

# CLINTON SERVICE GUIDE

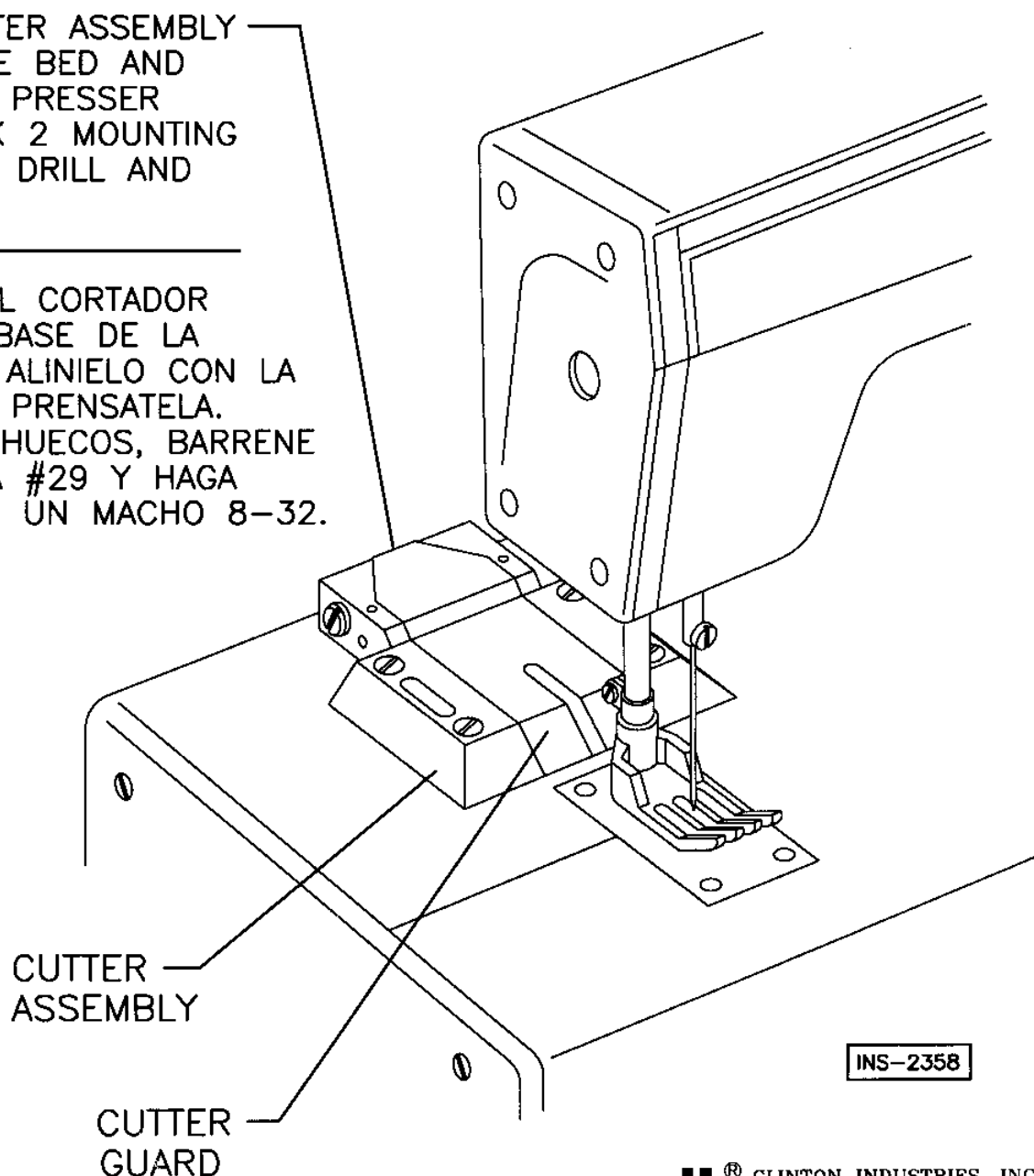
## MODEL 3115FCA

### FOR

## FLAT BED MACHINES

PLACE CUTTER ASSEMBLY ON MACHINE BED AND ALIGN WITH PRESSER FOOT. MARK 2 MOUNTING HOLES AND DRILL AND TAP 8-32.

COLOQUE EL CORTADOR SOBRE LA BASE DE LA MAQUINA Y ALINIELO CON LA BARRA DEL PrensATELA. MARQUE 2 HUECOS, BARRENE CON MECHA #29 Y HAGA ROSCA CON UN MACHO 8-32.

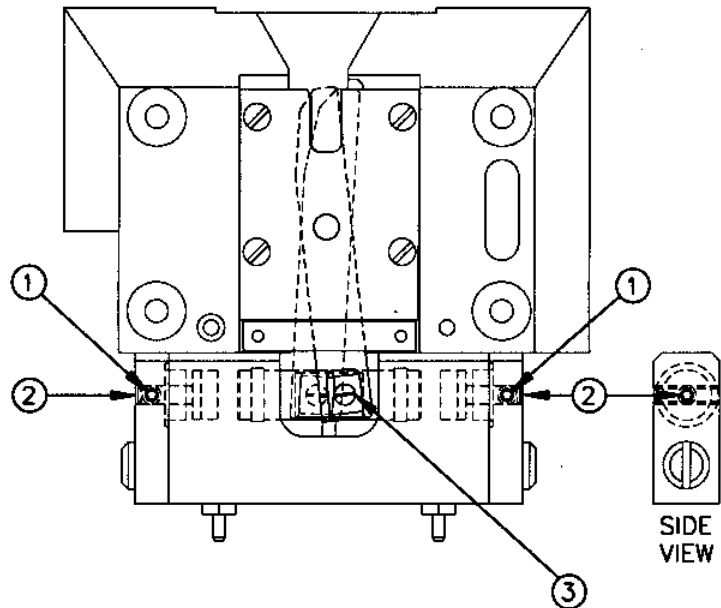


INS-2358

**cii**® CLINTON INDUSTRIES, INC.  
 700 Washington Avenue  
 Carlstadt, N.J. 07072  
 Phone: 201-935-4242  
 FAX: 201-935-3615

## KNIFE STROKE ADJUSTMENT AJUSTE DE LA TRAYECTORIA DE LA CUCHILLA

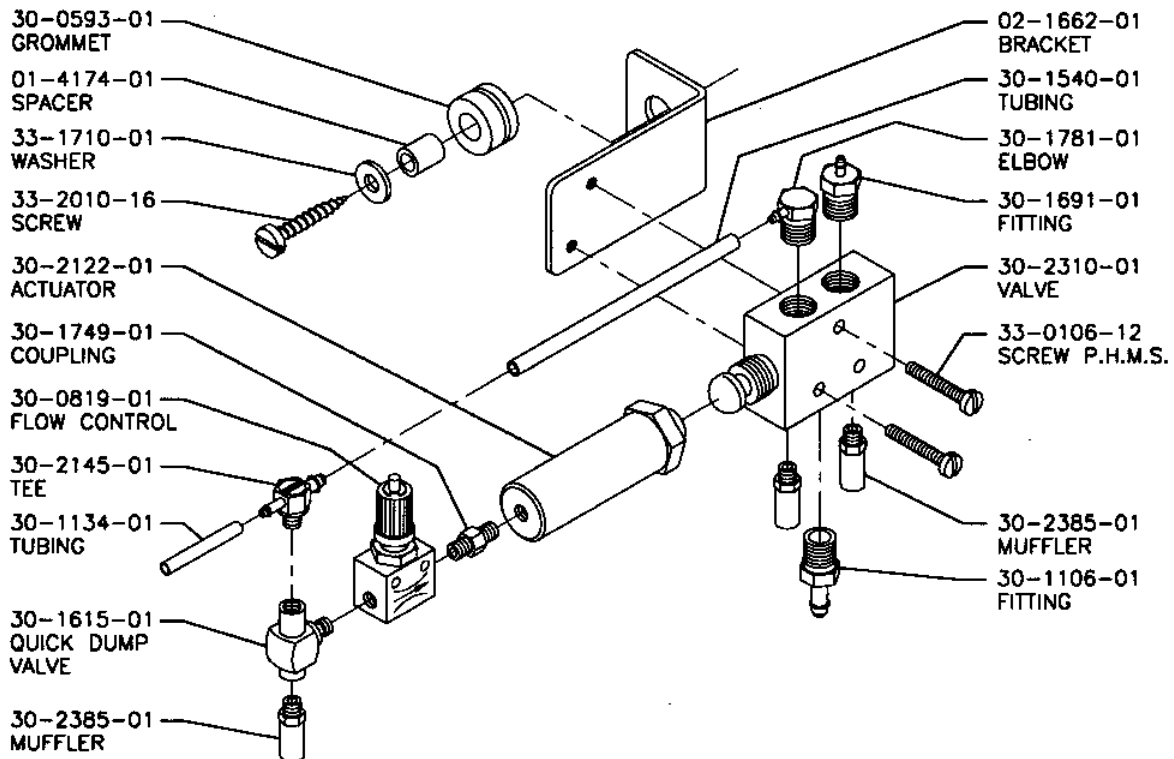
1. LOOSEN SET SCREWS ①.
2. ADJUST THE PISTON STOP CUSHIONS ② TO LIMIT BLADE TRAVEL IN BOTH DIRECTIONS. AFTER COMPLETING ADJUSTMENT, SECURE THE PISTON STOP CUSHIONS BY TIGHTENING SCREWS ①.
3. NOTE: EXCESSIVE TRAVEL MAY CAUSE MOVABLE KNIFE BREAKAGE AT FORK END ③.



1. AFLOJAR TORNILLOS ①.
2. AJUSTE EL TOPE AMORTIGUADOR ② PARA LIMITAR LA TRAYECTORIA DE LA CUCHILLA EN AMBAS DIRECCIONES. DESPUES DE HABER COMPLETADO ESTE AJUSTE, ASEGURE EL TOPE AMORTIGUADOR DEL PISTON CON LOS TORNILLOS ①.
3. NOTA: MOVIMIENTO EXCESIVO DEL PISTON PUEDE CAUSAR QUE SE ROMPA LA CUCHILLA ③.

INS-2357A

## SHUTTLE AIR VALVE ASSEMBLY 80-0512-01



INS-2381A

**CUTTER ASSEMBLY**  
 MODEL 3115 FCA  
 80-0511-01 STANDARD  
 80-0511-05 U.S.

01-3066-41  
SCREW

02-1689-01  
EXHAUST TUBING

01-3066-51  
SCREW

33-3204-04  
SCREW S.H.C.S.

02-1649-01  
BLADE HOLD DOWN

10-1385-01  
PISTON STOP  
CUSHION

02-1640-01  
BODY-DRIVER

30-1133-01  
HOSE FITTING

33-2106-03  
SCREW S.S.S.

10-1385-01  
PISTON STOP  
CUSHION

30-2700-01  
O-RING

02-1642-01  
END CAP

02-2778-01  
PLATE  
(80-0511-05)

02-1657-01  
GUARD

02-1657-02  
GUARD-WIDE

01-3057-02  
SCREW

10-1469-01  
BLADE-CARBIDE  
STATIONARY

10-1470-01  
BLADE-CARBIDE  
MOVABLE

02-1673-01  
PIN

30-2750-01  
SPRING

10-1451-01  
BODY &  
BUSHING ASS'Y.

01-8847-01  
LOGO DECAL

02-1650-01  
STUD

30-1385-01  
RUBBER MOUNTS

01-6003-035  
SCREW

01-1819-61  
BUSHING

02-1644-01  
SLIDE

30-1280-01  
O-RING

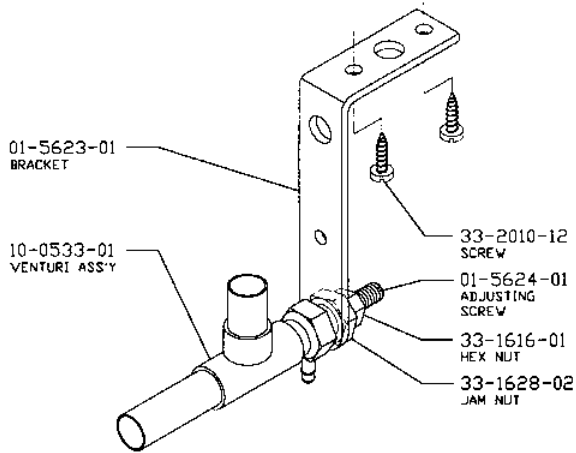
02-1641-01  
PISTON

33-3308-06  
SCREW-S.F.H.C.S.

