

INSTRUCTION MANUAL
ILLUSTRATED PARTS LIST

FOR

SINGER

MACHINES

2691D200G

THE SINGER COMPANY

INSTRUCTION MANUAL

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BEFORE OPERATION

1. Never operate the machine unless its oil pan has been filled with oil.
2. After setting up the machine, check the direction of motor rotation. To check it, turn the handwheel by hand to bring the needle down, and turn the power switch ON while observing the handwheel. (The handwheel should turn counterclockwise as observed from the handwheel side.)
3. Do not use a larger motor pulley for the first one month.
4. Confirm that the voltage and phase (Single or 3 phase) are correct by checking them against the ratings shown on the motor nameplate.

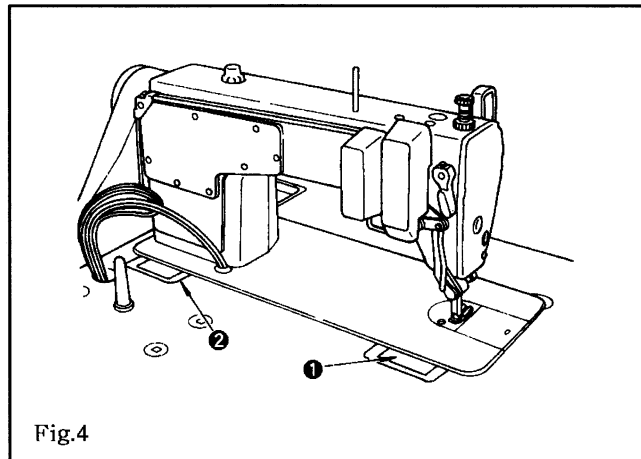
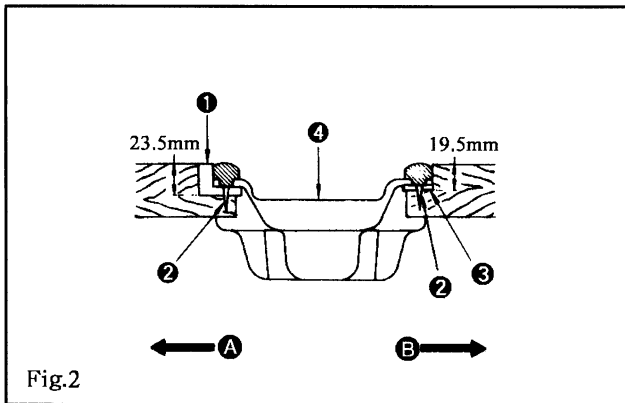
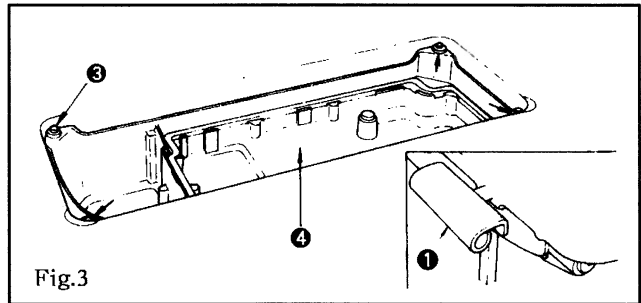
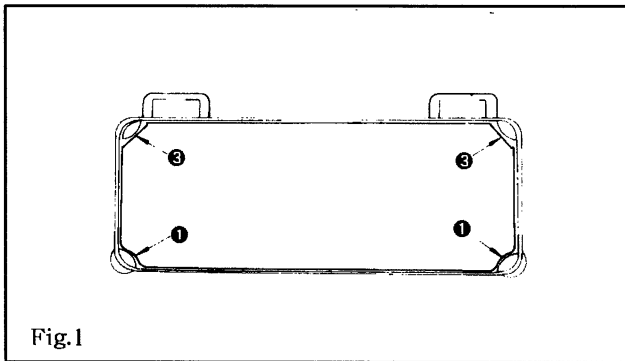
PRECAUTIONS

1. Keep your hands away from the needle when you turn the power switch ON or while the machine is operating.
2. Do not put your fingers into the thread take-up cover while the machine is operating.
3. Be sure to turn the power switch OFF before tilting the machine head or removing the V belt.
4. When an operator leaves from the machine, make sure to turn off the power.
5. During operation, be careful not to allow your or any other person's head or hands to come close to the hand wheel, V belt, bobbin winder or motor. Also, do not place anything close to them. Doing so may be dangerous.
6. If your machine is provided with a belt cover, finger guard or any other protectors, do not operate your machine with any of them removed.

INSTALLATION

* Installing the oil pan

- 1) The oil pan should rest on the four corners of the machine table groove.
- 2) Fix two rubber seats ① on side A (operator's side) using nails ② as illustrated below. Fix two cushion seats ③ on side B (hinged side) using nails ②. Then place oil pan ④ on the fixed seats. (Fig.1, Fig.2)
- 3) Fit hinge ① into the opening in the machine bed, and fit rubber cushions ③ and machine hinge rubbers ② before placing the machine head on machine table. (Fig.3, Fig.4)



LUBRICATION

1. Information on lubrication (Fig.5)

* Before starting the machine

- 1) Fill oil pan ① with sewing machine oil (10 white oil) up to HIGH mark A.
- 2) When the oil level lowers below LOW mark B, refill the oil pan with the specified oil.
- 3) When you operate the machine after lubrication, you will see splashing oil through oil sight window ② if the lubrication is adequate.
- 4) Note that the amount of the splashing oil is unrelated to the amount of the lubricating oil.

* Precaution

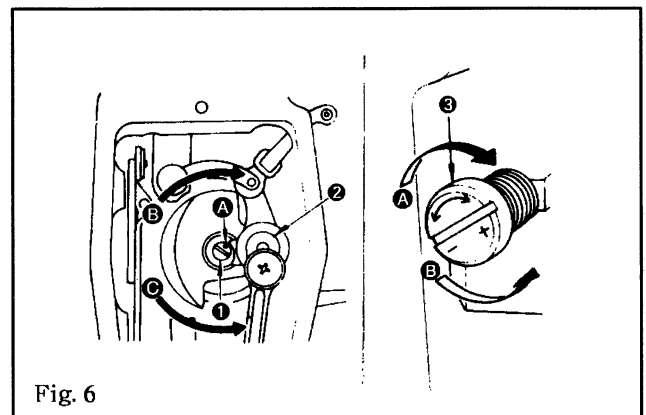
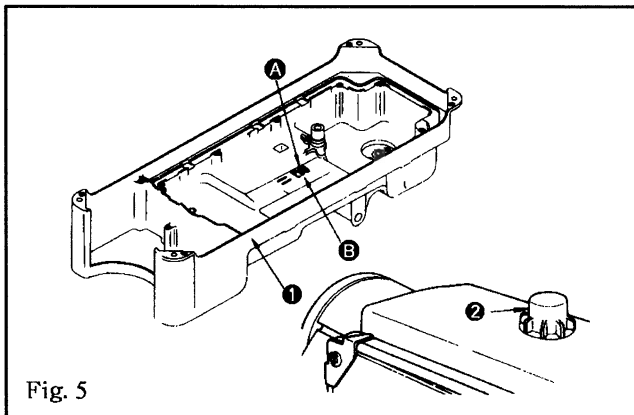
When you first operate your machine after set up or after an extended period of disuse, run your machine at 3,000 s.p.m. to 3,500 s.p.m. for about 10 minutes for the purpose of break-in.

2. Adjusting the amount of oil supplied to the face plate parts (Fig.6)

- 1) Adjust the amount of oil supplied to the thread take-up and needle bar crank ② by turning adjust pin ①.
- 2) The minimum amount of oil is reached when marker dot A is brought close to needle bar crank ② by turning the adjust pin in direction B.
- 3) The maximum amount of oil is reached when marker dot A is brought to the position just opposite from the needle bar crank by turning the adjust pin in direction C.

3. Adjusting the amount of oil supplied to the hook (Fig.6)

- 1) More oil is supplied as oil amount adjust screw ③ mounted on the hook driving shaft is turned toward + (in direction A).
- 2) As the oil amount adjust screw ③ is turned toward - (in direction B), the amount of oil supplied will be decreased.



ATTACHING NEEDLE

* Turn the motor power OFF before starting to attach the needle.

A needle of Singer CAT. No. 1955-01 should be used. Select a proper needle size according to the count of thread and the type of material used.

- 1) Turn the handwheel until the needle bar reaches the highest point of its stroke.
- 2) Loosen screw ②, and hold needle ① with its indented part A facing exactly to the right in direction B.
- 3) Insert the needle in the direction of the arrow until it will go no further.
- 4) Securely tighten screw ②.
- 5) Check that long groove C of the needle is facing exactly to the left in direction D.

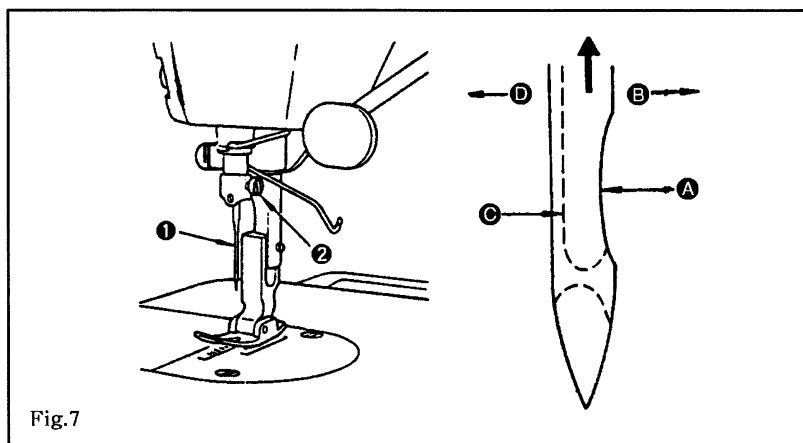


Fig.7

SETTING BOBBIN INTO BOBBIN CASE

- 1) Hold the bobbin in a way that the thread open end is directed to the left as observed from you, and set the bobbin into the bobbin case.
- 2) Pass the thread through thread slit A, and pull the thread in direction B. By so doing, the thread will pass under the tension spring and come out from notch B.
- 3) Check that the bobbin rotates in the direction of the arrow when thread C is pulled.

