

SINGER®

INSTRUCTION MANUAL ILLUSTRATED PARTS LIST

FOR HIGH-SPEED FLAT-BED INTERLOCK SEWING MACHINE

**2754A 331
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308
309
311
313
341**

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IMPORTANT SAFETY INSTRUCTIONS

When using this machine, basic safety precautions should always be followed. Read all instruction before using the machine.

1. Whenever using the machine, understand the basic safety instructions which are not just limited to the following items.
2. Read all instructions and take care of the instruction book for your reference at any moment.
3. Before operating, confirm the relevant safety specifications and standards of this machine are fit for your country.
4. The machine should not be used without its relevant safety devices.
5. General operation must only be carried out by the appropriately trained person.
6. For your personal safety, it is recommended that suitable safety glasses should be worn when operating the machine
7. In the following situation, switch off the machine or unplug the machine from the electrical outlet.
 - 7.1 Threading the needle and replacing bobbin or looper.
 - 7.2 Replacing the needle, presser foot, throat plate, feed dog and sliding plate, etc..
 - 7.3 During service work.
 - 7.4 When the workplace is left unattended.
8. If lubricating oil comes into contact with the eyes or skin, they should immediately be washed with a generous amount of cold water.
If any lubricating oil is ingested, medical advice should be sought immediately.
9. Whether the machine is running or not, you never casually change or fiddle with the parts and the relevant device of the machine.
10. Repairs, conversion and special maintenance work must only be carried out by trained technicians.
11. Normal repairs and maintenance work must only be carried out by persons with special training.
12. Service work on the electrical equipment should always be carried out by qualified electricians or appropriately trained persons. Once an electric element is found to be damaged, the machine must be stopped immediately.
13. Clean the machine periodically.
14. Before commencing full operation of the machine, a trial run should be carried out to ensure that it is capable of performing the task required.
The machine should not be located next to a source of strong noise such as a high frequency welding machine, etc.
15. The machine should only be operated with the appropriate plug and cord with proper earthing.
16. Singer will not bear any responsibility for damage or injury caused by unauthorized modifications to the machine.
17. The machine should only be used for sewing the type of materials and in the manner indicated in the accompanying instructions for operation.

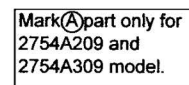
FOR SAFE OPERATION

1. To avoid electrical shock hazards, neither open the cover of the electrical box for the motor nor touch the components mounted inside the electrical box.
2. To avoid personal injury, never operate the machine with any of the belt cover, finger guard or safety devices removed.
3. To prevent possible personal injuries caused by being caught in the machine, keep your fingers, head and clothes away from the Handwheel, V belt and the motor while the machine is in operation. In addition, place nothing around them.
4. To avoid personal injury, never put your hand under the needle when you turn "ON" the power switch or operate the machine.
5. To avoid personal injury, never put your fingers into the thread take-up cover while the machine is in operation.
6. The hook rotates at a high speed while the machine is in operation. To prevent possible injury to hands, be sure to keep your hands away from the vicinity of the hook during operation. In addition, be sure to turn OFF the power to the machine when replacing the bobbin.
7. To avoid possible personal injuries, be careful not to allow your fingers in the machine when tilting/raising the machine head.
8. To avoid possible accidents because of abrupt start of the machine, turn OFF the power to the machine when tilting the machine head or removing the belt cover and the V belt.
9. If your machine is equipped with a servo-motor, the motor does not produce noise while the machine is at rest. To avoid possible accidents due to abrupt starting of the machine, be sure to turn OFF the power to the machine.
10. To avoid electrical shock hazards, never operate the sewing machine with the ground wire for the power supply removed.
11. To prevent possible accidents because of electric shock or damaged electrical component(s), turn OFF the power switch in prior to the connection/disconnection of the power plug.

High Speed Flat-bed Interlock sewing machine Specification

Model	Application	Singer Needle Cat.	needle	Thread	Needle guage (mm)	Stitch Lenth (mm)	differential Rate	Presser foot lift (mm)	Speed	Packing Size (mm)	NW/GW (Kg)	Device	
2754A331-0xxM	Be suitable for knitting material, and able to adorn two-sides.	Cat.3651-06 -75/11	2	4	4.0-4.8	4.4	0.5-1.3	6.3	6000	600*390*630	50/55	3 in 1 application device.(The device is included at the accessory) Plain seaming / Overlock seam covering / Bottom hemming.	
			3	5	5.6-6.4			5					
2754A303-0xxM	Be suitable for sewing rolled-edge of and T-shirt.	Cat.3651-06 -75/11	2	4	4.0-4.8	4.4	0.5-1.3	6.3	6000				Tape binder.
			3	5	5.6-6.4			5					
2754A313-0xxM	Be suitable for cover sewing rolled-edge of underwear and sports wear.	Cat.3651-06 -75/11	2	4	4.0-4.8	4.4	0.5-1.3	6.3	6000				Overlock seam covering.
			3	5	5.6-6.4			5					
2754A309-0xxM	Be suitable for sewing elastic lace of short pants and coractry and be equipped with an atomatic edge cutter. (Right-hand knife)	Cat.3651-06 -75/11	2	4	4.0-4.8	4.4	0.5-1.3	5.3	5000				Elastic tape and lace attachment with right-hand fabric trimmer.
			3	5	5.6-6.4			5					
2754A308-0xxM	Be suitable for sewing elastic lace of short pants and coractry.	Cat.3651-06 -75/11	2	4	4.0-4.8	4.4	0.5-1.3	6.3	5000				Elastic tape and lace attachment.
			3	5	5.6-6.4			5					
2754A311-0xxM	Be suitable for folding sewing skirt and cuff of T-shirt and underwear.	Cat.3651-06 -75/11	2	4	4.0-4.8	4.4	0.5-1.3	6.3	6000				Bottom hemming.
			3	5	5.6-6.4			5					
2754A300-0xxH	Be suitable for asirning of the heavy-duty material such as sweater, flannek clothes etc.	Cat.3651-06 -90/14	3	5	5.6-6.4	3.3	0.5-1.3	7	5000				Plain seaming for heavy material.
2754A341-0xxM	Be suitable for knitting material, and able to adorn two-sides.	Cat.3651-06 -75/11	2	4	4.0-4.8	4.4	0.5-1.3	6.3	6000				4 in 1 application device.(The device is included at the accessory) Plain seaming / Tape binder / Ovelock seam covering / Bottom hemming.
			3	5	5.6-6.4			5					

Cutting Diagram Of The Machine Table

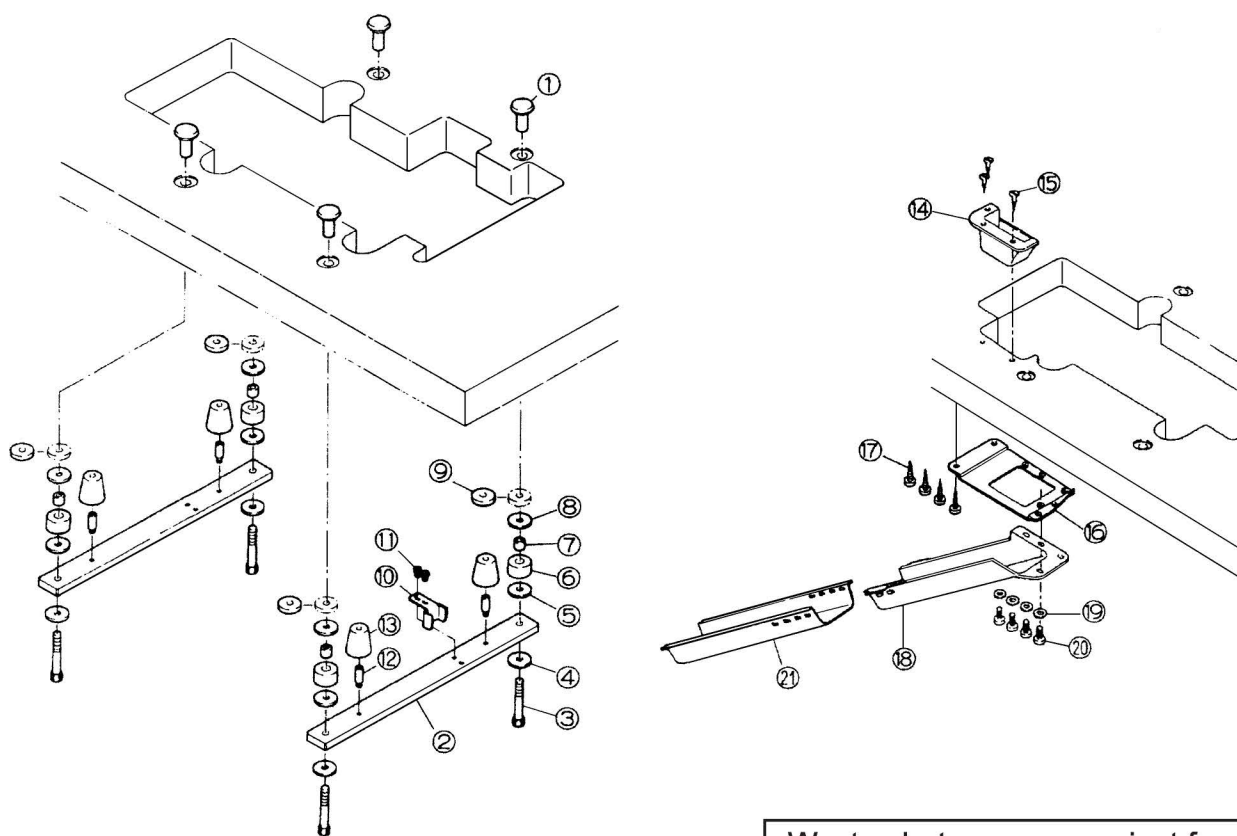


Assembling The Machine Supporting Components

Following are the procedure for assembling the machine rest board.

Assembling the machine rest board by following step 1~13 in the below illustration.

Select the washer⑨ based on the thick of the table.



Waste chute necessary just for
2754A309 model.

Following are the specifications for the motor and V-belt

1. Motor:

2-pole(2800rpm), 1/2HP(400 or 370W) clutch motor.

2. V-belt:

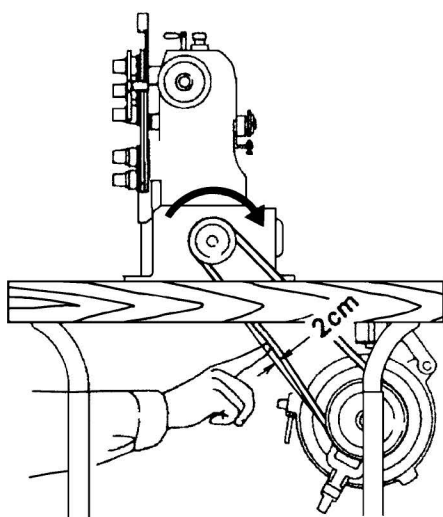
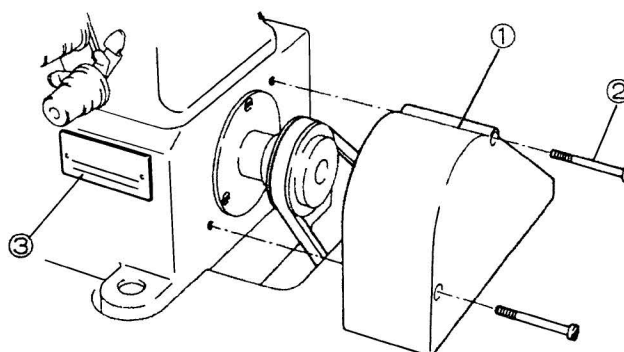
Type M

3. Motor pulley:

Select the proper motor pulley for the speed of machine to be used by referring to the table shown left.

Machine speed (r.p.m)	Motor pulley diameter(mm)	
	60Hz	50Hz
6,000	105	125
5,500	95	115
5,000	85	105
4,500	80	95
4,000	70	85

For safety reasons, make sure the Belt Guard ① is fixed on the machine ③ with supplied screws ②.



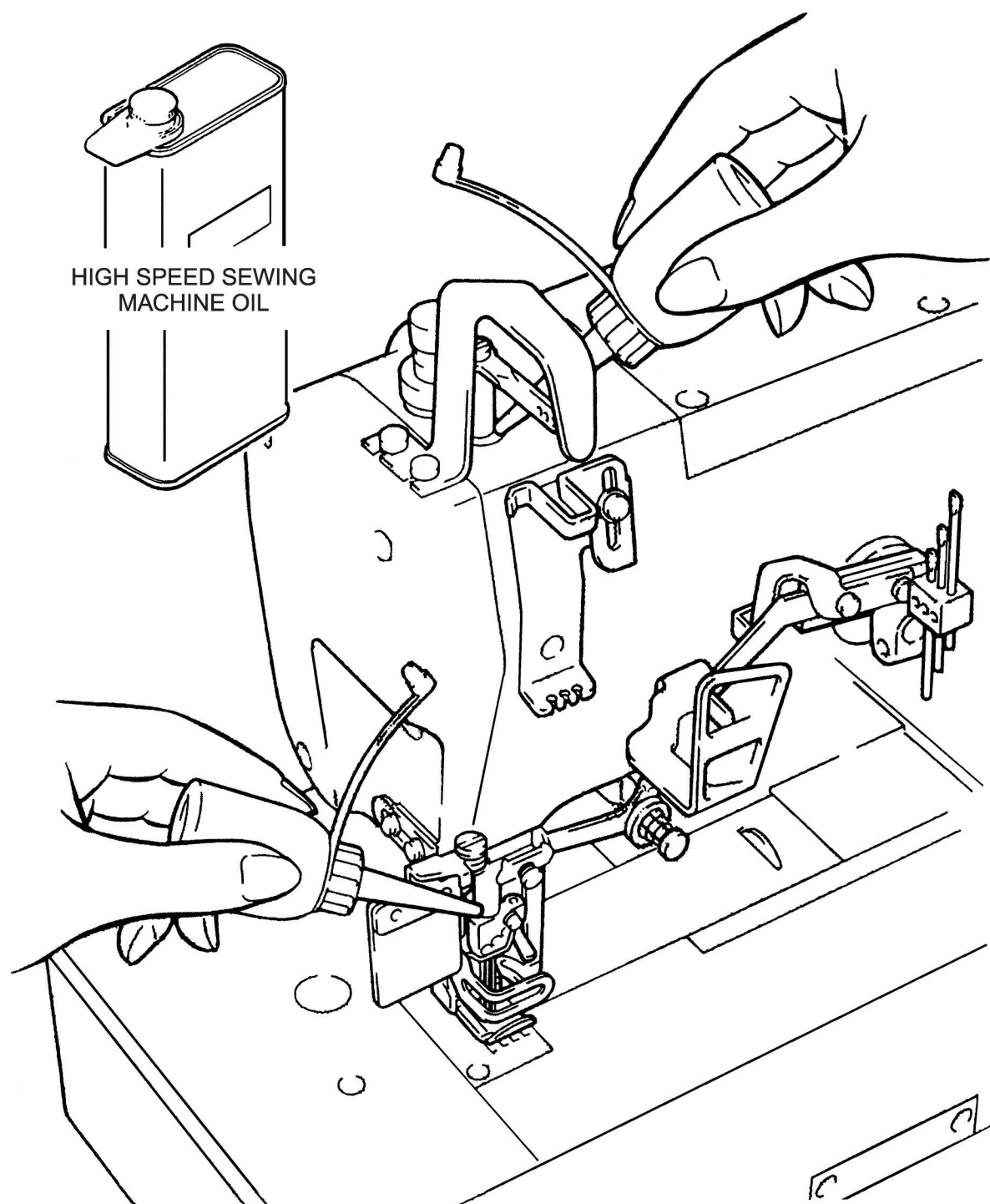
Adjust the tension of belt so that it can be 2 cm bent in ward when you press the middle of it.

Machine pulley must rotate clockwise (from right side view),as indicated in the figure.

BEFORE OPERATING

Manual lubrication

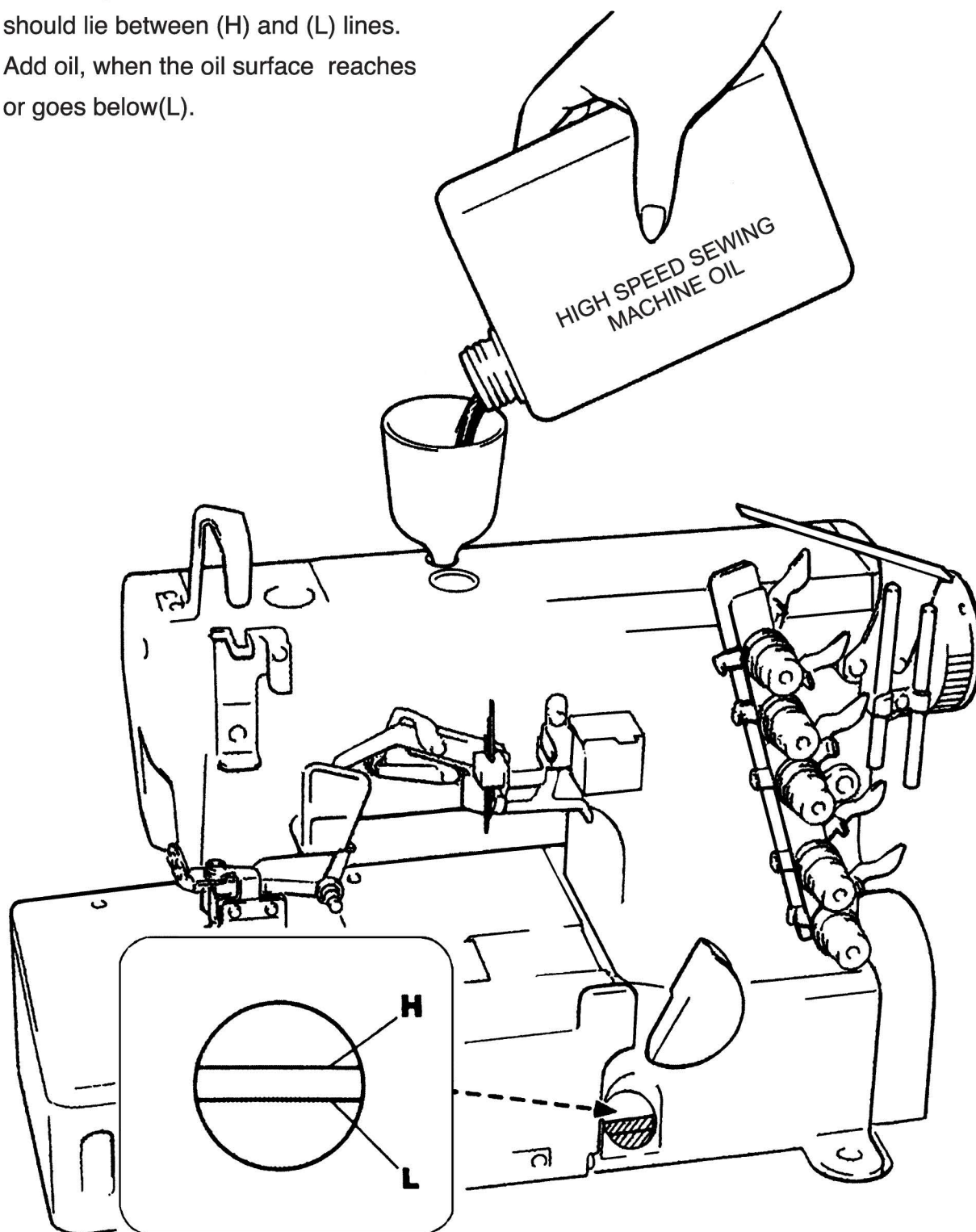
Apply 2 or 3 drops of oil by hand when the machine is used for the first time or has been left unused for some time.



