

# AMF Reece

## Automatic Template Stitching System



Consistent Quality  
Enhanced Productivity

**AMF<sup>®</sup> REECE**  
*Better Ideas, Better Made*



The AMF Reece Autojig template stitching system, pioneered in the 1960's, is now offered in comprehensive range of Autojig machines. The autojig system was specially designed for automatic assembly of garment components that are always sewn with high and consistent quality. Either double or single jigs with or without fullness can be used depending the model and application.

## Advantages of Using Autojig Templates Stitching System

**Consistent Quality & Unmatched Flexibility** - every component is correct in size and shape every time, in every fabric, with every operator. Component size, shape or new style can be changed in a few seconds by an operator, without any assistance. Also fabric changes are of no consequences since the feed mechanism drives the jig template and not the fabric.

**High flexibility** is also ensured in **small-productions** when sewing in sequence; for example one left forepart, one right forepart, one collar, two pocket flaps and two epaulettes.

Each assembled component has **precisely the correct amount of fullness** that is required. For example an operator with limited sewing experiences produce perfectly balanced left and right forepart of jacket with correct amount of fullness and perfect lapel points, which is the major contribution to the quality and appearance of the finished garment.

**Simple Operation by Unskilled Operator** - very limited sewing skills are required, simply the ability to maintain a steady routine in loading and unloading the stitching templates. New (unskilled) operators produce perfect components from the outset and achieve full productivity within only a few hours.

**Enhanced productivity** is achieved because one jig template can be loaded while a second template is being sewn so called "needle time" comfortably exceeds 80%





for assembling small components

84-50



The 84-50 is the lowest priced version in the range of autojig machines and is **ideal for small component pieces with a sewing range up to 30 cm** such as pocket flaps with or without fullness, cuffs, double epaulettes, waistband extension. This model is not equipped with a microprocessor.

### Features

**Pneumatic Control System** provides a fully automatic sewing cycle with dense stitching at beginning and end of seam, automatic thread trimming; cloth edge trimming that can be turned off when sewing nett-cut cloth pieces.

for assembling medium size components

84-55 M



84-55 M model incorporates a number of important innovations and accommodates **stitching templates up to about 60 cm** in length such as collars, cuffs, pockets, pointed and rounded collars.

**Patented Intermittent/Continuous Dual Drive System** advances the stitching template only when the needle is in the "up" position, for optimum stitch quality, garment appearance and needle life. This system enables the stitching templates to be turned at acute corners and also to be driven in "reverse"; for back tacking the seam ends if required, as an alternative to condensed stitching.

**Microprocessor** controls all of the sewing functions such as: automatic thread trimming, start and stopping of cloth trimming knife, automatic batch counter to monitor the productivity, up to 6 different modes of positions at corners, self diagnostic testing facility.

**Auto Start Facility** automatically initiates the sewing cycle as soon as the template is moved to the start position.

**Large Capacity Hook & Base** minimizes stoppages for bobbin changing.

**Increased Sewing Speed** from 2600 to 3600 spm, ensures that even the fastest operator never needs to wait for the machine to complete its sewing cycle.





## 84-72 M

for assembling medium size components

This model can be used for components up to 60 cm in length, including acutely pointed shapes such as two piece shirt collars.

**Advanced Microprocessor** controls all of the sewing functions including dense stitching at the beginning and end of the seam, automatic thread trimming, start and stopping of cloth trimming, up to 6 different operation modes at the corners, turn mechanism to rotate the template about the stationary needle at the corner, automatic template ejection at the end of the cycle, batch counter to monitor the productivity, self diagnostic testing facility.



## 84-55 U/72U

for assembling large/small components

These models are upgraded versions of 84-55M and 84-72M machines with further unique features to facilitate the handling of very large **stitching templates up to 140-150 cm** in length.

The models are intended primarily for applications such as attaching the facing to the forepart of jackets and top-coats which are the most critical operations in the manufacture of tailored outwear. These models can also assemble small components such as pocket flaps and tabs.



