

**UNITED**

**TAPE  
EDGE**

**CLOSING  
MACHINE**

**MODEL NR**

**UNITED MATTRESS MACHINERY COMPANY**

*Division of Mathewson Corporation*

86 Finnell Dr. Unit 6 • Weymouth, MA. 02188 • Telephone: 781-331-8440 or 800-245-7250

A Complete line of bedding machinery

**UNITED**  
*MATTRESS MACHINERY*

***UNITED*** MODEL NR® TAPE EDGE  
CLOSING MACHINE

**OPERATING AND PARTS MANUAL**

**MATHEWSON CORPORATION**  
***UNITED* MATTRESS MACHINERY**  
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# OPERATING MANUAL

## FOREWORD

This construction manual and parts catalog contains all the necessary information on installation, operation, care and maintenance of the United Model NR Tape Edge Closing Machine.

The design of this machine is the result of a continuous development program to provide you with modern production equipment to help make better products ... faster and at less cost.

To insure the successful operation of the machine it should be kept well lubricated and as clean as possible.

**PLEASE READ THIS MANUAL THOROUGHLY BEFORE OPERATING THE MACHINE**

### **ASSEMBLY INSTRUCTIONS**

This heavy duty machine is shipped to you in a single crate, with the completely assembled table on a skid, and boxed with the carriage and sewing head each strapped to it. The accessories are wrapped and packed in a separate box inside the shipping box.

#### **TABLE**

Set up the table in its proper location. install the adjusting screws provided, at the bottom of each leg to level the table.

#### **CARRIAGE**

To assemble the carriage to the table, first remove the roller and stud from the bracket at upper track level. This roller normally runs against the narrow inside (back) face of the upper track. It must be removed to get the carriage on the track. When the carriage has been lifted on the track, running on its caster rollers, replace the roller and stud, this roller adjusts the backlash in the carriage gear and is pre-set at the factory by means of the two set screws and locknuts in the front of the carriage mounting brackets. After mounting the carriage on the table, check for proper backlash by

reaching through the back of the carriage and turning the drive gear side to side. The gear should only have enough play to be just barely noticeable.

The machine has been tested at the factory and no other adjustments are needed.

#### **SEWING HEAD**

Attach the sewing head to the carriage, by means of the four hex head screws provided. These are put in from the bottom, and on two of them a little reaching under the carriage upper tilt plate will have to be done.

Fasten the sewing head drive belt (round belt) over the pulley and feed over idler pulley and sewing head pulley. Then replace the drive wheel cover and sewing head belt guard.

#### **WORK LIGHT**

The work-light bracket is fastened on the side of the head opposite the operator's position. Two screws for fastening the bracket will be found in place. The wire to plug in the work light should be fastened in two places with plasticclips before plugging it into the lower outlet on the carriage.

(The top outlet is for the main power wire coming down from the swivel.) Both these plugs (connectors) are of the twist-on type, requiring a short twist to lock them in place.

### THREADING

Next, fasten the (lower) thread cone platter and the (upper) tape reel on the same side of the carriage, away from the table. A rubber guide loop for the main power wire is attached to the head with the same screw used to fasten the tape reel.

Three thread guides, consisting of a wire with a loop at each end are fastened to the carriage and sewing head below the tape reel. The right-hand (needle) thread uses two thread guides, a long one on the carriage and a shorter one on the head; the latter to the left to by-pass the reel. The looper thread, further to the left, uses only one (long) thread guide on the carriage. These guide the two threads to the bracket on top of the head.

The looper thread (on the left) passes from the bracket down through a tube provided. Just thread any needle to the thread and use it as a weight to pass the thread down through the tube to its lower tension post.

The other (needle) thread goes from the upper tension post over various thread guides across the top of the head and down the nose to the needle. The sewing head comes to you fully threaded, so please observe the various thread guides. For further threading information, see page x of this section.

### ELECTRICAL CONNECTIONS

**ALL ELECTRICAL CONNECTIONS SHOULD BE MADE BY A QUALIFIED ELECTRICIAN**

### TABLE MOTOR

Connect from floor under the table to eliminate exposed wires.

### OVERHEAD SWIVEL

Fasten the overhead swivel (banjo) to the ceiling from 7' to 10' above the floor level. The swivel wire is

brought down and threaded through a rubber loop, which is fastened to the head below the tape reel with one of the tape reel screws. Be sure the "ground" wire is properly connected. The swivel wire is plugged in and twisted (locked) in place on the upper one of the two connectors on the side of the carriage.

### STARTING MACHINE

It is advisable to first turn it over by hand, to be sure everything is in order before turning on the power.

Be sure carriage moves freely along the rail before starting the machine.

Press your right knee against the foam rubber pad on the clutch control, flip the start switch to on, and then move the clutch handle to the horizontal position.

### ATTENTION:

**Movement of the clutch handle to the horizontal position without depressing the clutch knee pad will result in severe damage to the carriage drive and void the warranty.**

### ADJUSTMENTS

The machine is designed to tape-sew the full circumference of the mattress, to sew the complete panels to the boxing.

It will also close the ends of the mattresses filled on a filling machine with or without tape. When finishing a seam with tape, cut it off just behind the needle and sew it off to complete the unbroken tape continuity around the mattress edge. To rethread the tape into the binder, if necessary, cut it off on a long bias to create a point on the tape for easier threading.

The United heavy-duty head on this machine sews without bobbins, without interruption for the length of the thread cones. Owing to the special construction of the sewing head, it sews with walking feet up very close to the end of the arm, with the tape always under compression and requiring a minimum of effort for the

operator to pull the boxing and the panel into sewing position in the binder.

A soft 30/3 cord thread is recommended for both the needle and the looper. Either left twist or right twist thread can be used.

For the piping attachment, a 24/3 cord thread is recommended for the needle only.

### **LOOPER ADJUSTMENT**

To time and position the "United" sewing machine looper, set the machine to the desired stitch length. Loosen the Looper Carrier Crank Clamping Nut (#201524) sufficiently to be able to tap the Looper Carrier from position. Set looper timing mark (L.T.) on machine pulley opposite the arrow on the front of the arm. Tap the looper carrier until the looper point is at the center of the needle.

Turn the machine pulley until the letter "G" is opposite the arrow on the front of the arm. At this position the looper point should again be at the center of the needle. If it is not, adjust the timing of the looper crank by adjusting the looper timing screw, until the point of the looper is at the center of the needle at both the above described position of the machine pulley. ("L.T." opposite arrow and "G" opposite arrow.)

When this position is obtained, securely tighten the looper carrier crank clamping nut. The looper will now be timed and positioned correctly.

## OPERATING INSTRUCTIONS

About 7' x 10' floor space is needed for operating the machine. A combination of the angle setting (tilt) of the sewing head, plus the power adjustment of the table height, permits closing mattresses and cushions from 1" up to 11¼" box, or knife edge cushions and pads.

When the clutch handle, located to the left of the starting switch, is vertical (upright), the carriage is not in gear and will not move forward when the power is turned on. When this same handle is pulled to a horizontal position, the machine carriage is in gear and will move forward when the sewing head starts to function.

**CAUTION:** Movement of the clutch handle to the horizontal position without depressing the clutch knee pad will result in severe damage to the carriage drive and void the warranty.

There is a plunger type locking device just below the clutch handle which locks the carriage tight in place when it is desired to use the sewing head in a stationary position, viz: for closing cushions or similar smaller articles.

In general operation of this equipment, to stop the whole mechanism, both sewing head and forward motion carriage, press the right knee against the foam rubber pad on the knee control. This will leave both the operator's hands free to guide the sewing.

To start the whole mechanism forward, sewing, remove the knee pressure slowly from the knee control.

For the mattress closing operation, have a fully assembled mattress on the machine table with both the hemmed panels temporarily fastened to the hemmed boxing with 3" upholstery pins - six pins per panel will do. Use the finger-tip table height control to regulate for the proper sewing height by merely pulling the cord at any point around the table. Pull to the right to raise the mattress; to the left to lower it. Limit switches prevent the table from raising or lowering too far.

Before starting to sew, grasp the panel firmly with the left hand, the boxing with the right, aiming the two together so that the edges are in the binder. A special lever on the sewing head will lock the presser foot in the upper (open) position so that the panel and boxing can be pushed into the binder without difficulty.

To release the presser foot from the upper (raised and locked) position, the operator needs only to push the lever with his elbow, so that it disengages from its lock notch and closes down on the material to be sewn. The sewing head can then be turned over by hand to push the needle through the goods to be ready for sewing.

Have everything ready to sew, with the right knee pushed up against the foam rubber knee pad, and then turn on the power. Withdraw the knee pressure gradually, permitting the carriage to start forward, sewing as it goes along. To stop the machine, apply positive pressure with the right knee on the foam rubber pad again, which disengages the clutch and stops the machine.



## SPECIAL OPTIONAL FEATURES

### **PIPING ATTACHMENT**

A piping attachment is available, at an extra price, for the United Model NR Tape Edge Machine. It consists of a bracket for holding the 12 lb. roll of roving, guide piece to feed the roving into the needle, and a binder for using 1-7/16" tape.

This attachment produces the effect of a miniature roll edge, and adds height to the box of the mattress. If the original machine is purchased with this piping attachment, there is no problem for the user to figure out the feed of the roving. The tape goes into the binder from the binder platen just as any other tape would, and is hand-fed into the binder by cutting off the tape on the bias to create a point for easier handling.

All machines are drilled in the factory for this piping attachment, so it can be put on with the aid of an instruction blueprint (NR-465) furnished when sold separately for later attaching.

**SPECIAL NOTE:** When the piping attachment is used, we recommend changing from a 30/3 to a 24/3 cord thread on the needle. Machines furnished with the piping attachment as original equipment also have a standard 7/8" tape binder and pivot arm furnished as a separate unit. The two binders with their pivot arms are interchangeable so that the machine can be used for either a piping or a plain tape.

To change over from one attachment to another, simply remove the knurled-head pivot screw, replace the one attachment and its arm with the other, and the machine is ready to sew. Of course, the different size tape (with or without the roving) has to be fed into the binder. To do this quickly, cut the tape on the bias with scissors to create a long (tapered) point, which will feed into the binder easily.

**IF YOU HAVE ANY QUESTIONS, PLEASE CALL US AT 1-800-245-7250 OR FAX US AT 617-331-8870.** Our trained personnel will be pleased to help you.

### **EXTENSION BARS**

The special optional extension rack for oversize mattresses easily slides out 18" on either side to give extra support for King and other oversize mattresses. Locks out of the way when working on standard sizes.

### **UNDER TABLE SWIVEL**

The United under table swivel not only gives you trouble free operation, but it eliminates all overhead cords or swivels. Just plug in the power inlet cord and you are ready to start operating.

### **VARIABLE SPEED**

The optional variable speed system controls the speed of travel of the carriage and sewing head as they move along the table.

There are two knobs at the operator station, one for controlling the speed of the carriage along the straight portion of the table and the other to set the speed of the carriage as it travels through the corners. Speeds for straight and corner travel are independent.

The speeds selected depend on the skill and experience of the operator.

**Please note:** The carriage should not be subjected to shock as it enters the corners. Be sure to set the speed so that the carriage enters the corners smoothly.

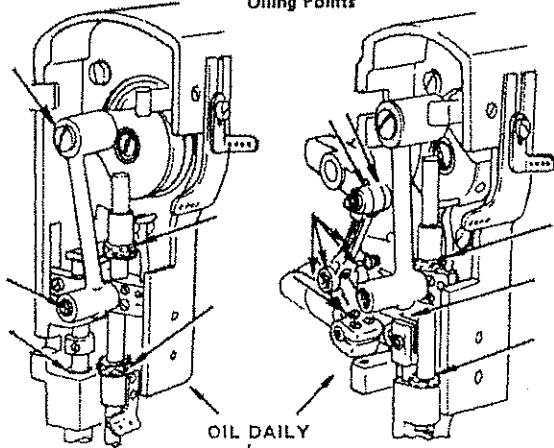
Travel speed is also controlled by means of the foam rubber knee pad. The carriage can be stopped by exerting "inward" pressure on the knee pad. Reducing the inward pressure on the knee pad allows the carriage to reach the travel speed set at the operator's station.

The variable speed electrical/ electronic components are enclosed under a cover guard located on the side of the carriage opposite the operator's station. The major electronic component under this guard is Zener master controller. Please refer to the Zener instruction manual for trouble shooting.

# SEWING HEAD LUBRICATION

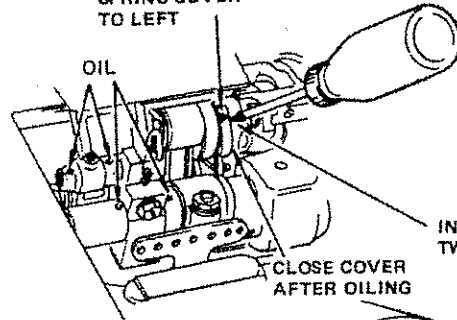
Use Singer Oil, "Type B" or Type D"  
Use "Type D" for minimum stain.

Oiling Points



OIL DAILY

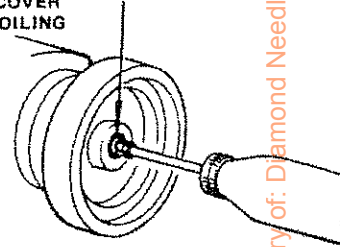
PUSH  
SPRING COVER  
TO LEFT



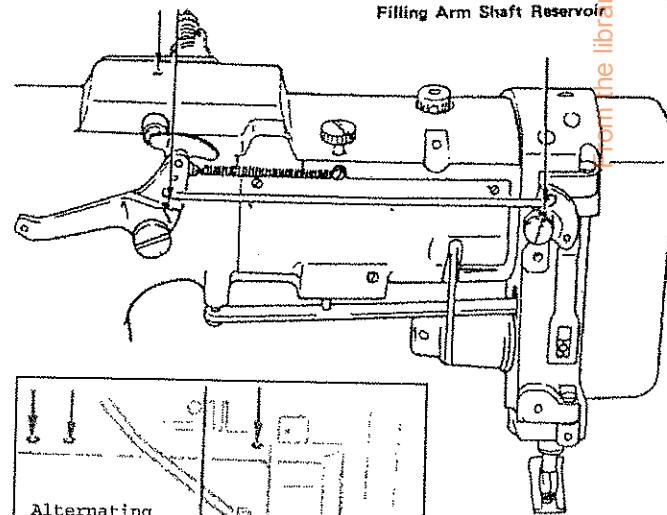
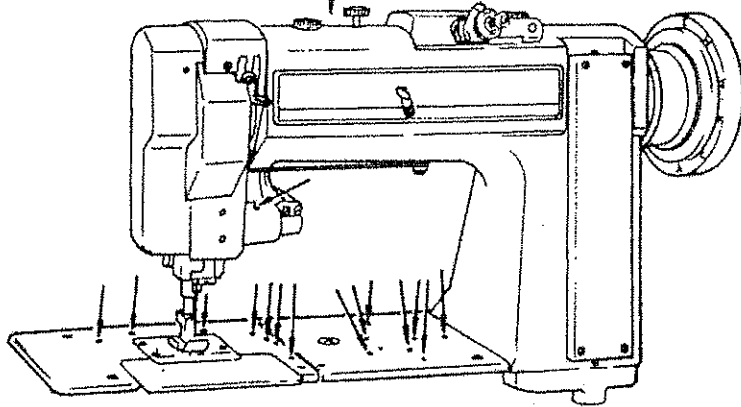
INJECT 1 SHOT  
TWICE DAILY

CLOSE COVER  
AFTER OILING

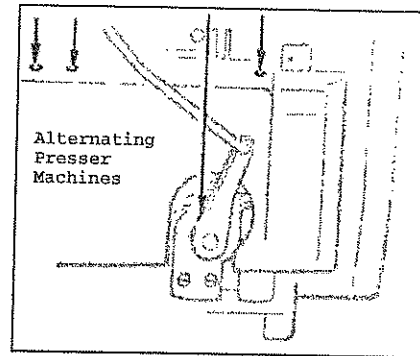
Filling Bed Shaft Reservoir



Filling Arm Shaft Reservoir



Oiling Points  
(Rear View)



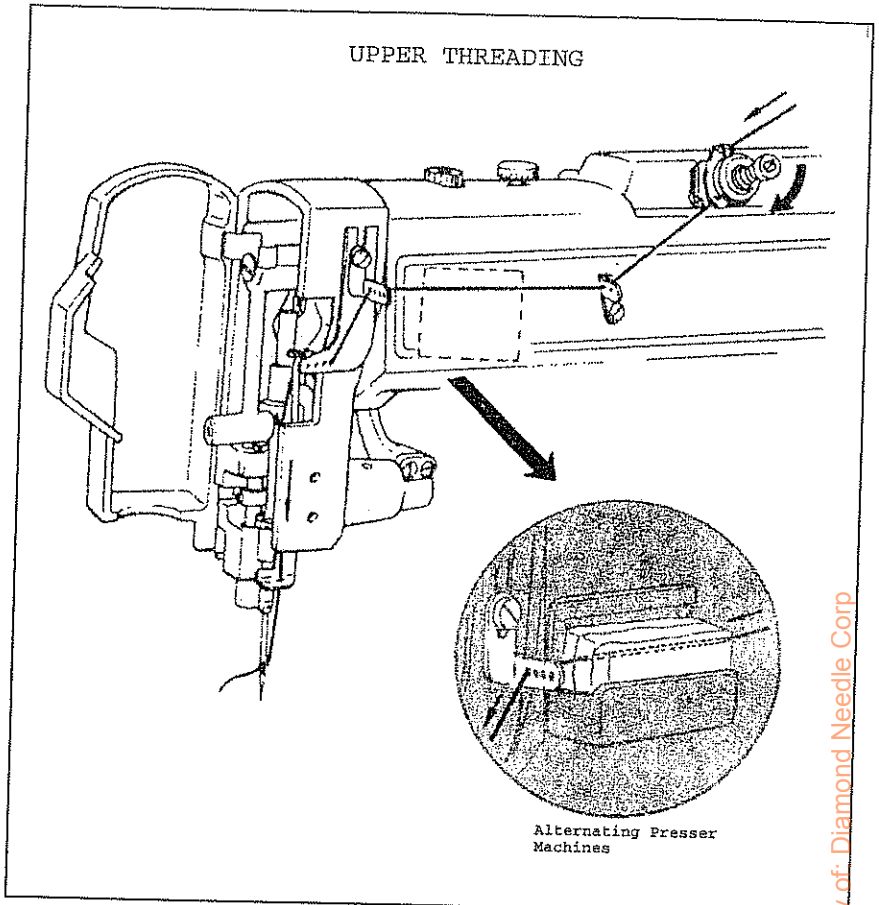
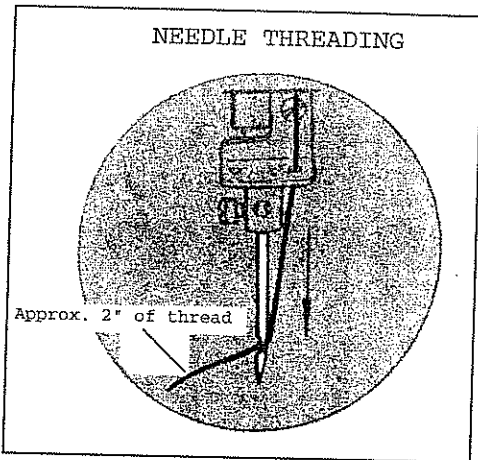
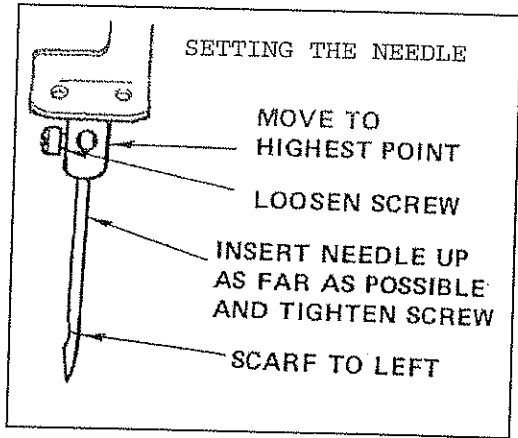
Alternating  
Presser  
Machines

## CLEANING

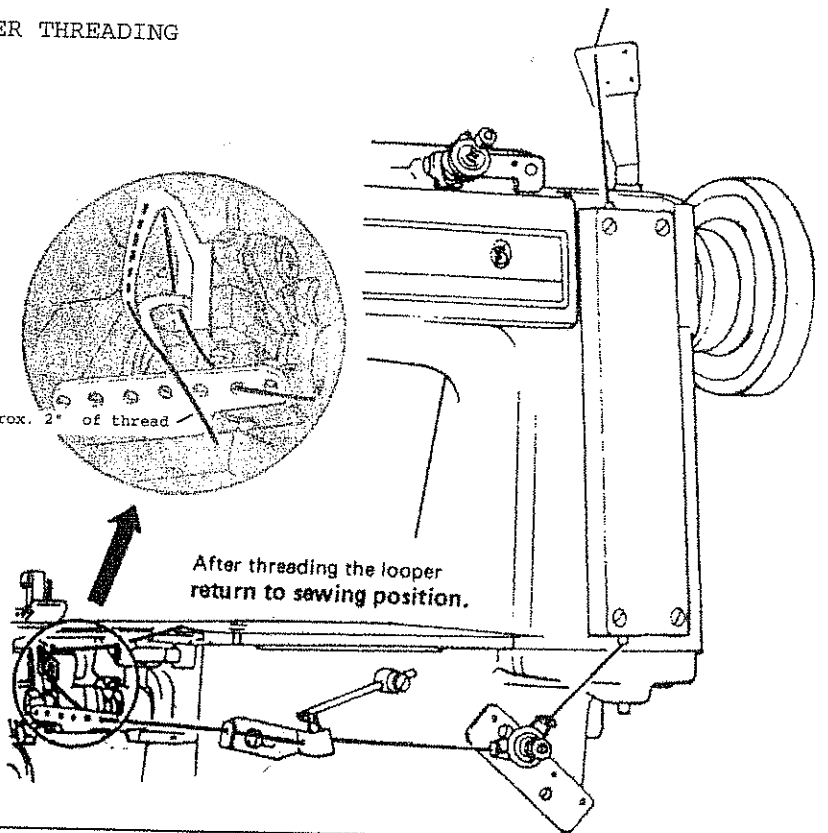
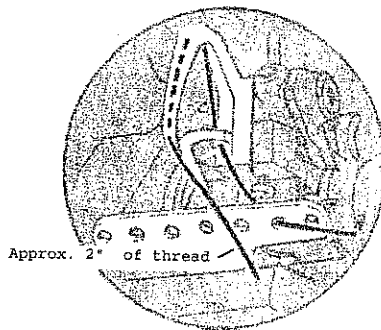
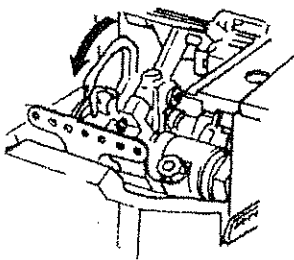
Using short bristled brush (not point of scissors), remove lint or other waste from around the loopers, from between the feed rows and underside of the throat plate and from other operating parts. Wipe the exterior of machine with a soft cloth.

From the library of: Diamond Needle Corp

# THREADING SEWING HEAD



## LOOPER THREADING



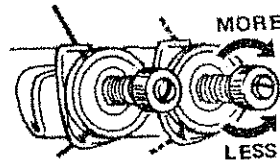
Open front table section, remove bed slide and turn machine pulley over toward operator until needle bar is at highest point.

# SEWING HEAD

## THREAD TENSION / STITCH LENGTH

### THREAD TENSIONS

#### NEEDLE Thread Tension

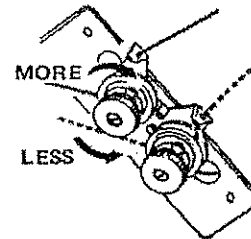


Regulate needle thread tension only when presser foot is down.

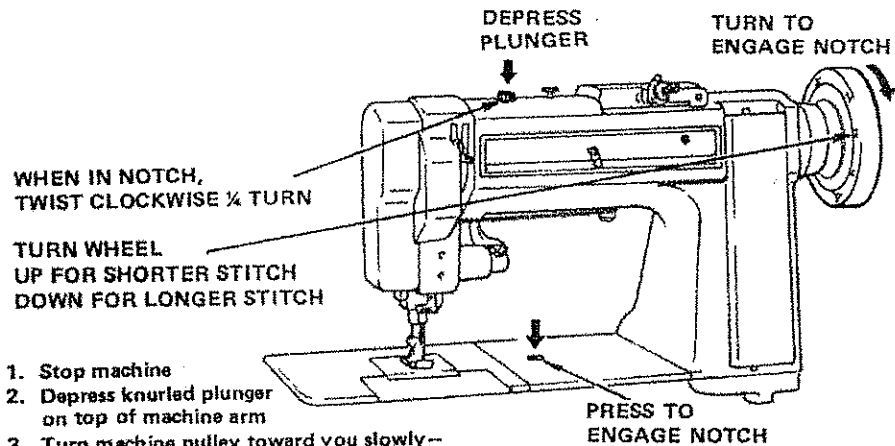
Tension on threads should be as light as possible while still sufficient to set stitch in material.

#### Looper Thread Tension

Open front cover plate to reach looper thread tension thumb screws.



### STITCH LENGTH REGULATION



1. Stop machine
  2. Depress knurled plunger on top of machine arm
  3. Turn machine pulley toward you slowly--
  4. until plunger drops into notch
  5. Twist knurled plunger clockwise  $\frac{1}{4}$  turn locking it in position
  6. Depress button in bed to engage notch
  7. Then turn machine pulley to desired stitch length and release button in bed and knurled plunger on top of arm by twisting it  $\frac{1}{4}$  counter-clockwise
- Never depress button or plunger while machine is running.  
Make certain both are disengaged before starting machine.

# ***UNITED MATTRESS MACHINERY***

## **STANDARD CONDITION OF SALE**

### **PARTS WARRANTY**

Mathewson Corporation, United Mattress Machinery Division (the SELLER), warrants all new parts to be free from defects in material or workmanship for 90 days from date of shipment. The obligation under the WARRANTY is limited to the replacement or repair, at the SELLER'S factory, of parts which shall appear to the SELLER, upon inspection, to have been so defective. This WARRANTY does not obligate the SELLER to bear the cost of labor or transportation charges in connection with the replacement or repair of defective parts. This WARRANTY shall not apply to any equipment which has been repaired or altered without the SELLER'S authorization, nor shall it apply to any equipment which has been subject to misuse, neglect or accident. With respect to any component or accessory purchased by the SELLER and incorporated into any equipment, the WARRANTY of the manufacturer thereof shall apply and no other. The SELLER shall in no event be liable for consequential damages or loss of prospective profits.

SELLER MAKES NO OTHER WARRANTY OF ANY KIND WHATEVER, EXPRESS OR IMPLIED; AND ALL WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE WHICH EXCEED THE ABOVE-MENTIONED OBLIGATION ARE DISCLAIMED BY SELLER AND EXCLUDED FROM THIS AGREEMENT.

Purchase Orders are accepted only when acknowledged in writing by the SELLER at Weymouth, Massachusetts, by its stated officers. No other employee, agent or salesman has authority to waive or vary and term of the order, to take oral orders or make any sales on any other terms. Any agreement made shall be governed by the laws of Massachusetts. Purchase Orders, after acceptance, are not cancelable except by mutual agreement.

The SELLER reserves the right to make changes in design or add improvements to equipment at any time, without incurring any obligation to install the same on equipment previously delivered.

### **DELIVERY**

Shipping dates are approximate and are subject to the prompt receipt of all necessary information.

The SELLER shall not be liable for delays in delivery or non-delivery, in whole or in part, due to causes beyond its reasonable control; due to acts of God, acts of the Purchaser, acts of civil or military authority, priorities, fires, strikes, floods, epidemics, war, riot, delays in transportation or car shortages, or inability due to causes beyond its reasonable control to obtain necessary labor, materials, components or manufacturing facilities. In the event of any such delay, the date of delivery shall be extended for a period equal to the time lost by reason of the delay.

## ***UNITED MATTRESS MACHINERY***

### **STANDARD CONDITION OF SALE**

#### **MACHINERY WARRANTY**

Mathewson Corporation, United Mattress Machinery Division (the SELLER), warrants all new equipment to be free from defects in material or workmanship for 120 days from date of installation. The obligation under the WARRANTY is limited to the replacement or repair, at the SELLER'S factory, of parts which shall appear to the SELLER, upon inspection, to have been so defective. This WARRANTY does not obligate the SELLER to bear the cost of labor or transportation charges in connection with the replacement or repair of defective parts. This WARRANTY shall not apply to any equipment which has been repaired or altered without the SELLER'S authorization, nor shall it apply to any equipment which has been subject to misuse, neglect or accident. With respect to any component or accessory purchased by the SELLER and incorporated into any equipment, the WARRANTY of the manufacturer thereof shall apply and no other. The SELLER shall in no event be liable for consequential damages or loss of prospective profits.

SELLER MAKES NO OTHER WARRANTY OF ANY KIND WHATEVER, EXPRESS OR IMPLIED; AND ALL WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE WHICH EXCEED THE ABOVE-MENTIONED OBLIGATION ARE DISCLAIMED BY SELLER AND EXCLUDED FROM THIS AGREEMENT.

Purchase Orders are accepted only when acknowledged in writing by the SELLER at Weymouth, Massachusetts, by its stated officers. No other employee, agent or salesman has authority to waive or vary and term of the order, to take oral orders or make any sales on any other terms. Any agreement made shall be governed by the laws of Massachusetts. Purchase Orders, after acceptance, are not cancelable except by mutual agreement.

