

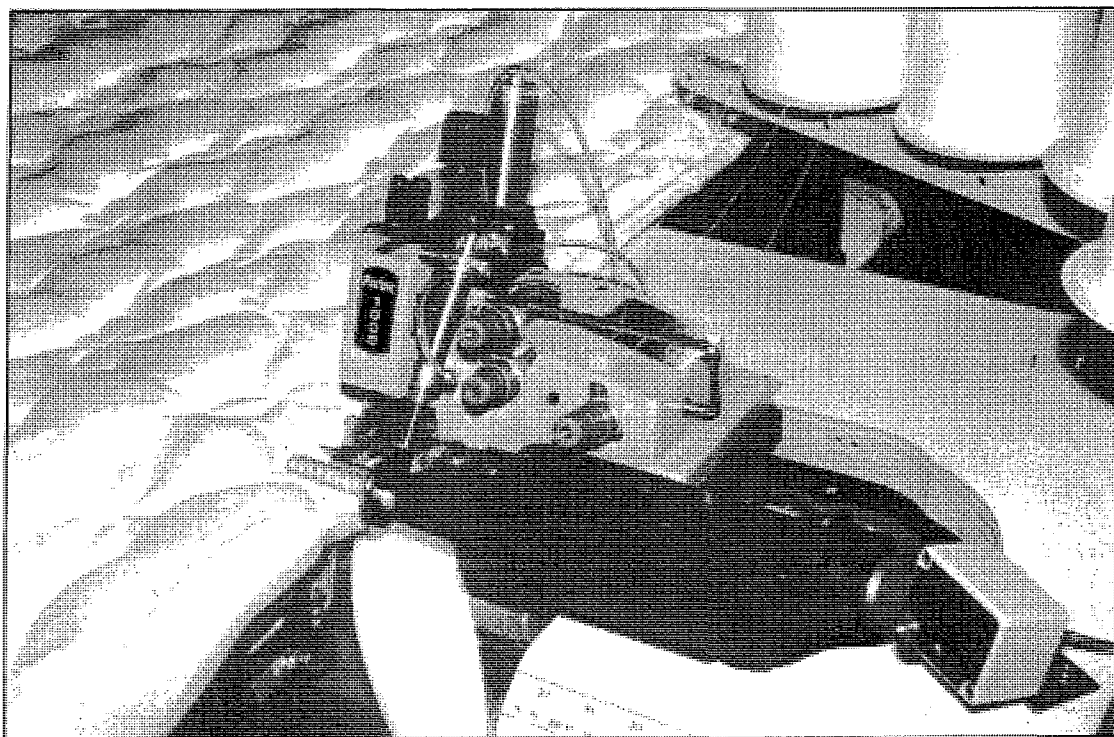


A Leggett & Platt Company

Catalog #PFM-1000(rev) 6/99



PFM 1000 Flange Machine



INSTRUCTIONS & PARTS MANUAL

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INSTRUCTIONS

RECOMMENDED SPEED

1. PFM 1000 SPEED NOT TO EXCEED 3500 SPM.
2. At the end of 4 weeks, the original oil should be drained and replaced.
3. Oil level should always be kept between two lines on the oil sight gauge. (See Lubrication below.).

NEEDLES

The PFM 1000 is designed to use needle type PSM 1160 (23).

Generally, the size of the needle should be determined by the size of thread or weight of material to be sewn.

CHAINING THREAD

It is necessary to have a chaining thread approximately 10 mm long behind the presser foot when starting to sew. This will avoid "skip-stitches." After replacing needles or thread, check that a continuous, smooth neat chaining thread comes out from under the presser foot.

CLEANING THE MACHINE

Cleaning the machine is a simple but important operation. It is not necessary to remove any parts. Swing out the covers and remove all the collected lint from around the loopers, feed slots, and under the needle plate. Blow out any loose lint or use a lint brush. Replace covers and return foot to the sewing position.

DAILY MAINTENANCE

Before morning start

- Make sure oil level is correctly maintained in oil sight gauge.
- Make sure needle is correctly set and not damaged.
- Make sure threading is correct.
- Make sure chaining thread approximately 10 mm long remains behind presser foot.

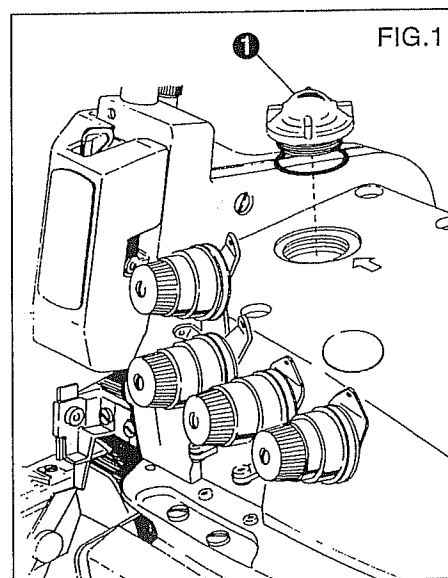
At close of work

- Remove dust and lint deposited in the machine around needle plate and looper.
- If any trouble or irregularity is found, report it to the plant mechanic for adjustment or repair.
- Keep record of needle and thread breakage.

LUBRICATION

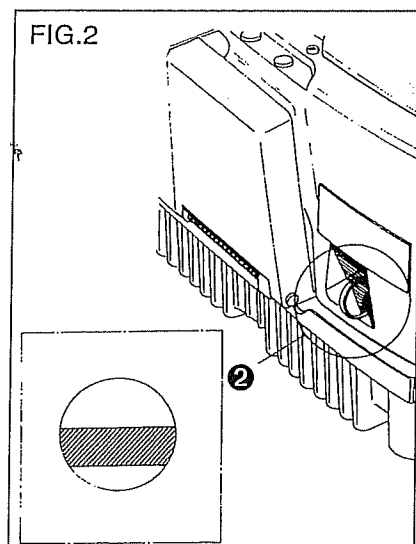
Lubrication is important in operating precision machine like the PFM1000. The life of the machine depends on the use of quality oil. Use recommended type oil only. Oil specifications for this machine are shown at right.

		Brand "A"	Brand "B"
Kinematic Viscosity (centistokes)	100°F	19.01	14.57
	210°F	4.04	3.57
Viscosity Index	VI (A)	130.0	147.5
	VI (B)	123.5	142.5
Pour Point (°F)		-59.0	-63.5
Load Carrying Capacity (kg/cm ²)		more than 12 (170 psi.)	more than 12 (170 psi.)



TO FILL OIL:

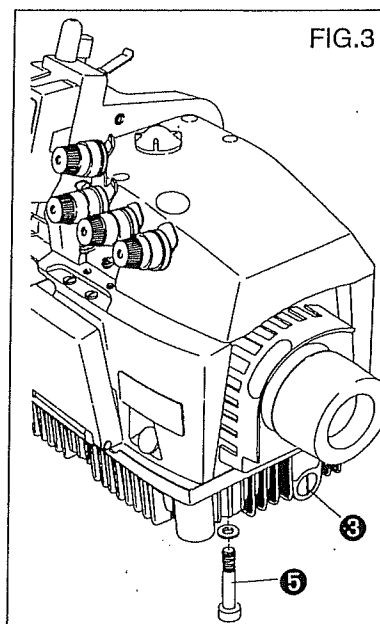
- 1.Remove oil sight window ❶ and pour fresh oil into reservoir (700 c.c. capacity) until oil reaches upper line of oil sight gauge ❷.
 - 2.Replace window ❶.
- Caution: Keep oil level between the two lines on gauge ❷



TO DRAIN OIL:

- 1.Remove the machine from its stand and set it on a table.
- 2.Screw out drain plug ❸ and drain oil.
- 3.Replace drain plug ❸.

Change oil entirely every 6 months.

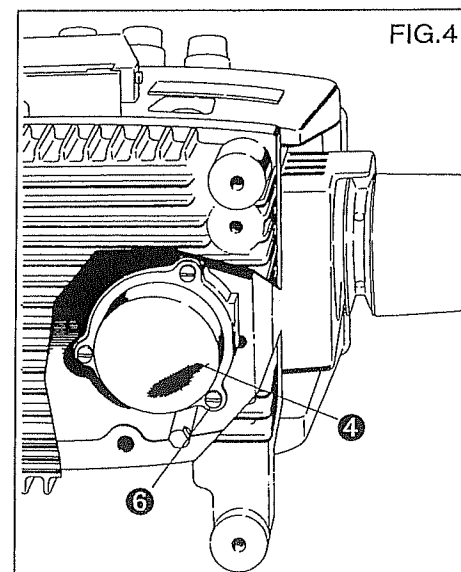


OIL FILTER

Filter ❹ should be kept clean. Lubrication oil is filtered and delivered to all frictional surfaces. Clogging of this filter may cause lack of lubrication and accidental seizure of parts. Check and clean filter every three months, or if necessary, replace with new filter when: Oil jet in oil sight window ❶ is restricted or weak, or oil contains foam or debris.

- 1.Drain oil from machine.

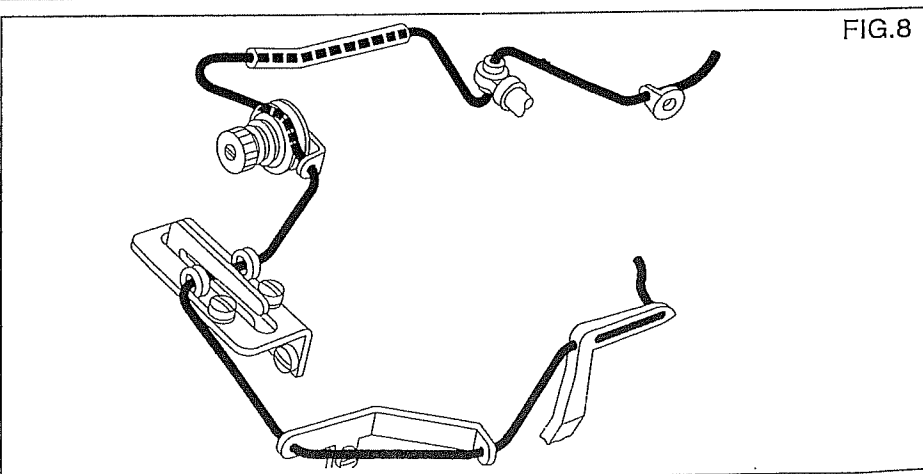
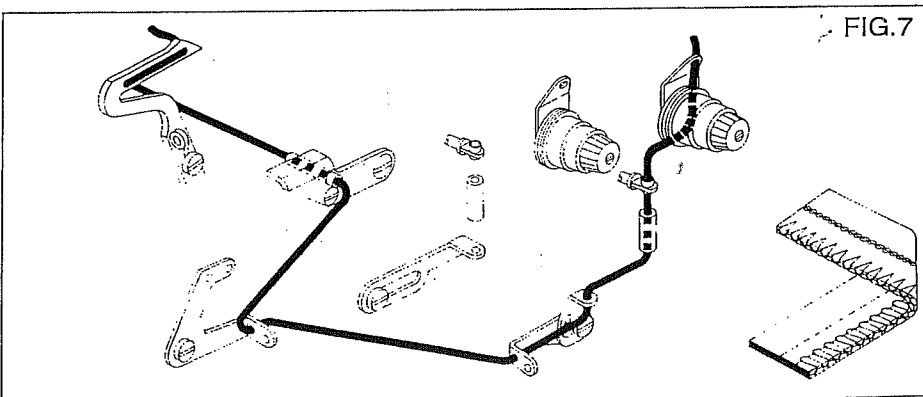
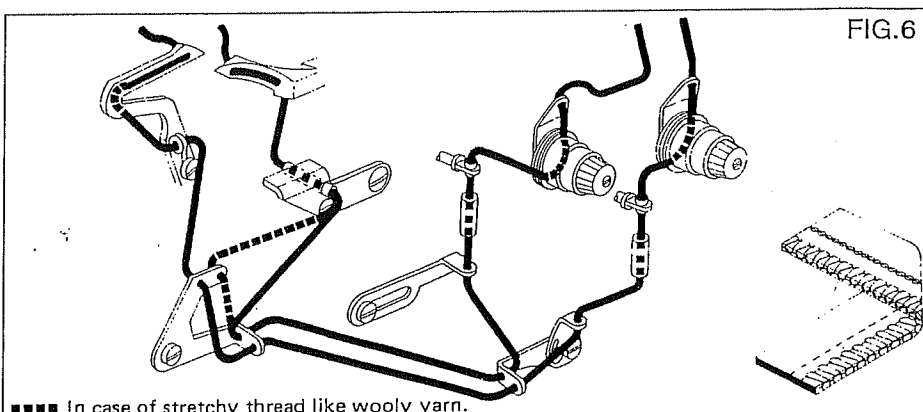
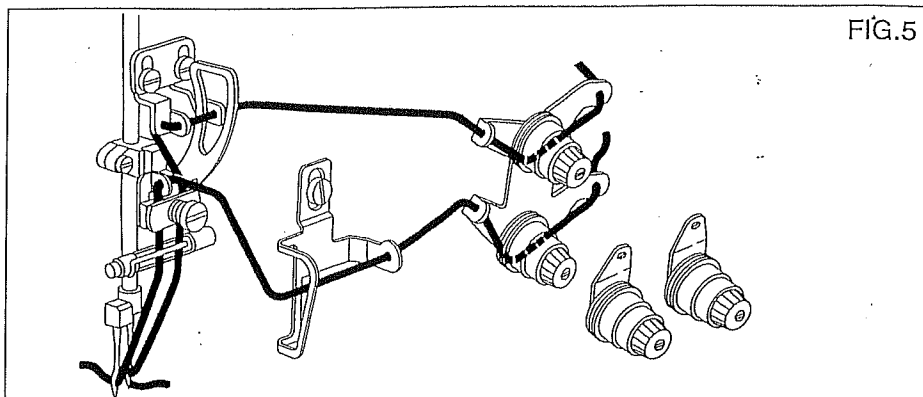
- 2.Remove bolts ❺ and oil pan from machine.
- 3.Remove screws ❻ and take out filter ❹.
- 4.Clean filter ❹ with new petrol and blow it with low pressure air.
- 5.Replace filter ❹ and tighten screws ❻.
- 6.Replace oil pan and tighten bolts ❺.
- 7.Fill reservoir with oil on a level of upper line of oil sight gauge ❷.



THREADING

When a machine is received, note that it has been threaded correctly. The simplest way to rethread it is to tie the new threads to those already in the machine and pull the new threads through, making sure that the knots will go through the looper eyes. In case the machine requires a complete rethreading, refer to Threading Diagrams **Fig. 5-8**.

The amount of thread tension required varies with type of material, size, and type of thread, etc. To increase thread tension, turn each thread tension nut clockwise, and to decrease, counter clockwise.

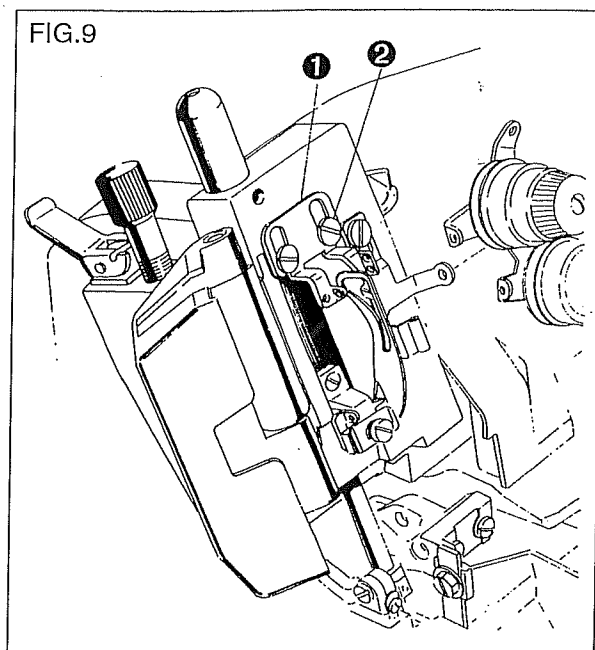




NEEDLE THREAD GUIDE REGULATION

Needle thread guide ❶ should be set down for the PFM 1000.

1. Loosen screws ❷.
2. Move guide ❶ down.
3. Tighten screws ❷.



STITCH LENGTH REGULATION

1. Swing out cloth plate to the left.
2. Press in rod ❶.
3. While pressing in on rod ❶, turn handwheel in the sewing direction until rod ❶ drops into the hole in eccentric. Read the number shown on hand-wheel, opposite to the mark on indication plate. This number indicates the length of one stitch of your machine in millimeters.
4. While keeping rod ❶ dropped in eccentric, turn handwheel toward the desired stitch length for a longer or a shorter stitch.

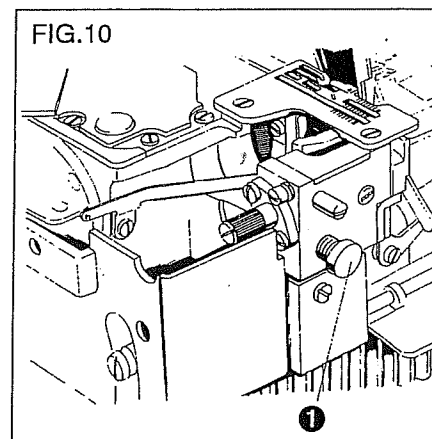
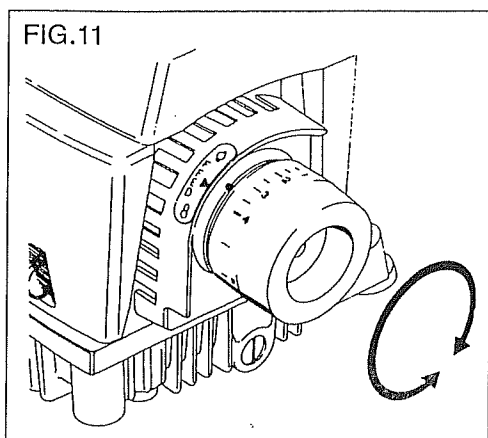


FIG. 11



Longer stitch - Turn handwheel clockwise.

Shorter stitch - Turn handwheel counter clockwise.

