

PREMIER SERIES

BY



P1541S-CC

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1. Brief introduction

Machine adopts compound feed and special feeding mechanism, which can ensure smooth feeding, low noise, and beautiful stitch seam. It is constructed with slide link thread take-up, horizontal large rotating hook, and synchronized belt driving system, which ensures high speed, but lower noise.

This machine is suitable for sewing the heavy materials of car seat, sofa, tarpaulins, tents, bag, etc.

3. Installation (Fig.1)

1. Installation of the table connecting hook bracket and rubber cushion.

Fix the connecting hook bracket ① and the rubber cushion ② on the table by screw ③.

2. Installing the oil reservoir.

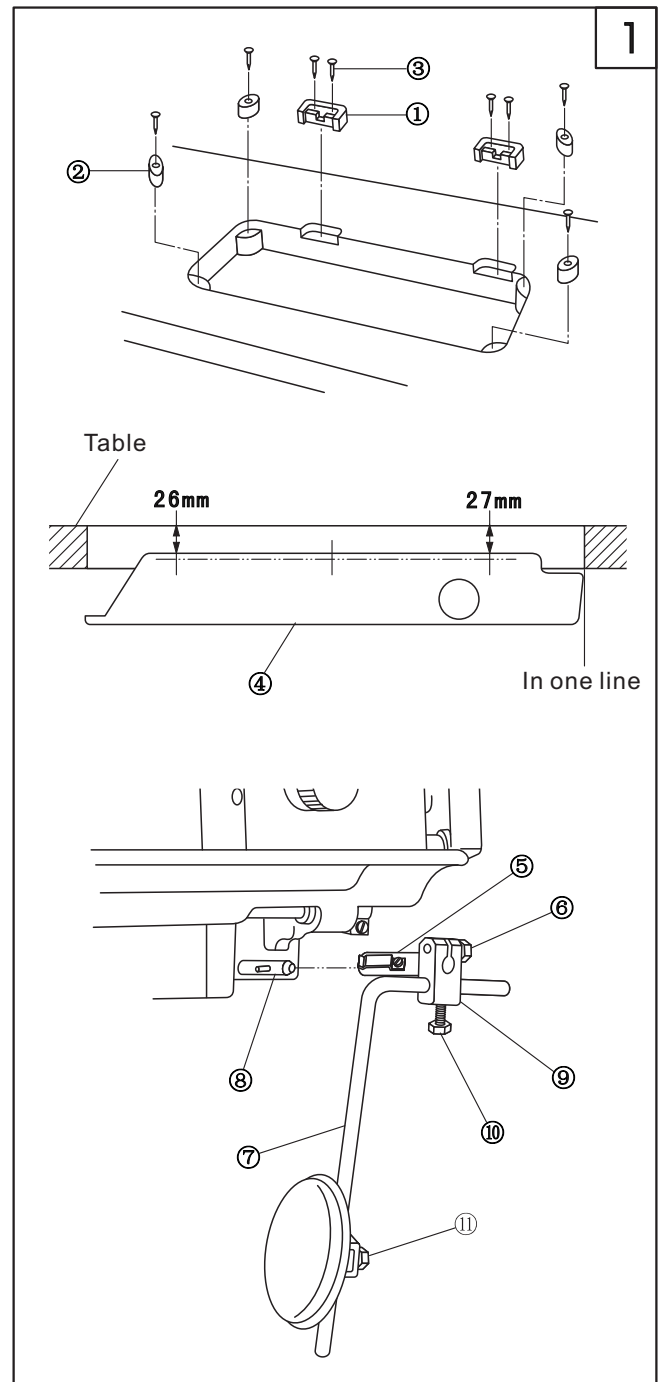
Set the oil reservoir ④ onto the table by six screws as shown in the Fig.1.

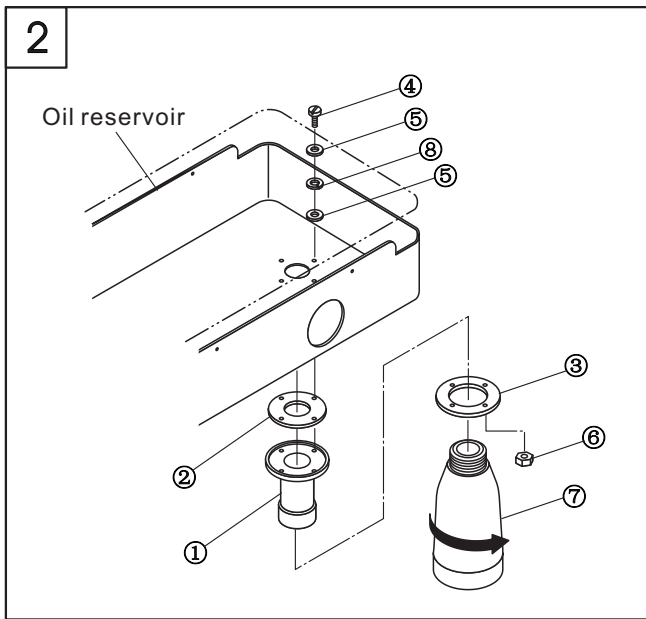
3. Install the knee control connector ⑤, knee control lift crank ⑨ and bent bar ⑦ according to the direction of the knee control lift bar shaft ⑧.

4. Adjust the direction of part ⑥, ⑩, ⑪ by set screw.

2. Main specifications

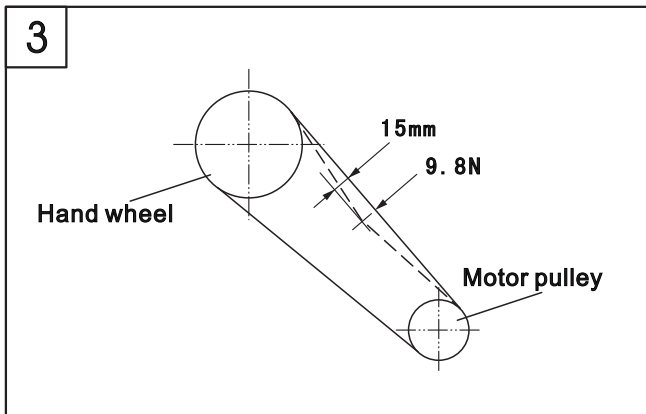
Application	Medium and heavy duty
Max. sewing speed	2000 s.p.m
Max. stitch length	9mm
Needle bar stroke	36mm
Needle	DP*17 (Nm125-Nm180) standard Nm160 (23#)
Lubrication	Semi-lubrication
Hook	Large hook
Height of presser foot lift	9mm by hand, 16mm by knee
Motor	370W clutch motor





4. Installing the oil pot (Fig. 2)

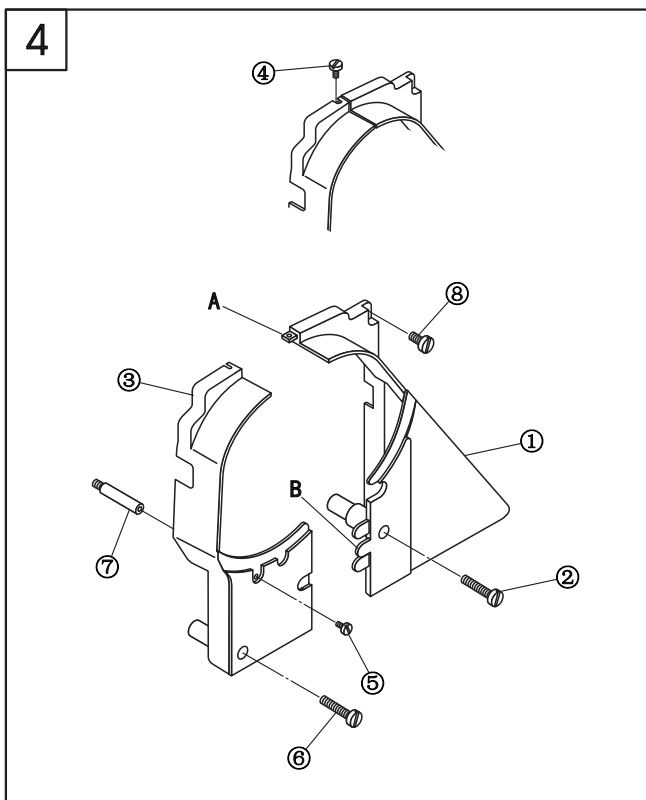
1. Install the bolt ①, oil seal ② and spacer ③ onto the oil reservoir, and then put the cushion ⑤ and spacer ⑧ into the set screw ④, then set it by nut ⑥.
2. Tighten the oil pot ⑦ onto the bolt ①.



5. Adjusting the tension of the belt (Fig.3)

When adjusting the tension of the belt, please adjust the height of the motor, and press down the middle of the belt with the force of 9.8N. There should be a slack of 15mm.

Note: Please turn off the motor before adjustment.



6. Installing the belt cover (Fig.4)

1. Tighten the column ⑦ into the screw hole on the machine head.
2. Install the belt cover (right) ① on the machine head by set screw ② and ⑧.
3. Connect the belt cover (left) ③ to the claw AB of the belt cover (right) ①.
4. Tighten the belt cover (left) ③ by set screws ④, ⑤ and ⑥.

Note: After installing the belt cover, make sure that the belt cover is not touch with the belt and hand wheel.

7. Lubrication (Fig.5)

1.Face plate lubrication

- Loosen the face plate screw;
- Open the face plate ① in the direction of the arrow;
- Lubricate the place as the arrow shows every day;
- Close the face plate;
- Tighten the screw.

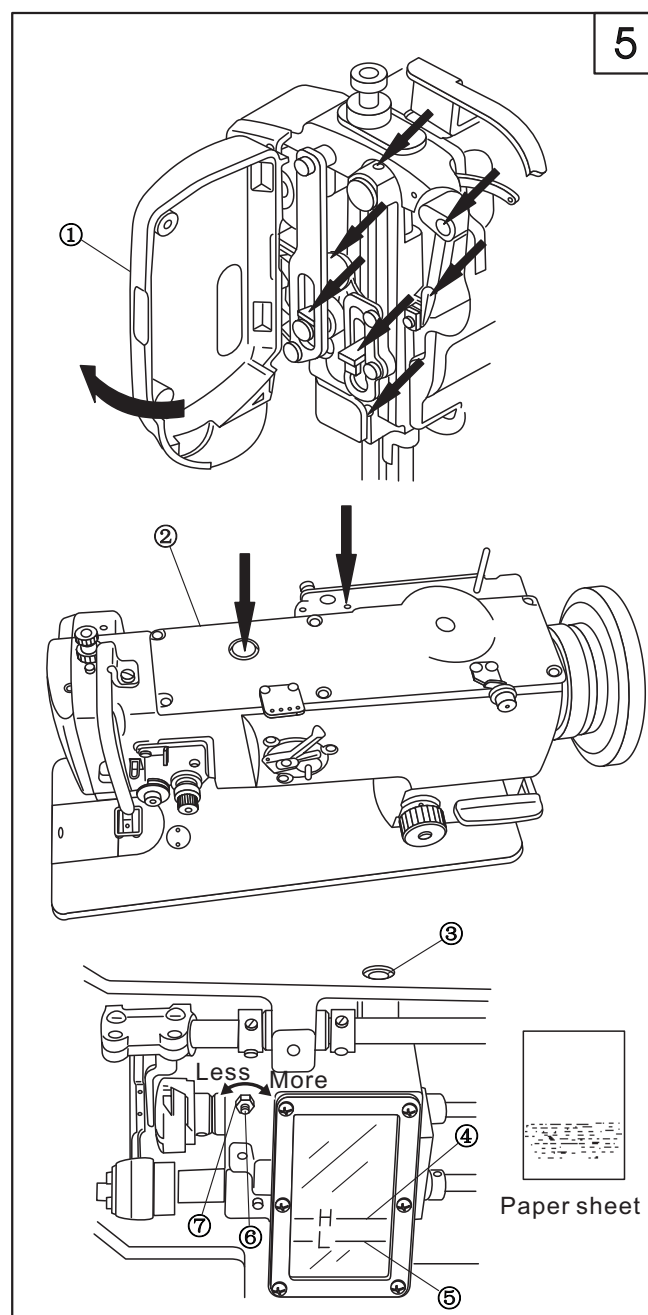
2.Machine body lubrication

- Lubricate the place as the arrows indicate every day;
- When run the machine for the first time or run it again after a long period of non-use, please oil the place as the arrows indicate. Besides, take down the top cover ②, then oil each felt and oil wick.

