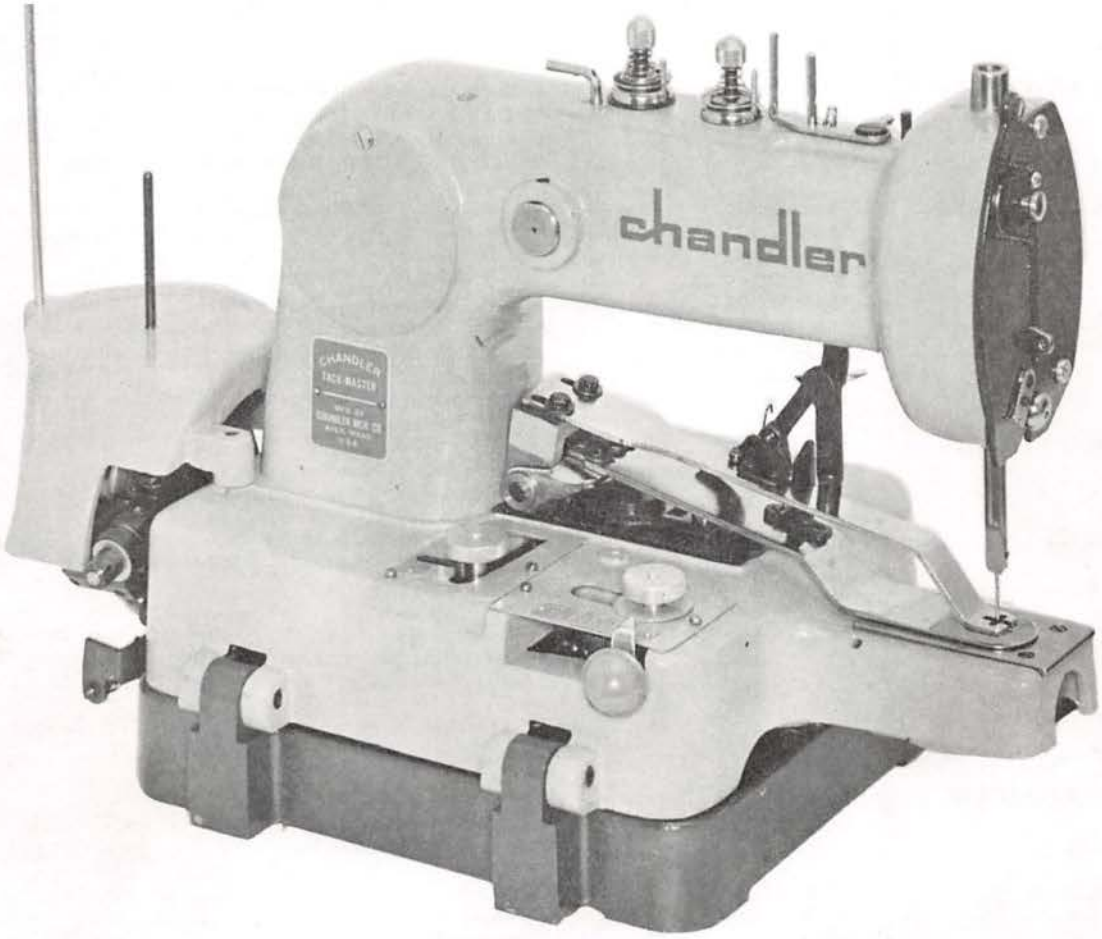
chandler®

INSTRUCTION BOOK & PARTS BOOK

TACKERS & BUTTON SEWERS



CLASSES: 543, 546, 548, 552, 554, 555, 558, 560, 600, 660, 710

chandler
CHANDLER MACHINE CO.
ayer, mass. 01432 u.s.a. tel. (617) 772-3393

chandler

CURRENT PRODUCTION MODELS OF CHANDLER CLASS 600 & 710 MACHINES

FLAT BUTTON SEWERS	Model 710-1	16 stitch, side vib., auto clamp lift.
	Model 710-5	12 stitch, side vib., auto clamp lift.
	Model 710-10	24 stitch, side vib.,
	Model 710-35	16 stitch, back & forth, auto clamp lift.
	Model 710-55	16 stitch, cross (X) stitch, auto clamp lift.
	Model 710-85	12 stitch, back & forth, auto clamp lift.
	Model 710-120	24 stitch, square pattern, auto clamp lift.
HOOK AND EYE	Model 710-1HE	16 stitch, side vib., auto clamp lift.
	Model 710-5HE	12 stitch, side vib., auto clamp lift.
WHIPPING	Model 710-12	24 stitch, for whipping suit buttons.
NECKING	Model 710-1N	16 stitch, side vib.
SHANK BUTTON SEWERS	Model 710-1S	16 stitch, side vib., side loading.
	Model 710-5S	12 stitch, side vib., side loading.
	Model 710-50	12 stitch, back & forth, front loading.
	Model 710-65	16 stitch, back & forth, front loading, shank master.
TACKERS	Model 600-15	6 stitch, back & forth
	Model 600-25	8 stitch, back & forth
	Model 600-25S	8 stitch, side vib.
	Model 600-60	6 stitch, side vib.
	Model 600-75	12 stitch, combination vib., drapery.
	Model 600-75D	12 stitch, combination vib., drapery extra hea /y needle
	Model 600-75K	12 stitch, combination vib., drapery knife thread cutter
	Model 600-75KD	(both of above)
	Model 600-95	6 stitch, combination vib.
BONE RING	Model 600-BR	12 stitch, back & forth vib.
	Model 600-BR.500	12 stitch, back & forth vib. ½" stroke for extra large bone rings.
JOKERS	Model 600-	Special machines for attaching labels and other removable objects. Normally modified square patterns.
BAR TACK	Model 710-70BT	24 stitch zig-zag pattern.
HIGH LIFT	Model 658 or 758	Full ½ inch bigger stroke. Designed for extra large shank buttons. Bulky tacking problems, etc. Specify above machine desired. Change prefix from "600" to "658".
		NOTE: Any of the above machines may be equipped with a built in knife mechanism. Add suffix "K"
TWIN NEEDLE TACKER	Model 660-	8 stitch, back & forth. Please specify needle gauges from 1¼ - 2½ in ¼" increments. Non adjustable.
STAND	Model 2Tc-600-1	Board only
	Stand, complete	Complete "H" legs. 110V.
	Stand	Complete "K" legs. 110V.
	Stand	Complete "K" legs. 220V.
CLAMPS	Flat button	
	Shank button	Side loading
	Shank button	Front loading (shank master)
	Snap	Adjustable, round or square
	Snap	Non-adjustable, square.
	Hook and eye	
	Whipping	
	Necking	
	Tacking	
	Tacking	Compensating
	Bone ring	Compensating
	Flat button	Front part only

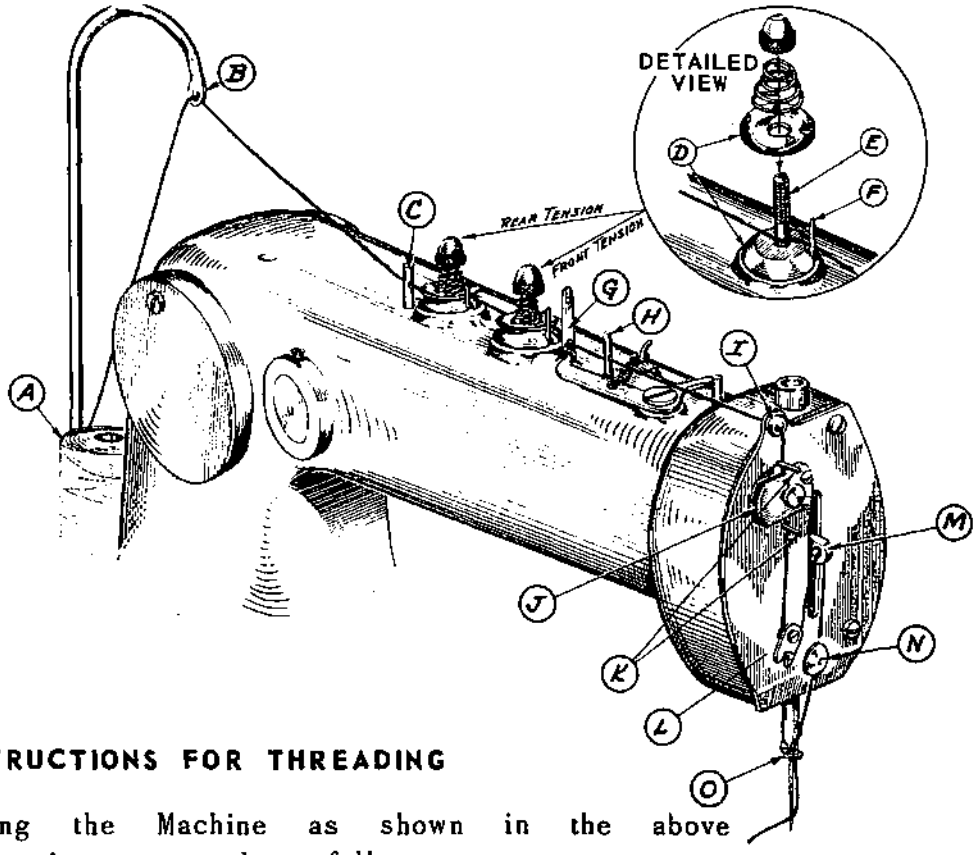
WORLD FAMOUS

This edition printed 10.1972

CHANDLER

NOTE: FOR BUTTONROBOTS, HOPPERS, AUTOMATIC FEEDING DEVICES CONTACT CHANDLER SALES & SERVICE CO., 245 7th AVE., N.Y., N.Y. 10001 TEL. 212-226-7300

THREADING DIAGRAM



INSTRUCTIONS FOR THREADING

Facing the Machine as shown in the above illustration, proceed as follows:

1 From Spool A, pass thread thru Spool Stand Arm B.

2 Then forward thru Rear Guide Pin C.

3 Slide thread between Rear Tension Disc D on the left hand side of Tension Post E, then to the right hand side of Pin F as above in detailed view.

4 Repeat step number 3 for Front Tension.

5 Pass thread forward thru hole in Thread Slack Pull-off Lever G, Front Guide Pin H and Thread Guide I in top of Face Plate.

6 Slide thread into slot J and down to the right of Pin K.

7 Pass down and around Roller in Lower Guide Plate L.

8 Insert thru Needle Bar Take-up M (left to right).

9 Thread under Tension Disc Face Plate N.

10 Catch thread in Needle Bar Thread Guide O and pass it thru the eye of the Needle from front to back. (For all models having Needle Bar Thread Guide)

CHANDLER

TIMING LOOPER TO NEEDLE BAR

The usual procedure for timing the Looper and Needle Bar, is first to time the Looper and then set the height of the Needle to the point of the Looper. This is accomplished as follows:

1 Insert new Needle full length of the Needle Bar hole and tighten Screw A (Fig.1)

2 As a preliminary setting, make sure the point of the Needle is approximately in line with the center of the Looper Shaft when the Needle Bar is at the lowest depth of its stroke.

Adjustment is made by means of Screw B (Figure 1).

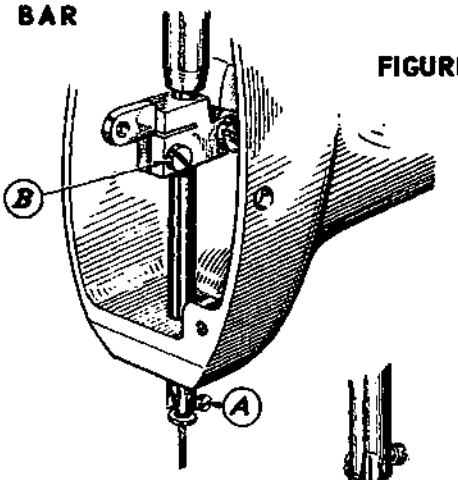


FIGURE 1

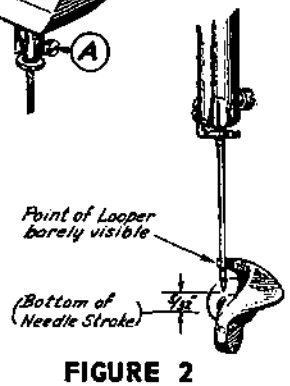


FIGURE 2

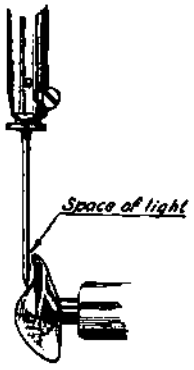


FIGURE 2A

3 Turn the machine by hand, rotating the Looper counterclockwise, thus raising the Needle 5/32 of an inch from the bottom of its stroke as shown in Figure 2.

At this time, the point of the Looper should be barely visible on the left side of the Needle as shown in Figure 2. To adjust, loosen Screws C (Figure 3) and rotate Knurled Looper Holder desired amount in either direction. Tighten Screws C securely.

4 There should be a space of light barely visible between the point of the Looper and the Needle as shown in Figure 2A. Adjust for proper clearance by loosening Screw D (Figure 3) and moving the Looper in or out the desired amount.

5 As a final setting, now that the Looper is properly timed in relation to the lift (or up stroke), the Needle Bar can be readjusted (as described in preceeding item 2) so that the point of the looper when passing the Needle is approximately 1/32 of an inch above the Needle Eye.

This final setting may have to be varied slightly depending upon the weight and softness of the thread or material being used.

The break of the loop (or loop formation) at the Needle Eye may vary according to the thread used. This will possibly require setting the point of the Looper closer or further from the eye of the Needle but within a range of approximately 1/32 of an inch.

TIMING THE FINGER

Lateral Setting - (Controlled by Barrel Cam I, Figure 3)

1 When the Finger has reached its most forward lateral position, the point of the Finger should extend approximately 1/32" beyond the front edge of the slot in the Throat Plate as shown below in Figure 3A.

To adjust, loosen Screw EA (Figure 3) and move Shaft F forward or backward the desired amount. (In moving Shaft F forward, make sure that Eccentric Finger G does not bind against shoulder of Eccentric J, otherwise Finger G will have to be moved back the same amount Shaft F is moved forward.)

Radial Setting - (Controlled by Eccentric J, Figure 3)

2 When the Needle is at the very bottom of its stroke there should be approximately 1/16" clearance between the Needle and the back edge of the Finger as shown in Figure 3B.

To adjust, loosen Clamp Screw GA (Figure 3) and move the Finger into correct position, and tighten Clamp Screw GA securely.

Turning the machine slowly in the direction of normal operation, observe carefully that at the instant the point of the Needle has cleared the Finger, the Finger must start its counterclockwise movement. The Finger should move backwards and sideways at the same time. Dotted line in Figure 3C shows approximate path of Finger point. Barrel Cam I must be adjusted to pull Finger sideways at the same time that Eccentric J moves Finger backward.

To adjust, loosen 3 Set Screws H (Figure 3) and retard or advance Finger Eccentric on Shaft the desired amount. Retighten Screws securely after making adjustment.

FIGURE 3

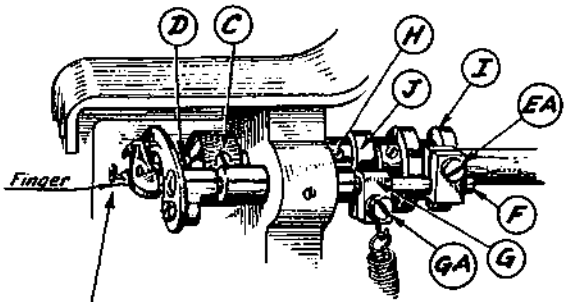


FIGURE 3A
Finger moving forward while Needle descending.

FIGURE 3B
Finger position from time Needle enters Throat Plate hole and returns.

FIGURE 3C
Dotted line shows path of Finger point. Finger starts moving backward and sideways as soon as Needle clears back of Finger.

THREAD LOCK TIMING ADJUSTMENT

When the Needle Bar has ascended to within 1/8 or 5/32 inch from the highest point of of the Needle Bar stroke on completion of the last stroke of the sewing cycle, the thread should be locked by the forward pressure of Plunger A against Plate B (Figure 1A).

The Thread should be locked when the machine stops, otherwise the thread will not break when the Clamp is lifted.

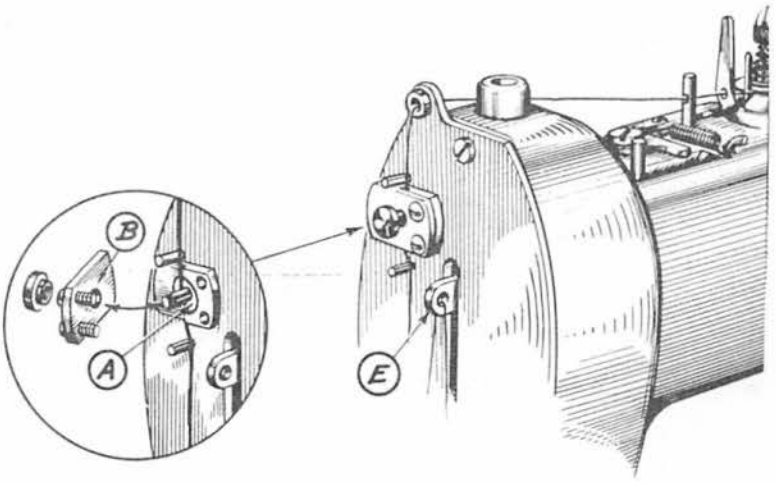


FIGURE 1A

FIGURE 1

Caution: Excessive pressure of the Plunger on light or weak thread will have a tendency to fracture the thread causing excessive thread breakage.

To adjust, loosen Lock Nut C (Figure 2) and turn Adjusting Screw D in or out the desired amount. Be sure to tighten Lock Nut C securely.

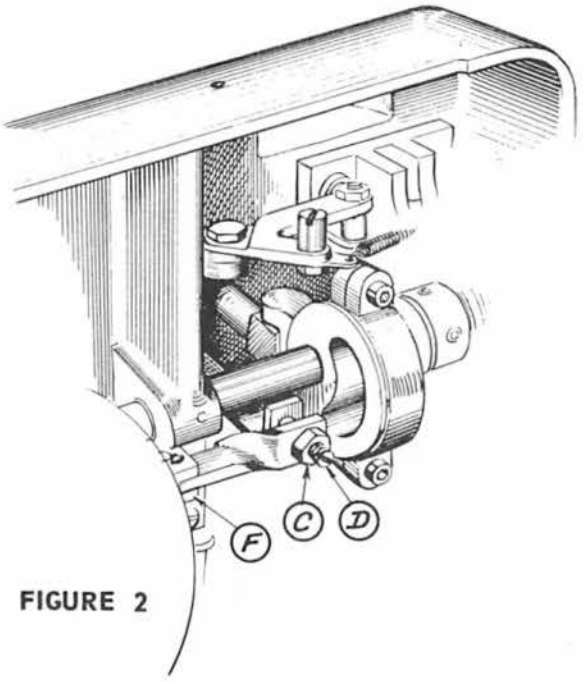


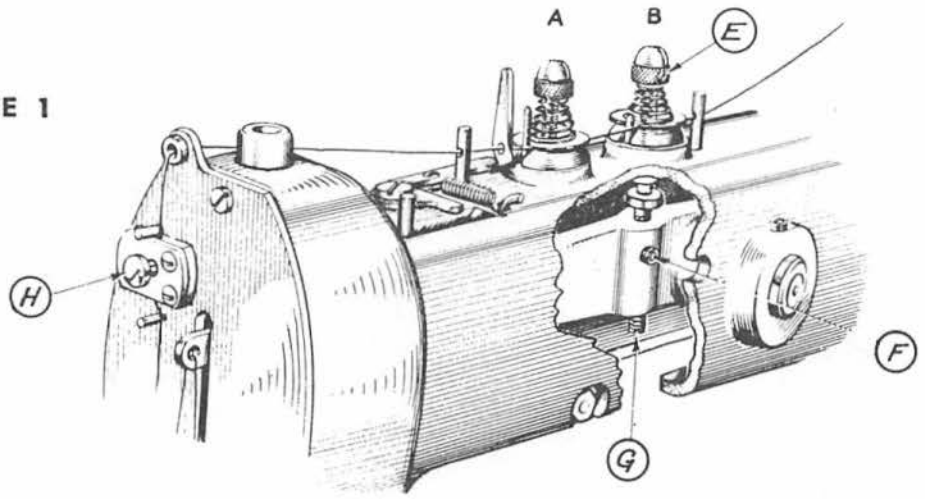
FIGURE 2

Note: Machines are usually equipped with light Lock Spring for use on light thread. For heavy threads use heavier Lock Spring (See Plate 1).