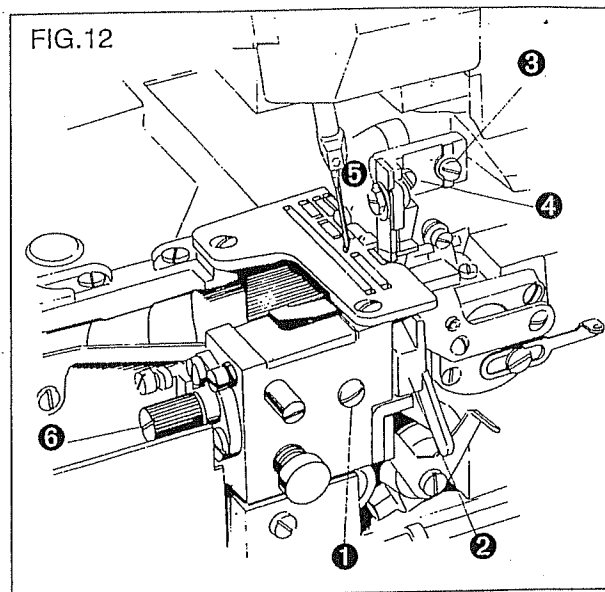
5. When desired stitch length is set, release rod ❶.

6. Return cloth plate to the sewing position.

The stitch length made may vary more or less depending on the material.

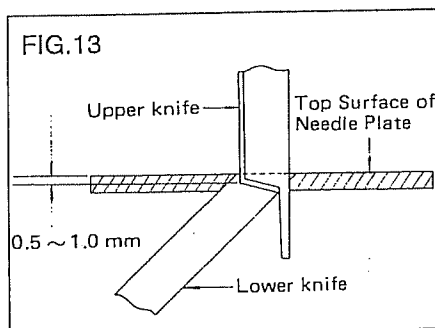
SEAM WIDTH REGULATION

1. Turn handwheel unit until upper knife is at its lowest position.
2. Loosen lower knife holder screw ①.
3. Push lower knife holder ② to the left as far as it will go and lightly tighten screw ①.
4. Loosen upper knife clamp screws ③ and move upper knife clamp ④ to the right or left until desired width is obtained.
5. Tighten screws ③.
6. Loosen screw ①, then the holder ② will return to position by spring action.
7. Tighten screw ①.



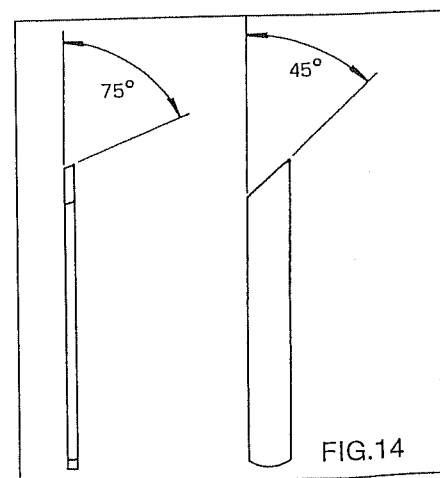
UPPER KNIFE REPLACEMENT

1. Loosen lower knife holder screw ① as shown in Fig. 12.
2. Push the lower knife holder ② to the left as far as it will go and lightly tighten screw ①.
3. Remove upper Knife screw ⑤ and withdraw knife downward.
4. Turn handwheel until upper knife clamp ④ is at its lowest position.
5. Replace with new knife but do not tighten screw ⑤ completely.
6. Set the blade so that its cutting edge overlaps lower knife by 0.5-1.0mm as shown in Fig. 13. Retighten screw ⑤ securely.
7. Loosen screw ①, then the holder ② will return to position by spring action.
8. Tighten screw ①.



LOWER KNIFE REPLACEMENT

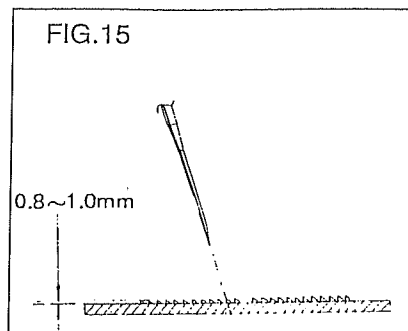
1. Loosen lower knife holder screw ①.
2. Push lower knife holder ② to the left as far as it will go and lightly tighten screw ① as shown in Fig. 12:
3. Loosen clamp stud nut ⑥ and withdraw knife downward.
4. Insert new knife into the groove of lower knife clamp stud, setting the blade so that the cutting edge is level with the top of the needle plate as shown in Fig. 11. Tighten nut.
5. Loosen screw ①, then the holder ② will return to position by spring action.
6. Tighten screw.



SHARPENING KNIVES

Knives must be kept sharp. Lower knife may be sharpened on a grinder while making sure that the correct angle is maintained as shown in Fig. 14.

FIG.15

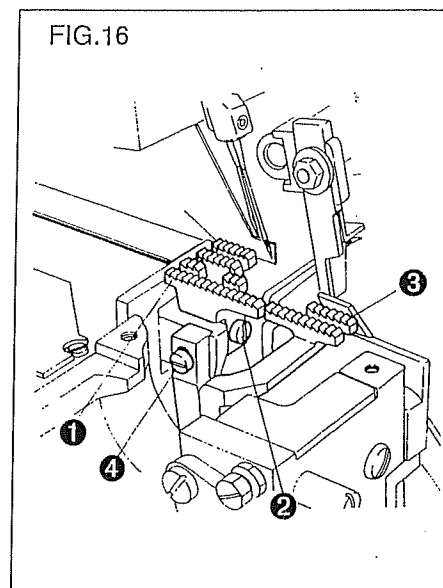


FEED HEIGHT ADJUSTMENT

Standard height of main feed is 0.8 - 1.0 mm above the surface of needle plate at its back tooth when feeds are at their highest position. A straight edge can be placed across the top of main and differential feeds.

1. Loosen screws ② and ④.
2. Adjust feeds ① and ③ by raising or lowering feeds until proper height is obtained.
3. Tighten screws ② and ④.

FIG.16

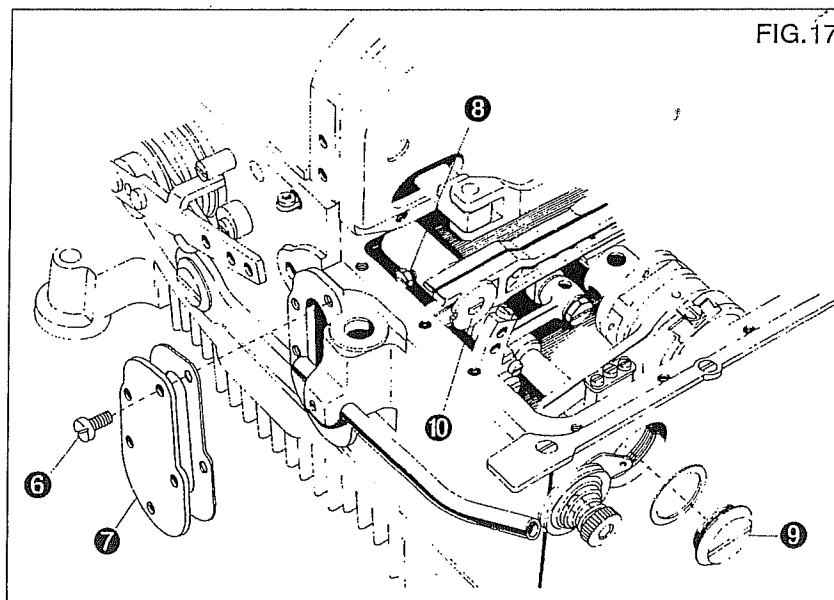


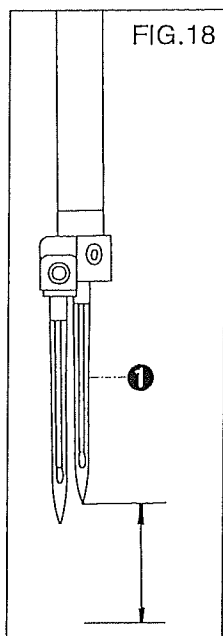
FEED TILT ADJUSTMENT

Feed dogs have generally been preset at the factory with a front to back tilt when feeds are at their highest position. In general, set feeds as follows:
Set feeds level.

1. Turn handwheel until feeds are at their highest position.
2. Remove screws ⑥ and cover plate ⑦.
3. Loosen screw ⑧.
4. Remove screw ⑨ and turn screw ⑩ with a screwdriver until proper tilt is obtained.
5. Tighten screw ⑧ while pressing screw ⑩ so that a play in feed bars can be eliminated.
6. Replace cover plate ⑦ and screws ⑥.
7. Replace screw ⑨.

FIG.17



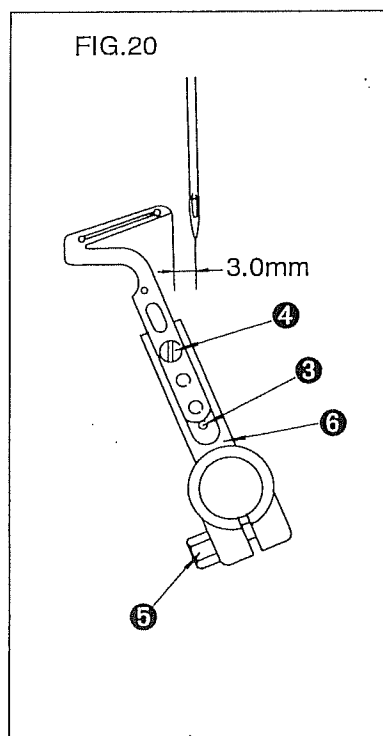
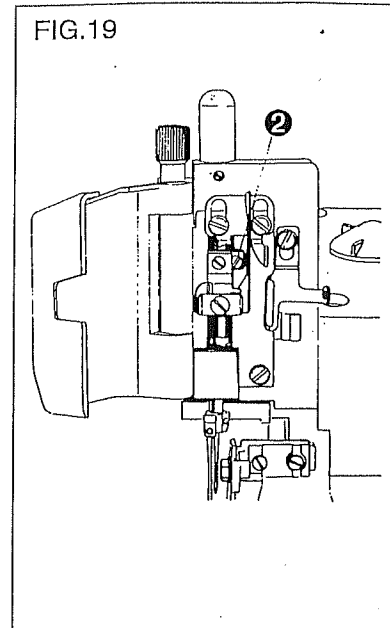


NEEDLE BAR HEIGHT ADJUSTMENT

Turn handwheel until needles are at their highest position. Check that the clearance between the point of right (overlock) needle ① and the top of needle plate is correct as listed below. If this setting is incorrect, reset as follows.

1. Slightly loosen screw ②.
2. Reset needle bar to correct clearance at its highest position.
3. Turn handwheel and observe that left (chainstitch) needle descends in the center of the needle hole in needle plate.
4. Tighten screw ② securely.

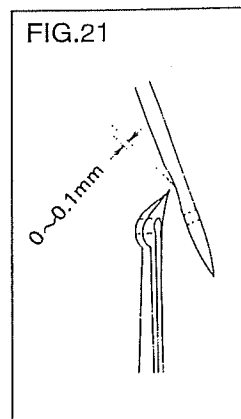
PFM 1000	NEEDLE BAR HEIGHT	
	Left 11mm	Right 13mm



OVEREDGE (LEFT) LOOPER ADJUSTMENT

When overedge (left) looper is at its extreme left position, the distance 3.0 mm center line of the overlock needle to the point of the looper. The clearance 0 - 0.1 mm should also be obtained when the looper point is in the scarf of the needle.

1. Slide left looper into lever ⑥, making sure it reaches the pin ③ of slot, then tighten screw ④.
2. Slightly loosen screw ⑤.
3. Turn handwheel by hand until needle bar ascends 3mm from the lowest position.
4. Move lever ⑥ so that looper point comes to the scarf of right needle and just touches needle (the clearance 0 - 0.1 mm).
5. Turn handwheel until looper is at its extreme left position.
6. Adjust the distance from the centerline of right needle to point of looper to 3mm.
7. Tighten screw ⑤ securely.



RIGHT LOOPER ADJUSTMENT

When right looper is at its highest position, the clearance 3.3 mm should be obtained from looper eye (bottom of V groove in case of spreader) to the centerline of the overlock needle. When right looper crosses left looper, the clearance (A) should be 0.5 mm and (B) should be 0.2 mm.

1. Insert right looper into lever and preset the clearance from the back edge of looper to the left side of looper lever to 5.3 mm. Lightly tighten screw ❶.
2. Slightly loosen screw ❷.
3. Turn handwheel until looper is at its highest position.
4. Adjust looper eye or spreader (bottom of V groove) from centerline of right needle to 3.3 mm by moving lever ❸ downward or upward.
5. Turn handwheel slowly and observe that the clearance (A) is 0.5 mm.
6. When clearance (A) is more than 0.5 mm, move lever ❸ upward. move right looper to the right until the clearance is obtained of 3.3 mm as shown in Fig. 23 or 24. Turn handwheel slowly and check that the clearance (A) is 0.5 mm.
7. When clearance (A) is less than 0.5 mm, move lever ❸ downward. Move right looper to the left until the clearance is obtained of 3.3 mm as shown in Fig. 23 or 24. Turn handwheel slowly and check that the clearance (A) is 0.5 mm.
8. Rotate looper in its holder and adjust the clearance (B) to 0.2 mm as shown in Fig. 25.
9. When the above settings are complete, tighten screws ❶ and ❷ securely.

FIG.22

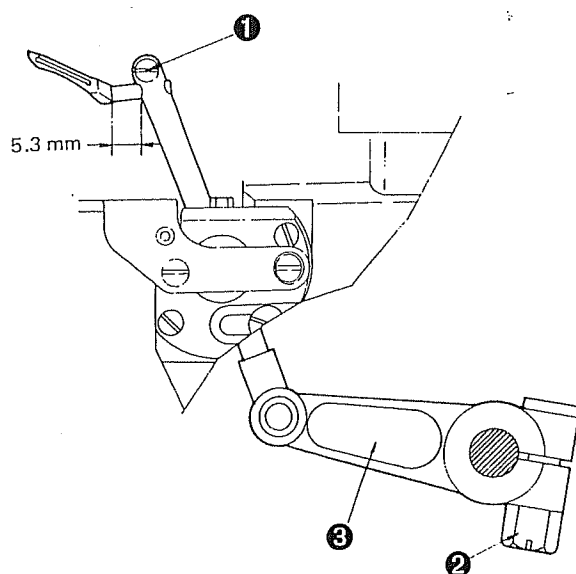


FIG.23

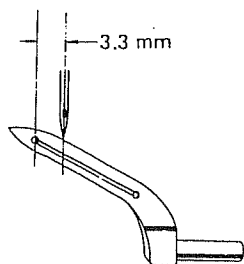


FIG.24

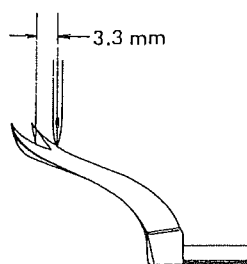


FIG.25

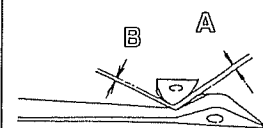
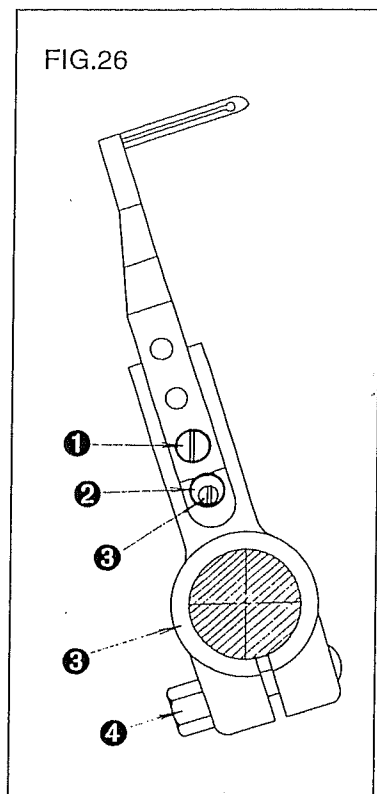


FIG.26



CHAINSTITCH LOOPER ADJUSTMENT

When chainstitch looper is at its extreme left position, the distance 2.1 mm should be obtained from the center line of the chainstitch (left) needle to the point of looper. The clearance 0 - 0.1 mm should also be obtained when the looper point is in the scarf of the needle.

1. Slide chainstitch looper into lever ⑤, making sure it reaches regulator ②.
2. If necessary, adjust this by turning regulator ②.
3. Turn handwheel by hand until needle bar ascends 3.0 mm from the lowest position.
5. Move lever ⑤ so that looper point comes to the scarf of left needle and just touches needle (the clearance 0 - 0.1 mm).
6. Turn handwheel until looper is at its extreme left position.
7. Adjust the distance from the centerline of left needle to point of looper to 1.5 to 2 mm.
8. Tighten screw ④ securely.

FIG.27

0~0.1mm

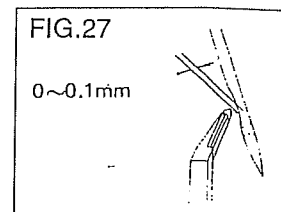
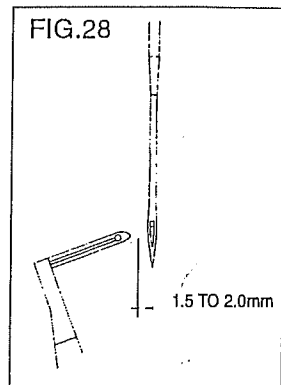


FIG.28



CHAINSTITCH LOOPER THREAD CONTROL ADJUSTMENT

1. Lightly loosen screw ⑤.
2. Set bracket ⑥ horizontal and set guide ⑦ as 0.5 mm above from the top of bracket ⑥.
3. Tighten screw ⑤.
4. Loosen two screws for takeup ⑧ and turn handwheel until chainstitch looper is at extreme right position.
5. Set takeup ⑧ so that its flat portion is at a 10 degrees angle to guide ⑦.
7. Tighten the two screws loosened.
7. Loosen screws holding eyelets ⑨ and move eyelets ⑨ until the coiled ends line up with engraved line (A) on bracket, then tighten screws.

