



CONSOLIDATED SEWING MACHINE CORPORATION  
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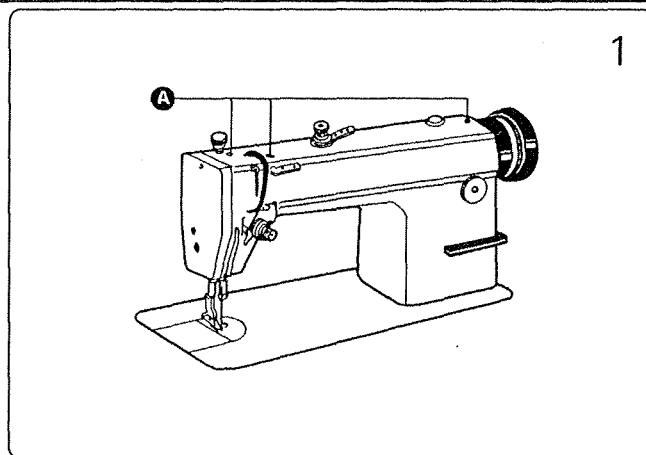
# MODEL

## 315R-2

INSTRUCTION & PARTS MANUAL

## ※NOTE (Fig. 1)

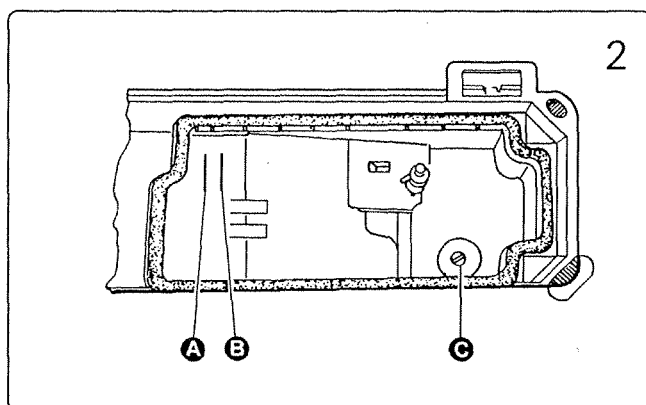
Before putting a new machine into operation, run-in operation is required for a new machine. Remove the rubber plug (A) on the top of arm replenish sufficient amount of oil, then lift the presser foot and run the machine at a low speed of 2000 spm to check oil distributing condition through oil check window. When lubricating is normal, keep the machine run in at this speed for 30 minutes, then increase the running speed gradually, after one month run-in operation, the machine can be run at the Max speed under normal working condition.



## 1. OIL FILLING (Fig. 2)

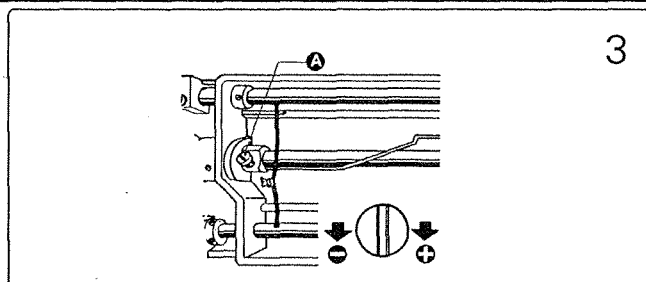
1). The oil amount in the oil reservoir is controlled through the reference marks A and B shown in Fig2. The mark A indicates the max. oil amount level, the mark B for the min. oil amount level. If the oil amount level is under the mark B, replenish the oil reservoir with oil in time.

2). When filling oil, loosen the oil draining screw (C), drain off the remaining oil in the oil reservoir completely, clean the oil reservoir and tighten the oil draining screw (C), then fill the oil reservoir with fresh oil.



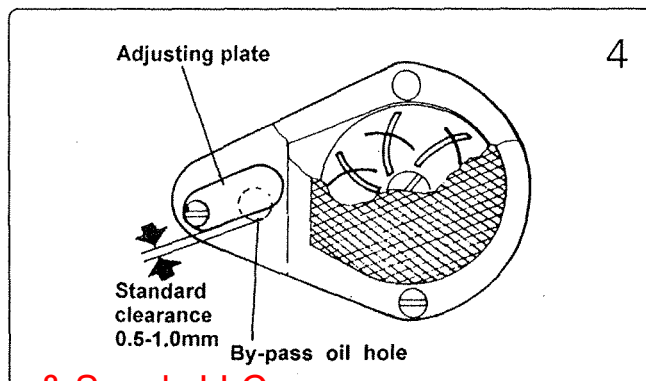
## 2. ROTATING HOOK OIL AMOUNT ADJUSTMENT (Fig. 3)

Adjust the oil amount of the rotating hook by turning the oil amount adjusting screw (A). Turn the screw (A) clockwise (in the "+" direction) to increase the oil amount; turn it counter-clockwise (in the "-" direction) to decrease the oil amount.



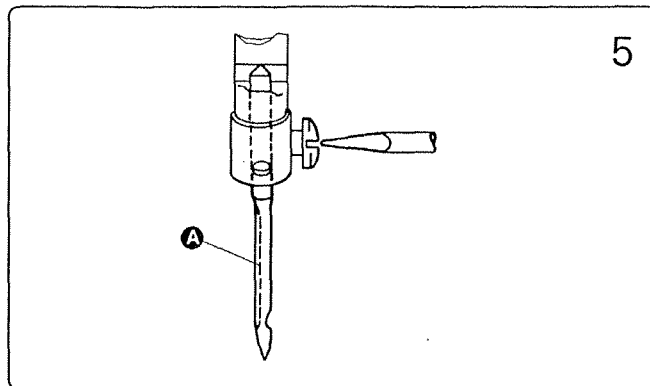
## 3. OIL PUMP ADJUSTMENT (Fig. 4)

In ordinary operation, adjustment is not required for the oil pump. If oil splashing does not occur in the oil check window when the machine runs at a low speed (approx. 2000 spm), close the clearance of the bypass oil hole.



#### 4. NEEDLE INSTALLATION (Fig. 5)

Turning the balance wheel to lift the needle bar to the upper end of its stroke. Loosen the needle clamp screw while keeping the long groove of the needle leftward, fully insert the needle shank up to the bottom of the needle socket, then tighten the needle clamp screw.



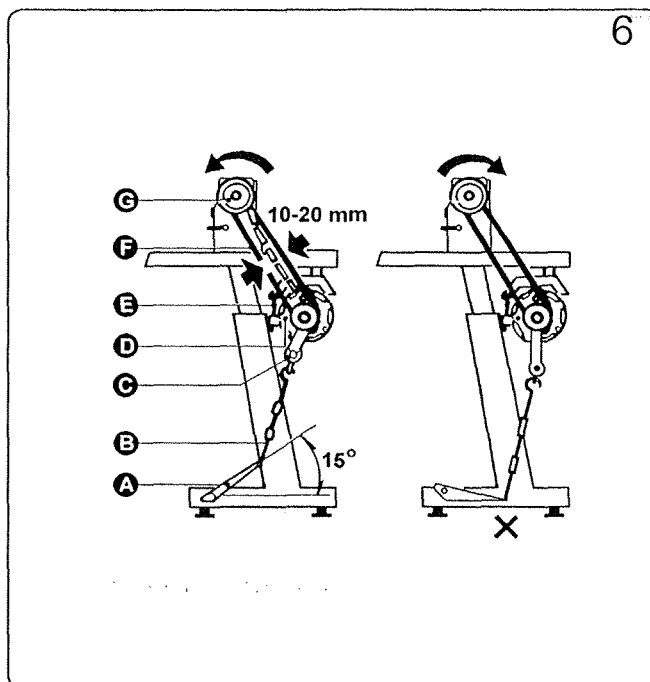
#### 5. CONNECTION OF THE CLUTCH LEVER WITH THE PEDAL (Fig. 6)

1) . The optimum tilt angle of pedal is approximately 15 deg.

2) . Adjust the clutch so that the clutch lever (C) align with the draw bar (B) as shown in Fig. 6

3) . The machine pulley should rotate counter-clockwise when viewed from the outside of it. The rotating direction of the motor pulley can be reversed by turning the plug of the motor at 180 deg.

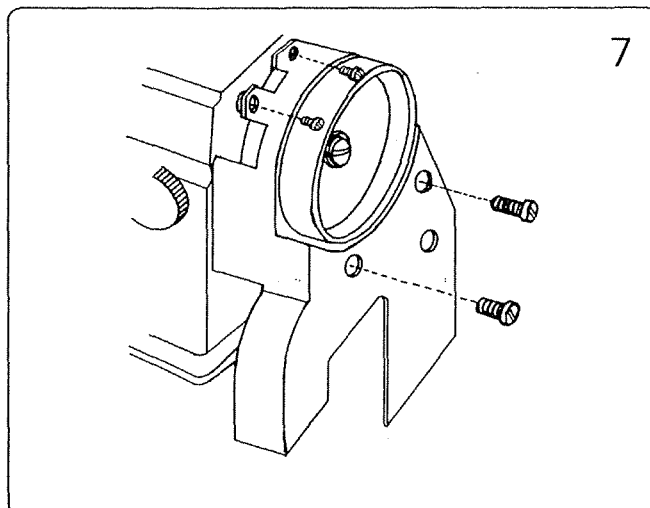
4) . Adjust the tension of O-belt (F) by moving the motor up and down. The proper tension of the O-belt is a slack of 10-20 mm when the belt is depressed at the center of the belt by finger.



#### 6. BELT COVER INSTALLATION (Fig. 7)

Install the belt cover for the sake of safety.

Install belt cover (C) to arm with screw (A) and screw (B), and install belt cover (E) on board with screw (D).

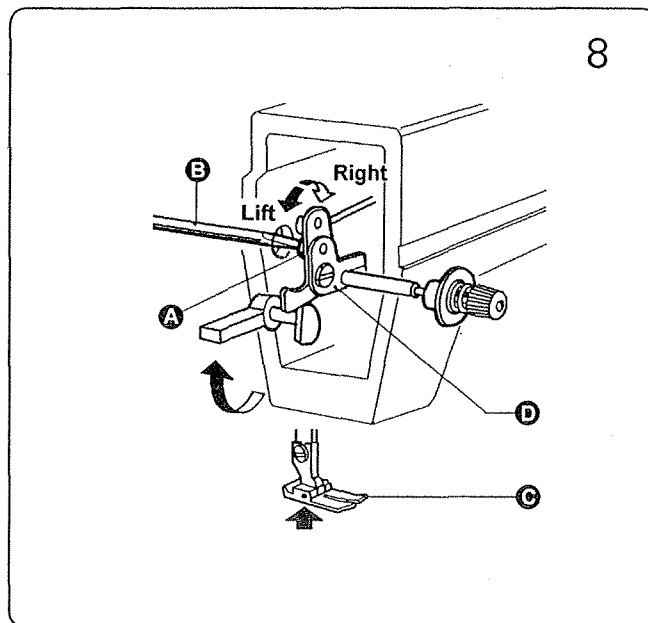


## 7. ADJUST THE OPENING TIME OF THE TENSION DISCS (Fig. 8)

Within the presser foot lift range, the opening time of the tension discs can be adjusted as follows:

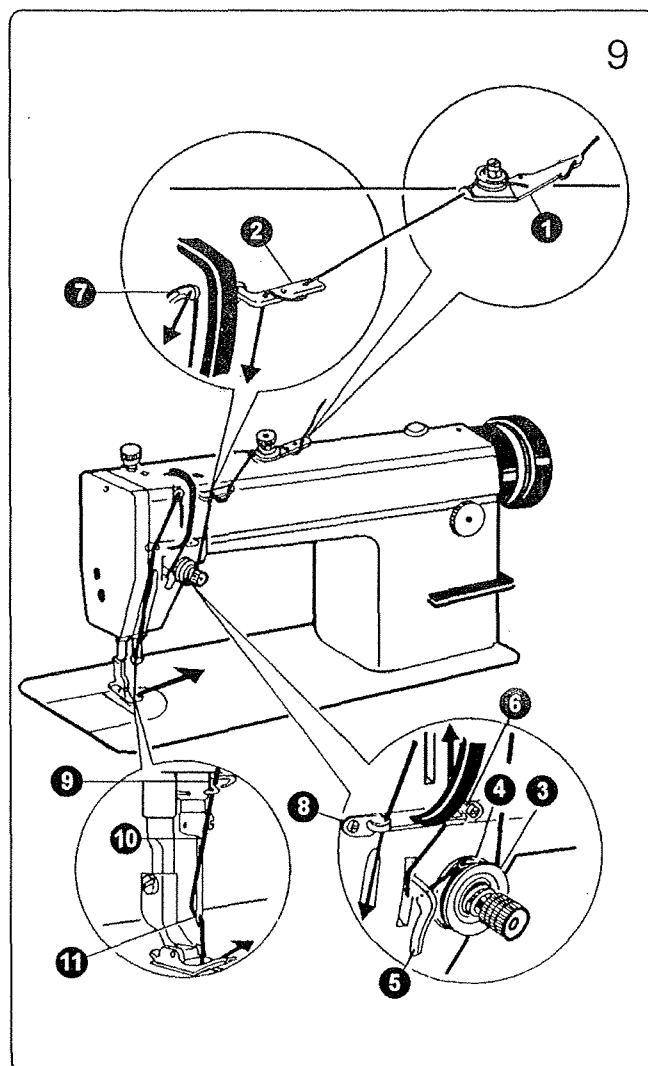
1). Remove the rubber plug from the back of the arm and loosen the screw (A) of the knee lift lever (left).

