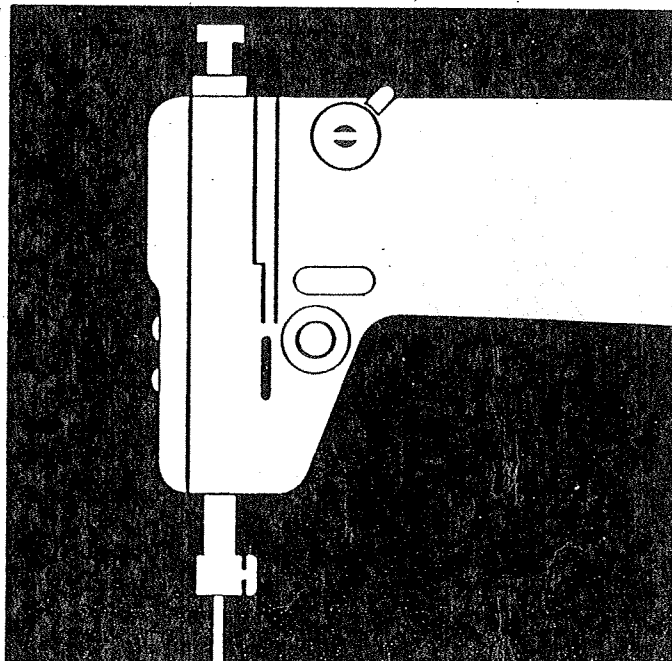


DLS600

OPERATION MANUAL

PARTS LIST

High Speed Single Needle Lockstitch
Industrial Sewing Machine



We thank you for purchasing Model

high speed, single needle, lockstitch industrial sewing machine.

is equipped with reverse feed mechanism for a wide range of usage such as sewing men's shirts, blouses and other general garments.

The thread take-up, sewing hook, feed mechanism, etc. are all specially designed and constructed for high speed sewing. Therefore, at high speed sewing, the running sound is minimal and the stitching condition is superb.

Before operating the machine, please read this OPERATION MANUAL carefully and thoroughly digest the functions of this efficient machine and enjoy everlasting pleasure of using this machine.

SPECIFICATIONS

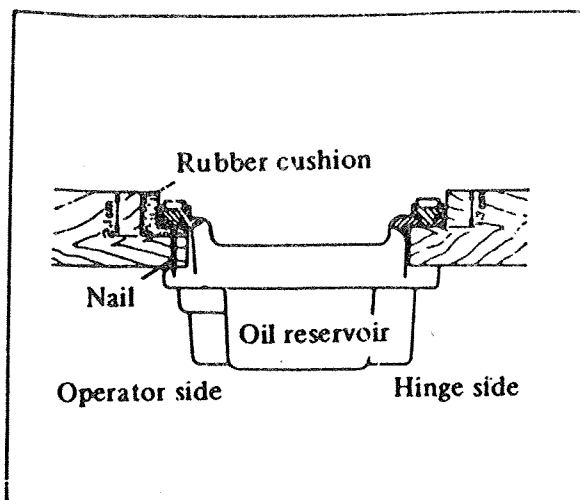
Sewing type	Single needle lockstitch	
Usage	General fabric Medium weight material	Leather or Heavy weight material
Sewing speed	Up to 5,500 s.p.m. Normal speed: 5,000 s.p.m.	Up to 4,500 s.p.m. Normal speed 4,000 s.p.m.
Thread take-up	Link-type thread take-up	
Sewing hook	Automatic lubricating rotary hook Dia. of hook shaft 7.94	
Needles	DB x 1 #14 (#8-#18)	DB x 1 #22 (#20-#25)
Stitch length	0-4mm (5/32")	0-4.5 (11/64)
Stitch adjuster	Dial system	
Reverse sewing	Lever system	
Bed size	178 x 477mm	
Lubrication	Completely automatic lubrication (Rotating volute pump)	
Lubricating oil	Mobile: Velocite E (Viscosity CST 40 °C 9.4-10.6) Shell: Tellus C10 (Viscosity CST 40 °C 10.0)	

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(Note) Due to improvements on the machine, operational procedures in this
OPERATION MANUAL might be partially changed without notice.

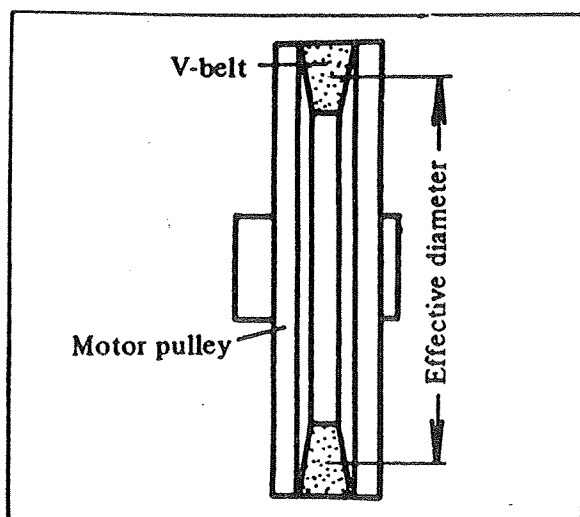
INSTALLING THE OIL RESERVOIR



As shown in the figure, set the reservoir in such a way so that the 4 corners of the grooved part of the table will be supporting the reservoir.

1. Nail in the 2 rubber cushions in front to the protruding part of the table.
2. Place the oil reservoir on the protruding part of the table.

MOTOR PULLEY AND THE BELT



Model' can sew at a high speed of up to 5,500 s.p.m.

Use a 3-phase 400W (1/2 HP) clutch motor when connected directly to the power source. Use a M type V-belt. The relation between the number of rotation of the machine with the dimension of the motor pulley effective diameter is shown in the table.

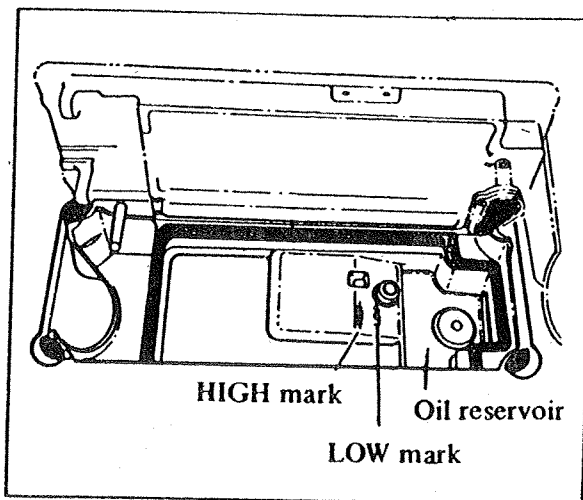
* The effective diameter of the motor pulley means the diameter as measured from the center of the V-belt when the belt is wound around the machine.

Model	Cycle	No. of rotation of machine	Part No. of motor pulley	Effective diameter of motor pulley
	50	5,060 s.p.m. 4,630 s.p.m.	MTK-PV 120000 MTK-PO 110000	120mm (4-47/64") 110mm (4-5/16")
	60	5,040 s.p.m. 4,540 s.p.m.	MTK-PV100000 MTK-PV090000	100mm (3-15/16") 90mm (3-35/64")

CAUTIONS ON OPERATING THE MACHINE

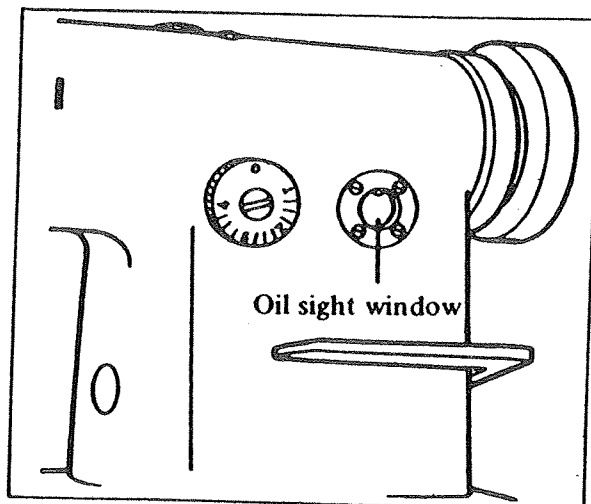
1. Do not run the machine, under any circumstances, before the oil reservoir is filled up with fresh oil.
2. Always rotate the machine toward the operator. Do not run the machine in the reverse direction.
3. Although the machine can attain the maximum speed, operate all a normal speed of 4,500 s.p.m. for the first month. After that, run the machine at an appropriate speed depending on the nature of work and the capability of the operator.

LUBRICATION



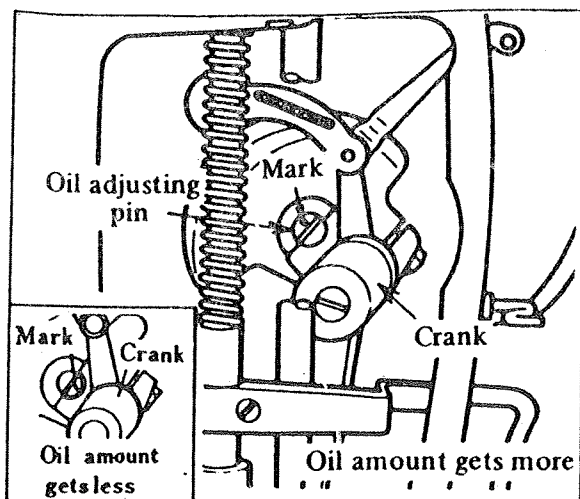
Before operating the machine

1. Fill up the oil reservoir with Oil up to the mark "HIGH".
2. Watch and see that the oil level does not go below the "LOW" mark.
3. Under normal conditions, when the machine is run after it is filled up with oil, the oil will spurt against the oil sight window.



(Caution)

- 1) When the oil gets dirty, change it with new, fresh oil. If the oil plug of the reservoir is removed, oil will come out.
- 2) When the machine is to be run for the first time or when it was idle for a great length of time, run the machine at 3,000–3,500 s.p.m. for about 10 minutes and allow the machine to get well-oiled.
- 3) When the machine is to be run constantly at less than 3,500 s.p.m. adjust so that the oil supply to various parts is increased.



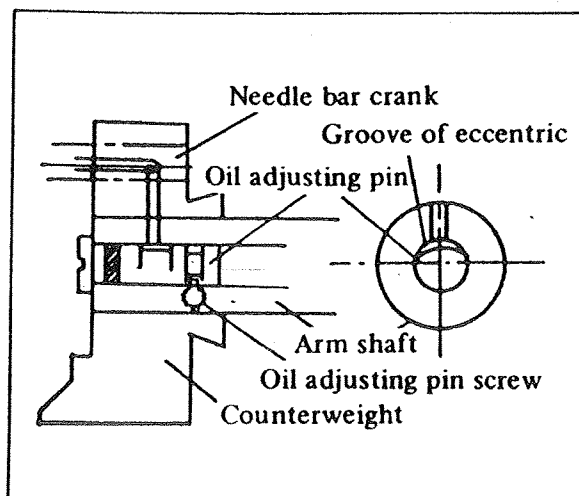
1. Adjusting the oil supply to the face part

When adjusting the oil supply to the thread take-up and needle bar crank components, remove the face plate and the oil preventing plate and adjust by turning the oil adjusting pin at the tip of the main shaft.

1. When the red mark of the adjusting pin comes near the crank, the oil amount gets less.
2. When the red mark comes to the opposite side of the crank, the oil amount gets more.

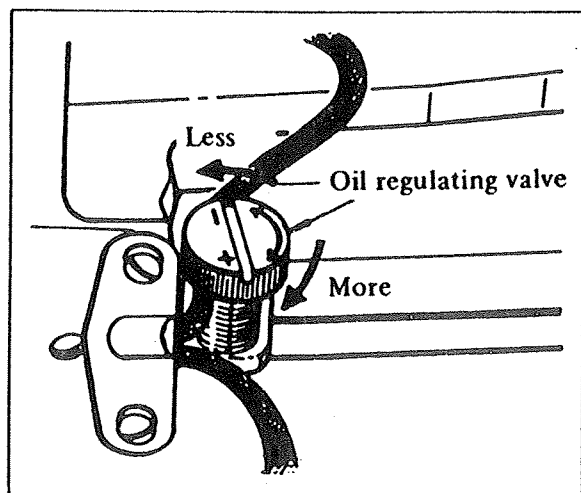
(Caution)

The oil amount does not change immediately after the adjustment, so when adjusting, have this in mind.



2. Oil adjusting pin

1. The oil adjusting pin has a carved groove as shown in the figure. When this groove and the oil hole of the main shaft come together, the oil amount gets more.
2. When the groove is at the opposite side of the oil hole, the oil amount gets less.
3. The red mark on the oil adjuster shows the side without the carved groove.



