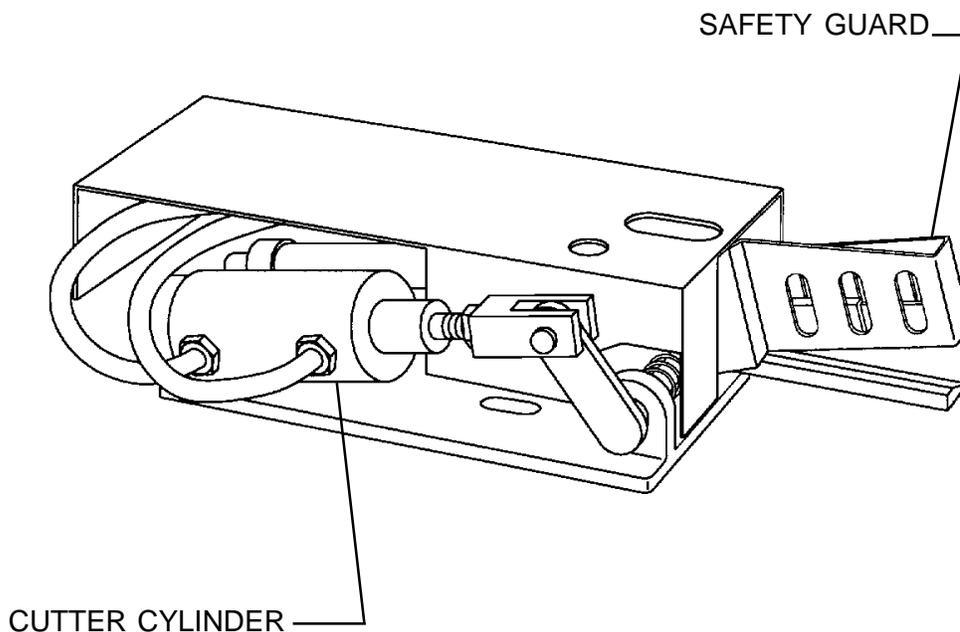


CLINTON

SHEAR CHAIN CUTTER

MODEL 405NSA-SG-HS, KS



SERVICE

MANUAL

40-0251-01



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I. GENERAL DESCRIPTION

The model 405NSA-SG is a scissor-type pneumatic cutter equipped with a safety guard, designed for tape binding operations on T-shirts, briefs, childrens' wear, etc. It is equipped with a blade length of 1½" for a maximum cutting width of 1".

The cutter can be operated manually by a hand switch, knee switch or automatically with an electric eye. Two (2) types of automatic operations are available, one controls the cutter and the other combines the cutter with the on and off cycle of the machine.

II. INSTALLATION

A. 405NSA-SG

1. Remove cover from assembly.
2. Position the cutter on the sewing machine bed, spot the two cutter mounting holes and drill & tap 10-32.
3. Replace cover after mounting cutter assembly.
4. Mount the knee valve on the underside of the table for right knee operation and connect air hoses from knee valve to cutter cylinder.
5. For hand valve operation mount valve assembly on the machine.

B. 405NSA-SG-EE

Install cutter as described above. Refer to model 3700 (Retro-Reflective Electric Eye) Service Manual for cutter operation only.

C. 405NSA-SG-8000

Install the cutter as described above. Refer to model 8000 (Accu-Stop Processor) Service Manual to operate the cutter and automatically control the machine.

WARNING: DISCONNECT AIR SUPPLY BEFORE MAKING ANY ADJUSTMENT TO THE CUTTER.