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# UNITED MATTRESS MACHINERY

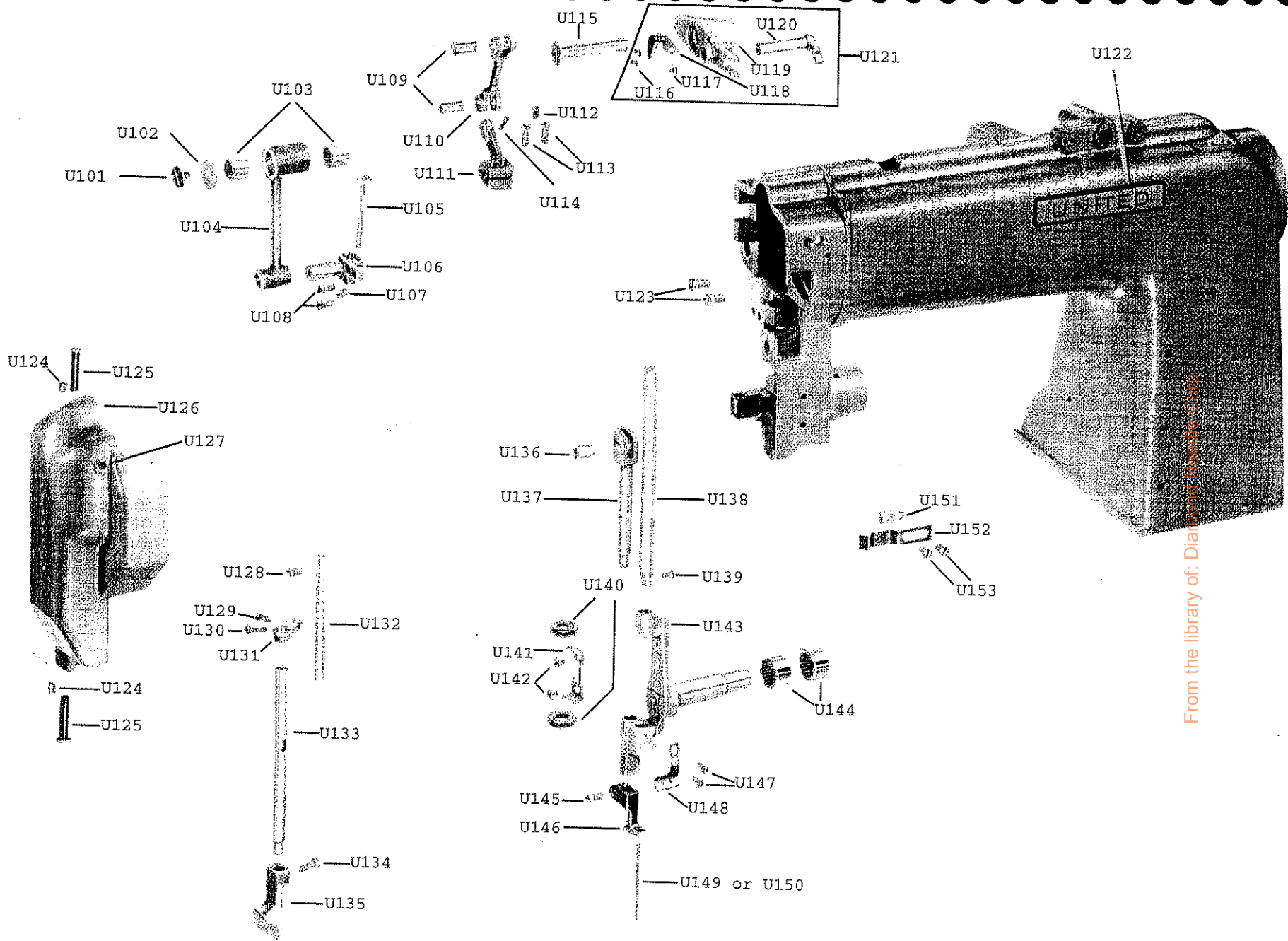
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UNITED MATTRESS MACHINERY

PLATE 1  
FRONT ASSEMBLY SEWING ARM  
(see over)





From the library of: Diablos Sewing Machine

FRONT ASSEMBLY SEWING ARM

**UNITED MATTRESS MACHINERY**

Tel: (781) 331-8440 Toll Free 1-800-245-7250

Fax: (781) 331-8870

E-mail: mathcorp1@aol.com

KEY.	PART NO.		DESCRIPTION.	KEY.	PART NO.		DESCRIPTION.
	300-U	300-W			300-U	300-W	
U101	S200095	SAME	NEEDLE BAR CONN. LINK SCREW	U118	S267718	SAME	PRESSER BAR BEARING RETAINER
U102	S268139	SAME	NEEDLE BAR CONN. LINK WASHER	U119	S415067	SAME	LIFTING LEVER
U103	S270266	SAME	BEARING FOR NR-439 (U104)	U120	S267631	SAME	PRESSER BAR LIFTING CRANK
U104	NR-439	SAME	NEEDLE BAR CONNECTING LINK	U121	S415333	SAME	PRESSER BAR CRANK - ASSY.
U105	S268512	SAME	THREAD GUIDE - NEEDLE BAR STUD	U122	NR-163	SAME	UNITED NAME PLATE
U106	NR-438	SAME	NEEDLE BAR CONNECTING STUD	U123	S350604	S201254	SCREW
U107	S414545	S201188	SCREW FOR THREAD GUIDE	U124	S545174-452	6601	SET SCREW
U108	S414511	S200069	SCREW	U125	S268330	SAME	STUD - FACE PLATE
U109	S267617	SAME	HINGE PIN - LIFTING ECCENTRIC	U126	NR411,411J	SAME	FACE PLATE DOOR - 411 USED UP TO SER
U110	S267627	SAME	LIFTING LEVER LINK STUD	U127	S268033	SAME	PRESSER BAR GUIDE BLOCK
U111	S415061	SAME	LIFTING CRANK	U128	S544301	S200351	BAR GUIDE ROD SET SCREW
U112	S141338	S200344	SCREW	U129	S414516	S200056	SCREW
U113	S414511	S200061	SCREW	U130	S414512	S200066	SCREW
U114	4784	SAME	SCREW	U131	S415059	SAME	PRESSER BAR GUIDE BLOCK
U115	S267626	SAME	LIFTING LEVER LINK STUD	U132	S267907	SAME	PRESSER BAR GUIDE ROD
U116	S414548	S201409	SCREW	U133	S267628	SAME	PRESSER BAR
U117	6576	SAME	BALL FOR U118 <i>276025 (Ball)</i>	U134	1653	SAME	SCREW
U135	NR-413	SAME	PRESSER FOOT				
U136	S267658	SAME	VIBRATING PRESSER BAR HINGE STUD				
U137	S267657	SAME	VIBRATING PRESSER BAR				

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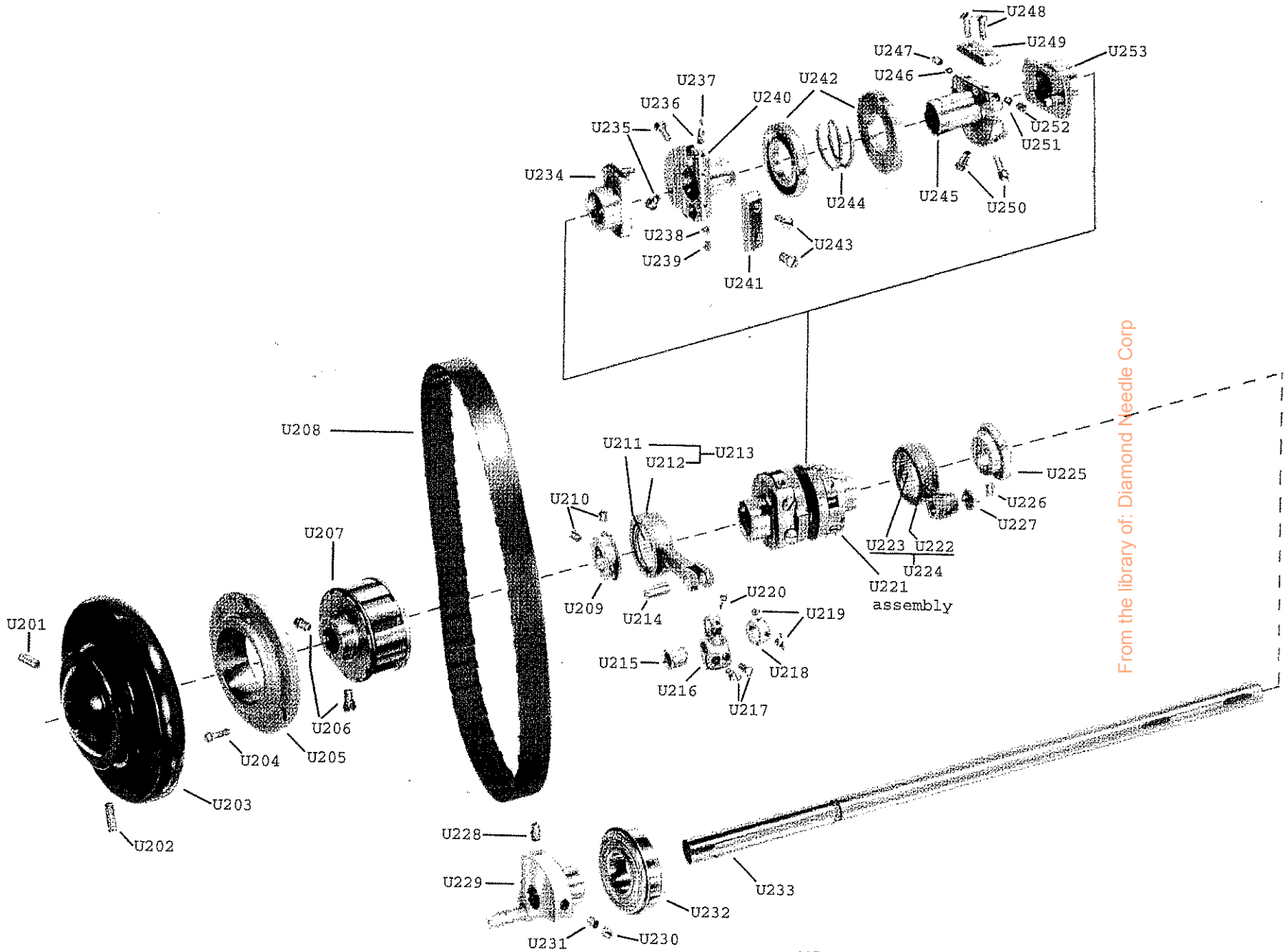
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KEY.	PART NO. 300-U	300-W	DESCRIPTION.	KEY.	PART NO. 300-U	300-W	DESCRIPTION.
U138	NR-482	SAME	NEEDLE BAR				
U139	S200125	SAME	SCREW - FOR NR-482 (U138)				
U140	S268144	SAME	NEEDLE BAR OILING FELT				
U141	S268278	SAME	NEEDLE BAR SEALING FELT HOLDER				
U142	S414522	S200173	NEEDLE BAR OILING FELT HOLDER SCREW				
U143	S415344	SAME	NEEDLE BAR ROCKER FRAME				
U144	S268029	SAME	NEEDLE BEARING				
U145	7333	SAME	LOCKING SCREW				
U146	NR-433 A	SAME	VIBRATING PRESSER FOOT				
U147	S414539	S200583	SCREW				
U148	S268219	SAME	ROCK FRAME THREAD GUIDE				
U149	NR-448	SAME	SMALL NEEDLE - FOR PLASTICS				
U150	NR-470	SAME	STANDARD NEEDLE				
U151	S415369	S268197	FACE PLATE LOCK SPRING PLATE				
U152	S268032	SAME	FACE PLATE LOCK SPRING				
U153	S414534	S200571	SCREW				

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PLATE 2  
UPPER SHAFT ASSEMBLY  
(see over)



UPPER SHAFT ASSEMBLY

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KEY.	PART NO.		DESCRIPTION.	KEY.	PART NO.		DESCRIPTION.
	300-U	300-W			300-U	300-W	
U201	S414525	S200347	BALANCE WHEEL LOCK SCREW	U221	S415075	SAME	TOP SHAFT ECCENTRIC ASSEMBLY
U202	S414526	S200342	BALANCE WHEEL POSITION SCREW	U222	S268060	SAME	CONNECTOR
U203	S415153	SAME	HAND WHEEL ASSEMBLY	U223	S415368	SAME	NEEDLE BEARING
U204	S544336	S20047	SCREW	U224	S268061	SAME	CONNECTOR ASSEMBLY
U205	S268004	SAME	ARM SHAFT BEARING HOUSING	U225	NR-641	SAME	LIFTING ECCENTRIC SPACING COLLAR
U206	S414546	S201254	SCREW	U226	S414529	6266	SCREW
U207	NR-491	SAME	ARM SHAFT TIMING PULLEY	U227	S545297	S200123	CAP SCREW
U208	NR-494	SAME	BELT - ARM SHAFT - TIMING ASSEMBLY	U228	S500272	S200346	SCREW
U209	NR-641	SAME	LIFTING ECCENTRIC SPACING COLLAR	U229	S415137	SAME	NEEDLE BAR CRANK
U210	S414529	6266	SCREW	U230	S544358	S200346	SCREW
U211	S415368	SAME	NEEDLE BEARING	U231	S549024	S201222	SCREW
U212	S268492	SAME	LIFTING ECCENRIC CONNECTION	U232	S32848	SAME	ARM SHAFT BALL BEARING
U213	S268493	SAME	LIFTING ECCENTRIC CONNECTION ASSY.	U233	S415128	SAME	ARM SHAFT ASSEMBLY
U214	S267617	SAME	LINK ECCENTRIC HINGE PIN	U234	S268064	SAME	LIFTING ECCENTRIC
U215	S267110	SAME	BEARING	U235	S414555	S350467	SCREW
U216	S415069	SAME	LIFING ECCENTRIC CRANK	U236	S241763	SAME	BRASS PACKING
U217	S414509	S200058	SCREW	U237	S414557	S350477	SET SCREW
U218	NR-429	SAME	COLLAR	U238	S241763	SAME	BRASS PACKING
U219	6526	SAME	SET SCREW	U239	S414557	S350477	SET SCREW
U220	S414543	S201063	SCREW	U240	S267639	SAME	LIFTING ECCENTRIC FLANGE

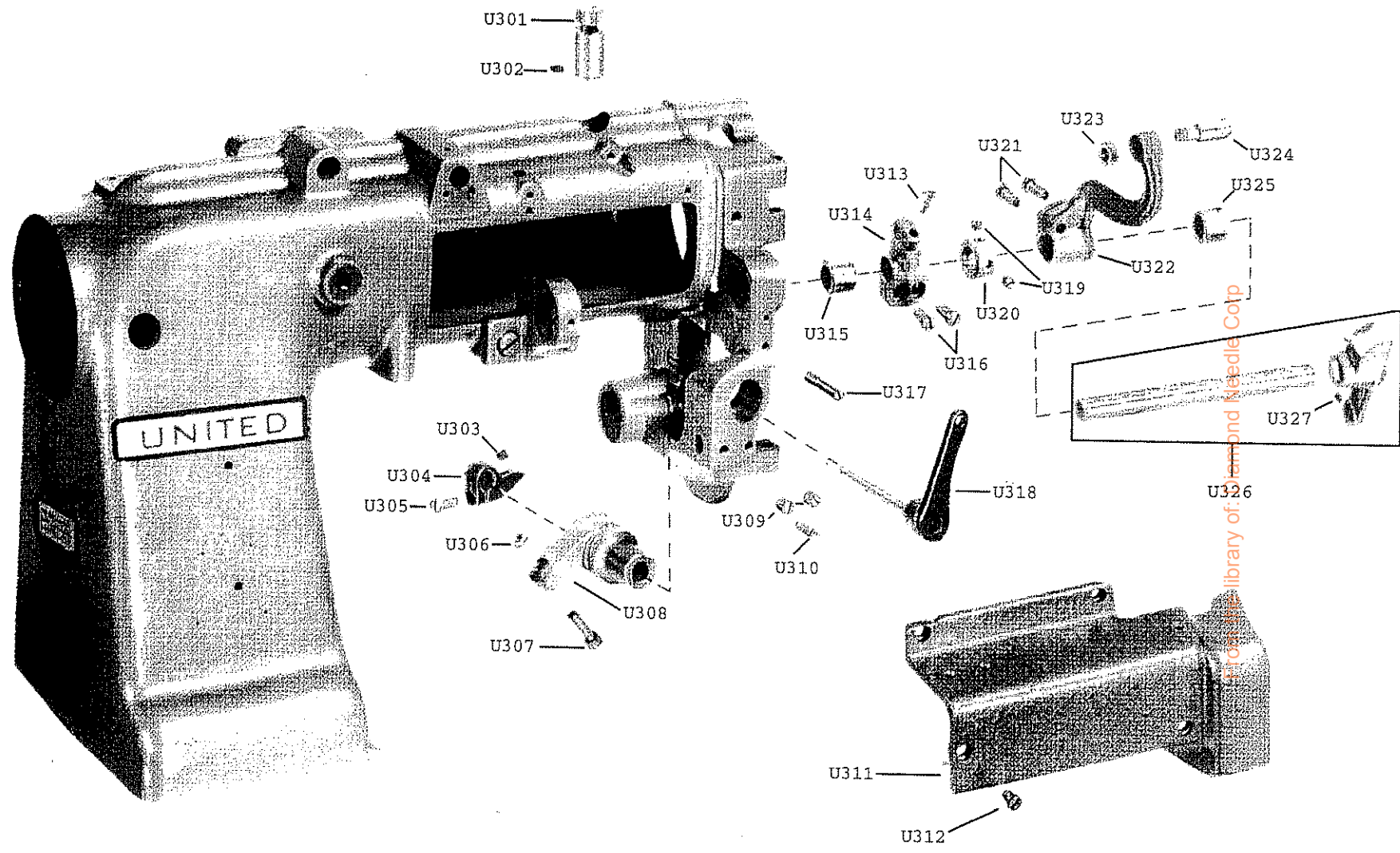
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PLATE 3  
EXTERNAL PARTS SEWING ARM  
(see over)





EXTERNAL PARTS SEWING ARM

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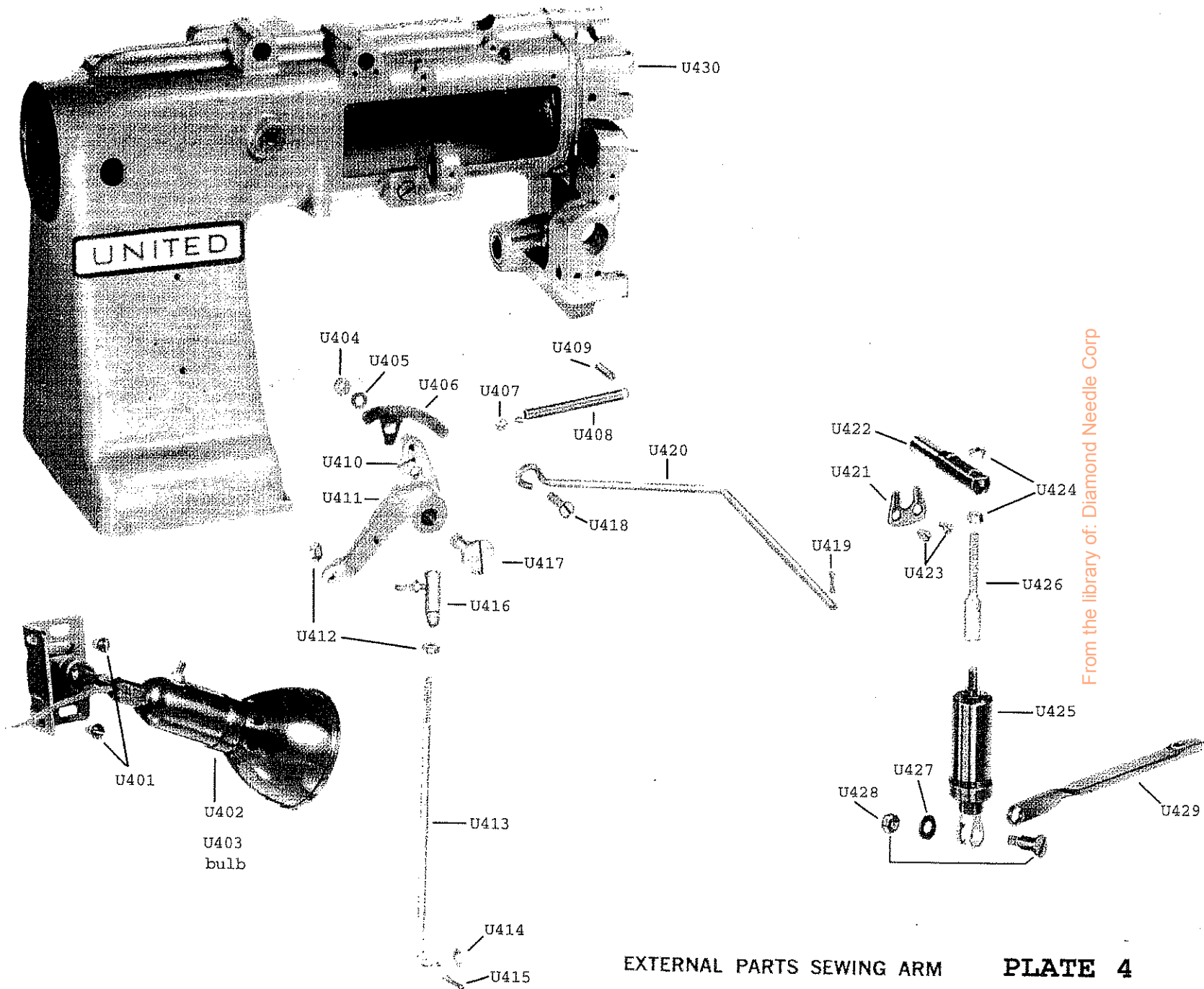
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**PLATE 3**

KEY.	PART NO.		DESCRIPTION.	KEY.	PART NO.		DESCRIPTION.
	300-U	300-W			300-U	300-W	
U301	S415098	SAME	ROCK FRAME REGULATING STUD	U321	NR-509	SAME	SCREW
U302	S414527	S200337	SCREW	U322	S415094	SAME	ROCK FRAME DRIVING ARM
U303	S545213	S200364	SCREW	U323	S541197	S201522	NUT
U304	S415122	SAME	FOOT LIFTER ARM	U324	S415092	S415373	HINGE STUD
U305	S414509	S200058	SCREW	U325	S267110	SAME	BEARING
U306	6360	SAME	NUT	U326	S32789	SAME	LIFTING ROCK SHAFT ASSEMBLY
U307	6219	SAME	SCREW	U327	S141124	4784	SCREW
U308	NR-502	SAME	SPRING ARM FULCRUM				
U309	S544322	S200362	SET SCREW				
U310	S414530	S200417	SCREW				
U311	NR-901 J	SAME	COVER				
U312	S545246	S200078	SCREW				
U313	S414543	S201063	SCREW				
U314	S415069	SAME	LIFTING ECCENTRIC CONNECTION CRANK				
U315	S267110	SAME	BEARING				
U316	S414509	S200058	SCREW				
U317	S414566	NR-534	SCREW STUD				
U318	S267612	SAME	FOOT LIFTER CRANK				
U319	6526	SAME	SET SCREW				
U320	NR-429	SAME	COLLAR				

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EXTERNAL PARTS SEWING ARM **PLATE 4**

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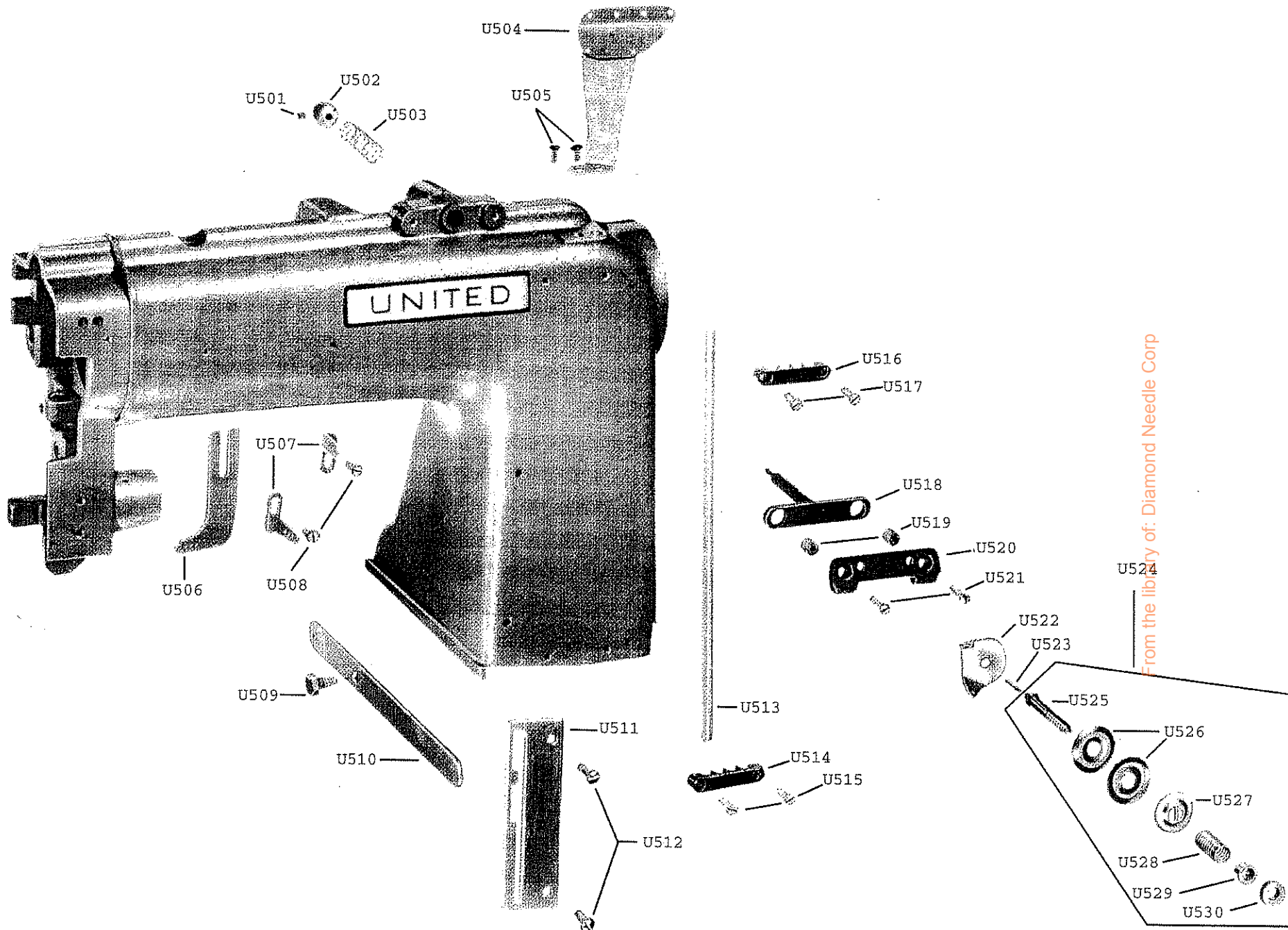
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**PLATE 4**

KEY.	PART NO. 300-U	300-W	DESCRIPTION.	KEY.	PART NO. 300-U	300-W	DESCRIPTION.
U401	749	SAME	SCREW	U421	S267650	SAME	SPRING HOUSING RETAINER
U402	NR907	NR907	LAMP ASSY. ( REPLACES ALL LAMP ASSY'S)	U422	NR-904	SAME	PRESSURE CYLINDER SUPPORT
U403	S3211	2084	S3211 SCREW TYPE / 2084 BAYONET TYPE	U423	S545205	S200098	HINGE SET SCREW
U404	S541166	S201526	NUT	U424	NR-199	SAME	NUT
U405	S543804-004	SAME	WASHER	U425	NR505/506 J	SAME	PISTON AND ADAPTER
U406	S267707	SAME	THREAD TENSION RELEASING PLATE	U426	NR-506 J	SAME	ADAPTER
U407	S414570	S201160	SCREW EYE	U427	105	SAME	WASHER
U408	S204348	SAME	SPRING	U428	S545405 & S414567	SAME	SCREW AND NUT ( MUST BE PURCHASED AS ONE UNIT)
U409	S544336	S200047	SCREW	U429	S267738	SAME	LEVER
U410	1075	SAME	ROLL PIN	U430	S415009	S267905	BELL CASTING
U411	NR-486	SAME	FOOT LIFTER LEVER				
U412	6360	SAME	NUT				
U413	NR-425	SAME	PRESSER FOOT LIFTING ROD				
U414	108	SAME	WASHER				
U415	127	SAME	COTTER PIN				
U416	1648	SAME	BALL JOINT				
U417	S201363	SAME	SCREW				
U418	S414577	S350524	SCREW				
U419	127	SAME	COTTER PIN				
U420	S267704	SAME	FOOT LIFTER LEVER ROD				

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EXTERNAL PARTS SEWING ARM

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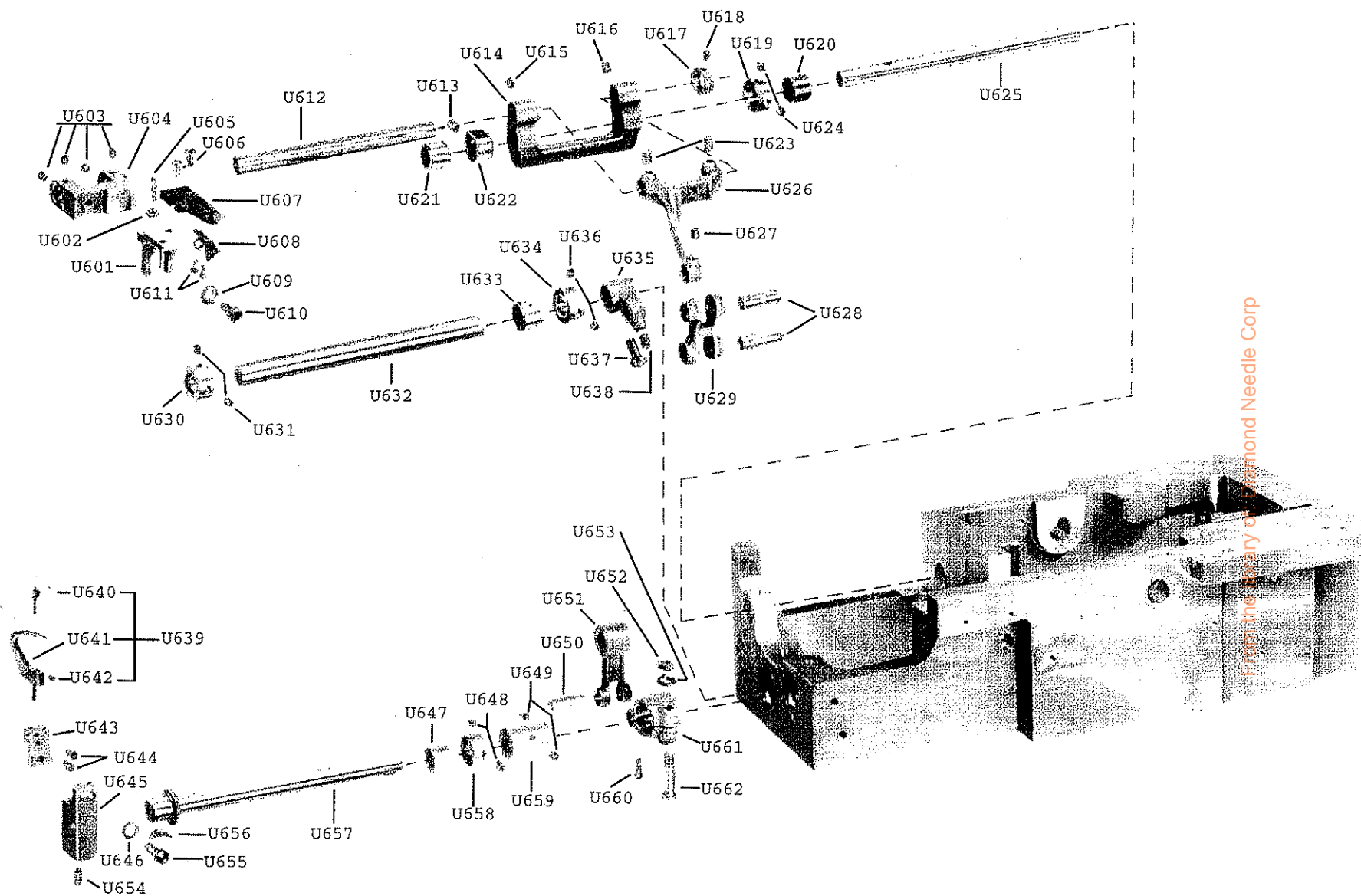
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PLATE 5

KEY.	PART NO.		DESCRIPTION.	KEY.	PART NO.		DESCRIPTION.
	300-U	300-W			300-U	300-W	
U501	S504048	S201052	CAP SCREW	U521	S544336	S200047	SCREW
U502	S415252	SAME	NEEDLE THREAD TENSION NUT	U522	S54279	SAME	DOUBLE THREAD GUIDE TENSIONER
U503	S204365	SAME	SPRING	U523	S226206	SAME	RELEASING PIN
U504	S268506	SAME	THREAD GUIDE	U524	S267971	SAME	COMPLETE TENSION ASSEMBLY
U505	S414537	S200578	SCREW	U525	S59539	SAME	STUD
U506	S268312	SAME	THREAD GUIDE	U526	S2102	SAME	FLANGE
U507	S268513	SAME	THREAD GUIDE	U527	S32572	SAME	FLANGE
U508	S414514	S200082	THREAD GUIDE SCREW	U528	S131741	SAME	THREAD TENSIONER SPRING
U509	NR-403	SAME	SCREW	U529	S143657	S59537	SPRING BUSHING
U510	NR-426	SAME	LIFTING LEVER	U530	S51570	SAME	NUT
U511	NR-427	SAME	LIFT LEVER LATCH PLATE				
U512	749	SAME	SCREW				
U513	S268123	SAME	LOOPER THREAD TUBE				
U514	S415342	S268124	LOOPER THREAD TUBE COVER				
U515	S414639	S200054	TUBE COVER SCREW				
U516	S415342	S268124	LOOPER THREAD TUBE COVER				
U517	S414639	S200054	TUBE COVER SCREW				
U518	S415357	S268168	THREAD TENSION RELEASE				
U519	S268121	SAME	SPRING COLLAR				
U520	S268167	SAME	NEEDLE THREAD TENSION BRACKET				

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FRONT ASSEMBLY SEWING BED

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**PLATE 6**

KEY.	PART NO. 300-U	300-W	DESCRIPTION.	KEY.	PART NO. 300-U	300-W	DESCRIPTION.
U601	NR-432	SAME	FEED DOG LIFTING SHANK	U621	S268071	SAME	BEARING
U602	S541200	S201537	NUT	U622	NR-443	SAME	COLLAR
U603	6526	SAME	SCREW	U623	NR-451	SAME	SET SCREW
U604	NR-423	SAME	FEED DOG ADAPTER	U624	6526	SAME	SCREW
U605	S414559	S350552	SCREW	U625	S268070	SAME	FEED DRIVING ROCK SHAFT
U606	S414518	S200100	FEED DOG SCREW	U626	NR-940	SAME	FEED BAR
U607	NR-421	SAME	FEED DOG	U627	S545213	S200373	SCREW
U608	S267665	SAME	LOOP DEFLECTOR	U628	S268079	SAME	LIFTING LINK HINGE PIN
U609	NR-452	SAME	WASHER	U629	S268078	SAME	FEED LIFTING LINK
U610	6243	SAME	SCREW	U630	NR-429	SAME	COLLAR
U611	6315	SAME	SCREW	U631	6526	SAME	SCREW
U612	NR-434 J	NR-434	FEED DOG LIFTING MOTION SHAFT	U632	S267933	SAME	FEED LIFTING ROCK SHAFT
U613	6526	SAME	SCREW	U633	S268071	SAME	BEARING
U614	NR-466	SAME	ROCKER FRAME	U634	NR-429	SAME	COLLAR
U615	S549024	S201222	SCREW	U635	S415204	SAME	FEED LIFTING CRANK
U616	S500264	S200362	SCREW	U636	6526	SAME	SCREW
U617	NR-468	SAME	HINGE PIN COLLAR	U637	S414501	S201256	SCREW
U618	S414529	S200380	SCREW	U638	S545213	S200373	SCREW
U619	NR-429	SAME	COLLAR	U639	S268382	SAME	LOOPER
U620	S268071	SAME	BEARING	U640	S268310	SAME	NEEDLE GUIDE

