

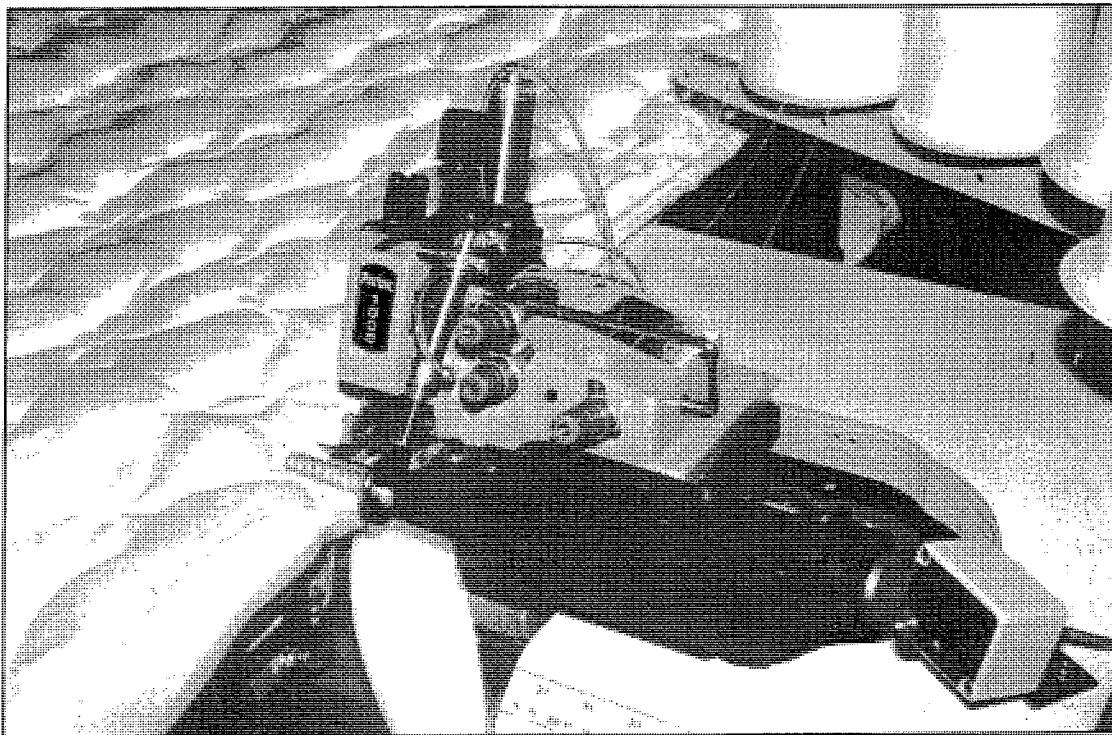


Catalog #PFM-1000(rev) 6/99



A Leggett & Platt Company

PFM 1000 Flange Machine



INSTRUCTIONS & PARTS MANUAL

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INSTRUCTIONS

RECOMMENDED SPEED

1. PFM 1000 SPEED NOT TO EXCEED 3500 SPM.

2. At the end of 4 weeks, the original oil should be drained and replaced.

3. Oil level should always be kept between two lines on the oil sight gauge. (See Lubrication below.).

CHAINING THREAD

It is necessary to have a chaining thread approximately 10 mm long behind the presser foot when starting to sew. This will avoid "skip-stitches."

After replacing needles or thread, check that a continuous, smooth neat chaining thread comes out from under the presser foot.

CLEANING THE MACHINE

Cleaning the machine is a simple but important operation. It is not necessary to remove any parts. Swing out the covers and remove all the collected lint from around the loopers, feed slots, and under the needle plate. Blow out any loose lint or use a lint brush. Replace covers and return foot to the sewing position.

LUBRICATION

Lubrication is important in operating precision machine like the PFM1000. The life of the machine depends on the use of quality oil. Use recommended type oil only. Oil specifications for this machine are shown at right.

	Brand "A"	Brand "B"
Kinematic Viscosity (centistokes)	100°F	19.01
	210°F	4.04
Viscosity Index	VI (A)	130.0
	VI (B)	123.5
Pour Point (°F)	—59.0	—63.5
Load Carrying Capacity (kg/cm ²)	more than 12 (170 psi.)	more than 12 (170 psi.)

NEEDLES

The PFM 1000 is designed to use needle type PSM 1160 (23).

Generally, the size of the needle should be determined by the size of thread or weight of material to be sewn.

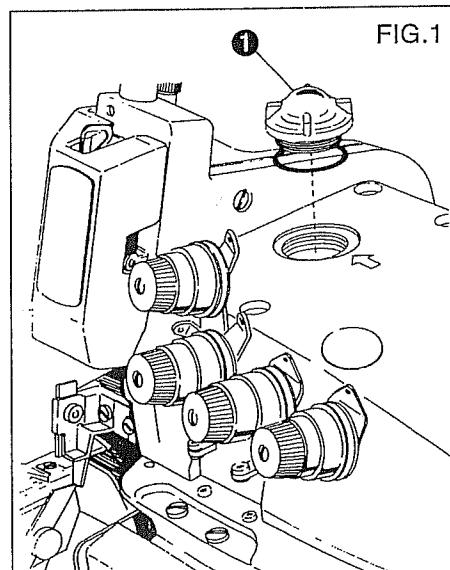
DAILY MAINTENANCE

Before morning start

- Make sure oil level is correctly maintained in oil sight gauge.
- Make sure needle is correctly set and not damaged.
- Make sure threading is correct.
- Make sure chaining thread approximately 10 mm long remains behind presser foot.

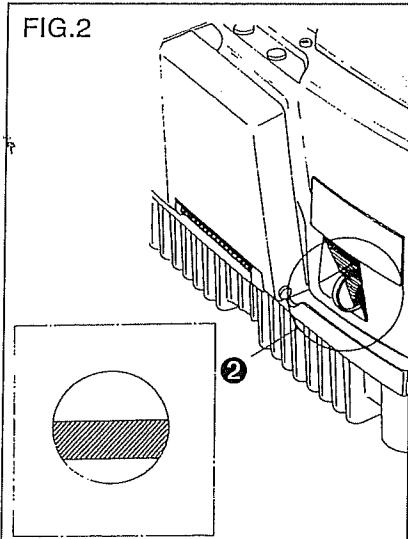
At close of work

- Remove dust and lint deposited in the machine around needle plate and looper.
- If any trouble or irregularity is found, report it to the plant mechanic for adjustment or repair.
- Keep record of needle and thread breakage.



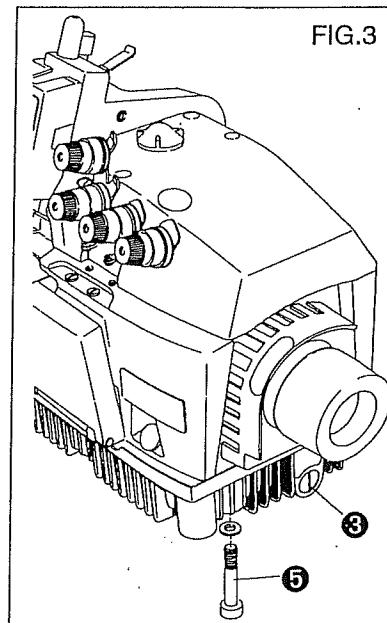
**TO FILL OIL:**

1. Remove oil sight window **①** and pour fresh oil into reservoir (700 c.c. capacity) until oil reaches upper line of oil sight gauge **②**.
2. Replace window **①**.
Caution: Keep oil level between the two lines on gauge **②**.

**TO DRAIN OIL:**

1. Remove the machine from its stand and set it on a table.
2. Screw out drain plug **③** and drain oil.
3. Replace drain plug **③**.

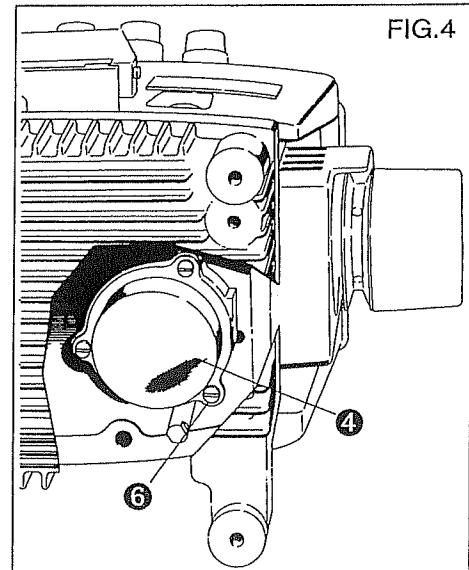
Change oil entirely every 6 months.

**OIL FILTER**

Filter **④** should be kept clean. Lubrication oil is filtered and delivered to all frictional surfaces. Clogging of this filter may cause lack of lubrication and accidental seizure of parts. Check and clean filter every three months, or if necessary, replace with new filter when: Oil jet in oil sight window **①** is restricted or weak, or oil contains foam or debris.

1. Drain oil from machine.

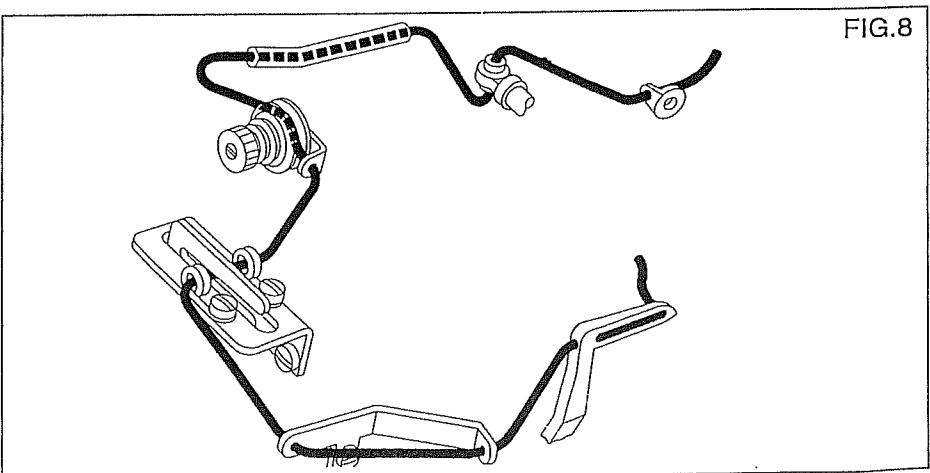
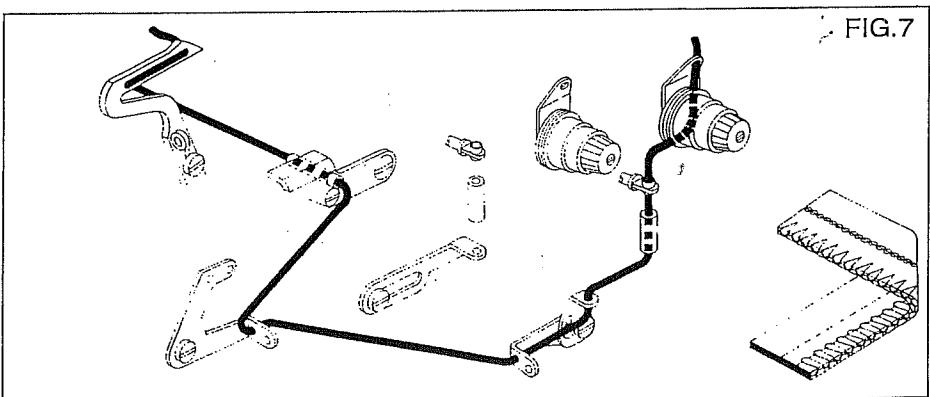
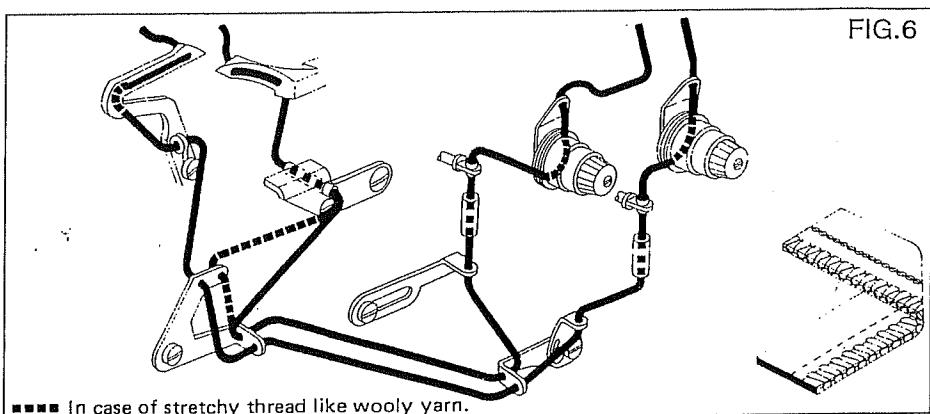
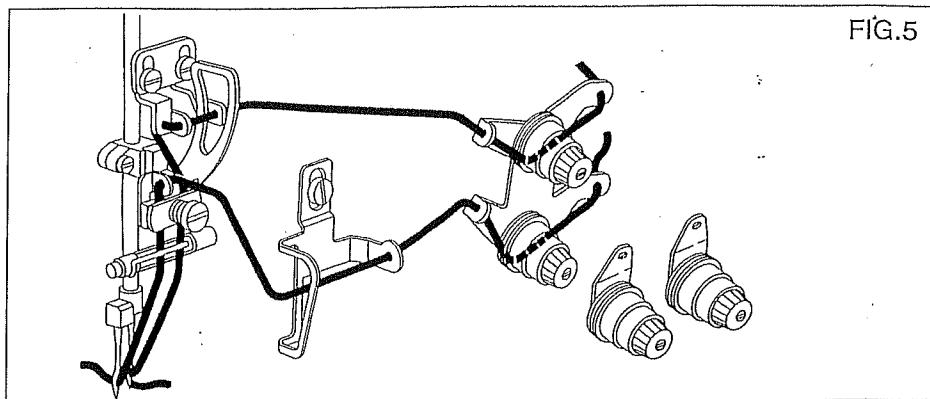
2. Remove bolts **⑤** and oil pan from machine.
3. Remove screws **⑥** and take out filter **④**.
4. Clean filter **④** with new petrol and blow it with low pressure air.
5. Replace filter **④** and tighten screws **⑥**.
6. Replace oil pan and tighten bolts **⑤**.
7. Fill reservoir with oil on a level of upper line of oil sight gauge **②**.



THREADING

When a machine is received, note that it has been threaded correctly. The simplest way to rethread it is to tie the new threads to those already in the machine and pull the new threads through, making sure that the knots will go through the looper eyes. In case the machine requires a complete rethreading, refer to Threading Diagrams Fig. 5-8.

The amount of thread tension required varies with type of material, size, and type of thread, etc. To increase thread tension, turn each thread tension nut clockwise, and to decrease, counter clockwise.



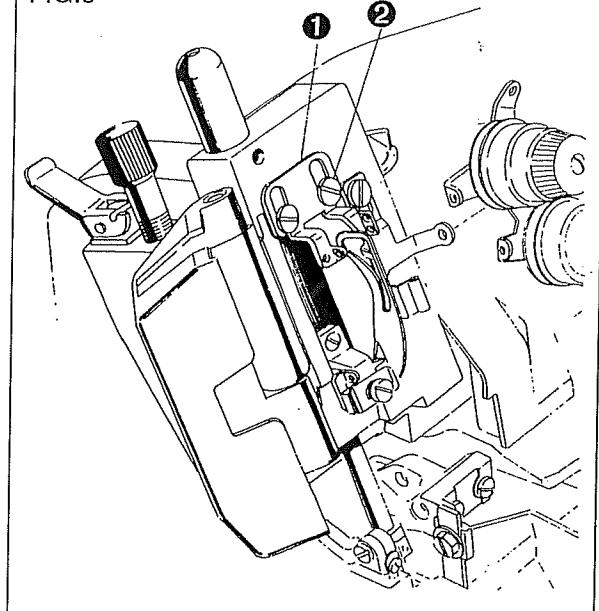


NEEDLE THREAD GUIDE REGULATION

Needle thread guide ① should be set down for the PFM 1000.

1. Loosen screws ②.
2. Move guide ① down.
3. Tighten screws ②.

FIG.9



STITCH LENGTH REGULATION

1. Swing out cloth plate to the left.
2. Press in rod ①.
3. While pressing in on rod ①, turn handwheel in the sewing direction until rod ① drops into the hole in eccentric. Read the number shown on handwheel, opposite to the mark on indication plate. This number indicates the length of one stitch of your machine in millimeters.
4. While keeping rod ① dropped in eccentric, turn handwheel toward the desired stitch length for a longer or a shorter stitch.

FIG.10

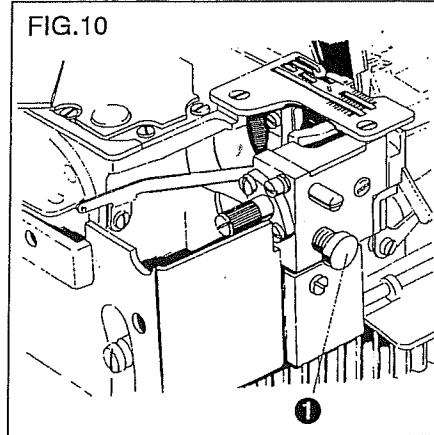
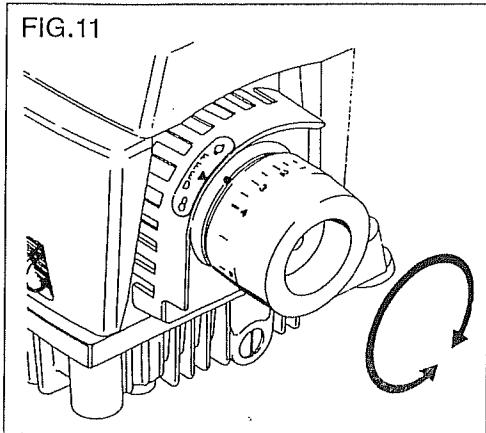


FIG.11



Longer stitch - Turn handwheel clockwise.

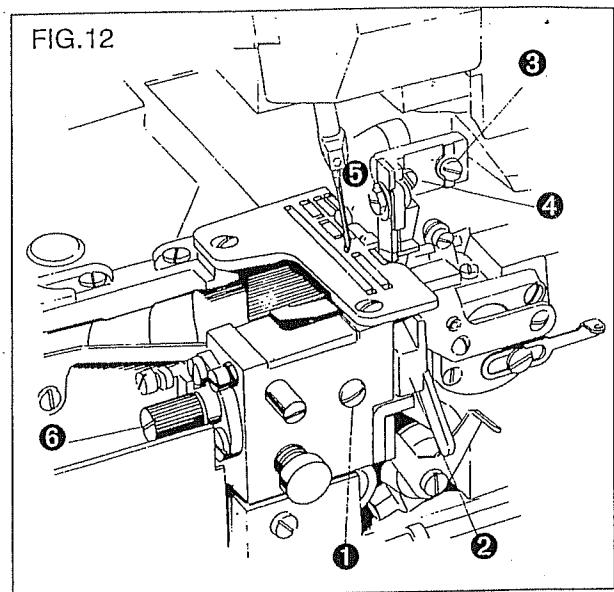
Shorter stitch - Turn handwheel counter clockwise.

