

**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.

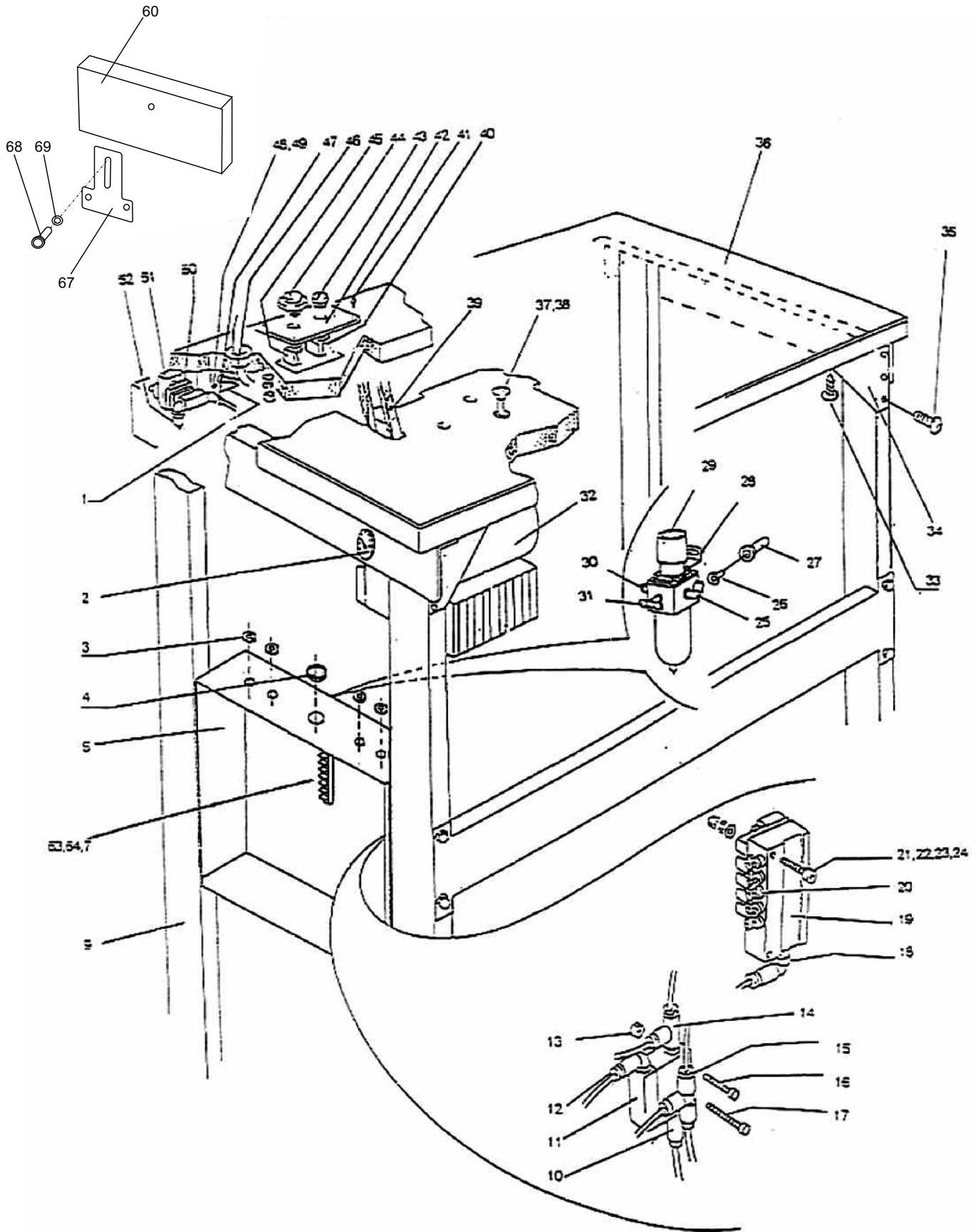
Individual parts are furnished without screws, nuts, taper pins, cotter pins, dowels, keys, spring posts, clamp studs, washers, etc., as these can be transferred in most cases from the part being replaced. Every part has its own number and can be ordered separately.

