

# BLINDSTITCH SEWING MACHINES





REX BLINDSTITCH MACHINE CORP. 278-15th AVENUE, NEWARK, N. J. 07103 Phone (201) 242-8484

Cable Address: REX-NEWARK, NEW JERSEY

05683M

STANDARD #10 Fine knit rayon SIZE #15 Fine knit wear NEEDLES

Fine knit jersey #20

Dresses and light fabrics #25

For sportswear #30

#35 For heavy, hard material and coats

For extra hard material #40

#1 - #11/2 Also available ----Needle size numbers: #2 - #21/2 - #3 -#31/2 - #4 - #41/2

VERY IMPORTANT

Use only genuine REX needles. Accept no others. **REX** needles cost no more than cheap imitations and are ALWAYS available.



If you have any difficulty, do not hesitate to contact dealer who sold you this machine. If unable to obtain satisfaction, 







have model numbers that end with "6" 618-6 SERIES - 618-6 618-C-6 618-K-6 618-N-6 618-NT-6 808 SERIES - 808 808-1 808-2 808-A 808-C 808-K 808-N 808-NT 808-F 818 Self-Oiler - See Pages 20 & 21

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## INFORMATION

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## **MOUNTING MACHINE**

Fasten machine to table using felt pad. Tighten screws evenly, turning each a little at a time.
 When an individual motor and clutch unit is employed, it is recommended that the motor be rated at 1/3 HP and 1725/1750 RPM. On all standard models, use a 31/2" outside diameter pulley. On models intended for alteration, use a 21/2" outside diameter pulley.

## CAUTION: BEFORE OPERATING MACHINE, LUBRICATE IN ACCORDANCE WITH INSTRUCTIONS. REFER TO OIL CHART.

- Place a few drops of oil at all points shown on the oiling chart All moving parts MUST be oiled.
- **b.** When the machine is mounted on a power table, a 4" pulley should be used. If possible, when using such stands, the machine should be mounted TO AVOID CROSS-ING THE BELT.
- **c.** The maximum machine speed recommended for any installation is 3000 RPM, unless otherwise specified.
- .2. The handwheel's direction of rotation is away from the operator. It rotates in a clockwise direction when looking at the face of the wheel pulley, as shown by the arrow.
- 3. Either V-belting or round leather belting may

2. In production use, the machine should be oiled twice daily

![](_page_2_Picture_16.jpeg)

be used. Excessive tension of belt will cause over-heating and freezing of bearing at handwheel.

![](_page_3_Picture_0.jpeg)

## **KNEE LIFTER ADJUSTMENT**

To adjust Knee Lifter (A), loosen Lift Arm Screws (B) and bring Knee Lifter into position most comfortable for operator. Tighten Screws (B) securely.

This adjustment may require readjusting tension spring.

To adjust tension of spring on Knee Lifter, loosen Collar Screws (C) and wind spring by placing side blade of screw driver in Collar slots (D). Wind tight enough until Knee Lifter (A) swings towards the operator, then tighten Collar Screws securely.

"S" Hook (E) must always have slack between Feed Frame and Lift Arm (F). To do this, first loosen Lock Nut (H) and turn Adjusting Screw (G) left or right until "S" Hook is FREE of Feed Frame and Lift Arm. Hold Screw in place and tighten Lock Nut (H).

![](_page_3_Picture_6.jpeg)

## THREADING CHART

- Use any type thread which is suitable for the fabric being sewn. This includes mercerized, 00, silk and synthetic threads.
- The thread is passed through rear thread guide (A) then slides between two tension discs (B) through (C) through front thread guide (D) . . . then down through needle clamp hole (E) . . . and entering from the underside of needle hole (F).

3. Leave thread about 2 to 3 inches past needle hole.

![](_page_3_Picture_11.jpeg)

#### THREADING NEEDLE

To thread needle at point (F)

a. Swing work plate out of way

b. Depress cylinder out of way with knee lifter

c. Hold thread between index finger and thumb

d. End of thread must be stub not feather edge.

## **ADJUSTING RIB TO NEEDLE**

### THE MACHINE SHOULD BE CHECKED TO INSURE CORRECT NEEDLE SETTING TO PREVENT DAMAGE TO NEEDLES.

Press knee lifter to depress feed frame.

- 2. Turn hand wheel CLOCKWISE until eye of needle is at slot in presser foot shoe (Fig. 1).
- 3. Slowly release knee lifter. The rib should JUST TOUCH THE NEEDLE (Fig. 2).
- 4. If rib is pressing up against needle (Fig. 3), turn dial toward "LESS" until rib just touches needle.
- 5. If rib is away from needle (Fig. 4), turn dial toward "MORE" until rib just touches needle.
- 6. When needle just touches rib (Fig. 2), machine is set to test.

![](_page_4_Picture_8.jpeg)

- 7. To test machine, when ratio is set 2 to 1 ratio-take single layer of material, place in machine and turn machine by hand. If machine catches once, then does not catch on next stroke, machine is ready to work.
- 8. Keep dialing "MORE" or "LESS" until above results are obtained on silk or any thin goods.
- 9. On heavy goods, it should catch on each stroke of needle.
- 10. You are now ready to thread machine. Refer to threading instructions.

