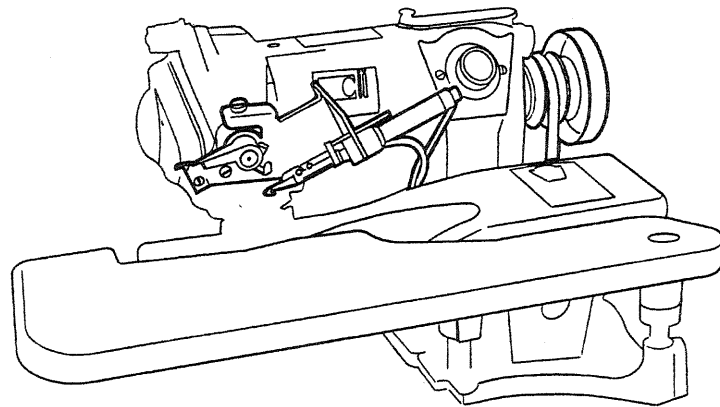
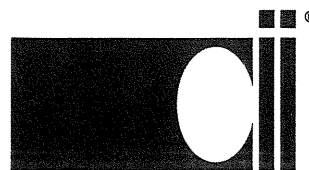


CLINTON
THREAD TRIMMER
MODEL 132
FOR
BLINDSTICH



SERVICE
MANUAL

40-0220-01



Clinton Industries, Inc.
700 Washington Ave.
Carlstadt, N.J. 07072
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Fax: 201-935-3615
Web Site: <http://www.clintonind.com>
Email: general@clintonind.com

I. GENERAL INFORMATION

A. WHAT IT DOES

The 132 Trim system enables the operator to automatically position the needle out of the work, trim the thread on the surface of the cloth and drop the frame of the machine. This eliminates the need to do these operations manually thereby saving time and reducing operator fatigue.

II. POSITIONING MOTOR INSTALLATION

Refer to the motor service manual for installation instructions.

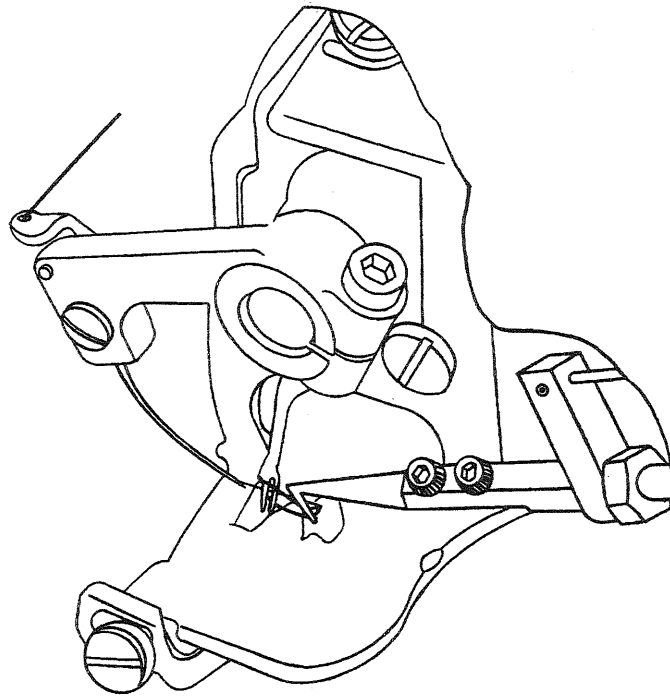
III. TRIMMER AND FRAME DROP INSTALLATION

1. Remove from the machine the front thread guide mounting screw and the right mounting screw of the presser foot plate.
2. Install the main mounting bracket with the longer screws supplied between the front thread guide hole and the right mounting hole of the presser foot plate. (INS-909 or INS-910).
3. Fasten cylinder assembly to main mounting bracket with 01-3061-51 screws (INS-909 or INS-910).
4. Mount the air frame drop on the table with two bolts shown. (INS-790 or INS-839).

IV. ADJUSTMENTS

1. Time the machine with the needle in the desired position as described in the motor service manual.
2. Prior to starting any knife adjustments, insert the work underneath the presser foot, sew a few inches and position the needle to the up position.
3. To adjust the knife assembly loosen the two mounting screw 01-3061-51 on the air cylinder bracket and proceed with the following steps:
 - a. Adjust the knife assembly so that on the down stroke of the air cylinder the thread loop is deflected around the hook point of the cutting edge of the knife as shown in INS-791-1 and INS-791-2.
 - b. Adjust the knife assembly so that on the return stroke of the air cylinder the knife will pick up both sides of the thread loop and cut only the lower thread of the loop formation as shown in INS-791-2 and INS-791-3.
 - c. Adjust the knife by loosening screws marked "A" to make sure that the point of the knife does not strike the presser foot plate at the end of the air cylinder stroke. INS-791-3.