On resuming the first stroke of the new sewing cycle, the Thread Lock must release the thread some time before the Needle Bar reaches the lowest point of the stroke so that the thread is not held tight when the Take-up E (Figure 1) above starts its return upward stroke.

Bracket F (Figure 12) is provided with slots so that the Trip Lock Lever may be retarded or advanced for proper timing.

FIGURE 1



TIMING OF TOP INTERMITTENT TENSION

On the top of the machine there are two thread tension adjustments...Rear Tension B and Front Tension A (See Figure 1). Rear Tension B is an intermittent thread locking tension which locks the thread prior to the end of each stitch. This prevents the Looper from stealing thread from Spool instead of pulling up the loop at the end of each stitch. The amount of tension for locking the thread is factory set reasonably tight by means of Set Screw E (Figure 1) therefore, do not disturb or attempt to utilize Rear Tension B for adjusting the normal tension explained below. However, the time at which the thread is locked by Tension B may be adjusted as follows:

Loosen Set Screw F (Figure 1) and turn Adjusting Screw G up or down until Tension B locks the thread when the Needle Bar has ascended to within 5/32 of an inch from the top of the Needle Bar stroke on light thread but 1/8 of an inch or less on heavy thread.

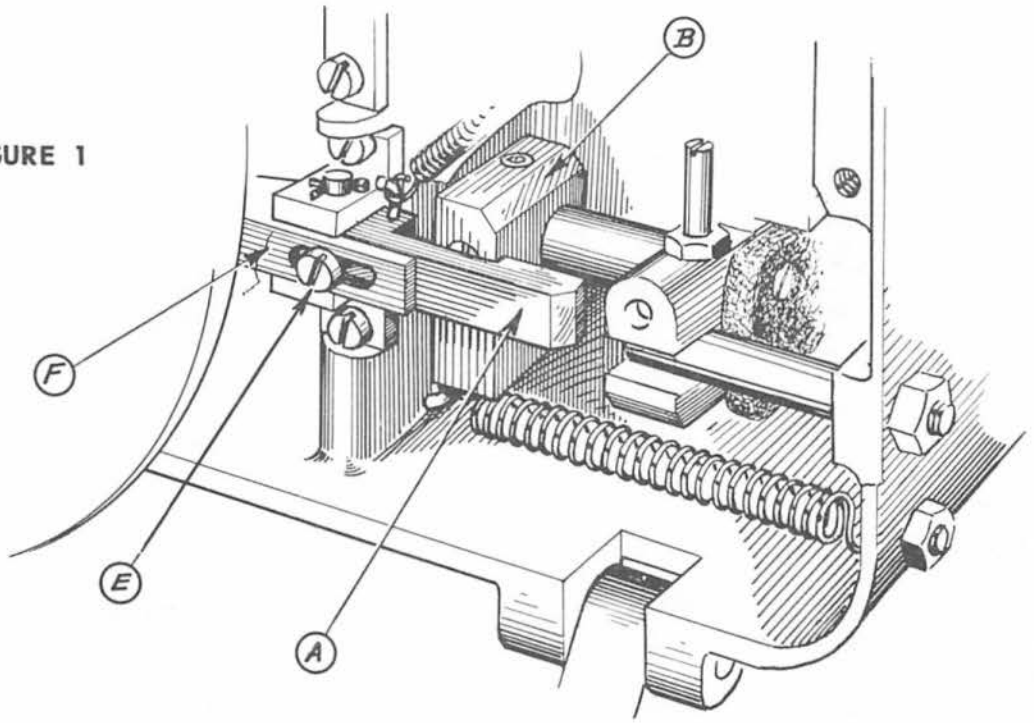
To prevent thread breakage or extremely light thread, the Intermittent Tension should release the thread when the Needle Bar is at least 5/32 of an inch from the top of its stroke.

ADJUSTMENT OF NORMAL THREAD TENSION

Tightness of the stitch is regulated by Front Tension A. If the Tension Adjustment is too tight the Looper will snap the thread, if too loose the knots on the under side of the button will be loose. Adjustment is made as follows:

Turn handwheel at the end of the Mainshaft until Rear Tension B is in "UP" position. Lower the Button Clamp so the Thread Lock H on the Face Plate is open (center plunger is released). Pull the thread at the Needle to be sure it pulls thru with slight tension. If tension is too tight or too loose, turn Tension A up or down until proper tension is achieved.

FIGURE 1



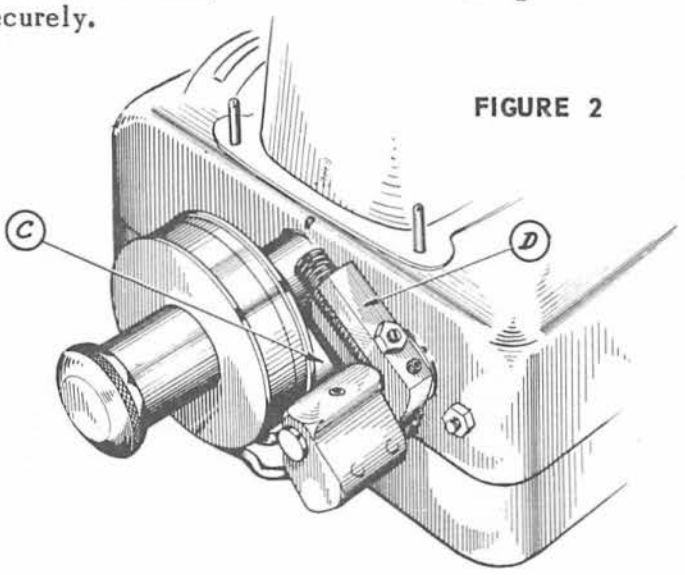
STOP KICK-OFF FINGER MECHANISM

On completion of the Button Sewing Cycle, Latch A should release Block B (Figure 1) just as Stop Finger C (Figure 2) has cleared Bumper Spring Holder D. The illustration shows an earlier model but the same instructions will apply to all models.

To advance moment of release, loosen Screw E (Figure 1) and move Kick-off Finger F to the left.

To retard moment of release, move Kick-off Finger F to the right. Tighten Screw E securely.

FIGURE 2



AUTOMATIC CLAMP LIFTER MECHANISM

Automatic Operation

To set the automatic clamp lifter mechanism in the automatic operating position (or single pedal control) insert stud A in the forward hole of connecting strap B as illustrated in Fig. 1. With stud A in this position, the amount of clamp lift is controlled by loosening check nut C and turning adjusting nut D in or out as required,

Adjustment of the amount of clamp lift may necessitate a compensating adjustment of the thread slack kick pin H Fig. 2 in order to maintain the proper amount of thread take-off.

The automatic lifter actuating bracket E Fig. 1, controls the timing of the lowering of the clamp in relation to the first needle bar stroke, and the rising of the clamp on the final needle bar stroke. For proper timing, loosen two screws F Fig. 1 and swing bracket E so that its drop-off point is approximately on the centerline of the roller G as shown in Fig. 1A.

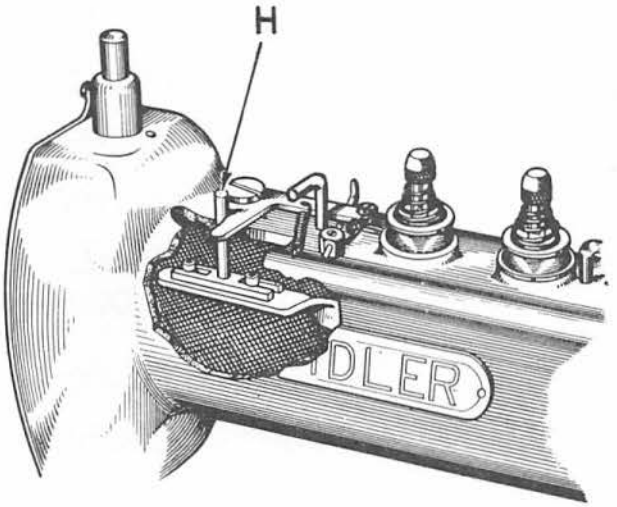


FIGURE 2

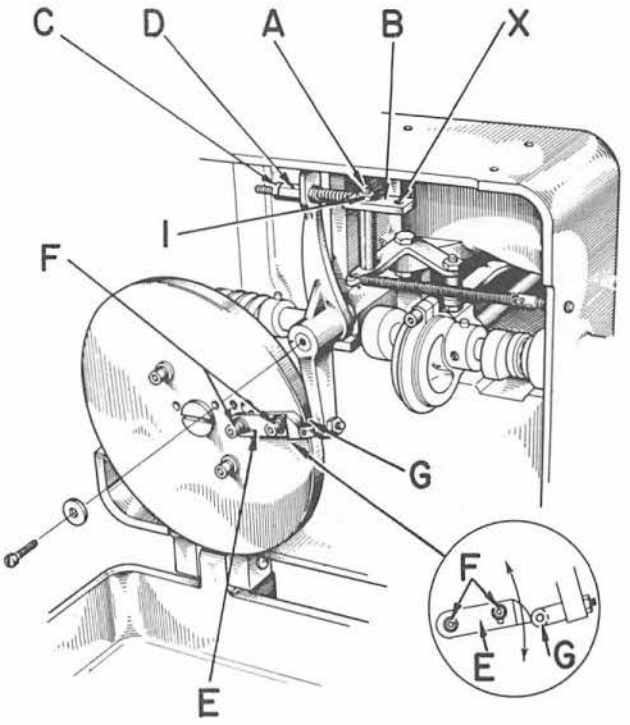


FIGURE 1 FIGURE 1A

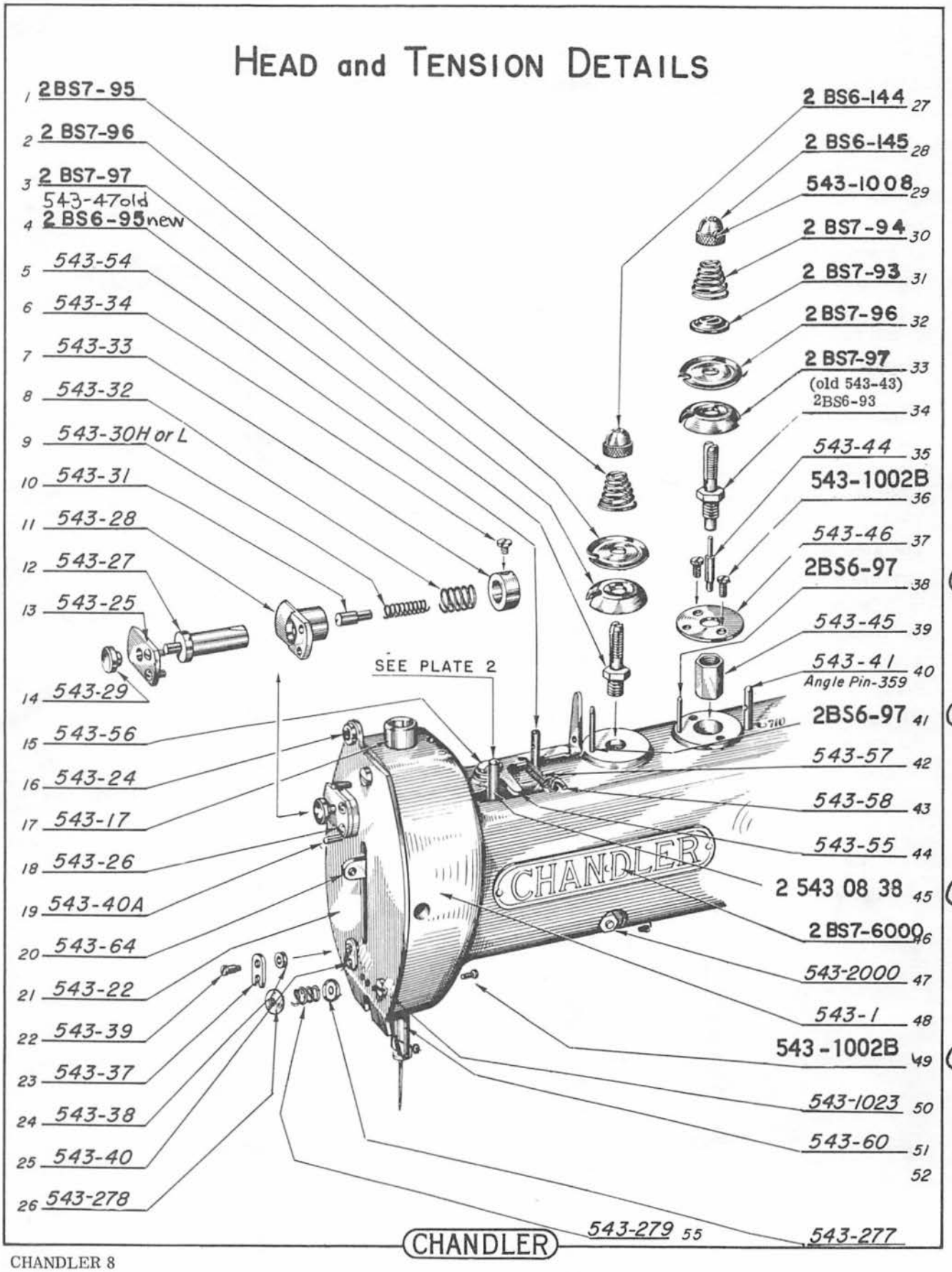
Manual Operation

To convert the machine from automatic to manual clamp lift (or two pedal control) remove nut I Fig. 1, lift connecting strap B and insert stud A in hole X. Replace nut I and tighten securely. The automatic function is now inoperative, since roller G no longer contacts bracket E.

Adjustment for the amount of clamp lift is now made by means of the adjusting screw in the lifting bracket 543-213 located in the base of the machine (See parts plate 9).

Either of the above adjustments may necessitate a compensating adjustment of the thread slack kick pin H Fig. 2 in order to maintain the proper amount of thread take-off.

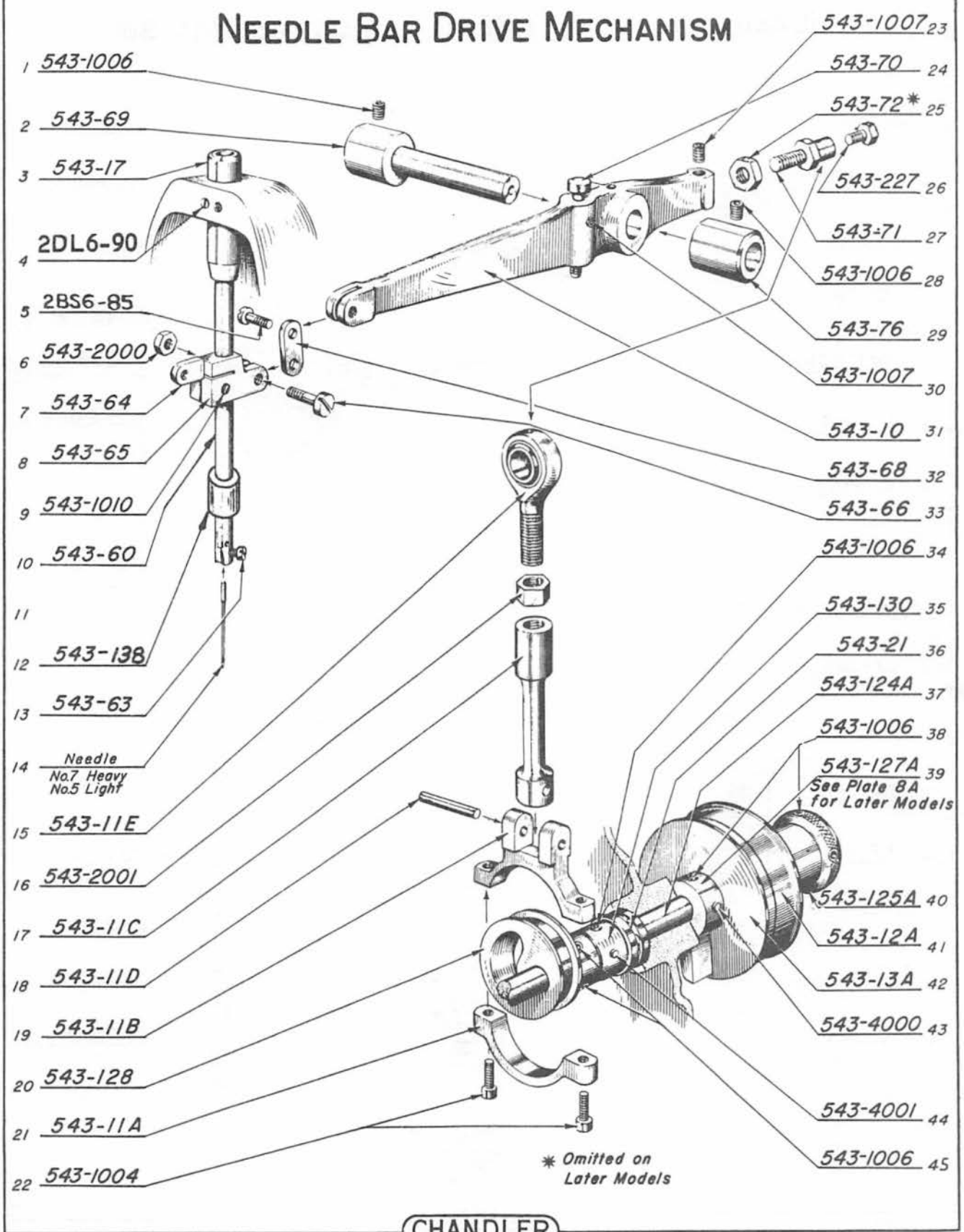
BASIC COMMON PARTS



CHANDLER 8

CHANGES: 08.1972
1. was 543-1002A
2. was 543-35
3. was 543-35
4. was 543-84
5. was 543-1002A