### Additional Machine Features

**Large Worktable Extensions** and ergonomic template loading station helps to accommodate the large templates such as jacket and raincoat foreparts,

**Air Flotation System** supports large stitching templates on a cushion of air. This system can be turned off when small components are being sewn.

**Template Alignment Feature** preserves the correct orientation of large templates during stitching to provide a more smoothly trimmed cloth edge.

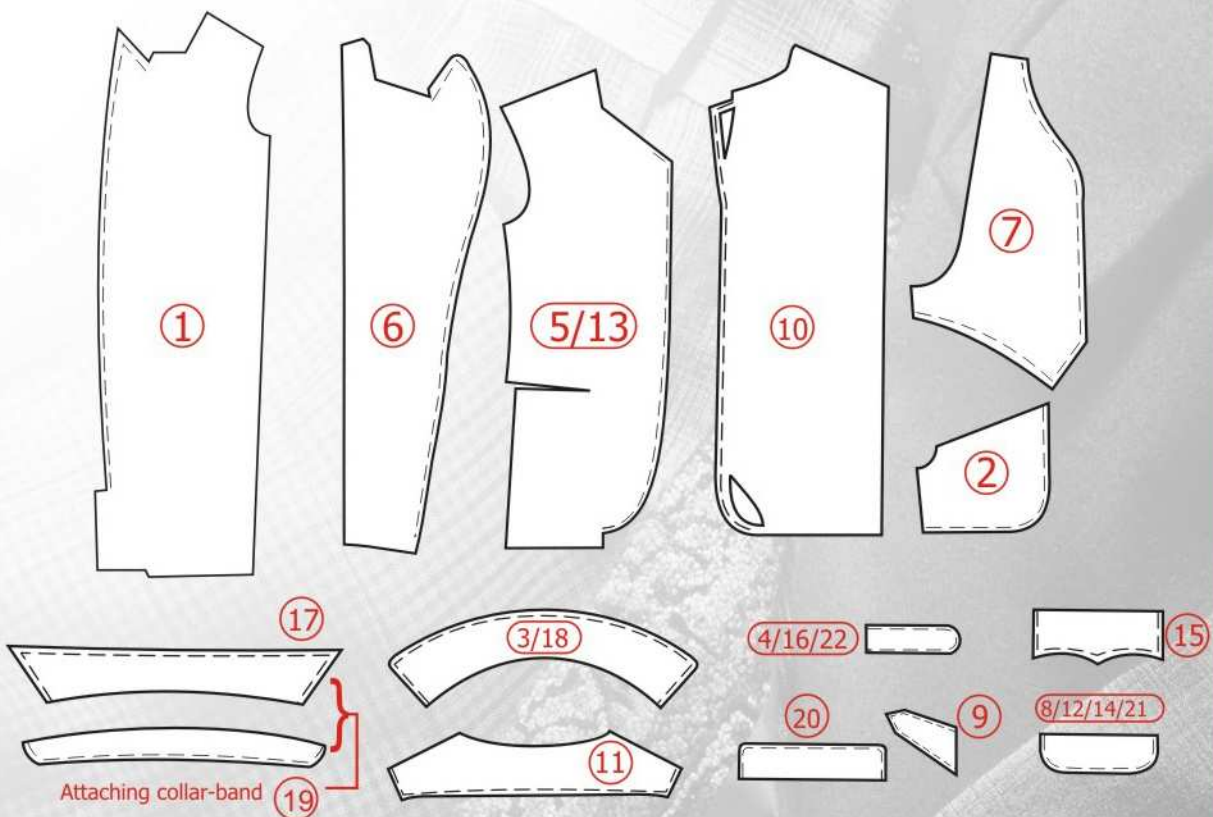




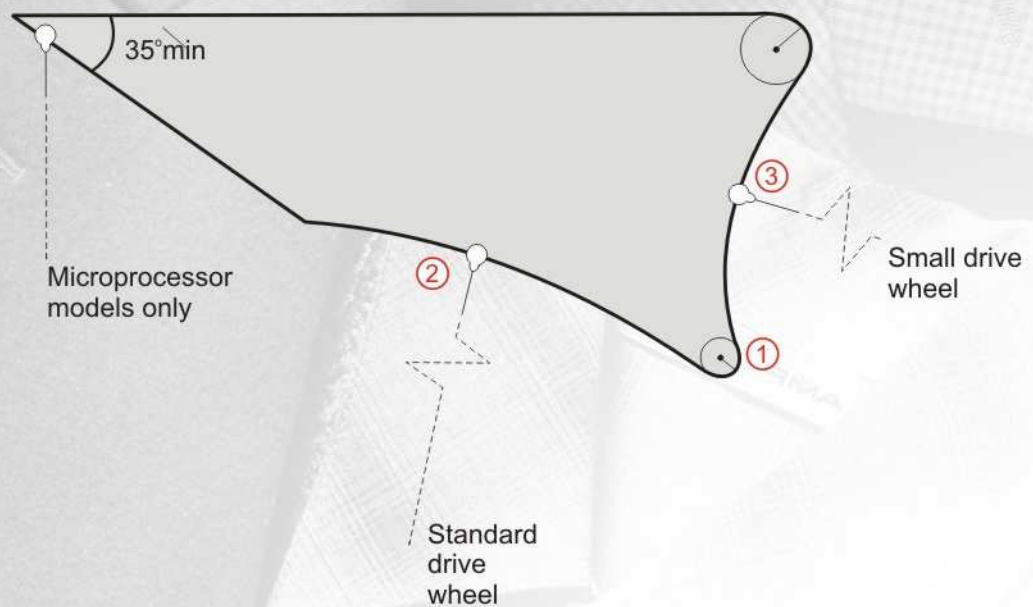
## Typical Production Rate per 8 Hour Day

<b>Topcoats</b>			<b>84-55M</b>	<b>84-55U</b>	<b>84-72M</b>	<b>84-72U</b>	<b>84-50E</b>
1 Raincoat forepart	<b>P</b>	●		340-390		260-300	
2 Yoke or gun patch			1300-1550	1300-1550	1000-1200	1000-1200	
3 Collar		●	1400-1700	1400-1700	1100-1300	1100-1300	
4 Epaulette			2300-2500	2300-2500	2300-2500	2300-2500	2300-2500
<b>Menswear</b>							
5 Jacket forepart (SB)	<b>P</b>	●		650-720		550-600	
6 Jacket forepart (DB)	<b>P</b>	●		550-620		420-480	
7 Vest Front		●		730-800		560-620	
