

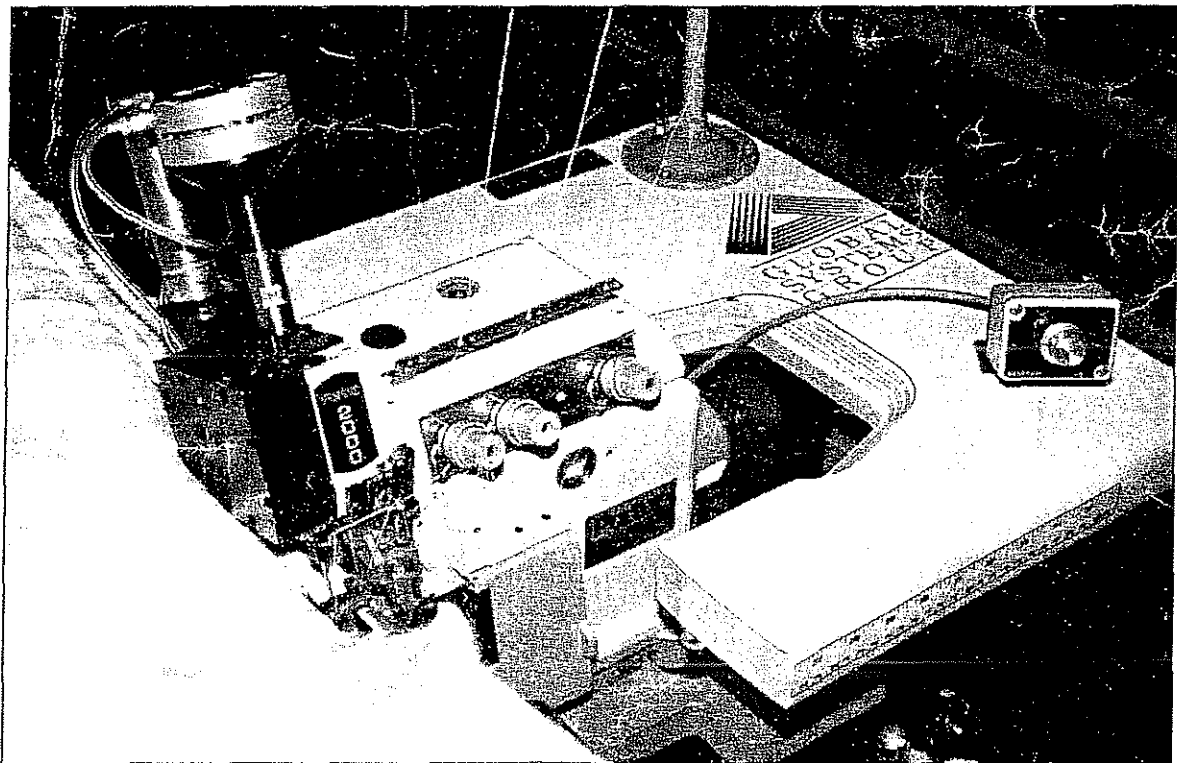
Porter[®]
INTERNATIONAL

A Leggett & Platt Company

Catalog #PFM 2000 6/98



PFM 2000 Flange Machine



INSTRUCTIONS & PARTS MANUAL

ORDERING INFORMATION

TO ORDER BY PHONE:

From Massachusetts 978-922-2611

From out of state 800-343-8138

(Extensions 622 & 633)

TO ORDER BY FAX: 978-922-5839

(Fax & Message Service available 24 hours per day.)

TO ORDER BY MAIL:

**Porter International
97 Rantoul Street
Beverly, MA 01915 USA**

HAVE THIS INFORMATION READY:

1. Machine Model Number
2. Part Number or complete part description
3. Customer Number
4. Person placing order
5. Bill To and Ship To addresses
6. Fax/Phone

PRICES AND TERMS:

All prices are F.O.B. Beverly, MA, and are valid at the time of shipment.

All prices are list, unless otherwise noted.

Open account terms extended to firms with established credit.

Overseas orders must be paid before shipment unless otherwise noted.

SHIPPING:

When ordering parts please state how the shipment is to be made: (UPS Red, Blue, Orange or Ground; Federal Express; air mail).

Freight charges are included on invoice.

If a customer is on C.O.D. status, shipping costs are included in the C.O.D. amount.

TAXES:

Where the law requires, state sales and/or use taxes must be charged.

MINIMUM ORDERS:

Due to the rising costs of handling orders, we have established a minimum order of \$25.00.

RETURNED GOODS:

Porter International has a policy on returned parts which must be strictly adhered to.

1. All customers must call Porter to obtain a RMA (Returned Material Authorization) number. Parts returned without a RMA number will be returned to customer. We will not accept parts returned 60 days after authorization.
2. All parts to be returned must be shipped to Porter prepaid unless otherwise instructed by our Customer Service Department.
3. Credit for parts will be issued upon inspection by Porter and credited against your account.
4. A restocking charge of 15% will be issued on parts ordered incorrectly by the customer, unless otherwise noted.

CLAIMS:

If a parcel post shipment reaches you in damaged condition, advise us *immediately* so that a claim can be filed. All parcel post packages are insured by Porter. If a truck, UPS or express shipment arrives damaged, request the driver to make a notation on the freight bill. If the damage was concealed at the time of delivery, call the carrier for an inspection and obtain a DAMAGE REPORT. This is necessary in order to file a claim. In the case of truck lines, customer must file the claim. We will give any needed assistance, but the carrier is responsible for the safe arrival of goods.

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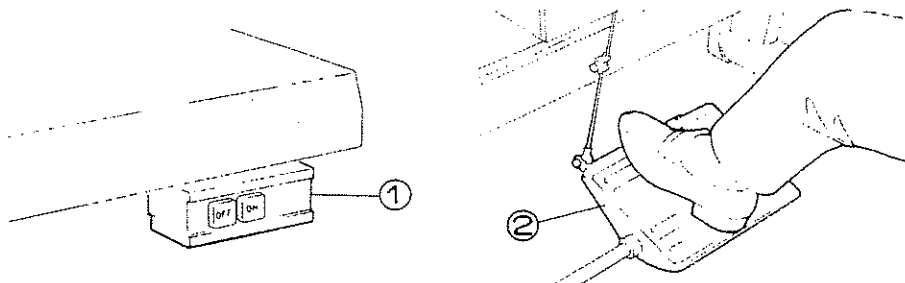
INSTRUCTIONS

CAUTION

OBSERVE THESE SAFETY PRECAUTIONS

- To prevent accidents, do not remove safety devices or parts while operating the machine.
- Do not leave tools or other unnecessary objects on the machine table while operating the machine.
- Before maintenance, adjusting, cleaning, threading or replacing the needle, and to prevent accidents, be sure the power is turned off. Check that the machine will not operate when the pedal is pressed.

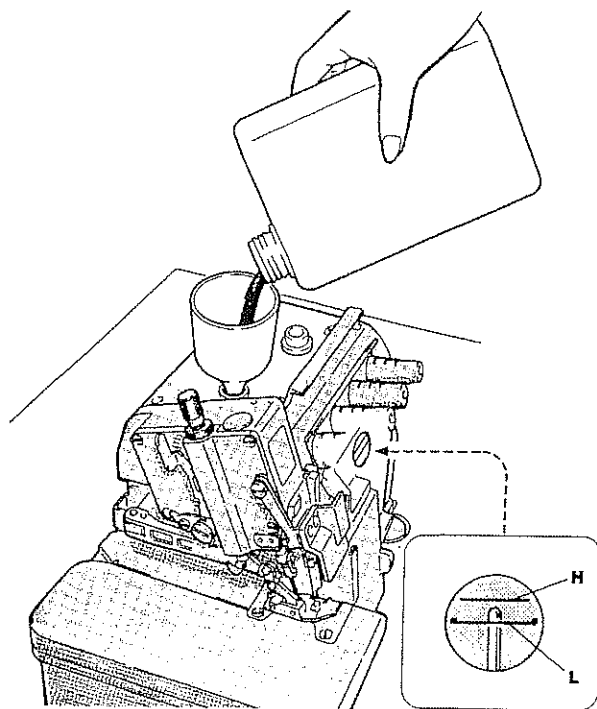
NOTE:



In case a clutch type motor is used, it will keep on rotating by inertia after turning off power supply (1). If the machine pedal (2) is stepped on inadvertently, it is dangerous because the machine will move unexpectedly. Keep on stepping on the pedal (2) until the machine comes to a stop after turning off power supply.

- Turn the power off before leaving the machine table.
- In the event of a power failure, be sure to turn the machine off.
- Check that the machine is securely grounded.

LUBRICATION

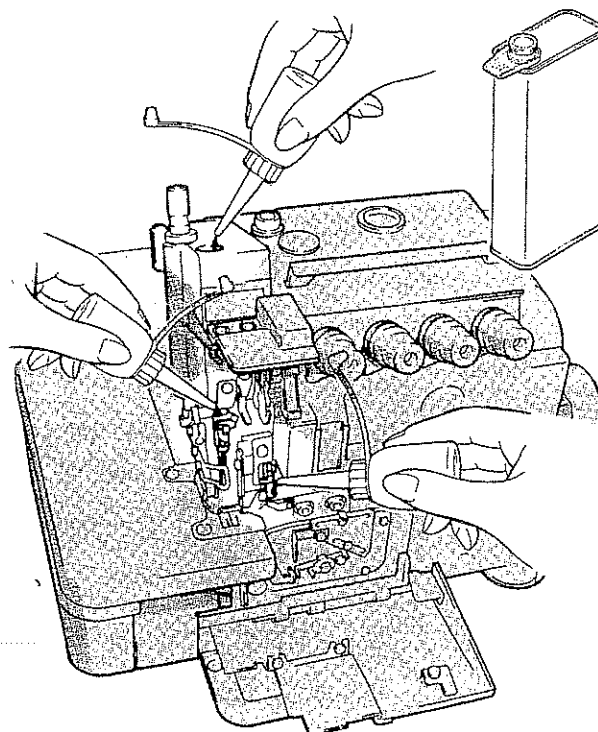


LUBRICATION

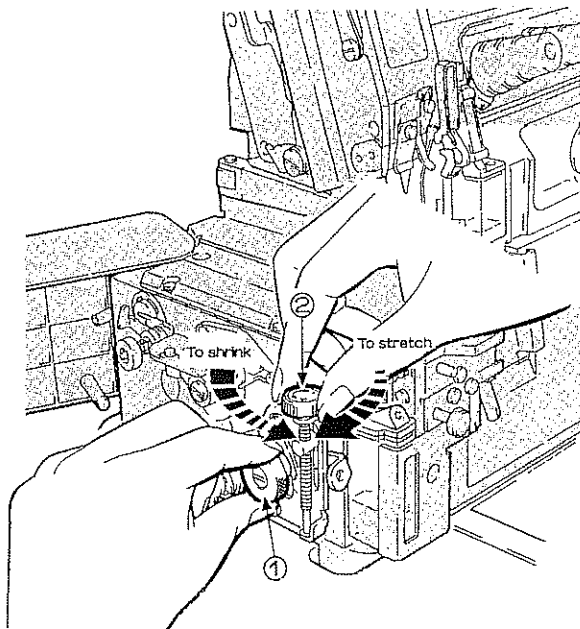
After filling the oil pan, the top of the indicator should lie between the (H) and (L) lines.

MANUAL LUBRICATION

Apply 2 or 3 drops of oil by hand when the machine is used for the first time, or has been left unused for some time.



FEED ADJUSTMENT



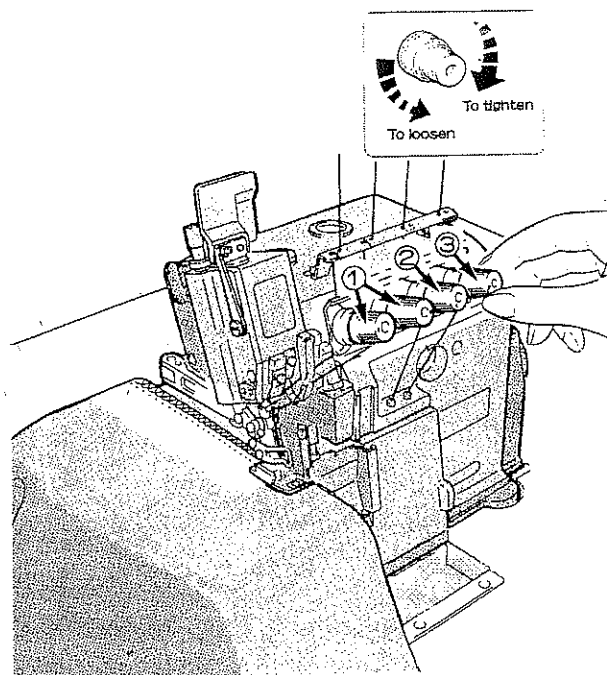
FEED ADJUSTMENT

Loosen the adjusting nut (1) and turn the adjusting nut (2) to adjust the differential feed ratio.

THREAD TENSION

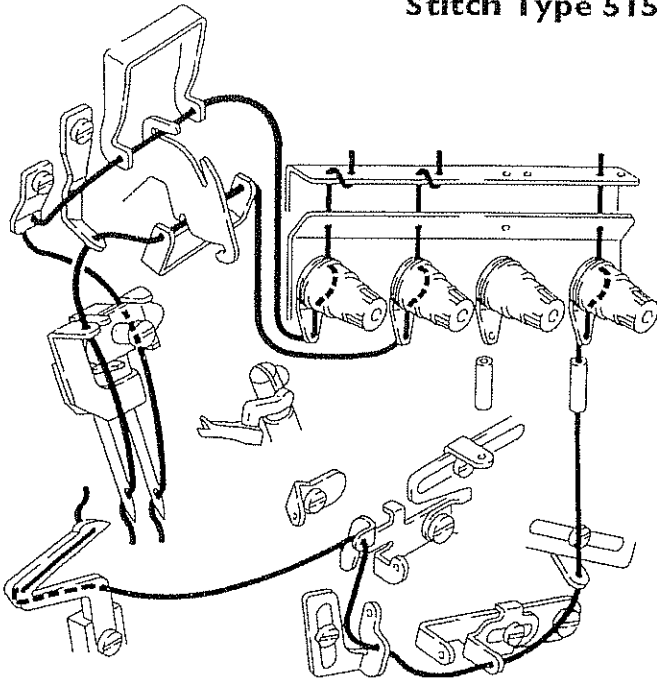
THREAD TENSION

Make tension adjustments with the needle thread knob (1), the upper looper knob (2) and the lower looper knob (3).

