U.S. BLIND STITCH MACHINE CORP.

EXPRESS STREET & SKYLINE DRIVE PLAINVIEW N.Y. 11803
TELEPHONE: 516-433-4350
CABLE ADDRESS:"BLINSTIT PLAINVIEW NEW YORK"

EST. 1925

INSTALLATION AND OPERATING INSTRUCTIONS MAINTENANCE & PARTS CATALOG for U.S. Blind Stitch Machine

Model 1099SF/1200SF

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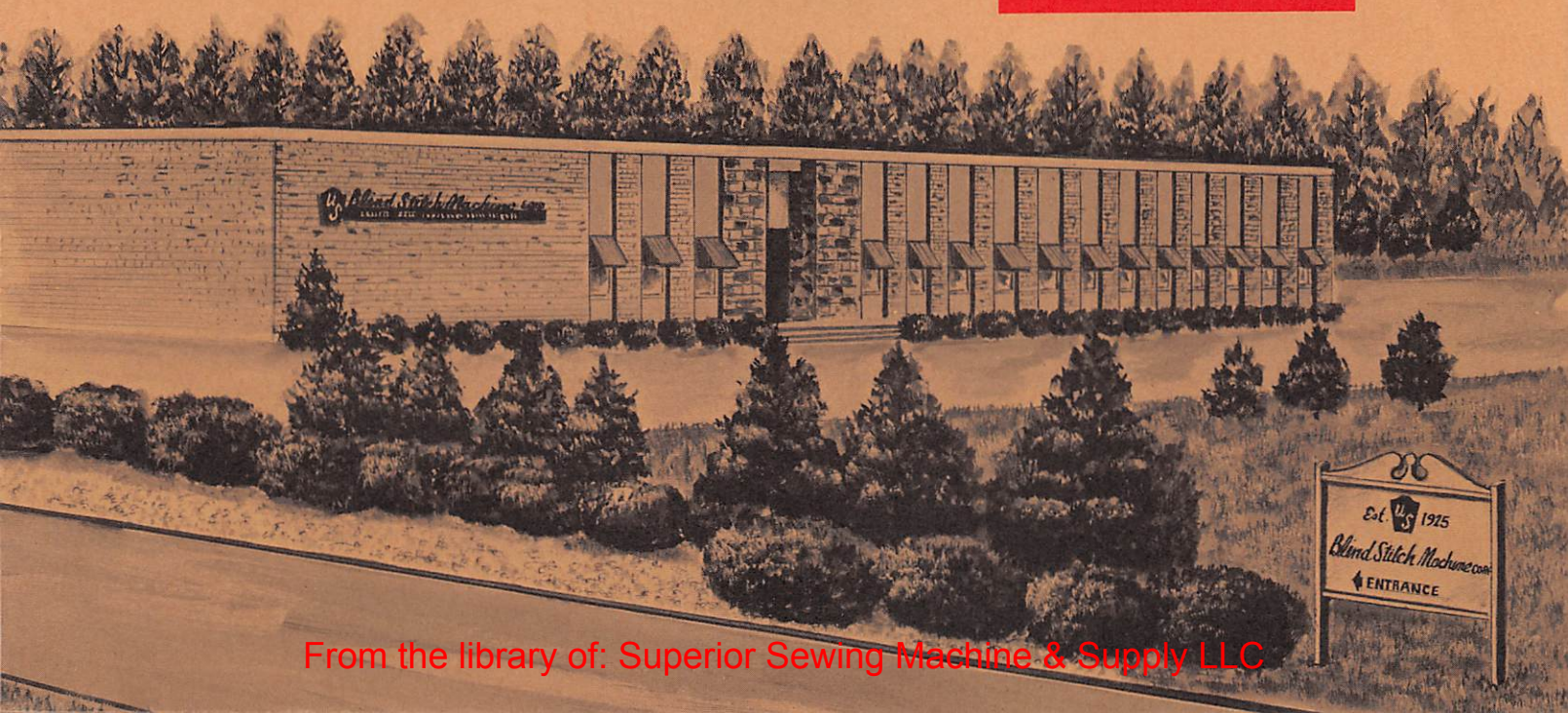

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NOTE FOR PARTS CATALOG

The 1200SF has recently been modified and renamed 10099SF. However, only a few parts are changed. You may still refer to this parts book for either unit, just note where part numbers have been changed. Please indicate serial number when ordering parts or requesting service information.

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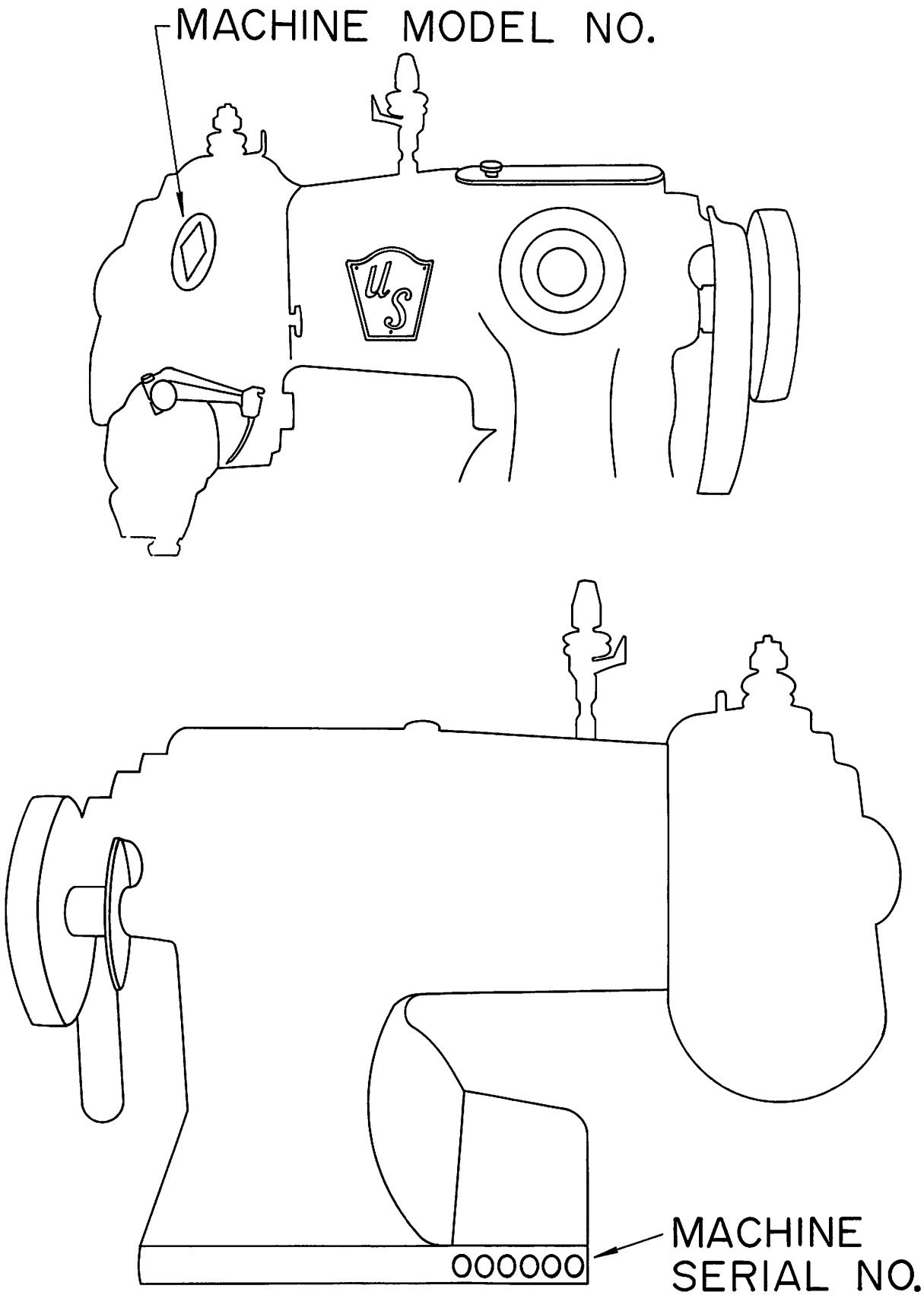

PARTS CATALOGS ARE AVAILABLE UPON REQUEST

BE SURE TO SPECIFY MODEL AND SERIAL NO.
OF MACHINE WHEN ORDERING PARTS.

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1099SF/1200-SF

INSTALLATION, OPERATING AND MAINTENANCE INSTRUCTIONS

All U.S. Blind Stitch Machines are designed for long life and trouble-free performance. When installed and lubricated in accordance with the INSTALLATION AND OPERATING INSTRUCTIONS, only the minimum maintenance normally associated with industrial sewing machines will be required. These maintenance requirements will generally be confined to the five locations described below, at which wear may be expected after extensive use. When such wear does occur, the worn part may be readily replaced by following the appropriate instructions. For ease of installation, and to insure satisfactory service, it is essential that only genuine U.S. Blind Stitch parts and needles are used. They are the only parts designed specifically for the machine, with the built-in long life and excellent wearing characteristics typical of the U.S. Blind Stitch Machine.

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INSTALLATION INSTRUCTIONS

I. UNPACKING AND INSTALLING THE MACHINE

A. UNPACKING

1. Cardboard Carton: Open the carton and remove the corrugated liner. Insure that the envelope containing the accessories is not misplaced or accidentally discarded. Lift the machine out of the carton with the plywood base still attached. Next, remove the bolts attaching the plywood base, and set the bolts aside for use in mounting the machine.

B. FITTING THE MACHINE TO THE TABLE TOP

1. The machine should be mounted on a blank table top.

C. LOCATING THE MACHINE WITH RESPECT TO THE TABLE EDGE

1. The 1200-SF is set even with the front edge of the table top. After establishing the position of the machine as noted above, move it sideways until the machine handwheel lines up with the motor drive pulley. The belt slot may now be cut in the table top. Install the belt to insure that the correct machine locatior has been established. Mark the center of the bolt holes in the base of the machine, and remove the machine from the table top. Drill 3/8" holes for the mounting bolts, place the felt pad, supplied with each machine, on the table top, replace the machine in its proper location and install the attaching bolts, washers and nuts. Insure that the machine is firmly clamped in position and the bolts securely fastened.

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2. Position the thread stand behind the machine to the right of the handwheel, and secure in place with the supplied wood screws.

D. MOTOR DRIVE

1. The machine is shipped with a handwheel and pulley combination which is properly sized to insure operation at the correct speed when used in accordance with the following recommendations. When an individual motor and clutch unit is employed, it is recommended that the motor be rated at 1/3 HP and 1750 RPM. On all standard models, a 2-1/2" pulley should be used.

2. Either V-belting or round leather belting may be used. When installing the belt, use just enough tension to prevent slippage. Excessive tension will cause rapid belt wear and can possibly damage the machine

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II. OPERATING INSTRUCTIONS

A. LUBRICATING THE MACHINE

1. Before operating the machine, it is extremely important that it be properly lubricated in accordance with the following instructions.
2. Place a few drops of oil at all the points shown on the oiling chart in Figure 1. Remove the table cover shown on Figure 1 by loosening the cover attaching bolt "A". Then place a few drops of oil at all the points shown on the oiling chart in Figure 2.
3. In production use, the machine should be oiled on a daily basis in accordance with the instructions in Item 2 above.

B. ADJUSTING THE KNEE LIFTER

1. In order to insure optimum operator comfort, the knee lifter may be adjusted.
2. To place lifter pad in proper position, loosen two screws (Item E, Fig. 1) and push down on rod (Item F) until the lifter pad is in comfortable position for operator knee, then tighten screws.

C. THREADING THE MACHINE

1. Use any type of thread which is suitable for the work being sewn. This includes mercerized, nymo 000, mercerized 00/2, 70/2 and nylon K15 or K13.
2. Prior to starting the threading operation, the handwheel should be turned in the direction away from the operator until the needle reaches the extreme right hand portion of it's swing. This will put it into the most convenient position for threading.

