

INSTRUCTIONS and PARTS BOOK for U. S. MACHINES

BASIC and SPECIAL PARTS for
ALL SKIP STITCH MODELS SUCH AS:

108, 108-1, 118, 118-1,

508, 508-1, 508-C, 508-K

518, 518-1, 518-2, 518-9,

518-A, 518-C, 518-PR, 518-PRB

U. S. BLIND STITCH MACHINES

U. S. BLIND STITCH MACHINE CORP.

231 West 29th Street, New York 1, N.Y.

YOU CAN DEPEND ON U. S. SERVICE

Simplicity of construction is the keynote of U. S. Blind Stitch Machines. Every effort has been made to simplify the use of this catalogue so that each machine part can be easily identified.

Seldom does a U. S. Machine get out of order, because it is rugged and uncomplicated in construction and there are many years of practical experience behind it. Instructions are simply given and if an ordinary amount of knowledge is used, very little mechanical skill is necessary. You are sure to be more than pleased with quantity and quality of production you receive from your U. S. Machines.

**When Ordering Parts
BE SURE to
Specify Model of Machine**

VERY IMPORTANT

To assure the proper operation of U. S. Machines, use GENUINE U. S. NEEDLES ONLY, this is the wise way to avoid trouble, loss of valuable time, costly repairs and assures the best results.

Standard Needle Sizes
Used in These Models
#10, #15, #20, #25, #30

Each needle has its size stamped on the shank.
U. S. B. S. is stamped on all U. S. needles.

THROW AWAY DULL OR HOOKED NEEDLE

Good results are obtained only by using a sharp needle. While U. S. needles give extra long service, they do, eventually, become dull. Then discard and insert a new U. S. needle of the proper size.

HOW TO INSERT NEW NEEDLE CORRECTLY

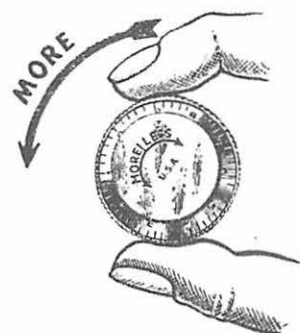
To take out the old needle, slightly loosen the clamp screw where the needle sets. Before inserting the new needle, turn the Radio Dial Knob to the right a sufficient number of times so the needle is entirely clear of the rib. To insert a new needle: push it up into the groove as far as it will go and tighten the screw, then turn the dial back slowly until you reach the required penetration. It is easy to operate the Radio Dial Knob which regulates needle penetration.

Be Sure the Needle You Use Has Genuine U. S. Trademark on the Shank, on the Box and on the Envelope.

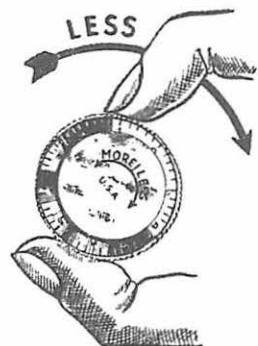
THE DIAL

The dial, of course, must be adjusted to the thickness of the fabric, so that the stitch will be regular and even. If the needle fails to catch on the right side of the material, or bottom layer, turn the dial-a little at a time-to the left; as the arrow points to "MORE". Run a few stitches to test. If the needle point goes down too deep and shows too much impression on the right side of the material, turn the dial to the right as the arrow points to "LESS". Then test until you have the right penetration. Only a little patience is required for skilled adjusting.

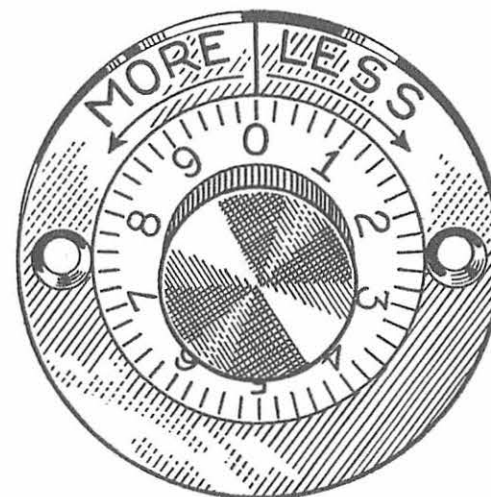
GUIDE FOR PROPER NEEDLE PENETRATION



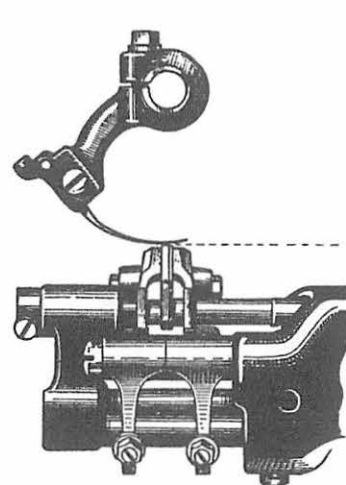
Dial Showing "MORE"



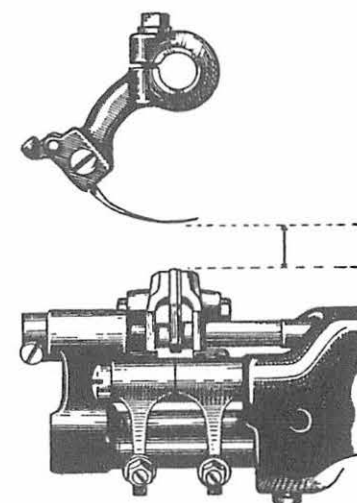
Dial Showing "LESS"



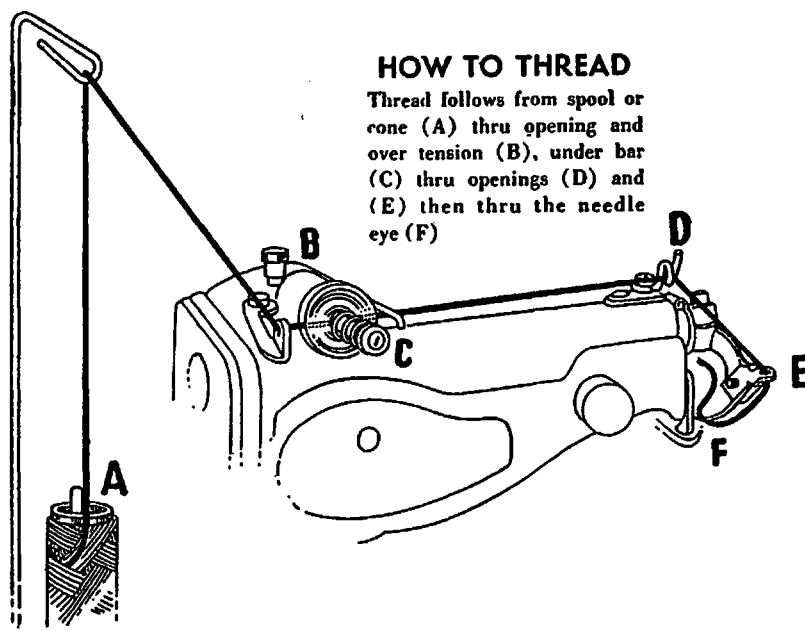
NEW TYPE DIAL NOW USED ON U. S. MACHINES



Rib Shaft Adjustment
for "MORE"



Rib Shaft Adjustment
for "LESS"



THREAD BREAKAGE: HOW TO AVOID

See that the machine is threaded properly, as improper threading causes breakage. The thread should feed firmly, but without pull or interruption. If the stitch is loose, turn the tension nut (C) toward you. If the thread travels too tightly, shirring the material, or if it breaks, turn the tension nut (C) away from you which will loosen tension of the spring.