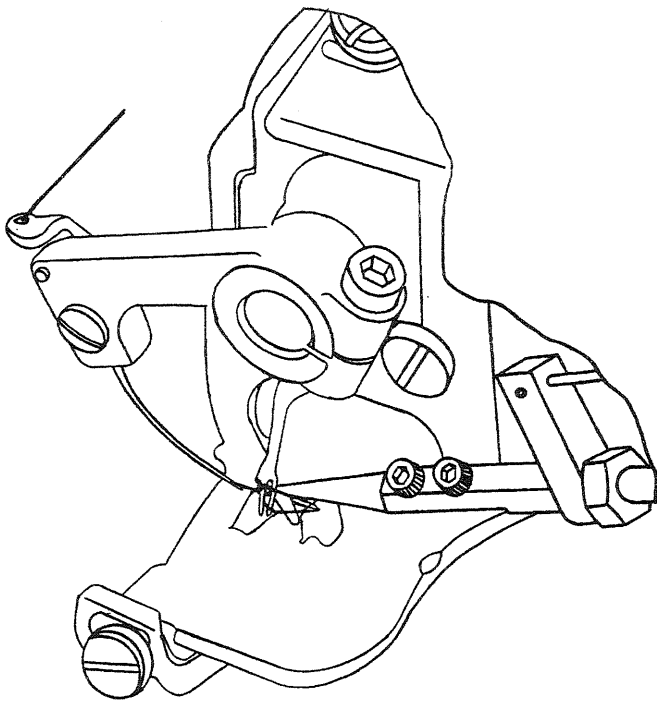
TRIMMER MODEL 132



KNIFE ON FORWARD STROKE DEFLECTING THREAD

TRIMMER MODEL 132

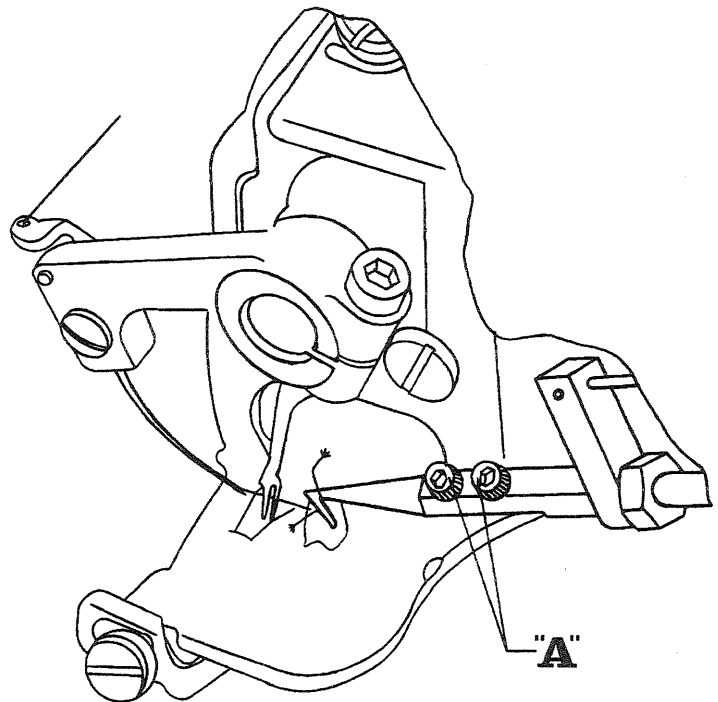
INS-791-2A



KNIFE FULLY EXTENDED

TRIMMER MODEL 132

INS-791-3A



KNIFE CUTTING ON RETURN STROKE

V. TROUBLESHOOTING

PROBLEM	CAUSES	CORRECTIVE ACTION
Thread not cut	Defective or broken knife	Replace
	Defective solenoid air valve	Replace
	Low air pressure	Check regulator and air supply
Thread cut short	Sharp edge or burrs on front edge of knife cutting thread on forward stroke	Remove sharp edge and burrs then polish
	Knife misadjusted picks up and cuts on rear side of "V" stitch formation	Readjust knife. Thread must be cut on front side of "V" stitch formation. See INS-791-2
Thread cut short due to short stroke of cylinder misadjusted knife	Knife not adjusted for enough forward therefore it will pick up and cut the rear side of the "V" stitch formation	Readjust the knife to pick up the thread as shown in INS-791-2
	Low air pressure	Check regulator and air supply
Knife strikes the looper or does not pick up the threads due to incorrect positioning	Needle positioning out of time	Retime synchronizer

TRIMMER ASSEMBLY MODEL 132

80-0212-01 ADAMSON, CHANDLER M60, REX, BROTHER-B935
U.S. BLINDSTITCH 88, 99, 518, 718 & 1118, SUNCO 618
80-0212-02 LEWIS, REECE LWX6T
80-0212-03 AMERICAN & SINGER BLINDSTITCH
80-0212-05 UNION SPECIAL 37500
80-0212-06 U.S. BLINDSTITCH 1200SF
80-0212 07 MAIER 241

EXISTING SCREW
MAIER 241
01-3061-21
SCREW
01-4555-01
SPACER
AMER. & SINGER

01-4977-04
MTG. BRACKET
U.S. B.S. 1200SF

01-4977-01
MTG. BRACKET
U.S. BL. STITCH
ADAMSON
& SUNCO 618

01-4977-02
MTG. BRACKET
AMERICAN
& SINGER

01-4980-01
MTG. BRACKET
LEWIS &
UN. SP. 37500

01-4977-05
MTG. BRACKET

EXISTING SCREW
MAIER 241

01-3061-21
SCREW
U.S. BL. STITCH

01-3061-11
SCREW

01-4979-01
BLADE

01-5048-02
U.S. B.S. 1200SF

01-5049-01
BRACKET

33-0106-04
SCREW P.H.M.S.