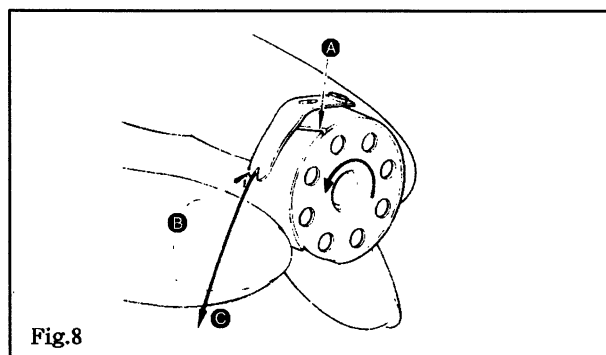
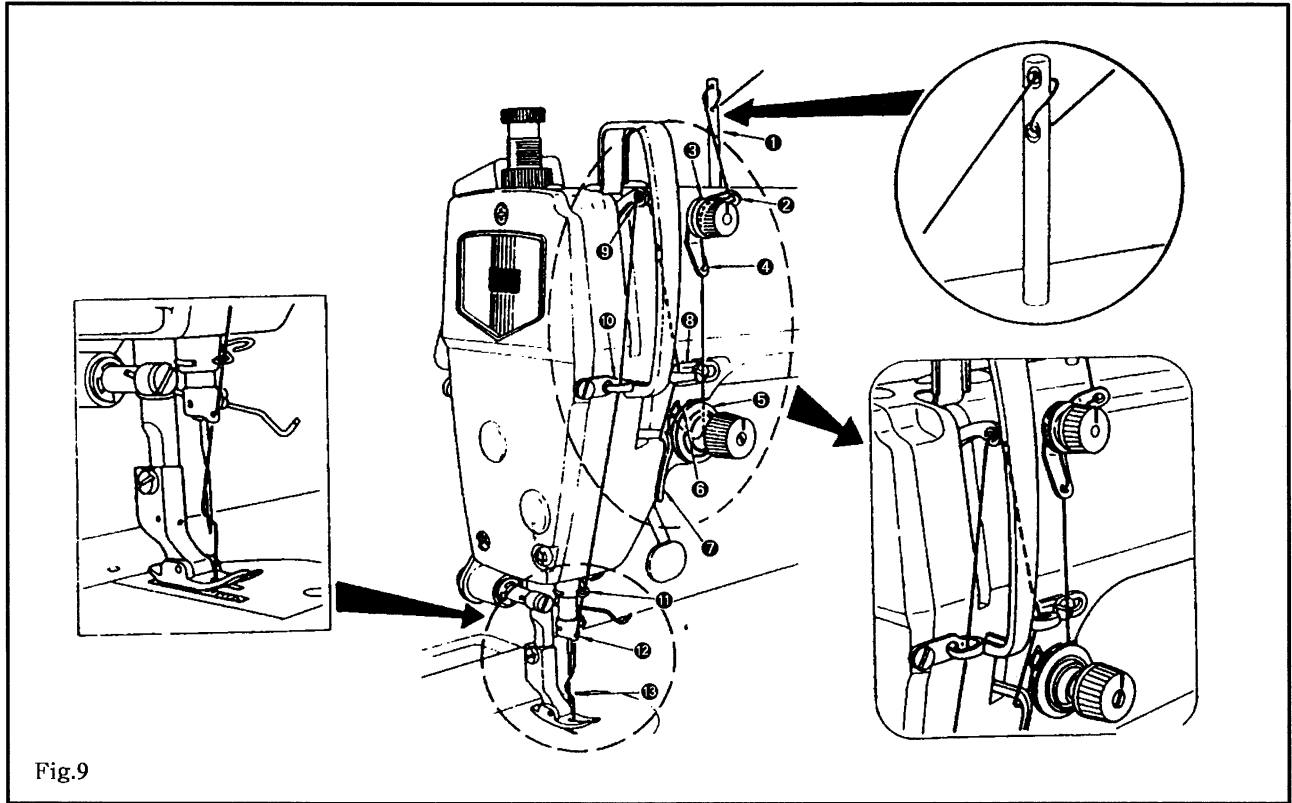


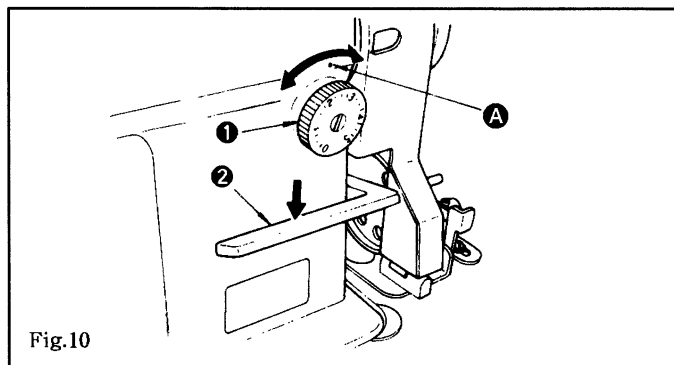
Fig.8

THREADING



ADJUSTING STITCH LENGTH

- 1) Turn stitch length dial ① in the direction of the arrow, and align the desired number to marker dot A on the machine arm.
- 2) The dial calibration is in millimeters.
- 3) When you want to decrease the stitch length, turn stitch length dial ① while pressing feed lever ② in the direction of the arrow.



ADJUSTING THREAD TENSION

1. Adjusting the needle thread tension

- 1) As you turn thread tension No.1 nut ① clockwise (in direction ①), the thread remaining on the needle after thread trimming will be shorter.
- 2) As you turn nut ① counterclockwise (in direction ②), the thread length will be longer.
- 3) As you turn thread tension No.2 nut ② clockwise (in direction ③), the needle thread tension will be increased.
- 4) As you turn nut ② counterclockwise (in direction ④), the needle thread tension will be decreased.

2. Adjusting the bobbin thread tension

- 1) As you turn tension adjust screw ③ clockwise (in direction ⑤), the bobbin thread tension will be increased.
- 2) As you turn screw ③ counterclockwise (in direction ⑥), the bobbin thread tension will be decreased.

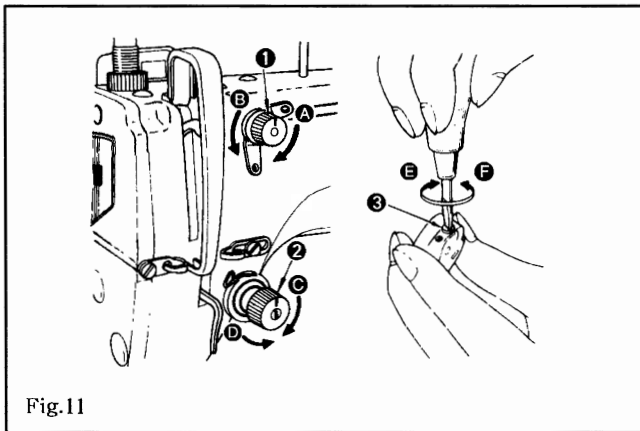


Fig.11

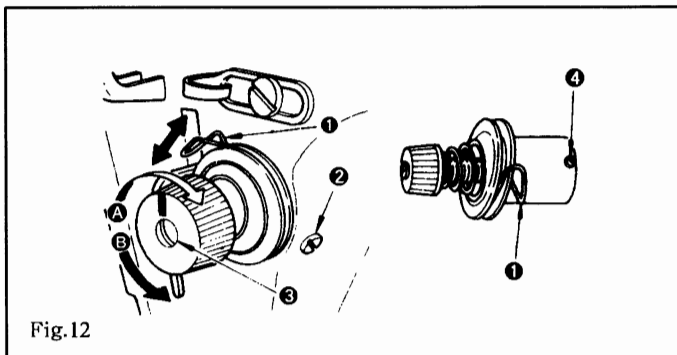
ADJUSTING THREAD TAKE-UP SPRING

1. Changing the stroke of thread take-up spring ①

- 1) Loosen setscrew ②.
- 2) As you turn tension post ③ clockwise (in direction A), the stroke of the thread take-up spring will be increased.
- 3) As you turn tension post ③ counterclockwise (in direction B), the stroke will be decreased.

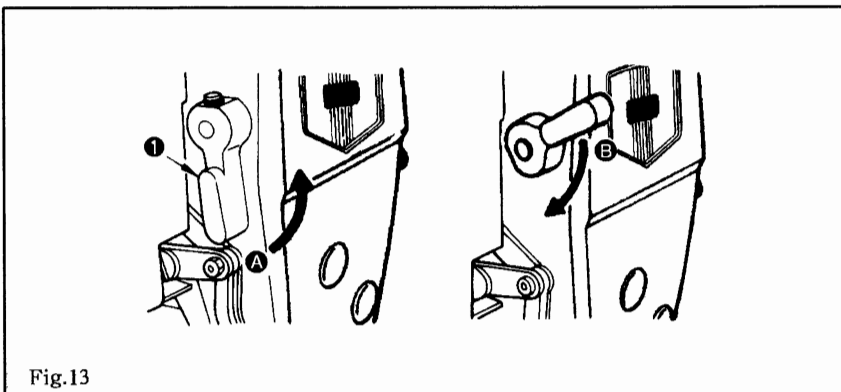
2. Changing the pressure of thread take-up spring ①

- 1) Loosen setscrew ②, and remove tension assembly.
- 2) Loosen setscrew ④.
- 3) As you turn tension post ③ clockwise (in direction A), the pressure will be increased.
- 4) As you turn the post counterclockwise (in direction B), the pressure will be decreased.



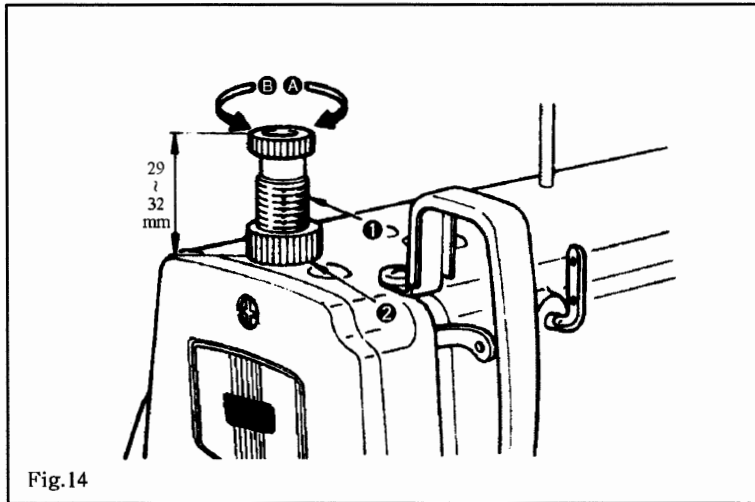
HAND LIFTER

- 1) To stop the machine with its presser foot up, turn hand lifter ① in direction A.
- 2) The presser foot will go up about 5.5 mm and stop.
- 3) The presser foot will go back to its original position when hand lifter ① is turned down in direction B.
- 4) Using the knee lifter, you can get the standard presser foot lift of about 10 mm and a maximum lift of about 13 mm.



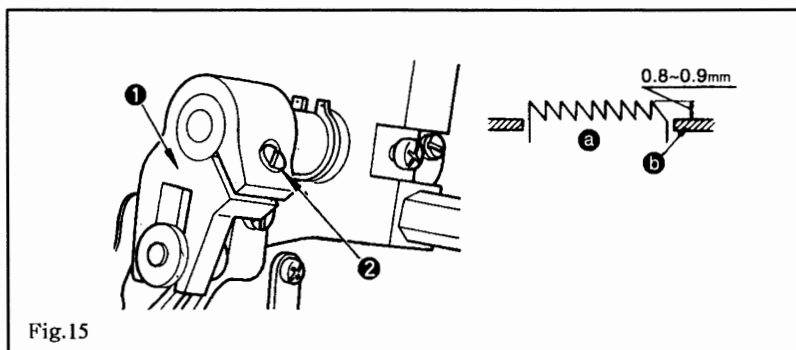
ADJUSTING PRESSER FOOT PRESSURE

- 1) Loosen nut ②. As you turn presser spring regulator ① clockwise (in direction A), the presser foot pressure will be increased.
- 2) As you turn the presser spring regulator counterclockwise (in direction B), the pressure will be decreased.
- 3) After adjustment, tighten nut ②.
- 4) For general fabrics, the standard height of the presser spring regulator is 29 to 32 mm (5kg).



