

**CHANDLER MACHINE
USA**

**INSTRUCTIONS
&
PARTS BOOK
406RB-1**

**Chandler Machine USA,
LLC**

400 VETERANS BLVD, CARLSTADT NJ 07072

212-721-2474

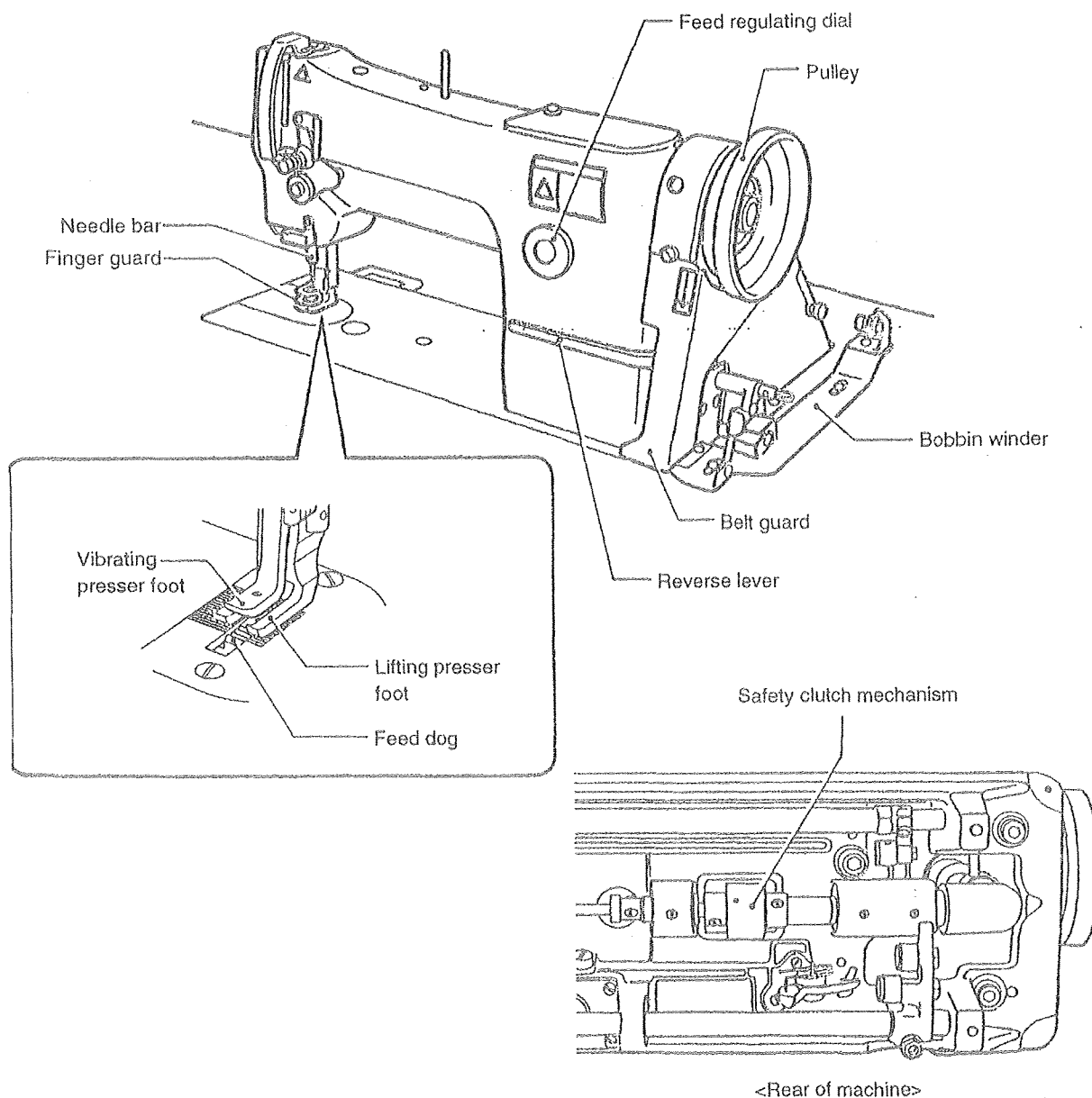
INSTRUCTION MANUAL
AND
SPARE PARTS MANUAL

CONTENTS

1. MAIN PARTS NAMES.....	1
2. SPECIFICATIONS.....	1
3. WORK TABLE AND MOTOR.....	2
4. INSTALLATION.....	3
4-1. Installing the rubber hinge and the corner rubber.....	3
4-2. Installing the oil pan.....	3
4-3. Installing the machine head.....	3
4-4. installing the spool pin.....	4
4-5. installing the knee lifter assembly.....	4
4-6. Installing the belt.....	5
4-7. Installing the bobbin winder.....	5
4-8. Installing the belt guard(L).....	6
4-9. Installing the thread stand.....	6
4-10. Lubrication.....	7
4-11. Checking the machine pulley rotating direction.....	8
5. PREPARATION BEFORE SEWING.....	9
5-1. Installing the needle.....	9
5-2. Removing the bobbin case.....	9
5-3. Winding the lower thread.....	10
5-4. Installing the bobbin case.....	10
5-5. Threading the upper thread.....	11
5-6. Adjusting the stitch length.....	11
6. SEWING.....	12
6-1. Sewing.....	12
6-2. Backtacking.....	12
7. THREAD TENSION.....	13
7-1. Adjusting the thread tension.....	13
7-2. Adjusting the presser foot pressure.....	13
8. STANDARD ADJUSTMENTS.....	14
8-1. Adjusting the thread controller spring.....	14
8-2. Adjusting the height of the feed dog.....	15
8-3. Adjusting the feed dog position (longitudinal).....	15
8-4. Adjusting the positions of the needle and needle hole of the feed dog.....	16
8-5. Adjusting the timing the needle with feed.....	18
8-6. Adjusting the height of the needle bar.....	18
8-7. Adjusting the timing between the needle and hook.....	19
8-8. Adjusting the clearance between rotary hook and opener (thread release finger).....	20
8-9. Adjusting the clearance between feed forked connection and feed fork collar.....	21
8-10. Adjusting the height of the presser feet.....	21
8-11. Adjusting the presser foot movement amount.....	22
8-12. Adjusting the timing of the vibrating presser foot.....	23
8-13. Adjusting the feed regulator.....	24
9. SAFETY CLUTCH MECHANISM.....	25

1. MAIN PARTS NAMES
2.SPECIFICATIONS

1. MAIN PARTS NAMES



2. SPECIFICATIONS

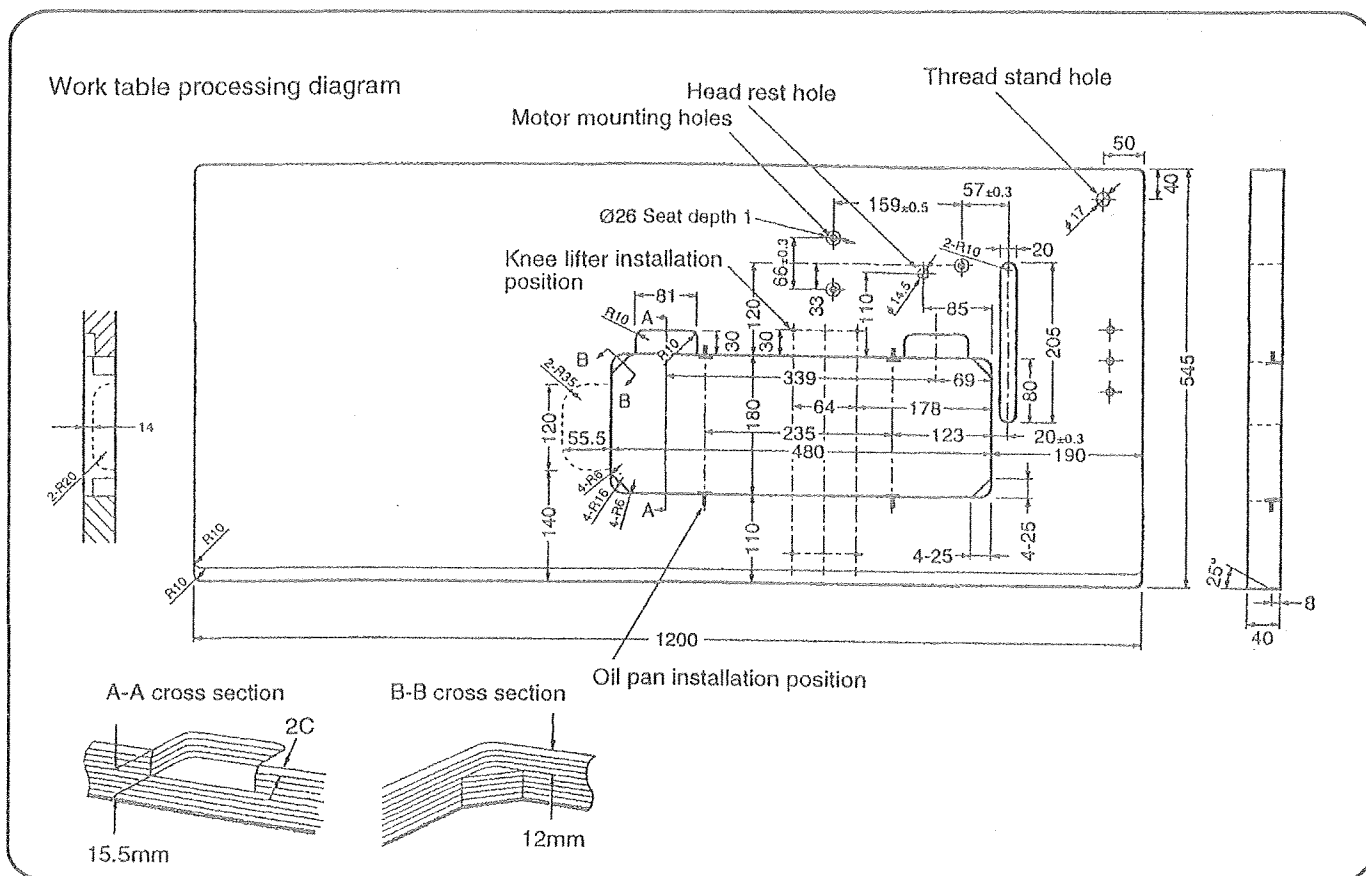
Use		Medium--thick materials--very thick materials
Sewing speed		2,200 spm
Presser foot height	Presser bar lifter	8.5 mm
	Knee lifter	14 mm
Max.stitch length		10 mm
Feed dog height		1 mm
Needles		DP x 17

3.WORK TABLE AND MOTOR

3.WORK TABLE AND MOTOR

■ Work Table

- When using a table made by another manufacturer, drill holes in the table as shown in the figure below.
- The top of the table should be 40 mm in thickness and should be strong enough to hold the weight and withstand the vibration of the sewing machine.



■ Work Table



CAUTION



- All cords which are connected to the motor should be secured at least 25 mm away from any moving parts. Furthermore, do not excessively bend the cords or secure them too firmly with staples, otherwise there is the danger that fire or electric shocks could occur.



- Install the correct belt guard which corresponds to the motor being used.

<Motor>

- Select the correct motor from those listed in the table.
- Refer to the instruction manual for the motor for details on installing and using the motor.

<Motor pulley and V-belt>

- Select the correct motor pulley and V-belt by referring to the table to suit the power frequency of your area.

Power	Motor
Single-phase 110V	2pole,400W motor
Three-phase 220V	2pole,400W motor

Sewing speed	Frequency	Motor pulley	V-belt
2,000 spm	50 HZ	Motor pulley 55	41 inches
	60 HZ	Motor pulley 45	41 inches

4. INSTALLATION

4. INSTALLATION



CAUTION



- The sewing machine should only be installed by a qualified technician.



- Ask your dealer or a qualified electrician for any electrical work that may need to be done.



- The sewing machine weights more than 29 kg. The installation should be carried out by two or more people.



- Do not connect the power cord until installation is complete, otherwise the machine will operate if the treadle is pressed by mistake, which could result in injury.

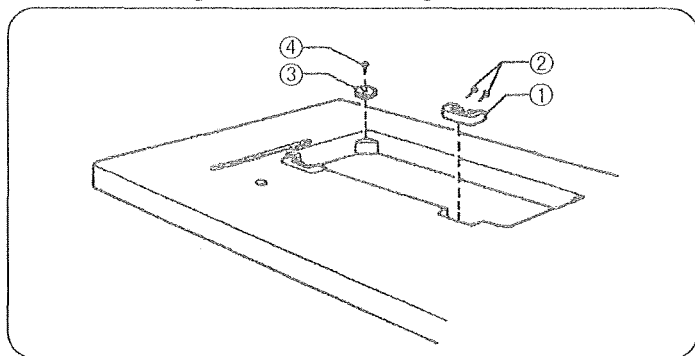


- Be sure to connect the ground. If the ground connection is not secure, serious electric shocks will result.



- Install the belt guard to the machine head.

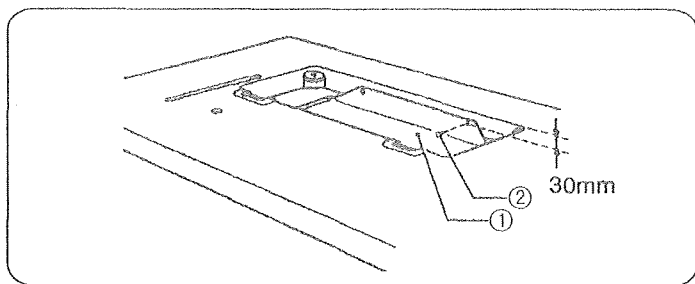
4-1. Installing the rubber hinge and the corner rubber



1. Install the rubber hinge ① on the table with nails ②. (Two places)

2. Install the corner rubber ③ at the four corners of the table with nails ①.

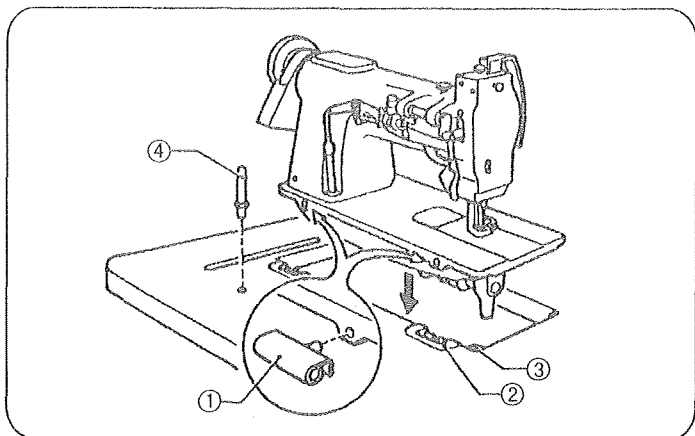
4-2. Installing the oil pan



Fit oil pan ① into the opening in the table, and secure it with 4 nails ②.

(Refer to the work table processing diagram on page 2.)

4-3. Installing the machine head



1. Insert the two bed hinge connections ① into the holes in the machine bed.

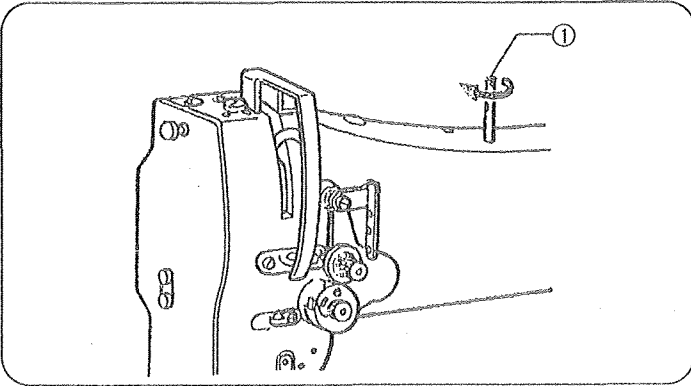
2. Fit the bed hinge connection ① to the rubber hinge ② and then place the machine head onto the corner rubber ③.

3. Tap the head rest ④ into the table hole.

NOTE: Tap the head rest securely into the table hole. If the head rest is not pushed in as far as it will go, the machine head will not be sufficiently stable when it is tilted back.

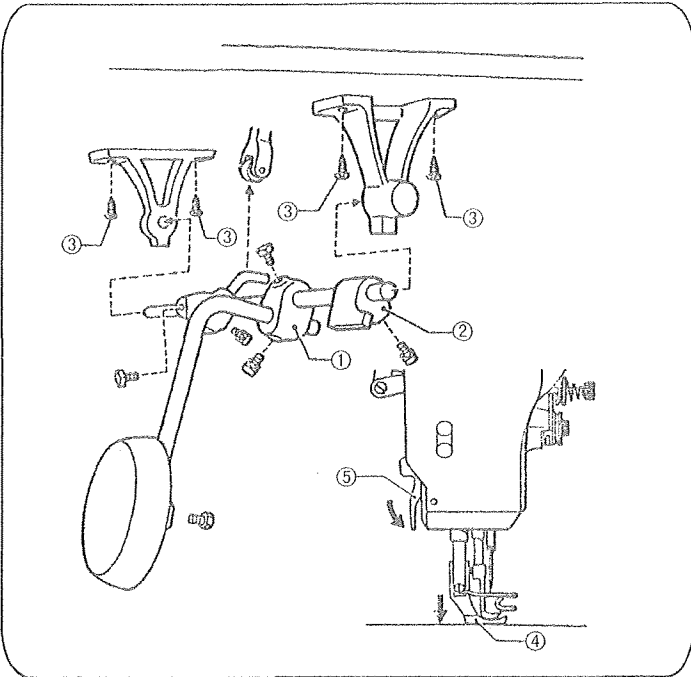
4. INSTALLATION

4-4. Installing the spool pin.



Insert the spool pin ① into the installation hole, and screw it in tightly.

4-5. Installing the knee lifter assembly



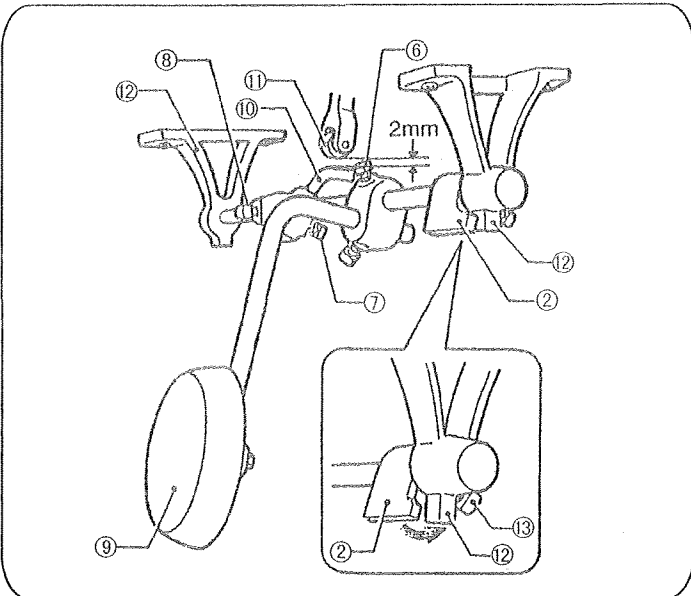
1. Assemble the knee lifter assembly ① as shown in the illustration.

NOTE: Make sure that the knee lifter stopper ② is facing in the correct direction.

2. Install the knee lifter assembly ① on the back of the table with 4 screws ③. (Refer to the work table processing diagram on page 2.)

3. Adjust the knee lifter.

1) Lower the presser foot ④ by using the presser bar lifter ⑤.



2) Loosen bolts ⑥, ⑦ and ⑧.