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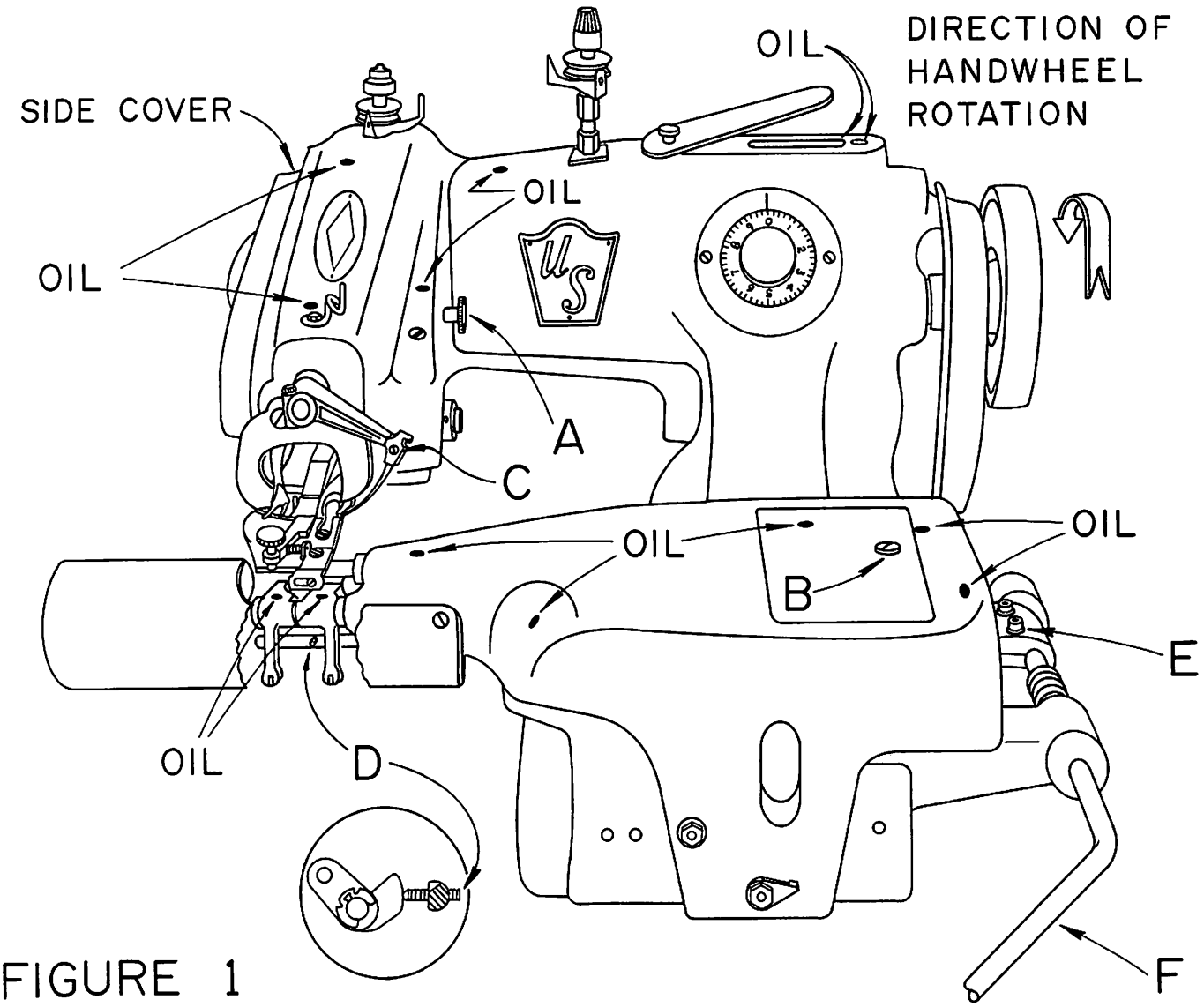

FIGURE 1

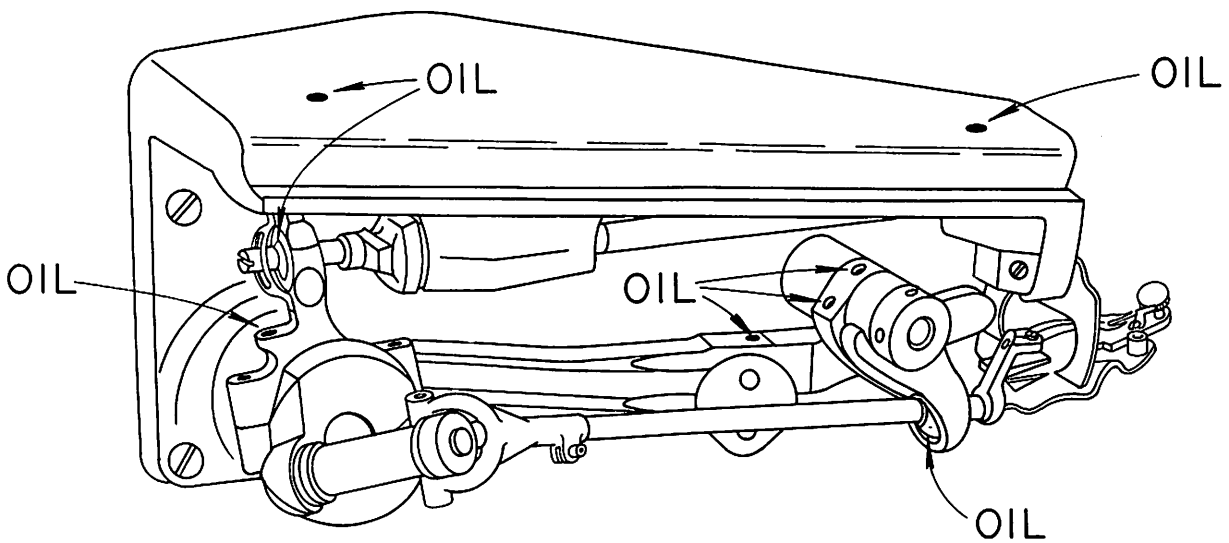

FIGURE 2

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3. Referring to the threading chart in Figure 3, it can be seen that the threading procedure is a simple one. The thread is passed from front to back through guide hole "A". It then slides between the two tension discs "B" and is carried to the left through guide hole "C". It then slides between the two tension discs "D" and is brought forward along "E" through the front thread guide "F". It then is passed through the needle clamp guide hole "G", then through the eye of the needle "H", entering on the underside of the needle and being removed at the top. The thread should be pulled through to extend past the eye of the needle by a few inches.

D. INSERTING THE WORK IN THE MACHINE

1. Prior to inserting the work, the handwheel should be turned in the direction away from the operator until the needle reaches the extreme right hand portion of its swing.
2. The knee lifter is then pressed to the right which drops the feed frame and creates a gap between the presser foot and the plattens.
3. The work is inserted underneath the presser foot and the edge of the lining fold or with the center of the spring-loaded cloth retainer or "shoe". The lifter is then released which locks the work in position. It is very important to insure that during machine operation, the operator's knee is not permitted to rest against the knee lifter. This can effect needle penetration and result in non-uniform stitch quality.
4. A trial run should be made along a few inches of work.

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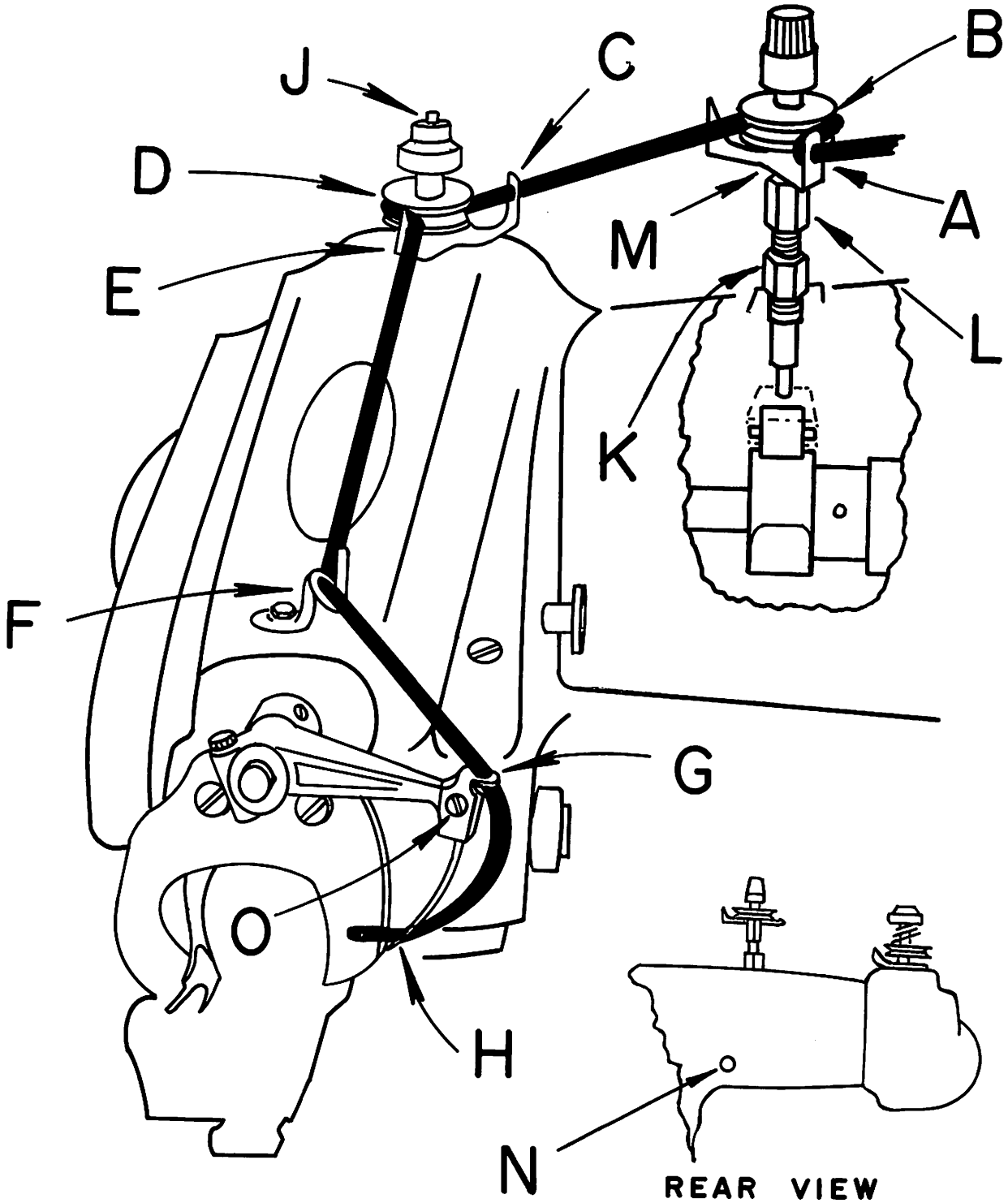

FIGURE 3

Threading Diagram For 1099SF and 1200SF

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Do not attempt to pull the work through the machine as the machine will feed it automatically at the proper rate. The operator merely needs to guide the work by resting it against the edge guide located on the presser foot.

E. ADJUSTING THE STITCH LINE LOCATION

1. If, on the trial run, it is found that the stitch formation has missed the edge of the hem fold or ribbon, the edge guide, which is located at the front of the presser foot, should be moved to the left.
2. If it is found that the stitch formation is too far past the edge of the hem fold or ribbon, the edge guide should be moved to the right.

F. ADJUSTING THE LENGTH OF STITCH

The stitch length is factory set.