2). Move the tension releasing cam (D) leftward for earlier opening or rightward for later opening. It will facilitate the adjustment if putting a block under the presser foot lift.



## 8. THREADING (Fig. 9)

To thread the needle thread, raise the needle bar to the upper end of its stroke, lead the thread from the spool and perform threading as shown in Fig. 9. To draw the bobbin thread, hold the end of the needle thread and turn the balance wheel to lower the needle bar and then lift it to its highest position. Pull the ends of needle thread and bobbin thread frontward under presser foot.

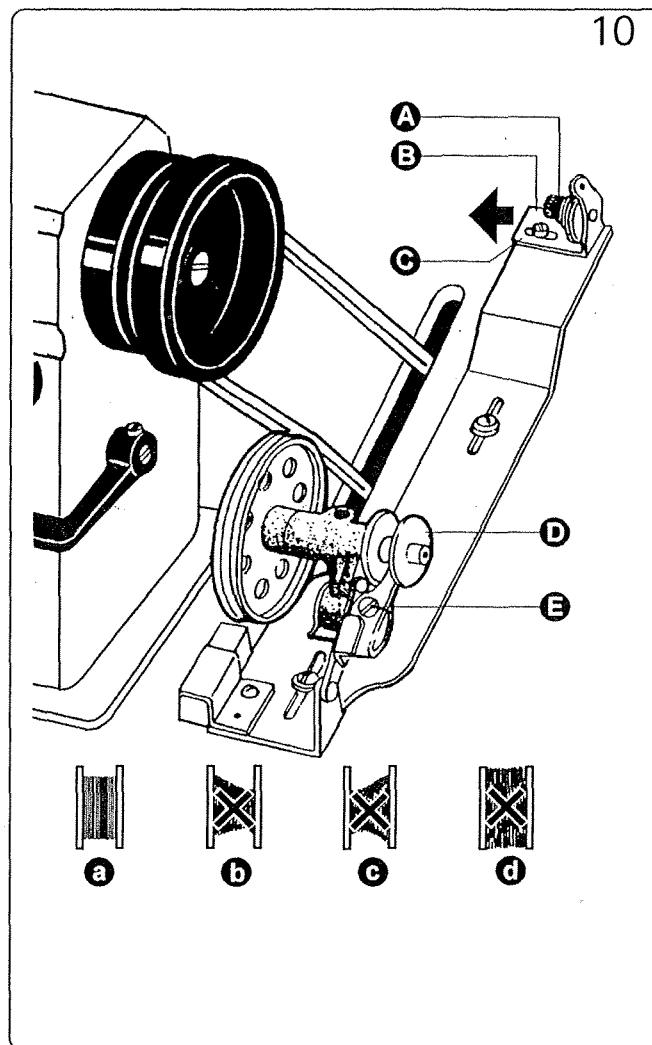


## 9. WINDING INSTALLATION AND ADJUSTMENT (Fig. 10)

The bobbin winder pulley should align with the V-belt and there should be some clearance between them. When the bobbin winder stop latch lever is depressed, the V-belt should be in touch with the bobbin winder pulley in order that the bobbin winder puller can be driven by the V-belt.

The thread wound on the bobbin should be neat and tight. If not tight, adjust the winding tension by turning the tension stud nut (A) of the bobbin winder tension bracket. When the thread wound on the bobbin does not present a cylindrical shape as shown in Fig. 10(a), loosen the set screw (B) of the bobbin winder tension bracket and move the bracket (C) leftward or rightward. If the thread is wound as shown in the figure (b), move the bracket rightward or if wound as shown in the figure (c), move it leftward. After positioning the bracket adequately, tighten the set screw (B).

Do not overfill the bobbin. The optimum wound length of the thread will fill about 80% of the bobbin capacity. This can be adjusted by the screw (E) of the bobbin winder stop latch.

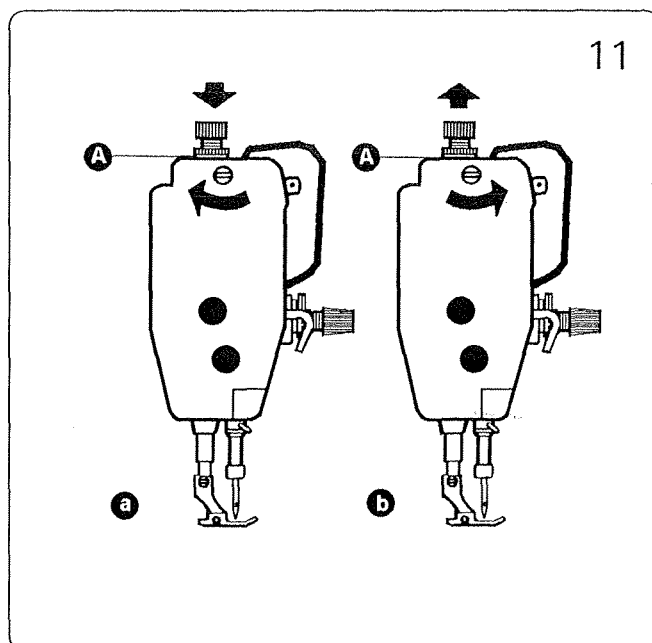


## 10. ADJUST THE PRESSURE OF PRESSER FOOT (Fig. 11)

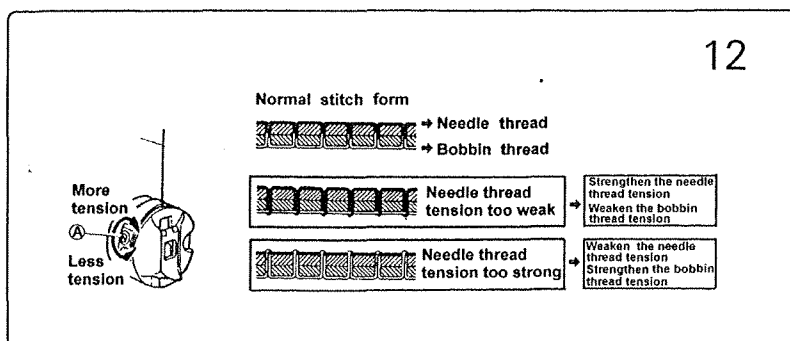
Pressure of the presser foot is adjusted in accordance with thickness of materials to be sewn.

First loosen the lock nut (A), for heavy materials, turn the pressure regulating thumb screw as shown in Fig. 11(a) to increase the pressure, while for light materials, turn the pressure regulating thumb screw as shown in Fig. 11(b) to decrease the pressure, then tighten the lock nut (A).

The pressure of the presser foot is recommended to be less as long as normal feeding is ensured.

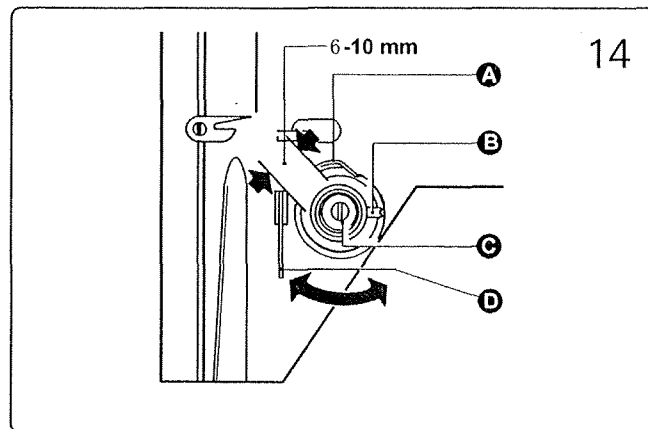
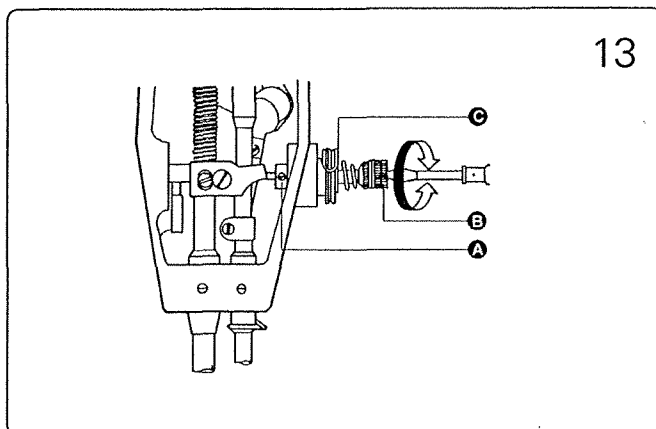


## 11. THREAD TENSION ADJUSTMENT (Fig. 12, 13, 14)



Thread tension should be determined in accordance with the stitches obtained by adjusting the tension of the bobbin thread and needle tension (Fig. 12).

The tension of the bobbin thread: to be adjusted by turning the tension spring regulating screw of the bobbin case. After adjusting, insert the bobbin into the bobbin case and hold the end of the thread from the bobbin case to hang the bobbin case, if the bobbin case falls slowly and evenly, the proper tension of the bobbin thread is obtained.



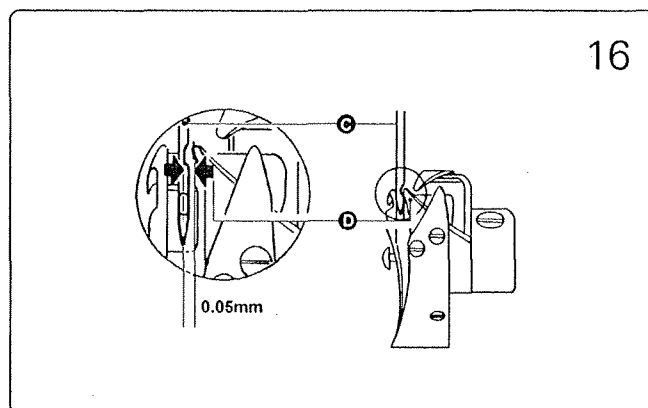
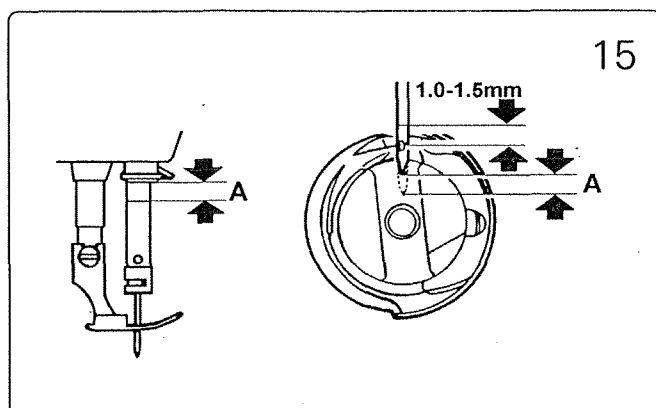
The tension of the needle thread: to be adjusted by turning the thumb nut.

The stroke of the thread take-up spring runs from 6mm to 10mm. When sewing very thin fabrics, reduce the thread take-up spring tension and increase the thread take-up spring stroke, whereas increase the thread take-up spring tension and reduce the thread take-up stroke when sewing very thick fabrics.

Adjusting the thread take-up spring tension: (Fig. 13) First loosen the set screw (A), turn the tension stud (B) counter-clockwise to decrease the tension of the thread take-up spring (C) to zero, then turn the tension stud (B) clockwise till the spring (C) comes to the notch of the tension regulating bushing, and again turn the tension stud (B) half way back (counter-clockwise). After the adjustment, tighten the set screw (A).

Adjusting the thread take-up spring stroke: (Fig. 14) Loosen the set screw (B), turn the stud (C) clockwise to increase the stroke or turn the stud (C) counter-clockwise to decrease the stroke. After the adjustment, tighten the set screw (B).