![](_page_4_Picture_14.jpeg)

![](_page_4_Picture_15.jpeg)

## TO CHANGE STITCH RATIO, DEPRESS KNEE LIFTER AND MOVE LEVER TO DESIRED STITCH RATIO

## When set for

catches every other stitch catches every stitch

#### **IMPORTANT:**

Place a piece of thin sample material in machine. Set stitch ratio on 2-to-1. Turn hand wheel clockwise by hand so that needle catches on one stroke and skips a stitch on second stroke.

ON THE SKIP STROKE, stop when the eye of the needle is at

![](_page_4_Picture_22.jpeg)

the rib (Fig. 1). At this point, the gap between the Compensating Skip Stitch Screw (Fig. 5, A) and the Push Rod (B) should be .018 (C). (In the absence of a gauge, .018 is about 5 times the thickness of average letterhead paper.) This adjustment is made by loosening Lock Nut (F), adjusting screw (A) so gap at (C) is .018. Keep screw in place with screwdriver and secure Lock Nut.

Once this is done, a similar adjustment on Feed Frame Limit Safety Screw (E) should be made. Loosen Lock Nut (D), adjust Safety Screw (E) so that gap (G) between Screw (E) and Main Frame of machine is .018. Hold Screw in place with screwdriver and secure Lock Nut. THIS ADJUSTMENT IS TO PREVENT OPERATOR FROM MISTAKENLY ADJUSTING RIB TOO HIGH WITH "MORE/LESS" DIAL CAUSING NEEDLE TO STRIKE RIB AND BREAK.

## **TESTING NEEDLE**

**IMPORTANT:** First test needle to make sure there is no bur or it is not bent. To check for bur, rub fingernail across point. If needle is bent, it will not rest firmly on needle guide Fig. 6. (F)

## CHANGING NEEDLE

## TO REMOVE

- Loosen screw (A) about 2<sup>1</sup>/<sub>2</sub> turns until Needle Clamp (B) is loosened from Needle Lever (C) and Needle is free. (Fig. 1)
- 2. Hold Needle with left hand thumb and index finger, remove by moving away from you and

![](_page_5_Picture_6.jpeg)

to the left (Fig. 1). It should come out effortlessly. DO NOT FORCE.

## INSERTING NEW NEEDLE

- Place good new needle in groove of presserfoot and hold in place with right index finger (Fig. 2). With tilting motion of right thumb (Fig. 3), tilt shank of needle to right in between Needle Clamp (B) and Needle Lever (C) and into groove of Needle Lever.
- 2. With left index finger and thumb (Fig. 4), bring Needle Clamp and Lever together making sure Needle is setting in Needle Lever Groove. While holding together with left hand, draw needle up as high as possible with right hand. Then with right hand, tighten screw (A) with screw driver.
- 3. Hold Needle at point (D) (Fig. 5) with left thumb and index finger, loosen screw (A) a quarter turn, then push Needle all the way up the Needle Lever (DO NOT FORCE) and secure screw (A) firmly.
- **4.** EYE of Needle should be at point (E) (Fig. 6) when Needle Lever (C) is at its highest point.

![](_page_5_Figure_13.jpeg)

## HOW TO SEW

- . Turn hand wheel slowly clockwise until needle reaches high point (A).
- 2. With hands 12 inches or so apart (Fig. 1) hold hem firmly. Depress knee lifter, place hem in machine parallel with, and up under presser foot. (D)
- 3. Place edge of hem in slot of shoe (B) and at edge of gauge (C).
- 4. Start sewing. IMPORTANT: Keep edge of hem lightly, but firmly against gauge, keep material parallel to gauge by KEEPING EYES ON GAUGE ONLY ... NOT ON NEEDLE OR SEWING.

![](_page_6_Picture_5.jpeg)

5. To remove . . . make sure needle is again at high point. Depress knee lifter and pull work AWAY FROM YOU, straight back to break thread.

#### IMPORTANT-DO NOT TUG MATERIAL BACK AND FORTH OR IT WILL UNRAVEL THE STITCH.

## **START SEWING**

- 1. On thin goods or ribbon cloth guide Fig. 1.(C). should be set almost at extreme right side of machine and should obtain results shown in Fig. 2. (F).
- 2. For heavier goods, bring cloth guide to the left as necessary.
- 3. Do not pull material to help feeding, do not hold material back, just hold firm but lightly.

4. To remove finished work, MAKE SURE NEEDLE IS AT HIGH POINT FREE OF GARMENT.

## TENSION

If material puckers, loosen tension.

If thread is loose, make sure thread is between tension, discs then tighten accordingly. Do not hesitate to turn tension nut several times as needed.

On thin goods, a light tension is required. On heavier goods, a tighter tension is necessary.

IMPORTANT: Unlike a regular machine, this machine requires very little tension.