Parts should not be returned without our previous 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

ELECTRICAL AND PNEUMATIC COMPONENTS



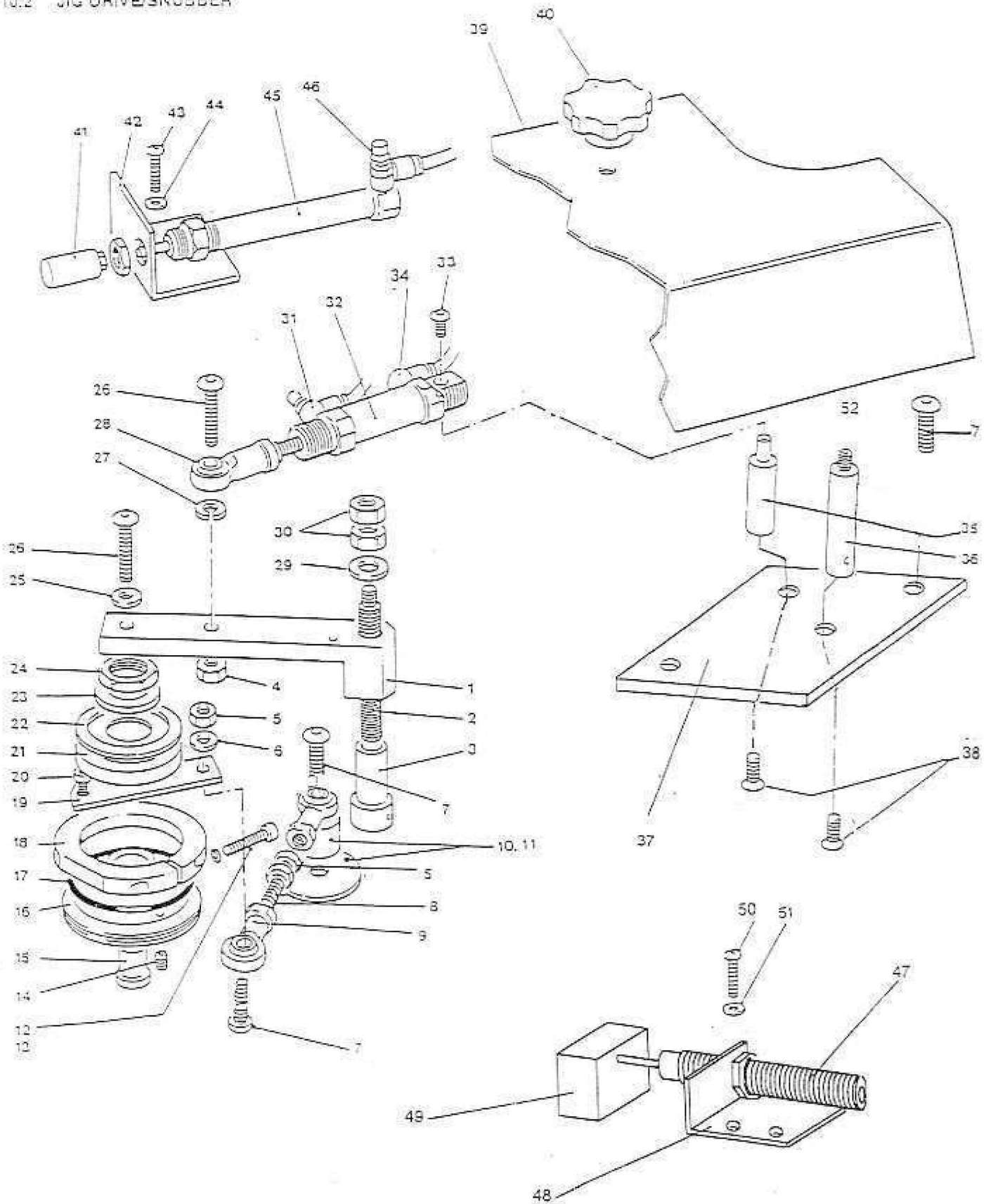
ELECTRICAL AND PNEUMATIC COMPONENTS

ITEM	CODE No.	DESCRIPTION	QTY	ITEM	CODE No.	DESCRIPTION	QTY
1	—	Efka On/Off Box	1	47	032105	Elbow 6mm	1
2	046865	Pressure Gauge	1	48	046806	Small Cable Gland	1
	020727	1/8" Sleeve Coupler	1	49	—	Wood Screw	2
	032100	1/8"-4mm Adaptor	1	50	032120	Air Valve On/Off	1
3	058625	4mm Rubber Grommet	5	51	107350	Bracket	1
4	—	Rubber Grommet	6	52	020719	Elbow 1/4"x8mm	1
5	057110	Electrical Cabinet	1	53	020871	M6x50 Cap Hd Screw	2
6	048948	Capacitor	1	54	021099	M6 Plain Washer	2
7	046795	12 Way Terminal Strip	1	55	021088	M6 Nut	2
8				56	021028	M6 Spring Washer	2
				57			
9	057095	Frame	1	58	046565	Control Box Mntg. Bkt	1
10	032110	Straight Fitting 4mm	1	59	020851	M4x16 Cap Hd. Screw	4
11	046746	Pilot Valve	1	60	06.8400.1.007	Display	1
12	032095	Elbow 4mm	1				
13	021085	M3 Nut	2				
14	060989	T Connector 4mm	1	61			
15	032150	T Connector 4mm	1	62	020878		
16	020846	M3x20 Cap Hd Screw	1		021086	M4 Nut	1
17	—	M3x30 Cap Hd Screw	1		021092	M4 Plain Washer	1
18	032105	6mm Elbow	1		020843	M3X12 Cap Hd Screw	1
19	057125	5 Station Manifold	1		021085	M3 Nut	1