HEIGHT OF FEED DOG

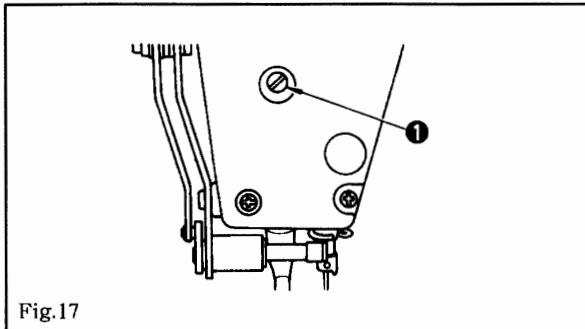
- 1) The feed dog is factory-adjusted so that it juts out from the throat plate surface 0.8 mm to 0.9 mm.
 - 2) If the feed dog juts out too much, puckering may result when sewing light-weight materials. (Recommended protrusion: 0.7 mm to 0.8 mm)
 - 3) To adjust the height of the feed dog:
 - (1) Loosen screw ② of crank ①.
 - (2) Move the feed bar up or down to make adjustment.
 - (3) Securely tighten screw ②.
- a Feed dog b Throat plate



2

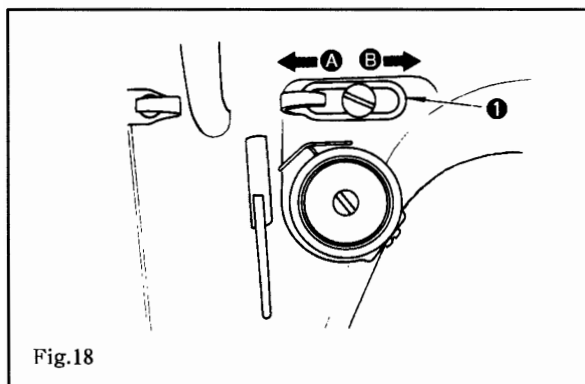
ADJUSTING HEIGHT OF PRESSER BAR

- 1) Loosen setscrew ①, and adjust the presser bar height and the angle of the presser foot.
- 2) After adjustment, securely tighten the setscrew.



ADJUSTING NEEDLE THREAD SUPPLY

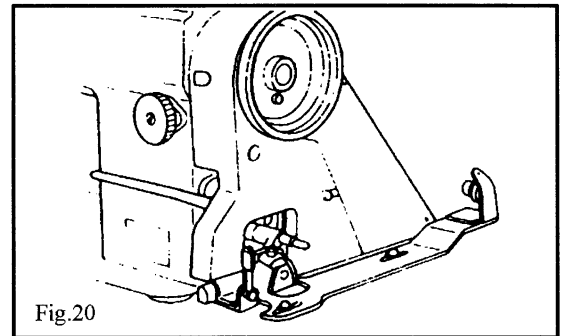
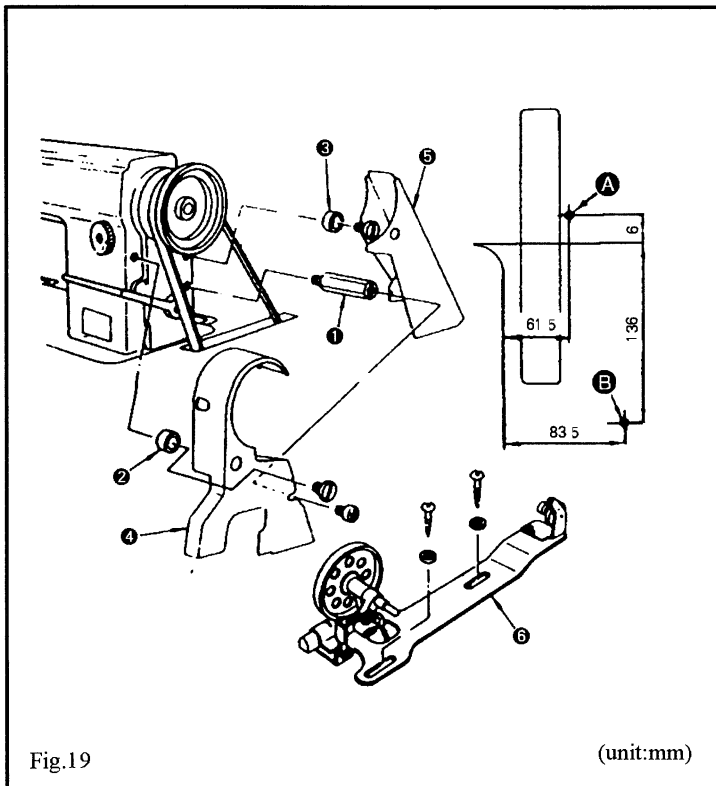
- 1) When sewing heavy-weight materials, move thread guide ① to the left in direction A to increase the length of thread pulled out by the thread take-up.
- 2) When sewing light-weight materials, move thread guide ① to the right in direction B to decrease the length of thread pulled out by the thread take-up.



INSTALLATION OF BELT GUARD AND BOBBIN WINDER

1. Installing procedure

- 1) Drill two wooden screw guide holes A and B in the machine table.
- 2) Insert support ① in the tapped hole in the arm.
- 3) Fix belt cover collars ② and ③ using the belt cover setscrews for preliminary installation.
- 4) Accurately position belt cover ④, then fix it on collar ②.
- 5) Fix belt cover ⑤ on collar.
- 6) Securely fix belt cover ④ and belt cover ⑤ on the support using the belt cover setscrews.
- 7) Fix bobbin winder ⑥ at A and B using the wooden screws.



11

12

13

OPERATION OF PEDAL

1. The pedal is operated in the following four steps:

- 1) The machine runs at low sewing speed when you lightly depress the front part of the pedal. (B shown in Fig.24)
 - 2) The machine runs at high sewing speed when you further depress the front part of the pedal. (If the automatic reverse feed stitching has been preset, the machine runs at high speed after it completes reverse feed stitching.) (A shown in Fig.24)
 - 3) The machine stops (with its needle up or down) when you reset the pedal to its original position. (C shown in Fig.24)
 - 4) The machine trims threads when you fully depress the back part of the pedal. (E shown in Fig.24)
- * If your machine is provided with the Auto-lifter, an addition step is given between the machine stop and thread trimming step.

The presser foot goes up when you lightly depress the back part of the pedal (D shown in Fig.24), and if you further depress the back part, the thread trimmer is actuated.

- If you reset the pedal to its neutral position during the automatic reverse feed stitching at start seam, the machine stops after it completes the reverse feed stitching.
- The machine will perform normal thread trimming even if you depress the back part of the pedal immediately following high or low speed sewing.
- The machine will completely perform thread trimming even if you reset the pedal to its neutral position immediately after the machine started thread trimming action.
- When the machine stops with its needle down, and if you want to bring the needle up, depress the back part of the pedal once.

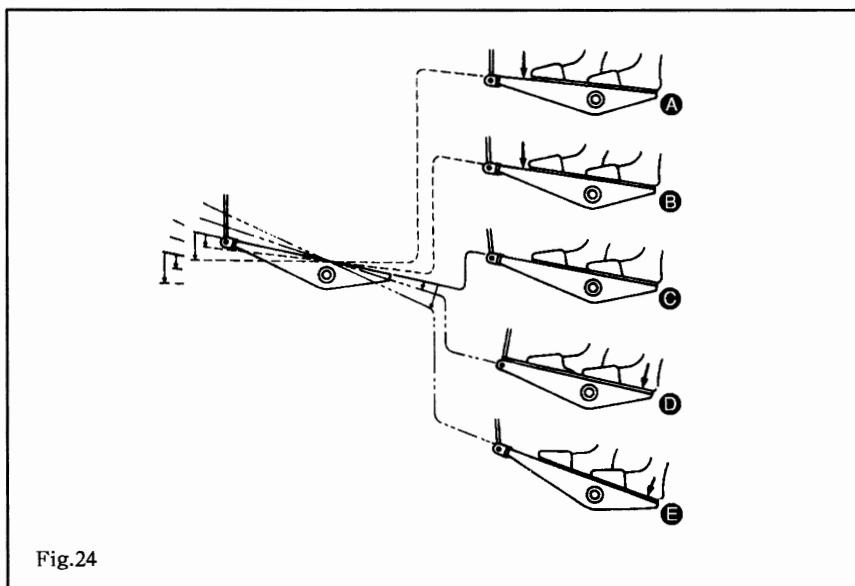
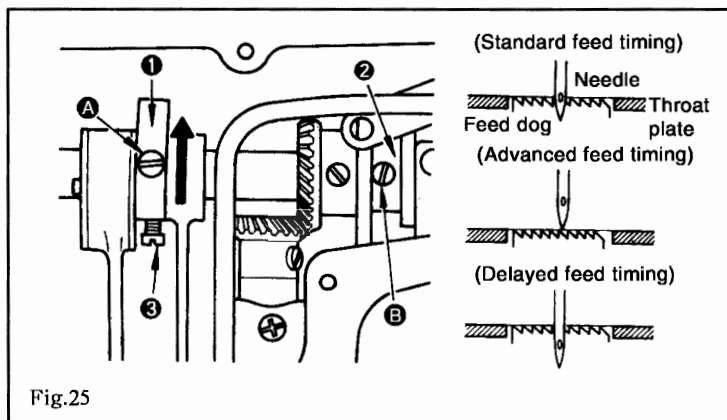


Fig.24

ADJUSTING FEED TIMING

- 1) To obtain the standard feed timing, align setscrew **A** on feed eccentric cam **1** with setscrew **B** on main shaft thrust collar **2**.
- 2) To make adjustment, loosen two setscrews **3** to release the feed eccentric cam, properly position the eccentric cam. Then retighten the setscrews.
- 3) To advance the feed timing in order to prevent uneven material feed, move the feed eccentric cam in the direction of the arrow.
- 4) To delay the feed timing in order to increase stitch tightness, move the feed eccentric cam in the opposite direction from the arrow.
- 5) Be careful not to move the feed eccentric cam too far, or else needle breakage may result.

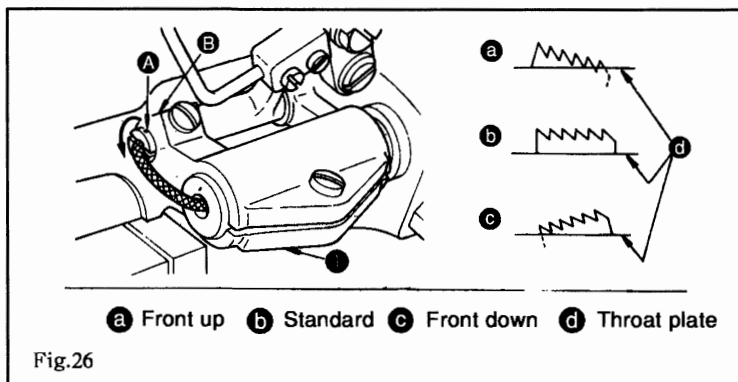


TILTING FEED DOG

- 1) The standard tilt (horizontal) of the feed dog is obtained when marker dot (A) on the feed bar shaft is aligned with marker dot (B) on feed rocker (1).
- 2) To tilt the feed dog with its front up in order to prevent puckering, loosen the setscrew, and turn the feed bar shaft 90 degrees in the direction of the arrow, using a screwdriver.
- 3) To tilt the feed dog with its front down in order to prevent uneven material feed, turn the feed bar shaft 90 degrees in the opposite direction from the arrow.