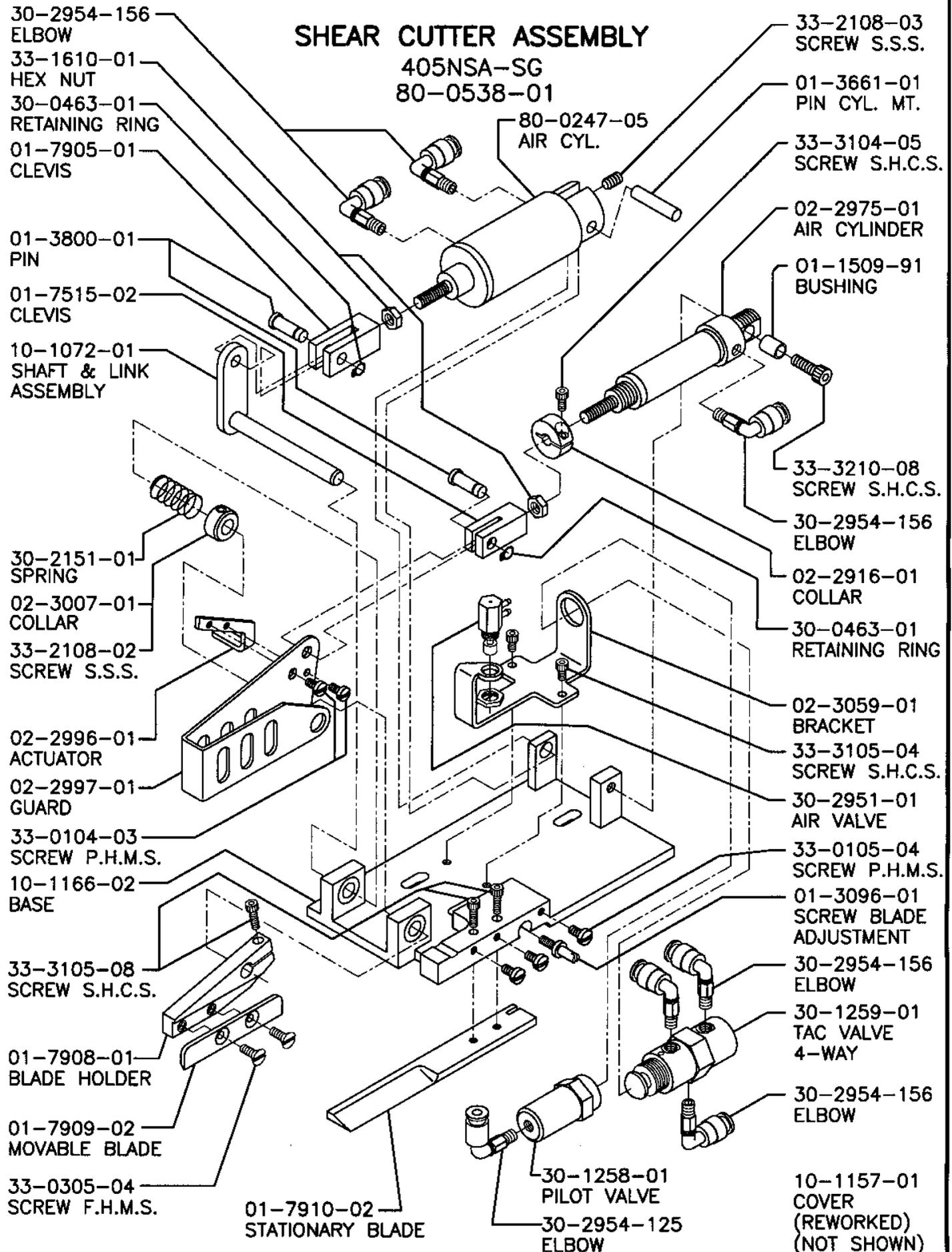
III. ADJUSTMENTS (Refer to ML405-15)

- A. To adjust the angle of the cutting blade, loosen the two 5-40 X 1/2 S.H.C.S. and turn screw 01-3096-01 to adjust the degree of the cutting blade angle.
- B. Loosen the 6-32 hex nut and the 6-32 X 3/8 S.S.S., adjusting the screw so that the moving blade barely misses the stationary blade at the beginning of its down stroke.
- C. To adjust the blade cutting pressure, loosen collar 30-0148-01 moving either to the left or to the right to increase or decrease the cutting pressure.
- D. Set the air pressure at 50 P.S.I.
- E. Adjust guard actuator valve to activate when guard is at the lowest actuating position.
- F. Adjust guard parallel to the stationary blade when placed at its lowest actuating position.
- G. Adjust air valve flow to control the return of the knife cylinder.
- H. Adjust low pressure regulator so that the guard completes its travel with minimum amount of air pressure.

