

# **REX**

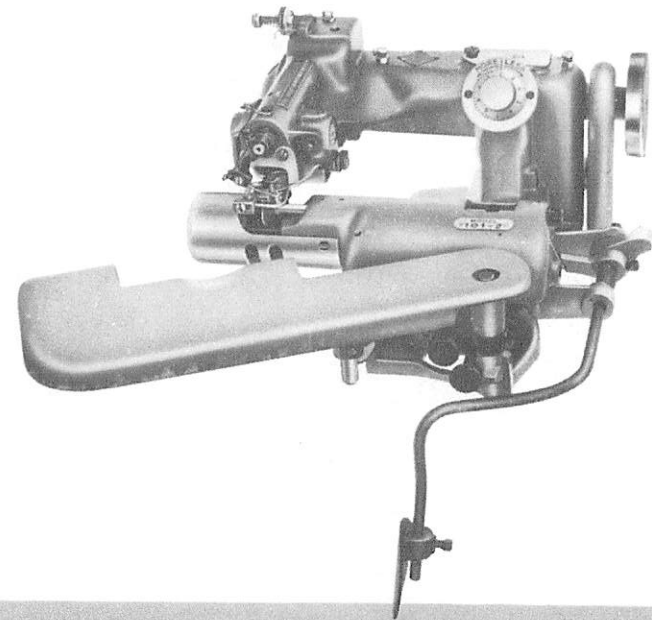
## **BLINDSTITCH**

### **SEWING MACHINES**

## **INSTRUCTION and PARTS BOOK**

### **MODELS**

**101-1 • 101-2 • 101-3 • 101-1PB**



**REX TRADING CORPORATION**

**278 — 15th AVENUE, NEWARK, N. J. 07103**

**Area Code 201 — 242-8485**

**Cable Address: REX - NEWARK, N. J.**

# INDEX

|                                     | PAGE |
|-------------------------------------|------|
| Changing 1-1 and 2-1 Ratios.....    | 3    |
| Knee Lifter Adjustment.....         | 4    |
| Mounting Machine .....              | 5    |
| Oiling Instructions .....           | 6    |
| Threading Chart .....               | 7    |
| Needle Setting .....                | 8    |
| Needle Changing .....               | 8    |
| How to Sew.....                     | 10   |
| Tension .....                       | 10   |
| Proper Stitching .....              | 11   |
| Part Numbers and Illustrations..... | 12   |
| Hemmers .....                       | 30   |

Copyrighted 1964  
By Rex Trading Corporation  
Printed U.S.A.

## REX BLINDSTITCH RATIO DIAL

(LOCATED IN REAR OF MACHINE)

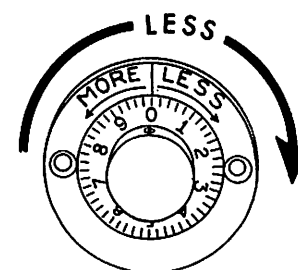
RATIO 1-1 to catch every stitch

RATIO 2-1 to catch every other stitch

### WHEN CHANGING FROM 1-1 TO 2-1 RATIO TURN RATIO DIAL



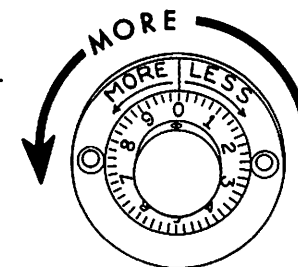
TURN PENETRATION DIAL  
ONE COMPLETE TURN  
TOWARD LESS



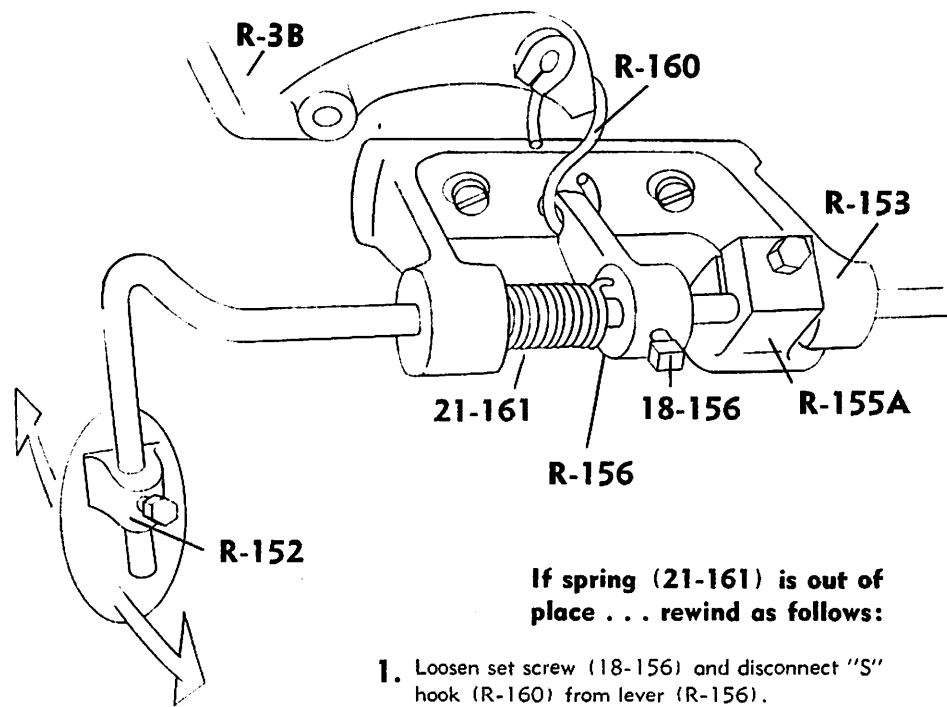
### WHEN CHANGING FROM 2-1 TO 1-1 RATIO TURN RATIO DIAL



TURN PENETRATION DIAL  
ONE COMPLETE TURN  
TOWARD MORE



## KNEE LIFTER ADJUSTMENT



**If spring (21-161) is out of place . . . rewind as follows:**

1. Loosen set screw (18-156) and disconnect "S" hook (R-160) from lever (R-156).
2. Wind spring (21-161) by turning lever (R-156) when machine is not fastened to table.
3. When spring is wound, tighten lever set screw temporarily.
4. Attach "S" hook (R-160) back to lever (R-156).
5. Adjust knee lifter to comfort of operator by loosening lever set screw. When in desired position, tighten set screw (18-156) securely.
6. With knee, press knee lifter to right to bring lever (R-156) down to bottom of "S" hook (R-160). While in this position, loosen screw on stop bracket (R-155A), bring stop firmly up to bottom of knee lifter bracket (R-153) and tighten screw securely. If properly done, it should look like illustration.
7. **IMPORTANT STEP:**  
For the final operation, tap knee lifter (R-152) slightly to the LEFT. This little "give" should relieve tension of hook (R-160) allowing it to play freely between feed frame (3B) and lever (R-156). Keeping this slack is all important for proper operation.

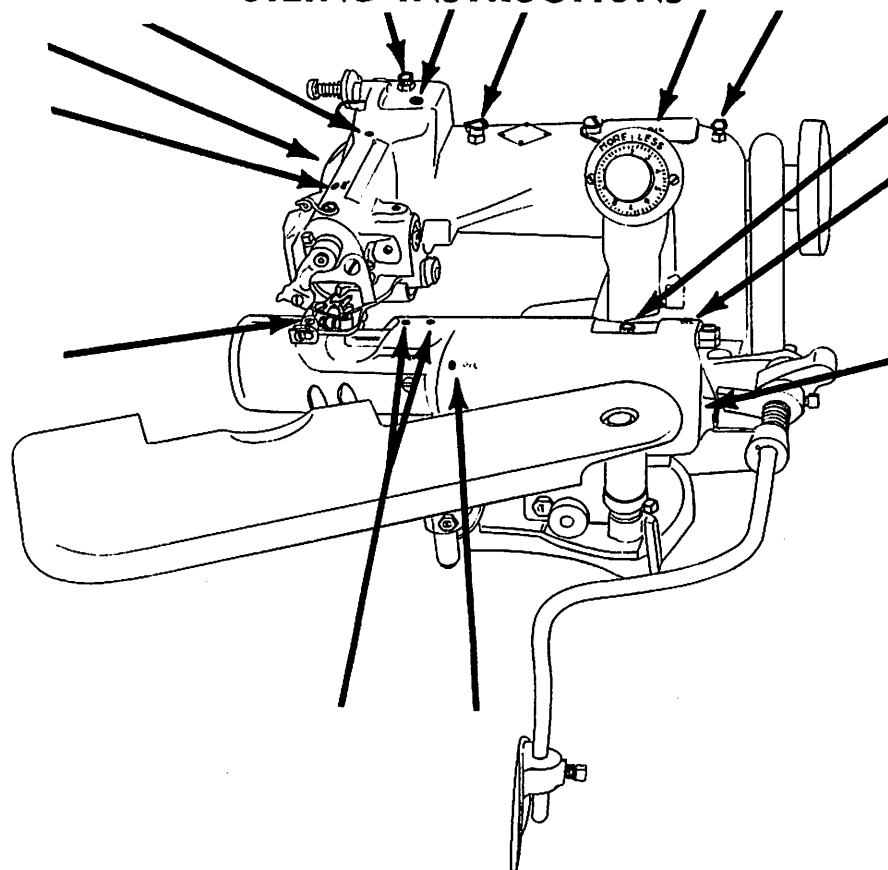
WHEN MACHINE IS WORKING, KNEE LIFTER (R-152) WILL NOT SWING BACK AND FORTH, IF PROPERLY ADJUSTED.

