DESCRIPTION OF MACHINES

Cylinder bed machines P300-2/201, P300-2/206 and P300-2/406 preform high speed, double locked stitch type 401 on a wide variety of medium and heavy weight fabrics.

General Features

Cylinder bed overhangs base, allowing tubular work to be stitched.

Sliding cover encloses elliptical bed.

Arm shaft is mounted with ball bearing in front and rear.

Belt driven bed shaft is mounted in ball bearing at rear and needle bearing in front.

Machine base also serves as a drip pan with a glass, oil-sump jar.

Face plate is hinged to facilitate threading and oiling.

All threading is done on operator's side of machine.

Vibrating looper thread take-up is non-winding.

Needle bar connecting link, needle bar rock frame, needle bar rock frame driving connection and spreader driving connection are all mounted on needle bearings.

Needle bar stroke: 1-1/4 inches.

Presser bar lift: 3/8 inch.

Bed Dimensions: 16-3/4 inches long, 7 inches wide. Top of bed is 7 inches above table.

Space at right of needle bar: 10 inches.

Space at left of needle bar to edge of bed: 2-1/4 inches.

Federal stitch type 401.

Special Features of Individual Machines

MACHINE P300-2/201

Two needles, two loopers.

Combination of needle feed and drop feed prevents the slipping of the upper and lower plies of material and assists in two or more plies being fed evenly.

Maximum stitch length: 4 per inch.

MACHINE P300-2/206

Two needles, two loopers.

Puller Feed-Combination of needle feed and continuous close coupled gear driven puller feed.

Length of stitch: 4 to 12 per inch (regularly fitted for 9 stitches per inch).

Made in gauges from 3/16 inch to 2 inches. Standard guages are 1 inch, 1-3/8 inches and 1-1/2 inches.

MACHINE P300-2/406

Four needles, four loopers.

Puller Feed -Combination of needle feed and continuous close coupled gear driven puller feed.

Length of stitch: 4 to 12 per inch (regularly fitted for 9 stitches per inch).

Standard guages are 5/16, 5/16, 5/16 inch, 3/8, 3/8, 3/8 inch, 1/2, 1/2, 1/2 inch and 1/4, 1, 1/4 inch. Minimum spacing between any two adjacent needles is 3/16 inch.

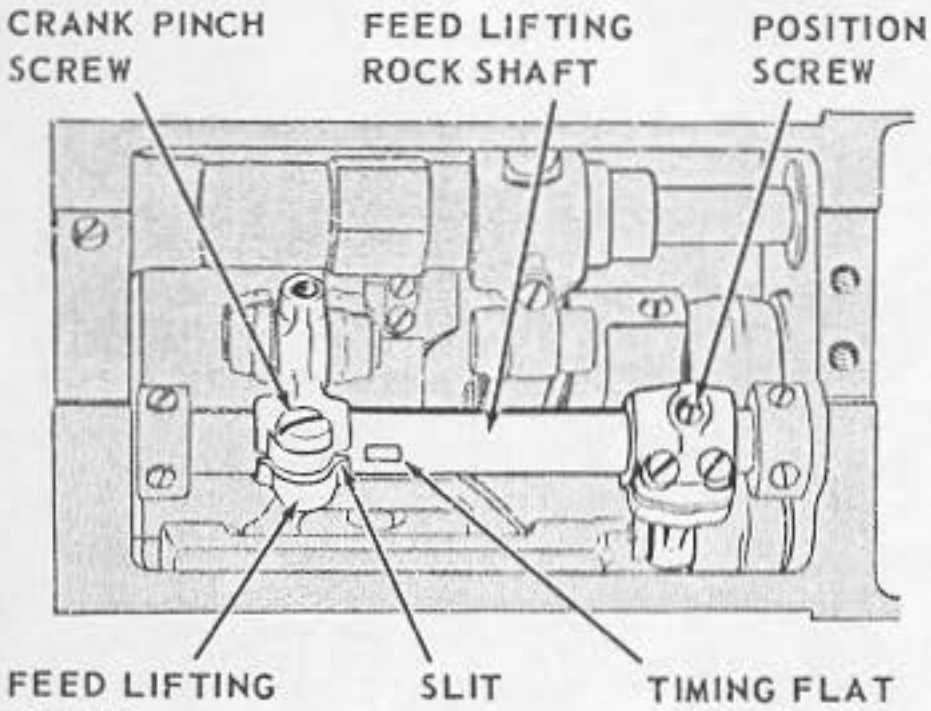


Fig. 23. Feed Bar Height Setting

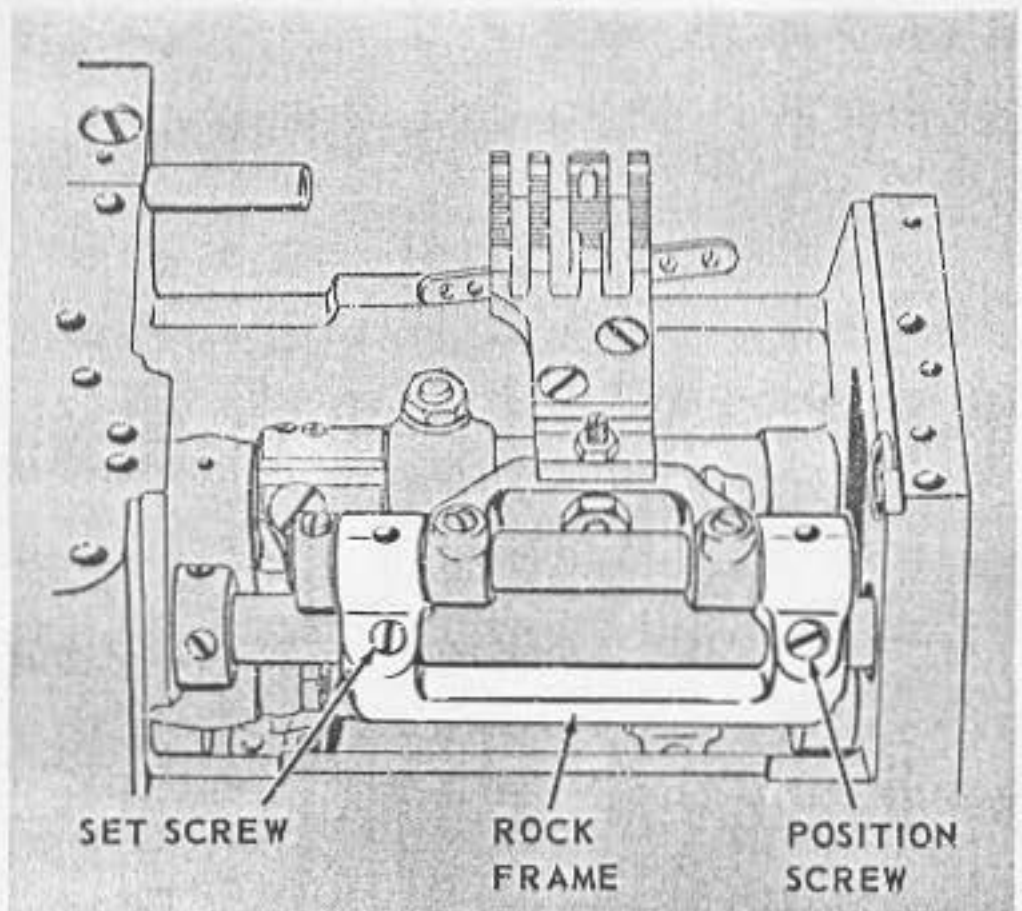


Fig. 24. Feed Driving Rock Frame

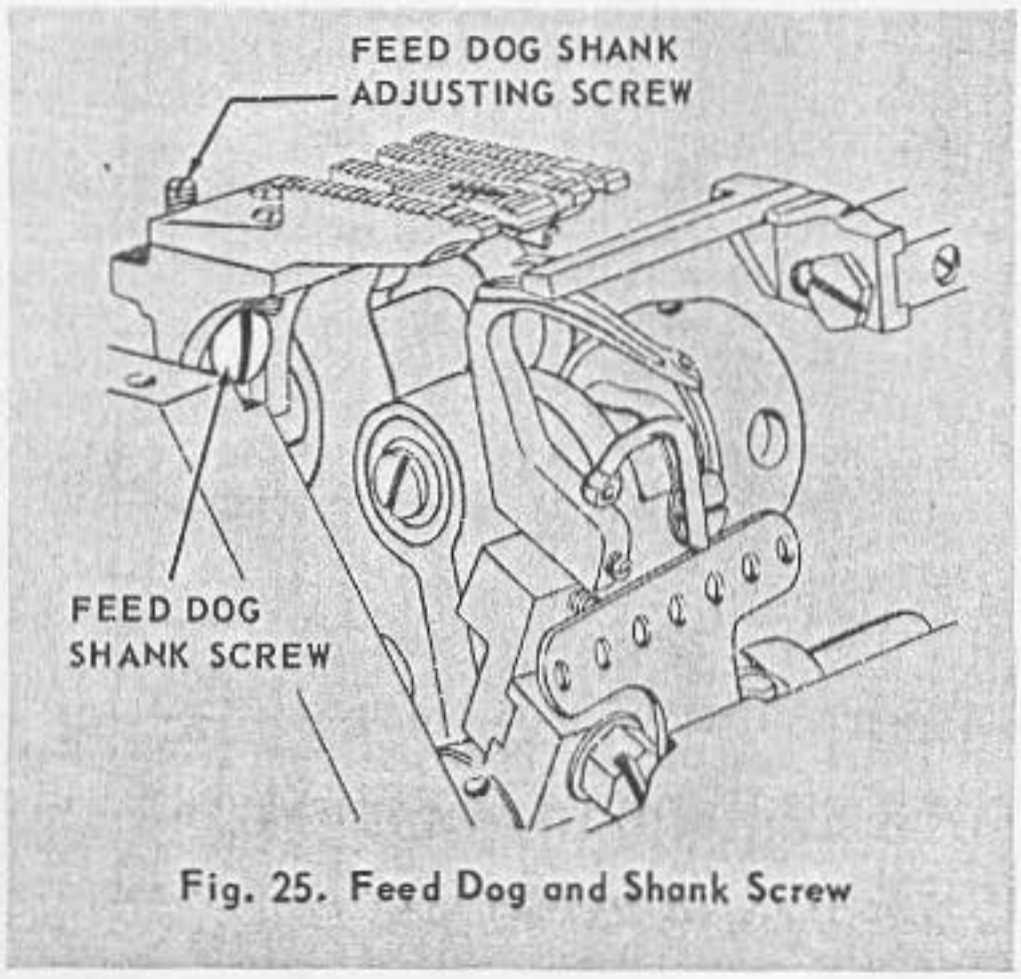


Fig. 25. Feed Dog and Shank Screw

FEED BAR HEIGHT SETTING P300-2/201

When feed bar is at correct height, the slit in the feed lifting crank is aligned with the timing flat on feed lifting rock shaft as shown in Fig. 23.

If adjustment is required, first be sure that the feed lifting rock shaft crank position screw engages the rock shaft spot correctly.

Then loosen feed lifting crank pinch screw and align slit of feed lifting crank with timing flat on feed lifting shaft. Re-tighten crank pinch screw.

FEED DOG ADJUSTMENT P300-2/201

Lengthwise Setting

The feed dog is correctly adjusted when its movement is centralized between forward and rear ends of throat plate.

For adjustment, loosen position screw and set screw, Fig. 24, and move rock frame forward or backward to centralize the movement of the feed dog in the throat plate. Re-tighten set screw and position screw.

Sidewise Setting

The feed dog should clear the sides of the throat plate with approximately the same distance on both sides. If adjustment is required, loosen position screw and set screw shown in Fig. 24 and feed lifting crank pinch screw shown in Fig. 23 and move assembly to correct position.

Height Setting

The feed dog, at its highest position, should be limited to the projection of the full depth of teeth above the throat plate. It should be at its highest position when the needle is at its lowest position.

For adjustment, loosen feed dog shank screw shown in Fig. 25. To raise feed dog, turn feed dog shank adjusting screw, Fig. 25, down. To lower feed dog, turn feed dog shank adjusting screw up.

TIMING FEED LIFT ECCENTRIC (P300-2/201

The feed lifting eccentric shown in Fig. 26 can be adjusted to permit the teeth of the feed dog to remain below the throat plate until the needle penetrates the material.

It is correctly adjusted when the edge of the looper driving crank lines up with the edge of the lubricating pad on the feed lifting eccentric as shown in Fig. 26.

Set screws, accessible through hole in feed driving connection, allow for adjustment when required.

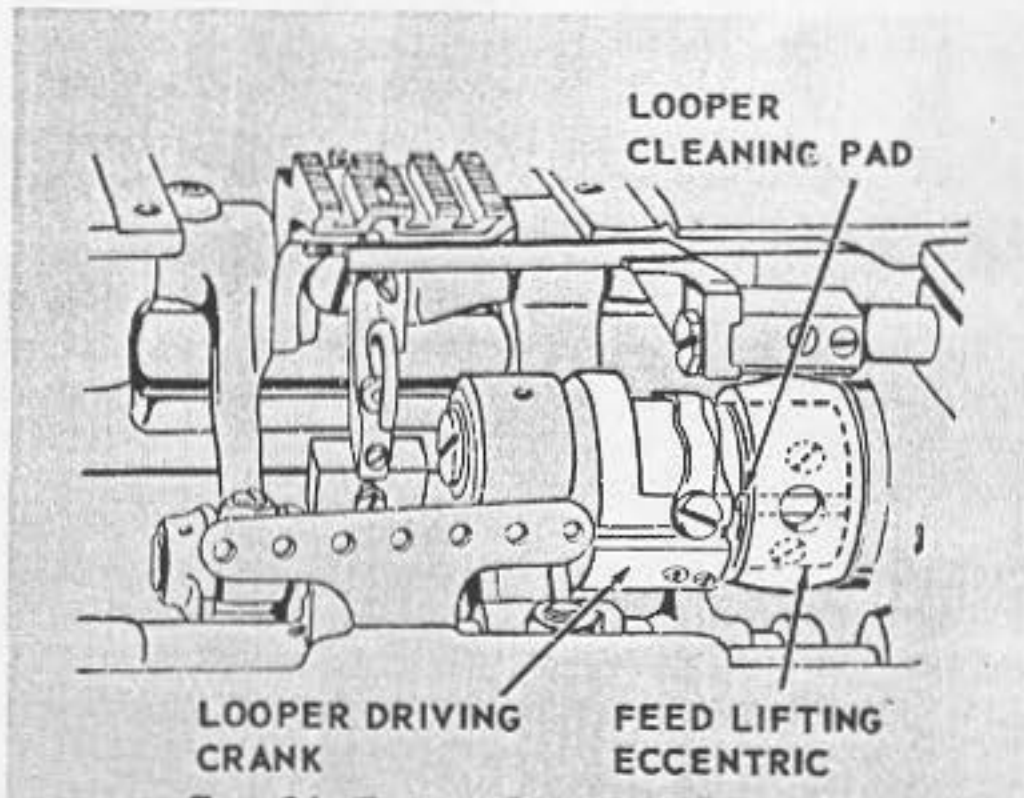


Fig. 26. Timing Feed Lift Eccentric

POSITIONING LOOP DEFLECTOR (P300-2/201)

Loop deflector, located on underside of feed dog, is correctly positioned when there is approximately a 1/32 inch clearance between needle and loop deflector as shown in Fig. 27.

Loop deflector screws shown in Fig. 27 allow for adjustment when required.

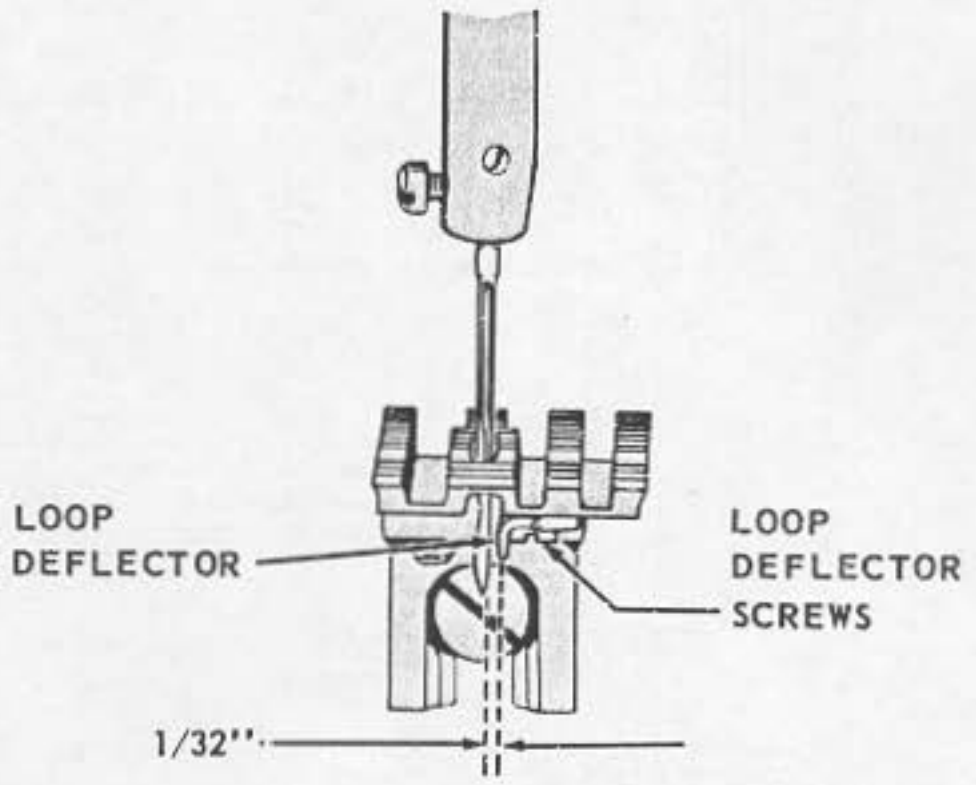


Fig. 27. Positioning Loop Deflector

SETTING THE NEEDLE GUARDS

The needle guards are correctly set when the needles pass them as close as possible without hitting.

To adjust, turn machine pulley over toward operator until points of loopers are about to pass needles on their forward stroke.

Loosen needle guard set screws shown in Fig. 28 and turn needle guards as close as possible to the needles without touching. Tighten set screws.

Check by springing the needles to the left while turning the machine pulley to make certain that the looper points do not strike the needles.