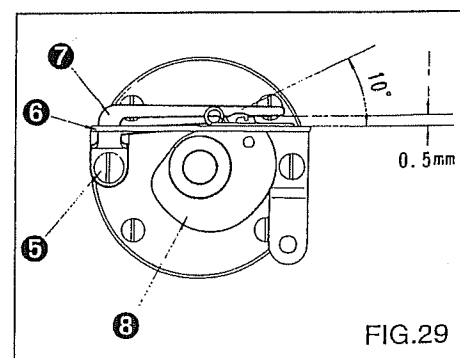
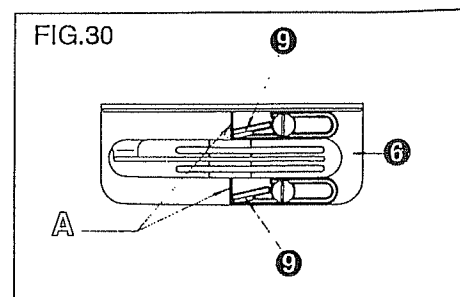


FIG.29

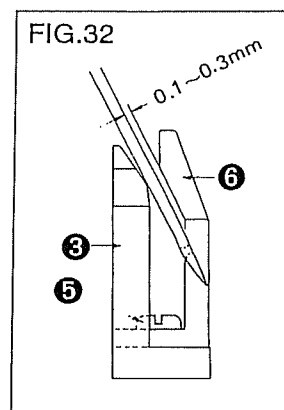
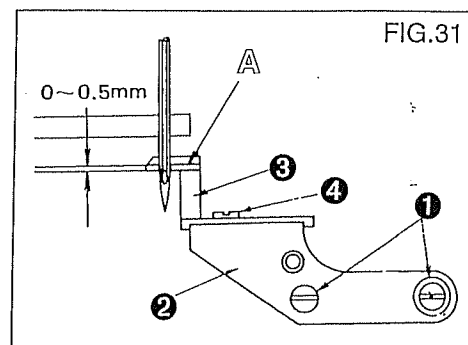
FIG.30



NEEDLE GUARDS ADJUSTMENT

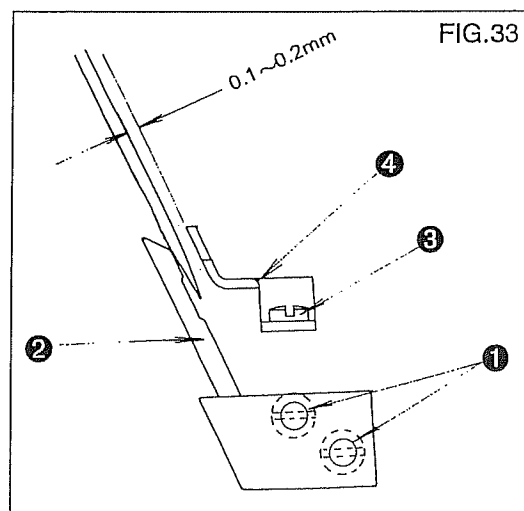
Needle guards for right (overlock) needle

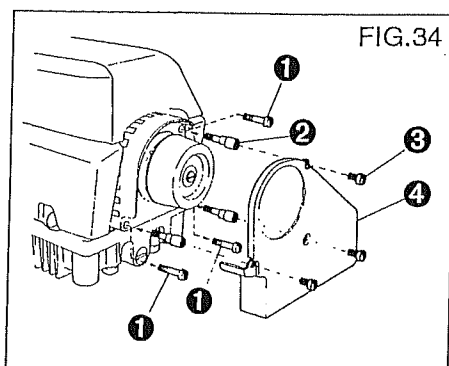
1. Turn handwheel until needles are at their lowest position.
2. Loosen screws ❶. Move bracket ❷ until the top of the right needle eye is 0 - 0.5 mm below the line (A) of guard ❸. Tighten screws ❶.
3. Turn handwheel until the point of left looper is opposite to the centerline of right needle.
4. Loosen screw ❹. Adjust guard ❸ back and forth until it just touches needle without deflecting needle point. Tighten screw ❹.
5. Loosen screws ❺. Turn handwheel until needles are at their lowest position.
6. Adjust guard ❻ so there is a space of 0.1 - 0.3 mm between needle and guard ❻ as shown in Fig. 32. Tighten screws ❺.



NEEDLE GUARDS FOR LEFT (CHAINSTITCH NEEDLE)

1. Turn handwheel until needles are at their lowest position.
2. Loosen screws ❶. Adjust guard ❷ back and forth until it just touches needle. Tighten screws ❶.
3. Loosen screw ❸. Turn handwheel until needles are at their lowest position.
4. Adjust guard ❹ so there is a space of 0.1 - 0.2 mm between needle and guard ❹. Tighten screw ❸.





BELT GUARD ASSEMBLY

Assemble belt guard on machine in sequence as follows.

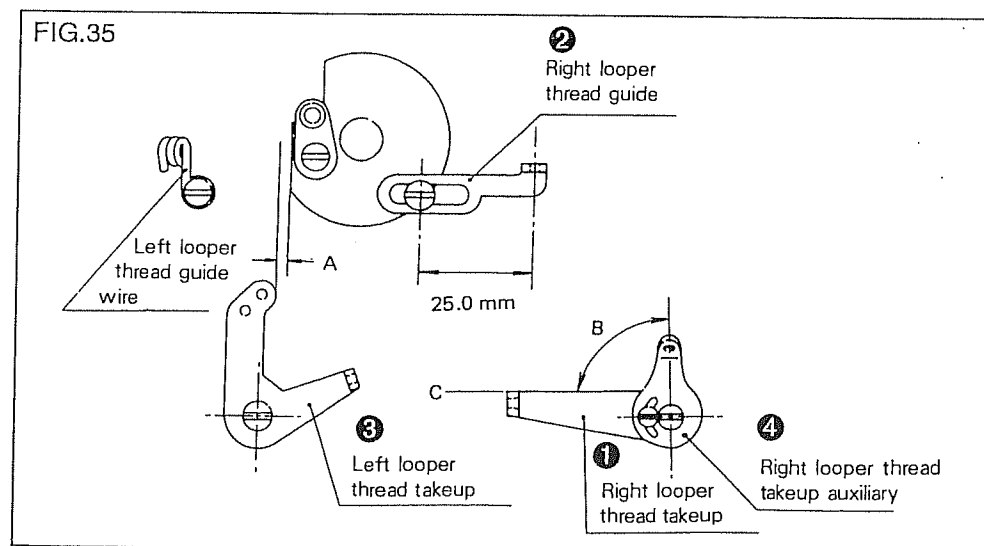
1. Put machine on table.
2. Replace screws ① for oil cooler cover with fixing screws ② provided.
3. Put V-belt in machine pulley.
4. Fix belt guard ④ on fixing screws ② with screws ③.
5. Rest machine in position in work table.
6. Engage V-belt in machine motor pulley.

THREAD GUIDE POSITIONS

Set thread guides as listed below. Note that the position of each thread guide varies more or less depending on operation, material to be sewn, etc.

1. Check dimensions when left looper is at its extreme right position.
2. Once set, takeup ① and guide ② in the basic position, do not move them.
3. To increase the amount of right looper thread, move takeup auxiliary ④ to the left, and to decrease, to the right.
4. To increase the amount of left looper thread, move takeup ③ to the left, and to decrease, to the right.

Material of looper threads	Distance 'A'	Angle 'B'	Surface 'C'
For almost all materials.	7.0 mm	80° – 90°	Set horizontally



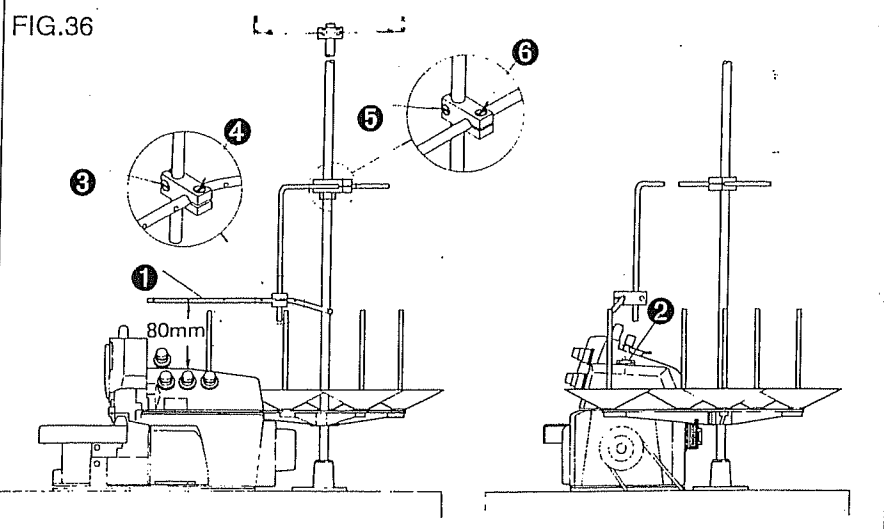
THREAD STAND SETUP

Set thread stand as per shown in Fig 36. Loosening screws ③, ④, ⑤, and ⑥, set thread guide bar ① as follows.

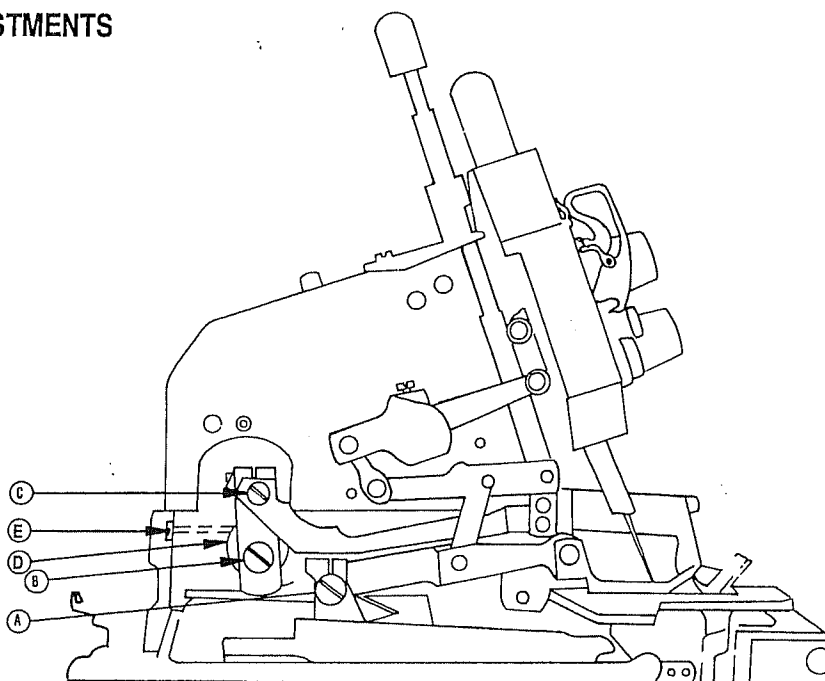
2. Obtain the distance of approximately 80 mm between bar ① and machine top cover.

3. Bar ① should be above and a little front of oil sight window ②.

4. Tighten screws ③, ④, ⑤, and ⑥.



WALKING FOOT ADJUSTMENTS



A • This eccentric pin adjusts the position of the Walking Foot front to rear. This enables you to align the Walking Foot teeth with the lower feed dog teeth.

B • This screw adjusts the Walking Foot movement in relation to the presser foot. The higher the bracket, the faster the presser foot will meet the needle plate, causing the Walking Foot to raise off the work faster. Lowering the bracket will cause the Walking Foot to raise off the work more slowly.

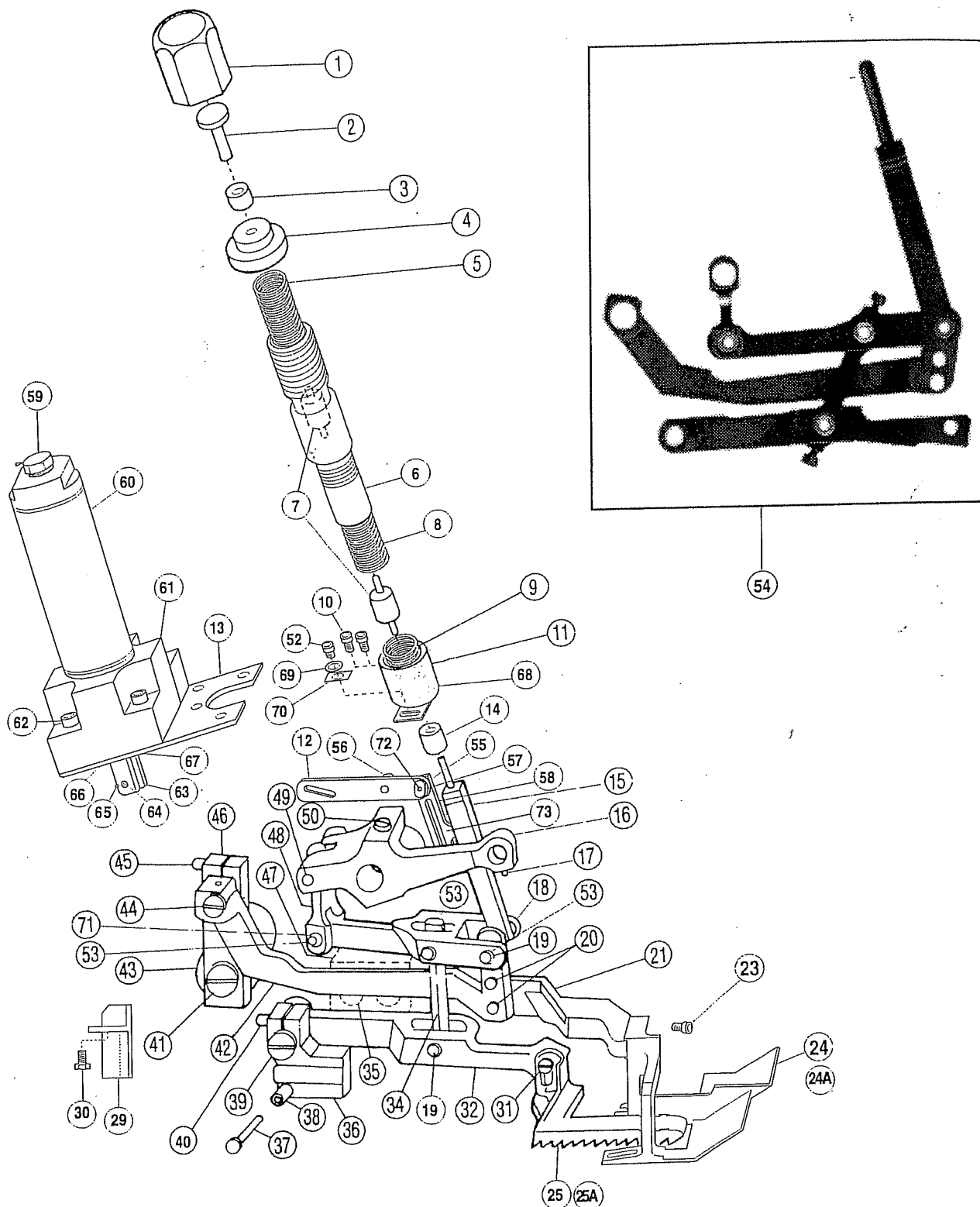
C • This eccentric pin primarily adjusts the position of the presser foot front to rear.

D • This shaft adjusts the position of the presser foot front to rear. It is used to adjust the clearance between the presser foot and the Walking Foot.

E • This screw holds shaft 'D'. Loosen it to free the shaft.

Any one of the above adjustments will slightly change one or more of the other adjustments. Take this into consideration when making any one adjustment. Before running the machine, turn it over by hand to check all clearances.