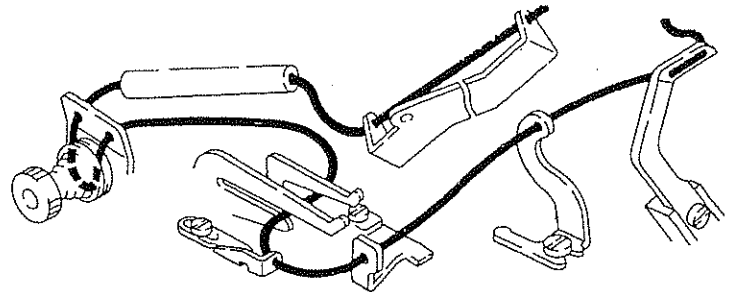


THREADING

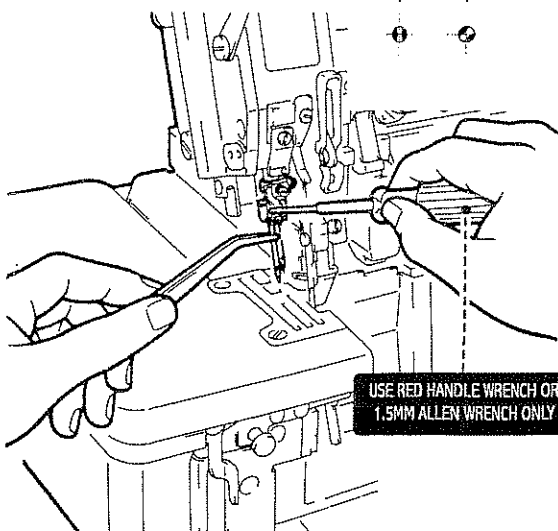
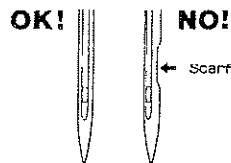
Stitch Type 515



Stitch Type 401



REPLACING THE NEEDLE



USE RED HANDLE WRENCH OR
1.5MM ALLEN WRENCH ONLY

← 730346

REPLACING THE NEEDLE

- Check the needle carefully to see that the scarf is turned to the rear of the machine.
- Insert the needle to the proper depth, and fasten securely.

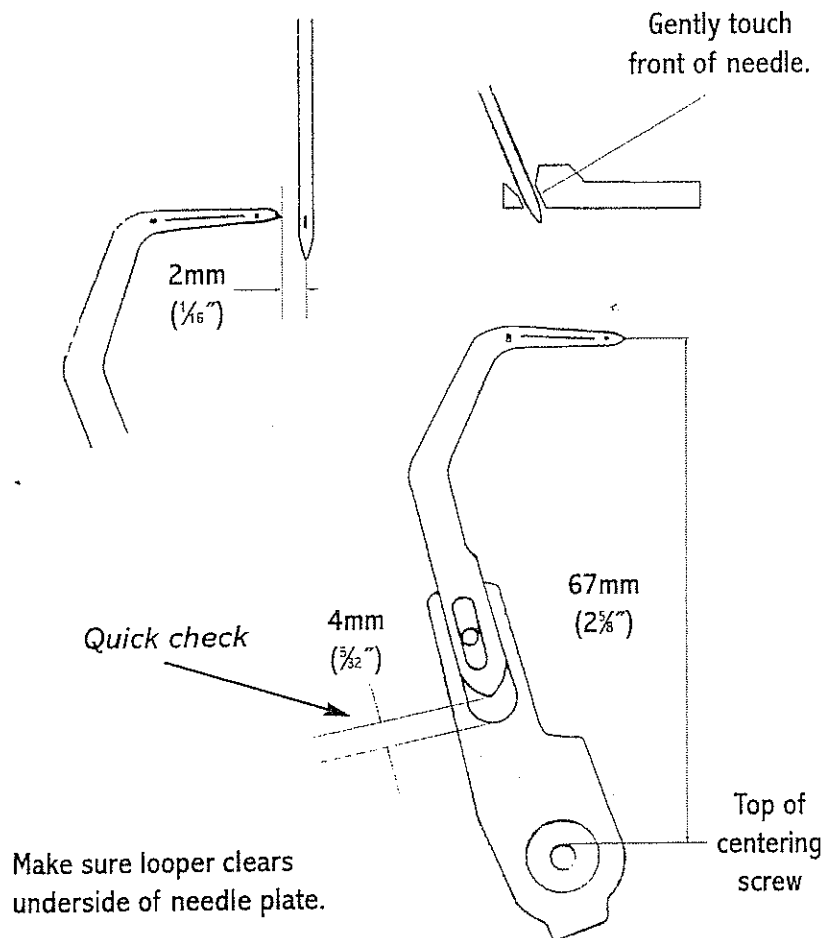
Standard needle: PSM-1170 = 16X257 #24

Note: Do not remove the screw.

TIMING ADJUSTMENTS

NEEDLE HEIGHT TO PLATE 14MM

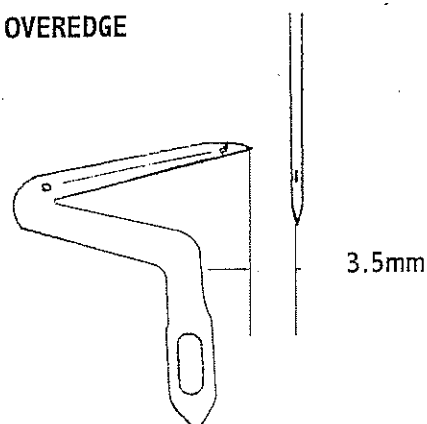
SETTING SAFETY STITCH (401)



SPREADER AT EXTREME LEFT



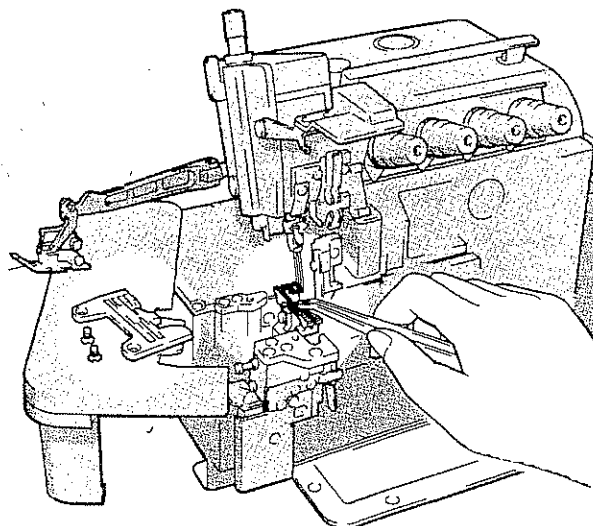
OVEREDGE



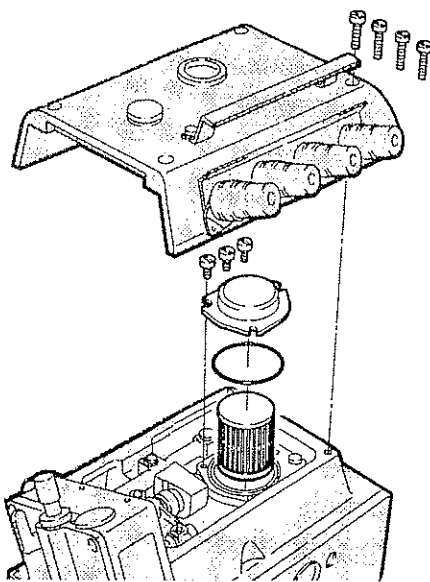
CLEANING

CLEANING THE MACHINE

Mainly the slots of the needle plate and the feed rows should be cleaned.



MAINTENANCE

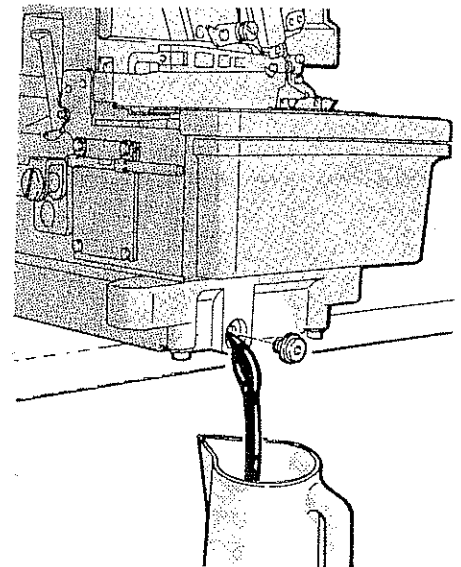


CHECKING AND REPLACING THE OIL FILTER

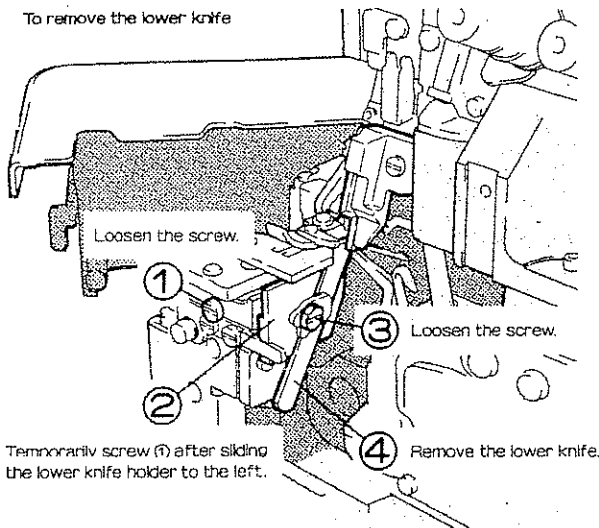
Check and replace the oil filter every 6 months.

REPLACING THE OIL

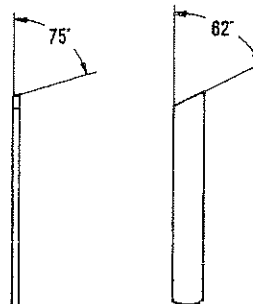
Replace the oil 1 month after the first use and every 6 month thereafter.
(See pg.5)



To remove the lower knife

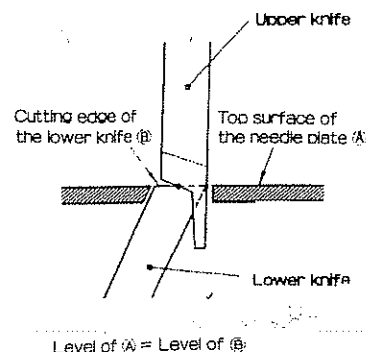
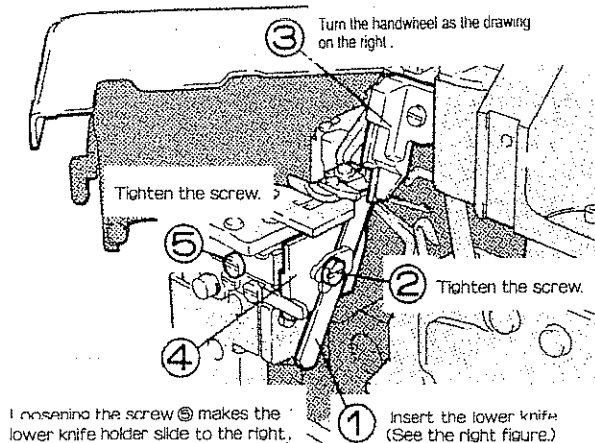


Correct angles to resharpen the lower knife



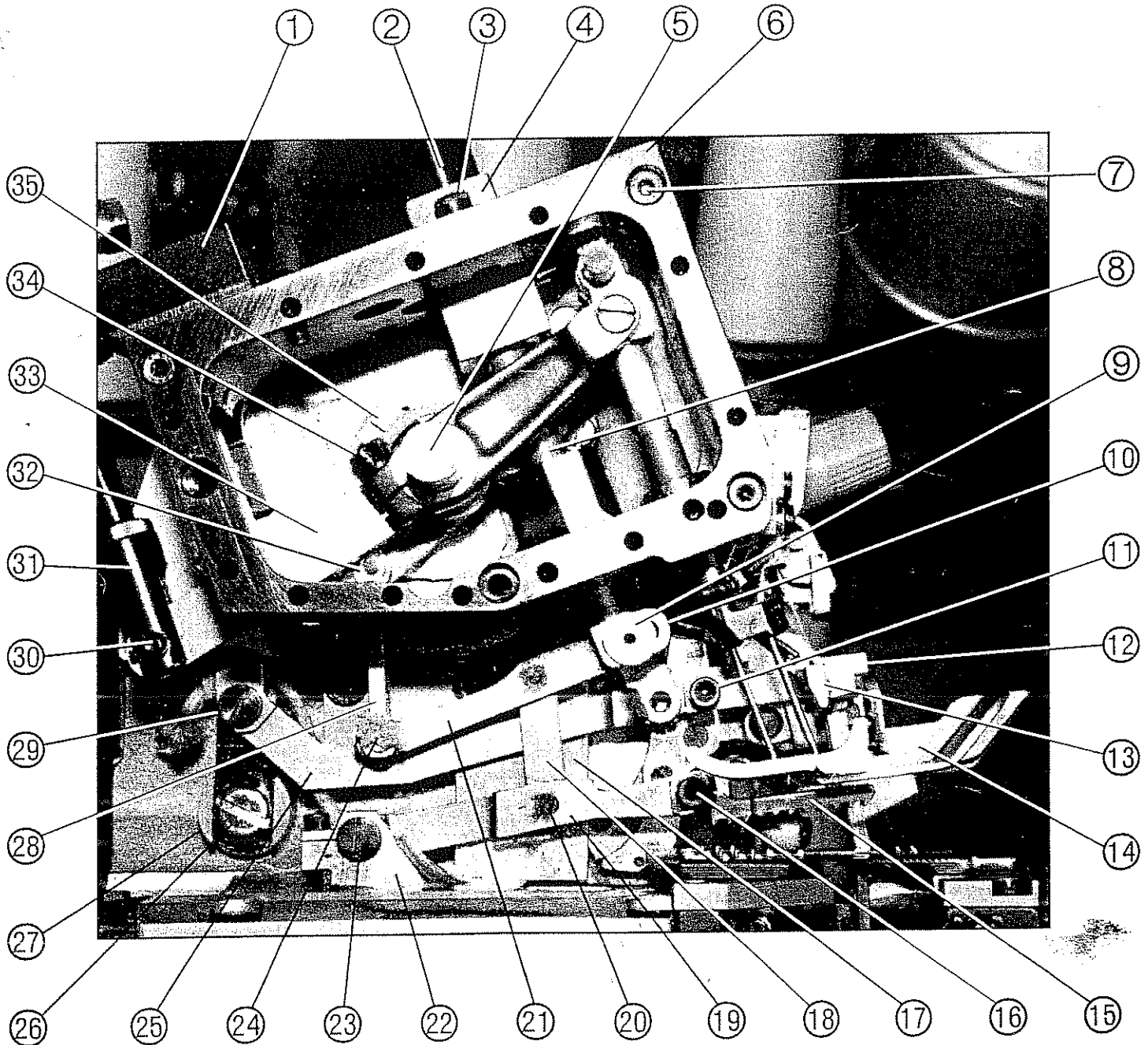
KNIVES

To replace the lower knife



Check cutting action of knives.