8 Pocket flap*		●	2000-2400	2000-2400	2000-2400	2000-2400	2000-2400
9 Waistband extension			1400-1500	1400-1500	1400-1500	1400-1500	1400-1500
<b>Ladieswear</b>							
10 Jacket forepart	<b>P</b>	●		700-770		550-600	
11 Jacket collar		●	1400-1700	1400-1700	1100-1300	1100-1300	
12 Pocket flap*		●	2000-2400	2000-2400	2000-2400	2000-2400	2000-2400
<b>Uniforms / Workwear</b>							
13 Jacket forepart	<b>P</b>	●		650-720	420-480	420-480	
14 Pocket flap*			2000-2400	2000-2400	2000-2400	2000-2400	2000-2400
15 Van Dyke flap*		○	1900-2300	1900-2300	1900-2300	1900-2300	1900-2300
16 Epaulette			1150-1250	1150-1250	1150-1250	1150-1250	1150-1250
<b>Shirts/Blouses</b>							
17 Pointed collar			1300-1550	1300-1550	1000-1200	1000-1200	
18 Rounded collar			1900-2200	1900-2200	1500-1700	1500-1700	
19 Attach collar band			2000-2600	2000-2600	1600-2000	1600-2000	
20 Cuff*			2400-2800	2400-2800	2400-2800	2400-2800	2400-2800
21 Pocket flap*			2400-2800	2400-2800	2400-2800	2400-2800	2400-2800
22 Epaulette			1150-1250	1150-1250	1150-1250	1150-1250	1150-1250

● fullness option ○ Special small drive wheel recommended \* Double jig optional **P** Pairs