After substantial service, the needle will be inclined to cut a sharp edge in the groove of the needle guide, causing thread breakage. When this occurs, we suggest replacing needle guide: part #47.

Sometimes a groove will be caused in the opening of needle clamp (E) by constant thread friction; this also will cause thread breakage. You can avoid this by changing needle clamp: part #36.

OIL IS THE LIFE OF THE MACHINE

Be SURE to oil every movable part wherever oil cups or open holes are located EVERY DAY, especially when the machine is new. When oiling, insert the oil spout firmly. Use proper lubricating oil.

By observing these simple instructions, you will secure satisfactory results from your machine. If you do run into any trouble, get in touch with our main office, or the representative from whom you bought the machine.

HAND WHEEL

The hand wheel must always turn *away* from the operator.

SPEED

Speed of the machine depends on the model. On all skip (or interval) stitch machines, we recommend speed from 2,000 to 3,000 stitches per minute.

Very Important: Do not mount machine on high speed motors.

REPLACING LOOPER

Replacing of the looper (part #22) is of utmost importance and the principle is the same on all machines.

Loosen the screw and remove the old looper. Insert new looper in the same slot and turn with fingers so that the looper is straight and the needle enters between the prongs of the looper clearing the looper prongs without touching either one. Then turn hand wheel slowly away from you until the looper reaches the far right side of the presser foot where the looper should clear the needle just in front of the needle eye and needle is under the looper without touching it. Then when looper goes to left side also, see that it clears the needle guide. Tighten looper screw to hold looper in position. Make certain that the looper does not touch the feeder.

If, for some reason, you are not able to adjust the looper in the proper position, note that on the right side of machine is the eccentric block (part #21). Here are three set screws which hold assembly unit of the entire looper in position. By loosening these three screws, you may raise or lower looper to desired position. When the looper is finally in correct position, be sure to tighten the screws again.

REPLACING FEEDER

To replace feeder (part #43), remove only front screw of feed lever and loosen inner screw. Remove the broken or worn feeder from feed lever and replace with new one. After new feeder is in place, move hand wheel away from you to determine that looper clears above feeder; if they do touch, press feeder down with finger until the looper clears and tighten screws on feed lever.

D O N T ' S

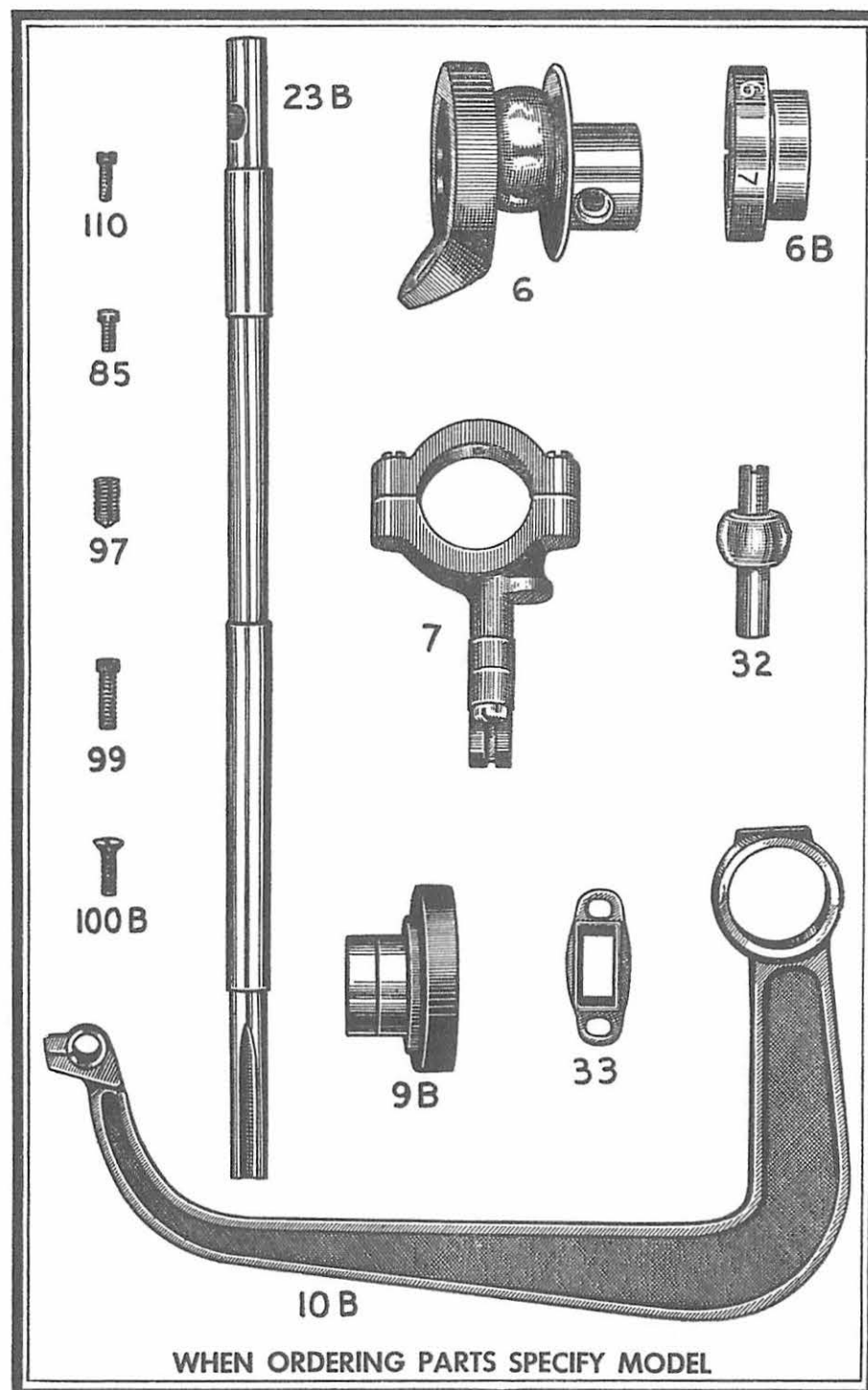
Do not rest on knee lifter. Be sure that the knee does not touch the knee lifter while the machine is in operation.

Do not try to help the machine by pulling the fabric, lest you bend the needle. The machine feeds the work without assistance.