NEEDLE BAR DRIVE MECHANISM



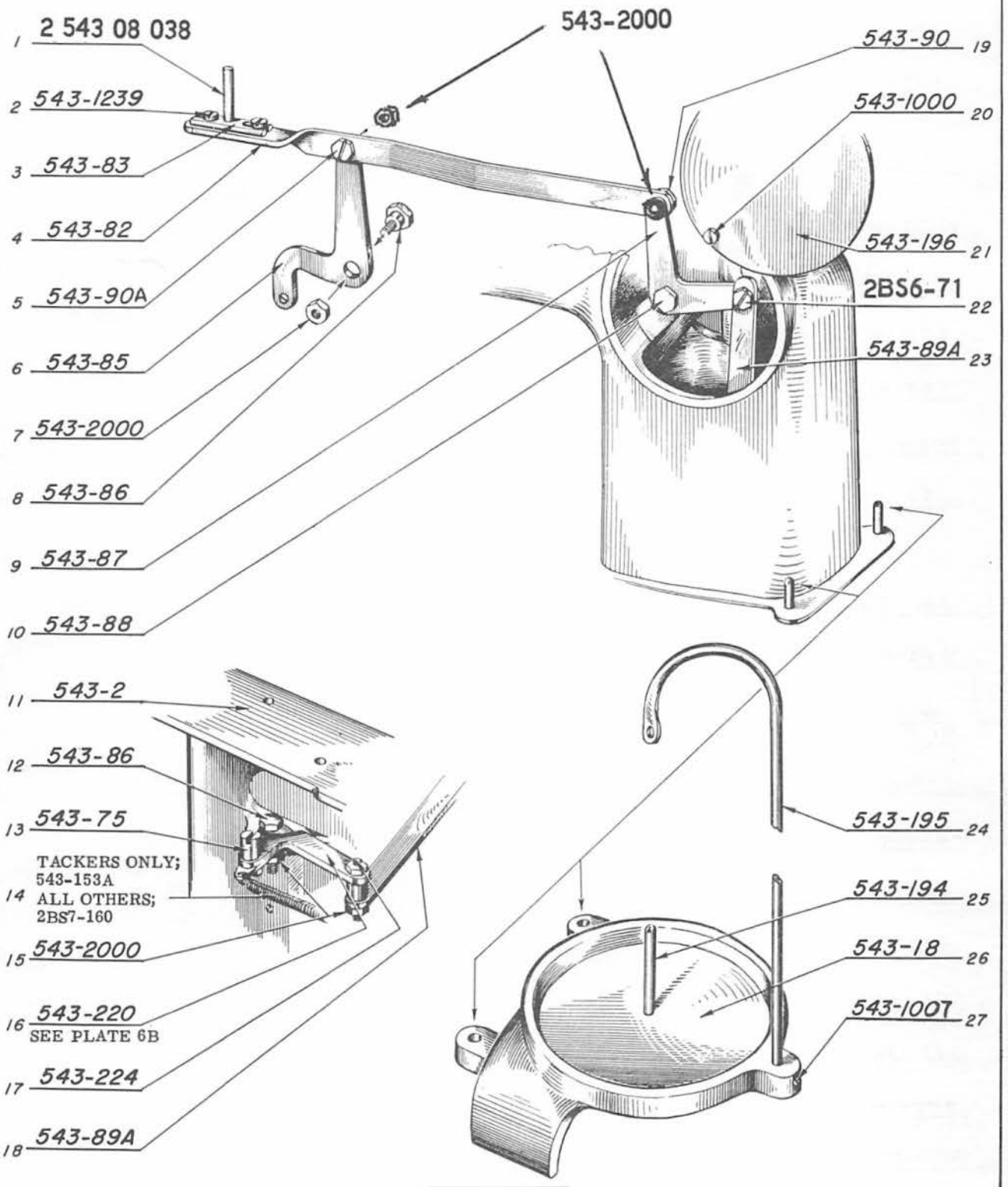
(1)

CHANDLER

CHANDLER 9

CHANGES: 08.1972
1. was 543-1003

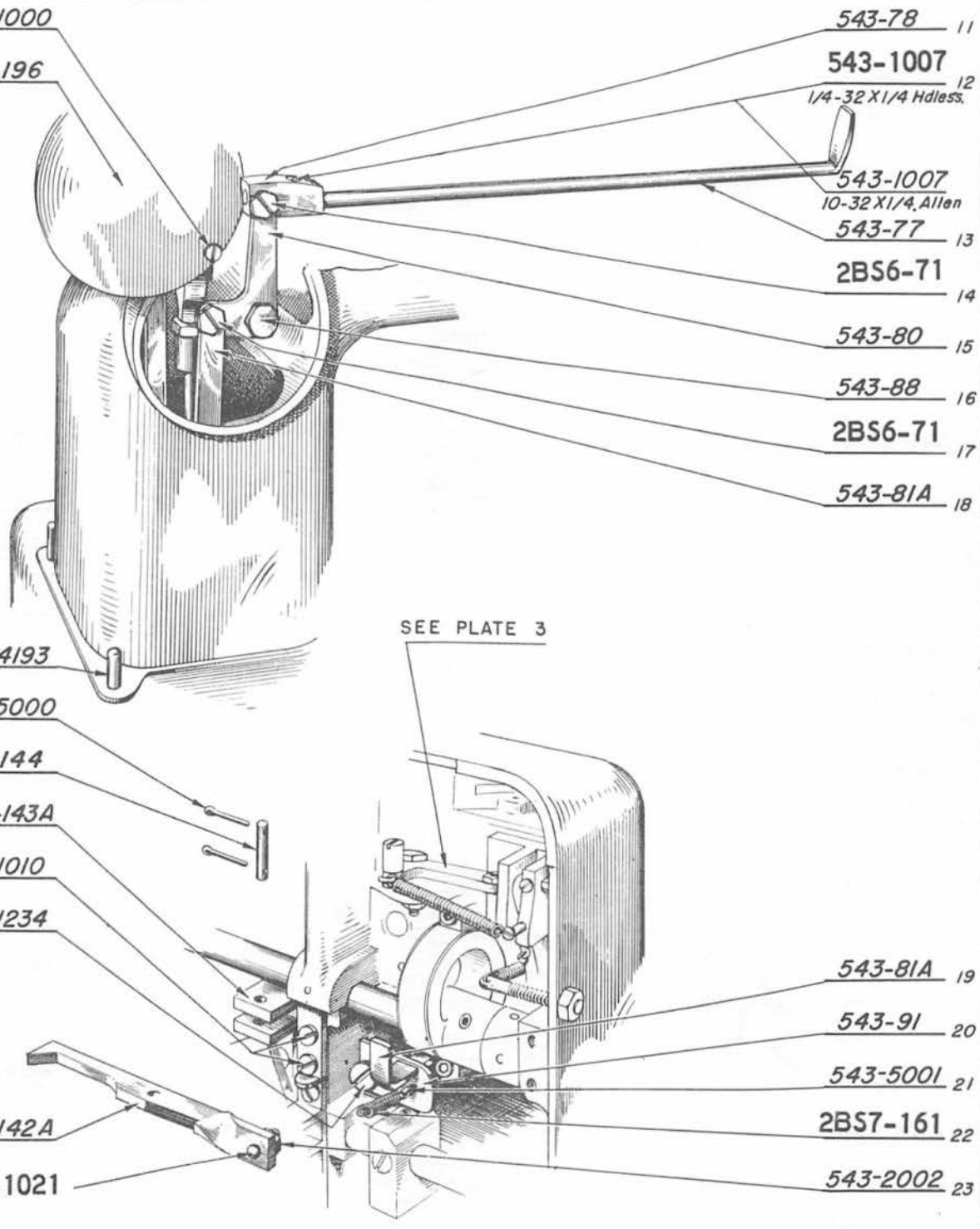
CLAMP LIFT and THREAD SLACK MECHANISM



CHANDLER 10

CHANGES 08.1972
1. was 543-90
2. was 543-92A
3. was 543-84

AUTOMATIC THREAD LOCKING MECHANISM

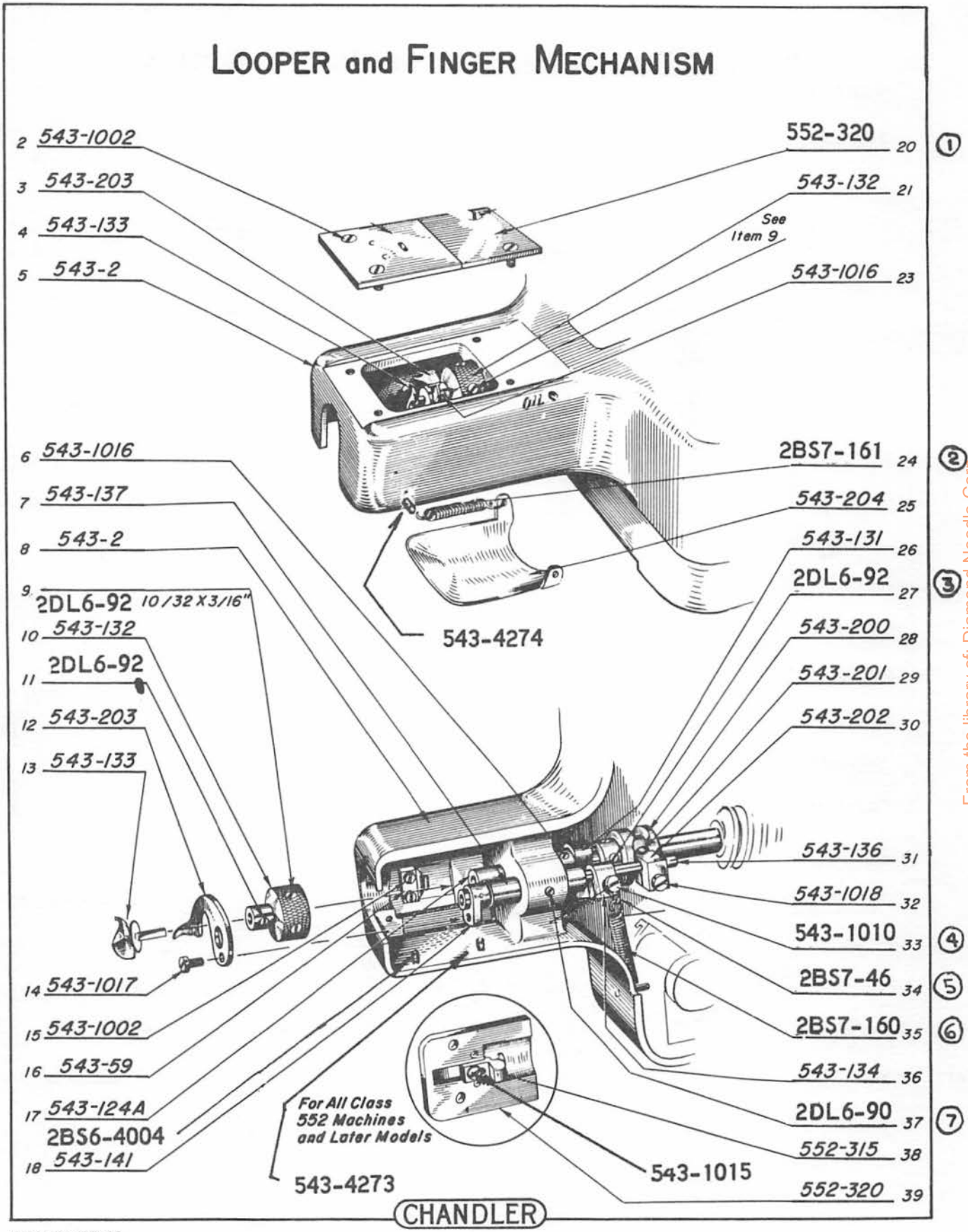


* FOR TWO NEEDLE TACKER USE NO. 560-404

CHANDLER

CHANGES: 08.1972
1. was 543-90
2. was 543-90
3. was 543-169
4. was 543--1012
5. was 543-1013

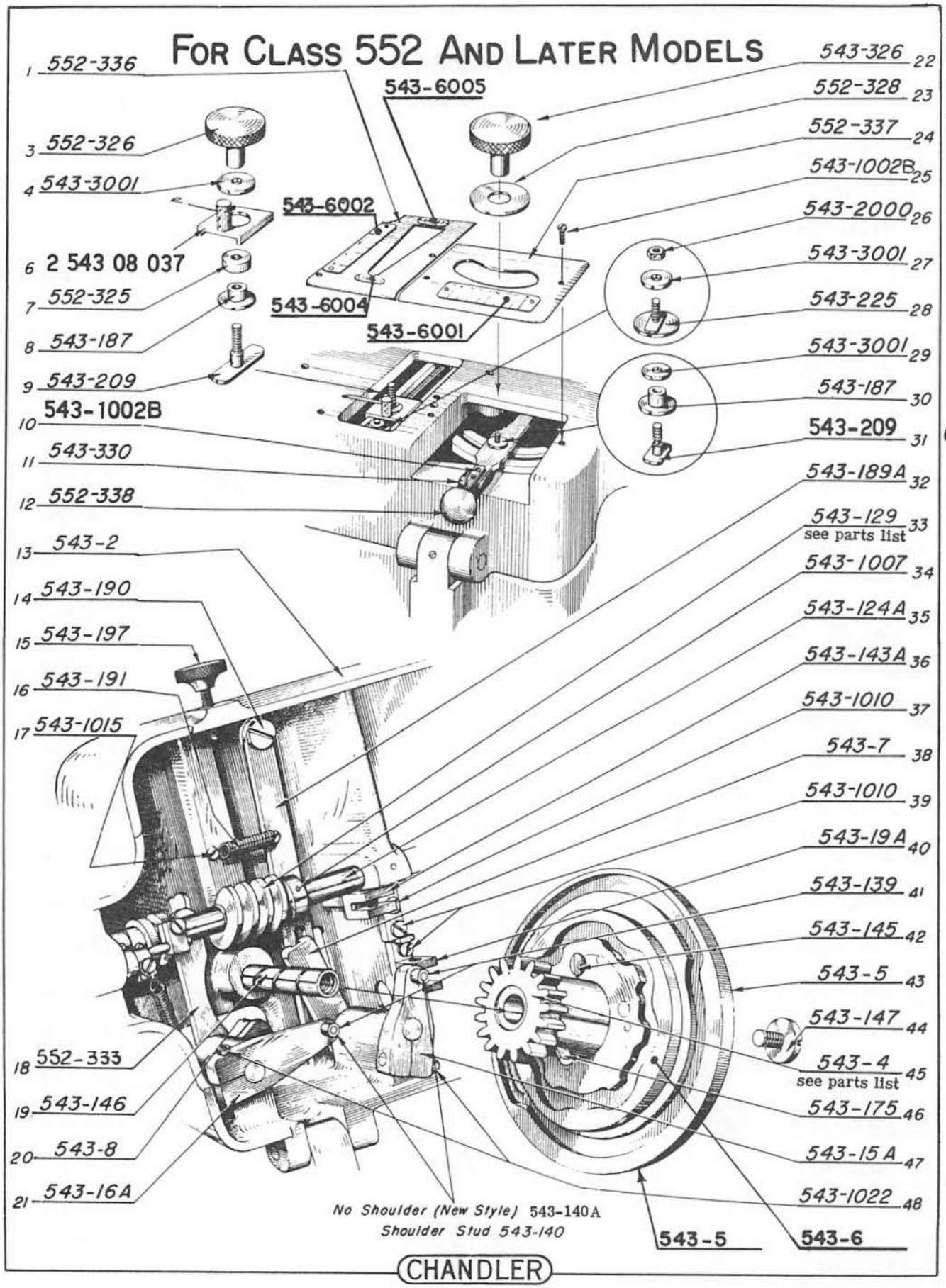
LOOPER and FINGER MECHANISM



CHANDLER 12

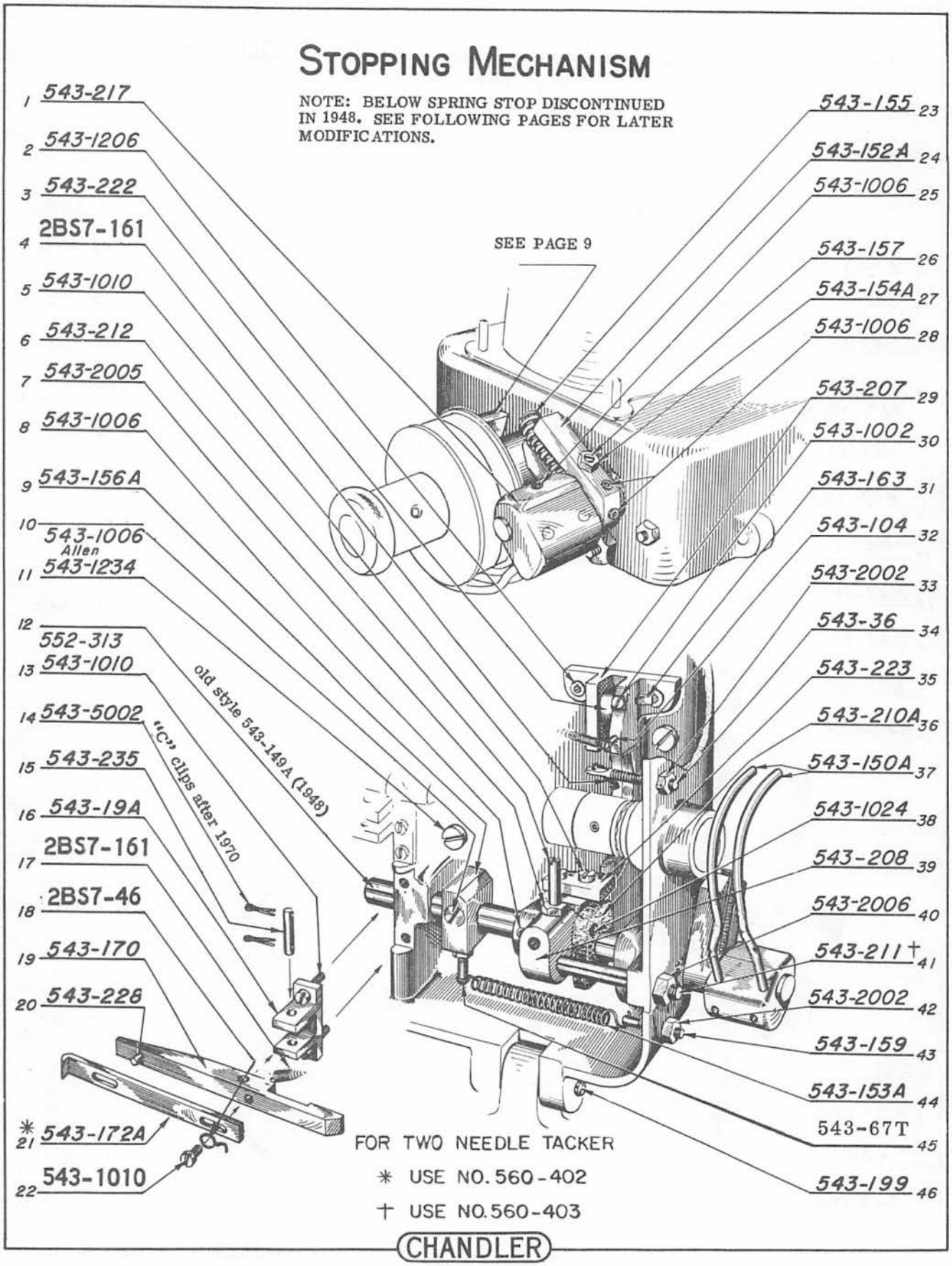
CHANGES: 08.1972

1. was 543-121 & 122
   In 1968 needle plate was changed to one piece
2. was 543-205
3. was 543-1016
4. was 543-1018
5. was 543-151
6. was 543-135
7. was 543-1003



