

**SPARE PARTS ORDERING  
PROCEDURE**

This Service Manual is issued for the A.M.F.  
Reece Autojig Machine, AJ84-72M July 98  
SERIAL N° 0001 onwards

Customer should furnish the catalogue part  
number, the serial number of the machine, and  
information as requested in notes on pages  
illustrating the parts.

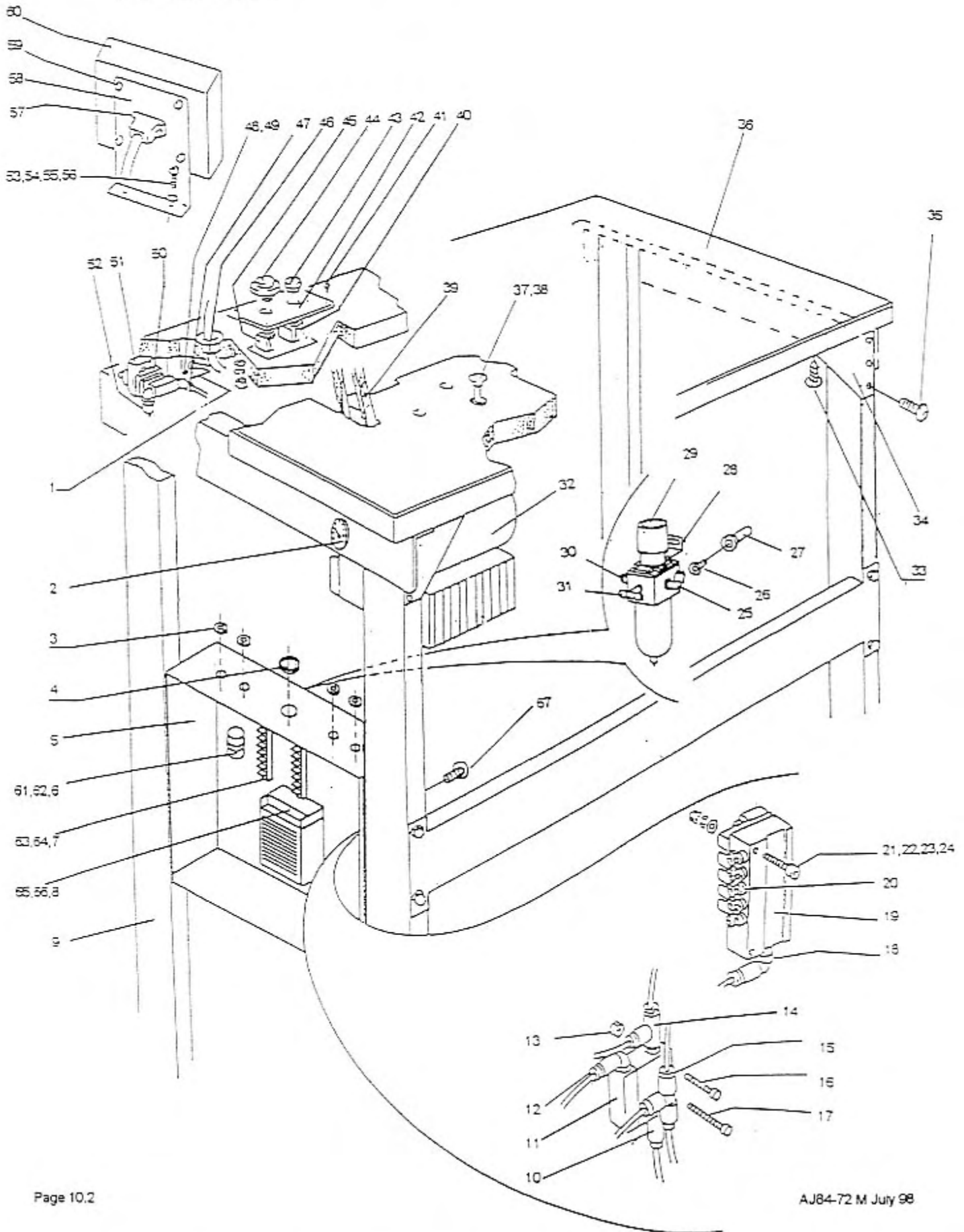
Individual parts are furnished without screws,  
nuts, taper pins, cotter pins, dowels, keys,  
spring posts, clamp studs, washers, etc., as  
these can be transferred in most cases from the  
part being replaced. Every part has its own  
number and can be ordered separately.

