

**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 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 | 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 | 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 |

Not Illustrated

| | | |
|--------|---------------------|---|
| 058680 | 5/6mm Ferrite | 3 |
| 058682 | 6.5mm Ferrite | 3 |
| 058684 | 13mm Hinged Ferrite | 1 |

10.1 JIG DRIVE/SNUBBER/JIG EJECT

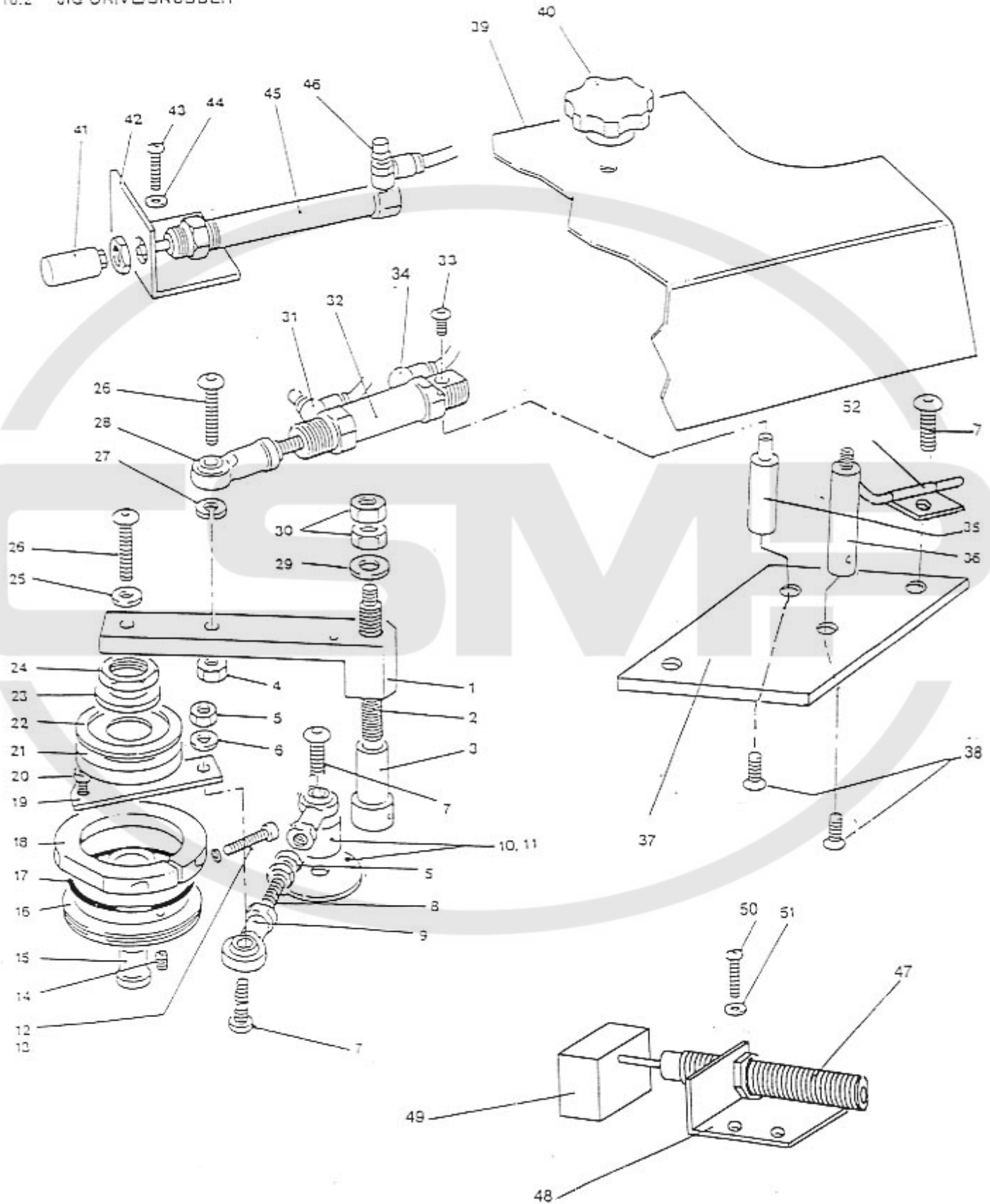
| ITEM | CODE No. | DESCRIPTION | QTY |
|-----------|----------|------------------------|-----|
| JIG DRIVE | | | |
| 1 | 048085 | Drive Arm | 1 |
| 2 | 046935 | Drive Cover Stud | 1 |
| 3 | 030511 | Mounting Arm Eccentric | 1 |
| 4 | 021088 | M6 Nut | 1 |
| 5 | 021087 | M5 Nut | 1 |
| 6 | 021098 | M5 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 |
|-----------------|----------|------------------------|-----|
| 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 |
| 52 | 057122 | Rear Blower | 1 |
| Not Illustrated | | | |
| 53 | 059140 | Jigh Drive Regulator | 1 |
| 54 | 060325 | 4mm In Line Restrictor | 1 |