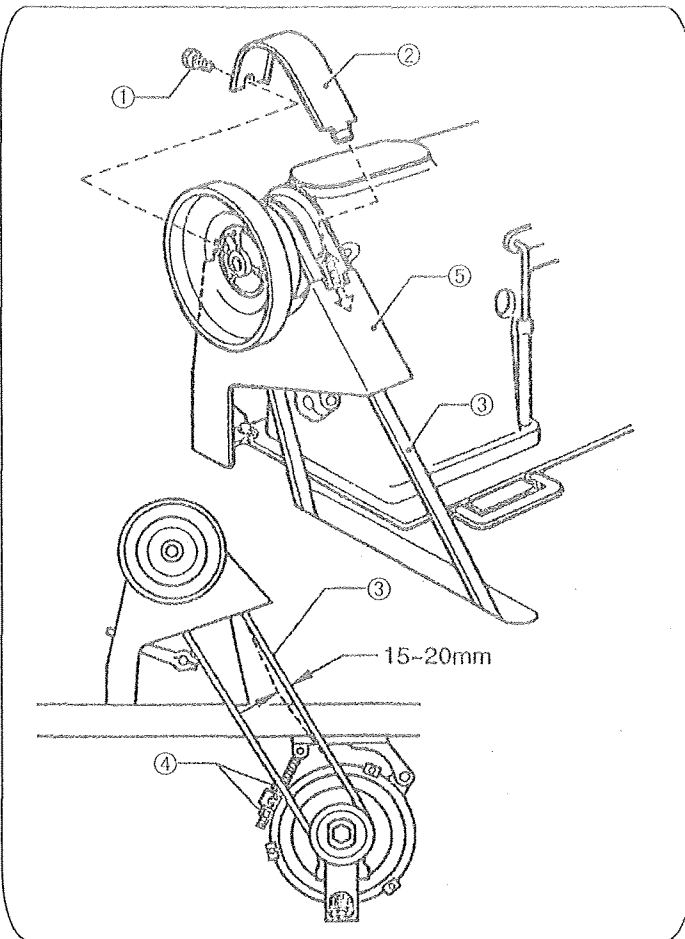
3) Adjust the position of the thrusting bar complete ⑩ so that the clearance between its curved section and the very bottom of the roller ⑪ is approximately 2 mm when the knee pad ⑨ is at the stop position.

4) Securely tighten bolts ⑥, ⑦ and ⑧.

5) Press the knee pad ⑨ to raise the presser foot ④ by 14 mm; then move the knee lifter stopper ② in the direction of the arrow so that it is against the installation bracket projection ⑫, securely tighten the bolt ⑬.

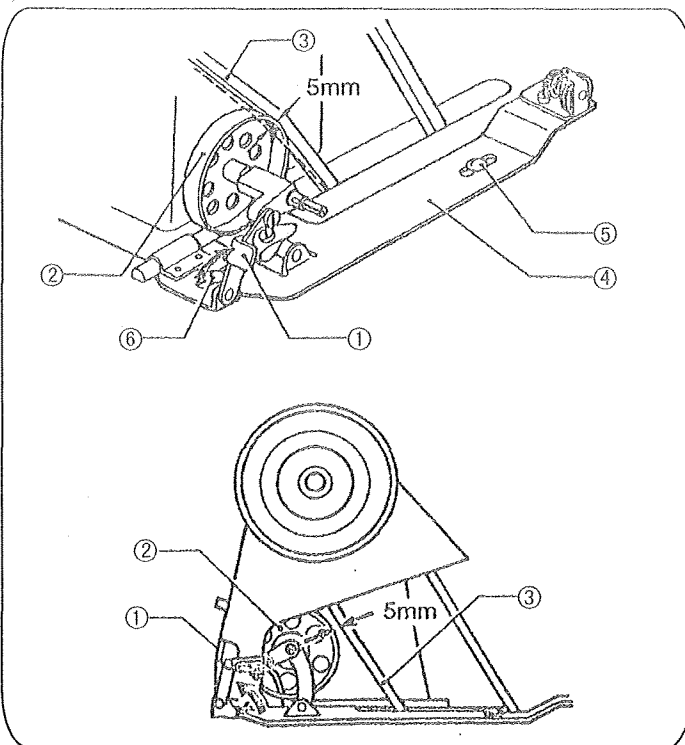
4. INSTALLATION

4-6. Installing the belt



1. Remove the screw ① and remove the belt guard upper cover ②.
2. Tilt back the machine head, and then place the belt ③ onto the motor pulley and the machine pulley.
3. Turn the nut ④ to adjust so that there is 15-20 mm of deflection in the belt ③ when it is pressed with a finger with a force of 9.8 N (1 kgf).
4. Insert the belt guard upper cover ② into the belt guard ⑤ from above the pulley, and then tighten it with the screw ①.

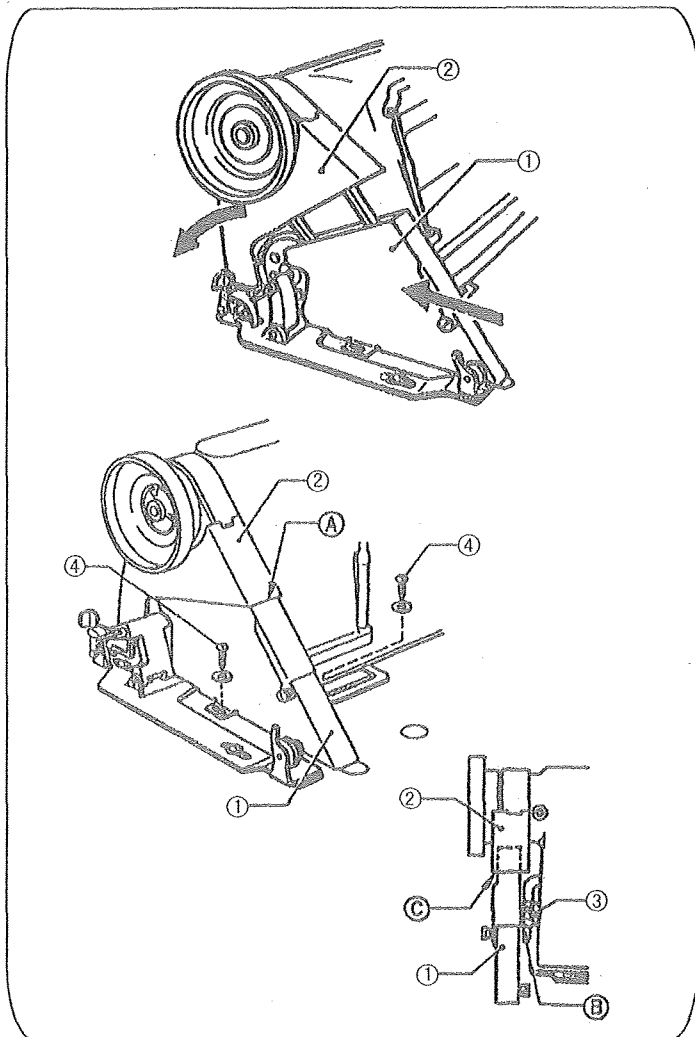
4-7. Installing the bobbin winder



1. Push down the bobbin set lever ① as far as it will go.
2. Place the bobbin winder pulley ② so that it pushes the belt ③ by approximately 5 mm, and then place the bobbin winder ④ so that it is parallel with the belt hole in the work table.
3. Install the bobbin winder ④ to the work table with the two screws ⑤.
4. Pull the bobbin set lever ① back and check that there is approximately 5 mm of clearance between the bobbin winder pulley ② and the belt ③.

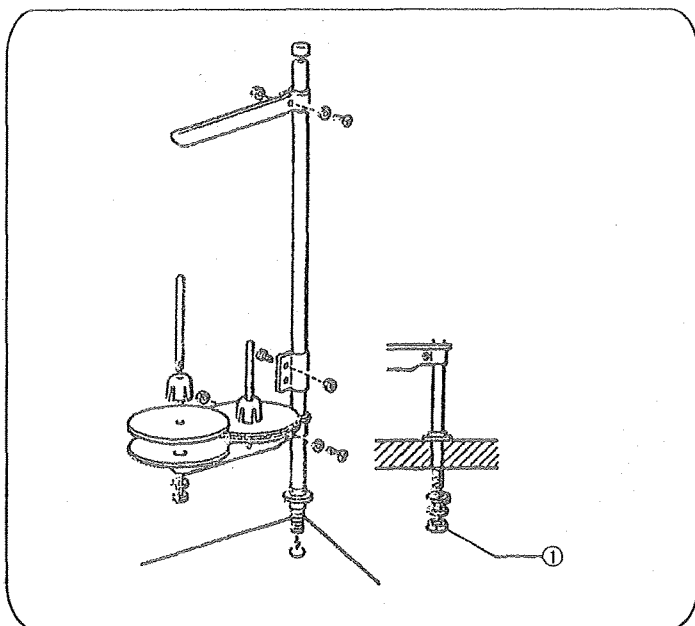
4. INSTALLATION

4-8. Installing the belt guard (L)



1. Tilt back the machine head, and then remove the V-belt from the motor pulley.
2. While tilting the machine forward, insert belt guard(L) ① into the belt guard ② from underneath, and let it rest there.
3. Place the V-belt back onto the pulley.
4. Install belt guard (L) ① with the two screws ④ so that there is no clearance between the belt guard ② and belt guard (L) ① (position A), and so that the reverse lever ③ and the belt guard ② are not touching (positions B and C).

4-9. Installing the thread stand



Assemble the thread stand as shown in the illustration, and then install it to the work table.

- * Securely tighten the nut ① so that the thread stand does not move.

4. INSTALLATION

4-10. Lubrication



CAUTION



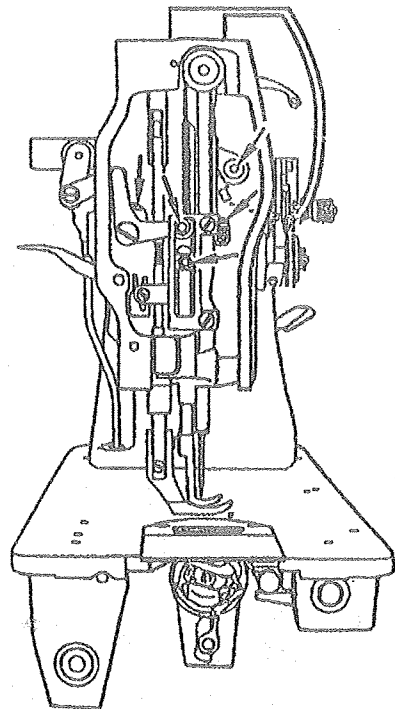
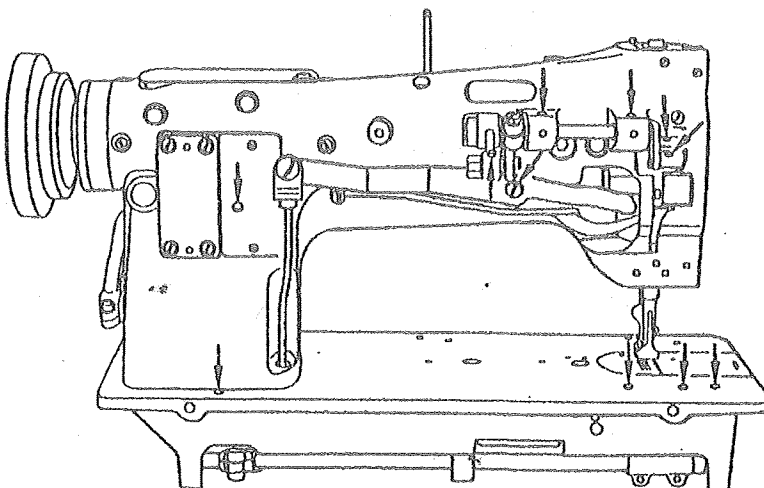
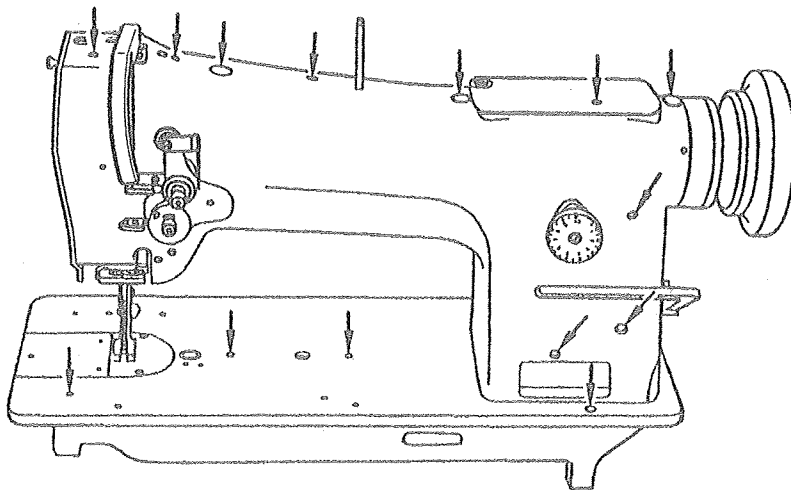
• Do not connect the power cord until lubrication has been completed, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury.



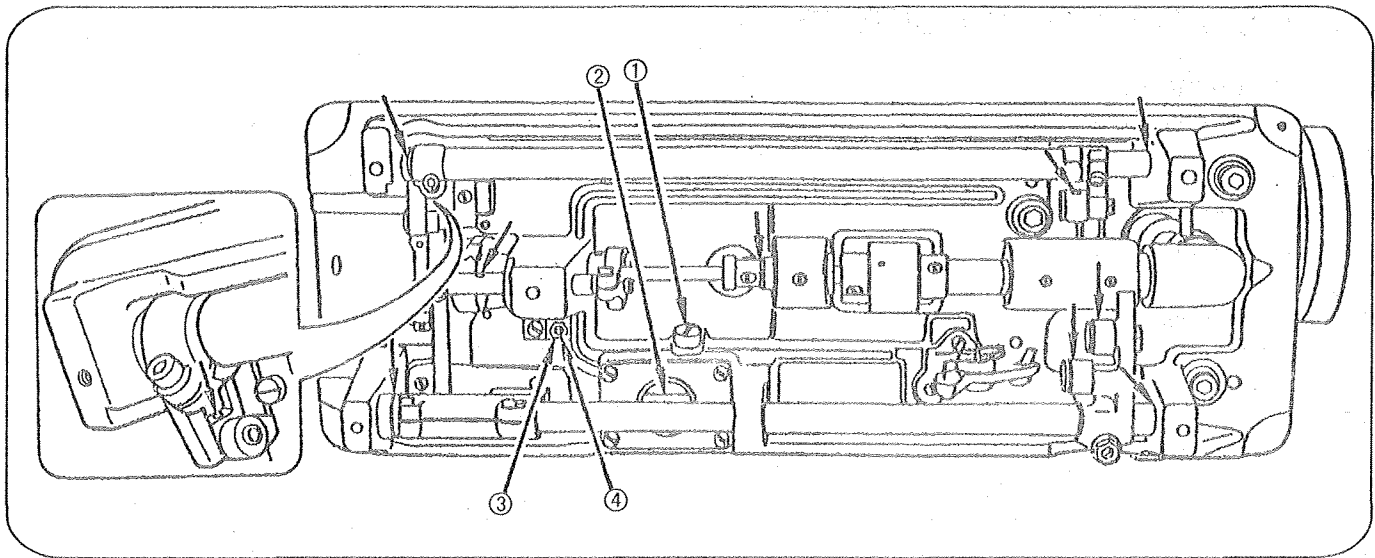
• Be sure to wear protective goggles and gloves when handling the lubricating oil, so that no oil gets into your eyes or onto your skin, otherwise inflammation can result.
Furthermore, do not drink the oil under any circumstances, as it can cause vomiting and diarrhoea. Keep the oil out of the reach of children.

- The sewing machine should always be lubricated and the oil supply replenished before it is used for the first time, and also after long periods of non-use.
- Use only the lubricating oil.

- Add 1-2 drops of oil in the places indicated by the arrows.
- Add oil to other sliding parts also, while being careful to avoid oil leaks.
- Oiling must be done at least twice daily in continuous use.



4. INSTALLATION



■ For oiling to hook

Remove the oil plug ① and pour oil until the oil surface reaches to the red line of the oil indicator ②. After pouring oil, tighten the oil plug ① securely.

■ Oiling adjustment to hook

Loosen the nut ③, adjust oiling by adjusting screw ④. To increase oil flow, loosen the adjusting screw ④, to decrease oil flow, tighten the screw ④. After oiling adjustments completed, tighten the nut ③ securely.

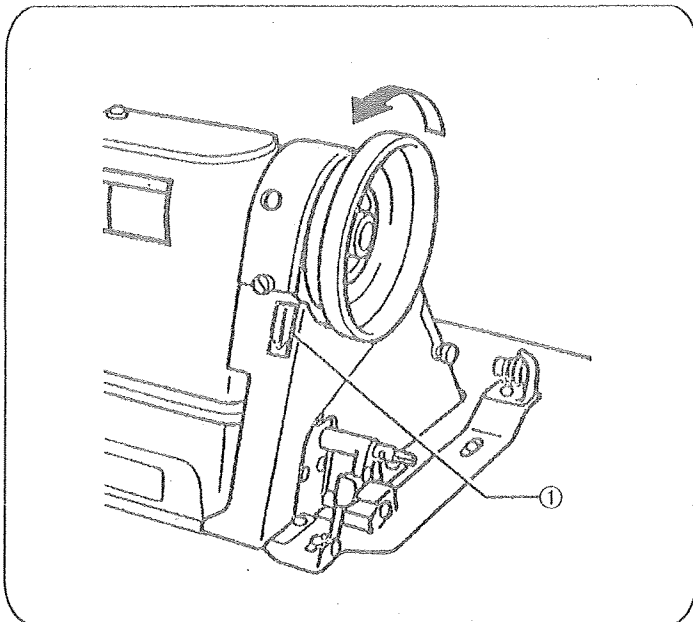
4-11. Checking the machine pulley rotating direction



CAUTION



- Do not touch any of the moving parts or place any objects against the machine while sewing, as this may result in personal injury or damage to the machine.



1. Insert the power cord plug into the wall outlet, and then turn on the power switch.
 2. Depress the treadle and check that the direction of rotation of the machine pulley matches the direction of the arrow ①.
- * If the direction of rotation is reversed, change the direction of rotation to the correct direction while referring to the instruction manual for the motor.

5. PREPARATION BEFORE SEWING

5. PREPARATION BEFORE SEWING

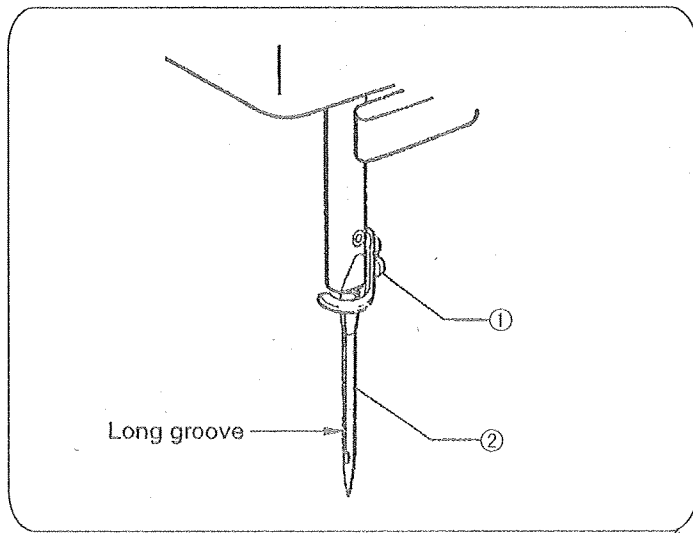
5-1. Installing the needle



CAUTION



- Turn off the power switch before installing the needle. The motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work. The machine may operate if the treadle is pressed by mistake, which could result in injury.



1. Turn the machine pulley toward you to move the needle bar to its highest position.
2. Loosen the screw ①.
3. Holding the needle ② with its long groove facing left, insert all the way into the needle bar.
4. Tighten the screw ①.

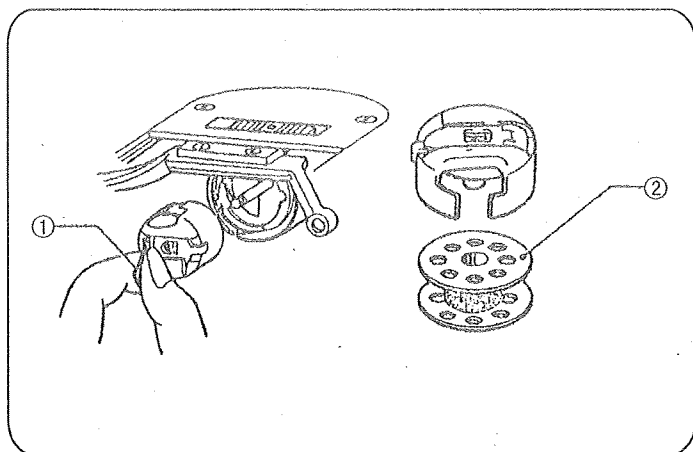
5-2. Removing the bobbin case



CAUTION



- Turn off the power supply before removing the bobbin case. The motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work. The machine may operate if the treadle is pressed by mistake, which could result in injury.