## 12. ADJUST THE SYNCHRONIZATION OF THE NEEDLE WITH ROTATING HOOK (Fig. 15, 16)



When lifting the needle bar from its lowest position of the stroke to the distance A, the hook point D of the bobbin should align with the center line of the needle and be 1.0 – 1.5 mm above the upper end of the needle eye. (Fig. 15)

The clearance between the bottom of the needle notch and the hook point should be 0.05 mm (Fig. 16).

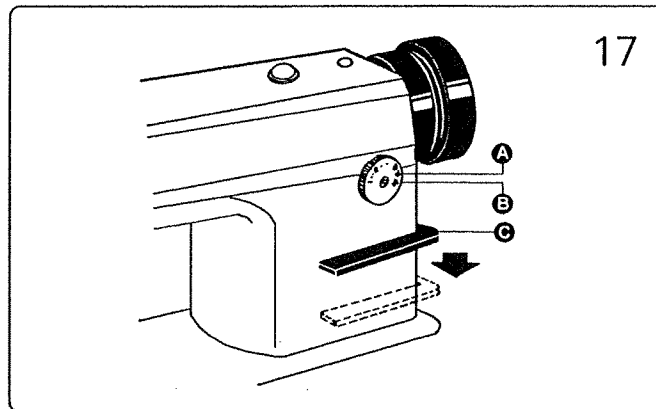
| Model | 6160   | 6160H | 6160B |
|-------|--------|-------|-------|
| A     | 2.2 mm | 2.2mm | 2.4mm |



### 13. ADJUSTMENT OF STITCH LENGTH AND REVERSE FEEDING (Fig. 17)

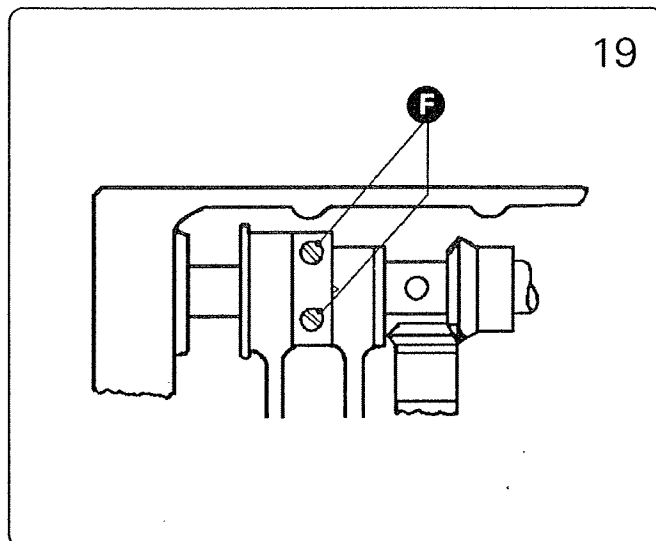
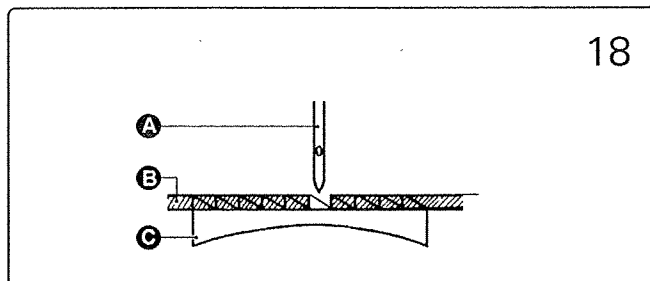
The stitch length can be adjusted by turning the dial (A). The figures on the face (B) of the dial show the stitch length in mm.

The reverse feeding starts when the reverse feed lever (C) is depressed, the machine will feed forward again if the reverse feed lever is released.



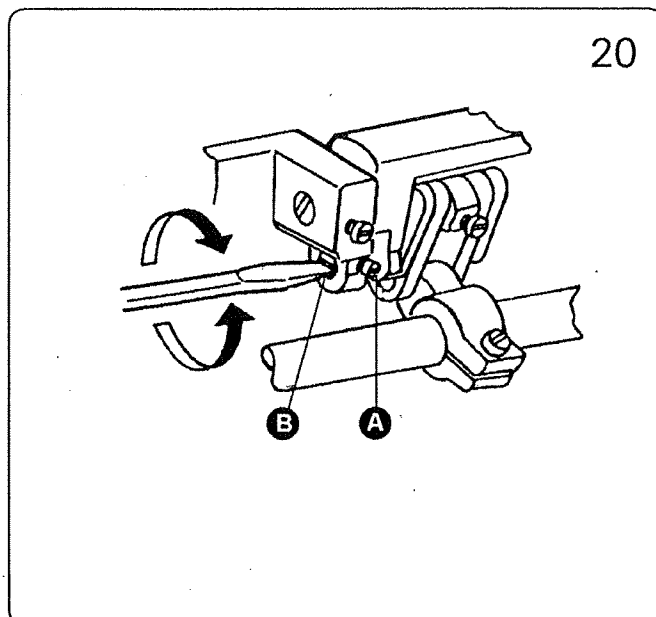
### 14. ADJUST THE SYNECHRONILATION OF THE NEEDLE MOTION WITH FEED MOTION (Fig. 18, 19)

To adjust the feed dog position (C), first should release the two set screw (F) and turn around the balance wheel by hand. When the needle (A) point reaches the surface of the throat plate (B), the top of the feed dog (C) should be flush with the throat plate surface.



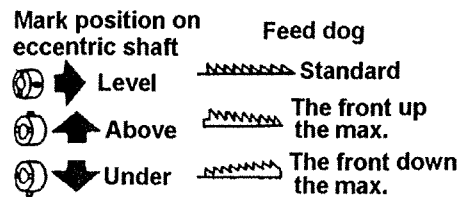
### 15. STITCH LENGTH ERROR ADJUSTMENT (Fig. 20)

Loosen screw (A) to adjust the stitch length adjusting cam (B). Turn it rightward to narrow the stitch length as forward sewing, and widen it as reverse sewing; turn it leftward to widen the stitch length as forward sewing, and narrow it as reverse sewing.



## 16. FEED DOG HORIZONTALITY ADJUSTMENT (Fig. 21)

Heighten the front of feed dog to prevent fabric from wrinkling, lower the front of feed dog to prevent fabric from defection, breaking of hook thread.



## 17. REGULAR CLEANING (Fig. 22. 23. 24)

### 1) Cleaning feed dog

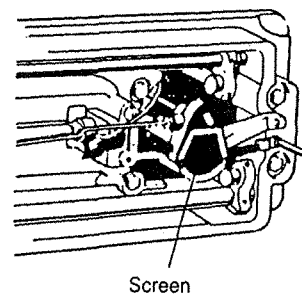
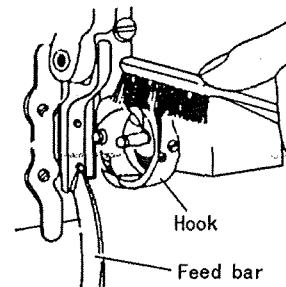
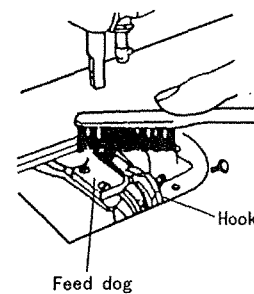
Remove the throat plate and clear off the dust and lint between feed dog tooth slots.

### 2) Cleaning rotating hook

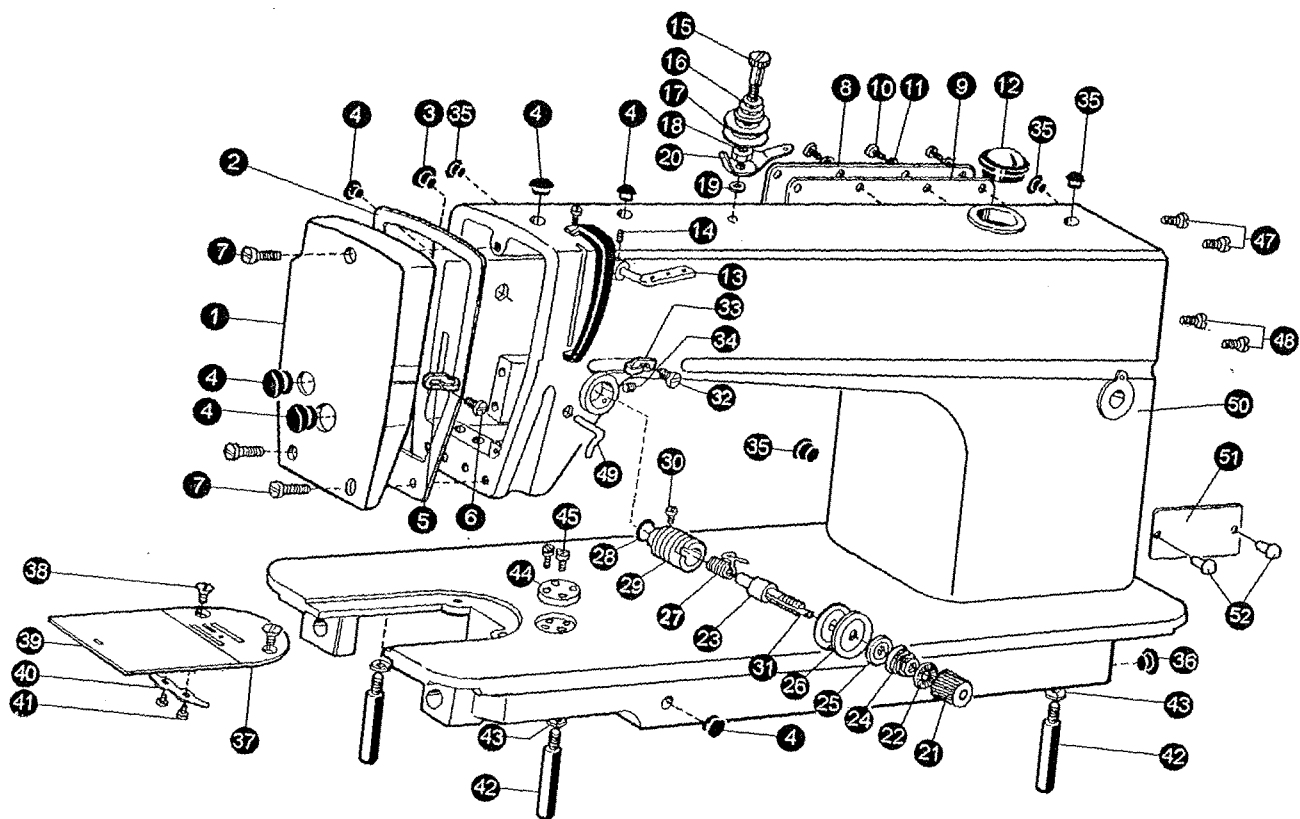
Swing out the machine head and clean the hook. Wipe the bobbin case with soft cloth.

### 3) Cleaning oil pump screen

Swing out the machine head and clear off the dust and dirt on oil pump screen.