3.Rotating hook lubrication

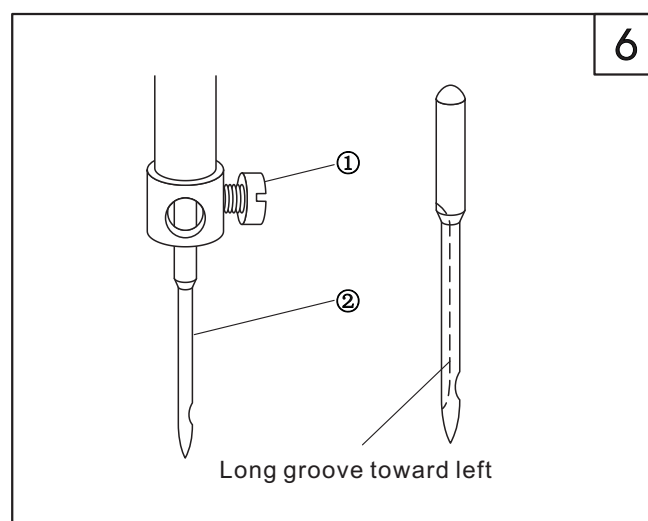
- Add the oil from oil hole ③ until it reaches the red line ④. Check it one time a day. If the oil is under the red line ⑤, it should be refilled.
- When adjusting the oil amount of the rotating hook, loosen the nut ⑦, and then adjust it by adjusting screw ⑥. Turn it rightward, the amount of the oil can be increased; on the contrary, the amount can be reduced.

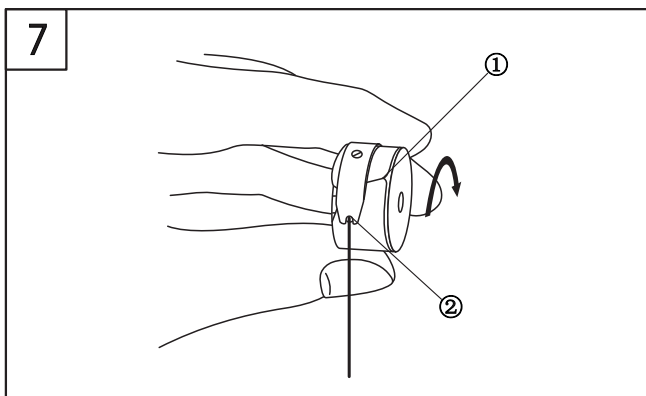
Note: Excess lubrication results in leaking.



8. Installing the needle (Fig.6)

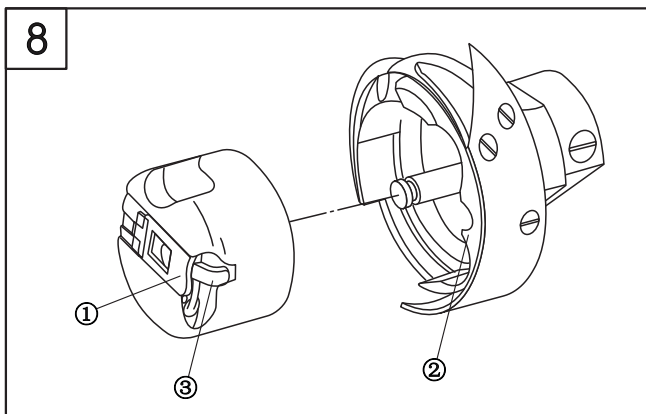
- Turn the balance wheel to raise the needle bar to its highest position;
- Loosen the set screw ② and make the long groove of the needle ① toward leftward;
- Insert the needle into the bottom of the needle bar;
- Tighten the set screw ②.





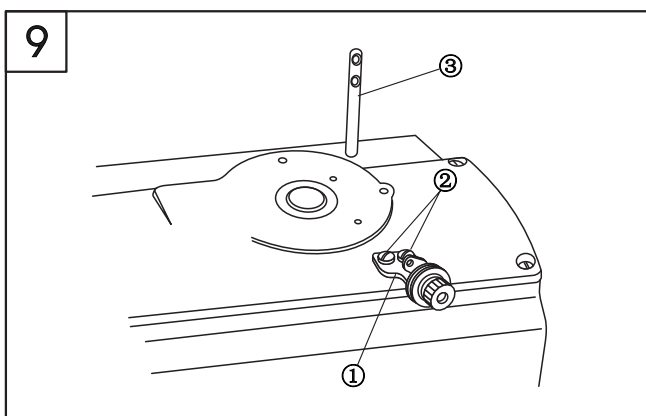
9. Threading the bobbin thread (Fig.7)

1. Insert the bobbin into the hook body, pass the thread through the thread hole ①, then pass down through the thread tension spring ②.
2. Draw the thread downward, then the bobbin will turn in the direction as the figure shows.



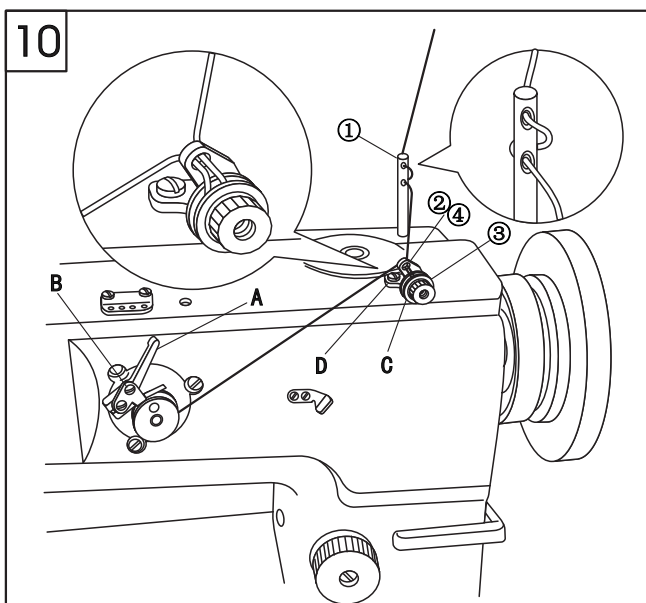
10. Installing the bobbin case (Fig. 8)

1. When taking out the bobbin case, open the gib ① and pull it off.
2. Align the bobbin case with the rotating hook shaft and then insert it. Align the inside of the rotating hook ② and the latch ③, then install the bobbin case by pressing it until "crack" occurs.



11. Installing the winding guider (Fig.9)

1. Set the winding guider ① onto the top cover of the machine head by set screw ②.
2. Insert the bobbin thread guider ③ into the machine head.

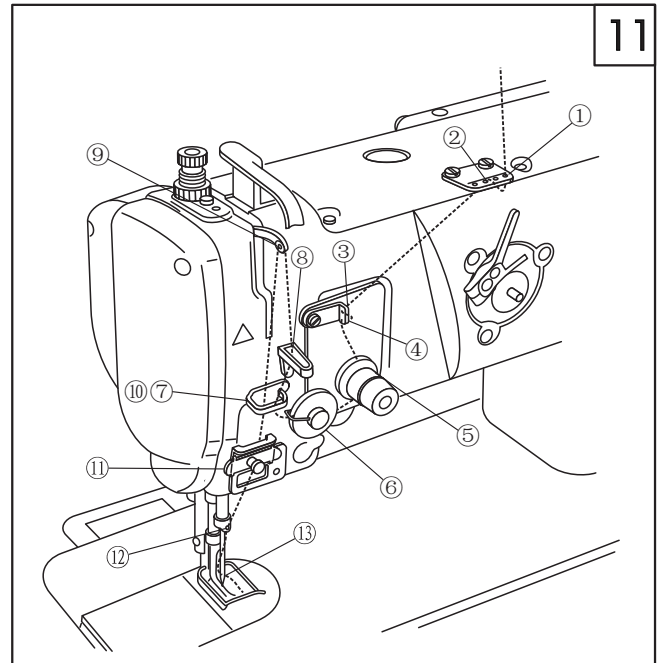


12. Winding the bobbin thread (Fig.10)

1. Thread in numerical order from ① to ④, then wind the bobbin winder.
2. Press down the bar A.
3. Loosen the set screw B and adjust the adjusting plate until the winding amount reaches the 80% of the outside diameter.
4. When the winding is not smooth, move the winding guider C forward and backward, then set it by set screw D.
5. After winding, the winding bar A will separate and stop automatically.

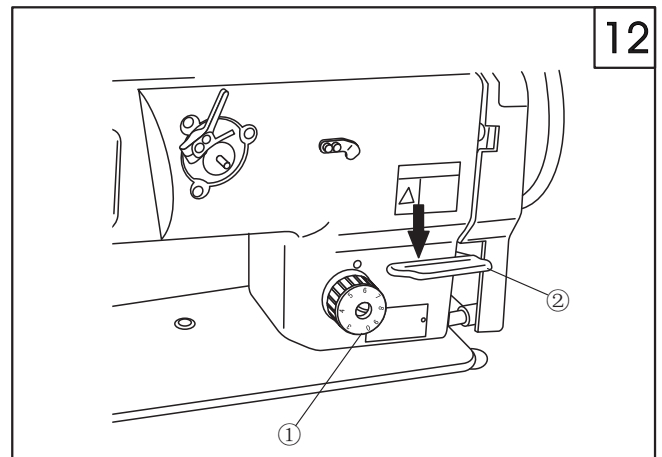
13. Threading (Fig11)

Thread in the order as shown in Fig.