BEFORE OPERATING

Lubrication

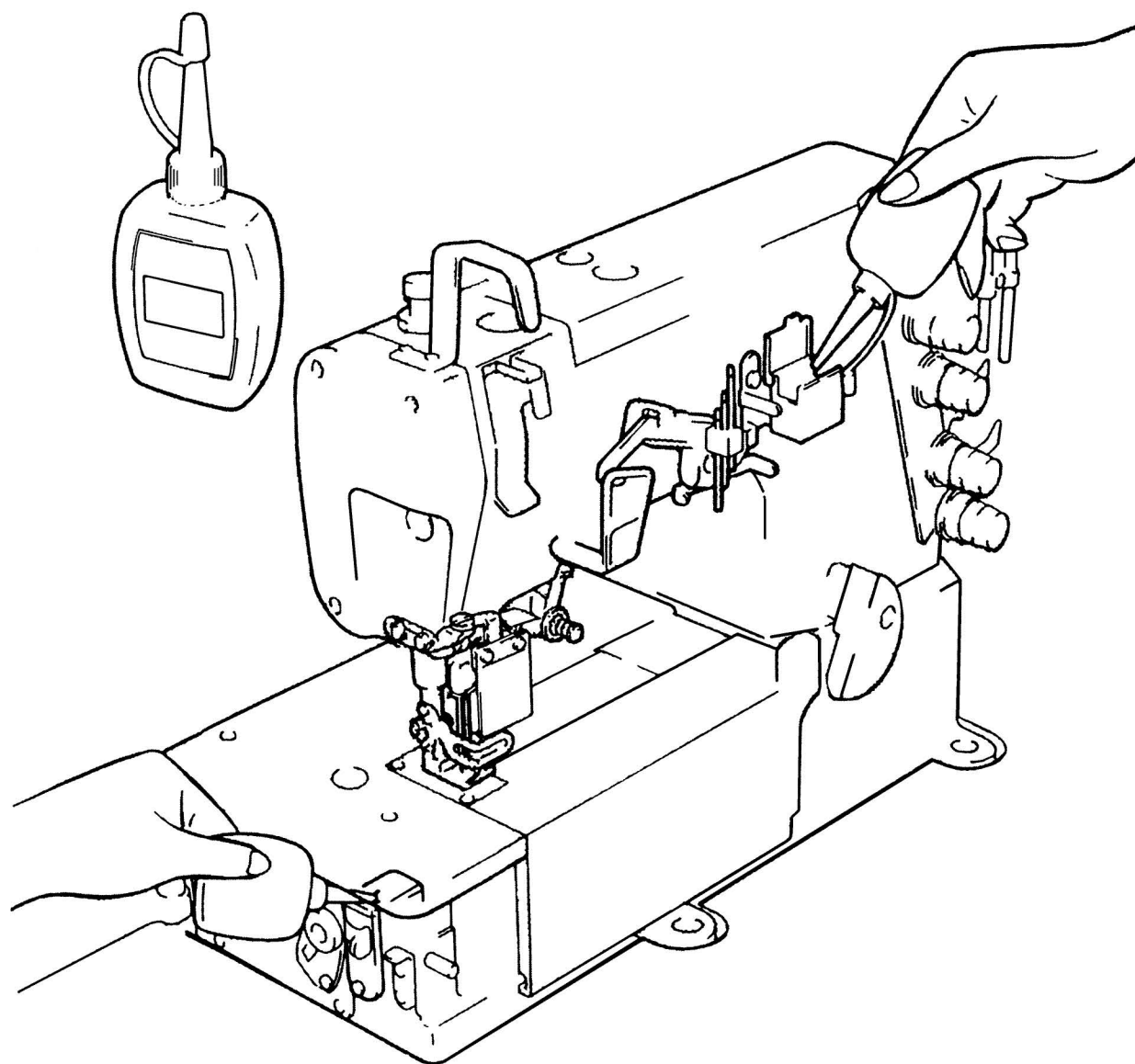
After filling the oil pan, the oil surface should lie between (H) and (L) lines. Add oil, when the oil surface reaches or goes below (L).



**BEFORE
OPERATING**

Filling the HR device with silicon oil

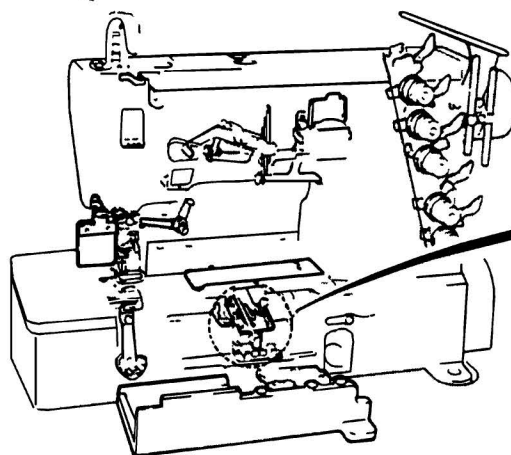
Fill the device with oil before it is too low in order to prevent needle thread breakage and fabric damage.



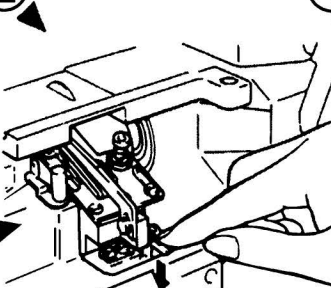
BEFORE OPERATING

Threading (1)

- ① Open the eye guard and three covers.

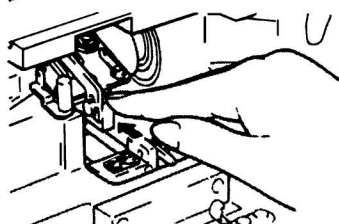


- ② Press down.



The looper thread take-up comes out.

- ④ Replace the looper thread take-up after threading.

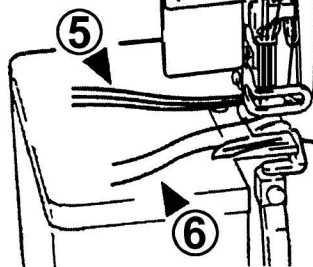


Knot the preset and the new thread together to thread the machine.

- ③

Needle thread

Trim the knots off neatly before passing through the eye of the needle to thread.

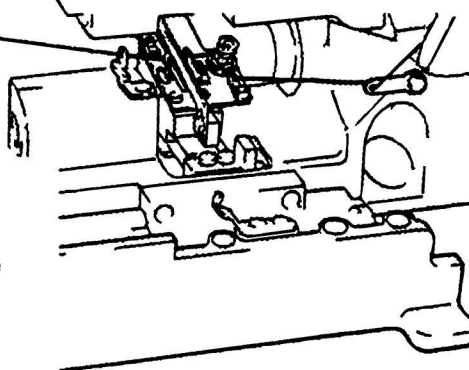


Be sure to thread the machine correctly by referring to the threading diagram. (See P. 5)

Looper thread and Top cover thread

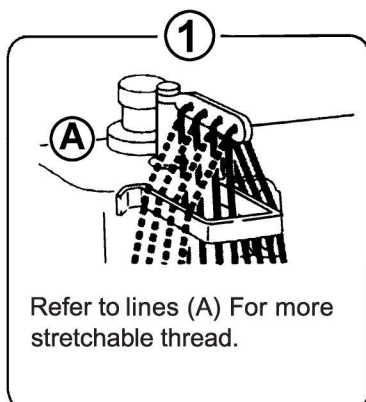
Trim the knots off neatly after passing through the eye of the looper

⑥

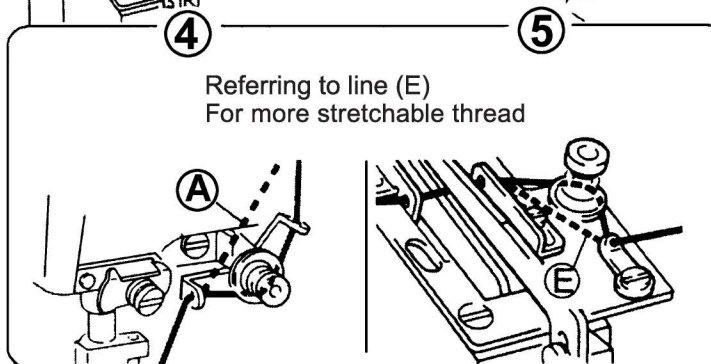
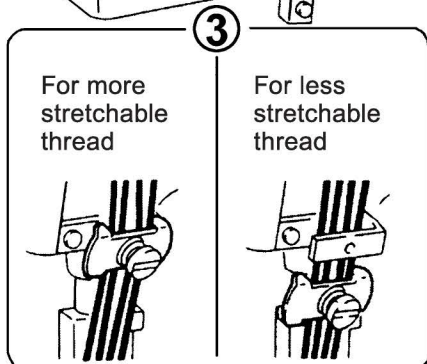
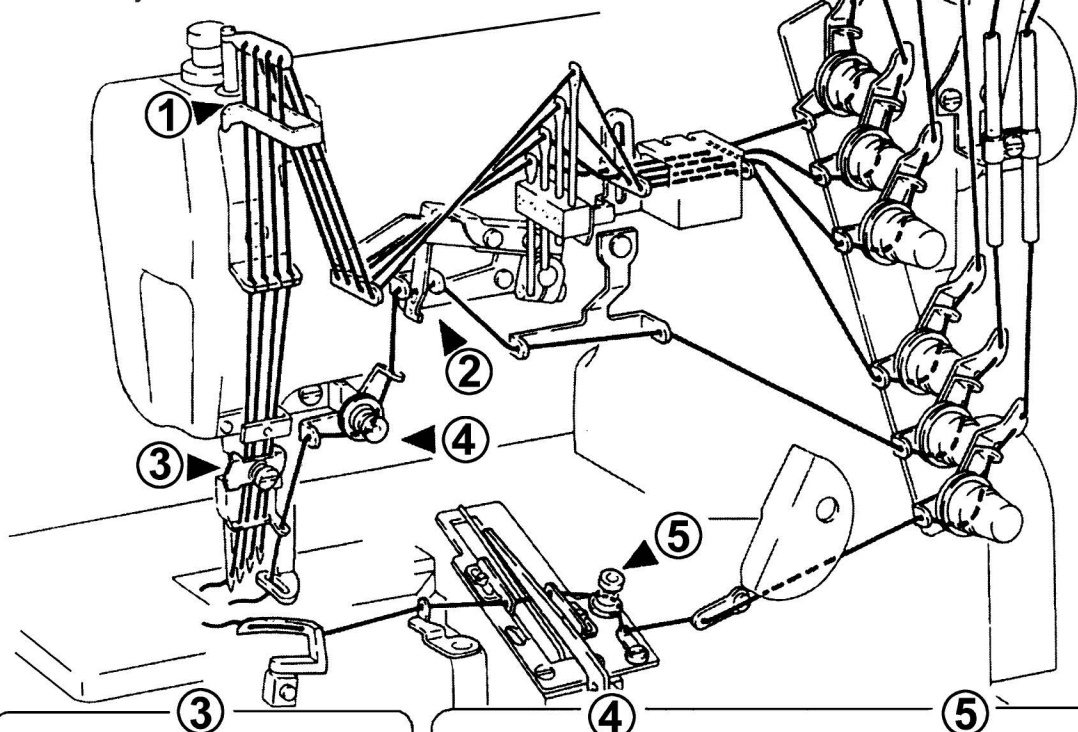
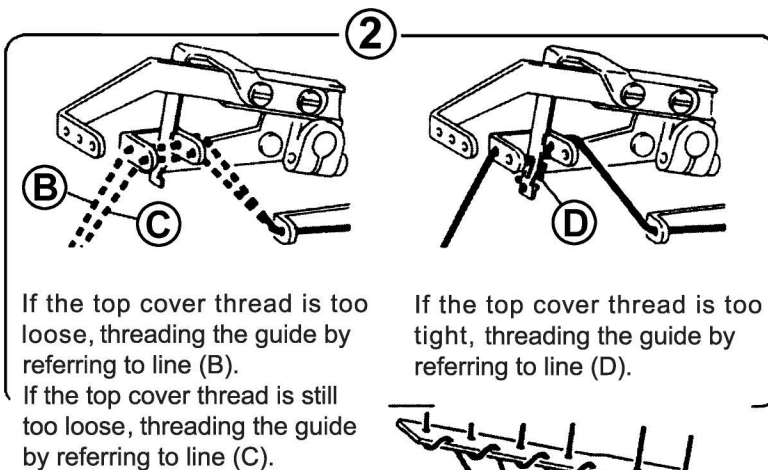


BEFORE OPERATING

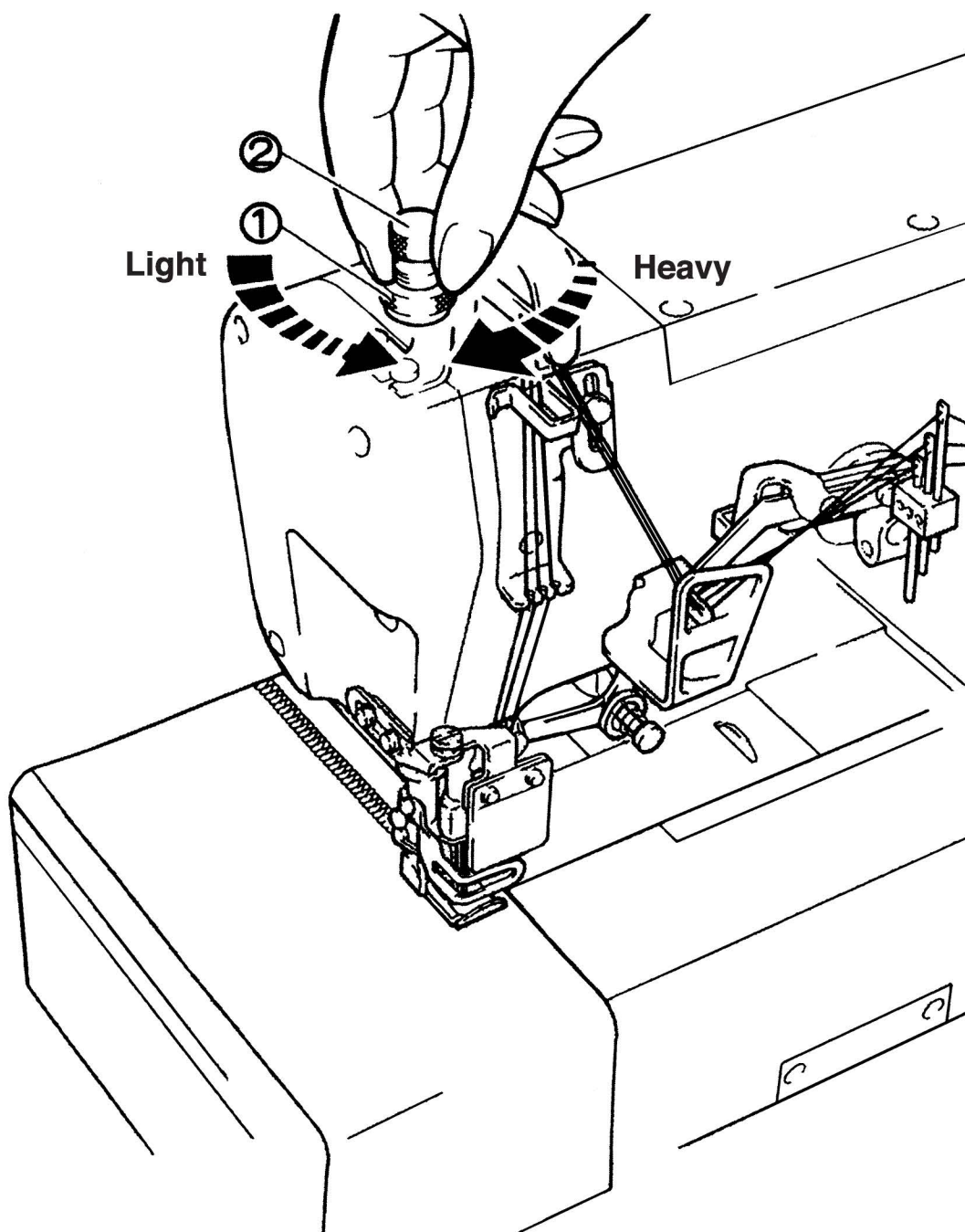
Threading (2)



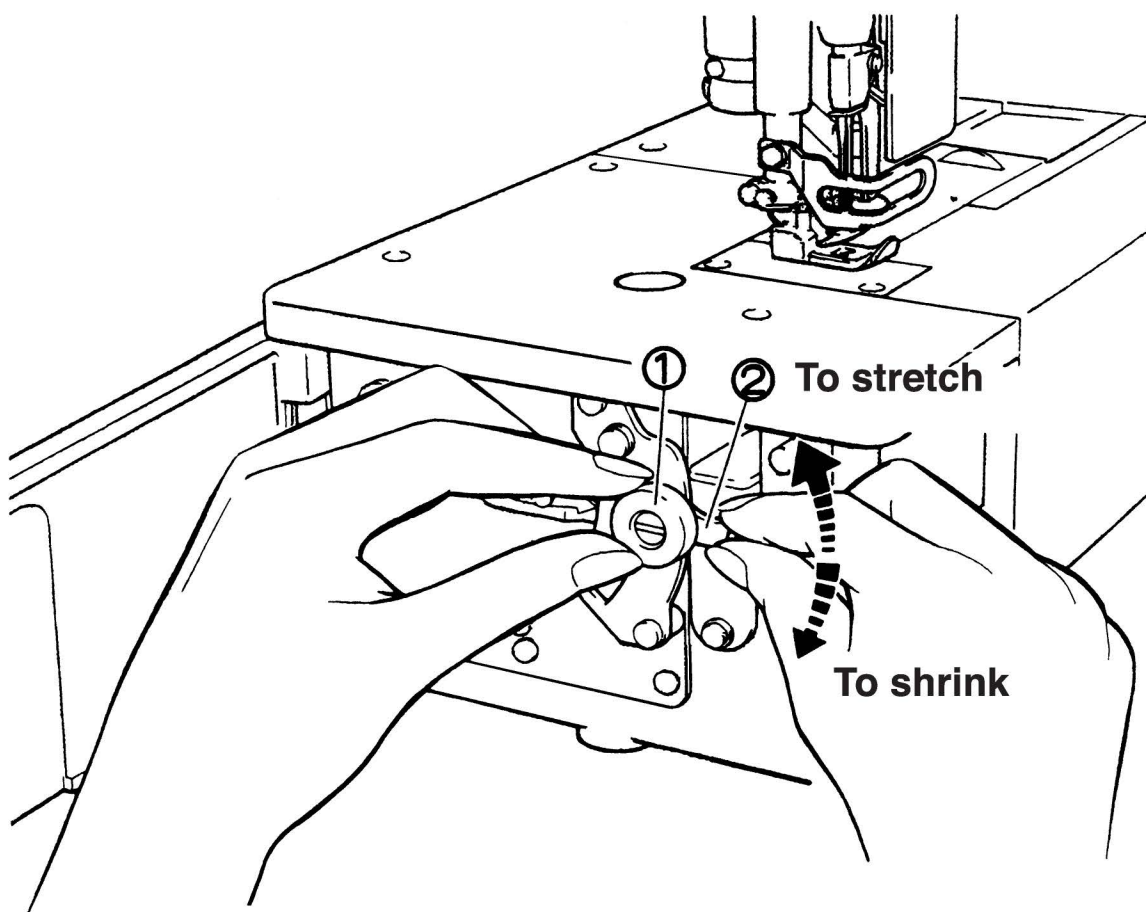
Solid lines
for ordinary thread



Loosen adjusting nut (1) and turn adjusting screw (2) to adjust the presser foot pressure. It should be as light as possible, yet be sufficient to obtain the proper stitch formation.