5. When desired stitch length is set, release rod ①.
6. Return cloth plate to the sewing position.

The stitch length made may vary more or less depending on the material.

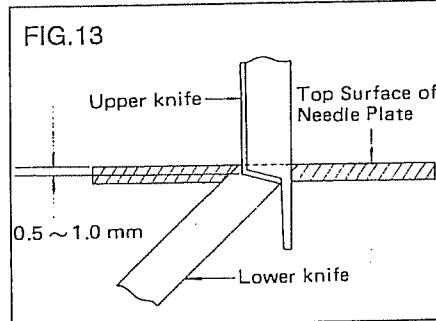
SEAM WIDTH REGULATION

1. Turn handwheel unit until upper knife is at its lowest position.
2. Loosen lower knife holder screw ①.
3. Push lower knife holder ② to the left as far as it will go and lightly tighten screw ①.
4. Loosen upper knife clamp screws ③ and move upper knife clamp ④ to the right or left until desired width is obtained.
5. Tighten screws ③.
6. Loosen screw ①, then the holder ② will return to position by spring action.
7. Tighten screw ①.



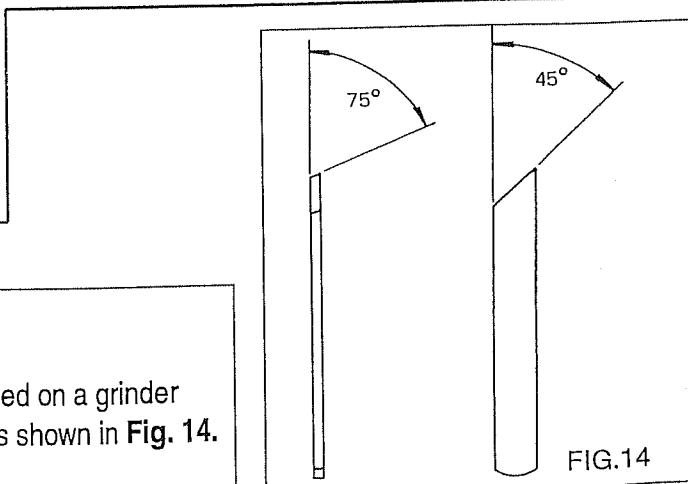
UPPER KNIFE REPLACEMENT

1. Loosen lower knife holder screw ① as shown in Fig. 12.
2. Push the lower knife holder ② to the left as far as it will go and lightly tighten screw ①.
3. Remove upper Knife screw ⑤ and withdraw knife downward.
4. Turn handwheel until upper knife clamp ④ is at its lowest position.
5. Replace with new knife but do not tighten screw ⑤ completely.
6. Set the blade so that its cutting edge overlaps lower knife by 0.5-1.0mm as shown in Fig. 13. Retighten screw ⑤ securely.
7. Loosen screw ①, then the holder ② will return to position by spring action.
8. Tighten screw ①.



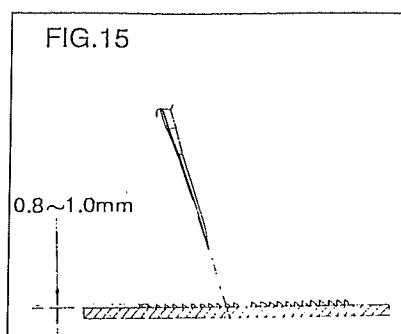
LOWER KNIFE REPLACEMENT

1. Loosen lower knife holder screw ①.
2. Push lower knife holder ② to the left as far as it will go and lightly tighten screw ① as shown in Fig. 12.
3. Loosen clamp stud nut ⑥ and withdraw knife downward.
4. Insert new knife into the groove of lower knife clamp stud, setting the blade so that the cutting edge is level with the top of the needle plate as shown in Fig. 11. Tighten nut.
5. Loosen screw ①, then the holder ② will return to position by spring action.
6. Tighten screw.



SHARPENING KNIVES

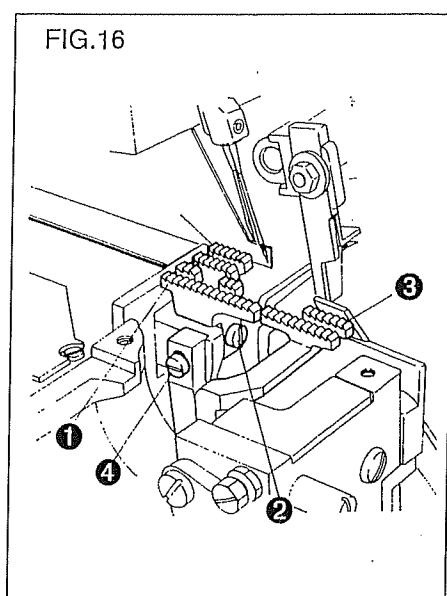
Knives must be kept sharp. Lower knife may be sharpened on a grinder while making sure that the correct angle is maintained as shown in Fig. 14.



FEED HEIGHT ADJUSTMENT

Standard height of main feed is 0.8 - 1.0 mm above the surface of needle plate at its back tooth when feeds are at their highest position. A straight edge can be placed across the top of main and differential feeds.

1. Loosen screws ② and ④.
2. Adjust feeds ① and ③ by raising or lowering feeds until proper height is obtained.
3. Tighten screws ② and ④.



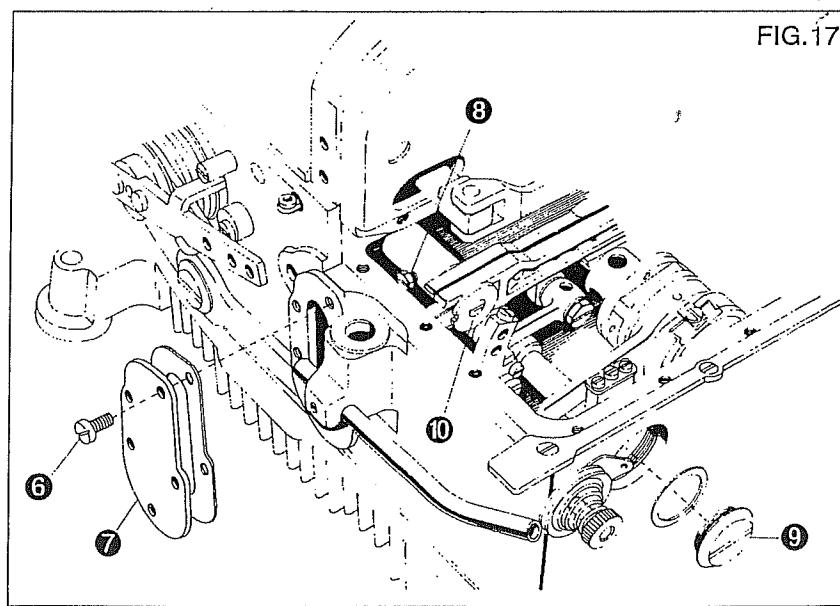
FEED TILT ADJUSTMENT

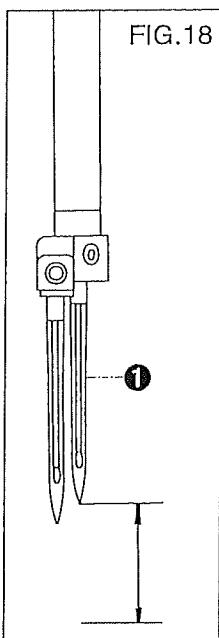
Feed dogs have generally been preset at the factory with a front to back tilt when feeds are at their highest position.

In general, set feeds as follows:

Set feeds level.

1. Turn handwheel until feeds are at their highest position.
2. Remove screws ⑥ and cover plate ⑦.
3. Loosen screw ⑧.
4. Remove screw ⑨ and turn screw ⑩ with a screwdriver until proper tilt is obtained.
5. Tighten screw ⑧ while pressing screw ⑩ so that a play in feed bars can be eliminated.
6. Replace cover plate ⑦ and screws ⑥
7. Replace screw ⑨.



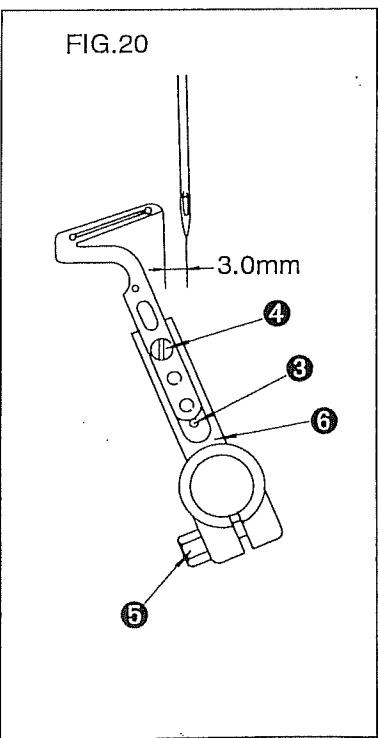
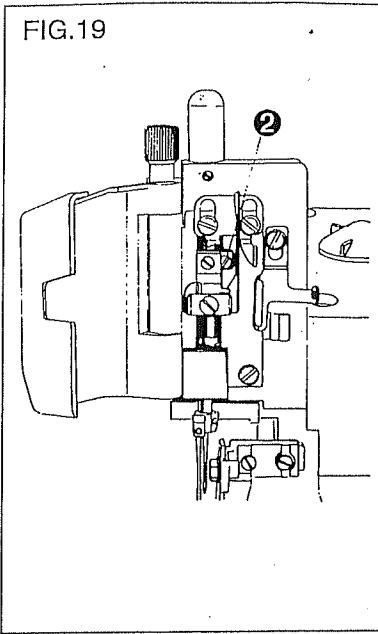


NEEDLE BAR HEIGHT ADJUSTMENT

Turn handwheel until needles are at their highest position. Check that the clearance between the point of right (overlock) needle ① and the top of needle plate is correct as listed below. If this setting is incorrect, reset as follows.

1. Slightly loosen screw ②.
2. Reset needle bar to correct clearance at its highest position.
3. Turn handwheel and observe that left (chainstitch) needle descends in the center of the needle hole in needle plate.
4. Tighten screw ② securely.

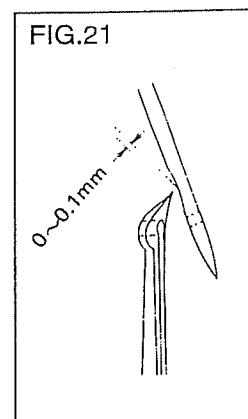
PFM 1000	NEEDLE BAR HEIGHT	
	Left 11mm	Right 13mm



OVEREDGE (LEFT) LOOPER ADJUSTMENT

When overedge (left) looper is at its extreme left position, the distance 3.0 mm center line of the overlock needle to the point of the looper. The clearance 0 - 0.1 mm should also be obtained when the looper point is in the scarf of the needle.

1. Slide left looper into lever ⑥, making sure it reaches the pin ③ of slot, then tighten screw ④.
2. Slightly loosen screw ⑤.
3. Turn handwheel by hand until needle bar ascends 3mm from the lowest position.
4. Move lever ⑥ so that looper point comes to the scarf of right needle and just touches needle (the clearance 0 - 0.1 mm).
5. Turn handwheel until looper is at its extreme left position.
6. Adjust the distance from the centerline of right needle to point of looper to 3mm.
7. Tighten screw ⑤ securely.





RIGHT LOOPER ADJUSTMENT

When right looper is at its highest position, the clearance 3.3 mm should be obtained from looper eye (bottom of V groove in case of spreader) to the centerline of the overlock needle. When right looper crosses left looper, the clearance (A) should be 0.5 mm and (B) should be 0.2 mm.

1. Insert right looper into lever and preset the clearance from the back edge of looper to the left side of looper lever to 5.3 mm. Lightly tighten screw ①.
2. Slightly loosen screw ②.
3. Turn handwheel until looper is at its highest position.
4. Adjust looper eye or spreader (bottom of V groove) from centerline of right needle to 3.3 mm by moving lever ③ downward or upward.
5. Turn handwheel slowly and observe that the clearance (A) is 0.5 mm.
6. When clearance (A) is more than 0.5 mm, move lever ③ upward, move right looper to the right until the clearance is obtained of 3.3 mm as shown in Fig. 23 or 24. Turn handwheel slowly and check that the clearance (A) is 0.5 mm.
7. When clearance (A) is less than 0.5 mm, move lever ③ downward. Move right looper to the left until the clearance is obtained of 3.3 mm as shown in Fig. 23 or 24. Turn handwheel slowly and check that the clearance (A) is 0.5 mm.
8. Rotate looper in its holder and adjust the clearance (B) to 0.2 mm as shown in Fig. 25.
9. When the above settings are complete, tighten screws ① and ② securely.

FIG.22

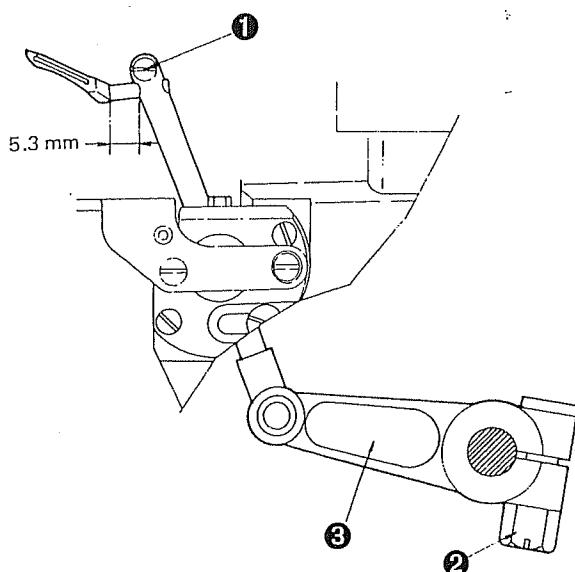


FIG.23

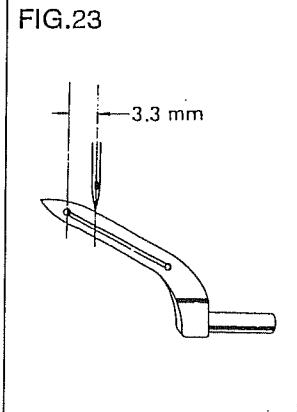


FIG.24

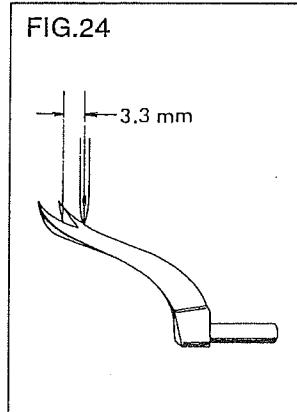
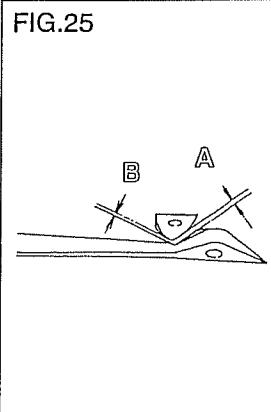


FIG.25



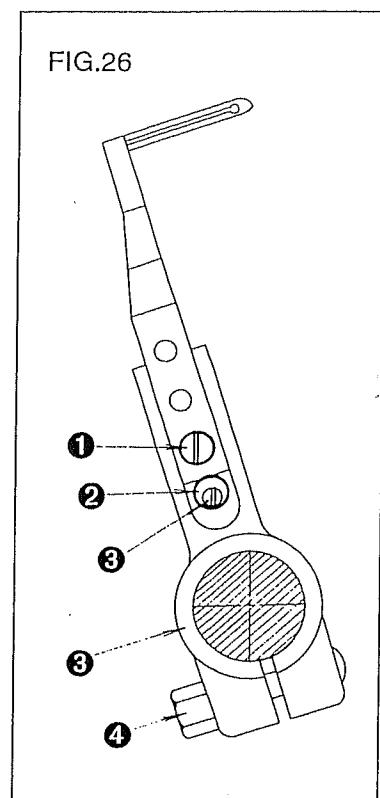


FIG.26

CHAINSTITCH LOOPER ADJUSTMENT

When chainstitch looper is at its extreme left position, the distance 2.1 mm should be obtained from the center line of the chainstitch (left) needle to the point of looper. The clearance 0 - 0.1 mm should also be obtained when the looper point is in the scarf of the needle.

1. Slide chainstitch looper into lever ⑤, making sure it reaches regulator ②.
2. If necessary, adjust this by turning regulator ②.
3. Turn handwheel by hand until needle bar ascends 3.0 mm from the lowest position.
5. Move lever ⑤ so that looper point comes to the scarf of left needle and just touches needle (the clearance 0 - 0.1 mm).
6. Turn handwheel until looper is at its extreme left position.
7. Adjust the distance from the centerline of left needle to point of looper to 1.5 to 2 mm.
8. Tighten screw ④ securely.

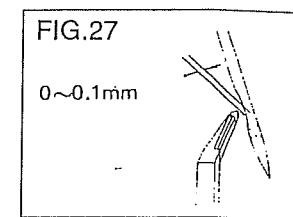


FIG.27

0~0.1mm

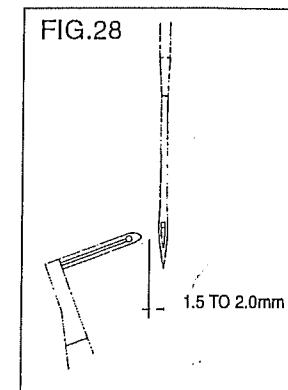


FIG.28

1.5 TO 2.0mm

CHAINSTITCH LOOPER THREAD CONTROL ADJUSTMENT

1. Lightly loosen screw ⑤.
2. Set bracket ⑥ horizontal and set guide ⑦ as 0.5 mm above from the top of bracket ⑥.
3. Tighten screw ⑤.
4. Loosen two screws for takeup ⑧ and turn handwheel until chainstitch looper is at extreme right position.
5. Set takeup ⑧ so that its flat portion is at a 10 degrees angle to guide ⑦.
6. Tighten the two screws loosened.
7. Loosen screws holding eyelets ⑨ and move eyelets ⑨ until the coiled ends line up with engraved line (A) on bracket, then tighten screws.