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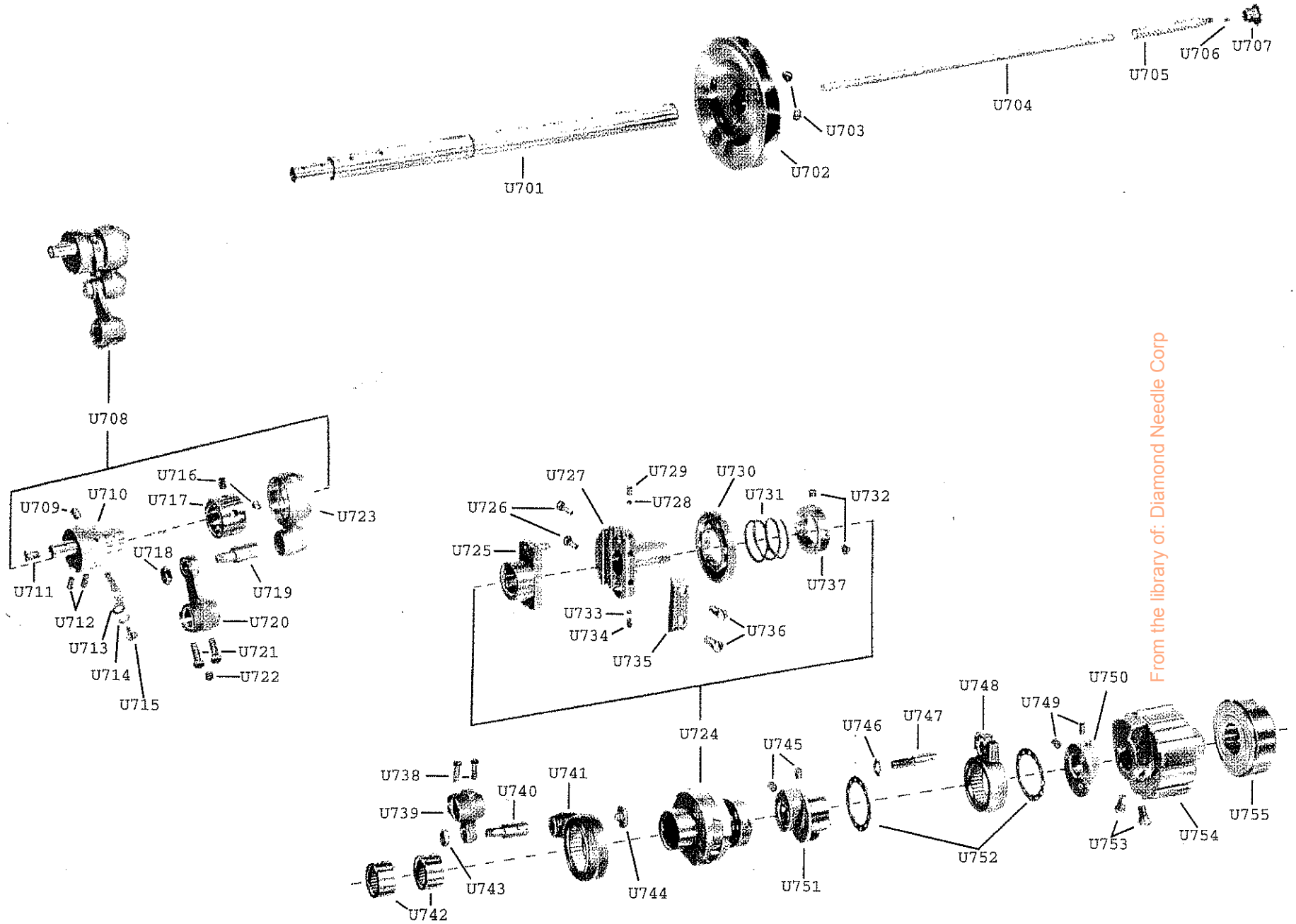
**PLATE 6**

KEY.	PART NO.		DESCRIPTION.	KEY.	PART NO.		DESCRIPTION.
	300-U	300-W			300-U	300-W	
U641	S268380	SAME	LOOPER (WITH SCREWS)	U661	S415174	SAME	LOOPER CARRIER CRANK
U642	S141494	SAME	SET SCREW	U662	S415292	S268308	CRANK CLAMPING STUD
U643	NR-440	SAME	LOOPER HOLDER				
U644	S414558	S350478	SCREW				
U645	NR-428	SAME	LOOPER CARRIER				
U646	S543804-004	SAME	WASHER				
U647	S268071	SAME	BEARING				
U648	6526	SAME	SCREW				
U649	6526	SAME	SCREW				
U650	S268208	SAME	LOOPER CARRIER CRANK HINGE PIN				
U651	S268216	SAME	LOOPER DRIVING CONNECTION ASSEMBLER				
U652	S541198	S201524	NUT				
U653	102	SAME	LOCK WASHER				
U654	6266	SAME	SCREW				
U655	S414553	S350267	LOOPER HOLDER SCREW				
U656	198	SAME	KEY				
U657	NR-419	SAME	LOOPER ROCKER SHAFT				
U658	NR-429	SAME	COLLAR				
U659	NR-418	SAME	ROCKER SHAFT BUSHING				
U660	S414516	S200089	SCREW				

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PLATE 7  
LOWER SHAFT ASSEMBLY  
(see over)



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LOWER SHAFT ASSEMBLY

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**PLATE 7**

KEY.	PART NO.		DESCRIPTION.	KEY.	PART NO.		DESCRIPTION.
	300-U	300-W			300-U	300-W	
U701	NR-405 J	SAME	SHAFT <i>(SERIAL #'S 1-3402 USE NR405)</i>	U721	S414511	S200061	SET SCREW
U702	NR-408	SAME	HEAD SHEAVE <i>(GROOVED PULLEY)</i>	U722	S414549	S201418 C	SCREW
U703	7221	SAME	SCREW	U723	S268074	SAME	FEED DRIVING CONNECTION
U704	S268265	SAME	BED SHAFT OIL CONTROL ROD <i>(WOOD)</i>	U724	S415072	SAME	ECCENTRIC
U705	S268044	SAME	ARM SHAFT OIL STOP BALL SPRING	U725	S268064	SAME	LIFTING ECCENTRIC
U706	1054	SAME	ARM SHAFT OIL STOP BALL	U726	S414555	S350467	SCREW
U707	S414578	SAME	BALL SCREW	U727	S415073	SAME	DRIVING FLANGE
U708	S415329	SAME	ASSEMBLY CRANK	U728	S241763	SAME	BRASS PACKING
U709	S500264	S200362	SCREW	U729	S414557	S350477	SET SCREW
U710	S415176	SAME	LOOPER DRIVING CRANK	U730	S268065	SAME	ADJUSTING FLANGE
U711	S414536	S200573	SCREW	U731	S268066	SAME	ADJUSTING FLANGE SPRING
U712	S374099	S200344	SCREW	U732	S544325	S200382	SCREW
U713	S268102	SAME	OIL HOLE COVER	U733	S241763	SAME	BRASS PACKING
U714	S204925	SAME	WASHER	U734	S414557	S3504771	SET SCREW
U715	S414563	S200303	OIL HOLE COVER SCREW	U735	S267623	SAME	GIB
U716	S544208-005	S200394	SET SCREW	U736	S374098	S350548	SCREW
U717	S415210	SAME	FEED LIFTING ECCENTRIC	U737	S412011	SAME	SPRING COLLAR
U718	S541197	S201522	NUT	U738	S414511	S200061	SET SCREW
U719	S415092	S415373	HINGE STUD	U739	S415213	SAME	ROCK SHAFT CRANK
U720	S415206	SAME	CRANK	U740	S415092	S415373	HINGE STUD

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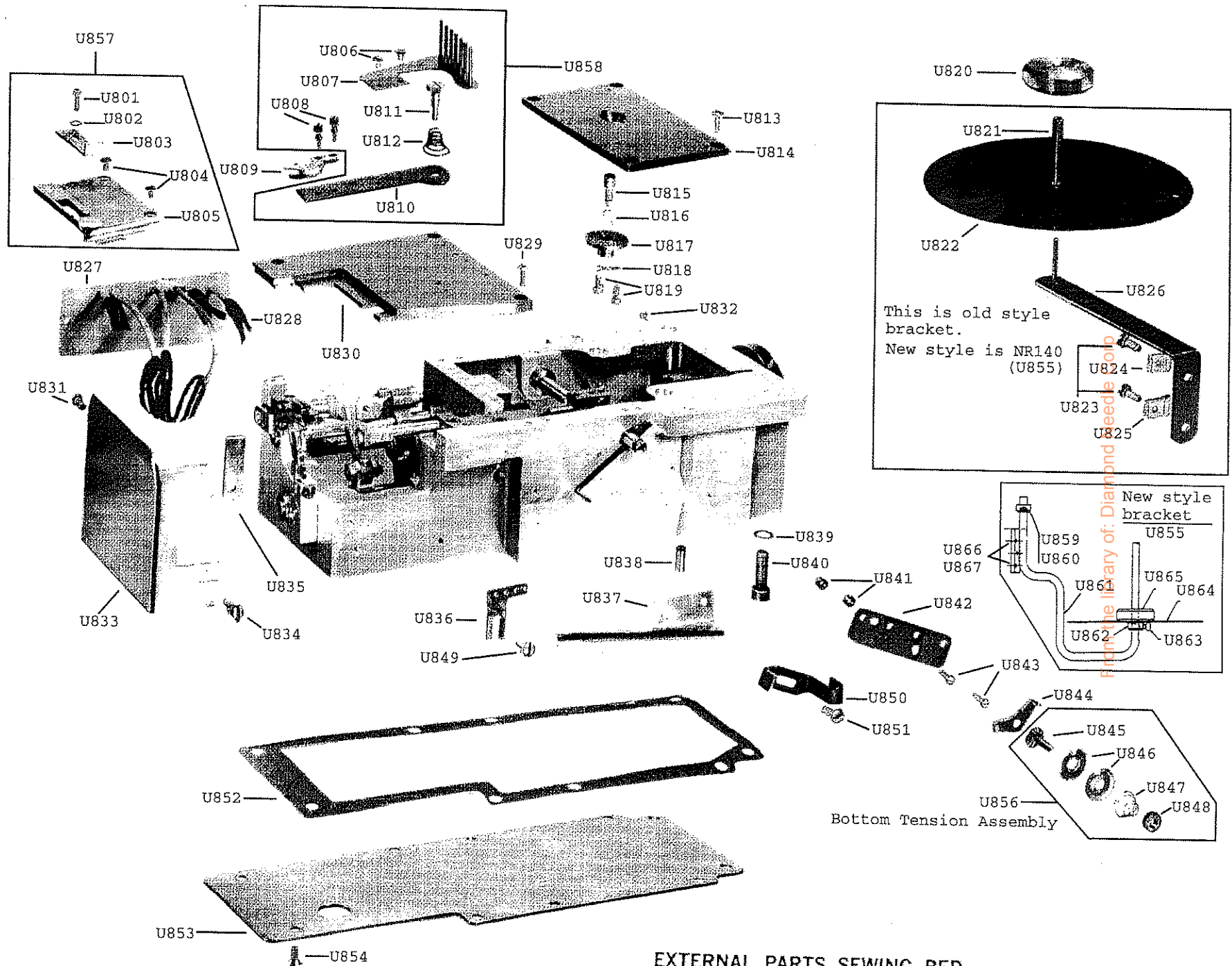
PLATE

KEY.	PART NO.		DESCRIPTION.	KEY.	PART NO.		DESCRIPTION.
	300-U	300-W			300-U	300-W	
U741	S268061	SAME	PULLER FEED DRIVING CONNECTION				
U742	S3826	OR S268029	NEEDLE BEARING- UP TO SERIAL NO. NRS-3409 USE S268029, ABOVE SER. NO. NRS-3409 USE S3826				
U743	S541197	S201522	NUT				
U744	S545297	S200123	SCREW				
U745	S414528	S200364	SCREW				
U746	S545424	S201736	NUT				
U747	S414575	S350466	STUD				
U748	S415183	SAME	SPREADER DRIVING CONNECTION				
U749	S414528	S200064	SCREW				
U750	S415190	SAME	COUNTER BALANCE				
U751	S415187	SAME	SPREADER DRIVING ECCENTRIC				
U752	S268220	SAME	THRUST WASHER				
U753	S414546	S201254	SCREW				
U754	NR-447	SAME	BELT PULLEY				
U755	NR-481	SAME	BEARING				

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PLATE 8  
EXTERNAL PARTS SEWING BED  
(see over)



EXTERNAL PARTS SEWING BED

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**PLATE 8**

KEY.	PART NO.		DESCRIPTION.	KEY.	PART NO.		DESCRIPTION.
	300-U	300-W			300-U	300-W	
U801	6645	SAME	SCREW	U821	NR-156	NR-156	EXTENSION (OLD STYLE)
U802	107	SAME	WASHER	U822	NR-834	NR-834	TAPE REEL DISC (OLD STYLE)
U803	NR-485	SAME	BINDER SWING PLATE STOP	U823	467	467	SCREW (OLD SYLE)
U804	NR-501	SAME	SCREW	U824	7508	7508	CLIP (OLD STYLE)
U805	NR-424	SAME	THROAT PLATE	U825	1311	1311	CLIP (OLD STYLE)
U806	7234	SAME	SCREW	U826	N-741	N-741	TAPE REEL BRACKET (OLD STYLE)
U807	NR-177	SAME	GUIDE	U827	NR-409 J	NR-409	OILER PLATE
U808	S200507	SAME	SCREW	U828		NR-431	OIL WICK ASSEMBLY
U809	S259552	SAME	BINDER (SEE NEXT PAGE)	U829	NR-499	SAME	COVER SCREW
U810	NR-496	SAME	SWING PLATE ONLY	U830	NR-402	SAME	THREAD GUIDE
U811	NR-417	SAME	BINDER PIVOT STUD	U831	NR-499	SAME	COVER SCREW
U812	S167229	SAME	SPRING	U832	NR-430	SAME	THREAD GUIDE
U813	NR-499	SAME	COVER SCREW	U833	NR-414	SAME	SIDE COVER
U814	NR-407	SAME	BED PLATE (RIGHT)	U834	1655	SAME	THUMB SCREW
U815	S268081	SAME	FEED REGULATING STUD	U835	NR-441	SAME	SIDE COVER SPACER
U816	S270026	SAME	FEED REGULATING STUD SOCKET	U836	S268373	SAME	THREAD GUIDE
U817	S268082	SAME	FEED REGULATING STUD SOCKET	U837	NR-415	SAME	THREAD GUARD
U818	S240245	SAME	COTTER PIN	U838	7199	SAME	DOWEL PIN
U819	760	SAME	MACHINE SCREW	U839	S543804-007	SAME	WASHER
U820	NR-100	SAME	TAPE WEIGHT	U840	S415361	S2000064	SCREW

From the library of Diamond Needle Corp



**UNITED MATTRESS MACHINERY**

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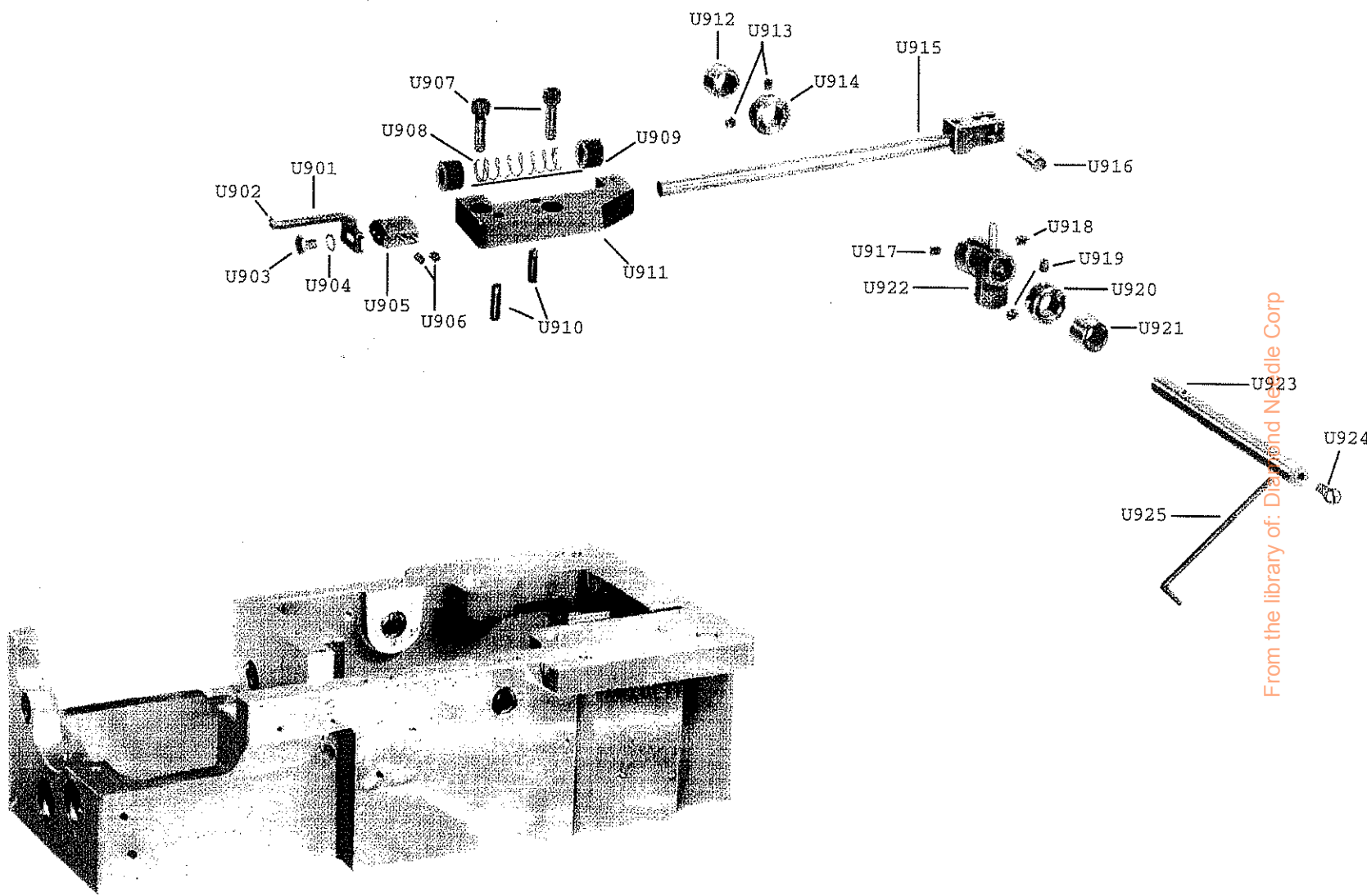
**PLATE**

KEY.	PART NO. 300-U	300-W	DESCRIPTION.	KEY.	PART NO. 300-U	300-W	DESCRIPTION.
U841	S268121	SAME	THREAD TENSION SPRING COLLAR	U855	NR-140	SAME	TAPE REEL BRACKET ASSEMBLY
U842	S415255	S268331	PLATE	U856	S415294	S268332	TENSION ASSEMBLY
U843	416	SAME	SCREW	U857	NR-488	SAME	THROAT PLATE ASSEMBLY
U844	S268333	SAME	FRAME GUIDE	U858	NR-850	SAME	SWING PLATE ASSEMBLY
U845	S141432	SAME	SCREW	U859	1004	SAME	COLLAR
U846	S244048	SAME	FLANGE DISC	U860	6532	SAME	THUMB SCREW
U847	S10148	SAME	SPRING	U861	NR-144	SAME	TAPE REEL BRACKET (NR-144-01 FOR V.S.)
U848	S541452	S201572	NUT	U862	1004	SAME	COLLAR
U849	2306	SAME	SCREW	U863	6532	SAME	THUMB SCREW
U850	S268051	SAME	LOOPER THREAD GUIDE	U864	NR-143	SAME	TAPE REEL DISC (NEW STYLE)
U851	2306	SAME	SCREW	U865	NR-100	SAME	TAPE WEIGHT
U852	NR-416	SAME	GASKET	U866	6519	SAME	BOLT
U853	NR-410	SAME	COVER PLATE	U867	102	SAME	LOCKWASHER
U854	446	SAME	SCREW	THE FOLLOWING BINDERS USE NR-850 SWINGPLATES			
THE FOLLOWING BINDERS USE NR-465A JUMBO SWING PLATE					S2595520-040	5/8", 16MM	BINDER
	NR-520	1", 25MM			S259552-11/16	11/16", 17MM	BINDER
	NR-511	1-1/8", 29MM			S259552-3/4	3/4", 19MM	BINDER
	NR-514	1-1/4", 32MM			S259552-056	7/8", 22MM	BINDER
	NR-450 A	1-1/2", 40MM					

From the library of Diamond Needle Corp

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PLATE 9  
CROSS SHAFT IN SEWING BED  
(see over)



From the library of: Ditz and Needle Corp

CROSS SHAFT IN SEWING BED

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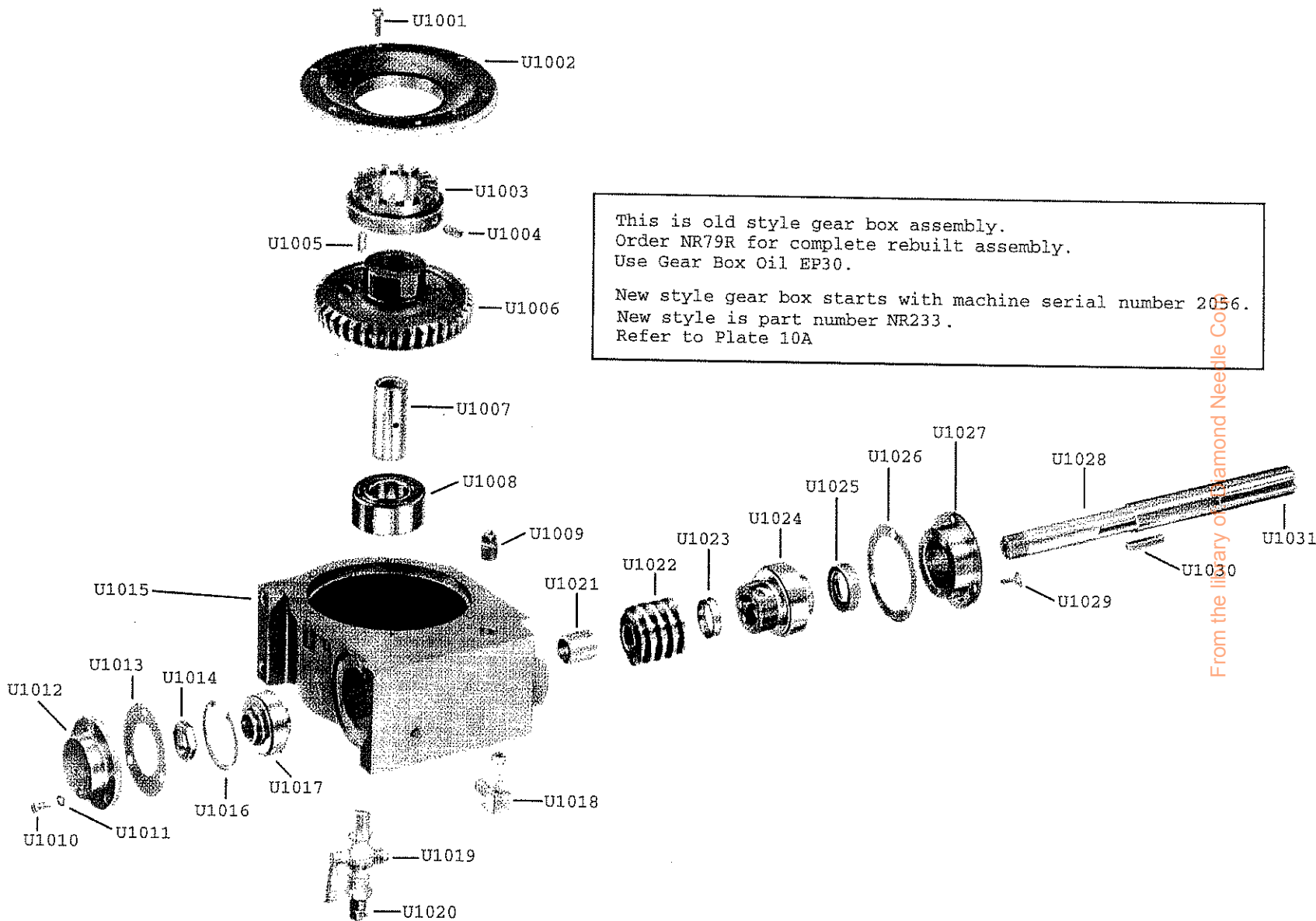
Fax: (781) 331-8870

E-mail: mathcorp1@aol.com

**PLATE**

KEY.	PART NO.		DESCRIPTION.	KEY.	PART NO.		DESCRIPTION.
	300-U	300-W			300-U	300-W	
U901	NR-469	SAME	SPREADER	U921	S268071	SAME	BEARING
U902	S268162	SAME	SPREADER POINT	U922	S415194	S267967	SPREADER DRIVING CRANK
U903	S414552	S350149	SCREW	U923	S415389	SAME	ROCK SHAFT
U904	S547670	SAME	WASHER	U924	S504019	S2000064	SCREW
U905	S415196	SAME	SPREADER BAR HOLDER	U925	S268052	SAME	LOOPER THREAD TAKE-UP ROD
U906	S414529	S200380	SCREW				
U907	6205	SAME	SCREW				
U908	NR-446	SAME	SPRING				
U909	NR-445	SAME	FELT WASHER / OILER				
U910	6731	SAME	DOWEL				
U911	NR-444	SAME	BEARING - SPREADER BAR				
U912	S268071	SAME	BEARING				
U913	6526	SAME	SCREW				
U914	NR-429	SAME	COLLAR				
U915	NR-420	SAME	SPREADER BAR				
U916	S268190	SAME	SPREADER DRIVING PIN				
U917	S544204-001	S200364	SET SCREW				
U918	S544204-001	S200403	SET SCREW				
U919	6526	SAME	SCREW				
U920	NR-429	SAME	COLLAR				

From the library of Diamond Needle Corp



This is old style gear box assembly.  
 Order NR79R for complete rebuilt assembly.  
 Use Gear Box Oil EP30.

New style gear box starts with machine serial number 2056.  
 New style is part number NR233.  
 Refer to Plate 10A

From the library of the Diamond Needle Co.

OLD STYLE  
 GEAR BOX ASSEMBLY

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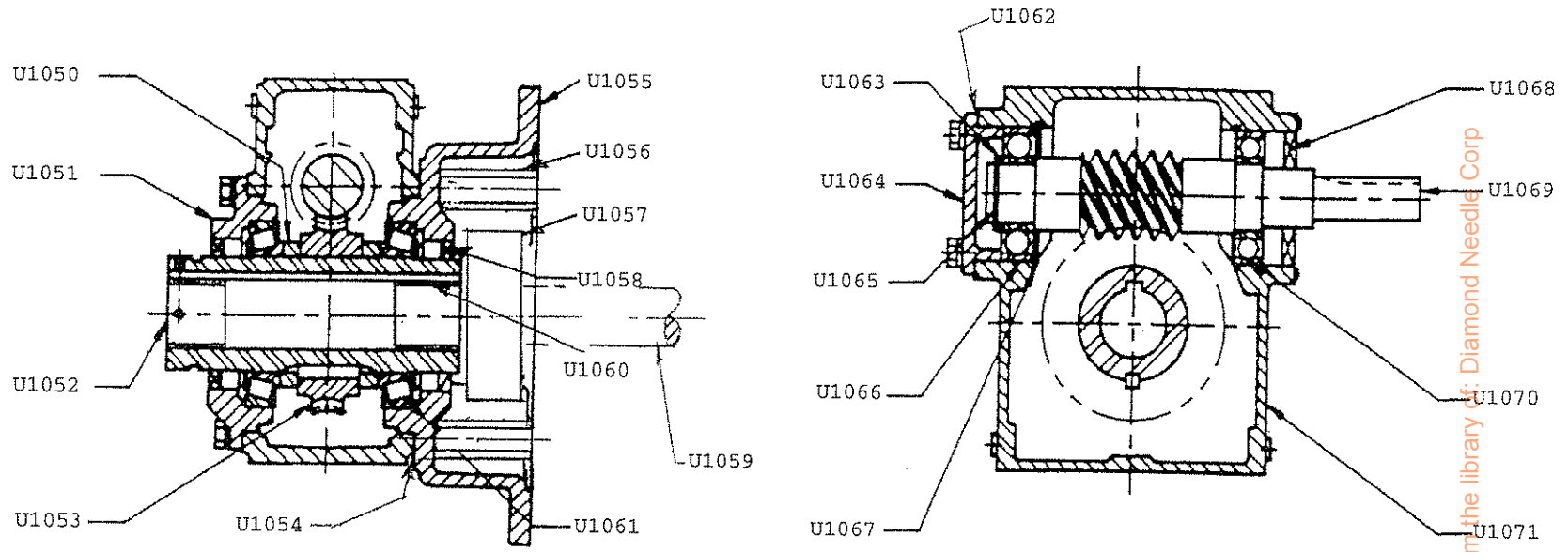
Fax: (781) 331-8870

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KEY.	PART NO.	DESCRIPTION.	KEY.	PART NO.	DESCRIPTION.
U1001	751	SCREW	U1021	NR-181	SLEEVE (USE NR-165 PRIOR TO SER. NO. 1967)
U1002	NR-18	GEAR BOX COVER PLATE	U1022	NR-9	WORM DRIVE SHAFT
U1003	NR-5	CLUTCH RING	U1023	NR-180	SLEEVE (USE NR-166 PRIOR TO SER. NO. 1967)
U1004	7220	SCREW	U1024	S3143	BEARING
U1005	16561	KEY	U1025	2989	OIL SEAL
U1006	NR-24	WORM GEAR	U1026	NR-183	SHIM
U1007	NR-23	WORM GEAR BUSHING	U1027	NR-182	GEARBOX COVER
U1008	S2692	BEARING	U1028	NR-4	VERTICAL DRIVE SHAFT
U1009	NR-75	PIPE PLUG - VENTED	U1029	525	SCREW
U1010	138	SCREW	U1030	NR-125	KEY
U1011	648	LOCKWASHER	U1031	14462	KEY (NOT SHOWN)
U1012	NR-70	END CAP			
U1013	NR-71	GASKET			
U1014	5997	JAM NUT			
U1015	NR-3	GEAR BOX HOUSING			
U1016	1542	RETAINING RING			
U1017	3177	BEARING			
U1018	1318	OIL GUAGE			
U1019	7032	OIL PLUG			
U1020	7032	OIL PLUG (REPLACES 428)			

From the library of Diamond Needle Corp

This is new style gear box assembly.  
 New style gear box starts with machine serial number 2056.  
 Order part number NR233 for complete assembly  
 Refer to Plate 10 for old style gear box.



