

**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

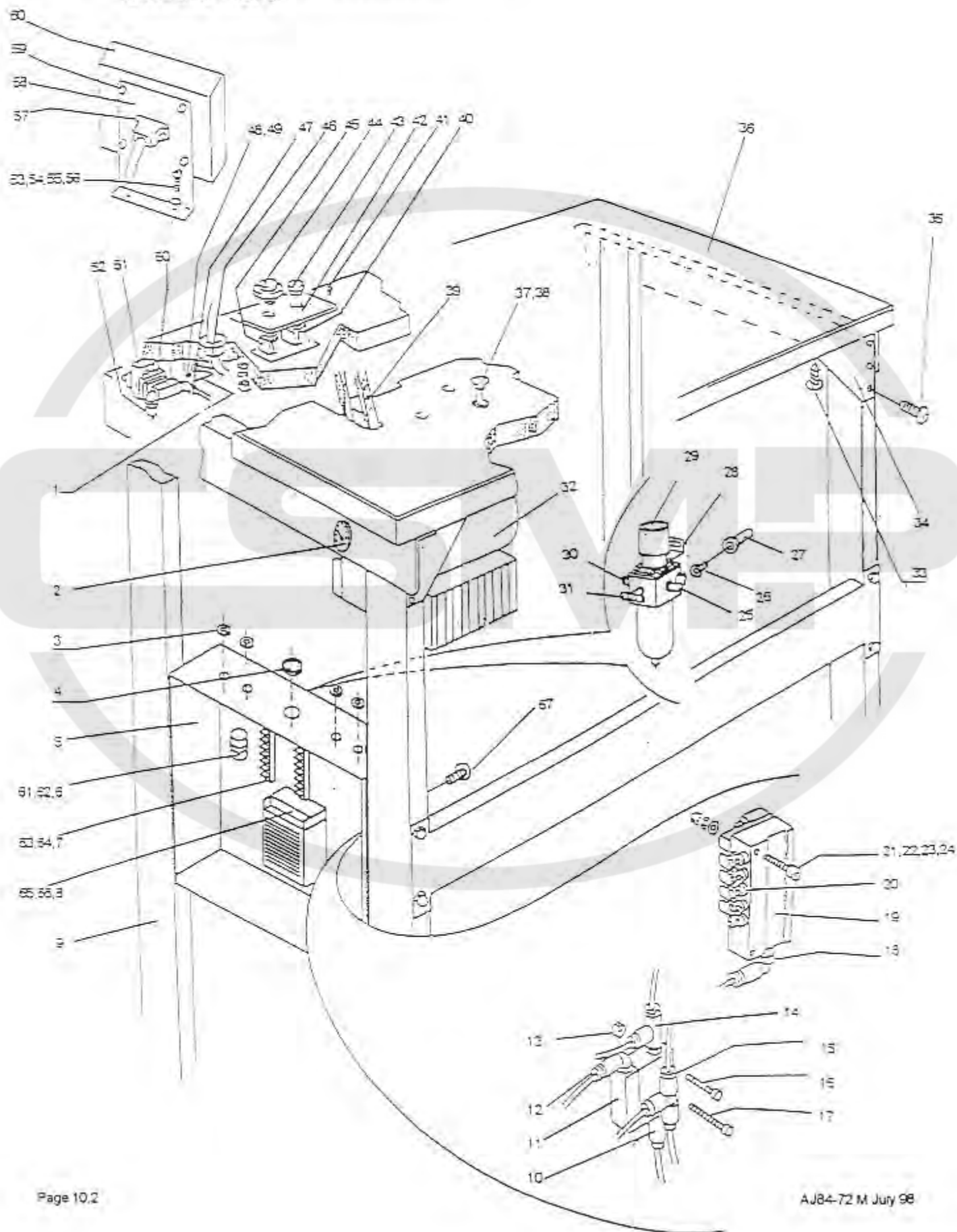
Customer should furnish the catalogue part
number, the serial number of the machine, and
information as requested in notes on pages
illustrating the parts.