1. Open the bed slide.
2. Pull the latch ① of the bobbin case upward and then remove the bobbin case.
3. The bobbin ② will come out when the latch ① is released.

5. PREPARATION BEFORE SEWING

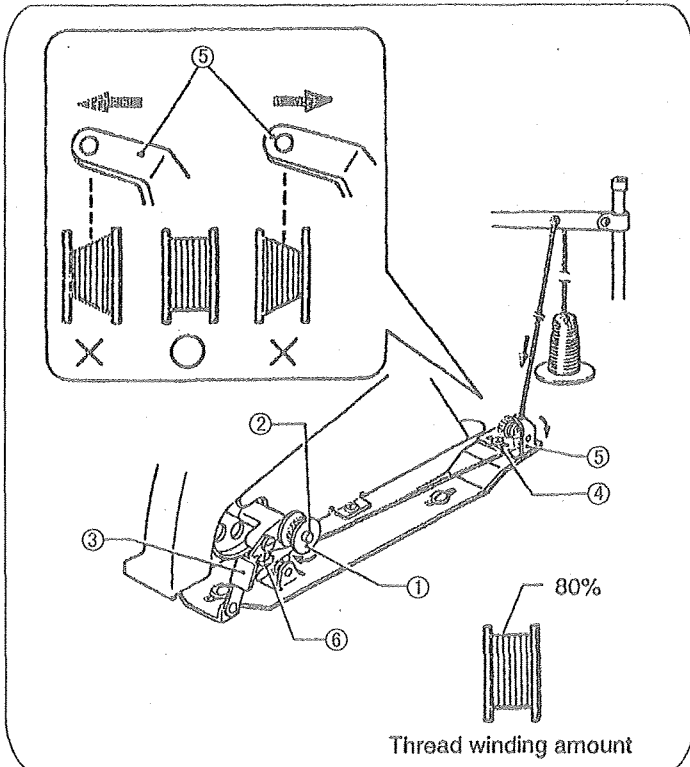
5-3. Winding the lower thread



CAUTION



- Do not touch any of the moving parts or place any objects against the machine while winding the lower thread, as this may result in personal injury or damage to the machine.



1. Turn on the power switch.
 2. Place the bobbin ① onto the bobbin winder shaft.
 3. Wind the thread several times around the bobbin ① in the direction indicated by the arrow.
 4. Push down the bobbin set lever ③.
 5. Raise the presser foot with the presser bar lifter.
 6. Depress the treadle. Lower thread winding will then start.
 7. Once winding of the lower thread is completed, the bobbin set lever ③ will return automatically.
- * If the thread cannot be wound on evenly, loosen the screw ④ and move the bobbin winder bracket ⑤ to the side where there is less thread.
 - * Turn the adjustment screw ⑥ to adjust the bobbin winding amount.
 - To increase the winding amount: Tighten the screw.
 - To decrease the winding amount: Loosen the screw.
- Note: The amount of thread wound onto the bobbin should be a maximum of 80% of the bobbin capacity.

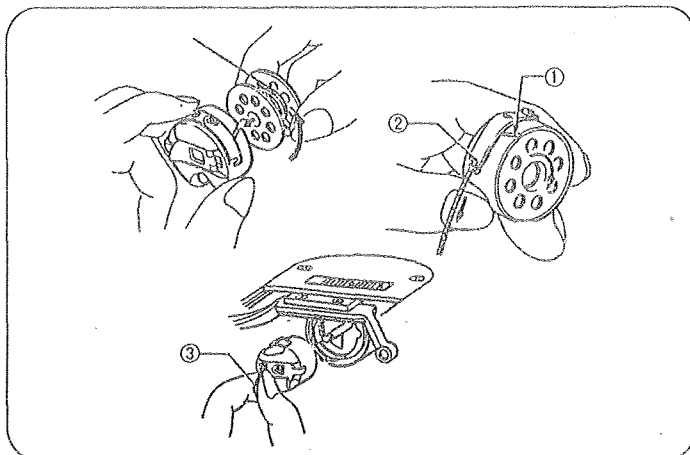
5-4. Installing the bobbin case



CAUTION



- Turn off the power supply before installing the bobbin case. The motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work. The machine may operate if the treadle is pressed by mistake, which could result in injury.



1. While holding the bobbin so that the thread winds to the right, insert the bobbin into the bobbin case.
2. Pass the thread through the slot ① and under the tension spring ②.
3. Pull the thread cut through the hole in the end of the tension spring ②.
4. Check that the bobbin turns clockwise when the thread is pulled.
5. Hold the latch ③ on the bobbin case and insert the bobbin case into the rotary hook.
6. Close the bed slide.

5. PREPARATION BEFORE SEWING

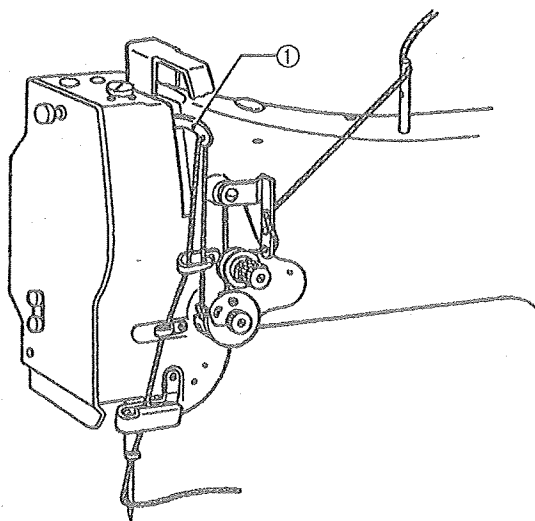
5-5. Threading the upper thread



CAUTION

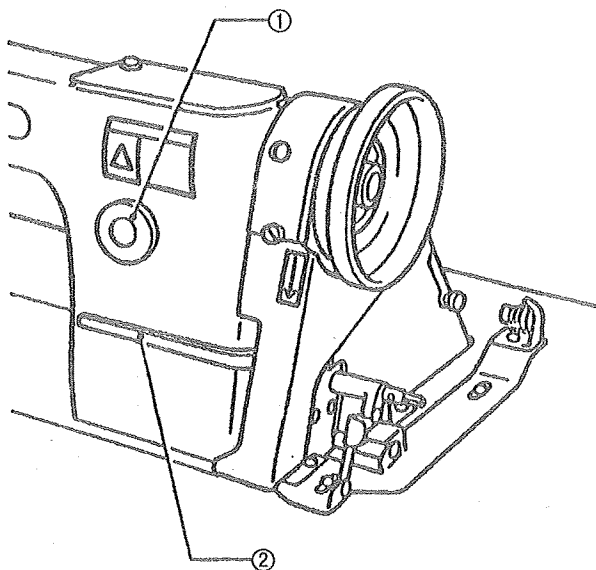


- Turn off the power supply before installing the bobbin case. The motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work. The machine may operate if the treadle is pressed by mistake, which could result in injury.



Turn the machine pulley and raise the thread take up lever ① before threading the upper thread. This will make threading easier and it will prevent the thread from coming out at the sewing start.

5-6. Adjusting the stitch length



Stitch length can be set by turning the feed regulating dial ①.

Numeric figures on the dial ① show the stitch length in mm. The desired numeric figure on the dial ① should be set at just above, while depressing the revers lever ② slightly.

6. SEWING



CAUTION



- Attach all safety devices before using the sewing machine. If the machine is used without these devices attached, injury may result.



- Turn off the power switch at the following times. The motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work. The machine may operate if the treadle is pressed by mistake, which could result in injury.

- When threading the needle

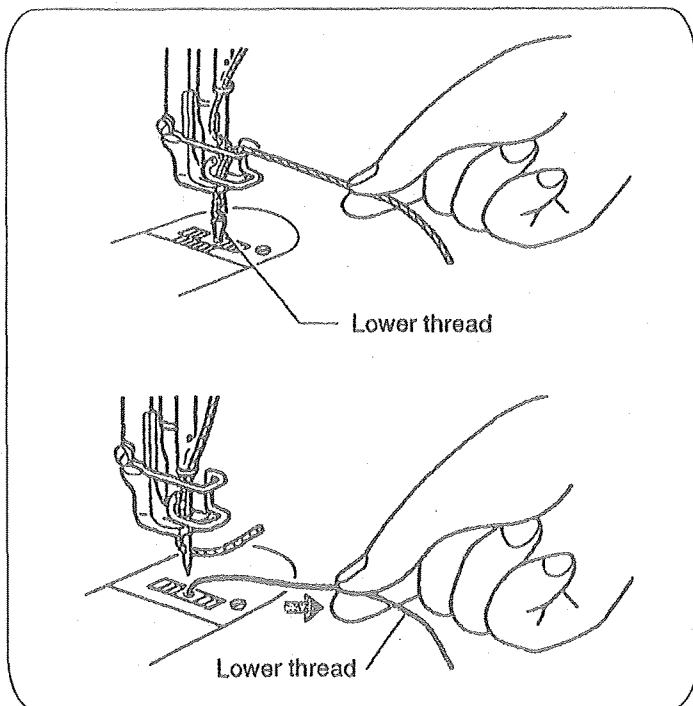
- When replacing the needle and bobbin

- When not using the machine and when leaving the machine unattended



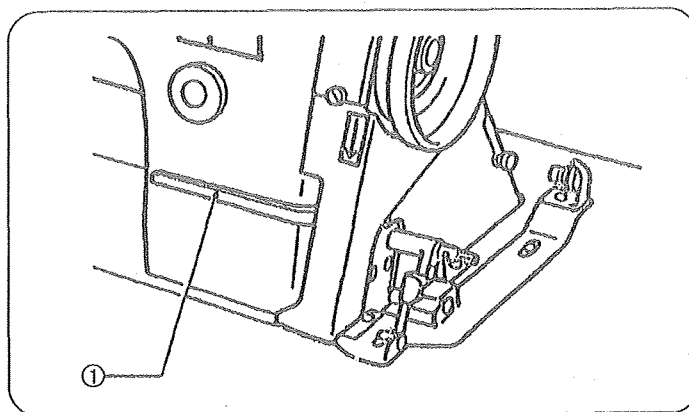
- Do not touch any of the moving parts or place any objects against the machine while sewing, as this may result in personal injury or damage to the machine.

6-1. Sewing



1. While holding the upper thread with your fingers, turn the machine pulley by hand toward you until the lower thread comes out onto the feed dog.
2. Pull the lower thread toward you and check that it pulls out smoothly,
3. Turn on the power switch.
4. Depress the treadle to start sewing,

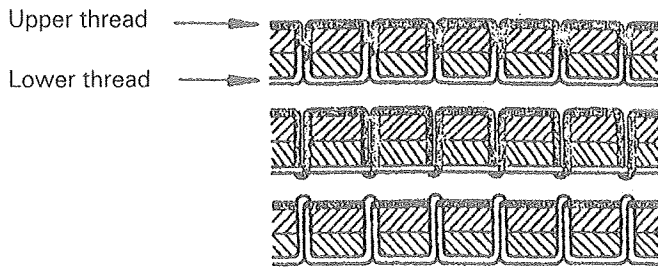
6-2. Backtacking



When the reverse lever ① is pushed, the material feed direction will be reversed, and when it is returned to its original position, the feed direction will change back to normal.

7. THREAD TENSION

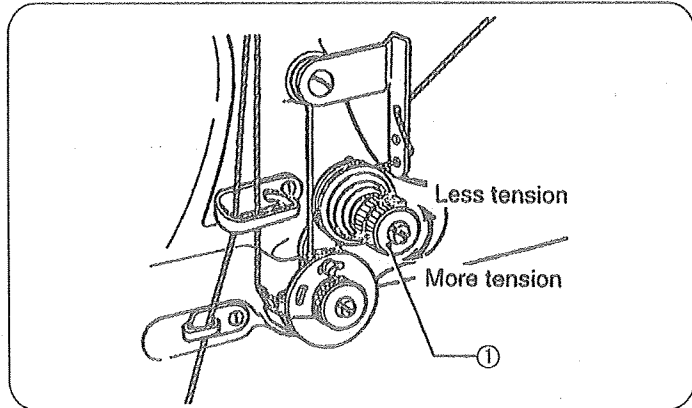
7-1. Adjusting the thread tension



Good even stitches

Upper thread tension too weak or lower thread tension too strong

Upper thread tension too strong or lower thread tension too weak



■ Upper thread tension

The tension of the upper thread is adjusted using the tension thumb nut ①.

To increase the tension of the upper thread, turn the tension thumb nut ① to the right. To decrease tension, turn the tension thumb nut ① to the left.

■ Lower thread tension

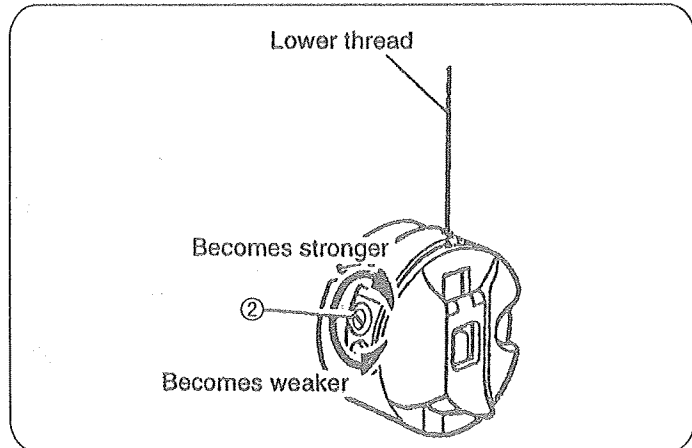


CAUTION



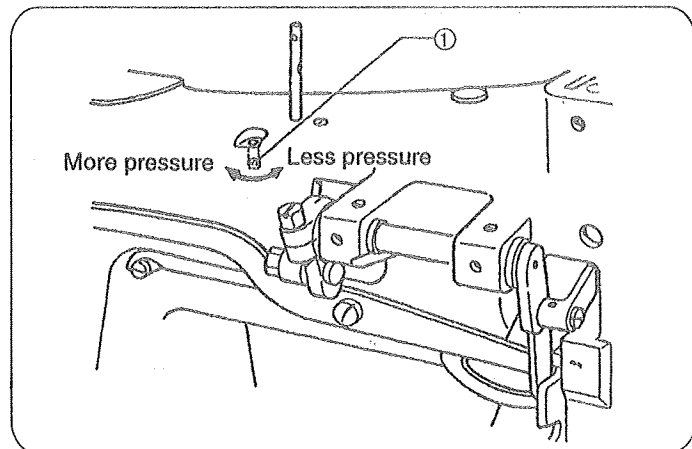
Turn off the power switch before removing or inserting the bobbin case.

The motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work. The machine may operate if the treadle is pressed by mistake, which could result in injury.



Adjust by turning the thread tension nut ② until the bobbin case will not drop by its own weight while the thread end coming out of the bobbin case is held.

7-2. Adjusting the presser foot pressure



Adjust the presser foot pressure to lower as much as possible so that the presser foot can properly hold down material by turning the screw ①.

8. STANDARD ADJUSTMENTS



CAUTION



• Maintenance and inspection of the sewing machine should only be carried out by qualified personnel.



• Ask your dealer or a qualified electrician to carry out any maintenance and inspection of the electrical system.



• If any safety devices have been removed, be absolutely sure to re-install them to their original positions and check that they operate correctly before using the machine.



• Turn off the power switch and disconnect the power cord from the wall outlet at the following times, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury. However, the motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work.

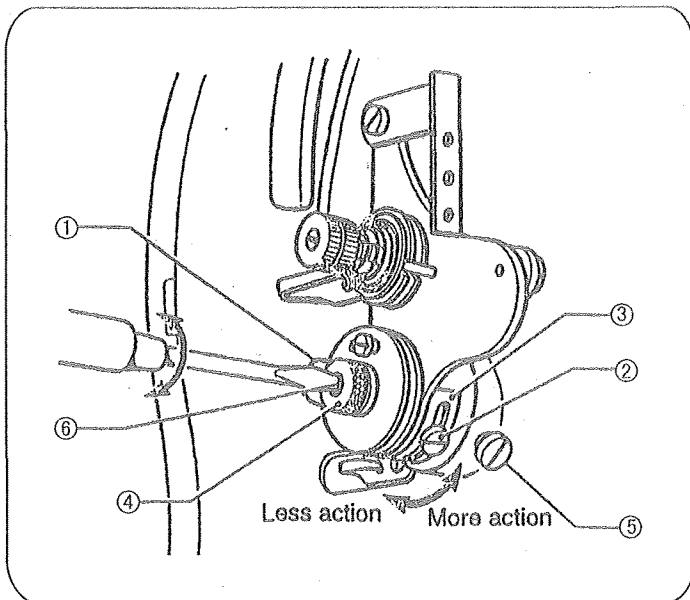
• When carrying out inspection, adjustment and maintenance

• When replacing consumable parts such as the rotary hook



• If the power switch needs to be left on when carrying out some adjustment, be extremely careful to observe all safety precautions.

8-1. Adjusting the thread controller spring



■ Operating range of spring

The standard operating range for spring ① is 5–10mm.

1. Loosen the screw ②, and then turn the thread controller spring stop ~ to adjust the operating range.

• For more operating range, move the spring stop ③ to the right.

• For less operating range, move the spring stop ③ to the left.

2. Tighten the screw ②.

■ Tension of the spring

The standard tension for spring ① is 0.39–0.78 N (40–80g).

1. Loosen the tension thumb nut ④ and screw ⑤.

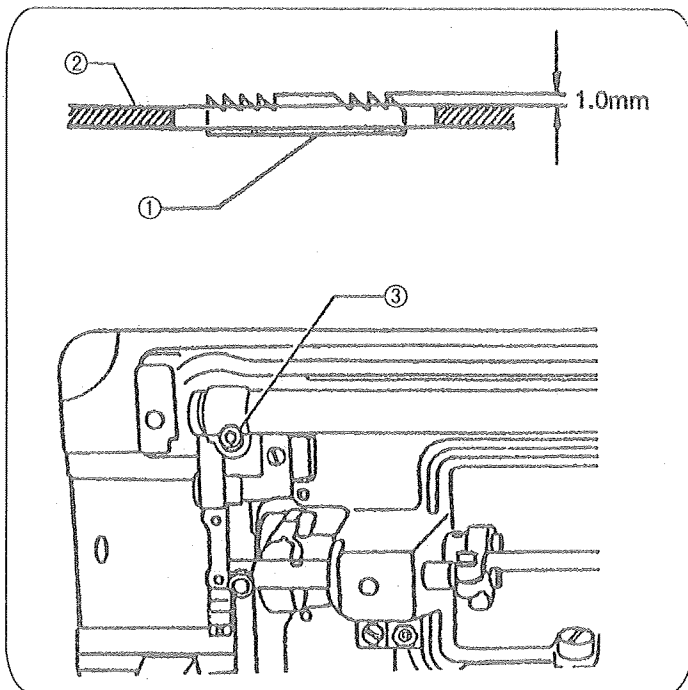
2. Turn the tension stud ⑥ to adjust the tension.

• To increase the spring tension, slightly turn the tension stud ⑥ counterclockwise.

• To decrease the tension, turn the stud clockwise.