**NOTE: WARRANTY ON PARTS AND EQUIPMENT LIMITED TO USE OF GENUINE
 CLINTON PARTS ONLY**

SHEAR CUTTER ASSEMBLY

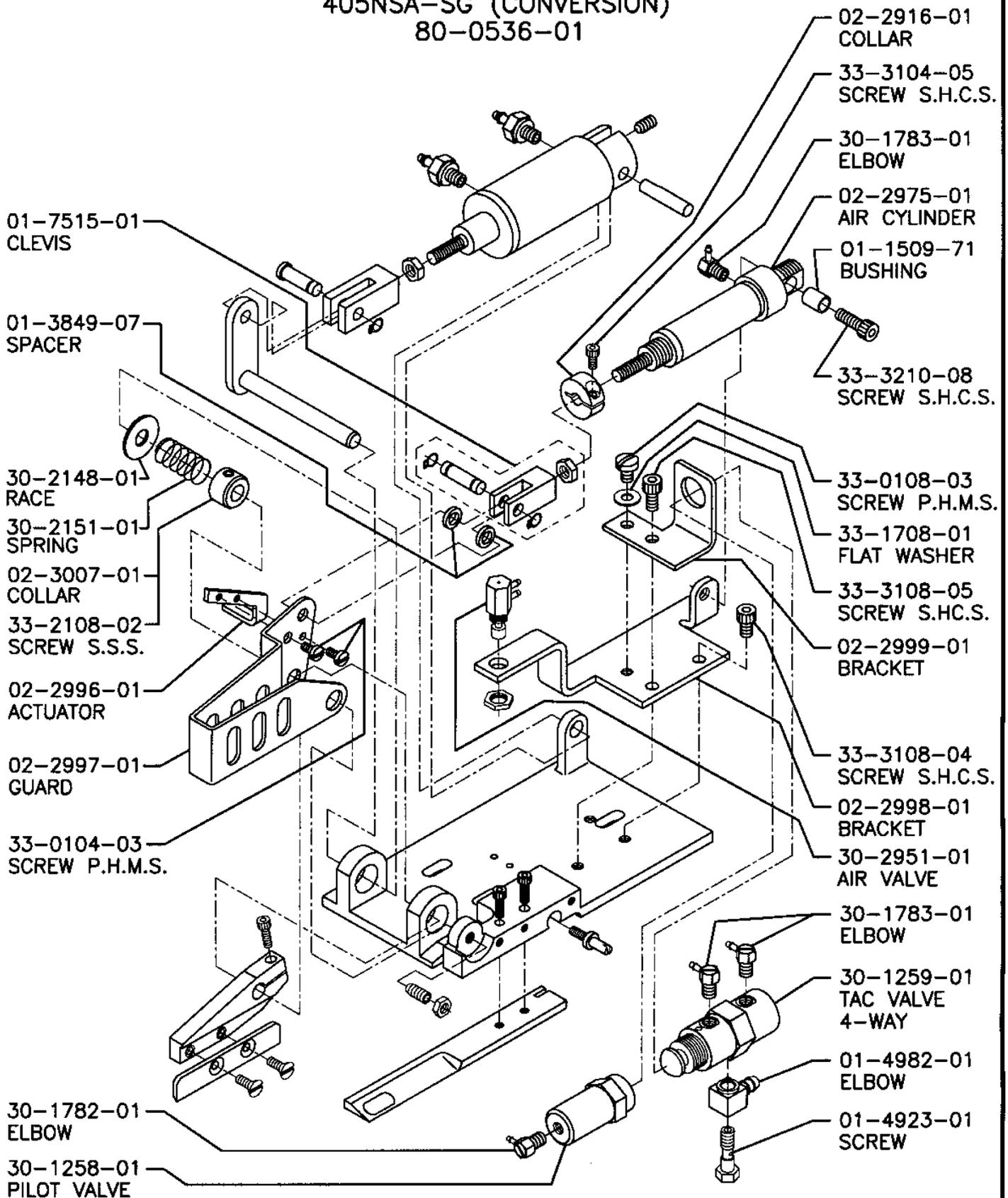
405NSA-SG
80-0538-01



SHEAR CUTTER ASSEMBLY

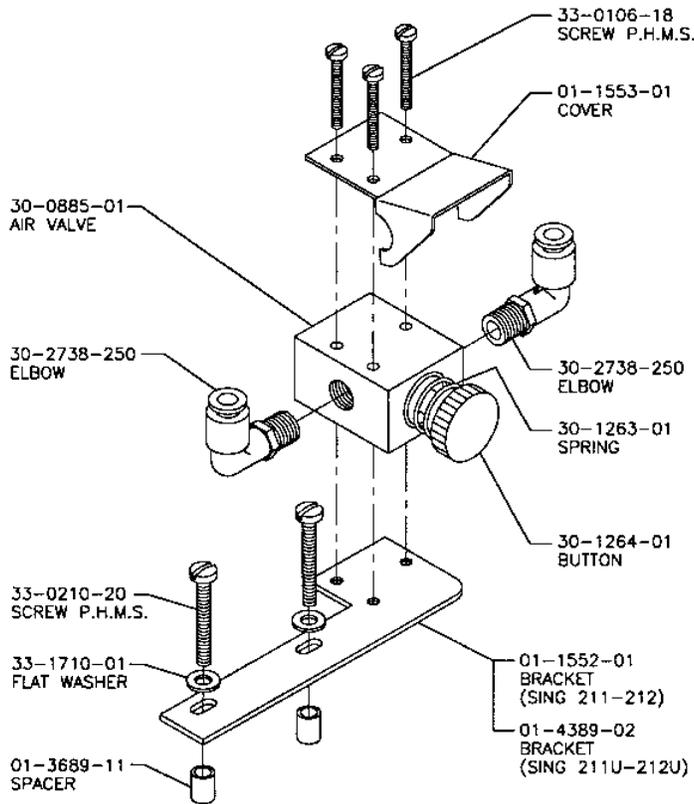
405NSA-SG (CONVERSION)