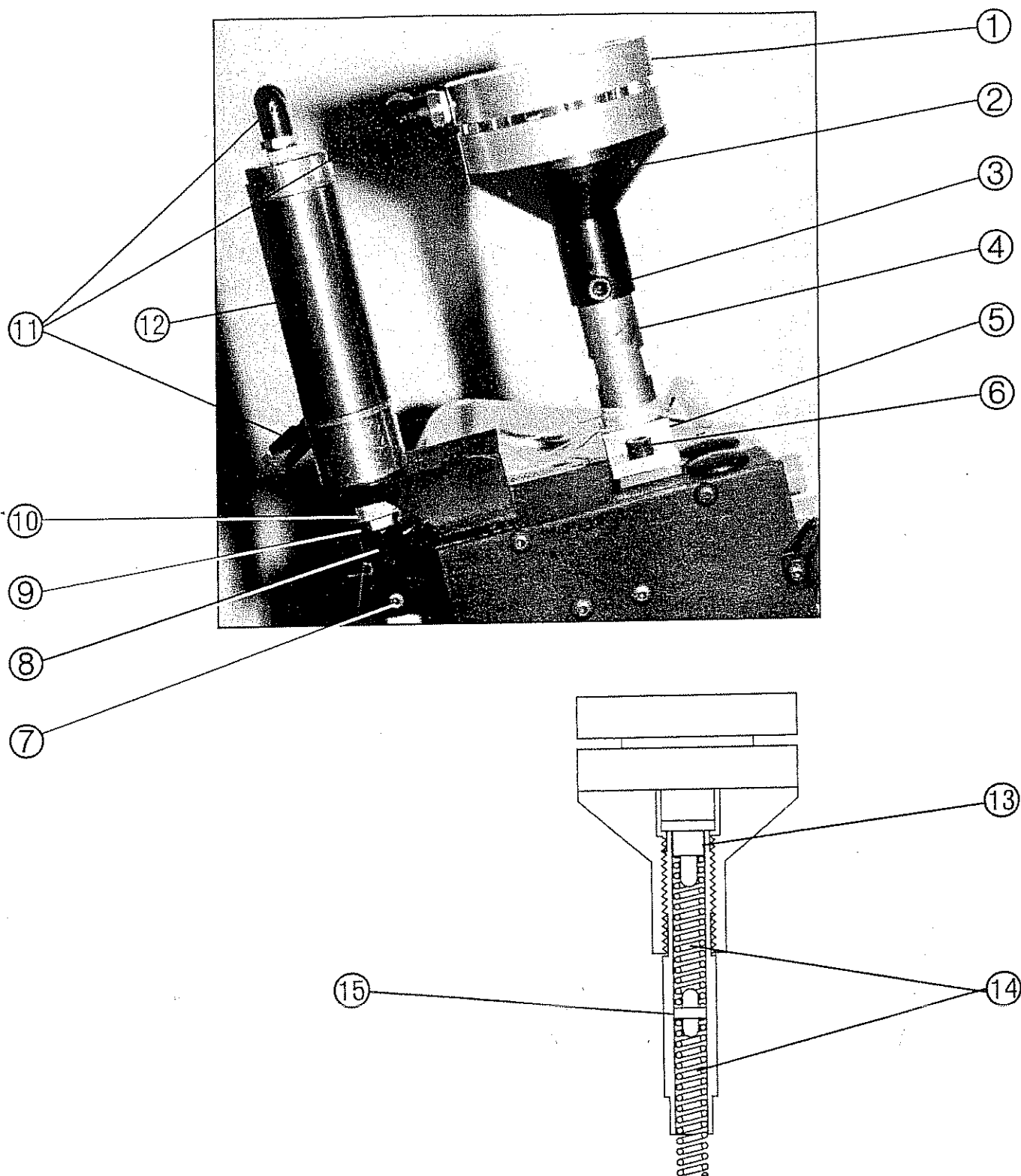
WALKING FOOT MECHANISM



WALKING FOOT MECHANISM

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1.....	800440	BRACKET CYCLINDER LIFT.....	1	19	801449	TOP FEED BEAM.....	1
2.....	801447	PRESSURE SPRING SLEEVE.....	1	20	660055	PIVOT PINS.....	2
3.....	SHCS10-32X3/8SHCS...	SCREW 10-32-X3/8.....	2	✓21	801444	TOP BEAM.....	1
4.....	801447	PRESSURE SLEEVE BASE.....	1	22	801279	TOP FEED HOLDER.....	1
5.....	801356	NEEDLE DRIVE SHIFT.....	1	23	630155	ECCENTRIC PIN.....	1
6.....	801439	HOUSING.....	1	24	620175	PIVOT PIN.....	1
7.....	SHCSM4X25.....	SHCS SCREWS M4X25.....	4	25	801379	PRESSER FOOT BEAM.....	1
8.....	801257	PRESSER BAR.....	1	26	BHCS1/4-28X5/8	BUTTON HEAD CAP SCREW 1/4-28X5/8...	1
✓9.....	800439	LIFTER PIN.....	1	27	801026	LOCATING STUD.....	1
10	801254	PRESSER BAR EXTENSION.....	1	✓28	801203	BEAM CONNECTOR LINK.....	1
11	SHCS8-32X1/2	SHCS SCREW 8-32X1/2.....	1	29	620134	ECCENTRIC STUD.....	1
12	SHCS-32X5/16	SHCS SCREW 8-32X5/6.....	1	30	660031	PIN.....	1
13	800959	PRESSER FOOT EXTENSION.....	1	31	660030	YOKE.....	1
14	801442	PRESSER FOOT.....	1	32	630138	CONNECTING LINK PIVOT PIN.....	1
15	660008	TOP FEED.....	1	33	801438	AUXILLART LIFTER.....	1
16	SHCS-32X1/2.....	SHCS SCREW 8-32X1/2.....	1	34	SCHS10-32X1/2SHCS	SCREW 10-32X1/2.....	1
17	800965	INSIDE GUIDE PLATE.....	1	35	801126	WALKING FOOT DRIVE CRANK.....	1
18	801478	CONNECTING LINK.....	1				

PRESSURE MECHANISM

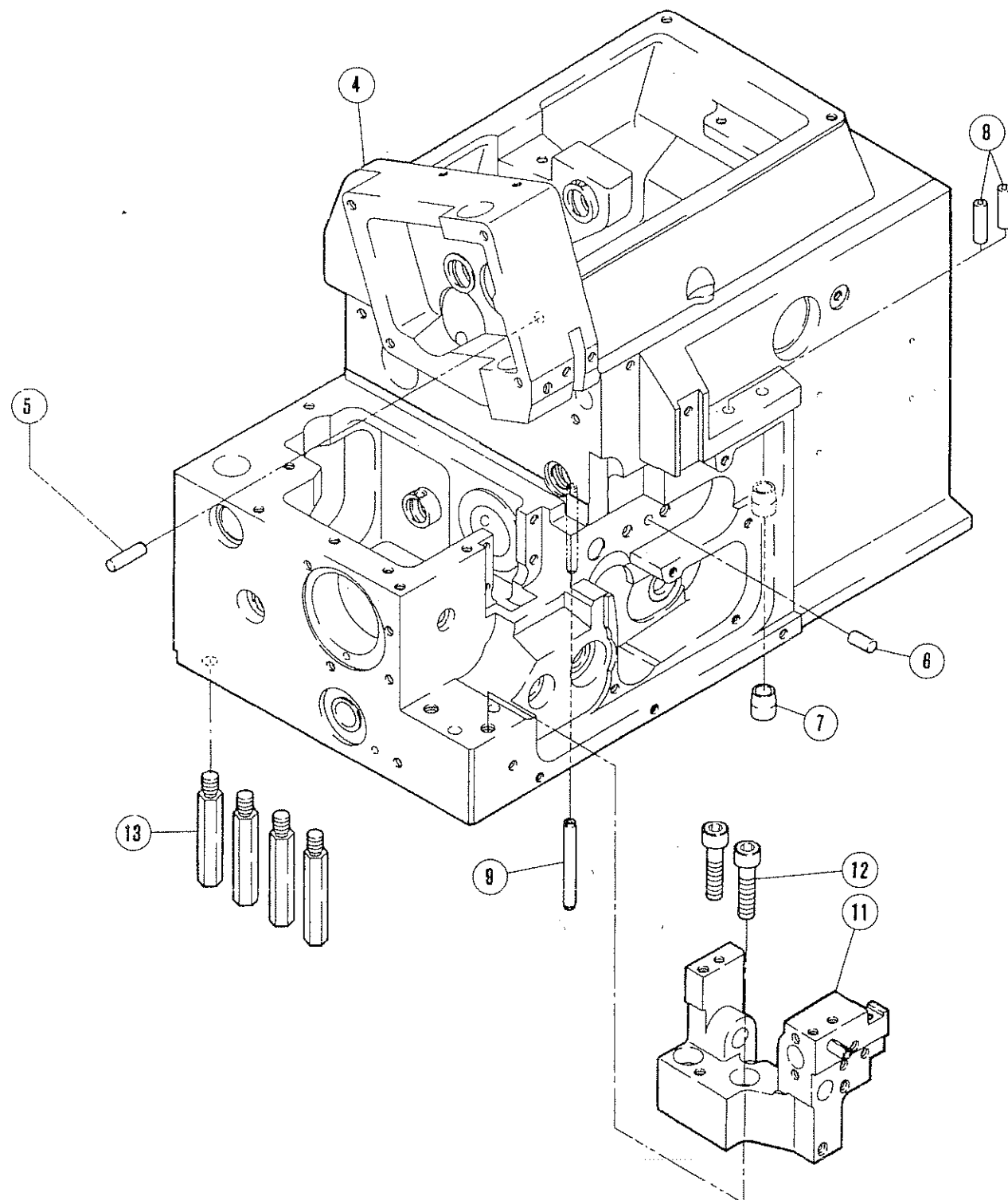


PRESSURE MECHANISM

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1	4001010	AIR CYLINDER	1	9	JN 5/16-24	JAM NUT	1
2	801454	PRESSURE CYLINDER MOUNT	1	10	660033	HEX NUT	1
3	SHCS10-32X1/2	SCREW	1	11	KQLO3-345	AIR FITTING	3
4	801447	PRESSURE SPRING SLEEVE	1	12	091.5-D	AIR CYLINDER	1
5	801448	PRESSURE SPRING SLEEVE HOLDER	1	13	801455	PRELOAD	1
6	SHCS 10-32X3/8	SCREW	2	14	630312	2" SPRING	2
7	660031	YOKE PIN	1	15	801380	SPACER	1
8	660030	YOKE	1				

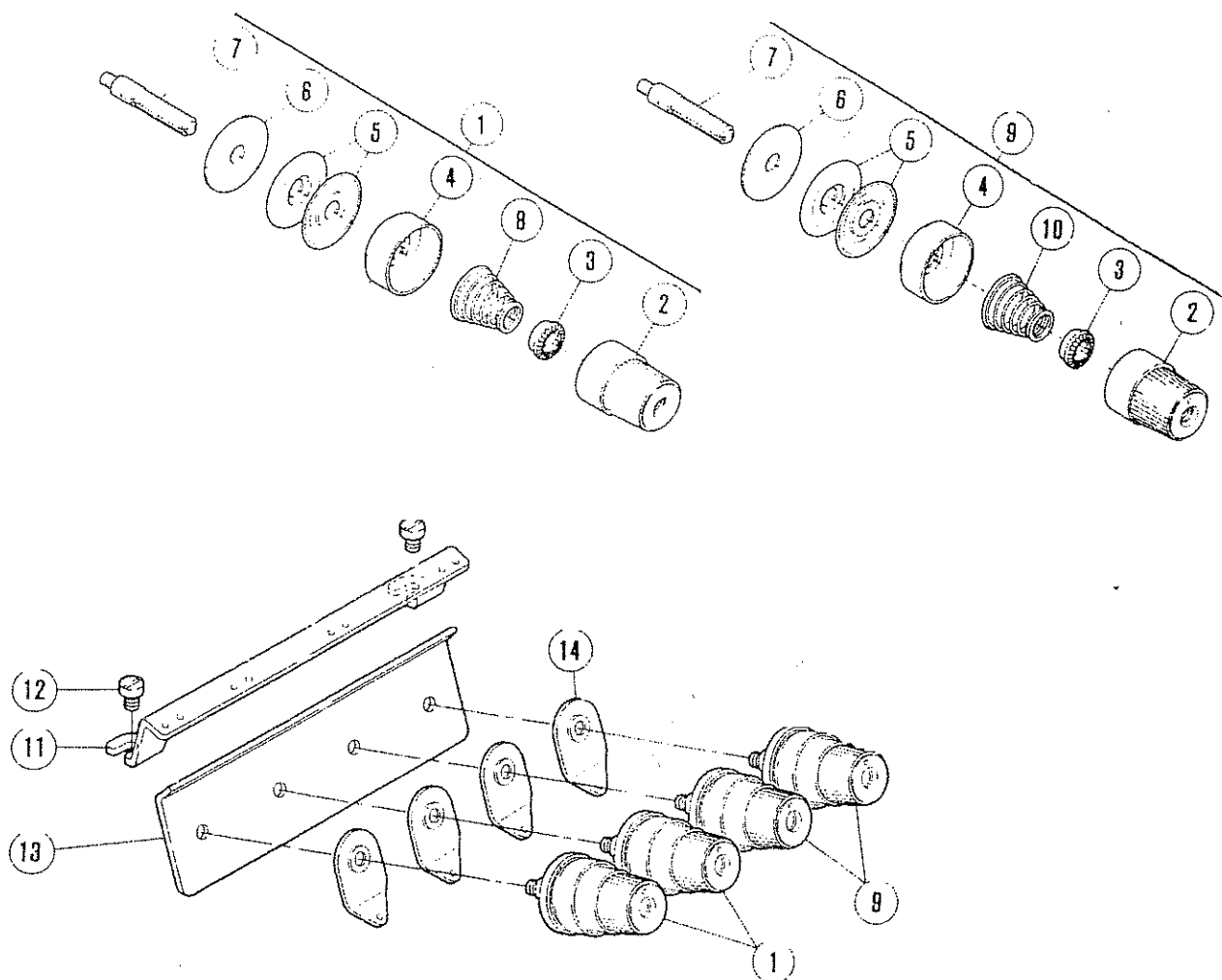
MACHINE BED FRAME

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
4	660280	MACHINE BED COMPLETE	1	9	660276	PLUG	1
5	660279	ROD	1	11	800926	THROAT PLATE/KN. CASTING	1
6	660274	PIN	1	12	660123	SCREW	2
7	660275	INDICATOR GUIDE	1	13	660278	BED PIN	4
8	660277	PIPE	2				