![](_page_6_Figure_20.jpeg)

![](_page_6_Picture_21.jpeg)

![](_page_6_Picture_22.jpeg)

## **UNRAVELING STITCH**

To unravel the stitching, turn hand wheel CLOCK-WISE to high point of needle. Continue clockwise until thread is off looper. Then COUNTERCLOCK-WISE to threading position.

Depress knee lifter and remove garment . . . thread will unravel.

To unravel stitch on finished garment, start where stitching finished, break straight thread and unravel backwards, NOT FROM DIRECTION OF SEWING.

If catching each time on light fabric, turn dial to "LESS" until it looks like J.

![](_page_6_Picture_28.jpeg)

Catches on thin fabric every other time. (Provided needle is good.)

## PROPER SETTING FOR RIB CONNECTION

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Turn Handwheel clockwise until Needle is on the DOWN stroke. When Needle reaches right hand edge of Needle Guide "A" (Fig. 1), Rib "B" should STOP and SHOULD NOT MOVE UNTIL NEEDLE POINT PASSES OVER RIB TO OTHER SIDE OF PRESSERFOOT OPENING "C".

If Rib does move, make the following adjustment: First loosen Screw "A" (Fig. 2). Bring Needle Point back to right hand edge of Needle Guide. Then loosen screw "B", keeping screwdriver in place. Move Cam (R-1062) forward or backward until Rib is at the STOP position, holding Needle in Position with handwheel while performing this operation. Tighten Screw "B". Test accuracy of adjustment by repeating operation outlined in first paragraph. If still not correct, readjust by loosening screw "B" again, change angle of Cam slightly forward or backward as needed and retighten Screw "B". When adjusted satisfactorily, be sure to TIGHTEN BOTH SCREWS "A" & "B" before putting machine into operation.

## TO SET RIB SHAFT

When needle is in same position as in Fig. 1, loosen Screw (R-1117) in Fig. 3, and turn Rib to desired position. Secure Screw. (See page 9 for closer detail of Rib Shaft if needed.)

## NEEDLE STROKE

Turn Handwheel clockwise, bringing Needle to end of stroke at the right side. At this point, the Needle tip should be 5/8" to 11/16" from the right side of Presserfoot opening (Fig. 4). To attain this, loosen Eccentric Ball Screw R-1118 (Fig. 5) and turn Eccentric Ball (R-1086) until Needle reaches desired position.

## **REGULATING LENGTH OF STITCH**

Loosen Screw R-1072 (Fig. 5) in Stitch Regulating Collar and turn until desired number is by Indicator Notch in R-1014. The larger the number by the notch, the longer the stitch. The

smaller the number by the notch, the shorter the stitch. WHEN MAKING STITCH LONGER OR SHORTER, CHECK FEEDER WITH LOOPER AND PRESSERFOOT AS IT CHANGES POSITION OF FEEDER WHEN CHANGING LENGTH OF STITCH

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![](_page_8_Figure_0.jpeg)

![](_page_8_Picture_1.jpeg)

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## ADJUSTING LOOPER

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- 1. (FIG. 1) Loosen screw (A) to take out Looper (B) (Part #R-2200).
- 2. To put Looper in, be sure you put Looper in until shoulder of Looper touches shoulder of Looper Rod (C) at point (D).
- 3. (FIG. 2) Turn Handwheel by hand, carefully and slowly. Looper must clear the Chain-Off Pin (E) and clear needle, being just above the needle about the thickness of a sheet of paper at point (G). The long prong of the Looper should be about 3/32''from the needle when needle is at the limit of stroke.
- 4. Should Looper touch needle or Presser Foot at point (G), loosen screws (H) and use wide blade of screwdriver in slot of Eccentric Block at (J). If Looper is hitting needle, turn Eccentric Block clockwise. If Looper is too far obove needle, turn Eccentric Block counterclockwise.
- 5. (FIG. 3) If Looper touches Presser Foot or needle at point (K) and upper part (long prong) of Looper at point (L), turn Eccentric Block clockwise.
- 6. (FIG. 3 & FIG. 1) Should Looper be touching at point (K) and needle touching short prong of Looper at point (L), then you must loosen nut (M) and screws (N). Then turn Lcoper Rod at point (C) downwards, which will clear the short prong of your Looper at point (L) and raise the Looper at point (K).
- 7. (FIG. 2 & FIG. 3) By turning Eccentric Block (J) clockwise or counterclockwise, it will raise or lower your Locper at points (K) and (L).

With ECCENTRIC BLOCK, you RAISE or LOWER Looper on BOTH SIDES.

TURNING LOOPER ROD, you RAISE one side and you LOWER the other side.

- 8. (FIG. 3 & FIG. 2) For Looper To clear Chain-Off Pin (Q) and Presser Foot at (R), Eccentric Block (J) can be moved from left to right by loosening screws (H). This will give you the desired clearance.
- 9. (FIG. 1 & FIG. 2) If this is necessary, be sure that Looper Rod Carrier Pin (S) is flush against Looper Rod Carrier (T) and does not have any play left or right. Secure by re-tightening screws (H).
- 10. (FIG. 4) When Needle Guide (U) (part #R-1238) becomes grooved or broken, remove and put in a new one. NOTE: When replacing Needle Guide, slide "U" of Needle Guide into undercut neck of screw (V). Hold together and screw on Presser Fcot. Just before tightening firmly, push Needle Guide securely towards screw, hold in position and tighten Needle Guide Screw (V).