01-3066-11  
SCREW

**VENTURI ASSEMBLY**

80-0198-02



**ADJUSTMENTS:**

- A. THE VACUUM ADJUSTING SCREW IS PRESET IN THE CLOSED POSITION. IN ORDER TO OBTAIN VACUUM, TURN THE ADJUSTING SCREW COUNTERCLOCKWISE ONE HALF TURN EACH TIME UNTIL THE DESIRED VACUUM IS REACHED. IN MOST APPLICATIONS ONE TO TWO FULL TURNS ON THE VACUUM ADJUSTING SCREW WILL PROVIDE SUFFICIENT VACUUM.
- B. USE ONLY THE AMOUNT OF VACUUM NEEDED FOR EFFECTIVE OPERATION. TOO MUCH VACUUM MAY INTERFERE WITH THE MATERIAL FEED AND CAUSE AN UNNECESSARY WASTE OF COMPRESSED AIR.

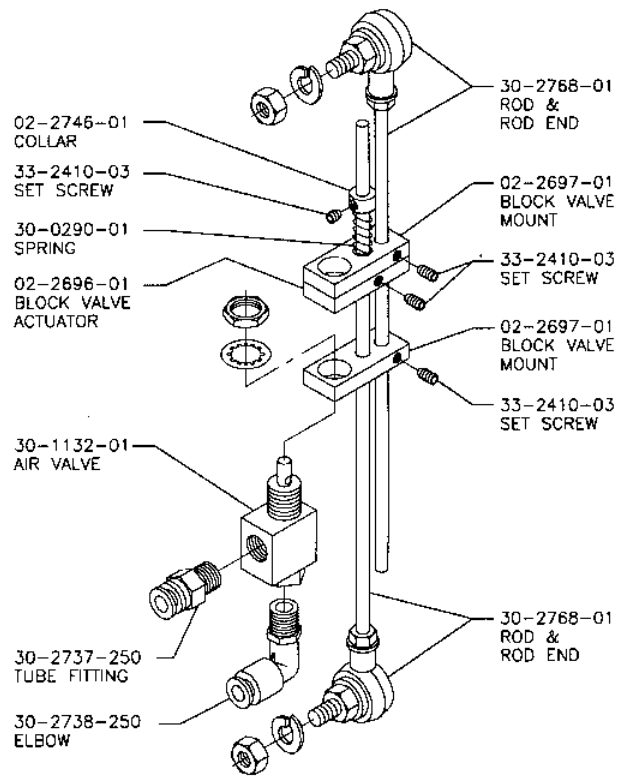
**AJUSTES:**

- A. LA VALVULA DE AGUJA REGULADORA VIENE PRE-AJUSTADA EN POSICION CERRADA. PARA OBTENER MAS ABSORCION, GIRE LA VALVULA DE AGUJA EN DIRECCION CONTRARIA A LAS MANECILLAS DEL RELOJ MEDIA VUELTA A LA VEZ, HASTA QUE LA ABSORCION REQUERIDA ES OBTENIDA. EN LA MAYORIA DE LAS APLICACIONES UNA O DOS VUELTAS COMPLETAS SON MAS QUE SUFFICIENTES PARA OBTENER SUFFICIENTE ABSORCION.
- B. USE SOLAMENTE EL AUMENTO NECESITADO PARA UNA OPERACION EFECTIVA. MUCHA ABSORCION PUEDE INTERFERIR CON LA ALIMENTACION DE LA TELA Y GASTO INNECESARIO DE AIRE.

INS-2360

**TREADLE AIR VALVE**

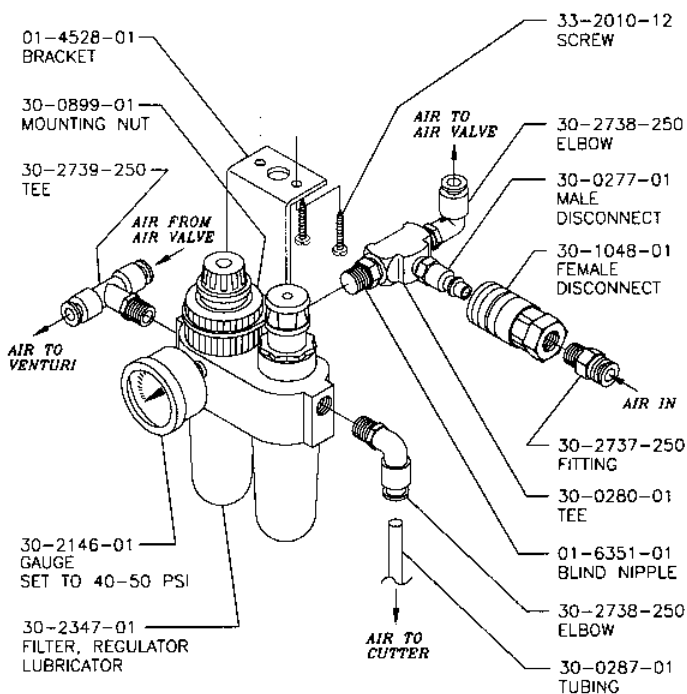
TOE ACTION  
80-0524-01



INS-2402A

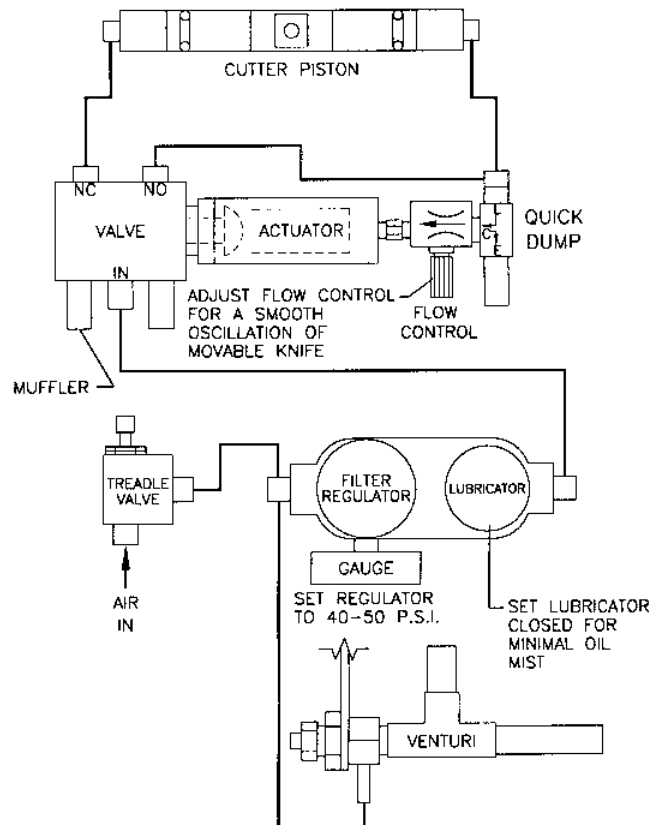
**FILTER, OILER, REGULATOR, GAUGE ASS'Y**

80-0415-04



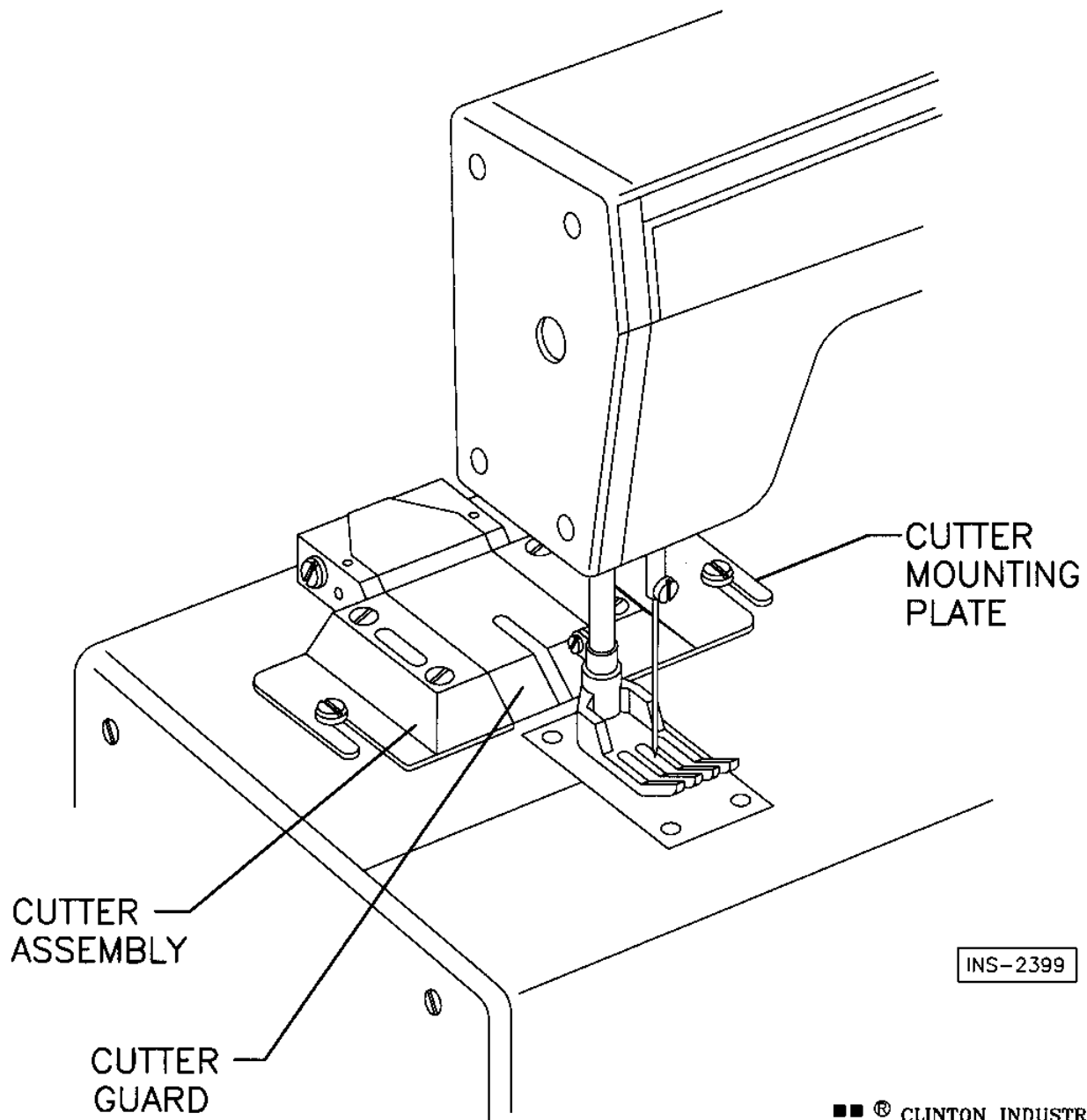
INS-570-15C

**AIR CIRCUIT DIAGRAM**  
MODEL 3115FCA



INS-2359B

# CLINTON SERVICE GUIDE MODEL 3115FCA FOR PFAFF 5489



INS-2399

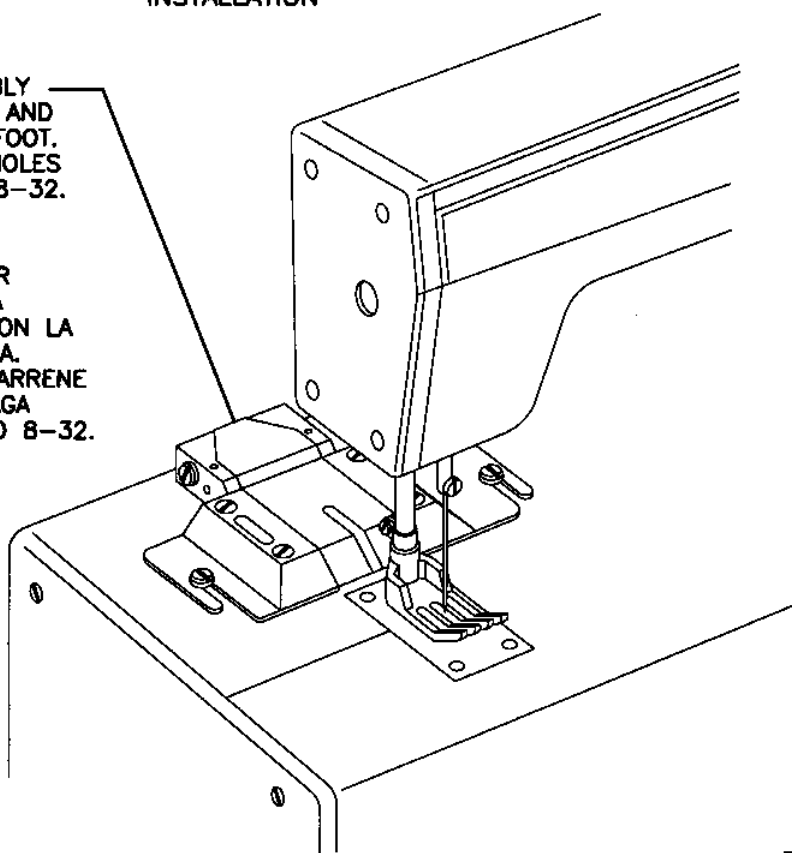


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## INSTALLATION

PLACE CUTTER ASSEMBLY ON THE MACHINE BED AND ALIGN WITH PRESSER FOOT. MARK (2) MOUNTING HOLES THEN DRILL AND TAP 8-32.