From the library of: Diamond Needle Corp

NEW STYLE GEAR BOX ASSEMBLY

PLATE 10A

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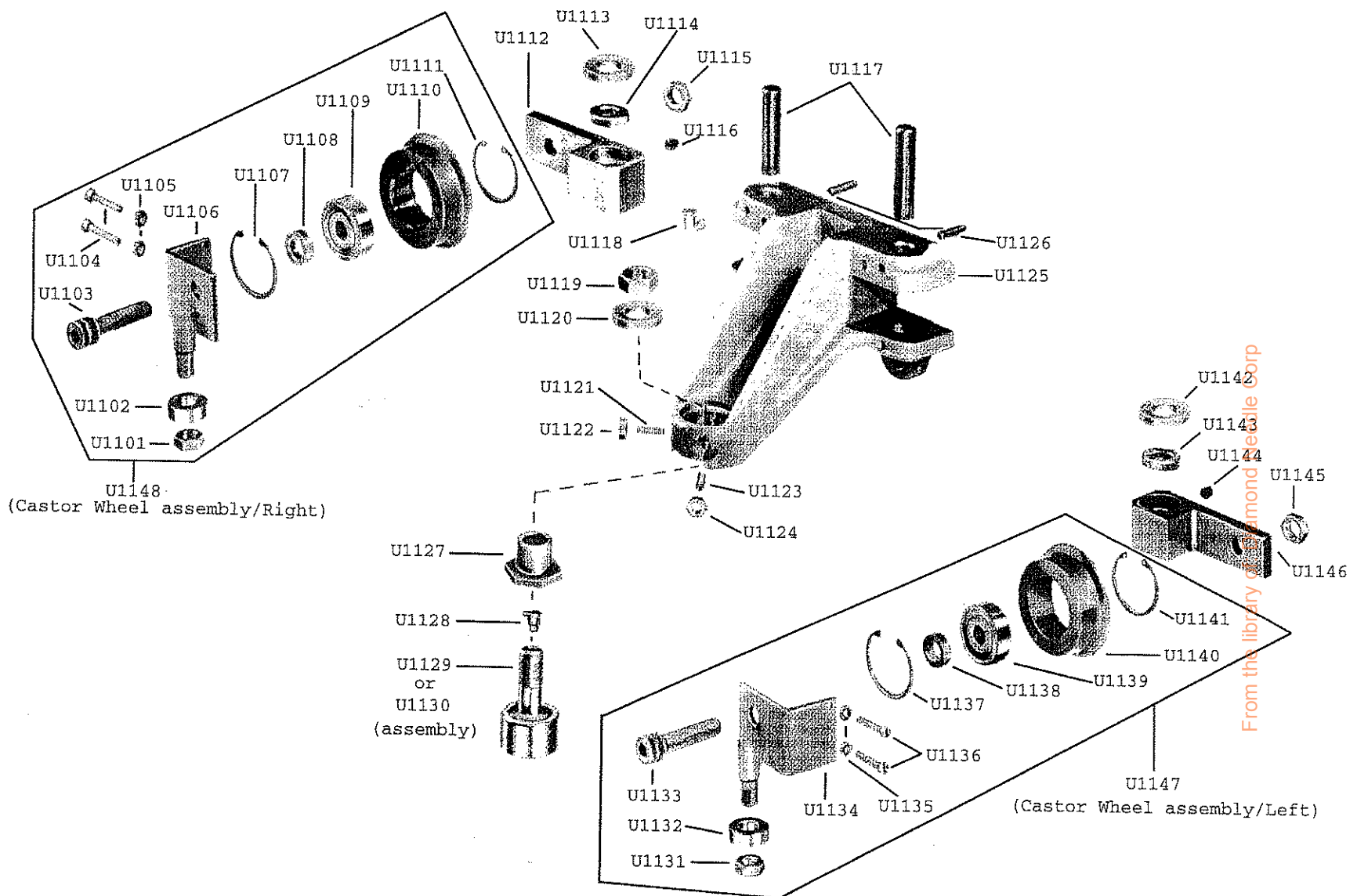
Fax: (781) 331-8870

E-mail: mathcorp1@aol.com

KEY.	PART NO.	DESCRIPTION.	KEY.	PART NO.	DESCRIPTION.
U1050	S3797	GEAR SPACER	U1070	S3800	BEARING
U1051	S3792	COVER	U1071	S3791	HOUSING
U1052	S3794	DRIVEN SHAFT		* ORDER PART NO. NR-233 FOR COMPLETE *	
U1053	S3796	WORM GEAR		GEARBOX ASSEMBLY	
U1054	S3549	SHIM / GASKET SET			
U1055	NR-219	FLANGE			
U1056	NR-218	MOUNTING BRACKET POST			
U1057	NR-215	CLUTCH RING			
U1058	S3795	SEAL			
U1059	NR-114	SHAFT			
U1060	6353	BUSHING			
U1061	S3798	BEARING			
U1062	S3549	SHIM / GASKET SET			
U1063	S3803	WORM SPACER			
U1064	S3793	BEARING CAP			
U1065	S3804	WORM RETAINING RING			
U1066	S3801	BEARING			
U1067	S3802	RETAINING RING			
U1068	S3805	OIL SEAL			
U1069	S3799	WORM SHAFT			

From the library of: Diamond Needle Corp





CASTOR ASSEMBLY

**UNITED MATTRESS MACHINERY**

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E-mail: mathcorp1@aol.com

KEY.	PART NO.	DESCRIPTION.	KEY.	PART NO.	DESCRIPTION.
U1101	6287	JAM NUT	U1121	7100	SET SCREW
U1102	7485	BEARING	U1122	6139	NUT
U1103	1911	SCREW	U1123	7100	SET SCREW
U1104	199	SCREW	U1124	6139	NUT
U1105	6360	NUT	U1125	NR-27	CENTER PIVOT BRACKET
U1106	NR-66	BRACKET - RIGHT GUIDE ROLLER	U1126	7177	ROLL PIN
U1107	1542	RETAINING RING	U1127	NR-32	SLEEVE
U1108	NR-68	SPACER	U1128	7283	OILER
U1109	2036	BEARING	U1129	S3178	CAM FOLLOWER (BEFORE SER. NO. 1666 USE 8668)
U1110	NR-65	ROLLER	U1130	NR-30	CAM FOLLOWER (INCL. S3178,7283, NR-32,NR-33,24)
U1111	1542	RETAINING RING	U1131	6287	JAM NUT
U1112	NR-848	CASTER ARM - RIGHT	U1132	7485	BEARING
U1113	S3655	HARDENED WASHER	U1133	1911	SCREW
U1114	1854	BEARING	U1134	NR-67	BRACKET - LEFT GUIDE ROLLER
U1115	6287	JAM NUT	U1135	6360	NUT
U1116	7172	SET SCREW	U1136	199	SCREW
U1117	NR-157	HINGE PIN	U1137	1542	RETAINING RING
U1118	1367	OIL CUP	U1138	NR-68	SPACER
U1119	24	HEX NUT	U1139	2036	BEARING
U1120	NR-33	WASHER	U1140	NR-65	ROLLER

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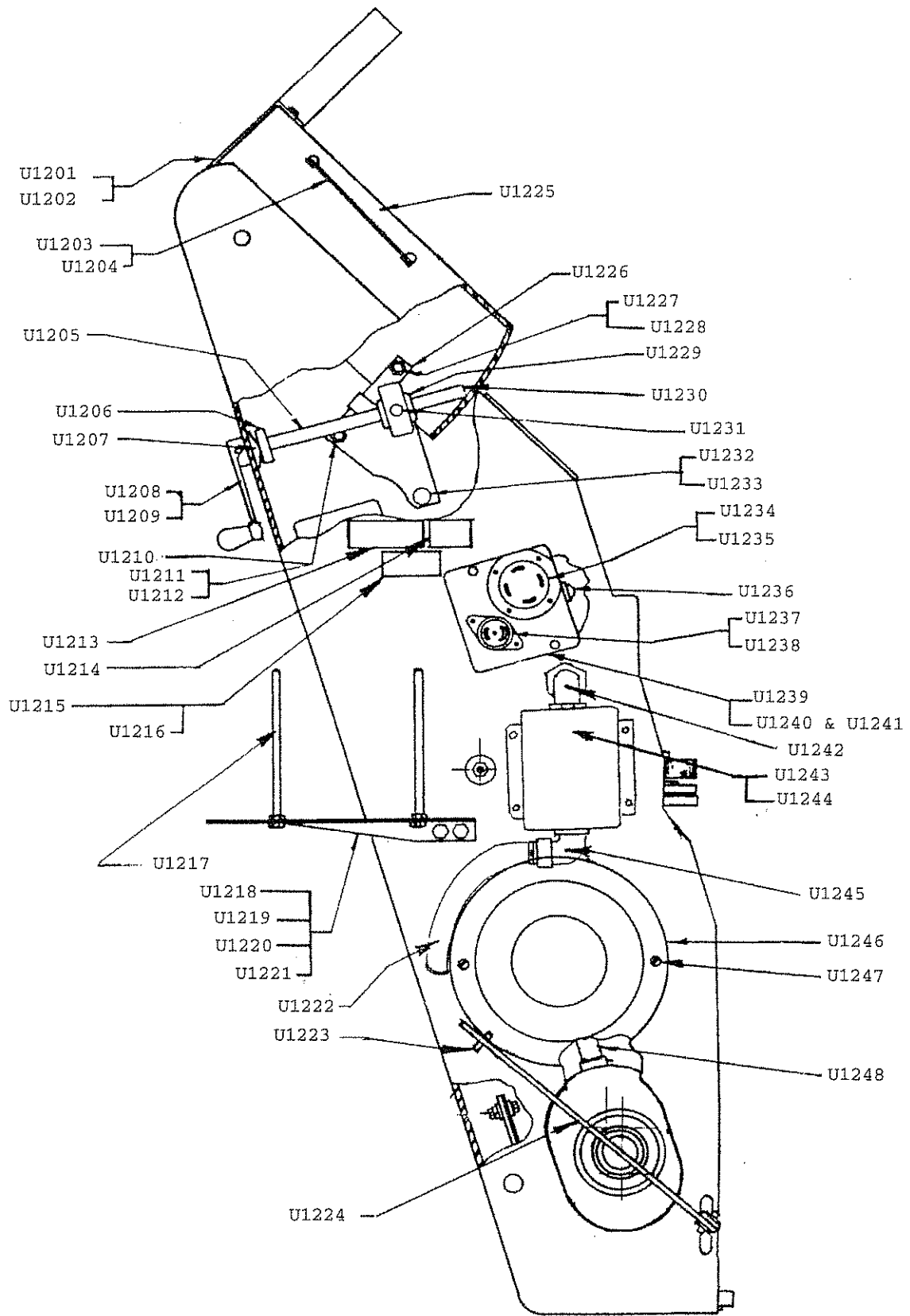
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KEY.	PART NO.	DESCRIPTION.	KEY.	PART NO.	DESCRIPTION.
U1141	1542	RETAINING RING			
U1142	S3655	HARDENED WASHER			
U1143	1854	BEARING			
U1144	7172	SET SCREW			
U1145	6287	JAM NUT			
U1146	NR-849	CASTER ARM - LEFT			
U1147	NR-69 L	CASTER WHEEL ASSEMBLY - LEFT			
U1148	NR-69 R	CASTER WHEEL ASSEMBLY - RIGHT			

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UNITED MATTRESS MACHINERY

PLATE 12  
MAIN DRIVE ASSEMBLY  
(see over)



MAIN DRIVE ASSEMBLY

**UNITED MATTRESS MACHINERY**

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KEY.	MACHINE NO. 2123 AND AFTER	MACHINE NO. 2122 AND BEFORE	DESCRIPTION.
U1201	NR-109	SAME	COVER - HEAD DRIVE PULLEY
U1202	494	SAME	MACHINE SCREW
U1203	NR-484	SAME	THREAD GUIDE
U1204	66	SAME	ROUND HEAD SCREW
U1205	NR-38 A	SAME	HEAD TILT SCREW SHAFT
U1206	D-6	SAME	THRUST BEARING
U1207	NR-45	SAME	HEAD TILT PAD
U1208	NR-42 A	SAME	CRANK
U1209	7368	SAME	SET SCREW
U1210	NR-40	SAME	HEAD TILT ARM
U1211	1637	SAME	SOCKET CAP SCREW
U1212	5887	SAME	JAM NUT
U1213	NR-803	SAME	NAMEPLATE (SERIAL NUMBER)
U1214	NR-804	SAME	VOLTAGE PLATE
U1215	BM-187	SAME	CAUTION PLATE
U1216	5763	SAME	DRIVE PIN
U1217	BM-430	SAME	THREAD SPOOL HOLDER ROD
U1218	NR-106	SAME	THREAD SPOOL HOLDER BRACKET
U1219	177	SAME	SCREW
U1220	102	SAME	LOCK WASHER
U1221	174	SAME	NUT
U1222	NR-245	SEE RIGHT	WIRING HARNESS ( NOT USED PRIOR TO SER. NO. 2095)
U1223	7253	SEE RIGHT	ROLL PIN *USE THE FOLLOWING PRIOR TO SER. NO.#880 *
U1224	NR-171	SEE RIGHT	CLUTCH ARM * #229 SCREW, #5887 NUT, NR-53 CLUTCH ARM *
U1225	NR-34	SAME	SEWING HEAD TILT BASE
U1226	NR-41	SAME	TILT LINK
U1227	1638	SAME	SCREW
U1228	5887	SAME	JAM NUT
U1229	NR-39 A	SEE RIGHT	TILT NUT * USE NR-39 ON MACH. PRIOR TO SER. NO. 444 *
U1230	129	SEE RIGHT	COTTER PIN * USE #172 SCREW ON MACH. PRIOR TO SER.NO. 444 *

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KEY.	MACHINE NO. 2123 AND AFTER	MACHINE NO. 2122 AND BEFORE	DESCRIPTION.
U1231	1645	SAME	DOWEL
U1232	6493	SAME	SCREW
U1233	119	SAME	WASHER
U1234	S3541	NR-701	FLANGED INLET
U1235	522	SAME	SCREW
U1236	S3085	7024	SEALTITE
U1237	1309	SAME	FEMALE CONNECTOR
U1238	980	522	SCREW
U1239	NR-133	SAME	RECEPTACLE COVER PLATE
U1240	527	214	SCREW
U1241	6177	SAME	WASHER
U1242	S3085	SAME	SEALTITE
U1243	S3231	SAME	ENCLOSURE
U1244	S1480	364	SCREW
U1245	S3085	SAME	SEALTITE
U1246	NR-105	SAME	SIDE COVER
U1247	500	SEE RIGHT	SCREW (SER.NO. 2055 & BELOW USE #5744 SCREW, 116 W, 282 NUT)
U1248	NR-242	SEE RIGHT	WIRING HARNESS (NOT USED PRIOR TO SER. NO. 2095)

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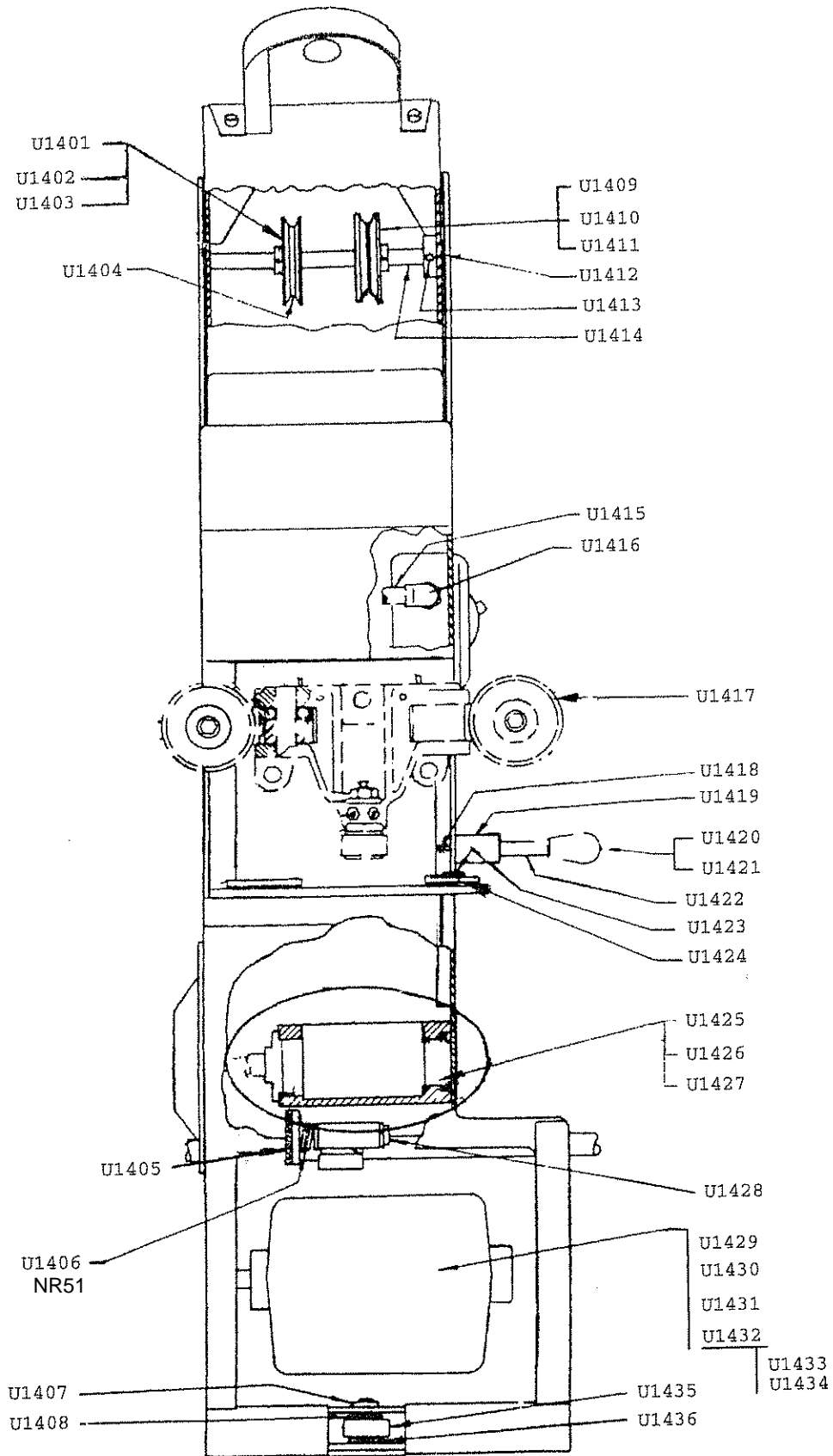
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**PLATE 13**

KEY.	MACHINE NO. 2123 AND AFTER	MACHINE NO. 2122 AND BEFORE	DESCRIPTION.
U1301	NR-202	NR-1	MAIN FRAME
U1302	N-691	SAME	CLUTCH RELEASE HANDLE
U1303	7106	SAME	ROLL PIN
U1304	267	SAME	SCREW
U1305	181	SAME	AERO WASHER
U1306	2625	1638	SCREW
U1307	100	5887	JAM NUT
U1308	283	SAME	BOLT
U1309	181	SAME	AERO WASHER
U1310	1633	SAME	SCREW
U1311	1632	SAME	AERO WASHER
U1312	S3234	SEE RIGHT	COVER
U1313	S3202	SEE RIGHT	STOP BUTTON * NOT USED ON MACH. PRIOR TO SER.NO. 2059*
U1314	S3203	SEE RIGHT	STOP OPERATOR * NOT USED ON MACH. PRIOR TO SER.NO. 2059*
U1315	S3233	SEE RIGHT	BOX * NOT USED ON MACH. PRIOR TO SER.NO. 2059*
U1316	S3204	SEE RIGHT	CONTACT BLOCK * NOT USED ON MACH. PRIOR TO SER.NO. 2059*
U1317	S3085	SAME	SEALTITE
U1318	NR-244	SEE RIGHT	HARNESS * NOT USED ON MACH. PRIOR TO SER.NO. 2059*
U1319	NR-108	SAME	REAR COVER
U1320	1921 A	SAME	SWITCH
U1321	S2851	SAME	ENCLOSURE
U1322	NR-246	SAME	HARNESS
U1323	NR-99	SAME	TOOL TRAY
U1324	500	SAME	SCREW
U1325	815	SAME	LOCKWASHER
U1326	6360	SAME	NUT
U1327	NR-147	SAME	TRANSFORMER
U1328	NR-243	SEE RIGHT	HARNESS * NOT USED ON MACH. PRIOR TO SER.NO. 2059*
U1329	6748	SAME	SCREW
U1330	5988	SAME	JAM NUT
U1331	3100	SAME	SCREW
U1332	5988	SAME	JAM NUT

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MAIN DRIVE ASSEMBLY

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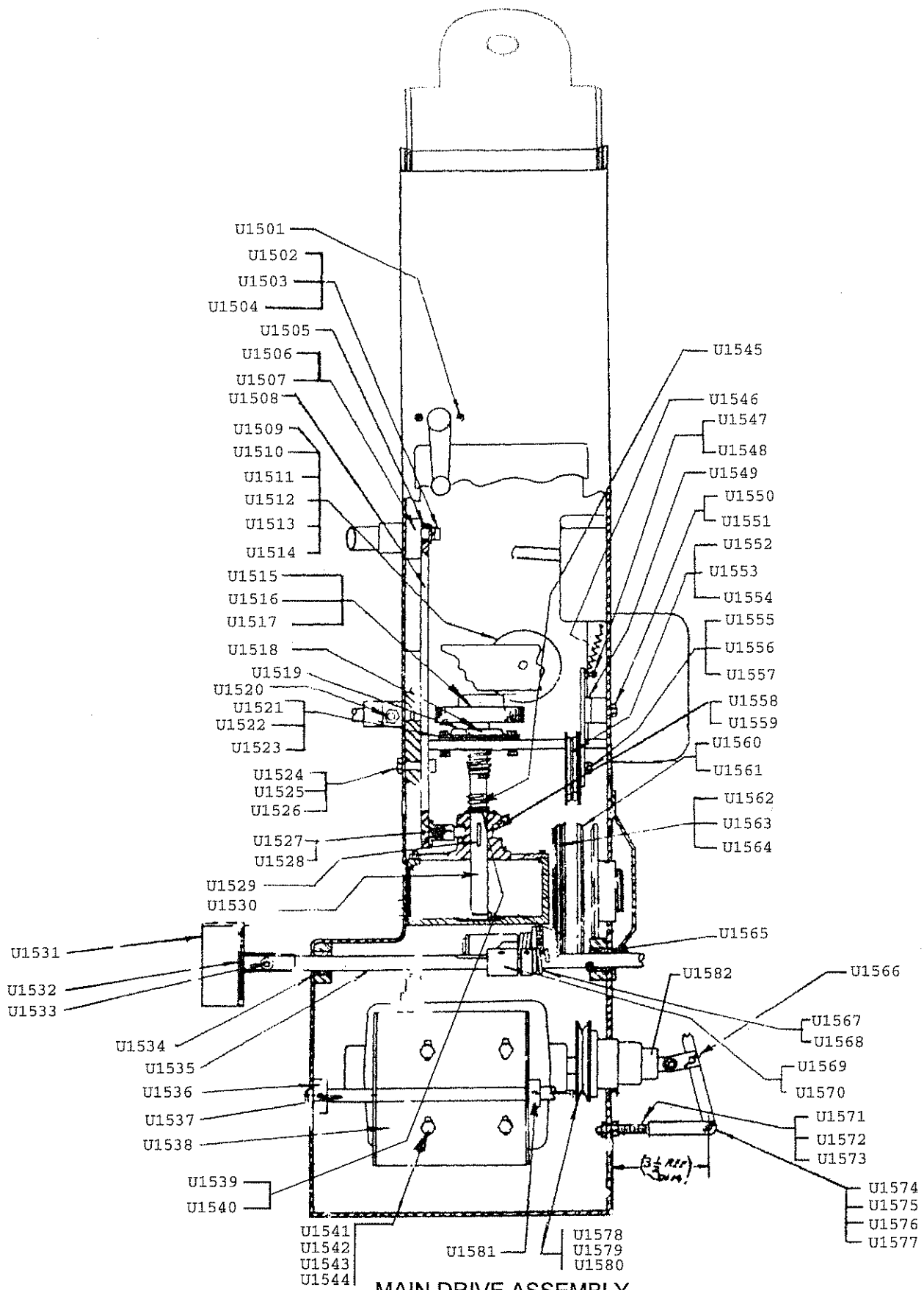
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**PLATE 14**

KEY.	MACHINE NO. 2123 AND AFTER	MACHINE NO. 2122 AND BEFORE	DESCRIPTION.
U1401	NR-333 A	SEE RIGHT	SHEAVE (USE NR-110 ON MACHINES PRIOR TO SER. NO. 1085)
U1402	S3186	SAME	BEARING
U1403	1542	SAME	RETAINING RING
U1404	NR-15	SAME	BELT - SEWING HEAD (97" BELT-S3790, 108" BELT-S3901)
U1405	NR-374	SAME	BRAKE ROD ASSEMBLY
U1406	NR-51 NR51	SAME	BRAKE DISC SPRING
U1407	NR-88	SAME	LOWER ROLLER STUD
U1408	234	SAME	AERO WASHER
U1409	NR-375 A	SEE RIGHT	SHEAVE ( USE NR-110 ON MACHINES PRIOR TO SER. NO. 1085 )
U1410	S3186	SAME	BEARING
U1411	1542	SAME	RETAINING RING
U1412	181	SAME	WASHER
U1413	6018	SAME	SCREW
U1414	NR-35	SAME	TILT BASE PIVOT SHAFT
U1415	NR-246	SEE RIGHT	WIRE HARNESS ( NOT USED PRIOR TO SER. NO. 2095 )
U1416	S3085	7024	SEALTITE
U1417	NR-870	SAME	FROG ASSEMBLY
U1418	7172	SAME	SCREW
U1419	NR-172	SAME	COLLAR
U1420	1994	SAME	OVAL KNOB
U1421	6678	SAME	WASHER
U1422	NR-95	SAME	GEAR LOCK PIN
U1423	NR-187	SEE RIGHT	STUD ( NR-61 USED PRIOR TO SER. NO. 2057 )
U1424	NR-60	SAME	ROLLER
U1425	NR-233	SEE RIGHT	GEAR BOX ASSY. * SEE PLATE 10 FOR GEAR BOX PRIOR TO *
U1426	S3239	SEE RIGHT	GEAR BOX OIL MACHINE SERIAL NO. 2056
U1427	S3549	SEE RIGHT	SHIM SET
U1428	6348	SAME	RETAINING RING
U1429	NR-120-1	SAME	MOTOR ( 220 / 440 VOLT-3 PHASE-50/60 CYCLE )
U1430	NR-120-2	SAME	MOTOR ( 220 / 440 VOLT-3 PHASE-50/60 CYCLE-HIGH ALTITUDE )
U1431	NR-120-3	SAME	MOTOR ( 575 VOLT-3 PHASE-60 CYCLE )
U1432	S3285	SAME	MOTOR ( 110 / 220 VOLT-1 PHASE-60 CYCLE-1 H.P. )
U1433	NR-251-00	SAME	ELECTRIC BOX ( 110 MOTORS ONLY )
U1434	NR-251-01	SAME	COVER ( 110 MOTORS ONLY )
U1435	NR-89	SAME	ROLLER
U1436	234	SAME	WASHER

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MAIN DRIVE ASSEMBLY

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PLATE 15

KEY.	MACHINE NO. 2123 AND AFTER	MACHINE NO. 2122 AND BEFORE	DESCRIPTION.
U1501	1711	SAME	SCREW
U1502	6753	SAME	SCREW
U1503	1643	SAME	STAR WASHER
U1504	117	SAME	WASHER
U1505	NR-97	SAME	SLEEVE
U1506	NR-222	SEE RIGHT	SHAFT ( USE NR-96 A PRIOR TO MACHINE SER. NO. 2056 )
U1507	7250	SEE RIGHT	ROLL PIN ( # 6645 SCREW, 6735 NUT USED PRIOR TO SER. NO. 2056 )
U1508	NR-225	SEE RIGHT	ARM ( USE NR-90 PRIOR TO MACHINE SER. NO. 2056 )
U1509	6067	SAME	CHECK NUT
U1510	NR-333 A	SEE RIGHT	SHEAVE ( USE NR-110 PRIOR TO MACHINE SER. NO. 1085 )
U1511	2036	SAME	BEARING
U1512	1542	SAME	RETAINING RING
U1513	1640	SAME	SCREW
U1514	181	SAME	WASHER
U1515	NR-113-00	SEE RIGHT	DRIVE GEAR ( REPLACES NR-86 )
U1516	14254	DBM-338	KEY
U1517	7233	SAME	SCREW
U1518	1153	SAME	BEARING
U1519	NR-59	SAME	FLANGETTE STAMPING
U1520	5108	SEE RIGHT	PLUNGER ( NR-93 & 94 USED PRIOR TO SER. NO. 885 )
U1521	6889	SAME	SCREW
U1522	102	SAME	LOCK WASHER
U1523	115	SAME	NUT
U1524	NR-231	SEE RIGHT	CLUTCH SLEEVE ( NOT USED PRIOR TO SER. NO. 2056 )
U1525	6375	SEE RIGHT	WASHER * USE NR-112 SCREW, 5887 NUT ON MACHINES *
U1526	S3491	SEE RIGHT	SCREW PRIOR TO SER. NO. 2056
U1527	NR-224	SEE RIGHT	CLUTCH ACTIVATOR ( NR-91 USED PRIOR TO SER. NO. 2056 )
U1528	2623	SEE RIGHT	SCREW ( 6034 SCREW USED PRIOR TO SER. NO. 2056 )
U1529	NR-941	SEE RIGHT	KEY ( NR125 USED PRIOR TO SER. NO. 2056 )
U1530	NR-114	SEE RIGHT	SHAFT ( NR-22 USED PRIOR TO SER. NO. 2056 )

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**PLATE 15**

KEY.	MACHINE NO. 2123 AND AFTER	MACHINE NO. 2122 AND BEFORE	DESCRIPTION.
U1531	NR-104	SAME	KNEE PAD
U1532	NR-102	SAME	KNEE PAD PLATE
U1533	356	SAME	SCREW
U1534	1634	SAME	BUSHING
U1535	NR-170	SEE RIGHT	KNEE SHAFT ( NR-48 USED PRIOR TO SER. NO. 832 )
U1536	1635	SAME	COLLAR
U1537	NR-101	SAME	MOTOR PIVOT SHAFT
U1538	NR-98	SAME	MOTOR MOUNTING PLATE
U1539	S3867	N / A	THRUST BEARING
U1540	S3868	N / A	TRUST WASHER ( 2 PER MACHINE )
U1541	110	SAME	SCREW
U1542	116	SAME	LOCK WASHER
U1543	6171	SAME	FLAT WASHER
U1544	282	SAME	NUT
U1545	S3193	SEE RIGHT	SPRING ( NR-25 USED PRIOR TO SER. NO. 2056 )
U1546	NR-47	SAME	BELT TENSIONER SPRING
U1547	771	SAME	SCREW
U1548	6360	SAME	NUT
U1549	NR-46	SAME	BELT TENSIONER ARM
U1550	1640	SAME	SCREW
U1551	109	SAME	NUT
U1552	NR-333 A	SEE RIGHT	SHEAVE ( NR-110 USED PRIOR TO SER. NO. 1085 )
U1553	2036	SAME	BEARING
U1554	1542	SAME	RETAINING RING
U1555	1640	SAME	SCREW
U1556	120	SAME	LOCK WASHER
U1557	109	SAME	NUT
U1558	NR-214	SEE RIGHT	MALE CLUTCH ( NR-9 USED PRIOR TO SER. NO. 2056 )
U1559	NR-215	SEE RIGHT	FEMALE CLUTCH RING ( NR-5 USED PRIOR TO SER. NO. 2056 )
U1560	NR-236	SEE RIGHT	SHEAVE ( NR-903 USED PRIOR TO SER. NO. 2056 )

**UNITED MATTRESS MACHINERY**

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Fax: (781) 331-8870

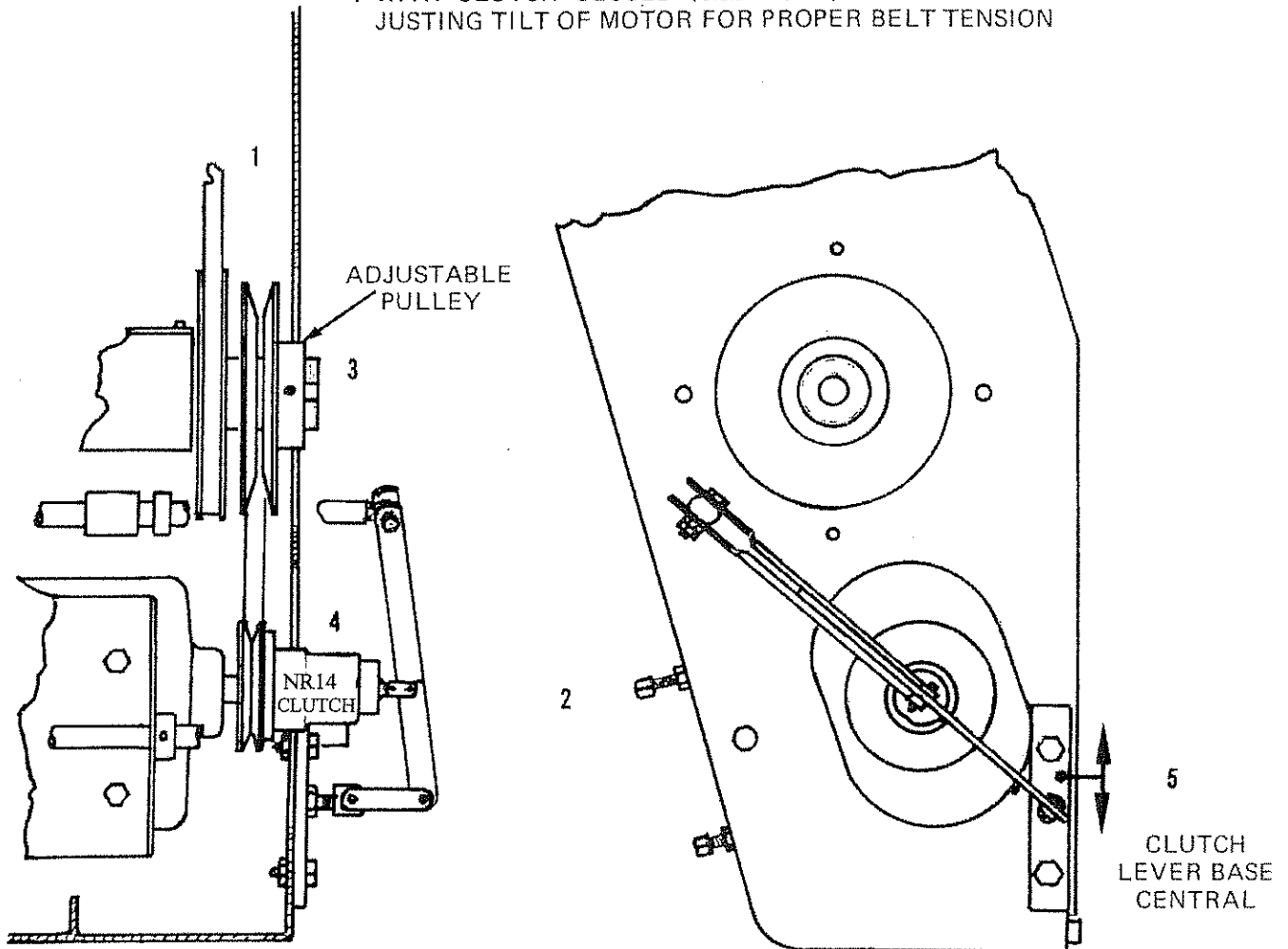
E-mail: mathcorp1@aol.com

**PLATE 15**

KEY.	MACHINE NO. 2123 AND AFTER	MACHINE NO. 2122 AND BEFORE	DESCRIPTION.
U1561	6526	SEE RIGHT	SCREW ( 6531 USED PRIOR TO SER. NO 2056 )
U1562	NR-211	SEE RIGHT	SHEAVE ( NR-12 USED PRIOR TO SER. NO 2056 )
U1563	2623	SEE RIGHT	SCREW ( NOT USED PRIOR TO SER. NO 2056 )
U1564	BM-257	SEE RIGHT	KEY ( 14462 USED PRIOR TO SER. NO 2056 )
U1565	1634	SAME	BUSHING
U1566	105	SAME	WASHER
U1567	NR-58	SAME	KNEE CONTROL SPRING
U1568	1635	SAME	COLLAR
U1569	NR-49	SAME	BRAKE ARM BRACKET
U1570	6531	SAME	SCREW
U1571	NR-173	SEE RIGHT	ADJUSTING ROD (NR-54 , NR-55 USED PRIOR TO SER.NO 921 )
U1572	109	SEE RIGHT	NUT ( NOT USED PRIOR TO SER.NO 921 )
U1573	813	SEE RIGHT	FLAT WASHER ( NOT USED PRIOR TO SER.NO 921 )
U1574	69065	SEE RIGHT	CLEVIS AND PIN (NOT USED PRIOR TO SER.NO 921 )
U1575	1099	SEE RIGHT	PIN ( NOT USED PRIOR TO SER.NO 921 )
U1576	129	SEE RIGHT	COTTER PIN ( NOT USED PRIOR TO SER.NO 921 )
U1577	119	SEE RIGHT	AERO WASHER ( NOT USED PRIOR TO SER.NO 921 )
U1578	NR-14	SAME	V-BELT CLUTCH
U1579	8493	SAME	V-BELT
U1580	14254	SAME	KEY
U1581	1635	SAME	COLLAR
U1582	NR14E60XY	SAME	REPLACEMENT BEARING ASSEMBLY FOR THE NR-14 CLUTCH