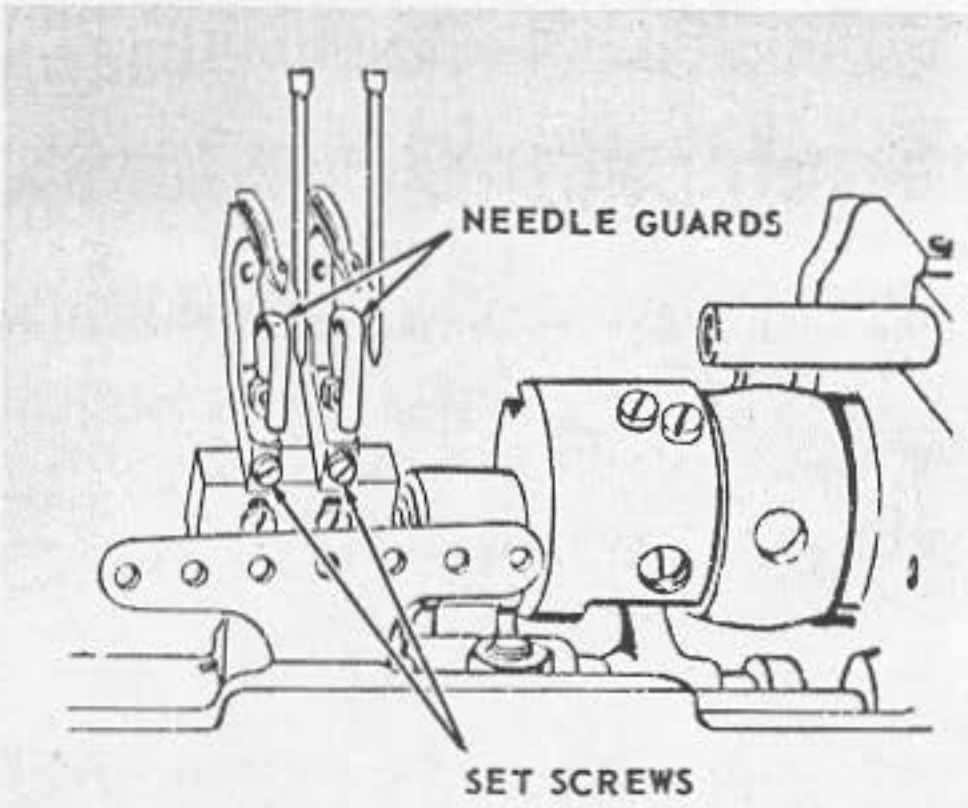


Fig. 28. Setting the Needle Guards

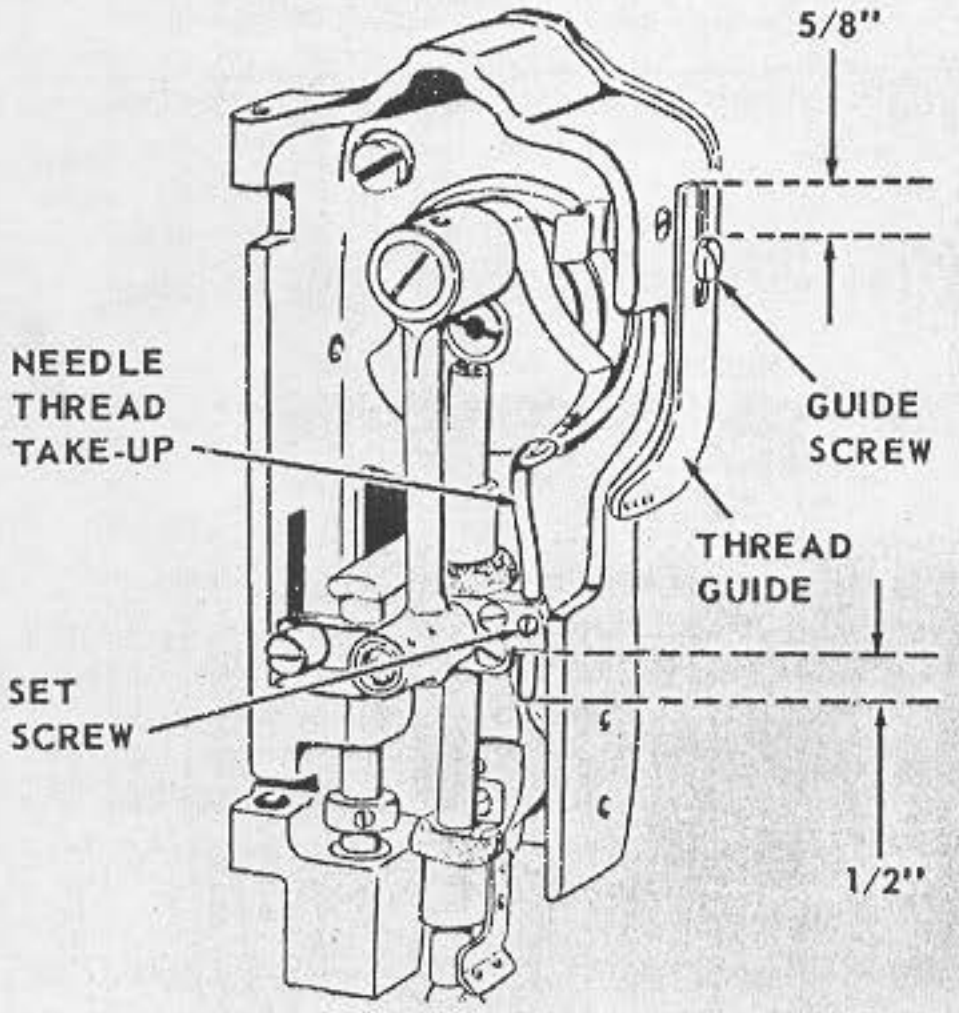


Fig. 29. Needle Thread Take-up

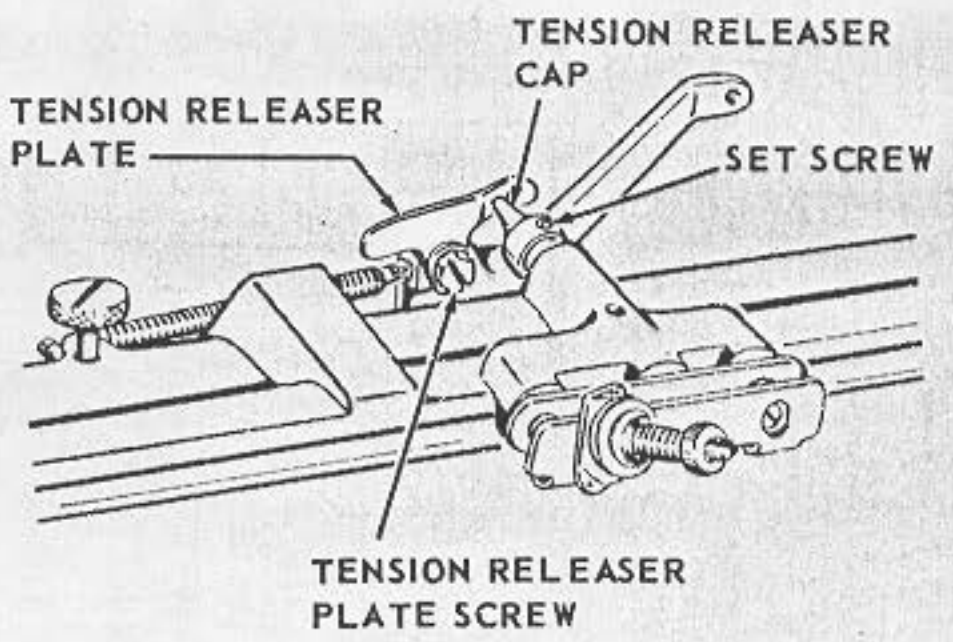


Fig. 30. Needle Thread Tension Releaser

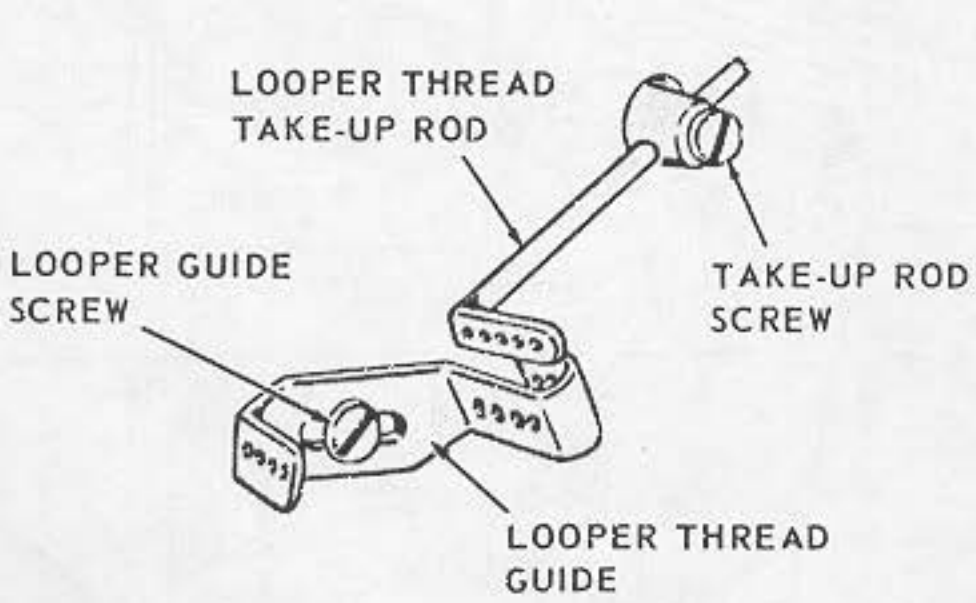


Fig. 31. Looper Thread Take-up

ADJUSTING NEEDLE THREAD TAKE-UP

The needle thread take-up and thread guide may be adjusted to increase or decrease the amount of thread drawn at the top of the needle bar stroke. To increase the amount, loosen thread take-up set screw, Fig. 29, and raise take-up (or loosen guide screw and lower guide). To decrease the amount, reverse the adjustment by lowering the take-up or raising the guide.

For average sewing conditions, the guide should be set with upper end 5/8 inch above the guide screw as shown in Fig. 29. The thread take-up should be set with the lower end 1/2 inch below the bottom of its holder.

ADJUSTING NEEDLE THREAD TENSION RELEASER

When correctly adjusted, the tension releaser should release tension on needle thread when the presser foot is about 1/4 inch above throat plate. To adjust, loosen set screw, Fig. 30 and move tension releaser cap out for earlier release of tention, or in for later release. Tighten set screw. Tension releaser plate, Fig. 30, may also be adjusted to release tension at proper time.

ADJUSTING LOOPER THREAD TAKE-UP

The looper thread take-up and guide may be adjusted for handling more or less thread, according to thickness of material and length of stitch, and to change the ratio of looper thread in the finished stitch.

To change the amount of thread handled, loosen looper thread guide screw, Fig. 31 and looper thread take-up rod screw. Move thread guide and take-up rod to the left for more thread take-up, or to the right for less thread take-up. Tighten the two set screws making certain that the take-up rod passes through the center of the guide yoke.

To change the ratio of looper thread in finished stitch, loosen thread guide screw, Fig. 31, and lower the yoke (right end) of the thread guide for more thread. For less thread, raise right end of guide. Hold in position and tighten guide screw.

NOTE: When ordering replacement parts from this catalog, a "P" prefix must be added to all part numbers required.

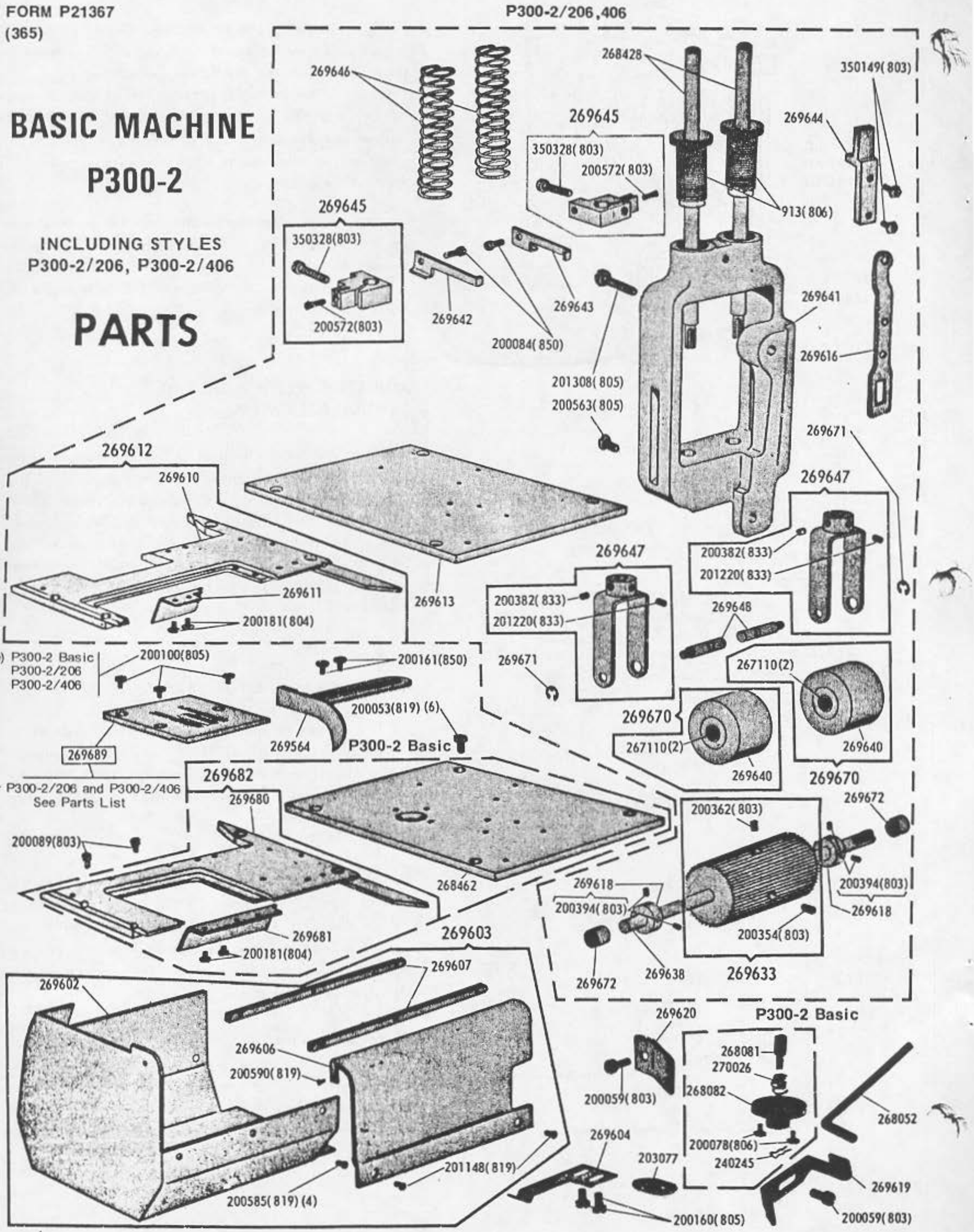
FORM P21367
(365)

BASIC MACHINE

P300-2

INCLUDING STYLES
P300-2/206, P300-2/406

PARTS



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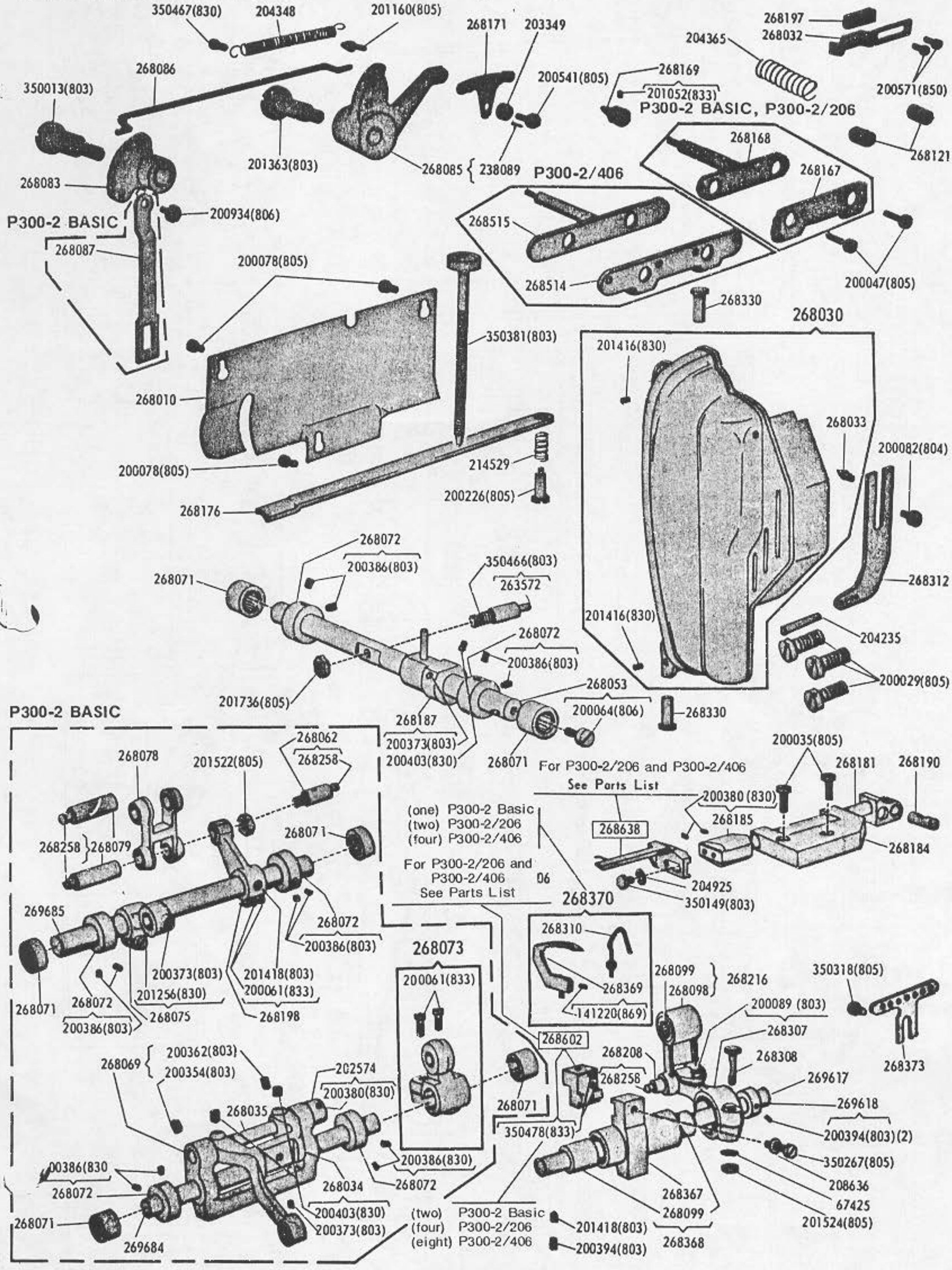