Loosen nut (1) and move the lever up (2) and down to obtain the correct differential feed ratio. then tighten nut (1).

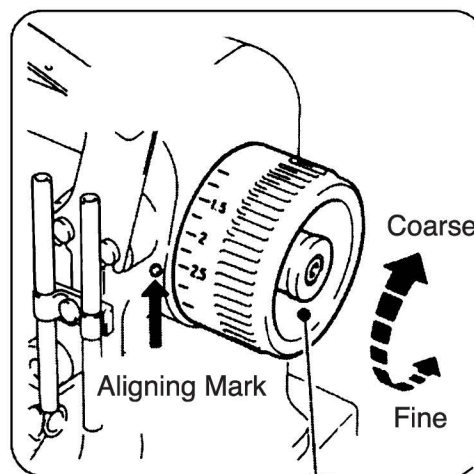


TEST SEWING

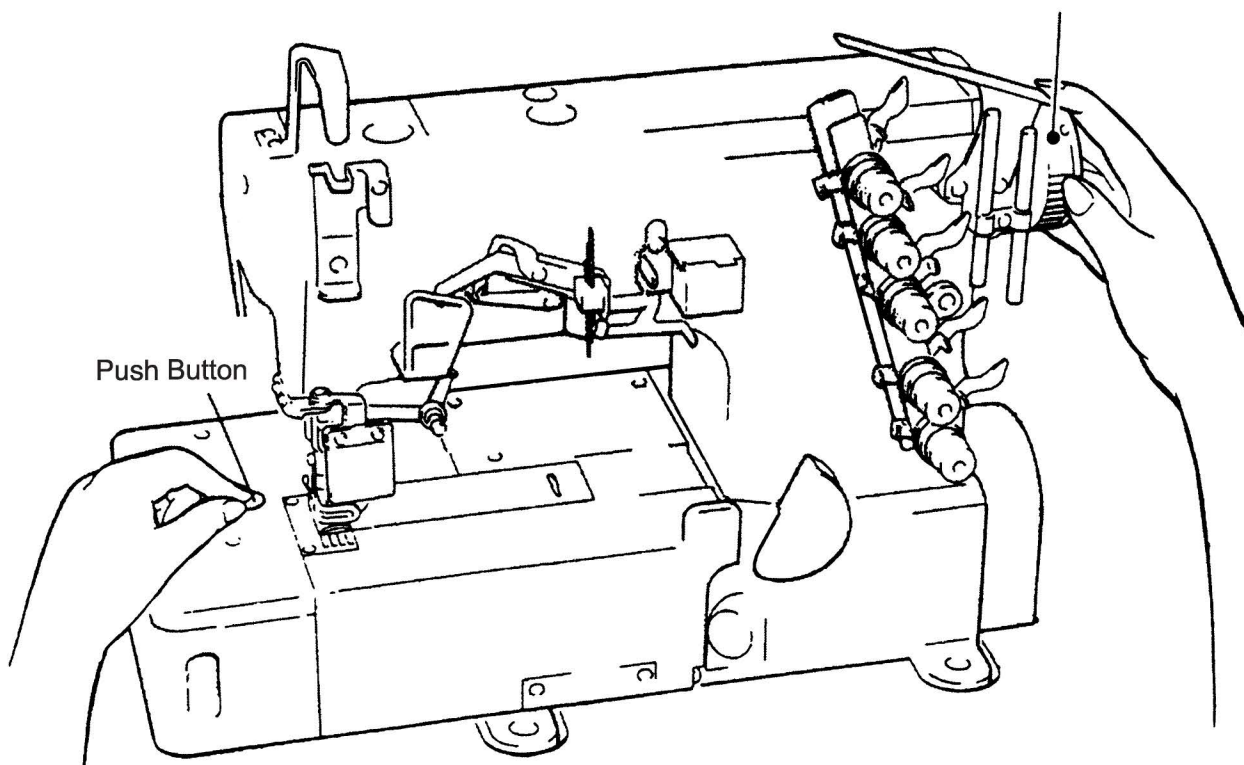
Stitch length adjustment

While pressing the push button, turn the handwheel to seek the position at which the push button goes further into the depth. Then, keeping the push button pressed, turn the handwheel and set the desired scale to the aligning mark.

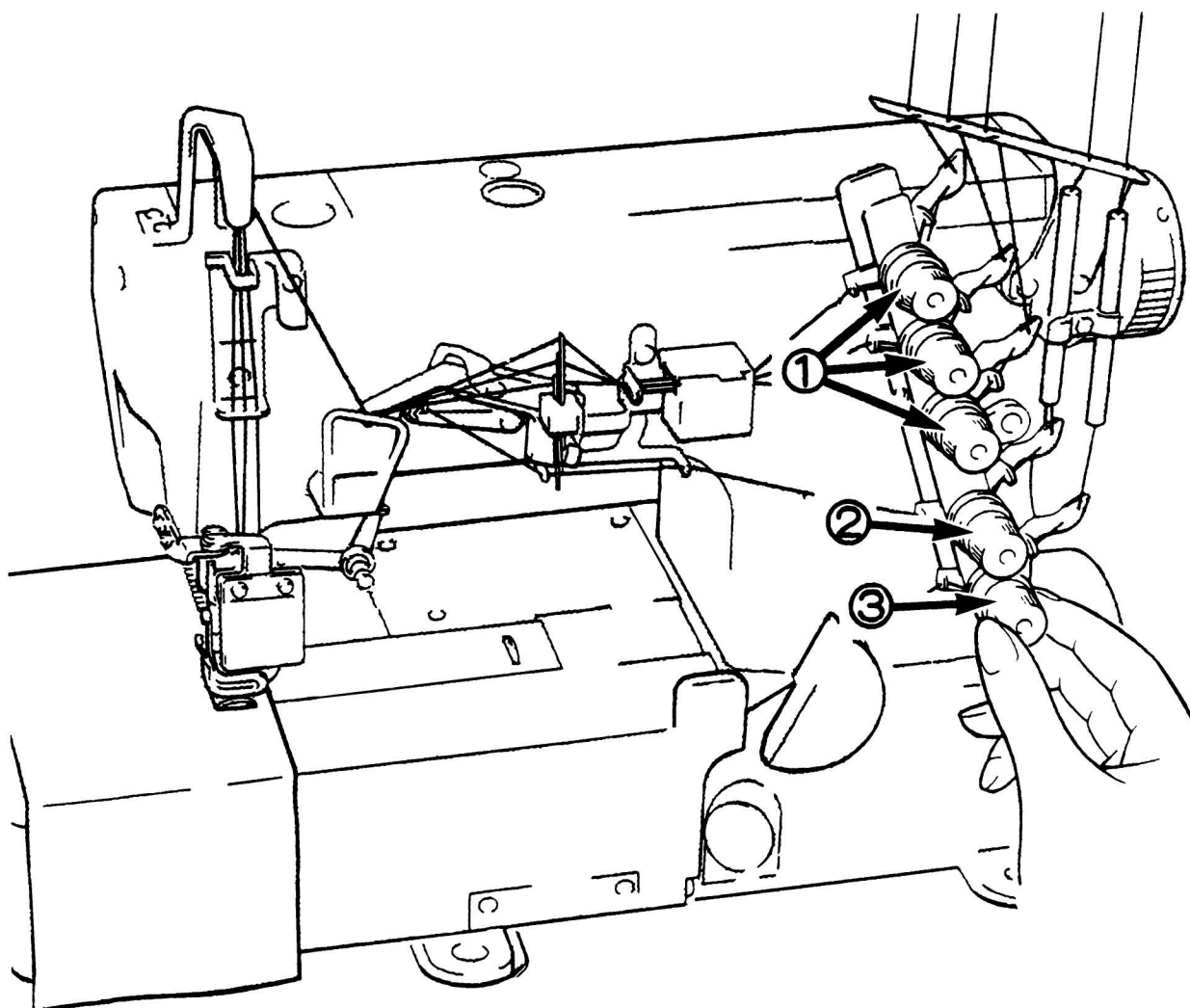
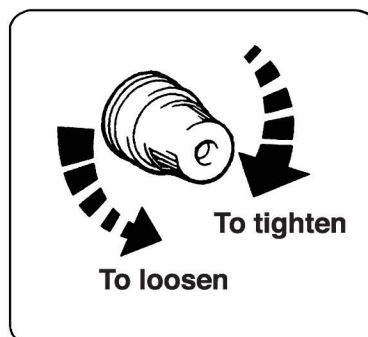
Important Note: Stitch length adjustment must only be made after the differential feed ratio has been changed.



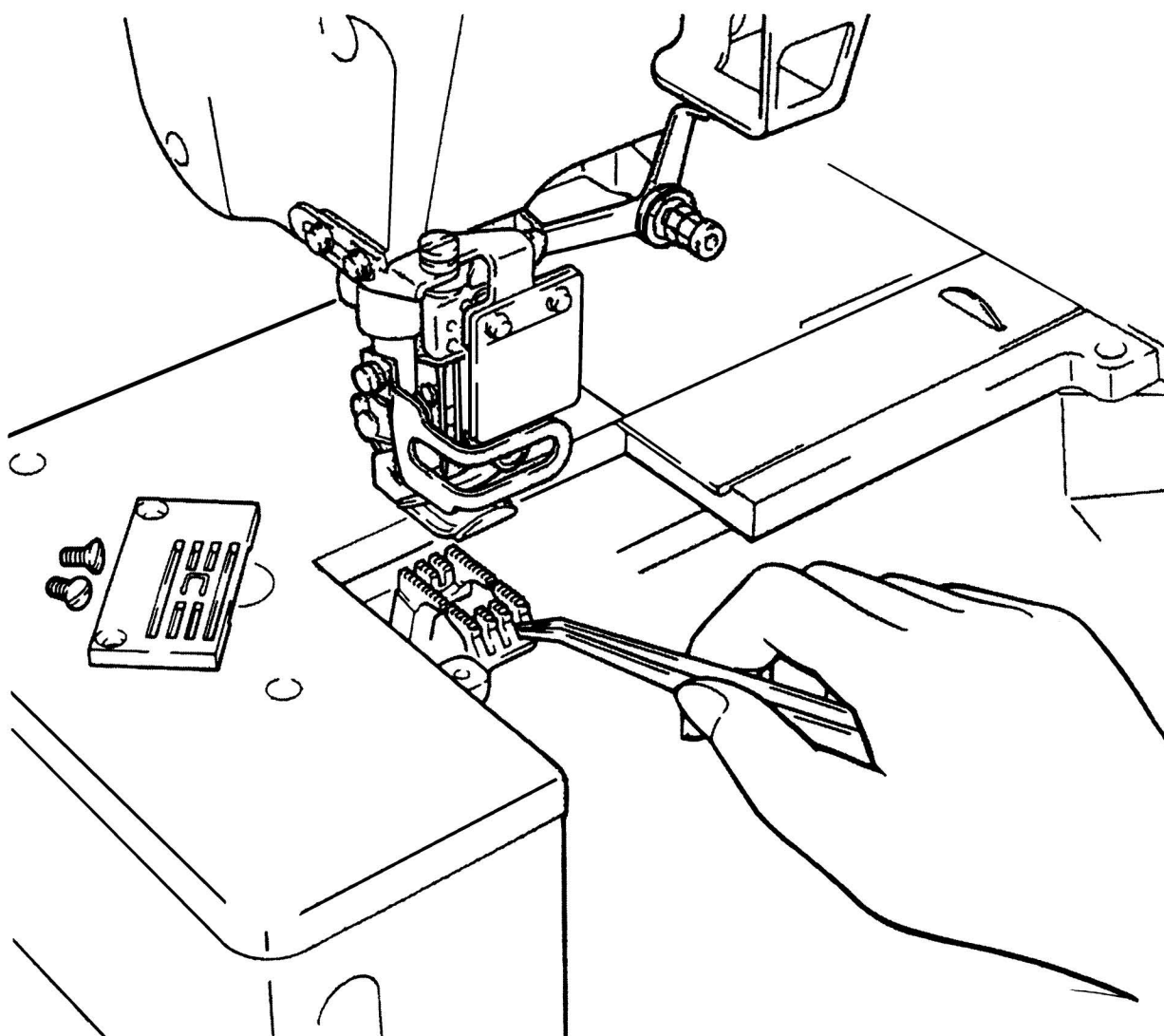
Handwheel



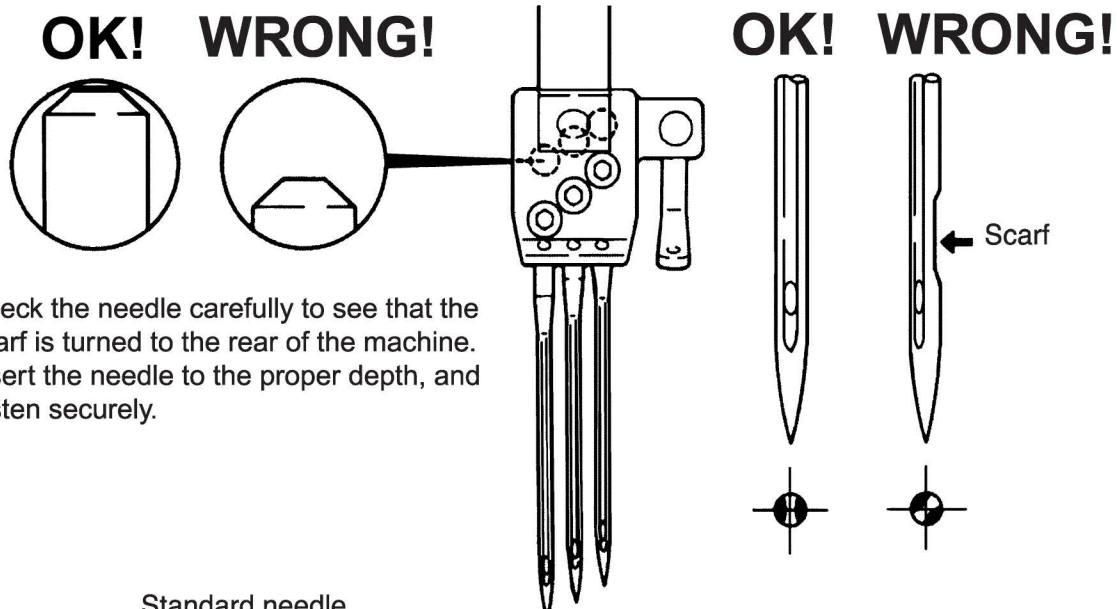
Make tension adjustments with the needle thread knob (1), top cover thread knob (2), and looper thread knob (3).



Mainly the slots of the needle plate and the feed rows should be cleaned.



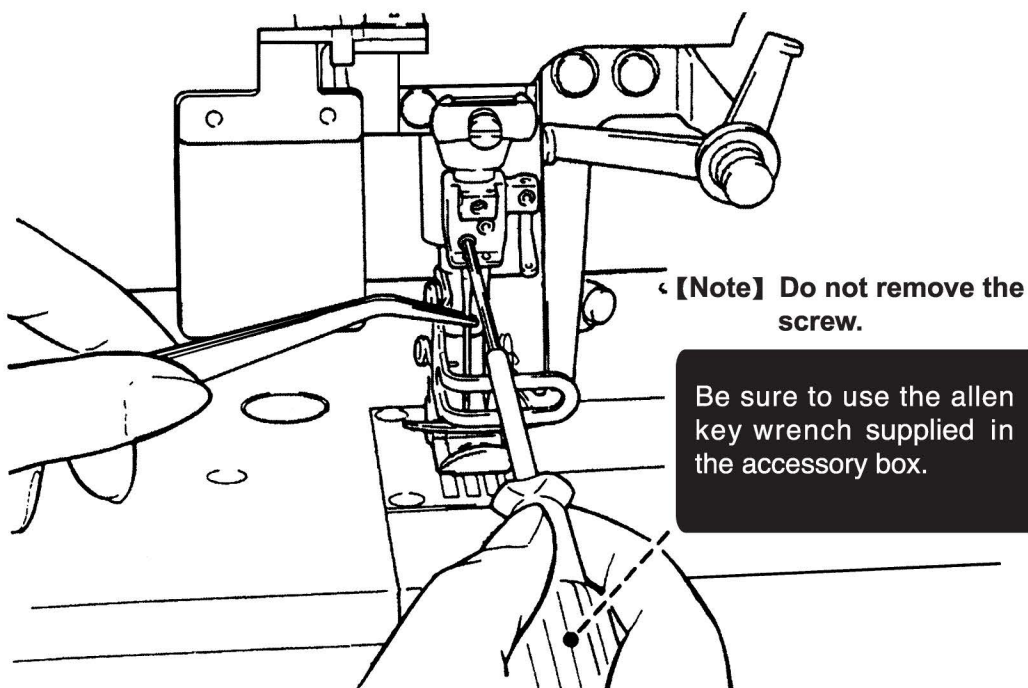
Replacing the needle

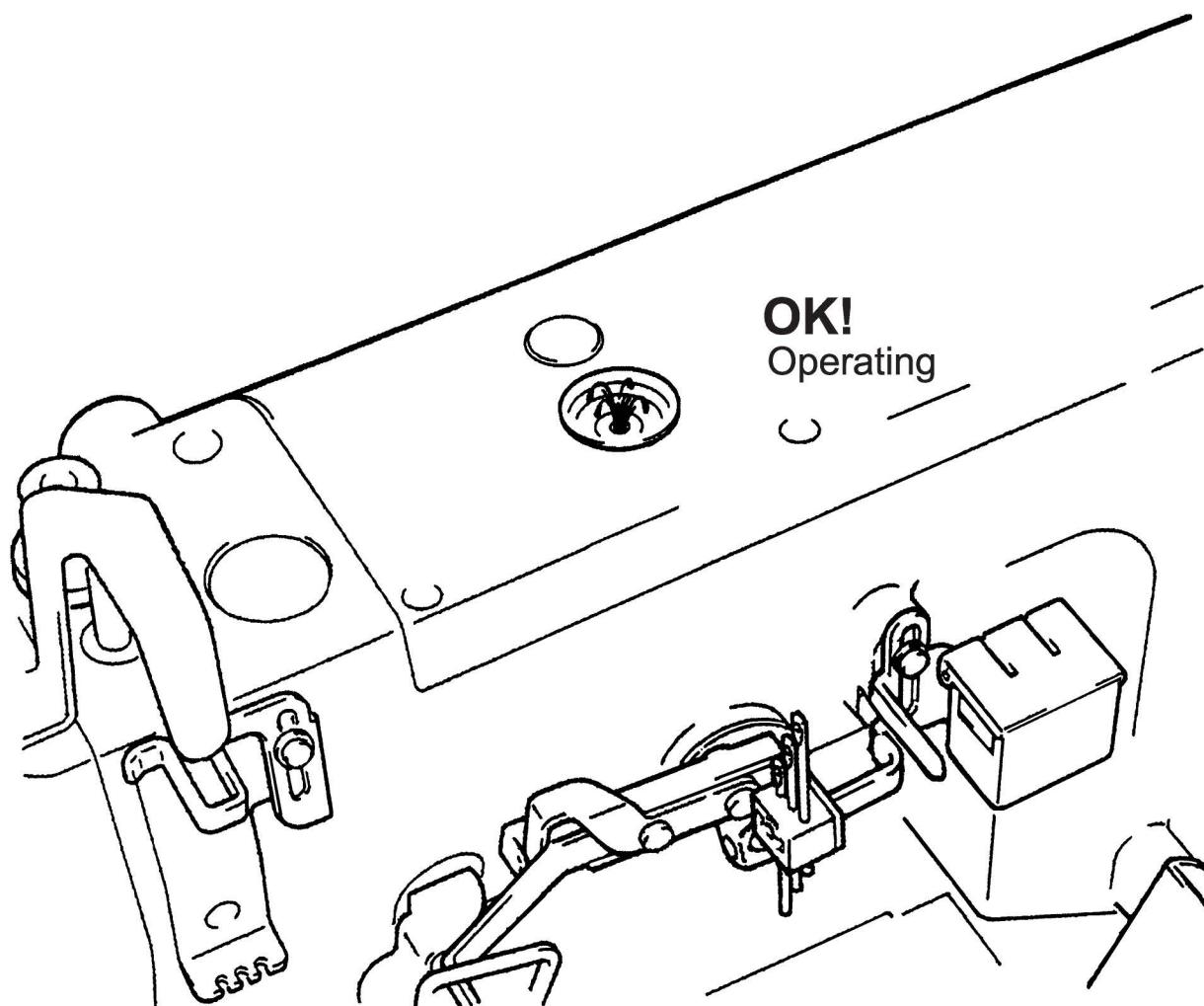


*Check the needle carefully to see that the scarf is turned to the rear of the machine.
*Insert the needle to the proper depth, and fasten securely.