3. Adjusting the oil supply to the hook components

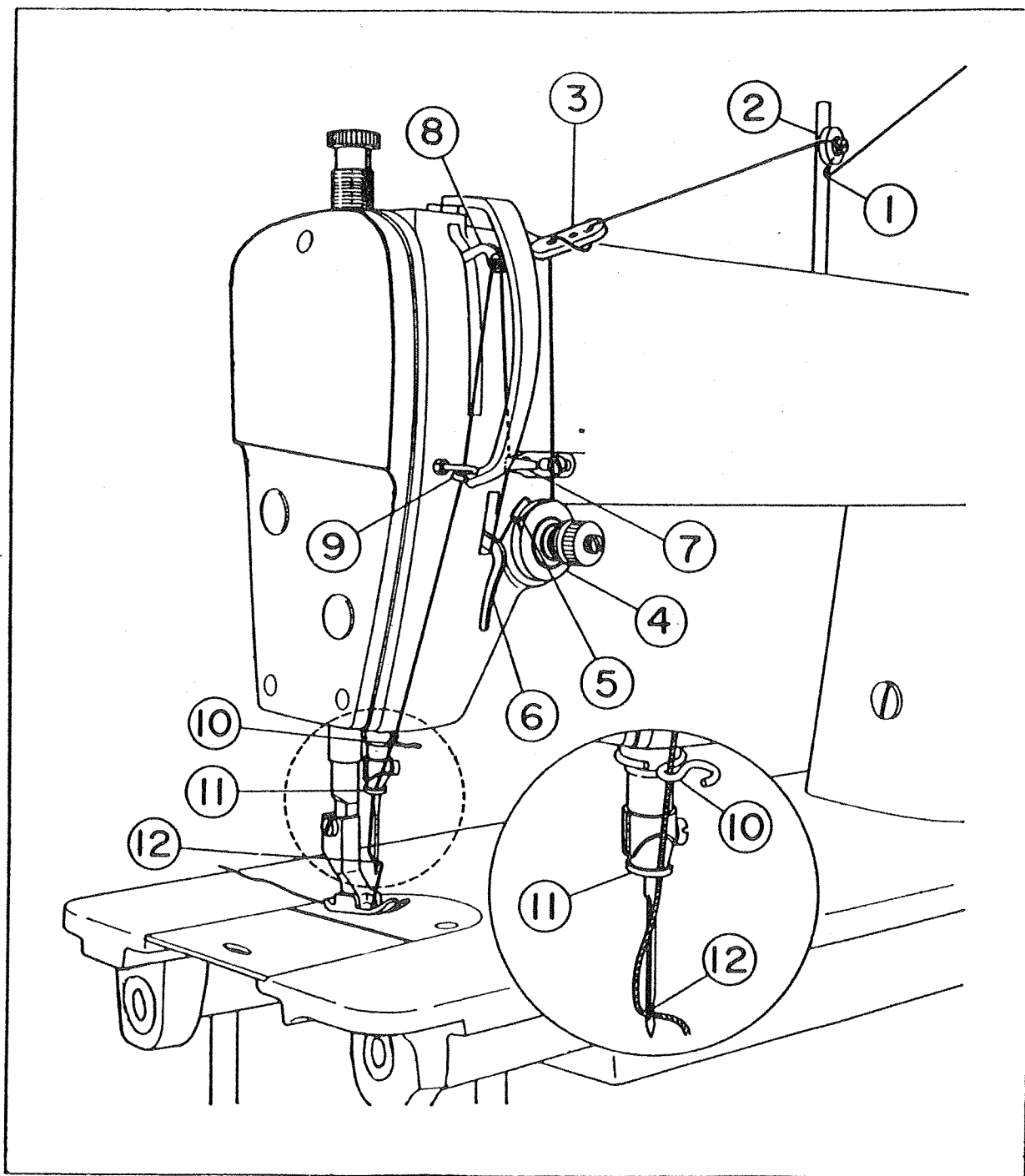
The oil supply to the hook components can be adjusted by the oil regulating valve on the hook shaft.

1. If this valve is turned toward $\oplus$ side (right), the oil amount gets more.
2. If this valve is tuned to $\ominus$ side (left), the amount gets less.

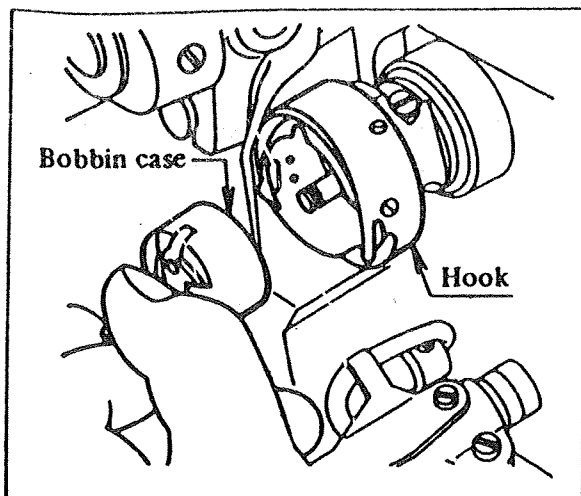
THREADING THE MACHINE

Rotate the handwheel to right and place the thread take-up to the highest position.

1. Pass the needle thread in the order shown by the figure.
2. Pass the thread to the needle eye from left to right.
3. Pull out about 10 cm (4") of the thread from the needle eye.

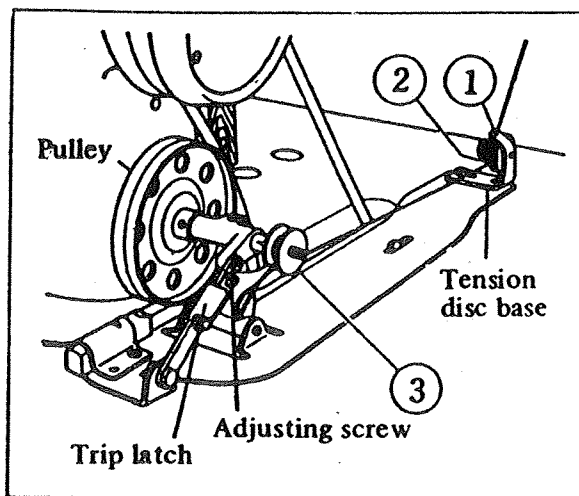


PREPARATION OF THE BOBBIN THREAD



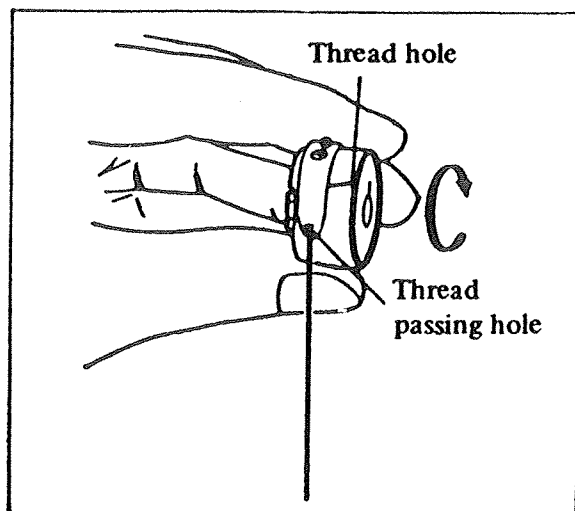
Inserting & removing the bobbin case

1. Rotate the hand wheel with your hand and bring the needle to its highest position.
2. Tilt the machine and support it by the head support on the table.
3. Lift up the knob of the bobbin case and take it out.
 - * If you hold the knob in open condition, bobbin will not fall off.
4. To insert the bobbin case, insert it deep into the shaft of the hook so that the nose of the bobbin case fully enters the groove of the hook and then close the knob.



Winding the bobbin thread

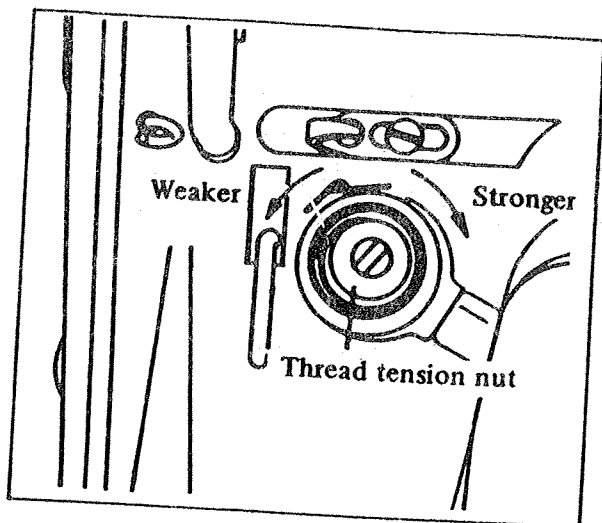
1. Set the bobbin winder to the table with screws.
2. Pass the thread in the order shown in the figure and wind it around the bobbin several times.
3. Knock down the trip latch and contact the pulley to the belt.
4. Adjust the winding amount by the winding adjusting screw so that about 80% is wound.
5. When the thread is wound unevenly, move the thread tension disc base to left and correct to even winding condition.
6. When the winding is completed, the trip latch will be released and the pulley will stop automatically.



How to insert the bobbin

1. Hold the bobbin and insert it to the bobbin case so that the thread will be in right-twist condition.
2. Pass the thread to the thread passing hole of the bobbin case.
3. Then pull the thread and it will pass under the thread tension spring and can be pulled out through the thread hole.
 - * When pulling the bobbin thread, rotate the bobbin in the arrow direction.

THREAD TENSION



Adjusting the needle thread tension

Ideal stitches are formed when the needle thread and the bobbin thread are perfectly interlocked at the center of the cloth. The tension of the needle thread is adjusted by the thread tension nut.

1. Turn it to right to make the tension stronger and to the left to make it weaker.

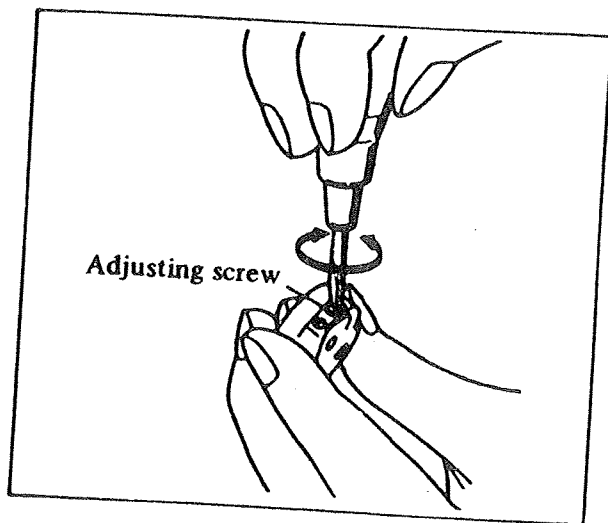
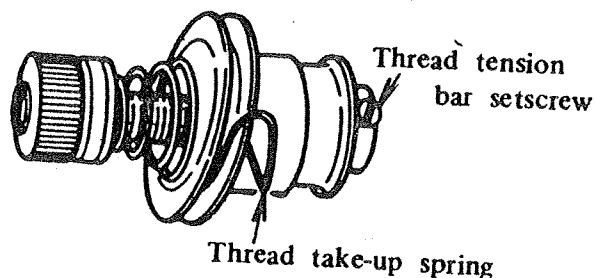
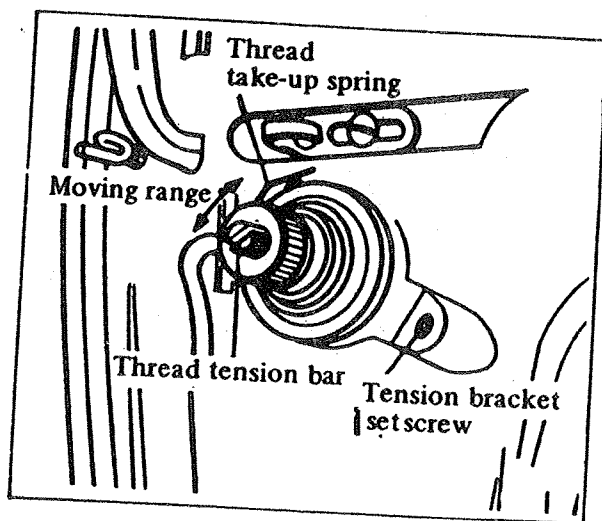
Thread take-up spring

* To change the moving range of the thread tension spring:

1. Loosen the screw of the thread tension bracket.
2. Rotate the thread tension bar.

* To change the strength of the thread take-up spring.

1. Loosen the setscrew, remove the thread tension bar.
2. Loosen the thread tension bar setscrew and adjust.
3. When the thread tension bar is turned to right, the spring will get stronger and if turned to left, it will get weaker.

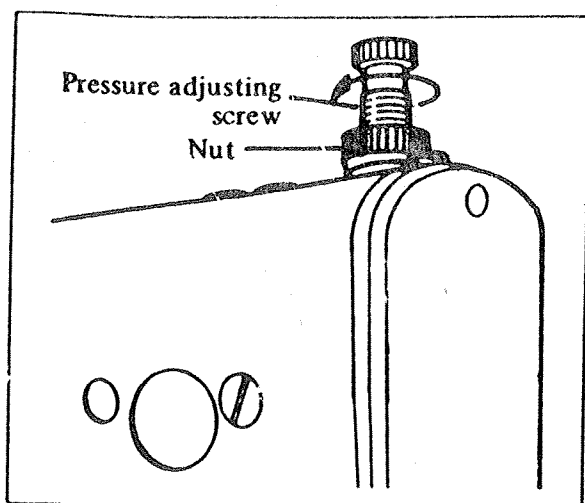


Adjusting the bobbin thread tension

Rotate the thread tension screw of the bobbin case to adjust the bobbin thread tension.

1. Rotate it to right to make the bobbin thread tension stronger and to left to make it weaker.

PRESSER FOOT AND FEED DOG

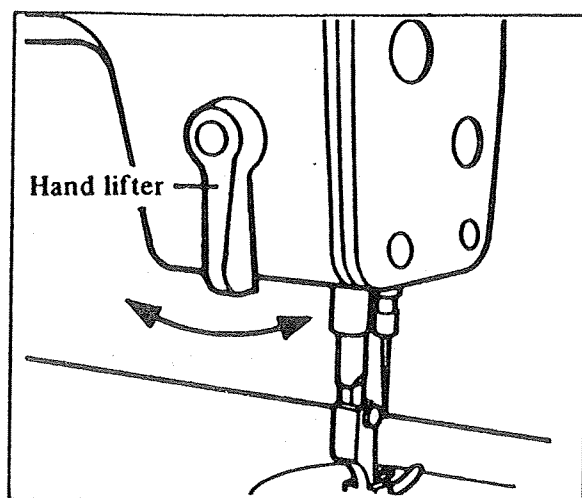


Adjusting the pressure of the presser foot

1. Turn the pressure adjusting screw to right to make the pressure stronger.
2. Turn this screw to left to make the pressure weaker.