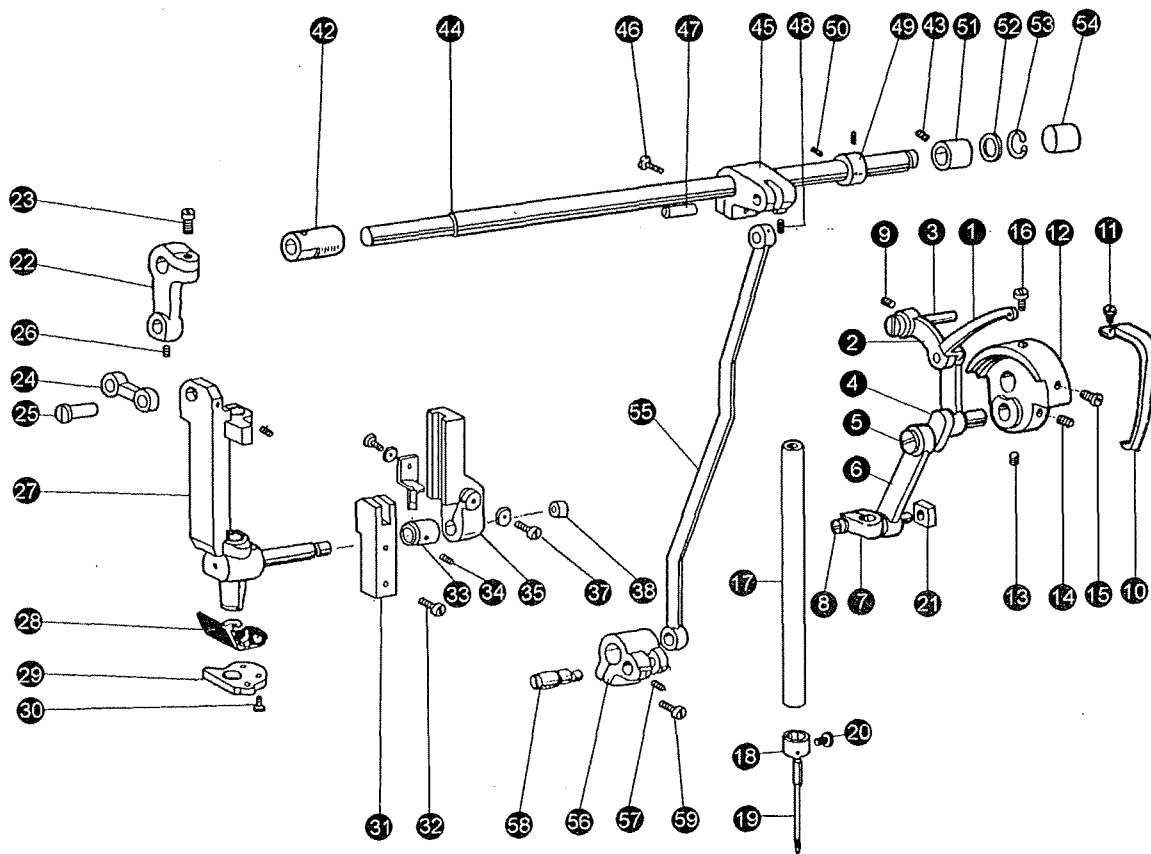






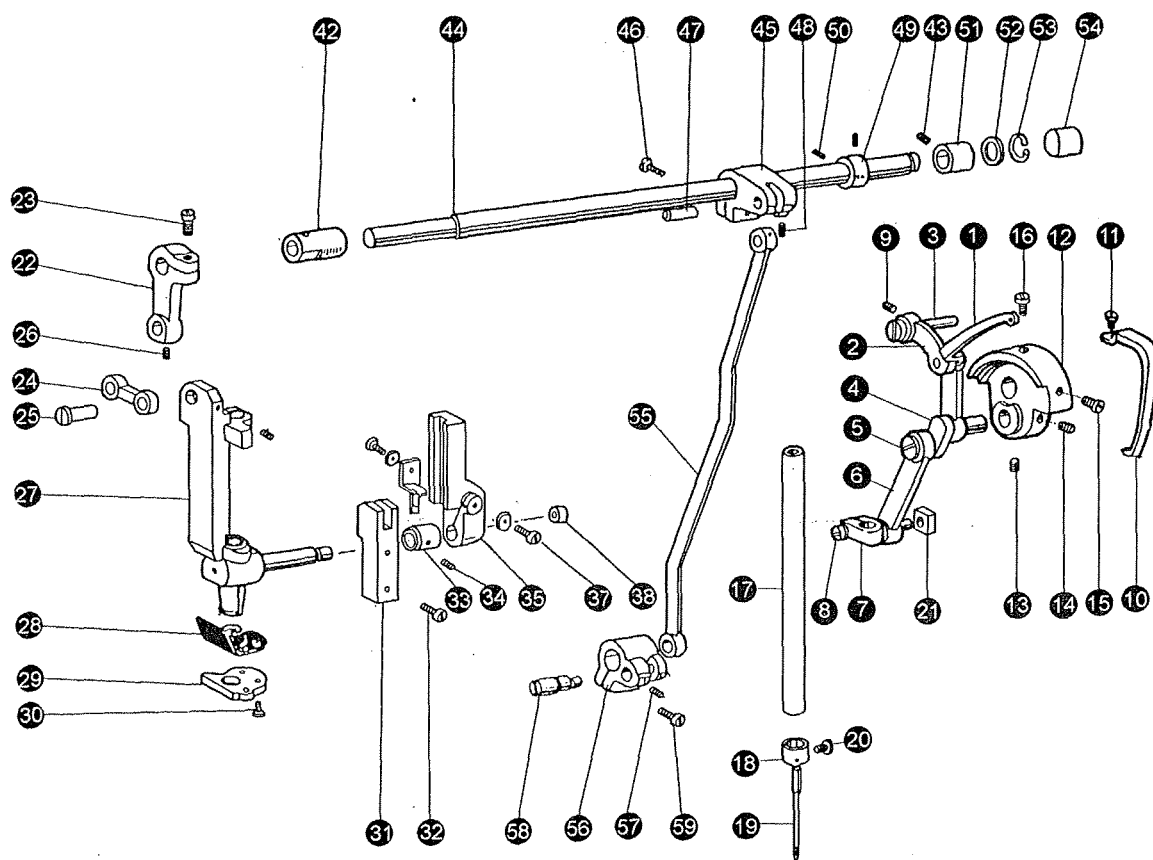
# 1. ARM BED AND ITS ACCESSORIES

| No. | Ref. No.      | Description                        | Qt. |   |   |
|-----|---------------|------------------------------------|-----|---|---|
|     |               |                                    | M   | H | B |
| 1   | 027100002     | Face plate                         | 1   | 1 | 1 |
| 2   | 027100003     | Gasket for face plate              | 1   | 1 | 1 |
| 3   | 22T1 - 003C3  | Rubber plug (Ø19)                  | 1   | 1 | 1 |
| 4   | 22T1 - 003C4  | Rubber plug (Ø11.8)                | 6   | 6 | 6 |
| 5   | 22T1 - 003C5  | Threade guide on face plate        | 1   | 1 |   |
|     | 078130001     | Threade guide on face plate        |     |   | 1 |
| 6   | 22T1 - 003C6  | Threade guide screw                | 1   | 1 | 1 |
| 7   | 22T1 - 004    | Face plate screw                   | 3   | 3 | 3 |
| 8   | 22T1 - 005D1  | Back plate                         | 1   | 1 | 1 |
| 9   | 22T1 - 005D2  | Gasket for rack plate              | 1   | 1 | 1 |
| 10  | 22T1 - 006    | Set screw                          | 8   | 8 | 8 |
| 11  | 22T1 - 007    | Washer                             | 8   | 8 | 8 |
| 12  | 22T1 - 008H   | Oil check window                   | 1   | 1 | 1 |
| 13  | 22T1 - 010    | Three hole thread guide            | 1   | 1 | 1 |
| 14  | 28T4 - 083    | Set screw                          | 1   | 1 | 1 |
| 15  | 22T1 - 009E1  | Screw                              | 1   | 1 | 1 |
| 16  | 22T1 - 009E2  | Spring for pre - tension           | 1   | 1 | 1 |
| 17  | 22T1 - 009E3  | Discs for pre - tension            | 2   | 2 | 2 |
| 18  | 22T1 - 009E4  | Washer                             | 1   | 1 | 1 |
| 19  | GB896 - 86    | Spring washer 3                    | 1   | 1 | 1 |
| 20  | 22T1 - 009E5  | Threade guide for pre - tension    | 1   | 1 | 1 |
| 21  | 124T1 - 003C1 | Knub for thread tension regulator  | 1   | 1 | 1 |
| 22  | 22T1 - 012F10 | Thumb nut revdution stoper         | 1   | 1 | 1 |
| 23  | 22T1 - 012F11 | Threade tension stud               | 1   | 1 | 1 |
| 24  | 22T1 - 012F3  | Threade tension spring             | 1   |   |   |
|     | 048110001     | Threade tension spring             |     | 1 | 1 |
| 25  | 22T1 - 012F4  | Threade tension releasing disc     | 1   | 1 | 1 |
| 26  | 22T1 - 012F5  | Threade tension disc               | 2   | 2 | 2 |
| 27  | 22T1 - 012F6  | Threade take - up spring           | 1   |   |   |
|     | 048110002     | Threade take - up spring           |     | 1 | 1 |
| 28  | 22T1 - 012F11 | Rubber ring                        | 1   | 1 | 1 |
| 29  | 22T1 - 012F7  | Threade tension regulating bushing | 1   | 1 | 1 |
| 30  | 22T1 - 012F8  | Set screw                          | 1   | 1 | 1 |
| 31  | 22T1 - 012F9  | Threade tension releasing pin      | 1   | 1 | 1 |
| 32  | 22T1 - 003C6  | Set screw                          | 1   | 1 | 1 |
| 33  | 22T1 - 014    | Threade guider for arm center      | 1   | 1 |   |
|     | 078100005     | Threade guider for arm center      |     |   | 1 |
| 34  | 22T1 - 013    | Set screw                          | 1   | 1 | 1 |
| 35  | 22T1 - 015    | Rubber plug (Ø8.8)                 | 5   | 5 | 5 |
| 36  | 22T1 - 016    | Rubber plug (Ø27)                  | 1   | 1 | 1 |
| 37  | 027100004     | Needle plate                       | 1   |   |   |
|     | 027100004     | Needle plate                       |     | 1 | 1 |
| 38  | 22T1 - 020    | Needle plate screw                 | 2   | 2 | 2 |
| 39  | 22T1 - 021G1  | Slide plate                        | 1   | 1 | 1 |
| 40  | 22T1 - 021G2  | Spring for slide plate             | 1   | 1 | 1 |
| 41  | 22T1 - 021G3  | Screw                              | 2   | 2 | 2 |
| 42  | 48T1 - 005    | Leg                                | 3   | 3 | 3 |
| 43  | GB93 - 87     | Washer 6                           | 3   | 3 | 3 |
| 44  | 57T1 - 008    | Ruler plate                        | 1   | 1 | 1 |
| 45  | 124T1 - 004   | Ruler screw                        | 2   | 2 | 2 |
| 47  | 22T1 - 006    | Screw                              | 2   | 2 | 2 |
| 48  | 22T8 - 009    | Screw                              | 2   | 2 | 2 |
| 49  | 027100005     | Slack thread regulator             | 1   | 1 | 1 |
| 50  | 027101000     | Machine arm assembly               | 1   | 1 |   |
|     | 027101100     | Machine arm assembly               |     |   | 1 |
| 51  | 027100001     | Trade mark plate                   | 1   |   |   |
|     | 027100101     | Trade mark plate                   |     | 1 |   |
|     | 027100201     | Trade mark plate                   |     |   | 1 |
| 52  | GB827 - 86    | Rivet (2.5 x 5)                    | 2   | 2 | 2 |