20	046847	Push In Fitting, 5mm	10	63	020851	M4x16 Cap Hd Screw	4
21	020852	M4x25 Cap Hd Screw	2	64	021086	M4 Nut	4
22	021092	M4 Plain Washer	2	65	048994	Panduit Connector	1
23	021026	M4 Spring Washer	2	66	048995	Panduit Connector Cover	1
24	021066	M4 Nut	2		048996	Polarizing Pin	3
25	032107	1/4"-M6 Elbow Adaptor	1	67	84.0005.9.682	Display Holder	1
26	—	M5x12 Butt Hd Screw	2	68	08.6000.5.012	Screw M5x12	1
27	046940	M5 Aluminum Rivnut	2	69	08.685.5.000	Washer 5,3	1
28	032015	Bracket	1				
29	048045	Filter Regulator	1				
30	032108	1/4"-6mm In line Adaptor	1				3
31	032155	1/8"-4mm Branch T Adaptor	1				3
32	057085	Efka Motor AB62	1				1
	046880	Speed Plug Harness	1		058680	5/6mm Ferrite	
33	—	Wood Screw	6		058682	6,5mm Ferrite	
34	057115	Brace, L/H	1		058684	13mm Hinged Ferrite	
	057116	Brace, R/H	1				
35	020962	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	12.0008.4.583	Start Button	1				
44	12.0008.4.584	Stop Button	1				
45							
46	025490	Nylon Grommet	3				

Not illustrated

JIG DRIVE/JIG EJECT/SNUBBER

10.2 JIG DRIVE/SNUBBER



JIG DRIVE/JIG EJECT/SNUBBER

ITEM	CODE No.	DESCRIPTION	QTY
JIG DRIVE			
1	046085	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
SNUBBER			
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	050325	4mm In Line Restrictor	1