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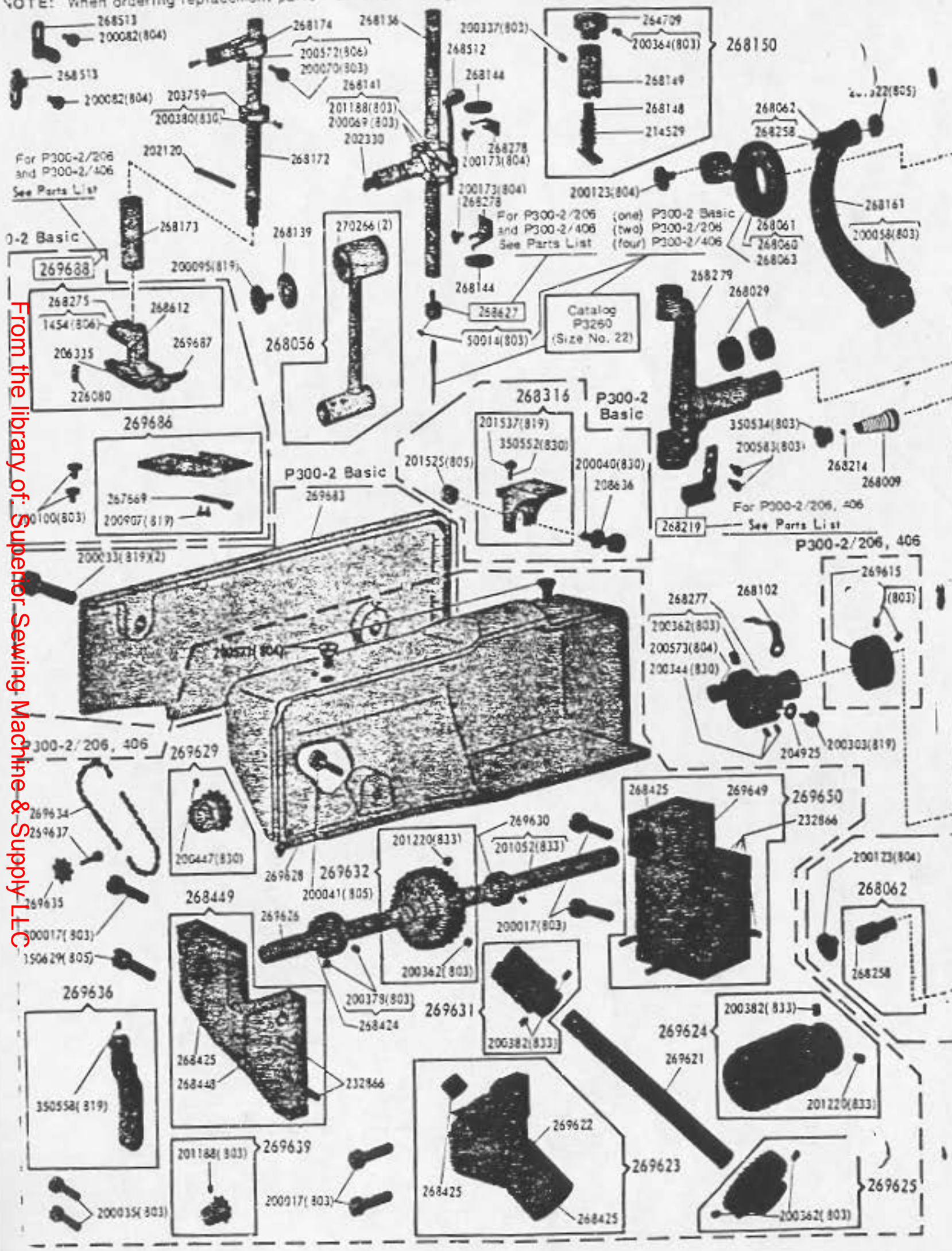

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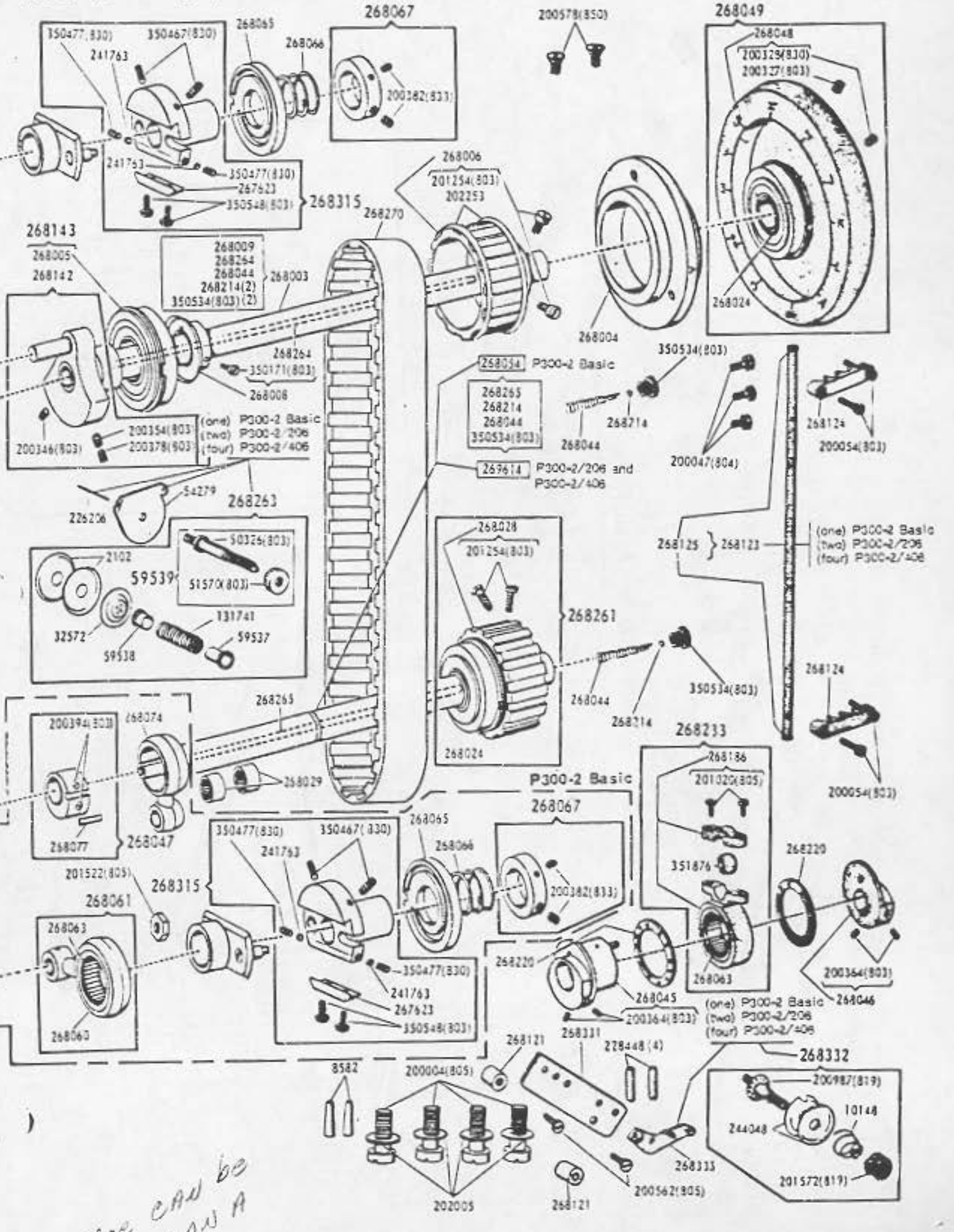

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NOTE: When ordering replacement parts from this catalog, a "P" prefix must be added to all part numbers required.

NUMERICAL LIST OF PARTS MACHINES P300-2 Basic, P300-2/206 AND P300-2/406

NUMBER	DESCRIPTION
1454(806)	Pressor Foot Shank Pinch Screw (P300-2 Basic)
2102	Needle Thread Tension Disc(2)
Catalog	
3260	Needle(62x57) Size No. 22
8582	Arm Position Pin(2)
10148	Looper Thread Tension Spring
32572	Needle Thread Tension Releasing Disc
50014(803)	Needle Set Screw
50326(803)	Needle Thread Tension Stud
51570(803)	Needle Thread Tension Thumb Nut
54279	Needle Thread Tension Thread Guide (double)
59537	Needle Thread Tension Spring Bushing (front)
59538	Needle Thread Tension Spring Bushing (back)
59539	Needle Thread Tension Stud 50326(803) with 51570(803)
67425	Looper Carrier Crank Clamping Stud Nut Washer
131741	Needle Thread Tension Spring
141220(869)	Needle Guard Set Screw
200004(805)	Arm Screw(4)
200029(805)	Arm Head Screw(3)
200033(819)	Bed Side Cover (back) Screw(2) (P300-2 Basic)
200035(805)	Spreader Bar Bearing Screw(2)
200047(804)	Arm Shaft Ball Bearing (back) Housing Screw(3)
200047(805)	Needle Thread Tension Bracket Screw(2)
200053(819)	Bed Plate Screw(6)
200054(803)	Looper Thread Tube Clamp Screw(4)
200058(803)	Needle Bar Rock Frame Driving Arm Pinch Screw(2)
200059(803)	Looper Thread Guide (on Bed) (on front) Screw
200059(803)	Looper Thread Guide (on Bed) (under cover) Screw
200064(806)	Looper Thread Take-up Rod Set Screw
200069(803)	Needle Bar Connecting Stud Pinch Screw(2)
200070(803)	Presser Bar Guide Bracket Pinch Screw
200078(805)	Arm Side Cover Screw(3)
200082(804)	Needle Thread Guide Screw(3)
200089(803)	Bed Plate (left) Screw(2)
200089(803)	Looper Carrier Crank Hinge Pin Pinch Screw
200095(819)	Needle Bar Connecting Link Cap Washer Screw
200100(805)	Throat Plate Screw
200123(804)	Needle Bar Rock Frame Driving Connection Cap Screw
200160(805)	Bed (elliptical) Cover Lock Spring Screw(2)
200161(850)	Edge Guide Screw(2)
200173(804)	Needle Bar Oiling Felt Holder Screw(2)
200181(804)	Bed Plate (left) Guard Screw(2)
200226(805)	Presser Bar Spring Support Screw
200303(819)	Looper Driving Crank Oil Hole Cover Screw
200327(803)	Machine Pulley Set Screw
200328(830)	Machine Pulley Position Screw
200337(803)	Needle Bar Rock Frame Regulating Stud Sleeve Set Screw
200344(830)	Looper Driving Crank Position Screw(2)
200346(803)	Needle Bar Crank Set Screw
200354(803)	Needle Bar Crank Position Screw
200362(803)	Looper Driving Crank Set Screw
200364(803)	Needle Bar Rock Frame Regulating Stud Cap Set Screw
200364(803)	Spreader Driving Eccentric Counter-balance Set Screw(2)
200364(803)	Spreader Driving Eccentric Set Screw(2)
200373(803)	Spreader Driving Crank Position Screw
200378(803)	Needle Bar Crank Position Screw Check Screw
200380(830)	Presser Bar Stop Collar Set Screw
200380(830)	Spreader Holder Set Screw(2)
200382(833)	Needle Bar Rock Frame Driving Eccentric Adjusting Disc Spring Collar Set Screw(2)
200386(803)	Bed Shaft Thrust Collar Set Screw(2) (P300-2/206, 406)
200386(803)	Spreader Driving Rock Shaft Collar Set Screw(4)
200394(803)	Looper Carrier Shaft Collar Set Screw(2)
200394(803)	Looper Carrier Shaft Set Screw Check Screw
200403(830)	Spreader Driving Crank Set Screw
200541(805)	Needle Thread Tension Releasing Plate Screw
200562(805)	Looper Thread Tension Bracket Screw(2)
200571(850)	Face Plate Lock Spring Screw(2)
200572(806)	Presser Bar Guide Bracket Adjusting Screw
200573(804)	Looper Driving Crank Oil Stop Screw
200578(850)	Looper Thread Guide (top of Arm) Bracket Screw(2)
200583(803)	Needle Bar Rock Frame Thread Guide Screw(2)
200585(819)	Bed (elliptical) Cover Slide Bar Screw(4)
200590(819)	Bed (elliptical) Cover Section (front) Screw (upper)
200907(819)	Loop Deflector Screw(2) (P300-2 Basic)
200934(806)	Foot Lifter Lifting Link Hinge Screw
200987(819)	Looper Thread Tension Stud
201020(805)	Spreader Driving Connection Cap Screw(2)
201052(833)	Needle Thread Tension Releaser Cap Set Screw
201148(819)	Bed (elliptical) Cover Section (front) Screw (lower)(2)
201160(805)	Foot Lifter Lever Spring Screw Eye
201188(803)	Needle Thread Guide (on Needle Bar Connecting Stud) Set Screw
201254(803)	Arm Shaft Connection Belt Pulley Set Screw(2)
201254(803)	Bed Shaft Connection Belt Pulley Set Screw(2)
201363(803)	Foot Lifter Lever Hinge Screw
201416(830)	Face Plate Hinge Set Screw(2)
201418(803)	Looper Carrier Shaft Set Screw
201522(805)	Needle Bar Rock Frame Driving Connection Hinge Stud Nut
201524(805)	Looper Carrier Crank Clamping Stud Nut
201572(819)	Looper Thread Tension Thumb Nut
201736(805)	Spreader Driving Rock Shaft Screw Stud Nut
202005	Arm Screw Washer(4)
202120	Foot Lifter Lifting Link Stop Pin
202253	Arm Shaft Connection Belt Pulley Spring Flange(2)
202330	Needle Bar Connecting Stud Oil Packing (wick)
203077	Bed (elliptical) Cover Lock Spring Screw Washer
203349	Needle Thread Tension Releasing Plate Screw Washer
203759	Presser Bar Stop Collar with 200380(830)
204235	Arm Head Position Pin
204348	Foot Lifter Lever Spring
204365	Needle Thread Tensi Releaser Spring
204925	Looper Driving Crank Oil Hole Cover Screw Washer
204925 206335	Spreader Screw Wash Pressor Foot Hinge Pin (P300-2 Basic)
208636	Looper Holder Scre w Washer
214529	Needle Bar Rock Frame Regulating Stud Spring
214529	Presser Bar Spring Cushion Spring
226080	Pressor Foot Plate Spring (P300-2 Basic
226206	Needle Thread Tensio Releasing Pin
228448	Machine Locating Stu (4)
238089	Needle Thread Tensio Releasing Plate Pin
241763	Needle Bar Rock Fram Driving Eccentric Friction Plate Screw Set Screw Packing (brass) (2)
244048	Looper Thread Tensio Disc(2)
263572	Spreader Driving Rock Shaft Screw Stud Oil Packing (wick)
264709	Needle Bar Rock Frame Regulating Stud Cap with 200364(803)
267623	Needle Bar Rock Fram Driving Eccentric Friction Plate
267669	Loop Deflector (P300-2 Basic)
268003	Arm Shaft with 268009, 268044, 268264, two each 268214 and 350534(803
268004	Arm Shaft Ball Bearin (back) Housing
268005	Arm Shaft Ball Bearin (front)
268006	Arm Shaft Connection Belt Pulley with two each 201254(803) and 202253
268008	Arm Shaft Oil Slinger with 350171(803)
268009	Arm Shaft Oil Stop Ball Spring (front)
268010	Arm Side Cover
268024	Arm Shaft Ball Bearing (back)
268024	Bed Shaft Ball Bearing
268028	Bed Shaft Connection Belt Pulley with two 201254(803)
268029	Bed Shaft Needle Bearing(2)
268029	Needle Bar Rock Fram Needle Bearing(2)
268030	Face Plate with 268033 and two 201416(830)
268032	Face Plate Lock Sprin

NOTE: When ordering replacement parts from this catalog, a "P" prefix must be added to all part numbers required.

NUMBER	DESCRIPTION
268033	Face Plate Lock Stud
268044	Arm Shaft Oil Stop Ball Spring (rear)
268044	Bed Shaft Oil Stop Ball Spring
268045	Spreader Driving Eccentric with two 200364(803)
268046	Spreader Driving Eccentric Counter-balance with two 200364(803)
268048	Machine Pulley (aluminum alloy casting) for "V" belt (outside diam of belt groove 2.9 in.) with 200327(803) and 200328(830)
268049	Machine Pulley 268048 with 268024
268052	Looper Thread Take-up Rod
268053	Spreader Driving Rock Shaft with 200064(806)
268054	Bed Shaft with 268044, 268214, 268265, 350534(803), (P300-2 Basic)
268056	Needle Bar Connecting Link with two 270266
268060	Needle Bar Rock Frame Driving Connection
268061	Needle Bar Rock Frame Driving Connection 268060 with 268063
268062	Needle Bar Rock Frame Driving Connection Hinge Stud with 268258
268063	Needle Bar Rock Frame Driving Connection Needle Bearing
268063	Spreader Driving Connection Needle Bearing
268065	Needle Bar Rock Frame Driving Eccentric Adjusting Disc
268066	Needle Bar Rock Frame Driving Eccentric Adjusting Disc Spring
268067	Needle Bar Rock Frame Driving Eccentric Adjusting Disc Spring Collar with two 200382(833)
268071	Spreader Driving Rock Shaft Needle Bearing(2)
268072	Spreader Driving Rock Shaft Collar with two 200386(803)(2)
268083	Foot Lifter Bell Crank
268085	Foot Lifter Lever with 238089
268086	Foot Lifter Lever Rod
268087	Foot Lifter Lifting Link (P300-2 Basic)
268098	Looper Driving Connection
268099	Looper Carrier Needle Bearing(2)
268099	Looper Driving Connection Needle Bearing
268102	Looper Driving Crank Oil Hole Cover
268121	Looper Thread Tension Bracket Spacing Collar(2)
268121	Needle Thread Tension Bracket Spacing Collar(2)
268123	Looper Thread Tube with two 268125
268124	Looper Thread Tube Clamp(2)
268125	Looper Thread Tube Thread Bushing(2)
268136	Needle Bar
268139	Needle Bar Connecting Link Cap Washer
268141	Needle Bar Connecting Stud with 201188(803), 202330 and two 200069(803)
268142	Needle Bar Crank with 200346(803), 200354(803) and 200378(803)
268143	Needle Bar Crank 268142 with 268005
268144	Needle Bar Oiling Felt(2)
268148	Needle Bar Rock Frame Regulating Stud
268149	Needle Bar Rock Frame Regulating Stud Sleeve
268150	Needle Bar Rock Frame Regulating Stud complete, 214529, 264709, 268148 and 268149
268161	Needle Bar Rock Frame Driving Arm with two 200058(803)
268167	Needle Thread Tension Bracket (P300-2 Basic, 206)
268168	Needle Thread Tension Releaser (P300-2, Basic, 206)
268169	Needle Thread Tension Releaser Cap with 201052(833)
268171	Needle Thread Tension Releasing Plate (Adjustable)
268172	Presser Bar
268173	Presser Bar Bushing
268174	Presser Bar Guide Bracket with 200070(803) and 200572(806)
268176	Presser Bar Spring
268181	Spreader Bar
268184	Spreader Bar Bearing
268185	Spreader Holder with two 200380(830)
268186	Spreader Driving Connection with two 201020(805)
268187	Spreader Driving Crank with 200373(803) and 200403(830)
268190	Spreader Driving Pin
268197	Face Plate Lock Spring Plate
268208	Looper Carrier Crank Hinge Pin with 268258
268214	Arm Shaft Oil Stop Ball 5/32 in. diam.(2)
268214	Bed Shaft Oil Stop Ball 5/32 in. diam.
268216	Looper Driving Connection 268098 with 268099
268219	Needle Bar Rock Frame Thread Guide (P300-2 Basic)
268220	Spreader Driving Eccentric Thrust Washer(2)
268233	Spreader Driving Connection 268186 with 268063 and 351876
268258	Looper Carrier Crank Hinge Pin Oil Packing (wick)
268258	Needle Bar Rock Frame Driving Connection Hinge Stud Oil Packing (wick)
268261	Bed Shaft Connector Belt Pulley 268028 with 268024
268263	Needle Thread Tension complete, 32572, 59537, 59538, 59539, 131741 and two 2102
268264	Arm Shaft Oil Control Rod (wood)
268265	Bed Shaft Oil Control Rod (wood)
268270	Arm Shaft Connection Belt (reinforced neoprene)
268275	Pressor Foot Shank with 1454(806) (P300-2 Basic)
268277	Looper Driving Crank with 200362(803), 200573(804) and two 200344(830)
268278	Needle Bar Oiling Felt Holder(2)
268279	Needle Bar Rock Frame
268307	Looper Carrier Crank with 200089(803)
268308	Looper Carrier Crank Clamping Stud
268310	Needle Guard
268312	Needle Thread Guide (on Arm Head)
268315	Needle Bar Rock Frame Driving Flange with 267623, two each 241763, 350467(830), 350477(830) and 350548(803)
268330	Face Plate Hinge Stud(2)
268331	Looper Thread Tension Bracket
268332	Looper Thread Tension complete, 10148 200987(819), 201572(819) and two 244048
268333	Looper Thread Tension Thread Guide
268367	Looper Carrier
268368	Looper Carrier 268367 with two 268099
269369	Looper with 141220(869)
269370	Looper and Needle Guard complete, 268310 and 268369
269373	Looper Thread Guide (on Bed at Looper)
268462	Bed Plate (right) (P300-2 Basic)
268512	Needle Thread Guide (on Needle Bar Connecting Stud)
268513	Needle Thread Guide (on side of Arm)(2)
268514	Needle Thread Tension Bracket (P300-2/406)
268515	Needle Thread Tension Releaser (P300-2/406)
268602	Looper Holder with two 350478(833) (P300-2 Basic)
268612	Pressor Foot Plate Heel Spring (P300-2 Basic)
268627	Needle Holder with 50014(803) (P300-2 Basic)
268638	Spreader with Point (P300-2 Basic)
269564	Edge Guide
269602	Bed (elliptical) Cover with Lock Stud
269603	Bed (elliptical) Cover complete, 200590(819), 269602, 269606, two each 201148(819), 269607 and four 200585(819)
269604	Bed (elliptical) Cover Lock Spring
269606	Bed (elliptical) Cover Section (front)
269607	Bed (elliptical) Cover Slide Bar(2)
269610	Bed Plate (left) (P300-2/206,406)
269611	Bed Plate (left) Guard (P300-2/206,406)
269612	Bed Plate (left) and Guard complete, 269610, 269611, and two 200181(804) (P300-2/206, 406)
269613	Bed Plate (right) (P300-2/206, 406)
269614	Bed Shaft with 268044, 268214, 268265, 350534,(803) (P300-2/206, 406)
269615	Bed Shaft Thrust Collar with two 200386(803), (P300-2/206, 406)
269616	Foot Lifter Lifting Link (P300-2/206, 406)
269617	Looper Carrier Shaft
269618	Looper Carrier Shaft Collar with two 200394(803)
269619	Looper Thread Guide (on Bed) (on front)
269620	Looper Thread Guide (on Bed) (under cover)
269680	Bed Plate (left) (P300-2 Basic)
269681	Bed Plate (left) Guard (P300-2 Basic)