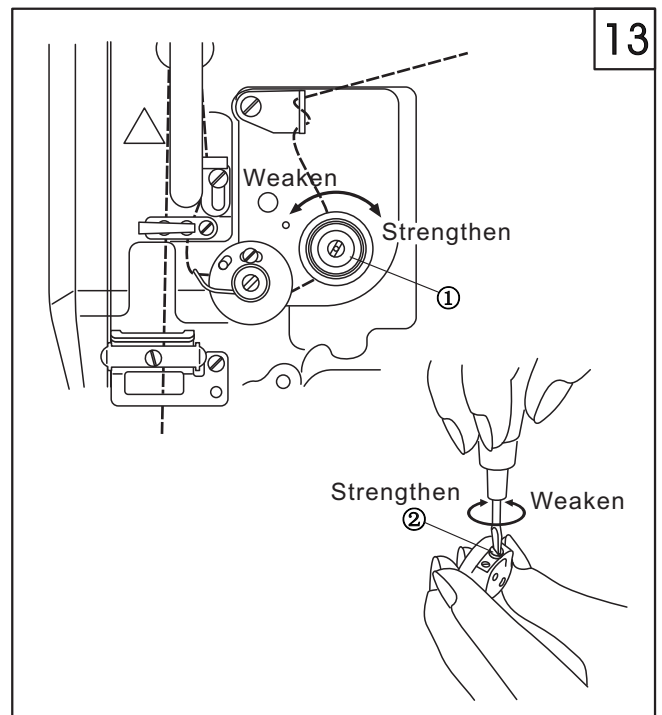
14. Adjusting the stitch length (Fig.12)

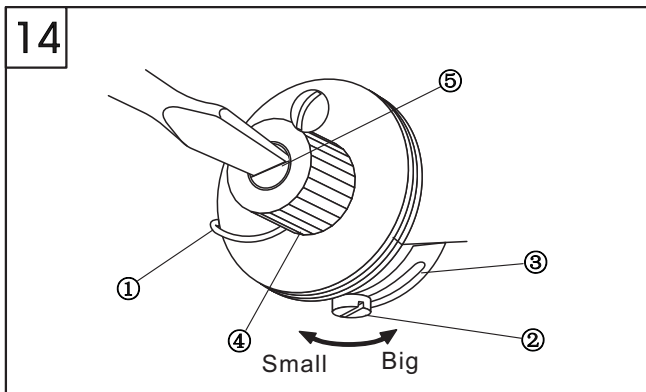
Turn the stitch length dial plate ① leftward and rightward to make the marker align with the required figure. Press down the reverse feed lever ② to start backward sewing, and release it to start normal sewing.



15. Adjusting the thread tension (Fig.13)

1. Adjusting the tension of the needle thread
Turn the nut ① clockwise to increase the tension of the needle thread; on the contrary, to reduce the tension of the needle thread.
2. Adjusting the tension of the bobbin thread.
Turn the screw ② clockwise to increase the tension of the bobbin thread, on the contrary, to reduce the tension of the bobbin thread.

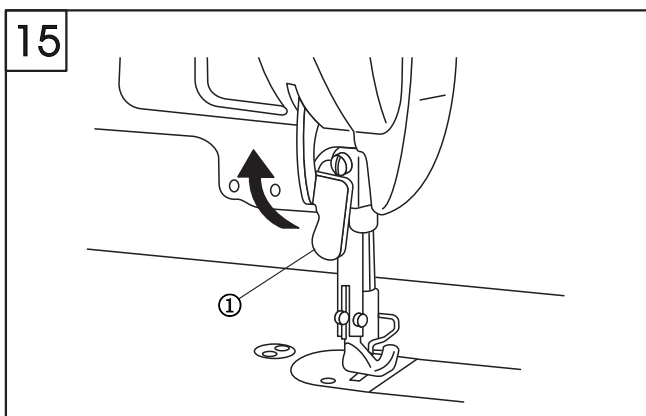




16. Adjusting the thread take-up spring (Fig.14)

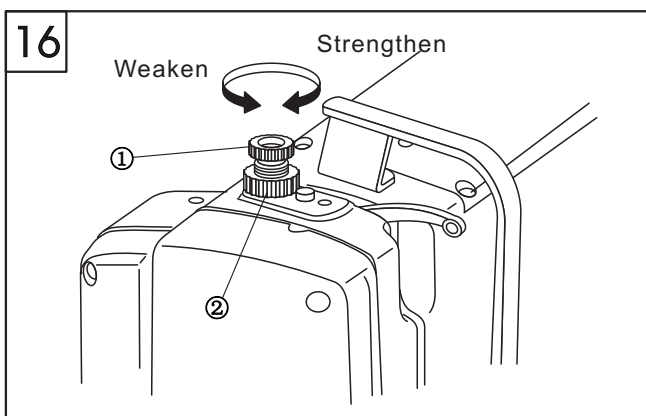
1. Changing the swing range of the thread take-up spring
 - a. Loosen the set screw ②, move the stopper ③ leftward and rightward, then adjust the thread take-up spring ①.
 - b. Move the stopper rightward to increase the swing range of the thread take-up spring; on the contrary, to reduce the swing range of the thread take-up spring.
2. Changing the tension of the thread take-up spring

Loosen the nut ④, turn the spring shaft ⑤ counter-clockwise to increase the tension; turn it clockwise to reduce the tension.



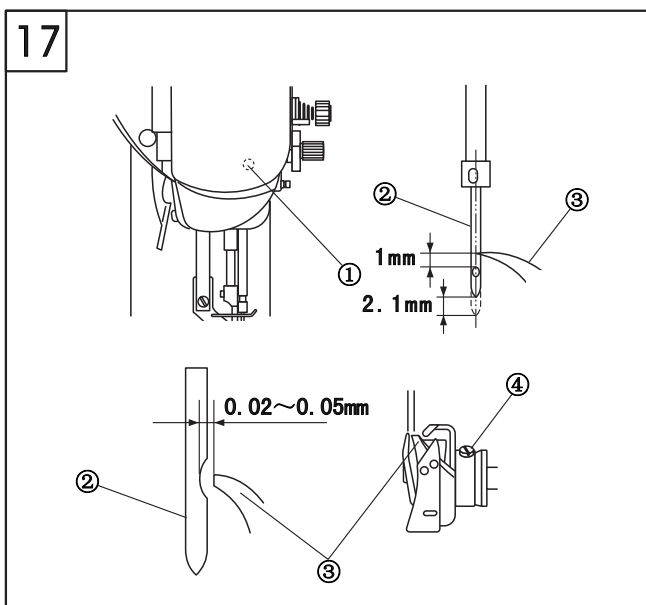
17. Presser foot lifter (Fig.15)

1. Stop the presser foot when it is lifted, lift the lifting bar ① in the direction of the arrow. When the presser foot is lifted by 9mm, then stop it.
2. When lowering the presser foot, put down the lifting bar ① to make the presser foot back to its original place.



18. Adjusting the pressure of the presser foot (Fig.16)

Turn the adjusting screw ① rightward to increase the pressure; turn it leftward to reduce the pressure. After adjustment, tighten the set nut ②.



19. Relationship between needle and rotating hook (Fig.17)

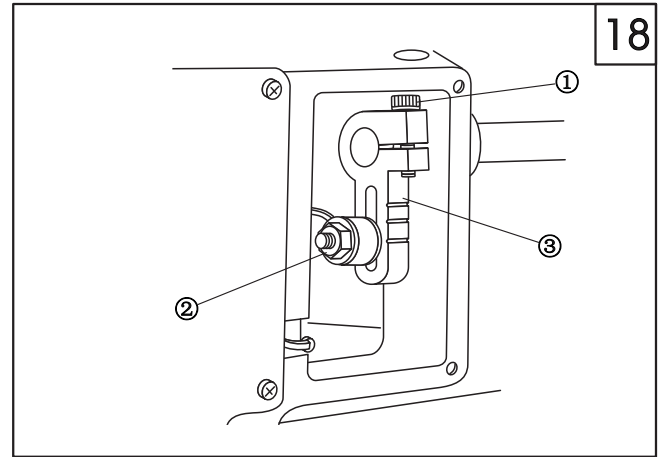
1. Adjust the stitch length dial to 0.
2. Turn the balance wheel to lift the needle bar from its lowest position by 2.1mm. Loosen the screw ①, adjust the distance between up end of the eye of needle ② and rotating hook point ③ to 1mm, then tighten it.
3. Turn the balance wheel to lift the needle bar from its lowest position by 2.1mm. Loosen the two set screws ④, turn the rotating hook, align the rotating hook point ③ with the center of the needle ②, then tighten the two screws ④.
4. Loosen the two set screws ④, move the rotating hook leftward and rightward. Align the rotating hook point ③ and the center of the needle ②, and adjust the clearance between rotating hook point and needle to 0.02-0.05mm, then tighten the screw.

20. Adjusting the alternating amount of presser foot (Fig.18)

When the presser foot is alternating increasingly, adjust it upward in the range of the long hole of the top feed crank ③; when the presser foot is alternating decreasingly, adjust it downward, then tighten the nut ②.

When the lifting amount of the presser and walking foot is different, first align the bottom of the presser foot and walking foot with the surface of the needle plate, then loosen the set screw ①. Turn the balance wheel to the front, the lifting amount of the presser foot is more than that of the walking foot. Turn the balance wheel reversely, the lifting amount of the walking foot is more than that of the presser foot. Finally tighten screw ②

Remove the right side of the window plate, then the top feed crank ③ can be observed.



21. Sewing speed list

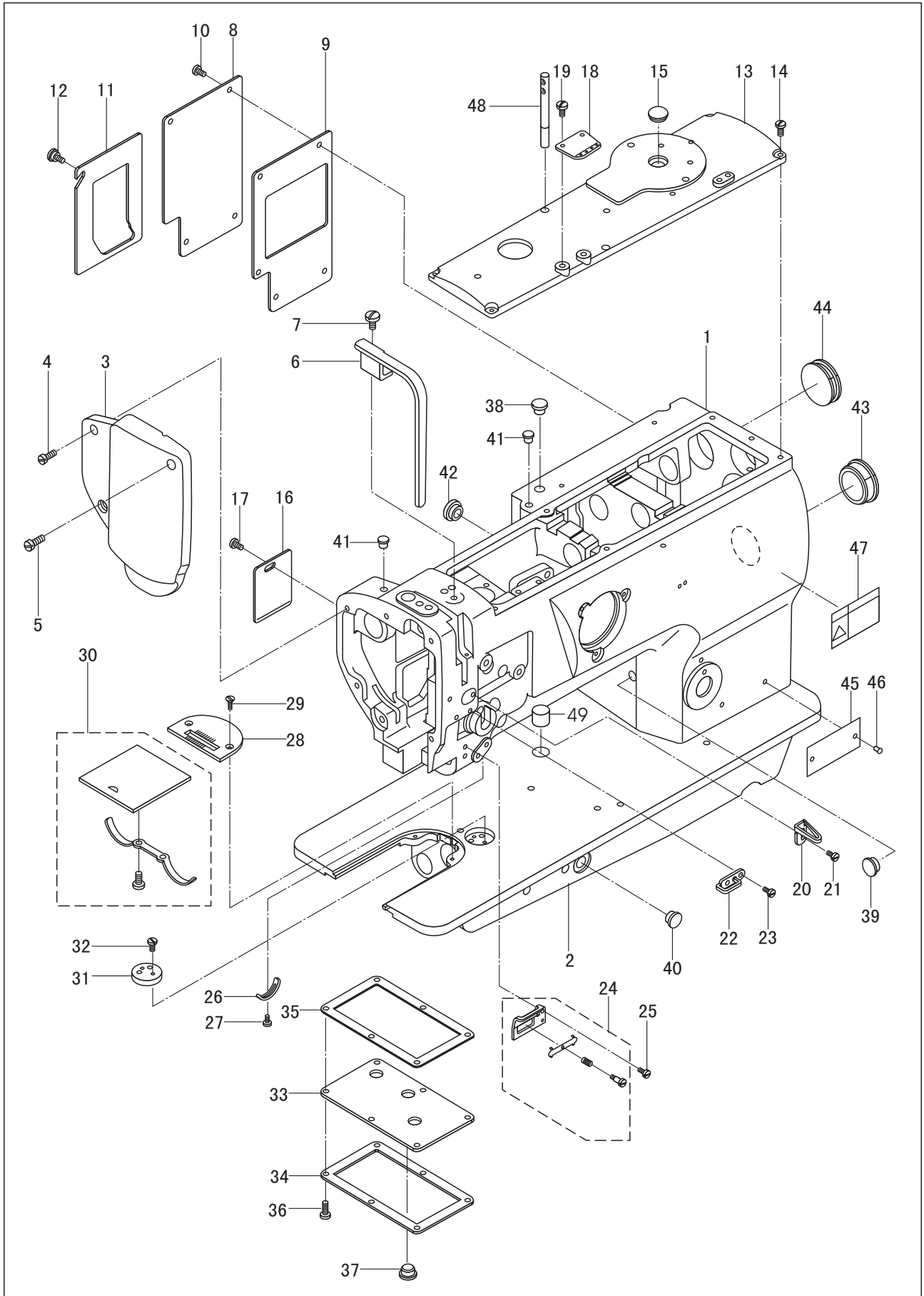
Alternating amount	Stitch less than 6mm	Stitch length between 6mm-9mm
Less than 3mm	2500s.p.m	2000s.p.m
Between 3~4mm	2000s.p.m	2000s.p.m
Between 4~6.5mm	1600s.p.m	1600s.p.m