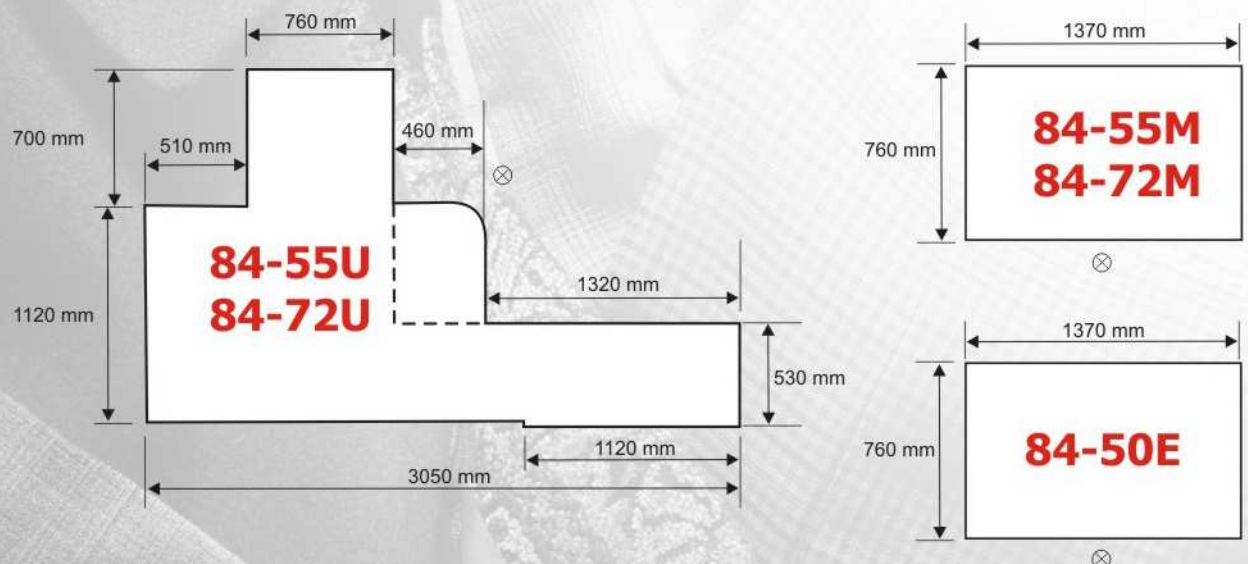


## Stitching Jig Specifications



Seam Allowance	mm	inch
- standard	4,8	3/16
- min-max	3,2-6,4	1/8 - 1/4
Extra fabric required, in addition to seam allowance:	8	5/16
<b>Minimum Turn Radius</b> at corners (except pointed corners on machines with microprocessor control)	3	1/8 (1)
<b>Minimum Concave Profile Radius</b>		
- standard	100	4 (2)
- with small drive wheel *	50	2 (3)
* then maximum component length becomes	250-300	10-12

## Floor Plans





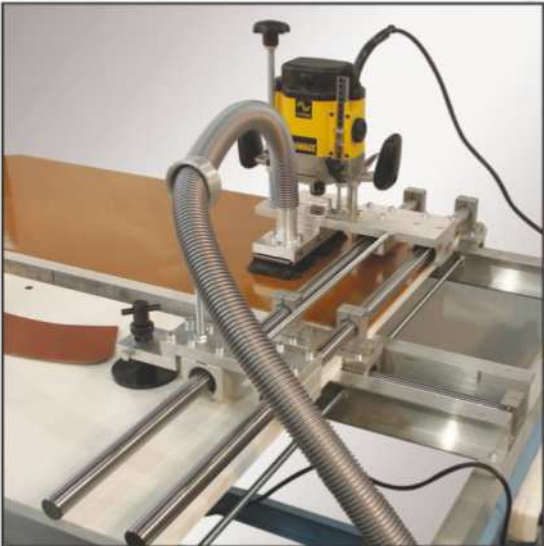
# 84-78 Autotrak



84-78 Autotrak enables Autojig system users to maintain full control over template cost and delivery time with easy on-site manufacturing of stitching templates. The system produces robust, accurate stitching templates (jigs) of proven durability for small or large scale production of precision-made garment components ranging from pocket flaps to jacket foreparts.