01-5048-01
GUARD

33-3104-04
SCREW S.H.C.S.

01-1622-51
SPACER
U.S. BR. 1200SF

01-4972-01
BRACKET

01-5024-01
SPACER
UN. SP. 37500

01-3061-51
SCREW

33-0106-04
SCREW P.H.M.S.

33-2105-02
SCREW S.S.S.

01-4976-01
ROD

30-2955-125
FITTING

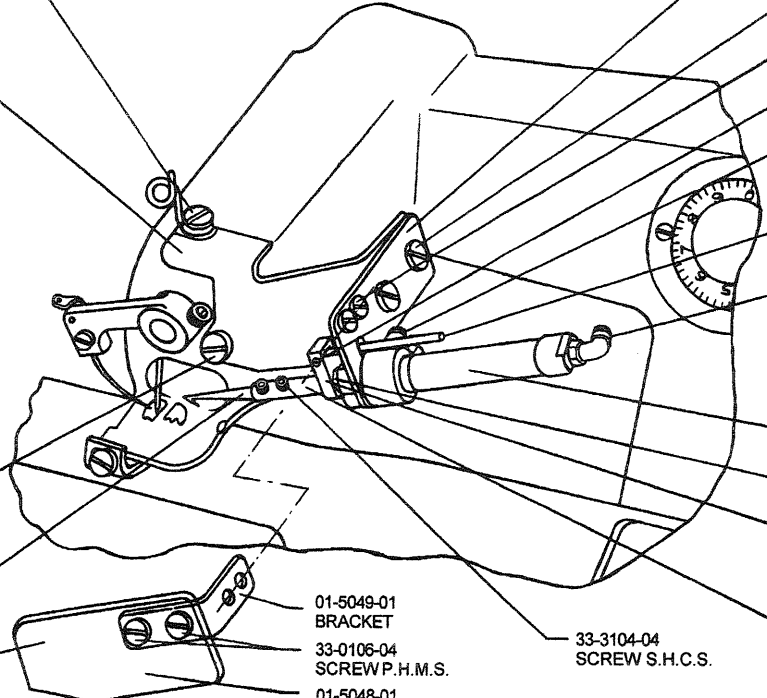
30-2954-125
ELBOW

30-0816-01
AIR CYLINDER

33-1610-01
HEX NUT

01-4975-01
BLOCK

01-4974-01
ADAPTER



TRIMMER ASSEMBLY MODEL 132

U.S. BLINDSTITCH BOOKSEAM
80-0212-04

33-0106-04
SCREW P.H.M.S.

01-4977-03
BRACKET

01-3037-11
SCREW

01-4984-01
BRACKET

01-4979-01
BLADE

01-5049-01
BRACKET

33-0106-04
SCREW P.H.M.S.