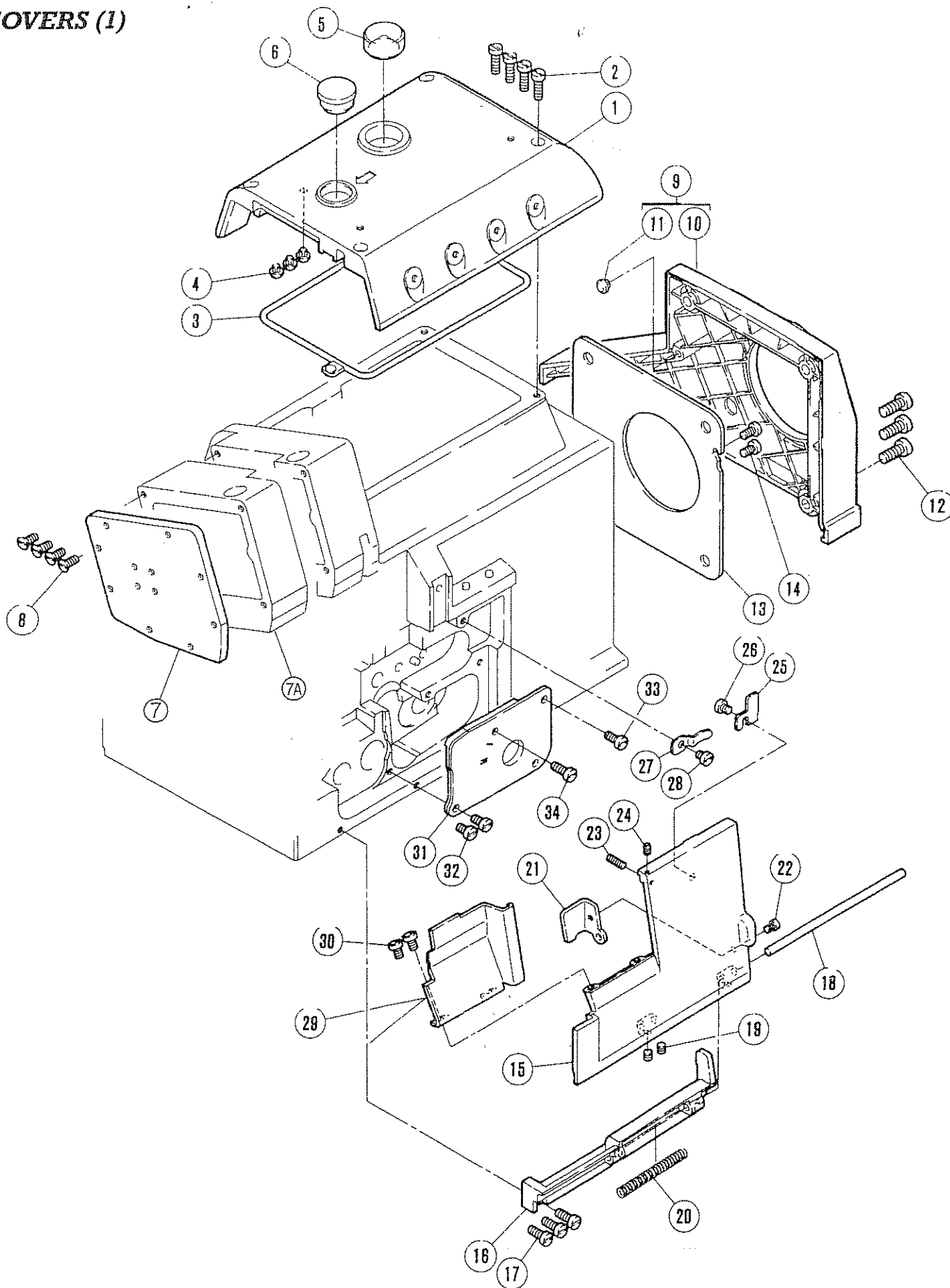


THREAD TENSION MECHANISM

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1	730056	THREAD TENSION COMPLETE	1	11	730058	THREAD EYELET	1
2	616680	POST NUT	1	12	660082	SCREW	1
3	616700	SPRING BUSHING	1	13	730059	THREAD EYELET	1
4	616740	CUP	1	14	730095	TENSION GUIDE	1
5	730061	TENSION DISC	2	15	660098	SCREW	1
6	616720	FELT	1	16	730060	THREAD EYELET	1
7	618560	SCREW STUD	1	17	660082	SCREW	1
8	611040	SPRING (HEAVY)	1	18	730062	THREAD EYELET	1
9	730057	THREAD TENSION COMPLETE	1	19	618280	NUT	1
10	611180	SPRING (MEDIUM)	1				



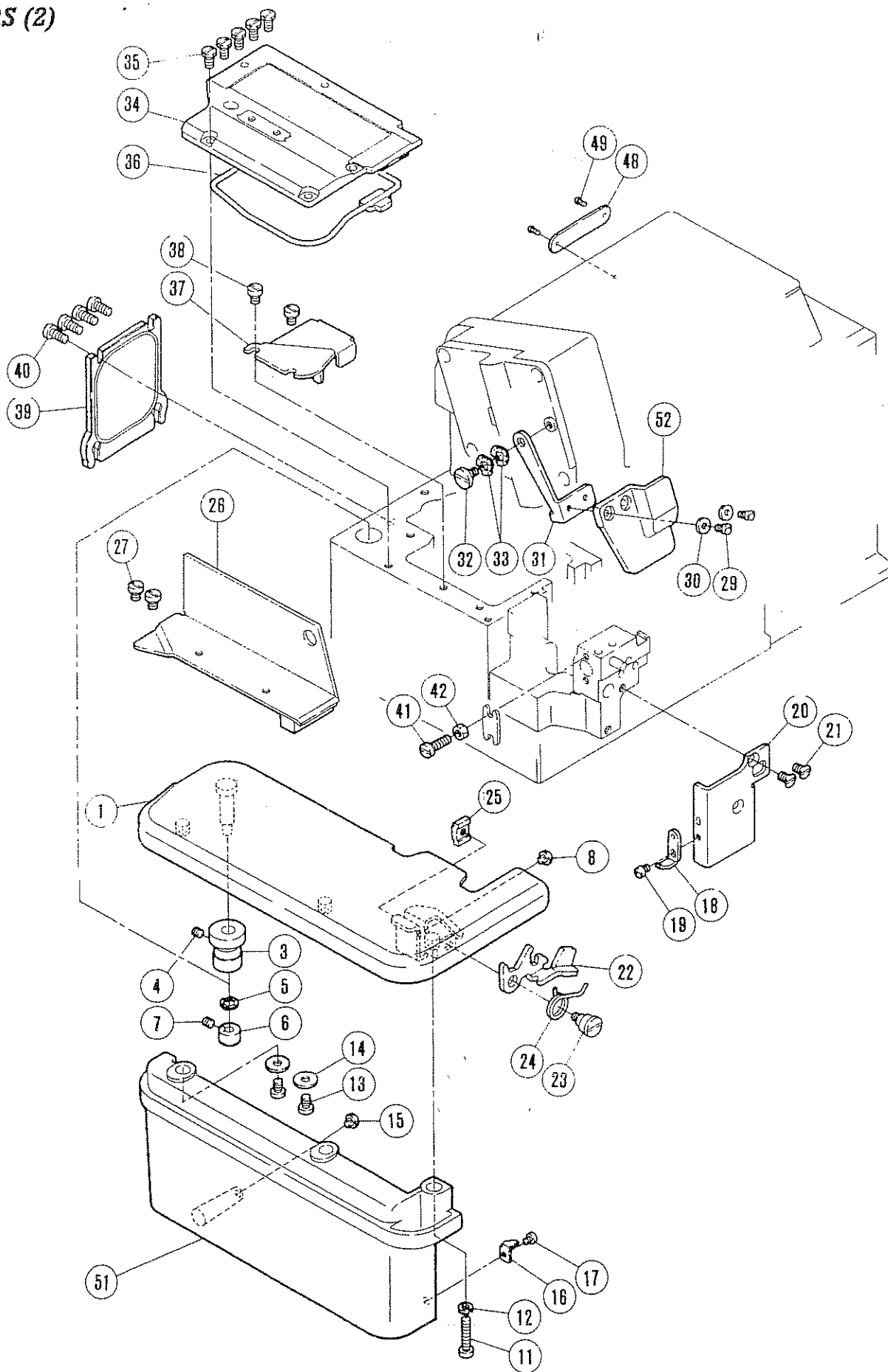
COVERS (1)



COVERS (1)

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1	730000	TOP COVER	1	18	730032	PIN	1
2	660072	SCREW	4	19	660077	SCREW	2
3	730001	GASKET	1	20	730033	SPRING	1
4	730030	CUSHION RUBBER	3	21	730008	LATCH	1
5	730045	OIL SIGHT WINDOW	1	22	660078	SCREW	1
6	730031	PLUG	1	23	660079	SCREW	1
7	801443	SIDE COVER	1	24	660080	SCREW	1
7A	801276	HOUSING	1	25	730009	LATCH	1
8	660074	SCREW	2	26	660081	SCREW	1
9	730003	BELT COVER ASSEMBLY	1	27	730050	FLAT SPRING	1
10	730004	BELT COVER	1	28	660081	SCREW	1
11	730030	CUSHION RUBBER	1	29	730034	FRONT COVER LEFT	1
12	660075	SCREW	3	30	660082	SCREW	2
13	730005	FAN COVER	1	31	730010	COVER	1
14	660076	SCREW	2	32	660076	SCREW	2
15	730006	FRONT COVER	1	33	660083	SCREW	1
16	730007	HINGE	1	34	660069	SCREW	1
17	660069	SCREW	3	35	801451	BEARING BLOCK (NOT SHOWN)	1

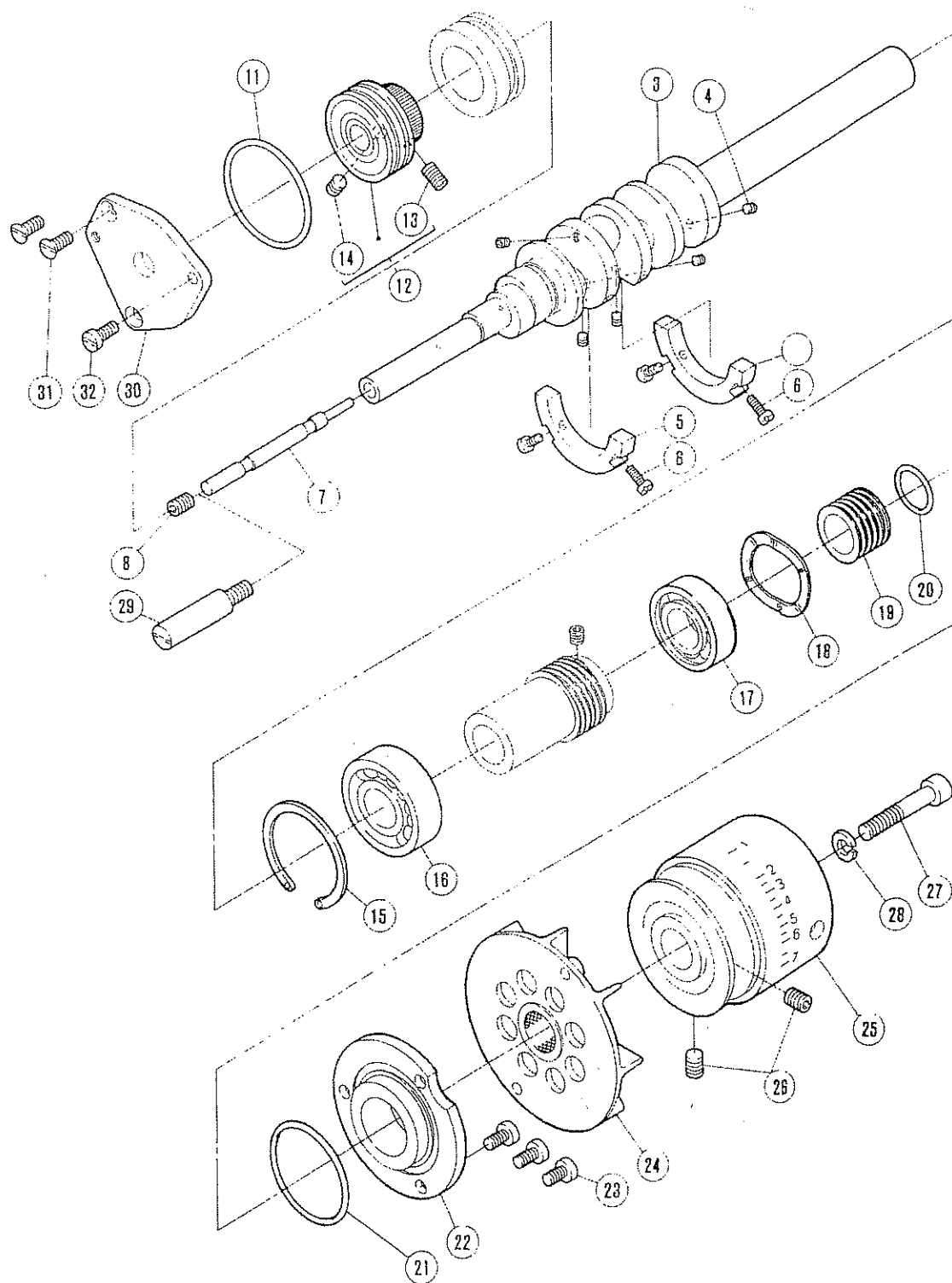
COVERS (2)



COVERS (2)

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1	801546	CLOTH PLATE	1	25	730017	BRACKET	1
3	730012	BUSHING	1	26	801450	FABRIC GUARD	1
4	660077	SCREW	1	27	FHSCS4X10mm	SCREW	2
5	730051	WASHER	1	29	660088	SCREW	2
6	730035	COLLAR	1	30	611960	WASHER	2
7	660077	SCREW	1	31	730019	BRACKET	1
8	730030	CUSHION RUBBER	1	32	660089	SCREW	1
11	660084	SCREW	1	33	730051	WASHER	2
12	640005	SPRING WASHER	1	34	730020	BED COVERPLATE ASSY	1
13	660082	SCREW	2	35	660073	SCREW	5
14	730036	WASHER	2	36	730020	GASKET	1
15	730030	CUSHION RUBBER	1	37	730021	COVER/FEED ECCENTRIC	1
16	730013	LATCH	1	38	660082	SCREW	2
17	660085	SCREW	1	39	730026	COVER PLATE	1
18	730014	LATCH	1	40	660083	SCREW	4
19	660086	SCREW	1	41	660091	SCREW	1
20	730011	PLATE	1	42	660099	NUT	1
21	660087	SCREW	2	48	730055	SERIAL NUMBER PLATE	1
22	730015	LEVER	1	49	730052	PIN	2
23	660090	SCREW	1	51	730023	SIDE COVER	1
24	730016	SPRING	1	52	730024	EYE GUARD	1

CRANKSHAFT DRIVE MECHANISM

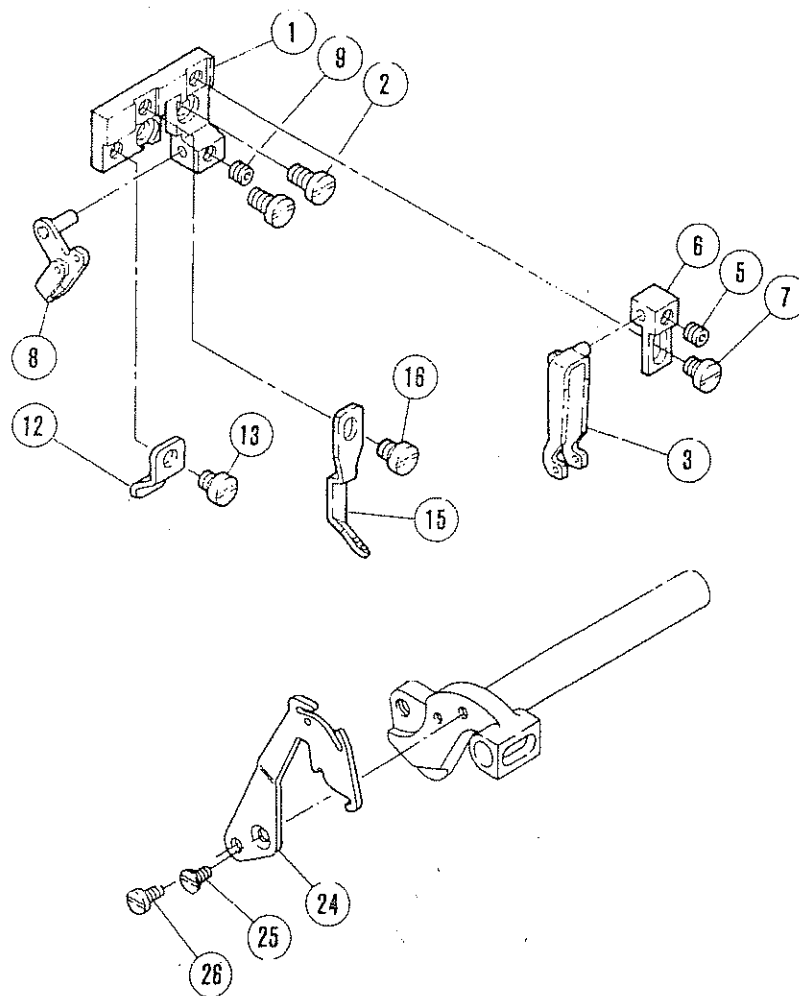


CRANKSHAFT DRIVE MECHANISM

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
3	730027	CRANKSHAFT	1	19	730049	OIL SEAL	1
4	660092	SCREW	5	20	730048	O-RING	1
5	730028	BALANCE WEIGHT	2	21	730038	O-RING	1
6	660093	SCREW	4	22	730053	BALL BEARING RETAINER	1
7	730029	PIN	1	23	660083	SCREW	3
8	660094	SCREW	1	24	730042	FAN COMPLETE	1
11	730038	O-RING	1	25	730043	MACHINE PULLEY	1
12	730039	BALL BEARING COMPLETE	1	26	660094	SCREW	2
13	660095	SCREW	2	27	660097	BOLT	1
14	660096	SCREW	1	28	613640	SPRING WASHER	1
15	730040	RING	1	29	730044	PIN	1
16	730046	BALL BEARING	1	30	730054	COVER	1
17	730047	BALL BEARING	1	31	660074	SCREW	2
18	730041	WASHER	1	32	660083	SCREW	1

