

I. MACHINE HEAD IDENTIFICATION

a) Identification numbers

1. Each machine head is identified by:
 - Class or sub-class number
 - Serial number
2. The class or sub-class number is punched on the name-plate bonded to the machine base.
3. The machine head serial number is punched on a boss provided for the purpose on the rear base.

II. TECHNICAL DATA BY MACHINE HEAD CLASS

The heads illustrated in this catalogue are the single needle overlocking machines with the following general features:

1. RIM 27 straight needle system - size 55 to 100.
2. Differential can be adjusted while machine is running.
3. Stitch length adjustment by push-button control.
4. Stitch length adjustment range: from 6 to 48 stitches per inch.
5. Differential Feed Ratio: up to 3,5 : 1 current use, but 4 : 1 can be attained.
6. Width of bight: from 3/64" to 15/64".
7. Speed: from 5400 to 7000 r.p.m. according to type of use.
8. Lubrication: by two-stage oil pump
9. Drive motor: 1/3 HP or 1/2 HP according to sub-class.
10. Overall dimensions of machine head: 11 4/5" x 9 1/2".
11. Weight: about 46 lbs.

5. Timing Secondary Looper

Note: To set the dimension $11/32''$ in **Fig. 9**, rotate lever E upwards or downwards: remember that by doing this the dimensions in **Figs. 7** and **8** will be increased or decreased.

- Slightly loosen screw B
- Slightly loosen screw A
- Adjust crossing of secondary and primary looper rotating the secondary so that its tip passes behind the primary looper barely skimming it
- Check distances given in figures 7-8-9 (see timing table)
- During its left to right motion the secondary looper should barely skim the needle.
- If adjustment is required, slightly loosen Screw D and push the complete looper assembly inwards or outwards, avoiding any change in the distance already fixed. Make sure all parts move smoothly
- Lock screw D
- Recheck to make sure the two loopers are crossing smoothly and verify all the other settings.
- Tighten up screws A and B.
- Finally, make sure all the assembly are moving smoothly

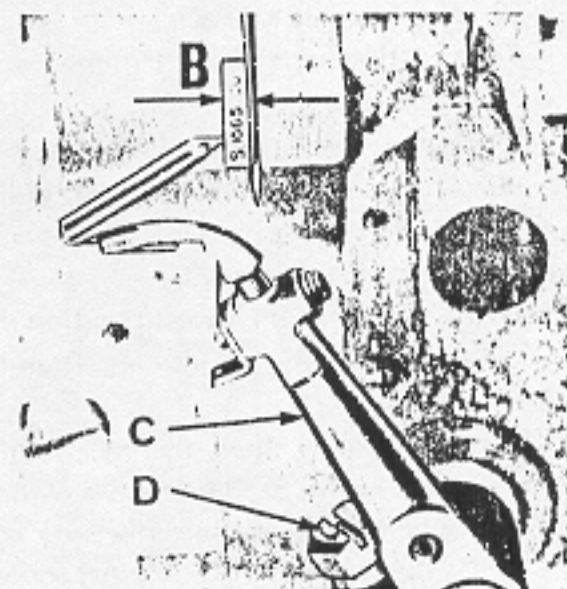


fig. 6

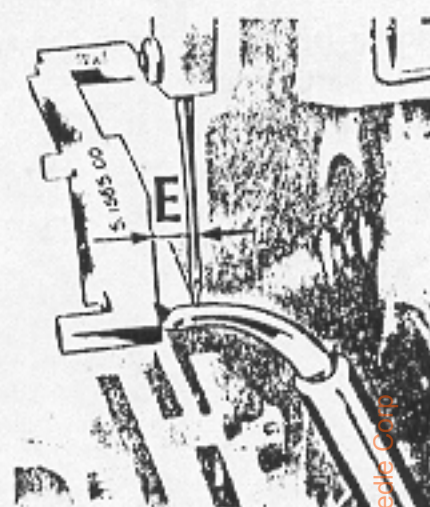


fig. 7

6. Mounting needle guards (fig. 10)

Mount front needle guard A.

- With needle in its lowest position, bring front needle guard close up so that the tip of the primary looper barely skims the needle as it moves rightwards.
- Tighten up screw C.
- Mount rear needle guard B and bring it close up to the needle, which should still be in its lowest position.
- Tighten up screw D.

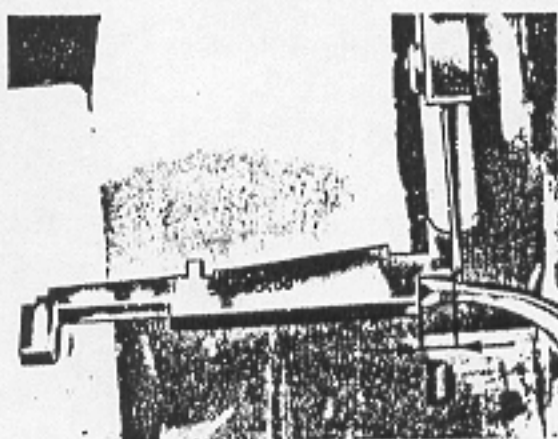


fig. 8

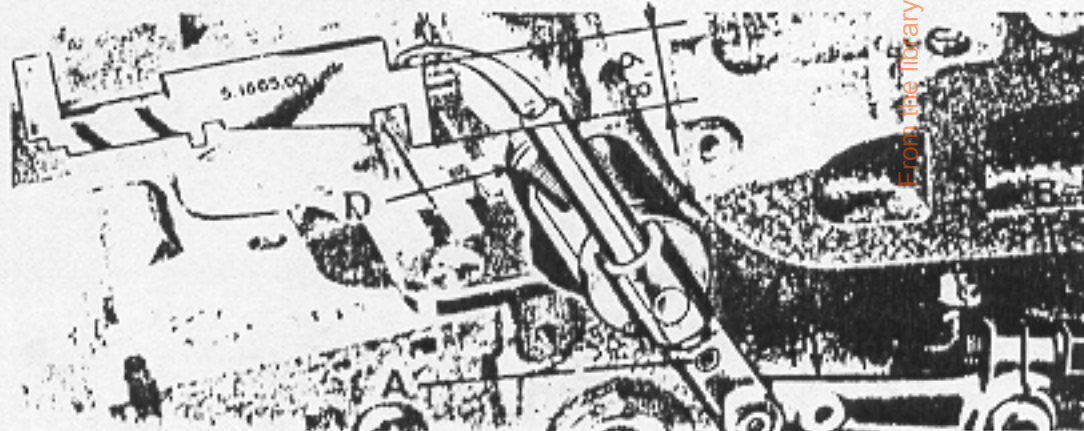


fig. 9

- With machine running, check that when the needle bends it does not break because of impact against the primary looper. This is done by bending the needle inwards and checking that the looper engages with the needle on its left-to-right motion without breaking it.
- Thread needle, move it to its lowest position and press it slightly against rear needle guard B.
- The thread must run smoothly. If it does not, then the needle is too low and the thread is trapped between needle and rear needle guard

Note: As the looper moves from left to right its tip should enter in the upper part of the scarf; conversely, when looper moves from right to left, its tip should enter the lower part of the scarf.

- For very tough synthetic fabrics the needle should be strongly bent on the front needle guard.

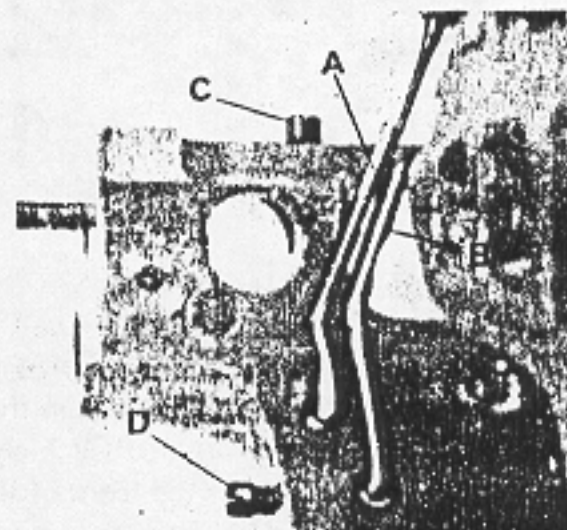
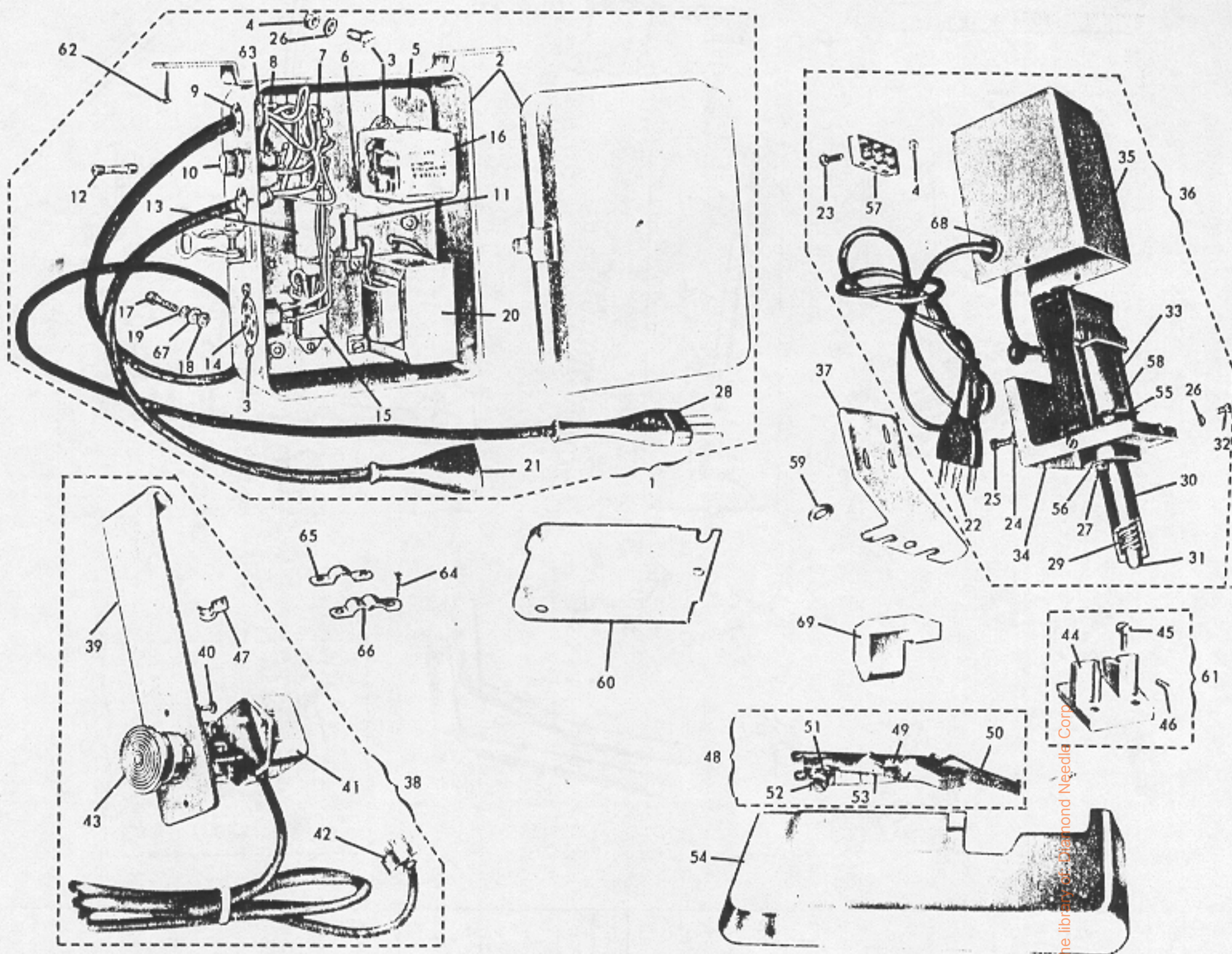


fig. 10

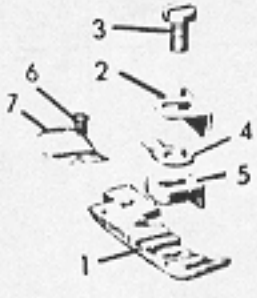
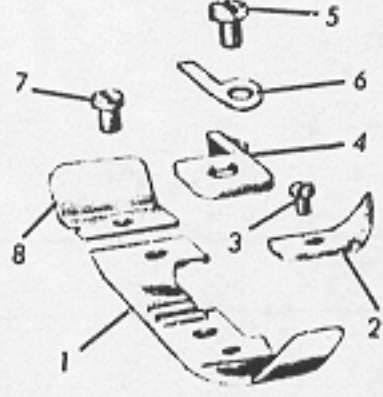
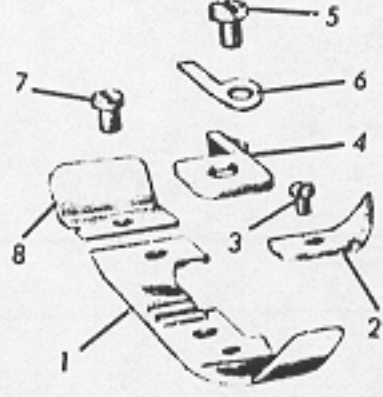
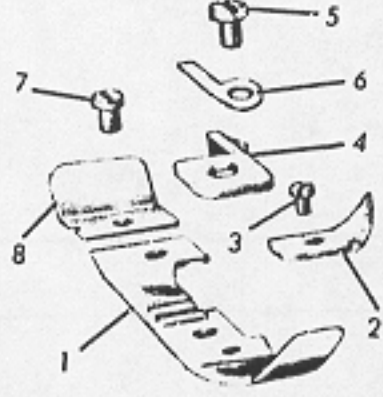
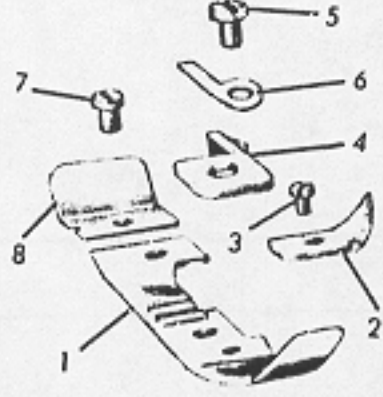
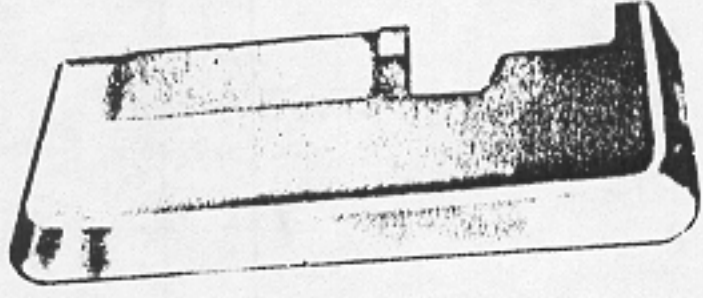
W.1 (100)
ELECTROMAGNETIC
CHAINSTITCH CUTTING DEVICE



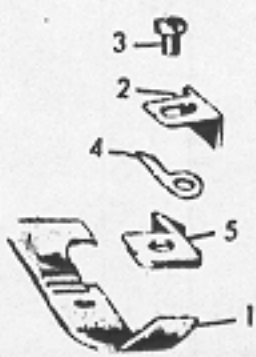
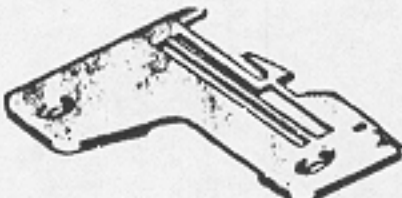
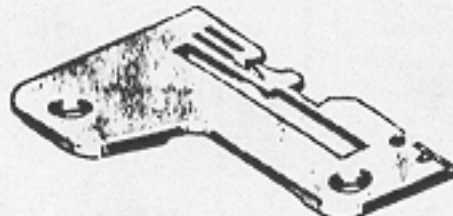
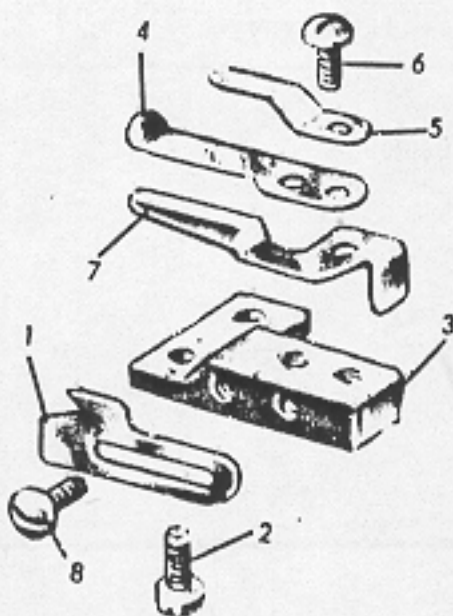
WARNING! : This device is built to operate at 220 V. If other voltages are used, install a special autotransformer Type SUT 1745.00 with cable and plug Type PM.T.11-127.

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	AS.270-W1-333	control box, complete	1	36	AS.270-W1-351	electromagnet, complete	1
2	G.270-W1-333	electric control box	1	37	270-W1-323	mounting plate	1
3	C.001-C-10	screw	11	38	G.270-W-3340	pushbutton switch, complete	1
4	057-B-3	nut	13	39	270-W-3300	pushbutton mounting plate	1
5	270-W1-373	panel	1	40	001-E-5	screw	4
6	270-W1-378	mounting base	1	41	270-W-3310	cover	1
7	T.11-22	ancorage	1	42	270-W-3700	4-contact flying docket	1
8	T.11-30	terminal, wire	1	43	270-W-3340	pushbutton	1
9	270-W1-3721	bush, cable	2	44	270-W-6400/3	guideblock, shoe	1
10	270-W1-363	fuse carrier	1	45	008-A-12	screw	1
11	T.11-16/3	resistance	1	46	270-716	screw	1
12	T.11-33/3	fuse	1	47	122-T-37	hook	2
13	T.11-21	electronic condenser	1	48	G.270-W-3220/1	lever assembly	1
14	270-W-3680	base, pushbutton switch	1	49	270-W-3220	lever, chainstitch cutting	1
15	T.11-14	rectifier	1	50	PM.270-W-0780/1	arm, presserfoot holder	1
16	270-W1-379	relay	1	51	270-W-3280	washer	1
17	C.001-E-30	screw	3	52	270-W-3250	screw, spring	1
18	053-D-4	nut	3	53	270-W-3240	spring, knife recall	1
19	063-L-4	washer	5	54	G.270-W1-210/3	workplate	1
20	T.11-13	transformer	1	55	270-W-3540	washer	4
21	270-W1-369	socket	1	56	533-710/1	washer	2
22	270-W1-372	plug with earth prong	2	57	122-T-215	terminal board	1
23	C.001-C-14	screw	2	58	001-E-8	screw	4
24	064-L-5	washer	3	59	055-C-6	washer	2
25	270-W-3550	screw	3	60	270-W-2470/1	guard, oil splash	1
26	270-W1-355	toothed washer	12	61	G.270-W-6400/3	guideblock, shoe	1
27	001-E-12	screw	2	62	TT. 20 x 25	wood screws	4
28	T. 11-126	plug with earth prong	1	63	270-W1-328	cap, cable securing	2
29	270-W1-246	spring	1	64	270-459	nail, hook attaching	30
30	270-W1-345	sleeve	1	65	545	fastener, cable	10
31	270-W1-349	plunger	1	66	547	twin fastener, cable	5
32	C.001-C-7	screw	3	67	T. 11-355	toothed washer	3
33	270-W1-351	electromagnet	1	68	270-W1-327	bush, cable	1
34	PM.270-W1-332	angle plate	1	69	270-253-TC.30	gasket, shoe guide	1
35	PM.270-W1-343	electromagnet housing	1	70			

PARTS FOR W1 (100) ELECTROMAGNETIC DEVICE

		Item	Drwg: N.	Description	Qty.	USED ON
	G. 270-W-181	1	270-184	shoe	1	227-00-01-100 227-00-07-100
		2	270-183	stop, presserfoot	1	
		3	270-989	screw	1	
		4	270-191	chaining finger	1	
		5	004-L-7	screw	1	
		6	270-196	lug, chaining plate	1	
		7	001-A-3,2	screw	1	
		8	270-W-185	chaining plate	1	
	G. 272-B2-W1-181	1	272-B2W1-184	shoe	1	227-00-05-100
		2	272-B-183	plate, stop	1	
		3	004-L-8	screw	1	
		4	270-196	lug, chaining plate	1	
		5	272-B-191	chaining finger	1	
		6	001-A-4	screw	1	
		7	275-W-185	chaining plate	1	
	G. 275-W-181	1	275-184	shoe	1	227-10-02-100 227-10-06-100
		2	275-183	stop, presserfoot	1	
		3	270-989	screw	1	
		4	275-191	chaining finger	1	
		5	004-L-7	screw	1	
		6	270-196	lug, chaining plate	1	
		7	001-A-3,2	screw	1	
		8	275-W-185	chaining plate	1	
	G. 27.21-CW-181/2	1	278-W-184/C 2	shoe	1	227-00-09-100
		2	270-183	stop, presserfoot	1	
		3	270-989	screw	1	
		4	2721-C-191/2	chaining finger	1	
		5	004-L-7	screw	1	
		6	270-196	lug, chaining plate	1	
		7	001-A-3,2	screw	1	
		8	270-W-185	chaining plate	1	
	G. 27.21-CCW-181	1	2721-CC-W-184	shoe	1	227-00-10-10
		2	270-183	stop, presserfoot	1	
		3	270-989	screw	1	
		4	2721-CC-191	chaining finger	1	
		5	004-L-7	screw	1	
		6	270-196	lug, chaining plate	1	
		7	001-A-3,2	screw	1	
		8	270-W-185	chaining plate	1	
	G. 27.54-W1-210/3	USED ON				
		227-10-06-100				

PARTS FOR X1 (101) DEVICE FOR FASTENING IN CHAIN

	G.270-X1-181	Item	Drwg. N.	Description	Qty.	USED ON		
		1	270-989	screw, stop mounting	1			
		2	270-183	stop, presserfoot	1			
		3	270-X1-191	chaining finger	1			
		4	004-L-7	screw, chaining finger securing	1	227-00-01-101		
		5	270-196	lug, chaining plate	1			
		6	270-184	shoe, presserfoot	1	227-00-07-101		
		7	001-A-3,2	screw, chaining plate mounting	1			
		8	270-185	chaining plate	1			
		N.B. - When type 227-00-01 is converted to 227-00-01-101 in the field, supply only chaining finger 270-X1-191 and not complete presserfoot.						
	G.272-B2X1-181	1	272-B2-184	shoe	1			
		2	272-B-183	plate, stop	1			
		3	004-L-8	screw	1			
		4	270-196	lug, chaining plate	1	227-00-05-101		
		5	272-BX-1-191	chaining finger	1			
		N.B. - When type 227-00-05 is converted to 227-00-05-101 in the field, supply only chaining finger 272-BX1-191 and not complete presserfoot						
			270-X1-1141	USED ON		2701-X1-1141	USED ON	
				227-00-01-101			227-00-07-101	
	272-BX1-114	USED ON						
		227-00-05-101						
	G.270-X1-4452	1	270-X1-4472	knife	1			
		2	001-B-6	screw	2			
		3	270-X1-4452	base, mounting	1			
		4	270-X1-4482	spring	1			
		5	270-X1-4302	plate	1	227-00-01-101		
		6	2701-PDB-4042	screw	1			
		7	270-X1-4462	cover plate	2			
		8	3647/B	screw	1	227-00-07-101		

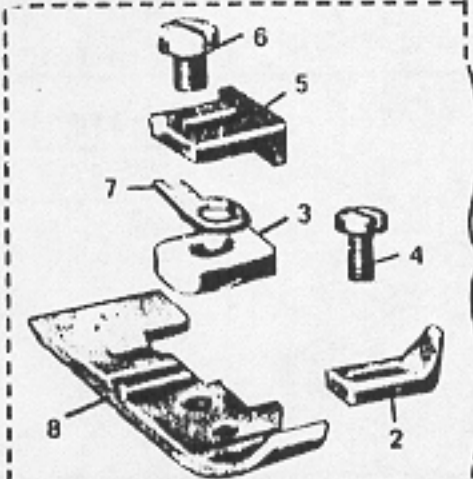
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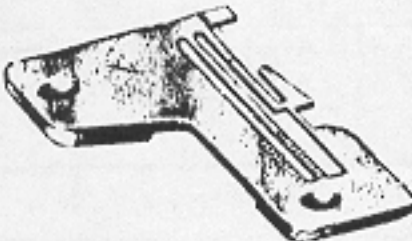
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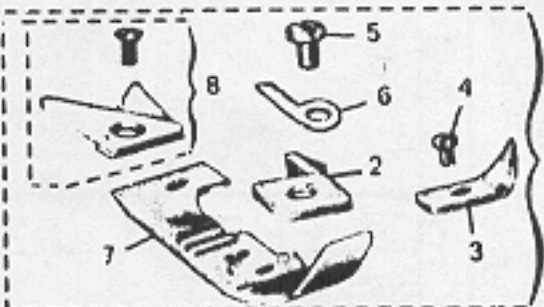
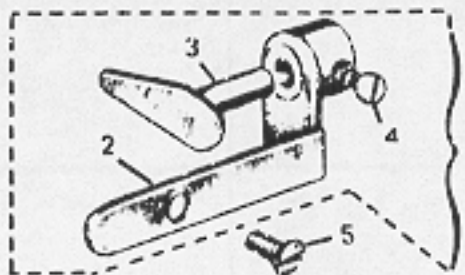
SECONDARY LOOPER, BLIND	27.221-C-074/1	SECONDARY LOOPER WITH EYE	27.277-0745	27.277-074	FIXED GUIDE & GUARD	270-401
	USED ON		USED ON			USED ON
	227-28-08		227-28-01 227-10-01 227-10-08 227-29-09	227-00-06 227-22-01 227-23-01 227-00-07 227-10-03 227-10-04	 001-D-7	227-00-07

PRIMARY LOOPER	270-075	270-075/2		FEED DOG, REAR	277-051	NEEDLE PLATE	PM.27.21-C-114
	USED ON		USED ON		USED ON		
	227-28-01 228-28-02	227-00-06 227-22-01 227-23-01 227-00-07 227-10-02 227-10-03 227-10-04 227-10-05	227-10-06 227-11-01 227-10-07 227-00-26 227-00-27 227-29-09 227-00-29		227-00-06		227-00-09

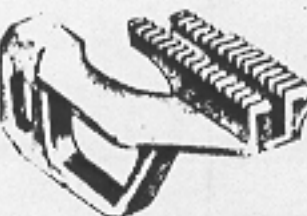
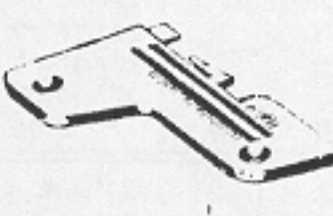
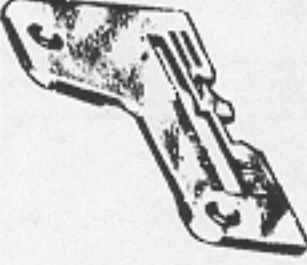
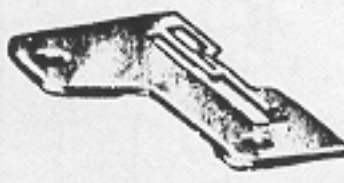
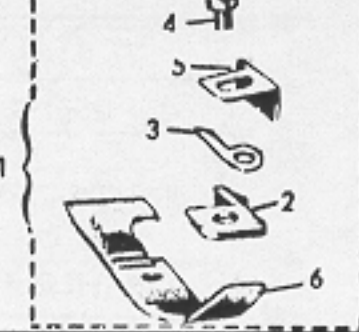
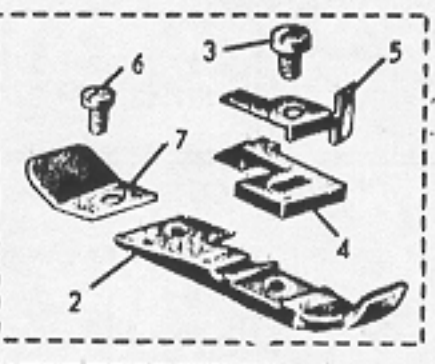
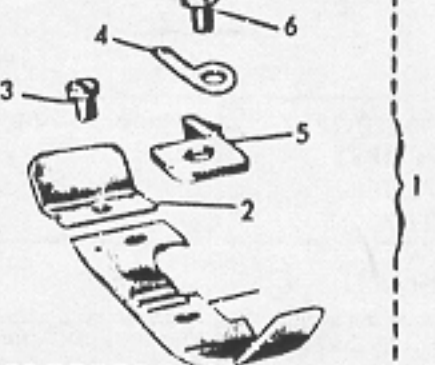
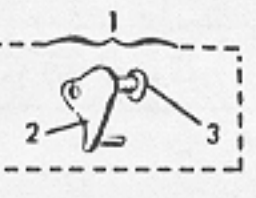
FEED DOG, FRONT	272-B-0501	PRESSERFOOT PRESSURE SPRING	272-092	KNIFE HONING BLOCK	272-BK-675	270-675/1
	USED ON		USED ON		USED ON	
	227-00-05 227-30-02		227-00-05 227-30-02 227-10-01 227-00-11		227-00-04	227-00-01

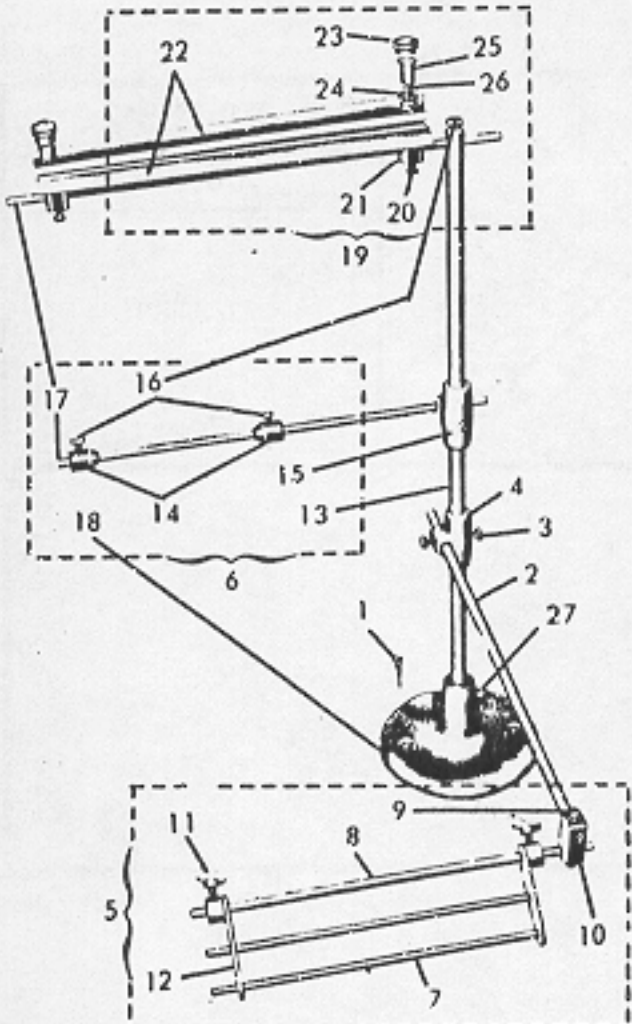
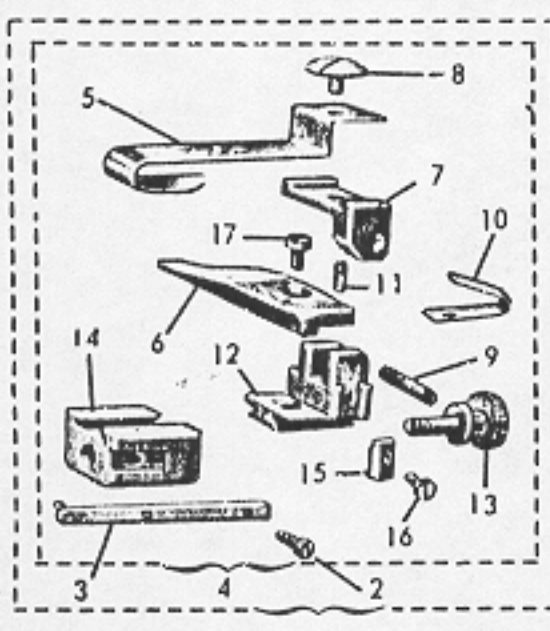
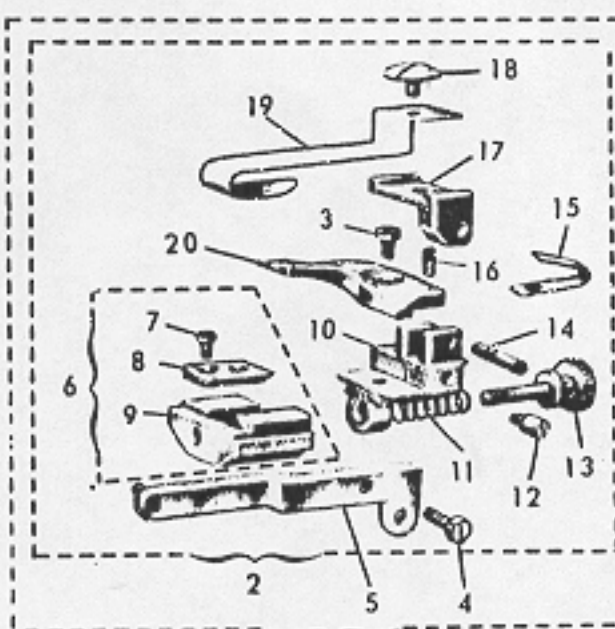
	1	G.2721-C-181	presserfoot, complete	USED ON
	2	270-183		
	3	2721-C-191	stop	227-00-09
	4	270-989	chaining finger	
	5	2700-1834	screw, stop securing	USED ON
	6	004-L-8	chaining plate	
	7	270-196	screw, chaining plate securing	227-00-09
	8	2721-C-184	lug, chaining plate	
	1	G.2721-C-181/1	shoe, presserfoot	USED ON
	2	270-183	presserfoot, complete	
	3	2721-C-191/1	stop, presserfoot	227-00-09
	4	270-989	chaining finger	
	5	2721-C-183/1	screw, stop mounting	USED ON
	6	004-L-8	chaining plate	
	7	270-196	screw, chaining plate	227-00-09
	8	2721-C-184/1	lug, chaining plate	
			shoe, presserfoot	

NEEDLE PLATE 	270-114	270-1142	270-1143	NEEDLE PLATE 	27.01-P-114
	USED ON				USED ON
	227-00-01	227-00-01	227-00-01		227-23-03
	27.01-1142	27.01-1143	275-1141		27.01-P-114/1
	USED ON				USED ON
	227-00-07	227-00-07	227-10-02 227-10-05 227-10-06 227-10-07 227-11-01		227-22-02 = 227-22-03 227-23-02 = 227-23-08

			GUIDE GUARD TO PREVENT CUTTING 			THREAD CUTTER . 			
1	G.270-1812	presserfoot, complete	1	G.274.401	guide complete	1	PM.270-1882	device, complete	
2	270-191	chaining finger	2	PM.274-417	guide, angle	1	270-1872	blade	
3	270-183	stop, presserfoot	3	PM.274-402	guide finger	1	270-1882	blade	
4	270-989	screw, stop securing	4	003-A-4,5	screw	1	4	028-A-3,5	screw
5	004-L-7	screw, chaining finger	5	001-D-7	screw	1	USED ON: 227-00-01 227-00-07		
6	270-196	lug					1 PM.275-1882 device, complete		
7	270-184	shoe					2 275-1872 blade		
8	PM.270-1882	thread cutter					3 270-1882 blade		
USED ON			USED ON			4 028-A-3,5 screw			
227-00-01			227-00-01 227-00-07			USED ON 227-10-02 = 227-10-05 = 227-10-06 = 227-11-01			

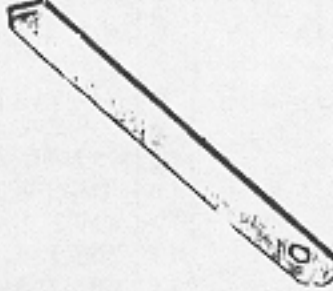
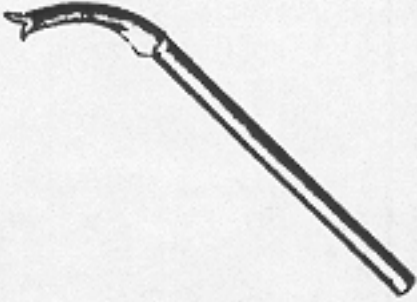
PARTS SUPPLIED ONLY ON REQUEST

CHAIN CUTTER 270-188 USED ON  001 A-4,3 227-00-01	PLATE 275-B-426 USED ON  001 C-5,5 227-10-03 227-10-04	REAR FEED DOG 272-051 272-B-0511 USED ON  227-00-11 227-00-05 227-30-02
FRONT FEED DOG 270-050 USED ON  227-00-11	FRONT FEED DOG 277-050 USED ON  227-00-06 227-10-02	NEEDLE PLATE 275-1141 USED ON  227-10-02 227-10-05 227-10-06 227-11-01 227-10-07
NEEDLE PLATE* 27.77-1142 USED ON  227-00-06	ORNAMENTAL CORD GUIDE PM.297-PDBO-4131 USED ON  227-23-01	PRESSERFOOT CHAINING FINGER 27.20-191/2  227-00-08
NEEDLE PLATE 272-BK-1141 USED ON  227-00-04	272-BK-114/1 272-B-114 272-B-114/1 USED ON 227-00-04 227-00-05 227-30-01 227-30-02 227-00-05 227-30-01 227-30-02	NEEDLE PLATE 278-114/1 USED ON  227-00-25
	1 G.2777-PDBO-1812 2 2777-PDBO-1911 3 2726-PDB-196/3 4 001-E-7 5 2777-PDBO-1831 6 2777-PDBO-1842 presserfoot complete chaining finger lug screw chaining plate shoe, presserfoot USED ON : 227-23-01	 297-PDB-4021 297-PDB-4031 USED ON 227-23-01 = 227-22-01 = 227-22-02 = 227-22-03 = 227-23-02 = 227-22-04 = 227-22-05 = 227-23-08
	1 G.272-181 2 272-184 3 004-L-7 4 272-191 5 272-196 6 001-A-3,2 7 275-185 presserfoot, complete shoe, presserfoot screw chaining finger lug screw chaining plate	USED ON 227-00-11
	1 G.2701-PD-181/1 2 270-185 3 001-A-3,2 4 270-196 5 270-191 6 004-L-7 7 2701-PD-184/1 presserfoot, complete chaining plate screw, chaining plate securing lug chaining finger screw shoe, presserfoot	USED ON 227-22-02 = 227-22-03 = 227-22-04 = 227-22-05
	1 G.2722-2624/1 2 PM.2722,2624/1 3 2722-2594 tension unit complete plate pulley	USED ON 227-28-08 = 227-00-08

AS. 272-MG.9371 	<table><tr><td>1</td><td>TS.20 x 30</td><td>wood screw</td></tr><tr><td>2</td><td>272-MG-4333</td><td>bar</td></tr><tr><td>3</td><td>605-980</td><td>screw, set</td></tr><tr><td>4</td><td>272-MG-937</td><td>bracket</td></tr><tr><td>5</td><td>G.272-MG-4192/3</td><td>feed control, lower</td></tr><tr><td>6</td><td>G.635-937</td><td>reel carrier</td></tr><tr><td>7</td><td>PM.272-MG-4302/3</td><td>frame-plate, with rod</td></tr><tr><td>8</td><td>272-MG-4212/3</td><td>rod</td></tr><tr><td>9</td><td>038-C-7</td><td>screw</td></tr><tr><td>10</td><td>272-MG-4242</td><td>block, coupling</td></tr><tr><td>11</td><td>PM.602-E-4364</td><td>wing nut</td></tr><tr><td>12</td><td>PM.272-MG-4342/3</td><td>plate, adjustable</td></tr><tr><td>13</td><td>605-143</td><td>upright</td></tr><tr><td>14</td><td>605-723</td><td>sleeve, tapered</td></tr><tr><td>15</td><td>605-937</td><td>bracket</td></tr><tr><td>16</td><td>605-980</td><td>screw, set</td></tr><tr><td>17</td><td>605-144-</td><td>rod</td></tr><tr><td>18</td><td>01141</td><td>base</td></tr><tr><td>19</td><td>G.272-MG-4412/2</td><td>metering device</td></tr><tr><td>20</td><td>039-C-10,5</td><td>screw</td></tr><tr><td>21</td><td>272-MG-4332</td><td>block, mouting</td></tr><tr><td>22</td><td>272-MG-4412/2</td><td>drag hinge</td></tr><tr><td>23</td><td>160-032</td><td>screw, adjustment</td></tr><tr><td>24</td><td>160-232/4</td><td>spring</td></tr><tr><td>25</td><td>1032/a</td><td>bushing</td></tr><tr><td>26</td><td>160-030</td><td>threaded pin</td></tr><tr><td>27</td><td>001-G-12</td><td>screw</td></tr></table>	1	TS.20 x 30	wood screw	2	272-MG-4333	bar	3	605-980	screw, set	4	272-MG-937	bracket	5	G.272-MG-4192/3	feed control, lower	6	G.635-937	reel carrier	7	PM.272-MG-4302/3	frame-plate, with rod	8	272-MG-4212/3	rod	9	038-C-7	screw	10	272-MG-4242	block, coupling	11	PM.602-E-4364	wing nut	12	PM.272-MG-4342/3	plate, adjustable	13	605-143	upright	14	605-723	sleeve, tapered	15	605-937	bracket	16	605-980	screw, set	17	605-144-	rod	18	01141	base	19	G.272-MG-4412/2	metering device	20	039-C-10,5	screw	21	272-MG-4332	block, mouting	22	272-MG-4412/2	drag hinge	23	160-032	screw, adjustment	24	160-232/4	spring	25	1032/a	bushing	26	160-030	threaded pin	27	001-G-12	screw	<table><tr><td>2</td><td></td></tr><tr><td>1</td><td></td></tr><tr><td>2</td><td></td></tr><tr><td>1</td><td></td></tr><tr><td>1</td><td></td></tr><tr><td>1</td><td></td></tr><tr><td>1</td><td></td></tr><tr><td>2</td><td></td></tr><tr><td>1</td><td></td></tr><tr><td>1</td><td></td></tr><tr><td>1</td><td></td></tr><tr><td>2</td><td></td></tr><tr><td>1</td><td></td></tr><tr><td>1</td><td></td></tr><tr><td>2</td><td></td></tr><tr><td>1</td><td></td></tr><tr><td>2</td><td></td></tr><tr><td>2</td><td></td></tr><tr><td>2</td><td></td></tr><tr><td>2</td><td></td></tr><tr><td>2</td><td></td></tr><tr><td>1</td><td></td></tr></table>	2		1		2		1		1		1		1		2		1		1		1		2		1		1		2		1		2		2		2		2		2		1	
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21	272-MG-4332	block, mouting																																																																																																																													
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PARTS SUPPLIED ONLY ON REQUEST

	270-112/2 USED ON 227.00-01		270-113/2 USED ON 227.00-01
	270-D.074/1 USED ON 227.00-01		

From the library of: Diamond Needle Corp

GENERAL LIST OF PARTS

DRWG. N.	SHEET	DRWG. N.	SHEET	DRWG. N.	SHEET	DRWG. N.	SHEET
RIM 27	5-13	005-L 11	3-11-22-23	059-P 8	11-22-23-29	01141	74
001-A 2,5	68		29-30-31-33		30-31-33-34	PM. 1159	11
001-A 3,2	7-14-15-16		34-35-36-37		35-36-37-47	01160/2	13
	17-18-19-20	005-M 10	8	063-L 4	69	1161/2	13
	24-26-27-28	007-C 11	3-5-6	063-N 4	47	01161/2	13
	29-30-31-32	007-F 14	8	064-D 5	22-23-29-30	1175	13
	33-34-35-36	007-H 25	8		31-33-34-35	01205 a	8
	37-45-47	007-M 15	10		36-37	3647 b	71
	49-50-51-55	007-P 10	6	064-E 5	11	3707	64
	57-58-59-60	007-R 7,5	8	064-F 5	3	3710	64
	61-70-71-73	008-A 12	69	064-L 5	69	4030-06	3
001 A 4	70	010-D 11,5	2	065-C 6	69	122-T 37	69
001-A 5,5	14-15-56	010-H 13,7	2	065-D 6	3	122 T. 215	69
001-B 6	71	011-E 13	14-15-19	065-L 6	10-11-22-23	128-110	21-22-23-39
001-C 4	49 50	012-H 5	47		29-30-31-33		40-41-64 65
001-C 5,5	17-18-20-24	016-A 2,5	5-21		34-35-36-37		66
	28-32	016-B 2,5	4-5-9-10	067-H 10	11	128-111	6
C.001-C 7	69	016-B 3	4	070-B 3	3	160-030	22-23-29-30
C 001-C 10	68	016-B 4	4	070-F 4	3-6-22-23		31-33-34-35
C 001-C 14	69	016-D 5	2		29-30-31-33		36-37-40-54
001-D 4,5	8	016-F 5	12		34-35-36-37		74
001-D 6	8-23-34-46	016-F 6,5	12	070-M 4,5	3	160-032	22-23-29-30
	47-74	016-F 7	50	071-D 5	6-42		31-33-34-35
001-D 7	18-22-29-30	016-F 10	41	071-E 5	5		36-37-40-54
	31-34-35-36	017-E 4,5	8	071-H 5	3		74
	37-38-41-43	017-E 7	18-19-23-31	071-M 5,5	3	160-232/4	40-44-74
	-45-47-51		35	073-A 8	3	240-035	22-23-29-30
	53 56-60-64	017-E 11,5	3	073-C 8	3		31-33-34-35
	66-72	017-F 11	4	073-F 9	5-6		36-37-64
001-D 10	8	017-H 12	10	073-N 10	4	250-031	64
001-E 5	69	023-E 14	3	074-A 12	2	250-130	12
001-E 6	18-22-23-29	023-N 5,5	2-3-5	092-A 10	21	PM. 250-133/1	12
	30-31-33-34	026-C 7	3-8	092-B 1	3-4-5	250-137	12
	35-36-37	026-E 10	8	092-C 2	2-4-6-7	G. 250-137	12
001-E 7	5-23-31-35	026-G 10	42	092-D 4	3	250-140	12
	36-37-73	028-A 3,5	72	092-D 5	5-6	AS. 250-140	12
001-E 8	23-69	028-B 5	6-22-23-29	092-D 6	3-5	250-143	12
001-E 10	2		30-31-33-34	092-D 7	4	PM 250-148/1	12
001-E 12	69		35-36-37	092-D 9	6	250-471	3-4-6
C 001-E 30	69	028-B 8	55-56-57-58	092-A 10	5	250-708/1	5
001-G 10	5-11-12-47		59-60-61	092-D 11	3-5-7	250-980	49-50
	64	028-E 10	8-10	092-D 12	3	G. 250-R-9373	28
001-C 12	12-16-17-20	032-A 6	9-67	092-D 14	2	255-404	14-15-19
	23-27-28-32	032-F 6,5	14-15-19	092-D 16	4	G. 250-R-9373	16-17-20-24
	40-54-74	032-F 9,5	8	092-D 23	3		27-32
002-C 8	38	032-L 10,5	7	RG 0 1x22	44	255-404	49
003-A 4,5	5-21-41-	036-C 7	9	RG. 0 2,5x4	44	255-415	49-50
	72	038-C 7	22-23-29-30	T 11-13	69	PM. 255-434	49-50
003-L 12	6		31-33-34-35	T 11-14	69	270-001/2	10
003-M 7	14-42-64-65		36-37-40-42	T 11-16/3	69	G. 270-001/2	10
004-A 2,5	53-56-60		54 74	T 11-21	69	270-002/1	1
004-A 3,2	9-47-76	038-M 9	11-22-23-29	T 11-22	69	G. 270-002/1	1
004-A 5	6-9		30-31-33-34	T 11-30	69	270-004	11
004-E 7	2		35-36-37-47	T 11-33/3	69	G. 270-005/3	11
004-F 3	40	039-C 10,5	40-54-74	T 11-126	69	PM. 270 005/3	11
004-G 3	24	039-D 6	47	T 11-355	69	270-006/1	5
004-H 5	38	039-G 10	10	TS 18x20	41	270-007/1	5
004-L 6	9-22-23-29	039-H 9	3	TS 20x30	12-16-17-18	270-008/1	2
	30-31-33-34	039-R 8,5	14-15-18-19		19-20-23-24	270-009/4	2
	35-36-37		22-29-30-31		27-28-32-35	PM. 270-009/4	2
004-L 7	3-7-14-15		33-34-35-36	TS 22x35	40-41-54-74	270-010/2	2
	16-17-19-27	051-L 10	37-49		11-22-23-29	270-016	1
	29-30-31-33	053-D 4	11		30-31-33-34	270-020/1	5
	34-35-36-37		22-23-29-30	TT 20x25	35-36-37-47	G. 270-025/2	5
	38-40-41-42		31-33-34-35	VR.604	69	270-030/1	8
	45-46-47-49	053-H 8	36-37-47-69	490-2	13	270-030/2	8
	50-51-52-53	054-D 4	12	G 497	12	270-031/1	3-5
	54-55-56-57	057-A 3	8-54	546	12	270-032/3	3
	58-59-60-61		10-17-24-28	547	69	270-033/1	3
	62-63-64-65		32	559	69	270-034	3
	67-70-71-72	057-B 3	47-69		12	270-035	3
	73	057-E 4	8-14-15-19	1032 a	22-23-29-30	270-036/1	3
004-L 8	17-20-21-28		42		31-33-34-35	270-037/3	3
	32-39-44-	057-F 4	3		36-37-40-54	270-038/3	3
	66-68-70-71	057-P 5	22-23-29-30		74	PM 270-038/3	3
	72-75		31-33-34-35	01141	12-16-17-20	270-039	3
004-L 9	22-24		36-37		23-27-28-32	270-040	3
004-N 5,5	9	057-R 5	64		40-54	270-041/1	3
004-P 6	3	058-M 10	11	01142	12	270-042/3	1
004-R 5	74	059-A 5	11	1145	12	270-044/2	1
005-D 5	74	059-G 6	10	1146	12	PM. 270-045/2	3
005-G 6	11-22-23-29	059-H 6	11	1156/1	13	270-046/3	3
	30-31-33-34			1158	13	270-047/2	3
	35-36-37						

		DRWG N.	SHEET	DRWG N.	SHEET	DRWG N.	SHEET
270-048	3	270-130	5	270-248/1	8	270-571	11-22-23-29
PM 270-049/1	3	270-131	5	270-249/1	3		30-31-33-34
270-050	3	270-132/1	5	270-250/2	3		35-36-37-47
270-B.050	41	270-133/1	5	270-253-TC 30	69	270-572	11-22-23-29
270-H.050	19	270-135	5	270-253	3		30-31-33-34
270-051	3	PM 270-137/1	4	270-255	9		35-36-37-42
270-H.051	19	PM 270-138/1	5	270-258	9	270-573	11-22-23-31
270-052	3	AS 270-140	12	270-259	9		33-34-35-36
270-053	4	270-155	13	270-261/1	9		37-47
270-054	3	270-157	12	G 270-262/2	9	270-574	11-22-23-31
270-056/2	4	G 270-157	12	G 270-262/3	39-30-62-63		33-34-35-36
270-057/1	1	270-158/1	12	PM 270-262/2	9		37-42-47
270-058/1	1	270-170	9	270-263	64	270-575	11-22-23-29
270-059/1	2	270-174	8	PM 270-263/1	9		30-31-33-34
PM 270-059/1	2	270-175	8	270-264	1-9		35-36-37-47
270-060/1	2	G 270-181	7	270-265	9	270-576	11-22-23-29
PM 270-060/1	2	G 270-E.181	16-27	270-265/1	9		30-31-33-34
270-061/2	2	G 270-EF 181	17-28	270-266	9		35-36-37
270-062	2	G 270-H 181	19	270-R 267	17-28-31	270-577	11-22-23-29
270-063/2	4	G 270-R 181	20-32	PM 270-R 267	17-20-28-31		30-31-33-34
270-065/3	4	270-183	7-16-26-27	270-268	1-9		35-36-37
G 270-065/3	4		52-53-62-64	270-269/1	9	270-578	11-22-23-29
270-066/2	8		65-66-70-71	270-269/2	71		30-31-33-34
270-067	4	270-184	72-75	270-270	64		35-36-37
270-068/3	4		7-16-26-70	270-270/1	9	270-579	11-22-23-29
270-069	4		71-72	270-270/2	71		30-31-33-34
270-070	4	270-EF 184	17-28	270-271	9		35-36-37-47
270-EF 071	17-28	270-H 184	19	270-272	9	270-580	11-22-23-29
270-R 071	20-32	270-R.184	20-27-32	270-274	64		30-31-33-34
270-073	7	270-185	7-14-15-16	270-274/3	9		35-36-37
270-074	39-40-62-63		17-18-19-20	270-274/4	71	270-581	11-22-23-31
	64-66-67		26-27-28-29	270-275/1	9		33-34-35-36
270-D.074/1	14-15-45		30-31-32-33	270-276/1	9		37
	46-47-49-50		34-35-36-37	270-287/1	3	270-582	11-22-23-29
	51		71-73	270-288/1	3		30-31-33-34
270-075/2	4	270-W.185	70	PM 270-301	8		35-36-37-42
270-076/2	7	270-191	7-14-15-18	270-303	8		47
G 270-076/2	7		20-29-30-31	270-W1 323	69	270-583	11
PM 270.076/2	7		32-33-35-36	270-W1 327	69	G 270-583	11
270-077	7		37-70-72-73	270-W1 328	69	270-584	11
270-078	8-22-23-29	270-E.191	16-27-38	PM 270-W1 332	69	270-585	11
	30-31-33-34	270-EF.191	17-28	AS 270-W1 333	69	270-586/1	11
	35-36-37	270-H 191	19	G 270-W1 333	69	270-588	11
270-081/1	7	270-X1.191	71	PM 270-W1 343	69	270-589/1	11
PM 270-081/1	7	270-196	7-14-15-16	270-W1 345	69	270-590/1	11
270-082/1	1		17-18-19-20	270-W1 346	69	270-590/2	11
270-083	7		21-26-27-28	270-W1 349	69	270-595	3
270-085/1	7		29-30-31-32	270-W1 351	69	270-608/5	2
PM 270.085/1	7		33-34-35-36	AS 270-W1.351	69	270-610	2
270-086	8		37-38-39-40	270-W1 355	69	270-611/1	3
270-087/1	7		41-42-44	270-W1 363	69	270-612/1	2
270-089/1	7		45-49-50-51	270-W1 369	69	270-613	2
270-090/1	8		52-53-54-55	270-W1 372	69	270-614	2
G 270-090/1	8		56-57-58-59	270-W1 373	69	270-617/2	2
270-091	7		60-61-62-63	270-W1 378	69	270-619	8
270-092	8		64-65-66-67	270-W1 379	69	270-620	2
270-093/1	8		70-71-72-73	G 270-F 401	18	270-623/1	8
270-094	8-22-23-29		75	270-F.402	18	270-624	8
	30-31-33-34	PM 270-205/3	8	PM 270-F.413	18	270-640/3	3
	35-36-37	PM 270-208/3	8	AS 270-H 413	19	270-642	1
PM 270-095/3	8	G 270-W1.210/3	69	G 270-H 413	19	270-645	10
270-096/1	6	PM 270-210/3	8	270-459	11-69	270-650	10
270-097/1	1	270-212	8	270-PDB 517	22	270-651	10
270-098	6	270-214	8	270-552	11	270-652	10
270-099	6	G 270-216/2	8	270-553	11	G 270-646	10
270-100	6	PM 270-217/2	8	270-554	11	PM 270-646/1	10
270-101	6	PM 270-218/2	8	G 270-556	11-22-23-29	270-701	7-8-11-29
270-102	6	270-220	8		30-31-33-34		30-31-32-34
270-103	6	270-221	8		35-36-37		35-36-37-40
270-104	6	270-226	8	270 556/1	11		54-64
PM 270-104/1	6	270-230	9	270-557	11	270-702	3-22-23-29
270-105	6	270-231	8	270-558	11		30-31-33-34
270-106	6	270-232/1	40-41-71	PM 270-562/2	3		35-36-37
270-107/1	7	270-232/2	9-39	270-566/1	3	270-703	3
270-108/1	6	270-233	9	270-567	3	270-704	2
270-109/1	7	270-234/1	9	270-568	3	270-705	2
270-110	8	270-235/1	9	270-570	11-22-23-29	270-707	2
270-112	6-13	270-241/2	8		30-31-35-36	270-708	5
270-113/1	6-13	G 270-242/3	8		37	270-709	2
270-H.114	19	PM 270-245/3	8	G 270-570	11-22-23-29	270-713	5
270-116/2	2	270-246	8		30-31-33-34	270-714	7
270-129/1	8	270-247/1	8		35-36-37	270-715	8

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DRWG N.	SHEET	DRWG N.	SHEET	DRWG N.	SHEET	DRWG N.	SHEET
270-716	69	270-997	3	272-BK. 976	42	275-B. 418	74
270-717	3	270-998	11-22-23-29	272-BK. 986	41	275-425	45-51
270-718	8		30-31-33-34	272-BK. 987	67-68	275-B. 425	74
270-719	5-6		35-36-37-47	272-BK. 994	42	275-426	45-49-50-51
270-720	11-22-23-29	270-999	2	272-BK. 1051	42	275-B. 430	47-74
	30-31-33-34	270-0751	40-41-62-63	272-B. 1141	39-40-41	PM. 275BS. 1482	47
	35-36-37-47		66-67	272-BMG 1840	40	275-1872	74
270-722	2	PM 270-W 0760.1	69	272-1911	40	PM. 275-1882	74
270-732/3	3	270-1141	7	272-BMG. 1990	40	G. 275-3792	49
270-728	5	270-1142	14-15	PM 272 BMG 1990	40	275-BS. 4062	47-74
270-730/2	8	G. 270-1812	72	G. 272-MG. 4192	40-54	275-BS. 4082	47-74
270-731/1	8	270-1472	72	G. 272-MG. 4192/3	73	PM. 275 BS 4082	47-74
PM 270-732/3	3	270-1882	72	272-MG. 4212	40-54	AS. 275 BS 4131/1	74
270-733/1	3-67	PM 270-1882	72	272-MG. 4212/3	74	AS. 275-BS. 4132	47
270-734	3	270-W 2470.1	69	272-MG. 4242	40-54-74	G. 275-BS. 4132	47
270-734/1	10	270 W 3220	69	PM 272-MG. 4302	40-54	G. 275 BS 4132/1	74
270-735	3	G. 270 W 3220/1	69	PM 272 MG 4302/3	74	275-BS. 4142	47-74
270-736/2	3	270-W. 3240	69	272-MG. 4332	40-54-74	275-BS. 4152	47-74
PM 270-736/2	3	270-W. 3250	69	272-MG. 4333	40-54-74	PM. 275-BS. 4172	47-74
270-737	3	270-W1. 3271	69	PM. 272-MG. 4342	40-54	275-BS. 4252	47-74
270-738	3	270 W. 3280	69	PM 272 MG 4342/3	74	275-BS. 5992	47
270-739	3	270-W. 3300	69	272-MG. 4412	40-54	275-BS. 6002	47
270-741	13	270-W. 3310	69	272-MG. 4412/2	74	275-BS. 6012	47
270-743	13	270-W. 3340	69	G. 272-MG. 4412	40-54	G. 275 BS. 6012	47
270-747	3-67	G. 270-W 3340	69	G. 272 MG 4412/2	74	275. BS. 6032	47
270-808	10	270-W. 3540	69			275-BS. 6052	47
270-810/2	10	270-W. 3550	69	G. 274-401	72	275-BS. 6062	47
270-811/1	10	270-W. 3680	69	PM 274-402	72	275-BS. 6412	47-74
270-816/1	10	270-W. 3700	69	G. 274-417	72	276-B. 112	21
G. 270-816/1	10	270 X1. 4452	71	PM. 274-417	41-	276-B. 184	14-15
PM 270-816/1	10	270 X1-4462	71	G. 274-B1. 1811	14-15	PM 276-B. 403	14-15
270-823/1	10	270 X1-4472	71	274-B1. 1921	14-15	AS. 276 B. 403/1	14-15
270-824/1	10	270 X1-4482	71	275-050	45-49-50-51	G. 276 B. 403/1	14-15-19
270-827/1	10	270 X1-4502	71	275-B. 050	46-47	276-B. 407/1	14-15-19
270-828/1	10	270-W. 6400/3	69	275-051	45-46-47-49	276-B. 412	14-15-19
270-831/1	10	G. 270 W 6400/3	69		50-51	276-B. 417/1	14-15-19
270-836	10	270-8251	10	275-114	45-49-50-51	277-052	21
270-877	6	272-B. 050	39-40	275-B. 114	46-47	277-113	21
270-912	1	272-051	59-60-	G. 275-181	45-49-50	G. 277-181	21
270-913	8	272-B. 051	39-40-41	G. 275-B. 181	47	G. 277-R. 181	24
270-927	3	272-B. 052	39-40-41-68	275-183	45-47-49-50	277-183	21
270-928	3-67	272-BK. 104	42		51-70	277-184	21
270-929	3-67	G. 272-BK. 104	42	275-B. 183	46-47	277-R. 184	24
270-933	5	272-B. 107	38	275-184	45-49-50-51	277-185	24
270-934/2	7	272-BK. 107	42		70	277-191	21-22-24
270-935	3	PM. 272-BK. 110	42	275-B. 184	46-47	277-0501	21
270-936/2	7	PM. 272-15. 114	66	275-185	45-47-49-	277-0511	21
270-937/1	3	G. 272-181	73		51-56-56-57	278-052	52-53-54
270-938	2	G. 272-B2. 181	39		58-59-60-61	278-114	52-53-54
270-940	8	G. 272-BK. 181	42		73	G. 278-181	52-53
270-941	9	272-B. 183	39-44-70-71	275-W. 185	70	278-184	53
270-943	3-44	272-184	73	275-191	45-49-51-70	278-184/C2	64
270-946	10	272-B2. 184	39-71	275-B. 191	46-47	278-W184-C2	70
270-947	10	272-B2-W1-184	70	275-B. 196	46-47	278-191	52-53-54
270-965/2	8	272-BK. 184	42	G. 275 B. 210/3	46-47	G. 278 MG-1811	54
270-966/1	10	272-B. 185	40	275-403	45-49-50-51	278-MG. 1841	54
270-971	11	272-186	39-41	275-B. 403	47-74	279-050	52-53-54-55
270-972	8	272-191	73	275-404	45-47-49-50		56-57-58-61
270-973	8	272-B. 191	39-44-70		51-74	279-051	52-53-54-55
270-974/1	4-44	272-BX1. 191	71	275-B. 406	74		56-57-58-61
270-975	2-3-5	272-1C. 191/1	66	275-407	45-51		62-63-65
270-975/1	5	272-196	73	275-B. 407	47	279-099	55-56-57-58
270-977	3	272-NG. 197	40-54	PM. 275-407	46-52		59-60-61
270-978	3	272-NG. 199	54	275-B. 407/B	74	279-112	16-17-27-28
270-979	3	PM. 272. NG. 199	54	275-408	45-49-50-51		45-52-53-54
270-980	3	G. 272-BK. 216/2	42	275-B. 408	74		56-56-57-58
270-981	2	272-232/1	9	PM. 275-408	46-49-50-51		59-60
270-983	8	272-B. 270	39-40-62-63	275-409	45-49-50-51	279-113/1	55-56-57-58
270-984	3		66-67	275-B. 409	47-74		59-60-61
270-985	7	272-B. 272	39-40-41-62	275-410	45-49-50-51	279-114	55-56-57-58
270-987	6		66-67	275-B. 410	47-74		59-60
270-989	7-16-26-27	G. 272-G. 401	53-56-60	275-411	45-49-50-51	G. 279-181	55-56-59-60
	45-46-47-49	PM. 272-G. 417	54-57-60	275-B. 411	47	PM. 279-183	55-56-57-59
	50-51-52-53	272-BK. 573	42	275-B. 411/1	74		60
	62-63-64-65	AS. 272-BK. 903	42	AS. 275-413	45-51	279-184	55-56-57-58
	66-70-71-72	G. 272-BK. 903	42	AS. 275-B. 413	46		65-60-61
	75	PM. 272-BK. 903	42	AS. 275-B. 413/1	74	279-191	55-56-59-60
270-992	3	272-BK. 905	42	G. 275-B. 413/1	74	G. 279-216/2	35-56-57-58
270-993	8	272-BK. 906	42	275-415	45-51		69-60
270-995	8	272-BK. 907	42	275-416	51	279-987	55-56-57-59
270-996/2	10	272-MG. 937	40-54-74	PM. 275-417	45-51		60-61
G. 270-996/2	10	AS. 272-MG. 937	40-54	PM. 275-B. 417	46-74	G. 27.00B009/3	21

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7. Mounting lower trimmer knife (fig. 11)

- Mount guide block P on knife-holder with screw Q.
 - Slide knife D into place.
 - The cutting edge of the trimmer knife must be flush with the rear needle guard.
 - Tighten up screw A.
 - With the needle in its lowest position, bring angle stop O close to the needle guard, lock bushing L and washer G by tightening up screw F.
 - Check that knife holder C moves smoothly and adjust setting for required bight.
 - Slightly tighten screw N.
 - With needle in its lowest position, bring guide block P close up to front needle guard and lock it by tightening up screw Q.
- After setting upper trimmer knife touching lower trimmer knife, slacken screw N. The proper pressure is applied between the knives by spring M and pin H.
- Press one finger lightly against screw A and tighten up screw N firmly.
 - Pressure should be lightly exerted to avoid generating strong friction between the two knives resulting in their hardening.

Note: The following sub-classes: 227-00-09 – 227-00-07 227-22-04 – 227-00-03 – 227-28-08 and types derived there from are not equipped with guide block P and angle block O.

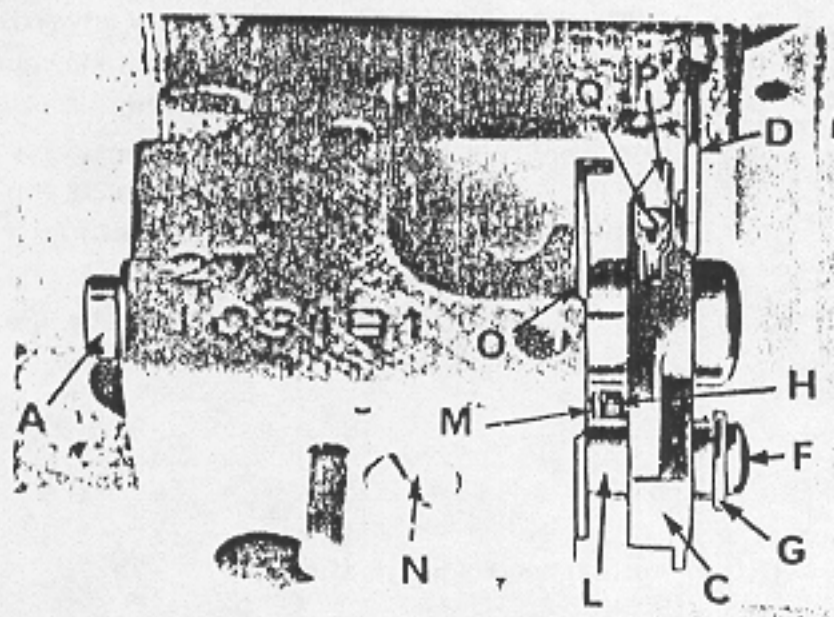


fig.11

8. Mounting and setting Feed Dogs (figures 12 and 13)

- Remove Plexiglass plate beneath work plate.
- Mount rear feed dogs C and D (fig. 12) and match the feed dog slides.
- With a small screwdriver pushed through the threaded holes on the levers, tighten screw F slightly, inserting the screwdriver into the groove on the tip of the screw.
- Mount the front differential feed dog E with screw G but do not tighten it up fully (fig. 13).
- Slacken screw A.
- Adjust feed dog angle by rotating eccentric B.