Normal pressure for general fabric is about 5 kg (11 lbs).

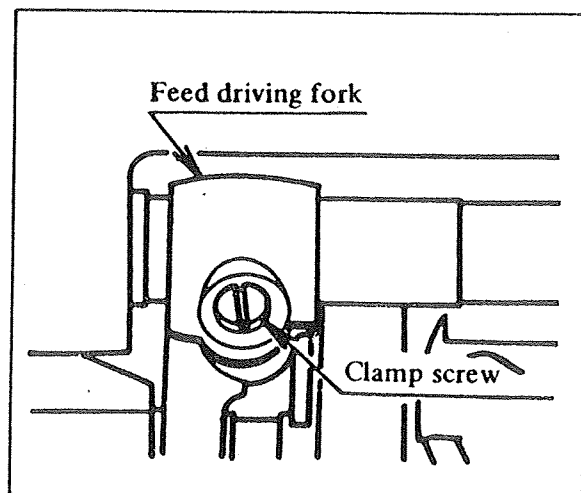
3. After adjustment, firmly tighten the nut.



The presser foot hand lifter

To stop the presser foot at the lifted position:

1. Rotate the hand lifter in the rear of the face part either to right or left.
2. The presser foot will go up about 5 mm (13/64") and stops.
3. To lower the presser foot, activate the knee lifter once and the presser foot will come down to the original position.
4. With the knee lifter, the presser foot will go up about 10 mm (25/64")

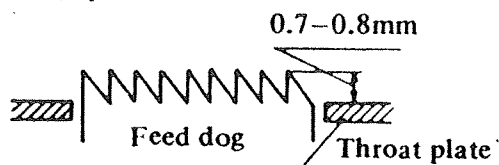


Height of the feed dog

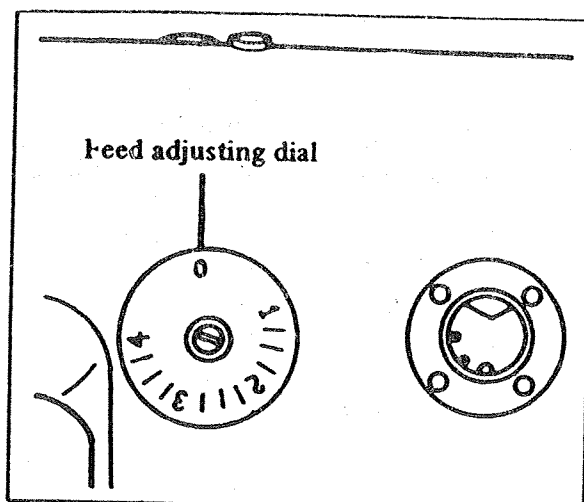
The height of the feed dog from the surface of the throat plate is set from 0.7–0.8mm (1/32"). In sewing light weight materials, if this height is too high, shrink-stitching may result.

To adjust the height of the feed dog:

1. Loosen the clamping screw of the feed driving fork of the compound feed.
2. Move the feed dog base up and down and adjust.
3. After adjusting, tightly tighten the clamping screw.



STITCH LENGTH



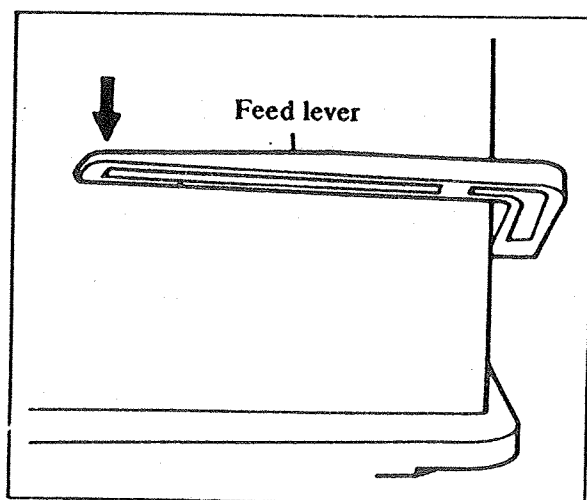
Adjusting the stitch length

The stitch length of this model can be adjusted by rotating the feed adjusting dial on top of the feed lever.

The figures on the graduation scale is shown in millimeter (mm).

1. Rotate the feed adjusting dial either to right or left and
2. Match the wanted figure with the pin coming out from the frame.

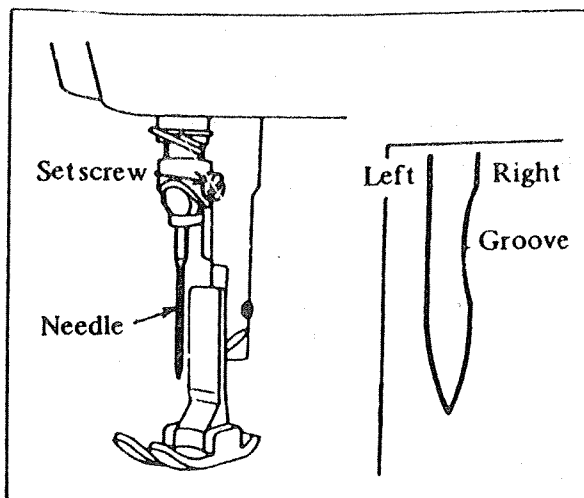
* The maximum stitch length is 4mm (5/32").



Reverse sewing

1. For reverse sewing, push the feed lever down.
2. As long as this lever is kept down, reverse sewing can be performed.
3. Release this lever and the feed lever will return to original position and normal straight stitching can be resumed.

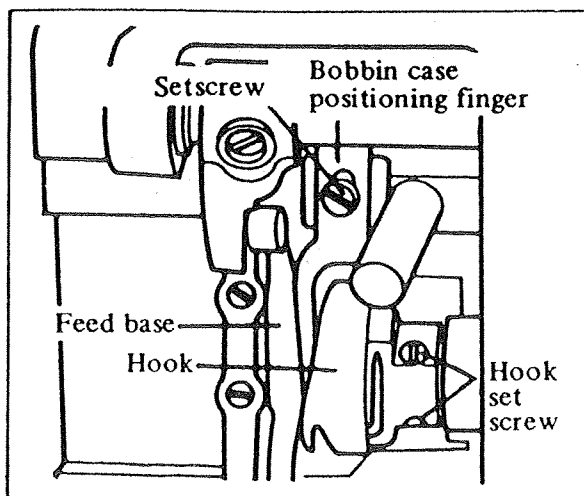
INSERTING THE NEEDLE



There are many size numbers of needles but size numbers depend on the thickness of the using thread or the kinds of sewing cloth. So, select a correct size and number for your work.

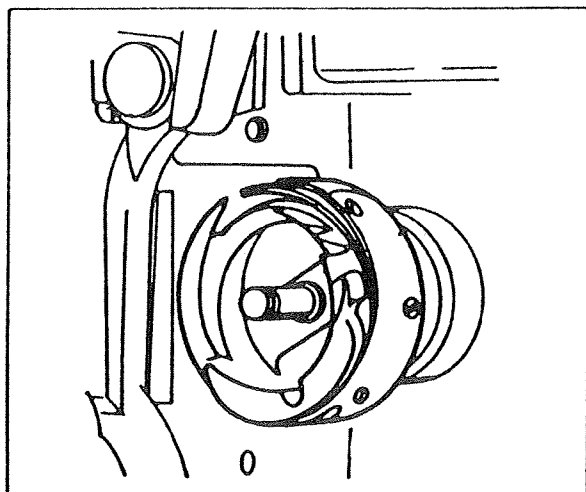
1. Rotate the hand wheel and bring the needle bar to the highest position.
2. Loosen the needle clamp screw.
3. Hold the needle so that the long groove of the needle comes to your right side.
4. Insert the needle deep into the needle hole.
5. Then securely tighten the needle clamp screw.

INSTALLING AND REMOVING THE SEWING HOOK

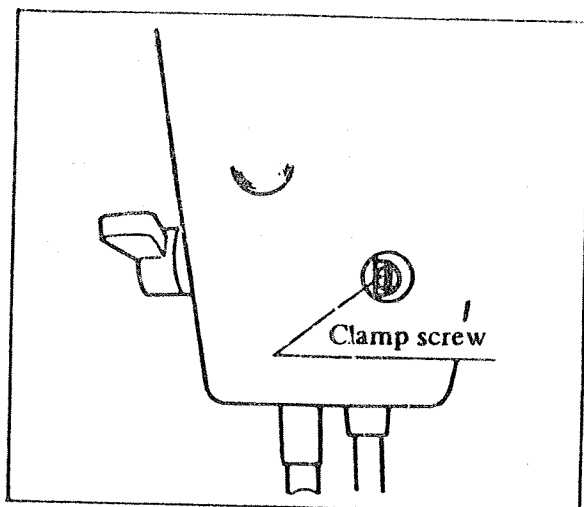


During the running of the machine, if thread hards get into the hook or the position of the hook changes for some reason or to exchange the hook with a new one, do as follows in order:

1. Rotate the hand wheel and bring the needle bar to the highest position.
 2. Remove the bobbin case and the needle.
 3. Remove the bobbin case base positioning finger setscrew and take out the bobbin case positioning finger.
 4. Loosen the 3 screws of the sewing hook.
 5. Rotate the hand wheel and raise up the feed base to its highest position.
 6. Rotate the sewing hook with your hand and place it in the position as shown in the figure.
 7. Pull the hook to your left and take it out.
- * To install the hook back, reverse this procedure.



RELATION BETWEEN THE HOOK AND THE NEEDLE

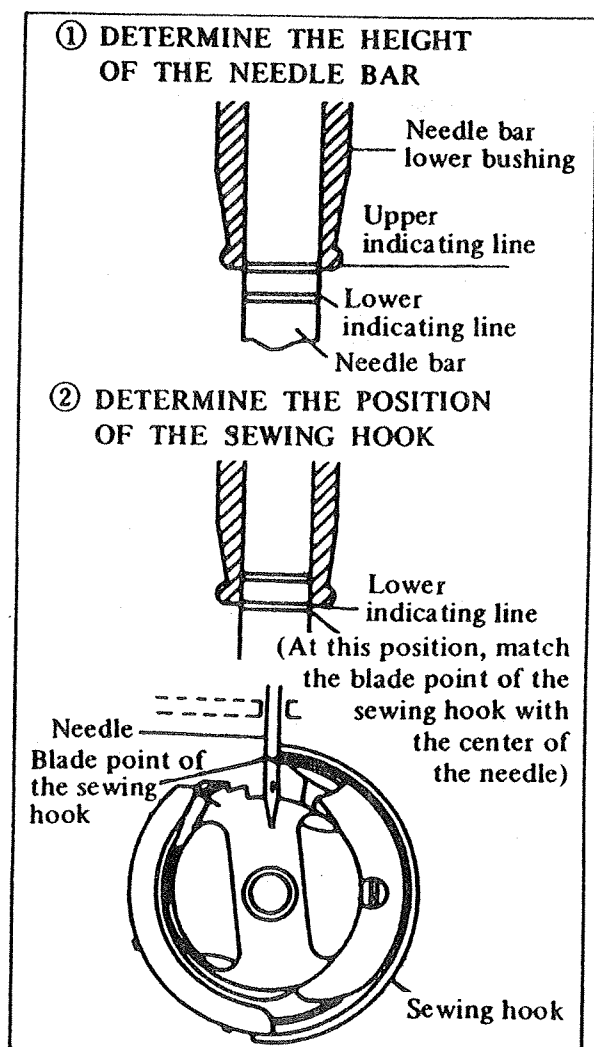


Match the needle with the sewing hook as follows:

1. Rotate the hand wheel and bring the needle bar to its lowest position.
2. Loosen the needle bar clamping setscrew.

(Note)

When matching the timing of the needle and the sewing hook, be sure to set the feed adjusting dial to "0".



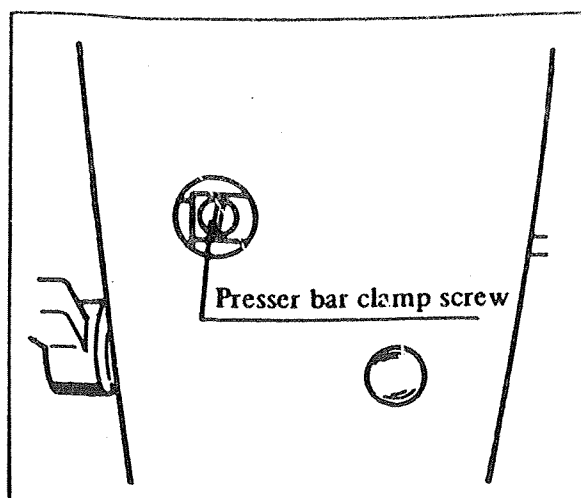
(Determine the height of the needle bar)

3. Match the upper carved line of the needle bar with the lower edge of the needle bar lower bushing.
4. Tighten the needle bar clamping setscrew.

(Determine the position of the sewing hook)

5. Loosen the 3 clamping screws of the hook so that the hook can be rotated freely with the hand.
6. Place the hook with your hand to the thread passing position.
7. Rotate the hand wheel and match the lower carved line of the needle bar with the lower edge of the needle bar lower bushing.
8. In this condition, match the blade point of the hook with the center line of the needle.
9. Make the clearance between the needle and the hook blade point to 0.05 mm and
10. Securely tighten the hook clamping set-screw.