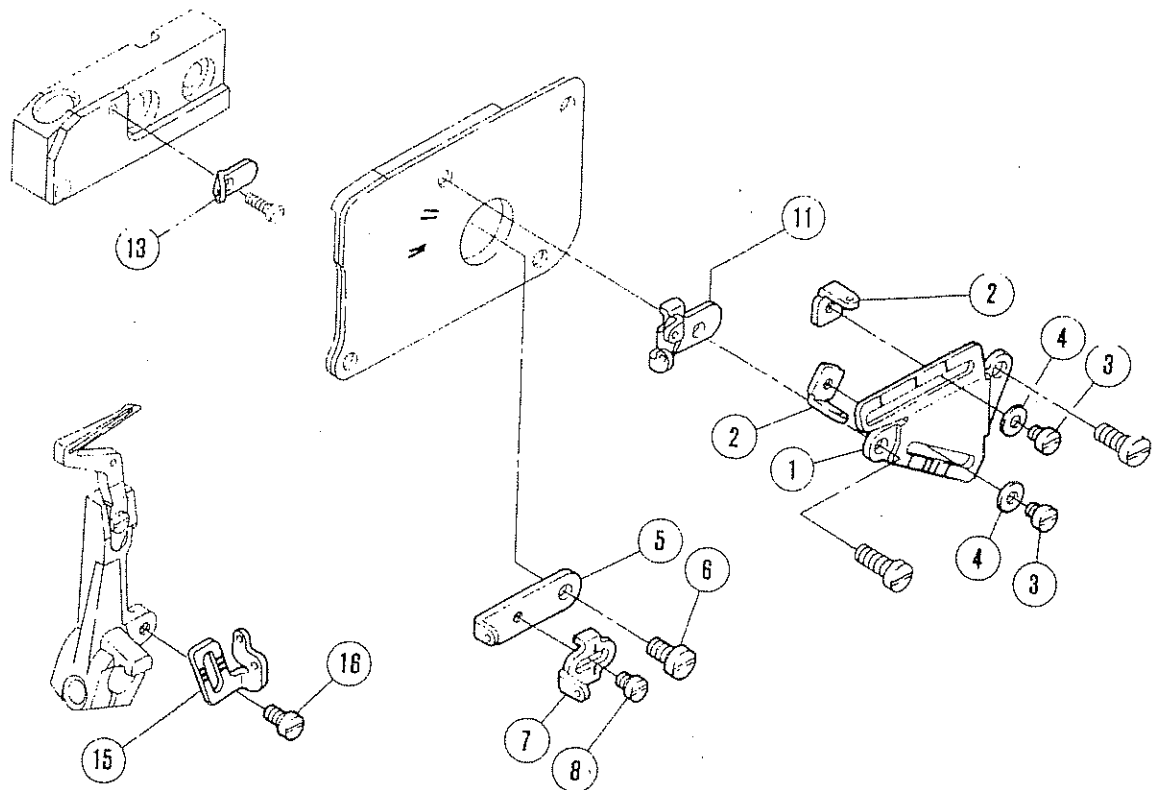
THREAD GUIDE & THREAD TAKEUP (1)

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1	730063	BRACKET	1	12	730067	THREAD EYELET	1
2	660100	SCREW	2	13	660081	SCREW	1
3	730064	THREAD GUIDE	1	15	730068	THREAD EYELET	1
5	660077	SCREW	1	16	660081	SCREW	1
6	730065	BRACKET	1	24	730071	THREAD TAKEUP	1
7	660081	SCREW	1	25	660102	SCREW	1
8	730066	THREAD GUIDE	1	26	660103	SCREW	1
9	660077	SCREW	1				

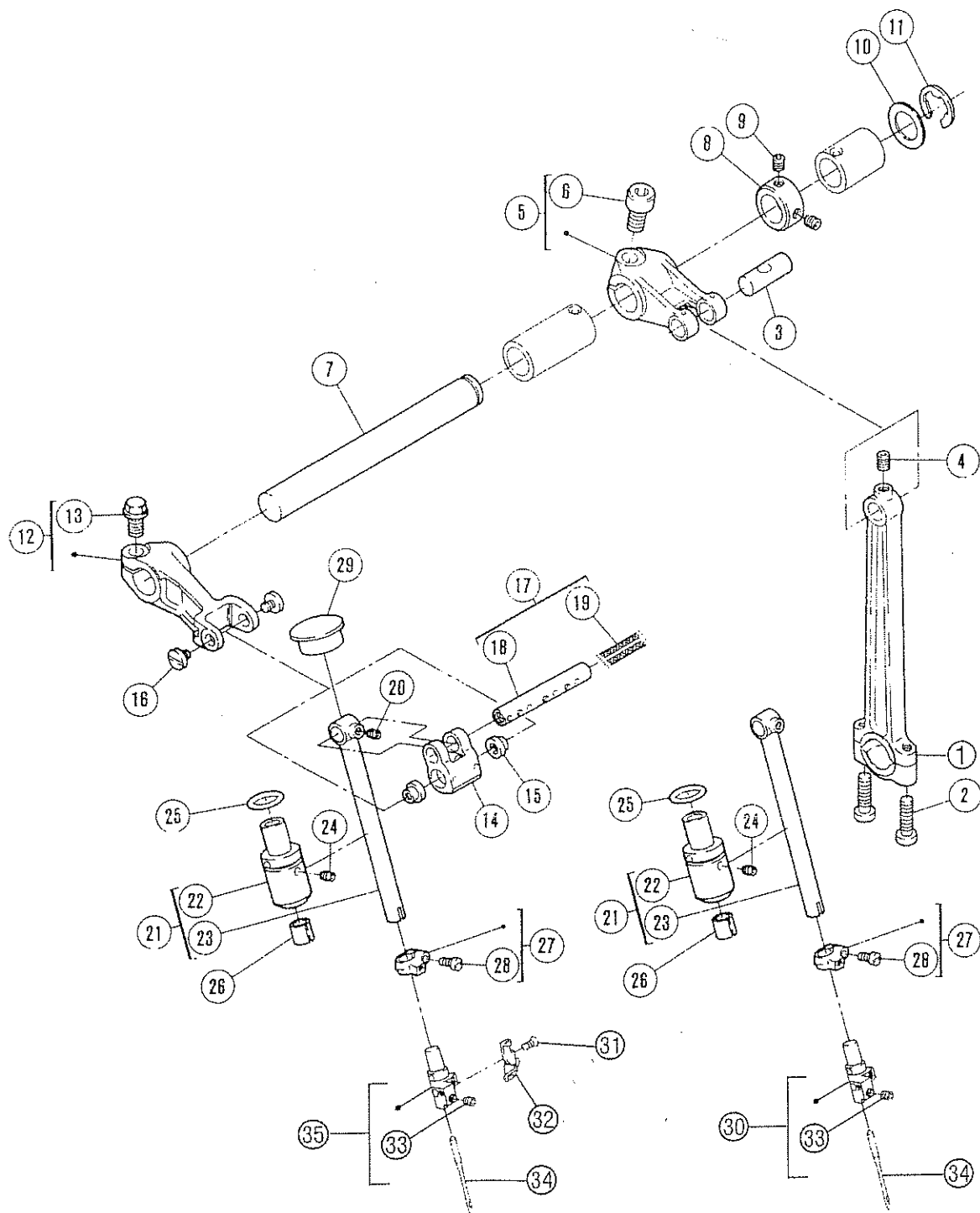


THREAD GUIDE & THREAD TAKEUP (2)

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1	730072	BRACKET	1	7	730074	THREAD EYELET	1
2	730075	THREAD GUIDE (RIGHT)	2	8	660085	SCREW	1
3	660085	SCREW	2	11	730076	THREAD EYELET	1
4	611960	WASHER	2	13	730077	THREAD EYELET	1
5	730073	THREAD TAKEUP	1	15	730078	THREAD TAKEUP	1
6	660076	SCREW	1	16	660104	SCREW	1



NEEDLE DRIVE MECHANISM (1)

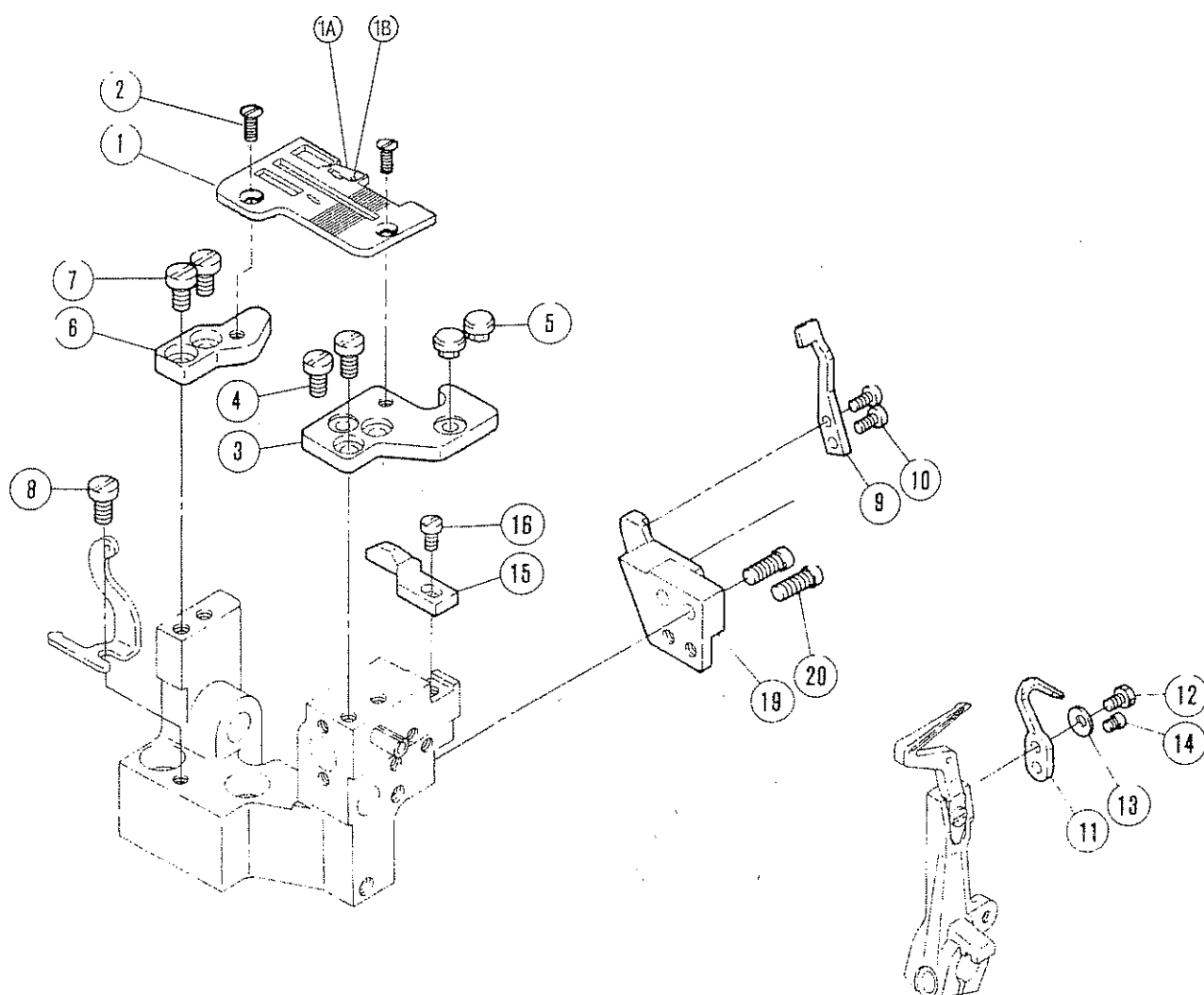


NEEDLE DRIVE MECHANISM (1)

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1	730100	CONNECTION	1	19	611600	OIL WICK	2
2	660091	SCREW	2	20	660109	SCREW	1
3	730102	PIN	1	21	801298	BUSHING ASSY (INCLUDES 22,23)	2
4	660107	SCREW	1	•22	(SEE 21)	BUSHING	2
5	730101	CRANK	1	•23	(SEE 21)	NEEDLE BAR	2
6	660106	SCREW	1	24	660110	SCREW	2
7	730103	SHAFT	1	25	730093	O-RING	2
8	730081	COLLAR	1	26	730096	OIL FELT	2
9	660077	SCREW	2	27	730112	RING	2
10	615390	WAHSE	1	28	660063	SCREW	2
11	730094	RING	1	29	730082	PLUG	2
12	730104	LEVER	1	30	801758	NEEDLE HOLDER ASSY	1
13	660105	BOLT	1	31	660121	SCREW	1
14	730105	LINK	1	32	730037	THREAD GUIDE	1
15	730106	PIN	2	33	660261	SCREW	2
16	660108	SCREW	2	34	PSM-1170	NEEDLE <i>16x157 #24</i>	2
17	730107	SHAFT ASSY	1	35	730125	NEEDLE HOLDER ASSY	1
*18	730108	PIN	1				