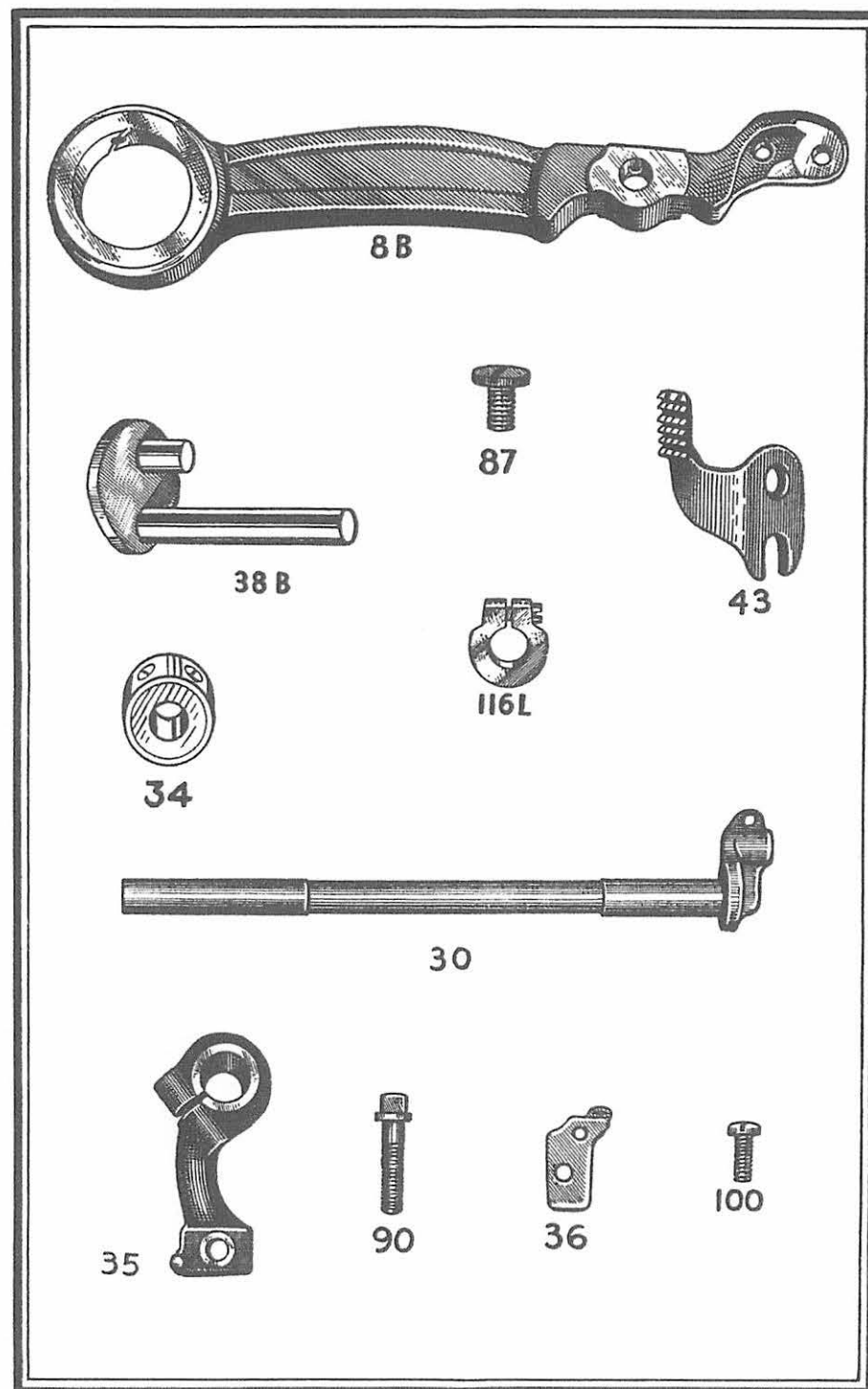
When removing the work from the machine, be sure that the needle is out of the cloth.

Do not run the machine without cloth.

NUMBER	NAME
6	Feed Eccentric
6-B	Stitch Regulating Collar
7	Needle Connection
9-B	Rib Lever Eccentric
10-B	Rib Connection Lever
23-B	Main Shaft
32	Eccentric Ball Stud
33	Eccentric Ball Guard
85	Rib Lever Eccentric Screw
97	Feed Eccentric Screw
99	Needle Connection Screw
100-B	Rib Lever Clamp Screw
110	Eccentric Ball Guard Screw



NUMBER	NAME
8-B	Feed Lever
30	Needle Shaft
34	Needle Shaft Clamp Collar
35	Needle Lever
36	Needle Clamp
38-B	Feed Lever Rocker Pin
43	Feeder
87	Feeder Screw
90	Needle Lever Clamp Screw
100	Needle Clamp Screw
100	Needle Shaft Crank Screw
116-L	Feed Lever Rocker Pin Collar



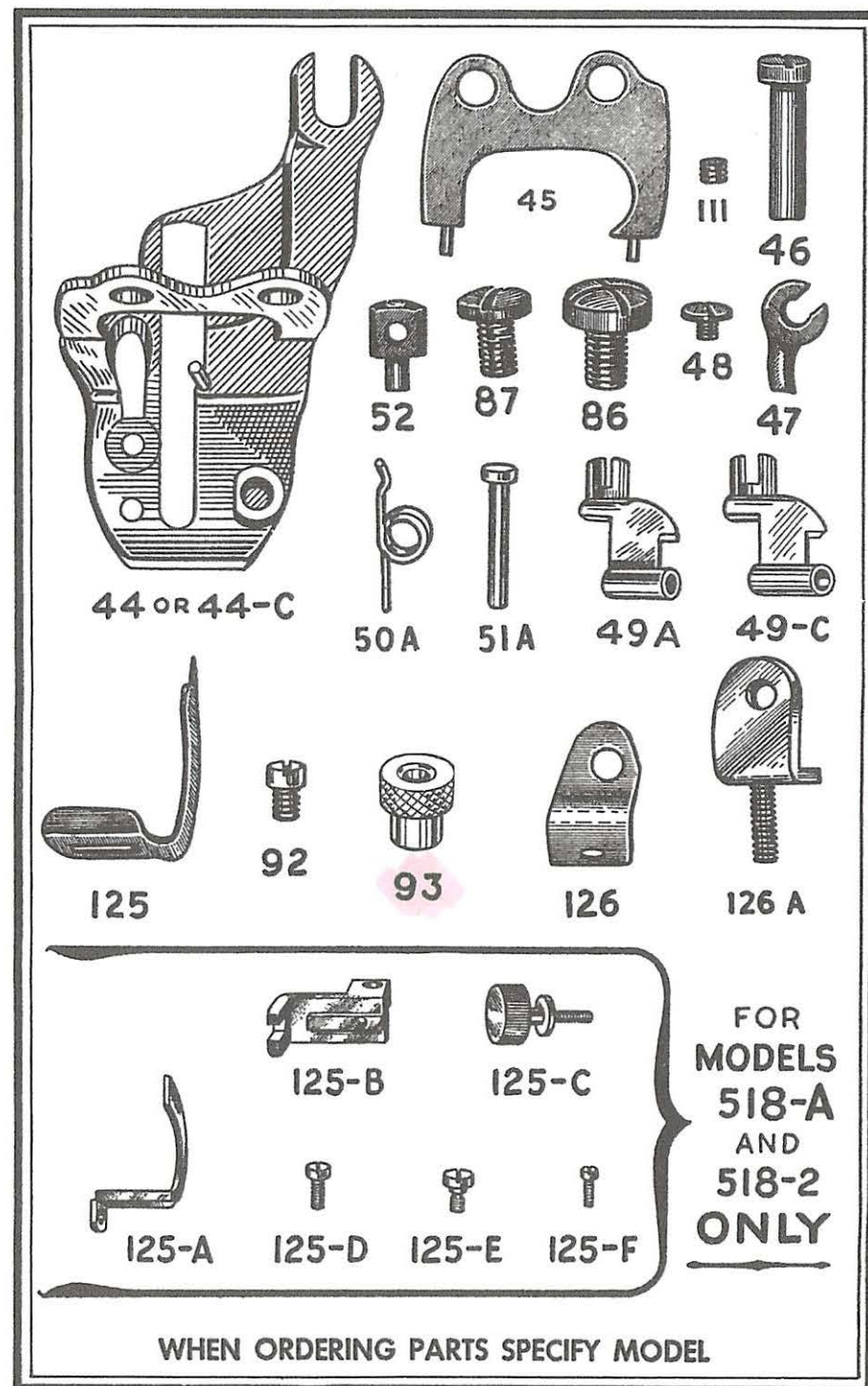
NUMBER	NAME
44	Presserfoot for Models 108, 118, 508 & 518
44-C	Presserfoot for Models 108-1, 118-1, 508-1, 508-C, 508-K, 518-1, 518-2, 518-9, 518-A, 518-C
45	Presserfoot Brace
46	Presserfoot Eccentric Pin
47	Needle Guide
48	Needle Guide Screw
48	Front Guide Holder Screw
49-A	Presserfoot Shoe for Models 108 and 118 508 and 518
49-C	Presserfoot Shoe for Models 108-1 and 118-1 508-1, 508-C, 508-K 518-1, 518-2, 518-9 518-A, 518-C
50-A	Presserfoot Shoe Spring
51-A	Presserfoot Shoe Pin
52	Presserfoot Shoe Stud
86	Presserfoot Clamp Screw
87	Presserfoot Brace Screw
92	Front Guide Holder Clamp Screw
93	Front Guide Holder Nut
111	Shoe Pin Holder Screw
125	Front Guide
126	Front Guide Holder
126-A	Front Guide Holder