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 & PNEUMATIC COMPONENTS/
TABLE AND FRAME



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	5
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	048940	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	M8 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
<i>Not Illustrated</i>			
	058680	5/6mm Ferrite	3
	058682	6.5mm Ferrite	3
	058684	13mm Hinged Ferrite	1

10.1 JIG DRIVE/SNUBBER/JIG EJECT

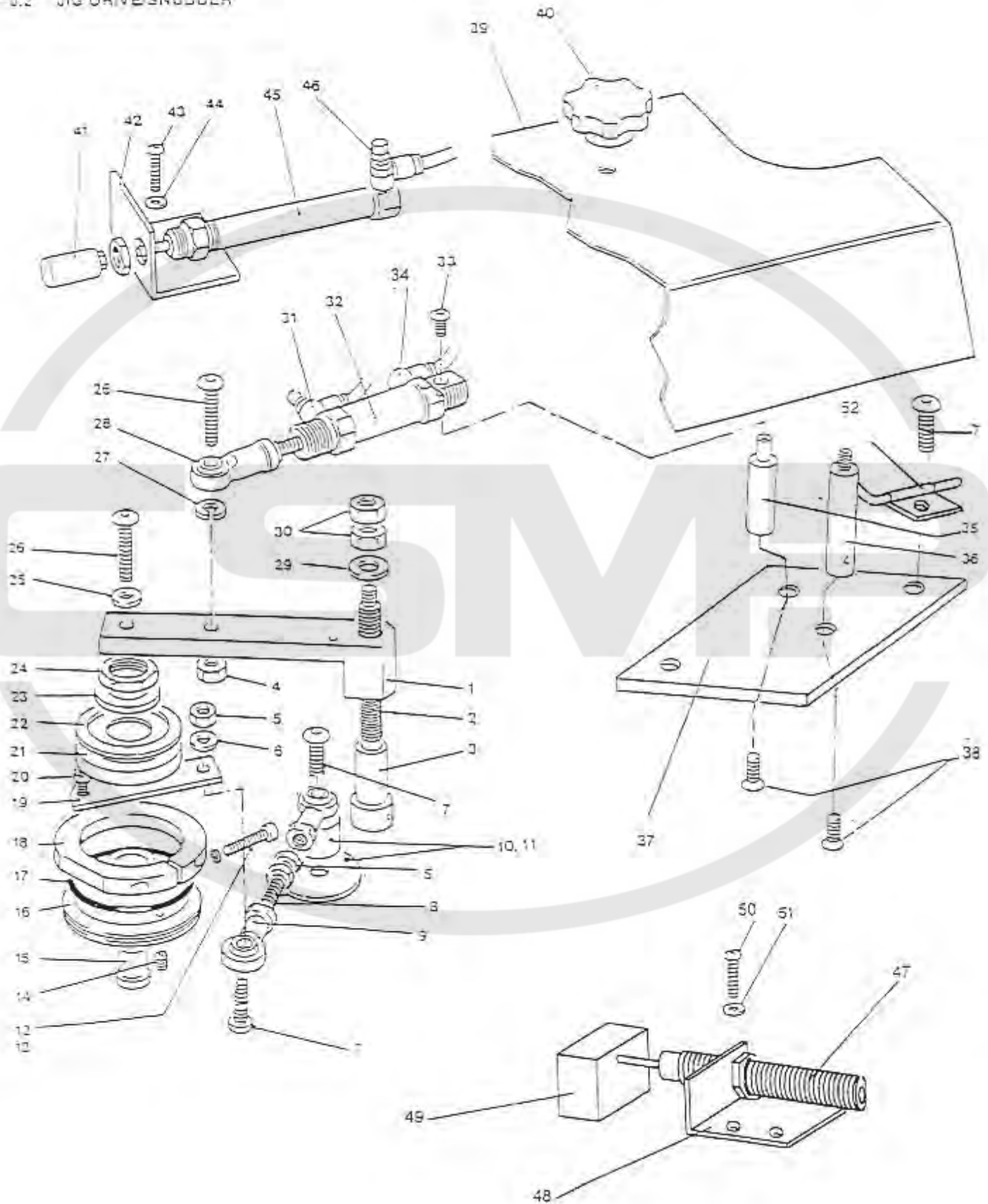
ITEM	CODE No.	DESCRIPTION	QTY
JIG DRIVE			
1	048085	Drive Arm	1
2	046935	Drive Cover Stud	1
3	030511	Mounting Arm Eccentric	1
4	021086	M6 Nut	1
5	021087	M5 Nut	1
6	021098	M5 Plain Washer	1
7	020984	M5x16 Butt Hd Screw	2
8	029060	Stud	1
9	028200	Rod End	2
10	046535	Oil Cover Tube	1
11	046530	Oil Cover	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	Nylon 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	030520	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	050325	4mm In Line Restrictor	1