WALKING FOOT MECHANISM



WALKING FOOT MECHANISM

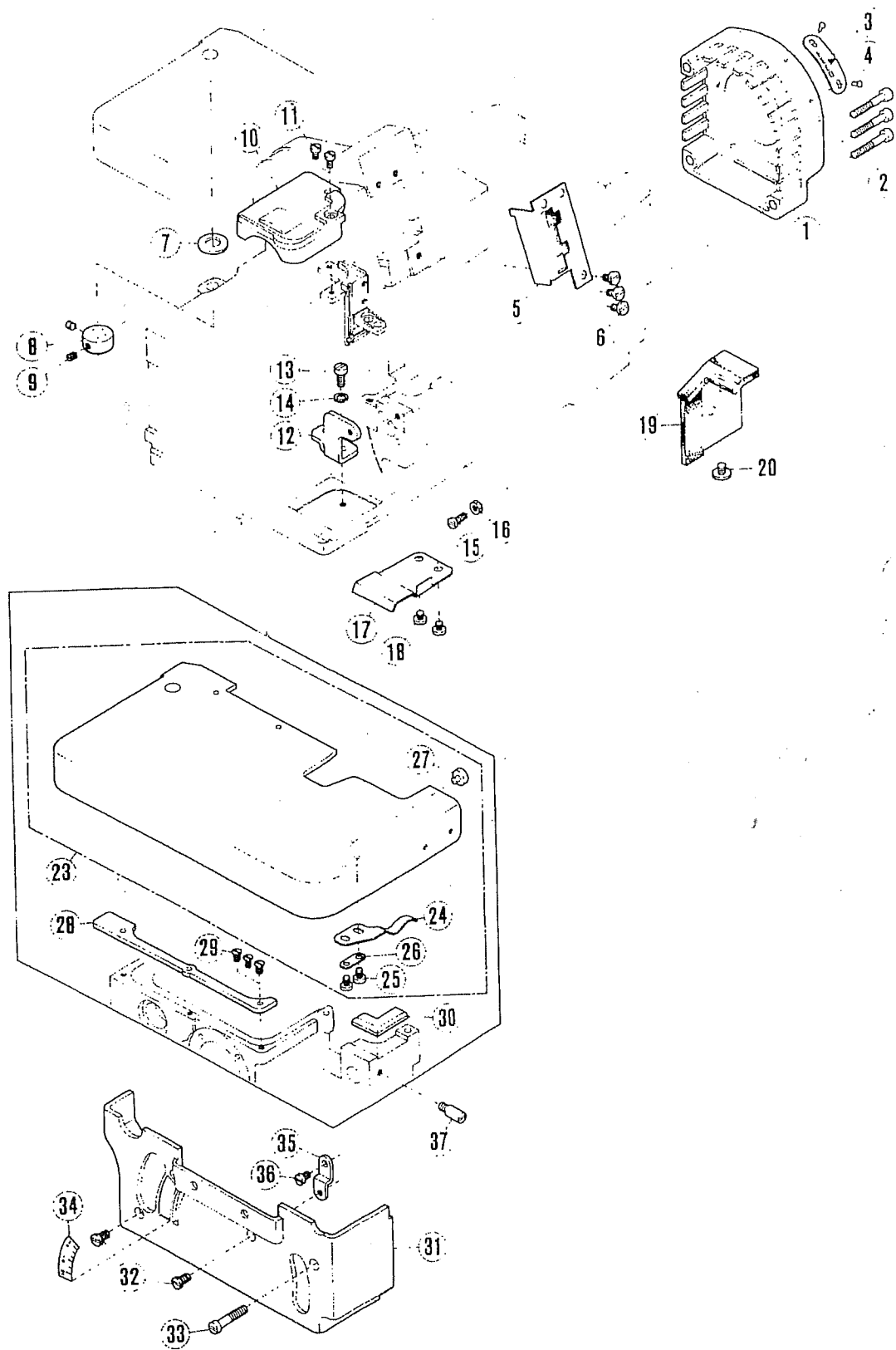
Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z 0142	630300	ACORN NUT	1	38	6z 1406	630147	LONG BUSHING	1
2	6z 2012	630301	ADAPTOR	1	39	6z 0784	630155	ECCENTRIC PIN	1
3	660036	660036	PRELOAD SPACER	1	40	6z 2754	SHCS4-40X $\frac{1}{2}$	SOCKET HEAD CAP SCREW	1
4	6z 0534	630303	CHECK NUT	1	41	6z 1885	PHMS $\frac{1}{2}$ -28X $\frac{1}{2}$	PAN HEAD MACHINE SCREW	2
5	6z 3358	630304	WHITE SPRING	1	42	6z 2036	630144	PRESSER FOOT ARM	1
6	6z 1256	630305	HOUSING PRESSURE SPRING	1	43	6z 0454	617440	SCREW	1
7	6z 2816	630306	SPACER	2	44	6z 0788	620134	ECCENTRIC STUD	1
8	6z 3358	630304	WHITE SPRING	1	45	6z 2764	SHCS6-32X1	SOCKET HEAD CAP SCREW	1
9	6z 3358	630304	WHITE SPRING	1	46	6z 1390	620165	LOCATING BAR	1
10	6z 2756	SHCS8-32X $\frac{1}{2}$	SOCKET HEAD CAP SCREW 8-32X $\frac{1}{2}$	2	47	6z 2292	620168	RUBBING BLOCK	1
11	6z 2103	630307	PRESSURE SPRING BASE	1	48	6z 0656	620135	BEAM CONNECTOR LINK	1
12	6z 243	660017	BEAM, LIFTER	1	49	6z 0657	630138	CONNECTOR LINK PIVOT PIN	1
13	6z 1587	660028	PRESSURE SPRING MOUNTING BLOCK	1	50	6z 2518	611620	SCREW	1
14	6z 0391	630310	BOTTOM SPACER	1	52	6z 2777	SHCS8-32X $\frac{1}{2}$	SOCKET HEAD CAP SCREW	1
15	6z 2032	660016	PRESSER BAR	1	53	6z 1216	HLSS4-40X $\frac{1}{2}$	HOLLOW LOCK SET SCREW	7
16	6z 0703	630136	NEEDLE DRIVE ARM	1	54	6z 1388	660042	LINKAGE ASSEMBLY	1
17	6z 2547	619400	SCREW	2	55	6z 0985	FHMS8-32X $\frac{1}{2}$	FLAT HEAD MACHINE SCREW	1
18	6z 0490	630140	W.F. BEAM	1	56	6z 2806	660032	SPACER	1
19	6z 0385	620150	LONG PIVOT PIN	3	57	6z 2224	660035	RETAINER	1
20	6z 2769	SHCS5-40X $\frac{1}{2}$	SOCKET HEAD CAP SCREW 5-40X $\frac{1}{2}$	2	58	6z 2730	660018	SLIDE, LIFTER	1
21	6z 3454	660022	PRESSER FOOT EXTENSION	1	59	6z 1571	MPAT-8016	FITTING	1
23	6z 2765	SHCS8-32X $\frac{1}{2}$	SOCKET HEAD CAP SCREW	1	60	6z 0167	091	AIR CYLINDER	1
24	6z 2087	660009	PRESSER FOOT ASSEMBLY, 3/4"	1	61	6z 2799	660029	SPACER AIR CYL	1
24A	6z 2088	660010	PRESSER FOOT ASSEMBLY, 1"	1	62	6z 2778	SHCS8-32X $\frac{1}{2}$	SCREWS	4
25	6z 3210	660007	3/4" TOP FEED	1	63	6z 3386	660030	YOKE	1
25A	6z 3195	660008	TOP FEED, 1"	1	64	6z 1924	660031	PIN	1
29	6z 0688	660026	COVER GUIDE	1	65	6z 2635	SC7-5	SET SCREW	1
30	6z 1167	HHCS $\frac{1}{2}$ -20X $\frac{1}{2}$	HEX HEAD BOLT	1	66	6z 1177	HN $\frac{1}{2}$ -24	NUT	1
31	6z 2478	SHCS8-32X $\frac{1}{2}$	SOCKET HEAD CAP SCREW	1	67	6z 1586	660033	CYL. MTG. NUT	1
32	6z 3207	630145	TOP FEED MAIN SECTION	1	69	6z 2830	SLW#8	LOCK WASHER	2
33	6z 1946	620175	PIVOT PIN	1	70	6z 0147	660034	ADAPTOR	2
34	6z 3190	620177	TOP FEED CONNECTOR LINK	1	71	6z 1946	620175	PIN	1
35	6z 2755	SHCS8-32X $\frac{1}{2}$	SOCKET HEAD CAP SCREW	1	72	6z 0745	DP $\frac{1}{2}$ X $\frac{1}{2}$	DOWEL PIN	1
36	6z 3534	630117	TOP FEED HOLDER	1	73	6z 0818	EXRPIN $\frac{1}{2}$ X $\frac{1}{2}$	EXPANSION PIN	1
37	6z 2477	SHCS8-32X $\frac{1}{2}$	SOCKET HEAD CAP SCREW	1	74	6z 3430	617420	WICKING (NOT SHOWN))	1

This exploded view diagram illustrates the assembly of a mechanical unit. The main components are numbered 1 through 65. Key sub-assemblies are shown separately: 23A (top right), 54 (middle right), 56 and 57 (middle right), 58 (middle right), and 59 (bottom right). The diagram shows the relationship between various plates, brackets, screws, and fasteners. A small inset box labeled 27A shows a specific fastener. The assembly is shown in a disassembled state to show the sequence of parts.

MISCELLANEOUS COVERS

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	615860	615860	TOP COVER	1	34	6z 1190	614880	HINGE	1
2	6z 2538	618980	SCREW	4	35	6z 1398	610200	HINGE SCREW SHORT	3
3	6z 1076	616800	GASKET	1	36	6z 1206	610400	HINGE SCREW WASHER	3
4	6z 2741	616820	CUSHION	2	37	6z 1202	614900	HINGE PIN	1
5	6z 1862	614820	OIL SPLASH SIGHT WINDOW	1	38	6z 1199	610920	HINGE PIN STOP RIGN	1
6	6z 0140	614840	O-RING	1	39	6z 2944	618920	STOP SCREW	1
7	6z 1977	616060	PLUG	1	40	6z 1208	614920	HINGE SPRING	1
8	6z 3075	640001	THREAD GUIDE BAR	1	41	6z 2533	618660	SCREW	1
9	6z 2941	618280	NUT	1	42	6z 1996	618800	POST LOCK NUT	1
10	6z 0561	610780	WASHER	1	43	6z 1324	640075	FRONT COVER LEFT	1
14	6z 0269	640003	BEDPLATE	1	44	6z 1037	640004	FRONT COVER	1
15	6z 2523	618340	SCREW	4	45	6z 0486	BHCS5-40X½	SCREW	5
16	6z 2566	640002	SCREW	1	46	6z 1855	620195	BOOT	1
17	6z 1075	616540	GASKET	1	47	6z 0684	620204	COVER BRKT (3/4" MODEL ONLY)	1
18	6z 2243	616100	BED COVER PLATE RIGHT	1	49	6z 0488	BHCS6-32X½	SCREW	2
19	6z 2535	618740	SCREW	6	54	6z 0828	640073	EYE GUARD	1
20	6z 1074	616120	GASKET	1	55	6z 2068	610120	SCREW	2
21	6z 0840	660048	FABRIC GUIDE	1	56	6z 1825	618320	NUT	2
22	6z 1886	PHMS6-32X½	SCREW	2	57	6z 1206	610400	HINGE SCREW WASHER	2
23	6z 1650	614940	NEEDLE BAR COVER	1	58	6z 1953	614780	EYE GUARD	1
23A	6z 1039	660044	NDLE BAR COVER-1" MODEL ONLY	1	59	6z 1036	630100	FRONT COVER ASSEMBLY	1
24	611820	611820	HINGE PIN	2	60	6z 1192	660045	HINGE, LARGE-1" MODEL ONLY	1
25	6z 1400	611860	LOCK SPRING	1	61	6z 1207	660046	HINGE, SMALL-1" MODEL ONLY	1
26	6z 1399	610220	LOCK SPRING SCREW	2	62	6z 0146	660047	ADAPTOR, HINGE-1" MODEL ONLY	1
27	6z 1397	613530	LOCK SPRING LATCH	1	63	6z 0488	BHCS6-32X½	SCREW	6
27A	6z 1316	660043	LATCH-1" MODEL ONLY	1	64	6z 2753	SHCS4-40X½	SCREW	2
28	6z 2523	618340	SCREW	1	65	6z 1332	611060	THREAD EYELET	2
29	6z 0710	610680	CUSHION RUBBER	1	66	6z 0488	BMHS-6-32X½	SCREW (NOT SHOWN)	1
30	6z 1599	617270	NAME PLATE	1	67	6z 0690	620211	COVER STAND OFF (NOT SHOWN)	1
31	6z 2247	640074	FRONT COVER RIGHT	1					

2) MISCELLANEOUS COVERS

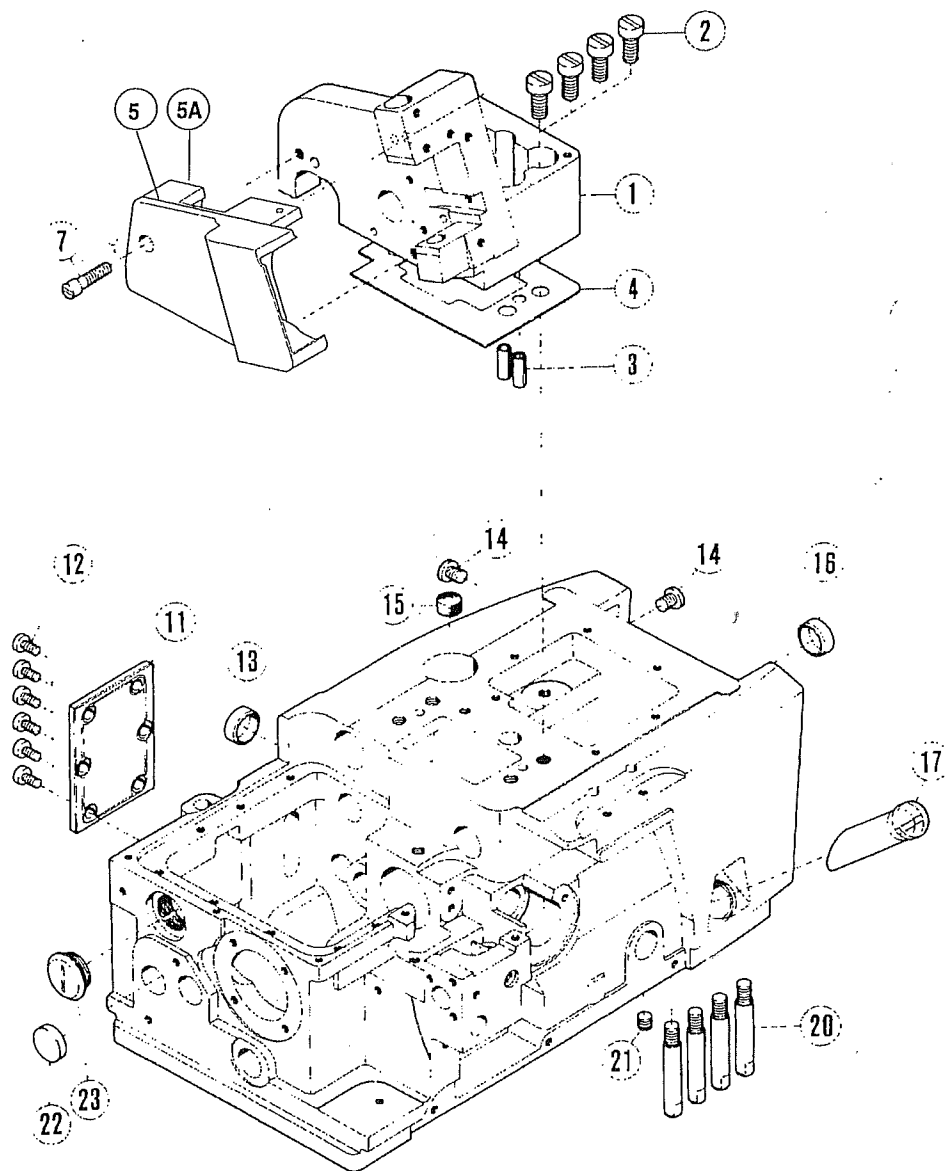


2) MISCELLANEOUS COVERS

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z 1835	613960	OIL COOLER COVER	1	19	617145	617145	R.LOOPER LVR.OIL SHIELD	1
2	6z 2533	618660	SCREW	1	20	6z 2537	618940	SCREW	1
3	6z 2936	613940	STITCH INDICATOR	1	23	6z 0579	660037	CLOTH COVER COMPLETE	1
4	6z 2257	614500	RIVET	2	24	613520	613520	LOCK SPRING	1
5	6z 0842	616640	FACE PLATE	1	25	6z 1398	610200	LOCK SPRING SCREW	2
6	6z 2523	618340	SCREW	3	26	610900	610900	LOCK SPRING SCREW WASHER	1
7	6z 1209	611760	WASHER	1	27	6z 2741	616820	CUSHION	1
8	611260	611260	THRUST COLLAR	1	28	6z 0711	613540	CUSHION RUBBER LEFT	1
9	6z 2515	610420	SET SCREW	2	29	6z 2526	618400	SCREW	3
10	640007	640007	FEED ECC. COVER	1	30	6z 1040	613560	CUSHION RUBBER FRONT	1
11	6z 2552	619520	SCREW	2	31	6z 1333	614420	MACHINE COVER LEFT	1
12	6z 2813	614440	SPACER	1	32	6z 2532	618640	SCREW	2
13	6z 2808	618120	SPACER SCREW	1	33	6z 1408	619060	LONG SCREW	1
14	6z 2809	611640	SPACER SCREW WASHER	1	34	616080	616080	INDICATION PLATE	1
15	619800	619800	STOP SCREW	1	35	6z 2812	614430	SPACER	1
16	6z 2941	618280	STOP SCREW WASHER	1	36	6z 2534	618720	SCREW	1
17	6z 0858	640008	FEED BAR COVER	1	37	6z 2945	619180	STOP SCREW	1
18	6z 2521	618140	SCREW	2					

MACHINE BED FRAME

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z 3184	660023	MACHINE ARM (RIGHT)	1	13	6z 1976	614360	PLUG	1
2	6z 2530	618500	SCREW	4	14	619540	619540	SCREW	2
3	6z 1928	610980	PIN	2	15	6z 1844	614280	OIL FILTER	1
4	6z 1071	613580	GASKET	1	16	314360	314360	PLUG	1
5	6z 2706	660025	SIDE COVER (LEFT), 3/4"	1	17	6z 1856	612000	OIL SIGHT GAUGE	1
5A	6z 0693	660049	SIDE COVER (LEFT), 1" MODEL ONLY	1	20	612020	612020	BED PIN	4
7	6z 2545	619240	SCREW	1	21	6z 2519	611680	SCREW	1
11	617380	617380	COVER PLATE	1	22	6z 1978	617360	PLUG	1
12	6z 2560	619840	SCREW	6	23	6z 2290	650072	PLUG	1

