



**733R-8**

**PARTS BOOK AND  
INSTRUCTION MANUAL**

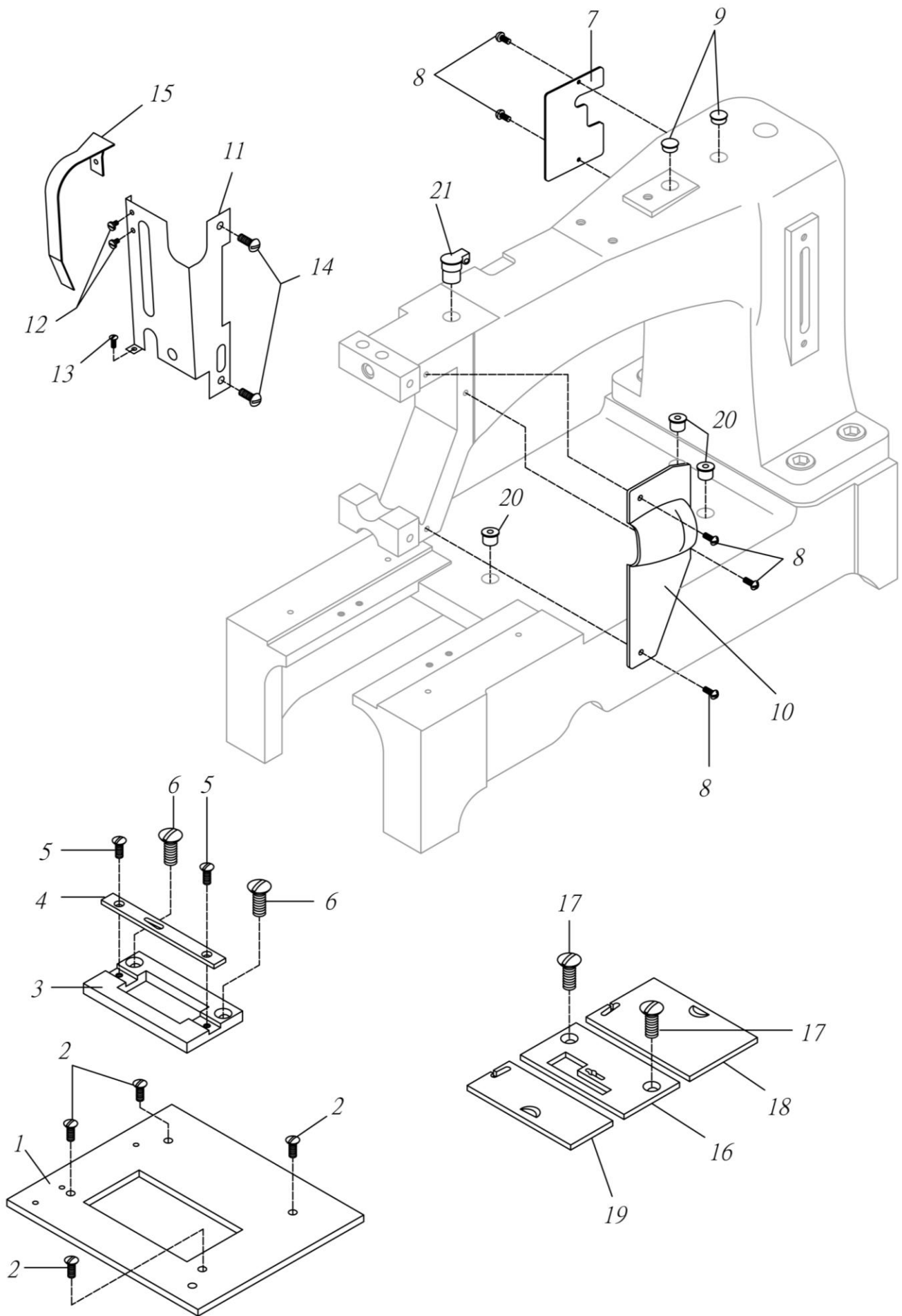
## SPECIFICATIONS

|                                  |   |
|----------------------------------|---|
| Model name                       | <b>733R-8</b>                           |
| Number of needles                | 1                                       |
| Max. sewing speed                | 700rpm                                  |
| Max. stitch length               | 15mm (Normal / Reverse feed)            |
| Needle bar stroke                | 72mm                                    |
| Lift of the presser foot         | 40mm                                    |
| Alternating vertical movement    | 5 ~ 7mm                                 |
| Hook                             | Semi-rotary large capacity shuttle hook |
| Needle (at the time of delivery) | 6X3-330                                 |
| Working space                    | 420mm                                   |
| Bed size                         | 654mm X 258mm                           |

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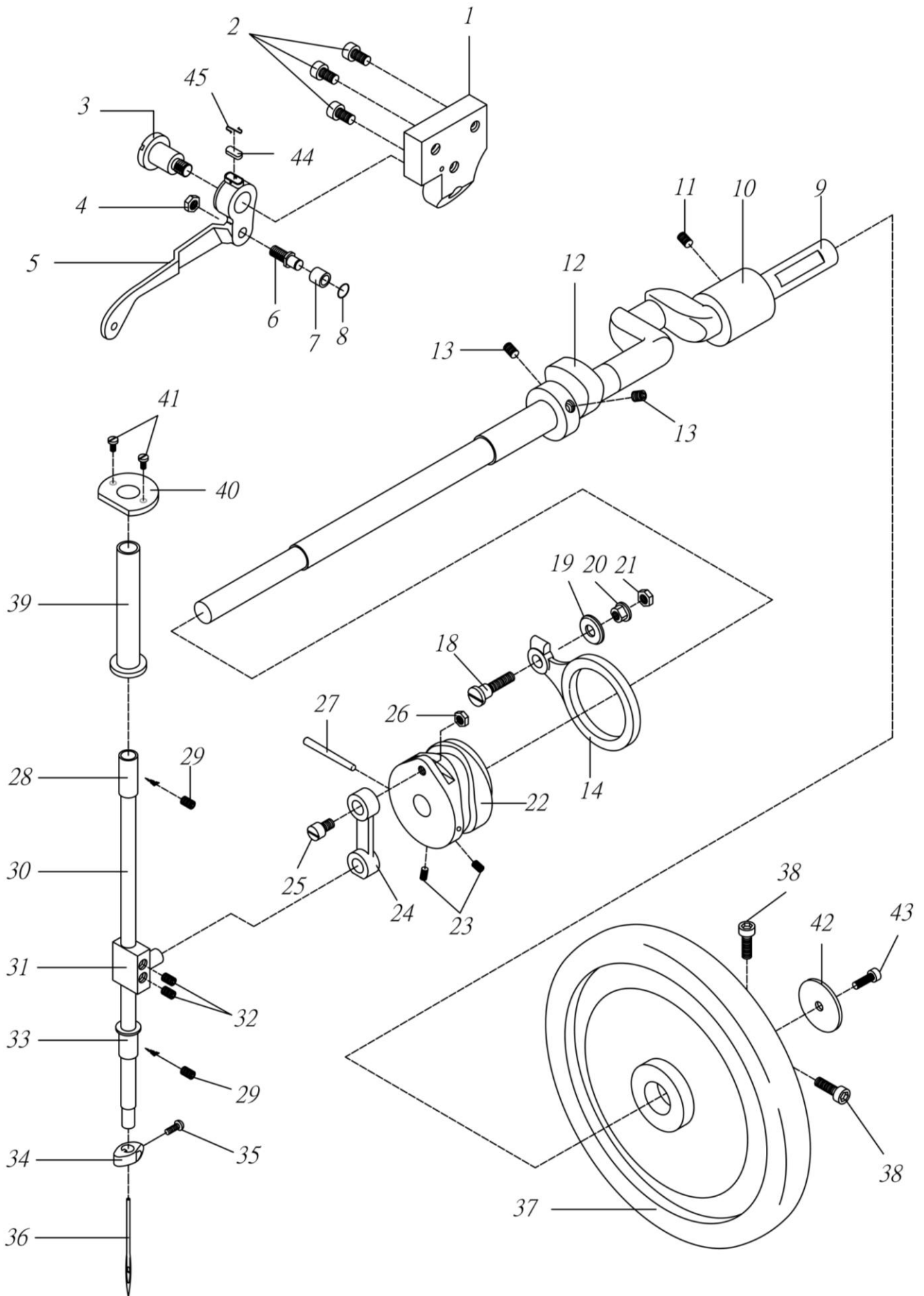
# 1. FRAME & MISCELLANEOUS COVER COMPONENTS



| REF. NO. | NOTE | PART NO. | DESCRIPTION                | AMT. | NOTE  |
|----------|------|----------|----------------------------|------|-------|
| 1        | #1   | 733-0101 | CLOTH PLATE                | 1    | 35194 |
| 2        | #1   | 733-0102 | SCREW 3/16-32 L=8          | 4    | 35195 |
| 3        | #1   | 733-0103 | THROAT PLATE BODY          | 1    | 35192 |
| 4        | #1   | 733-0104 | THROAT PLATE               | 1    | 35190 |
| 5        | #1   | 733-0105 | SCREW 3/16-32 L=6          | 2    | 35191 |
| 6        | #1   | 733-0106 | SCREW 15/64-28 L=11        | 2    | 35193 |
| 7        |      | 733-0107 | ARM SIDE COVER             | 1    | 35168 |
| 8        |      | 733-0108 | SCREW 9/64-40 L=7          | 5    |       |
| 9        |      | 733-0109 | RUBBER PLUG                | 2    |       |
| 10       |      | 733-0110 | ARM FACE COVER             | 1    | 35167 |
| 11       |      | 733-0111 | FACE PLATE                 | 1    | 35031 |
| 12       |      | 733-0112 | SCREW M4X0.7 L=4           | 2    | 30047 |
| 13       |      | 733-0108 | SCREW 9/64-40 L=7          | 1    |       |
| 14       |      | 733-0114 | SCREW 15/64-28 L=11        | 2    |       |
| 15       |      | 733-0115 | THREAD TAKE-UP LEVER COVER | 1    | 35032 |
| 16       | #2   | 733-0116 | THROAT PLATE               | 1    | 35175 |
| 17       | #2   | 733-0117 | SCREW 15/64-28 L=11        | 2    | 35193 |
| 18       | #2   | 733-0118 | BED SLID (RIGHT)           | 1    | 35178 |
| 19       | #2   | 733-0119 | BED SLID (LEFT)            | 1    | 35177 |
| 20       |      | 733-0120 | BALL TYPE OIL CUP          | 3    |       |
| 21       |      | 733-0121 | OIL CUP                    | 1    |       |