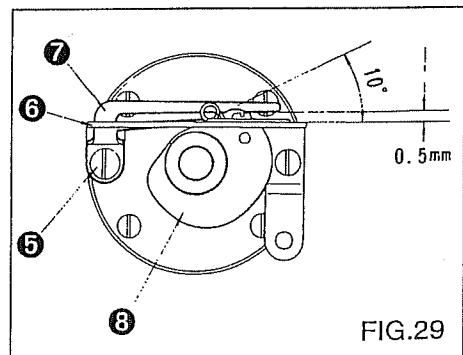


FIG.29

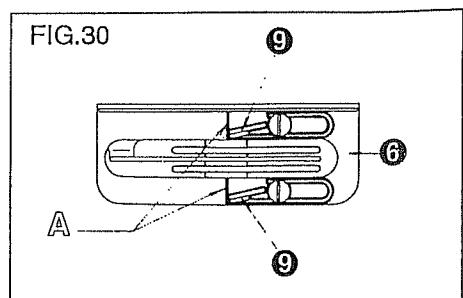
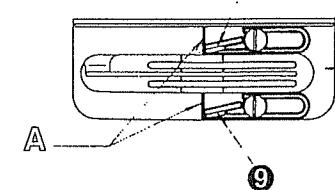


FIG.30

⑨

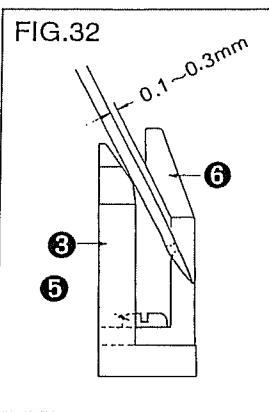
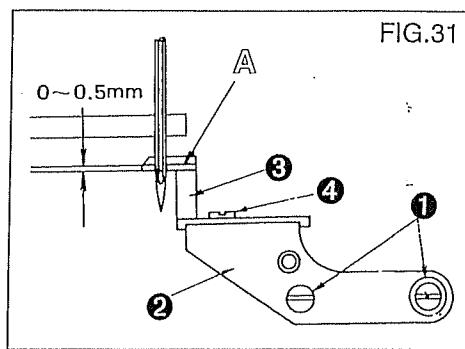




① NEEDLE GUARDS ADJUSTMENT

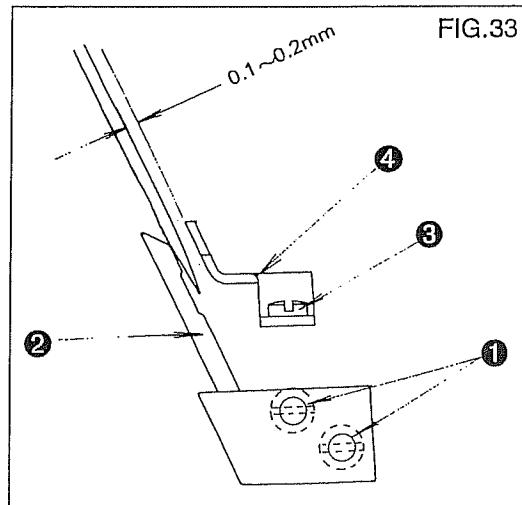
Needle guards for right (overlock) needle

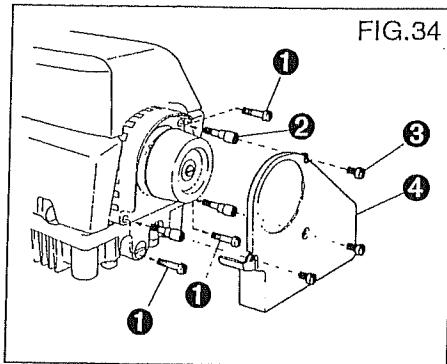
- 1.Turn handwheel until needles are at their lowest position.
- 2.Loosen screws ①. Move bracket ② until the top of the right needle eye is 0 - 0.5 mm below the line (A) of guard ③. Tighten screws ①.
- 3.Turn handwheel until the point of left looper is opposite to the centerline of right needle.
- 4.Loosen screw ④. Adjust guard ③ back and forth until it just touches needle without deflecting needle point. Tighten screw ④.
- 5.Loosen screws ⑤. Turn handwheel until needles are at their lowest position.
- 6.Adjust guard ⑥ so there is a space of 0.1 - 0.3 mm between needle and guard ⑥ as shown in Fig. 32. Tighten screws ⑤.



NEEDLE GUARDS FOR LEFT (CHAINSTITCH NEEDLE)

- 1.Turn handwheel until needles are at their lowest position.
- 2.Loosen screws ①. Adjust guard ② back and forth until it just touches needle. Tighten screws ①.
- 3.Loosen screw ③. Turn handwheel until needles are at their lowest position.
- 4.Adjust guard ④ so there is a space of 0.1- 0.2 mm between needle and guard ④. Tighten screw ③.





BELT GUARD ASSEMBLY

Assemble belt guard on machine in sequence as follows.

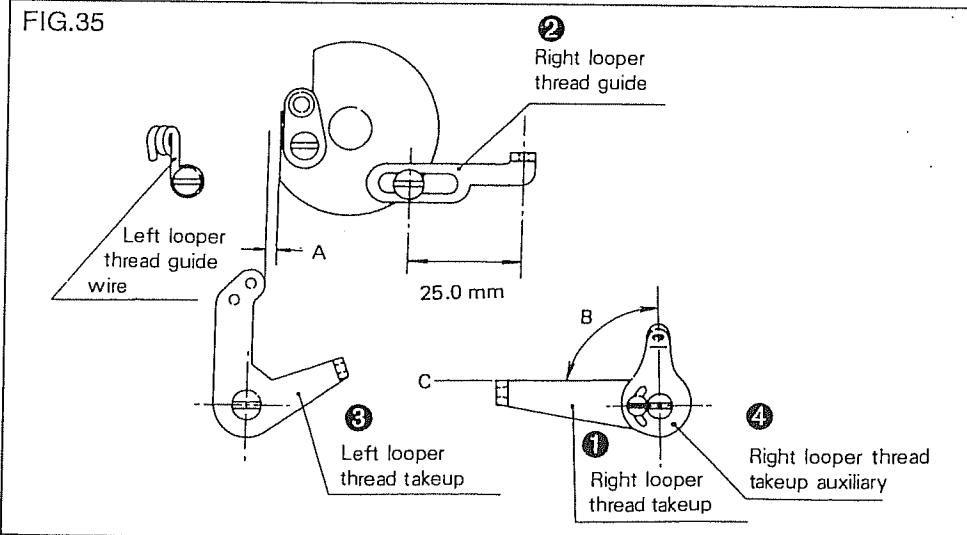
- 1.Put machine on table.
- 2.Replace screws ① for oil cooler cover with fixing screws ② provided.
- 3.Put V-belt in machine pulley.
- 4.Fix belt guard ④ on fixing screws ② with screws ③.
- 5.Rest machine in position in work table.
- 6.Engage V-belt in machine motor pulley.

THREAD GUIDE POSITIONS

Set thread guides as listed below. Note that the position of each thread guide varies more or less depending on operation, material to be sewn, etc.

- 1.Check dimensions when left looper is at its extreme right position.
- 2.Once set, takeup ① and guide ② in the basic position, do not move them.
- 3.To increase the amount of right looper thread, move takeup auxiliary ④ to the left, and to decrease, to the right.
- 4.To increase the amount of left looper thread, move takeup ③ to the left, and to decrease, to the right.

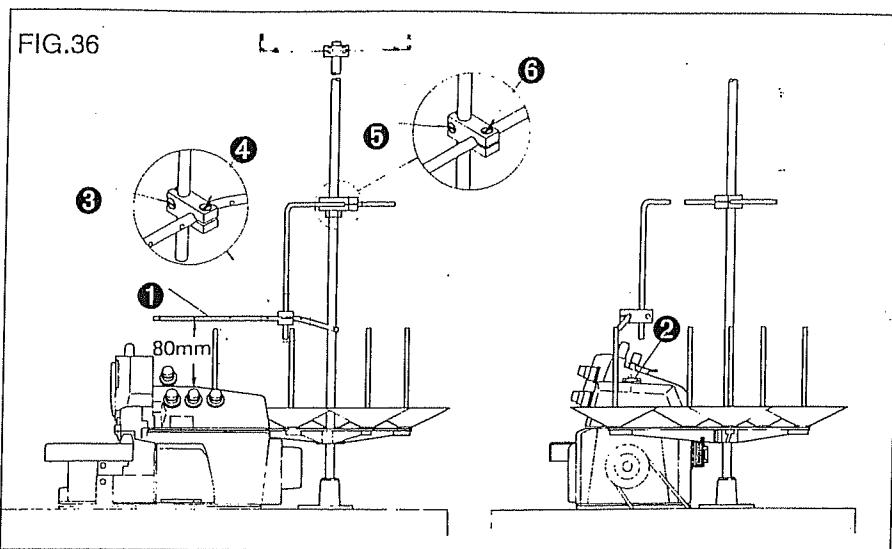
Material of looper threads	Distance 'A'	Angle 'B'	Surface 'C'
For almost all materials.	7.0 mm		
		80° – 90°	Set horizontally



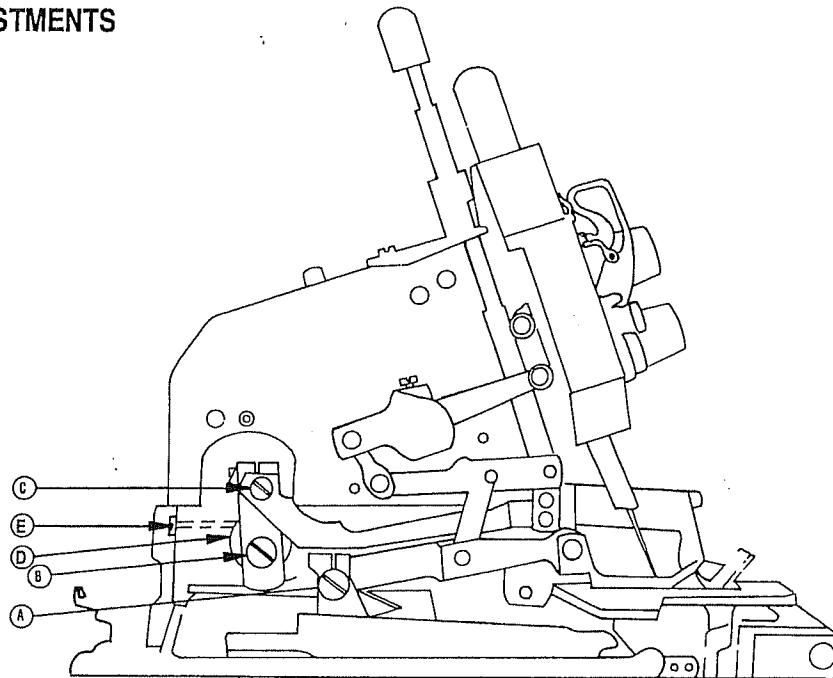
THREAD STAND SETUP

Set thread stand as per shown in Fig 36. Loosening screws ③, ④, ⑤, and ⑥, set thread guide bar ① as follows.

2. Obtain the distance of approximately 80 mm between bar (①) and machine top cover.
3. Bar ① should be above and a little front of oil sight window ②.
4. Tighten screws ③, ④, ⑤, and ⑥.



WALKING FOOT ADJUSTMENTS



A • This eccentric pin adjusts the position of the Walking Foot front to rear. This enables you to align the Walking Foot teeth with the lower feed dog teeth.

B • This screw adjusts the Walking Foot movement in relation to the presser foot. The higher the bracket, the faster the presser foot will meet the needle plate, causing the Walking Foot to raise off the work faster.

Lowering the bracket will cause the Walking Foot to raise off the work more slowly.

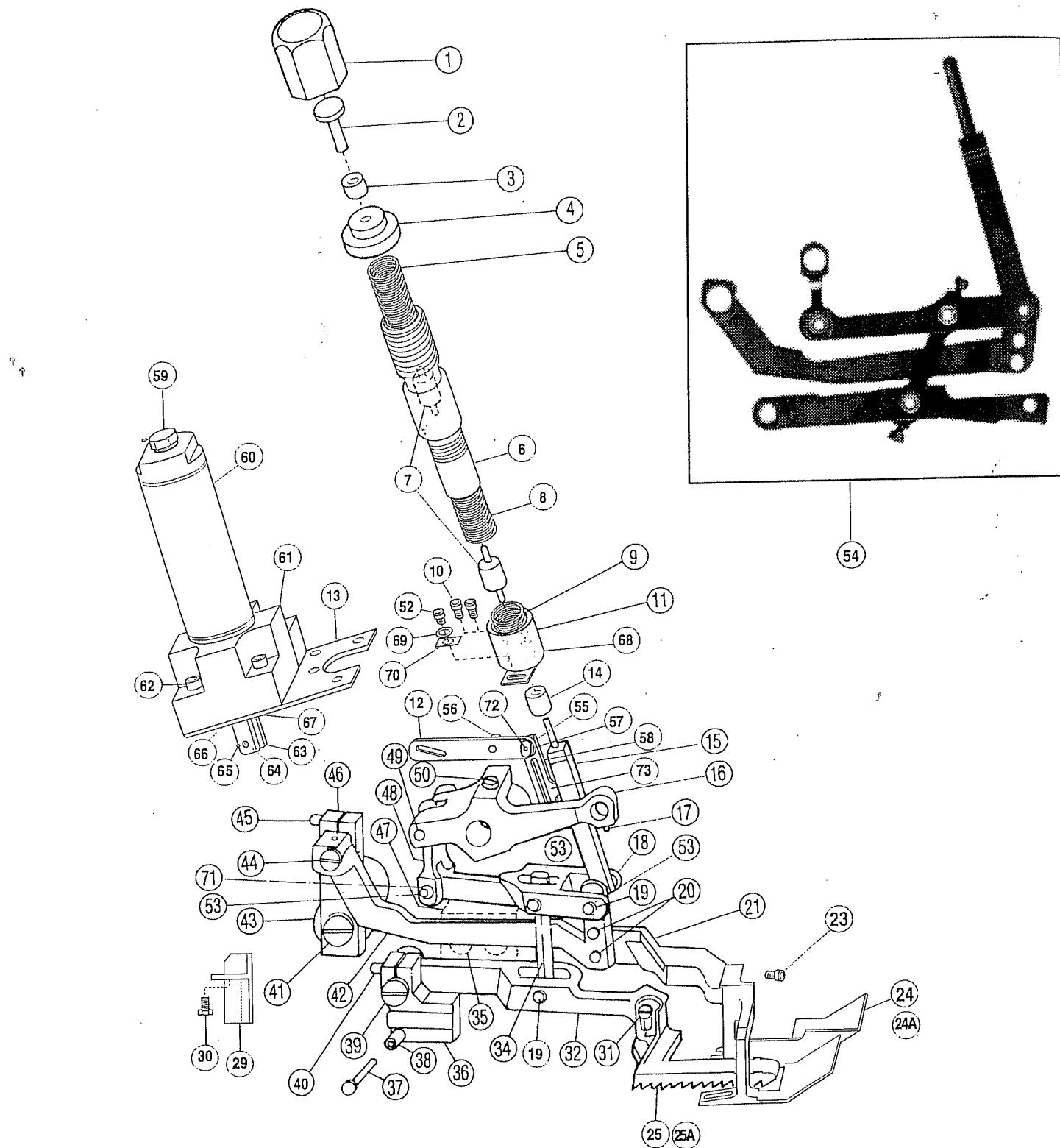
C • This eccentric pin primarily adjusts the position of the presser foot front to rear.

D • This shaft adjusts the position of the presser foot front to rear. It is used to adjust the clearance between the presser foot and the Walking Foot.

E • This screw holds shaft 'D'. Loosen it to free the shaft.

Any one of the above adjustments will slightly change one or more of the other adjustments. Take this into consideration when making any one adjustment. Before running the machine, turn it over by hand to check all clearances.

