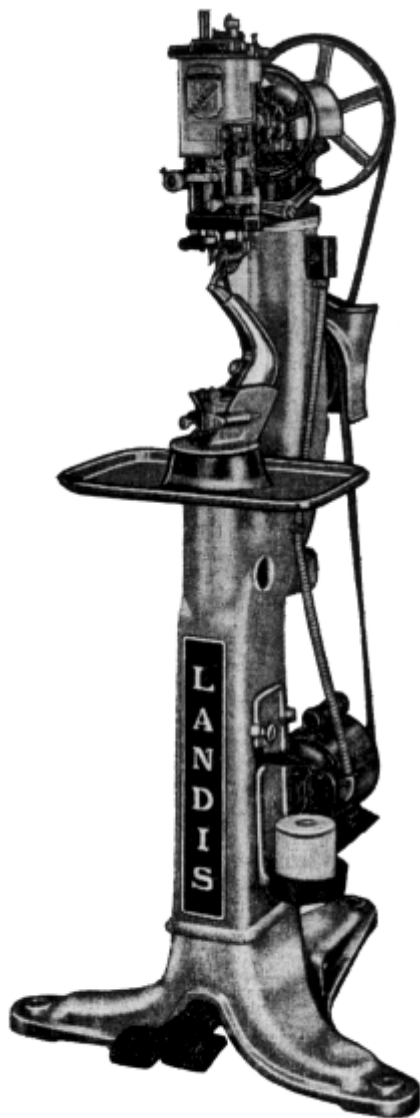


INSTRUCTIONS TO OPERATORS

LANDIS CHAINSTITCH MCKAY STITCHER

Model "77"
CATALOGUE OF PARTS



Shoe Systems Plus, Inc.
249 W Main Street
Goshen, NY 10924
1-800-354-6278

**MODEL "77" CHAINSTITCH
INTRODUCTION**

The Landis Model "77" Chainstitch McKay Stitcher is the result of many years of experience in the design and manufacture of shoe machinery, and has been especially designed to fit the needs of the shoe rebuilder of today and to enable him to increase his business through the repair or resoling of ladies' shoes.

The Model "77" McKay Stitcher is simple in design, constructed of the finest materials and manufactured with unusual accuracy, which is conducive to low cost of operation and low upkeep. In order to get the benefit of the features of this Stitcher the only necessary contribution by the operator is reasonable care in preparing and fitting up his work. If this is done in a first-class manner, excellent results will be obtained.

When sewing on the Model "77" McKay Stitcher no anxiety need be felt on the part of the operator should small trifles arise at times, which can be eliminated by consulting the following instructions which will enable you to care for your machine properly and keep it in perfect adjustment. For your particular benefit, it is desired that you familiarize yourself as much as possible with the operation of the machine. The following instructions will be of considerable assistance towards helping you in maintaining, adjusting and operating your machine. Remember that the Model "77" McKay Stitcher is a quality built machine, as are all Landis Machines. Clean it, oil it, and it will render you perfect service.

The Faycott Landis Machine Corp. will continue to manufacture the Model "77" McKay Stitcher as a Landis Product and we reserve the right to make changes or improvements at any time, without thereby incurring any obligation either to install the same on machinery or equipment previously sold, or install the old part, which has been changed, improved or omitted in new machines or equipment subsequently sold. Prices and equipment subject to change without notice.

FAYSCOTT LANDIS MACHINE CORP.

GENERAL INSTRUCTIONS

Keep your machine well oiled. Use a good grade of Oil. We recommend Landis Stitcher Oil.

Always use a good grade of Liquid Wax. We recommend Landis Yellow Label-Al-Liquid Wax for McKay Stitchers.

All Model "77" McKay Stitchers are carefully adjusted at the factory by experts who are competent on these machines, and they are shipped to you ready for operation.

All parts are of the highest grade material possible to purchase for their purpose and are inspected to insure interchangeability so that all repair parts fit into place without fitting or difficulty.

How To Order Parts for Quick Delivery

1. Give the complete part number of the part needed and quantity.
2. Give the Model and Serial Number of your machine.
3. Write your name and address as plainly as possible.
4. Prices of parts do not include postage or insurance. This is extra. Parts are usually shipped parcel post insured.
5. Prices are subject to change without notice.

NOTE: When mailing parts to Factory - be sure to write your name and address plainly on the package. Also write your name and address on your letter explaining why goods are being sent to the factory.

SETTING UP MACHINE

After the Model "77" McKay Stitcher is uncrated and placed in position where it will be used, place motor extension cord plug in electric light socket and machine will be ready to operate.

Machines are carefully oiled before leaving the factory, but should also be oiled carefully before operating.

THREADING THE WAX POT AND HORN

Put spool of thread on Thread Holder. Put Thread up through first hold in Thread Unwinder Rod and wrap thread half way around Rod and up through second hole in rear of Thread Unwinder Rod. Bring Thread up through Horn Spindle, by using the long straight Thread Hook furnished. To do this remove Wax Pot and push Thread Hook down in small hole found below the Wax Pot to the bottom of Horn Spindle, loop Thread around barb of Thread Hook and pull up through hole, then replace the Wax Pot. Place Thread in Tension and over Thread Roll to Wax Pot, down through Lower Wax Pot Roll, then up through Wax Pot Stripper, through Thread Guide Pin and under Horn Thread Roll and up Horn to small hole in Whirl. A small curved Thread Hook will be found in the supply package. (See Figure No. 1).

LIQUID WAX - CLEANING WAX POT

Stir Liquid Wax thoroughly before putting it in Wax Pot. Use "thinner" to thin wax when too thick or heavy. Order Landis Yellow Label Machine Cleaner & Wax Thinner available in pint and quart cans.

CAUTION: Do not put oil in wax pot.

Remove Wax Pot at least once a week and clean thoroughly with kerosene or coal oil. Keep thread rolls free from old or dried wax. (See Figure No. 1).

SIZE OF THREAD AND NEEDLE

In general practice a No. 33 Needle and 4 Cord right twist Thread will usually be found satisfactory.

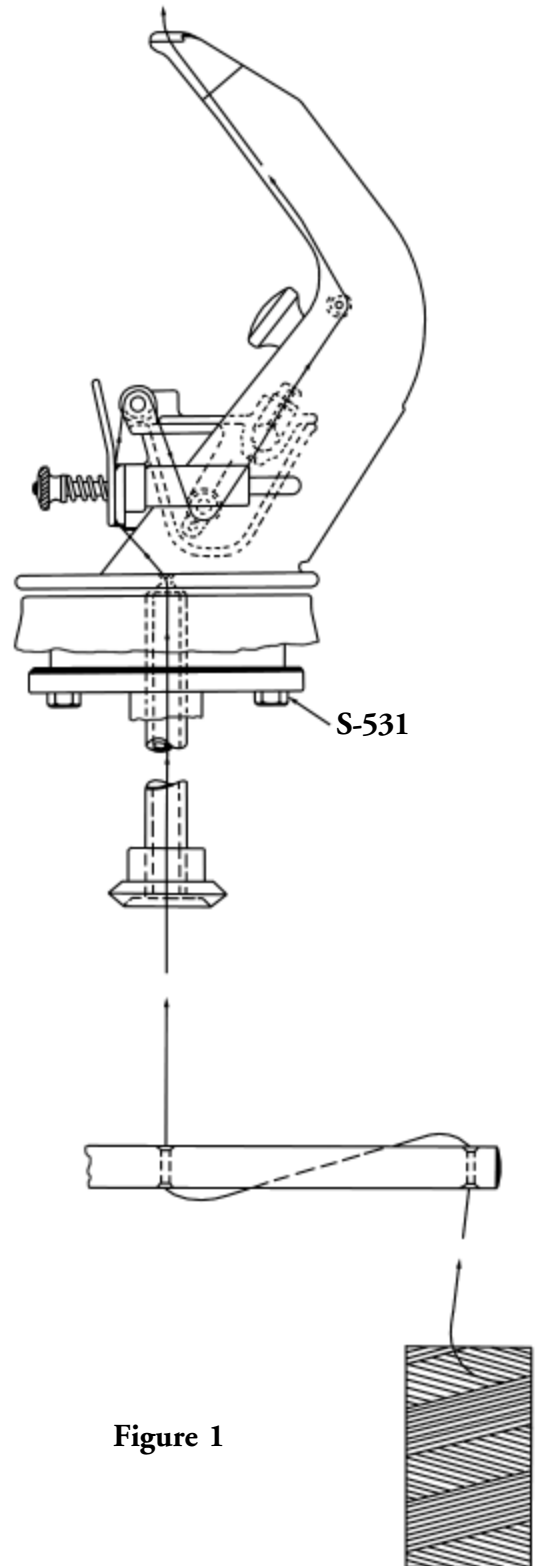


Figure 1

TO SET NEEDLE

Turn machine until Needle Bar is at its lowest position. Adjust needle until it projects slightly below bottom of whirl. The Needle should be set so that the Whirl lays the thread in the barb groove of the Needle as it revolves around the Needle, much on the order of the Loper on the Curved Needle Stitcher. (See figure No. 2).

