



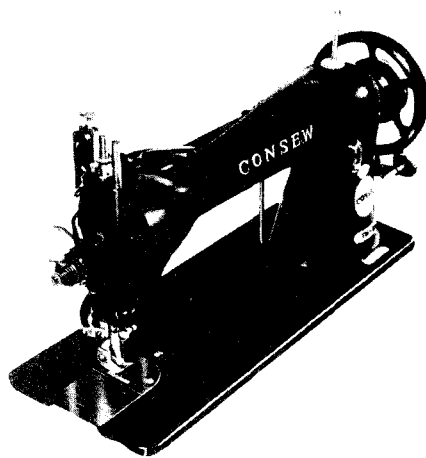
CONSOLIDATED SEWING MACHINE CORP.

— INDUSTRIAL SEWING & CUTTING EQUIPMENT

**OPERATING INSTRUCTIONS  
and PARTS LIST**

for

**CONSEW MODELS 18 and 118  
INDUSTRIAL SEWING MACHINES**



*CONSOLIDATED SEWING MACHINE*

Oiling must be done at least twice daily when the machine is in continuous operation to assure free-running and durability of the operating parts.

**NOTE**—During the breaking-in period a new machine should be oiled more frequently.

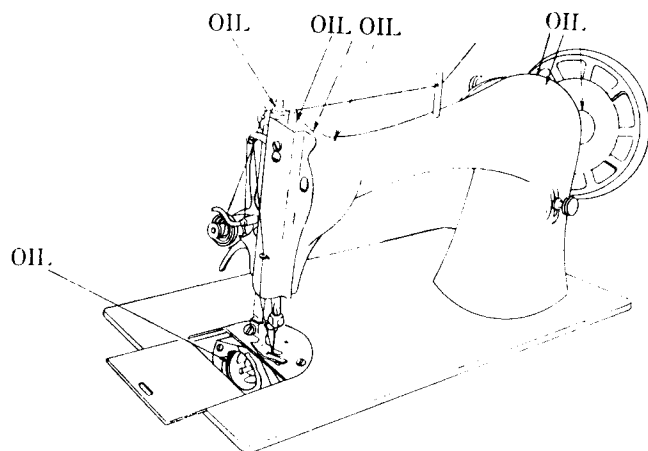


Fig. 1

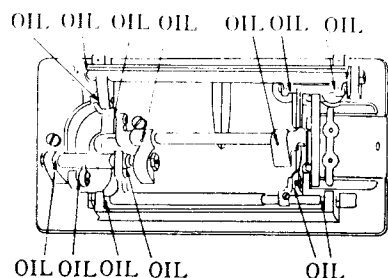


Fig. 2

### NEEDLE AND THREAD SELECTION

Consew Model 18 machines use standard styles 16×63 needles for sewing cloth and 16×64 for leather and plastics ranging in sizes from 14 to 25. The thickness of the sewing thread, which must pass freely through the eye of the needle, determines the size of the needle.

### SETTING UP THE MACHINE

Carefully unpack machine from packing case and make sure that all small parts and accessories are removed from packing material.

Wipe machine clean of protective grease and lubricate all oil holes with a good grade of sewing machine oil (see below).

The bed of the machine is made to standard dimensions and requires a normal "long arm" table cut-out, size 19"×7-1/8"

### CAPACITY AND SPEED

Consew Model 18 is designed for sewing light and medium-weight materials in cloth, plastics, and leather. It is equipped with independently adjustable upper and lower feeding mechanisms. As a consequence, upper and lower layers of material can be fed slower or faster, as the need arises.

Maximum possible stitch length is 4 stitches per inch.

Maximum operating speed is 1400 stitches per minute, depending of course on the type of material being sewn and its thickness.

To assure durability and trouble-free operation, it is imperative that for the first several weeks of operation the maximum speed is held to no more than 1000 to 1200 stitches in order to allow the parts to become properly broken in.

### DIRECTION OF ROTATION AND OPERATING SUGGESTIONS

In operation, the handwheel of the machine always turns toward the operator. To avoid tangled threads and jamming of the sewing hook, do not turn handwheel otherwise.

Always be sure that there is material between the presser feet and the feed dog when running the machine, particularly when the machine is fully threaded.

The machine will feed the material without your assistance. Therefore, do not pull the fabric as this may cause damage to the needle.

### OILING

Do not operate the machine, even if only for testing, unless it has been properly oiled at every spot requiring lubrication. The arrows on the following illustration indicate these spots.

Remember—uneven, knotted or rough thread impairs the satisfactory sewing performance of your machine.

Only **left** twist thread is to be used for the needle. To test for twist hold a length of thread between thumbs and index fingers of your hands. Turn thread counterclockwise. If it will twist tighter, it has a left twist. If it unravels, it has a right twist.

The bobbin can be wound with either left or right twist thread.

### THREADING THE NEEDLE

From the thread stand lead the thread through hole A in the spool pin on top of the arm and over guide B at rear of the upper end of the face plate. Now run it downward and around between the two tension discs C from the back, then over the wire guide D, and down again through the loop of the check spring E, straight upward through the eye of the take-up lever F from the rear, down again through thread guides G and H and from left to right through the eye of the needle. Pull about two to three inches of thread through the needle's eye before you begin with sewing.

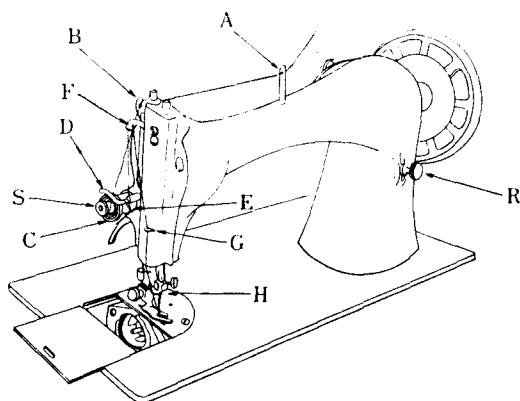


Fig. 3

### REMOVING AND INSERTING THE BOBBIN CASE

Pull out slide plate, lift latch of bobbin case with thumb and forefinger and take bobbin case out of machine. Bobbin will drop out when the open end of the bobbin case is held downward and the latch is released.