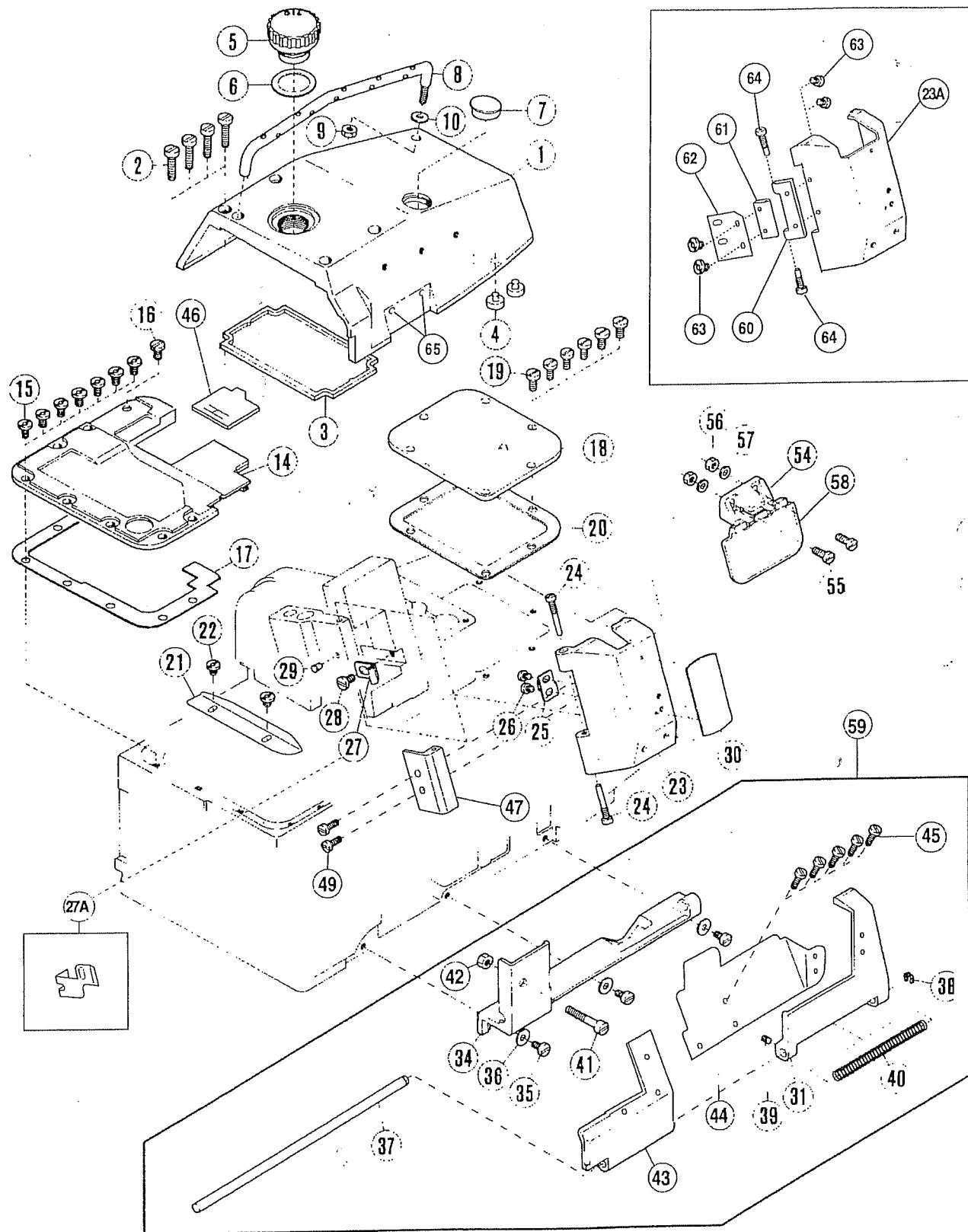
WALKING FOOT MECHANISM



WALKING FOOT MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z 0142	630300	ACORN NUT	1	38	6z 1406	630147	LONG BUSHING	1
2	6z 2012	630301	ADAPTOR	1	39	6z 0784	630155	ECCENTRIC PIN	1
3	660036	660036	PRELOAD SPACER	1	40	6z 2754	SHCS4-40X%	SOCKET HEAD CAP SCREW	1
4	6z 0534	630303	CHECK NUT	1	41	6z 1885	PHMS4-28X%	PAN HEAD MACHINE SCREW	2
5	6z 3358	630304	WHITE SPRING	1	42	6z 2036	630144	PRESSER FOOT ARM	1
6	6z 1256	630305	HOUSING PRESSURE SPRING	1	43	6z 0454	617440	SCREW	1
7	6z 2816	630306	SPACER	2	44	6z 0788	620134	ECCENTRIC STUD	1
8	6z 3358	630304	WHITE SPRING	1	45	6z 2764	SHCS6-32X1	SOCKET HEAD CAP SCREW	1
9	6z 3358	630304	WHITE SPRING	1	46	6z 1390	620165	LOCATING BAR	1
10	6z 2756	SHCS8-32X%	SOCKET HEAD CAP SCREW 8-32X%	2	47	6z 2292	620168	RUBBING BLOCK	1
11	6z 2103	630307	PRESSURE SPRING BASE	1	48	6z 0656	620135	BEAM CONNECTOR LINK	1
12	6z 243	660017	BEAM, LIFTER	1	49	6z 0657	630138	CONNECTOR LINK PIVOT PIN	1
13	6z 1587	660028	PRESSURE SPRING MOUNTING BLOCK	1	50	6z 2518	611620	SCREW	1
14	6z 0391	630310	BOTTOM SPACER	1	52	6z 2777	SHCS8-32X%	SOCKET HEAD CAP SCREW	1
15	6z 2032	660016	PRESSER BAR	1	53	6z 1216	HLSS4-40X%	HOLLOW LOCK SET SCREW	7
16	6z 0703	630136	NEEDLE DRIVE ARM	1	54	6z 1388	660042	LINKAGE ASSEMBLY	1
17	6z 2547	619400	SCREW	2	55	6z 0985	FHMS8-32X%	FLAT HEAD MACHINE SCREW	1
18	6z 0490	630140	W.F BEAM	1	56	6z 2806	660032	SPACER	1
19	6z 0385	620150	LONG PIVOT PIN	3	57	6z 2224	660035	RETAINER	1
20	6z 2769	SHCS5-40X%	SOCKET HEAD CAP SCREW 5-40X%	2	58	6z 2730	660018	SLIDE, LIFTER	1
21	6z 3454	660022	PRESSER FOOT EXTENSION	1	59	6z 1571	MPAT-8016	FITTING	1
23	6z 2765	SHCS8-32X%	SOCKET HEAD CAP SCREW	1	60	6z 0167	.091	AIR CYLINDER	1
24	6z 2087	660009	PRESSER FOOT ASSEMBLY, 3/4"	1	61	6z 2799	660029	SPACER AIR CYL	1
24A	6z 2088	660010	PRESSER FOOT ASSEMBLY, 1"	1	62	6z 2778	SHCS8-32X%	SCREWS	4
25	6z 3210	660007	3/4" TOP FEED	1	63	6z 3386	660030	YOKE	1
25A	6z 3195	660008	TOP FEED, 1"	1	64	6z 1924	660031	PIN	1
29	6z 0688	660026	COVER GUIDE	1	65	6z 2635	SC7-5	SET SCREW	1
30	6z 1167	HHCS1/20X%	HEX HEAD BOLT	1	66	6z 1177	HN%6-24	NUT	1
31	6z 2478	SHCS8-32X%	SOCKET HEAD CAP SCREW	1	67	6z 1586	660033	CYL. MTG.NUT	1
32	6z 3207	630145	TOP FEED MAIN SECTION	1	69	6z 2830	SLW#8	LOCK WASHER	2
33	6z 1946	620175	PIVOT PIN	1	70	6z 0147	660034	ADAPTOR	2
34	6z 3190	620177	TOP FEED CONNECTOR LINK	1	71	6z 1946	620175	PIN	1
35	6z 2755	SHCS8-32X%	SOCKET HEAD CAP SCREW	1	72	6z 0745	DP%6X%	DOWEL PIN	1
36	6z 3534	630117	TOP FEED HOLDER	1	73	6z 0818	EXPIN%6X%	EXPANSION PIN	1
37	6z 2477	SHCS8-32X%	SOCKET HEAD CAP SCREW	1	74	6z 3430	617420	WICKING (NOT SHOWN)	1

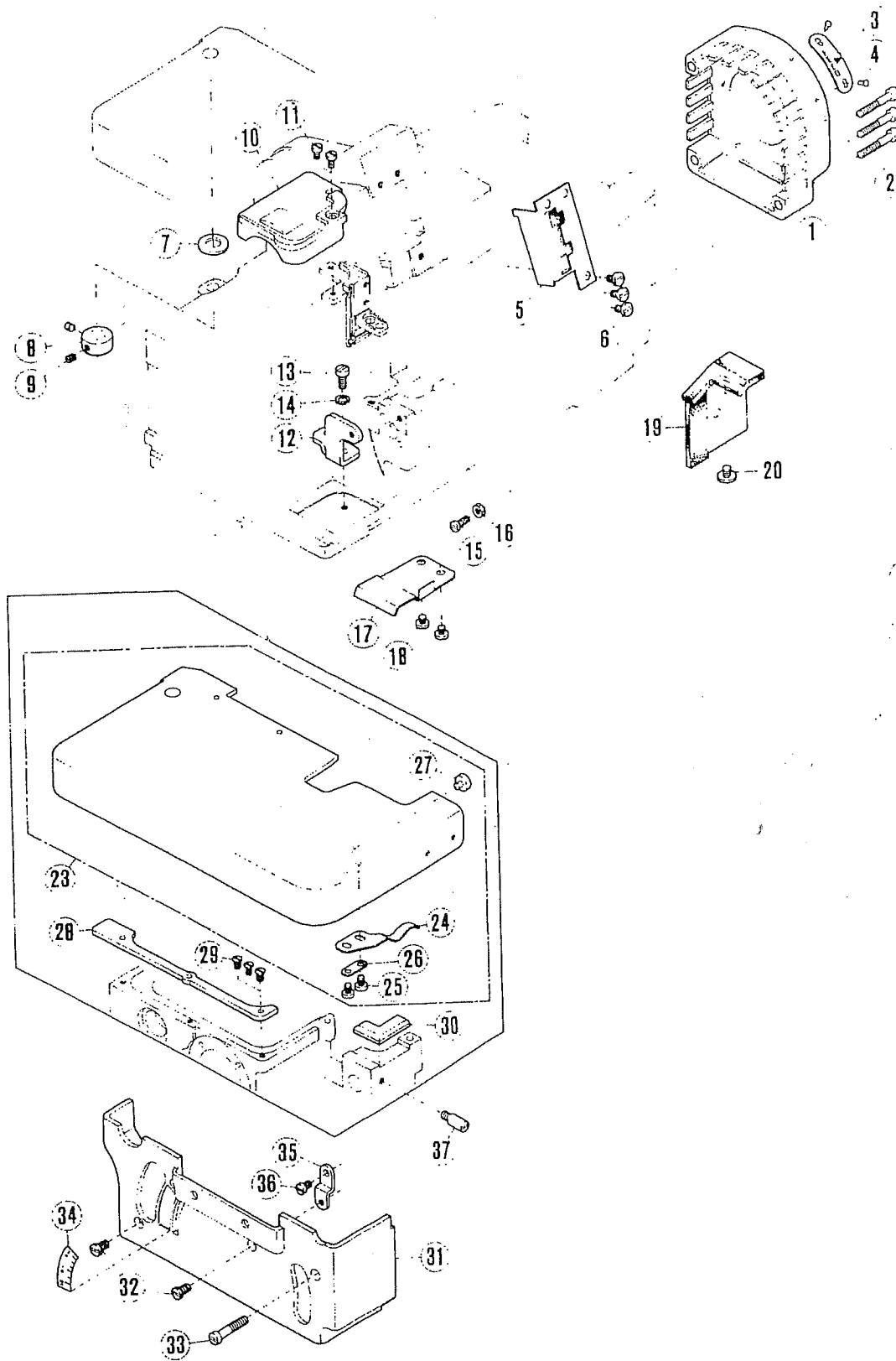
I) MISCELLANEOUS COVERS



MISCELLANEOUS COVERS

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1		615860	TOP COVER	1	34	6z1190	614880	HINGE	1
2		6z 2538	SCREW	4	35	6z1398	610200	HINGE SCREW SHORT	3
3		6z 1076	GASKET	1	36	6z1206	610400	HINGE SCREW WASHER	3
4		6z 2741	CUSHION	2	37	6z1202	614900	HINGE PIN	1
5		6z 1862	OIL SPLASH SIGHT WINDOW	1	38	6z1199	610920	HINGE PIN STOP RIGN	1
6		6z 0140	O-RING	1	39	6z2944	618920	STOP SCREW	1
7		6z 1977	PLUG	1	40	6z1208	614920	HINGE SPRING	1
8		6z 3075	THREAD GUIDE BAR	1	41	6z 2533	618660	SCREW	1
9		6z 2941	NUT	1	42	6z 1996	618800	POST LOCK NUT	1
10		6z 0561	WASHER	1	43	6z 1324	640075	FRONT COVER LEFT	1
14		6z 0269	BEDPLATE	1	44	6z 1037	640004	FRONT COVER	1
15		6z 2523	SCREW	4	45	6z 0486	BHCS5-40X $\frac{1}{4}$	SCREW	5
16		6z 2566	SCREW	1	46	6z 1855	620195	BOOT	1
17		6z 1075	GASKET	1	47	6z 0684	620204	COVER BRKT (3/4" MODEL ONLY)	1
18		6z 2243	BED COVER PLATE RIGHT	1	49	6z 0488	BHCS6-32X $\frac{1}{4}$	SCREW	2
19		6z 2535	SCREW	6	54	6z 0828	640073	EYE GUARD	1
20		6z 1074	GASKET	1	55	6z 2068	610120	SCREW	2
21		6z 0840	FABRIC GUIDE	1	56	6z 1825	618320	NUT	2
22		6z 1886	PHMS6-32X $\frac{1}{4}$	SCREW	57	6z 1206	610400	HINGE SCREW WASHER	2
23		6z 1650	NEEDLE BAR COVER	1	58	6z 1953	614780	EYE GUARD	1
23A		6z 1039	NDLE BAR COVER-1" MODEL ONLY	1	59	6z 1036	630100	FRONT COVER ASSEMBLY	1
24		611820	HINGE PIN	2	60	6z 1192	660045	HINGE, LARGE-1" MODEL ONLY	1
25		6z 1400	LOCK SPRING	1	61	6z 1207	660046	HINGE, SMALL-1" MODEL ONLY	1
26		6Z1399	LOCK SPRING SCREW	2	62	6z 0146	660047	ADAPTOR, HINGE-1" MODEL ONLY	1
27		6z 1397	LOCK SPRING LATCH	1	63	6z 0488	BHCS6-32X $\frac{1}{4}$	SCREW	6
27A		6z 1316	LATCH-1" MODEL ONLY	1	64	6z 2753	SHCS4-40X $\frac{1}{4}$	SCREW	2
28		6z 2523	SCREW	1	65	6z 1332	611060	THREAD EYELET	2
29		6z 0710	CUSHION RUBBER	1	66	6z 0488	BMHS-6-32X $\frac{1}{4}$	SCREW (NOT SHOWN)	1
30		6z 1599	NAME PLATE	1	67	6z 0690	620211	COVER STAND OFF (NOT SHOWN)	1
31		6z 2247	FRONT COVER RIGHT	1					

2) MISCELLANEOUS COVERS

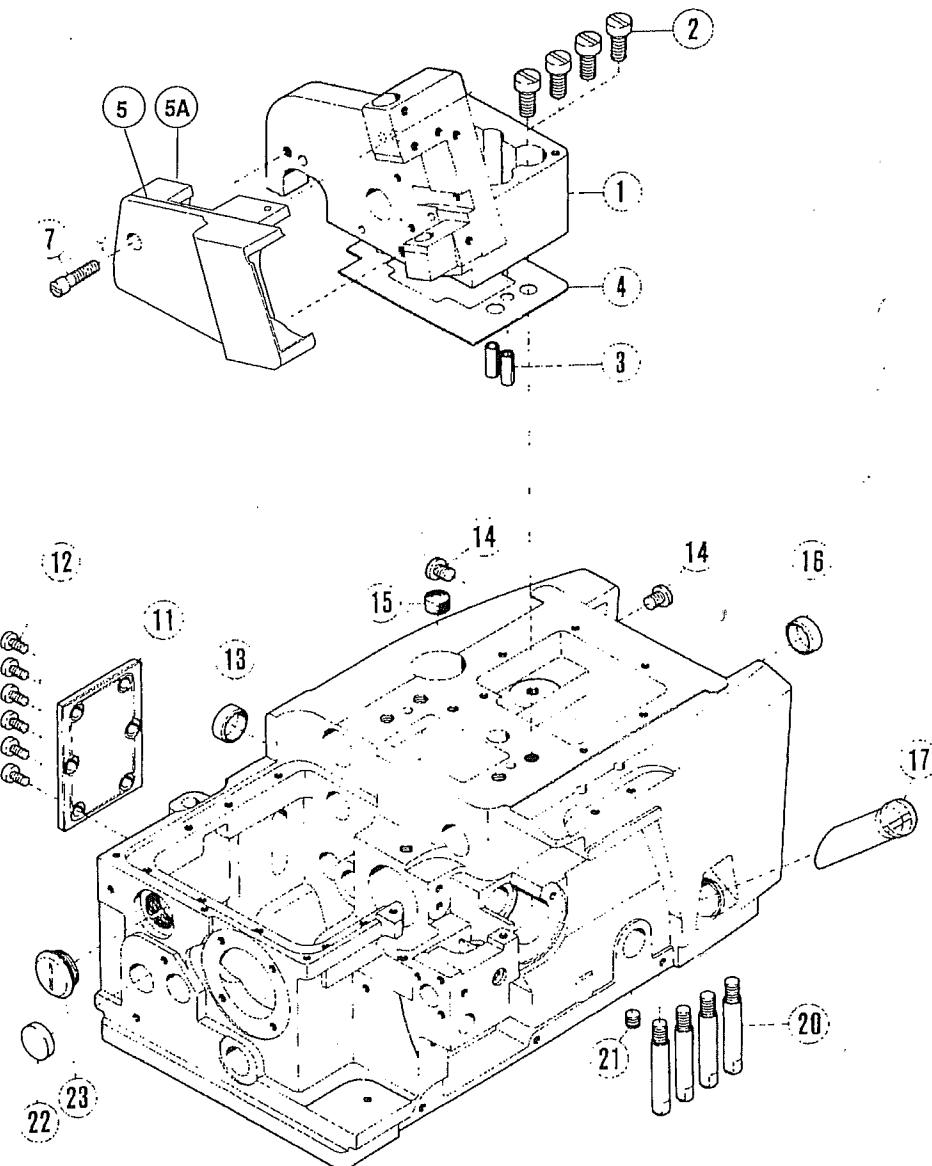


2) MISCELLANEOUS COVERS

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1.....	6z 1835.....	613960	OIL COOLER COVER	1	19.....	617145.....	617145	R.LOOPER LVR.OIL SHIELD.....	1
2.....	6z 2533.....	618660	SCREW.....	1	20.....	6z 2537.....	618940	SCREW.....	1
3.....	6z 2936.....	613940	STITCH INDICATOR	1	23.....	6z 0579.....	660037	CLOTH COVER COMPLETE.....	1
4.....	6z 2257.....	614500	RIVET	2	24.....	613520.....	613520	LOCK SPRING	1
5.....	6z 0842.....	616640	FACE PLATE.....	1	25.....	6z 1398.....	610200	LOCK SPRING SCREW	2
6.....	6z 2523.....	618340	SCREW.....	3	26.....	610900.....	610900	LOCK SPRING SCREW WASHER	1
7.....	6z 1209.....	611760	WASHER	1	27.....	6z 2741.....	616820	CUSHION	1
8.....	611260.....	611260	THRUST COLLAR.....	1	28.....	6z 0711.....	613540	CUSHION RUBBER LEFT	1
9.....	6z 2515.....	610420	SET SCREW	2	29.....	6z 2526.....	618400	SCREW.....	3
10.....	640007.....	640007	FEED ECC. COVER.....	1	30.....	6z 1040.....	613560	CUSHION RUBBER FRONT	1
11.....	6z 2552.....	619520	SCREW.....	2	31.....	6z 1333.....	614420	MACHINE COVER LEFT	1
12.....	6z 2813.....	614440	SPACER	1	32.....	6z 2532.....	618640	SCREW.....	2
13.....	6z 2808.....	618120	SPACER SCREW	1	33.....	6z 1408.....	619060	LONG SCREW	1
14.....	6z 2809.....	611640	SPACER SCREW WASHER.....	1	34.....	616080.....	616080	INDICATION PLATE	1
15.....	619800.....	619800	STOP SCREW.....	1	35.....	6z 2812.....	614430	SPACER	1
16.....	6z 2941.....	618280	STOP SCREW WASHER	1	36.....	6z 2534.....	618720	SCREW.....	1
17.....	6z 0858.....	640008	FEED BAR COVER	1	37.....	6z 2945.....	619180	STOP SCREW	1
18.....	6z 2521.....	618140	SCREW.....	2					