From the library of: Diamond Needle Corp

- 1 SLIP HEAD DRIVE BELT FROM PULLEY
- 2 RELEASE UPPER MOTOR ADJUSTING SCREW 1/2" APPROX.
- 3 TO CHANGE MACHINE TRAVEL SPEED — RELEASE SET SCREW IN HUB & OPEN (FASTER) OR CLOSE (SLOWER) TO DESIRED POSITION—RESET SCREW ON FLAT
- 4 WITH CLUTCH CLOSED (SEE NOTE) RESET 2 SCREWS READJUSTING TILT OF MOTOR FOR PROPER BELT TENSION



NOTE  
 CLUTCH PULLEY IS COMPLETELY CLOSED  
 WHEN ADJUSTING MOTOR SCREWS FOR  
 BELT TENSION  
 ROTATE CLUTCH BY HAND & PUSH TOWARD  
 MOTOR TO CLOSE CLUTCH TO OPERATING  
 POSITION

**MACHINE TRAVERSE SPEED ADJUSTMENT**

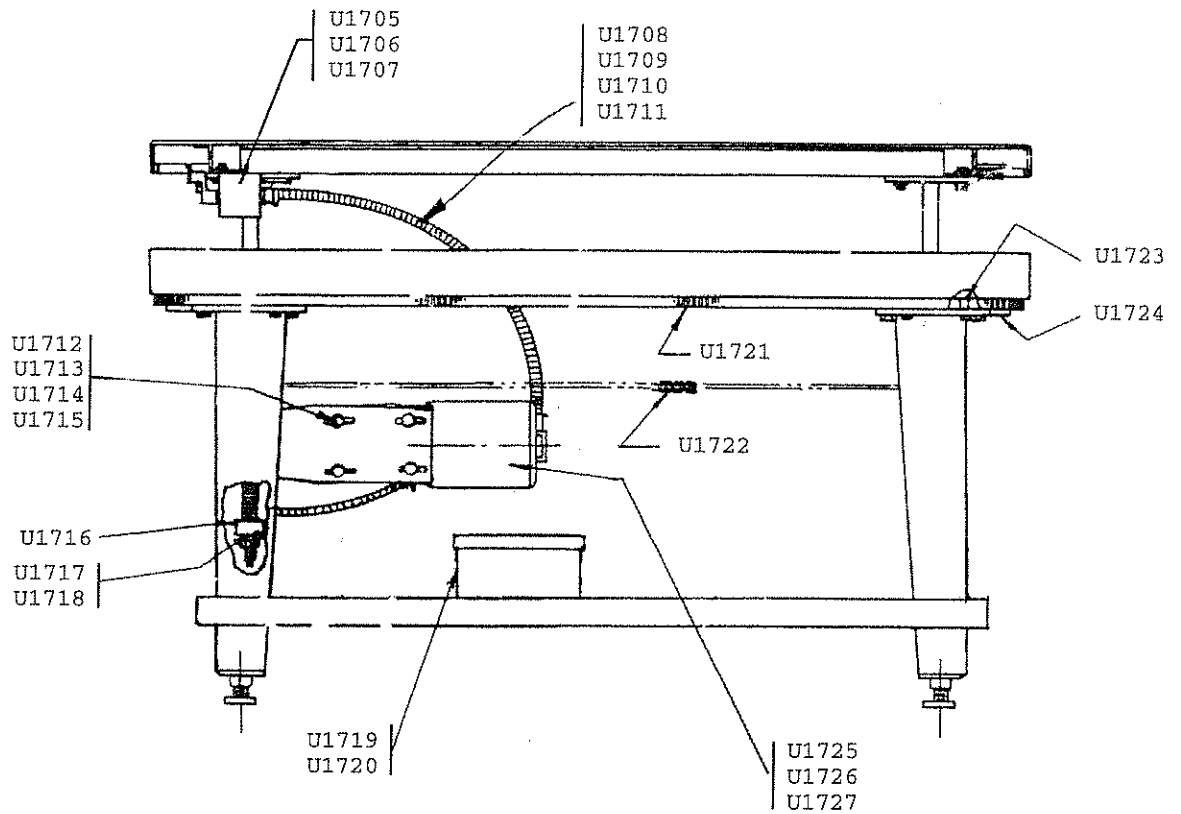
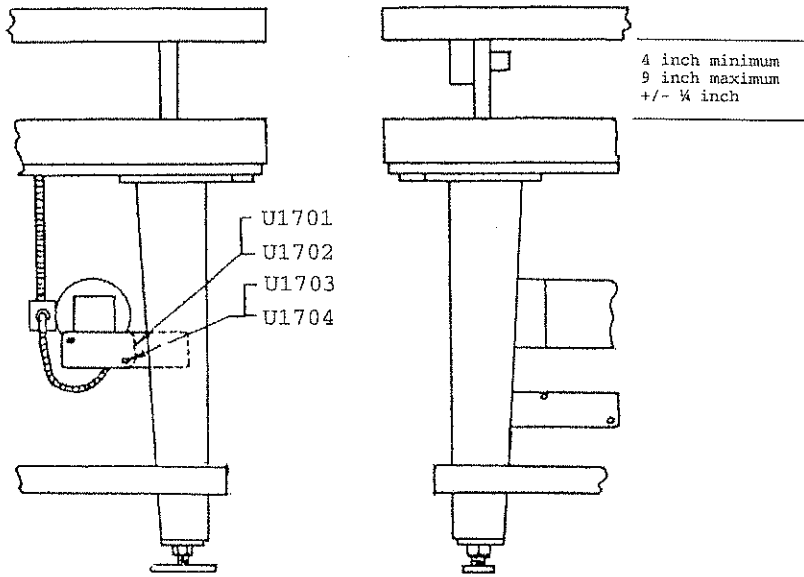
UNITED MATTRESS MACHINERY

PLATE 17

TABLE

(see over)





TABLE

PLATE 17

**UNITED MATTRESS MACHINERY**

Tel: (781) 331-8440 Toll Free 1-800-245-7250

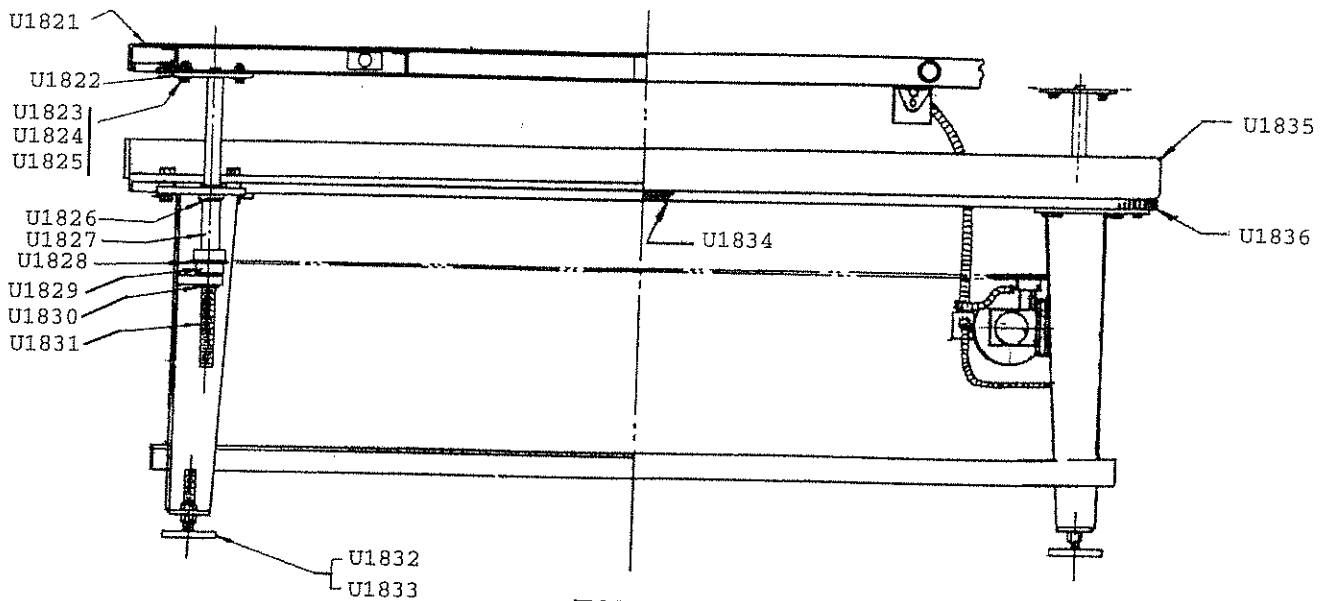
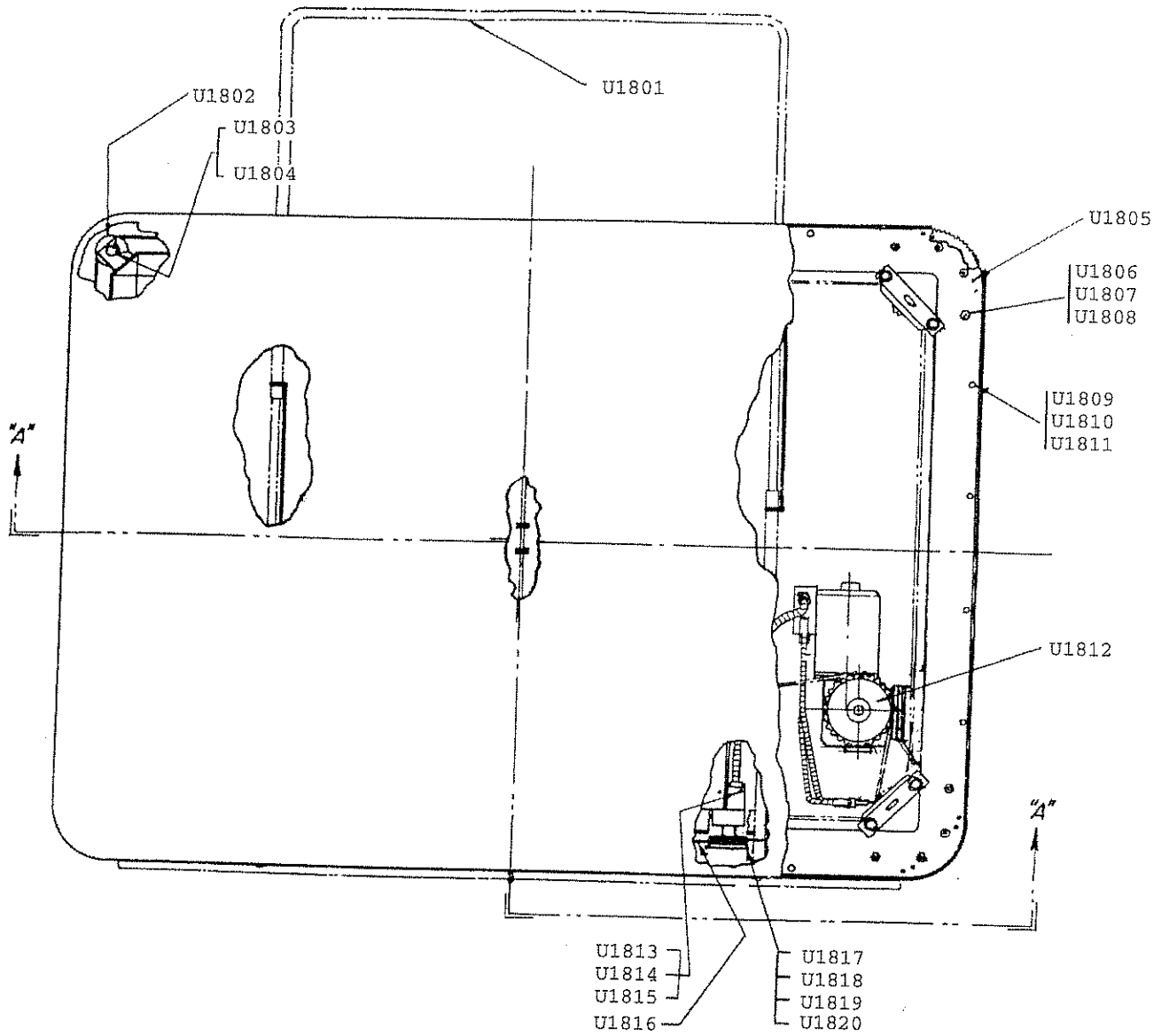
Fax: (781) 331-8870

E-mail: mathcorp1@aol.com

**PLATE 17**

KEY.	MACHINE NO. 2123 AND AFTER	MACHINE NO. 2122 AND BEFORE	DESCRIPTION.
U1701	S3220	SAME	LEVER
U1702	S3219	SAME	LIMIT SWITCH
U1703	101	SAME	SCREW
U1704	102	SAME	LOCK WASHER
U1705	NR-237	SAME	TABLE WIRING 110 V - 1 PHASE
U1706	NR-238	SAME	TABLE WIRING 220 V - 1 PHASE
U1707	NR-239	SAME	TABLE WIRING 220 V - 3 PHASE
U1708	NR-247	SEE RIGHT	CTL. BOX HARNESS ( NOT USED PRIOR TO SER.NO. 2095 )
U1709	NR-248	SEE RIGHT	REV. SWITCH HARNESS ( NOT USED PRIOR TO SER.NO. 2095 )
U1710	NR-249	SEE RIGHT	DOWN LIMIT SWITCH HARNESS ( NOT USED PRIOR TO SER.NO. 2095 )
U1711	NR-250	SEE RIGHT	UP LIMIT SWITCH HARNESS ( NOT USED PRIOR TO SER.NO. 2095 )
U1712	104	SAME	SCREW
U1713	6171	SAME	FLAT WASHER
U1714	116	SAME	LOCK WASHER
U1715	106	SAME	NUT
U1716	NR-232	SAME	LIMIT SWITCH ACTIVATOR
U1717	694	SAME	SCREW
U1718	120	SAME	LOCK WASHER
U1719	S3216	SAME	ENCLOSURE
U1720	NR-259	SAME	CONTROL BOX PANEL
U1721	NR-83	SAME	CORNER SEGMENTS
U1722	NR-314	SAME	CHAIN
U1723	NR-77	SAME	SPACER
U1724	NR-64	SAME	CORNER CAM
U1725	NR-316-1	SAME	TABLE MOTOR 220 / 440 V - 3 PHASE
U1726	NR-316-2	SAME	TABLE MOTOR 110 / 220 V - 1 PHASE
U1727	NR-316-3	SAME	TABLE MOTOR 575 V - 3 PHASE

From the library of: Diamond Needs Corp



TABLE

**UNITED MATTRESS MACHINERY**

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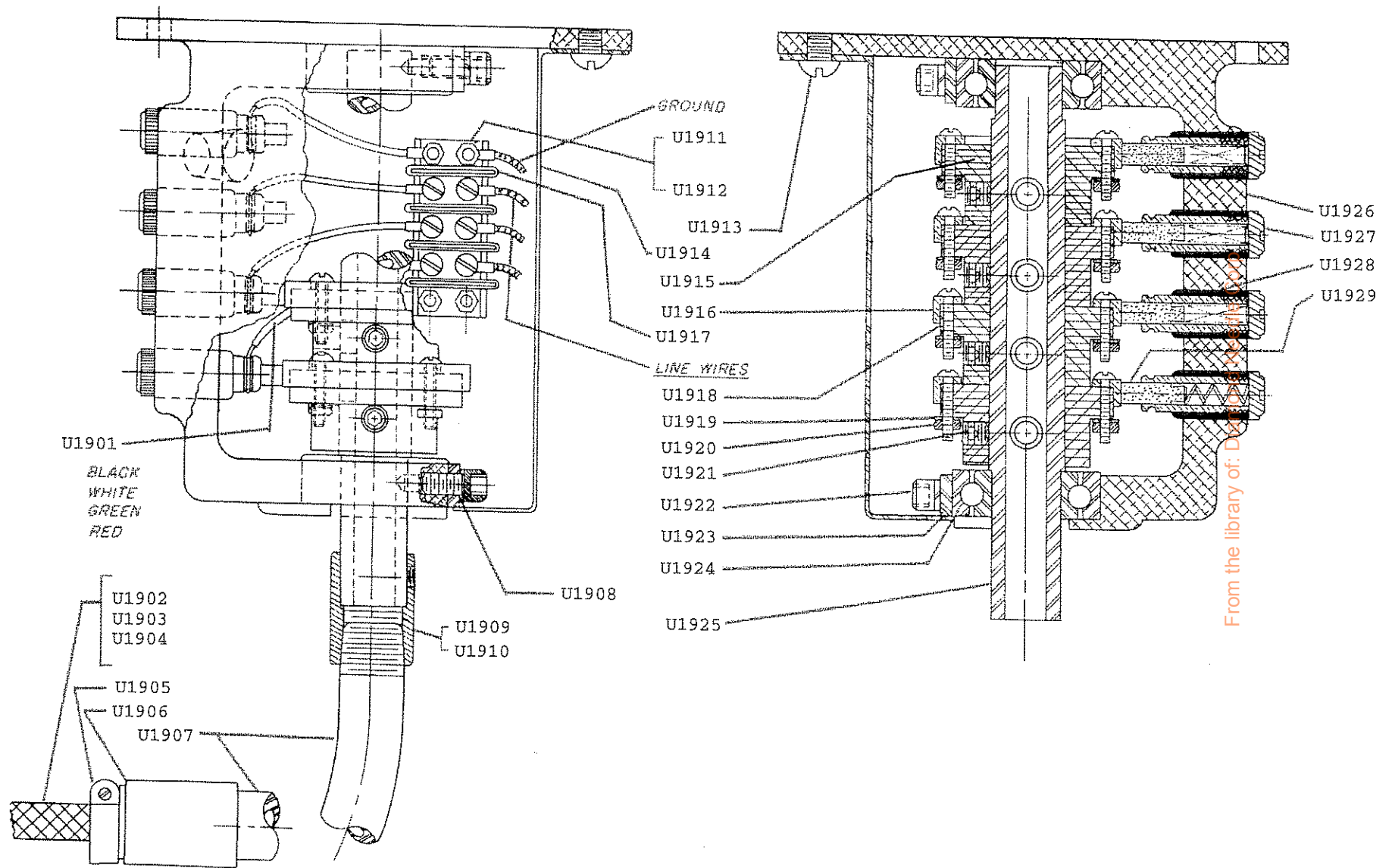
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**PLATE 18**

KEY.	MACHINE NO. 2123 AND AFTER	MACHINE NO. 2122 AND BEFORE	DESCRIPTION.
U1801	NR-720	SAME	EXTENSION BARS
U1802	7151	SAME	WHEEL
U1803	302	SAME	SCREW
U1804	6067	SAME	CHECK NUT
U1805	7225	SAME	ROLL PIN
U1806	877	SAME	SCREW
U1807	120	SAME	LOCK WASHER
U1808	109	SAME	NUT
U1809	6556	SAME	SCREW
U1810	102	SAME	LOCK WASHER
U1811	115	SAME	NUT
U1812	NR-315	SAME	SPROCKET
U1813	749	SAME	SCREW
U1814	815	SAME	LOCK WASHER
U1815	6360	SAME	NUT
U1816	NR-308	SAME	ROPE ( TABLE HEIGHT ADJUSMENT )
U1817	NR-351	SAME	CAM ( TABLE HEIGHT ADJUSMENT )
U1818	5711	SAME	SCREW
U1819	6171	SAME	FLAT WASHER
U1820	S3212	1721	REVERSING SWITCH
U1821	NR-600	SAME	TABLE TOP
U1822	NR-601	SAME	TABLE TOP MOUNTING PLATE
U1823	261	SAME	SCREW
U1824	813	SAME	FLAT WASHER
U1825	270	SAME	NUT
U1826	NR-303	SAME	BUSHING
U1827	NR-313	SAME	SPACER - ELEVATING SPROCKET
U1828	NR-309	SEE RIGHT	SPROCKET ( NR 312 USED PRIOR TO SER. NO. 2056 )
U1829	7245	SAME	BEARING
U1830	NR-303	SAME	BUSHING
U1831	NR-305	SEE RIGHT	ELEVATING SCREW ( NR-311 USED PRIOR TO SER. NO. 2056 )
U1832	BEE-197	SAME	TABLE FOOT
U1833	319	SAME	NUT
U1834	NR-84	SAME	TABLE GEAR RACK
U1835	NR-844	SAME	TABLE WELDMENT
U1836	NR-85	SAME	CORNER SEGMENTS

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OVERHEAD SWIVEL ASSEMBLY

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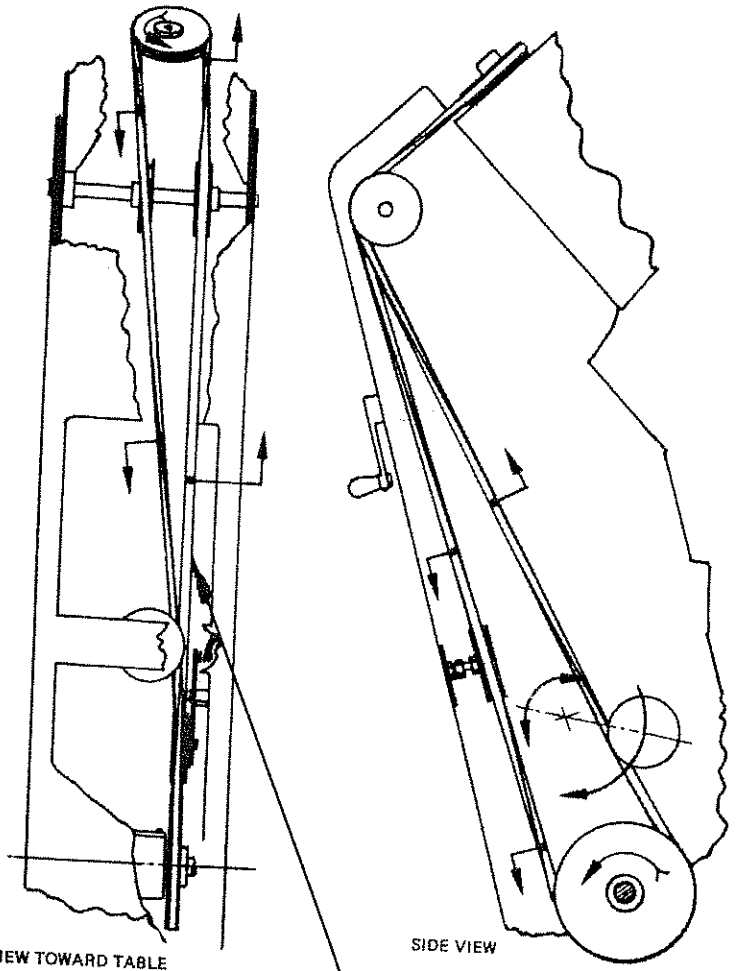
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**PLATE 19**

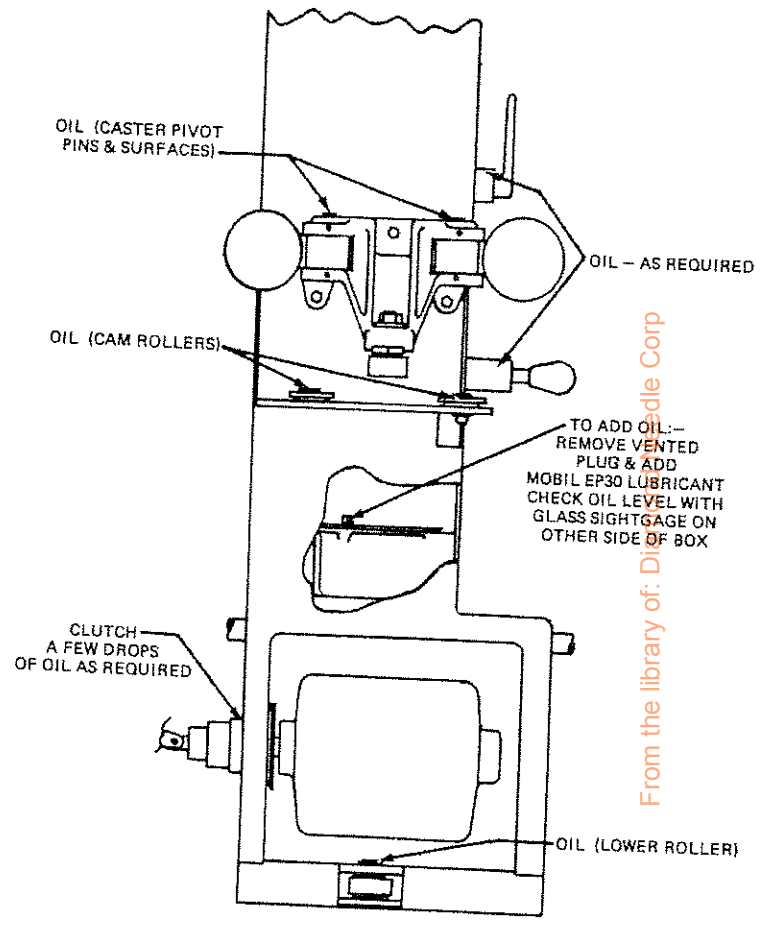
KEY.	PART NO.	DESCRIPTION.	KEY.	PART NO.	DESCRIPTION.
U1901	D-659 / 665	BRUSH HOLDER AND WIRE	U1921	889	SCREW
U1902	D-663	16-4 WIRE 14' LONG	U1922	6137	SCREW
U1903	1726	CONNECTOR BODY	U1923	D-653	CLAMP
U1904	1723	CONNECTOR	U1924	2197	BEARING
U1905	1309	CONNECTOR	U1925	D-652 A	SHAFT
U1906	617	COUPLING	U1926	D-651	SWIVEL HOUSING
U1907	D-661 A	ELBOW	U1927	D-660	CAP
U1908	6197	LOCK WASHER	U1928	D-659 / 665	BRUSH HOLDER AND WIRE
U1909	D-669	COUPLING	U1929	D-658	BRUSH - SPRING
U1910	6531	SET SCREW			
U1911	6451	NUT			
U1912	6574	SCREW			
U1913	1986	SCREW			
U1914	D-656	COVER			
U1915	D-654 A	BUSHING INSULATOR			
U1916	D-655	SLIP RING			
U1917	D-657	TERMINAL BLOCK			
U1918	957	SCREW			
U1919	7337	LOCK WASHER			
U1920	6451	NUT			

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VIEW TOWARD TABLE  
 NR15 - 89" ROUND DRIVE BELT  
 S3790 - 98" ROUND DRIVE BELT  
 S3901 - 108" ROUND DRIVE BELT

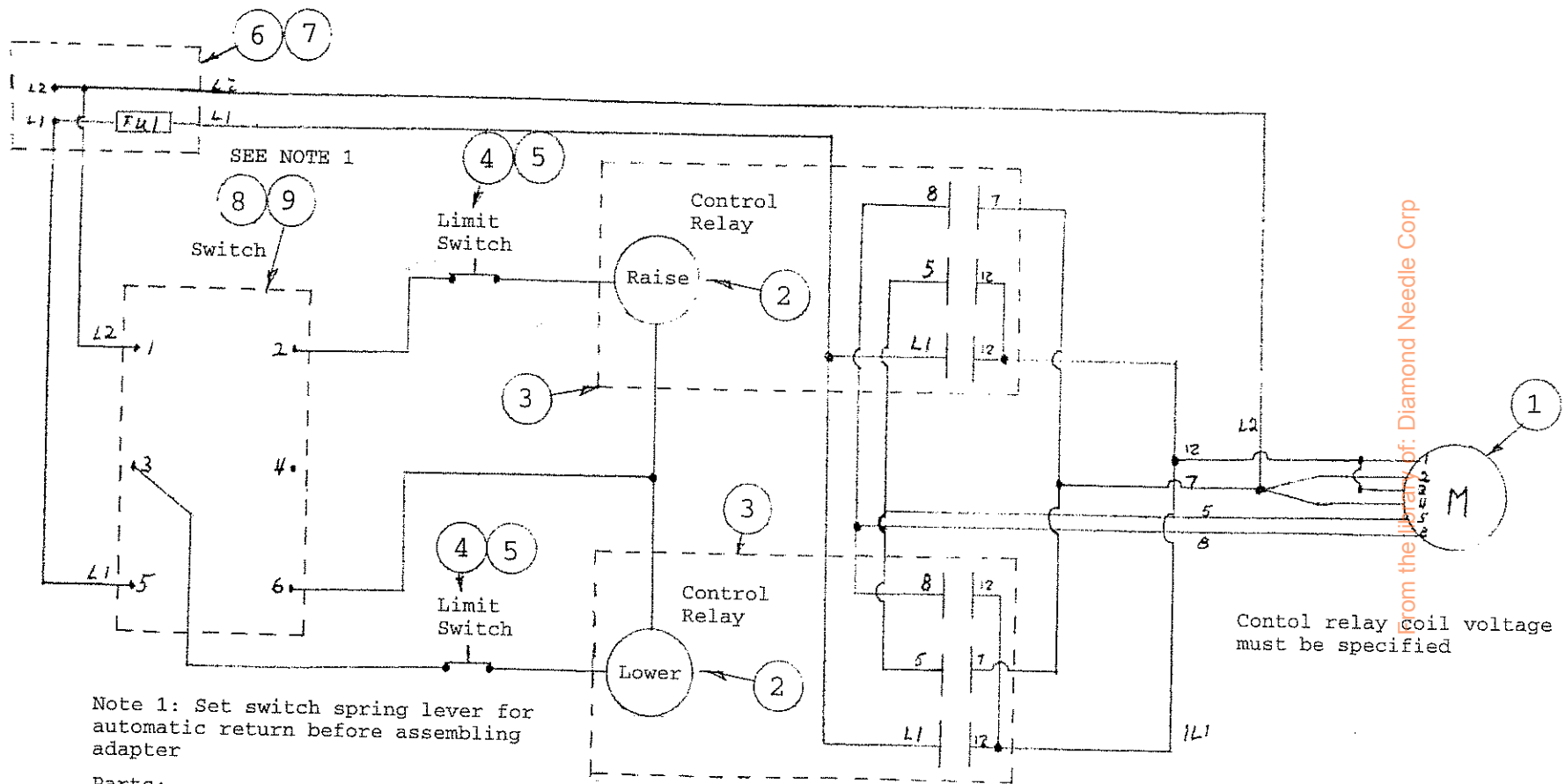
SEWING HEAD DRIVE BELT PATH



FOR MACHINES WITH GREASE FITTING IN PLACE OF OIL SIGHTGAGE - REMOVE VENTED PLUG & GREASE LEVEL SHOULD BE 1/2" TO 1 1/4" DEEP

LUBRICATION CHART

From the library of: Digi... Corp



Note 1: Set switch spring lever for automatic return before assembling adapter

Parts:

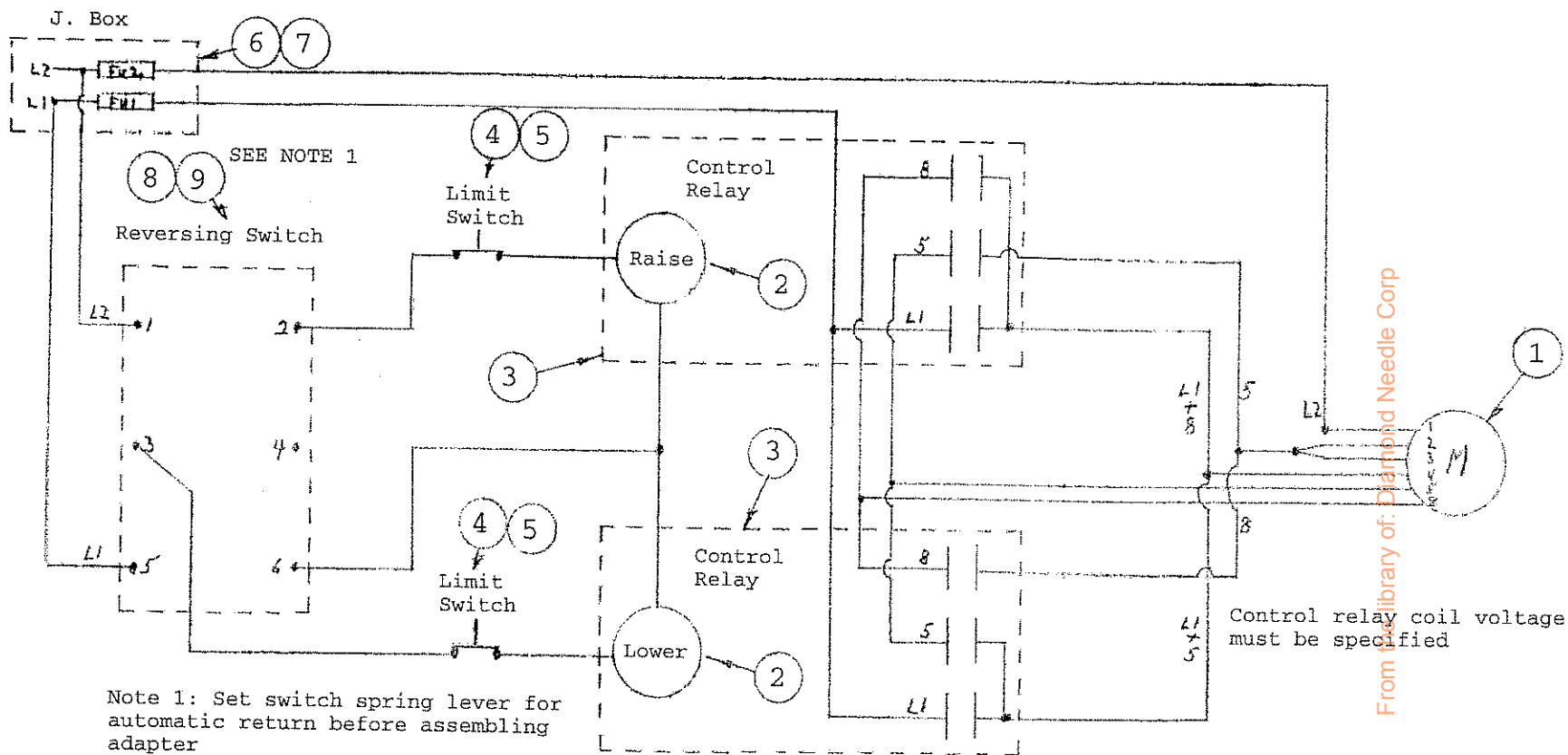
- 1 - NR316-2 Motor 110V Single phase
- 2 - S3691 Coil (coil voltage must be specified)
- 3 - S3248 Relay
- 4 - S3219 Limit Switch
- 5 - S3220 Lever Arm - Limit Switch
- 6 - S3236 Fuse Block
- 7 - S3268 Fuse
- 8 - S3212 Reversing Drum Switch
- 9 - NR351-01 Lever - Reversing Switch