G. ADJUSTING THE DEPTH OF NEEDLE PENETRATION

1. The shoe is designed to control the edge of the lining and the penetration depth made by the needle.
2. If an adjustment is necessary, do the following: Insert sleeve in place for sewing, but not over vents or seams. Loosen adjustment screw, item "E", Figure 7, so that shoe does not bear down on fabric. Turn handwheel away from you until needle penetrates lining and upper part of the sleeve only. If needle does not penetrate fabric, adjust penetration dial, Figure 4. With the needle penetrated through the lining and the upper part of the sleeve, turn shoe adjustment screw so that shoe rests lightly on fabric. Try the sleeve application. If the needle penetration is too deep, the thumb screw Item "E", should be moved in direction of arrow; if penetration is not deep

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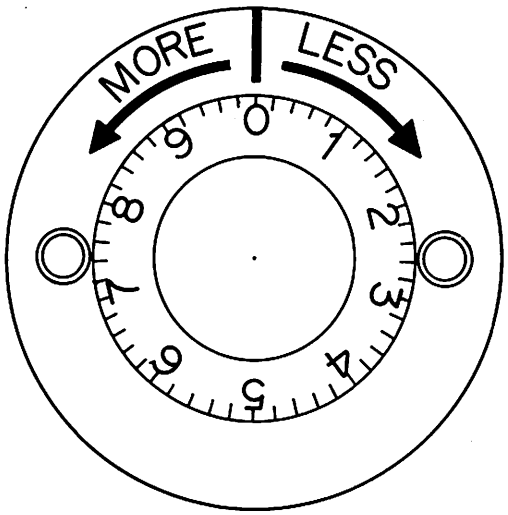
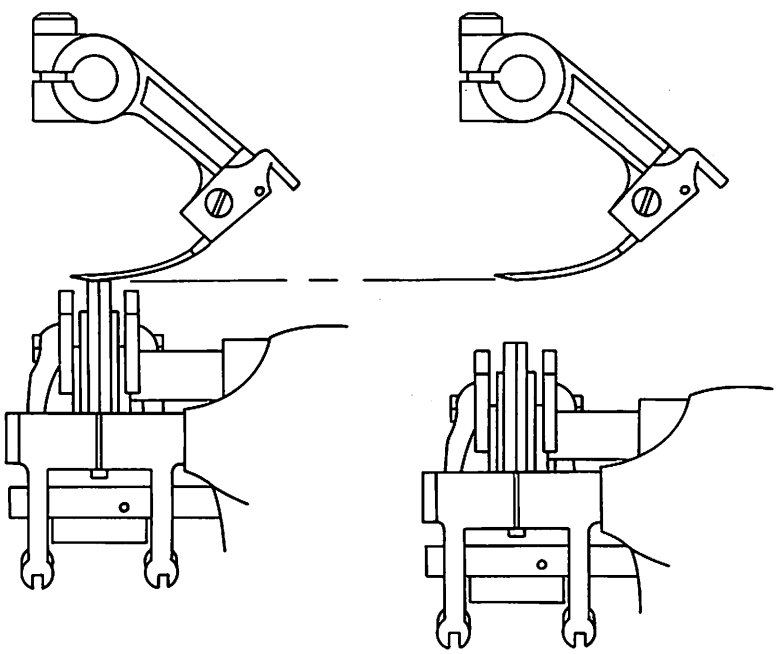


PENETRATION DIAL



RIB SHAFT ADJUSTMENT FOR - MORE -

RIB SHAFT ADJUSTMENT FOR - LESS -

FIGURE 4

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enough, turn screw in opposite direction of arrow. If the alignment of the lining edge is not correct, then guide Item "F" should be moved to correspond. Naturally, if there is an extreme fabric thickness change, such as going from a tropical to a heavy tweed, further adjustments are required on the dial.

H. ADJUSTING SPRING LOADED RIB - SERVICE MAN ONLY

1. This machine is equipped with a spring loaded fall-away rib which can be adjusted for a desired load.
2. This adjustment is made by turning screw, Item "D", Figure 1, which is reached through the right hand clearance hole of the cylinder using a 1.5 MM (.059) allen wrench. Turn the screw clockwise for more tension, counter clockwise for less tension. This screw has been sealed in place with locktite and may be hard to turn. However, after overcoming the initial tightness, it can be moved and will remain in place without vibrating loose.

I. REPLACING THE NEEDLE

1. U.S. needles are designed and manufactured specifically to meet the precise sewing requirements of the U.S. BLIND STITCH MACHINES. Because of the importance of a properly designed needle in achieving consistent high quality stitching, it is extremely important that only GENUINE U.S. NEEDLES be used at all times.
2. When it becomes necessary to replace worn or damaged needles, the following procedure should be followed:
   a. Turn the penetration dial to the right ("Less") three or four numbers to insure that the rib is lowered sufficiently to clear the needle.

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b. Loosen the needle clamp screw (Item "C" in Figure 1), slide the clamp forward sufficiently to release the old needle, remove and discard it. Insert the new needle and push it up into the groove of the needle lever as far as it will go. Make sure that the flat on the shank of the needle faces forward and the needle is properly seated in the groove. Tighten the needle clamp screw and turn the handwheel slowly making sure that the needle passes lightly over the needle guide on the presserfoot and clears the looper.

c. Readjust the needle penetration as described in a previous section, prior to resuming operation.

3. Needles

NEEDLE SIZES AVAILABLE

Use Genuine U.S.B.S. Needles for Best Results

Long Needles - System 251

Sizes 30, 35

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III. MAINTENANCE INSTRUCTIONS

A. REPLACING THE LOOPER

1. Should it become necessary to replace the looper (Item "B" in Fig. 6) do the following: with the looper at the left of the foot, turn the handwheel clockwise until the point of the needle is in the middle of the foot opening. Loosen the looper clamp screw (Item A, Fig. 6) and pull the looper out approximately 1/8 of an inch. Turn looper clockwise upside down and pull out. To replace the looper, reverse the above procedure.

2. Any time a looper is moved or changed. recheck the looper timing and reset if necessary. Proper looper timing is absolutely essential for correct stitch formation. As described in detail below, a properly timed looper will pass over the needle in the correct position to pick up the loop, and also clear the chain-off pin, feeder, looper slot, and needle. The first check point for timing the looper is at the position where the looper picks the thread loop off the needle during the needle return stroke. Referring to Figure 7, (Point "C"), the long prong of the looper should pass over and just clear the scarf of the needle, approximately 3/32" (2.4MM) behind the end of the needle eye. At the same time, the short prong of the looper should pass over the needle with about 1/64" (.406MM) clearance, and must be so set that it also clears the chain-off pin (Item "D" in Figure 7).

3. In the event that the timing of the looper must be changed, the crank cam can be adjusted. The normal setting of the crank cam (Item B, Figure 5) is the timing mark on the

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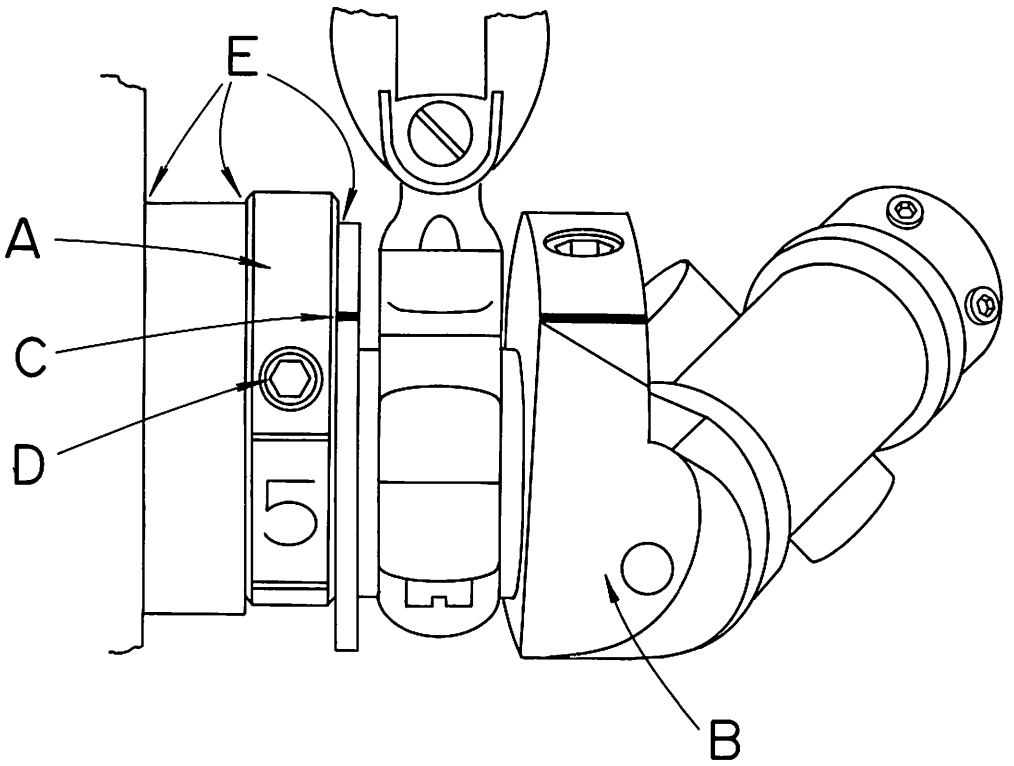

FIGURE 5

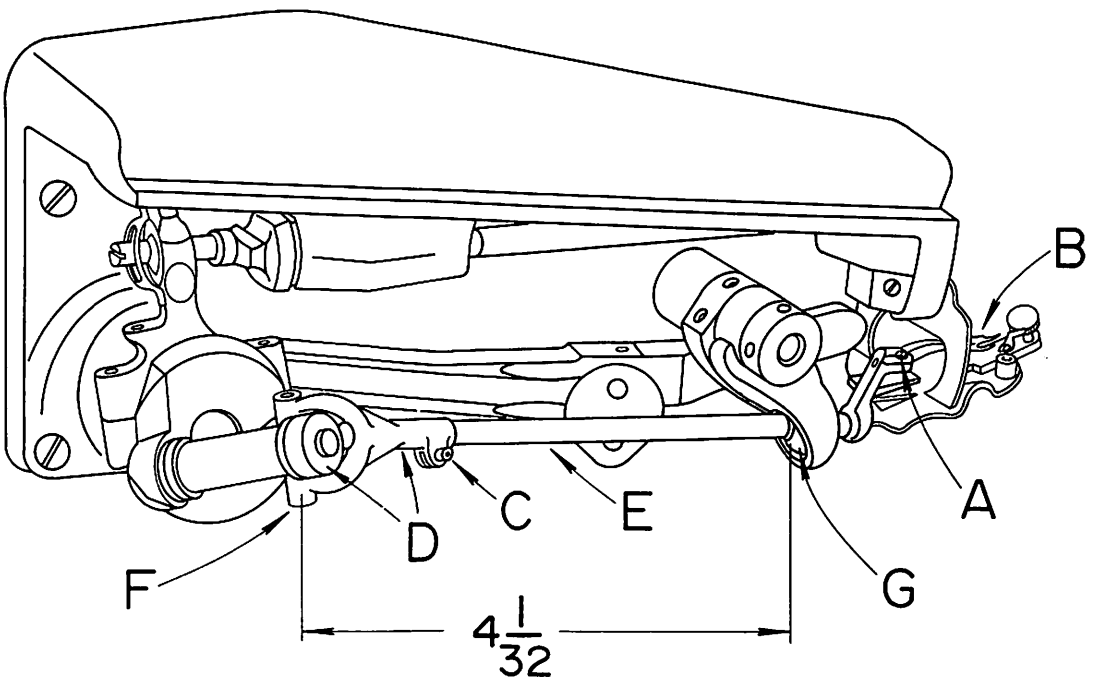

FIGURE 6

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cam corresponding to the notch in the rim of the feed eccentric Item C. Turning the crank clockwise will speed up the looper on the left side of the foot and slow it down on the right side of the foot. Reversing the movement of the cam will produce a reverse action of the looper.

B. REPLACING THE NEEDLE GUIDE

1. After considerable service, it may be expected that the wearing action of the needle will cause a sharp edged groove to form on the needle guide (Item "G" in Figure 9). This condition can cause thread breakage and uneven penetration. When this happens the guide should be replaced The needle guide was specifically designed as a readily replaceable wear plate to prevent damage to the presser-foot from the action of the needle.

2. Loosen the needle guide attaching screw (Item "A" in Figure 9) and remove the worn needle guide. Clear out any lint or dirt that may have accumulated under the old guide and insert the new guide. Insure that the new guide is seated flush with the top and side of the presser-foot and then retighten the attaching screw. Slowly turn the handwheel in the direction away from the operator and check to insure that the new guide fits properly under the needle and that no interference has been introducted between the guide and the looper.