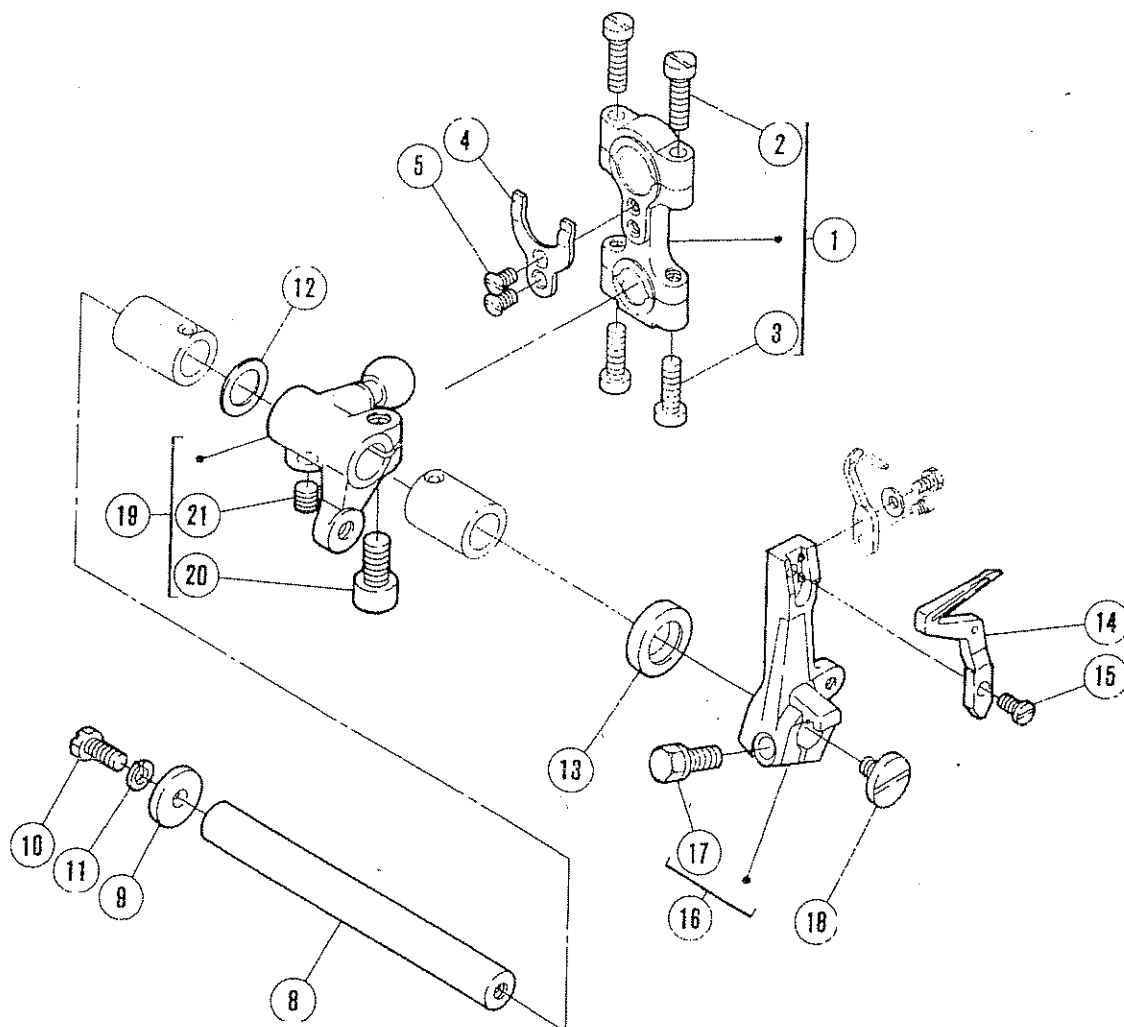
NEEDLE DRIVE MECHANISM (2)

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1	801366	NEEDLE PLATE	1	9	660071	NEEDLE GUARD (FRONT)	1
1A	660039	CHAINFINGER	1	10	660111	SCREW	2
1B	MS25001	CHAINFINGER SCREW	1	11	660070	NEEDLE GUARD (REAR)	1
2	660064	SCREW	2	12	660115	BOLT	1
3	800978	BRACKET (FRONT)	1	13	730083	SPRNG WASHER	1
4	660076	SCREW	2	14	660113	SCREW	1
5	730030	CUSHION RUBBER	2	15	801446	NEEDLE GUARD (FRONT)	1
6	800983	BRACKET (REAR)	1	16	SHCS6-32X $\frac{1}{2}$	SCREW	1
7	660076	SCREW	2	19	730115	BRACKET	1
8	660076	SCREW	1	20	660112	SCREW	2

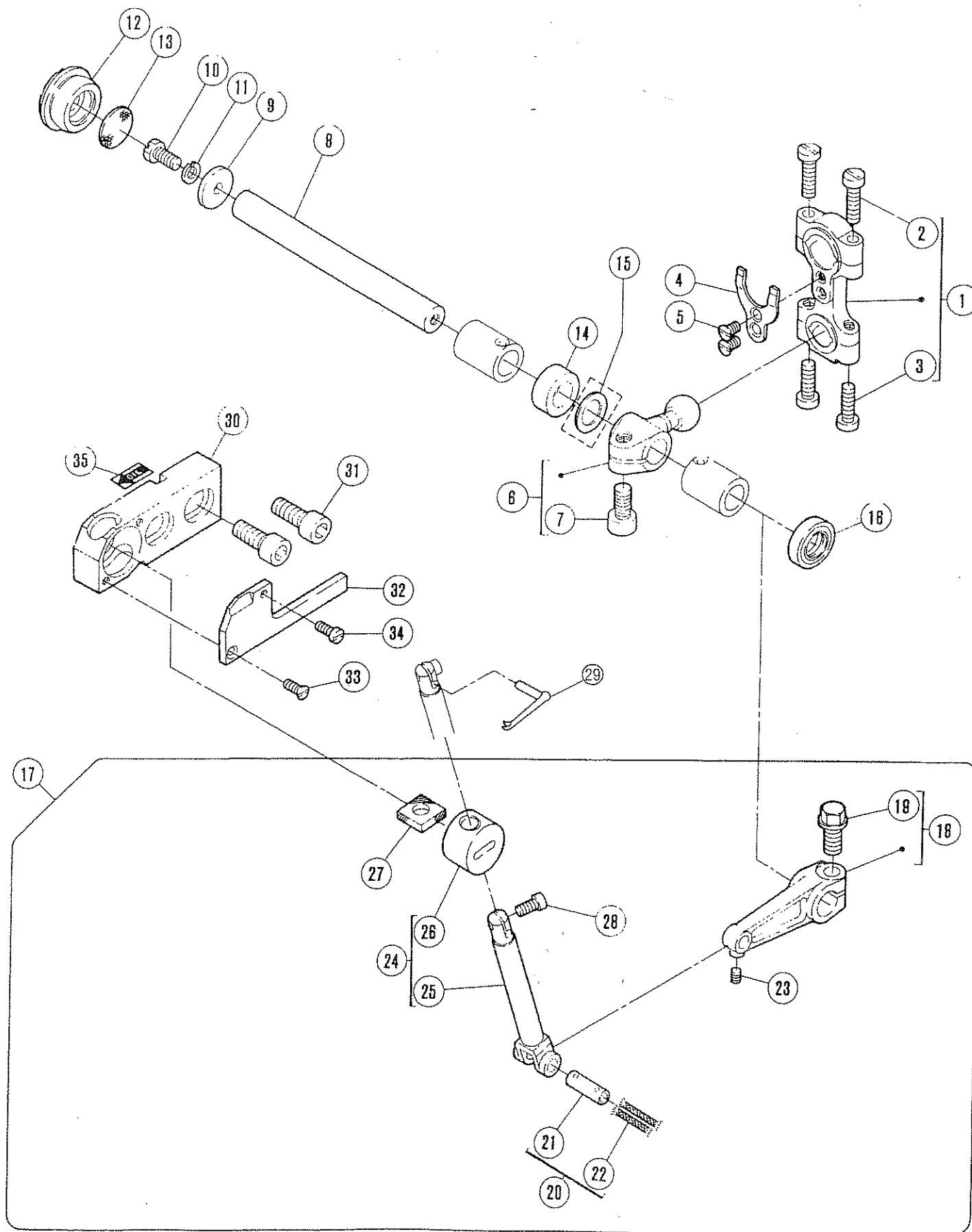


LOWER LOOPER DRIVE MECHANISM

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1	730084	CONNECTION	1	13	640024	OIL SEAL	1
2	660091	SCREW	2	14	730180	LOWER LOOPER	1
3	660072	SCREW	2	15	660067	SCREW	1
4	730085	GUIDE	1	16	730155	LOWER LOOPER HOLDER ASSY	1
5	660102	SCREW	2	17	660119	SCREW	1
8	730087	SHAFT	1	18	660120	SCREW	1
9	730080	WASHER	1	19	730170	CRANK	1
10	660114	SCREW	1	20	660106	SCREW	1
11	730097	SPRING WASHER	1	21	660096	SCREW	1
12	730123	WASHER	1				



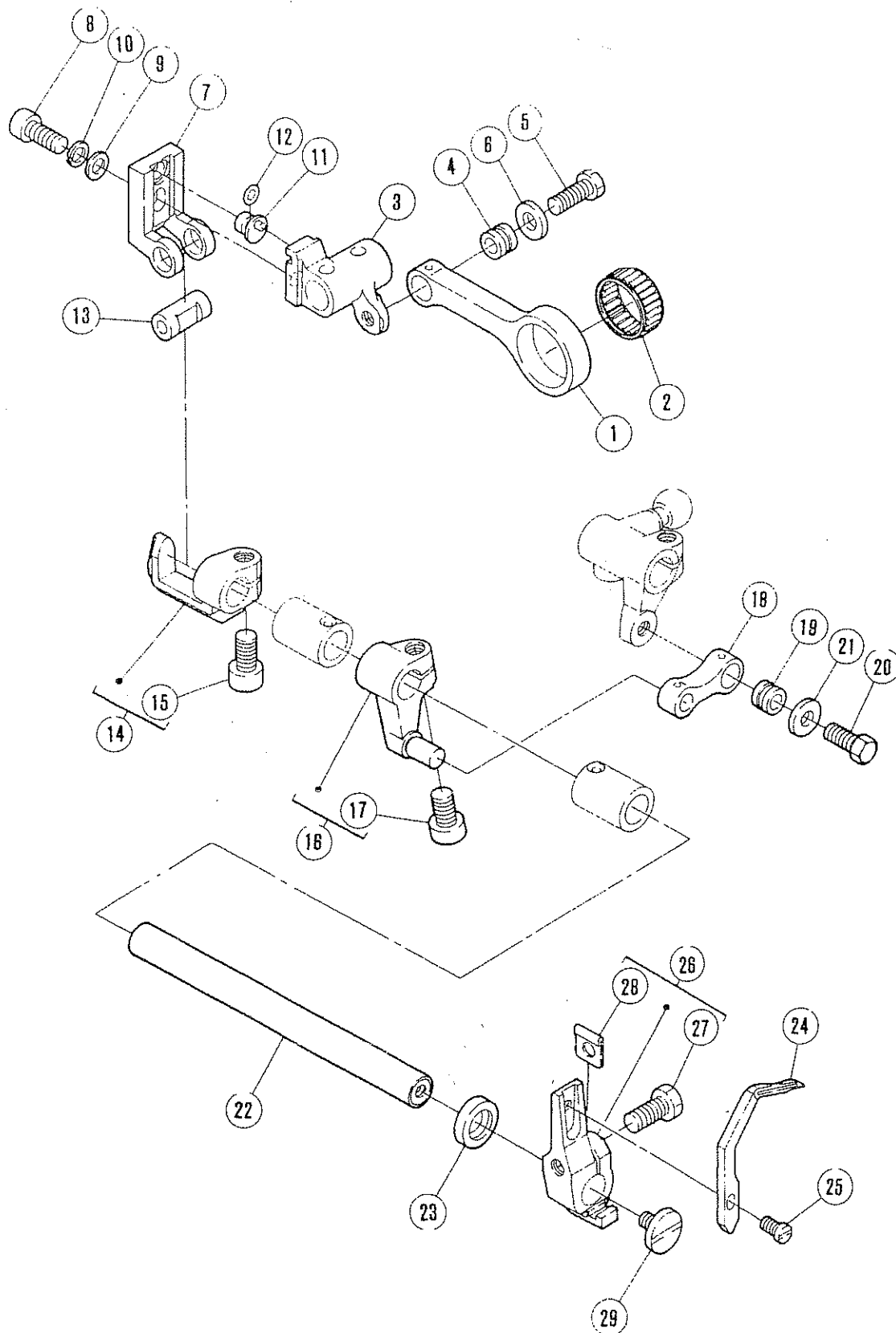
SPREADER DRIVE MECHANISM



SPREADER DRIVE MECHANISM

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1	730124	CONNECTION	1	19	660105	BOLT	1
2	660091	SCREW	2	20	730016	PIN ASSEMBLY	1
3	660072	SCREW	2	21	730117	PIN	1
4	730085	GUIDE	1	22	617420	OIL WICK	2
5	660102	SCREW	2	23	660109	SCREW	1
6	730129	CRANK	1	24	730130	SPREADER HOLDER ASSY	1
7	660106	SCREW	1	25	730131	SPREADER HOLDER	1
8	730087	SHAFT	1	26	730118	GUIDE/SPREADER HOLDER	1
9	730080	WASHER	1	27	730119	OIL FELT	1
10	660114	SCREW	1	28	660066	SCREW	1
11	730097	SPRING WASHER	1	29	730132	SPREADER	1
12	730088	PLUG	1	30	730127	BASE/SPREADER HOLDER	1
13	730089	FILTER	1	31	660116	SCREW	2
14	730098	SPACER	1	32	730128	COVER	1
15	730122	WASHER	1	33	660118	SCREW	1
16	640024	OIL SEAL	1	34	660017	SCREW	1
17	730134	SPREADER HOLDER ASSY	1	35	660122	OIL MARK	1
18	730126	LEVER	1				

CHAINSTITCH LOOPER DRIVE MECHANISM (1)



CHAINSTITCH LOOPER DRIVE MECHANISM (1)

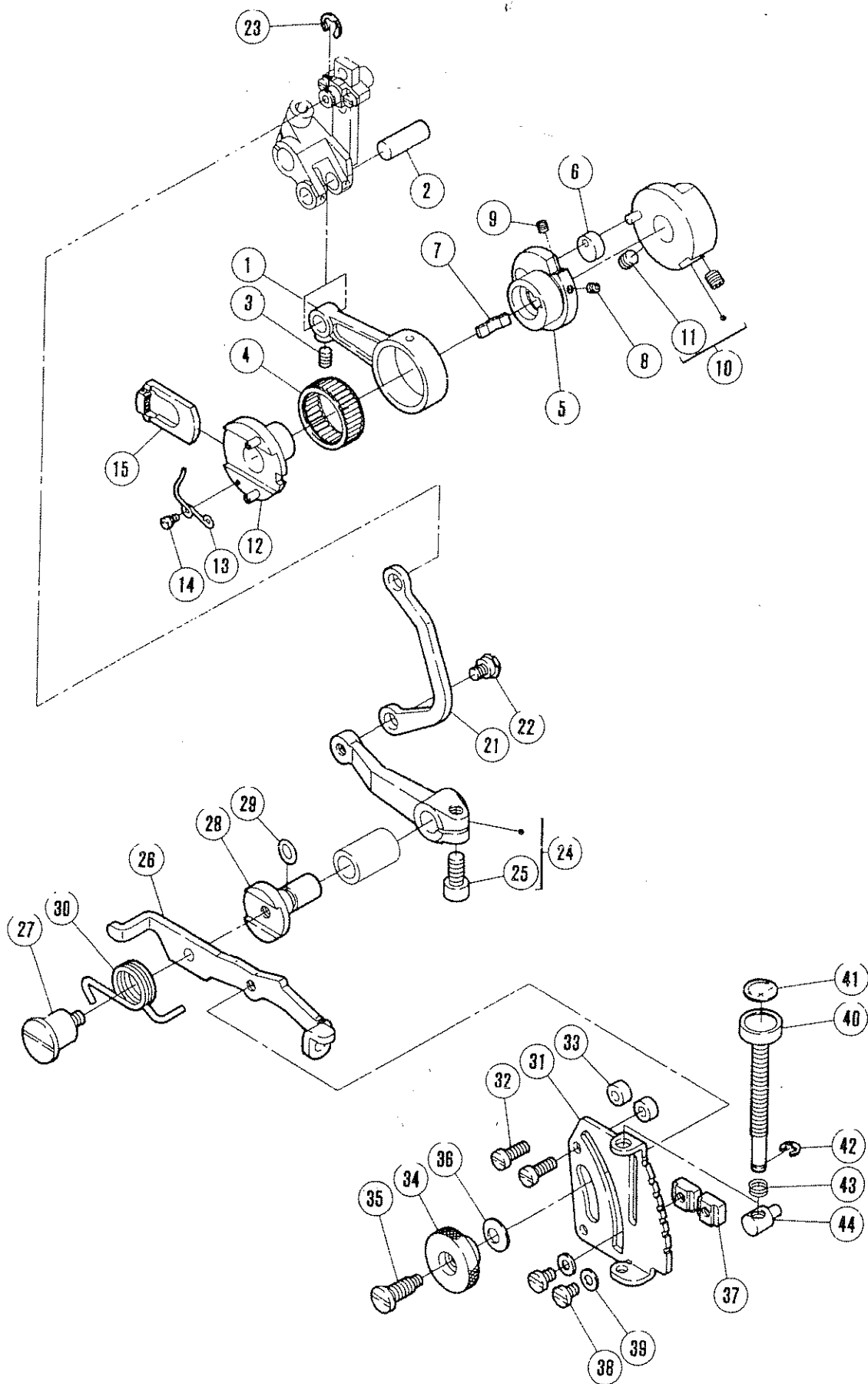
Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1	660229	CONNECTION	1	16	660247	CRANK	1
2	620028	NEEDLE BEARING	1	17	660106	SCREW	1
3	660192	CRANK	1	18	660169	LINK	1
4	660230	BUSHING	1	19	660230	BUSHING	1
5	660265	SCREW	1	20	660265	SCREW	1
6	660193	WASHER	1	21	660193	WASHER	1
7	660198	SLIDER	1	22	660195	SHAFT	1
8	660258	BOLT	1	23	612300	OIL SEAL	1
9	660145	WASHER	1	24	801458	DOUBLE CHAINSTITCH LOOPER	1 x
10	730097	SPRING WASHER	1	25	660067	SCREW	1
11	660159	PIN	1	26	660248	LOOPER HOLDER	1
12	660131	O-RING	1	27	660119	SCREW	1
13	660194	SHAFT	1	28	660157	SPACER	1
14	660246	HOLDER	1	29	660120	SCREW	1
15	660106	SCREW	1				