NR TABLE ELECTRICAL SCHEMATIC  
1 PH 110V MOTOR

from the library of: Diamond Needle Corp

Control relay coil voltage must be specified

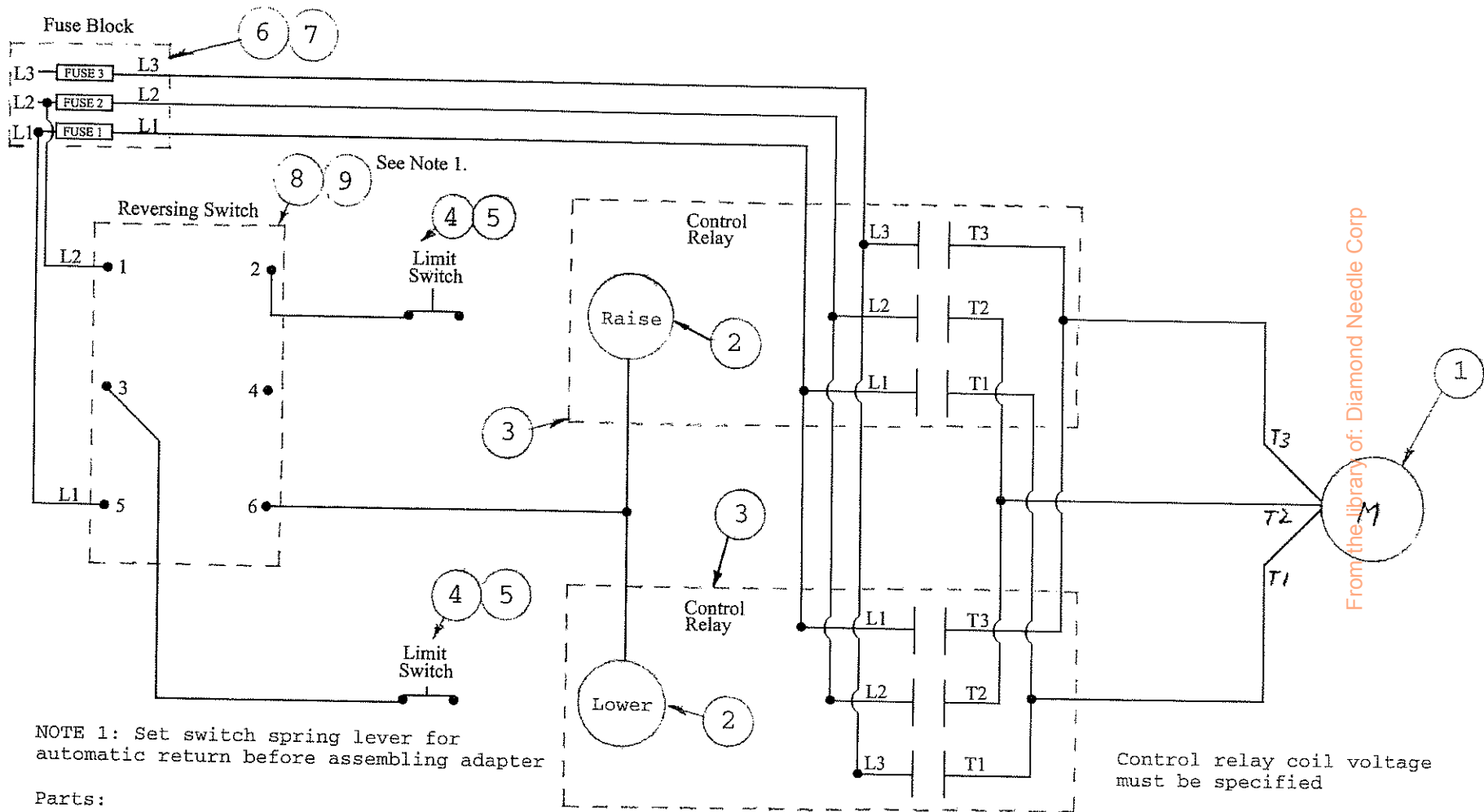




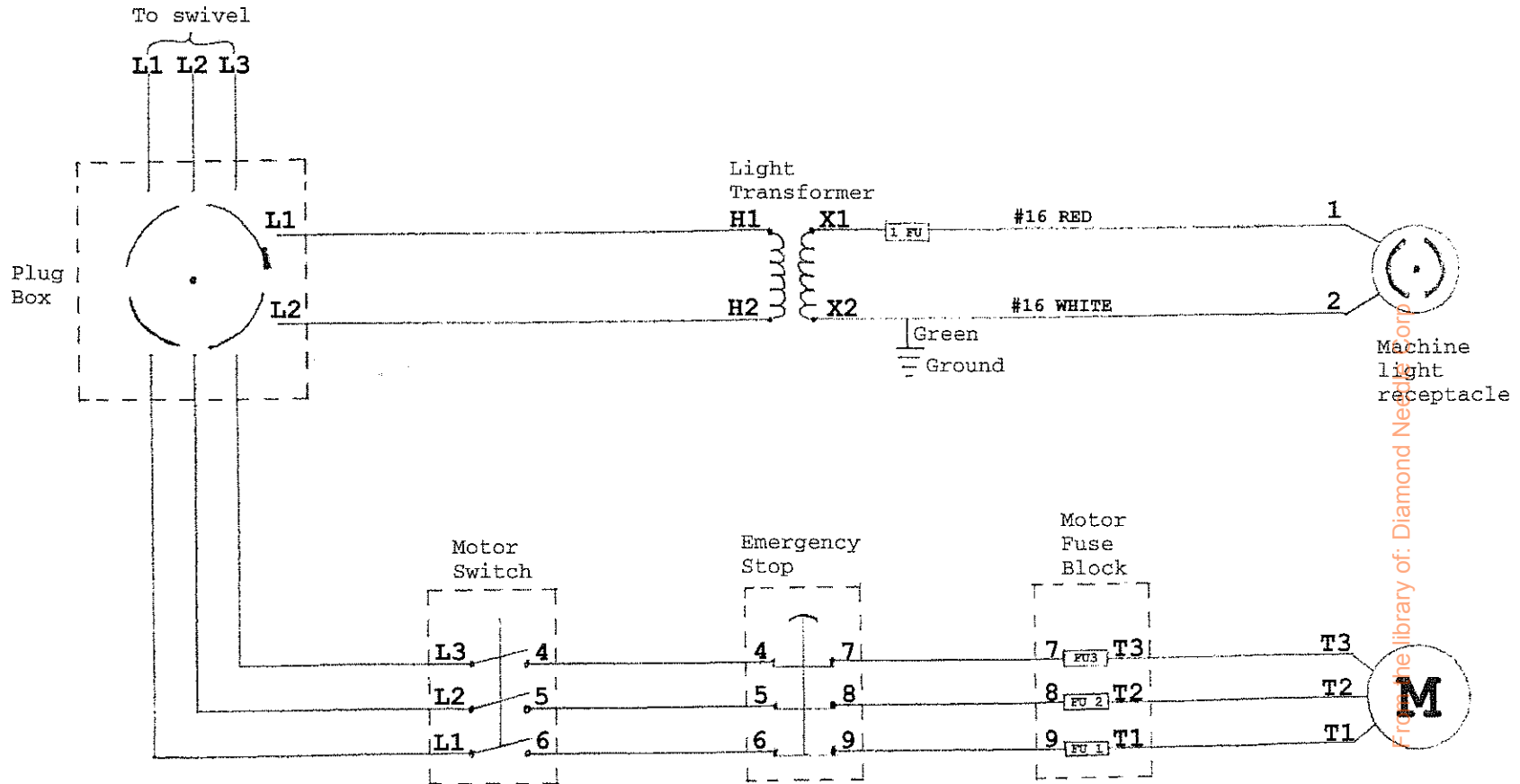
Parts:

- 1 - NR316-2 Motor 220V Single Phase
- 2 - S3692 Coil (coil voltage must be specified)
- 3 - S3261-220 Relay
- 4 - S3219 Limit Switch
- 5 - S3220 Lever Arm - Limit Switch
- 6 - S3236 Fuse Block
- 7 - S3265 Fuse
- 8 - S3212 Reversing Drum Switch
- 9 - NR351-01 Lever - Reversing Switch

NR TABLE ELECTRICAL SCHEMATIC  
1 PH 220V MOTOR



NR TABLE ELECTRICAL SCHEMATIC  
 3 PH 230/460V MOTOR



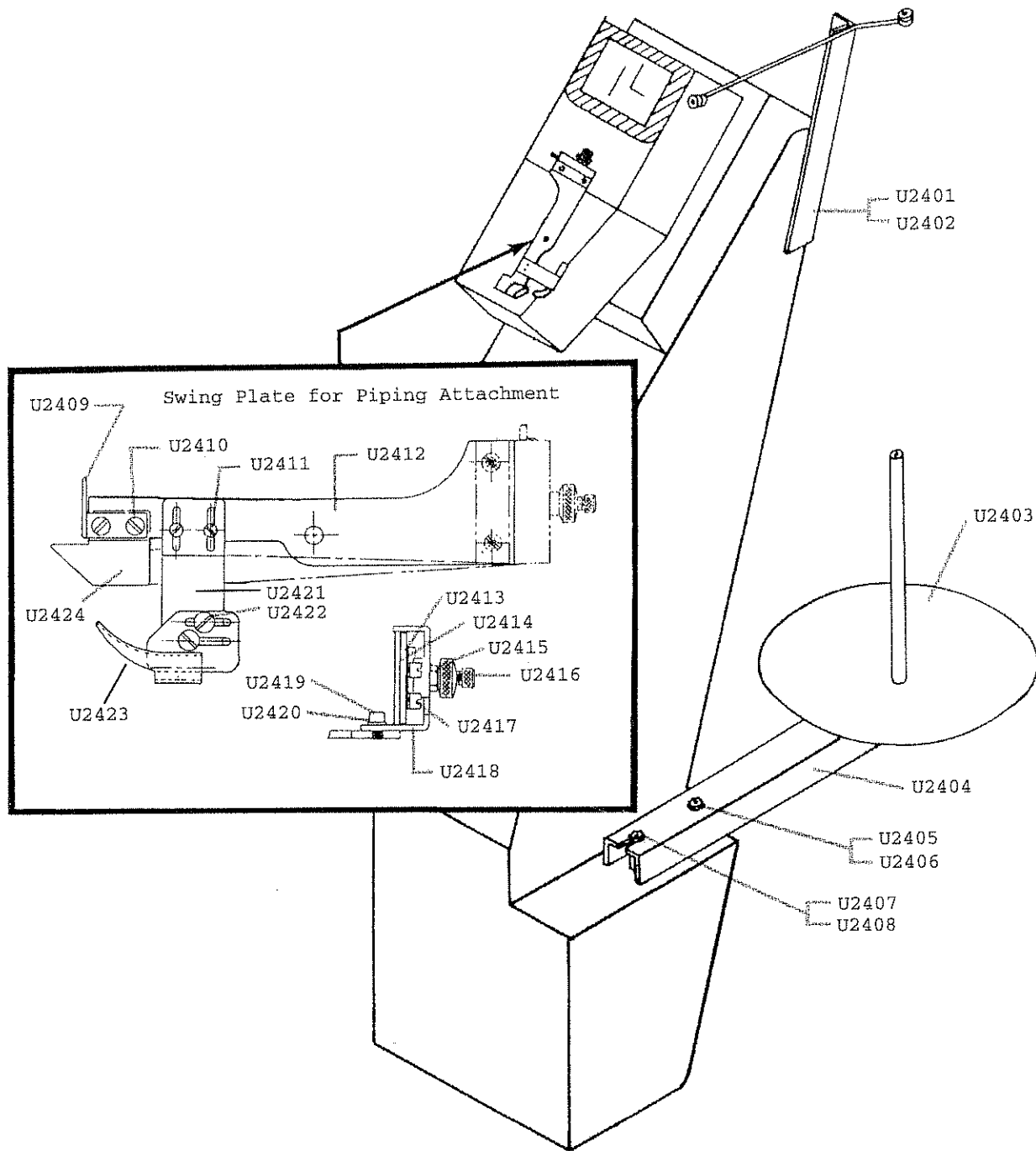
For single phase machines  
eliminate line #3

All wires shall be #14  
MTW (black) except  
where noted

NR CARRIAGE ASSEMBLY  
ELECTRICAL SCHEMATIC

UNITED MATTRESS MACHINERY

PLATE 24  
PIPING ATTACHMENT  
(see over)



From the library of: Diamond Needle Corp

PIPING ATTACHMENT

PLATE 24

**UNITED MATTRESS MACHINERY**

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E-mail: mathcorp1@aol.com

**PLATE 24**

KEY.	PART NO.	DESCRIPTION.
U2401	NR-458	PIPING GUIDE BRACKET
U2402	364	SCREW
U2403	NR-461	PIPING REEL HOLDER
U2404	NR-459	PIPING REEL HOLDER BRACKET
U2405	NR-460	STUD - PIPING REEL HOLDER BRACKET
U2406	6067	CHECK NUT
U2407	877	SCREW
U2408	6067	CHECK NUT
U2409	NR-457	PIPING SUPPORT
U2410	1774	SCREW
U2411	1073	SCREW
U2412	NR-449 A	SWING PLATE BASE
U2413	SM-163 A	SPRING
U2414	NR-475	PLATE - TAPE TENSION
U2415	S3247	NUT
U2416	6219	SCREW
U2417	1841	SCREW
U2418	NR-474	BODY - TAPE TENSION
U2419	7230	SCREW
U2420	648	LOCK WASHER
U2421	NR-478	PIPING GUIDE BASE PLATE
U2422	2171	SCREW
U2423	NR-480	PIPING GUIDE
U2424	NR-450 A	1-3/8" - 1-1/2", 36MM BINDER

From the library of: Diamond Needle Corp

## *UNITED MATTRESS MACHINERY*

### UNITED NR TAPE EDGE VARIABLE SPEED DRIVE

The variable speed drive carriage is an option offered by United for controlling the speed of the carriage and the sewing head as they travel around the table.

There is a control station located on the operator's side of the carriage, with two control knobs for controlling the speed of the carriage. The knob which is marked "straight", allows the operator to increase or decrease the speed of the carriage on the straightaway. The knob which is marked "corner", allows the operator to increase or decrease the speed of the carriage in the corners. The speeds for the straight and corners are independent. The speed selected should depend on the skill and experience of the operator.

Travel speed is also controlled by means of the foam rubber knee pad located on the operator's side of the carriage. The carriage can be stopped by exerting inward pressure on the knee pad, but can also be slowed by reducing the amount of inward pressure. Releasing the knee pad will allow the machine to reach the travel speed set at the operator's station.

The variable speed electronic components are located opposite the operator's side under a guard. the major electronic component is the variable frequency driver, which is preset at the factory and should not need to be adjusted. Please contact the factory before making any adjustments to this unit.

**USE CAUTION: when working with electrical components**

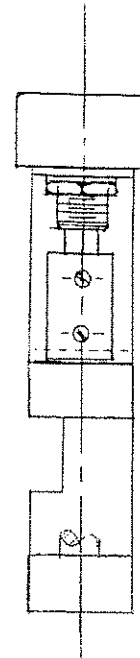
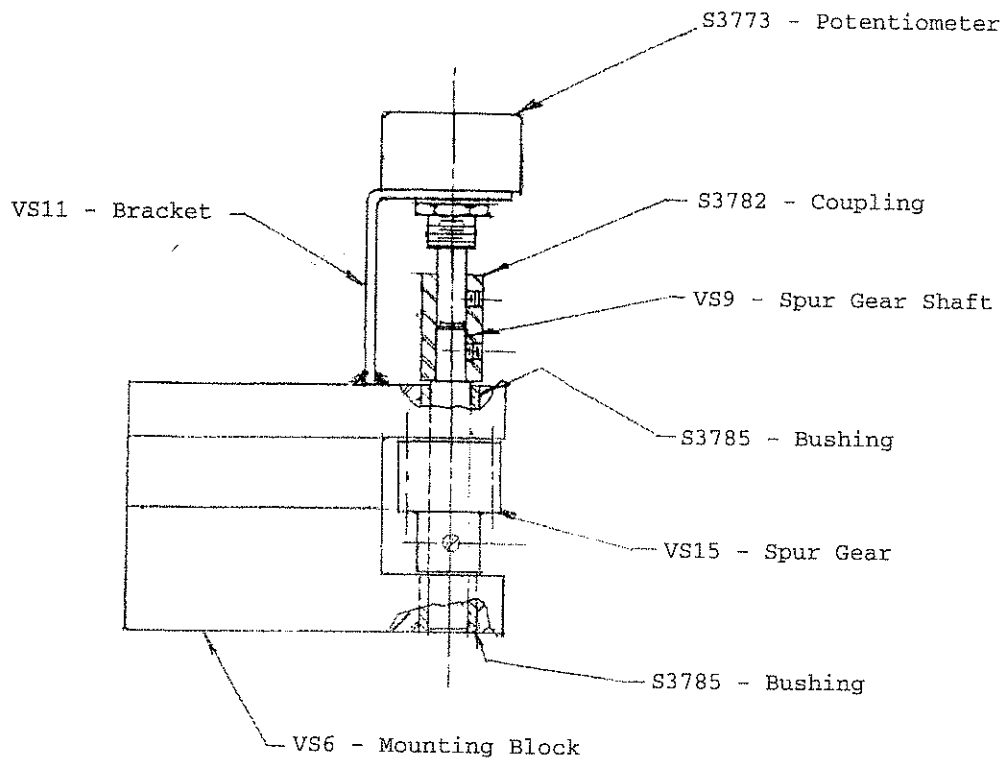
UNITED MATTRESS MACHINERY

PLATE 25  
VARIABLE SPEED DRIVE  
(see over)



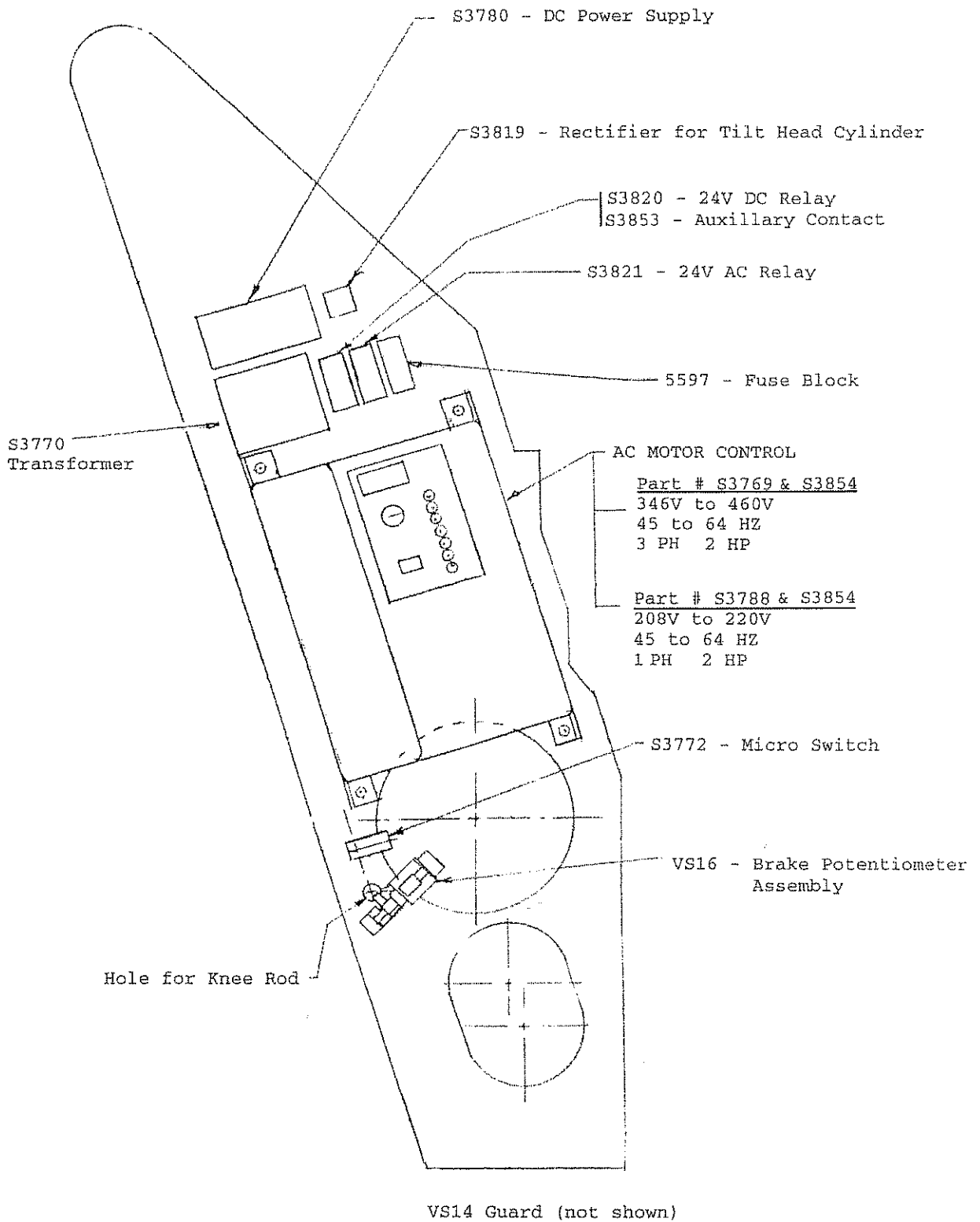
UNITED MATTRESS MACHINERY

PLATE 25  
RESERVED

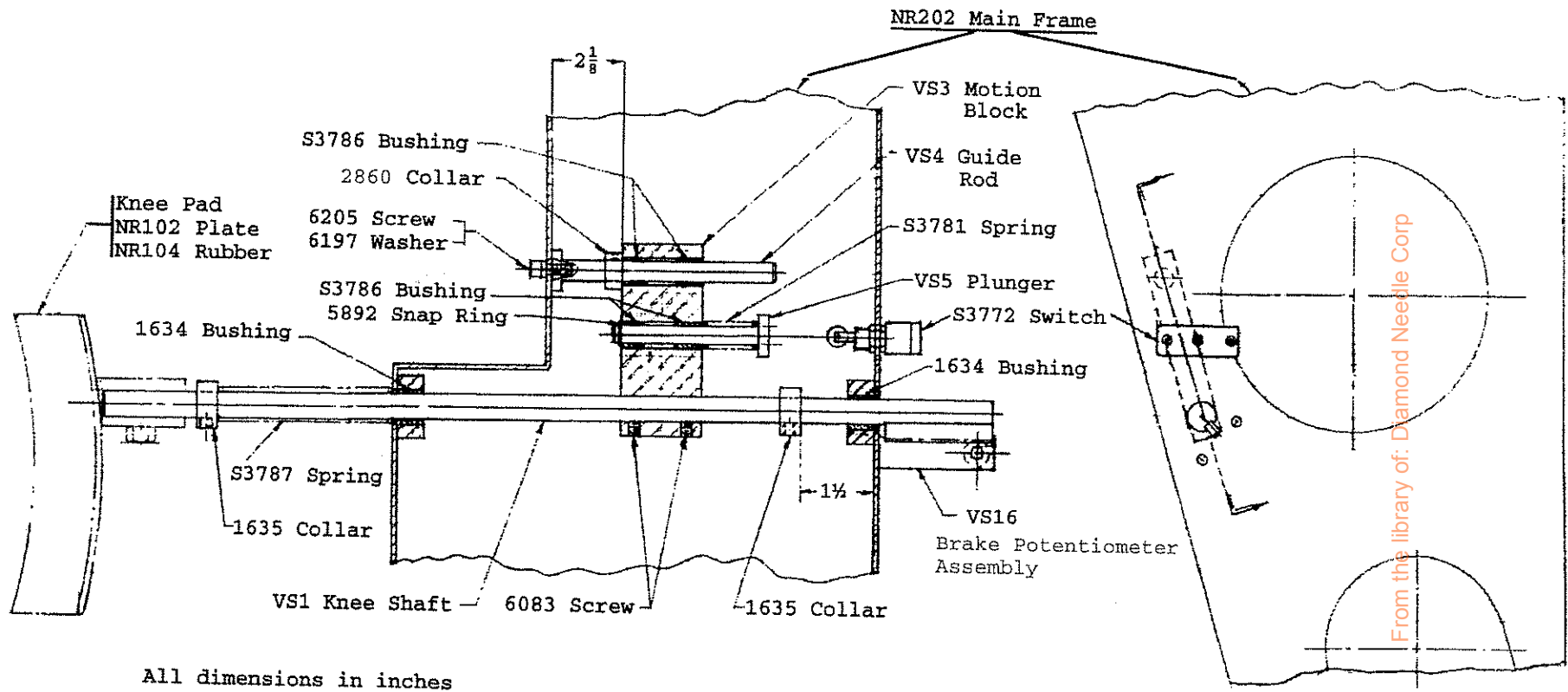


Order part number VS16 for complete assembly

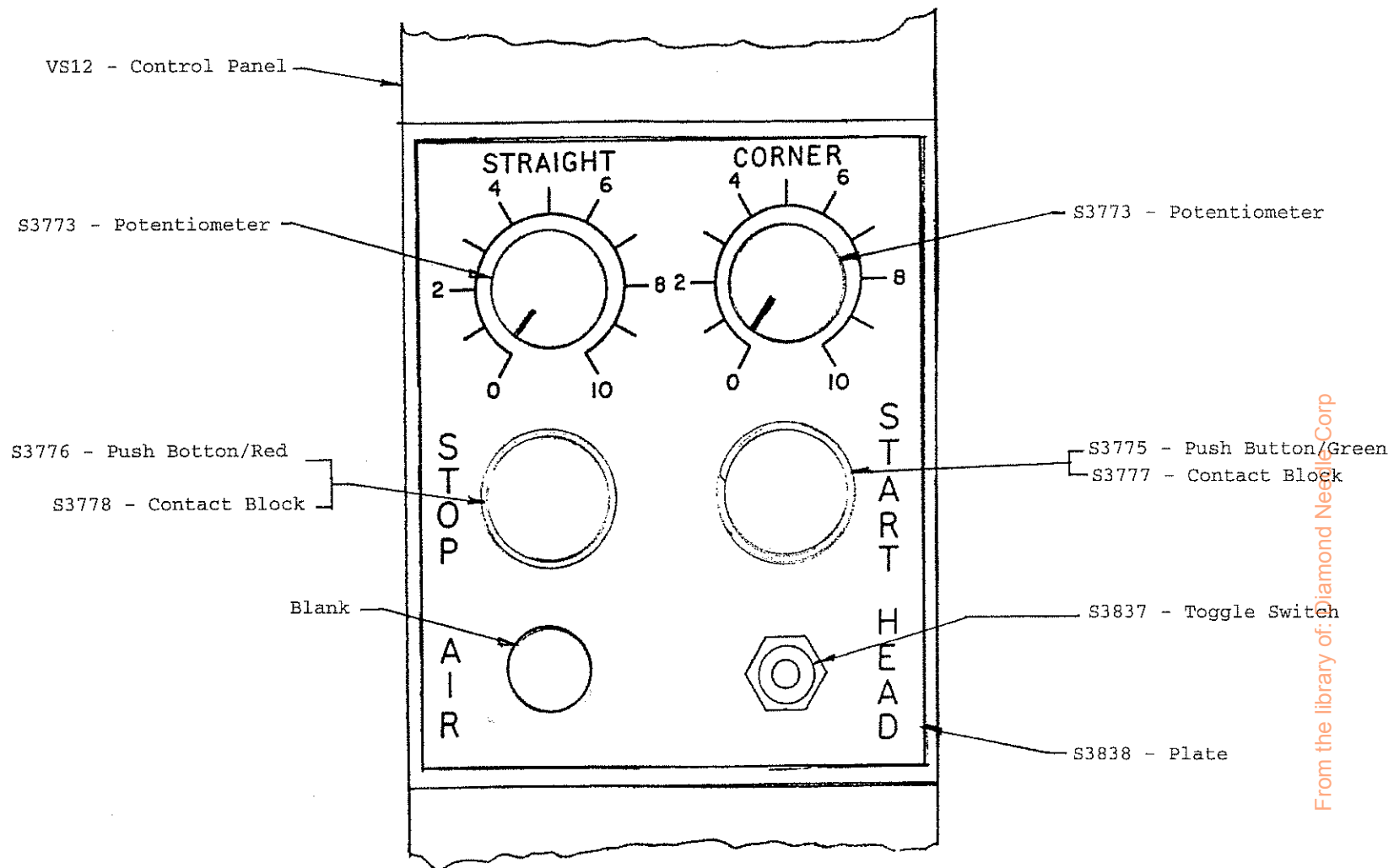
VARIABLE SPEED DRIVE  
BRAKE POTENTIOMETER ASSEMBLY



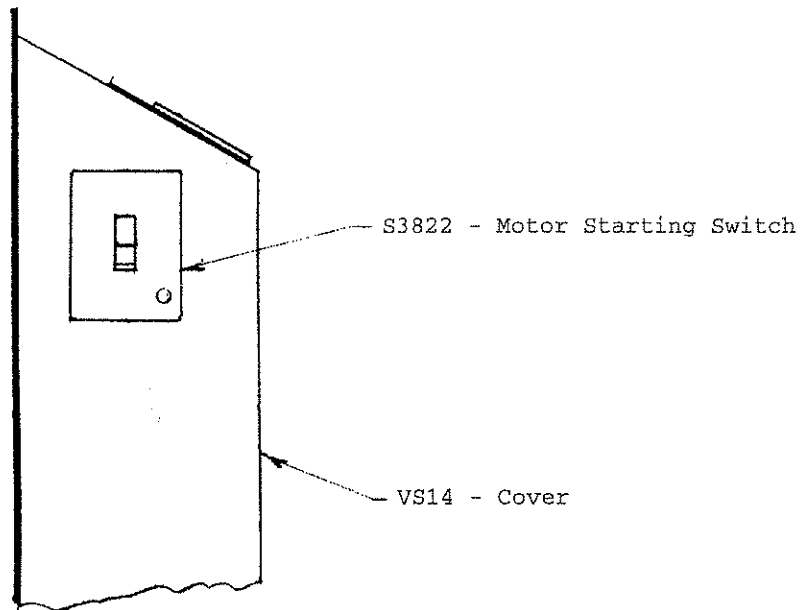
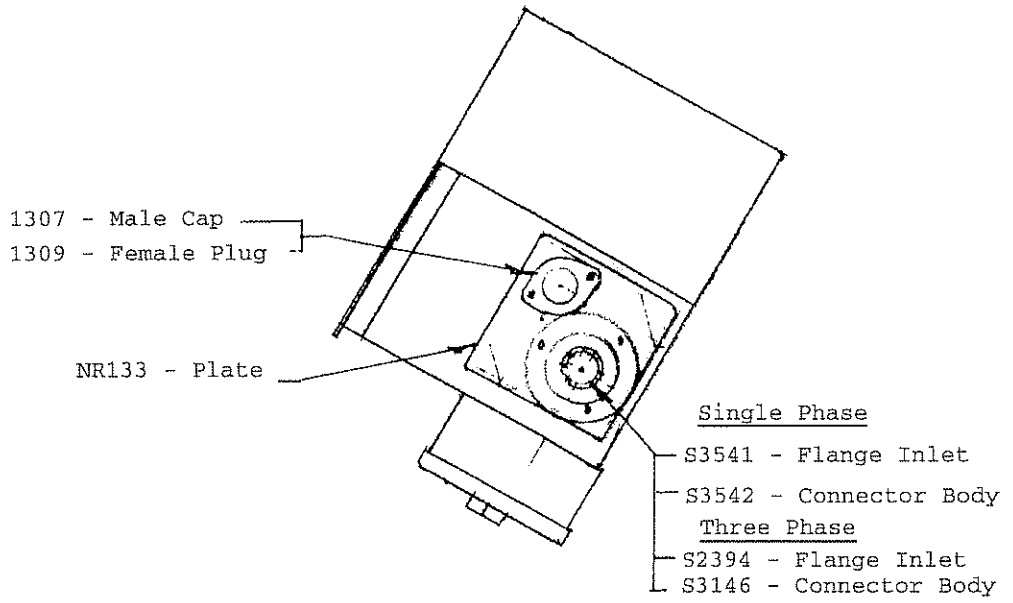
VARIABLE SPEED DRIVE  
COMPONENT LOCATIONS ON CONTROL SIDE OF CARRIAGE