3. After adjustment, tighten the tension thumb nut ④ and screw ⑤.

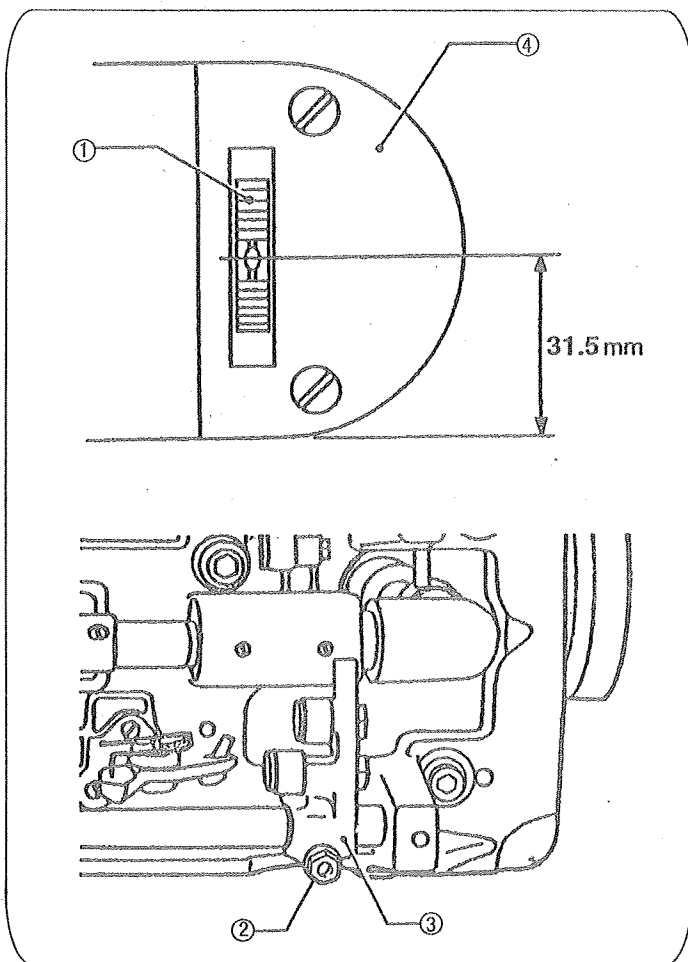
8-2. Adjusting the height of the feed dog



The maximum height of the feed dog ① from the surface of the needle plate ② is normally 1 mm. To adjust the height of the feed dog:

1. Tilt the machine head away from you. Turn the pulley to raise the feed dog ① to its highest position.
2. Loosen the screw ③.
3. Raise or lower the feed dog ① as necessary,
4. Tighten the screw ③.

8-3. Adjusting the feed dog position (longitudinal)



1. Change the feed amount to the smallest possible setting.
2. Turn the pulley to raise the feed dog ① to its highest position.
3. Tilt the machine head away from you.
4. Loosen the screw ②, and then move the feed rock shaft crank ③ to adjust so that there is a distance of 32.1 mm from the edge of the needle plate ④ to the center of the needle hole on the feed dog ①.
5. Securely tighten the screw ②.

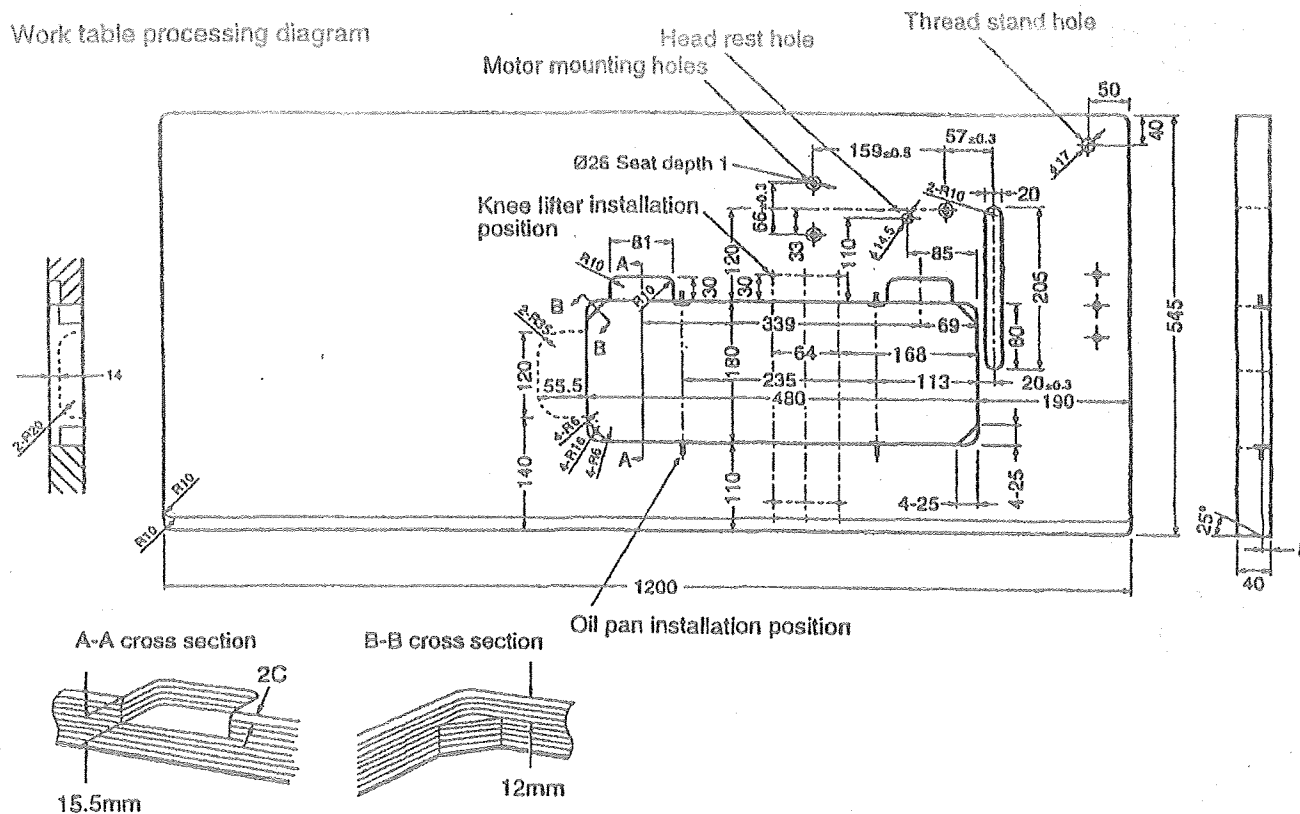
3. WORK TABLE AND MOTOR

3. WORK TABLE AND MOTOR

■ Work Table

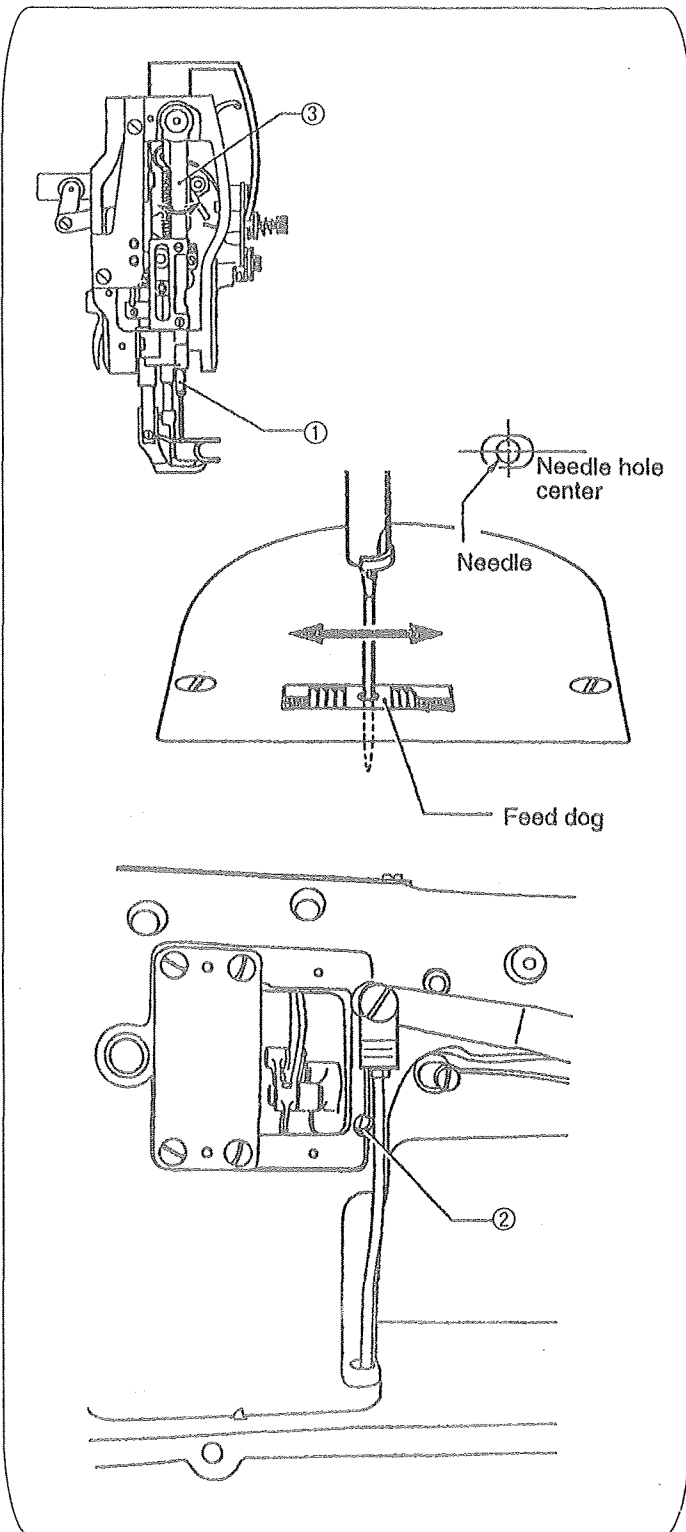
- When using a table made by another manufacturer, drill holes in the table as shown in the figure below.
- The top of the table should be 40 mm in thickness and should be strong enough to hold the weight and withstand the vibration of the sewing machine.

Work table processing diagram



8. STANDARD ADJUSTMENTS

3-4. Adjusting the Positions of the needle and needle hole of the feed dog



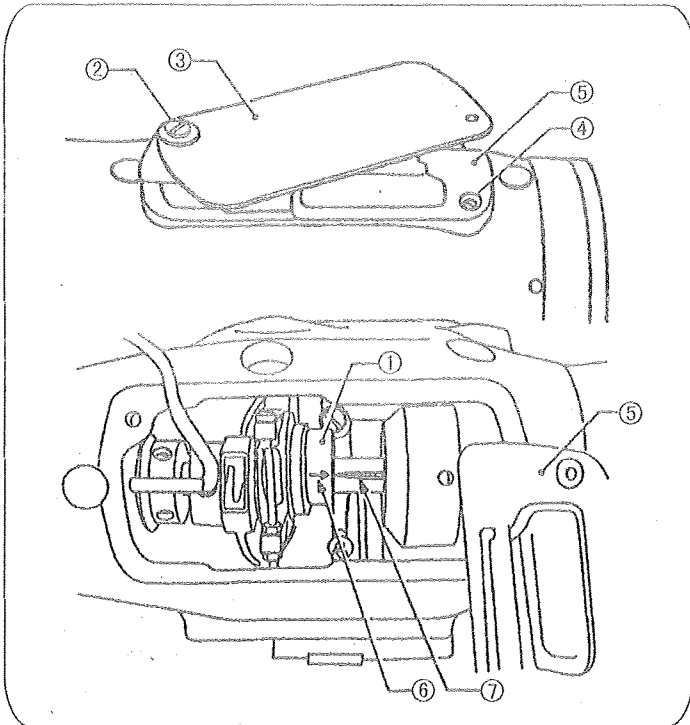
Turning the pulley to lower the needle bar (1) slowly, check whether the needle descends to the center of the needle hole of the feed dog or not.

If the needle does not enter into the center of the hole:

1. Remove the cover and loosen the screw (2) slightly.
2. Holding the needle bar rock frame (3) move it as may be required to get the correct position to the feeder.
3. Tighten the screw (2) and close the cover.

8. STANDARD ADJUSTMENTS

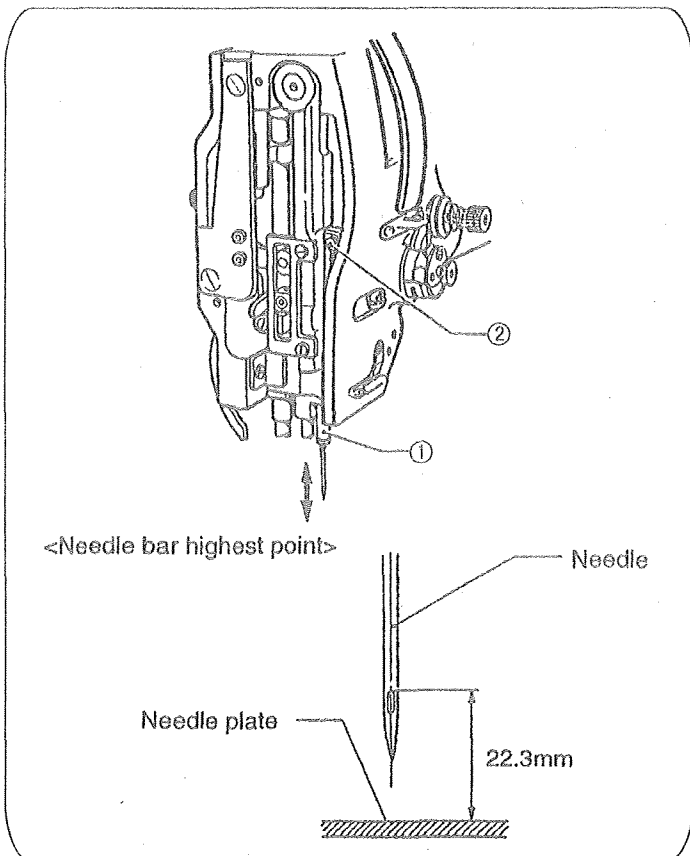
8-5. Adjusting the timing the needle with feed



It is important that the timing relationship between the needle on its downward stroke and the feed dog movement is maintained at all times. When the scarf of the needle on the downward stroke reaches the top surface of the feed dog, the feed dog movement must start. When adjustment is required, use the following procedure to change the position of cam ①.

1. Change the feed amount to the largest possible setting.
2. Loosen the screw ② for cover plate ③ and the screw ④ for oil reservoir ⑤, and then remove the cover plate ③ and the oil reservoir ⑤.
3. Normally put the arrow mark ⑥ of the cam ① on the V ditch ⑦ of arm shaft.
4. Turn the machine pulley to the needle at 1 mm up from its lowest point.
5. And, pushing the reverse lever up and down, turn the cam ① and set this at the point both the needle and the feed dog rest.
6. After positioning completed, tighten the each screw securely.

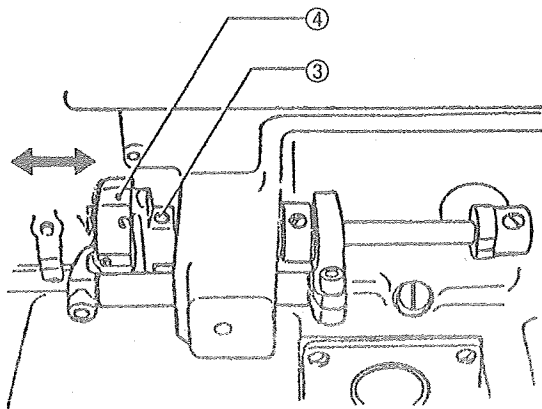
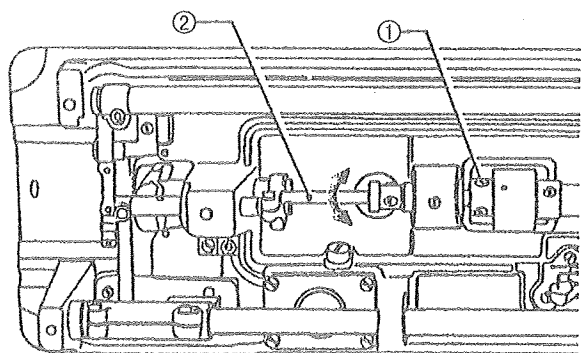
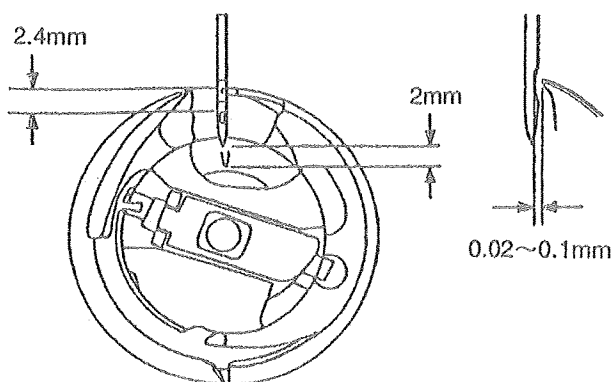
8-6. Adjusting the height of the needle



When the needle bar ① is at its highest point, normally the measurement between the surface of the needle plate and the upper end of the needle eye is 22.3mm.

1. Loosen the screw ② and move the setting position of the needle bar O to get the correct position.
2. Tighten the screw ②.

8-7. Adjusting the timing between the needle and the hook



After setting the needle bar height, set stitch length to minimum, turn the machine pulley toward you until the needle bar reaches its lowest point. Continue turning and allow the needle bar to raise about 2mm while on its upward stroke. With needle bar in this position, the point of the sewing hook should be at the center of the needle, and normally, the measurement between the hook point and the upper end of the needle eye should be 2.4mm, further the clearance between the hook point and the needle hollow should be about 0.02 to 0.1 mm.

*If they are not measured as above, perform the adjustments below.

■ Adjusting the timing

1. Loosen the three set screws ①.
2. Turn the hook shaft ② to align the hook point with the center of the needle.
3. Tighten the three set screws ① and re-check the timing of the sewing hook.

■ Adjusting the clearance

1. Loosen the two screws ③ slightly.
2. Move the hook ④ to the right or to the left as may require.

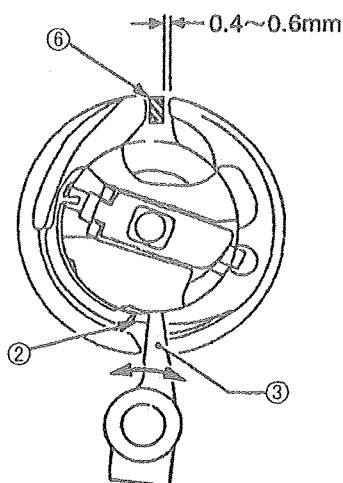
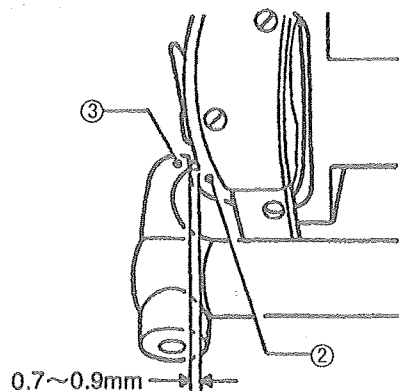
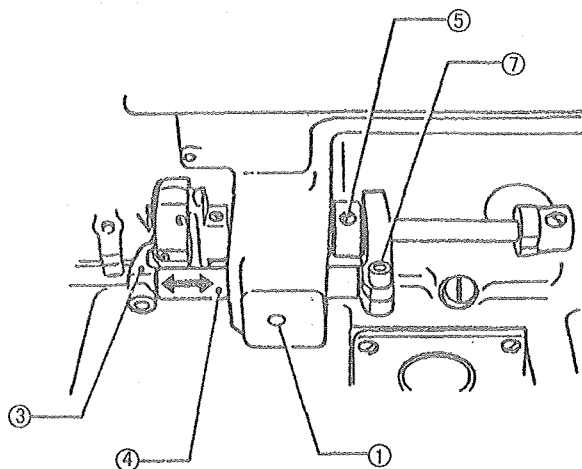
* Please note one of the two screws ③ is placed on the V ditch of hook shaft. Therefore, keep the screw on V ditch during adjustment.

3. Tighten the two screws ③.

8. STANDARD ADJUSTMENTS

8-8. Adjusting the Clearance between rotary hook and opener

(Thread release finger)



The opener facilitates the passage of the needle thread loop by slightly nudging the inner hook creating a slight rotating movement of it. This movement at that very instant opens a clearance gap between the notch of the inner hook and the tab of the hook retainer per mitting the needle thread loop to be drawn easily through the gap.

■ Clearance between the opener and projection of hook.

1. Loosen the screw ①.
2. Adjust the clearance between projection of hook ②, and the opener ③ by means of movement of thread releasing shaft bushing ④ to the right or to the left as may be required. The standard clearance between the two parts is 0.7~0.9mm.
3. Tighten the screw ① securely.

■ Position of the opener cam:

Place the one of screws ⑤ which is indicated by "S" on V ditch of the hook shaft.