(At no time, should the operator's knee be in contact with the knee lifter when machine is in operation).

## MOUNTING MACHINE

1. Fasten machine to table using felt pad. Tighten screws evenly, turning each a little at a time.
  - a. When an individual motor and clutch unit is employed, it is recommended that the motor be rated at 1/3 HP and 1725/1750 RPM. On all standard models, use a 3 1/2" outside diameter pulley. On models intended for alteration, use a 2 1/2" outside diameter pulley.
  - b. When the machine is mounted on a power table, a 4" pulley should be used. If possible, when using such stands, the machine should be mounted TO AVOID CROSSING THE BELT.
  - c. The maximum machine speed recommended for any installation is 3000 RPM, unless otherwise specified.
2. The handwheel's direction of rotation is away from the operator. It rotates in a **clock-wise** direction when looking at the face of the wheel pulley, as shown by the arrow.
3. Either V-belting or round leather belting may be used. Excessive tension of belt will cause over-heating and freezing of bearing at handwheel.

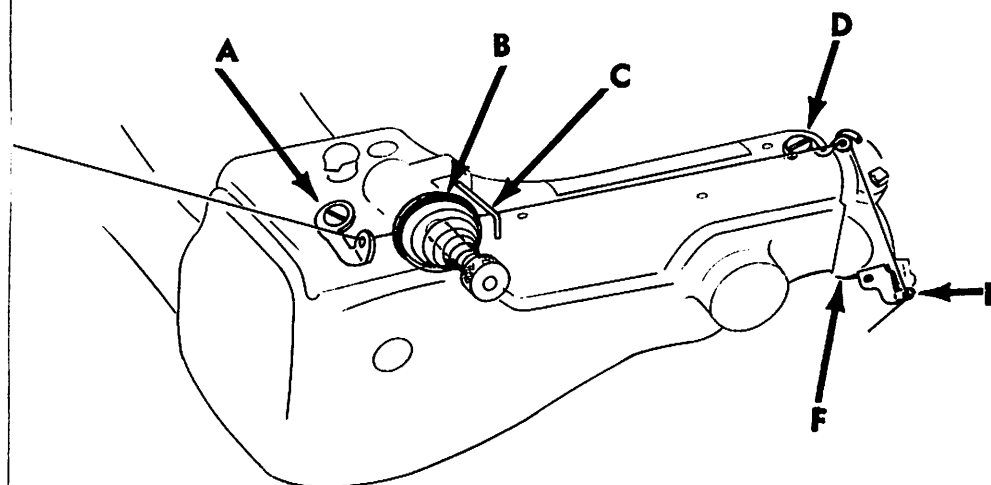
## OILING INSTRUCTIONS



**CAUTION:** BEFORE OPERATING MACHINE, LUBRICATE IN ACCORDANCE WITH INSTRUCTIONS. REFER TO OIL CHART.

1. Place a few drops of oil at all points shown on the oiling chart. All moving parts **MUST** be oiled.
2. In production use, the machine should be oiled twice daily

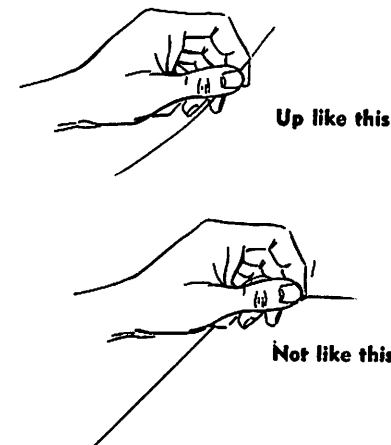
## THREADING CHART



1. Use any type thread which is suitable for the fabric being sewn. This includes mercerized, 00, silk and synthetic threads.
2. The thread is passed through rear thread guide A, then slides between two tension discs, B under pin C, through front thread guide D . . . then down through needle clamp guide hole E . . . and entering from the underside of needle hole F.
3. Leave thread about 2 to 3 inches past needle hole.

## THREADING NEEDLE

1. To thread needle at point F
  - a. Swing work plate out of way
  - b. Depress cylinder out of way with knee lifter (R-152)
  - c. Hold thread between index finger and thumb
  - d. End of thread must be **stub** not feather edge.



## NEEDLE SETTING AND CHANGING

**THE MACHINE SHOULD BE CHECKED TO INSURE CORRECT NEEDLE SETTING TO PREVENT DAMAGE TO NEEDLES.**

1. Depress knee lifter (R-152).
2. Turn hand wheel **CLOCKWISE** until eye of needle is at slot in presser foot shoe (R-49A).
3. Slowly release knee lifter . . . the rib (R-612) should **JUST TOUCH THE NEEDLE**.
4. If rib is pressing up against needle (Fig. 1), turn dial (R-57N) toward "LESS" until rib just touches needle.
5. If rib is away from needle (Fig. 2), turn dial toward "MORE" until rib just touches needle.

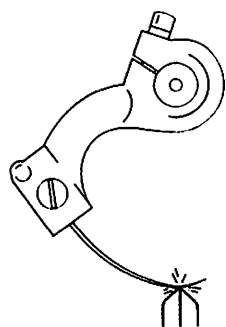
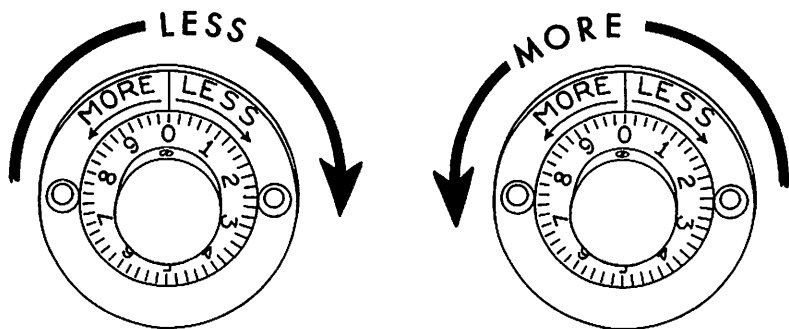


Fig. 1

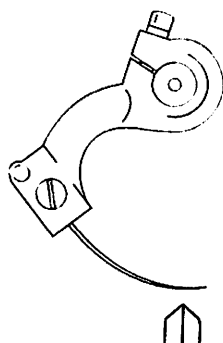


Fig. 2

6. When needle just touches rib (Fig. 3), machine is set to test.

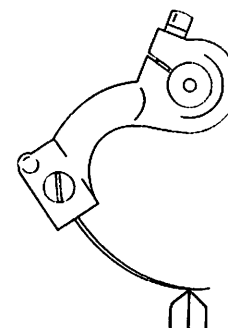


Fig. 3

7. To test machine, when ratio is set 2 to 1 ratio — take single layer of material, place in machine and turn machine by hand. If machine catches once, then does not catch on next stroke, machine is ready to work.
8. Keep dialing "MORE" or "LESS" until above results are obtained on silk or any thin goods.
9. On heavy goods, it should catch on each stroke of needle.
10. You are now ready to thread machine. Refer to threading instructions.

## CHANGING NEEDLES

If, after turning your dial several times, you experience difficulty in catching the lower layer of goods, examination may disclose a **BENT** or **BURRED NEEDLE** . . . The needle should be changed immediately.

**IMPORTANT** — To test if needle is bent, needle must rest on needle guide R-47. To test if needle is burred, rub fingernail across point of needle.

THE MACHINE SHOULD BE CHECKED TO INSURE CORRECT NEEDLE SETTING TO PREVENT DAMAGE TO NEEDLES.

### VERY IMPORTANT

Use only genuine REX needles. Accept no others. REX needles cost no more than cheap imitations, and are **ALWAYS** available. Standard Size Needles: #10 - #15 - #20 - #25 - #30

Machines equipped with #25



## HOW TO SEW

1. With hands 12 inches or so apart, hold hem firmly. Depress knee lifter, place hem in machine parallel with, and up under presser foot.
2. Place edge of hem in slot of R-49A, and at edge of gauge (R-125).
3. Start sewing. **IMPORTANT:** Keep edge of hem lightly, but firmly against gauge, keep material parallel to gauge by **KEEPING EYES ON GAUGE ONLY . . . NOT ON NEEDLE OR SEWING.**

## TENSION

If material puckers, loosen tension.

If thread is loose, make sure thread is down in tension, then tighten accordingly. Do not hesitate to turn tension nut several times as needed.