For Models 518-A and 518-2 ONLY

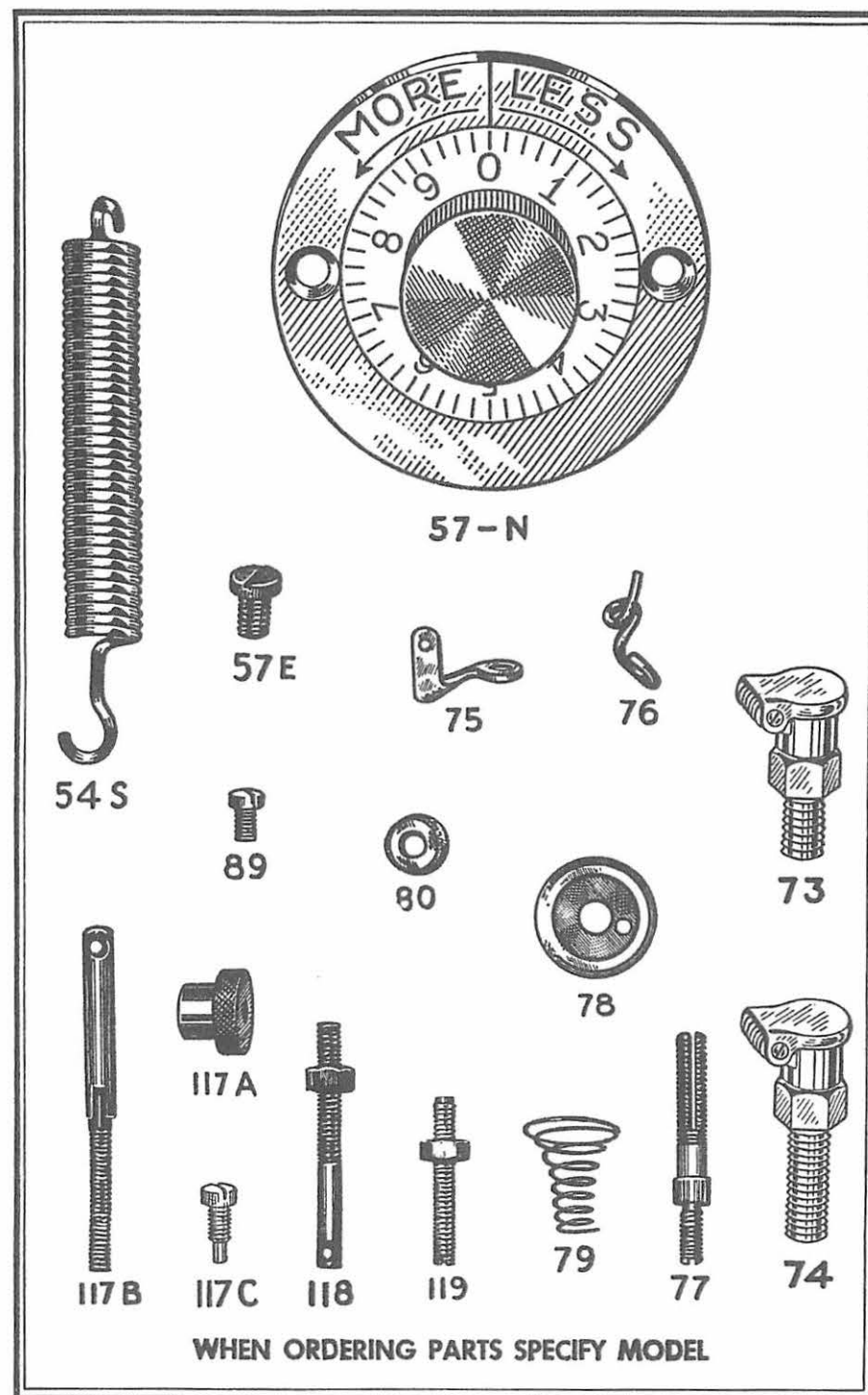
Not For Factory Use
Store Alteration Departments ONLY

125-A	Front Guide
125-B	Front Guide Block
125-C	Front Guide Adjusting Knob
125-D	Front Guide Block Clamp Screw
125-E	Front Guide Clamp Screw
125-F	Front Guide Block Check Screw

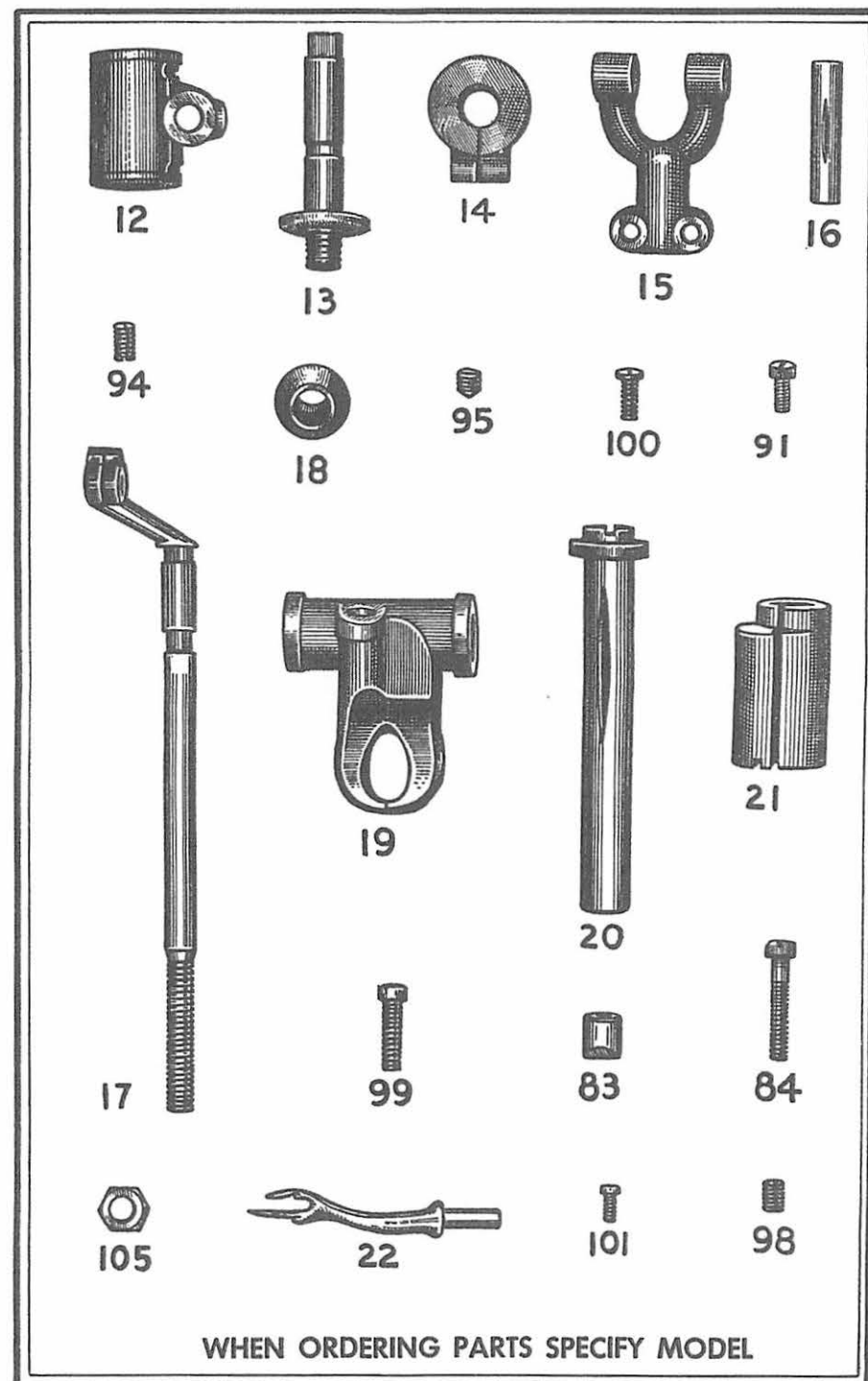
Be Sure to Specify Model of your Machine