Parts should not be returned without our previ-  
ous approval. All return shipments should be  
sent carriage paid to:-



**A.M.F. Reece**  
DIVISION OF A.M.F. REECE, INC.  
CLAYTON WOOD CLOSE,  
WEST PARK RING ROAD,  
LEEDS, LS16 6QQ  
ENGLAND

10.1 ELECTRICAL & PNEUMATIC COMPONENTS/  
 TABLE AND FRAME



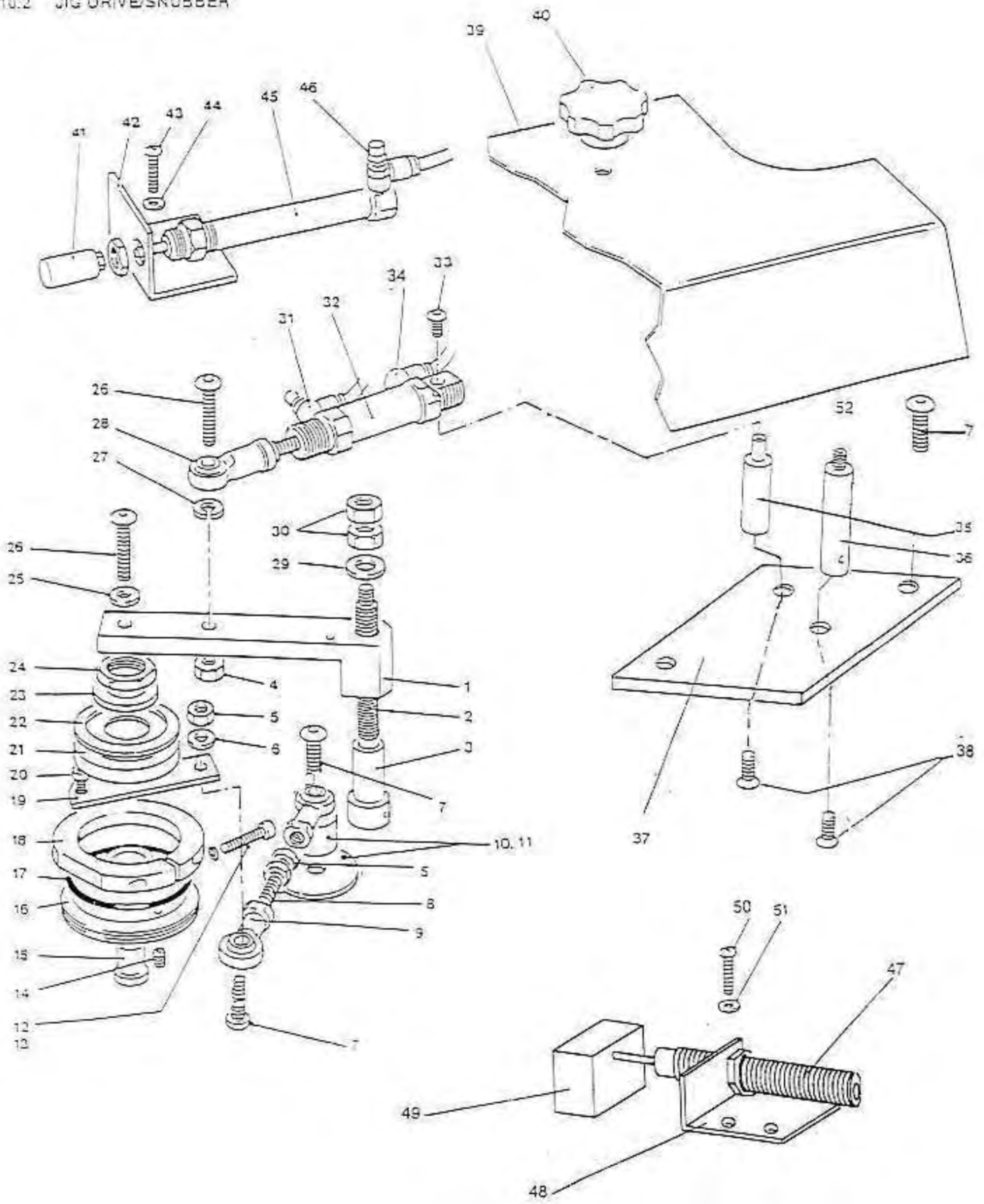
10.1 ELECTRICAL AND PNEUMATIC COMPONENTS

| ITEM | CODE No. | DESCRIPTION               | QTY |
|------|----------|---------------------------|-----|
| 1    | —        | Efka On/Off Box           | 1   |
| 2    | 046865   | Pressure Gauge            | 1   |
|      | 020727   | 1/8" Sleeve Coupler       | 1   |
|      | 032100   | 1/8"-4mm Adaptor          | 1   |
| 3    | 058625   | 4mm Rubber Grommet        | 5   |
| 4    | —        | Rubber Grommet            | 6   |
| 5    | 057110   | Electrical Cabinet        | 1   |
| 6    | 048948   | Capacitor                 | 1   |
| 7    | 046795   | 12 Way Terminal Strip     | 2   |
| 8    | 048993   | 50 W Weir Power Supply    | 1   |
|      | 048933   | 10 watt 5 Ohm Resistor    | 1   |
| 9    | 057095   | Frame                     | 1   |
| 10   | 032110   | Straight Fitting 4mm      | 1   |
| 11   | 046746   | Pilot Valve               | 1   |
| 12   | 032095   | Elbow 4mm                 | 1   |
| 13   | 021085   | M3 Nut                    | 2   |
| 14   | 060989   | 'T' Connector 4mm         | 1   |
| 15   | 032150   | 'T' Connector 4mm         | 1   |
| 16   | 020846   | M3x20 Cap Hd Screw        | 1   |
| 17   | —        | M3x30 Cap Hd Screw        | 1   |
| 18   | 032105   | 6mm Elbow                 | 1   |
| 19   | 057125   | 5 Station Manifold        | 1   |
| 20   | 046847   | Push In Fitting, 5mm      | 10  |
| 21   | 020852   | M4x25 Cap Hd Screw        | 2   |
| 22   | 021092   | M4 Plain Washer           | 2   |
| 23   | 021026   | M4 Spring Washer          | 2   |
| 24   | 021086   | M4 Nut                    | 2   |
| 25   | 032107   | 1/4"-M6 Elbow Adaptor     | 1   |
| 26   | —        | M5x12 Butt Hd Screw       | 2   |
| 27   | 046940   | M5 Aluminum Rivnut        | 2   |
| 28   | 032015   | Bracket                   | 1   |
| 29   | 048045   | Filter Regulator          | 1   |
| 30   | 032108   | 1/4"-6mm In line Adaptor  | 1   |
| 31   | 032155   | 1/8"-4mm Branch T Adaptor | 1   |
| 32   | 057085   | Efka Motor AB62           | 1   |
|      | 046880   | Speed Plug Harness        | 1   |
| 33   | —        | Wood Screw                | 6   |
| 34   | 057115   | Brace, L/H                | 1   |
|      | 057116   | Brace, R/H                | 1   |
| 35   | 020982   | M5x10 Butt. Hd. Screw     | 6   |
| 36   | 057100   | TableTop                  | 1   |
| 37   | 021068   | Motor Mounting Bolt       | 3   |
| 38   | 021058   | M8 Nut                    | 3   |
|      | 021093   | M8 Washer                 | 3   |