## 2. NEEDLE MECHANISM

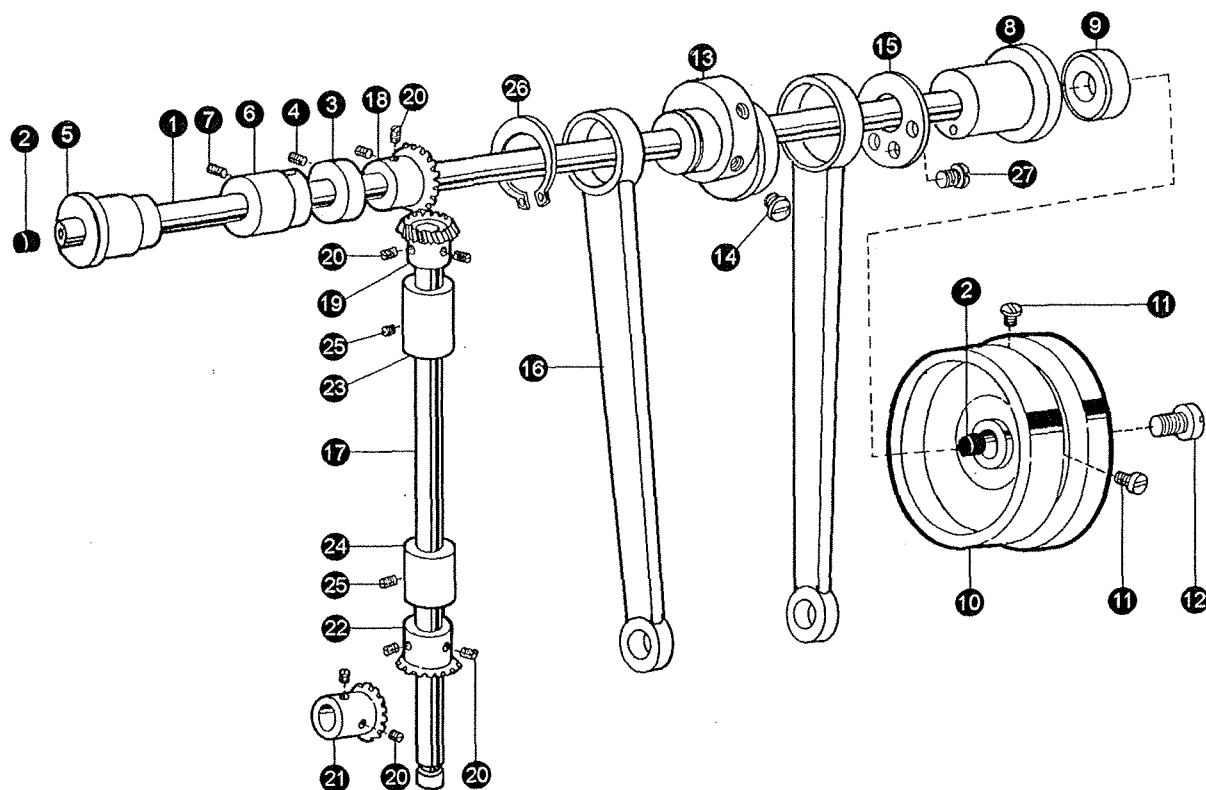
| No. | Ref. No.      | Description                           | Qt. |   |   |
|-----|---------------|---------------------------------------|-----|---|---|
|     |               |                                       | M   | H | B |
| 1   | 22T2 - 001A1a | Thread take - up lever                | 1   |   |   |
|     | 48T2 - 001A1a | Thread take - up lever                |     | 1 |   |
|     | 78T2 - 001A1a | Thread take - up lever                |     |   | 1 |
| 2   | 22T2 - 001A2  | Thread take - up link                 | 1   | 1 | 1 |
| 3   | 22T2 - 001A3  | Thread take - up lever hinge pin      | 1   | 1 | 1 |
| 4   | 22T2 - 001A4  | Thread take - up crank                | 1   |   |   |
|     | 78T2 - 001A2  | Thread take - up crank                |     | 1 | 1 |
|     | 22T2 - 001A5  | Needle roller bearing                 | 2   | 2 | 2 |
| 5   | 22T2 - 001A6  | Set screw (left hand thread)          | 1   | 1 | 1 |
| 6   | 22T2 - 001A7b | Needle bar link ass                   | 1   |   |   |
|     | 48T2 - 001A2  | Needle bar link                       |     | 1 | 1 |
| 7   | 22T2 - 001A8  | Needle bar connecting bar joint       | 1   | 1 | 1 |
| 8   | 22T2 - 001A9  | Screw                                 | 1   | 1 | 1 |
| 9   | 22T1 - 006    | Screw                                 | 1   | 1 | 1 |
| 10  | 36T2 - 007    | Take - up lever guard                 | 1   | 1 |   |
|     | 078200002     | Take - up lever guard                 |     |   | 1 |
| 11  | 22T2 - 004    | Screw                                 | 1   | 1 | 1 |
| 12  | 22T2 - 005B1  | Needle bar crank                      | 1   |   |   |
|     | 048220001     | Needle bar crank                      |     | 1 | 1 |
| 13  | 22T2 - 005B2  | Screw                                 | 1   | 1 | 1 |
| 14  | 22T2 - 005B3  | Thread take - up crank position screw | 1   | 1 | 1 |
| 15  | 22T2 - 006    | Screw                                 | 1   | 1 | 1 |
| 16  | 22T2 - 007    | Thread take - up crank position screw | 1   | 1 | 1 |
| 17  | 153200001     | Needle bar                            | 1   | 1 | 1 |
| 18  | 22T2 - 015    | Thread guide for needle bar           | 1   | 1 | 1 |
| 19  | 58T3 - 001A10 | Needle (DP x5 14#)                    | 1   |   |   |
|     | S150901003    | Needle (DP x5 22#)                    |     | 1 | 1 |
| 20  | 22T2 - 017    | Needle clamp screw                    | 1   | 1 | 1 |
| 21  | 22T2 - 020    | Slide block                           | 1   |   |   |
|     | 027200104     | Slide block                           |     | 1 | 1 |
| 22  | 027200001     | Needle bar vibrating lever            | 1   | 1 | 1 |
| 23  | 22T6 - 016    | Screw                                 | 1   | 1 | 1 |
| 24  | 027200002     | Needle bar vibrating connecting lever | 1   | 1 | 1 |
| 25  | 027200003     | Pin                                   | 2   | 2 | 2 |
| 26  | 22T1 - 011    | Screw                                 | 1   | 1 | 1 |
| 27  | 027201000     | Needle bar holder assembly            | 1   |   |   |
|     | 027201100     | Needle bar holder assembly            |     | 1 | 1 |
| 28  | 027200004     | Oil guard felt                        | 1   | 1 | 1 |
| 29  | 027200005     | Set plate                             | 1   | 1 | 1 |



## 2. NEEDLE MECH ANISM

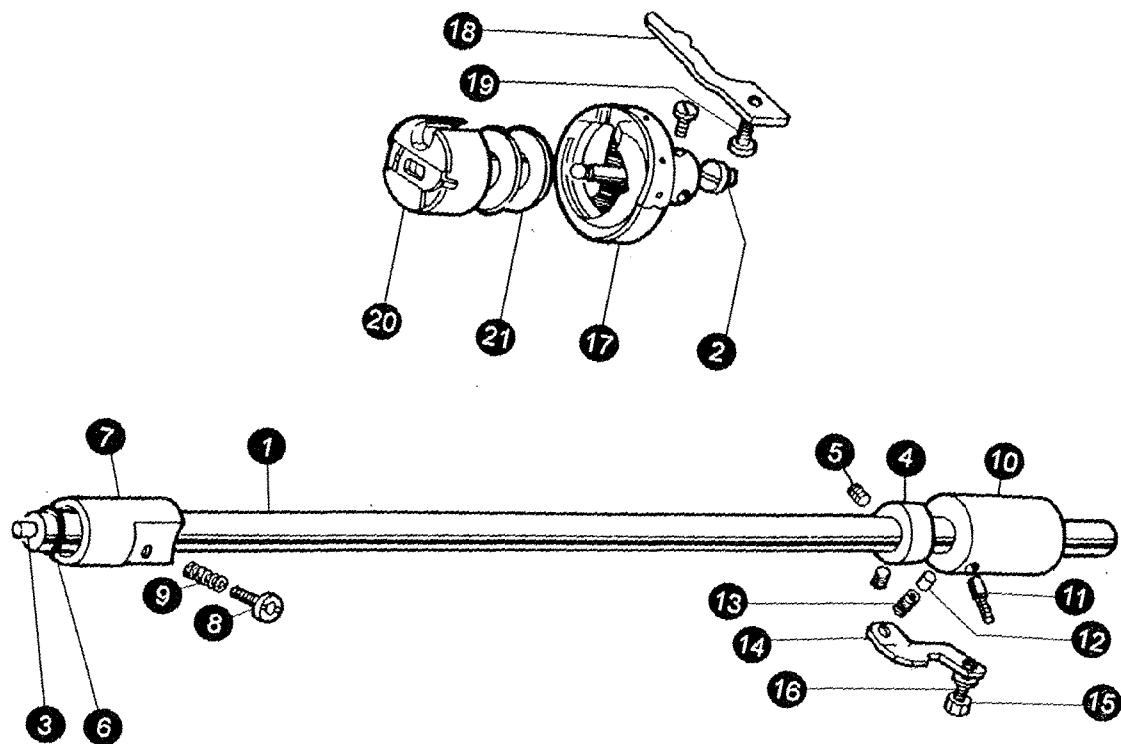
| No. | Ref. No.          | Description                     | Qt. |   |   |
|-----|-------------------|---------------------------------|-----|---|---|
|     |                   |                                 | M   | H | B |
| 30  | 165330001         | Screw                           | 3   | 3 | 3 |
| 31  | 027200006         | Needle bar holder guide         | 1   | 1 | 1 |
| 32  | 22T2 -019         | Screw                           | 1   | 1 | 1 |
| 33  | 027200007         | Bushing                         | 1   | 1 | 1 |
| 34  | 22T1 -011         | Screw                           | 1   | 1 | 1 |
| 35  | 027200008         | Needle bar sliding block guide  | 1   | 1 | 1 |
| 37  | 22T6 -016         | Screw                           | 1   | 1 | 1 |
| 38  | 027200009         | Needle roller bearing           | 1   | 1 | 1 |
| 42  | 027200011         | Vibrating shaft bushing (left)  | 1   | 1 | 1 |
| 43  | 22T1 -011         | Screw                           | 1   | 1 | 1 |
| 44  | 027200012         | Vibrating shaft                 | 1   | 1 | 1 |
| 45  | 027200013         | Vibrating shaft crank           | 1   | 1 | 1 |
| 46  | 22T6 -001A1b      | Screw                           | 1   | 1 | 1 |
| 47  | 027200014         | Pin                             | 1   | 1 | 1 |
| 48  | 22T1 -011         | Screw                           | 1   | 1 | 1 |
| 49  | 027200015         | Collar                          | 1   | 1 | 1 |
| 50  | 22T3 -002B2       | Screw                           | 2   | 2 | 2 |
| 51  | 027200016         | Vibrating shaft bushing (right) | 1   | 1 | 1 |
| 52  | 027200017         | Washer                          | 1   | 1 | 1 |
| 53  | GB8894. 2 -86 -12 | Vibrating shaft stop ring 12    | 1   | 1 | 1 |
| 54  | 027200018         | Rubber plug (Ø21. 5)            | 1   | 1 | 1 |
| 55  | 027200019         | Feed link (long)                | 1   | 1 | 1 |
| 56  | 027200020         | Feed crank                      | 1   | 1 | 1 |
| 57  | 22T6 -016         | Screw                           | 1   | 1 | 1 |
| 58  | 027200021         | Eccentric shaft                 | 1   | 1 | 1 |
| 59  | 22T1 -011         | Screw                           | 1   | 1 | 1 |





