CLINTON SERVICE GUIDE
MODEL 117VS-FOTA-KS
BROTHER B925

SHEAR CUTTER FOR
SHOULDER TAPING OPERATION

FOOT
LIFTING
LEVER

AIR
CYLINDER

GUARD

MOVABLE
BLADE

FIXED
BLADE
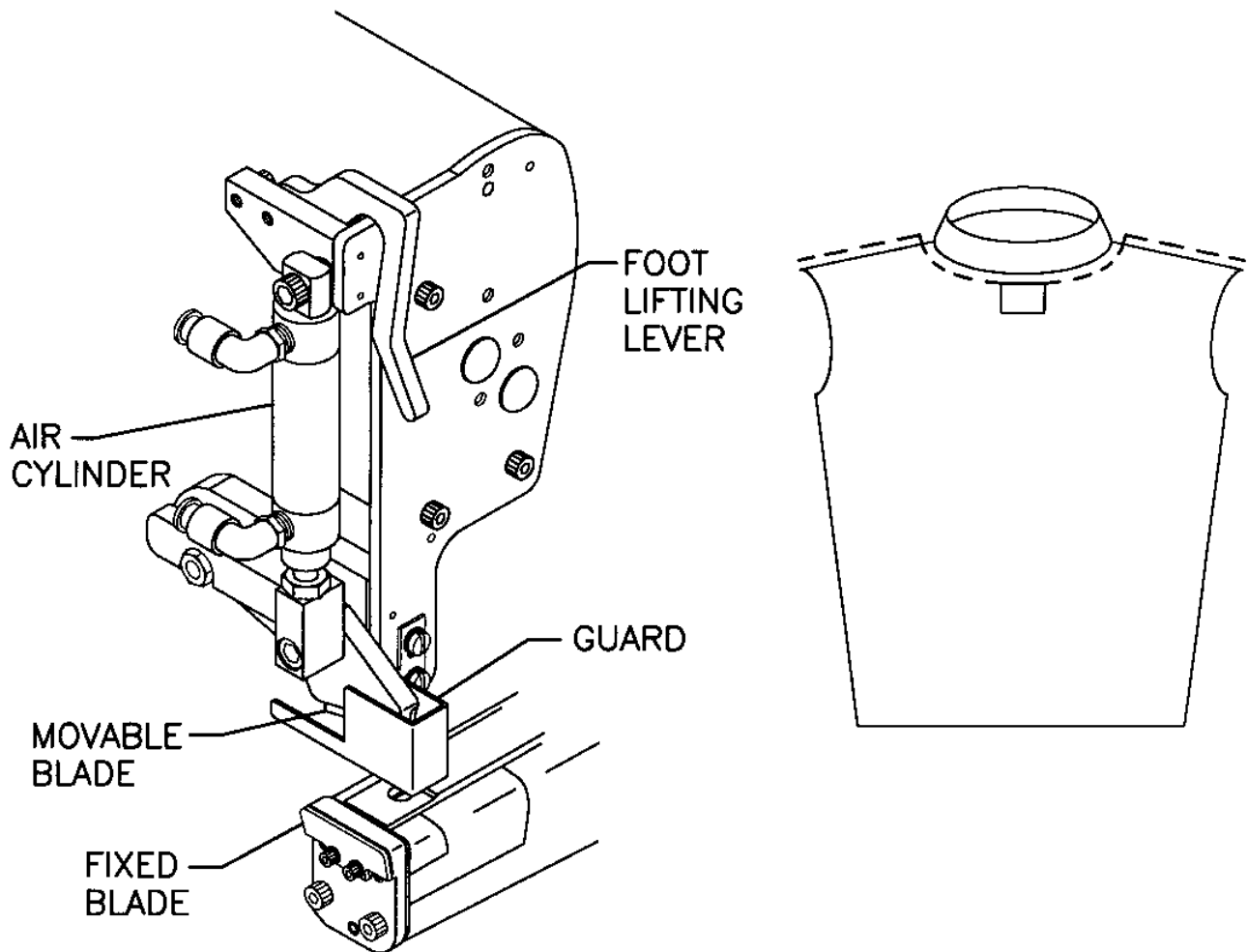
STEP 1   DRILLING INSTRUCTIONS FOR THE FACE PLATE END

REMOVE THE EXISTING HINGED FACE PLATE INCLUDING THE HINGE, ALONG WITH THE THREE SCREWS HOLDING THE OIL DAM PLATE. DRILL AND TAP THE (3) THREE EXISTING SCREW HOLES SHOWN, WITH DRILL NO.29 (30-2130-29) AND TAP 8-32 (30-1266-01) SUPPLIED.
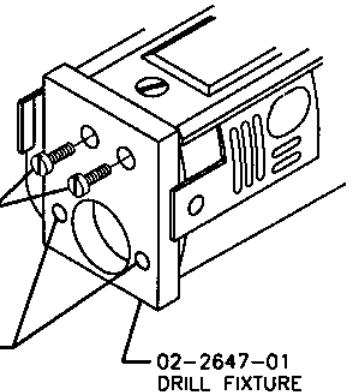
DRILL & TAP 1/2" DEEP THESE (3) THREE HOLES.
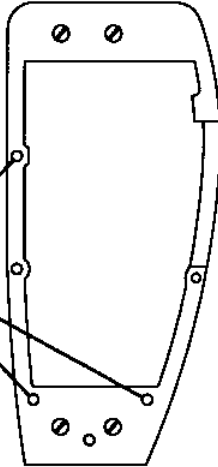
STEP 2   DRILLING INSTRUCTIONS FOR THE STATIONARY BLADE SUPPORT

1. PLACE DRILL FIXTURE ON THE MACHINE AS SHOWN.

2. DRILL (2) TWO HOLES 1/2" DEEP WITH NO.21 DRILL SUPPLIED. (30-2130-21)

3. REMOVE DRILL FIXTURE.

4. TAP THE (2) TWO HOLES WITH 10-32 TAP SUPPLIED. (30-1875-01)

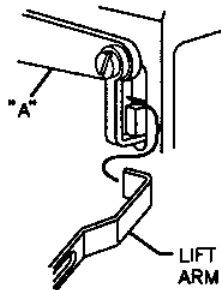EXISTING SCREWS FOR HOLDING THE DRILL FIXTURE
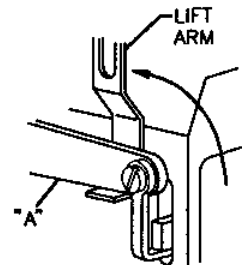