* Precaution

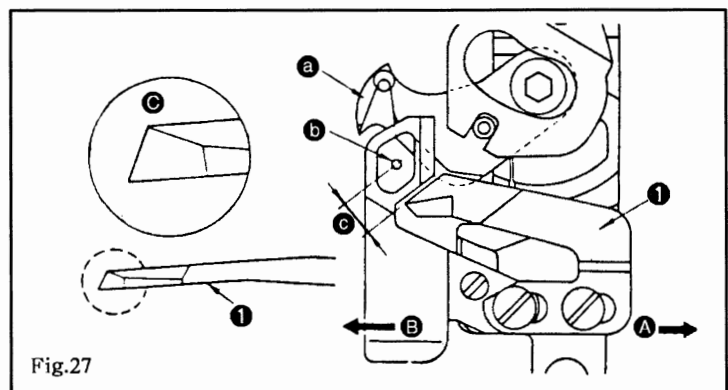
Whenever the feed dog tilt is adjusted, the feed dog height will be changed. So, it is necessary to check the height after tilt adjustment.



COUNTER KNIFE

1. When the knife sharpness has deteriorated, resharpen counter knife (1) as illustrated in Fig. (C) ,and properly reinstall it.
- 1) If the mounting position of the counter knife is moved in direction (A) from the standard mounting position, the thread length after thread trimming will be increased accordingly.
- 2) If the mounting position is moved in direction (B) , the thread length will be decreased accordingly.

- a. Moving knife
- b. Center of needle
- c. Standard: 4.0 mm



ADJUSTING NEEDLE STOP POSITION

1. Stop position after thread trimming

- 1) The standard needle stop position is obtained by aligning red marker dot (A) on the machine arm with white marker dot (B) on the handwheel.
- 2) Stop the needle in its highest position, loosen screw (1) to perform adjustment within the slot of the screw.

① The needle stop timing is advanced if you move the screw in direction (C) .

② The needle stop timing is delayed if you move the screw in direction (D) .

* Precaution

Do not operate the machine with screw (1) loosened. Just loosen the screw, and do not remove it.

2. Lower stop position

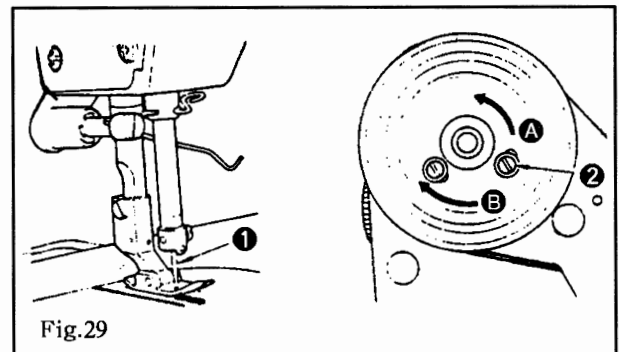
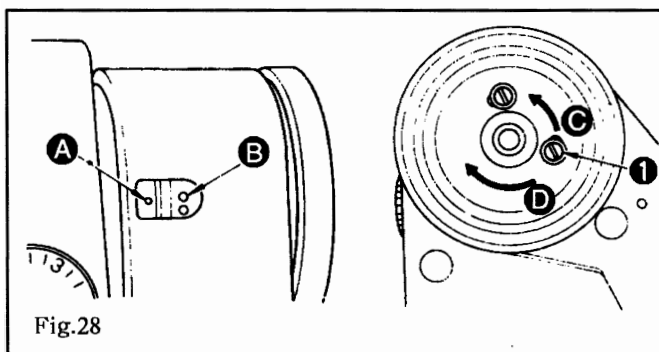
- 1) The lower needle stop position when the pedal is returned to the neutral position after the front part of the pedal is depressed can be adjusted as follows:

Stop needle (1) in its lowest position, loosen screw (2), and make adjustment within the slot of the screw.

Moving the screw in direction (A) , advances the needle stop timing. Moving the screw in direction (B) delays the timing.

* Precaution

Do not operate the machine with screw (2) loosened. Just loosen the screw, and do not remove it.



ADJUSTING PEDAL POSITION AND PEDAL ANGLE

1. Installing the connection rod

- 1) Move pedal ③ to the right or left as illustrated by the arrows so that motor control lever ① and connecting rod ② are straightened.

2. Adjusting the pedal angle

- 1) The pedal tilt can be freely adjusted by changing the length of the connecting rod.
- 2) Loosen adjust screw ④, and adjust the length of connecting rod ②.

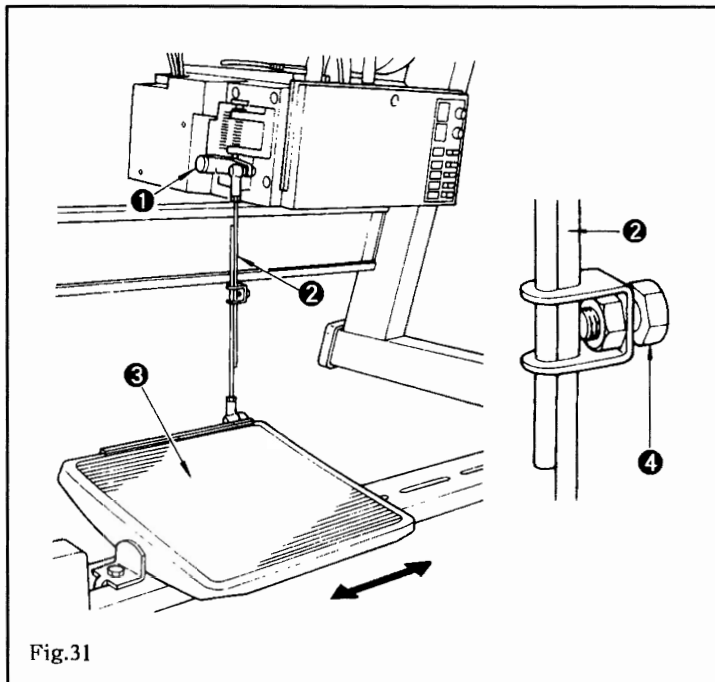


Fig.31

ONE-TOUCH REVERSE FEED STITCHING MECHANISM

1. How to operate

- 1) The moment switch lever ① is pressed, the machine performs reverse feed stitching.
- 2) The machine performs reverse feed stitching as long as the switch lever is held depressed.
- 3) The machine resumes normal feed stitching when the switch lever is released.

2. Height of the switch lever

- 1) Adjust the height of switch lever ① so that it can be easily operated.
- 2) Loosen screw ②, and move the switch lever up or down to adjust its height.

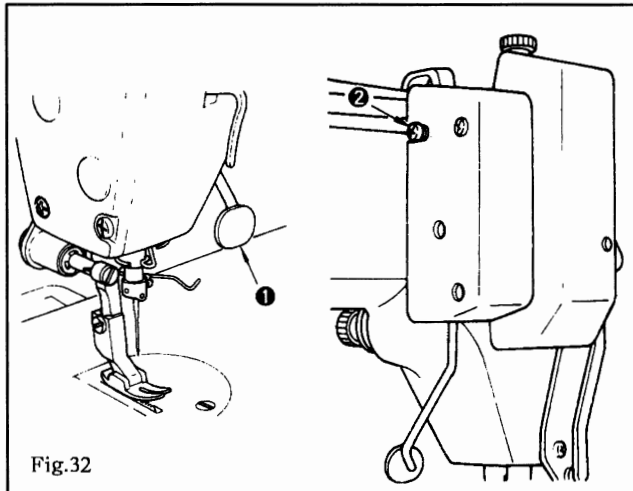


Fig.32

SPECIFICATIONS

Max. Sewing Speed:	5,000 s.p.m.
Max. Stitch Length:	4.0 mm
Presser Foot Lift (by knee lifter):	10.0 mm (standard) 13.0 mm (max.)
Needle:	CAT. No. 1955-01 #14
Lubrication Oil:	Singer “ C ” oil or equivalent

Note: Max. speed depends on the material and the sewing operation.

ILLUSTRATED PARTS LIST

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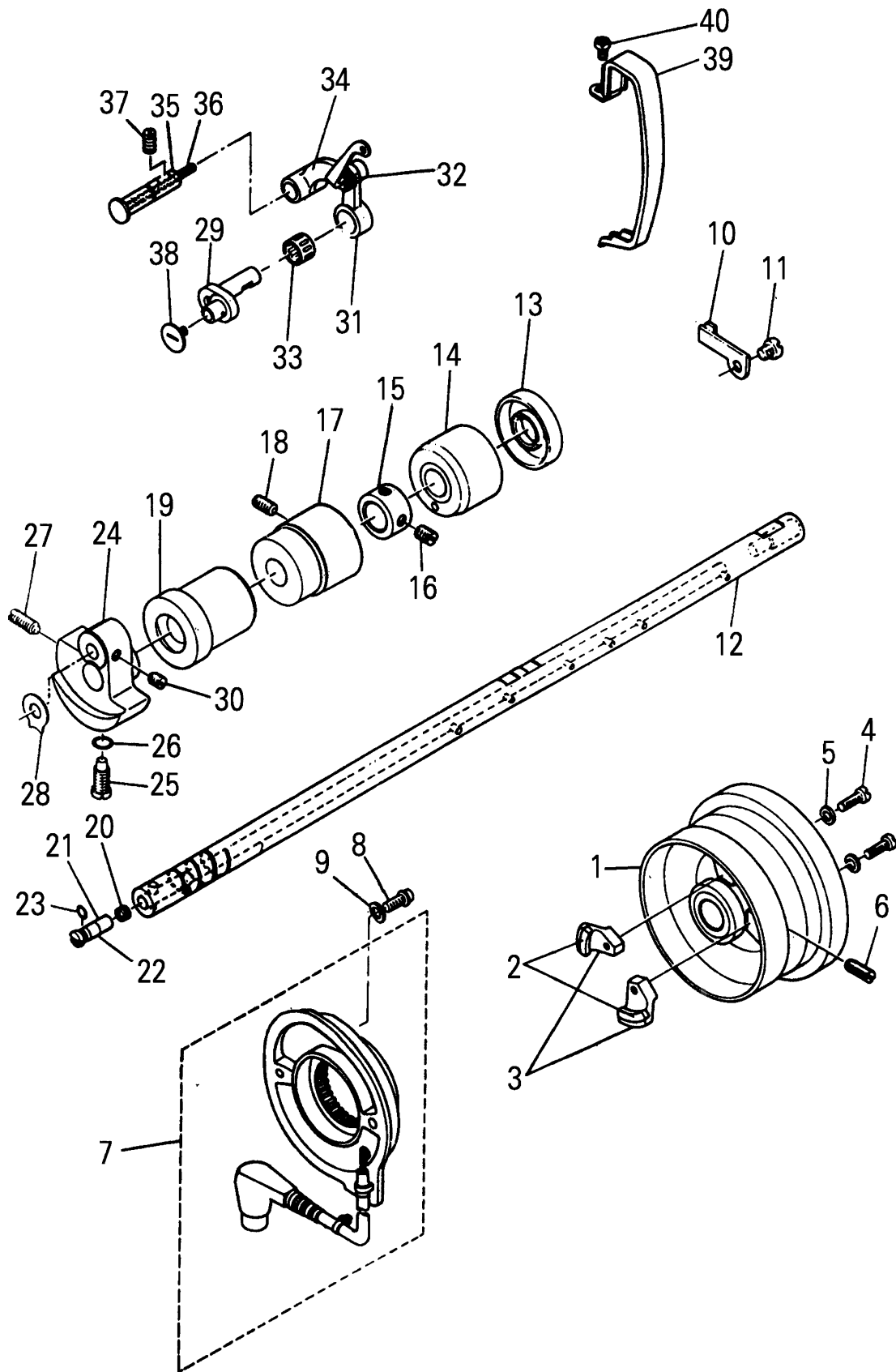
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1.Arm & Bed components