NOTE: When ordering replacement parts from this catalog, a "P" prefix must be added to all part numbers required.

NUMBER	DESCRIPTION
269682	Bed Plate (left) and Guard complete, 269680, 269681 and two 200181(804) (P300-2 Basic)
269683	Bed Side Cover (back) (P300-2 Basic)
269687	Pressor Foot Plate (P300-2 Basic)
269688	Pressor Foot (spring hinged) complete, 40 needle hole, 206335, 226080, 268275, 268612 and 269687 (P300-2 Basic)
269689	Throat Plate, for 269686 (P300-2 Basic)
270266	Needle Bar Connecting Link Needle Bearing(2)
350013(803)	Foot Lifter Bell Crank Hinge Screw
350149(803)	Spreader Screw
350171(803)	Arm Shaft Oil Slinger Set Screw
350267(805)	Looper Holder Screw
350318(805)	Looper Thread Guide (on Bed at Looper) Screw
350381(803)	Presser Bar Spring Adjusting Screw
350466(803)	Spreader Driving Rock Shaft Screw Stud with 263572
350467(830)	Needle Bar Rock Frame Driving Flange Set Screw(2)
350467(830)	Presser Bar Spring Adjusting Screw Set Screw
350477(830)	Needle Bar Rock Frame Driving Eccentric Friction Plate Screw Set Screw(2)
350478(833)	Looper Adjusting Screw
350478(833)	Looper Set Screw
350534(803)	Arm Shaft Oil Stop Ball Screw(2)
350534(803)	Bed Shaft Oil Stop Ball Screw
350548(803)	Needle Bar Rock Frame Driving Eccentric Friction Plate Screw(2)
351876	Spreader Driving Rock Shaft Screw Stud Ball Roller

FITTINGS

STANDARD GAUGES	LOOPER HOLDER	NEEDLE BAR ROCK FRAME THREAD GUIDE	NEEDLE HOLDER	PRESSER FOOT (COMPLETE)	SPREADER	THROAT PLATE
P300-2/206						
3/4"	268105	268255	268154	269574	268376	269597
7/8"	268105	268255	268154	269574	268376	269651
1"	268106	268256	268156	269574	268377	269598
1-1/4"	268107	268268	268157	269577	268378	269597
1-3/8"					268378	269651
1/1/2"	268107	268268	268157	269577	268378	269598
1-3/4"	268282	268304	268158	269577	268379	269597
2"	268282				268379	
P300-2/406						
1/4, 1/4, 1/4"	269065	269138	269191	269237	269342	269597
5/16, 5/16, 5/16"	269065	269138	269192	269237	269342	269652
3/8, 3/8, 3/8"	269065	269138	269192	269237	269342	269652
1/2, 1/2, 1/2"	269065	269138	269193	269240	269342	269598
1/4, 1, 1/4"	269065	269138	269193	269240	269342	269598

When Ordering Fittings, State Gauge Required.

P300-2 Basic DROP FEED PARTS

NUMBER	DESCRIPTION
200040(830)	Feed Dog Shank Screw
200061(833)	Feed Driving Rock Shaft Crank Pinch Screw(2)
200061(833)	Feed Lifting Rock Shaft Crank Pinch Screw(2)
200078(806)	Feed Regulating Stud Socket Screw(2)
200100(803)	Feed Dog Screw(2)
200123(804)	Feed Driving Connection Cap Screw
200354(803)	Feed Driving Rock Frame Position Screw
200362(803)	Feed Driving Rock Frame Set Screw
200373(803)	Feed Lifting Link Hinge Pin Set Screw (2)
200380(830)	Feed Bar Hinge Pin Collar Set Screw
200382(833)	Feed Driving Eccentric Adjusting Disc Spring Collar Set Screw(2)
200386(830)	Feed Driving Rock Shaft Collar Set Screw(4)
200386(803)	Feed Lifting Rock Shaft Collar Set Screw(4)
200394(803)	Feed Lifting Eccentric Set Screw(2)
200403(830)	Feed Bar Set Screw(2)
201256(830)	Feed Lifting Crank Pinch Screw
201418(803)	Feed Lifting Rock Shaft Crank Position Screw
201522(805)	Feed Driving Connection Hinge Stud Nut
201522(805)	Feed Lifting Connection Hinge Stud Nut
201525(805)	Feed Dog Shank Screw Lock Nut
201537(819)	Feed Dog Shank Adjusting Screw Lock Nut
202574	Feed Bar Hinge Pin Collar with 200380(830)
208636	Feed Dog Shank Screw Washer
240245	Feed Regulating Stud Retaining Spring
241763	Feed Driving Eccentric Friction Plate Screw Set Screw Packing (brass)(2)
267623	Feed Driving Eccentric Friction Plate
268034	Feed Bar with 200373(803) and two 200403(830)
268035	Feed Bar Hinge Pin
268047	Feed Lifting Eccentric with 268077 and two 200394(803)
268060	Feed Driving Connection
268061	Feed Driving Connection 268060 with 268063
268062	Feed Driving Connection Hinge Stud with 268258
268062	Feed Lifting Connection Hinge Stud with 268258
268063	Feed Driving Connection Needle Bearing
268065	Feed Driving Eccentric Adjusting Disc

NOTE: When ordering replacement parts from this catalog, a "P" prefix must be added to all part numbers required.

NUMBER	DESCRIPTION
268066	Feed Driving Eccentric Adjusting Disc Spring
268067	Feed Driving Eccentric Adjusting Disc Spring Collar with two 200382(833)
268069	Feed Driving Rock Frame with 200354(803) and 200362(803)
268071	Feed Driving Rock Shaft Needle Bearing(2)
268071	Feed Lifting Rock Shaft Needle Bearing(2)
268072	Feed Driving Rock Shaft Collar with two 200386(830)(2)
268072	Feed Lifting Rock Shaft Collar with two 200386(803)(2)
268073	Feed Driving Rock Shaft Crank with two 200061(833)
268074	Feed Lifting Connection
268075	Feed Lifting Crank with 200373(803) and 201256(830)
268077	Feed Lifting Eccentric Lubricating Pad (wood)
268078	Feed Lifting Link
268079	Feed Lifting Link Hinge Pin with 268258(2)
268081	Feed Regulating Stud
268082	Feed Regulating Stud Socket
268198	Feed Lifting Rock Shaft Crank with 201418(803) and two 200061(833)
268258	Feed Driving Connection Hinge Stud Oil Packing (wick)
268258	Feed Lifting Connection Hinge Stud Oil Packing (wick)
268258	Feed Lifting Link Hinge Pin Oil Packing (wick)(2)
268315	Feed Driving Flange with 267623, two each 241763, 350467(830), 350477(830) and 350548(803)
268316	Feed Dog Shank with 201537(819) and 350552(830)
269684	Feed Driving Rock Shaft
269685	Feed Lifting Rock Shaft
269686	Feed Dog, 40 needle hole, with 267669 and two 200907(819) for 269689
270026	Feed Regulating Stud Spring
350467(830)	Feed Driving Flange Set Screw(2)
350477(830)	Feed Driving Eccentric Friction Plate Screw Set Screw(2)
350548(803)	Feed Driving Eccentric Friction Plate Screw(2)
350552(830)	Feed Dog Shank Adjusting Screw

P300-2/206, 406 PULLER FEED PARTS

NUMBER	DESCRIPTION
913(806)	Puller Feed Roll (upper) Bar Spring Adjusting Screw(2)
200017(803)	Puller Feed Cross Shaft Bracket Screw(2)
200017(803)	Puller Feed Driving Shaft Bracket Screw(3)
200035(803)	Puller Feed Roll (lower) Chain Idler Sprocket Bracket Screw(2)
200041(805)	Puller Feed Driving Shaft Cover Screw (lower)
200084(850)	Puller Feed Roll (upper) Bar Lifter Arm Screw(2)
200354(803)	Puller Feed Roll (lower) Position Screw
200362(803)	Puller Feed Cross Shaft Worm Gear Set Screw(2)
200362(803)	Puller Feed Driving Shaft Worm Gear Set Screw
200362(803)	Puller Feed Roll (lower) Set Screw
200378(803)	Puller Feed Driving Shaft Collar Set Screw(2)
200382(833)	Puller Feed Cross Shaft Worm Set Screw
200382(833)	Puller Feed Driving Shaft Worm Set Screw(2)
200382(833)	Puller Feed Roll (upper) Bracket Set Screw(2)
200394(803)	Puller Feed Roll (lower) Shaft Collar Set Screw(4)
200447(830)	Puller Feed Driving Shaft Sprocket Set Screw
200563(805)	Puller Feed Roll (upper) Bar Bracket Screw (lower)
200571(804)	Puller Feed Driving Shaft Cover Screw (upper)(2)
200572(803)	Puller Feed Roll (upper) Bar Position Bracket Adjusting Screw(2)
201052(833)	Puller Feed Driving Shaft Thrust Collar Set Screw
201168(803)	Puller Feed Roll (lower) Shaft Sprocket Set Screw
201220(833)	Puller Feed Cross Shaft Worm Position Screw
201220(833)	Puller Feed Driving Shaft Worm Gear Position Screw
201220(833)	Puller Feed Roll (upper) Bracket Position Screw(2)
201308(805)	Puller Feed Roll (upper) Bar Bracket Screw (upper)
232866	Puller Feed Cross Shaft Bracket Position Pin(2)
232866	Puller Feed Driving Shaft Bracket Position Pin(4)
267110	Puller Feed Roll (upper) Needle Bearing(4)
268424	Puller Feed Driving Shaft Collar with two 200378(803)
268425	Puller Feed Cross Shaft Needle Bearing(2)
268425	Puller Feed Driving Shaft Needle Bearing(2)
268428	Puller Feed Roll (upper) Bar(2)
268448	Puller Feed Driving Shaft Bracket
268449	Puller Feed Driving Shaft Bracket 268448 with 268425
269618	Puller Feed Roll (lower) Shaft Collar with two 200394(803)(2)
269621	Puller Feed Cross Shaft
269622	Puller Feed Cross Shaft Bracket
269623	Puller Feed Cross Shaft Bracket 269622 with two 268425
269624	Puller Feed Cross Shaft Worm with 200382(833) and 201220(833)
269625	Puller Feed Cross Shaft Worm Gear with two 200362(803)
269626	Puller Feed Driving Shaft
269628	Puller Feed Driving Shaft Cover
269629	Puller Feed Driving Shaft Sprocket with 200447(830)
269630	Puller Feed Driving Shaft Thrust Collar with 201052(833)
269631	Puller Feed Driving Shaft Worm with two 200382(833) (for 9 stitches per inch)
269632	Puller Feed Driving Shaft Worm Gear with 200362(803) and 201220(833) (for 9 stitches per inch)
269633	Puller Feed Roll (lower) with 200354(803) and 200362(803)
269634	Puller Feed Roll (lower) Chain
269635	Puller Feed Roll (lower) Chain Idler Sprocket
269636	Puller Feed Roll (lower) Chain Idler Sprocket Bracket with 350558(819)
269637	Puller Feed Roll (lower) Chain Idler Sprocket Pin
269638	Puller Feed Roll (lower) Shaft
269639	Puller Feed Roll (lower) Shaft Sprocket with 201188(803)
269640	Puller Feed Roll (upper)(2)
269641	Puller Feed Roll (upper) Bar Bracket
269642	Puller Feed Roll (upper) Bar Lifter Arm (left)
269643	Puller Feed Roll (upper) Bar Lifter Arm (right)
269644	Puller Feed Roll (upper) Bar Lifter Arm Block
269645	Puller Feed Roll (upper) Bar Position Bracket with 200572(803) and 350328(803)(2)
269646	Puller Feed Roll (upper) Bar Spring(2)
269647	Puller Feed Roll (upper) Bracket with 200382(833) and 201220(833)(2)
269648	Puller Feed Roll (upper) Shaft(2)
269649	Puller Feed Driving Shaft Bracket (right)
269650	Puller Feed Driving Shaft Bracket 269649 with 268425 (Needle Bearing on left)
269670	Puller Feed Roll (upper) 269640 with two 267110(2)
269671	Puller Feed Roll (upper) Shaft Retaining Ring(2)
269672	Puller Feed Roll (lower) Shaft Needle Bearing(2)
350149(803)	Puller Feed Roll (upper) Bar Lifter Arm Block Screw(2)
350328(803)	Puller Feed Roll (upper) Bar Position Bracket Pinch Screw(2)
350558(819)	Puller Feed Roll (lower) Chain Idler Sprocket Pin Set Screw
350629(805)	Puller Feed Driving Shaft Bracket Screw (lower)

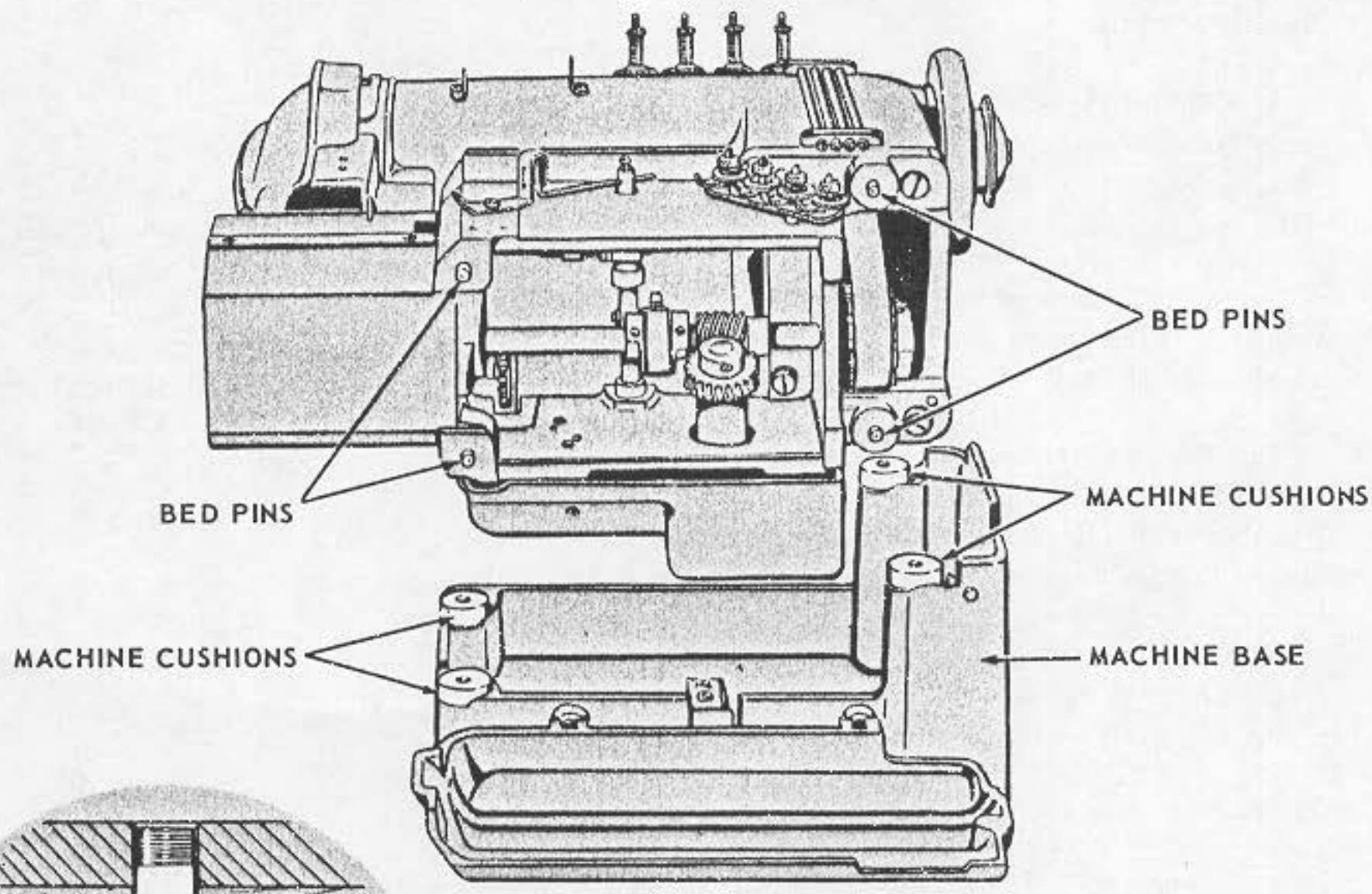
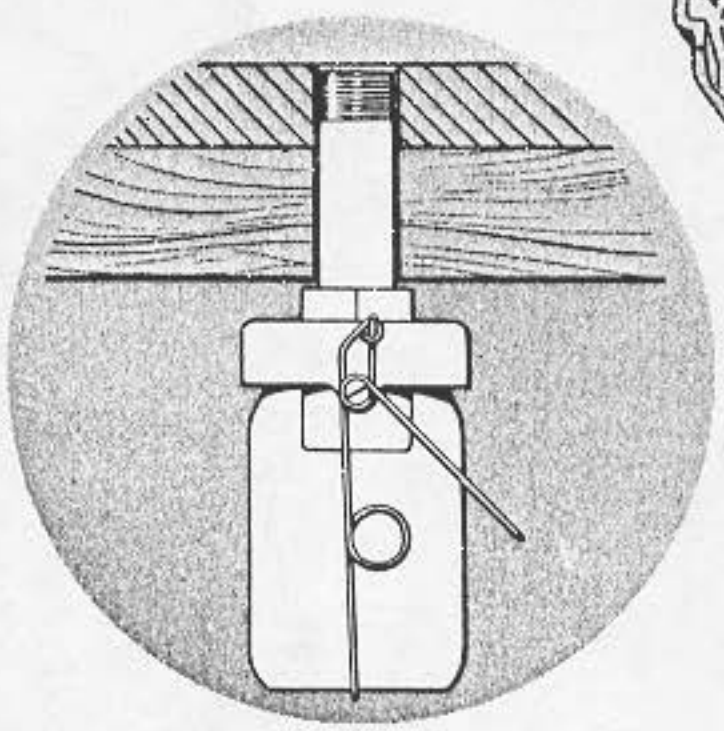