| 39   | 047150   | Drive Belt                | 1   |
| 40   | 030956   | Contact Block             | 1   |
| 41   | 020948   | No. 6x5/8" Pan Hd Screw   | 4   |
| 42   | 048455   | Stop Start Plate          | 1   |
| 43   | 048460   | Start Button              | 1   |
| 44   | 030922   | Stop Button               | 1   |
| 45   | 030956   | Contact Block             | 1   |
| 46   | 025490   | Nylon Grommet             | 3   |

10.1 ELECTRICAL AND PNEUMATIC COMPONENTS CONTINUED.

| ITEM                   | CODE No. | DESCRIPTION             | QTY |
|------------------------|----------|-------------------------|-----|
| 47                     | 032105   | Elbow 6mm               | 1   |
| 48                     | 046806   | Small Cable Gland       | 1   |
| 49                     | —        | Wood Screw              | 2   |
| 50                     | 032120   | Air Valve On/Off        | 1   |
| 51                     | 107350   | Bracket                 | 1   |
| 52                     | 020719   | Elbow 1/4"x8mm          | 1   |
| 53                     | 020871   | M6x50 Cap Hd Screw      | 2   |
| 54                     | 021099   | M6 Plain Washer         | 2   |
| 55                     | 021088   | M6 Nut                  | 2   |
| 56                     | 021028   | M6 Spring Washer        | 2   |
| 57                     | 057050   | Ext. Harness D Conn     | 1   |
| 58                     | 046565   | Control Box Mntg. Bkt   | 1   |
| 59                     | 020851   | M4x16 Cap Hd. Screw     | 4   |
| 60                     | 047072   | AMF Reece Control Box   | 1   |
|                        | 046575   | Controller End Plate    | 2   |
|                        | 046740   | Controller Facia        | 1   |
|                        | 048901   | EPROM                   | 1   |
| 61                     | 048947   | Capacitor Clip          | 1   |
| 62                     | 020878   | M4x10 Cap Hd Screw      | 1   |
|                        | 021086   | M4 Nut                  | 1   |
|                        | 021092   | M4 Plain Washer         | 1   |
|                        | 020843   | M3X12 Cap Hd Screw      | 1   |
|                        | 021085   | M3 Nut                  | 1   |
| 63                     | 020851   | M4x16 Cap Hd Screw      | 4   |
| 64                     | 021086   | M4 Nut                  | 4   |
| 65                     | 048994   | Panduit Connector       | 1   |
| 66                     | 048995   | Panduit Connector Cover | 1   |
|                        | 048996   | Polarizing Pin          | 3   |
| <i>Not Illustrated</i> |          |                         |     |
|                        | 058680   | 5/6mm Ferrite           | 3   |
|                        | 058682   | 6.5mm Ferrite           | 3   |
|                        | 058684   | 13mm Hinged Ferrite     | 1   |