Ref.No.	Part No.	Description	Qty.
1	GS5048	Bed screw stud	4
2	SY0066	Slide plate	1
3	GR3340	Gasket	1
4	GS053	Screw 3/16-28 L=9	8
5	SY0063	Face plate	1
7	GR3343	Gasket	1
8	GS053	Screw 3/16-28 L=9	3
9	GR1458	Rubber plug	2
10	GR1463	Rubber plug	1
11	GR3344	Rubber plug	2
12	GR3345	Rubber plug	1
13	GR1464	Rubber plug	1
14	GS1077	Screw M5	4
15	GZ1104	Cap screw	1
16	GT1027	O-ring	1
17	GR5820	Driving disc	1
18	GW1058	Spring	1
19	GR5819	Nut	1
20	GR5816	Base	1
21	GW1056	Spring	1
22	GR5815	Bearing	2
23	GO1077	Slide bush	1
24	GRD1086	Spacer	1
25	GZ1103	Stud	1
26	GW1055	Spring	1
27	GR5814	Cap	1
28	GR1081	Shoulder screw	1
29	GS1080	Screw M3	1
30	GRD1085	Washer	1
31	GR5818	Pawl	1
32	GX1066	Adjust pin	1
33	GRD1084	E-ring	1
34	GW1057	Spring	1
35	GS1079	Screw M4	1
36	GR5810	Bobbin winder asm.	1
37	GC1027	Driving pulley asm.	1
38	GS1078	Screw M6 × 0.75	1
39	GR5821	Thread guide	1
40	GR5813	Tension disc	1
41	GW1059	Spring	1
42	GL1023	Tension nut	1
43	GL1025	Nut	1
44	GR5811	Tension thread asm.	1
45	GR4021	Scale base plate	1
46	GS086	Screw	1

2.Main Shaft & Thread Take-up components

Ref.No.	Part No.	Description	Qty.
1	GP144	Hand wheel	1
2	GD302	Magnet	2
3	GR2406	Magnet Support	2
4	GS0219	Screw 11/64-40 L=12	2
5	GR2407	Washer	2
6	GS03	Screw 15/64-28 L=15	2
7	GD303/2	Dynamo Stator	1
8	GS0220	Screw	2
9	GR2409	Washer	2
10	GR2410	Cable holder	1
11	GS0551	Screw 3/16-28 L=6	1
12	GZ431	Main shaft	1
13	GR3346	Oil seal	1
14	GO462	Main shaft bushing, rear	1
15	GR1469	Thrust collar asm	1
16	GS39	Screw 1/4-40 L=6	1
17	GO463	Bushing, intermediate	1
18	GS0549	Screw 15/64-28 L=9	1
19	GO464	Main shaft bushing, front	1
20	GR1470	Roller felt	1
21	GX334	Oil amount adjusting pin asm	1
22	GO269	Rubber pushing	1
23	GR1471	Rubber ring	1
24	GH561	Counterweight	1
25	GS06	Screw 1/4-40 L=6	1
26	GR1472	Rubber ring	1
27	GS0550	Screw 9/32-28 L=16	1
28	GR1473	Counterweight protecting plate	1
29	GH563	Needle bar crank	1
30	GS39	Screw 1/4-40 L=6	2
31	GH564/4	Thread take-up lever asm	1
32	GR3349	Rubber	1
33	GO270	Needle bearing	1
34	GH566	Thread take-up crank	1
35	GX566	Thread take-up crank shaft	1
36	GR3350	Oiling wick	1
37	GS04	Screw 15/64-28 L=10.5	1
38	GS09	Screw (left tiwist) 9/64-40 L=4.8	1
39	GK240	Thread take-up lever cover	1
40	GS0551	Screw 3/16-28 L=6	1



3. Needle Bar & Thread Tension components

Ref.No.	Part No.	Description	Qty.
1	GH334	Needle bar crank rod	1
2	GO270	Needle bearing	1
3	GR1478	Needle bar connection asm	1
4	GS011	Screw 9/64-40 L=6	1
5	GU168	Slide block	1
6	GO271	Needle bar bushing, upper	1
7	GR1479	Cap	1
8	GO272	Needle bar bushing, lower	1
9	GR3351	Needle bar thread guide	1
10	GZ342/2	Needle bar asm	1
11	GR1481	Needle bar thread guide	1
12	GS071	Screw 1/8-44 L=4.5	1
13	Cat.1995-01 #14	Needle	1
14	GS0221	First tension post	1
15	GR2413	Thread tension guide	1
16	GR1659	Bobbin winder tension disc	2
17	GW332	Thread tension spring	1
18	GL47	Thread tension nut	1
19	GS0551	Screw	1
20	GR3354	Frame thread guide, right	1
21	GS0552	Screw 11/64-40 L=6	1
22	GR3355	Frame thread guide, left	1
23	GS0552	Screw 11/64-40 L=6	1
24	GR1635	Tension post socket	1
25	GW250	Take-up spring	1
26	GS015	Screw	1
27	GS016	Set screw 9/64-40 L=5.5	1
28	GX336	Thread release pin	1
29	GR1488	Tension disc	2
30	GR1489	Tension disc holder	1
31	GW251	Tension spring	1
32	GR1490	Tension disc stopper	1
33	GL0133	Tension nut	1
34	GS48	Screw 15/64-28 L=7	1
35	GX568	Tension release supporting pin	1
36	GR1717	Snap ring	1
37	GR3357	Washer plate	1
38	GW432	Tension release pin spring	1
39	GR1664	Needle thread guide pin	(1)



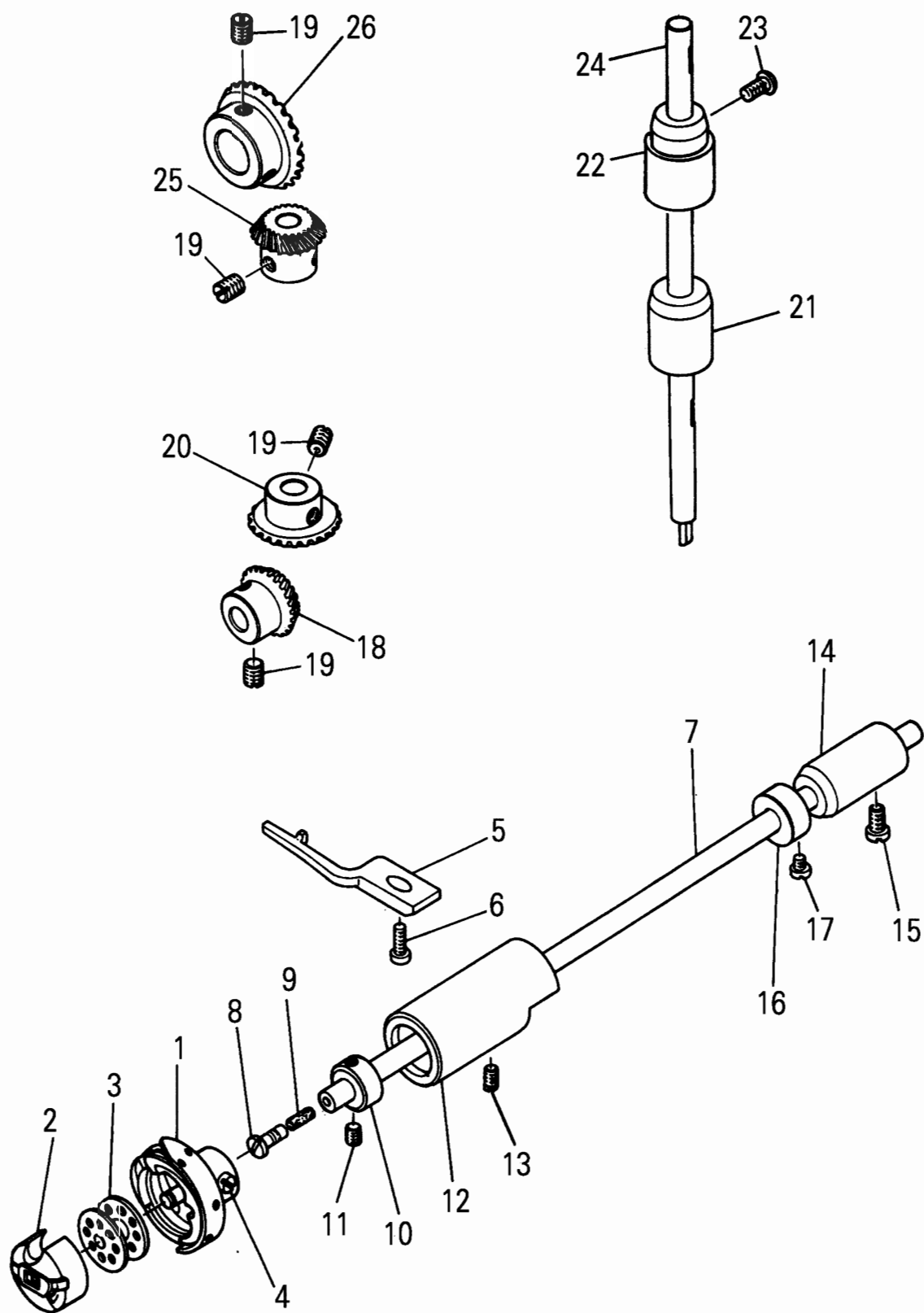
4.Presser Bar & Tension Release components