CHANGES: 08.1972
1. was 552-329
2. was 543-1002A
3. was 543-184

BASIC COMMON PARTS

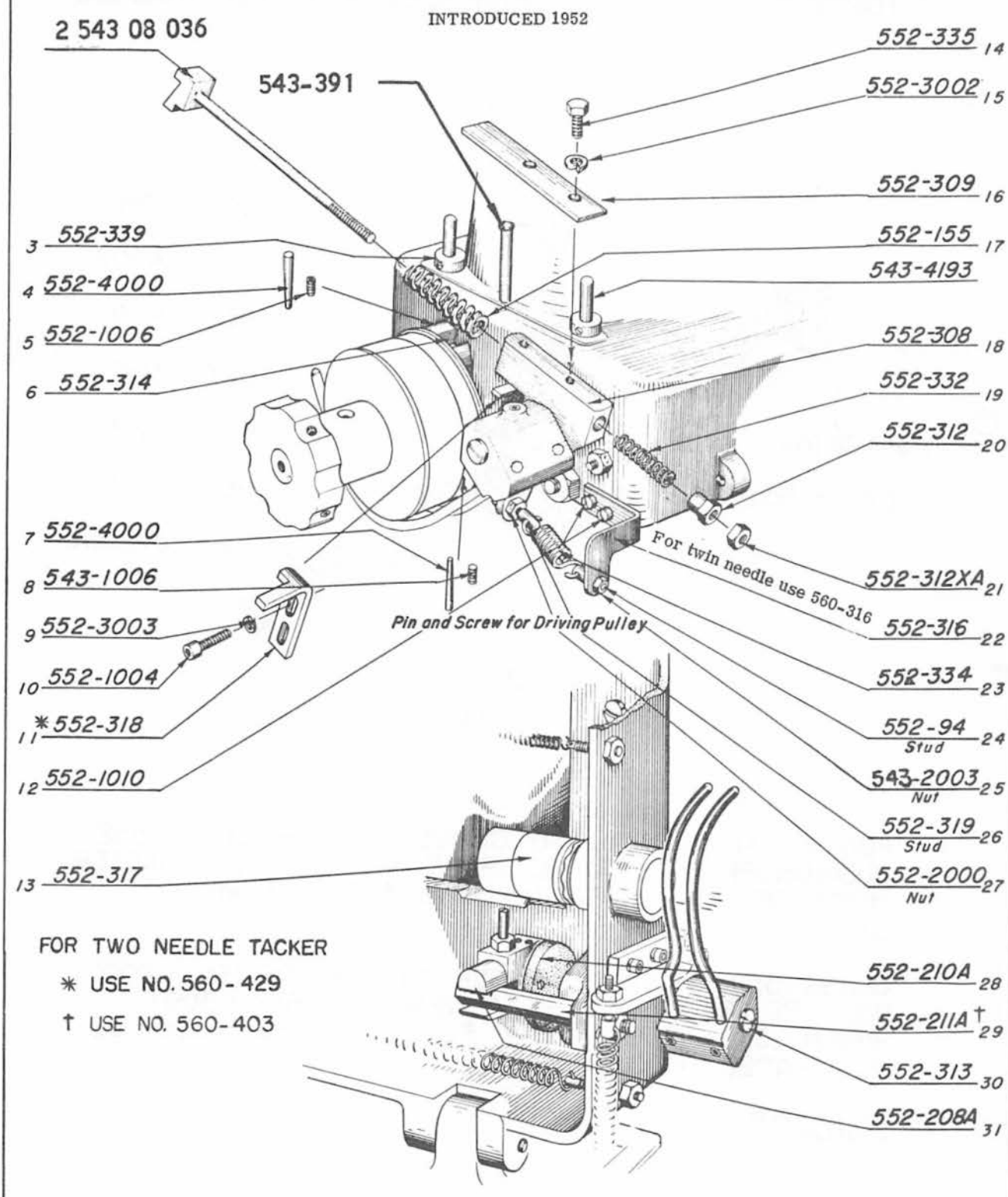


CHANDLER 14

CHANGES: 08.1972
1. was 543-169
2. was 543- 20
3. was 543-1018
4. was 543-235 (after 1970, "C" clips used)

STOPPING MECHANISM FOR CLASS 552 MACH.

INTRODUCED 1952



FOR TWO NEEDLE TACKER

* USE NO. 560-429

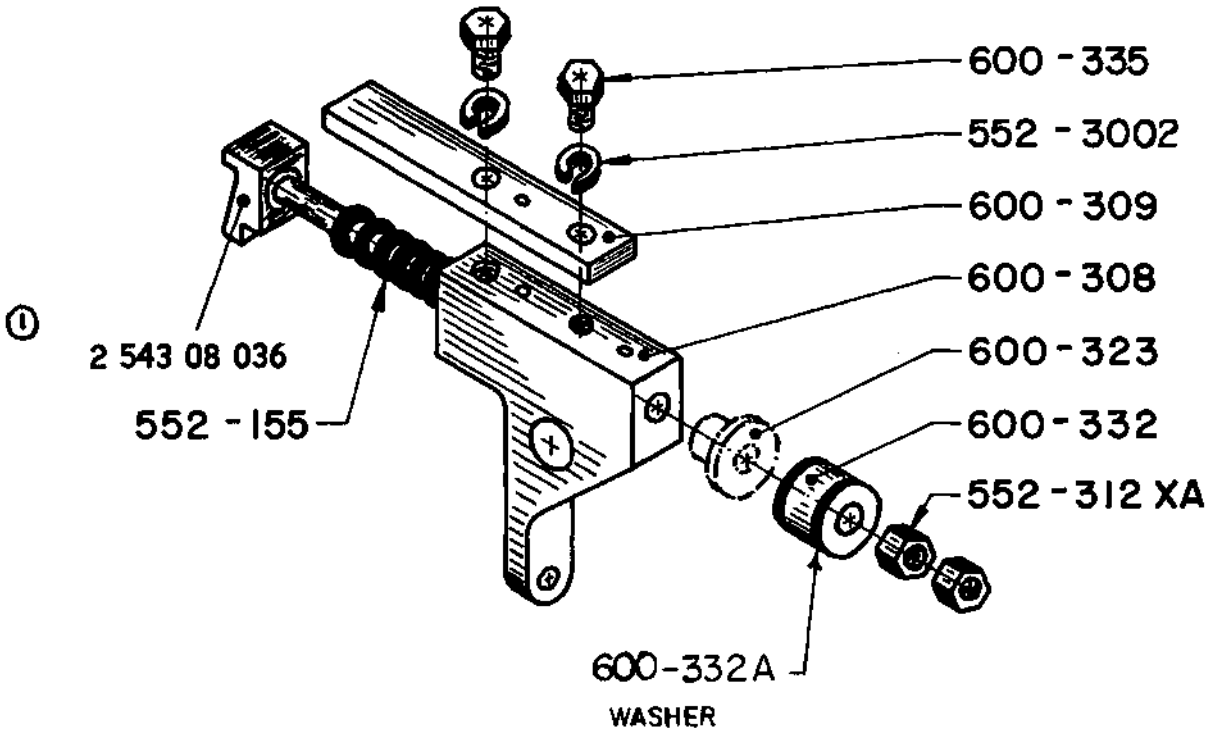
† USE NO. 560-403

CHANDLER

CHANGES: 08.1972
1. was 543-311, also see assy dwgs

STOPPING MECHANISM FOR CLASS 600 MACHINE

INTRODUCED 1971



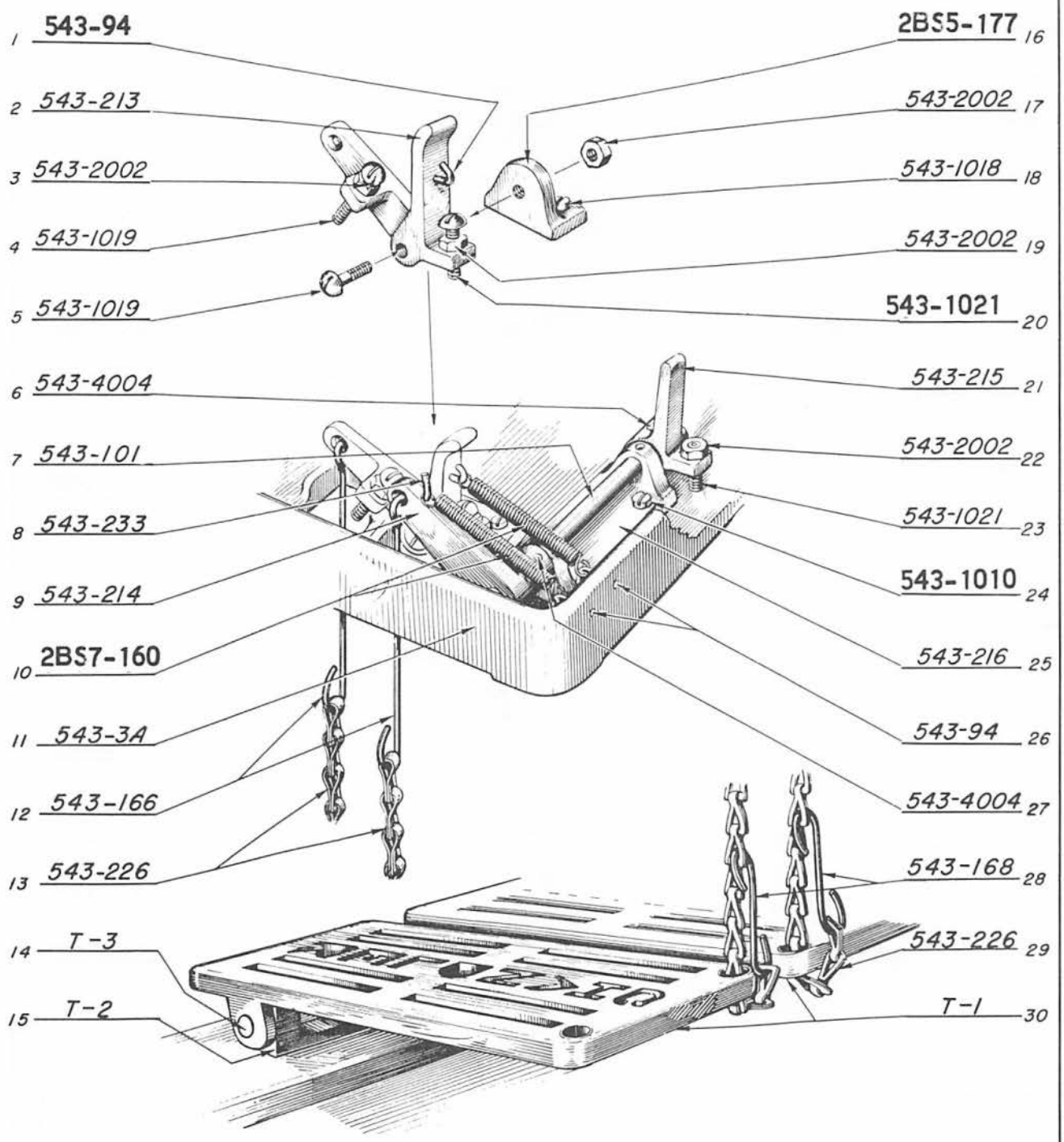
FOR THOSE WISHING TO CONVERT THEIR CLASS 552 CUSHIONSPRING HOLDERS, PART NO. 600-323 ADAPTER MUST BE PURCHASED. (spring no. 552-332 will be discontinued.)

CLASS 552 REBOUND FINGER STOP GUIDE (552-309) WILL BE REPLACED BY A NEW ONE (600-309), WHICH IS HEAVIER. NEW SCREWS MUST ALSO BE PURCHASED (600-335).

SEE PAGE 34 FOR ASSEMBLY NUMBER FOR COMPLETE UNIT.

CHANGES: 08.1972
1. was 552-311. also see assy dwgs

TREADLES and TRIP LEVERS

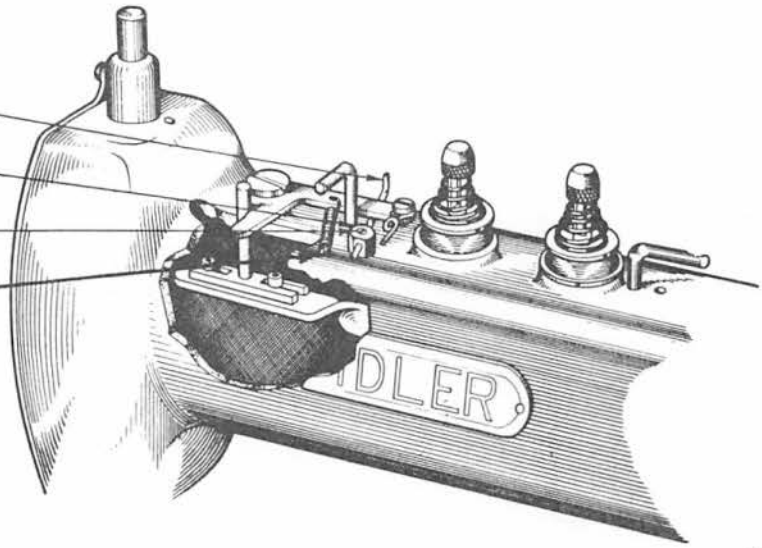


CHANDLER

CHANGES: 08.1972
1. was 543-93
2. was 543-79
3. was BS-77
4. was 543-1019

OPTIONAL - NOT FOUND ON ALL MACHINES

AUTOMATIC CLAMP LIFTER



1 555-385
2 555-384
① 3 2DL6-92
GROOVE PIN

4 555-380
5 543-2000
6 555-386
7 555-377
② 8 543-3001
9 543-1023
10 543-1308
11 555-382

12 543-3001
13 555-387
14 555-381
15 543-2000
543-220A
nut 543-2005
552-367
16 555-378
17 555-379
18 543-2000
19 555-383
20 543-241

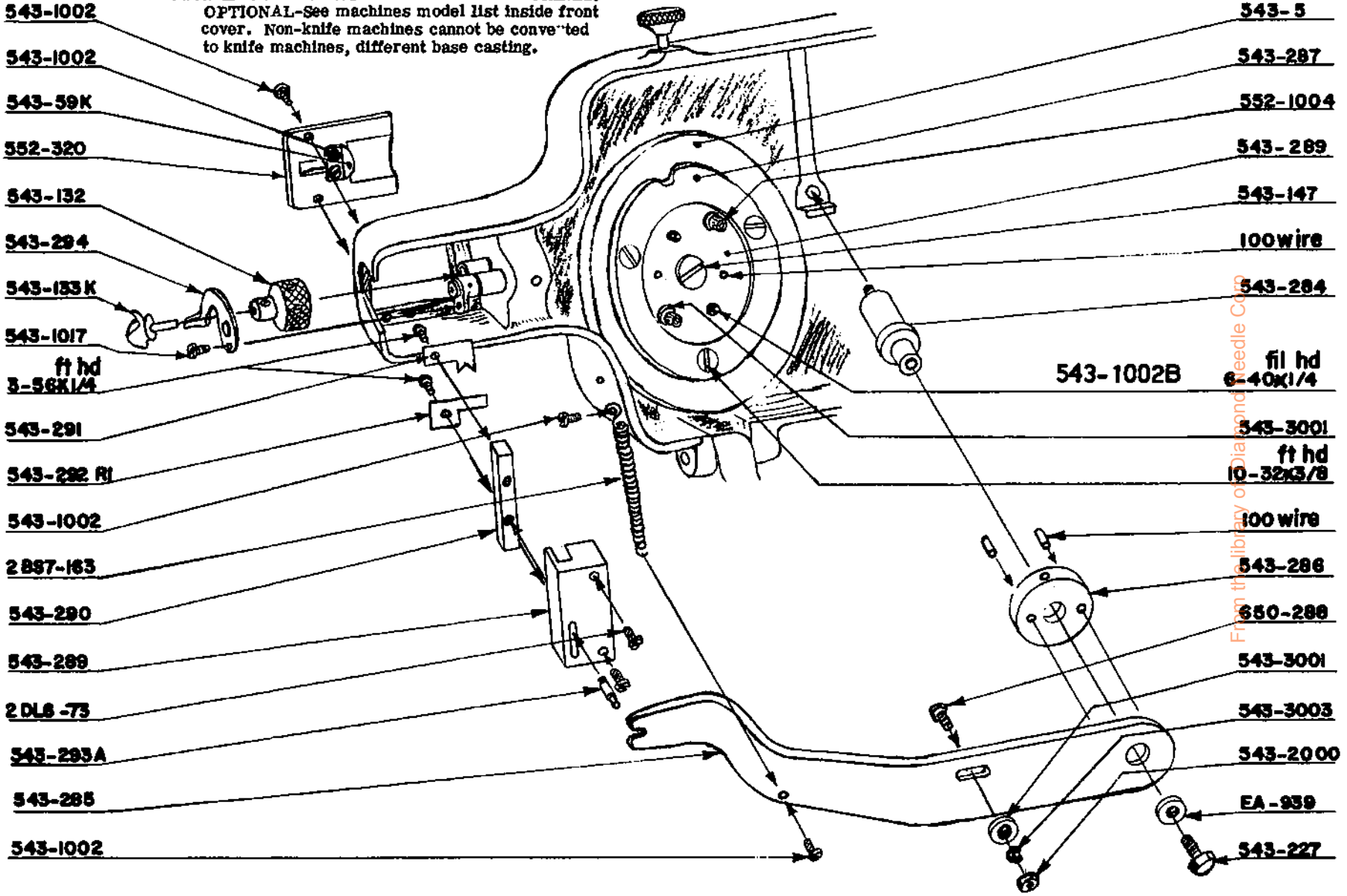
CHANDLER

CHANDLER 18

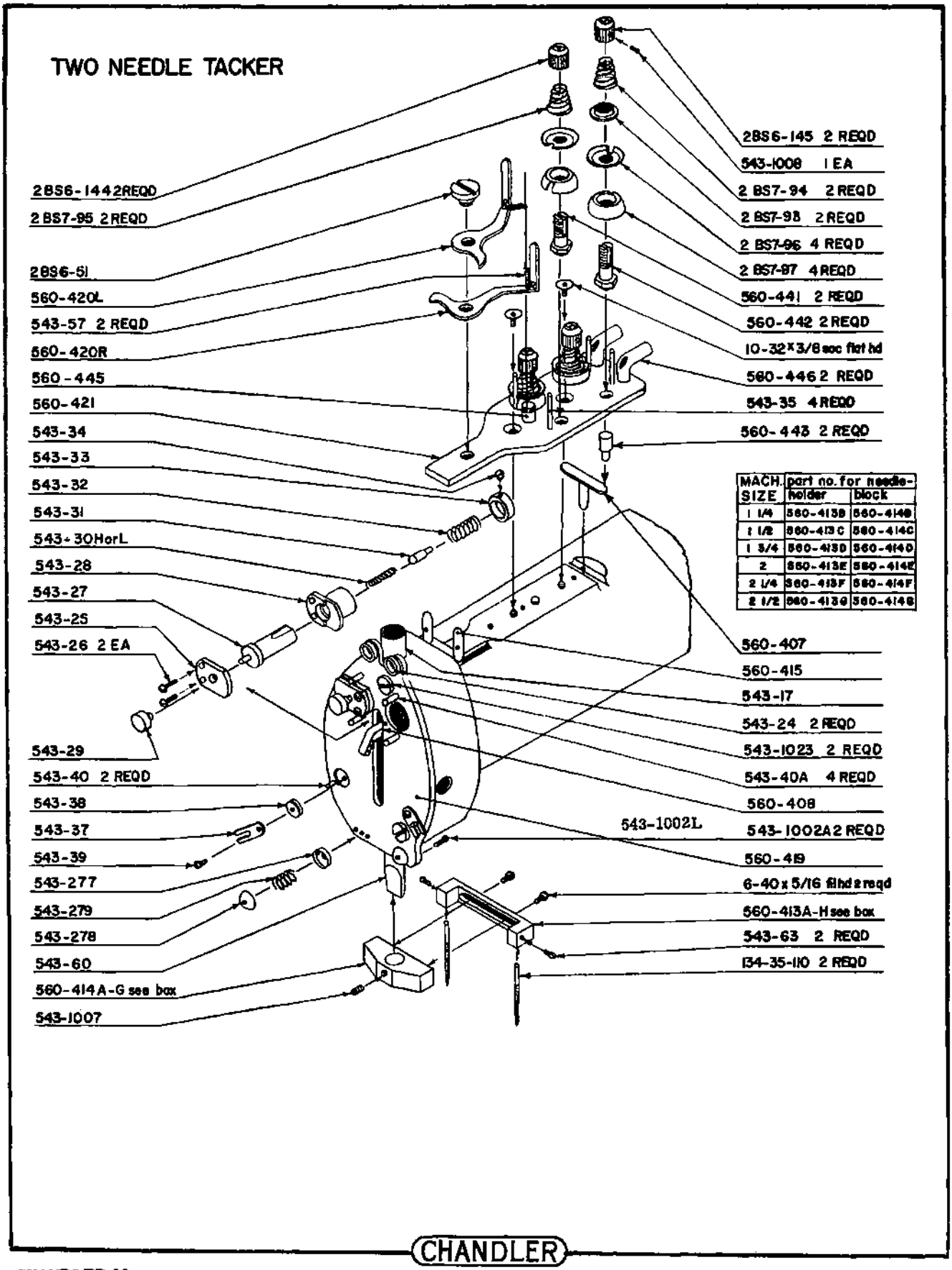
CHANGES: 08.1972
1. was 543-1016
2. was 543-1018

KNIFE MECHANISM "K" SUFFIX MACHINES.