10.2 JIG DRIVE/SNUBBER



10.1 JIG DRIVE/SNUBBER/JIG EJECT

| ITEM             | CODE No. | DESCRIPTION            | QTY |
|------------------|----------|------------------------|-----|
| <b>JIG DRIVE</b> |          |                        |     |
| 1                | 048085   | Drive Arm              | 1   |
| 2                | 046935   | Drive Cover Stud       | 1   |
| 3                | 030511   | Mounting Arm Eccentric | 1   |
| 4                | 021088   | M6 Nut                 | 1   |
| 5                | 021087   | M5 Nut                 | 1   |
| 6                | 021098   | M5 Plain Washer        | 1   |
| 7                | 020984   | M5x16 Butt Hd Screw    | 4   |
| 8                | 029060   | Stud                   | 1   |
| 9                | 028200   | Rod End                | 2   |
| 10               | 046535   | Oil Cover Tube         | 1   |
| 11               | 046530   | Oil Cover              | 1   |
| 12               | 020855   | M4x30 Cap Hd Screw     | 1   |
| 13               | 021026   | M4 Spring Washer       | 1   |
| 14               | 020922   | M5x5 Grub Screw        | 2   |
| 15               | 025280   | Pivot Spindle          | 1   |
| 16               | 029010   | Drive Wheel            | 1   |
| 17               | 029125   | 'O' Ring               | 1   |
| 18               | 025290   | Free Wheel Housing     | 1   |
| 19               | 046920   | Drive Plate            | 1   |
| 20               | 020842   | M3x10 Cap Hd Screw     | 2   |
| 21               | 029070   | Bearing                | 1   |
| 22               | 029126   | Nilos Ring             | 1   |
| 23               | 029020   | Washer                 | 1   |
| 24               | 029030   | Locknut                | 1   |
| 25               | 021099   | M6 Washer              | 1   |
| 26               | 020992   | M6x25 Butt Hd Screw    | 1   |
| 27               | 021028   | M6 Spring Washer       | 1   |
| 28               | 028210   | Rod End                | 1   |
| 29               | 021093   | M8 Plain Washer        | 1   |
| 30               | 021058   | M8 Nut                 | 2   |
| 31               | 032040   | Flow Control           | 2   |
| 32               | 028192   | Cylinder               | 1   |
| 33               | —        | M4x6 Butt Hd Screw     | 1   |
| 34               | 032095   | M5-4mm Elbow Adaptor   | 1   |
| 35               | 030620   | Drive Cylinder Stud    | 1   |
| 36               | 059110   | Cover Stud             | 1   |
| 37               | 059023   | Jig Drive Base Plate   | 1   |
| 38               | 020807   | M5x10 Csk Screw        | 1   |
| 39               | 057055   | Drive Cover Guard      | 1   |
| 40               | 046525   | Thumb Nut, 8mm         | 2   |

**JIG EJECT**

|    |        |                     |   |
|----|--------|---------------------|---|
| 41 | 046540 | Nylon Nose          | 1 |
| 42 | 059010 | Jig Eject Brkt      | 1 |
| 43 | 020984 | M5x16 Butt Hd Screw | 2 |
| 44 | 021098 | M5 Plain Washer     | 2 |
| 45 | 046950 | Jig Eject Cylinder  | 1 |
| 46 | 032045 | Flow Control        | 1 |

| ITEM                   | CODE No. | DESCRIPTION            | QTY |
|------------------------|----------|------------------------|-----|
| <b>SNUBBER</b>         |          |                        |     |
| 47                     | 046765   | Shock Absorber         | 1   |
| 48                     | 057025   | Snubber Bkt            | 1   |
| 49                     | 057030   | Nylon Damper Block     | 1   |
| 50                     | 020984   | M5x16 Butt Hd Screw    | 2   |
| 51                     | 021098   | M5 Plain Washer        | 2   |
| <i>Not Illustrated</i> |          |                        |     |
| 53                     | 059140   | Jigh Drive Regulator   | 1   |
| 54                     | 060325   | 4mm In Line Restrictor | 1   |



10.3 PRESSER FOOT/JIG FLAP/AMPLIFIER

| ITEM                | CODE No. | DESCRIPTION        | QTY |
|---------------------|----------|--------------------|-----|
| <b>PRESSER FOOT</b> |          |                    |     |
| 1                   | 020840   | M3x5 Cap Hd Screw  | 1   |
| 2                   | 057060   | Photocell Mtg Bkt  | 1   |
| 3                   | 030715   | Fibre Optic Head   | 1   |
| 4                   | 025550   | Presser Foot 3/16" | 1   |
| 5                   | 025540   | Presser Foot 1/8"  | 1   |
| 6                   | 025560   | Presser Foot 1/4"  | 1   |
| 5                   | 057120   | Foot Blower        | 1   |
| 8                   | 021025   | Finger Guard       | 1   |
| 7                   | —        | Plain Washer       | 1   |
| 8                   | —        | Slot Hd Screw      | 1   |