NOTE: #01 ..... FOR 733R-5  
#02 ..... FOR 733R-8

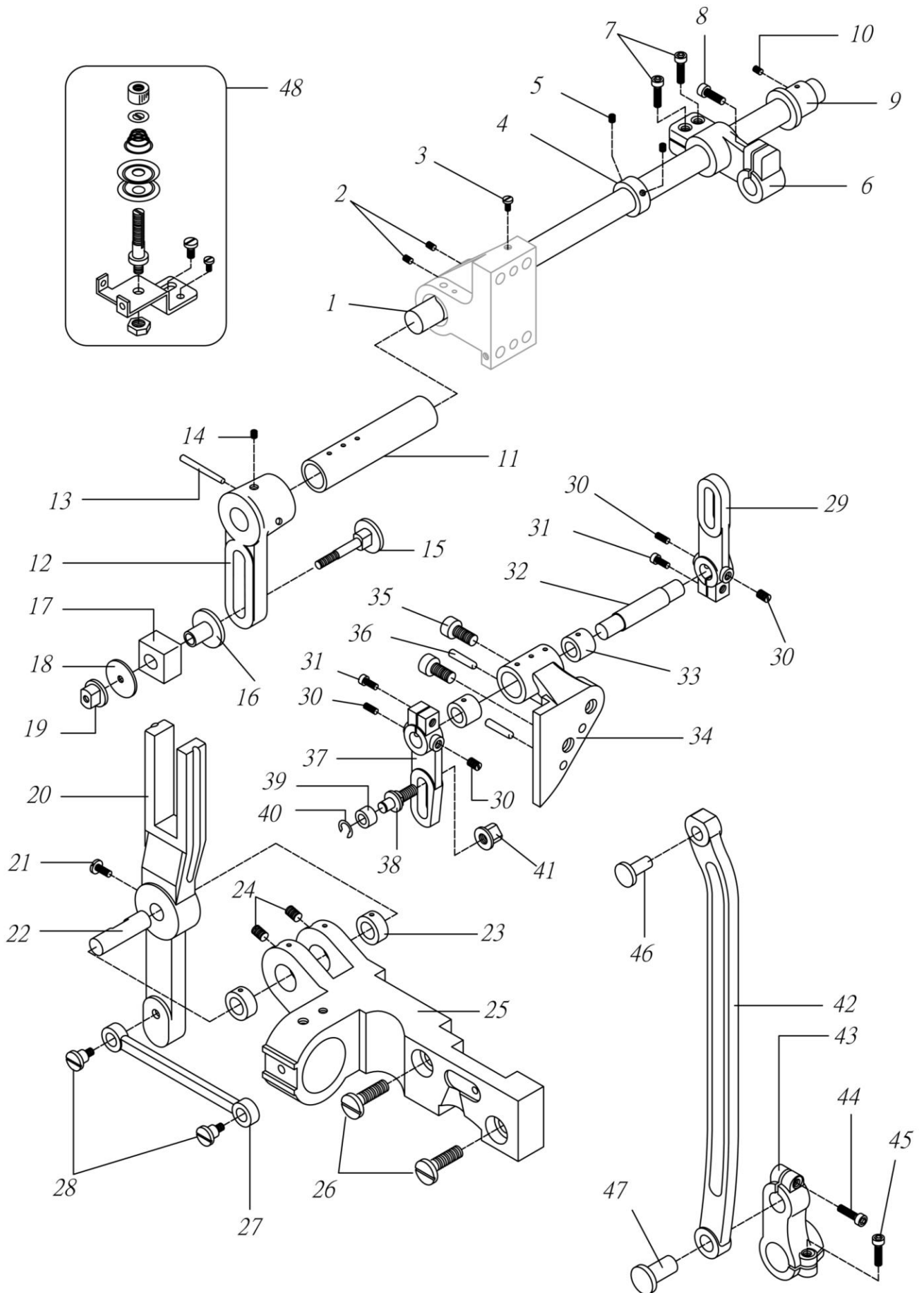
## 2. MAIN SHAFT & NEEDLE BAR COMPONENTS



| NO. | NOTE | PART NO.  | DESCRIPTION                  | AMT. | NOTE   |
|-----|------|-----------|------------------------------|------|--------|
| 1   |      | 733-0201  | TAKE-UP LEVER BRACKET        | 1    | 35033  |
| 2   |      | 733-0202  | SCREW M6*1 L=20              | 3    | 35034  |
| 3   |      | 733-0203  | HINGE SCREW 3/8-18           | 1    | 35036  |
| 4   |      | 733-0204  | NUT 9/32-28                  | 1    | 8105   |
| 5   |      | 733-0205N | TAKE-UP LEVER                | 1    |        |
| 6   |      | 733-0206  | SCREW STUD 9/32-28 L=13      | 1    | 35039  |
| 7   |      | 733-0207  | ROLLER                       | 1    | 35038  |
| 8   |      | 733-0208  | E-RING                       | 1    |        |
| 9   |      | 733-0209  | ARM SHAFT                    | 1    | 35010  |
| 10  |      | 733-0210  | ARM SHAFT BUSHING            | 1    | 35011  |
| 11  |      | 733-0211  | SCREW 5/16-24 L=10           | 1    | 35012  |
| 12  |      | 733-0212  | FEED DRIVING ECCENTRIC       | 1    | 35045  |
| 13  |      | 733-0213  | SCREW 5/16-24 L=8            | 2    | 35017  |
| 14  |      | 733-0214N | ECCENTRIC ROD                | 1    |        |
| 15  |      | 733-0215  | SCREW 3/16-28 L=20           | 1    | 35103  |
| 16  |      | 733-0216  | SPRING WASHER 5*8*1          | 1    |        |
| 17  |      | 733-0217  | NUT 3/16-28                  | 1    | 35104  |
| 18  |      | 733-0218  | HINGE SCREW 9/32-28 L=20     | 1    | 35105  |
| 19  |      | 733-0219  | WASHER 7*21*3                | 1    | 35107  |
| 20  |      | 733-0220  | NUT 9/32-28                  | 1    | 35106  |
| 21  |      | 733-0204  | NUT 9/32-28                  | 1    | 8105   |
| 22  |      | 733-0222  | CAM                          | 1    | 35016  |
| 23  |      | 733-0213  | SCREW 5/16-24 L=8            | 2    | 35017  |
| 24  |      | 733-0224N | NEEDLE BAR CONNECTING LINK   | 1    |        |
| 25  |      | 733-0225N | SCREW 3/8-28 L=10            | 1    |        |
| 26  |      | 733-0226  | NUT 3/8-28                   | 1    | 6027-2 |
| 27  |      | 733-0227  | PIN 5X70                     | 1    | 35018  |
| 28  |      | 733-0228  | BUSHING                      | 1    |        |
| 29  |      | 733-0229  | SCREW 15/64-28 L=7           | 2    |        |
| 30  |      | 733-0230  | NEEDLE BAR                   | 1    | 35022  |
| 30  | #3   | 733-0230N | NEEDLE BAR FOR 6*3#30 NEEDLE | 1    |        |
| 31  |      | 733-0231  | NEEDLE BAR CONNECTION        | 1    | 35021  |
| 32  |      | 733-0213  | SCREW 5/16-24 L=8            | 2    | 35017  |
| 33  |      | 733-0233  | BUSHING                      | 1    |        |
| 34  |      | 733-0234  | NEEDLE CLAMP                 | 1    | 35024  |
| 35  |      | 733-0235  | SCREW 3/16-32 L=10           | 1    |        |
| 36  |      | 733-0236  | NEEDLE                       | 1    | N0925  |
| 37  |      | 733-0237  | BALANCE WHEEL                | 1    | 35008  |
| 38  |      | 733-0238  | SCREW 3/8-16 L=25            | 2    | 35009  |
| 39  |      | 733-0239  | NEEDLE BAR COVER             | 1    |        |
| 40  |      | 733-0240  | COVER PLATE                  | 1    |        |
| 41  |      | 733-0241  | SCREW 11/64-40 L=8           | 2    |        |
| 42  |      | 733-0242  | WASHER                       | 1    |        |
| 43  |      | 733-0243  | SCREW M6*1 L=15              | 1    |        |
| 44  |      | 733-0244  | OIL FELT                     | 1    |        |
| 45  |      | 733-0245  | FELT RETAINER                | 1    |        |