10.2 JIG DRIVE/SNUBBER



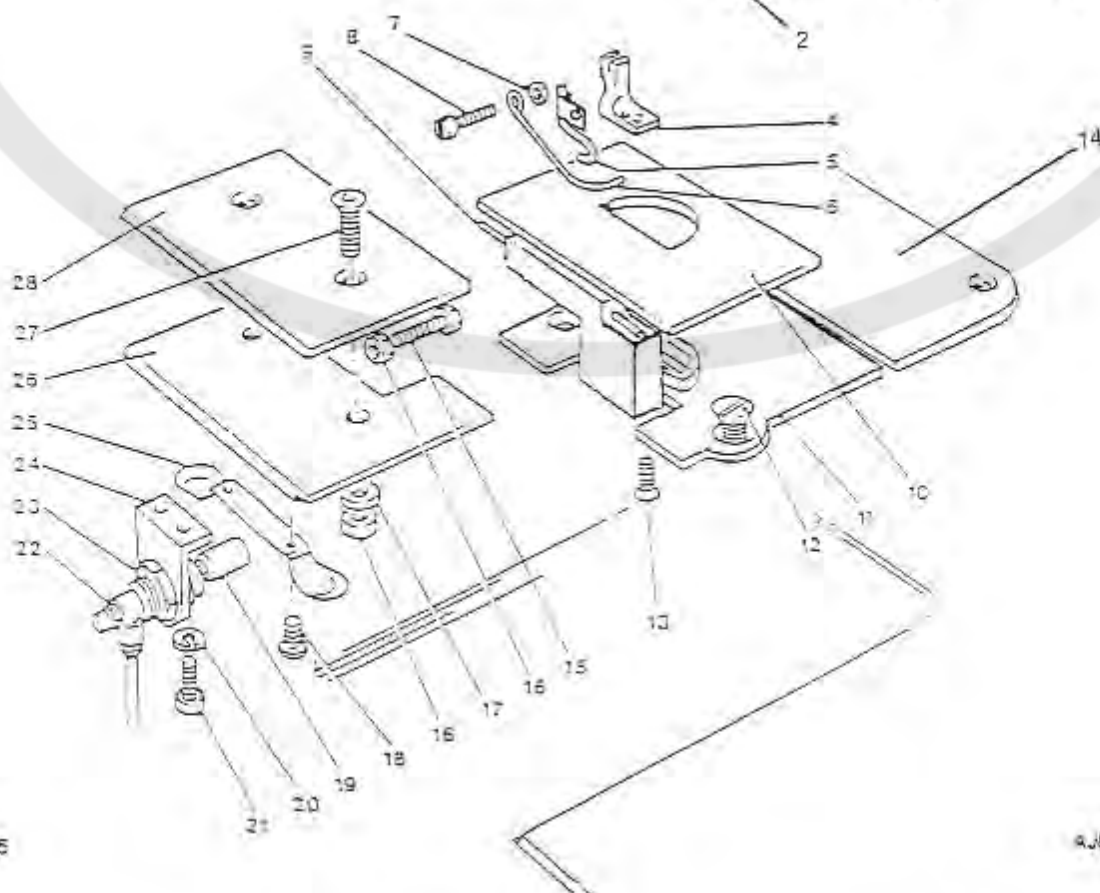
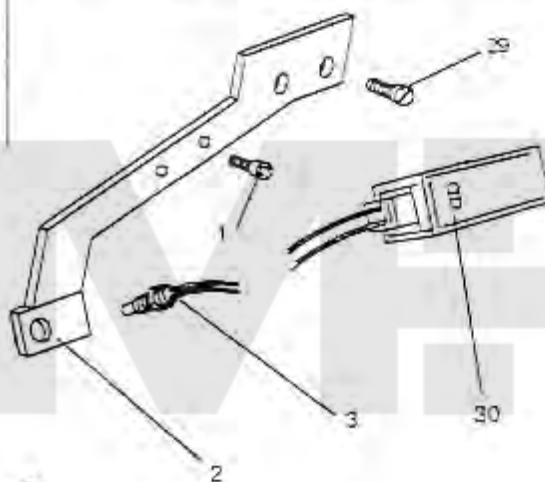
10.3 PRESSER FOOT/JIG FLAP/AMPLIFIER

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
6	025560	Presser Foot 1/4"	1
7	057120	Foot Blower	1
8	021026	Finger Guard	1
9	—	Plain Washer	1
10	—	Slot Hd Screw	1
<i>S = Special</i>			