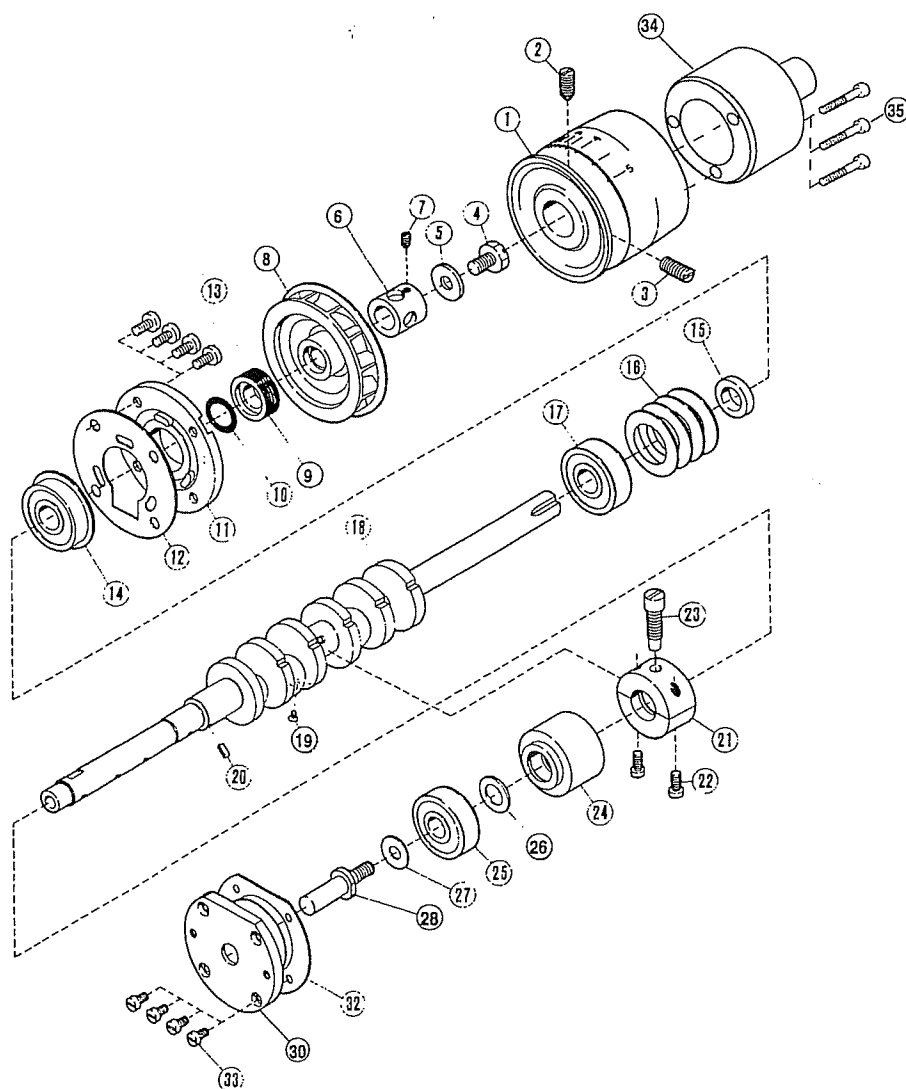


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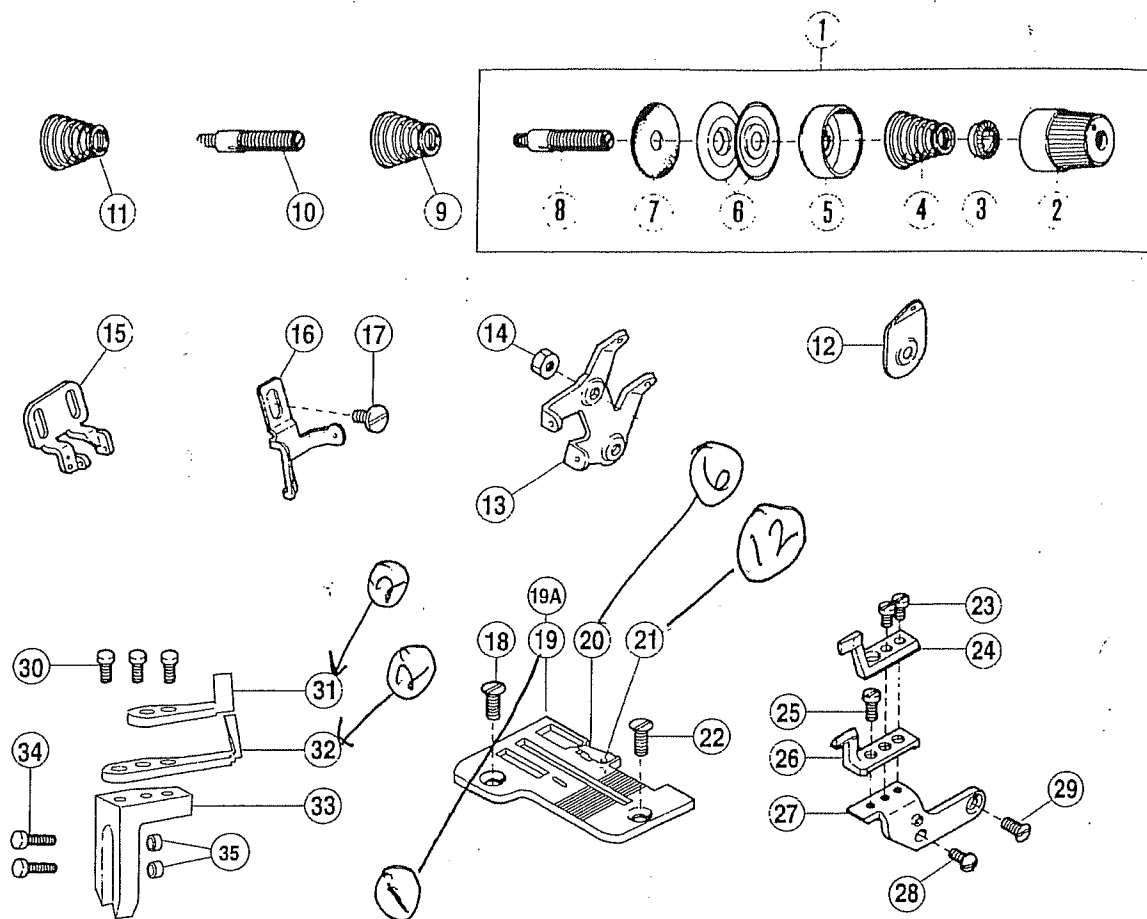
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CRANKSHAFT MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z 1541	612220	PULLEY	1	18	6z 0704	616140	CRANKSHAFT	1
2	6z 1990	618520	SCREW	1	19	620013	620013	SCREW	1
3	6z 2531	618540	SCREW	1	20	6z 1840	611580	OIL FELT	1
4	6z 2563	620012	SCREW	1	21	6z 0513	612080	BUSHING (CENTER)	1
5	6z 3342	612200	WASHER	1	22	6z 2740	610040	SCREW	2
6	6z 0636	612240	COLLAR	1	23	6z 0444	619300	SCREW	1
7	6z 0630	619340	SCREW	1	24	6z 0461	612060	BUSHING (LARGE)	1
8	6z 1836	613500	COOLING FAN	1	25	6z 1321	612040	BALL BEARING	1
9	6z 0705	616770	OIL SEAL COLLAR	1	26	6z 3345	640006	THRUST WASHER	1
10	6z 1853	615540	"O" RING	1	27	613840	613840	WASHER	1
11	616775	616775	PLATE	1	28	6z 0824	614520	CRANKSHAFT EXTENSION	1
12	6z 1069	612180	GASKET	1	30	6z 0228	614580	HOUSING	1
13	6z 2535	618740	SCREW	4	32	6z 1255	613680	GASKET	1
14	6z 2241	612140	BALL BEARING	1	33	6z 2512	610100	SCREW	4
15	612120	612120	SPACER	1	34	6z 1147	630102	SYNCHRONIZER ADAPTOR	1
16	6z 3341	612100	WASHER	4	35	6z 2775	SHCS8-32X1-1/2	SCREW	3
17	6z 0512	611480	BEARING	1					



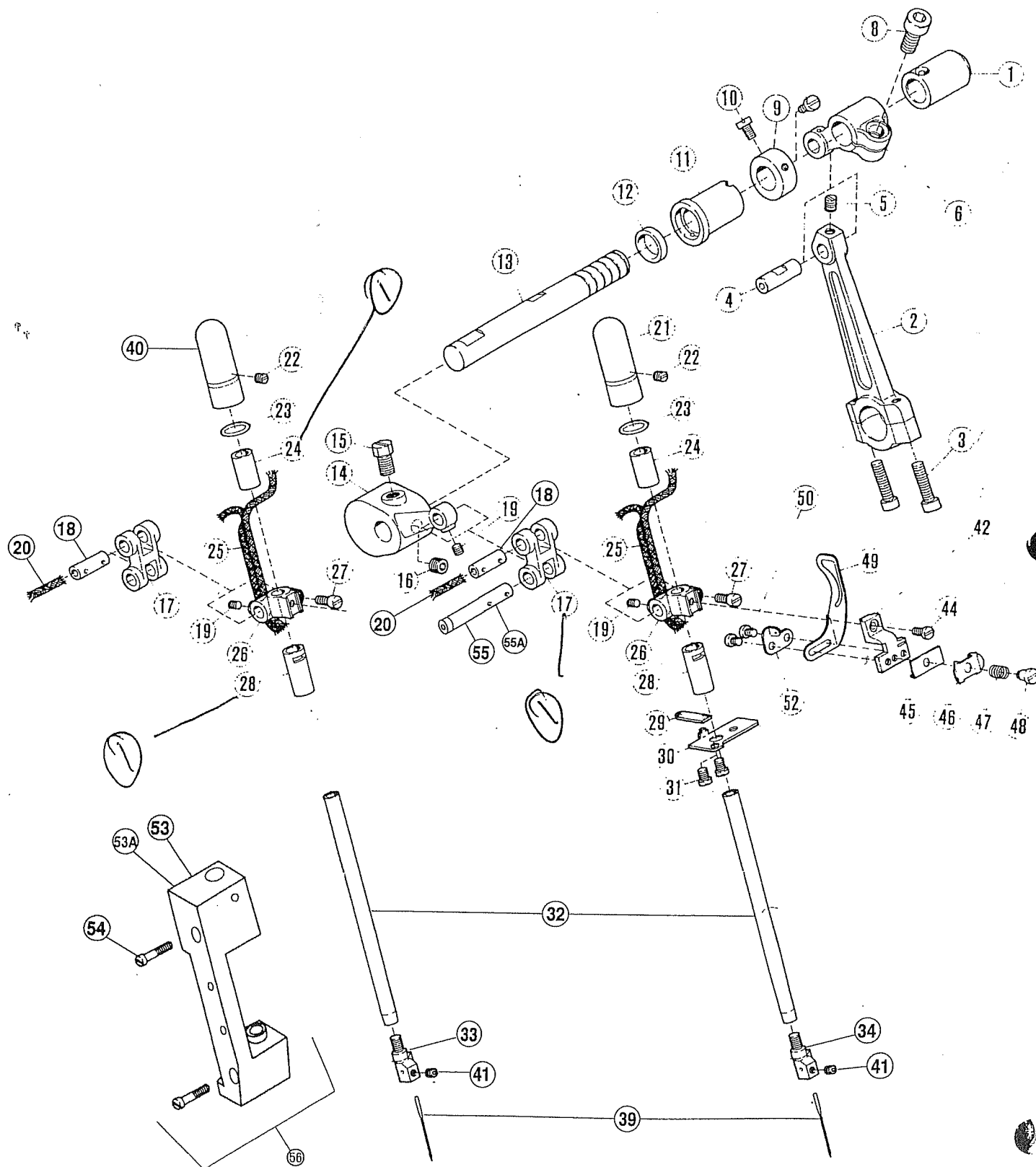
NEEDLE DRIVE AND NEEDLE GUARD MECHANISM



NEEDLE DRIVE AND NEEDLE GUARD MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z 1778	616840	NEEDLE THREAD TENSION COMPLETE	1	19	6z 3137	660001	THROAT PLATE (3/4")	1
2	6z 1824	616680	NUT	1	20	6z 0526	660039	CHAIN FINGER	1
3	6z 2870	616700	SPRING BUSHING	1	21	6z 0947	HMS2-56X-1/8"	PHL CHAINFINGER SCREW	1
4	6z 1161	611040	SPRING (HEAVY)	1	22	6z 1106	610560	SCREW	1
5	6z 2871	616740	SPRING CUP	1	23	6z 2527	618420	SCREW	2
6	6z 0742	611460	DISC	2	24	6z 1049	614220	NEEDLE GUARD, FRONT	1
7	6z 0709	616720	CUSHION FELT	1	25	6z 2525	618380	SCREW	1
8	6z 2967	618880	POST, SHORT ENDED	1	26	6z 2158	614200	NEEDLE GUARD, REAR	1
9	6z 1381	611120	SPRING (LIGHT)	1	27	6z 1333	614240	NEEDLE GUARD BRACKET	1
10	6z 1998	618560	POST, LONG ENDED	1	28	6z 1312	618700	SCREW	1
11	6z 1568	611180	SPRING (MEDIUM)	1	29	6z 2544	619120	SCREW	1
12	6z 3036	611920	GUIDE DISC	1	30	6z 2754	SHCS4-40X1/2"	SOCKET HEAD CAP SCREW	3
13	6z 1136	615880	TENSION GUIDE	1	31	6z 1879	630103	NEEDLE GUARD, FRONT	1
14	6z 1996	618800	POST LOCK NUT	1	32	6z 1266	630104	NEEDLE GUARD, REAR	1
15	6z 3090	640009	THREAD GUIDE	1	33	6z 1703	630105	NEEDLE GUARD BRACKET	1
16	6z 3091	640010	THREAD GUIDE	1	34	6z 1166	HHB10-32X1/2"	BOLT	2
17	6z 2523	618340	SCREW	1	35	6z 2271	660050	SPACER, 1" MODEL ONLY	2
18	6z 1106	610560	SCREW	1	19A	6z 3128	660002	1" THROAT PLATE	1

NEEDLE BAR MECHANISM

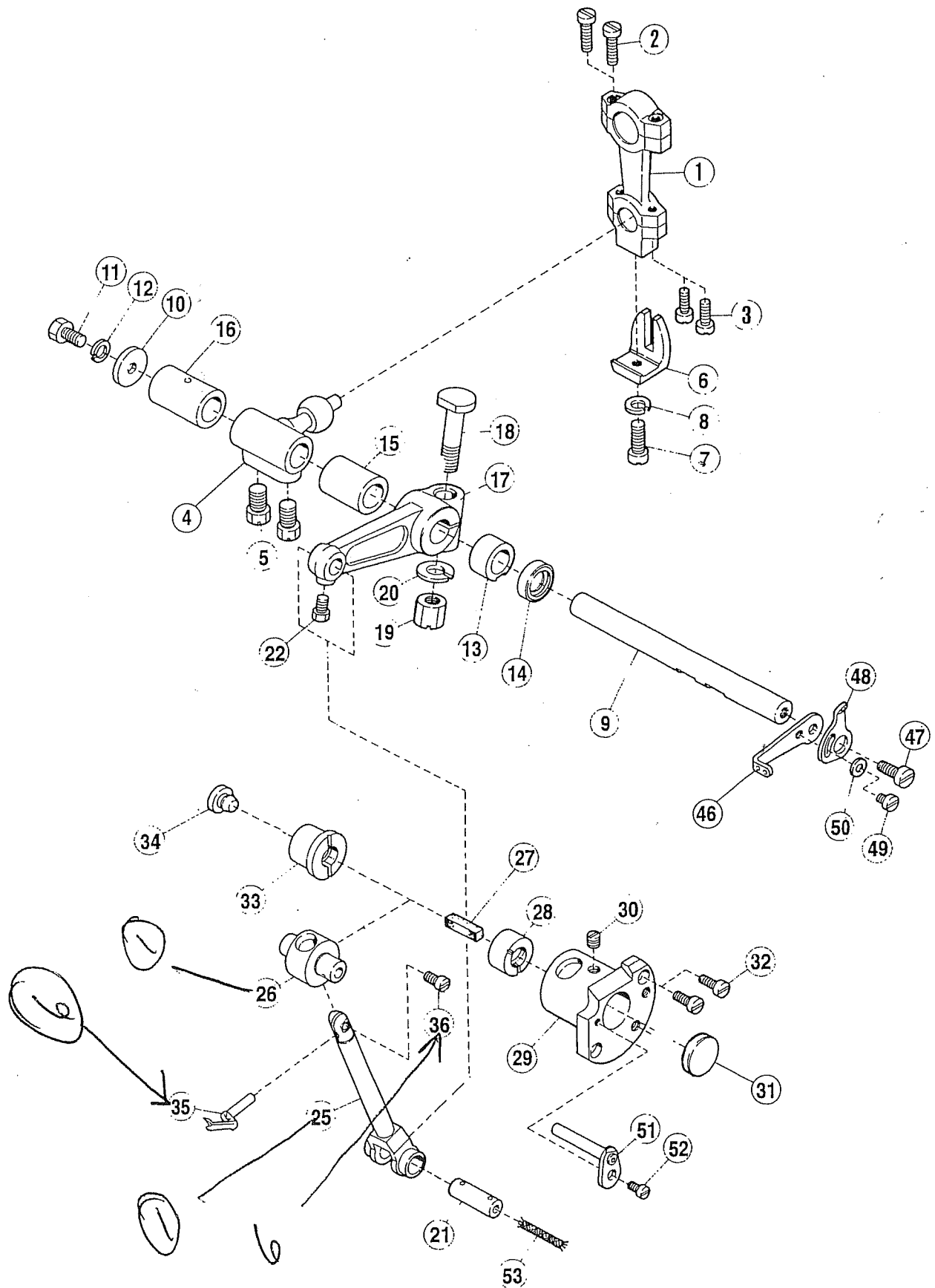


NEEDLE BAR MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z0464	615440	BUSHING (RIGHT)	1	28	6z1488	660024	BUSHING (LOWER)	2
2	6z1653	612260	CONNECTION	1	29	6z1842	617220	OIL FELT	1
3	6z0500	619200	SCREW	2	30	6z0764	617200	DUST SHIELD	1
4	6z1931	614760	PIN	1	31	6z0454	618440	SCREW	2
5	6z1920	619220	SCREW	1	32	6z1673	617280	NEEDLE BAR CLAMP	2
6	6z2242	630107	CRANK(REAR)	1	33	6z1720	617300	NEEDLE HOLDER	1
8	6z2761	SHCS $\frac{1}{4}$ -28X $\frac{1}{2}$	SCREW	1	34	6z2255	630113	NEEDLE HOLDER	1
9	611220	611220	THRUST WASHER	1	39	6z0121	PSM-1160	NEEDLE/OVERLOCK	2
10	6z2552	619520	SCREW	2	40	6z1637	660019	NEEDLE BAR CAP	1
11	6z1322	615420	BUSHING (LEFT)	1	41	6z2547	619400	SCREW	2
12	6z1323	615460	OIL SEAL	1	42	6z2222	614040	RETAINER BRACKET	1
13	6z1654	615400	SHAFT	1	44	6z2556	619640	SCREW	1
14	6z0703	630136	CRANK (FRONT)	1	45	6z1133	611720	GUIDE	1
15	6z2518	611620	SCREW	1	46	6z1132	610760	GUIDE	1
16	6z2549	619420	SCREW	1	47	6z2908	617340	SPRING	1
17	6z0660	630118	LINK	2	48	6z2565	629860	SCREW	1
18	6z1927	610960	PIN	2	49	6z1200	611880	TAKEUP	1
19	6z2547	619400	SCREW	3	50	6z2513	610135	SCREW	2
20	6z3415	611600	OIL WICK	2	52	6z3089	614060	THREAD GUIDE	1
21	6z1638	660038	CAP	1	53	6z1659	660020	NDLE. BAR SUPPORT ASSY, 3/4"	1
22	6z2515	610420	SCREW	1	53A	6z1613	660021	NDLE. BAR SUPPORT ASSY, 1"	1
23	6z2291	610740	"O" RING	2	55A	6z1909	660051	PIN CONN LINK (1" MODEL ONLY)	1
24	6z3298	613900	BUSHING UPPER	2	54	6z2776	SHCS8-32X1- $\frac{1}{2}$	SCREW	2
25	6z3430	617420	OIL WICK	2	55	6z1908	630115 *	PIN, CONNECTING LINK *	1
26	6z1642	640012	NEEDLE BAR CLAMP	2	56	660052	660052	NEEDLE BAR SUPPORT WITH BUSHINGS.	1
27A	6z2774	SHCS6-32X $\frac{1}{2}$	SCREW	1					
27B	6z2510	610060	SCREW	1					