PRESSER FOOT/JIG FLAP/AMPLIFIER

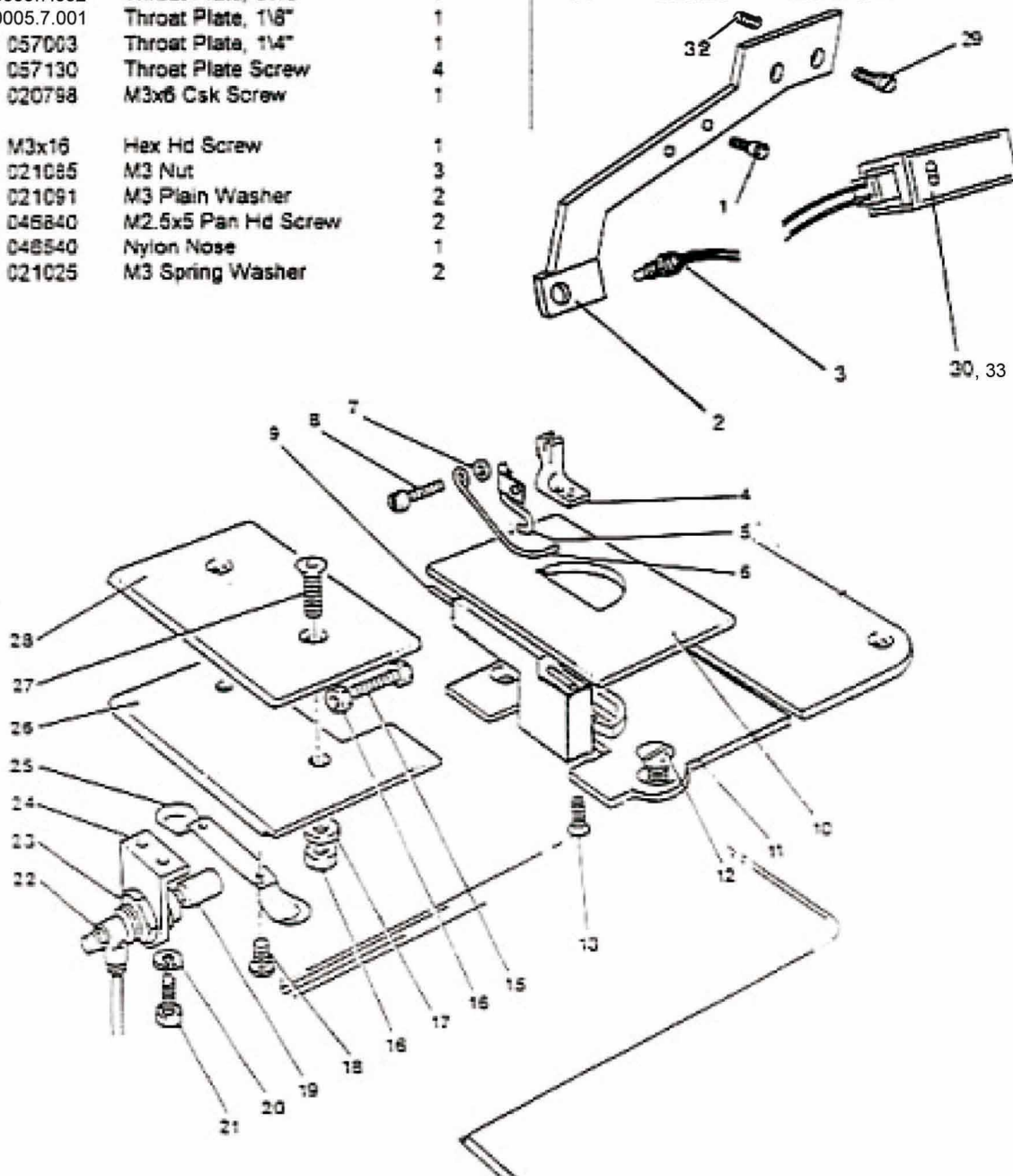
ITEM	CODE No.	DESCRIPTION	QTY
PRESSER FOOT			
1	020840	M3x5 Cap Hd Screw	1
2	84.0005.9.088	Photocell Mtg Skt	1
3	030715	Fibre Optic Head	1
4	025550	Presser Foot 3/16"	1
5	025540	Presser Foot 1/8"	1
6	025560	Presser Foot 1/4"	1
5	057120	Foot Blower	1
6	021025	Finger Guard	1
7	07016002	Plain Washer	1
8	08.7000.6.012	Slot Hd Screw	1
S = Special			

ITEM	CODE No.	DESCRIPTION	QTY
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			