Standard needle

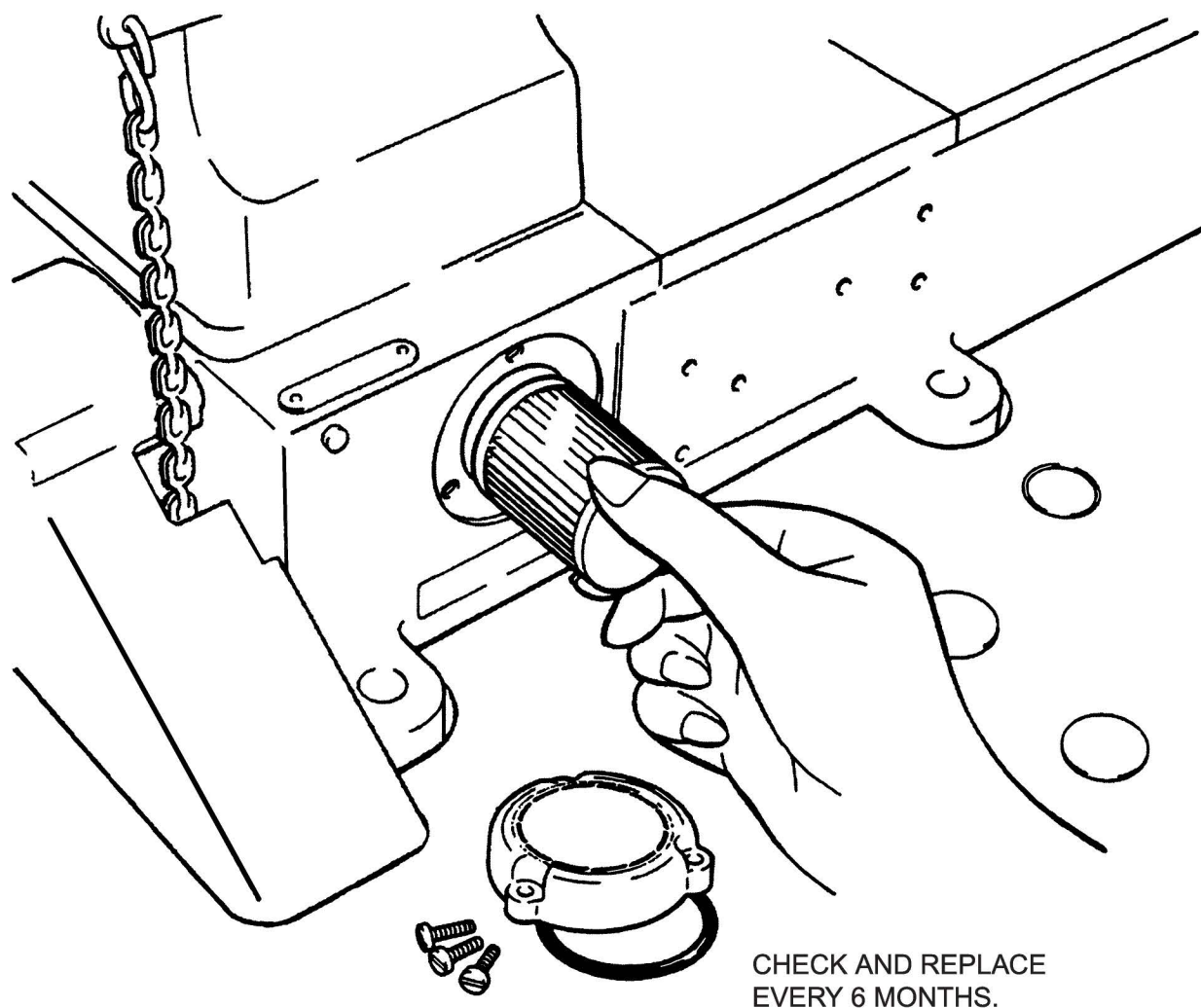
	NEEDLE SIZE	
	2-needle	3-needle
Needle Cat No. 3651-06	# 9	# 10





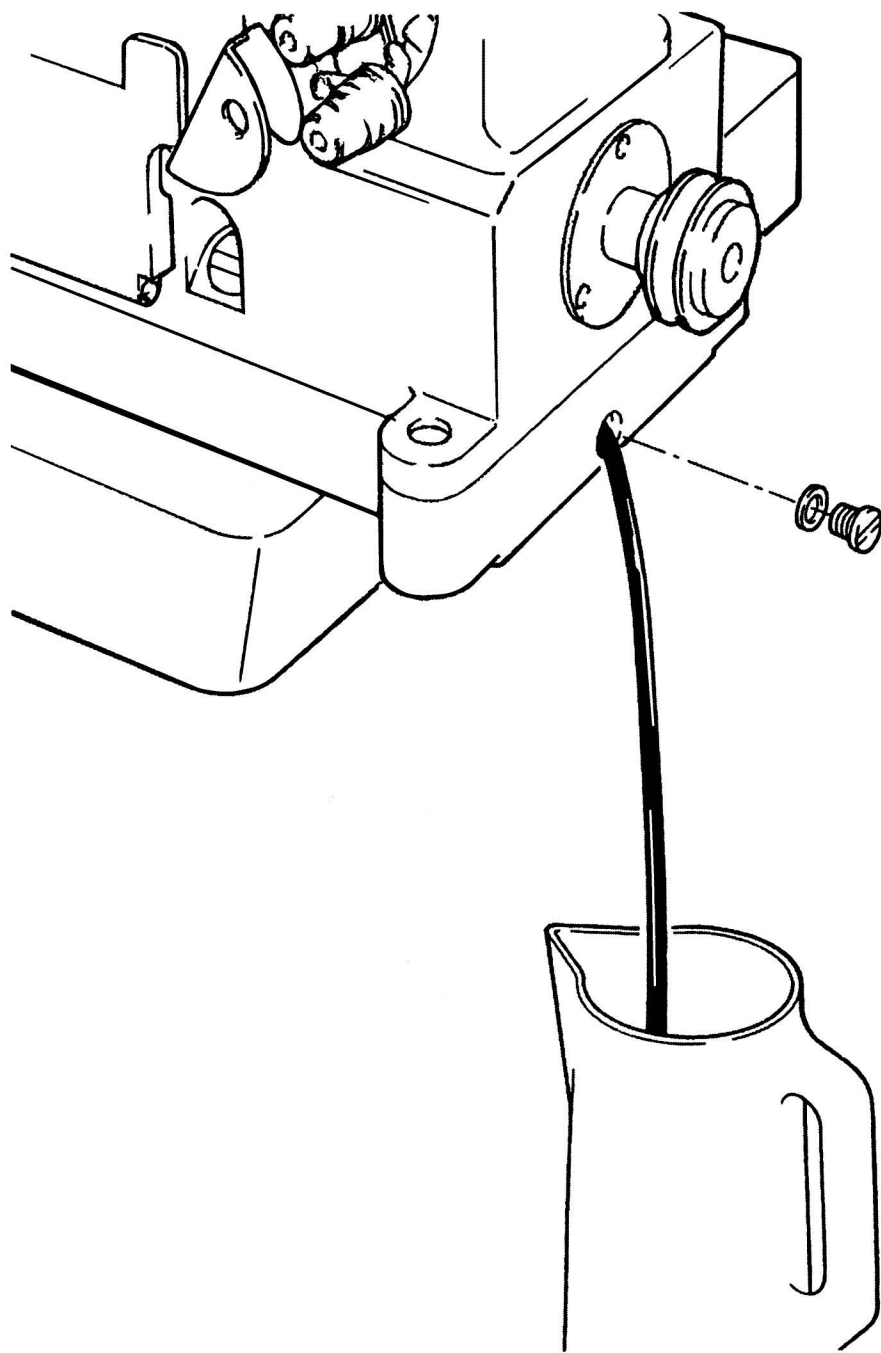
Checking and replacing the oil filter

Check and replace the oil filter every six months.



NOTE: On machines fit with a UT Device, remove the solenoid bracket.

Replace the oil one month after the first use and every six months thereafter.

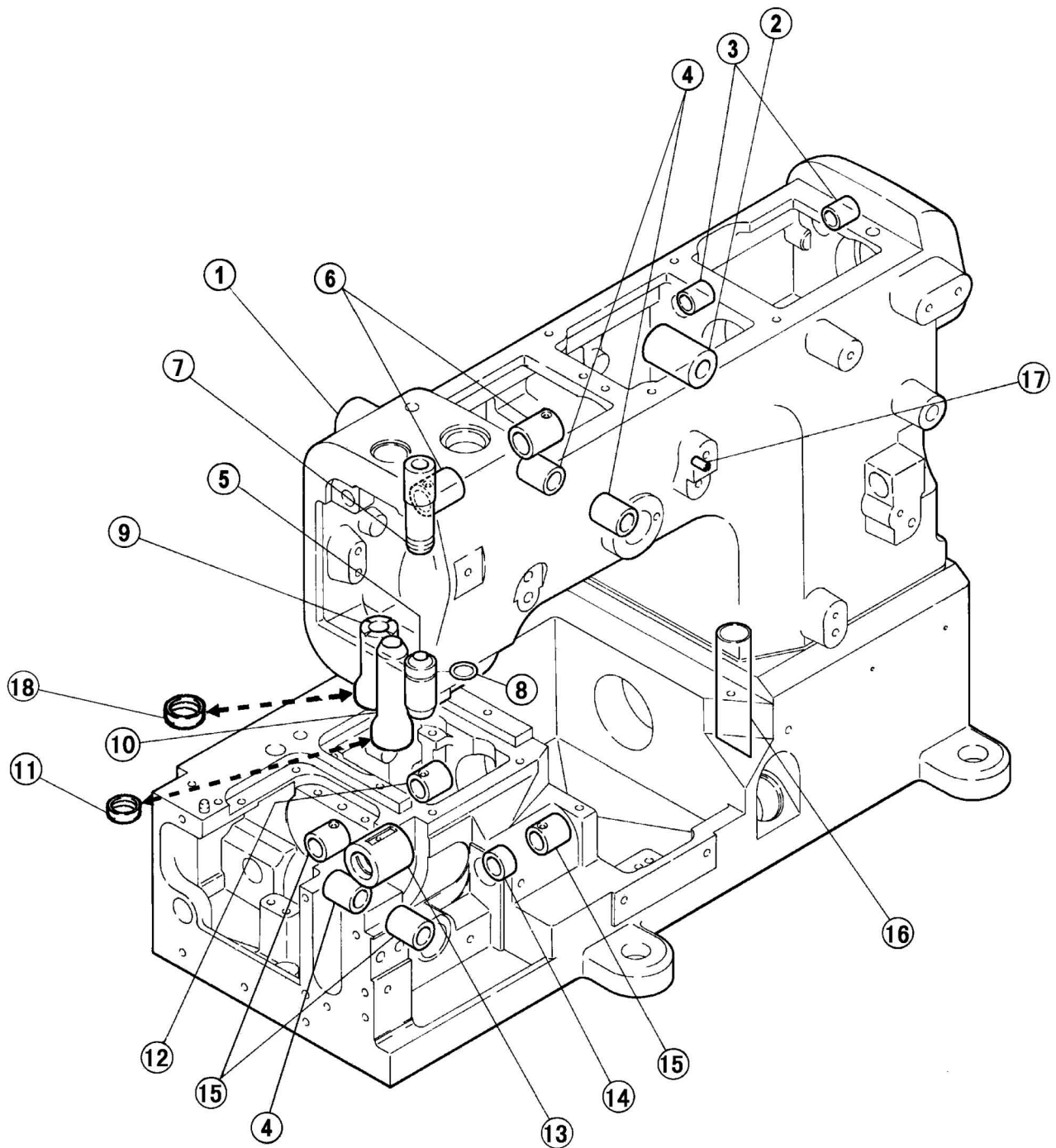


2754A Adjustment Dimensions (mm)

Three-needle	048M	9.4	3.6~3.9	8.3~8.7	4.5~5.0	17.0	0.8~1.2		
	056M	8.5	8.3~8.7	8.3~8.7	4.5~5.0	17.0	0.8~1.2		
	064M	8.1	2.8~3.1	8.3~8.7	4.5~5.0	17.0	0.8~1.2		

ILLUSTRATED PARTS LIST

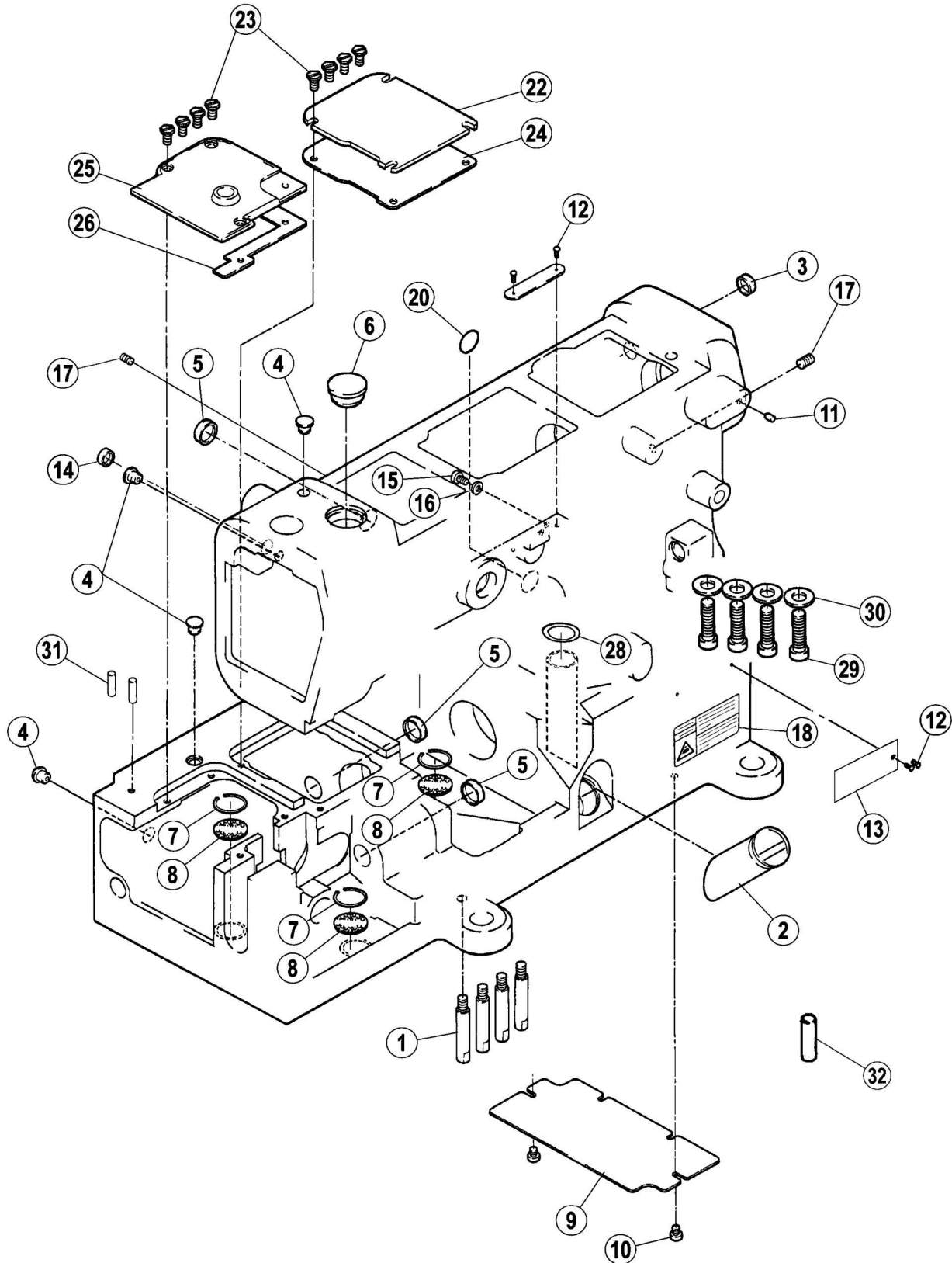
1. Bushing Components



1. Bushing Components

No.	Parts No.	Description	QTY
1	30101003	machine frame	1
2	30103036	bushing	1
3	30103037	bushing	2
4	30103042	bushing	3
5	30103018	bushing	1
6	30103039	bushing	2
7	30103017	bushing	1
8	001039	o ring	1
9	30103038	bushing	1
10	30103035	bushing	1
11	30122039	plug	1
12	30103021	bushing	1
13	30103010	bushing	1
14	30103019	bushing	1
15	20103014	bushing	3
16	30121001	pipe	1
17	P03005	pin	1
18	20622019	plug	1

