

PREMIER SERIES

BY



P2339RB

P1255RB

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1. Brief introduction

Both the models adopt straight twin-needle and two horizontal hooks with auto lubrication for thread looping, sliding lever for thread take up to form two lines of lockstitch seam. The upper shaft and lower shaft is connected by ball bearing and driven by teeth-type synchronic belt; plunge oil pump lubrication system. They adopt the compound feed mechanics of feed dog, needle bar and presser foot, even if for long stitch length and long material, They can deal with them freely.

They are widely used in factories of suitcase, tent, cushion, leather goods, apparel, mat, etc..

The difference between the two models:

P2339RB adopts twin-needle, two large horizontal hooks with auto lubrication. With the parts it can form ten different needle gauges.

P1255RB adopts single needle and form single line double lockstitch form.

2. Main Technical Specification

1 Application:	medium and heavy duty materials
2 Max. sewing speed:	2000 spm
3 Max. Stitch length :	9 mm
4 Needle bar stroke:	36 mm
5 Presser foot lift height:	8mm(by hand); 16mm(by knee)
6 Hook:	large horizontal hook with auto lubrication
7 Needle:	DPX 17 Nm125~180
8 Lubrication:	pump auto lubrication (partial of manually oiling)
9 Needle gauge: (Twin-needle)	6.4, 3.2, 4, 4.8, 8, 9.5, 12.7, 16, 19, 25.4
10 Motor power:	0.37 kw (clutch motor)

3. Installation and preparation

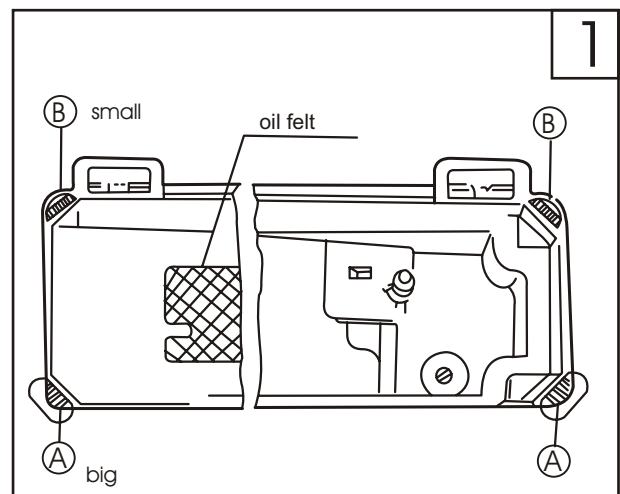
3.1 Installation

3.1.1 Location of the machine

To ensure a smooth running, the machine should be located on rigid and flat floor. The insert of rubber mat between machine stand and floor is recommended for further reducing the running noise and vibration.

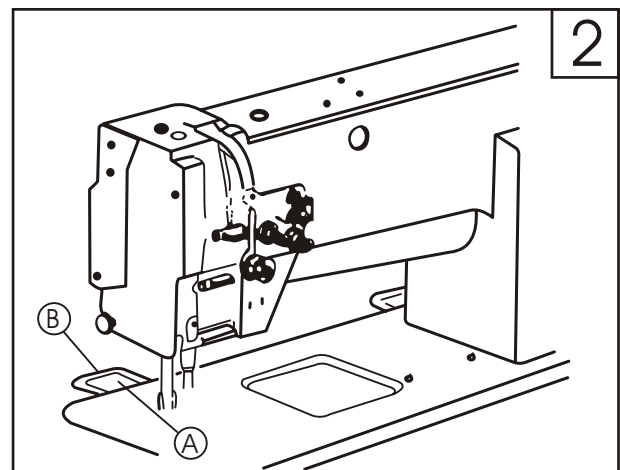
3.1.2 Oil Reservoir Installation(Fig.1)

Put the oil reservoir into the table cutout, and place the four cushions on the four corners of the cutout, and place oil felt into the oil reservoir.



3.1.3 Mounting machine head(Fig.2)

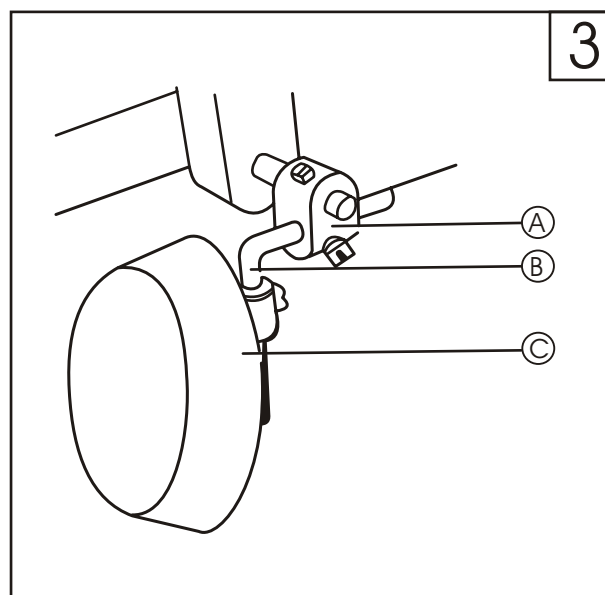
Make the hinge (A) of machine head engaged with hinge socket (B) on the table, then turn the machine head freely till it is seated on the frame of table cutout.



3.1.4 Knee control presser foot lifter installation(Fig.3)

a. Installing

Install Connector (A) , Bell Crank (B) , Bell (C) in the order shown in Fig.3.

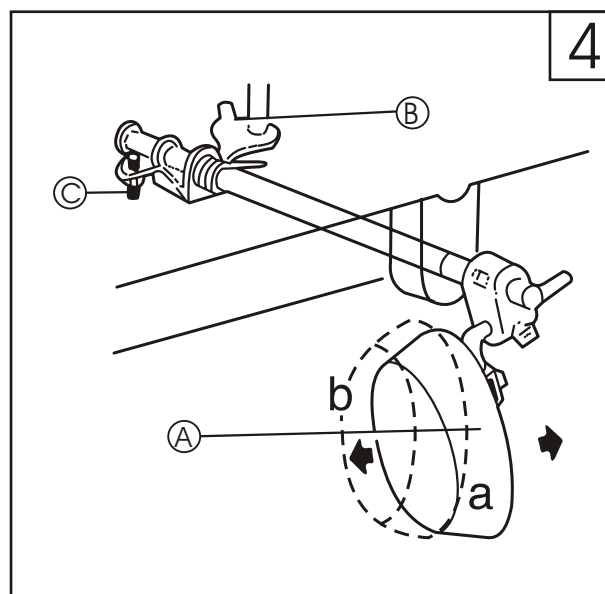


b. Adjustment (Fig.4)

In the order of the following:

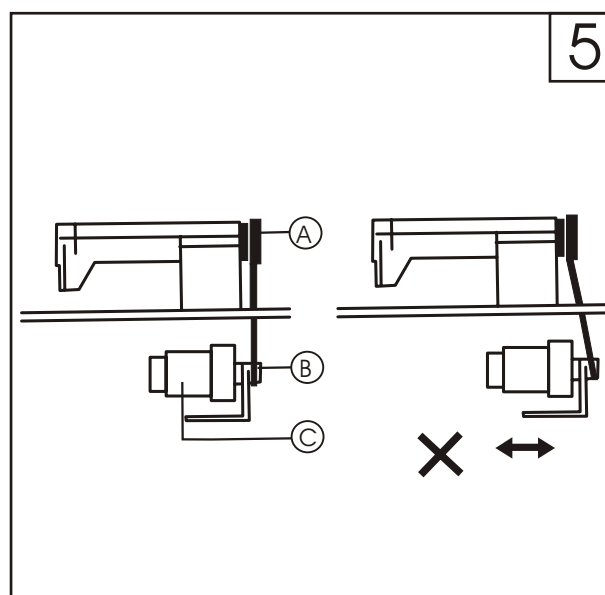
1. When the presser foot is at its lowest position, keep the crank in the position shown by b in the figure, turn Knee Control Stop Adjusting Screw (C) to touch with the oil reservoir, and tighten the nut of Screw (C) .

2. When operate by knee, the presser foot lift volume is controlled by Screw (B) . Turn the presser foot lever down, make the bell in the position shown by a in the figure, lift the presser foot to 13 mm, adjust Screw (B) to touch the oil reservoir. Then tighten the nut of Screw (B) .



3.1.5 Installing the motor (Fig.5)

Align machine balance wheel belt groove (A) with motor pulley belt groove (B) by moving the motor (C) leftward or rightward. Be sure the belt is not touch with table.



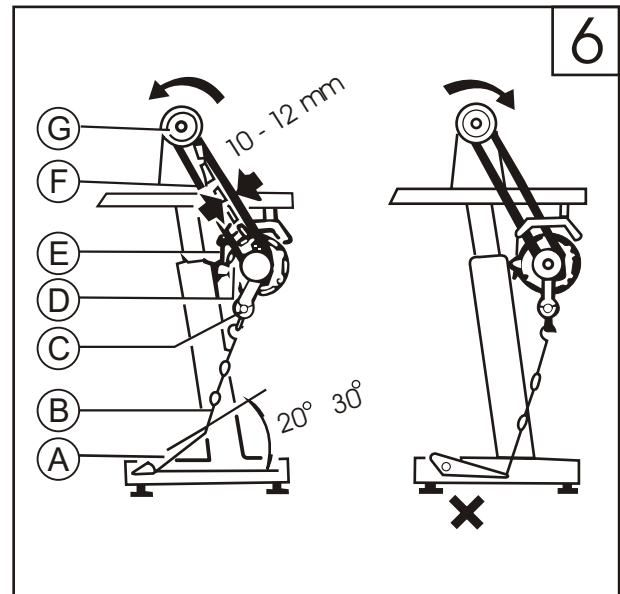
3.1.6 Connecting the clutch lever to the pedal (Fig.6)

1)The optimum tilt angle of pedal (A) with floor is approx.30 degree.

2)Adjust the clutch of the motor so that clutch lever (C) and draw bar (B) run in line.

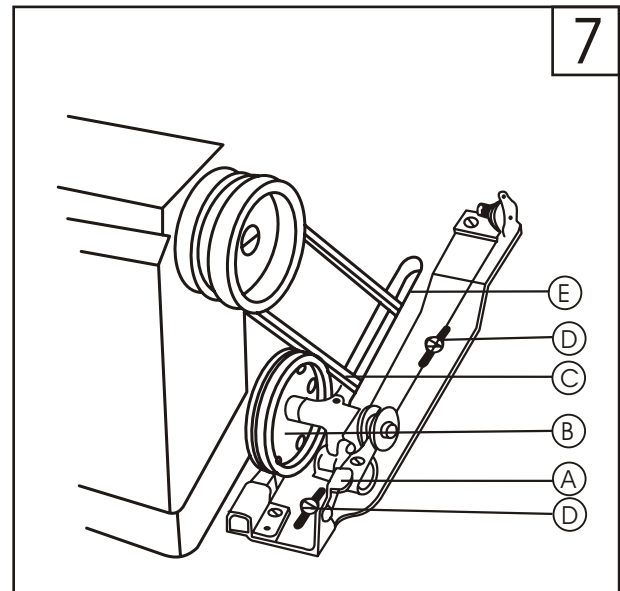
3)The machine balance wheel should rotate counterclockwise for normal sewing when view from opposite side of balance wheel (G). The motor is rotated in the same direction. The rotation can be reversed by reversing (turn over 180 deg.)the plug of motor.

4)Adjust the tension of V-belt (F) by moving the motor vertically. The proper tension of V-belt is a slack of 10-12mm when the belt is depressed at the belt span by finger.



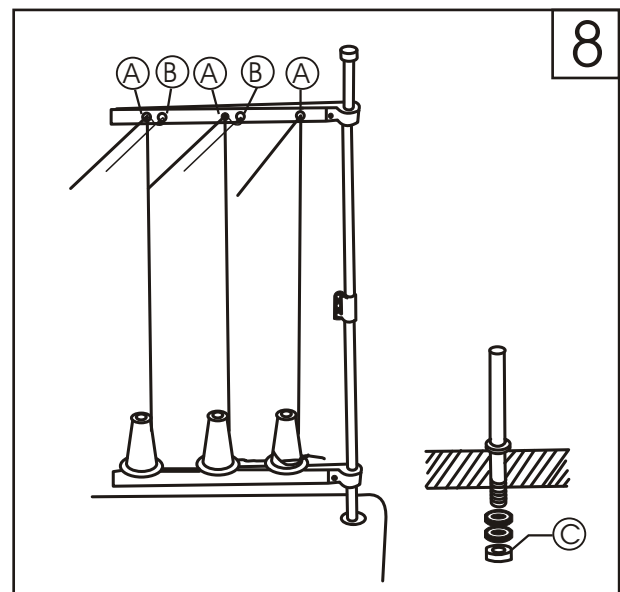
3.1.7 Installing the bobbin winder (Fig.7)

Align pulley (B) of bobbin winder with outside of belt (C) and should be kept a proper clearance between them, so that pulley B could be contacted with belt after the stop latch thumb lever (A) depressed, thereby belt drives the pulley B while machine running. After check bobbin winder is in parallel with belt slit E of table, fastened by two wood screws (D).



3.1.8 Installing the thread spool stand (Fig.8)

Locate thread spool stand at the right front of the table, note that spool rest may not obstruct when machine head is turned backward, then tighten wood screw.



3.2 Preparation

3.2.1 Cleaning the machine

Before delivery, the machine parts are coated with rust preventive grease, which may be hardened and contaminated by dust during storage and shipment. The grease must be removed by clean cloth with gasoline.

3.2.2 Examination

Though every machine is confirmed by strict inspection and test before delivery, the machine parts may be loosed or deformed after long distance transportation with jolt. A thorough examination must be performed after cleaning the machine. Turn the balance wheel to see if there is running obstruction, parts collision, uneven resistance or abnormal noise. If these exist, adjustment must be made accordingly before run.

3.2.3 Precaution before Start

a. Oiling (Fig.9)

Oil amount should be filled according to the marks in the oil reservoir. Mark (H) refers to the highest of oil amount; (L) refers to the lowest, be careful that the oil amount should not be lower than Mark (L), otherwise the machine parts can not be fed with oil and cause overheat and collision.

Be sure to use machine oil HA-8 or HJ-7

b. When the machine starts for the initial time or reuse after a long period of time, the proper oil amount should be filled in sections of machine shown by arrows in Fig 10, 11. When it is in operation, observe the oil sparking in oil screen to check the oil condition.

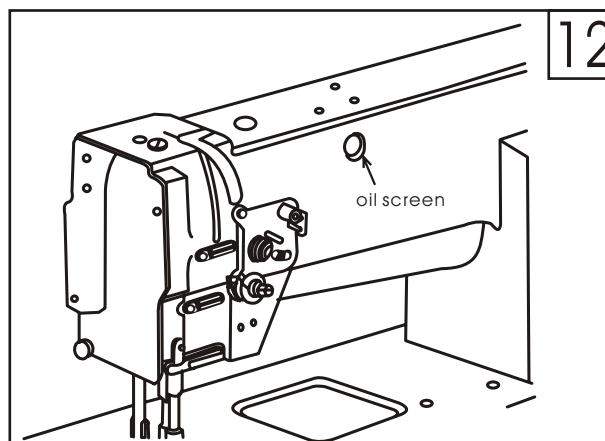
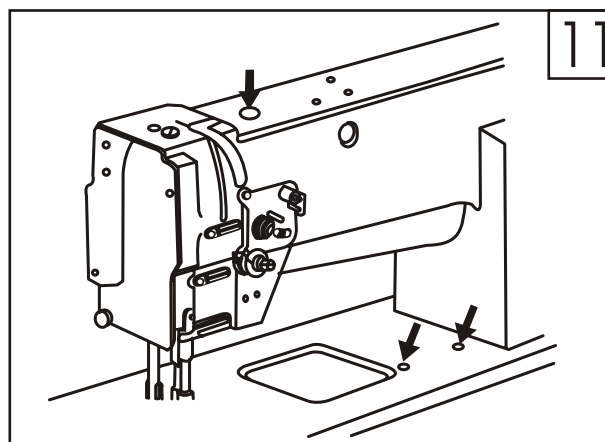
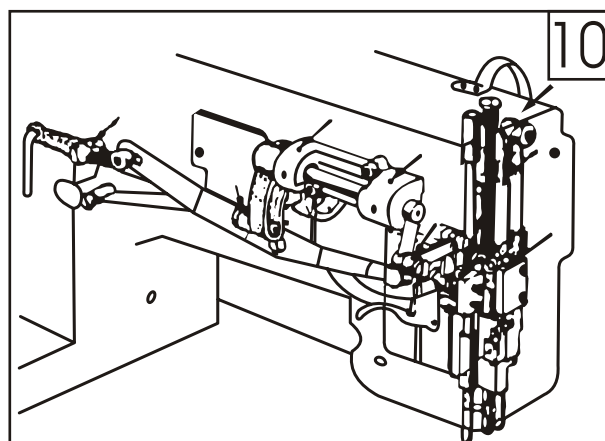
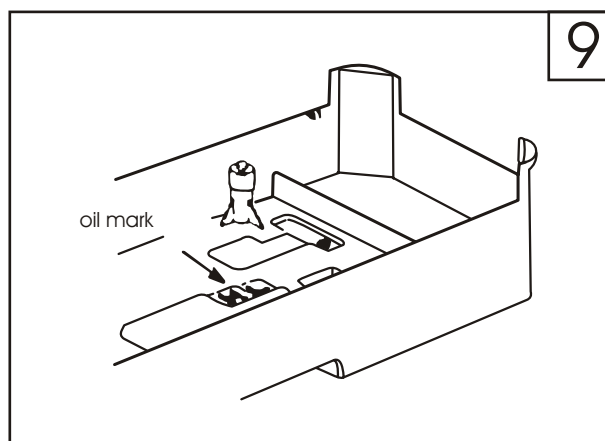
Note: when the machine needs drop oiling, do not start before drop oiling.

c. When a new machine starts running, for extending its life, please run at a medium and low speed (1000 spm) for about a month and then raise the speed gradually.

d. Please turn off the power when it is not in use or the operator leaves away from it.

e. Replace the oil every month. When replacing, fully drain off the old oil in the reservoir and add the new one.

f. The needle gauge options are: 6.4, 3.2, 4, 4.8, 8, 9.5, 12.7, 16, 19, 25.4. For getting it, the throat plate, presser foot or alternating foot, needle holder, feed dog, left and right sliding plates, thread guide should be changed. It is provided with 6.4mm when it leaves off the factory. For the other size, the relevant parts can be ordered from the factory.