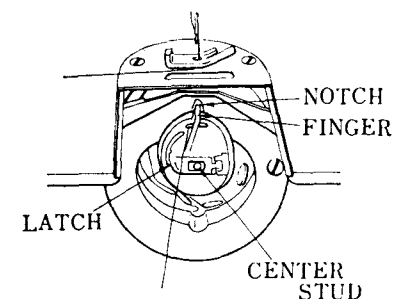


Fig. 4

Take bobbin case by the latch after the full bobbin has been inserted and place it on the center stud of the shuttle. See that the finger of the bobbin case is in line with the notch on top of the shuttle race.

Release the latch and press the bobbin case into the shuttle until the latch catches on the center stud of the shuttle. The bobbin thread should hang down freely about four inches.

### INSERTING A NEW NEEDLE

Turn handwheel toward you until needle has reached the highest point of its travel. Loosen the needle set screw about one turn, pull out the old needle and insert a new one. Push the needle up into the needle bar as far as it will go, setting its long groove toward the left with eye of the needle going from left to right. Tighten needle set screw securely.

### WINDING BOBBINS

The bobbin winder is mounted on the table top with its pulley in front of the driving belt so that the pulley will separate from the belt after the bobbin has been wound with sufficient thread.

Push the bobbin on bobbin winder spindle as far as it will go. Pass thread from thread stand downward through eye in tension bracket; then between and around the back of the tension discs. Bring thread forward toward bobbin and wind from below in clockwise direction several times around bobbin. Push bobbin winder lever downward until wheel contacts the drive belt and start machine. After bobbin is filled with thread, release will cause wheel to

disengage from belt and winding will stop. Cut thread and remove bobbin from winder spindle.

Adjustment screw can be turned in or out to increase or decrease the amount of thread wound on the bobbin.

When fine thread is wound on bobbins, use light tension. It is regulated by turning the knurled nut on the tension bracket at the rear of the bobbin winder. Bobbin can be wound while the machine is sewing.

### THREADING THE BOBBIN CASE

1. Hold bobbin case between thumb and forefinger of left hand, so that the slot in the edge of the bobbin case is on top as shown in Fig. 5.

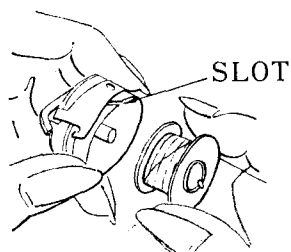


Fig. 5

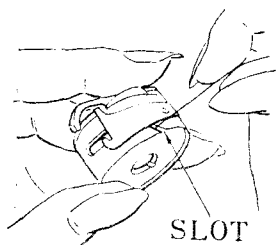


Fig. 6

2. Take the bobbin between thumb and forefinger of right hand so that the thread on top leads from the left to the right, as shown in Fig. 6.

3. Insert bobbin into bobbin case, pull the thread into the slot of the bobbin case as shown in Fig. 6 and then draw it under the tension spring and into the fork-shaped opening of the spring as seen in Fig. 7.

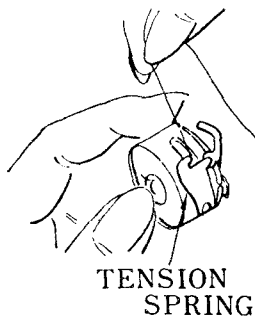


Fig. 7

### ADJUSTING THE STITCH LENGTH

The length of stitch is changed by movement of the knurled knob in the slot at front of the machine frame (Fig. 3). Turn this knob counterclockwise to unlock it and move it downward to lengthen the stitch. To obtain a shorter stitch, move it in upward direction. Lock knob turning it clockwise after the correct length of stitch has been selected.

### SEWING PROCEDURE

Turn the balance wheel towards you with the right hand until the needle moves down and up again to its highest point, thus catching the lower (bobbin) thread. Now pull the end of the upper thread you are holding and the bobbin thread will be brought up with it through the needle hole in the needle plate.

Place both ends of thread back under the presser foot. Place the material to be sewn beneath the presser foot, lower the foot upon it and then start the machine.

### TO REMOVE THE WORK

Raise the needle bar to its highest point; lift the presser foot and draw the fabric back and to the left. Cut the ends of the threads a few inches long from the needle.

### REGULATING THE THREAD TENSIONS

For ordinary stitching, the tension on the upper and lower threads should be equal so as to lock both threads in the center of the fabric.

If the tension on either thread is stronger than on the other, imperfect stitching will be the result. If the tension on the upper thread is greater than that on the lower there it will lie straight along the upper surface of the fabric. If the tension on the lower thread is greater than that on the upper thread, the lower thread will lie straight along the underside of the fabric.

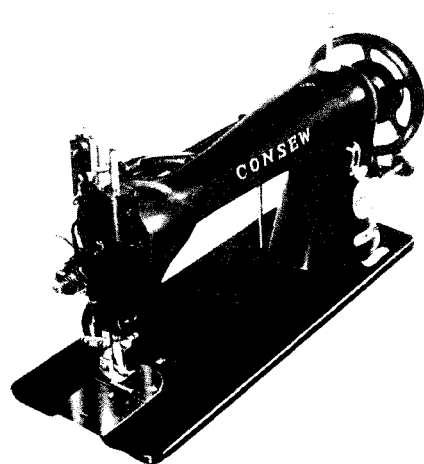
#### A. Tension of the upper (Needle) thread:

Before adjusting the tension of the upper (needle) thread, be certain that the presser foot is let down and not in lifted position. Turn serrated nut 'S'

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|                                       | PAGE |
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| KNEE LIFTER .....                     | 3/7  |
| PRESSER FOOT AND UPPER FEED DOG ..... | 7    |
| PARTS FOR WIDER SEAM .....            | 7    |

The word C stamped at the side of parts  
No. means a complete set of the parts.