01-5048-01
GUARD

01-4972-01
BRACKET

01-3061-51
SCREW

30-2955-125
FITTING

30-2954-125
ELBOW

30-0816-01
AIR CYLINDER

01-4976-01
ROD

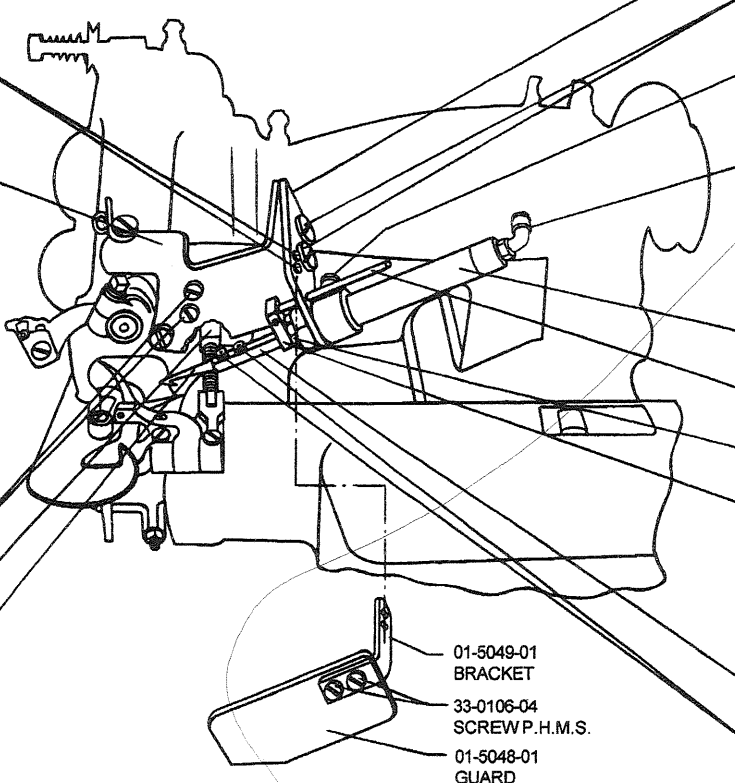
33-1610-01
HEX NUT

01-4975-01
BLOCK

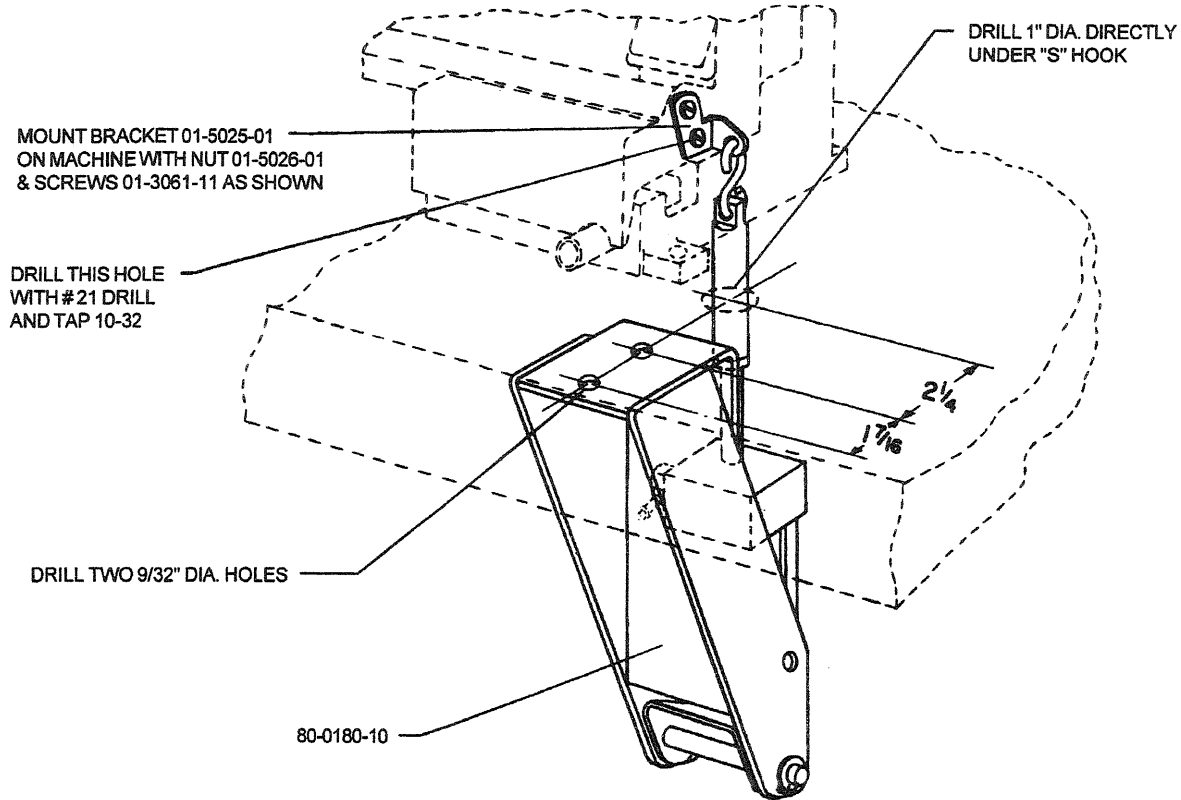
33-2105-02
SCREW S.S.S.

01-4974-01
ADAPTER

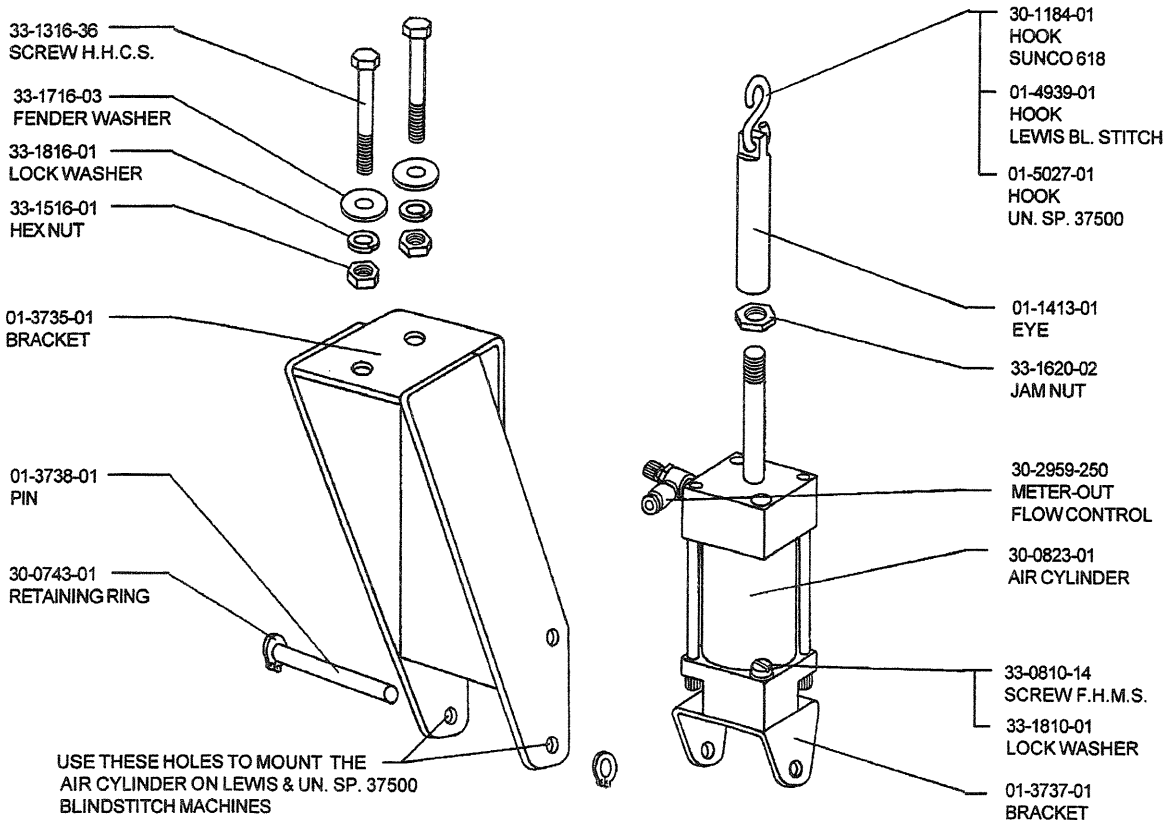
33-3104-04
SCREW S.H.C.S.