Fig. 2. Installation



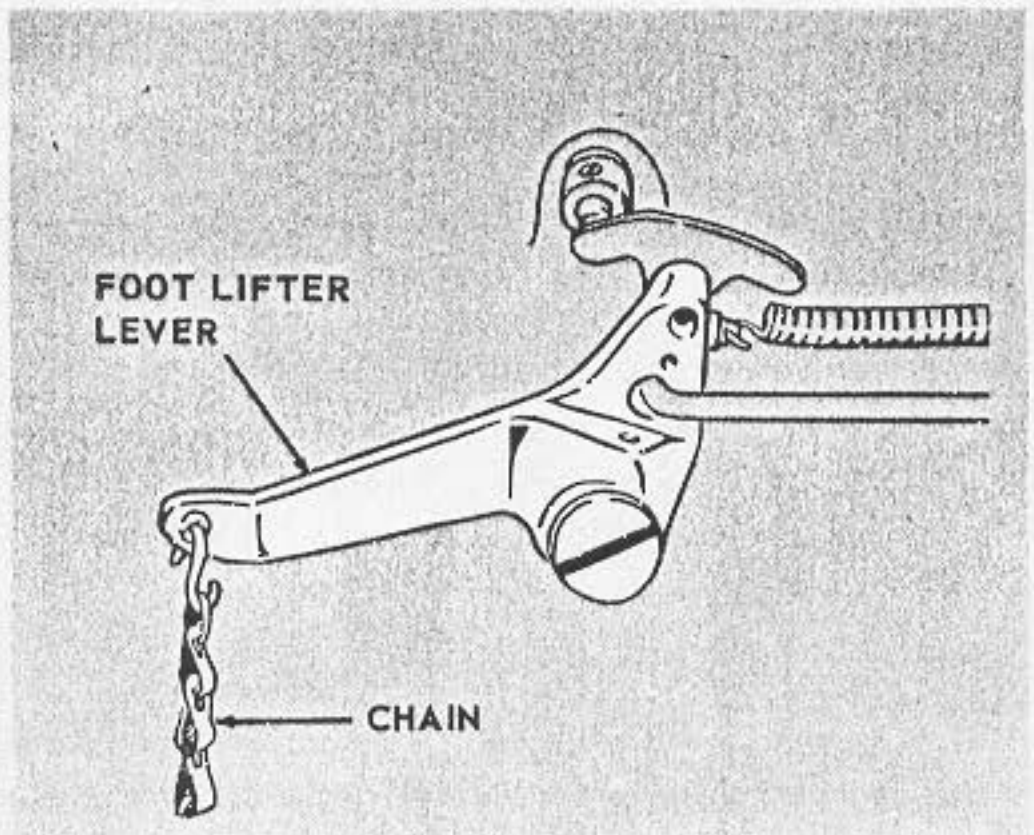


Fig. 3. Foot Lifter Lever

INSTALLATION

Fasten machine base to table with hole for oil drain jar aligned with hole in table. Attach oil drain jar.

Set machine onto machine base by inserting bed pins into machine cushions as shown in Fig. 2.

Connect foot lifter lever to foot lifter treadle with chain furnished for this purpose.

LUBRICATION

These machines have an automatic oiling system consisting of a hollow arm shaft and hollow bed shaft which act as reservoirs. Oil is delivered by centrifugal force, through small jets in the shafts, to all principle bearings when the machine is operating.

Oil holes are provided for lubricating movable parts in contact which are not lubricated from the reservoirs.

P486-72

Supplement to
Parts Chart
Form P21367

LIST OF PARTS FOR P300-2/201 MACHINE SAME AS BASIC MACHINE P300-2 WITH THE FOLLOWING EXCEPTIONS

267821 Feed Dog with two 268318 and four 200172(804) 15TPL #46 N,H. for 7/8'' gauge (code 056). When ordering state gauge.

267825 Feed Dog with two 268318 and four 200172(804) 15TPI #46 N.H. for 1'' gauge.(code 100) and 1-1/4'' gauge (code 116). When ordering state gauge.

267829 Feed Dog with two 268318 and four 200172(804) 15TPI #46D N.H. for 1-3/8'' gauge (code 124) and 1-1/2'' gauge (code 132). When ordering state gauge.

268105 Looper Holder with four 350478(803) for 7/8'' gauge (code 056). When ordering state gauge.

268106 Looper Holder with four 350478(803) for 1'' gauge (code 100). When ordering state gauge.

268107 Looper Holder with four 350478(803) for 1-1/4'' gauge (code 116) 1-3/8'' gauge (code 124) and 1-1/2'' gauge (code 132). When ordering state gauge.

268136 Needle Bar.

268255 Needle Bar Rock Frame Thread Guide for 7/8'' gauge.(code 056). When ordering state gauge.

268256 Needle Bar Rock Frame Thread Guide for 1'' gauge (code 100). When ordering state gauge.

268268 Needle Bar Rock Frame Thread Guide for 1-1/4'' gauge (code 116) 1-3/8'' gauge (code 124) and 1-1/2'' gauge (code 132). When ordering state gauge.

268154 Needle Holder with two 50014(830) for 7/8'' gauge (code 056). When ordering state gauge.

268156 Needle Holder with two 50014(830) for 1'' gauge (code 100). When ordering state gauge.

269574 Pressor Foot (hinged, compensating) #46D N.H. for 7/8'' gauge (code 056) and 1'' gauge (code 100). When ordering state gauge.

269577 Pressor Foot (hinged, compensating) #46D N.H. for 1-1/4'' gauge (code 116) 1-3/8'' gauge (code 124) and 1-1/2'' gauge (code 132). When ordering state gauge.

268376 Spreader with two 268162 for 7/8'' gauge (code 056). When ordering state gauge.

268378 Spreader with two 268162 for 1-1/4'' gauge (code 116) 1-3/8'' gauge (code 124) and 1-1/2'' gauge (code 132). When ordering state gauge.

267858 Throat Plate for 7/8'' gauge.(code 056). When ordering state gauge.

NOTE: When ordering replacement parts from this catalog, a ''P'' prefix must be added to all part numbers required.

267859 Throat Plate for 1'' gauge (code 100) and 1-1/4'' gauge (code 116). When ordering state gauge.

267860 Throat Plate for 1-3/8'' gauge (code 124) and 1-1/2'' gauge (code 132). When ordering state gauge.

TWO EACH OF THE FOLLOWING PARTS ARE USED

268382 Looper and Needle Guard complete nos. 268310 and 268380.

268333 Looper Thread Tension Thread Guide.

268332 Looper Thread Tension complete, nos. 10148, 141432(819), 201572(819) and two 244048.

268132 Looper Thread Tube.

226206 Needle Thread Tension Releasing Pin.

54279 Needle Thread Tension Thread Guide (double).

268263 Needle Thread Tension complete nos. 32572, 59537, 59538, 59539, 131741 and two 2102.

THE FOLLOWING PARTS ARE NOT USED

269564 Edge Guide.

200161(850) Edge Guide Screw (2)

NOTE: The standard gauges are 1-1/4 - 1-3/8 and 1-1/2. The 7/8 and 1 are furnished on special order.

NOTE: When ordering replacement parts from this catalog, a ''P'' prefix must be added to all part numbers required.

Complete Lubrication of Machine is Necessary Before Operation

Use Union Special Oil, Specification 175, a water white straight mineral oil of a saybolt viscosity of 90 to 125 seconds at 100 degrees fahrenheit.

Arm shaft reservoir is filled through oil hole at end of machine pulley or at end of needle bar crank as shown in Fig. 4.

Needle bar connecting link needle bearings, connecting stud and needle bar bearings are readily accessible for lubrication under face plate as shown in Fig. 4.

Needle bar rock frame needle bearings are lubricated through oil hole indicated in Fig. 5.

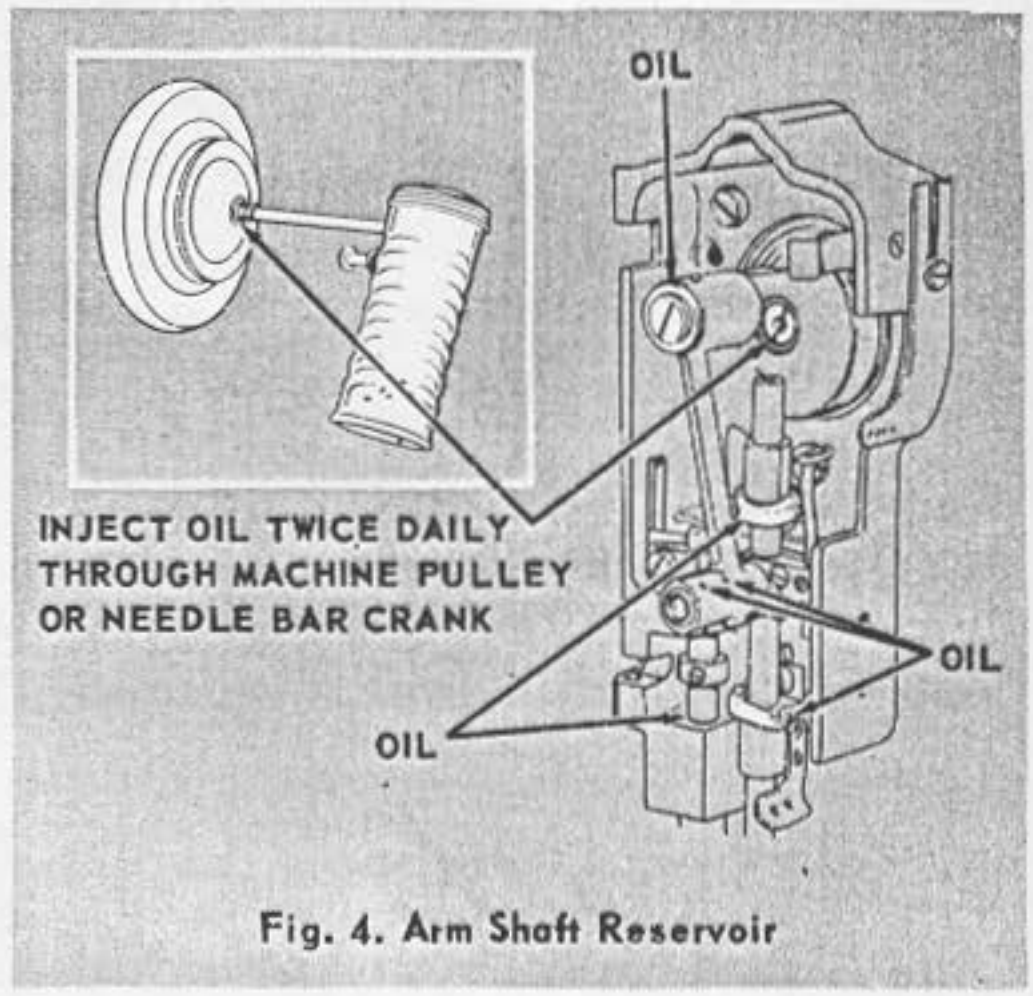
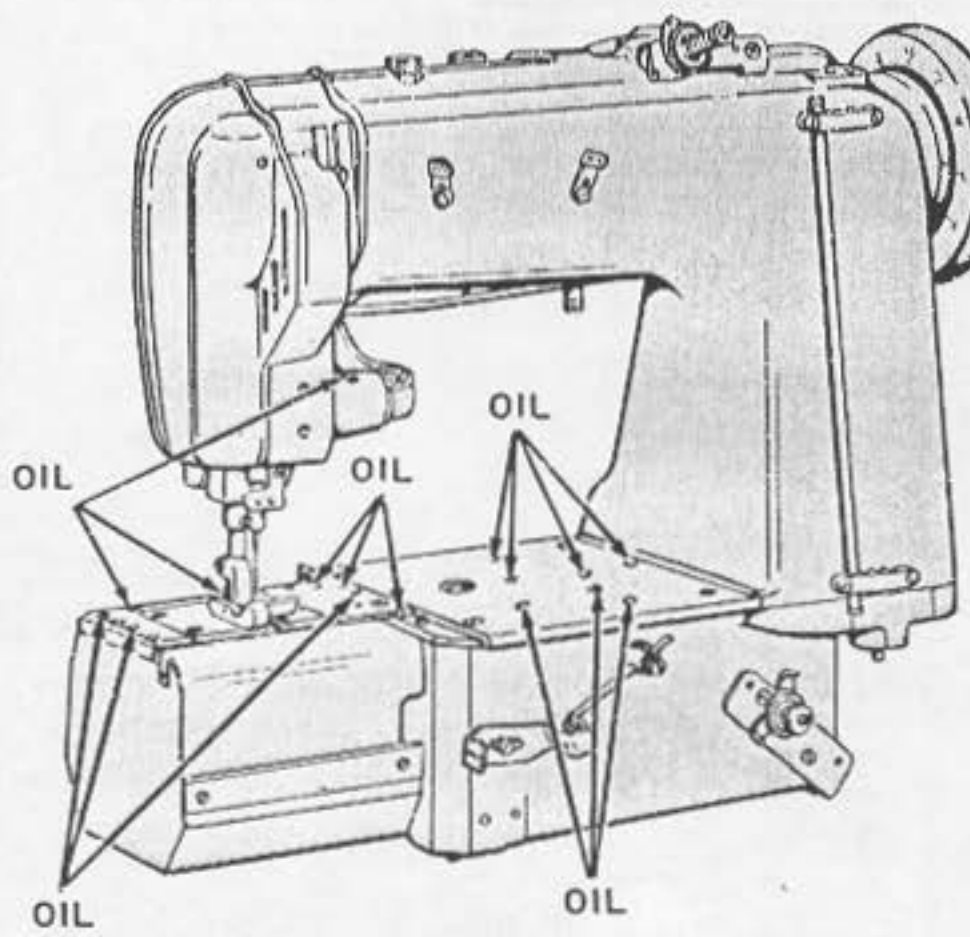
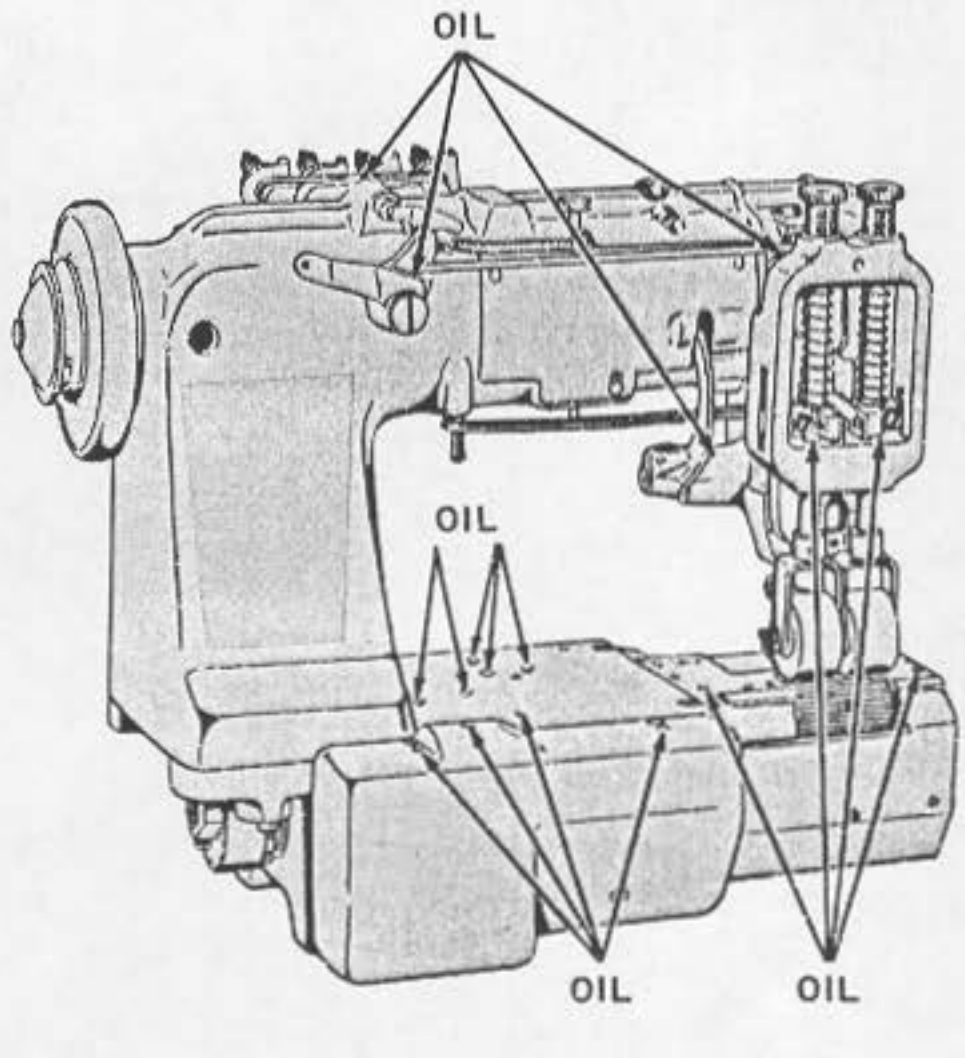


Fig. 4. Arm Shaft Reservoir



Needle Feed Machines



Puller Feed Machines

Fig. 5. Lubricating the Machine

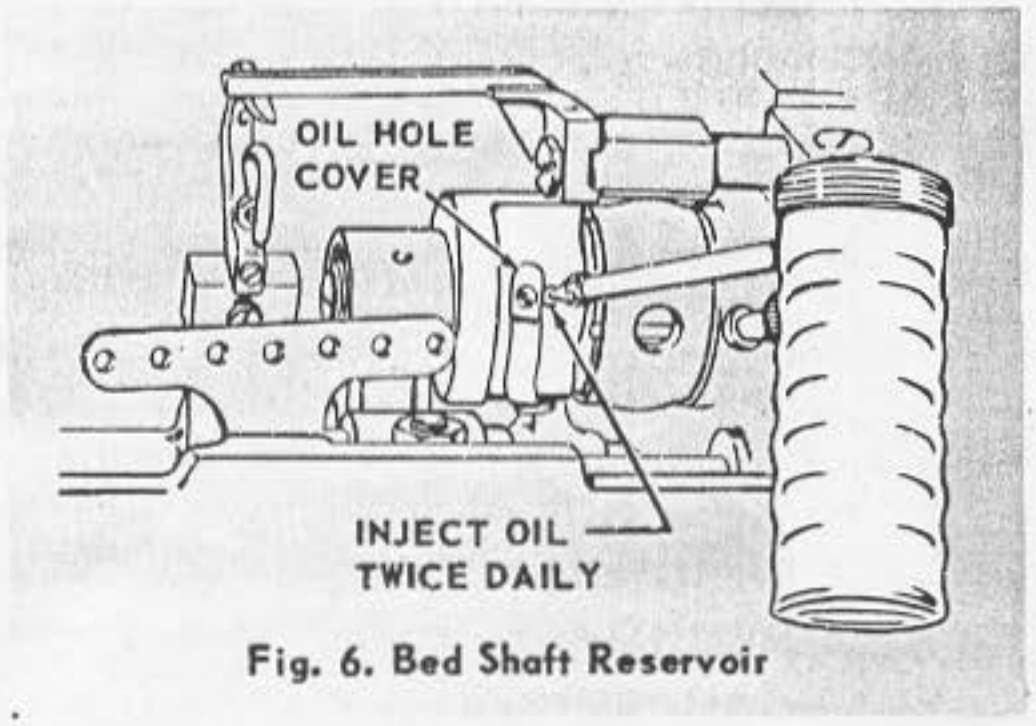


Fig. 6. Bed Shaft Reservoir

Bed shaft reservoir is filled through hole under looper driving crank oil hole cover, Fig. 6, or through oil hole at end of bed shaft connection belt pulley.