S = Special

**JIG FLAP**

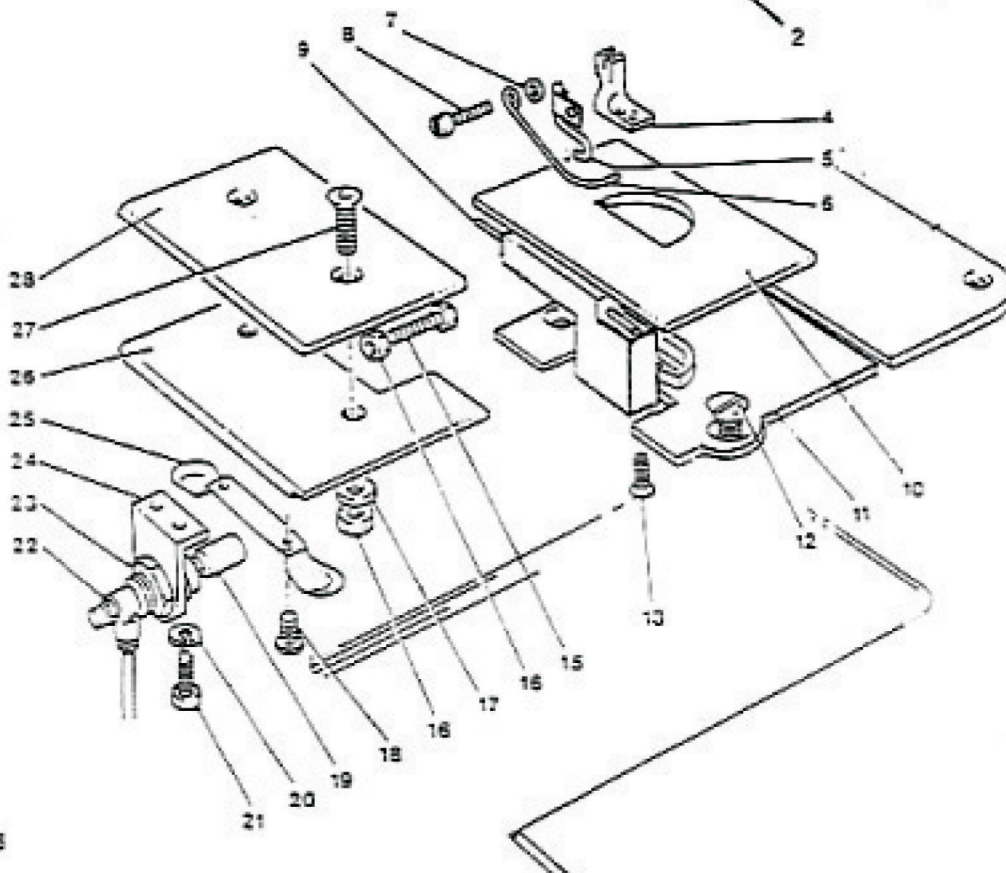
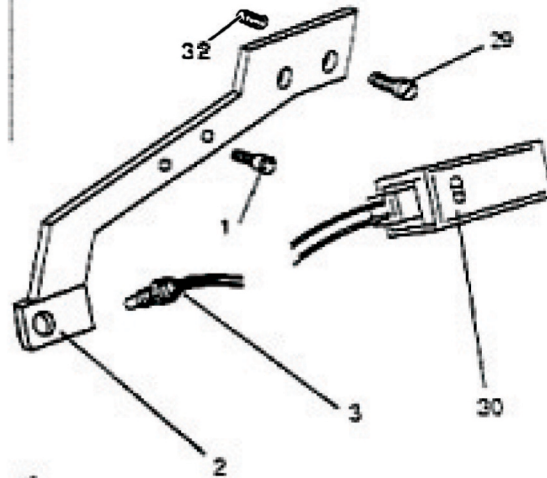
|    |               |                           |   |
|----|---------------|---------------------------|---|
| 9  | 040183        | Throat Plate Locating Pin | 1 |
| 10 | 059040        | Jig Flap Bracket          | 1 |
| 11 | 84.0005.7.002 | Throat Plate, 3/16"       | 1 |
| 5  | 84.0005.7.001 | Throat Plate, 1/8"        | 1 |
| 5  | 057003        | Throat Plate, 1/4"        | 1 |
| 12 | 057130        | Throat Plate Screw        | 4 |
| 13 | 020798        | M3x6 Csk Screw            | 1 |
| 14 |               |                           |   |
| 15 | M3x16         | Hex Hd Screw              | 1 |
| 16 | 021085        | M3 Nut                    | 3 |
| 17 | 021091        | M3 Plain Washer           | 2 |
| 18 | 046840        | M2.5x5 Pan Hd Screw       | 2 |
| 19 | 048540        | Nylon Nose                | 1 |
| 20 | 021025        | M3 Spring Washer          | 2 |

| ITEM | CODE No. | DESCRIPTION               | QTY |
|------|----------|---------------------------|-----|
| 21   | 020841   | M3x8 Cap Hd Screw         | 2   |
| 22   | 032045   | Flow Control              | 1   |
| 23   | 046745   | Jig Flap Cylinder         | 1   |
| 24   | 046755   | Jig Flap Cylinder Bracket | 1   |
| 25   | 046750   | Jig Flap Spring           | 1   |
| 26   | 057010   | Jig Eject Slide Plate     | 1   |
| 27   | 020799   | M3x10 Csk Screw           | 2   |
| 28   | 059050   | Jig Flap Cover Plate      | 1   |