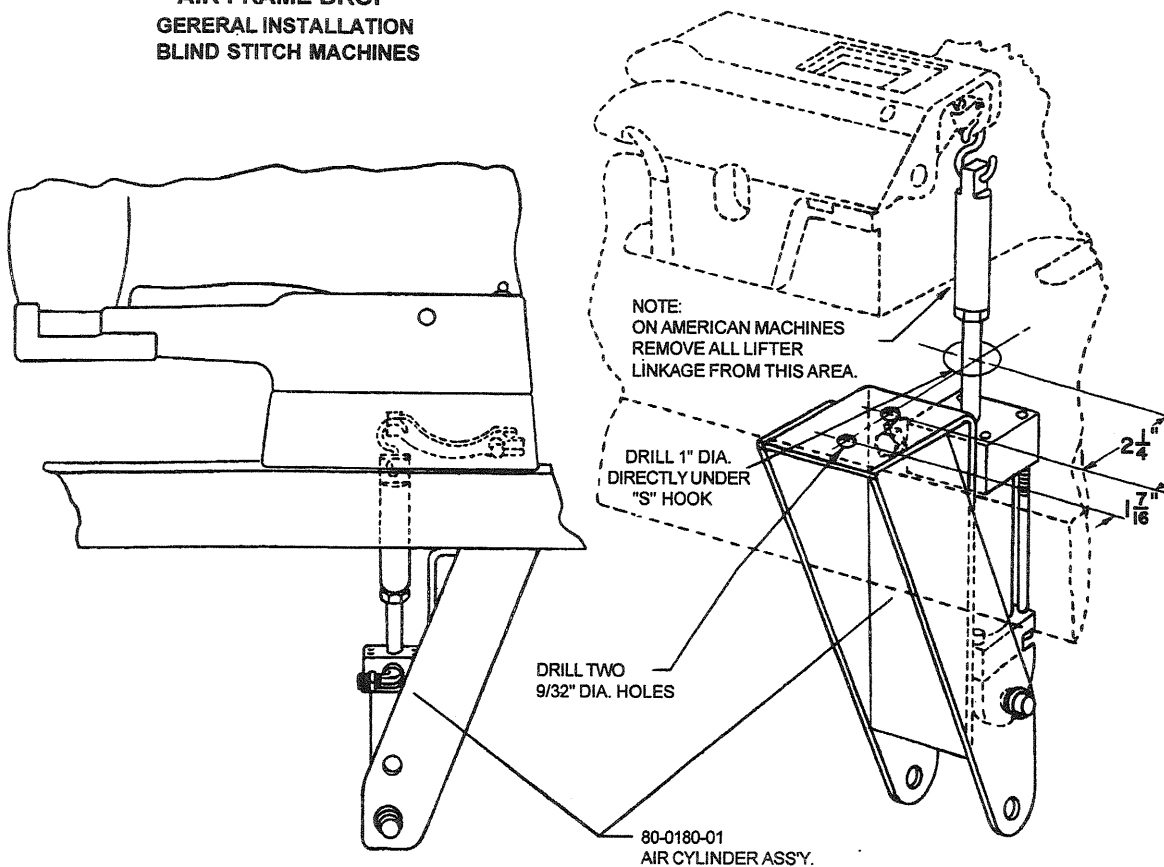
**AIR FRAME DROP
UNION SPECIAL BLINDSTITCH 37500**