CHAINSTITCH LOOPER DRIVE MECHANISM (2)

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1	660210	THREAD GUIDE	1	12	660214	THREAD GUIDE	1
2	660076	SCREW	1	13	660081	SCREW	1
3	660211	THREAD GUIDE	1	14	660215	THREAD GUIDE	1
4	660129	HOLDER	2	15	660085	SCREW	1
5	660212	BRACKET	1	16	660218	THREAD GUIDE	1
6	660089	SCREW	1	17	660085	SCREW	1
7	730051	WASHER	2	18	660232	LOOPER THREAD TAKEUP ASSY	1
8	660270	SCREW	1	19	660261	SCREW	2
9	660125	TENSION DISC	2	20	660216	SPRING	1
10	660137	SPRING	1	21	660217	THREAD GUIDE	1
11	660213	KNOB	1				

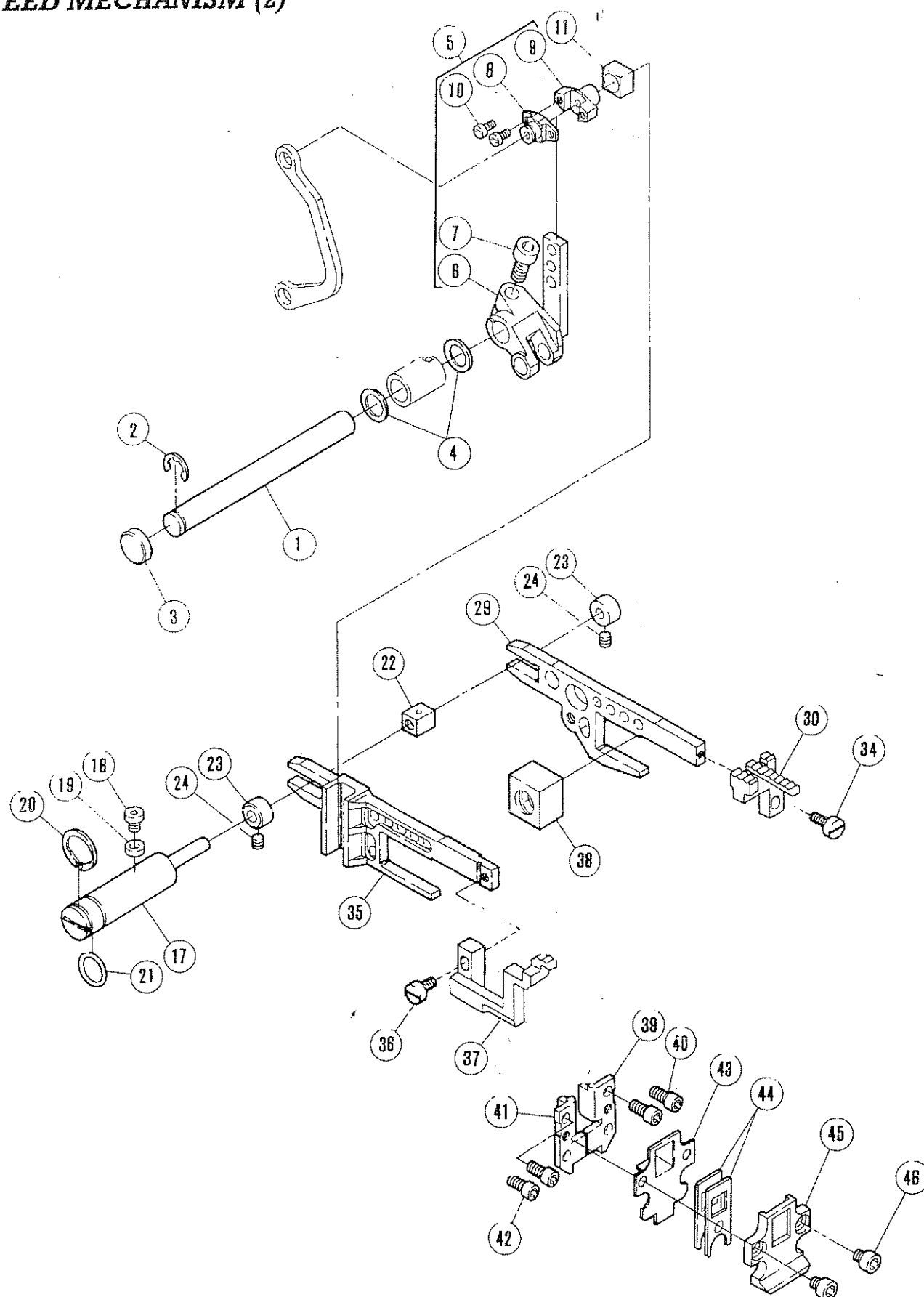
FEED MECHANISM (1)



FEED MECHANISM (1)

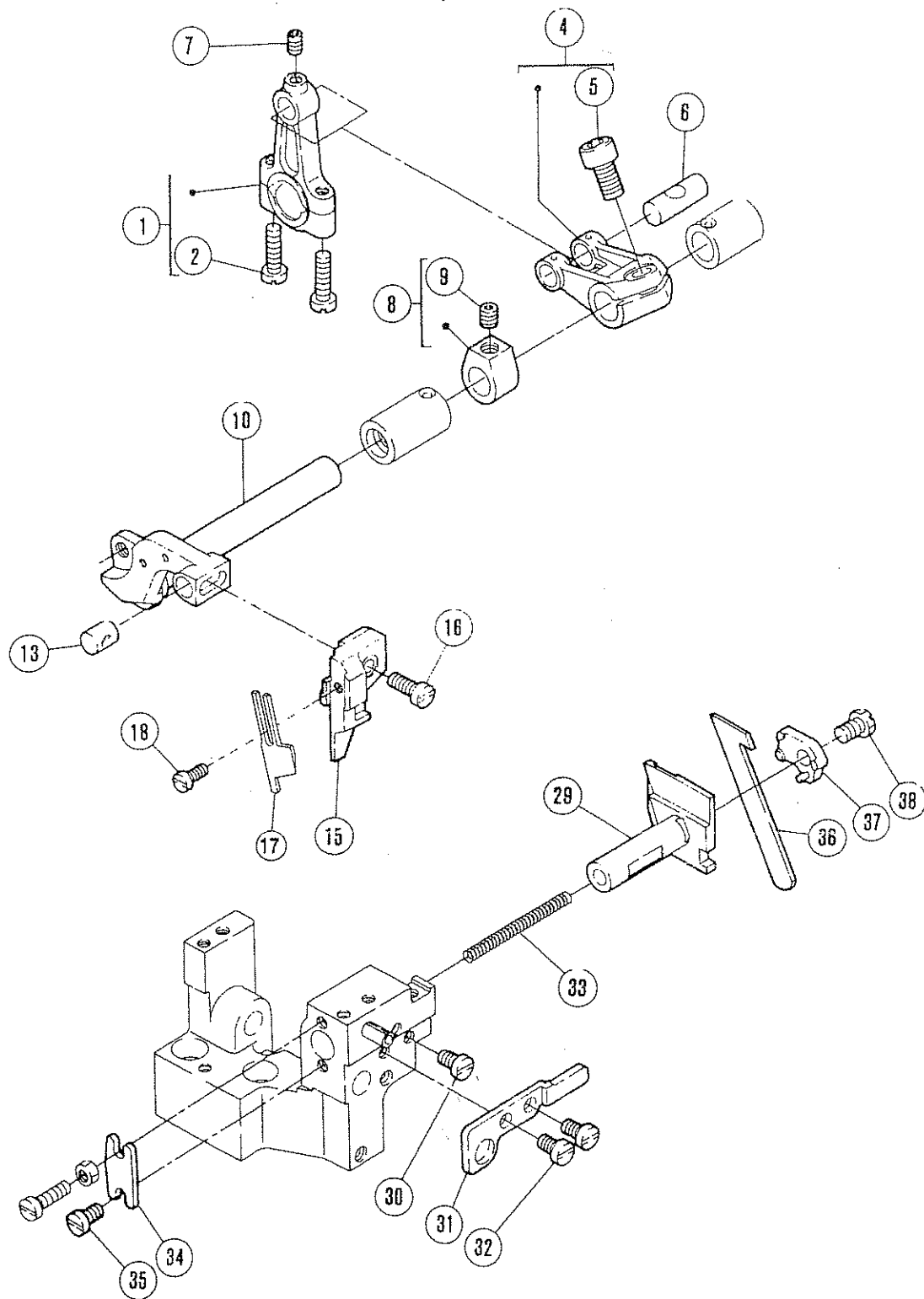
Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1	660161	CONNECTION	1	31	660184	REGULATOR PLATE	1
2	730102	PIN	1	32	660069	SCREW	2
3	660107	SCREW	1	33	660150	SPACER	2
4	730034	NEEDLE BEARING	1	34	660231	NUT	1
5	660162	ECCENTRIC	1	35	660267	SCREW	1
6	620037	GUIDE/FEED ECCENTRIC	1	36	660136	SPRING WASHER	1
7	620038	FLAT SPRING	1	27	660269	SCREW	1
8	660256	SCREW	1	28	660241	SHAFT	1
9	660259	SCREW	1	29	613320	O-RING	1
10	660238	REGULATOR	1	30	660183	SPRING	1
11	660096	SCREW	2	31	660184	REGULATOR PLATE	1
12	660237	ECCENTRIC ASSEMBLY	1	32	660069	SCREW	2
13	660164	SPRING	1	33	660150	SPACER	2
14	660264	SCREW	1	34	660231	NUT	1
15	660163	RATCHET	1	35	660267	SCREW	1
21	660181	LINK	1	36	660136	SPRING WASHER	1
22	660266	SCREW	1	37	660160	STOPPER	2
23	611740	RING	1	38	660082	SCREW	2
24	660240	LEVER	1	39	660227	WASHER	2
25	660106	SCREW	1	40	660242	ADJUSTING BAR	1
26	660182	LEVER	1	41	660151	SEAL	1
27	660269	SCREW	1	42	610920	RING	1
28	660241	SHAFT	1	43	660135	SPRING	1
29	613320	O-RING	1	44	660231	PIN	1
30	660183	SPRING	1				

FEED MECHANISM (2)



FEED MECHANISM (2)

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1	660168	SHAFT	1	23	730035	COLLAR	2
2	660128	RING	1	24	660077	SCREW	2
3	615220	PLUG	1	29	801559	MAIN FEED BAR	1
4	730123	WASHER	2	30	800962	MAIN FEED DOG	1
5	660239	CRANK	1	34	660263	SCREW	1 ✕
6	660165	CRANK	1	35	801560	DIFFERENTIAL FEED BAR	1
7	660080	SCREW	1	36	660268	SCREW	2
8	660166	CRANK PIN	1	37	801457	DIFFERENTIAL FEED DOG	1S
9	660167	CRANK PIN	1	38	660176	BLOCK	1
10	660111	SCREW	2	39	660171	GUIDE/FEED BAR	1
11	660170	BLOCK	1	40	660268	SCREW	4
17	660177	PIN	1	41	660172	GUIDE (LEFT) FEED BAR	1
18	660272	SCREW	1	43	660175	GUIDE/FEED BAR OIL SEAL	1
19	660148	GASKET	1	44	660173	OIL SEAL	2
20	660149	RING	1	45	660174	GUIDE FEED BAR OIL SEAL	1
21	730093	O-RING	1	46	660262	SCREW	2
22	660178	BLOCK	1				

KNIFE DRIVE MECHANISM

KNIFE DRIVE MECHANISM

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1	660243	CONNECTION	1	16	660069	SCREW	1
2	660091	SCREW	2	17	630128	UPPER KNIFE	1
3	660244	CRANK	1	18	660263	SCREW	1
4	660245	CRANK	1	29	801548	LOWER KNIFE HOLDER	1
5	660106	SCREW	1	30	660076	SCREW	1
6	730102	PIN	1	31	660190	GUIDE/LOWER KNIFE HOLDER	1
7	660107	SCREW	1	32	660076	SCREW	2
8	660236	COLLAR	1	33	660152	SPRING	1
9	660260	SCREW	1	34	660188	PLATE	1
10	660185	UPPER KNIFE LEVER	1	35	660076	SCREW	1
13	660187	PIN	1	36	800867	LOWER KNIFE	1
15	660234	UPPER KNIFE CLAMP	1	37	660191	LOWER KNIFE CLAMP	1