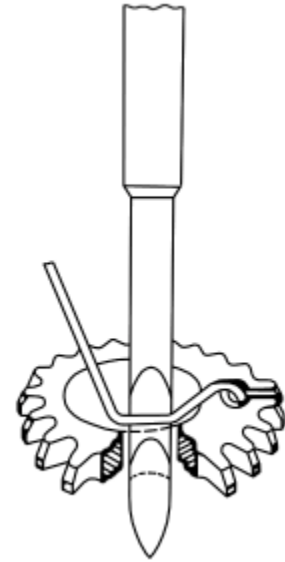


Figure No. 2

PLACING THE FEED POINT

Place Feed Point S-191 so that it extends $3/64$ " below bottom of Presser Foot S-130 when Feed Socket S-190 is at its lowest point. (See figure No. 3).

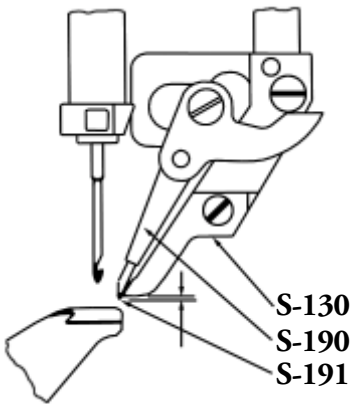


Figure No. 3

NEEDLE BAR FRICTION

For more friction, turn Adjusting Screw (in top of Main Head) to the right; for less friction, turn screw left. This Friction Screw is adjusted at the factory and requires little attention. It is used to hold Needle Bar in place when Latch is released. A few drops of oil should be placed in Oil Hole each day.

CAST-OFF FRICTION

The Cast-Off Friction is adjusted at the factory so the Cast-Off Block can be moved up and down with the fingers without moving the Cast-Off Rod. For more friction, turn Adjusting Screw in Cast-Off Friction Holder to right; for less friction, turn Screw to left. A few drops of oil should be placed in Oil Hole each day.

SETTING THE CAST-OFF

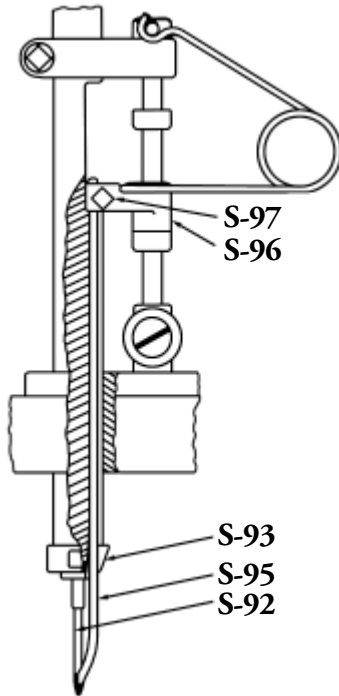


Figure No. 4

The adjustment of the Cast-Off S-95 is important. The Cast-Off Point must be set low enough to completely cover the barb of the Needle S-92 as the Needle pulls the thread up.

To adjust Cast-Off up or down, loosen Cast-Off Screw S-97, raising or lowering the Cast-Off to the desired position, and afterward tightening the screw. (See figure 4).

The correct relation of the Cast-Off to the Needle is that it just clears the side of the Needle. To test this relation, raise and lower the Cast-Off repeatedly by lifting on Cast-Off Block, S-96. If too close, the Cast-Off will spring the Needle sideways. To correct this, spring the Cast-Off a little away from the Needle. Pliers will be found in the supply package for this purpose. Should the Cast-Off be too far from the Needle, remove the Needle, spring the Cast-Off in as much as necessary.

TO REMOVE AND REPLACE CAST-OFF: Loosen Cast-Off Set Screw (S-97). Loosen and take off Needle Clamp Collar S-93, remove Cast-Off. To replace Cast-Off, insert Cast-Off in Cast-Off Block, tighten Set Screw and replace Needle Clamp Collar. (See figure No. 4).

ADJUSTMENTS FOR ELIMINATING THE SKIPPING OF STITCHES

See that the following are in proper adjustment:

- Timing of Whirl (See Page 8)
- Setting of Needle (See Page 4)
- Setting of Cast-Off (See Page 5)

LENGTH OF STITCH - ADJUSTMENT OF FEED

The usual practice is to use about 4-3/4 stitches per inch. Should you desire to sew more or less stitches per inch, loosen the Hexagon Screw S-260 on Feed Cam S-255. Turn Adjusting Screw S-259 on Movable Cam S-256 in for more stitches per inch and out for less stitches per inch. After adjustment is made, press Movable Cam and Feed Cam together and tighten Hexagon Screw. (See figure No. 5).

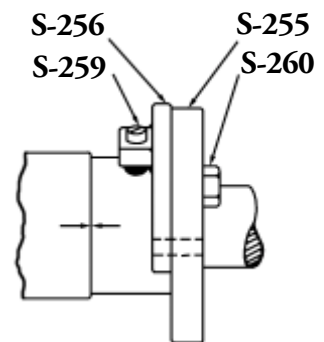


Figure No. 5

CAUTION:

Before mounting the sole on a shoe, it will be well to find and pull out two to four staples, which will be found near the beginning of the toe curvature, where the upper puckers worst. These staples were put in to hold the sole before the first McKay sewing. These staples will interfere with sewing and may even break the needle. They are generally a little outside the row of lasting tacks.

STITCHING SHOES

Shoes are stitched in the same order as on your other stitching machine; that is to say, the shoe is put on the horn with the heel to the left and the stitches started in the shank, stitching up and around the toe, turning the heel of the shoe from left to right, with the heel towards the operator, then sewing down the opposite side of the shoe to the shank with the heel on the right. You will find this procedure extremely easy.

With the different types of shoes, namely Welt, McKay and Turn, it will be found necessary to stitch at different distances from the edges of the inner sole.

On McKays, the usual practice is to stitch along the old line of stitching if the make-up of the shoe enables the line of stitching to catch the upper.

In stitching the Turn shoe, it is desirable to stitch outside of the inside channel of the turn shoe in order to catch the upper.

In stitching the Welt shoe, it is desirable to stitch as close to the edge of the inner sole as the Horn will permit. The same applies to the stitching of cement shoes.

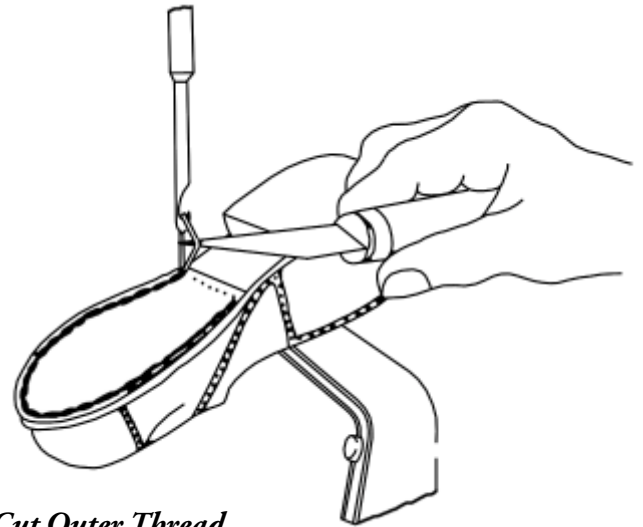
It might be well to mention the fact that often on McKay shoes the uppers are not drawn or lasted as close to the shank as they should be, in which case it would be good practice to sew a little outside the regular line of stitching to catch the upper.

NOTE: With the channel cut the proper distance from the edge, this difference of stitching from the edge of the inner sole can be accomplished by simply tipping the shoe up in back or down in front, as the case may require, much on the order of the Straight Needle Stitcher. The tipping of the shoe has the desired effect of setting the stitches in on the insole or out as may be desired.

Ordinarily the stitching is accomplished by simply holding the shoe in its place on the horn and the presser foot in the groove, letting the machine feed the shoe around.

As for sewing the channel, and the general handling of stitching, you will find the Model "77" McKay Stitcher without doubt the easiest simplest machine to operate and you will find it extremely so in sewing in the channel and around the toe. There is such a marked difference between this and other machines that it is quite noticeable.

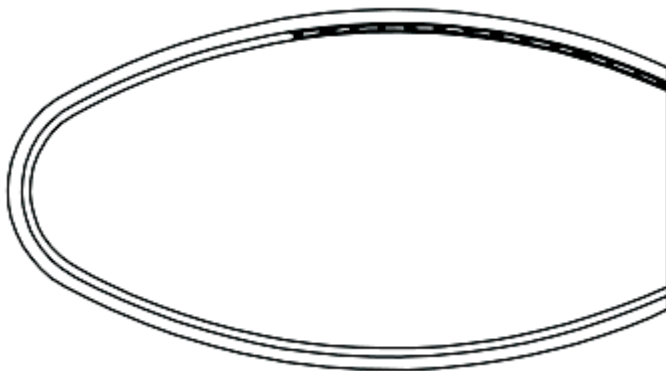
After stitching, cut the front thread of the needle loop, the thread nearest you, close to the work, raise the presser foot and remove the shoe. (See figure No. 6).