On thin goods, a light tension is required. On heavier goods, a tighter tension is necessary.

**IMPORTANT: Unlike a regular machine, this machine requires very little tension.**

### CHANGING FROM RATIO 1-1 TO 2-1

1. Turn Ratio Dial to 2-1 . . . to **CATCH** every other stitch when working with silk or other thin fabrics.
2. Turn Penetration Dial (R-57N) one complete turn toward LESS.

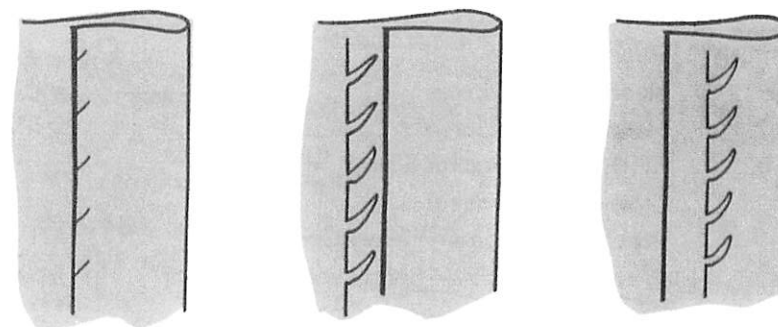
### CHANGING FROM RATIO 2-1 TO 1-1

1. Turn Ratio Knob to 1-1 to catch **EVERY STITCH**.
2. Turn Penetration Dial (R-57N) one complete turn toward MORE.

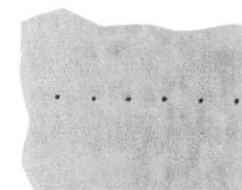
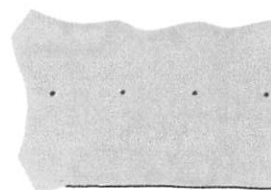
## START SEWING

1. On thin goods or ribbon gauge (R-125) should be set almost at extreme right side of machine and should obtain results shown in Fig. 1.
2. For heavier goods, bring gauge to the left as necessary.
3. Do not pull material to help feeding, do not hold material back, just hold firm but lightly.

## PROPER STITCHING



1. Proper stitching.
2. Material running off. Bring gauge over a little to left.
3. Gauge too far to left. Move gauge over to right.

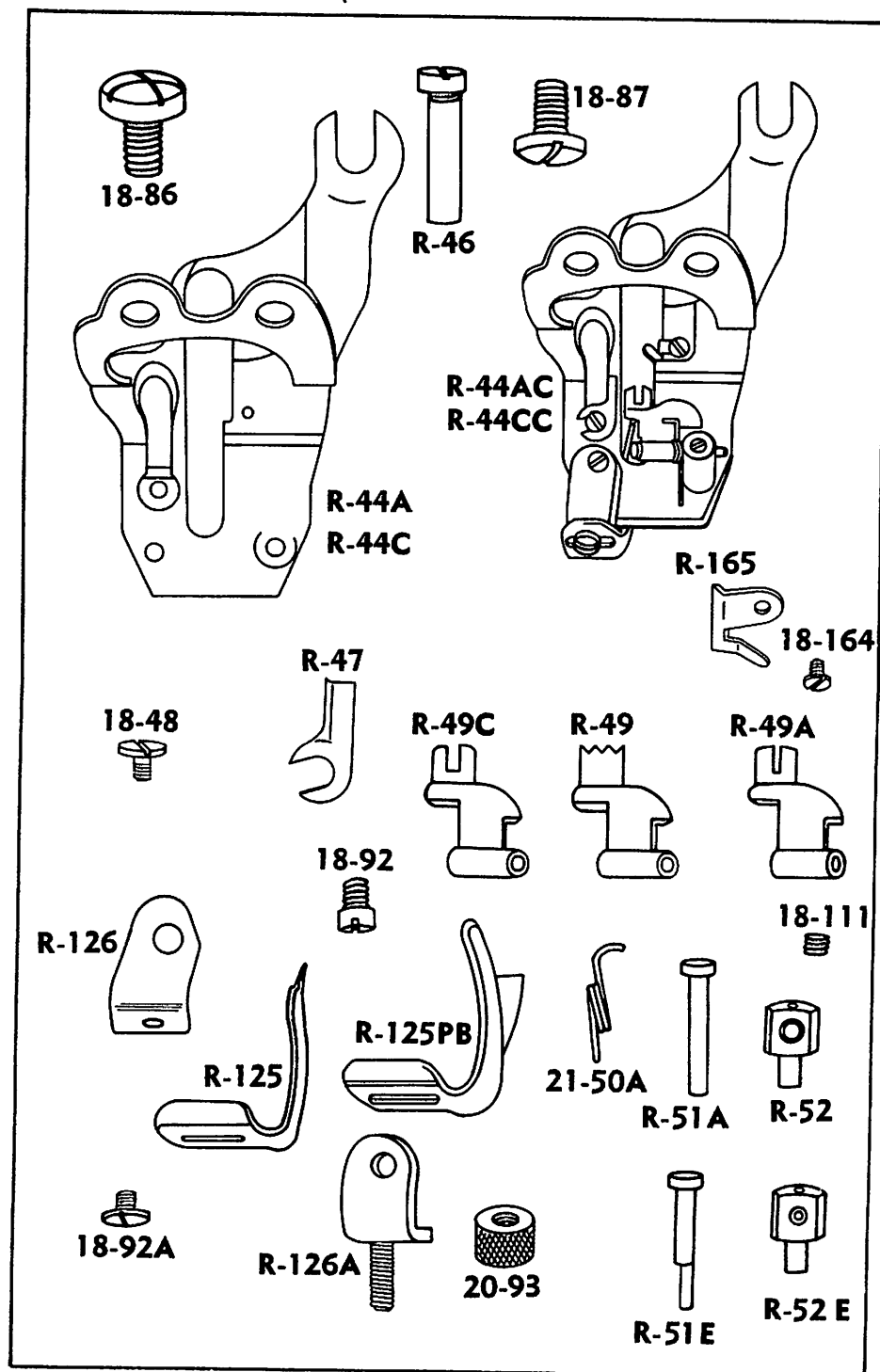


4. Catches on thin fabric every other time. (Provided needle is good.)
5. If catching each time on light fabric, turn dial to "LESS" until it looks like Fig. 4.

| PART No. | DESCRIPTION  |
|----------|--|
| R-44A    | Presserfoot For Fine Goods (Dresses)               |
| R-44C    | Presserfoot For Heavier Goods (Sportswear)         |
| R-44AC   | Presserfoot Assembled Including Parts (Fine Goods) |
| R-44CC   | Presserfoot Assembled Including Parts (Sportswear) |
| R-52     | Presserfoot Shoe Stud                              |
| R-51A    | Shoe Stud Pin                                      |
| R-51E    | Eccentric Shoe Pin For R-52E                       |
| R-52E    | Stud For R51E Eccentric Shoe Pin                   |
| R-46     | Presserfoot Eccentric Pin                          |
| 18-111   | Shoe Pin Screw                                     |
| 18-48    | Needle Guide Screw                                 |
| R-47     | Needle Guide                                       |
| 18-92    | Cloth Guide Bracket Screw                          |
| R-126    | Cloth Guide Bracket                                |
| R-49     | Presserfoot Shoe — Heavy Coats                     |
| R-49C    | Presserfoot Shoe — Sportswear and Drapery          |
| R-49A    | Presserfoot Shoe — Fine Goods                      |
| 18-87    | Presserfoot Brace Screw                            |
| 18-86    | Presserfoot Clamp Screw                            |
| 21-50A   | Presserfoot Shoe Spring                            |
| 18-164   | Chain Off Pin Screw                                |
| R-165    | Chain Off Pin                                      |
| 18-92A   | Cloth Guide Screw                                  |
| R-125    | Cloth Guide  |
| R-125PB  | Cloth Guide — Pants Bottom                         |
| 20-93    | Cloth Guide Nut                                    |
| R-126A   | Cloth Guide Bracket                                |