4. Operation

4.1 Coordination between needle, thread and sewing material

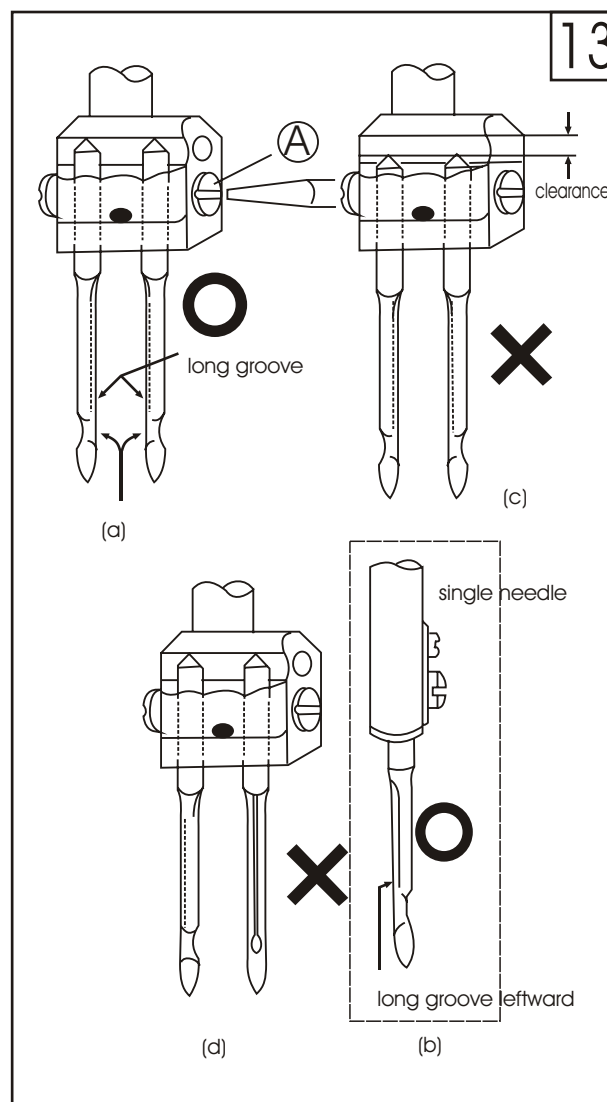
Please use needle DPX 17, Nm125-180. The coarseness of needle should be in accordance with the nature of material. If stitch on heavy duty material with a slim needle, the needle will be easily bent, skip or thread breakage occurs, on the contrary, stitch on tightly woven material with a very coarse needle, the material will be destroyed with over-big needle. So the needle and thread should be properly selected.

4.2 Needle installation (Fig.13)

Turn the balance wheel to lift needle bar to the highest position, loosen Needle Set Screw (A), fully insert the needle shank up to the bottom of needle socket, keeping the long grooves of the two needles opposite with each other, then tighten Screw (A). For single needle, keep the long groove of needle facing the left of the operator. See Fig (b).

Note: Fig.(c): insufficient insertion.

Fig.(d): wrong direction of needle long groove in insertion.



4.3 Winding the Bobbin thread

4.3.1 Winding method (Fig.14)

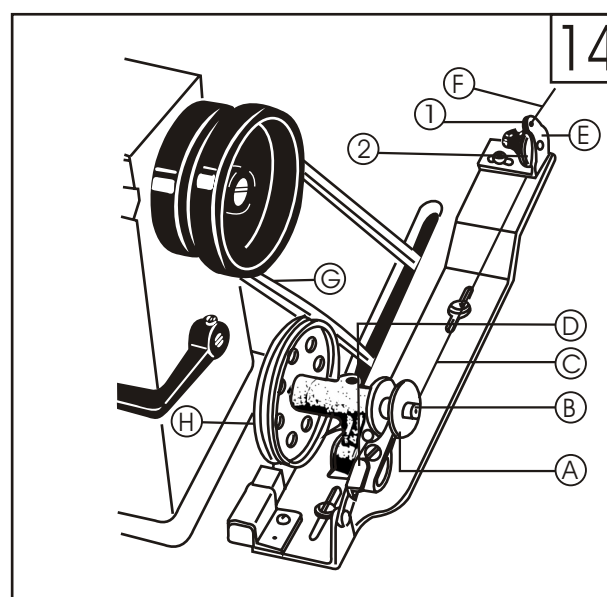
1) Install bobbin (A) to bobbin winder spindle (B).
2) Pass thread (C) from spool through the eye 1 on tension bracket (E). Pass it between tension discs 2, and then wind the end of the thread a few turns on the bobbin.

3) Push stop latch thumb lever (D) down to lock the bobbin, the winder pulley (F) is thereby pressed on belt (G).

4) Start the machine to wind thread.

Note when thread is wound without sewing operation, be sure to keep the presser foot lifted.

5) When the thread is fully wound, the bobbin winder stop latch automatically release the bobbin winder, thus stopping the winding motion.



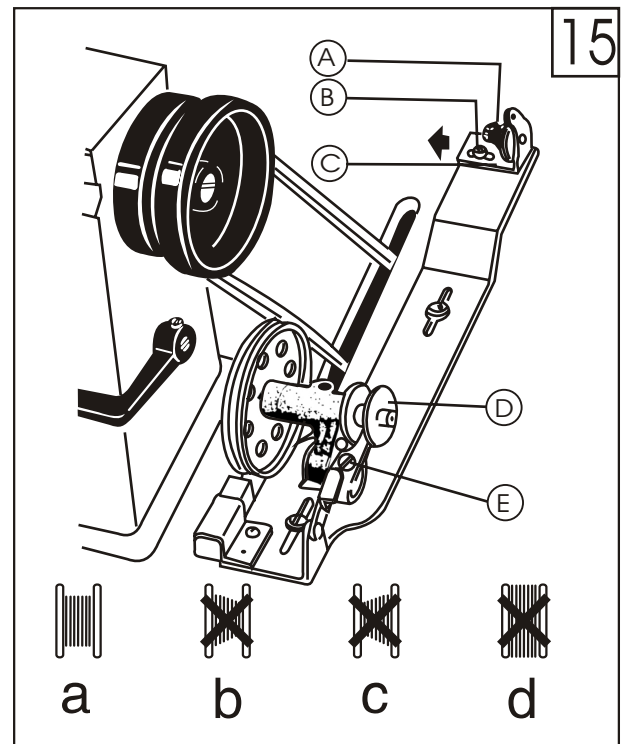
4.3.2 Winding adjustment (Fig.15)

1) Wound bobbin thread should be neat and tight, if not, adjust the thread tension by turning tension stud thumb nut (A) of bobbin winder tension bracket.

Note: nylon or polyester thread should be wound with light tension, otherwise bobbin (D) might be broken or deformed.

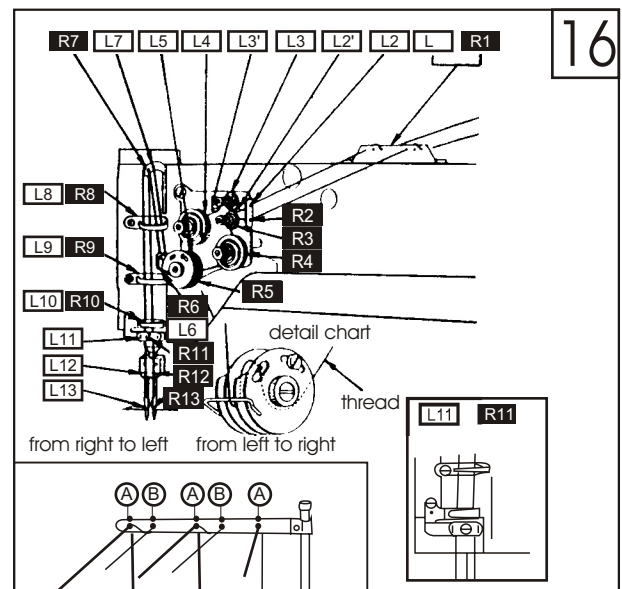
2) When the wound thread layer does not present a cylindrical shape as in Fig.15a, loosen tension bracket screw (B) and move tension bracket (C) leftward or rightward. If thread is wound as shown in Fig, 15b, move the tension bracket rightward, while if thread is wound as shown in Fig.15c, move the tension bracket leftward, After adequately positioning the tension bracket, tighten screw (B).

3) Do not over fill the bobbin, the optimum capacity of thread will fill about 80% of bobbin outside diameter, this can be adjusted by stop latch screw (E).



4.3.3 Threading (Fig.16)

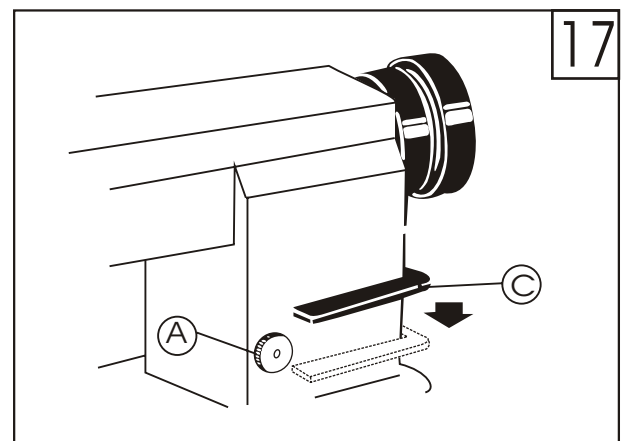
Every thread should be drawn through Thread Hole (A), when use light and smooth thread (polyester or long silk thread), it should be drawn through Hole (B), Keep the thread take-up lever in its highest position, draw every thread in the following numerical order.



4.3.4 The stitch length and forward and reverse sewing control (Fig.17)

The stitch length can be regulated by Stitch Length Dial (A). Turn it counter-clockwise to expand its length and clockwise to shorten its length. The numbers on Dial (A) show the sizes of the stitch length in mm.

For reverse feed, press down Release Feed Lever (C) to perform reverse sewing, Release the lever, the reverse feed lever can reset automatically and the forward sewing is resumed.

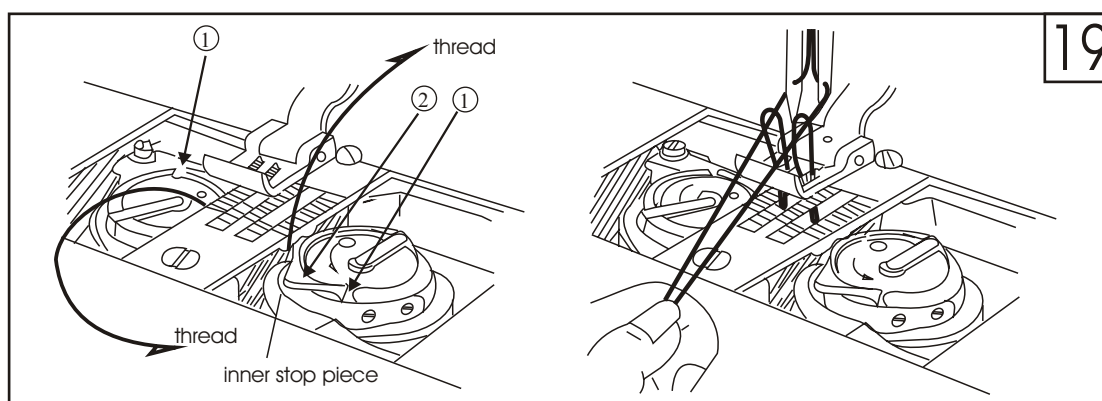
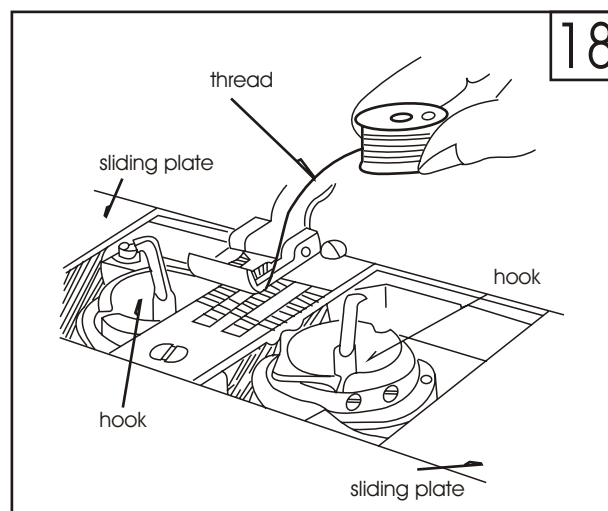


4.3.5 Placing bobbin (Fig.18)

Note: when bobbin is placed into the bobbin case, the thread should be wound properly in the correct direction shown in the figure.

4.3.6 Drawing thread from the bobbin (Fig.19)

- Draw the thread end to Bobbin Slot (1) shown in the figure, and pull it out down through the inner bobbin stop piece.
- Hold the thread with left hand, turn the balance wheel slowly and get the bobbin thread, then draw them a little apart from the presser foot.

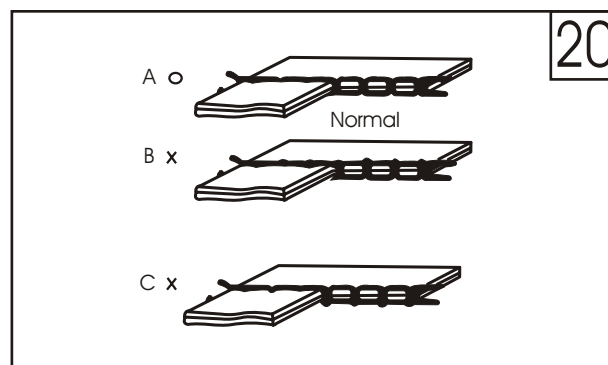


5. Machine Adjustment

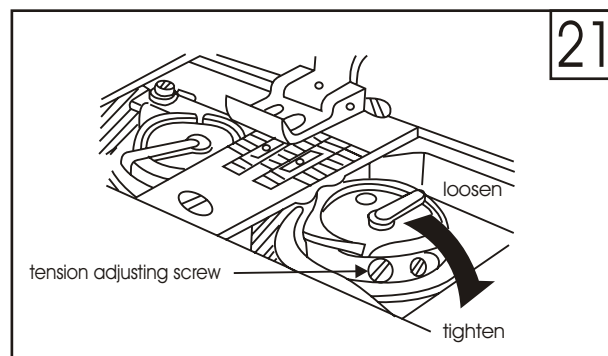
5.1 Thread tension adjustment

All forms of stitches are shown in Fig.20.

The normal stitch of sewing machine is shown as Fig.(A) If stitch is abnormal, the puckering and thread breakage will occur, and the needle thread tension and bobbin thread tension should be adjusted so that the normal stitch can be obtained.

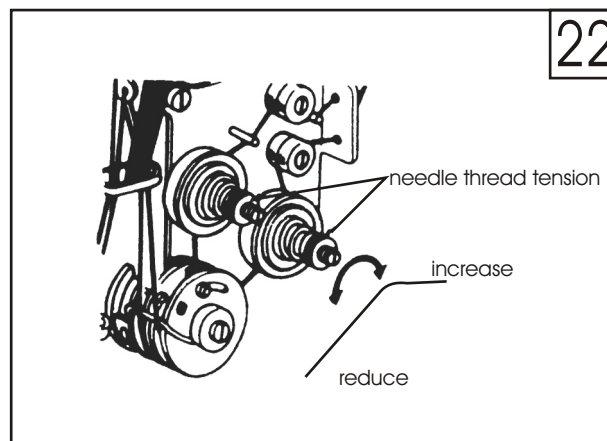


- If the stitch seam shows as Fig. 20B, indicates that the needle thread or bobbin thread tension is too loose, then turn the thread tension screw counter-clockwise to release the needle thread pressure; or turn the adjusting screw with a screwdriver to increase the bobbin thread tension. (see Fig.20,22)



- b. If the needle thread is too loose and the bobbin thread is too tight, then shows as Fig. 20C, And turn the thread tension screw clockwise to increase the needle thread tension; or turn loose the bobbin lace screw to reduce the bobbin thread tension. (See Fig. 21, 22)

For special sewing with special thread, the tension needed can be obtained by adjusting the power and stroke of the thread take-up spring.

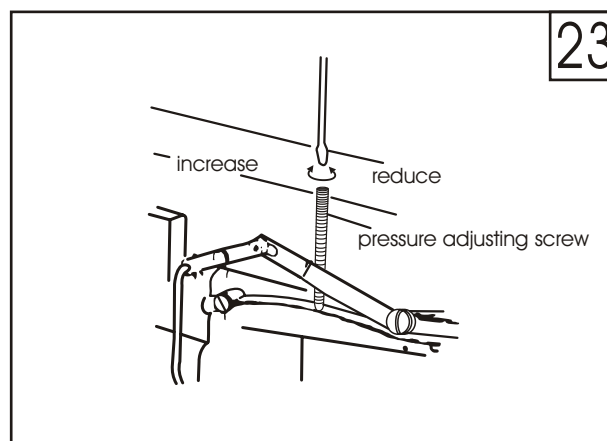


5.2 Adjusting the pressure of presser foot (Fig.23)

The pressure of the presser foot should be adjusted according to the thickness of the sewing materials. If stitch on heavy duty material, the pressure should be increased and turn the pressure adjusting screw on the back of the arm clockwise if reduce the pressure, turn it counter-clockwise.

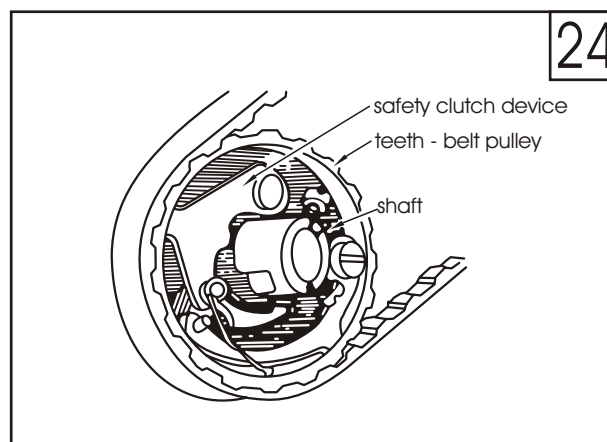
5.3 Use and adjustment of the safety clutch device

The function of the safety clutch device is to prevent the hook and teeth-belt from destroy when the needle thread is drawn into the hook for a normal load during the operation.



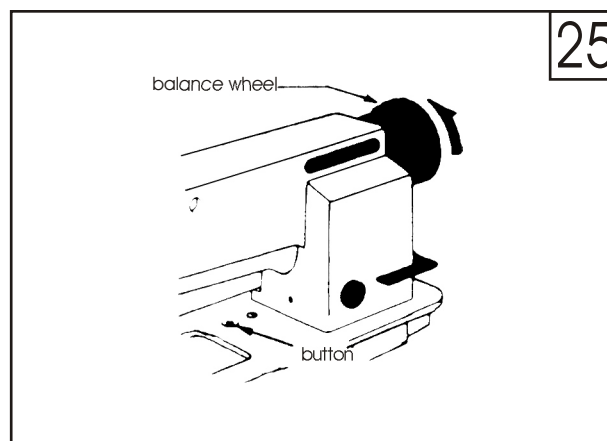
5.3.1 The function of the safety clutch device (Fig.24)

- When the safety clutch device is functioning, the teeth-belt will remove the load and the rock shaft will stop rotating, only the upper shaft rotates, and the machine stops work.
- Clean off the needle thread which is drawn in the hook.
- Turn the shaft of the teeth-belt with hand to check if the rock shaft can turn smoothly, then reset the safety clutch device.

