

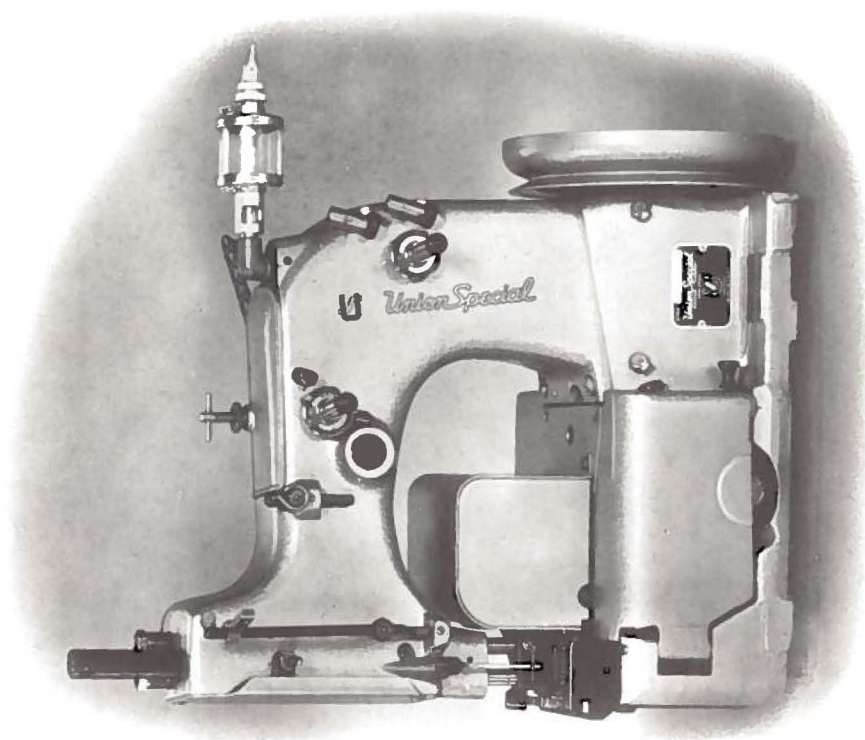


*Union Special*<sup>®</sup>  
LEWIS<sup>®</sup> • COLUMBIA<sup>®</sup>

INDUSTRIAL  
SEWING  
MACHINES

**STYLES**

**80800E  
80800F  
80800H**



**CLASS 80800**

**HIGH SPEED**

**FILLED BAG CLOSING MACHINES**

**CATALOG**

**No.**

**137M**

**Second  
Edition**

***UNION SPECIAL CORPORATION***

**CHICAGO**

From the library of: Superior Sewing Machine & Supply LLC

# Union Special Wants to Help You Cut Sewing Machine Maintenance Costs

Union Special is offering two practical systems to help pinpoint and reduce your sewing machine maintenance costs: a record keeping system to help spot machines requiring abnormally high maintenance, and a parts inventory system to speed routine repairs.

## Machine Maintenance Records

Repair-prone machines or inexperienced competent operators can eat up your maintenance dollars in short order. To help spot these problems, Union Special suggests two variations of a simple maintenance record keeping system using cards provided by Union Special.

The first system utilizes a "Machine Maintenance Record" card (Form 237) for each sewing machine in a plant. When a repair is required, the card is pulled from the file and the repair date, parts used, and their cost are entered in the spaces provided and the card is refilled.

The second system is normally used when more detailed information on repair costs is desired. Two record cards are used: a "Repair Request Card" (Form 234), and a "Machine Repair Record" (Form 233). When a machine requires service, the forelady or foreman fills out the top of a "Repair Request Card" and gives it to a mechanic. He fills in the time the repair work is started, the parts used and their cost,

and the completion time. This data is then transferred to the permanent "Machine Repair Record" kept in the office.

Whichever system is used, management now has an invaluable tool to reduce needless maintenance costs.

## Repair Part Inventories

While record keeping tells management which machines require abnormally high maintenance, it does little to help reduce the downtime caused by routine repairs. To alleviate this situation, Union Special recommends that manufacturers establish a formal parts inventory system for each type of sewing machine they operate.

Excessive machine downtime and wasted hours by mechanics can be eliminated with an orderly in-plant inventory of the most commonly needed parts. There is no longer a need to cannibalize other machines for spare parts. Long waits for deliveries are avoided and machine downtime is kept to a minimum. The cost of a parts inventory is small when the overall savings are considered.

For free sample copies of the machine record cards and spare part inventory lists for a variety of the most popular machines, contact your local Union Special Representative or write direct to Union Special.

**Union Special**  
Industrial Sewing Equipment

## Style 80800 E

### Suggested Minimum Spare Parts List\*

| Part Number | Description                       | Minimum Quantity Per 5 Machines | Part Number | Description            | Minimum Quantity Per 5 Machines |
|-------------|-----------------------------------|---------------------------------|-------------|------------------------|---------------------------------|
| 80627 E     | Presser foot                      | 1                               | 1975 G      | Needles (specify size) | 200                             |
| C41         | Hinge screw for #80627 E          | 2                               | 80675       | Lower knife            | 1                               |
| 88          | Clamp screw                       | 1                               | 88 D        | Screw for lower knife  | 1                               |
| 22570       | Clamp screw                       | 1                               | 80677       | Upper knife            | 1                               |
| 22707       | Screw to adj. presser foot bottom | 1                               | 92127       | Screw for upper knife  | 1                               |
| 80605 E     | Feed dog                          | 1                               | AS26 XA     | Looper                 | 1                               |
| 93          | Screw for feed dog                | 1                               | 73          | Looper set screw       | 2                               |
| 80624 E     | Throat plate                      | 1                               | 80604       | Thread hook            | 1                               |
| 80          | Screw for throat plate            | 3                               | AS22 D      | Screw for thread hook  | 2                               |
| HA56        | Needle clamp nut                  | 2                               | 80623       | Looper thread take up  | 1                               |
|             |                                   |                                 | 21225 5/16  | Looper gauge           | 1                               |
|             |                                   |                                 | 29484       | Screw assortment       | 1                               |

\*The parts and quantities listed above are intended to assist you in setting up the initial inventory of spare parts. An efficient inventory can only be established according to actual usage. The nature of the sewing operation will determine actual usage.



Catalog No. 137 M

INSTRUCTIONS

FOR

ADJUSTING AND OPERATING

LIST OF PARTS

CLASS 80800

Styles

80800 E

80800 F

80800 H

Second Edition

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**UNION SPECIAL CORPORATION**

INDUSTRIAL SEWING MACHINES

**CHICAGO**

Printed in U.S.A.

May, 1979

## IDENTIFICATION OF MACHINES

Each UNION SPECIAL machine is identified by a Style number which is stamped in the name plate on the machine. Style numbers are classified as standard and special. Standard Style numbers have one or more letters suffixed, but never contain the letter "Z". Example: "Style 80800 E". Special Style numbers contain the letter "Z". When only minor changes are made in a standard machine, a "Z" is suffixed to the Standard Style number. Example: "Style 80800 EZ".

Styles of machines similar in construction are grouped under a Class number which differs from the Style number, in that it contains no letters. Example: "Class 80800".

## APPLICATION OF CATALOG

This catalog applies specifically to the Standard Styles of machines as listed herein. It can also be applied with discretion to some Special Styles of machines in this Class. References to direction, such as right, left, front, back, etc., are described as viewing the machine as it sits in front of the mechanic on an adjusting table, with the pulley to the right and the needle bar in vertical position. Operating direction of handwheel is away from the operator.

## STYLES OF MACHINES

Enclosed Type Flat Bed Bag Closing Machine, One Needle, High Throw, Manual Lubrication, Lateral Looper Travel, with Improved Bearings, Smaller Diameter Eccentrics and Coil Type Presser Springs, Distance From Center Line of Needle to Left Edge of Throat Plate 7/8 Inch.

80800 E Sewing head, for closing filled medium and heavy weight bags made from burlap, jute and single or multiwall paper. Filter cord guided under presser foot. Equipped with mechanical chain cutter. Seam specification 401-SSa-1. Type 1975 G needle. Maximum recommended speed 2500 R.P.M.

80800 F Sewing head, for closing filled medium and heavy weight bags made from burlap, jute and single or multiwall paper. Filter cord guided under presser foot. Equipped with mechanical chain cutter. Seam specification 101-SSa-1. Type 1975 G needle. Maximum recommended speed 2500 R.P.M.

NOTE: Styles 80800 E and F machines can also be used for seaming fabric bags by removing the filter cord.

80800 H Sewing head, for tape bound closures on filled medium and large size single ply or multiwall paper bags, using Union Special tape bound closing attachment. Filter cord guided under presser foot. Equipped with automatic tape cutter. Seam specification 401-BSa-1. Type 1975 G needle. Maximum recommended speed 2500 R.P.M.

NOTE: On Style 80800 H, the tape reel, folder, filter cord stand and adaptor assembly are not included with the machine. Tape folder and adaptor assembly No. 21884 C is available as an extra send and charge item. The included folder is designed to use a strip ranging from 2 1/8 to 2 1/2 inches.



## NEEDLES

Each UNION SPECIAL needle has both a type and size number. The type number denotes the kind of shank, point, length, groove, finish and other details. The size number, stamped on the needle shank, denotes largest diameter of blade, measured in thousandths of an inch, midway between shank and eye. Collectively, the type and the size number represent the complete symbol, which is given on the label of all needles packaged and sold by Union Special.

Needle Type 1975 G, Size 100 is recommended for the machine Styles covered by this catalog. The description and sizes available are listed below:

| <u>Type No.</u> | <u>Description and Sizes</u>                                                                                                                            |
|-----------------|---------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1975 G          | Round shank, square point, long Antaeus, double groove, spotted, chromium plated - sizes 200/080, 230/090, 250/100, 300/120, 350/140, 400/156, 480/188. |

To have needle orders promptly and accurately filled, an empty package, a sample needle, or the type and size number should be forwarded. Use description on label. A complete order would read: "100 needles, Type 1975 G, Size 250/100".

Selection of proper needle size is determined by size of thread used. Thread should pass freely through needle eye in order to produce a good stitch formation.

Success in the operation of UNION SPECIAL machines can be secured only by use of needles packaged under our brand name, *Union Special*<sup>®</sup>, which is backed by a reputation for producing highest quality needles in materials and workmanship for more than three-quarters of a century.

## OILING INSTRUCTIONS

Clean machine daily and thoroughly oil before the morning and afternoon start. Oiling diagram PL106 is applicable to machine Styles 80800 E and F, PL179 is applicable to machine Style 80800 H.

## THREADING

Thread machine as illustrated in Fig. 1 or 1A as applicable.

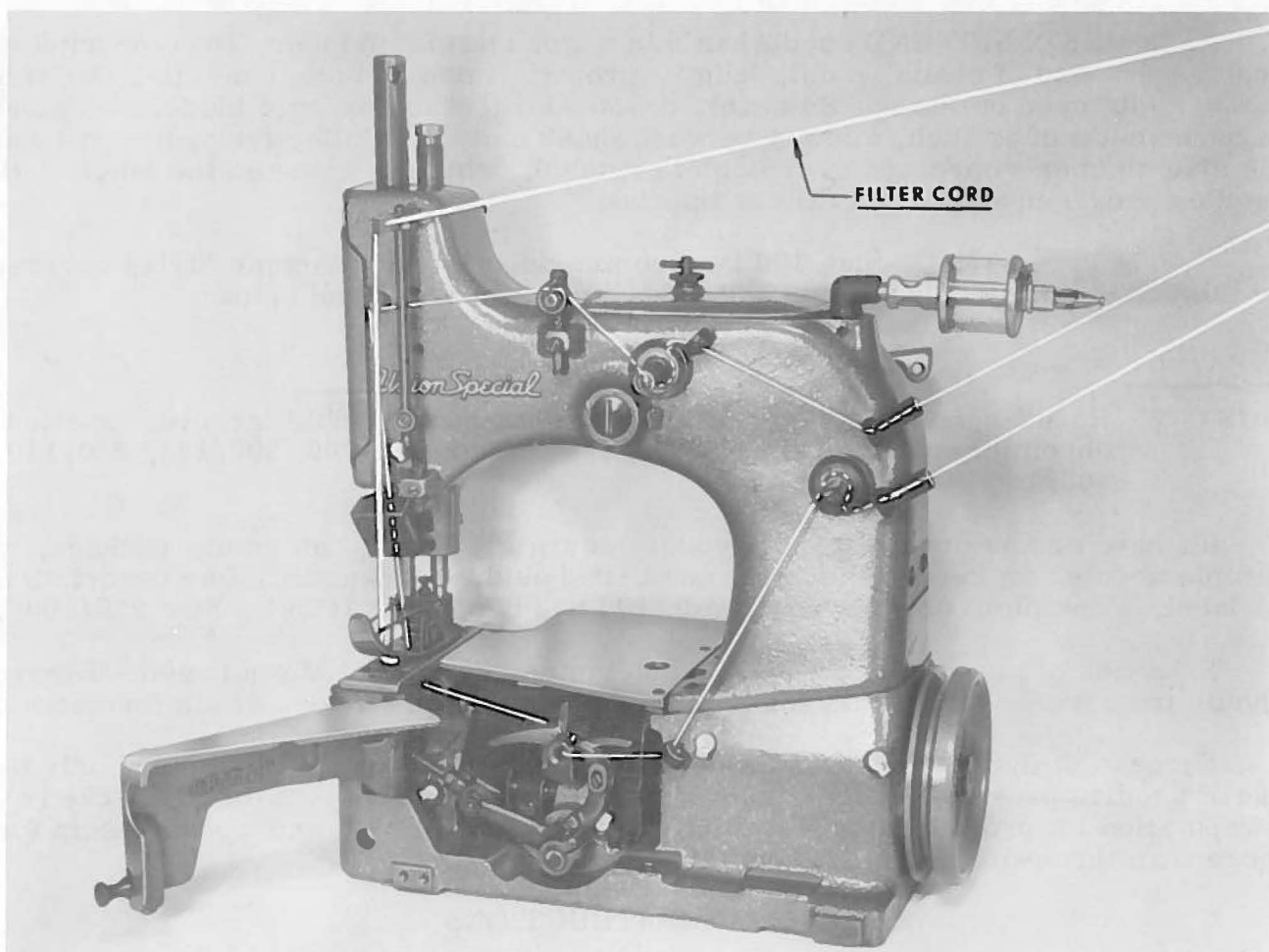


Fig. 1

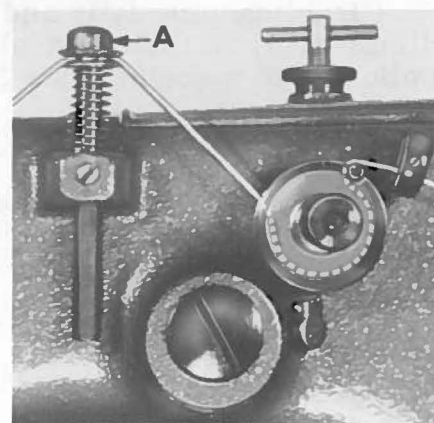


Fig. 1A

#### THREADING DIAGRAM FOR CLASS 80800 MACHINES

Thread machine Styles 80800 E and H as indicated in Fig. 1. The looper threading has been enlarged for clarity. When threading the looper, be sure the thread goes thru the front eyelet, over the take-up and thru the back eyelet before threading the looper.