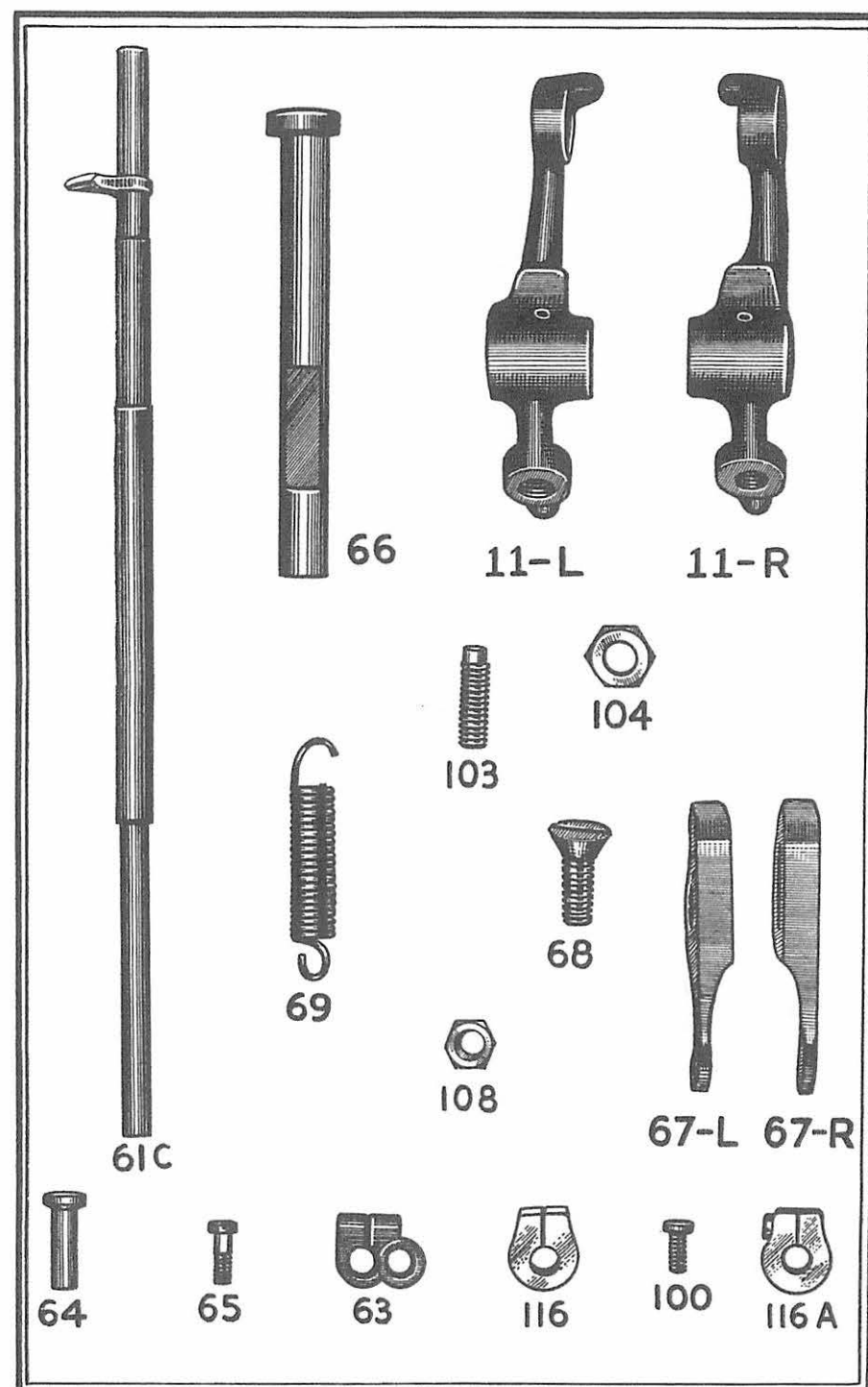
NUMBER	NAME
54-S	Main Spring
57-E	Regulating Knob Screw
57-N	Regulating Knob
73	Oil Cup
74	Oil Cup
75	Rear Thread Guide
76	Front Thread Guide
77	Tension Stud
78	Tension Disc
79	Tension Spring
80	Tension Nut
89	Thread Guide Screw
117-A	Spring Knob
117-B	Spring Link
117-C	Main Spring Lock Screw
118	Main Spring Screw and Nut
119	Feed Frame Limit Screw and Nut