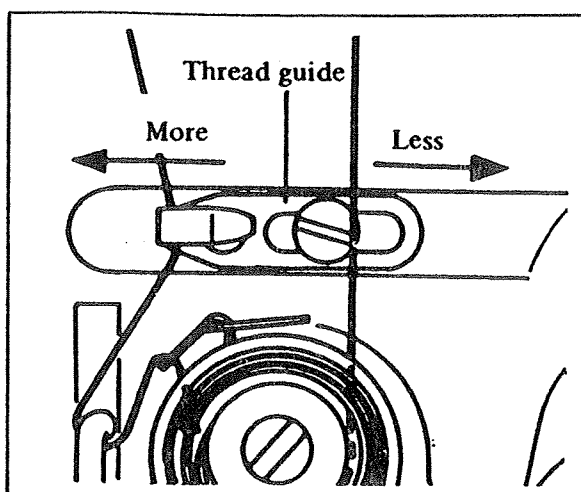
ADJUSTING THE HEIGHT OF THE PRESSER BAR



When the height or the direction of the presser bar is to be changed due to the exchange of presser foot:

1. Remove the rubber plug of the face plate.
2. From this hole, adjust by loosening the presser bar clamping screw.
3. After the adjustment, securely tighten the setscrew.

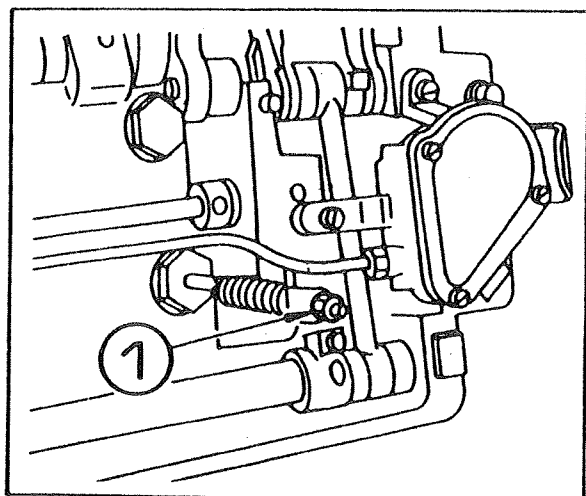
ADJUSTING THE STROKE OF THREAD TAKE-UP



The amount of the thread take-up should be changed according to the length of stitches or thickness of the sewing cloth to produce ideal thread tension.

1. When sewing heavy weight materials, move the thread guide to your left.
The thread take-up amount of the take-up gets more.
2. When sewing light weight materials, move the thread guide to your right.
The thread take-up amount gets less.

ADJUSTING THE PRESSING PRESSURE OF THE FEED LEVER



The reversing spring of the feed lever is strengthened somewhat so that at high speed sewing, no matter what kind of stitches are to be formed, the lever returns positively to the original position.

When the stitching pitch is small or when the machine is to be run by lowering the r.p.m., the pressing pressure of the feed lever can be lessened by loosening the adjusting nut ① of the accompanying figure.

HOW TO MAKE USE OF THIS PARTS LIST

1. As a basic principle, this parts list is divided into various sections according to the functions of respective parts.
2. The part numbers of parts shown in the figure indicate the corresponding numbers(Ref.No.) shown by the Index.
3. Explanation of codes

1) 1 ☆ mark means this part is changed from the previous parts list.

2) 001, 002 refer to "Note" explanation at bottom of page.

2) Codes on the "E.C. (Engineering change)" column

1 A. 10/74 Added from October, 1974

2 D. 1/75 Obsoleted from January, 1975

3 When D. (obsoleted) and A. (added) are indicated together

D. 12/74)

A. 12/74)

When previous parts (Obsoleted part) and new parts (Added parts) are not interchangeable with each other:

In this case, even obsoleted parts(D.) can be ordered with the obsoleted part number, so select the parts with changed dates and place your orders.

(Example)

Ref. No.	Note	Part No.	Description	E.C.	Amt. Req.
1	☆	B1401-100-000	Needle bar	D. 12/74	
1-1	☆	B1401-100-000-A	Needle bar	A. 12/74	1

4) M.5/75 The amount required is changed from March, 1975

The new amount required is shown in the "Amt. Req." column.

3) Codes on the "Amt. Req." column

1 2 Indicates amount required is 2.

2 2.0 Indicates length in meters. (unit is meter)

3 - Indicates parts obsoleted from the parts list.

4 (1) Indicates sub parts which construct the assembly part.

Assembly part is shown as "asm. in the "Description" column.

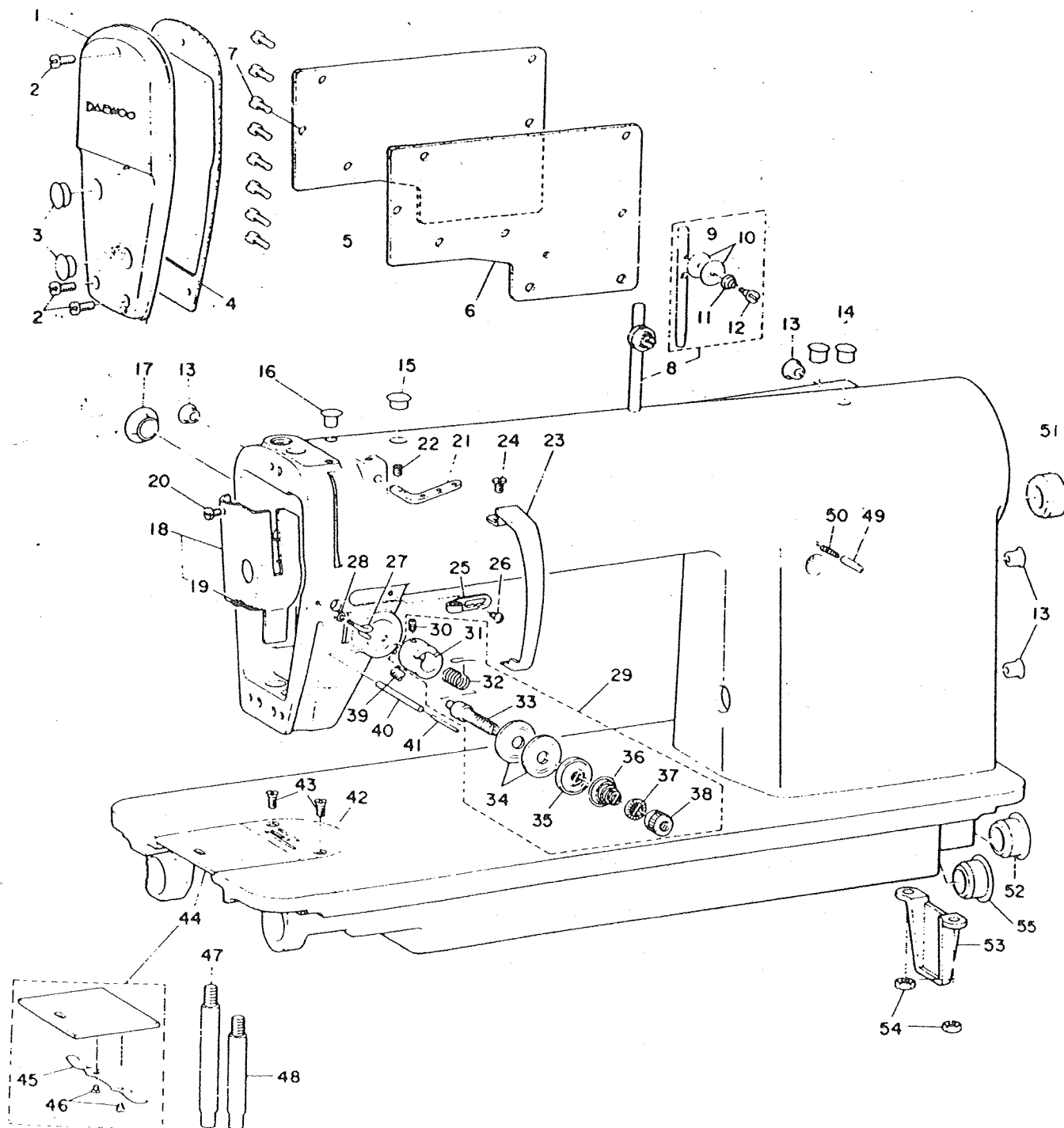
(Example)

Ref. No.	Note	Part No.	Description	E.C.	Amt. Req.
10		B1105-900-0A0	Frame cover asm.		1
11		B1105-900-000	Frame cover		(1)
12		SS-8110310-SP	Screw 11/64 40 L=2.8		(2)

CONTENTS

1. FRAME & MISCELLANEOUS COVER COMPONENTS.....	1
2. MAIN SHAFT & UPRIGHT SHAFT & NEEDLE BAR COMPONENTS	3
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8. EXCLUSIVE PARTS FOR SUBCLASS COMPONENTS	13
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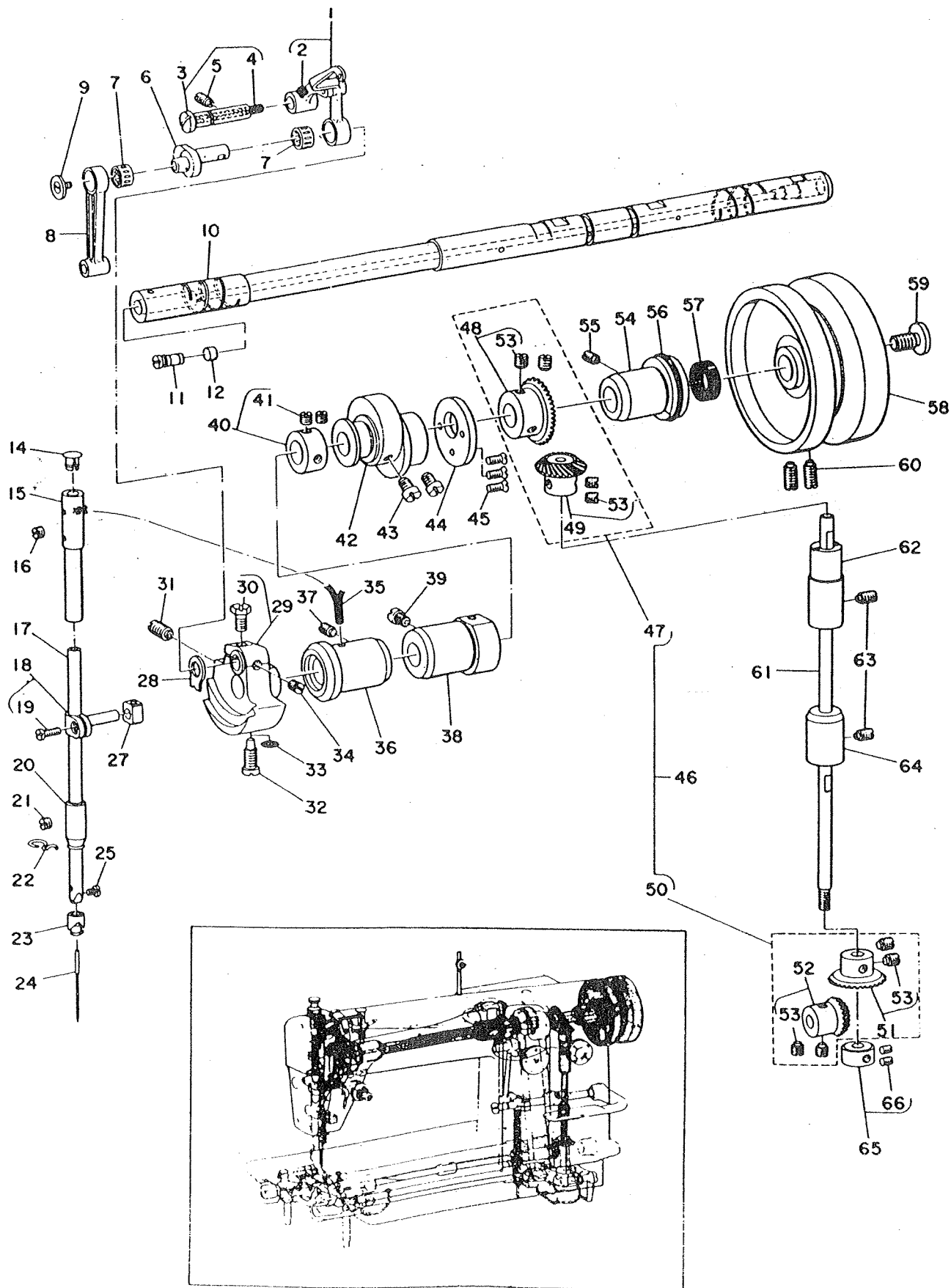
1. FRAME & MISCELLANEOUS COVER COMPONENTS