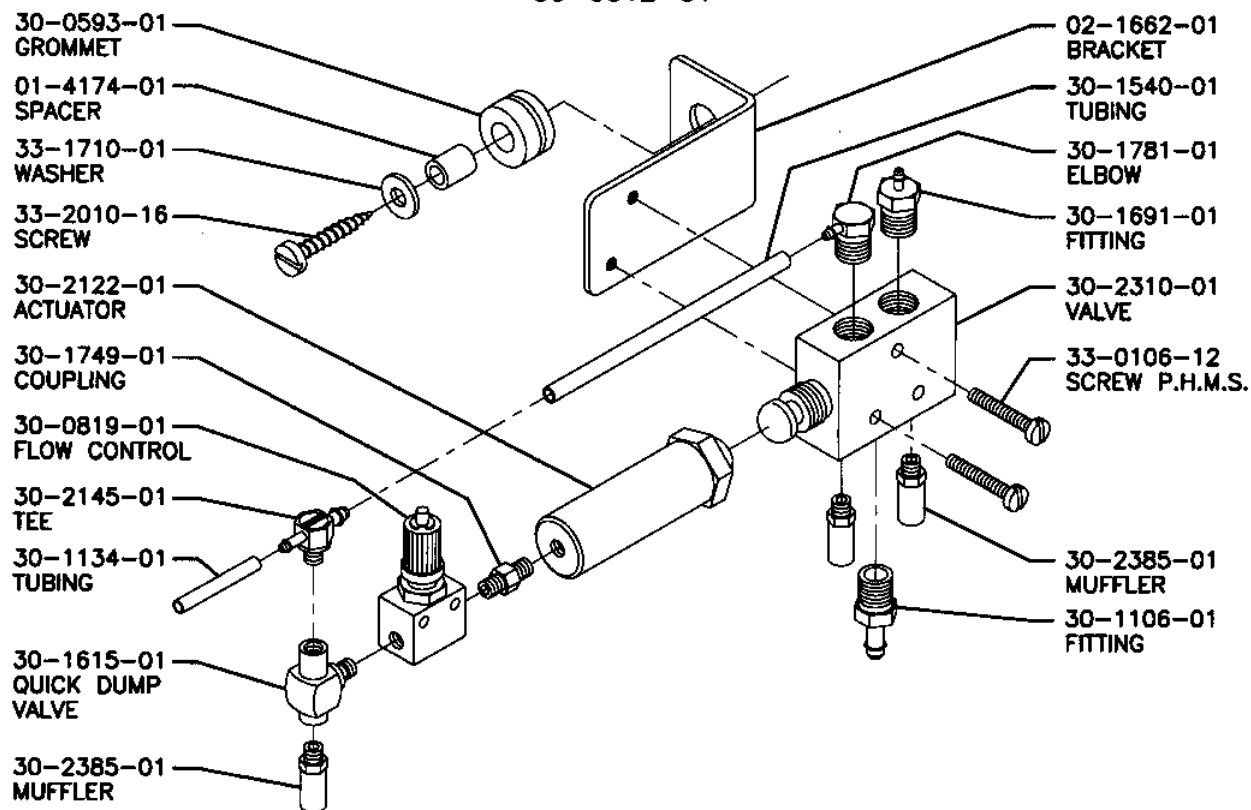
COLOQUE EL CORTADOR SOBRE LA BASE DE LA MAQUINA Y ALINIELO CON LA BARRA DEL PRENSATELA. MARQUE 2 HUECOS. BARRENE CON MECHA #29 Y HAGA ROSCA CON UN MACHO 8-32.



INS-2400

## SHUTTLE AIR VALVE ASSEMBLY

80-0512-01



INS-2361A

# CUTTER ASSEMBLY

MODEL 3115 FCA  
80-0511-02

01-3066-41  
SCREW

02-1689-01  
EXHAUST TUBING

01-3066-11  
SCREW

33-3204-04  
SCREW S.H.C.S.

02-1649-01  
BLADE HOLD DOWN

10-1385-01  
PISTON STOP  
CUSHION

02-1640-01  
BODY-DRIVER

30-1133-01  
HOSE FITTING

33-2106-03  
SCREW S.S.S.

10-1385-01  
PISTON STOP  
CUSHION

30-2700-01  
O-RING

02-1642-01  
END CAP

02-2778-01  
PLATE

02-1657-01  
GUARD

02-1657-02  
GUARD-WIDE

01-3057-02  
SCREW

10-1469-01  
BLADE-CARBIDE  
STATIONARY

10-1470-01  
BLADE-CARBIDE  
MOVABLE

02-1673-01  
PIN

30-2750-01  
SPRING

10-1451-01  
BODY &  
BUSHING ASS'Y.

01-8847-01  
LOGO DECAL

02-1650-01  
STUD

30-1385-01  
RUBBER MOUNTS

01-6003-035  
SCREW

01-1819-61  
BUSHING

02-1644-01  
SLIDE

30-1280-01  
O-RING

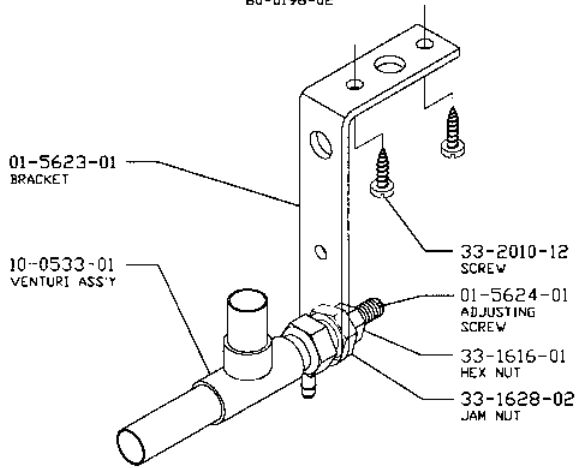
02-1641-01  
PISTON

33-3308-06  
SCREW-S.F.H.C.S.

01-3066-11  
SCREW

**VENTURI ASSEMBLY**

80-0198-02



**ADJUSTMENTS:**

- A. THE VACUUM ADJUSTING SCREW IS PRESET IN THE CLOSED POSITION. IN ORDER TO OBTAIN VACUUM, TURN THE ADJUSTING SCREW COUNTERCLOCKWISE ONE HALF TURN EACH TIME UNTIL THE DESIRED VACUUM IS REACHED. IN MOST APPLICATIONS ONE TO TWO FULL TURNS ON THE VACUUM ADJUSTING SCREW WILL PROVIDE SUFFICIENT VACUUM.
- B. USE ONLY THE AMOUNT OF VACUUM NEEDED FOR EFFECTIVE OPERATION. TOO MUCH VACUUM MAY INTERFERE WITH THE MATERIAL FEED AND CAUSE AN UNNECESSARY WASTE OF COMPRESSED AIR.

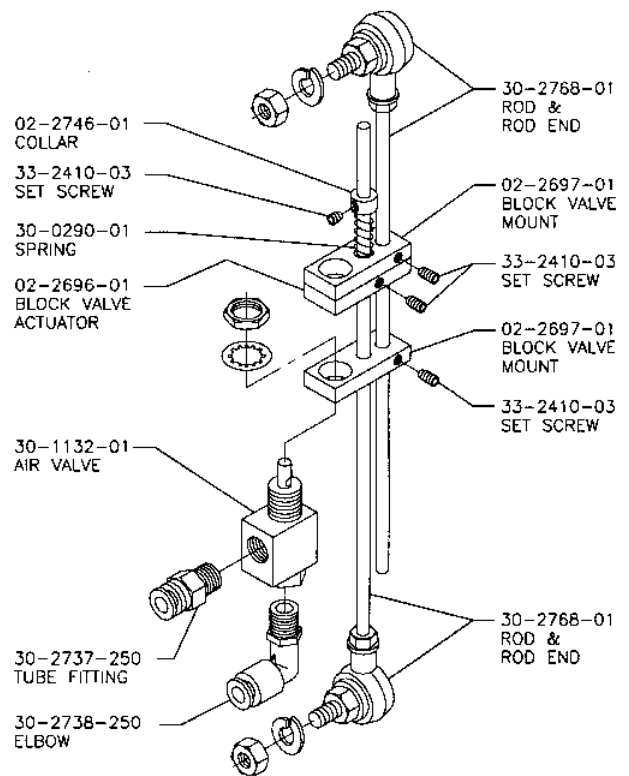
**AJUSTES:**

- A. LA VALVULA DE AGUJA REGULADORA VIENE PRE-AJUSTADA EN POSICION CERRADA. PARA OBTENER MAS ABSORCION, GIRE LA VALVULA DE AGUJA EN DIRECCION CONTRARIA A LAS MANECILLAS DEL RELOJ MEDIA VUELTA A LA VEZ, HASTA QUE LA ABSORCION REQUERIDA ES OBTENIDA. EN LA MAYORIA DE LAS APLICACIONES UNA O DOS VUELTAS COMPLETAS SON MAS QUE SUFFICIENTES PARA OBTENER SUFFICIENTE ABSORCION.
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INS-2360

