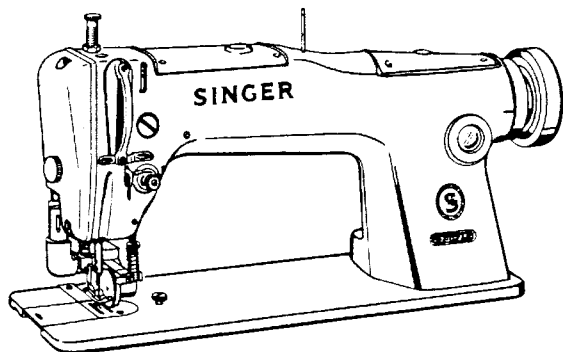
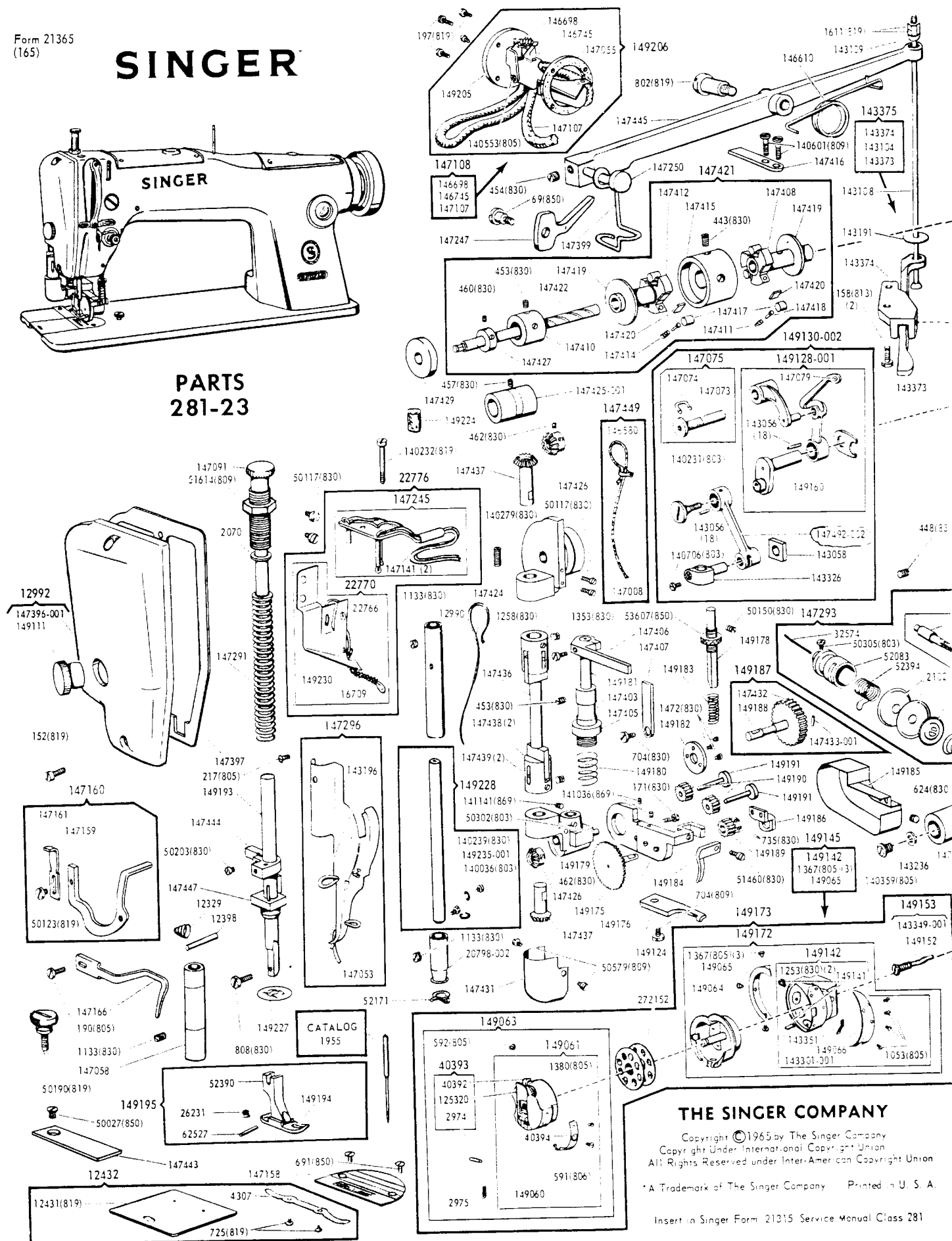


# SINGER



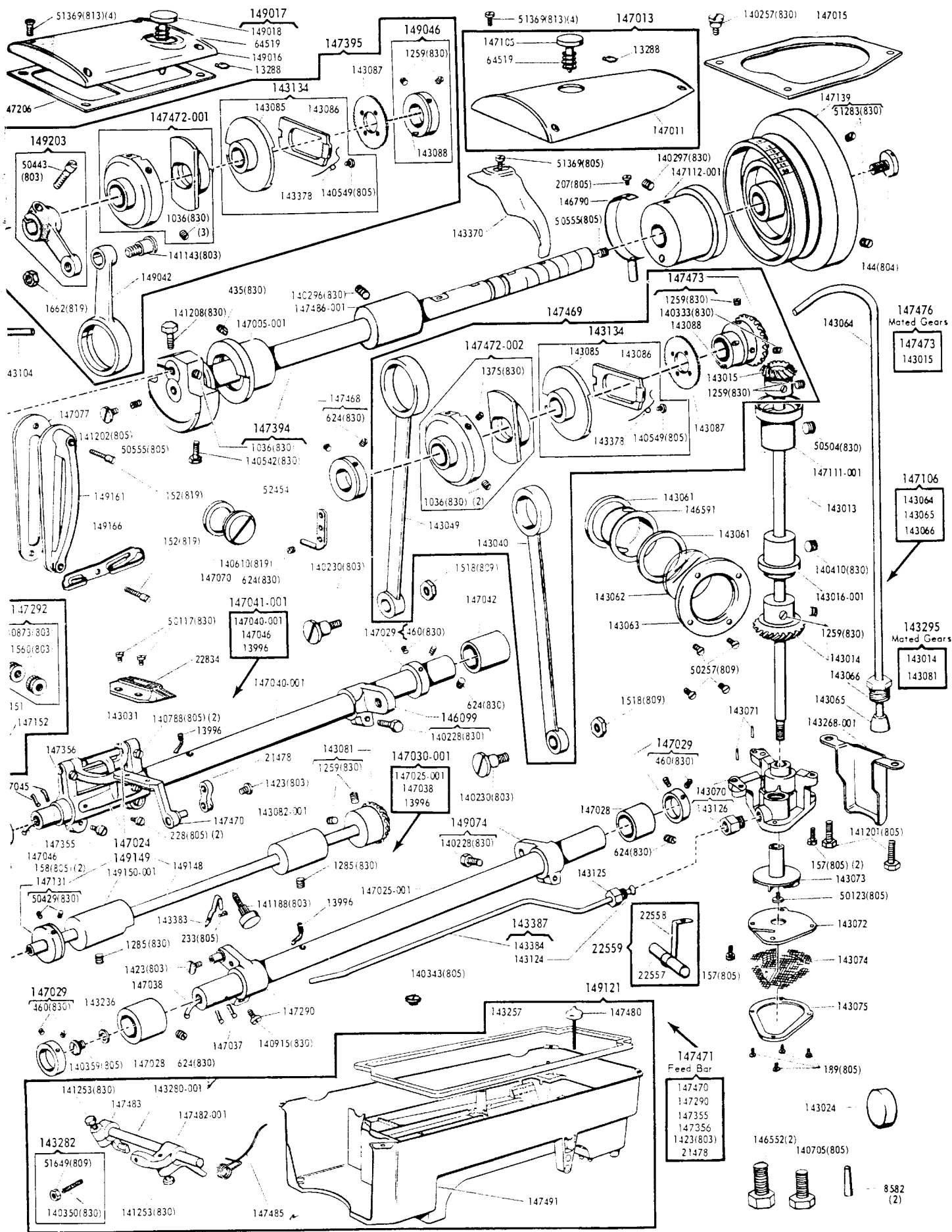
## PARTS 281-23



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Insert in Singer Form 21315 Service Manual Class 281



# NUMERICAL LIST OF PARTS FOR 281-23 MACHINE

| NUMBER   | DESCRIPTION             | NUMBER    | DESCRIPTION             | NUMBER     | DESCRIPTION            |
|----------|-------------------------|-----------|-------------------------|------------|------------------------|
| 69(850)  | Presser Bar Lifter      | 624(830)  | Feed Rock Shaft         | 1662(819)  | Feed (side) Wheel      |
| 144(804) | Hinge Screw             |           | Bushing (back) Set      |            | Eccentric Connecting   |
|          | Arm Shaft (horizontal)  | 624(830)  | Screw                   | 2070       | Rod Hinge Screw Nut    |
| 152(819) | Screw (back)            |           | Feed Lifting Rock       |            | Presser Bar Spring     |
|          | Thread Take-up Lever    |           | Shaft Bushing (front)   |            | Washer                 |
|          | Guard Screw (upper)     |           | Set Screw               | 2102       | Tension Disc(2)        |
| 152(819) | Thread Take-up Lever    | 624(830)  | Arm Shaft (horizontal)  | 2974       | Rotating Hook          |
|          | Guard and Thread        |           | Thrust Collar Set       |            | Bobbin Case Latch      |
|          | Eyelet and Thread       |           | Screw(2)                |            | Lever Fulcrum Pin      |
|          | Guard Screw (front of   | 691(850)  | Throat Plate Screw(2)   | 2975       | Rotating Hook          |
|          | Arm)                    | 704(803)  | Feed (side) Wheel       |            | Bobbin Case Latch      |
| 152(819) | Face Plate Screw(2)     |           | Bracket Holder Shaft    |            | Spring                 |
| 157(805) | Magnet Retaining        |           | Guide Bracket Holder    | 4307       | Bed Slide Spring       |
|          | Clamp and Oil Pump      |           | Screw                   | 8582       | Arm Dowel Pin(2)       |
|          | (centrifugal) Body      | 704(809)  | Rotating Hook Bobbin    | 12329      | Tension Releasing      |
|          | Screw                   |           | Case Holder Position    |            | Lever Spring           |
| 157(805) | Oil Pump (centrifugal)  |           | Bracket Screw           | 12398      | Tension Releasing      |
|          | Body Screw              | 725(819)  | Bed Slide Spring        |            | Lever Hinge Pin        |
| 158(805) | Feed Bar Carrier        |           | Screw(2)                | 12431(819) | Bed Slide              |
|          | Clamping Screw (2)      | 735(830)  | Feed (side) Wheel       | 12432      | Bed Slide complete,    |
| 158(813) | Bell Crank Bracket      |           | Spur Gear (front) Set   |            | Nos. 4307, 12431(819)  |
|          | Screw(2)                |           | Screw(2)                |            | and two 725(819)       |
| 171(830) | Feed (side) Wheel       | 802(819)  | Presser Bar and Feed    | 12990      | Needle Bar Bushing     |
|          | Gear Cover and Wheel    |           | (side) Wheel Lifting    |            | (upper)                |
|          | Position Bracket        |           | Lever Hinge Screw       | 12992      | Face Plate 147396-001  |
|          | Screw(2)                | 808(830)  | Presser Foot Screw      |            | with 149111            |
| 189(805) | Oil Pump (centrifugal)  | 1036(830) | Feed Eccentric Body     | 13288      | Arm Top Cover (front)  |
|          | Screen Frame Screw(4)   |           | Set Screw(2)            |            | Stitch Regulator       |
| 190(805) | Slack Thread            | 1036(830) | Feed (side) Wheel       |            | Plunger Spring         |
|          | Regulator Screw         |           | Eccentric Set Screw(3)  |            | Stop Ring              |
| 197(819) | Oil Removing Wick       | 1036(830) | Thread Take-up Crank    | 13288      | Arm Top Cover (back)   |
|          | (head end) Hinge        |           | Set Screw               |            | Stitch Regulator       |
|          | Plate and Cover         | 1053(805) | Rotating Hook Thread    |            | Plunger Stop Ring      |
|          | Screw(4)                |           | Guard Screw(4)          | 13996      | Feed Rock Shaft Oil    |
| 207(805) | Arm Shaft (horizontal)  | 1133(830) | Presser Bar Bushing     |            | Wick                   |
|          | Flanged Bushing         |           | (lower) Set Screw       | 13996      | Feed Lifting Rock      |
|          | (back) Oil Sump Tube    | 1133(830) | Needle Bar Bushing      |            | Shaft Oil Wick         |
|          | Holder Screw            |           | (upper) Set Screw       | 16709      | Arm Side Shield        |
| 217(805) | Thread Take-up Lever    | 1133(830) | Needle Bar Bushing      |            | Wick Spring Holder     |
|          | Oil Guard Screw         |           | (lower) Set Screw       | 20798-002  | Needle Bar Bushing     |
| 228(805) | Feed Bar Carrier Oil    | 1253(830) | Rotating Hook Set       |            | (lower)                |
|          | Wick Holder Screw       |           | Screw(2)                | 21478      | Feed Bar Connecting    |
|          | (2)                     | 1258(830) | Feed (side) Wheel       |            | Link                   |
| 233(805) | Rotating Hook Oil       |           | Driving Shaft (upright) | 22557      | Magnet (for removing   |
|          | Flow Regulating         |           | Driving Collar Set      |            | iron particles from    |
|          | Thumb Screw Spring      |           | Screw(4)                |            | oil)                   |
|          | Screw                   | 1259(830) | Arm Shaft (upright)     | 22558      | Magnet Retaining       |
| 435(830) | Thread Take-up Lever    |           | Bevel Gear (upper)      |            | Clamp                  |
|          | Link Hinge Stud Set     |           | Set Screw(2)            | 22559      | Magnet Retaining       |
|          | Screw                   | 1259(830) | Feed Lifting            |            | Clamp 22558 with       |
| 435(830) | Arm Shaft (horizontal)  |           | Eccentric Set Screw     |            | 22557                  |
|          | Flanged Bushing (front) | 1259(830) | Arm Shaft (upright)     | 22766      | Arm Side Shield Wick   |
|          | Set Screw               |           | Bevel Gear (lower)      |            | (16 in. long)          |
| 443(830) | Feed (side) Wheel       |           | Set Screw(2)            | 22770      | Arm Side Shield        |
|          | Clutch Body Set         | 1259(830) | Rotating Hook Shaft     |            | complete, Nos.         |
|          | Screw(2)                |           | Bevel Gear Set          |            | 16709, 22766 and       |
| 448(830) | Thread Take-up Spring   |           | Screw(2)                |            | 149230                 |
|          | Regulator Set Screw     | 1259(830) | Feed (side) Wheel       | 22776      | Arm Side Shield and    |
| 453(830) | Feed (side) Wheel       |           | Feed Regulating         |            | Oil Wick Holder Nos.   |
|          | Bracket Holder Shaft    |           | Locking Slide           |            | 22770 and 147245       |
|          | Bushing Set Screw       |           | Ratchet Wheel           | 22834      | Feed Dog (20 teeth     |
| 453(830) | Feed (side) Wheel       |           | Retaining Collar Set    |            | to the inch)           |
|          | Clutch (brake)          |           | Screw(2)                | 26231      | Presser Foot Spring    |
|          | Bushing Set Screw(2)    | 1285(830) | Rotating Hook Shaft     | 32574      | Tension Releasing      |
| 454(830) | Presser Bar and Feed    |           | Bushing (front) Set     |            | Pin                    |
|          | (side) Wheel Lifting    |           | Screw                   | 40392      | Rotating Hook Bobbin   |
|          | Lever Pin Set Screw     | 1285(830) | Rotating Hook Shaft     |            | Case Latch             |
| 457(830) | Feed (side) Wheel       |           | Bushing (back) Set      | 40393      | Rotating Hook Bobbin   |
|          | Clutch Shaft Arm        |           | Screw                   |            | Case Latch Hinge,      |
|          | Bushing (rear) Set      | 1353(830) | Feed (side) Wheel       |            | Nos. 2974, 40392 and   |
|          | Screw                   |           | Bracket Holder          |            | 125320                 |
| 460(830) | Feed Lifting Rock       |           | Shaft Guide Bracket     | 40394      | Rotating Hook          |
|          | Shaft Collar Set        |           | Clamping Screw          |            | Bobbin Case Tension    |
|          | Screw(4)                | 1367(805) | Rotating Hook Section   |            | Spring                 |
| 460(830) | Feed Rock Shaft         |           | Screw(3)                | 50027(850) | Feed Roll Plate Screw  |
|          | Collar Set Screw(2)     | 1375(830) | Feed Eccentric Body     | 50117(830) | Feed Dog Screw(2)      |
| 460(830) | Feed (side) Wheel       |           | Position Screw          | 50117(830) | Arm Side Shield        |
|          | Clutch Shaft Collar     | 1380(805) | Rotating Hook Bobbin    |            | Screw(2)               |
|          | Set Screw(2)            |           | Case Tension Spring     | 50123(819) | Tension Releasing      |
| 462(830) | Feed (side) Wheel       |           | Screw                   |            | Lever (adjustable)     |
|          | Clutch Shaft Bevel      | 1423(803) | Feed Bar Connecting     |            | Screw                  |
|          | Gear Set Screw(2)       |           | Link Cap Screw(2)       | 50123(805) | Oil Pump (centrifugal) |
| 462(830) | Feed (side) Wheel       | 1472(850) | Feed (side) Wheel       |            | Impeller Locking       |