C. REPLACING THE SHOE

1. The shoe, (Item "E" in Figure 8), also known as a cloth retainer, normally will not require replacement. However, in the event of wear due to the particular fabrics being

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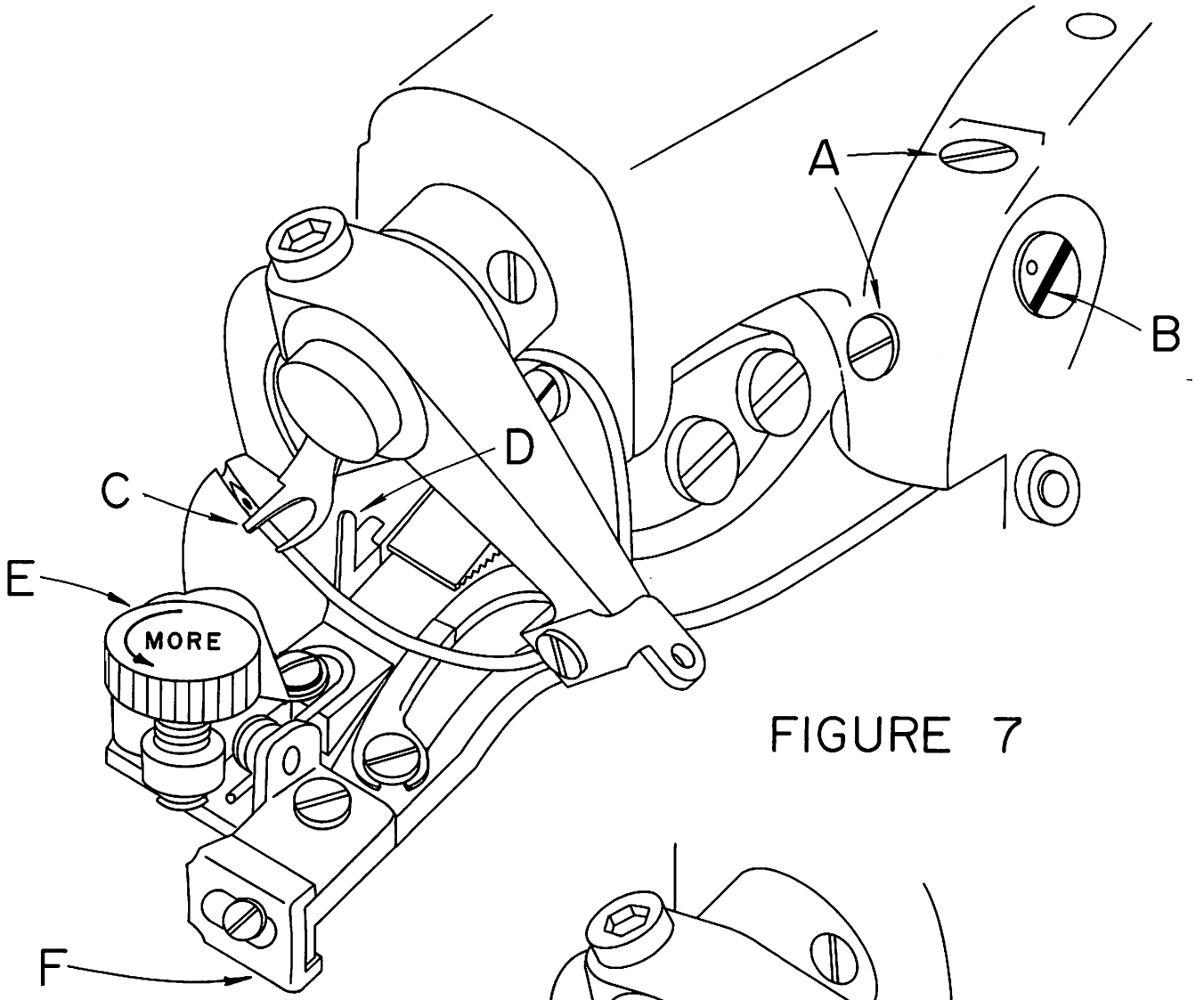

FIGURE 7

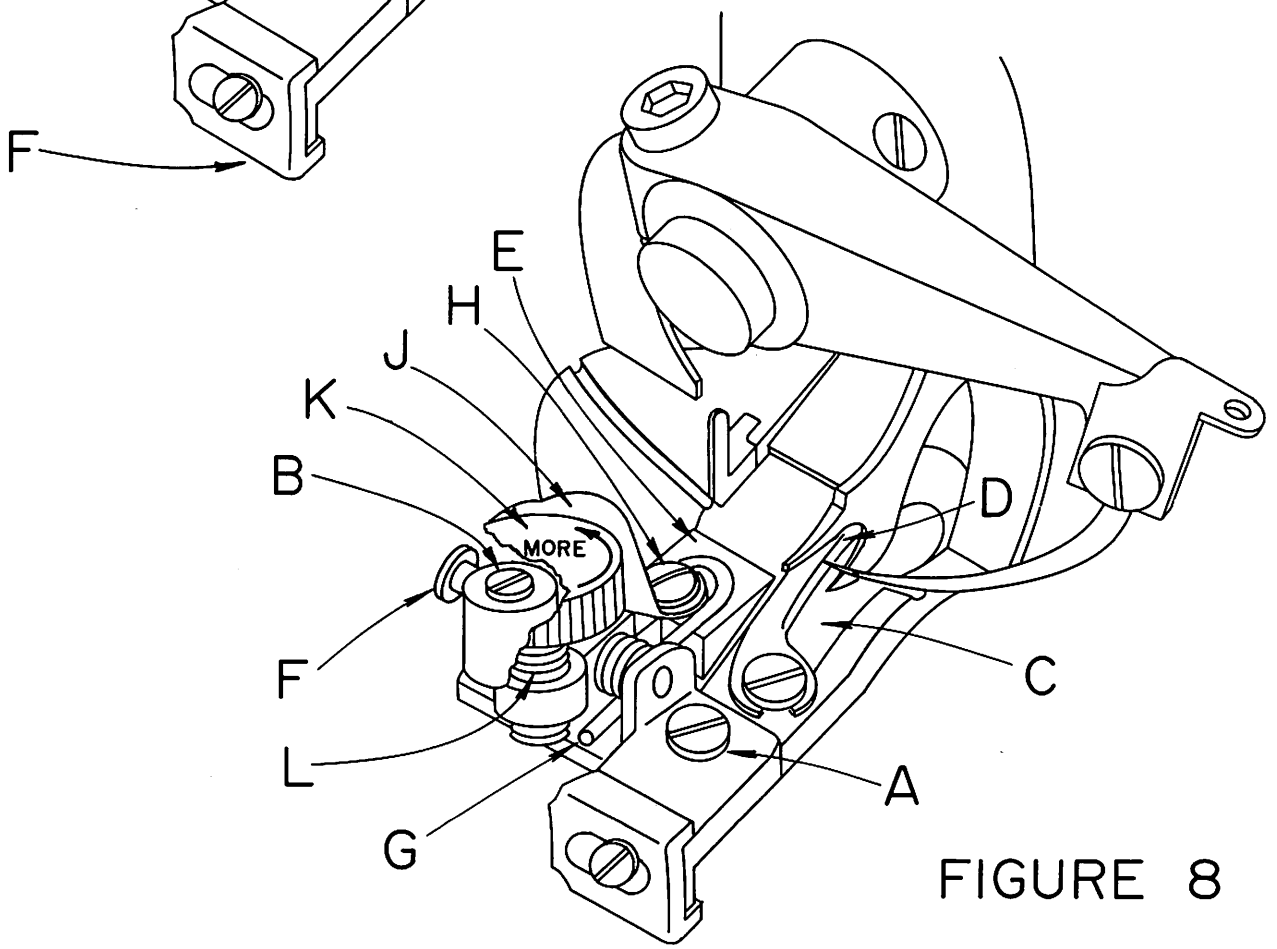

FIGURE 8

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used, or if the shoe or spring suffers any damage, they may be readily replaced.

2. The first step is to loosen the complete front guide assembly by unscrewing the front guide holder attaching screw (Item "A" in Figure 8). Next, loosen the shoe pin locking screw (Item "B", Figure 8) and slide out the shoe pin (Item "F"), shoe and retaining spring (Item "G"). Before removing these components it is advisable to note the manner in which the spring is assembled so that it may be reinstalled in the same way. Remove Items H, J, K and L. Attach these items to the new shoe.

3. When replacing an old shoe, make sure that the replacement shoe properly fits the pin without binding and without excessive looseness. In the event that the pin has worn, it should be replaced. After replacing the shoe, shoe pin spring and shoe pin, retighten screws (Items "A" and "B", Figure 8), and check to insure that the center of the shoe is lined up with the center of the rib. Also insure that the shoe clears both sides of the opening of the presserfoot.

D. REPLACING THE CHAIN-OFF PIN

1. After considerable service, it may become necessary to replace the chain-off pin, (Item "D" in Figure 7).

2. Remove the chain-off pin attaching screw and remove the chain-off pin, clean out any lint or dirt that may have accumulated. Attach the new chain-off pin, using the screw previously removed. Insure that the chain-off pin is against the side and forward edge of the slot in the presserfoot, and then tighten the screw.

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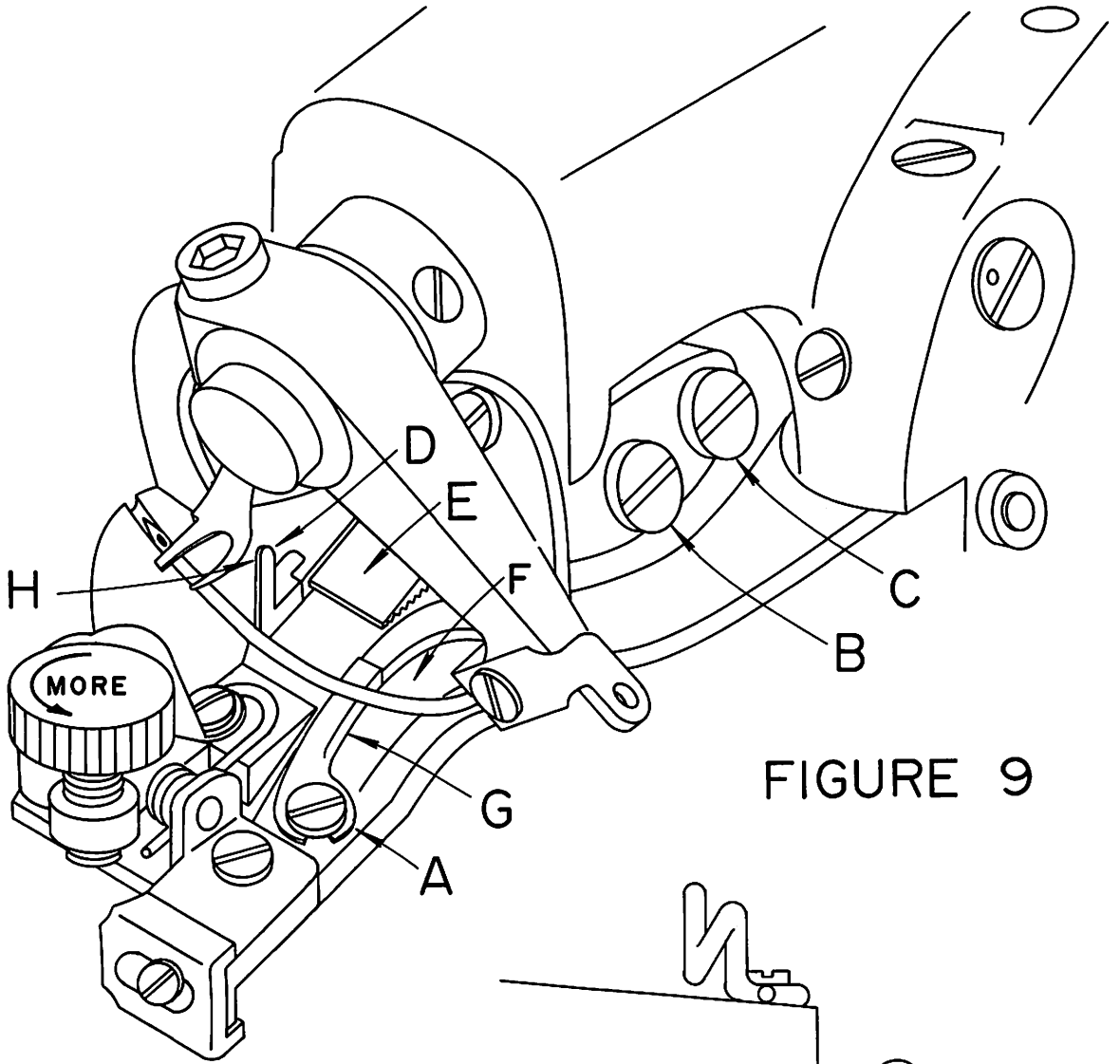