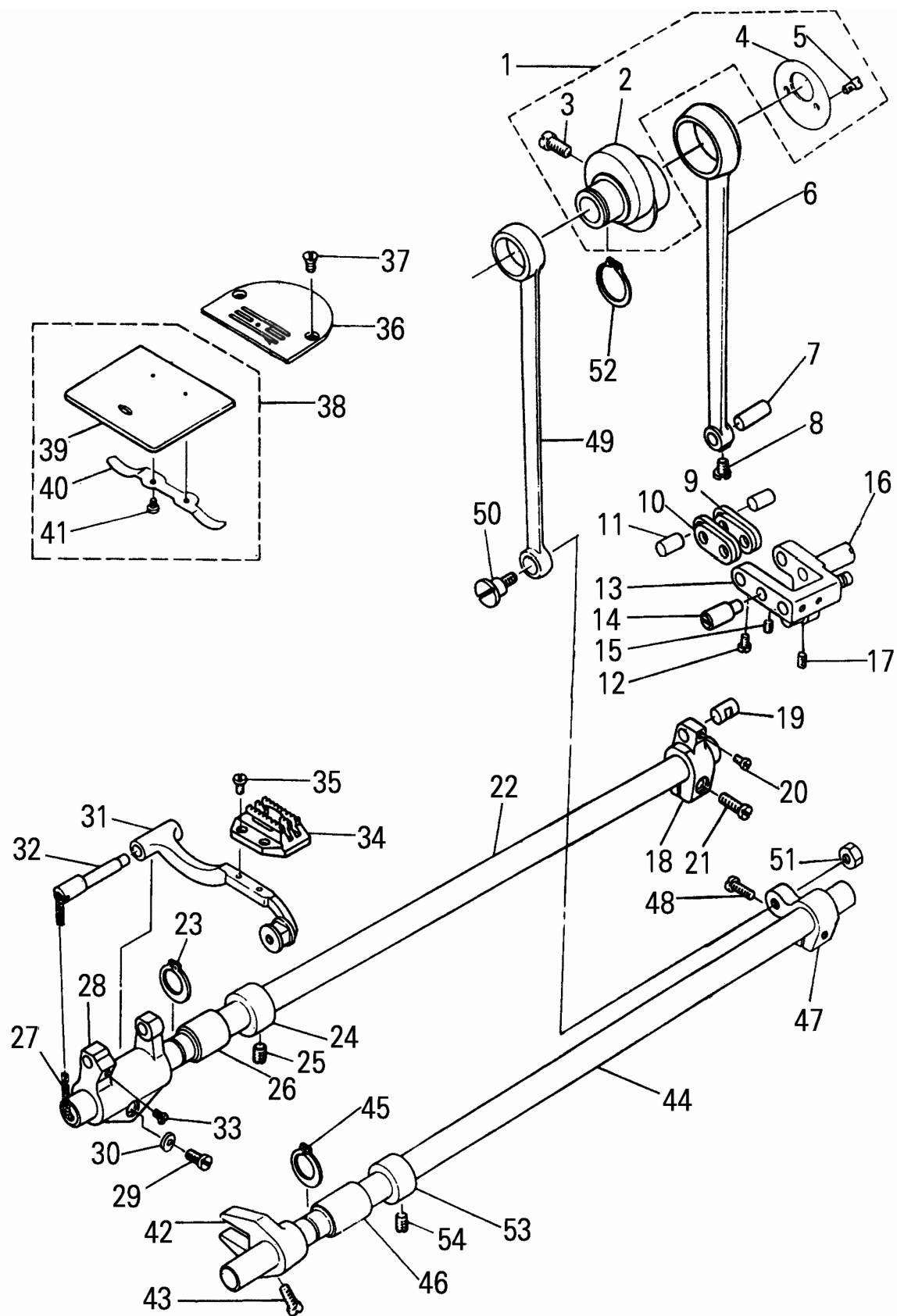
Ref.No.	Part No.	Description	Qty.
1	GS0553	Presser spring regulator	1
2	GL18	Nut 1/2-28	1
3	GR1494	Presser guide bar	1
4	GW253	Presser spring	1
5	GZ275	Presser bar	1
6	GR3358	Needle bar guide bracket	1
7	GS033	Screw 1/4-40 L=8	1
8	GR3359	Presser bar thread guide	1
9	GS0100	Screw 9/64-40 L=8.5	2
10	GO273	Presser bar bushing, lower	1
11	GM214/5	Presser foot asm	1
12	GS020	Screw 9/64-40 L=10.5	1
13	GR3360	Hand lifter	1
14	GS0554	Screw 9/64-40 L=9.5	1
15	GR3361	Hand lifter cam asm	1
16	GR1503	Rubber ring	1
17	GR3363	Lifting lever	1
18	GR3364/3	Hand lifter link asm	1
19	GS0161	Link shaft	2
20	GR2053	Gasket	2
21	GR1510	Snap ring	3
22	GR3366	Lifting lever ring	1
23	GR3367	Tension release plate	1
24	GS0162	Tension release shaft	1
25	GR2035	Gasket	1
26	GR1510	Snap ring	2
27	GW433	Tension release return spring	1
28	GR3368	Lifting lever connecting rod	1
29	GR1510	Snap ring	1
30	GR3369	Lifting lever link	1
31	GS0557	Hinge screw	1
32	GS0558	Hinge screw	1
33	GR3370	Connecting rod vertical	1
34	GR2416	Wire cable	1
35	GR2418	Wire tube	1
36	GS078	Set screw	1
37	GL19	Nut	2
38	GR2419	Wire holder bracket (upper)	1
39	GR2420	Wire holder	1
40	GS080	Screw 11/64-40 L=7	1
41	GS0551	Screw 3/16-28 L=6	1
42	GR2422	Wire cable holder	1
43	GS0551	Screw 3/16-28 L=6	1
44	GR2422	Wire holder bracket (lower)	1
45	GR2420	Wire holder	1
46	GS010	Screw 11/64-40 L=5	1

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5.Hook Driving Shaft components

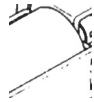
Ref.No.	Part No.	Description	Qty.
1	GN177	Hook asm	1
2	GN162	Bobbin case asm	1
3	GN163 →	Bobbin <i>S.V.O. 235</i>	1
4	GS029	Screw	2
5	GR1685	Position finger	1
6	GS030	Screw 11/64-40 L=9.5	1
7	GZ434	Hook driving shaft	1
8	GS031	Oil seal screw asm	1
9	GR1515	Oil wick	1
10	GR3372	Thrust collar	1
11	GS032	Screw 11/64-28 L=3.5	2
12	GO468	Bushing front	1
13	GS0559	Screw 15/64-28 L=4	1
14	GO470	Bushing rear	1
15	GS053	Screw 12/64-28 L=9	1
16	GR1519	Thrust collar asm	1
17	GS082	Screw 11/64-28 L=4.8	2
18	GC165	Pinion asm.	1
19	GS033	Screw 1/4-40 L=8	8
20	GC166	Gear asm. large	1
21	GO471	Upright shaft bushing, lower	1
22	GO472	Bushing, upper	1
23	GS053	Screw 12/64-28 L=9	1
24	GZ435	Upright shaft	1
25	GC167	Pinion asm	1
26	GC168	Gear asm	1





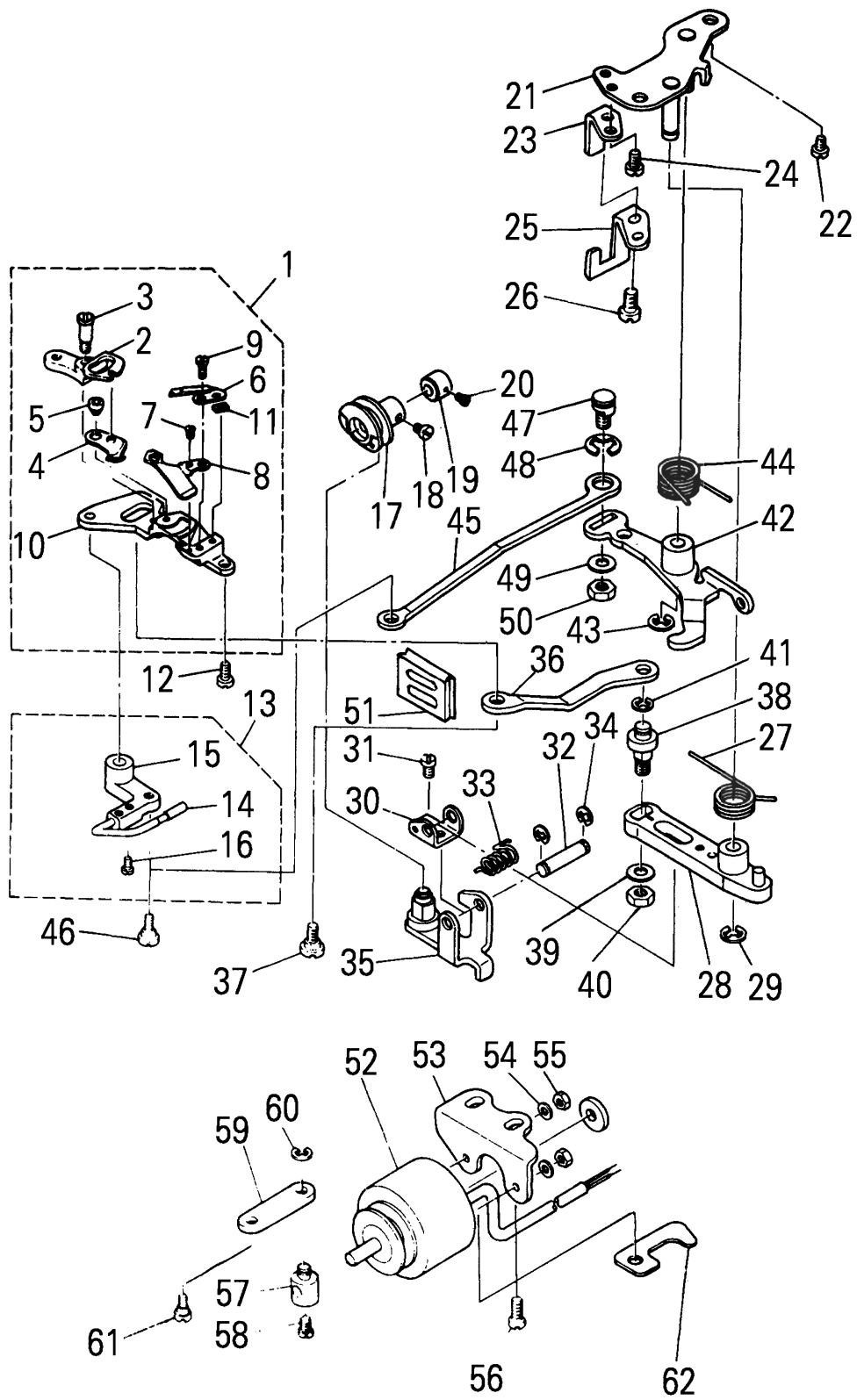
7.Feed Regulating components

Ref.No.	Part No.	Description	Qty.
1	GR3429	Feed dial	1
2	GS0563	Screw 3/16-28 L=18	1
3	GS0167	Feed regulator screw	1
4	GR3383	Rubber ring	1
5	GX576	Pin	1
6	GW257	Spring	1
7	GR3384	Feed regulator	1
8	GO474	Feed regulator bushing	1
9	GS0565	Screw	1
10	GX577	Feed regulator pin	1
11	GS011	Screw 9/64-40 L=6	1
12	GH453	Feed regulator connecting rod	1
13	GR1510	Snap ring	1
14	GZ438	Feed reverse shaft	1
15	GR3385	Rubber ring	1
16	GO475	Feed lever metal	1
17	GR3386	Reverse feed control lever	1
18	GS050	Screw 1/4-40 L=10	1
19	GS033	Screw 1/4-40 L=8	1
20	GR2428	Reverse feed lever stopper	1
21	GS0222	Screw 3/16-28 L=18	1
22	GH574/2	Feed reverse arm asm	1
23	GS0566	Feed reverse arm screw	1
24	GW435	Feed reverse spring	1
25	GR3387	Feed spring hook	1
26	GR3388	Adjusting link spring guide	1
27	GS0567	Screw 11/64-40 L=5	1
28	GW436	Adjusting link spring	1
29	GD305	Reverse feed magent asm	1
30	GS0223	Screw 15/64-28 L=12	1
31	GX419	Plunger arm pin	1
32	GR1717	Snap ring	1
33	GR1695	Rubber plunger	1
34	GR2429	Washer	1
35	GR1697	Snap ring	1
36	GH454	Reverse feed connecting link	1
37	GH455/3	Connecting arm asm	1
38	GR1717	Snap ring	1
39	GR1510	Snap ring	1
40	GR2402	Snap ring	1
41	GR2430	Reverse feed connecting shaft	1
42	GR1510	Snap ring	1
43	GR2432	Reverse feed switch base	1
44	GS053	Screw 3/16-28 L=9	1
45	GD306	Reverse feed switch	1
46	GR2433	Reverse feed switch plate	1
47	GS571	Screw M3 × 16	1
48	GX422	Reverse feed switch shaft	1
49	GW333	Reverse feed switch spring	1
50	GS0224	Screw	1
51	GR2434/2	Reverse feed switch lever	1
52	GR2436	Reverse feed switch lever	1
53	GS81	Screw 11/64-40 L=6	1