11. (FIG. 5) Feeder should be below Presser Foot a maximum of 3/32" at point (W) and a hair less at point (X).

#### (FIG. 4) BE SURE LOOPER CLEARS FEEDER AT POINT (Y).

#### BE DOUBLY SURE FEEDER SCREWS (Z) ARE SECURED FIRMLY.

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![](_page_10_Picture_0.jpeg)

IF RIB ON YOUR MACHINE IS CUSTOMIZED AND STAMPED WITH A NUMBER OTHER THAN NUMBER INDICATED WITH MODEL BELOW, RE-ORDER USING NUMBER STAMPED ON THE RIB SUPPLIED WITH YOUR SPECIFIC MACHINE.

### RIB FOR VARIOUS MODELS AS INDICATED (Specify no notch, fine notch or deep notch)

Model	Rib	Model	Rib	Model	Rib
618 618-2	Fine Notch	618-1 618-9	Fine Notch R-6008	618-NT { 808-NT {	R-6040
618-A 618-C 618-N 808	R-6008 No Notch R-6007	808-9 808-9 808-9SP	Deep Notch R-6001	618-6 618-N6 }	R-6036
808-A 808-C		618-K )	D 6004	618-C6 618-K6	R-6010 R-6032

808-K

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![](_page_11_Picture_4.jpeg)

R-6004

618-NT6 R-6041

### FEED FRAME (618 and 808)

GROUP 1

- R-1205 Window Plate
- R-1030 Screw Window Plate
- R-1087 Rib Shaft Bushing Left
- Rib Shaft Bushing Right R-1088
- R-1069 Set Screw Platten Bracket Pivot Stud
- R-1159 Screw Spring Link Lock
- R-1104 Screw Feed Frame Limit
- R-1146 Nut Feed Frame Limit Screw Lock

#### GROUP 2

- Nut Skip Stitch Compensating R-1029
- R-1105 Screw Skip Stitch Compensating
- R-1202 Skip Regulating
- R-1028 Spring Washer Skip Regulating Lever Stud
- R-1203 Stud Skip Regulating Lever
- R-1332 Screw Skip Regulating Lever Stud-Lock

#### GROUP 3

- **RIB** See Chart Top of Page
- R-1163 Crank Rib Shaft
- R-1117 Screw Rib Shaft Crank Clamp
- R-1164 Stud Rib Shaft Crank
- R-1161 Rib Shaft Collar Left
- R-1076 Screw Rib Shaft Collar-Clamp
- R-1162 Rib Shaft Collar Right
- R-1076 Screw Rib Shaft Collar-Clamp

#### **GROUP** 4

### 618 and 808 Series Only

- R-1166 Stud Platten Bracket Pivot R-2451 Platten Bracket - Left R-2450 Platten Bracket - Right
- R-2400 Platten Left

### IMPORTANT

### For Rex Semi-Self-Oiler Models — 818 Series

### Use same part numbers as with 618 models, but add prefix "L"

R-2401 Platten - Right R-1244 Screw - Platten to Bracket - Attaching R-1167 Nut - Platten to Bracket Attaching Screw R-1168 Nut - Platten Bracket Limit Screw-Lock R-1114 Screw - Platten Bracket Limit R-1171 Spring - Platten Bracket Spacer - Platten Bracket R-1021 **GROUP** 5 618 and 808 Series Only R-1211 Cylinder

Screw - Cylinder R-1101

![](_page_12_Figure_0.jpeg)

![](_page_12_Picture_1.jpeg)

## NARROW CYLINDER MACHINES

### 618-6 SERIES

R-1166 Stud - Platten Bracket Pivot R-2455 Platten Bracket - Left R-2456 Platten Bracket - Right R-2410 Platten - Left R-2409 Platten - Right R-1244 Screw Platten to Bracket R-1167 Nut - Platten to Bracket Screw Spring - Platten Bracket R-1172 Spacer - Platten Bracket R-1021 Spring Post R-1056 Stop Post R-1055

- R-1132 Screw Platten Bracket-Limit
- R-1262 Nut Platten Bracket Limit-Screw Lock
- R-1212 Cylinder
- R-1101 Screws Cylinder
- R-1069 Set Screw Platten Bracket Pivot Stud

## MAIN FRAME GROUP

![](_page_13_Picture_1.jpeg)

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![](_page_13_Picture_2.jpeg)

IMPORTANT

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For Rex Semi-Self-Oiler Models — 818 Series

### MAIN FRAME GROUP

#### **GROUP** 1

R-1066 Shaft - Feed Frame Rocker R-1093 Set Screw - Feed Frame Shaft R-1025 Pin - Regulating Fork-Pivot

RM-1088 Main Shaft Bushing - Right RM-1087 Main Shaft Bushing - Left R-1068R Belt Guard R-1120R Set Screw - Belt Guard