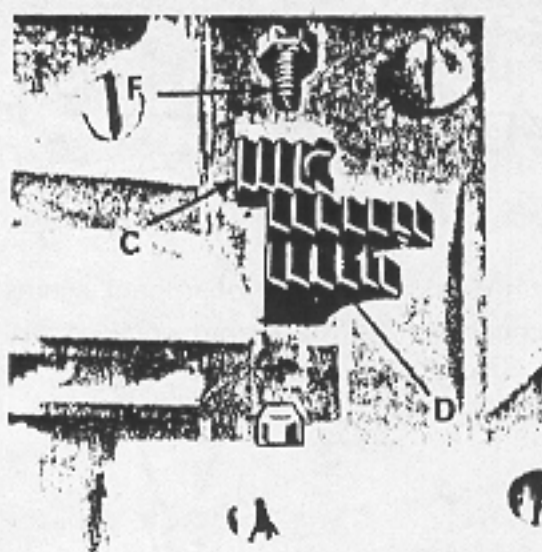


fig.12

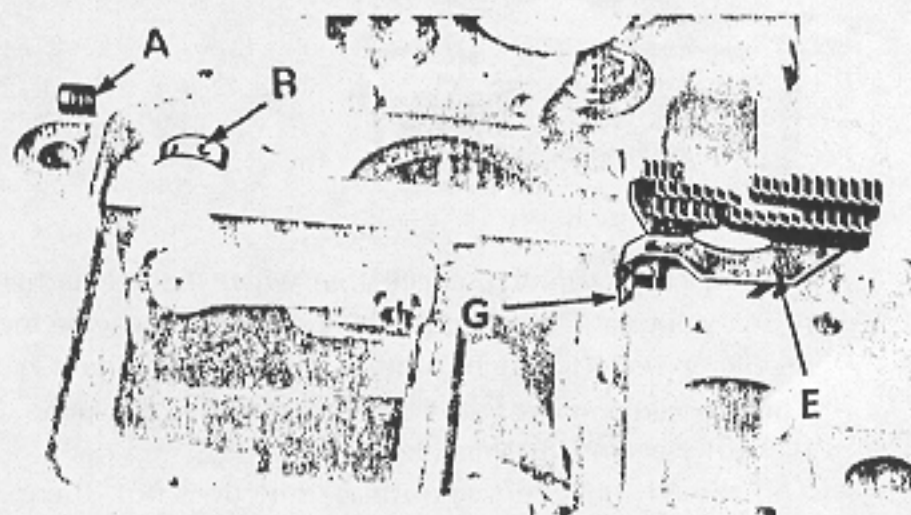


fig.13

- The feed dog teeth visible through the needle plate should be absolutely flush with the latter.
- When the feed dogs are at their highest position, there should be a clearance of 1,3 mm. between the teeth and the needle plate at the front of the differential feed dog.
- Feed dog C should be lower than the other three.
- Lock screws F, G, and A.

DRWG N.	SHEET	DRWG N.	SHEET	DRWG N.	SHEET	DRWG N.	SHEET
27.00-1834	72-75	27.21-C.050	62-63-65	27.32-B.071	44	290-025/1	5-21
27.01-P.050	29-30-31-35	PM.2721 C.050	64-66	27.32-B.072	44	290-027/1	5
	36-37	PM.2721 C.051	64-66	27.32-B.107	44	290-923	8
27.01-P.051	29-30-31-35	G2721 C2067/3	39-40-41-62	G.27.32-B2.181	44	290-944	3
	36-37-38		63-64-65-66	27.32-B2.184	44	297-PDB.401	22-23-29-30
27.01-P.092	21-38		67	27.32-B.916	44		31-33-34-35
27.01-P9.113/1	30-34-37-	PM2721 C.114/1	64				36-37
	52-53-54	27.21-E.114	63			G.297PDB.401	22-23-29-30
G.27.01-A.114	26	G.2721-C.181	72-75				31-33-34
27.01-P.114	29-30-31-38	G.2721-CC.181	62-65			297-PDB.402	22-23-29-30
27.01-P9.114	34	G.2721-C181/1	66-72-75				31-33-34-35
G.27.01 A.181	26	G.2721-C181/2	64				36-37
G.27.01-PD.181	18-29-30-33	G.2721-E.181	63			297-PDB.403	22-23-29-30
	36	2721-C.183/1	66-72-75				31-33-34-35
G.27.01-PD181/1	73	27.21-E.183	63				36-37
G.27.01-PD9.181	34-37	27.21-C.184	62-65-72-75	PM.27.53-210/3	51	PM.297PDB-406	22-23-29-30
G.27.01-PDBO181	31-35	2721-CC-W.184	70	27.53-2201	19-49-50		31-34-35-36
27.01-P.184	38	2721-C.184/1	66-72-75	27.53-2211	18-49-50		37
27.01-PD.184	18-29-30-33	27.21-E.184	63	27.53-2221	50	297-PDB.407	22-23-31-33
	36	27.21-C.191	72-75	27.53-2231	49-50		34-35-36-37
27.01-PD.184/1	73	27.21-CC.191	41-62-65-70	27.53-3792	50	297-PDB.408	22-23-29-30
27.01-PD9.184	34-37	27.21-C.191/1	72-75	27.53-4011	49-50		31-33-34-35
27.01-PDBO.184	31-35	27.21-C.191/2	64-70	27.53-4071	19-49-50		36-37
27.01-P.185	38	27.21-E.191	63	PM.27.53-4081	49-50	PM.297PDBO413	23-31-35
27.01-A.191	26	27.21-C.220	64-66	27.53-4121	49-50	PM.297PDB417/1	23
27.01-P9.191	34	27.21-C.232	64	AS.27.53-4132	49-50	297-PDB.418	22-23-29-30
27.01-P.401	38	2721-C2.617	39-40-62-63	27.53-4172	49-50		31-33-34-35
27.01 P.403/1	21-38-39-40		64-65-66-67	27.53-4181	18-49-50		36-37
	41	AS.2721-C.700	64	27.53-4251	18-49-50	297-PDB.441	22-23-29-30
27.01-P.404	38	G.27.21-C.700	64	27.53-4261	18-49-50		31-33-34-35
PM.2701 PD417/1	18-22-29-30	27.21-C.702	64	G.27.54-E.181	50		36-37
	31-33-34-35	G.27.21-C.703	64	G.27.54-E.191	50	297-PDB.442	22-23-29-30
	36-37	G.27.21-C.704	64	G.27.54-210/3	49-50		31-33-34-35
27.01-PD.444	18	PM.2721-C.704	64	27.77-020	21		36-37
27.01-PDB.516	22-23-29-30	27.21-C.708	64	G.27.77-025/2	21	297-PDB.443	22-23-29-30
	31-33-34-35	PM.2721-C.708	64	27.77-PDB.050	22-23		31-33-34-35
	36-37	27.21-C.709	64	27.77-PDB.051	22-23		36-37
27.01-PDB.517	23-29-30-31	27.21-C.983	64	27.77-107/1	21	297-PDB.444	22-23-29-30
	33-34-35-36	27.21-1141	62	27.77-109/1	21		31-33-34-35
	37	27.21-1143	65	27.77-183	22-24		36-37
27.01-PDB.518	22-23-29-30	G.2721 OG.1414	41	27.77-PDB.184	22	G.297PDB515	22-23-29-30
	31-33-34-35	27.21-OG.1434	41	27.77-196	22-24		31-33-34-35
	36-37	27.21-OG.1844	41	27.77-227	6		36-37
27.01-PDB.519	22-23-29-30	G.2721-OG.1814	41	27.77-228	6	PM297PDB.515	22-23-29-30
	31-33-34-35	G.2721-OG.4014	41	27.77-R.267	24		31-33-34-35
	36-37	PM2721-OG.4024	41	PM.27.77 R.267	24		36-37
27.01-PDB.520	22-23-29-30	PM2721-OG.4054	41	27.77-1141	21	297-987	58
	31-33-34-35	G.2721-OG.4194	41	27.77-PDB.1141	22-23	390-974	42
	36-37	G.2721-OG.4414	41	G.2777PDBO1811	23	PM.602-141/1	18-19-23-31
27.01-PDB.558	22-29-30-31	27.22-0504	67-68	G2777 PDBO1812	73		35
	33-34-35-36	27.22-0514	67-68	2777-PDBO.1831	23-73	602-E.1414	41
	37	27.22-0524	67	2777-PDBO.1841	23	PM.602 E.4364	40-41-54-74
27.01-PD.933	19	27.22-0994/1	67-68	2777-PDBO.1842	73	603-031	9
27.01-PD.980	18	27.22-1031	67-68	2777-PDBO.1911	23-73	605-143	16-17-20-24
27.01-0501	25-26-27-28	27.22-1074	67-68	G.2791-E.181	58		27-28-32-40
27.01-1141	25-27-28	27.22-1094	67-68	PM.2791-E.183	58-63		54-74
27.01-PDB.2232	18	27.22-1114	67-68	G.27.91-1811	57	605-144	16-17-20-24
G.27.01 PDB3792	18	27.22-1124	67-68	27.91-1911	57-58		27-28-32-40
27.01-PDB.4012	18	27.22-1134/1	67-68	27.92-0504	59		41-55-75
27.01-PDB.4042	72	27.22-1144/1	67	27.94-0504	60	605-412	8-14-15-19
27.01-PDB.4083	18	G.2722-1814/1	67	27.94-1012	61	605-723	16-17-20-24
G2701 PDB.4083	18	27.22-1844/1	67	27.94-1122	61		27-28-32-40
27.01-PDB.4422	18	27.22-1914	67	27.94-1142	61		41-54-74
27.02-P.050	33-34	G.2722-2164/2	67	G.27.94-1812	61	605-937	12-16-17-20
27.02-P.051	33-34	G.2722-2164/2	68	27.94-1832	61		24-27-28-32
27.03-PG.050	38	27.22-2594	73	27.94-1912	61		40-54-74
27.03-P.114	33-35-36-37	G.27.22-2624	73	G.27.94-2162/2	61	605-980	12-16-17-20
27.03-PG.181	38	PM.2722-2624/1	73	27.100-227	44		24-27-28-32
PM.27.03 PG.401	38	27.22-7314	67	27.221 C-074/1	41-65		40-41-54-74
27.03-PG.402	38	27.22-7324/1	67	27.277-R.071	24	620-565	47
PM2703-P.402	53-56-60	PM.2722-7324/1	67	27.277-074	4	620-570	47
27.03-PG.408	38	27.22-9874	67-68	G.27.277-PDB181	22	G.620-570	47
27.03-PG.421	38	27.26-186	21-40	27.277-0745	21-25-26-27	620-572	47
27.20-052	68	2726-PDB.196/3	23-73		28-29-30-31	633-707	10
27.20-114/1	68	PM2726PDBO1425	18-19-23-31		33-34-35-36	633-708	10
G.27.20-181/3	68		35		37-38-45-46	633-710/1	69
27.20-183	68	2726-PDBO.2055	18		47-49-50-51	633-711/1	10
27.20-184/3	68	G2726PDBO9375	18-19-23-35		52-53-54-55	633-742	13
27.20-185	68	G2732-B.002/1	44		56-57-58-59	633-812	10
27.20-191/1	68	27.32-B.029	44		60-61	633-813	10
27.20-196	68	27.32-B.039	44	270-012/3	2	633-814	10
G2721C2009/4	39-40-41-42	G.2732-B.039	44	27.778-076/1	21	PM.633-817/1	10
	62-63-64-65	G.2732-B.050	44	290-700	3	633-818/1	10
	66-67	27.32-B.051	44	290-726	2	633-819	10

DRWG N.	SHEET
633-821 / 2	10
633-822 / 2	10
633-826 / 1	10
633-833	10
G. 633-833 / 1	10
633-834 / 1	10
633-842	10
635-925	10
633-959 / 1	10
633-966	10
G. 635-937	40-54-74
639-M. 745	13
641-L.Y. 743	13
670-702	10
780201-0-00	9
780203-0-00	24
780204-0-00	42
780205-0-00	39
780208-0-00	68
780209-0-00	64
780210-0-00	65
780211-0-00	62
780222-0-00	44
780255-0-00	52
780226-0-00	55
780227-0-00	57
780229-0-00	61
780250-0-00	18
780251-0-00	20
780253-0-00	32
780281-0-00	45
780282-0-00	46
780283-0-00	47
780285-0-00	49
780286-0-00	51
780300-0-00	50
780340-0-00	19
780360-0-00	22
780361-0-00	29
780362-0-00	30
780363-0-00	33
780364-0-00	34
780380-0-00	23
780381-0-00	31
780382-0-00	36
780383-0-00	37
780387-0-00	35
780410-0-00	14
780411-0-00	15
780416-0-00	66
780417-0-00	67
780430-0-00	16
780431-0-00	17
780433-0-00	26
780435-0-00	28
780438-0-00	63
780437-0-00	58
780450-0-00	40
780451-0-00	41
780452-0-00	53
780453-0-00	54
780454-0-00	56
780455-0-00	60
910-143	12
910-144	12
P.M. 910-914	12
G. 910-914 / 1	12
910-934 / 1	12
910-964	12

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9. Feed mechanism (fig. 14).

Note: The machine heads illustrated in this catalogue are supplied with the feed mechanism already set for the type of use to which they will be put.

If feed mechanism adjustment is required, proceed as follows:

1. Inactivation of differential feed:

- Slacken nut B using wrench A supplied with the machine head, and raise pin Q on rear feed dog lever as high as it will go.
- Tighten up nut B; lower lever H against stop F and lock knurled knob R manually.

2. Setting differential feed for ratio 2 : 1

- Slacken nut B.
- Set pin Q at highest position
- Lower lever H against stop G.

3. Setting differential feed for ratio 3,5 : 1

- Slacken nut B.
- Set pin Q in lowest position
- Lock nut B.
- Lower lever H against stop G.

4. Setting differential feed for ratio 4 : 1

- Raise cursor C to its highest position on slide-bar S
- Proceed as for item 3
- The differential ratio can be changed while the machine is in operation by adjusting lever E.

5. Setting negative differential feed.

- Slacken nut B.
- Set pin Q at highest position
- Shift cursor C in lowest position.

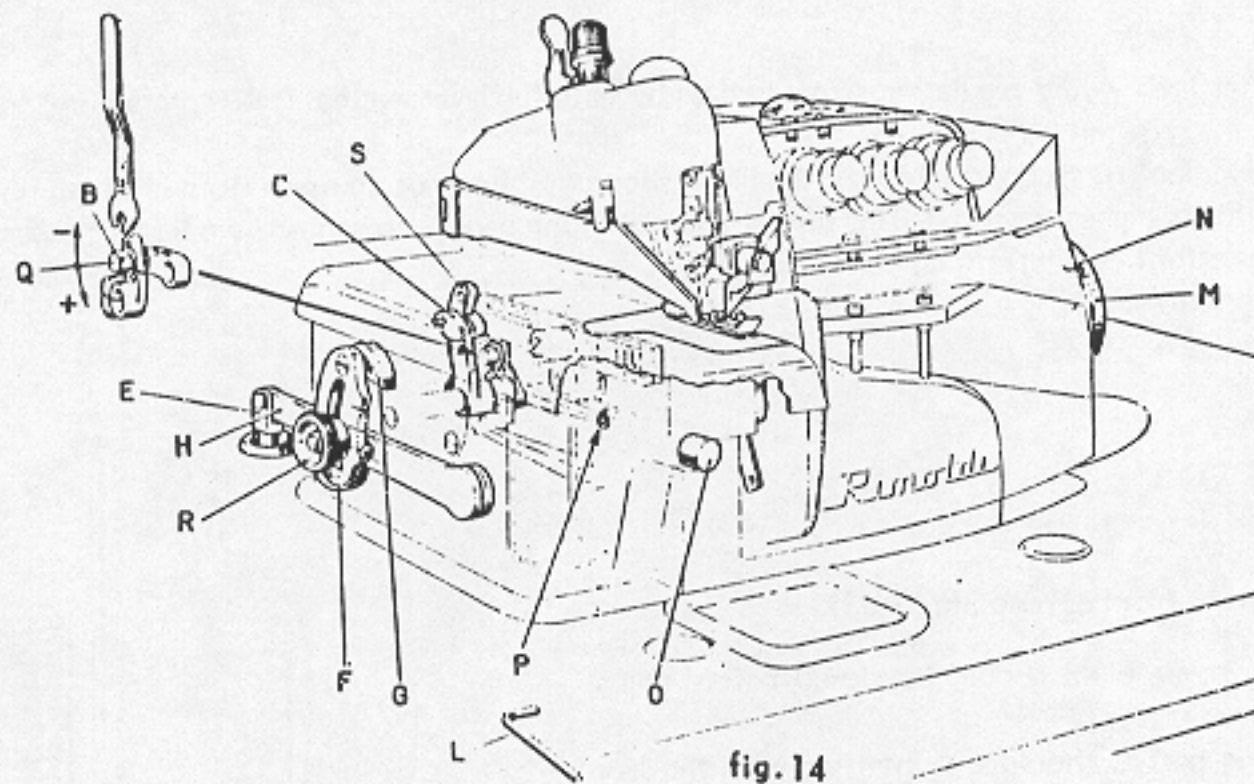


fig. 14

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10. Mounting upper trimmer knife (fig. 15).

- Mount upper trimmer knife C on knife holder block A.
- Mount knife holder block D and trimming guards E and G with screw F.
- Trimming guard E should be very close to cutting edge of knife C.
- When trimmer knife C is at its lowest position, its cutting edge should overlap the cutting edge of lower trimmer knife by 1/32".
- For this adjustment, shift trimmer knife in its slanting seat and knife holder block A on the upper knife holder B.
- Tighten up screw F and check that the upper knife, when in lowest position, does not touch front needle guard.

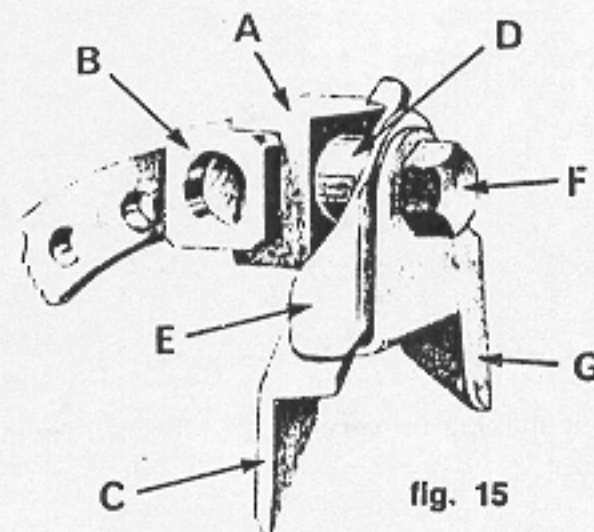


fig. 15

e) Positioning and adjustment of presserfoot arm (fig. 16)

- Insert presserfoot arm shaft L in bushing C on which presserfoot bearing arm is hinged.
- Insert presserfoot arm shaft L with bushing C into hole provided in baseplate.
- Slide lever A and spring E on to shaft L.
- Slide snapping F on to shaft L.
- Set lifter lever A so that there is no end-play on presserfoot arm shaft L.
- Slightly tighten screw B.
- With needle at highest position, insert presserfoot bearing arm D in guide fork.
- Engage lifter lever A with presserfoot lifting foot pedal.
- When pedal is depressed it should have a slight idle stroke before actuating presserfoot bearing arm D.

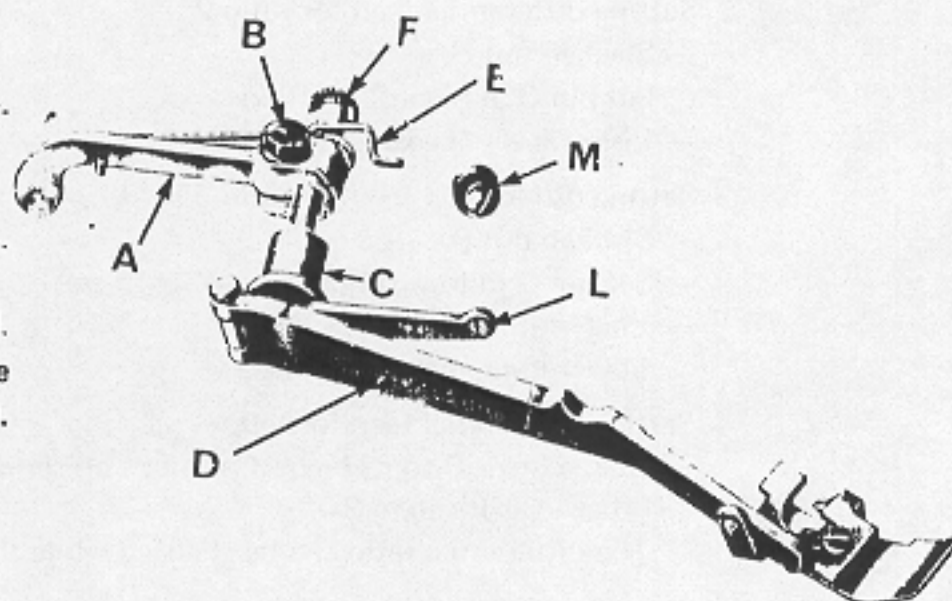


fig.16

- Adjust lifter lever A, by regulating screw in base beneath the lever, so that it lifts presserfoot to required position.
- Check movement of secondary looper; the latter should not impinge on presserfoot chaining finger when presserfoot is at its highest position. This undesirable condition can be prevented by adjusting eccentric washer M, below presserfoot bearing arm D, on side cover.
- Tighten up screw B.

f) Adjustment of front cover plate (fig. 17)

- The front cover plate should be closed before adjustment.
- The moving part C should not interfere with the front needle guard or the lower knife holder.
- The cover plate can be shifted towards left or right by adjusting screw B.
- Lock nut A.

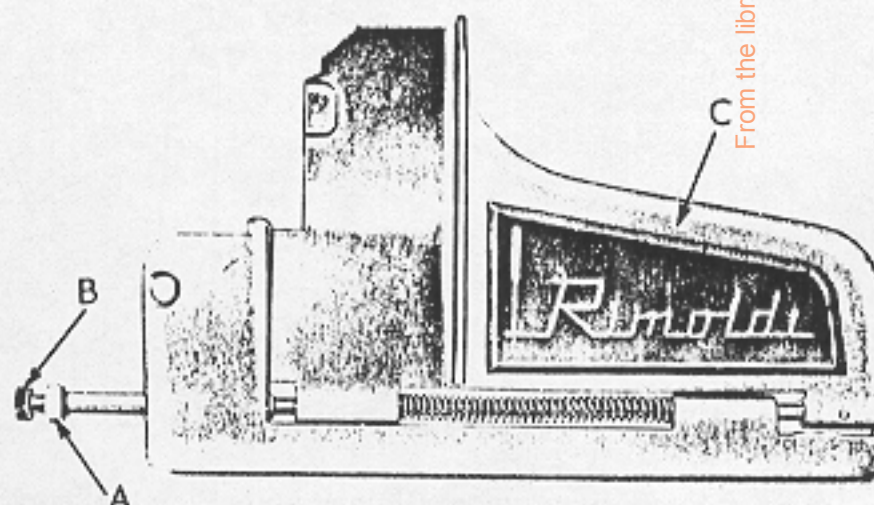


fig.17

g) Adjustment of needle thread take-up

- For making up very tough fabrics, needle thread take-up 270-274/2 should be shifted forwards, towards operator.

ELECTRIC LUBRICATION CONTROL DEVICE (PRESSURE SWITCH)

h) Disassembly and replacement of pressure switch

- Take down oil cup from baseplate and drain out oil.
- Remove screw by which pressure switch bracket is mounted on oil cup.
- Slacken the two screws on the electric wire terminal lugs.
- Slip plastic tube connecting pressure switch to rubber connection off the pressure switch.
- Remove bracket and fix it to new pressure switch.
- Screw down electric wire lugs, slip plastic tube into pressure switch and mount switch on oil cup using the screws previously removed.
- Re-install oil cup and fill with oil as instructed on page 11, par c

Replacement of pressure switch lamp

- Proceed as described under items 1 and 2 for replacement of pressure switch.
- Remove rubber tube, remove lamp (bayonet cap) and replace with new lamp.
- Re-install rubber tube, replace pressure switch in position and fasten firmly to oil with screw
- Re-install oil cup and fill with oil as instructed on page 11, par c

Electrical connection of pressure switch on Zefir motors

- Plug cable to current socket and insert plug at other end of cable in 12 V. light socket on motor.
- Note:** If no light socket is provided on the motor to be connected, but the voltage connection box is provided with 12 V. connections, proceed as follows:
- Mount a Mignon socket pitch 13 at one end of a cable 4 - 5 inches long and at the other connect it to the 12 V. light terminal lugs.
 - Plug cable to current socket at one end and to the above Mignon socket at the other.

Adjustment of forced feed lubrication rate to main shaft (fig. 18)

- Remove cover.
- Using a screwdriver, turn indicator B in required direction. (Turning towards the letter C punched on the plate, the rate of flow is decreased, turning the indicator towards the letter A, the rate of flow is increased).

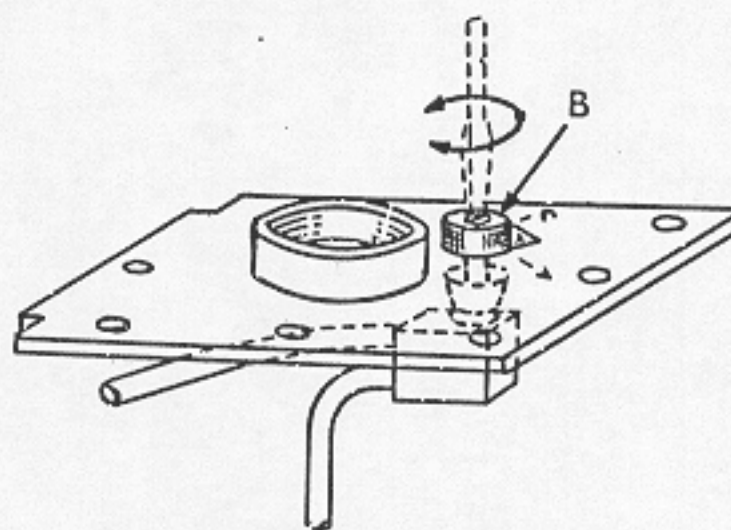
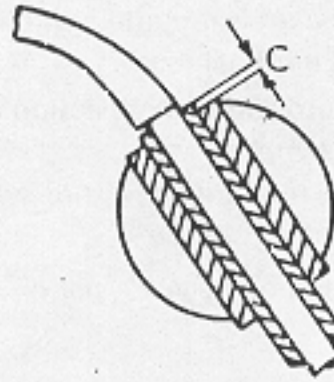


fig. 18

TIMING TABLE

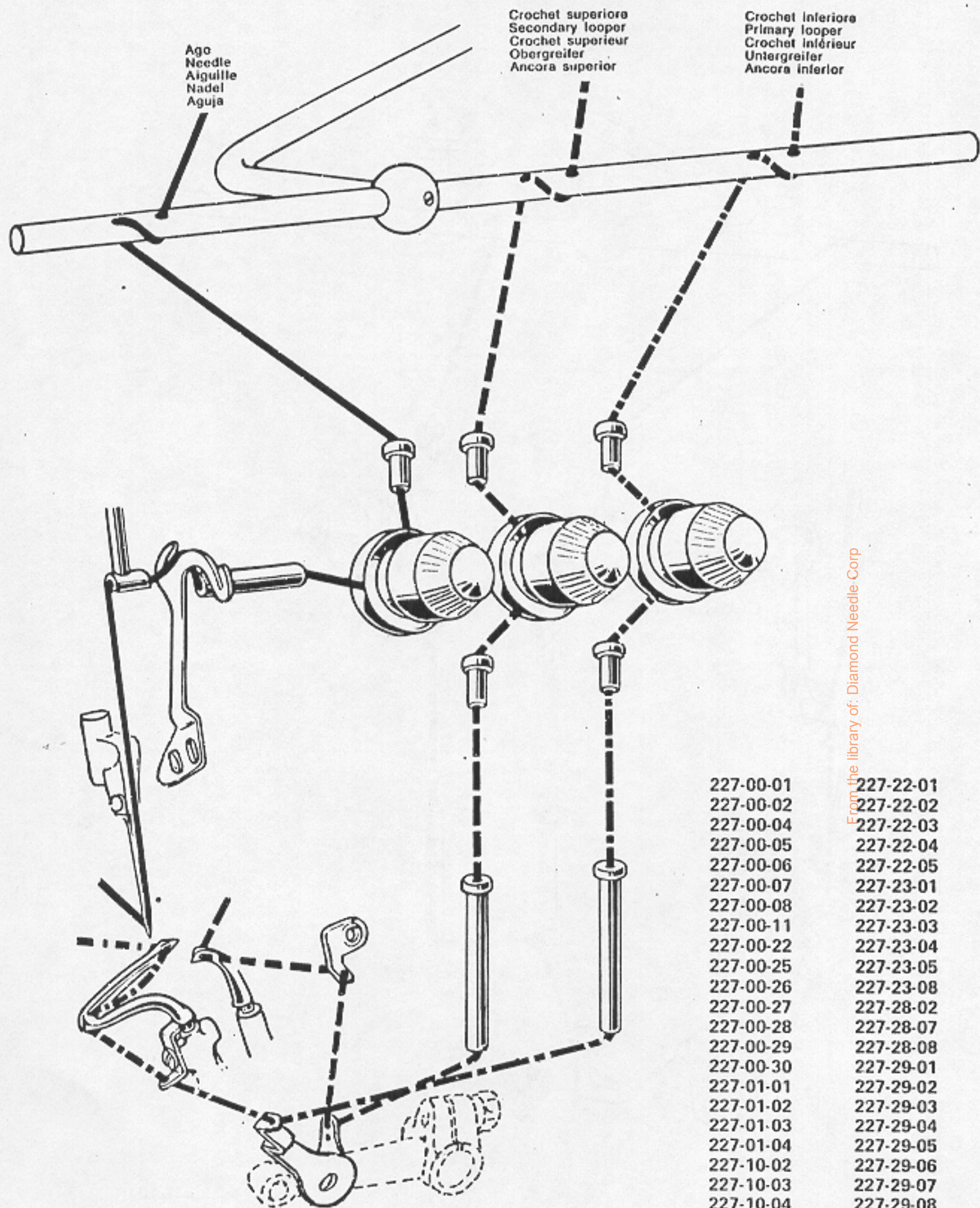


MACHINE HEAD NUMBERS	A	B	C	D	E
227-00-01 = 227-28-01 = 227-28-02 = 227-29-01 = 227-29-02 = 227-01-01 = 227-17-01 = 227-01-02 = 227-00-06 = 227-22-01 = 227-01-03 = 227-00-07 = 227-29-04 = 227-29-01 = 227-29-06 = 227-22-02 = 227-22-03 = 227-23-02 = 227-01-04 = 227-22-04 = 227-22-05 = 227-23-08 = 227-23-03 = 227-23-04 = 227-23-03 = 227-10-01 = 227-23-06 = 227-10-02 = 227-10-03 = 227-10-04 = 227-10-05 = 227-10-06 = 227-11-01 = 227-10-07 = 227-00-25 = 227-30-03 = 227-30-04 = 227-00-26 = 227-30-05 = 227-00-27 = 227-29-08 = 227-00-28 = 227-30-06 = 227-00-29 = 227-00-08 = 227-00-02 = 227-00-30 =	2,5	1,5	0,8	4,5	3,5
227-00-05 = 227-30-01 = 227-00-11 = 227-00-09 = 227-29-07 = 227-00-04 = 227-00-22 =	2,3	1,5	0,8	-	5
227-00-10 = 227-30-02 = 227-28-07 = 227-28-08 =	2,3	1,5	0,8	5	-
227-00-33	2,5+3	2,5	0,2	-	4,2 4,3

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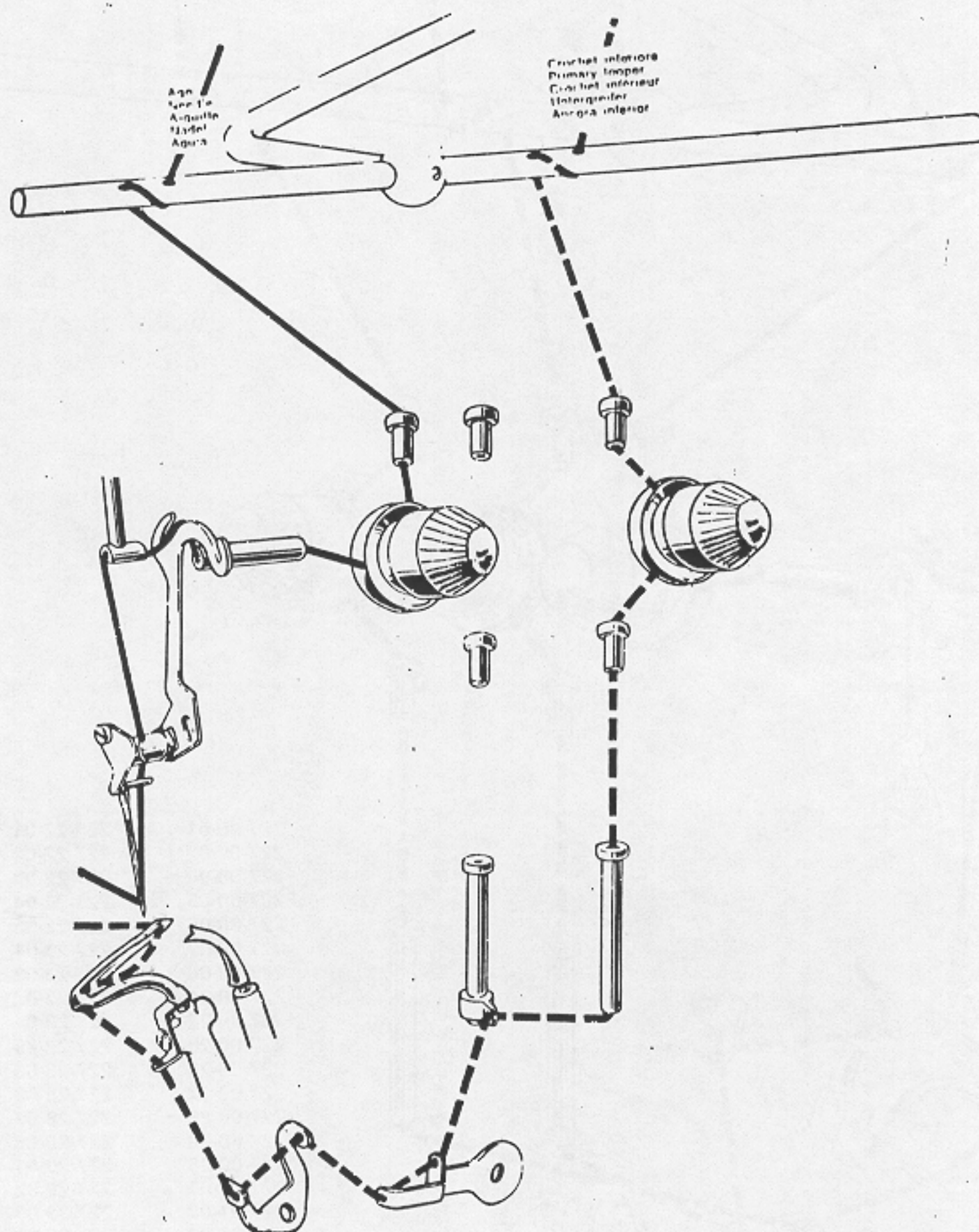
II. IMPIEGO

a) Infilatura -



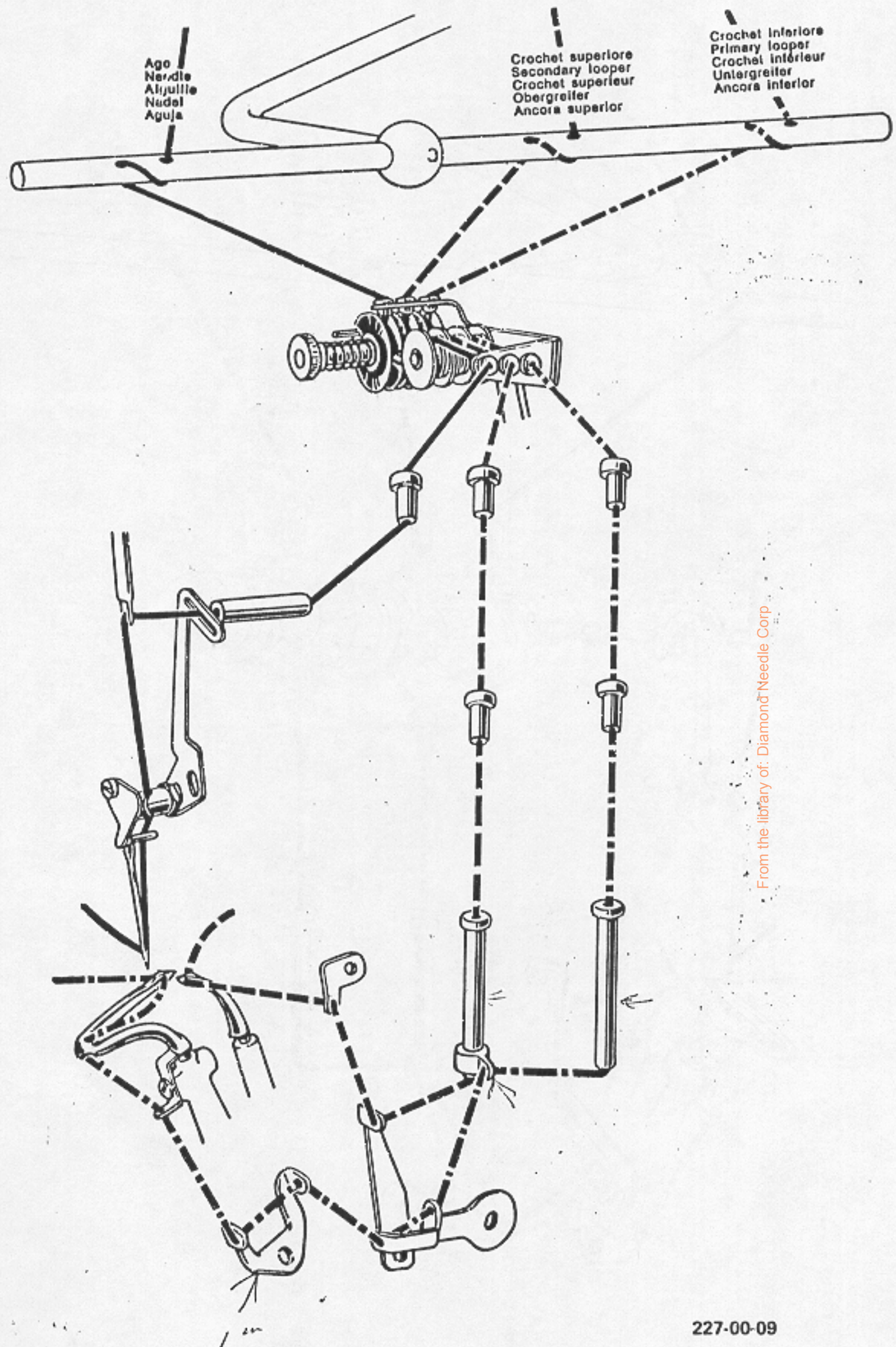
227-00-01	227-22-01
227-00-02	227-22-02
227-00-04	227-22-03
227-00-05	227-22-04
227-00-06	227-22-05
227-00-07	227-23-01
227-00-08	227-23-02
227-00-11	227-23-03
227-00-22	227-23-04
227-00-25	227-23-05
227-00-26	227-23-08
227-00-27	227-28-02
227-00-28	227-28-07
227-00-29	227-28-08
227-00-30	227-29-01
227-01-01	227-29-02
227-01-02	227-29-03
227-01-03	227-29-04
227-01-04	227-29-05
227-10-02	227-29-06
227-10-03	227-29-07
227-10-04	227-29-08
227-10-05	227-30-01
227-10-06	227-30-03
227-10-07	227-30-04
227-11-01	227-30-05
227-17-01	227-30-06

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227-10-01



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227-00-09

III. TECHNICAL DATA BY SUB-CLASS

HEAD No.	TECHNICAL CHARACTERISTICS							SPECIFIC USES
	No. threads	Width of bight	Diff. pos.	S P E E D		Knives	Sp. attach- ments on req.	
				No. of revs. 1" max.	St. per inch			
227-00-01	3	1/8" 1/4"	max. med.	7000	15-30 7-30	yes	100 101 106 107 115	MAKING UP WITH OR WITHOUT FELLING For medium cut knit fabrics in wool, cotton, etc.
227-00-07	3	3/32" 5/32"	max. med.	7000	15-30 7-30	yes	100 101 106 107 115	For light cotton and wollen cut knit fabrics, same as 227-00-01 but with a slightly narrower bight.
227-00-08	3	1/8"	zero	5000	14-40	yes	107 115	For seaming woven fabrics and knit fabrics with narrow bands. Particularly suitable for woollen gloves and children's mittens.
227-00-25	3	5/64" 8/64"	negat.	7000	8-30	yes	100 106 107 115	For very light and light woven fabrics (nylon, satin, very light flannel, etc.) with attachment to curl the fabric downwards into the seam.
227-00-26	3	3/32"	negat.	7000	8-30	yes	100 106 107 115	For light woven fabrics, with attachment to curl the fabric upwards into the seam.
227-00-27	3	3/32"	negat.	7000	8-30	yes	100 106 107 115	Same as 227-00-25, but for medium fabrics (satin, heavy satin, etc.).
227-00-28	3	3/32"	negat.	7000	8-30	yes	100 106 107 115	Same as 227-00-27, but with finer toothed feed-dogs for very light delicate woven fabrics.
227-00-29	3	1/8" 8/64"	med.	6500	8-30	yes	107 115	Same as 227-00-25, but with wider bight for sponge cloth, flannels, etc.
227-01-01	3	1/8" 1/4"	med. max.	7000	7-20 15-30	yes	107 115	MAKING UP WITH OR WITHOUT FELLING, WITH APPLICATIONS AND INSERTION OF TAPE For inserting decorative piping. For light and medium fabrics.
227-01-02	3	1/8" 1/4"	max. med.	7000	15-30 7-30	yes	107 115	For medium cut knit fabrics, in wool, cotton, etc., with attachment for inserting a reinforcement tape into the seam.
227-01-03	3	8/64" 15/64"	max.	5500	8-20	yes	115	For medium and heavy fabrics, with attachment for inserting a reinforcement tape into the seam. With a maximum presser-foot throw of 19/64" - maximum bight 15/64".
227-01-04	3	3/32" 5/32"	max. med.	7000	15-30 7-30	yes	107 115	Same as 227-01-02, but with a slightly narrower bight, for light knit fabrics.
227-10-01	2	5/64"	med.	5500	15-30	yes	115	HEMMING For hemming the top of ladies' circular stockings.

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b) Needle change

1. Switch off motor.
2. Depress motor driving pedal to check that machine is absolutely motionless.
3. Set needle at top dead centre.
4. Lower lever B as far as it will go (**fig. 19**).
5. Swing out presserfoot from usual working position
6. Slacken needle set-screw by one half-turn using screw-driver 1161/2.
7. Remove needle.
8. Insert new needle.
9. The needle scarf should face the rear needle guard, i.e. towards the rear of the machine.
10. Using pincers supplied with machine kit, check that needle touches the bottom of the hole.
11. Retighten needle set-screw without displacing the needle, but do not apply excessive force

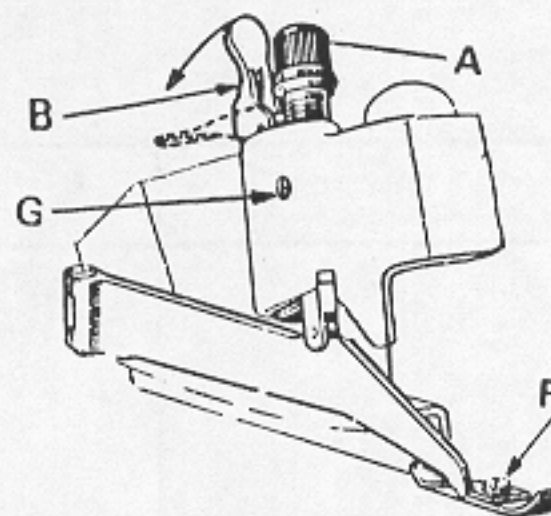


fig. 19

c) Positioning and adjustment of presserfoot (**fig. 19**).

1. Check that presserfoot is in proper position
2. Needle should pass between pressurefoot shoe and chaining finger.
3. To adjust presserfoot slacken screw F.
4. Center presserfoot in proper position and tighten up screw F.
5. Presserfoot pressure is increased or slackened by loosening screw G with wrench 633-742 and adjusting knurled knob A.
6. Lock knob A by tightening up screw G with wrench 633-742.

d) Tensioning discs adjustment

1. Tighten tension discs just enough for even stitch formation.
2. Avoid over-tightening.

e) Stitch length adjustment (**fig. 14**)

1. Slacken screw P using appropriate wrench.
2. Depress pushbutton O and turn handwheel M until tip of pushbutton slips into the notch on the regulator.
3. Holding pushbutton O firm, turn handwheel M vigorously until indicator N shows the desired length on the handwheel.
4. Tighten up screw P firmly.

Note: The stitch lengthener eccentric has a built-in stop-pin which limits the maximum stitch length according to the type of fabric.

f) Seam width adjustment

Seam width can be adjusted within a very narrow range beyond which the needle plate must be changed. To vary seam width within the above narrow range, proceed as follows:

1. Slacken screw N of lower knife holder (**fig. 11**).
2. Slacken screw F (**fig. 15**).
3. Shift upper knife holder block A (**fig. 15**) to right or left until desired seam width is obtained.
4. Tighten up screw F (**fig. 15**).
5. Lower knife holder should be checked and set as described in paragraph a) 7.

g) Trouble due to incorrect handling of machine

No.	TROUBLE	PROBABLE CAUSE
1	Uneven stitches	- Tension badly adjusted - Thread take-ups incorrectly adjusted - Wrong threading - Yarns not gauged
2	Feed and Fabric slipping sideways	- Presserfoot pressure too light - Height and slant of feed dogs not properly adjusted - Knives require sharpening - Differential badly adjusted
3	Machine skipping stitches	- Primary or Secondary Looper badly adjusted in respect of needle size that looper becomes blunted - Loopers too far apart at crossing - Loopers too near at crossing, thus becoming blunted - Front needle guard too far from needle - Needle not set in proper position
4	Thread breaking	- Tensions too tight - Yarn irregularly wound on reel
5	Needle breaking	- Needle bent - Needle badly mounted
6	Fabric being punctured	- Blunt needle - Needle size unsuitable for plate - Needle point unsuitable
7	Oil leaking	- Screws mounting oil cup on base not sufficiently tightened up - Oil cup plug not screwed down tightly - Oil cup gasket badly mounted
8	Faulty lubrication	- Oil level too low - V-belt incorrectly mounted - Upper tube clogged - Lubrication pump filter clogged

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III. MAINTENANCE

a) Daily

Lightly clean feed and stitch formation mechanisms

b) Weekly

1. Thoroughly clean, removing needle plate, feed dogs, front and rear needle guard and loopers
2. Open front cover plate and carefully clean front cavity
3. Clean inside the needle movement mechanism casing.

c) Quarterly

1. Using wrench provided with service kit, remove plug beneath oil sump and drain off oil completely
2. Unscrew screw 007-M-15 by which filter is mounted on drain plug
3. Remove filter and clean thoroughly by immersing in gasoline
4. Blow filter and plug with jet of compressed air
5. Soak felt gasket with clean oil
6. Replace plug
7. Fill oil cup with 1 3/4 pints fresh VR 604 oil.

IMPORTANT

When following instructions given in paragraph c, 1, do not unscrew drain plug completely immediately, but allow most of the oil to drain out from the side slots in the plug as shown in (fig. 20).

d) Sharpening knives

1. Sharpen knives using RIMOLDI knife sharpener and the special block provided, which assures the exact angle of sharpening. The sharpening block is supplied on request

e) Instructions for taking down and removing cam shaft (if necessary)

- Tools required supplied on request only
- Pincers type S 0560/00
- Pincers type S 0459/00
- Puller type S.0416/00.

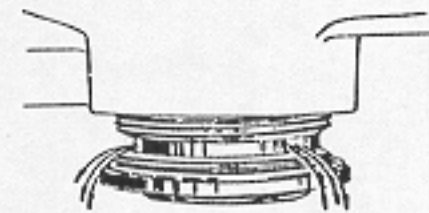


fig. 20

IMPORTANT

It is absolutely necessary for the main parts of the shaft-connecting rod assembly to be re-installed in their original position. Therefore proceed as follows:

- Re-install flanges G and T with lubrication hole facing downwards.
- Leave all connecting rod lock-screws in their own holes.
- Connecting rods J and L are identified by a 2 punched on the L big-end and three lines on the J rod surface.
- For positioning the connecting rod cap a reference mark is provided on both the cap and connecting rod. Both marks should be on the same side
- For positioning connecting rod N reference is made to the drawing number on the handwheel side.
- Cup springs should be installed in the original order.

OPERATION SEQUENCE

1. Turn stitch length to reference 5 on handwheel
2. Remove screw Z.
3. Turn stitch length to reference O on handwheel.
4. Remove flange G.
5. Slacken the two screws on eccentric C.
6. Remove ball bearing A and eccentric C, using puller S 0416/99
7. Remove spring D from regulator E, using pincers S 0560/00
8. Slacken screws on ring F.
9. Remove caps from connecting rods N,O,J,L.
10. Remove cover Y from hanwheel
11. Slacken hex screw X.
12. Remove washer W.
13. Remove handwheel V.
14. Remove flange T.
15. Slide off spacer U.
16. Remove cup spring S.
17. Pull off snap-ring P using pincers S.0459/00, slightly shifting cam to the right.
18. Remove sectors K and Q.
19. Remove shaft.

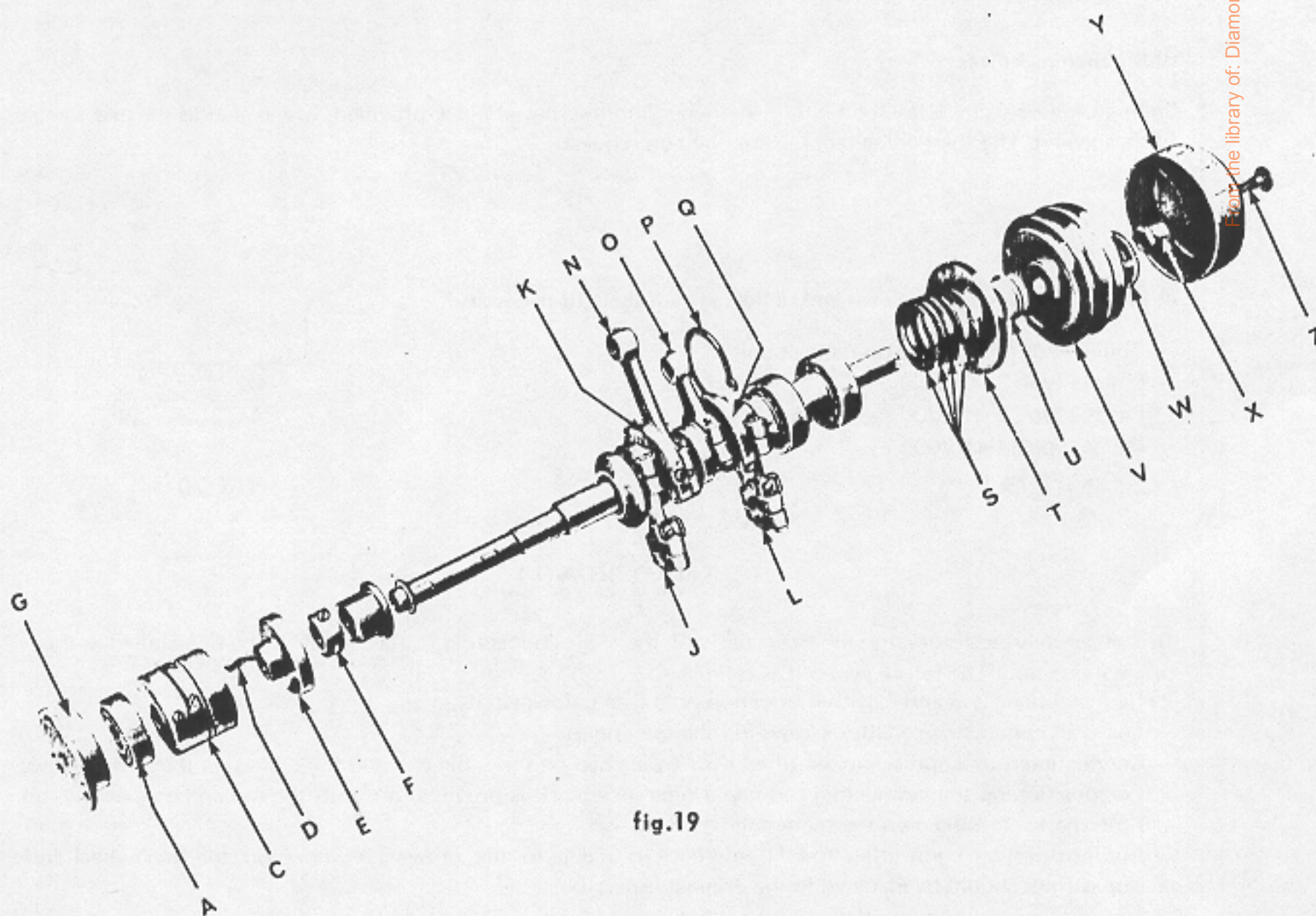
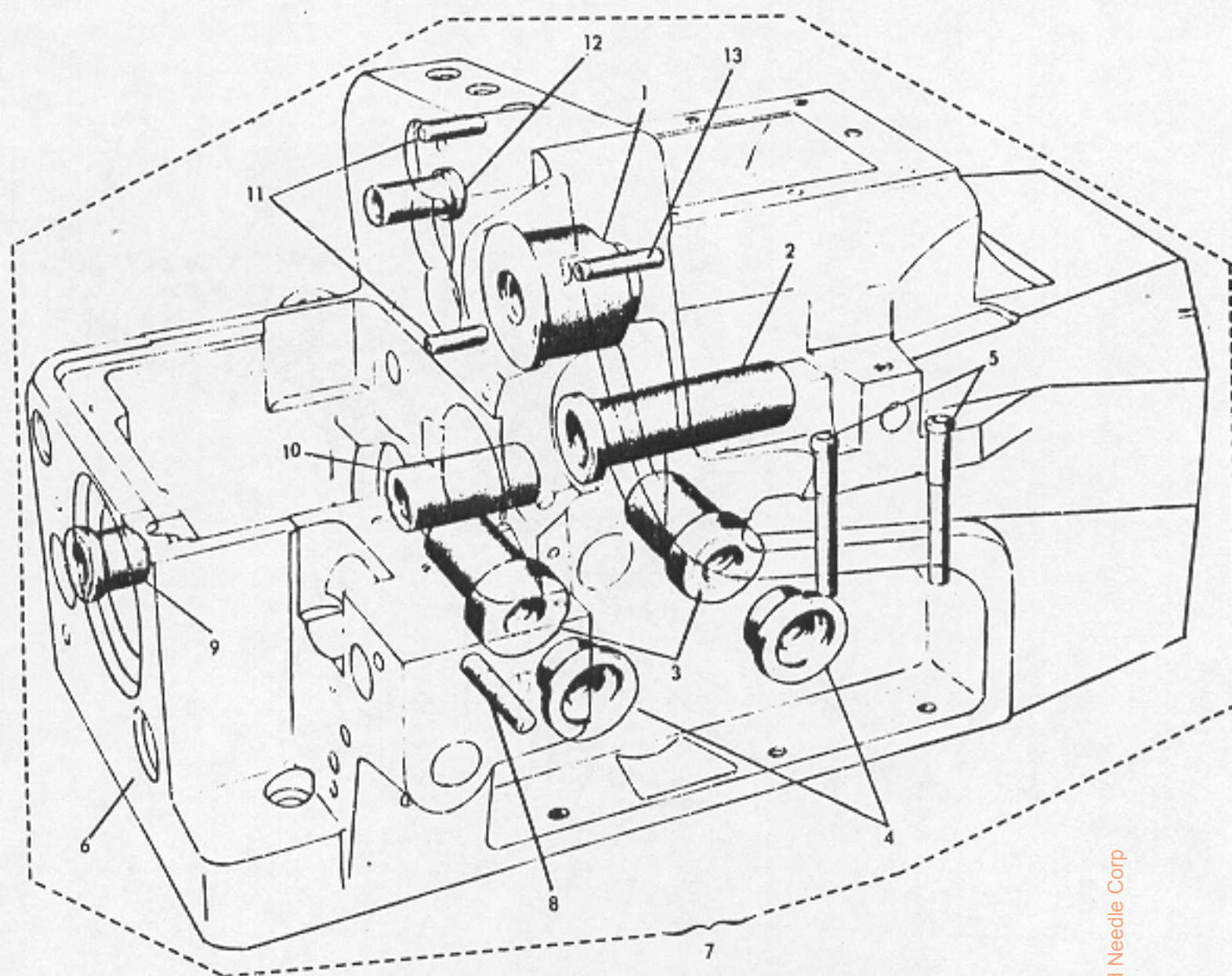


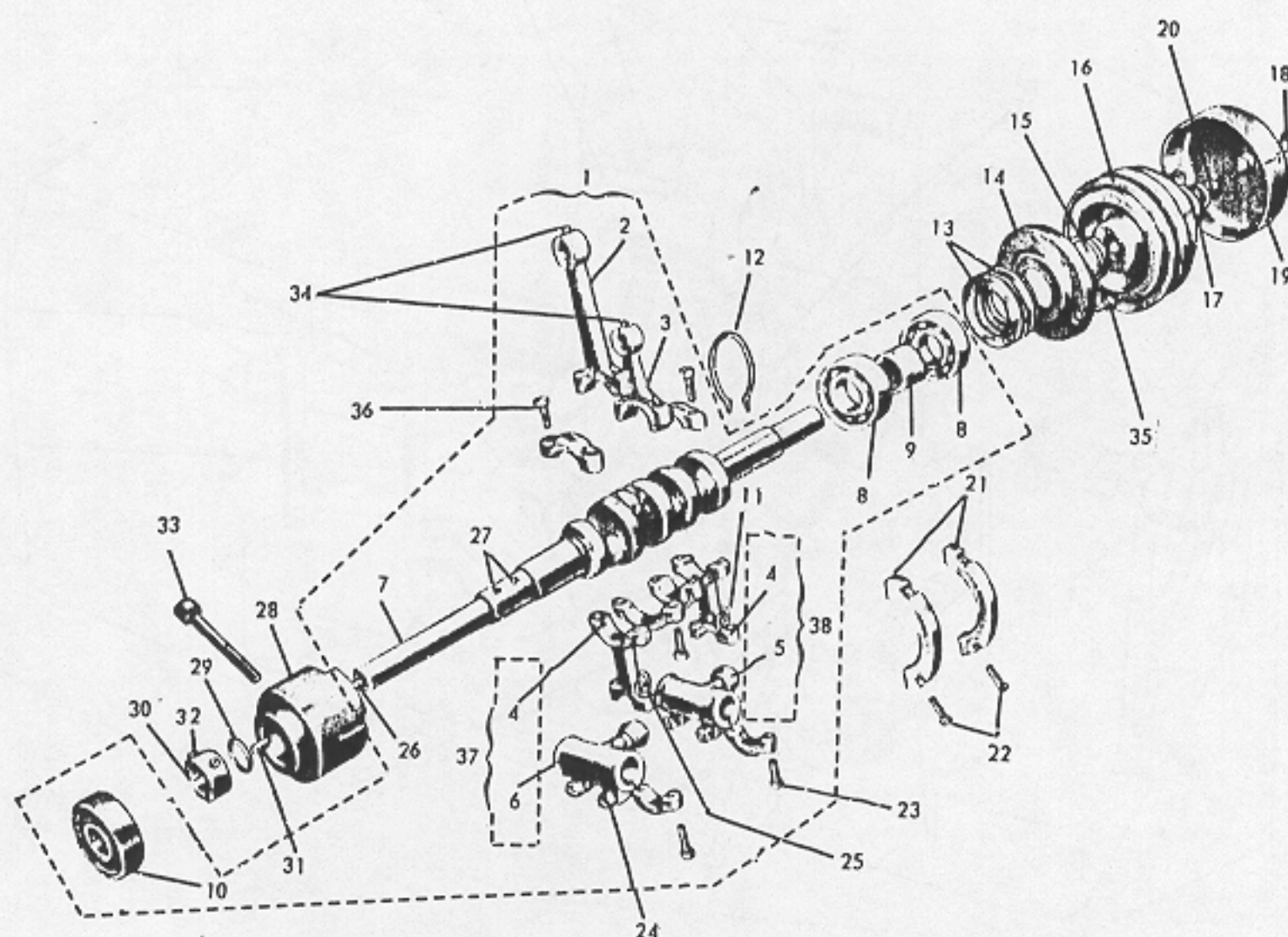
fig.19



REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-016	bushing, needle bar shaft	1	8	270-912	latch pin, workplate	1
2	270-097/1	bushing, upper knife holder	1	9	270-044/2	bushing, differential shaft	1
3	270-058/2	rear bushing, looper shaft	2	10	270-032/3	bushing (left), differential shaft	1
4	270-057/1	front bushing, looper shaft	2	11	270-042	pin, coverplate centering	2
5	270-268	guide tube, looper thread	2	12	270-082/1	bushing, presserfoot lifter lever	1
6	270-002/1	base, machine	1	13	270-254	thread guide, needle	1
7	G.270-002/1	base with bushings and thread guides	1				

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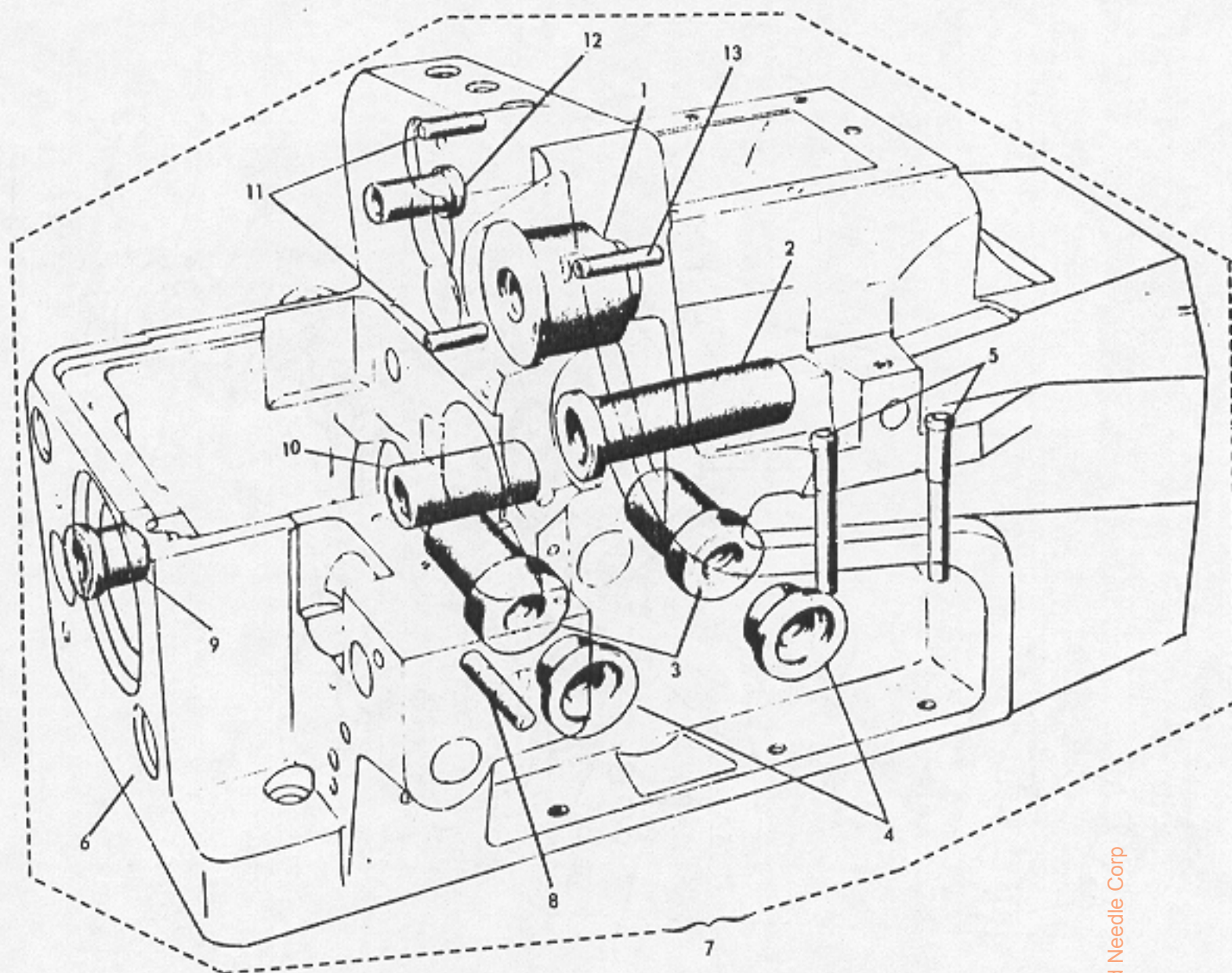
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REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	PM.270-009/4	main shaft, with connecting rods	1	20	270-510	pivot, handwheel	1
2	280-012/3	control rod, needle bar	1	21	270-517/2	rockers	2
3	270-116/2	control rod, knife	1	22	270-999	screws, rocker	4
4	270-061/2	control rod, secondary looper	1	23	010-11-13,7	screw for control rods 280-012/3 and 270-113/2	4
5	270-060/1	sleeve, secondary looper control rod	1	24	270-975	screw, sleeve	4
6	270-059/1	sleeve, primary looper control rod	1	25	290-944	lock-screw, connecting rod guide	2
7	270-009/4	main shaft	1	26	002-D-14	oil wick, main shaft	1
8	270-707	ball bearing, right	2	27	002-C-2	wick	2
9	270-513	spacer, bearing	1	28	270-010-2	hush, intermediate	1
10	270-709	ball bearing, left	1	29	074-A-12	washer, differential	1
11	270-062	guide, connecting rod	2	30	270-722	ring, adjustment	1
12	270-704	snap-ring, right ball bearing	1	31	290-726	cap, main shaft	1
13	270-705	spring, cup	1	32	016-D-5	screw, adjustment ring	2
14	260-620	flange, right	1	33	270-936	lock-screw, intermediate hush	1
15	270-614	spacer, main shaft right	1	34	02-E-5,5	grub-screw, pin	2
16	270-008/1	handwheel	1	35	001-E-10	screw, right flange	1
17	270-512/1	washer with guide	1	36	010-D-11,5	screw, looper control rod	6
18	270-981	set-screw, handwheel	1	37	PM.270-059-1	sleeve assembly	1
19	270-608/5	cover with handwheel	1	38	PM.270-030/1	sleeve assembly	1

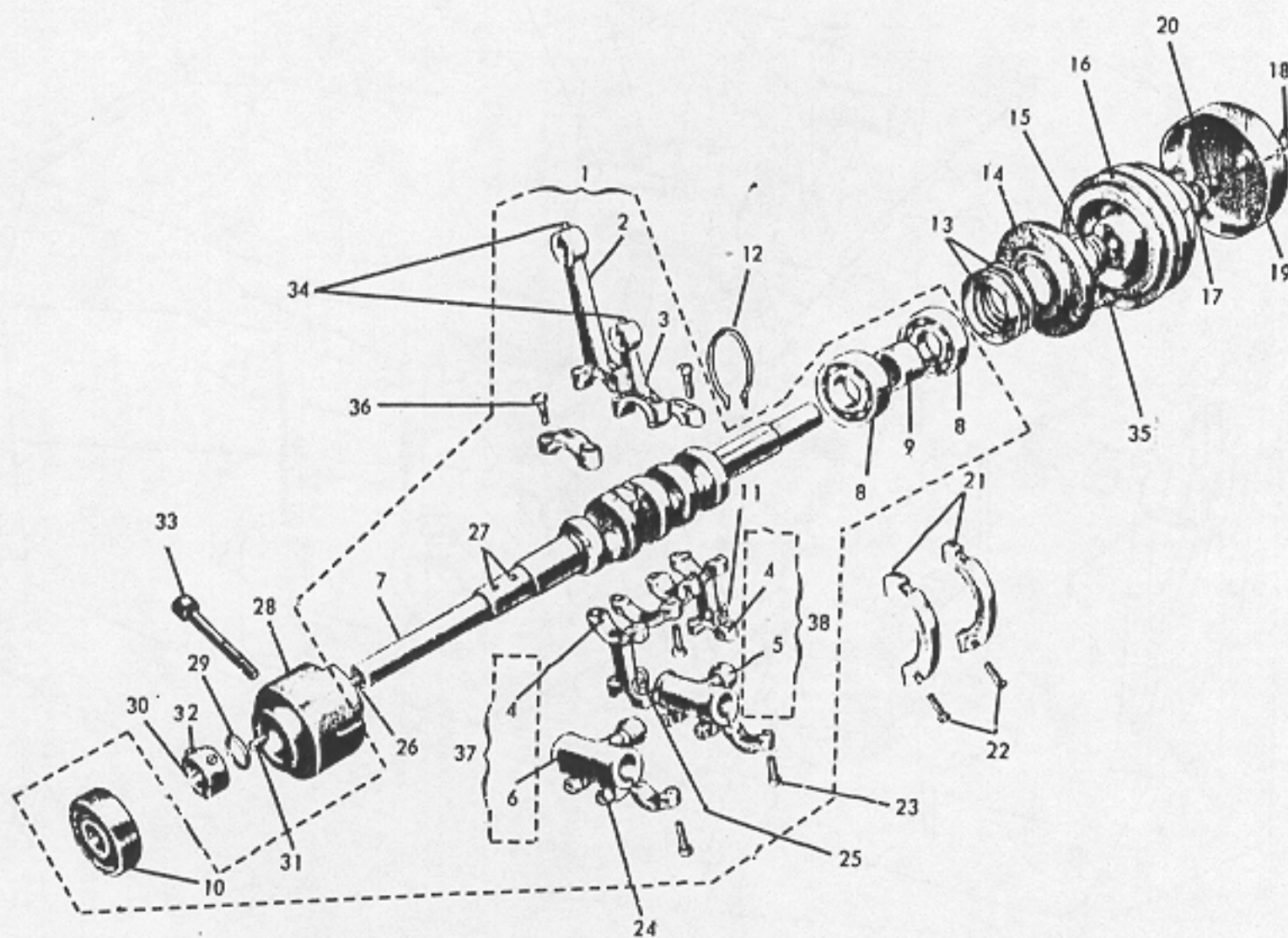
N. B. Bearing reference number 8 can be supplied as separate spares, however it is indispensable to specify on the order sheet the Roman numeral appearing on the outer race of the removed bearing.



REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-016	bushing, needle bar shaft	1	8	270-912	latch pin, workplate	1
2	270-097/1	bushing, upper knife holder	1	9	270-044/2	bushing, differential shaft	1
3	270-058/2	rear bushing, looper shaft	2	10	270-012/3	bushing (left), differential shaft	1
4	270-057/1	front bushing, looper shaft	2	11	270-042	pin, coverplate centering	2
5	270-268	guide tube, looper thread	2	12	270-082/1	bushing, presserfoot lifter lever	1
6	270-002/1	base, machine	1	13	270-254	thread guide, needle	1
7	G. 270-002/1	base with bushings and thread guides	1				

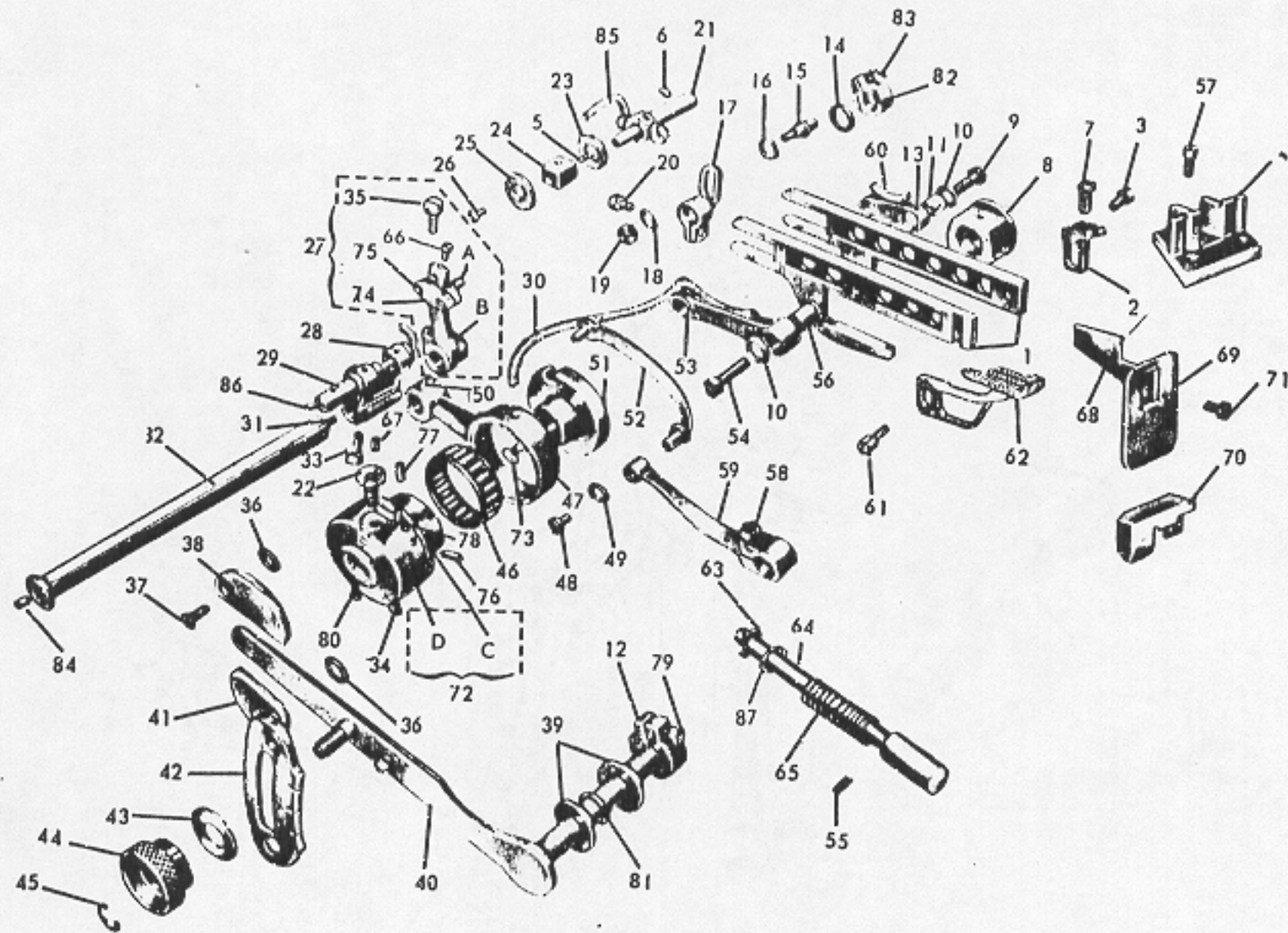
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27



REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	PM.270-009/4	main shaft, with connecting rods	1	20	270-510	pivot, handwheel	1
2	280-012/3	control rod, needle bar	1	21	270-517/2	rockers	2
3	270-116/2	control rod, knife	1	22	270-999	screws, rocker	2
4	270-061/2	control rod, secondary looper	1	23	010-11-13,7	screw for control rods 280-012/3 and 270-113/2	4
5	270-060/1	sleeve, secondary looper control rod	1	24	270-975	screw, sleeve	4
6	270-059/1	sleeve, primary looper control rod	1	25	290-944	lock-screw, connecting rod guide	2
7	270-009/4	main shaft	1	26	092-0-14	oil wick, main shaft	1
8	270-707	ball bearing, right	1	27	092-0-2	wick	2
9	270-613	spacer, bearing	1	28	270-010 2	bush, intermediate	1
10	270-709	ball bearing, left	1	29	074-A-12	washer, differential	1
11	270-062	guide, connecting rod	2	30	270-722	ring, adjustment	1
12	270-704	snap-ring, right ball bearing	1	31	290-726	cap, main shaft	1
13	270-705	spring, cup	1	32	016-0-5	screw, adjustment ring	2
14	260-620	flange, right	1	33	270-938	lock-screw, intermediate bush	1
15	270-614	spacer, main shaft right	1	34	02-51-5,5	grub-screw, pin	2
16	270-008/1	handwheel	1	35	001-E-10	screw, right flange	1
17	270-512/1	washer with guide	1	36	010-0-11,5	screw, looper control rod	6
18	270-981	set-screw, handwheel	1	37	PM.270-059 1	sleeve assembly	1
19	270-608/5	cover with handwheel	1	38	PM.270-030/1	sleeve assembly	1

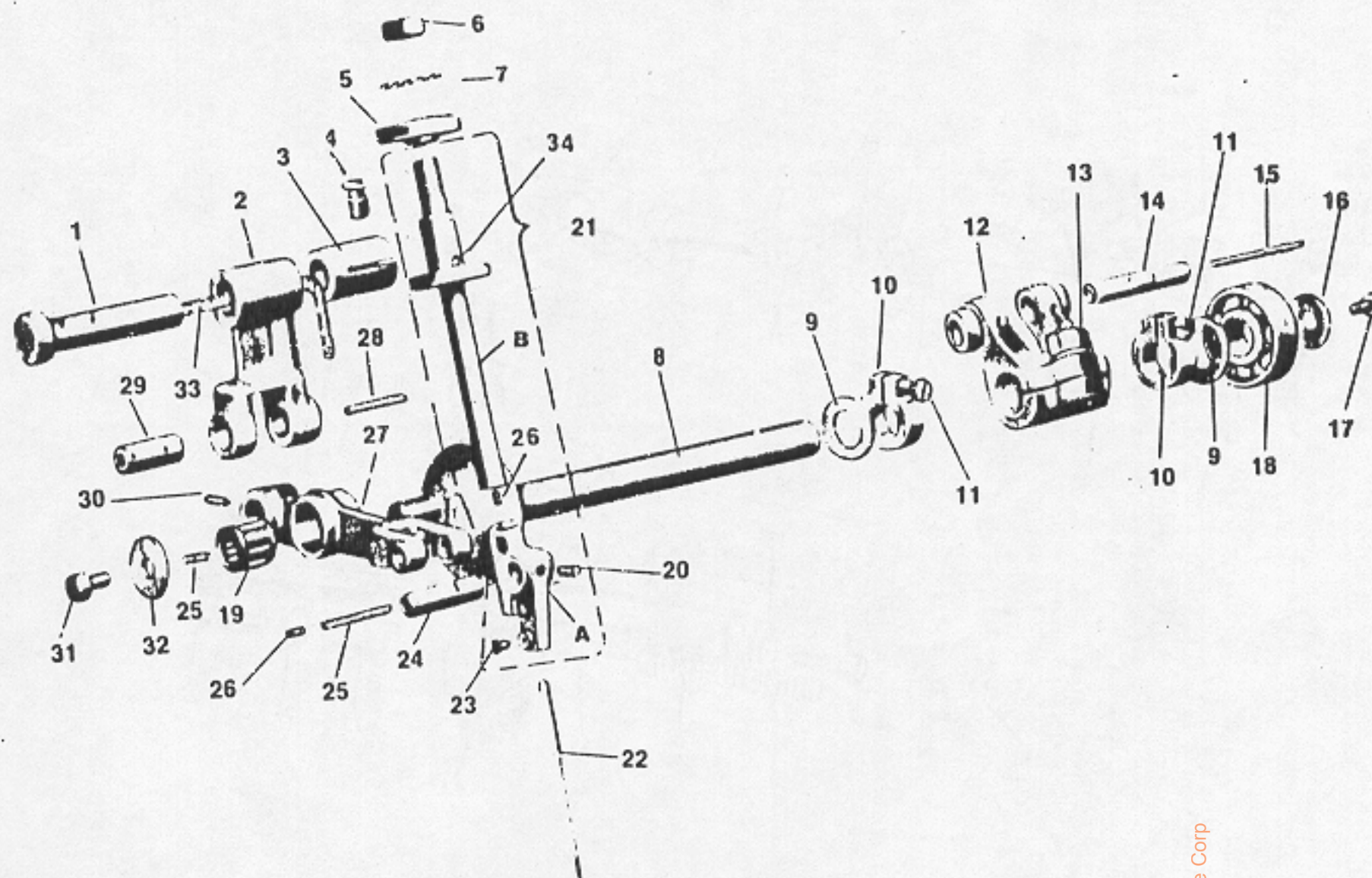
N. B. Bearing reference number 8 can be supplied in separate spares, however it is indispensable to specify on the order sheet the Roman numeral appearing on the outer race of the removed bearing.



REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	PM.270-049/1	assembly, differential slide	1	12	270-032/3	rod, differential control	1
2	270-051	feed dog, rear	1	48	270-984	screw, feed lever	1
3	270-977	screw, attach rear feed dog	1	49	070-E-3	washer, feed lever	1
4	270-540/3	guide block, right differential	1	50	023-N-5,5	securing screw, pin	1
5	092-B-1	oil wick	4	51	270-735	eccentric regulation	1
6	270-937/1	securing screw, differential eccentric shaft	1	52	PM.270-045/2	attachment, differential segment	1
7	270-052	feed dog, chaining	1	53	270-033/1	link, differential slide	1
8	270-611/1	eccentric, feed dog lifter	1	54	270-980	securing screw, differential link	1
9	270-979	securing screw, link	1	55	270-943	grub-screw, securing pushbutton	1
10	070-M-4,5	washer, differential links	2	56	270-034	bush for differential slide	1
11	270-035	bush, differential feed slide	1	57	005-L-11	securing screw for guide	2
12	4030-06	collar	1	58	270-997	screw, differential control lever	1
13	270-048	link, differential feed slide	1	59	270-566/1	control lever, differential segment	1
14	073-C-8	washer, pin	1	60	092-D-4	oil wick, differential link	1
15	270-054	pin, differential segment	1	61	270-978	securing screw, front feed dog	1
16	071-M-5,5	washer, diff. ratio increase segment	1	62	270-050	front feed dog	1
17	279-047/2	guide segment, diff. ratio increase	1	63	290-700	snap-ring for pushbutton	1
18	070-F-4	washer, diff. ratio pin	1	64	270-736/3	shank, pushbutton	1
19	057-F-4	nut for pin 270-054	1	65	270-738	spring, pushbutton	1
20	270-975	screw, segment	1	66	001A-2,5	screw	1
21	270-039	shaft, differential eccentric	1	67	270-729	set-screw	1
22	270-7391	securing pin	1	68	279-249/1	shield	1
23	071-H-5	washer, differential eccentric shaft	1	69	270-250/2	rubber guard for feed dogs	1
24	270-036/1	sliding block, for differential	1	70	270-253	gasket, slide guide	1
25	270-935	counter-washer	1	71	004-L-7	securing screw, guard	2
26	026-C-7	screw, counter-washer	1	72	PM.270-732/3	housing and cam stitch length eccentric	1
27	PM.270-038/3	complete adjustable differential assembly	1	73	270-734	flat spring	1
28	270-040	yoke, connecting rod	1	74	270-032/3	plate, differential mechanism cursor	1
29	270-031/1	pin, fork yoke	1	75	004-P-6	securing screw, cursor plate	2
30	092-D-6	oil wick, dowel	1	76	270-928	grub-screw, for eccentric slide	2
31	092-D-12	oil wick, rear pivot	1	77	270-929	lock-screw, for grub-screw	2
32	270-041/1	rear pivot, differential	1	78	270-747	gib, eccentric slide	1
33	250-471	screw, yoke	1	79	007-C-11	screw, collar	2
34	017-E-11,5	securing screw, adjustable eccentric	1	80	023-E-12	set-screw, eccentric	1
35	039-H-9	screw, differential segment	1	81	270-595	gasket, differential control lever	1
36	064-F-5	washer, segment	2	82	270-717	collar, differential collar	1
37	270-992	screw, differential segment	2	83	270-927	screw, collar	1
38	270-287/1	upper sector	1	84	270-915	plug, differential pinion bore	1
39	073-A-8	washer, differential drive shaft	2	85	092-D-11	oil wick	1
40	PM.270-562/2	lever, complete differential control	1	86	092-D-23	oil wick	1
41	270-288/1	stop	1	87	270-594	gasket	1
42	270-567	sector with setting marks	1	A	270-045/3	slide for differential adjustment	1
43	065-D-6	washer, knurled knob	1	B	270-038/3	segment for differential adjustment	1
44	270-568	knurled knob, lever lock	1	C	279-733/1	slide, stitch length eccentric cam	1
45	270-702	snap ring	1	D	270-732/3	stitch length eccentric cam	1
46	270-703	needle roller bearing cage	1				

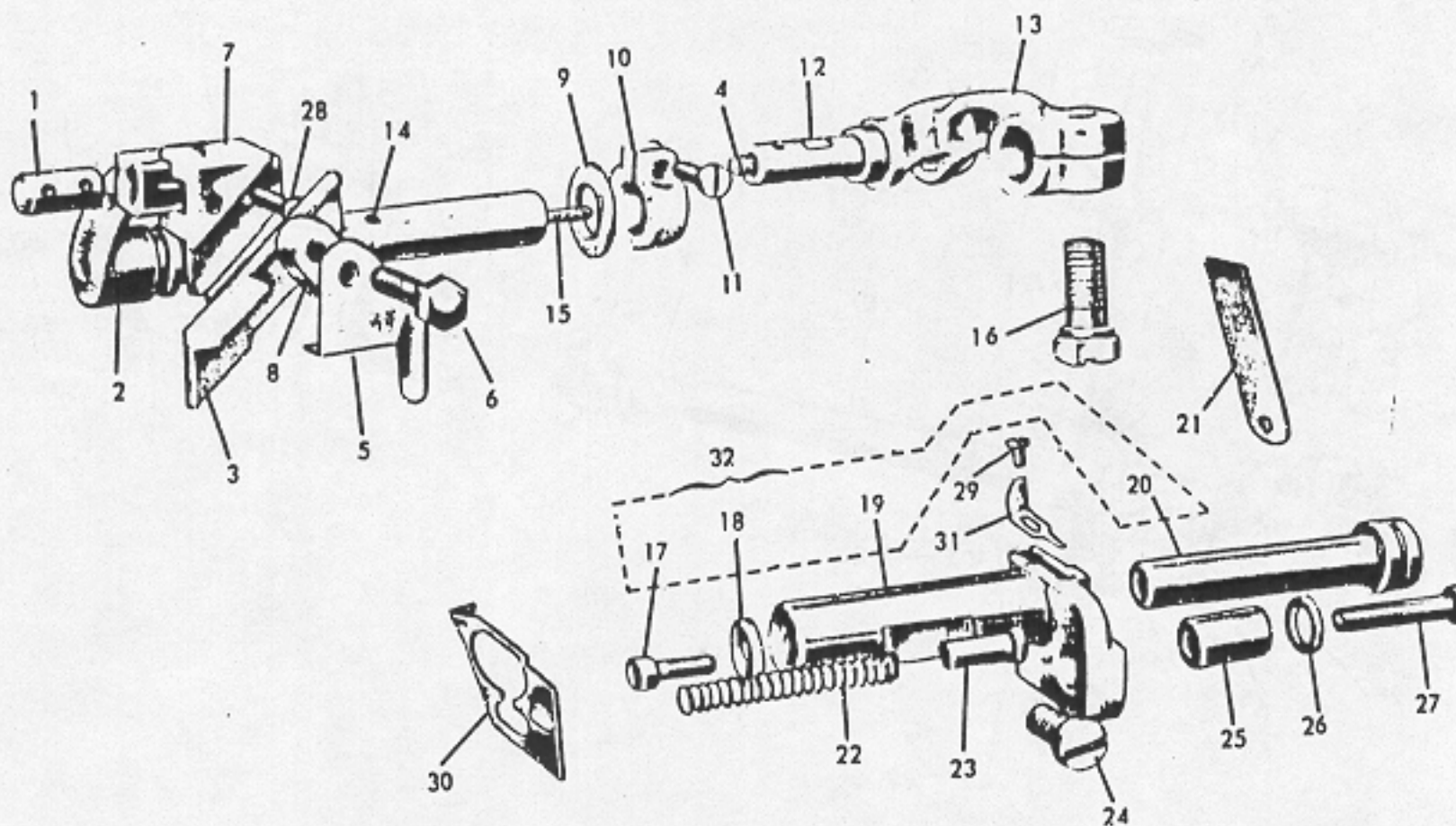
III. TECHNICAL DATA BY SUB-CLASS

HEAD No.	TECHNICAL CHARACTERISTICS							SPECIFIC USES
	No. threads	Width of bight	Diff. pos.	S P E E D		Knives	Sp. attach- ments on req.	
				No. of revs. 1" max.	St. per inch			
227-10-02	3/2	5/64" 1/8"	med.	7000	8-30	yes	100 106 107 115	For wetting knit fabrics in general with invisible seam on right side, with fixed hinged wetting folder. With a blind looper to work also with 2 threads.
227-10-03	3/2	5/64" 1/8"	med.	7000	8-30	yes	100 106 107 115	Fitted with folder, throat plate, feed dog and presserfoot specially designed for wetting along the non-stretchy direction of warpknit, jersey fabrics, etc. with invisible seam on right side. With a blind looper to work also with 2 threads.
227-10-04	3/2	5/64" 1/8"	med.	7000	8-30	yes	100 106 107 115	Same as 227-10-03, but with wetting folder moveable by means of knee-press, guaranteeing a regular hem even at cross-seams.
227-10-05	3/2	5/64" 1/8"	med.	7000	8-30	yes	100 106 107 115	For wetting of knit fabrics, with invisible seam on right side, with swing-out wetting folder and with work plate cut out to accept preclosed sleeves, and with blind looper to work also with 2 threads.
227-10-06	3/2	5/64" 1/8"	med.	7000	8-30	yes	100 106 107 115	For wetting of knit fabrics with invisible seam on right side, with blind looper to work also with 2 threads.
227-10-07	3/2	5/64" 1/8"	med.	7000	8-30	yes	100 106 107 115	Same as 227-10-02, but with special work plate cut out to accept preclosed sleeves.
HEMMING WITH APPLICATIONS AND INSERTIONS								
227-11-01	3/2	5/64" 1/8"	med.	7000	8-30	yes	115	For wetting of knit fabrics with invisible seam on right side, with attachment to insert a latex thread from the top (please specify elastic diameter) - with swing-out wetting folder and blind looper to work also with 2 threads.
ELASTIC FACINGS AND EDGINGS WITH APPLICATIONS AND INSERTIONS								
227-17-01	3	3/64" 5/32"	negat.	5000	8-30	yes	107 115	With binder to attach a rubber strapping to the legs of the internal brief of men's bathing shorts. The machine is always supplied with a binder for 5/16" rubber strapping entering the binder - without cutting device.
SHIRTING								
227-22-01	3	3/16"	max.	6000	6-20	yes	-	For medium and light fabrics and for linen with attachment to ruffle the lower fabric - with knee press control.
227-22-02	3	3/16" 5/32"	max.	6000	6-20	yes	101	For medium and light fabrics, with attachment to ruffle the lower fabric - with knee press control.



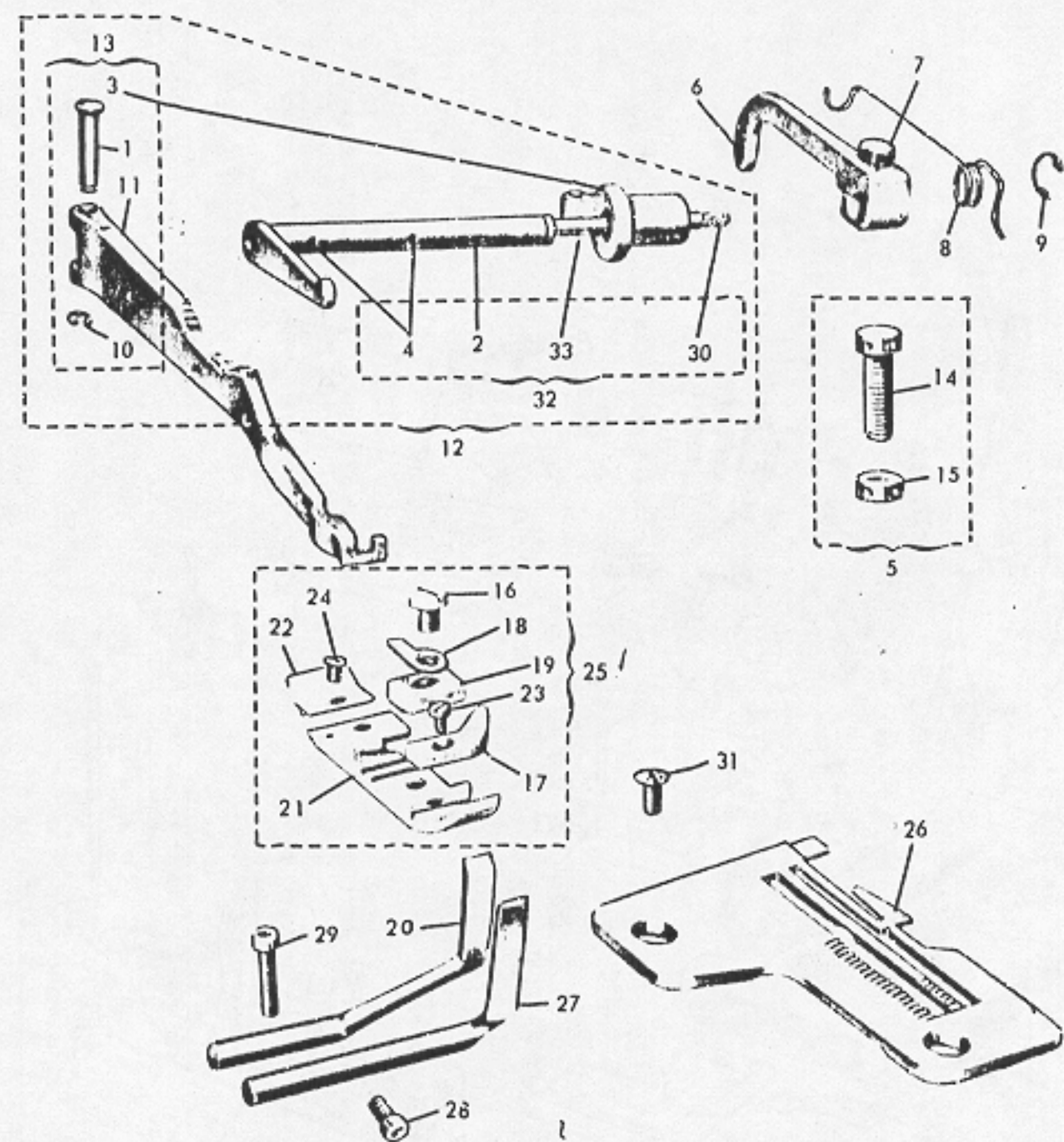
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	PM.270-138/1	pin, needle lever rocker	1	19	250-708/1	needle bearing cage	1
2	PM.270-137/1	lever, fork	1	20	016-B-2,5	screw, pin securing	1
3	270-132/1	bush, fork lever	1	21	G.270-025/2	needle bar assembly with clamp, complete	1
4	270-728/1	securing screw, bush	1	22	HIM.27	needle	1
5	290-027/1	washer, needle rocker pin	1	23	003-A-4,5	screw, needle clamp	1
6	270-933	lock-nut, guide pin	1	24	270-130	pin, needle clamp	1
7	270-713	flexible washer	1	25	092-B-1	oil-wick for needle clamp pin	2
8	270-006/1	drive shaft, needle bar	1	26	016-A-2,5	grub-screw, needle bar clamp pin	2
9	073-F-9	washer, upper shaft	2	27	270-135	lever, needle holder slide control	1
10	270-719	collar, upper shaft	2	28	092-D-5	oil-wick for pin	1
11	007-C-11	screw, for collar	2	29	270-133/1	pin, fork lever	1
12	270-007/1	attachment, drive shaft	1	30	023-N-5,5	set-screw, needle bar control lever	1
13	270-975/1	screw, attachment drive shaft	1	31	001-E-7	screw, upper shaft	1
14	270-031/1	pin, attachment drive shaft	1	32	270-131	shim, adjustment	1
15	092-D-6	oil-wick, for pin	1	33	092-D-11	oil-wick, for pin	1
16	071-E-5	washer, upper shaft	1	34	092-A-10	oil-wick, for needle bar	1
17	001-G-10	screw, washer	1	A	270-020/1	needle clamp	1
18	270-708	bearing, upper shaft	1	B	290-025/1	needle bar	1

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REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-102	pin, upper knife holder	1	17	007-P-10	set-screw, lower knife	1
2	270-096/1	upper knife holder	1	18	071-D-5	washer, for pin	1
3	270-112	upper knife, serrated	1	19	270-104	lower knife holder	1
4	092-D-5	oil-wick	1	20	270-105	pin, lower knife holder	1
5	128-111	trimming guard, upper knife	1	21	270-113/1	lower knife	1
6	270-987	securing screw, upper knife	1	22	270-100	spring, lower knife	1
7	270-099	block, upper knife holder	1	23	270-106	pressure pin, lower knife	1
8	270-103	lock-pawl, upper knife	1	24	003-L-12	securing screw, lower knife holder	1
9	073-F-9	washer, upper knife holder	1	25	270-101	bushing, lower knife guide	1
10	270-719	collar, upper knife holder	1	26	070-F-4	washer, for bushing	1
11	007-C-11	screw, upper knife holder collar	1	27	270-877	screw, bushing	1
12	270-108/1	pin, yoke attachment	1	28	028-B-5	screw, upper knife holder	1
13	270-098	yoke attachment	1	29	004-A-5	securing screw, angle stop	1
14	092-C-2	oil-wick for yoke attachment pin	2	30	27.77-227	brace-plate, rear needle guard	1
15	092-D-9	oil-wick for knife holder	1	31	27.77-223	angle stop, front needle guard	1
16	250-471	screw, upper knife lever	1	32	PM.270-104/1	knife holder, lower	1
On request:							
270-113/2						Tab. 78	
270-112/2						" 78	
270-401						" 75	

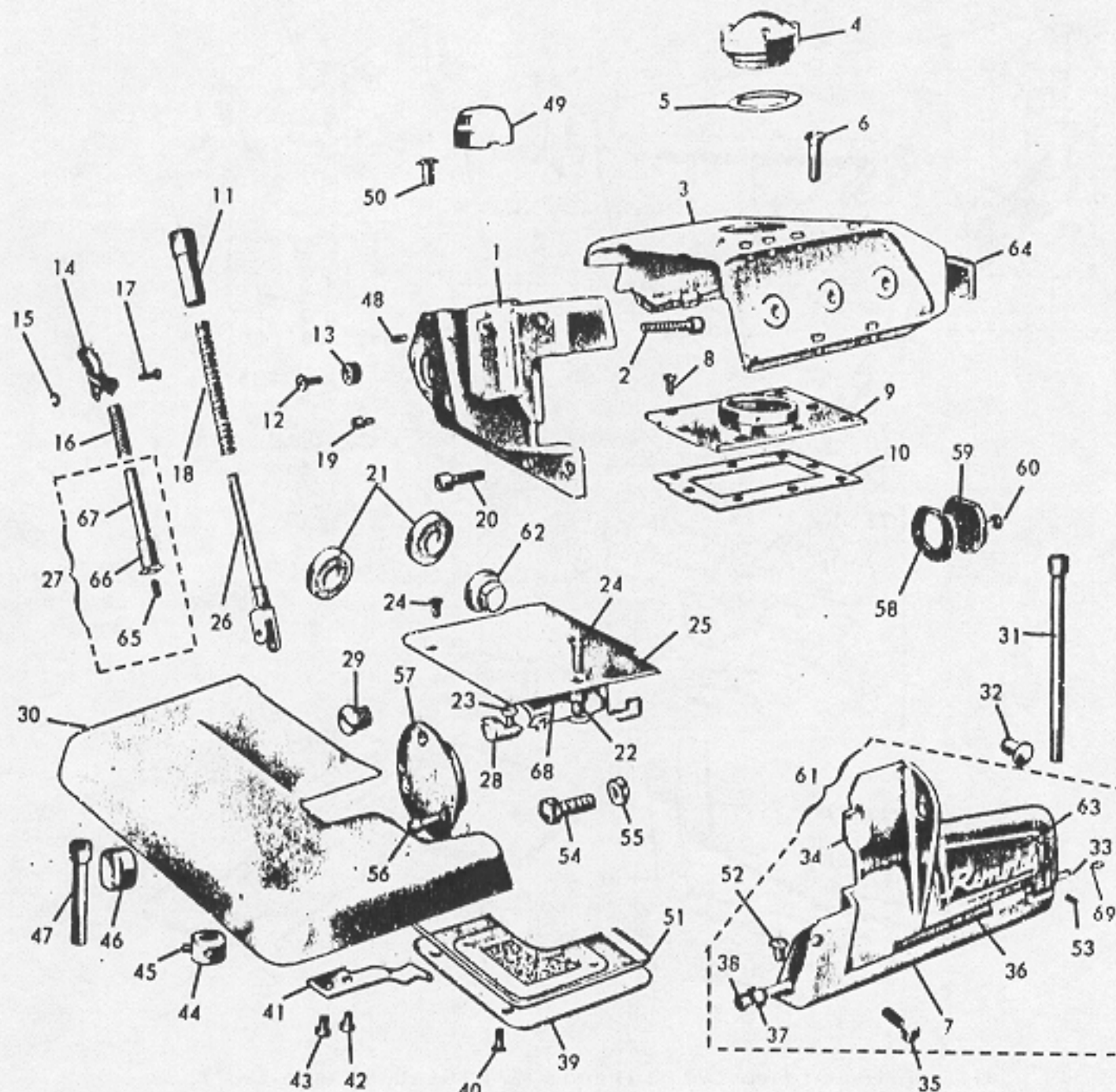
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N.B. To convert a type 227-00-01 into a 227-00-01-100 see table 72-73
To convert a type 227-00-01 into a 227-00-01-101 see table 74

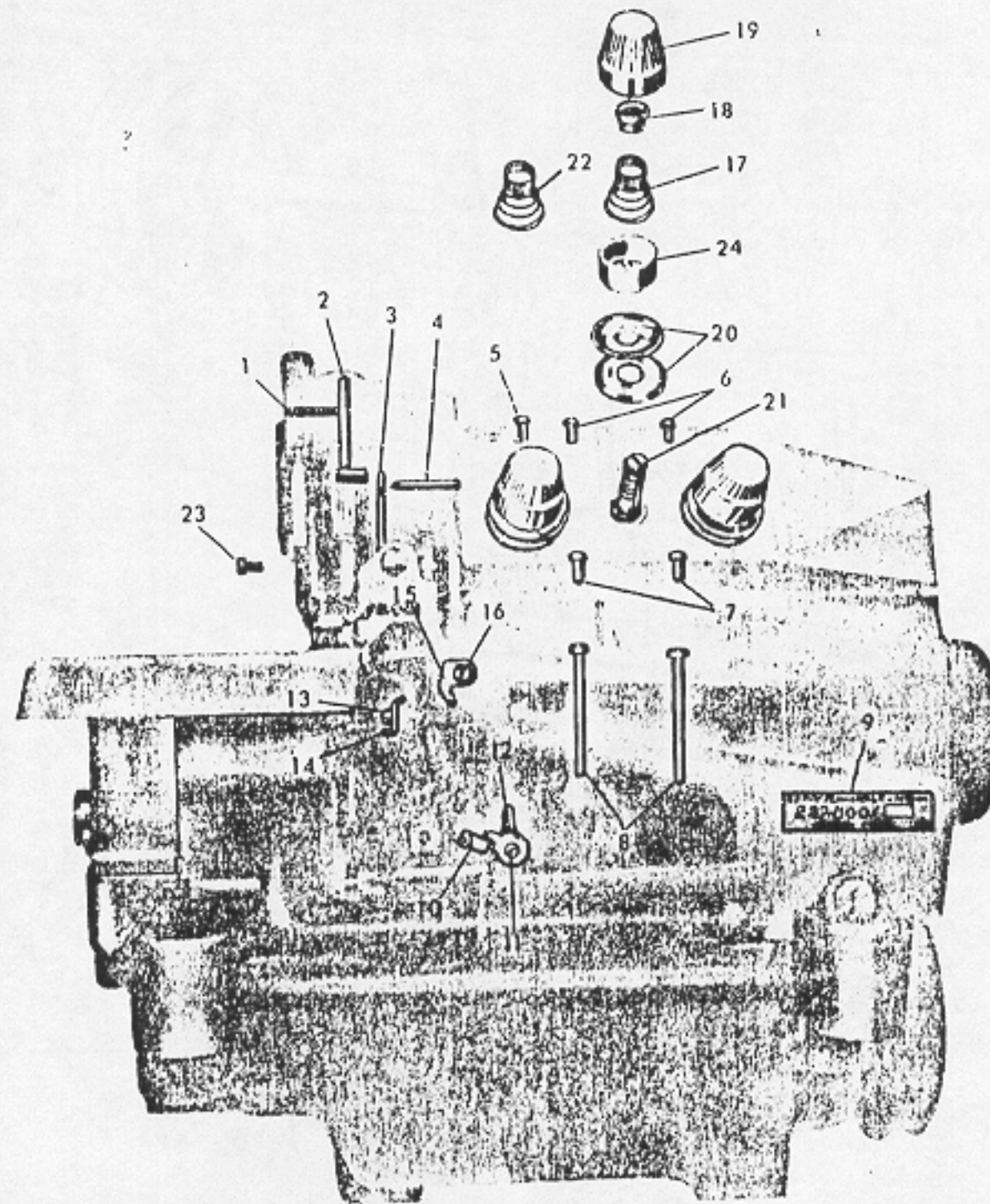
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-077	pin, presserfoot arm	1	19	270-199	bracket, presserfoot	1
2	270-081/1	shaft, presserfoot lifter lever	1	19	270-191	chaining finger, presserfoot	1
3	270-083	bushing, presserfoot lifter lever shaft	1	20	270-109/1	needle guard, rear	1
4	092-C-2	oil-wick	4	21	270-184	shoe, presserfoot	1
5	PM.270-085/1	stop-pin, lever stroke adjustment	1	22	270-185	plate, chaining guide	1
6	270-087/1	lever, presserfoot lifter	1	23	270-989	screw, block	1
7	270-985	screw, presserfoot lifter lever	1	24	001-A-3,2	screw, chaining guide plate	1
8	270-089/1	spring, presserfoot lifter lever	1	25	G.270-181	presserfoot assembly	1
9	270-714	snap-ring, presserfoot lifter lever shaft	1	26	270-1141	needle plate for narrow bight	1
10	270-701	snap-ring	1	27	270-107/1	needle guard, front	1
11	270-075/2	presserfoot arm	1	28	270-936/2	screw, front needle guard	1
12	G.270-076/2	presserfoot arm assembly	1	29	270-934/2	screw, rear needle guard	1
13	PM.270-078/2	coupling, presserfoot lifter lever	1	30	092-D-11	oil-wick	1
14	270-085/1	stop-pin, presserfoot lifter lever travel	1	31	032-L-10,5	screw, needle plate securing	2
15	270-091	lock-ring, for item 14	1	32	PM.270-081/1	shaft, presserfoot arm, complete	1
16	004-L-7	screw, presserfoot chaining finger	1	33	270-073	tube, protection	1
17	270-183	block	1				
						On request:	
						270-188	Tab. 76
						001-A-1,2	" 76
						G.270-1812	" 75
						PM.270-1832	" 75
						G.274-401	" 75
						270-1142	" 75
						270-1143	" 75
						270-114	" 75

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REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	PM.270-208/3	side cover, with bushing	1	35	007-F-14	screw, cover	1
2	007-H-25	screw, top cover	1	36	270-221	spring, front cover	1
3	PM.270-205/3	cover, with thread take-up bushing	1	37	054-D-4	nut, retaining	1
4	270-241/2	oil-cap, with window	1	38	270-226	screw, front cover securing	1
5	270-965/2	packing ring, oil-cap	1	39	G.270-242/3	plate, complete with filters, tubes	1
6	270-983	screw, cover securing	1	40	028-E-10	screw, bottom plate securing	4
7	PM.270-218/2	hinge assembly with guide tubes	1	41	270-212	spring, workplate latch	1
8	007-R-7,5	screw, securing oil-cap plate	7	42	001-D-6	screw, spring securing	1
9	G.270-245/4	oil-cap plate	1	43	001-D-4,5	screw, spring securing	1
10	270-246	oil-cap plate gasket	1	44	270-718	collar, workplate pin	1
11	270-053/1	cap, spring adjustment	1	45	017-E-4,5	screw, collar	2
12	032-F-9,5	set-screw, stop cam	1	46	270-030	plug, differential shaft seal	1
13	605-412	stop cam	1	47	270-973	screw-bolt, machine assembly, short	1
14	270-094	lever, presserfoot locking	1	48	270-715	set-screw for adjustment cap 270-093/1	1
15	270-701	snap-ring	1	49	270-129/1	cap, guide pin	1
16	270-086	spring, presserfoot release rod	1	50	270-731/1	plug, attachment Waseal	2
17	270-078	pin, presserfoot release lever	1	51	270-231	gasket	1
18	270-092	spring, presserfoot pressure	1	52	01205/A	screw, front cover plate securing	3
19	270-993	set-screw	1	53	270-913	pin, front cover plate	1
20	270-995	screw, top cover securing	2	54	270-214	set-screw, side cover plate	1
21	270-066/2	plug, looper bushing	2	55	057-E-4	nut, set-screw	1
22	270-303	nipple, cover	1	56	005-M-10	screw, side flange, left	3
23	026-E-10	screw, seal plug securing	1	57	270-610	flange, left side	1
24	026-C-7	screw, splash guard securing	2	58	270-524	gasket, sealing disc	1
25	270-247/1	splash guard	1	59	270-523/1	sealing disc	1
26	PM.270-095/3	shaft, pressurefoot pressure	1	60	001-D-10	screw, sealing disc	2
27	G.270090/1	release rod, presserfoot	1	61	G.270-216/2	cover plate assembly, front	1
28	270-248/1	plug, seal	1	62	270-030/2	screw, plug	1
29	270-940	plug, screw	1	63	270-175	nameplate, front cover plate	1
30	PM.270-210/3	work-plate assembly	1	64	270-174	nameplate, tensioning disc housing cover	1
31	270-972	screw-bolt, machine assembly	1	65	230-293	set-screw, tie-rod	1
32	270-730/2	screw, plug	1	66	270-090/1	block, tie-rod	1
33	270-220/1	pin, front cover plate	1	67	270-110	tie-rod	1
34	PM.270-217/2	cover, looper and take-up	1	68	PM.270-301	splashguard assembly	1
				69	016-E-5,5	screw	1

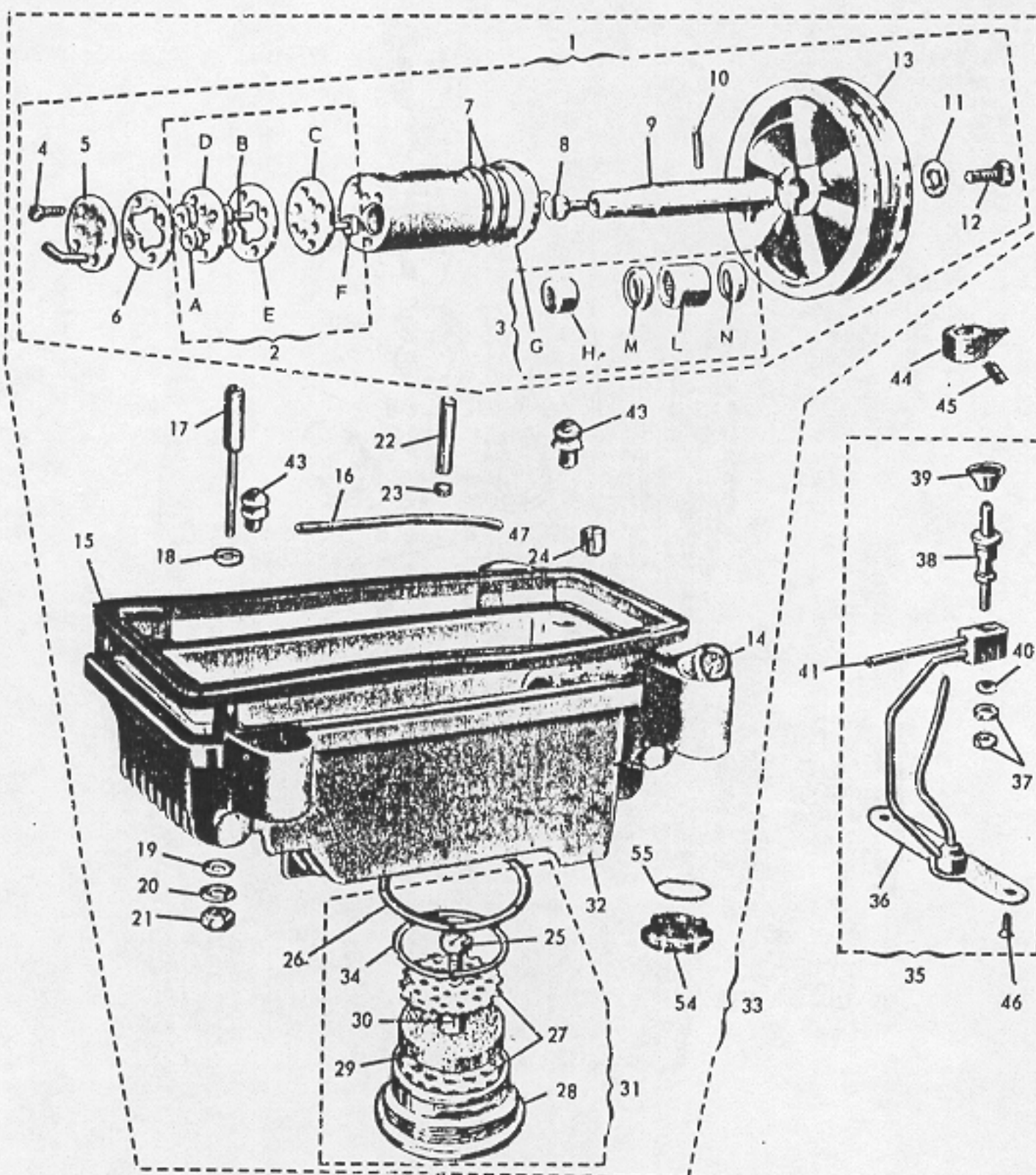
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REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-941	screw, thread guide tube securing	1	13	004 A-3,2	screw, bracket securing	1
2	PM270-263/1	tube, needle thread guide	1	14	270-276/1	bracket, looper	1
3	270-274/4	take-up, needle thread	1	15	270-275/1	thread guide, secondary looper	1
4	270-264	needle thread guide	1	16	032 A-6	screw, thread guide securing	1
5	270-265	bush, upper thread guide	1	17	272-232/1	spring, primary looper	2
6	270-265/1	bush, upper thread guide	2	18	270-233	bushing, upper tension	3
7	270-266	bush, lower thread guide	2	19	202558-2-00	nut, tension adjusting	3
8	270-268	tube, lower thread guide	2	20	603-031	disc, tension	6
9	780201-0-00	machine type nameplate	1	21	270-230	pin, tension screw	3
10	270-269/2	take-up, primary looper	1	22	270-232/2	spring, needle	1
11	004 L-8	screw, take-up securing	1	23	004 N-5,5	screw, needle take-up securing	2
12	270-270/2	take-up, secondary looper	1	24	202556-0-00	cup, tension disc	3

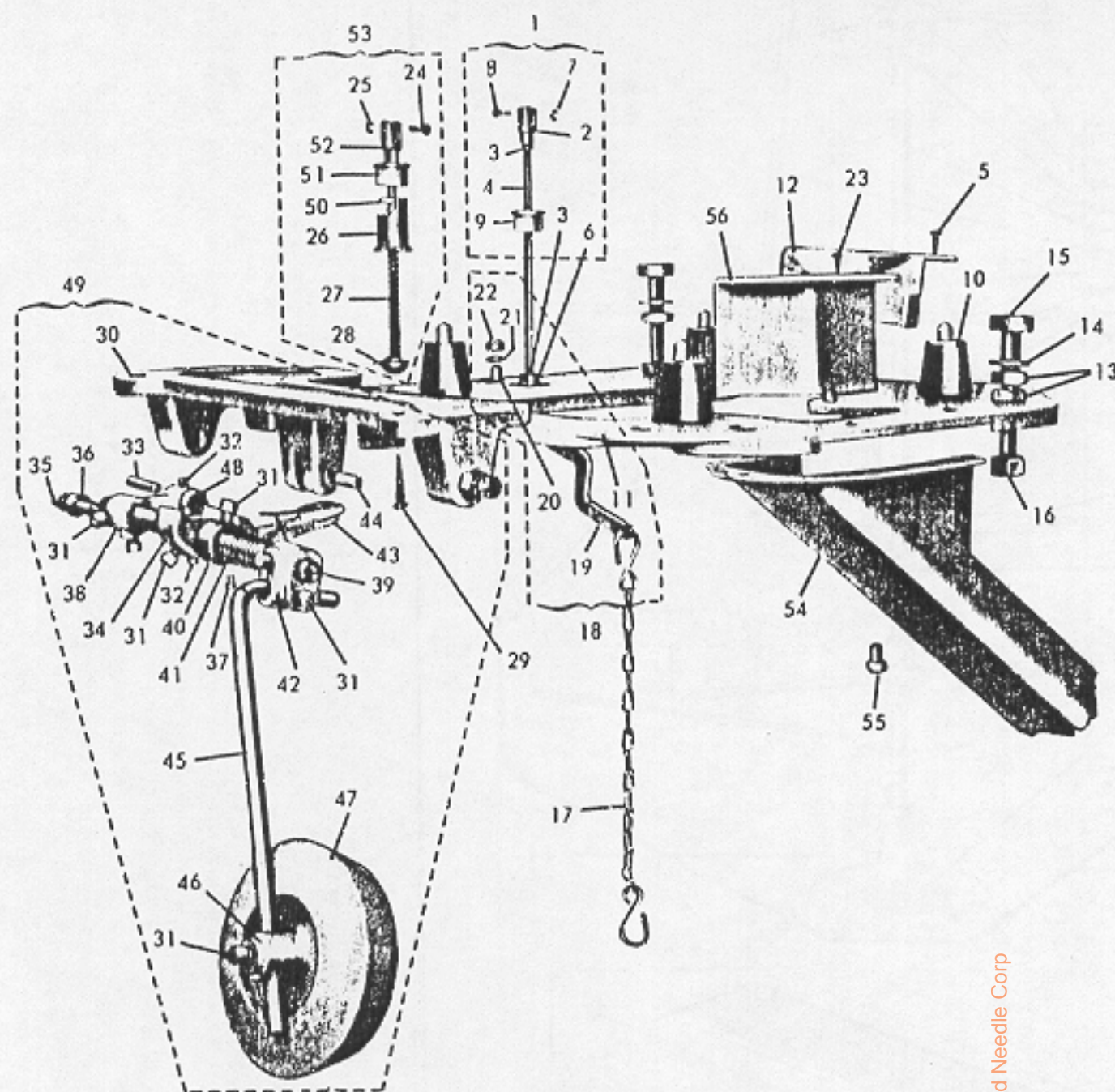
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10



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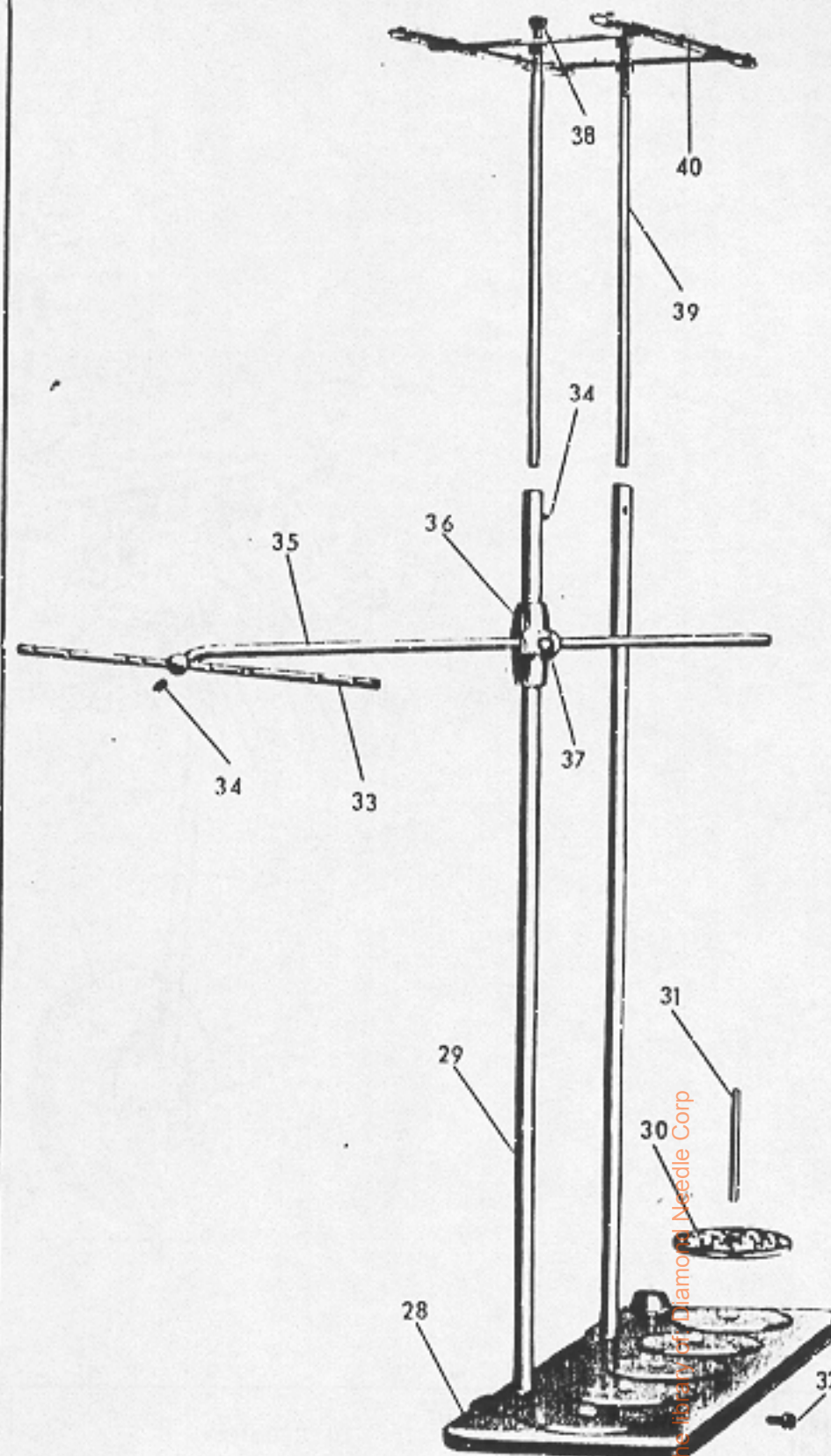
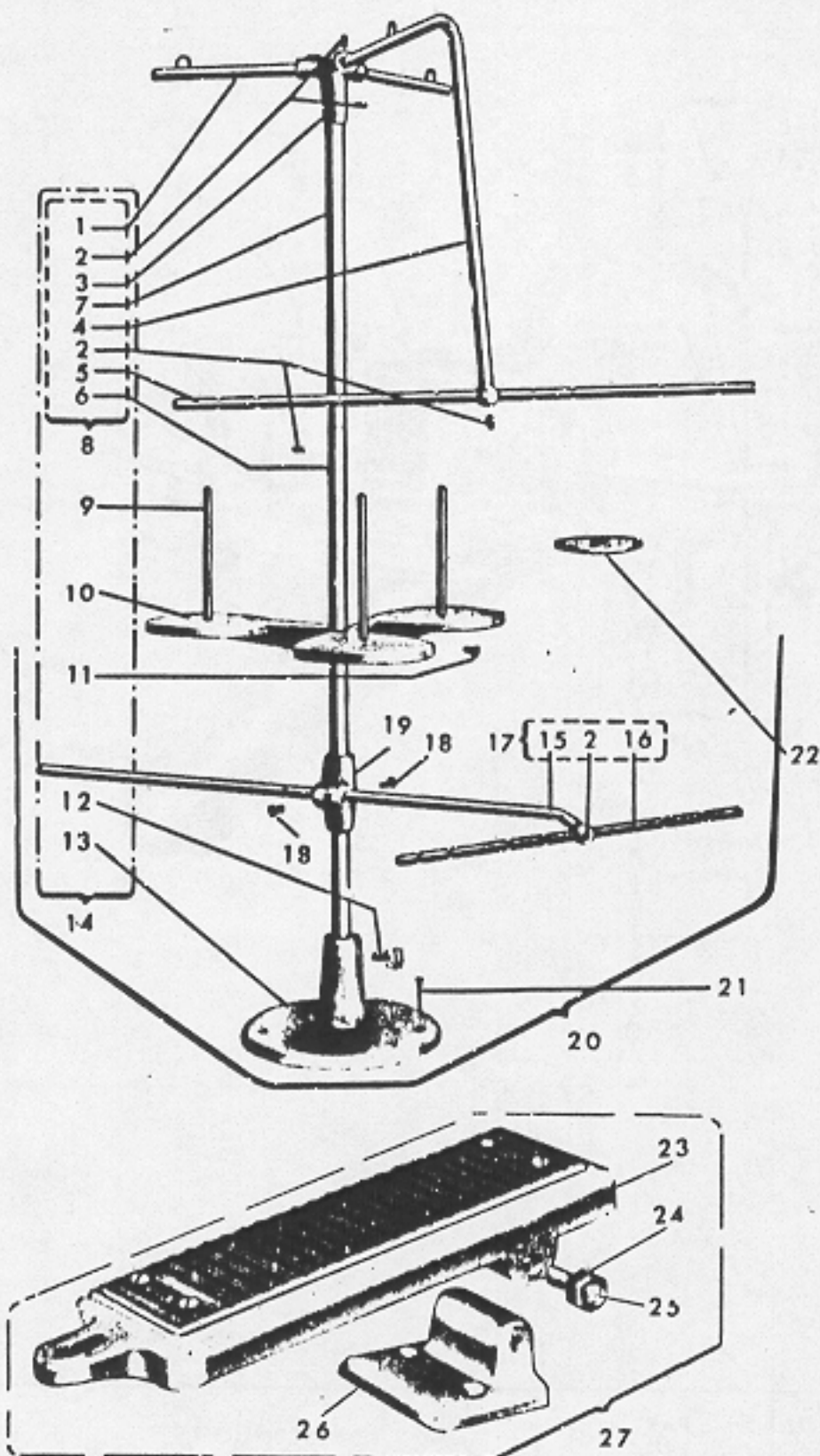
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.270-816/1	oil pump assembly	1	34	270-966/1	gasket	1
2	G.633-833/1	gear assembly	1	35	G.270-646	oil distributor assembly	1
3	PM.270-816/1	pump unit	1	36	PM.270-643/1	oil distributor	1
4	633-812	screw	1	37	057-A-3	nut	2
5	PM.633-817/1	cover	1	38	270-550	valve	1
6	633-818/1	washer	1	39	270-551	gasket	1
7	633-711/1	gasket	2	40	270-734/1	flexible washer	1
8	270-824/1	worm	1	41	270-652	junction tube	1
9	270-823/1	shaft	1				
10	633-708	flexible pin	1	43	633-826/1	coupling tube, oil pump	2
11	633-707	cup spring	1	44	270-645	pointer, oil distributor	1
12	039-G-10	screw, pulley securing	1	45	015-B-2,5	grub-screw, pointer	1
13	270-810/2	pulley, oil pump	1	45	028-E-10	screw	2
14	633-959/1	oil level window	1				
15	270-808/1	gasket	1				
16	633-842	tube	1				
17	270-811/1	pin	2				
18	270-946	gasket	2				
19	270-947	gasket	2				
20	065-L-5	washer	2				
21	059-G-6	nut	2				
22	270-831/1	tube	1	54	270-432/1	current plug	1
23	270-836	felt pad	1	55	270-430	rubber gasket	1
24	017-H-12	grub-screw	1	A	633-821/2	gear wheel	4
25	007-L-20	screw	1	B	633-822/2	gear wheel pin	1
26	633-966	gasket	1	C	633-819	gear plate, side	1
27	270-828/1	disc	1	D	633-833	gear plate, inner	1
28	270-996/2	plug	1	E	633-818/1	washer, inner	1
29	270-827/1	felt disc	1	F	633-834/1	drive shaft	1
30	633-925	spacer	1	G	270-816/1	housing, pump	1
31	G.270-996/2	plug, oil sump	1	H	633-814	roller housing	1
32	270-001/2	oil sump	1	L	633-813	roller housing	1
33	205520-5-00	oil pump and sump assembly complete	1	M	670-702	seal ring	2



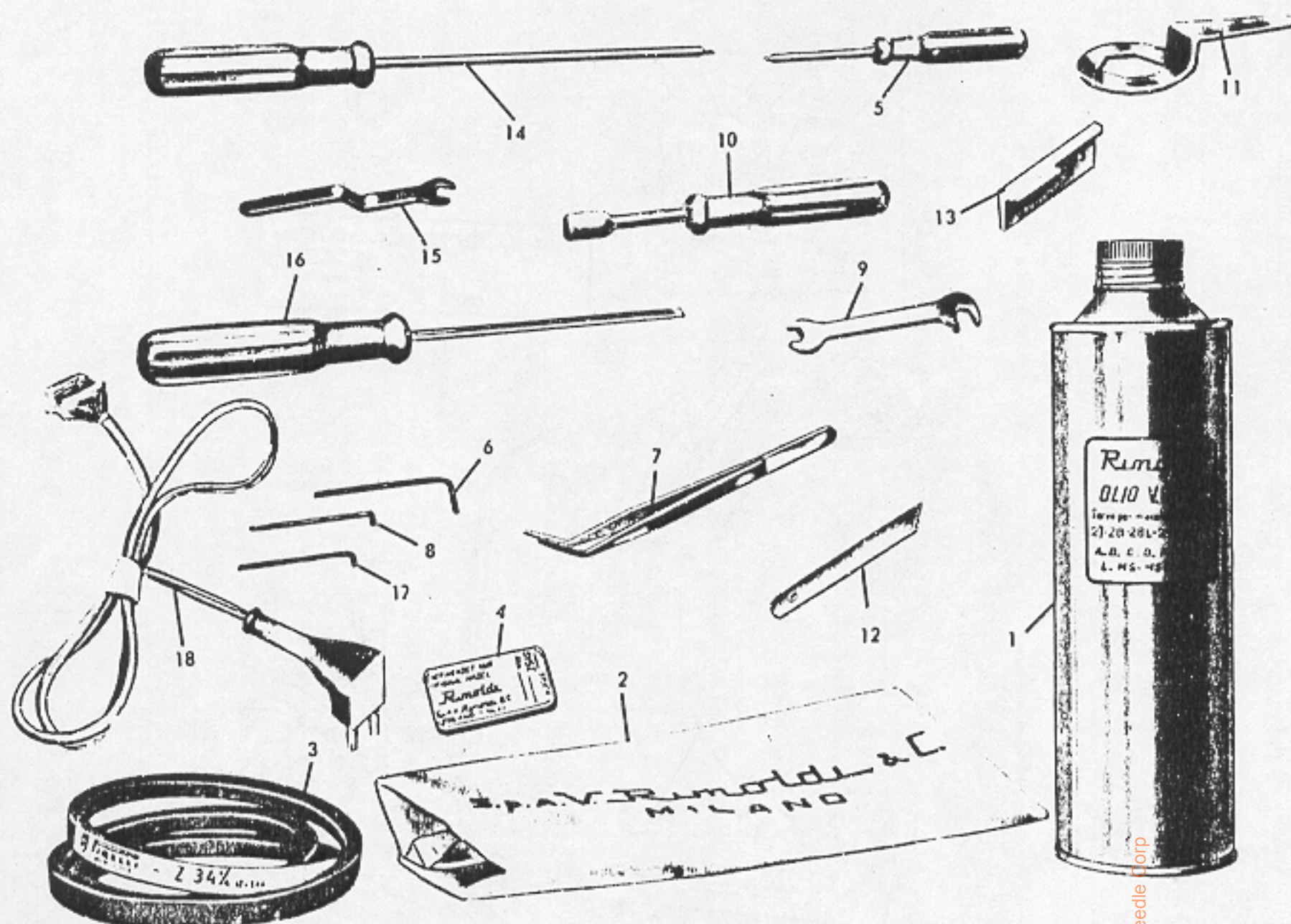
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.270-583	tie-rod assembly, presserfoot lifter lever	1			ON REQUEST	
2	270-585	coupling, presserfoot lifter lever upper	1				
3	059-A-5	lock-nut, lifter lever tie-rod	2	23	270-459	bolts, chute securing	9
4	270-583	rod, presserfoot lifter lever	1	24	270-552	pin	1
5	270-459	lock-screw, flywheel guard	7	25	270-701	snap-ring	1
6	270-557	coupling, presserfoot lifter lever	1	26	270-553	bushing, lower differential rod	1
7	270-701	snap-rings	3	27	270-554	spring, differential rod	1
8	270-558	pin, for coupling	2	28	270-555/1	rod, differential lever	1
9	270-552	bushing, upper plate	1	29	15 22 x 35	screw, knee control securing	4
10	270-004	rubber mounts, machine	4	30	270-570	base, knee control	1
11	PM.270-005/3	bearing plate, with pins	1	31	038-M-9	screw, knee control securing	9
12	270-588	guard, flywheel	1	32	005-G-6	set-screw	2
13	058-M-10	nut, machine bearing screw	8	33	270-580	pin, for link	2
14	057-H-10	washer, machine bearing plate	4	34	270-579	stop, knee control	1
15	270-971	screw, machine bearing plate	4	35	270-998	screw, knee control	2
16	051-L-10	nut, machine plate mounting bolt	4	35	059-P-8	nut, knee control screw	2
17	PM.1159	chain with hook	1	37	005-L-11	set-screw	1
18	G.270-005/3	machine bearing plate	1	38	270-578	knee control push lever	1
19	270-586/1	lever, presserfoot lifter	1	39	270-571	shaft, knee control	1
20	270-584	pivot, presserfoot lifter lever	1	40	270-720	collar, knee control spring pressure adjusting	1
21	065-L-3	washer	3	41	270-575	spring, knee control disc return	1
22	059-H-3	nut, presserfoot lifter lever pivot	1	42	270-572	coupling, knee control rod	1
				43	270-573	rocker, knee control	1
				44	270-581	pin, knee control rocker	1
				45	270-573	rod, knee control	1
				46	270-574	disc, knee control	1
				47	270-582	pad, knee control disc	1
				48	270-577	joint, knee control	1
				49	G.270-570	knee control assembly	1
				50	034-E-5	washer, differential actuator rod	1
				51	270-552	bushing, upper differential rod	1
				52	270-577	attachment	1
				53	G.270-553	rod, differential lever actuator	1
				54	270-590/1	waste chute (long - right)	1
				55	270-590/2	waste chute (left)	1
				56	001-G-10	screw, waste chute securing	3
				57	270-589-1	waste chute - short	1

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12



REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
		SUPPLIED WITH HEAD ONLY				SUPPLIED WITH STAND	
1	PM.250-133/1	rod, thread guide	2	28	409/2	thread spool	1
2	016-F-6,5	grub-screw	8	29	910-143	upright, main	2
3	250-140	connector-piece, rod	1	30	569	pad, thread spool	5
4	PM.250-148/1	sustaining rod, thread guide rod (upper)	1	31	1145	pin, thread spool	5
5	250-137	rod, thread guide	1	32	001-G-10	cap-screw	5
6	250-143	upright, main lower	1	33	270-157	rod, thread guide	1
7	250-130	upright, main upper	1	34	016-F-5	grub-screw	1
8	G.250-137	frame, thread guide (assembly)	1	35	270-158/1	bar, thread guide rod sustaining	1
9	1146	pin, thread spool	3	36	605-937	bracket, thread guide rod sustaining bar	1
10	01142	plate, thread spool	1	37	605-980	lock-screw	2
11	001-G-10	screw, plate securing	1	38	1145	lock-nut, thread guide securing	4
12	001-G-12	screw, rod securing	1	39	910-144	upright, top section	2
13	01141	base, thread stand	1	40	G.497	thread guide assembly	1
14	AS.250-140	thread stand assembly	1				
15	270-158/1	bar, thread guide sustaining (lower)	1				
16	270-157	rod, thread guide	1				
17	G.270-157	bar, sustaining, with thread guide rod	1				
18	605-980	lock-screws	3				
19	605-937	bracket	1				
20	AS.270-140	thread stand assembly complete	2				
21	TS.20 x 30	screw, thread stand securing	3				
22	569	pad, thread spool	1				
23	PM.910-914	pedal	2				
24	053-H-8	nut, pedal	2				
25	910-964	screw, sharp	1				
26	910-934/1	base, pedal	1				
27	G.901-914/1	pedal assembly complete	1				
28							