10.2 JIG DRIVE/SNUBBER



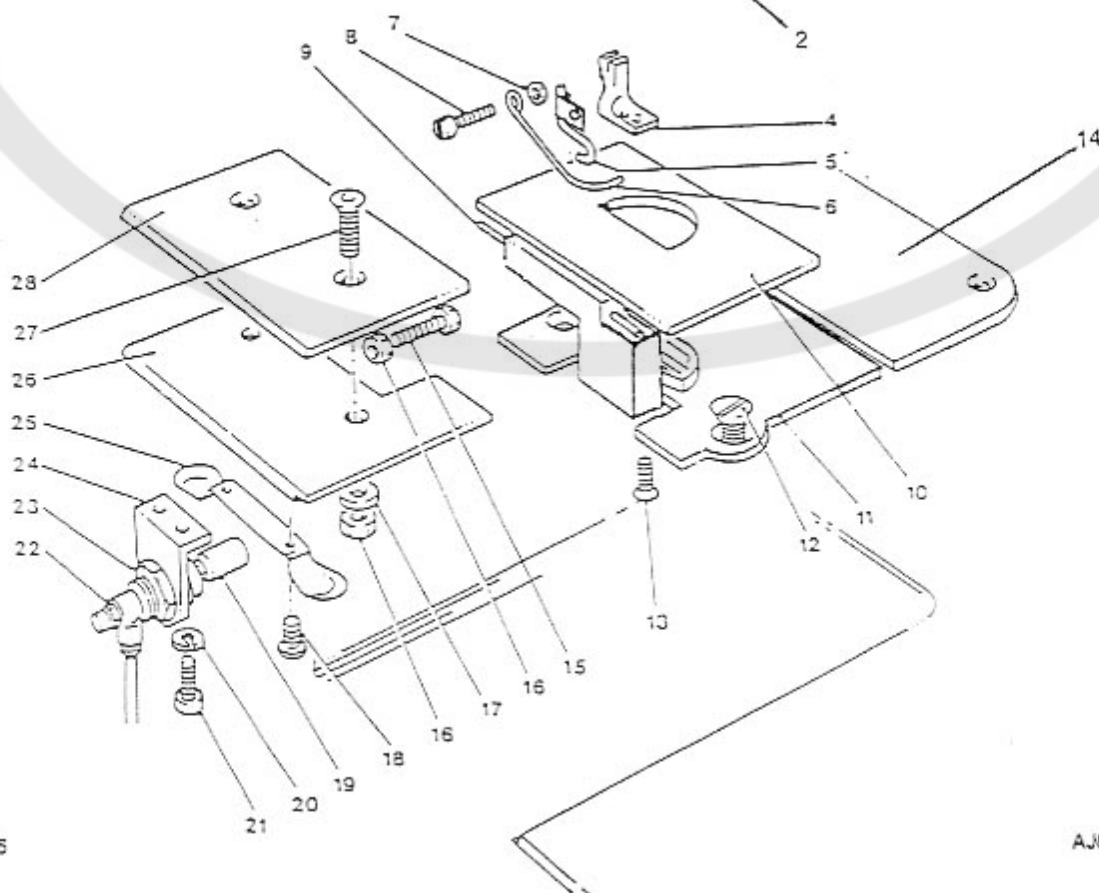
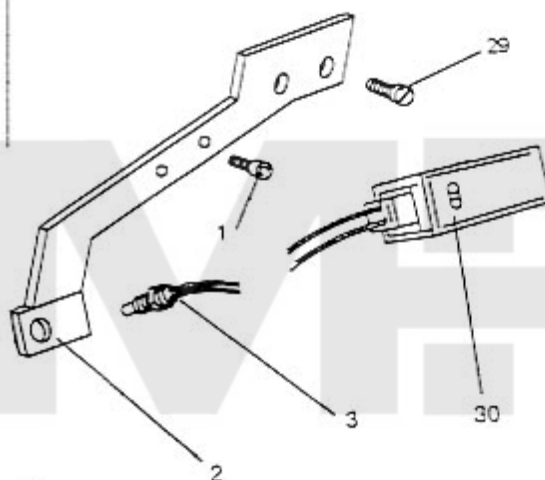
10.3 PRESSER FOOT/JIG FLAP/AMPLIFIER

| ITEM | CODE No. | DESCRIPTION | QTY |
|---------------------|----------|--------------------|-----|
| PRESSER FOOT | | | |
| 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 |
| S | 025560 | Presser Foot 1/4" | 1 |
| 5 | 057120 | Foot Blower | 1 |
| 6 | 021026 | Finger Guard | 1 |
| 7 | — | Plain Washer | 1 |
| 8 | — | Slot Hd Screw | 1 |
| S = Special | | | |

| | | | |
|-----------------|--------|---------------------------|---|
| JIG FLAP | | | |
| 9 | 040163 | Throat Plate Locating Pin | 1 |
| 10 | 059040 | Jig Flap Bracket | 1 |
| 11 | 057002 | Throat Plate, 3/16" | 1 |
| S | 057001 | Throat Plate, 1/8" | 1 |
| S | 057003 | Throat Plate, 1/4" | 1 |
| 12 | 057130 | Throat Plate Screw | 4 |
| 13 | 020798 | M3x6 Csk Screw | 1 |
| 14 | 057005 | Throat Plate Rear | 1 |
| 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 | 046540 | Nylon Nose | 1 |
| 20 | 021025 | M3 Spring Washer | 2 |