**TREADLE AIR VALVE**

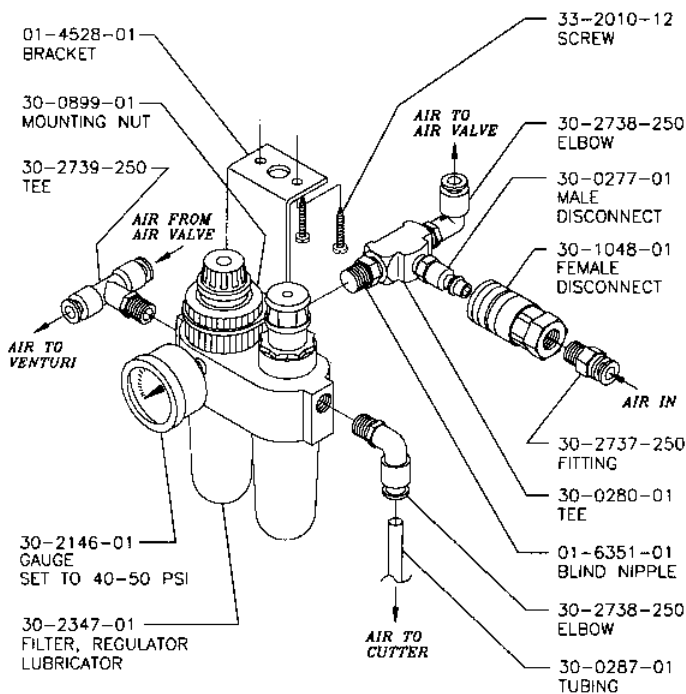
TOE ACTION  
80-0524-01



INS-2402A

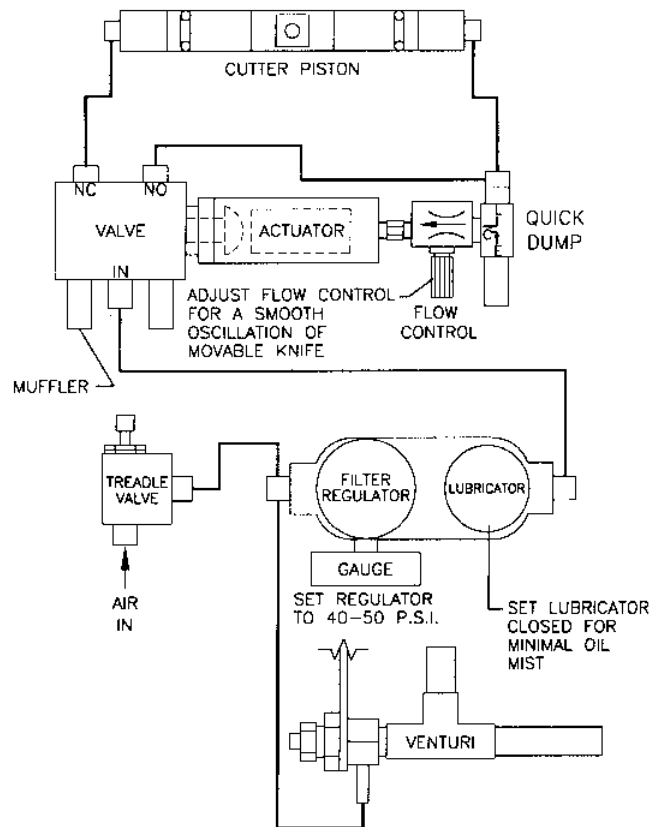
**FILTER, OILER, REGULATOR, GAUGE ASS'Y**

80-0415-04



INS-570-15C

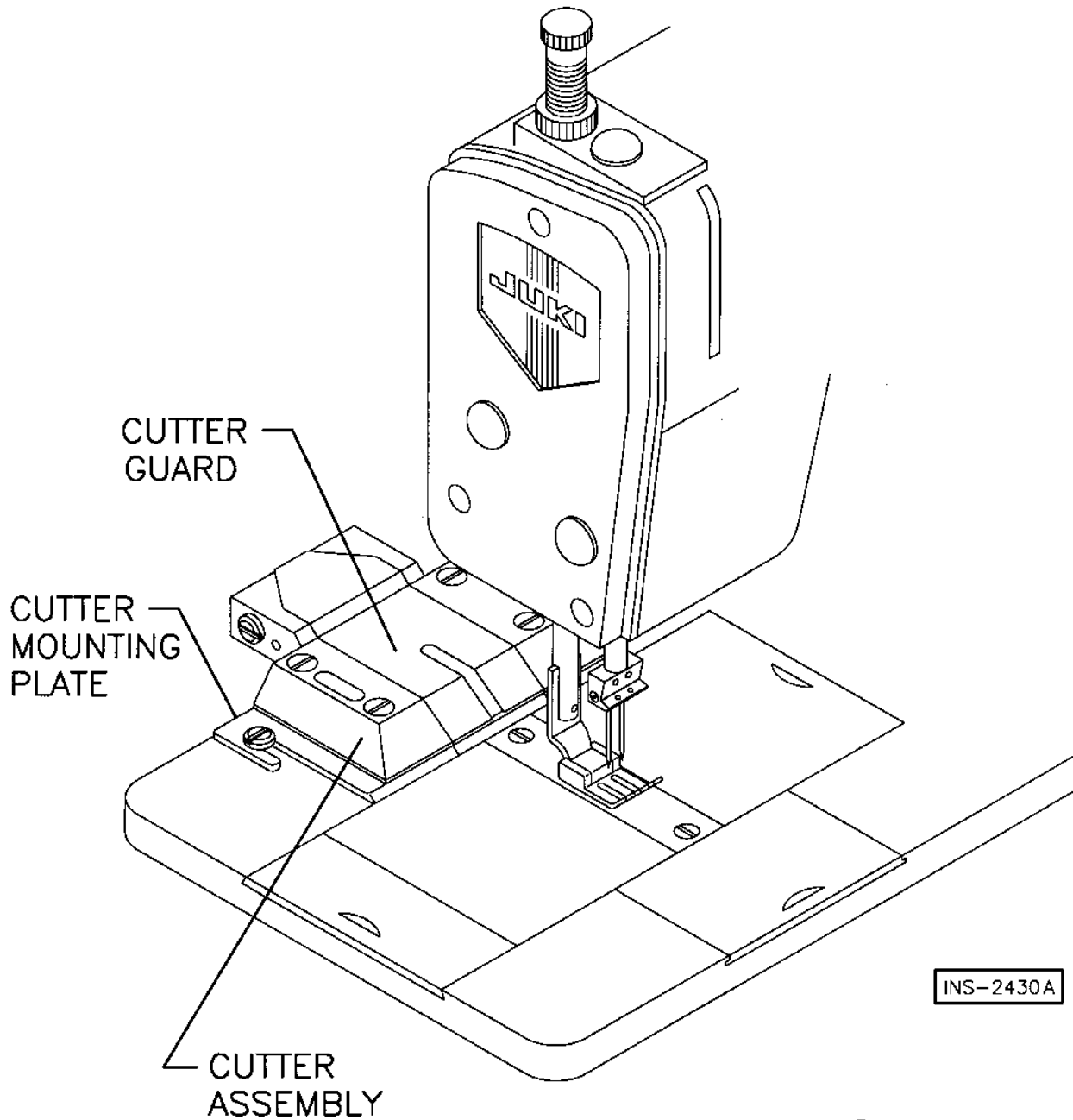
**AIR CIRCUIT DIAGRAM**  
MODEL 3115FCA



INS-2359B



# CLINTON SERVICE GUIDE MODEL 3115FCA FOR JUKI 1152



INS-2430A

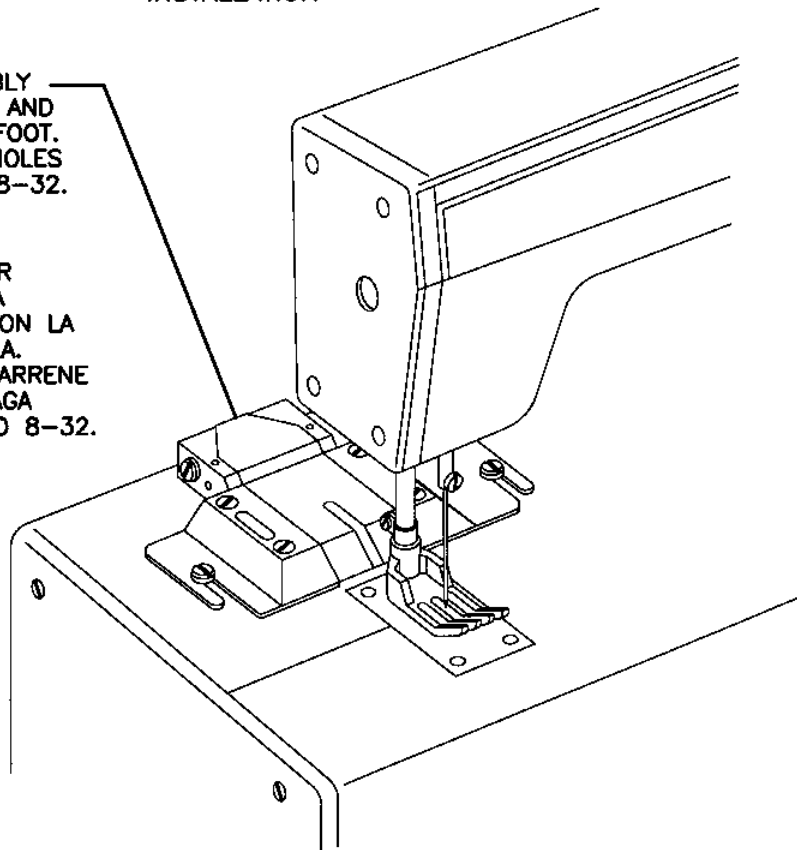


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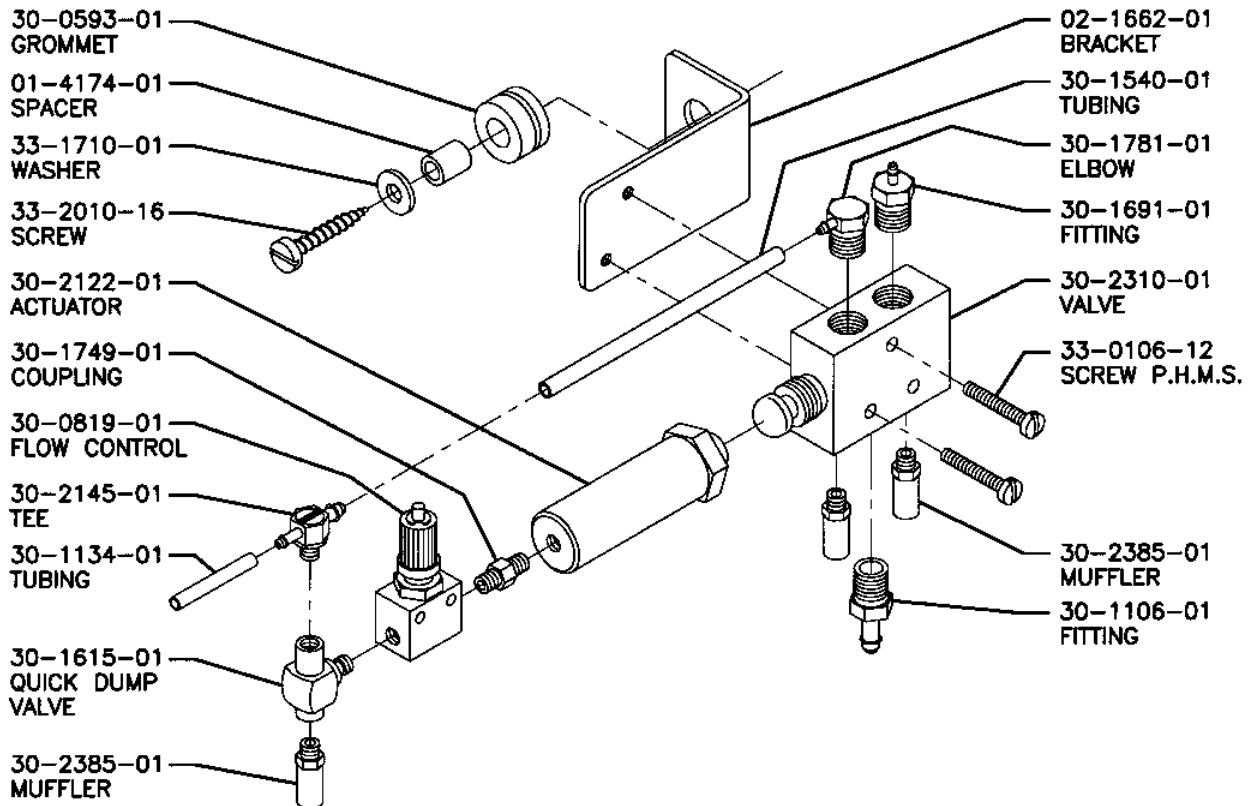
## INSTALLATION

PLACE CUTTER ASSEMBLY  
ON THE MACHINE BED AND  
ALIGN WITH PRESSER FOOT.  
MARK (2) MOUNTING HOLES  
THEN DRILL AND TAP 8-32.

COLOQUE EL CORTADOR  
SOBRE LA BASE DE LA  
MAQUINA Y ALINIELO CON LA  
BARRA DEL PRENSATELA.  
MARQUE 2 HUECOS. BARRENE  
CON MECHA #29 Y HAGA  
ROSCA CON UN MACHO 8-32.