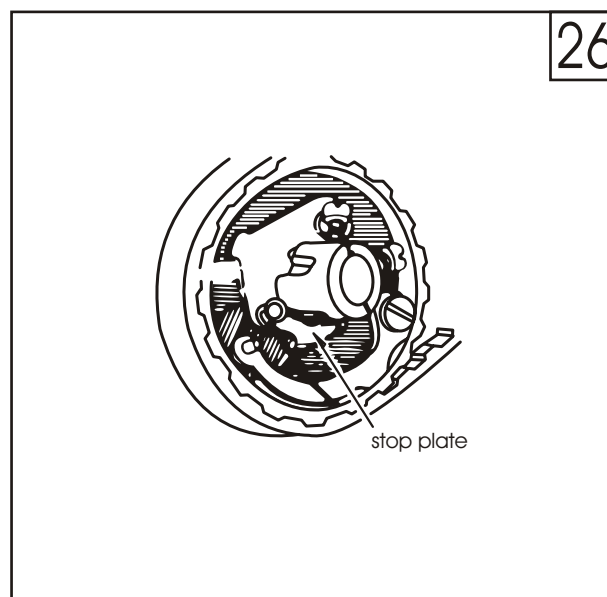


5.3.2 Resetting the safety clutch device.

- While press down the button in the bed surface with left hand, turn the balance wheel slowly with right hand in the direction shown in Fig. 25.

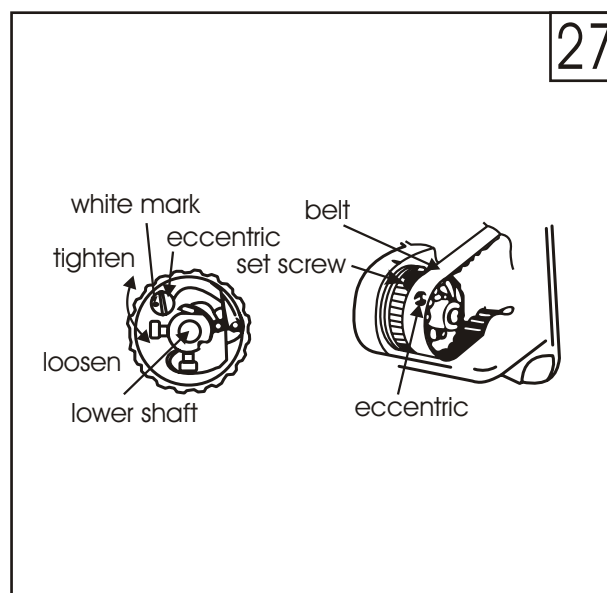


- b. When the stop plate stops the balance wheel, more strength is needed to turn the balance wheel to reset the safety clutch device.
- C. Release the button in the bed. So the resetting of it is OK. (See Fig.26)



5.3.3 Regulating the strength on the safety clutch device(Fig.27)

- a. When the white mark of the eccentric pin aims at the center of the rock shaft, indicates that the strength on the safety clutch device is the minimum. When the white mark points outward, the strength is properly increased.
- b. For regulating the strength of it, move the teeth - belt and loosen the set screw of the eccentric pin, and turn the eccentric pin.
- c. After regulation, please tighten the set screw.

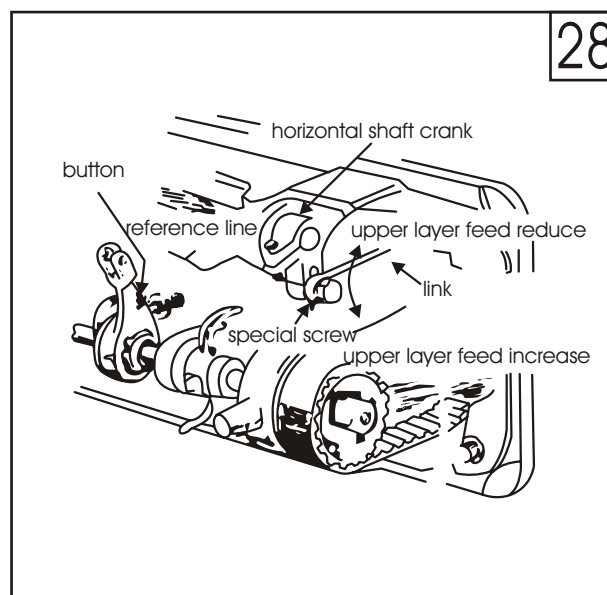


5.4 Upper feed adjustment (Fig.28)

If the upper and lower feed are not in timing during sewing, the long hole of the horizontal feed crank should be adjusted to get the length of upper feed.

Adjust as the following:

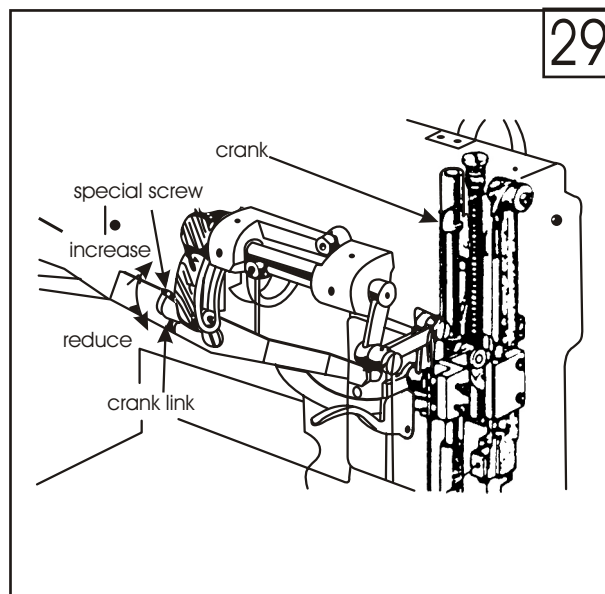
- a. Loosen the special screw.
- b. Move the special screw upward to reduce the feed amount or upper layer of material.
- c. Move the special screw downward to increase the feed amount. Theoretically when it is on the reference line of the horizontal feed crank, the upper feed amount equals to the lower feed amount.
- d. After adjustment, tighten the special screw.



5.5 Presser foot lift volume adjustment (Fig.29)

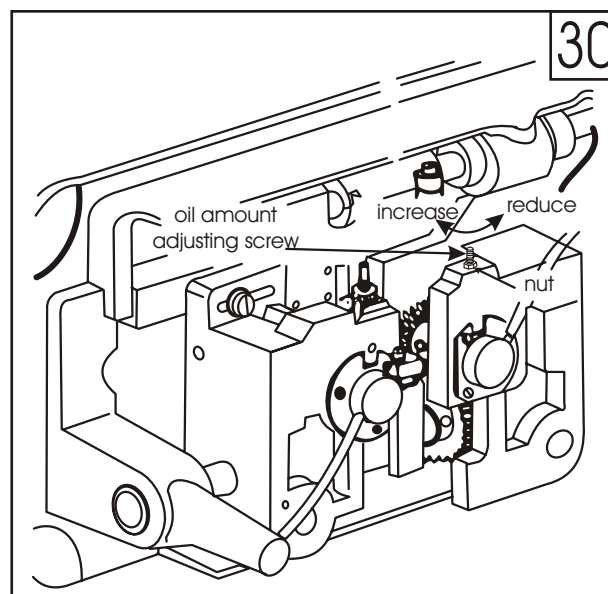
when stitch on the very elastic material or the thickness of the sewing material is changed. The adjustment should be done in the following order:

1. Loosen the special screw.
2. When the centerline distance between the special screw and the presser foot lift rear crank becomes shorter, the presser foot lift volume will become longer. On the contrary the distance becomes longer, the lift volume will become shorter.
3. After adjustment, tighten the special screw. The common presser foot lift volume can be adjusted in the range of 2-6 mm.

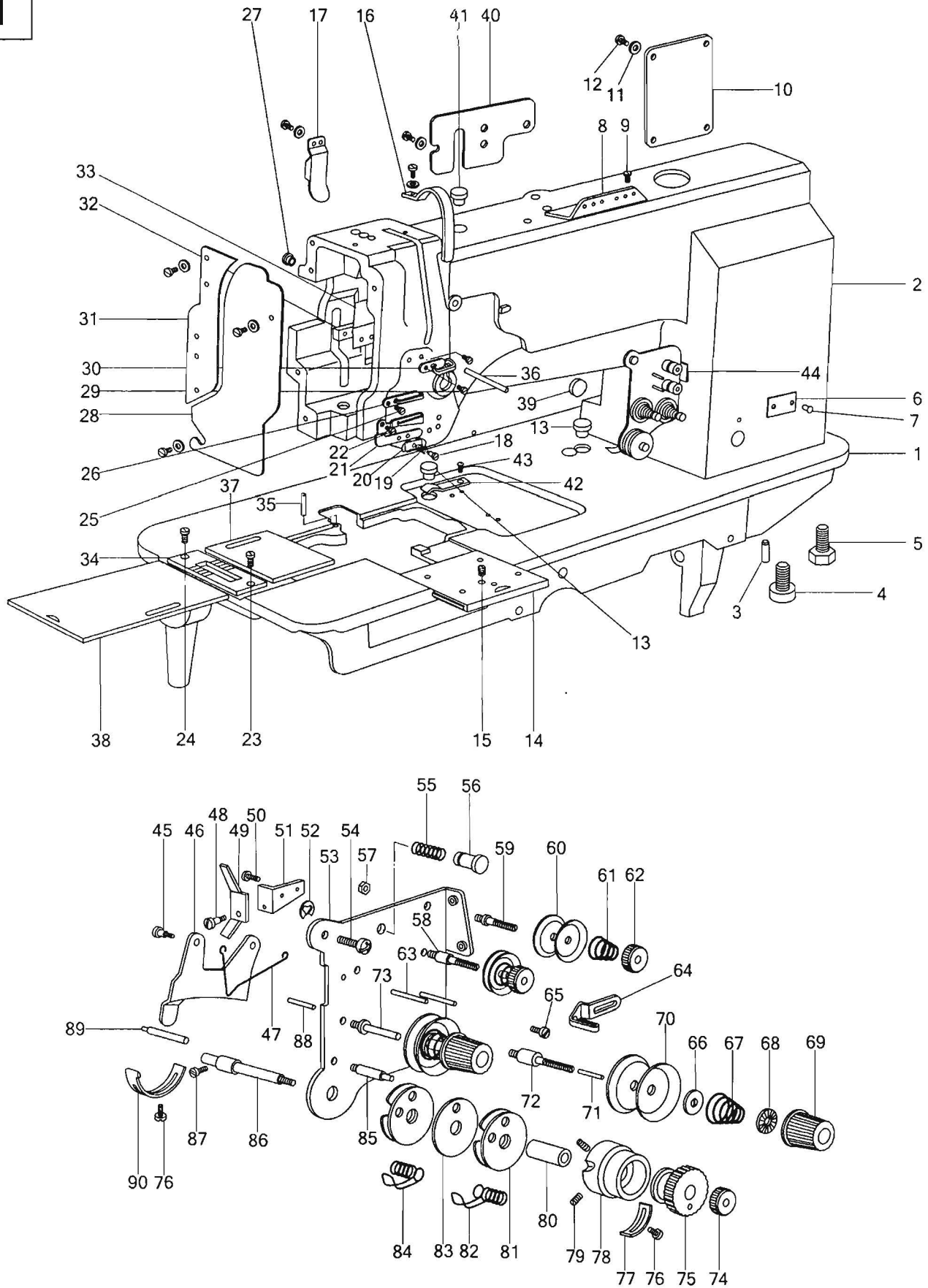


5.6 Hook oil amount adjustment (Fig.30)

It adopts plunger full auto lubrication system, even at very low speed, it can supply and suck oil very well. Generally only the hook oil amount can be adjusted, the other can not be adjusted. The hook oil amount can be obtained by the oil amount adjusting screw. First loosen the nut of the adjusting screw, turn the screw clockwise to increase the oil amount, on the contrary reduce the oil amount. After adjustment, tighten the nut.

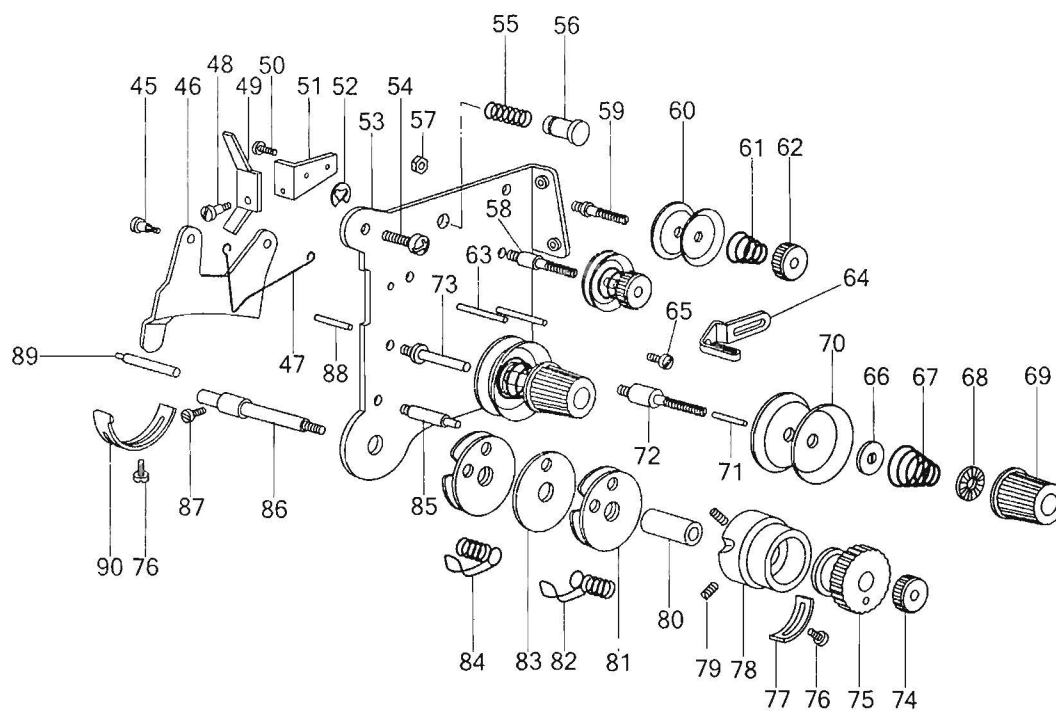
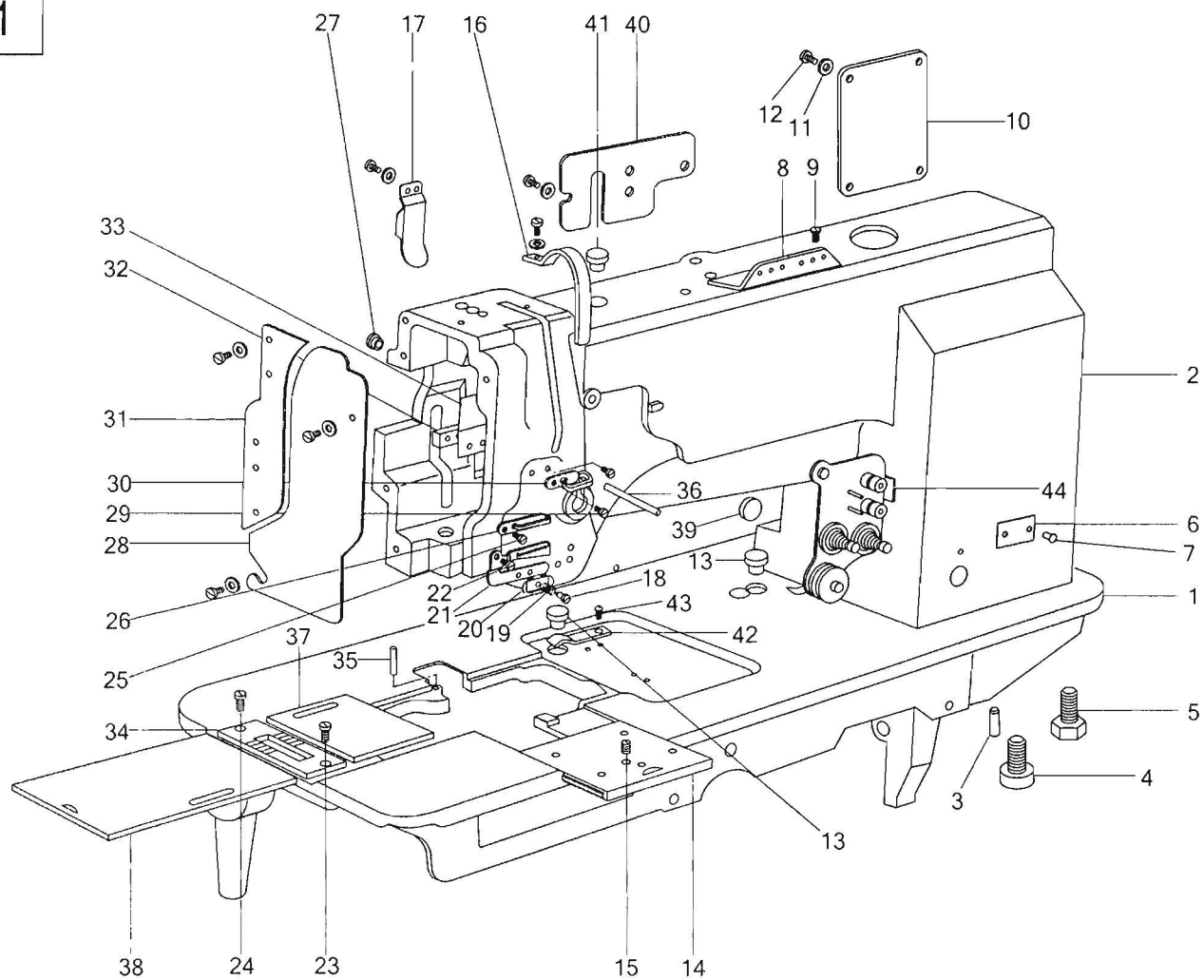