S = Special

**AMPLIFIER**

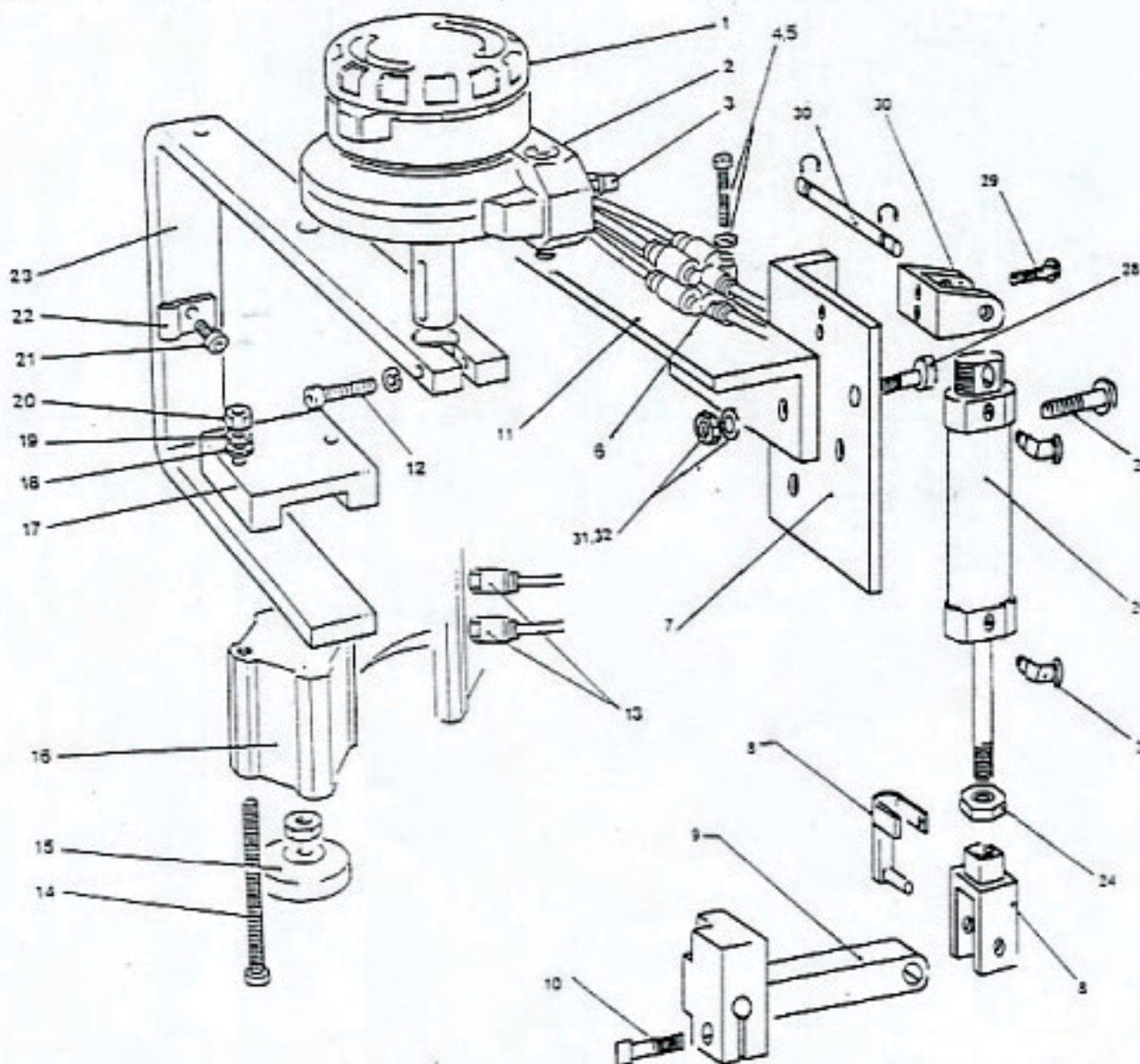
|                        |               |                        |   |
|------------------------|---------------|------------------------|---|
| 29                     | —             | Screw                  | 2 |
| 30                     | 057062        | Amplifier Unit         | 1 |
| <i>Not illustrated</i> |               |                        |   |
| 31                     | 060325        | 4mm In Line Restrictor | 2 |
| 32                     | 84.0005.7.059 | Spacer                 | 1 |