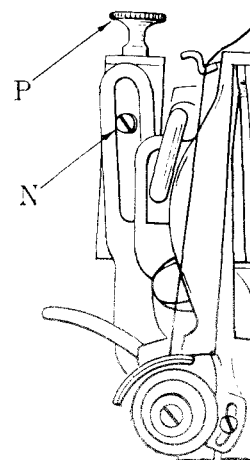


MODEL 18

on tension device to the right to increase tension and to the left, if you desire to decrease it.

### B. Tension of the lower (Bobbin) thread :

Once the tension of the lower (bobbin) thread has been adjusted correctly, it is rarely necessary to adjust it ever again. However, it if should ever require regulation, do so by carefully turning the single screw located at the outside of the bobbin case shell on top of the tongue-shaped curved spring. Turn this screw clockwise no more than 1/4 turn at one time to tighten tension and counterclockwise to loosen it.



### THE UPPER FEEDING MECHANISM

For normal sewing operation the upper feeding mechanism is adjusted to work in synchronism with the feed dog in the bed of the machine. By loosening set screw "N" (Fig. 8) and turning thumb screw "P" clockwise the top layer of material can be fed faster. Turning the thumb screw "P" counter clockwise will feed it slower than the bottom layer. Be sure to tighten set screw "N" after adjustments are made.

Fig. 8

| PARTS NO. | PAGE | NAME                                 |
|-----------|------|--------------------------------------|
| 6004      | 101  | Oscillating rock shaft crank         |
| 6005      | 103  | " " " shaft screw pipe               |
| 6006      | 104  | Lower shaft crank                    |
| 6007      | 104  | " " " slide block                    |
| 6008      | 105  | Lower shaft                          |
| 6009      | 103  | Shuttle driver                       |
| 6010      | 106  | Shuttle race body                    |
| 6010      | 106  | shuttle race complete                |
| 6011      | 106  | Shuttle race back                    |
| 6012      | 106  | " " " " spring                       |
| 6013      | 106  | " " " " screw                        |
| 6014      | 106  | " " " cap spring                     |
| 6015      | 106  | " " " " screw                        |
| 6016      | 106  | " " " body                           |
| 6017      | 106  | Bobbin case                          |
| 6018      | 110  | Bobbin                               |
| 6019      | 105  | Feed rock shaft rocker bar           |
| 6020      | 103  | Feed driven rock shaft crank         |
| 6021      | 101  | Feed base                            |
| 6022      | 105  | Feed lifting rock shaft              |
| 6023      | 103  | " " " " crank                        |
| 6024      | 103  | " " " " roller                       |
| 6025      | 103  | " " " " set screw                    |
| 6026      | 101  | Feed base center screw with nut      |
| 6027      | 103  | Feed rock shaft center screw         |
| 6027      | 103  | Feed lifting rock shaft center screw |
| 6027      | 103  | Center screw with nut(8013) complete |
| 6028      | 101  | Feed dog                             |
| 6029      | 101  | " " " set screw                      |
| 6029      | 109  | Upper feed rod pin set screw         |
| 6030      | 106  | Needle plate                         |

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| PARTS NO. | PAGE | NAME                                    |
|-----------|------|-----------------------------------------|
| 6031      | 106  | Needle plate set screw                  |
| 6033      | 106  | Slide plate                             |
| 6034      | 106  | Oscillating hook slide friction spring  |
| 6035      | 106  | Slide plate spring screw                |
| 6050 C    | 109  | Bobbin winder complete(6051 C & 6052 C) |
| 6051 C    | 109  | Bobbin winder                           |
| 6052 C    | 109  | Bobbin winder spool stand complete      |
| 6053      | 109  | " " " base                              |
| 6054      | 109  | " " " pulley                            |
| 6055      | 109  | " " " spindle                           |
| 6056      | 109  | " " " frame                             |
| 6057      | 109  | " " " stop latch                        |
| 6058      | 109  | " " " frame hinge screw                 |
| 6059      | 109  | " " " " " nut                           |
| 6060      | 109  | " " " " spring                          |
| 6061      | 109  | " " " stop latch hinge screw            |
| 6062      | 109  | " " " pulley set screw                  |
| 6063      | 109  | " " " spool stand                       |
| 6064      | 109  | " " " " pin                             |
| 6065      | 109  | " " " tension screw stud                |
| 6066      | 109  | " " " " disc                            |
| 6067      | 109  | Bobbin winder tension spring            |
| 6068      | 109  | " " " " " regulating thumb nut          |
| 6069      | 109  | " " " " " thread guide                  |
| 6070      | 109  | " " " " screw                           |
| 6071      | 110  | Wrench                                  |
| 6073      | 110  | Scale                                   |
| 6074      | 110  | " " " set screw                         |
| 6075      | 110  | Machine rest pin(wood)                  |
| 6076      | 111  | Machine hinge plate                     |
| 6077      | 111  | Machine hinge connection                |