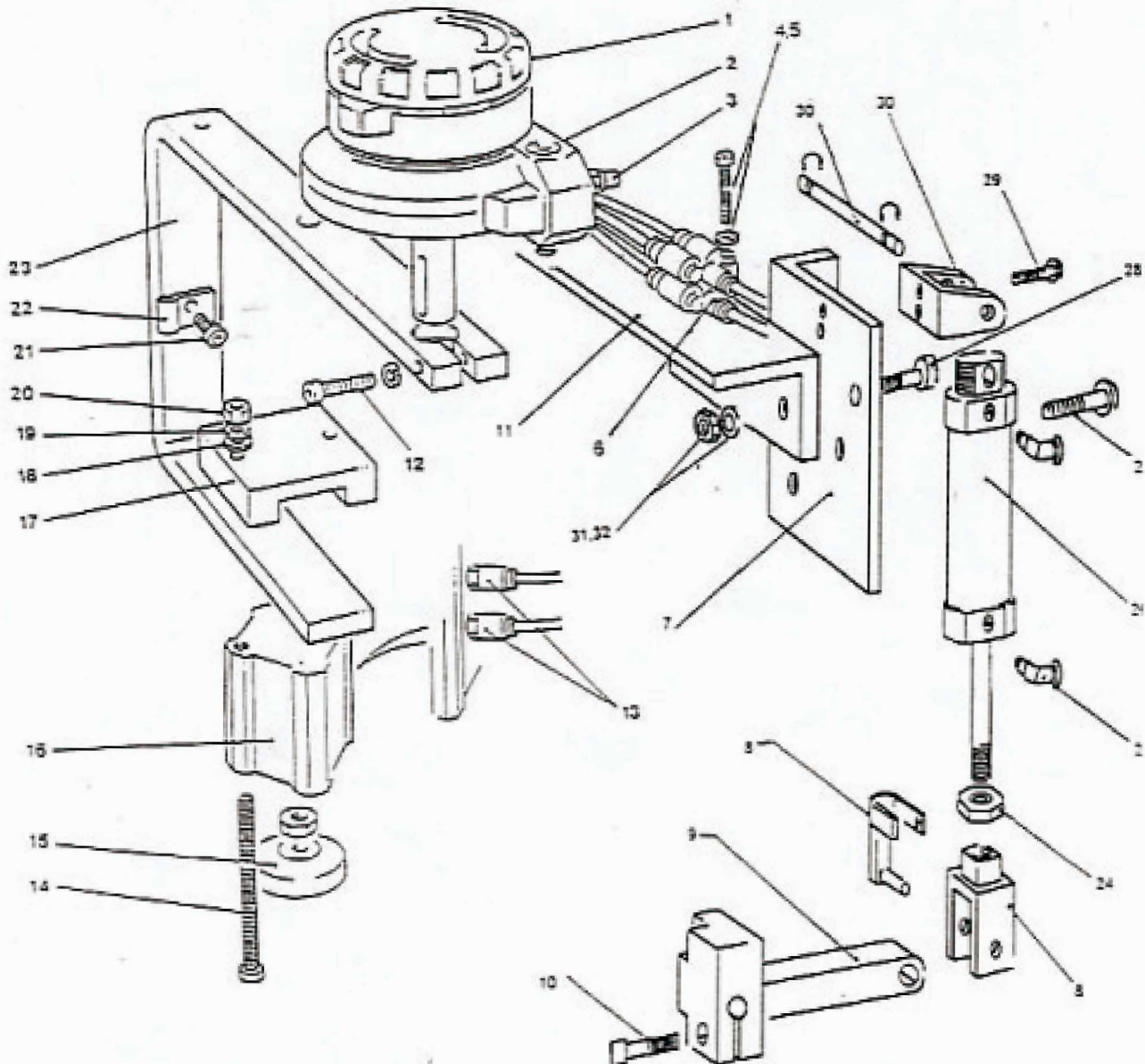
ITEM	CODE No.	DESCRIPTION	QTY
AMPLIFIER			
29	08.6200.5.016	Screw 5x16	1
30	12.0010.4.328	Sensor Optic	1
32	84.0005.7.059	Spacer	1
33	12.0010.4.256	Holder	1