R-1081 Cover Plate R-1096 Screw - Cover Plate

R-1240 Eccentric Pin

### MAIN SHAFT GROUP

#### GROUP 1

R-1044	Main Shaft	
R-1129	Gear - Skip Stitch Drive	
R-1069	Screw - Skip Stitch Drive Gear	Set

#### GROUP 2

RT-5003 Group 2, Fitted & Lapped (618 & 808) RT-5022 Group 2, Fitted & Lapped (618-6 Series) **Rib Connection Lever** R-1015 R-1071 Screw - Rib Connecting Lever Clamp R-1062 **Rib** Connection.Eccentric R-1120 Screw - Rib Lever Eccentric

R-1094	Screw - Eccentric Pin Set
R-1289	Screw - Regulating Fork-Pivot Pin Set
GROUP 2	
R-5002	Tension Assembly, Complete
R-1084	Thread Guide
R-1082	Tension Post
R-1083	Tension Discs
R-1009	Cover
R-1085	Spring
R-1011	Ratchet
R-1010	Nut
R-1080	Front Thread Guide
R-1070	Screw - Front Thread Guide
GROUP 3	

#### GROUP 3

R-1043	Handwheel
R-1121	Screw - Handwheel Set (Cone Point)
R-1069	Screw - Handwheel Set

#### GROUP 4

RT-5004	Group 4, Fitted and Lapped
R-1014	Needle and Feed Eccentric
R-1331	Set Screw - (Cone Point) Feed Eccentric
R-1331A	Screw - (Flat) Eccentric Set-Lock
R-1013	Needle Shaft and Feed Connection
R-1086	Eccentric Ball Stud
R-1072	Screw - Needle Connection

#### **GROUP** 5

#### R-1134 Eccentric Ball Guard

![](_page_14_Figure_19.jpeg)

![](_page_14_Figure_20.jpeg)

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![](_page_14_Figure_21.jpeg)

![](_page_15_Figure_0.jpeg)

# FRONT PLATE GROUP AND SUPPORT BRACKETS (Except Models 618-9 and 808-F)

#### **GROUP** 1

R-5180 Complete Plate and Bracket Assembly (618 and 808)
R-5180-6 Complete Plate and Bracket Assembly (618-6 Series)
R-1200 Swing Plate (618 and 808)
R-1200-6 Swing Plate (618-6 Series)
R-1360 Swing Plate For Infants Wear
R-5015 Support Shaft Assembly

- R-1051 Screw Pivot Pin-Lock
- R-1228 Bracket Swing Plate-Support
- R-1052 Screw Stop Plate
- R-1053 Washer Stop Plate Screw
- R-1227 Stop Plate
- R-1230 Washers (Flat) Swing Plate Support Bracket Screw
- R-1229 Washers (Lock) Swing Plate Support Bracket Screw
- R-1103 Screw Swing Plate Support Bracket
- R-1230 Washer (Flat) Swing Plate Support Bracket Screw
- R-1229 Washer (Lock) Swing Plate Support Bracket Screw
- R-1103 Screw Swing Plate Support Bracket
- R-1225 Pin Swing Plate Pivot
- R-1048 Retaining Ring Swing Plate Pivot Pin
- R-1226 Collar Swing Plate Pivot Pin
- R-1049 Set Screw Swing Plate Pivot Pin Collar
- R-1051 Screw Swing Plate Pivot Pin-Lock

### GROUP 2 Models 618-9 and 808-F

- R-51809 Complete Plate and Bracket Assembly (618-9 Models)
- R-1320 Stationary Plate (618-9 and 808-9)
- R-1321 Bracket Stationary Plate
- R-1326 Screw Stationary Plate to Bracket
- R-1054 Washer (Flat) Plate Screw
- R-1229 Washer (Lock) Plate Screw
- R-1341 Nut Plate Screw
- R-1230 Washer (Flat) Bracket Support
- R-1229 Washer (Lock) Bracket Support
- R-1103 Screw Bracket Support
- R-1317 Support Stationary Plate
- R-1318 Extension Support, Adjustable
- R-1037 Screw Extension Support, Lock
- R-1327 Screw Plate to Support

SPECIAL GUIDE AND GAUGE WHERE NECESSARY FOR MATERIAL PRESSERFOOT GROUP THAT IS HARD TO KEEP UNCURLED, SUCH AS NYLON TRICOT. R-1107 GROUP GROUP R-1122 R-1099 R-1238 **R-2600NT** FOR 618NT - 618NT - 808NT R-1241 COMPLETE R-5028 M. CLOTH GUIDE ASSEMBLY

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![](_page_17_Figure_1.jpeg)

NOTE: When ordering, specify part number and model of machine and serial number.