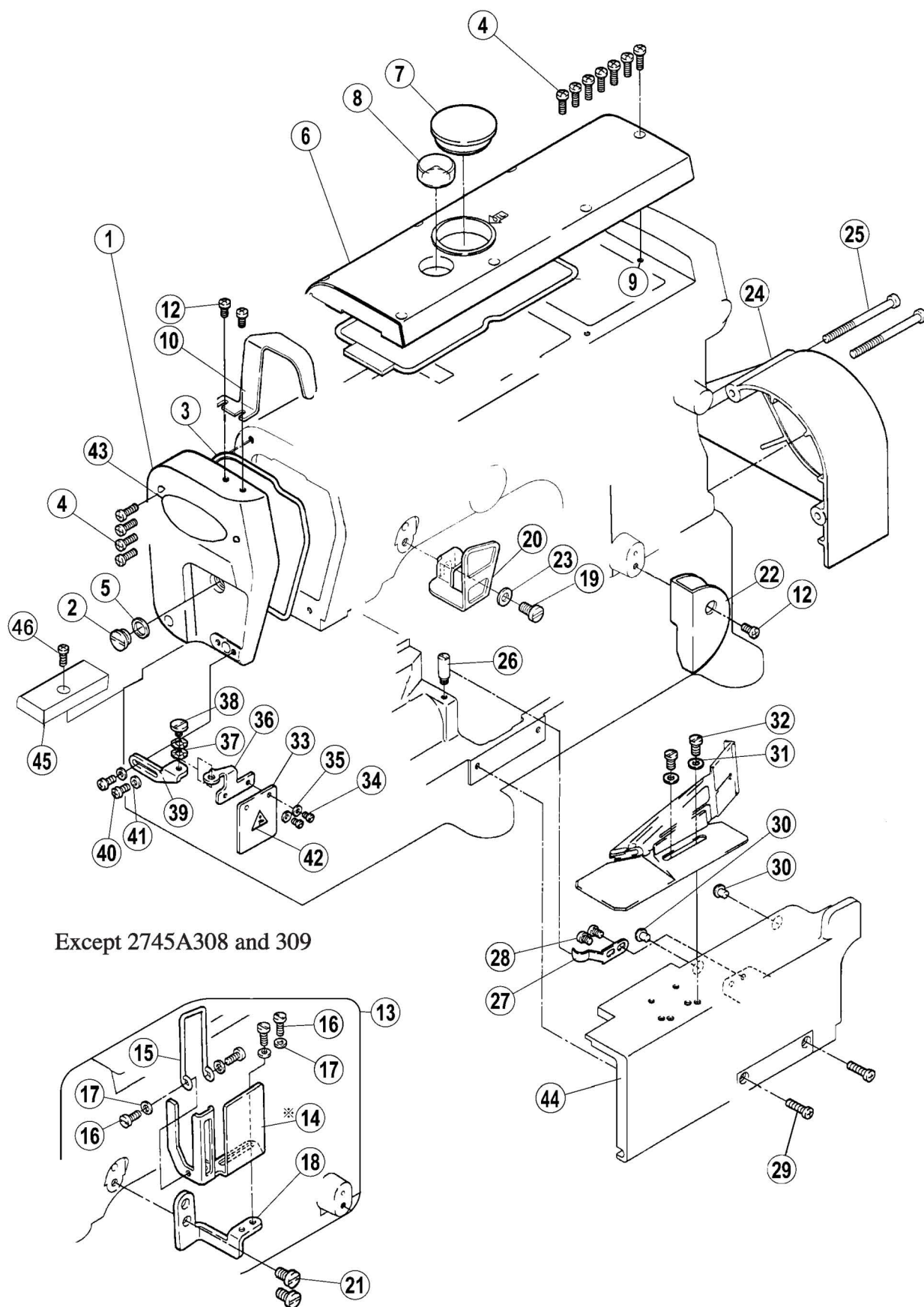
2. Frame Components



2. Frame Components

No.	Parts No.	Description	QTY
1	301S30001	shoulder pin	4
2	30111001	oil level gauge	1
3	30122004	plug	1
4	30122006	plug	4
5	30122008	plug	3
6	30122005	plug	1
7	H01001	ring 18	3
8	30112001	filter	3
9	30112002	cover	1
10	S01002	screw M4x6,5	2
11	30122010	mark	1
12	R03001	pin 2.5x4	4
13	J900111-xxx	sticker	1
14	30122007	plug	1
15	S01004	screw M4x7.8	1
16	W01001	washer4	1
17	S12004	screw M6x10	2
18	20131063	sticker	1
20	30122036	sticker	1
22	30101005	top cover plate (right)	1
23	L02001	screw M4x8	8
24	30122003	gasket	1
25	30101004	top cover plate (left)	1
26	30122002	gasket	1
28	1001	o ring 15x2.65	1
29	S05001	screw M10x27.5	4
30	W02003	washer 10	4
31	3022600	pin	2
32	P02001	pin	1

3. Cover Components

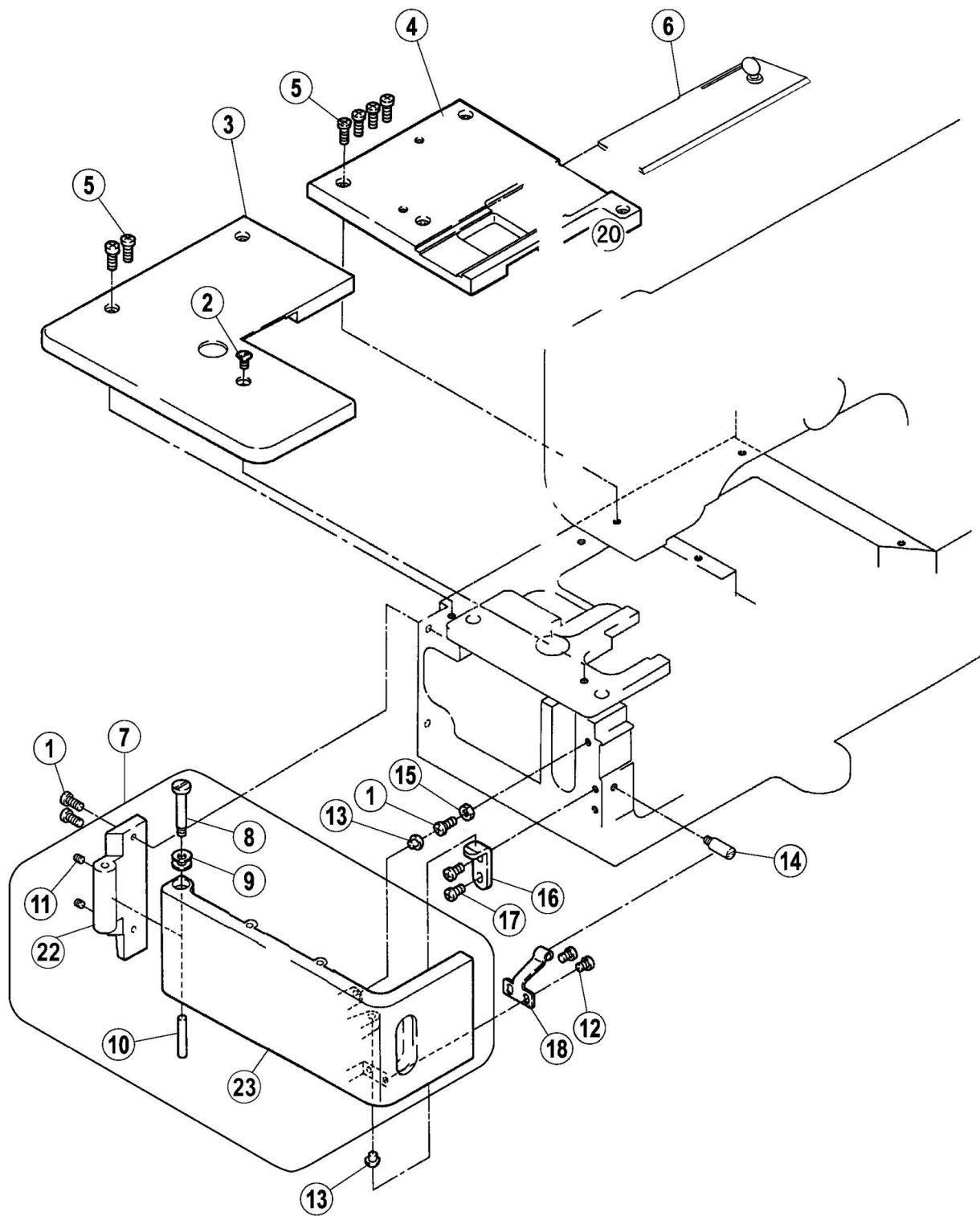


Except 2745A308 and 309

3. Cover Components

No.	Parts No.	Description	QTY
1	30101072	arm cover (left)	1
2	301S11001	screw	1
3	30122014	o ring	1
4	S01003	screw M4x12	1
5	3012801	washer	1
6	30101006	arm cover(top)	1
7	30122012	plug	1
8	20711002	sight window	1
9	30122013	o ring	1
10	30112003	needle bar cover	1
12	S01004	screw M4x78	3
13	3011208300	thread take-up guard assembly	1
14	30112083	thread take-up guard	1
15	30112084	finger guard	1
16	S01001	screw	1
17	W01001	washer 4	3
18	30112085	bracket	1
20	30112006	thread take-up cover	1
21	301S11002	screw	2
22	300135	looper thread guide cover	1
23	W01003	washer 6	1
24	30111004	pulley cover	1
25	301S11003	screw	2
26	301S30002	screw	1
27	30127001	flat spring	1
28	S01002	screw M4x65	2
29	S01007	screw M4x13.5	2
30	30122015	cushion	2
31	W01004	washer 5	2
32	S01011	screw M5x10	2
33	30111003	eye guard	1
34	S01006	screw M3x45	2
35	W01002	washer 3	2
36	30112005	bracket	1
37	W03001	washer 6	2
38	301S20001	screw	1
39	30112004	bracket	1
40	S01004	screw M4x78	2
41	W01001	washer 4	2
42	30137005	sticker	1
43	30337001	sticker	1
44	300136	arm cover (top)	1
45	300657	bracket	1
46	S01003	screw M4x12	4

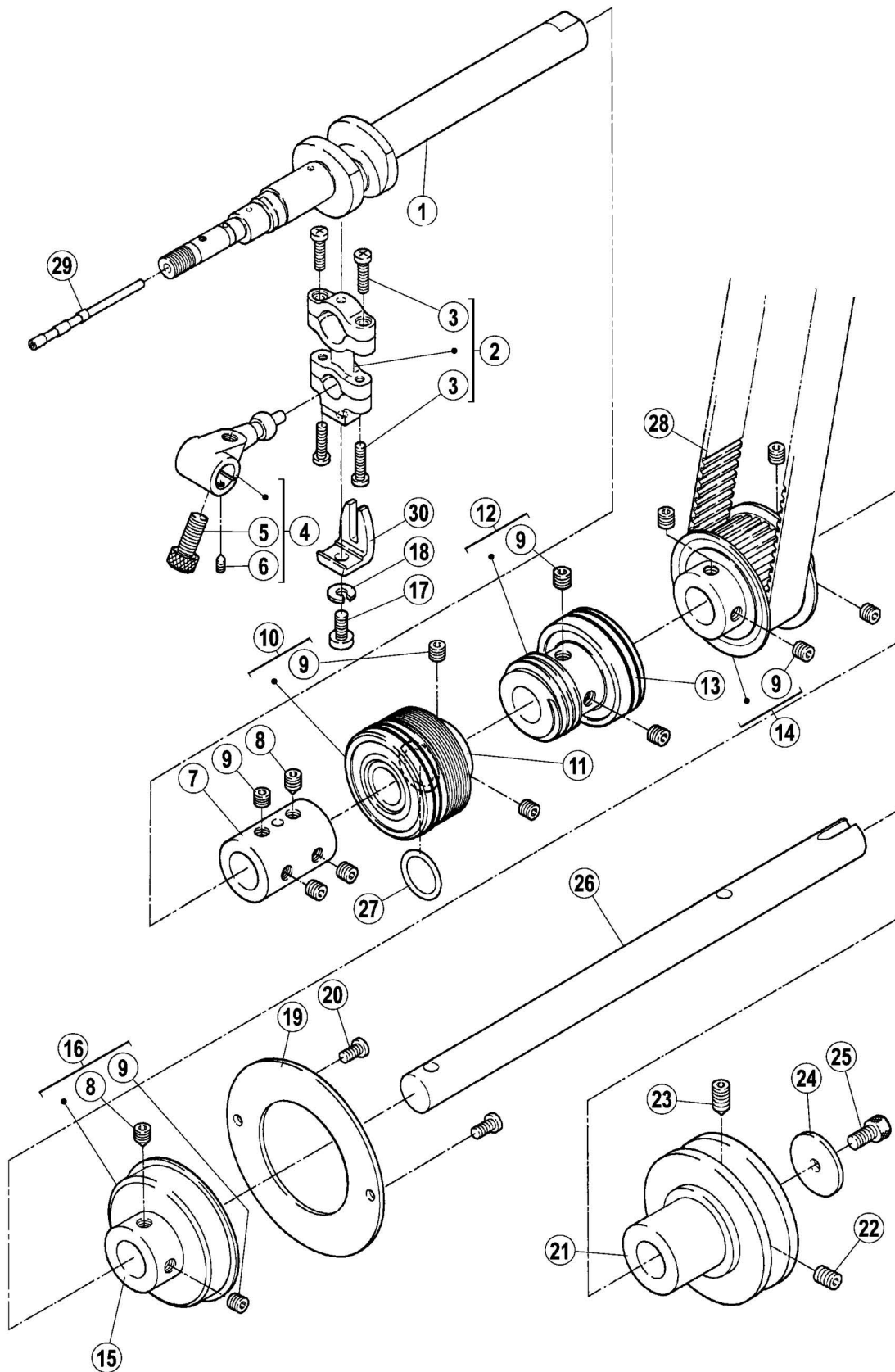
4. Cloth Plate Components



4. Cloth Plate Components

No.	Parts No.	Description	QTY
1	S01005	screw M4x10	3
2	S02001	screw M4x6	1
3	300139	bed cover(left)	1
4	300137	bed cover(right)	1
5	S01003	screw M4x12	6
6	30115001	cover	1
7	300138	side cover assembly	1
8	301S20004	screw	1
9	30128036	spring	2
10	301S20005	pin	1
11	S10001	screw M3x4	2
12	S01002	screw M4x6.5	2
13	30122015	cushion	2
14	301S30002	screw	1
15	N01001	nut M4	1
16	30112008	bracket	1
17	S01004	screw M4x7.8	2
18	30127002	flat spring	1
22	30101013	bracket	1
23	30111020	side cover	1

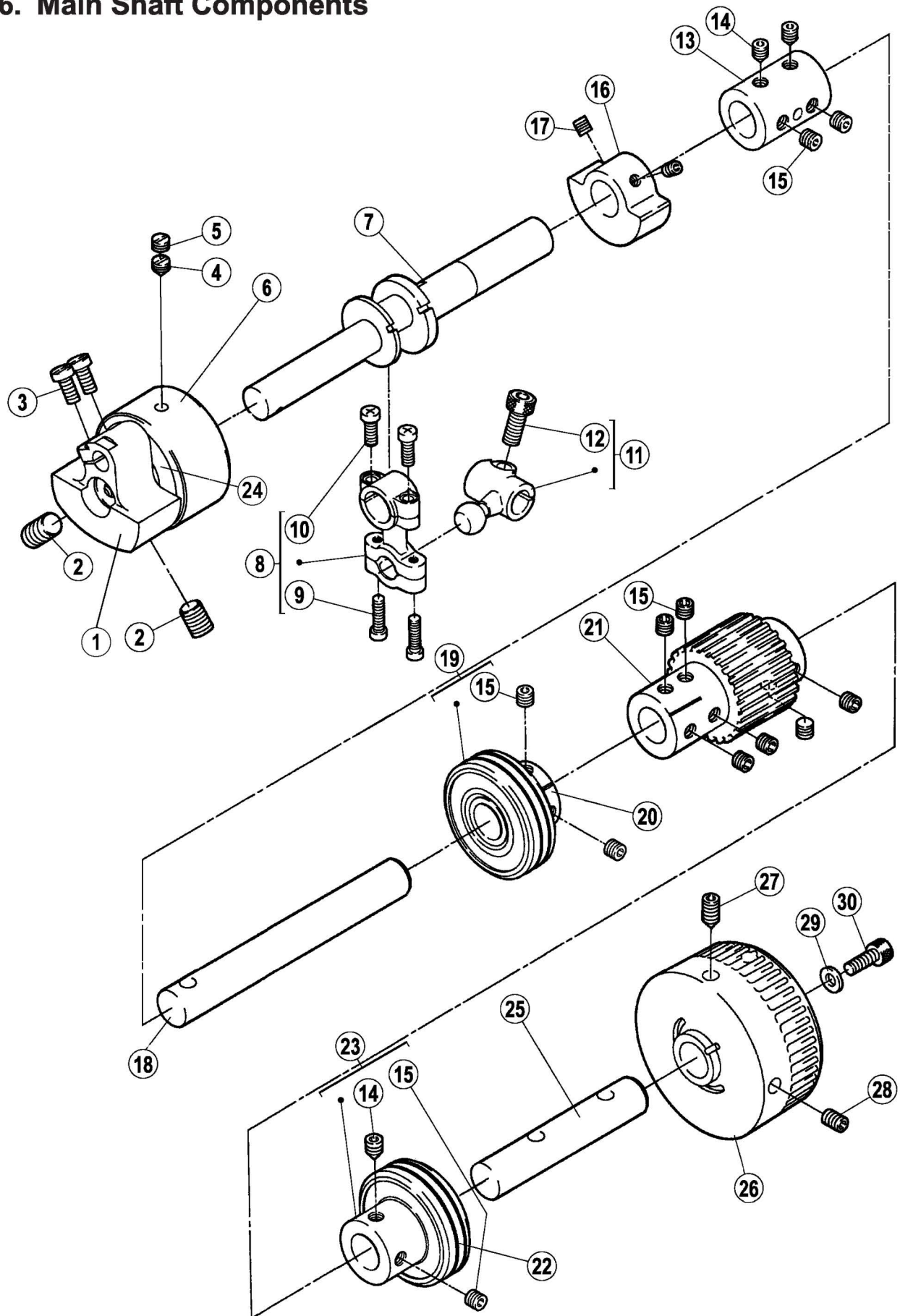
5. Crankshaft Components



5. Crankshaft Components

No.	Parts No.	Description	QTY
1	30102049	crankshaft assy	1
2	3010500100	connection assy	1
3	S01008	screw M3.5x13	4
4	30104002	crank	1
5	S05002	screw M6x0.75x15.2	1
6	S12002	screw M3x4	1
7	30103004	joint	1
8	S12003	screw M6x7	2
9	S10003	screw Mx0.75x5	12
10	3012400300	beating	1
11	30103006	bushing	1
12	30103008	bushing	1
13	3012400400	bearing	1
14	30125001	gear (lower)	1
15	30103009	bushing	1
16	B01003	bearing 6304z	1
17	301S11004	screw	1
18	W02001	washer 5	1
19	30108001	cover	1
20	S01004	screw M4x7.8	2
21	30101015	machine pulley	1
22	S10009	screw M6x8	1
23	S12001	screw M6x8	1
24	30128005	washer	1
25	S05003	screw M5x10	1
26	30102003	shaft	1
27	001001	o ring 15x2.65	1
28	30135002	timing belt	1
29	30126001	adjusting bar	1
30	30109001	guide	1