|          | Driving Shaft           |           | Bracket Position        |            | Screw                  |
|          | (horizontal) Bevel      |           | Plate Screw(3)          | 50150(830) | Feed (side) Wheel      |
|          | Gear Set Screw(2)       | 1518(809) | Feed Lifting Rock       |            | Bracket Guide Set      |
| 591(806) | Rotating Hook Bobbin    |           | Shaft Connecting        |            | Screw                  |
|          | Case Tension            |           | Rod Hinge Screw Nut     | 50190(819) | Guide Thumb Screw      |
|          | Regulating Screw        | 1518(809) | Feed Rock Shaft         | 50203(830) | Presser Bar Guide      |
| 592(805) | Rotating Hook           |           | Connecting Rod          |            | Bracket Clamping       |
|          | Bobbin Case Latch       |           | Hinge Screw Nut         |            | Screw                  |
|          | Stop Screw              | 1560(803) | Tension Regulating      | 50257(809) | Oil Flow Window Cap    |
|          |                         |           | Thumb Nut Lock Nut      |            | Screw(4)               |
| 624(830) | Feed Lifting Rock       | 1560(803) | Tension Regulating      | 50302(803) | Feed (side) Wheel      |
|          | Shaft Bushing (back)    |           | Thumb Nut               |            | Bracket Stop Screw     |
|          | Set Screw               | 1611(819) | Presser Bar and Feed    |            | Tension Stud Set       |
| 624(830) | Feed Rock Shaft         |           | (side) Wheel Lifting    |            | Screw                  |
|          | Bushing (front) Set     |           | Lever Connecting Rod    | 50429(830) | Rotating Hook Shaft    |
|          | Screw                   |           | Nut Lock Nut            |            | Oil Sling Set Screw(2) |
| 624(830) | Thread Retainer         | 1611(819) | Presser Bar and Feed    | 50443(830) | Feed (side) Wheel      |
|          | Set Screw               |           | (side) Wheel Lifting    |            | Clutch Shaft Driving   |
|          |                         |           | Lever Connecting Rod    |            | Crank Clamping Screw   |
|          |                         |           | Nut                     |            |                        |

Numerical List of Parts for 281-23 Machine

| NUMBER      | DESCRIPTION                                                                     | NUMBER                                                                                                                                                                        | DESCRIPTION                                                                          | NUMBER                                                                                                                                                                                                                 | DESCRIPTION                                                                                               |
|-------------|---------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------|
| 50504(830)  | Arm Shaft (upright)<br>Bushing (upper) Set<br>Screw                             | 140549(805)                                                                                                                                                                   | Feed (side) Wheel<br>Feed Regulator<br>Locking Slide<br>Spring Screw                 | 143058                                                                                                                                                                                                                 | Needle Bar<br>Connecting Stud<br>Slide Block                                                              |
| 50555(805)  | Arm Shaft (horizontal)<br>Plug Screw(2)                                         | 140549(805)                                                                                                                                                                   | Stitch Regulator<br>Locking Slide Spring<br>Screw                                    | 143061                                                                                                                                                                                                                 | Oil Flow Body<br>Gasket(2)                                                                                |
| 50579(809)  | Feed (side) Wheel<br>Driving Shaft<br>(horizontal) Bevel<br>Gear Cover Screw(2) | 140553(805)                                                                                                                                                                   | Oil Removing Wick<br>(head end) Holder<br>Body Hinge Screw                           | 143062                                                                                                                                                                                                                 | Oil Flow Window                                                                                           |
| 51283(830)  | Machine Pulley Set<br>Screw(2)                                                  | 140601(809)                                                                                                                                                                   | Feed (side) Wheel<br>Clutch Position<br>Bracket Screw(2)                             | 143063                                                                                                                                                                                                                 | Oil Flow Window Cap                                                                                       |
| 51369(805)  | Oil Lead Screw                                                                  | 140607(819)                                                                                                                                                                   | Arm Top Cover (front)<br>Stitch Regulator<br>Plunger Hole Plug<br>Screw              | 143064                                                                                                                                                                                                                 | Oil Pipe                                                                                                  |
| 51369(813)  | Arm Top Cover (back)<br>Screw(4)                                                | 140607(819)                                                                                                                                                                   | Arm Top Cover<br>(back) Stitch<br>Regulator Plunger<br>Hole Plug Screw               | 143065                                                                                                                                                                                                                 | Oil Pipe Clamping<br>Sleeve                                                                               |
| 51369(813)  | Arm Top Cover (front)<br>Screw(4)                                               | 140610(819)                                                                                                                                                                   | Thread Take-up<br>Crank Clamping<br>Screw Hole Plug<br>Screw                         | 143066                                                                                                                                                                                                                 | Oil Pipe Clamping<br>Sleeve Nut                                                                           |
| 51460(830)  | Feed (side) Wheel<br>Finger Guard Screw                                         | 140705(805)                                                                                                                                                                   | Arm Screw (back)                                                                     | 143070                                                                                                                                                                                                                 | Oil Pump (centrifugal)<br>Body with 143126                                                                |
| 51614(809)  | Pressure Regulating<br>Thumb Screw Lock<br>Nut                                  | 149706(830)                                                                                                                                                                   | Needle Bar<br>Connecting Stud<br>Clamping Screw                                      | 143071                                                                                                                                                                                                                 | Oil Pump (centrifugal)<br>Body Position Pin(2)                                                            |
| 51649(809)  | Knee Lifter Rock Shaft<br>Crank adjusting Screw<br>Lock Nut                     | 140788(805)                                                                                                                                                                   | Feed Bar Hinge Pin<br>Clamping Screw(2)                                              | 143072                                                                                                                                                                                                                 | Oil Pump (centrifugal)<br>Cover                                                                           |