		618-1 618-9SP			•	MODELS			
DESCRIPTION AND PART NUMBER	618 618-6 808	808-1 808-9 808-9SP	618-2 808-2	618-A 808-A	618-C 808-C	618-K 618-K6 808-K	618-N 618-N6 808-N	618-NT 618-NT6 808-NT	618-9 808-9
Complete Presserfoot Assy.	R-6101	R-6100	R-6100	R-6100	R-6100	R-6100	R-6102	R-6105NT	R-6100
Presserfoot	R-2301	R-2300	R-2300	R-2300	R-2300	R-2300	R-2302	R-2305NT	R-2300
Washer - Presserfoot	R-1054	R-1054	R-1054	R-1054	R-1054	R-1054	R-1054	R-1054	R-1054
Screw - Presserfoot	R-1108	R-1108	R-1108	R-1108	R-1108	R-1108	R-1108	R-1108	R-1108
Shoe	R-2503	R-2500	R-2501	R-2502	R-2501	R-2500	R-2504	R-2500NT	R-2500
Pin - Eccentric	E-1235	E-1235	E-1235	E-1235	E-1235	E-1235	E-1235	E-1235	E-1235
Screw - Eccentric Pin	R-1641	R-1641	R-1641	R-1641	R-1641	R-1641	R-1641	R-1641	R-1641
Needle Guide	R-1238	R-1238	R-1238	R-1238	R-1238	R-1238	R-1238	R-1238	R-1266
Screw - Needle Guide	R-1122	R-1122	R-1122	R-1122	R-1122	R-1122	R-1122	R-1122	R-1122
Cloth Guide	R-2600	R-2600	R-2601	R-2601	R-2600	R-2600	R-2600	R-2600NT	R-2600
Nut - Cloth Guide	R-1283	R-1283	R-1283	R-1283	R-1283	R-1283,	R-1283	R-1283	R-1283
Guide Bracket	R-5028	R-5028	R-5028	R-5028	R-5028	R-5028	R=5028	R-5028	R-5028
Screw - Bracket	R-1099	R-1099	R-1099	R-1099	R-1099	R-1099	R-1099	R-1099	R-1099
Shoe Post	R-1233	R-1233	R-1233	R-1233	R-1233	R-1233	R-1233	R-1233	R-1233
Screw - Shoe Post	R-1106	R-1106	R-1106	R-1106	R-1106	R-1106	R-1106	R-1106	R-1106
Chain-off Pin	R-1650	R-1650	R-1650	R-1650	R-1650	R-1650	R-1650	R-1650	R-1650
Screw - Chain-off Pin	R-1640	R-1640	R-1640	R-1640	R-1640	R-1640	R-1640	R-1640	R-1640
Presserfoot Bridge	R-1241	R-1241	R-1241	R-1241	R-1241	R-1241	R-1241	R-1241	R-1241
Screw - Bridge	R-1107	R-1107	R-1107	R-1107	R-1107	R-1107	R-1107	R-1107	R-1107

![](_page_18_Figure_0.jpeg)

#### **GROUP 1**

- RT-5006 Looper Rod Fork and Sleeve Assembly
- R-1154 Looper Rod Fork
- R-1155A Looper Rod Sleeve
- R-1155 Pin Fork and Sleeve
- R-1094 Set Screw Fork and Sleeve Pin
- R-1123 Stud Looper Rod Sleeve
- R-1145 Collar Sleeve Stud

#### **GROUP 2**

- RT-5008 Looper Rod and Carrier Complete (618 & 808)
- RT-5053 Looper Rod and Carrier Complete (618-6)
- R-5017 Looper Rod Carrier
- R-1148 Looper Rod Ball
- R-1098 Set Screw Looper Rod Ball
- R-1147 Looper Rod
- R-1151 Nut Looper Rod-Lock
  R-1156 Screw Looper Clamp
  R-1072 Screw Looper Rod Carrier-Clamp

R-1076	Screw - Stud Collar
R-1077	Screw - Looper Rod Fork-Clamp

#### GROUP 3

R-1149 Stud - Looper Rod Carrier R-1150 Eccentric Block

![](_page_18_Figure_20.jpeg)

![](_page_18_Picture_21.jpeg)

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### NEEDLE DRIVE GROUP

- R-5021 Needle Lever
  R-1097 Screw Needle Lever Clamp
  R-1137 Needle Clamp
  R-1076 Screw Needle Clamp
- R-1095 Needle Shaft R-1118 Screw - Eccentric Ball Clamp
- R-1135 Collar Needle Shaft R-1094 Set Screw - Needle Shaft Collar

![](_page_19_Figure_0.jpeg)

#### **GROUP** 1

- R-1183 Support Arm Cam Roller 618 and 618-6 Series
- R-1345 Support Arm Cam Roller 808 Series
- R-1185 Regulating Fork
- R-1025 Pin Regulating Fork-Pivot

#### **GROUP 3**

- R-5018 Regulating Dial Assembly
- R-1223 Regulating Dial Shoe
- R-1222 Regulating Dial Screw
- R-5010 Face Plate and Guide Pin Assembly

- R-1026 Pin Roller Support Arm-Pivot
- R-1094 Screw Roller Support Arm Pivot Pin-Set
- R-1180 Cam Roller
- R-1179 Pin Cam Roller Support
- R-1069 Screw Cam Roller Support Pin-Set