22. Troubleshooting

Trouble	Possible cause	Remedy
1. Thread breaking (2-3mm thread left on the cloth)	<ol style="list-style-type: none"> 1. Damage on the rotating hook set groove of thread way, needle point, rotating hook point and needle plate. 2. Too strong the needle thread tension 3. Collision between needle and rotating hook. 4. Too little the oil of the rotating hook 5. Too weak the needle thread tension. 6. Too strong the tension of the thread take-up spring 7. Over fast or slow the timing between needle and rotating hook 	<ol style="list-style-type: none"> 1. Polish the damaged part with sand paper; rasp the middle rotating hook set groove with file. 2. Weaken the needle thread tension. 3. Refer to (19.Relationship between needle and rotating hook.) 4. Adjust the oil amount (Refer to 7. Lubrication) 5. Increase the needle thread tension. 6. Weaken the tension of the thread take-up spring. 7. Refer to (19. Relationship between needle and rotating hook)
2. Puckering	<ol style="list-style-type: none"> 1. Over fast or slow the timing between needle and rotating hook. 2. Too weak the pressure of the presser foot. 3. The clearance between the up end of the needle and the rotating hook is not right. 4. Wrong needle. 	<ol style="list-style-type: none"> 1. Refer to (19. Relationship between needle and rotating hook). 2. Tighten the presser foot adjusting screw. 3. Refer to (19.Relationship between needle and rotating hook.) 4. Replace the needle.
3. Loose stitch	<ol style="list-style-type: none"> 1. Without threading the bobbin thread under the spring of the thread tension of the rotating hook body. 2. Bad work on thread way. 3. No movement of bobbin. 4. Too weak the bobbin thread tension. 5. Too strong the bobbin thread tension. 6. Damage of the needle point. 	<ol style="list-style-type: none"> 1. Refer to (9.Threading the bobbin thread) 2. Rast with sand paper or file. 3. Replace the bobbin or rotating hook 4. Increase the bobbin thread tension. 5. Reduce the bobbin thread tension. 6. Replace the needle.

Parts Manual

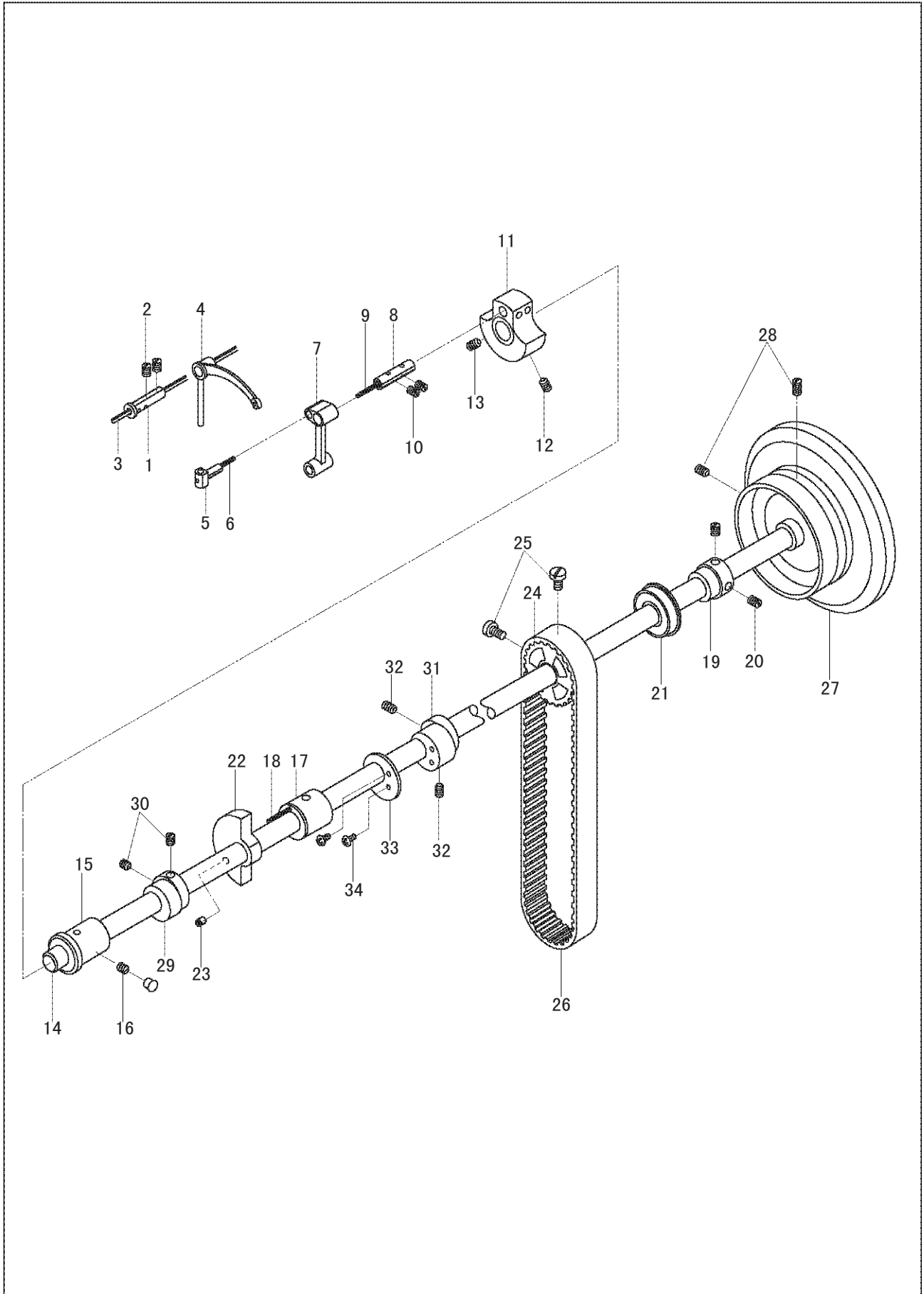
1. Arm and bed



1. Arm and bed

Line	Part Number	Description	Qt.	Notes
1	400-1001	Arm	1	
2	400-1002	Bed	1	
3	400-1003	Face plate assembly	1	
4	200-1301	Screw (1)	2	SM11/64"X40
5	400-1004	Screw (2)	1	SM15/64"X28
6	400-1005	Safe guard	1	
7	400-1006	Screw	1	SM15/64"X28
8	400-1007	Side cover (1)	1	
9	400-1008	Seal spacer	1	
10	200-1019	Screw	5	SM11/64"X40
11	400-1009	Side cover (2)	1	
12	400-1010	Screw	1	SM11/64X40
13	400-1011	Upper cover	1	
14	200-1019	Screw	6	SM11/64"X40
15	400-1012	Rubber plug	1	
16	400-1013	Small cover	1	
17	200-1019	Screw	1	SM11/64"X40
18	400-1014	Upper thread guide plate	1	
19	400-1015	Screw	2	SM3/16"X32
20	400-1016	Upper thread guide	1	
21	400-1017	Screw	1	SM9/64"X40
22	400-1018	Middle thread guide	1	
23	200-1030	Screw	2	SM9/64"X40
24	400-1019	Lower thread guide assembly	1	
25	200-1030	Screw	1	SM9/64"X40
26	400-1020	Position plate	1	
27	200-1077	Screw	1	SM9/64"X40
28	100-1043	Needle plate	1	
29	400-1021	Screw	2	SM11/64"X40
30	400-1022	Slide plate assembly	1	
31	400-1023	Clamp holder	1	
32	100-1129	Screw	2	SM11/64"X40
33	400-1024	Oil screen	1	
34	400-1025	Presser plate	1	
35	400-1026	Seal spacer	1	
36	400-1027	Screw	6	SM11/64X40
37	400-1028	Rubber plug	3	
38	400-1028	Rubber plug	1	
39	400-1028	Rubber plug	1	
40	400-1028	Rubber plug	1	
41	400-1029	Rubber plug	2	
42	400-1030	Rubber plug	1	
43	400-1031	Rubber plug	1	
44	400-1032	Rubber plug	1	
45	400-1033	Model label	1	
46	400-1034	Rivet	2	GB827 2X5
47	400-1035	Safety caution label	1	
48	400-1036	Upper thread guide bar	1	
49	400-1037	plug	/	