*Cut Outer Thread
When Sewing Is Finished*

Figure No. 6

ALOFT WORK



ALOFT STITCHING is easily accomplished with the Aloft Channel Groover which is easy to operate, the channel operation requiring but a second or two, and when properly done, it permits of practically closing the grooved channel over the thread. (See figure No. 7).

The Aloft Presser Foot should be inserted when stitching aloft. This Presser Foot can be used for any other type of channel work. You will find aloft stitching extremely simple.

THREAD

It is highly important that a good grade of right twist thread be used, and should you experience difficulty in breaking thread, examine and test your thread.

SIZES OF THREAD AND NEEDLES

For all ordinary purposes, it has been found that No. 33 needle and 4 cord right twist thread is very satisfactory. Should it be desired to use a different size needle and thread, the chart below will show the sizes of needles to be used with different sizes of thread.

We recommend needles and right twist thread as follows:

NEEDLE SIZES	33	34	35	36
THREAD USED WITH	4 cord	5 cord	6 cord	7 cord

THREAD TENSION

To increase the Tension, turn Tension Thumb Nut S-583 to the right, and to decrease, turn to the left. (See figure No. 8).

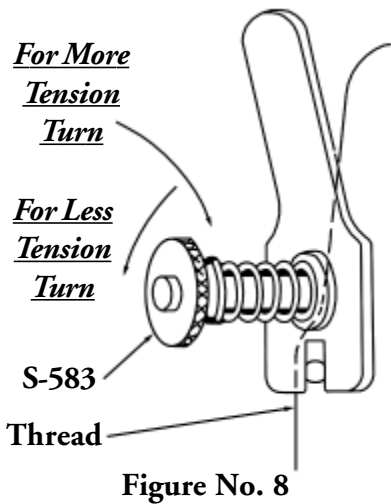


Figure No. 8

WAX STRIPPER ADJUSTMENT

To replace Wax Stripper S-573, remove Stripper Screw S-574 and take out old Stripper, insert new Stripper and replace Stripper Screw. (See figure No. 9).

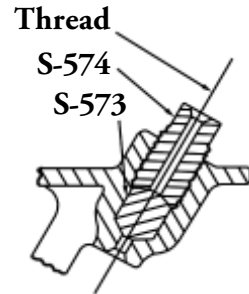
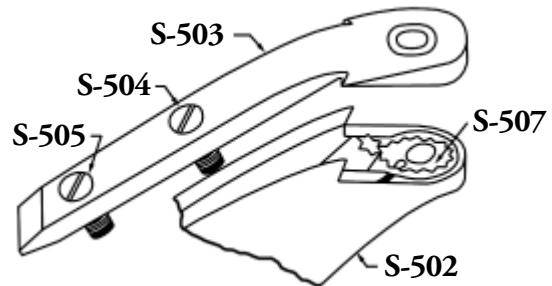


Figure No. 9

CAUTION: Do not tighten rubber stripper too tight as this tends to increase tension.

TO REMOVE WHIRL

Remove the Horn Cap S-503 by taking out two Fastening Screws, S-504 and S-505, so that the Horn Tip S-502 can be raised enough to allow removal of Whirl. (See figure No. 10).



Set thread hole in whirl in line with mark on horn tip. The outer edge of pinion tooth in mesh, is even with top of whirl.

Figure No. 10

TO REPLACE AND TIME WHIRL

Care must be taken to see that the Whirl S-507 is correctly timed. Two settings of the machine are necessary. 1st - Revolve the machine by hand until the arrow on the Feed Cam S-255 coincides with the Arrow on the Main Head (See figure No. 5). 2nd - Set the Horn at the left until the marks on the Horn and Horn Table coincide. (See figure No. 11).

With these settings arranged, insert the Whirl so that the small hole in Whirl coincides with mark on Horn Tip (See figure No. 10). Push the Horn Tip down, replace Horn Cap and fasten securely with two Screws.

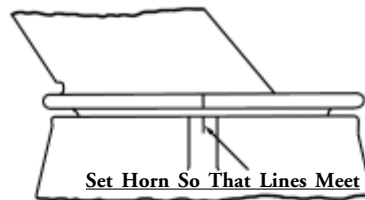


Figure No. 11

TO CHANGE PINION

Take out the two Fastening Screws S-504 and S-505, remove Horn Tip S-502 and Horn Cap S-503; the Pinion S-508 may now be lifted out and replaced with a new one.

Be sure that the new Pinion meshes with the Whirl S-507 properly. (See cut for Pinion Adjustment).

Replace the Horn Tip and Whirl. Be sure Whirl is correctly timed as previously described. Replace Horn Cap and fasten with two Screws. (See figure No. 12).

ADJUSTING PINION

To adjust Pinion S-508, remove Horn Rear Curved Plate S-555, which will permit access to Pinion Adjusting Screw S-510.

To raise Pinion turn Adjusting Screw to the right; to lower Pinion, turn Adjusting Screw to the left. Pinion and Whirl teeth should mesh, and turn freely. (See figure No. 13).

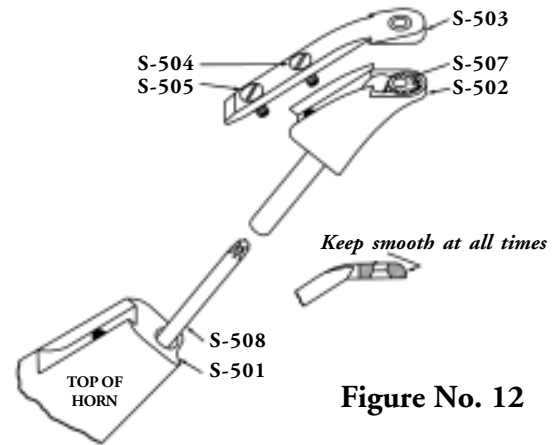


Figure No. 12

HORN CAP

The top of the Horn Cap should be kept smooth at all times, also the hole should be dressed out smooth with emery cloth if at any time it is nicked or burred.

If not perfectly smooth, the thread may catch on sharp edges and strand. (See figure No. 12).

ALIGNMENT OF HORN

The Horn is lined up at the factory. Should the occasion arise at any time for re-alignment, it can be accomplished by the following procedure:

Loosen four Screws S-531 under Horn Table slightly, which will permit tapping the Horn to correct alignment. Tap into a central position so that hole in Horn Cap runs true. After firmly tightening Horn Holding Screws, you can check the position by putting needle down into the Whirl and see that it does not rub on the side of the hole in Whirl. (See figure No. 14).

CLEANING HORN

IMPORTANT: Take off Horn Cap S-503 each day after you are finished sewing and clean Whirl, Pinion and Rollers with kerosene. Your machine will be ready for work the next day and this will eliminate any difficulty from hard and gummed wax.

On the LANDIS McKay Stitcher Model "77" the Horn is separated in three parts to provide easy cleaning and threading.