JIG FLAP			
9	040163	Throat Plate Locating Pin	1
10	059040	Jig Flap Bracket	1
11	057002	Throat Plate, 3/16"	1
12	057001	Throat Plate, 1/8"	1
13	057003	Throat Plate, 1/4"	1
14	057130	Throat Plate Screw	4
15	020798	M3x6 Csk Screw	1
16	057005	Throat Plate Rear	1
17	M3x16	Hex Hd Screw	1
18	021085	M3 Nut	3
19	021091	M3 Plain Washer	2
20	046840	M2.5x5 Pan Hd Screw	2
21	046540	Nylon Nose	1
22	021025	M3 Spring Washer	2

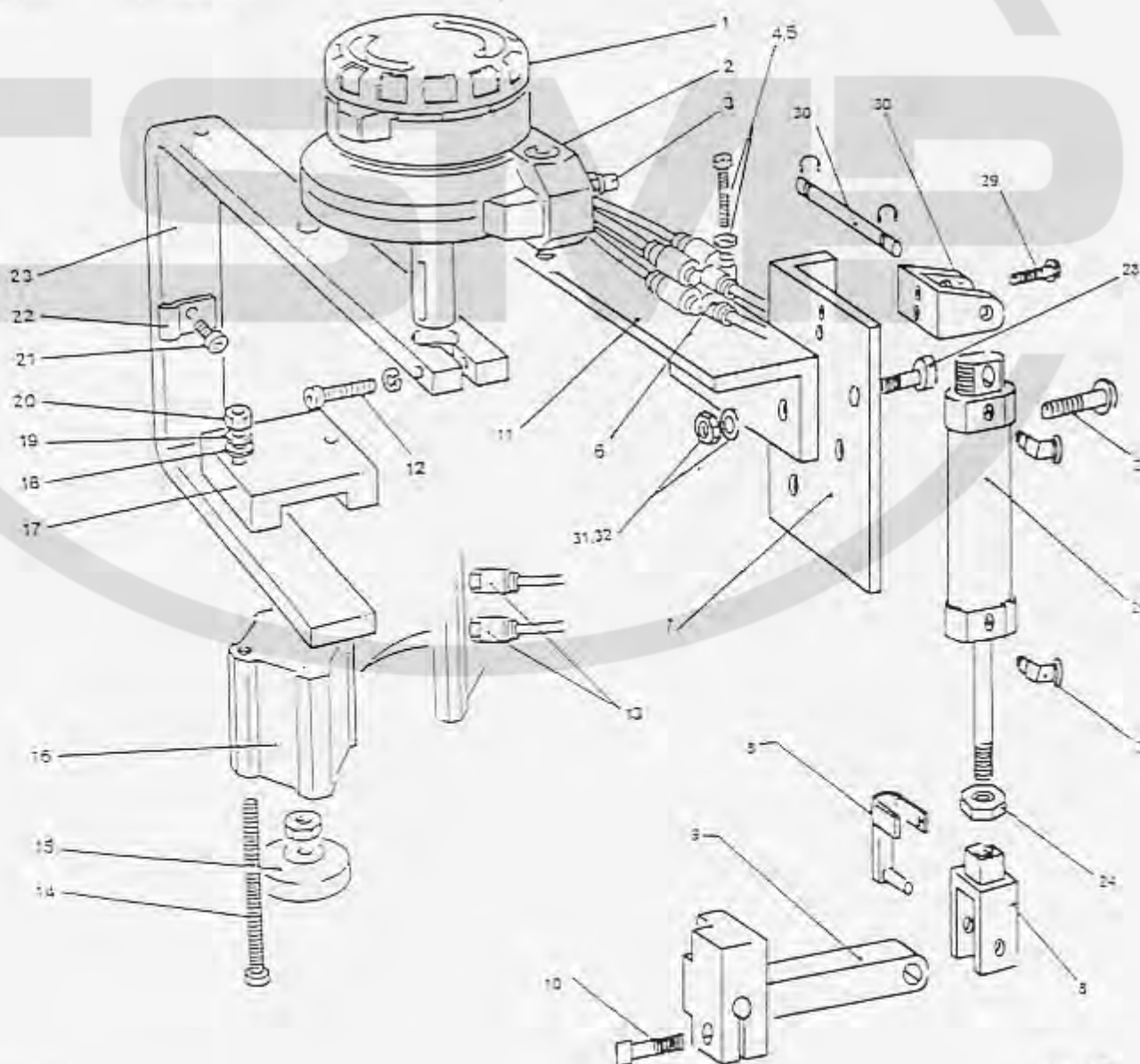
ITEM	CODE No.	DESCRIPTION	QTY
21	020841	M3x8 Cap Hd Screw	2
22	032045	Flow Control	1
23	046745	Jig Flap Cylinder	1
24	046755	Jig Flap Cylinder Bracket	1
25	046750	Jig Flap Spring	1
26	057010	Jig Eject Slide Plate	1
27	020799	M3x10 Csk Screw	2
28	059050	Jig Flap Cover Plate	1
<i>S = Special</i>			