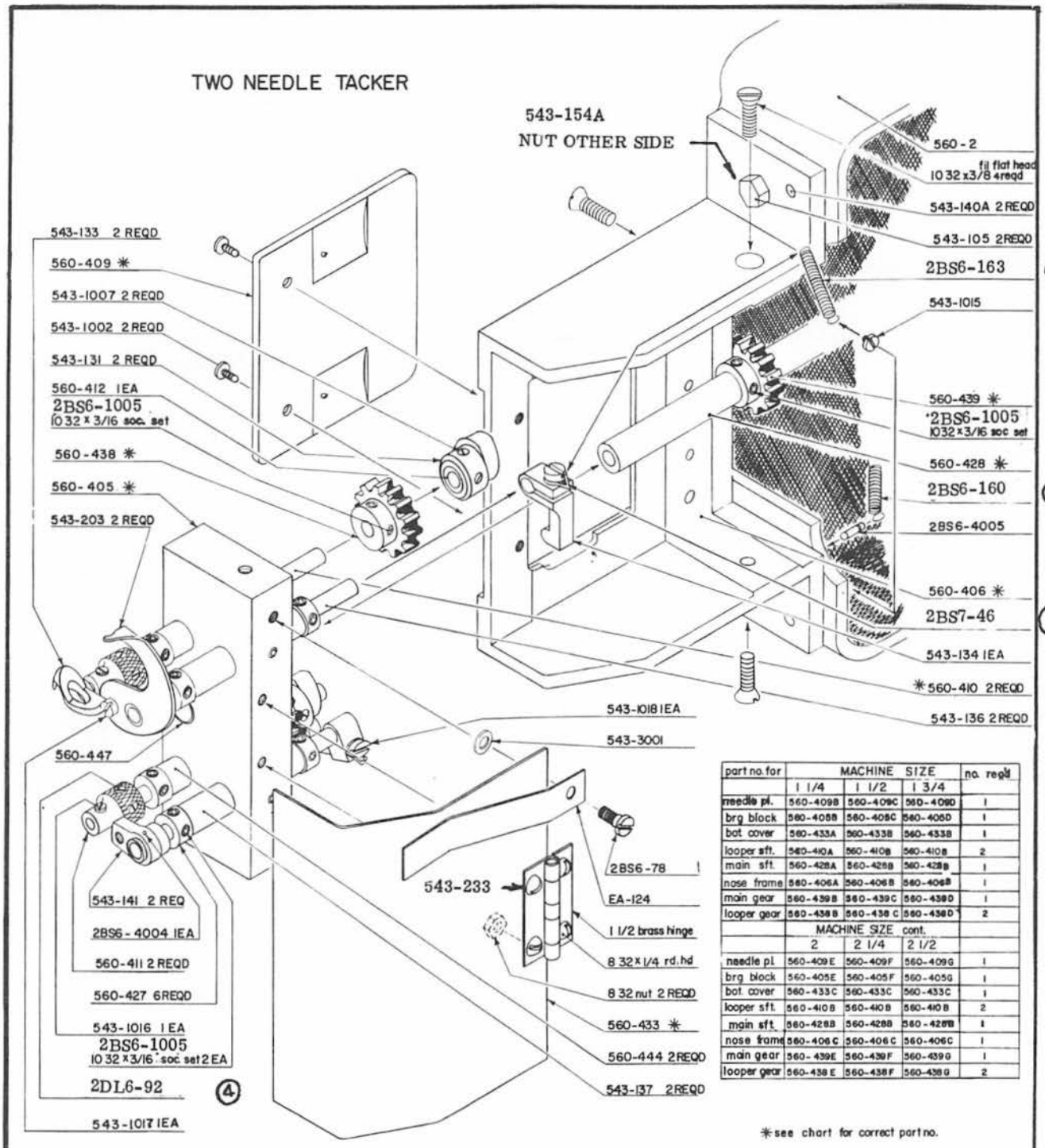
OPTIONAL-See machines model list inside front cover. Non-knife machines cannot be converted to knife machines, different base casting.



TWO NEEDLE TACKER



MACH. SIZE	part no. for needle- holder	block
1 1/4	560-413B	560-414B
1 1/2	560-413C	560-414C
1 3/4	560-413D	560-414D
2	560-413E	560-414E
2 1/4	560-413F	560-414F
2 1/2	560-413G	560-414G



part no. for	MACHINE SIZE			no. req'd
	1 1/4	1 1/2	1 3/4	
needle pl.	560-409B	560-409C	560-409D	1
brg block	560-405B	560-405C	560-405D	1
bot. cover	560-433A	560-433B	560-433B	1
looper sft.	560-410A	560-410B	560-410B	2
main sft.	560-428A	560-428B	560-428B	1
nose frame	560-406A	560-406B	560-406B	1
main gear	560-439B	560-439C	560-439D	1
looper gear	560-438B	560-438 C	560-438D	2
	MACHINE SIZE cont.			
	2	2 1/4	2 1/2	
needle pl	560-409E	560-409F	560-409G	1
brg block	560-405E	560-405F	560-405G	1
bot. cover	560-433C	560-433C	560-433C	1
looper sft.	560-410B	560-410B	560-410B	2
main sft.	560-428B	560-428B	560-428B	1
nose frame	560-406C	560-406C	560-406C	1
main gear	560-439E	560-439F	560-439G	1
looper gear	560-438E	560-438F	560-438G	2

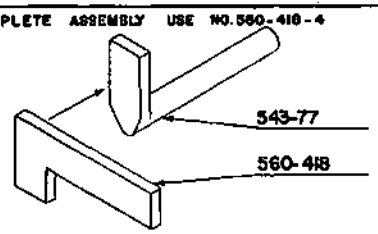
✳see chart for correct part no.

CHANDLER

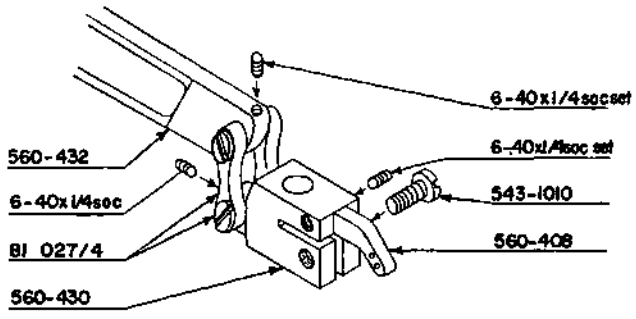
CHANGES: 08.1972
1. was 543-92A
2. was 543-169
3. was 543-151
4. was 543-1016

TWO NEEDLE TACKER

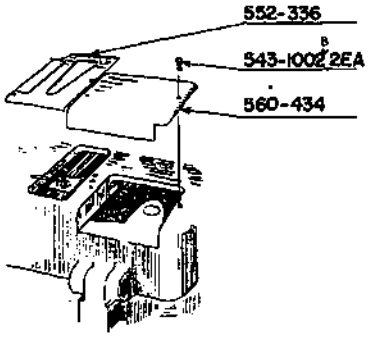
TWO NEEDLE TACKER PARTS THAT DIFFER FROM STANDARD



for further details see plate 4

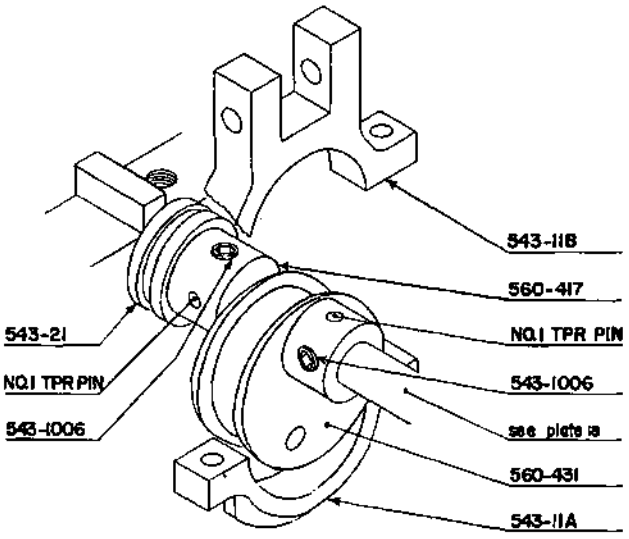


for further details see plate 2



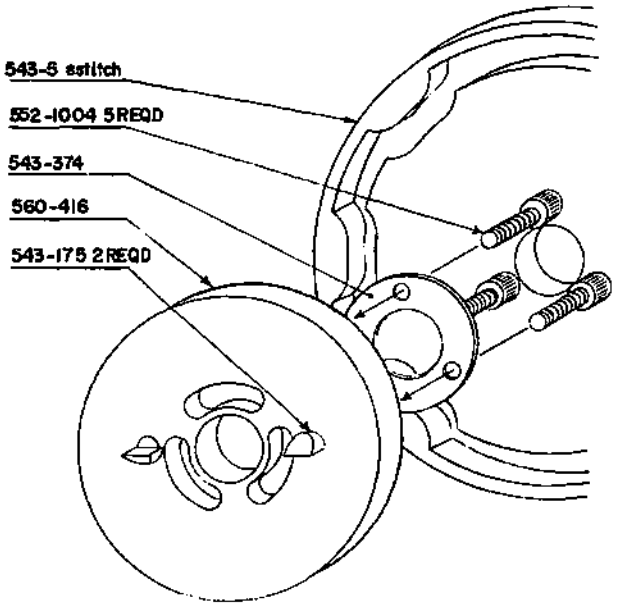
for further details see plate 6

543-4002



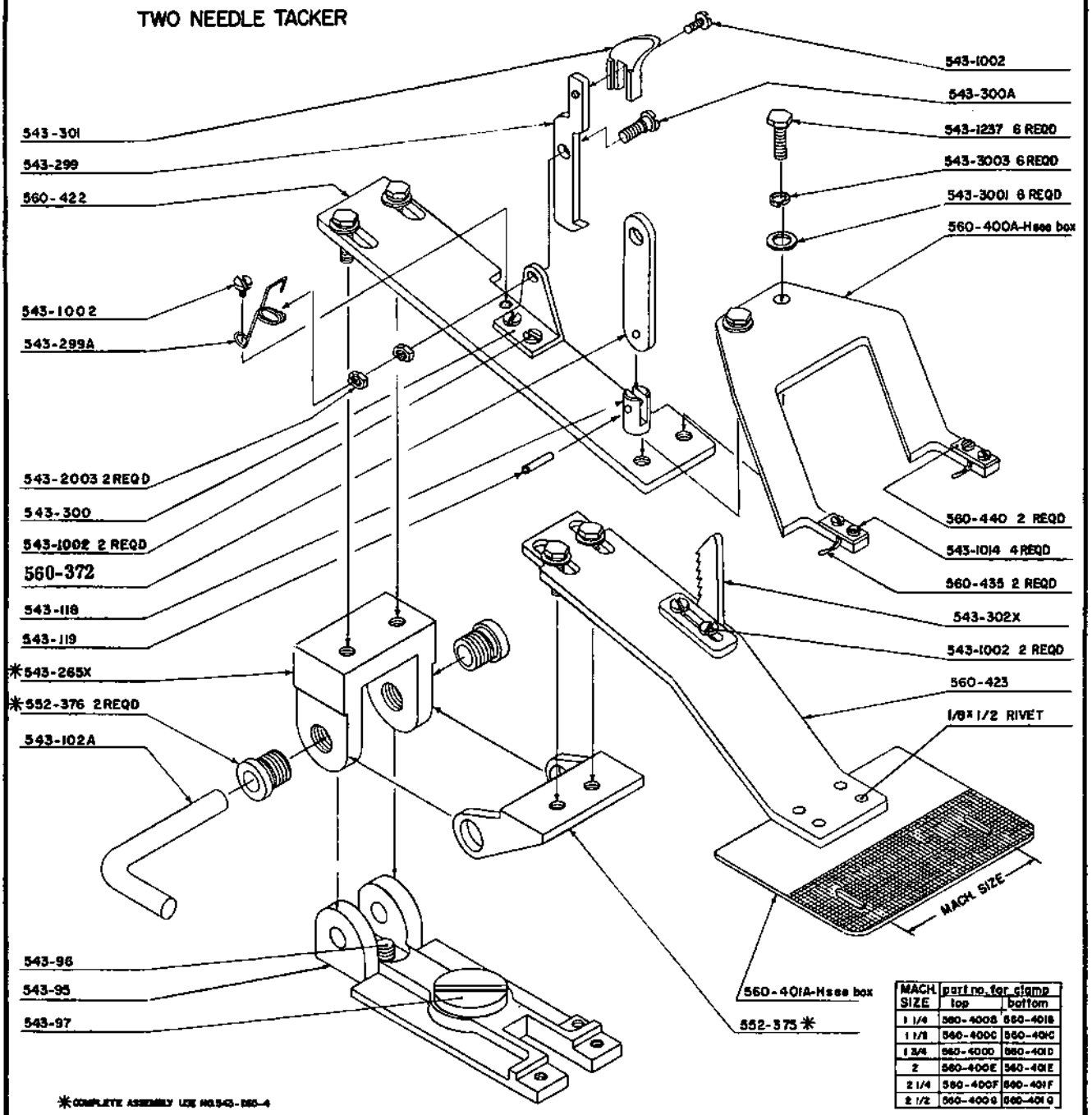
for further details see plate 2

SHORT LIFT ECCENTRIC



for further details see plate 6

SPECIAL CAM

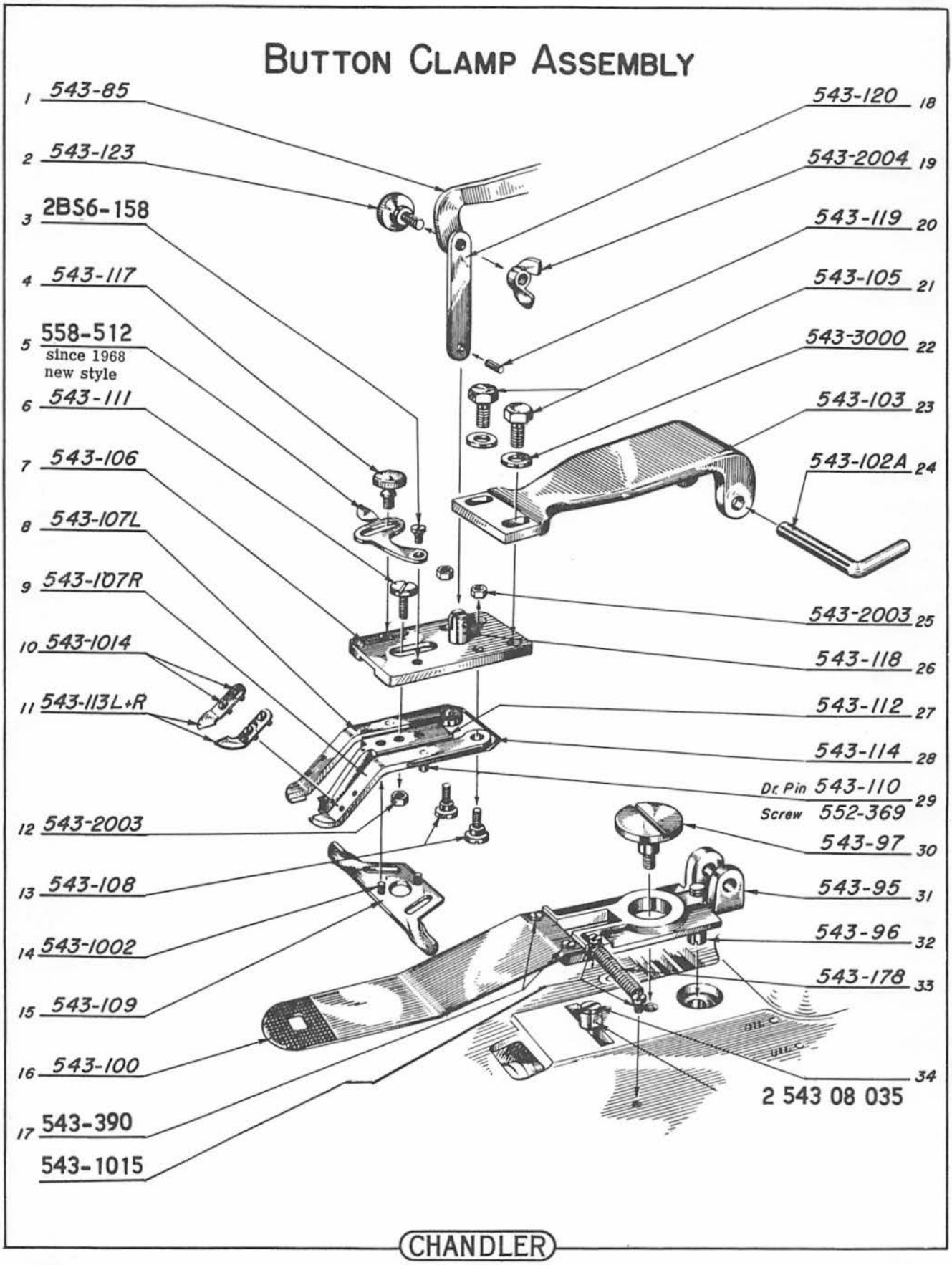


MACH. SIZE	part no. for clamp top	bottom
1 1/4	560-400B	560-401B
1 1/8	560-400C	560-401C
1 3/4	560-400D	560-401D
2	560-400E	560-401E
2 1/4	560-400F	560-401F
2 1/2	560-400G	560-401G