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| PARTS NO. | PAGE | NAME                                                      |
|-----------|------|-----------------------------------------------------------|
| 6321      | 106  | Thread take up cam                                        |
| 6322      | 106  | " " crank pipe                                            |
| 6323      | 106  | " " " screw                                               |
| 6324      | 102  | " " " "                                                   |
| 6325      | 102  | " " " roller stud                                         |
| 6326      | 102  | " " " " pin                                               |
| 6327      | 106  | Needle bar crank                                          |
| 6328      | 106  | " " connecting stud                                       |
| 6329      | 103  | Needle bar                                                |
| 6330      | 103  | Needle clamp                                              |
| 6331      | 103  | Needle bar thread guide                                   |
| 6332      | 104  | Thread take up lever complete                             |
| 6332      | 104  | Thread take up lever                                      |
| 6333      | 104  | " " " set screw                                           |
| 6334      | 102  | Upright bracket plate                                     |
| 6335      | 102  | Upper feed dog set plate                                  |
| 6336      | 102  | " " " " base                                              |
| 6337      | 102  | " " " " pin                                               |
| 6338      | 102  | " " " bracket                                             |
| 6339      | 102  | " " " " screw                                             |
| 6340      | 102  | Presser bar guide bracket                                 |
| 6341      | 102  | " " " " set screw                                         |
| 6342      | 102  | " " " " roller                                            |
| 6343      | 102  | Presser bar attaching bracket                             |
| 6344      | 102  | " " " " set screw                                         |
| 6345      | 102  | Presser bar lifter & knee lifter connecting rod connector |
| 6346      | 102  | " " " " " pin                                             |
| 6347      | 102  | Upper feed dog set plate connecting plate                 |
| 6348      | 102  | " " " double binding screw                                |
| 6349      | 103  | Middle presser foot                                       |

| PARTS NO. | PAGE | NAME                                    |
|-----------|------|-----------------------------------------|
| 6078      | 111  | Machine hinge plate set screw           |
| 6079      | 111  | Knee lifter complete                    |
| 6080      | 111  | Rock shaft for 6079                     |
| 6081      | 111  | " " hanger                              |
| 6082      | 111  | " " knee arm                            |
| 6083      | 111  | " " " plate                             |
| 6084      | 111  | " " " arm hub                           |
| 6085      | 111  | " " lifting bracket                     |
| 6086      | 111  | " " " " hook                            |
| 6087      | 111  | " " stop dog                            |
| 6088      | 111  | " " knee arm set screw                  |
| 6088      | 111  | " " " plate screw                       |
| 6088      | 111  | " " lifting bracket set screw with hook |
| 6088      | 111  | " " stop dog set screw                  |
| 6090      | 112  | Drip pan                                |
| 6303      |      | Upper feeding rock shaft front metal    |
| 6304      |      | " " " " set screw                       |
| 6305      |      | " " " rear metal                        |
| 6306      |      | " " " base                              |
| 6307      | 103  | Upper feeding rock shaft                |
| 6308      | 104  | Feed cam                                |
| 6309      | 101  | Upper feed forked connection            |
| 6310      | 102  | " " regulator box                       |
| 6311      | 102  | " " " slide stud                        |
| 6313      | 108  | Balance wheel                           |
| 6314      | 102  | Upper feed regulator thumb screw        |
| 6315      | 102  | " " " screw (long)                      |
| 6316      | 102  | " " " receiver                          |
| 6317      | 102  | " " " " set screw                       |
| 6318      | 101  | Upper feed rod                          |
| 6320      | 109  | " " set pin                             |

| PARTS NO. | PAGE | NAME                                  |
|-----------|------|---------------------------------------|
| 6350      | 103  | Upper feed dog                        |
| 6351      | 103  | Presser bar lifting lever             |
| 6352      | 109  | " " set screw                         |
| 6353      | 107  | Face plate                            |
| 6353      | 107  | Face plate complete                   |
| 6354      | 108  | Knee lifter lifting lever             |
| 6355      | 108  | " " hook                              |
| 6356      | 109  | Lifting lever connecting bar          |
| 6356      | 109  | Lifting lever connecting bar complete |
| 6357      | 108  | Arm side cover                        |
| 6358      | 103  | Presser bar thumb screw nut           |
| 6359      | 109  | Lifting lever connecting bar joint    |
| 6360      | 109  | " " " nut                             |
| 6361      | 109  | " " " joint set screw                 |
| 6363      | 109  | Upper shaft screw                     |
| 6365      | 105  | Upper shaft                           |
| 6366      | 106  | Needle bar crank set screw            |
| 6367      | 104  | Knee lifter bell crank body           |
| 6368      | 104  | " " " " pin                           |
| 6369      | 104  | " " " " spring                        |
| 6370      | 104  | " " " set screw                       |
| 6371      |      | Upper feed rod base                   |
| 6372      |      | " " set screw                         |
| 7020      | 104  | Feed regulator body                   |
| 7023      | 107  | Tension spring receiver               |
| 7025      | 107  | Tension thread guide (big)            |
| 7026      | 107  | " " (middle)                          |
| 7027      | 107  | " " (small)                           |
| 7028      | 107  | Thread take up spring                 |
| 7029      | 107  | Tension releasing                     |
| 7030      | 107  | " " pin                               |

| PARTS NO. | PAGE | NAME                                              |
|-----------|------|---------------------------------------------------|
| 8007      | 104  | Feed cam set screw                                |
| 8007      | 104  | Balance wheel screw                               |
| 8008      | 104  | Rear bush                                         |
| 8009      | 104  | " screw                                           |
| 8009      | 108  | Knee lifter lifting lever hook screw              |
| 8010      | 101  | Crank connecting rod                              |
| 8012      | 101  | Oscillating rock shaft crank shaft                |
| 8013      | 101  | " " " nut                                         |
| 8013      | 103  | Feed rock shaft center screw nut                  |
| 8013      | 103  | Oscillating rock shaft crank shaft screw pipe nut |
| 8013      | 103  | Feed lifting rock shaft center screw              |
| 8014      | 101  | Forked rod screw                                  |
| 8014      | 101  | Connecting rod screw                              |
| 8014      | 101  | Feed regulator connecting rod screw               |
| 8020      | 103  | Lower shaft crank pin                             |
| 8020      | 103  | Shuttle driver pin                                |
| 8023      | 106  | Thread take up cam pin                            |
|           |      | Upper feeding rock shaft pin                      |
| 8031      | 107  | Tension spring receiver set screw                 |
| 8031      | 107  | Tension thread guide set screw                    |
| 8031      | 103  | Needle bar thread guide set screw                 |
| 8035      | 104  | Thread take up lever roller with nut              |
| 8036      | 103  | Presser regulating thumb screw                    |
| 8037      | 103  | Presser bar spring                                |
| 8039      | 103  | Presser bar                                       |
| 8040      | 103  | Upper feed dog screw                              |
| 8042      | 104  | Lower shaft crank set screw                       |
| 8053      | 101  | Forked rod                                        |
| 8054      | 104  | Feed regulator connecting rod                     |
| 8056      | 104  | Feed regulator set screw                          |
| 8057      | 104  | " thumb screw                                     |