Moving parts under bed may be lubricated through holes in bed surface or by removing bed plates. Other moving parts in contact under bed and at rear of machine are provided with oil holes for efficient lubrication.

A machine in continuous use should be lubricated twice daily.

CLEANING

Using short bristled brush (not point of scissors or shears), remove lint or other waste from around the loopers, from between the feed rows and underside of the throat plate and from other operating parts. Wipe the exterior of machine with a soft cloth.

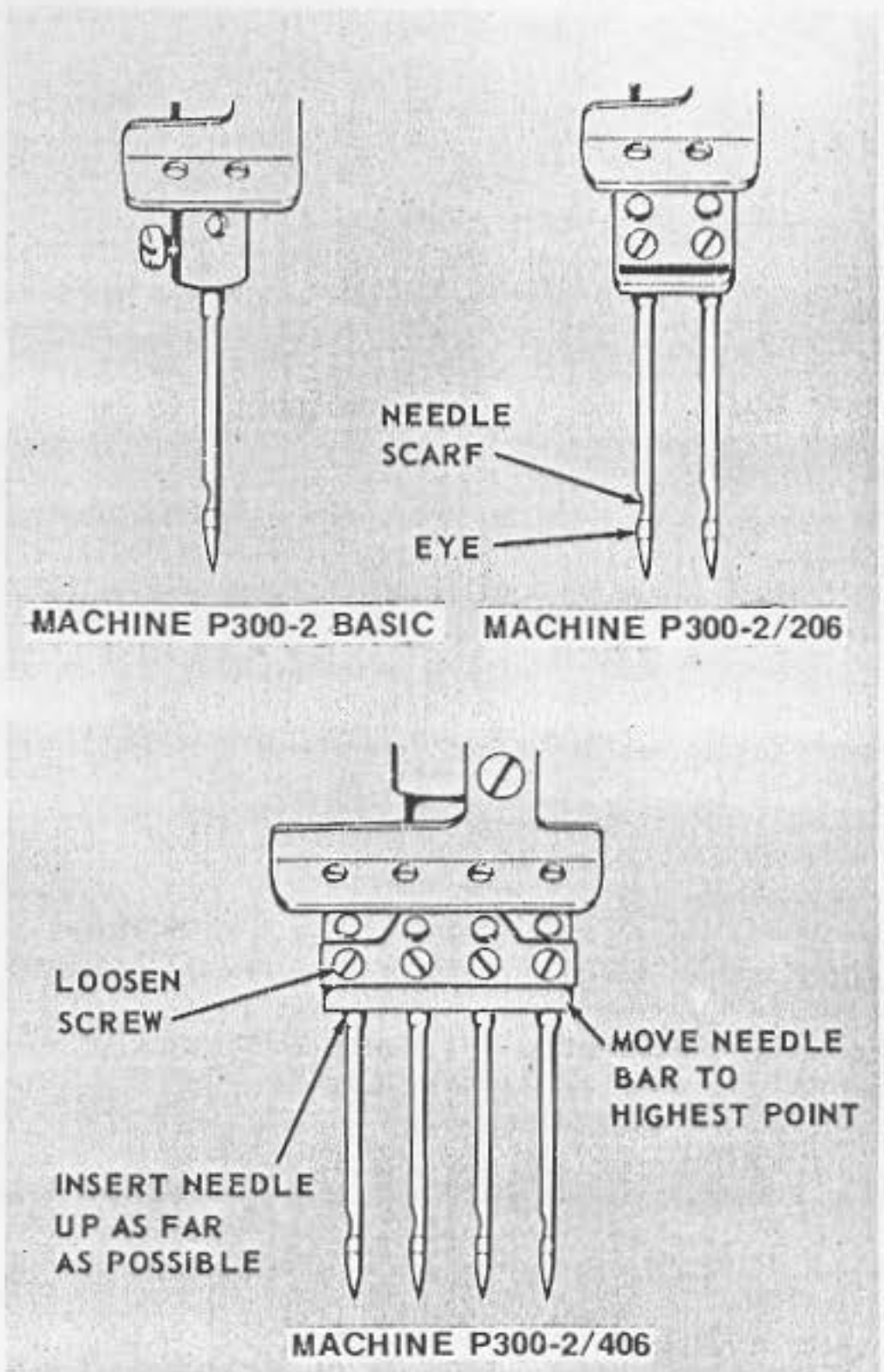


Fig. 7. Setting the Needle

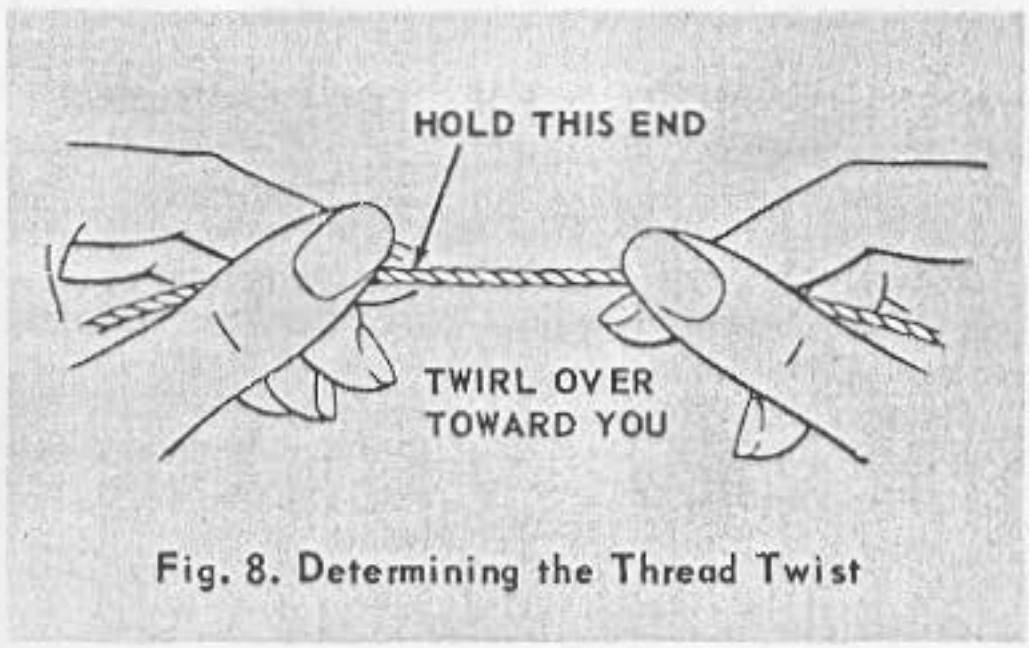


Fig. 8. Determining the Thread Twist

SPEED

Maximum speed for these machines is 4500 stitches per minute. Operating speed depends on material sewn and operation performed.

New machines should run at a speed of 500 stitches per minute less than maximum speed for the first 100 hours of operation.

NEEDLES

Use Union Special Needles, Catalog P3260, in sizes ranging from 14 to 25.

Size of needle for an operation is determined by size of thread used and type of material sewn.

Orders for needles should specify quantity required, catalog number and size number.

For Example:
100 Needles, Catalog P-3260, Size 22

SETTING THE NEEDLE

Turn machine pulley over toward operator until needle bar is at its highest position. Loosen needle set screw. Insert needle up into needle holder as high as it will go with needle scarf to left and eye of needle in line with horizontal machine arm, as shown in Fig. 7.

THREAD

Left twist thread should be used in the needles.

Either left or right twist thread may be used in the loopers.

Thread twist is determined by holding thread as indicated in Fig. 8. Twirl thread over toward you with thumb and forefinger of right hand. If left twist thread, strands will wind tighter. If right twist thread, strands will unwind or separate.

THREADING THE MACHINE

Upper Threading

Turn machine pulley over toward operator until needle bar is at its highest position.

Pass thread through threading points indicated in Fig. 9.

Draw about two inches of thread through needle eye to start sewing.

The P300-2/201, P300-2/206 and P300-2/406 are all threaded as indicated in Fig. 9.

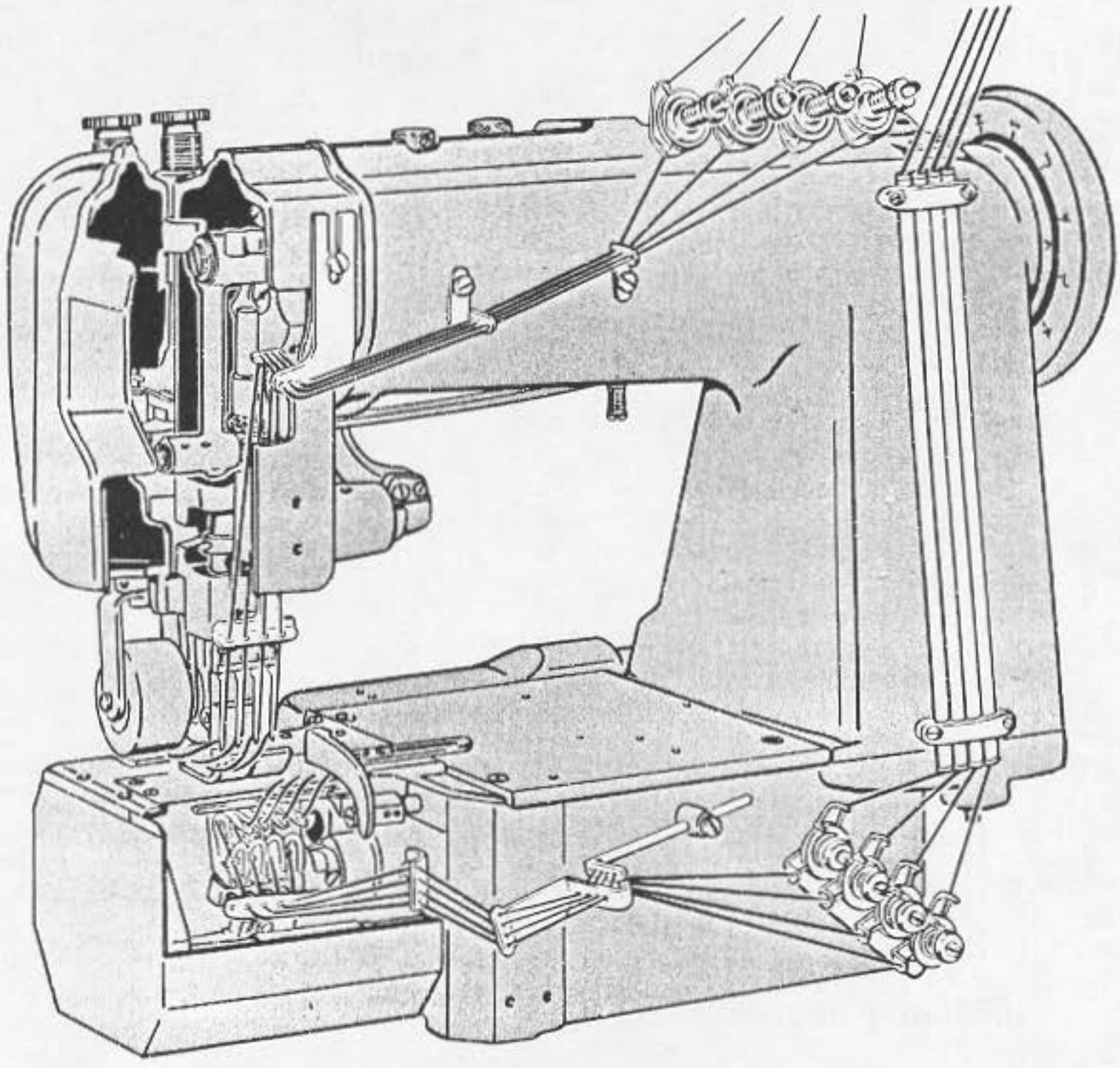
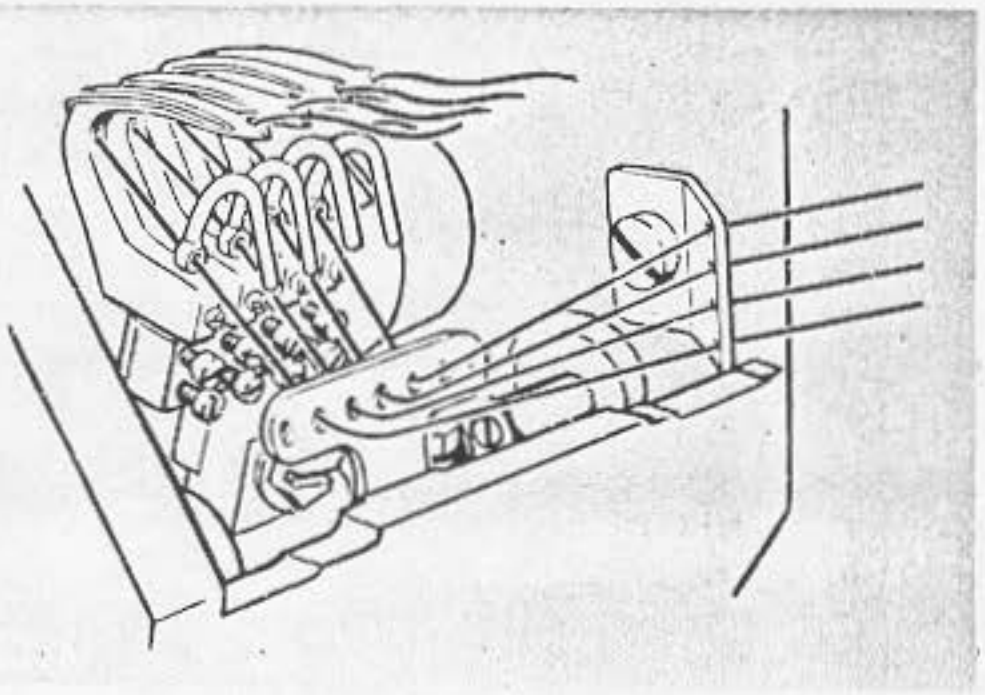


Fig. 9. Threading the Machine



Lower Threading

Turn machine pulley over toward operator until needle bar is at its highest position. Pass thread through threading points indicated in Fig. 9. When threading looper, insert wire threader into front of looper eye shown at left. With threading tweezers, drop thread into wire threader opening and draw wire threader toward you from back to front through the looper eye. Draw about two inches of thread through looper to start sewing.