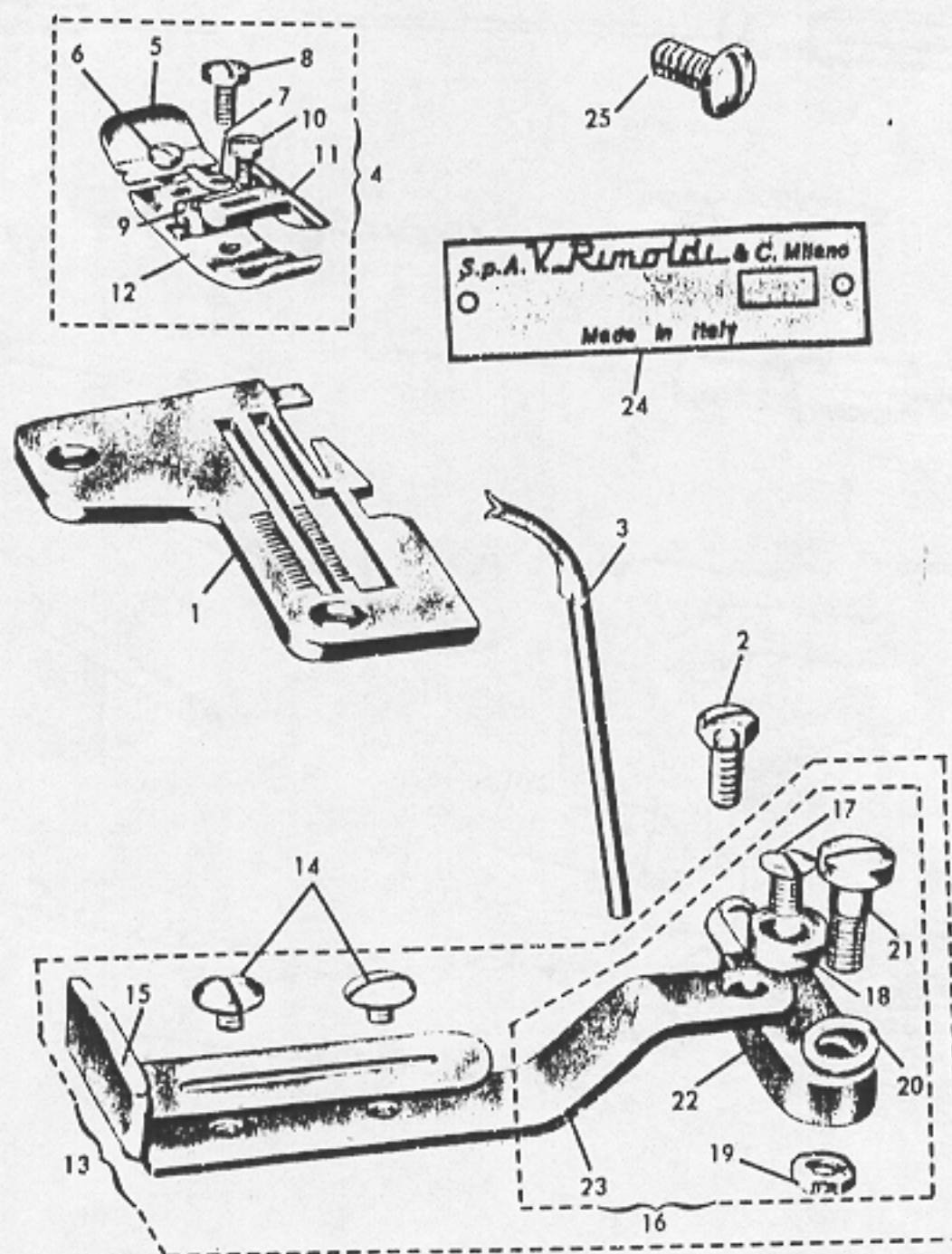
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	VR.504	oil, 1 quart can	1	10	270-741	pipe-wrench, 9/32"	1
2	1175	machine cover	1	11	539-M-745	wrench for oil sump plug	1
3	280-155	vee-belt	1	12	270-113/1	knife, lower	1
4	RIM.27	needle, RIM.27	1	13	270-112	knife, upper	1
5	1151/2	screwdriver	5	14	01160/2	screwdriver	1
6	533-742	hex. wrench, 1/8", for 270-715	1	15	270-745	hex. wrench, 9/32"	1
7	1158	pincers, threading	1	16	01161/2	screwdriver	1
8	641-LY-743	hex. wrench 3/32"	1	17	270-743	hex. wrench, 5/64"	1
9	1156/1	wrench, double-ended	1	18	270-431	power cable and plug	1
10						On request: 270-675/1	
						Tab. 75	

III. TECHNICAL DATA BY SUB-CLASS

HEAD No.	TECHNICAL CHARACTERISTICS							SPECIFIC USES
	No. threads	Width of bight	Diff. pos.	S P E E D		Knives	Sp. attach- ments on req.	
				No. of revs. 1" max.	St. per inch			
227-22-03	3	3/32"	max.	6000	6-20	yes	107	Same as 227-22-02, but with attachment to turn the edges of the fabric downwards - with knee press control.
227-22-04	3	5/64" 3/32"	max.	6000	6-20	yes	107	For warpknit fabrics, with attachment to ruffle the lower fabric - with knee press control.
227-22-05	3	3/32"	max.	6000	6-20	yes	107	Same as 227-22-04, but with attachment to turn the edges of the fabric downwards - with knee press control.
SHIRTING WITH APPLICATIONS AND INSERTIONS								
227-23-01	3	3/16"	max.	6000	6-20	yes	--	For medium and light fabrics and for linen. With attachment to ruffle the lower fabric and attachment to insert a decorative piping, formed by a doubled strip of fabric with cord inside - with knee press control.
227-23-02	3	8/64"	max.	6000	6-20	yes	---	Same as 227-23-01, but for linen in general, with knee press control.
227-23-03	3	5/64" 3/32"	max.	6000	6-20	yes	107	For attaching lace without trimming the selvedge, for medium and light warpknit fabrics, with kneepress control and with attachment to ruffle the lower fabric.
227-23-04	3	3/32"	max.	6000	6-20	yes	107	Same as 227-23-03, but with attachment to turn the edges of the fabric downwards - with kneepress control.
227-23-05	3	3/32" 8/64"	max.	6000	6-20	yes	107	
227-23-08	3	3/32"	max.	5000	6-20	yes	---	Same as 227-23-01, but for warpknit fabrics - with kneepress control.
OVEREDGING								
227-28-01	2	1/8" 1/4"	zero	7000	8-14	yes	109	For serging and/or overedging light and medium woven and knit fabrics where the use of the differential is particularly requested.
			---	---	---		106	
			---	---	---		107	
			---	---	---		120	
			---	---	---		121	
227-28-02	2/3	1/8" 1/4"	zero	7000	8-14	yes	121	Same as 227-28-01, but with looper to work also with 3 threads.
			---	---	---		200	
			---	---	---		201	
			---	---	---		902	
			---	---	---		115	
			---	---	---		109	
			---	---	---		106	
			---	---	---		107	
			---	---	---		115	
			---	---	---		120	

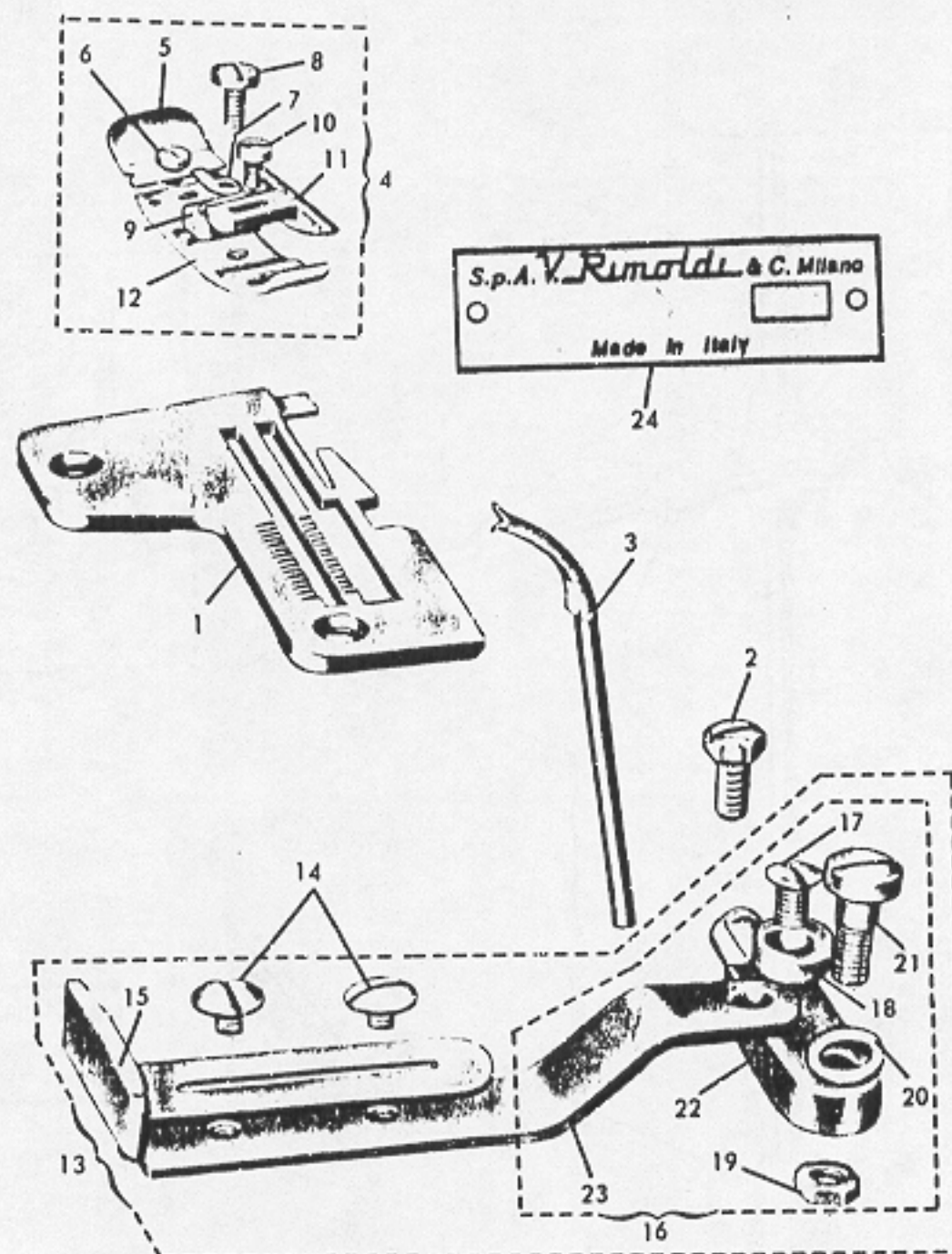
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14



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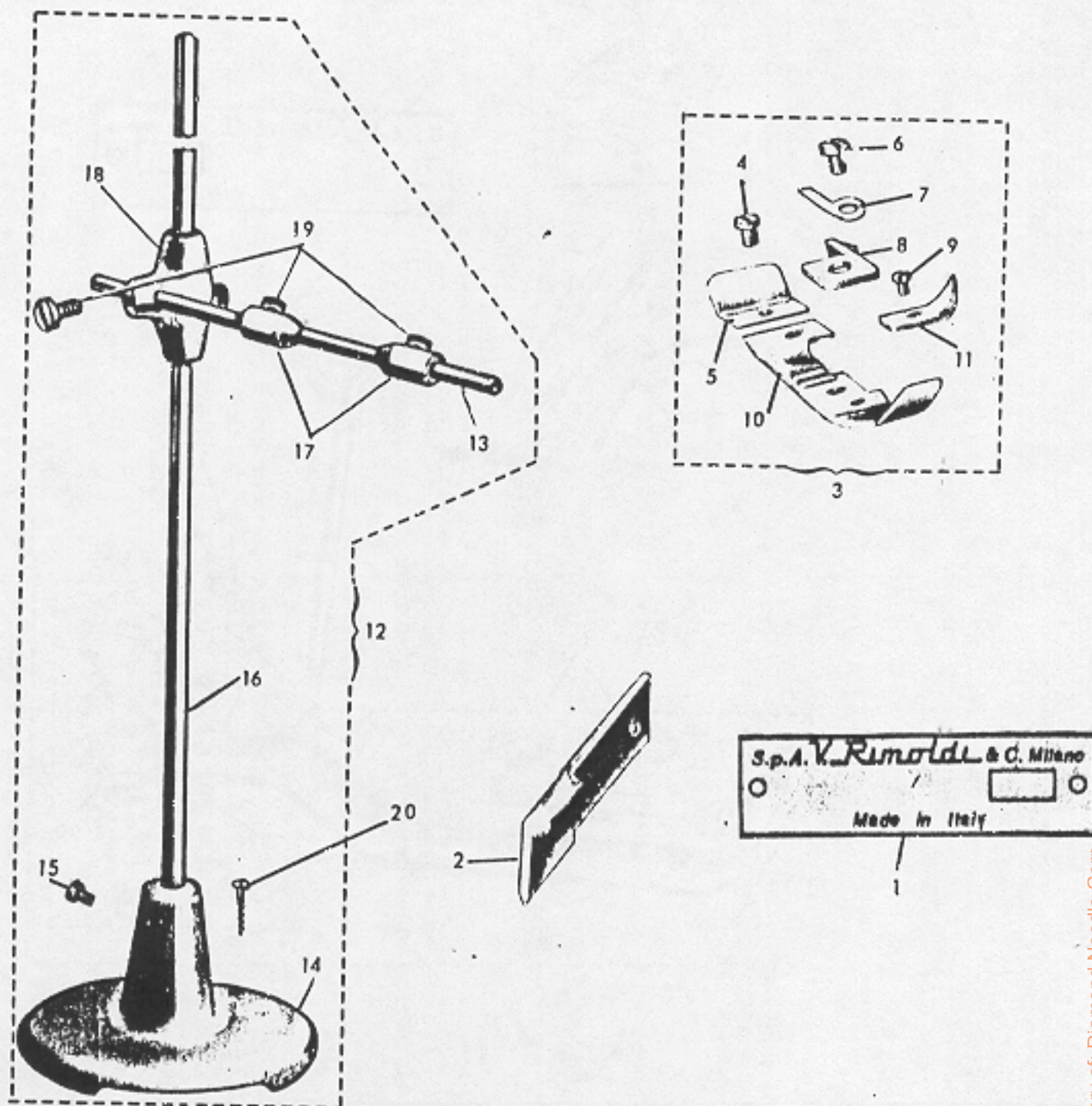
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-1142	needle plate, bight width 11/64"	1	14	255-404	screws	2
2	039-R-8,5	screw, guide plate securing	1	15	PM.273-B-403	guide	1
3	270-D-074/1	looper, eyeless secondary	1	16	G.276-B-403/1	support, complete	1
4	G.274-B1-1811	presserfoot assembly complete	1	17	032-F-5,5	screw, for eccentric	1
5	270-185	presserfoot chaining plate	1	18	605-412	eccentric	1
6	001-A-3,2	screw, chaining plate securing	1	19	057-E-4	nut	1
7	270-196	lug, chaining plate	1	20	276-B-412	cup spring	1
8	004-L-7	screw, securing chaining finger	1	21	011-E-13	collet screw	1
9	270-191	chaining finger	1	22	276-B-417/1	bearing plate, guide	1
10	001-A-5,5	screw, guide retaining	1	23	276-B-407/1	swivel support	1
11	274-B1-1921	guide	1	24	7804-10-0-00	machine class plate	1
12	276-B-184	shoe, presserfoot	1	25	003-M-7	screw, cap	1
13	AS.276-B-403/1	guide, swivel	1				
						On request:	
						270075	
						Tab. 75	



REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-1142	needle plate, bight width 11/64"	1	14	255-404	screws	2
2	039-R-8,5	screw, guide plate securing	1	15	PM.276-B-403	guide	1
3	270-D-074/1	looper, eyeless secondary	1	16	G.276-B-403/1	support, complete	1
4	G.274-B1-1811	presserfoot assembly complete	1	17	032-F-6,5	screw, for eccentric	1
5	270-185	presserfoot chaining plate	1	18	505-412	eccentric	1
6	001-A-3,2	screw, chaining plate securing	1	19	057-E-4	nut	1
7	270-196	lug, chaining plate	1	20	276-B-412	cup spring	1
8	004-L-7	screw, chaining finger securing	1	21	011-E-13	collet screw	1
9	270-191	chaining finger	1	22	276-B-417/1	bearing plate, guide	1
10	001-A-5,5	screw, guide retaining	1	23	276-B-407/1	swivel support	1
11	274-B1-1921	guide	1	24	780411-0-00	machine class plate	1
12	276-B-184	shoe, presserfoot	1				
13	AS.276-B-403/1	guide, swivel	1				
					On request:		
					270-075	primary looper	Tab. 75
					27-277-0745	secondary looper	" 75

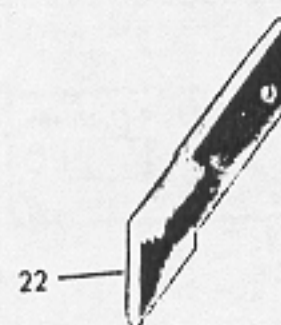
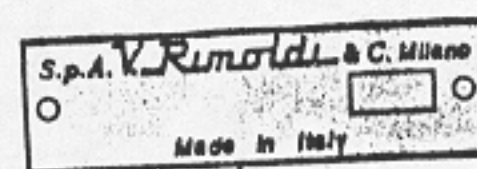
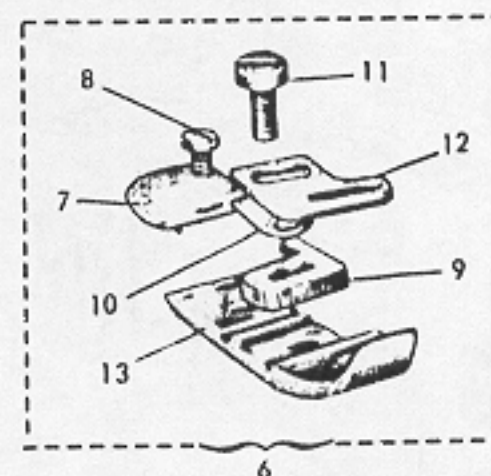
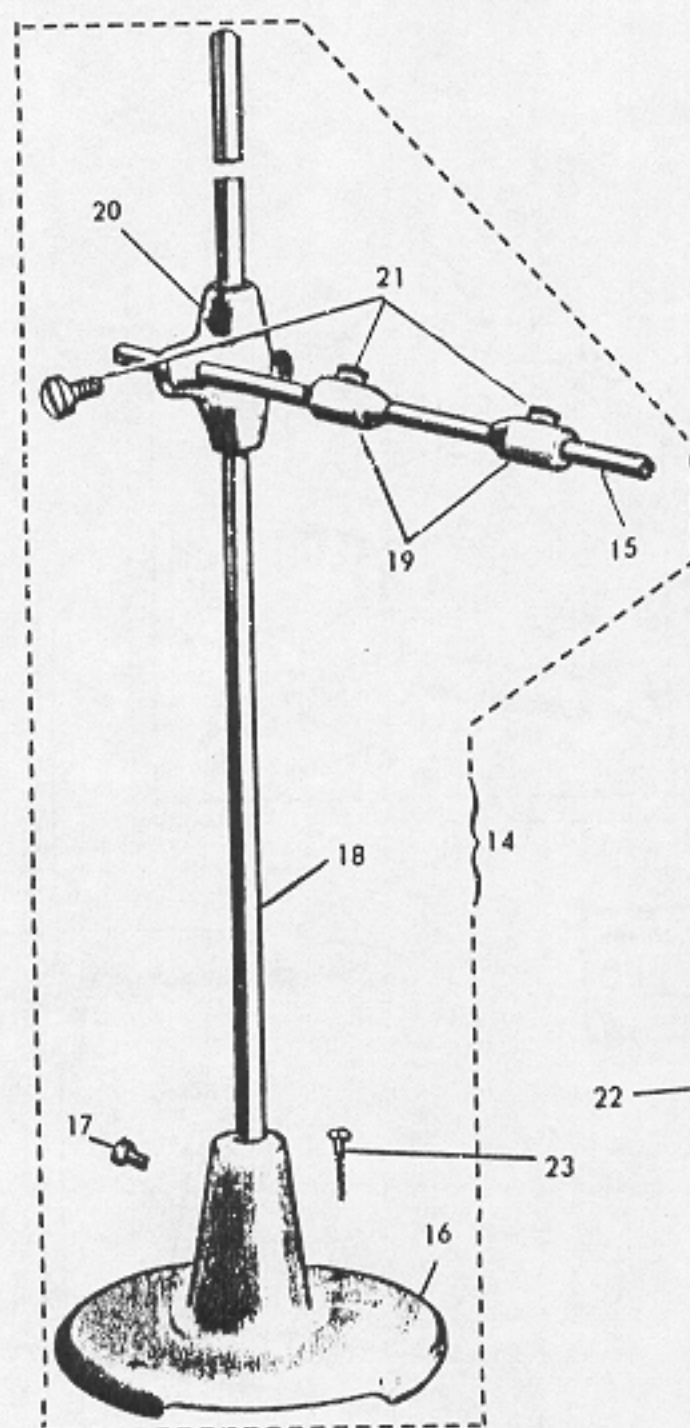
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16



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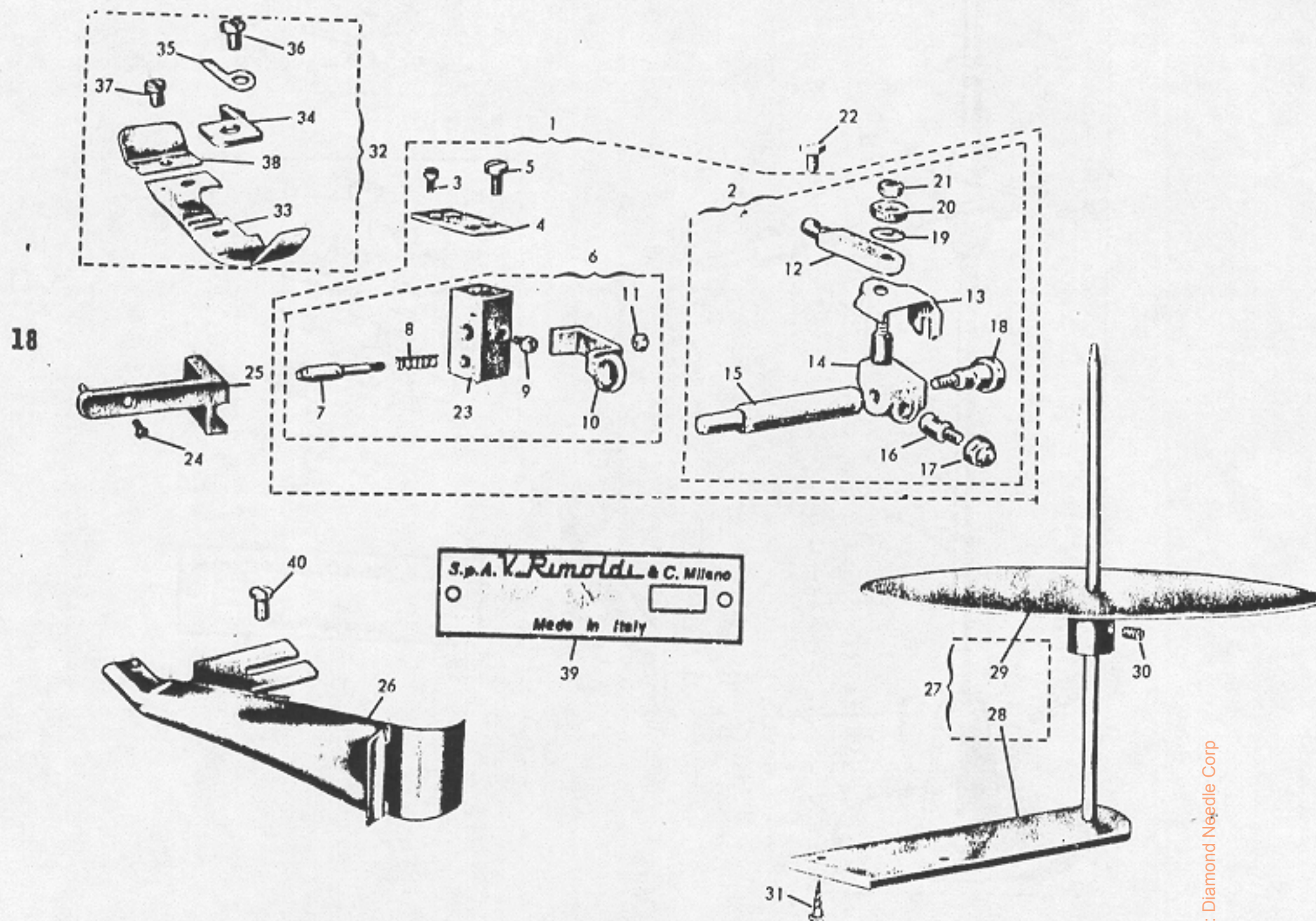
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	780430-0-00	machine class plate	1	11	270-183	stop	1
2	279-112	knife, upper	1	12	G.250-R-9373	spool stand, complete	1
3	G.270-E-181	presserfoot, complete	1	13	605-144	bar, top	1
4	001-A-3,2	screw, chaining plate securing	1	14	01141	base	1
5	270-185	chaining plate	1	15	001-G-12	screw	1
6	004-L-7	screw, chaining finger securing	1	16	605-143	upright	1
7	270-196	lug, chaining plate	1	17	605-723	tapered sleeve	2
8	270-E-191	finger, chaining	1	18	605-937	bracket	1
9	270-989	screw, stop securing	1	19	605-980	knurled head screw	4
10	270-184	shoe, presserfoot	1	20	TS.20x30	screw, frame securing	2
N.B. When 227-00-01 is changed to 227-29-01 on customer's premises install only chaining finger 270-E-191 and not complete presserfoot G.270-E-181.							



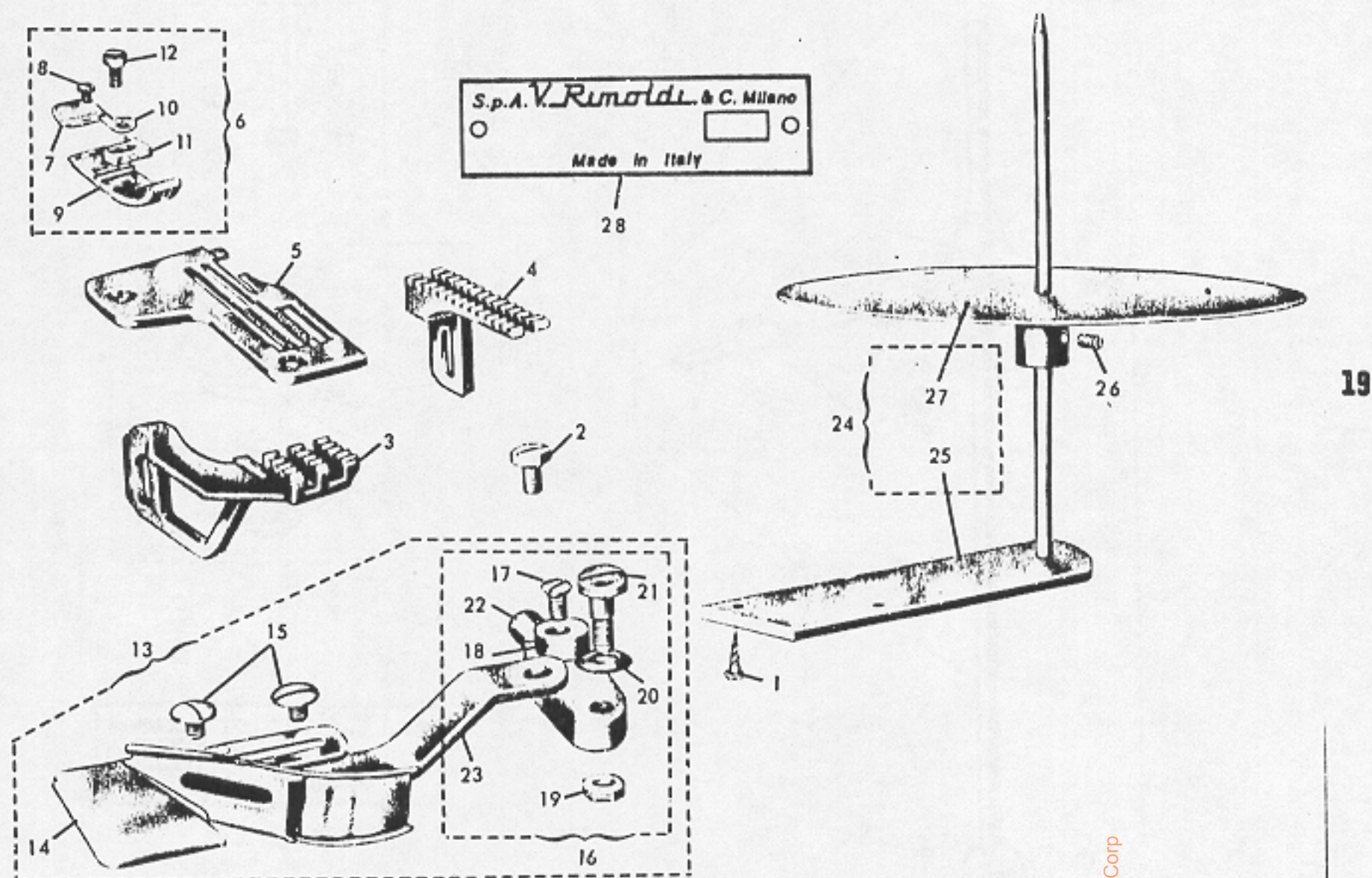
17

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	780431-0-00	plate, machine class	1	13	270-EF-184	shoe	1
2	PM.270-R-267	guide, reinforcing tape, complete	1	14	G.250-R-9373	elastic reel stand	1
3	057-A-3	nut	1	15	605-144	bar, top	1
4	270-R-267	guide, reinforcing tape	1	13	01141	base, elastic reel stand	1
5	001-C-5,5	screw	1	17	001-G-12	screw	1
6	G.270-EF-181	presserfoot, complete	1	18	605-143	upright	1
7	270-185	plate, chaining	1	19	605-723	taper sleeve	2
8	001-A-3,2	screw, chaining plate securing	1	20	605-937	bracket	1
9	270-EF-191	finger, chaining	1	21	605-980	knurled head screw	4
10	270-196	lug, chaining plate	1	22	279-112	knife, upper	1
11	004-L-8	screw	1	23	5.20 x 30	screws, frame securing	2
12	270-EF-0/1	plate	1				

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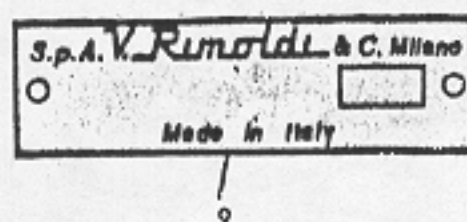
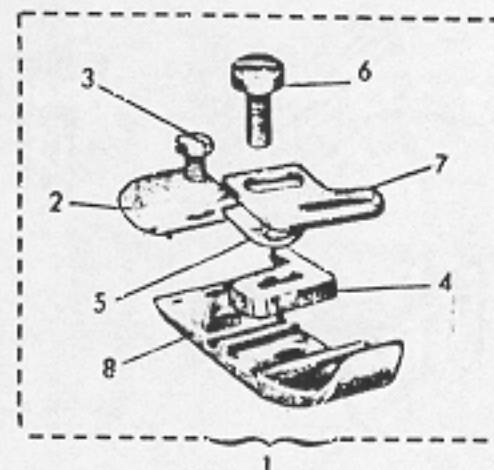
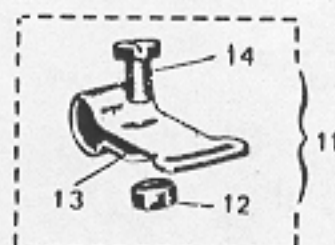
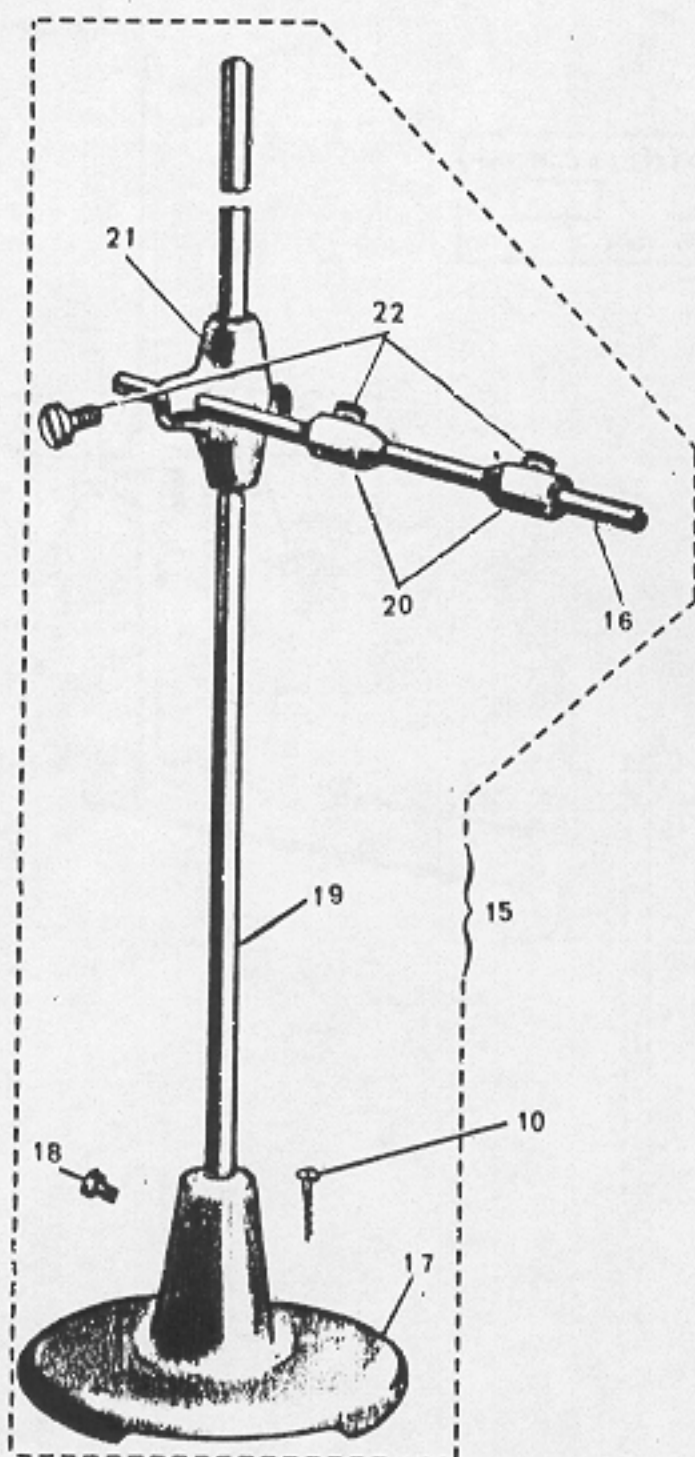


REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.270-F-401	guide carrier base	1	21	27.53-2211	nut	1
2	G2701PDB3792	base	1	22	039-R-8,5	screw, base securing	1
3	001-E-6	screw	2	23	2701PD34083	shirring attachment housing	1
4	270-F-402	shirring plate	1	24	001-D-7	screw, angle stop securing	1
5	2726PDPO2055	screw	2	25	PM2701PD417/1	angle stop	1
6	G2701PDB4083	shirring attachment mounting block	1	26	PM.270-F-113	fabric guide	1
7	2791PDB4422	push rod	1	27	G2726PD309375	reel stand	1
8	27.01-PD-444	spring	1	28	PM.602-141/1	base-plate with upright	1
9	001-C-5,5	screw	2	29	PM2726PD301425	plate reel	1
10	2701PDB2232	lever	1	30	017-E-7	grub-screw	1
11	27.01-PD-933	nut	1	31	TS. 20 x 30	wood screw	2
12	27.53-4172	bearing plate	1	32	G.2701-PD	presser foot, complete	1
13	27.53-2201	latch	1	33	27.01-PD-184	shoe, presserfoot	1
14	27.53-4071	pivot	1	34	270-191	finger, chaining	1
15	27.01-PDB-4012	shaft	1	35	270-195	lug, chaining plate	1
16	27.53-4181	pawl	1	36	004-L-7	screw	1
17	27.01-PD-980	nut	1	37	001-A-1,2	screw	1
18	27.53-4251	screw	1	38	270-185	chaining plate	1
19	27.53-4121	washer	1	39	780250-0-00	machine class plate	1
20	27.53-4261	screw-nut	1	40	001-E-7	screw, guide securing	1

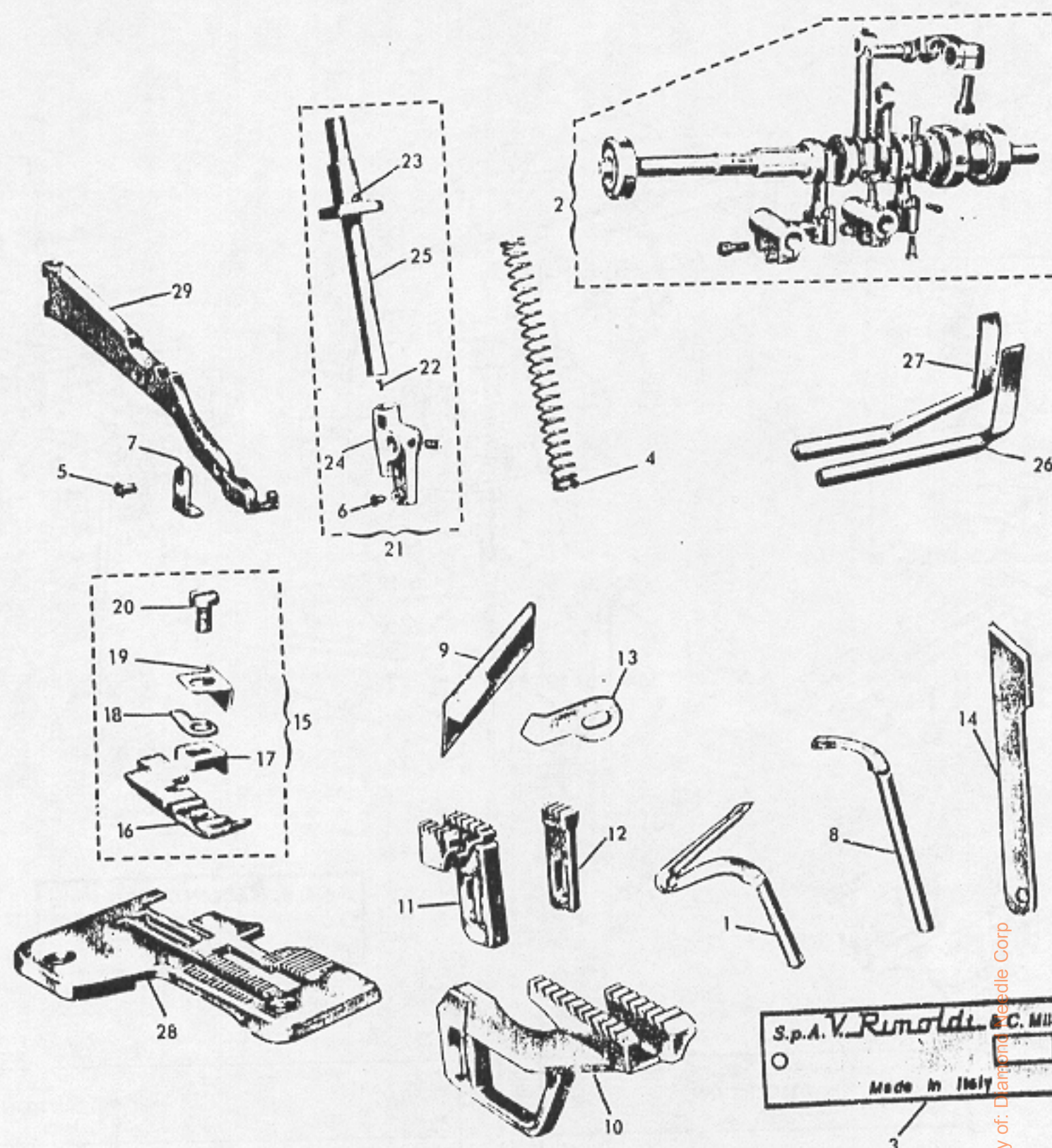


REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	TS.20 x 30	screw, reel stand securing	2	15	255-404	screws	2
2	039-R-8,5	screw, guide securing	1	16	G.276-B-403/1	bearing block, complete	1
3	270-H-050	feed dog, front	1	17	032-F-6,5	screw, eccentric	1
4	270-H-051	feed dog, rear	1	18	605-412	eccentric	1
5	270-H-114	needle plate, bight width 9/64" - 5/32"	1	19	057-E-4	nut	1
6	G.270-H-181	presserfoot, complete	1	20	276-B-412	cup spring	1
7	270-185	chaining plate	1	21	011-E-13	collar screw	1
8	001-A-3,2	screw	1	22	276-B-417/1	bearing block, guide	1
9	270-H-184	shoe, presserfoot	1	23	276-B-407/1	swivel arm	1
10	270-196	lug, chaining plate	1	24	G2726PDBO9375	reel stand	1
11	270-H-191	chaining finger	1	25	PM.502-141/1	base-plate with upright	1
12	004-L-7	screw	1	26	017-E-7	grub-screw	1
13	AS.270-H-413	fabric guide	1	27	PM2726PDBO1425	plate, complete	1
14	G.270-H-412	funnel guide	1	28	780340-0-00	machine class plate	1

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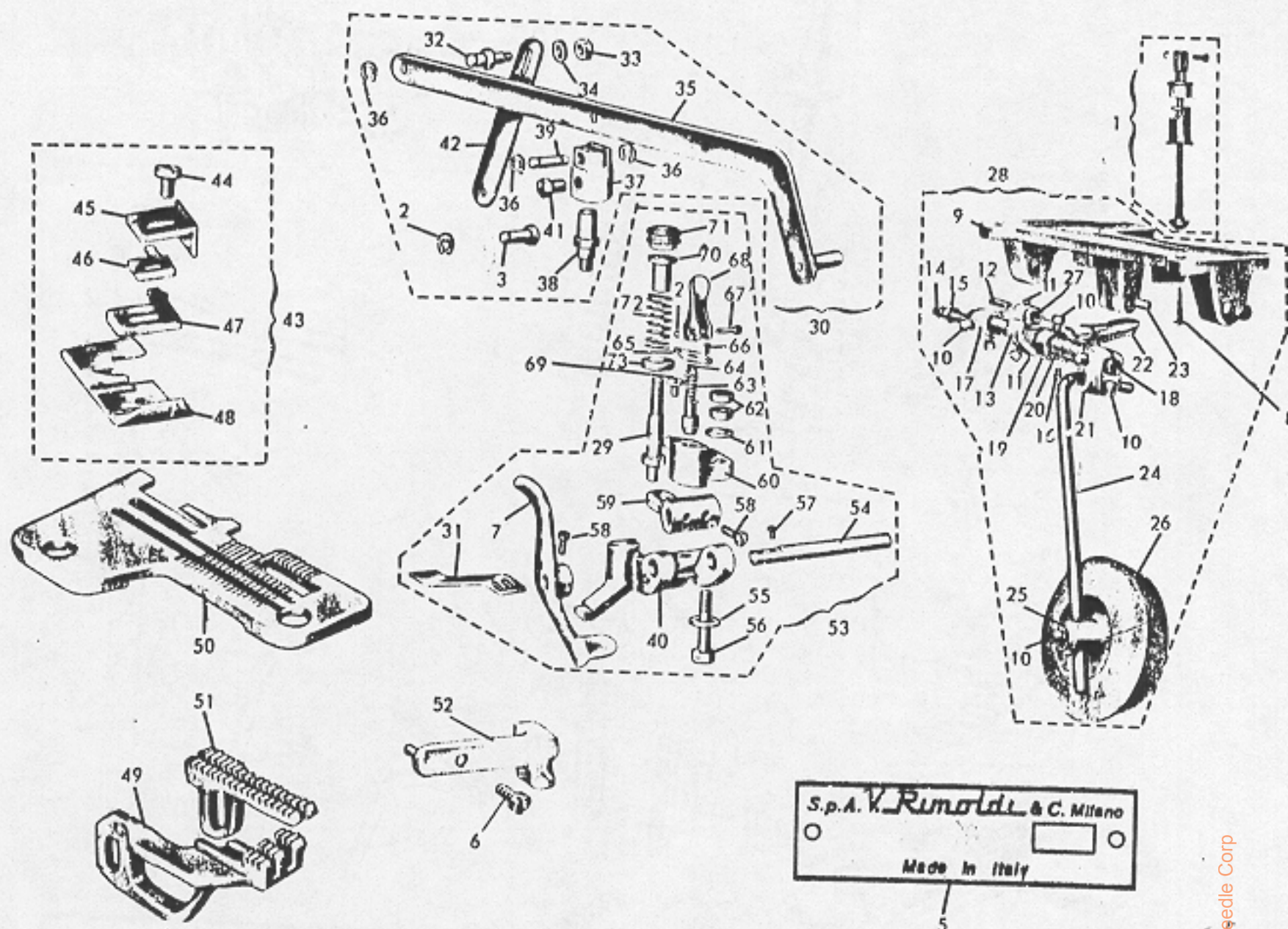
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.270-R-181	presserfoot, complete	1	12	057-A-3	nut	1
2	270-185	chaining plate	1	13	270-R-267	tape guide	1
3	001-A-3,2	screw	1	14	001-C-5,5	screw	1
4	270-191	chaining finger	1	15	G.250-R-9373	reel stand	1
5	270-196	lug, chaining plate	1	16	605-144	bar, top	1
6	004-L-8	screw	1	17	01141	base	1
7	270-R-071	plate	1	18	001-G-12	screw	1
8	270-R-184	shoe, presserfoot	1	19	605-143	upright	1
9	780251-0-00	machine class plate	1	20	605-723	taper sleeve	2
10	TS. 20 x 30	wood screw	2	21	605-937	bracket	1
11	PM.270-R-267	tape guide	1	22	605-980	knurled head screw	4



21

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-075	primary looper	1	15	277-184	shoe, presserfoot	1
2	G.27.00-8-009/3	main shaft assembly, complete	1	17	277-191	chaining finger	1
3	780205-0-00	machine class plate	1	18	270-196	lug, chaining plate	1
4	27.01-P-092	spring, presserfoot pressure	1	19	277-183	chaining plate	1
5	27.01-P-03/1	screw, angle stop	1	20	004-L-8	screw	1
6	003-A-4,5	screw, needle securing	1	21	G.27.77-025/2	needle bar and clamp	1
7	27.26-186	presserfoot angle stop	1	22	016-A-2,5	grub-screw	1
8	27.277-0745	secondary looper	1	23	092-A-10	oil wick	1
9	276-B-112	knife, upper	1	24	27.77-020	needle clamp	1
10	277-0501	feed dog, front	1	25	290-025/1	needle guide bar	1
11	277-0511	feed dog, rear	1	26	27.77-107/1	needle guard, front	1
12	277-052	feed dog, chaining	1	27	27.77-109/1	needle guard, rear	1
13	128-110	guard, upper knife	1	28	27.77-1141	needle plate, bight width 7/32"	1
14	277-113	knife, lower	1	29	28.778-076/1	lever, presserfoot lifter	1
15	G.277-181	presserfoot complete	1				
						On request:	
						270.075/2	Tab. 75
						27.277-074	" 75
						277.050	" 76
						277.051	" 75
						27.77-1142	" 76

22

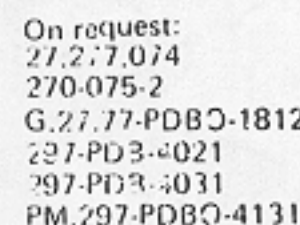


S.p.A. V. Rimoldi & C. Milano
Made in Italy

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.270-556	actuator rod, differential - assembly	1	33	27.01-PDB-519	stud, lifter lever mounting	1
2	270-701	snap ring	2	39	27.01-PDB-520	pin, yoke	1
3	27.01-PDB-558	stud, securing	1	40	297-PDB-401	base, shirring attachment	1
5	780360-0-00	machine class plate	1	41	038-C-7	screw, securing	1
6	001-D-7	screw, block securing	1	42	27.01-PDB-516	link, rear	1
7	PM.297-PDB-406	lever, shirring blade lifter	1	43	G.2777-PDB-181	presserfoot assembly, complete	1
8	TS. 22 x 35	screws, wood for securing knee-control	4	44	004-L-3	screw, chaining finger securing	1
9	270-570	base, knee control	1	45	27.77-183	chaining plate	1
10	038-M-9	screw, knee control mounting	1	46	27.77-196	lug, presserfoot securing	1
11	005-G-6	screws, pin securing	9	47	27.77-191	chaining finger, presserfoot	1
12	270-580	pin, knee control linkage	2	48	27.77-PDB-184	shoe, presserfoot	1
13	270-579	stop, knee control	2	49	27.77-PDB-050	feed dog, front	1
14	270-998	screw, knee control assembly	1	50	27.77-PDB-1141	needle plate, bight width 13/64"	1
15	059-P-8	nut, for knee control assembly screw	2	51	27.77-PDB-051	feed dog, rear	1
16	005-L-11	screw, set	2	52	PM2701PD417/1	block, shirring attachment retainer	1
17	270-578	lever, knee control actuator	1	53	G.297-PDB-401	shirring attachment assembly complete	1
18	270-571	shaft, knee control main	1	54	297-PDB-403	shaft, shirring blade	1
19	270-720	collar, spring pressure adjustment	1	55	065-L-6	washer	1
20	270-575	spring, knee control disc recall	1	56	297-PDB-418	screw, shirring attachment assembly	1
21	270-572	block, knee control connection	1	57	004-L-3	screw, shirring blade securing	2
22	270-576	rocker, knee control	1	58	001-E-6	screw	4
23	270-581	pin, knee control rocker	1	59	297-PDB-407	lever, shirring blade pressure	1
24	270-573	rod, knee control	1	60	297-PDB-408	block, shirring attachment mounting	1
25	270-574	disc, knee control	1	61	054-D-5	washer	1
26	270-582	pad, knee control disc	1	62	057-P-5	nut	2
27	270-577	coupling, knee control	1	63	297-PDB-144	spring, latch	1
28	G.270-570	knee control assembly complete	1	64	297-PDB-442	pin, latch	1
29	160-030	pin for spring	1	65	297-PDB-441	guide-plate, latch pin	1
30	G.297-PDB-515	shirring blade lifter lever linkage compl.ass.	1	66	028-B-5	screw, latch pin guide-plate securing	2
31	297-PDB-402	shirring blade	1	67	270-078	pin, latch lifter	1
32	27.01-PDB-518	pin, rear lifter lever	1	68	270-094	lifter lever, latch	1
33	053-D-4	nut	1	69	039-R-8,5	screw, shirring attachment securing	1
34	070-F-4	washer	1	70	1032 a	bushing, shirring blade pressure spring	1
35	PM.297-PDB-515	lifter lever, shirring blade	1	71	160-032	knurled head screw, shirring blade pressure adjustment	1
36	270-702	snap ring	3	72	297-PDB-443	spring, shirring blade pressure	1
37	27.01-PDB-517	yoke, shirring blade lifter lever	1	73	240-035	washer, spring	1
On request:							
27.277.074							Tab. 75
270.075-2							75
297-PDB-4021							76
297-PDB-4031							76

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60

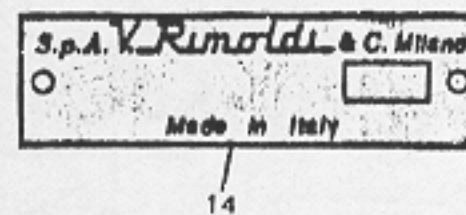
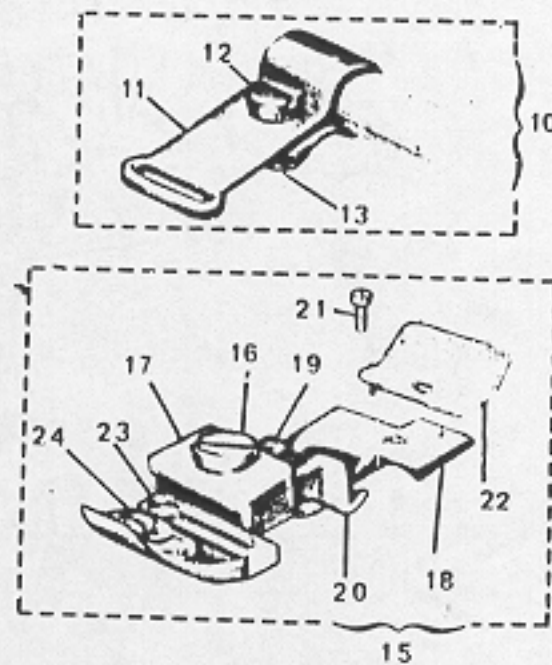
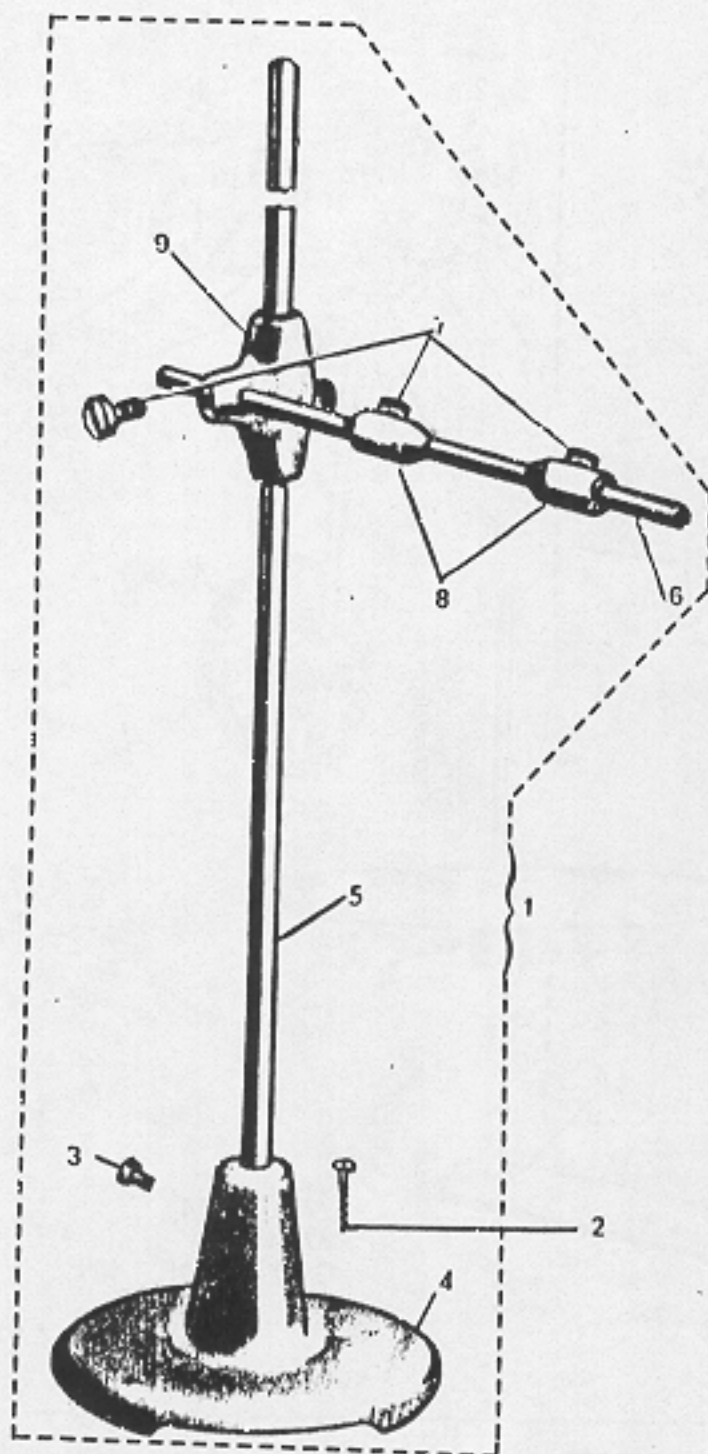


REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.270-556	actuator rod, differential-assembly	1	41	038-C-7	screw, securing	1
2	270-701	snap ring	2	42	27.01-PD3-516	link, rear	1
3	27.01-PD3-558	stud, securing	1	43	G.2777PD3-1811	presserfoot assembly complete (only for 5/64" ornamental cord)	1
4	017-F-7	grub screw	2				
5	PM726PD3-1425	plate, complete	1	44	001-E-8	screw, chaining finger securing	1
6	PM.602-141-1	base-plate with upright	1	45	2777 PD3-1831	chaining plate	1
7	G2726PD3-0375	reel stand	1	46	27.76-PD3-196-3	lug, presserfoot securing	1
8	TS. 22 x 35	screws, for securing knee control	4	47	27.77PD3-1911	chaining finger, presserfoot	1
9	270-570	base, knee control	1	48	27.77PD3-1841	shoe, presserfoot	1
10	038-M-9	screw, knee control mounting	9	49	27.77PD3-050	feed-dog, front	1
11	005-G-6	screws, pin securing	2	50	27.77PD3-1141	needle plate, bight width 13/64"	1
12	270-580	pin, knee control linkage	2	51	27.77-PD3-051	feed-dog, rear	1
13	270-579	stop, knee control	1	52	PM297PD3-417/1	block, shirring attachment retainer	1
14	270-998	screw, knee control assembly	2	53	G.297-PD3-401	shirring attachment complete	1
15	059-P-8	nut, knee control assembly screw	2	54	297-PD3-403	shaft, shirring blade	1
16	005-L-11	screw, set	1	55	035-L-5	washer	1
17	270-578	lever, knee control actuator	1	56	297-PD3-418	screw, shirring attachment mounting	1
18	270-571	shaft, knee control main	1	57	004-L-5	screw, shirring blade securing	2
19	270-720	collar, spring pressure adjustment	1	58	001-E-6	screw	4
20	270-575	spring, knee control disc recall	1	59	297-PD3-407	lever, shirring blade pressure	1
21	270-572	block, knee control connection	1	60	297-PD3-408	block, shirring blade mounting	1
22	270-576	rocker, knee control	1	61	064-D-5	washer	1
23	270-581	pin, knee control rocker	1	62	057-P-5	nut	2
24	270-573	rod, knee control disc	1	63	297-PD3-444	spring, latch	1
25	270-574	disc, knee control	1	64	297-PD3-442	pin, latch	1
26	270-582	pad, knee control disc	1	65	297-PD3-441	guide-plate, latch pin	1
27	270-577	coupling, knee control	1	66	028-B-5	screw, guide-plate securing	2
28	G.270-570	knee control assembly complete	1	67	270-078	pin, latch lifter	1
29	160-030	pin, for spring	1	68	270-094	lifter lever, latch	1
30	G.297-PD3-515	shirring blade lifter lever linkage, compl. ass.	1	69	039-B-8,5	screw, shirring attachment securing	1
31	297-PD3-402	shirring blade	1	70	1032-A	bushing, shirring blade pressure spring	1
32	27.01-PD3-518	pin, rear lifter lever	1	71	130-032	knurled head screw, shir. blade press. adjust.	1
33	053-D-4	nut	1	72	297-PD3-443	spring, shirring blade pressure	1
34	070-F-4	washer	1	73	240-035	washer, spring	1
35	PM297-PD3-515	lifter lever, shirring blade	1	74	130-030	stud, shirring blade spring	1
36	270-702	snap ring	3	75	PM297-PD3-406	lever, shirring blade lifter	1
37	27.01-PD3-517	yoke, shirring blade lifter lever	1	76	001-D-7	screw, retainer block securing	1
38	27.01-PD3-519	stud, lifter lever mounting	1	77	PM297PD3-413	guide, for 5/64" ornamental cord	1
39	27.01-PD3-520	pin, yoke	1	78	001-E-7	screw, guide securing	2
40	297-PD3-401	base, shirring attachment	1				
				80	730330-0-00	name-plate	1

III. TECHNICAL DATA BY SUB-CLASS

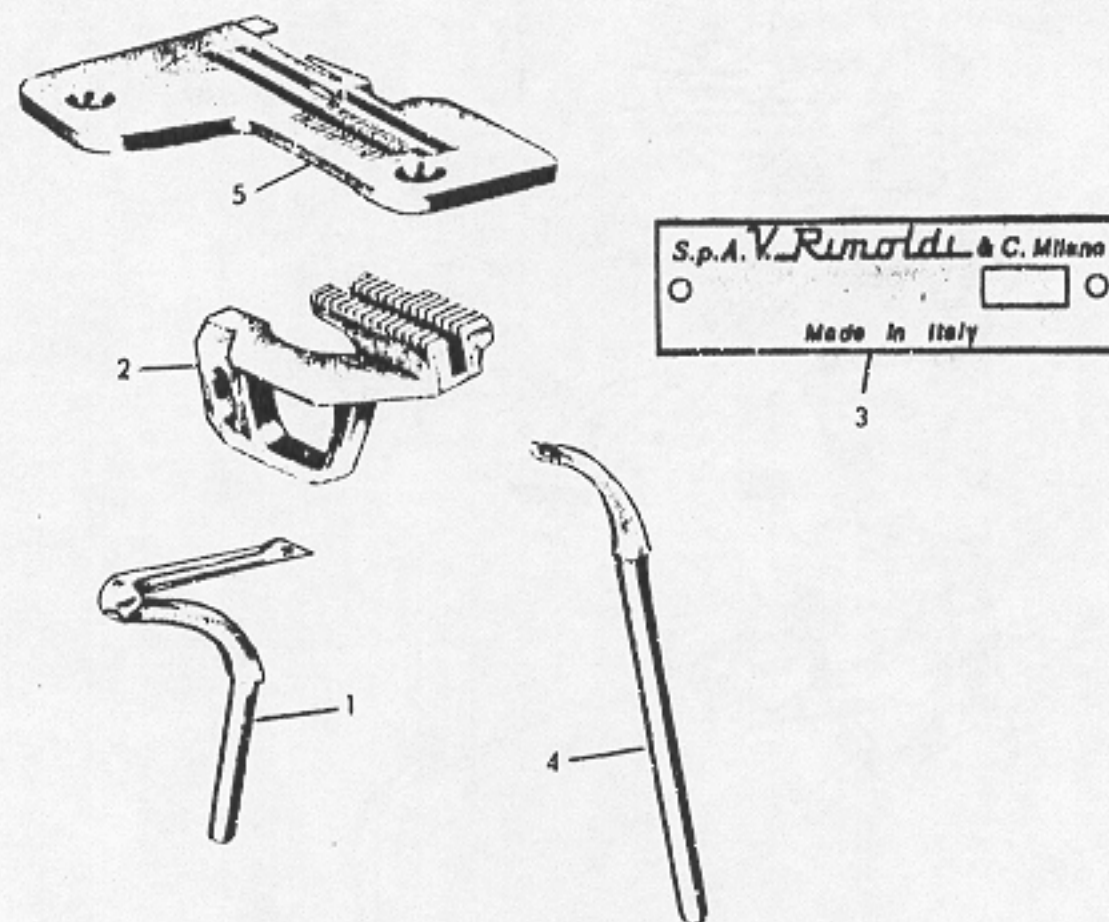
HEAD No.	TECHNICAL CHARACTERISTICS							SPECIFIC USES
	No. threads	Width of bight	Diff. pos.	S P E E D		Knives	Sp. attach- ments on req.	
				No. of revs. 1" max.	St. per inch			
227-29-01	3	1/8" 1/4"	max. med.	7000	15-30 1-30	yes	107 115	OVEREDGING WITH INSERTIONS For medium cut knit fabrics in wool, cotton, etc. - with attachment for inserting lastex thread from the top
227-29-02	3	1/8" 1/4"	max. med.	7000	15-30 1-30	yes	107 115	For medium cut knit fabrics, in wool, cotton, etc. - with attachment for inserting a flat elastic of a maximum width of 5/32", from the top
227-29-04	3	8/64"	max. med.	7000	15-30 1-30	yes	107 115	For light cut knit fabrics in wool, cotton, etc., with narrow bight, with attachment for inserting a lastex thread from under the throat plate
227-29-05	3	3/32" 5/32"	max. med.	7000	15-30 1-30	yes	107 115	Same as 227-29-01, but with slightly narrower bight. For light knit fabrics.
227-29-06	3	3/32" 5/32"	max. med.	7000	15-30 1-30	yes	107 115	Same as 227-29-02, but with slightly narrower bight. For light knit fabrics.
227-29-08	3	3/32"	max.	6500	15-30	yes	107 115	For medium fabrics (satin, heavy satin, etc.) with attachment to turn the fabric upwards into the seam and with attachment to insert a lastex thread from the top
227-30-03	3	5/64" 9/64"	negat.	6500	15-30	yes	115	APPLICATION STIFF LACE For light and very light woven fabrics (nylon, satin, very light flannel) with attachment to turn the fabric downwards into the seam, with special edge guide to attach lace without trimming the selvage.
227-30-04	3	5/64" 8/64"	negat.	6500	15-30	yes	115	For light and very light woven fabrics. With attachment to turn the fabric downwards into the seam and attachment for attaching cicle lace from the top. With tensioning device.
227-30-05	3	3/32"	negat.	6500	15-30	yes	115	For light woven fabric. With attachment to turn the fabric upwards into the seam. With special edge guide to attach lace without trimming the selvage.
227-30-06	3	3/32"	negat.	6500	15-30	yes	115	Same as 227-30-05, but with special fine toothed feed-dogs, for very light delicate woven fabrics.
227-00-02	3		negat.	7000	8:30	sl	100 101 106 115 107	For very light rib, jersey and warpknit fabrics.
227-00-30	3		max.	6500	8:20	sl	106 115	For medium and heavy knit fabrics, with a maximum presserfoot throw of 7.5 mm. - maximum bight 6 mm. Equipped with additional feed-dog to improve the feeding, and facilitate the chaining-off (U.S.A. edition)
227-00-33	3		max.	6000	6:20	sl	115	For very bulk knit fabrics, gauges 5 and 3, maximum bight 7 mm. Equipped with additional feed-dog to improve the feeding and facilitate the chaining-off (U.S.A. edition).