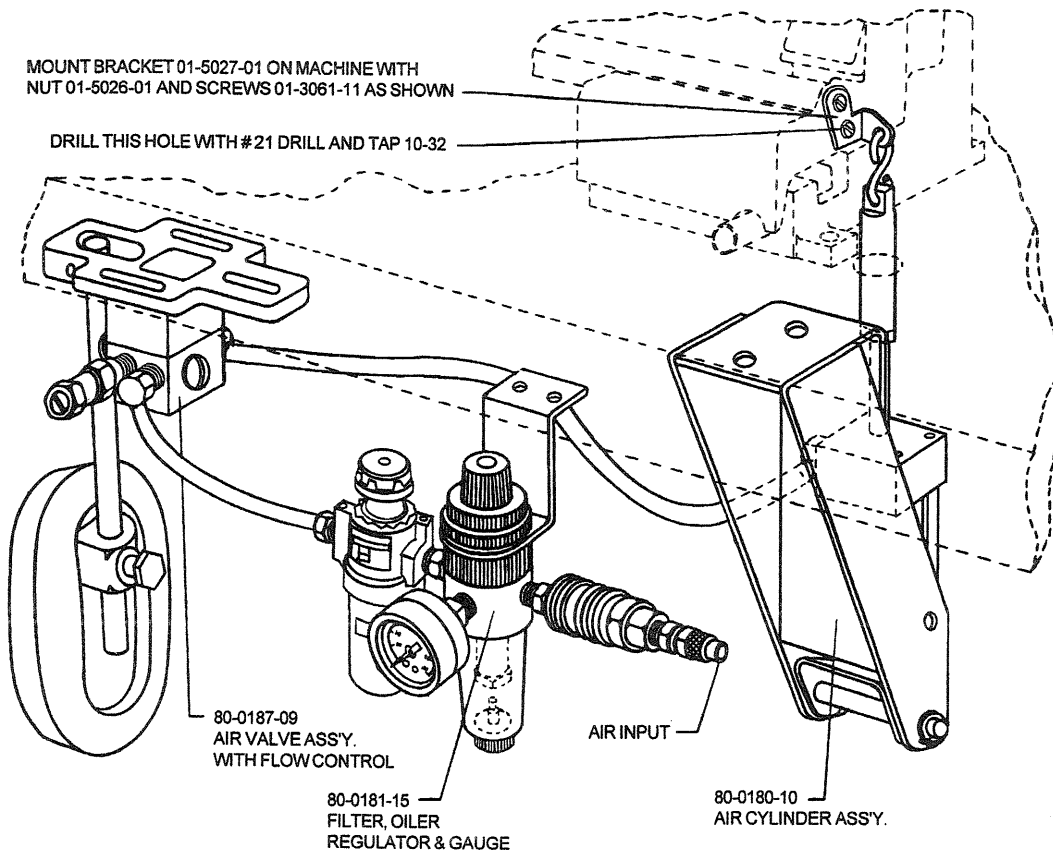
**AIR CYLINDER ASSEMBLY FRAME DROP
80-0180-01 LEWIS, YAMATO CM-203, PLUSHMASTER, REX, SUNCO, U.S. BLINDSTITCH, REECE LWX6T
80-0180-10 U.N. SP. 37500**