| PARTS NO. | PAGE | NAME                                   |
|-----------|------|----------------------------------------|
| 8060      | 107  | Tension thread guide set screw(middle) |
| 8060      | 107  | Face plate set screw                   |
| 8076      | 107  | Tension screw stud.                    |
| 8077      | 107  | Tension disc wheel                     |
| 8078      | 107  | Tension spring                         |
| 8079      | 107  | Tension stud nut                       |
| 8086      | 109  | Knee lifter lifting lever hinge screw  |
| 8091      | 106  | Shuttle race set screw                 |
| 8093      | 109  | Arm side cover set screw               |
| 8102      | 109  | Spool pin                              |
| 8104      | 104  | Feed regulator screw washer            |
| 8115      | 110  | Screw driver (big)                     |
| 8116      | 110  | " (small)                              |
| 8119      | 110  | Oil can                                |

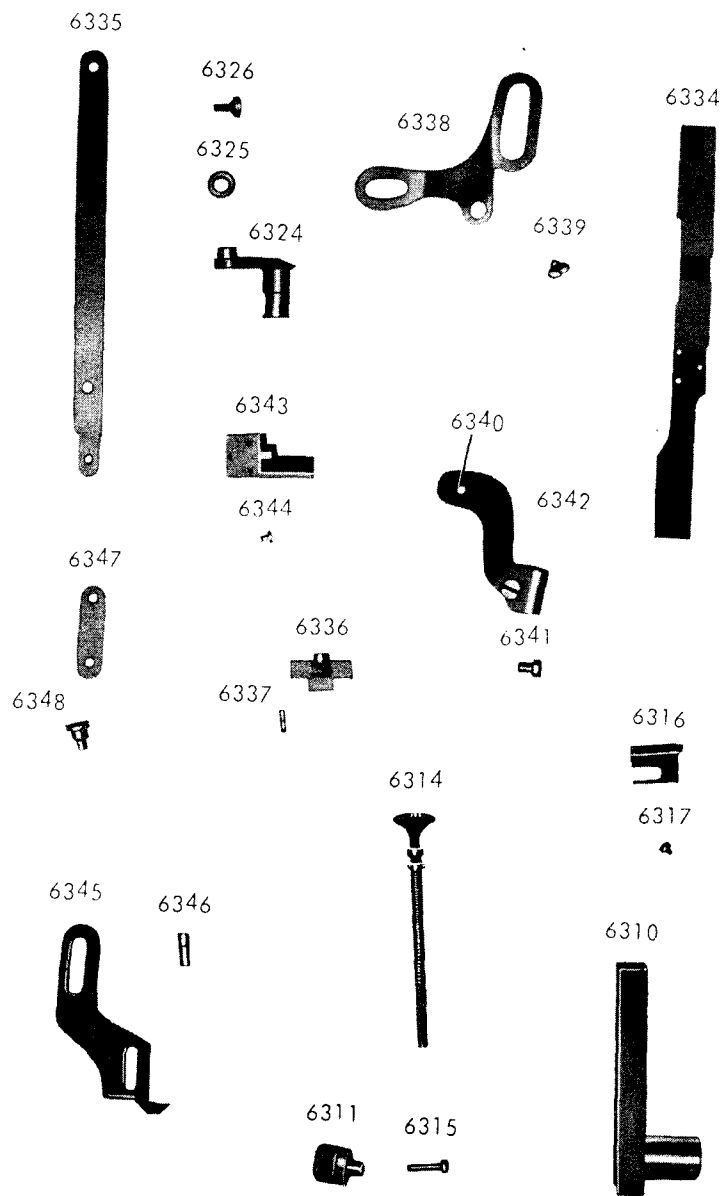
PRESSER FOOT AND FEED DOG (Different size)

|      |     |                                           |
|------|-----|-------------------------------------------|
| 6349 | 113 | Middle presser foot (standard)            |
| 6350 | 113 | Upper feed dog ( " )                      |
| 6349 | 113 | Middle presser foot (bottom 1/8" grooved) |
| 6350 | 113 | Upper feed dog ( " " " )                  |
| 6349 | 113 | Middle presser foot ( " 3/16" " )         |
| 6350 | 113 | Upper feed dog ( " " " )                  |
| 6349 | 113 | Middle presser foot ( " 1/4" " )          |
| 6350 | 113 | Upper feed dog ( " " " )                  |
| 6349 | 113 | Middle presser foot ( " 5/16" " )         |
| 6350 | 113 | Upper feed dog ( " " " )                  |