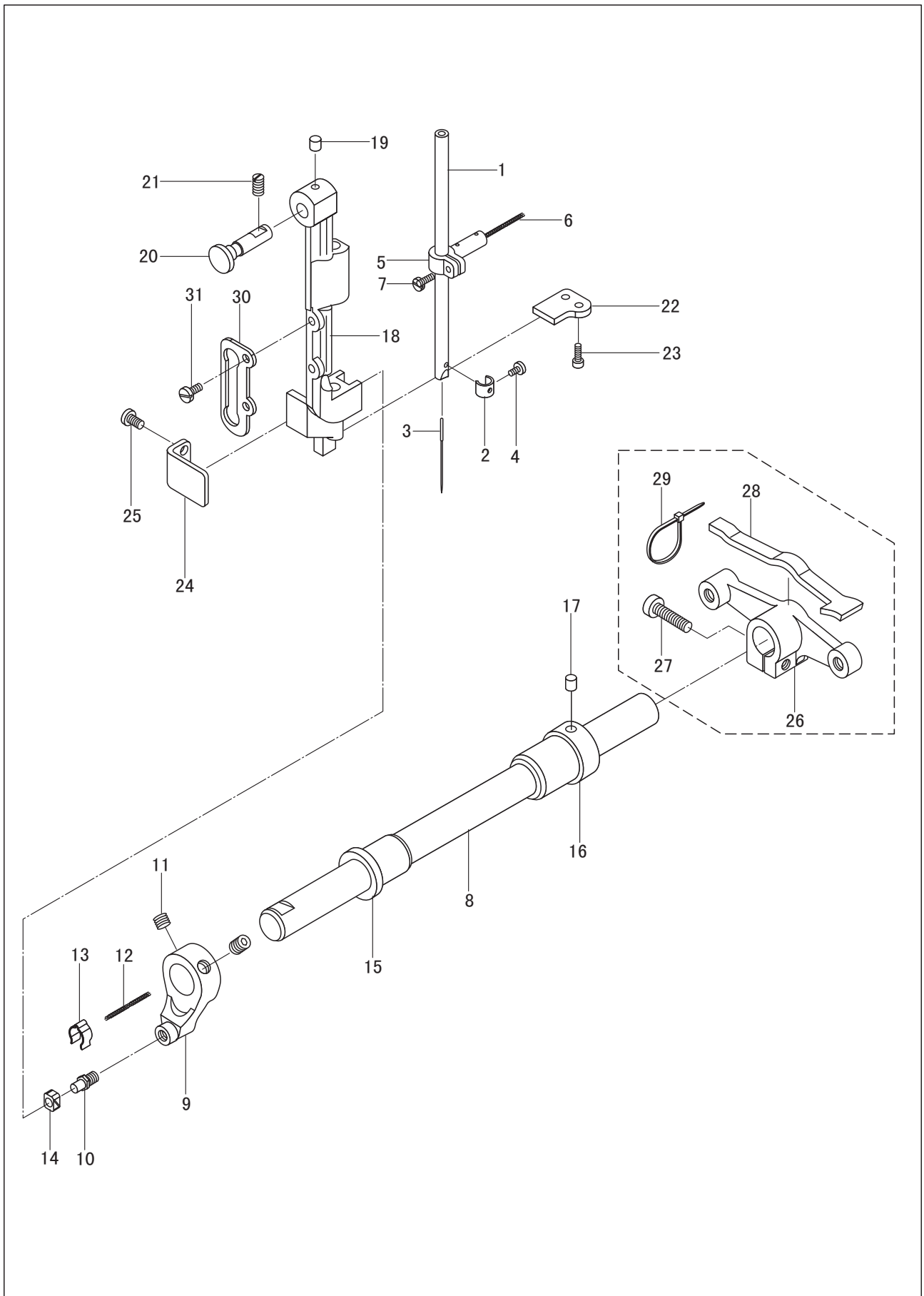
2. Upper shaft and thread take-up mechanism



2. Upper shaft and thread take-up mechanism

Line	Part Number	Description	Qt.	Notes
1	400-1038	Thread take-up lever pin shaft	1	103530
2	100-1049	Screw	2	SM15/64"X28
3	400-1039	Oil wick	1	φ2.5X155
4	400-1040	Thread take-up lever	1	
5	400-1041	Slide block	1	
6	400-1042	Oil wick	1	
7	400-1043	Needle bar link	1	
8	400-1044	Needle bar crank pin	1	
9	400-1045	Oil wick	1	
10	100-1049	Screw	2	SM15/64"X28
11	400-1046	Needle bar crank	1	
12	100-1071	Screw	1	SM9/32"X28
13	400-1047	Screw	1	SM9/32"X28
14	400-1048	Upper shaft	1	
15	400-1049	Upper shaft front bushing	1	
16	100-1049	Screw	1	SM15/64"X28
17	400-1050	Upper shaft middle bushing	1	
18	400-1051	Oil wick	1	φ2x120
19	400-1052	Bearing bushing	1	
20	400-1053	Screw	2	
21	400-1054	Upper bearing	1	6005-2ZNR
22	400-1055	Balance shock	1	
23	400-1056	Screw	2	SM15/64"X28
24	400-1057	Synchronized pulley assembly	1	
25	400-1058	Screw	2	SM1/4"X40
26	400-1059	Synchronized belt	1	540-8YU-15
27	400-1060	Hand wheel	1	
28	100-1049	Screw	2	SM15/64"X28
29	400-1061	Lift eccentric cam	1	
30	200-1109	Screw	2	SM1/4"X40
31	400-1062	Feed eccentric cam	1	
32	200-1109	Screw	2	SM1/4"X40
33	400-1063	Retaining block	1	
34	400-1064	Screw	2	SM11/64"X40

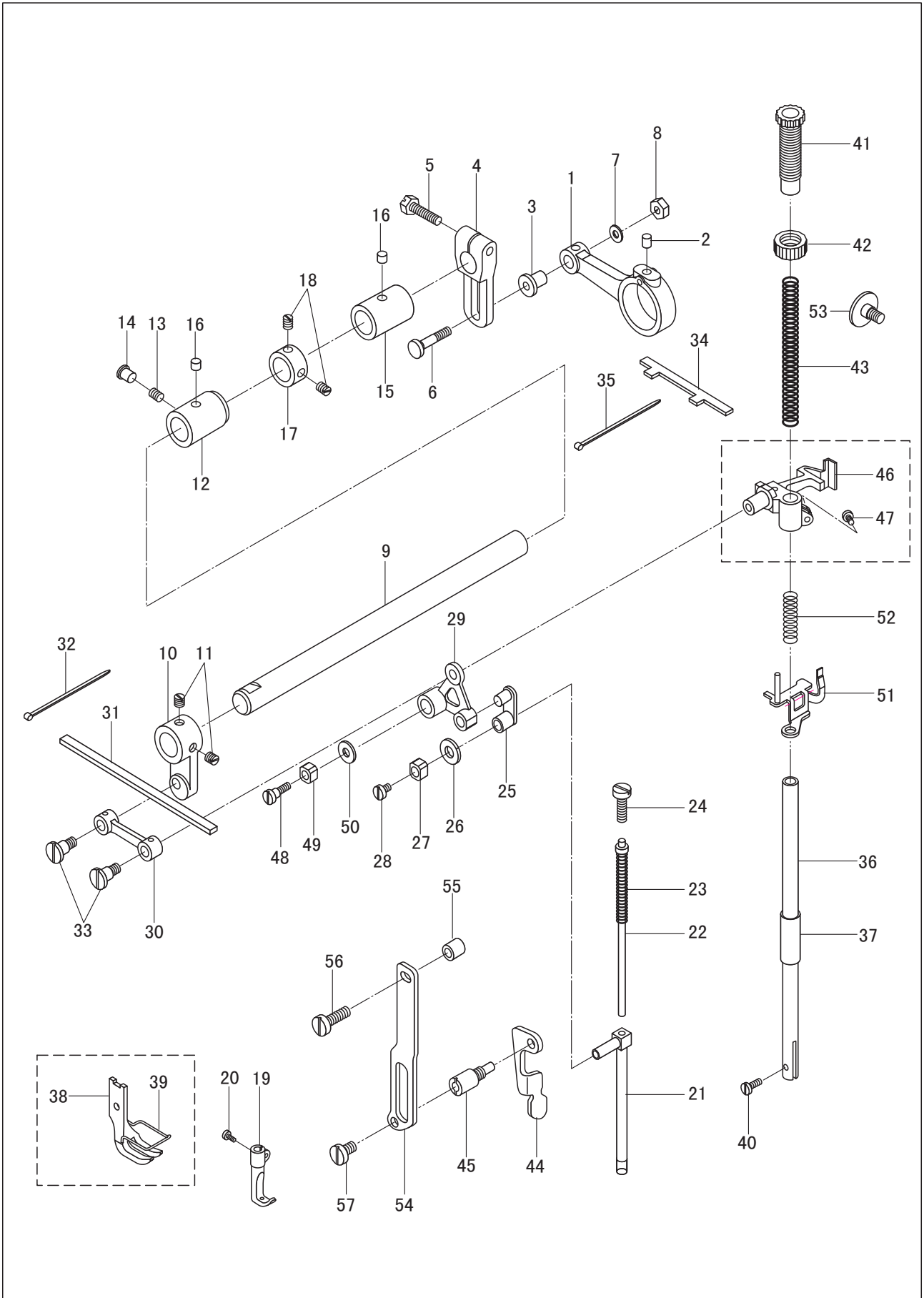
3. Needle bar vibrating parts



3. Needle bar vibrating parts

Line	Part Number	Description	Qt.	Notes
1	400-1065	Needle bar	1	
2	400-1066	Needle bar thread guide	1	
3	400-1067	Needle	1	135X17#23
4	200-1166	Screw	1	SM1X8"X44
5	400-1068	Needle bar adapter	1	
6	400-1069	Oil wick	1	
7	400-1070	Screw	1	SM9X64"X40
8	400-1071	Vibrating shaft	1	
9	400-1072	Crank	1	
10	400-1073	Crank pin	1	
11	400-1074	Screw	2	GB/T80 M8X8
12	400-1075	Oil felt	1	φ1.5 20
13	400-1076	Spring	1	
14	400-1077	Slide block	1	
15	400-1078	Vibrating shaft front bushing	1	
16	400-1079	Vibrating shaft rear bushing	1	
17	400-1080	Oil felt	1	
18	400-1081	Needle bar vibrating bracket	1	
19	400-1080	Oil felt	1	
20	400-1082	Hinge shaft	1	
21	200-1123	Screw	1	SM15/64"X28
22	400-1083	Position plate (1)	1	
23	400-1084	Screw	2	SM9/64"X40
24	400-1085	Position plate (2)	1	
25	200-1019	Screw	2	SM11/64"X40
26	400-1086	Driven crank	1	
27	400-1087	Screw	1	SM15/64"X28
28	400-1088	Oil felt	1	
29	400-1089	Wire	2	
30	400-1090	Guide rail	1	
31	200-1019	Screw	2	SM11/64"X40