* USE RETAINER #5103-23

SPREADER DRIVE MECHANISM

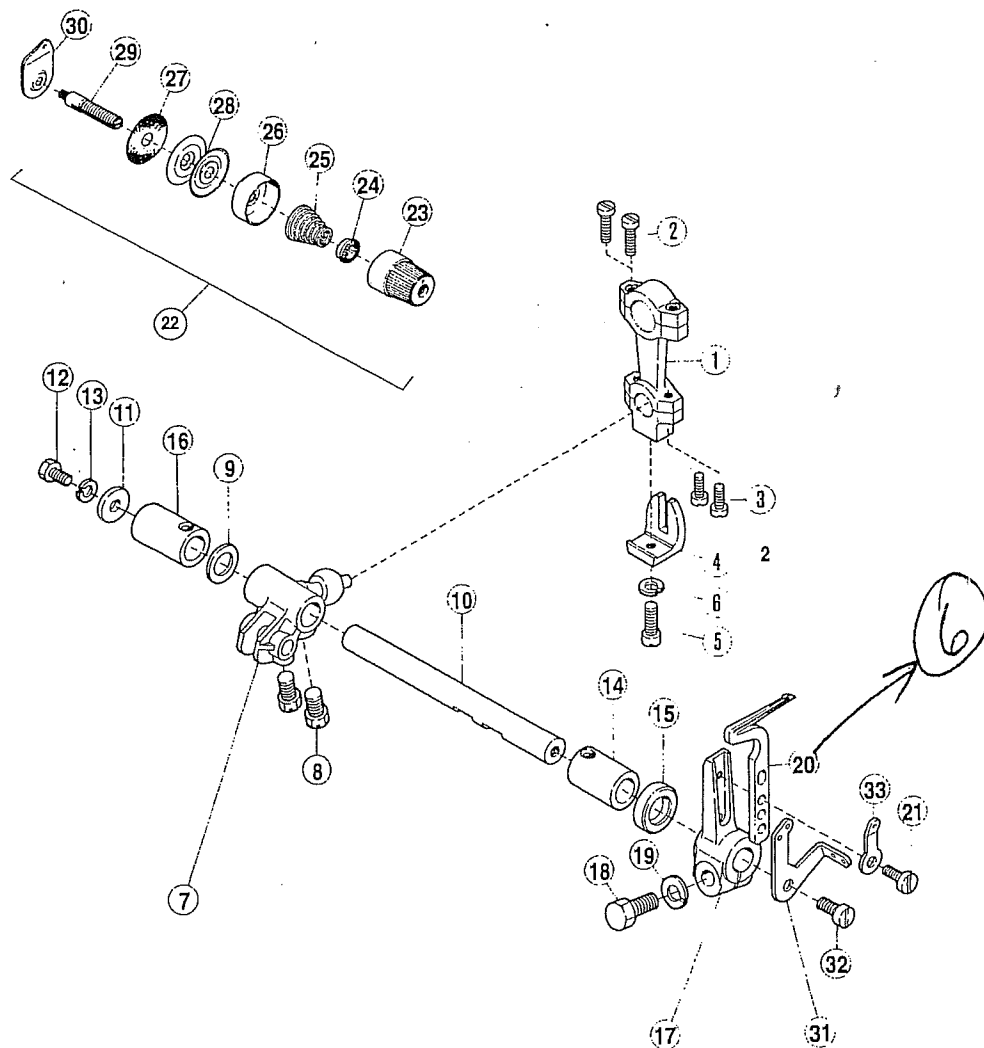


SPREADER DRIVE MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z 2250	616160	RIGHT LOOPER DRIVE CONN	1	22	6z 0629	618600	PIN SCREW	1
2	6z 2567	640013	CAP SCREW (LARGE)	2	25	6z 2252	616000	RIGHT LOOPER LEVER	1
3	6z 2567	640013	CAP SCREW (LARGE)	2	26	6z 3299	615100	GUIDE	1
4	612280	612280	CRANK	1	27	613600	613600	OIL FELT	2
5	6z 2518	611620	CRANK SCREW	2	28	6z 1034	612380	BUSHING (FRONT)	1
6	611160	611160	GUIDE	1	29	6z 1253	640017	HOUSING	1
7	6z 2554	619600	GUIDE SCREW	1	30	6z 2568	640018	BUSHING FRONT SCREW	1
8	6z 2809	611640	GUIDE SCREW WASHER	1	31	6z 1254	615220	HOUSING CAP	1
9	640015	640015	RIGHT LOOPER DRIVE SHAFT	1	32	6z 2512	610100	HOUSING CAP SCREW	2
10	6z 3156	612640	THRUST WASHER	1	33	6z 0467	640016	BUSHING (REAR)	1
11	6z 3153	617540	THRUST WASHER SCREW	1	34	617060	617060	CAP SCREW (LARGE)	1
12	6z 2809	611640	WASHER	1	35	6z 2869	620244	SPREADER	1
13	615760	615760	BUSHING (FRONT)	1	36	6z 0552	610700	CLAMP SCREW	1
14	6z 1033	612300	BUSHING (FRONT) OIL SEAL	1	46	6z 3105	616660	THREAD TAKEUP	1
15	6z 0466	640014	BUSHING (CENTER)	1	47	6z 2808	618120	SCREW	1
16	6z 2148	616620	BUSHING (REAR)	1	48	6z 0216	614640	AUXILIARY EYELET	1
17	6z 0757	630119	RIGHT LOOPER LEVER CRANK	1	49	6z 0210	618200	AUXILIARY SCREW	1
18	6z 0553	619280	CLAMP SCREW	1	50	6z 0215	611960	AUXILIARY SCREW WASHER	1
19	6z 0550	619380	CLAMP SCREW NUT	1	51	640019	640019	THREAD GUIDE WIRE	1
20	6z 0548	611560	CLAMP SCREW NUT WASHER	1	52	6z 2525	618380	SCREW	1
21	6z 1934	615480	PIN	1	53	6z 1840	611580	OIL WICK	1

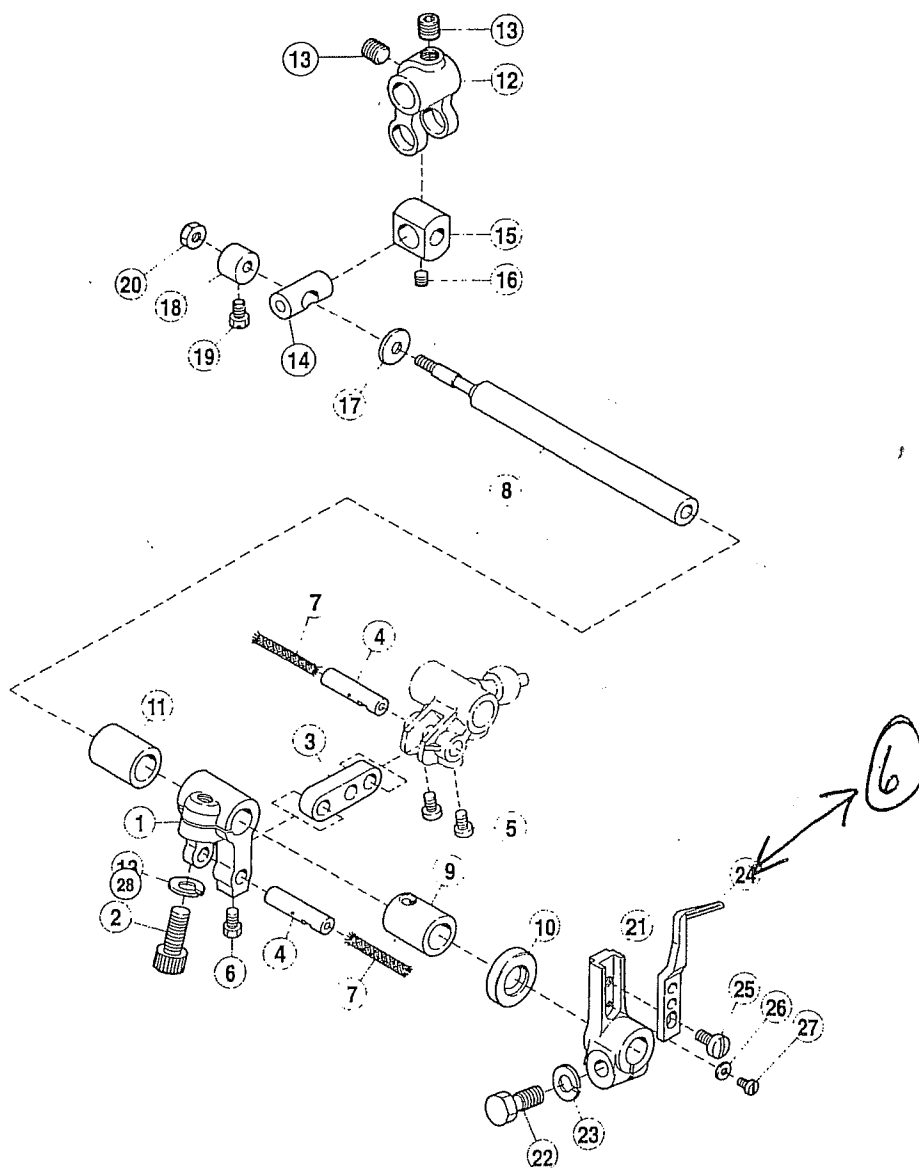
OVEREDGE (LEFT) LOOPER MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z2250	616160	LEFT LOOPER DRIVE CONN	1	18	6z0554	619360	CLAMP SCREW	1
2	6z2567	640013	CAP SCREW	4	19	6z0551	613640	CLAMP SCREW WASHER	1
4	611160	611160	GUIDE	1	20	6z1443	620238	RIGHT LOOPER LEVER	1
5	6z2569	640021	GUIDE SCREW	1	21	6z2068	610120	SCREW	1
6	6z2809	611640	GUIDE SCREW WASHER	1	22	6z3108	616860	THREAD TENSION COMPLETE	1
7	615240	615240	LEFT LOOPER DRIVE CRANK	1	23	6z1824	616680	NUT	1
8	6z2518	611620	SCREW	2	24	6z2870	616700	SPRING BUSHING	1
9	6z3345	640006	THRUST WASHER	1	25	6z1568	611180	SPRING (MIDDLE)	1
10	640015	640015	LEFT LOOPER LEVER SHAFT	1	26	6z2871	616740	SPRING CUP	1
11	6z3156	612640	THRUST WASHER	1	27	6z0709	616720	CUSHION FELT	1
12	6z3153	617540	THRUST WASHER SCREW	1	28	6z0742	611460	DISC	2
13	6z2809	611640	WASHER	1	29	6z1998	618560	POST	1
14	6z0469	640023	BUSHING (FRONT)	1	30	6z3036	611920	GUIDE	1
15	6z1852	640024	BUSHING FRONT OIL SEAL	1	31	6z1533	614620	LEFT LOOPER THREAD TAKEUP	1
16	6z0468	640022	BUSHING (REAR)	1	32	6z2808	618120	SCREW	1
17	6z1331	614000	RIGHT LOOPER LEVER	1	33	6z0831	640025	THREAD GUIDE	1



I) CHAINSTITCH LOOPER MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	640020	640020	LOOPER DRIVE CRANK	1	15	6z0315	615000	BLOCK	1
2	619265	619265	CLAMP SCREW	1	16	6z2547	619400	BLOCK SCREW	1
3	6z1387	615280	LINK	1	17	6z3157	615020	THRUST WASHER	1
4	6z1384	615300	LINK PIN	2	18	6z0637	615040	COLLAR	1
5	6z2552	619520	LINK PIN SCREW	2	19	6z0629	618600	COLLAR SCREW	1
6	6z0629	618600	LINK PIN SCREW	1	20	6z2570	640026	NUT	1
7	6z3415	611600	OIL WICK	2	21	6z1433	612520	LOOPER LEVER	1
8	6z1430	615320	LOOPER DRIVE SHAFT	1	22	6z0554	619360	CLAMP SCREW	1
9	6z1035	615820	BUSHING FRONT	1	23	6z0551	613640	CLAMP SCREW WASHER	1
10	6z1852	640024	BUSHING FRONT OIL SEAL	1	24	6z1484	620270	LOOPER	1
11	6z0466	640014	BUSHING REAR	1	25	6z2514	610140	SCREW	1
12	6z1415	614960	LOOPER AVOIDING LINK	1	26	6z2174	613200	REGULATOR	1
13	6z2557	619720	SCREW	2	27	6z1959	618220	REGULATOR SCREW	2
14	6z1932	614980	PIN	1	28	6z0551	613640	WASHER	1

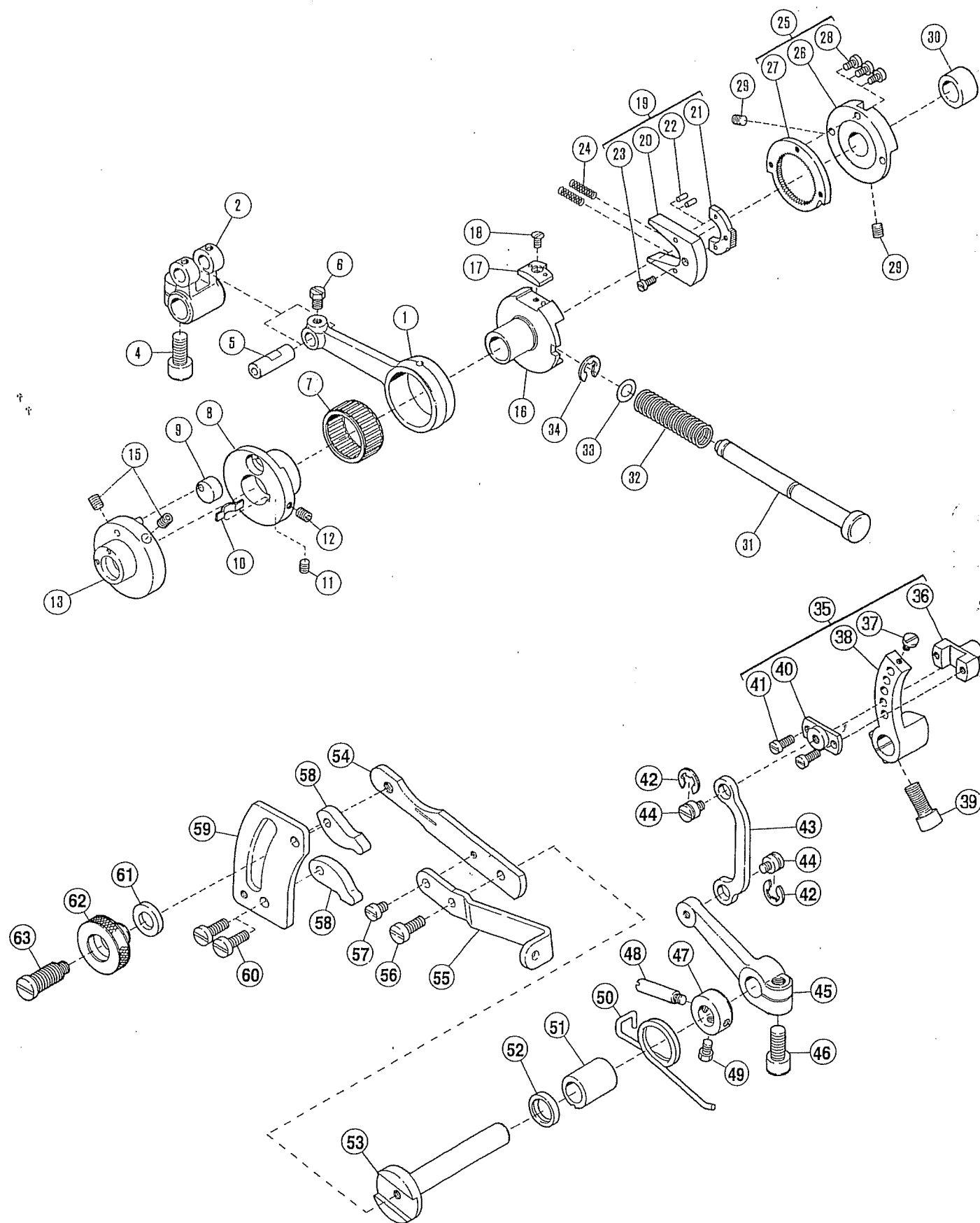




2) CHAINSTITCH LOOPER MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z 1412	620030	LOOPER AVOIDING CONNECTION	1	22	6z 1134	612560	GUIDE	1
2	6z 1937	620031	PIN	1	23	6z 1458	612580	LOOPER THREAD GUIDE BRACKET	1
4	6z 1916	619740	PIN NUT	1	24	6z 2523	618340	SCREW	1
6	6z 1914	615740	PIN NUT WASHER	1	25	6z 2534	618720	SCREW	1
8	6z 1411	620029	COLLAR	1	26	6z 3003	613700	TAKEUP EYELET	2
10	6z 1678	620028	NEEDLE BEARING	1	27	6z 2529	618480	SCREW	2
11	6z 1413	620032	LOOPER AVOIDING CRANK	1	28	6z 1457	616220	LOOPER THREAD GUIDE	1
12	6z 0556	620026	CLAMP SCREW	1	29	6z 2534	618720	SCREW	1
13	6z 1416	614540	LOOPER AVOIDING SHAFT	1	30	6z 1462	612600	LOOPER THREAD TUBE	1
14	6z 0470	640027	LEFT BUSHING	1	31	6z 2515	610420	SCREW	1
15	6z 2244	612500	RIGHT BUSHING	1	32	6z 1461	618300	LOOPER THREAD TENSION NUT	1
16	6z 3150	611100	THRUST COLLAR	2	33	6z 2902	610520	SPRING	1
17	6z 0629	618600	COLLAR SCREW	4	34	6z 0742	611460	DISC	2
19	619315	619315	SCREW	2	35	6z 1997	610500	POST	1
20	6z 1459	612540	LOOPER THREAD TAKEUP	1	36	6z 3036	611920	GUIDE	1
21	6z 2547	619400	GENUINE SCREW	2					