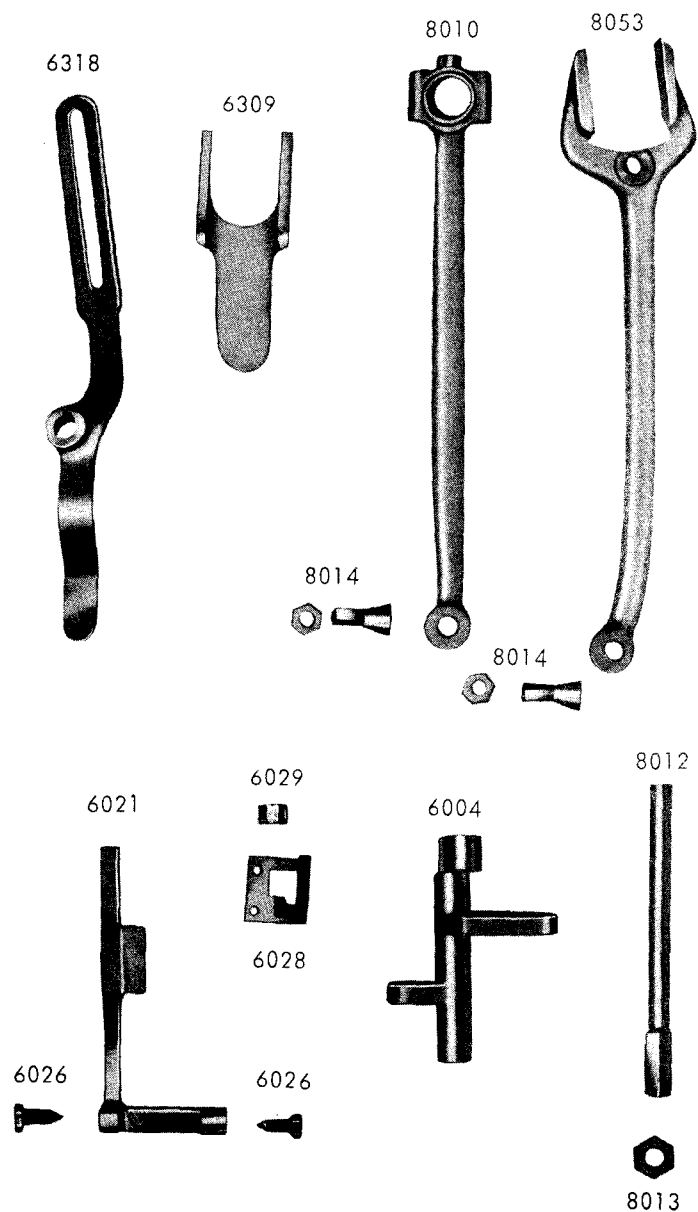
| PARTS NO.                   | PAGE | NAME                                               |
|-----------------------------|------|----------------------------------------------------|
| <u>PARTS FOR WIDER SEAM</u> |      |                                                    |
| 6312                        |      | Upper feed regulator box (instead of 6310)         |
| 6319                        |      | Upper feed rod (instead of 6318)                   |
| 6362                        |      | Upper feed regulator thumb screw (instead of 6314) |
| 6364                        |      | Feed regulator body (instead of 7020)              |

CONTENTS OF ACCESSORIES BOX

|      |     |                    |
|------|-----|--------------------|
| 6071 | 110 | Wrench             |
| 6073 | 110 | Scale              |
| 6074 | 110 | " set screw        |
| 8115 | 110 | Screw driver (big) |
| 8116 | 110 | " (small)          |
| 8119 | 110 | Oil can            |
|      |     | Oil                |
|      |     | Needle 3 pcs.      |
|      |     | Bobbin 3 pcs.      |