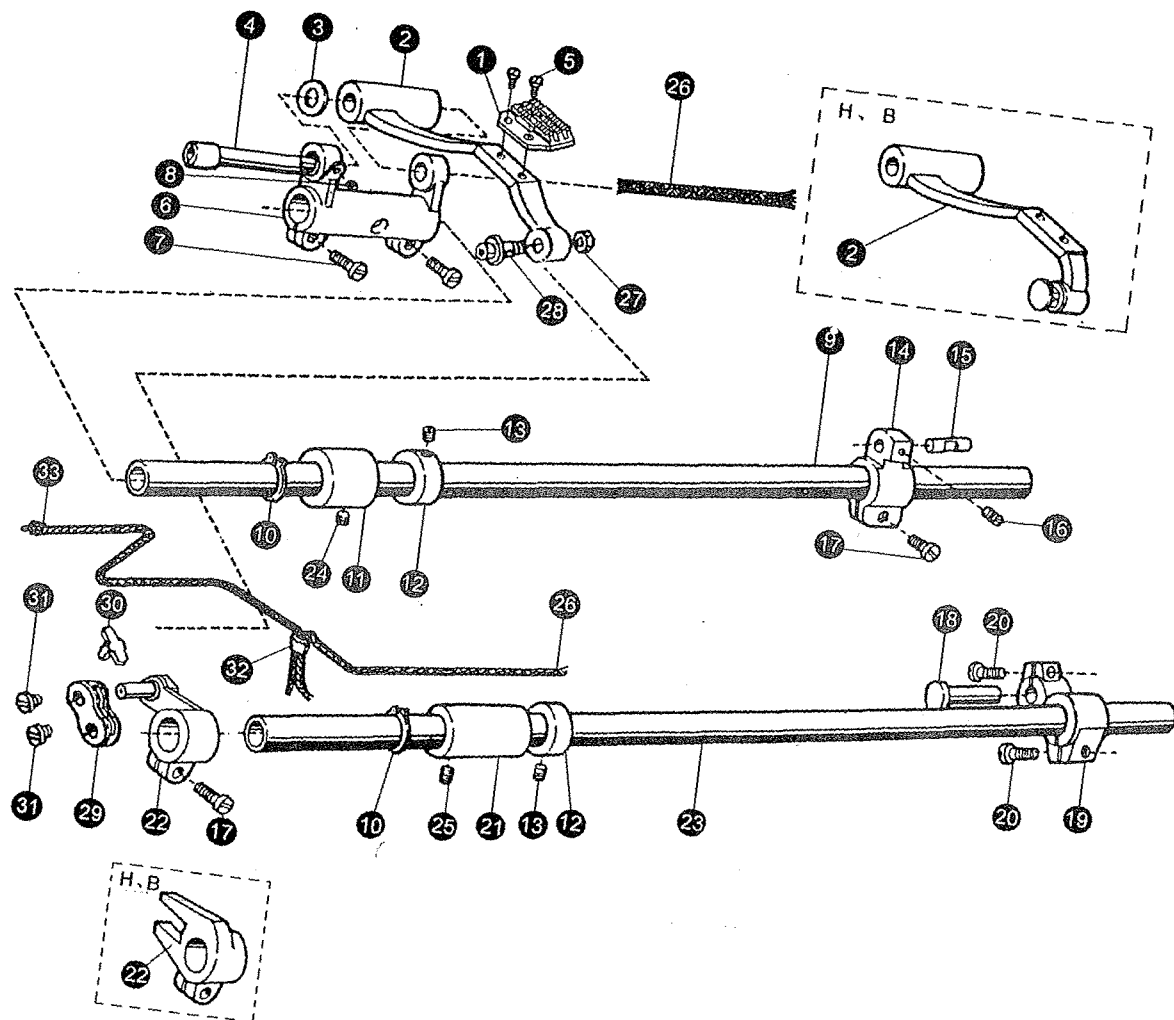
### 3. ARM SHAFT AND VERTICAL SHAFT MECHANISM

| No. | Ref. No.         | Description                                  | Qt. |   |   |
|-----|------------------|----------------------------------------------|-----|---|---|
|     |                  |                                              | M   | H | B |
| 1   | 1533100001       | Arm shaft                                    | 1   | 1 | 1 |
| 2   | 22T3 -001A2      | Arm shaft rubber plug(Ø7.4 × 10)             | 2   | 2 | 2 |
| 3   | 22T3 -002B1      | Collar for arm shaft                         | 1   | 1 | 1 |
| 4   | 22T2 -005B3      | Set screw                                    | 2   | 2 | 2 |
| 5   | 22T2 -003        | Arm shaft bushing(left)                      | 1   | 1 | 1 |
| 6   | 22T3 -004        | Arm shaft bushing(middle)                    | 1   | 1 | 1 |
| 7   | 22T2 -002        | Set screw                                    | 1   | 1 | 1 |
| 8   | 124T3 -003C1     | Arm shaft bushing(right)                     | 1   | 1 | 1 |
| 9   | 124T3 -003C2     | Oil seal                                     | 1   | 1 | 1 |
| 10  | 153300001        | Balance wheel                                | 1   | 1 | 1 |
| 11  | 22T3 -007C2      | Set screw                                    | 2   | 2 | 2 |
| 12  | 22T3 -008        | Set screw                                    | 1   | 1 | 1 |
| 13  | 027300001        | Eccentric wheel                              | 1   | 1 | 1 |
| 14  | 58T5 -012F2      | Eccentric wheel screw                        | 2   | 2 | 2 |
| 15  | 36T3 -004        | Spacer                                       | 1   | 1 | 1 |
| 16  | 22T3 -009D1c     | Crank rod for lifting rock shaft             | 1   | 1 | 1 |
| 17  | 22T3 -010E1      | Vertical shaft                               | 1   | 1 | 1 |
| 18  | 22T3 -010E2a1 -2 | Bever gear for arm shaft(Z =27)              | 1   | 1 | 1 |
| 19  | 22T3 -010E2a2 -2 | Bever gear for vertical shaft(upper) (Z =18) | 1   | 1 | 1 |
| 20  | 22T2 -005B3      | Set screw                                    | 8   | 8 | 8 |
| 21  | 22T3 -010E2b1 -2 | Bever gear for hook shaft(Z =21)             | 1   | 1 | 1 |
| 22  | 22T3 -010E2b2 -2 | Bever gear for Vertical shaft(lower) (Z =28) | 1   | 1 | 1 |
| 23  | 22T3 -011        | Vertical shaft bushing(upper)                | 1   | 1 | 1 |
| 24  | 22T3 -012        | Vertical shaft bushing(lower)                | 1   | 1 | 1 |
| 25  | 22T2 -002        | Set screw                                    | 2   | 2 | 2 |
| 26  | 22T3 -009D1b     | Ring                                         | 1   | 1 | 1 |
| 27  | 165330001        | Screw                                        | 3   | 3 | 3 |



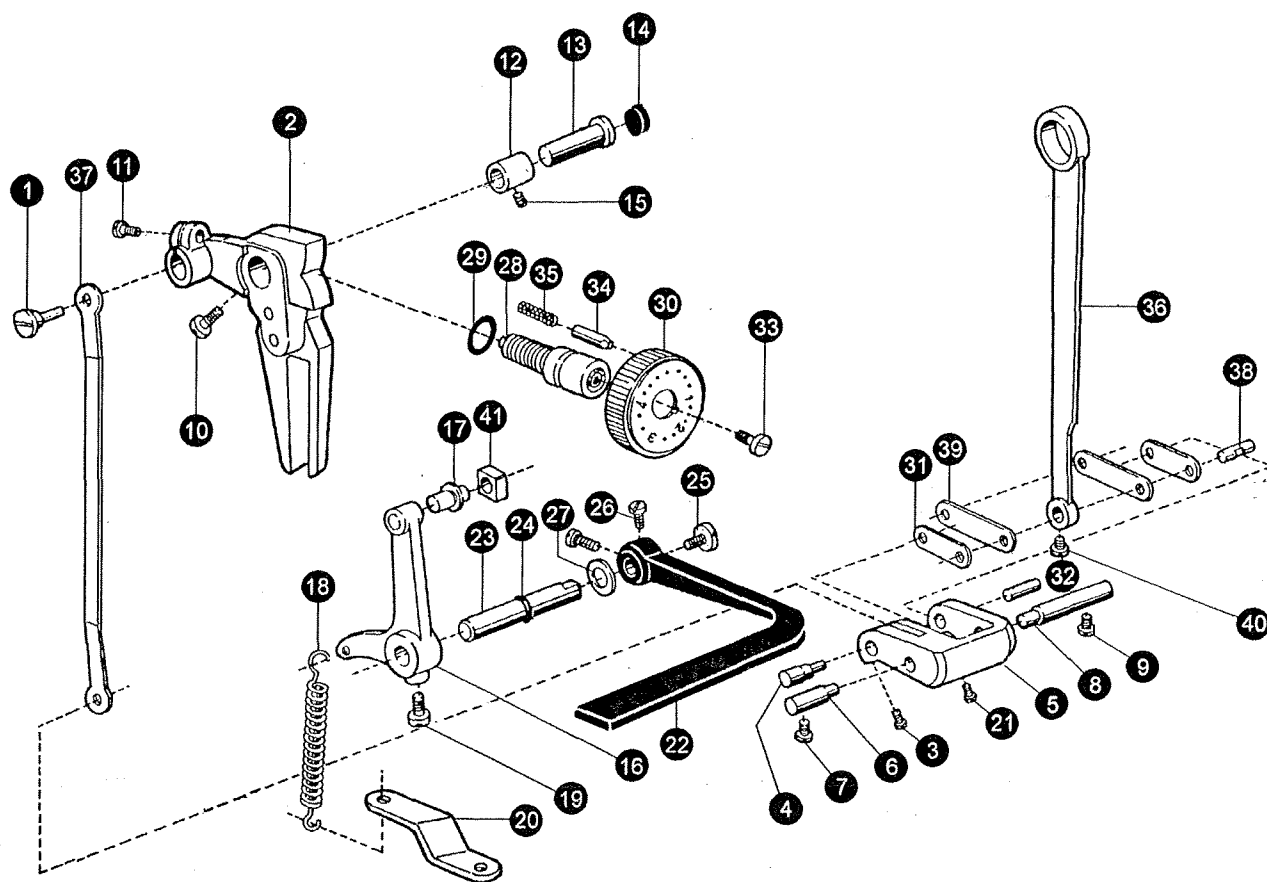
#### 4. ROTATING HOOK MECHANISM

| No. | Ref. No.       | Description                     | Qt. |   |   |
|-----|----------------|---------------------------------|-----|---|---|
|     |                |                                 | M   | H | B |
| 1   | 36T4 - 008D1   | Hook shaft                      | 1   | 1 |   |
|     | 120400001      | Hook shaft                      |     |   | 1 |
| 2   | 22T4 - 001A1a1 | Filter screw                    | 1   | 1 | 1 |
| 3   | 22T4 - 001A1a2 | Filter                          | 1   | 1 | 1 |
| 4   | 22T4 - 002B1   | Collaer for hook shaft          | 1   | 1 | 1 |
| 5   | 22T2 - 009     | Set screw                       | 2   | 2 | 2 |
| 6   | 22T4 - 003G    | Oil seal for rotating           | 1   | 1 | 1 |
| 7   | 22T4 - 004     | Hook shaft bushing (left)       | 1   | 1 | 1 |
| 8   | 22T4 - 005     | Oil adjusting screw             | 1   | 1 | 1 |
| 9   | 22T4 - 006     | Spring for oil adjusting        | 1   | 1 | 1 |
| 10  | 36T4 - 014F1   | Hook shaft bushing (right)      | 1   | 1 | 1 |
| 11  | 22T4 - 007C2   | Oil pipe for hook shaft bushing | 1   | 1 | 1 |
| 12  | 36T4 - 015     | Plunger                         | 1   | 1 | 1 |
| 13  | 36T4 - 016     | Plunger spring                  | 1   | 1 | 1 |
| 14  | 22T4 - 001A1   | Guide plate                     | 1   | 1 |   |
|     | 78400006       | Guide plate                     |     |   | 1 |
| 15  | 22T8 - 009     | Screw                           | 1   | 1 | 1 |
| 16  | GB93 - 87 - 6  | Spring washer 6                 | 1   | 1 | 1 |
| 17  | KSH12 - SD     | Rotating hook                   | 1   |   |   |
|     | 048400101      | Rotating hook                   |     | 1 |   |
|     | 027403000      | Rotating hook                   |     |   | 1 |
| 18  | 22T4 - 013     | Rotating hook positioner        | 1   |   |   |
|     | 048400002      | Rotating hook positioner        |     | 1 |   |
|     | 78T4 - 003     | Rotating hook positioner        |     |   | 1 |
| 19  | 22T4 - 015     | Screw                           | 1   | 1 | 1 |
| 20  | SC82 - J       | Bobbin case                     | 1   | 1 |   |
|     | 027402100      | Bobbin case                     |     |   | 1 |
| 21  | 36T4 - 006     | Bobbin                          | 1   | 1 |   |
|     | 078400005      | Bobbin                          |     |   | 1 |