FIGURE 9

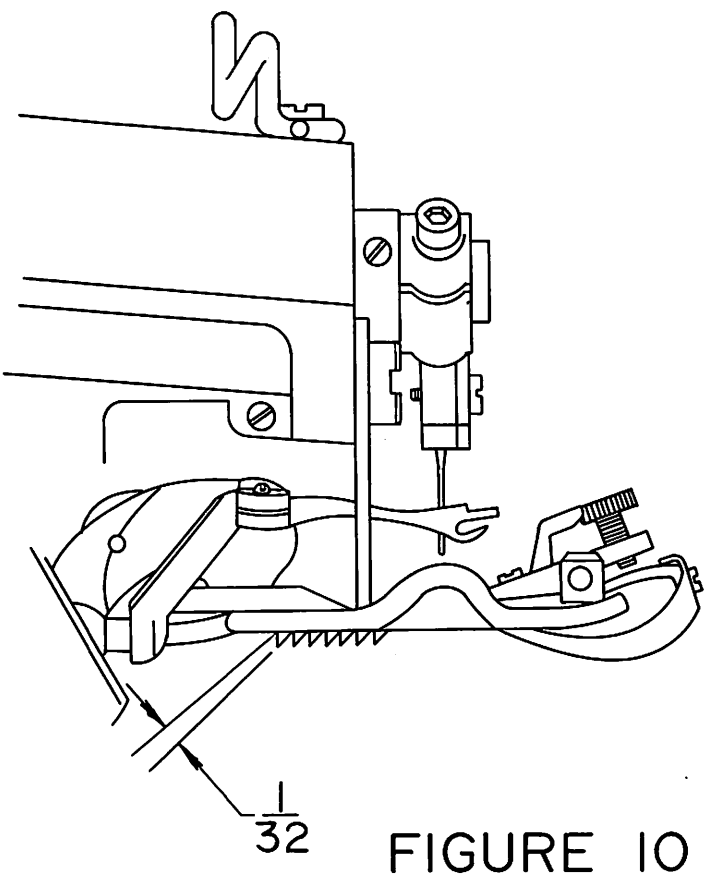

FIGURE 10

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E. REPLACING THE FEEDER

1. In the event that the machine develops difficulty by failing to properly feed the work, a worn feeder is frequently found to be the cause. After considerable service, especially with certain hard fabrics, the feeder teeth have a tendency to become dull, and the feeder should be replaced. In order to remove the old feeder, remove the front feeder attaching screw (Item "B" in Figure 9) and loosen the rear feeder attaching screw (Item "C" in Figure 9). The old feeder may then be slid out of place. Insert the new feeder under the rear screw and replace the front screw.

2. Before tightening the attaching screws, check to see that the feeder is set to the proper depth. Referring to Figure 10, this should be approximately 1/32" (.795MM) below and parallel to the bottom of the presserfoot for all light and medium weight fabrics. For heavy fabrics, the setting should be approximately 1/16" (1.59 MM) below and parallel to the bottom of the presserfoot. These dimensions are intended as guides and may be modified as required by the specific fabrics. Once the proper depth is established, rotate the handwheel slowly in a direction away from the operator and check to insure that the feeder clears the looper (see Figure 9, Point "H")and also clears both sides of the feeder slot in the presserfoot. Firmly tighten feeder attaching screws (Figure 9, Items "B" and "C") before resuming sewing.

F. THREAD TENSION RELEASE

1. The purpose of the thread tension release is to obtain

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uniform thread tension over seams and vents. This tension is factory adjusted when the machine is sewed off. Turn the handwheel clockwise as you pull on the thread. A distinct locking and releasing of the thread should be felt twice with each revolution of the handwheel. In the event a minor adjustment must be made, do the following referring to Figure 3, release locking nut Item "K" (using a 9/16 open end wrench) just enough so that the tension assembly can be moved. Turn Item "L" (using a 1/2 open end wrench) clockwise for more release and counter clockwise for less release. For best results, keep release of thread to a minimum. Retighten release locking nut Item "K". If necessary to reposition thread guide turn Item "M" (using a 3/8 open end wrench).

G. TIMING OF THREAD RELEASE - SERVICE MAN ONLY

1. The thread should release when the needle is located 3/8 of an inch from the left edge of the presserfoot (Figure 7). This measurement is to be taken when the needle stroke is moving towards the left side of the foot.

2. If an adjustment is needed, the tension lift cam located directly under the release tension assembly can be reset. Open the top window plate, looking in, place a 3/32" allen wrench through the opening in back of the machine, Item "N" Figure 3, and loosen the unmarked screw. Insert the same 3/32" allen wrench into the marked screw, loosen and hold in place. Turn the handwheel clockwise until the eye of the needle is in line with the right edge of the presserfoot and tighten screw. Check the timing of the

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thread release as described in Paragraph 1. If the needle is not 3/8 of an inch from the edge of the presserfoot when the thread is released, readjust the cam. After all adjustments are made, tighten both screws.

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PARTS CATALOG

TO MAINTAIN EFFICIENCY OF THE ORIGINAL EQUIPMENT
GENUINE U.S. PARTS AND NEEDLES ARE RECOMMENDED

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MAIN FRAME GROUP

*5001	Side Cover Assembly (for 1200SF only)
1401	Washer, Clamp Screw
5019	Screw, Side Cover
*1068	Guard, Belt (for 1200SF only)
1069	Screw, Guard
5198	Thread Tension Regulating Ass'y.
	Consists of:
	1084 Thread Guide
	1083 Disc. Thread Tension
	1082 Post, Thread Tension
	1329 Spring, Tension
	1994 Nut, Tension
1005	Tube, Oil
1006	Wick, Oil
1093	Screw, Set
1289	Screw, Set
1240	Pin, Presserfoot
1089	Screw, Set
*1081	Plate, Top Cover (for 1200SF only)
1096	Screw, Top Cover
1107	Screw, Bridge Mtg.
1054	Washer, Clamp Screw
1108	Screw, Clamp
1080	Thread Guide
1070	Screw, Thread Guide
5197	Thread Tension Release Ass'y.
	5217 Regulator Ass'y.
	1953-1 Rod
	1954 Spring
	1959 Nut
	1955-1 Sleeve
	1084 Thread Guide
	1957 Post
	1021-6 Spacer
	1083 Disc
	3046 Disc
	1085 Spring
	1011 Ratchet
	3069 Nut

*For the 1099SF use the following:

5182	Side Cover Assembly
7028	Top Cover Plate
7004	Belt Guard

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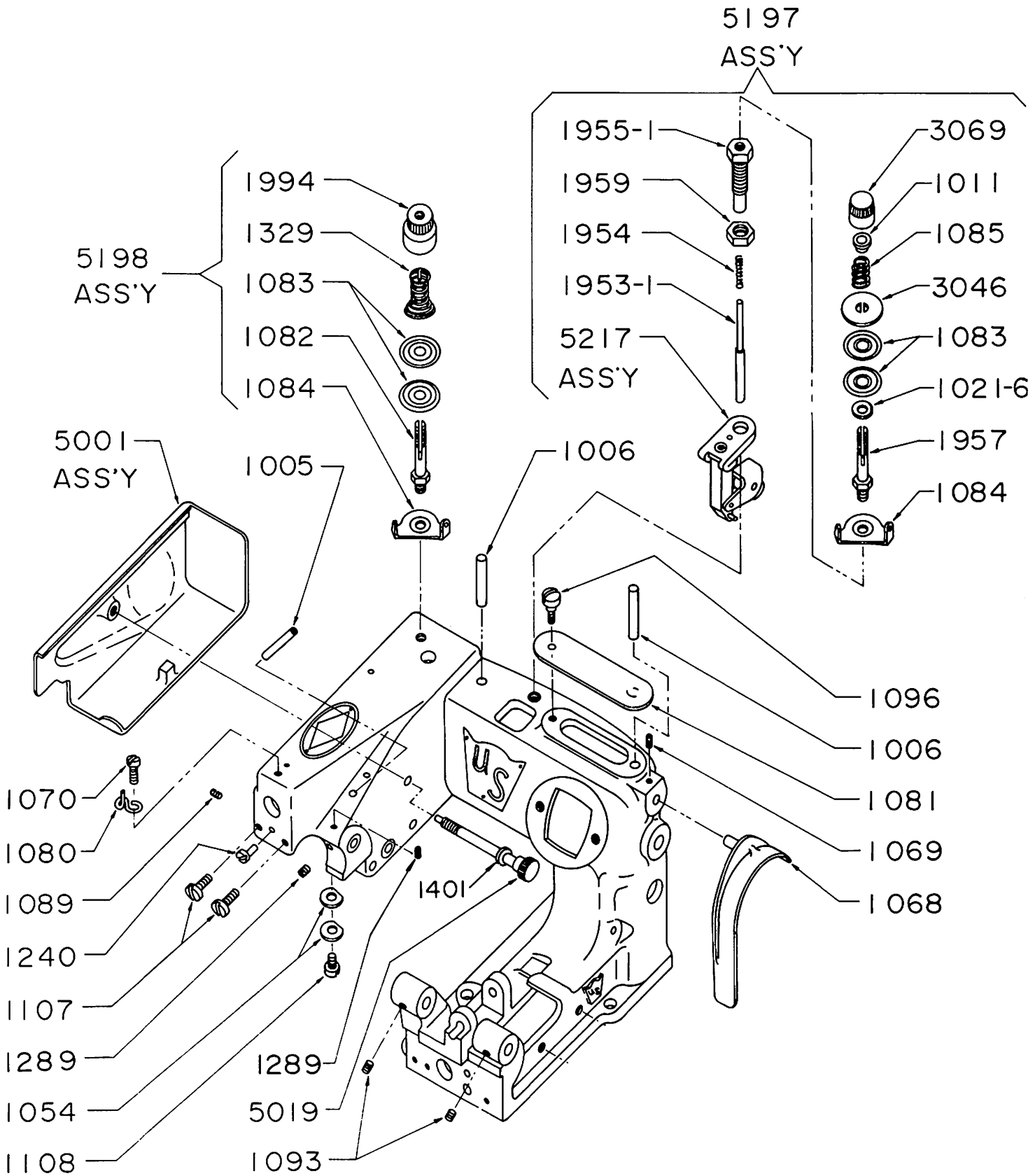

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MAIN SHAFT GROUP

***1964 Main Shaft (for 1200SF only)

5003-1* Rib Connection Lever & Eccentric Ass'y.
- 1974 Screw Eccentric
- 1973 Screw For Stud
- 1880 Screw, Clamp

5194-1* Needle Connection Ass'y.
- 1072 Screw
- 1134 Guard
- 1132 Screw
- 3061 Screw
- 3276 Screw
- 1946 Crank

1845 Collar Ass'y.
- 1971 Screw

5226** Handwheel Ass'y.
- 3290 Handwheel
- 3291 Screw
- 3032 Pulley Ass'y.
  - 1121 Screw
  - 1069 Screw