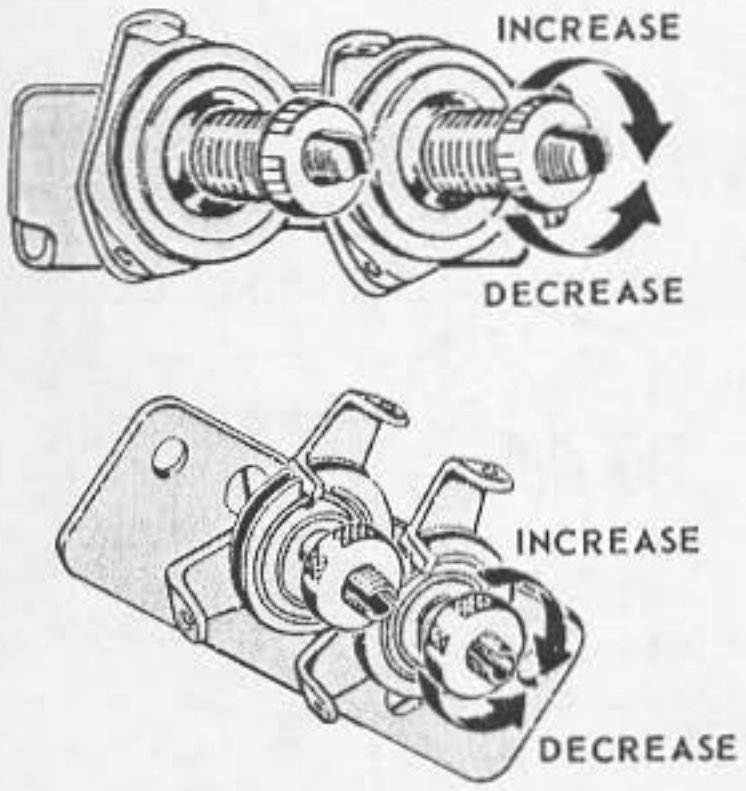


Fig. 10. Needle and Looper Thread Tensions

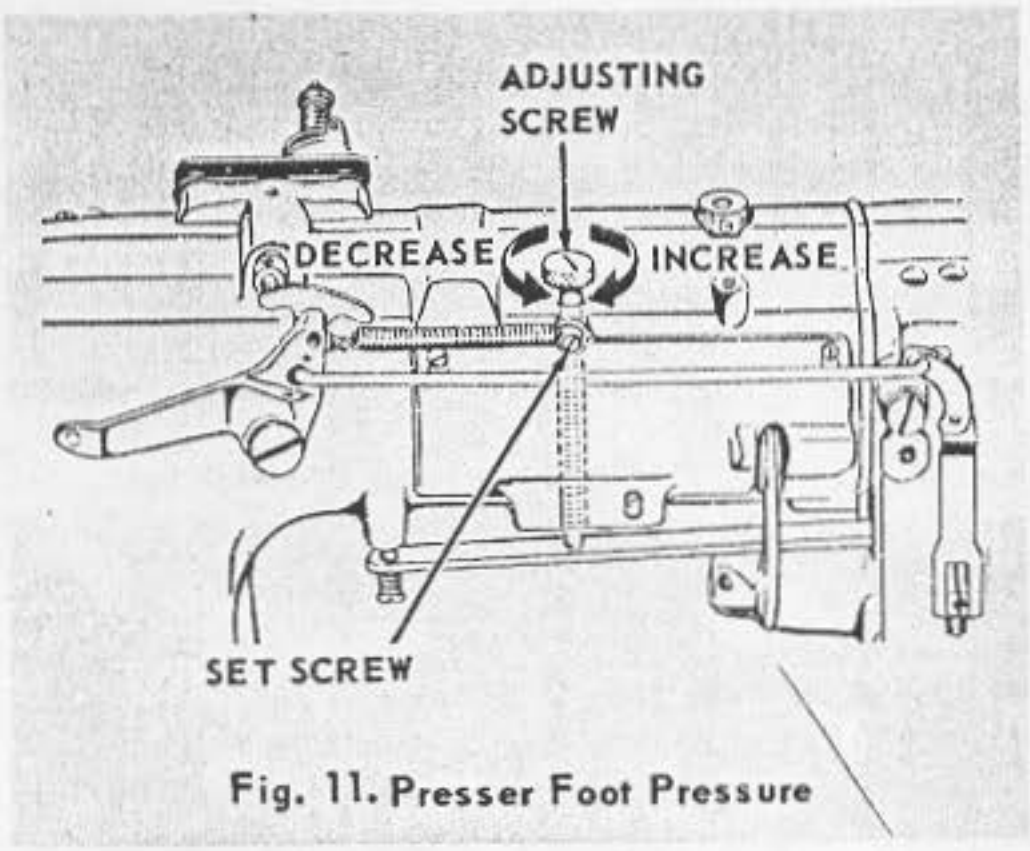


Fig. 11. Presser Foot Pressure

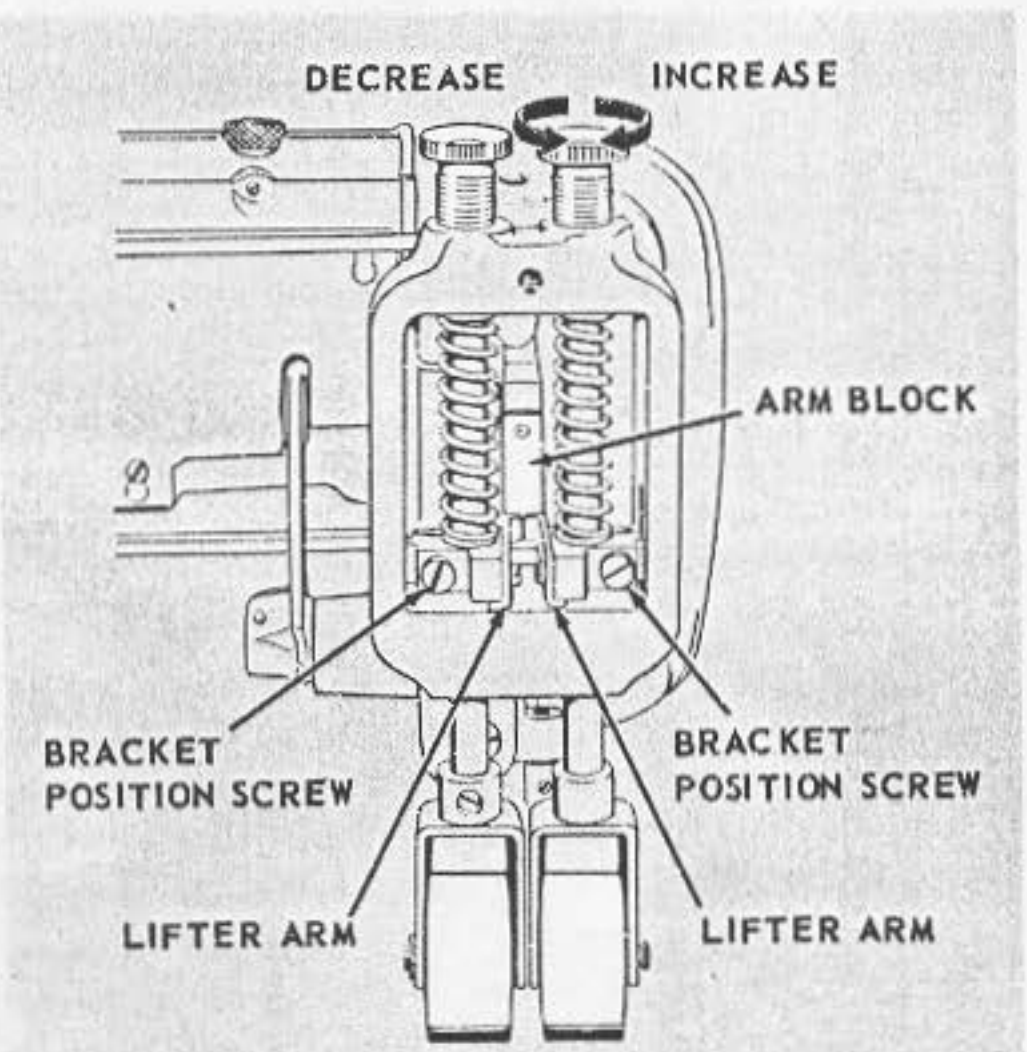


Fig. 12. Puller Feed Rolls

THREAD TENSIONS

Tension on thread should be as light as possible while sufficient to set stitches correctly in material.

Regulate Needle Thread Tensions Only When Presser Foot is Down

Needle thread tension and looper thread tension are regulated by thumb nuts shown in Fig. 10. To increase tension, turn thumb nuts over to right. To decrease tension, turn thumb nuts over to left.

PRESSURE ON MATERIALS

Pressure on material should be as light as possible while still sufficient to insure correct feeding.

Presser Foot

To regulate presser foot pressure, loosen set screw shown in Fig. 11. To increase pressure, turn adjusting screw in. To decrease pressure, turn adjusting screw out. Re-tighten set screw.

Puller Feed Roll

To increase puller feed roll pressure, turn adjusting screw (shown in Fig. 12) down. To decrease, turn up.

Puller Feed Roll Bar Position Brackets

Puller feed roll bar position brackets are correctly positioned when lifter arms are resting on arm block as shown in Fig. 12. If adjustment is required, loosen bracket position screw shown in Fig. 12 and lower bracket to correct position. Re-tighten bracket position screw.

STITCH LENGTH REGULATION

P300-0/201 - Needle Feed

To regulate stitch length, depress plunger on machine arm shown in Fig. 13 and turn machine pulley until plunger drops into recess in eccentric adjusting disc on arm shaft. **NEVER DEPRESS PLUNGER WHEN MACHINE IS OPERATING.** Turn plunger to lock in "Down" position. With machine pulley in this position, the button on bed surface should drop into recess in eccentric adjusting disc on bed shaft. When both plunger and button are in "Down" position, turn machine pulley until desired stitch length is opposite indicating arrow on machine arm. Release plunger and button. **NEVER START MACHINE UNTIL PLUNGER AND BUTTON ARE RELEASED.**

The letter "A" opposite the indicating arrow represents the longest stitch length and the letter "L" represents the shortest stitch length.

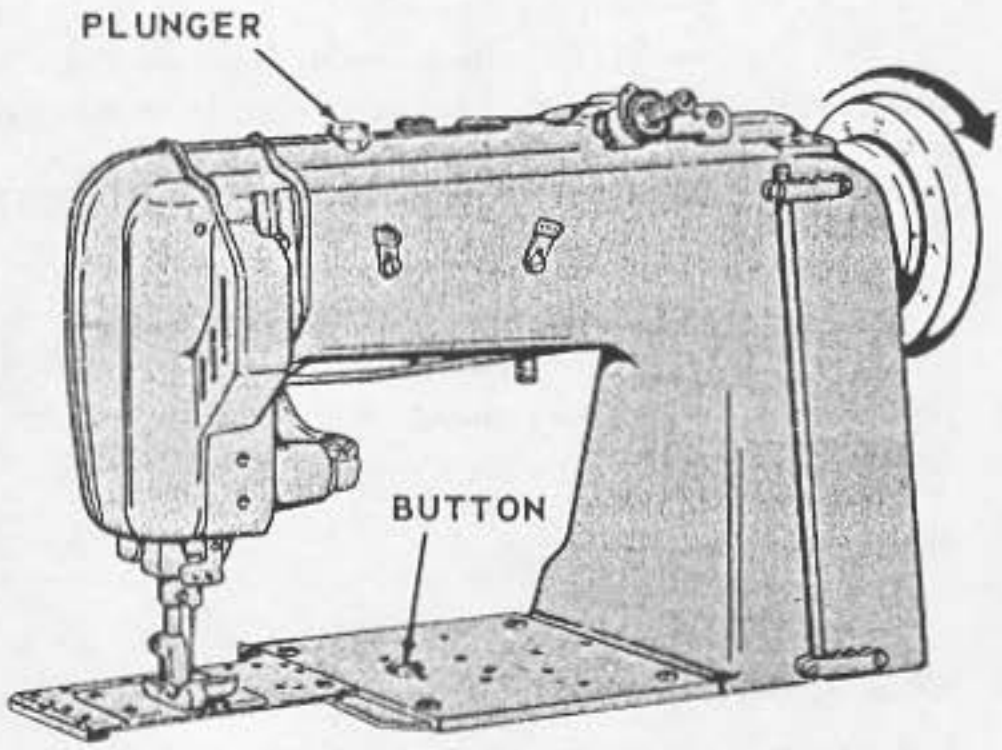


Fig. 13. Stitch Length Regulation

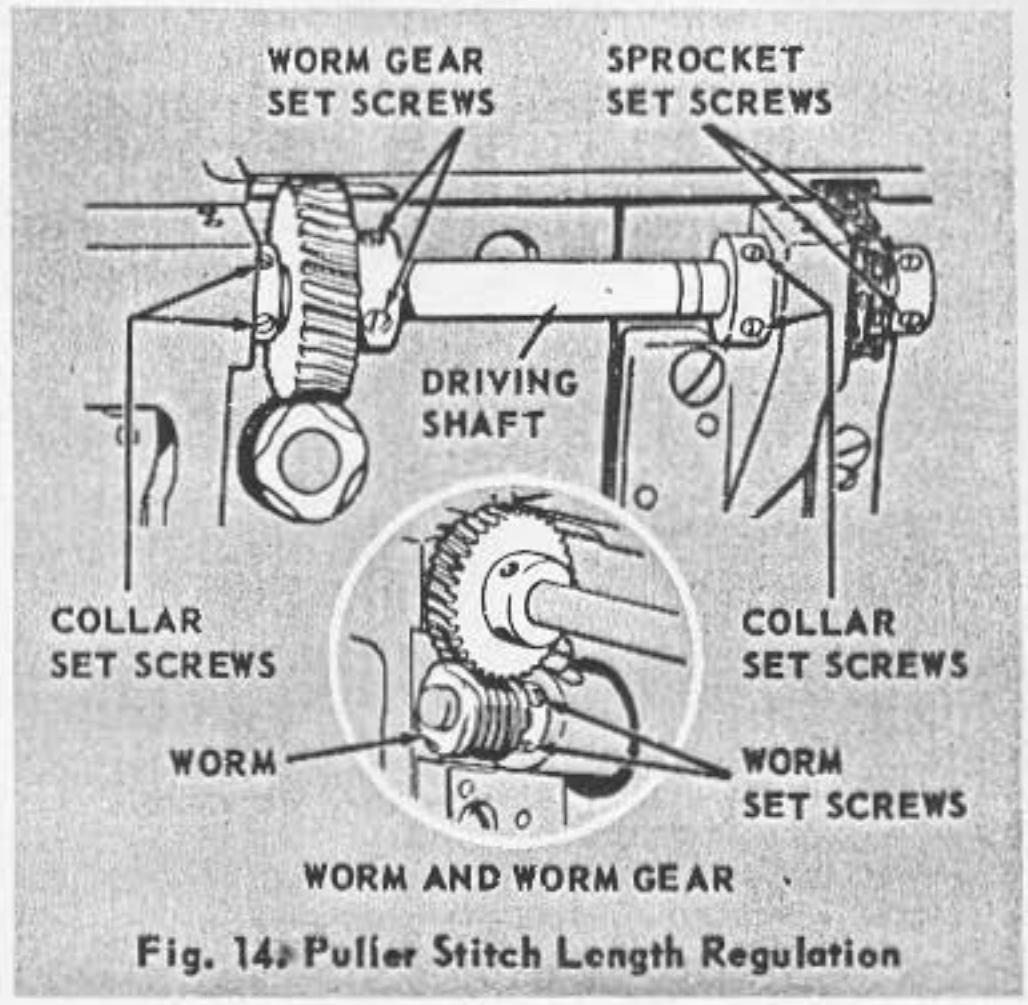


Fig. 14. Puller Stitch Length Regulation

P300-2/206 and P300-2/406 — Puller Feed

Puller feed stitch length is regulated by changing the worm and worm gear shown in Fig. 14. These puller feed machines are regularly furnished with a worm and worm gear for 9 stitches per inch but can be fitted for stitch lengths ranging from 4 to 12 per inch. To change puller feed stitch length worm and worm gear, first remove cover from rear of machine. Loosen collar set screws, worm gear set screws, worm set screws and sprocket set screws. Slide driving shaft to right far enough to allow for removal of worm and worm gear. Place new worm on cross shaft and turn worm in operating direction so that first set screw is tightened into flat of cross shaft. Tighten the other worm set screw, also. Place worm gear on driving shaft in a position engaged with worm and set shaft in brackets so that end of shaft is flush with end of sprocket as shown in Fig. 14. Tighten worm gear set screws and sprocket set screws. Set collars against brackets to remove end play as shown in Fig. 14 and tighten collar set screws.

Synchronizing Needle Feed with Puller Feed

Depress plunger on machine arm shown in Fig. 15 and turn machine pulley until plunger drops into recess in eccentric adjusting disc. **NEVER DEPRESS PLUNGER WHEN MACHINE IS OPERATING.** Then turn machine pulley toward operator to increase stitch length, or away from operator to decrease stitch length. Release plunger. **NEVER START MACHINE UNTIL PLUNGER IS RELEASED.** Repeat this procedure to gradually increase or decrease the needle feed stitch length until it matches puller feed stitch length.

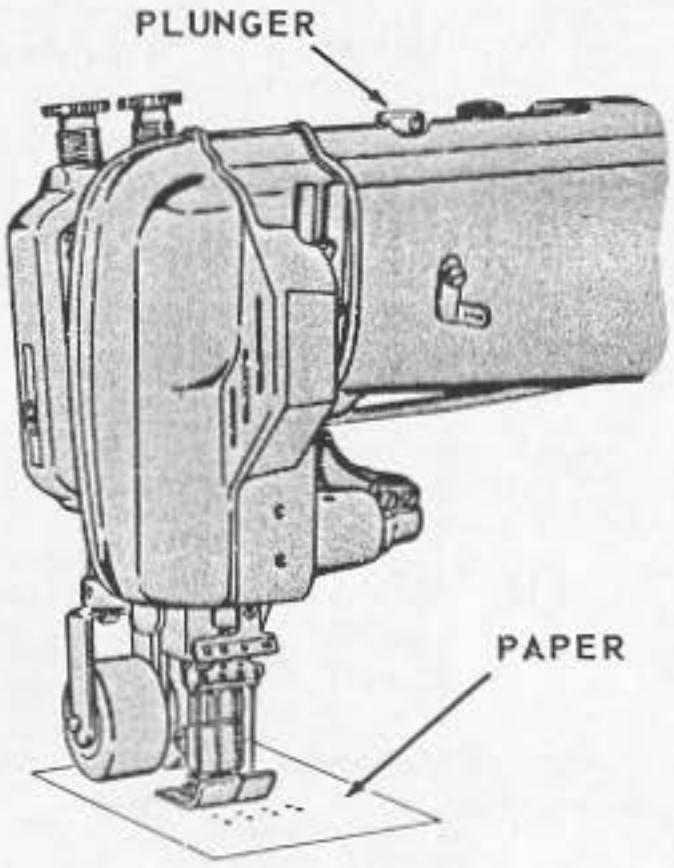


Fig. 15. Synchronizing Needle Feed with Puller Feed

One method of determining whether needle feed is synchronized with puller feed is by using an ordinary sheet of paper. Raise puller feed rolls and presser foot and place paper in sewing position. Lower puller feed rolls and presser foot onto paper. Rotate machine pulley by hand through a few stitching cycles. If needle feed is synchronized with puller feed, the holes in the paper produced by the needles will be the same size as the needles. If the needle feed is not synchronized with the puller feed, the needles will tear the paper, producing oblong shaped holes. Continue adjusting needle feed in this way until the needles produce circular holes of their own size in the paper.