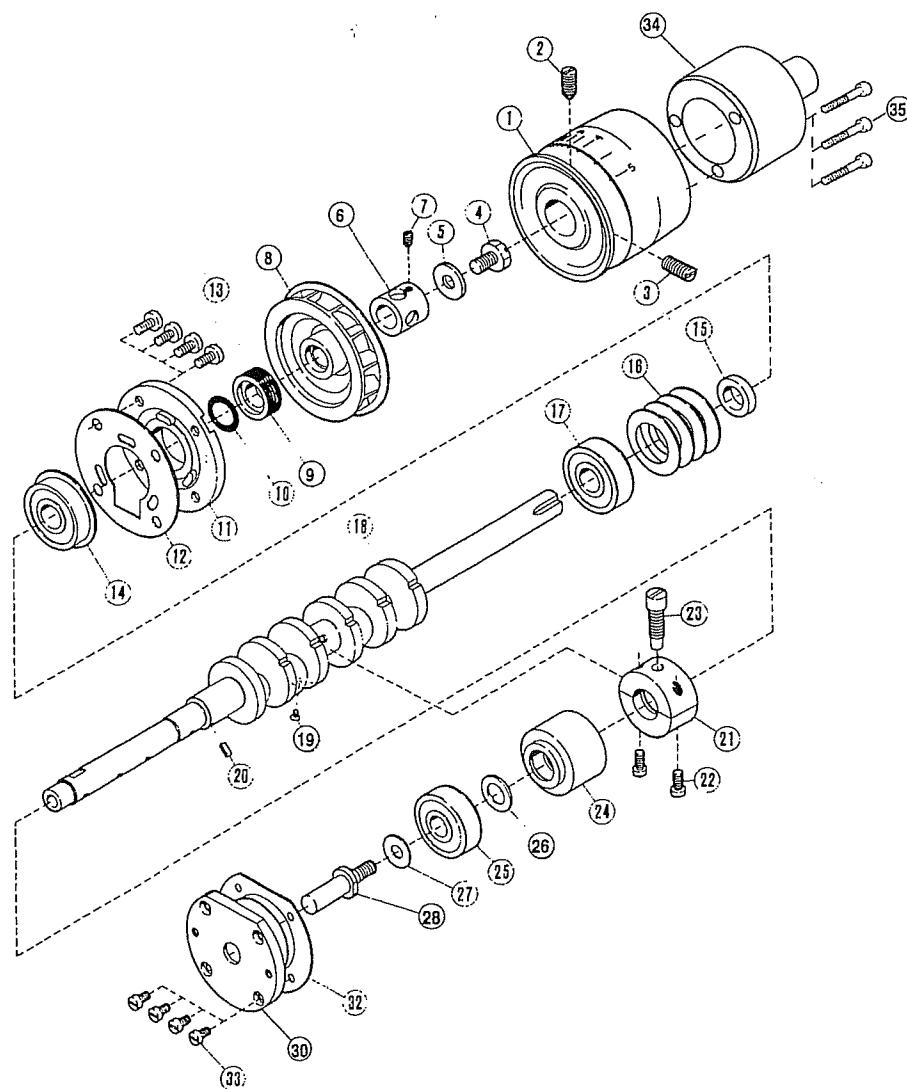
MACHINE BED FRAME

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z 3184	660023	MACHINE ARM (RIGHT)	1	13	6z 1976	614360	PLUG	1
2	6z 2530	618500	SCREW	4	14	619540	619540	SCREW	2
3	6z 1928	610980	PIN	2	15	6z 1844	614280	OIL FILTER	1
4	6z 1071	613580	GASKET	1	16	314360	314360	PLUG	1
5	6z 2706	660025	SIDE COVER (LEFT), 3/4"	1	17	6z 1856	612000	OIL SIGHT GAUGE	1
5A	6z 0693	660049	SIDE COVER (LEFT), 1" MODEL ONLY	1	20	612020	612020	BED PIN	4
7	6z 2545	619240	SCREW	1	21	6z 2519	611680	SCREW	1
11	617380	617380	COVER PLATE	1	22	6z 1978	617360	PLUG	1
12	6z 2560	619840	SCREW	6	23	6z 2290	650072	PLUG	1

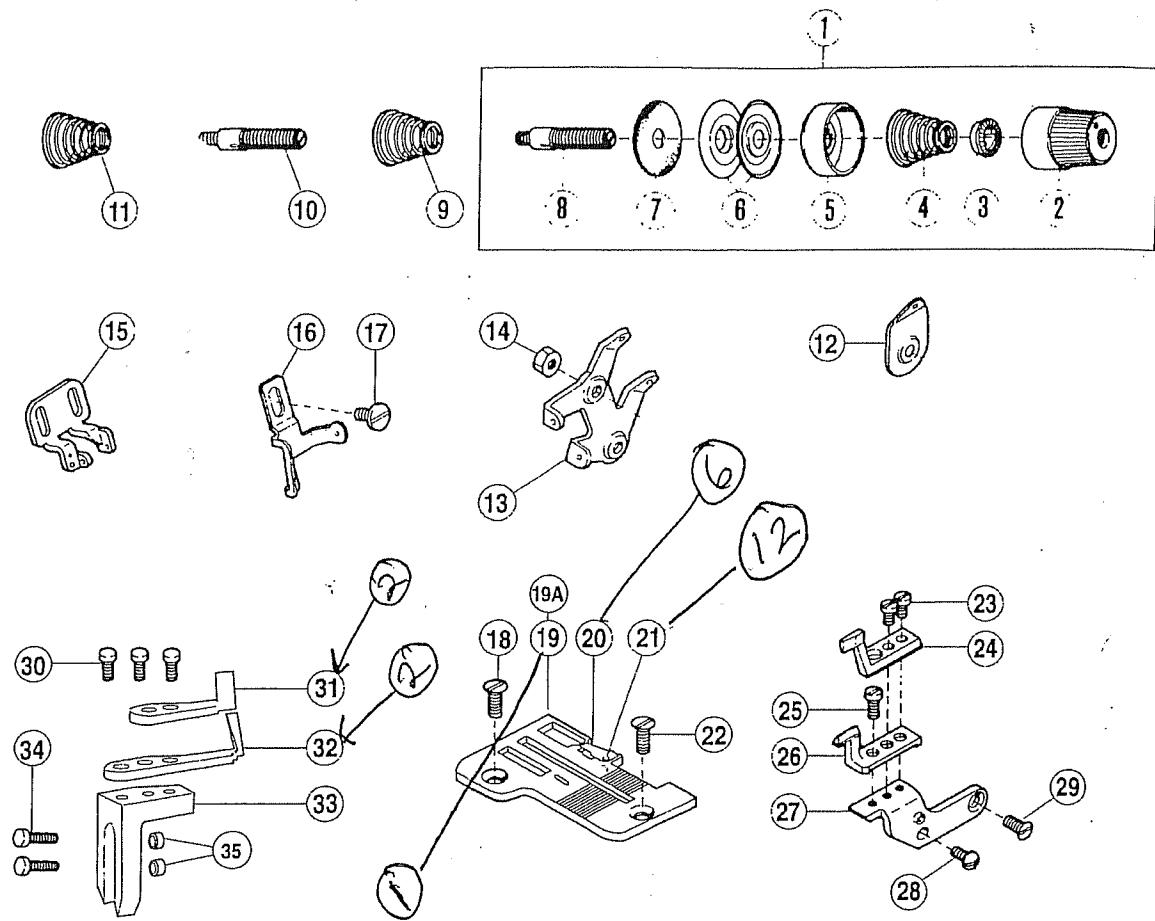


CRANKSHAFT MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z 1541	612220	PULLEY	1	18	6z 0704	616140	CRANKSHAFT	1
2	6z 1990	618520	SCREW	1	19	620013	620013	SCREW	1
3	6z 2531	618540	SCREW	1	20	6z 1840	611580	OIL FELT	1
4	6z 2563	620012	SCREW	1	21	6z 0513	612080	BUSHING (CENTER)	1
5	6z 3342	612200	WASHER	1	22	6z 2740	610040	SCREW	2
6	6z 0636	612240	COLLAR	1	23	6z 0444	619300	SCREW	1
7	6z 0630	619340	SCREW	1	24	6z 0461	612060	BUSHING (LARGE)	1
8	6z 1836	613500	COOLING FAN	1	25	6z 1321	612040	BALL BEARING	1
9	6z 0705	616770	OIL SEAL COLLAR	1	26	6z 3345	640006	THRUST WASHER	1
10	6z 1853	615540	"O" RING	1	27	613840	613840	WASHER	1
11	616775	616775	PLATE	1	28	6z 0824	614520	CRANKSHAFT EXTENSION	1
12	6z 1069	612180	GASKET	1	30	6z 0228	614580	HOUSING	1
13	6z 2535	618740	SCREW	4	32	6z 1255	613680	GASKET	1
14	6z 2241	612140	BALL BEARING	1	33	6z 2512	610100	SCREW	4
15	612120	612120	SPACER	1	34	6z 1147	630102	SYNCHRONIZER ADAPTOR	1
16	6z 3341	612100	WASHER	4	35	6z 2775	SHCS8-32X1-1/8 SCREW		3
17	6z 0512	611480	BEARING	1					



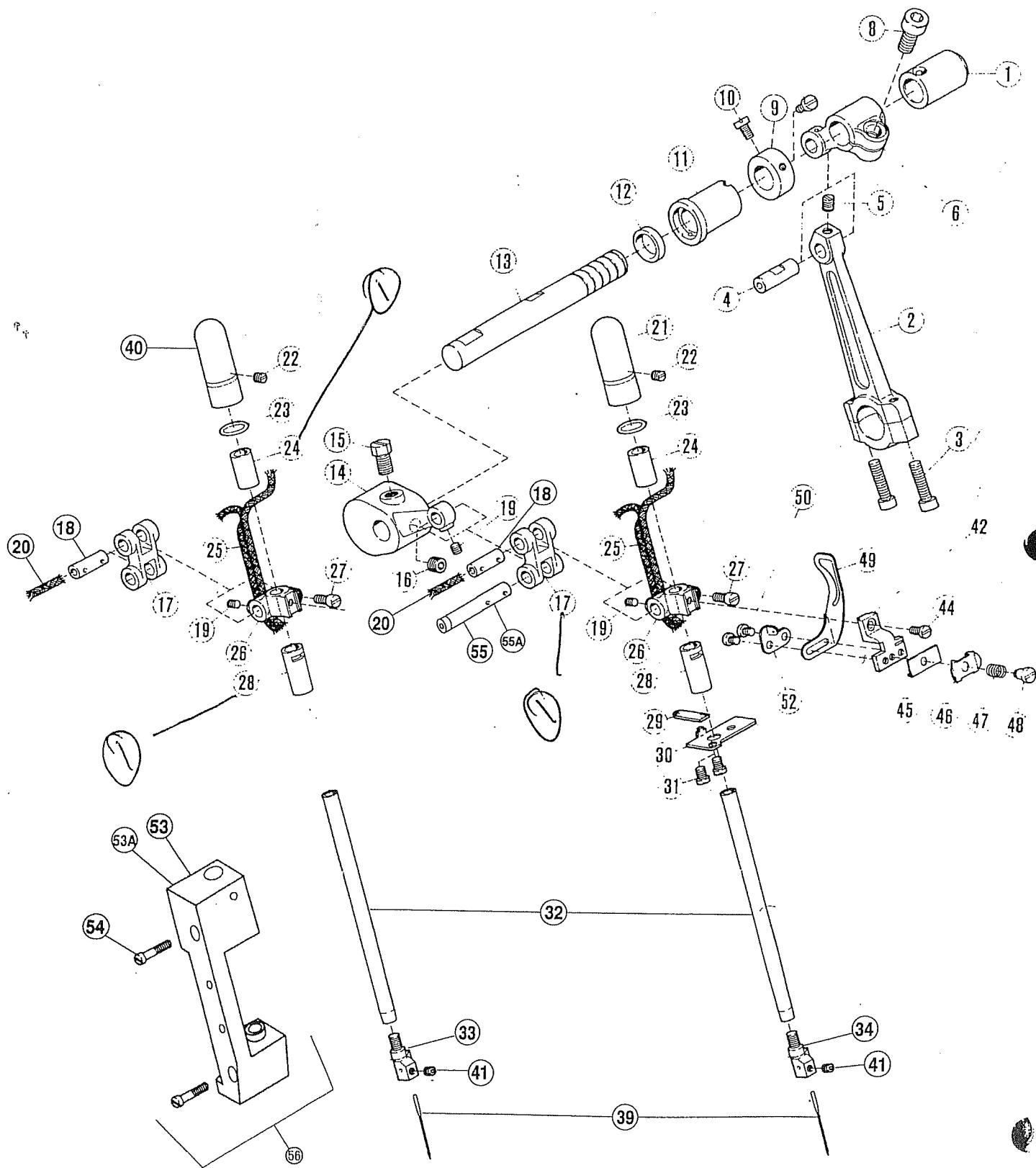
NEEDLE DRIVE AND NEEDLE GUARD MECHANISM



NEEDLE DRIVE AND NEEDLE GUARD MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z 1778	616840	NEEDLE THREAD TENSION COMPLETE	1	19	6z 3137	660001	THROAT PLATE ^(3/4")	1
2	6z 1824	616680	NUT	1	20	6z 0526	660039	CHAIN FINGER	1
3	6z 2870	616700	SPRING BUSHING	1	21	6z 0947	FHMS2-56X $\frac{1}{2}$ -PHL	CHAINFINGER SCREW	1
4	6z 1161	611040	SPRING (HEAVY)	1	22	6z 1106	610560	SCREW	1
5	6z 2871	616740	SPRING CUP	1	23	6z 2527	618420	SCREW	2
6	6z 0742	611460	DISC	2	24	6z 1049	614220	NEEDLE GUARD, FRONT	1
7	6z 0709	616720	CUSHION FELT	1	25	6z 2525	618380	SCREW	1
8	6z 2967	618880	POST, SHORT ENDED	1	26	6z 2158	614200	NEEDLE GUARD, REAR	1
9	6z 1381	611120	SPRING (LIGHT)	1	27	6z 1333	614240	NEEDLE GUARD BRACKET	1
10	6z 1998	618560	POST, LONG ENDED	1	28	6z 1312	618700	SCREW	1
11	6z 1568	611180	SPRING (MEDIUM)	1	29	6z 2544	619120	SCREW	1
12	6z 3036	611920	GUIDE DISC	1	30	6z 2754	SHCS4-40X $\frac{1}{2}$	SOCKET HEAD CAP SCREW	3
13	6z 1136	615880	TENSION GUIDE	1	31	6z 1879	630103	NEEDLE GUARD, FRONT	1
14	6z 1996	618800	POST LOCK NUT	1	32	6z 1266	630104	NEEDLE GUARD, REAR	1
15	6z 3090	640009	THREAD GUIDE	1	33	6z 1703	630105	NEEDLE GUARD BRACKET	1
16	6z 3091	640010	THREAD GUIDE	1	34	6z 1166	HHB10-32X $\frac{1}{2}$	BOLT	2
17	6z 2523	618340	SCREW	1	35	6z 2271	660050	SPACER, 1" MODEL ONLY	2
18	6z 1106	610560	SCREW	1	19A	6z 3128	660002	1" THROAT PLATE	1

NEEDLE BAR MECHANISM

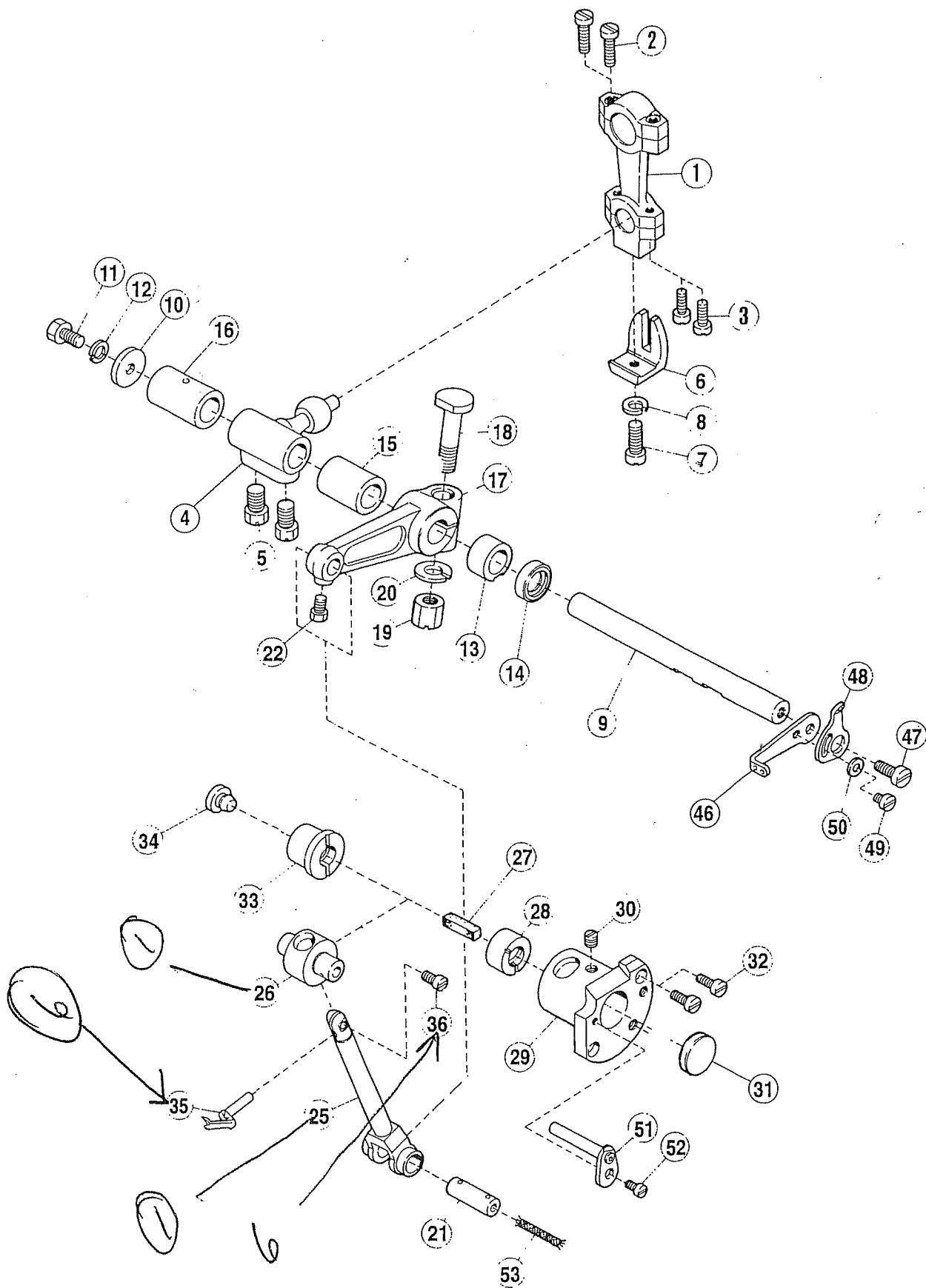


NEEDLE BAR MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z 0464	615440	BUSHING (RIGHT)	1	28	6z 1488	660024	BUSHING (LOWER)	2
2	6z 1653	612260	CONNECTION	1	29	6z 1842	617220	OIL FELT	1
3	6z 0500	619200	SCREW	2	30	6z 0764	617200	DUST SHIELD	1
4	6z 1931	614760	PIN	1	31	6z 0454	618440	SCREW	2
5	6z 1920	619220	SCREW	1	32	6z 1673	617280	NEEDLE BAR CLAMP	2
6	6z 2242	630107	CRANK(REA)	1	33	6z 1720	617300	NEEDLE HOLDER	1
8	6z 2761	SHCS $\frac{1}{4}$ -28X $\frac{1}{8}$	SCREW	1	34	6z 2255	630113	NEEDLE HOLDER	1
9	611220	611220	THRUST WASHER	1	39	6z 0121	PSM-1160	NEEDLE/OVERLOCK	2
10	6z 2552	619520	SCREW	2	40	6z 1637	660019	NEEDLE BAR CAP	1
11	6z 1322	615420	BUSHING (LEFT)	1	41	6z 2547	619400	SCREW	2
12	6z 1323	615460	OIL SEAL	1	42	6z 2222	614040	RETAINER BRACKET	1
13	6z 1654	615400	SHAFT	1	44	6z 2556	619640	SCREW	1
14	6z 0703	630136	CRANK (FRONT)	1	45	6z 1133	611720	GUIDE	1
15	6z 2518	611620	SCREW	1	46	6z 1132	610760	GUIDE	1
16	6z 2549	619420	SCREW	1	47	6z 2908	617340	SPRING	1
17	6z 0660	630118	LINK	2	48	6z 2565	629860	SCREW	1
18	6z 1927	610960	PIN	2	49	6z 1200	611880	TAKEUP	1
19	6z 2547	619400	SCREW	3	50	6z 2513	610135	SCREW	2
20	6z 3415	611600	OIL WICK	2	52	6z 3089	614060	THREAD GUIDE	1
21	6z 1638	660038	CAP	1	53	6z 1659	660020	NDLE. BAR SUPPORT ASSY, 3/4"	1
22	6z 2515	610420	SCREW	1	53A	6z 1613	660021	NDLE. BAR SUPPORT ASSY, 1"	1
23	6z 2291	610740	"O" RING	2	55A	6z 1909	660051	PIN CONN LINK (1" MODEL ONLY)	1
24	6z 3298	613900	BUSHING UPPER	2	54	6z 2776	SHCS8-32X1- $\frac{1}{8}$	SCREW	2
25	6z 3430	617420	OIL WICK	2	55	6z 1908	630115 *	PIN, CONNECTING LINK *	1
26	6z 1642	640012	NEEDLE BAR CLAMP	2	56	660052	660052	NEEDLE BAR SUPPORT WITH BUSHINGS	1
27A	6z 2774	SHCS6-32X $\frac{1}{8}$	SCREW	1					
27B	6z 2510	610060	SCREW	1					