#### GROUP 2

18

- R-5013 Skip Eccentric Gear Assembly (618 Series)
- R-5070 Skip Eccentric Gear Assembly (808 Series)
- R-1201 Pin Skip Eccentric Gear
- R-1069 Screw Skip Eccentric Gear

- R-1109 Screw Regulating Dial Assembly
- R-5039 Dial and Ratchet Assembly
- R-1039 Screw Dial and Ratchet Assembly-Lock

#### GROUP 4

- R-5011 Push Rod Assembly
- R-1193 Push Rod (1/4")
- R-1022 Cotter Pin
- R-1181 Spring Push Rod (1/4")

#### **GROUP** 5

- R-5012 Push Rod Assembly
- R-1195 Push Rod (兆")
- R-1023 Cotter Pin
- R-1024 Spring Push Rod (3/8")

P-5016 (618 £ 808)	FITTED & LAPPED RT-5112 (618-6)		
( R-5023 (618-6)	FITTED & LAPPED RT-5111 (618-808)		
	R-1072	FEED	DRIVE GROUP
		R-1138	Feed Lever

![](_page_19_Figure_35.jpeg)

Feed Lever For 618-6 Series R-1254 Stitch Regulating Collar R-1091 Stitch Regulating Collar For 618-K and 618-K6 R-1092 Screw-Stitch Regulating Collar-Clamp R-1072 R-5016 Rocker Pin Assembly Rocker Pin Assembly For 618-6 Series R-5023 Collar - Rocker Pin R-1145 Screw - Rocker Pin Collar - Clamp R-1076 R-2100 Feed Dog Feed Dog Fine, 20 Teeth to Inch. R-2101 Screw - Feed Dog R-1119 (1091 & 1138) Fitted and Lapped (618 & 808) RT-59138 (1092 & 1254) Fitted and Lapped (618-6) RT-59254

#### **GROUP** 1

- R-1060R Knee Lifter Rod Shaft
- R-5060 Lift Arm
- R-1120 Screw - Lift Arm Clamp
- Nut Lift Arm Adjusting Screw-Lock R-1008
- Screw Lift Arm Adjustment R-1035
- Spring Knee Lifter Rod-Return R-1061
- R-1059 Collar Knee Lifter Rod
- R-1036 Set Screw Knee Lifter Rod Collar
- R-1334 Feed Frame "S" Hook
- R-1060C Knee Lifter Rod Sleeve
- R-1060D Knee Lifter Rod Sleeve Screws

![](_page_20_Figure_12.jpeg)

GROUP 2

![](_page_20_Figure_14.jpeg)

![](_page_21_Figure_0.jpeg)

![](_page_21_Figure_1.jpeg)

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# IMPORTANT – For Rex Self-Oiler Models – 818 SERIES

Use same part numbers as with 618 models, but add prefix "L".

Example: Needleshaft (618 models) Part No. R-1095 Needleshaft (818 models) Part No. LR-1095

## PARTS LISTED BELOW ARE USED EXCLUSIVELY ON REX SELF-OILERS (818 MODELS).

L-814 Wire Loop Holder - Wick L-815

L-800 Felt Pad - Base

L-801	Base - Machine
L-802	Nipple - Base
L-803	Holder - Oil Bottle
L-804	Screws - Holder
L-805	Spring Clamp - Bottle Holder
L-806	Oil Bottle
L-807	Cover - Main Frame
L-808	Gasket - Cover
L-809	Screws - Cover
L-810	Oil Vibrator
L-810A	Spring - Oil Vibrator
L-810B	Screw - Oil Vibrator
L-811	Screws - Splasher
L-812	Wire Loop Holder - Wick L-813
L-813	Wick - Bushing

L-815	Wick - Rib Connection Lever
L-816	Wire Loop Holder - Wick L-817
L-817	Wick - Skip Eccentric Gear
L-818	Wire Loop Holder - Wick L-819
L-819	Wick - Skip Stitch Gear Drive
L-820	Wire Holder - Wicks
L-821	Screws - Wire Loop Holders
L-822	Nipple - Wick L-824
L-824	Wick - Main Shaft
L-825	Wire Loop Holder - Wick L-826
L-826	Wick - Looper Rod Carrier
L-827	Glass - Oil Gauge
L-828	Wire Loop Holder - Wick 829
L-829	Wick - Drain From Side Cover To Base

![](_page_22_Figure_8.jpeg)

![](_page_23_Picture_0.jpeg)

# for 2 to 1 and 1 to 1 stitch

TO SWITCH THE STITCH

## REX MODEL 818 --- SEMI-AUTOMATIC OILER REX MODEL 618 ---- NON SELF-OILER (Stitch Ratio 2-to-1 and 1-to-1) (Stitch Ratio 1-to-1)

![](_page_23_Picture_3.jpeg)

# HERE AT LAST ... A TRULY PORTABLE BLINDSTITCH MACHINE

 $2 \cdot 1 t_0$ 

## New, from REX, model 990.

Often claimed, but never accomplished until now! Lightweight, small, compact . . . easy to carry in sturdy case. Ideal for on-the-premise alterations of dresses and draperies. Use swing plate and cylinder for pants, cuffs and sleeve operations. Feather touch knee lifter ... rheostat speed control . . . quality workmanship. Fully contained, ready to travel. Smallest Blindstitch available to do a FULL SIZE job.