Horn S-501

Hole for Screw S-556

Hole for Cover Plate S-555 in Back of Horn

To Adjust Pinion S-508 Up, Turn Screw S-510 to Right

To Adjust Pinion S-508 Down, Turn Screw S-510 to Left



Figure No. 13

When Horn is Centrally Located, the Whirl Will Not Rub Needle

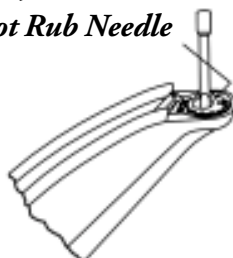
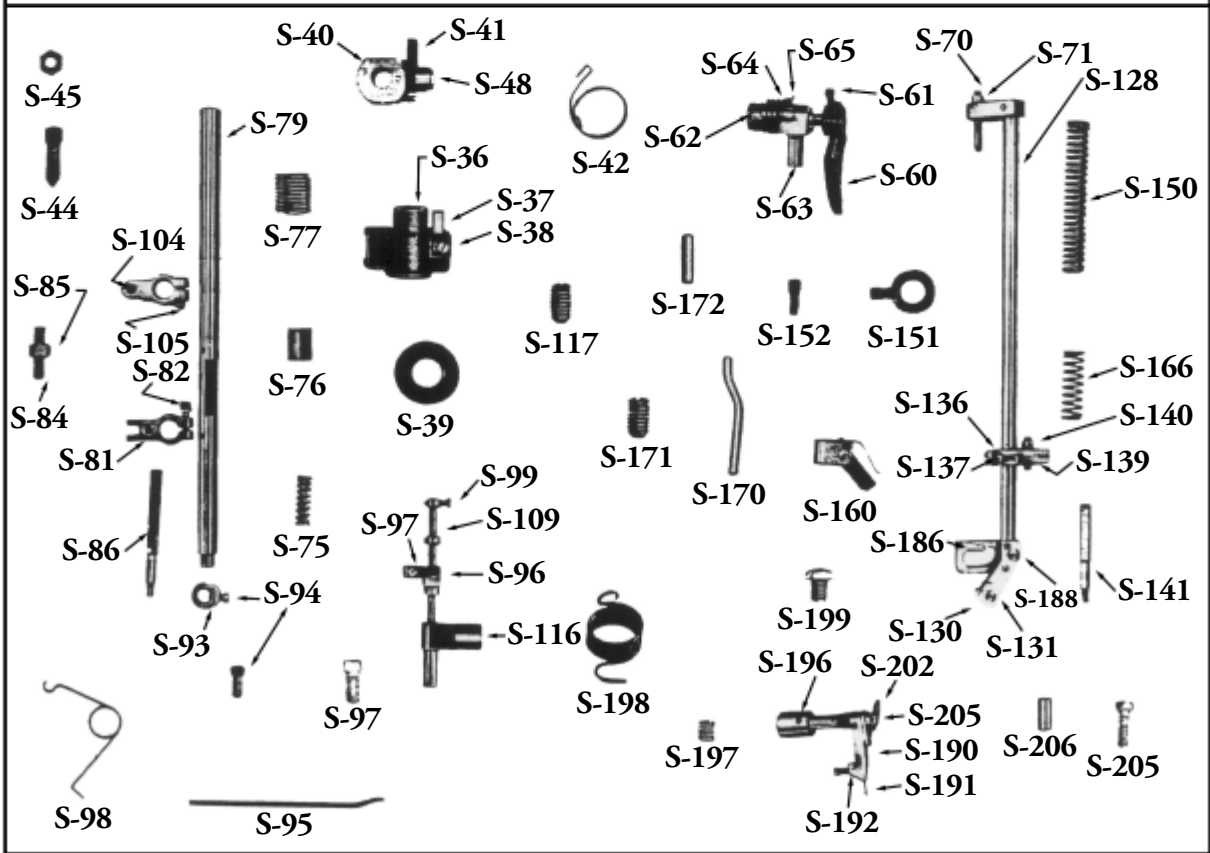
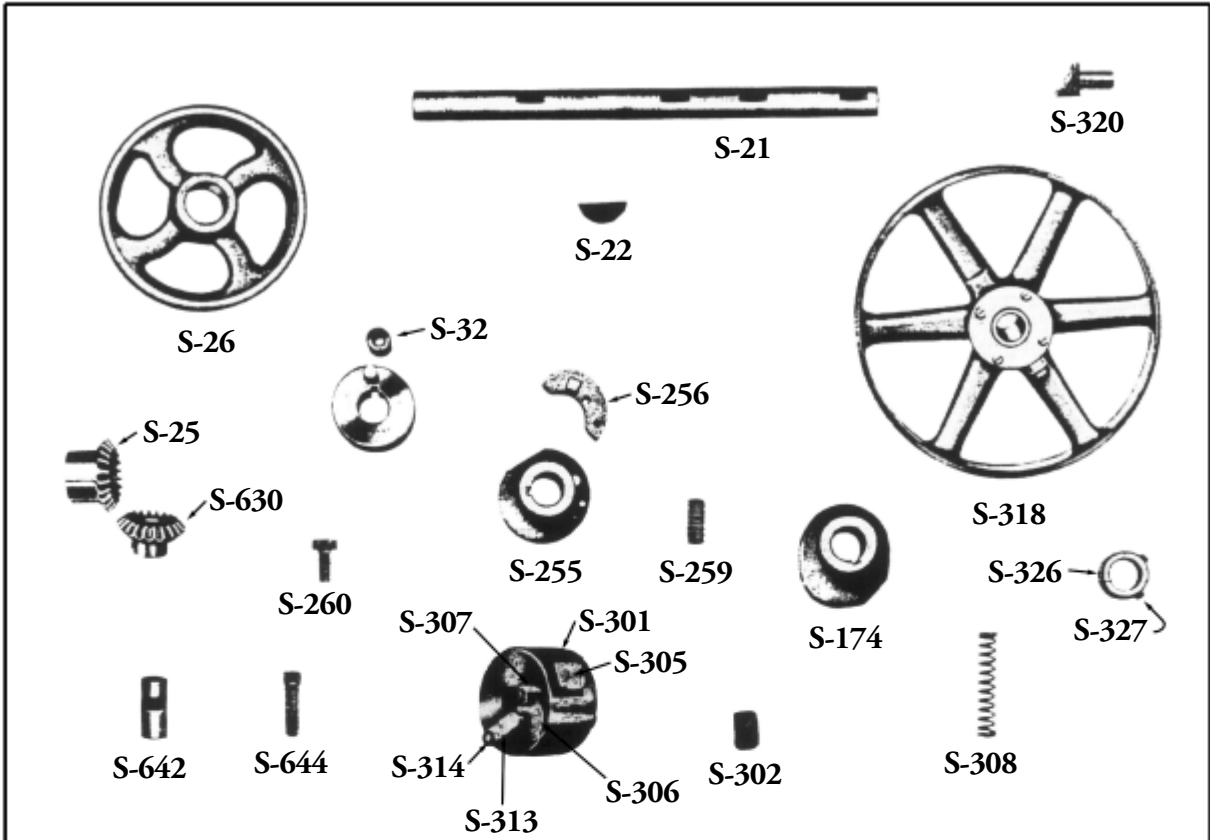
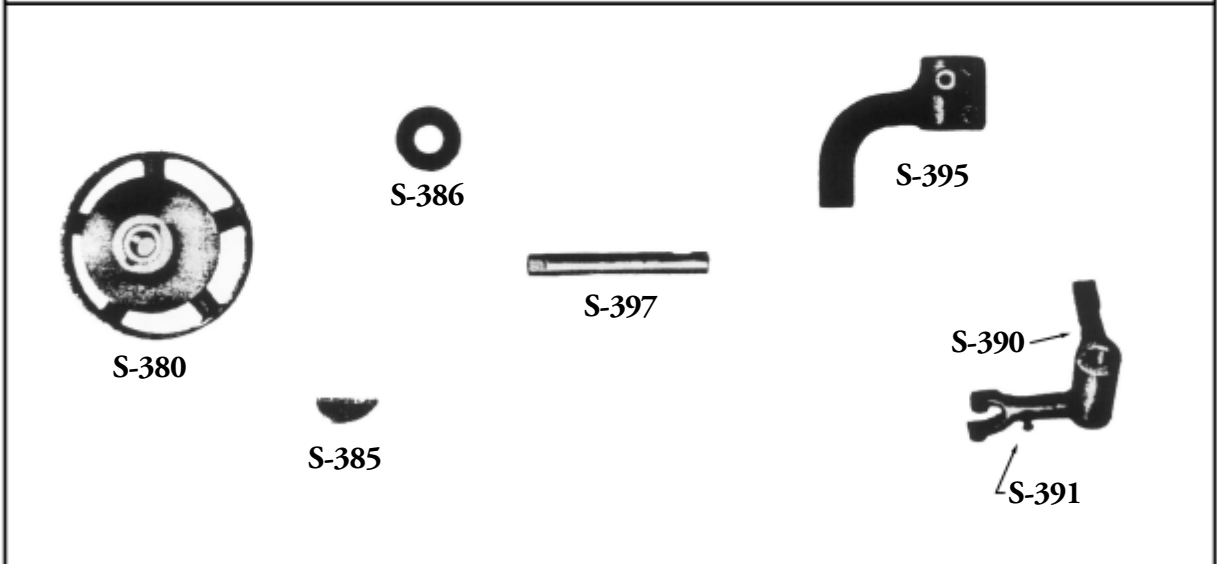
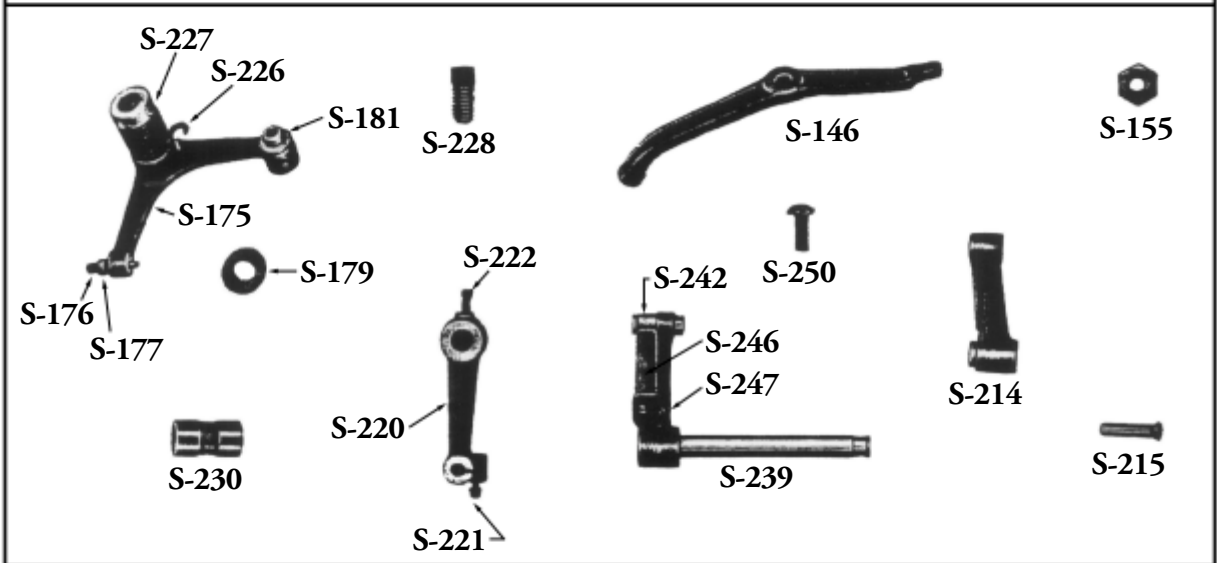
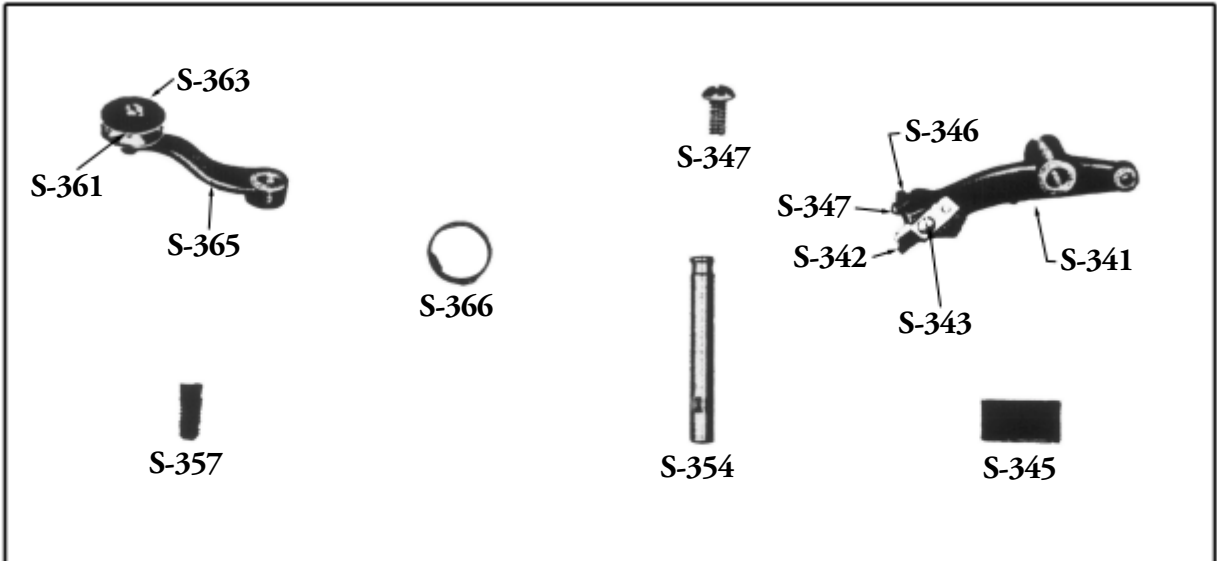
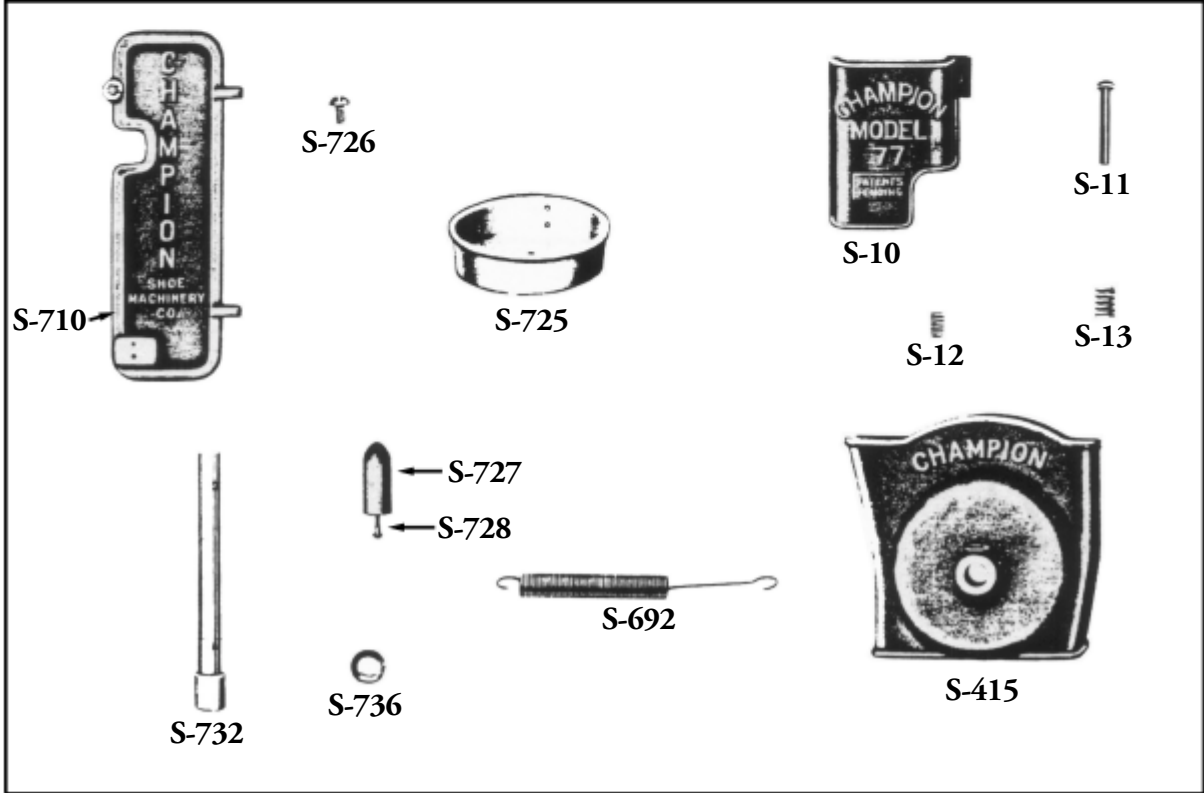
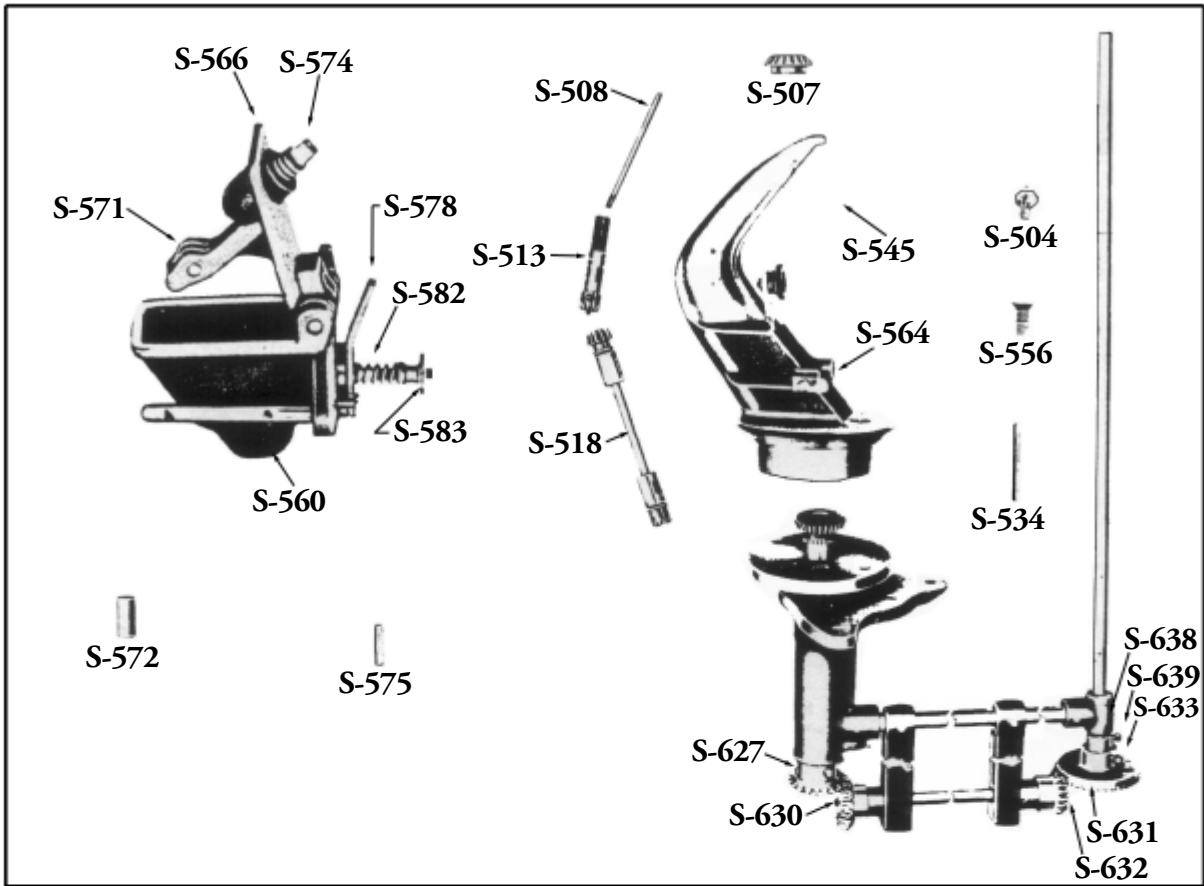