* USE RETAINER #5103-23

SPREADER DRIVE MECHANISM

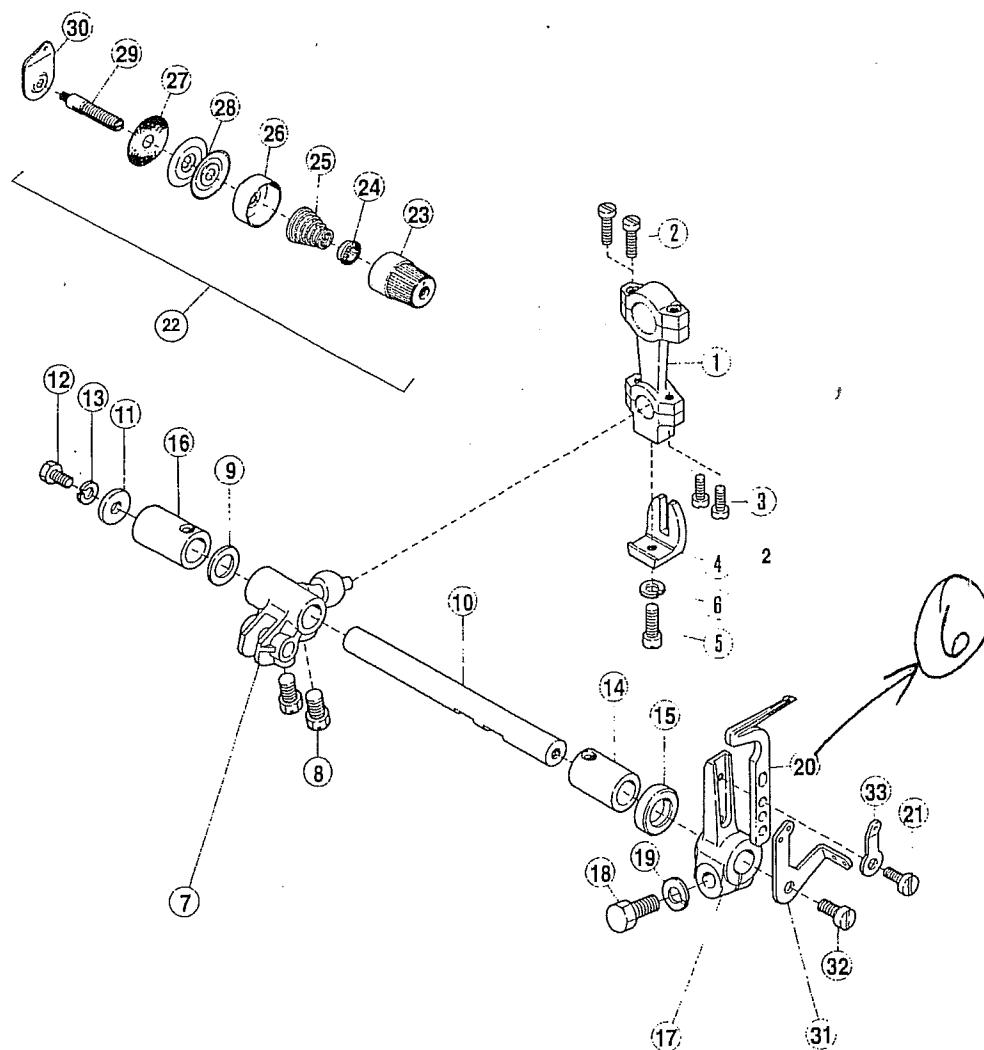


SPREADER DRIVE MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z 2250	616160	RIGHT LOOPER DRIVE CONN	1	22	6z 0629	618600	PIN SCREW	1
2	6z 2567	640013	CAP SCREW (LARGE)	2	25	6z 2252	616000	RIGHT LOOPER LEVER	1
3	6z 2567	640013	CAP SCREW (LARGE)	2	26	6z 3299	615100	GUIDE	1
4	612280	612280	CRANK	1	27	6z 13600	613600	OIL FELT	2
5	6z 2518	611620	CRANK SCREW	2	28	6z 1034	612380	BUSHING (FRONT)	1
6	611160	611160	GUIDE	1	29	6z 1253	640017	HOUSING	1
7	6z 2554	619600	GUIDE SCREW	1	30	6z 2568	640018	BUSHING FRONT SCREW	1
8	6z 2809	611640	GUIDE SCREW WASHER	1	31	6z 1254	615220	HOUSING CAP	1
9	640015	640015	RIGHT LOOPER DRIVE SHAFT	1	32	6z 2512	610100	HOUSING CAP SCREW	2
10	6z 3156	612640	THRUST WASHER	1	33	6z 0467	640016	BUSHING (REAR)	1
11	6z 3153	617540	THRUST WASHER SCREW	1	34	617060	617060	CAP SCREW (LARGE)	1
12	6z 2809	611640	WASHER	1	35	6z 2869	620244	SPREADER	1
13	615760	615760	BUSHING (FRONT)	1	36	6z 0552	610700	CLAMP SCREW	1
14	6z 1033	612300	BUSHING (FRONT) OIL SEAL	1	46	6z 3105	616660	THREAD TAKEUP	1
15	6z 0466	640014	BUSHING (CENTER)	1	47	6z 2808	618120	SCREW	1
16	6z 2148	616620	BUSHING (REAR)	1	48	6z 0216	614640	AUXILIARY EYELET	1
17	6z 0757	630119	RIGHT LOOPER LEVER CRANK	1	49	6z 0210	618200	AUXILIARY SCREW	1
18	6z 0553	619280	CLAMP SCREW	1	50	6z 0215	611960	AUXILIARY SCREW WASHER	1
19	6z 0550	619380	CLAMP SCREW NUT	1	51	640019	640019	THREAD GUIDE WIRE	1
20	6z 0548	611560	CLAMP SCREW NUT WASHER	1	52	6z 2525	618380	SCREW	1
21	6z 1934	615480	PIN	1	53	6z 1840	611580	OIL WICK	1

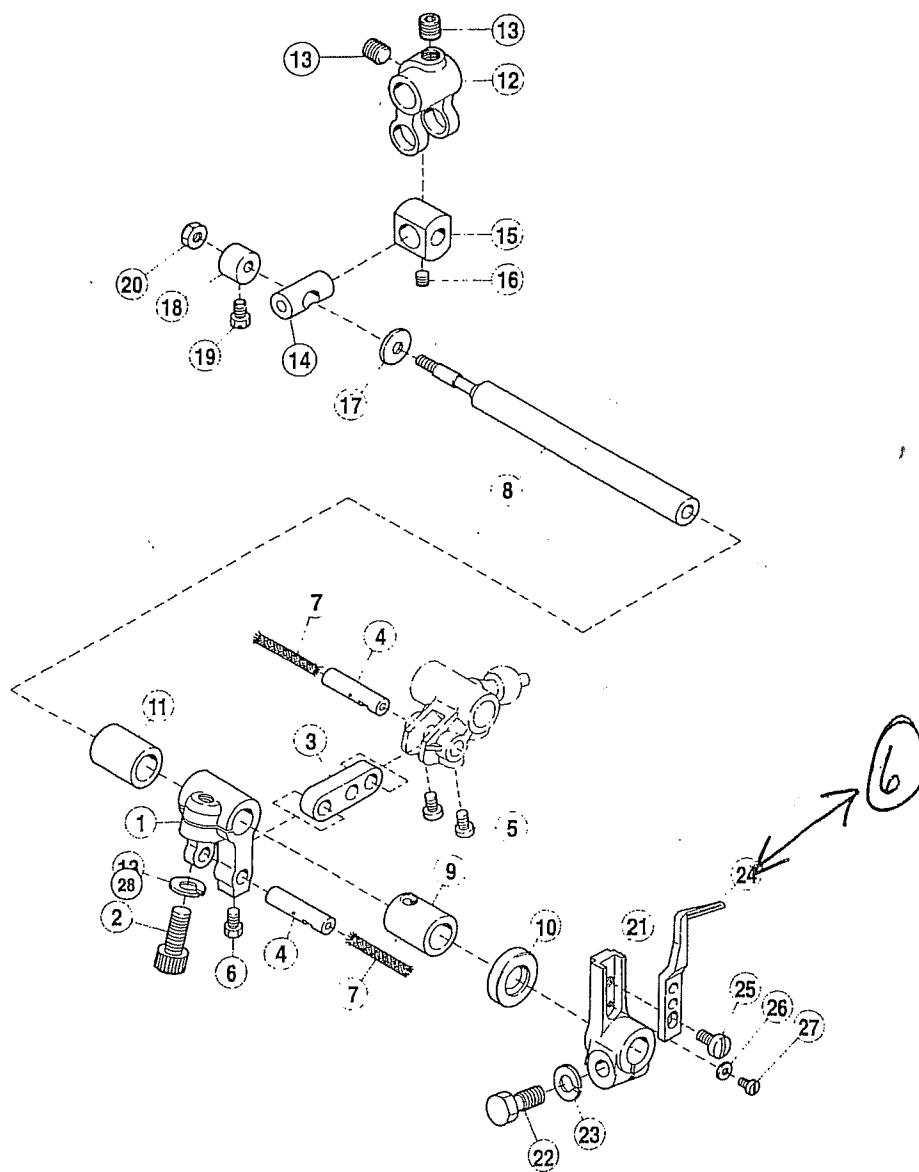
OVEREDGE (LEFT) LOOPER MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z2250	616160	LEFT LOOPER DRIVE CONN	1	18	6z0554	619360	CLAMP SCREW	1
2	6z2567	640013	CAP SCREW	4	19	6z0551	613640	CLAMP SCREW-WASHER	1
4	611160	611160	GUIDE	1	20	6z1443	620238	RIGHT LOOPER LEVER	1
5	6z2569	640021	GUIDE SCREW	1	21	6z2068	610120	SCREW	1
6	6z2809	611640	GUIDE SCREW WASHER	1	22	6z3108	616860	THREAD TENSION COMPLETE	1
7	615240	615240	LEFT LOOPER DRIVE CRANK	1	23	6z1824	616680	NUT	1
8	6z2518	611620	SCREW	2	24	6z2870	616700	SPRING BUSHING	1
9	6z3345	640006	THRUST WASHER	1	25	6z1568	611180	SPRING (MIDDLE)	1
10	640015	640015	LEFT LOOPER LEVER SHAFT	1	26	6z2871	616740	SPRING CUP	1
11	6z3156	612640	THRUST WASHER	1	27	6z0709	616720	CUSHION FELT	1
12	6z3153	617540	THRUST WASHER SCREW	1	28	6z0742	611460	DISC	2
13	6z2809	611640	WASHER	1	29	6z1998	618560	POST	1
14	6z0469	640023	BUSHING (FRONT)	1	30	6z3036	611920	GUIDE	1
15	6z1852	640024	BUSHING FRONT OIL SEAL	1	31	6z1533	614620	LEFT LOOPER THREAD TAKEUP	1
16	6z0468	640022	BUSHING (REAR)	1	32	6z2808	618120	SCREW	1
17	6z1331	614000	RIGHT LOOPER LEVER	1	33	6z0831	640025	THREAD GUIDE	1

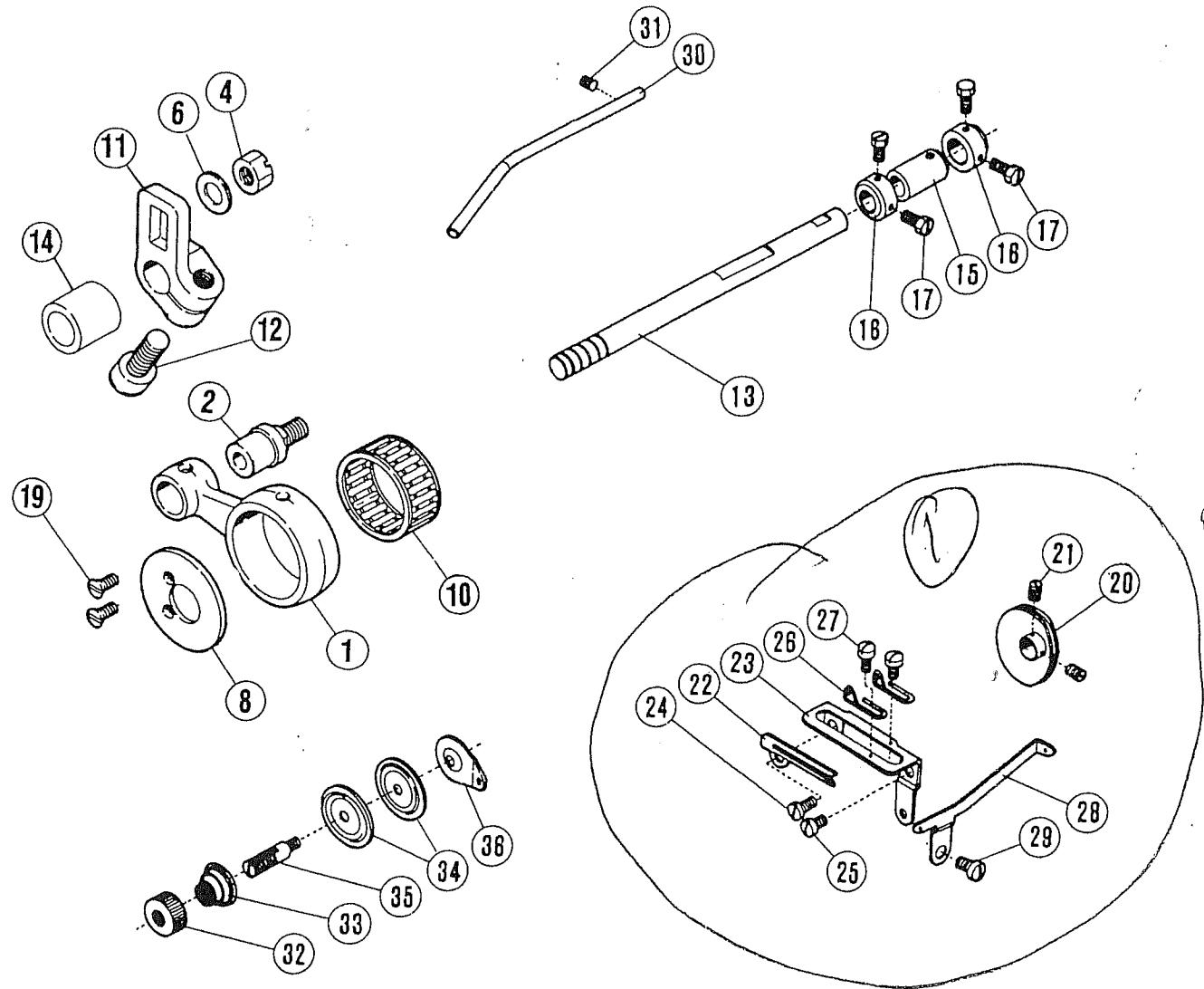


I) CHAINSTITCH LOOPER MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1640020640020	LOOPER DRIVE CRANK	1	156z0315615000	BLOCK	1
2619265619265	CLAMP SCREW	1	166z2547619400	BLOCK SCREW	1
36z1387615280	LINK	1	176z3157615020	THRUST WASHER	1
46z1384615300	LINK PIN	2	186z0637615040	COLLAR	1
56z2552619520	LINK PIN SCREW	2	196z0629618600	COLLAR SCREW	1
66z0629618600	LINK PIN SCREW	1	206z2570640026	NUT	1
76z3415611600	OIL WICK	2	216z1433612520	LOOPER LEVER	1
86z1430615320	LOOPER DRIVE SHAFT	1	226z0554619360	CLAMP SCREW	1
96z1035615820	BUSHING FRONT	1	236z0551613640	CLAMP SCREW WASHER	1
106z1852640024	BUSHING FRONT OIL SEAL	1	246z1484620270	LOOPER	1
116z0466640014	BUSHING REAR	1	256z2514610140	SCREW	1
126z1415614960	LOOPER AVOIDING LINK	1	266z2174613200	REGULATOR	1
136z2557619720	SCREW	2	276z1959618220	REGULATOR SCREW	2
146z1932614980	PIN	1	286z0551613640	WASHER	1