**WHEN ORDERING PARTS BE SURE TO INCLUDE MODEL NUMBER AND SERIAL NUMBER OF BLINDSTITCH MACHINE**

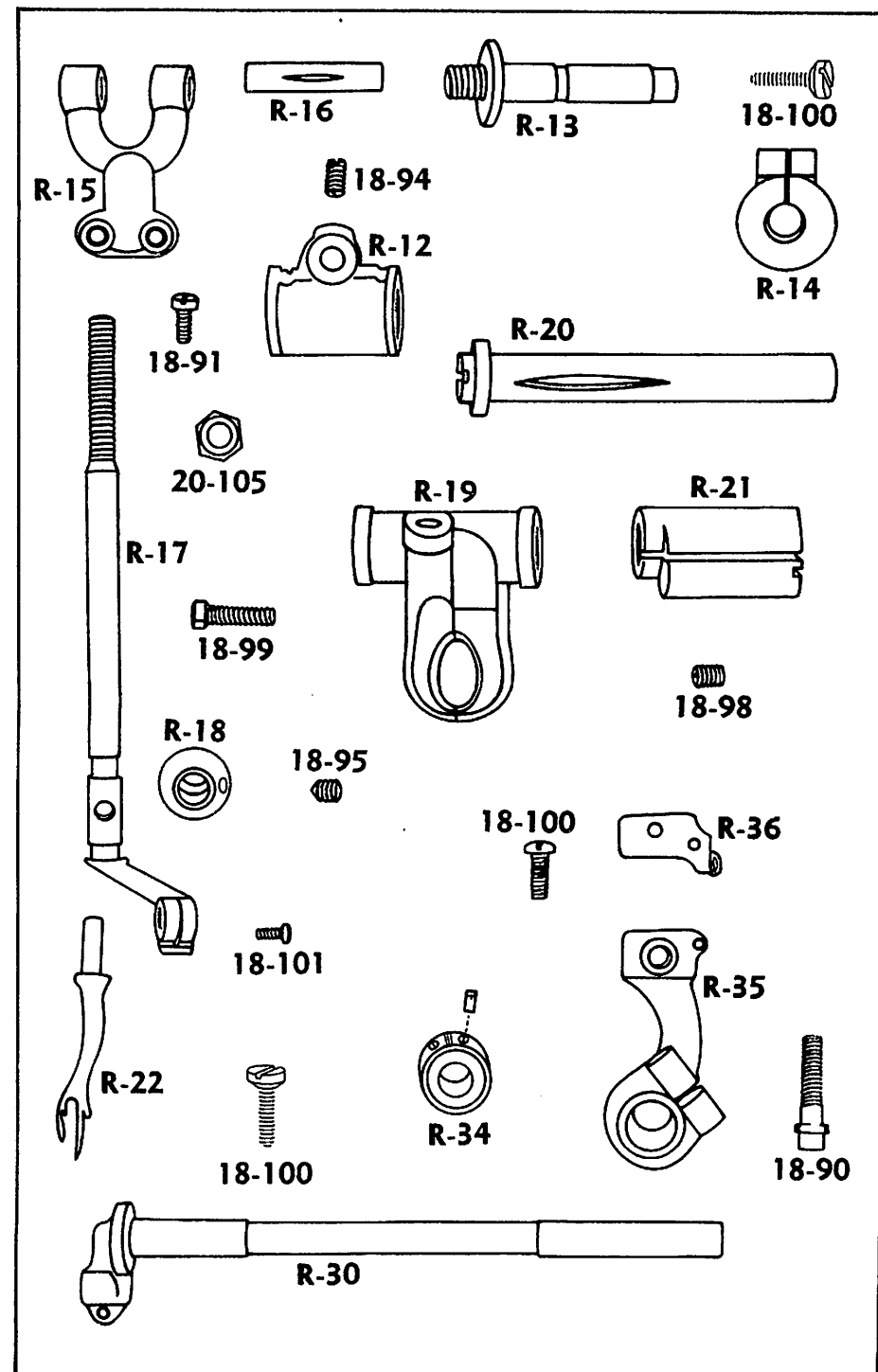
(Look for Serial Number stamped in lower left hand corner in rear of machine.)



| PART No. | DESCRIPTION  |
|----------|--|
| R-12     | Looper Rod Sleeve                                  |
| 18-94    | Looper Sleeve Pin Screw                            |
| R-13     | Looper Rod Sleeve Stud                             |
| R-14     | Looper Rod Sleeve Clamp Collar                     |
| 18-100   | Sleeve Clamp Collar Screw                          |
| R-15     | Looper Rod Fork                                    |
| 18-91    | Looper Fork Clamp Screw                            |
| R-16     | Looper Rod Fork Pin                                |
| R-17     | Looper Rod   |
| 18-101   | Looper Clamp Screw                                 |
| 20-105   | Looper Rod Nut                                     |
| R-18     | Looper Rod Ball                                    |
| 18-95    | Looper Rod Ball Screw                              |
| R-19     | Looper Rod Carrier                                 |
| 18-99    | Looper Rod Carrier Clamp Screw                     |
| R-20     | Looper Rod Carrier Pin                             |
| R-21     | Eccentric Block                                    |
| 18-98    | Eccentric Block Screw                              |
| R-22     | Looper   |
| R-30     | Needle Shaft                                       |
| 18-100   | Needle Shaft Crank Screw                           |
| R-34     | Needle Shaft Clamp Collar                          |
| R-35     | Needle Lever                                       |
| R-36     | Needle Clamp                                       |
| 18-100   | Needle Clamp Screw                                 |
| 18-90    | Needle Lever Clamp Screw                           |
| 412356   | R-12-13-14-15-16 with Screws Fitted and Lapped     |
| 47892    | R-17-18-19-20 with Screws Fitted and Lapped        |
| 41819    | R-18-19 with Screws Fitted and Lapped              |
| 41220    | R-12 to 20 Inclusive with Screws Fitted and Lapped |

**WHEN ORDERING PARTS BE SURE TO INCLUDE MODEL NUMBER AND SERIAL NUMBER OF BLINDSTITCH MACHINE**

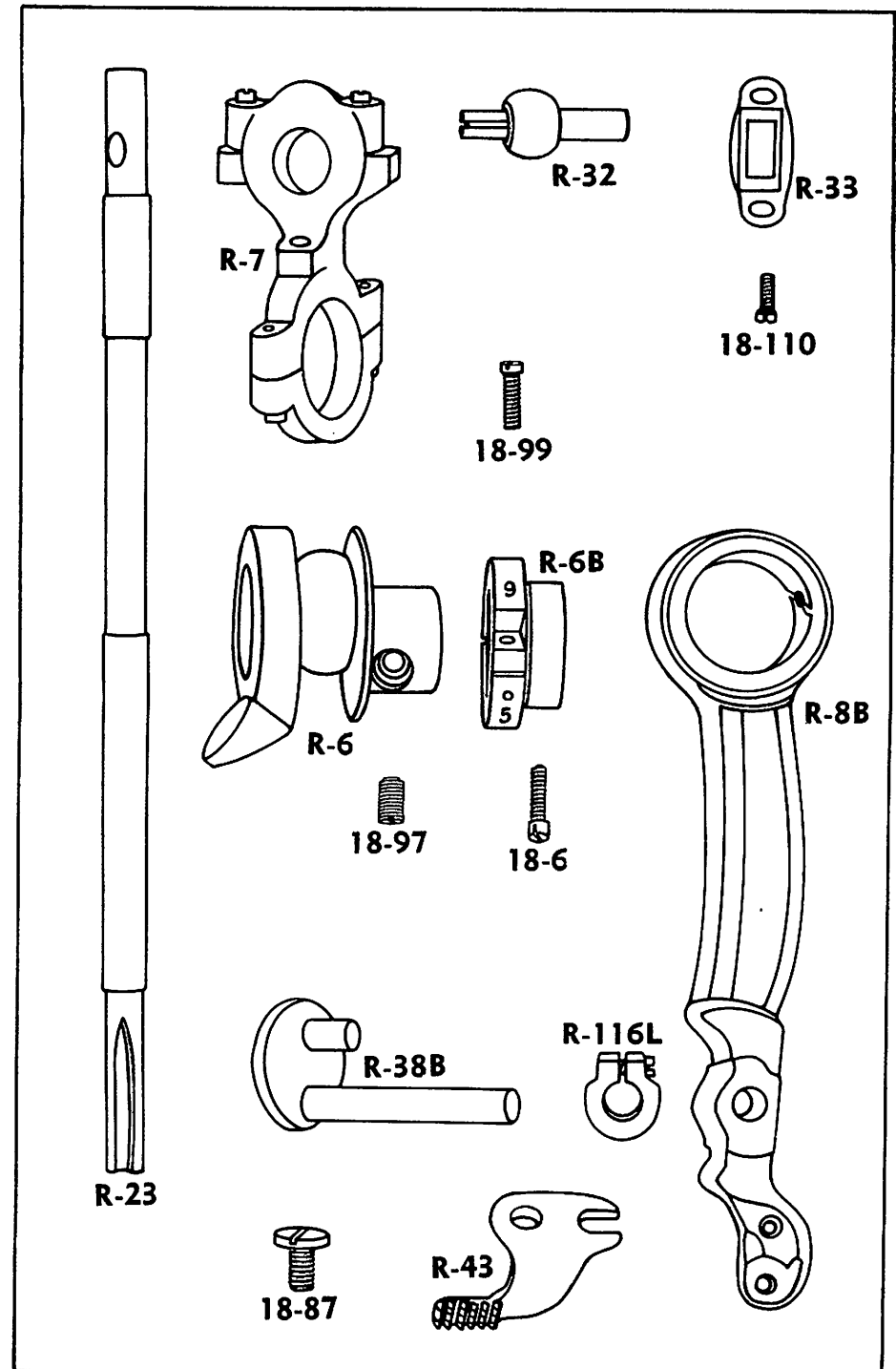
(Look for Serial Number stamped in lower left hand corner in rear of machine.)