DRILL GUIDE HOLES FOR DRILL NO.21.

02-2647-01 DRILL FIXTURE

STEP 3   INSTALL THE CUTTER AS A COMPLETE ASSEMBLY. START BY PLACING THE LIFT ARM IN AND WORKING THE LIFT ARM UP AND AROUND BETWEEN THE MACHINE WALL AND BAR "A" AS SHOWN
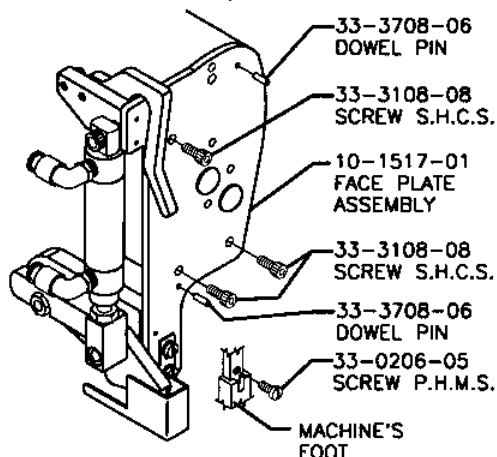
"A"

LIFT ARM

LIFT ARM

"A"

ADJUSTMENTS

WARNING!!   TO PREVENT SERIOUS INJURY, DISCONNECT AIR SUPPLY BEFORE MAKING ANY ADJUSTMENTS.

STEP 4   MOUNT VERTICAL SHEAR CUTTER WITH (3) SCREWS 33-3210-10.

33-3708-06 DOWEL PIN

33-3108-08 SCREW S.H.C.S.

10-1517-01 FACE PLATE ASSEMBLY

33-3108-08 SCREW S.H.C.S.

33-3708-06 DOWEL PIN

33-0206-05 SCREW P.H.M.S.

MACHINE'S FOOT

NOTE: LATER WHEN THE CUTTER IS INSTALLED COMPLETELY ALONG WITH THE STATIONARY BLADE AND ALL THE ADJUSTMENTS HAVE BEEN MADE AND THE CUTTER IS WORKING PERFECTLY, USE THE DRILLS PROVIDED TO DRILL HOLES FOR THE DOWEL PINS USING THE FACE PLATE HOLES AS THE TEMPLATE. USE DRILL #33 (30-1070-01) FOR THE PILOT HOLES FIRST, 3/16" DEEP. THEN USE 1\8" DIA. (30-2376-08), SAME DEPTH 3/16".