CHANGES: 08.72
1. was 543-372

CLAMPS

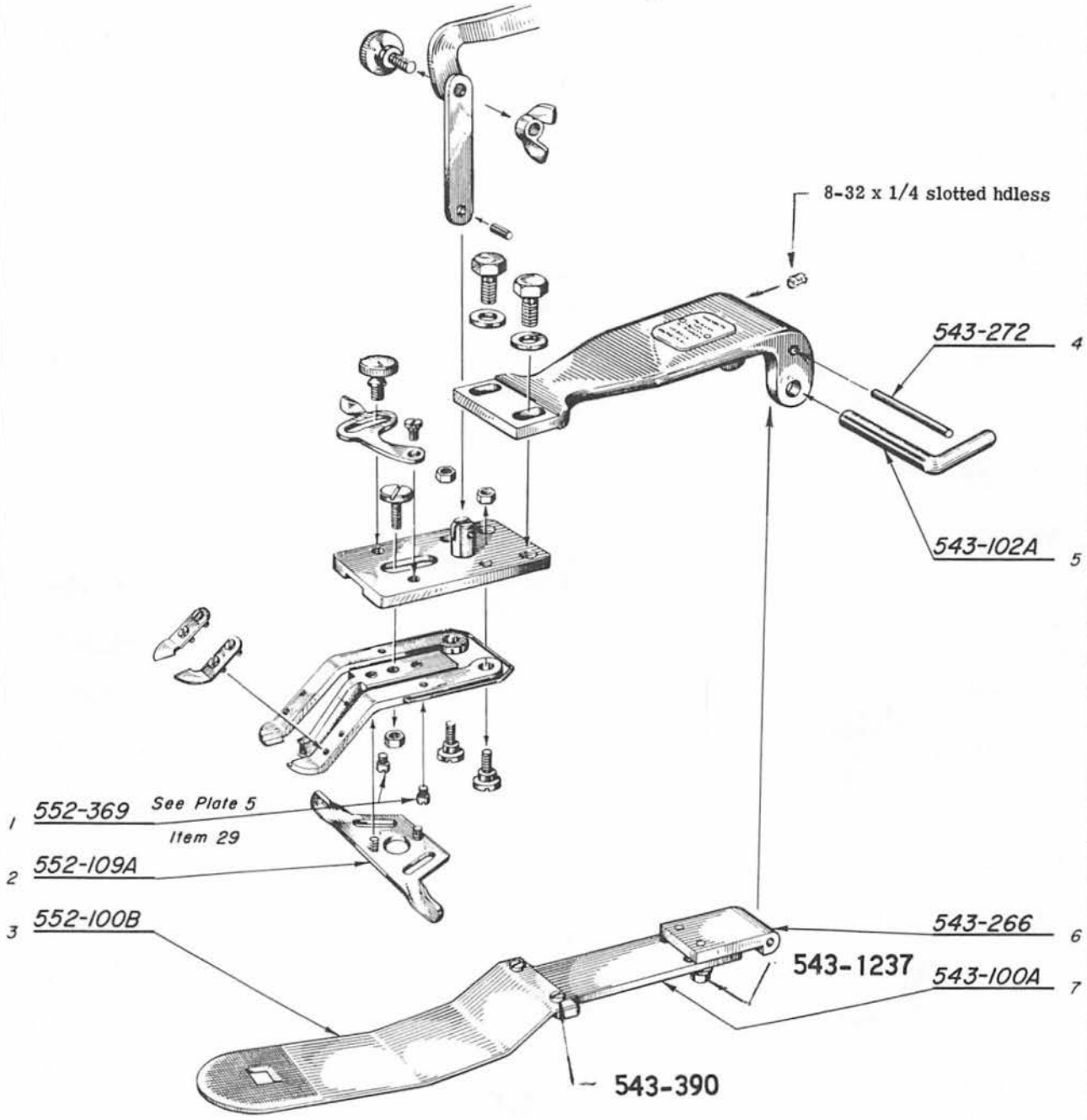
BUTTON CLAMP ASSEMBLY



CHANDLER 24

CHANGES: 08.1972
1. was 543-116
2. was 543-1015
3. was 543-98 & 543-99
4. was 543-115

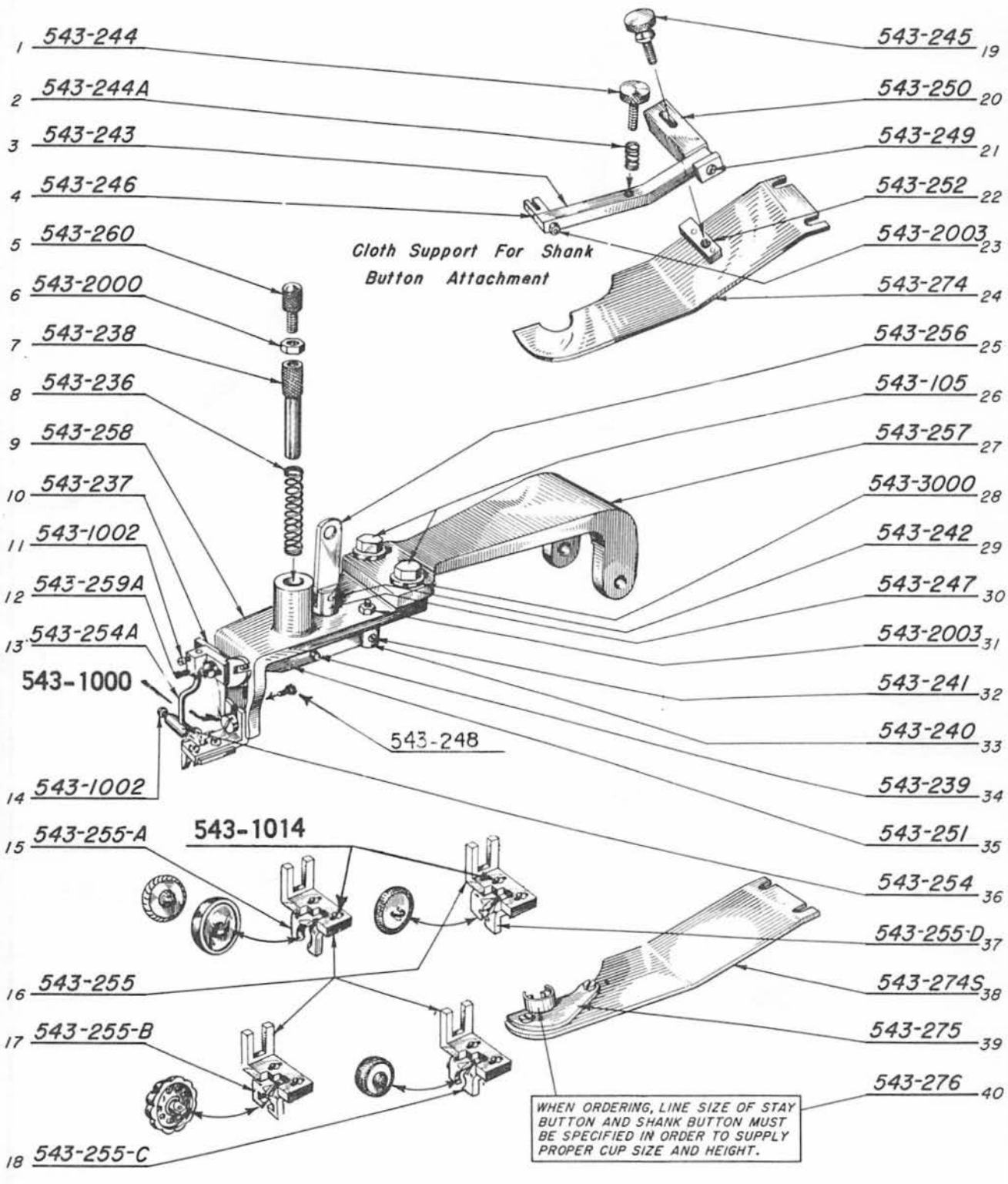
BUTTON CLAMP ASSEMBLY
All In One Style



NOTE
Parts Not Bearing Numbers
Are Identified On Plate 5

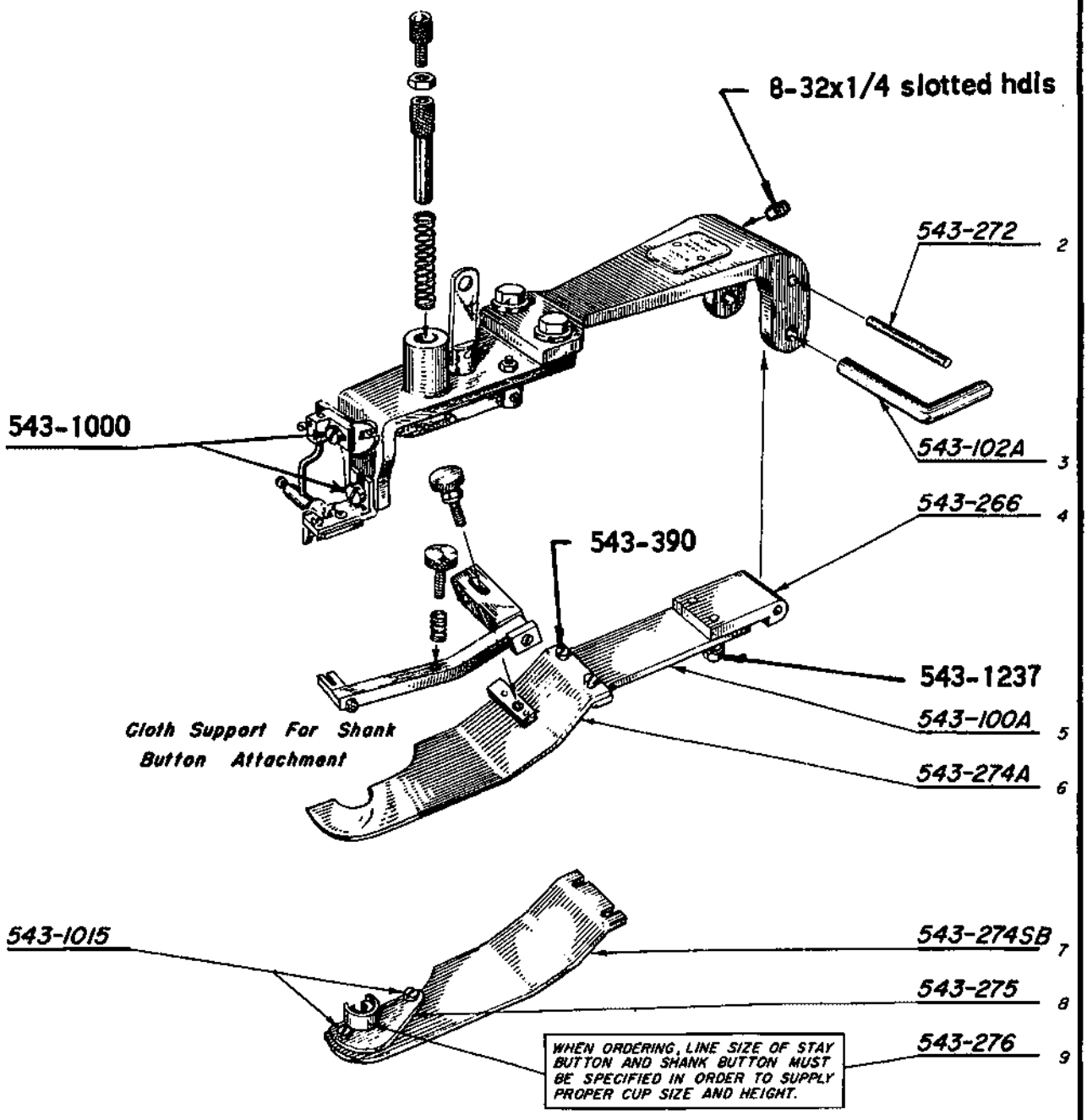
CHANDLER

SHANK BUTTON ATTACHMENT



CHANDLER

SHANK BUTTON ATTACHMENT
All In One Style



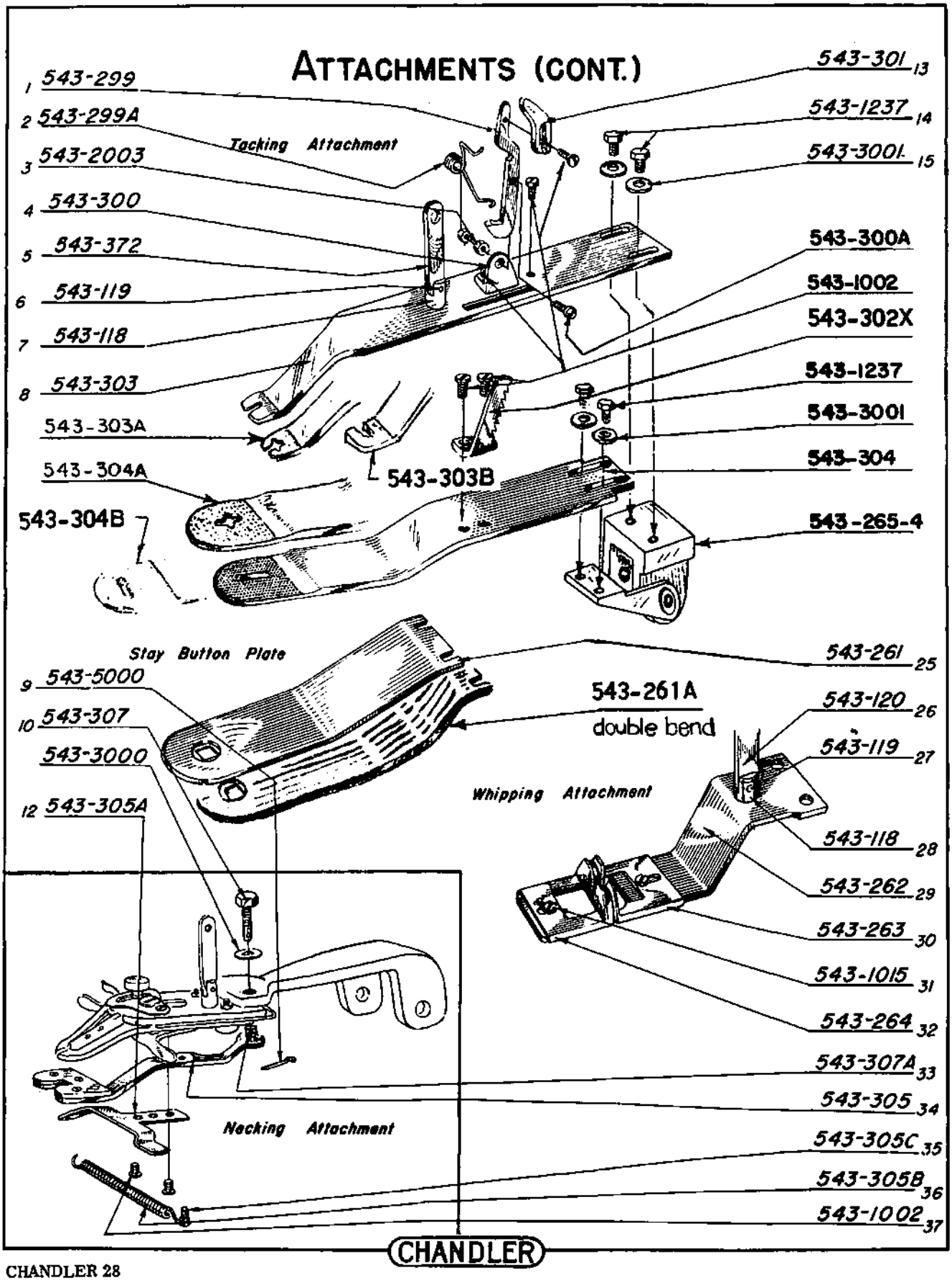
NOTE

Parts Not Bearing Numbers

Are Identified On Plate 10

CHANDLER

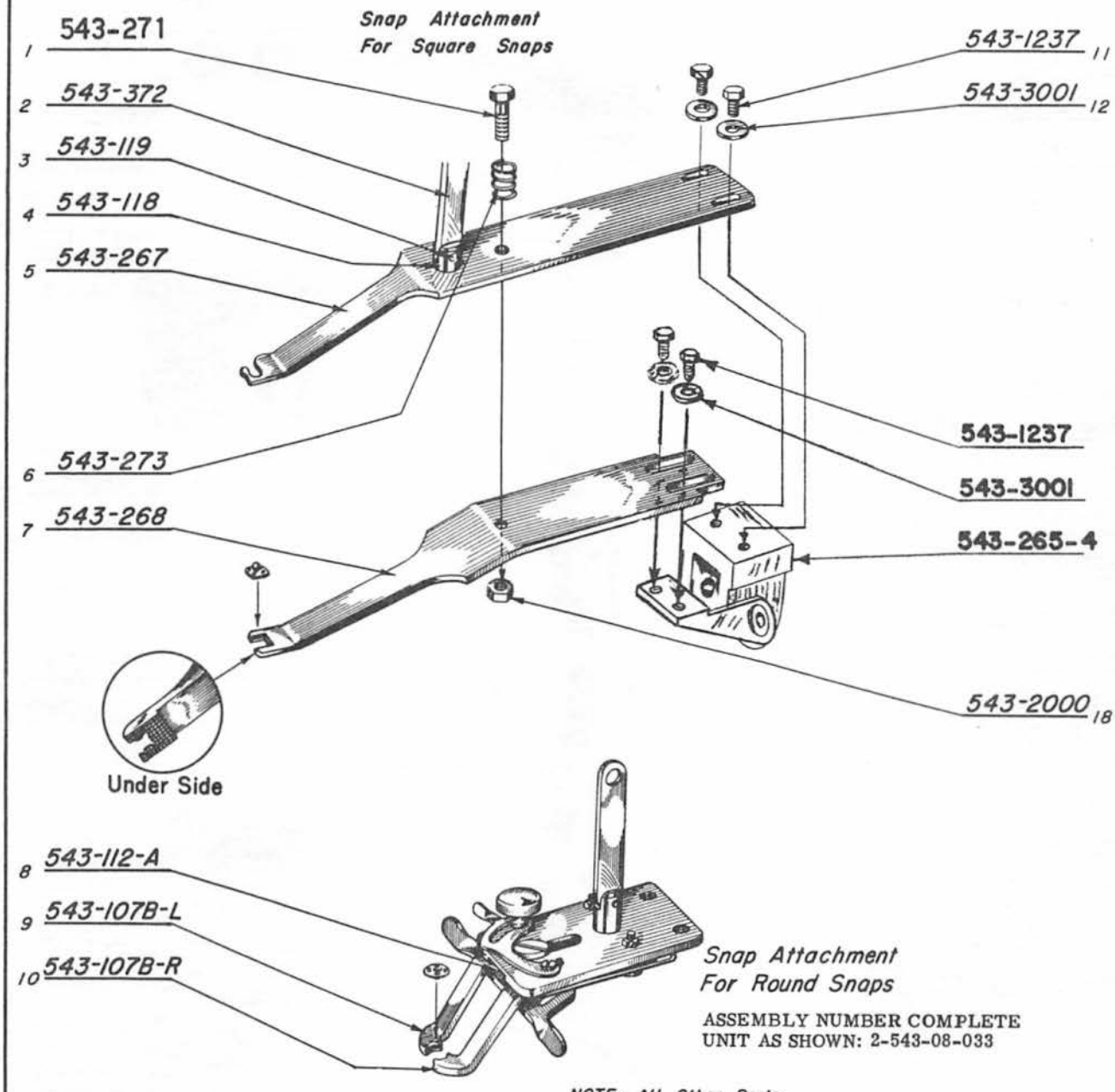
CLAMPS



CHANDLER 28

CHANGES: 08.1972
1. was 543-302

ATTACHMENTS (Cont.)