Parts Manual



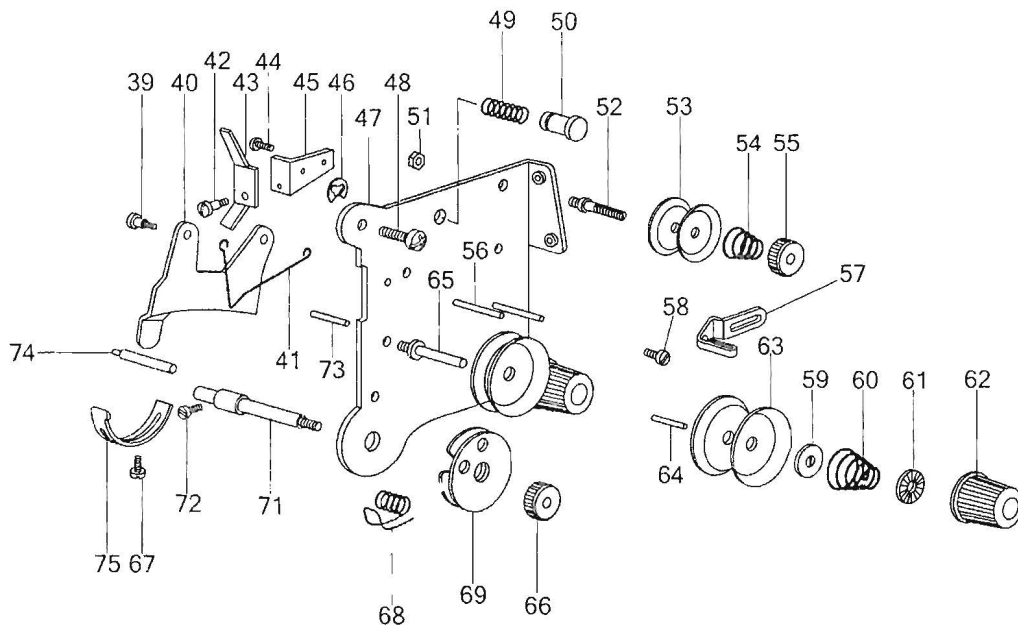
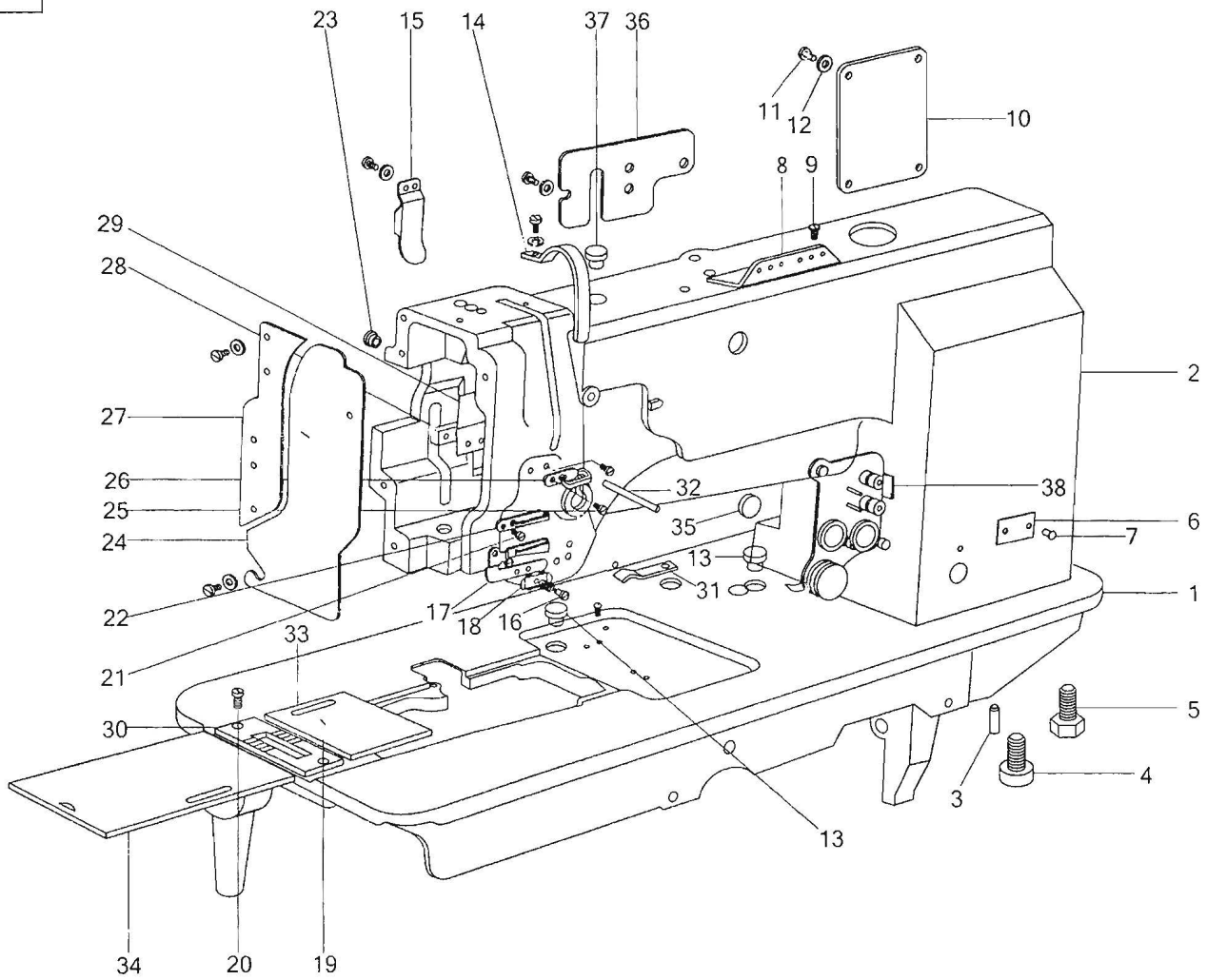
1. P2339RB Arm Parts

Line	Part Number	Description	Qt.	Notes
1	300-1001	Bed	1	
2	200-1003	Arm	1	
3	200-1005	Pin	2	GB/T117 6x30
4	300-1003	Screw	1	GB/T70.1 M10x32
5	200-1009	Screw	3	GB/T5781 M10x30
6	300-1004	Trade mark	1	
7	200-1014	Screw	2	GB827 2x5
8	200-1016	Upper thread guide	1	
9	200-1017	Screw	2	SM11/64"x40/8
10	200-1018	Back cover	1	
11	200-1019	Screw	15	SM11/64"x40/9
12	200-1377	Washer	16	
13	200-1020	Cover	2	
14	200-1021	Front slide plate	1	
15	200-1022	Screw	1	SM3/16"x32/5.4
16	200-1023	Thread take-up lever guard	1	
17	200-1024	Back front cover	1	
18	300-1007	Screw	1	
19	300-1008	Spring	1	
20	300-1009	Thread retainer	1	
21	300-1010	Low thread finger	1	
22	200-1025	Screw	1	SM9/64"x40/6.5
23	200-1028	Screw	1	
24	200-1029	Screw	1	SM11/64"x40
25	200-1030	Screw	1	SM9/64"x40
26	200-1031	Middle thread finger	1	
27	200-1032	Rubber plug	2	
28	200-1033	Face plate	1	
29	200-1034	Screw	2	SM3/16"x28
30	200-1035	Upper thread guide	1	
31	200-1036	Guide set plate	1	
32	200-1037	Set plate	1	
33	200-1038	Oil retainer	1	
34	300-1011	Needle plate	1	
35	300-1012	Pin shaft	1	
36	200-1042	Thread releasing lever	1	
37	200-1043	Right sliding plate	1	
38	200-1041	Left sliding plate	1	
39	200-1045	Rubber plug	1	
40	200-1048	Cover	1	
41	200-1050	Rubber plug	1	
42	200-1040	Spring retaining plate	1	
43	100-1034	Screw	1	
44	300-1013	Thread tension Complete	1	
45	200-1073	Screw	2	



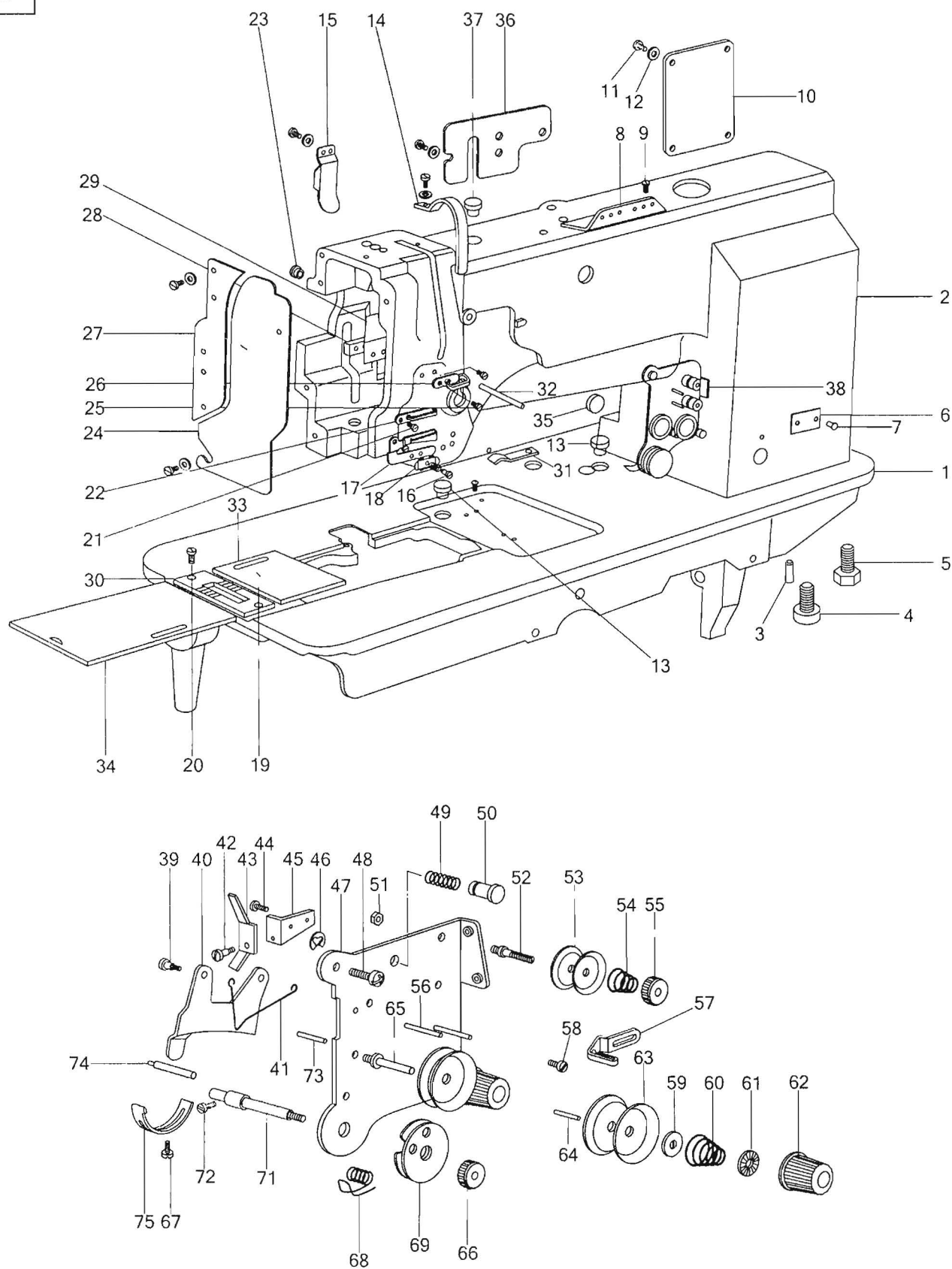
1. P2339RB Arm Parts

Line	Part Number	Description	Qt.	Notes
46	200-1049	Thread releasing plate	1	
47	200-1089	Thread releasing spring	1	
48	200-1053	Screw	1	
49	200-1055	Thread releasing moving lever	1	
50	200-1059	Screw	1	
51	200-1059	Setting plate	1	GB8965
52	200-1061	Ring	1	
53	200-1063	Thread tension plate	1	
54	200-1250	Screw	1	
55	200-1066	Spring	1	
56	200-1068	Thread tension button	1	
57	200-1069	Nut	2	
58	300-1014	Screw (long)	1	
59	200-1071	Screw	1	
60	200-1074	Small thread tension plate	4	
61	200-1075	Spring	2	
62	200-1078	Nut	2	
63	200-1080	Thread guide pin	3	
64	200-1082	Thread finger	1	
65	200-1025	Screw	1	
66	200-1085	Thread releasing plate	2	
67	200-1087	Spring	2	
68	200-1088	Stopping plate	2	
69	200-1090	Nut	2	
70	200-1091	Thread tension plate	4	
71	200-1062	Thread releasing pin	1	
72	300-1015	Screw (right)	1	
73	200-1094	Screw (left)	1	
74	200-1064	Nut	1	
75	300-1016	Bushing	1	
76	200-1077	Screw	1	
77	200-1079	Position bracket	1	
78	300-1017	Guide bushing	1	
79	300-1018	Setting screw	1	
80	200-1059	Bushing	1	
81	200-1096	Thread control plate	2	
82	300-1020	Thread take-up spring	1	
83	300-1021	Thread finger	1	
84	200-1095	Thread take-up spring	1	
85	300-1022	Screw	1	
86	300-1023	Shaft	1	
87	200-1084	Screw	1	
88	200-1098	Thread releasing pin (long)	1	
89	200-1099	Thread releasing lever	1	
90	200-1079	Position plate	1	



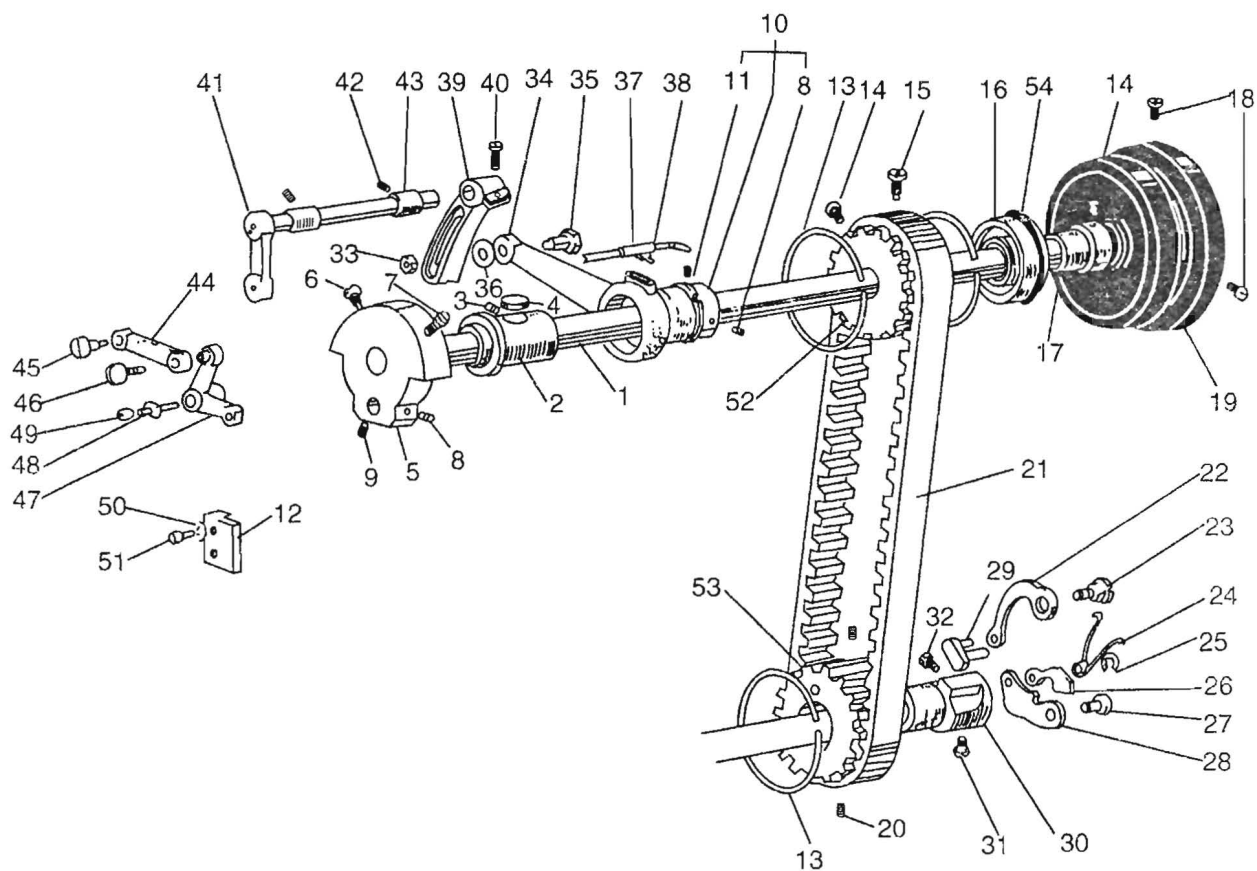
2. P1255RB Arm Parts

Line	Part Number	Description	Qt.	Notes
1	200-1002	Bed	1	
2	200-1003	Arm	1	
3	200-1005	Pin	2	GB/T117 6x30
4	200-1007	Screw	1	GB/T70.1 M10x25
5	200-1009	Screw	3	GB/T5781 M10x30
6	200-1012	Trade mark	1	
7	200-1014	Screw	2	GB827 2x5
8	200-1016	Upper thread guide	1	
9	200-1017	Screw	2	SM11/64"x40/8
10	200-1018	Back cover	1	
11	200-1019	Screw	15	SM11/64"x40/9
12	200-1377	Washer	15	
13	200-1020	Cover	2	
14	200-1023	Thread take-up lever guard	1	
15	200-1024	Back front cover	1	
16	200-1025	Screw	1	
17	200-1026	Lower thread finger	1	
18	200-1027	Oil felt	1	
19	200-1028	Screw	2	
20	200-1029	Screw	1	
21	200-1030	Screw	1	
22	200-1031	Middle thread finger	1	
23	200-1032	Rubber plug	2	
24	200-1033	Face plate	1	
25	200-1034	screw	2	
26	200-1035	Upper thread guide	1	
27	200-1036	Guide set plate	1	
28	200-1037	Set plate	1	
29	200-1038	Oil retainer	1	
30	200-1039	Needle plate	1	
31	200-1040	Spring retaining plate	1	
32	200-1042	Thread releasing lever	1	
33	200-1043	Right sliding plate	1	
34	200-1041	Left sling plate	1	
35	200-1045	Rubber plug	1	
36	200-1048	Cover	1	
37	200-1050	Rubber plug	1	
38	200-1046	Thread tension Complete	1	
39	200-1073	Screw	2	
40	200-1049	Thread releasing plate	1	
41	200-1089	Thread releasing spring	1	
42	200-1053	Screw	1	
43	200-1055	Thread releasing moving lever	1	
44	200-1059	Screw	1	
45	200-1059	Setting plate	1	