STEP 5   ADJUSTING THE MOVABLE BLADE
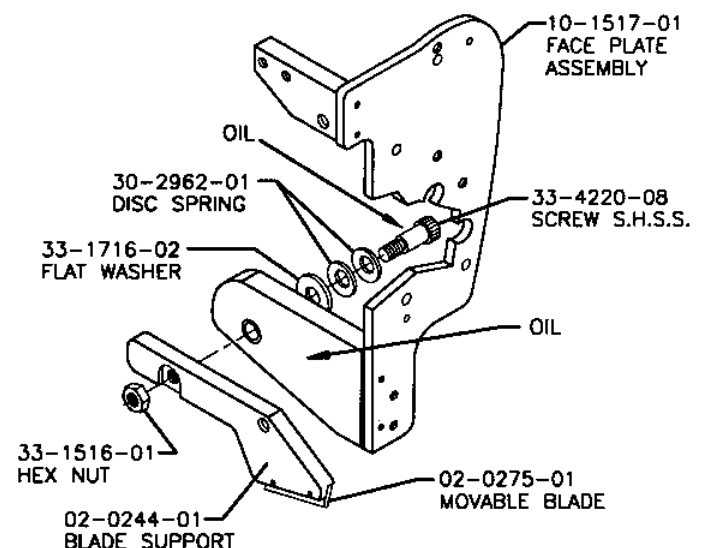
10-1517-01 FACE PLATE ASSEMBLY

OIL

30-2962-01 DISC SPRING

33-4220-08 SCREW S.H.S.S.

33-1716-02 FLAT WASHER

OIL

33-1516-01 HEX NUT

02-0275-01 MOVABLE BLADE

02-0244-01 BLADE SUPPORT

SHOULDER SCREW 33-4220-08 SHOULD BE SCREWED INTO THE BLADE SUPPORT, FINGER TIGHT. THE HEX NUT 33-1516-01 IS USED TO LOCK IN THE ADJUSTED CONDITION.

STEP 6 — ADJUSTING THE STATIONARY BLADE

IF THE BLADES ARE NOT TOUCHING EACH OTHER, LOOSEN THE THE (2) SCREWS 33-3210-08. THIS WILL ALLOW THE (2) TOP JACK SCREWS 33-2210-03 TO BE TURNED TO MAKE UP ANY ADJUSTMENT.
ADJUST THE (2) SCREWS 33-2210-03 ON THE RIGHT FOR THE RADIAL ADJUSTMENT OF THE FIXED BLADE AS SHOWN. RETIGHTEN THE (2) SCREWS 33-3210-08. TRY LOWERING THE MOVABLE BLADE SLOW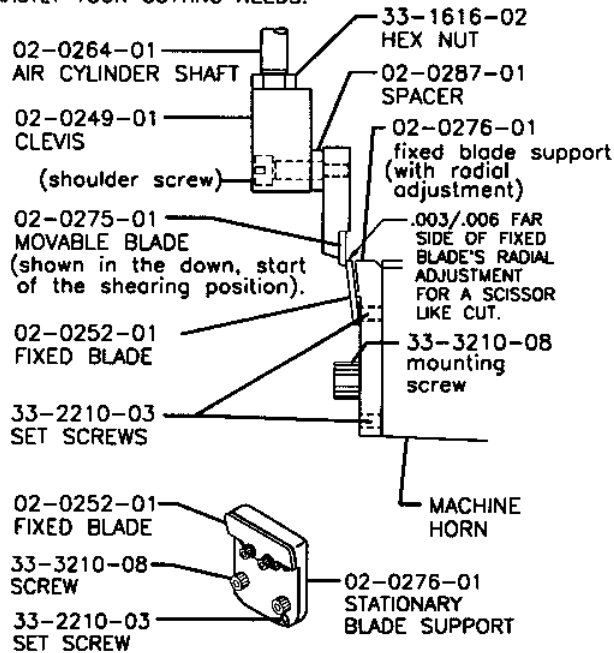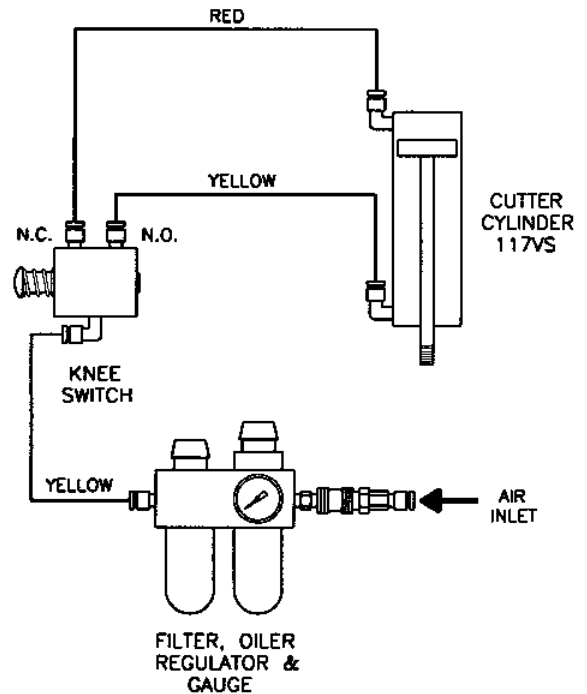LY (WITHOUT THE AIR BEING ON) FOR TESTING THE SHEARING ACTION. IT MAY REQUIRE SEVERAL ADJUSTMENTS TO GET EXACTLY YOUR CUTTING NEEDS.