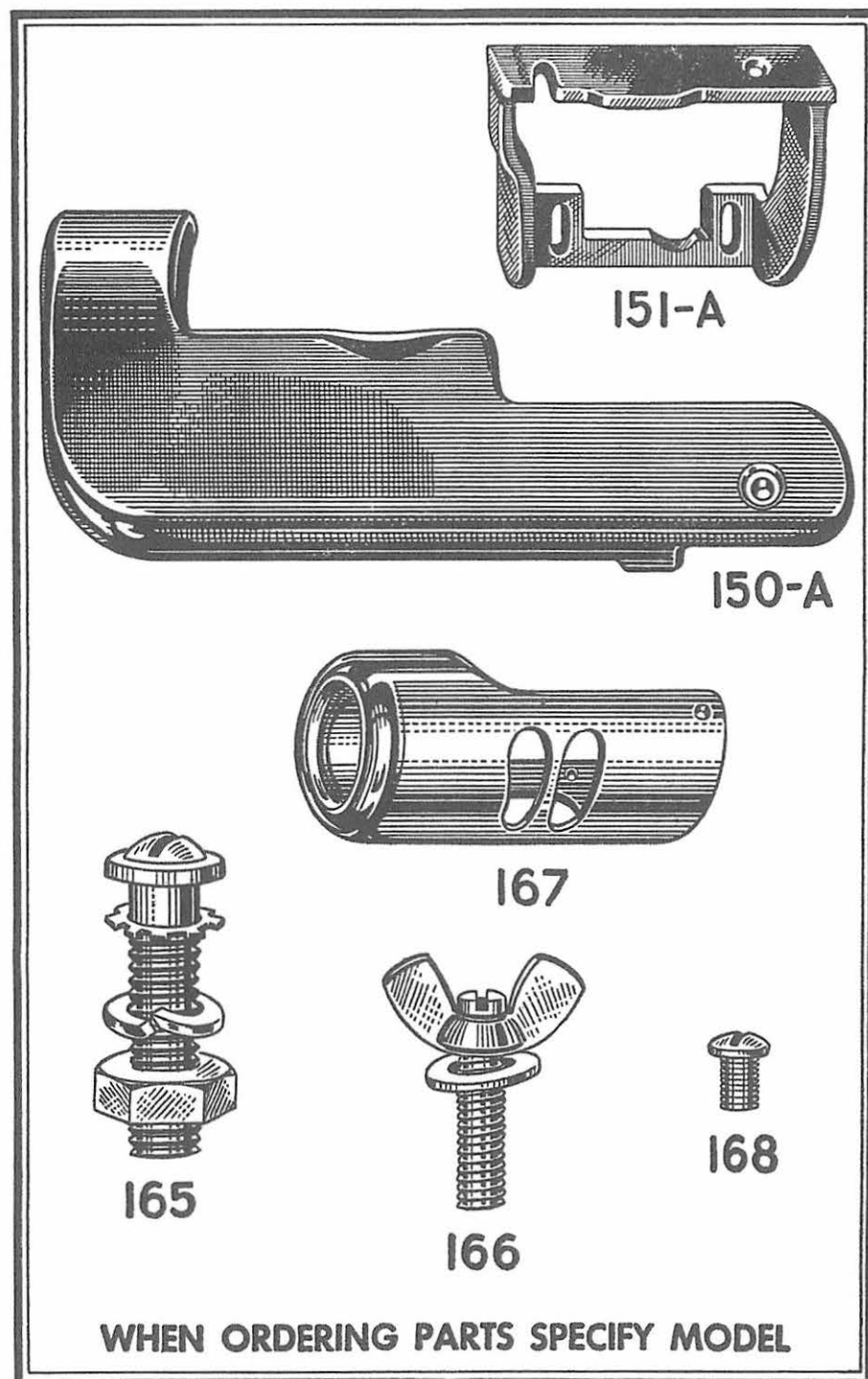
NUMBER	NAME
12	Looper Rod Sleeve
13	Looper Rod Sleeve Stud
14	Looper Rod Sleeve Clamp Collar
15	Looper Rod Fork
16	Looper Rod Fork Pin
17	Looper Rod
18	Looper Rod Ball
19	Looper Rod Carrier
20	Looper Rod Carrier Stud
21	Eccentric Block
22	Looper
83	Eccentric Block Clamp
84	Eccentric Block Clamp Screw
91	Looper Fork Clamp Srew
94	Looper Sleeve Pin Screw
95	Looper Rod Ball Screw
98	Eccentric Block Screw
99	Looper Rod Carrier Clamp Screw
100	Sleeve Collar Clamp Screw
101	Looper Clamp Screw
105	Looper Rod Nut



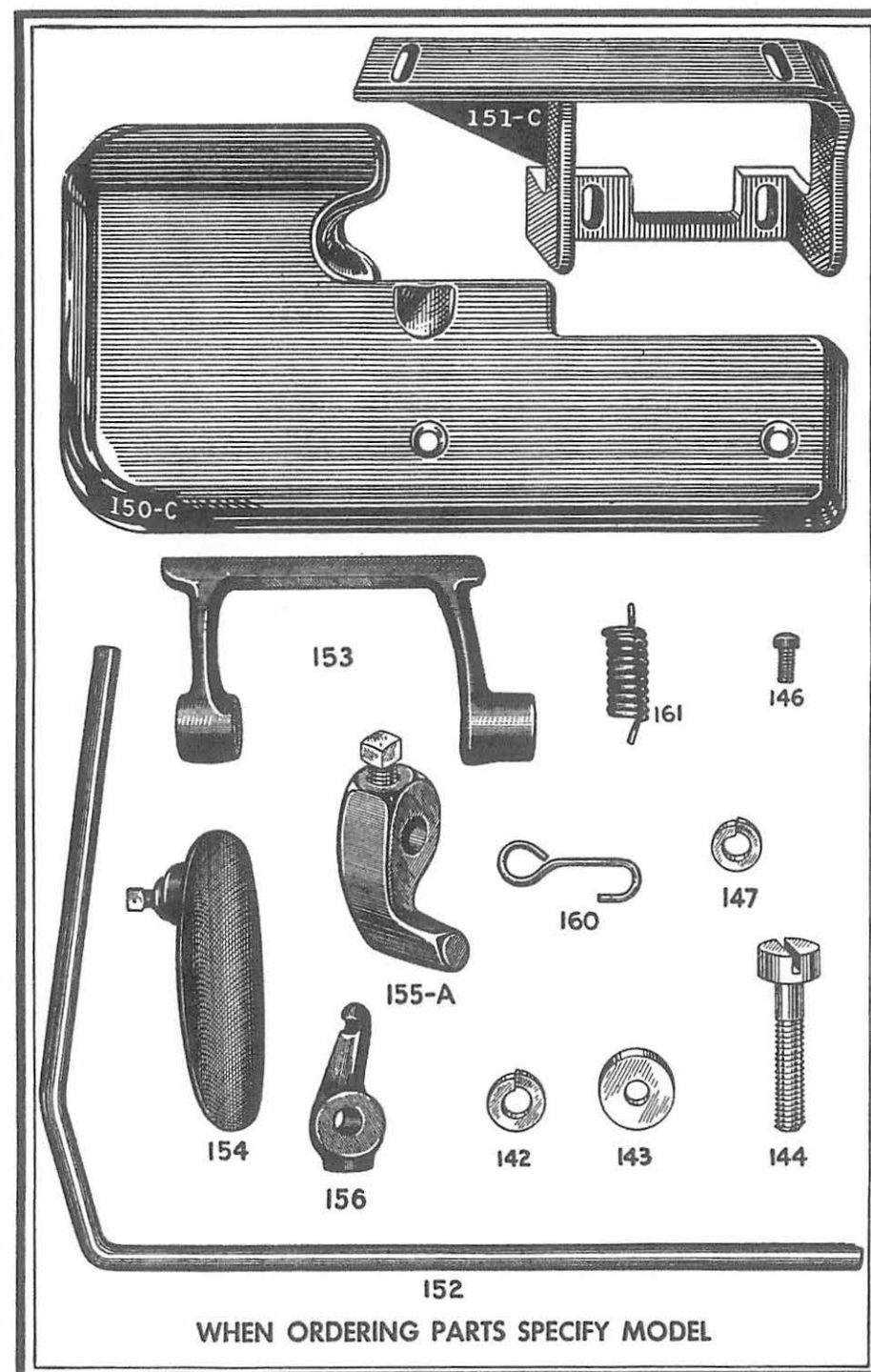
NUMBER	NAME
11-L	Left Platten Bracket
11-R	Right Platten Bracket
61-C	Rib Shaft V Shape for Models 108, 108-1, 118, 118-1, 508, 508-1, 508-C, 508-K, 518, 518-1, 518-2, 518-9, 518-A, 518-C
63	Rib Shaft Crank
64	Rib Shaft Crank Stud
65	Rib Shaft Crank Clamp Stud
66	Bracket Stud
67-L	Left Platten
67-R	Right Platten
68	Platten Screw
69	Platten Spring
100	Rib Shaft Collar Clamp Screw
103	Bracket Limit Screw
104	Bracket Limit Screw Nut
108	Platten Screw Nut
116	Left Rib Shaft Collar
116-A	Right Rib Shaft Collar