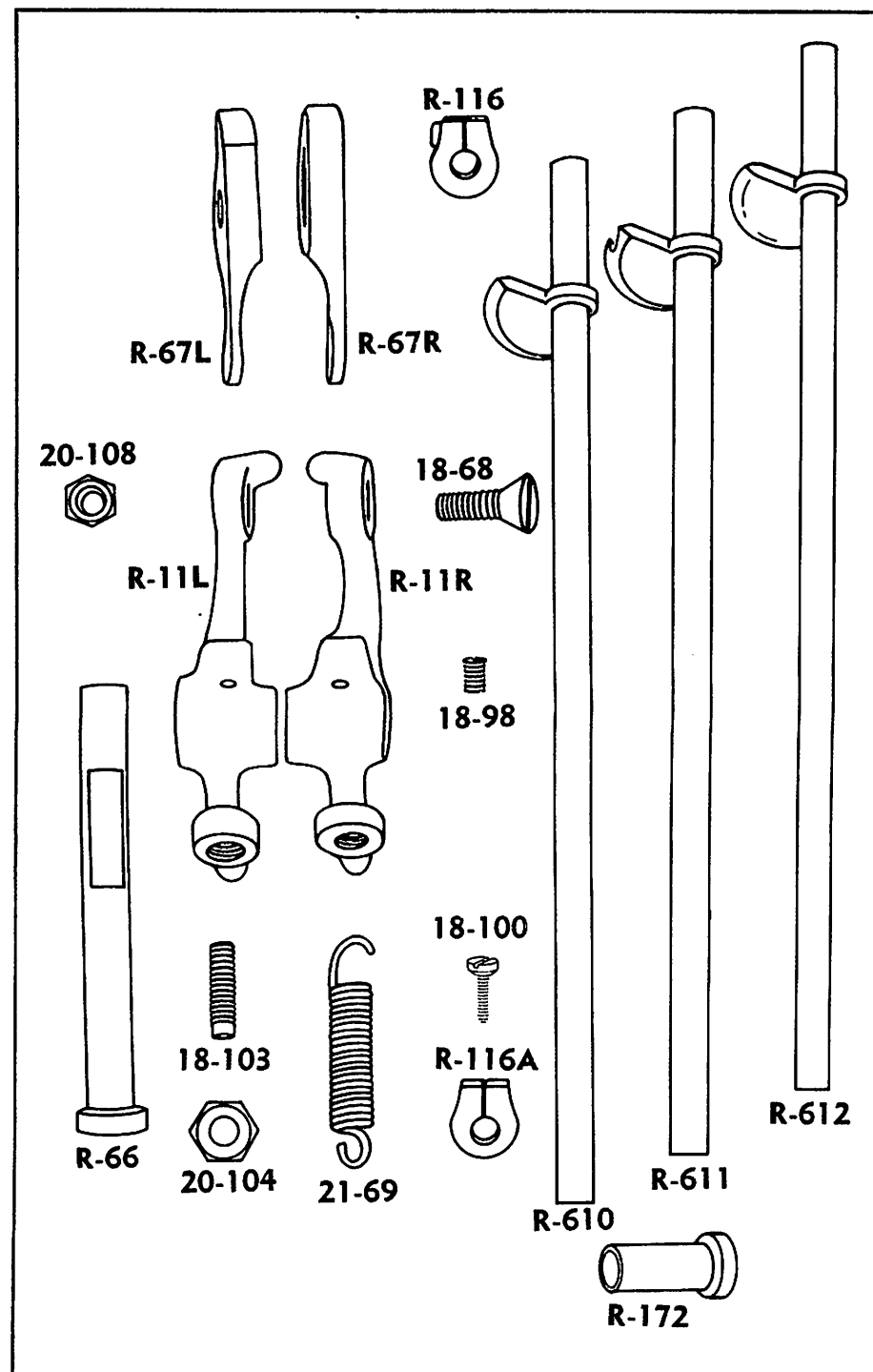
| PART No. | DESCRIPTION                    |
|----------|--------------------------------|
| R-23     | Main Shaft                     |
| R-7      | Needle Shaft Connection        |
| R-6      | Needle and Feed Eccentric      |
| R-38B    | Feed Lever Rocker Pin          |
| R-32     | Eccentric Ball Stud            |
| R-8B     | Feed Lever                     |
| R-33     | Eccentric Ball Guard           |
| R-116L   | Feed Lever Rocker Pin Collar   |
| R-43     | Feeder                         |
| R-6B     | Stitch Regulating Collar       |
| 18-97    | Eccentric Screw for R-6        |
| 18-99    | Needle Connection Screw        |
| 18-87    | Feeder Screw                   |
| 18-110   | Eccentric Ball Guard Screw     |
| 18-6     | Stitch Regulating Collar Screw |
| R-46732  | Parts 6-7-32 Fitted and Lapped |
| R-46B8   | Parts 6B-8B Fitted and Lapped  |

**WHEN ORDERING PARTS BE SURE TO INCLUDE MODEL NUMBER AND SERIAL NUMBER OF BLINDSTITCH MACHINE**  
 (Look for Serial Number stamped in lower left hand corner in rear of machine.)



| PART No. | DESCRIPTION  |
|----------|--|
| R-67L    | Left Platten   |
| R-67R    | Right Platten  |
| 20-108   | Platten Screw Nut  |
| 18-68    | Platten Screw  |
| R-11L    | Left Platten Bracket                                       |
| R-11R    | Right Platten Bracket                                      |
| 18-103   | Platten Bracket Limit Screw                                |
| 20-104   | Platten Bracket Limit Screw Nut                            |
| R-66     | Platten Bracket Pin  |
| 18-98    | Platten Bracket Pin Screw                                  |
| R-172    | Rib Shaft Bearing (Left or Right)                          |
| 21-69    | Platten Spring   |
| R-116    | Left Rib Shaft Collar                                      |
| R-116A   | Right Rib Shaft Collar                                     |
| R-610    | Rib Shaft — No Notch for Thin Fabrics (Dresses)            |
| R-611    | Rib Shaft with Notch for Synthetic Hard Goods (Dresses)    |
| R-612    | Rib Shafts for Coats, Suits, Pants and Woolens             |
| 46711    | R-67 and R-11 Left and Right with Screws and Nuts Complete |

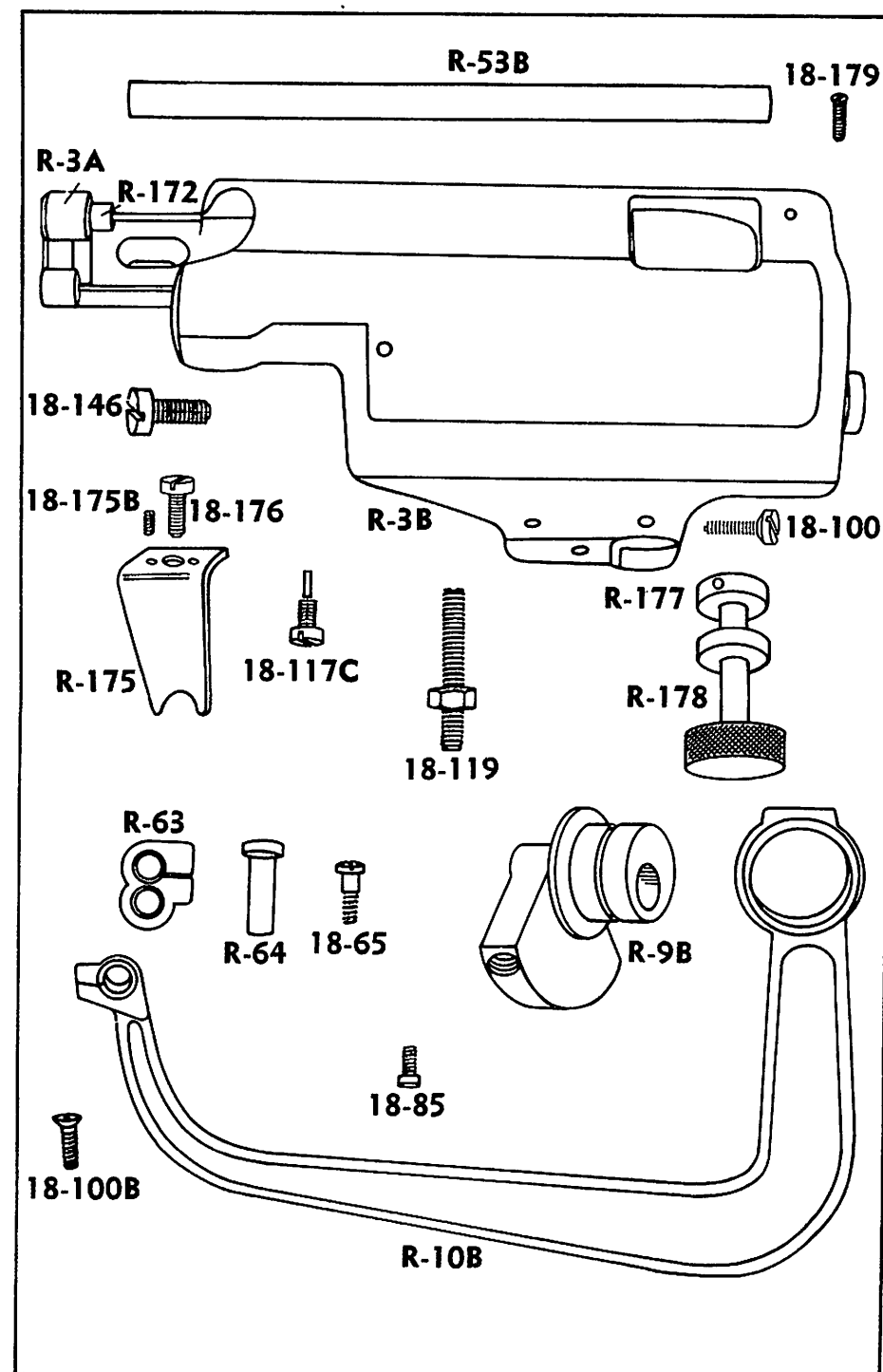
**WHEN ORDERING PARTS BE SURE TO INCLUDE MODEL NUMBER AND SERIAL NUMBER OF BLINDSTITCH MACHINE**  
 (Look for Serial Number stamped in lower left hand corner in rear of machine.)