| 52083       | Thread Take-up Spring<br>Regulator with<br>50305(803)                           | 140873(803)                                                                                                                                                                   | Tension Stud                                                                         | 143073                                                                                                                                                                                                                 | Oil Pump (centrifugal)<br>Impeller                                                                        |
| 52171       | Needle Bar Bushing<br>(lower) Thread<br>Eyelet                                  | 140915(830)                                                                                                                                                                   | Feed Lifting Rock<br>Shaft Crank (front)<br>Clamping Screw                           | 143074                                                                                                                                                                                                                 | Oil Pump (centrifugal)<br>Screen                                                                          |
| 52390       | Presser Foot Shank                                                              | 141036(869)                                                                                                                                                                   | Feed (side) Wheel<br>Spur Gear<br>(intermediate) Stud<br>Set Screw(2)                | 143075                                                                                                                                                                                                                 | Oil Pump (centrifugal)<br>Screen Frame                                                                    |
| 52394       | Thread Take-up Spring                                                           | 141141(869)                                                                                                                                                                   | Feed (side) Wheel<br>Bracket Holder<br>Set Screw(2)                                  | 143081                                                                                                                                                                                                                 | Rotating Hook Shaft<br>Bevel Gear (left<br>hand spiral) with<br>two 1259(830)                             |
| 52454       | Thread Retainer                                                                 | 141143(803)                                                                                                                                                                   | Feed (side) Wheel<br>Eccentric Connecting<br>Rod Hinge Screw                         | Note: To ensure<br>proper functioning of<br>Gears, No. 143081<br>will not be supplied<br>separately to Agencies,<br>but will be<br>substituted by Pair<br>of Gears No. 143295<br>Rotating Hook Shaft<br>Bushing (back) |                                                                                                           |
| 53607(850)  | Feed (side) Wheel<br>Bracket Pressure<br>Spring Adjusting<br>Nut                | 141188(803)                                                                                                                                                                   | Rotating Hook Oil<br>Flow Regulating<br>Thumb Screw                                  |                                                                                                                                                                                                                        |                                                                                                           |
| 62527       | Presser Foot Hinge<br>Pin                                                       | 141201(805)                                                                                                                                                                   | Arm and Bed Leg<br>(back) Screw(2)                                                   | 143082-001                                                                                                                                                                                                             | Feed (side) Wheel<br>Feed Regulator                                                                       |
| 64519       | Arm Top Cover<br>(front) Stitch<br>Regulator Plunger<br>Spring                  | 141202(805)                                                                                                                                                                   | Arm Shaft (horizontal)<br>Screw Plug (front)                                         | 143085                                                                                                                                                                                                                 | Stitch Regulator                                                                                          |
| 64519       | Arm Top Cover (back)<br>Stitch Regulator<br>Plunger Spring                      | 141208(830)                                                                                                                                                                   | Thread Take-up Crank<br>Clamping Screw                                               | 143085                                                                                                                                                                                                                 | Stitch Regulator                                                                                          |
| 125320      | Rotating Hook Bobbin<br>Case Latch Lever                                        | 141253(830)                                                                                                                                                                   | Knee Lifter Rock<br>Shaft Crank Clamping<br>Screw                                    | 143086                                                                                                                                                                                                                 | Stitch Regulator<br>Locking Slide                                                                         |
| 140036(803) | Needle Bar Thread<br>Guard Screw                                                | 141253(830)                                                                                                                                                                   | Knee Lifter Rock<br>Shaft Stop Dog<br>Clamping Screw                                 | 143086                                                                                                                                                                                                                 | Feed (side) Wheel<br>Feed Regulator<br>Locking Slide                                                      |
| 140228(830) | Feed Rock Shaft<br>Crank Clamping Screw                                         | 143013                                                                                                                                                                        | Arm Shaft (upright)                                                                  | 143087                                                                                                                                                                                                                 | Feed (side) Wheel<br>Feed Regulator<br>Locking Slide                                                      |
| 140228(830) | Feed Lifting Rock<br>Shaft Crank (back)<br>Clamping Screw                       | 143014                                                                                                                                                                        | Arm Shaft (upright)<br>Bevel Gear (lower)<br>right hand spiral with<br>two 1259(830) | 143087                                                                                                                                                                                                                 | Stitch Regulator<br>Locking Slide<br>Ratchet Wheel                                                        |
| 140230(803) | Feed Rock Shaft<br>Connecting Rod<br>Hinge Screw                                | Note: To ensure proper<br>functioning of Gears,<br>No. 143014 will not<br>be supplied separately<br>to Agencies, but will<br>be substituted by<br>Pair of Gears No.<br>143295 |                                                                                      | 143088                                                                                                                                                                                                                 | Stitch Regulator<br>Locking Slide<br>Ratchet Wheel Pin                                                    |
| 140230(803) | Feed Lifting Rock<br>Shaft Connecting<br>Rod Hinge Screw                        |                                                                                                                                                                               |                                                                                      | 143088                                                                                                                                                                                                                 | Feed (side) Wheel<br>Feed Regulator<br>Locking Slide<br>Ratchet Wheel Pin                                 |