**AIR FRAME DROP
GENERAL INSTALLATION
BLIND STITCH MACHINES**

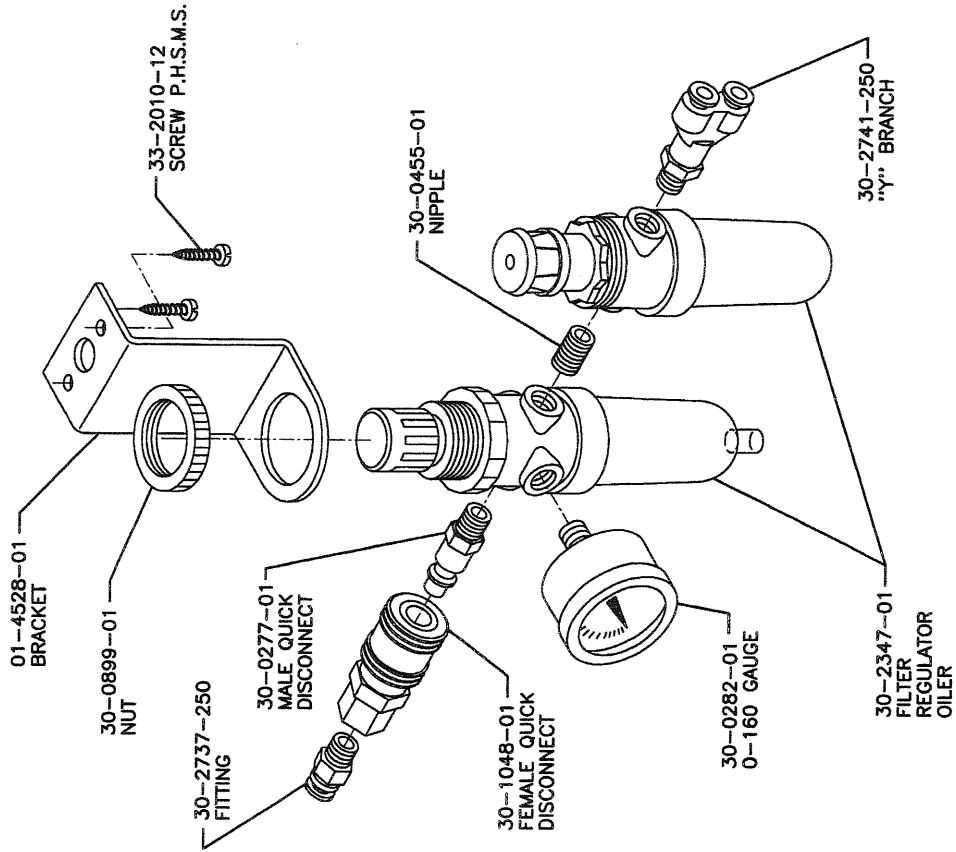


**AIR FRAME DROP (KNEE ACTUATED)
UNION SPECIAL BLINDSTITCH 37500**



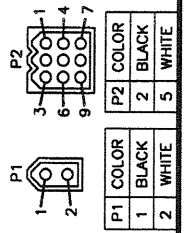
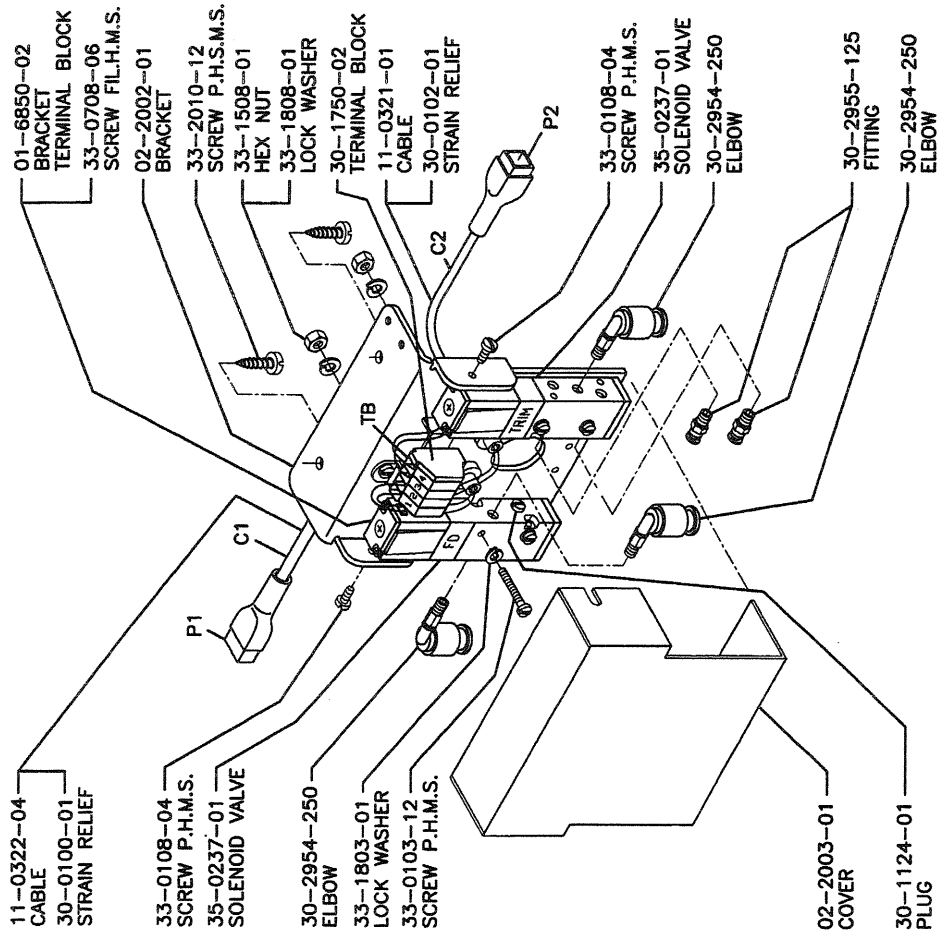
INS-570-17