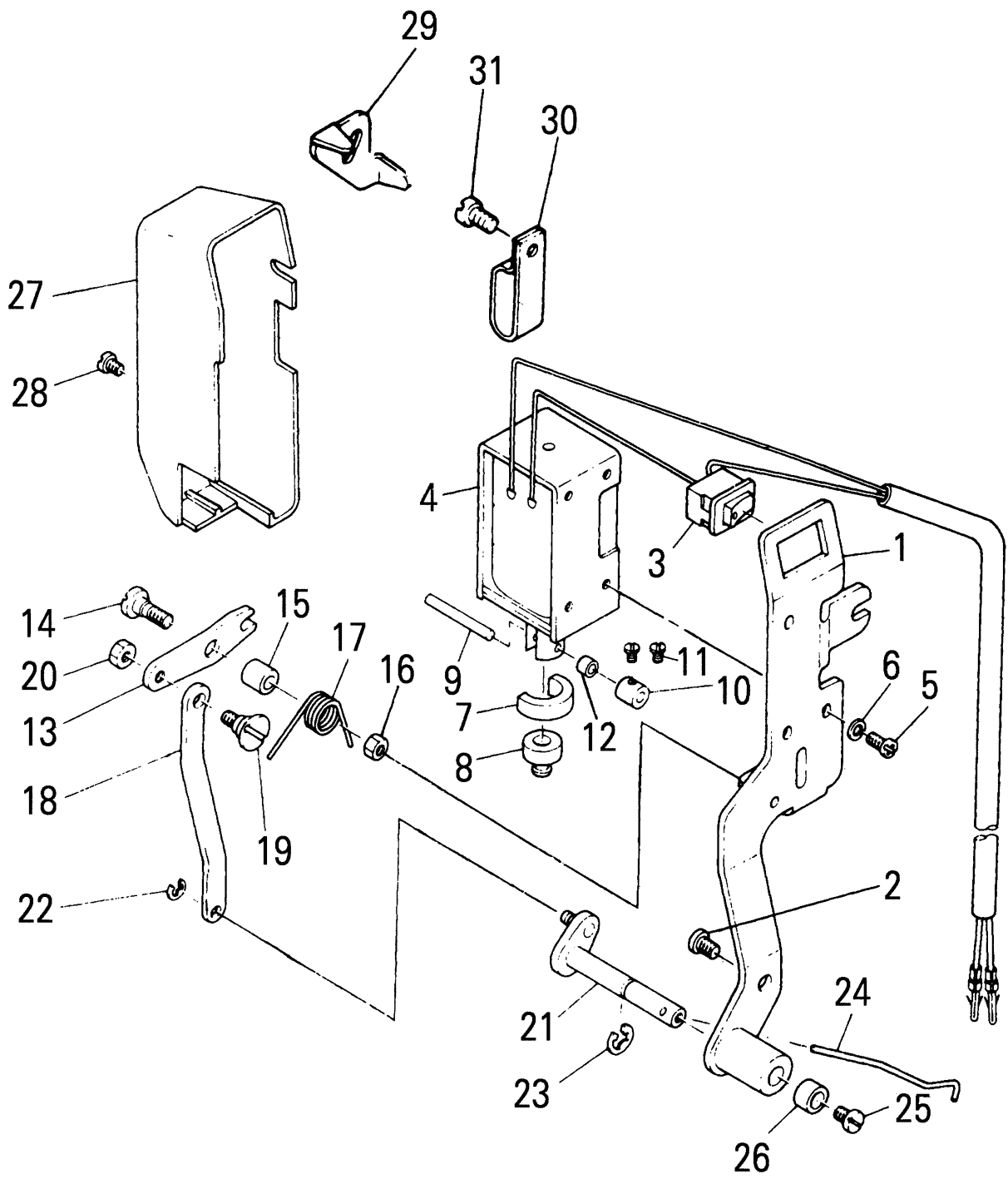
8.Thread Trimmer components

Ref.No.	Part No.	Description	Qty.
1	GR2437/11	Knife unit	1
2	GH457	Forked base for knife	(1)
3	GS093	Hinge screw	(1)
4	GR2438/2	Moving knife asm	(1)
5	GS0225	Moving knife hinger screw	(1)
6	GR1705	Counter knife	(1)
7	GS072	Screw 1/8-44 L=6	(2)
8	GR1706	Thread guide for knife	(1)
9	GS095	Screw 3/32-56 L=2.3	(1)
10	GR2440	Knife mounting base	(1)
11	GR1708	Counter knife spacer	(1)
12	GS81	Screw 11/64-40 L=7	1
13	GR2441/4	Picker arm asm	1
14	GR2442/4	Thread take-up picker asm	(1)
15	GH458	Picker arm	(1)
16	GS096	Screw 9/64-40 L=5	(2)
17	GT172	Thread trimmer cam asm	1
18	GS0226	Screw 1/4-40 L=6	2
19	GR2444	Cam collar asm	1
20	GS032	Screw 11/64-40 L=4.5	1
21	GR2445/3	Base plate asm	1
22	GS062	Screw 15/64-28 L=9	2
23	GR2447/2	Driving arm stopper asm	1
24	GS81	Screw 11/64-40 L=7	1
25	GR2450	Driving arm stopper asm	1
26	GS81	Screw 11/64-40 L=7	1
27	GW334	Clutch spring	1
28	GH459/2	Clutch plate asm	1
29	GR1507	Snap ring	1
30	GR2451	Roller arm bracket	1
31	GS0560	Screw 9/64-40 L=6	1
32	GX426	Roller fulcrum shaft	1
33	GW335	Roller return spring	1
34	GR1717	Snap ring	2
35	GR2452/4	Roller arm asm	1
36	GR2456	Moving knife link	1
37	GS0227	Screw	1
38	GX428	Moving knife link pin	1
39	GR1599	Washer	1
40	GL21	Nut	1
41	GR1510	Snap ring	1
42	GR2457/2	Clutch plate asm	1
43	GR1507	Snap ring	1
44	GW336	Clutch spring	1
45	GR2460	Picker link	1
46	GS022	Hinger screw	1
47	GX429	Picker link prin	1
48	GR2461	Snap ring	1
49	GR1599	Washer	1
50	GL21	Nut	1
51	GR2462	Oil shield plate	1
52	GD307	Thread trimmer solenoid	1
53	GR2463	Solenoid base	1
54	GR1672	Washer	2
55	GL110	Nut	2
56	GS0223	Screw 15/64-28 L=12	2
57	GR2464	Solenoid pin	1
58	GS81	Screw 11/64-40 L=7	1
59	GR1510	Snap ring	1
60	GR2465	Clutch link	1
61	GS0228	Hinge screw	1
62	GR3400	Tube holder	1