VARIABLE SPEED DRIVE  
CARRIAGE INTERNAL PARTS

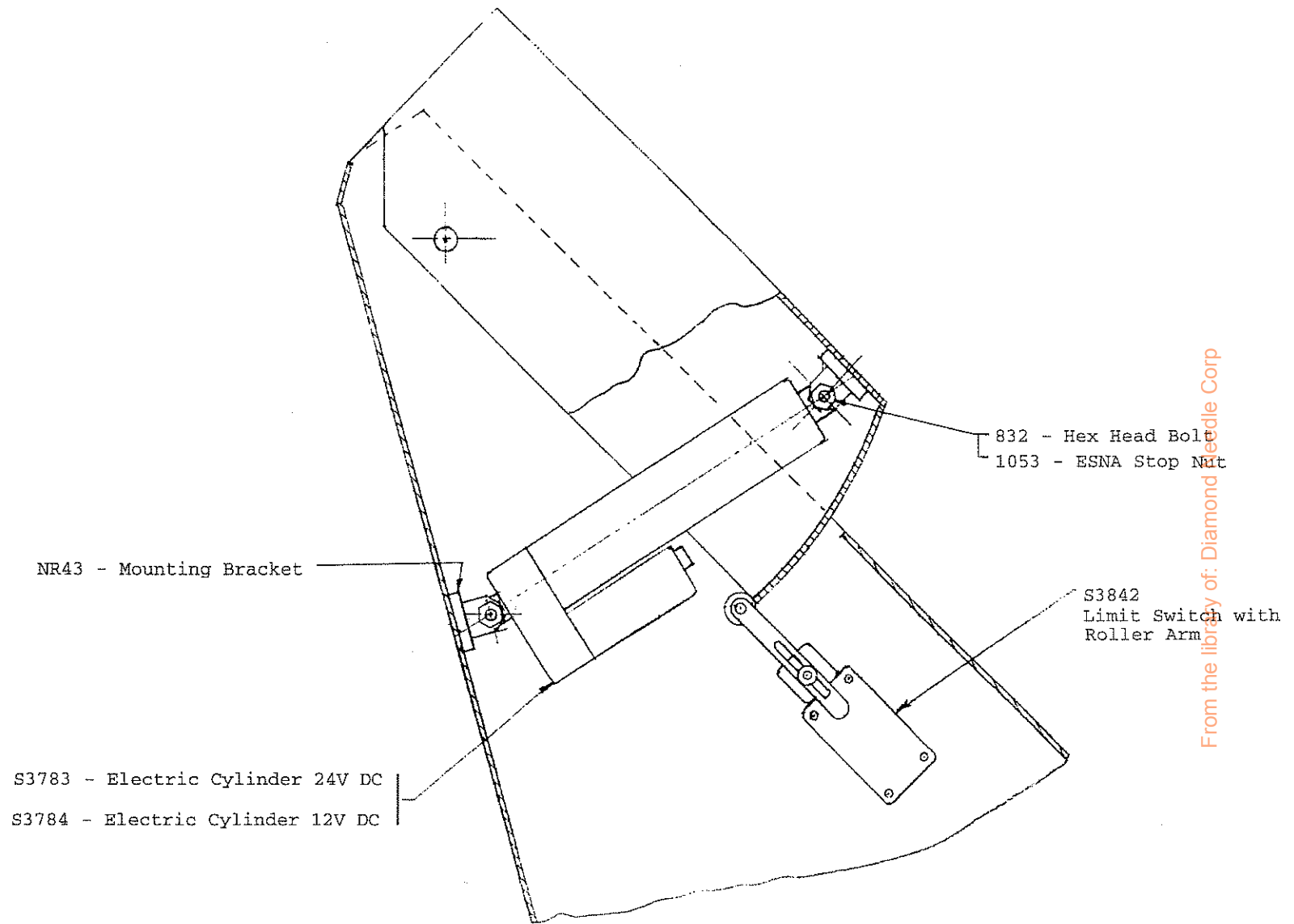


VARIABLE SPEED DRIVE  
CONTROL PANEL ASSEMBLY



VARIABLE SPEED DRIVE  
 GUARD GROUP

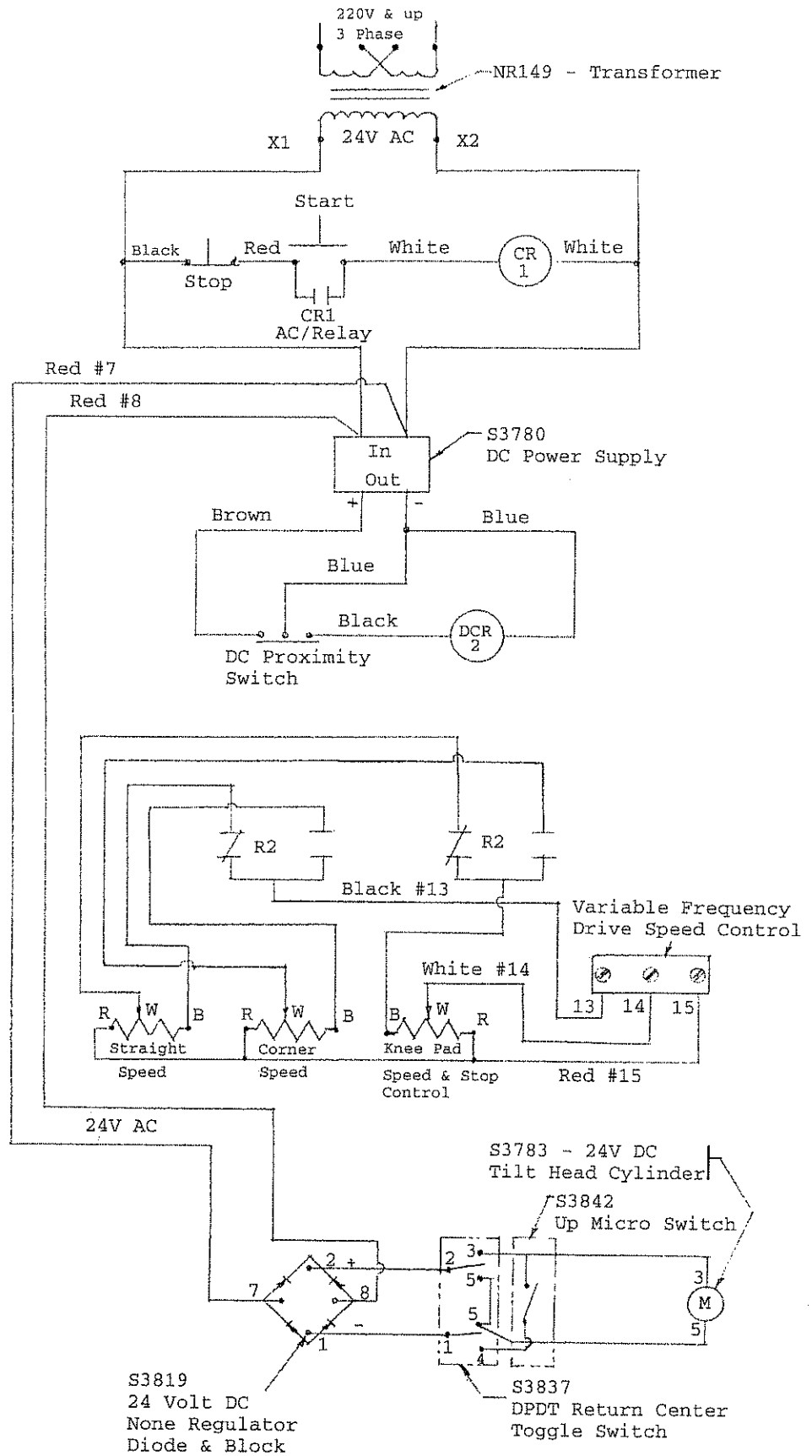
PLATE 30



From the library of: Diamond Needle Corp

Related items not shown:  
S3837 - Toggle Switch  
S3819 - Rectifier

VARIABLE SPEED DRIVE  
TILT HEAD ASSEMBLY

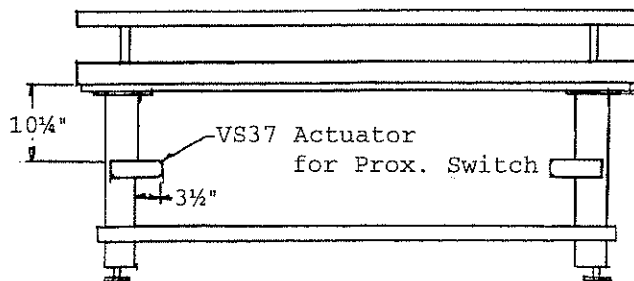
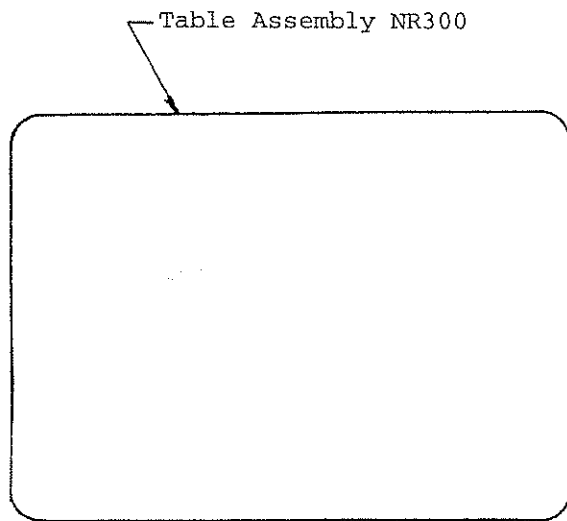


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VARIABLE SPEED DRIVE  
ELECTRICAL SCHEMATIC

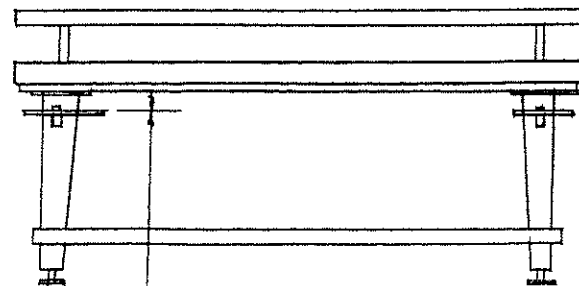
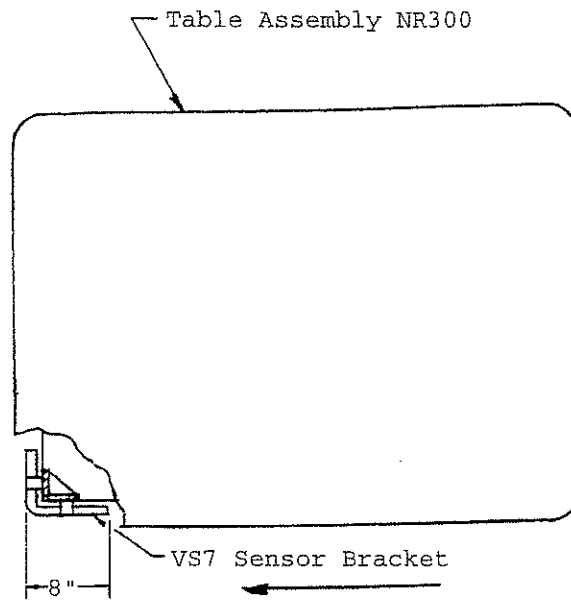


Machine Serial No. 2255VS  
and above



All measurements are in inches

Machines prior to  
Serial No. 2255VS

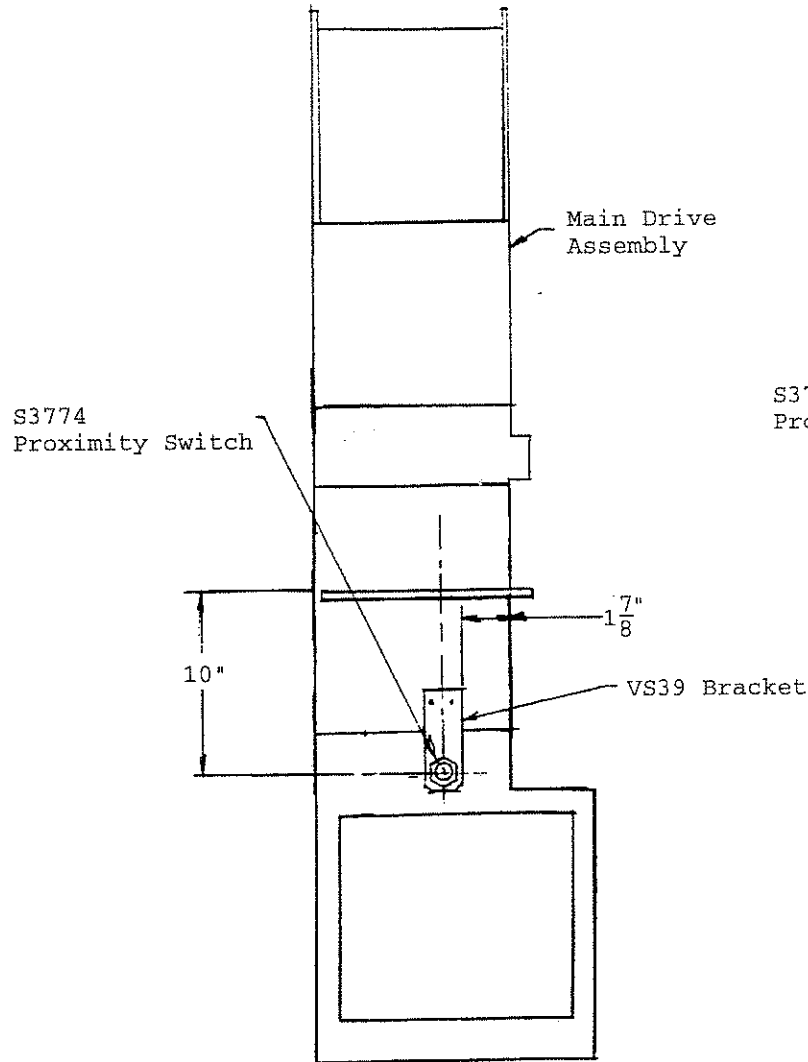


1 13/16" below bottom  
of rack

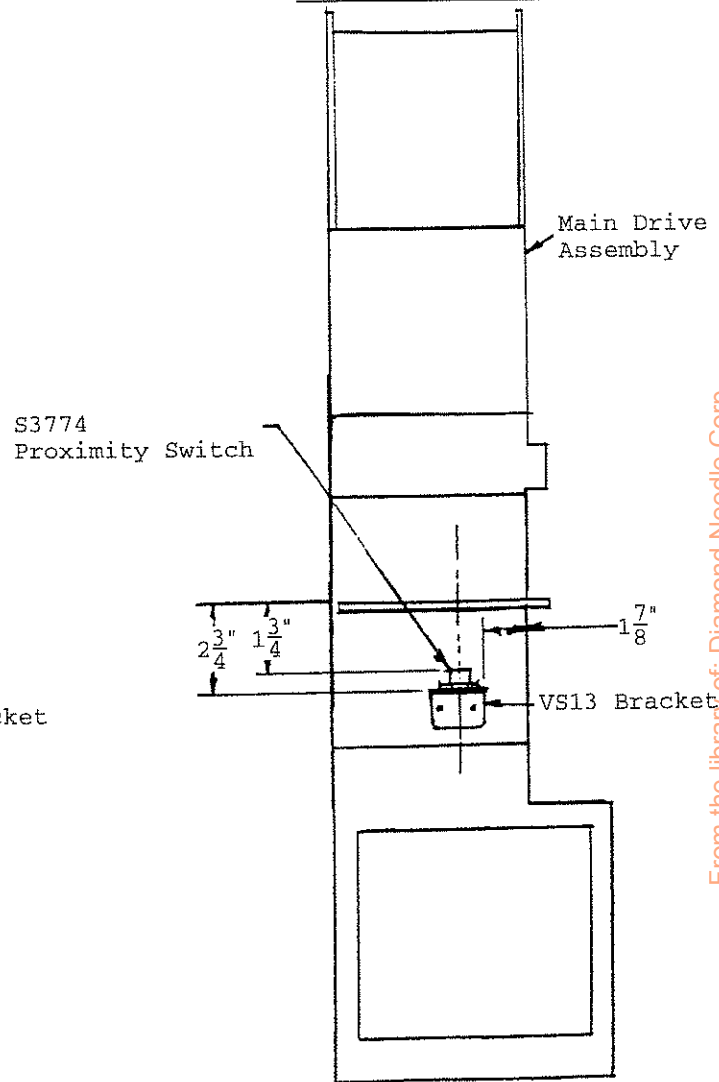
From the library of: Diamond Needle Corp

VARIABLE SPEED DRIVE  
LOCATION OF PROXIMITY  
SWITCH ACTUATOR

Machine Serial No. 2255VS  
and above



Machines prior to  
Serial No. 2255VS



From the library of: Diamond Needle Corp

All measurements are in inches

VARIABLE SPEED DRIVE  
LOCATION OF PROXIMITY  
SWITCH & BRACKET

PLATE 34

TOP VIEW

UTS31 Bracket  
Extension Short  
273 Bolt  
102 Washer  
115 Nut  
3080 Elbow

UTS32 Bracket  
(VS30 for Vari Speed)  
273 Bolt  
102 Washer  
115 Nut

UTS35 Tubing  
1981 Coupling

UTS50 Koil Kord  
(VS31 for Vari Speed)  
1471 Fitting  
1909 Straight Connector

UTS45 Bracket UTS39 Harness  
Assembly

UTS66 Bracket (note 1)  
S3212 Switch (note 2)  
232 Bolt  
115 Nut  
102 Washer  
6657 Screw  
815 Lockwasher  
6360 Nut  
UTS29 Extension  
NR351 Lever Segment  
NR235 Adapter (note 3)  
6526 Set Screw  
3465 Pipe Strap  
for UTS29  
6657 Screw  
815 Lockwasher  
6360 Nut

NR313 Sleeve  
NR303 Bushing

Slip Ring Assembly

NR600 Table Top

4" Min  $\pm \frac{1}{4}$   
9" Max  $\pm \frac{1}{4}$

SIDE VIEW

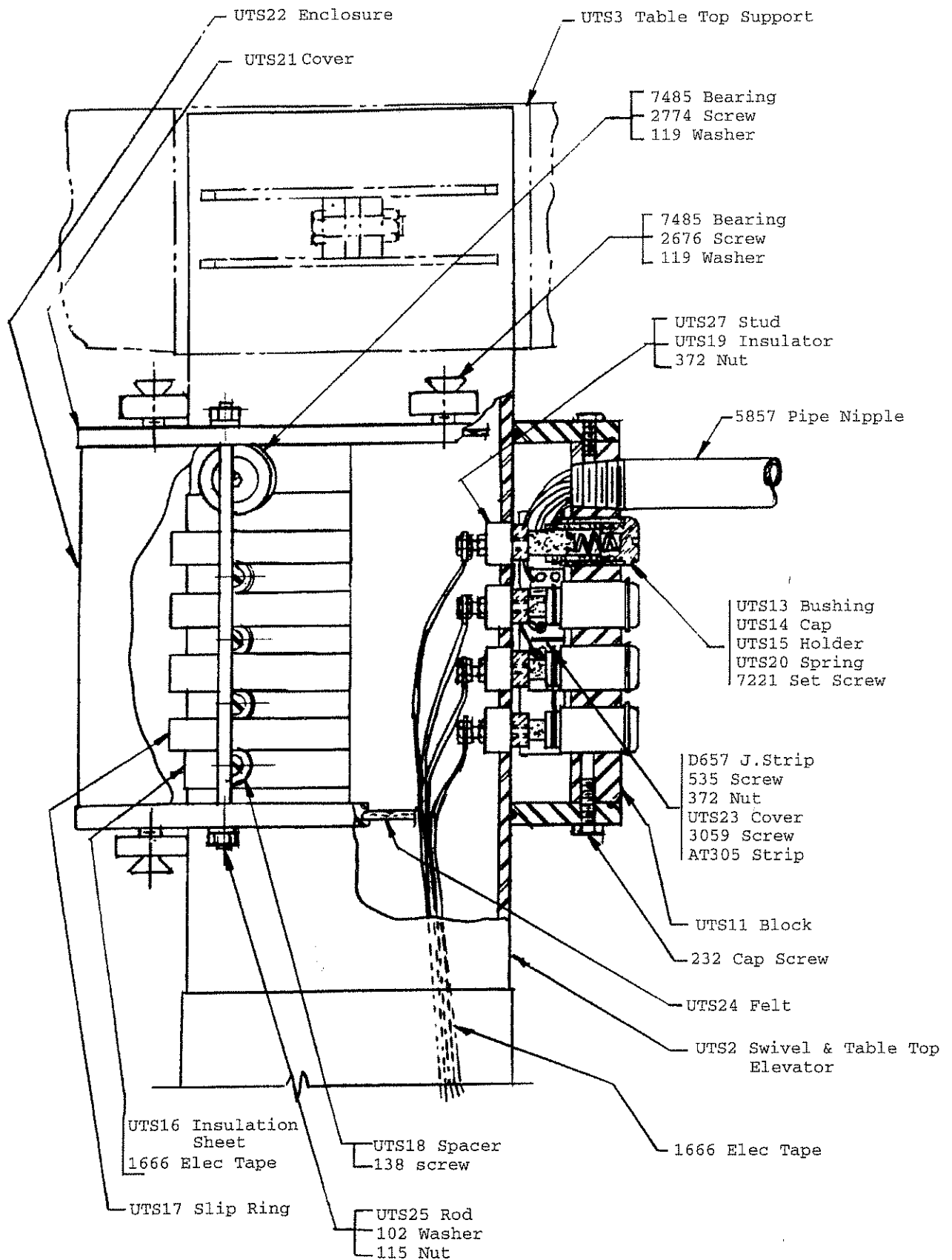
UTS65 Elevating Nut (note 4)  
260 Bolt  
S3871 Nut  
UTS64 Elevating Screw (note 5)

NR303 Bushing  
7245 Bearing  
UTS6 Sprocket Elevating Screw  
6050 Set Screw  
4488 Roll Pin

NOTES

- 1) UTS63 prior to machine # NR2093
- 2) UTS28 prior to machine # NR2021
- 3) 1721 prior to machine # NR2093
- 4) NR235 starts with machine #NR2093
- 5) UTS55 prior to machine # NR2065
- 6) UTS6 prior to machine # NR2065

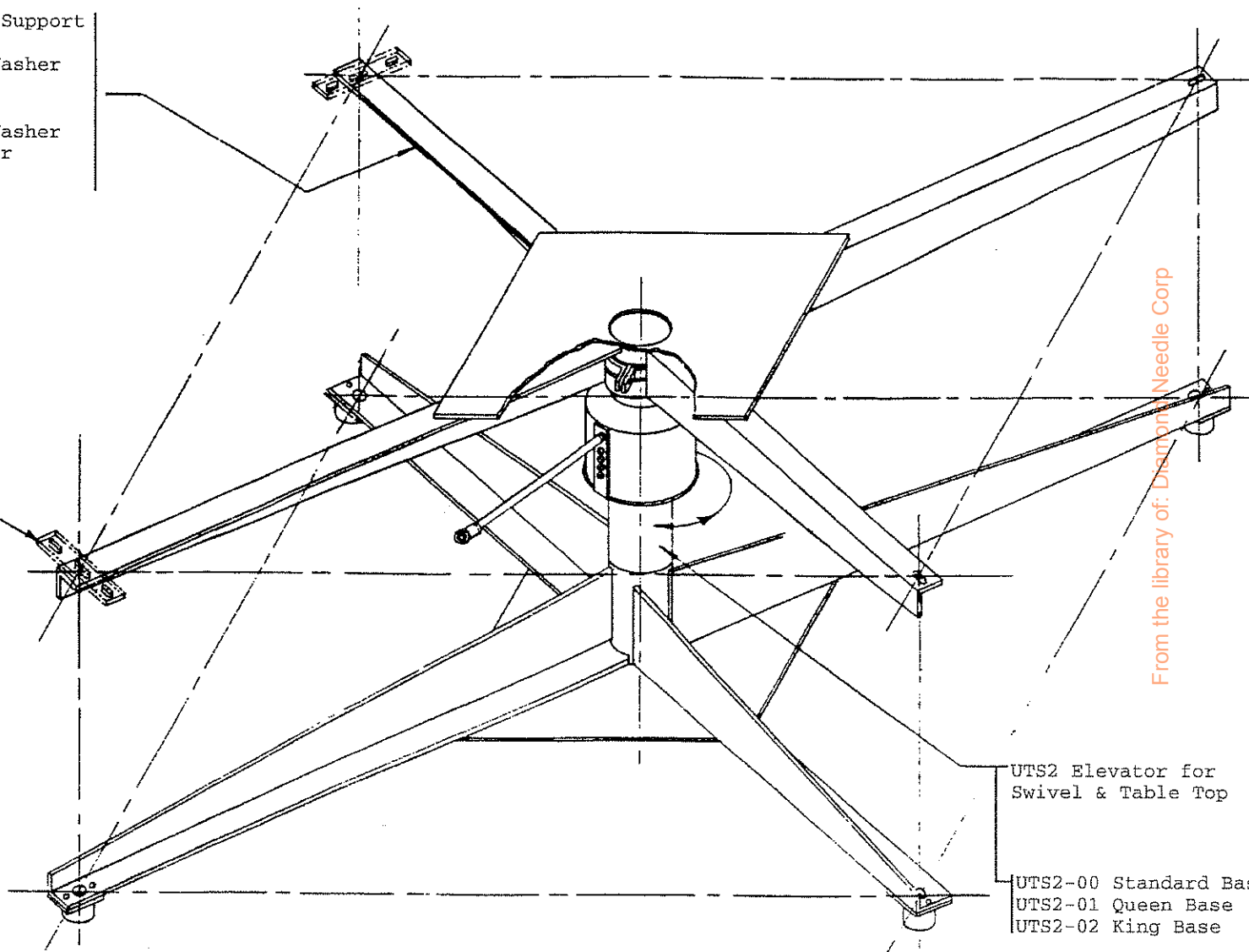
UNDER TABLE SWIVEL  
TOP AND SIDE VIEWS



UNDER TABLE SWIVEL  
SLIP RING ASSEMBLY

UTS 3 Top Support  
 393 Bolt  
 120 Lock Washer  
 109 Nut  
 151 Bolt  
 116 Lock Washer  
 6171 Washer  
 282 Nut

NR601  
 Top Plate for  
 Elevating Screw



From the library of: Diamond Needle Corp

UTS2 Elevator for  
 Swivel & Table Top  
 UTS2-00 Standard Base  
 UTS2-01 Queen Base  
 UTS2-02 King Base

UNDER TABLE SWIVEL  
 ISOMETRIC VIEW

# UNITED MATTRESS MACHINERY PARTS INDEX

Part#	Description	Key	Plate	Part#	Description	Key	Plate
24	Hex Nut	U1119	11	177	Hex Head Cap Screw	U1219	12
66	Round Head Screw	U1204	12	181	1/2 Aero Washer	U1305	13
100	Jam Nut	U1307	13	181	1/2 Aero Washer	U1309	13
101	Screw	U1703	17	181	Washer	U1412	14
102	Lock Washer	U653	6	181	Washer	U1514	15
102	Lock Washer	U867	8	198	Key	U656	6
102	Lock Washer	U1220	12	199	Screw	U1136	11
102	Lock Washer	U1522	15	199	Screw	U1104	11
102	Lock Washer	U1704	17	214	Machine Screw	U1240	12
102	Lock Washer	U1810	18	232	Bolt		35
102	Lock Washer		35	232	Cap Screw		36
102	Lock Washer		35	234	Aero Washer	U1408	14
102	Lock Washer		35	234	Washer	U1436	14
104	Hex Head Cap Screw	U1712	17	260	Bolt		35
105	Washer	U427	4	261	Hex Head Cap Screw	U1823	18
105	Washer	U1566	15	267	Hex Head Cap Screw	U1304	13
106	Nut	U1715	17	270	Nut	U1825	18
107	Washer	U802	8	273	Bolt		35
108	Washer	U414	4	273	Bolt		35
109	Nut	U1557	15	280	Nut		37
109	Nut	U1572	15	282	Nut	U1247	12
109	Nut	U1551	15	282	Nut	U1544	15
109	Nut	U1808	18	283	Bolt	U1308	13
109	Nut		37	302	Hex Head Cap Screw	U1803	18
110	Screw	U1541	15	319	Hex Nut	U1833	18
115	Nut	U1523	15	356	Screw	U1533	15
115	Hex Nut	U1811	18	364	Cap Screw	U1244	12
115	Nut		35	364	Screw	U1243	12
115	Nut		35	364	Machine Screw	U2402	24
115	Nut		35	372	Brass Nut		36
116	Washer	U1247	12	393	Bolt		37
116	Lock Washer	U1542	15	416	Screw	U843	8
116	Lock Washer	U1714	17	428	Oil Plug (replaced by 7032)	U1020	10
116	Lock Washer		37	446	Screw	U854	8
117	Washer	U1504	15	467	Screw (old style)	U823	8
119	Washer	U1233	12	494	Machine Screw	U1202	12
119	Aero Washer	U1577	15	500	Screw	U1247	12
119	Aero Washer		35	500	Round Head Machine Screw	U1324	13
120	Lockwasher	U1556	15	522	Screw	U1238	12
120	Lockwasher	U1718	17	522	Round Head Screw	U1235	12
120	Lockwasher	U1807	18	525	Screw	U1029	10
120	Lock Washer		37	527	Machine Screw	U1240	12
127	Cotter Pin	U419	4	535	Machine Screw		36
127	Cotter Pin	U415	4	617	Coupling	U1906	19
129	Cotter Pin	U1230	12	634	Cap Screw	U1528	15
129	Cotter Pin	U1576	15	648	Lock washer	U1011	10
138	Screw	U1010	10	648	Lock Washer	U2420	24
150	Bolt		37	694	Cap Screw	U1717	17
174	Nut	U1221	12	749	Screw	U401	4

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<u>Part#</u>	<u>Description</u>	<u>Key</u>	<u>Plate</u>	<u>Part#</u>	<u>Description</u>	<u>Key</u>	<u>Plate</u>
749	Screw	U512	5	1635	Collar	U1536	15
749	Screw	U1813	18	1635	Collar	U1568	15
751	Screw	U1001	10	1635	Collar	U1581	15
760	Machine Screw	U819	8	1635	Collar		28
771	Machine Screw	U1547	15	1637	Socket Cap Screw	U1211	12
813	Flat Washer	U1824	18	1638	Socket Flat Head Screw	U1227	12
813	Flat Washer	U1573	15	1638	Screw	U1306	13
815	Washer	U1243	12	1638	Collar		28
815	Lock Washer	U1325	13	1640	Screw	U1555	15
815	Lock Washer	U1814	18	1640	Screw	U1550	15
815	Lock Washer		35	1640	Screw	U1513	15
815	Lock Washer		35	1643	Star Washer	U1503	15
832	Bolt Hex Head		31	1645	Dowel	U1231	12
877	Hex Head Cap Screw	U1806	18	1648	Ball Joint	U416	4
877	Hex Head Cap Screw	U2407	24	1653	Screw	U134	1
889	Screw	U1921	19	1655	Thumbscrew	U834	8
957	Screw	U1918	19	1666	Electrical Tape		36
980	Screw	U1238	12	1711	Machine Screw	U1501	15
1004	Collar	U859	8	1721B	Reversing Switch	U1820	18
1004	Collar	U862	8	1723	Connector	U1904	19
1053	Stop Nut		31	1726	Connector Body	U1903	19
1054	Arm shaft Oil Stop Ball	U706	7	1774	Binder Head Screw	U2410	24
1073	Binder Head Screw	U2411	24	1841	Fillister Head Screw	U2417	24
1075	Roll Pin	U410	4	1854	Bearing	U1114	11
1099	Pin	U1575	15	1854	Bearing	U1143	11
1153	Bearing	U1518	15	1909	Connector		35
1307	Male Connector		30	1911	Screw	U1103	11
1309	Connector Female	U1237	12	1911	Screw	U1133	11
1309	Connector	U1905	19	1921A	Internal parts for switch	U1320	13
1309	Female Connector		30	1981	Coupling		35
1311	Clip (old style)	U825	8	1986	Screw	U1913	19
1318	Oil Gauge	U1018	10	1994	Oval Knob	U1420	14
1367	Oil Cup	U1118	11	2036	Bearing	U1553	15
1471	Fitting		35	2036	Bearing	U1109	11
1542	Retaining Ring	U1016	10	2036	Bearing	U1139	11
1542	Retaining Ring	U1141	11	2036	Bearing	U1511	15
1542	Retaining Ring	U1107	11	2084	Bulb - Bayonet type	U403	4
1542	Retaining Ring	U1111	11	2171	Screw	U2422	24
1542	Retaining Ring	U1137	11	2197	Bearing	U1924	19
1542	Retaining Ring	U1403	14	2306	Screw	U851	8
1542	Retaining Ring	U1411	14	2306	Screw	U849	8
1542	Retaining Ring	U1512	15	2623	Cap Screw	U1528	15
1542	Retaining Ring	U1554	15	2623	Soc Cap Screw	U1563	15
1632	Aero Washer	U1311	13	2625	Screw	U1306	13
1633	Binder Head Screw	U1310	13	2676	Screw		36
1634	Bronze Bushing	U1534	15	2762	Collar		28
1634	Bronze Bushing	U1565	15	2774	Screw		36
1634	Bronze Bushing		28	2989	Oil Seal	U1025	10
1634	Bronze Bushing		28	3059	Machine Screw		36