Figure No. 14







LIST OF PARTS - MODEL "77" MCKAY STITCHER

PART NO.	REQ'D	NAME OF PART	PART NO.	REQ'D	NAME OF PART
77-S-1	1	Main Head	77-S-110	1	Cast Off Rod
77-S-2	1	Main Head Fastening Screw (Short)	77-S-111	3	Cast Off Rod Collar
77-S-2A	2	Main Head Fastening Screw (Long)	77-S-112	2	Cast Off Rod Collar Pin
77-S-3	3	Main Head Fastening Screw Washer	77-S-116	1	Cast Off Friction Holder
77-S-5	1	Main Head Rear Cover	77-S-117	1	Cast Off Friction Holder Gib Screw
77-S-6	1	Main Head Rear Cover Screw	77-S-118	1	Cast Off Friction Spring
77-S-7	1	Main Head Rear Cover Lock Washer	77-S-119	1	Cast Off Friction Fibre
77-S-10	1	Main Head Front Cover	77-S-120	1	Cast Off Friction Screw
77-S-11	1	Main Head Front Cover Fulcrum	77-S-128	1	Presser Bar Assembly, Includes 77-S-68, 77-S-69 and 77-S-129
77-S-12	1	Main Head Front Cover Set Screw			
77-S-13	1	Main Head Front Cover Spring	77-S-129	1	Presser Bar
77-S-21	1	Cam Shaft	77-S-130	1	Presser Foot
77-S-22	4	Cam Shaft Key	77-S-130B	1	Two Prong Presser Foot
77-S-23	4	Cam Set Screw	77-S-131	1	Presser Foot Screw
77-S-24	2	Needle Bar Driving Cam Set Screw	77-S-133	1	Presser Bar Holder
77-S-25	1	Miter Gear	77-S-134	1	Presser Bar Holder Pin
77-S-25A	2	Miter Gear Set Screw	77-S-136	1	Presser Bar Guide
77-S-26	1	Hand Wheel	77-S-137	1	Presser Bar Guide Clamp Screw
77-S-27	1	Hand Wheel Set Screw	77-S-138	1	Presser Bar Guide Dowel
77-S-29	1	Needle Bar Driving Cam Assembly, Includes 77-S-30 and 77-S-31	77-S-139	1	Presser Bar Guide Stop Screw
77-S-30	1	Needle Bar Driving Cam	77-S-140	1	Presser Bar Guide Stop Nut
77-S-31	1	Needle Bar Driving Stud	77-S-141	1	Presser Bar Guide Post
77-S-32	1	Needle Bar Driving Cam Roll	77-S-142	1	Presser Bar Guide Post Nut
77-S-36	1	Needle Bar Cam	77-S-143	1	Presser Bar Guide Post Lock Washer
77-S-37	1	Needle Bar Cam Post	77-S-146	1	Lift Lever
77-S-38	1	Needle Bar Cam Post Screw	77-S-147	1	Lift Lever Screw
77-S-39	1	Needle Bar Cam Bumper Washer	77-S-150	1	Presser Bar Spring
77-S-40	1	Needle Bar Latch Holder Assembly, Includes 77-S-43, 77-S-46 and 77-S-50	77-S-151	2	Presser Bar Spring Collar
77-S-41-1	1	Needle Bar Latch	77-S-152	2	Presser Bar Spring Collar Set Screw
77-S-41A	1	Needle Bar Latch Pin	77-S-154	1	Lift Lever Rod
77-S-42	1	Needle Bar Latch Spring	77-S-154A	1	Lift Lever Rod Retaining Pin
77-S-43	1	Needle Bar Latch Holder	77-S-155	4	Lift Lever Rod Nut
77-S-44	1	Needle Bar Latch Holder Set Screw	77-S-156	2	Lift Lever Rod Washer
77-S-45	1	Needle Bar Latch Holder Nut	77-S-157	1	Lift Lever Rod Stud
77-S-46	1	Needle Bar Latch Stud	77-S-158	1	Lift Lever Rod Stud Lock Washer
77-S-47	1	Needle Bar Latch Spring Pin	77-S-159	1	Lift Lever Rod Stud Nut
77-S-48	1	Needle Bar Latch Stud Collar	77-S-160	1	Lifting Dog Assembly, Includes 77-S-161, 77-S-162 and 77-S-163
77-S-49	2	Needle Bar Latch Stud Collar Set Screw	77-S-161	1	Presser Foot Lifting Dog Block
77-S-50	1	Needle Bar Latch Stud Taper Pin	77-S-162	1	Presser Foot Lifting Dog Tail
77-S-60	1	Thread Measure Cam	77-S-163	1	Presser Foot Lifting Dog Fulcrum Pin
77-S-61	1	Thread Measure Cam Set Screw	77-S-164	1	Presser Foot Lifting Dog Block Spring
77-S-62	1	Thread Measure Cam Stud	77-S-165	2	Presser Foot Lifting Dog Block Spring Screw
77-S-63	1	Thread Measure Cam Block	77-S-166	1	Presser Foot Lifting Dog Spring
77-S-64	1	Thread Measure Cam Spring	77-S-170	1	Lifting Dog Trip Pin
77-S-65	2	Thread Measure Cam Spring Screw	77-S-171	1	Lifting Dog Trip Pin Set Screw
77-S-66	2	Thread Measure Cam Block Set Screw	77-S-172	1	Lifting Dog Trip Pin Set Screw Rod
77-S-68	1	Thread Measure Presser Bar Block	77-S-174	1	Presser Foot Lift Cam
77-S-69	1	Thread Measure Presser Bar Dowel	77-S-175	1	Presser Foot Lifting Lever
77-S-70	1	Thread Measure Presser Bar Adjusting Screw	77-S-176	1	Presser Foot Lifting Lever Adjusting Screw
77-S-71	1	Thread Measure Presser Bar Nut	77-S-177	1	Presser Foot Lifting Lever Adjusting Screw Nut
77-S-75	1	Needle Bar Friction Spring	77-S-178	1	Presser Foot Lifting Lever Spring Pin
77-S-76	1	Needle Bar Friction Fibre	77-S-179	1	Presser Foot Lifting Lever Cam Roll
77-S-77	1	Needle Bar Friction Screw	77-S-180	1	Presser Foot Lifting Lever Cam Stud
77-S-79	1	Needle Bar, assembled	77-S-181	1	Presser Foot Lifting Lever Cam Nut
77-S-81	1	Needle Bar Guide	77-S-186	1	Feed Socket Cam Block
77-S-82	1	Needle Bar Guide Post Clamp Screw	77-S-187	2	Feed Socket Cam Block Dowel
77-S-83	1	Needle Bar Guide Dowel	77-S-188	1	Feed Socket Cam Block Fastening Screw
77-S-84	1	Needle Bar Guide Stop Screw	77-S-190	1	Feed Socket
77-S-85	1	Needle Bar Guide Stop Nut	77-S-191	1	Feed Point (Regular)
77-S-86	1	Needle Bar Guide Post	77-S-191A	1	Feed Point (Aloft)
77-S-87	1	Needle Bar Guide Post Nut	77-S-192	1	Feed Point Screw
77-S-88	1	Needle Bar Guide Post Lock Washer	77-S-196	1	Feed Socket Collar
77-S-93	1	Needle Clamp Collar	77-S-197	1	Feed Socket Collar Set Screw
77-S-94	1	Needle Clamp Collar Screw	77-S-198	1	Feed Socket Spring
77-S-95	1	Cast Off	77-S-199	1	Feed Socket Spring Fastening Screw
77-S-96	1	Cast Off Holder	77-S-202	1	Feed Socket Cam Plate
77-S-97	1	Cast Off Holder Set Screw	77-S-205	1	Feed Socket Cam Plate Dowel Screw
77-S-98	1	Cast Off Spring	77-S-206	1	Feed Socket Cam Plate Dowel
77-S-99	1	Cast Off Spring Screw	77-S-214	1	Feed Lever Connecting Link
77-S-104	1	Cast Off Guide			
77-S-105	1	Cast Off Guide Clamp Screw			
77-S-106	1	Cast Off Guide Pin			
77-S-109	1	Cast Off Rod Assembly, Includes 77-S-99, 77-S-110, 77-S-111 and 77-S-112			