24



From the library of: Diamond Needle Corp

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.250-R-9373	spool stand, complete	1	13	057-A-3	nut	1
2	TS. 20 x 30	screw, wood	2	14	780-252-0-00	machine class plate	1
3	001-G-12	screw	1	15	G.277-R-181	presserfoot complete	1
4	01141	base	1	16	004-L-9	screw	1
5	605-143	upright	1	17	27.77-183	chaining plate	1
6	605-144	bar, top	1	18	27.77-184	shoe, presserfoot	1
7	605-980	knurled head screw	4	19	27.77-195	lug, chaining plate	1
8	605-723	tapered sleeve	2	20	277-191	finger, chaining	1
9	605-937	bracket	1	21	001-A-3 2	screw	1
10	PM.27.77-R-267	tape guide, complete	1	22	277-185	plate	1
11	27.77-R-267	tape guide, complete	1	23	27.277-R-071	plate	1
12	001-C-5,5	screw	1	24	004-G-3	screw	1

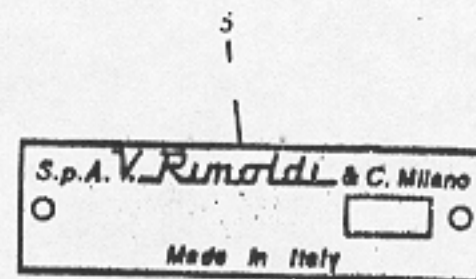
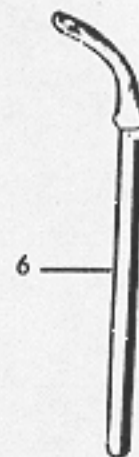
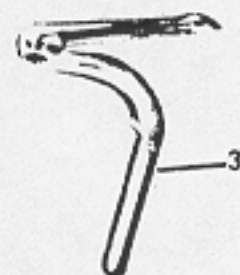
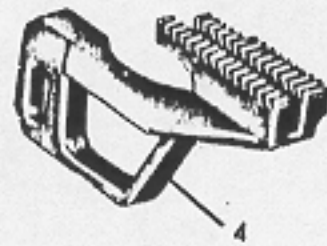
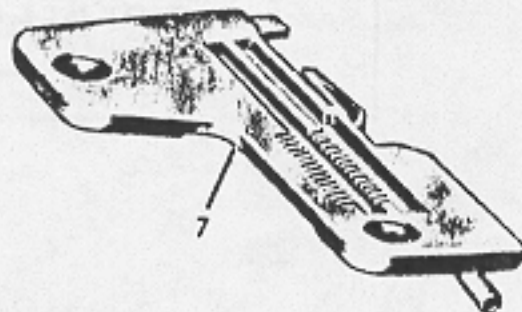
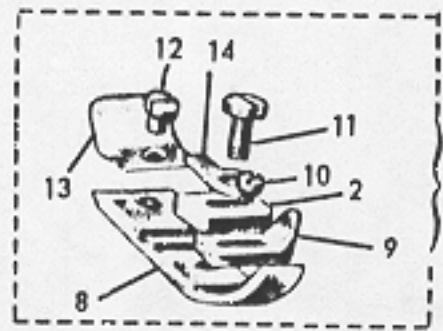


25

N.B. To convert a 227-00-07 machine into 227-00-07-100 see tab. 72-73
To convert a 227-00-07 machine into 227-00-07-101 see tab. 74

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-075	primary looper	1	4	27.277-0745	secondary looper	1
2	27.01-0501	feed dog, front	1	5	27.01-1141	needle plate, bight width 9/64"	1
3	780-207-0-00	machine class plate	1				
						On request:	
						001-D-7	Tab. 75
						270-075-2	" 75
						270-401	" 75
						PM.270-1882	" 75
						27.01-1143	" 75
						27.01-1142	" 75
						27.277-074	" 75
						G.274-401	" 75

62

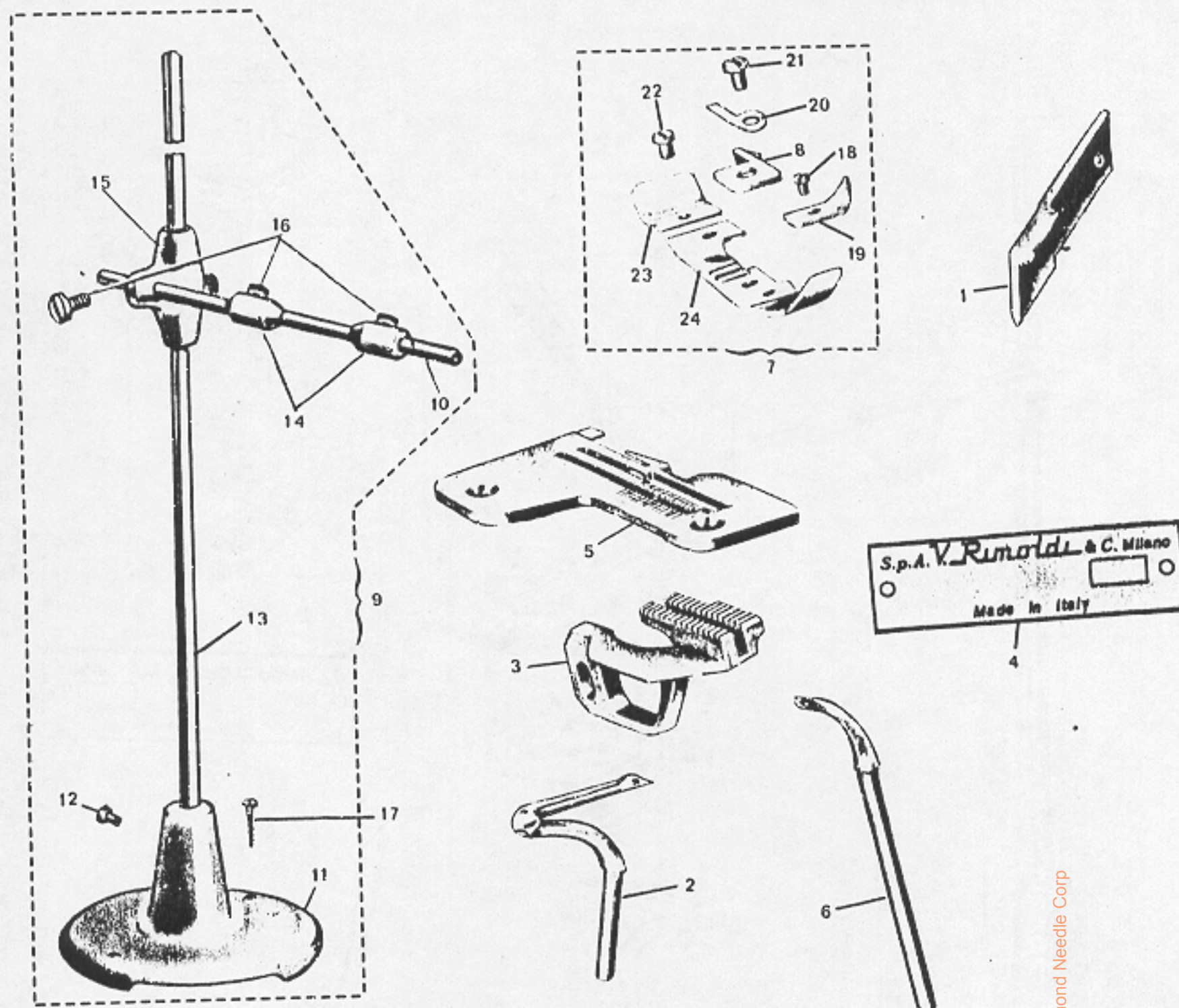


26

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REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.27.01-A-181	presserfoot complete	1	8	270-184	shoe, presserfoot	1
2	27.01-A-191	chaining finger presserfoot	1	9	270-183	stop block	1
3	270-075	primary looper	1	10	270-989	screw, stop block	1
4	27.01-0501	feed dog, front	1	11	004-L-7	screw, chaining finger securing	1
5	780433-0-00	machine class plate	1	12	001-A-3,2	screw, chaining plate	1
6	27.277-0745	secondary looper	1	13	270-185	presserfoot chaining plate guide	1
7	G.27.01-A-114	needle plate with guide for bight	1	14	270-193	lug, chaining plate	1
8		width 9/64"					
N.B. When a 227-00-07 is converted into a 227-29-04 on customer's premises, only supply chaining finger 27.01-A-191 and not complete presserfoot G.27.01-A-181.							

634



27

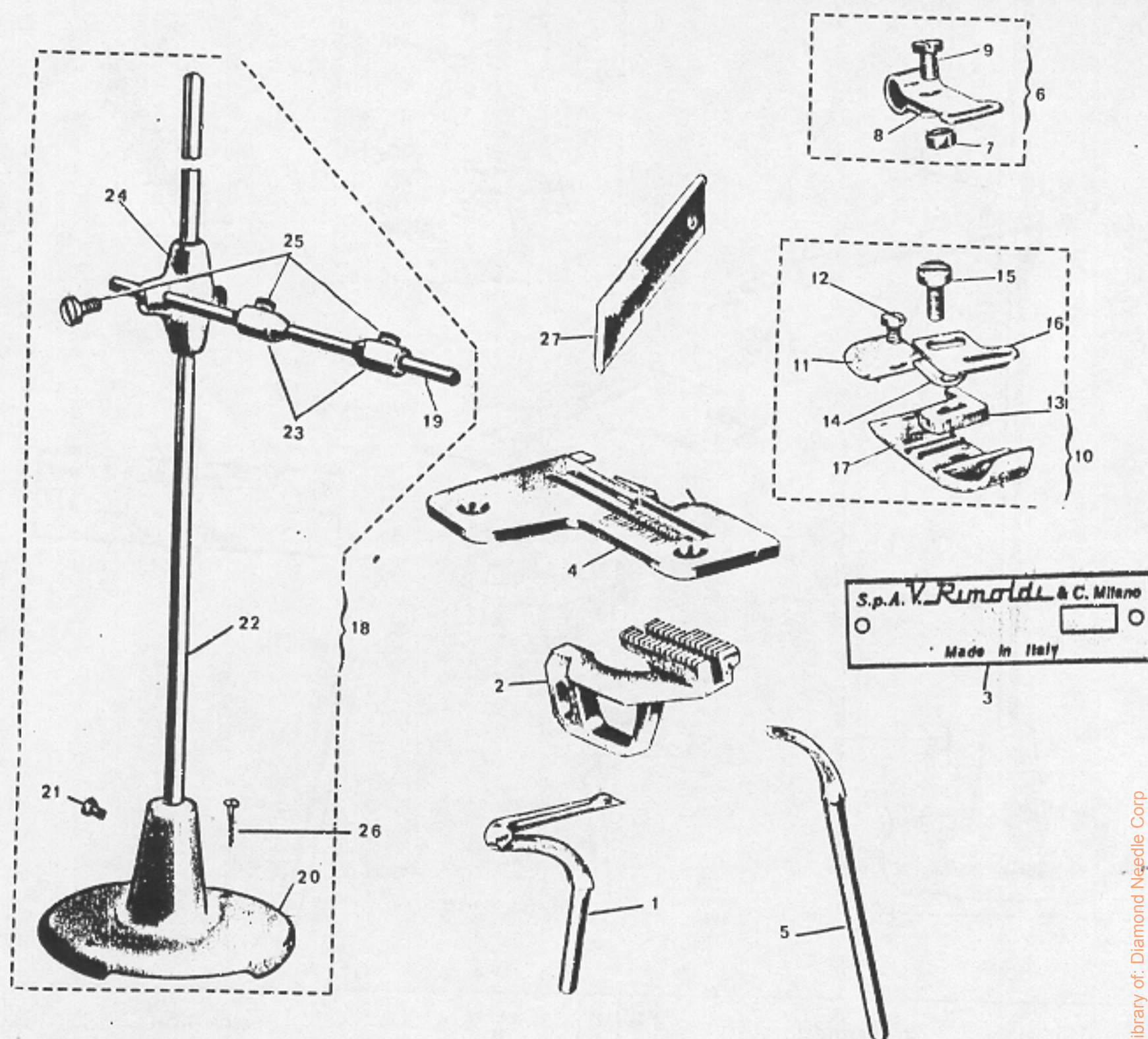
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	279-112	knife, upper	1	13	605-143	upright	1
2	270-075	primary looper	1	14	605-723	tapered sleeve	2
3	27.01-0501	feed dog, front	1	15	605-937	bracket	1
4	780434-0-00	machine class plate	1	16	605-980	knurled head screw	4
5	27.01-1141	needle plate, height width 9/64"	1	17	TS. 20 x 30	screw, frame securing	2
6	27.277-0745	secondary looper	1	18	270-983	screw, stop securing	1
7	G.270-E-181	presserfoot, complete	1	19	270-183	stop block	1
8	270-E-191	chaining finger, presserfoot	1	20	270-196	lug, chaining plate	1
9	G.250-R-9373	reel stand	1	21	004-L-7	screw, chaining finger securing	1
10	605-144	bar, top	1	22	001-A-3,2	screw, chaining plate securing	1
11	01141	base	1	23	270-185	chaining plate	1
12	001-G-12	screw	1	24	270-184	shoe, presserfoot	1

N.B. When a 227-00-07 is converted into 227-29-05 on customer's premises, supply only chaining finger 270-E-191 and not complete presserfoot G.270-E-181.

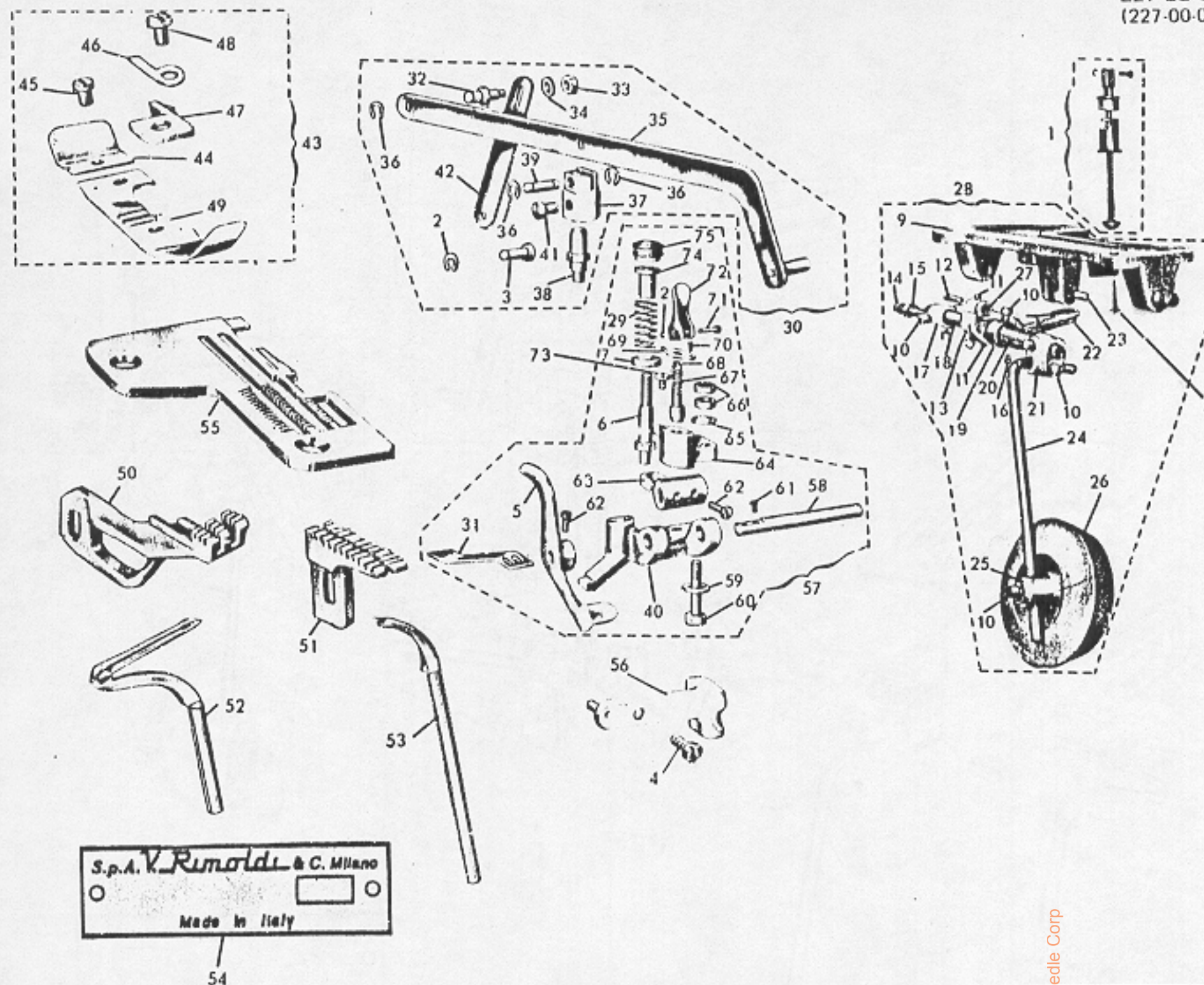
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65

28

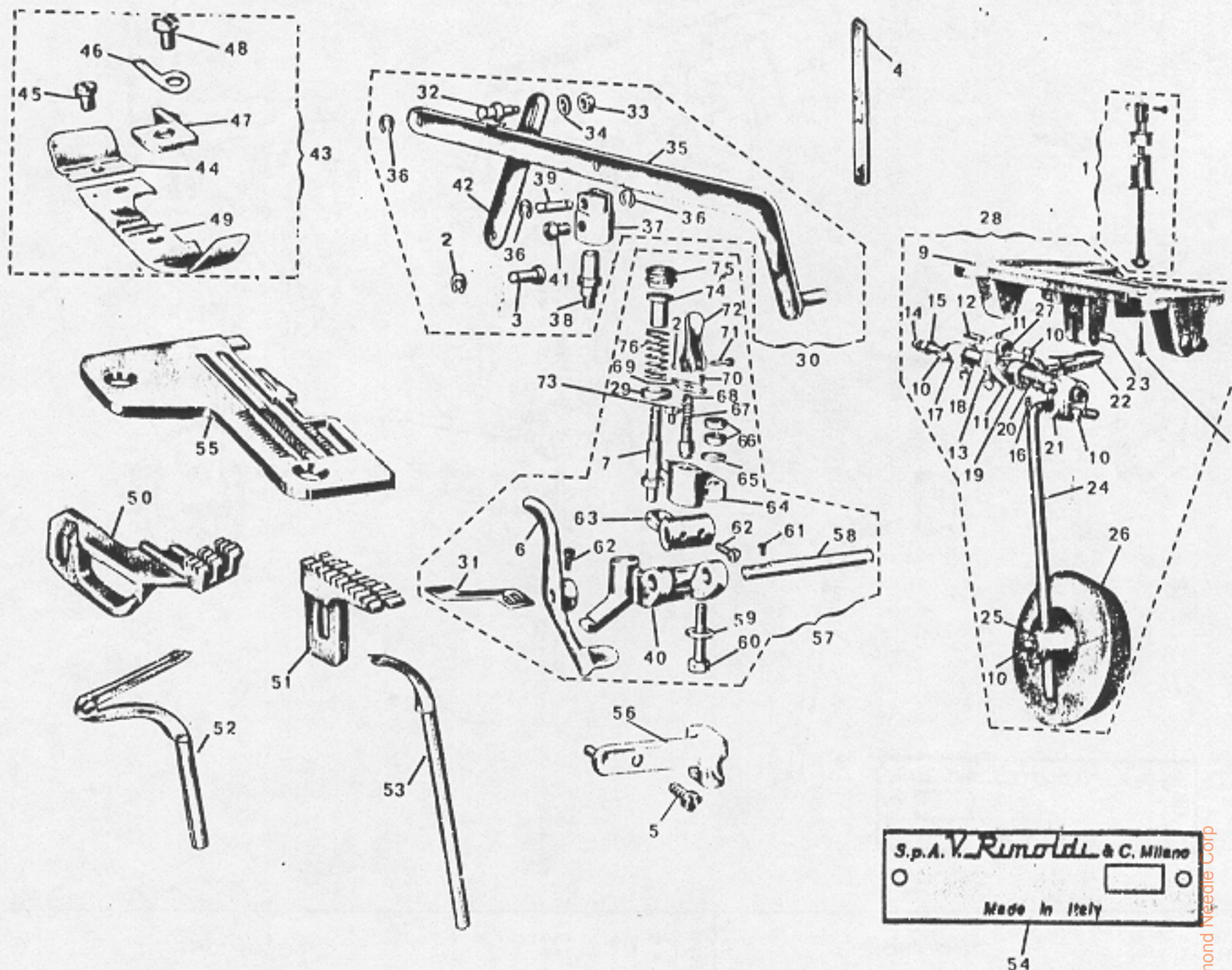


REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-075	primary looper	1	15	004-L-8	screw	1
2	27.01-0501	feed-dog, front	1	16	270-EF-071	plate	1
3	780435-0-00	machine class plate	1	17	270-EF-184	shoe, presserfoot	1
4	27.01-1141	needle plate, bight width 9/64"	1	18	G.250-R-9373	reel stand	1
5	27.277-0745	secondary looper	1	19	305-144	bar, top	1
6	PM.270-R-267	guide plate, tape	1	20	01141	base	1
7	057-A-3	nut	1	21	001-G-12	screw	1
8	270-R-267	guide, tape	1	22	305-143	upright	1
9	001-C-5,5	screw	1	23	305-723	tapered sleeve	1
10	G.270-EF-181	presserfoot, complete	1	24	305-937	bracket	2
11	270-185	chaining plate	1	25	305-980	knurled head screw	1
12	001-A-3,2	screw, chaining plate securing	1	26	TS. 20 x 30	screw, frame securing	4
13	270-EF-191	chaining finger	1	27	279-112	knife, upper	2
14	270-196	lug, chaining plate	1				1



REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.270-556	actuator rod, differential - assembly	1	39	27.01-PD3-520	pin, yoke	1
2	270-701	stud, securing	2	40	297-PDB-401	base, shirring attachment	1
3	27.01-PDB-558	screw, retainer block securing	1	41	038-C-7	screw, securing	1
4	001-D-7	lever, shirring blade lifter	1	42	27.01-PDB-516	link, rear	1
5	PM297PDB406	pin, for spring	1	43	G.27.01-PD-181	presserfoot, complete	1
6	160-030	cup, for spring	1	44	270-185	chaining plate, presserfoot	1
7	240-035	screws, knee control securing	1	45	001-A-3,2	screw, chaining plate securing	1
8	TS. 22x35	base, knee control	1	46	270-196	lug, chaining finger	1
9	270-570	screw, knee control mounting	1	47	270-191	chaining finger, presserfoot	1
10	038-M-9	screws, pin securing	2	48	004-L-7	screw, chaining finger securing	1
11	005-G-6	pin, knee control linkage	2	49	27.01-PD-184	shoe, presserfoot	1
12	270-580	stop, knee control	1	50	27.01-P-050	feed-dog, front	1
13	270-579	screw, knee control assembly	2	51	27.01-P-051	feed-dog, rear	1
14	270-998	nut, knee control assembly screw	2	52	270-075	primary looper	1
15	059-P-8	screw, set	1	53	27.277-0745	secondary looper	1
16	005-L-11	lever, knee control actuator	1	54	780361-0-00	machine class plate	1
17	270-578	shaft, knee control main	1	55	27.01-P-114	needle plate, bight width 3/32"	1
18	270-571	collar, spring pressure adjustment	1	56	PM27.01PD417/1	angle stop	1
19	270-720	spring, knee control disc recall	1	57	G.297-PD3-401	shirring attachment complete	1
20	270-575	block, knee control connection	1	58	297-PDB-403	shaft, shirring blade	1
21	270-572	rocker, knee control	1	59	065-L-6	washer	1
22	270-576	pin, knee control rocker	1	60	297-PDB-418	screw, shirring attachment mounting	1
23	270-581	rod, knee control disc	1	61	004-L-6	screw, shirring blade securing	2
24	270-573	disc, knee control	1	62	001-E-6	screw	4
25	270-574	pad, knee control disc	1	63	297-PDB-407	lever, shirring blade pressure	1
26	270-582	coupling, knee control	1	64	297-PDB-408	block, shirring blade mounting	1
27	270-577	knee control assembly complete	1	65	054-D-5	washer	1
28	G.270-570	spring, shirring blade pressure	1	66	057-P-5	nut	2
29	297-PDB-443	lifter lever, shirring blade complete ass.	1	67	297-PDB-444	spring, latch	1
30	G.297-PDB-515	shirring blade	1	68	297-PDB-442	pin, latch	1
31	297-PDB-442	pin, rear lifter lever	1	69	297-PDB-441	guide-plate, latch pin	1
32	27.01-PDB-518	nut	1	70	028-B-5	screw, guide-plate securing	2
33	053-D-4	washer	1	71	270-078	pin, latch lifter	1
34	070-F-4	lifter lever, shirring blade	1	72	270-094	lifter lever, latch	1
35	PM.297-PDB-515	screw, shirring attachment securing	1	73	039-R-8,5	bushing, shirring blade pressure spring	1
36	270-702	stud, shirring blade lifter lever	3	74	1032-a	stud, shirring blade spring	1
37	27.01-PDB-517	stud, lifter lever mounting	1	75	160-032		
38	27.01-PDB-519		1				

On request:
27.01-P-114/1 Tab. 75
G.27.01-PD-181/1 " 76
297-PDB-4021 " 76
297-PDB-4031 " 76



30

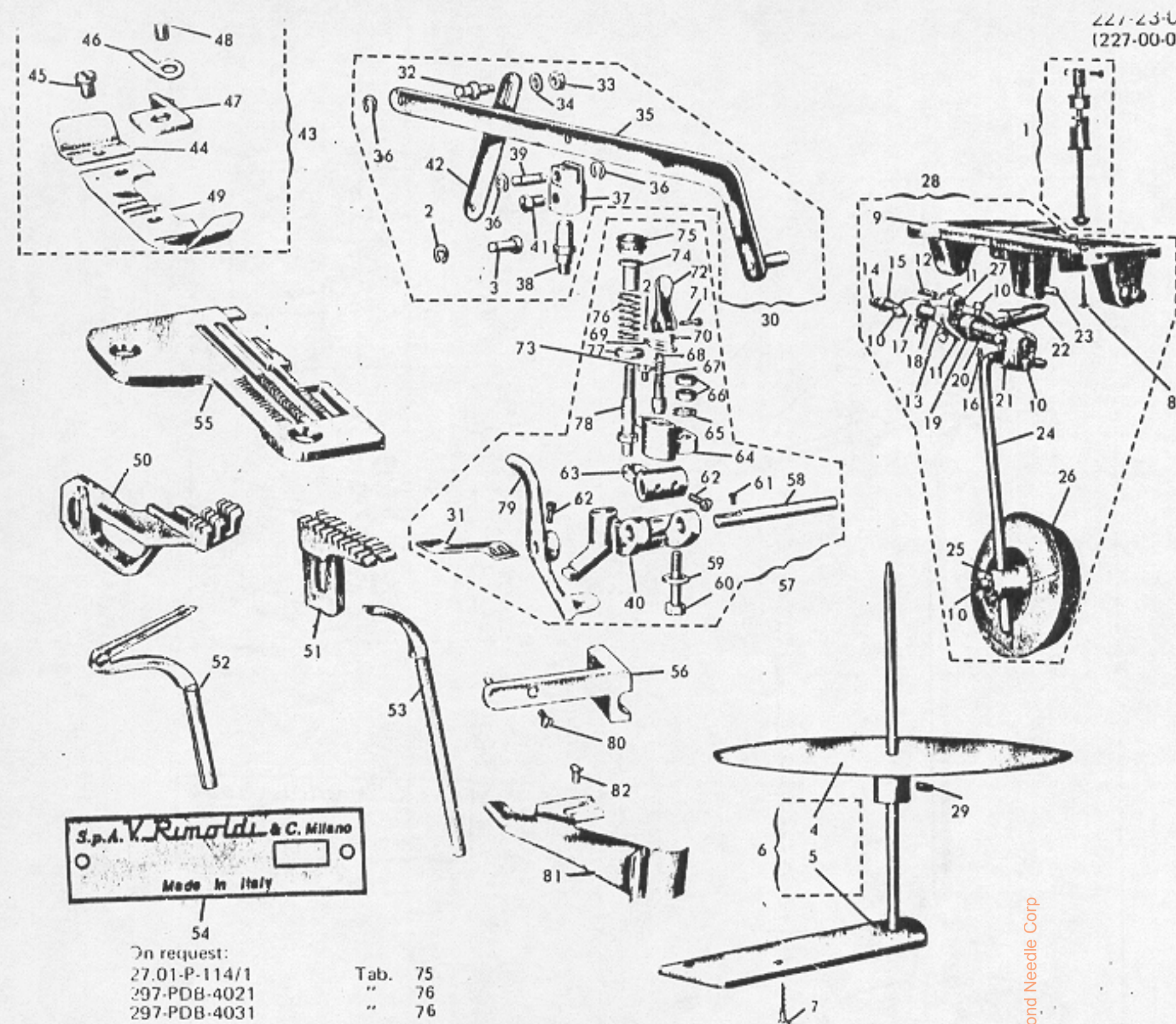
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.270-556	attuatore rod, differential - assembly	1	39	27.01-PD3-520	pin, yoke	1
2	270-701	snap ring	2	40	29.1-PD3-401	base, shirring attachment	1
3	27.01-PDB-558	stud, securing	1	41	038-C-7	screw, securing	1
4	27.01-P-9-113/1	knife, lower	1	42	27.01-PDB-516	link, rear	1
5	001-D-7	screw, block securing	1	43	G.2701-PD9-181	presserfoot, complete	1
6	PM.297-PDB-406	lever, shirring blade lifter	1	44	270-185	chaining plate	1
7	160-C30	pin, for spring	1	45	001-A-3,2	screw, chaining plate securing	1
8	TS. 22 x 35	screws, wood, for securing knee control	4	46	270-196	lug, chaining plate	1
9	270-570	base, knee control	1	47	27.01-P-9-191	chaining finger, presserfoot	1
10	038-M-9	screw, knee control mounting	9	48	004-L-7	screw, chaining finger securing	1
11	005-G-6	screws, pin securing	2	49	27.01-PD-9-184	shoe, presserfoot	1
12	270-580	pin, knee control linkage	2	50	27.01-P-050	feed-dog, front	1
13	270-579	stop, knee control	1	51	27.01-P-051	feed-dog, rear	1
14	270-998	screw, knee control assembly	2	52	270-075	primary looper	1
15	059-P-8	nut, for knee control assembly screw	2	53	27.277-0745	secondary looper	1
16	005-L-11	screw, set	1	54	780362-0-00	machine class plate	1
17	270-578	lever, knee control actuator	1	55	27.01-PD-114	needle plate, high width 3/32"	1
18	270-571	shaft, knee control main	1	56	PM2701PD417/1	block, shirring attachment retainer	1
19	270-720	collar, spring pressure adjustment	1	57	G.297-PDB-401	shirring attachment assembly complete	1
20	270-575	spring, knee control disc recall	1	58	297-PDB-403	shaft, shirring blade	1
21	270-572	block, knee control connection	1	59	065-L-6	washer	1
22	270-576	rocker, knee control	1	60	297-PD3-418	screw, shirring attachment mounting	1
23	270-581	pin, knee control rocker	1	61	004-L-6	screw, shirring blade securing	2
24	270-573	rod, knee control	1	62	001-E-3	screw	4
25	270-574	disc, knee control	1	63	297-PD3-407	lever, shirring blade pressure	1
26	270-582	pad, knee control disc	1	64	297-PD3-408	block, shirring blade mounting	1
27	270-577	coupling, knee control	1	65	034-D-5	washer	1
28	G.270-570	knee control assembly complete	1	66	057-P-5	nut	2
29	240-035	cup washer, for spring	1	67	297-PDB-444	spring, latch	1
30	G.297-PDB-515	shirring blade lifter lever linkage assembly	1	68	297-PD3-442	pin, latch	1
31	297-PDB-402	shirring blade	1	69	297-PD3-441	guide-plate, latch pin	1
32	27.01-PDB-518	pin, rear lifter lever	1	70	028-B-5	screw, guide-plate securing	2
33	053-D-4	nut	1	71	270-078	pin, latch lifter lever	1
34	070-F-4	washer	1	72	270-094	lever, latch lifter	1
35	PM297PDB515	lifter lever, shirring blade	1	73	039-R-8,5	screw, shirring attachment securing	1
36	270-702	snap ring	3	74	1032 a	bushing, shirring blade pressure spring	1
37	27.01-PDB-517	yoke, shirring blade lifter lever	1	75	160-032	stud, shirring blade spring	1
38	27.01-PDB-519	stud, lifter lever yoke mounting	1	76	297-PDB-443	spring, shirring blade pressure	1

S.p.A. V. Remoldi & C. Milano
Made in Italy

54

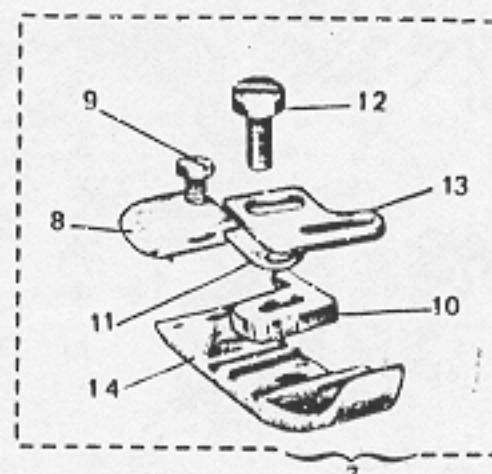
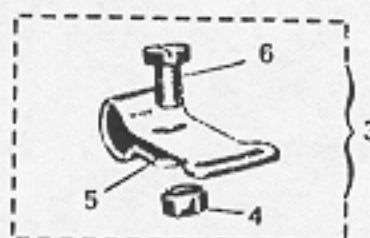
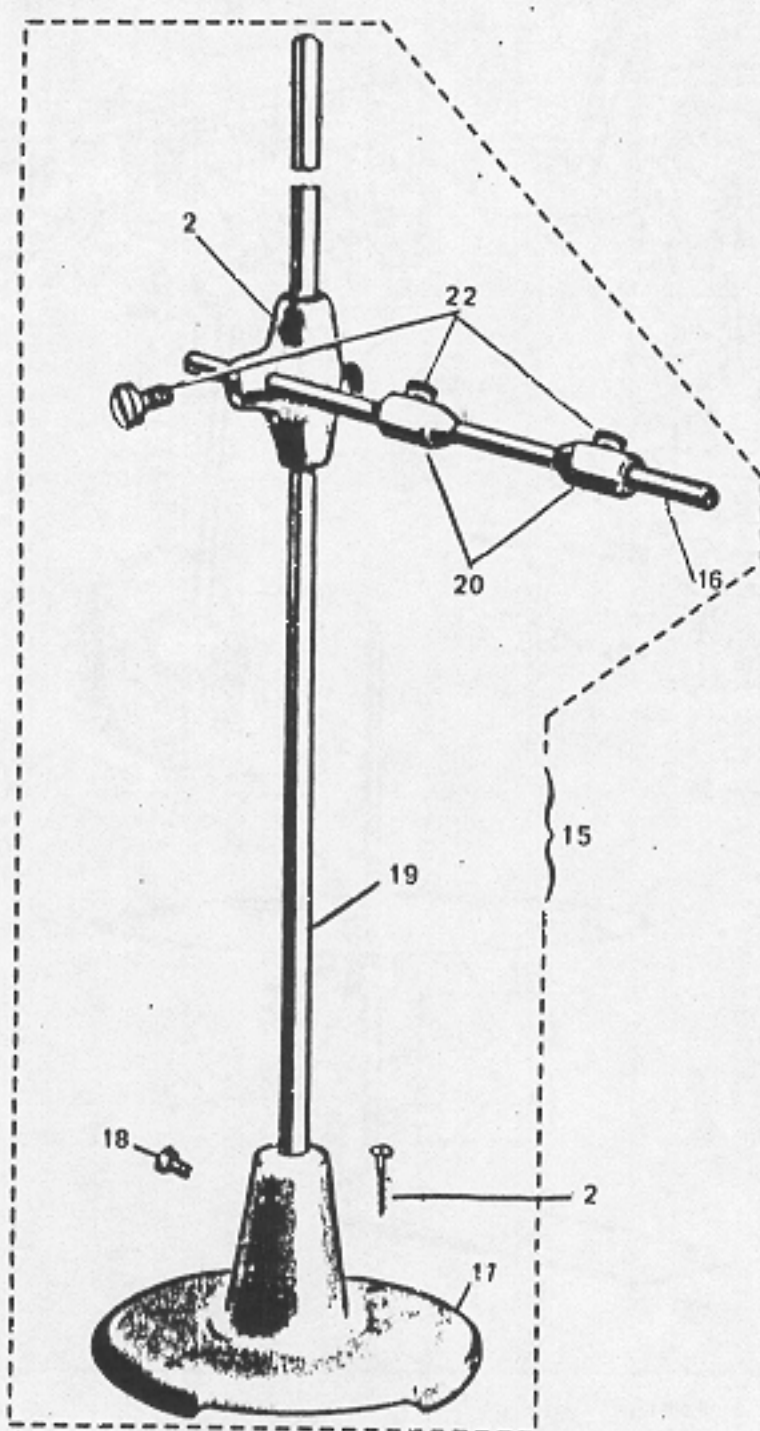
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On request:
27.01-P-114 Tab. 75
G.27.01-PD-181/1 " 76
297-PDB-4021 " 76
297-PD3-4031 " 76



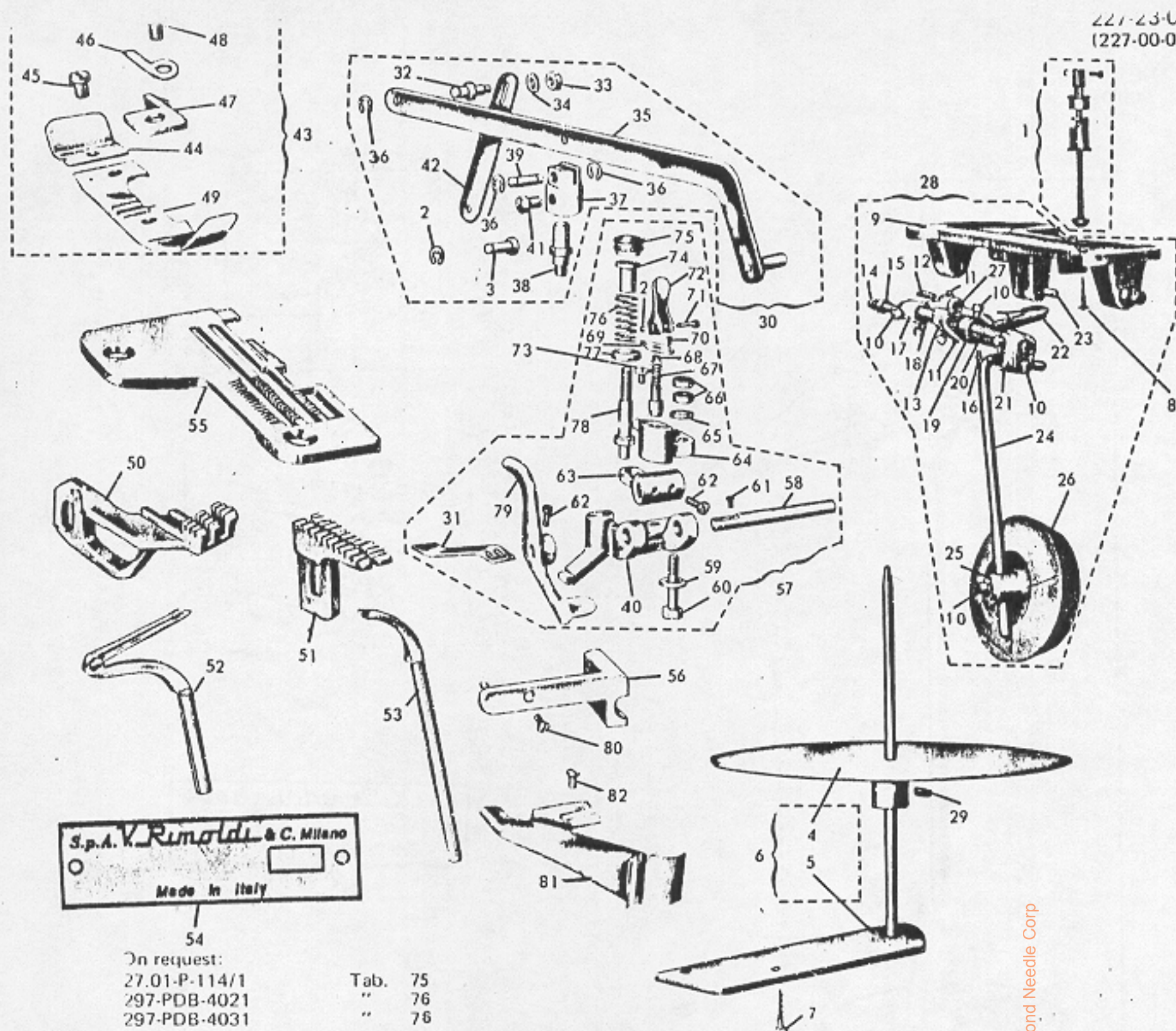
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.270-556	actuator rod, differential - assembly	1	42	27 01-PDB-516	link, rear	1
2	270-701	stud, securing	2	43	G2701PDBO181	presserfoot assembly complete for 5/64"	1
3	27 01-PDB-558	plate, complete	1			ornamental cord	1
4	PM2726PDBO1425	base plate with upright	2	44	270-135	chaining plate	1
5	PM602-141/1	reel stand	1	45	001-A-3,2	screw, chaining plate securing	1
6	G.2726PDBO9375	screw, reel stand mounting	1	46	270-196	lug, presserfoot	1
7	TS. 20 x 30	screws, knee control securing	2	47	270-191	chaining finger, presserfoot	1
8	TS. 22 x 35	base, knee control	4	48	004-L-7	screw, chaining finger securing	1
9	270-570	screw, knee control mounting	1	49	27 01-PDB-184	shoe, presserfoot	1
10	038-M-9	screw, pin securing	9	50	27.01-P-050	feed-dog, front	1
11	005-G-6	pin, knee control linkage	2	51	27.01-P-051	feed-dog, rear	1
12	270-580	stop, knee control	2	52	270-075	primary looper	1
13	270-579	screw, knee control assembly	1	53	27.277-0745	secondary looper	1
14	270-998	nut, knee control assembly screw	2	54	780381-0-00	machine class plate	1
15	005-L-11	screw, set	2	55	27.01 P-114	needle plate, bight width 3/32"	1
16	270-578	lever, knee control actuator	1	56	PM2701PD417/1	block, shirring attachment retainer	1
17	270-571	shaft, knee control main	1	57	G.297-PDB-401	shirring attachment, complete	1
18	270-720	collar, spring pressure adjustment	1	58	297-PDB-403	shaft, shirring blade	1
19	270-575	spring, knee control disc recall	1	59	065-L-6	washer	1
20	270-572	block, knee control connection	1	60	297-PDB-418	screw, shirring attachment mounting	1
21	270-576	rocker, knee control	1	61	004-L-6	screw, shirring blade securing	2
22	270-581	pin, knee control rocker	1	62	001-E-6	screw	4
23	270-573	rod, knee control disc	1	63	297-PDB-407	lever, shirring blade pressure	1
24	270-574	disc, knee control	1	64	297-PDB-408	block, shirring blade mounting	1
25	270-582	pad, knee control disc	1	65	064-D-5	washer	2
26	270-577	coupling, knee control	1	66	057-P-5	nut	1
27	G.270-570	knee control assembly complete	1	67	297-PDB-444	spring, latch	1
28	017-E-7	grub screw	1	68	297-PDB-442	pin, latch	1
29	G.297-PDB-515	shirring blade lifter lever linkage assembly	2	69	297-PDB-441	guide-plate, latch pin	1
30	297-PDB-402	shirring blade	1	70	028-B-5	screw, guide-plate securing	2
31	2701-PDB-518	pin, rear lifter lever	1	71	270-078	pin, latch lifter	1
32	053-D-4	nut	1	72	270-094	lifter lever, latch	1
33	070-F-4	washer	1	73	039-R-8,5	screw, shirring attachment securing	1
34	PM297-PDB-515	lever, shirring blade lifter	1	74	1032 a	bushing shirring blade pressure spring	1
35	270-702	snap ring	1	75	150-032	stud, shirring blade spring	1
36	27.01-PDB-517	yoke, shirring blade lifter lever	3	76	297-PDB-443	spring, shirring blade pressure	1
37	27.01-PDB-519	pin, lifter lever mounting	1	77	240-035	cup washer, for spring	1
38	27.01-PDB-520	pin, yoke	1	78	150-030	pin, for spring	1
39	297-PDB-401	base, shirring attachment	1	79	PM.297-PDB-406	lever, shirring blade lifter	1
40	038-C-7	screw, securing	1	80	001-C-7	screw, retainer block securing	1
41			1	81	PM297PDBO413	guide, for 5/64" ornamental cord	1
				82	001-F-7	screw, guide mounting	2

32



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REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	780253-0-00	machine class plate	1	12	004-L-8	screw	1
2	TS. 20 x 30	screw	2	13	270-R-071	plate	1
3	PM.270-R-267	tape guide, complete	1	14	270-R-184	shoe, presserfoot	1
4	057-A-3	nut	1	15	G.250-R-9373	reel stand	1
5	270-R-267	tape guide plate	1	16	605-144	bar, top	1
6	001-C-5,5	screw	1	17	01141	base, reel stand	1
7	G.270-R-181	presserfoot, complete	1	18	001-G-12	screw	1
8	270-185	chaining plate	1	19	605-143	upright	1
9	001-A-3,2	screw, chaining plate securing	1	20	605-723	tapered sleeve	2
10	270-191	chaining finger	1	21	605-937	bracket	1
11	270-196	lug, chaining plate	1	22	605-980	knurled head screw	4



REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.270-556	actuator rod, differential - assembly	1	42	27 01-PDB-516	link, rear	1
2	270-701	stud, securing	2	43	G2701PDBO181	presserfoot assembly complete for 5/64"	1
3	27 01-PDB-558	plate, complete	1	44	270-135	ornamental cord	1
4	PM2726PDBO1425	base plate with upright	2	45	001-A-3,2	chaining plate	1
5	PM602-141/1	reel stand	1	46	270-196	screw, chaining plate securing	1
6	G.2726PDBO9375	screw, reel stand mounting	1	47	270-191	lug, presserfoot	1
7	TS. 20 x 30	screws, knee control securing	2	48	004-L-7	chaining finger, presserfoot	1
8	TS. 22 x 35	base, knee control	4	49	27 01-PDB-184	screw, chaining finger securing	1
9	270-570	screw, knee control mounting	1	50	27.01-P-050	shoe, presserfoot	1
10	038-M-9	screw, pin securing	9	51	27.01-P-051	feed-dog, front	1
11	005-G-6	pin, knee control linkage	2	52	270-075	feed-dog, rear	1
12	270-580	stop, knee control	2	53	27.277-0745	primary looper	1
13	270-579	screw, knee control assembly	1	54	780381-0-00	secondary looper	1
14	270-998	nut, knee control assembly screw	2	55	27.01 P-114	machine class plate	1
15	059-P-8	screw, set	2	56	PM2701PD417/1	needle plate, bight width 3/32"	1
16	005-L-11	lever, knee control actuator	1	57	G.297-PDB-401	block, shirring attachment retainer	1
17	270-578	shaft, knee control main	1	58	297-PDB-403	shirring attachment, complete	1
18	270-571	collar, spring pressure adjustment	1	59	065-L-6	shaft, shirring blade	1
19	270-720	spring, knee control disc recall	1	60	297-PDB-418	washer	1
20	270-572	block, knee control connection	1	61	004-L-6	screw, shirring attachment mounting	1
21	270-576	rocker, knee control	1	62	001-E-6	screw, shirring blade securing	2
22	270-581	pin, knee control rocker	1	63	297-PDB-407	screw	4
23	270-573	rod, knee control disc	1	64	297-PDB-408	lever, shirring blade pressure	1
24	270-574	disc, knee control	1	65	064-D-5	block, shirring blade mounting	1
25	270-582	pad, knee control disc	1	66	057-P-5	washer	2
26	270-577	coupling, knee control	1	67	297-PDB-444	nut	1
27	G.270-570	knee control assembly complete	1	68	297-PDB-442	spring, latch	1
28	017-E-7	grub screw	1	69	297-PDB-441	pin, latch	1
29	G.297-PDB-515	shirring blade lifter lever linkage assembly	2	70	028-B-5	guide-plate, latch pin	1
30	297-PDB-402	shirring blade	1	71	270-078	screw, guide-plate securing	2
31	2701-PDB-518	pin, rear lifter lever	1	72	270-094	pin, latch lifter	1
32	053-D-4	nut	1	73	039-R-8,5	lifter lever, latch	1
33	070-F-4	washer	1	74	1032 a	screw, shirring attachment securing	1
34	PM297-PDB-515	lever, shirring blade lifter	1	75	150-032	bushing shirring blade pressure spring	1
35	270-702	snap ring	1	76	297-PDB-443	stud, shirring blade spring	1
36	27.01-PDB-517	yoke, shirring blade lifter lever	3	77	240-035	spring, shirring blade pressure	1
37	27.01-PDB-519	pin, lifter lever mounting	1	78	150-030	cup washer, for spring	1
38	27.01-PDB-520	pin, yoke	1	79	PM.297-PDB-406	pin, for spring	1
39	297-PDB-401	base, shirring attachment	1	80	001-C-7	lever, shirring blade lifter	1
40	038-C-7	screw, securing	1	81	PM297PDBO413	screw, retainer block securing	1
41				82	001-F-7	guide, for 5/64" ornamental cord	1
						screw, guide mounting	2

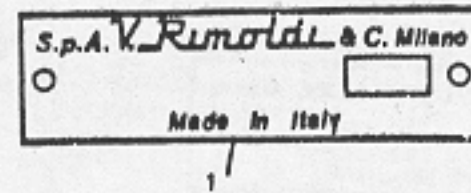
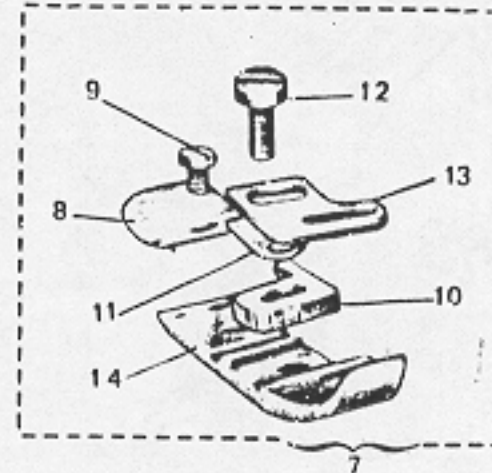
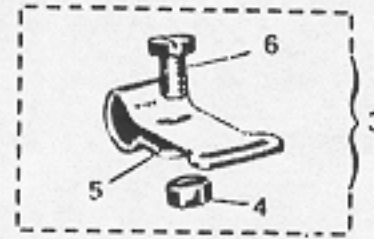
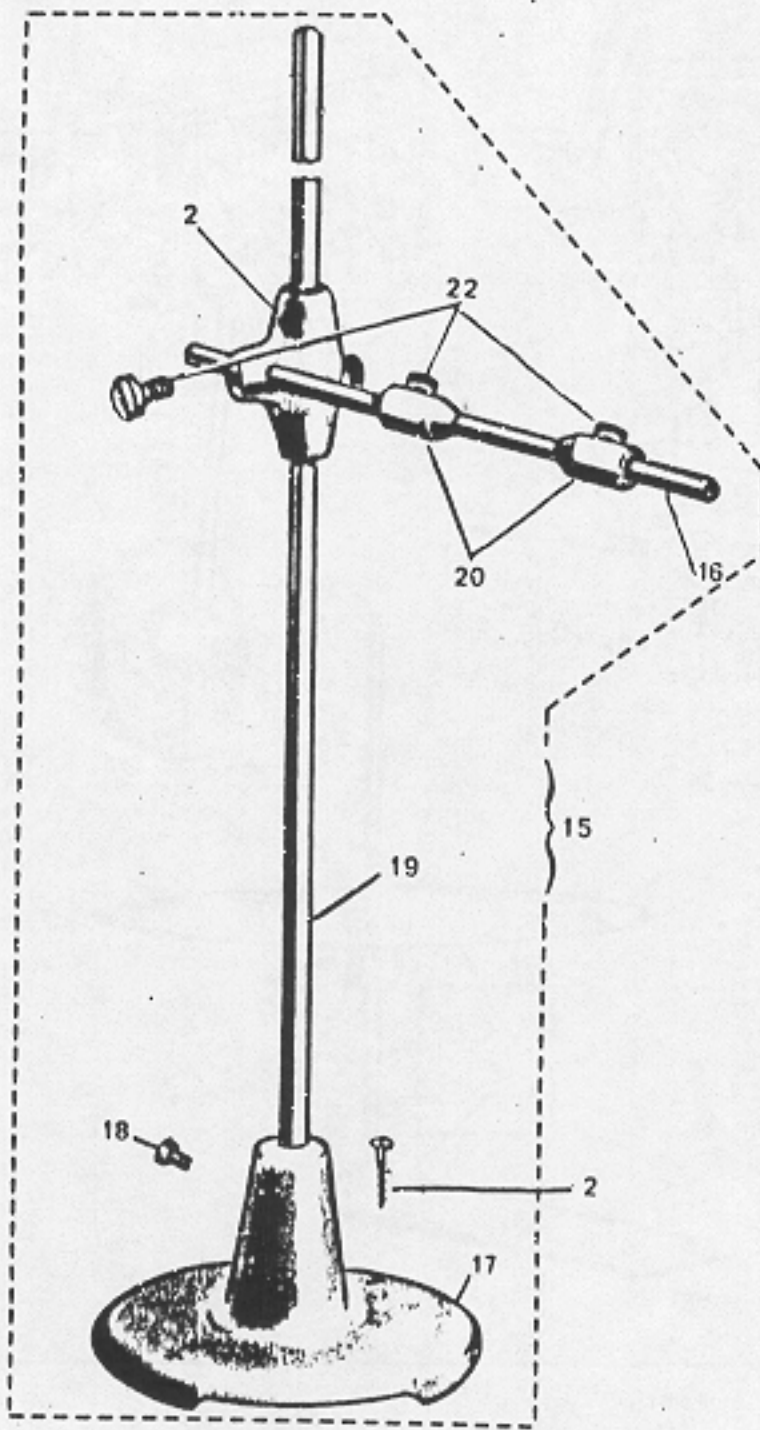
III. TECHNICAL DATA BY SUB-CLASS

HEAD No.	TECHNICAL CHARACTERISTICS							SPECIFIC USES
	No. threads	Width of bight	Diff. pos.	S P E E D		Knives	Sp. attach- ments on req.	
				No. of revs. 1" max.	St. per inch			
227-00-04	3	5/64" 9/64"	negat.	7000	8-30	si	100 101 106 107 115	ASSEMBLING OF FABRICS WITH OR WITHOUT CURLED EDGES. For perfectly straight hanging seams on warpknit nylon fabrics etc. With cutting device adjustable while the machine is in operation.
227-00-05	3	5/64" 9/64"	negat.	7000	8-30	si	100 101 106 107 115	Same as 227-00-04, but without possibility of adjusting the cutting device while the machine is in operation.
227-00-06	3	1/8" 15/64"	max.	6500	8-20	si	106 115	For medium and heavy fabrics, with a maximum presser foot throw of 19/64" - maximum bight 15/64".
227-00-09	3	3/64" 1/16"	zero	6200	20-40	si	100 106 115	For closing the toes of nylon stockings
227-00-10	2	1/16" 5/64"	zero	6200	20-40	si	100 106 115	For closing the toes of helanca and cotton socks.
227-00-11	3	3/64" 1/16"	negat.	5200	14-40	si	100 106 115	For very light nylon warpknit fabrics, etc. (15 deniers), with very fine seam.
227-00-22	3	5/64" 9/64"	negat.	7000	8-30	si	115	For perfectly straight hanging seams on warpknit nylon fabrics etc. With kneepress operated device for closing-up the stitches and securing the seam at the beginning and at the end of the execution.
227-28-07	3	3/32" 9/64"	negat.	6000	14-40	si	100 106 107 115	OVEREDGING For serging and/or overedging headsquares, vei's, scarves, etc. made from lightweight fabrics such as nylon, silk, japonette, turning the edge of the fabric into the seam.
227-28-08	3	3/64" 1/16"	negat.	6500	14-40	si	100 106 107 115	Particularly suitable for serging and/or overedging handkerchiefs, head scarves.
227-29-07	3	3/64" 1/16"	max.	6500	15-40	si	107 115	OVEREDGING WITH INSERTIONS Particularly suitable for seaming the bottom edge on ladies and children's knit underwear garments turning the edge of the fabric downwards and simultaneously inserting a fastex thread into the seam so as to avoid the linking operation.
227-30-01	3	5/64" 1/16"	negat.	6500	15-30	si	115	ATTACHING THE LACES For attaching wide lace from the top on warpknit fabrics. With tensioning device.
227-30-02	2	5/64" 9/64"	negat.	6500	15-30	si	115	For attaching wide lace fed from below by a lace rack tensioning device, on warpknit nylon fabrics, etc.

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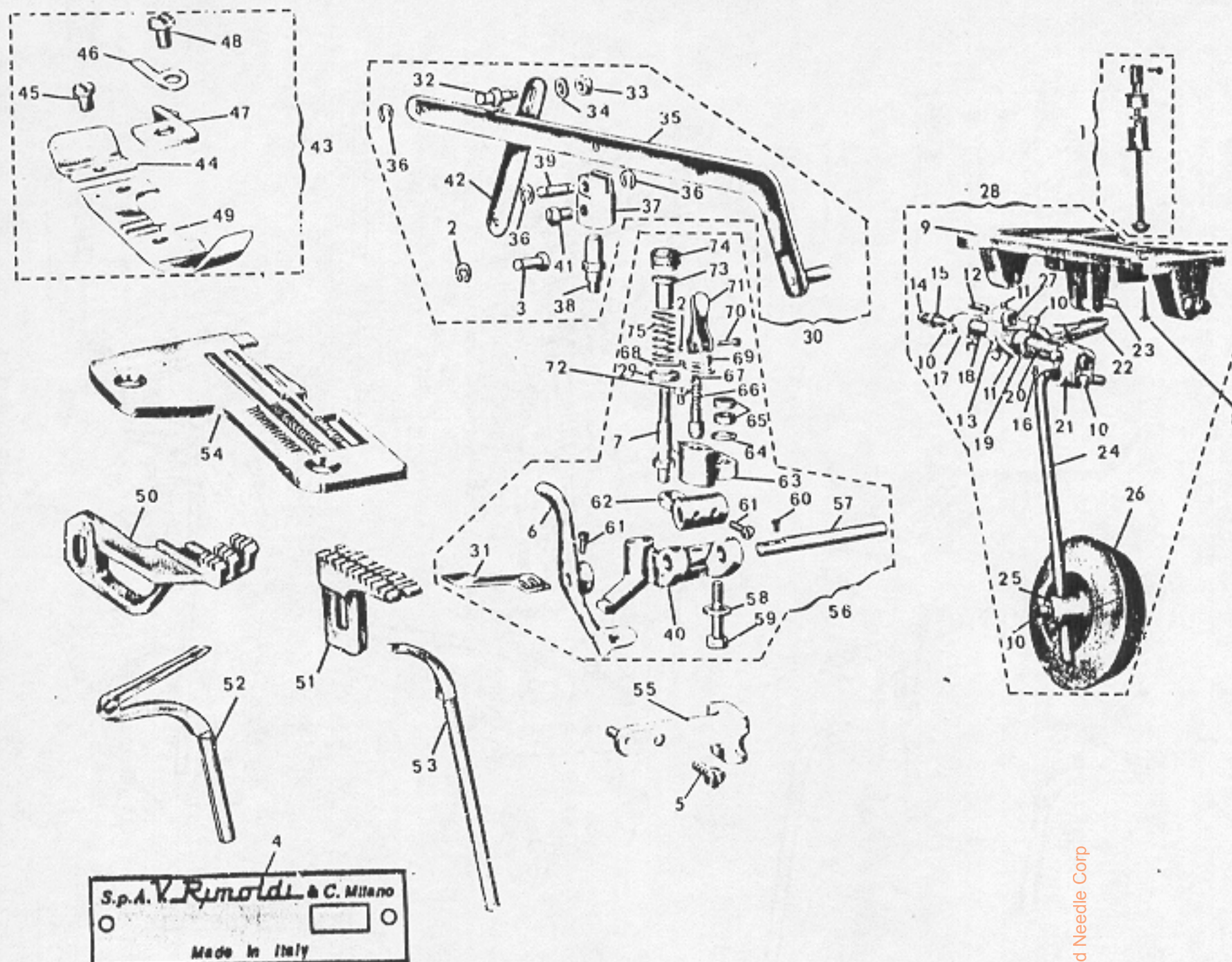
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32



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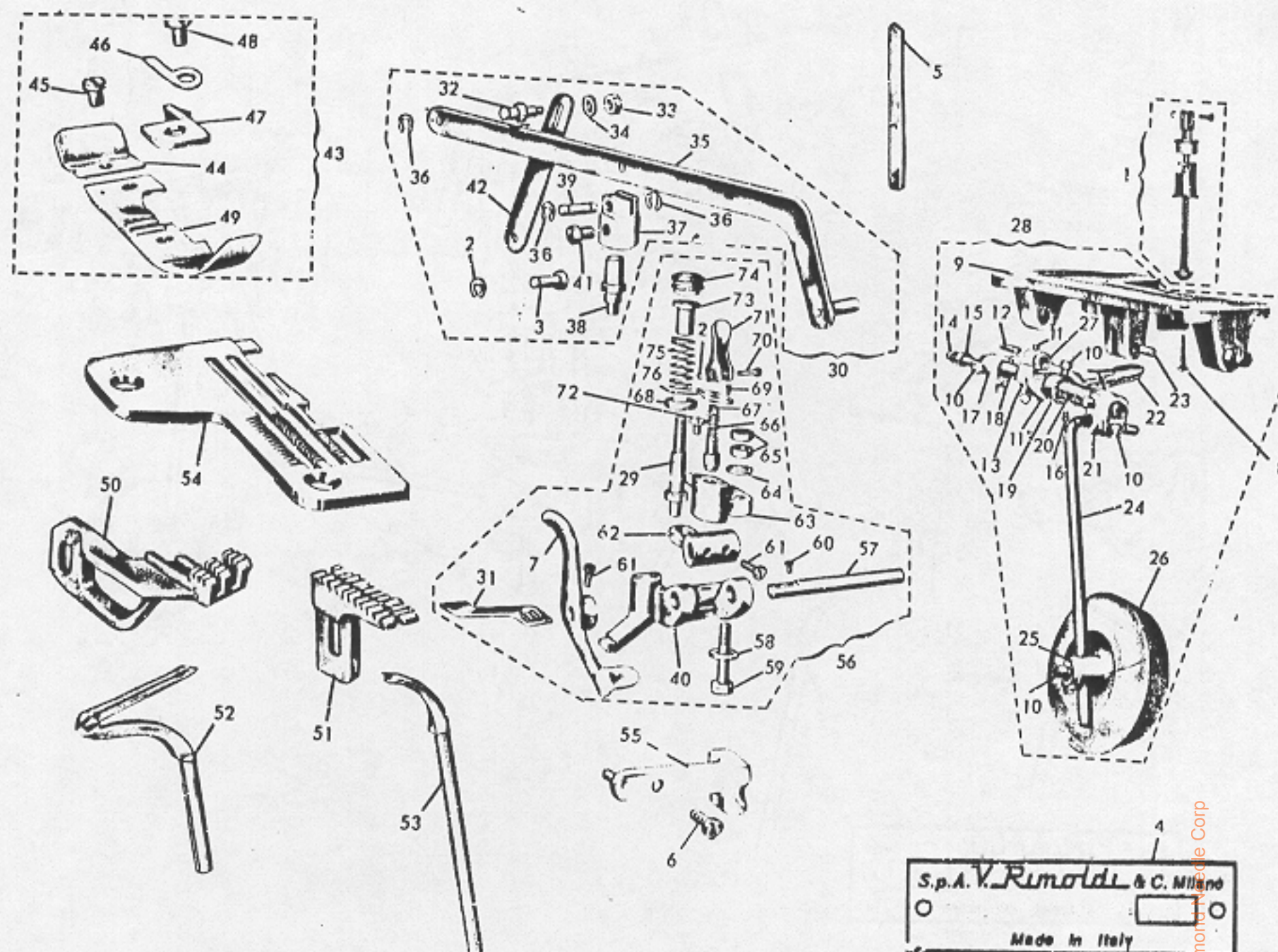
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	780253-0-00	machine class plate	1	12	004-L-8	screw	1
2	TS. 20 x 30	screw	2	13	270-R-071	plate	1
3	PM.270-R-267	tape guide, complete	1	14	270-R-184	shoe, presserfoot	1
4	057-A-3	nut	1	15	G.250-R-9373	reel stand	1
5	270-R-267	tape guide plate	1	16	605-144	bar, top	1
6	001-C-5,5	screw	1	17	01141	base, reel stand	1
7	G.270-R-181	presserfoot, complete	1	18	001-G-12	screw	1
8	270-185	chaining plate	1	19	605-143	upright	1
9	001-A-3,2	screw, chaining plate securing	1	20	605-723	tapered sleeve	2
10	270-191	chaining finger	1	21	605-937	bracket	1
11	270-196	lug, chaining plate	1	22	605-980	knurled head screw	4



33

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.270-556	actuator rod, differential assembly	1	39	27.01-PDB-520	pin, yoke	1
2	270-701	snap ring	2	40	297-PDB-401	base, shirring attachment	1
3	27.01-PDB-558	stud, securing	1	41	038-C-7	screw, securing	1
4	780363-0-00	machine class plate	1	42	27.01-PDB-516	link, rear	1
5	001-D-7	screw, block securing	1	43	G.27.01PD181	presserfoot, complete	1
6	PM.297PDB406	lever, shirring blade lifter	1	44	270-185	chaining plate	1
7	160-030	pin, for spring	1	45	001-A-3,2	screw, chaining plate mounting	1
8	TS. 22 x 35	screws, wood for securing knee control	4	46	270-196	lug, chaining plate	1
9	270-570	base, knee control	1	47	270-191	chaining finger, presserfoot	1
10	038-M-9	screw, knee control mounting	9	48	004-L-7	screw, presserfoot chaining finger mounting	1
11	005-G-6	screws, pin securing	2	49	27.01-PD-184	shoe, presserfoot	1
12	270-580	pin, knee control linkage	2	50	27.02-P-050	feed-dog, front	1
13	270-579	stop, knee control	1	51	27.02-P-051	feed-dog, rear	1
14	270-998	screw, knee control assembly	2	52	270-075	primary looper	1
15	059-P-8	nut, for knee control assembly screw	2	53	27.277-0745	secondary looper	1
16	005-L-11*	screw, set	1	54	27.03-P-114	needle plate, bight width 3/32"	1
17	270-578	lever, knee control actuator	1	55	PM2701PD417/1	block, shirring attachment retainer	1
18	270-571	shaft, knee control main	1	56	G297-PDB401	shirring attachment, complete	1
19	270-720	collar, spring pressure adjustment	1	57	297-PDB-403	shaft, shirring blade	1
20	270-575	spring, knee control disc recall	1	58	065-L-6	washer	1
21	270-572	block, knee control connection	1	59	297-PDB-418	screw, shirring attachment mounting	1
22	270-576	rocker, knee control	1	60	004-L-6	screw, shirring blade securing	2
23	270-581	pin, knee control rocker	1	61	001-E-6	screw	4
24	270-573	rod, knee control	1	62	297-PDB-407	lever, shirring blade pressure	1
25	270-574	disc, knee control	1	63	297-PDB-408	block, shirring blade mounting	1
26	270-582	pad, knee control disc	1	64	064-D-5	washer	1
27	270-577	coupling, knee control	1	65	057-P-5	nut	2
28	G.270-570	knee control assembly complete	1	66	297-PDB-444	spring, latch	1
29	240-035	cup washer, spring	1	67	297-PDB-442	pin, latch	1
30	G297-PDB-515	shirring blade lifter lever linkage assembly	1	68	297-PDB-441	guide-plate, latch pin	1
31	297-PDB-402	shirring blade	1	69	028-B-5	screw, guide-plate securing	2
32	27.01-PDB-518	pin, rear lifter lever	1	70	270-078	pin, latch lifter lever	1
33	053-D-4	nut	1	71	270-094	lever, latch lifter	1
34	070-F-4	washer	1	72	039-R-8,5	screw, shirring attachment securing	1
35	PM297-PDB515	lifter lever, shirring blade	1	73	1032/a	bushing, shirring blade pressure spring	1
36	270-702	snap ring	3	74	160-032	stud, shirring blade spring	1
37	27.01-PDB-517	yoke, shirring blade lifter lever	1	75	297-PDB-443	spring, shirring blade pressure	1
38	27.01-PDB-519	stud, lifter lever yoke mounting	1				
On request:							
G.27.01-PD-181/1						Tab. 76	
297-PDB-4021						" 76	
297-PDB-4031						" 76	

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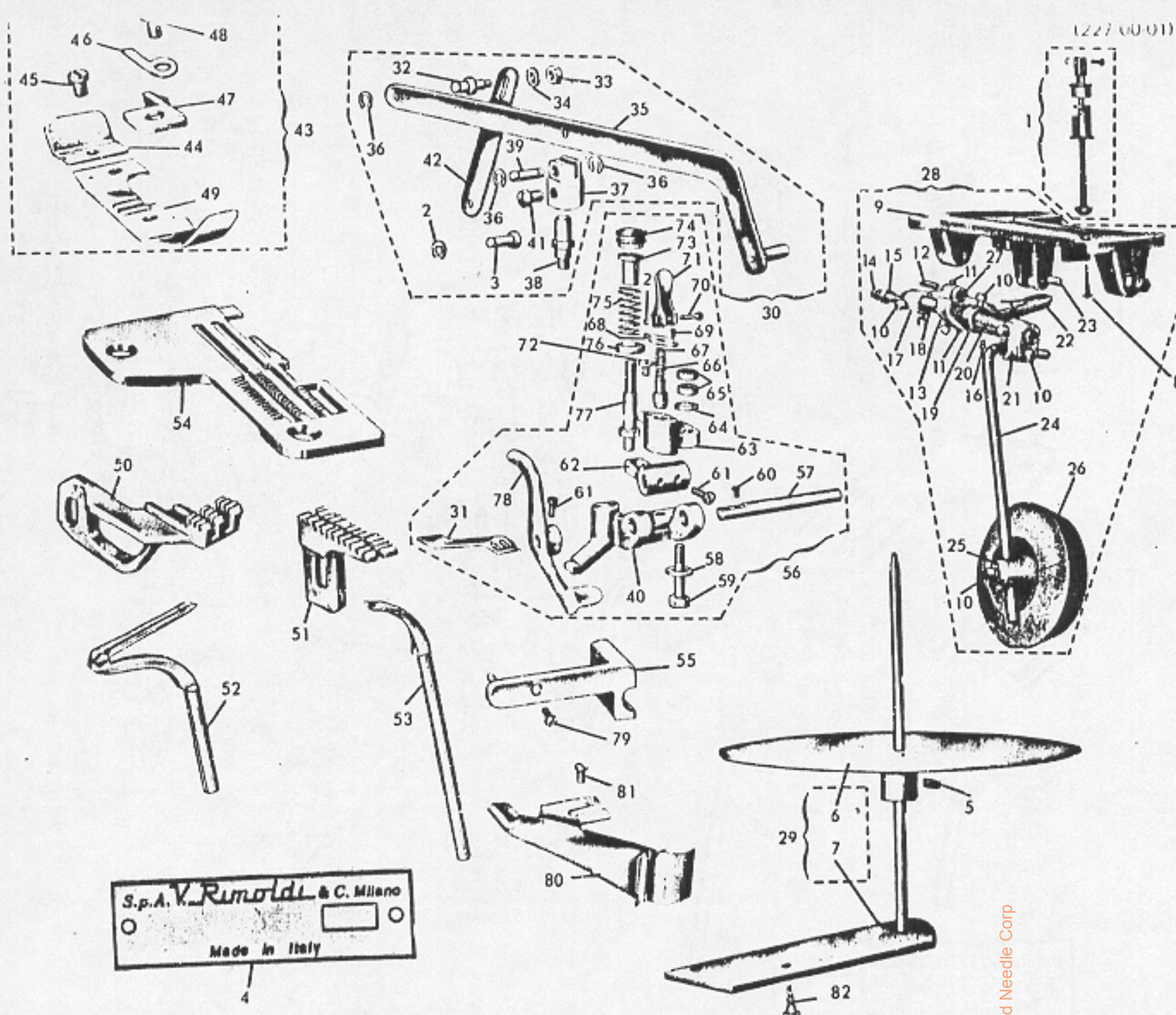