## 5. FEEDING AND FEED LIFTING MECHANISM

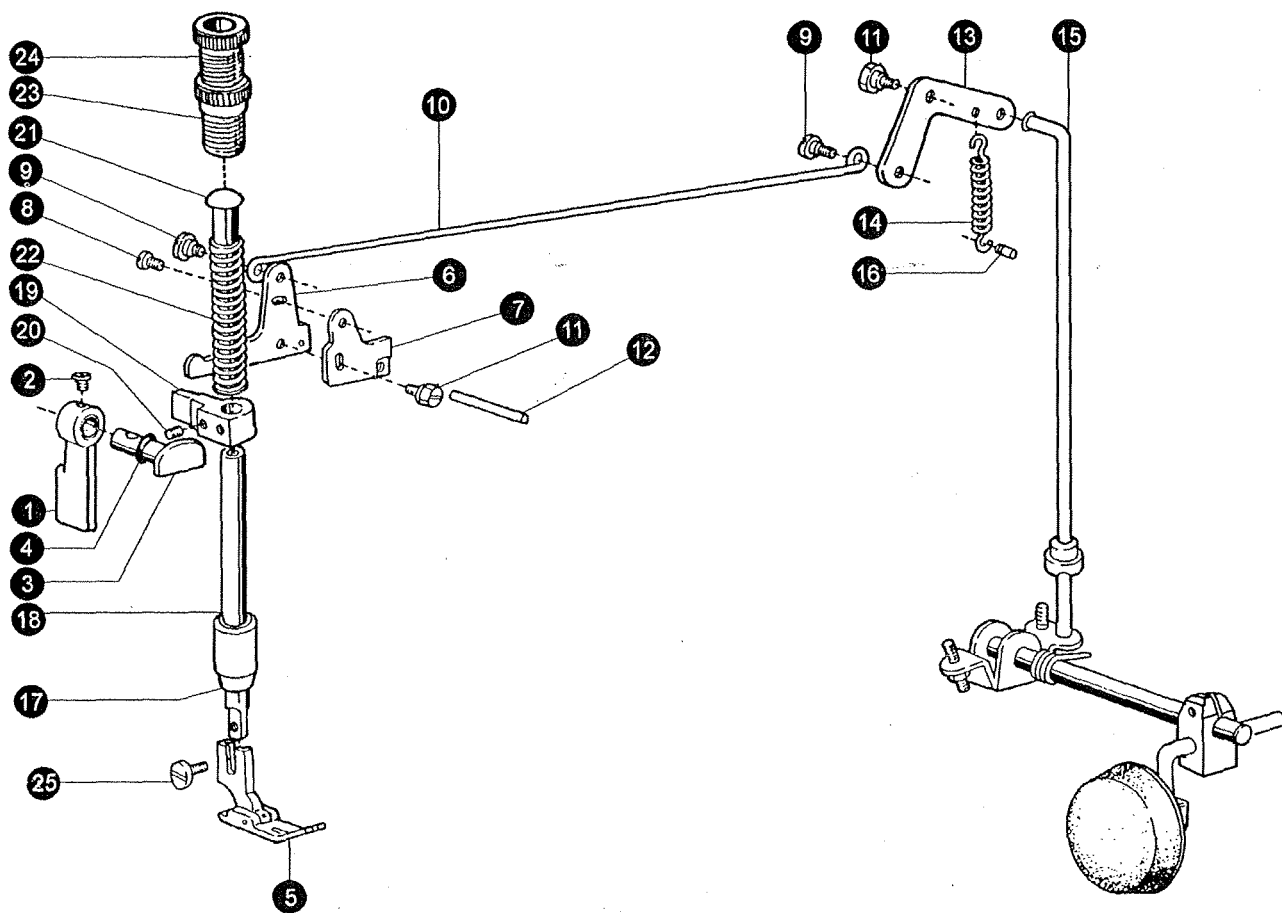
| No. | Ref. No.      | Description                            | Qt. |   |   |
|-----|---------------|----------------------------------------|-----|---|---|
|     |               |                                        | M   | H | B |
| 1   | 027600001     | Feed dog                               | 1   |   |   |
|     | 027600101     | Feed dog                               |     | 1 | 1 |
| 2   | 027601000     | Feed bar                               | 1   |   |   |
|     | 36T4 -001A1a  | Feed bar                               |     | 1 | 1 |
| 3   | 22T6 -001A6   | Washer                                 | 1   | 1 | 1 |
| 4   | 36T4 -001A2   | Feed bracket shaft                     | 1   | 1 | 1 |
| 5   | 22T6 -001A4   | Screw                                  | 2   | 2 | 2 |
| 6   | 22T6 -001A1a  | Feed rock bracket arm                  | 1   | 1 | 1 |
| 7   | 22T6 -001A1b  | Screw                                  | 2   | 2 | 2 |
| 8   | 22T2 -019     | Screw                                  | 1   | 1 | 1 |
| 9   | 124T6 -002    | Feed rock shaft                        | 1   | 1 | 1 |
| 10  | GB894. 1 -86  | C -type stop ring (15)                 | 2   | 2 | 2 |
| 11  | 22T6 -004     | Feed rock shaft bushing                | 1   | 1 | 1 |
| 12  | 22T6 -005B1   | Collar                                 | 2   | 2 | 2 |
| 13  | 22T6 -005B2   | Set screw                              | 4   | 4 | 4 |
| 14  | 36T4 -003     | Feed rock shaft crank(right)           | 1   | 1 | 1 |
| 15  | 36T4 -004H01  | Feed link stod                         | 1   | 1 | 1 |
| 16  | 36T5 -008E5   | Set screw                              | 1   | 1 | 1 |
| 17  | 22T6 -008D3   | Screw                                  | 2   | 2 | 2 |
| 18  | 22T6 -007     | Hinge                                  | 1   | 1 | 1 |
| 19  | 48T6 -006     | Feed lifting rock shaft crank(right)   | 1   | 1 | 1 |
| 20  | 22T6 -016     | Screw                                  | 2   | 2 | 2 |
| 21  | 22T6 -012     | Bushing for feed lifting rock shaft    | 1   | 1 | 1 |
| 22  | 22T6 -008D    | Feed lifting rock shaft crank assembly | 1   |   |   |
|     | 36T4 -018H1D1 | Feed lifting shaft crank               |     | 1 | 1 |
| 23  | 124T6 -003    | Feed lifting rock shaft                | 1   | 1 | 1 |
| 24  | 22T2 -009     | Set screw                              | 1   | 1 | 1 |
| 25  | 22T2 -002     | Set screw                              | 1   | 1 | 1 |
| 26  | 22T6 -009F3   | Wick                                   | 2   | 2 | 2 |
| 27  | 22T6 -001A8   | Nut                                    | 1   |   |   |
| 28  | 22T6 -001A9   | Hinge                                  | 1   |   |   |
| 29  | 22T6 -009F1   | Feed stand link                        | 1   |   |   |
| 30  | 22T6 -009F2   | Oil wick clamp                         | 1   |   |   |
| 31  | 22T6 -010     | Screw                                  | 1   |   |   |
| 32  | 22T6 -015     | Oil wick clamp                         | 1   | 1 | 1 |
| 33  | 22T6 -001A7   | Oil wick                               | 1   | 1 | 1 |





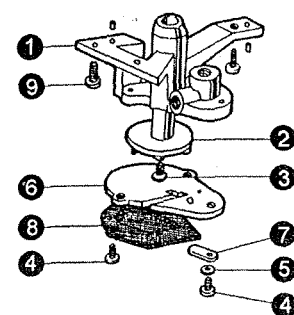
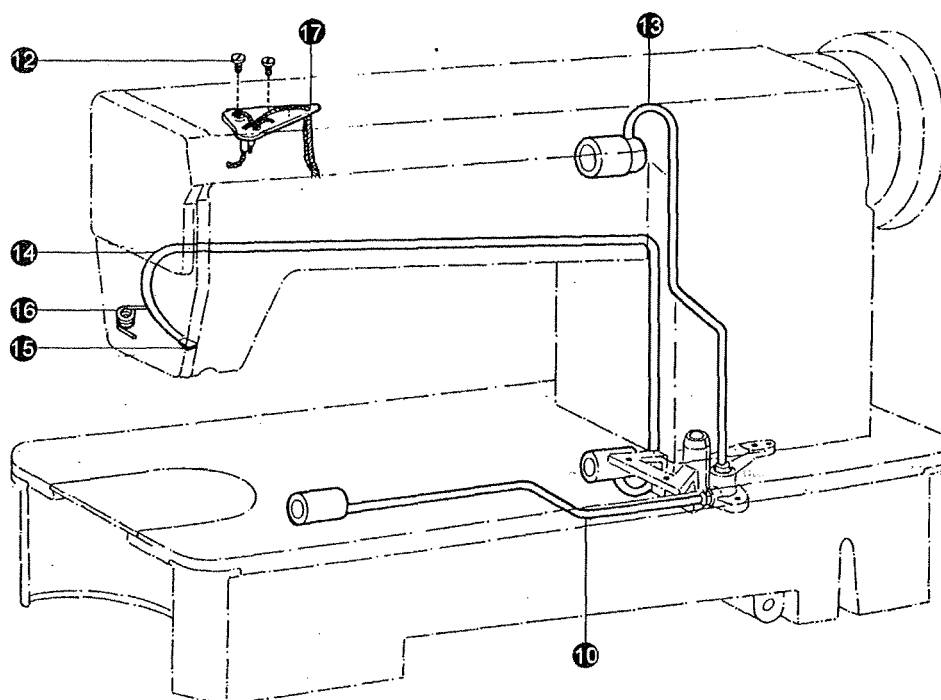
## 6. STITCH LENGTH REGULATING MECHANISM

| No. | Ref. No.       | Description                       | Qt. |   |   |
|-----|----------------|-----------------------------------|-----|---|---|
|     |                |                                   | M   | H | B |
| 1   | 36T5 -001      | Connecting stud                   | 1   | 1 | 1 |
| 2   | 57T5 -001      | Feed regulator                    | 1   | 1 | 1 |
| 3   | 36T5 -008E8    | Screw                             | 1   | 1 | 1 |
| 4   | 36T5 -008E9    | Lever link eccentric shaft        | 1   | 1 | 1 |
| 5   | 36T5 -008E10   | Lever regulator                   | 1   | 1 | 1 |
| 6   | 36T5 -009H02   | Pin (left)                        | 1   | 1 | 1 |
| 7   | 22T6 -008D3    | Screw                             | 1   | 1 | 1 |
| 8   | 36T5 -009H01   | Pin (right)                       | 1   | 1 | 1 |
| 9   | 22T6 -008D3    | Screw                             | 1   | 1 | 1 |
| 10  | 22T5 -010D4    | Screw of feed regulator           | 1   | 1 | 1 |
| 11  | 22T2 -019      | Screw                             | 1   | 1 | 1 |
| 12  | 22T5 -003      | Feed regulator bushing            | 1   | 1 | 1 |
| 13  | 22T5 -004      | Feed regulator shaft              | 1   | 1 | 1 |
| 14  | 36T5 -003      | Rubber plug(Ø20)                  | 1   | 1 | 1 |
| 15  | 22T2 -002      | Set screw                         | 1   | 1 | 1 |
| 16  | 22T5 -012E1    | Back tacking crank                | 1   | 1 | 1 |
| 17  | 22T5 -012E1a1  | Slide block pin                   | 1   | 1 | 1 |
| 18  | 57T5 -004B1    | Lever spring                      | 1   | 1 | 1 |
| 19  | 22T5 -013      | Set screw                         | 1   | 1 | 1 |
| 20  | 57T5 -005      | Bracket for spring                | 1   | 1 | 1 |
| 21  | 36T5 -008E7    | Screw                             | 1   | 1 | 1 |
| 22  | 124500004      | Backtacking lever                 | 1   | 1 | 1 |
| 23  | 36T5 -006C1a1  | Backtacking lever shaft           | 1   | 1 | 1 |
| 24  | GB3452.1 -92   | O -ring(6.3 x 1.8G)               | 1   | 1 | 1 |
| 25  | 22T5 -010D3    | Screw                             | 1   | 1 | 1 |
| 26  | 22T5 -010D4    | Screw                             | 2   | 2 | 2 |
| 27  | 22T5 -011      | O -ring                           | 1   | 1 | 1 |
| 28  | 124T5 -001A2   | Feed regulator screw              | 1   | 1 | 1 |
| 29  | 124T5 -001A3   | O -ring for feed regulating screw | 1   | 1 | 1 |
| 30  | 027500001      | Knob                              | 1   |   |   |
|     | 124T5 -002B1   | Knob                              |     | 1 |   |
|     | 124T5 -001A1   | Knob                              |     |   | 1 |
| 31  | 36T5 -008E4H01 | Feed rock link                    | 1   | 1 | 1 |
| 32  | 36T5 -008E6    | Pin                               | 1   | 1 | 1 |
| 33  | 22T5 -006C3    | Screw                             | 1   | 1 | 1 |
| 34  | 22T5 -008      | Stopper pin                       | 1   | 1 | 1 |
| 35  | 22T5 -009      | Spring for stopper pin            | 1   | 1 | 1 |
| 36  | 36T5 -008E2    | Lever feed connecting rod         | 1   | 1 | 1 |
| 37  | 36T5 -008E3    | Feed regulator link               | 1   | 1 | 1 |
| 38  | 36T4 -004H02   | Sink shaft                        | 1   | 1 | 1 |
| 39  | 36T5 -008E4H02 | Feed rock arm link                | 2   | 2 | 2 |
| 40  | 36T5 -008E5    | Screw                             | 1   | 1 | 1 |
| 41  | 22T5 -012E1a2  | Crank slide block                 | 1   | 1 | 1 |