LIST OF PARTS - MODEL "77" MCKAY STITCHER

PART NO.	REQ'D	NAME OF PART	PART NO.	REQ'D	NAME OF PART
77-S-215	1	Feed Lever Connecting Link Stud	77-S-347	1	Clutch Throw Out Lever Plate Screw
77-S-220	1	Feed Lever	77-S-348	1	Clutch Throw Out Lever Plate Lock Washer
77-S-221	1	Feed Lever Clamp Screw			
77-S-222	1	Feed Lever Set Screw	77-S-354	1	Clutch Throw Out Lever Shaft
77-S-223	1	Feed Lever Dowel	77-S-355	1	Clutch Throw Out Lever Shaft Set Screw
77-S-226	1	Feed Lever Spring			
77-S-227	1	Feed Lever Spring Collar	77-S-356	1	Clutch Throw Out Lever Shaft Collar
77-S-228	1	Feed Lever Spring Collar Set Screw	77-S-357	1	Clutch Throw Out Lever Shaft Collar Set Screw
77-S-229	1	Feed Lever Shaft			
77-S-230	1	Feed Lever Shaft Bushing	77-S-360	1	Clutch Idler Pulley Assembly, Includes 77-S-361 and 77-S-362
77-S-231	2	Feed Lever Shaft Bushing Clamp			
77-S-231A	2	Adjusting Bushing for Feed Lever Shaft Bush. Clamp Screw	77-S-361	1	Clutch Idler Pulley
			77-S-362	1	Clutch Idler Pulley Needle Bearing
77-S-239	1	Feed Cam Lever Assembly, Includes 77-S-229, 77-S-240 and 77-S-241	77-S-363	1	Clutch Idler Pulley Screw
			77-S-364	1	Clutch Idler Pulley Screw Nut
77-S-240	1	Feed Cam Lever	77-S-365	1	Clutch Idler Pulley Lever
77-S-241	1	Feed Cam Lever Dowel Pin	77-S-365A	1	Clutch Idler Pulley Screw Nut Lock Washer
77-S-242	1	Feed Cam Lever Cam Roll			
77-S-243	1	Feed Cam Lever Cam Stud	77-S-366	1	Clutch Idler Pulley Lever Spring
77-S-244	1	Feed Cam Lever Cam Stud Nut	77-S-380	1	Lower Clutch Pulley Assembly, Includes 77-S-381, 77-S-382, 77-S-383 and 77-S-387
77-S-246	1	Feed Cam Lever Oil Wiper			
77-S-247	1	Feed Cam Lever Oil Wiper Plate	77-S-381	1	Lower Clutch Pulley
77-S-248	1	Feed Cam Lever Oil Wiper Screw	77-S-382	1	Lower Clutch Stationary "V" Pulley
77-S-249	1	Feed Cam Lever Oil Wiper Nut	77-S-383	3	Lower Clutch Stationary Pulley Screw
77-S-250	1	Feed Cam Lever Oil Wiper Fastening Screw	77-S-384	1	Lower Clutch Sliding "V" Pulley
			77-S-385	1	Lower Clutch Pulley Key
77-S-255	1	Feed Cam	77-S-386	2	Lower Clutch Pulley Fibre Washer
77-S-256	1	Feed Cam Plate Assembly, Includes 77-S-257 and 77-S-258	77-S-387	3	Lower Clutch Stationary Pulley Screw Lock Washer
77-S-257	1	Feed Cam Plate	77-S-390	1	Lower Clutch Yoke
77-S-258	1	Feed Cam Plate Block	77-S-390A	1	Lower Clutch Yoke Spacing Washer (1/8")
77-S-259	1	Feed Cam Plate Adjusting Screw			
77-S-260	1	Feed Cam Plate Clamp Screw	77-S-390B	1	Lower Clutch Yoke Spacing Washer (3/16")
77-S-261	1	Feed Cam Plate Dowel			
77-S-301	1	Clutch Sleeve	77-S-390C	1	Lower Clutch Yoke Set Collar
77-S-302	2	Clutch Sleeve Set Screw	77-S-390D	2	Lower Clutch Yoke Set Collar Set Screw
77-S-304	1	Clutch Sleeve Plunger Pin			
77-S-305	1	Clutch Sleeve Stop	77-S-391	1	Lower Clutch Yoke Adjusting Screw
77-S-306	1	Clutch Sleeve Plunger	77-S-392	3	Lower Clutch Yoke Adjusting Screw Nut
77-S-307	1	Clutch Sleeve Plunger Pin			
77-S-308	1	Clutch Sleeve Plunger Spring	77-S-394	2	Lower Clutch Yoke Bracket Lock Washer
77-S-311	1	Clutch Sleeve Plunger Fibre Stop			
77-S-312	1	Clutch Sleeve Plunger Stop Stud	77-S-395	1	Lower Clutch Yoke Bracket
77-S-313	1	Clutch Sleeve Plunger Stop Bar	77-S-396	2	Lower Clutch Yoke Bracket Fastening Screw
77-S-314	1	Clutch Sleeve Plunger Stop Bar Screw			
77-S-318	1	Clutch Pulley Assembly, Includes 77-S-319, 77-S-320, 77-S-321, 77-S-322, 77-S-323, 77-S-324, 77-S-325, 77-S-326 and 77-S-327	77-S-397A	1	Lower Clutch Yoke Shaft (New Style)
			77-S-398	1	Lower Clutch Yoke Shaft Set Screw
77-S-319	1	Clutch Pulley (10 1/2" Diam.)	77-S-404	1	Lower Clutch Yoke Finger
77-S-320	2	Clutch Pulley Driving Dog	77-S-405	1	Lower Clutch Yoke Finger Set Screw
77-S-321	1	Clutch Pulley Pipe Plug	77-S-409	1	Lower Clutch Shaft
77-S-322	1	Clutch Pulley Plate	77-S-410	1	Lower Clutch Shaft Oil Cup
77-S-323	1	Clutch Pulley Plate Gasket	77-S-411	1	Lower Clutch Shaft Oil Wick
77-S-324	4	Clutch Pulley Plate Screw	77-S-412	1	Lower Clutch Shaft Set Screw
77-S-325	4	Clutch Pulley Wool Yarn	77-S-415	1	Lower Clutch Belt Guard
77-S-326	1	Clutch Pulley Set Collar	77-S-416	2	Lower Clutch Belt Guard Set Screw
77-S-326A	1	Hand Wheel Set Collar (Regular)	77-S-501	1	Horn
77-S-326B	1	Hand Wheel Set Collar (For Repairs)	77-S-502	1	Horn Tip
77-S-327	2	Clutch Pulley Set Collar Set Screw	77-S-503	1	Horn Tip Cap
77-S-327A	2	Hand Wheel Set Collar Set Screw (Regular)	77-S-504	1	Horn Tip Cap Upper Screw
77-S-327B	2	Hand Wheel Set Collar Retaining Screw (For Repairs)	77-S-505	1	Horn Tip Cap Lower Screw
			77-S-506	1	Horn Tip Cap Lower Screw Insert
77-S-336	1	Clutch Pulley Round Belt	77-S-507	1	Horn Whirl
77-S-337	1	Motor Belt	77-S-508	1	Horn Pinion Shaft
77-S-340	1	Clutch Throw Out Lever Assembly, Includes 77-S-341, 77-S-342, 77-S-343, 77-S-344, 77-S-345, 77-S-346, 77-S-347 and 77-S-348	77-S-509	1	Horn Pinion Shaft Sleeve
			77-S-510	1	Horn Pinion Shaft Adjusting Screw
			77-S-511	1	Horn Pinion Shaft Bushing
			77-S-512	2	Horn Hollow Hex Set Screw (Lower Shaft)
77-S-341	1	Clutch Throw Out Lever			
77-S-342	1	Clutch Throw Out Lever Wedge	77-S-512A	1	Horn Hollow Hex Set Screw (Pinion Shaft)
77-S-343	1	Clutch Throw Out Lever Wedge Screw			
77-S-344	1	Clutch Throw Out Lever Wedge Dowel	77-S-513	1	Horn Pinion Shaft Sleeve Assembly, Includes 77-S-509, 77-S-510, 77-S-511, 77-S-514 and 77-S-515
77-S-345	1	Clutch Throw Out Lever Bumper			
77-S-346	1	Clutch Throw Out Lever Plate			