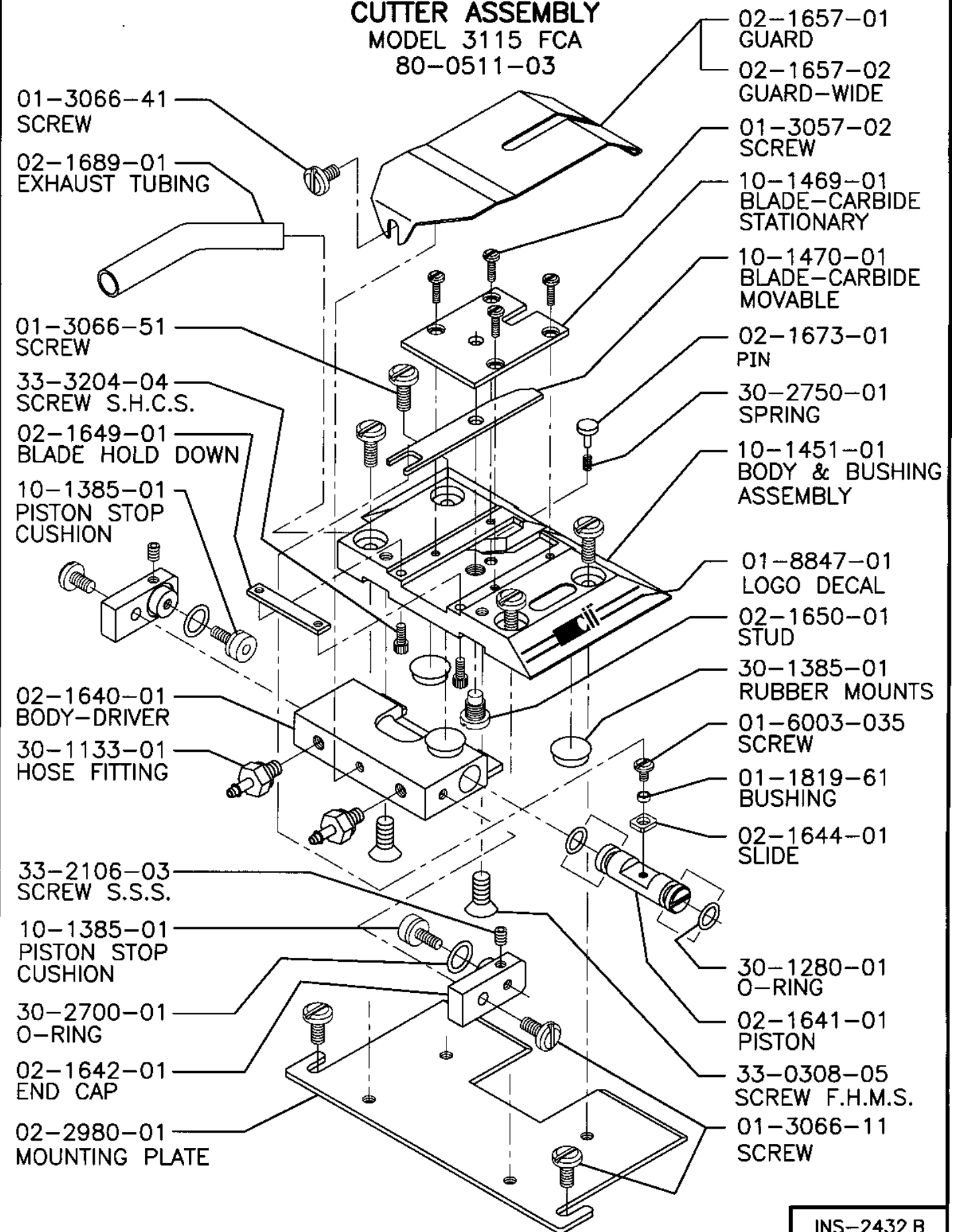
INS-2400

SHUTTLE AIR VALVE ASSEMBLY  
80-0512-01

INS-2361A

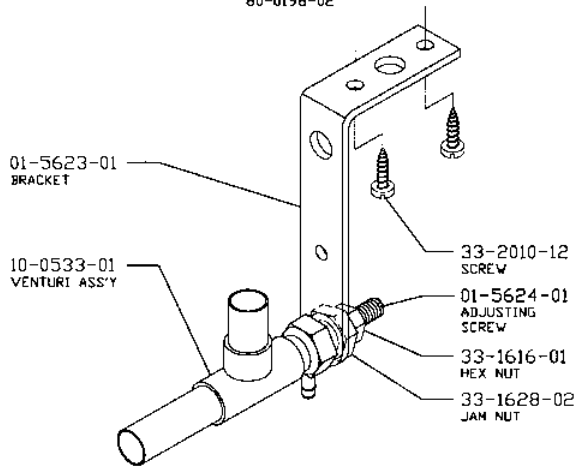
# CUTTER ASSEMBLY

MODEL 3115 FCA  
80-0511-03



### VENTURI ASSEMBLY

80-0198-02



**ADJUSTMENTS:**

- A. THE VACUUM ADJUSTING SCREW IS PRESET IN THE CLOSED POSITION. IN ORDER TO OBTAIN VACUUM, TURN THE ADJUSTING SCREW COUNTERCLOCKWISE ONE HALF TURN EACH TIME UNTIL THE DESIRED VACUUM IS REACHED. IN MOST APPLICATIONS ONE TO TWO FULL TURNS ON THE VACUUM ADJUSTING SCREW WILL PROVIDE SUFFICIENT VACUUM.
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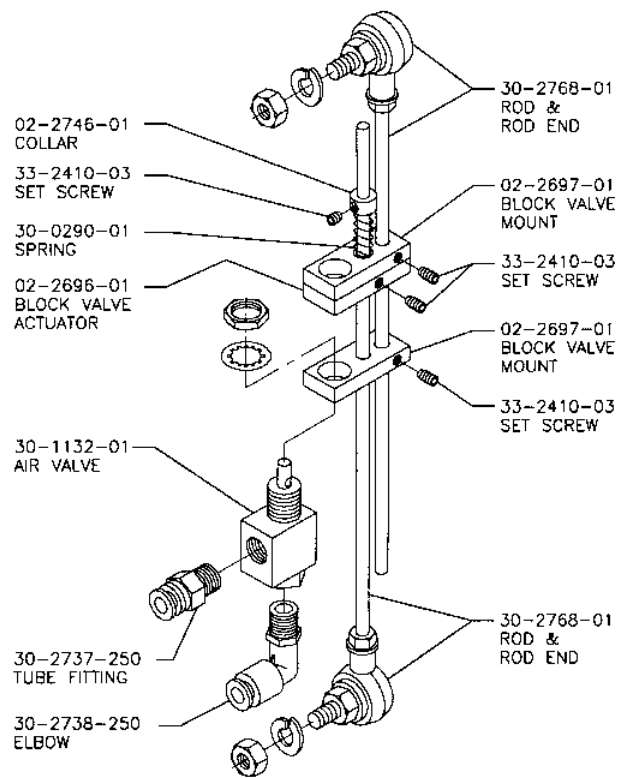
**AJUSTES:**

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INS-2360

### TREADLE AIR VALVE

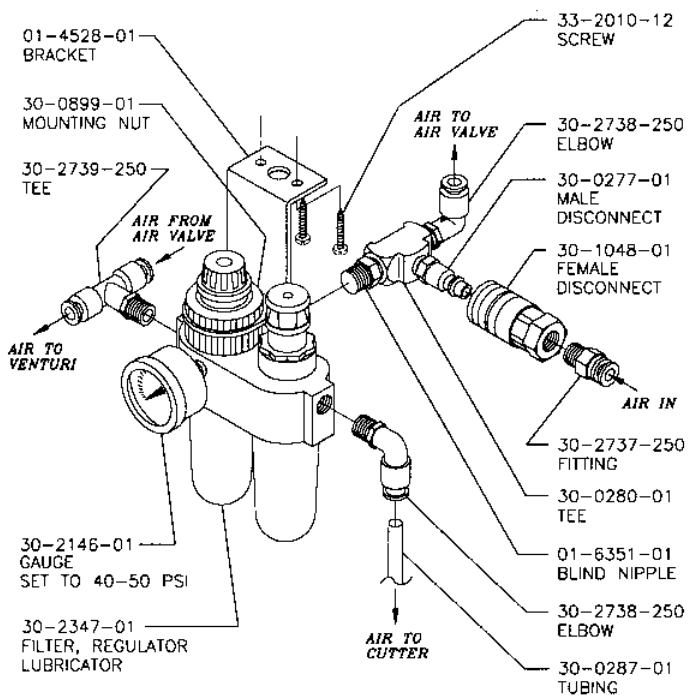
TOE ACTION  
80-0524-01



INS-2402A

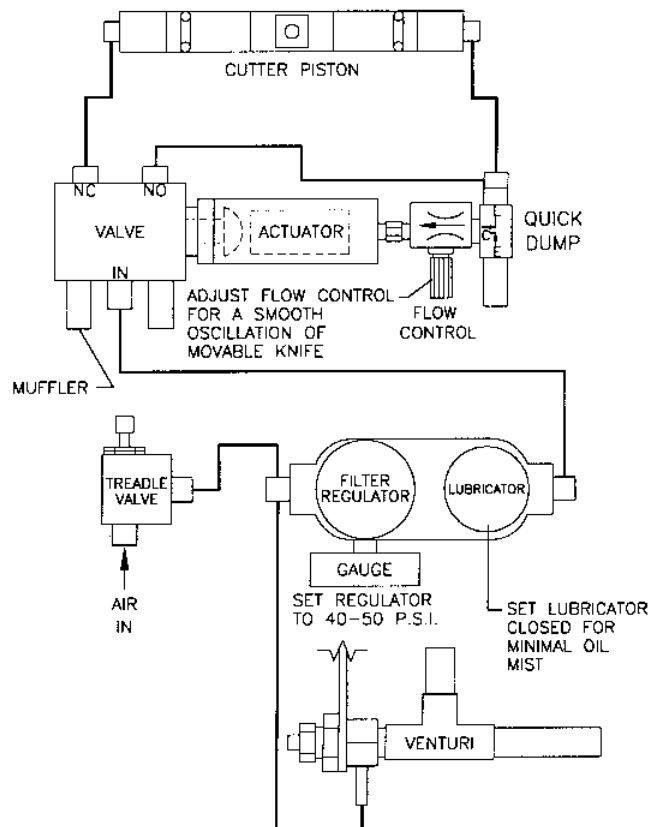
### FILTER, OILER, REGULATOR, GAUGE ASS'Y