## Benefits of Autotrak

- robustly constructed lightweight aluminium alloy router head moves in the "X" and "Y" directions on hardened steel shafts fitted with linear recirculating ball bushings, giving ultra-smooth movement ideal for machining the template
- bushings are fitted with lip seals to exclude dust, for durability and easy maintenance router speed is variable to ensure optimal cutting of different materials
- at 1.7 kWh, the router unit is more powerful than previous models
- depth of cut is adjustable and can be pre-set to 3 positions for easier working
- cutter is fully guarded and dust is continuously extracted
- cutting tools and consumable items can be obtained from local stockists, if necessary
- stitching templates may be either of the proven AMF Reece construction, using phenolic resin sheet material and conventional hinges or, for short production runs, the template may be cut in a single operation from pre-manufactured plastic-hinged Autotrak 'blanks'.



## Available Models

### 84-78 without tools

No jig material is supplied with this version. You can contact the spare parts department to procure materials that are used in making of jigs.

### 84-78 with tools

Certain quantities of tufnol, sheet aluminium, green base, and hinges are included with the machine allowing the user to start making templates immediately. Additionally, the machine is supplied with small tools such as a drill required to assemble jigs.





# Technical Specifications

	84-55M	84-55U	84-72M	84-72U	84-50E
<b>Sewing Head</b>	Juki	Juki	Sunstar/Juki	Sunstar/Juki	Juki
<b>Motor</b>	Mitsubishi PLC Control		EFKA Modular DC Motor with solid state needle positioning		
<b>Needle Positioner</b>	Yes	Yes	Yes	Yes	Yes
<b>Stitch Type</b>	High speed single needle lockstitch				
<b>Speed</b>	3600	3600	2600	2600	2600
<b>Cloth Trimming</b>	Yes	Yes	Yes	Yes	Yes
<b>Air Flotation</b>	No	Yes	No	Yes	No

## Seam Allowance

<b>Standard</b>	4,8 mm	4,8 mm	4,8 mm	4,8 mm	4,8 mm
<b>Option Min.</b>	3,2 mm	3,2 mm	3,2 mm	3,2 mm	3,2 mm
<b>Option Max.</b>	6,4 mm	6,4 mm	6,4 mm	6,4 mm	6,4 mm

## Stitching Templates

<b>Maximum Length</b>	60 cm	140 cm	60 cm	140 cm	30 cm
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## Min Concave Radius

<b>Standard Drive Wheel</b>	10 cm	10 cm	10 cm	10 cm	10 cm
<b>Small Drive Wheel</b>	5 cm	5 cm	5 cm	5 cm	5 cm
<b>Recommended Needle</b>	134R	134R	134K	134K	134K
<b>Recommended Thread</b>	Core spun polyester/cotton				
<b>Electrical Supply</b>	220-240 50/60 Hz Single phase				
<b>Air Requirements</b>	5.7 bar (80 psi)				

## Dimensions

<b>Length</b>	1370 mm	3050 mm	1300 mm	3050 mm	1370 mm
<b>Width</b>	760 mm	1850 mm	700 mm	1850 mm	760 mm
<b>Table Height</b>	920 mm	920 mm	930 mm	920 mm	920 mm
<b>Weight</b>	150kg	225 kg	140 kg	225 kg	150 kg

## Shipping Dimensions

<b>Length</b>	1540 mm	1480 mm	1510 mm	1480 mm	1480 mm
<b>Width</b>	990 mm	970 mm	970 mm	970 mm	970 mm
<b>Height</b>	1460 mm	1360 mm	1450 mm	1360 mm	1360 mm
<b>Weight</b>	302 kg	396 kg	254 kg	396 kg	248 kg

Accuracy of illustration and description of equipment show herein applies to products as manufactured at time of publication.

**AMF REECE**  
*Genuine Parts*

**AMF REECE**  
*Better Ideas, Better Made*

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