34

REF. N°	PART. N°	DESCRIPTION	QUANT	REF. N°	PART. N°	DESCRIPTION	QUANT
1	G.270-556	actuator rod, differential assembly	1	39	27.01-PDB-520	pin, yoke	1
2	270-701	snap ring	2	40	297-PDB-401	base, shirring attachment	1
3	27.01-PDB-558	stud, securing	1	41	038-C-7	screw, securing	1
4	780364-0-00	machine class plate	1	42	27.01-PDB-516	link, rear	1
5	27.01-P9-113/1	knife, lower	1	43	G2701PD9-181	presserfoot, complete	1
6	001-D-7	screw, block securing	1	44	270-185	chaining plate	1
7	PM297PDB406	lever, shirring blade lifter	1	45	001-A-3,2	screw, chaining plate mounting	1
8	TS. 22 x 35	screw, wood, for securing knee control	4	46	270-196	lug, chaining plate	1
9	270-570	base, knee control	1	47	2701-P9-191	chaining finger, presserfoot	1
10	038-M-9	screw, knee control mounting	9	48	004-L-7	screw, presserfoot chaining finger mounting	1
11	005-G-6	screws, pin securing	2	49	27.01-PD9-184	shoe, presserfoot	1
12	270-580	pin, knee control linkage	2	50	2702-P-050	feed-dog, front	1
13	270-579	stop, knee control	1	51	2702-P-051	feed-dog, rear	1
14	270-998	screw, knee control assembly	2	52	270-075	primary looper	1
15	059-P-8	nut, for knee control assembly screw	2	53	27.277-0745	secondary looper	1
16	005-L-11	screw, set	1	54	27.01-P9-114	needle plate, bight width 3/32"	1
17	270-578	lever, knee control actuator	1	55	PM2701PD417/1	block, shirring attachment retainer	1
18	270-571	shaft, knee control main	1	56	G.297-PDB-401	shirring attachment complete	1
19	270-720	collar, spring pressure adjustment	1	57	297-PDB-403	shaft, shirring blade	1
20	270-575	spring, knee control disc recall	1	58	065-L-6	washer	1
21	270-572	block knee control connection	1	59	297-PDB-418	screw, shirring attachment mounting	1
22	270-576	rocker, knee control	1	60	004-L-6	screw, shirring blade securing	2
23	270-581	pin, knee control rocker	1	61	001-E-6	screw	4
24	270-573	rod, knee control	1	62	297-PDB-407	lever, shirring blade pressure	1
25	270-574	disc, knee control	1	63	297-PDB-408	block, shirring blade mounting	1
26	270-582	pad, knee control disc	1	64	064-D-5	washer	1
27	270-577	coupling, knee control	1	65	057-P-5	nut	2
28	G.270-570	knee control assembly, complete	1	66	297-PDB-444	spring, latch	1
29	160-030	pin, for spring	1	67	297-PDB-442	pin, latch	1
30	G.297-PDB-515	shirring blade lifter lever linkage assembly	1	68	297-PDB-441	guide-plate, latch pin	1
31	297-PDB-402	shirring blade	1	69	028-B-5	screw, guide-plate securing	2
32	27.01-PDB-518	pin, rear lifter lever	1	70	270-078	pin, latch lifter lever	1
33	053-D-4	nut	1	71	270-094	lever, latch lifter	1
34	070-F-4	washer	1	72	039-R-8,5	screw, shirring attachment securing	1
35	PM.297-PDB-515	lever, shirring blade lifter	1	73	1032/a	bushing, shirring blade pressure spring	1
36	270-702	snap ring	3	74	160-032	stud, shirring blade spring	1
37	27.01-PDB-517	yoke, shirring blade lifter lever	1	75	297-PDB-443	spring, shirring blade pressure	1
38	27.01-PDB-519	stud, lifter lever yoke mounting	1	76	240-035	cup washer, spring	1

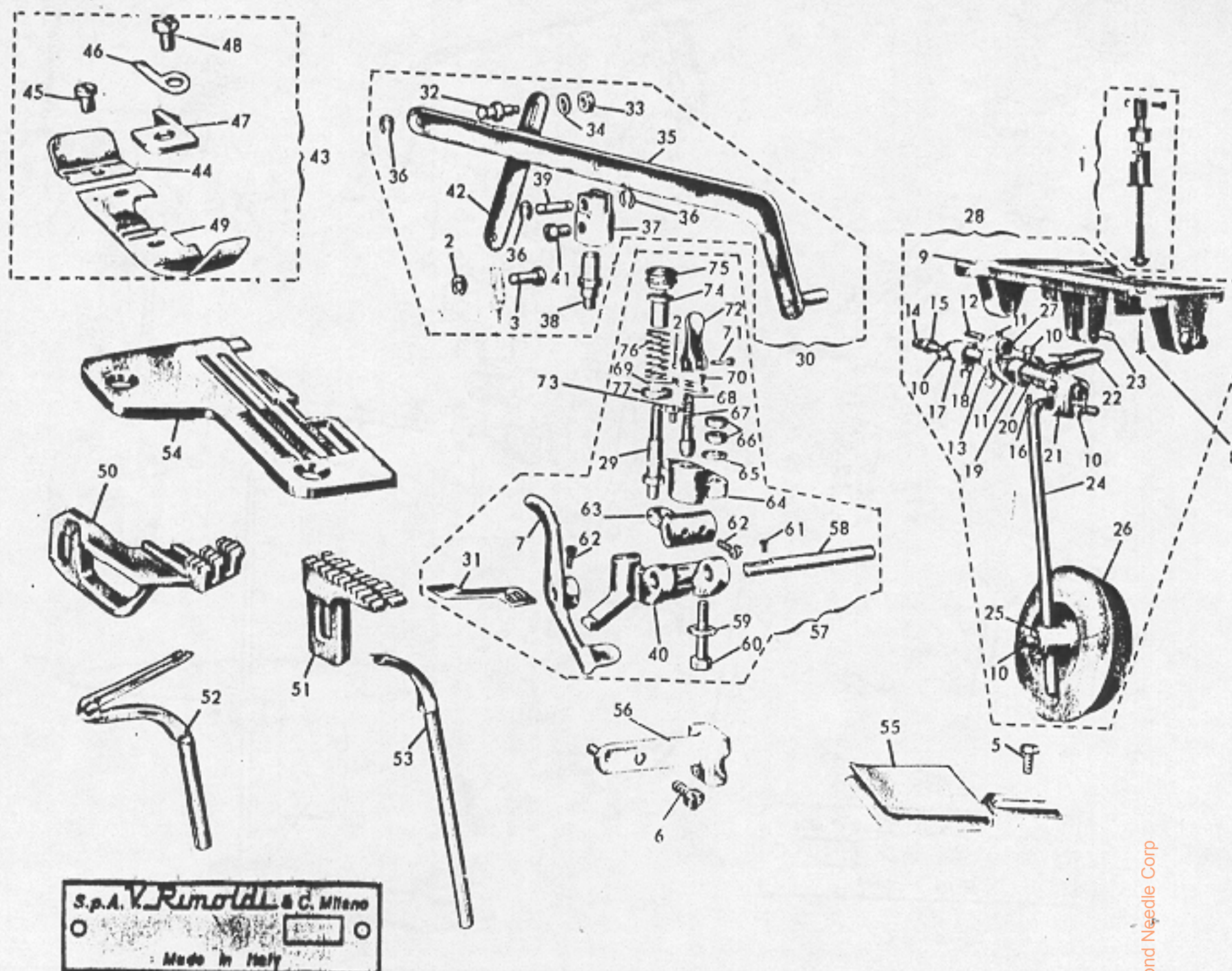
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27.01-P-114/1 Tab. 75
G.27.01-PD-181/1 " 76
297-PDB-4021 " 76
297-PDB-4031 " 76

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REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.270-556	actuator rod, differential assembly	1	42	27.01-PDB-516	link, rear	1
2	270-701	snap ring	2	43	G2701PDBO181	presserfoot, complete, for 2mm. ornam. cord	1
3	27.01-PDB-558	stud, securing	1	44	270-185	chaining plate	1
4	780387-0-00	machine class plate	1	45	001-A-3,2	screw, chaining plate securing	1
5	017-E-7	grub screw	1	46	270-196	lug, presserfoot	1
6	PM2726PDBO1425	complete plate assembly	1	47	270-191	chaining finger, presserfoot	1
7	PM.602-141/1	base plate with upright	1	48	004-L-7	screw, chaining finger securing	1
8	TS.22x35	screws, knee control securing	4	49	2701PDBO184	shoe, presserfoot	1
9	270-570	base, knee control	1	50	2702-P-050	feed-dog, front	1
10	038-M-9	screw, knee control mounting	9	51	27.02-P-051	feed-dog, rear	1
11	005-G-6	screw, pin securing	2	52	270-075	primary looper	1
12	270-580	pin, knee control linkage	2	53	27.277-0745	secondary looper	1
13	270-579	stop, knee control	1	54	27.03-P-114	needle plate, bight width 3/32"	1
14	270-998	screw, knee control assembly	2	55	PM2701PD417/1	block, shirring attachment retainer	1
15	059-P-8	nut, knee control assembly screw	2	56	G.297-PDB-401	shirring attachment complete	1
16	005-L-11	screw, set	1	57	297-PDB-403	shaft, shirring blade	1
17	270-578	lever, knee control actuator	1	58	065-L-6	washer	1
18	270-571	shaft, knee control main	1	59	297-PDB-418	screw, shirring attachment mounting	1
19	270-720	collar, spring pressure adjustment	1	60	004-L-6	screw, shirring blade securing	2
20	270-575	spring, knee control disc recall	1	61	001-E-6	screw	4
21	270-572	block, knee control connection	1	62	297-PDB-407	lever, shirring blade pressure	1
22	270-576	rocker, knee control	1	63	297-PDB-408	block, shirring blade mounting	1
23	270-581	pin, knee control rocker	1	64	064-D-5	washer	1
24	270-573	rod, knee control disc	1	65	057-P-5	nut	2
25	270-574	disc, knee control	1	66	297-PDB-444	spring latch	1
26	270-582	pad, knee control disc	1	67	297-PDB-442	pin, latch	1
27	270-577	coupling, knee control	1	68	297-PDB-441	guide-plate, latch pin	1
28	G.270-570	knee control assembly complete	1	69	028-B-5	screw, guide-plate securing	2
29	G2726PDBO9375	reel stand complete	1	70	270-078	pin, latch lifter	1
30	G.297-PDB-515	shirring blade lifter lever linkage assembly	1	71	270-094	lever, latch lifter	1
31	297-PDB-402	shirring blade	1	72	039-R-8,5	screw, shirring attachment securing	1
32	2701-PDB-518	pin, rear lifter lever	1	73	1032/a	bushing, shirring blade pressure spring	1
33	053-D-4	nut	1	74	160-032	stud, shirring blade spring	1
34	070-F-4	washer	1	75	297-PDB-443	spring shirring blade pressure	1
35	PM297-PDB515	lever, shirring blade lifter	1	76	240-035	cup washer for spring	1
36	270-702	snap ring	3	77	160-030	pin, for spring	1
37	2701-PDB-517	yoke, shirring blade lifter lever	1	78	PM297PDB406	lever, shirring blade lifter	1
38	2701-PDB-519	pin, lifter lever mounting	1	79	001-D-7	screw, retainer block securing	1
39	2701-PDB-520	pin, yoke	1	80	PM297PDBO413	guide for 2 mm. ornamental cord	1
40	297-PDB-401	base, shirring attachment	1	81	001-E-7	screws, guide mounting	2
41	038-C-7	screw, securing	1	82	TS. 20 x 30	screws, reel standing mounting	2
On request:							
297-PDB-4021							Tab. 76
297-PDB-4031							" 76

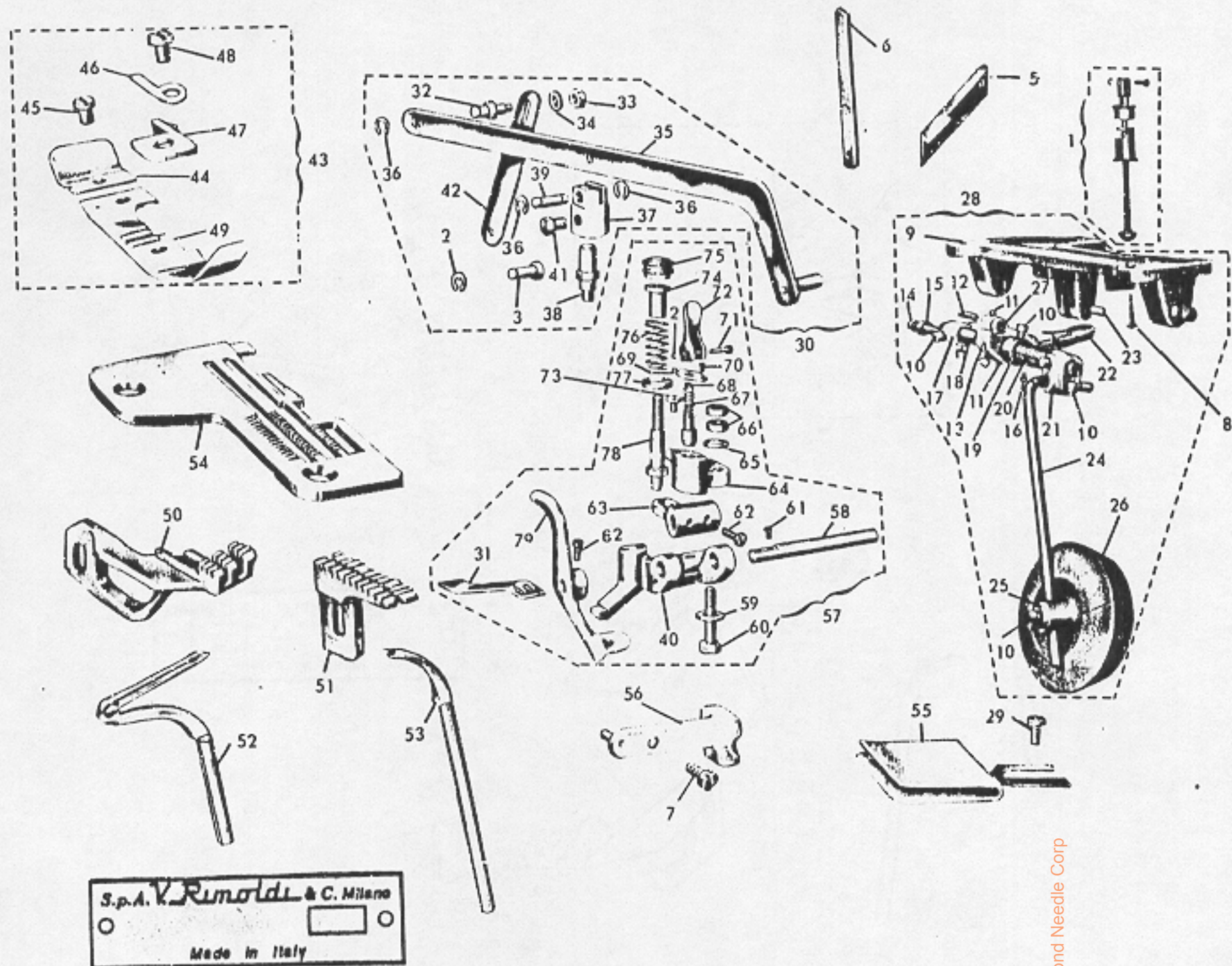
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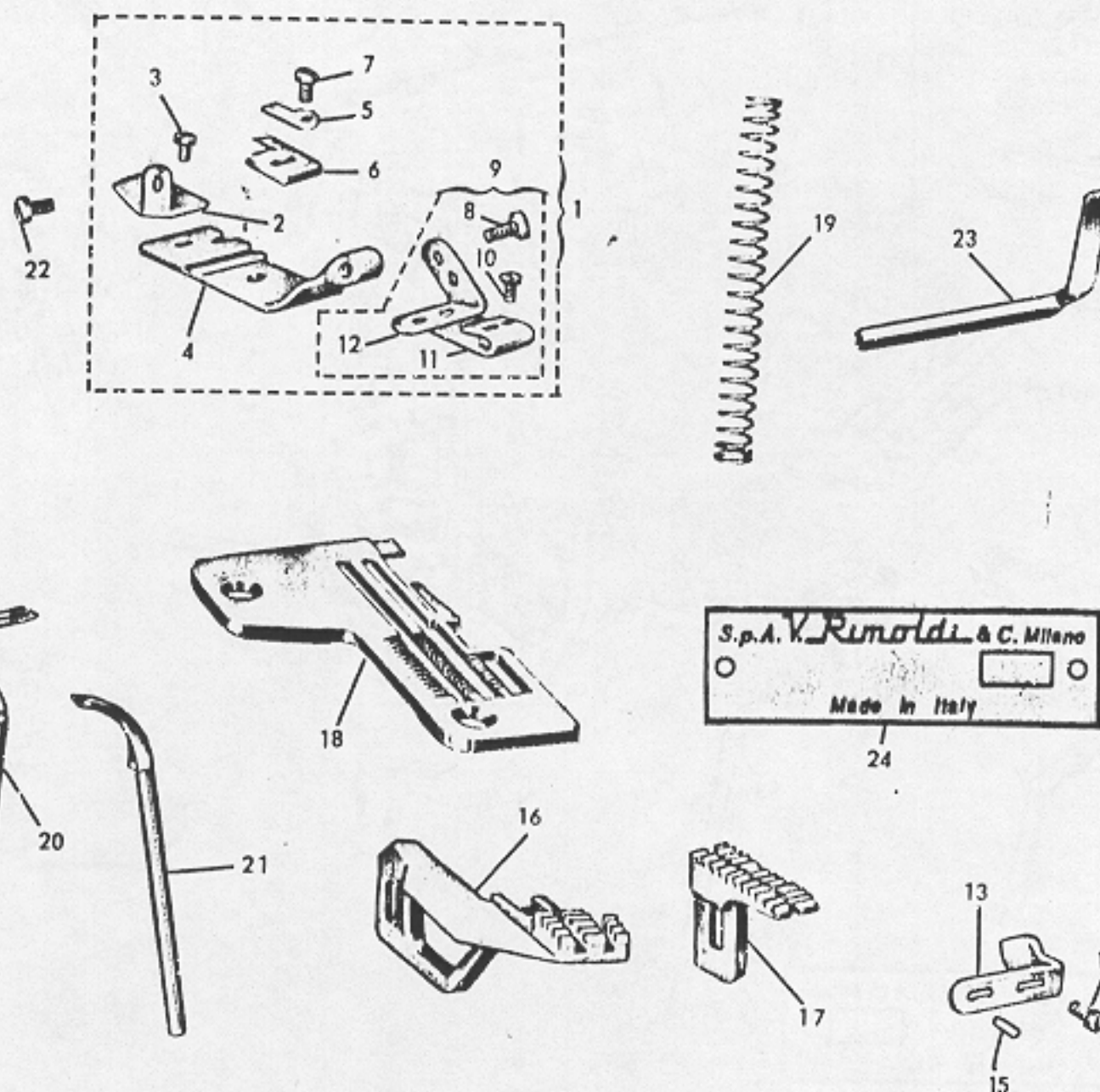
36

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REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.270-556	actuator rod, differential-assembly	1	40	27.01-PDB-401	base, shirring attachment	1
2	270-701	snap ring	2	41	038-C-7	screw, securing	1
3	27.01-PDB-558	stud, securing	1	42	27.01-PDB-516	link, rear	1
4	780382-0-00	machine class plate	1	43	G.27.01-PD-181	presserfoot, complete	1
5	001-E-7	screw, guide mounting	2	44	270-185	chaining plate	1
6	001-D-7	screw, block securing	1	45	001-A-3,2	screw, chaining plate mounting	1
7	PM297-PDB-406	lever, shirring blade lifter	1	46	270-196	lug, presserfoot	1
8	TS. 22 x 35	wood screw, knee control securing	4	47	270-191	chaining finger, presserfoot	1
9	270-570	base, knee control	1	48	004-L-7	screw, presserfoot chaining finger	1
10	038-M-9	screw, knee control mounting	9	49	27.01-PD-184	shoe, presserfoot	1
11	005-G-6	screw, pin securing	2	50	27.01-P-050	feed-dog, front	1
12	270-580	pin, knee control linkage	2	51	27.01-P-051	feed-dog, rear	1
13	270-579	stop, knee control	1	52	270-075	primary looper	1
14	270-998	screw, knee control assembly	2	53	27.777-0745	secondary looper	1
15	059-P-8	nut, for knee control assembly screw	2	54	27.03-P-114	needle plate, bight width 3/32"	1
16	005-L-11	screw, set	1	55	PM.27.03PDB413	guide-plate, lace	1
17	270-578	lever, knee control actuator	1	56	PM2701PD417/1	block, shirring attachment retainer	1
18	270-571	shaft, knee control main	1	57	G297PDB401	shirring attachment complete	1
19	270-720	collar, spring pressure adjustment	1	58	297-PDB-403	shaft, shirring blade	1
20	270-575	spring, knee control disc recall	1	59	065-L-6	washer	1
21	270-572	block, knee control connection	1	60	297-PDB-418	screw, shirring attachment mounting	1
22	270-576	rocker, knee control	1	61	004-L-6	screw, shirring blade securing	2
23	270-581	pin, knee control rocker	1	62	001-E-6	screw	4
24	270-573	rod, knee control	1	63	297-PDB-407	lever, shirring blade pressure	1
25	270-574	disc, knee control	1	64	297-PDB-408	block, shirring blade mounting	1
26	270-582	pad, knee control disc	1	65	064-D-5	washer	1
27	270-577	coupling, knee control	1	66	057-P-5	nut	1
28	G.270-570	knee control assembly, complete	1	67	297-PDB-444	spring, latch	2
29	160-030	pin, for spring	1	68	297-PDB-442	pin, latch	1
30	G.297-PDB-515	shirring blade lifter lever linkage assembly	1	69	297-PDB-441	guide-plate, latch pin	1
31	297-PDB-402	shirring blade	1	70	028-B-5	screw, guide-plate securing	2
32	27.01-PDB-518	pin, rear lifter lever	1	71	270-078	pin, latch lifter lever	1
33	053-D-4	nut	1	72	290-094	lever, latch lifter	1
34	070-F-4	washer	1	73	039-R-8,5	screw, shirring attachment securing	1
35	PM297PDB515	lever, shirring blade lifter	1	74	1032/a	bushing, shirring blade pressure spring	1
36	270-702	snap ring	3	75	160-032	stud, shirring blade spring	1
37	27.01-PDB-517	yoke, shirring blade lifter lever	1	76	297-PDB-443	spring, shirring blade pressure	1
38	27.01-PDB-519	stud, lifter lever yoke mounting	1	77	240-035	cup washer, spring	1
39	27.01-PDB-520	pin, lifter lever yoke	1				
				On request: 27.01-P-114			
				Tab. 75			



REF. N°	PART. N°	DESCRIPTION	QUANT	REF. N°	PART. N°	DESCRIPTION	QUANT
1	G.270-556	actuator rod, differential-assembly	1	41	038-C-7	screw securing	1
2	270-701	snapring	2	42	27.01-PDB-516	link, rear	1
3	27.01-PDB-558	stud, securing	1	43	G.27.01-PD-9-181	presserfoot, complete	1
4	780383-0-00	machine class plate	1	44	270-185	chaining plate	1
5	279-112	knife, upper	1	45	001-A-3,2	screw, chaining plate mounting	1
6	27.01-P9-113/1	knife, lower	1	46	270-196	lug, presserfoot	1
7	001-D-7	screw, block securing	1	47	27.01-P9-191	chaining finger, presserfoot	1
8	TS. 22 x 35	wood screw, knee control securing	4	48	004-L-7	screw, presserfoot chaining finger mounting	1
9	270-570	base, knee control	1	49	27.01-PD9-184	shoe, presserfoot	1
10	038-M-9	screw, knee control mounting	9	50	27.01-P-050	feed-dog, front	1
11	005-G-6	screw, pin securing	2	51	27.01-P-051	feed-dog, rear	1
12	270-580	pin, knee control linkage	2	52	270-075	primary looper	1
13	270-579	stop, knee control	1	53	27.277-0745	secondary looper	1
14	270-998	screw, knee control assembly	2	54	27.01-P9-114	needle plate, bight width 3/32"	1
15	059-P-8	nut, for knee control assembly screw	2	55	PM2703PDB413	guide, lace	1
16	005-L-11	screw, set	1	56	PM2701PD417/1	block, shirring attachment retainer	1
17	270-578	lever, knee control actuator	1	57	G297-PDB-401	shirring attachment complete	1
18	270-571	shaft, knee control main	1	58	297-PDB-403	shaft, shirring blade	1
19	270-720	collar, spring pressure adjustment	1	59	065-L-6	washer	1
20	270-575	spring, knee control disc recall	1	60	297-PDB-418	screw, shirring attachment mounting	1
21	270-572	block, knee control connection	1	61	004-L-6	screw, shirring blade securing	2
22	270-576	rocker, knee control	1	62	001-E-6	screw	4
23	270-581	pin, knee control rocker	1	63	297-PDB-407	lever, shirring blade pressure	1
24	270-573	rod, knee control	1	64	297-PDB-408	block, shirring blade mounting	1
25	270-574	disc, knee control	1	65	064-D-5	washer	1
26	270-582	pad, knee control disc	1	66	057-P-5	nut	2
27	270-577	coupling, knee control	1	67	297-PDB-444	spring, latch	1
28	G.270-570	knee control assembly, complete	1	68	297-PDB-442	pin, latch	1
29	001-E-7	screw, guide mounting	1	69	297-PDB-441	guide-plate, latch pin	2
30	G.297-PDB-515	lever, shirring blade lifter lever linkage ass.	1	70	028-B-5	screw, guide-plate securing	2
31	297-PDB-402	shirring blade	1	71	270-078	pin, latch lifter lever	1
32	27.01-PDB-518	pin, rear lifter lever	1	72	270-094	lever, latch lifter	1
33	053-D-4	nut	1	73	039-R-8,5	screw, shirring attachment securing	1
34	070-F-4	washer	1	74	1032/a	bushing, shirring blade pressure spring	1
35	PM297PDB515	lever, shirring blade lifter	1	75	160-032	stud, shirring blade spring	1
36	270-702	snap ring	3	76	297-PDB-443	spring, shirring blade pressure	1
37	27.01-PDB-517	yoke, shirring blade lifter lever	1	77	240-035	cup washer, spring	1
38	27.01-PDB-519	stud, lifter lever yoke mounting	1	78	160-030	pin, for spring	1
39	27.01-PDB-520	pin, yoke	1	79	PM.297-PDB-406	lever, shirring blade lifter	1
40	297-PDB-401	base, shirring attachment	1				

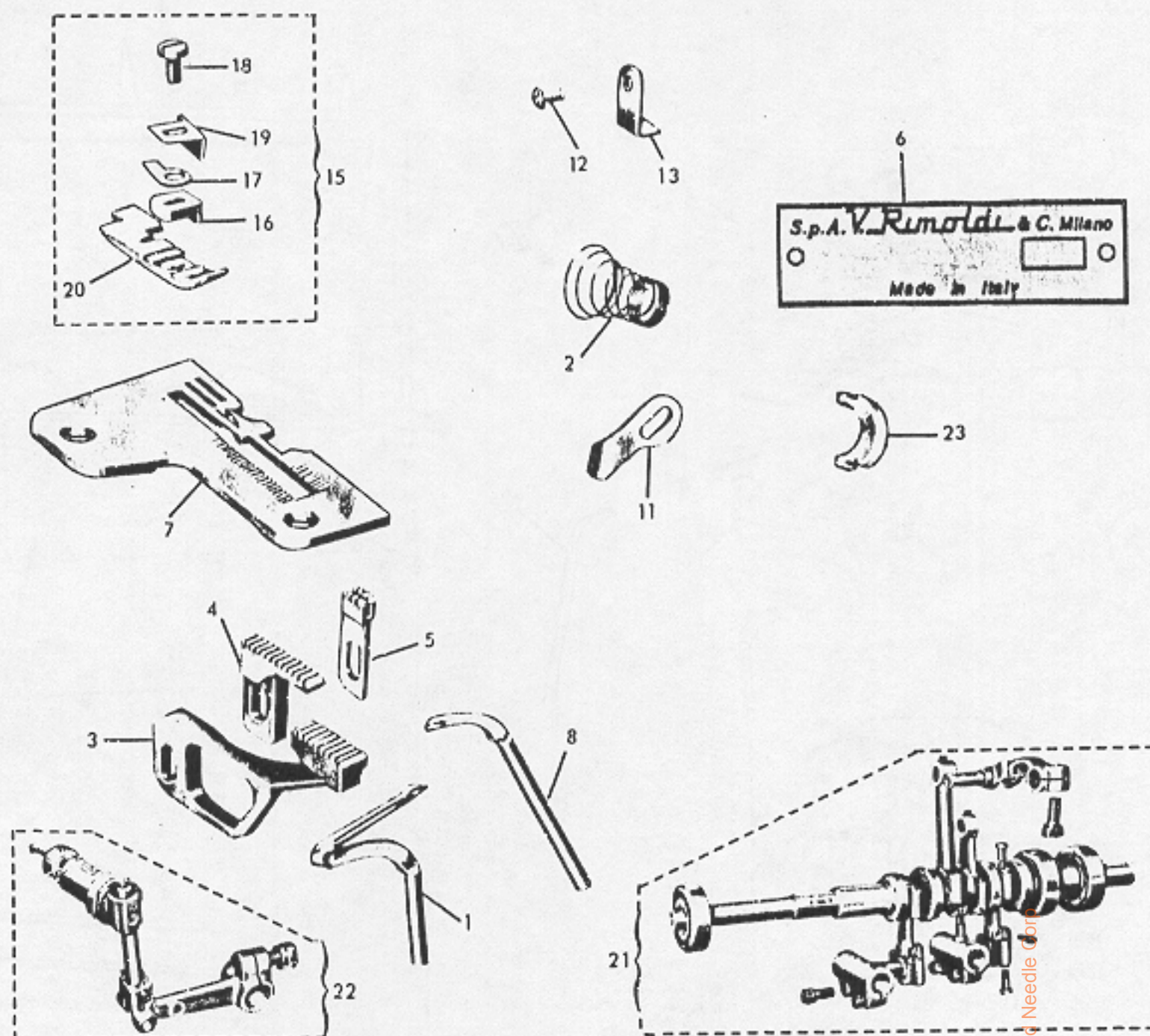


38

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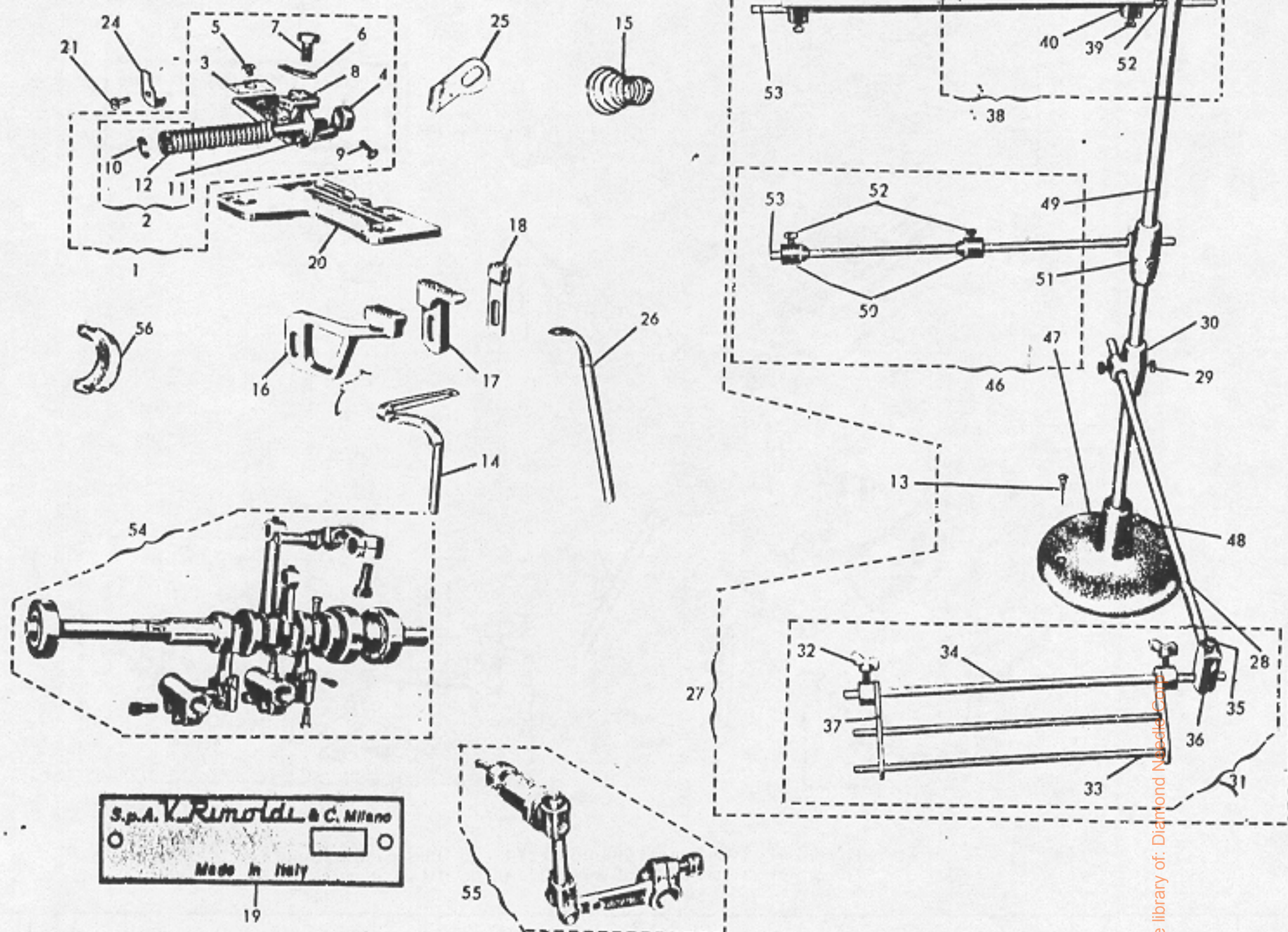
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.27.03-PG-181	presserfoot complete	1	13	27.03-PG-408	knife guard guide-plate	1
2	27.01-P-185	chaining plate	1	14	001-D-7	guide-plate screw	2
3	004-H-5	screw	1	15	27.03-PG-421	guide-plate pin	1
4	27.01-P-184	shoe presserfoot	1	16	27.03-PG-050	feed-dog, front	1
5	270-196	lug, chaining plate	1	17	27.01-P-051	feed-dog, rear	1
6	270-191	finger, chaining	1	18	27.01-P-114	needle plate	1
7	004-L-7	screw	1	19	27.01-P-092	spring, presserfoot pressure	1
8	002-C-8	screw	1	20	270-075	primary looper	1
9	PM.27.03-PG-401	stop plate	1	21	27.277-0745	secondary looper	1
10	27.01-P-404	screw	2	22	27.01-P-403/1	screw, presserfoot mounting	1
11	27.03-PG-402	pressure blade	1	23	272-B-107	needle-guard, front	1
12	27.01-P-401	angle stop	1	24	780384-0-00	machine class plate	1

76

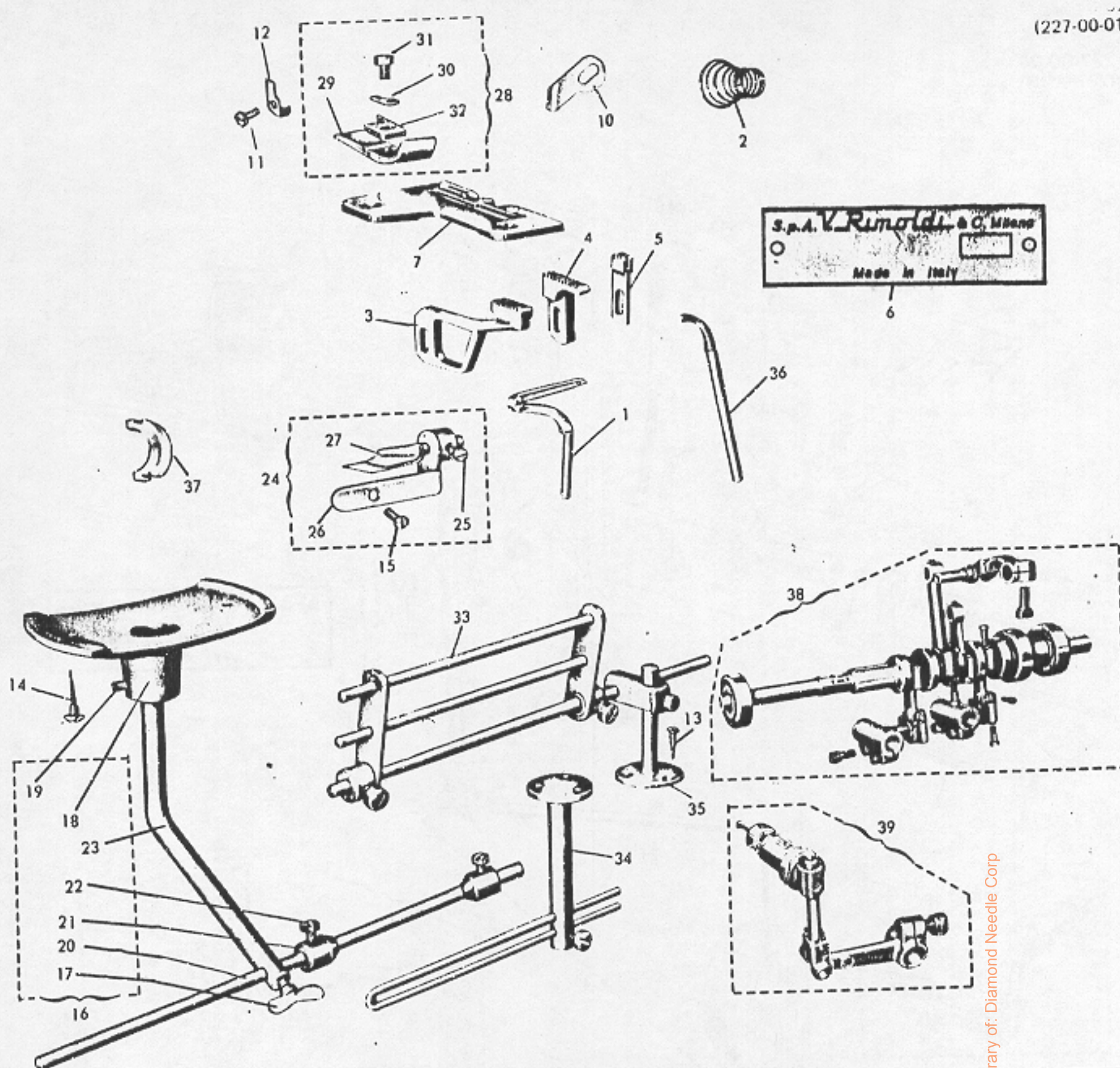


N.B. To convert a type 227-00-05 into a 227-00-05-100 see illustration 72-73
To convert a type 227-00-05 into a 227-00-05-101 see illustration 74

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-0751	primary looper	1	13	272-186	angle stop, presserfoot	1
2	270-232/1	spring, primary looper tension	1	15	G.272-B2-181	presserfoot, complete	1
3	272-B-050	feed-dog, front	1	16	272-B-191	chaining finger	1
4	272-B-051	feed-dog, rear	1	17	270-196	lug, chaining plate	1
5	272-B-052	feed-dog, chaining	1	18	004-L-8	screw	1
6	780205-0-00	machine class plate	1	19	272-B-183	chaining plate	1
7	272-B-1141	needle plate, bight width 5/64"	1	20	272-B2-184	shoe, presserfoot	1
8	270-074	secondary looper	1	21	G.27.21-C2-009/4	main shaft assembly with connecting rods	1
11	128-110	waste trimming shield	1	22	G.27.21-C2-067/3	looper drive shaft with connecting rods	1
12	27.01-P-403/1	screw, angle mounting	1	23	27.21-C2-617	rocker	1
				24			
						On request:	
						272-092	Tab. 75
						272-B-0501	" 75
						272-B-0511	" 76
						272-B-114	" 76
						272-B-114/1	" 76



REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.272-BMG-1810	presserfoot, complete	1	20	272-MG-937	bracket	1
2	PM.272BMG1990	roller	1	31	G.272-MG-4192	feed control, lower	1
3	272-B-185	chaining plate	1	32	PM.602-E-4364	wing nut	2
4	272-BMG-1840	shoe, presserfoot	1	33	PM.272-MG-4302	frame-plate, with rod	1
5	001-A-3,2	screw	1	34	272-MG-4212	rod	1
6	270-196	lug, chaining plate	1	35	038-C-7	screw	2
7	004-L-7	screw	1	36	272-MG-4242	block, coupling	1
8	272-1911	chaining finger	1	37	PM.272-MG-4342	plate, width adjustment	1
9	004-F-3	screw	1	38	G.272-MG-4412	feed control, upper	1
10	270-701	snap ring	1	39	039-C 10,5	screw	2
11	272-BMG-1990	pin	1	40	272-MG-4332	block, mounting	2
12	272-NG-197	roller	1	41	272-MG-4412	drag hinge	2
13	TS.20x30	screw	1	42	160-030	pin	2
14	270-0751	primary looper	2	43	160-032	screw, adjustment	2
15	270-232/1	spring, primary looper thread take-up	1	44	1032/A	bushing	2
16	272-B-050	feed-dog, front	1	45	150-232/1	spring	2
17	272-B-051	feed-dog, rear	1	46	G.S.45-937	reel carrier, complete	1
18	272-B-052	feed-dog, chaining	1	47	01141	base	1
19	780450-0-00	machine class plate	1	48	001-G-12	screw	1
20	272-B-1141	needle plate, bight width 5/64"	1	49	505-140	upright	1
21	27.01-P-403/1	screw, angle stop mounting	1	50	505-723	sleeve, tapered	2
24	2726-186	stop, presserfoot	1	51	605-937	bracket	1
25	128-110	trimming shield, waste	1	52	605-930	screw, set	5
26	270-074	secondary looper	1	53	505-141	pin	2
27	AS.272-MG-937	feed system, 5" face controlled	1	54	G.27.21-C2-009/4	main shaft assembly with connecting rods	1
28	272-MG-4333	bar	1	55	G.27.21-C2-057/3	looper drive shaft with connecting rods	1
29	605-980	lock-screw	2	56	27.21-C2-617	rocker	1
				On request:			
				272-B-114		Tab. 76	
				272-B-114/1		" 76	
				AS.272-MG-9371		" 77	



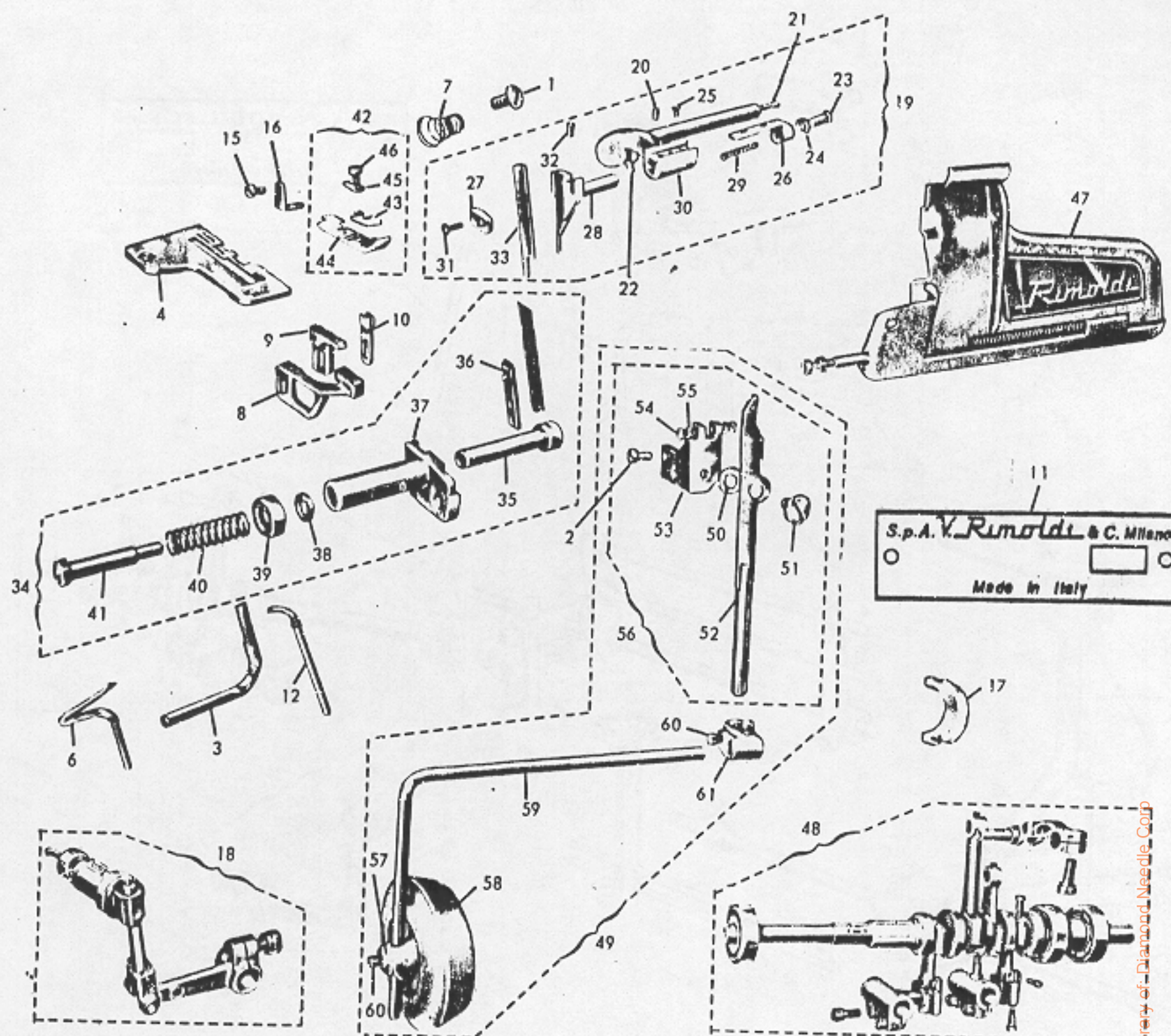
41

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-0751	primary looper	1	21	505-723	sleeve, tapered	2
2	270-232/1	spring, primary looper thread take-up	1	22	605-980	screw, set	2
3	272-B-050	feed-dog, front	1	23	505-144	pin	1
4	272-B-051	feed-dog, rear	1	24	G.27.21-OG-4014	lace guide	1
5	272-B-052	feed-dog, chaining	1	25	003-A-4,5	screw	1
6	780.451-0-00	machine class plate	1	26	PM.274-417	guide-plate	1
7	272-B-1141	needle plate, bight width 5/64"	1	27	PM.27.21-OG-4024	guide blade	1
				28	G.27.21-OG-1814	presserfoot, complete	1
				29	27.21-OG-1844	shoe, presserfoot	1
				30	270-196	lug, chaining plate	1
10	128-110	trimming shield, waste	1	31	004-L-7	screw	1
11	27.01-P-403/1	screw, angle stop mounting	1	32	27.21-CC-191	chaining finger	1
12	272-186	stop, presserfoot	1	33	G.27.21-OG-4194	control, lace feed	1
13	TS.18 x 20	screw	9	34	G.27.21-OG-4414	device, lace guide	2
14	TS.20 x 30	screw	2	35	PM.27.21-OG-4054	rod, feed control bearing	1
15	001-D-7	screw, guide-plate securing	1	36	27.221-C-074/1	secondary looper, blind	1
16	G.27.21-OG-1414	reel carrier assembly	4	37	27.21-C2-617	rocker	1
17	PM.602-E-4364	wing-nut	1	38	G.27.21-C2-009/4	main shaft assembly with connecting rods	1
18	602-E-1414	base	1	39	G.27.21-C2-067/3	looper drive shaft with connecting rods	1
19	016-F-10	grub screw	1				
20	27.21-OG-1434	reel bar	1				
						On request:	
						272-092	Tab. 75
						272-B-0501	" 75
						272-B-0511	" 76
						272-B-114	" 76
						272-B-114/1	" 76

INSTRUCTIONS : FOR

- INSTALLATION AND TIMING**
- USE**
- MAINTENANCE**

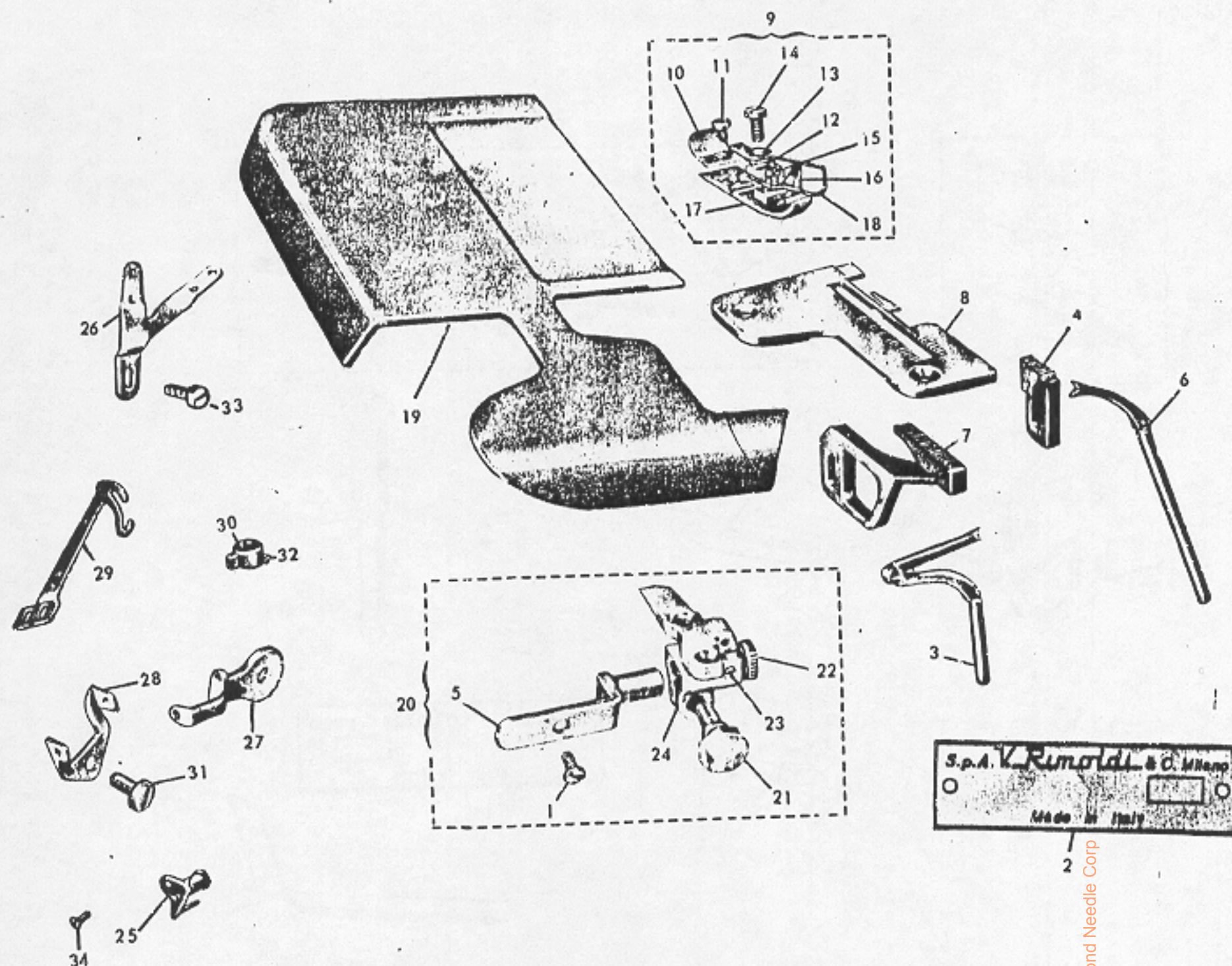
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42

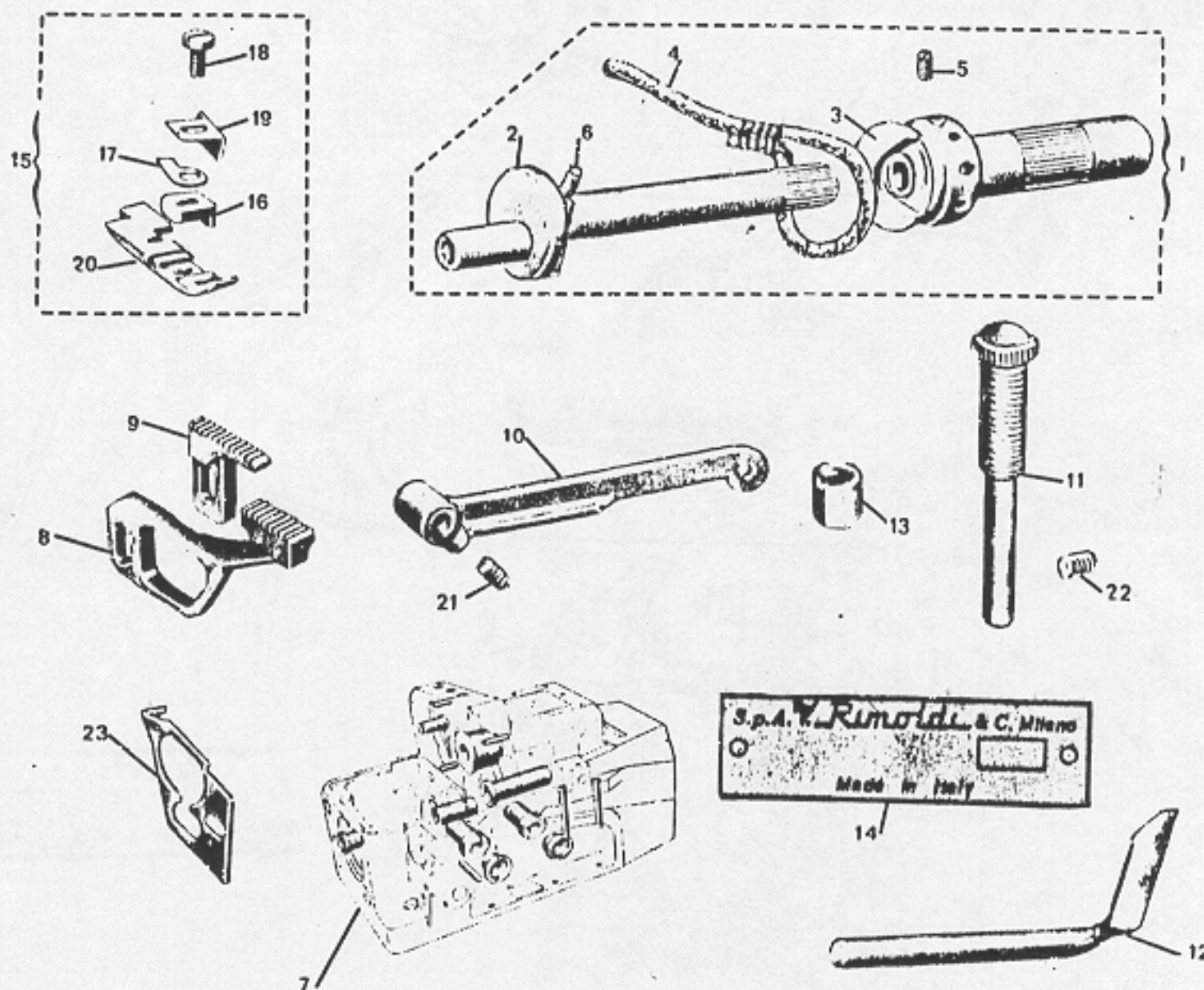
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REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	003-M-7	screw	1	32	255-442	pin	1
2	026-G-10	screw, lever lock	1	33	272-BK-112	knife	1
3	272-BK-107	needle guard, front	1	34	G.272-BK-104	knife holder, complete lower	1
4	272-BK-114	needle plate, bight width 3/32"	1	35	272-BK-1051	shaft	1
6	270-0751	primary looper	1	36	PM.272-BK-110	plate	1
7	270-232/1	spring, primary looper thread take-up	1	37	272-BK-104	knife holder	1
8	272-B-050	feed-dog, front	1	38	071-D-7	washer	1
9	272-B-051	feed-dog, rear	1	39	272-BK-994	washer, cup	1
10	272-B-052	feed-dog, chaining	1	40	272-BK-976	spring	1
11	780.204-0-00	machine class plate	1	41	272-BK-985	screw	1
12	270-074	secondary looper	1	42	G.272-BK-181	presserfoot, complete	1
15	27.01-P403/1	screw, angle stop mounting	1	43	272-BK-191	chaining finger	1
16	272-186	angle stop, presserfoot	1	44	272-BK-184	shoe, presserfoot	1
17	27.21-C2-617	rocker	1	45	270-196	lug, chaining plate	1
18	G.27.21-C2-067/3	looper drive shaft with connecting rods	1	46	004-L-7	screw	1
19	G.272-BK-096	knife holder, complete upper	1	47	G.272-BK-216/2	coverplate, front assembly	1
20	092-C-2	oil-wick	1	48	G.27.21-C2-009/4	main shaft assembly with connecting rods	1
21	092-D-11	oil-wick	2	49	AS.272-BK-903	knee control, complete	1
22	092-D-2	oil-wick	1	50	272-BK-907	washer	1
23	272-BK-991	screw, adjustment	1	51	272-BK-906	screw	1
24	059-A-5	nut	1	52	PM.272-BK-903	lever	1
25	004-A-3,2	screw	1	53	272-BK-905	bracket	1
26	272-BK-102	guide	1	54	390-974	screw	1
27	272-BK-103	lug	2	55	057-E-4	nut	2
28	272-BK-099	knife holder	1	56	G.272-BK-903	knife shift lever assembly	2
29	272-BK-100	spring	1	57	270-574	disc	1
30	PM.272-BK-096	lifter	1	58	270-582	pad	1
31	272-BK-982	screw	1	59	272-BK-573	rod	1
			1	60	038-M-9	screw	1
				61	270-572	block, coupling	3
On request:							
	272-BK-1141			Tab.	76		
	272-BK-114/1			"	76		
	272-BK-675			"	75		



REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	001 D-7	screw, guide mounting	1	18	273-186	guide	1
2	780280-0-00	machine class plate	1	19	G27.53-210,3	workplate, complete	1
3	270-075	primary looper	1	20	AS273-413	guide, hemming	1
4	272-051	feed-dog, rear	1	21	275-426	screw	1
5	PM275-417	support	1	22	275-425	screw, locking	1
6	270-D-074/1	secondary looper, blind	1	23	275-410	pin,	1
7	273-050	feed-dog, front	1	24	272-408	block, guide	1
8	273-114	needle plate, bight width 5/64"	1	25	G270-262/3	needle throat take-up assembly	1
9	G273-181	presserfoot, complete	1	26	270-270/1	take-up, secondary looper	1
10	275-185	chaining plate	1	27	270-272	take-up looper thread	1
11	001 A-3,2	screw	1	28	270-269/1	take-up, primary	1
12	272-191	chaining finger	1	29	270-274/3	take-up, needle thread	1
13	270-196	lug, chaining plate	1	30	270-271	thread guide, primary looper	1
14	004 L-8	screw	1	31	036 C-7	screw	1
15	270-989	screw	1	32	016 B-2,5	screw	1
16	275-183	stop, presserfoot	1	33	004 L-6	screw	1
17	273-184	shoe, presserfoot	1	34	004 A-5	screw	1

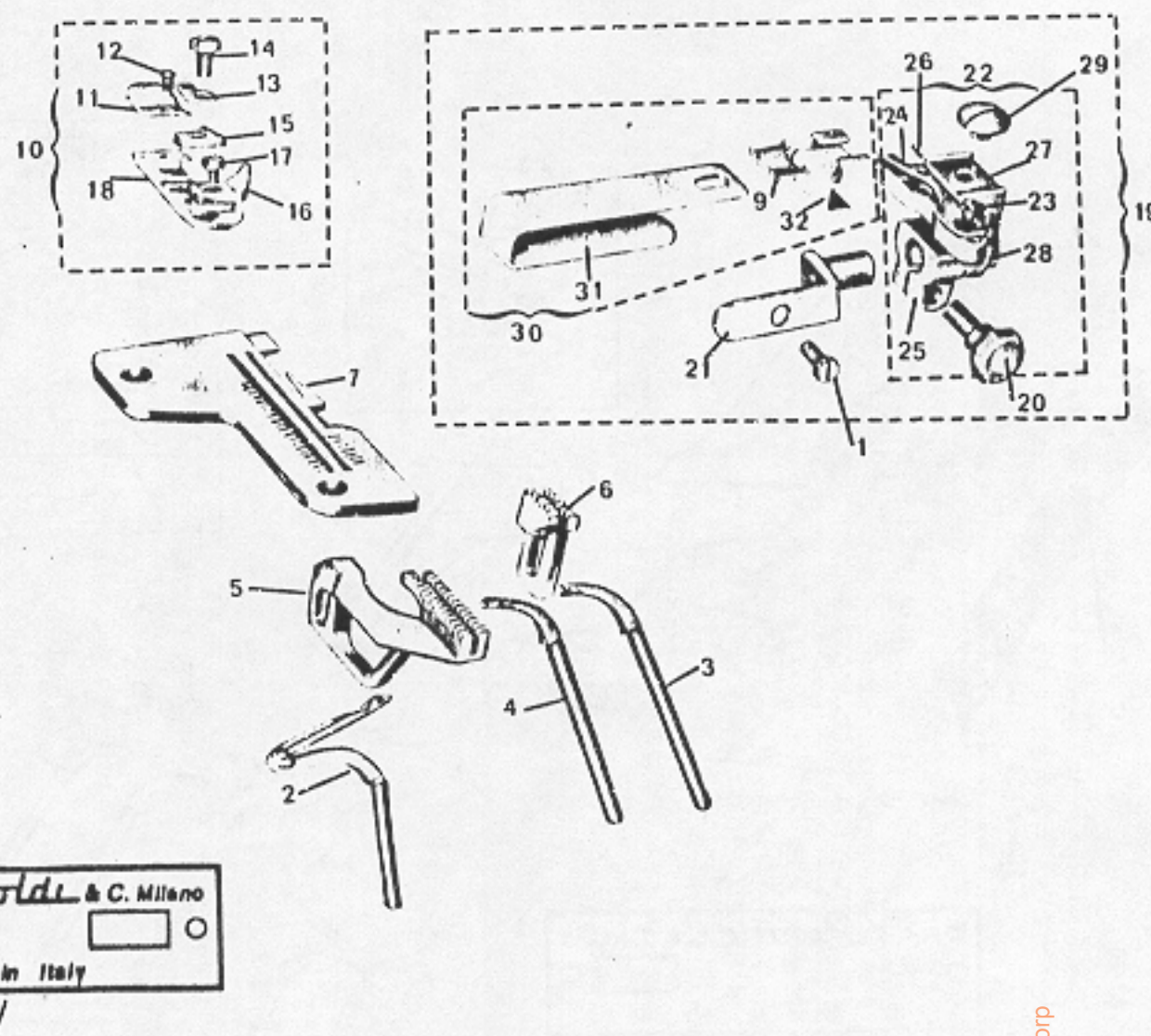
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44

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.27.32-B-039	stitch adjustment mechanism, complete	1	13	27.32-B-916	bushing	1
2	27.32-B-039	shaft	1	14	780.222-0-00	machine class plate	1
3	27.32-B-029	bushing	1	15	G.27.32-B2-181	presserfoot, complete	1
4	RG. 3 x 220	oil-wick	1	16	272-B-191	chaining finger	1
5	RG. 2,5 x 4	oil-wick	1	17	270-196	lug, chaining plate	1
6	RG. 1 x 22	oil-wick	1	18	004-L-8	screw	1
7	G.27.32-B-002/1	base, complete	1	19	272-B-183	chaining plate	1
8	27.32-B-050	feed-dog, front	1	20	27.32-B2-184	shoe, presserfoot	1
9	27.32-B-051	feed-dog, rear	1	21	270-943	set-screw, lever securing	1
10	27.32-B-071	actuator lever, stitch adjustment shaft	1	22	270-974/1	set-screw, adjustment screw securing	1
11	27.32-B-072	screw, stitch adjustment	1	23	27.100-227	stop plate, front needle guard	1
12	27.32-B-107	needle guard, front	1				

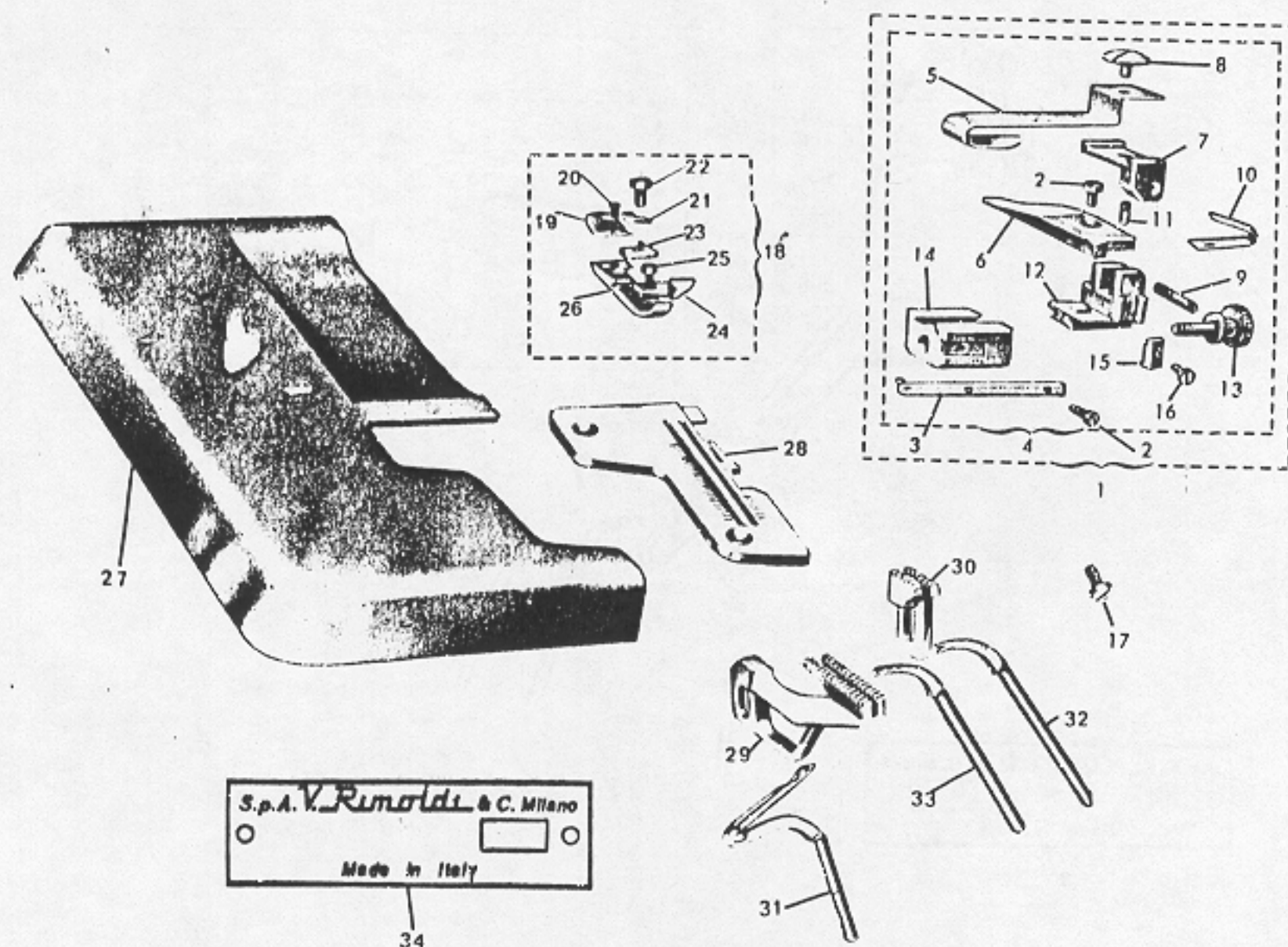
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N.B. To convert a type 227-10-02 into a 227-10-02-100 see illustration 72 73