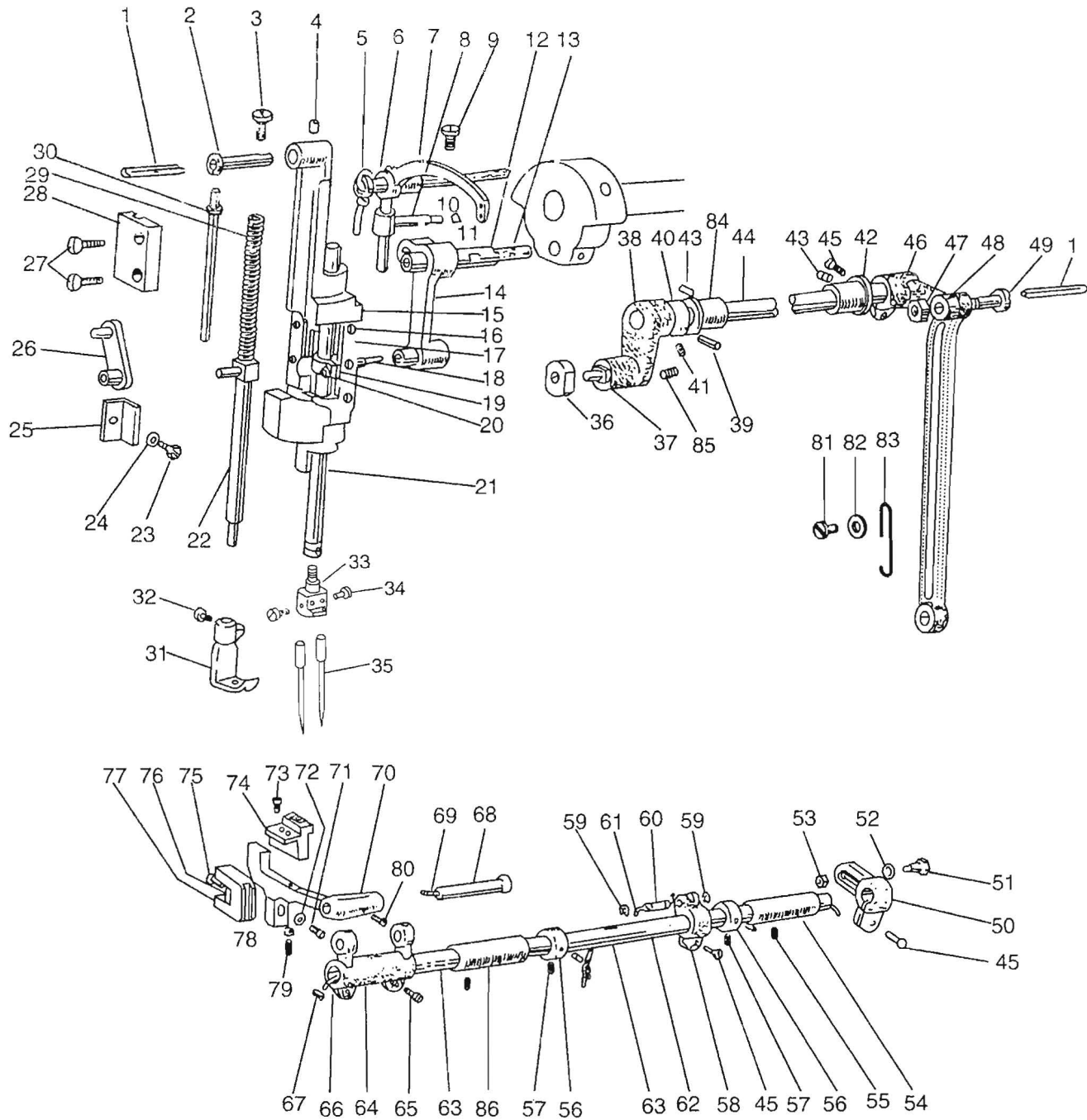
2. P1255RB Arm Parts

Line	Part Number	Description	Qt.	Notes
46	200-1061	Ring	1	GB8965
47	200-1063	Thread tension plate	1	
48	200-1250	Screw	1	
49	200-1066	Spring	1	
50	200-1068	Thread tension button	1	
51	200-1069	Nut	1	
52	200-1071	Screw	1	
53	200-1074	Small thread tension plate	2	
54	200-1075	Spring	1	
55	100-1192	Nut	1	
56	200-1080	Thread guide pin	2	
57	200-1082	Thread finger	1	
58	200-1025	Screw	1	
59	200-1085	Thread releasing plate	1	
60	200-1087	Spring	1	
61	200-1088	Stopping plate	1	
62	200-1090	Nut	1	
63	200-1091	Thread tension plate	2	
64	200-1062	Thread tension pin (short)	1	
65	200-1094	Thread tension screw	1	
66	200-1064	nut	1	
68	200-1095	thread take-up spring	1	
69	200-1096	Thread control plate	1	
71	200-1097	Shaft	1	
72	200-1084	Screw	1	
73	200-1098	Thread releasing pin (long)	1	
74	200-1099	Thread releasing lever	1	
75	200-1079	Position plate	1	



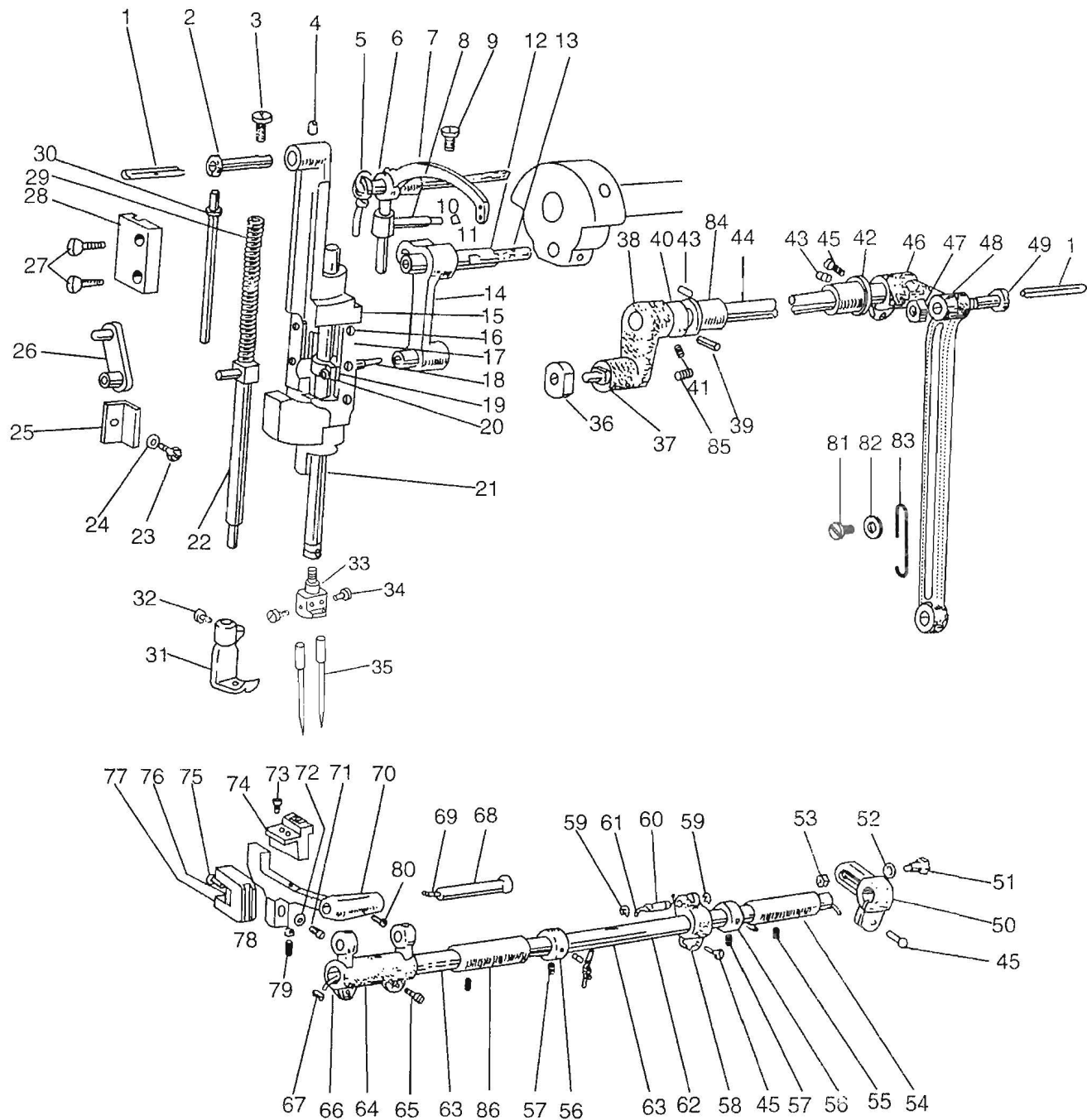
3. Upper Shaft Presser Foot Parts

Line	Part Number	Description	Qt.	Notes
1	200-1100	Upper shaft	1	
2	200-1102	Front bushing	1	
3	200-1103	Screw	1	SM1/4"x24/13
4	200-1104	Oil felt	1	
5	200-1105	Needle bar crank	1	
6	200-1107	Screw	1	SM9/32"/28
7	100-1071	Screw	1	GB7-1
8	200-1109	Screw	3	SM1/4"x40/7
9	200-1110	Screw	1	SM1/4"x40/4
10	200-1111	Presser foot lift eccentric cam	1	
11	200-1112	Stop ring	1	GB894.1 5
12	200-1115	Slot for front crank sliding block	1	
13	200-1116	Stop ring	3	
14	200-1118	Screw	3	SM15/64"x28/8.5
15	200-1119	Screw	1	SM15/64"x28/15
16	200-1120	Ball bearing	1	20x47x14
17	200-1122	Rear bushing	1	
18	200-1123	Screw	2	SM15/64"x28/12
19	200-1124	Balance wheel	1	
20	200-1125	Screw	2	SM15/64"x28/4.5
21	200-1126	Timing belt	1	
22	200-1127	Spring plate	1	
23	200-1128	Pin	1	
24	200-1129	Spring	1	
25	200-1130	Split stop ring	1	GB896 3
26	200-1132	Stop plate	1	
27	200-1133	Nail	1	
28	200-1134	Control plate	1	
29	200-1135	Connecting	1	
30	200-1136	Bushing	1	
31	200-1137	Screw	1	SM15/64"x28/10.5
32	200-1138	Screw	1	SM15/64"x28/10
33	200-1139	Nut	1	
34	200-1140	Connecting lever	1	
35	200-1141	Screw	1	
36	200-1426	Washer	1	
37	200-1143	Oil tube complete	1	
38	100-1241	Spring	1	
39	200-1144	Presser foot lift rear crank	1	
40	200-1145	Screw	1	SM1/4"x24/16
41	200-1146	Presser foot lift front crank	1	
42	200-1147	Screw	2	SM1/4"x24/8
43	200-1148	Bushing	2	
44	200-1149	Presser foot lift link	1	
45	200-1150	Screw	1	
46	200-1151	Screw	1	SM11/64"x40/6
47	200-1152	Presser foot lift movable plate	1	
48	200-1153	Needle bearing shaft	1	
49	200-1154	Ball bearing	1	
50	200-1377	Washer	2	
51	200-1156	Screw	2	SM11/64x40/10
52	200-1157	Upper timing wheel	1	
53	200-1158	Lower timing wheel	1	
54	200-1159	Ring	1	



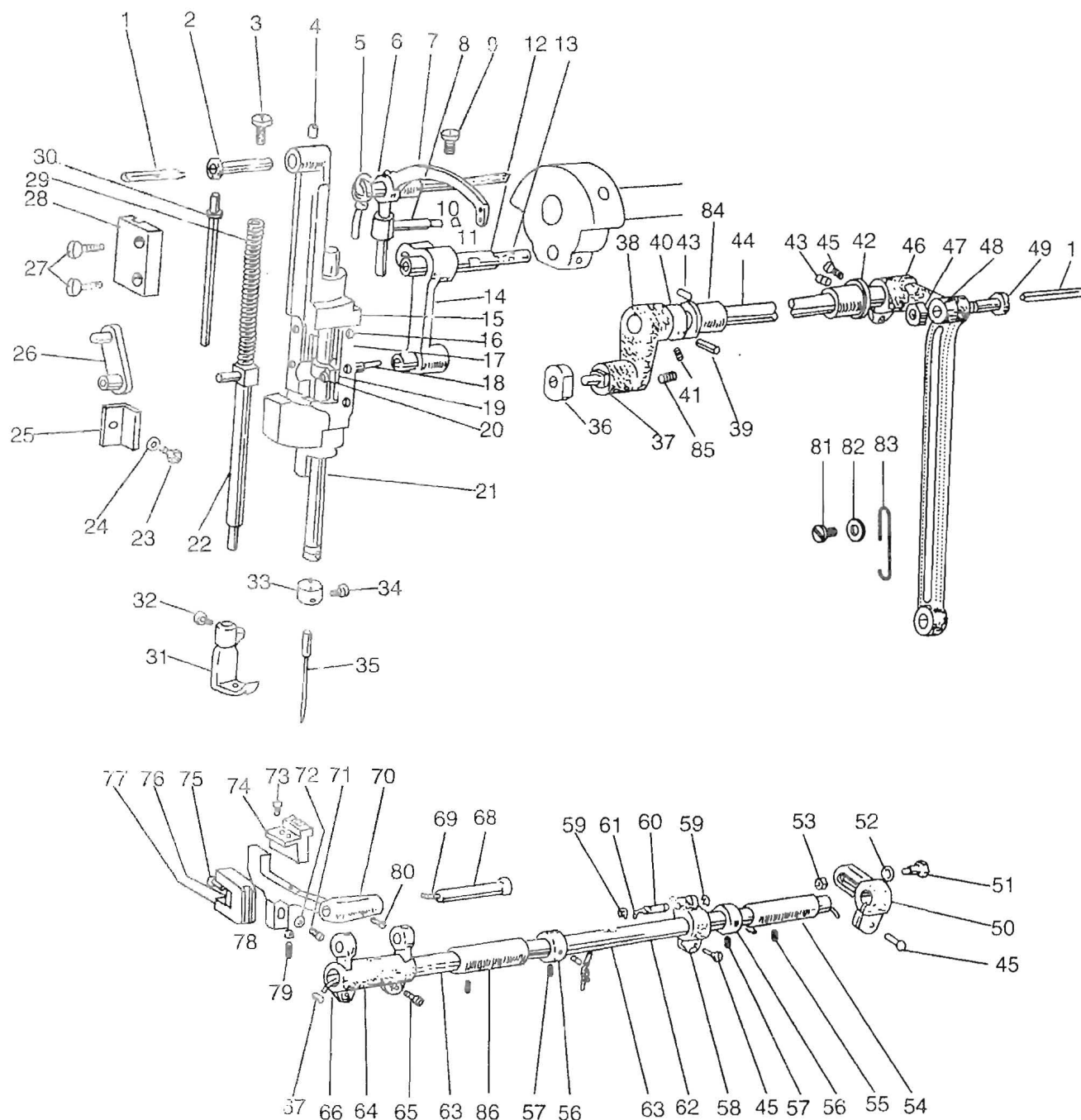
4. P2339RB Needle Bar And Lower Feed Parts

Line	Part Number	Description	Qt.	Notes
1	200-1382	Oil wick	2	φ2.5x80
2	200-1383	Shaft	1	
3	200-1384	Screw	1	SM5/16"x28/10
4	100-1049	Screw	1	SM15/64"x28/8.5
5	200-1385	Oil wick	1	φ2.5x240
6	200-1386	Bushing	1	
7	200-1387	Thread take-up lever	1	
8	200-1388	Sliding block	1	
9	200-1123	Screw	1	SM15/64"x28/12
10	200-1389	Oil wick	1	φ3x25
11	200-1390	Plug	1	
12	200-1391	Pin	1	
13	200-1392	Oil wick	1	φ3x80
14	200-1393	Needle bar link	1	
15	200-1394	Needle bar moving holder	1	
16	200-1395	Screw	6	SM3/32"x56/4.6
17	200-1396	Shim	2	
18	200-1108	Oil felt	1	
19	200-1398	Needle bar adaptor	1	
20	200-1399	Screw	1	SM9/64"x40/8.5
21	200-1400	Needle bar	1	
22	200-1164	Presser bar	1	
23	200-1403	Screw	1	SM11/64"x40/12
24	200-1377	Washer	1	
25	200-1165	Needle bar guide plate	1	
26	200-1404	Presser bar link	1	
27	200-1405	Screw	2	SM11/64x40/15
28	200-1406	Guide plate	1	
29	200-1407	Spring	1	
30	200-1408	Reel for spring	1	
31	200-1409	Small presser foot	1	
32	100-1034	Screw	1	
33	200-1410	Needle clamp	1	
34	200-1411	Screw	2	SM9/64"x40/4.3
35	200-1401	Needle	2	DPx17 23#
36	200-1412	Sliding block	1	
37	200-1413	Shaft	1	
38	200-1414	Left crank	1	
39	200-1168	Pin	1	GB/T117 4x24
40	200-1416	Washer	1	
41	200-1417	Screw	2	
42	200-1418	Bushing	1	
43	200-1147	Screw	2	SM1/4"x24/8
44	200-1169	Shaft	1	
45	200-1145	Screw	3	



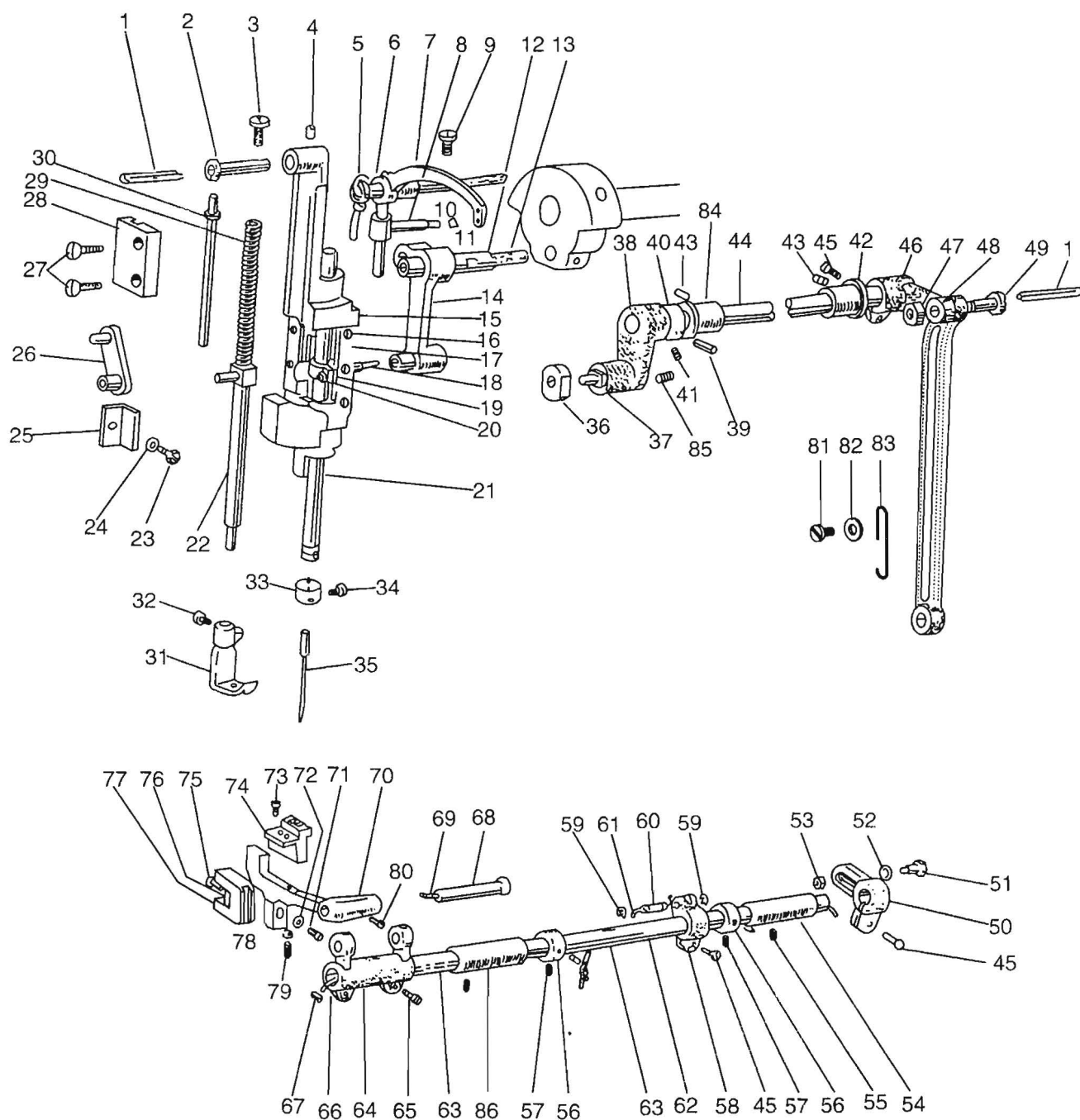
4. P2339RB Needle Bar And Lower Feed Parts