■ Adjustment of operation:

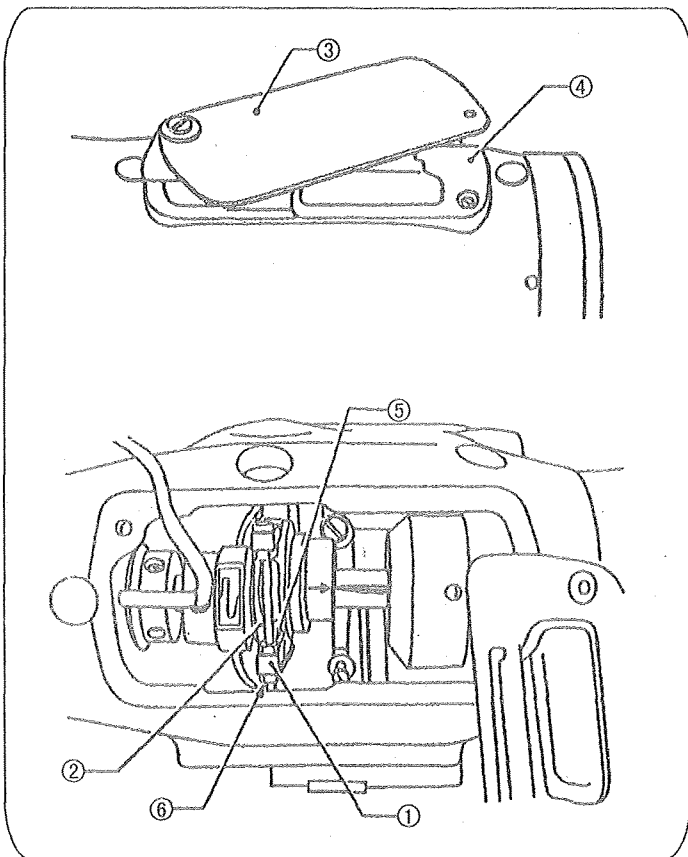
1. Turn the machine pulley until the opener ③ presses the projection of hook ② extremely on its travel.
2. Press the opener ③ to the projection of hook ② and make the right side clearance between the notch on the bobbin case holder and tab the hook retainer ⑥ 0.4~0.6mm.

This adjustment can be done by loosening the screw ⑦,

3. Tighten the screw ⑦ securely.

8. STANDARD ADJUSTMENTS

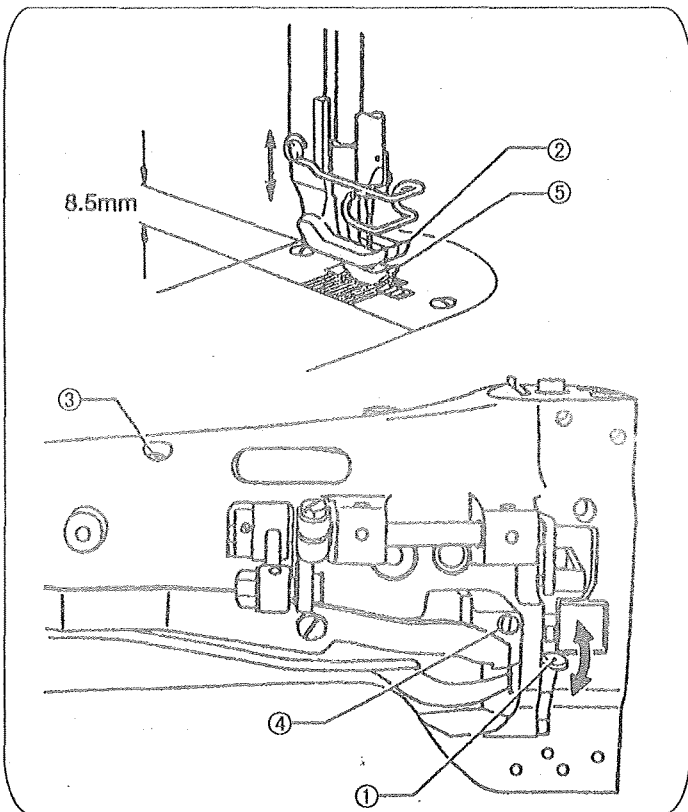
8-9. Adjusting the clearance between feed forked connection and feed fork collar



Incorrect clearance between the fork ① of feed forked connection and feed fork collar ② will bring irregular stitch length or overheating, etc.

1. Remove the cover plate ③ and the oil reservoir ④.
2. To increase the clearance, loosen the nut ⑤ and turn the nut ⑥ to left or counter-clockwise.
- * This adjustment should be done with turning the machine pulley toward you to get correct clearance.
3. Upon completion of adjustment, tighten the screw and screw ⑤.

8-10. Adjusting the height of the presser feet



The standard height for the lifting presser foot ② is 8.5 mm when the presser foot has been raised by the presser bar lifter ①.

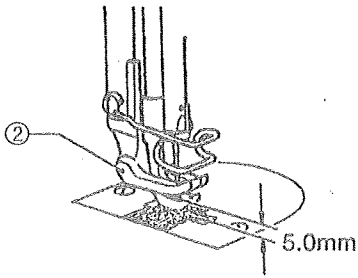
1. Loosen the screw ③, raise the presser bar lifter ①, and then loosen the set screw ④.
2. Move the lifting presser foot ② up or down to adjust its height.
3. Tighten the screw ④.
4. Tighten the screw ③ to adjust the presser foot pressure. (Refer to page 13.)

NOTE: If the height of the lifting presser foot ② is changed, the movement amount of the lifting presser foot ② and vibrating presser foot 0 will change. Adjust the amount of movement of the vibrating presser foot ~ so that it matches the movement of the lifting presser foot ②. (Refer to page 21.)

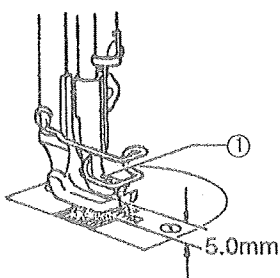
8. STANDARD ADJUSTMENTS

8-11. Adjusting the presser foot movement amount

Movement amount for
lifting presser foot



Movement amount for
vibrating presser foot

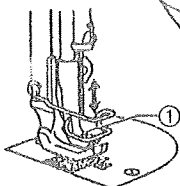
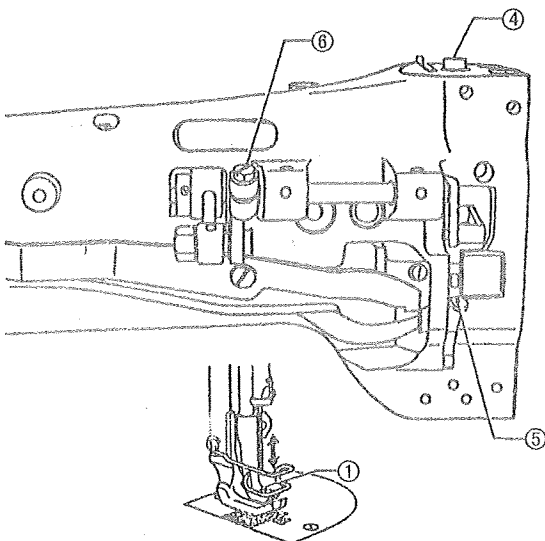
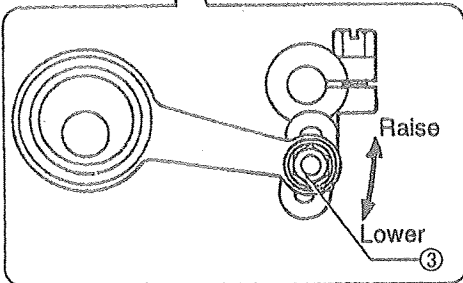
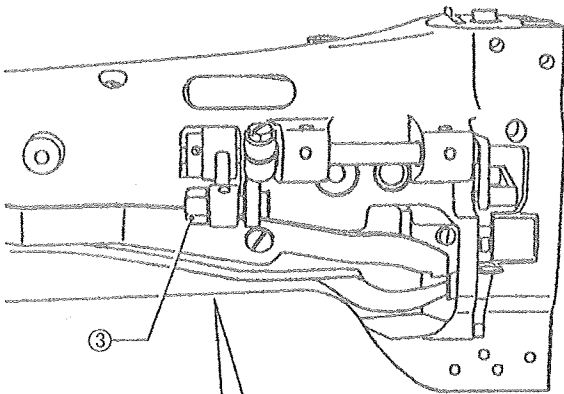


- Vibrating presser foot ① and lifting presser foot ② move up and down alternately.
- Normally, vibrating presser foot ① and lifting presser foot ② operate to the same height in their vertical motions.
- The maximum height of vibrating presser foot ① and lifting presser foot ② is 5.0 mm.

If changing the movement amounts of both the lifting presser foot and vibrating presser foot simultaneously, use method (A); if increasing the movement amount for only one (thereby decreasing the movement of the other), use method (B).

Method (A): Simultaneous adjustment of the movement amount for both the lifting presser foot and vibrating presser foot

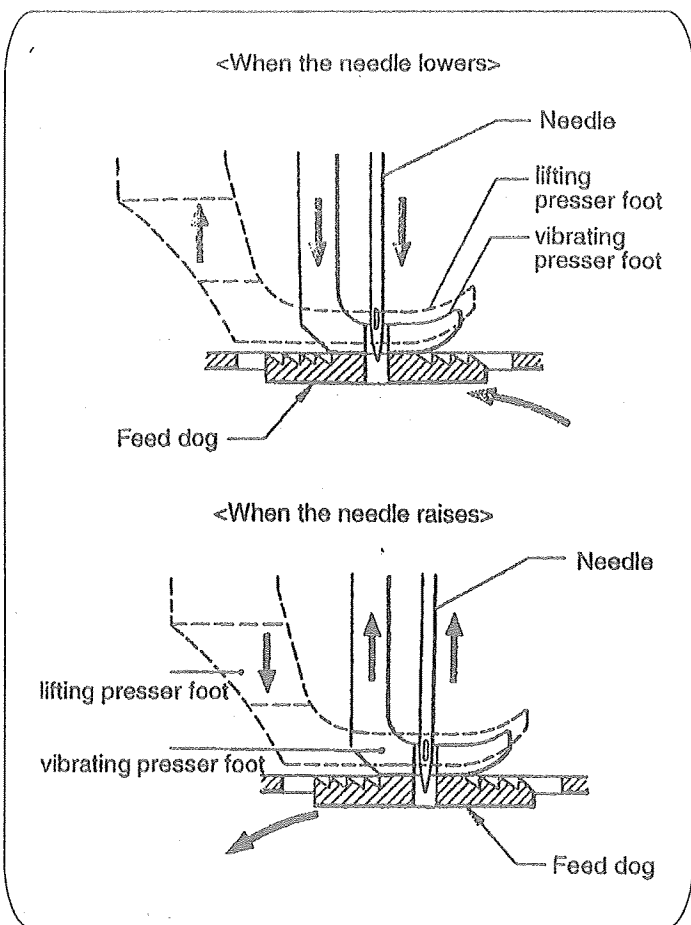
1. Loosen nut ③.
2. Move nut ③ up or down as suitable to the work.
(Raise the nut ③ for increasing motion; or lower it for decreasing motion.)
3. Tighten the nut ③.



Method (B): Adjustment of the movement amount for the vibrating presser foot

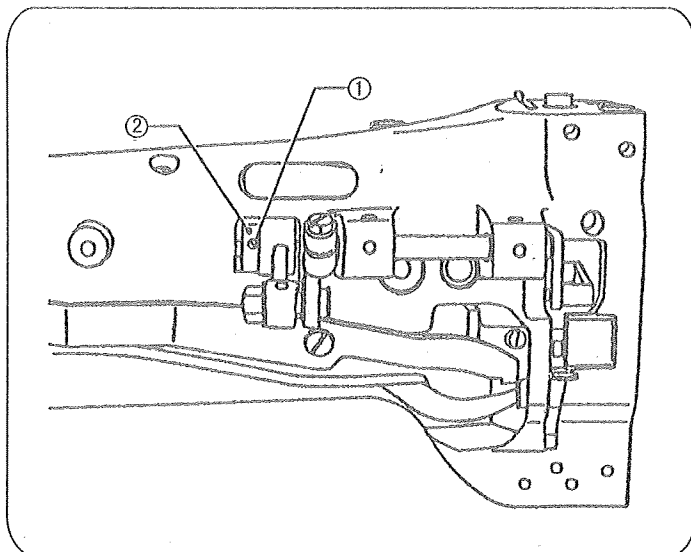
1. Loosen the vibrating presser bar screw ④, and lower the presser bar lifter ⑤.
2. While holding the vibrating presser foot ①, loosen the bolt ⑥ and then move the presser foot ① up or down as necessary.
3. After positioning the vibrating presser foot ①, tighten the bolt ⑥.
4. Tighten the vibrating presser bar screw ④.

8-12. Adjusting the timing of the vibrating presser foot



Check the vibrating presser foot timing as follows:

1. Lower the presser bar lifter lever, then turn the pulley toward you. At this time, the vibrating presser foot should reach the feed dog before the needle eye does.
2. When the needle is raised, make sure the vibrating presser foot is still holding the material firmly. If the vibrating presser foot rises while the needle is still penetrating to the material, it may cause skipped stitches, etc.

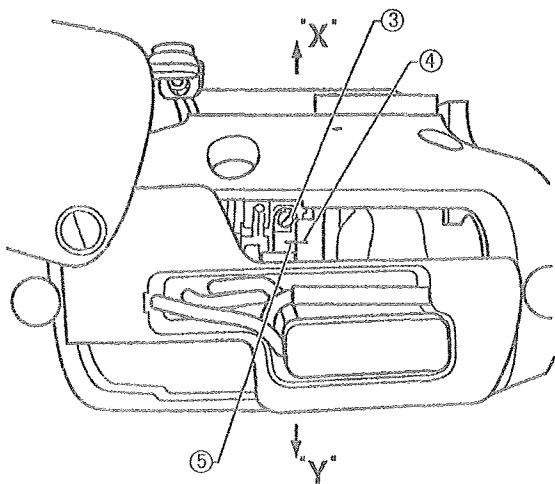
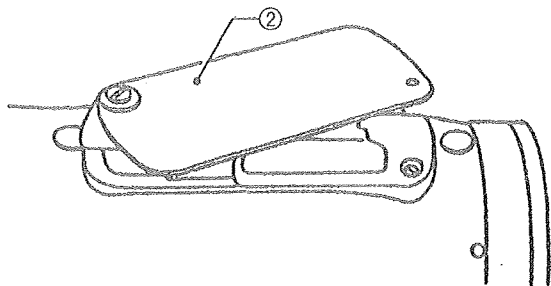
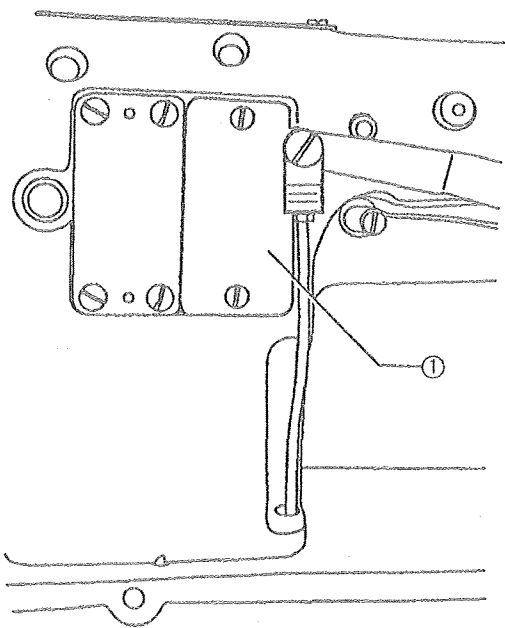


If the timing is not correct after you make these adjustments:

1. Loosen the two screws ①.
2. To synchronize the timing of the vibrating presser foot, turn the cam ②.
3. Tighten the screws ①.

8. STANDARD ADJUSTMENTS

8-13, Adjusting the feed regulator



If the stitch length of forward and reverse are not same, make adjustment of feed regulator.

1. Remove the arm rear cover plate ①.
2. Turn the cover plate ②, loosen the screw ③ with holding upward the reverse lever.
3. When the mark of feed regulator ④ and feed regulator rod ⑤ are alignment, stitch length of forward and reverse will be same.
4. Turn feed regulator rod ⑤ to the arrow "X", stitch length of reverse is bigger and stitch length of forward is smaller.
5. Turn feed regulator rod ⑤ to the arrow "Y", stitch length of reverse is smaller and stitch length of forward is bigger.
6. After adjustment, tighten the screw ③.

9. SAFETY CLUTCH MECHANISM

If the thread is tangled with the rotary hook during sewing, the safety clutch mechanism for the safety clutch pulley operates to stop the lower shaft and let the safety clutch pulley race off load, thereby protecting the rotary hook and timing belt.

Release the safety clutch mechanism as mentioned below.

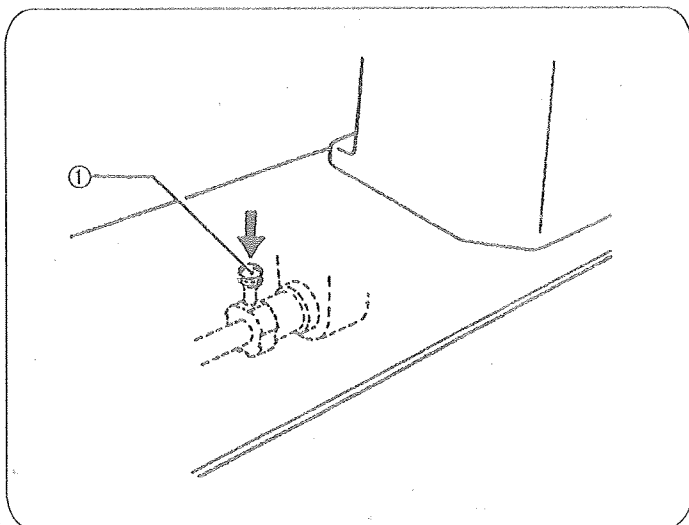
■ Releasing the safety clutch mechanism



CAUTION



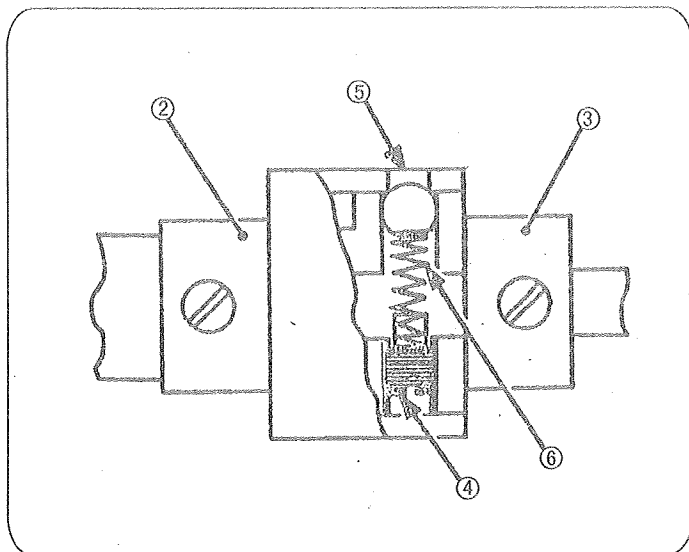
Turn off the power switch before releasing the safety clutch mechanism. The motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work. The machine may operate if the treadle is pressed by mistake, which could result in injury.



1. Remove the thread, etc. entangled with the rotary hook.

NOTE: Do not use a sharp-edged tool to clean the hook, as doing so may damage the hook.

2. Slowly turn the machine pulley while pressing push button and the safety clutch mechanism returns to the original position.