ASSEMBLY NUMBER COMPLETE
UNIT AS SHOWN: 2-543-08-033

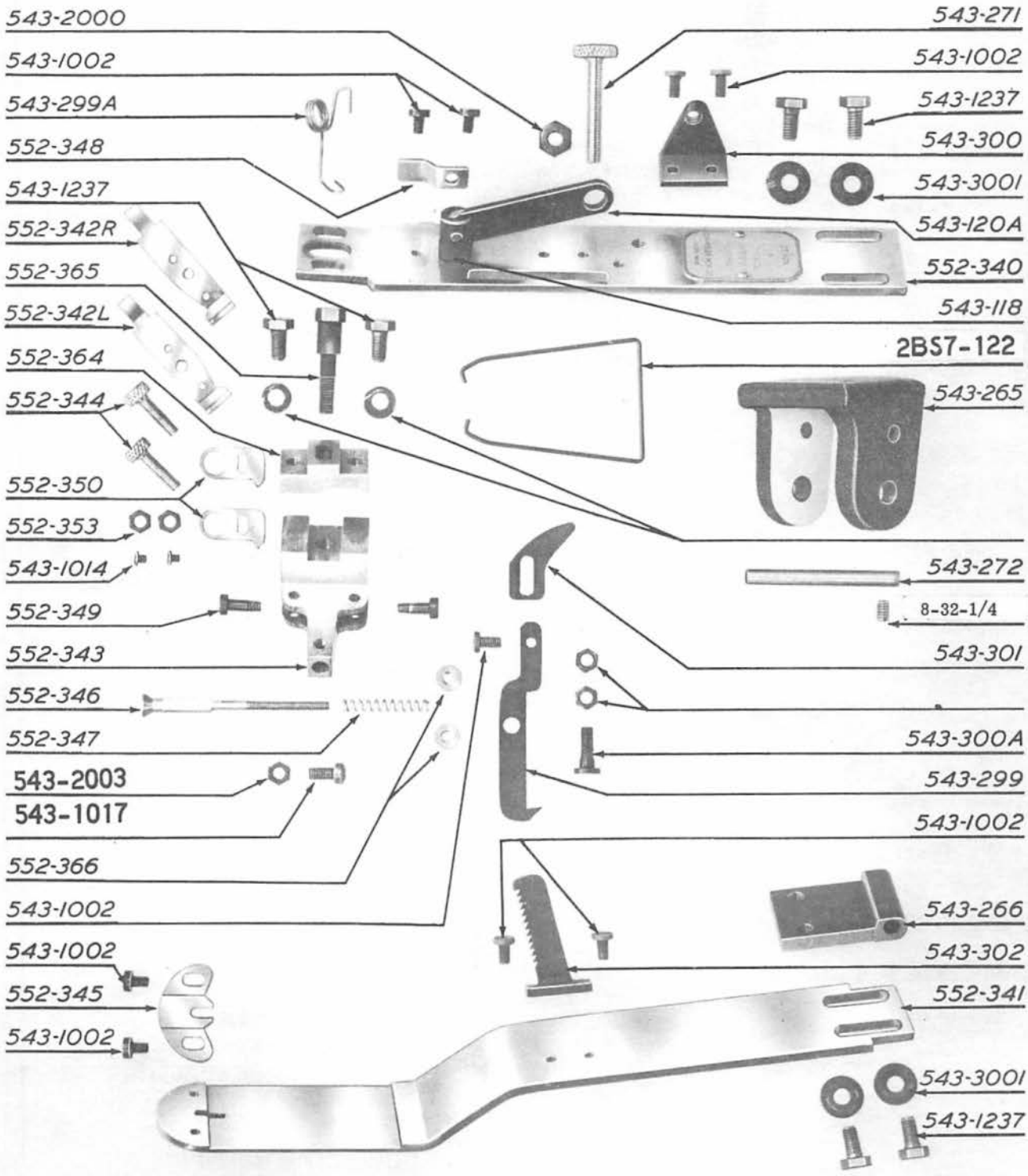
NOTE: All Other Parts Same As Plate 5

CHANDLER

CHANGES: 08,1972
1. was 543-1236

CLAMPS

SHANK-MASTER ATTACHMENT



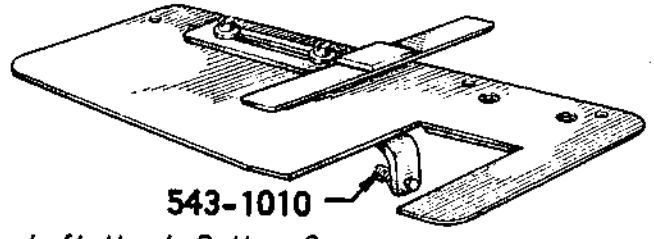
CHANDLER

CHANDLER 30

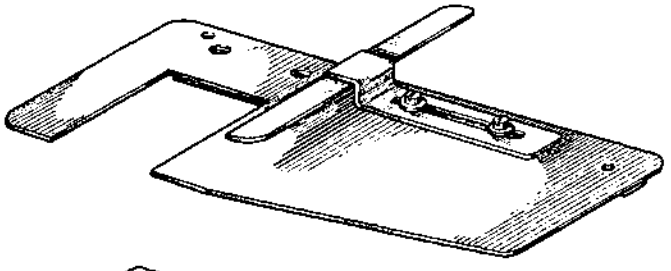
CHANGES: 08.1972
1. was 552-353
2. was 552-352
3. was 552-351

ASSEMBLY NUMBER FOR ABOVE ENTIRE UNIT:
2-543-08-034

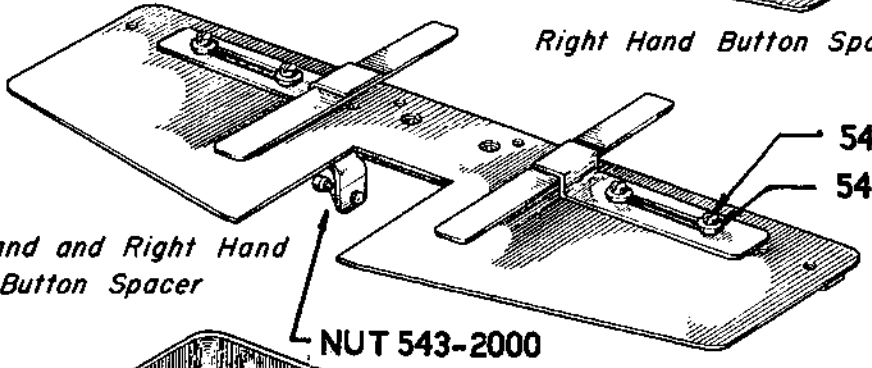
BUTTON ACCESSORIES



543-1010
Left Hand Button Spacer



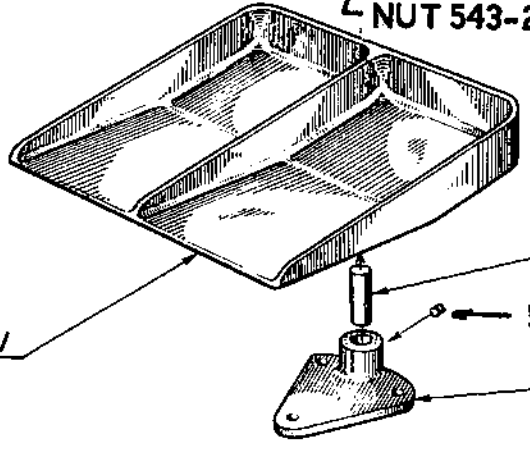
Right Hand Button Spacer



543-1018
543-3001

Left Hand and Right Hand Button Spacer

NUT 543-2000



552-324 2

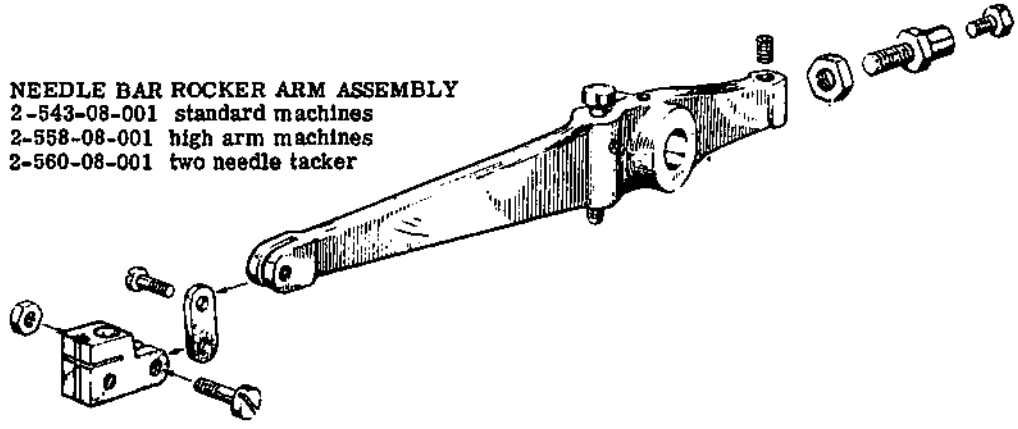
552-321

543-1007

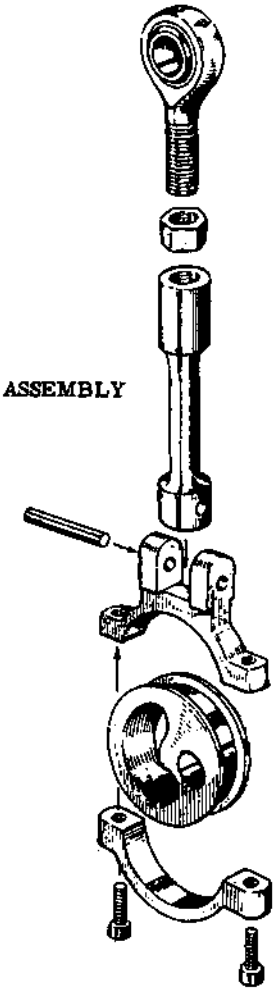
552-322 3

ASSEMBLY GROUPS

NEEDLE BAR ROCKER ARM ASSEMBLY
2-543-08-001 standard machines
2-558-08-001 high arm machines
2-560-08-001 two needle tacker

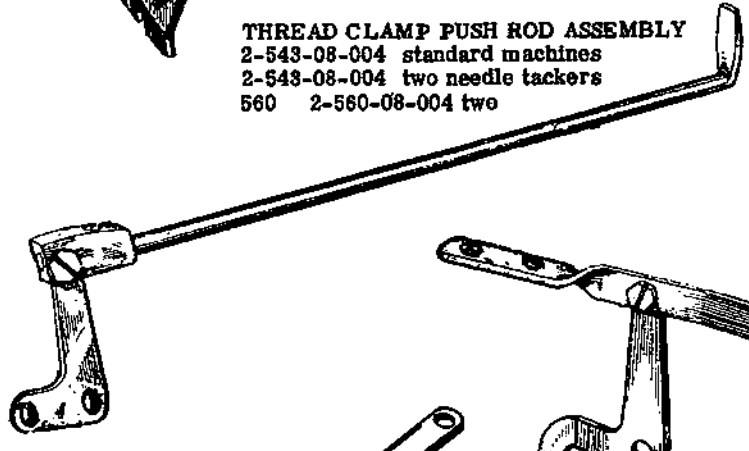


ECCENTRIC CONNECTING ROD ASSEMBLY
2-543-08-002 standard machines
2-558-08-002 high arm machines
2-560-08-002 two needle tacker

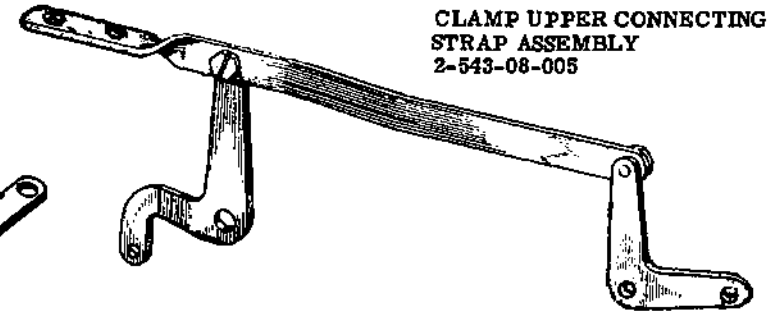


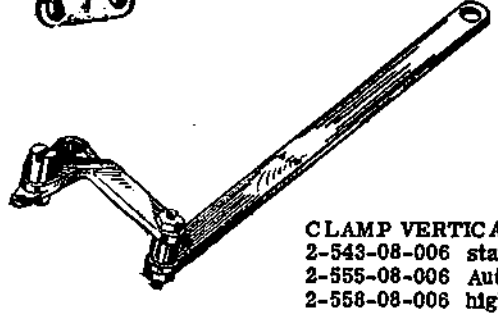
FACE PLATE ASSEMBLY
2-543-08-003 standard machines
2-560-08-003 two needle tackers

THREAD CLAMP PUSH ROD ASSEMBLY
2-543-08-004 standard machines
2-543-08-004 two needle tackers
560 2-560-08-004 two



CLAMP UPPER CONNECTING STRAP ASSEMBLY
2-543-08-005

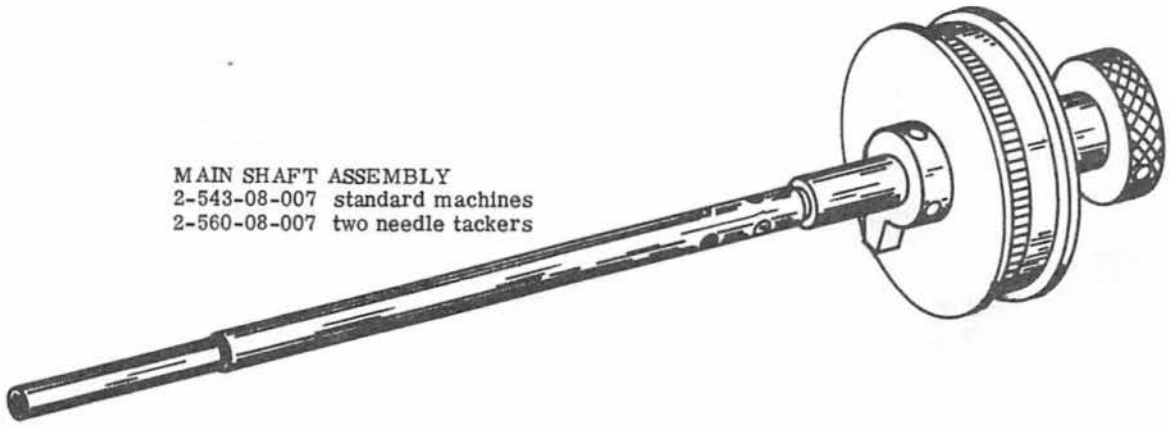




CLAMP VERTICAL CONNECTING STRAP ASSEMBLY
2-543-08-006 standard machines
2-555-08-006 Automatic clamp lift
2-558-08-006 high arm

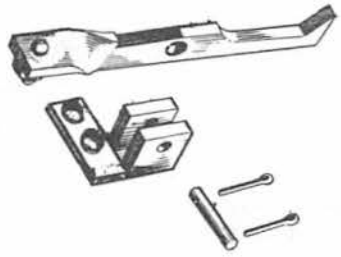
CHANDLER

MAIN SHAFT ASSEMBLY
2-543-08-007 standard machines
2-560-08-007 two needle tackers



FINGER SHAFT ASSEMBLY
2-543-08-008 standard machines
2-560-08-008 two needle tackers

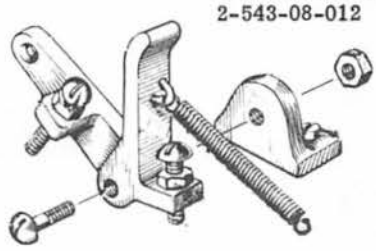
THREAD LOCK FINGER ASSEMBLY
2-543-08-009 standard machines
2-543-08-009A specials
2-560-08-009 two needle tackers