Line	Part Number	Description	Qt.	Notes
46	200-1420	Rear crank	1	
47	200-1421	Nut	1	
48	200-1422	Link	1	
49	200-1423	Screw	1	
50	200-1424	Right crank	1	
51	200-1425	Pin	1	
52	200-1426	Washer	1	
53	200-1139	Nut	1	
54	200-1427	Bushing	1	
55	200-1103	Screw	2	
56	200-1428	Collar	2	
57	200-1110	Screw	4	SM1/4"x40/4
58	200-1429	Feed crank	1	
59	200-1170	Split stop ring	2	GB896 6
60	200-1430	Pin	1	
61	200-1431	Oil wick	1	φ3x55
62	200-1172	Feed shaft	1	
63	200-1433	Oil felt	2	
64	200-1434	Feed connecting crank (left)	1	
65	200-1435	Screw	2	SM3/16"x28/12
66	200-1238	Oil wick	1	φ2.5x430
67	200-1436	Oil wick clamp	1	
68	200-1437	Shaft	1	
69	200-1438	oil wick	1	
70	200-1439	Feed dog supporter	1	
71	100-1201	Screw	1	SM15/64"x28/16
72	200-1173	Washer	1	GB/T95 6
73	200-1441	Screw	2	SM1/8"x40/7
74	200-1442	Feed dog supporter	1	
75	200-1444	Screw	1	SM1/8"x44/4
76	200-1445	Oil wick	1	
77	200-1446	Feed dog lift fork	1	
78	200-1447	Nut	1	
79	200-1448	Screw	1	SM1/8"x40/13.5
80	200-1449	Screw	1	SM11/64"x40/6
81	200-1084	Screw	1	
82	200-1175	Washer	1	
83	200-1325	Spring	1	
84	200-1176	Front bushing	1	
85	100-1060	Screw	1	
86	200-1177	Bushing	1	



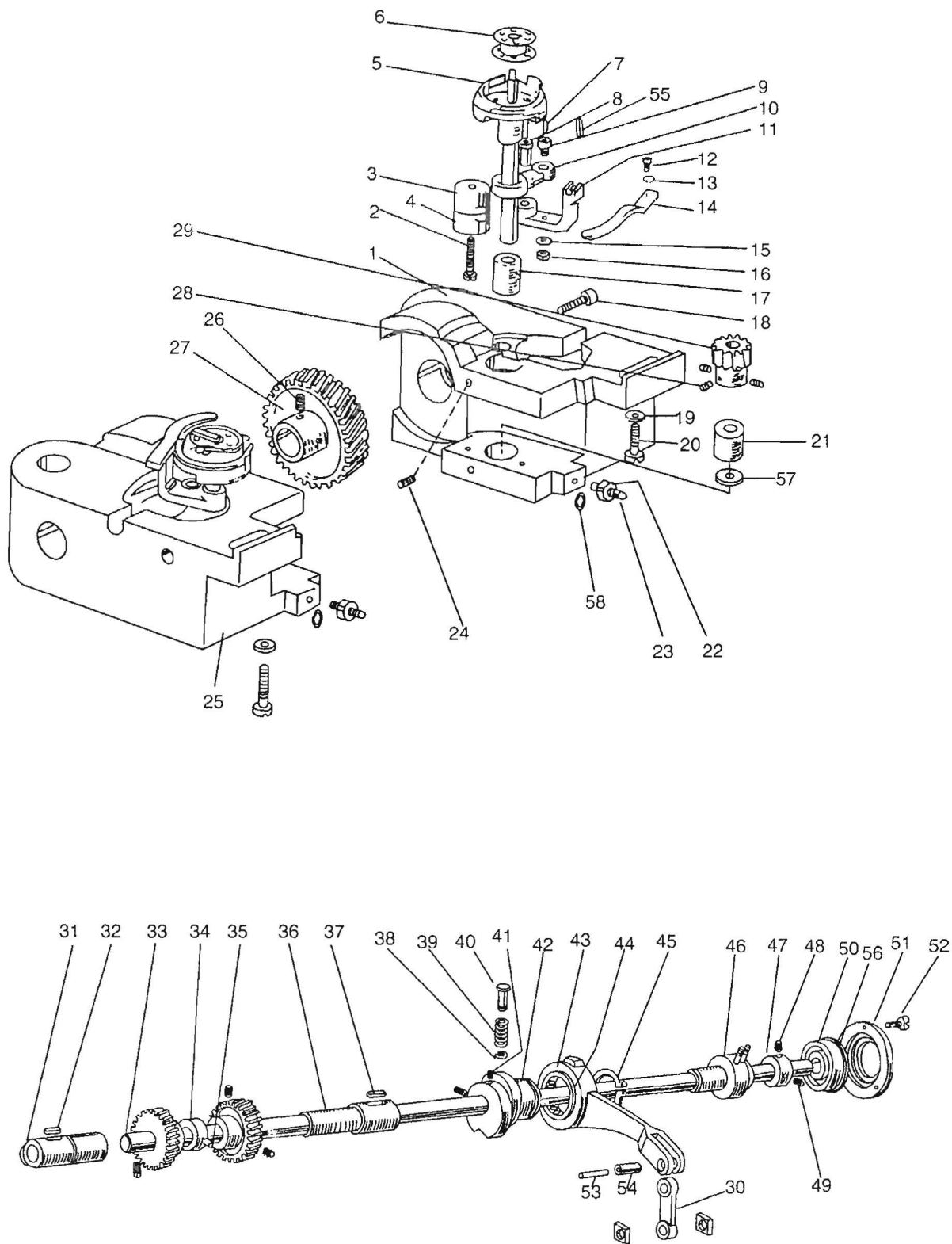
5. P1255RB Needle Bar And Lower Feed Parts

Line	Part Number	Description	Qt.	Notes
1	200-1382	Oil wick	2	φ2.5x80
2	200-1383	Shaft	1	
3	200-1384	Screw	1	SM5/16"x28/10
4	100-1049	Screw	1	SM15/64"x28/8
5	200-1385	Oil wick	1	φ2.5x240
6	200-1386	Bushing	1	
7	200-1387	Thread take-up lever	1	
8	200-1388	Sliding block	1	
9	200-1123	Screw	1	SM15/64"x28/12
10	200-1389	Oil wick	1	φ3x25
11	200-1390	Plug	1	
12	200-1391	Pin	1	
13	200-1392	Oil wick	1	φ3x80
14	200-1393	Needle bar link	1	
15	200-1394	Needle bar moving holder	1	
16	200-1395	Screw	6	SM3/32"x56/4.6
17	200-1396	Shim	2	
18	200-1108	Oil felt	1	
19	200-1398	Needle bar adaptor	1	
20	200-1399	Screw	1	SM9/64"x40/8.5
21	200-1163	Needle bar	1	
22	200-1164	Presser bar	1	
23	200-1403	Screw	1	SM11/64"x40/12
24	200-1377	Washer	1	
25	200-1165	Needle bar guide plate	1	
26	200-1404	Presser bar link	1	
27	200-1405	Screw	2	SM11/64x40/15
28	200-1406	Guide plate	1	
29	200-1407	Spring	1	
30	200-1408	Reel for spring	1	
31	100-1192	Small presser foot	1	
32	100-1027	Screw	1	
33	100-1077	Needle bar thread ring	1	φ6.15±0.05
34	200-1166	Screw	2	SM9/64"x40/4.3
35	200-1401	Needle	2	DPx17 23#
36	200-1412	Sliding block	1	
37	200-1413	Shaft	1	
38	200-1414	Left crank	1	
39	200-1168	Pin	1	GB/T117 4x24
40	200-1416	Washer	1	
41	200-1417	Screw		
42	200-1418	Bushing	1	
43	200-1147	Screw	2	SM1/4"x24/8
44	200-1169	Shaft	1	
45	200-1145	Screw	3	



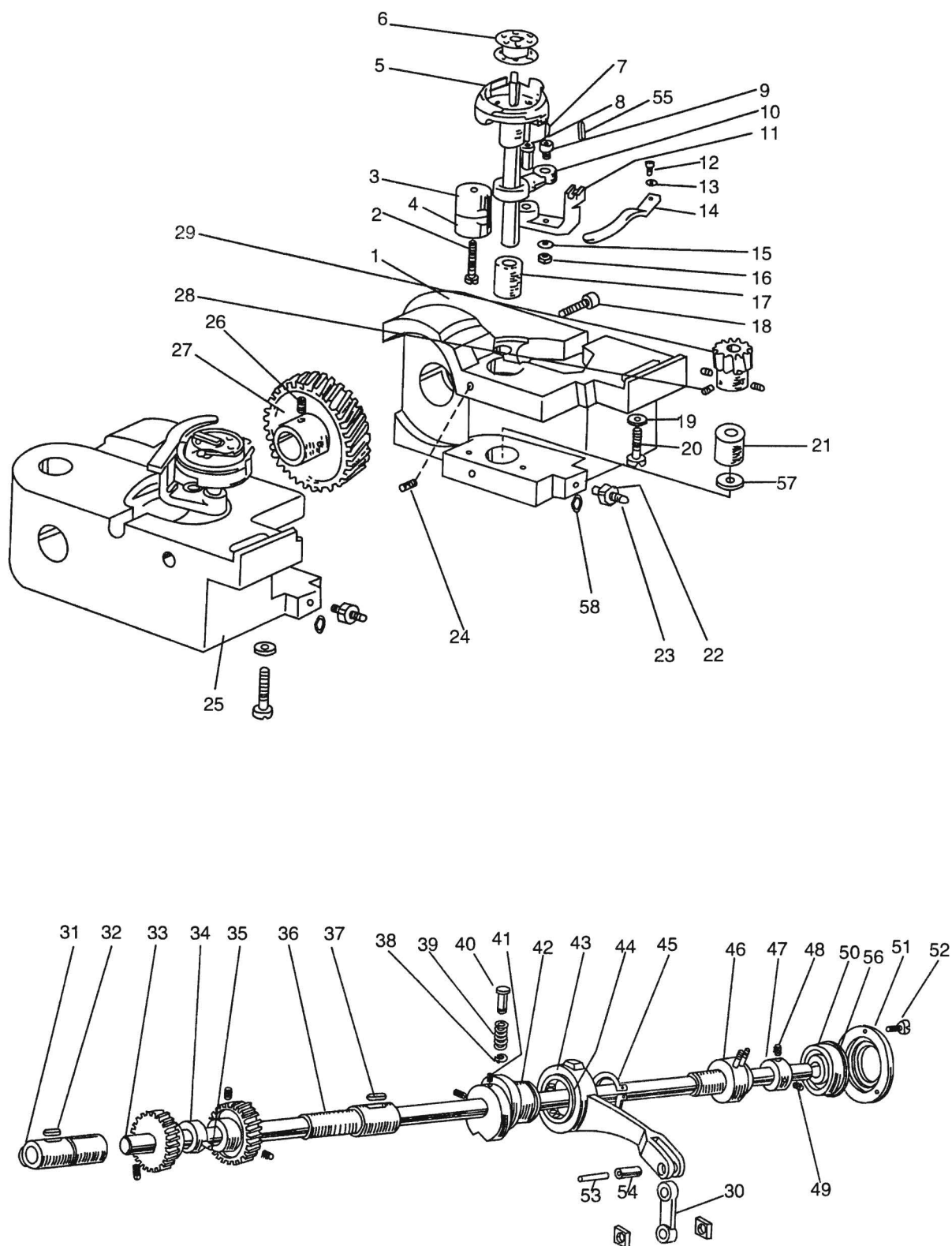
5. P1255RB Needle Bar And Lower Feed Parts

Line	Part Number	Description	Qt.	Notes
46	200-1420	Rear crank	1	
47	200-1421	Nut	1	
48	200-1422	Link	1	
49	200-1423	Screw	1	
50	200-1424	Right crank	1	
51	200-1425	Pin	1	
52	200-1426	Washer	1	
53	200-1139	Nut	1	
54	200-1427	Bushing	1	
55	200-1103	Screw	2	
56	200-1428	Collar	2	
57	200-1110	Screw	4	SM1/4"x40/4
58	200-1429	Feed crank	1	
59	200-1170	Split stop ring	2	GB896 6
60	200-1430	Pin	1	
61	200-1431	Oil wick	1	φ3x55
62	200-1172	Feed shaft	1	
63	200-1433	Oil felt	2	
64	200-1434	Feed connecting crank (left)	1	
65	200-1435	Screw	2	SM3/16"x28/12
66	200-1238	Oil wick	1	φ2.5x430
67	200-1436	Oil wick clamp	1	
68	200-1437	Shaft	1	
69	200-1438	oil wick	1	
70	200-1440	Feed dog supporter	1	
71	100-1201	Screw	1	SM15/64"x28/16
72	200-1173	Washer	1	GB/T95 6
73	200-1369	Screw	2	SM1/8"x40/7
74	200-1174	Feed dog	1	
75	200-1444	Screw	1	SM1/8"x44/4
76	200-1445	Oil wick	1	
77	200-1446	Feed dog lift fork	1	
78	200-1447	Nut	1	
79	200-1448	Screw	1	SM1/8"x40/13.5
80	200-1449	Screw	1	SM11/64"x40/6
81	200-1084	Screw	1	
82	200-1377	Washer	1	
83	200-1325	Spring	1	
84	200-1176	Front bushing	1	
85	100-1060	Screw	1	
86	200-1177	Bushing	1	



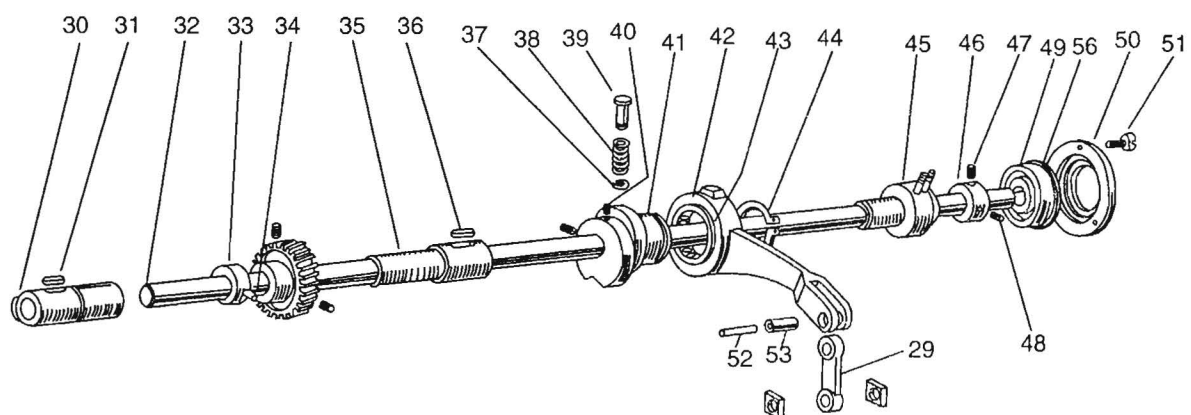
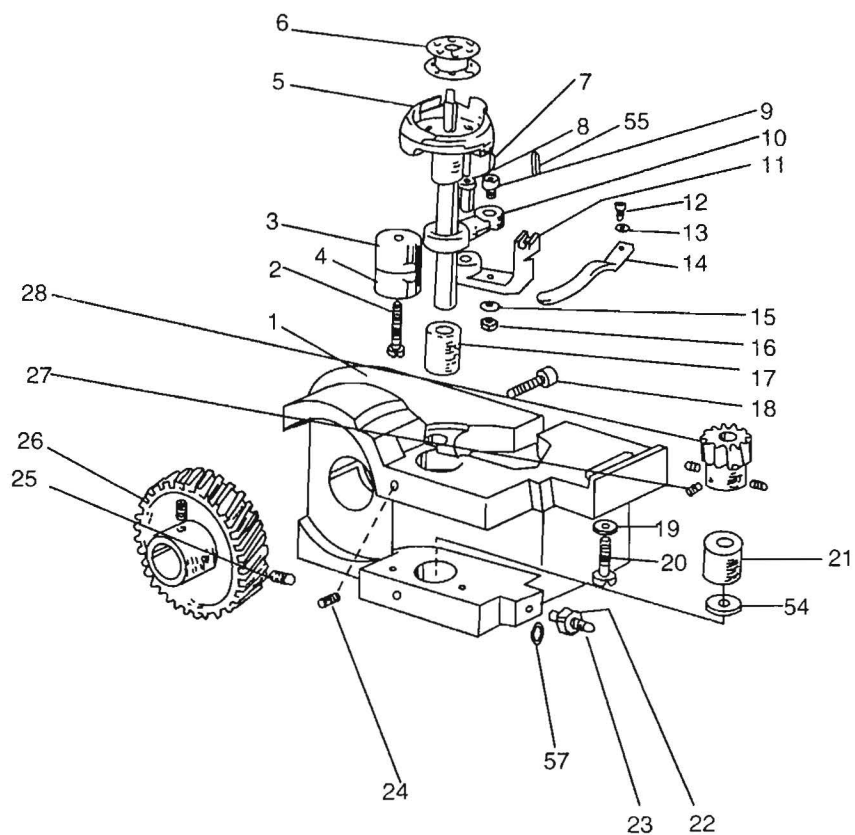
6. P2339RB Rock Shaft And Thread Looping Parts