NOTE: The diagram also shows the threading of the filter cord.

Thread the needle thread on machine Style 80800 F as indicated in Fig. 1A, assuring the thread passes between the discs and in the slot of the needle thread nipper support pin (A, Fig. 1A).



## SETTING THE LOOPER

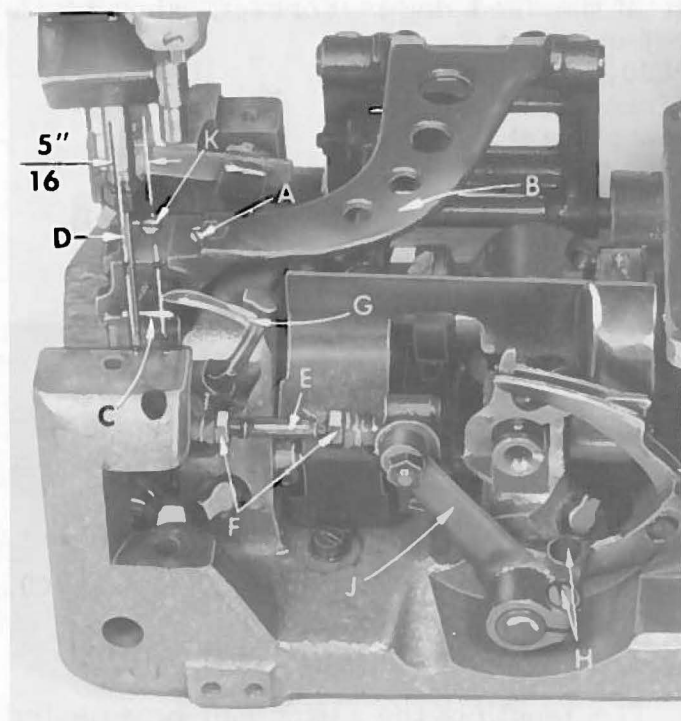


Fig. 2

Remove the presser foot, throat plate and feed dog for convenient access to the machine. Loosen the screw (A, Fig. 2) in the feed bar (B) and push the feed bar needle guard (C) to the rear to avoid its contacting the needle (D). For Styles 80800 E and H, set the looper connecting rod (E) so the distance between the centerlines of the two ball joints is  $2 \frac{3}{4}$  inches (See Fig. 3). This dimension should be  $2 \frac{11}{16}$  inches on Style 80800 F. If adjustment is necessary, loosen nuts (F, Fig. 2) and turn connecting rod (E) forward or backward as required to obtain specified dimension, retighten nuts (F). NOTE: The right nut has a left hand thread. Set the looper (G) so the distance from the centerline of the needle (D) to the point of the looper (G) is  $\frac{5}{16}$  inch, when the looper is at its farthest position to the right. Looper gauge No. 21225-5/16 can be used advantageously in making this adjustment. Loosen screws (H) in the looper drive lever (J), reposition as required to obtain specified dimension

and retighten screws (H) assuring that all end play is taken out of the looper drive lever rocker shaft. Check to insure clearance between the point of the looper and the cylinder end cover when the looper is at its extreme left position. Should the looper strike the end cover, RECHECK the distance between centerlines of ball joints and the looper gauge distance as described above. As the looper moves to the left and its point is even with the right side of the needle, the looper should pass as close as possible to the back of the needle without contacting it (.003 to .005 inch clearance). Adjustment can be made by loosening screw (A, Fig. 3) in looper avoid connection link (B) and turn looper rocker shaft (C) forward or backward as required, retighten screw (A).

## SETTING HEIGHT OF NEEDLE BAR

For Styles 80800 E and H, the height of the needle (A, Fig. 4) is correct when the top of its eye is  $\frac{1}{32}$  inch below the underside of the looper (B), with the looper point flush with the left side of the needle. This dimension should be  $\frac{3}{64}$  inch on Style 80800 F. If adjustment is necessary, loosen screw (A, Fig. 5) and move needle bar (B) up or down as required and retighten screw.

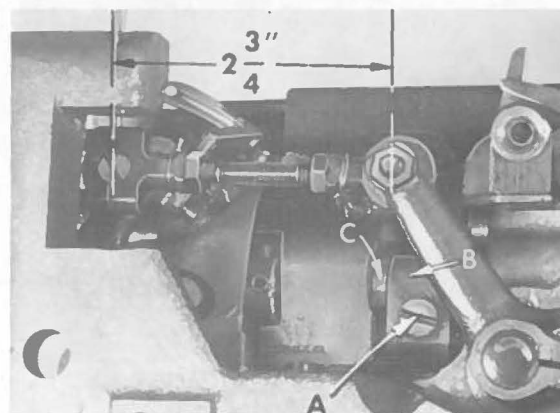


Fig. 3



## SETTING THE FEED DOG

For Styles 80800 E and H, the height of the feed dog is correct, when at its highest point of travel, the rear teeth project above the throat plate their full depth. On Style 80800 F, the tips of the two rear teeth should project  $\frac{1}{32}$  inch above the throat plate at this point. This can be accomplished by removing the feed dog holding screw (C, Fig. 5) and feed dog (D), then adjusting the stop screw (K, Fig. 2) in feed bar (B) as required to maintain the prescribed setting. Assemble feed dog (D, Fig. 5) and feed dog holding screw (C).

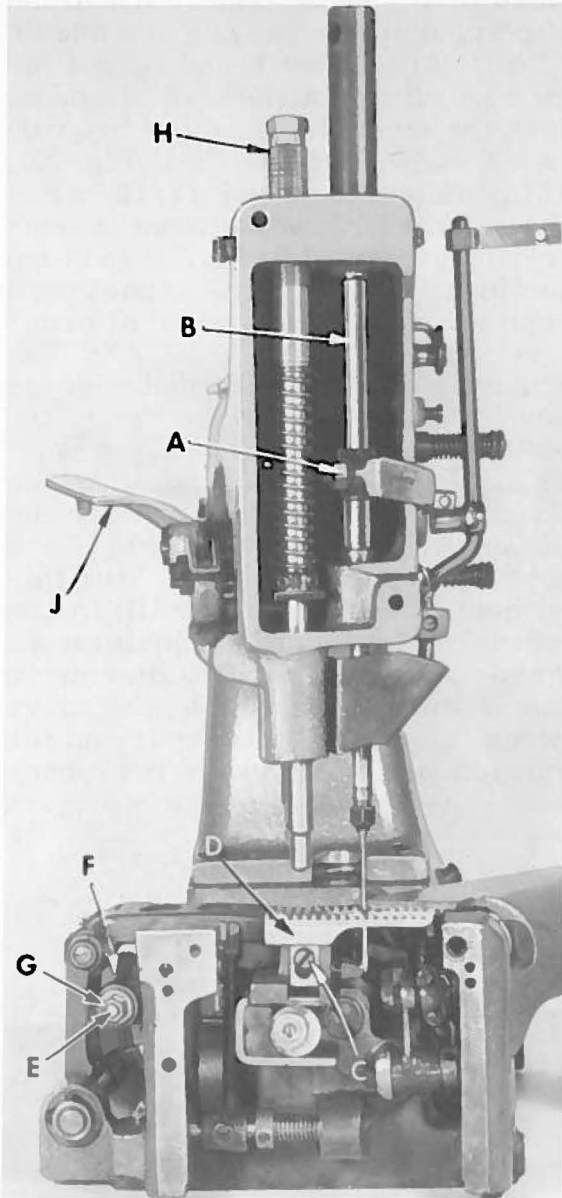


Fig. 5

and pressure released. The bars must move freely.

## PRESSER FOOT PRESSURE

Regulate the pressure on the presser foot using the presser spring regulators (H, Fig. 5) so that the springs exert a pressure sufficient to feed properly. A comparatively heavy pressure is usually required. There should be approximately  $\frac{1}{16}$  inch free play in the presser foot lifter lever (J, Fig. 5) when the presser foot is down.

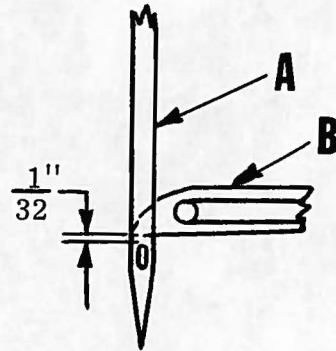


Fig. 4

(D, Fig. 5) and feed dog holding screw (C).

## CHANGING STITCH LENGTH

The length of the stitch can be adjusted by raising or lowering the stud (E, Fig. 5) in the segment slot of the feed rocker (F). This can be accomplished by loosening nut (G), lowering stud (E) will lengthen the stitch and raising the stud will shorten the stitch. When desired stitch length position is obtained, retighten nut (G).

NOTE: Any change in stitch length will necessitate a corresponding change in the feed bar needle guard setting.

## SETTING THE FEED BAR NEEDLE GUARD

Set the feed bar needle guard (C, Fig. 2) so that it barely contacts the needle at its most forward point of travel. Screw (A) secures it in place.

## SETTING HEIGHT OF PRESSER BAR

Check the vertical movement of the presser bars with the presser foot in position



## THREAD TENSIONS

The tension applied to the needle thread at (A, Fig. 6 and 6A) should be fairly strong. On Styles 80800 E and H, the tension applied to the looper thread at (B, Fig. 6) should be barely sufficient to steady it.

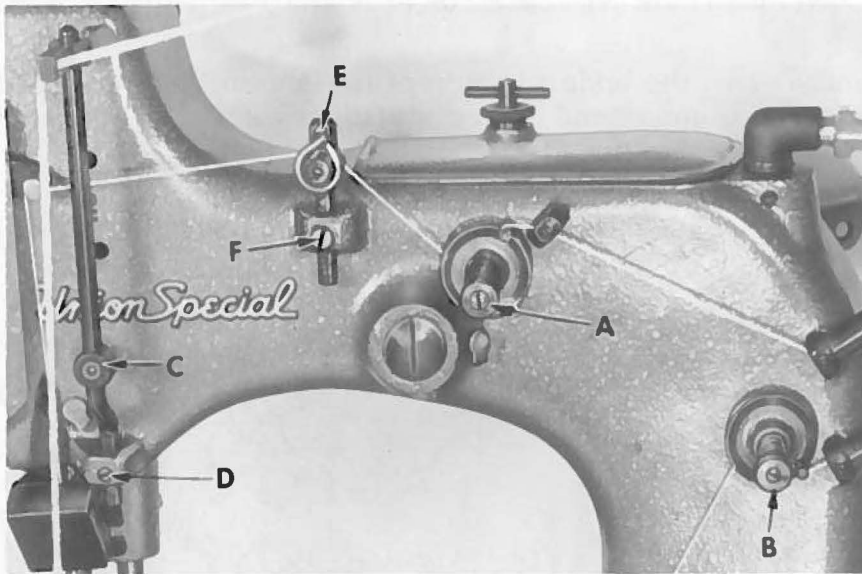


Fig. 6

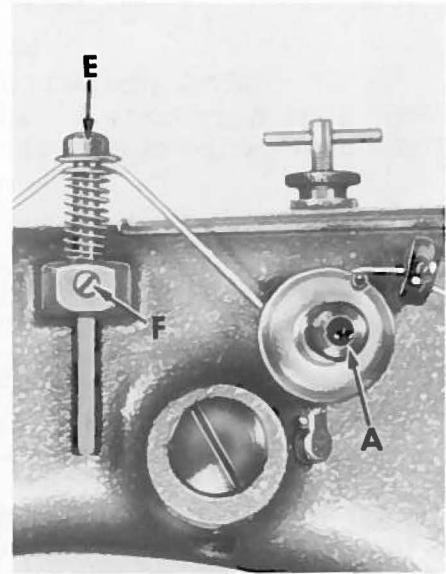


Fig. 6A

## LOOPER THREAD TAKE-UP

On Styles 80800 E and H, adjust the height of the looper thread take-up (A, Fig. 7) by loosening screw (B) so the point of the descending needle is approximately  $1/8$  inch below the lower edge of the looper at the time the cast-off forces the looper thread over the corner of the take-up. This adjustment can be made by drawing the looper thread into the machine and noting the location of the needle point at the time the cast-off forces the looper thread over the corner. Retighten screw.