## WORLD-WIDE ACCEPTANCE -- MODELS FOR EVERY PURPOSE

NOW ALL REX 618 MODELS (Stitch Ratio 2-to-1 and 1-to-1) AVAILABLE IN 818 SERIES SEMI-AUTOMATIC OILERS

ALL REX 900 MODELS (Stitch Ratio 1-to-1) AVAILABLE IN 999 SERIES SEMI-AUTOMATIC OILERS

## REX BLINDSTITCH

## A REX MODEL TO SERVE EVERY NEED --- STANDARD OR CUSTOM BUILT

## DRESSES

- Model 618 618-6 618-1 618-N 618-NT
- Silk, cotton, all lightweights
- For small sleeve openings also hemming and felling
- All man-made fabrics and hard materials
  - Fine dress and negligees of fine silk voile and Nylon Tricot — small running stitch
  - Especially for Nylon Tricot, fine knitwear and rayons with special uncurling hemmer
- 618-NT-6 Same as 618-NT with small cylinder

## DRAPERIES

618-9

900-9

Model

900-LP

900-9-SP

Model

- For hemming droperies and curtains exclusively on fiberglass, chintz, synthetics and every type weight material
- 618-9-SP Same as 618-9 but with small swing plate
- 900-9-DP Double pulley for large scale production. Fiberglass, polished cottons, muslins, etc. Large work plate. 1-to-1 stitch ratio
  - Same as 900-9-DP but with only one pulley
  - Same as 900-9 but with small swing plate

## MEN'S CLOTHING

## SPORTSWEAR

#### Model 618-C

900-CS

Cottons, synthetics, light corduroys and woolens

- 618-C-6 Narrow cylinder for sleeve and leg openings
  - 1-to-1 stitch on light corduroy, cottons and synthetics

900-CS-6 Small cylinder for leg openings — plate optional

## PANTS

Model 900-PB 900-PB-6

Worsted and woolen trouser cuffs

- Small cylinder for narrow sleeve and trouser openings
- 900-PB-1 A retail store must --- expressly for cuffing bottoms of no cuff trousers . . . light, sheer and medium fabrics

- Padding heavy coats, collars and lapels, tacking pockets and turning-up coat bottoms. No plate or bracket
- 900-LP-1 All weight materials, synthetics, wash and wear man-made fibers
- 900-LP-2 Padding top coats and overcoats
- 900-T Tacking facings on jackets and coats
- 900-T-1 For top coats and overcoats
- 900-T-2 Same as 900-T but for synthetics and tropical sack coats, wash and wear

## ALTERATION DEPTS.

Model 618-2

618-A

900-PB-1

900-PB

For dresses, coat bottoms, skirts, trouser cuffs, draperies and reinforcing

23

Expressly for ladies wear specialty dress shops and department stores

900-PBW

900-WB

900-TW

For heavy material, lined and unlined corduroy pants and blue jeans

For felling waistbands

Fells buckram under the waistband

For fine pants and tropicals cuffless

For woolens and tuxedos

WORLD-WIDE ACCEPTANCE -- MODELS FOR EVERY PURPOSE FROM THE REX ALL-PURPOSE BLINDSTITCH FOR THE ALTERATION SHOP TO SPECIAL MODIFIED REX BLINDSTITCH MACHINES ... EACH DESIGNED TO DO A SPECIFIC JOB . . . ACCURATELY . . . ECONOMICALLY . . . QUICKLY.

![](_page_25_Picture_0.jpeg)

![](_page_25_Picture_1.jpeg)

3"
3 1/2 "
4."

## SWING HEMMER For **BLINDSTITCH** Machines (Clean Finish)

**R-1000** 

1 1/4 " 31/2" 1/4 " 1 1/2 " 1." 3/8 "

![](_page_25_Picture_7.jpeg)

![](_page_25_Picture_8.jpeg)

Adjustable to and from the Needle Point

![](_page_25_Picture_10.jpeg)

![](_page_25_Picture_11.jpeg)

## ADJUSTABLE SPLIT HEMMER For BLINDSTITCH Machines

Complete with any 5 size shells 1/2"; 1"; 11/4"; 11/2"; 2"; 21/2"; 3" SPECIFY SIZE OF SHELLS WHEN ORDERING

![](_page_25_Picture_14.jpeg)

![](_page_26_Picture_0.jpeg)

# Models — 818 Series Use same part numbers as with 618 models, but add prefix "L"

### ACCESSORY GROUP

#### DESCRIPTION

#### PART No.

25

Bolt — Machine Mounting	R4513	
Wing Nut — Machine Mounting Bolt Attaching		
Washer — Machine Mounting Bolt (13/8" O.D.)	R4505	
Washer — Machine Mounting Bolt (1" O.D.)	R4546	
Felt Pad — Machine Mounting	R4543	
Rubber Pad — Knee Lifter	R4544	

![](_page_26_Picture_6.jpeg)

![](_page_27_Picture_0.jpeg)