1. FRAME & MISCELLANEOUS COVER COMPONENTS

Ref. No.	Part No.	Description	E.C.	Amt. Req.
1	B1121-945-0A0	Face plate asm.		1
2	SS-7111120SP	Screw 11/64-40 L=10.5		1
3	B1179-552-000	Rubber plug		3
4	B1122-945-000	Gasket		2
5	B1118-945-000	Side plate		1
6	B1119-522-000	Gasket		1
7	SS-7110910-SP	Screw 11/64-40 L=8.5		1
8	B1113-155-0A0	Needle thread guide pin asm.		8
9	B1113-155-000	Needle thread guide pin		1
10	B3148-123-000	Tension disc		(1)
11	B3149-123-A00	Spring		(2)
12	SD-0380552-SL	Stud D=3.8 H=5.5		(1)
13	B1117-552-000	Rubber plug		(1)
14	B1186-552-000	Rubber plug		4
15	B1187-552-000	Rubber plug		2
16	B1117-552-000	Rubber plug		1
17	B1164-012-000	Counterweight screw hole plug		1
18	B1188-552-0A0	Arm oil shield asm.		1
19	CQ-2020000-00	Oil wick		1
20	SS-6080410-SP	Screw 11/64-40 L=5		(0.1)
21	B1128-552-000	Three-hole thread eyelet		1
22	SS-8110510-SP	Screw 11/64-40 L=5.0		1
23	B1123-552-000-A	Thread take-up lever cover		1
24	SS-7110510-SP	Screw 11/64-40 L=5.0		1
25	B1126-552-000	Frame thread guide (A)		1
26	SS-5090610-SP	Screw 9/64-40 L=3.5		1
27	B3114-761-000	Frame thread guide (B)		1
28	NS-6060350-SP	Nut 3/32-56		1
29	B3111-552-0A0	Thread tension asm		1
30	SS-8090670-6P	Screw 9/64-40 L=5.5		1
31	B3111-552-B00	Thread tension post socket		(1)
32	B3128-012-000	Take-up spring		(1)
33	B3115-552-000	Thread tension post		(1)
34	B3126-012-000	Thread tension disc		(1)
35	B3132-552-000	Presser		(2)
36	B3129-012-A00	Thread tension spring		(1)
37	B3120-125-000	Thread disc rotation stopper		(1)
38	B3116-125-000	Thread tension nut		(1)
39	SS-8150710-SP	Clamp screw 15/64-28 L=7.0		(1)
40	B3127-127-000	Tension release auxiliary pin		1
41	B3118-552-C00	Tension release pin		1
42	B1109-012-A00	Throat plate (A)		1
43	SS-2110920-TP	Screw 11/64-40 L=8.5		1
44	B1110-012-0A0	Bed slide asm.		2
45	B1111-012-000	Spring		1
46	SS-6060210-SP	Screw 3/32-56 L=1.9		(1)
47	B1104-122-000	Bed screw stud (A)		(2)
48	B1105-122-000	Bed screw stud (B)		1
49	B1147-555-000	Feed regulator pin		1
50	B1148-555-000	Spring		1
51	B1189-415-000	Rubber plug		1
52	B1166-552-000-A	Hook shaft rubber plug		1
53	B1106-122-000	Bed support		1
54	NS-6150310-SP	Nut 15/64-28		1
55	B1166-552-000-A	Rubber plug		2
				1

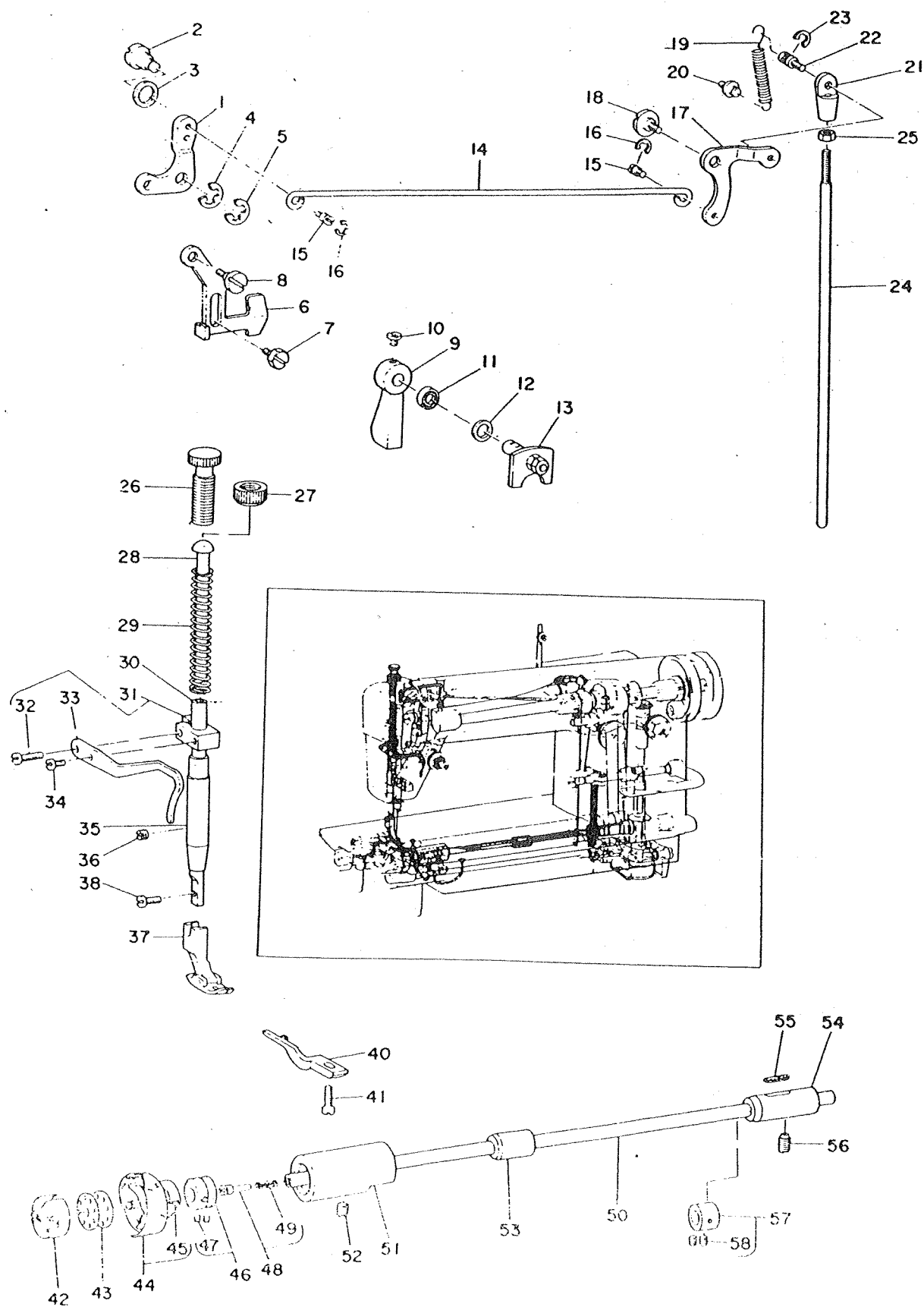
2. MAIN SHAFT & UPRIGHT SHAFT & NEEDLE BAR COMPONENTS



2. MAIN SHAFT & UPRIGHT SHAFT & NEEDLE BAR COMPONENTS

Ref. No.	Part No.	Description	E.C.	Amt. Req.
1	B1901-552-0C0	Thread take-up lever asm.		1
2	CQ-2000000-00	Oil wick		(0.1)
3	B1904-552-0A0	Thread take-up crank shaft stud asm.		1
4	CQ-2020000-00	Oil wick		(0.2)
5	SS8151150-SP	Screw 15/64-28 L=10.5		1
6	B1209-552-000	Needle crank		1
7	B1905-541-B00	Needle shaft bushing		2
8	B1408-552-000	Needle bar crank rod		1
9	B1903-552-000	Thread take-up crank screw, left		1
10	B1201-555-000	Main shaft		1
11	B1213-552-0A0	Crank oil adjusting pin asm.		1
12	B1226-552-000	Oil regulating felt		1
13				
14	B1405-012-000	Rubber plug		1
15	B1402-552-000-A	Needle bar bushing, upper		1
16	SS-8150310-SP	Screw 15/64-28 L=3.4		11
17	B1401-552-A00	Needle bar (A)		1
18	B1411-552-0A0	Needle bar connection asm.		1
19	SS-6090670-TP	Clamp screw 9/64-40 L=6.0		(1)
20	B1403-155-000	Needle bar bushing, lower		1
21	SS-8150310-SP	Screw 15/64-28 L=3.4		1
22	B1419-155-000	Needle bar thread guide		1
23	B1418-541-000	Needle bar thread guide		1
24	MDB-100B1400	Needle (DBx1, #14)		1
25	SS-7080510-SP	Screw 1/8-44 L=4.5		1
27	B1414-232-000	Needle bar guide block		1
28	B1212-552-A00	Counterweight wearing plate (A)		1
29	B1206-552-0A0	Counterweight asm.		1
30	SS-9661120-CP	Clamp screw 1/4-40 L=10.5		(1)
31	SS-8681950-SP	Screw (B) 9/32-28 L=19.0		1
32	SS-7681650-TP	Screw (A) 9/32-28 L=19.0		1
33	RO-0442401-00	Rubber ring		1
34	SS-8660610-TP	Screw 1/4-40 L=6.0		1
35	CQ-2020000-00	Oil wick		0.3
36	B1202-552-B00A	Main shaft bushing, front		1
37	SS-8151150-SP	Screw 15/64-28 L=10.5		1
38	B1203-227-000	Main shaft bushing, intermediate		1
39	SS-7151120-SP	Screw 15/64-28 L=11.0		1
40	CS-147121A-SH	Main shaft thrust collar asm.		1
41	SS-8660610-TP	Screw 1/4-40 L=6.0		(2)
42	B1610-555-000	Feed drive eccentric cam		1
43	SS-666110-SP	Screw 1/4-40 L=11.0		2
44	B1611-161-000	Feed eccentric thrust washer		1
45	SS-2110930-SP	Screw 11/64-40 L=8.7		3
46	B1306-155-0C0	Gear & pinion asm.		1
47	B1306-155-0B0	Gear & pinion asm., upper		(1)
48	B1305-012-0A0	Gear asm.		(1)
49	B1306-155-0A0	Pinion asm.		(1)
50	B1307-155-0B0	Gear & pinion asm., lower		(1)
51	B1307-155-0A0	Gear asm.		(1)
52	B1308-155-0A0	Pinion asm.		(1)
53	SS-8660810-TP	Screw 1/4-40 L=8.0		(8)
54	B1204-552-B00	Main shaft bushing, rear		1
55	SS-8151150-SP	Screw 15/64-28 L=10.5		1
56	RO-2943101-00	Rubber ring		1
57	B1208-552-000-A	Oil seal ring		1
58	B1217-555-000	Hand wheel		1
59	B1233-012-000	End screw		1
60	SS-8151150-SP	Screw 15/64-28 L=15.0		2
61	B1301-552-000	Upright shaft		1
62	B1302-552-B00	Bushing, upper		1
63	SS-8151150-SP	Screw 15/64-28 L=10.5		2
64	B1303-552-B00	Bushing, lower		1
65	CS-0791010-SH	Thrust collar asm.		1
66	SS-8110520-TP	Screw 11/64-40 L=4.5		(2)

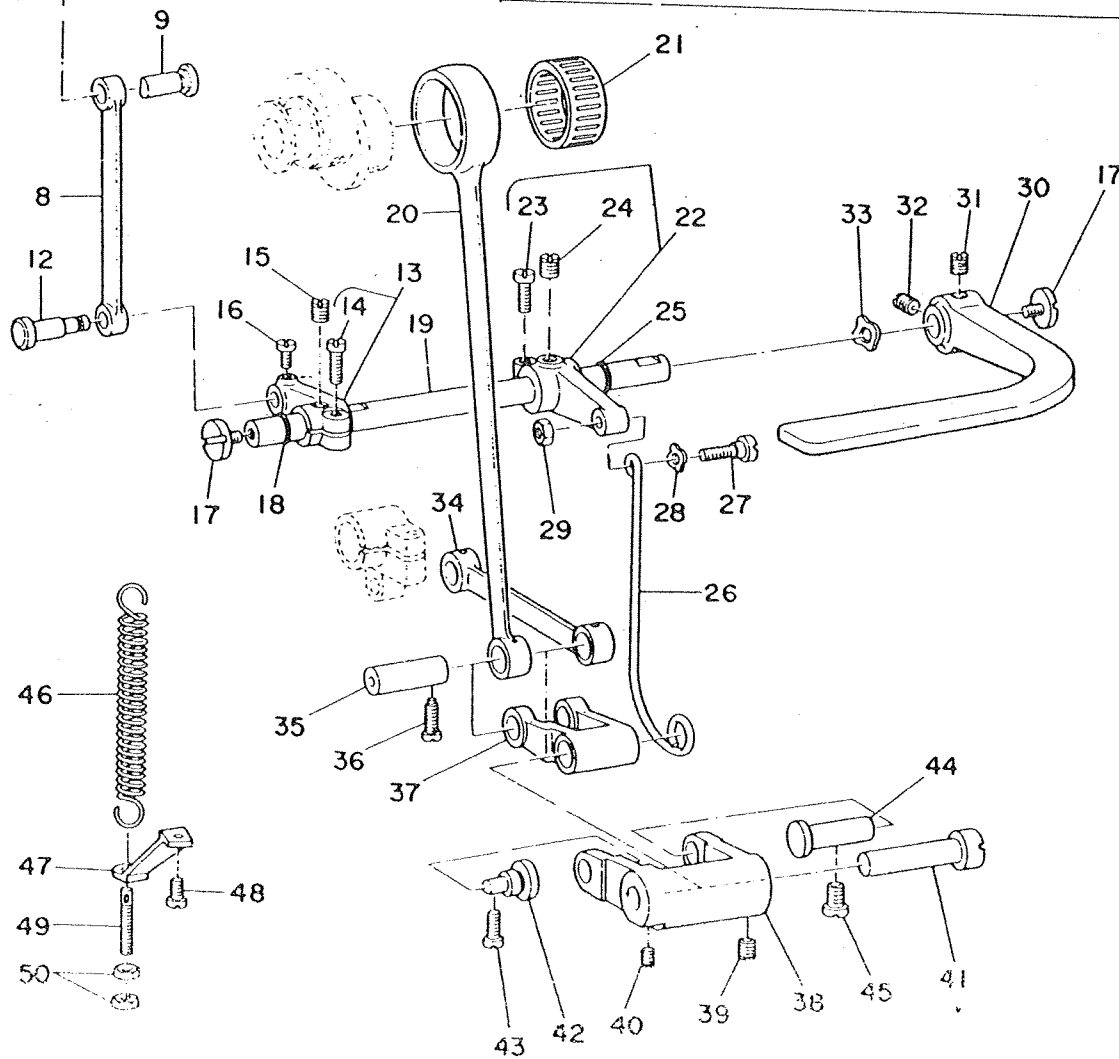
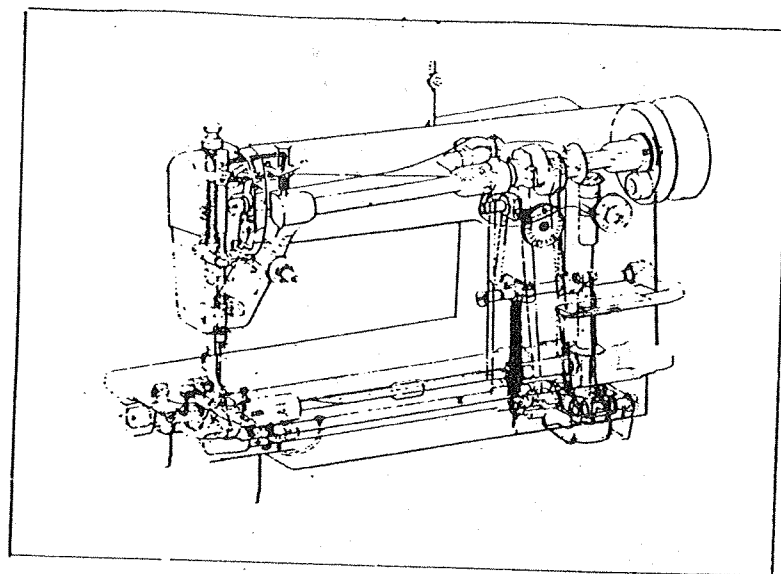
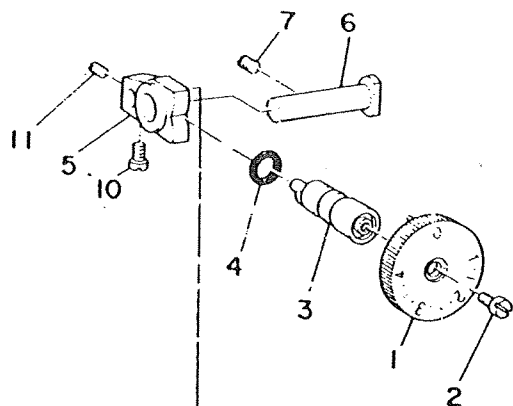
3. HOOK DRIVING SHAFT & PRESSER BAR & KNEE LIFTER COMPONENTS