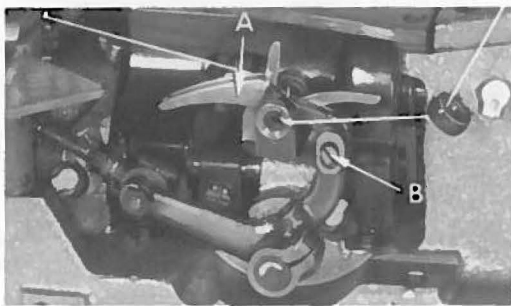


Fig. 7

## SETTING NEEDLE THREAD TAKE-UP ROLLER AND EYELET

On Styles 80800 E and H, adjust the height of the needle thread take-up roller (C, Fig. 6), which is secured by screw (D), so that the needle thread on the downstroke of the needle, contacts the roll at the time the needle loop is released from the looper.

On Style 80800 F, the needle thread take-up roller (C, Fig. 6) should be positioned so as not to contact the needle thread at anytime.

On Styles 80800 E and H, adjust the height of the vertical thread eyelet (E, Fig. 6) which is secured by screw (F), so that an equal quantity of needle thread is drawn through the needle thread tension discs on the up and down stroke of the needle.

## SETTING NEEDLE THREAD TAKE-UP ROLLER AND EYELET (Continued)

On Style 80800 F, adjust the tension on needle thread nipper (E, Fig. 6A) by loosening screw (F) and raising or lowering needle thread nipper support pin to increase or decrease tension as required to suit sewing conditions. Retighten screw (F).

## ADJUSTING KNIVES (FOR STYLES 80800 E and F)

The knives are set correctly when the upper corner of the driven knife overlaps the stationary knife 1/32 inch and the upper end of the stationary knife is even with the upper edge of the driven knife.

## ADJUSTING KNIVES AND TAPE CUTTER (FOR STYLE 80800 H)

To remove the tape cutter housing, turn the pulley in operating direction until the needle is at high position, move the cloth plate swinging extension out of operating position and remove the two tape cutter housing screws. Remove the housing and cloth plate, also remove the upper knife actuating shoe, presser foot, throat plate, feed dog and needle guard in the order named for convenient access.

Wrenches Nos. 116 and 21388C can be used advantageously for adjusting the hexagonal head screws used in the tape cutting mechanism.

With the throat plate temporarily laid in its seat, set the lower knife (A, Fig. 8) so that the cutting edge is even with the top of the throat plate (B) and tighten in this position with the hexagonal head screw (C). Reassemble needle guard, feed dog and throat plate.

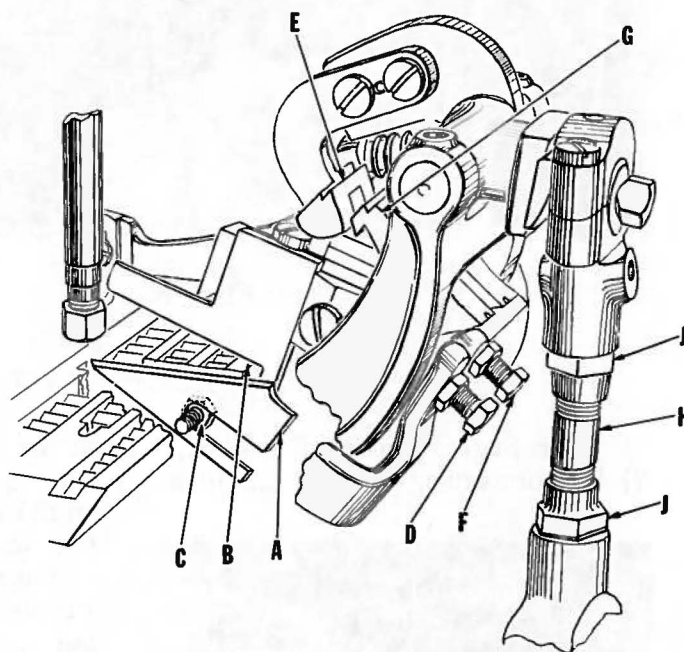


Fig. 8

Reassemble actuating shoe (A, Fig. 9). Loosen the hexagonal head adjusting screw (D, Fig. 8) and set, so that the bottom of the actuating shoe is even with the bottom of throat plate (B). Tighten locknut.

Insert upper knife (B, Fig. 9) in upper knife lever (C) and raise it as high as it will go. Tighten clamp screw (D), set stop screw (E) so that it contacts top of knife.

NOTE: As the knives (A, Fig. 8) and (B, Fig. 9) are resharpened, their adjustment is maintained by raising and lowering them in their holders.

Loosen screw (A, Fig. 10) and move shoe (B) to extreme left (or remove if desired). Turn handwheel until pawl (E, Fig. 8) is at its lowest position. Turn screw (F) until ratchet block (G) snaps over pawl (E), then add 1/4 to 1/2 turn more to insure adequate clearance under operating conditions. If screw is turned too far, the mechanism will not work.



## ADJUSTING KNIVES AND TAPE CUTTER (FOR STYLE 80800 H) (Continued)

If ratchet block and pawl will not engage, it may be necessary to adjust connecting rod (H, Fig. 8) by means of the locknuts (J). The correct center to center distance of the connecting rod should be 4 1/16 inch. Individual tape clippers may require slightly different settings due to slight accumulation of tolerances in manufacture.

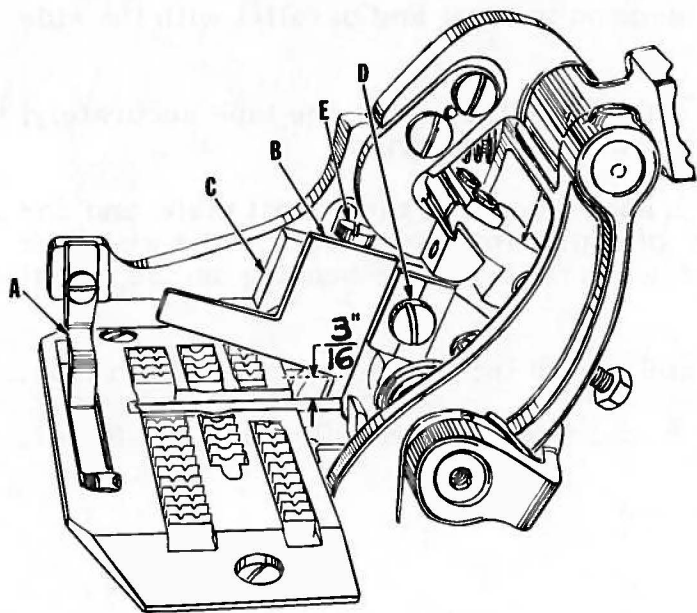


Fig. 9

The length at the finish is not adjustable.

The trip dog operating cam (E, Fig. 10) can be retarded or advanced to vary the length of the tape at the start of the closure. Loosen screws (F and G) and turn the operating cam toward the handwheel end of the machine to shorten the distance and in the opposite direction to lengthen the distance. The actuating shoe tension spring (H) is adjustable for various weights of material.

Attach cloth plate and tape cutter housing.

The folder, tape reel and filter cord stand are furnished as a separate unit under No. 21884 C. Their installation is shown on PL162. A wood core is provided for the roll of paper tape and a tension for controlling the tape.

Move shoe (B, Fig. 10) to right (or reassemble if it was removed) so that pawl (C) will rest on top of the extreme right end of shoe. Shoe should have polished end to the right and point of pawl may overlap slightly over outside to insure trigger action during operation of machine.

When actuating shoe (A, Fig. 9) is raised slightly, trip dog (D, Fig. 10) should allow pawl (C) to slide off shoe (B, Fig. 10) and knife should clip tape within 1 1/2 turns or less of the handwheel. Make sure that the knives engage for their full length. When open there should be about 3/16" opening at the pilot end of the knives (See Figure 9).

The position of the tape cutter actuating shoe (A, Fig. 9) controls the length of tape extending beyond the material at the start of the closure.

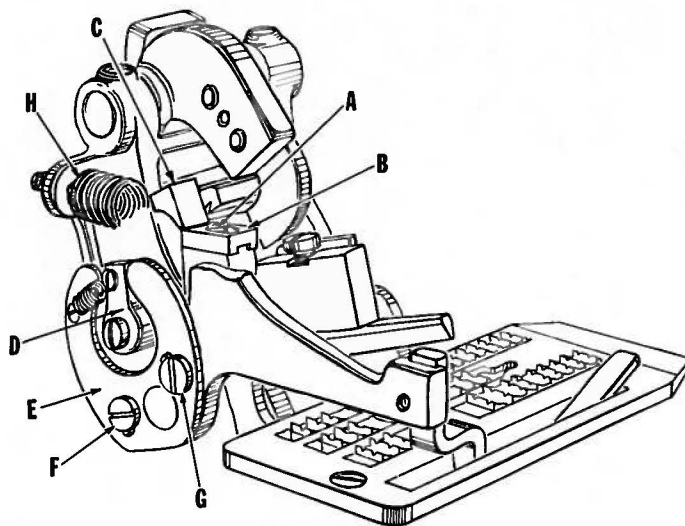


Fig. 10

## ADJUSTING KNIVES AND TAPE CUTTER (FOR STYLE 80800 H) (Continued)

A width of tape ranging from  $2 \frac{1}{8}$  to  $2 \frac{1}{2}$  inches can be used in the folder. It is adjusted to suit the widest width when it leaves the factory, consequently will have to be readjusted, if the tape used is less than  $2 \frac{1}{2}$  inches wide. This is accomplished by loosening the two hexagonal head bolts nearest the left end of the folder and moving the folder sections and resetting the tape guide collars.

The folder is set correctly when the following conditions prevail:

- (a) The upper surface of the middle section is level and parallel with the side of the conveyor belt.
- (b) The front and rear sections are set so that they guide the tape accurately, yet the tape passes freely and the two edges are even.
- (c) There is approximately  $\frac{1}{64}$  inch space between the throat plate and delivery end of folder and a space of approximately  $\frac{1}{32}$  inch between the delivery end and the presser foot when the latter is bearing on the throat plate.
- (d) The line of stitches is approximately  $\frac{5}{16}$  inch from the edge of the tape.
- (e) The tape guide collars are set to lead the tape centrally into the folder.



## ORDERING REPAIR PARTS

### ILLUSTRATIONS

This catalog has been arranged to simplify ordering repair parts. Exploded views of various sections of the mechanism are shown so that the parts may be seen in their actual position in the machine. On the page opposite the illustration will be found a listing of the parts with their part number, description, and the number of pieces required in the particular view being shown.

Numbers in the first column are reference numbers only, and merely indicate the position of that part in the illustration. Reference numbers should never be used in ordering parts. Always use the part number listed in the second column.

Component parts of sub-assemblies which can be furnished for repairs are indicated by indenting their descriptions under the description of the main sub-assembly. Example:

|    |         |                                                    |   |
|----|---------|----------------------------------------------------|---|
| 23 | 29442 P | Looper Drive Eccentric Assembly -----              | 1 |
| 24 | 80636 C | Looper Lever Connection -----                      | 1 |
| 25 | 88 F    | Screw, for looper lever connection -----           | 4 |
| 26 | 80649 A | Oil Felt Holder, for looper lever connection ----- | 1 |
| 27 | 660-90  | Felt Oil Wick -----                                | 1 |
| 28 | 80642   | Looper Drive Eccentric -----                       | 1 |
| 29 | 22894 L | Spot Screw -----                                   | 1 |
| 30 | 22894 C | Set Screw -----                                    | 1 |
| 31 | 80645   | Looper Drive Ball Stud -----                       | 1 |
| 32 | 80636 A | Ball Fork, for looper drive ball stud -----        | 1 |
| 33 | 22515 A | Screw, for ball fork -----                         | 1 |

It will be noted in the above example that the bearing is not listed. The reason is that replacement of this part individually is not recommended, so complete sub-assembly should be ordered.

At the back of the book will be found a numerical index of all the parts shown in this book. This will facilitate locating the illustration and description when only the part number is known.

### IDENTIFYING PARTS

Where the construction permits, each part is stamped with its part number. On some of the smaller parts, and on those where the construction does not permit, an identification letter is stamped in to distinguish the part from similar ones.

Part numbers represent the same part, regardless of the catalog in which they appear.