5232 Stitch Collar Ass'y., Regular
- 1834 Set Screw

5224 Cam Ass'y.
- 1814 Screw

*Sold as an Assembly Only

**The Following Optional Handwheel Ass'y. is Available

5188-1 Handwheel With Position Hub

***For the 1099SF use the following:

7012-1 Main Shaft

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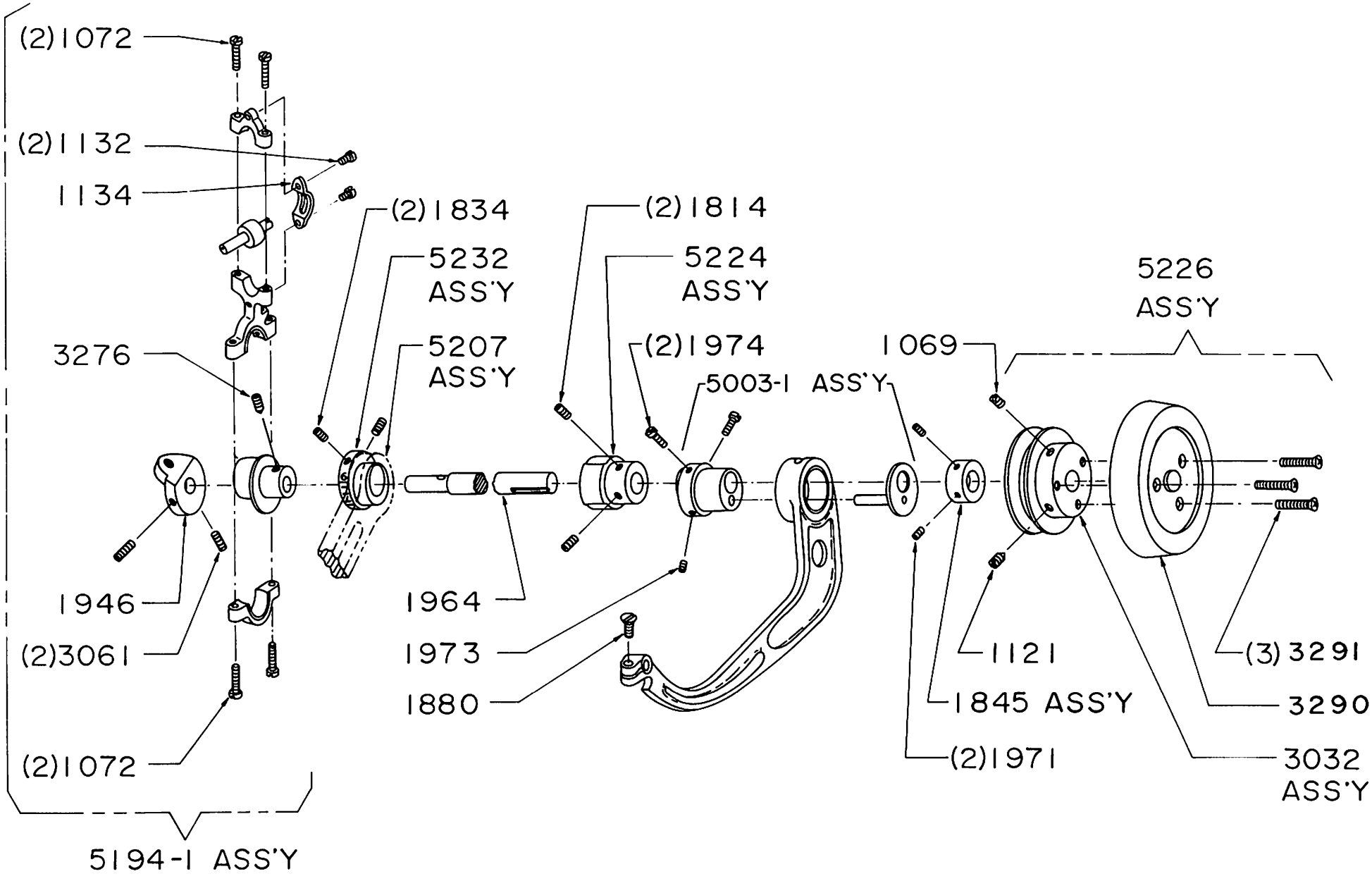

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1099SF/1200-SF

NEEDLE DRIVE GROUP

5184	Needle Lever Ass'y.		5135	Collar Ass'y.	
	1076	Screw		1089	Screw
	3050	Screw	1095	Shaft	
	1945	Clamp		1118	Screw
	1243	Pin			
	1944	Lever			

NEEDLE SIZES AVAILABLE

Use Genuine U.S.B.S. Needles For Best Results

System 251 Size 35 or Size 40 for Heavy Sleeves

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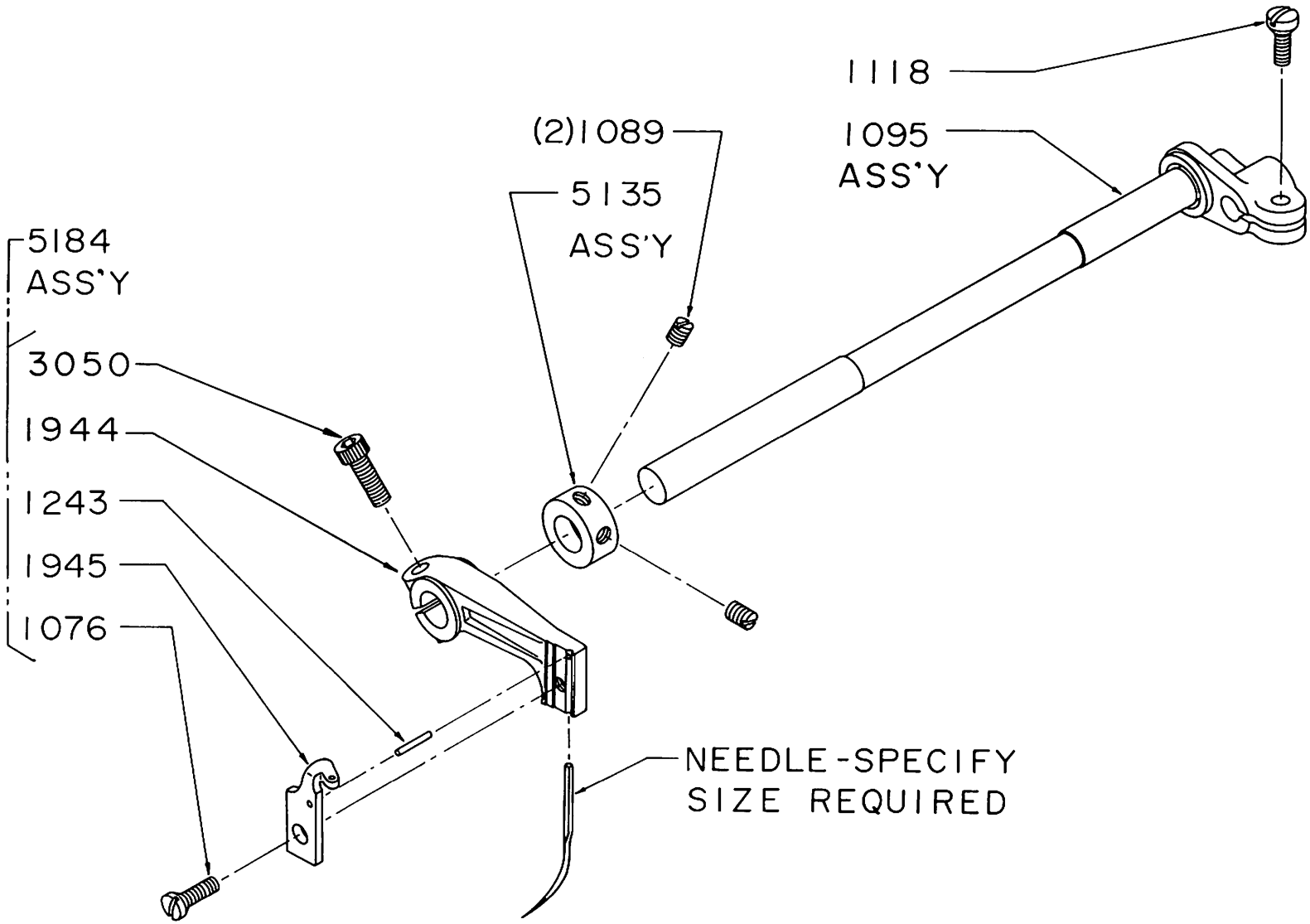

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1099SF/1200-SF

FEED DRIVE GROUP

5212	Feed Lever & Stitch Collar Ass'y. (Sold as Ass'y. only)
1834	Screw
5023	Feed Rocker Ass'y.
1821	Thrust Collar Ass'y.
	1870 Set Screw
2124	Feeder
	1119 Feeder Screw

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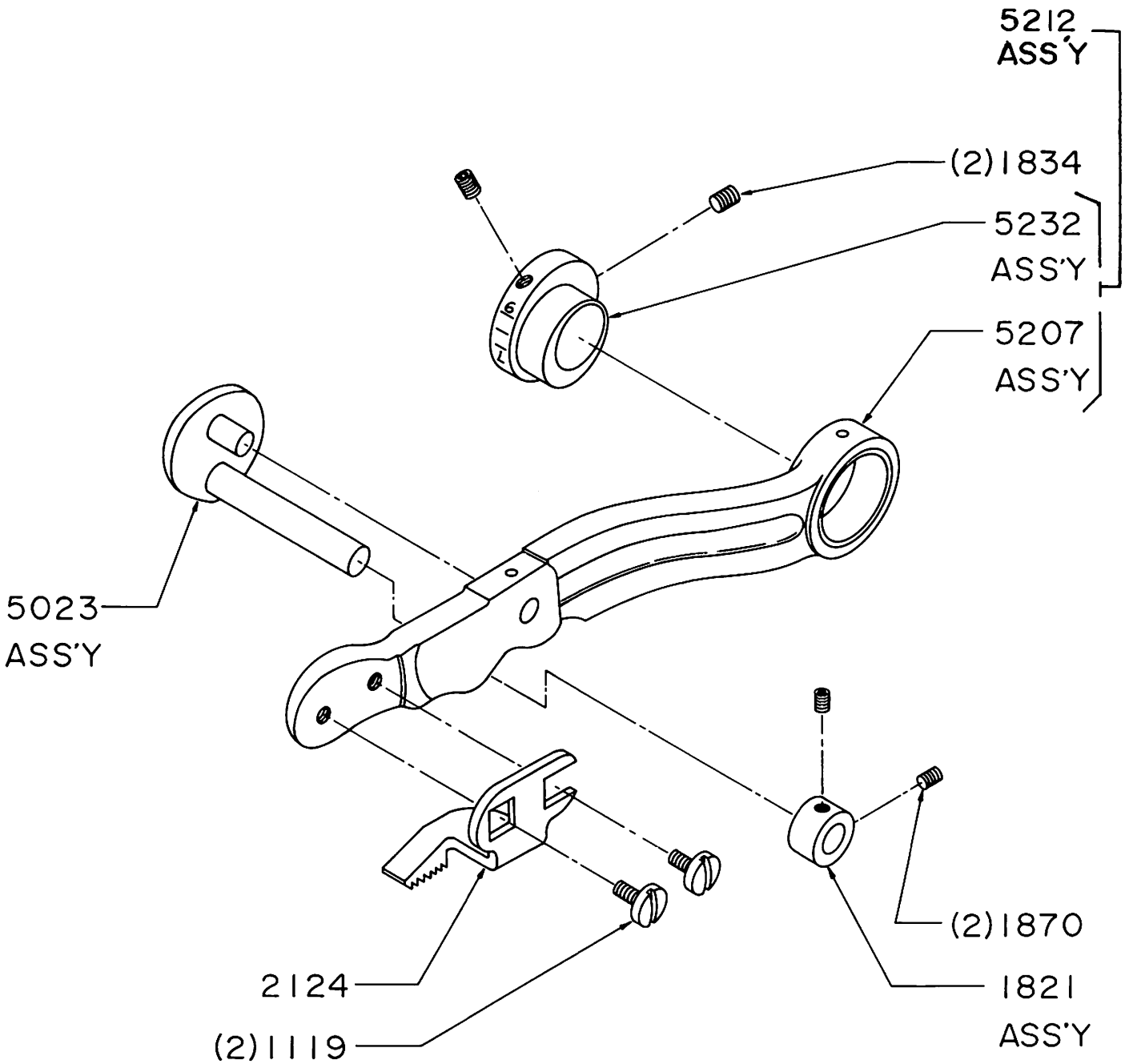