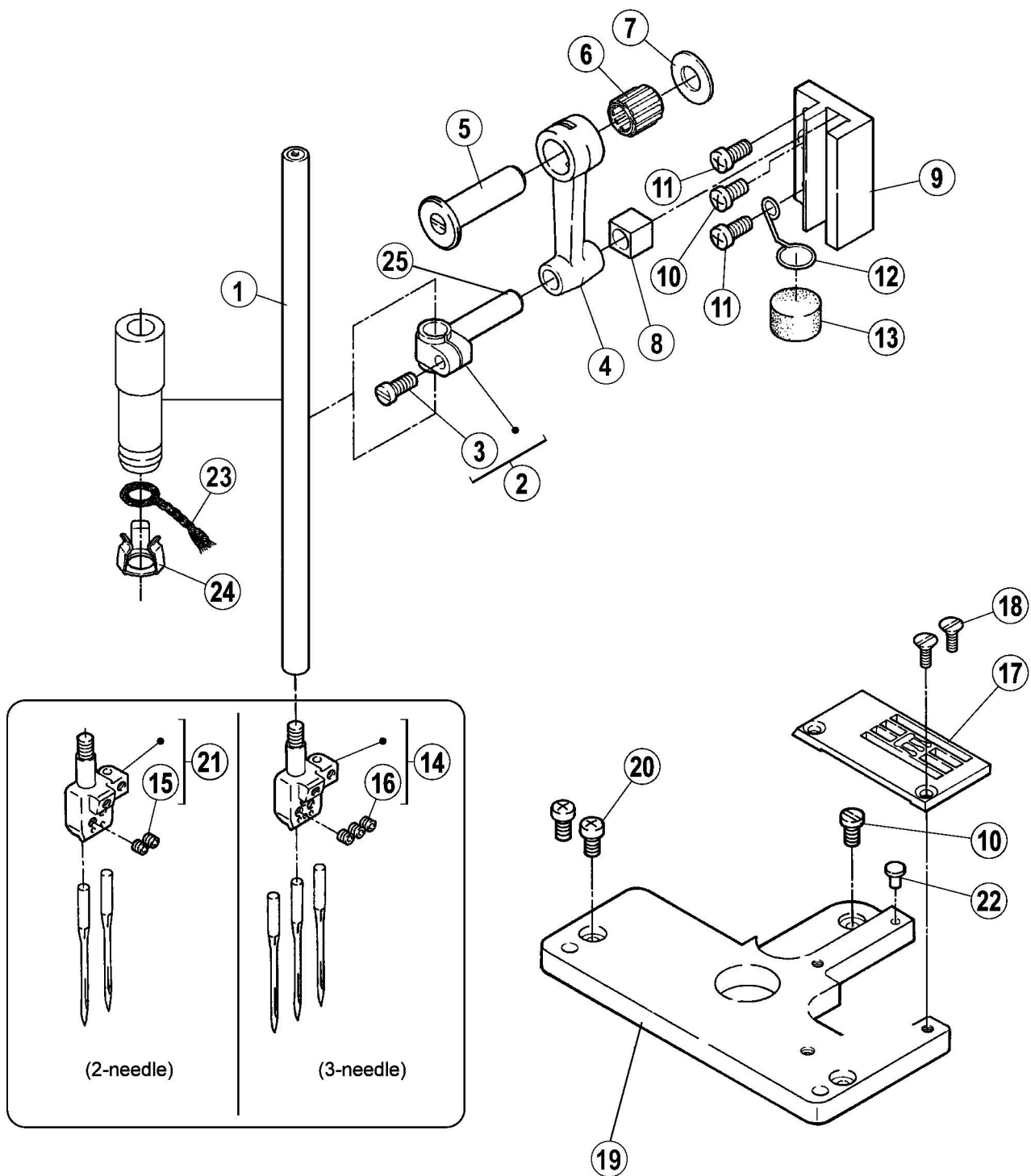
6. Main Shaft Components



6. Main Shaft Components

No.	Parts No.	Description	QTY
1	30104004	motion assy	1
2	S1130114	screw M8x1x2	2
3	S01011	screw M5x10	2
4	S08001	screw M6x0.75x3.5	1
5	S11001	screw M6x0.75x6	1
6	30103015	bushing	1
7	30102005	crankshaft	1
8	3010500300	connection assy	1
9	S01003	screw M4x12	2
10	S01008	screw M3.5x13	2
11	30104006	crank assy	1
12	S05002	screw M6x0.75x15.2	1
13	30103004	joint	1
14	S12003	screw M6x0.75x15.2	3
15	S10003	screw M6x0.75x5	11
16	30109003	balance weight	1
17	S10002	screw M5x5	2
18	30102006	shaft	1
19	3012400400	bushing	1
20	30103012	bushing	1
21	30125002	gear (upper)	1
22	3012400400	bearing	1
23	30103014	bushing	1
24	B01005	bearing	2
25	30102007	shaft	1
26	30101016	handwheel	1
27	S12001	screw M6x8	1
28	S10009	screw M6x8	1
29	W01004	washer 5	1
30	S05004	screw M5X14	1

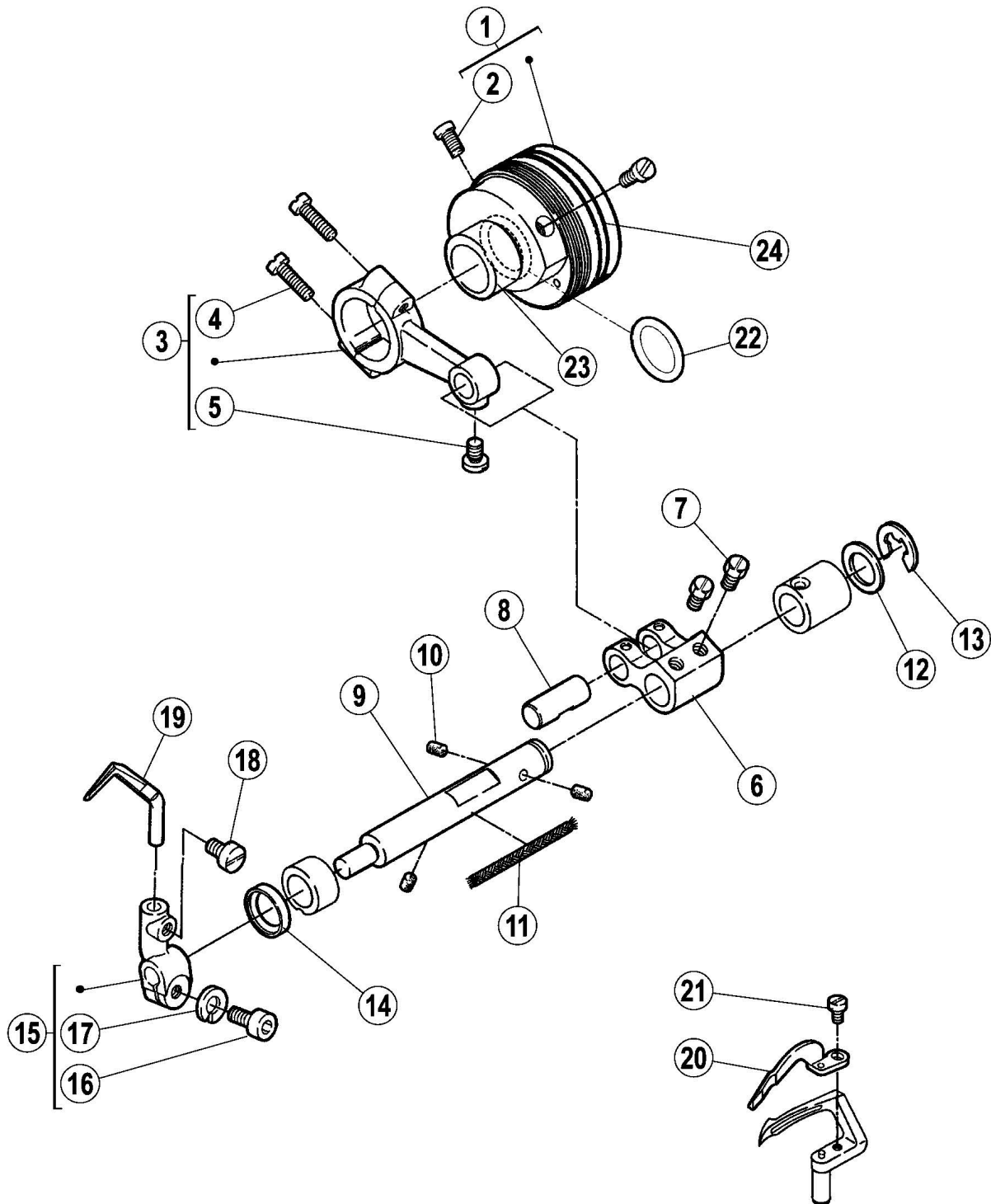
7. Needle Bar Components



7. Needle Bar Components

No.	Parts No.	Description	QTY
1	30102008	needle bar	1
3	301S11005	screw	1
4	30105005	needle bar drive link	1
5	30102010	pin	1
6	B07001	needle bearing	1
7	30128006	washer	1
8	80109004	block	1
9	30109005	needle bar guide block	1
10	301S11024	screw	2
11	S01003	screw M4x12	2
12	30127003	latch	1
13	30123002	sponge	1
14	XXXXXXXXX	needle holder	1
15	S10005	screw M3x3	2
16	S10005	screw M3x3	3
17	XXXXXXXXX	needle plate	1
18	301S17001	screw	2
19	30109006	bracket	1
20	S01004	screw M4x7.8	2
21	XXXXXXXXX	needle holder	1
22	30122018	cushion rubber	1
23	20523003	oil wick	1
24	30112009	oil wick retainer	1
25	30102009	needle bar crank	1

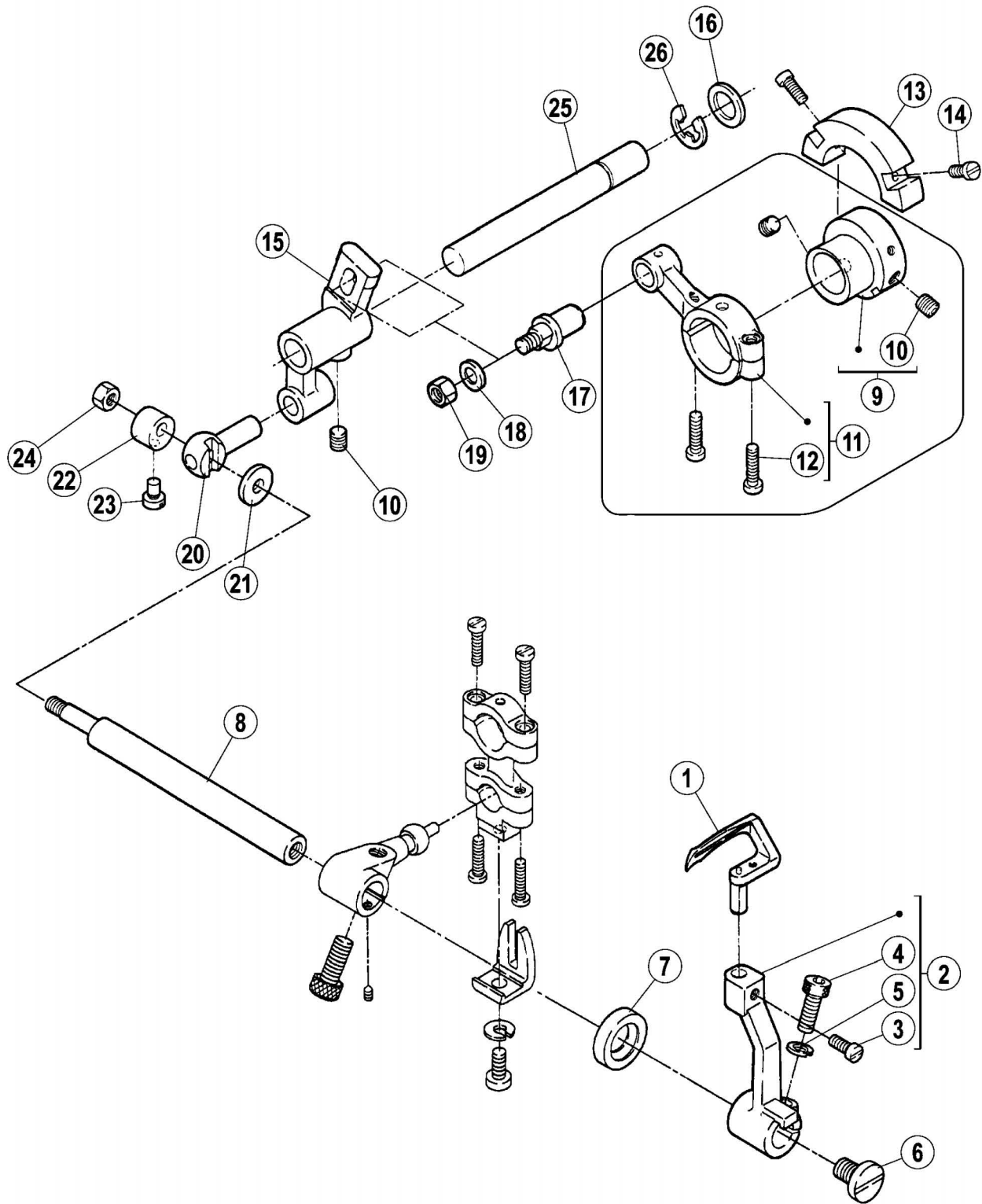
8. Needle Guard Components



8. Needle Guard Components

No.	Parts No.	Description	QTY
1	B01001	eccentric assy	1
2	S10006	screw	2
3	3010500600	connection assy	1
4	S01008	screw	2
5	301811024	screw	1
6	30104007	crank	1
7	301S12001	scrcew	2
8	30126003	pin	1
9	30102011	shaft	1
10	30123001	felt	3
11	20523003	oil wick	1
12	30128008	washer	1
13	H05001	ring	1
14	30122019	oil seal	1
15	30104009	lever assy	1
16	S05003	screw	1
17	W02001	washer	1
18	S01002	scow	1
19	30117002	needle guard (rear)	1
20	30117003	needle guard (front)	1
21	S01012	screw	1
22	001001	o ring	1
23	30110002	eccentric	1
24	30122017	oil sel	2

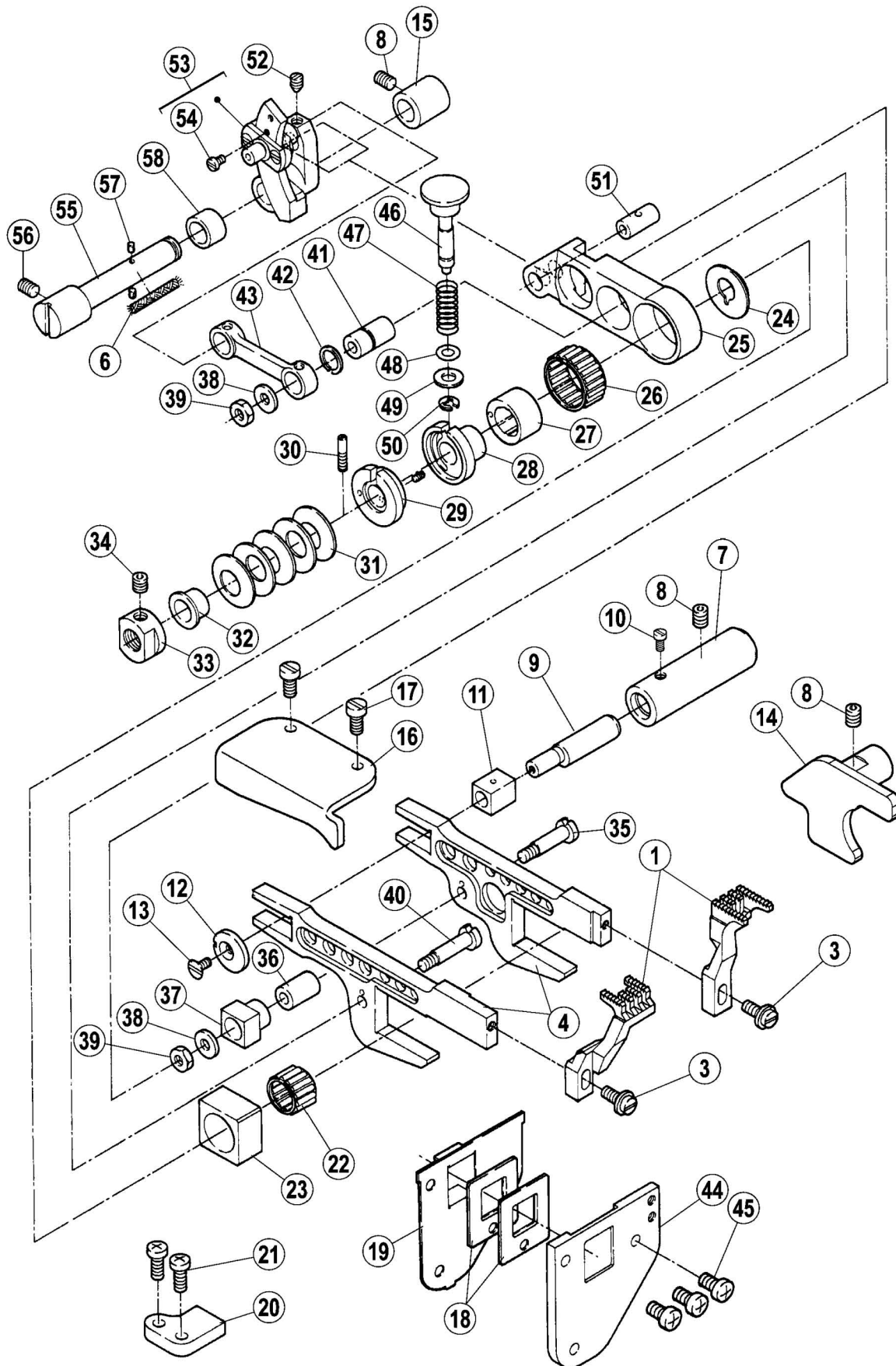
9. Looper Components



9. Looper Components

No.	Parts No.	Description	QTY
1	3011700900	looper	1
2	30104012	looper holder assy	1
3	S01004	screw M4x7.8	1
4	S05004	screw M5x14	1
5	W02001	spring washer 5	1
6	S01014	screw M6x0.75x9.6	1
7	20622019	oil seal	1
8	30102014	shaft	1
9	30110005	eccentric assy	1
10	S10006	screw M5x6	3
11	31)10500800	connection assy	1
12	S01008	screw M3.5x13	2
13	30109007	balance weight	1
14	S01009	screw M3x7.5	2
15	30104010	crank	1
16	30128008	washer	1
17	30102013	pin	1
18	30128032	washer	1
19	N01002	nut M5	1
20	30102015	block pin	1
21	30128010	washer	1
22	30108002	collar	1
23	301812001	screw	1
24	N01001	nut M4	2
25	30102012	shaft	1
26	H05001	ring 10	1

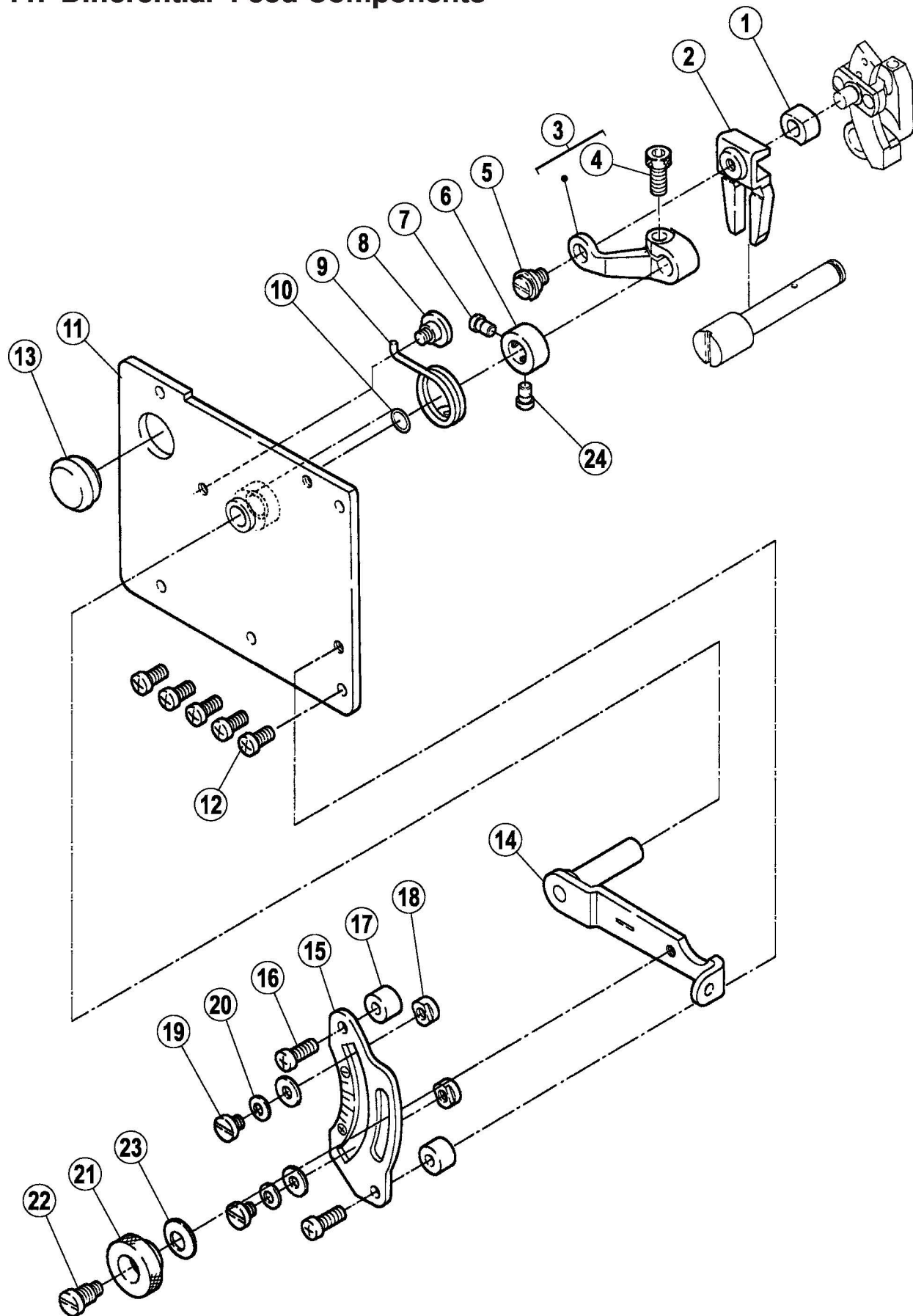
10. Feed Dog Holder Components



10. Feed Dog Holder Components

No.	Parts No.	Description	QTY
1	3011400700	main feed dog assy	1
3	301S30003	screw	2
4	30110600400	main feed bar assy	1
6	20123019	oil wick	1
7	30103022	bushing	1
8	S10006	screw M5x6	4
9	30102016	eccentric pin	1
10	301S12001	screw	1
11	301109008	block / feed bar guide	1
12	30128011	washer	1
13	301S17002	screw	1
14	30109009	guide (right)	1
15	30103031	bushing	1
16	30100010	guide (left)	1
17	L02003	screw M4x7	2
18	30122020	oil shield	2
19	30109011	cover	1
20	30109012	guide (lower)	1
21	S01005	scww M4x10	2
22	807002	needle bearing	1
23	30109013	block	1
24	30108003	washer	1
25	30104013	main feed link	1
26	B07003	needle bearing	1
27	30103023	eccentric	1
28	30103024	regulator	1
29	3010306500	eccentric retainer	1
30	301S30004	screw	1
31	30128012	spring	5
32	30103026	spacer	1
33	301S16001	nut	1
34	S10002	screw M5x5	1
35	301S30005	screw	1
36	30103027	bushing	1
37	30109014	guide block	1
38	30128013	wsher	2
39	301S10002	nut	2
40	301S30006	screw	1
41	30103028	bushing	1
42	30129001	ring	1
43	30105010	differential feed link	1
44	30109015	bracket	1
45	S01004	screw M4x7.8	3
46	30102017	pin	1
47	30127004	spring	1
48	1004	o ring 4x1.8	1
49	30128032	washer	1
50	1105003	ring 5	1
51	30103029	pin	1
52	S12005	screw M4x4	1
53	3010401500	crank	1
54	S01012	screw M2.5x4	1
55	30102018	shaft	1
56	S10002	serew MSx5	1
57	30123005	felt	2
58	30103030	spacer	1