**IMPORTANT! ON ALL ORDERS, PLEASE INCLUDE PART NAME AND STYLE OF MACHINE FOR WHICH PART IS ORDERED.**

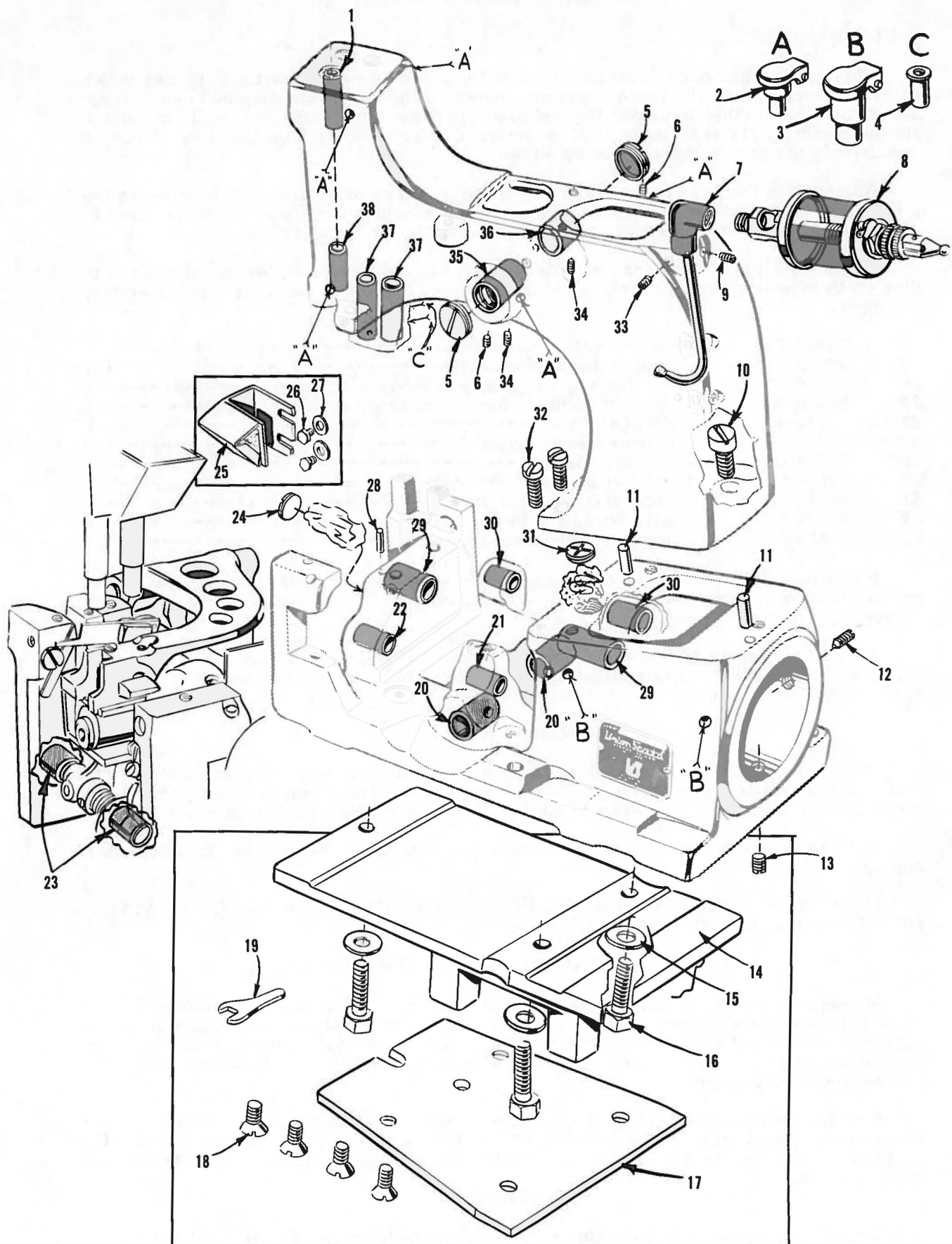
### USE GENUINE NEEDLES AND REPAIR PARTS

Success in the operation of these machines can be secured only with genuine UNION SPECIAL Needles and Repair Parts as furnished by the Union Special Corporation, its subsidiaries and authorized distributors. They are designed according to the most approved scientific principles, and are made with utmost precision. Maximum efficiency and durability are assured.

Genuine needles are packaged with labels marked *Union Special*. Genuine repair parts are stamped with a reproduction of the familiar Union Special trademark, U S Emblem. Each trademark is your guarantee of the highest quality in materials and workmanship.

### TERMS

Prices are net cash and are subject to change without notice. All shipments are forwarded f.o.b. shipping point. Parcel Post shipments are insured unless otherwise directed. A charge is made to cover postage and insurance.

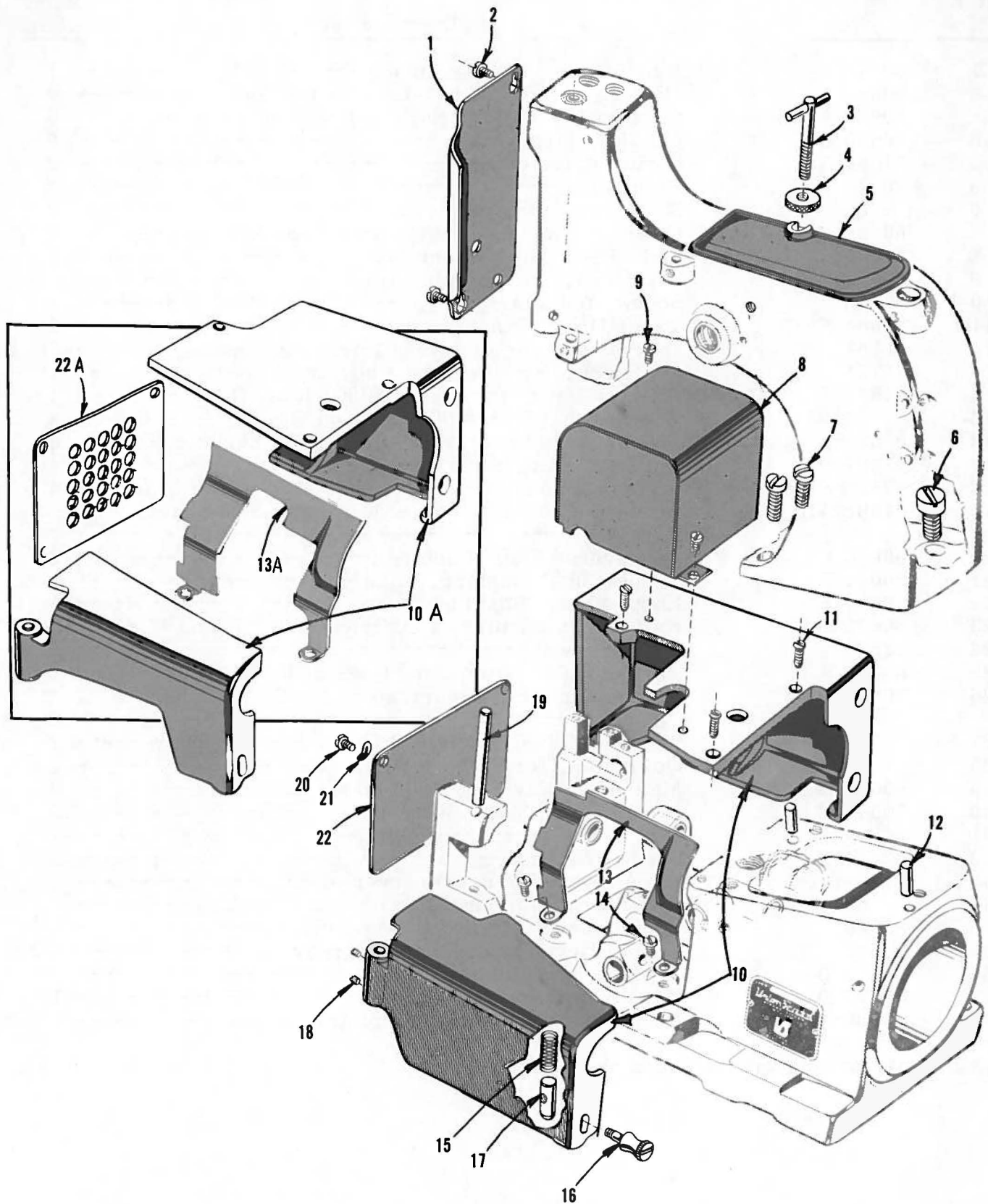




# MAIN FRAME, BUSHINGS, OILING PARTS AND BASE PLATE

| <u>Ref.<br/>No.</u> | <u>Part<br/>No.</u> | <u>Description</u>                                              | <u>Amt.<br/>Req.</u> |
|---------------------|---------------------|-----------------------------------------------------------------|----------------------|
| 1                   | 80673 E             | Needle Bar Bushing, upper -----                                 | 1                    |
| 2                   | 80689 A             | Oil Cup, small, for Styles 80800 E and F -----                  | 9                    |
| -                   | 80689 A             | Oil Cup, small, for Style 80800 H only -----                    | 6                    |
| 3                   | 80690 A             | Oil Cup, large-----                                             | 2                    |
| 4                   | 41046 G             | Spring Valve Oiler -----                                        | 2                    |
| 5                   | 80644               | Plug Screw-----                                                 | 2                    |
| 6                   | 88                  | Set Screw, for plug screw -----                                 | 2                    |
| 7                   | 80898               | Oiler, for needle lever connection bearing -----                | 1                    |
| 8                   | 666-79              | Sight Feed Oiler Assembly -----                                 | 1                    |
| 9                   | 22894 J             | Set Screw, for needle lever oiler -----                         | 1                    |
| 10                  | 99256               | Screw, for arm -----                                            | 1                    |
| 11                  | 664 F-16            | Taper Dowel Pin -----                                           | 2                    |
| 12                  | HA81                | Spot Screw, for crankshaft bearing housing -----                | 1                    |
| 13                  | HA95                | Set Screw, for crankshaft bearing housing -----                 | 1                    |
| *14                 | 11667 V             | Adapter Base, for Styles 80800 E and F -----                    | 1                    |
| *15                 | 652-24              | Washer, for Styles 80800 E and F -----                          | 3                    |
| *16                 | 22639 B             | Screw, for adapter base, for Styles 80800 E and F -             | 3                    |
| *17                 | 11667 K             | Adapter Plate, for Styles 80800 E and F -----                   | 1                    |
| *18                 | 22638 B             | Screw, for adapter plate, for Styles 80800 E and F -            | 4                    |
| 19                  | 21388 AH            | Wrench, 1/4 inch open end, for Styles 80800 E<br>and F -----    | 1                    |
| 20                  | 80640 E             | Transverse Shaft Bushing-----                                   | 2                    |
| 21                  | 80639 F             | Looper Shaft Bushing, right-----                                | 1                    |
| 22                  | 80639 E             | Looper Shaft Bushing, left-----                                 | 1                    |
| 23                  | 80692 D             | Knife Shaft Bushing, for Styles 80800 E and F -----             | 2                    |
| 24                  | 22539               | Plug Screw-----                                                 | 1                    |
| 25                  | 80698 A             | Thread Lubricator, for Styles 80800 E and F -----               | 1                    |
| 26                  | 79048               | Screw, for thread lubricator, for Styles 80800 E<br>and F ----- | 2                    |
| 27                  | 69 H                | Washer, for Styles 80800 E and F -----                          | 2                    |
| 28                  | 50-430 Blk.         | Dowel Pin, for Style 80800 H only -----                         | 2                    |
| 29                  | 80694 D             | Main Shaft Bushing, left and middle-----                        | 2                    |
| 30                  | 80692 E             | Feed Rocker Shaft Bushing -----                                 | 2                    |
| 31                  | 22539               | Plug Screw-----                                                 | 1                    |
| 32                  | 22814 B             | Screw, for arm-----                                             | 2                    |
| 33                  | 22894 J             | Set Screw, for needle lever oiler -----                         | 1                    |
| 34                  | 89                  | Spot Screw, for needle lever shaft bushings-----                | 2                    |
| 35                  | 80646               | Needle Lever Shaft Bushing, front -----                         | 1                    |
| 36                  | 80647               | Needle Lever Shaft Bushing, rear -----                          | 1                    |
| 37                  | 80662 B             | Presser Bar Bushing, lower -----                                | 2                    |
| 38                  | 80673 D             | Needle Bar Bushing, lower -----                                 | 1                    |
| -                   | 660-457             | Dust Cover (not shown on picture plate) -----                   | 1                    |

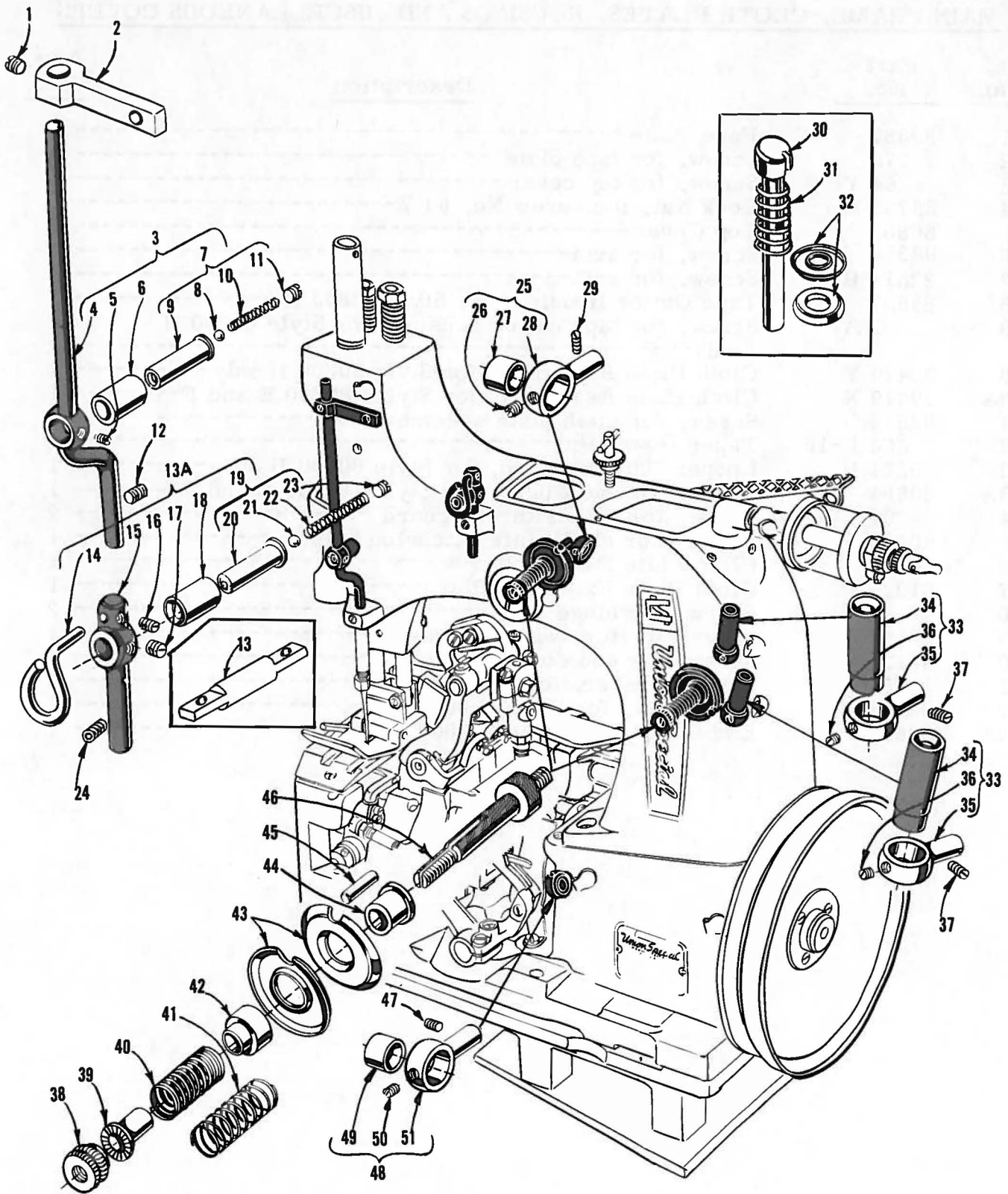
\* Available as an extra send and charge item.