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Part#	Description	Key	Plate	Part#	Description	Key	Plate
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3100	Set Screw	U1331	13	6287	Jam Nut	U1145	11
3177	Bearing	U1017	10	6315	Screw	U611	6
3465	Pipe Strap		35	6348	Retaining Ring	U1428	14
4488	Roll Pin		35	6353	Bushing	U1060	10A
4784	Screw	U114	1	6360	Nut	U306	3
4784	Screw	U327	3	6360	Nut	U412	4
5108	Plunger	U1520	15	6360	Nut	U1135	11
5396	Relay	U1243	12	6360	Nut	U1105	11
5597	Fuse Block		27	6360	Nut	U1326	13
5711	Screw	U1818	18	6360	Nut	U1548	15
5744	Screw	U1247	12	6360	Nut	U1815	18
5763	Drive pin	U1216	12	6360	Nut		35
5857	Eye Nipple		36	6360	Nut		35
5887	Jam Nut	U1228	12	6375	Washer	U1525	15
5887	Jam Nut	U1212	12	6375	Nut	U1507	15
5887	Jam Nut	U1307	13	6451	Nut	U1911	19
5887	Nut	U1525	15	6451	Nut	U1920	19
5892	Snap Ring		28	6493	Socket Head Screw	U1232	12
5988	Jam Nut	U1330	13	6519	Bolt	U866	8
5988	Jam Nut	U1332	13	6526	Screw	U1561	15
5997	Jam Nut	U1014	10	6526	Set Screw	U219	2
6018	Set Screw	U1413	14	6526	Set Screw	U319	3
6050	Set Screw		35	6526	Screw	U624	6
6067	Check Nut	U1509	15	6526	Screw	U636	6
6067	Check Nut	U1804	18	6526	Screw	U649	6
6067	Check Nut	U2408	24	6526	Screw	U613	6
6067	Check Nut	U2406	24	6526	Screw	U631	6
6083	Screw		28	6526	Screw	U603	6
6137	Screw	U1922	19	6526	Screw	U648	6
6139	Nut	U1122	11	6526	Screw	U913	9
6139	Nut	U1124	11	6526	Screw	U919	9
6171	Flat Washer	U1543	15	6526	Set Screw		35
6171	Flat Washer	U1713	17	6531	Screw	U1561	15
6171	Flat Washer	U1819	18	6531	Screw	U1570	15
6171	Flat Washer		37	6531	Set Screw	U1910	19
6177	Washer	U1241	12	6532	Thumb Screw	U860	8
6197	Lock Washer	U1908	19	6532	Thumb Screw	U863	8
6197	Lock Washer		28	6556	Screw	U1809	18
6205	Screw	U907	9	6574	Screw	U1912	19
6205	Screw		28	6576	Ball	U117	1
6219	Screw	U307	3	6601	Set Screw	U124	1
6219	Socket Head Cap Screw	U2416	24	6645	Screw	U801	8
6243	Screw	U610	6	6645	Screw	U1507	15
6266	Screw	U210	2	6657	Screw		35
6266	Screw	U226	2	6657	Screw		35
6266	Screw	U654	6	6678	Star Washer	U1421	14
6287	Jam Nut	U1101	11	6731	Dowel	U910	9
6287	Jam Nut	U1115	11	6748	Set Screw	U1329	13

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<u>Part#</u>	<u>Description</u>	<u>Key</u>	<u>Plate</u>	<u>Part#</u>	<u>Description</u>	<u>Key</u>	<u>Plate</u>
6753	Screw	U1502	15	D652A	Shaft	U1925	19
6889	Cap Screw	U1521	15	D653	Clamp	U1923	19
6906	Clevis & Pin	U1574	15	D654A	Bushing Insulator	U1915	19
7024	Sealtite	U1416	14	D655	Slip Ring	U1916	19
7024	Sealtite	U1236	12	D656	Cover	U1914	19
7032	Oil Plug	U1020	10	D657	Terminal Block	U1917	19
7032	Oil Plug	U1019	10	D657	Terminal Block		36
7100	Set Screw	U1121	11	D658	Brush - Spring	U1929	19
7100	Set Screw	U1123	11	D659/665	Brush Holder & Wire	U1928	19
7106	5/32 X 1 Roll pin	U1303	13	D659/665	Brush Holder & Wire	U1901	19
7151	Wheel	U1802	18	D660	Cap	U1927	19
7172	Set Screw	U1116	11	D661A	Elbow	U1907	19
7172	Set Screw	U1144	11	D663	16-4 Wire 14'	U1902	19
7172	Screw	U1418	14	D669	Coupling	U1909	19
7177	Roll pin	U1126	11	DBM338	Key	U1516	15
7199	Dowel Pin	U838	8	N691	Clutch Release Handle	U1302	13
7220	Screw	U1004	10	N741	Tape Reel Bracket	U826	8
7221	Screw	U703	7	NR1	Main Frame	U1301	13
7221	Set Screw		36	NR3	Gear Box Housing	U1015	10
7225	Roll pin	U1805	18	NR4	Worm drive Shaft	U1028	10
7230	Fillister Head Screw	U2419	24	NR5	Clutch Ring	U1003	10
7233	Screw	U1517	15	NR5	Female Clutch Ring	U1559	15
7234	Screw	U806	8	NR9	drive Shaft Worm	U1022	10
7245	Bearing	U1829	18	NR9	Male Clutch	U1558	15
7245	Bearing		35	NR12	Sheave	U1562	15
7250	Roll pin	U1507	15	NR14	V-Belt Clutch	U1578	15
7253	Roll pin	U1223	12	NR14E60XY	Thrust Bearing for NR14	U1582	15
7283	Oiler	U1128	11	NR15	Head-Drive Round belt	U1404	14
7333	Locking Screw	U145	1	NR15	Head-Drive Round belt		20
7337	Lock Washer	U1919	19	NR18	Gear Box Cover Plate	U1002	10
7368	Set screw	U1209	12	NR22	Shaft	U1530	15
7485	Bearing	U1102	11	NR23	Sleeve (Bushing) Bronze		
7485	Bearing	U1132	11		Vertical Shaft Sleeve	U1007	10
7485	Bearing		36	NR24	Main Drive Worm Gear		
7485	Bearing		36		Casting	U1006	10
7508	Clip	U824	8	NR25	Spring	U1545	15
8493	V-Belt for Gear box	U1579	15	NR27	Center Pivot Casting	U1125	11
14254	Key	U1580	15	NR30	Center Pivot Roller	U1130	11
14254	Key	U1516	15	NR32	Sleeve	U1127	11
14462	Key	U1031	10	NR33	Washer	U1120	11
14462	Key	U1564	15	NR34	Head Tilt Base	U1225	12
16561	Key	U1005	10	NR35	Head Tilt Pivot Shaft	U1414	14
AT305	Strip		36	NR38A	Head Tilt Screw Shaft	U1205	12
BEE197	Table Foot	U1832	18	NR39A	Head Tilt Nut	U1229	12
BM187	Plate	U1215	12	NR40	Head Tilt Arm	U1210	12
BM257	Key	U1564	15	NR41	Head Tilt link	U1226	12
BM430	Thread Spool Holders	U1217	12	NR42A	Crank	U1208	12
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<u>Part#</u>	<u>Description</u>	<u>Key</u>	<u>Plate</u>	<u>Part#</u>	<u>Description</u>	<u>Key</u>	<u>Plate</u>
NR46.....	Head Belt Adjuster Arm .....	U1549 .....	15	NR110 .....	Sheave.....	U1552.....	15
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NR58.....	Knee Control Spring.....	U1567 .....	15	NR113-01.....	Drive Gear.....	U1515.....	15
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.....	Roller.....	U1424 .....	14	NR120-1.....	Motor 220/440V 3PH 50/60CY... U1429.....	14	
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NR64.....	Corner Cam .....	U1724 .....	17	.....	3PH 220/440V 50/60CY.....	U1430.....	14
NR65.....	Roller-Caster .....	U1110 .....	11	NR120-3.....	Motor 3PH 575V 60CY.....	U1431.....	14
NR65.....	Roller-Caster .....	U1140 .....	11	NR125 .....	Key.....	U1030.....	10
NR66.....	Bracket-Right Guide.....	U1106 .....	11	NR125 .....	Key.....	U1529.....	15
NR67.....	Bracket-Left Guide Roller .....	U1134 .....	11	NR132 .....	Heater.....	U1243.....	12
NR68.....	Spacer-Guide Roller .....	U1108 .....	11	NR133 .....	Receptacle Cover Plate.....	U1239.....	12
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NR69L.....	Caster Wheel Assembly.....	U1147 .....	11	NR140 .....	Tape Reel Bracket Assembly		
NR69R.....	Caster Wheel Assembly.....	U1148 .....	11	.....	(new style).....	U855.....	8
NR70.....	Cap - Gear Box.....	U1012 .....	10	NR143 .....	Tape Reel Disc (new style).....	U864.....	8
NR71.....	Gasket - Gear Box Ca.....	U1013 .....	10	NR144 .....	Tape Reel Bracket (new style).....	U861.....	8
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NR100.....	Tape Weight - Steel.....	U820.....	8	NR181 .....	Sleeve.....	U1021.....	10
NR100.....	Tape Weight - Steel.....	U865.....	8	NR182 .....	Gearbox Cap.....	U1027.....	10
NR101.....	Motor Pivot Shaft.....	U1537.....	15	NR182 .....	Gearbox Cap.....	U1027.....	10
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NR104.....	Knee Rubber Pad.....		28	NR202 .....	Main Frame.....	U1301.....	13
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NR108.....	Full Cover Rear .....	U1319.....	13	NR215 .....	Female Clutch Ring.....	U1559.....	15
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NR231	Clutch Sleeve	U1524	15	NR351-01	Lever - Reversing Switch		21B
NR232	Limit Switch Activator	U1716	17	NR351	Lever Switch Segment		35
NR233	Gear Box Assembly, New Style		10A	NR374	Break Rod Assembly	U1405	14
NR233	Gear Box Assembly, New Style	U1425	14	NR375A	Sheave	U1409	14
NR235	Adapter		35	NR402	Bed Plate	U830	8
NR236	Sheave	U1560	15	NR403	Presser Foot Lift Lever Screw	U509	5
NR237	Table Wiring 110-1ph	U1705	17	NR405J	Shaft	U701	7
NR238	Table Wiring 220V-1ph	U1706	17	NR406	Ball Screw	U707	7
NR239	Table Wiring 220V 60CY 3PH	U1707	17	NR407	Bed Plate Right	U814	8
NR242	Wiring Harness	U1248	12	NR408	Head Sheave (Grooved Pulley)	U702	7
NR243	Harness	U1328	13	NR409	Oiler Plate	U827	8
NR244	Harness	U1318	13	NR409J	Oiler Plate	U827	8
NR245	Wiring Harness	U1222	12	NR410	Cover Plate	U853	8
NR246	Harness	U1322	13	NR411	Sewing head face plate door	U126	1
NR246	Wire Harness	U1415	14	NR411J	Sewing head face plate door	U126	1
NR247	Control Box Harness	U1708	17	NR413	Presser Foot	U135	1
NR248	Reversing Switch Harness	U1709	17	NR414	Side Bed Cover	U833	8
NR249	Lower Limit Switch Harness	U1710	17	NR415	Thread Guard	U837	8
NR250	Raise Limit Switch Harness	U1711	17	NR416	Gasket	U852	8
NR251-00	Electric Box	U1433	14	NR417	Binder Pivot Stud Steel	U811	8
NR251-01	Cover	U1434	14	NR418	Looper Rocker Shaft		
NR259	Control Box Panel	U1720	17		Bushing-Steel	U659	6
NR303	Bushing	U1830	18	NR419	Looper Rocker Shaft	U657	6
NR303	Bushing	U1826	18	NR420	Spreader Bar	U915	9
NR303	Bushing		35	NR421	Feed Dog	U607	6
NR303	Bushing		35	NR423	Feed Dog Adapter	U604	6
NR305	Elevating Screw	U1831	18	NR424	Throat Plate	U805	8
NR308	Reversing Switch Sash Cord	U1816	18	NR425	Presser Foot Lifting Rod	U413	4
NR309	Sprocket	U1828	18	NR426	Lifting Lever	U510	5
NR311	Elevating Screw	U1831	18	NR427	Lift Lever Latch Plate	U511	5
NR312	Sprocket	U1828	18	NR428	Looper Carrier	U645	6
NR313	Elevating Sprocket	U1827	18	NR429	Collar	U218	2
NR313	Sleeve		35	NR429	Collar	U320	3
NR314	Chain	U1722	17	NR429	Collar	U658	6
NR315	Table Elevating Drive			NR429	Collar	U630	6
	Sprocket (On Motor)	U1812	18	NR429	Collar	U634	6
NR316-1	Table Motor 220/440 3ph	U1725	17	NR429	Collar	U619	6
NR316-1	Motor 230/460V 3PH		21B	NR429	Collar	U914	9
NR316-2	Table Motor 115/230 1ph 60cy	U1726	17	NR429	Collar	U920	9
NR316-2	Motor 110V Single Phase		21	NR430	Thread Guide	U832	8
NR316-2	motor 220v Single Phase		21A	NR431	Oil Wick Assembly	U828	8
NR316-3	Table Motor 575v 3ph	U1727	17	NR432	Feed Dog Lifting Shank	U601	6
NR333A	Sheave	U1401	14	NR433A	Vibrating Presser Foot		
NR333A	Sheave	U1510	15		(walking foot)	U146	1
NR333A	Sheave	U1552	15	NR434	Feed Dog Lifting Motion Shaft	U612	6
NR351	Lever-Switch Segment	U1817	18	NR434J	Feed Dog Lifting Motion Shaft	U612	6
NR351-01	Lever-Switch Segment	U1817	18	NR438	Needle Bar Connecting Stud	U106	1

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Part#	Description	Key	Plate	Part#	Description	Key	Plate
NR439	Needle Bar Connecting Link	U104	1	NR506J	Adapter	U426	4
NR440	Looper Holder	U643	6	NR509	Screw	U321	3
NR441	Side Cover Bed Spacer	U835	8	NR511	Binder 1 1/8" 29mm	U809	8
NR443	Long Shaft Collar	U622	6	NR514	Binder 1 1/4" 32mm	U809	8
NR444	Spreader Bar Bearing	U911	9	NR520	Binder 1" 25mm	U809	8
NR445	Felt Washer/oiler	U909	9	NR534	Screw Stud	U317	3
NR446	Spring Spreader Bar Oiler			NR600	Table Top	U1821	18
	Retainer	U908	9	NR600	Table Top		35
NR447	Belt Pulley	U754	7	NR601	Elevating Screw Top Plate	U1822	18
NR448	Small Needle for Plastics	U149	1	NR601	Top Plate for Elevating Screw		37
NR449A	Swing Plate only	U2412	24	NR641	Lifting Eccentric Spacing Collar	U209	2
NR450A	1-3/8 1/2 Binder 36mm	U809	8	NR641	Lifting Eccentric Spacing Collar	U225	2
NR450A	1-3/8 1/2 Binder 36mm	U2424	24	NR701	Flanged Inlet	U1234	12
NR451	Set Screw	U623	6	NR721	Extension Bars Assembly	U1801	18
NR452	Washer	U609	6	NR803	Label Tag	U1213	12
NR457	Piping Support	U2409	24	NR804	Label	U1214	12
NR458	Piping Guide Ring Bracket	U2401	24	NR818	Relay	U1243	12
NR459	Piping Reel Holder Bracket	U2404	24	NR834	Tape Reel Disc	U822	8
NR460	Piping Reel Holder			NR844	Table Weldment	U1835	18
	Bracket Stud	U2405	24	NR848	Caster Arm-Right	U1112	11
NR461	Piping Reel Holder	U2403	24	NR849	Caster Arm-Left	U1146	11
NR465	Piping Attachment		24	NR850	Swing Plate & Tension		
NR465A	Swing Plate	U809	8		Assembly	U858	8
NR465A	Swing Plate	U2412	24	NR870	Frog Assembly	U1417	14
NR466	Feed Driving Rocker Frame	U614	6	NR901J	Cover	U311	3
NR468	Feed Bar Hinge Pin Collar	U617	6	NR903	Sheave	U1560	15
NR469	Spreader	U901	9	NR904	Presser Bar Pressure		
NR470	Standard Needle	U150	1		Cylinder Support	U422	4
NR474	Body-tape Tension	U2418	24	NR907	Lamp Assembly	U402	4
NR475	Plate-Tape Tension	U2414	24	NR940	Feed Bar	U626	6
NR478	Piping Guide Base Pl	U2421	24	NR941	Key	U1529	15
NR480	Piping Guide	U2423	24	NR96A	Shaft	U1506	15
NR481	Bearing	U755	7	S1480	Cap Screw	U1244	12
NR482	Needle Bar	U138	1	S2102	Flange	U526	5
NR484	Thread Guide	U1203	12	S2394	Flange Inlet		30
NR485	Binder Swing Plate Stop	U803	8	S2692	Bearing	U1008	10
NR486	Foot Lifter Lever	U411	4	S2851	Enclosure	U1321	13
NR488	Throat Plate Assembly	U857	8	S3085	Sealtite	U1236	12
NR491	Arm Shaft Timing Pulley	U207	2	S3085	Sealtite	U1242	12
NR494	Belt - Arm Shaft - Timing			S3085	Sealtite	U1245	12
	Assembly	U208	2	S3085	Sealtite	U1317	13
NR496	Swing Plate	U810	8	S3085	Sealtite	U1416	14
NR499	Cover Screw	U831	8	S3143	Bearing	U1024	10
NR499	Cover Screw	U829	8	S3146	Connector Body		30
NR499	Cover Screw	U813	8	S3178	Cam Follower	U1129	11
NR501	Screw	U804	8	S3186	Bearing	U1410	14
NR502	Presser Bar Spring Arm Fulcrum	U308	3	S3186	Bearing	U1402	14
NR505/506J	Piston & Adapter	U425	4	S3193	Spring	U1545	15
NR506	Adapter	U426	4	S3202	Stop Button	U1313	13

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S3204	Contact Block	U1316	13	S3773	Potentiometer		29
S3211	Bulb - Screw type	U403	4	S3774	Proximity Switch		34
S3212	Reversing Switch	U1820	18	S3775	Push Button Switch Green		29
S3212	Reversing Switch		21	S3776	Push Button/Red		29
S3212	Reversing Switch		21A	S3777	Contact Block		29
S3212	Reversing Switch		21B	S3778	Contact Block		29
S3212	Reversing Switch		35	S3780	DC Power Supply		27
S3216	Enclosure	U1719	17	S3780	DC Power Supply		32
S3218	Relay		21B	S3781	Spring		28
S3219	Limit Switch	U1702	17	S3782	Coupling		26
S3219	Limit Switch		21	S3783	Electric Cylinder 24V DC		31
S3219	Limit Switch		21A	S3783	Electric Cylinder 24V DC		32
S3219	Limit Switch		21B	S3784	Electric Cylinder 12V DC		31
S3220	Lever	U1701	17	S3785	Bushing		26
S3220	Lever Arm - Limit switch		21	S3785	Bushing		26
S3220	Lever Arm - Limit Switch		21A	S3786	Bushing		28
S3220	Lever Arm - Limit Switch		21B	S3786	Bushing		28
S3221	Fuse Block		21B	S3787	Spring		28
S3231	Enclosure	U1243	12	S3788	Control		27
S3233	Box	U1315	13	S3790	Drive Belt (98")		20
S3234	Cover	U1312	13	S3791	Housing	U1071	10A
S3236	Fuse Block		21	S3792	Cover	U1051	10A
S3236	Fuse Block		21A	S3793	Bearing Cap	U1064	10A
S3238	Fuse		21B	S3794	Slow Speed Shaft	U1052	10A
S3239	Gear Box Lubricant	U1426	14	S3795	Seal	U1058	10A
S3247	Nut	U2415	24	S3796	Worm Gear	U1053	10A
S3248	Relay		21	S3797	Gear Spacer	U1050	10A
S3261	Relay		21A	S3798	Bearing	U1061	10A
S3265	Fuse		21A	S3799	Worm Shaft	U1069	10A
S3268	Fuse		21	S3800	Front Ball Bearing	U1070	10A
S3285	Motor 1hp 1ph 110v	U1432	14	S3801	Rear Ball Bearing	U1066	10A
S3491	Screw	U1526	15	S3802	Bearing Retainer Rin	U1067	10A
S3541	Flanged Inlet	U1234	12	S3803	Worm Spacer	U1063	10A
S3541	Flanged Inlet		30	S3804	Worm Retainer Ring	U1065	10A
S3542	Connector Body		30	S3805	Oil Seal	U1068	10A
S3549	Shim/Gasket Set	U1062	10A	S3819	Diode Block		27
S3549	Shim/Gasket Set	U1054	10A	S3819	Diode Block		31
S3549	Shim Set	U1427	14	S3819	Diode Block 24V DC		32
S3655	Hard Washer	U1113	11	S3820	Relay 24V DC		27
S3655	Hard Washer	U1142	11	S3821	Relay 24V AC		27
S3691	Coil		21	S3822	Motor Start Switch		30
S3692	Coil		21A	S3826	Needle Bearing	U742	7
S3693	Coil		21B	S3837	Toggle Switch		29
S3769	Zerner Drive Control		27	S3837	Toggle Switch		31
S3770	Transformer		27	S3837	Toggle Switch		32
S3772	Micro Switch		26	S3838	Plate		29
S3772	Micro Switch		28	S3842	Limit Switch		31
S3773	Potentiometer		26	S3842	Limit Switch		32

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S3853	Auxillary Contact		27	S200123	Cap Screw	U744	7
S3854	Fast Start		27	S200125	Screw for NR482	U139	1
S3854	Fast Start		27	S200173	Needle Bar Oiling Felt		
S3867	Thrust Bearing	U1539	15		Holder Screw	U142	1
S3868	Thrust Washer	U1540	15	S200303	Looper driving crank		
S3871	Nut		35		Oil Hole Cover Screw	U715	7
S3901	Drive Belt (108")		20	S200337	Screw	U302	3
S10148	Spring	U847	8	S200342	Balance Wheel Position Screw	U202	2
S20047	Screw	U204	2	S200344	Screw	U112	1
S32572	Flange	U527	5	S200344	Screw	U712	7
S32789	Lifting Rock Shaft Assembly	U326	3	S200346	Screw	U228	2
S32848	Arm Shaft Ball Bearing			S200347	Balance Wheel Lock Screw	U201	2
	Front	U232	2	S200351	Lifting Presser Bar Guide		
S51570	Nut	U530	5		Rod Set Screw	U128	1
S54279	Needle Thread Tension Guide	U522	5	S200362	Set Screw	U309	3
S59537	Spring Bushing	U529	5	S200362	Screw	U616	6
S59539	Stud	U525	5	S200362	Screw	U709	7
S131741	Spring for Needle Thread			S200364	Screw	U303	3
	Tension	U528	5	S200364	Screw	U745	7
S141124	Screw	U327	3	S200364	Set Screw	U917	9
S141338	Screw	U112	1	S200373	Screw	U627	6
S141432	Screw	U845	8	S200373	Screw	U638	6
S141494	Needle Guard Set Screw	U642	6	S200378	Screw	U230	2
S143657	Spring Bushing	U529	5	S200380	Screw	U618	6
S167229	Spring	U812	8	S200380	Screw	U906	9
S200004	Screw	U840	8	S200382	Screw	U732	7
S200047	Screw	U409	4	S200394	Feed Lifting Eccentric Set Screw	U716	7
S200047	Screw	U521	5	S200403	Set Screw	U918	9
S200054	Looper Thread Tube Cover Screw	U517	5	S200417	Screw	U310	3
S200054	Looper Thread Tube Cover Screw	U515	5	S200507	Screw	U808	8
S200056	Screw	U129	1	S200571	Screw	U153	1
S200058	Screw	U316	3	S200573	Screw	U711	7
S200058	Screw	U217	2	S200578	Screw	U505	5
S200058	Screw	U305	3	S200583	Screw	U147	1
S200061	Screw	U113	1	S201052	Cap Set Screw	U501	5
S200061	Set Screw	U738	7	S201063	Screw	U313	3
S200061	Set Screw	U721	7	S201063	Screw	U220	2
S200064	Screw	U749	7	S201160	Screw Eye	U407	4
S200064	Screw	U924	9	S201188	Set Screw for Thread Guide	U107	1
S200066	Screw	U130	1	S201222	Screw	U231	2
S200069	Screw	U108	1	S201222	Screw	U615	6
S200078	Screw	U312	3	S201254	Screw	U123	1
S200082	Needle Thread Guide Screw	U508	5	S201254	Screw	U206	2
S200089	Screw	U660	6	S201254	Screw	U753	7
S200095	Needle Bar Connecting Link			S201256	Screw	U637	6
	Cap Washer Screw	U101	1	S201363	Screw	U417	4
S200098	Hinge Set Screw	U423	4	S201409	Screw	U116	1
S200100	Feed Dog Screw	U606	6	S201418C	Screw	U722	7
S200123	Cap Screw	U227	2	S201522	Nut	U323	3

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Part#	Description	Key	Plate	Part#	Description	Key	Plate
S201522	Nut	U718	7	S267718	Presser Bar Spring Arm Ball		
S201522	Nut	U743	7		Bearing Retainer	U118	1
S201524	Nut	U652	6	S267738	Lever	U429	4
S201526	Nut	U404	4	S267907	Lifting Presser Bar Guide Rod	U132	1
S201537	Nut	U602	6	S267933	Feed Lifting Rock Shaft	U632	6
S201572	Nut	U848	8	S267967	Spreader Driving Crank	U922	9
S204348	Spring	U408	4	S267971	Tension Assembly Complete	U524	5
S204365	Spring	U503	5	S268004	Arm Shaft Ball Bearing		
S204925	Washer	U714	7		(Back) Housing	U205	2
S226206	Releasing Pin	U523	5	S268029	Needle Bearing	U144	1
S240245	Cotter Pin	U818	8	S268029	Needle Bearing	U742	7
S241763	Packing Brass	U238	2	S268032	Face Plate Lock Spring	U152	1
S241763	Packing Brass	U251	2	S268033	Pin	U127	1
S241763	Packing Brass	U246	2	S268044	Arm Shaft Oil Stop Spring (rear)	U705	7
S241763	Packing Brass	U236	2	S268051	Looper Thread guide	U850	8
S241763	Packing Brass	U733	7	S268052	Looper Thread Take-up Rod	U925	9
S241763	Packing Brass	U728	7	S268060	Connector	U222	2
S244048	Flange Disc	U846	8	S268061	Connector Assembly	U224	2
S259552	Binder	U809	8	S268061	Puller Feed Driving Connection	U741	7
S259552-040	Binder 5/8" 16mm	U809	8	S268064	Lifting Eccentric	U253	2
S259552-11/16	Binder 11/16" 17mm	U809	8	S268064	Lifting Eccentric	U234	2
S259552-3/4	Binder 3/4" 19mm	U809	8	S268064	Lifting Eccentric	U725	7
S259552-056	Binder 7/8" 22mm	U809	8	S268065	Adj. Flange	U242	2
S267110	Bearing	U215	2	S268065	Adjusting Flange	U730	7
S267110	Bearing	U325	3	S268066	Adjusting Flange Spring	U731	7
S267110	Bearing	U315	3	S268070	Feed Driving Rock Shaft	U625	6
S267612	Foot Lifter Crank	U318	3	S268071	Bearing	U633	6
S267617	Lifting Eccentric Connection			S268071	Bearing	U621	6
	Hinge Pin	U109	1	S268071	Bearing	U647	6
S267617	Link Eccentric Connection			S268071	Bearing	U620	6
	Hinge Pin	U214	2	S268071	Bearing	U912	9
S267618	Lifting Eccentric Adjusting			S268071	Bearing	U921	9
	Disc Spring	U244	2	S268074	Feed Driving Connection	U723	7
S267623	Gib	U241	2	S268078	Feed Lifting Link	U629	6
S267623	Gib	U249	2	S268079	Feed Lifting Link Hinge Pin	U628	6
S267623	Gib	U735	7	S268081	Feed Regulating Stud	U815	8
S267626	Lifting Lever Link Stud	U115	1	S268082	Feed Regulating Stud Socket	U817	8
S267627	Lift Lever Link	U110	1	S268102	Looper Driving Crank Oil		
S267628	Presser Bar	U133	1		Hole Cover	U713	7
S267631	Lifting Presser Bar Lifting			S268121	Needle Thread Tension		
	Crank	U120	1		Bracket Spring Collar	U519	5
S267650	Presser Bar Spring Housing			S268121	Needle Thread Tension		
	Retainer	U421	4		Bracket Spring Collar	U841	8
S267657	Vibrating Presser Bar	U137	1	S268123	Looper Thread Tube	U513	5
S267658	Vibrating Presser Bar Hinge Stud	U136	1	S268124	Looper Thread Tube Cover	U516	5
S267665	Loop Deflector for Feed Dog	U608	6	S268124	Looper Thread Tube Cover	U514	5
S267704	Foot Lifter Lever Rod	U420	4	S268139	Needle Bar Connecting		
S267707	Needle Thread Tension				Link Cap Washer	U102	1
	Releasing Plate	U406	4	S268144	Needle Bar Oiling Felt	U140	1

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S268167	Needle Thread Tension Bracket	U520	5	S350524	Screw	U418	4
S268168	Needle Thread Tension Release	U518	5	S350548	Screw	U248	2
S268190	Spreader Driving Pin	U916	9	S350548	Screw	U736	7
S268197	Face Plate Lock Spring Plate	U151	1	S350548	Screw	U243	2
S268208	Looper Carrier Crank Hinge Pin	U650	6	S350552	Screw	U605	6
S268216	Looper Driving Connection			S350604	Screw	U123	1
	Assembler	U651	6	S374098	Screw	U736	7
S268219	Needle Bar Rock Frame			S374098	Screw	U243	2
	Thread Guide	U148	1	S374099	Screw	U712	7
S268220	Thrust Washer	U752	7	S374362	Screw	U220	2
S268265	Bed Shaft Oil Control			S412011	Spring Collar	U737	7
	Rod (Wood)	U704	7	S414501	Screw	U637	6
S268278	Needle Bar Sealing Felt Holder	U141	1	S414509	Screw	U217	2
S268308	Looper Carrier Crank			S414509	Screw	U316	3
	Clamping Stud	U662	6	S414509	Screw	U305	3
S268310	Needle Guide	U640	6	S414511	Screw	U113	1
S268312	Needle Thread Guide			S414511	Screw	U108	1
	(On Arm Head)	U506	5	S414511	Set Screw	U721	7
S268330	Stud for Face Plate	U125	1	S414511	Set Screw	U738	7
S268331	Plate	U842	8	S414512	Screw	U130	1
S268332	Tension Assembly for 300W	U856	8	S414514	Needle Thread Guide Screw	U508	5
S268333	Frame Guide	U844	8	S414516	Screw	U129	1
S268373	Thread guide	U836	8	S414516	Screw	U660	6
S268380	Looper with screws			S414518	Feed Dog Screw	U606	6
	(no needle guard)	U641	6	S414522	Needle Bar Oiling Felt		
S268382	Looper	U639	6		Holder Screw	U142	1
S268492	Lifting Eccentric			S414525	Balance Wheel Lock Screw	U201	2
	Connection	U212	2	S414526	Balance Wheel Position Screw	U202	2
S268493	Lifting Eccentric			S414527	Screw	U302	3
	Connection Assembly	U213	2	S414528	Screw	U745	7
S268506	Thread Guide for Top Arm	U504	5	S414528	Screw	U749	7
S268512	Thread Guide			S414529	Screw	U226	2
	(On Needle Bar Stud)	U105	1	S414529	Screw	U210	2
S268513	Thread Guide	U507	5	S414529	Screw	U618	6
S270026	Feed Regulating Stud Spring	U816	8	S414529	Screw	U906	9
S270266	Bearing for NR439	U103	1	S414530	Screw	U310	3
S350149	Screw	U903	9	S414534	Screw	U153	1
S350267	Looper Holder Screw	U655	6	S414536	Screw	U711	7
S350466	Screw Stud	U747	7	S414537	Screw	U505	5
S350467	Screw	U726	7	S414539	Screw	U147	1
S350467	Screw	U250	2	S414543	Screw	U220	2
S350467	Screw	U235	2	S414543	Screw	U313	3
S350477	Set Screw	U252	2	S414545	Set Screw for Thread Guide	U107	1
S350477	Set Screw	U239	2	S414546	Screw	U206	2
S350477	Set Screw	U237	2	S414546	Screw	U753	7
S350477	Set Screw	U247	2	S414548	Screw	U116	1
S350477	Set Screw	U729	7	S414549	Screw	U722	7
S350477	Set Screw	U734	7	S414552	Screw	U903	9



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S414553	Looper Holder Screw	U655	6	S415187	Spreader Driving Eccentric	U751	7
S414555	Screw	U235	2	S415190	Spreader Driving Eccentric		
S414555	Screw	U250	2		Counter Balance	U750	7
S414555	Screw	U726	7	S415194	Spreader Driving Crank	U922	9
S414557	Set Screw	U252	2	S415196	Spreader Bar Holder	U905	9
S414557	Set Screw	U247	2	S415204	Feed Lifting Crank	U635	6
S414557	Set Screw	U239	2	S415206	Crank	U720	7
S414557	Set Screw	U237	2	S415210	Feed Lifting Eccentric	U717	7
S414557	Set Screw	U729	7	S415213	Feed Driving Rock Shaft Crank	U739	7
S414557	Set Screw	U734	7	S415252	Needle Thread Tension		
S414558	Screw	U644	6		Releaser Cap	U502	5
S414559	Screw	U605	6	S415255	Plate	U842	8
S414563	Looper driving crank			S415292	Looper Carrier Crank		
	Oil Hole Cover Screw	U715	7		Clamping Stud	U662	6
S414566	Screw Stud	U317	3	S415294	Tension Assembly	U856	8
S414567	Screw	U430	4	S415329	Assembly Crank for Looper	U708	7
S414567	Screw	U428	4	S415333	Presser Bar Crank Assembly	U121	1
S414570	Screw Eye	U407	4				
S414575	Screw Stud	U747	7	S415342	Looper Thread Tube Cover	U514	5
S414577	Screw	U418	4	S415342	Looper Thread Tube Cover	U516	5
S414578	Ball Screw	U707	7	S415344	Needle Bar Rocker Frame	U143	1
S414639	Looper Thread Tube Cover Screw	U515	5	S415357	Needle Thread Tension		
					Releaser	U518	5
S414639	Looper Thread Tube Cover Screw	U517	5	S415361	Screw	U840	8
S415059	Lifting Presser Bar Guide Block	U131	1	S415368	Needle Bearing	U223	2
S415061	Lifting Crank	U111	1	S415368	Needle Bearing	U211	2
S415067	Lifting Lever	U119	1	S415369	Face Plate Lock Spring Plate	U151	1
S415069	Lifting Eccentric Connection			S415373	Hinge Stud	U324	3
	Crank	U216	2	S415373	Hinge Stud	U719	7
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