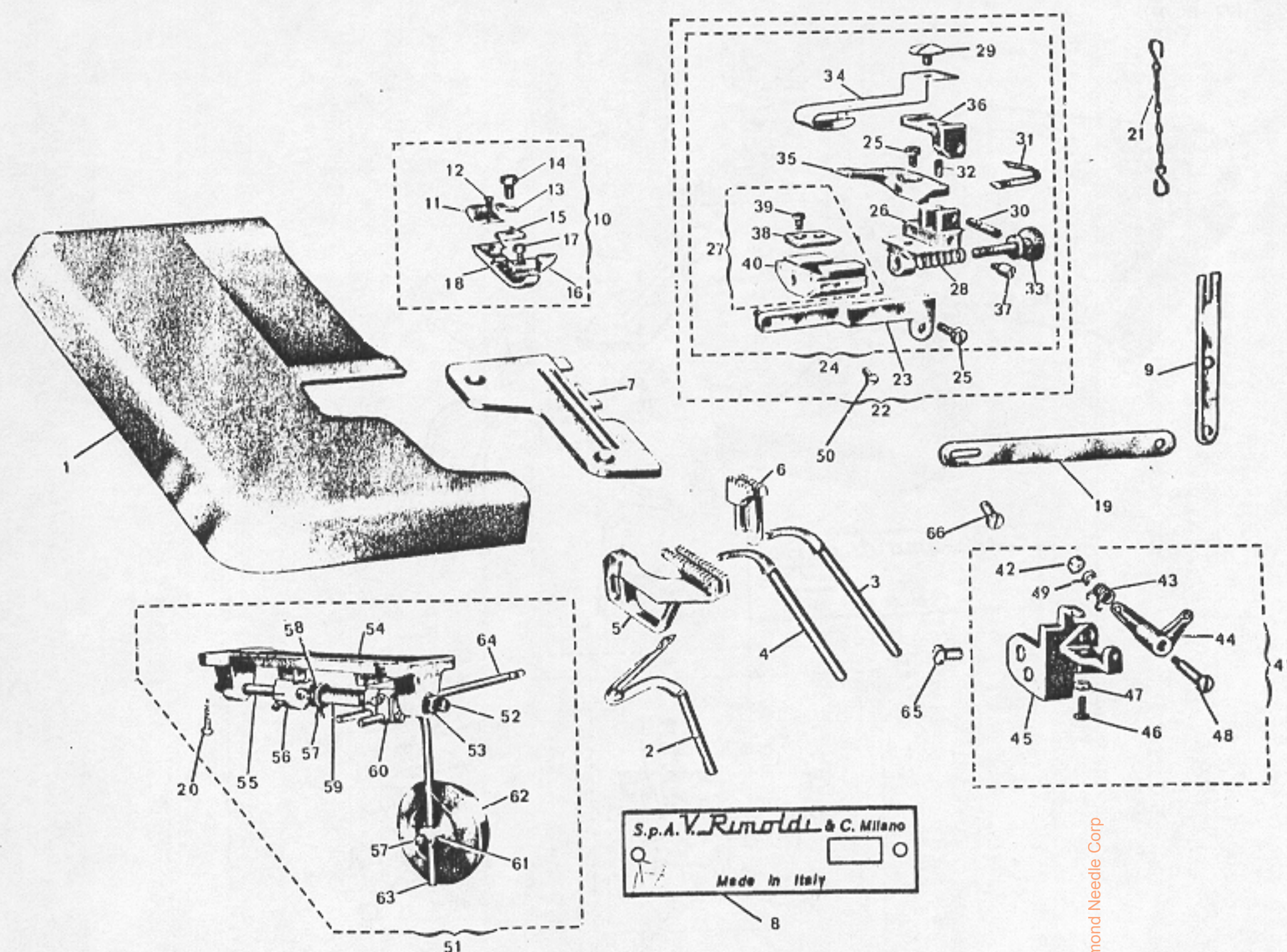
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	001-D-7	screw, guide mounting	1	17	270-989	screw	1
2	270-075	primary looper	1	18	275-184	shoe, presserfoot	1
3	270-D-074/1	secondary looper, blind	1	19	AS.275-413	guide, complete hemming	1
4	27.277-0745	primary looper with eye (attached)	1	20	275-426	screw	1
5	275-050	feed-dog, front	1	21	PM.275-417	support	1
6	275-051	feed-dog, rear	1	22	PM.275-408	guide assembly	1
7	275-114	needle plate, bight width 1/8"	1	23	275-403	screw	1
8	780-281-0-00	machine class plate	1	24	275-411	plate	1
9	275-416	spring	1	25	275-408	guide block	1
10	G.275-181	presserfoot, complete	1	26	275-410	pin	2
11	275-185	chaining plate	1	27	275-409	hinge	1
12	001-A-3,2	screw, chaining plate securing	1	28	275-425	set screw	1
13	270-196	lug, chaining plate	1	29	275-404	screw	1
14	004-L-7	screw, chaining finger mounting	1	30	PM.275-407	pressure blade and spring assembly	1
15	275-191	chaining finger	1	31	275-407	blade	1
16	275-183	stop, presserfoot	1	32	275-415	slide guide	1
On request:							
270-075/2						Tab. 75	
27.277-074						" 75	
275-1141						" 75	
PM.275-1882						" 75	

From the library of: Diamond Needle Corp



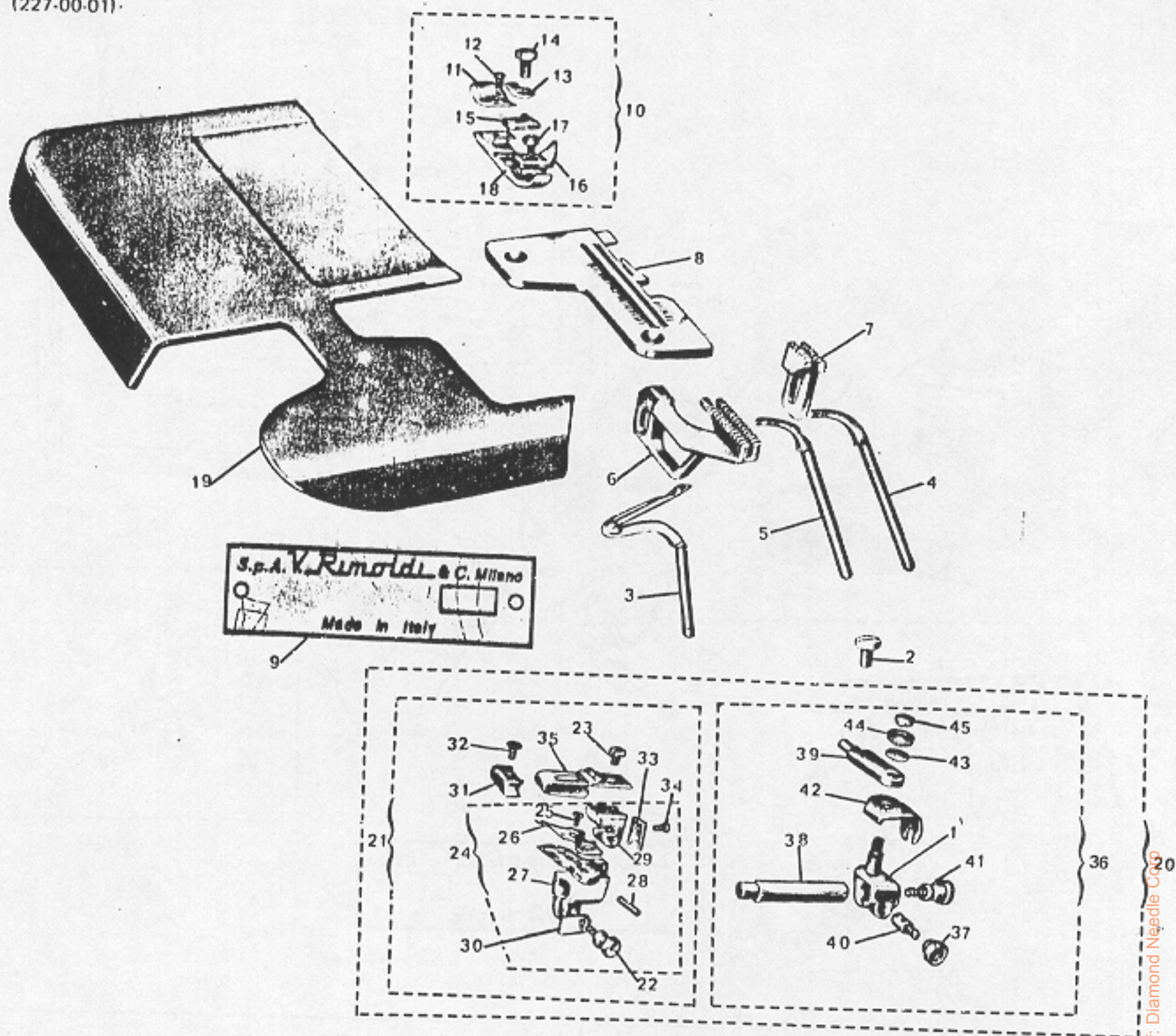
46

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	AS.275-B413	guide, complete hemming	1	18	G.275-B-181	presserfoot, complete	1
2	001-D-6	screw	2	19	275-185	chaining plate	1
3	PM 275-B-417	support	1	20	001-A-2,2	screw, chaining plate securing	1
4	G.275-B-413	guide, hemming	1	21	275-B-196	lug, chaining plate	1
5	275-B-407	blade, hemming	1	22	004-L-7	screw, chaining finger securing	1
6	275-B-411	plate, guide	1	23	275-B-191	chaining finger	1
7	275-B-409	block	1	24	275-B-183	stop, presserfoot	2
8	275-404	screw	1	25	270-083	screw	1
9	275-B-410	threaded pin	1	26	275-B-184	shoe, presserfoot	1
10	275-B-430	spring, blade	1	27	G.275-B-210/3	workplate, complete	1
11	275-B-403	screw, lock	1	28	275-B-114	needle plate, height width 7/64"	1
12	275-B-406	shoe	1	29	275-B-050	feed dog, front	1
13	275-B-425	screw, adjustment	2	30	275-051	feed dog, rear	1
14	275-B-408	block, guide	1	31	270-075	primary looper	1
15	275-B-418	lug	1	32	270-D-074/1	secondary looper, blind	1
16	005-D-5	screw	1	33	27.277-0745	secondary looper with eye (attached)	1
17	001-D-7	screw, guide securing	1	34	780 282-0-00	machine class plate	1
On request:							
AS.275-B-413/1						Tab. 77	
270-075/2						" 75	
27.277-074						" 75	
001-C-5,5						" 76	
275-B-426						" 76	



REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.275-B-210/3	workplate, complete	1	34	275-B-407	hemming blade	1
2	270-075	primary looper	1	35	275-B-411	guide	1
3	270-D-074/1	secondary looper, blind	1	36	275-B-409	block	1
4	27.277-0745	secondary looper with eye (attached)	1	37	275-B-6412	threaded pin	1
5	275-B-0501	feed dog, front	1	38	275-B-4142	guide plate	1
6	275-051	feed dog, rear	1	39	004-A-3,2	screw	2
7	275-B-114	needle plate, bight width 7/5-4"	1	40	275-B-4082	block, guide	1
8	780.283-0-00	machine class plate	1	41	G.275-B-6012	lever, guide shift assembly	1
9	275-B-6002	lever, vertical guide shift	1	42	053-D-4	nut	1
10	G.275-B-181	presserfoot, complete	1	43	275-B-6052	spring	1
11	275-185	chaining plate	1	44	275-B-6032	arm, transmission	1
12	001-A-3,2	screw, chaining plate securing	1	45	275-B-6012	bracket	1
13	275-B-195	lug, chaining plate	1	46	039-D-6	screw	1
14	004-L-7	screw, chaining finger securing	1	47	057-3-3	nut	1
15	275-B-191	chaining finger	1	48	275-B-6032	pin	1
16	275-B-183	stop, presserfoot	1	49	053-N-4	washer	1
17	270-989	screw	1	50	001-D-7	screw, guide securing	1
18	275-B-184	shoe, presserfoot	1	51	G.320-570	knee control, complete	1
19	275-B-5992	lever, link	1	52	270-993	screw, knee control mounting	2
20	TS 22 x 35	screw, knee control securing	4	53	059-P-8	nut, hex.	1
21	PM.275-B-1482	chain, foot lifter	1	54	520-570	plate, mounting	1
22	AS.275-B-4132	hemming guide complete	1	55	270-571	shaft, knee control main	1
23	PM.275-B-4172	bracket	1	56	270-579	stop, knee control	1
24	G.275-B-4132	guide, complete	1	57	038-M-9	nut, hex.	9
25	001-D-6	screw	2	58	270-720	collar, spring pressure adjustment	1
26	275-B-4062	shoe	1	59	270-575	spring, knee control disc recall	1
27	PM.275-B-4082	block, guide	1	60	620-572	block, knee control connection	1
28	275-B-4152	spring, coil	1	61	270-574	disc, knee control	1
29	275-404	screw	1	62	270-582	pad, knee control disc	1
30	275-B-410	threaded pin	1	63	270-573	rod, knee control	1
31	275-B-430	spring, blade	1	64	520-565	rod, horizontal	1
32	275-B-403	screw, lock	1	65	001-G-10	screw, lever unit mounting	2
33	275-B-4252	screw, adjustment	1	66	012-H-5	screw, lever link	3
On request:							
270-075/2							Tab. 75
27.277-074							" 75
AS.275-B-4132/1							" 77
001-C-5,5							" 76
275-B-425							" 76

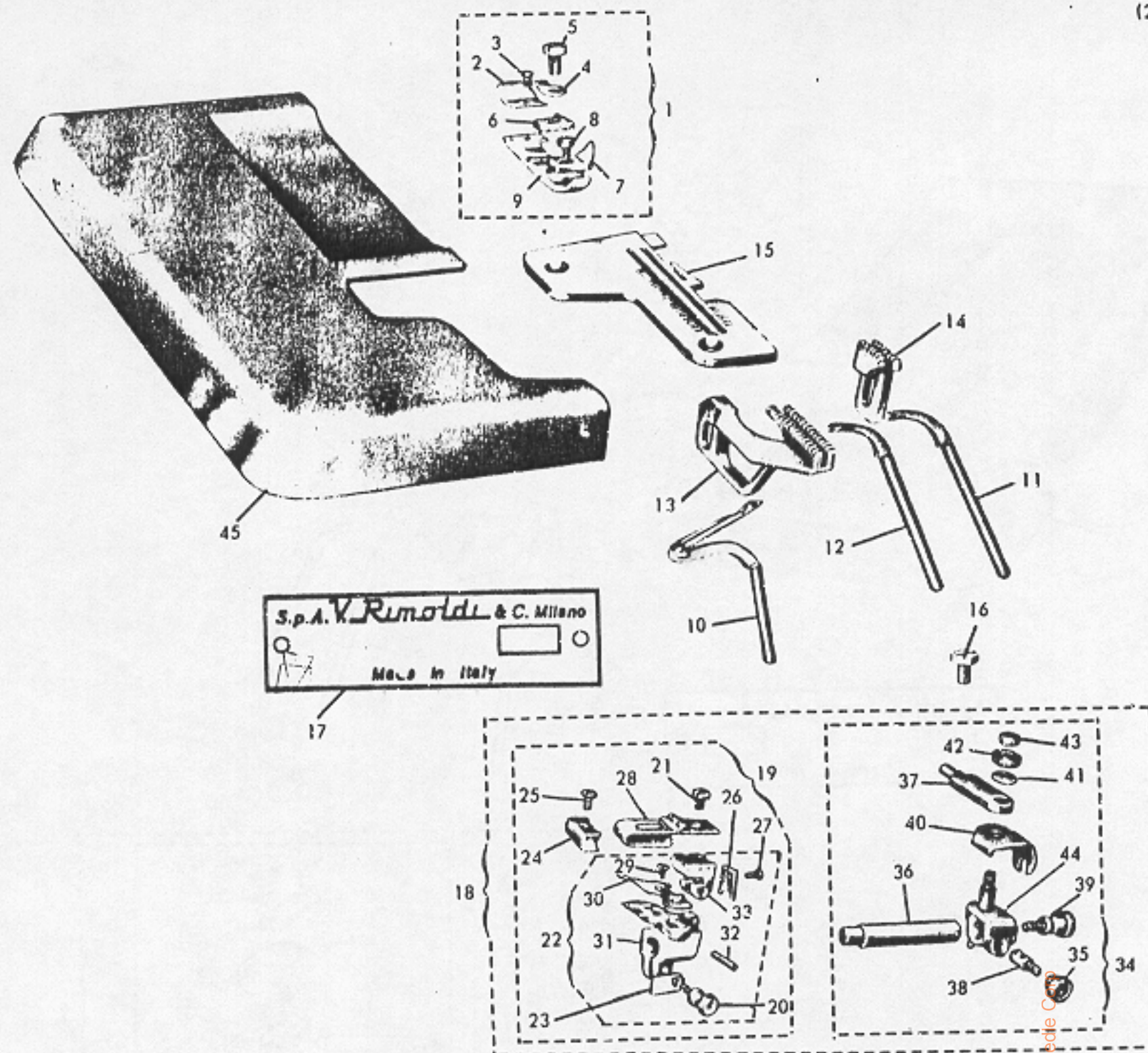
From the library of: Diamond Needle Corp



N.B. To convert machine 227-10-05 to machine 227-10-101 see Table 74.

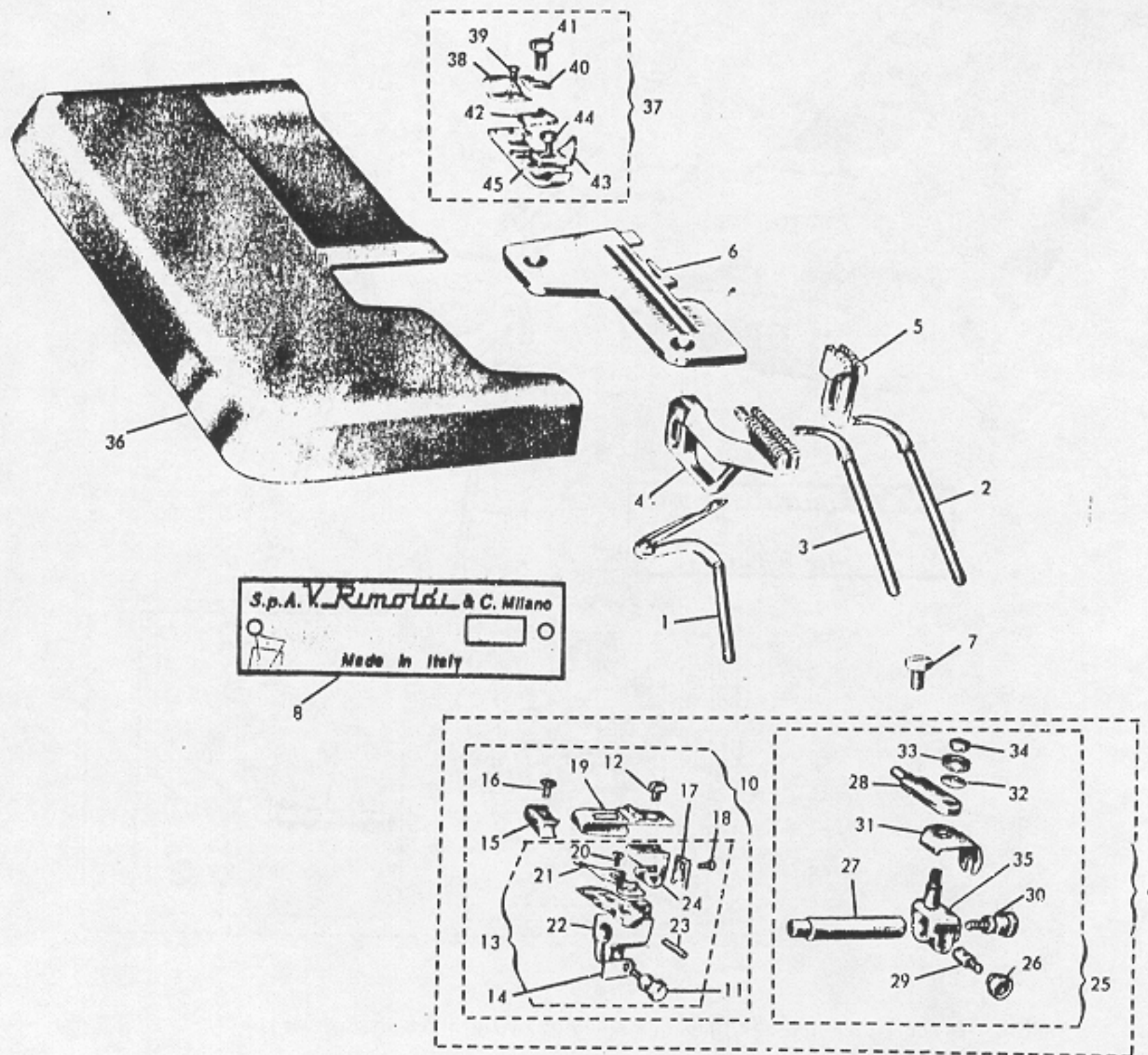
48

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	27.53-4071	swivel block	1	24	PM.275-408	block, guide swivel	1
2	039-R-8,5	screw, guide securing	1	25	275-403	screw	1
3	270-075	primary looper	1	26	275-411	plate, guide	1
4	270-D-074/1	secondary looper, blind	1	27	275-408	block, guide	1
5	27.277-0745	secondary looper with eye (attached)	1	28	275-410	pin	1
6	275-050	feed dog, front	1	29	275-409	hinge, block	1
7	275-051	feed dog, rear	1	30	27.53-2231	plate, stop	1
8	275-114	needle plate bight width 7/64"	1	31	255-415	block, stop	1
9	780-284-0-00	machine class plate	1	32	255-404	screw	1
10	G.275-181	presserfoot, complete	1	33	27.53-2221	plate, guide stop	1
11	275-185	chaining plate	1	34	001-C-4	screw	1
12	001-A-3,2	screw, chaining plate securing	1	35	PM.255-434	spring, hinged	1
13	270-196	lug, chaining plate	1	36	G.27.53-3792	attaching device, complete	1
14	004-L-7	screw, chaining finger securing	1	37	250-980	knurled screw head	1
15	275-191	chaining finger	1	38	27.53-4011	shaft	1
16	275-183	stop, presserfoot	1	39	27.53-4172	plate, bearing	1
17	270-989	screw	1	40	27.53-4181	pawl	1
18	275-184	shoe, presserfoot	1	41	27.53-4251	screw, knurled head adjustment	1
19	G.27.53-210/3	workplate, complete	1	42	27.53-2201	plate, forked	1
20	AS.27.53-4132	guide, complete hemming	1	43	27.53-4121	spring, cup	1
21	PM.27.53-4081	guide assembly	1	44	27.53-4261	washer, knurled	1
22	275-426	screw, locking	1	45	27.53-2211	nut	1
23	275-404	screw	1				
						On request:	
						PM.275-1882	Tab. 75
						270-075/2	" 75
						27.277-074	" 75
						275-1141	" 75



N.B. To convert machine 227-10-06 to machine 227-10-06-100 see Table 72-73.

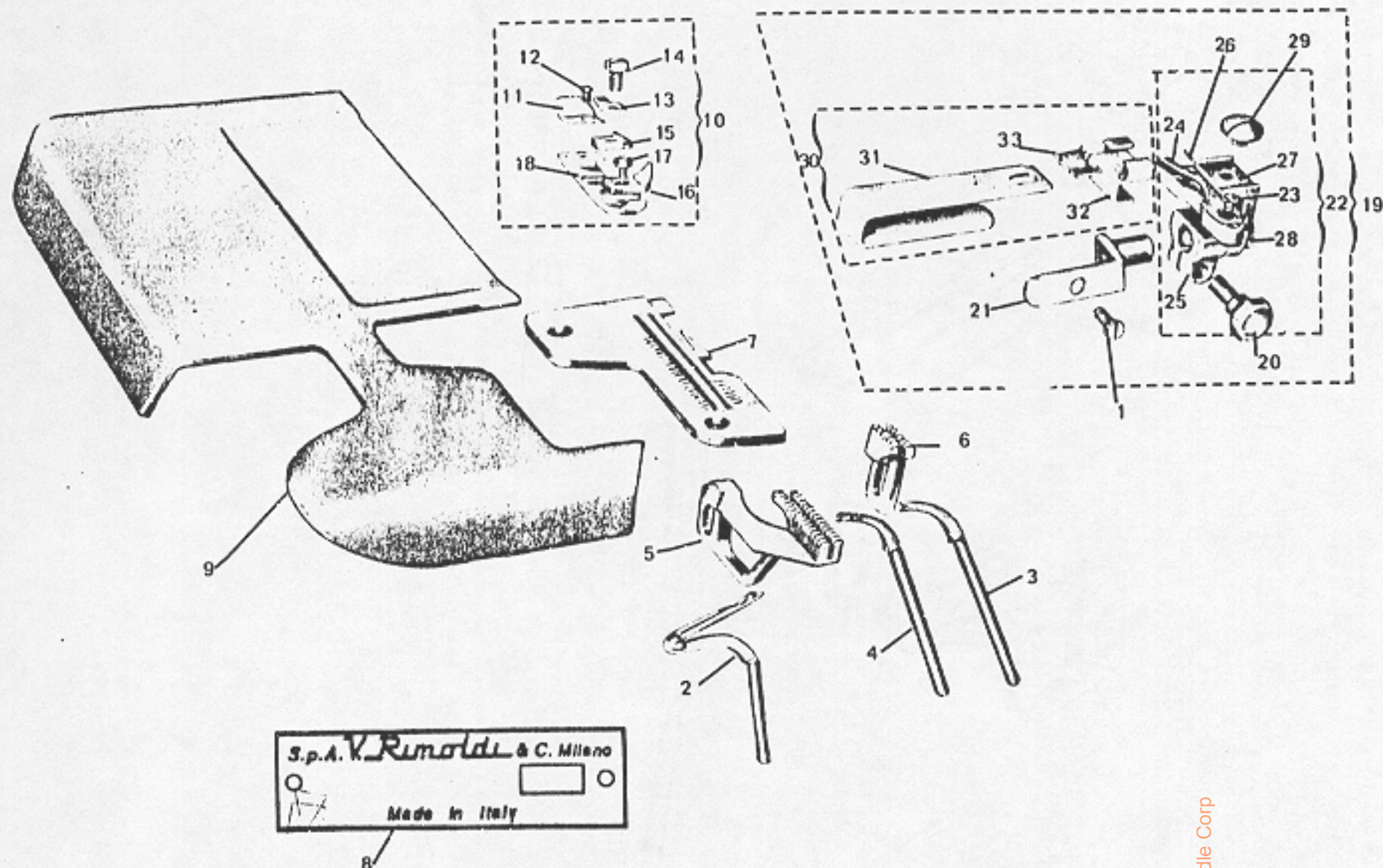
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	G.275-181	presserfoot, complete	1	24	244-415	block, stop	1
2	275-185	chaining plate	1	25	255-404	screw	1
3	001-A-3,2	screw, chaining plate securing	1	26	27.53-2221	plate, guide stop	1
4	270-196	lug, chaining plate	1	27	001-C-4	screw	1
5	004-L-7	screw, chaining finger securing	1	28	PM.255-434	spring, hinged	1
5	275-191	chaining finger	1	29	275-403	screw	2
7	275-183	stop, presserfoot	1	30	275-411	plate, guide	1
8	270-989	screw	1	31	275-408	block, guide	1
9	275-184	shoe, presserfoot	1	32	275-410	pin	1
10	270-075	primary looper	1	33	275-409	hinge, block	1
11	270-D-074/1	secondary looper, blind	1	34	G.275-3792	attaching device, complete	1
12	27.277-0745	secondary looper with eye (attached)	1	35	250-980	screw head knurled	1
13	275-050	feed dog, front	1	36	27.53-4011	shaft	1
14	275-051	feed dog, rear	1	37	27.53-4172	plate, bearing	1
15	275-114	needle plate bight width 7/64"	1	38	27.53-4181	pawl	1
16	039-R-8,5	screw, guide securing	1	39	27.53-4251	screw, knurled head adjustment	1
17	780285-0-00	machine class plate	1	40	27.53-2201	plate, forked	1
18	AS.27.53-4132	hemming guide, complete	1	41	27.53-4121	spring, cup	1
19	PM.27.53-4081	guide assembly	1	42	27.53-4261	washer, knurled	1
20	275-426	screw, locking	1	43	27.53-2211	nut	1
21	275-404	screw	1	44	27.53-4071	swivel block	1
22	PM.275-408	block, guide swivel	1	45	G.27.54-210/3	workplate, complete	1
23	27.53-2231	plate, stop	1				
						On request:	
						270-075/2	Tab. 75
						27.277-074	" 75
						275-1141	" 75
						PM.275-1882	" 75



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50

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-075	primary looper	1	24	275-409	hinge, block	1
2	270-D-074/1	secondary looper, blind	1	25	G.27.53-3792	attaching device, complete	1
3	27.277-0745	secondary looper with eye (attached)	1	26	250-980	knurled screw head	1
4	275-050	feed dog, front	1	27	27.53-4011	shaft	1
5	275-051	feed dog, rear	1	28	27.53-4172	plate, bearing	1
6	275-114	needle plate bight width 7/54"	1	29	27.53-4181	pawl	1
7	016-F-7	screw, guide set	1	30	27.53-4251	screw, knurled head adjustment	1
8	780300-D-00	machine class plate	1	31	27.53-2201	plate, forked	1
9	AS.27.53-4132	hemming guide, complete	1	32	27.53-4121	spring, cup	1
10	PM.27.53-4081	guide assembly	1	33	27.53-4251	washer, knurled	1
11	275-426	screw, locking	1	34	27.53-2211	nut	1
12	275-404	screw	1	35	27.53-4071	swivel block	1
13	PM.275-408	block, guide swivel	1	36	G.27.54-210/3	workplate, complete	1
14	27.53-2231	plate, stop	1	37	G.27.54-E-181	presserfoot, complete	1
15	255-415	block, stop	1	38	275-185	chaining plate	1
16	275-404	screw	1	39	001-A-3,2	screw, chaining plate securing	1
17	27.53-2221	plate, guide stop	1	40	270-196	lug, chaining plate	1
18	001-C-4	screw	1	41	004-L-7	screw, chaining finger securing	1
19	PM.255-434	spring, hinged	2	42	27.54-E-191	chaining finger	1
20	275-403	screw	2	43	275-183	stop, presserfoot	1
21	275-411	plate, guide	1	44	270-989	screw	1
22	275-408	block, guide	1	45	275-184	shoe, presserfoot	1
23	275-410	pin	1				
		On request:					
		270-075/2	Tab. 75				
		27.277-074	" 75				
		275-1141	" 75				
		PM.275-1882	" 75				
						N.B. When machine 227.10.06 is converted to 227.11.01 in the field, supply chaining finger 27.54-E-191 and not complete presserfoot G.27.54-E-181.	



REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	001-D-7	screw, guide securing	1	18	275-184	shoe, presserfoot	1
2	270-075	primary looper	1	19	AS.275-413	hemming guide, complete	1
3	270-D-074/1	secondary looper, blind	1	20	275-426	screw	1
4	27.277-0745	secondary looper with eye (attached)	1	21	PM.275-447	support arm	1
5	275-050	feed dog, front	1	22	PM.275-408	block, guide assembly	1
6	275-051	feed dog, rear	1	23	275-403	screw	1
7	275-114	needle plate bight width 7/64"	1	24	275-411	plate, guide	1
8	780286-0-00	machine class plate	1	25	275-408	block, guide	1
9	PM.27.53-210/3	workplate, complete	1	26	275-410	pin	1
10	G.275-181	presserfoot, complete	1	27	275-409	hinge, block	1
11	275-185	chaining plate	1	28	275-425	screw, knurled head adjustment	1
12	001-A-3,2	screw, chaining plate securing	1	29	275-404	screw	1
13	270-196	lug, chaining plate	1	30	PM.275-407	pressure blade and spring assembly	1
14	004-L-7	screw, chaining finger securing	1	31	275-407	blade	1
15	275-191	chaining finger	1	32	275-415	slide guide	1
16	275-183	stop, presserfoot	1	33	275-416	spring	1
17	270-989	screw	1				
						On request:	
						270-075/2	Tab. 75
						27.277-074	" 75
						275-1141	" 75
						PM.275-1882	" 75

a) Positioning of head

After motor is mounted on stand, proceed as follows:

1. Force-fit the four rubber shock absorber pads on to the pins provided on the machine head bearing plate
2. Place machine head on table centering the lower holes in the head on the shock absorber pad pins

b) Assembly of transmission

1. Install driving belt as shown in diagram 1
2. Check that reverse of driving belt rides firmly and squarely on pump pulley, without slipping
3. Adjust belt tension by loosening motor clamp
4. Level machine head by adjusting machine cradle bolts.
5. Tighten up machine cradle bolt lock-nuts

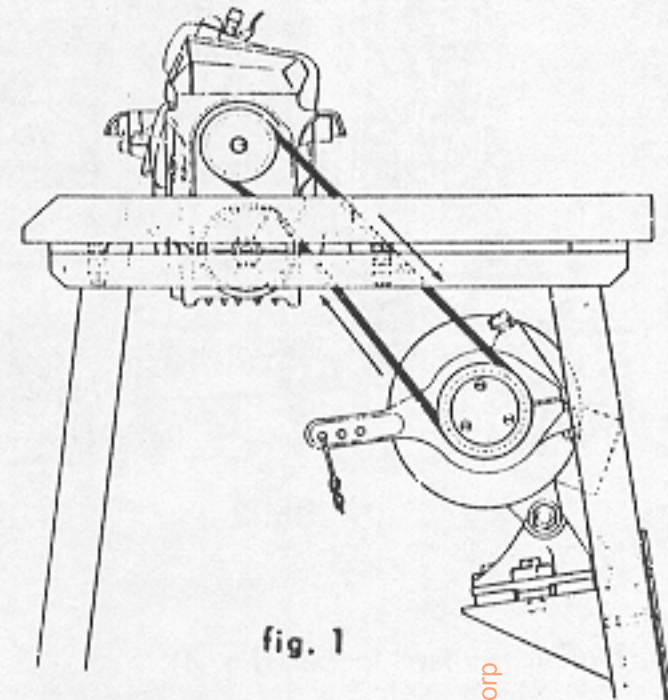


fig. 1

c) Filling lube oil sump (fig.2)

1. Unscrew threaded cap 'A'
2. Pour in 1 and 3/4 pts Esso Standard Teresso 43 oil.
3. Check through oil-window that oil level is between the two red lines.
4. Replace and tighten cap 'A'
5. Before starting up the machine, the following points should be lubricated:
 - needle clamp guide rod
 - upper looper bar
6. Start machine slowly, letting it idle for about 5 minutes and gradually rev up from 1500 r.p.m. to rated operating speed

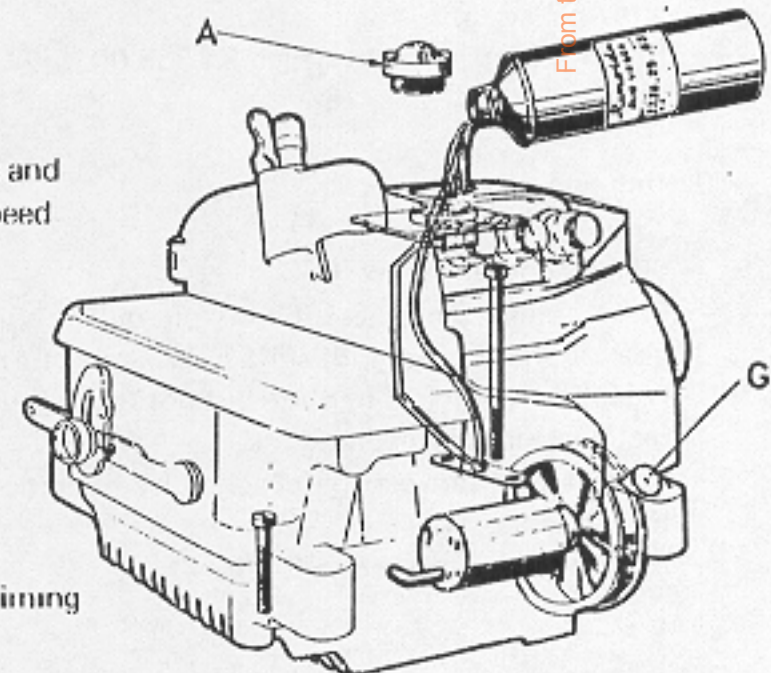
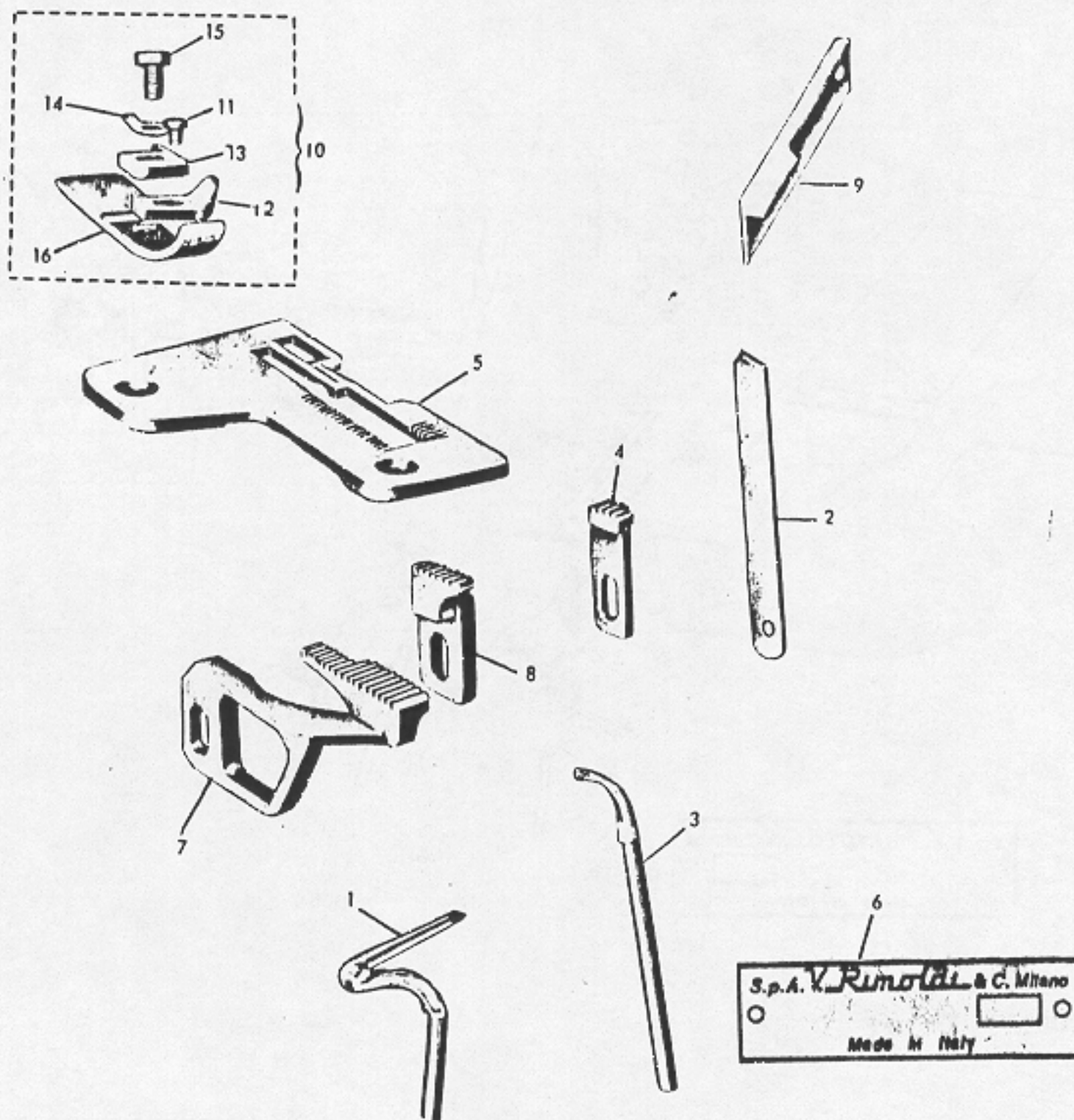


fig. 2

d) Assembly and adjustment of sewing parts

Note: The operations described below are for machine timing

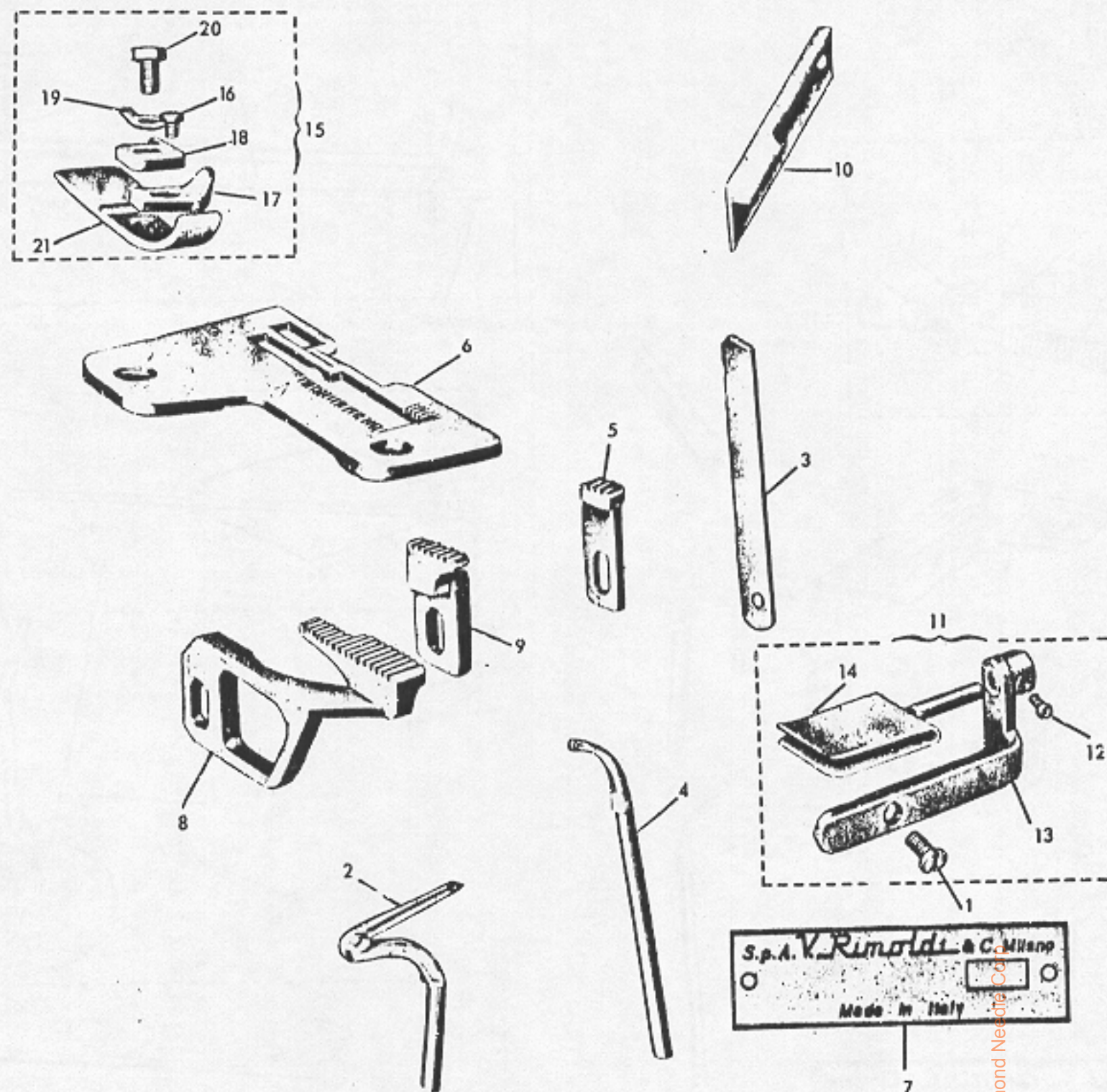
1. Timing gauges required:
 - S.1665.00 for all operations except operation 4 (fig 4)
 - S.1555.00 for operation N.4
2. Preliminary disassembly of:
 - Front cover plate
 - Both thread take-ups of lower looper holder
 - Side Cover Plate (casing) of needle movement
 - Upper plate with oil indicator cap
 - Side plate protecting needle movement
 - Main feed dog



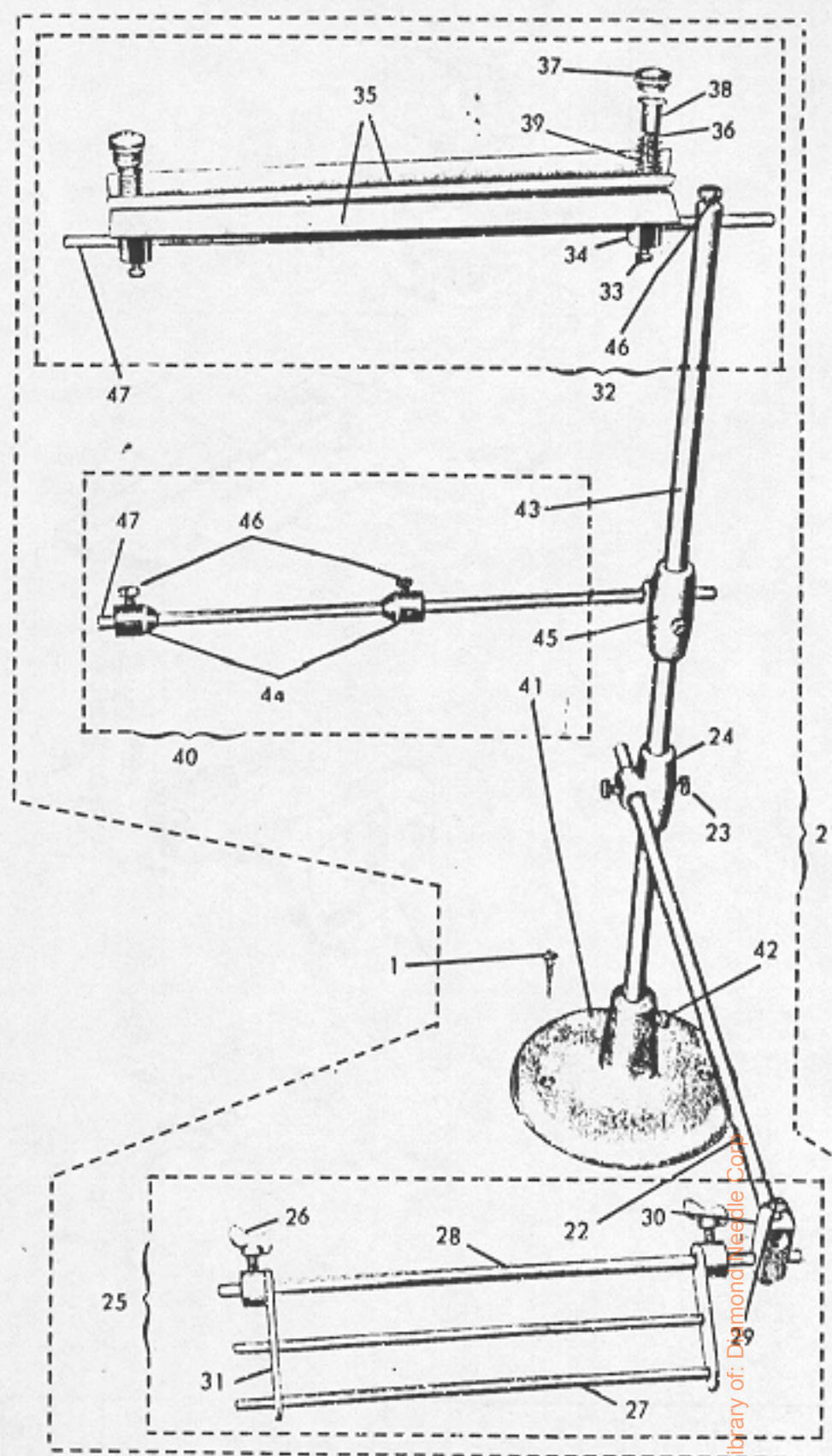
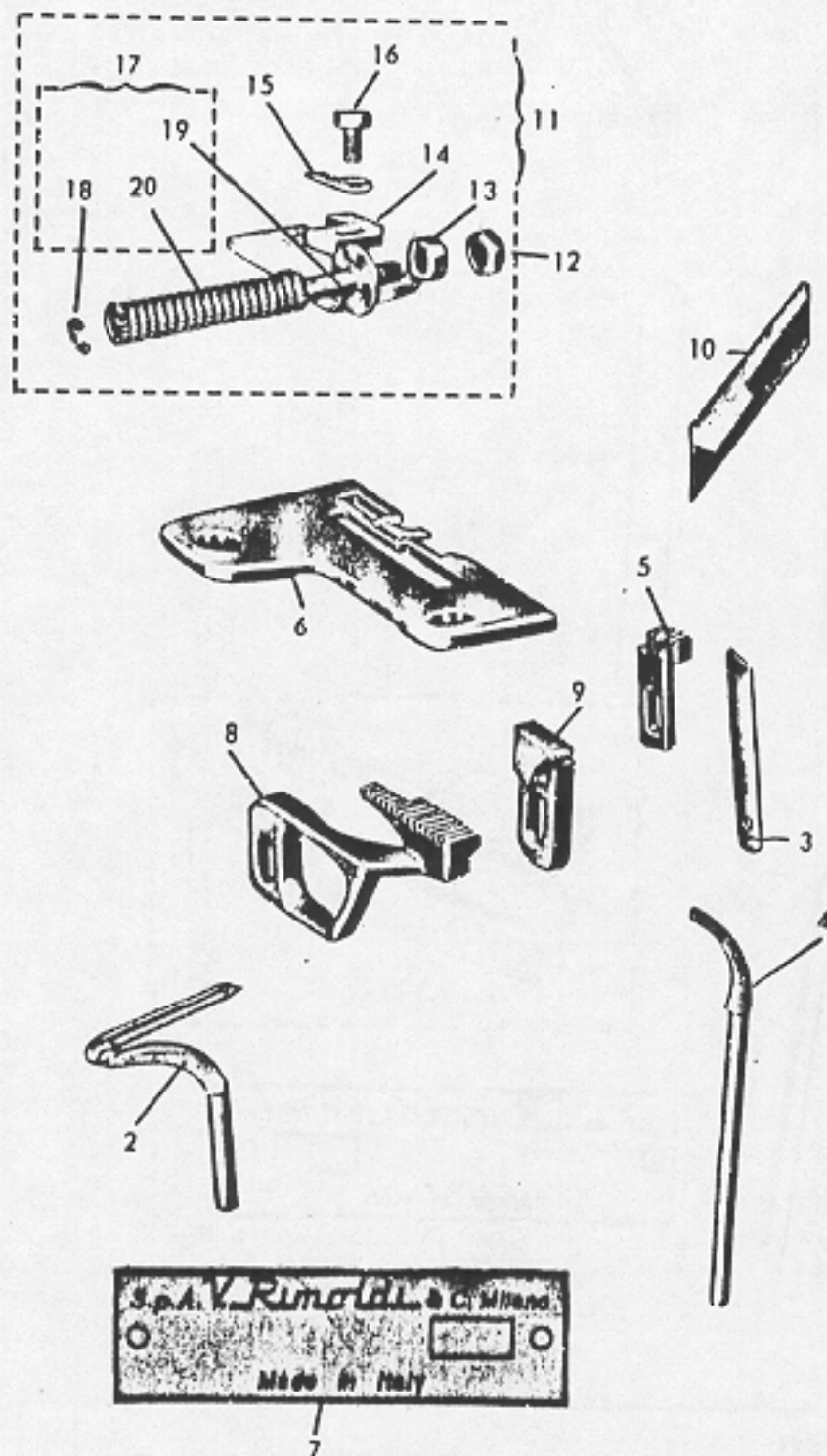
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52

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-075	primary looper	1	9	279-112	knife, upper	1
2	27.01-P9-113/1	knife, lower	1	10	G.278-181	presserfoot, complete	1
3	27.277-0745	secondary looper	1	11	270-989	screw	1
4	278-052	feed dog, chaining	1	12	270-183	stop, presserfoot	1
5	278-114	needle plate bight width 5/64"	1	13	278-191	chaining finger	1
6	780225-0-00	machine class plate	1	14	270-196	lug, chaining finger	1
7	279-050	feed dog, front	1	15	004-L-7	screw, chaining finger securing	1
8	279-051	feed dog, rear	1	16	278-184	shoe, presserfoot	1
On request: 278-114/1 Tab. 76							



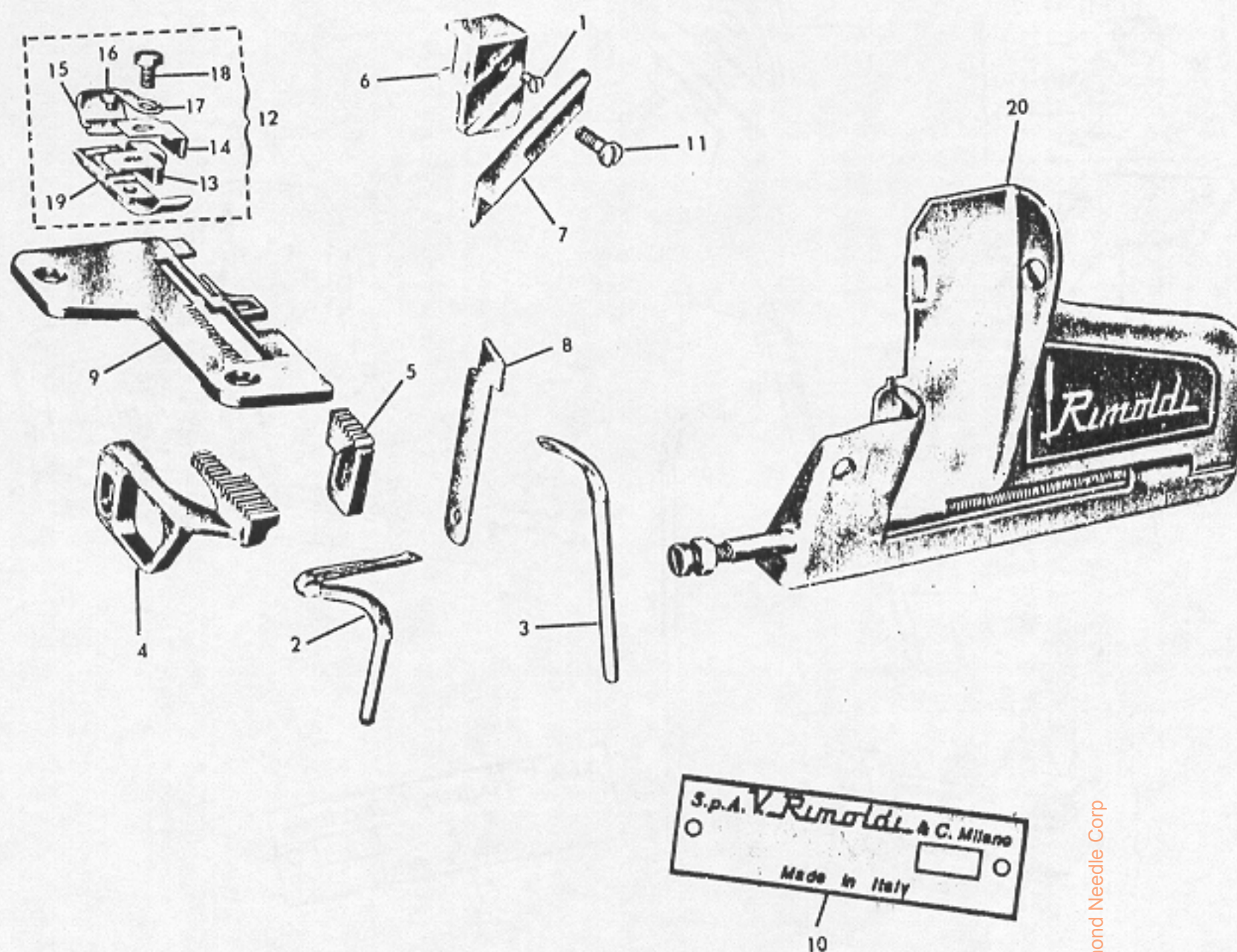
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	001-D-7	screw, guide securing	1	12	004-A-2,5	screw	1
2	270-075	primary looper	1	13	PM.272-G-417	bearing arm	1
3	27.01-P9-113/1	knife, lower	1	14	PM.27.03-P-402	guide	1
4	27.277-0745	secondary looper	1	15	G.278-181	presserfoot, complete	1
5	278-052	feed dog, chaining	1	16	270-999	screw, stop securing	1
6	278-114	needle plate bight width 5/64"	1	17	270-183	stop, presserfoot	1
7	780452-0-00	machine class plate	1	18	278-191	chaining finger	1
8	279-050	feed dog, front	1	19	270-195	lug, chaining plate	1
9	279-051	feed dog, rear	1	20	004-L-7	screw, chaining finger securing	1
10	279-112	knife, upper	1	21	278-184	shoe, presserfoot	1
11	G.272-G-401	guide, lace attaching	1				



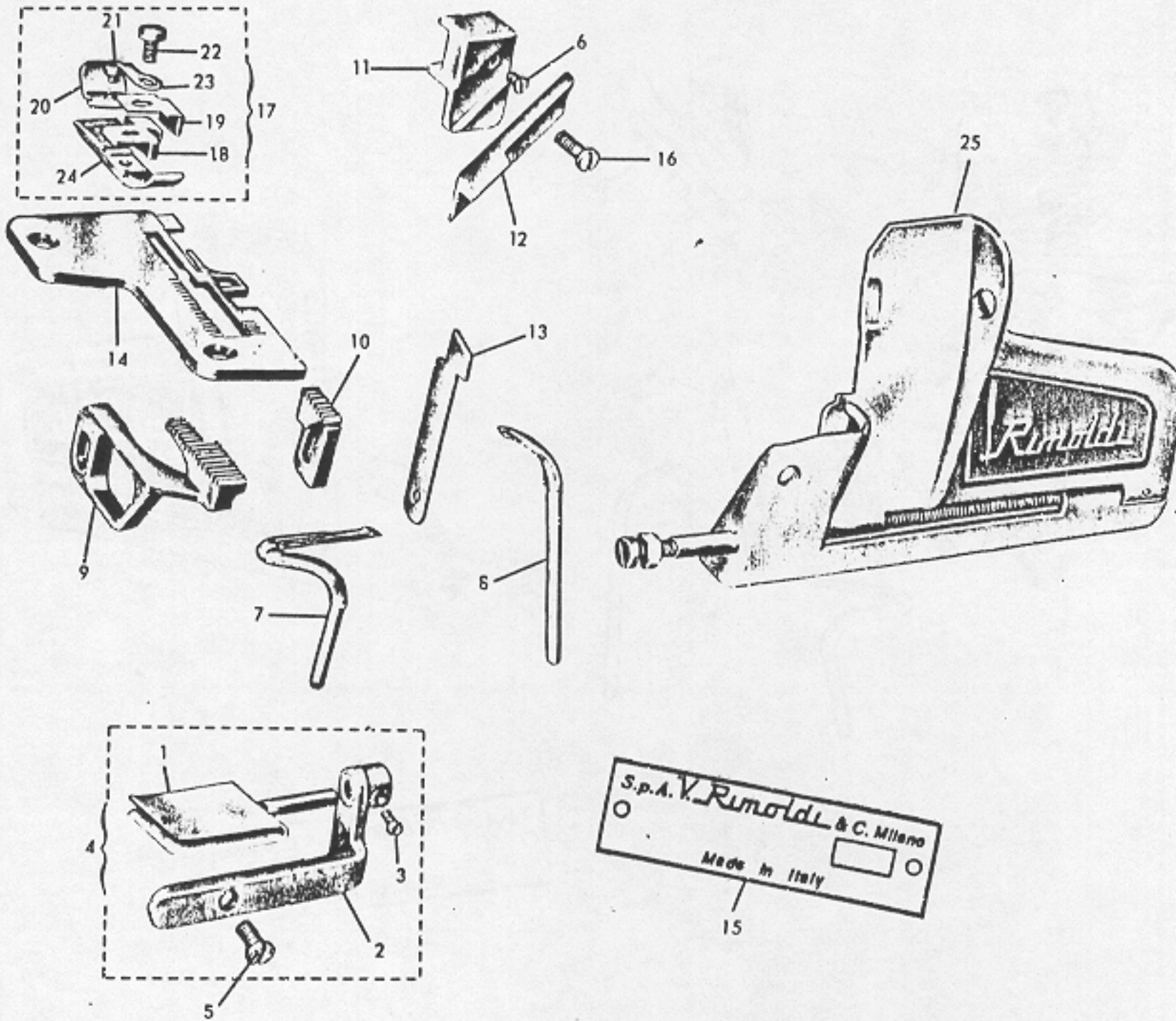
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54

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	TS.20 x 30	screws	2	25	G.272-MG-4192	feed control, lower	1
2	270-075	primary looper	1	25	PM.302-E-4354	wing nut with shank	2
3	27.01-P9-113/1	knife, lower	1	27	PM.272-MG-4302	frame-plate, with rod	1
4	27.277-0745	secondary looper	1	28	272-MG-4212	rod	1
5	278-052	feed dog, chaining	1	29	038-C-7	screw	2
6	278-114	needle plate bight width 5/64"	1	30	272-MG-4242	block, coupling	1
7	780453-0-00	machine class plate	1	31	PM.272-MG-4342	plate, width adjustment	1
8	279-050	feed dog, front	1	32	G.272-MG-4412	feed control, upper	1
9	279-051	feed dog, rear	1	33	039-C-10,5	screw	2
10	279-112	knife, upper	1	34	272-MG-4332	block, mounting	2
11	G.278-MG-1811	presserfoot, complete	1	35	272-MG-4412	hinge, drag	2
12	054-D-4	nut	1	35	150-232/4	spring	2
13	278-MG-1841	shoe, presserfoot	1	37	150-030	pin	2
14	278-191	chaining finger	1	38	1032 a	bushing	2
15	270-196	lug, chaining plate	1	39	150-032	screw, adjustment knurled head	2
16	004-L-7	screw, chaining plate securing	1	40	G.635-937	reel carrier, complete	1
17	PM.272-NH-199	roller, with shaft	1	41	01141	base	1
18	270-701	snap ring	1	42	001-G-12	screw	1
19	272-NG-199	shaft	1	43	505-143	upright	1
20	272-NG-197	roller	1	44	505-723	sleeve, tapered	2
21	AS.272-MG-937	metering device for 5" lace	1	45	505-937	bracket	1
22	272-MG-4333	bar	1	45	505-980	screw, set	5
23	605-980	lock-screw	2	47	505-144	pin	2
24	272-MG-937	bracket	1	48			
On request: AS.272-MG-9371 Tab. 77							

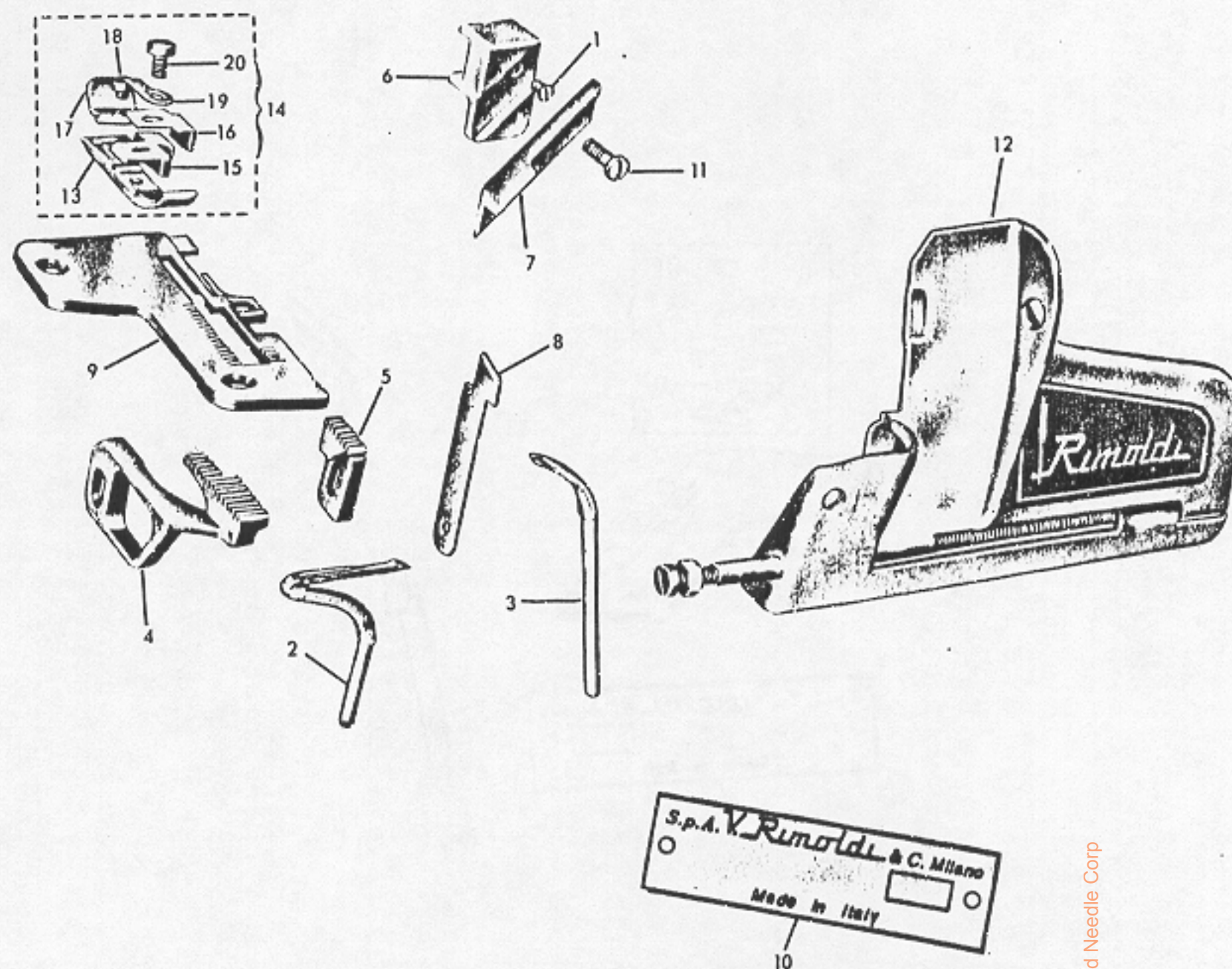


REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	028-B-8	screw, chaining plate securing	1	11	279-987	screw, upper knife mounting	1
2	270-075	primary looper	1	12	G.279-181	presserfoot, complete	1
3	27.277-0745	secondary looper	1	13	279-191	chaining finger	1
4	279-050	feed dog, front	1	14	PM.279-183.	stop, presserfoot	1
5	279-051	feed dog, rear	1	15	275-185	chaining plate	1
6	279-099	knife holder, upper	1	16	001-A-3,2	screw, chaining plate securing	1
7	279-112	knife, upper	1	17	270-196	lug, chaining plate	1
8	279-113/1	knife, lower	1	18	004-L-7	screw, chaining finger securing	1
9	279-114	needle plate bight width 5/64"	1	19	279-184	shoe, presserfoot	1
10	780226-0-00	machine class plate	1	20	G.279-216/2	front coverplate, complete	1
				On request:			
				270-075/2 Tab. 75			
				27.277-074 " 75			

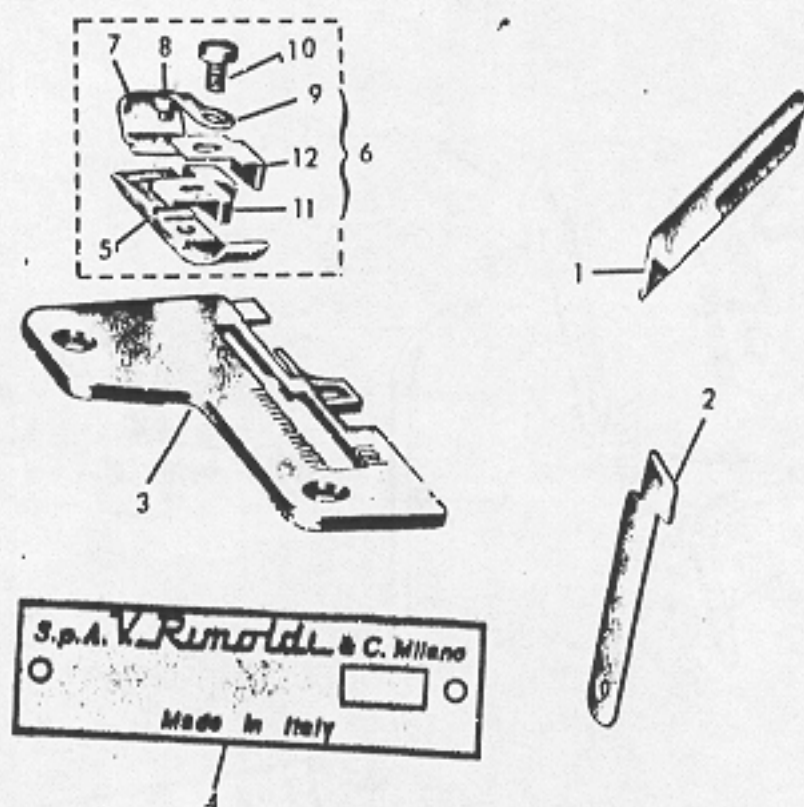


From the library of: Diamond Needle Corp

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	PM.27.03-P-402	guide	1	14	279-114	needle plate bight width 5/64"	1
2	PM.272-G-417	arm, bearing	1	15	780454-0-00	machine class plate	1
3	004-A-2,5	screw	1	16	279-987	screw, upper knife mounting	1
4	G.272-G-401	guide, lace attaching	1	17	G.279-181	presserfoot, complete	1
5	001-D-7	screw, guide securing	1	18	279-131	chaining finger	1
6	028-B-8	screw, chaining plate securing	1	19	PM.279-183	stop plate	1
7	270-075	primary looper	1	20	275-185	chaining plate	1
8	27.277-0745	secondary looper	1	21	001-A-3,2	screw, chaining plate securing	1
9	279-050	feed dog, front	1	22	270-196	lug, chaining plate	1
10	279-051	feed dog, rear	1	23	004-L-7	screw	1
11	279-099	knife holder, upper	1	24	279-184	shoe, presserfoot	1
12	279-112	knife, upper	1	25	G.279-216/2	front coverplate, complete	1
13	279-113/1	knife, lower	1				

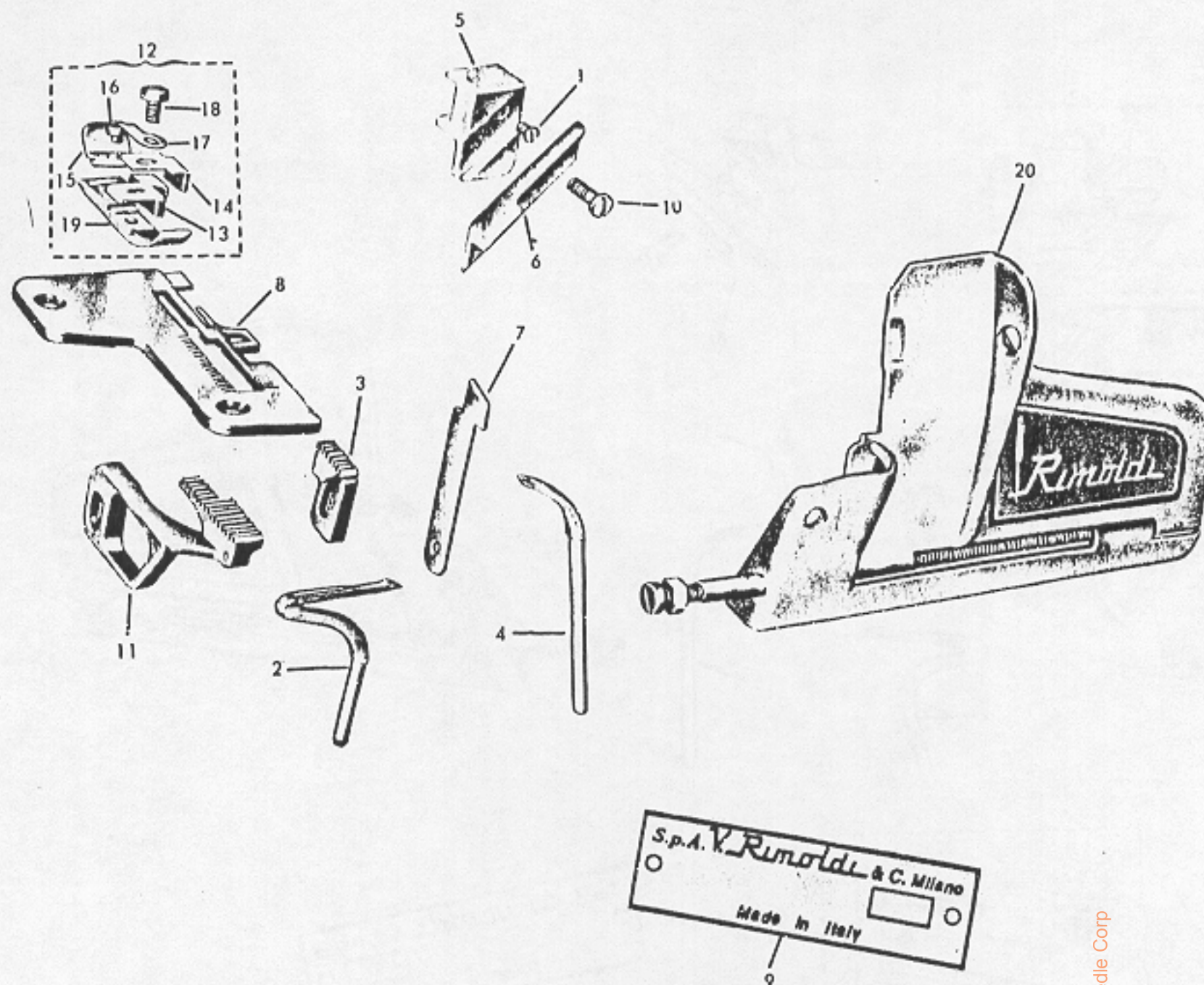


REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	028-B-8	screw, chaining plate securing	1	11	279-987	screw, upper knife mounting	1
2	270-075	primary looper	1	12	G.279-216/2	front coverplate, complete	1
3	27.277-0745	secondary looper	1	13	279-184	shoe, presserfoot	1
4	279-050	feed dog, front	1	14	G.2791-1811	presserfoot, complete	1
5	270-051	feed dog, rear	1	15	27.91-1911	chaining finger	1
6	279-099	knife holder, upper	1	16	PM.279-183	plate, presserfoot stop	1
7	279-112	knife, upper	1	17	275-185	chaining plate	1
8	279-113/1	knife, lower	1	18	001-A-3,2	screw, chaining plate securing	1
9	279-114	needle plate bight width 3/32"	1	19	270-196	lug, chaining plate	1
10	780227-0-00	machine class plate	1	20	004-L-7	screw	1



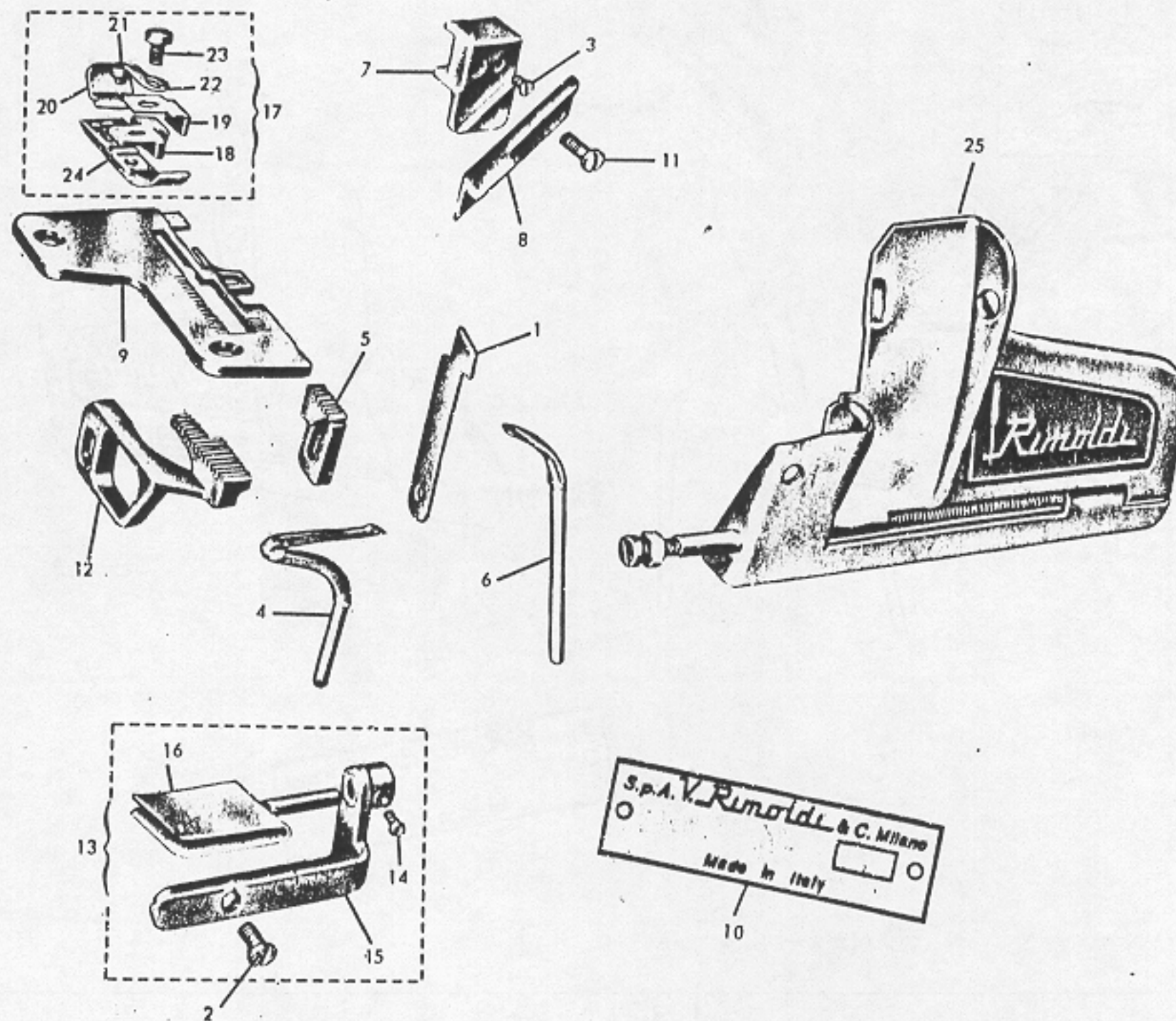
From the library of: Diamond Needle Corp

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	279-112	knife, upper	1	7	275-185	chaining plate	1
2	279-113/1	knife, lower	1	8	001 A-3,2	screw, chaining plate securing	1
3	279-114	needle plate bight width 3/32"	1	9	270-196	lug, chaining plate	1
4	780437-0-00	machine class plate	1	10	004 L-7	screw	1
5	279-184	shoe, presserfoot	1	11	27.91-1911	chaining finger	1
6	G27.91 E-191	presserfoot, complete	1	12	PM27.91 E-183	plate, with tube	1
N.B. When machine 227.00.01 is converted into 227.29.09 in the field, supply chaining plate PM.27.91 E-183 and not the complete presserfoot G 27.91 E-181.							