80-0536-01



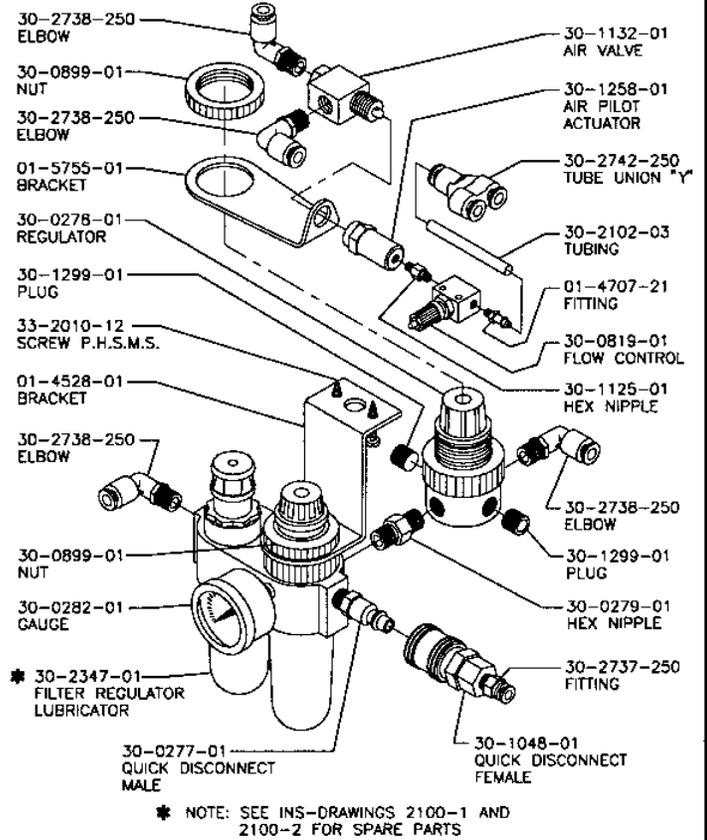
HAND SWITCH ASSEMBLY
MODEL 405NSA-SG-HS
80-0244-12

INS-2607A



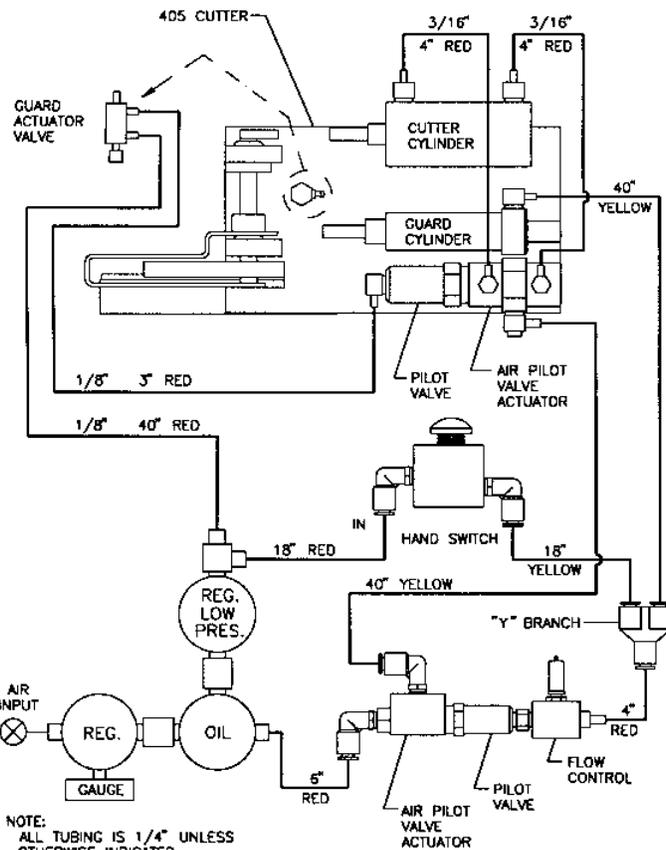
FILTER, OILER, REGULATOR, GAUGE ASSEMBLY
DUAL REGULATOR MODEL 405NSA-SG
80-0181-30

INS-2608A



AIR SAFETY CIRCUIT DIAGRAM
MODEL 405NSA-SG

INS-2609A



KNEE AIR VALVE ASSEMBLY
MODEL 405NSA-SG-KS
80-0187-15

INS-2610A