| PART No. | DESCRIPTION   |
|----------|---|
| R-53B    | Feed Frame Shaft  |
| R-3B     | Feed Frame  |
| 18-146   | Screw for Rib Shaft Bracket Bearing Holder                      |
| R-3A     | Rib Shaft Bracket   |
| R-172    | Right and Left Rib Shaft Bearing                                |
| 18-100   | Regulator Knob Securing Screw                                   |
| R-175    | Rib Support Bracket   |
| 18-175B  | Rib Support Bracket Adjusting Screw                             |
| 18-176   | Rib Support Bracket Holding Screw                               |
| 18-100B  | Rib Lever Clamp Screw   |
| R-10B    | Rib Connection Lever  |
| R-9B     | Rib Connection Eccentric (For Non-Skip, 1-1 Models Only)        |
| 18-65    | Rib Shaft Crank Clamp Screw                                     |
| R-63     | Rib Shaft Crank   |
| R-64     | Rib Shaft Crank Pin   |
| 18-119   | Rib Height Limit Screw  |
| 18-117C  | Main Spring Lock Screw  |
| 18-179   | Feed Frame Shaft Screw  |
| R-178    | 2-1 Regulator Knob (On Models with Serial Numbers Under 455)    |
| R-177    | Regulator Knob Collar (On Models with Serial Numbers Under 455) |
| 18-85    | Rib Connection Screw  |

**WHEN ORDERING PARTS BE SURE TO INCLUDE MODEL NUMBER AND SERIAL NUMBER OF BLINDSTITCH MACHINE**

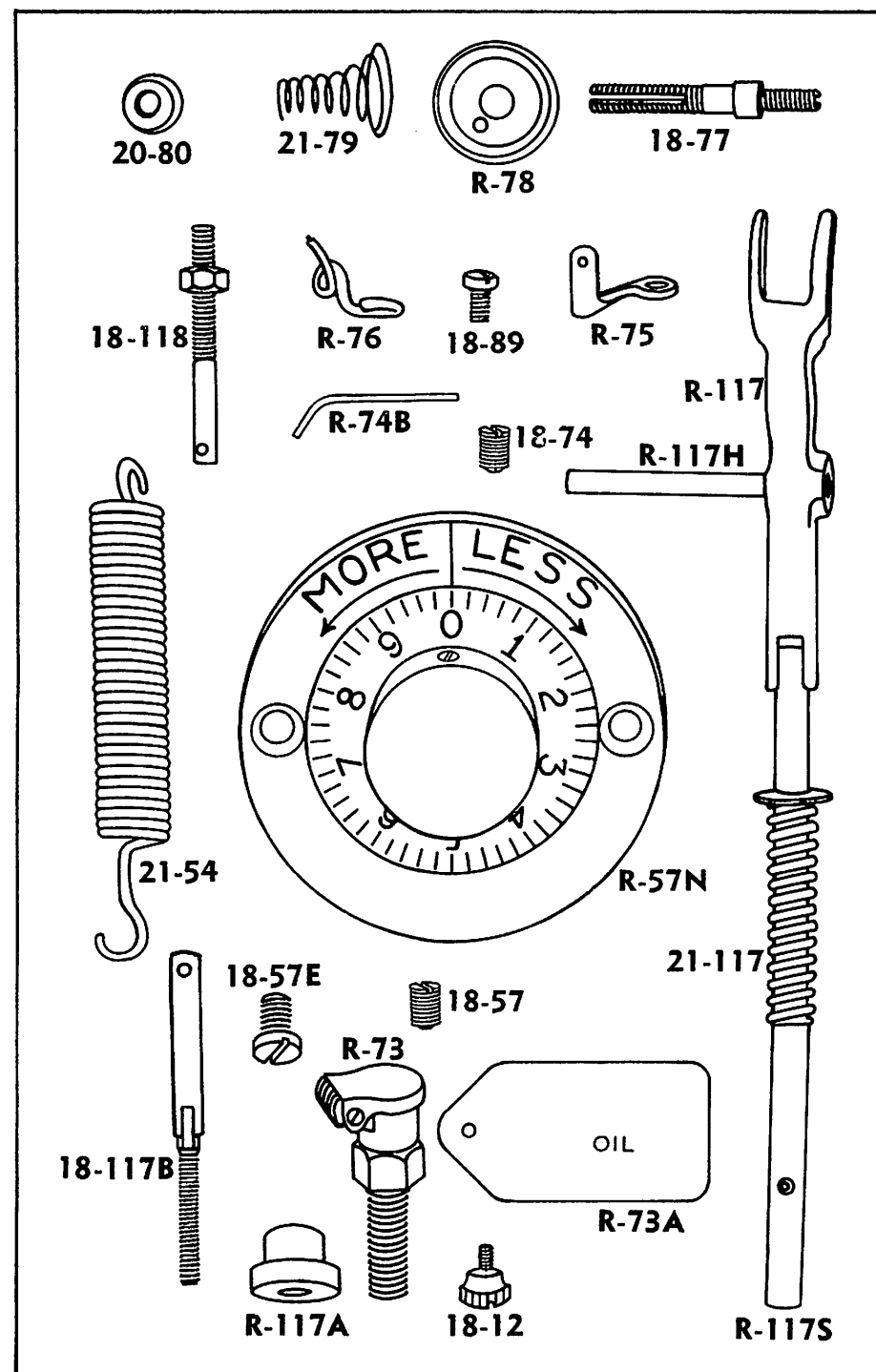
(Look for Serial Number stamped in lower left hand corner in rear of machine.)



| PART No. | DESCRIPTION   |
|----------|---|
| 18-77    | Tension Stud  |
| R-78     | Tension Disc  |
| 21-79    | Tension Spring  |
| 20-80    | Tension Nut   |
| 47890    | Tension Complete 18-77 - R78 - (21-79) (20-80)        |
| R-73     | Oil Cup   |
| 21-54    | Main Spring   |
| R-118    | Main Spring Screw and Nut                             |
| 18-117B  | Spring Link   |
| 20-117A  | Spring Knob   |
| 18-89    | Thread Guide Screw Front or Rear                      |
| R-76     | Front Thread Guide                                    |
| R-75     | Rear Thread Guide                                     |
| R-57N    | Regulating Penetration Dial and Plate                 |
| R-117    | Regulating Lever (Used Only on None-Skip Model 101-1) |
| R-117H   | Regulating Lever Pin                                  |
| 21-117   | Regulating Tension Spring                             |
| R-117S   | Regulating Shaft (Used Only on Model 101-1)           |
| 18-57E   | Regulating Plate Screw                                |
| 18-57    | Regulating Knob Dial Screw                            |
| R-74B    | Thread Guide  |
| 18-74    | Thread Guide Screw                                    |
| 18-12    | Oil Plate Stud  |
| R-73A    | Oil Plate Cover                                       |

**WHEN ORDERING PARTS BE SURE TO INCLUDE MODEL NUMBER AND SERIAL NUMBER OF BLINDSTITCH MACHINE**

(Look for Serial Number stamped in lower left hand corner in rear of machine.)