Not illustrated
31 060325 4mm In Line Restrictor 2



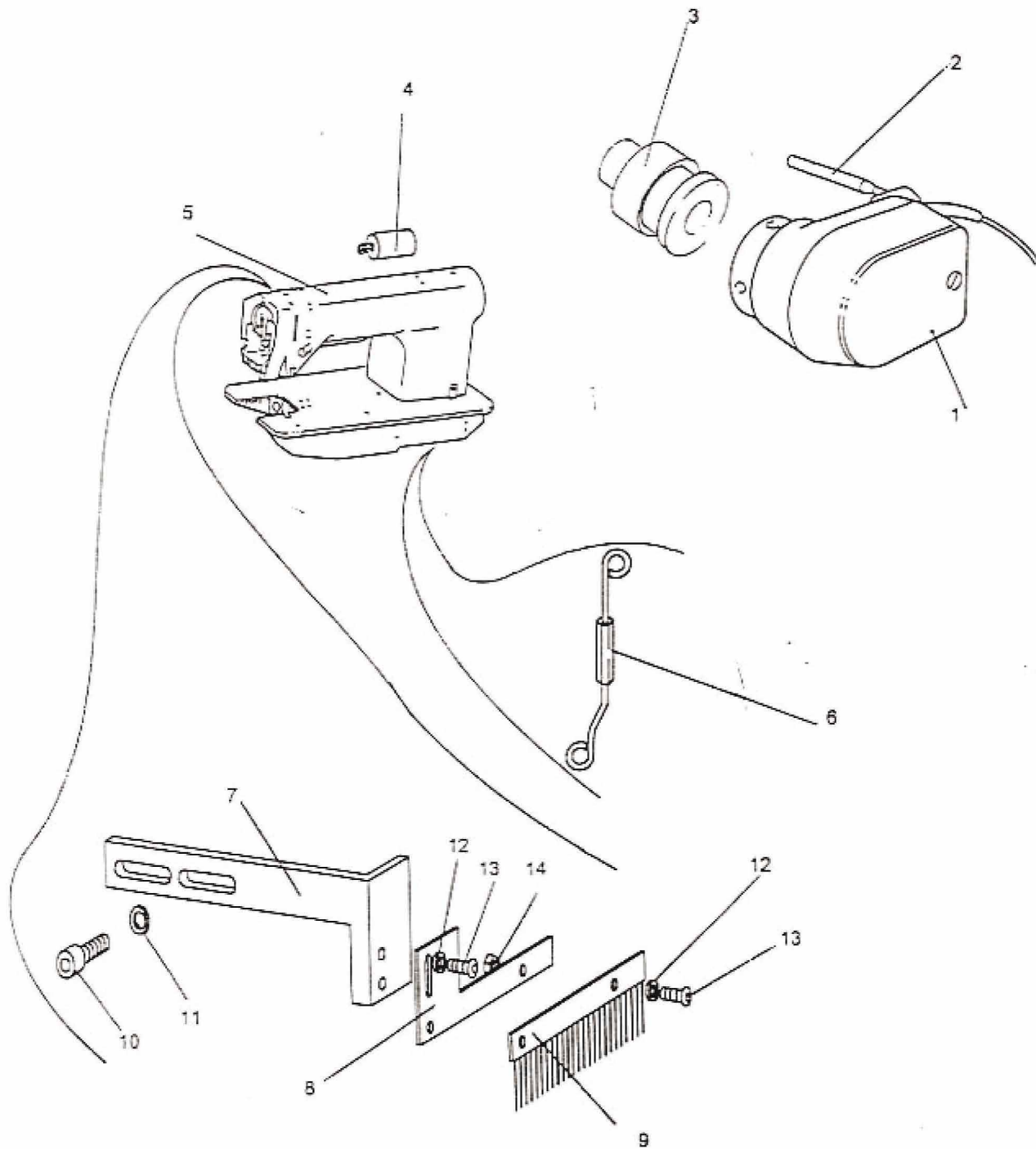
TURN ARM

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	M5x16 Cap Hd Screw	1	29	—	M6x12 Btt Hd Screw	2
11	059012	Outtrigger 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	—	M6x55 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				



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	84.0005.9.502	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



KNIFE MECHANISM

Item No.	Code No.	Description	Qty
1	84.0005.9.174	M2.5x6 Countersunk Screw	2
2	84.0005.9.172	Clamp Plate	1
3	84.0005.9.173	16mm Knife	1
4	84.0005.9.161	9mm Knife	1
5	84.0005.9.171	Adapter	1
6	08.6000.4.008	Screw	1
7	84.0005.9.166	Slide Block	1
8	84.0005.9.685	Clamp Screw	1
9	84.0005.9.166	Adjustable Holder Bkt.	1
10	08.6012.1.008	Slide Clamp Screw	1
11	08.6850.4.000	Washer	1