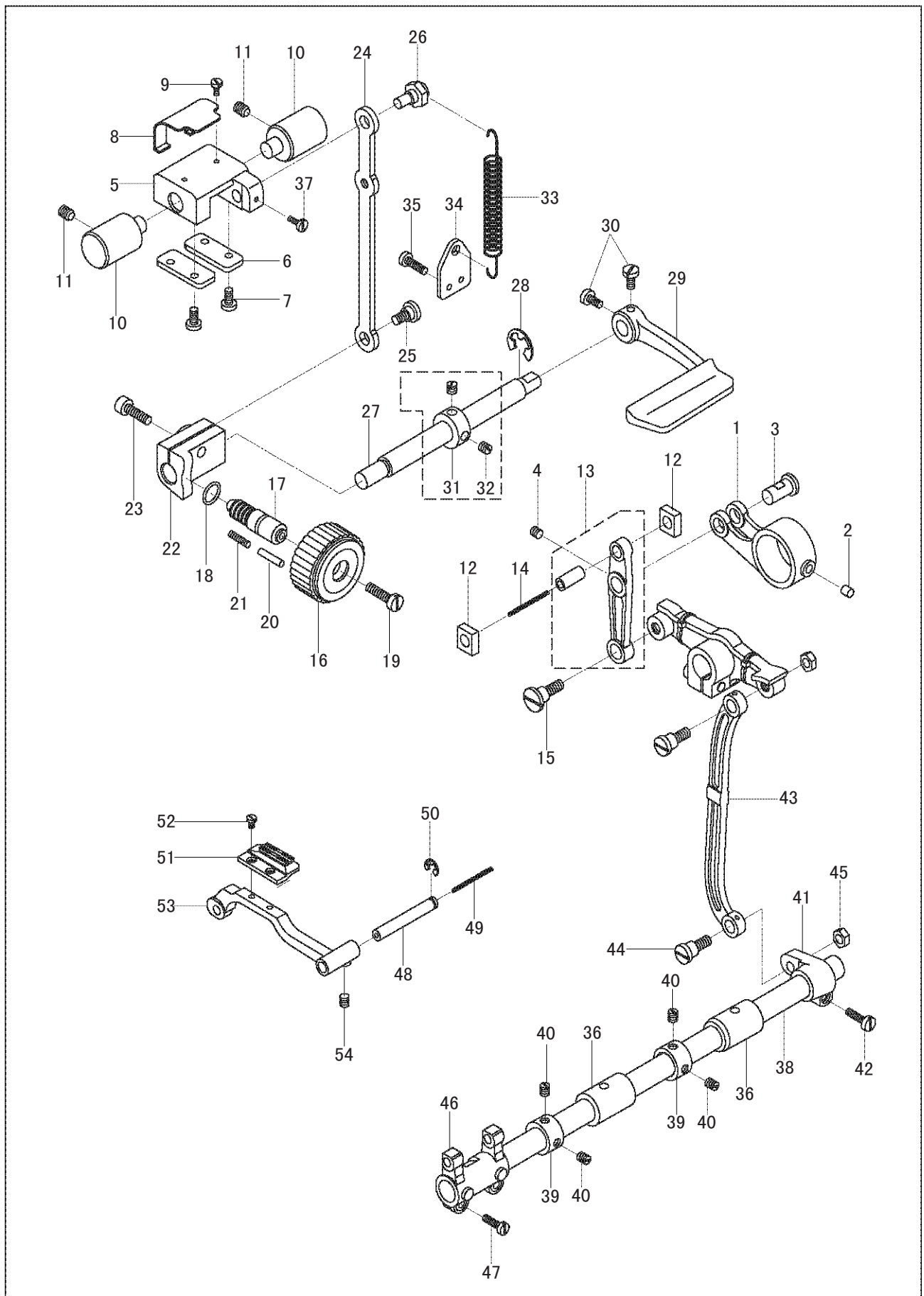
4. Upper feed parts



4. Upper feed parts

Line	Part Number	Description	Qt.	Notes
1	400-1091	Connecting bar	1	
2	400-1080	Oil felt	1	
3	400-1092	Connecting pin	1	
4	400-1093	Adjusting crank	1	
5	400-1094	Screw	1	GB5781-86 M6X22
6	400-1095	Screw	1	SM11/64"X40
7	400-1096	Washer	1	
8	400-1097	Nut	1	SM11/64"X40
9	400-1098	Upper feed shaft	1	
10	400-1099	Upper feed crank	1	
11	400-1100	Screw	2	SM1/4"X40
12	400-1101	Upper feed shaft bushing (left)	1	
13	100-1049	Screw	1	SM15/64"X28
14	400-1029	Rubber plug	1	
15	400-1102	Upper feed bushing (right)	1	
16	400-1103	Oil wick	2	φ6x10
17	400-1104	Collar	1	
18	400-1105	Screw	2	SM1/4"x40
19	400-1106	Walking foot	1	
20	400-1107	Screw	1	SM11/64"X40
21	400-1108	Walking foot lifting bar	1	
22	400-1109	Spring guide assembly	1	
23	400-1110	Presser spring	1	
24	400-1111	Screw	1	SM15/64"X28
25	400-1112	Link	1	
26	400-1113	Oil felt	1	
27	400-1114	Slide block	1	
28	100-1284	Screw	1	SM11/64"X40
29	400-1115	Foot lifting plate	1	
30	400-1116	Foot lifting link	1	
31	400-1117	Oil felt	1	
32	400-1118	Binding cord	2	
33	400-1119	Screw	2	
34	400-1120	Oil felt	1	
35	400-1118	Binding cord	1	
36	400-1121	Presser bar	1	
37	400-1122	Presser bar bushing	1	
38	400-1123	Presser foot	1	
39	400-1124	Finger guard	1	
40	400-1070	Screw	1	SM9/64"X40
41	400-1125	Screw	1	SM1/2"X28
42	100-1110	Nut	1	SM1/2"X28
43	400-1126	Spring	1	
44	400-1127	Presser foot lifting bar	1	
45	400-1128	Lifting bar shift	1	
46	400-1129	Releasing bracket	1	
47	200-1019	Screw	1	SM11/64"X40
48	400-1130	Screw	1	
49	400-1131	Slide block	1	
50	400-1132	Washer	1	
51	400-1133	Releasing plate	1	
52	400-1134	Spring	1	
53	400-1135	Screw	1	SM1/4"X28
54	400-1136	Presser bar guide plate	1	
55	400-1137	Washer	1	
56	400-1138	Screw (upper)	1	SM15/64"X28
57	400-1139	Screw (lower)	1	SM15/64"X28

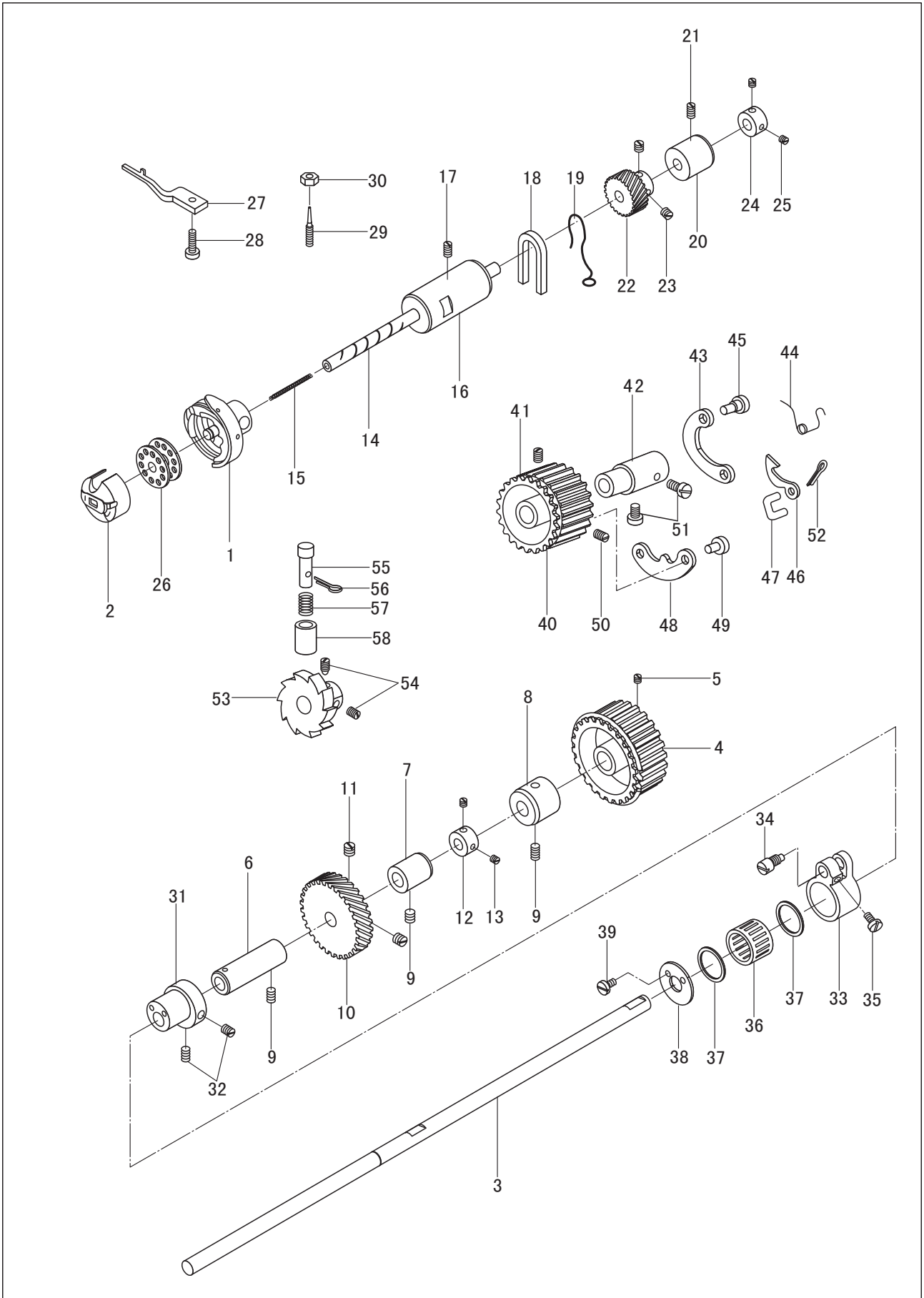
5. Feed parts



5. Feed parts

Line	Part Number	Description	Qt.	Notes
1	400-1140	Feed link	1	
2	400-1141	Oil felt	1	
3	400-1142	Link pin	1	
4	100-1089	Screw	1	
5	400-1143	Reverse feed bracket	1	
6	400-1144	Retaining plate	2	
7	200-1019	Screw	4	SM11/64"X40
8	400-1145	Presser plate	1	
9	400-1146	Screw	2	SM11/64"X40
10	400-1147	Reverse feed bracket shaft	2	
11	100-1049	Screw	2	SM15/64"X40
12	400-1148	Slide block	2	
13	400-1149	Feed vibrating bar assembly	1	
14	400-1150	Oil wick	1	φ1.5 35
15	400-1151	Screw	1	
16	400-1152	stitch length adjusting dial	1	
17	400-1153	Bolt	1	
18	400-1154	Seal ring	1	
19	400-1155	Screw	1	SM3/16"X28
20	400-1156	Stop pin	1	
21	400-1157	Spring	1	
22	400-1158	Stitch length holder	1	
23	400-1159	Screw	1	
24	400-1160	Link	1	
25	400-1161	Screw	1	
26	400-1162	Eccentric pin	1	
27	400-1163	Reverse feed lever shaft	1	
28	400-1164	Retainer	1	GB896-86-9
29	400-1165	Reverse feed lever	1	
30	400-1166	Screw	2	SM3/16"X28
31	400-1167	Collar	1	
32	400-1105	Screw	2	SM1/4"X40
33	400-1168	Spring	1	
34	400-1169	Spring hook	1	
35	200-1405	Screw	2	SM11/64"X40
36	400-1102	Feed shaft bushing	2	
37	400-1170	Screw	2	
38	400-1171	Feed shaft	1	
39	400-1104	Collar	2	
40	400-1105	Screw	4	SM1/4"X40
41	400-1172	Crank	1	
42	400-1173	Screw	1	SM3/16"X28
43	400-1174	Link	1	
44	400-1175	Screw	2	
45	400-1176	Nut	2	SM9/32"X28
46	400-1177	Feed crank	1	
47	200-1405	Screw	2	SM11/64"X40
48	400-1178	Connecting pin	1	
49	400-1179	Oil wick	1	φ3 50
50	400-1180	Retainer	1	GB896 5
51	400-1181	Feed dog	1	
52	400-1182	Screw	2	SM1/8"X44
53	400-1183	Feed dog support	1	
54	400-1184	Screw	1	