**PART No. DESCRIPTION**

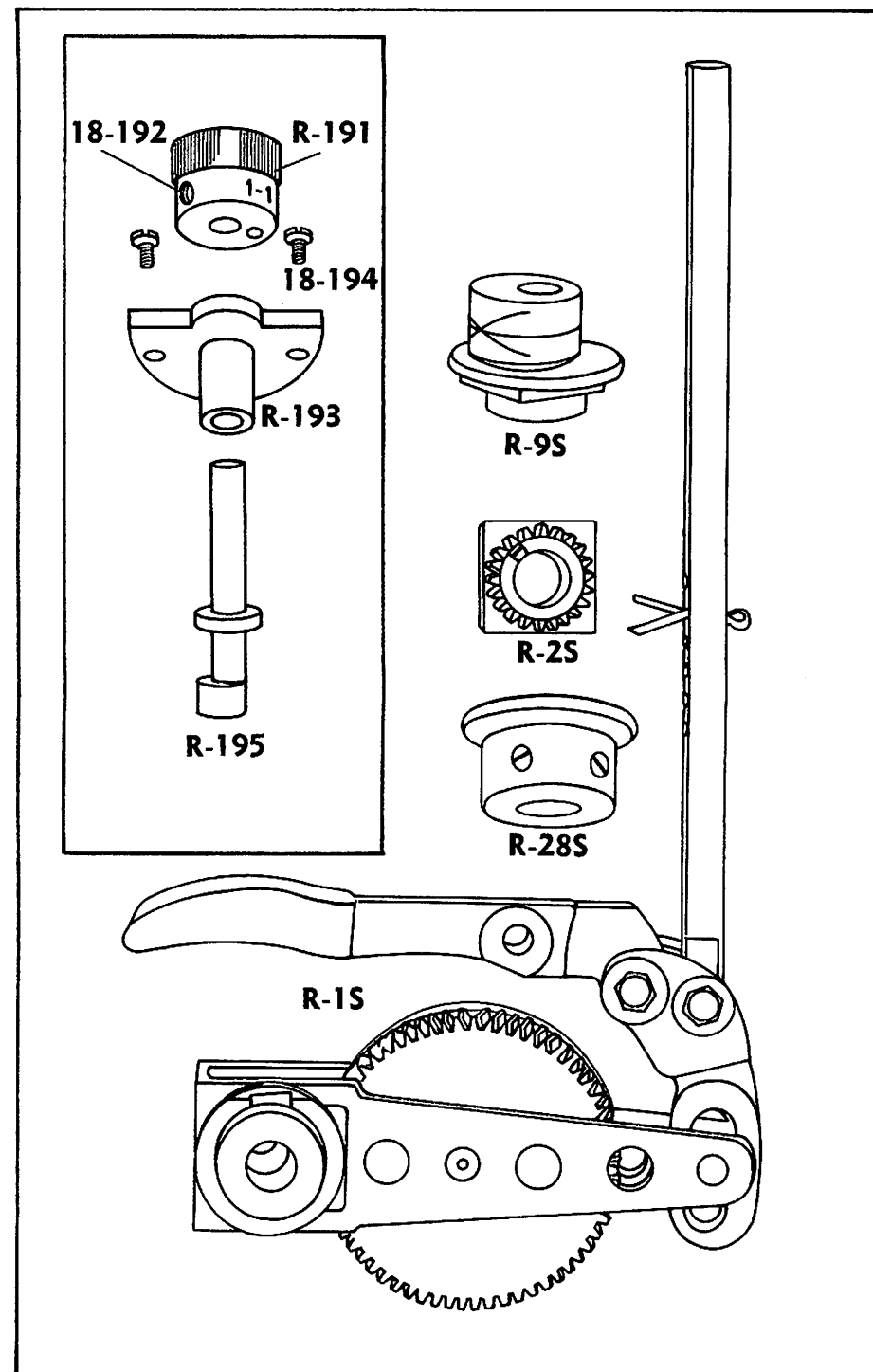
|       |  |
|-------|--|
| R-1S  | Skip Stitch Gears Complete — Specify Model |
| R-9S  | Eccentric                                  |
| R-28S | End Collar                                 |
| R-2S  | Small Gear                                 |

**ON MODELS 101-2/SERIAL NUMBERS OVER 455**

|        |                             |
|--------|-----------------------------|
| R-191  | Ratio Knob 1-1 and 2-1      |
| 18-192 | Ratio Knob Screw            |
| R-193  | Ratio Control Housing       |
| 18-194 | Ratio Control Housing Screw |
| R-195  | Ratio Control Shaft         |

**WHEN ORDERING PARTS BE SURE TO INCLUDE MODEL NUMBER AND SERIAL NUMBER OF BLINDSTITCH MACHINE**

(Look for Serial Number stamped in lower left hand corner in rear of machine.)

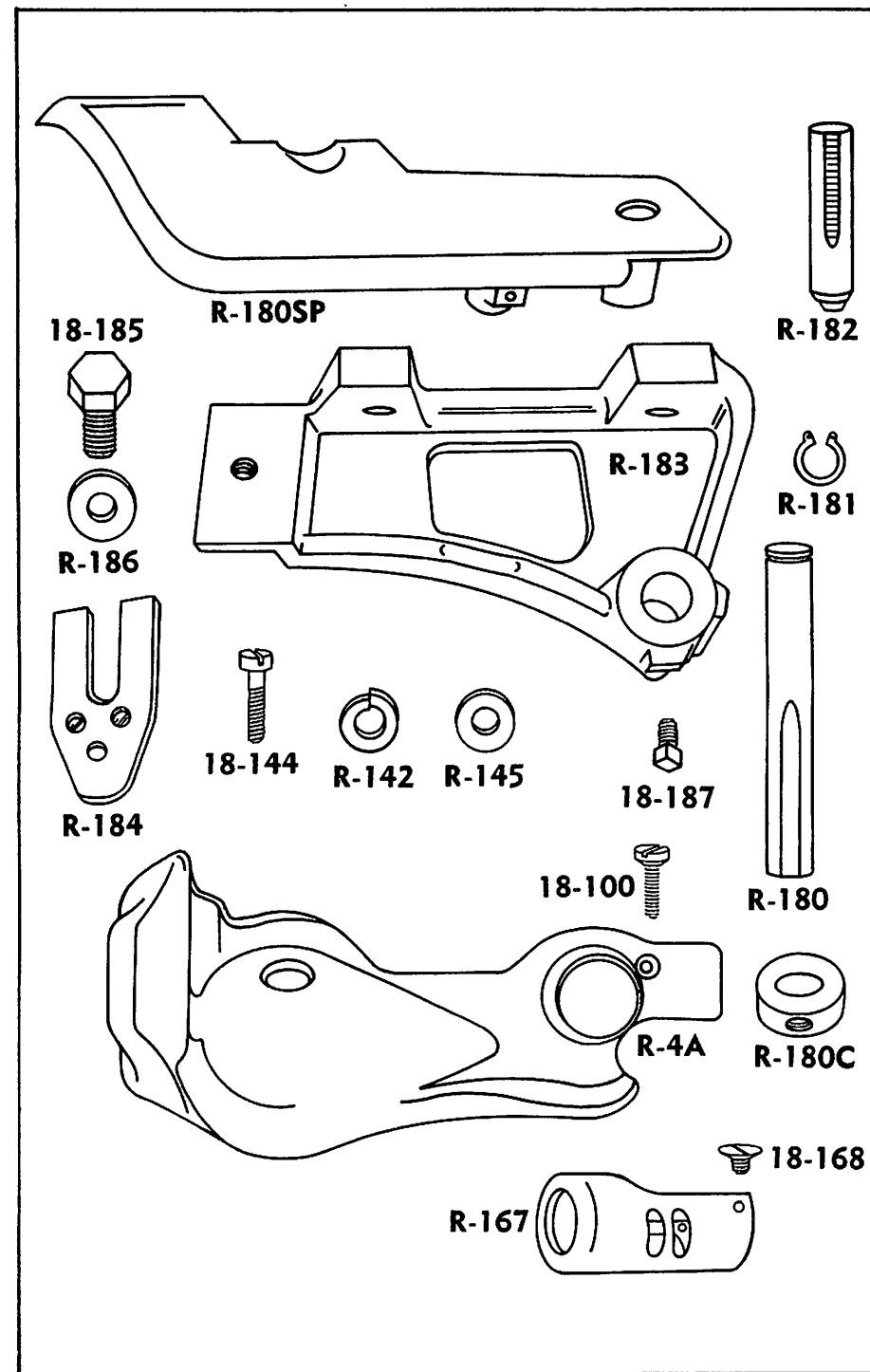




| PART No. | DESCRIPTION                                     |
|----------|---|
| R-180SP  | Work Plate on Swivel                            |
| R-142    | Supporting Bracket Lock Washer                  |
| R-145    | Supporting Bracket Washer                       |
| 18-144   | Supporting Bracket Screw                        |
| R-4A     | New Style Cover                                 |
| 18-100   | Cover Screw                                     |
| R-167    | Cylinder  |
| 18-168   | Cylinder Screw                                  |
| R-180    | Work Plate Pivot Pin                            |
| R-181    | True Arc  |
| R-182    | Work Plate Support Pin                          |
| R-183    | Work Plate Support Bracket                      |
| R-184    | Lock Plate                                      |
| 18-185   | Lock Plate Screw                                |
| R-186    | Lock Plate Screw Washer                         |
| 18-187   | Set Screw For Pivot Pin R-180                   |
| 18-187   | Set Screw For Support Pin R-182                 |
| 18-187   | Set Screw For Pivot Pin Collar                  |
| R-180C   | Work Plate Pivot Pin Collar                     |
| R-4180   | Complete Work Plate & Support Bracket Assembled |