| 140231(803) | Needle Bar<br>Connecting Link<br>Cap Screw                                      | 143015                                                                                                                                                                        | Arm Shaft (upright)<br>Bevel Gear (upper)<br>left hand spiral with<br>two 1259(830)  | 143104                                                                                                                                                                                                                 | Bell Crank Hinge Pin                                                                                      |
| 140232(819) | Oil Wick Holder<br>Screw                                                        | Note: To ensure proper<br>functioning of Gears,<br>No. 143015 will not<br>be supplied<br>separately to Agencies,<br>but will be<br>substituted by Pair<br>of Gears No. 147476 |                                                                                      | 143108                                                                                                                                                                                                                 | Presser Bar and Feed<br>(side) Wheel Lifting<br>Lever Connecting<br>Rod                                   |
| 140239(830) | Needle Set Screw                                                                |                                                                                                                                                                               |                                                                                      | 143109                                                                                                                                                                                                                 | Presser Bar and Feed<br>(side) Wheel Lifting<br>Lever Connecting Rod<br>Swivel                            |
| 140257(830) | Feed Eccentric<br>Stop Screw (5-1/2<br>stitch)                                  | 143016-001                                                                                                                                                                    | Arm Shaft (upright)<br>Bushing (lower)                                               | 143124                                                                                                                                                                                                                 | Oil Pipe Clamping<br>Sleeve                                                                               |
| 140279(830) | Feed (side) Wheel<br>Clutch Shaft Arm<br>Bushing (front)<br>Set Screw           | 143024                                                                                                                                                                        | Bed Hole Plug                                                                        | 143125                                                                                                                                                                                                                 | Oil Pipe Clamping<br>Sleeve Nut                                                                           |
| 140296(830) | Arm Shaft (horizontal)<br>Bushing (center)<br>Set Screw                         | 143031                                                                                                                                                                        | Feed Bar Carrier<br>Oil Wick                                                         | 143126                                                                                                                                                                                                                 | Oil Pipe Clamping<br>Sleeve Nut Adaptor                                                                   |
| 140297(830) | Arm Shaft (horizontal)<br>Flanged Bushing<br>(back) Set Screw                   | 143040                                                                                                                                                                        | Feed Lifting Rock<br>Shaft Connecting<br>Rod                                         | 143134                                                                                                                                                                                                                 | Feed (side) Wheel<br>Feed Regulator<br>143085 with<br>140549(805), 143086<br>and 143378                   |
| 140333(830) | Feed Lifting<br>Eccentric Position<br>Screw                                     | 143049                                                                                                                                                                        | Feed Rock Shaft<br>Connecting Rod                                                    | 143134                                                                                                                                                                                                                 | Stitch Regulator<br>143085 with 140549(805),<br>143086 and 143378                                         |
| 140343(805) | Machine and Machine<br>Base Oil Reservoir<br>Screw Hole Plug<br>Screw           | 143056                                                                                                                                                                        | Needle Bar<br>Connecting Link<br>Roller Bearing(18)                                  | 143191                                                                                                                                                                                                                 | Presser Bar and Feed<br>(side) Wheel Lifting<br>Lever Connecting Rod<br>Oil Mist Retaining<br>Disc (felt) |
| 140350(805) | Knee Lifter Rock<br>Shaft Crank<br>Adjusting Screw                              | 143056                                                                                                                                                                        | Thread Take-up<br>Lever Roller Bearing (18)                                          | 143196                                                                                                                                                                                                                 | Needle Bar Oil Wick                                                                                       |
| 140359(805) | Feed Rock Shaft<br>Oil Screw Plug                                               |                                                                                                                                                                               |                                                                                      | 143236                                                                                                                                                                                                                 | Feed Rock Shaft Oil<br>Screw Plug Washer<br>(fiber)                                                       |
| 140359(805) | Feed Lifting Rock<br>Shaft Oil Screw Plug                                       |                                                                                                                                                                               |                                                                                      | 143236                                                                                                                                                                                                                 | Feed Lifting Rock<br>Shaft Oil Screw Plug<br>Washer (fiber)                                               |
| 140410(830) | Arm Shaft (upright)<br>Bushing (lower) Set<br>Screw                             |                                                                                                                                                                               |                                                                                      | 143257                                                                                                                                                                                                                 | Machine Base and<br>Oil Reservoir Gasket<br>(Cork)                                                        |
| 140542(830) | Needle Bar Crank<br>Position Screw                                              |                                                                                                                                                                               |                                                                                      |                                                                                                                                                                                                                        |                                                                                                           |

Numerical List of Parts for 281-23 Machine

| NUMBER     | DESCRIPTION             | NUMBER                  | DESCRIPTION            | NUMBER                | DESCRIPTION            |