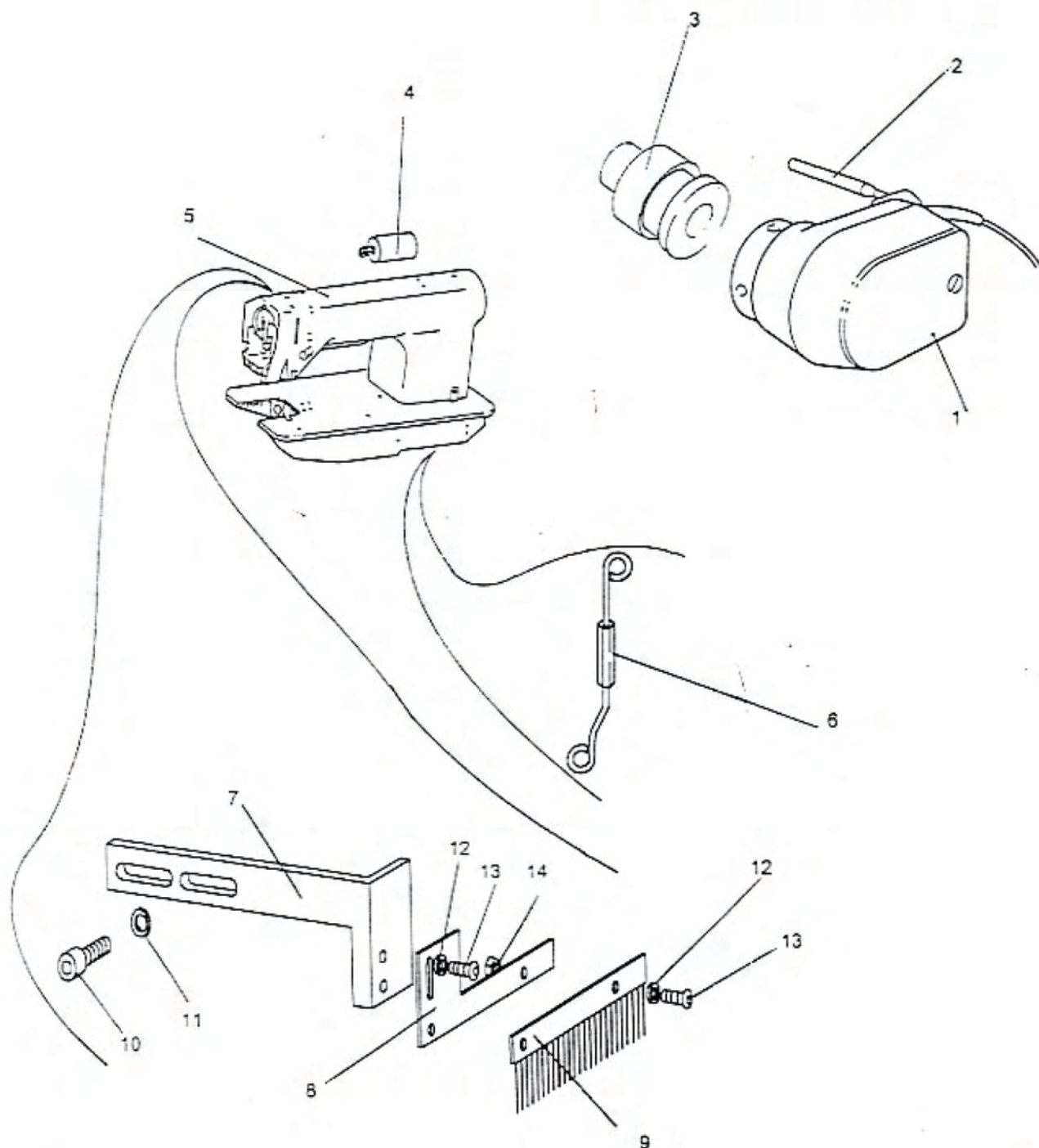
**10.4 TURN ARM**

| ITEM | CODE No.      | DESCRIPTION             | QTY | ITEM | CODE No. | DESCRIPTION        | QTY |
|------|---------------|-------------------------|-----|------|----------|--------------------|-----|
| 1    | 031000        | Turn Unit               | 1   | 20   | 021087   | M5 Nut             | 2   |
| 2    | 020868        | M6x30 Cap Hd Screw      | 2   | 21   | 020878   | M4x10 Cap Hd Screw | 2   |
| 3    | 032040        | Flow Control            | 2   | 22   | —        | Pipe Clamp         | 2   |
| 4    | 020853        | M4x35 Cap Hd Screw      | 1   | 23   | 046695   | Turn Arm           | 1   |
| 5    | 021092        | M4 Plain Washer         | 2   | 24   | 021087   | M5 Nut             | 1   |
| 6    | 060326        | Y Connector, 4mm        | 2   | 25   | 032100   | 90° Elbow Adaptor  | 2   |
| 7    | 84.0005.9.011 | Turn Support Bkt        | 1   | 26   | 059018   | Knife Cylinder     | 1   |
| 8    | 059019        | Piston Rod End Clevis   | 1   | 27   | —        | 15/64"x28x12 Screw | 2   |
| 9    | 059013        | Knife Lever             | 1   | 28   | —        | M6x20 cap Hd Screw | 2   |
| 10   | 020857        | M5x18 Cap Hd Screw      | 1   | 29   | —        | M6x12 Btt Hd Screw | 2   |
| 11   | 059012        | Outrigger Turner        | 1   | 30   | 059017   | Clevis & Pin Kit   | 1   |
| 12   | 020855        | M4x30 Cap Hd Screw      | 1   | 31   | 021088   | M6 Full Nut        | 2   |
| 13   | 032110        | Straight Connector, 4mm | 2   | 32   | 021099   | M6 Plain Washer    | 2   |
| 14   | —             | M5x55 Cap Hd Screw      | 2   |      |          |                    |     |
| 15   | 046840        | Turn Arm Cylinder Nose  | 1   |      |          |                    |     |
| 16   | 046825        | Turn Arm Cylinder       | 1   |      |          |                    |     |
| 17   | 046835        | Turn Arm Cylinder Clamp | 1   |      |          |                    |     |
| 18   | 021098        | M5 Plain Washer         | 1   |      |          |                    |     |
| 19   | 020878        | M5 Spring Nut           | 2   |      |          |                    |     |