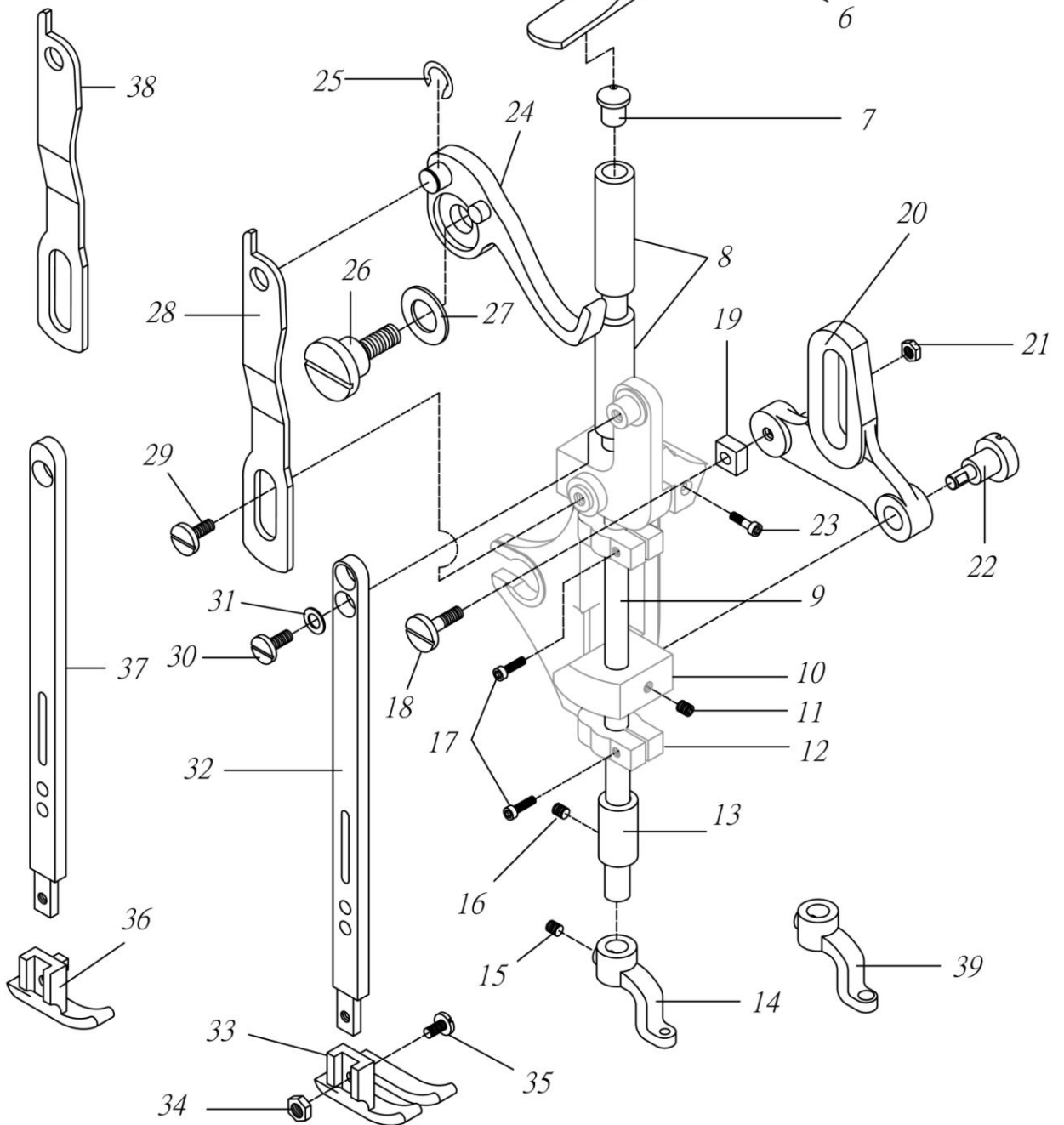
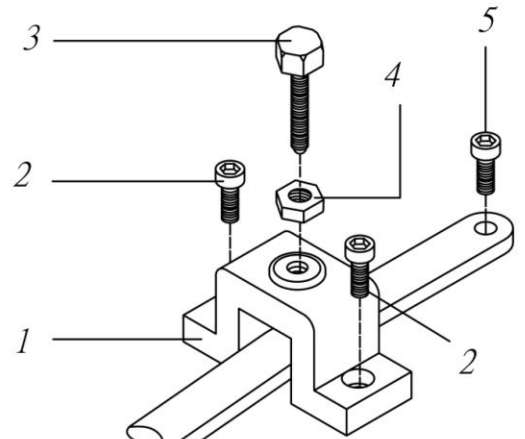
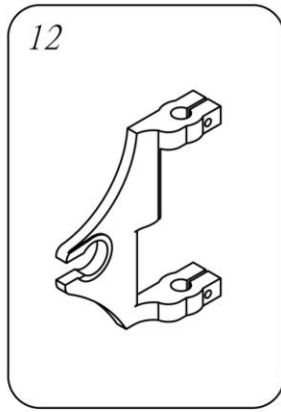
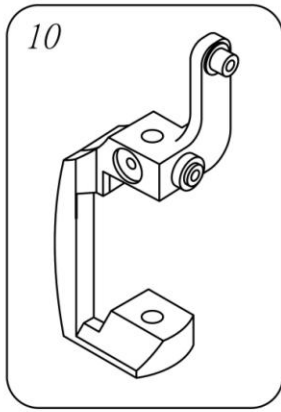
NOTE: #03 ..... Optional Part

### 3. UPPER FEED MECHANISM COMPONENTS



| NO. | NOTE | PART NO. | DESCRIPTION                  | AMT. | NOTE  |
|-----|------|----------|------------------------------|------|-------|
| 1   |      | 733-0301 | UPPER FEED SHAFT             | 1    | 35072 |
| 2   |      | 733-0302 | SCREW 15/64-28 L=8           | 2    |       |
| 3   |      | 733-0303 | SCREW 9/64-40 L=8            | 1    |       |
| 4   |      | 733-0304 | COLLAR 16*26*12              | 1    | 35073 |
| 5   |      | 733-0305 | SCREW 15/64-28 L=5           | 2    |       |
| 6   |      | 733-0306 | CRANK                        | 1    | 35069 |
| 7   |      | 733-0202 | SCREW M6*1 L=20              | 2    | 35034 |
| 8   |      | 733-0308 | SCREW M6*1 L=18              | 1    |       |
| 9   |      | 733-0309 | BUSHING (REAR)               | 1    | 35071 |
| 10  |      | 733-0310 | SCREW 15/64-28 L=11          | 1    |       |
| 11  |      | 733-0311 | BUSHING (FRONT)              | 1    | 35077 |
| 12  |      | 733-0312 | ADJUSTING ARM                | 1    | 35078 |
| 13  |      | 733-0313 | PIN 5X40                     | 1    |       |
| 14  |      | 733-0213 | SCREW 5/16-24 L=8            | 1    | 35017 |
| 15  |      | 733-0315 | HINGE SCREW 7/32-32          | 1    | 35079 |
| 16  |      | 733-0316 | PIPE                         | 1    | 35080 |
| 17  |      | 733-0317 | SLIDE BLOCK                  | 1    | 35081 |
| 18  |      | 733-0318 | WASHER 5.6*23*2              | 1    | 35082 |
| 19  |      | 733-0319 | NUT 7/32-32                  | 1    |       |
| 20  |      | 733-0320 | UPPER FEED FORKED CONNECTION | 1    | 35083 |
| 21  |      | 733-0321 | SCREW 7/32-32 L=12           | 1    |       |
| 22  |      | 733-0322 | SHAFT                        | 1    | 35084 |
| 23  |      | 733-0323 | BUSHING                      | 2    | 35085 |
| 24  |      | 733-0324 | SCREW 15/64-28 L=9           | 2    |       |
| 25  |      | 733-0325 | CONNECTING BRACKET           | 1    | 35087 |
| 26  |      | 733-0326 | SCREW 1/4-24 L=16            | 2    | 35223 |
| 27  |      | 733-0327 | CRANK                        | 1    | 35090 |
| 28  |      | 733-0328 | HINGE SCREW                  | 2    |       |
| 29  |      | 733-0329 | ADJUSTING ARM                | 1    |       |
| 30  |      | 733-0330 | SCREW 1/4-40 L=8             | 4    |       |
| 31  |      | 733-0331 | SCREW 15/64-28 L=15          | 2    |       |
| 32  |      | 733-0332 | STUD                         | 1    | 35109 |
| 33  |      | 733-0333 | BUSHING                      | 2    |       |
| 34  |      | 733-0334 | BRACKET                      | 1    | 35454 |
| 35  |      | 733-0335 | SCREW 3/8-16 L=18            | 2    | 35111 |
| 36  |      | 733-0336 | PIN 6X50                     | 2    | 35112 |
| 37  |      | 733-0337 | ADJUSTING ARM                | 1    |       |
| 38  |      | 733-0338 | SCREW STUD 9/32-28           | 1    |       |
| 39  |      | 733-0339 | ROLLER                       | 1    |       |
| 40  |      | 733-0340 | E-RING                       | 1    |       |
| 41  |      | 733-0220 | NUT 9/32-28                  | 1    |       |
| 42  |      | 733-0342 | CONNECTING ROD               | 1    | 35067 |
| 43  |      | 733-0343 | SHAFT CRANK                  | 1    | 35065 |
| 44  |      | 733-0202 | SCREW M6*1 L=20              | 1    | 35034 |
| 45  |      | 733-0345 | SCREW M6*1 L=15              | 1    |       |
| 46  |      | 733-0346 | STUD                         | 1    | 35066 |
| 47  |      | 733-0347 | STUD                         | 1    | 5068  |
| 48  |      | 733-0348 | THREAD WINDER GUIDE BASE     | 1    |       |