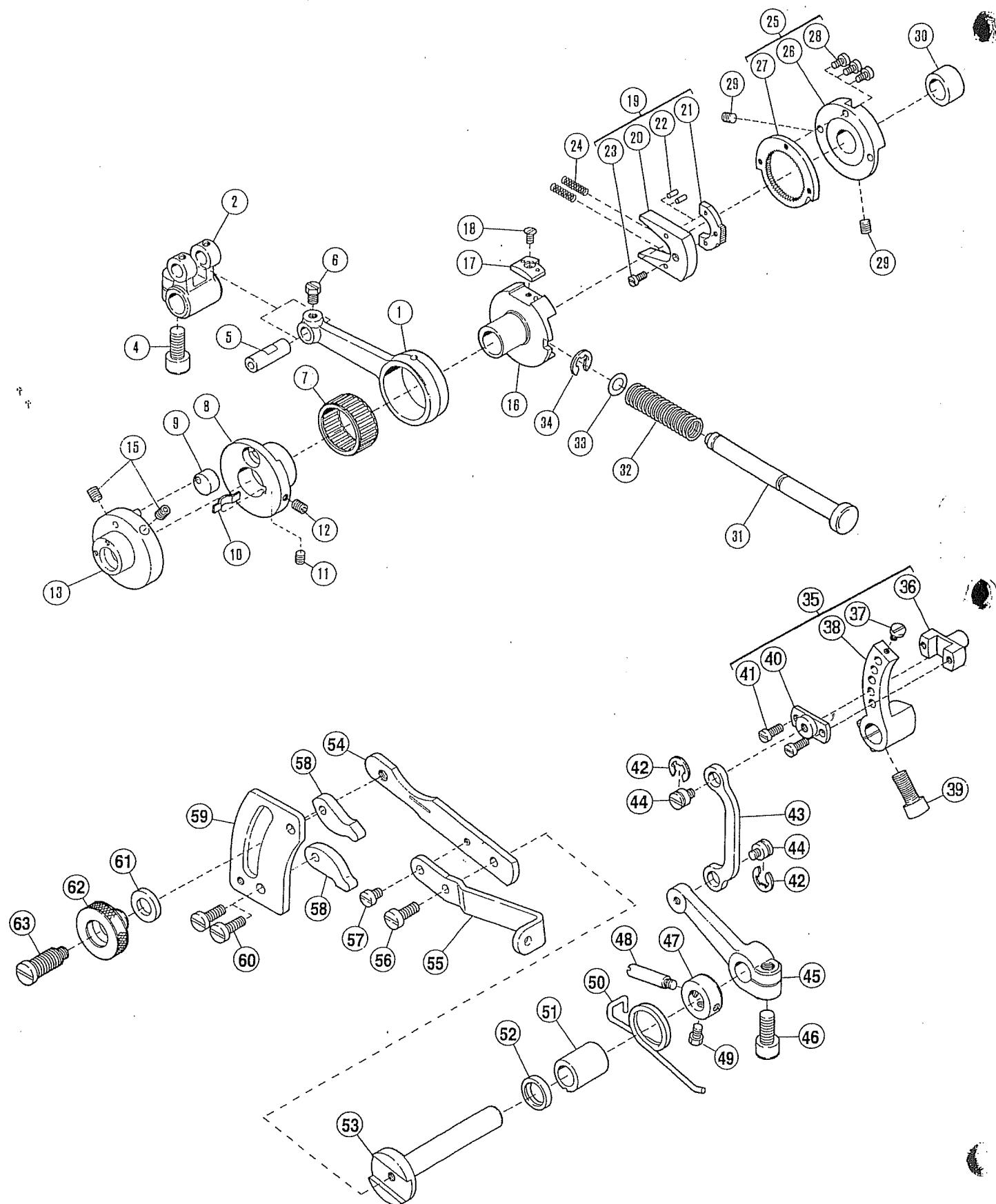
2) CHAINSTITCH LOOPER MECHANISM



2) CHAINSTITCH LOOPER MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z 1412	620030	LOOPER AVOIDING CONNECTION	1	22	6z 1134	612560	GUIDE	1
2	6z 1937	620031	PIN	1	23	6z 1458	612580	LOOPER THREAD GUIDE BRACKET ...	1
4	6z 1916	619740	PIN NUT	1	24	6z 2523	618340	SCREW.....	1
6	6z 1914	615740	PIN NUT WASHER	1	25	6z 2534	618720	SCREW.....	1
8	6z 1411	620029	COLLAR.....	1	26	6z 3003	613700	TAKEUP EYELET	2
10	6z 1678	620028	NEEDLE BEARING	1	27	6z 2529	618480	SCREW.....	2
11	6z 1413	620032	LOOPER AVOIDING CRANK	1	28	6z 1457	616220	LOOPER THREAD GUIDE	1
12	6z 0556	620026	CLAMP SCREW	1	29	6z 2534	618720	SCREW.....	1
13	6z 1416	614540	LOOPER AVOIDING SHAFT	1	30	6z 1462	612600	LOOPER THREAD TUBE	1
14	6z 0470	640027	LEFT BUSHING	1	31	6z 2515	610420	SCREW.....	1
15	6z 2244	612500	RIGHT BUSHING	1	32	6z 1461	618300	LOOPER THREAD TENSION NUT	1
16	6z 3150	611100	THRUST COLLAR.....	2	33	6z 2902	610520	SPRING	1
17	6z 0629	618600	COLLAR SCREW.....	4	34	6z 0742	611460	DISC	2
19	619315	619315	SCREW.....	2	35	6z 1997	610500	POST	1
20	6z 1459	612540	LOOPER THREAD TAKEUP	1	36	6z 3036	611920	GUIDE	1
21	6z 2547	619400	GENUINE SCREW.....	2					

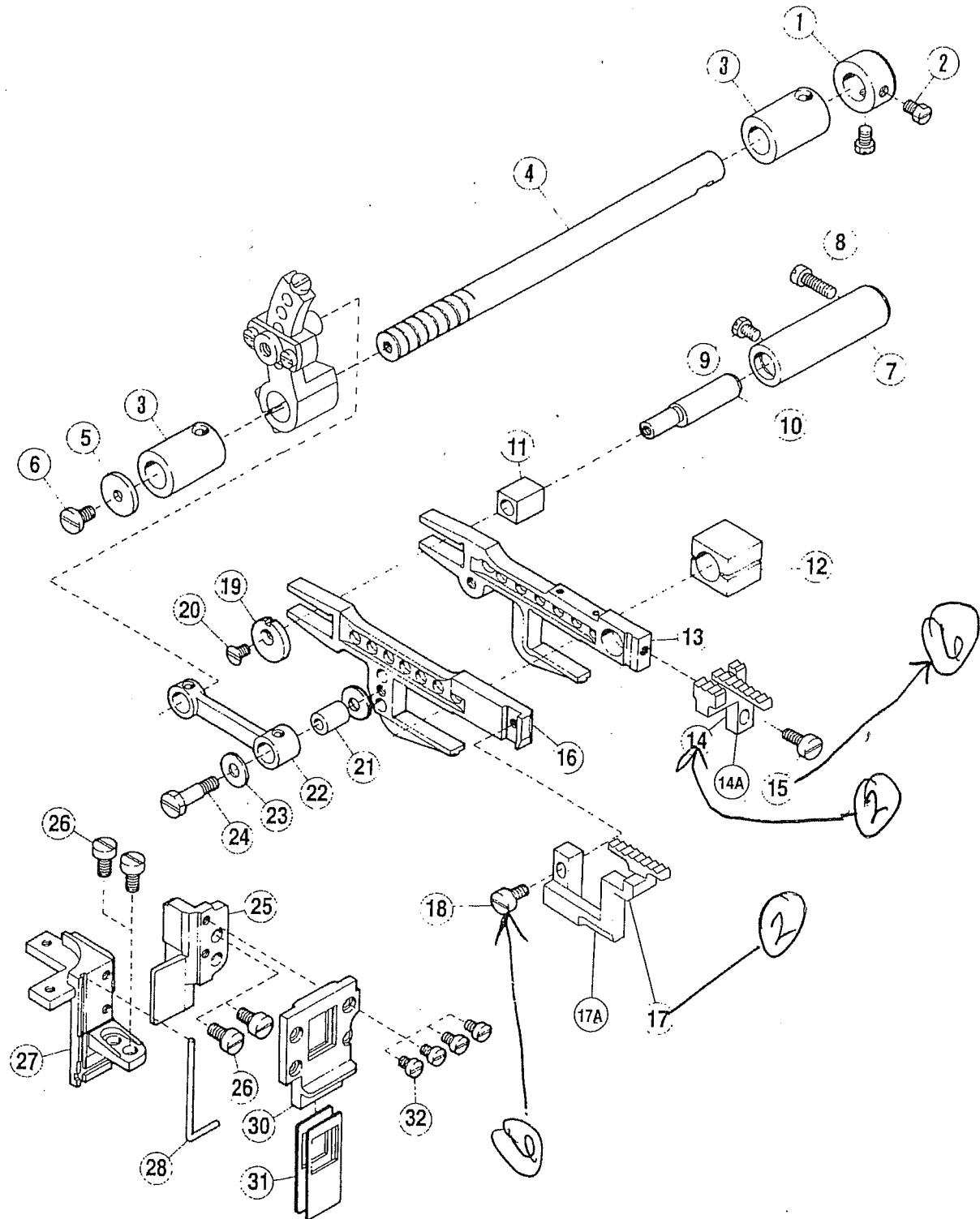
I) MAIN & DIFFERENTIAL FEED MECHANISM



I) MAIN & DIFFERENTIAL FEED MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z 0902	612620	FEED DRIVE CONNECTION	1	34	6z 2382	611740	RETAINING RING	2
2	6z 2937	620217	FEED DRIVE CRANK	1	35	6z 0702	615560	DIFF. FEED REG. ASSY. (REF.#36-41)	1
4	SHCS4-28X $\frac{1}{2}$	SHCS4-28X $\frac{1}{2}$	SCREW	1	36	615600	615600	BLOCK	1
5	6z 1931	614760	PIN	1	37	6z 2533	618660	STOP SCREW	1
6	6z 0629	618600	PIN SCREW	1	38	615580	615580	SEGMENT (CRANK)	1
7	6z 1677	612480	NEEDLE BEARING	1	39	6z 0555	619700	SCREW	1
8	6z 0910	620034	FEED DRIVE ECCENTRIC	1	40	615610	615610	COVER	1
9	6z 0905	620037	FEED ECCENTRIC GUIDE	1	41	6z 2527	618420	SCREW	2
10	6z 0854	620038	FLAT SPRING	1	42	6z 2382	611740	RETAINING RING	2
11	6z 2547	619400	SET SCREW	1	43	6z 0735	612820	DIFF. FEED REG. LINK	1
12	6z 2564	620039	SET SCREW	1	44	6z 2551	619460	SCREW	2
13	6z 1414	620040	LOOPER AVOIDING ECCENTRIC	1	45	6z 0928	612800	DIFF. FEED REG. LEVER	1
15	6z 2641	620033	SET SCREW	2	46	6z 0555	619700	SCREW	1
16	6z 0911	620042	FEED REGULATING ECCENTRIC	1	47	6z 3151	614120	COLLAR	1
17	6z 2948	620052	STOPPER	1	48	6z 1318	614180	SCREW PIN	1
18	6z 2558	619780	SCREW	1	49	6z 0629	618600	SCREW	1
19	6z 0922	616340	FD.REG.RACHET ASSY.(REF.#20-24)	1	50	6z 2170	614160	REGULATING SPRING	1
20	616365	616365	POSITION GEAR BRACKET	1	51	640031	640031	BUSHING	1
21	616360	616360	POSITION GEAR	1	52	6z 1033	612300	OIL SEAL	1
22	6z 1938	640029	PIN	2	53	6z 0736	614100	DIFF. FEED SHAFT	1
23	6z 2553	619580	SCREW	1	54	6z 2160	614140	DIFF. FEED REG. LEVER	1
24	6z 2907	616400	SPRING	2	55	6z 1043	614600	LEVER (FRONT)	1
25	6z 2141	620035	RACHET WHEEL ASSY. (REF.#26-29)	1	56	6z 2353	618760	SCREW	1
26	620043	620043	BRACKET	1	57	6z 1398	610200	SCREW	1
27	620044	620044	WHEEL	1	58	6z 3269	612860	STOPPER	2
28	620045	620045	SCREW	3	59	6z 1342	612840	REGULATING PLATE	1
29	6z 2641	620033	SET SCREW	2	60	6z 2353	618760	SCREW	2
30	6z 2814	620053	SPACER	1	61	6z 1340	611940	WASHER	1
31	6z 2133	620055	PUSH BUTTON	1	62	6z 1339	614480	THUMB NUT	1
32	6z 2267	616520	SPRING	1	63	6z 1341	619500	SCREW	1
33	620054	620054	O-RING	1					

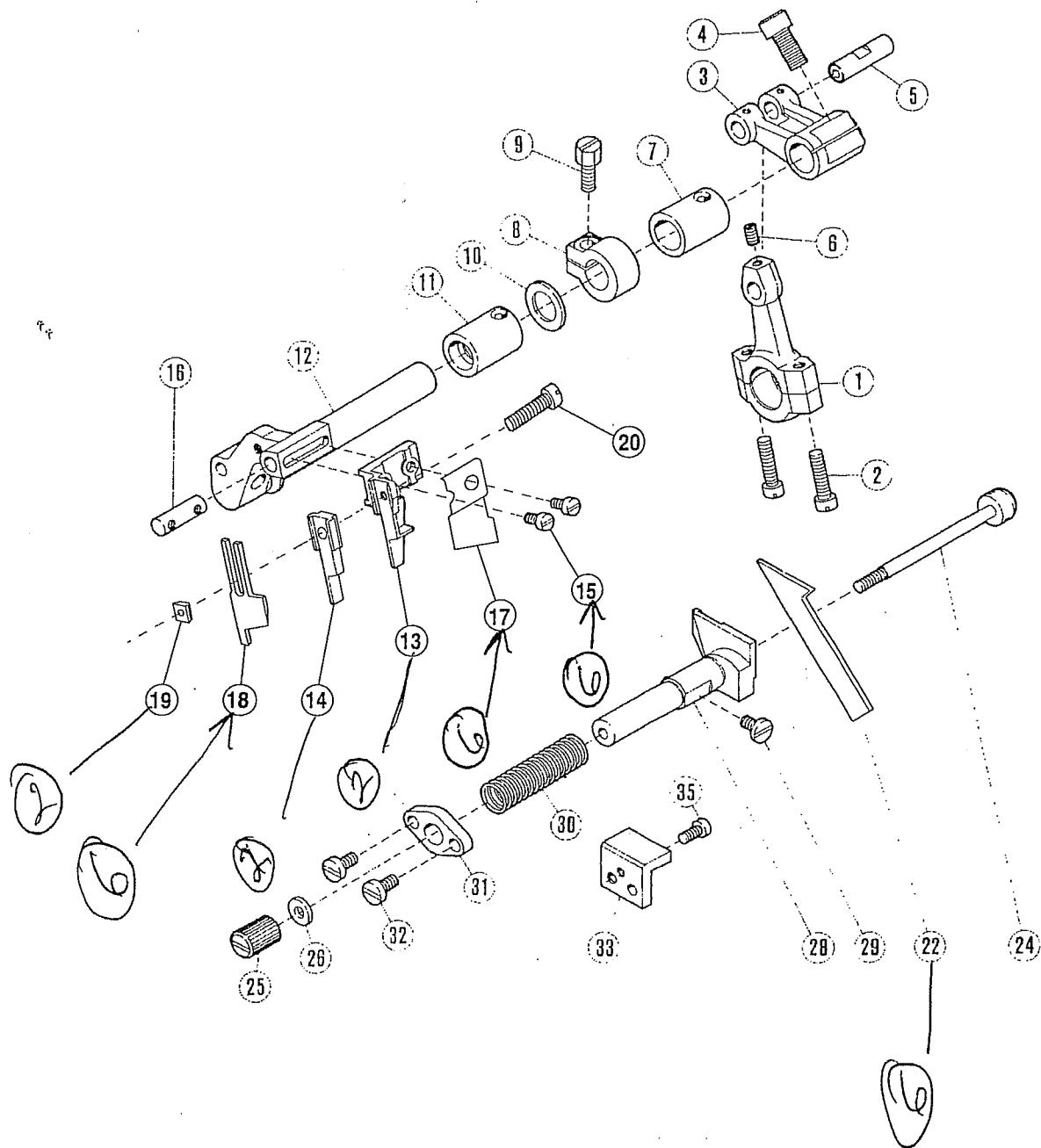
2) MAIN & DIFFERENTIAL FEED MECHANISM



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2) MAIN & DIFFERENTIAL FEED MECHANISM