3. HOOK DRIVING SHAFT & PRESSER BAR & KNEE LIFTER COMPONENTS

Ref. No.	Part. No.	Description	E.C.	Amt. Req.
1	B1516-552-000	Lifting lever link		1
2	B1517-552-000	Shaft		1
3	B3431-581-000	Gasket		1
4	RE-0600000-KO	Snap ring		1
5	B1523-226-000	Snap ring (B)		1
6	B1515-552-000	Lifting lever		1
7	SD-0630275-SP	Hinge screw (A) D=6.35 H=2.7		1
8	SD-0630301-SP	Hinge screw (B) D=6.35 H=3.0		1
9	B1520-552-000	Hand lifter lever		1
10	SS-7120910-SP	Screw 3/16-28 L=9.0		1
11	B1522-552-00	Oil seal		1
12	WP-0740516-SP	Washer 7.4 x 11.2 x 0.5		1
13	B1518-522-0A0	Hand lifter cam asm.		1
14	B3412-522-000	Lifting lever connecting rod		1
15	B3416-552-000	Hinge screw		2
16	RE-0500000-KO	Spring		2
17	B3414-552-000	Lifting lever link arm		1
18	SD-0720331-SP	Hinge screw D=7.24 H=3.3		1
19	B3417-552-000	Spring		1
20	B3415-227-000	Suspension screw		1
21	B3416-012-000	Swivel		1
22	B3418-552-000	Screw		1
23	RE-0500000-KO	Snapring		1
24	B3415-552-000	Connecting rod, vertical		1
25	NS-6620310-SP	Nut 3/16-32		1
26	B1509-227-000	Presser spring regulator		1
27	NS-2820850-SA	Nut 1/2-28		1
28	B1510-227-000	Presser guide bar		1
29	B1505-227-000-A	Presser spring		1
30	B1501-127-000	Presser bar		1
31	B1507-552-000	Presser bar guide bracket asm.		1
32	SS-7111410-SP	Clamp screw 11/64-40 L=14.0		(1)
33	B1521-552-000	Presser bar clamp thread guide		1
34	SS-6090650-SP	Screw 9/64-40 L=6.0		1
35	B1502-541-000	Presser bar bushing, lower		1
36	SS-8150310-SP	Screw 15/64-28 L=3.4		1
37	B1524-012-0A0	Hinged presser foot asm.		1
38	SS-7091110-SP	Screw 9/64-40 L=10.5		1
40	B-1835-012-000	Bobbin case holder positioning finger		1
41	SS-6111010-SP	Screw 11/64-40 L=9.5		1
42	B1837-012-0A0	Bobbin case asm.		1
43	B9117-012-000	Bobbin		1
44	B1830-127-0A0	Lubricating hook asm.		1
45	SS-6110560-TP	Screw		(2)
46	CS-079106A-SH	Thrust collar asm.		1
47	SS-8110410-TP	Screw 11/64-40 L=3.5		(2)
48	B1808-552-0A0	Hook driving shaft front screw asm.		1
49	B1810-552-000	Oil wick asm.	D.7/75	1
	B1810-552-000	Oil wick	A.7/75	1
50	B1801-412-000	Hook driving shaft		(1)
51	B1802-412-0A0	Bushing, front asm.		1
52	SS-8151150-SP	Screw 15/64-28 L=10.5		1
53	B1803-552-000	Bushing, intermediate		1
54	B1806-038-000	Bushing, rear		1
55	B1906-038-000	Oil felt		1
56	SS-8151550-SP	Screw 15/64-28 L=15.0		1
57	CS-0791010-SH	Hook driving shaft thrust collar (B) asm.		1
58	SS-8110520-TP	Screw 11/64-40 L=4.5		(2)

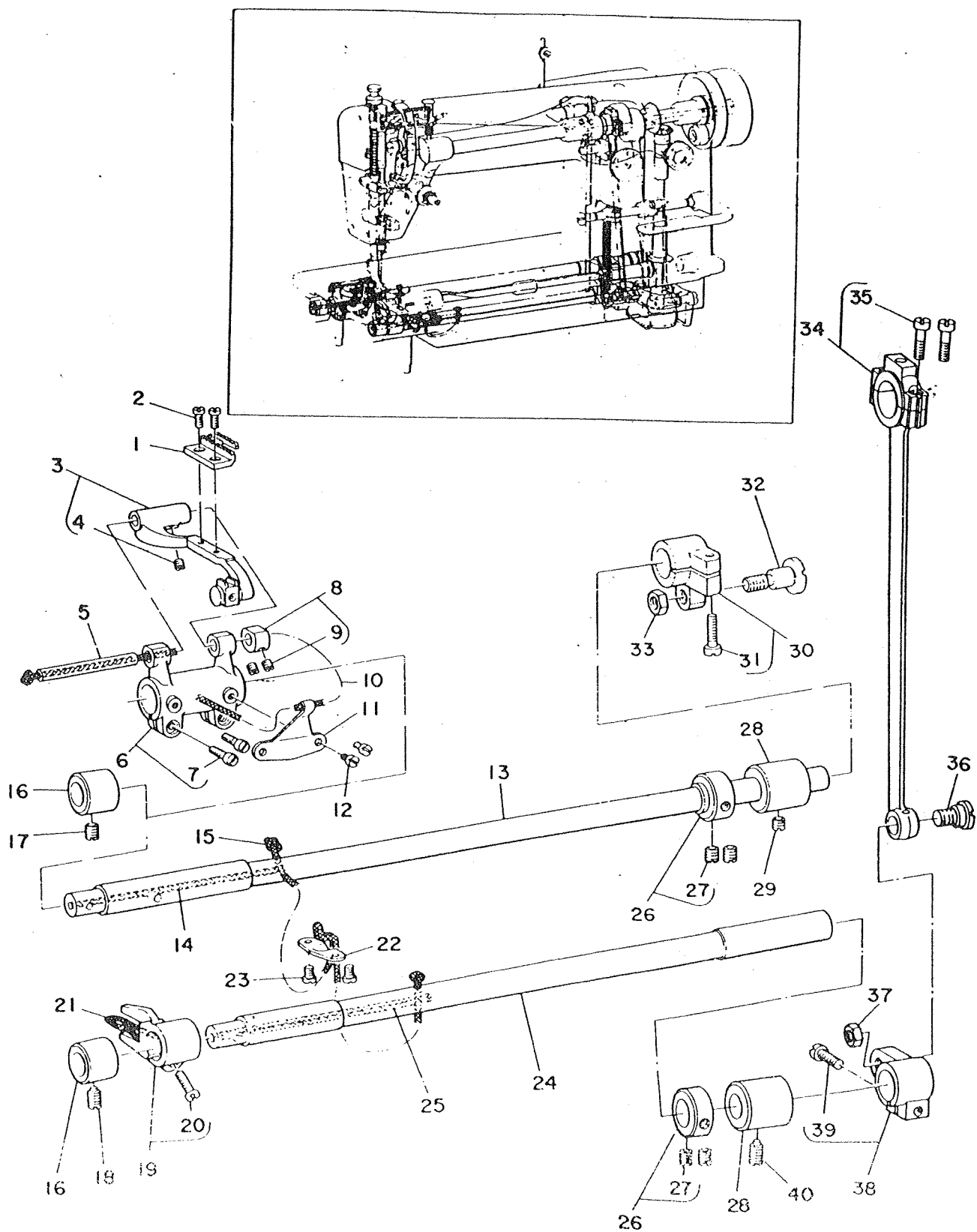
4. FEED MECHANISM COMPONENTS (1)



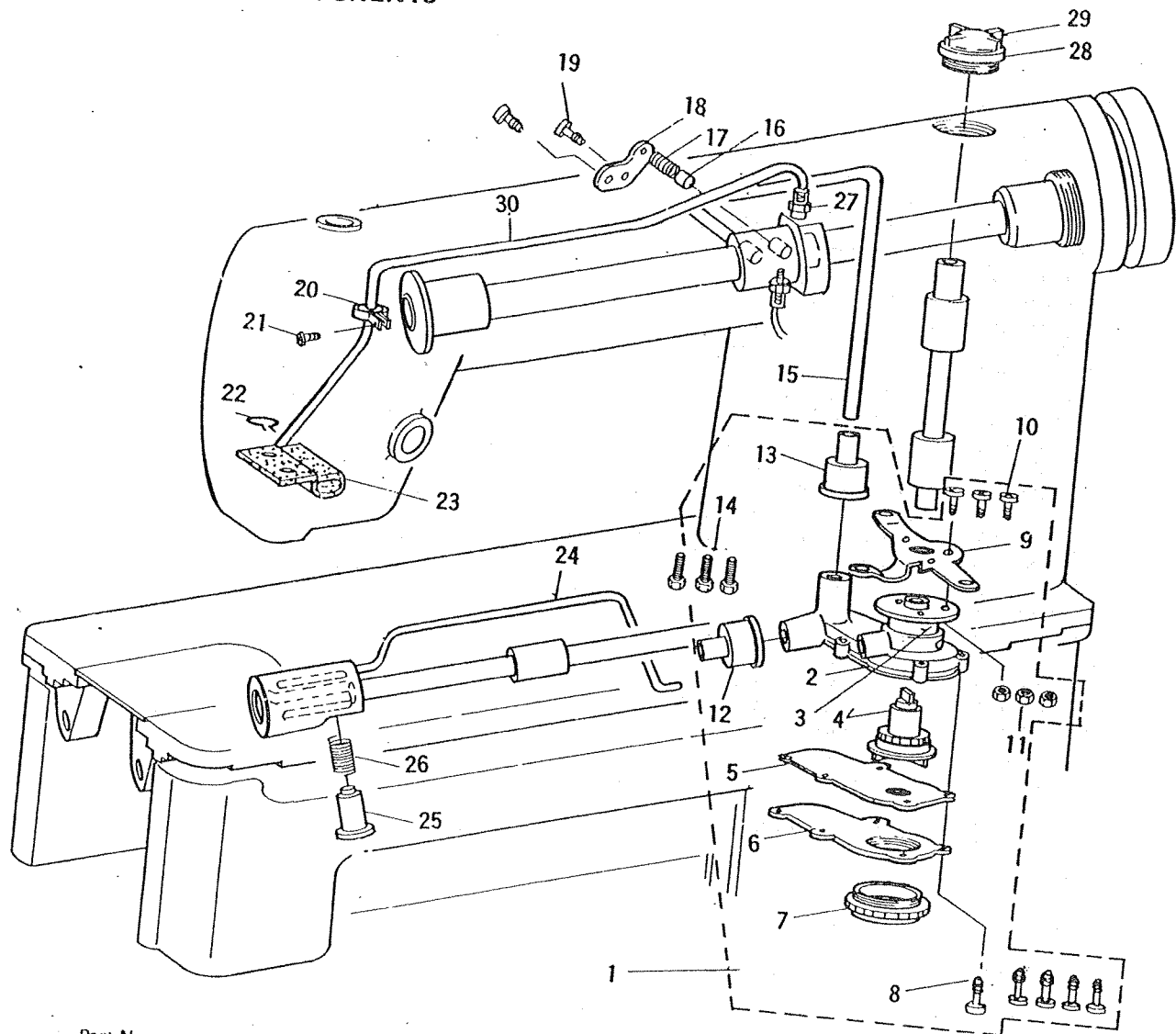
4. FEED MECHANISM COMPONENTS (1)