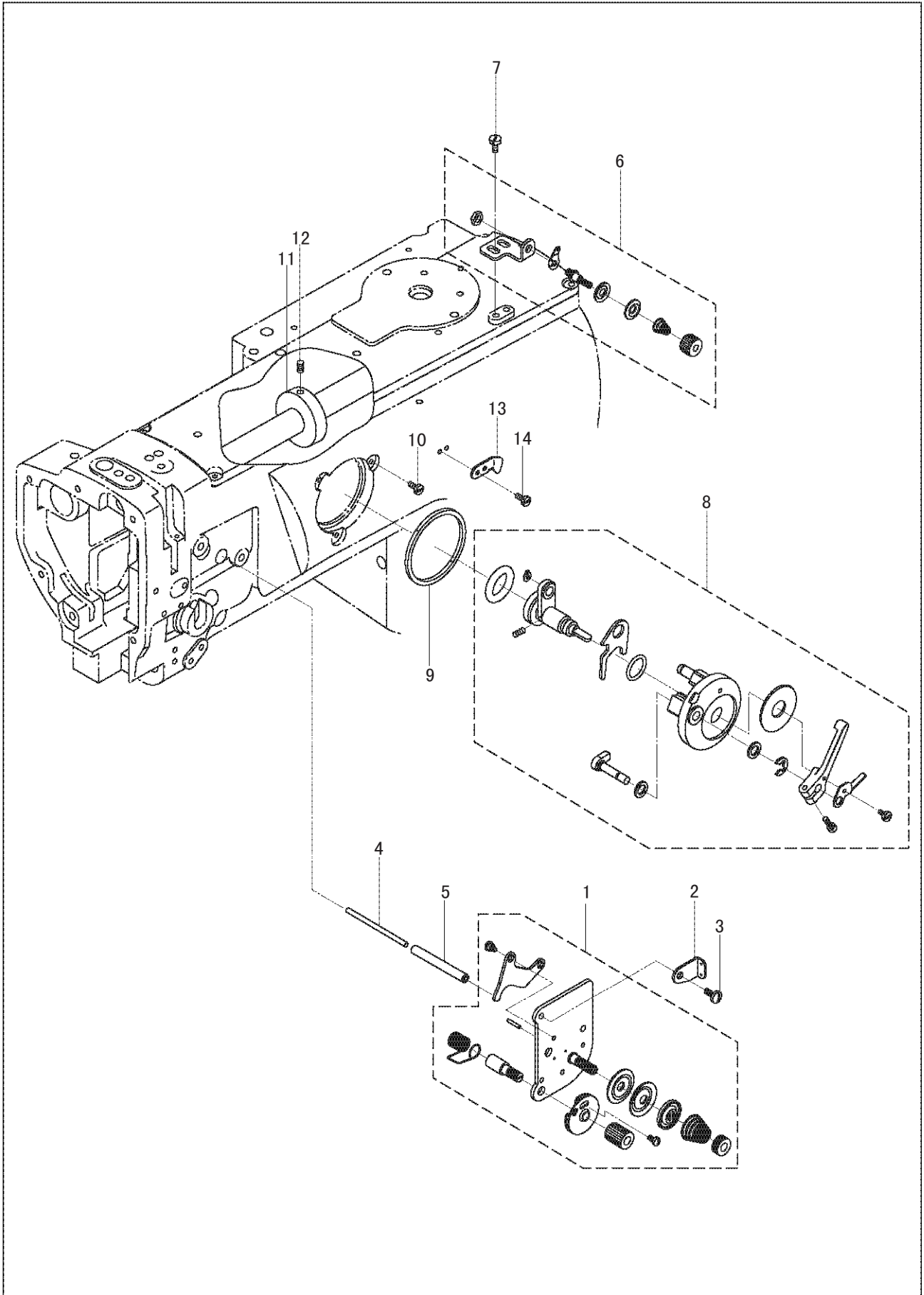
6. Lower shaft mechanism



6. Lower shaft mechanism

Line	Part Number	Description	Qt.	Notes
1	400-1185	Hook CPL	1	
2	100-1250	Bobbin case CPL	1	
3	400-1186	Lower shaft	1	
4	400-1187	Lower shaft synchronized pulley CPL	1	
5	400-1058	Screw	2	SM1/4"X40
6	400-1188	Lower shaft bushing (L)	1	
7	400-1189	Lower shaft bushing (M)	1	
8	400-1190	Lower shaft bushing (R)	1	
9	400-1191	Screw	3	SM15/64"X28
10	400-1192	Lower shaft gear	1	
11	400-1100	Screw	2	SM1/4"X40
12	400-1193	Collar	1	
13	400-1194	Screw	2	SM11/16"X40
14	400-1195	Hook driving shaft	1	
15	400-1196	Oil wick	1	
16	400-1197	Hook driving shaft bushing (L)	1	
17	400-1198	Screw	1	SM15/64"X28
18	400-1199	Oil felt	1	
19	400-1200	Spring	1	
20	400-1201	Hook driving shaft bushing (R)	1	
21	400-1198	Screw	1	SM15/64"X28
22	400-1202	Hook driving gear	1	
23	400-1203	Screw	2	SM1/4"X40
24	400-1204	Collar	1	
25	400-1205	Screw	2	SM11/64"X40
26	400-1206	Bobbin	1	
27	400-1207	Bobbin case opener	1	
28	400-1208	Screw	1	SM11/64"X40
29	400-1209	Screw	1	SM11/64"X40
30	400-1097	Nut	1	SM11/64"X40
31	400-1210	Eccentric cam	1	
32	400-1211	Screw	2	SM15/64"X28
33	400-1212	Feed dog lift link	1	
34	400-1213	Eccentric pin	1	
35	400-1214	Screw	1	SM11/64"X40
36	400-1215	Bearing	1	K202417
37	400-1216	Retainer	2	
38	400-1217	Cover	1	
39	400-1146	Screw	2	SM9/64"X40
40	400-1218	Lower shaft synchronized pulley	1	
41	400-1219	Retaining ring	1	
42	400-1220	Pulley bushing	1	103614
43	400-1221	Spring plate	1	
44	400-1222	Spring plate	1	
45	400-1223	Pin	1	
46	400-1224	Stop plate	1	
47	400-1225	Link	1	
48	400-1226	Clutch plate	1	
49	400-1227	Clutch plate pin	1	
50	400-1228	Screw	2	
51	400-1229	Screw	2	
52	400-1230	Pin	1	GB/T991 1.2X8
53	400-1231	Clutch wheel	1	
54	100-1089	Screw	2	
55	400-1232	Button	1	
56	400-1233	Pin	1	
57	400-1234	Spring plate	1	
58	400-1235	Button bushing	1	

7. Thread tension and bobbin thread winder mechanism

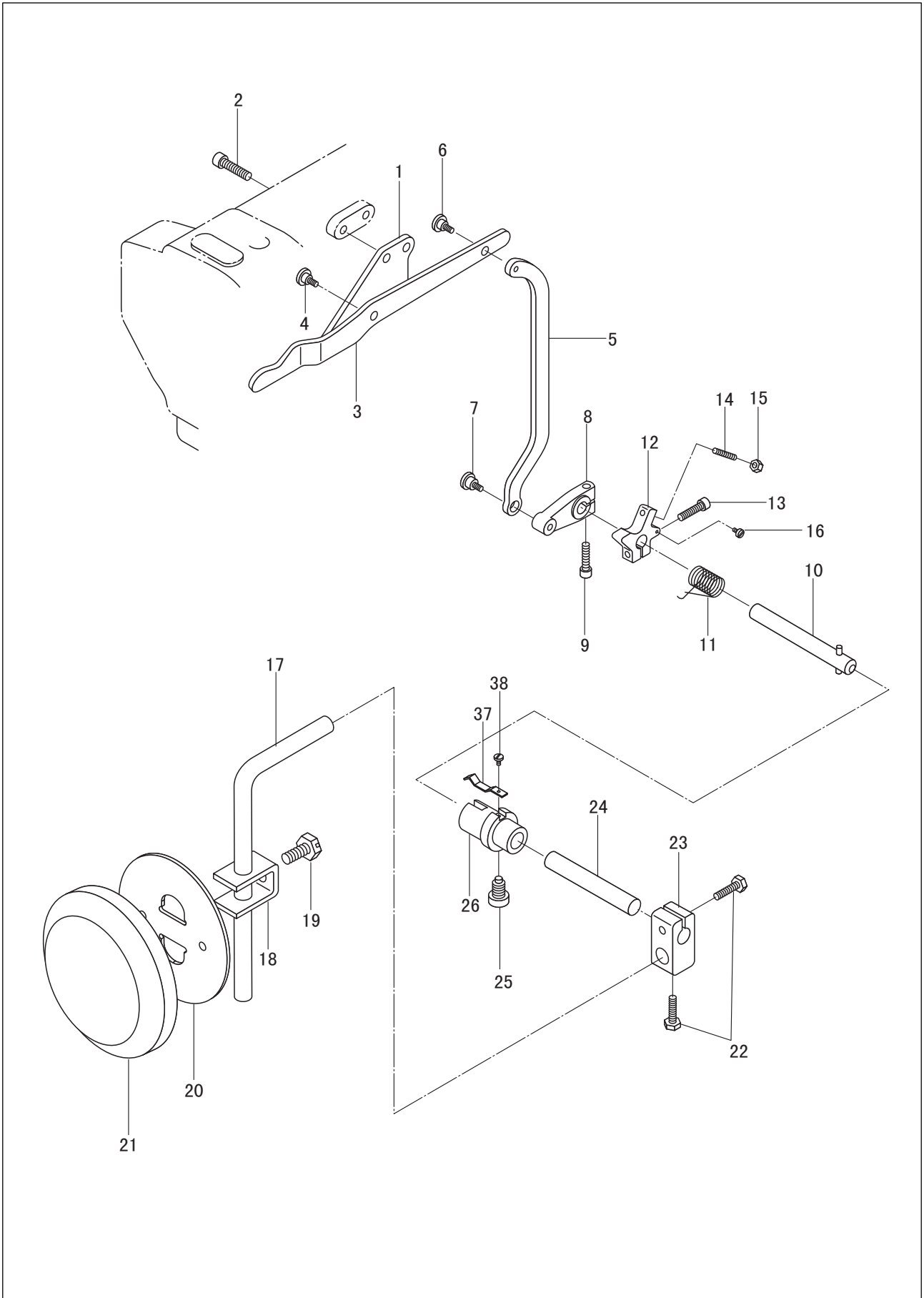


7. Thread tension and bobbin thread winder mechanism

Line	Part Number	Description	Qt.	Notes
1	400-1236	Thread tension plate assembly	1	
2	400-1237	Thread guide plate	1	
3	200-1019	Screw	2	SM11/64"X40
4	400-1238	Thread releasing bar	1	
5	400-1239	Thread releasing bar bushing	1	GB/T879.1 6X55
6	400-1240	Bobbin thread tension assembly	1	
7	400-1241	Screw	1	
8	400-1242	Thread winder assembly	1	
9	400-1243	Friction ring	1	
10	400-1244	Screw	3	SM11/64"X40
11	400-1245	Friction wheel	1	
12	100-1089	Screw	2	
13	400-1246	Cutter	1	
14	100-1047	Screw	2	