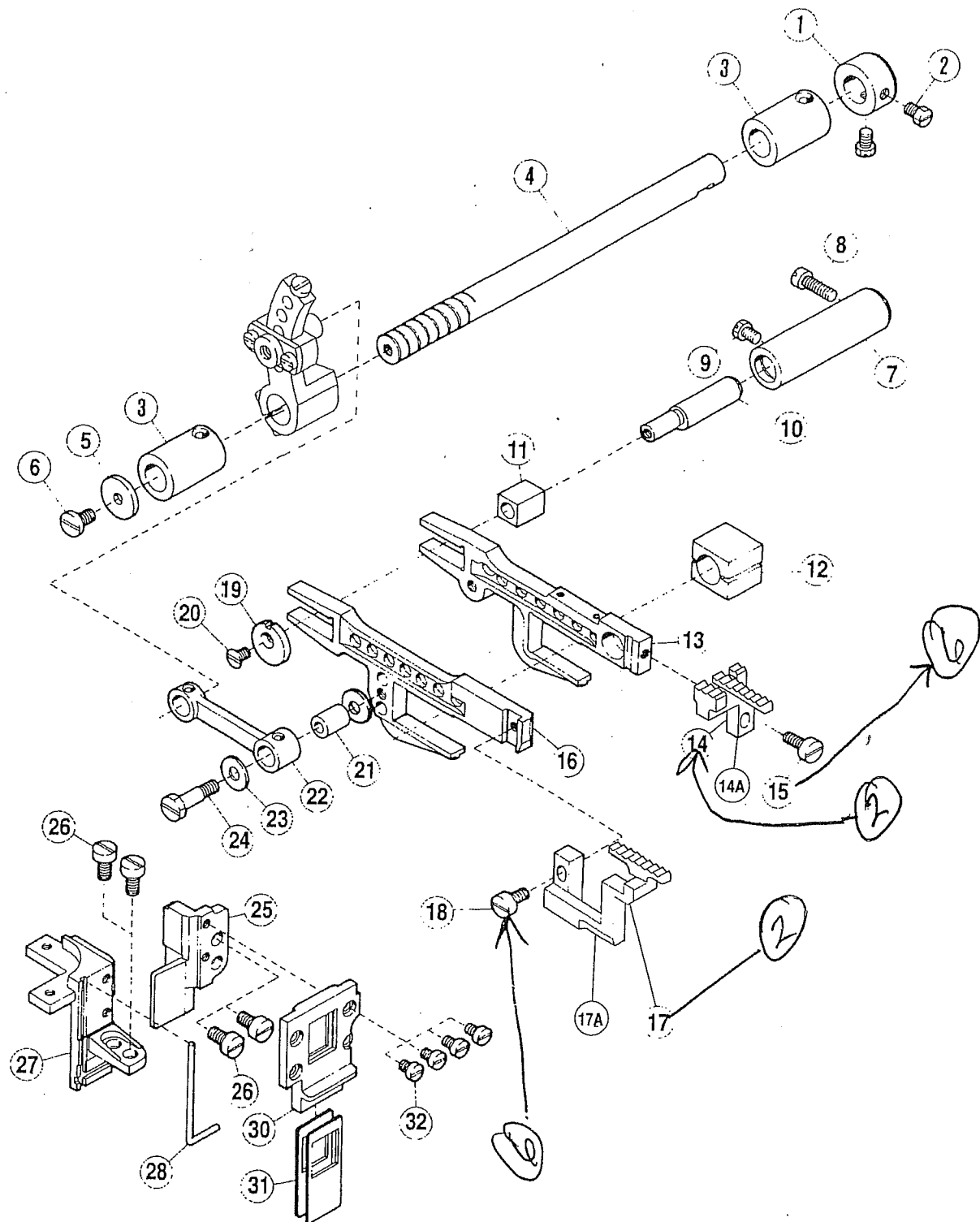
I) MAIN & DIFFERENTIAL FEED MECHANISM



I) MAIN & DIFFERENTIAL FEED MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z0902	612620	FEED DRIVE CONNECTION	1	34	6z2382	611740	RETAINING RING	2
2	6z2937	620217	FEED DRIVE CRANK	1	35	6z0702	615560	DIFF FEED REG. ASSY. (REF:#36-41)	1
4	SHCSX-28X	SHCSX-28X	SCREW	1	36	615600	615600	BLOCK	1
5	6z1931	614760	PIN	1	37	6z2533	618660	STOP SCREW	1
6	6z0629	618600	PIN SCREW	1	38	615580	615580	SEGMENT (CRANK)	1
7	6z1677	612480	NEEDLE BEARING	1	39	6z0555	619700	SCREW	1
8	6z0910	620034	FEED DRIVE ECCENTRIC	1	40	615610	615610	COVER	1
9	6z0905	620037	FEED ECCENTRIC GUIDE	1	41	6z2527	618420	SCREW	2
10	6z0854	620038	FLAT SPRING	1	42	6z2382	611740	RETAINING RING	2
11	6z2547	619400	SET SCREW	1	43	6z0735	612820	DIFF. FEED REG. LINK	1
12	6z2564	620039	SET SCREW	1	44	6z2551	619460	SCREW	2
13	6z1414	620040	LOOPER AVOIDING ECCENTRIC	1	45	6z0928	612800	DIFF. FEED REG. LEVER	1
15	6z2641	620033	SET SCREW	2	46	6z0555	619700	SCREW	1
16	6z0911	620042	FEED REGULATING ECCENTRIC	1	47	6z3151	614120	COLLAR	1
17	6z2948	620052	STOPPER	1	48	6z1318	614180	SCREW PIN	1
18	6z2558	619780	SCREW	1	49	6z0629	618600	SCREW	1
19	6z0922	616340	FD.REG.RACHET ASSY.(REF:#20-24)	1	50	6z2170	614160	REGULATING SPRING	1
20	616365	616365	POSITION GEAR BRACKET	1	51	640031	640031	BUSHING	1
21	616360	616360	POSITION GEAR	1	52	6z1033	612300	OIL SEAL	1
22	6z1938	640029	PIN	2	53	6z0736	614100	DIFF. FEED SHAFT	1
23	6z2553	619580	SCREW	1	54	6z2160	614140	DIFF. FEED REG. LEVER	1
24	6z2907	616400	SPRING	2	55	6z1043	614600	LEVER (FRONT)	1
25	6z2141	620035	RACHET WHEEL ASSY. (REF:#26-29)	1	56	6z2353	618760	SCREW	1
26	620043	620043	BRACKET	1	57	6z1398	610200	SCREW	1
27	620044	620044	WHEEL	1	58	6z3269	612860	STOPPER	2
28	620045	620045	SCREW	3	59	6z1342	612840	REGULATING PLATE	1
29	6z2641	620033	SET SCREW	2	60	6z2353	618760	SCREW	2
30	6z2814	620053	SPACER	1	61	6z1340	611940	WASHER	1
31	6z2133	620055	PUSH BUTTON	1	62	6z1339	614480	THUMB NUT	1
32	6z2267	616520	SPRING	1	63	6z1341	619500	SCREW	1
33	620054	620054	O-RING	1					

2) MAIN & DIFFERENTIAL FEED MECHANISM



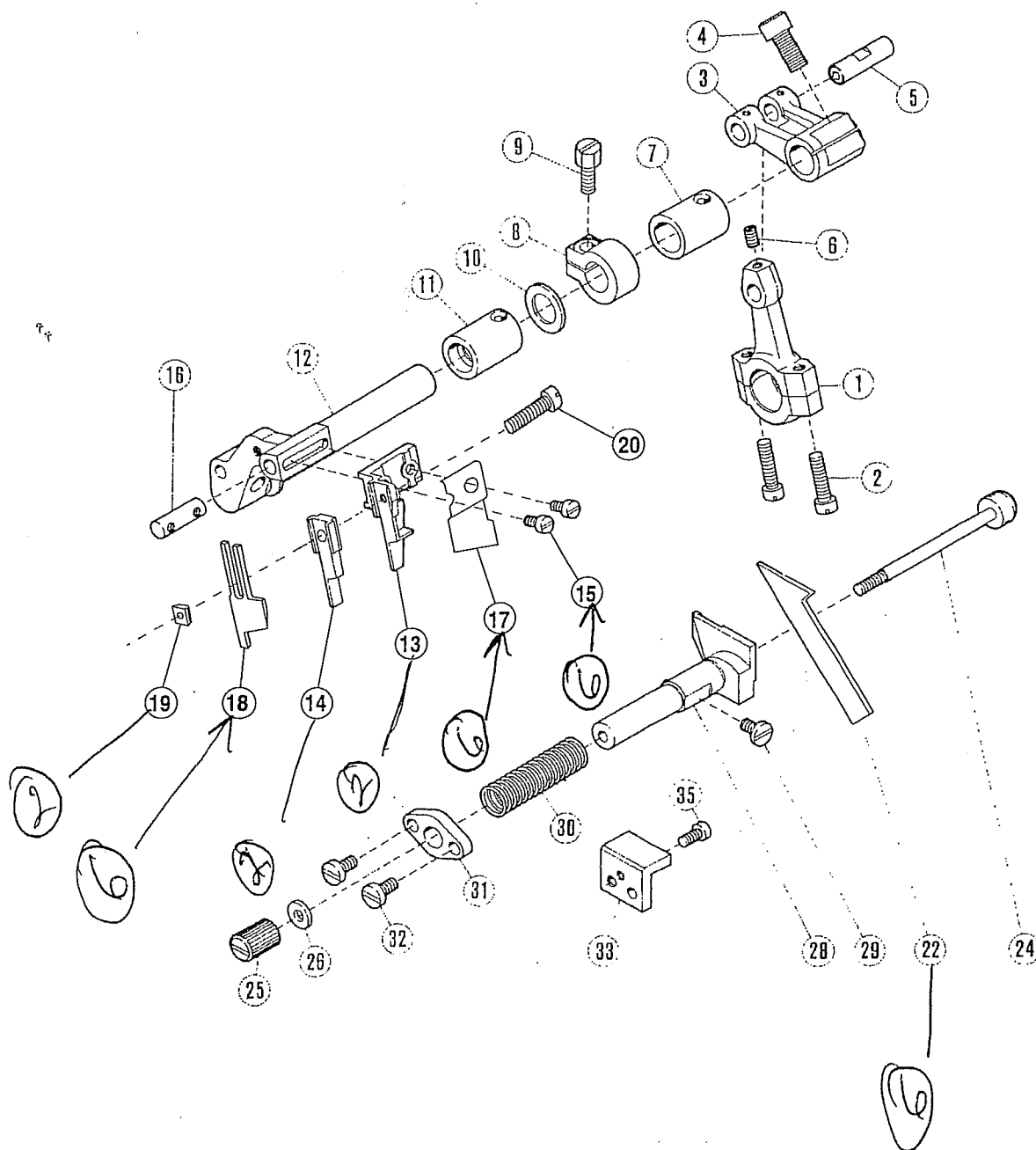
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2) MAIN & DIFFERENTIAL FEED MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z3150	611100	THRUST COLLAR	1	17	6z1537	660003	DIFFERENTIAL FEED DOG, 3/4" (FRONT)	1
2	6z0629	618600	THRUST COLLAR SCREW	2	17A	6z1495	660004	DIFFERENTIAL FEED DOG, 1" (FRONT)	4
3	6z0471	640032	BUSHING	2	18	6z2068	610120	SCREW	1
4	6z0863	614080	FEED BAR SHAFT	1	19	6z3343	613780	WASHER	1
5	6z3156	612640	THRUST WASHER	1	20	6z3322	619480	WASHER SCREW	1
6	6z2523	618340	THRUST WASHER SCREW	1	21	6z0462	612680	BUSHING	1
7	6z0857	612780	FEED BAR GUIDE BUSHING	1	22	6z0650	612720	CONNECTING LINK	1
8	6z0454	617440	SCREW	1	23	6z0453	612700	BUSHING SCREW WASHER	1
9	6z0629	618600	SCREW	1	24	6z0455	619140	BUSHING SCREW	1
10	6z0860	612760	FEED BAR HINGE PIN	1	25	6z2245	615140	FEED BAR GUIDE (RIGHT)	2
11	6z1138	640033	FEED BAR GUIDE BLOCK	1	26	6z2542	619080	SCREW	1
12	6z2825	614320	LIFT BLOCK (SPLIT)	1	27	6z1139	640034	FEED BAR GUIDE	1
13	6z1544	612730	FEED BAR	1	28	6z1072	615200	GASKET	4
14	6z1539	660005	MAIN FEED DOG, 3/4" (REAR)	1	30	6z1262	615180	INSERT PLATE	1
14A	6z1538	660006	MAIN FEED DOG, 1" (REAR)	1	31	6z0849	615160	FEED BAR OIL SPLASH GUARD	1
15	6z2512	610100	SCREW	1	32	6z2554	619600	SCREW	1
16	6z0731	612740	DIFFERENTIAL FEED BAR	1					

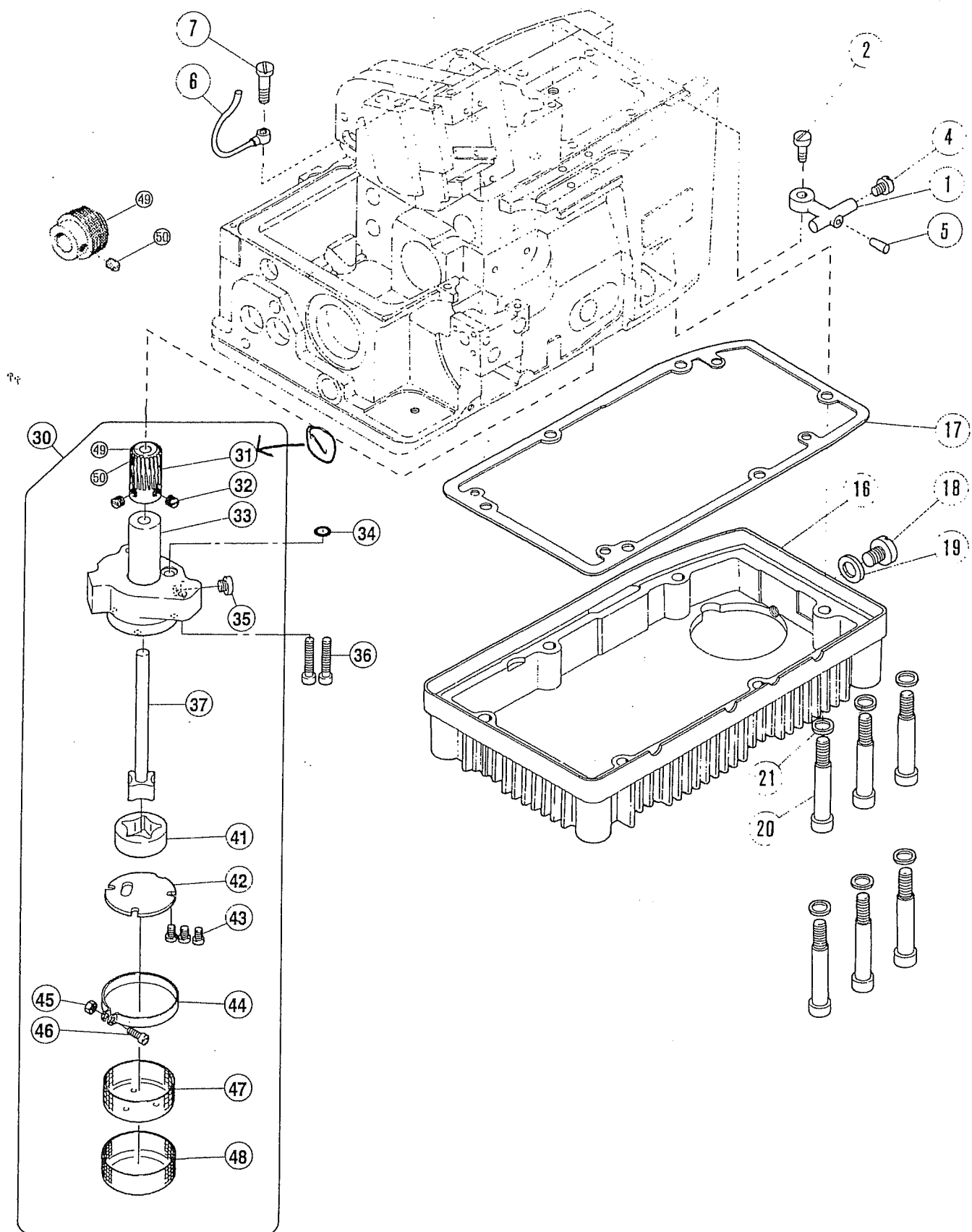
UPPER & LOWER KNIFE MECHANISM



UPPER & LOWER KNIFE MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z3269.....	612880	UPPER KNIFE DRIVE CONN.....	1	17	6z3232.....	620240	TRIM SHIELD.....	1
2	6z0500.....	619200	CAP SCREW.....	2	18	6z3284.....	630128	UPPER KNIFE-CARB. TIPPED.....	1
3	6z3270.....	613000	UPPER KNIFE DRIVE CRANK.....	1	19	6z3285.....	630127	T-NUT.....	1
4	6z0555.....	619700	CLAMP SCREW.....	1	20	6z2771.....	SHCS6-32X½	SCREW.....	1
5	6z1929.....	612900	PIN.....	1	22	6z0385.....	630150	LOWER KNIFE.....	1
6	6z1919.....	610440	PIN SCREW.....	1	24	6z0563.....	613160	CLAMP STUD.....	1
7	640035.....	640035	BUSHING (LEFT).....	1	25	6z0560.....	619320	CLAMP STUD NUT.....	1
8	614815.....	614815	THRUST COLLAR.....	1	26	6z0561.....	610780	CLAMP STUD NUT WASHER.....	1
9	618350.....	618350	THRUST COLLAR SCREW.....	2	28	6z1503.....	616280	LOWER KNIFE HOLDER.....	1
10	615390.....	615390	WASHER.....	1	29	6z2523.....	618340	SCREW.....	1
11	613020.....	613020	BUSHING (RIGHT).....	1	30	6z2904.....	613080	SPRING.....	1
12	620184.....	620184	UPPER KNIFE LEVER.....	1	31	613100.....	613100	SPRING SEAT.....	1
13	6z3266.....	640036	UPPER KNIFE CLAMP MODIFIED.....	1	32	6z2535.....	618740	SPRING SEAT SCREW.....	2
14	6z0793.....	630148	UPPER KNIFE SPACER.....	1	33	6z1135.....	613120	GUIDE.....	1
15	6z2512.....	610100	SCREW.....	2	35	6z2512.....	610100	GUIDE SCREW.....	1
16	6z1930.....	613060	PIN.....	1					