# MAIN FRAME, CLOTH PLATES, HOUSINGS AND MISCELLANEOUS COVERS

| <u>Ref.<br/>No.</u> | <u>Part<br/>No.</u> | <u>Description</u>                                              | <u>Amt.<br/>Req.</u> |
|---------------------|---------------------|-----------------------------------------------------------------|----------------------|
| 1                   | 80887               | Face Plate -----                                                | 1                    |
| 2                   | 376                 | Screw, for face plate -----                                     | 2                    |
| 3                   | 64 Y                | Screw, for top cover -----                                      | 1                    |
| 4                   | 35733 B             | Lock Nut, for screw No. 64 Y -----                              | 1                    |
| 5                   | 80888               | Top Cover -----                                                 | 1                    |
| 6                   | 99256               | Screw, for arm -----                                            | 1                    |
| 7                   | 22814 B             | Screw, for arm -----                                            | 2                    |
| 8                   | 80897               | Tape Cutter Housing, for Style 80800 H -----                    | 1                    |
| 9                   | 93 A                | Screw, for tape cutter housing, for Style 80800 H<br>only ----- | 2                    |
| 10                  | 29479 Y             | Cloth Plate Assembly, for Style 80800 H only -----              | 1                    |
| 10A                 | 29479 X             | Cloth Plate Assembly, for Styles 80800 E and F -----            | 1                    |
| 11                  | 22574               | Screw, for cloth plate assembly -----                           | 3                    |
| 12                  | 664 F-16            | Taper Dowel Pin -----                                           | 2                    |
| 13                  | 80284 H             | Looper Thread Guard, for Style 80800 H only -----               | 1                    |
| 13A                 | 80684               | Looper Thread Guard, for Styles 80800 E and F -----             | 1                    |
| 14                  | 94                  | Screw, for looper thread guard -----                            | 2                    |
| 15                  | 80438               | Spring, for cloth plate extension bolt -----                    | 1                    |
| 16                  | 80440               | Cloth Plate Bolt Knob -----                                     | 1                    |
| 17                  | 81239               | Cloth Plate Extension Bolt -----                                | 1                    |
| 18                  | 89                  | Screw, for hinge pin -----                                      | 2                    |
| 19                  | 8564                | Hinge Pin, for swing-out cover -----                            | 1                    |
| 20                  | 92121               | Screw, for end cover -----                                      | 1                    |
| 21                  | 12957 E             | Spring Washer, for end cover -----                              | 1                    |
| 22                  | 80683 H             | End Cover, for Style 80800 H only -----                         | 1                    |
| 22A                 | 80683               | End Cover, for Styles 80800 E and F -----                       | 1                    |



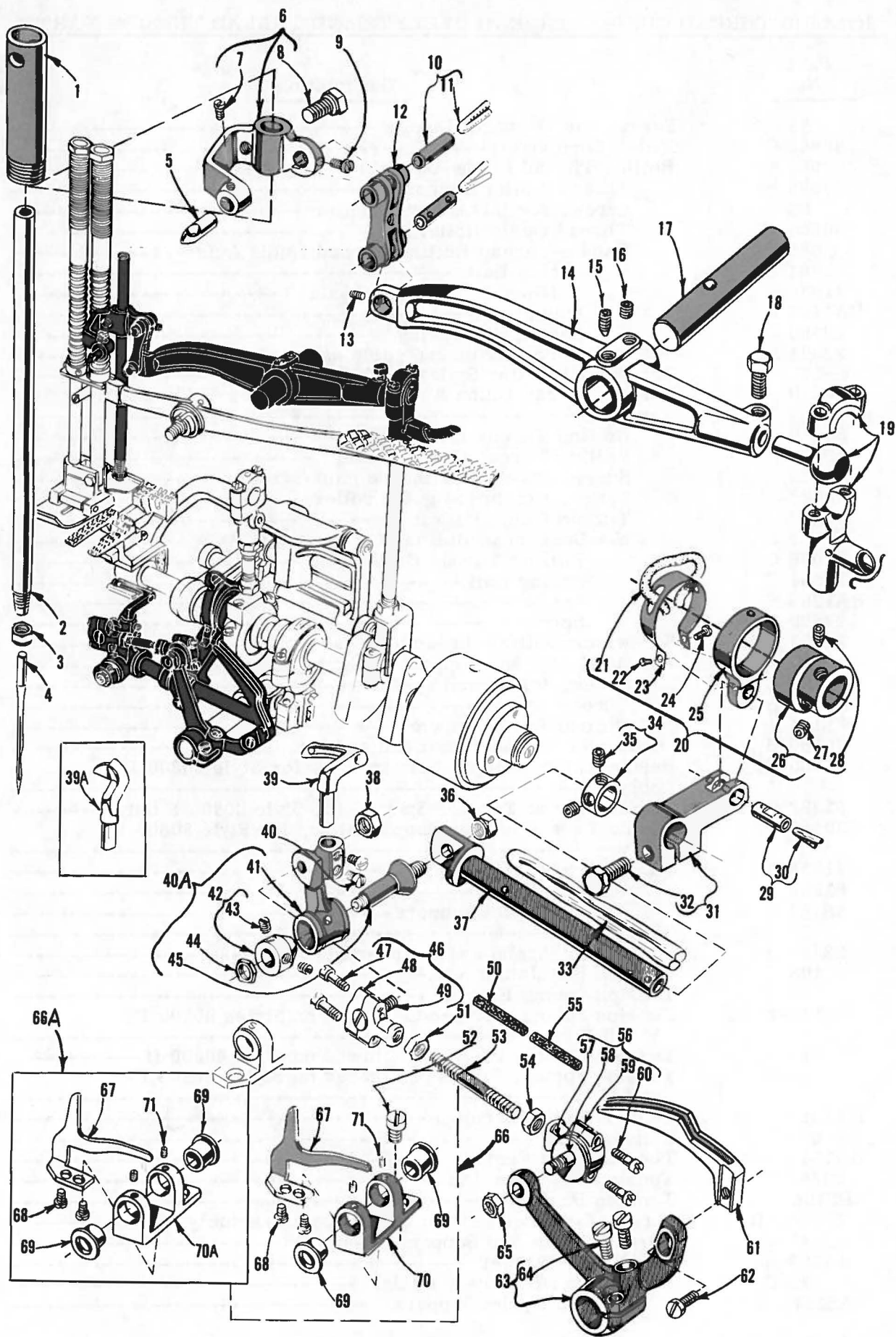


# ROLLING THREAD GUIDES, THREAD EYELETS AND THREAD TENSION PARTS

| Ref.<br>No. | Part<br>No. | Description                                                           | Amt.<br>Req. |
|-------------|-------------|-----------------------------------------------------------------------|--------------|
| 1           | 88          | Screw, for filter cord guide -----                                    | 1            |
| 2           | 80665 C     | Filter Cord Guide -----                                               | 1            |
| 3           | 80665 A     | Rolling Thread Guide Assembly -----                                   | 1            |
| 4           | 80665 B     | Thread Roller Support -----                                           | 1            |
| 5           | 88          | Screw, for thread guide roller -----                                  | 1            |
| 6           | 80668       | Thread Guide Roller -----                                             | 1            |
| 7           | HS53 B      | Needle Thread Rolling Thread Guide Axle -----                         | 1            |
| 8           | 12964 C     | Spring Ball -----                                                     | 1            |
| 9           | 81086 G     | Rolling Thread Guide Axle -----                                       | 1            |
| 10          | HA1286 B    | Spring -----                                                          | 1            |
| 11          | 22560       | Screw, for spring -----                                               | 1            |
| 12          | 22894 AD    | Screw, for rolling thread guide assembly -----                        | 1            |
| 13          | G-111       | Thread Guide, for Styles 80800 E and H -----                          | 1            |
| *13A        | 80250       | Rolling Thread Guide Assembly, for Styles 80800 E and<br>and H -----  | 1            |
| 14          | 80250 B     | Rolling Thread Guide Wire -----                                       | 1            |
| 15          | 80250 A     | Rolling Thread Guide Holder -----                                     | 1            |
| 16          | 22743       | Screw, for rolling thread guide wire -----                            | 1            |
| 17          | 88          | Screw, for thread guide roller -----                                  | 1            |
| 18          | 80668       | Thread Guide Roller -----                                             | 1            |
| 19          | HS52 B      | Needle Thread Rolling Thread Guide Axle -----                         | 1            |
| 20          | 81086 C     | Rolling Thread Guide Axle -----                                       | 1            |
| 21          | 12964 C     | Spring Ball -----                                                     | 1            |
| 22          | HA1286 B    | Spring -----                                                          | 1            |
| 23          | 22560       | Screw -----                                                           | 1            |
| 24          | 22894 AD    | Screw, for rolling thread guide assembly -----                        | 1            |
| 25          | AS137 A     | Thread Eyelet and Support Assembly -----                              | 1            |
| 26          | 28 C        | Screw, for thread eyelet -----                                        | 1            |
| 27          | HA103 B     | Thread Eyelet -----                                                   | 1            |
| 28          | AS137       | Thread Eyelet Support -----                                           | 1            |
| 29          | 22560 B     | Screw, for thread eyelet and support assembly -----                   | 1            |
| 30          | 80665 E     | Needle Thread Nipper Support Pin, for Style 80800 F<br>only -----     | 1            |
| 31          | 51292 F-4   | Needle Thread Tension Spring, for Style 80800 F only -----            | 1            |
| 32          | 80665 F     | Needle Thread Nipper Support Disc, for Style 80800 F<br>only -----    | 2            |
| 33          | 81256 A     | Thread Eyelet Assembly -----                                          | 2            |
| 34          | 81256       | Thread Sleeve -----                                                   | 1            |
| 35          | AS137       | Thread Eyelet Support -----                                           | 1            |
| 36          | 28 C        | Screw -----                                                           | 1            |
| 37          | 22560 B     | Screw, for thread eyelet assembly -----                               | 2            |
| 38          | 108         | Tension Regulating Nut -----                                          | 2            |
| 39          | 107         | Tension Spring Ferrule -----                                          | 2            |
| 40          | 110-4       | Tension Spring, for needle thread on Styles 80800 E,<br>F and H ----- | 1            |
| 41          | 110-3       | Tension Spring, for looper thread on Style 80800 H -----              | 1            |
| -           | 110-2       | Tension Spring, for looper thread on Styles 80800 E<br>and F -----    | 1            |
| 42          | HA1349      | Tension Post Ferrule -----                                            | 2            |
| 43          | 80676 A     | Tension Disc -----                                                    | 4            |
| 44          | HA1348      | Tension Post Ferrule -----                                            | 2            |
| 45          | 80667       | Tension Disc Stop Pin -----                                           | 2            |
| 46          | HS106       | Tension Post -----                                                    | 2            |
| 47          | 22894 AD    | Screw, for thread eyelet and support assembly -----                   | 1            |
| 48          | AS137 A     | Thread Eyelet and Support Assembly -----                              | 1            |
| 49          | HA103 B     | Thread Eyelet -----                                                   | 1            |
| 50          | 28 C        | Screw, for thread eyelet -----                                        | 1            |
| 51          | AS137       | Thread Eyelet Support -----                                           | 1            |

\* Replaced by Ref. No 13 on late model machines.