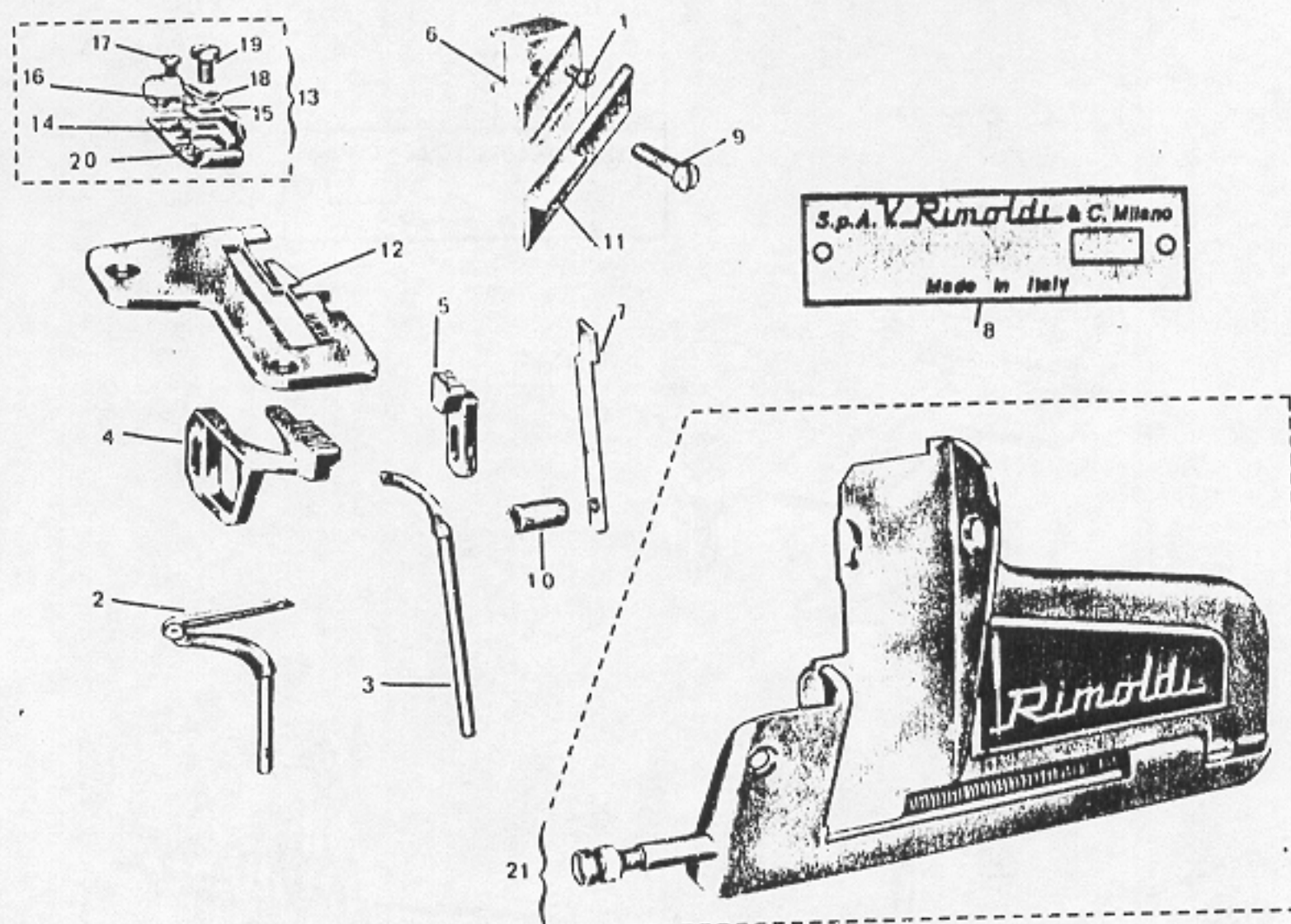
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	028-B-8	screw, chaining plate securing	1	11	27.92-0504	feed dog, front	1
2	270-075	primary looper	1	12	G.279-181	presserfoot, complete	1
3	272-051	feed dog, rear	1	13	279-191	chaining finger	1
4	27.277-0745	secondary looper	1	14	PM.279-183	plate, presserfoot stop	1
5	279-099	knife holder, upper	1	15	275-185	chaining plate	1
6	279-112	knife, upper	1	16	001-A-3,2	screw, chaining plate securing	1
7	279-113/1	knife, lower	1	17	270-196	lug, chaining plate	1
8	279-114	needle plate bight width 3/32"	1	18	004-L-7	screw, chaining finger securing	1
9	780228-0-00	machine class plate	1	19	279-184	shoe, presserfoot	1
10	279-987	screw, upper knife mounting	1	20	G.279-215/2	front coverplate, complete	1

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REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	279-113/1	knife, lower	1	14	004-A-2,5	screw	1
2	001-D-7	screw, guide securing	1	15	PM.272-G-417	arm, bearing	1
3	028-B-8	screw, chaining plate securing	1	16	PM.27.03-P-402	guide	1
4	270-075	primary looper	1	17	G.279-181	presserfoot, complete	1
5	272-051	feed dog, rear	1	18	279-191	chaining finger	1
6	27.277-0745	secondary looper	1	19	PM.279 183	plate, presserfoot stop	1
7	279-099	knife holder, upper	1	20	275-185	chaining plate	1
8	279-112	knife, upper	1	21	001-A-3,2	screw	1
9	279-114	needle plate bight width 3/32"	1	22	270-196	lug, chaining plate	1
10	780455-0-00	machine class plate	1	23	004-L-7	screw	1
11	279-987	screw, upper knife mounting	1	24	279-184	shoe, presser foot	1
12	27.94-0504	feed dog, front	1	25	G.279-216/2	front coverplate, complete	1
13	G.272-G-401	guide, lace attaching	1				



REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	028-B-8	screw, chaining plate securing	1	12	27.94-1142	needle plate bight width 1 7/8" to 9/64"	1
2	270-075	primary looper	1	13	G.27.94-1812	presserfoot, complete	1
3	27.277-0745	secondary looper	1	14	27.94-1912	chaining finger	1
4	279-050	feed dog, front	1	15	27.94-1832	plate, presserfoot stop	1
5	279-051	feed dog, rear	1	16	275-185	chaining plate	1
6	279-099	knife holder	1	17	001-A-3,2	screw	1
7	279-113/1	knife, lower	1	18	270-196	lug, chaining plate	1
8	780229-0-00	machine class plate	1	19	004-L-7	screw	1
9	279-987	screw, knife mounting	1	20	279-184	shoe, presserfoot	1
10	27.94-1012	bushing, lower knife holder	1	21	G.27.94-2152/2	front coverplate, complete	1
11	27.94-1122	knife, upper	1				
						On request:	
						270-075/2	Tab. 75
						27.277-074	" 75

3. Setting needle position (fig. 3).

- If needle plate is correctly installed, needle should be centred precisely over the slot in needle plate.
- When needle is at top dead center, the needle tip should be $25/64$ " away from needle plate.
For machine head 227-00-06 and sub-classes this distance should be $3/8$ ".
- To adjust height of needle bar clamp, loosen screw A (fig. 3) and check with gauge S. 1665.00.

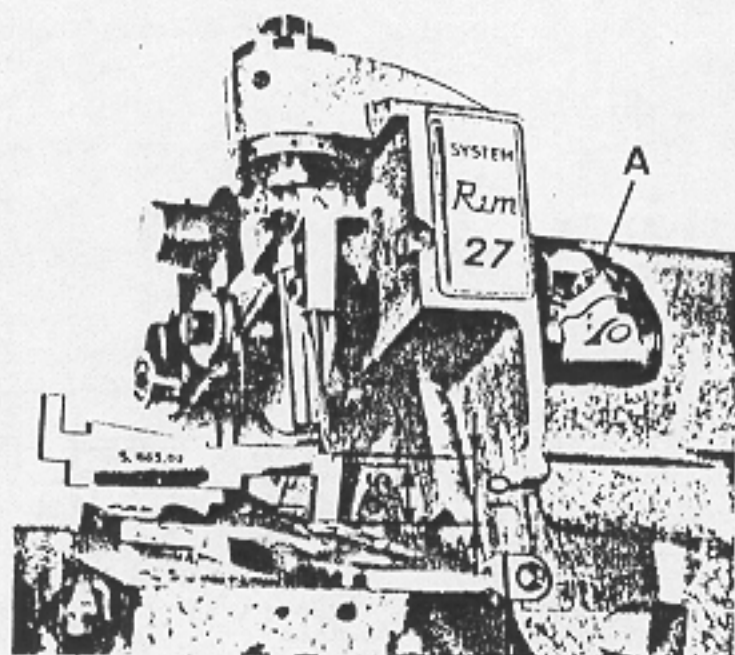


fig. 3

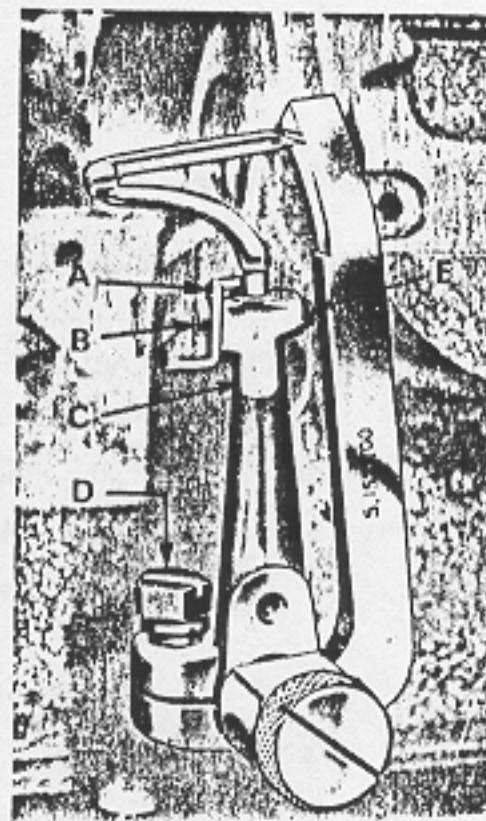


fig. 4

4. Timing primary looper (fig. 4).

Setting height

- Loosen screw E
- Screw gauge S.1555.00 on to primary looper shaft exerting slight pressure on screw.
- Set looper height so that its tip is coincident with the lower notch on gauge. For the 227-00-06 and sub-classes the looper tip should be coincident with the upper notch.
- Slightly lock looper by tightening screw E.
- Set height of thread guide bracket 'A' by raising it to top of looper shank and lock by tightening up screw 'B'.
- Remove looper height gauge S.1555.00.

Setting angle

- Slightly loosen screw 'D'
- Place timing gauge S.1665.00 on milled surface of base as shown in fig. 5; shift lever C and turn looper (which has been set in place but not locked) until correct angle is obtained.
- Correct position can be checked by reference to the timing table.
- Firmly tighten up screw E (fig. 4).

Setting the primary looper in relation to the needle:

- When the primary looper has completed its stroke to the left and with the needle in its lowest position, the distance between the looper point and the needle should be as indicated in fig. 6.
- If adjustment is necessary move lever C along its rotation axis. In its stroke from left to right the looper point should pass $1/64$ " from the bottom of the needle scarf.
- Retighten screw D.

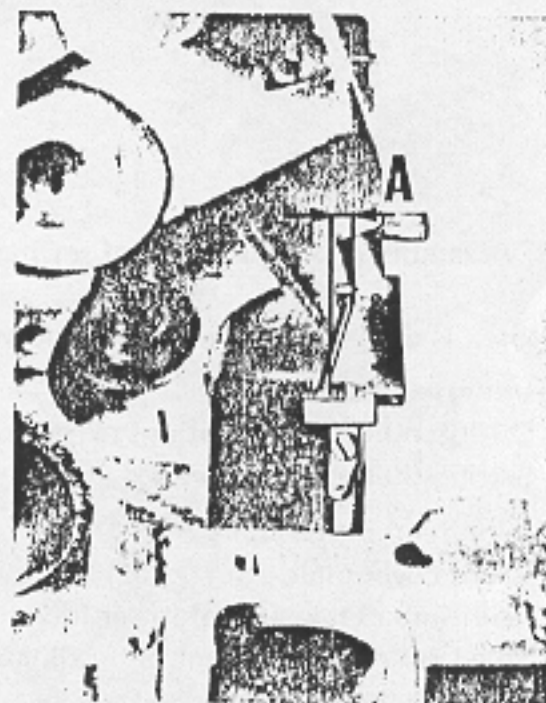
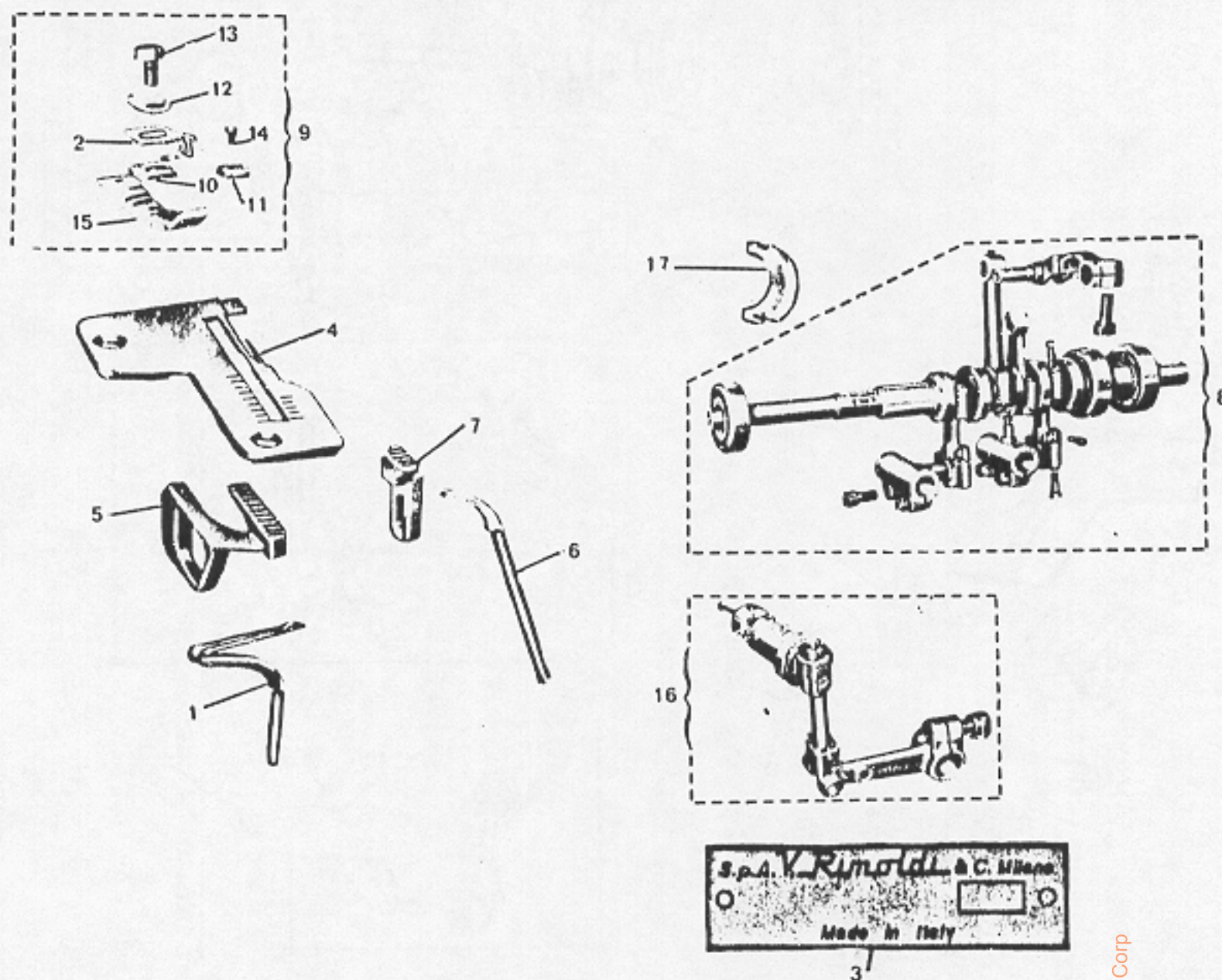


fig. 5



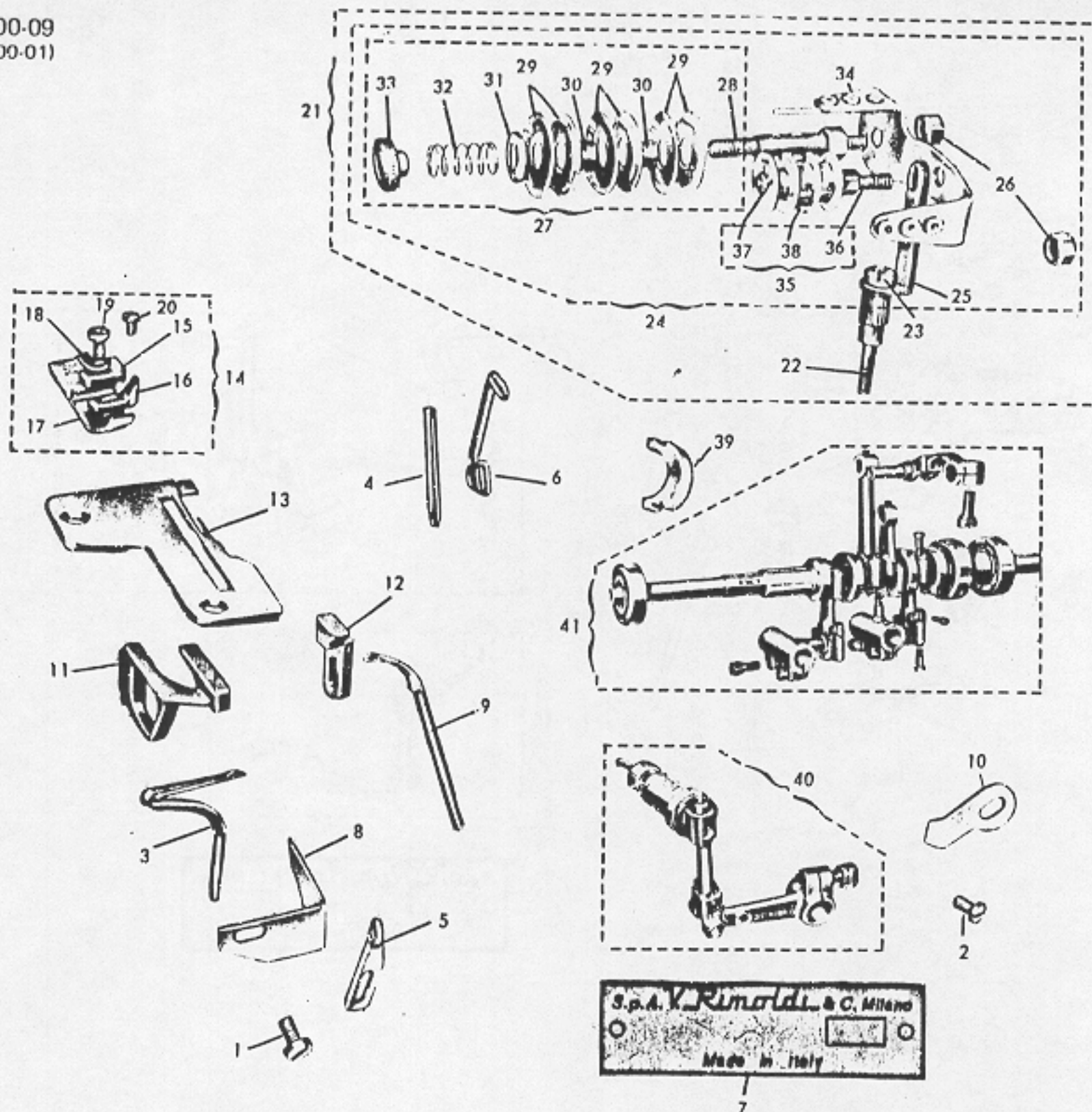
REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-0751	primary looper	1
3	780211-0-00	machine class plate	1
4	27.21-1141	needle plate bight width 3/64" to 1/16"	1
5	27.21-C-050	feed dog, front	1
6	270-074	secondary looper with eye	1
7	279-051	feed dog, rear	1
8	G.27.21-C2-009/4	main shaft and connecting rods	1
9	G.27.21-CC-181	presserfoot, complete	1
10	27.21-CC-191	chaining finger	1

REF. N°	PART. N°	DESCRIPTION	QUANT.
11	270-183	stop, presserfoot	1
12	270-198	lug, chaining plate	1
13	004-L-7	screw, chaining finger securing	1
14	270-989	screw, stop securing	1
15	27.21-C-184	shoe, presserfoot	1
16	G.27.21-C2-067/3	drive assembly, secondary looper	1
17	27.21-C2-617	rocker	1
On request:			
	272-050	Tab.	75
	272-051	"	75
	272-092	"	75
	G.272-181	"	76



REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-0751	primary looper	1	11	27.21-E-183	stop, presserfoot	1
2	PM.27.91-E-183	plate, with tube	1	12	270-196	lug, chaining plate	1
3	780436 0-00	machine class plate	1	13	004-L-7	screw, chaining finger securing	1
4	27.21-E 114	needle plate bight width 3/64" to 1/16"	1	14	270-989	screw, presserfoot stop mounting	1
5	27.21-C-050	feed dog, front	1	15	27.21-E-184	shoe, presserfoot	1
6	270-074	secondary looper, with eye	1	16	G 2721C2-067/3	drive assembly, secondary looper	1
7	279-051	feed dog, rear	1	17	27.21-C2-617	rocker	1
8	G2721C2-009/4	main shaft and connecting rod assembly	1				
9	G.27.21-E-181	presserfoot, complete	1				
10	27.21-E-191	chaining finger	1				

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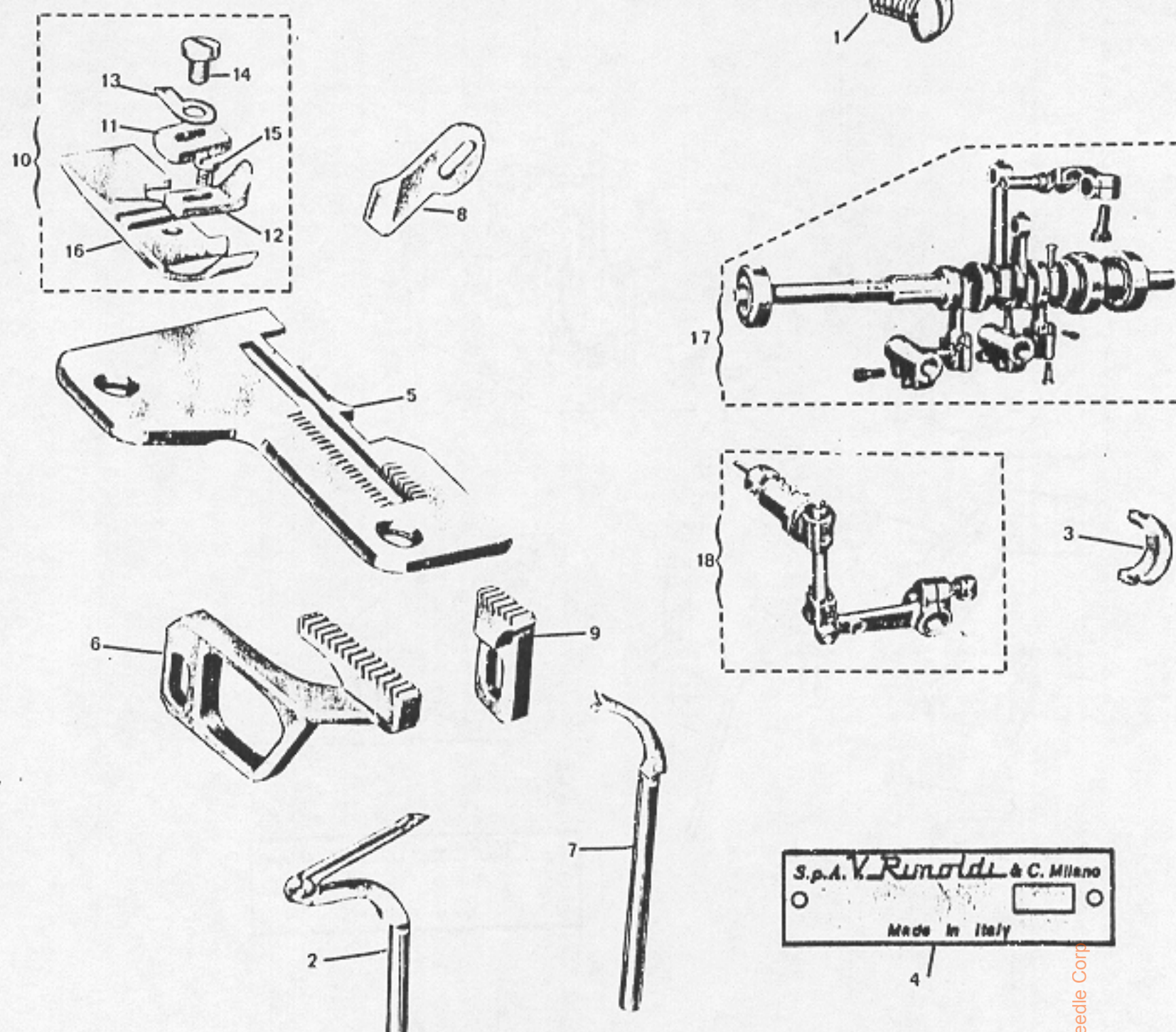


N.B. To convert a type 227-00-09 into a 227-00-09-100 see illustration 72-73

From the library of: Diamond Needle Corp

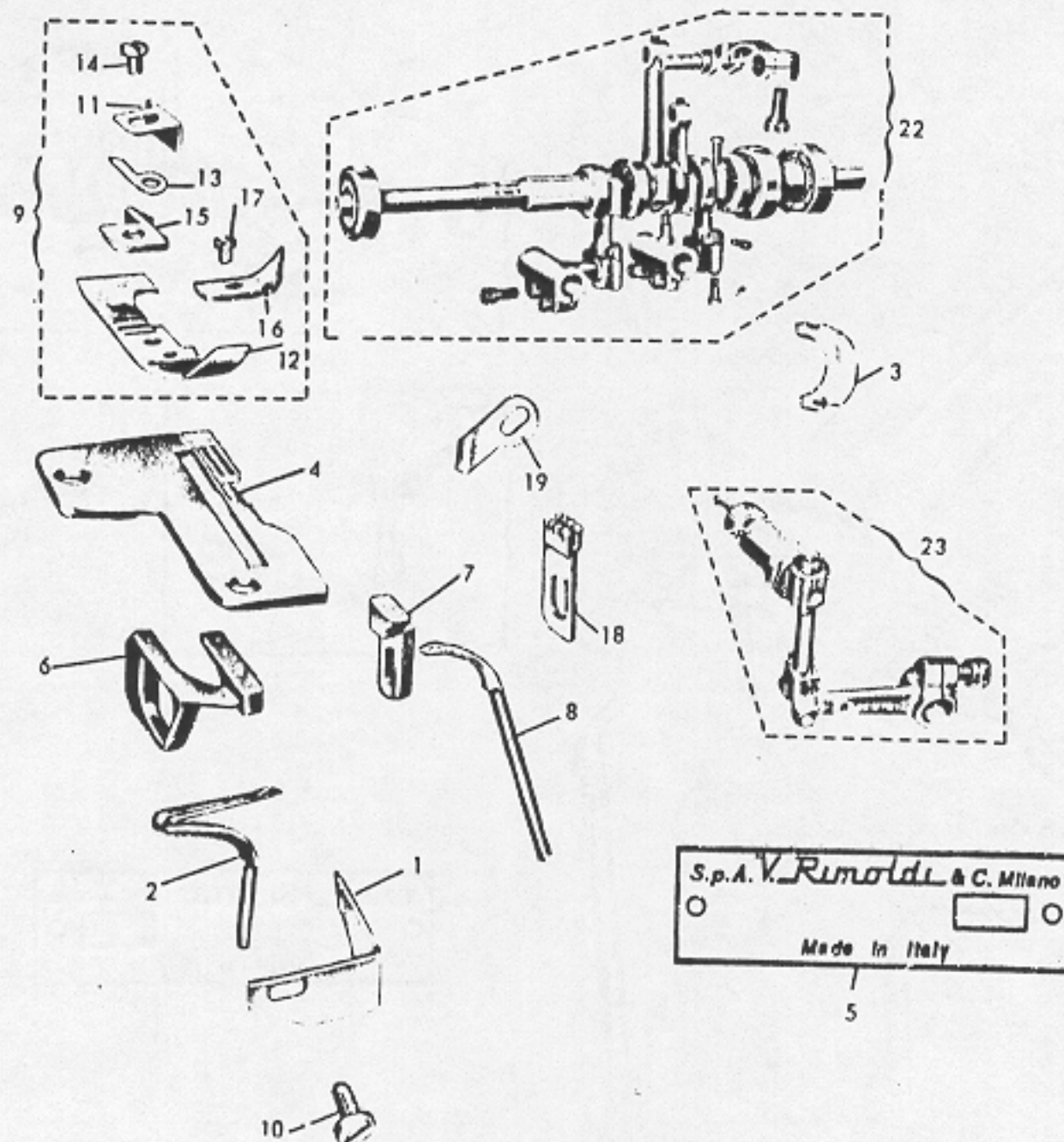
64.

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	001-D-7	screw, guide mounting	1	22	27.21-C-983	screw	1
2	003-M-7	screw, cap	1	23	001-G-10	screw	1
3	270-075	primary looper	1	24	G.27.21-C-700	tension disc assembly	1
4	270-263	thread guide, needle	1	25	27.21-C-702	angle bar	1
5	270-270	thread take-up, secondary looper	1	26	057-R-5	nut	2
6	270-274	thread take-up, needle	1	27	PM.27.21-C-708	shaft with discs	1
7	780209-0-00	machine class plate	1	28	27.21-C-708	shaft	1
8	27.21-C-220	guard, feed dog	1	29	250-031	tensioning disc	6
9	270-074	secondary looper	1	30	27.21-C-709	shim	1
10	128-110	shield, upper knife holder	1	31	240-035	washer, cup	1
11	PM.27.21-C-050	feed dog, front	1	32	27.21-C-232	spring	1
12	PM.27.21-C-051	feed dog, rear	1	33	3710	knurled knob	1
13	PM.27.21-C-114/	needle plate bight width 3/64" to 1/16"	1	34	G.27.21-C-703	plate with bushing	1
14	G.27.21-C-181/2	presserfoot, complete	1	35	G.27.21-C-704	pulley shaft	1
15	27.21-C-191/2	chaining finger	1	36	3707	shaft	1
16	270-183	chaining plate	1	37	270-701	snap ring	1
17	278-184-C2	shoe, presserfoot	1	38	PM.27.21-C-704	pulley	1
18	270-196	lug, chaining plate	1	39	27.21-C2-617	rocker	1
19	004-L-7	screw	1	40	G.27.21-C2-037/3	drive assembly, secondary looper	1
20	270-989	screw, presserfoot stop mounting	1	41	G.27.21-C2-009/4	main shaft and connecting rod assembly	1
21	AS.27.21-C-700	tensioning disc and pulley assembly	1	42			
On request:							
PM.27.21-C-114						Tab. 75	
G.27.21-C-181						" 75	
G.27.21-C-181/1						" 75	



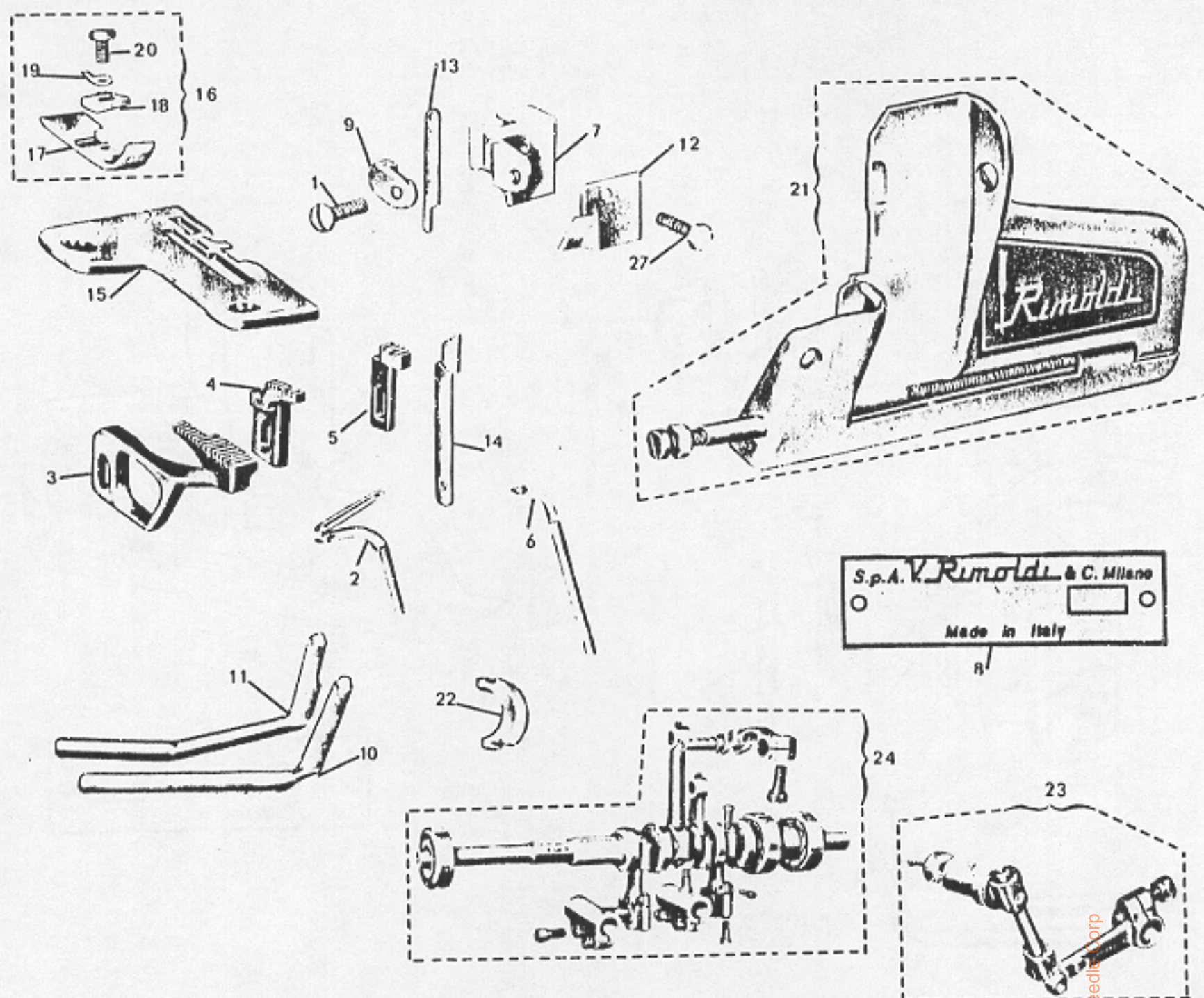
N.B. To convert machine 227-00-10 into machine 227-00-10-100 see illustrations 72/73

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	003-M-7	screw, cap	1	10	G.27.21-CC-181	presserfoot, complete	1
2	270-075	primary looper	1	11	27.21-CC-191	chaining finger	1
3	27.21-C2 617	rocker	1	12	270-183	chaining plate	1
4	780210-0-00	machine class plate	1	13	270-196	lug, chaining plate	1
5	27.21-1143	needle plate bight width 3/54" to 1/16"	1	14	004-L-7	screw	1
6	27.21-C-050	feed dog, front	1	15	270-989	screw	1
7	27.221-C-074/1	secondary looper, blind	1	16	27.21-C-184	shoe, presserfoot	1
8	128-110	shield, upper knife holder	1	17	G.27.21-C2-009/4	main shaft and connecting rod assembly	1
9	279-051	feed dog, rear	1	18	G.27.21-C2-067/3	drive assembly, secondary looper	1

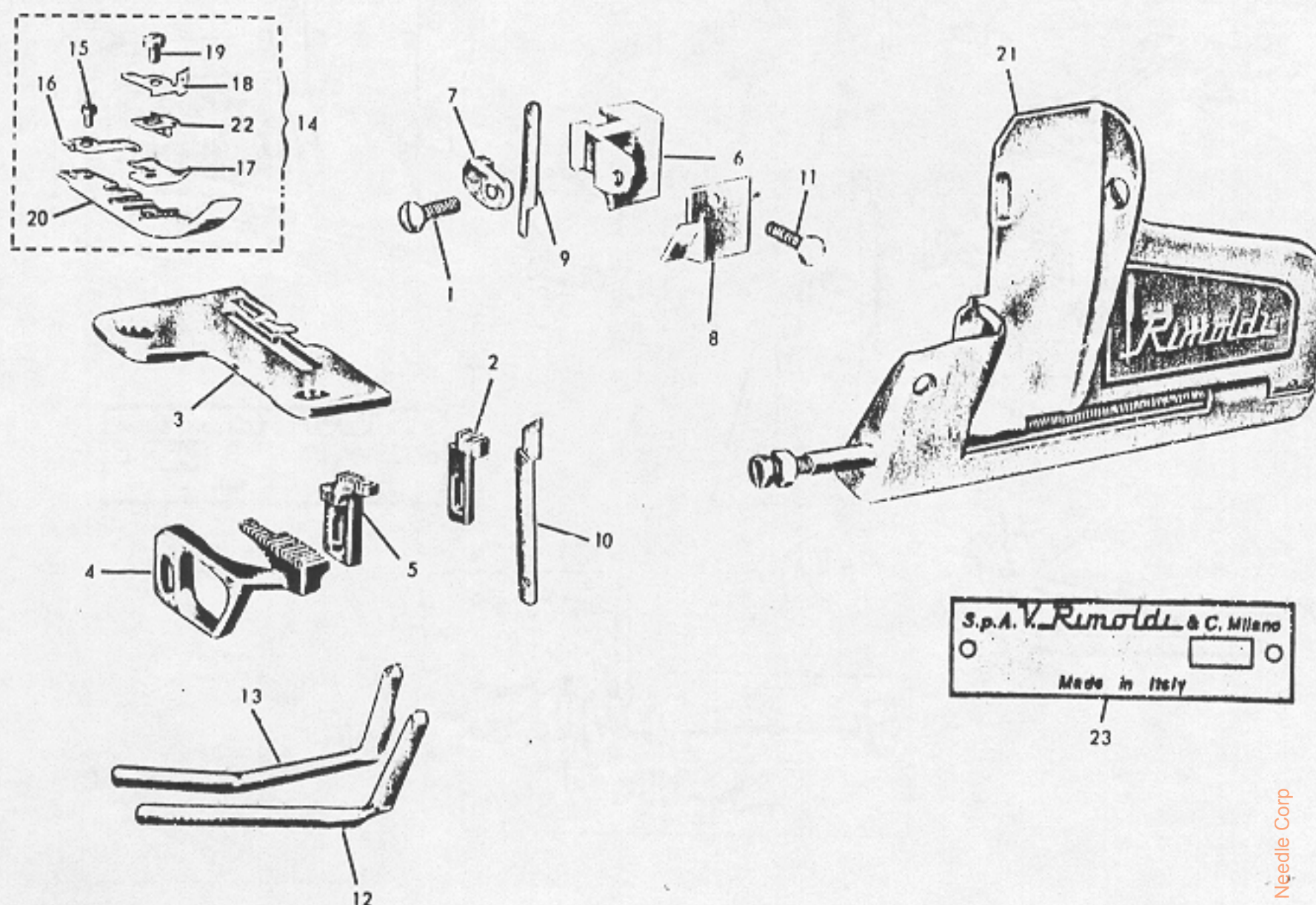


From the library of: Diamond Needle Corp

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	27.21-C-220	guard, feed dog	1	13	270-196	lug, chaining plate	1
2	270-0751	primary looper	1	14	004-L-8	screw	1
3	27.21-C2-617	rocker	1	15	272-C-191/1	chaining finger	1
4	PM.272-1S-114	needle plate	1	16	270-183	stop, presserfoot	1
5	780416-0-00	machine class plate	1	17	270989	screw	1
6	PM.27.21-C-050	feed dog, front	1	18	272-B-052	feed dog, chaining	1
7	PM.27.21-C-051	feed dog, rear	1	19	128-110	shield, upper knife holder	1
8	270-074	secondary looper,	1				
9	G.27.21-C-181/1	presserfoot, complete	1				
10	001-D-7	screw	1	22	G.27.21-C2-009/4	main shaft with connecting rod assembly	1
11	27.21-C-183/1	chaining plate	1	23	G.27.21-C2-067/3	drive assembly, secondary looper	1
12	27.21-C-184/1	shoe, presserfoot	1				

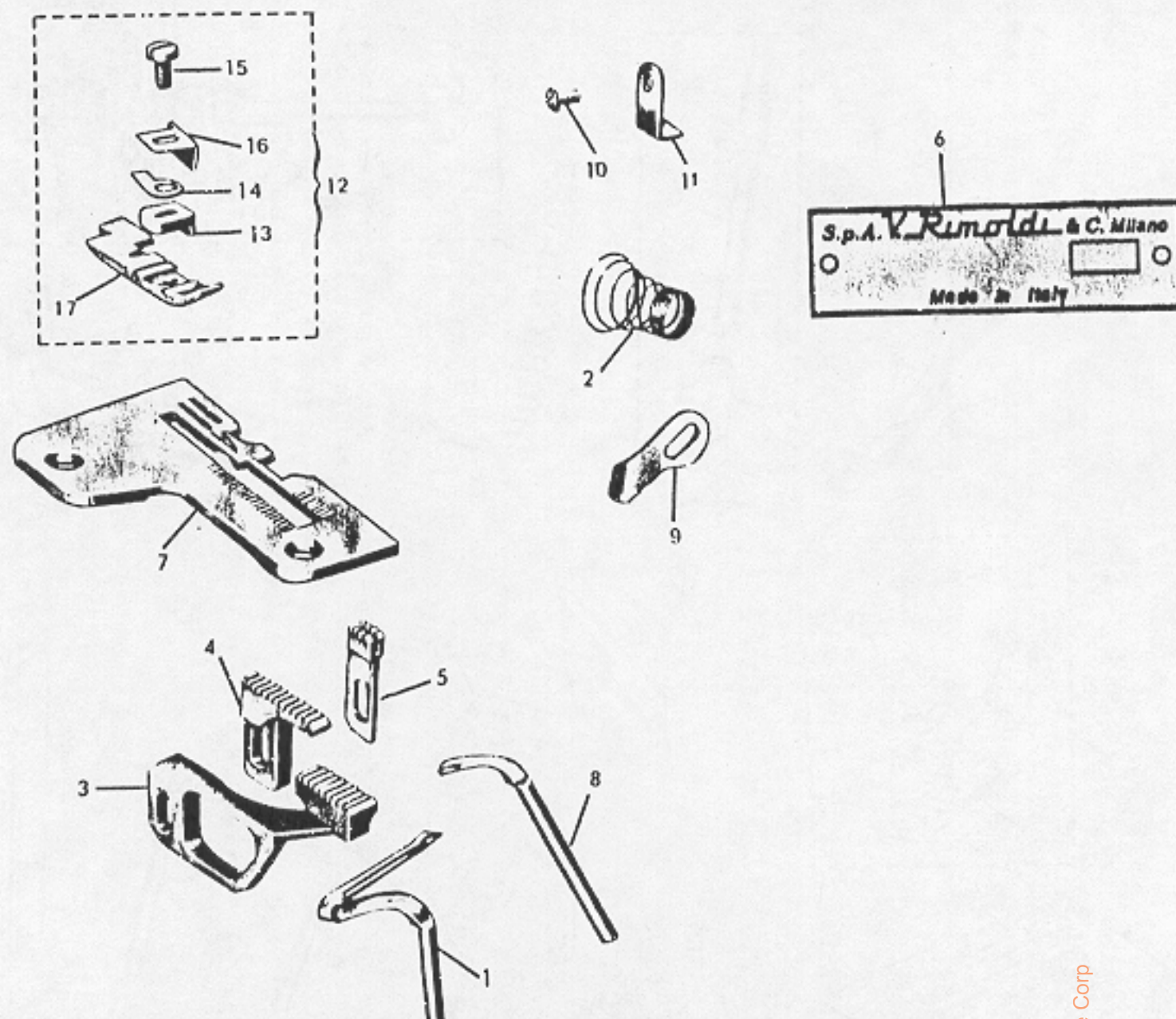


REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	272-BK-987	screw, lug securing	1	15	27.22-1144/1	needle plate height width 3/64" to 1/16"	1
2	270-0751	primary looper	1	16	G.27.22-1814/1	presserfoot, complete	1
3	27.22-0504	feed dog, front	1	17	27.22-1844/1	shoe, presserfoot	1
4	27.22-0514	feed dog, rear	1	18	27.22-1914	chaining finger	1
5	27.22-0524	feed dog, chaining	1	19	270-195	lug, chaining plate	1
6	270-074	secondary looper, blind	1	20	004-L-7	screw	1
7	27.22-0994/1	knife holder, upper	1	21	G.27.22-2164/2	front cover plate, complete	1
8	780417-0-00	machine class plate	1	22	27.21-C2-617	rocker	1
9	27.22-1034	lug, upper knife stop	1	23	G.27.21-C2-067/3	drive assembly, secondary looper	1
10	27.22-1074	needle guard, front	1	24	G.27.21-C2-009/4	main shaft with connecting rods assembly	1
11	27.22-1094	needle guard, rear	1				
12	27.22-1114	shield, upper knife	1				
13	27.22-1124	knife, upper	1	27	27.22-9874	screw, upper knife holder mounting	1
14	27.22-1134/1	knife, lower	1	28			
						On request:	
						G.27.22-2524/1	Tab. 76
						27.221-C-074/1	" 76



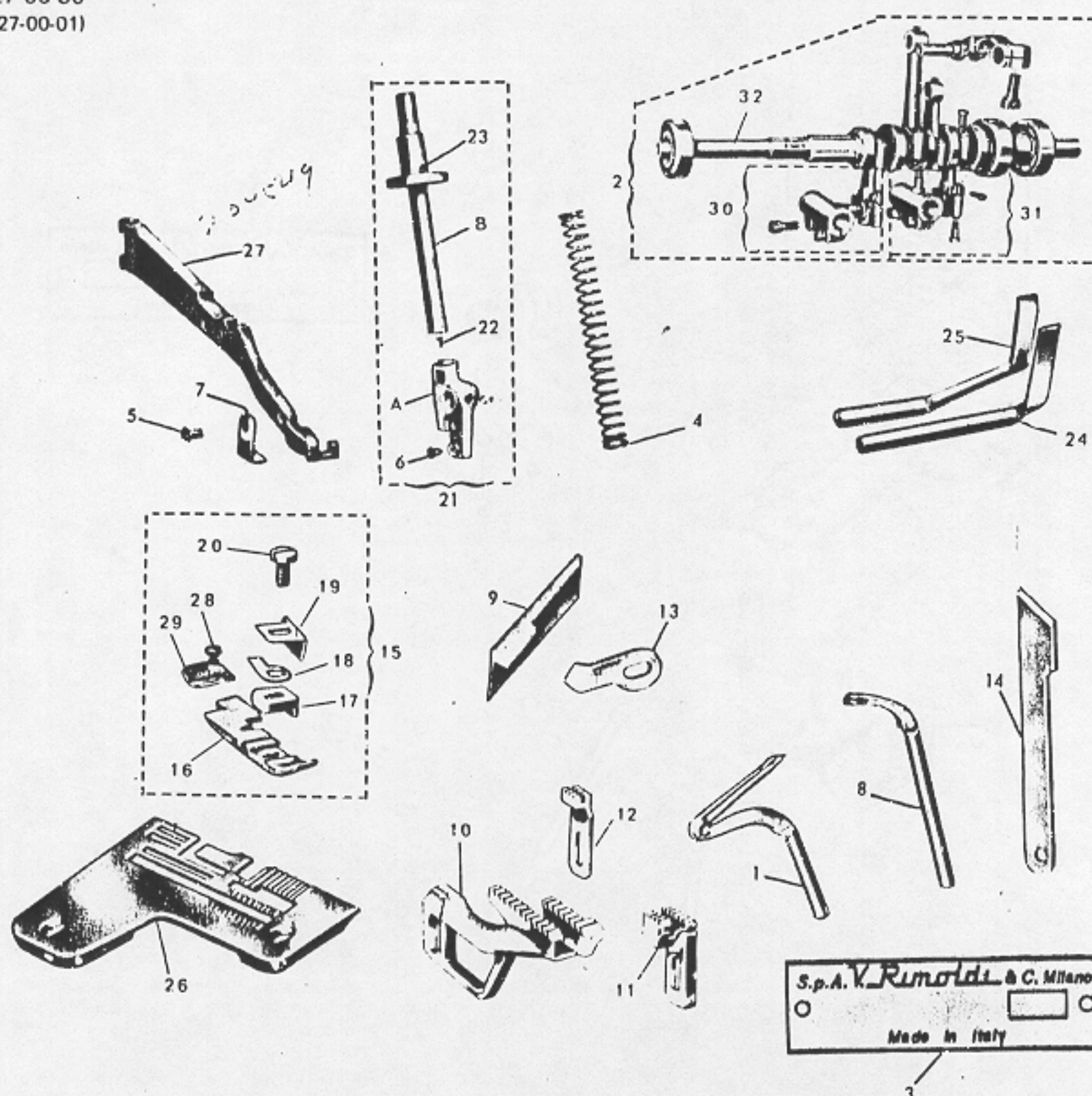
From the library of: Diamond Needle Corp

REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	272-BK-987	screw, lug securing	1	13	27.22-1094	needle guard, rear	1
2	27.20-052	feed dog, chaining	1	14	G.27.20-181/3	presserfoot, complete	1
3	27.20-114/1	needle plate bight width 1/8"	1	15	001-A-2,5	screw	1
4	27.22-0504	feed dog, front	1	16	27.20-185	chaining plate	1
5	27.22-0514	feed dog, rear	1	17	27.20-191/1	plate, presserfoot stop	1
6	27.22-0994/1	knife holder, upper	1	18	27.20-195	lug, chaining plate	1
7	27.22-1034	lug, upper knife stop	1	19	004-L-8	screw	1
8	27.22-1114	shield, upper knife	1	20	27.20-184/3	shoe, presserfoot	1
9	27.22-1124	knife, upper	1	21	G.27.22-2164/2	front cover plate, complete	1
10	27.22-2164/2	knife, lower	1	22	27.20-183	plate	1
11	27.22-9874	screw, upper knife holder mounting	1	23	780208-0-00	machine class plate	1
12	27.22-1074	needle guard, front	1				
						On request:	
						G.27.22-2624/1	Tab. 76
						27.20-191/2	" 76



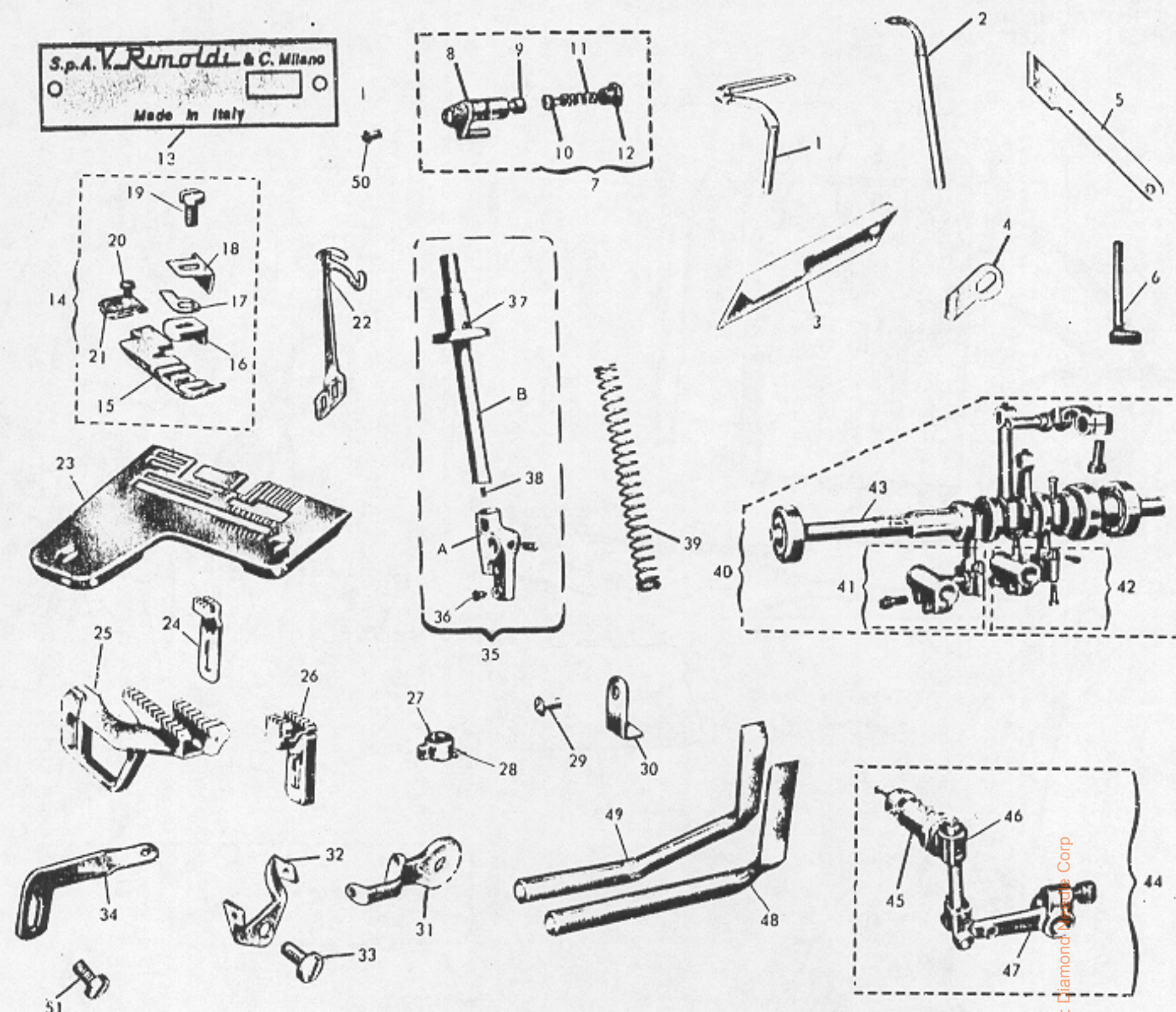
REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-075	primary looper	1	10	27.01 P-403, 1	screw	1
2	270-232, 1	spring, primary looper	1	11	272-186	angle stop, presserfoot	1
3	272 B-050	front feed dog	1	12	G272B-181, 2	presserfoot assembly	1
4	272 B-051	feed dog, rear	1	13	272 B-191	chaining finger, presserfoot	1
5	272 B-052	feed dog, chaining	1	14	270-196	bracket, presserfoot	1
5	780202-0-00	machine type nameplate	1	15	004 L-8	screw	1
7	272 B-1141	needle plate	1	16	272 B-183	chaining plate	1
8	27277-0745	secondary looper	1	17	272 B-184, 1	shoe, presserfoot	1
9	128-110	shield, upper knife holder	1				
						On request:	
						272-092	Tav. 75
						272 B-0501	" 75
						272 B-0511	" 76
						272 B-114	" 76
						272 B-114, 1	" 76

107



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REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-075	primary looper	1	18	27.77-196	bracket, presserfoot	1
2	G27.00B-009/3	main shaft and connecting rod assembly	1	19	27.77-183	chaining plate	1
3	780230-0-00	machine type nameplate	1	20	004 L-9	screw	1
4	27.01 P-092	spring, presserfoot pressure	1	21	G27.77-025.2	needle bar assembly with clamp, complete	1
5	27.01 P-403.1	screw	1	22	016 A-2.5	screw	1
6	003 A-4.5	screw	1	23	092 A-10	oil-wich, for needle bar	1
7	27.26-186	angle stop, presserfoot	1	24	27.77-107.1	needle guard, front	1
8	27.277-0745	secondary looper	1	25	27.77-109.1	needle guard, rear	1
9	276 B-112	knife upper	1	26	27.7-1141.S	needle plate	1
10	277-0501	front feed dog	1	27	28.778-07671.1	presserfoot arm	1
11	277-0511	feed dog, rear	1	28	001 A-3.2	screw	1
12	277-052/S	feed dog, chaining	1	29	277-185.S	plate, chaining guide	1
13	128-110	shield, upper knife holder	1	30	PM270-059.1	sleeve assembly	1
14	277-113	lower knife	1	31	PM270-060.1	sleeve assembly	1
15	G27.7-1811.S	presserfoot assembly	1	32	270-039/3	main shaft	1
16	277-184/S	shoe, presserfoot	1	A	27.77-020	needle clamp	1
17	277-191	chaining finger, presserfoot	1	B	290-025.1	needle bar	1
On request:							
277-114/S							
277-1142/S							
277-050							Tab 75
277-051							76



REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-075	primary looper	1	28	016 B-2,5	screw	1
2	27.77-074	secondary looper	1	29	27.01 P-403.1	screw	1
3	27.77-112	knife, upper	1	30	27.26-186	angle stoop, presserfoot	1
4	128-110	guard, upper knife holder	1	31	270-272	take-up looper thread	1
5	277-113	lower knife	1	32	270-269.1	take-up primary looper	1
6	PM27.77-263	tube needle thread guide	1	33	037 C-7	screw	2
7	G270-262.2	needle thread take-up assembly	1	34	27.26 B-270	take-up secondary looper	1
8	PM270-262.2	thread guide assembly with pin	1	35	G27.77-025.2	needle bar assembly with clamp complete	1
9	270-255	pin needle thread take-up	1	36	003 A-4,5	screw	1
10	270-259	pin needle thread take-up	1	37	092 A-10	oil-wick, for needle bar	1
11	270-258	spring	1	38	016 A-2,5	screw	1
12	270-261.1	stud, needle thread tension	1	39	27.01 P-092	spring, presserfoot pressure	1
13	780233-0-00	machine type nameplate	1	40	G27.77-009.3	main shaft assembly with connecting rods	1
14	G277-181 S	presserfoot assembly	1	41	PM270-060.1	sleeve assembly	1
15	277-184/S	shoe, presserfoot	1	42	PM27.77-060	sleeve assembly	1
16	277-191	chaining finger, presserfoot	1	43	270-009.3	main shaft	1
17	27.77-196	bracket presserfoot	1	44	G27.77-067/3	looper drive shaft with connecting rods	1
18	27.77-183	chaining plate	1	45	27.77-056.1	adjustable bush	1
19	004 L-9	screw	1	46	27.77-065.3	oscillating-guide	1
20	001 A-3,2	screw	1	47	27.77-067	control lever secondary looper	1
21	277-135	plate chaining guide	1	48	27.77-109.1	needle guard, rear	1
22	270-274/3	take-up, needle thread	1	49	27.77-107.1	needle guard, front	1
23	277-114/S	needle plate	1	50	004 A-5	screw	1
24	277-052.S	feed dog, chaining	1	51	004 L-6	screw	1
25	277-050	front feed dog	1	A	27.77-020	needle-clamp	1
26	277-051	feed dog rear	1	B	290-025.1	needle-bar	1
27	270-271	thread guide primary looper	1				