|------------|-------------------------|-------------------------|------------------------|-----------------------|------------------------|
| 143268-001 | Bed Leg (back)          | 147041-001              | Feed Rock Shaft        | 147290                | Feed Lifting Rock      |
| 143280-001 | Knee Lifter Rock Shaft  | 147040-001              | with                   | Shaft Crank (front)   |                        |
| 143282     | Knee Lifter Rock Shaft  | 13996, 147046 and       | with 140915(830)       | with 140915(830)      |                        |
|            | Crank Adjusting Screw   | suitable length of      |                        | Presser Bar Spring    |                        |
|            | 140350(803) with        | No. 1229 White          |                        | 147291                |                        |
|            | 51649(809)              | Lighter Wicking         |                        | 147292                | Tension Stud           |
| 143295     | Pair of Gears for       | Feed Rock Shaft         |                        | 140873(803) with two  |                        |
|            | Lower Shaft Nos.        | Bushing (back)          |                        | 1560(803)             |                        |
|            | 143014 and 143081       | 147042                  |                        | 147293                | Tension complete, Nos  |
| 143301-001 | Rotating Hook Oil       | 147043                  | Feed Rock Shaft        | 32574, 52083, 52394,  |                        |
|            | Wick (felt)             | Bushing (front)         |                        | 147151, 147152,       |                        |
| 143326     | Needle Bar Connecting   | 147045                  | Feed Rock Shaft Oil    | 147292 and two 2102   |                        |
|            | Strud with 140706(803)  | Wick (short)(2)         |                        | Thread Take-up Lever  |                        |
| 143349-001 | Rotating Hook Shaft     | 147046                  | Feed Rock Shaft Oil    | Oil Guard with        |                        |
|            | Oil Filter Wick Holder  | Wick (long)             |                        | 143196 and 147053     |                        |
| 143351     | Rotating Hook Wiper     | 147050-001              | Needle Bar Connecting  | Feed Bar Carrier with |                        |
|            | (leather)               | Link 147492-002 with    |                        | two each 158(805) and |                        |
| 143370     | Oil Lead                | 143326                  |                        | 140788(805)           |                        |
| 143373     | Bell Crank              | 147053                  | Needle Bar Connecting  | Feed Bar Hinge Pin    |                        |
| 143374     | Bell Crank Bracket      | Strud Oil Wick          |                        | (eccentric)           |                        |
| 143375     | Bell Crank Complete,    | 147055                  | Oil Removing Wick      | 147394                | Arm Shaft (horizontal) |
|            | Nos. 143104, 143373     | (head end) Hinge        |                        | with 1036(830) and    |                        |
|            | and 143374              | Plate and Cover         |                        | 140542(830)           |                        |
| 143378     | Stitch Regulator        | Gasket                  |                        | 147395                | Combination of Feed    |
|            | Lacking Slide Spring    | Presser Bar Bushing     |                        | Roll Feed and Stitch  |                        |
| 143378     | Feed (side) Wheel       | (lower)                 |                        | Regulator Parts,      |                        |
|            | Feed Regulator          | 147070                  | Thread Take-up Crank   | Nos. 1662(819),       |                        |
|            | Lacking Slide Spring    | Clamping Screw Hole     |                        | 141143(803), 143087,  |                        |
| 143383     | Rotating Hook Oil       | Plug Gasket             |                        | 143134, 147472-001    |                        |
|            | Flow Regulating         | Thread Take-up Lever    |                        | 149042, 149046 and    |                        |
|            | Thumb Screw Spring      | Link Hinge Stud         |                        | 149203                |                        |
| 143384     | Oil Pipe for Oiling     | Thread Take-up Lever    |                        | 147396-001            | Face Plate             |
|            | Rotating Hook Shaft     | Link Hinge Stud         |                        | 147397                | Face Plate Gasket      |
|            | (front) Bearing         | Oil Wick                |                        | 147399                | Feed (side) Wheel      |
| 143387     | Oil Pipe 143384 with    | 147075                  | Thread Take-up Lever   | and Presser Bar       |                        |
|            | 143124 for oiling       | Link Hinge Stud         |                        | Lifting Lever Link    |                        |
|            | Rotating Hook Shaft     | 147073 with 147074      |                        | Feed (side) Wheel     |                        |
|            | Front Bearing           | Thread Take-up Lever    |                        | Bracket Holder        |                        |
| 146099     | Feed Rock Shaft         | Guard Gasket            |                        | Shaft Bushing         |                        |
|            | Crank with              | 147079                  | Thread Take-up Lever   | Feed (side) Wheel     |                        |
|            | 140228(830)             | Thread Eyelet           |                        | Bracket Holder        |                        |
| 146552     | Arm Screw (front and    | Bushing                 |                        | Pressure Spring       |                        |
|            | intermediate)(2)        | 147091                  | Pressure Regulating    | Adjusting Nut         |                        |
| 146580     | Feed (side) Wheel       | Thumb Screw and         |                        | Feed (side) Wheel     |                        |
|            | Bracket Holder Shaft    | Presser Bar Guide       |                        | Bracket Holder Shaft  |                        |
|            | Oil Retaining Wick Clip | Arm Top Cover (back)    |                        | Guide Bracket with    |                        |
| 146591     | Oil Flow Body           | Stitch Regulator        |                        | 1353(830)             |                        |
| 146610     | Presser Bar and Feed    | Plunger                 |                        | 147407                | Feed (side) Wheel      |
|            | (side) Wheel Lifting    | 147106                  | Oil Pipe Complete      | Bracket Holder Shaft  |                        |
|            | Lever Spring            | from Oil Pump to Arm    |                        | Guide Bracket Holder  |                        |
| 146698     | Oil Removing Wick       | Shaft (horizontal)      |                        | Feed (side) Wheel     |                        |
|            | (head end) Holder       | Center Bearing, Nos.    |                        | Clutch (brake)        |                        |
|            | Body Spring             | 143064, 143065 and      |                        | Feed (side) Wheel     |                        |
| 146745     | Oil Removing Wick       | 143066                  |                        | Clutch (brake)        |                        |
|            | (head end) Holder       | 147107                  | Oil Removing Wick      | Bushing with two      |                        |
|            | Body                    | (head end)              |                        | 453(830)              |                        |
| 146790     | Arm Shaft (horizontal)  | 147108                  | Oil Removing Wick      | 147411                | Feed (side) Wheel      |
|            | Flanged Bushing (back)  | (head end) Holder       |                        | Clutch (brake)        |                        |
|            | Oil Sump Tube           | Body 146745 with        |                        | Member Spring(3)      |                        |
| 147005-001 | Arm Shaft (horizontal)  | 146698 and 147107       |                        | Feed (side) Wheel     |                        |
|            | Flanged Bushing (front) | 147111-001              | Arm Shaft (upright)    | Clutch (drive)        |                        |
| 147008     | Feed (side) Wheel       | Bushing (upper)         |                        | Feed (side) Wheel     |                        |
|            | Bracket Holder Shaft    | 147112-001              | Arm Shaft (horizontal) | Clutch (drive)        |                        |
|            | Oil Retaining Wick      | Flanged Bushing (back)  |                        | Member Spring(3)      |                        |
| 147011     | Arm Top Cover (back)    | Rotating Hook Shaft     |                        | Feed (side) Wheel     |                        |
|            | for 147013              | Oil Retaining Collar    |                        | Clutch Body with      |                        |
| 147013     | Arm Top Cover (back)    | with two 50429(830)     |                        | two 443(830)          |                        |
|            | with Stitch Regulator   | Machine Pulley small    |                        | Feed (side) Wheel     |                        |
|            | Plunger complete, Nos.  | rim diameter (disc      |                        | Clutch Position       |                        |
|            | 13288, 64519, 147011    | power) "V" belt         |                        | Bracket               |                        |
|            | and 147105              | groove 2.9 in. diam.    |                        | Feed (side) Wheel     |                        |