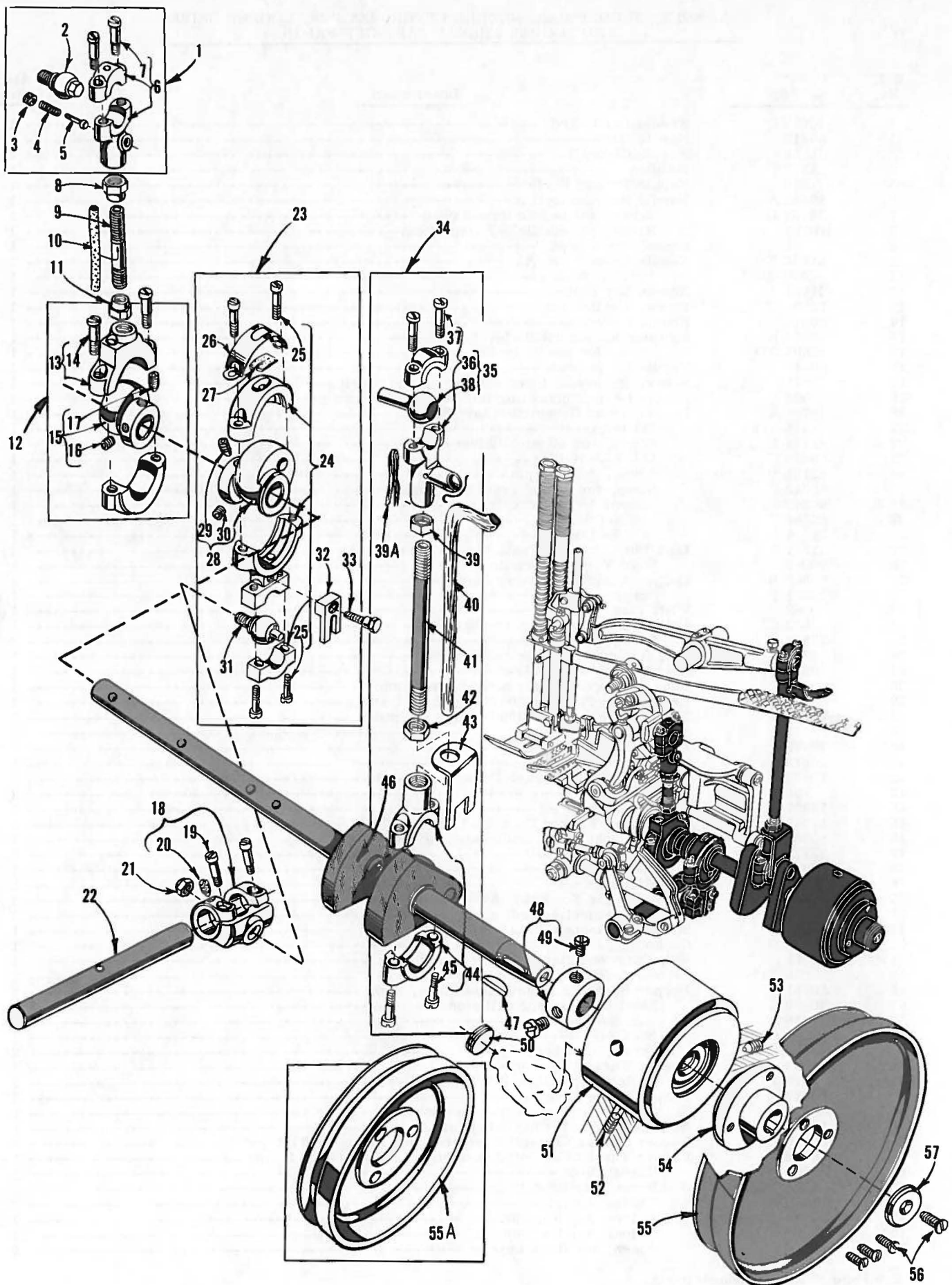


NEEDLE, NEEDLE BAR, NEEDLE LEVER, LOOPER, LOOPER DRIVE  
AND LOOPER THREAD CAST-OFF PARTS

| Ref.<br>No. | Part<br>No. | Description                                                     | Amt.<br>Req. |
|-------------|-------------|-----------------------------------------------------------------|--------------|
| 1           | 80673 C     | Needle Bar Guard -----                                          | 1            |
| 2           | 80617       | Needle Bar -----                                                | 1            |
| 3           | HA56        | Needle Clamp Nut -----                                          | 1            |
| 4           | 1975 G      | Needle -----                                                    | 1            |
| 5           | 334         | Needle Thread Eyelet-----                                       | 1            |
| 6           | 80659 A     | Needle Bar Connection-----                                      | 1            |
| 7           | 22564 D     | Screw, for needle thread eyelet-----                            | 1            |
| 8           | BP108       | Screw, for needle bar connection-----                           | 1            |
| 9           | 91          | Screw, for link pin -----                                       | 1            |
| 10          | 51134 V     | Needle Lever Link Pin-----                                      | 2            |
| 11          | 666-260     | Felt Oil Wick -----                                             | 1            |
| 12          | HA54 A      | Needle Bar Link-----                                            | 1            |
| 13          | 22565 C     | Screw, for link pin -----                                       | 1            |
| 14          | 80615       | Needle Lever -----                                              | 1            |
| 15          | 22894 K     | Spot Screw, for needle lever-----                               | 1            |
| 16          | 22894 AD    | Set Screw, for needle lever-----                                | 1            |
| 17          | 80643       | Needle Lever Shaft -----                                        | 1            |
| 18          | 22811       | Screw, for needle lever connecting rod bearing-----             | 1            |
| *19         | 29066 U     | Needle Lever Connecting Rod Bearing Assembly-----               | 1            |
| 20          | 29793 A     | Looper Avoid Eccentric Assembly -----                           | 1            |
| 21          | 666-149     | Oil Wick-----                                                   | 1            |
| 22          | 22738 B     | Screw, for oil wick holder-----                                 | 1            |
| 23          | 80649 C     | Oil Wick Holder -----                                           | 1            |
| 24          | 22768 B     | Screw, for link pin -----                                       | 1            |
| 25          | 80642 C     | Strap, for looper avoid eccentric-----                          | 1            |
| 26          | 80842       | Looper Avoid Eccentric -----                                    | 1            |
| 27          | 22894 C     | Set Screw-----                                                  | 1            |
| 28          | 22894 L     | Spot Screw-----                                                 | 1            |
| 29          | 51236 A     | Link Pin, for looper avoid eccentric assembly-----              | 1            |
| 30          | WO-2        | Wool Yarn, 2 strands -----                                      | 1            |
| 31          | 80642 B     | Looper Avoid Connecting Link -----                              | 1            |
| 32          | 22811 B     | Screw -----                                                     | 1            |
| 33          | WO-3        | Wool Yarn -----                                                 | 1            |
| 34          | 482 C       | Collar, for looper rocker shaft -----                           | 1            |
| 35          | 22894 C     | Screw, for collar-----                                          | 2            |
| 36          | 1280        | Nut, for looper rocker assembly-----                            | 1            |
| 37          | 80639       | Looper Rocker Shaft-----                                        | 1            |
| 38          | 18          | Nut, for looper rocker ball joint assembly -----                | 1            |
| 39          | AS26 XA     | Looper, for Styles 80800 E and H, 401 stitch-----               | 1            |
| 39A         | 80608 A     | Looper, for Style 80800 F only, 101 stitch -----                | 1            |
| 40          | 73          | Screw, for looper -----                                         | 2            |
| 40A         | 29479       | Looper Rocker Assembly-----                                     | 1            |
| 41          | 80613 A     | Looper Rocker -----                                             | 1            |
| 42          | 15465 F     | Differential Rocker Cone -----                                  | 1            |
| 43          | 88          | Screw -----                                                     | 2            |
| 44          | 12987 A     | Check Nut -----                                                 | 1            |
| 45          | 15745 B     | Looper Rocker Cone Stud, marked "A"-----                        | 1            |
| 46          | 80657 A     | Looper Rocker Ball Joint Assembly, left -----                   | 1            |
| 47          | 22729 C     | Screw, for shell-----                                           | 2            |
| 48          | 6040 A      | Shell -----                                                     | 1            |
| 49          | 237 A       | Ball Stud -----                                                 | 1            |
| 50          | 666-149     | Oil Wick, for No. 80657 A-----                                  | 1            |
| 51          | 269         | Nut, for connecting rod, right hand thread -----                | 1            |
| 52          | HA61 D      | Screw, for looper thread cast-off assembly -----                | 1            |
| 53          | 41331 G     | Connecting Rod-----                                             | 1            |
| 54          | 18          | Nut, for connecting rod, left hand thread -----                 | 1            |
| 55          | 666-149     | Oil Wick, for No. 80641 B-----                                  | 1            |
| 56          | 80641 B     | Looper Rocker Ball Joint Assembly, right -----                  | 1            |
| 57          | HS-36 K     | Steel Washer, for ball stud-----                                | 1            |
| 58          | 36 E        | Ball Stud -----                                                 | 1            |
| 59          | 35841 C     | Shell -----                                                     | 1            |
| 60          | 22729 C     | Screw, for shell-----                                           | 2            |
| 61          | 80623       | Looper Thread Take-up-----                                      | 1            |
| 62          | J79 J       | Screw, for looper thread take-up-----                           | 1            |
| 63          | 80637       | Looper Drive Lever -----                                        | 1            |
| 64          | 22517       | Screw, for looper drive lever-----                              | 2            |
| 65          | 12538       | Nut, for looper rocker ball joint assembly -----                | 1            |
| 66          | 80653 A     | Looper Thread Cast-off Assembly, for Styles 80800 E and F ----- | 1            |
| 66A         | 80653 I     | Looper Thread Cast-off Assembly, for Style 80800 H only -----   | 1            |
| 67          | 80604       | Thread Hook -----                                               | 1            |
| 68          | AS22 D      | Screw, for thread hook-----                                     | 2            |
| 69          | HA102 A     | Thread Eyelet-----                                              | 2            |
| 70          | 80653       | Holder, for No. 80653 A -----                                   | 1            |
| 70A         | 80653 H     | Holder, for No. 80653 I -----                                   | 1            |
| 71          | 22743       | Screw, for thread eyelet -----                                  | 2            |

\* See Page 23 for component parts.