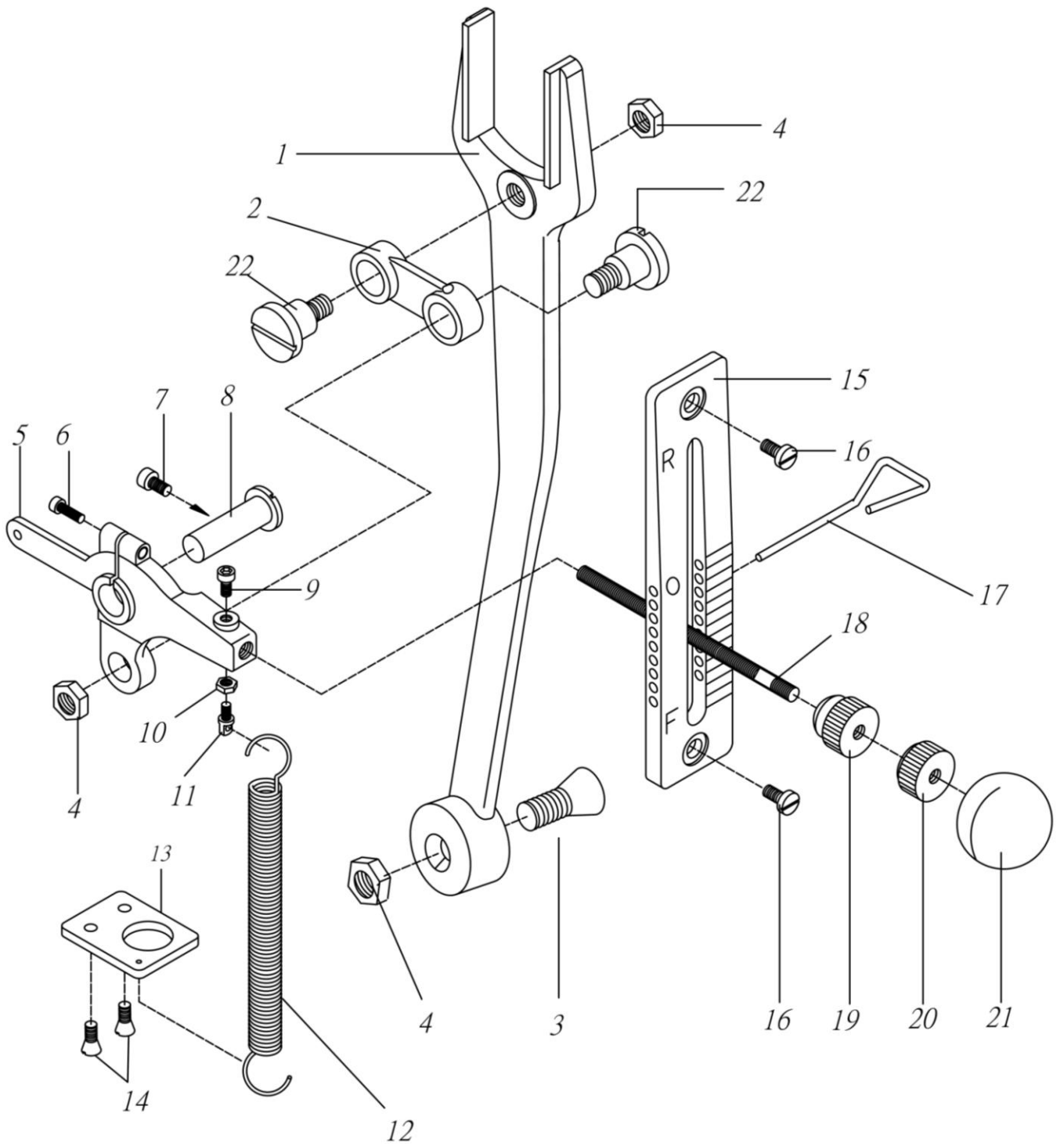
# 4. PRESSER BAR COMPONENTS



| NO. | NOTE | PART NO.  | DESCRIPTION                      | AMT. | NOTE   |
|-----|------|-----------|----------------------------------|------|--------|
| 1   |      | 733-0401  | BRACKET                          | 1    | 35127  |
| 2   |      | 733-0402  | SCREW M6*1 L=20                  | 2    |        |
| 3   |      | 733-0403  | SCREW 5/16-18 L=36               | 1    | 35128  |
| 4   |      | 733-0404  | NUT 5/16-18                      | 1    | 35129  |
| 5   |      | 733-0345  | SCREW M6*1 L=15                  | 1    |        |
| 6   |      | 733-0406  | PRESSER BAR SPRING               | 1    | 35125  |
| 7   |      | 733-0407  | SLEEVE CAP                       | 1    | 35136  |
| 8   |      | 733-0408  | PRESSER BAR SLEEVE               | 2    |        |
| 9   |      | 733-0409  | PRESSER BAR                      | 1    | 35140  |
| 10  |      | 733-0410  | PRESSER BAR CONNECTING LINK      | 1    | 35139  |
| 11  |      | 733-0411  | SCREW 1/4-40 L=12                | 1    | 8009   |
| 12  |      | 733-0412  | LIFTING PRESSER BAR BRACKET      | 1    | 35120  |
| 13  |      | 733-0228  | BUSHING                          | 1    |        |
| 14  |      | 733-0414  | INNER PRESSER FOOT               | 1    | 35141  |
| 15  |      | 733-0415  | SCREW 1/4-40 L=6                 | 1    | 10828  |
| 16  |      | 733-0229  | SCREW 15/64-28 L=7               | 1    |        |
| 17  |      | 733-0417  | SCREW 3/16-28 L=12               | 2    | 6306   |
| 18  |      | 733-0418  | HINGE SCREW 9/32-28              | 1    | 35116  |
| 19  |      | 733-0419  | SLIDE BLOCK                      | 1    | 35117  |
| 20  |      | 733-0420  | OUTER PRESSER BAR BELL           | 1    | 35115  |
| 21  |      | 733-0204  | NUT 9/32-28                      | 1    | 8105   |
| 22  |      | 733-0422N | STUD PIN                         | 1    |        |
| 23  |      | 733-0215  | SCREW 3/16-28 L=20               | 1    | 6029   |
| 24  |      | 733-0424  | PRESSER BAR LIFTING LEVER ASM.   | 1    | 35147C |
| 25  |      | 733-0425  | COTTER PIN                       | 1    |        |
| 26  |      | 733-0426  | HINGE SCREW 5/16-24              | 1    | 35150  |
| 27  |      | 733-0427  | WASHER 17.4*12.9*0.33            | 1    | 35151  |
| 28  |      | 733-0428  | PRESSER BAR LIFTING LINK         | 1    | 35152  |
| 28  | #1   | 733-0428N | PRESSER BAR LIFTING LINK         | 1    |        |
| 29  |      | 733-0429  | SCREW 1/4-24 L=11                | 1    | 35154  |
| 30  |      | 733-0430  | SCREW 3/16-32 L=8                | 1    | 8089   |
| 31  |      | 733-0431  | WASHER                           | 1    | 35094  |
| 32  |      | 733-0432  | OUTER PRESSER BAR                | 1    | 35093  |
| 32  | #1   | 733-0432N | OUTER PRESSER BAR                | 1    |        |
| 33  |      | 733-0433  | OUTER PRESSER FOOT               | 1    | 35096  |
| 34  |      | 733-0434  | NUT 3/16-32                      | 1    |        |
| 35  |      | 733-0435  | SCREW 3/16-32 L=8                | 1    |        |
| 36  | #1   | 733-0436  | OUTER PRESSER FOOT               | 1    | 35174  |
| 37  | #1   | 733-0437  | OUTER PRESSER BAR                | 1    |        |
| 38  | #1   | 733-0438  | PRESSER BAR LIFTING LINK         | 1    |        |
| 39  | #1   | 733-0439  | INNER PRESSER FOOT (For 6x3 #30) | 1    |        |