10.5 HEAD AND SYNCHRONIZER

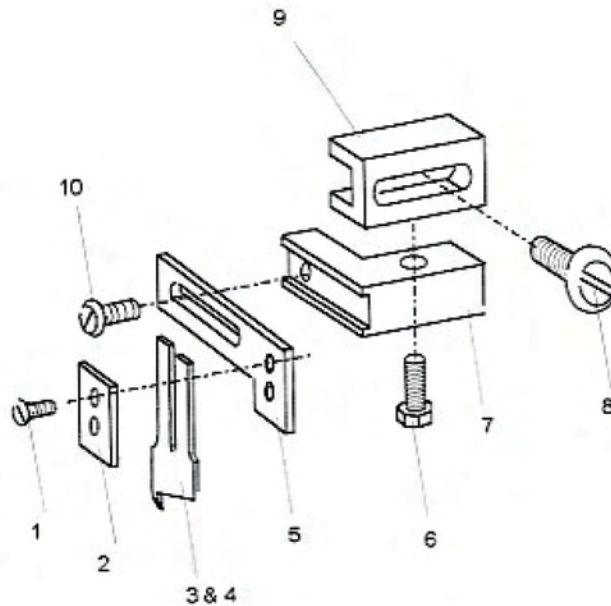
| ITEM | CODE No. | DESCRIPTION           | QTY | ITEM | CODE No.             | DESCRIPTION        | QTY |
|------|----------|-----------------------|-----|------|----------------------|--------------------|-----|
| 1    | —        | EFKA Synchroniser     | 1   | 7    | 059170               | Brush Mtg Brkt     | 1   |
| 2    | 057035   | Synch. Stabiliser Arm | 1   | 8    | 059175               | Extension Bkt      | 1   |
| 3    | 057020   | Synch. Spigot         | 1   | 9    | <b>84.0005.9.502</b> | Anti-static Brush  | 1   |
| 4    | 057091   | Foot Lift Solenoid    | 1   | 10   | 020856               | M5x12 Cap Hd Screw | 1   |
| 5    | 057090   | Sunstar Head          | 1   | 11   | 021098               | M5 Plain Washer    | 1   |
| 6    | 057075   | Dense Adjusting Rod   | 1   | 12   | 021091               | M3 Plain Washer    | 4   |
|      |          |                       |     | 13   | 020975               | M3x8 Butt Hd Screw | 4   |
|      |          |                       |     | 14   | 021092               | M3 Nut             | 4   |





10.6 KNIFE MECHANISM

| Item No. | Code No. | Description              | Qty |
|----------|----------|--------------------------|-----|
| 1        | 059174   | M2.5x6 Countersunk Screw | 2   |
| 2        | 059172   | Clamp Plate              | 1   |
| 3        | 059173   | 16mm Knife               | 1   |
| 4        | 059161   | 9mm Knife                | 1   |
| 5        | 059171   | Adapter                  | 1   |
| 6        | —        | M6 Hexagon Head Screw    | 1   |
| 7        | 059166   | Slide Block              | 1   |
| 8        | —        | Clamp Screw              | 1   |
| 9        | 059164   | Adjustable Holder Bkt.   | 1   |
| 10       | —        | Slide Clamp Screw        | 1   |

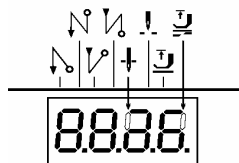


**Parameter list  
for Sunstar Machines AJ 84-72**

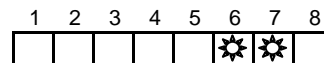


| NEW EFKA DRIVER MOTOR:<br>AB211A |                     | OLD EFKA DRIVER MOTOR:<br>AB62CV1466<br>( Original: AB62CV1463 DATE: 26-11-98 ) |                                      |
|----------------------------------|---------------------|---|--------------------------------------|
| Parameter                        | Setting             | Setting   | Designation                          |
| 110                              | 180                 | 18  | Positioning Speed                    |
| 111                              | 2600                | 260   | Maximum Speed                        |
| 153                              | 03                  | 003   | Braking Power at standstill          |
| 161                              | 1                   | 1   | Counterclockwise rotation            |
| 171                              | 56   281   98   323 | -   | Setting Needle Positions             |
| 180                              | 005                 | 005   | Number of reversion increments       |
| 181                              | 010                 | 010   | Activation delay of reversion        |
| 182                              | 1                   | ON  | Reversion On                         |
| 202                              | 200                 | 200   | Foot down delay at the start         |
| 204                              | 020                 | 2   | Holding power for presser foot lift. |
| 213                              | 20                  | 3   | Holding power fot Thread Trimm.      |
| 240                              | 16                  | 016   | Activate Dense Control               |
| 270                              | 6                   | -   | Pos.senzor                           |
| 290                              | 00                  | 0   | Lock stitch Sunstar                  |

Setting Display:



Setting LEDs light:



Programming the Code Number:  
Press the **P** key and turn power on.

Supplier CODE: **3112**  
Technical level: 1907

Press the **P** key  
for Exit programming

Supplier CODE: **311**  
Technical level: 190

Press the **P** key  
for Exit programming

Note:  
Backtaking switches: S1 and S2 = OFF  
Needle down switch: S4 = ON

**Important !**

The changed parameter values will be saved when you start sewing again !  
Speed parameter is changed only after trimming and when you start sewing again !  
Use manual EFKA for more informations.