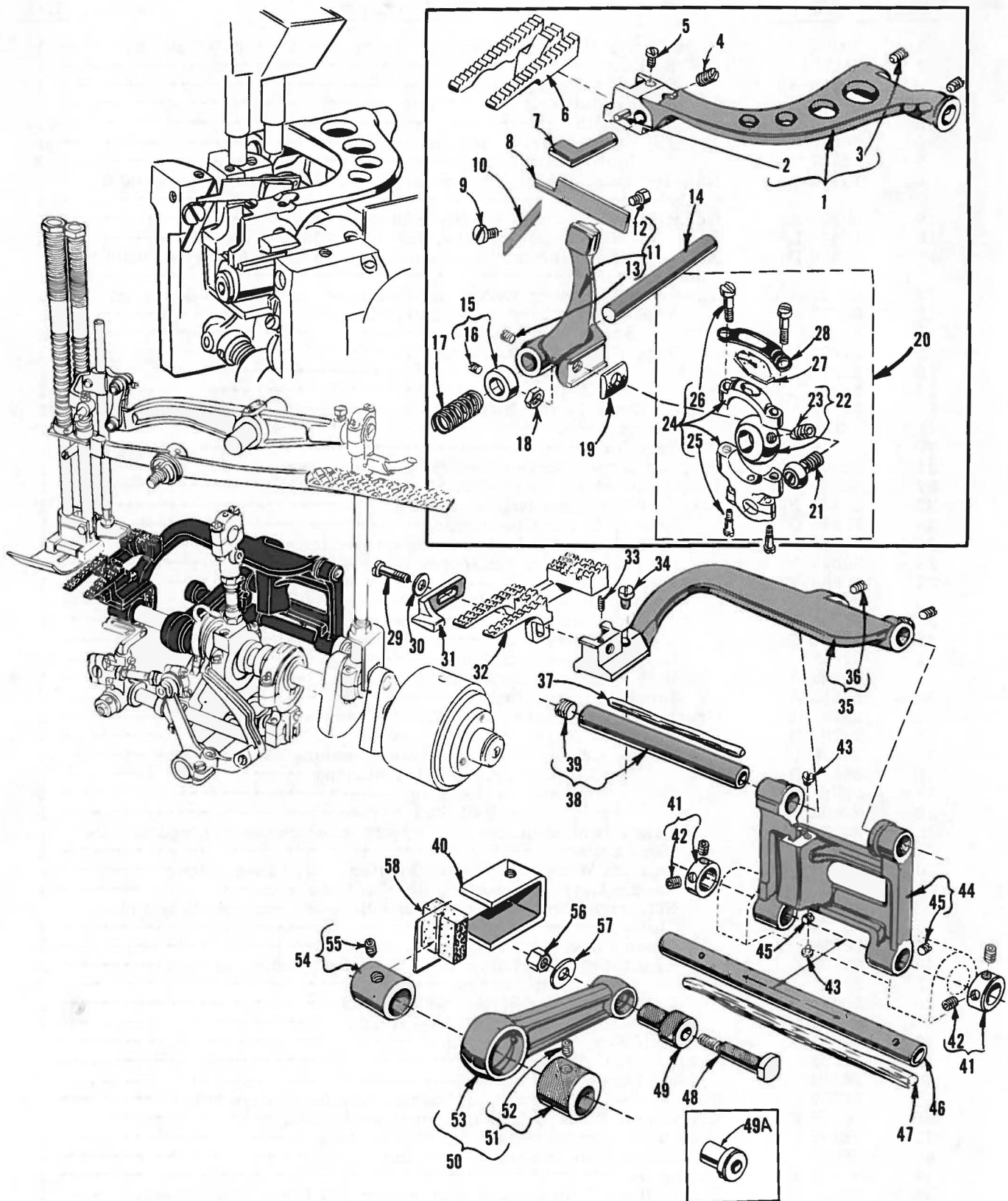






TAPE CUTTER DRIVE, LOOPER DRIVE, CRANKSHAFT ASSEMBLY  
AND PULLEY RIM

| Ref.<br>No. | Part<br>No. | Description                                                                      | Amt.<br>Req. |
|-------------|-------------|----------------------------------------------------------------------------------|--------------|
| 1           | 29139 E     | Tape Cutter Bearing Assembly, upper, for Style 80800 H only-----                 | 1            |
| 2           | G21710      | Ball Stud -----                                                                  | 1            |
| 3           | 22586 A     | Screw, for spring pin -----                                                      | 1            |
| 4           | 1230 B      | Spring, for pin -----                                                            | 1            |
| 5           | 1230 D      | Spring Pin -----                                                                 | 1            |
| 6           | 80630 E     | Tape Cutter Drive Bearing -----                                                  | 1            |
| 7           | 22587       | Screw, for bearing -----                                                         | 2            |
| 8           | 15430 C     | Nut, left hand thread, for connecting rod tube, for Style 80800 H<br>only -----  | 1            |
| 9           | 80230       | Connecting Rod Tube, for Style 80800 H only -----                                | 1            |
| 10          | 15430 L     | Felt, for connecting rod tube, for Style 80800 H only -----                      | 1            |
| 11          | 15430 D     | Nut, right hand thread, for connecting rod tube, for Style 80800 H<br>only ----- | 1            |
| 12          | 29132 AG    | Tape Cutter Driving Eccentric Assembly, for Style 80800 H only ---               | 1            |
| 13          | 80630 F     | Tape Cutter Driving Eccentric Bearing -----                                      | 1            |
| 14          | 22587       | Screw, for bearing -----                                                         | 2            |
| 15          | 21703 L     | Tape Cutter Driving Eccentric -----                                              | 1            |
| 16          | 22894 C     | Set Screw -----                                                                  | 1            |
| 17          | 22894 L     | Spot Screw -----                                                                 | 1            |
| 18          | 80638 A     | Looper Drive Lever Shaft Rocker -----                                            | 1            |
| 19          | 136         | Clamp Screw -----                                                                | 2            |
| 20          | 96          | Spot Screw -----                                                                 | 1            |
| 21          | 80691       | Nut, for looper drive eccentric ball stud -----                                  | 1            |
| 22          | 80640       | Looper Drive Lever Rocker Shaft -----                                            | 1            |
| 23          | 29442 P     | Looper Drive Eccentric Assembly -----                                            | 1            |
| 24          | 80636 C     | Looper Lever Connection -----                                                    | 1            |
| 25          | 88 F        | Screw, for looper lever connection -----                                         | 4            |
| 26          | 80649 A     | Oil Felt Holder, for looper lever connection-----                                | 1            |
| 27          | 660-90      | Felt Oil Wick -----                                                              | 1            |
| 28          | 80642       | Looper Drive Eccentric -----                                                     | 1            |
| 29          | 22894 L     | Spot Screw -----                                                                 | 1            |
| 30          | 22894 C     | Set Screw -----                                                                  | 1            |
| 31          | 80645       | Looper Drive Ball Stud-----                                                      | 1            |
| 32          | 80636 A     | Ball Fork, for looper drive ball stud -----                                      | 1            |
| 33          | 22515 A     | Screw, for ball fork -----                                                       | 1            |
| 34          | 29781 A     | Crankshaft Eccentric Assembly, for Styles 80800 E and F -----                    | 1            |
| -           | 29781 B     | Crankshaft Eccentric Assembly, for Style 80800 H only -----                      | 1            |
| 35          | 29066 U     | Needle Lever Connection Upper Bearing Assembly -----                             | 1            |
| 36          | 80650 B     | Needle Lever Connection Bearing -----                                            | 1            |
| 37          | 22587       | Screw, for bearing -----                                                         | 2            |
| 38          | 80656 A     | Needle Lever Ball Stud -----                                                     | 1            |
| 39          | 80630 C     | Nut, left hand thread, for needle lever connecting rod oil tube--                | 1            |
| 39A         | WO-3        | Wool Yarn -----                                                                  | 1            |
| 40          |             | Felt Oil Wick, 3/16 inch diameter, 7 1/4 inches long-----                        | 1            |
| 41          | 80630       | Needle Lever Connecting Rod Oil Tube -----                                       | 1            |
| 42          | 80630 D     | Nut, right hand thread, for needle lever connecting rod oil<br>tube -----        | 1            |
| 43          | 80636 B     | Guide Fork, for crankshaft bearing-----                                          | 1            |
| 44          | 80652 A     | Crankshaft Bearing, for crankshaft eccentric assembly-----                       | 1            |
| 45          | 22587       | Screw, for bearing -----                                                         | 2            |
| 46          | 80622 B     | Crankshaft, for Styles 80800 E and F -----                                       | 1            |
| -           | 80622 A     | Crankshaft, for Style 80800 H only -----                                         | 1            |
| 47          | HA66 K      | Woodruff Key, for pulley hub -----                                               | 1            |
| 48          | 80681       | Crankshaft Collar -----                                                          | 1            |
| 49          | 22891       | Set Screw -----                                                                  | 2            |
| 50          | 22539       | Plug Screw, for crankshaft bearing housing sponge hole -----                     | 1            |
| 51          | 80685 E     | Crankshaft Bearing Housing, includes bushing -----                               | 1            |
| 52          | HA95        | Set Screw, for crankshaft bearing housing -----                                  | 1            |
| 53          | HA81        | Spot Screw, for crankshaft bearing housing-----                                  | 1            |
| 54          | 80621 A     | Pulley Hub -----                                                                 | 1            |
| 55          | 80821 H     | Pulley Rim, 6 inch working diameter, for Style 80800 H only -----                | 1            |
| 55A         | 80821 B     | Pulley Rim, 4 1/4 inch working diameter, for Styles 80800 E<br>and F -----       | 1            |
| 56          | 80          | Screw, for lock washer and pulley rim -----                                      | 4            |
| 57          | 80674       | Lock Washer, for pulley hub-----                                                 | 1            |

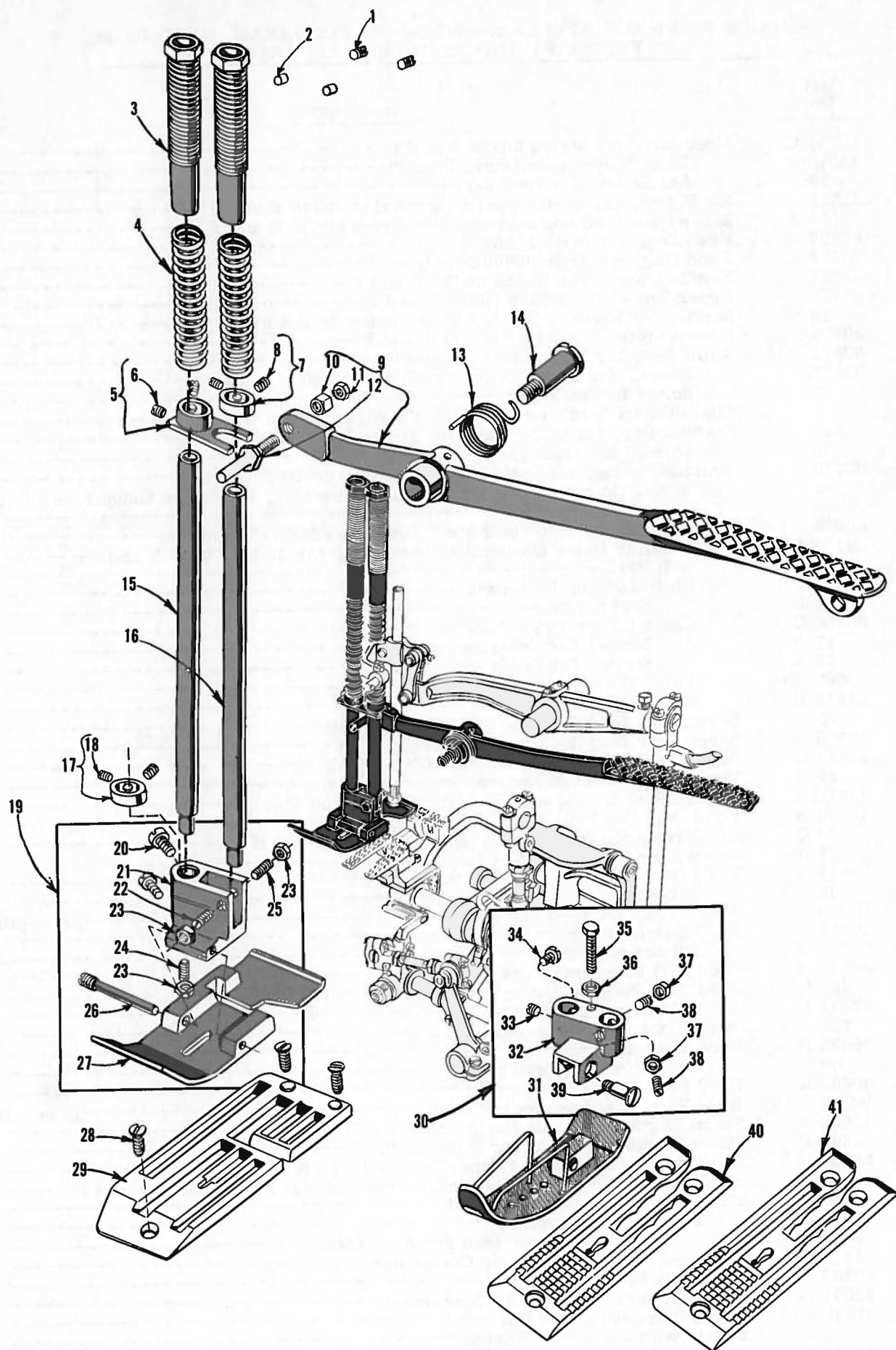




**KNIFE DRIVE FOR STYLES 80800 E and F, FEED DOGS, FEED BARS,  
FEED LIFT AND FEED DRIVING PARTS**

| Ref.<br>No. | Part<br>No. | Description                                                                       | Amt.<br>Req. |
|-------------|-------------|-----------------------------------------------------------------------------------|--------------|
| 1           | 80634 C     | Feed Bar, for Styles 80800 E and F-----                                           | 1            |
| 2           | 80699 B     | Feed Bar Needle Guard Stop Pin-----                                               | 1            |
| 3           | 89          | Set Screw, for feed bar-----                                                      | 2            |
| 4           | HA95        | Set Screw, for needle guard, for Styles 80800 E and F-----                        | 1            |
| 5           | 97 X        | Screw, for feed dog support, for Styles 80800 E and F-----                        | 1            |
| 6           | 80605 E     | Feed Dog, for Style 80800 E only-----                                             | 1            |
| -           | 80626 E     | Feed Dog, for Style 80800 F only-----                                             | 1            |
| 7           | 80625       | Needle Guard, for Styles 80800 E and F-----                                       | 1            |
| 8           | 80677       | Upper Knife, for Styles 80800 E and F-----                                        | 2            |
| 9           | 88 D        | Screw, for lower knife, for Styles 80800 E and F-----                             | 1            |
| 10          | 80675       | Lower Knife, for Styles 80800 E and F-----                                        | 2            |
| 11          | 80671       | Knife Bar, for Styles 80800 E and F-----                                          | 1            |
| 12          | 92127       | Screw, for upper knife, for Styles 80800 E and F-----                             | 1            |
| 13          | 98          | Screw for knife bar-----                                                          | 1            |
| 14          | 459         | Chain Cutter Knife Lever Shaft, for Styles 80800 E and F-----                     | 1            |
| 15          | 460         | Shaft Collar, for knife bar, for Styles 80800 E and F-----                        | 1            |
| 16          | 88          | Screw, for shaft collar-----                                                      | 1            |
| 17          | HS110       | Tension Spring, for knife bar, for Styles 80800 E and F-----                      | 1            |
| 18          | 18          | Nut, for chain cutter drive connection assembly, for Styles 80800 E and<br>F----- | 1            |
| 19          | 80670       | Ball Stud Washer, for ball stud, for Styles 80800 E and F-----                    | 1            |
| 20          | 29132 AF    | Chain Cutter Drive Connection Assembly, for Styles 80800 E and F-----             | 1            |
| 21          | 10349       | Ball Stud-----                                                                    | 1            |
| 22          | 80672       | Knife Driving Eccentric-----                                                      | 1            |
| 23          | 22894 L     | Spot Screw-----                                                                   | 1            |
| 24          | 80650 C     | Chain Cutter Drive Connection-----                                                | 1            |
| 25          | 97 A        | Screw, for drive connection-----                                                  | 2            |
| 26          | 75 A        | Screw, for drive connection-----                                                  | 2            |
| 27          | 660-90      | Felt Oiling Pad-----                                                              | 1            |
| 28          | 80649 B     | Oil Felt Holder-----                                                              | 1            |
| 29          | 93          | Screw, for feed dog, for Style 80800 E only-----                                  | 1            |
| -           | 22596       | Screw, for feed dog, for Style 80800 F only-----                                  | 1            |
| -           | 22874 C     | Screw, for feed dog, for Style 80800 H only-----                                  | 1            |
| 30          | 69 H        | Washer, for feed dog screw-----                                                   | 1            |
| 31          | 80625 H     | Needle Guard, marked "TL", for Style 80800 H only-----                            | 1            |
| 32          | 80605 H     | Feed Dog, for Style 80800 H only-----                                             | 1            |
| 33          | 73 C        | Set Screw, for feed dog support, for Style 80800 H only-----                      | 1            |
| 34          | 93 A        | Screw, for feed driving eccentric fork-----                                       | 1            |
| 35          | 80634 H     | Feed Bar, for Style 80800 H only-----                                             | 1            |
| 36          | 89          | Set Screw, for feed bar-----                                                      | 2            |
| 37          | WO-3        | Wool Yarn, for feed bar shaft-----as required                                     |              |
| 38          | 80411       | Feed Bar Shaft-----                                                               | 1            |
| 39          | 22706 A     | Set Screw-----                                                                    | 1            |
| 40          | 80634 E     | Feed Lift Eccentric Fork-----                                                     | 1            |
| 41          | 482 C       | Feed Bar Shaft Collar-----                                                        | 2            |
| 42          | 22894 C     | Set Screw, for feed bar shaft collar-----                                         | 2            |
| 43          | T26         | Stop Screw, for stitch regulating stud-----                                       | 2            |
| 44          | 80633 H     | Feed Rocker-----                                                                  | 1            |
| 45          | 89          | Set Screw, for feed rocker-----                                                   | 2            |
| 46          | 80408 A     | Feed Rocker Shaft-----                                                            | 1            |
| 47          | WO-3        | Wool Yarn, for feed rocker shaft-----as required                                  |              |
| 48          | 80696       | Stitch Regulating Stud, for Styles 80800 E and F-----                             | 1            |
| -           | 80696 H     | Stitch Regulating Stud, for Style 80800 H-----                                    | 1            |
| 49          | 80654 H     | Feed Rocker Eccentric Connection Bushing, for Style 80800 H-----                  | 1            |
| 49A         | 80654       | Feed Rocker Eccentric Connection Bushing, for Styles 80800 E and F-----           | 1            |
| 50          | 29099 X     | Feed Drive Eccentric Assembly-----                                                | 1            |
| 51          | 80606 C     | Feed Drive Eccentric-----                                                         | 1            |
| 52          | 22894 L     | Spot Screw, for feed drive eccentric-----                                         | 1            |
| 53          | 80651 C     | Feed Rocker Eccentric Connection-----                                             | 1            |
| 54          | 80606 D     | Feed Lift Eccentric-----                                                          | 1            |
| 55          | 22894 D     | Spot Screw, for feed lift eccentric-----                                          | 1            |
| 56          | HA18 A      | Stitch Regulating Stud Nut-----                                                   | 1            |
| 57          | HA20 A      | Stitch Regulating Stud Washer-----                                                | 1            |
| 58          | 80634 EB    | Felt, for feed lift eccentric fork-----                                           | 1            |