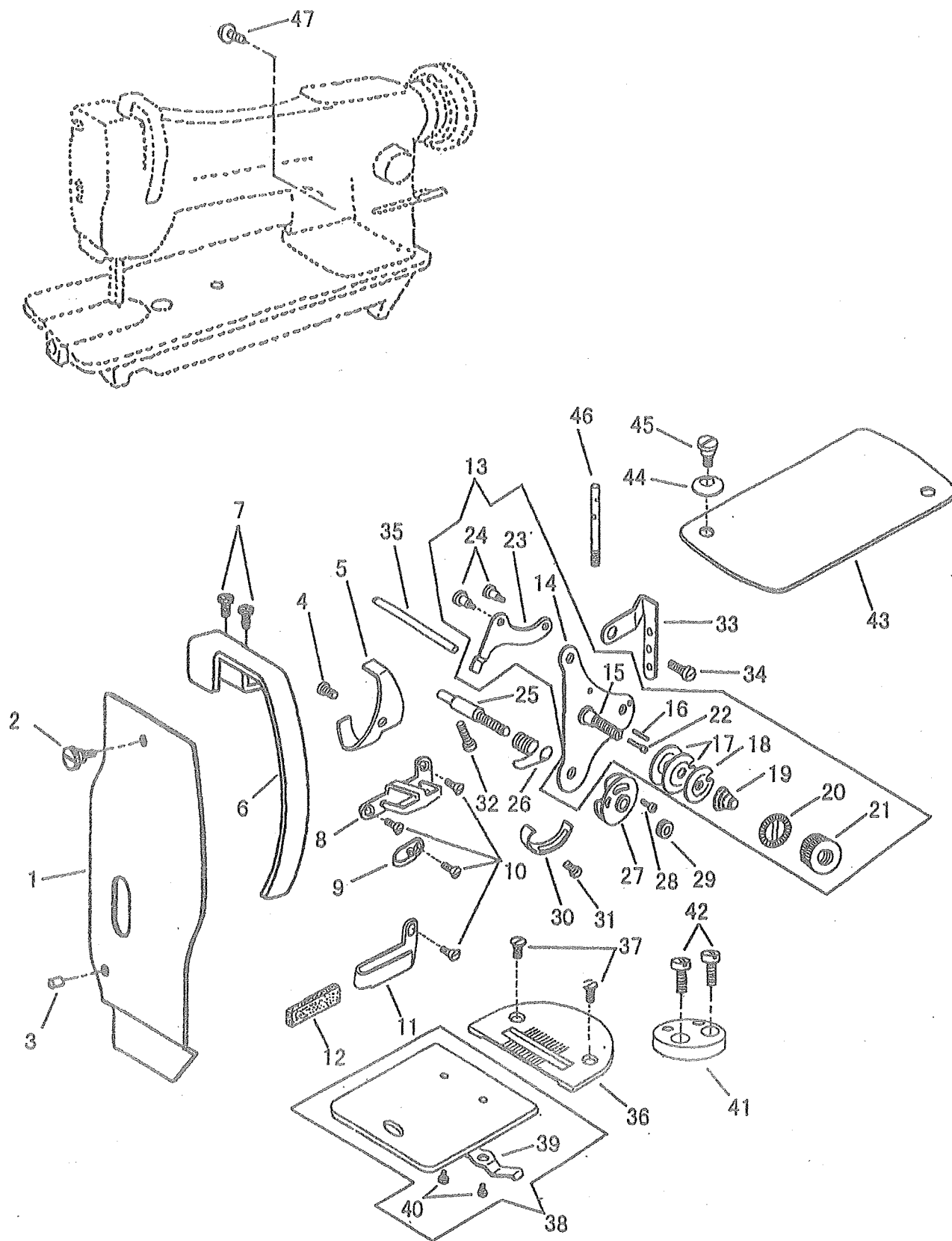


■ Adjustment of spring tension of safety clutch

If the safety clutch should become necessary to adjust spring tension, use the following procedure:

1. Depress the button ① in the bed plate of the machine with your left hand. At the same time, turn the machine pulley strongly so that the safety clutch disengages.
2. Tilt back the machine head. Hold the safety clutch (left) ② and turn the safety clutch (right) ③ until you can see the screw ⑤ through the hole ⑤.
3. To strengthen the tension of spring ④, turn the screw ④ to the right, while to lighten the tension, turn the screw ④ to the left.
4. Upon completion of adjustment, depress the button ①. At the same time, turn the machine pulley until the safety clutch re-engages.

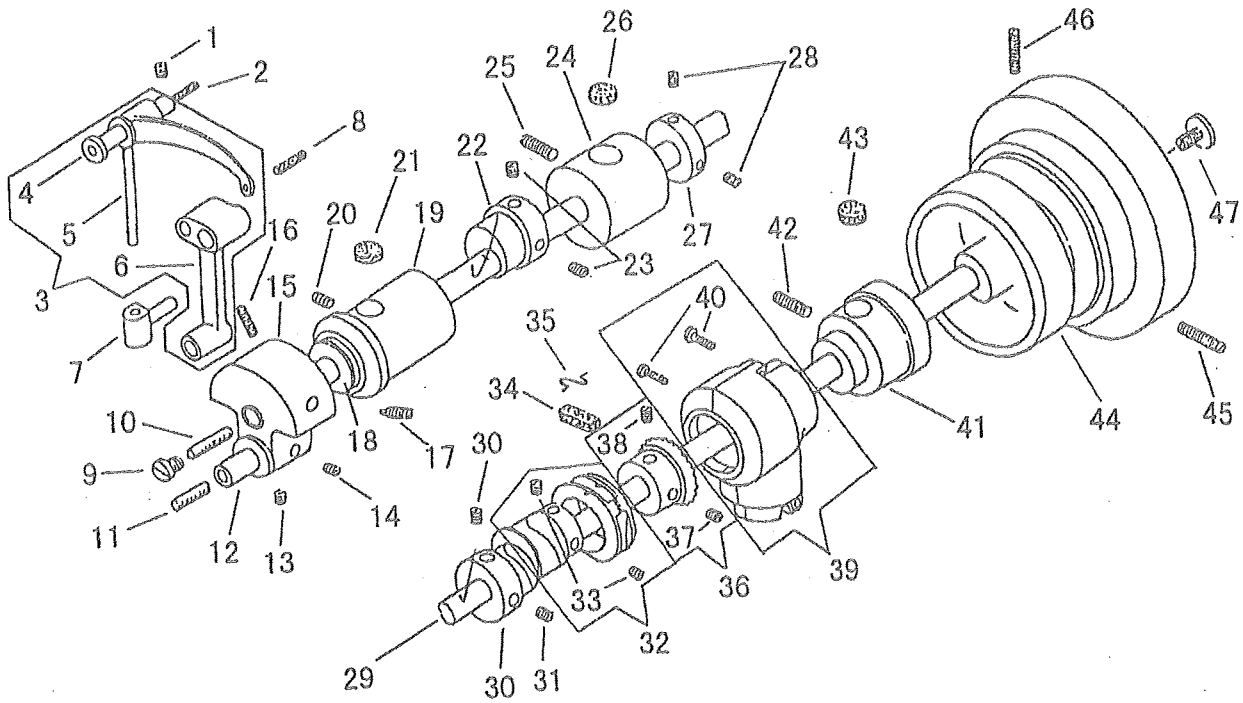
THREAD TENSION, NEEDLE PLATE



FACE PLATE, NEEDLE PLATE, THREAD TENSION

NO.	PART NO.	Qty	PARTS NAME
1	B19451	1	FACE PLATE
2	B8093	1	SCREW 9/64 × 40
3	B10700	1	POSITION PIN
4	B3052	1	SCREW 9/64 × 40 L=4.5
5	B10551	1	OIL GUARD
6	B19452	1	TAKE-UP LEVER COVER
7	B8040	2	SCREW 9/64 × 40 L=8.0
8	B15054	1	THREAD GUIDE (UPPER)
9	B10683	1	THREAD GUIDE (MIDDLE)
10	B19510	4	SCREW 9/64 × 40 L=6.5
11	B10759-A	1	THREAD GUIDE (LOWER)
12	B10760	1	THREAD GUIDE FELT
13	B19421C-A	1	TENSION BRACKET COMPLETE
14	B19421	1	TENSION BRACKET
15	B19511	1	TENSION STUD
16	B10791	1	TENSION BRACKET PIN
17	B19531	2	THREAD DISC
18	B19532	1	TENSION RELEASE WASHER
19	B19533	1	TENSION SPRING
20	B28206	1	TENSION THUMB NUT STOPPER
21	B19513	1	TENSION THUMB NUT
22	B10793	1	TENSION RELEASE PLUNGER
23	B10678	1	TENSION RELEASE LEVER
24	B19422	2	SCREW 9/64 × 40
25	B19512	1	THREAD CONTROLLER STUD
26	B10689	1	THREAD CONTROLLER SPRING
27	B10694	1	THREAD CONTROLLER DISC
28	BB118319	1	SCREW 3/32 × 56 L=6.0
29	B19534	1	TENSION THUMB NUT
30	B10690	1	THREAD CONTROLLER SPRING STOP
31	B8100	1	SCREW 9/64 × 40 L=6.5
32	B19518	1	SCREW 11/64 × 40 L=14.0
33	B15062	1	THREAD RETAINER
34	B18085	1	SCREW 11/64 × 40 L=8.5
35	B19501	1	TENSION RELEASE LEVER ROD
36	B18030-S	1	NEEDLE PLATE
37	B6031-02	2	SCREW 11/64 × 40 L=8.5
38	B18032C	1	BED SLIDE COMPLETE
39	B6034	1	BED SLIDE SPRING
40	B6035	2	SCREW 3/32 × 56 L=2.7
41	B18495	1	EDGE GUIDE PLATE
42	B37254	2	SCREW M4 × 0.7 L=8.0
43	B19455	1	ARM CAP
44	B10703	1	WASHER
45	B12384	1	SCREW 3/16 × 32
46	B10709	1	SPOOL PIN SCREW 7/32 × 32
47	B30046	1	EARTH WIRE SCREW M4 × 0.7 L=4.0

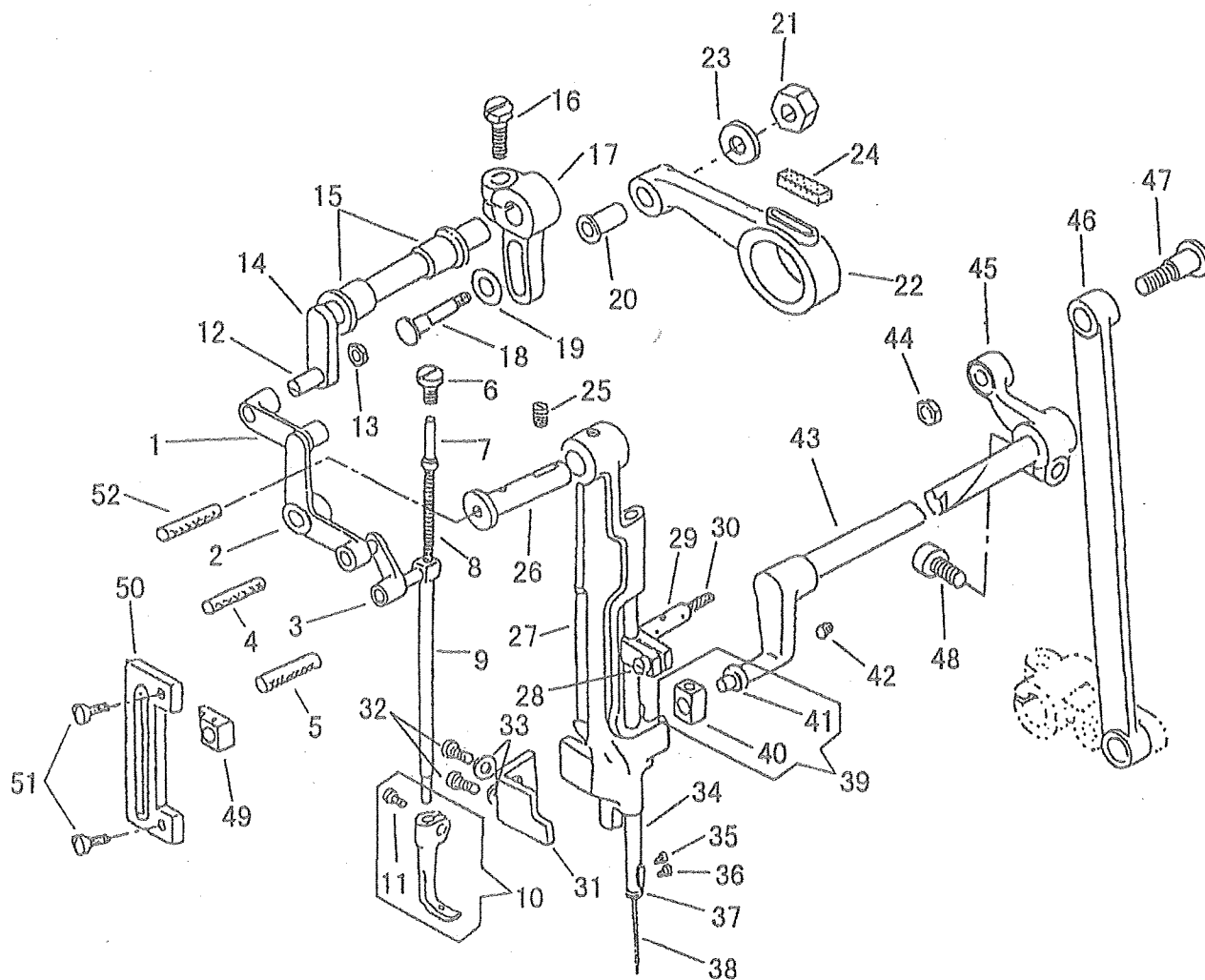
ARM SHAFT, TAKE UP LEVER



ARM SHAFT, THREAD TAKE-UP LEVER

NO.	PART NO.	Qty	PARTS NAME
1	B8009	1	SCREW 15/64 × 28 L=7.5
2	B10724	1	OILING WICK
3	B18003C	1	THREAD TAKE-UP LEVER COMPLETE
4	B10527	1	TAKE-UP LEVER HINGED STUD
5	B18003	1	THREAD TAKE-UP LEVER
6	B10528	1	NEEDLE BAR CONNECTING LINK
7	B15026	1	TAKE-UP LEVER DRIVING STUD
8	B10728	1	OILING WICK
9	B19504	1	OIL PACKING STOP SCREW 5/16 × 28 L=6.0
10	B10724	1	OILING WICK
11	B10726	1	OILING WICK
12	B10523	1	NEEDLE BAR CONNECTING LINK STUD
13	B19418	1	SCREW 1/4 × 28 L=4.5
14	B19417	1	SCREW 1/4 × 28 L=6.5
15	B19414	1	NEEDLE BAR CRANK
16	B19416	1	SET SCREW 1/4 × 28 L=14.0
17	B19415	1	POSITION SCREW 1/4 × 28 L=20.0
18	B10563	1	WASHER
19	B18006	1	ARM SHAFT BUSHING (FRONT)
20	B1786	1	SCREW 15/64 × 28 L=12.0
21	B10725	1	OILING FELT
22	B18486	1	LIFTING ECCENTRIC
23	B19508	2	SCREW 1/4 × 40 L=5.5
24	B18008	1	ARM SHAFT BUSHING (MIDDLE)
25	B10579	1	SCREW 15/64 × 28 L=20.0
26	B10725	1	OILING FELT
27	B19508	1	ARM SHAFT BUSHING COLLAR
28	B23637	2	SCREW 1/4 × 28 L=7.5
29	B19503-A	1	ARM SHAFT (STANDARD MACHINE)
	B19503-B	1	ARM SHAFT (18 " MACHINE)
	B19503-C	1	ARM SHAFT (25 " MACHINE)
30	B19521	1	FEED LIFTING CAM
31	B10827	2	SCREW 1/4 × 40 L=7.5
32	B19528C	1	FEED DRIVING ECCENTRIC COMPLETE
33	B23637	2	SCREW 1/4 × 28 L=7.5
34	B17041	1	OILING FELT
35	B10723	1	OILING FELT RETAINER
36	B17017C	1	ARM SHAFT GEAR (SPIRAL) COMPLETE
37	B17018	1	POSITION SCREW 1/4 × 40 L=8.0
38	B17019	1	SET SCREW 1/4 × 40 L=7.5
39	B17015C	1	GEAR COVER COMPLETE (UPPER)
40	B17016	2	SET SCREW 9/64 × 40 L=10.0
41	B17013	1	ARM SHAFT BUSHING (REAR)
42	B10579	1	SCREW 15/64 × 28 L=20.0
43	B13081	1	OILING FELT
44	B18470	1	BALANCE WHEEL
45	B10576	1	POSITION SCREW 15/64 × 28 L=21.0
46	B10579	1	SET SCREW 15/64 × 28 L=20.0
47	B19505	1	SCREW 3/32 × 28 L=11.0

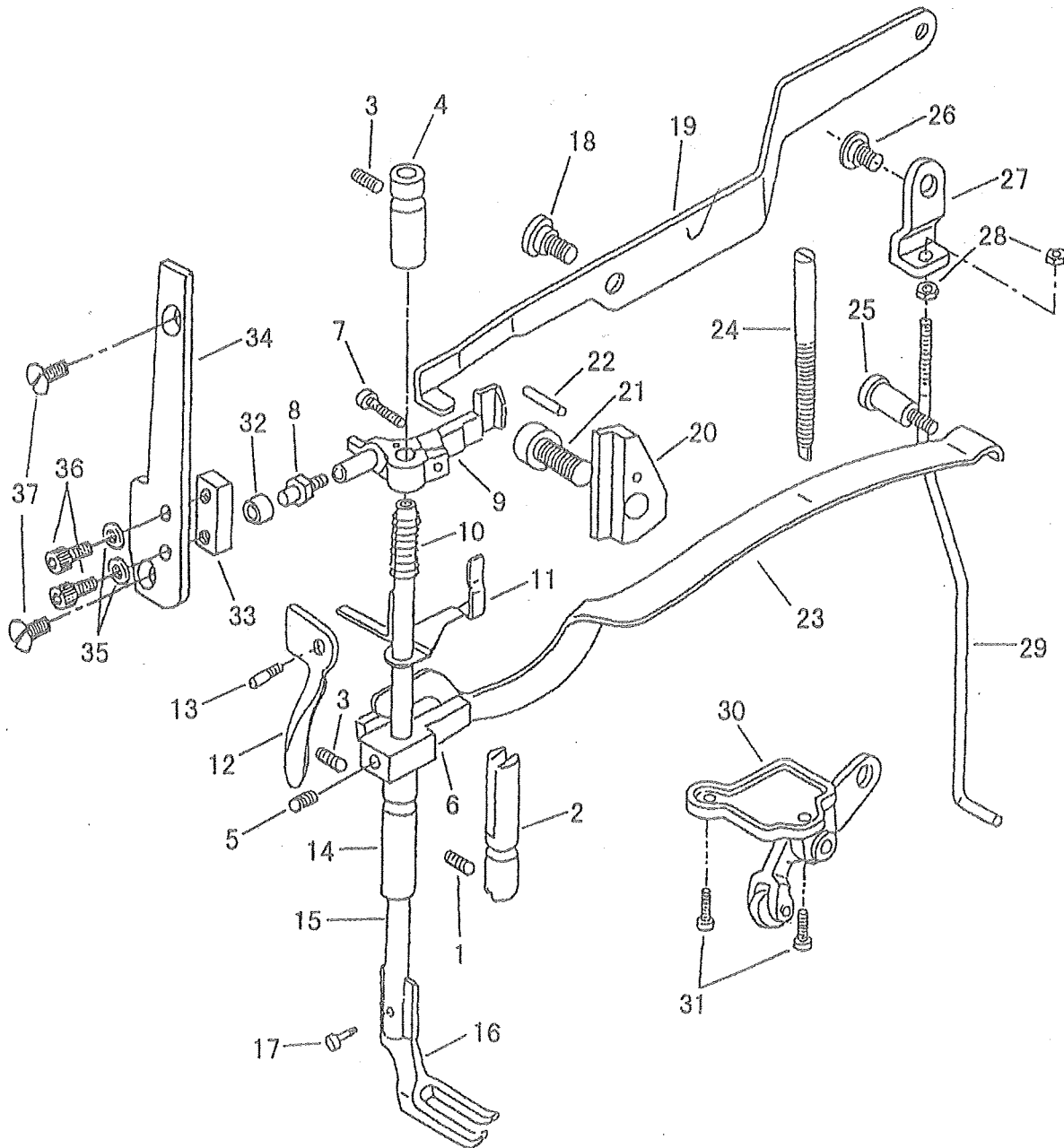
NEEDLE BAR, FEEDLE BAR ROCK FRAME



NEEDLE BAR, NEEDLE BAR ROCK FRAME

NO.	PART NO.	Qty	PARTS NAME
1	B10557	1	LIFTING BELL CRANK LINK
2	B19509	1	LIFTING BELL CRANK
3	B10556	1	PRESSER BAR CONNECTING LINK
4	B10728	1	OILING WICK
5	B10728	1	OILING WICK
6	B19517	1	SCREW 5/16 x 28 L=16.0
7	B10553-A	1	VIBRATING PRESSER BAR EXTENSION
8	B10554	1	PRESSER BAR EXTENSION SPRING
9	B34713	1	VIBRATING PRESSER BAR
10	B19412C	1	VIBRATING PRESSER FOOT COMPLETE
11	B17104	1	PINCH SCREW 11/64 x 40 L=6.0
12	B19515	1	HINGE SCREW 1/4 x 28
13	B19516	1	NUT 1/4 x 28
14	B19514	1	LIFTING ROCK SHAFT
15	B10514	2	LIFTING ROCK SHAFT BUSHING
16	B19420	1	PINCH SCREW 1/4 x 28 L=16.0
17	B19419	1	CONNECTING CRANK
18	B10775	1	HINGE SCREW 7/32 x 32
19	B12136	1	WASHER
20	B10774	1	CONNECTING COLLAR
21	B17114	1	NUT 7/32 x 32
22	B18485	1	LIFTING ECCENTRIC CONNECTION
23	B37215	1	WASHER
24	B17041	1	OILING FELT
25	B100446	1	SCREW 15/64 x 28 L=8.8
26	B34712	1	HINGE STUD
27	B17611	1	NEEDLE BAR ROCK FRAME
28	B37134	1	PINCH SCREW M4 x 0.7 L=10.0
29	B19426	1	NEEDLE BAR CONNECTING STUD
30	B19429	1	OILING WICK
31	B34723	1	POSITION BRACKET
32	B37134	2	SCREW M4 x 0.7 L=10.0
33	B30078	2	WASHER
34	B19413	1	NEEDLE BAR
35	B6035	1	SCREW 3/32 x 56 L=2.7
36	BB140553	1	SCREW 1/8 x 40 L=4.5
37	B10533	1	NEEDLE BAR THREAD GUIDE
38	BN0122	1	NEEDLE DP x 17 #22
39	B11876C	1	SLIDE BLOCK COMPLETE
40	B11877	1	SLIDE BLOCK
41	B11876	1	HINGE SCREW 7/32 x 32
42	B10581	1	SCREW 7/32 x 32 L=7.0
43	B17048-A	1	ARM SHAFT (STANDARD MACHINE)
	B17048-B	1	ARM SHAFT (18 " MACHINE)
	B17048-C	1	ARM SHAFT (25 " MACHINE)
44	B6026-02	1	NUT 9/32 x 28
45	B19409	1	CONNECTION
46	B18017	1	CONNECTION ROD
47	B18018	1	HINGE SCREW 9/32 x 28
48	B19408	1	PINCH SCREW 1/4 x 28 L=17.5
49	B34722	1	VIBRATING PRESSER BAR BLOCK
50	B34721	1	VIBRATING PRESSER BAR BLOCK GUIDE
51	B8100	2	SCREW 9/64 x 40 L=6.5
52	B10728	1	OILING WICK