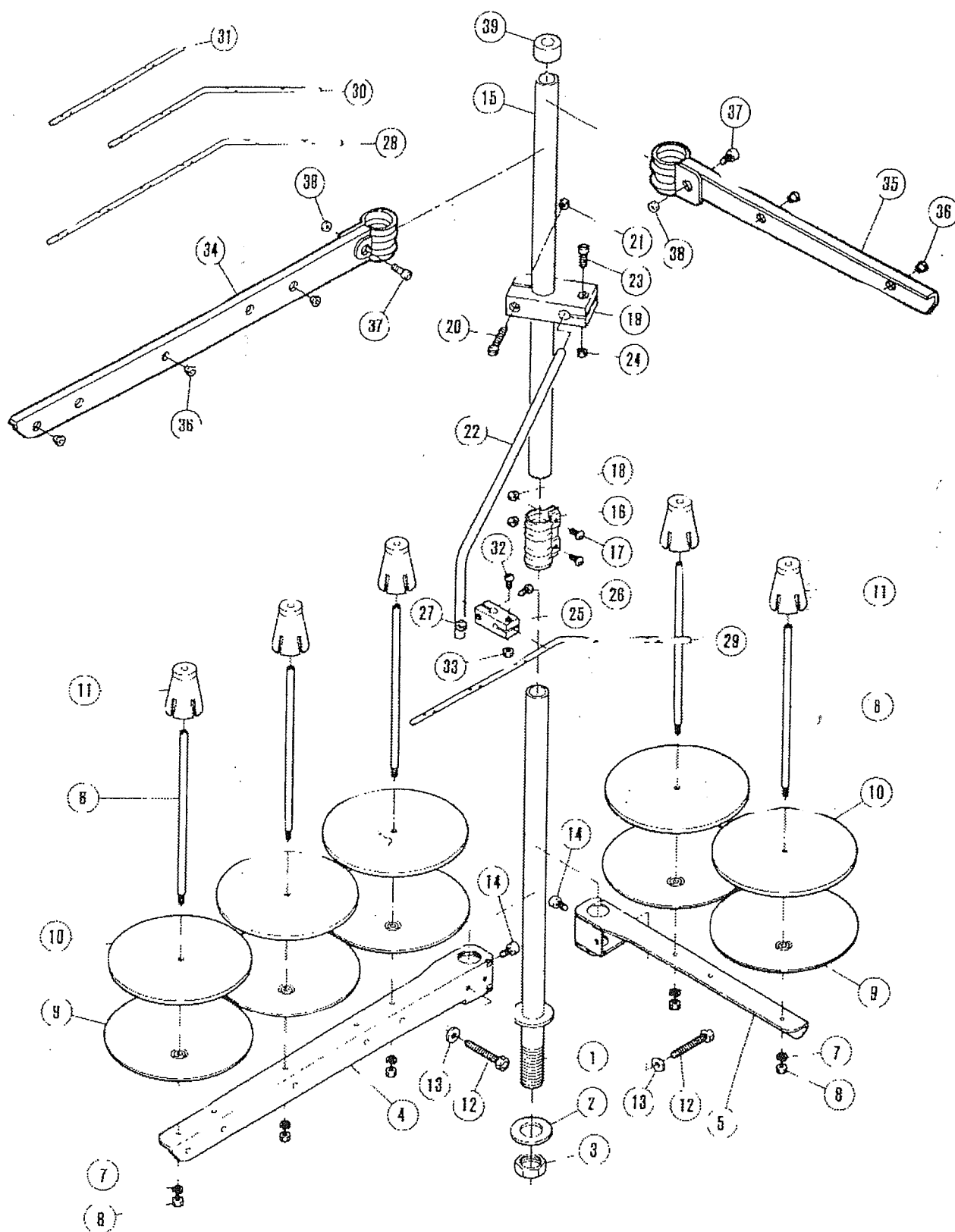
LUBRICATING MECHANISM



LUBRICATING MECHANISM

Ref#	LPCS#	Part#	Description	Qty	Ref#	LPCS#	Part#	Description	Qty
1	6z0743	613440	OIL DISTRIBUTOR	1	34	6z1833	613320	"O" RING	1
2	6z1860	610860	OIL SPLASH SCREW	1	35	6z2536	618900	SCREW	1
4	6z3372	613360	SCREW	1	36	6z2533	618660	SCREW	2
6	6z1859	613460	OIL SPLASH PIPE COMPLETE	1	37	6z2278	620020	INSIDE ROTOR SHAFT	1
7	6z1861	611520	OIL SPLASH SCREW	1	41	6z1850	620024	OUTSIDE ROTOR	1
16	6z1851	615500	OIL RESERVOIR	1	42	620025	620025	ROTOR PLATE	1
17	6z1073	615980	GASKET	1	43	6z2552	619520	SCREW	3
18	6z0057	618840	SCREW	1	44	6z0905	640037	FILTER CLAMP	1
19	6z3340	611660	WASHER	1	45	6z1825	618320	NUT	1
20	6z0375	618960	BOLT	6	46	6z2740	610040	SCREW	1
21	6z3344	614300	WASHER	6	47	6z2564	640039	INSIDE FILTER	1
30	6z1088	613880	GEAR PUMP COMPLETE	1	48	6z0854	640038	OUTSIDE FILTER	1
31	6z3372	613360	WORM WHEEL	1	49	6z3369	613340	WORM GEAR	1
32	6z3149	618460	SCREW	2	50	6z2518	611620	SCREW	1
33	620019	620019	CASING COMPLETE	1					

THREAD STAND

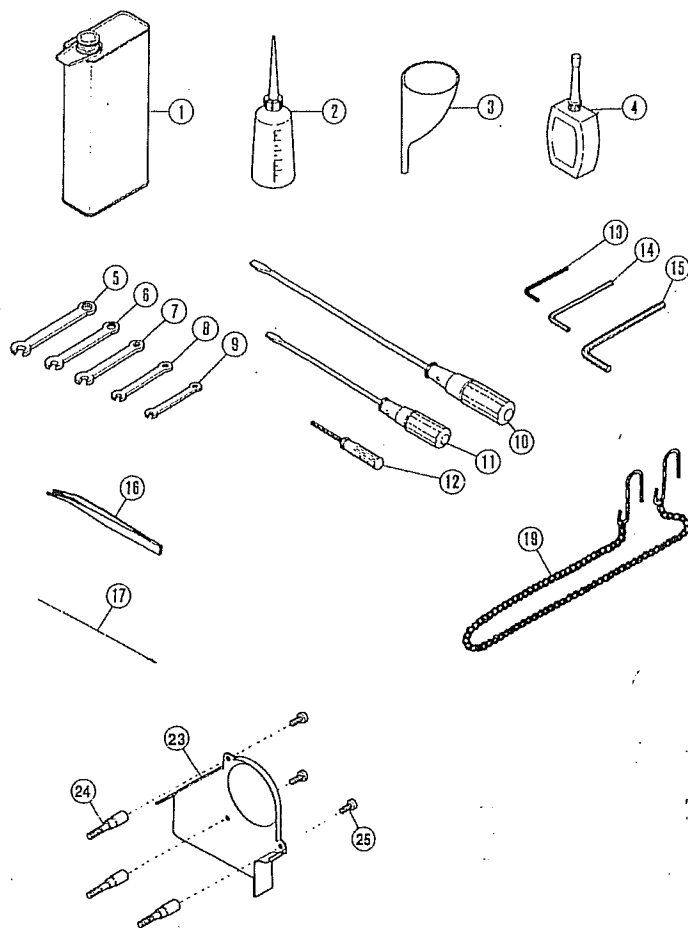


THREAD STAND

Ref#	LPCS#	Part#	Description	3 spool	4 spool	5 spool
1	6z3102	640043	THREAD STAND ROD (LOWER)	1	1	1
2	640044	640044	WASHER	1	1	1
3	640042	640042	NUT	1	1	1
4	6z1899	640058	BRACKET	1		1
5	6z0408	640059	BRACKET		2	1
6	6z2835	640060	SPOOL PIN	3	4	5
7	6z3346	640061	SPRING WASHER	3	4	5
8	6z1828	640053	NUT	3	4	5
9	6z2838	640062	SPOOL TRAY	3	4	5
10	6z1900	640063	CUSHION	3	4	5
11	6z2837	640064	SPOOL RETAINING FIN	3	4	5
12	640065	640065	SCREW	1	2	2
13	6z3347	640066	WASHER	1	2	2
14	6z2574	640067	SCREW	1	2	2
15	640040	640040	THREAD STAND ROD (UPPER)	1	1	1
16	6z3100	640056	JOINT	1	1	1
17	640057	640057	SCREW	2	2	2
18	6z1827	640049	NUT	2	2	2
19	6z2264	640050	BRACKET	1	1	1
20	6z0237	640051	THREAD GUIDE BAR ORD	1	1	1
21	6z2572	640052	SCREW	1	1	1
22	6z1828	640053	NUT	1	1	1
23	6z1214	640054	HOLDER	1	1	1
24	6z2573	640055	SCREW	2	2	2
25	6z1828	640053	NUT	2	2	2
26	6z3074	618240	THREAD GUIDE BAR (5-SPOOLS)			1
27	618241	618241	THREAD GUIDE BAR (4-SPOOLS)			1
28	618242	618242	THREAD GUIDE BAR (3-SPOOLS)		1	
29	6z2573	640055	SCREW	1	1	1
30	6z1828	640053	NUT	1	1	1
31	6z0410	640045	BRACKET	1		
32	6z0406	640046	BRACKET		2	1
33	6z3070	640047	THREAD EYELET	3	4	5
34	6z2571	640048	SCREW	1	2	2
35	6z1827	640049	NUT	1	2	2
36	640041	640041	ROD CAP	1	1	1
*	6z3489	640068	THREAD STAND ASS. (5-SPOOLS)			1
*	6z3476	640069	THREAD STAND ASS. (4-SPOOLS)		1	
*	640070	640070	THREAD STAND ASS. (3-SPOOLS)	1		

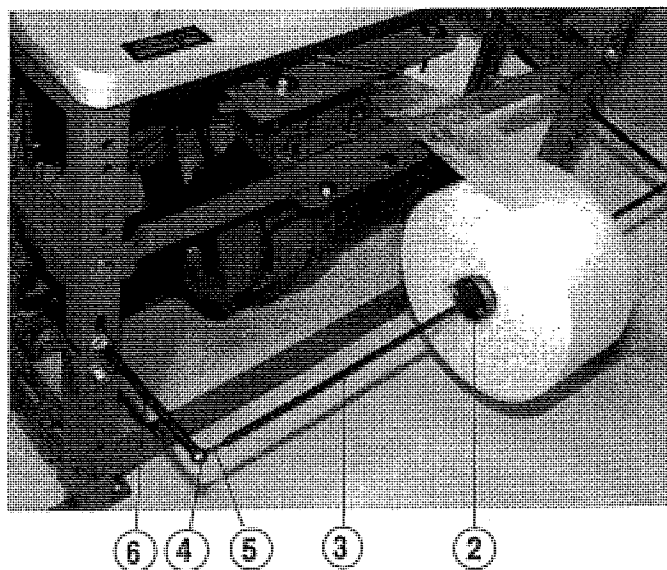
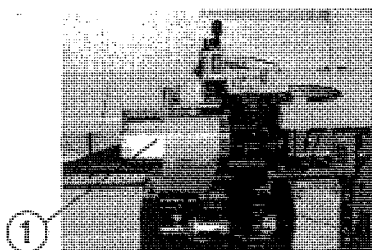
ACCESSORIES

Ref#	LPCS#	Part#	Description	Qty
1	6z1834	610340	OIL CONTAINER	1
2	6z1865	610320	OILER	1
3	6z1846	610380	OIL FUNNEL	1
4	6z3495	610580	LUBRICANT CONTAINER	1
5	6z3525	618080	WRENCH (9.5MM)	1
6	6z3524	618060	WRENCH (8MM)	1
7	6z3517	618040	WRENCH (7MM)	1
8	6z3506	618020	WRENCH (6MM)	1
9	6z3493	618000	WRENCH (5MM)	1
10	6z1313	610260	SCREWDRIVER (LARGE)	1
11	6z1563	610280	SCREWDRIVER (MEDIUM)	1
12	6z0185	610600	ALLEN WRENCH	1
13	6z0186	640071	ALLEN KEY (2.38MM)	1
14	6z3451	610640	ALLEN KEY (3.17MM)	1
15	6z3475	610720	ALLEN KEY (4.76MM)	1
16	6z3239	610300	TWEEZERS	1
17	6z3114	610460	THREADING WIRE	1
19	6z0518	640072	THREADLE CHAIN	1
23	6z0271	614720	BELT GUARD	1
24	6z0964	614740	FIXING SCREW	3
25	6z2535	618740	SCREW	3
26	6z3464	35V	V-BELT (not shown)	1



MISCELLANEOUS STAND PARTS

Ref#	LPCS#	Part#	Description	Qty
1	6z0966	P110	FLANGE FOLDER ASSY.	1
2	6z0644	CB5-1/2	CONE BEARING	2
3	6z0971	1249	SHAFT	1
4	6z3405	6072K21	BALL JOINT	1
5	6z1227	9491T14	HOOK	1
6	6z0972	1248	STANDOFF	2



INDEX

PART#	LPCS#	PAGE	REF#	PART#	LPCS#	PAGE	REF#	PART#	LPCS#	PAGE	REF#	PART#	LPCS#	PAGE	REF#
091	6z0167	17	60	611260	611260	21	8	612700	6z0453	37	23	614500	6z2257	21	4
1248	6z0972	44	6	611460	6z0742	25	6	612720	6z0650	37	22	614520	6z0824	23	28
1249	6z0971	44	3	611460	6z0742	30	28	612730	6z1544	37	13	614540	6z1416	33	13
314360	314360	22	16	611460	6z0742	33	34	612740	6z0731	37	16	614580	6z0228	23	30
610040	6z2740	23	22	611480	6z0512	23	17	612760	6z0860	37	10	614600	6z1043	35	55
610040	6z2740	41	46	611520	6z1861	41	7	612780	6z0857	37	7	614620	6z1533	30	31
610060	6z2510	27	27B	611560	6z0548	29	20	612800	6z0928	35	45	614640	6z0216	29	48
610100	6z2512	23	33	611580	6z1840	23	20	612820	6z0735	35	43	614720	6z0271	44	23
610100	6z2512	29	32	611580	6z1840	29	53	612840	6z1342	35	59	614740	6z0964	44	24
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610100	6z2512	39	15	611600	6z3415	31	7	612880	6z3269	39	1	614760	6z1931	35	5
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640041	640041	43	36	640073	6z 0828	19	54	660042	6z 1388	17	54	SHCS4-40X	6z2753	19	64
640042	640042	43	3	640074	6z 2247	19	31	660043	6z 1316	19	27A	SHCS4-40X	6z2754	17	40
640043	6z 3102	43	1	640075	6z 1324	19	43	660044	6z 1039	19	23A	SHCS4-40X	6z2754	25	30
640044	640044	43	2	650072	6z 2290	22	23	660045	6z 1192	19	60	SHCS5-40X	6z2769	17	20
640045	6z 0410	43	31	660001	6z 3137	25	19	660046	6z 1207	19	61	SHCS6-32X	6z2764	17	45
640046	6z 0406	43	32	660002	6z 3128	25	19A	660047	6z 0146	19	62	SHCS6-32X	6z2771	39	20
640047	6z 3070	43	33	660003	6z 1537	37	17	660048	6z 0840	19	21	SHCS6-32X	6z2774	27	27A
640048	6z 2571	43	34	660004	6z 1495	37	17A	660049	6z 0693	22	5A	SHCS8-32X	6z2755	17	35
640049	6z 1827	43	18	660005	6z 1539	37	14	660050	6z 2271	25	35	SHCS8-32X	6z2756	17	10
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640050	6z 2264	43	19	660007	6z 3210	17	25	660052	660052	27	56	SHCS8-32X	6z2775	23	35
640051	6z 0237	43	20	660008	6z 3195	17	25A	35V	6z 3464	44	26	SHCS8-32X	6z2776	27	54
640052	6z 2572	43	21	660009	6z 2087	17	24	6072K21	6z 3405	44	4	SHCS8-32X	6z2477	17	37
640053	6z 1828	43	8	660010	6z 2088	17	24A	630115 *	6z 1908	27	55	SHCS8-32X	6z2765	17	23
640053	6z 1828	43	22	660016	6z 2032	17	15	9491T14	6z 1227	44	5	SHCS8-32X	6z2778	17	62
640053	6z 1828	43	25	660017	6z 243	17	12					SHCS8-32X	6z2478	17	31
												SLW#8	6z2830	17	69