Ref. No.	Part. No.	Description	E.C.	Amt. R Req.
1	B1623-555-0A0-A	Stitch dial asm.		1
2	SS-6121050-SP	... Screw 3/16-28 L=9.5		1
3	B1634-555-000-A	Feed regulating screw	D.6/67	1
3-1	B1634-555-000-B	Feed regulating screw	A.6/67	1
4	RO-0742401-00	... Rubber ring		1
5	B1620-161-000	Feed regulator		1
6	B1622-555-000	... Hinge pin		1
7	SS-8151230-SP	... Screw 15/64-28 L=12.0		1
8	B1625-555-000	Feed regulator connecting rod		1
9	B1626-555-000	... Pin		1
10	SS-7110720-SP	... Screw (A) 11/64-40 L=7.0		1
11	SS-8110510-SP	... Screw (B) 11/64-40 L=5.0		1
12	B1628-555-000	Tension spring suspension stud		1
13	B1627-555-0A0	Tension spring suspension crank asm.		1
14	SS-6121210-SP	... Clamp screw 3/16-28 L=12.0		1
15	SS-8150710-SP	... Screw 15/64-28 L=7.0		(1)
16	SS-7110910-SP	Screw, 11/64-40 L=8.5		1
17	SS-7020750-SP	End screw 3/16-32 L=6.5		1
18	RO-0611801-00	Rubber ring, small		2
19	B1621-555-000	Reverse feed control lever shaft		1
20	B1612-161-000	Feed rocker shaft connecting rod		1
21	B1636-581-B00	... Needle bearing		1
22	B1629-555-0A0	Control lever crank, rear asm.		1
23	SS-6121210-SP	... Clamp screw 3/16-28 L=12.0		1
24	SS-8150710-SP	... Screw 15/64-28 L=7.0		(1)
25	RO-0691801-00	Rubber ring, large		1
26	B1630-555-000	Feed driving rocker arm connecting rod		1
27	SD-05000401-KP	... Hinge screw D=5.0 H=4.0		1
28	WZ-0541510-KP	... Washer 5.4 x 9.0 x 0.3		1
29	NS-6120310-SP	... Nut 3/16-28		1
30	B1624-555-000	Reverse feed control lever		1
31	SS-8660970-TP	... Screw (A) 1/4-40 L=8.5		1
32	SS-8660810-TP	... Screw (b) 1/4-40 L=8.0		1
33	WZ-1052010-KP	... Waved washer 10.5 x 14.5 x 0.3		1
34	B1613-555-000	Connecting rod		1
35	B1633-555-000	Feed rocker shaft connecting pin		1
36	SS-7111260-SP	... Screw 11/64-40 L=12.0		1
37	B1614-555-000	Feed driving rocker arm		1
38	B1617-555-000	Feed driving rocker		1
39	SS-8150710-SP	... Screw (A) 15/64-28 L=7.0		1
40	SS-8620610-SP	... Screw (B) 3/16-32 L=6.0		1
41	B1615-555-000	... Hinge pin		1
42	B1619-555-000	... Hinge stud		1
43	SS-7111120-SP	... Screw 11/64-40 L=10.5		1
44	B1618-161-000	Feed driving rocker arm hinge pin		1
45	SS-7151120-SP	... Screw 15/64-28 L=11.0		1
46	B1646-555-000	Tension spring		1
47	B1632-555-000	... Suspension bracket		1
48	SS-7111120-SP	... Screw 11/64-40 L=10.5		1
49	B1649-161-000	... Adjusting screw		1
50	NS-6110420-SP	... Nut 11/64-40		1
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5. FEED MECHANISM COMPONENTS (2)



6. OIL LUBRICATION COMPONENTS

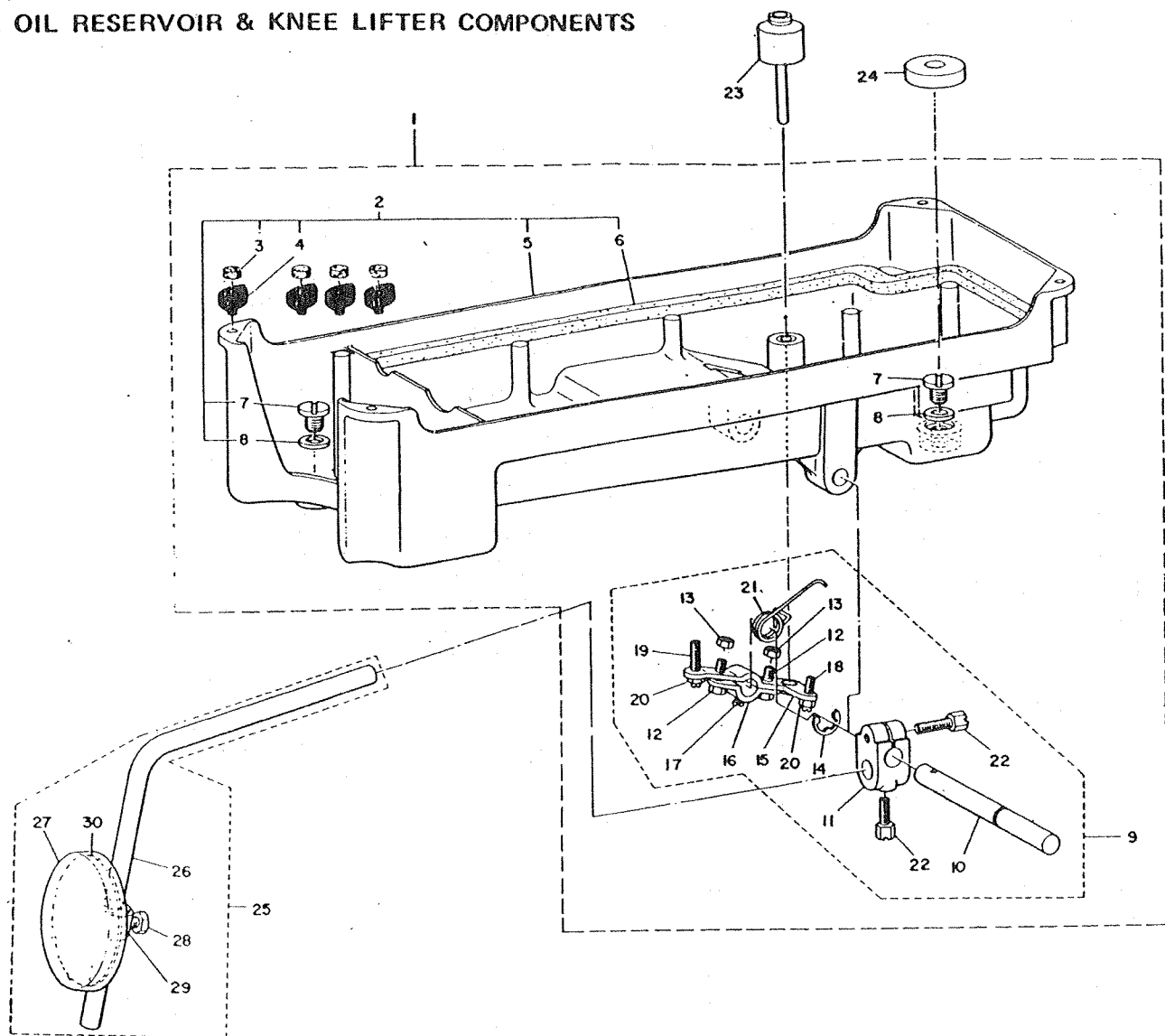


Ref. No.	Part No.	Description	Amt. Req.
1	B3501-557-0A0	Oil pump asm.	
2	B3501-557-000	Oil pump	1
3	B3512-557-000	Impeller bush	(1)
4	B3505-557-000	Impeller	(1)
5	B3502-557-000	Cover	(1)
6	B3503-557-000	Screen holder	(1)
7	B3504-557-000	Screen	(1)
8	SK-3030101-SE	... Screw M3 x P1.06	(1)
9	B3506-557-000	Bracket	(5)
10	SM-7030101-SE	... Screw M3 x P0.5	(1)
11	NM-6032400-CR	... Nut M3 x P0.5	(3)
12	B3508-557-000	Oil tube joint	(3)
13	B3507-557-000	Oil tube joint	(1)
14	SS-4120900-SP	... Screw 3/16" n=28 L=9.0	(1)
15	B3509-557-000	Main shaft oil tube	(3)
16	B3534-155-000	Pump plunger	1
17	B1214-038-000	Spring	1
18	B3524-552-000	Plunger thrust plate	1
19	SS-7110910-SP	... Screw 11/64" n=40 L=8.5	1
20	B3536-122-000	Return tube pipe	2
21	SS-7110710-SP	... Screw 11/64" n=40 L=7.0	1
22	B3529-226-000	Presser	1
23	B3526-552-0A0	Felt asm	1
24	B3510-557-000	Hook oil tube	1
25	B3514-412-000	Oil adjusting screw	1
26	B2616-372-000	Spring	1
27	SQ-1110402-MZ	Nipple	1
28	RO-0192402-00	Oil ring	1
29	B3511-557-000	Oil window	1
30	BP-3030000-00	Oil tube	1

5. FEED MECHANISM COMPONENTS (2)

Ref. No.	Part No.	Description	E.C.	Amt. Req.
1	B1613-012-A00	Feed dog (A)		1
2	SS-4080620-TP	... Screw 1/8-44 L=6.4		2
3	B1602-155-0B0	Feed bar asm.		1
4	SS-8620610-TP	... Shaft clamp screw 3/16-32 L=6.0		(1)
5	B1604-012-000	... Shaft		1
6	B1603-155-0A0	Feed rocker asm.		1
7	SS-7111310-TP	... Clamp screw 11/64-40 L=12.8		(2)
8	CS-0640860-SH	Thrust collar asm.		1
9	SS-8110510-SP	... Screw 11/64-40 L=5.0		(2)
10	CQ-3030000-00	Oil wick		0.2
11	B1609-155-000	... Holder		1
12	SS-6080410-SP	... Screw 1/8-44 L=4.0		2
13	B1601-552-000	Feed rocker shaft		1
14	CQ-3030000-00	... Oil wick (A)		0.3
15	CQ-3030000-00	... Oil wick (B)		0.5
16	B1604-155-000	Feed rocker shaft bushing, front		2
17	SS-8150710-SP	... Screw 15/64-28 L=7.0		1
18	SS-8151550-SP	Screw 15/64-28 L=15.0		1
19	B1704-155-0A0	Feed rocker shaft crank asm.		1
20	SS-7111120-SP	... Clamp screw 11/64-40 L=10.5		(1)
21	CQ-2020000-00	Oil wick		0.1
22	B1635-552-000	... Holder		1
23	SS-7110540-SP	... Screw 11/64-40 L=5.0		2
24	B1701-555-000	Feed driving shaft		1
25	CQ-3030000-00	... Oil wick (A)		0.3
26	CS-147121A-SH	... Thrust collar asm.		2
27	SS-8660610-TP	... Screw 1/4-40 L=6.0		(4)
28	B1702-155-000	... Bushing, rear		2
29	SS-8150410-SP	... Screw 15/64-28 L=4.0		1
30	B1608-161-0A0	Feed rocker shaft crank, rear asm.		1
31	SS-6121610-TP	... Clamp screw 3/16-28 L=15.5		(1)
32	SD-1020701-SP	... Hinge screw D=10.2 H=7.0		1
33	NS-6680410-SP	... Nut 9/32-28		1
34	B1708-555-0A0	Feed driving shaft connecting rod asm.		1
35	SS-6121610-SP	... Clamp screw 3/16-28 L=15.5		(2)
36	SD-1020701-SP	... Hinge screw D=10.2 H=7.0		1
37	NS-6680410-SP	... Nut 9/32-28		1
38	B1703-155-0A0	Feed driving shaft crank, rear asm.		1
39	SS-6121610-TP	... Clamp screw 3/16-28 L=15.5		(1)
40	SS-8150710-SP	Screw, 15/64-28 L=7.0		1

7. OIL RESERVOIR & KNEE LIFTER COMPONENTS



Ref. No.	Part No.	Description	E.C.	Amt. Req.
1	B8217-552-0C0	Oil reservoir asm.		1
2	B8217-552-0A0	Oil reservoir asm.		(1)
3	B8227-125-000	Felt pad		(4)
4	B8226-125-000	Rubber pad		(4)
5	B8217-552-000	Oil reservoir		(1)
6	B8281-552-000	Gasket		(1)
7	SS-6741010-SP	Oil drain cap screw 3/8-28 L=10.0		(2)
8	B8219-125-000	Gasket		(2)
9	B3420-552-0A0	Knee press rod asm.		(1)
10	B3420-552-000	Knee press rod		(1)
11	B3427-122-000	Bearing bracket		(1)
12	SS-9151540-SR	Rotating lever clamp screw 15/64-28 L=15.0		(2)
13	NS-6150430-SR	Nut 15/64-28		(2)
14	B3426-552-000	Thrust ring		(1)
15	B3425-552-000	Lifting (B)		(1)
16	B3424-552-000	Lifting (A)		(1)
17	SS-9151220-SR	Screw 15/64-28 L=12.0		(1)
18	SS-8152080-SR	Positioning screw (B) 15/64-28 L=19.5		(1)
19	SS-8153010-SR	Positioning screw (A) 15/64-28 L=30.0		(1)
20	NS-6150430-SR	Nut 15/64-28		(2)
21	B3429-552-000	Spring		(1)
22	SS-9182010-SN	Clamp screw 9/32-20 L=20.0		(2)
23	B3421-552-000	Knee press lifter rod asm.		1
24	B8228-125-000	Oil reservoir magnet		1
25	B3419-122-0A0	Knee lifter plate rod asm.		1
26	B3419-122-000	Knee lifter plate rod		(1)
27	B3431-552-000	Knee press plate cover		(1)
28	SM-9061003-SE	Stopper screw M6 L=10.0		(1)
29	B3432-552-000	Knee press plate stopper		(1)
30	B3430-552-000	Knee press plate		(1)