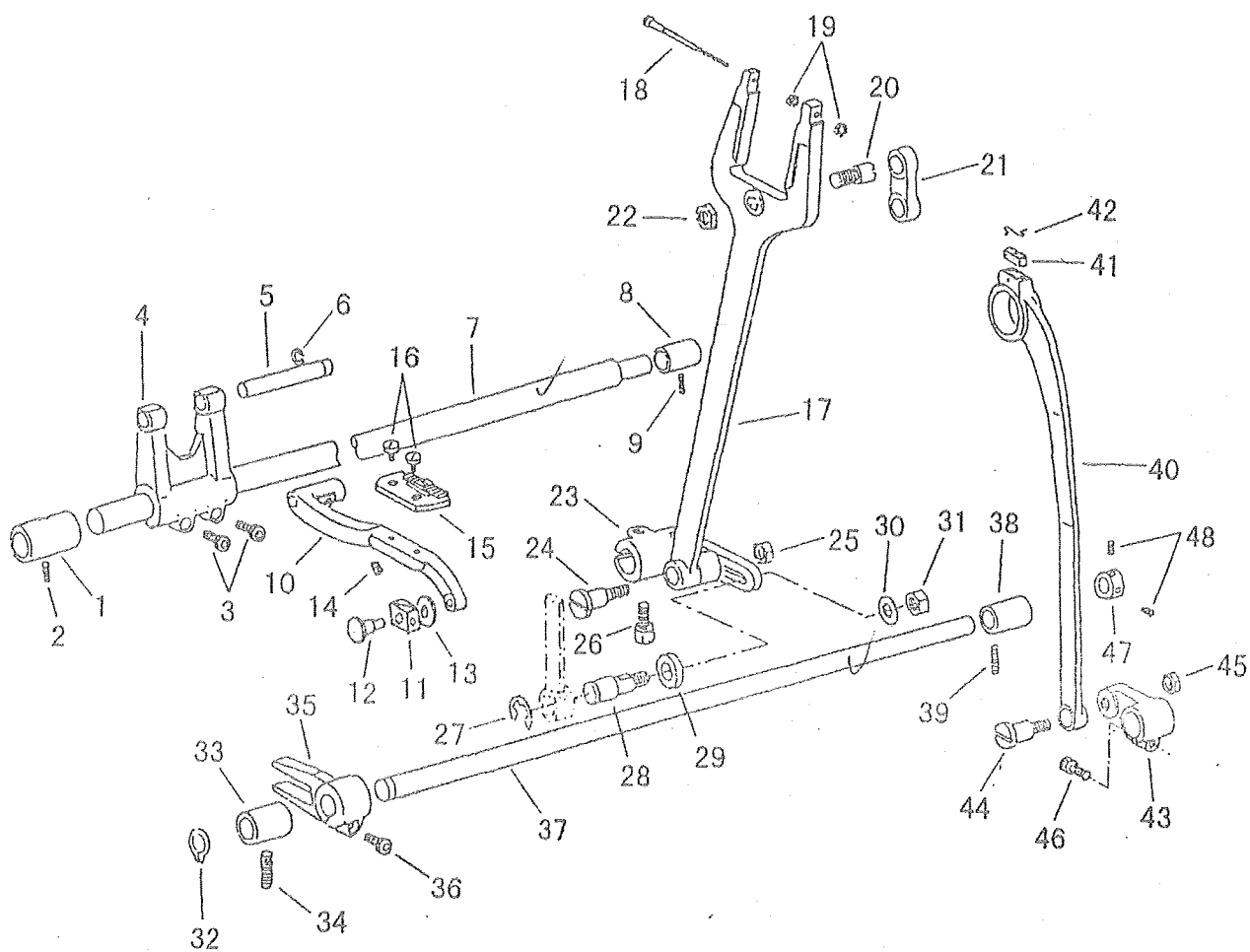
PRESSER BAR,LIFTING PRESSER FOOT



PRESSER BAR, LIFTING PRESSER FOOT

NO.	PART NO.	Qty	PARTS NAME
1	B8043	1	SCREW M6 × 1 L=10.0
2	B6729	1	PRESSER BAR POSITION GUIDE
3	B9406	2	SCREW 15/64 × 28 L=11.0
4	B0538	1	PRESSER BAR BUSHING (UPPER)
5	B5999	1	SCREW M6 × 1 L=6.0
6	B8478	1	PRESSER BAR POSITION GUIDE BRACKET
7	B9518	1	PINCH SCREW 11/64 × 40 L=14.0
8	B4828	1	SCREW 11/64 × 40
9	B8479	1	PRESSER BAR LIFTING BRACKET
10	B0547	1	SPRING
11	B0546-A	1	TENSION RELEASE SLIDE
12	B0659	1	PRESSER BAR LIFTER
13	B9405	1	HINGE SCREW 3/16 × 32
14	B8085	2	SCREW 11/64 × 40 L=8.5
15	B8477	1	PRESSER BAR
16	B0796	1	LIFTING PRESSER FOOT
17	B8483	1	SCREW 9/64 × 40 L=9.0
18	B9403	1	HINGE SCREW 1/4 × 28
19	B18080-A	1	ARM SHAFT (STANDARD MACHINE)
	B18080-B	1	ARM SHAFT (18 " MACHINE)
	B18080-C	1	ARM SHAFT (25 " MACHINE)
20	B0548-A	1	BRACKET GUIDE BLOCK
21	B9408	1	PINCH SCREW 1/4 × 28 L=17.5
22	B5111	1	PIN
23	B5026	1	PRESSER BAR SPRING
24	B9519	1	PRESSER BAR SPRING REGULATING SCREW 1/4 × 28
25	B9404	1	PRESSER BAR SPRING SUPPORT SCREW 1/4 × 28
26	B384	1	HINGE SCREW 15/64 × 28
27	B359-A	1	LIFTING LEVER CONNECTING ROD JOINT
28	B360	2	NUT 3/16 × 32
29	B8081	1	LIFTING LEVER CONNECTING ROD
30	B8862	1	KNEE LIFTER BELL CRANK COMPLETE
31	B0539-A	1	PRESSER BAR BUSHING (LOWER)
32	B4717	1	LIFTING BELL CRANK GUIDE COLLAR
33	B4718	1	LIFTING BELL CRANK GUIDE BLOCK
34	B4719	1	LIFTING BELL CRANK GUIDE PLATE
35	B6287	2	WASHER
36	B0601	2	SCREW M5 × 0.8 L=10.0
37	B4720	2	SCREW M6 × 1 L=12.0

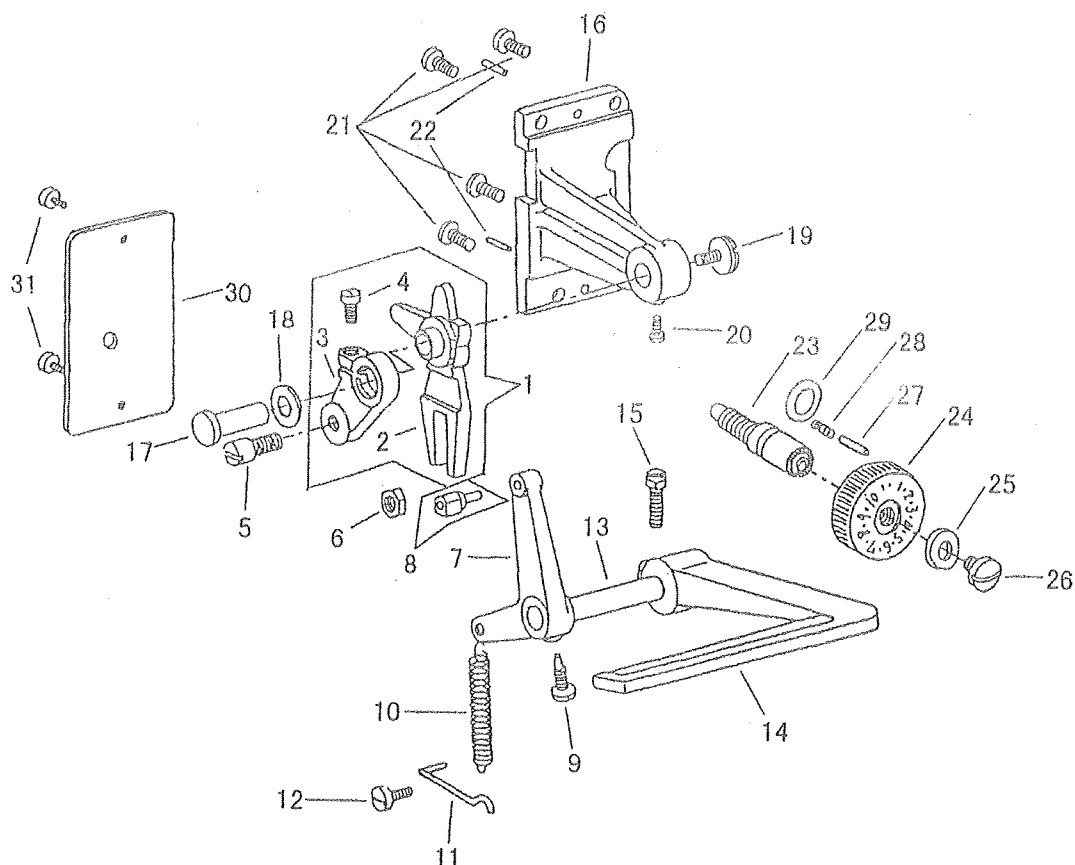
FEED MECHANISM



FEED MECHANISM

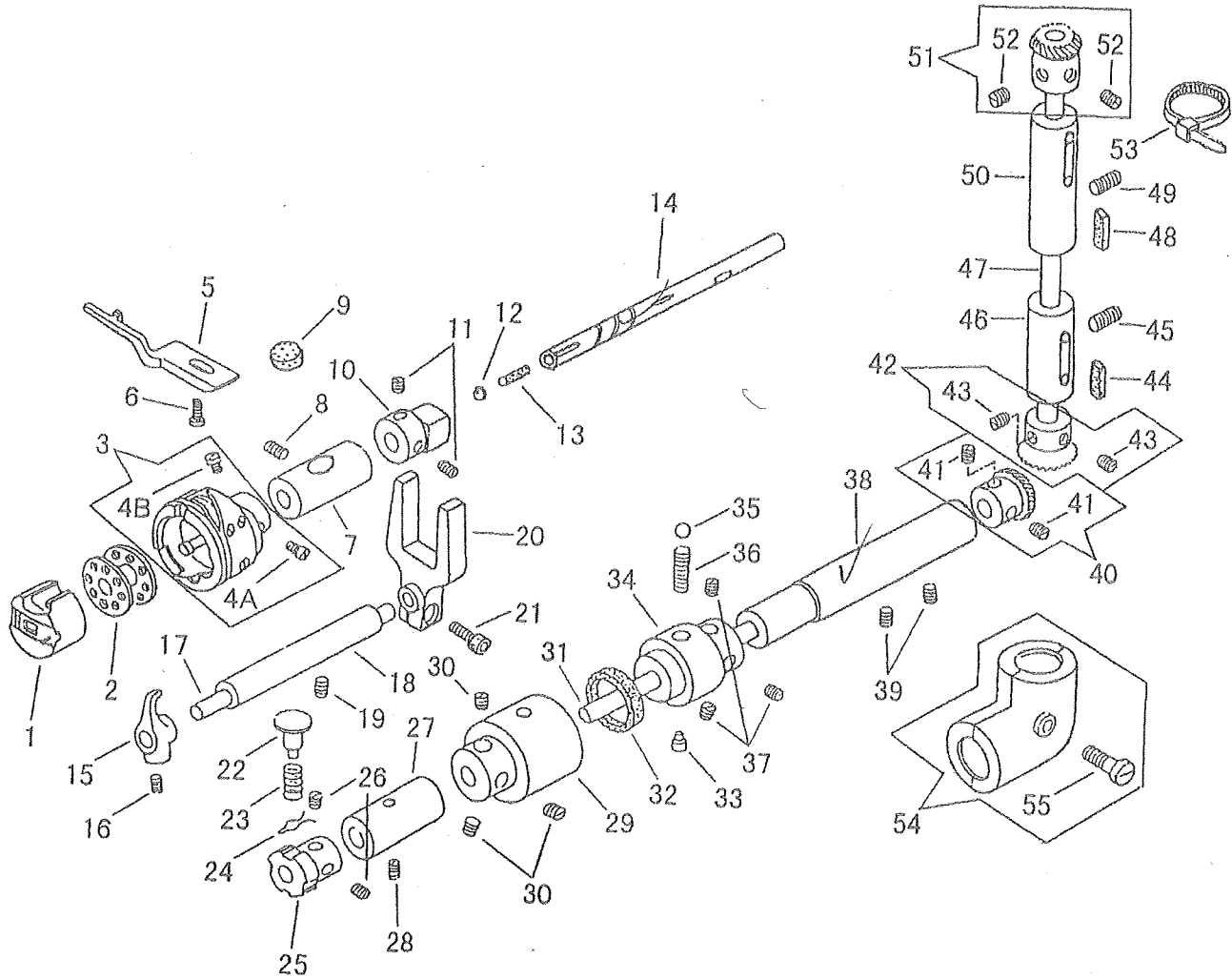
NO.	PART NO.	Qty	PARTS NAME
1	B8523	1	FEED ROCK SHAFT BUSHING (FRONT)
2	B009	1	SCREW 15/64 × 28 L=7.5
3	B8065	2	PINCH SCREW M5 × 0.8 L=14.0
4	B8694	1	FEED ROCK SHAFT BASE
5	B8696	1	FEED BASE SUPPORTING PIN
6	B1094	1	"E" RING
7	B18061-A	1	ARM SHAFT (STANDARD MACHINE)
	B18061-B	1	ARM SHAFT (18 " MACHINE)
	B18061-C	1	ARM SHAFT (25 " MACHINE)
8	B8702	1	FEED ROCK SHAFT BUSHING (BACK)
9	B009	1	SCREW 15/64 × 28 L=7.5
10	B9526	1	FEED BASE
11	B9535	1	FEED BAR SLIDE BLOCK
12	B9529	1	SLIDE BLOCK PIN
13	B9530	1	WASHER
14	B0230	1	SCREW 3/10 × 32 L=5.0
15	B8031	1	FEED DOG
16	B9525	2	SCREW 1/8 × 40 L=6.0
17	B8122	1	FEED FORKED CONNECTION
18	B8121	1	HINGE SCREW M3 × 0.5
19	B211	2	NUT M3 × 0.5(SMALL)
20	B8014	1	HINGE SCREW 9/32 × 28
21	B7207	1	FEED CONNECTING LINK
22	B105	1	NUT 9/32 × 28
23	B9527	1	FEED ROCK SHAFT CRANK (BACK)
24	B8015	1	HINGE SCREW 9/32 × 28
25	B105	1	NUT 9/32 × 28
26	B1021	1	PINCH SCREW M6 × 1 L=18.0
27	B7095	1	"E" RING
28	B8539	1	HINGE SCREW M6 × 1
29	B8540	1	WASHER
30	B0599	1	WASHER
31	B1412	1	NUT M6 × 1
32	B8490	1	RETAINING RING
33	B8489	1	FEED LIFTING ROCK SHAFT BUSHING(FRONT)
34	B009	1	SCREW 15/64 × 28 L=7.5
35	B8492	1	FEED LIFTING CRANK (FRONT)
36	B0066	1	PINCH SCREW M5 × 0.8 L=12.0
37	B8488	1	FEED LIFTING ROCK SHAFT
38	B8489	1	FEED LIFTING ROCK SHAFT BUSHING (BACK)
39	B009	1	SCREW 15/64 × 28 L=7.5
40	B8021	1	CRANK CONNECTING ROD
41	B7041	1	OILING FELT
42	B0723	1	RETAINER
43	B8493	1	FEED LIFTING CRANK(BACK)
44	B8018	1	HINGE SCREW 9/32 × 28
45	B105	1	NUT 9/32 × 28
46	B8065	1	PINCH SCREW M5 × 0.8 L=14.0
47	B8491	1	LIFTING SHAFT COLLAR
48	B9508	2	SCREW 1/4 × 40 L=5.5

FEED REGULATOR



NO.	PART NO.	Qty	PARTS NAME
1	B19542C	1	FEED REGULATOR COMPLETE
2	B19542	1	FEED REGULATOR
3	B19524	1	FEED REGULATOR ROD
4	B37134	1	PINCH SCREW M4 × 0.7 L=10.0
5	B17209	1	FEED REGULATOR SCREW 9/32 × 28
6	B8105	1	NUT 9/32 × 28
7	B18506	1	REVERSE LEVER SHAFT CRANK
8	B18721C	1	REVERSE BLOCK COMPLETE
9	B18507	1	SCREW 15/64 × 28
10	B18515	1	REVERSE LEVER SPRING
11	B18516	1	SPRING RETAINER
12	B7033	1	SCREW 9/64 × 40 L=10.8
13	B18574	1	REVERSE LEVER SHAFT
14	B19544	1	REVERSE LEVER
15	B10845	1	PINCH SCREW 15/64 × 28 L=18.0
16	B19546	1	FEED REGULATING BASE
17	B18494	1	FEED REGULATING SUPPORT STUD
18	B17057	1	WASHER
19	B1392	1	SCREW 11/64 × 40 L=6.5
20	B19552	1	SCREW 11/64 × 28 L=11.5
21	B30066	4	SCREW M5 × 0.8 L=12.0
22	B50174	2	POSITION PIN
23	B19523	1	FEED REGULATING SCREW
24	B18496	1	FEED REGULATING DIAL
25	BB142746	1	WASHER
26	B19522	1	SCREW 3/16 × 32 L=20.0
27	BB145502	1	PIN
28	BB100328	1	SPRING
29	B18420	1	O RING
30	B19543	1	ARM SIDE COVER
31	B37509	2	SCREW M5 × 0.8 L=6.0