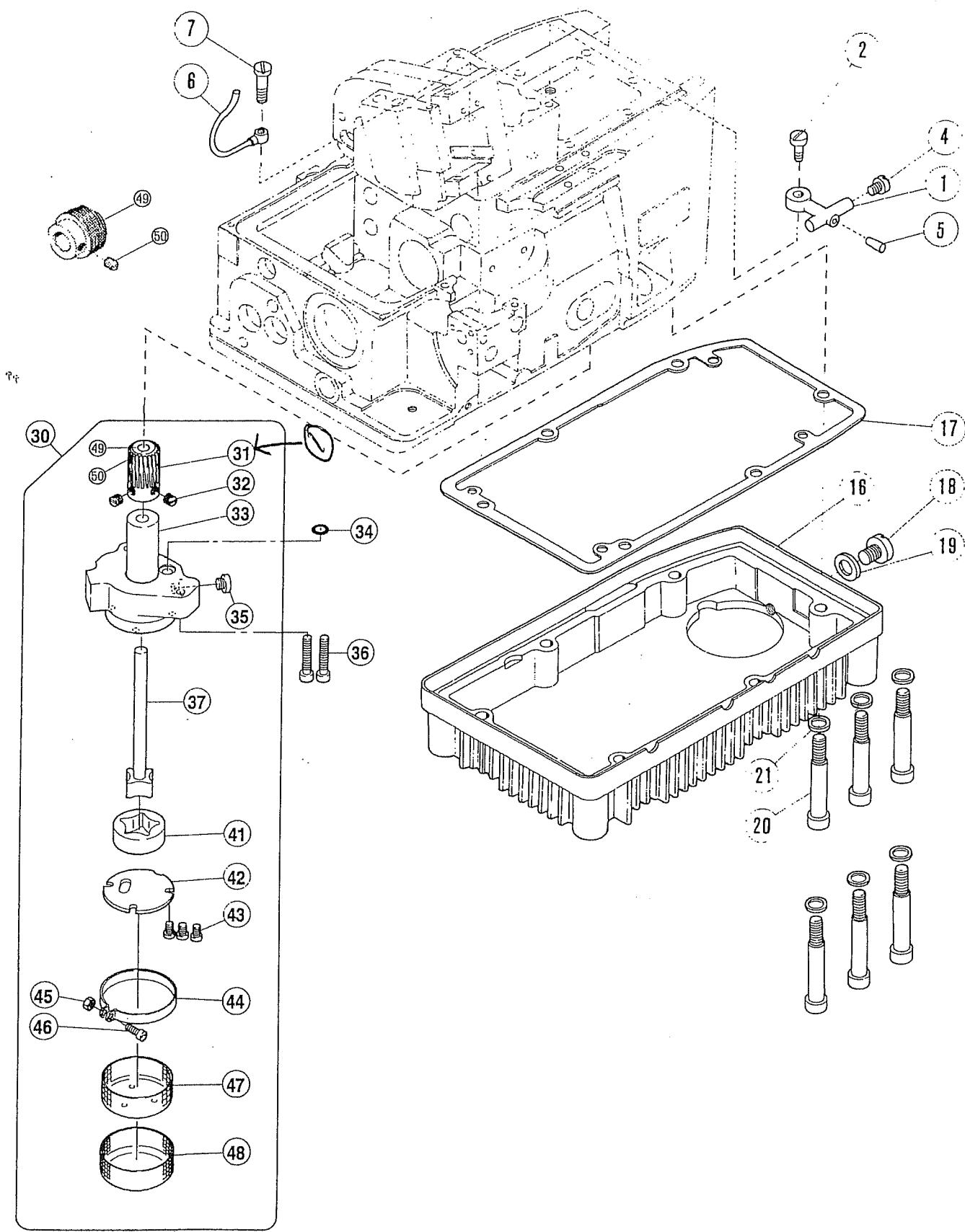
Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z 3150611100	THRUST COLLAR	1	17	6z 1537660003	DIFFERENTIAL FEED DOG, 3/4" (FRONT)	1
2	6z 0629618600	THRUST COLLAR SCREW	2	17A	6z 1495660004	DIFFERENTIAL FEED DOG, 1" (FRONT)	4
3	6z 0471640032	BUSHING	2	18	6z 2068610120	SCREW	1
4	6z 0863614080	FEED BAR SHAFT	1	19	6z 3343613780	WASHER	1
5	6z 3156612640	THRUST WASHER	1	20	6z 3322619480	WASHER SCREW	1
6	6z 2523618340	THRUST WASHER SCREW	1	21	6z 0462612680	BUSHING	1
7	6z 0857612780	FEED BAR GUIDE BUSHING	1	22	6z 0650612720	CONNECTING LINK	1
8	6z 0454617440	SCREW	1	23	6z 0453612700	BUSHING SCREW WASHER	1
9	6z 0629618600	SCREW	1	24	6z 0455619140	BUSHING SCREW	1
10	6z 0860612760	FEED BAR HINGE PIN	1	25	6z 2245615140	FEED BAR GUIDE (RIGHT)	2
11	6z 1138640033	FEED BAR GUIDE BLOCK	1	26	6z 2542619080	SCREW	1
12	6z 2825614320	LIFT BLOCK (SPLIT)	1	27	6z 1139640034	FEED BAR GUIDE	1
13	6z 1544612730	FEED BAR	1	28	6z 1072615200	GASKET	4
14	6z 1539660005	MAIN FEED DOG, 3/4" (REAR)	1	30	6z 1262615180	INSERT PLATE	1
14A	6z 1538660006	MAIN FEED DOG, 1" (REAR)	1	31	6z 0849615160	FEED BAR OIL SPLASH GUARD	1
15	6z 2512610100	SCREW	1	32	6z 2554619600	SCREW	1
16	6z 0731612740	DIFFERENTIAL FEED BAR	1					

UPPER & LOWER KNIFE MECHANISM

UPPER & LOWER KNIFE MECHANISM

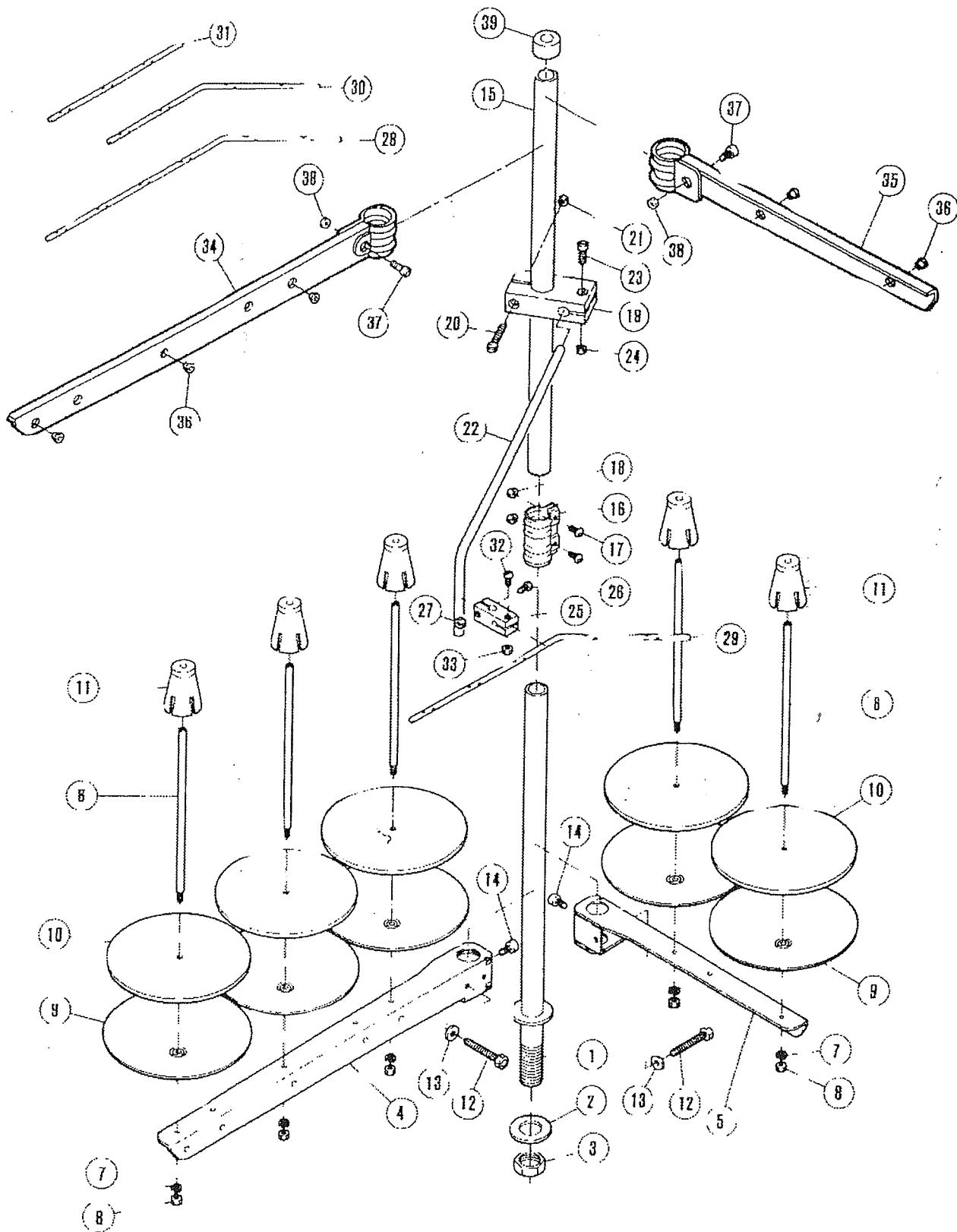
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1	6z3269	612880	UPPER KNIFE DRIVE CONN.....	1	17	6z3232	620240	TRIM SHIELD	1
2	6z0500	619200	CAP SCREW	2	18	6z3284	630128	UPPER KNIFE-CARB. TIPPED	1
3	6z3270	613000	UPPER KNIFE DRIVE CRANK	1	19	6z3285	630127	T-NUT	1
4	6z0555	619700	CLAMP SCREW	1	20	6z2771	SHCS6-32X $\frac{1}{2}$	SCREW	1
5	6z1929	612900	PIN	1	22	6z0385	630150	LOWER KNIFE	1
6	6z1919	610440	PIN SCREW	1	24	6z0563	613160	CLAMP STUD	1
7	640035	640035	BUSHING (LEFT)	1	25	6z0560	619320	CLAMP STUD NUT	1
8	614815	614815	THRUST COLLAR	1	26	6z0561	610780	CLAMP STUD NUT WASHER.....	1
9	618350	618350	THRUST COLLAR SCREW	2	28	6z1503	616280	LOWER KNIFE HOLDER	1
10	615390	615390	WASHER	1	29	6z2523	618340	SCREW	1
11	613020	613020	BUSHING (RIGHT)	1	30	6z2904	613080	SPRING	1
12	620184	620184	UPPER KNIFE LEVER	1	31	613100	613100	SPRING SEAT	1
13	6z3266	640036	UPPER KNIFE CLAMP MODIFIED.....	1	32	6z2535	618740	SPRING SEAT SCREW	2
14	6z0793	630148	UPPER KNIFE SPACER	1	33	6z1135	613120	GUIDE	1
15	6z2512	610100	SCREW	2	35	6z2512	610100	GUIDE SCREW	1
16	6z1930	613060	PIN	1					

LUBRICATING MECHANISM



LUBRICATING MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z 0743	613440	OIL DISTRIBUTOR	1	34	6z 1833	613320	"O" RING	1
2	6z 1860	610860	OIL SPLASH SCREW	1	35	6z 2536	618900	SCREW	1
4	6z 3372	613360	SCREW	1	36	6z 2533	618660	SCREW	2
6	6z 1859	613460	OIL SPLASH PIPE COMPLETE	1	37	6z 2278	620020	INSIDE ROTOR SHAFT	1
7	6z 1861	611520	OIL SPLASH SCREW	1	41	6z 1850	620024	OUTSIDE ROTOR	1
16	6z 1851	615500	OIL RESERVOIR	1	42	620025	620025	ROTOR PLATE	1
17	6z 1073	615980	GASKET	1	43	6z 2552	619520	SCREW	3
18	6z 0057	618840	SCREW	1	44	6z 0905	640037	FILTER CLAMP	1
19	6z 3340	611660	WASHER	1	45	6z 1825	618320	NUT	1
20	6z 0375	618960	BOLT	6	46	6z 2740	610040	SCREW	1
21	6z 3344	614300	WASHER	6	47	6z 2564	640039	INSIDE FILTER	1
30	6z 1088	613880	GEAR PUMP COMPLETE	1	48	6z 0854	640038	OUTSIDE FILTER	1
31	6z 3372	613360	WORM WHEEL	1	49	6z 3369	613340	WORM GEAR	1
32	6z 3149	618460	SCREW	2	50	6z 2518	611620	SCREW	1
33	620019	620019	CASING COMPLETE	1					

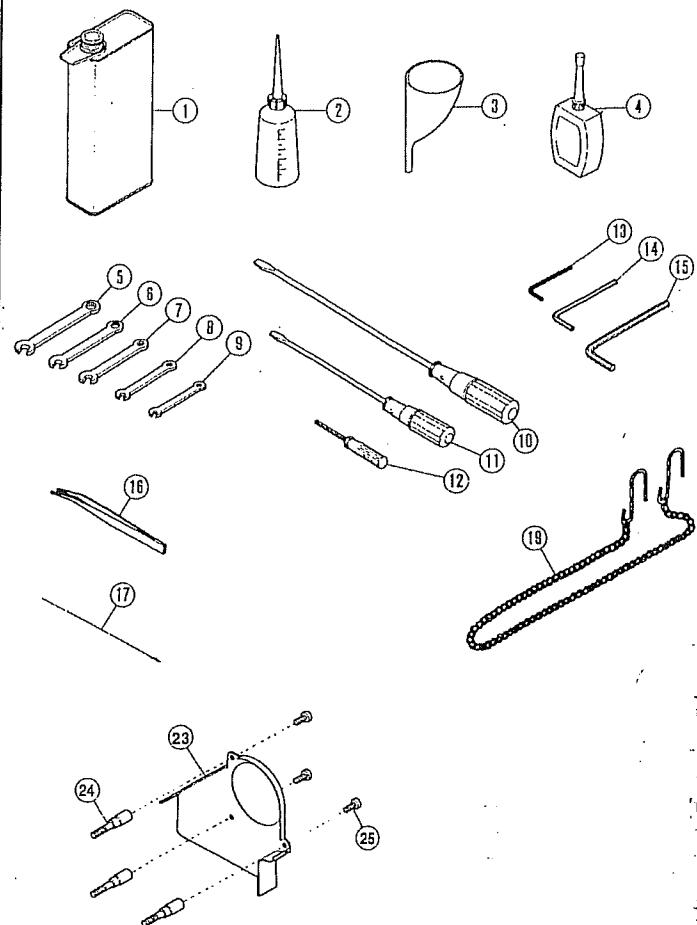
THREAD STAND

THREAD STAND

Ref#	LPCS#	Part#	Description	3 spool	4 spool	5 spool
1	6z3102	THREAD STAND ROD (LOWER)	1	1	1
2	640044	WASHER	1	1	1
3	640042	NUT	1	1	1
4	6z1899	BRACKET	1		1
5	6z0408	BRACKET		2	1
6	6z2835	SPOOL PIN	3	4	5
7	6z3346	SPRING WASHER	3	4	5
8	6z1828	NUT	3	4	5
9	6z2838	SPOOL TRAY	3	4	5
10	6z1900	CUSHION	3	4	5
11	6z2837	SPOOL RETAINING FIN	3	4	5
12	640065	SCREW	1	2	2
13	6z3347	WASHER	1	2	2
14	6z2574	SCREW	1	2	2
15	640040	THREAD STAND ROD (UPPER)	1	1	1
16	6z3100	JOINT	1	1	1
17	640057	SCREW	2	2	2
18	6z1827	NUT	2	2	2
19	6z2264	BRACKET	1	1	1
20	6z0237	THREAD GUIDE BAR ORD.	1	1	1
21	6z2572	SCREW	1	1	1
22	6z1828	NUT	1	1	1
23	6z1214	HOLDER	1	1	1
24	6z2573	SCREW	2	2	2
25	6z1828	NUT	2	2	2
26	6z3074	THREAD GUIDE BAR (5-SPOOLS)			1
27	618241	THREAD GUIDE BAR (4-SPOOLS)			1
28	618242	THREAD GUIDE BAR (3-SPOOLS)		1	
29	6z2573	SCREW	1	1	1
30	6z1828	NUT	1	1	1
31	6z0410	BRACKET		1	
32	6z0406	BRACKET		2	1
33	6z3070	THREAD EYELET	3	4	5
34	6z2571	SCREW	1	2	2
35	6z1827	NUT	1	2	2
36	640041	ROD CAP	1	1	1
*	6z3489	THREAD STAND ASS. (5-SPOOLS)			1
*	6z3476	THREAD STAND ASS. (4-SPOOLS)		1	
*	640070	THREAD STAND ASS. (3-SPOOLS)	1		

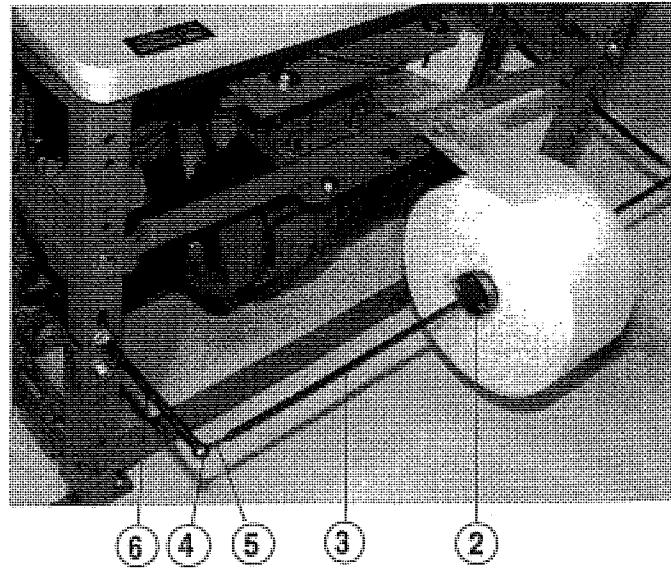
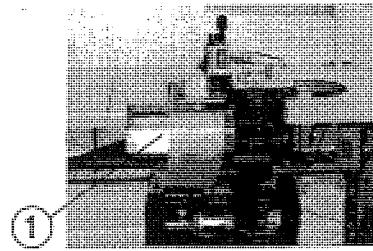
ACCESSORIES

Ref#	LPCS#	Part#	Description	Qty
1	6z1834	610340	OIL CONTAINER	1
2	6z1865	610320	OILER	1
3	6z1846	610380	OIL FUNNEL	1
4	6z3495	610580	LUBRICANT CONTANINER	1
5	6z3525	618080	WRENCH (9.5MM)	1
6	6z3524	618060	WRENCH (8MM)	1
7	6z3517	618040	WRENCH (7MM)	1
8	6z3506	618020	WRENCH (6MM)	1
9	6z3493	618000	WRENCH (5MM)	1
10	6z1313	610260	SCREWDRIVER (LARGE)	1
11	6z1563	610280	SCREWDRIVER (MEDIUM)	1
12	6z0185	610600	ALLEN WRENCH	1
13	6z0186	640071	ALLEN KEY (2.38MM)	1
14	6z3451	610640	ALLEN KEY (3.17MM)	1
15	6z3475	610720	ALLEN KEY (4.76MM)	1
16	6z3239	610300	TWEEZERS	1
17	6z3114	610460	THREADING WIRE	1
19	6z0518	640072	THREADLE CHAIN	1
23	6z0271	614720	BELT GUARD	1
24	6z0964	614740	FIXING SCREW	3
25	6z2535	618740	SCREW	3
26	6z3464	.35V	V-BELT (not shown)	1



MISCELLANEOUS STAND PARTS

Ref#	LPCS#	Part#	Description	Qty
1	6z0966	P110	FLANGE FOLDER ASSY.	1
2	6z0644	CB5-1/2	CONE BEARING	2
3	6z0971	1249	SHAFT	1
4	6z3405	.6072K21	BALL JOINT	1
5	6z1227	.9491T14	HOOK	1
6	6z0972	1248	STANDOFF	2



INDEX (CONTINUED)

PART#	LPCS#	PAGE	REF#	PART#	LPCS#	PAGE	REF#	PART#	LPCS#	PAGE	REF#	PART#	LPCS#	PAGE	REF#
616365.....616365.....35.....20	618380.....6z2525.....25.....25	619400.....6z2547.....27.....19	620195.....6z1855.....19.....46												
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