FEED DRIVE GROUP

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1099SF/1200-SF

LOOPER DRIVE GROUP

Part No.	Description
2203	Looper
1150	Stud, Looper Adjustment
5233	Collar Ass'y.
	1870 Set Screw
5195	Looper Rod Fork, Sleeve & Stud Ass'y.
	Consists of:
	1154 Fork
	1155 Pin
	3049 Screw
	1979 Nut
	3297 Stud
	1094 Screw
5213-1	Looper Rod & Fork Ass'y.
	Consists of:
	5185-1 Looper Rod & Ball Ass'y.
	1154 Fork
	3049 Screw
	1979 Nut
5186-1	Looper Rod & Carrier Ass'y.
	Consists of:
	5017 Looper Rod Carrier Ass'y.
	1117 Screw
	5185-1 Looper Rod & Ball Ass'y.
5206-1	Looper Rod, Fork & Carrier Ass'y.
	Consists of:
	5186-1 Ass'y.
	1154 Fork
	3049 Screw
	1979 Nut

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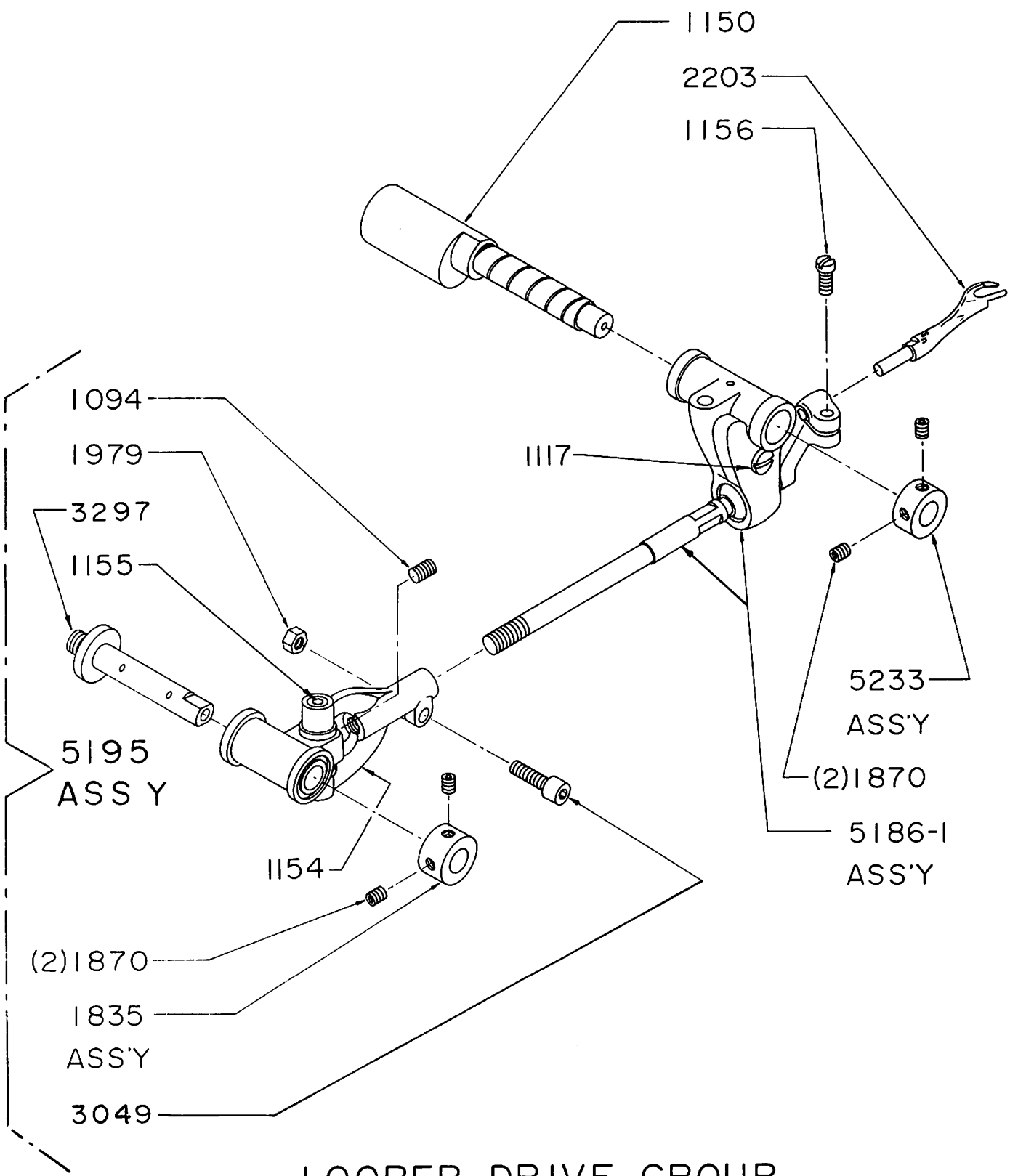

LOOPER DRIVE GROUP

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1099SF/1200-SF

FEED FRAME GROUP I

*5046-1	Feed Frame Ass'y.(for 1200SF only)
1836-1	Collar Ass'y.
	1077 Set Screw
5167	Rib Shaft Crank Ass'y.
	1117 Screw
*1205	Plate, Window(for 1200SF only)
*1030	Screw, Plate(for 1200SF only)
3057	Post, Spring
1262	Nut
2434	Platten, L.H.
1244-4	Screw, Platten
1146	Nut
1966	Screw, Cylinder
1167	Nut, Platten Lock
1836	Collar Ass'y.
	1079 Set Screw
6098	Rib Shaft Pawl Ass'y
	2086 Rib Pawl
	1158 Screw, Pawl
	1881 Nut
	*6095 Rib Shaft Ass'y. (for 1200SF only)
2483	BKT, L.H. Platten
2484	BKT, R.H. Platten
1379	Stud
1069	Set Screw
1021	Spacer :-1021-1 = .010"; 12 = .015", etc.
3062	Spring
1710	Screw, Limit
3056	Post
2435	Platten, R.H.
1113	Screw, Frame
*1213	Cylinder(for 1200SF only)
*1066	Shaft, Rocker(for 1200SF only)
3027	Plate Cover
1004-1	Stud
3280	Set Screw
3065	Spring
3063	Spring Pin
3059	Retaining Ring
3058	Yoke
3064	Retaining Ring

*For 1099SF use the following:

5179	Feed Frame Ass'y.
7019	Window Plate
1864	(2) Plate Screw
7014	Rocker Shaft
1213-1	Cylinder
8095	Rib Shaft Ass'y.

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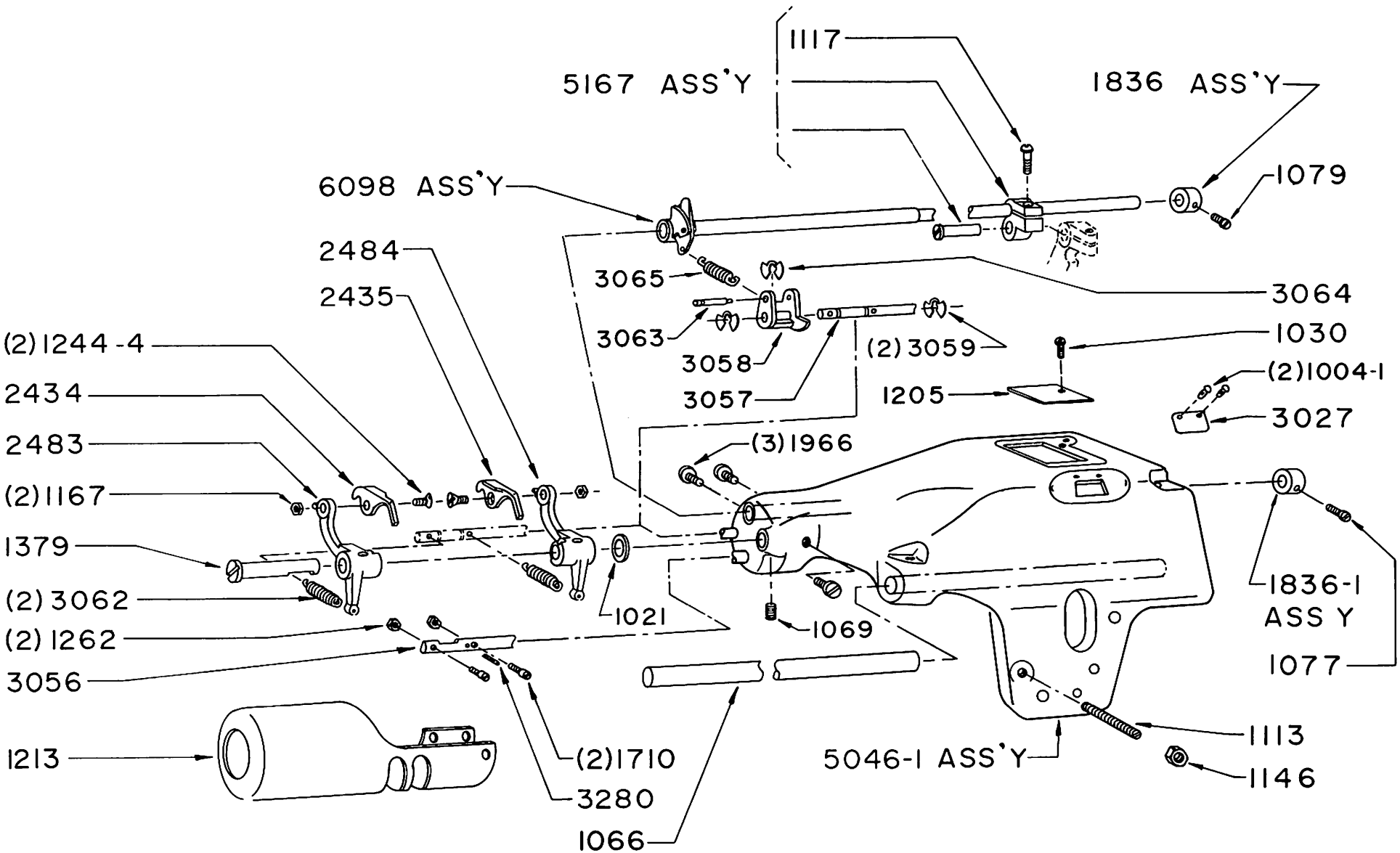

FEED FRAME GROUP I

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1099SF/1200-SF

FEED FRAME GROUP II

5020	Spring Link Ass'y.
	1176 Pin
1146	Nut, Ret'ng.
1177	Screw, Link
1184	Nut, Spring
1191	Main Spring
5235	Knee Pedal Ass'y.
	1208 Knee Pedal
	1037 Screw
7013	Key
3079	Knee Lift Rod
4544	Pad, Pedal
5237	Knee Lifter Bracket Ass'y.
	1841 Screw
	3048 Link
	1815 Bracket
	3299 Screw
	1054 Washer (For 3299 Screw)
1882	Washer
3047	Block
1117	Screw
1271	Knee Lifter Spring
1393	Screw
1414	Washer
1839	Bracket
1879	Screw
1008	Nut
1117	Screw