Line	Part Number	Description	Qt.	Notes
1	200-1178	Right hook saddle	1	SM15/64"x28
2	200-1179	Screw	2	
3	200-1180	Upper bushing	2	
4	200-1181	Lower bushing	2	
5	200-1182	Hook	2	
6	200-1183	Bobbin	2	φ2.5x14
7	200-1184	Oil wick	2	
8	200-1185	Hinge shaft	2	
9	200-1186	Screw	2	
10	200-1187	Connecting lever	2	
11	200-1188	Thread finger bracket	2	SM9/64"x40/4.5 D=0.5
12	200-1077	Screw	2	
13	200-1377	Washer	2	
14	200-1189	Thread finger	2	
15	200-1190	Spring washer	2	
16	200-1191	Nut	2	SM3/16"x32
17	200-1192	Bushing	2	
18	200-1193	Screw	2	
19	200-1194	Washer	2	
20	200-1195	Screw	2	
21	200-1196	Lower bushing	2	SM1/4"x40/5
22	200-1197	Nut	2	
23	200-1200	Screw	2	
24	200-1125	Screw	4	
25	200-1201	left hook saddle	1	
26	200-1202	Screw	4	SM1/4"x40/4
27	200-1203	Spiral gear	2	
28	200-1110	Screw	6	
29	200-1204	Spiral gear	2	
30	200-1205	Feed link	1	
31	200-1207	Left bushing	1	φ25x45
32	200-1208	Oil wick	1	
33	200-1209	Rock shaft	1	
34	200-1210	Feed dog lift cam	1	
35	200-1212	Screw	1	
36	200-1213	Right bushing	1	SM15/64"x28/3.8
37	200-1215	Oil wick	1	
38	200-1216	Split stop ring	1	
39	200-1217	Spring	1	
40	200-1218	Button	1	
41	200-1219	Screw	2	SM15/64"x28/13.5
42	200-1220	Feed cam	1	
43	200-1221	Feed link	1	
44	200-1222	Needle bearing	1	
45	200-1223	Spring stop ring	1	



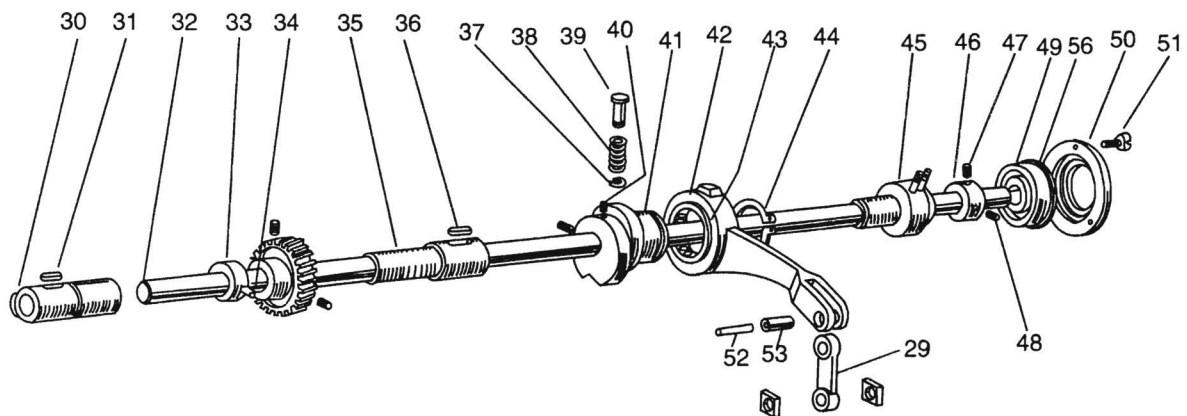
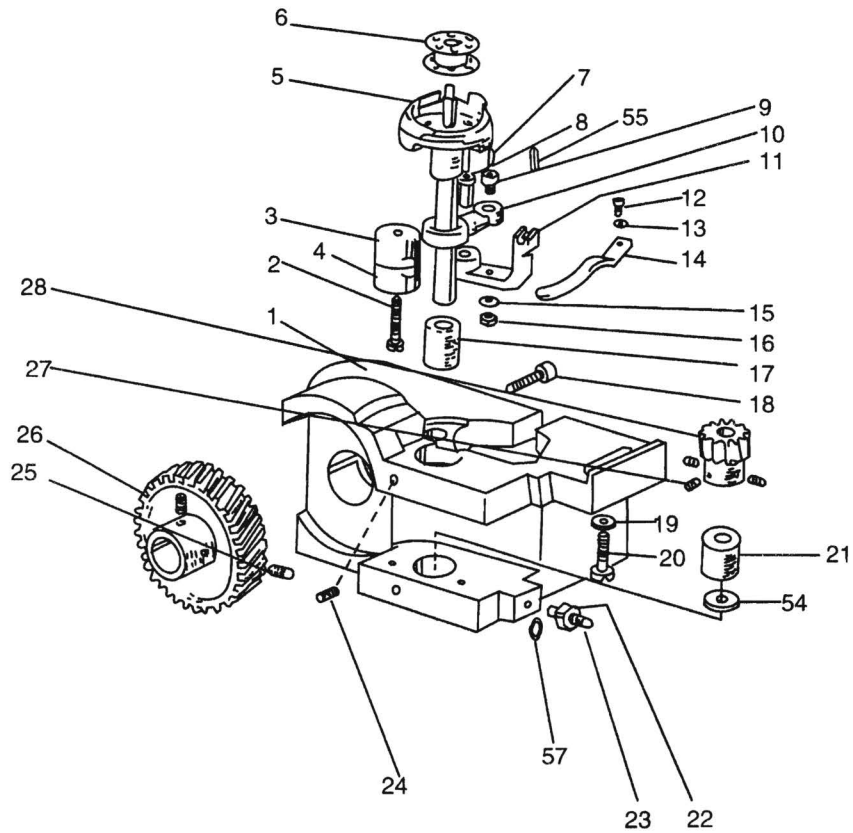
6. P2339RB Rock Shaft And Thread Looping Parts

Line	Part Number	Description	Qt.	Notes
46	200-1206	Middle bushing	1	
47	200-1226	Rear bushing	1	
48	400-1105	Screw	1	
49	200-1202	Screw	1	SM1/4"x40/5
50	200-1227	Ball bearing	1	17x40x12
51	200-1229	Bearing press ring	1	
52	200-1230	Screw	3	SM9/64"x40/7
53	200-1231	Oil wick	1	
54	200-1233	Feed link pin	1	
55	200-1234	Oil wick	2	
56	200-1235	Ring	1	
57	200-1232	Washer	2	
58	200-1236	Washer	1	GB 955 5



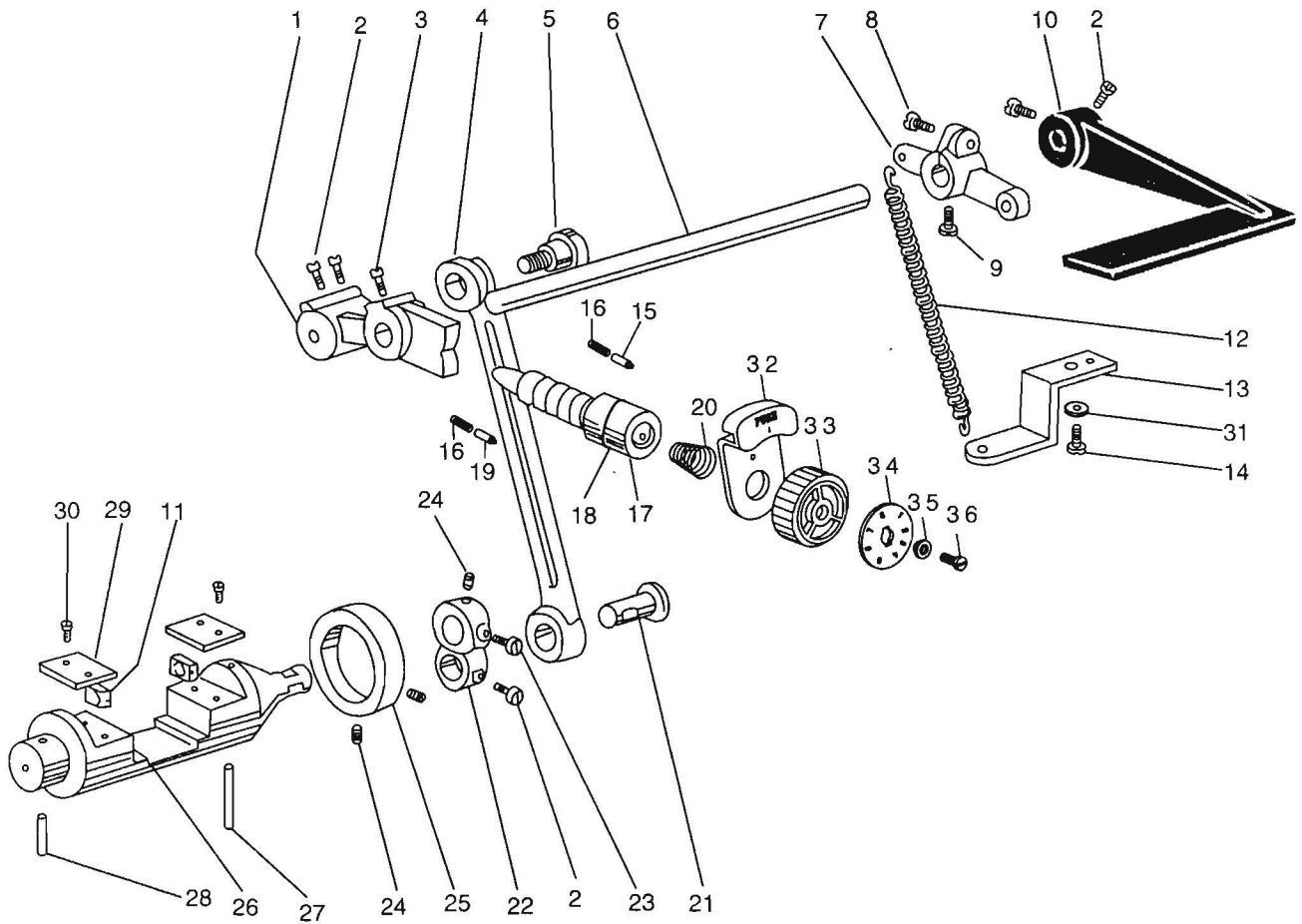
7. P1255RB Rock Shaft And Thread Looping Parts

Line	Part Number	Description	Qt.	Notes
1	200-1178	Right hook saddle	1	SM15/64"x28
2	200-1179	Screw	1	
3	200-1180	Upper bushing	1	
4	200-1181	Lower bushing	1	
5	200-1182	Hook	1	
6	200-1183	Bobbin	1	φ2.5x14
7	200-1184	Oil wick	1	
8	200-1185	Hinge shaft	1	
9	200-1186	Screw	1	
10	200-1187	Connecting lever	1	
11	200-1188	Thread finger bracket	1	SM9/64"x40/4.5
12	200-1077	Screw	1	
13	200-1377	Washer	1	
14	200-1189	Thread finger	1	
15	200-1190	Spring washer	1	
16	200-1191	Nut	1	SM3/16"x32
17	200-1192	Bushing	1	
18	200-1193	Screw	1	
19	200-1194	Washer	1	
20	200-1195	Screw	1	
21	200-1196	Lower bushing	1	SM1/4"x40/5
22	200-1197	Nut	1	
23	200-1200	Screw	1	
24	200-1125	Screw	2	
25	200-1202	Screw	2	
26	200-1203	Spiral gear	1	SM15/64"x28/3.8
27	200-1110	Screw	3	
28	200-1204	Spiral gear	1	
29	200-1205	Feed link	1	
30	200-1207	Left bushing	1	
31	200-1208	Oil wick	1	φ25x45
32	200-1209	Rock shaft	1	
33	200-1210	Feed dog lift cam	1	
34	200-1398	Screw	1	
35	200-1213	Right bushing	1	
36	200-1215	Oil wick	1	φ2.5x85 GB896 5
37	200-1216	Split stop ring	1	
38	200-1217	Spring	1	
39	200-1218	Button	1	
40	200-1219	Screw	2	
41	200-1220	Feed cam	1	HK263416 GB894.1 26
42	200-1221	Feed link	1	
43	200-1222	Needle bearing	1	
44	200-1223	Spring stop ring	1	
45	200-1206	Middle bushing	1	



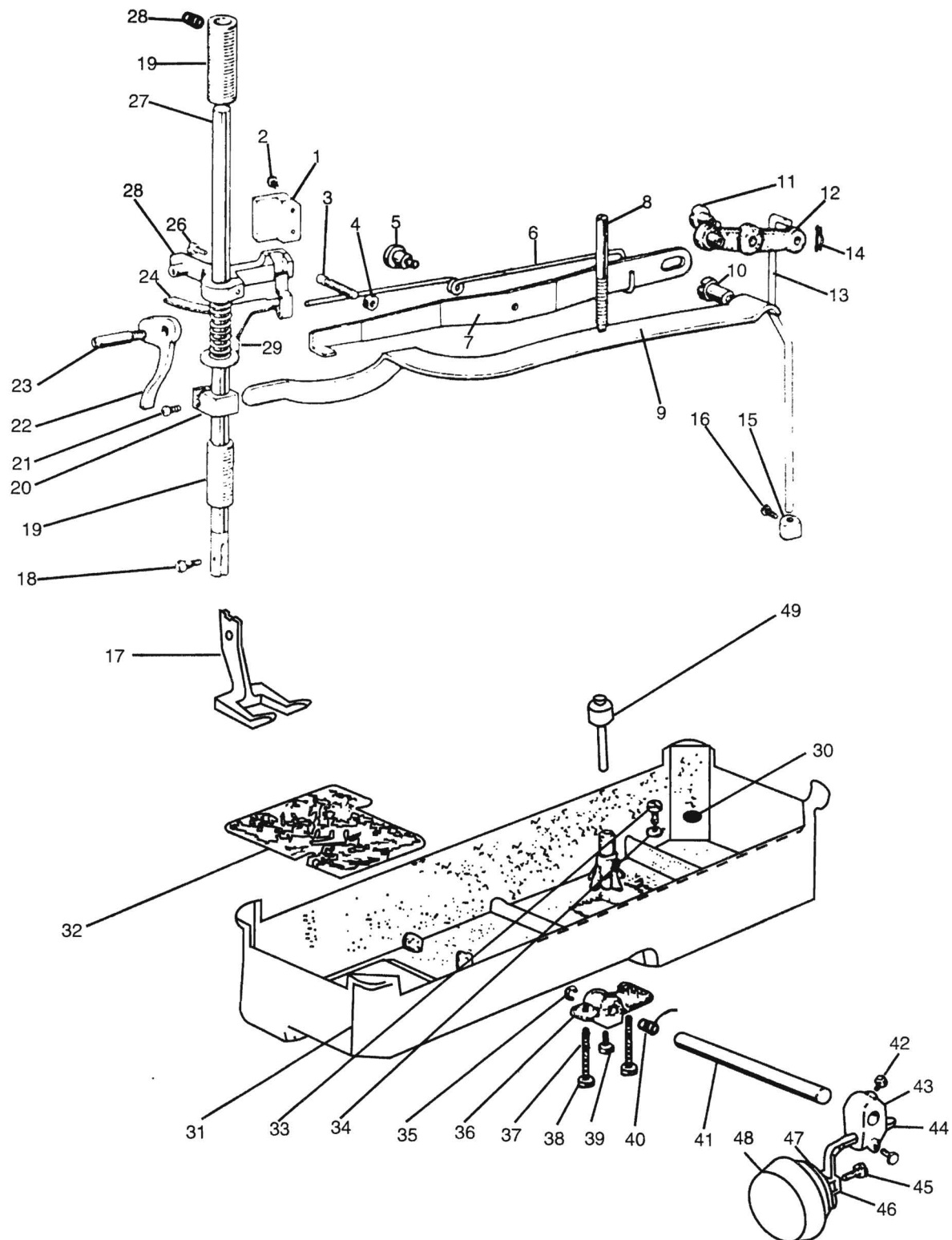
7. P1255RB Rock Shaft And Thread Looping Parts

Line	Part Number	Description	Qt.	Notes
46	200-1226	Rear bushing	1	
47	400-1105	Screw	1	SM1/4"x40/4
48	200-1202	Screw	1	SM1/4"x40/5
49	200-1227	Ball bearing	1	17x40x12
50	200-1229	Bearing press ring	1	
51	200-1230	Screw	3	SM9/64"x40/7
52	200-1231	Oil wick	1	φ3x18
53	200-1233	Feed link pin	1	
54	200-1232	Oil wick	1	
55	200-1234	Ring	1	
56	200-1235	Washer	1	
57	200-1236	Washer	1	GB 955 5