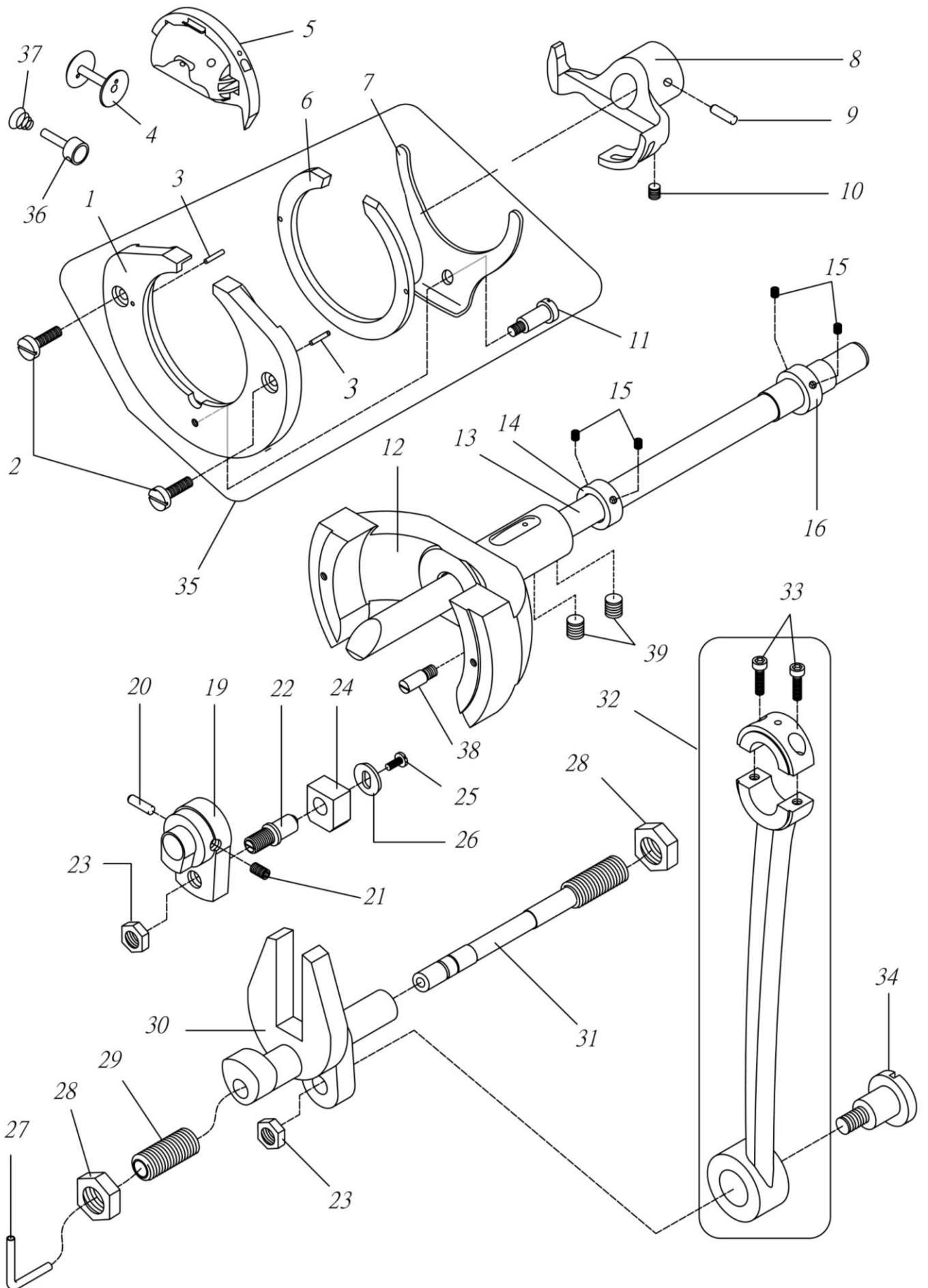
NOTE: #01 ..... FOR 733R-8

5.FEED REGULATOR MECHANISM COMPONENTS



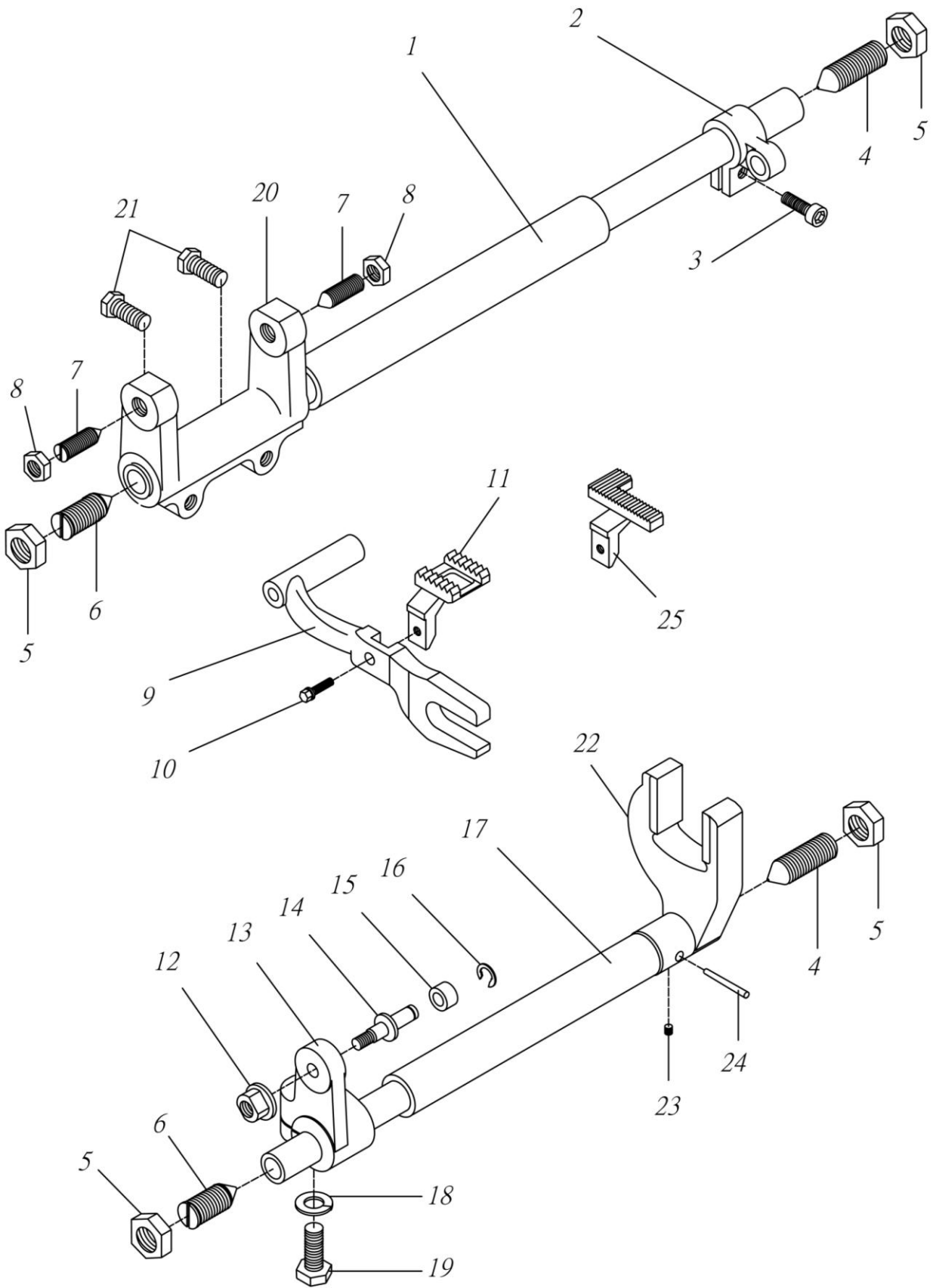
| REF. NO. | NOTE | PART NO.  | DESCRIPTION            | AMT. | NOTE   |
|----------|------|-----------|------------------------|------|--------|
| 1        |      | 733-0501  | FEED FORKED CONNECTION | 1    | 35046  |
| 2        |      | 733-0502N | FEED CONNECTING LINK   | 1    |        |
| 3        |      | 733-0503  | SCREW 3/8-28 L=18      | 1    | 35048  |
| 4        |      | 733-0226  | NUT 3/8-28             | 3    | 6027-2 |
| 5        |      | 733-0505  | FEED REGULATOR         | 1    | 35049  |
| 6        |      | 733-0506  | SCREW M5*0.8 L=20      | 1    | 17053  |
| 7        |      | 733-0507  | SCREW 15/64-28 L=12    | 1    |        |
| 8        |      | 733-0508  | FEED REGULATOR SHAFT   | 1    | 35050  |
| 9        |      | 733-0509  | SCREW 3/16-32          | 1    |        |
| 10       |      | 733-0510  | NUT 3/16-32            | 1    |        |
| 11       |      | 733-0511  | SCREW STUD             | 1    |        |
| 12       |      | 733-0512  | SPRING                 | 1    | 35058  |
| 13       |      | 733-0513N | BRACKET                | 1    |        |
| 14       |      | 733-0514N | SCREW 11/64-40         | 2    |        |
| 15       |      | 733-0515  | STITCH LENGTH PLATE    | 1    | 35052  |
| 16       |      | 733-0516  | SCREW 15/64-28 L=14    | 2    |        |
| 17       |      | 733-0517  | LEVER STOPPER          | 1    |        |
| 18       |      | 733-0518  | FEED REGULATING LEVER  | 1    | 35051  |
| 19       |      | 733-0519  | NUT (A) 5/16-28        | 1    | 35055  |
| 20       |      | 733-0520  | NUT (B) 5/16-28        | 1    | 35056  |
| 21       |      | 733-0521  | KNOB                   | 1    | 35057  |
| 22       |      | 733-0522N | SCREW 3/8-28 L=18      | 2    |        |

## 6. HOOK DRIVING SHAFT COMPONENTS



| REF. NO. | NOTE | PART NO.  | DESCRIPTION                    | AMT. | NOTE    |
|----------|------|-----------|--------------------------------|------|---------|
| 1        |      | 733-0601  | SHUTTLE RACE BODY              | 1    | 35222-1 |
| 2        |      | 733-0326  | SCREW 1/4-24 L=16              | 2    | 35223   |
| 3        |      | 733-0603  | SHUTTLE RACE BACK POSITION PIN | 2    | 35222-2 |
| 4        |      | 733-0604  | BOBBIN                         | 1    | 35226   |
| 5        |      | 733-0605  | SHUTTLE HOOK                   | 1    | 35224   |
| 6        |      | 733-0606  | SHUTTLE RACE BACK              | 1    | 35222-3 |
| 7        |      | 733-0607  | BACK SPRING                    | 1    | 35222-4 |
| 8        |      | 733-0608  | SHUTTLE DRIVER                 | 1    | 35218   |
| 9        |      | 733-0313  | PIN 5X40                       | 1    |         |
| 10       |      | 733-0213  | SCREW 5/16-24 L=8              | 1    | 35017   |
| 11       |      | 733-0611  | HINGE SCREW 1/4-24             | 1    | 35222-5 |
| 12       |      | 733-0612  | SHUTTLE RACE FRAME             | 1    | 35219   |
| 13       |      | 733-0613  | OSCILATING SHAFT               | 1    | 35216   |
| 14       |      | 733-0614  | COLLAR 19*32*14.5              | 1    | 35227   |
| 15       |      | 733-0615  | SCREW 1/4-40 L=6               | 4    |         |
| 16       |      | 733-0616  | COLLAR 20*32*14.5              | 1    | 35217   |
| 17       |      | 733-0617  | SCREW 3/8-16 L=32              | 1    |         |
| 18       |      | 733-0618  | SPRING WASHER 10*16.5*2        | 1    |         |
| 19       |      | 733-0619  | OSCILATING SHAFT CRANK         | 1    | 35214   |
| 20       |      | 733-0313  | PIN 5X40                       | 1    |         |
| 21       |      | 733-0213  | SCREW 5/16-24 L=8              | 1    | 35017   |
| 22       |      | 733-0622  | HINGE SCREW 1/2-18             | 1    |         |
| 23       |      | 733-0623  | NUT 1/2-18                     | 2    |         |
| 24       |      | 733-0624  | SLIDE BLOCK                    | 1    | 35210   |
| 25       |      | 733-0625  | SCREW 13/64-32 L=9             | 1    | 12418   |
| 26       |      | 733-0626  | WASHER                         | 1    | 35212   |
| 27       |      | 733-0627  | OIL PIPE & WICK                | 1    | 35208   |
| 28       |      | 733-0628  | NUT 5/8-16                     | 2    | 35187   |
| 29       |      | 733-0629  | THUMB SCREW 5/8-16             | 1    | 35207   |
| 30       |      | 733-0630  | OSCILATING ROCK SHAFT          | 1    | 35205   |
| 31       |      | 733-0631  | HINGE PIN                      | 1    | 35206   |
| 32       |      | 733-0632  | CONNECTING ROD ASM.            | 1    | 35201C  |
| 33       |      | 733-0633  | SCREW M5*0.8 L=20              | (2)  |         |
| 34       |      | 733-0634N | SCREW 1/2-18 L=25              | 1    |         |
| 35       |      | 733-0635  | SHUTTLE RACE COMPLETE          | 1    | 35222C  |
| 36       |      | 733-0636  | TENSION SHAFT                  | 1    |         |
| 37       |      | 733-0637  | TENSION SPRING                 | 1    |         |
| 38       |      | 733-0638  | SCREW 3/8-28 L=10              | 1    |         |
| 39       |      | 733-0639  | SCREW M8X1.25 L=20             | 2    |         |