02-0264-01 AIR CYLINDER SHAFT
33-1616-02 HEX NUT
02-0287-01 SPACER
02-0249-01 CLEVIS (shoulder screw)
02-0276-01 fixed blade support (with radial adjustment)
02-0275-01 MOVABLE BLADE (shown in the down, start of the shearing position).
.003/.006 FAR SIDE OF FIXED BLADE'S RADIAL ADJUSTMENT FOR A SCISSOR LIKE CUT.
02-0252-01 FIXED BLADE
33-3210-08 mounting screw
33-2210-03 SET SCREWS
MACHINE HORN

02-0252-01 FIXED BLADE
33-3210-08 SCREW
33-2210-03 SET SCREW
02-0276-01 STATIONARY BLADE SUPPORT

AIR CIRCUIT DIAGRAM
MODEL 117VS KS
MODEL 117VS F.O.R.G.-KS

RED
YELLOW
N.C.   N.O.
CUTTER CYLINDER 117VS
KNEE SWITCH
YELLOW
AIR INLET
FILTER, OILER REGULATOR & GAUGE

INS-570-3D

FILTER, OILER, REGULATOR, GAUGE ASSEMBLY
80-0181-01
80-0181-10

30-2737-250 FITTING (80-0181-01)
30-2741-250 TEE (80-0181-10)
01-4528-01 BRACKET
33-2010-12 SCREW P.H.S.M.S.
30-0899-01 NUT
30-0277-01 QUICK DISCONNECT MALE
30-2737-250 FITTING
30-0282-01 GAUGE
* 30-2347-01 FILTER REGULATOR LUBRICATOR
30-1048-01 QUICK DISCONNECT FEMALE
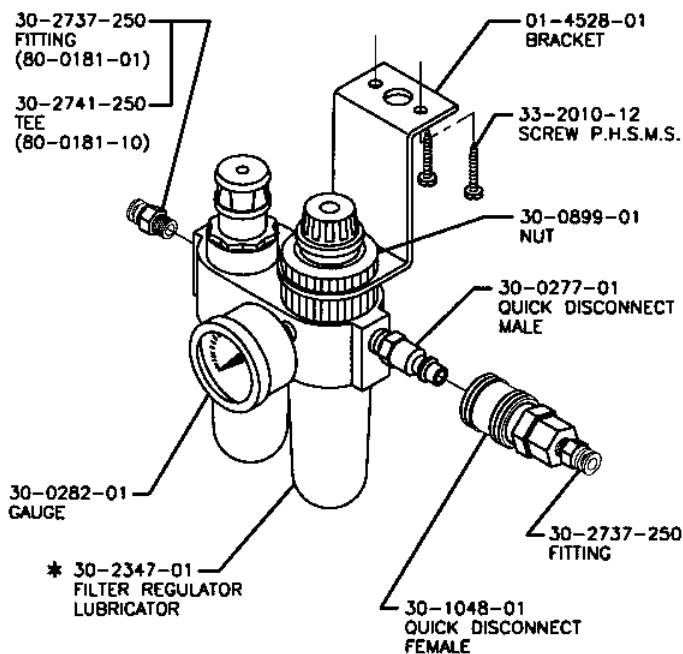
* NOTE: SEE INS-DRAWINGS 2100-1 AND 2100-2 FOR SPARE PARTS