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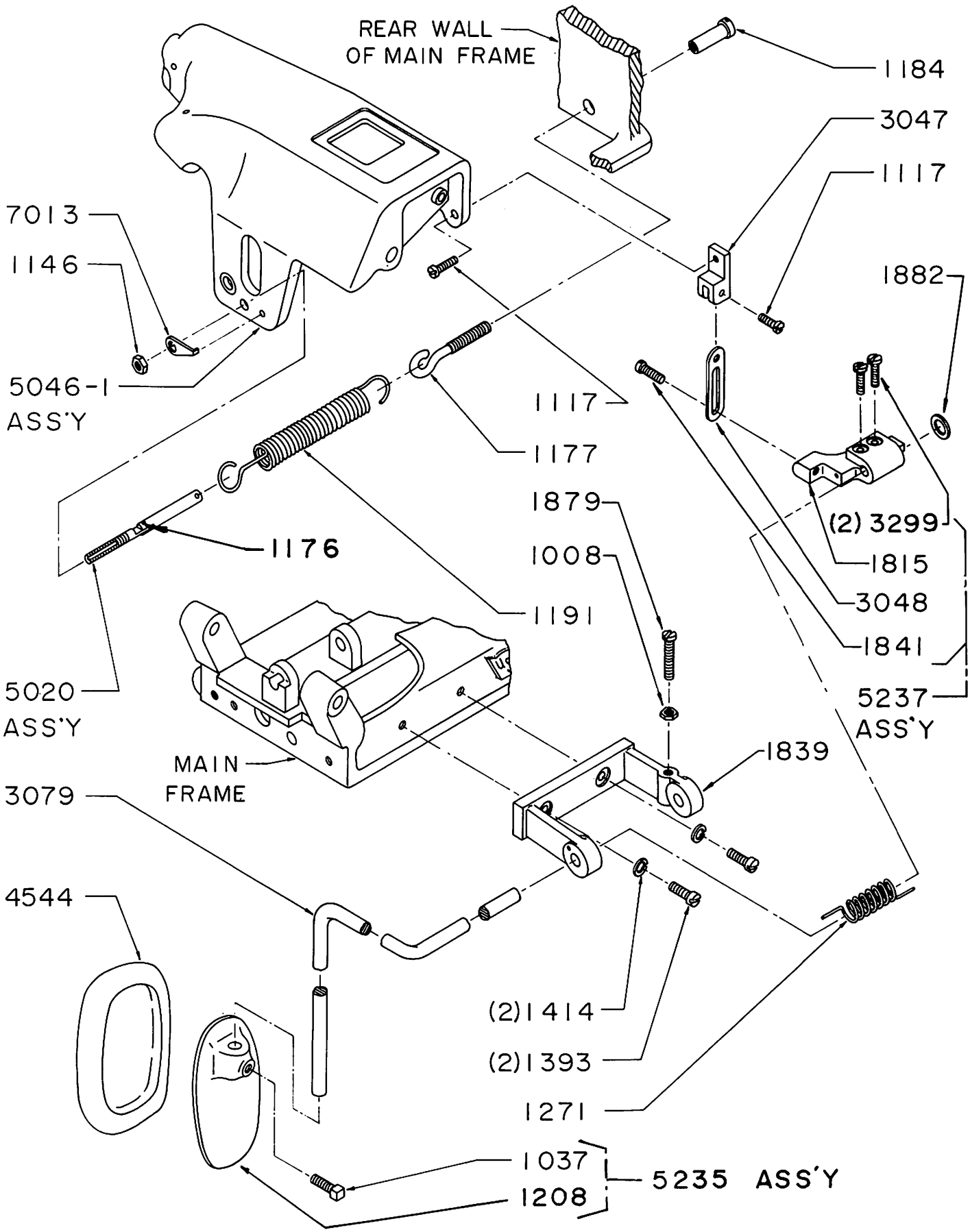

FEED FRAME GROUP II

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1099SF/1200-SF

REGULATING GROUP

1186	Regulating Fork
5012-1	Push Rod Ass'y.
	1023 Pin
	1024 Spring
1025	Pin
5018	Regulator Ass'y. - Complete
	1109 Screw, Regulator
	*5039 Dial & Ratchet Ass'y. (for 1200SF only)
	*5010 Dial Plate Ass'y. (for 1200SF only)
	1223 Shoe
	1222 Screw
	*1039 Screw (for 1200SF only)

*For the 1099SF use the following:

5173	Dial & Ratchet Ass'y.
5178	Dial Plate Ass'y.
1977	Screw

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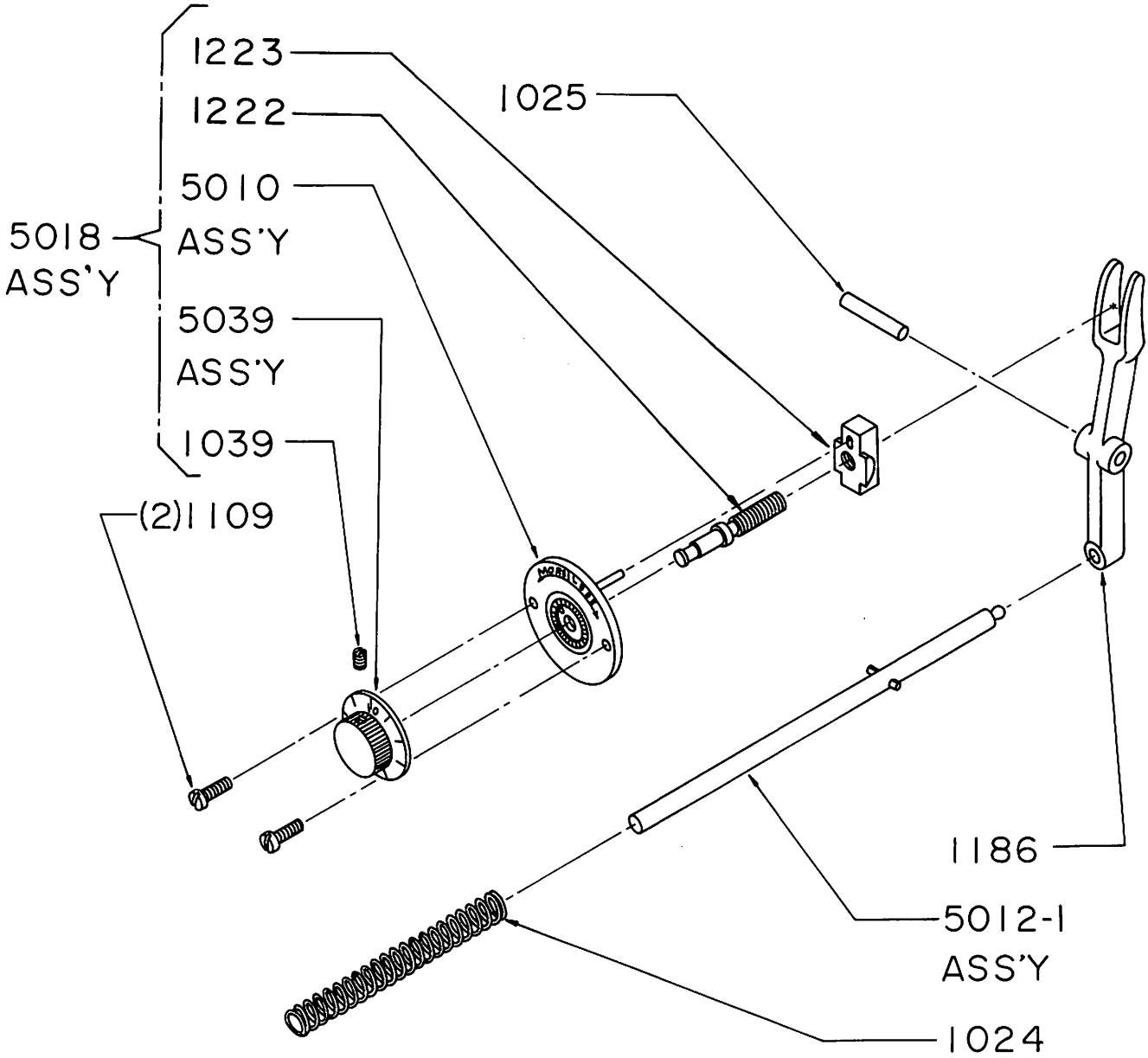

REGULATING GROUP

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1099SF/1200-SF

PRESSERFOOT ASS'Y.

5214	Shoe Ass'y.
	1075 Screw
	1372 Lock Spring
	1308 Screw
	1305 Spring
	2542 Shoe
1099	Screw
1943	Spring
1967	Bracket
2620	Edge Guide
1079	Screw
1237	Pin
1106	Set Screw
6194	Presserfoot Ass'y.
	1866 Screw
	1961 Pin, Chain Off
	1102 Screw
	1960 Guide
1054	Washer
1108	Screw
1107	Screw

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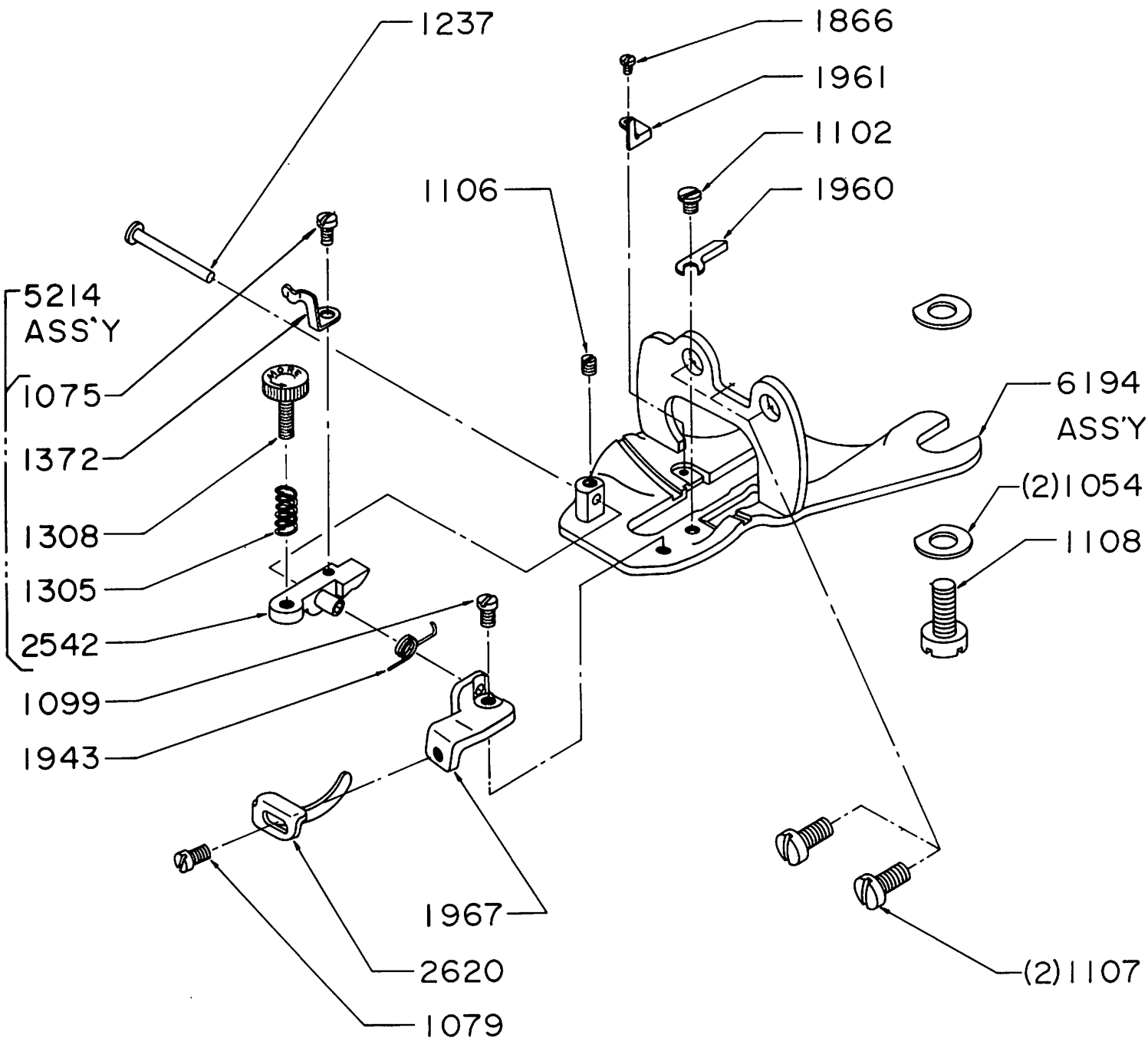

COMPLETE ASS'Y 5259

PRESSERFOOT GROUP

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Notes

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Top-quality sewing demands top-quality machines equipped with top-quality needles to achieve perfect results.

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500/885

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