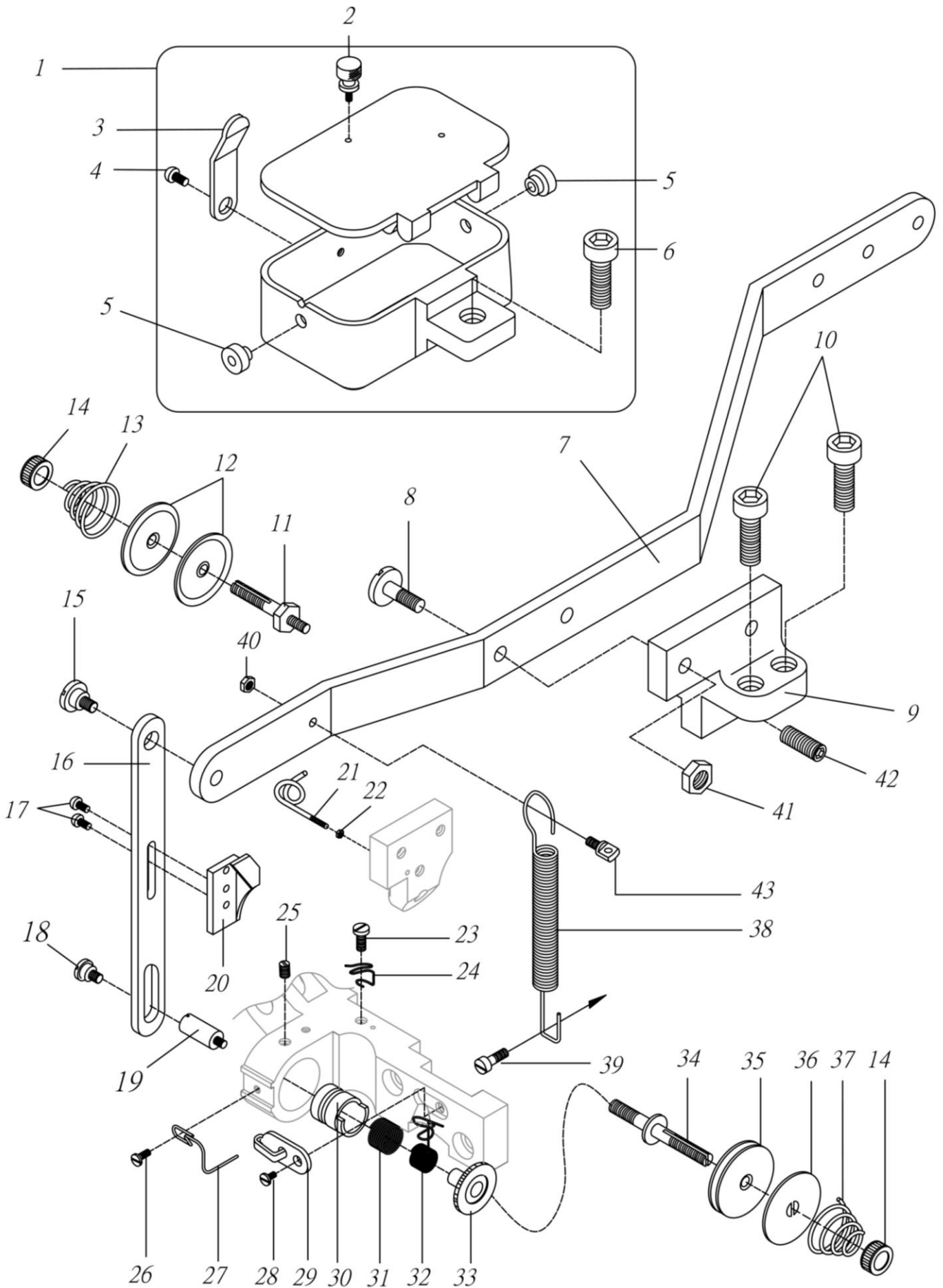
# 7. FEED MECHANISM COMPONENTS



| REF. NO. | NOTE | PART NO.  | DESCRIPTION          | AMT. | NOTE   |
|----------|------|-----------|----------------------|------|--------|
| 1        |      | 733-0701N | FEED ROCK SHAFT      | 1    |        |
| 2        |      | 733-0702  | CRANK                | 1    | 35182  |
| 3        |      | 733-0202  | SCREW M6*1 L=20      | 1    |        |
| 4        |      | 733-0704  | SCREW 5/8-16 L=52    | 2    |        |
| 5        |      | 733-0628  | NUT 5/8-16           | 4    | 35187  |
| 6        |      | 733-0706  | SCREW 5/8-16 L=41    | 2    | 35186  |
| 7        |      | 733-0707  | SCREW 3/8-28 L=20    | 2    | 6027-1 |
| 8        |      | 733-0226  | NUT 3/8-28           | 2    | 6027-2 |
| 9        |      | 733-0709  | FEED BAR             | 1    | 35188  |
| 10       |      | 733-0710  | SCREW 15/64-28 L=8.5 | 1    |        |
| 11       |      | 733-0711  | FEED DOG             | 1    | 35189  |
| 12       |      | 733-0220  | NUT 9/32-28          | 1    |        |
| 13       |      | 733-0713  | ROCK SHAFT CRANK     | 1    |        |
| 14       |      | 733-0714  | SCREW STUD 9/32-28   | 1    |        |
| 15       |      | 733-0715  | ROLLER               | 1    |        |
| 16       |      | 733-0716  | E-RING               | 1    |        |
| 17       |      | 733-0717N | DRIVING SHAFT        | 1    |        |
| 18       |      | 733-0618  | WASHER 10*16.5*2     | 1    |        |
| 19       |      | 733-0719  | SCREW 3/8-16 L=25    | 1    |        |
| 20       |      | 733-0720  | FEED BAR ARM         | 1    |        |
| 21       |      | 733-0721  | SCREW M8x1.25 L=20   | 2    |        |
| 22       |      | 733-0722  | DRIVING SHAFT ARM    | 1    |        |
| 23       |      | 733-0723  | SCREW                | 1    |        |
| 24       |      | 733-0724  | PIN                  | 1    |        |
| 25       | #01  | 733-0725  | FEED DOG             | 1    | 35176  |

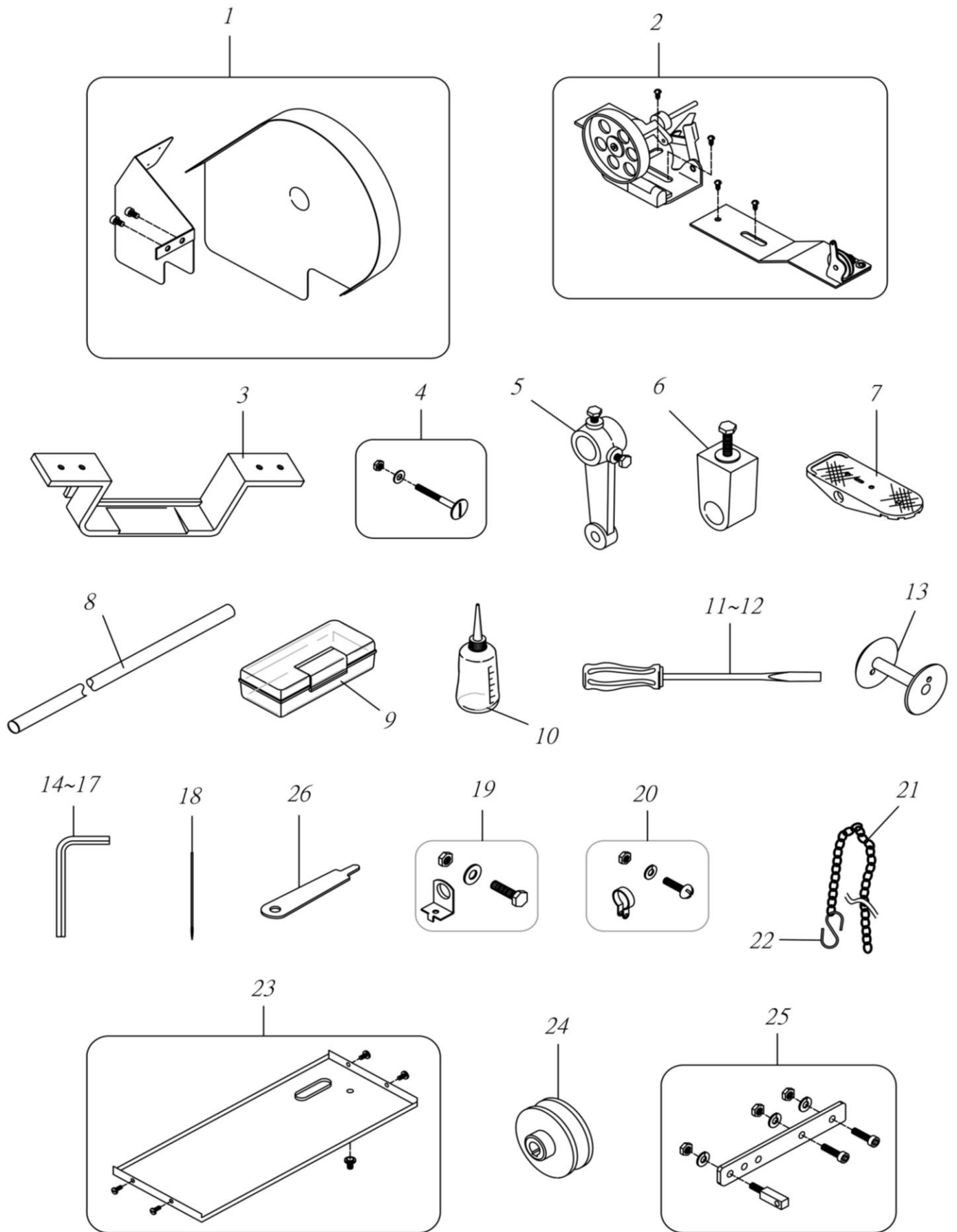
NOTE: #01 ..... FOR 733R-8

8. KNEE LIFTER & TENSION POST COMPONENTS



| REF. NO. | NOTE | PART NO. | DESCRIPTION                     | AMT. | NOTE   |
|----------|------|----------|---------------------------------|------|--------|
| 1        |      | 733-0801 | OIL BOX ASM.                    | 1    | 35157C |
| 2        |      | 733-0802 | SCREW                           | (1)  |        |
| 3        |      | 733-0803 | SPRING                          | (1)  |        |
| 4        |      | 733-0108 | SCREW 9/64-40 L=7               | (1)  |        |
| 5        |      | 733-0805 | PIPE                            | (2)  |        |
| 6        |      | 733-0345 | SCREW M6*1 L=12                 | (1)  |        |
| 7        |      | 733-0807 | FOOT LIFTING LEVER              | 1    | 35131  |
| 8        |      | 733-0808 | HINGE SCREW 1/4-24              | 1    |        |
| 9        |      | 733-0809 | BRACKET                         | 1    | 35130  |
| 10       |      | 733-0202 | SCREW M6*1 L=16                 | 1    | 35034  |
| 11       |      | 733-0811 | TENSION STUD 3/16-32            | 1    | 4171   |
| 12       |      | 733-0812 | TENSION DISC                    | 2    | 1423   |
| 13       |      | 733-0813 | TENSION SPRING                  | 1    | 1422   |
| 14       |      | 733-0814 | TENSION THUMB NUT 1/4-40        | 2    | 8079   |
| 15       |      | 733-0815 | HINGE SCREW 1/4-24 D=7.94 H=3.9 | 1    |        |
| 16       |      | 733-0816 | LIFTING BRACKET                 | 1    | 35132  |
| 17       |      | 733-0108 | SCREW 9/64-40 L=7               | 2    |        |
| 18       |      | 733-0818 | HINGE SCREW 17/64-24            | 1    |        |
| 19       |      | 733-0819 | SCREW STUD 17/64-24             | 1    | 35135  |
| 20       |      | 733-0820 | TENSION RELEASE LEVER           | 1    | 35145  |
| 21       |      | 733-0821 | THREAD GUIDE (UPPER)            | 1    | 35158  |
| 22       |      | 733-0822 | NUT 9/64-40                     | 1    |        |
| 23       |      | 733-0514 | SCREW 11/64-40 L=8              | 1    |        |
| 24       |      | 733-0824 | THREAD GUIDE                    | 1    | 35159  |
| 25       |      | 733-0302 | SCREW 15/64-28 L=8              | 1    |        |
| 26       |      | 733-0435 | SCREW 3/16-32 L=8               | 1    |        |
| 27       |      | 733-0827 | LARGE THREAD GUIDE              | 1    | 35166  |
| 28       |      | 733-0108 | SCREW 9/64-40 L=7               | 1    |        |
| 29       |      | 733-0829 | THREAD GUIDE                    | 1    | 10683  |
| 30       |      | 733-0830 | TENSION REGULATOR               | 1    | 1414   |
| 31       |      | 733-0831 | REGULATING SPRING               | 1    | 1417   |
| 32       |      | 733-0832 | THREAD TAKE-UP SPRING           | 1    | 35161  |
| 33       |      | 733-0833 | SLEEVE                          | 1    | 1418   |
| 34       |      | 733-0834 | THREAD CONTROLLER STUD          | 1    | 35160  |
| 35       |      | 733-0835 | TENSION DISC                    | 1    | 35162  |
| 36       |      | 733-0836 | TENSION WASHER                  | 1    | 35163  |
| 37       |      | 733-0837 | TENSION SPRING                  | 1    | 35165  |
| 38       |      | 733-0838 | LEVER SPRING                    | 1    | 35276  |
| 39       |      | 733-0839 | SCREW 11/64-40 L=12             | 1    |        |
| 40       |      | 733-0840 | NUT 3/16-32                     | 1    |        |
| 41       |      | 733-0841 | NUT 1/4-24                      | 1    |        |
| 42       |      | 733-0842 | SCREW M6x1 L=25                 | 1    |        |
| 43       |      | 733-0843 | SCREW 3/16-32                   | 1    |        |