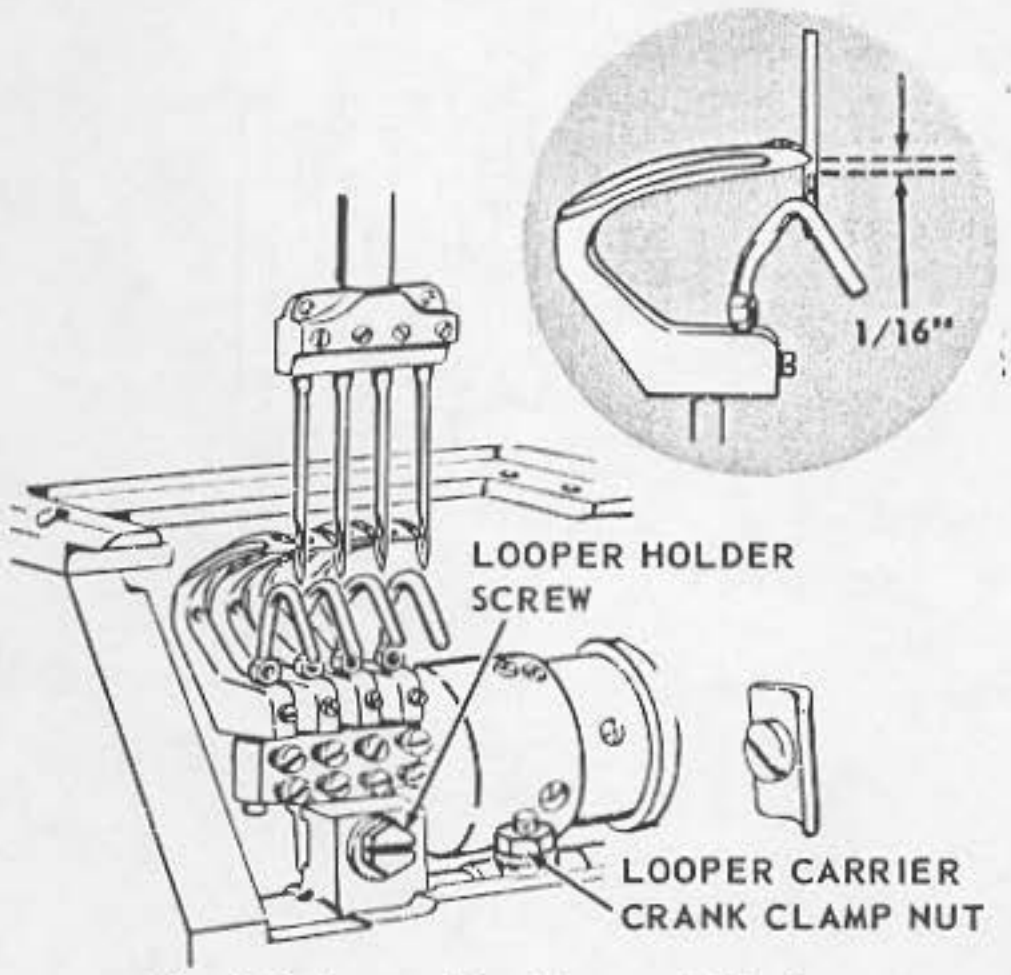


Fig. 16. Looper Position and Timing

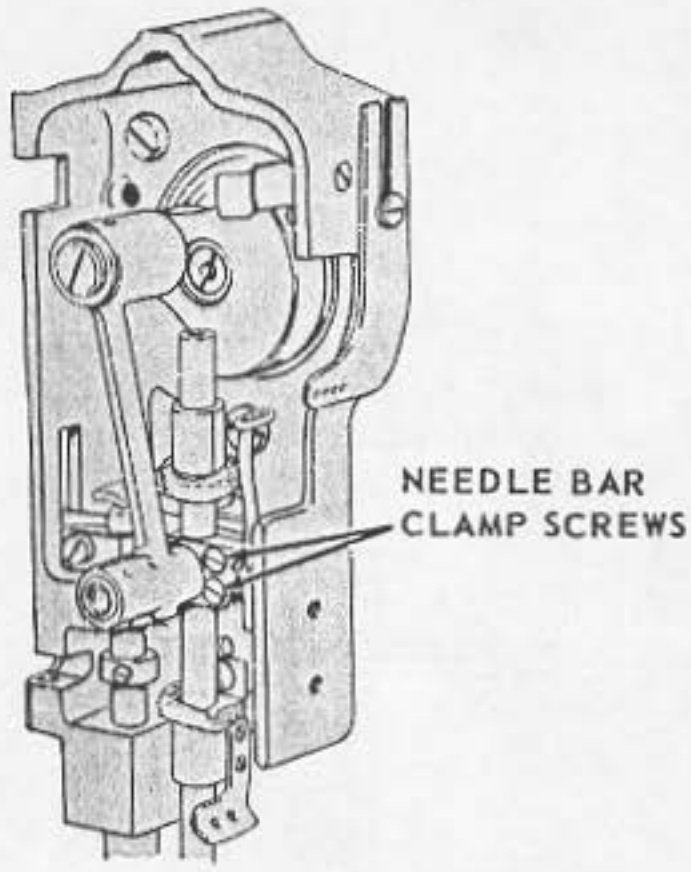


Fig. 17. Setting Needle Bar

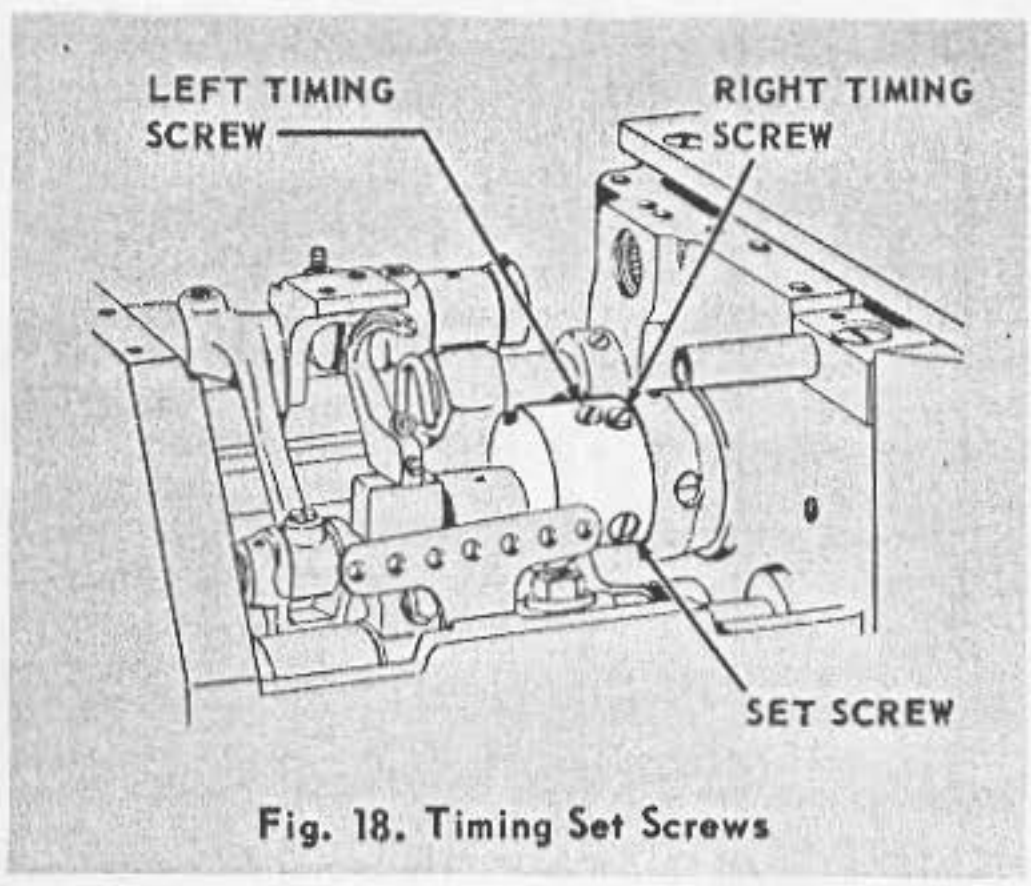


Fig. 18. Timing Set Screws

LOOPER POSITION

The loopers should be inserted into the looper holder, down to their lowest position. The looper points should pass the needle scarfs as close as possible (without hitting the needles) approximately 1/16 inch above the upper edge of the needle eye as shown in Fig. 16. If adjustment is required, loosen looper holder screw shown in Fig. 16 and tap looper holder toward or away from needle as required.

LOOPER TIMING AND NEEDLE BAR SETTING

When looper timing mark "LT" on machine pulley is opposite indicating arrow on machine arm, the looper point should be at the center of the needle blade. If adjustment is required, loosen looper carrier crank clamping nut shown in Fig. 16 and move looper carrier forward or backward to correct position.

With looper point at the center of needle blade, the needle bar height is correct when the upper edge of the needle eye is about 1/16 inch below the looper point. If adjustment is required, loosen needle bar clamping screws shown in Fig. 17 and raise or lower needle bar to correct position.

Turn machine pulley over until letter "G" is opposite indicating arrow on machine arm. At this position the looper point should again be at the center of the needle blade about 1/16 inch above the upper edge of the needle eye. When adjustment is required, loosen set screw indicated in Fig. 18. Then, loosening the right timing screw shown in Fig. 18 and tightening the left timing screw moves the looper point forward in its cycle with respect to the needle. Loosening the left timing screw and tightening the right timing screw moves the looper point backward in its cycle with respect to the needle. Adjust timing screws and looper carrier until the looper driving crank positions the looper point about 1/16 inch above the upper edge of the needle eye on its forward and reverse stroke.

NEEDLE BAR POSITIONING

Needles should enter the needle holes of the feed dog or throat plate toward the front and centered with respect to the sides. To adjust, press needle bar rock frame, Fig. 19, against drive arm, and at the same time loosen the two driving arm clamp screws. Continue holding the rock frame against the drive arm, move needle bar to correct position and tighten two clamp screws.

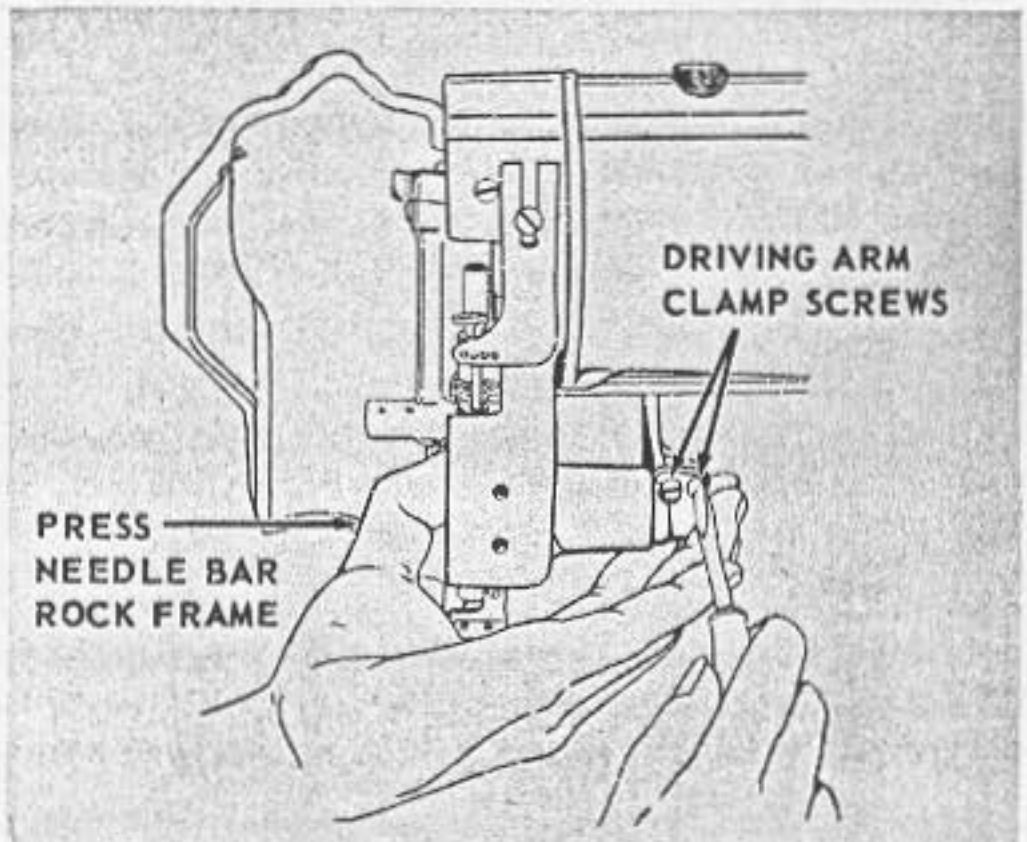


Fig. 19. Positioning Needle Bar Rock Frame

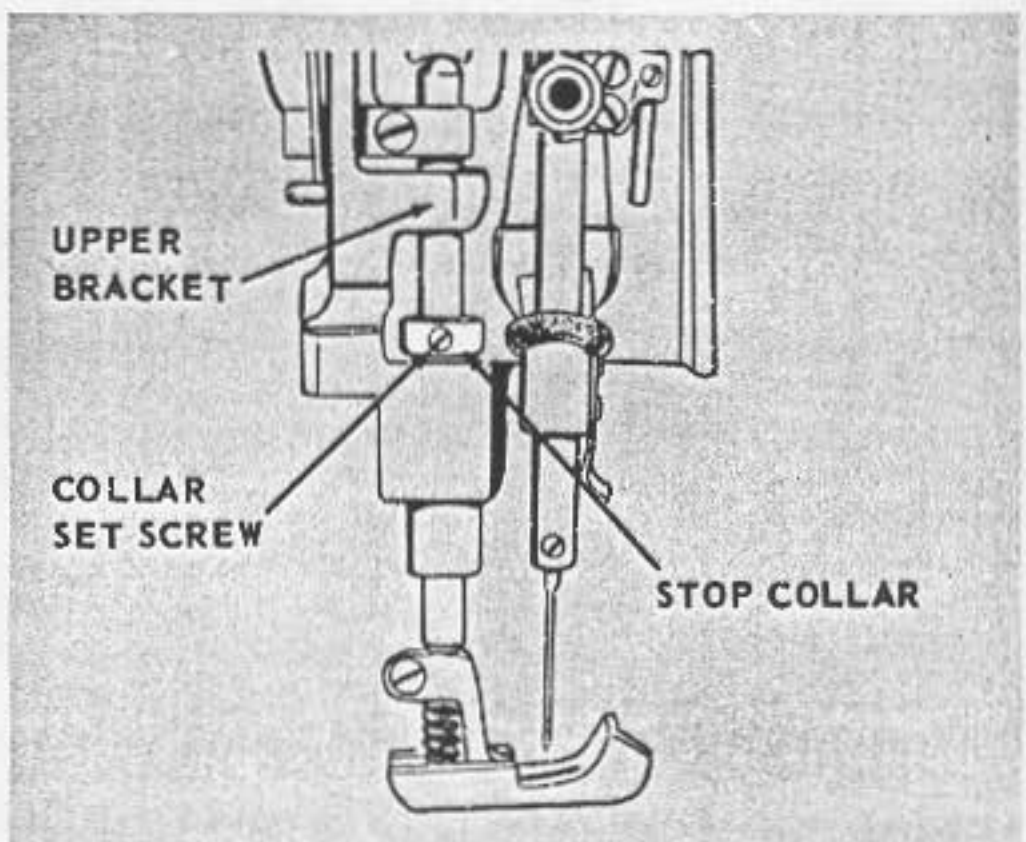


Fig. 20. Presser Bar Height Setting

PRESSER BAR LIFT

When the presser foot is raised by the presser bar lifter and the needle is at its highest position, the point of the needle should not protrude below the presser foot.

To adjust, turn machine pulley over toward operator until needle is at its highest position. Loosen collar set screw, Fig. 20. Raise presser foot to the correct height, place stop collar against upper bracket, and tighten the set screw.

POSITION OF SPREADER POINTS

Spreader Points in Relation to Loopers

The correct height of the spreader points as the loopers pass on their forward stroke is opposite the upper edge of the thread groove at the left side of the loopers as indicated in Fig. 21.

The clearance between the spreader points and the loopers should be approximately a double thickness of ordinary paper.

If adjustment is required, loosen spreader holder set screws, shown in Fig. 21 and set spreader points at correct position.

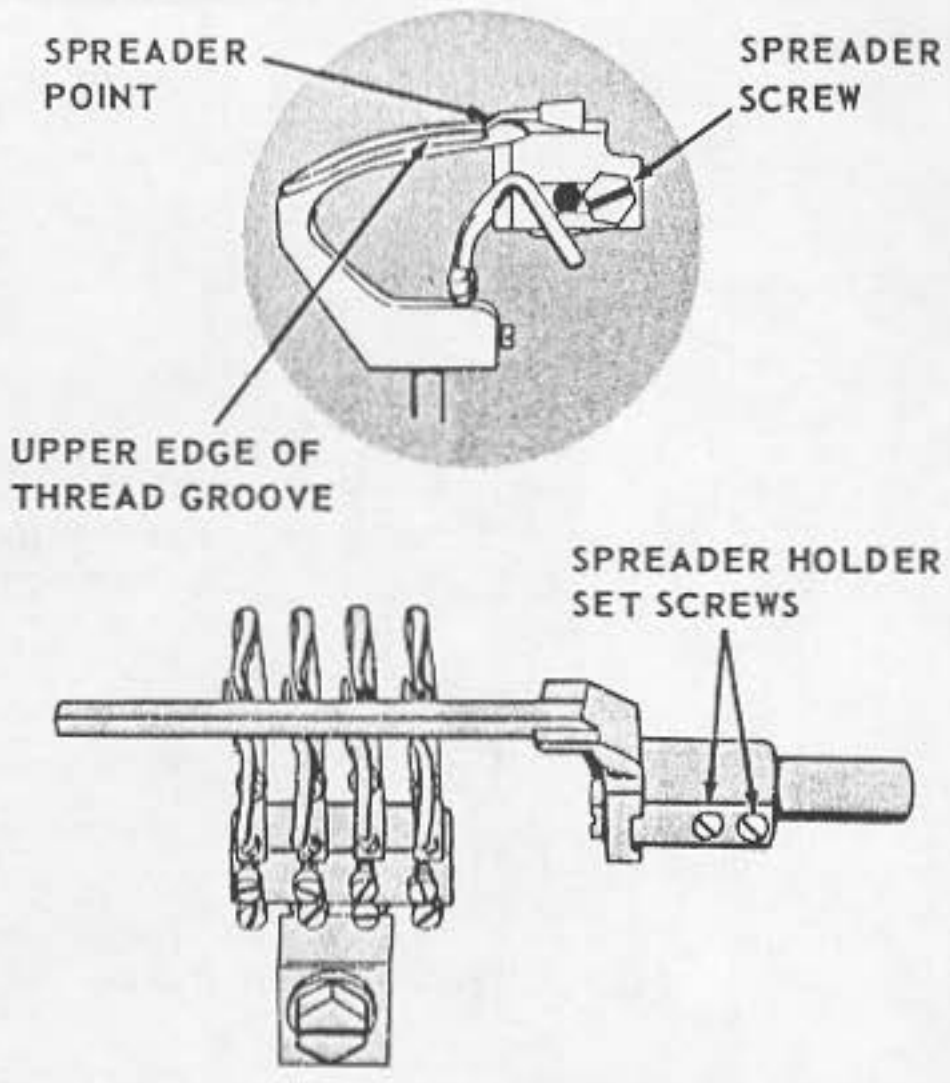


Fig. 21. Spreader Points in Relation to Loopers

Spreader Points in Relation to Needles

Turn machine pulley over until, on the downward stroke of the needle, the needle point and the spreader point are on the same level. The distance as illustrated in Fig. 22 between the spreader point and the looper point should then be approximately 1/16 inch. If adjustment is required, loosen spreader screw shown in Fig. 21 and move spreader points backward or forward as required. Re-tighten spreader screw.

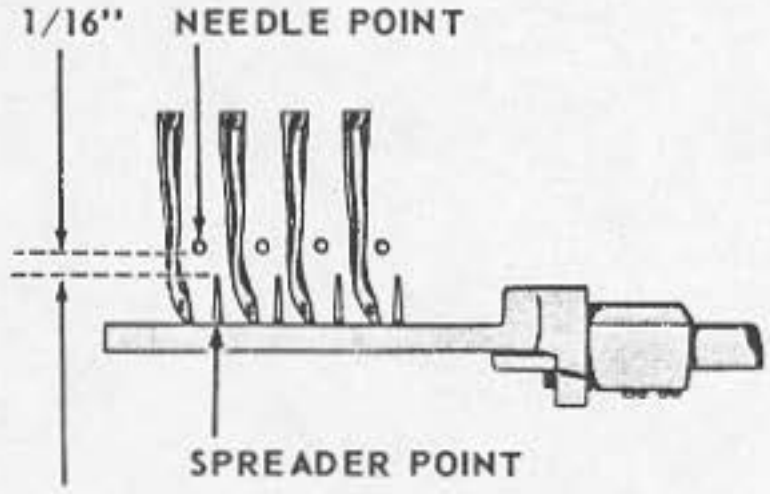


Fig. 22. Spreader Points in Relation to Needles