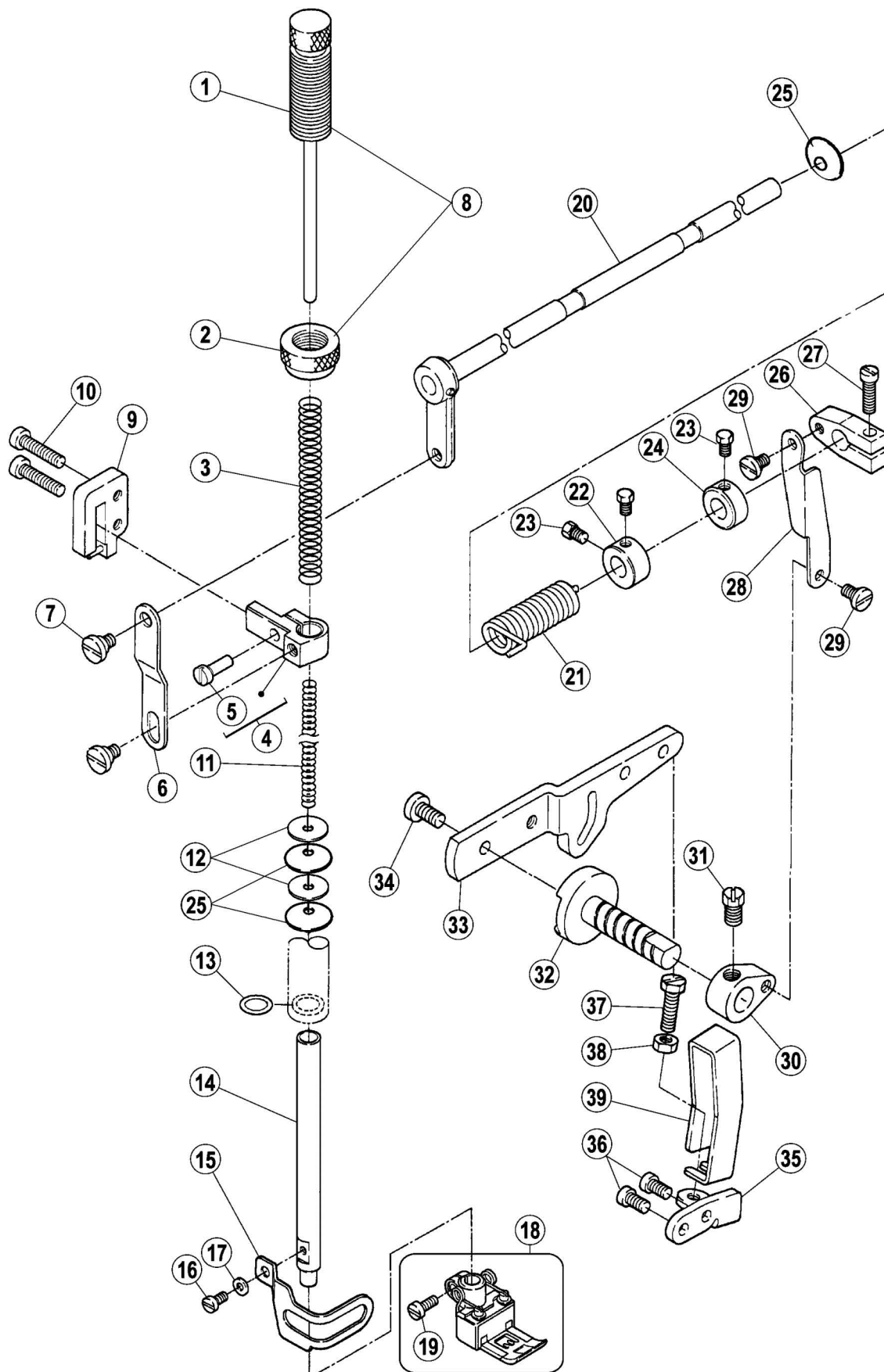
11. Differential Feed Components



11. Differential Feed Components

No.	Parts No.	Description	QTY
1	30103032	block	1
2	30109016	guide / block	1
3	30105012	lever assy	1
4	S05005	screw M5x12	1
5	301S20006	screw	1
6	30108004	ring	1
7	301S11007	scow	1
8	301S20001	screw	1
9	30127005	spring	1
10	001005	o ring 2.5x1.8	1
11	3011201100	bracket	1
12	S01004	screw M4x7.8	5
13	30122021	plug	1
14	3011201300	lever	1
15	30112015	scale plate	1
16	S01003	screw M4x12	2
17	30203019	spacer	2
18	20109005	stopper	2
19	301S11008	screw	2
20	W01006	washer 4	2
21	301S16004	nut	1
22	301S30007	screw	1
23	30128014	washer	1
24	301S11023	screw	1

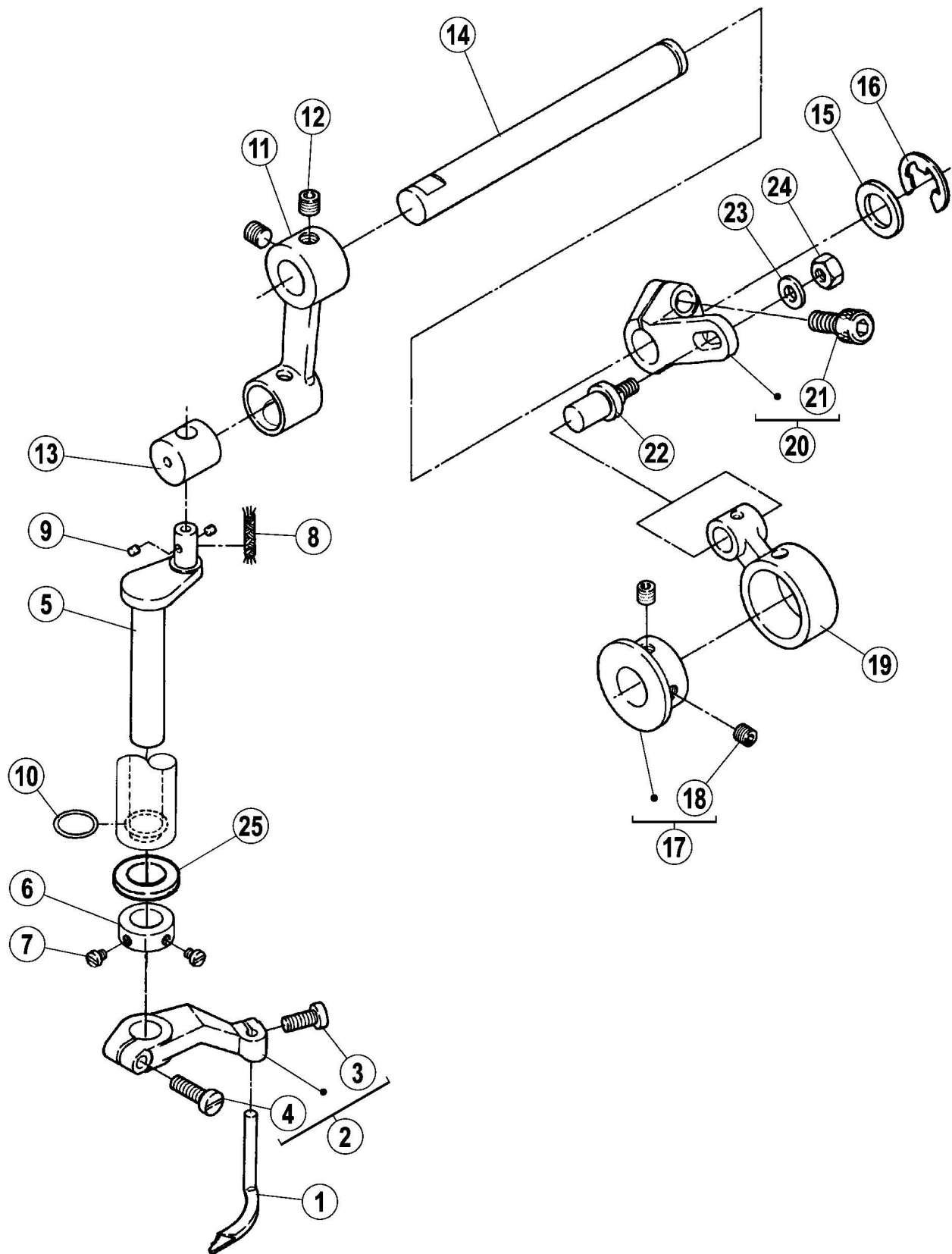
12. Presser Foot Components



12. Presser foot Components

No.	Parts No.	Description	QTY
1	301S30008	adjusting bar	1
2	301S16005	nut	1
3	30127006	spring	1
4	30104017	presser bar clamp	1
5	S01003	screw	1
6	30112016	link	1
7	301S20007	screw	2
8	3013002400	adjusting bar assy	1
9	3010901700	guide assy	1
10	S11025	screw	2
11	30127008	spring	1
12	30122022	oil guard	2
13	001006	o ring	1
14	30102020	presser bar	1
15	30112017	finger guard	1
16	S01006	screw	1
17	W01002	washer	1
18	XXXXXXXXXX	presser foot assy	1
19	301S11010	screw	1
20	30102021	lever	1
21	30127009	spring	1
22	30108005	ring	1
23	301S12001	screw	3
24	30108006	ring	1
25	30122023	plug	3
26	30104019	bell crank (upper)	1
27	301S11011	screw	1
28	30112018	link	1
29	301S20008	screw	2
30	30104020	bell crank (lower)	1
31	301S20013	screw	1
32	30102022	shaft	1
33	30112019	lever	1
34	S01011	screw	1
35	30112020	bracket	1
36	9111004	screw	2
37	S01016	screw	1
38	N01002	nut	1
39	30211006	guard / presser foot lift lever	1

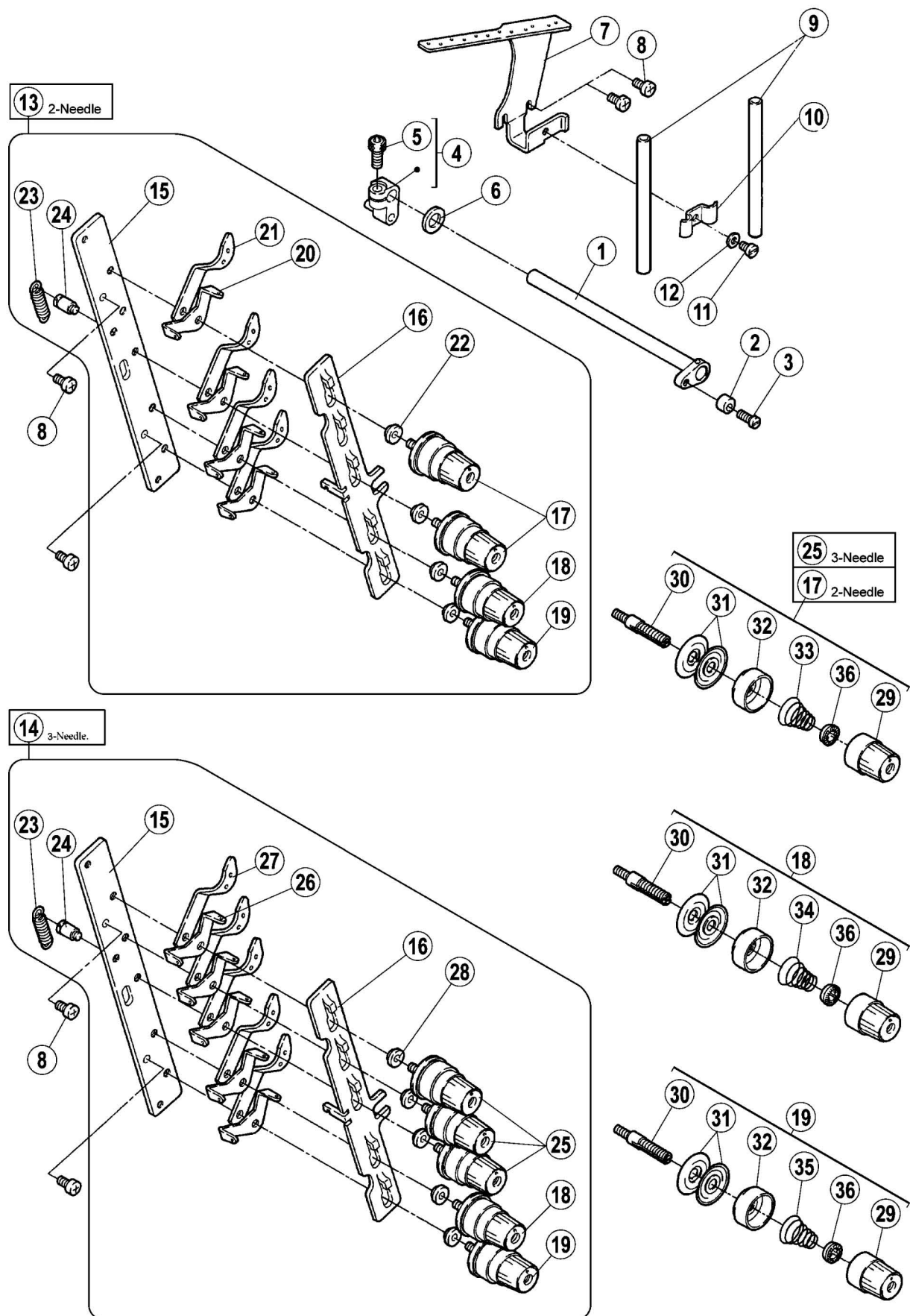
13. Spreader Components



13. Spreader Components

No.	Parts No.	Description	QTY
1	3011700900	Spreader	1
2	30104012	Spreader holder assy	1
3	S01004	screw M4x7.8	1
4	S05004	screw M5x14	1
5	W02001	scranksaft	1
6	S01014	collar	1
7	20622019	screw	1
8	30102014	oil wick	1
9	30110005	felt	1
10	S10006	o ring	3
11	3010500800	connection assy	1
12	S01008	screw M3 5x13	2
13	30109007	balance weight	1
14	S01009	shaft	2
15	30104010	washer	1
16	30128008	ring	1
17	30102013	eccentric assembly	1
18	30128032	screw	1
19	N01002	connection	1
20	30102015	crank	1
21	30128010	screw	1
22	30108002	screw	1
23	301S12001	washer	1
24	N01001	nut M4	2
25	30102012	shaft	1
26	H05001	ring 10	1