9. BELT COVER & ACCESSORIES PARTS COMPONENTS



| REF. NO. | NOTE | PART NO. | DESCRIPTION                       | AMT. | NOTE     |
|----------|------|----------|-----------------------------------|------|----------|
| 1        |      | 733-0901 | BELT COVER ASM.                   | 1    | 35494C   |
| 2        |      | 733-0902 | BOBBIN WINDER ASM.                | 1    | 35255    |
| 3        |      | 733-0903 | BED HINGE                         | 2    | 35240    |
| 4        |      | 733-0904 | SCREW, WASHER, & NUT ASM. 5/16-18 | 8    | 35241    |
| 5        |      | 733-0905 | PEDAL ASM.                        | 2    | 35280C   |
| 6        |      | 733-0906 | PEDAL ASM.                        | 2    | 35280C-1 |
| 7        |      | 733-0907 | PEDAL                             | 1    | 13094    |
| 8        |      | 733-0908 | PIPE                              | 1    | 35280C-2 |
| 9        |      | 733-0909 | ACCESSORY BOX                     | 1    |          |
| 10       |      | 733-0910 | OILER ASM.                        | 1    |          |
| 11       |      | 733-0911 | SCREW DRIVER, LARGE               | 1    | 8118     |
| 12       |      | 733-0912 | SCREW DRIVER, SMALL               | 1    | 8120     |
| 13       |      | 733-0604 | BOBBIN                            | 3    | 35226    |
| 14       |      | 733-0914 | HEXAGON WRENCH                    | 1    |          |
| 15       |      | 733-0915 | HEXAGON WRENCH                    | 1    |          |
| 16       |      | 733-0916 | HEXAGON WRENCH                    | 1    |          |
| 17       |      | 733-0917 | HEXAGON WRENCH                    | 1    |          |
| 18       |      | 733-0236 | NEEDLE                            | 3    | N0925    |
| 19       |      | 733-0919 | STOPPER ASM.                      | 2    |          |
| 20       |      | 733-0920 | STOPPER ASM.                      | 2    |          |
| 21       |      | 733-0921 | CHAIN                             | 1    |          |
| 22       |      | 733-0922 | S-PLUG                            | 1    |          |
| 23       |      | 733-0923 | OIL PAN                           | 1    |          |
| 24       |      | 733-0924 | MOTOR PULLEY A65 (OPTIONAL A75)   | 1    |          |
| 25       |      | 733-0925 | MOTOR LEVER COMPLETE              | 1    |          |
| 26       |      | 733-0926 | SHUTTLE CYLINDER OPENER           | 1    | 35225    |

# INSTRUCTION MANUAL

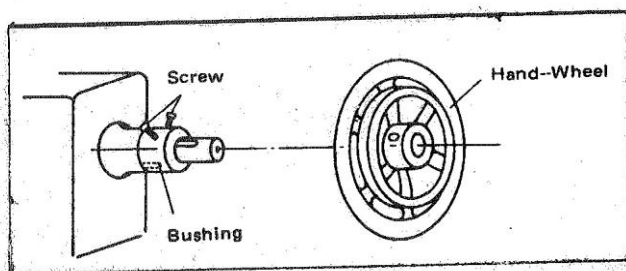
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## IMPORTANT SAFETY INSTRUCTIONS

Putting sewing systems into operation is prohibited until it has been ascertained that the sewing systems in which these sewing machines will be built into, have conformed with the safety regulations in your country. Technical service for those sewing systems is also prohibited.

1. Observe the basic safety measures, including, but not limited to the following ones, whenever you use the machine.
2. Read all the instructions, including, but not limited to this instruction manual before you use the machine.
3. Use the machine after it has been ascertained that it conforms with safety rules/standards valid in you country.
4. All safety devices must be in position when the machine is ready for work or in operation. The operation without the specified safety devices is not allowed.
5. This machine shall be operated by appropriately-trained operators.
6. For your personal protection, we recommend that you wear safety glasses.
7. For the following, turn off the power switch or disconnect the power plug of the machine from the receptacle.
  - ✓ For threading needle(s), looper, spreader etc. and replacing bobbin.
  - ✓ For replacing part(s) of needle, presser foot, throat plate, looper, spreader, feed dog, needle guard, folder, cloth guide etc.
  - ✓ For repair work.
  - ✓ When leaving the working place or when the working place is unattended.
  - ✓ When using clutch motors without applying brake, it has to be waited until the motor stopped totally.
8. If you should allow oil, grease, etc. used with the machine and devices to come in contact with your eyes or skin or swallow any of such liquid by mistake, immediately wash the contacted areas and consult a medical doctor.
9. Tampering with the live parts and devices, regardless of whether the machine is powered, is prohibited.
10. Repair, remodeling and adjustment works must only be done by appropriately trained technicians or specially skilled personnel. Only spare parts designated by Consew can be used for repairs.
11. General maintenance and inspection works have to be done by appropriately trained personnel.
12. Repair and maintenance works of electrical components shall be conducted by qualified electric technicians or under the audit and guidance of specially skilled personnel.
13. Before making repair and maintenance works on the machine equipped with pneumatic parts such as an air cylinder, the air compressor has to be detached from the machine and the compressed air supply has to be cut off. Existing residual air pressure after disconnecting the air compressor from the machine has to be expelled. Exceptions to this are only adjustments and performance checks done by appropriately trained technicians or specially skilled personnel.
14. Periodically clean the machine throughout the period of use.
15. Grounding the machine is always necessary for the normal operation of the machine. The machine has to be operated in an environment that is free from strong noise sources such as high-frequency welder.
16. An appropriate power plug has to be attached to the machine by electric technicians. Power plug has to be connected to a grounded receptacle.
17. The machine is only allowed to be used for the purpose intended. Other used are not allowed.
18. Remodel or modify the machine in accordance with the safety rules/standards while taking all the effective safety measures. Consew assumes no responsibility for damage caused by remodeling or modification of the machine.

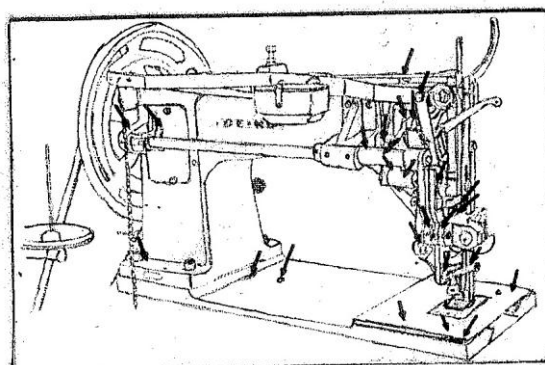
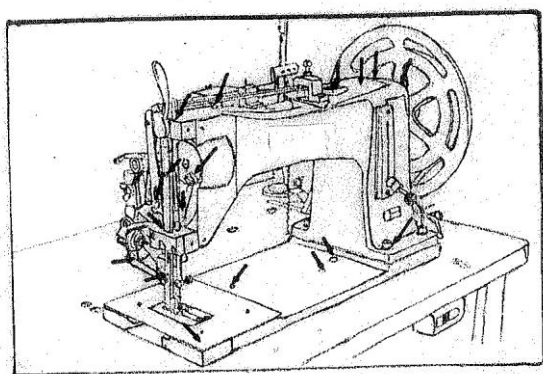
## 1. HOW TO SET HANDWHEEL / 手轉輪的安裝



Remove two screws and take off bushing, and set handwheel with the two screws.

將固定套環的兩個螺絲鬆開，取下套環並將手轉輪裝上並鎖緊螺絲。

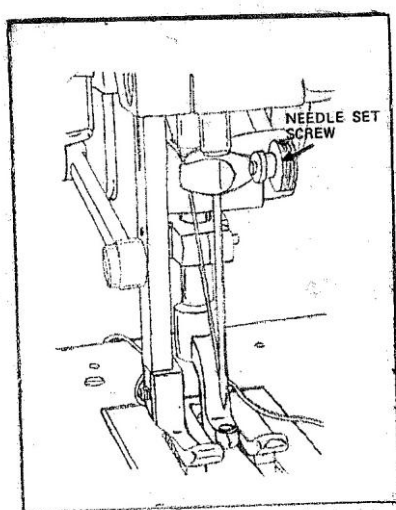
## 2. LUBRICATION / 潤滑



Use white spindle oil. When starting the machine initially and kept for a long time without using at all, oil sufficiently to respective necessary parts before starting operation, pre-running and with severe use. Oil frequently each necessary parts during operation.