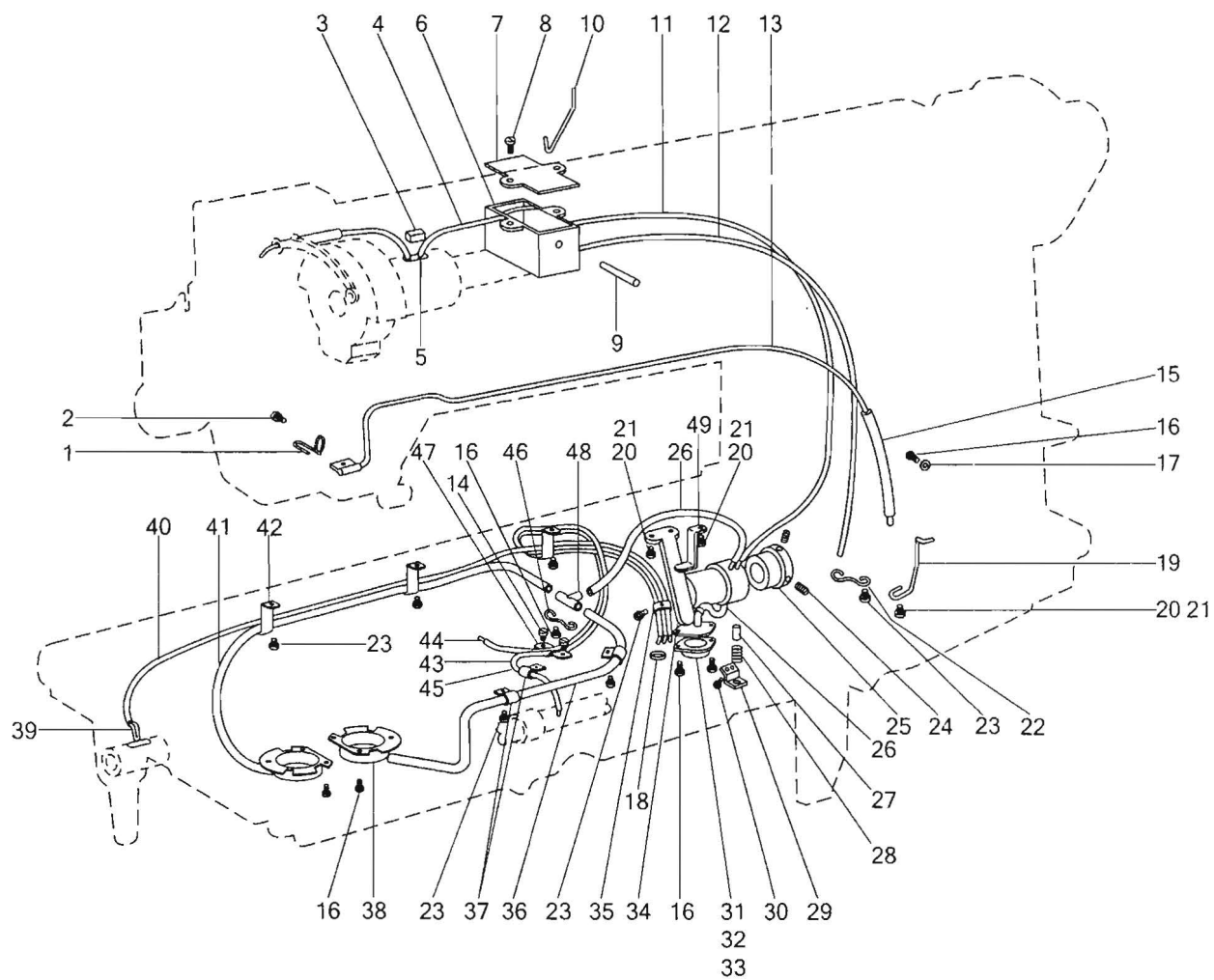
8. Stitch Length Adjusting Parts

Line	Part Number	Description	Qt.	Notes
1	200-1237	Stitch length adjusting swing lever	1	SM15/64"x28/8.5 SM15/64"x28/12
2	200-1117	Screw	5	
3	200-1239	Screw	1	
4	200-1240	Stitch length link	1	
5	200-1241	Eccentric shaft	1	
6	200-1242	Reverse sewing shaft	1	SM15/64"x28/13 SM15/64"x40/10.5
7	200-1243	Reverse sewing crank	1	
8	200-1244	Screw	1	
9	200-1245	Screw	1	
10	200-1246	Reverse sewing lever	1	
11	200-1247	Sliding block	2	SM11/64"x40/8
12	200-1248	Spring washer	1	
13	200-1249	Spring holder	1	
14	200-1250	Screw	1	
15	100-1157	Stop pin	1	
16	100-1158	Spring	2	
17	200-1253	Stitch length adjusting bolt	1	
18	100-1152	O-gasket	1	
19	100-1159	Pin	1	
20	100-1175	Spring	1	
21	200-1257	Stitch length adjusting crank shaft	1	SM15/64"x28/10 SM15/64"x28/6
22	200-1258	Stitch length adjusting crank	1	
23	200-1138	Screw	1	
24	200-1259	Screw	3	
25	200-1260	Collar	1	
26	200-1261	Reverse sewing adjusting stand	1	φ326 φ4x16 SM11/64"x40/9
27	200-1262	Oil wick	1	
28	200-1263	Oil wick	1	
29	200-1264	Sliding block guide	2	
30	200-1019	Screw	4	
31	200-1377	Washer	1	
32	100-1174	Stitch length button	1	
33	100-1153	Stitch length dial	1	
34	200-1265	Stitch length dial	1	
35	100-1155	bushing	1	
36	100-1156	Screw	1	



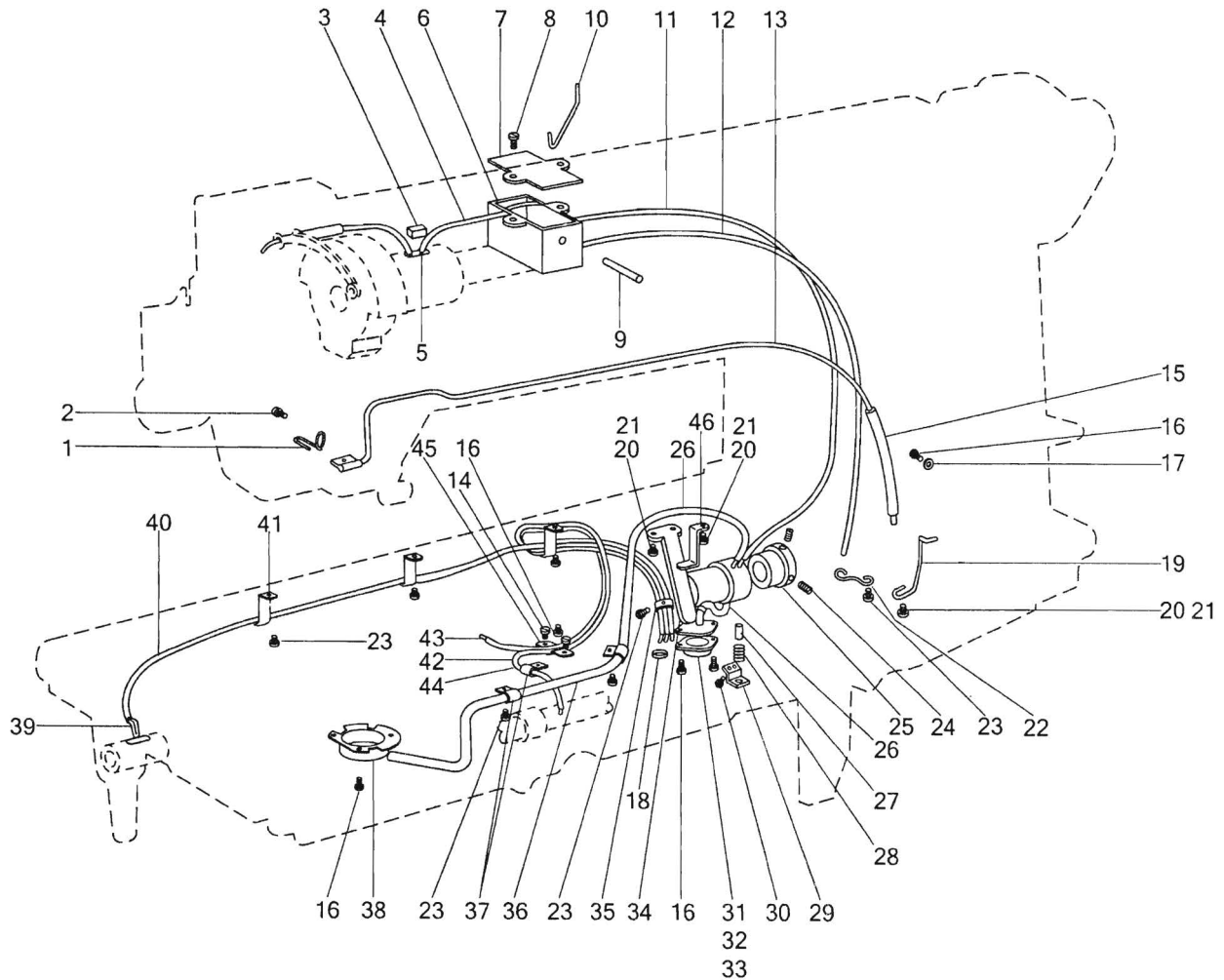
9. Presser Foot Lift Parts

Line	Part Number	Description	Qt.	Notes
1	200-1300	Sliding block rail	1	SM1/64"x40/12 SM1/4"x24/16.5
2	200-1301	Screw	2	
3	200-1303	Screw	1	
4	200-1304	Nut	1	
5	200-1305	Screw	1	
6	200-1306	Spring	1	
7	200-1271	Knee lifter lever	1	
8	200-1455	Adjusting screw	1	
9	200-1456	Pressure bar spring lever	1	
10	200-1468	Screw	1	
11	200-1276	Screw	1	
12	200-1278	Knee lifter crank complete	1	
13	200-1280	Knee lifter prop rod	1	
14	200-1282	Split pin	1	
15	200-1284	Stop Collar	1	
16	100-1034	Screw	1	P1255RB
17	200-1287	Presser foot	1	
18	200-1459	Set screw	1	
19	200-1460	Bushing	2	
20	200-1461	Spring lever holder	1	
21	200-1399	Screw	1	SM9/64"x40/8.5
22	200-1462	Presser foot lift lever	1	
23	200-1463	Screw	1	
24	200-1464	Thread releasing lever	1	
25	200-1465	Presser bar guide	1	
26	200-1405	Screw	1	SM11/64"x40/15 SM1/4"x24x23
27	200-1466	Presser bar	1	
28	200-1103	Screw	2	
29	200-1467	Spring	1	
30	100-1308	Magnet	1	
31	200-1302	Oil pan	1	SM5/16"x25/10 GB896 9
32	200-1328	Oil gasket	1	
33	200-1371	Screw	1	
34	100-1305	Washer	1	
35	100-1334	Retain ring	1	
36	200-1307	Knee lifter stop bracket	1	SM15/64"x28/28 SM15/64"x28/15
37	100-1324	Adjust screw	2	
38	100-1325	Adjust nut	2	
39	200-1308	Screw	1	
40	100-1322	Spring	1	
41	200-1309	Hinge pin	1	SM5/16"x18/13 SM15/64"x28/8
42	200-1308	screw	2	
43	100-1327	Connector	1	
44	100-1329	Bent rod	1	
45	100-1332	Screw	1	
46	100-1331	Knee lifter bell bracket	1	
47	100-1330	Bell	1	
48	100-1333	Pat	1	
49	200-1310	Knee lifter prop rod	1	



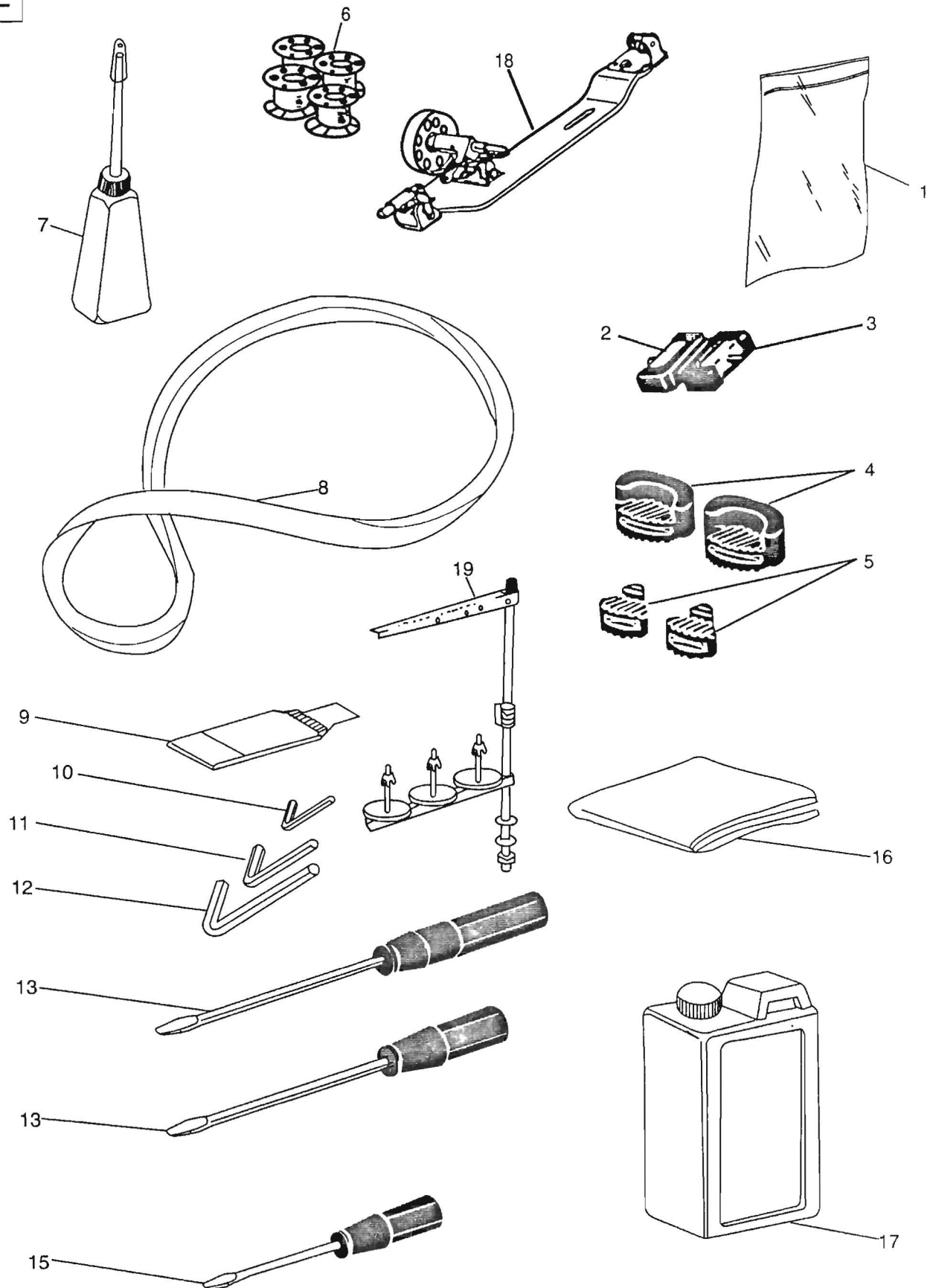
10. P2339RB Lubrication Parts

Line	Part Number	Description	Qt.	Notes
1	200-1311	Presser spring	1	SM11/64"x40x8 3Dx0.5x60
2	200-1250	Screw	1	
3	200-1313	Oil felt	1	
4	200-1314	oil pipe	1	
5	200-1315	Oil wick	1	
6	200-1316	Oil cup	1	GB/T69 M4x16
7	200-1317	Oil cup cover	1	
8	200-1318	Screw	2	
9	200-1320	Pin	1	
10	200-1321	Presser spring	1	
11	200-1322	Oil pipe	1	3Dx1x400
12	200-1323	Oil drain pipe	1	5Dx1x400
13	200-1324	Oil wick	1	φ2.5x550
14	200-1025	Screw	1	3Dx0.5x150
15	200-1326	Needle bar oil return pipe	1	
16	200-1084	Screw	8	
17	200-1377	Washer	1	
18	200-1436	Oil wick clamp	1	
19	200-1329	Spring	1	SM11/64"x40/9
20	200-1019	Screw	4	
21	200-1377	Washer	1	
22	200-1330	Oil pipe end clamp	1	
23	200-1077	Screw	10	
24	200-1331	Screw	2	SM9/64"x40/4.5
25	200-1332	Bushing	1	SM11/64"x40/10
26	200-1333	Oil pipe	2	3Dx1x90
27	200-1334	Plug	1	
28	200-1335	Spring	1	
29	200-1336	Bracket for spring	1	
30	200-1337	Screw	1	
31	200-1338	Oil filter	1	SM1/8"x44/4.5
32	200-1339	Washer	1	
33	200-1340	Oil filter screen	1	
34	200-1341	Oil filter bracket	1	
35	200-1342	Oil pipe clamp	1	
36	200-1343	Oil pipe	1	φ2.5x430 3DX0.5x410
37	200-1344	Oil pipe clamp	4	
38	200-1345	Oil tray complete	2	
39	200-1346	Oil wick	1	
40	200-1347	Oil pipe	1	
41	200-1348	Oil pipe	1	#1 3Dx1x445
42	200-1312	Pipe clamp	3	
43	200-1349	Oil pipe	2	
44	200-1350	Oil wick	1	
45	200-1351	Oil wick	1	
46	200-1352	3-nozzle oil mouth bracket	1	
47	200-1353	Oil pipe clamp	1	
48	200-1354	3-nozzle oil mouth bracket	1	
49	200-1355	Oil filter bracket	1	



11. P1255RB Lubrication Parts

Line	Part Number	Description	Qt.	Notes
1	200-1311	Presser spring	1	SM11/64"x40x8 3Dx0.5x60
2	200-1250	Screw	1	
3	200-1313	Oil felt	1	
4	200-1314	oil pipe	1	
5	200-1315	Oil wick	1	
6	200-1316	Oil cup	1	GB/T69 M4x16
7	200-1317	Oil cup cover	1	
8	200-1318	Screw	2	
9	200-1320	Pin	1	
10	200-1321	Presser spring	1	
11	200-1322	Oil pipe	1	3Dx1x400
12	200-1323	Oil drain pipe	1	5Dx1x400
13	200-1324	Oil wick	1	φ2.5x550
14	200-1025	Screw	1	3Dx0.5x150
15	200-1326	Needle bar oil return pipe	1	
16	200-1084	Screw	8	
17	200-1377	Washer	1	
18	200-1436	Oil wick clamp	1	
19	200-1329	Spring	1	SM11/64"x40/9
20	200-1019	Screw	4	
21	200-1377	Washer	1	
22	200-1330	Oil pipe end clamp	1	
23	200-1077	Screw	8	
24	200-1331	Screw	2	SM9/64"x40/4.5
25	200-1332	Bushing	1	SM11/64"x40/10
26	200-1333	Oil pipe	2	3Dx1x90
27	200-1334	Plug	1	
28	200-1335	Spring	1	
29	200-1336	Bracket for spring	1	
30	200-1337	Screw	1	
31	200-1338	Oil filter	1	SM1/8"x44/4.5
32	200-1339	Washer	1	
33	200-1340	Oil filter screen	1	
34	200-1341	Oil filter bracket	1	
35	200-1342	Oil pipe clamp	1	
36	200-1343	Oil pipe	1	φ2.5x430 3DX0.5x410
37	200-1344	Oil pipe clamp	4	
38	200-1345	Oil tray complete	2	
39	200-1346	Oil wick	1	
40	200-1347	Oil pipe	1	
41	200-1312	Pipe clamp	3	3Dx0.5x220 φ2.5x300 φ2.5x240
42	200-1349	Oil pipe	2	
43	200-1350	Oil wick	1	
44	200-1351	Oil wick	1	
45	200-1353	Oil pipe clamp	1	
46	200-1355	Oil filter bracket	1	



12. Accessories

Line	Part Number	Description	Qt.	Notes
1	100-1299	Parts bag	1	
2	100-1310	Hinge pin	2	
3	100-1311	Hinge pin socket	2	
4	100-1312	Cushion	2	
5	100-1313	Cushion	2	
6	200-1183	Bobbin	4	
7	100-1309	Oil pot	1	
8	200-1359	V-belt	1	42V
9	200-1360	Needle	1	135X17#23
10	100-1318	Hex key	1	2 GB/T5356-1998
11	200-1363	Hex key	1	2.5 GB/T5356-1998
12	200-1364	Hex key	1	3 GB/T5356-1998
13	100-1302	Screwdriver	1	
14	100-1301	Screwdriver	1	
15	100-1300	Screwdriver	1	
16	200-1366	Cover	1	70x35
17	100-1314	Oil tank	1	
18	200-1369	Bobbin winder	1	
19	200-1370	Thread stand	1	