| 147015     | Arm Top Cover (back)    | with two 51283(830)     |                        | Clutch Roller(6)      |                        |
|            | Gasket                  | Oil Wick, 11 in. long   |                        | Feed (side) Wheel     |                        |
| 147024     | Feed Bar Carrier        | (for oiling Take-up     |                        | Clutch Roller         |                        |
|            | Oil Wick Holder with    | Lever, Take-up Lever    |                        | Plunger(6)            |                        |
|            | 143031                  | Link, Needle Bar        |                        | Feed (side) Wheel     |                        |
| 147025-001 | Feed Lifting Rock Shaft | Connecting Link and     |                        | Clutch Washer(2)      |                        |
| 147028     | Feed Lifting Rock Shaft | Thread Take-up Lever    |                        | Feed (side) Wheel     |                        |
|            | Bushing (front)         | Link Hinge Bearing) (2) |                        | Clutch Wearing Plate  |                        |
| 147028     | Feed Lifting Rock       | 147151                  | Tension Releasing Disc | (6)                   |                        |
|            | Shaft Bushing (back)    | 147152                  | Tension Spring         | 147421                | Feed (side) Wheel      |
| 147029     | Feed Lifting Rock       | 147158                  | Throat Plate           | Clutch and Shaft      |                        |
|            | Shaft Collar with two   | 147159                  | Tension Releasing      | complete, Nos.        |                        |
|            | 460(830)(2)             | Lever Body              |                        | 147408, 147410,       |                        |
| 147029     | Feed Rock Shaft         | 147160                  | Tension Releasing      | 147412, 147415,       |                        |
|            | Collar with two         | Lever (adjustable)      |                        | 147422, 147427, two   |                        |
|            | 460(830)                | 147159 with 50123(819)  |                        | 147419, three         |                        |
| 147030-001 | Feed Lifting Rock       | and 147161              |                        | 147411, 147414 and    |                        |
|            | Shaft 147025-001 with   | 147161                  | Tension Releasing      | six each 147417,      |                        |
|            | 13996, 147038 and       | Lever Segment           |                        | 147418 and 147420     |                        |
|            | suitable length of      | 147166                  | Slack Thread           | Feed (side) Wheel     |                        |
|            | No. 1229 White Lighter  | Regulator               |                        | Clutch Shaft          |                        |
|            | Wicking                 | 147206                  | Arm Top Cover (front)  | 147424                | Feed (side) Wheel      |
| 147037     | Feed Lifting Rock       | Gasket                  |                        | Clutch Shaft Arm      |                        |
|            | Shaft Oil Wick (short)  | 147245                  | Oil Wick Holder with   | Bushing (front) Oil   |                        |
|            | (2)                     | two 147141              |                        | Wick                  |                        |
| 147038     | Feed Lifting Rock       | 147247                  | Presser Bar Lifter     | 147425-001            | Feed (side) Wheel      |
|            | Shaft Oil Wick (long)   | 147250                  | Presser Bar and Feed   | Clutch Shaft Arm      |                        |
| 147040-001 | Feed Rock Shaft         | (side) Wheel Lifting    |                        | Bushing (rear)        |                        |
|            |                         | Lever Pin               |                        |                       |                        |

# Numerical List of Parts for 281-23 Machine

| NUMBER     | DESCRIPTION                                                                                                                                                                                                                                                                                                               | NUMBER     | DESCRIPTION                                                                                                                                         | NUMBER     | DESCRIPTION                                                                                                                                                                                                                                            |
|------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------|-----------------------------------------------------------------------------------------------------------------------------------------------------|------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 147426     | Feed (side) Wheel<br>Clutch Shaft Bevel<br>Gear with two<br>462(830)                                                                                                                                                                                                                                                      | 147482-001 | Knee Lifter Rock<br>Shaft Crank with<br>141253(830) and<br>143282                                                                                   | 149166     | Thread Eyeler and<br>Thread Guard (front of<br>Arm)                                                                                                                                                                                                    |
| 147426     | Feed (side) Wheel<br>Driving Shaft<br>(horizontal) Bevel<br>Gear with two 462(830)                                                                                                                                                                                                                                        | 147483     | Knee Lifter Rock<br>Shaft Stop Dog<br>with 141253(830)                                                                                              | 149172     | Rotating Hook (Air<br>Cooled) 149142 with<br>149064, 149065 and<br>three 1367(805)                                                                                                                                                                     |
| 147427     | Feed (side) Wheel<br>Clutch Shaft Collar<br>with two 460(830)                                                                                                                                                                                                                                                             | 147485     | Knee Lifter Rock<br>Shaft Spring                                                                                                                    | 149173     | Rotating Hook (Air<br>Cooled) 149172 with<br>149063 and 149153                                                                                                                                                                                         |
| 147429     | Feed (side) Wheel<br>Clutch Shaft Oil<br>Retainer (felt)                                                                                                                                                                                                                                                                  | 147486-001 | Arm Shaft (horizontal)<br>Bushing (center)                                                                                                          | 149175     | Feed (side) Wheel                                                                                                                                                                                                                                      |
| 147431     | Feed (side) Wheel<br>Driving Shaft<br>(horizontal) Bevel<br>Gear Cover                                                                                                                                                                                                                                                    | 147491     | Machine Base and<br>Oil Reservoir                                                                                                                   | 149176     | Feed (side) Wheel<br>Bracket with two<br>141036(869)                                                                                                                                                                                                   |
| 147432     | Feed (side) Wheel<br>Driving Shaft<br>(horizontal) Spur<br>Gear                                                                                                                                                                                                                                                           | 147492-002 | Needle Bar Connecting<br>Link                                                                                                                       | 149177     | Feed (side) Wheel<br>Bracket complete, Nos.<br>51460(830), 147426,<br>147431, 147437,<br>149175, 149176,<br>149179, 149182,<br>149184, 149185,<br>149186, 149187,<br>149189, two each<br>171(830) 50579(809),<br>149190, 149191 and<br>three 1472(850) |