F.O.R.G. ASSEMBLY
MODEL 132
80-0181-31



INS-2612

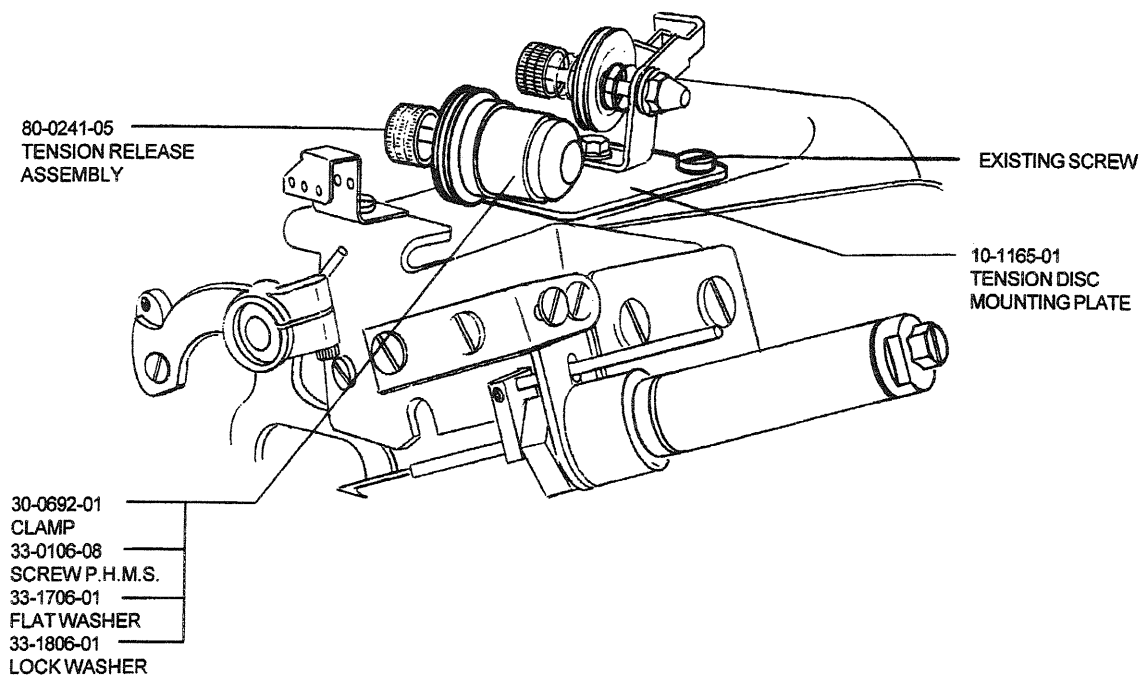
SOLENOID VALVE ASSEMBLY
MODEL 132
81-0883-01



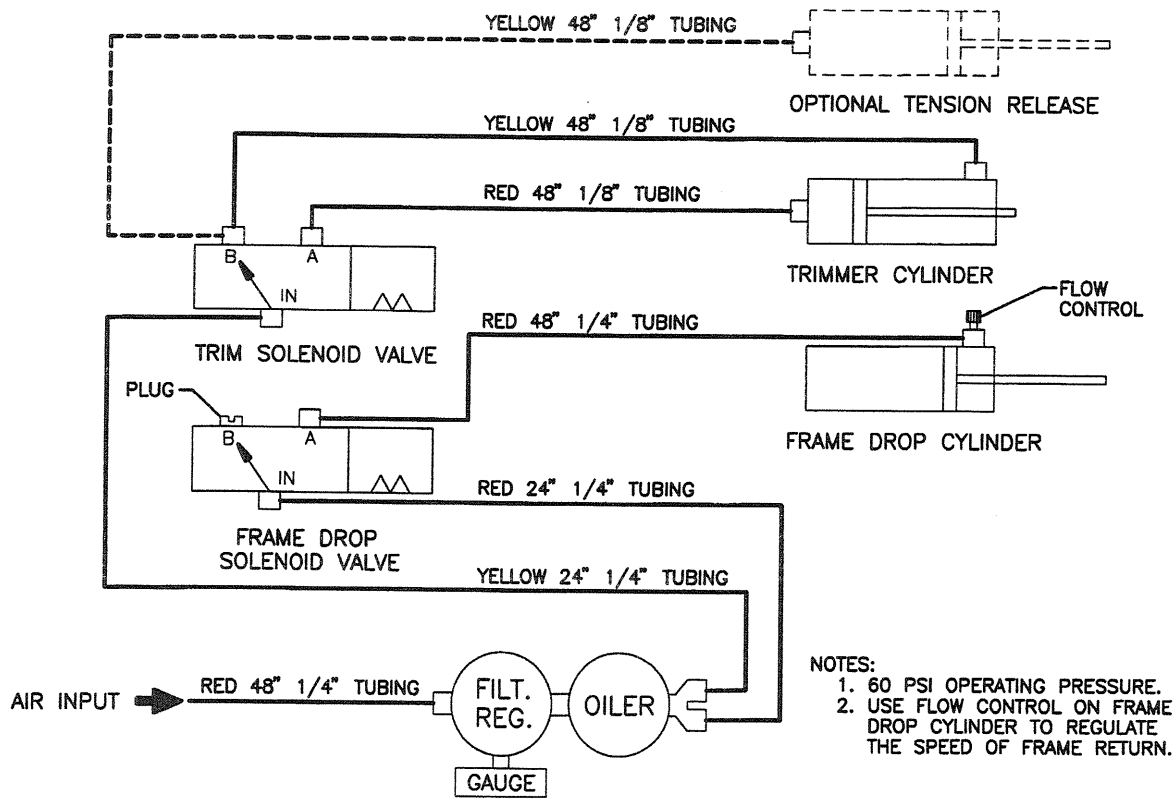
4	RED	WHITE
3	BLK	BLACK
2	RED	WHITE
1	BLK	BLACK
TB	FD TRIM	C1 C2

SOLENOID WIRING TABLE

**TENSION RELEASE ASSEMBLY
MODEL 132 FR
80-0449-01**



**AIR CIRCUIT DIAGRAM
MODEL 132**



- NOTES:**
1. 60 PSI OPERATING PRESSURE.
 2. USE FLOW CONTROL ON FRAME DROP CYLINDER TO REGULATE THE SPEED OF FRAME RETURN.