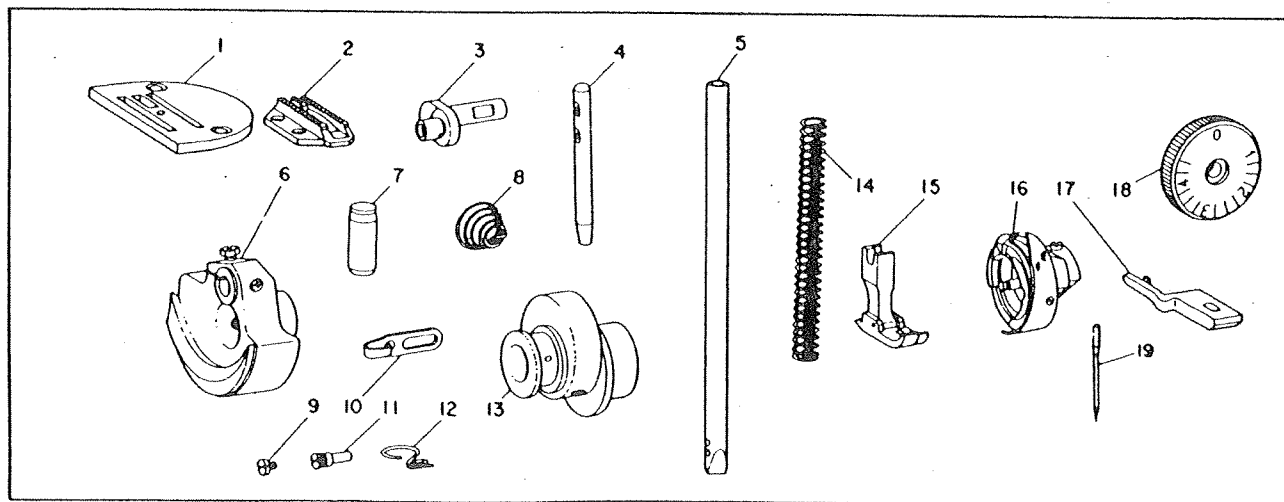
EXCLUSIVE PARTS LIST OF SUBCLASS SEWING MACHINES

	Description	Standard	For heavy weight materials
1	Throat plate	B-1109-012-A00	B1109-555-HOB
2	Needle thread guide pin asm.	B1113-155-0A0	B1114-012-000
3	Frame thread guide (A)	B1126-552-000	B1126-553-000
4	Counterweight asm.	B1206-552-0A0	B1206-553-0A0
5	Needle bar crank	B1209-552-000	B1209-553-000
6	Needle bar	B1401-552-A00	B1401-552-i00
7	Needle bar bushing, lower	B1403-155-000	B1403-553-000
8	Needle bar thread guide	B1418-541-000	—
9	Needle bar thread guide	B1419-155-000	B1419-553-000
10	Presser spring	B1505-227-000-A	B1505-552-000-A
11	Hand lifter cam asm.	B1518-552-0A0	*
12	Hinged presser foot asm.	B1524-012-0A0	B1511-543-BA0
13	Feed dog	B1613-012-A00	B1613-555-H00
14	Stitch dial asm.	B1623-555-0A0-A	B1623-555-HA0-A
15	Lubricating hook asm.	B1830-127-0A0	B1830-555-HA0
16	Bobbin case holder	B1835-012-000	B1835-555-H00
17	Thread tension post socket	B3111-552-B00	*
18	Thread tension spring	B3129-012-A00	B3114-232-000
19	Take-up spring	B3128-012-000	*
20	Bobbin	B9117-012-000	*
21	Needle	MD8-100B1400	MD8-100B2200
22	Arm oil shield screw	SS-6080410-SP	SS-6080320-SP
23	Lower shaft front screw asm.	B1808-552-0A0	B1808-227-HA0
24	Feed drive eccentric cam	B1610-555-000	B1610-555-H00

Note: Parts marked with * are same as standard parts

— Parts to be removed

8. EXCLUSIVE PARTS SUBCLASS COMPONENTS



(FOR HEAVY WEIGHT MATERIALS)

1	B1109-555-HOB	Throat plate (H)	1
2	B1613-555-H00	Feed dog (H)	1
3	B1209-553-000	Needle bar crank	1
4	B1114-012-000	Needle thread guide pin	1
5	B1401-552-i00	Needle bar	1
6	B1206-553-0A0	Counterweight asm.	1
7	B1403-553-000	Needle bar bushing, lower	1
8	B3114-232-000	Thread tension spring	1
9	SS-6080320-SP	Arm oil shield screw 1/8.44 L=2.5	1
10	B1126-553-000	Frame thread guide (A)	1
11	B1808-227-HA0	Hook driving shaft front screw asm.	1
12	B1419-553-000	Needle bar thread guide	1
13	B1610-555-H00	Feed drive eccentric cam	1
14	B1505-552-000-A	Presser spring	1
15	B1511-543-BA0	Hinged presser foot asm.	1
16	B1830-555-HA0	Lubricating hook asm.	1
17	B1835-555-H00	Bobbin case holder	1
18	B1623-555-HA0-A	Stitch dial asm.	1
19	MD8-100B2200	Needle D6x1 #22	1

Parts. No.	Page	Ref. No.	Parts. No.	Page	Ref. No.	Parts. No.	Page	Ref. No.
CS-0640860-SH	05	8	SS-4120900-SP	06	14	SS-8110510-SP	04	11
CS-0791010-SH	02	65	SS-5090610-SP	01	26		05	9
	03	57	SS-6060210-SP	01	46	SS-8110520-TP	02	66
CS-079106A-SH	03	46	SS-6080320-SP	08	9		03	58
CS-147121A-SH	02	40	SS-6080410-SP	01	20	SS-8150310-SP	02	16
	05	26		05	12		02	21
MDB-100B1400	02	24	SS-6090650-SP	03	34		03	36
MDB-100B2200	08	19	SS-6090670-TP	02	19	SS-8150410-SP	05	29
NM-6032400-CR	06	11	SS-6110560-TP	03	45	SS-8150710-SP	01	39
NS-2820850-SA	03	27	SS-6111010-SP	03	41		04	24
NS-6060350-SP	01	28	SS-6121050-SP	04	2		04	15
NS-6110420-SP	04	50	SS-6121210-SP	04	14		04	39
NS-6120310-SP	04	29		04	23		05	40
NS-6150310-SP	01	54	SS-6121610-SP	05	35		05	17
NS-6150430-SR	07	13		05	39	SS-8151150-SP	02	55
	07	20		05	31		02	60
NS-6620310-SP	03	25	SS-666110-SP	02	43		02	37
NS-6680410-SP	05	33	SS-6741010-SP	07	7		02	63
	05	37	SS-7080510-SP	02	25		02	5
R0-0192402-00	06	28	SS-7091110-SP	03	38		03	52
R0-0442401-00	02	33	SS-7110510-SP	01	24	SS-8151230-SP	04	7
R0-0611801-00	04	18	SS-7110540-SP	05	23	SS-8151550-SP	03	56
R0-0691801-00	04	25	SS-7110710-SP	06	21		05	18
R0-0742401-00	04	4	SS-7110720-SP	04	10	SS-8152080-SR	07	18
R0-2943101-00	02	56	SS-7110910-SP	01	7	SS-8153010-SR	07	19
RE-0500000-K0	03	23		04	16	SS-8620610-SP	04	40
	03	16		06	19	SS-8620610-TP	05	4
RE-0600000-K0	03	4	SS-7111120-SP	01	2	SS-8660610-TP	02	34
SD-0380552-SL	01	12		04	43		02	41
SD-0500401-KP	04	27		04	48		05	27
SD-0630275-SP	03	7		05	20	SS-8660810-TP	02	53
SD-0630301-SP	03	8	SS-7111260-SP	04	36		04	32
SD-0720331-SP	03	18	SS-7111310-TP	05	7	SS-8660970-TP	04	31
SD-1020701-SP	05	36	SS-7111410-SP	03	32	SS-8681950-SP	02	31
	05	32	SS-7120910-SP	03	10	SS-9151220-SR	07	17
SK-3030101-SE	06	8	SS-7151120-SP	02	39	SS-9151540-SR	07	12
SM-7030101-SE	06	10		04	45	SS-9182010-SN	07	22
SM-9061003-SE	07	28	SS-7681650-TP	02	32	SS-9661120-CP	02	30
SQ-1110402-MZ	06	27	SS-7820750-SP	04	17	V3424-552-000	07	16
SS-2110920-TP	01	43	SS-8090670-SP	01	30	V3425-552-000	07	15
SS-2110930-SP	02	45	SS-8110410-TP	03	47	WP-0740516-SP	03	12
SS-4080620-TP	05	2	SS-8110510-SP	01	22	WZ-0541510-KP	04	28
						WZ-1052010-KP	04	33

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B1106-122-000	01	53	B1515-552-000	03	6	B3114-232-000	08	8
B1109-012-A00	01	42	B1516-552-000	03	1	B3114-761-000	01	27
B1109-555-H0B	08	1	B1517-552-000	03	2	B3115-552-000	01	33
B1110-012-0A0	01	44	B1518-522-0A0	03	13	B3116-125-000	01	38
B1111-012-000	01	45	B1520-552-000	03	9	B3118-552-C00	01	41
B1113-155-000	01	9	B1521-552-000	03	33	B3120-125-000	01	37
B1113-155-0A0	01	8	B1522-552-00	03	11	B3126-012-000	01	34
B1114-012-000	08	4	B1523-226-000	03	5	B3127-127-000	01	40
B1117-552-000	01	16	B1524-012-0A0	03	37	B3128-012-000	01	32
	01	13	B1601-552-000	05	13	B3129-012-A00	01	36
B1118-945-000	01	5	B1602-155-0B0	05	3	B3132-552-000	01	35
B1119-522-000	01	6	B1603-155-0A0	05	6	B3148-123-000	01	10
B1121-945-0A0	01	1	B1604-012-000	05	5	B3149-123-A00	01	11
B1122-945-000	01	4	B1604-155-000	05	16	B3412-522-000	03	14
B1123-552-000-A	01	23	B1608-161-0A0	05	30	B3414-552-000	03	17
B1126-552-000	01	25	B1609-155-000	05	11	B3415-227-000	03	20
B1126-553-000	08	10	B1610-555-000	02	42	B3415-552-000	03	24
B1128-552-000	01	21	B1610-555-H00	08	13	B3416-012-000	03	21
B1147-555-000	01	49	B1611-161-000	02	44	B3416-552-000	03	15
B1148-555-000	01	50	B1612-161-000	04	20	B3417-552-000	03	19
B1164-012-000	01	17	B1613-012-A00	05	1	B3418-552-000	03	22
B1166-552-000-A	01	52	B1613-555-000	04	34	B3419-122-000	07	26
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B1186-552-000	01	14	B1615-555-000	04	41	B3420-552-0A0	07	9
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B1208-552-000-A	02	57	B1625-555-000	04	8	B3501-557-0A0	06	1
B1209-552-000	02	6	B1626-555-000	04	9	B3502-557-000	06	5
B1209-553-000	08	3	B1627-555-0A0	04	13	B3503-557-000	06	6
B1212-552-A00	02	28	B1628-555-000	04	12	B3504-557-000	06	7
B1213-552-0A0	02	11	B1629-555-0A0	04	22	B3505-557-000	06	4
B1214-038-000	06	17	B1630-555-000	04	26	B3506-557-000	06	9
B1217-555-000	02	58	B1632-555-000	04	47	B3507-557-000	06	13
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B1233-012-000	02	59	B1634-555-000-A	04	3	B3509-557-000	06	15
B1301-552-000	02	61	B1634-555-000-B	04	3-1	B3510-557-000	06	24
B1302-552-B00	02	62	B1635-552-000	05	22	B3511-557-000	06	29
B1303-552-B00	02	64	B1636-581-B00	04	21	B3512-557-000	06	3
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B1307-155-0B0	02	50	B1704-155-0A0	05	19	B3536-122-000	06	20
B1308-155-0A0	02	52	B1708-555-0A0	05	34	B8217-552-000	07	5
B1401-552-A00	02	17	B1801-412-000	03	50	B8217-552-0A0	07	2
B1401-552-I00	08	5	B1802-412-0A0	03	51	B8217-552-0C0	07	1
B1402-552-000-A	02	15	B1803-552-000	03	53	B8219-125-000	07	8
B1403-155-000	02	20	B1806-038-000	03	54	B8226-125-000	07	4
B1403-553-000	08	7	B1808-227-HA0	08	11	B8227-125-000	07	3
B1405-012-000	02	14	B1808-552-0A0	03	48	B8228-125-000	07	24
B1408-552-000	02	8	B1810-552-000	03	49	B8281-552-000	07	6
B1411-552-0A0	02	18	B1830-127-0A0	03	44	B9117-012-000	03	43
B1414-232-000	02	27	B1830-555-HA0	08	16	BP-3030000-00	06	30
B1418-541-000	02	23	B1835-012-000	03	40	CQ-2000000-00	02	2
B1419-155-000	02	22	B1835-555-H00	08	17	CQ-2020000-00	01	19
B1419-553-000	08	12	B1837-012-0A0	03	42		02	35
B1501-127-000	03	30	B1901-552-0C0	02	1		02	4
B1502-541-000	03	35	B1903-552-000	02	9		05	21
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CONSOLIDATED SEWING MACHINE CORP.

— INDUSTRIAL SEWING & CUTTING EQUIPMENT

MAIN OFFICE
131 WEST 25TH ST
NEW YORK, NY 10001
TEL: 212-741-7788
FAX: 212-741-7787

MIAMI OFFICE
7855 NW 29TH ST,
BAY 166
MIAMI, FL 33122
TEL: 305-471-0200
FAX: 305-471-0243

L.A. OFFICE
2320 SOUTH HILL ST.
LOS ANGELES, CA 90007
TEL: 213-745-8844
FAX: 213-745-8855