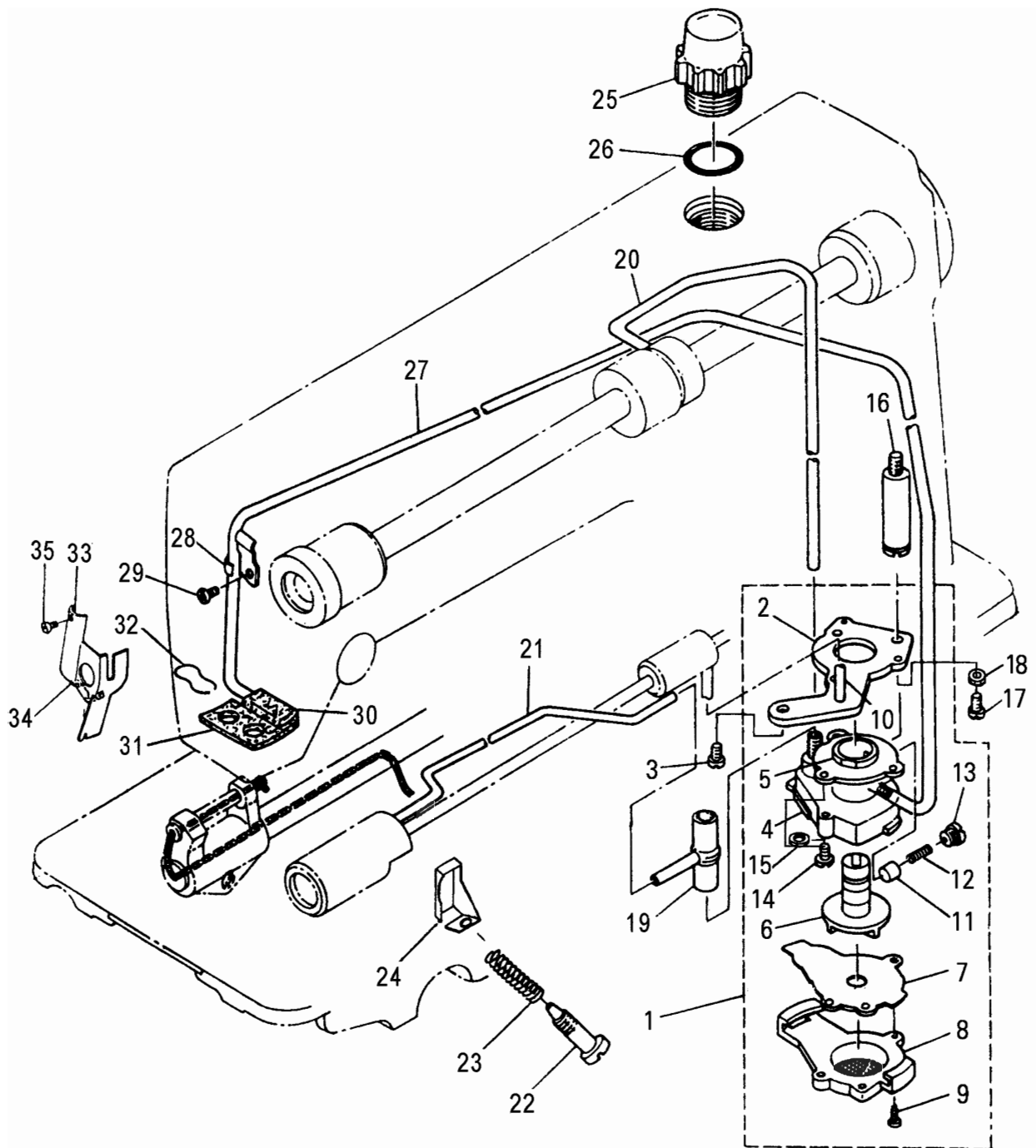
9.Wiper components

Ref.No.	Part No.	Description	Qty.
1	GR2466/2	Wiper base asm	1
2	GS053	Screw 3/16-28 L=9	1
3	GD308	Power source switch asm	1
4	GD309	Wiper solenoid	1
5	GS304	Screw M3 × 0.5 L=6	3
6	GD254	Spring washer	3
7	GR2468	Wiper rubber	1
8	GR2469	Wiper rubber	1
9	GX430	Wiper solenoid pin	1
10	GR2470	Thrust collar asm	1
11	GS0229	Screw 1/8-44 L=2.5	2
12	GR2471	Wiper link collar	1
13	GR2472	Wiper link	1
14	GS0230	Hinge screw	1
15	GR2473	Wiper hinge screw collar	1
16	GL31	Nut	1
17	GW337	Wiper spring	1
18	GR2474	Connecting Link	1
19	GS0231	Wiper link hinge screw	1
20	GL48	Nut	1
21	GZ344/3	Wiper driving shaft asm	1
22	GR1662	Snap ring	1
23	GR1510	Snap ring	1
24	GR2475	Wiper	1
25	GS0232	Screw 9/64-40 L=5	1
26	GR2476	Bracket installing collar	1
27	GK203	Wiper cover	1
28	GS304	Screw M3 × 0.5 L=6	1
29	GR2447	Cord holder	1
30	GR1721	Cord holder	1
31	GS053	Screw 3/16-28 L=9	1



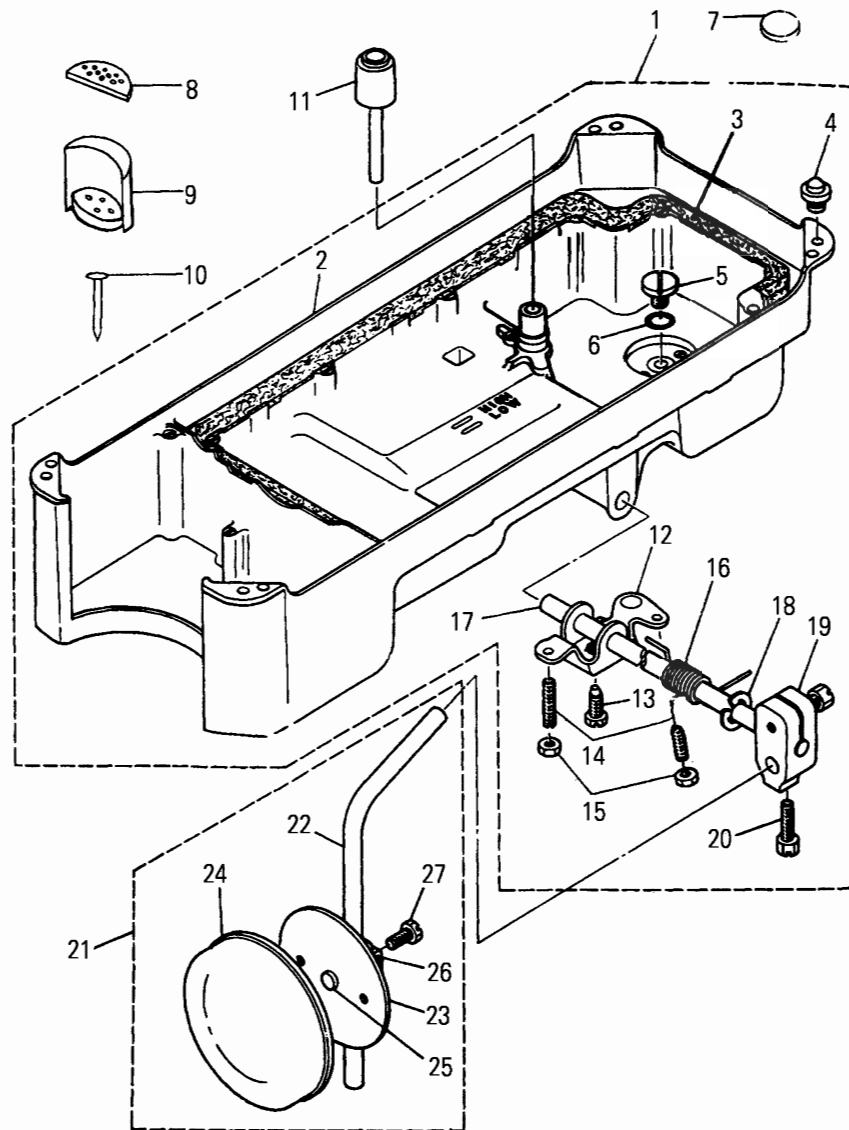
10.Lubrication components

Ref.No.	Part No.	Description	Qty.
1	GR3389/12	Lubricating oil pump asm	1
2	GR3390	Oil pump installing base	(1)
3	GS0568	Screw 15/64-28 L=8	(3)
4	GR3391	Oil pump	(1)
5	GO476	Oil pump bushing	(1)
6	GR3392	Oil pump impeller	(1)
7	GR3393	Oil pump impeller cover	(1)
8	GR3394	Lubricating oil pump cover	(1)
9	GS554	Screw	(3)
10	GR3395	Hook driving shaft oil tube	(1)
11	GR3396	Plunger	(1)
12	GW437	Plunger spring	(1)
13	GS0569	Plunger screw	(1)
14	GS062	Screw	(1)
15	GR2478	Washer	1
16	GS0233	Oil pump support	1
17	GS030	Screw 11/64-40 L=9.5	1
18	GR2479	Washer	1
19	GR3397	Rubber joint	1
20	GR3398	Main shaft oil tube	1
21	GR3399	Oil tube	1
22	GS054	Oil adjusting screw	1
23	GW259	Spring	1
24	GK204	Oil shield guard	1
25	GR2480	Oil sight window	1
26	GR1562	Rubber ring	1
27	GR3401	Oil return tube	1
28	GR1566	Oil return tube holder	1
29	GS81	Screw 3/16-28 L=6	1
30	GR1567	Anti-dust oil felt	1
31	GR1568	Oil felt	1
32	GR1569	Oil felt presser	1
33	GR3403	Arm oil shield	1
34	GR3404	Oil wick	1
35	GS44	Screw 1/8-44 L=4	1



11.Oil Reservoir & Knee Lifter components

Ref.No.	Part No.	Description	Qty.
1	GR3405/17	Oil reservoir asm	1
2	GR3406	Oil reservoir	(1)
3	GR3407	Gasket	(1)
4	GR3408	Rubber cushion	(4)
5	GSO2	Screw	(2)
6	GR1575	Rubber ring	(2)
7	GR1576	Oil reservoir magnet	1
8	GR1578	Oil reservoir felt cushion	2
9	GR1736	Oil reservoir rubber cushion	1
10	GBX105	Nail	4
11	GX579	Knee press lifter rod	1
12	GH576	Connecting rod, vertical	1
13	GS056	Screw 15/64-28 L=6	1
14	GS057	Screw 15/64-28 L=30	2
15	GL21	Nut 15/64-28	2
16	GW438	Spring	1
17	GZ439	Knee press rod	1
18	GR1583	Snap ring	1
19	GR3401	Bearing bracket	1
20	GS059	Screw 9/32-20 L=20	2
21	GR3411/6	Knee press plate asm.	1
22	GZ440	Knee lifter plate rod	1
23	GR3412	Knee press plate	1
24	GKR13	Knee press plate cover	1
25	GR3413	Rubber	1
26	GR3414	Knee press plate holder	1
27	GS584	Screw M6 × 12	1



12. Machine Head Accessories (1)

Ref.No.	Part No.	Description	Qty.
1	GR1509/2	Machine hinge plate asm	2
2	GR1593	Machine hinge plate	2
3	GBX105	Nail	4
4	GK195	Belt cover	1
5	GK196	Belt cover	1
6	GS0173	Screw 5/16-24 L=14	1
7	GR2481	Washer	2
8	GR2482	Belt cover rubber cushion	2
9	GR2483/2	Belt cover collar asm.	2
10	GS0575	Belt cover support	1
11	GS0193	Screw 3/16-28 L=6	1
12	Cat.1955-01 #14	Needle	3
13	GR1610	Screw driver, large	1
14	GR1602	Screw driver, medium	1
15	GR1603	Screw driver, small	1
16	GR749	Wrench	1
17	GR544	Double-head wrench	1
18	GN163 →	Bobbin <i>S.Y.O.2.3.5</i>	3
19	GF424	Machine head cover	1
20	GBR148	Machine rest pin	1
21	GR1604/3	Oil reservoir asm.	1

13.Accessories (2)

Ref.No.	Part No.	Description	Qty.
1	GR3419	Bobbin winder base asm	1
2	GR3420	Thread winder base asm	1
3	GP167	Thread winder asm	1
4	GS013	Screw	1
5	GZ284	Bobbin winder shaft	1
6	GR3421	Connecting rod	1
7	GX347	Connecting rod pin	1
8	GR3422	Bobbin winder frame rod	1
9	GX347	Bobbin winder frame rod pin	1
10	GS063	Screw 1/8-44 L=12.5	1
11	GX348	Bobbin winder frame pin	1
12	GW263	Bobbin winder frame spring	1
13	GR1613	Rubber brake	1
14	GR3423	Presser plate	1
15	GS064	Screw 11/64-40 L=3	1
16	GW439	Bobbin winder spring	1
17	GS065	Hinger screw	1
18	GR3425	Thread tension bracket asm	1
19	GS0577	Screw	1
20	GR1617	Bobbin winder tension disc collar	1
21	GR1488	Tension disc	2
22	GW265	Tension spring	1
23	GL22	Thread tension stud nut	1
24	GS0578	Screw 11/64-40 L=7.8	1
25	GBS120	Wood screw	2
26	GBR147	Washer	2
27	GR1744	Spool rest rod rubber cap	1
28	GZ315	Spool rest rod (lower)	1
29	GZ316	Spool rest rod (upper)	1
30	GR1932	Spool rested joint	1
31	GR1825	Thread guide asm.	2
32	GR1745	Thread guide arm joint	2
33	GS558	Screw	2
34	GR1748	Thread guide ring	2
35	GS067	Spool pin	2
36	GR1625	Spring washer	2
37	GR1626	Washer	2
38	GL23	Nut	2
39	GR1811	Spool rest	2
40	GR1215	Spool vibration stopper	2
41	GR1696	Washer	2
42	GR1751	Spring washer	1
43	GL158	Nut	2
44	GR1753	Rubber washer	2

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