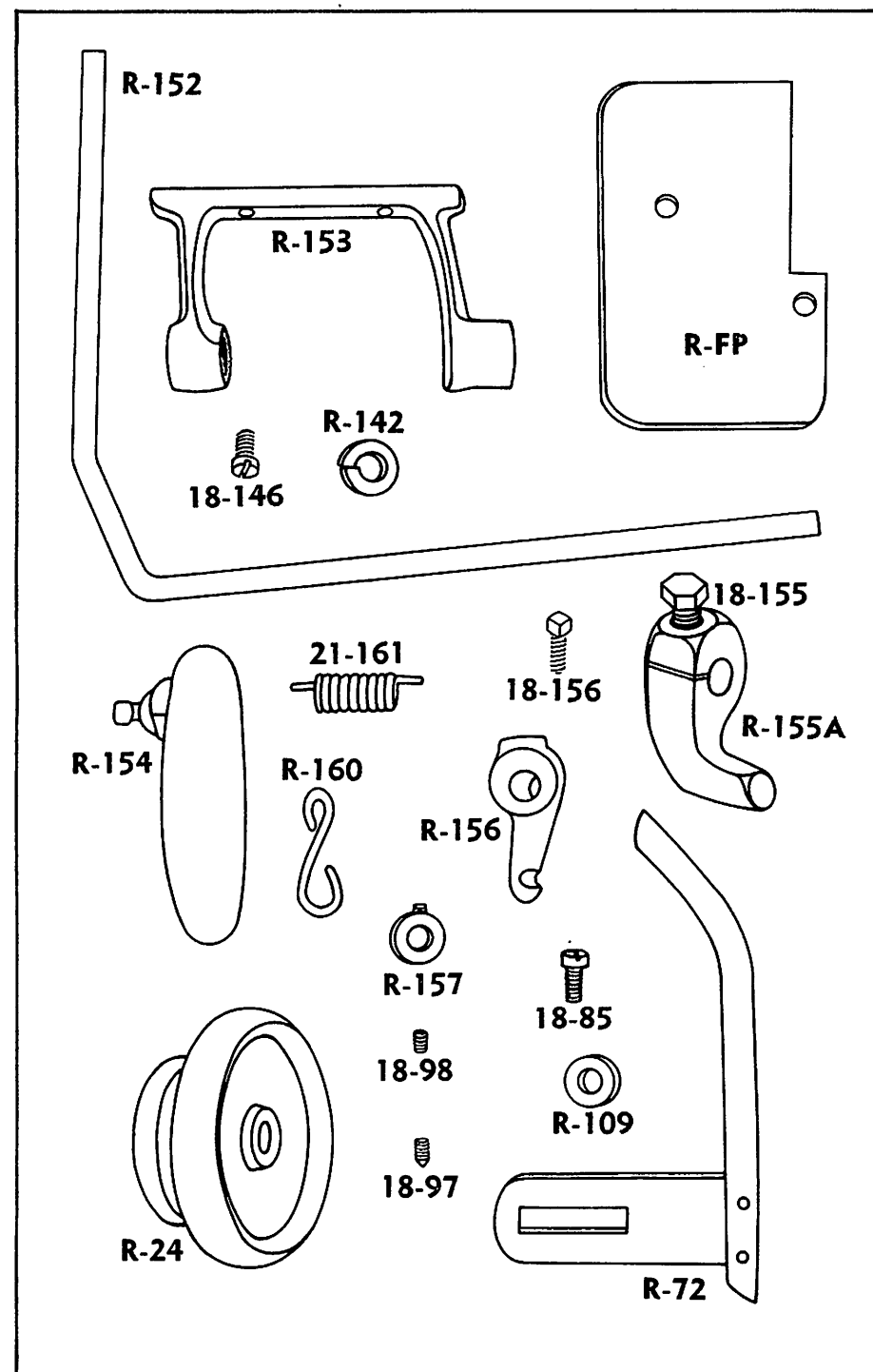
**WHEN ORDERING PARTS BE SURE TO INCLUDE MODEL NUMBER AND SERIAL NUMBER OF BLINDSTITCH MACHINE**

(Look for Serial Number stamped in lower left hand corner in rear of machine.)



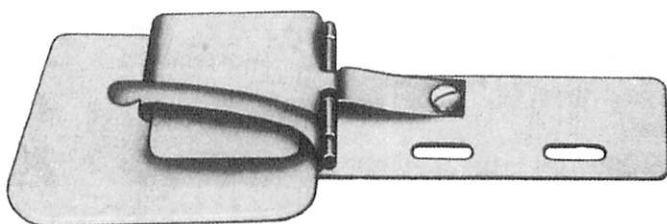
| PART No. | DESCRIPTION                               |
|----------|---|
| R-152    | Knee Lifter Rod                           |
| R-153    | Knee Lifter Rod Bracket                   |
| R-142    | Bracket Lock Washer                       |
| R-160    | S Hook for Depressing R-3B                |
| R-154    | Knee Pad                                  |
| 18-146   | Knee Lifter Bracket Screw                 |
| 21-161   | Knee Lifter Support Spring                |
| R-156    | Lifter Lever                              |
| 18-156   | Lever Set Screw                           |
| R-155A   | Stop Clamp                                |
| 18-155   | Stop Clamp Screw                          |
| 18-85    | Belt Guard Screw                          |
| 18-98    | Hand Wheel Screw                          |
| 18-97    | Conical Point Screw for R-24 (Hand Wheel) |
| R-157    | Collar for Non-Skip (1 to 1) Models Only  |
| R-109    | Belt Guard Washer                         |
| R-72     | Belt Guard                                |
| R-24     | Hand Wheel                                |
| R-FP     | Felt Pad                                  |

**WHEN ORDERING PARTS BE SURE TO INCLUDE MODEL NUMBER AND SERIAL NUMBER OF BLINDSTITCH MACHINE**  
 (Look for Serial Number stamped in lower left hand corner in rear of machine.)



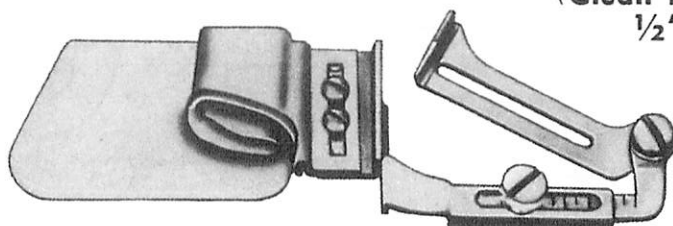
**LATCH BLINDSTITCH HEMMER**  
(R-2000)

**Stainless Steel**  
**1" to 3"**



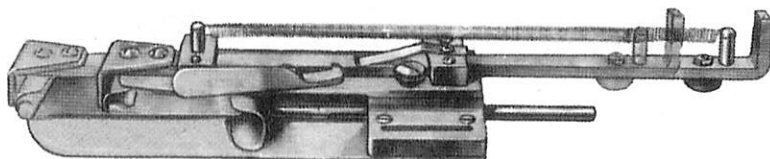
**FOR FINISHING BOTTOM HEMS**  
**ON DRESSES, SKIRTS, AND OTHER CIRCULAR GARMENTS.**

**STAINLESS STEEL SWING HEMMER**  
(R-1000) **For BLINDSTITCH Machines**  
**(Clean Finish)**  
**1/2" to 4"**



**SPECIAL FEATURE:**  
**Adjustable to and from the Needle Point**

**ADJUSTABLE SPLIT HEMMER**  
(R-1400) **For BLINDSTITCH Machines**



**SHELLS AVAILABLE**  
**from**  
**1/2" to 4"**  
**Specify Size & Quantity**

**STANDARD SIZE NEEDLES**

- #10 Fine knit rayon
- #15 Fine knit wear
- #20 Fine knit jersey
- #25 Dresses and light fabrics
- #30 For sportswear
- #35 For heavy, hard material and coats

Machines generally equipped with #25.

**Also available —**

Needle size numbers: #2 - #2½ - #3 - #3½ - #4 - #4½

**VERY IMPORTANT**

**Use only genuine REX needles. Accept no others. REX needles**  
**cost no more than cheap imitations and are ALWAYS available.**

If you have any difficulty, do not hesitate to contact dealer  
who sold you this machine. If unable to obtain satisfaction,  
please write or phone us direct:

REX TRADING CORPORATION  
278 - 15th Avenue  
Newark, New Jersey 07103  
Area Code 201 — Phone 242-8485  
Cable address: REX - NEWARK, NEW JERSEY

**REX — BACKED BY OVER THIRTY-FIVE YEARS OF**  
**BLINDSTITCH EXPERIENCE**