80-0415-04



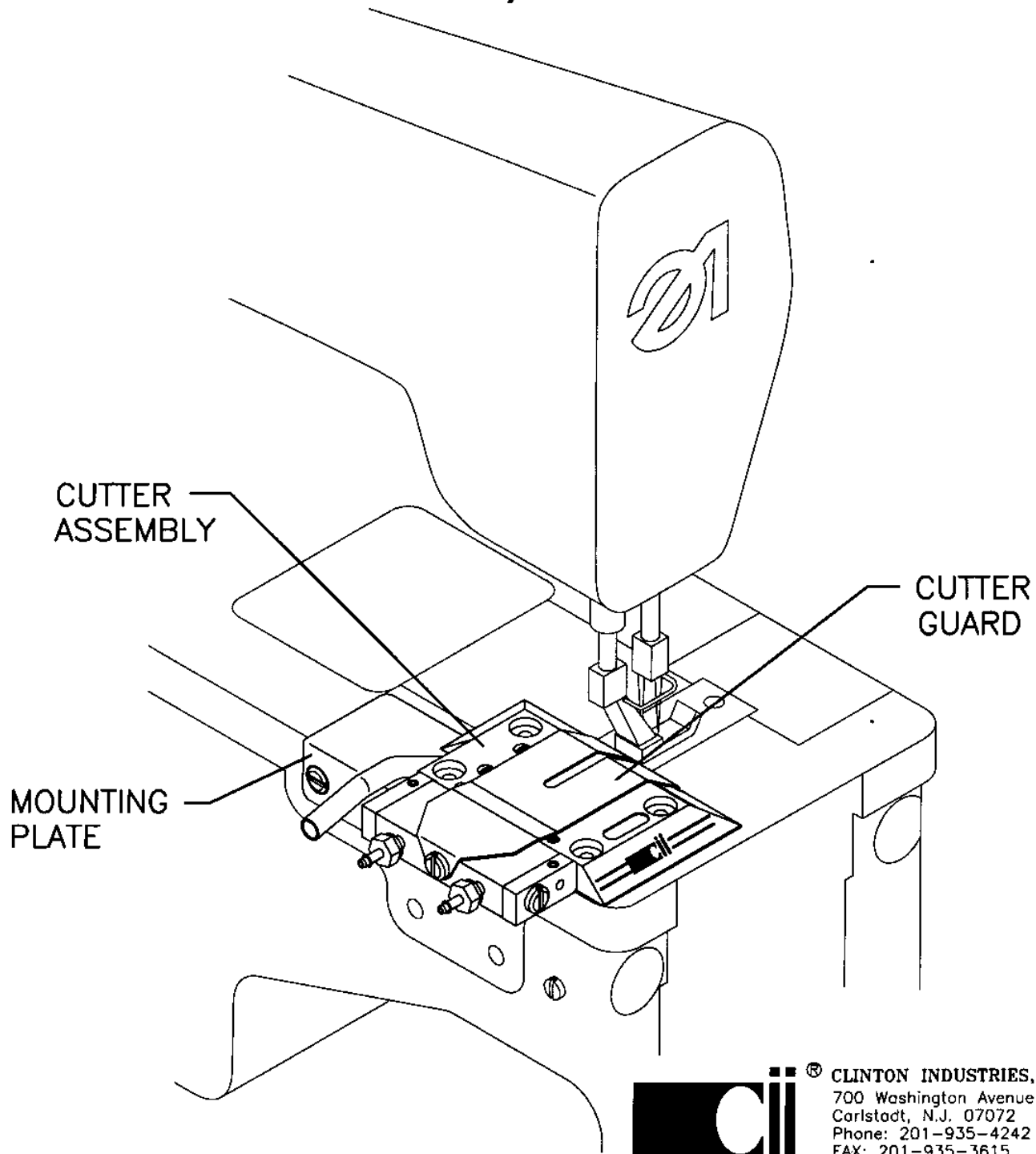
INS-570-15C

### AIR CIRCUIT DIAGRAM MODEL 3115FCA



INS-2359B

# CLINTON SERVICE GUIDE MODEL 3115FCA FOR DURKOPP/ADLER 244

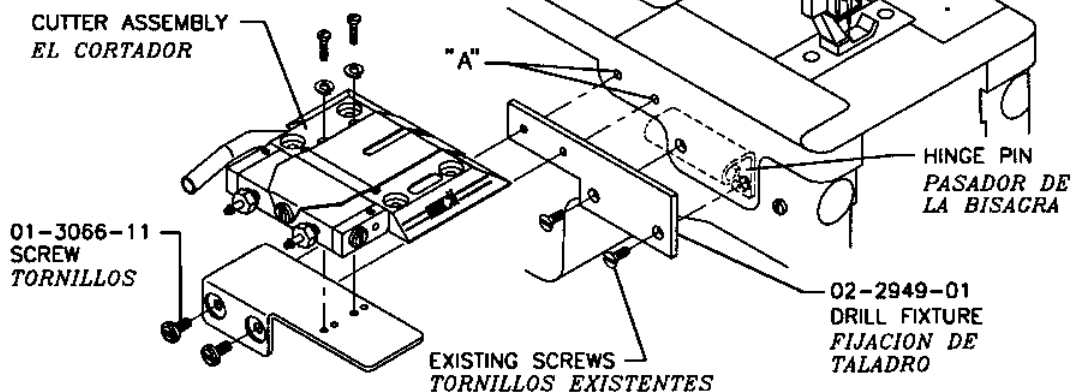


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## INSTALLATION

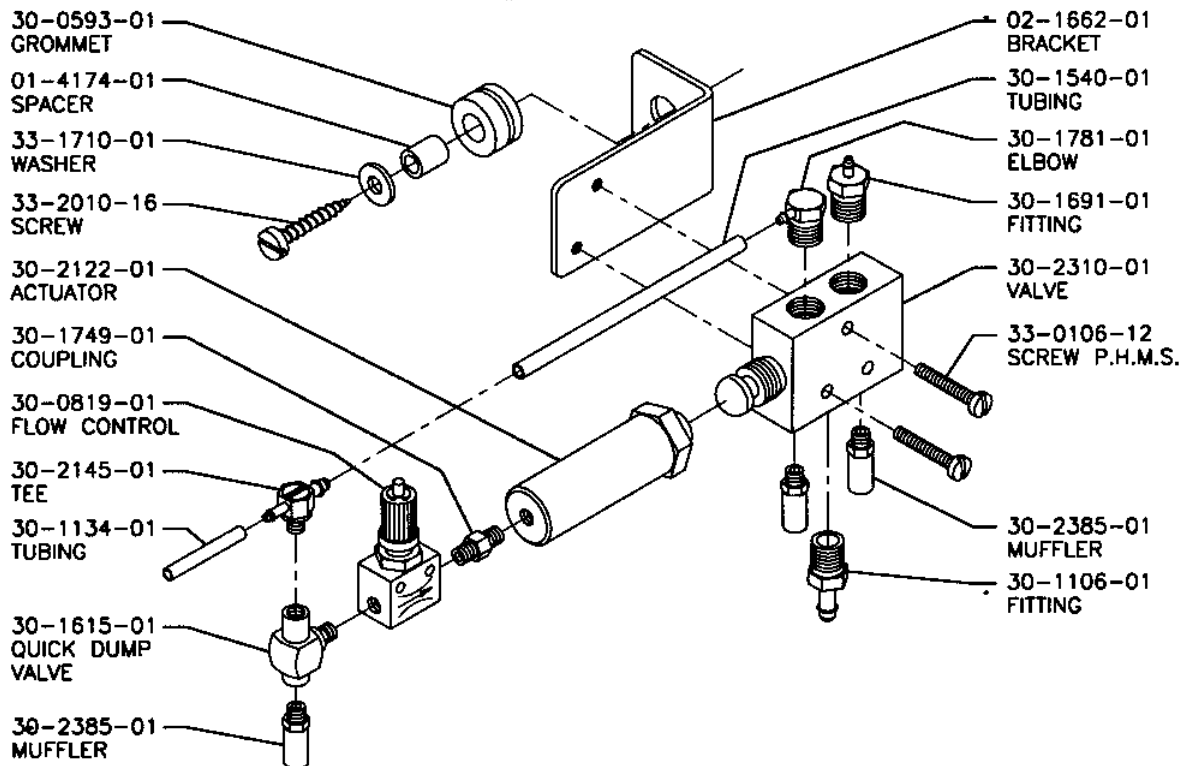
1. REMOVE THE HINGE PIN.
2. MOUNT DRILL FIXTURE 02-2949-01 USING EXISTING SCREWS.
3. DRILL AND TAP (2) 8-32 HOLES MARKED "A".
4. MOUNT CUTTER ASSEMBLY TO MACHINE HEAD USING (2) SCREWS 01-3066-11.

1. *QUITE EL PASADOR DE LA BISAGRA.*
2. *MONTE LA FIJACION DE TALADRO USANDO LOS TORNILLOS EXISTENTES.*
3. *USANDO LA BROCA Y EL MACHUELO 8-32, HAGA (2) PERFORACIONES MARCADOS CON LA LETRA "A".*
4. *MONTE EL CORTADOR A LA MAQUINA USANDO LOS DOS TORNILLOS 01-3066-11.*



## SHUTTLE AIR VALVE ASSEMBLY

80-0512-01



# CUTTER ASSEMBLY

MODEL 3115 FCA  
80-0511-04

01-3066-41  
SCREW

02-1689-01  
EXHAUST TUBING

33-0105-08  
SCREW-P.H.M.S.

33-1805-01  
LOCK WASHER

33-3204-04  
SCREW S.H.C.S.

02-1649-01  
BLADE HOLD DOWN

10-1385-01  
PISTON STOP  
CUSHION

02-1640-01  
BODY-DRIVER

30-1133-01  
HOSE FITTING

33-2106-03  
SCREW S.S.S.

10-1385-01  
PISTON STOP  
CUSHION

30-2700-01  
O-RING

02-2948-01  
MOUNTING PLATE

01-3066-11  
SCREW

02-1657-01  
GUARD

02-1657-02  
GUARD-WIDE

01-3057-02  
SCREW

10-1469-01  
BLADE-CARBIDE  
STATIONARY

10-1470-01  
BLADE-CARBIDE  
MOVABLE

02-1673-01  
PIN

30-2750-01  
SPRING

10-1451-02  
BODY & BUSHING  
ASSEMBLY

01-8847-01  
LOGO DECAL

02-1650-01  
STUD

30-1385-01  
RUBBER MOUNTS

01-6003-035  
SCREW

01-1819-61  
BUSHING

02-1644-01  
SLIDE

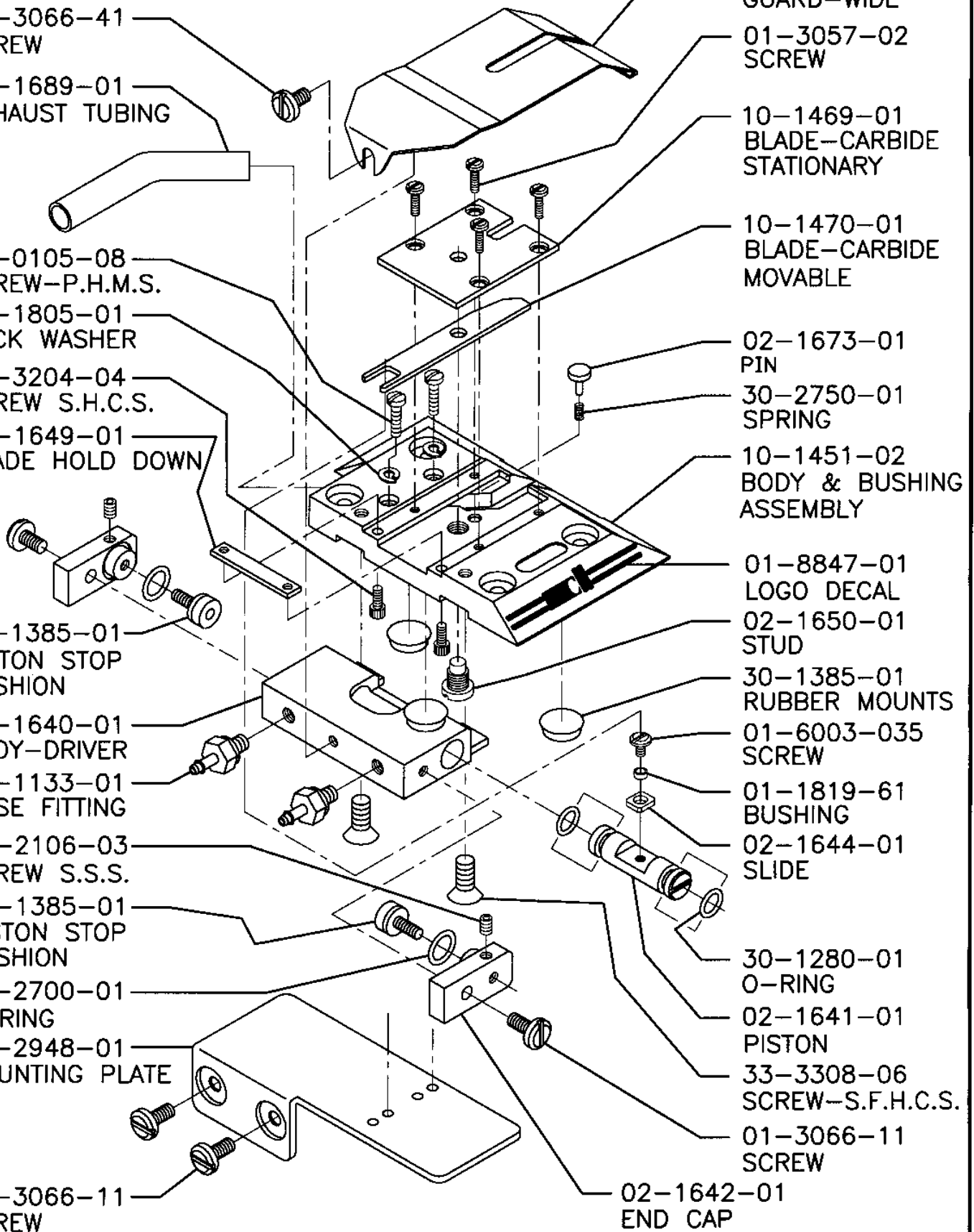
30-1280-01  
O-RING

02-1641-01  
PISTON

33-3308-06  
SCREW-S.F.H.C.S.