INS-619-1A

4 WAY AIR VALVE, KNEE OPERATED
80-0185-01

33-3712-16 DOWEL PIN
01-1539-01 SUPPORT
30-2737-250 FITTING
30-0287-01 TUBING - RED
01-4410-01 BUTTON
30-0802-01 SPRING
33-2010-16 (3) SCREW-P.H.S.M.S.
30-0886-01 AIR VALVE
30-2738-250 ELBOW
33-0106-20 SCREW-P.H.M.S.
01-4412-01 ROD
30-0228-01 KNEE PLATE
30-0902-01 KNEE PAD
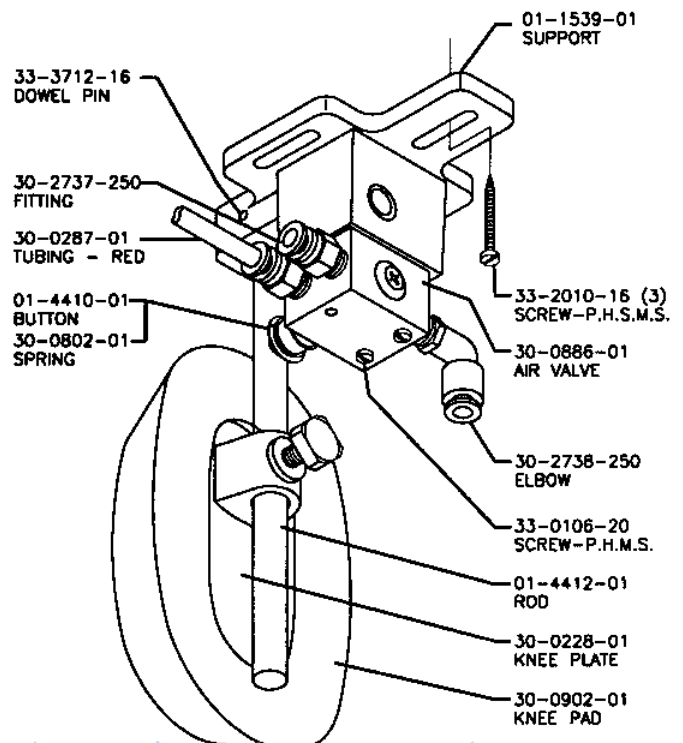
CUTTER ASSEMBLY
MODEL 117VS
BROTHER B925
80-0539-05

01-3061-11
SCREW (LONG)

01-1509-61
BUSHING (LONG)

02-0254-01
LEVER

33-3210-04
SCREW S.H.C.S.

02-0287-01
SPACER

33-4220-08
SCREW S.H.S.S.

30-2738-250
ELBOW

02-0264-01
AIR CYLINDER

30-2962-01
DISC SPRING

33-1716-02
FLAT WASHER

02-0262-01
BEARING

33-1516-01
HEX NUT

02-0244-01
BLADE SUPPORT

02-0275-01
MOVABLE BLADE

33-1616-02
HEX NUT

02-0249-01
CLEVIS

02-0286-01
SCREW S.H.S.S.

02-0287-01
SPACER

33-1805-01
LOCK WASHER

33-3105-04
SCREW S.H.C.S.

02-0252-01
STATIONARY BLADE

33-3210-08
SCREW S.H.C.S.

02-0659-01 ✱
ROD

33-1516-01 ✱
HEX NUT

02-0256-01 ✱
ARM-RIBBON RACK

01-3061-51
SCREW (SHORT)

01-1509-31
BUSHING (SHORT)

02-0247-01
LIFT ARM

10-1517-01
FACE PLATE ASSEMBLY

33-3708-06
DOWEL PIN

33-3210-04 ✱
SCREW S.H.C.S.

33-4220-08
SCREW S.H.S.S.

33-3210-04 ✱
SCREW S.H.C.S.

30-1509-01
RUBBER PLUG

33-0308-06 ✱
SCREW F.H.M.S.

02-0657-01 ✱
NUT PLATE

33-3210-09 ✱
SCREW S.H.C.S.

02-0255-01 ✱
FOLDER BRACKET

01-3849-10 ✱
SPACER

33-3108-08
SCREW S.H.C.S.

33-3708-06
DOWEL PIN

33-0108-04
SCREW P.H.M.S.

33-1708-01
FLAT WASHER

02-0253-01
GUARD

33-0305-04
SCREW F.H.M.S.

02-0245-01
PRESSER FOOT EXTENSION

33-2210-03
SCREW S.S.S.

02-0276-01
STATIONARY BLADE SUPPORT

✱ NOT PART OF 80-0539-05

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