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— 101 —

6307



6005



8013



8036



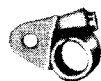
6358



6023



6020



6351



8031



6009



6349



6024



6025



8020



6329



6330



6331



6027



6027

8039



8040



6350



8037



7020



8056



8104



8057



8054



8042

6006



8008



8009



6308



8007



6333



6332

8035



6332

6367



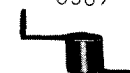
6370



6368

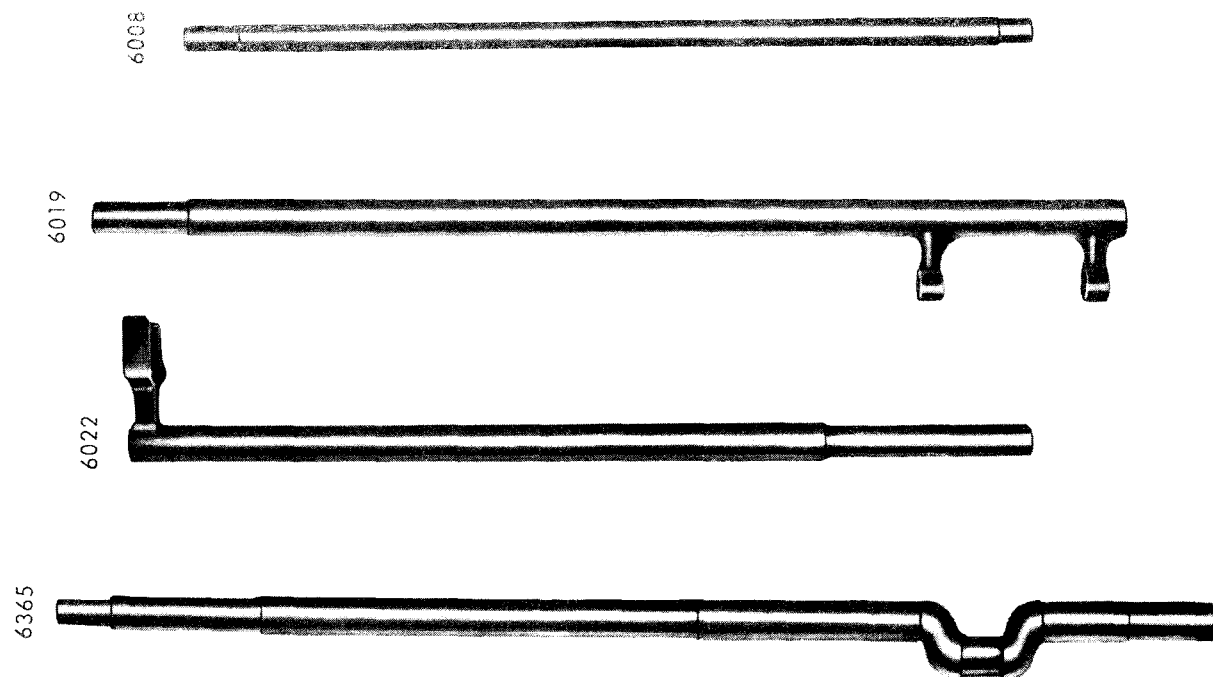


6369

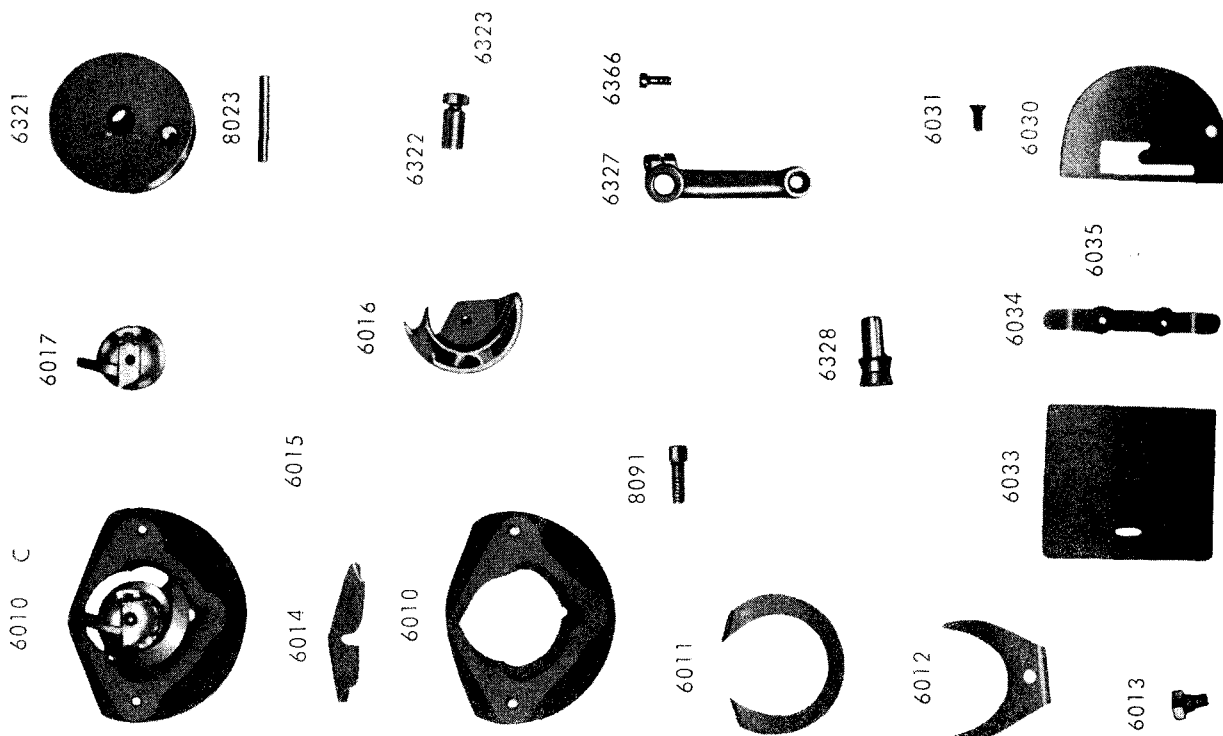


6007



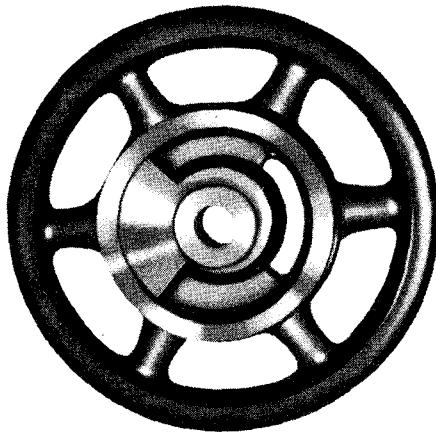


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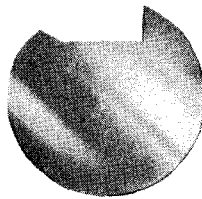


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6313



6357



8009



6355

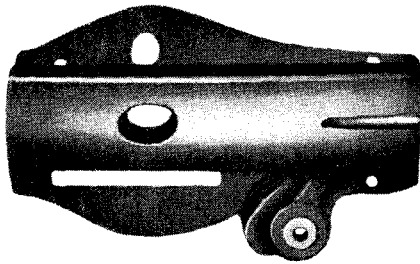


6354



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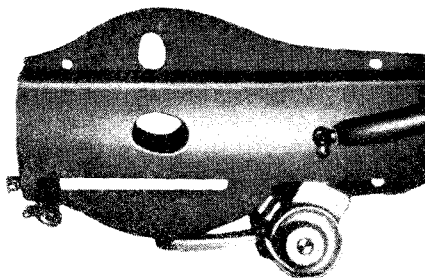
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6353 C