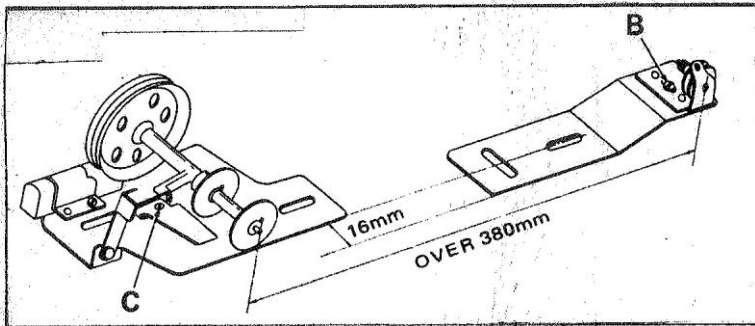
初次運轉縫紉機之前，或長時間沒有使用時，請往箭頭所示的位置加適當的針車油並慢速運轉，1~2 分鐘後即可依正常速度操作。作業時須經常將需要的零件加以潤滑。

## 3. ATTACHING THE NEEDLE / 車針的安裝方法



- 1) Turn the handwheel to bring the needle bar to the highest position of its stroke.
  - 2) Loosen needle clamp screw, and hold needle so that the long groove in the needle is facing exactly to the left.
  - 3) Push needle deep into the needle clamp hole until it will go no further.
  - 4) Tighten needle clamp screw firmly.
- 
- 1) 轉動手轉輪，把針桿上昇到最高位置。
  - 2) 擰鬆車針固定螺絲，讓車針的長溝轉到朝向左側。
  - 3) 把車針插到最裡面。
  - 4) 鎖緊車針固定螺絲。

#### 4. WINDING A BOBBIN / 底線的繞線方法



Set bobbin winder as shown

依照圖所示安裝繞線器

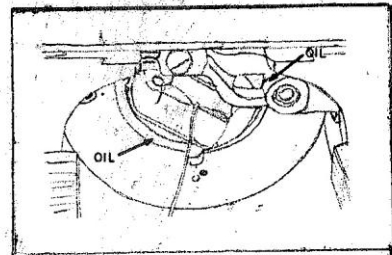
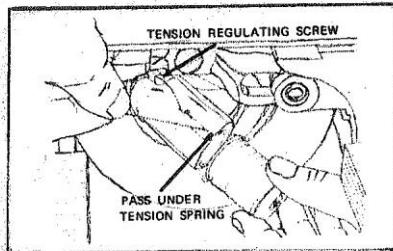
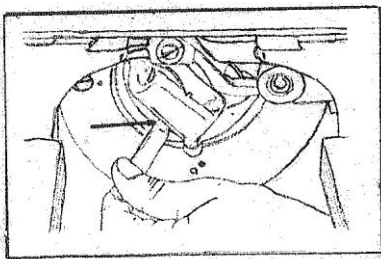
B: Adjustment of center position

B: 中央位置的調整

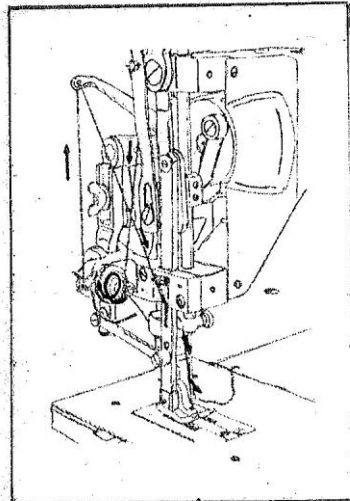
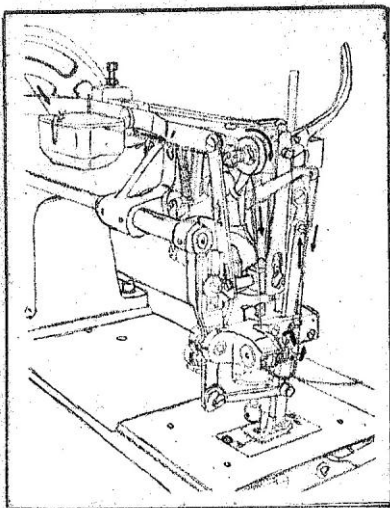
C: Adjustment of winding amount

C: 底線捲繞容量的調整

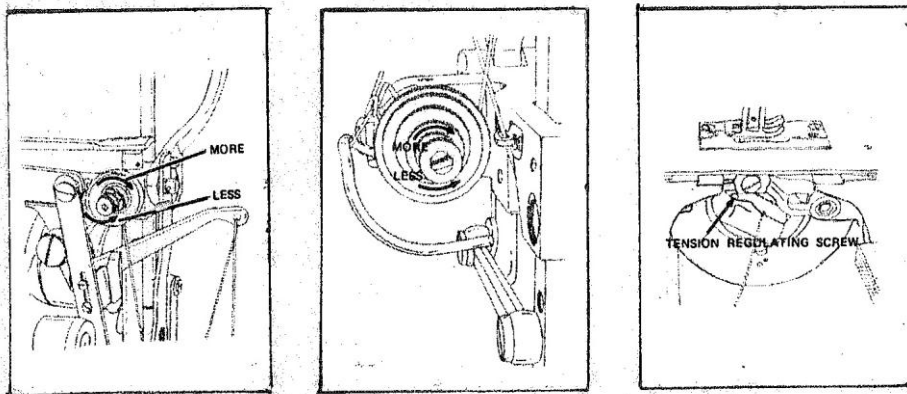
#### 5. ATTACHING AND REMOVING THE BOBBIN / 梭蕊的安裝與取出



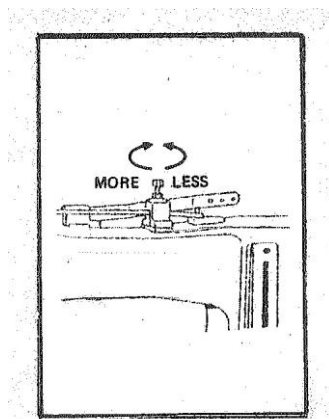
#### 6. THREADING THE MACHINE HEAD / 上線的穿線方法



## 7. THREAD TENSION / 線張力調整



## 8. ADJUSTMENT OF FOOT PRESSURE / 押腳壓力的調整



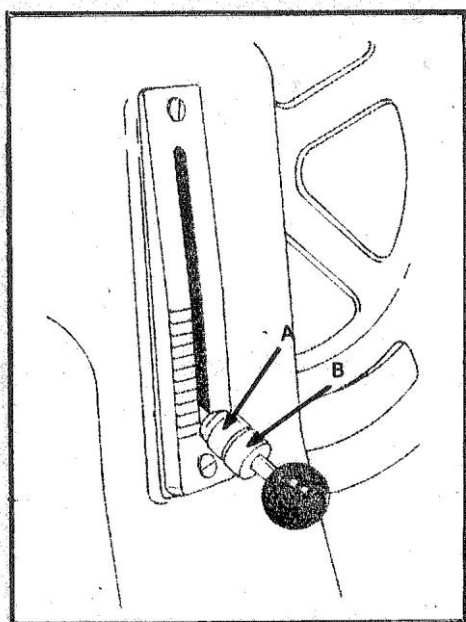
MORE TENSION: turn to right

LESS TENSION: turn to left

向右轉動，押腳壓力則變強。

向左轉動，押腳壓力則變弱。

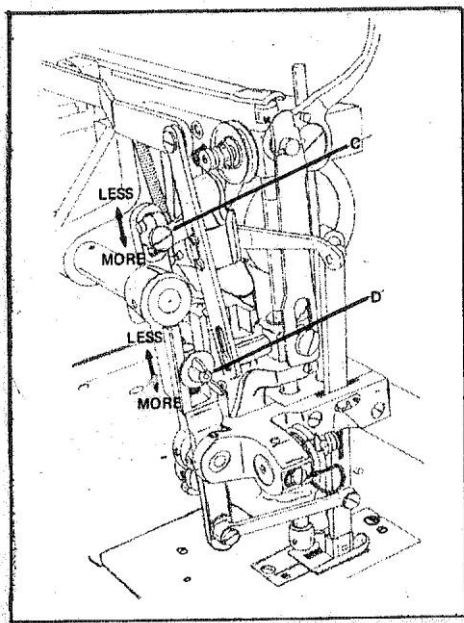
## 9. ADJUSTMENT OF STITCH LENGTH / 縫跡長度的調節



To adjust the stitch length, loosen serrated nut (B). Align the feed lever to the scale indicating the desired amount by nut (A) and tighten nut (B) against nut (A)

鬆開齒狀形的螺母(B)，調整螺母(A)使調整桿往上下移動至希望的線跡長度，並將螺母(B)往螺母(A)鎖緊。

## 10. ADJUSTMENT OF ALTERNATING PRESSER AND UPPER FEED / 押腳與送料腳上升量的調整



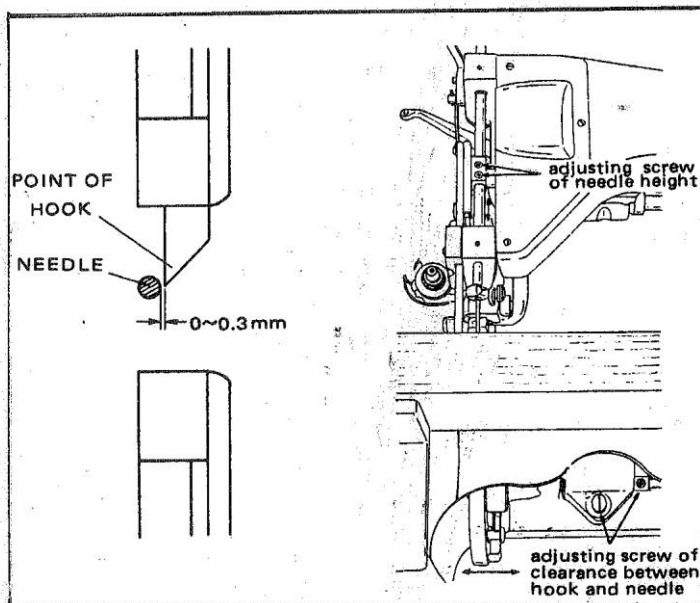
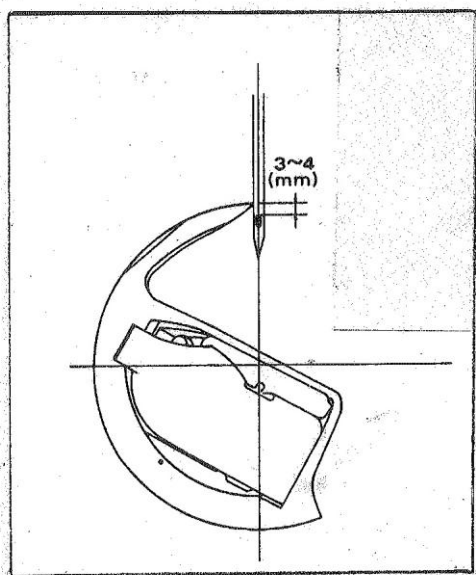
C: adjustment of alternating presser

D: adjustment of feeding amount of outer foot

C: 內押腳壓力的調整

D: 外押腳上升量的調整

## 11. ADJUSTMENT OF THE NEEDLE-TO-SHUTTLE RELATIONSHIP / 車針與大釜的關係



HEIGHT OF NEEDLE: When the point of hook is at the center of the needle, normal measurement between the hook point and the upper end of the needle eye should be 3~4 mm.

(Note) The measurement is for standard needle size. To adjust the measurement, raise or lower the needle bar as may be required

車針最高點: 當大釜尖位於車針的中心時, 大釜尖與針孔最上緣之正常距離應為 3~4mm。

【註】此距離為使用標準車針尺寸。距離調整時需將針桿往上或下降調整。