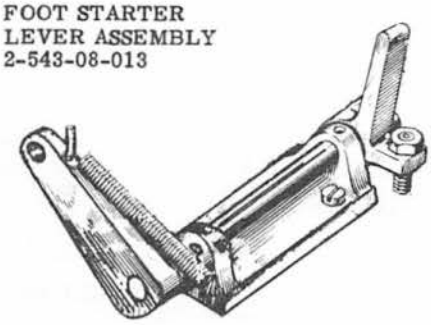
STOP SHAFT BLOCK ASSEMBLY
2-543-08-010

STOP SHAFT GUIDE BLOCK ASSEMBLY
2-543-08-011

CLAMP LIFTER LEVER ASSEMBLY
2-543-08-012

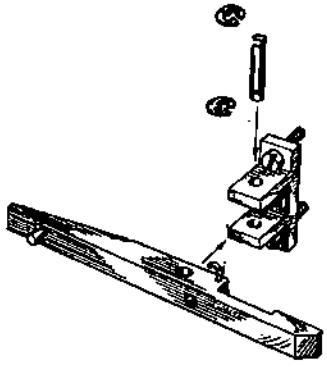


FOOT STARTER LEVER ASSEMBLY
2-543-08-013

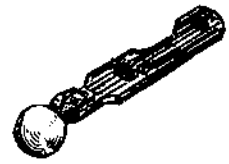


BELT SHIFTER ASSEMBLY
2-543-08-014

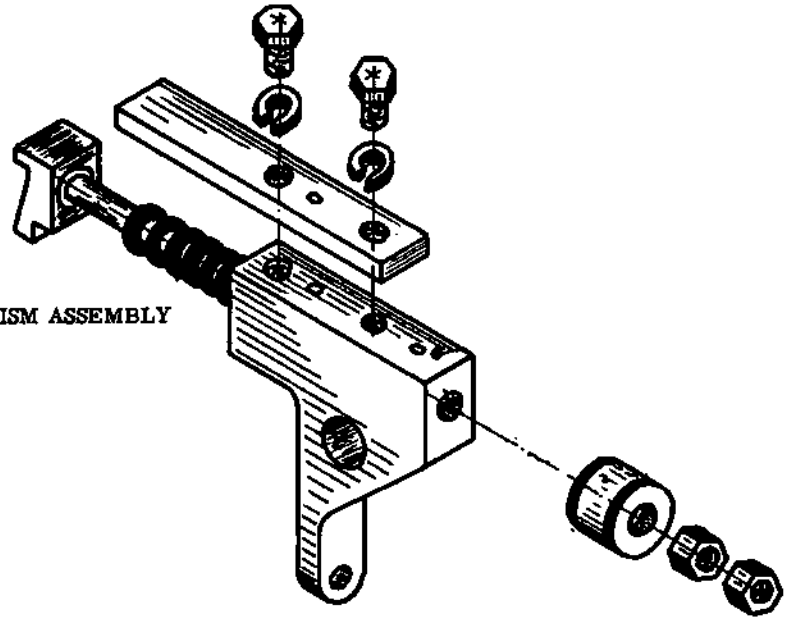
ASSEMBLY GROUPS



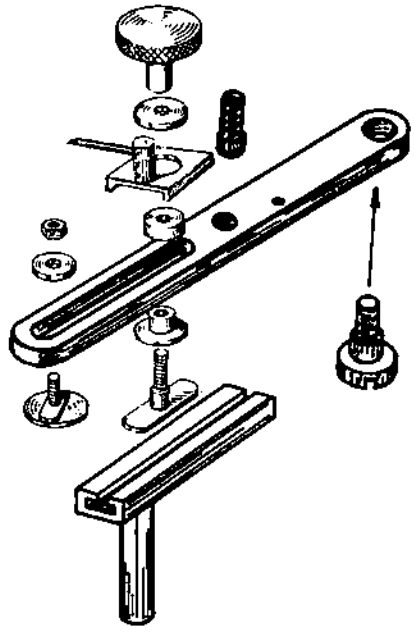
STOP MOTION KICKOFF
TRIPPER ASSEMBLY
2-543-08-015



FRONT ADJUSTING STITCH
LEVER ASSEMBLY
2-543-08-016



STOPPING MECHANISM ASSEMBLY
2-543-08-017



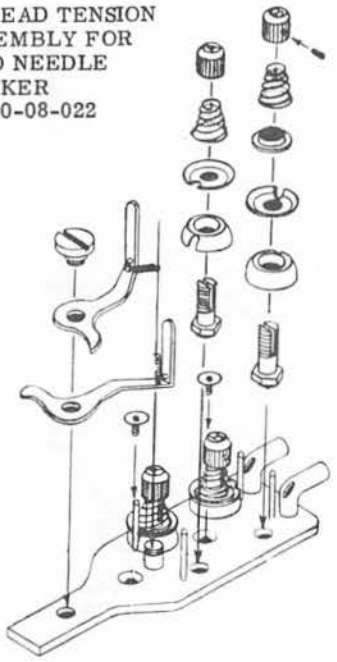
FRONT & REAR STITCH ADJUSTING ASSEMBLY
2-543-08-018

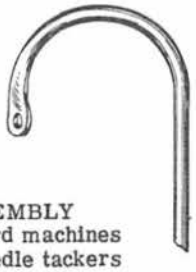
AUTOMATIC LIFT LEVER
ASSEMBLY
2-555-08-019

REAR THREAD
TENSION
ASSEMBLY
2-543-08-020

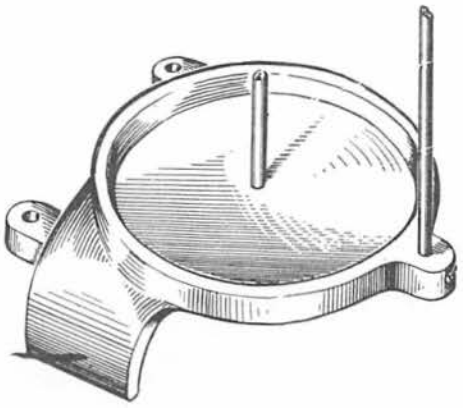
FRONT THREAD
TENSION
ASSEMBLY
2-543-08-021

THREAD TENSION
ASSEMBLY FOR
TWO NEEDLE
TACKER
2-560-08-022





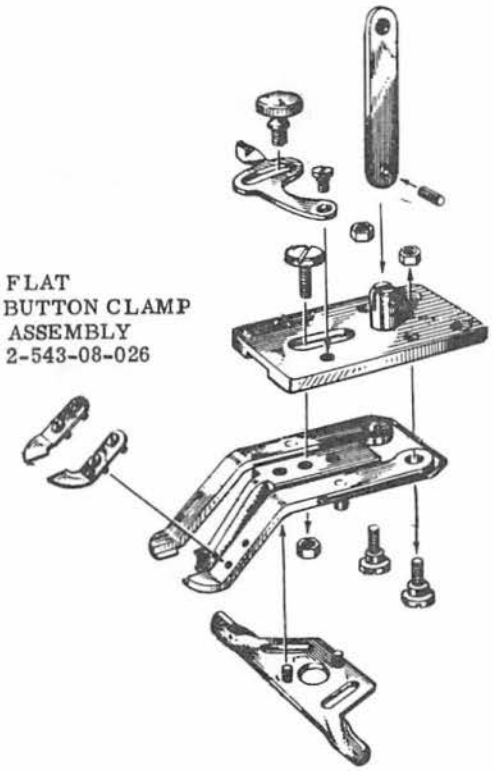
THREAD STAND ASSEMBLY
2-543-08-023 standard machines
2-560-08-023 two needle tackers



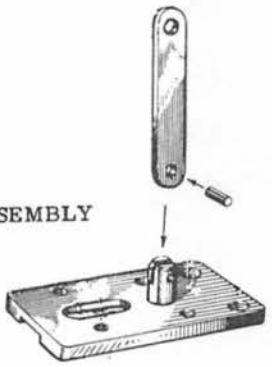
FRONT CAM
ARM ASSEMBLY
2-543-08-024

REAR CAM
ARM ASSEMBLY
2-543-08-025

ASSEMBLY GROUPS



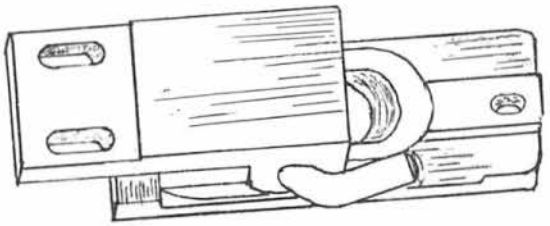
FLAT
BUTTON CLAMP
ASSEMBLY
2-543-08-026



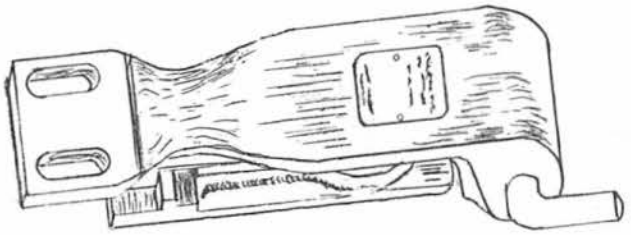
FLAT BUTTON JAW
HOLDING PLATE ASSEMBLY
2-543-08-026A

FLAT BUTTON JAW
ASSEMBLY (one left
& one right)
2-543-08-26B

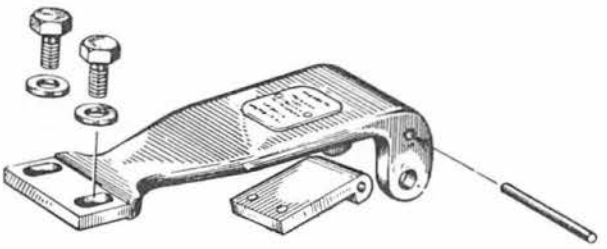
BUTTON CLAMP BASE (short type)1
More stability but less reach.
2-543-08-26C for Flat Buttons
2-543-08-26D for Shank Buttons(casting ears longer)

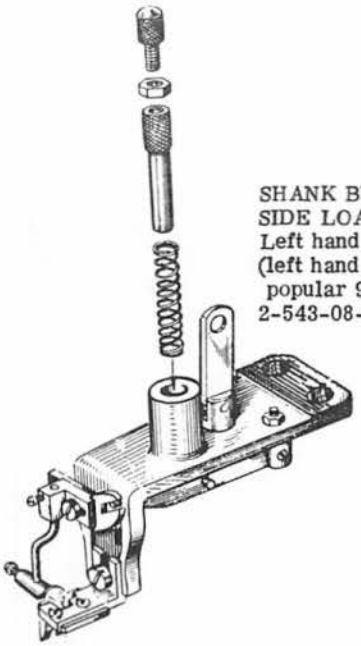


BUTTON CLAMP BASE (long type)2
Less stability, more reach.
2-543-08-026E for flat buttons
2-543-08-026F for Shank Buttons (casting ears longer)

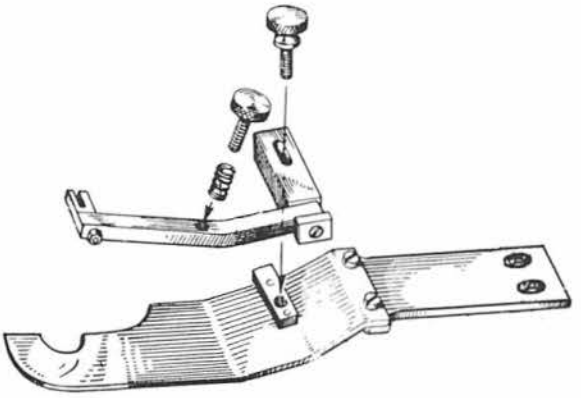


BUTTON CLAMP TOP HINGE ASSEMBLY
2-543-08-027



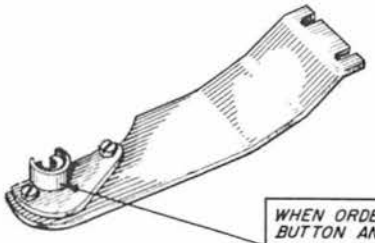


SHANK BUTTON CLAMP ASSEMBLY
SIDE LOADING.
Left hand and right hand loading available.
(left hand loading is shown and is most popular 95% of the time)
2-543-08-027A



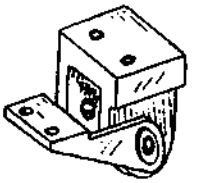
STAY BUTTON CLAMP CLOTH
SUPPORT ASSEMBLY
2-543-08-027C

SHANK BUTTON CLAMP CLOTH
SUPPORT ASSEMBLY
2-543-08-027B

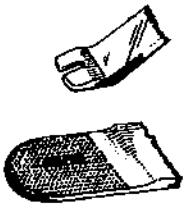


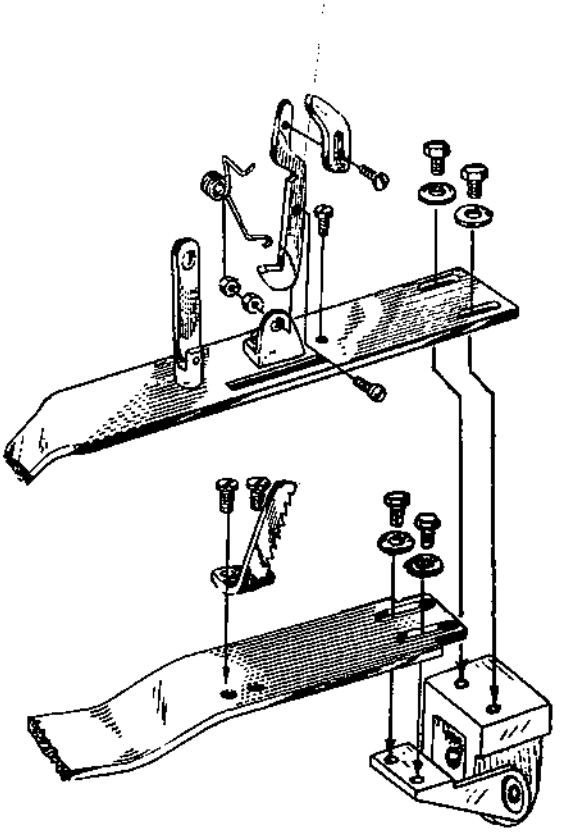
WHEN ORDERING, LINE SIZE OF STAY BUTTON AND SHANK BUTTON MUST BE SPECIFIED IN ORDER TO SUPPLY PROPER CUP SIZE AND HEIGHT.

CLAMP HINGE ASSEMBLY
2-543-08-028

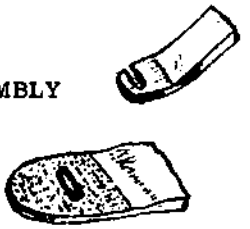


BACK & FORTH TACKING CLAMP ASSEMBLY
2-543-08-029

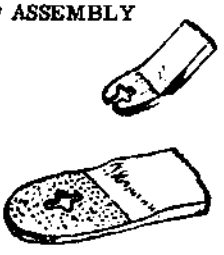




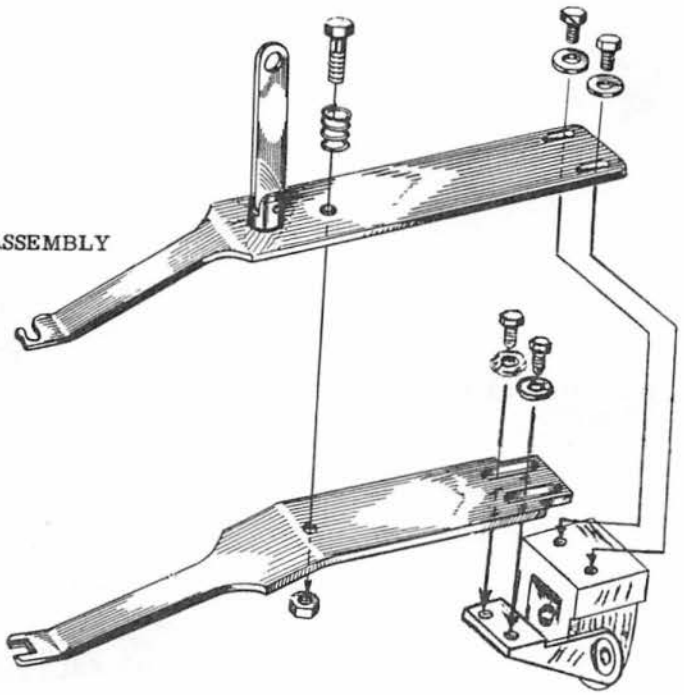
SIDE MOTION TACKING CLAMP ASSEMBLY
2-543-08-030



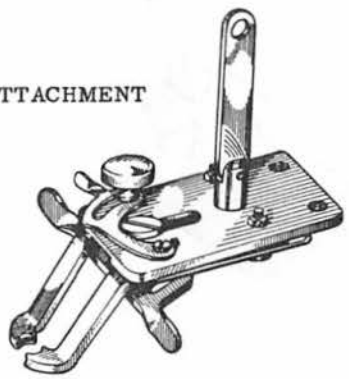
COMBINATION TACKING CLAMP ASSEMBLY
2-543-08-031



SQUARE SNAP ATTACHMENT ASSEMBLY
2-543-08-032



ROUND SNAP ATTACHMENT
ASSEMBLY
2-543-08-033

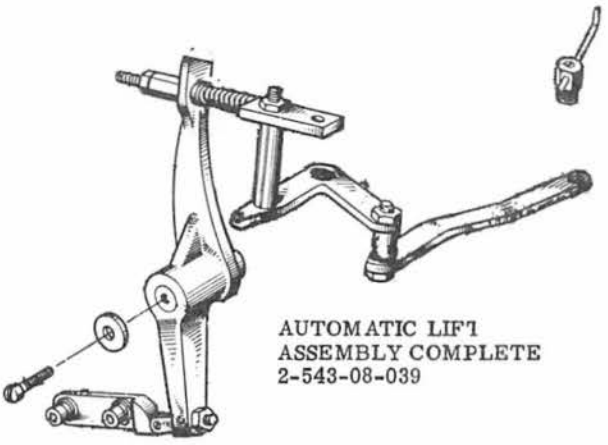


CLAMP SHIFTER
LEVER STUD
ASSEMBLY
2-543-08-035

REBOUND FINGER
ASSEMBLY
2-543-08-036

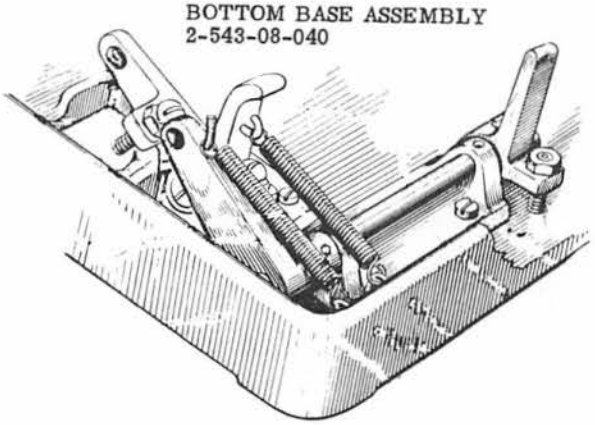
REAR STITCH
INDICATOR ASSEMBLY
2-543-08-037

THREAD SLACK KICKPIN
ASSEMBLY
2-543-08-038

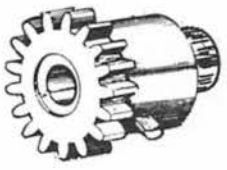


AUTOMATIC LIFT
ASSEMBLY COMPLETE
2-543-08-039

BOTTOM BASE ASSEMBLY
2-543-08-040



GEAR & WORM ASSEMBLY
Specify stitch count
2-543-08-041



ADDITIONAL NOTES:

NEEDLE BARS:
There are three types of needle bars available for the Chandler tackers and button sewers.

1.	543-60	Regular needle bar
2.	543-60A	Special long needle bar for high arm machines, classes 558, 658
3.	543-60D	Special large needle hole for extra heavy needle. Used on many tackers — classes 555-75, 555-75K, 600-75, & 600-75K Needle code: 332lgCF-No. 160

RECOMMENDED NEEDLES:
Use only genuine Chandler needles for best results.

REGULAR:

PBS3-14	very light work
PBS3-16	light work
PBS3-18	medium, heavy work
PBS3-20	heavy work

LONG SHANK: (shank buttons)

PBS7-16	medium
PBS7-20	heavy

DRAPERY TACKER

PB DT-22	Drapery needle for regular needle bar 543-60
332 lgCF No. 160	Extra heavy drapery needle for needle bar 543-60D

RECOMMENDED SPEEDS:
Machine classes 543, 546, & 548 are not to be operated in excess of 1000 RPM. Models 552 and later models can be operated at speeds up to 1500 rpm.

LUBRICATION:
Use a light No. 10 sewing machine oil on all moving parts. We can supply this in quart or gallon cans.

Gears and cam races are lubricated with a special non drying grease which we can also supply. Ask for "Oilzum" grease.