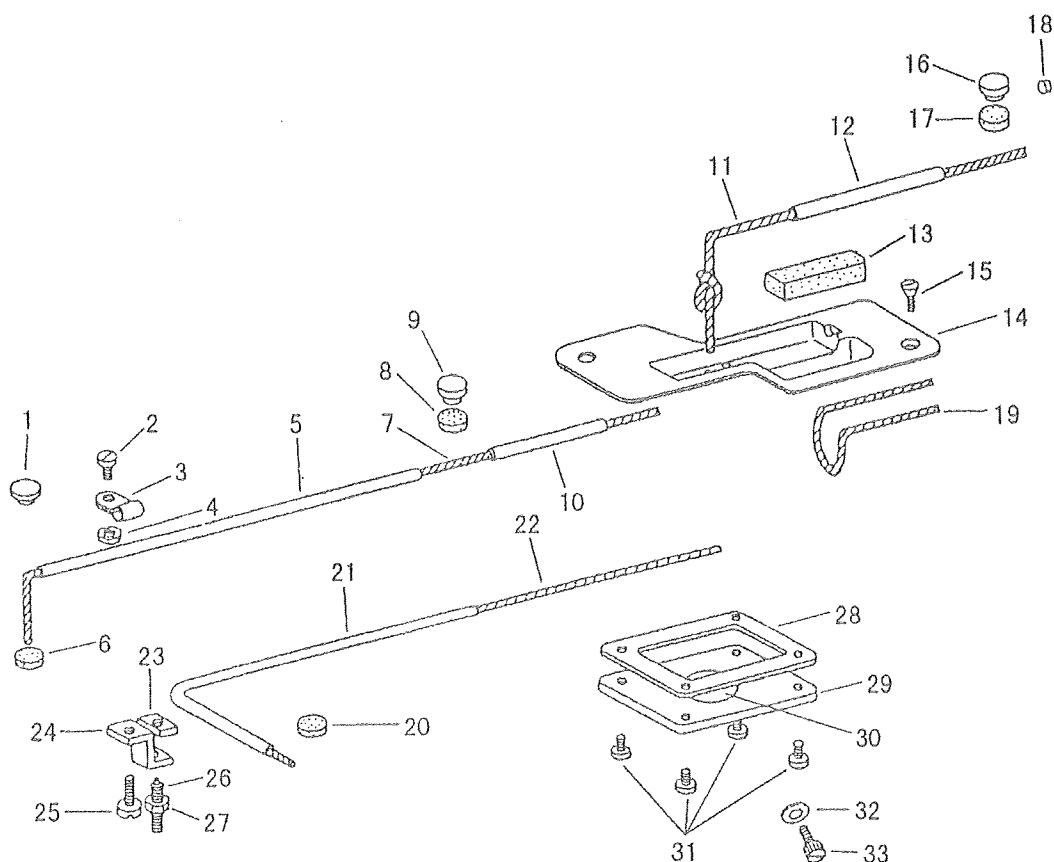
ARM SHAFT(UPRIGHT),LOWER SHAFT



ARM SHAFT(UPRIGHT),LOWER SHAFT

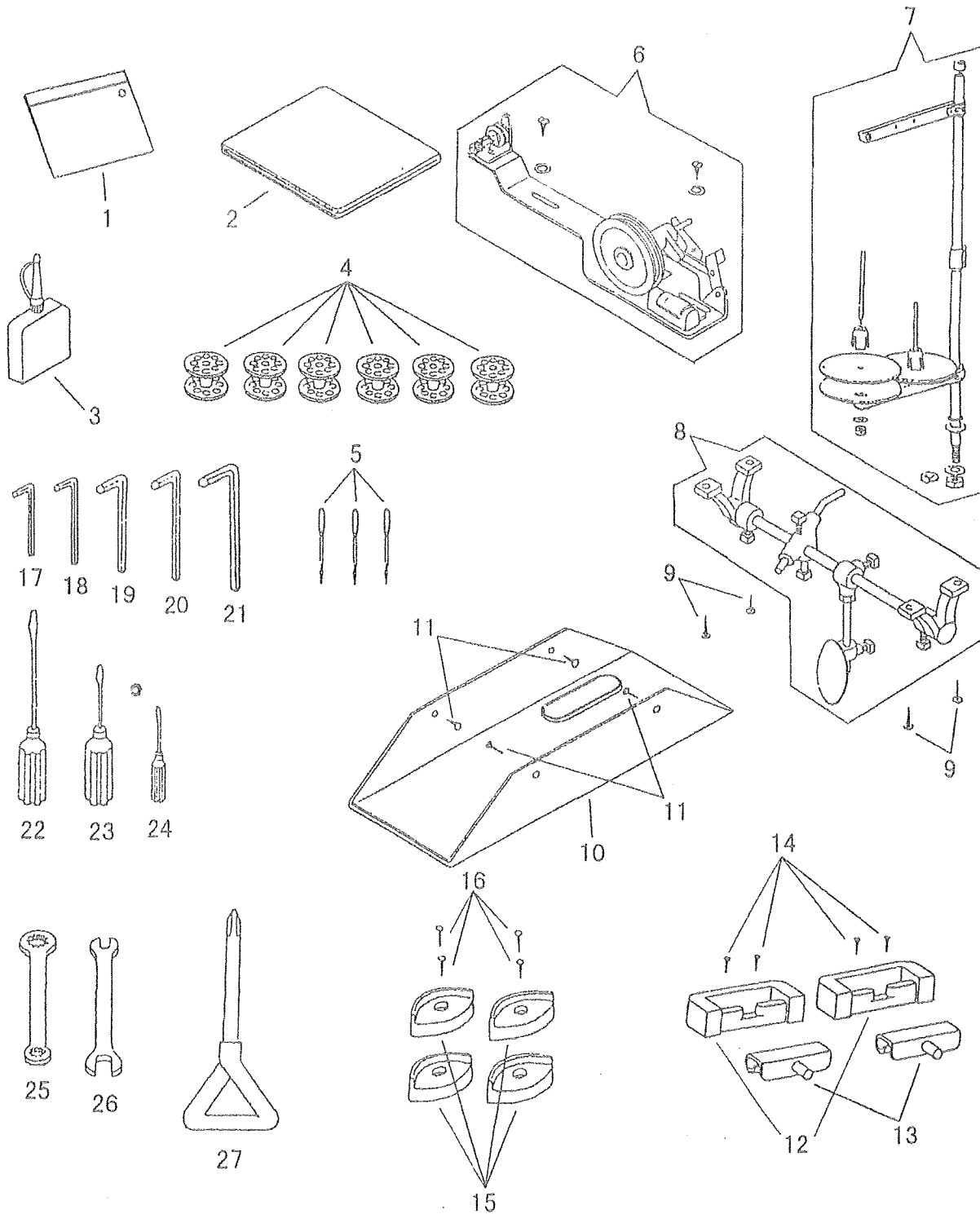
NO.	PART NO.	Qty	PARTS NAME
1	B18096	1	BOBBIN CASE COMPLETE
2	B18034	1	BOBBIN
3	B18033C	1	ROTATING HOOK COMPLETE
4A	B18033-07	1	POSITION SCREW 11/84 × 40 L=8.9
4B	B18033-08	1	SET SCREW 11/64 × 40 L=7.3
5	B18035	1	HOOK SUPPORTING PLATE
6	B6025	1	SCREW 11/64 × 40 L=12.0
7	B18090	1	HOOK SHAFT BUSHING (FRONT)
8	B8009	1	SCREW 15/64 × 28 L=7.5
9	B11069	1	OILING FELT
10	B18044	1	HOOK SHAFT CAM
11	B8009	2	SCREW 15/84 × 28 L=7.5
12	B18351	1	WASHER
13	B0148-B	1	OILING FELT
14	B18089	1	HOOK DRIVING SHAFT
15	B18039	1	THREAD RELEASING FINGER
16	B18040	1	SCREW M5 × 0.8 L=8.0
17	B18041	1	THREAD RELEASING SHAFT
18	B18042	1	THREAD RELEASING SHAFT BUSHING
19	B8009	1	SCREW 15/64 × 28 L=7.5
20	B18043	1	THREAD RELEASING SHAFT FORK
21	B30066	1	PINCH SCREW M5 × 0.8 L=12.0
22	B18053	1	PUSH BUTTON
23	B18054	1	PUSH BUTTON SPRING
24	B10674	1	CLIP
25	B18052	1	HOOK SHAFT LOCK RATCHET
26	B19508	2	SCREW 1/4 × 40 L=5.0
27	B18038-A	1	HOOK SHAFT BUSHING (REAR)
28	B8009	1	SCREW 15/64 × 28 L=7.5
29	B18047	1	SAFETY CLUTCH (LEFT)
30	B17019	3	SCREW 1/4 × 40 L=7.5
31	B18056	1	LOWER SHAFT
32	B18046	1	OILING WICK
33	B18051	1	SCREW 9/32 × 28
34	B18048	1	SAFETY CLUTCH (RIGHT)
35	B18049	1	STEEL BALL
36	B18050	1	SPRING
37	B17019	3	SCREW 1/4 × 40 L=7.5
38	B18057-A	1	ARM SHAFT (STANDARD MACHINE)
	B18057-B	1	ARM SHAFT (18 " MACHINE)
	B18057-C	1	ARM SHAFT (25 " MACHINE)
39	B8009	2	SCREW 15/64 × 28 L=7.5
40	B17028C	1	LOWER SHAFT GEAR (SPIRAL) COMPLETE
41	B17022	2	SET SCREW 1/4 × 40 L=5.0
42	B17023C	1	ARM SHAFT (UPRIGHT) GEAR (LOWER) (SPIRAL) COMPLE
43	B17022	2	SET SCREW 1/4 × 40 L=5.0
44	B17026	1	OILING FELT
45	B10579	1	SET SCREW 15/64 × 28 L=20.0
46	B19553	1	ARM SHAFT (UPRIGHT) BUSHING (LOWER)
47	B17020	1	ARM SHAFT (UPRIGHT)
48	B17026	1	OILING FELT
49	B10579	1	SCREW 15/64 × 28 L=20.0
50	B19554	1	ARM SHAFT (UPRIGHT) BUSHING (UPPER)
51	B17021C	1	ARM SHAFT (UPRIGHT) GEAR (SPIRAL) COMPLETE
52	B17022	2	SET SCREW 1/4 × 40 L=5.0
53	B30750	1	BAND
54	B18058C	1	GEAR COVER (LOWER) (SPIRAL) COMPLETE
55	B18059	1	PINCH SCREW 15/64 × 28 L=26

LUBRICATION



NO.	PART NO.	Qty	PARTS NAME
1	B20171	1	RUBBER PLUG
2	B4124	1	SCREW M4 × 0.7 L=9.5
3	B30022	1	OILING WICK CLAMP
4	B31206	1	NUT
5	B18112	1	OIL TUBE 160MM
6	B11069	1	OILING FELT
7	B18110	1	OILING WICK 380MM
8	B11069	1	OILING FELT
9	B20171	1	RUBBER PLUG
10	B18113	1	OIL TUBE 35MM
11	B18109	1	OILING WICK 220MM
12	B18111	1	OIL TUBE 75MM
13	B18104	1	FELT
14	B19106	1	OIL RESERVOIR
15	B11044	1	SCREW 1/8 × 40 L=7.0
16	B20171	1	RUBBER PLUG
17	B11069	1	OILING FELT
18	B20067	1	RUBBER PLUG
19	B18108	1	OILING WICK 100MM
20	B11069	1	OILING FELT
21	B18100	1	OIL TUBE 80MM
22	B18101	1	OILING WICK 180MM
23	B18094	1	OIL CONTROLLER
24	B18093	1	OIL CONTROLLER PLATE
25	B21104	1	SCREW 11/64 × 40 L=7.5
26	B18095	1	REGULATING SCREW M4 × 0.7 L=16.0
27	B4137	1	NUT M4 × 0.7
28	B18354	1	OIL RESERVOIR GASKET
29	B19545	1	OIL RESERVOIR PLATE
30	B18353	1	OIL RESERVOIR WINDOW
31	B15007	4	SCREW 9/64 × 40 L=10.0
32	B18092	1	OIL PACKING
33	B18091	1	SCREW 11/64 × 40

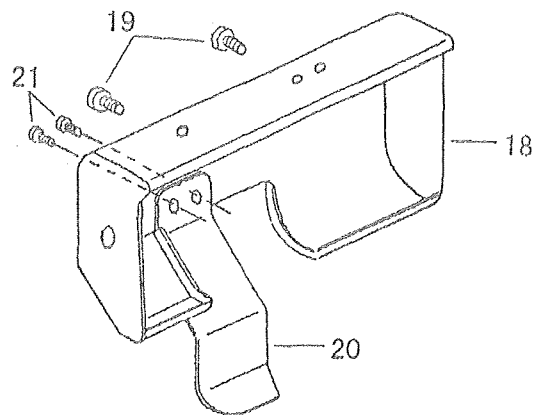
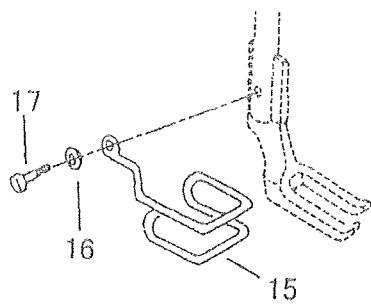
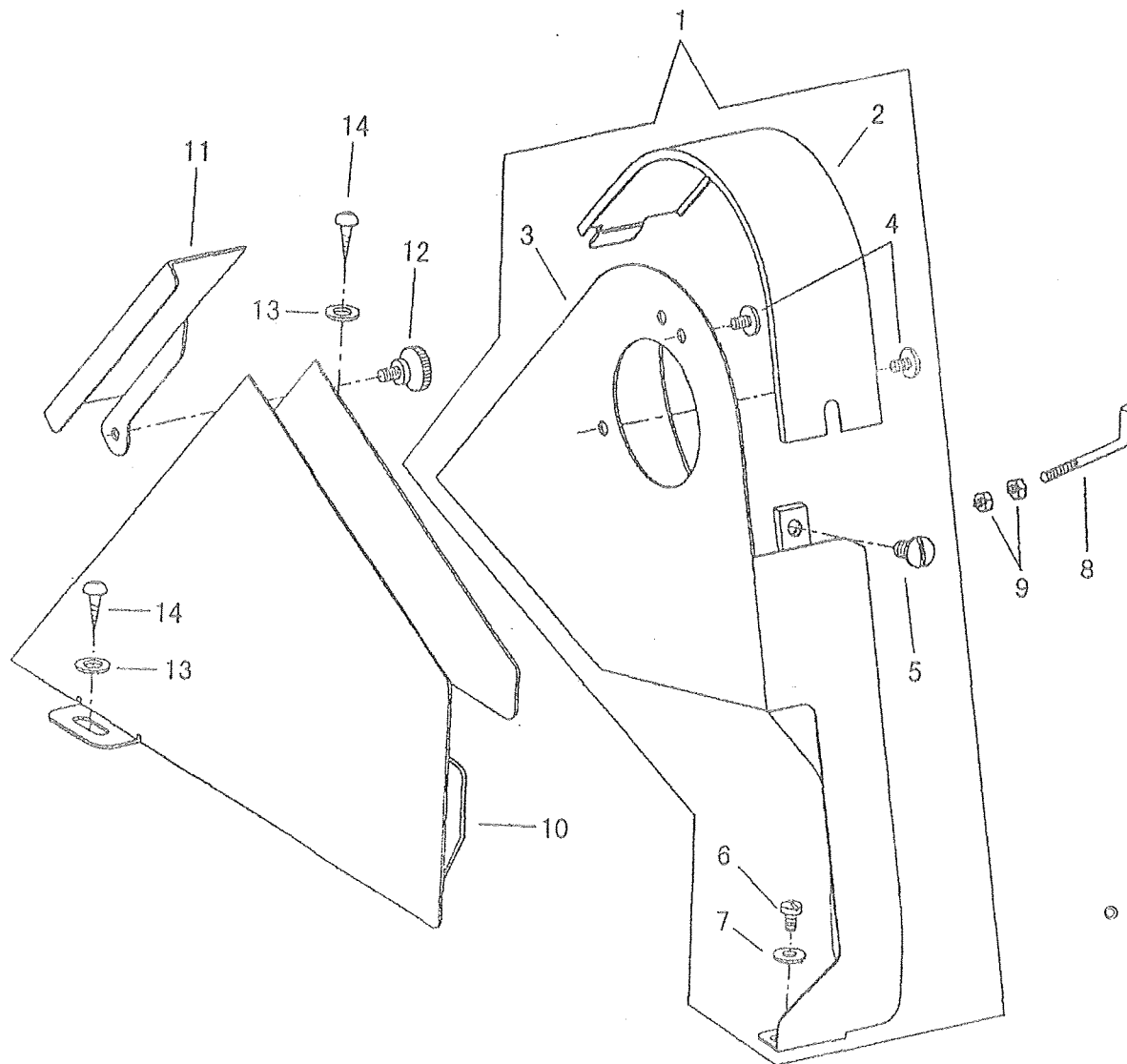
ACCESSORIES



ACCESSORIES

NO.	PART NO.	Qty	PARTS NAME
1	B8132-B	1	ACCESSORIES BAG
2	B6057	1	VINYL COVER
3	B8123	1	OIL
4	B18034	6	BOBBIN
5	BN0122	3	NEEDLE DP × 17 #22
6	B10734	1	BOBBIN WINDER COMPLETE
7	B35254	1	SPOOL PIN COMPLETE
8	B19464	1	KNEE LIFTER COMPLETE
9	B19464-14	4	SCREW
10	B6054-A	1	ARM SHAFT (STANDARD MACHINE)
	B6054-B	1	ARM SHAFT (18 " MACHINE)
	B6054-C	1	ARM SHAFT (25 " MACHINE)
11	B6055	4	NAIL
12	B11866	2	BED HINGE RUBBER
13	B11885	2	BED HINGE CONNECTION
14	B6055	4	NAIL
15	B11887	4	RUBBER
16	B6055	4	NAIL
17	B19456	1	WRENCH 2.0 MM
18	B19457	1	WRENCH 2.5 MM
19	B19458	1	WRENCH 3.0 MM
20	B19459	1	WRENCH 4.0 MM
21	B19460	1	WRENCH 5.0 MM
22	B19466	1	SCREW DRIVER(LARGE)
23	B19467	1	SCREW DRIVER(MIDDLE)
24	B19468	1	SCREW DRIVER(SMALL)
25	B19462	1	DOUBLE HEAD WRENCH
26	B19461	1	SPANNER 6 × 7 MM
27	B8180	1	SCREW DRIVER(+)

PARTS AVAILABLE AT EXTRA CHARGE



PARTS AVAILABLE AT EXTRA CHARGE

NO.	PART NO.	Qty	PARTS NAME
1	B15098C	1	BELT GUARD SET
2	B15099	1	BELT GUARD UPPER COVER
3	B15098	1	BELT GUARD
4	B8100	2	SCREW 9/64 × 40 L=6.5
5	B12418	1	UPPER COVER SCREW 13/64 × 32 L=9.0
6	B8100	1	SCREW (LOWER) 9/64 × 40 L=6.5
7	B11142	1	WASHER
8	B17372	1	SYNCHRONIZER SUPPORT
9	B50409	2	SYNCHRONIZER SUPPORT NUT
10	B15121	1	AUXILIARY BELT GUARD (LARGE)
11	B15122	1	AUXILIARY BELT GUARD (SMALL)
12	B11830	1	SCREW 9/64 × 40 L=5.0
13	B16287	2	WASHER
14	B15081	2	SCREW
15	B10937	1	FINGER GUARD
16	B10677	1	WASHER
17	B18484	1	SCREW 9/64 × 40 L=11.0
18	B18469	1	ROCK SHAFT COVER
19	B37136	2	SCREW MS × 0.8 L=10
20	B18469-02	1	ROCK SHAFT COVER (LOWER)
21	B6333	2	SCREW 9/64 × 40 L=6.5

BACK COVER

406RB-1

**Chandler Machine USA,
LLC**

400 VETERANS BLVD, CARLSTADT NJ 07072

212-721-2474