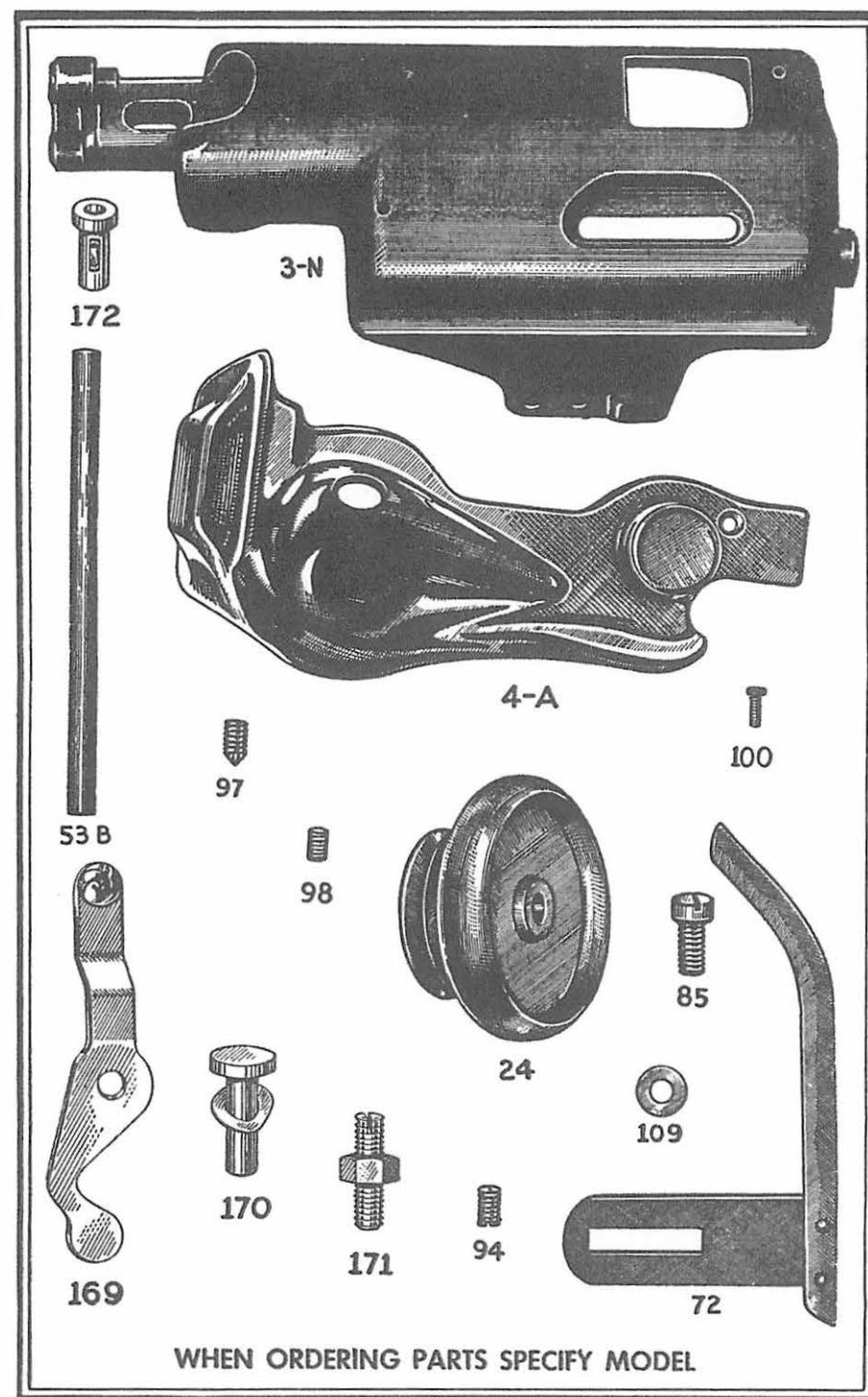
NUMBER	NAME
150-A	Swing Plate
151-A	Swing Plate Bracket
165	Swing Plate Pivot Stud and Nut Complete
166	Swing Plate Lock Screw and Wing Nut
167	Cylinder
168	Cylinder Screw



NUMBER	NAME
142	Supporting Bracket Lock Washer
143	Supporting Bracket Washer
144	Supporting Bracket Screw
146	Knee Lifter Bracket Screw
147	Knee Lifter Bracket Lock Washer
150-C	Front Plate for Model 518-9 ONLY
151-C	Front Plate Bracket for Model 518-9 ONLY
152	Knee Lifter Rod
153	Knee Lifter Bracket
154	Knee Pedal
155-A	Knee Lifter Stop Bracket
156	Lifting Bracket
160	Knee Lifter Stop Bracket Hook
161	Knee Lifter Supporting Spring



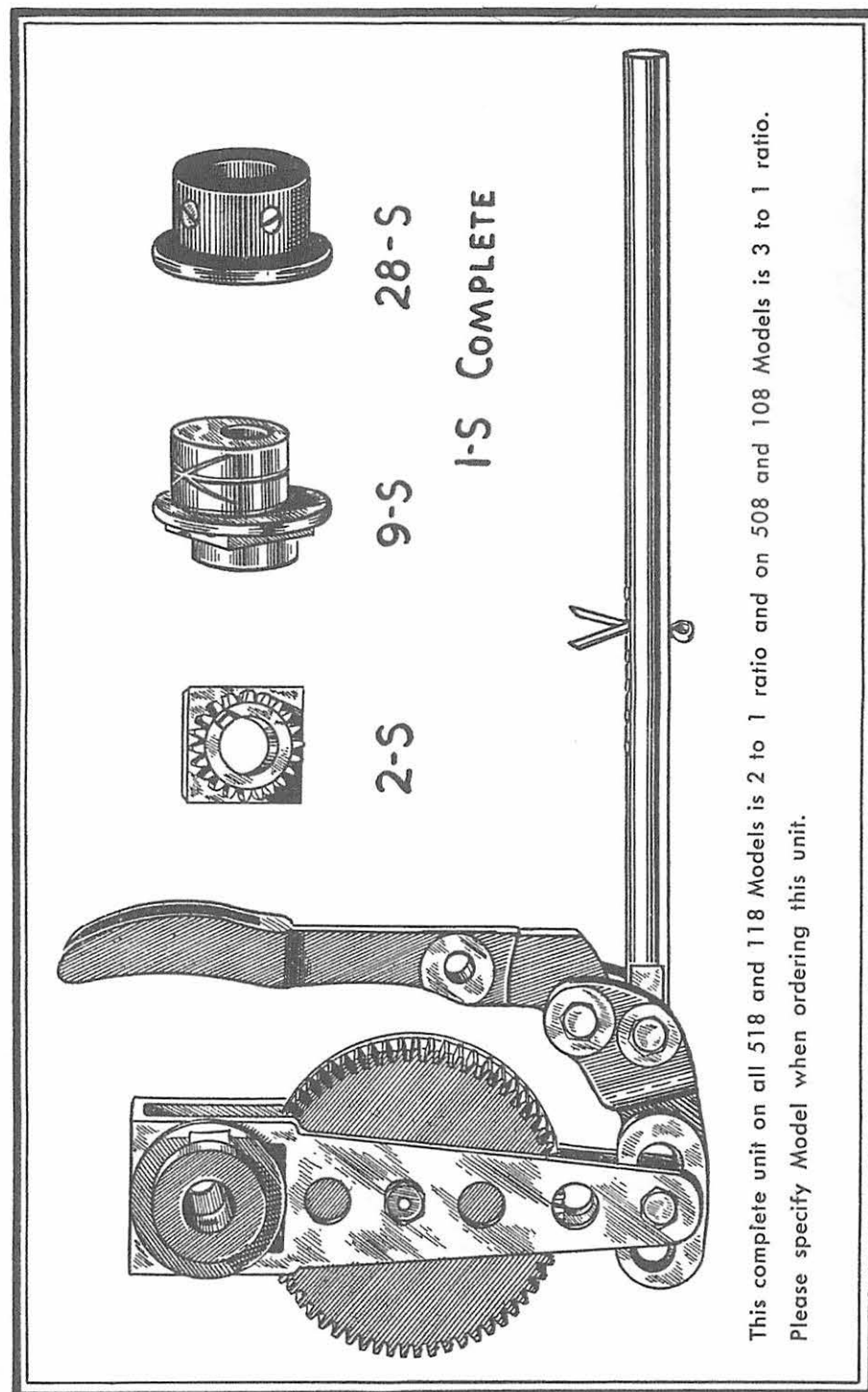
NUMBER	NAME
3-B	Feed Frame for 108, 108-1, 118, 118-1 Not Illustrated
3-N	Feed Frame for 508, 508-1, 508-C, 508-K 518, 518-1, 518-2, 518-9, 518-A, 518-C 518-PR 518-PRB
4-A	New Style Cover
24	Hand Wheel
24-V	Hand Wheel V Belt Drive (Not illustrated)
53-B	Feed Frame Shaft
72	Belt Guard
85	Belt Guard Screw
94	Lever Stud Clamp Screw
94	Feed Frame Shaft Clamp Screw
97	Hand Wheel Screw
98	Hand Wheel Screw
100	Cover Screw
109	Belt Guard Washer
169	Skip Regulator Lever
170	Lever Stud and Washer
171	Lever Nut and Screw
172	Left & Right Feed Frame Bushing