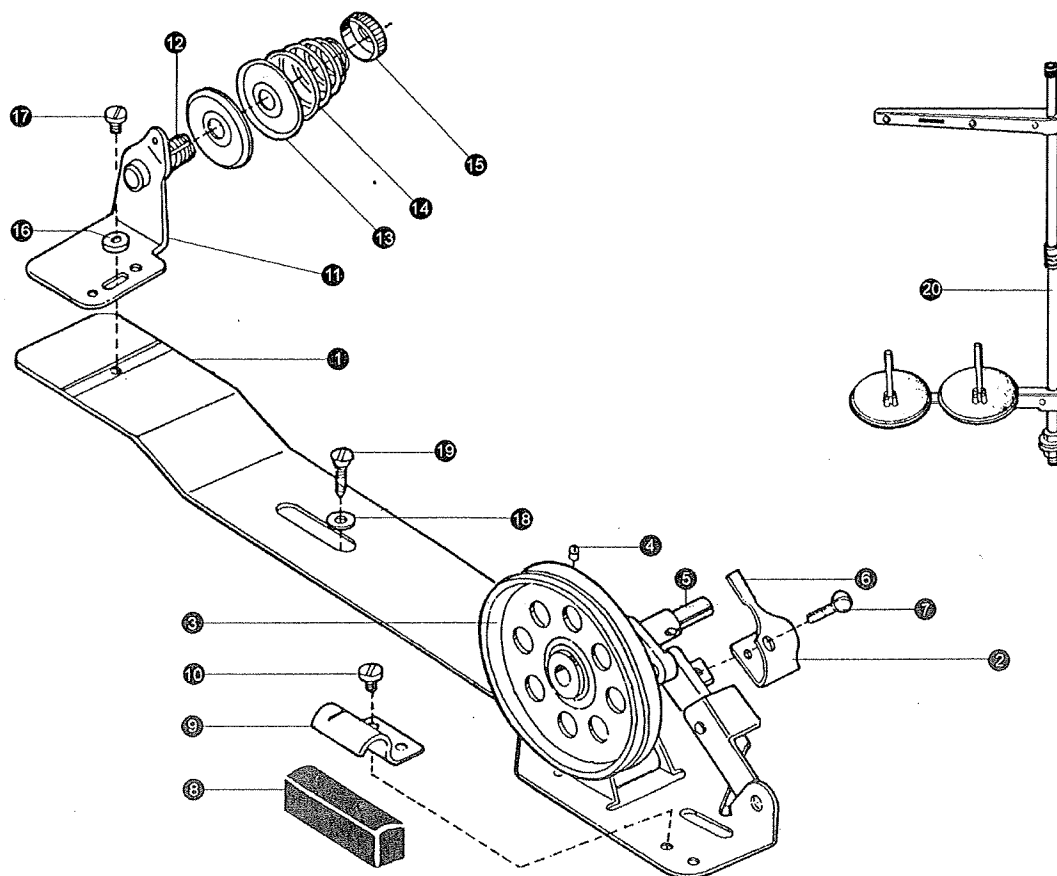
## 7. PRESSER FOOT MECHANISM

| No. | Ref. No.       | Description                          | Qt. |   |   |
|-----|----------------|--------------------------------------|-----|---|---|
|     |                |                                      | M   | H | B |
| 1   | 22T7 - 001A1   | Presser bar lifter                   | 1   | 1 | 1 |
| 2   | 22T1 - 006     | Set screw                            | 1   | 1 | 1 |
| 3   | 22T7 - 002     | Presser bar lifter                   | 1   | 1 | 1 |
| 4   | GB3452. 1 - 92 | Oil seal for presser bar(4.5 x 1.8G) | 1   | 1 | 1 |
| 5   | 027701000      | Presser foot complete                | 1   |   |   |
|     | 027701100      | Presser foot complete                |     | 1 | 1 |
| 6   | 22T7 - 004B1a  | Knee lifter lever(left)              | 1   | 1 | 1 |
| 7   | 22T7 - 004B1b  | Tension releasing cam                | 1   | 1 | 1 |
| 8   | 22T7 - 004B1c  | Screw                                | 1   | 1 | 1 |
| 9   | 22T7 - 004B2   | Hinge screw                          | 2   | 2 | 2 |
| 10  | 22T7 - 004B3   | Knee lifter rod                      | 1   | 1 | 1 |
| 11  | 22T7 - 005     | Bolt for tension releasing cam       | 1   | 1 | 1 |
| 12  | 22T7 - 006     | Tension releasing pin                | 1   | 1 | 1 |
| 13  | 22T7 - 007C1   | Knee lifte lever(right)              | 1   | 1 | 1 |
| 14  | 22T7 - 007C2   | Spring for knee lifter lever(right)  | 1   | 1 | 1 |
| 15  | 22T7 - 007C3   | Knee lifter connecting rod           | 1   | 1 | 1 |
| 16  | 22T7 - 008     | Pin for spring                       | 1   | 1 | 1 |
| 17  | 22T7 - 009     | Presser bar bushing                  | 1   | 1 | 1 |
| 18  | 22T7 - 010     | Presser bar                          | 1   | 1 | 1 |
| 19  | 027700001      | Presser bar lifting bracket          | 1   | 1 | 1 |
| 20  | 22T1 - 013     | Set screw                            | 1   | 1 | 1 |
| 21  | 22T7 - 012     | Presser bar guide                    | 1   | 1 | 1 |
| 22  | 22T7 - 013     | Presser spring                       | 1   |   |   |
|     | 048700002      | Presser spring                       |     | 1 | 1 |
| 23  | 22T7 - 014E1   | Presser regulating thumb screw       | 1   | 1 | 1 |
| 24  | 22T7 - 014E2   | Presser regulating thumb nut         | 1   | 1 | 1 |
| 25  | 22T7 - 015     | Set screw                            | 1   | 1 | 1 |



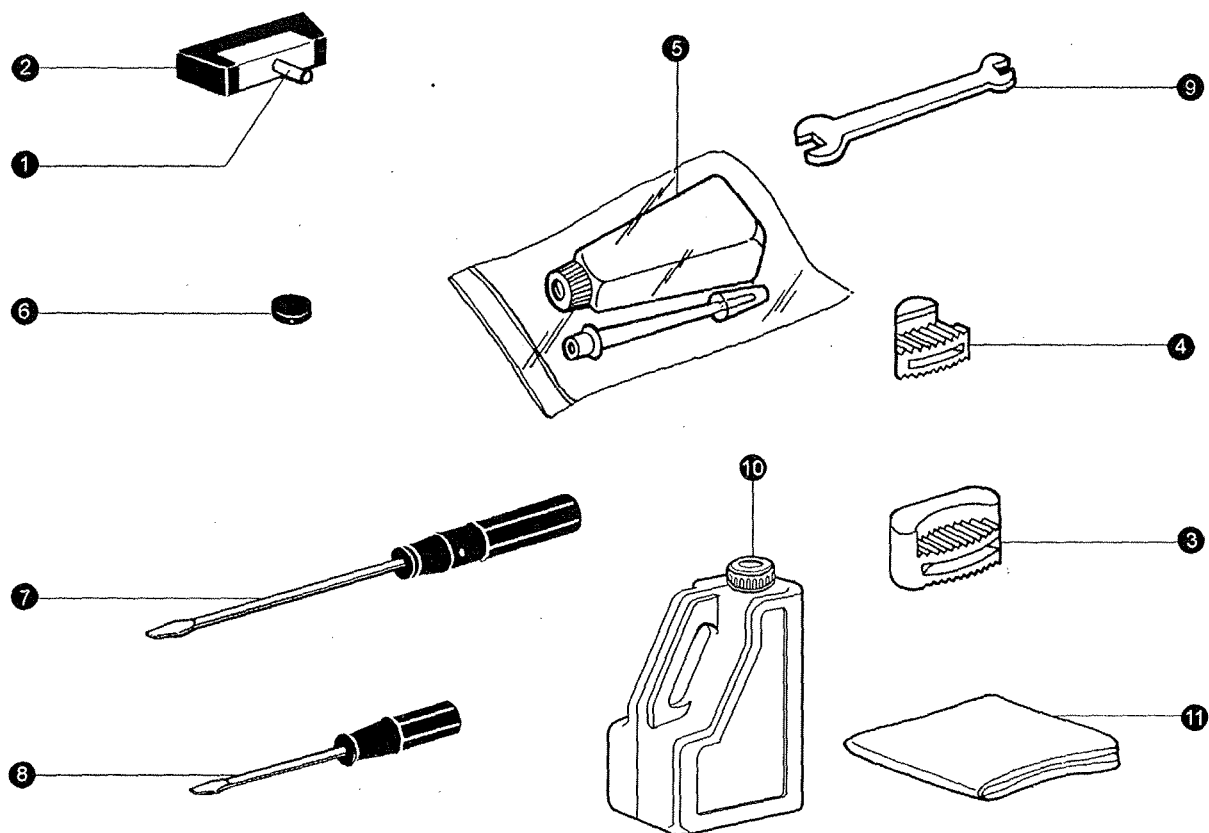
## 8. LUBRICATION MECHANISM

| No. | Ref. No.   | Description                  | Qt. |   |   |
|-----|------------|------------------------------|-----|---|---|
|     |            |                              | M   | H | B |
| 1   | 22T8 -001  | Oil pump body                | 1   | 1 | 1 |
| 2   | 22T8 -002  | Oil pump impeller            | 1   | 1 | 1 |
| 3   | 22T8 -003  | Screw                        | 1   | 1 | 1 |
| 4   | 22T8 -004  | Screw                        | 3   | 3 | 3 |
| 5   | GB93 -87   | Spring washer 3              | 1   | 1 |   |
| 6   | 22T8 -006  | Oil pump filtering plate     | 1   | 1 |   |
|     | 78T8 -001  | Oil pump filtering plate     |     |   | 1 |
| 7   | 22T8 -007  | Oil adjusting plate          | 1   | 1 |   |
| 8   | 22T8 -008A | Oil pump screen complete     | 1   | 1 | 1 |
| 9   | 22T8 -009  | Screw                        | 3   | 3 | 3 |
| 10  | 22T8 -010B | Oil pipe for hook shaft      | 1   | 1 | 1 |
| 12  | 22T7 -012  | Screw                        | 2   | 2 | 2 |
| 13  | 22T8 -013D | Oil pipe for arm shaft       | 1   | 1 |   |
|     | 78T8 -002A | Oil pipe for arm shaft       |     |   | 1 |
| 14  | 027800001  | Oil returnning pipe          | 1   | 1 | 1 |
| 15  | 027800002  | Felt pouch for return filter | 1   | 1 | 1 |
| 16  | 027800003  | Spring for oil felt          | 1   | 1 | 1 |
| 17  | 027810000  | Oil braid filting plate      | 1   | 1 | 1 |



## 10. BOBBIN WINDER, SPOOL STAND MECHANISM

| No. | Ref. No.     | Description                      | Qt. |   |   |
|-----|--------------|----------------------------------|-----|---|---|
|     |              |                                  | M   | H | B |
| 1   | 6F0 -001A    | Bobbin winder base               | 1   | 1 | 1 |
| 2   | 6F0 -001A6a  | Bobbin winder stop latclever set | 1   | 1 | 1 |
| 3   | 6F0 -002     | Bobbin winder pulley             | 1   | 1 | 1 |
| 4   | 01/B112      | Screw                            | 1   | 1 | 1 |
| 5   | 6F0 -003     | Bobbin winder spindle            | 1   | 1 | 1 |
| 6   | 6F0 -004 -1  | Bobbin winder stop latch         | 1   | 1 |   |
|     | 6F0 -004 -2  | Bobbin winder stop latch         |     |   | 1 |
| 7   | 6F0 -005     | Adjusting screw                  | 1   | 1 | 1 |
| 8   | 6F0 -006     | Stopper block                    | 1   | 1 | 1 |
| 9   | 6F0 -007     | Stopper block clamp              | 1   | 1 | 1 |
| 10  | 6F0 -008     | Set screw                        | 1   | 1 | 1 |
| 11  | 6F0 -009B1b1 | Bobbin winder tension bracket    | 1   | 1 | 1 |
| 12  | 17T7 -017    | Bobbin winder tension stud       | 1   | 1 | 1 |
| 13  | 22T1 -012F5  | Bobbin winder tension discs      | 2   | 2 | 2 |
| 14  | 22T1 -012F3  | Bobbin winder tension spring     | 1   | 1 | 1 |
| 15  | J2. 2. 7     | Tension stud nut                 | 1   | 1 | 1 |
| 16  | BQ10021      | Screw                            | 1   | 1 | 1 |
| 17  | 22T2 -004    | Tension bracket screw            | 1   | 1 | 1 |
| 18  | GB848 -85    | Washer 6                         | 2   | 2 | 2 |
| 19  | GB99 -86     | Wood screw                       | 2   | 2 | 2 |
| 20  | GXJ -2       | Spool stand                      | 1   | 1 | 1 |



## 11. ACCESSORIES

| No. | Ref. No.    | Description                  | Qt. |   |   |
|-----|-------------|------------------------------|-----|---|---|
|     |             |                              | M   | H | B |
| 1   | 22T9 -007F1 | Hinge of machine head        | 2   | 2 | 2 |
| 2   | 22T9 -007F2 | Hinge socket of machine head | 2   | 2 | 2 |
| 3   | 22T9 -009   | Rubber cap (B)               | 2   | 2 | 2 |
| 4   | 22T9 -010   | Rubber cap (S)               | 2   | 2 | 2 |
| 5   | 22T9 -011   | Oil pot                      | 1   | 1 | 1 |
| 6   | 22T9 -012   | Magnet                       | 1   | 1 | 1 |
| 7   | 22T9 -013   | Screw driver (B)             | 1   | 1 | 1 |
| 8   | 22T9 -015   | Screw driver (S)             | 1   | 1 | 1 |
| 9   | 22T9 -016   | Double end wrench            | 1   | 1 | 1 |
| 10  | 22T9 -017   | Oil can                      | 1   | 1 | 1 |
| 11  | 22T9 -018   | Vinyl cover                  | 1   | 1 | 1 |

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