AMPLIFIER			
29	—	Screw	2
30	057062	Amplifier Unit	1
<i>Not Illustrated</i>			
31	060325	4mm In Line Restrictor	2



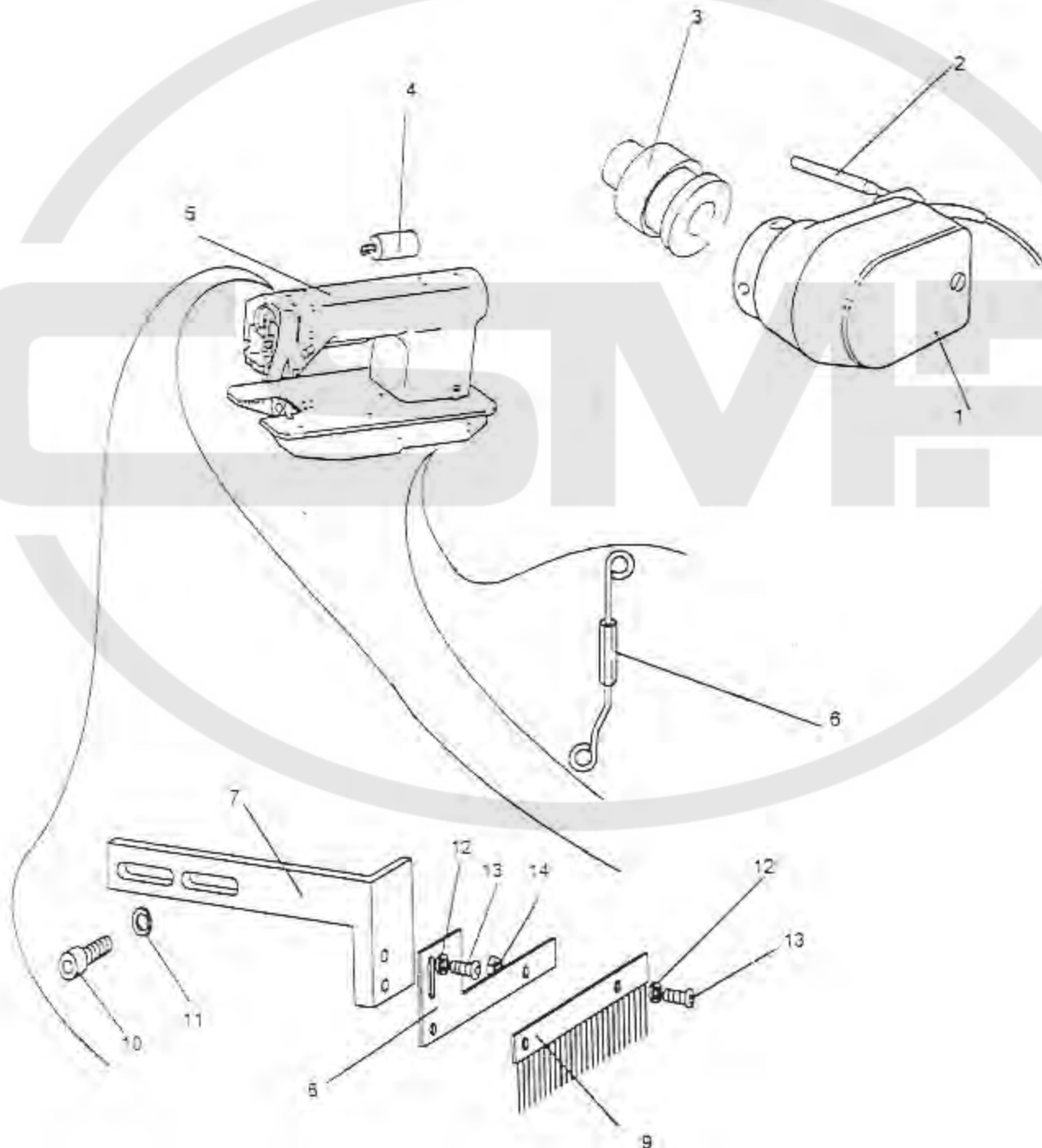
10.4 TURN ARM

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	057015	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	M5x18 Cap Hd Screw	1	29	—	M6x12 Btt Hd Screw	2
11	059012	Outrigger 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	—	M5x55 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				



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