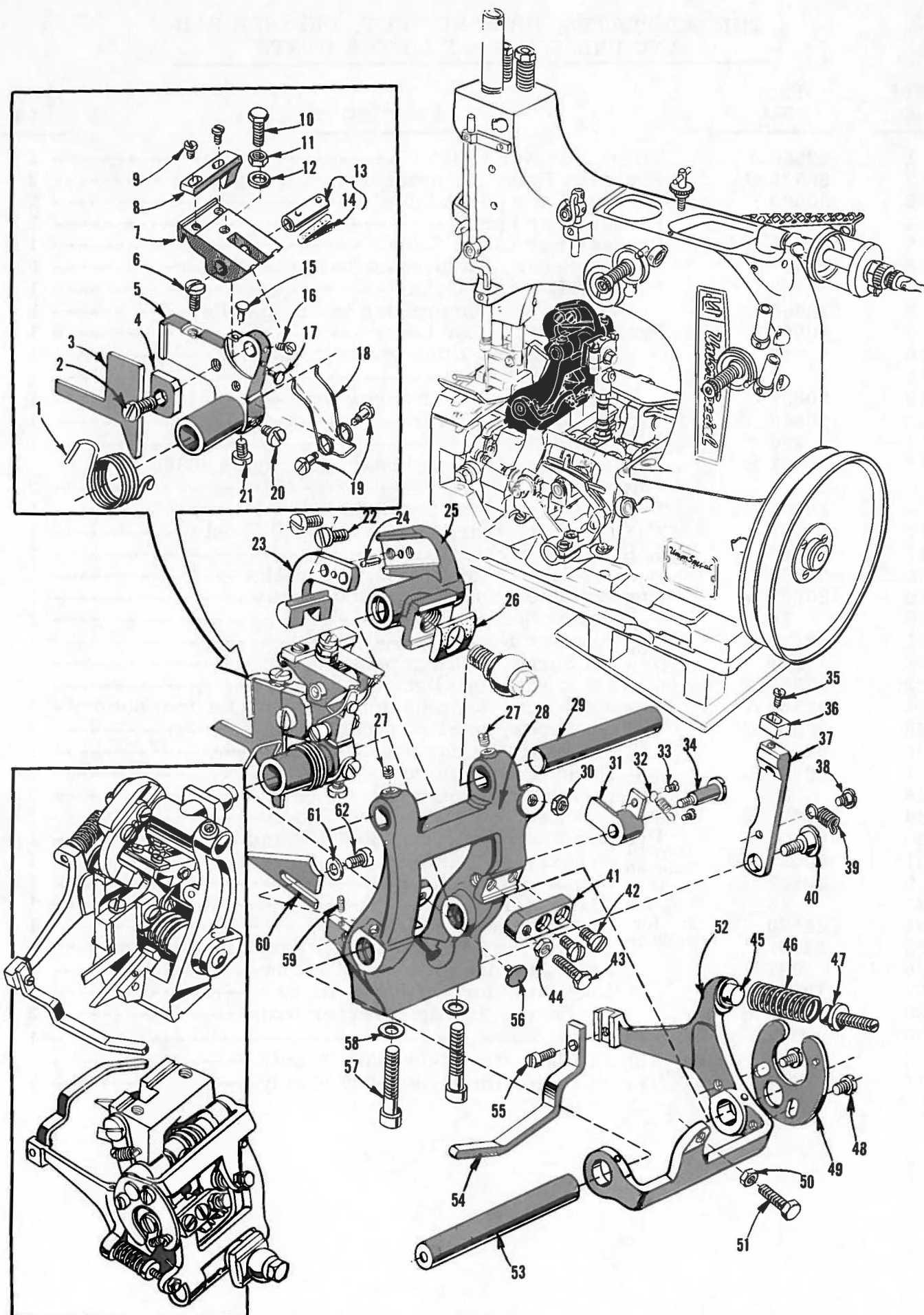




THROAT PLATES, PRESSER FEET, PRESSER BAR  
AND PRESSER FOOT LIFTER PARTS

| <u>Ref.<br/>No.</u> | <u>Part<br/>No.</u> | <u>Description</u>                                            | <u>Amt.<br/>Req.</u> |
|---------------------|---------------------|---------------------------------------------------------------|----------------------|
| 1                   | 22580 A             | Screw, for No. 39536 CA-----                                  | 2                    |
| 2                   | 39536 CA            | Pressure Plug, for presser spring regulator-----              | 2                    |
| 3                   | 80689 B             | Presser Spring Regulator-----                                 | 2                    |
| 4                   | HA63 F              | Presser Bar Spring-----                                       | 2                    |
| 5                   | 80666 C             | Presser Bar Lifter Collar-----                                | 1                    |
| 6                   | 22894 C             | Set Screw, for presser bar lifter collar-----                 | 2                    |
| 7                   | 482 C               | Presser Bar Stop Collar-----                                  | 1                    |
| 8                   | 22894 C             | Set Screw, for presser bar stop collar-----                   | 2                    |
| 9                   | 80648 A             | Presser Foot Lifter Lever-----                                | 1                    |
| 10                  | 258                 | Nut, for foot lifter lever screw stud-----                    | 1                    |
| 11                  | 258 A               | Check Nut-----                                                | 1                    |
| 12                  | 80632 C             | Foot Lifter Lever Screw Stud-----                             | 1                    |
| 13                  | 80649               | Spring, for lifter lever-----                                 | 1                    |
| 14                  | 420                 | Stud, for lifter lever-----                                   | 1                    |
| 15                  | 80661 B             | Presser Bar, front and rear, for Styles 80800 E<br>and F----- | 2                    |
| -                   | 80661 B             | Presser Bar, front, for Style 80800 H only-----               | 1                    |
| 16                  | 80861 A             | Presser Bar, rear, for Style 80800 H only-----                | 1                    |
| 17                  | 482 C               | Collar, for presser bar-----                                  | 1                    |
| 18                  | 22894 C             | Set Screw, for presser bar collar-----                        | 2                    |
| 19                  | 80627 M             | Presser Foot, for Style 80800 H only-----                     | 1                    |
| 20                  | 88 A                | Clamp Screw-----                                              | 2                    |
| 21                  | 80627 K             | Presser Foot Shank-----                                       | 1                    |
| 22                  | 531                 | Set Screw, to align presser foot-----                         | 1                    |
| 23                  | 12934 A             | Lock Nut, for alignment screws-----                           | 3                    |
| 24                  | 22560 A             | Set Screw, for adjustment of presser foot bottom -            | 1                    |
| 25                  | 22560 B             | Set Screw, to align presser foot-----                         | 1                    |
| 26                  | 99251               | Hinge Screw, for presser foot-----                            | 1                    |
| 27                  | 80627 L             | Presser Foot Bottom-----                                      | 1                    |
| 28                  | 80                  | Screw, for throat plate-----                                  | 3                    |
| 29                  | 80628 H             | Throat Plate, for Style 80800 H only-----                     | 1                    |
| 30                  | 80627 E             | Presser Foot, for Styles 80800 E and F-----                   | 1                    |
| 31                  | 80627 EB            | Presser Foot Bottom-----                                      | 1                    |
| 32                  | 80627 EA            | Presser Foot Shank-----                                       | 1                    |
| 33                  | 88                  | Clamp Screw-----                                              | 1                    |
| 34                  | 22570               | Clamp Screw-----                                              | 1                    |
| 35                  | 22707               | Screw, for adjustment of presser foot bottom-----             | 1                    |
| 36                  | 907                 | Lock Nut, for adjustment screw-----                           | 1                    |
| 37                  | 12934 A             | Lock Nut, for alignment screws-----                           | 2                    |
| 38                  | 22560 B             | Set Screw, to align presser foot-----                         | 2                    |
| 39                  | C41                 | Hinge Screw-----                                              | 1                    |
| 40                  | 80628 E             | Throat Plate, for Style 80800 F only-----                     | 1                    |
| 41                  | 80624 E             | Throat Plate, for Style 80800 E only-----                     | 1                    |







No. 29486 D AUTOMATIC TAPE CUTTER ASSEMBLY  
FOR STYLE 80800 H ONLY

| Ref.<br>No. | Part<br>No. | Description                                                        | Amt.<br>Req. |
|-------------|-------------|--------------------------------------------------------------------|--------------|
| 1           | 80237       | Spring, for upper knife lever -----                                | 1            |
| 2           | 22517       | Screw, for upper knife clamp -----                                 | 1            |
| 3           | 80277       | Upper Knife -----                                                  | 1            |
| 4           | 80272       | Upper Knife Clamp -----                                            | 1            |
| 5           | 80271       | Upper Knife Lever -----                                            | 1            |
| 6           | 22528       | Screw, for upper knife lever -----                                 | 1            |
| 7           | 80287       | Upper Knife Operating Ratchet Block -----                          | 1            |
| 8           | 80288 A     | Upper Knife Actuating Pawl -----                                   | 1            |
| 9           | 22768       | Screw, for upper knife actuating pawl -----                        | 2            |
| 10          | 906         | Stop Screw, for upper knife operating ratchet block -----          | 1            |
| 11          | 907         | Lock Nut, for upper knife operating ratchet block stop screw ----- | 1            |
| 12          | 80266       | Washer, for screw on upper knife operating ratchet block -----     | 1            |
| 13          | 51134 V     | Taper Link Pin, for ratchet block -----                            | 1            |
| 14          | 666-260     | Felt Oil Wick -----                                                | 1            |
| 15          | 80285       | Adjusting Screw Stop, for upper knife lever -----                  | 1            |
| 16          | 77          | Set Screw, for taper link pin -----                                | 1            |
| 17          | 80285       | Adjusting Screw Stop, for upper knife lever -----                  | 1            |
| 18          | 80238       | Spring, for upper knife operating ratchet block -----              | 1            |
| 19          | 57 WD       | Screw, for upper knife operating ratchet block spring -----        | 2            |
| 20          | 25 CC       | Screw, for upper knife lever -----                                 | 1            |
| 21          | 94          | Screw, for upper knife lever -----                                 | 1            |
| 22          | 93          | Screw, for upper knife operating pawl -----                        | 2            |
| 23          | 80286 A     | Upper Knife Operating Pawl -----                                   | 1            |
| 24          | 76099 G     | Dowel Pin, for upper knife operating pawl -----                    | 1            |
| 25          | 80276       | Upper Knife Operating Lever -----                                  | 1            |
| *26         | 80270       | Upper Knife Operating Lever Buffer Washer -----                    | 1            |
| 27          | 88          | Set Screw, for tape cutter support -----                           | 2            |
| 28          | 80274       | Tape Cutter Support -----                                          | 1            |
| 29          | 80278       | Upper Knife Operating Lever Shaft -----                            | 1            |
| 30          | 907         | Lock Nut, for upper knife actuating lever spring stop screw -----  | 1            |
| 31          | 80288 K     | Upper Knife Actuating Pawl Trip Dog -----                          | 1            |
| 32          | 80288 G     | Spring, for upper knife actuating pawl trip dog -----              | 1            |
| 33          | 22599       | Screw, for upper knife actuating pawl trip dog spring -----        | 2            |
| 34          | 22559 J     | Screw, for upper knife actuating pawl trip dog -----               | 1            |
| 35          | 22564       | Screw, for trip lever shoe -----                                   | 1            |
| 36          | 80288 C     | Trip Lever Shoe -----                                              | 1            |
| 37          | 80288 B     | Trip Lever -----                                                   | 1            |
| 38          | 22760 A     | Screw, for trip lever spring -----                                 | 1            |
| 39          | 80288 D     | Trip Lever Spring -----                                            | 1            |
| 40          | 22557       | Screw, for trip lever -----                                        | 1            |
| 41          | 80269       | Stop Screw Block -----                                             | 1            |
| 42          | 93 A        | Screw, for stop screw block -----                                  | 2            |
| 43          | 906 A       | Stop Screw -----                                                   | 1            |
| 44          | 907         | Lock Nut, for stop screw -----                                     | 1            |
| 45          | 80268       | Stop Pin, for upper knife actuating lever spring -----             | 1            |
| 46          | HS110       | Tension Spring, for upper knife actuating lever -----              | 1            |
| 47          | 99246       | Stop Screw, for upper knife actuating lever spring -----           | 1            |
| 48          | 94          | Screw, for trip dog cam -----                                      | 2            |
| 49          | 80288 F     | Trip Dog Cam -----                                                 | 1            |
| 50          | 907         | Lock Nut, for stop screw -----                                     | 1            |
| 51          | 906 A       | Stop Screw, for upper knife actuating lever -----                  | 1            |
| 52          | 80281 A     | Upper Knife Actuating Lever -----                                  | 1            |
| 53          | 80279       | Shaft, for upper knife actuating lever -----                       | 1            |
| *54         | 80297 D     | Actuating Shoe, for upper knife -----                              | 1            |
| *55         | 97          | Screw, for actuating shoe -----                                    | 1            |
| 56          | 80283       | Actuating Ratchet Block Adjusting Screw Stop -----                 | 1            |
| 57          | 22806 G     | Screw, for tape cutter support -----                               | 2            |
| 58          | 6042 A      | Washer, for tape cutter support -----                              | 2            |
| 59          | 73 C        | Set Screw, for lower knife screw -----                             | 1            |
| 60          | 80275       | Lower Knife -----                                                  | 1            |
| 61          | 8372 A      | Washer, for lower knife -----                                      | 1            |
| 62          | 99248       | Screw, for lower knife -----                                       | 1            |

\* Not component parts of No. 29486 D tape clipping assembly.



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