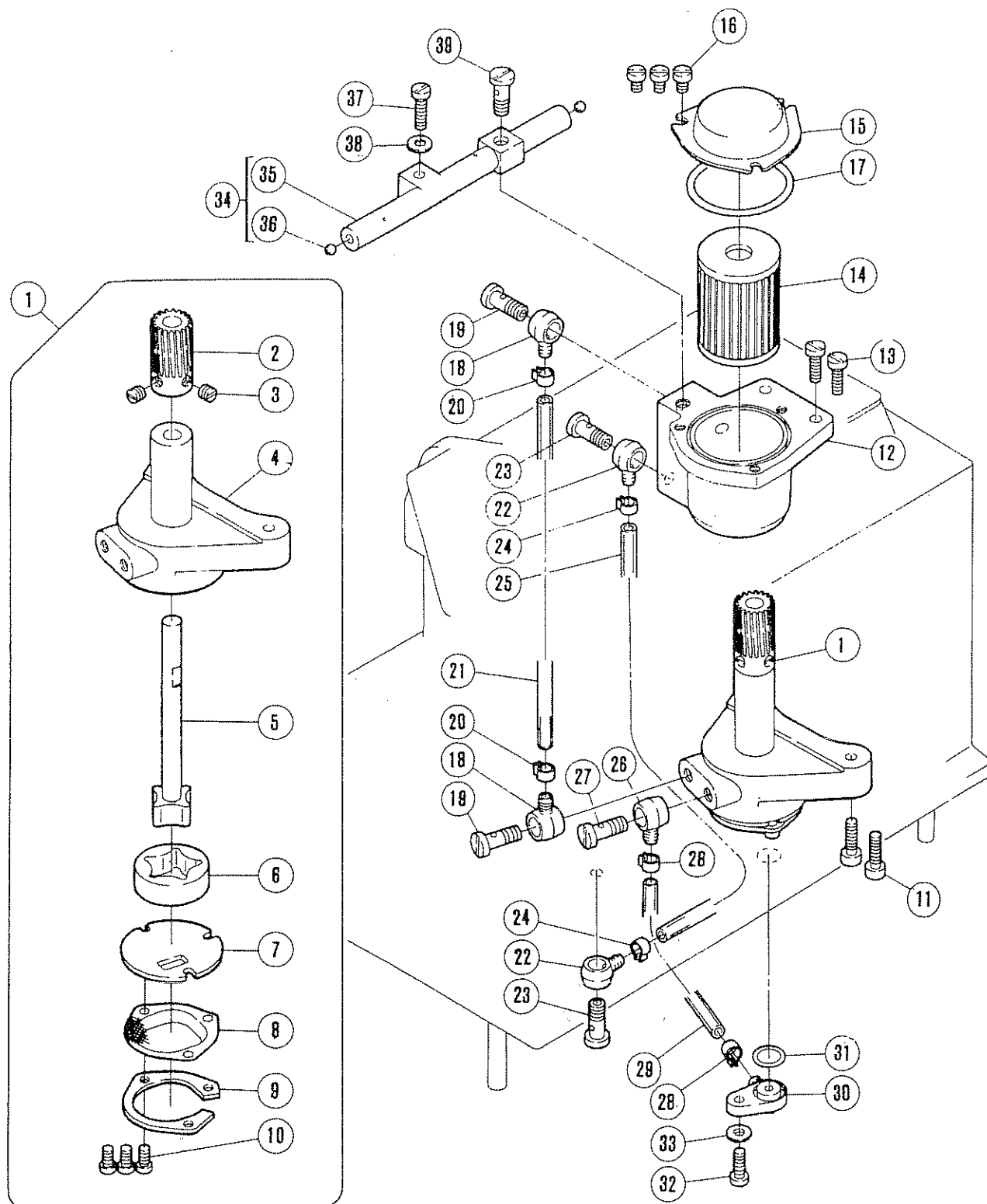
ITEM # 36

800867
LOWER KNIFE

1

This is Actual Size

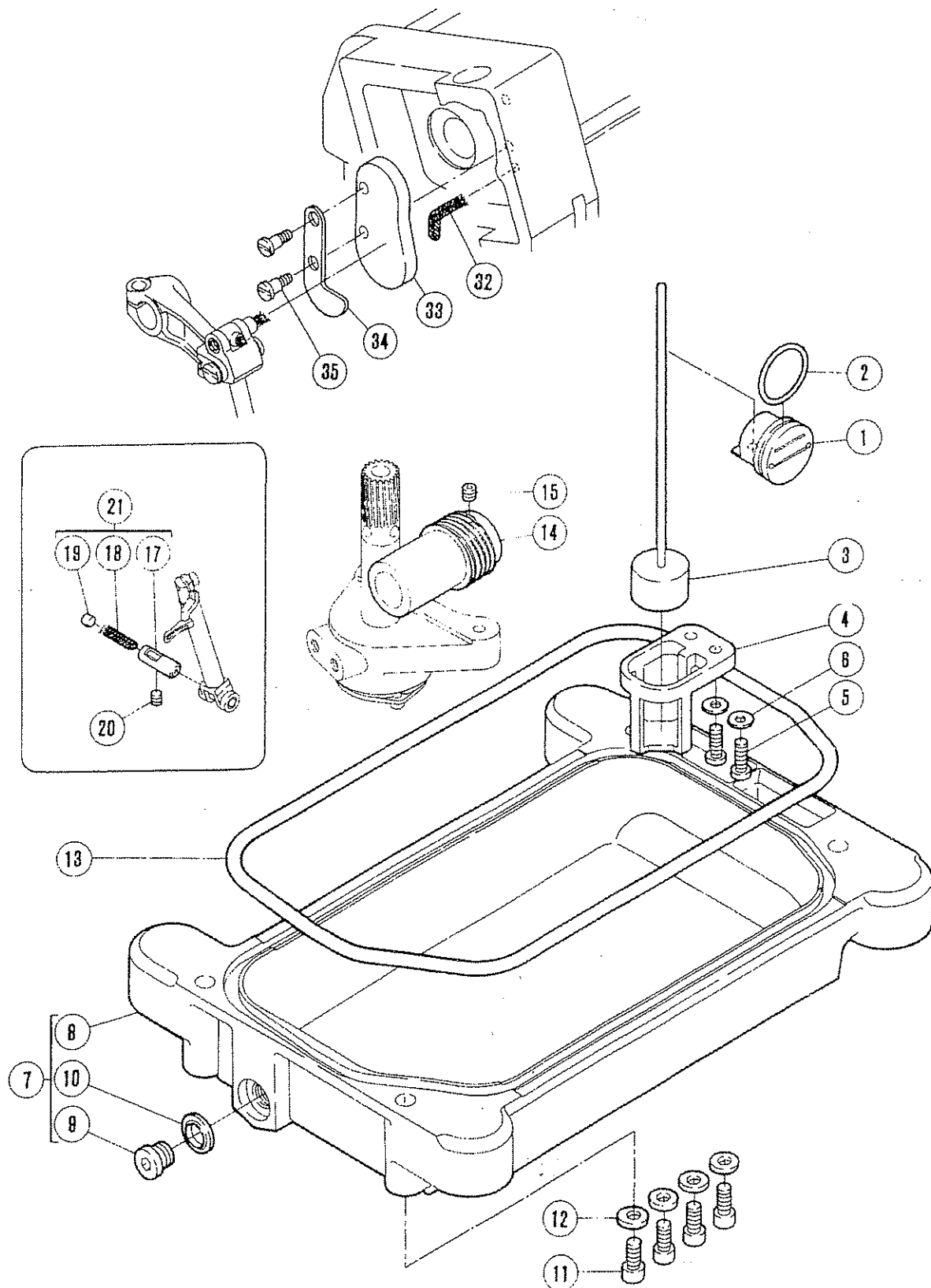
LUBRICATION MECHANISM (1)



LUBRICATION MECHANISM (1)

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1	660250	PUMP	1	21	660153	TUBE	1
2	660138	WORM WHEEL	1	22	610800	JOINT	2
3	618460	SCREW	2	23	660154	SCREW	2
4	660200	PUMP BODY	1	24	611615	CLAMP	2
5	620020	ROTOR (INSIDE) SHAFT	1	25	660146	TUBE	1
6	620024	ROTOR (OUTSIDE)	1	26	610800	JOINT	1
7	660201	CASING PLATE	1	27	660154	SCREW	1
8	660139	FILTER	1	28	611615	CLAMP	2
9	660140	GUIDE	1	29	660156	TUBE	1
10	660263	SCREW	3	30	660205	JOINT	1
11	660257	SCREW	2	31	660142	O-RING	1
12	660202	TANK	1	32	660069	SCREW	1
13	660069	SCREW	2	33	660227	WASHER	1
14	660130	OIL FILTER	1	34	660251	OIL DISTRIBUTOR COMPLETE	1
15	660203	COVER	1	35	660204	OIL DISTRIBUTOR	1
16	660082	SCREW	3	36	660133	PLUG	2
17	660147	O-RING	1	37	660091	SCREW	1
18	610800	JOINT	2	38	660227	WASHER	1
19	660154	SCREW	2	39	660154	SCREW	1
20	611615	CLAMP	2				

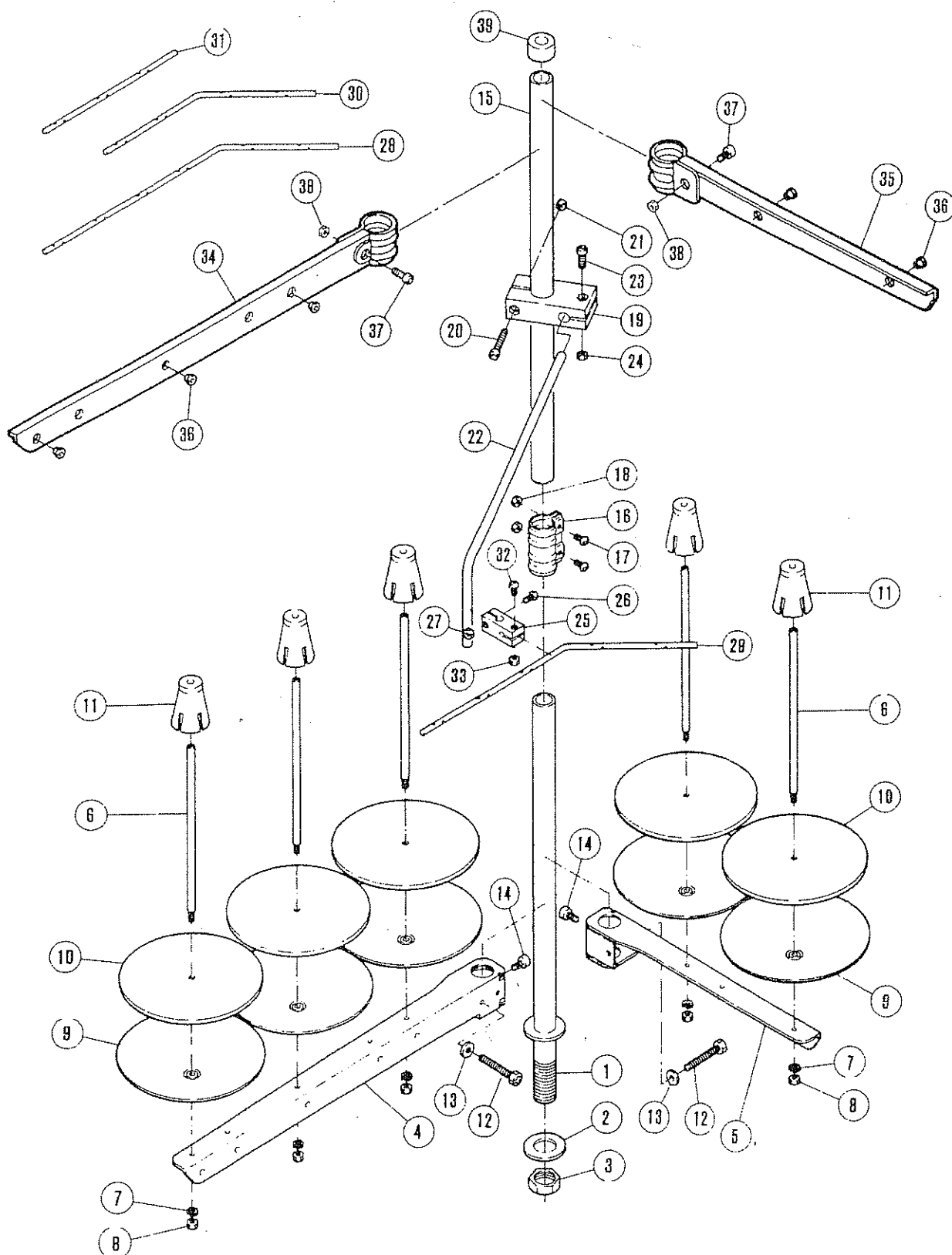
LUBRICATION MECHANISM (2)



LUBRICATION MECHANISM (2)

Ref#	Part#	Description	Qty	Ref#	Part#	Description	Qty
1	660198	OIL SIGHT GUAGE	1	13	660197	GASKET	1
2	660141	O-RING	1	14	660199	WORM	1
3	660132	INDICATOR COMPLETE	1	15	660096	SCREW	1
4	660134	INDICATOR SUPPORT	1	17	660206	PIN	1
5	660069	SCREW	2	18	660126	OIL WICK	1
6	660227	WASHER	2	19	660143	PLUG	1
7	660249	OIL RESERVOIR ASSY	1	20	660077	SCREW	1
8	660196	OIL RESERVOIR	1	21	660252	PIN ASSY	1
9	618840	SCREW	1	32	660226	OIL WICK	1
10	611660	GASKET	1	33	660207	OIL FELT	1
11	660258	BOLT	4	34	660208	COVER	1
12	660158	WASHER	4	35	660271	SCREW	1

THREAD STAND



Porter International • 97 Rantoul Street • Beverly, MA 01915

From the library of Superior Sewing Machine & Supply LLC - www.supsew.com

THREAD STAND

Ref#	Part#	Description	3 spool	4 spool	5 spool	6 spool
	660273	THREAD STAND ASS. (6-SPOOLS)				1
	640068	THREAD STAND ASS.(5-SPOOLS)			1	
	640069	THREAD STAND ASS. (4-SPOOLS)		1		
	640070	THREAD STAND ASS. (3-SPOOLS)	1			
1	640043	THREAD STAND ROD	1	1	1	1
2	640044	WASHER	1	1	1	1
3	640042	NUT	1	1	1	1
4	640058	BRACKET	1		1	1
5	640059	BRACKET		2	1	
6	640060	SPOOL PIN	3	4	5	6
7	640005	SPRING WASHER	3	4	5	6
8	640053	NUT	3	4	5	6
9	640062	SPOOL TRAY	3	4	5	6
10	640063	CUSHION	3	4	5	6
11	640064	SPOOL RETAINING FIN	3	4	5	6
12	640065	SCREW	1	2	2	2
13	640066	WASHER	1	2	2	2
14	640067	SCREW	1	2	2	2
15	640040	THREAD STAND ROD (UPPER	1	1	1	1
16	640056	JOINT	1	1	1	1
17	640057	SCREW	2	2	2	2
18	640049	NUT	2	2	2	2
19	640050	BRACKET	1	1	1	1
20	640052	SCREW	1	1	1	1
21	640053	NUT	1	1	1	1
22	640051	THREAD GUIDE BAR ROD	1	1	1	1
23	640055	SCREW	2	2	2	2
24	640053	NUT	2	2	2	2
25	640054	HOLDER	1	1	1	1
26	640055	SCREW	1	1	1	1
27	640053	NUT	1	1	1	1
28	660255	THREAD GUIDE BAR (6-SPOOLS)				1
29	618240	THREAD GUIDE BAR (5-SPOOLS)			1	
30	618241	THREAD GUIDE BAR (4-SPOOLS)		1		
31	618242	THREAD GUIDE BAR (3-SPOOLS)	1			
32	640055	SCREW	1	1	1	1
33	640053	NUT	1	1	1	1
34	640045	BRACKET	1		1	
35	640046	BRACKET		2	1	
36	640047	THREAD GUIDE	3	4	5	6
37	640048	SCREW	1	2	2	2
38	640049	NUT	1	2	2	2
39	640041	ROD CAP	1	1	1	1