LIST OF PARTS - MODEL "77" MCKAY STITCHER

PART NO.	REQ'D	NAME OF PART	PART NO.	REQ'D	NAME OF PART
77-S-514	1	Horn Center Bevel Gear	77-S-625	1	Horn Spindle Hollow Shaft Spacer
77-S-515	2	Horn Center Bevel Gear Taper Pin	77-S-626	1	Horn Spindle Hollow Shaft Washer
77-S-518	1	Horn Lower Shaft Assembly, Includes 77-S-514, 77-S-515, 77-S-519, 77-S-520 and 77-S-521	77-S-627	1	Horn Spindle Hollow Shaft Lower Gear
77-S-519	1	Horn Lower Shaft	77-S-630	2	Drive Shaft Miter Gear
77-S-520	2	Horn Lower Shaft Bushing	77-S-631	1	Drive Shaft Center Bevel Gear
77-S-521	1	Horn Lower Shaft Bevel Gear	77-S-632	1	Drive Shaft Center Bevel Pinion
77-S-530	3	Horn Spring Oiler	77-S-633	6	Gear Ball Point Set Screw
77-S-531	4	Horn Fastening Screw	77-S-635	1	Drive Shaft Gear Guard
77-S-532	1	Horn Thread Guard Plate	77-S-636	1	Drive Shaft Gear Guard Screw
77-S-533	1	Horn Thread Roll	77-S-637	1	Drive Shaft Gear Guard Lock Washer
77-S-534	1	Horn Thread Roll Pin	77-S-638	1	Vertical Drive Shaft Thrust Collar
77-S-535	1	Horn Thread Guide Pin	77-S-639	1	Vertical Drive Shaft Thrust Collar Set Screw
77-S-537	1	Horn Spindle Bearing Oiler	77-S-640	1	Vertical Drive Shaft
77-S-545	1	Horn Front Cover Assembly, Includes 77-S-546, 77-S-547, 77-S-549, 77-S-550, 77-S-551 and 77-S-552	77-S-641	1	Vertical Drive Shaft Lower Bushing
77-S-546	1	Horn Front Cover	77-S-642	1	Vertical Drive Shaft Upper Bushing
77-S-547	2	Horn Front Cover Pin	77-S-643	1	Vertical Drive Shaft Upper Bushing Oil Wick
77-S-549	1	Horn Front Cover Knob	77-S-644	1	Vertical Drive Shaft Upper Bushing Set Screw
77-S-550	1	Horn Front Cover Latch	77-S-645	1	Vertical Drive Shaft Upper Bushing Nut
77-S-551	1	Horn Front Cover Lock Washer	77-S-654	1	Horizontal Drive Shaft
77-S-552	1	Horn Front Cover Dowel	77-S-655-1	1	Horizontal Drive Shaft Bracket (Rear)
77-S-553	1	Horn Rear Cover	77-S-656	1	Horizontal Drive Shaft Bracket (Front)
77-S-556	1	Horn Rear Cover Screw	77-S-659	1	Horizontal Drive Bracket Rod
77-S-557	1	Horn Rear Lower Cover	77-S-660	4	Horizontal Drive Bracket Rod Pin
77-S-558	4	Horn Rear Lower Cover Screw	77-S-680	1	Column
77-S-560	1	Horn Wax Pot Assembled Complete	77-S-681	1	Tripod
77-S-561	1	Wax Pot Only	77-S-682	4	Tripod Fastening Screw
77-S-562	1	Wax Pot Stud (Right)	77-S-683	4	Tripod Fastening Screw Washer
77-S-562A	1	Wax Pot Stud (Left) Cotter Pin	77-S-684	4	Tripod Fastening Screw Lock Washer
77-S-563-1	1	Wax Pot Stud (Left) With Hole	77-S-688	1	Clutch Pedal
77-S-566-1	1	Horn Wax Pot Lid	77-S-689	1	Presser Foot Pedal
77-S-567	1	Horn Wax Pot Lid Hinge	77-S-690	1	Pedal Fulcrum
77-S-568	1	Horn Wax Pot Lid Stop Screw	77-S-691	2	Pedal Fulcrum Set Screw
77-S-571	1	Horn Wax Pot Thread Roll	77-S-692	1	Presser Foot Pedal Spring
77-S-572	1	Horn Wax Pot Thread Roll Pin	77-S-693	2	Clutch Pedal Yoke
77-S-573	1	Horn Wax Pot Stripper	77-S-694	2	Clutch Pedal Pin
77-S-574	1	Horn Wax Pot Stripper Screw	77-S-695	4	Clutch Pedal Yoke Cotter Pin
77-S-575	1	Horn Wax Pot Thread Guide Pin	77-S-696	2	Clutch Pedal Yoke Nut
77-S-576	1	Horn Wax Pot Thread Roll Thread Guide Pin	77-S-696A	2	Clutch Pedal Yoke Screw
77-S-578	1	Thread Tension Lever	77-S-700	1	Clutch Throw Out Rod
77-S-579	1	Thread Tension Plate	77-S-701	1	Clutch Throw Out Rod Spring
77-S-580	1	Thread Tension Lever Dowel	77-S-702	1	Clutch Throw Out rod Clamp with Screws
77-S-581	1	Thread Tension Stud	77-S-703	2	Clutch Throw Out Rod Clamp Set Screw
77-S-582	1	Thread Tension Spring	77-S-710	1	Column Door
77-S-583	1	Thread Tension Thumb Nut	77-S-711	2	Column Door Hinge Pin
77-S-584	1	Thread Tension Washer	77-S-712	2	Column Door Hinge
77-S-586	1	Horn Wax Pot Plug	77-S-713	4	Column Door Hinge Screw
77-S-587	1	Horn Wax Pot Stripper Screw	77-S-715	1	Column Door Knob
77-S-588	1	Horn Wax Pot Stripper Plunger	77-S-716	1	Column Door Knob Screw
77-S-590	1	Table	77-S-717	1	Column Door Knob Nut
77-S-591	2	Table Fastening Screw (Long)	77-S-722	1	Column Door Assembled Complete
77-S-592	1	Table Fastening Screw (Short)	77-S-725	1	Thread Holder Cup
77-S-593	2	Table Fastening Screw Nut	77-S-726	2	Thread Holder Cup Fastening Screw
77-S-594	2	Table Fastening Screw Lock Washer	77-S-726A	2	Thread Holder Cup Fastening Screw Nut
77-S-595	1	Table Rubber Bushing	77-S-727	1	Thread Holder
77-S-601	1	Horn Spindle Bearing	77-S-728	1	Thread Holder Wood Screw
77-S-602	2	Horn Spindle Bearing Dowel Pin	77-S-740	1	Thread Unwinder Bracket
77-S-603	4	Horn Spindle Bearing Fastening Screw	77-S-741	1	Thread Unwinder Bracket Screw
77-S-605	4	Horn Spindle Bearing Lock Washer	77-S-764	1	Motor Extension Cord Complete
77-S-610	1	Horn Spindle	77-S-768	2	Wire Terminals (Copper)
77-S-611	1	Horn Spindle Dowel	77-S-770	1	2" Diam. Motor Pulley
77-S-612	1	Horn Spindle Oil Tube	77-S-770A	1	Motor Pulley Set Screw
77-S-616	2	Horn Spindle Thrust Disc	77-S-777	1	Motor Base
77-S-617	1	Horn Spindle Thrust Bearing Retainer	77-S-778	4	Motor Fastening Screw
77-S-620	14	Steel Balls	77-S-778A	4	Motor Fastening Screw Washer
77-S-621	1	Horn Spindle Hollow Shaft Assembly, Includes 77-S-622, 77-S-623 and 77-S-624	77-S-778B	4	Motor Fastening Screw Nut
77-S-622	1	Horn Spindle Hollow Shaft	77-S-781	1	Motor Base Fulcrum Set Screw
77-S-623	1	Horn Spindle Hollow Shaft Upper Gear	77-S-795	1	Motor Switch
77-S-624	1	Horn Spindle Hollow Shaft Upper Gear Key	77-S-795B	2	Motor Switch Fastening Screw

LIST OF PARTS - MODEL "77" MCKAY STITCHER

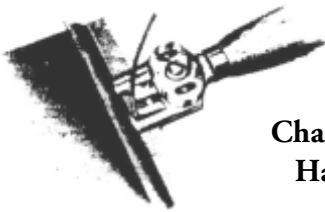
PART NO.	REQ'D	NAME OF PART	PART NO.	REQ'D	NAME OF PART
77-S-796	1	Motor Switch Rod	77-S-863	1	Threading Wire - Straight
77-S-850	1	1/4" Hollow Hex Wrench	77-S-864	1	Threading Wire - Bent
77-S-852	1	3" Screw Driver	77-S-865	1	Can Liquid Wax
77-S-855	1	1/4" Square Socket Wrench	77-S-870	1	Model Name Plate
77-S-856	1	3/16" Hollow Hex "L" Wrench	77-S-871	2	Model Name Plate Drive Screw
77-S-861	1	Oil Can			

CHAMPION AND LANDIS COMBINATION HAND CHANNELER AND GROOVER

PART NO.	REQ'D	NAME OF PART	PART NO.	NAME OF PART
HC50		Right Hand Channeler & Groover Complete with Sharpening Stone	MX-1R	McKay Lip Channeler - Right Hand Complete
HC50A		Left Hand Channeler & Groover Complete with Sharpening Stone	MX-1L	McKay Lip Channeler - Left Hand Complete
		<u>PARTS</u>	X-6R	McKay Lip Channeler Knife - Right Hand
			X-6L	McKay Lip Channeler Knife - Left Hand
HC53	1	Hand Channeler Frame		
HC54	1	Hand Groover Frame		
HC58	1	Hand Channeler Knife		
HC62	1	Semi-English Knife		
HC63	1	Groover Knife	X-5R	McKay Groover - Right Hand Complete
HC67	2	Edge Gauge	X-5L	McKay Groover - Left Hand Complete
HC68	4	Edge Gauge Screw		
HC69	3	Edge Gauge Washer		
HC73	1	Hand Channeler Handle	X-4R	McKay Groover Knife - Right Hand
HC77	1	Sharpening Stone	X-4L	McKay Groover Knife - Left Hand

LANDIS HAND GROOVERS

ILLUSTRATION OF CHAMPION COMBINATION HAND CHANNELER AND GROOVER



**Champion Combination
Hand Channeler and
Groover**

Has an Adjustable Gauge. Groove can be cut in channel where desired.



Quickly adjusted for cutting channel any margin from the edge of sole or to make thin or thick lip.