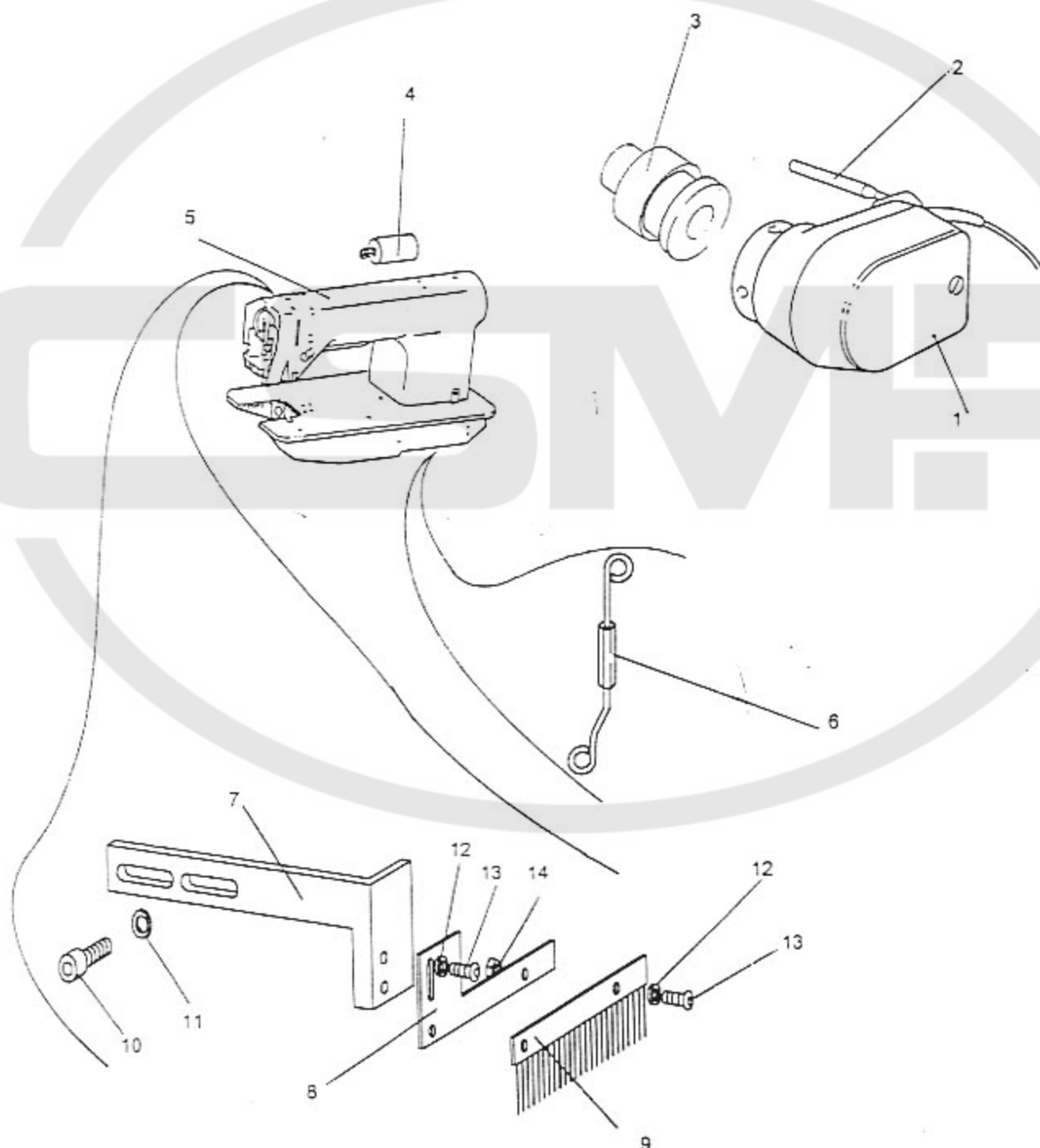
| ITEM | CODE No. | DESCRIPTION | QTY |
|-------------|----------|---------------------------|-----|
| 21 | 020841 | M3x8 Cap Hd Screw | 2 |
| 22 | 032045 | Flow Control | 1 |
| 23 | 046745 | Jig Flap Cylinder | 1 |
| 24 | 046755 | Jig Flap Cylinder Bracket | 1 |
| 25 | 046750 | Jig Flap Spring | 1 |
| 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 |
| Not Illustrated | | | |
| 31 | 060325 | 4mm In Line Restrictor | 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 | — | 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 | 059166 | Adjustable Holder Bkt. | 1 |
| 10 | — | Slide Clamp Screw | 1 |