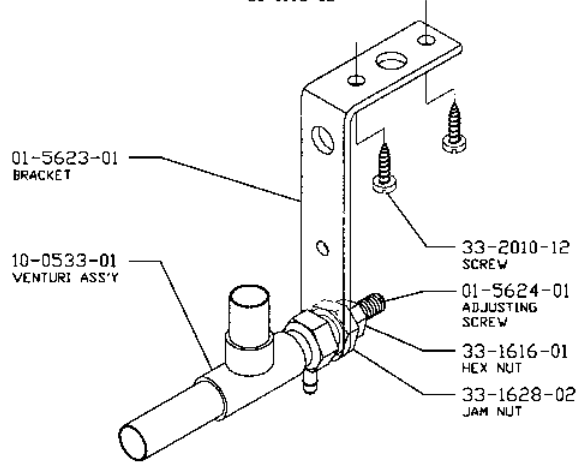
01-3066-11  
SCREW

02-1642-01  
END CAP



**VENTURI ASSEMBLY**

80-0198-02



**ADJUSTMENTS:**

- A. THE VACUUM ADJUSTING SCREW IS PRESET IN THE CLOSED POSITION. IN ORDER TO OBTAIN VACUUM, TURN THE ADJUSTING SCREW COUNTERCLOCKWISE ONE HALF TURN EACH TIME UNTIL THE DESIRED VACUUM IS REACHED. IN MOST APPLICATIONS ONE TO TWO FULL TURNS ON THE VACUUM ADJUSTING SCREW WILL PROVIDE SUFFICIENT VACUUM.
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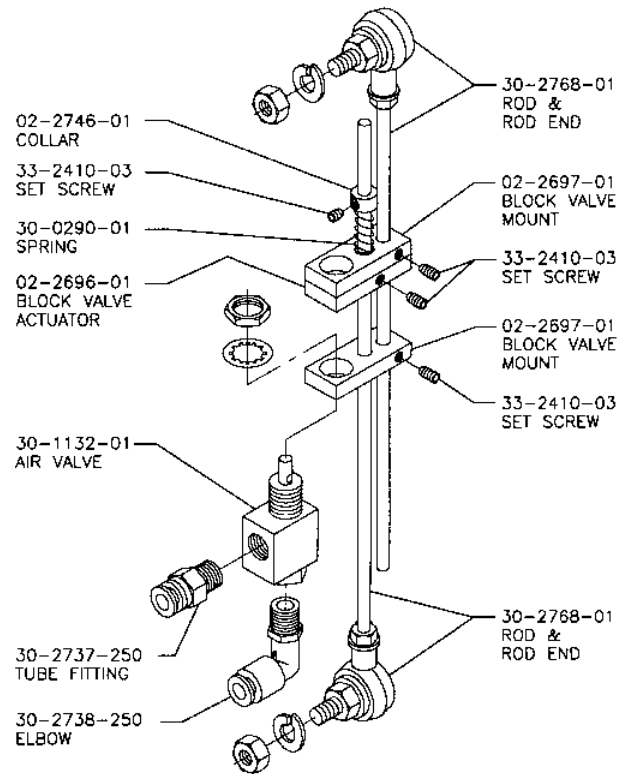
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INS-2360

**TREADLE AIR VALVE**

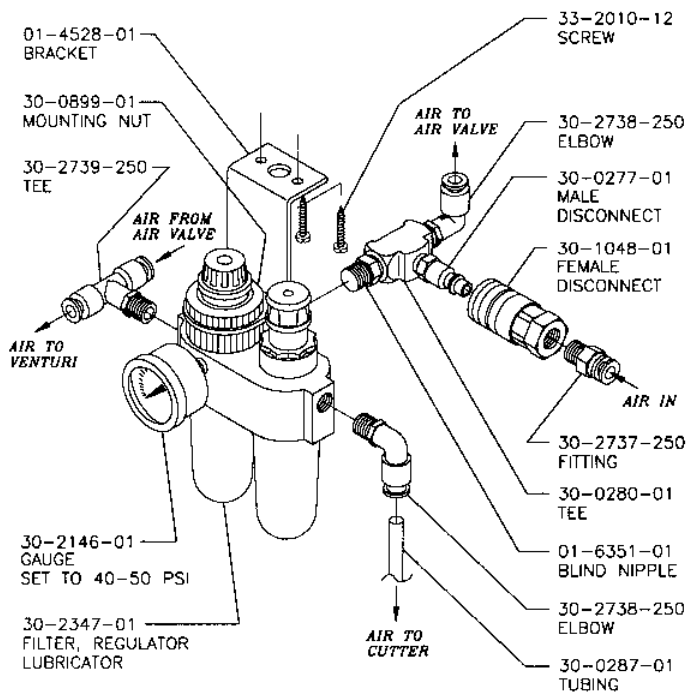
TOE ACTION  
80-0524-01



INS-2402A

**FILTER, OILER, REGULATOR, GAUGE ASS'Y**

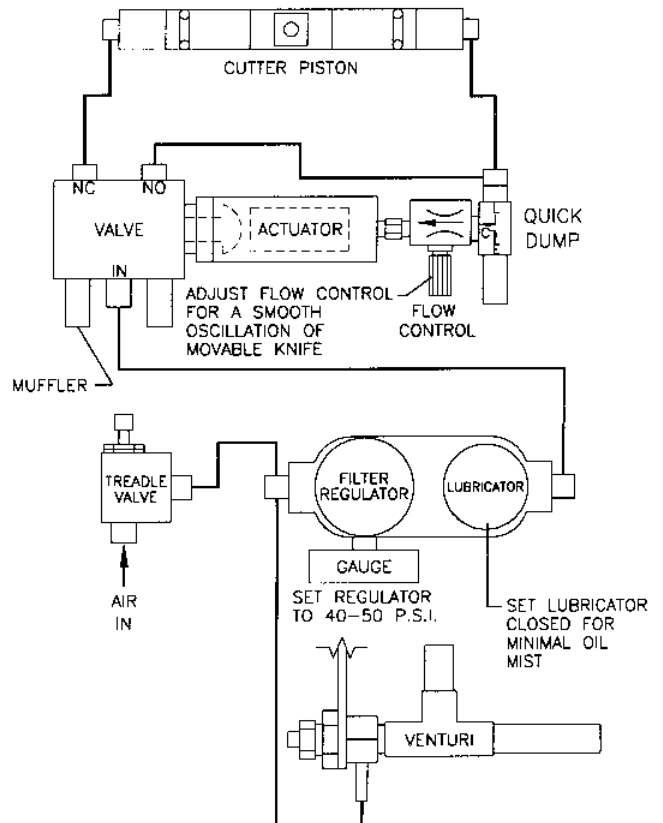
80-0415-04



INS-570-15C

**AIR CIRCUIT DIAGRAM**

MODEL 3115FCA



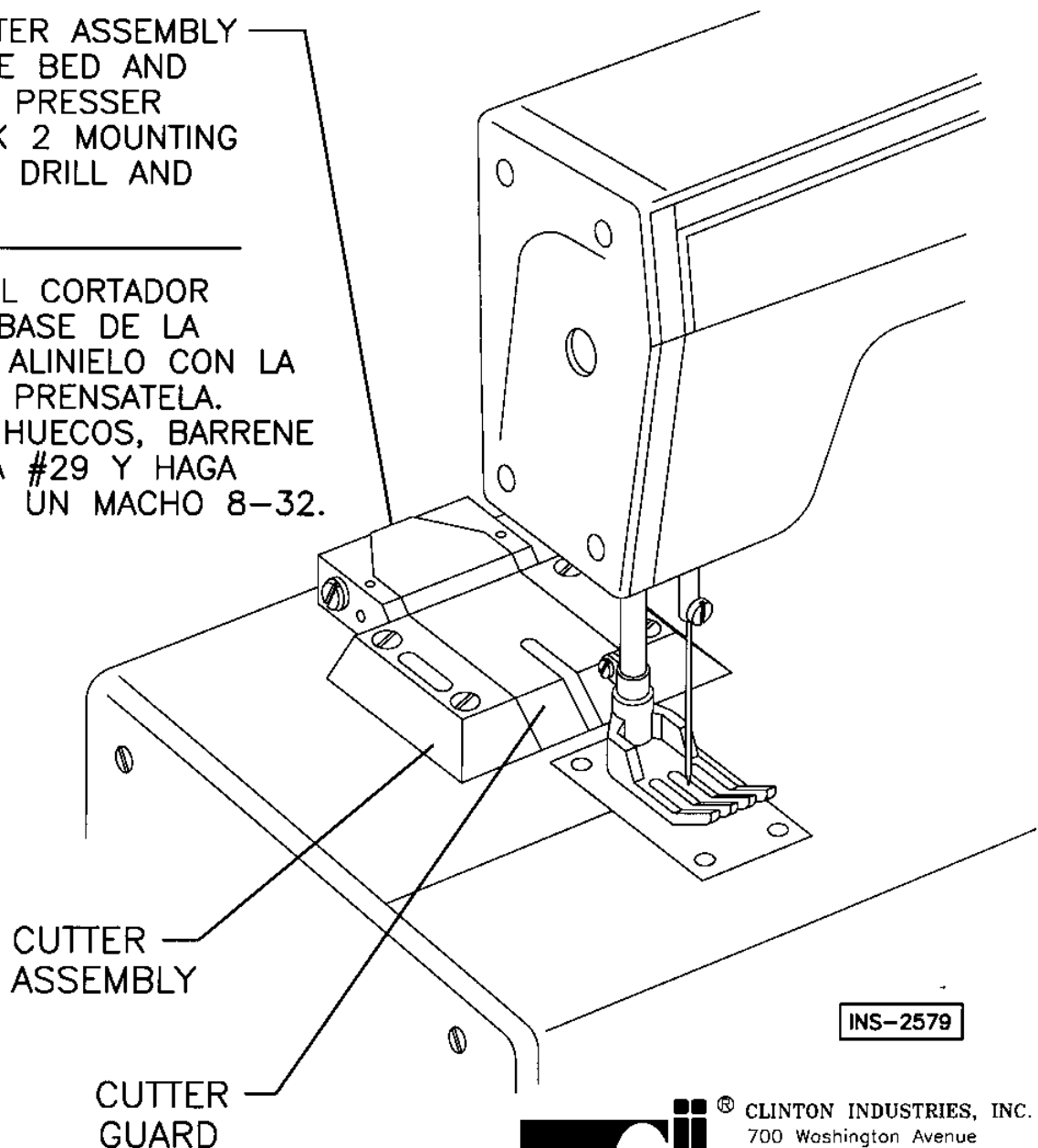
INS-2359B



# CLINTON SERVICE GUIDE MODEL 3115FCA-TR-C FOR UNION SPECIAL FLAT BED MACHINES

PLACE CUTTER ASSEMBLY  
ON MACHINE BED AND  
ALIGN WITH PRESSER  
FOOT. MARK 2 MOUNTING  
HOLES AND DRILL AND  
TAP 8-32.

COLOQUE EL CORTADOR  
SOBRE LA BASE DE LA  
MAQUINA Y ALINIELO CON LA  
BARRA DEL PrensATELA.  
MARQUE 2 HUECOS, BARRENE  
CON MECHA #29 Y HAGA  
ROSCA CON UN MACHO 8-32.