| 147433-001 | Feed (side) Wheel<br>Driving Shaft<br>(horizontal) Spur<br>Gear Pin (1.2 in.<br>long)                                                                                                                                                                                                                                     | 149016     | Arm Top Cover (front)                                                                                                                               | 149178     | Feed (side) Wheel<br>Bracket Guide                                                                                                                                                                                                                     |
| 147436     | Feed (side) Wheel<br>Driving Shaft (upright)                                                                                                                                                                                                                                                                              | 149017     | Arm Top Cover (front)<br>with Stitch Regulator<br>Plunger complete,<br>Nos. 13288, 64519,<br>149016 and 149018                                      | 149179     | Feed (side) Wheel<br>Bracket Holder with<br>50302(803) and two<br>141141(869)                                                                                                                                                                          |
| 147437     | Feed (side) Wheel<br>Driving Shaft (upright)<br>Bevel Gear (lower)                                                                                                                                                                                                                                                        | 149018     | Arm Top Cover (front)<br>Stitch Regulator<br>Plunger                                                                                                | 149180     | Feed (side) Wheel<br>Bracket Holder<br>Pressure Spring                                                                                                                                                                                                 |
| 147437     | Feed (side) Wheel<br>Driving Shaft (upright)<br>Bevel Gear (upper)                                                                                                                                                                                                                                                        | 149042     | Feed (side) Wheel<br>Eccentric Connecting<br>Rod                                                                                                    | 149181     | Feed (side) Wheel<br>Bracket Holder Shaft                                                                                                                                                                                                              |
| 147438     | Feed (side) Wheel<br>Driving Shaft (upright)<br>Driving Collar with<br>two 1258(830)(2)                                                                                                                                                                                                                                   | 149046     | Feed (side) Wheel<br>Feed Regulator<br>Locking Slide Ratchet<br>Wheel Retaining<br>Collar with 143088 and<br>two 1259(830)                          | 149182     | Feed (side) Wheel<br>Bracket Position Plate                                                                                                                                                                                                            |
| 147439     | Feed (side) Wheel<br>Driving Shaft (upright)<br>Hinge Pin (3.4 in.<br>long) (2)                                                                                                                                                                                                                                           | 149060     | Rotating Hook<br>Bobbin Case                                                                                                                        | 149183     | Feed (side) Wheel<br>Bracket Pressure<br>Spring                                                                                                                                                                                                        |
| 147443     | Feed Roll Plate                                                                                                                                                                                                                                                                                                           | 149061     | Rotating Hook<br>Bobbin Case 149060<br>with 591(806),<br>1380(805) and 40394                                                                        | 149184     | Feed (side) Wheel<br>Finger Guard                                                                                                                                                                                                                      |
| 147444     | Presser Bar Guide<br>Bracket with<br>50203(830)                                                                                                                                                                                                                                                                           | 149063     | Rotating Hook Bobbin<br>Case complete, Nos.<br>592(805), 2974, 2975,<br>40392, 125320 and<br>149061                                                 | 149185     | Feed (side) Wheel<br>Gear Cover                                                                                                                                                                                                                        |
| 147445     | Presser Bar and<br>Feed (side) Wheel<br>Lifting Lever with<br>454(830)                                                                                                                                                                                                                                                    | 149064     | Rotating Hook Bobbin<br>Case Holder                                                                                                                 | 149186     | Feed (side) Wheel<br>Position Bracket                                                                                                                                                                                                                  |
| 147447     | Presser Bar Lifting<br>Bracket                                                                                                                                                                                                                                                                                            | 149065     | Rotating Hook Section                                                                                                                               | 149187     | Feed (side) Wheel<br>Driving Shaft<br>(horizontal) Spur Gear<br>147432 with<br>147433-001 and 149188                                                                                                                                                   |
| 147449     | Feed (side) Wheel<br>Bracket Holder<br>Shaft Oil Retaining<br>Wick 147008 with<br>146580                                                                                                                                                                                                                                  | 149066     | Rotating Hook Thread<br>Guard                                                                                                                       | 149188     | Feed (side) Wheel<br>Driving Shaft<br>(horizontal)                                                                                                                                                                                                     |
| 147468     | Arm Shaft (horizontal)<br>Thrust Collar with<br>two 624(830)                                                                                                                                                                                                                                                              | 149074     | Feed Lifting Rock<br>Shaft Crank (back) with<br>140228(830)                                                                                         | 149189     | Feed (side) Wheel<br>Spur Gear (front) with<br>two 735(830)                                                                                                                                                                                            |
| 147469     | Combination of<br>Feed and Stitch<br>Regulator Parts,<br>Nos. 143015, 143040,<br>143049, 143087,<br>143134, 147472-002<br>and 147473                                                                                                                                                                                      | 149111     | Face Plate Plug                                                                                                                                     | 149190     | Feed (side) Wheel<br>Spur Gear<br>(intermediate) (2)                                                                                                                                                                                                   |
| 147470     | Feed Bar                                                                                                                                                                                                                                                                                                                  | 149121     | Machine Base and<br>Oil Reservoir with<br>Knee Lifter Rock<br>Shaft Nos. 143257,<br>143280-001, 147480,<br>147482-001, 147483,<br>147485 and 147491 | 149191     | Feed (side) Wheel<br>Spur Gear<br>(intermediate) Stud(2)<br>Presser Bar (hollow)                                                                                                                                                                       |