SKIP STITCH GEAR ASSEMBLY

It is very important to specify the Model Number when ordering these parts, because on all 508 and 108 models, the skip stitch assembly is three to one (3 to 1) ratio and on all 518 and 118 models the skip stitch assembly is two to one (2 to 1) ratio, therefore the model number of your machine is imperative.

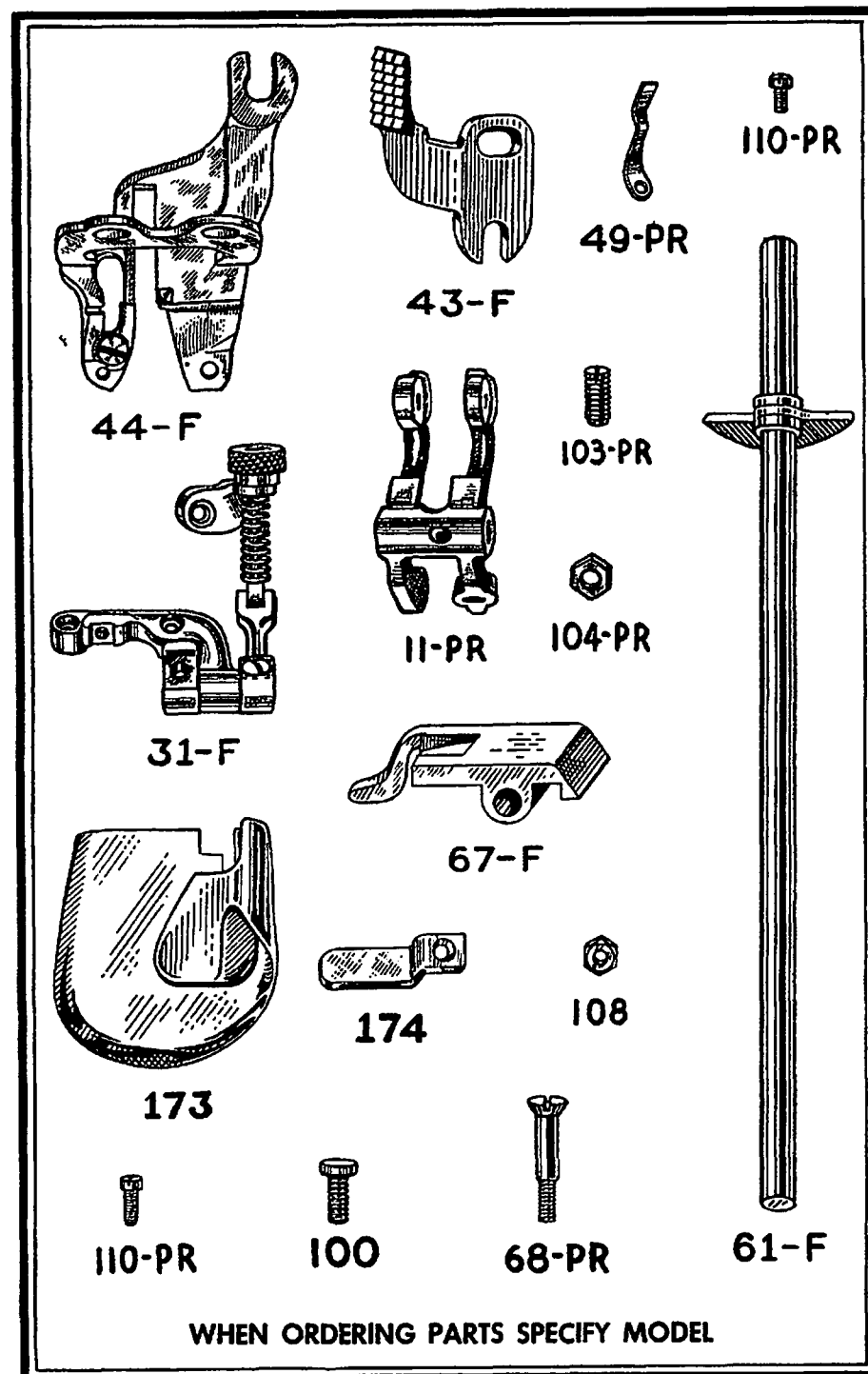
NUMBER	NAME
1-S	Skip Stitch Gears Complete
2-S	Small Gear
9-S	Eccentric
28-S	Clamping Collar



This complete unit on all 518 and 118 Models is 2 to 1 ratio and on 508 and 108 Models is 3 to 1 ratio. Please specify Model when ordering this unit.

**SPECIAL PARTS FOR
MODEL 518-PR AND 518-PRB ONLY**

NUMBER	NAME
11-PR	Platten Bracket
31-F	Hemmer Bracket Complete
43-F	Feeder
44-F	Presserfoot
49-PR	Shoe
61-F	Rib Shaft
67-F	Platten
68-PR	Platten Stud
100	Hemmer Bracket Screw
103-PR	Platten Bracket Limit Screw
104-PR	Platten Bracket Limit Screw Nut
108	Platten Stud Nut
110-PR	Bridge Bracket Screw
110-PR	Shoe Screw
173	Hemmer (Specify size and whether A or B)
174	Hemmer Side Bracket



WHEN ORDERING PARTS SPECIFY MODEL