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8116



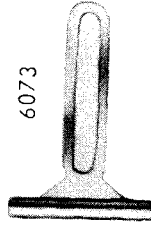
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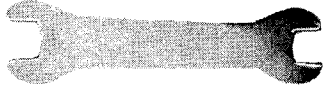
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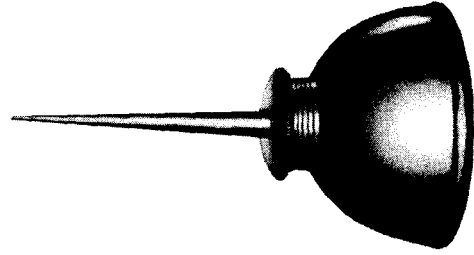
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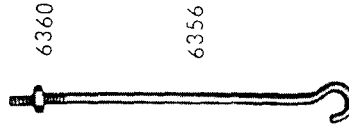
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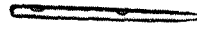
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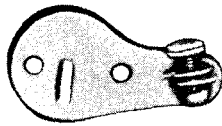
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8086



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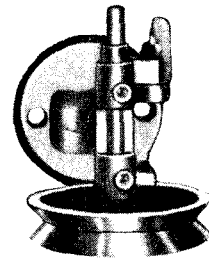


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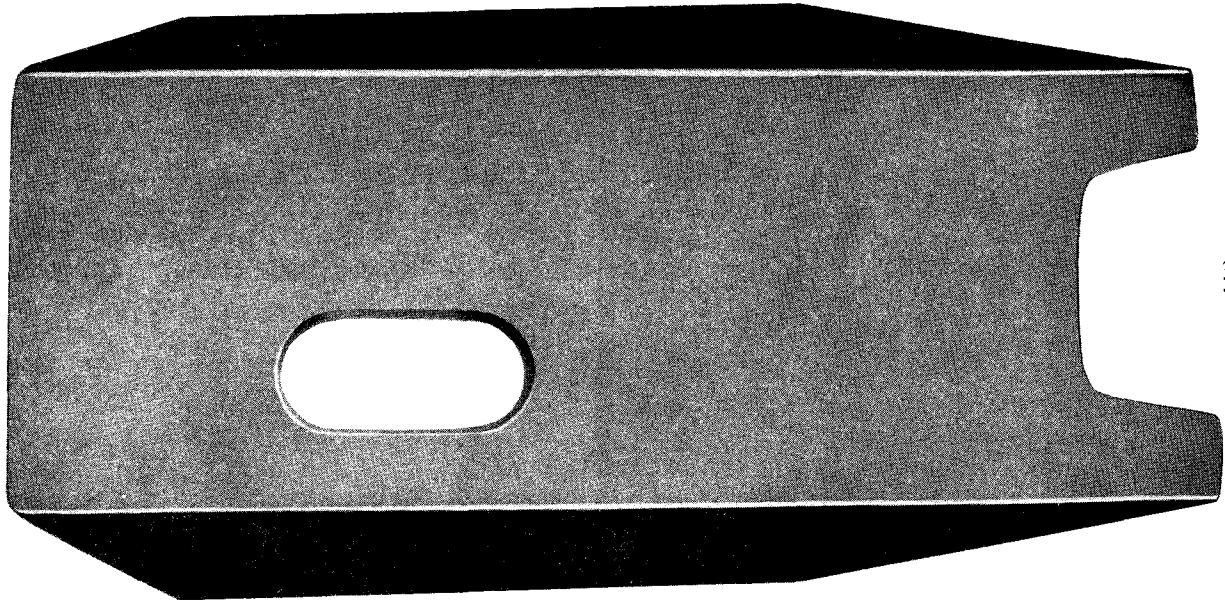
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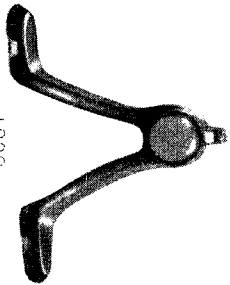
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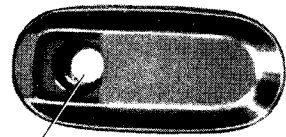
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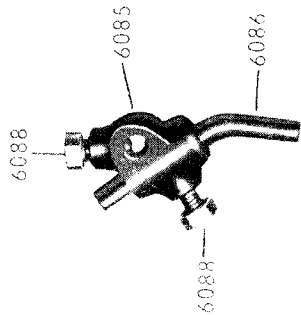


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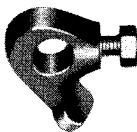
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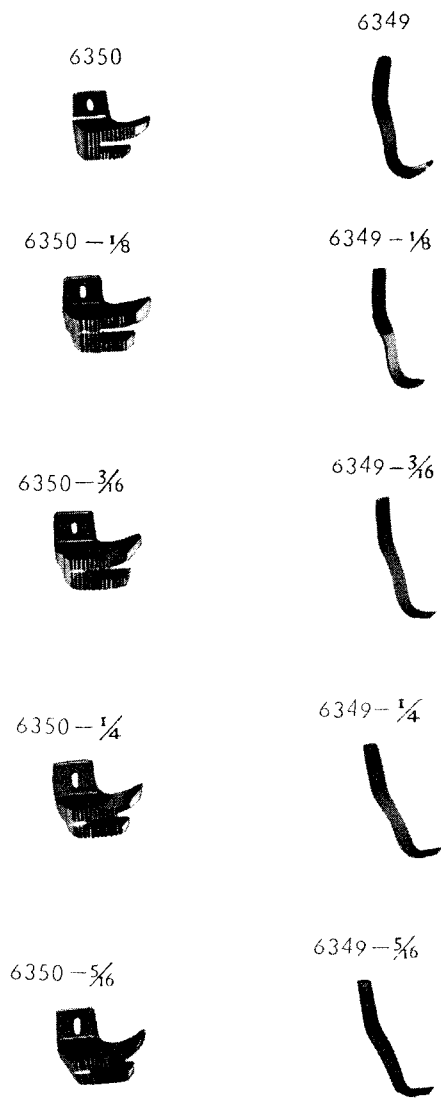
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**PARTS FOR 118 REVERSE FEED**