| 147471     | Feed Bar 147470<br>with 21478, 147290,<br>147355, 147356 and<br>two 1423(803)                                                                                                                                                                                                                                             | 149124     | Rotating Hook Bobbin<br>Case Holder Position<br>Bracket                                                                                             | 149194     | Presser Foot Plate                                                                                                                                                                                                                                     |
| 147472-001 | Feed (side) Wheel<br>Eccentric                                                                                                                                                                                                                                                                                            | 149128-001 | Thread Take-up Crank<br>with Thread Take-up<br>Lever with 149160<br>and eighteen 143056                                                             | 149195     | Presser Foot (spring<br>hinged) complete, Nos.<br>26231, 52390, 62527<br>and 149194                                                                                                                                                                    |
| 147472-002 | Feed Eccentric                                                                                                                                                                                                                                                                                                            | 149130-002 | Thread Take-up Crank<br>and Thread Take-up<br>Lever complete, Nos.<br>147075 and 149129-002                                                         | 149203     | Feed (side) Wheel<br>Clutch Shaft Driving<br>Crank with 50443(830)                                                                                                                                                                                     |
| 147473     | Feed Lifting<br>Eccentric and Arm<br>Shaft (horizontal)<br>Bevel Gear, right<br>hand spiral with<br>1259(830), 140333(830)<br>and 143088<br>Note: To ensure proper<br>functioning of Gears,<br>No. 147473 will not<br>be supplied separately<br>to Agencies, but will<br>be substituted by<br>Pair of Gears No.<br>147476 | 149141     | Rotating Hook (Air<br>Cooled) with<br>143301-001 and two<br>1253(830)                                                                               | 149205     | Oil Removing Wick<br>(head end) Hinge<br>Plate and Cover                                                                                                                                                                                               |
| 147476     | Pair of Gears for<br>Upper Shaft Nos.<br>143015 and 147473                                                                                                                                                                                                                                                                | 149142     | Rotating Hook (Air<br>Cooled) 149141 with<br>143351, 149066 and<br>four 1053(805)                                                                   | 149206     | Oil Removing Wick<br>(head end) Holder<br>Body complete, Nos.<br>140553(805), 146698,<br>146745, 147055,<br>147107 and 149205                                                                                                                          |
| 147480     | Knee Lifter Bell<br>Crank Plunger                                                                                                                                                                                                                                                                                         | 149145     | Rotating Hook (Air<br>Cooled) 149142 with<br>149065 and three<br>1367(805)                                                                          | 149224     | Oil Wick Holder Plug<br>(felt)                                                                                                                                                                                                                         |
| 147481     | Knee Lifter Rock<br>Shaft 143280-001<br>with 147482-001,<br>147483 and 147485                                                                                                                                                                                                                                             | 149148     | Rotating Hook Shaft<br>with 149153                                                                                                                  | 149227     | Presser Bar Bushing<br>(lower) Washer                                                                                                                                                                                                                  |
|            |                                                                                                                                                                                                                                                                                                                           | 149149     | Rotating Hook Shaft<br>149148 with 147131                                                                                                           | 149228     | Needle Bar (hollow)<br>with 140036(803),<br>140239(830) and<br>149235-001                                                                                                                                                                              |
|            |                                                                                                                                                                                                                                                                                                                           | 149150-001 | Rotating Hook Shaft<br>Bushing (front)                                                                                                              | 149230     | Arm Side Shield                                                                                                                                                                                                                                        |
|            |                                                                                                                                                                                                                                                                                                                           | 149152     | Rotating Hook Shaft<br>Oil Filter Wick                                                                                                              | 149235-001 | Needle Bar Thread<br>Guard                                                                                                                                                                                                                             |
|            |                                                                                                                                                                                                                                                                                                                           | 149153     | Rotating Hook Shaft<br>Oil Filter complete,<br>Nos. 143349-001 and<br>149152                                                                        | 272152     | Rotating Hook Bobbin<br>Needle Cot, 1955<br>(Size No. 16)                                                                                                                                                                                              |
|            |                                                                                                                                                                                                                                                                                                                           | 149160     | Thread Take-up Crank<br>Wearing Plate                                                                                                               | ---        |                                                                                                                                                                                                                                                        |
|            |                                                                                                                                                                                                                                                                                                                           | 149161     | Thread Take-up Lever<br>Guard                                                                                                                       |            |                                                                                                                                                                                                                                                        |