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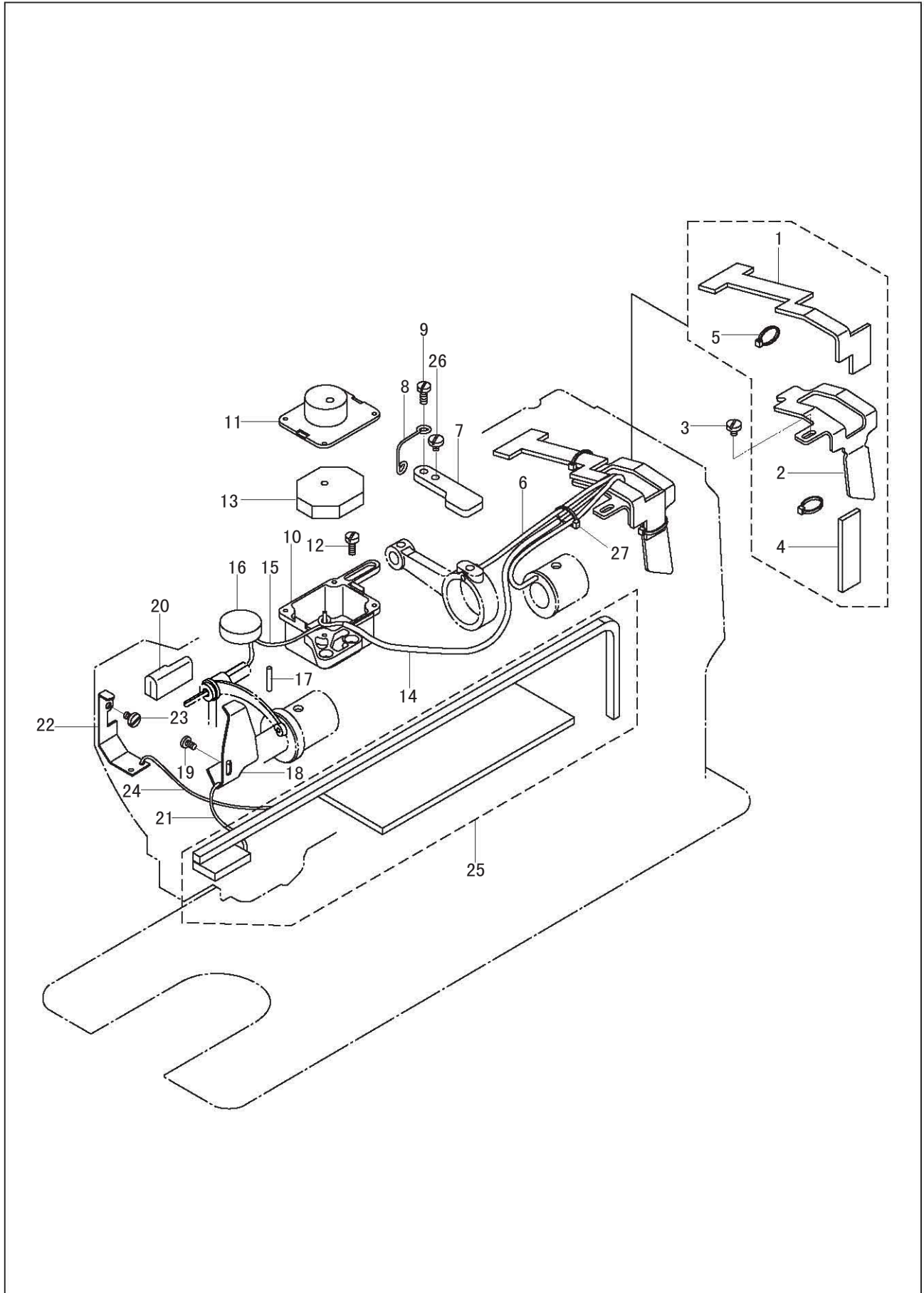
8. Knee lifter mechanism



8. Knee lifter mechanism

Line	Part Number	Description	Qt.	Notes
1	400-1247	Knee control lever support	1	
2	400-1248	Screw	2	
3	400-1249	Knee control lever support	1	
4	400-1250	Screw	1	SM1/4"X40
5	400-1251	Knee control connecting rod	1	
6	400-1252	Screw	1	SM11/64"X40
7	400-1250	Screw	1	SM1/4"X40
8	400-1253	Crank	1	
9	400-1254	Screw	1	
10	400-1255	Knee control revolving shaft	1	
11	400-1256	Spring	1	
12	400-1257	Position block	1	
13	400-1254	Screw	1	
14	400-1258	Screw	1	GB/T77 M5X25
15	400-1259	Nut	1	GB/T6172.1 M5
16	400-1260	Screw	1	SM9/64"X40
17	100-1329	Knee control bell bent bar	1	
18	100-1331	Bell bracket	1	
19	100-1332	Screw	1	
20	100-1330	Knee control bell	1	
21	100-1333	Cushion	1	
22	400-1261	Screw	2	SM5/16"X24
23	400-1262	Bell bent adapter	1	
24	400-1263	Knee control connecting bar	1	
25	400-1264	Screw	1	SM5/16"X24
26	400-1265	Connecting bushing	1	
27	400-1266	Spring	1	
28	400-1267	Screw	1	SM9/64"X40

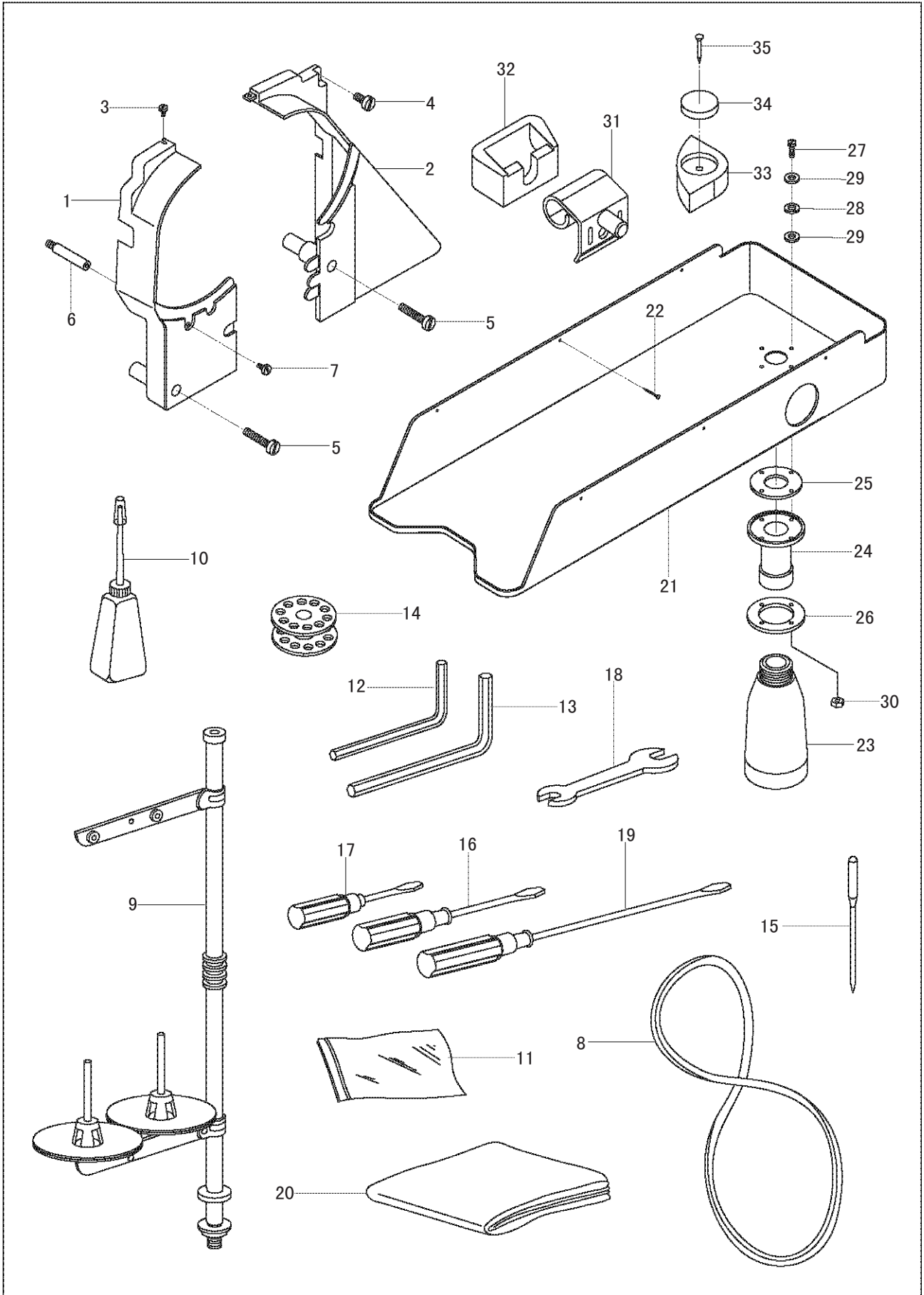
9. Lubrication



9. Lubrication

Line	Part Number	Description	Qt.	Notes
1	400-1268	Oil felt	1	
2	400-1269	Oil felt support	1	
3	200-1019	Screw	1	SM11/64"X40
4	400-1270	Small oil felt	1	
5	400-1118	Binding cord	3	
6	400-1271	Oil wick	1	φ2x190
7	400-1272	Press plate	1	
8	400-1273	Hook	1	
9	400-1274	Screw	1	SM11/64"X40
10	400-1275	Oil pot	1	
11	400-1276	Oil pot cover	1	
12	400-1277	Screw	2	SM11/64"X40
13	400-1278	Oil felt	2	
14	400-1279	Oil tube	1	φ3x φ5X180
15	400-1196	Oil wick	1	φ2x380
16	400-1280	Oil felt 1	1	
17	400-1281	Oil felt 2	1	
18	400-1282	Oil retaining plate	1	
19	400-1146	Screw	1	SM9/64"X40
20	400-1283	Oil felt	1	
21	400-1284	Oil wick	1	φ2x250
22	400-1285	Oil retaining plate	1	
23	400-1286	Screw	1	SM11/64"X40
24	400-1287	Oil wick	1	φ2x250
25	400-1283	Oil felt assembly	1	
26	200-1019	Screw	1	SM11/64"X40
27	400-1118	Binding cord	1	

10. Accessories



10. Accessories

Line	Part Number	Description	Qt.	Notes
1	400-1288	Safety guard 1	1	
2	400-1289	Safety guard 2	1	
3	400-1290	Screw	1	SM11/64"X40
4	400-1291	Screw 1	1	SM15/64"X28
5	200-1179	Screw 2	2	SM15/64"X28
6	400-1292	Column	1	
7	400-1274	Screw	1	SM11/64X40
8	400-1293	V-belt	1	42V
9	200-1368	Spool stand	1	
10	100-1309	Small oil pot	1	
11	100-1299	Parts bag	2	
12	400-1294	Spanner	1	S=2.5mm GB/T5356-1998
13	400-1295	Spanner	1	S=3MM GB/T5356-1998
14	400-1206	Bobbin	6	
15	100-1078	Needle	3	135X17#23
16	100-1301	Screwdriver (medium)	1	
17	100-1300	Screwdriver (small)	1	
18	400-1296	Double ended spanner	1	9X10
19	100-1302	Screwdriver (big)	1	
20	400-1297	Machine head cover	1	
21	400-1298	Oil reservoir	1	
22	400-1299	Screw	6	SG162 19
23	400-1300	Oil pot	1	
24	400-1301	Adapter	1	
25	400-1302	Seal ring	1	
26	400-1303	Presser plate	1	
27	400-1304	Connecting screw	4	GB/T818 M3X14
28	400-1305	Spacer	4	GB/T848 3
29	400-1306	Seal spacer	8	
30	400-1307	Connecting nut	4	GB/T6170 M3
31	400-1308	Connecting hook assembly	2	
32	400-1309	Rubber cushion	2	
33	400-1310	Rubber cushion	4	
34	400-1311	Oil felt	4	
35	400-1312	Screw	4	GB349-88-1