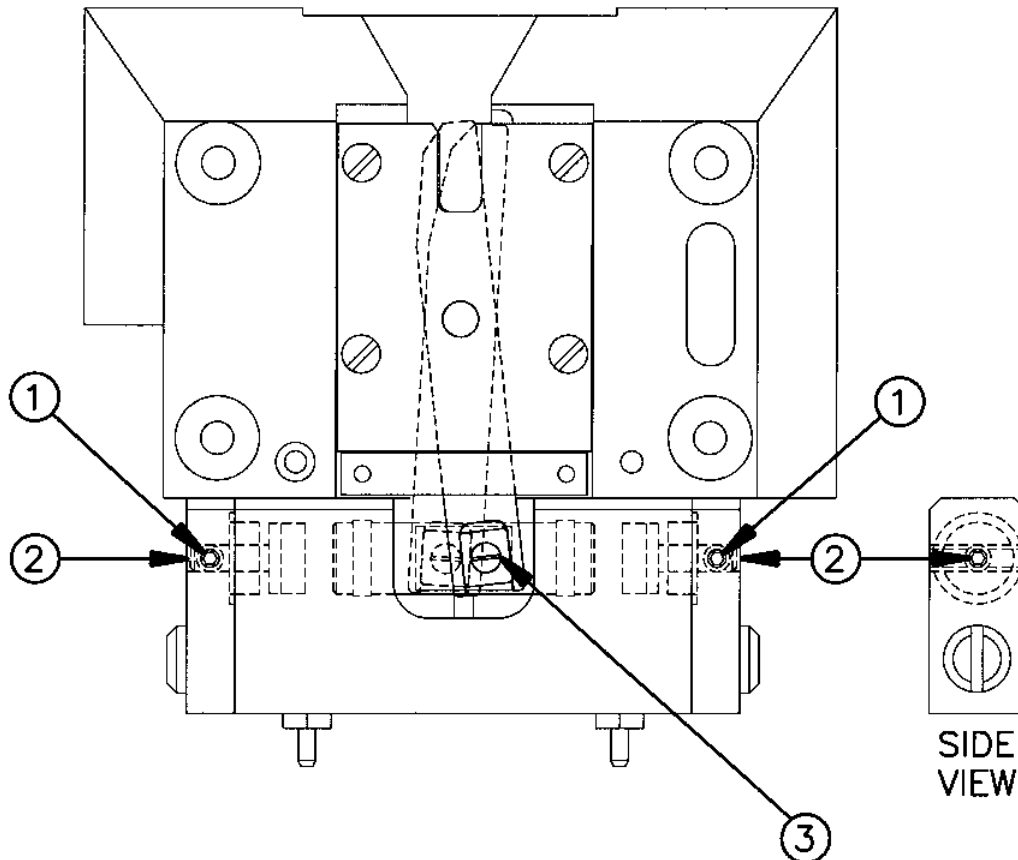


INS-2579



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## KNIFE STROKE ADJUSTMENT AJUSTE DE LA TRAYECTORIA DE LA CUCHILLA



1. LOOSEN SET SCREWS ① .
2. ADJUST THE PISTON STOP CUSHIONS ② TO LIMIT BLADE TRAVEL IN BOTH DIRECTIONS. AFTER COMPLETING ADJUSTMENT, SECURE THE PISTON STOP CUSHIONS BY TIGHTENING SCREWS ① .
3. NOTE: EXCESSIVE TRAVEL MAY CAUSE MOVABLE KNIFE BREAKAGE AT FORK END ③ .

1. AFLOJAR TORNILLOS ① .
2. AJUSTE EL TOPE AMORTIGUADOR ② PARA LIMITAR LA TRAYECTORIA DE LA CUCHILLA EN AMBAS DIRECCIONES. DESPUES DE HABER COMPLETADO ESTE AJUSTE, ASEGURE EL TOPE AMORTIGUADOR DEL PISTON CON LOS TORNILLOS ① .
3. NOTA: MOVIMIENTO EXCESIVO DEL PISTON PUEDE CAUSAR QUE SE ROMPA LA CUCHILLA ③ .

**CUTTER ASSEMBLY**  
 MODEL 3115 FCA  
 80-0511-01 STANDARD  
 80-0511-05 CARBIDE

01-3066-41  
SCREW

02-1689-01  
EXHAUST TUBING

01-3066-51  
SCREW

33-3204-04  
SCREW S.H.C.S.

02-1649-01  
BLADE HOLD DOWN

10-1385-01  
PISTON STOP  
CUSHION

02-1640-01  
BODY-DRIVER

30-1133-01  
HOSE  
FITTING

33-2106-03  
SCREW S.S.S.

10-1385-01  
PISTON STOP  
CUSHION

30-2700-01  
O-RING

02-1642-01  
END CAP

01-3066-11  
SCREW

02-1657-01  
GUARD

02-1657-02  
GUARD-WIDE

01-3057-02  
SCREW

02-1647-01 (-01)  
BLADE  
STATIONARY

10-1469-01 (-05)  
BLADE-CARBIDE  
STATIONARY

02-1648-01 (-01)  
BLADE MOVABLE

10-1470-01 (-05)  
BLADE, CARBIDE  
MOVABLE

02-1673-01  
PIN

30-2750-01  
SPRING

02-1613-01  
BUSHING

02-1645-01  
MAIN BODY

01-8847-01  
LOGO DECAL

02-1650-01  
STUD

30-1385-01  
RUBBER MOUNTS

01-6003-035  
SCREW

01-1819-61  
BUSHING

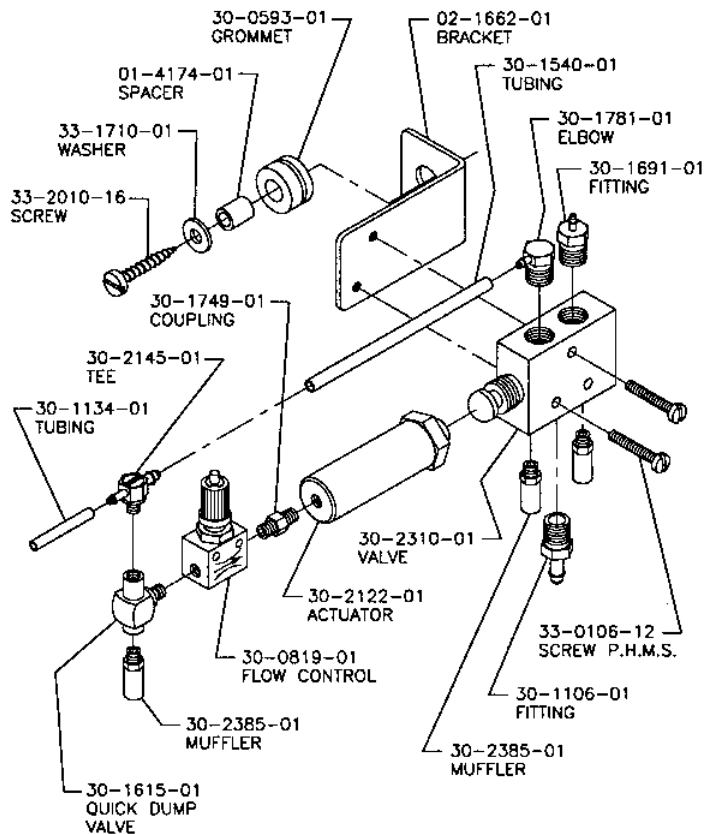
02-1644-01  
SLIDE

30-1280-01  
O-RING

02-1641-01  
PISTON

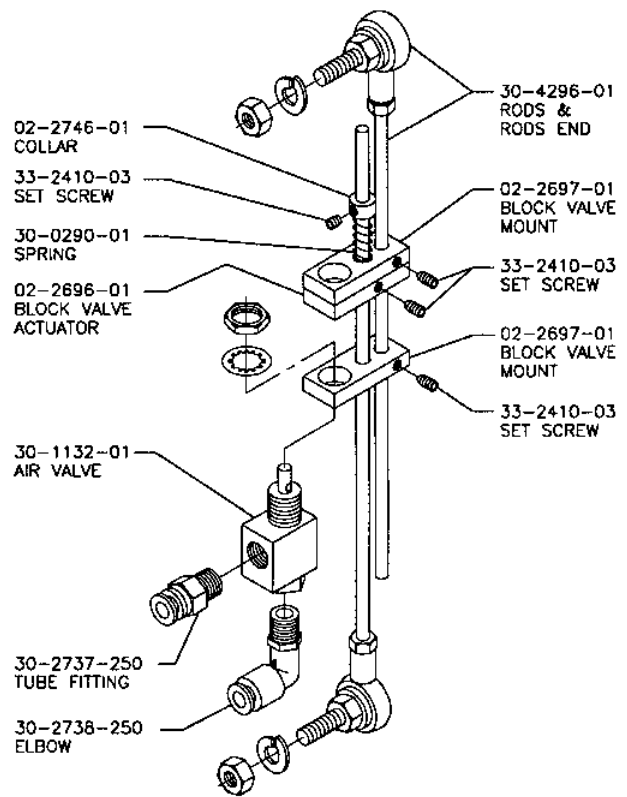
33-3308-06  
SCREW-S.F.H.C.S.

**SHUTTLE AIR VALVE ASSEMBLY**  
80-0512-01



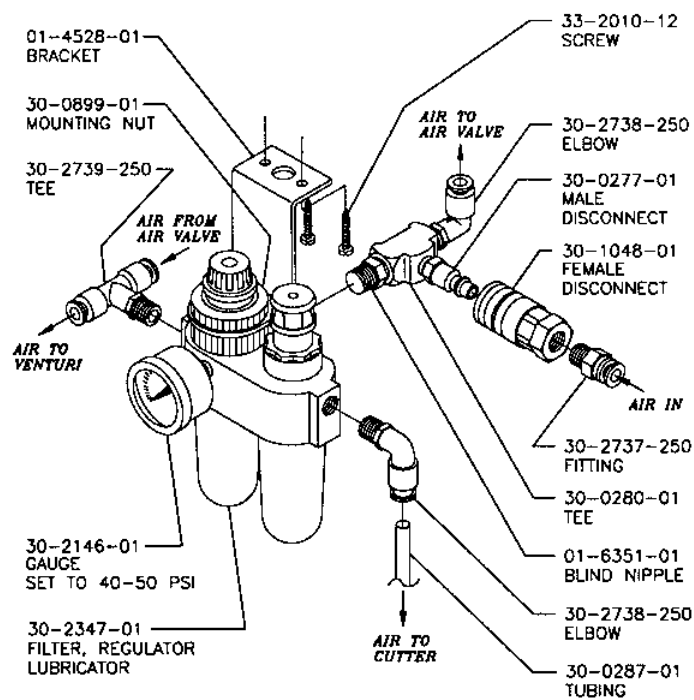
INS-2361A

**TREADLE AIR VALVE**  
TOE ACTION  
80-0524-01



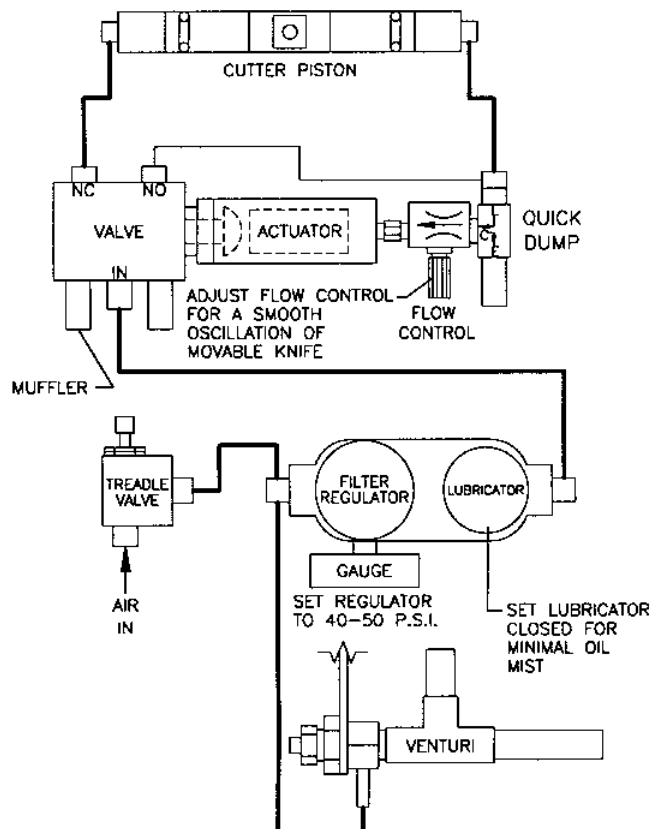
INS-2402B

**FILTER, OILER, REGULATOR, GAUGE ASSY**  
80-0415-04



INS-570-15C

**AIR CIRCUIT DIAGRAM**  
MODEL 3115FCA



INS-2359B