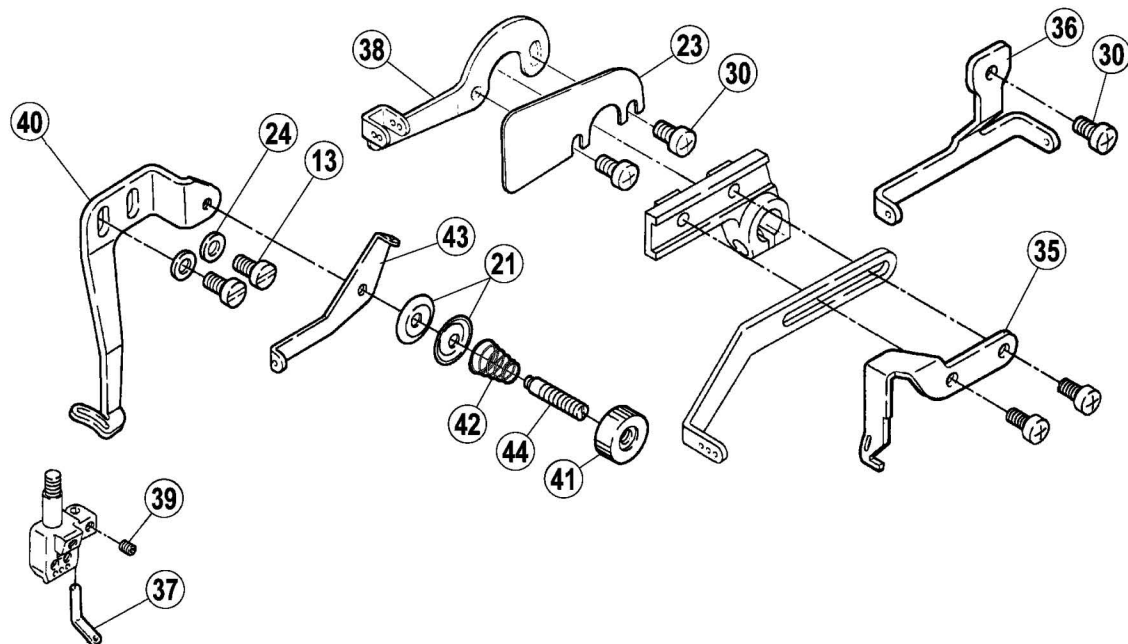
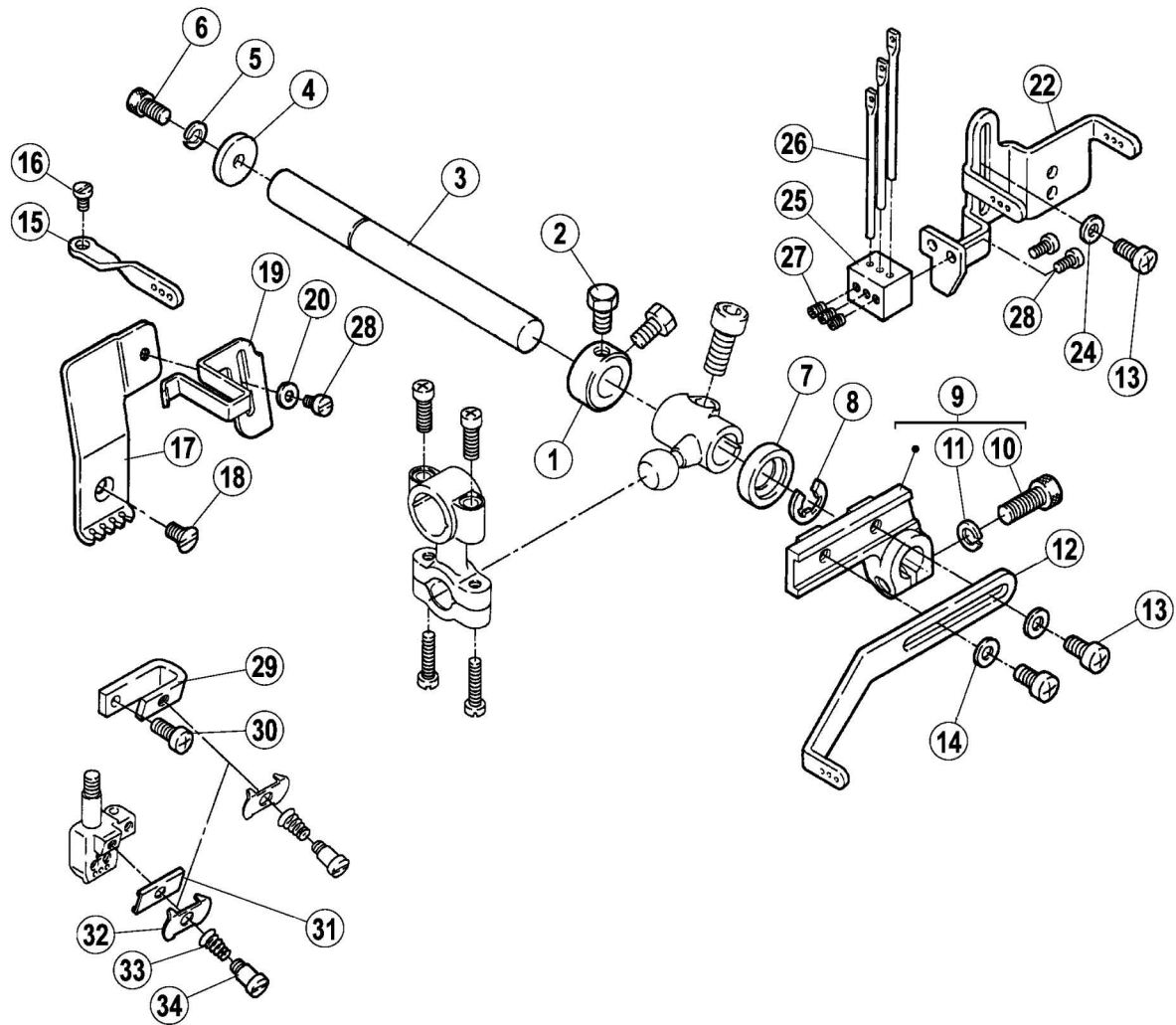
14. Thread Tension Components



14. Thread Tension Components

No.	Parts No.	Description	QTY
1	3010403200	lever	1
2	30103040	spacer	1
3	301S11013	screw	1
4	3010403100	crank	1
5	S05005	screw M5x12	1
6	W01010	washer 4	1
7	30113001	thread guide	1
8	S01004	screw M4x7.8	4
9	30102026	pipe	2
10	30112021	bracket	1
11	S01002	screw M4x6.5	1
12	W01001	washer 4	1
13	3011300300	tension control mechanism	1
14	3011300200	tension control mechanism	1
15	30113003	bracket	1
16	30112022	thread releaser	1
17	3011300400	tension spring assy (heavy)	2
18	3011300500	tension spring assy (medium)	1
19	3011300600	tension spring assy (light)	1
20	30113007	thread guide	4
21	30113008	thread guide	4
22	30103041	spacer	4
23	30127010	spring	1
24	301S30009	screw	1
25	3011300400	tension spring assy (heavy)	3
26	30113007	thread guide	5
27	30113008	thread guide	5
28	30103041	spacer	5
29	301S16006	knob	1
30	301S30010	screw stud	1
31	30128016	tension disc	2
32	30111005	spring shield	1
33	30127011	spring (heavy)	3
34	30127012	spring (medium)	1
35	30127013	spring (light)	1
36	30111006	ratchet	1

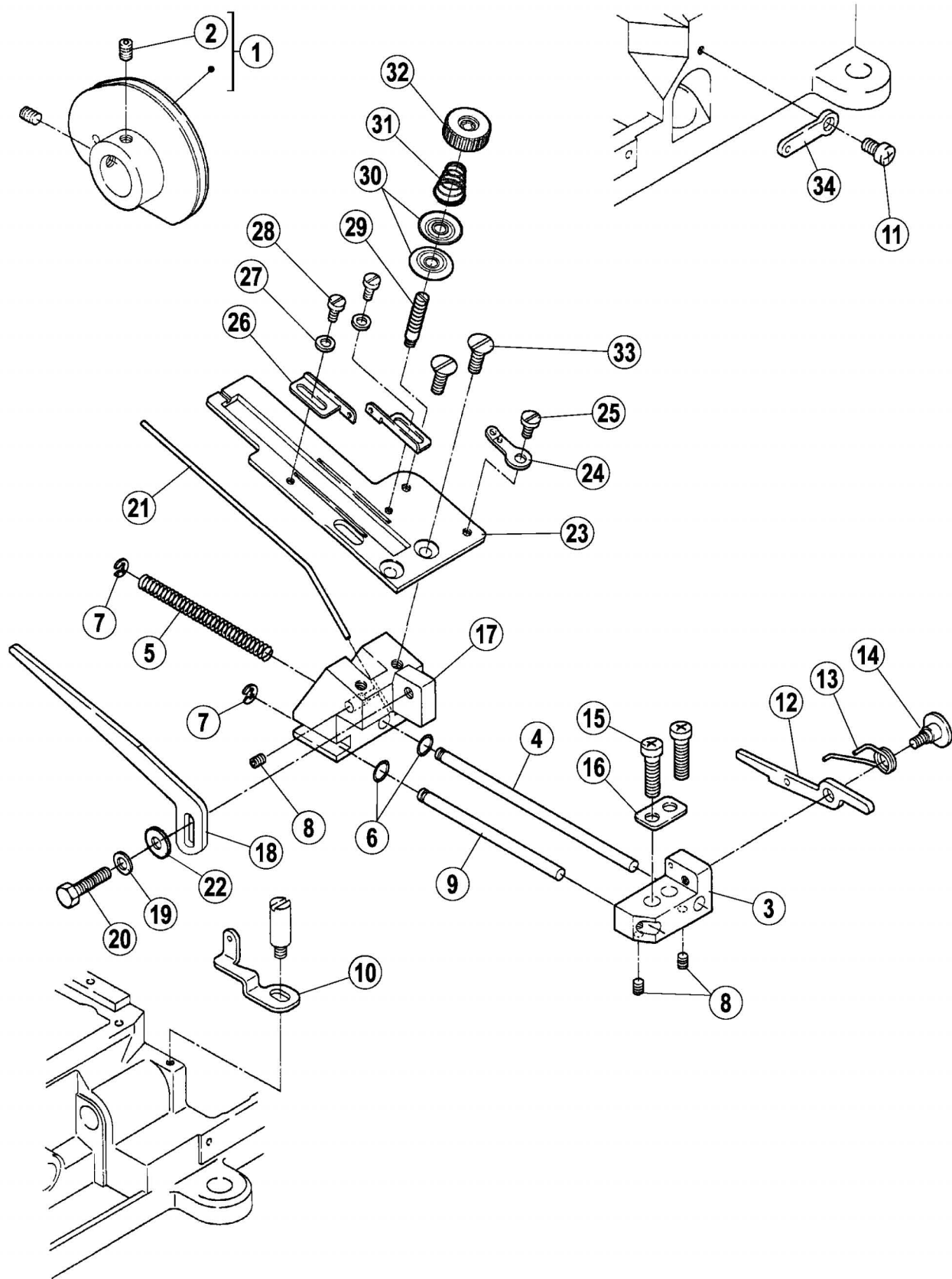
15. Needle, Spreader Thread Components



15. Needle, Spreader Thread Components

No.	Parts No.	Description	QTY
1	20608003	collar	1
2	301S12001	screw	2
3	30102028	shaft	1
4	30128019	washer	1
5	W02002	washer 4	1
6	S05048	screw M4x10	1
7	20622019	plug	1
8	H05001	ring 10	1
9	30101018	lever assy	1
10	S05004	screw M5x14	1
11	W02001	washer 4	1
12	30113009	thread take-up	1
13	S01004	screw M4x7.8	5
14	W01001	washer	2
15	30113010	thread guide	1
16	S01006	screw M3x45	1
17	30113011	thread guide	1
18	206S30016	screw	1
19	30112023	thread support	1
20	30128034	washer	1
21	20112033	tension disc	2
22	30H2027	thread guide	1
23	30H2086	guard / thread take-up lever	1
24	W01001	washer	3
25	30113012	holder	1
26	30113013	thread guide	3
27	S10001	screw M3x4	3
28	S01006	screw M3x45	2
29	30112024	thread tension bracket	1
30	S01001	screw M4x7	4
31	30112025	thread guide	1
32	30112026	thread retainer	1
33	30127014	spring	1
34	301S20009	screw	1
35	30112028	thread take-up	1
36	30112030	thread guide	1
37	30112033	thread guide	1
38	30112029	thread guide	1
39	S10005	screw M3x3	1
40	30112031	thread guide	1
41	301S16007	knob	1
42	30127016	spring	1
43	30112032	thread guide	1
44	301S30011	screw	1

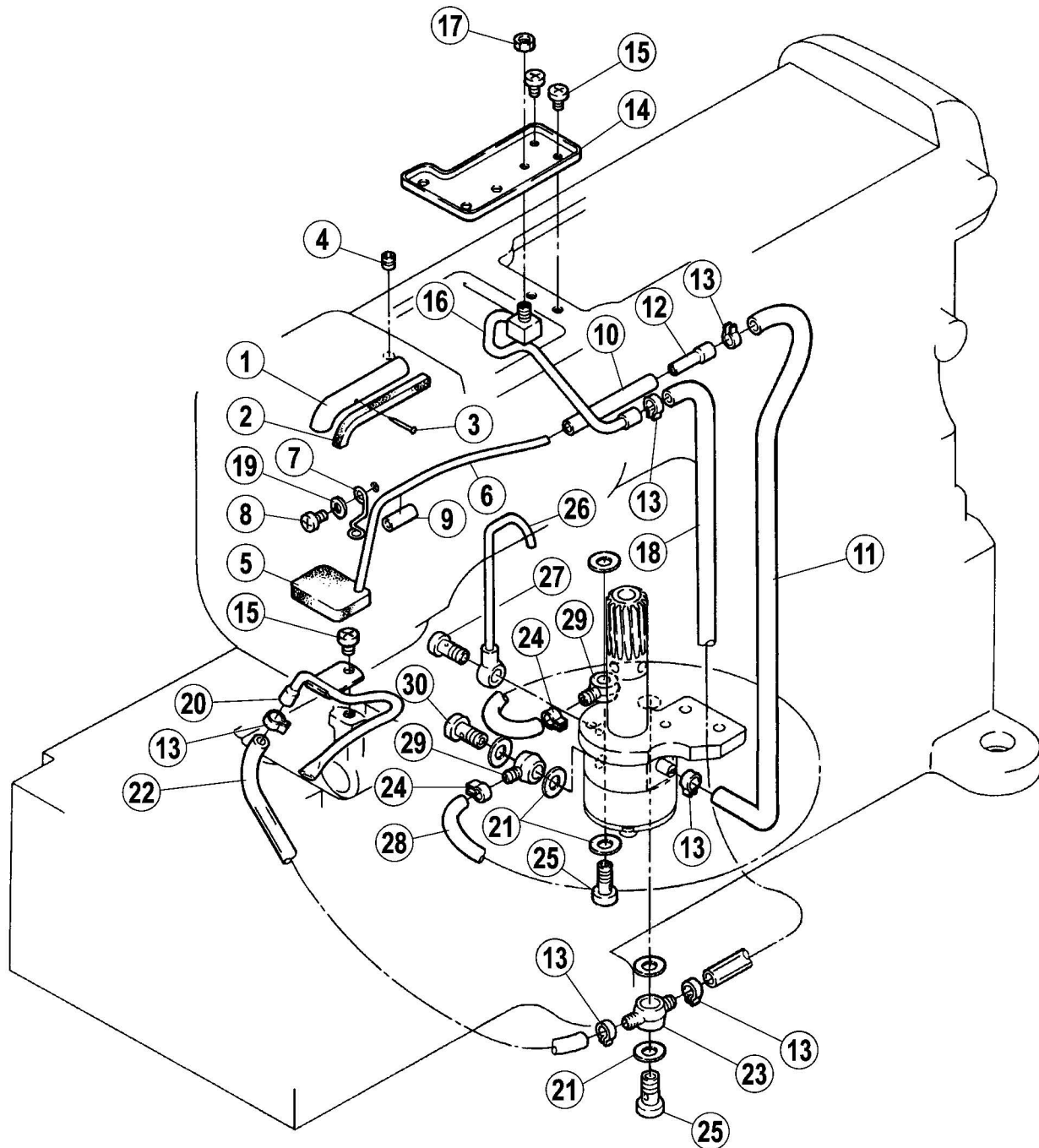
16. Looper Thread Cam Components



16. Looper Thread Cam Components

No.	Parts No.	Description	QTY
1	3011000800	thread take-up	1
2	S10002	screw M5x5	2
3	30101020	bracket	1
4	30102029	shaft	1
5	30127017	spring	1
6	001009	o ring 4.5x1.8	2
7	H05003	ring	2
8	S10005	screw M3x3	3
9	30102030	shaft	1
10	30113017	thread guide	1
11	S01001	screw M4x7	1
12	30112038	stopper	1
13	30127018	spring	1
14	301S20010	screw	1
15	S01007	screw M4x 13.5	2
16	30128023	washer	1
17	30101019	bracket	1
18	30112037	thread guide	1
19	W02002	washer	1
20	L02002	screw M4x10	1
21	30112036	thread support	1
22	30128019	washer	1
23	30112035	bracket	1
24	20613008	thread guide	1
25	301S11014	screw	1
26	30113014	thread guide	2
27	W01012	washer 2.5	2
28	S01012	screw M2.5x4	2
29	301S30011	screw	1
30	20112033	thread retainer	2
31	30127016	spring	1
32	301S16007	knob	1
33	S02001	screw M4	2
34	30113016	thread guide	1

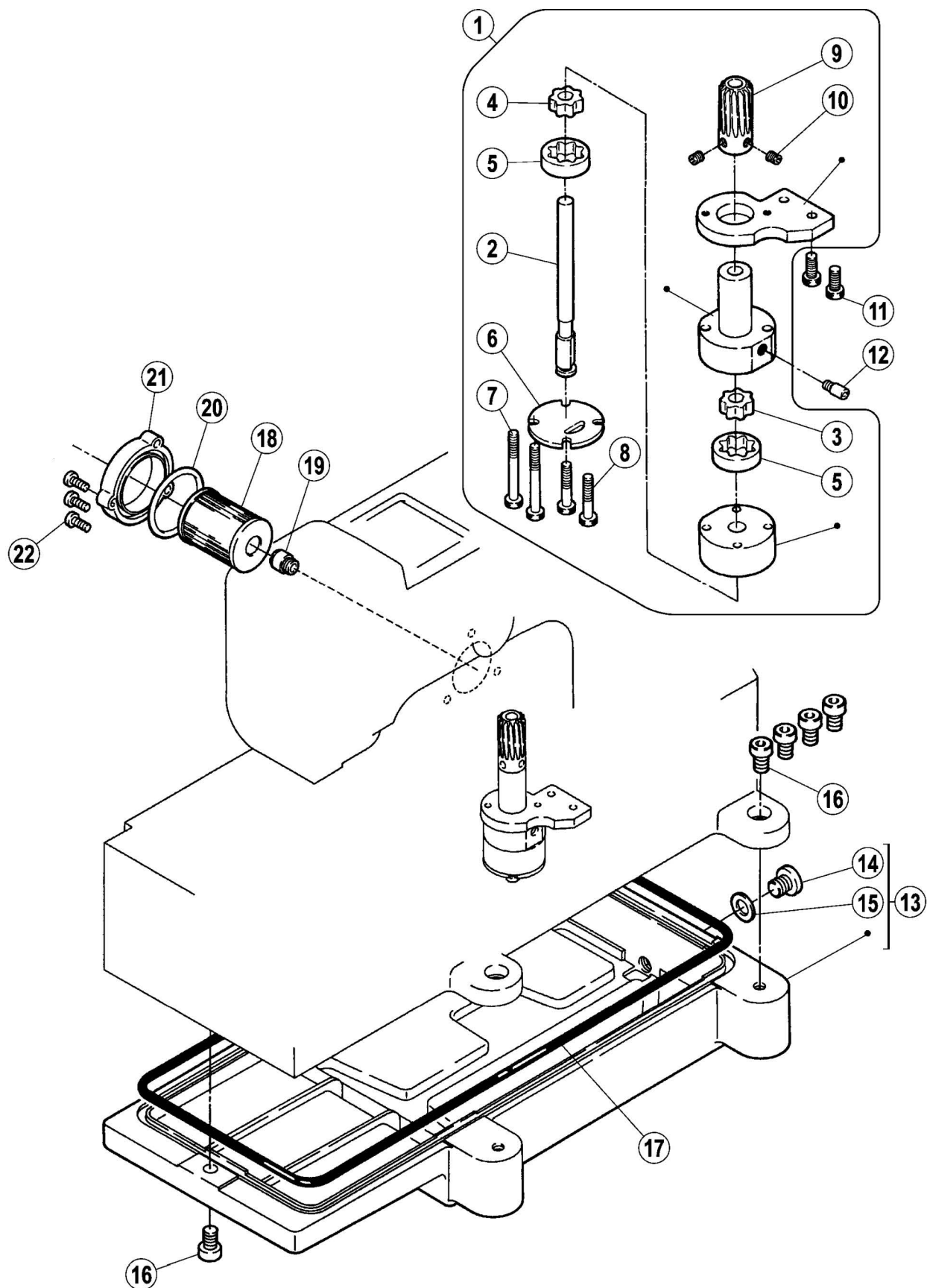
17. Lubrication Components



17. Lubrication Components

No.	Parts No.	Description	QTY
1	30121012	oil pipe	1
2	30123010	felt	1
3	30126008	pin	1
4	S10002	screw M5x5	1
5	30123009	felt	1
6	3012101400	pipe	1
7	30127019	latch	1
8	S01004	screw M4x7.8	1
9	30121007	tube	1
10	30121005	tube	1
11	30121018	tube $\Phi 4 \times \Phi 6$	1
12	30136002	joint	1
13	20129002	clamp	6
14	30112039	oil guard	1
15	S01002	screw M4x6.5	3
16	3012101500	oil distributor	1
17	N01001	nut	1
18	30121010	tube $\Phi 4 \times \Phi 6$	1
19	W01001	ring	1
20	30121009	oil distributor	1
21	20122033	washer	6
22	30121008	tube $\Phi 4 \times \Phi 6$	1
23	30136004	joint	1
24	30129006	clamp	2
25	301S30013	joint screw	2
26	30136003	pipe	1
27	301S30012	screw	1
28	30121017	tube $\Phi 5 \times \Phi 7$	1
29	30136001	joint	2
30	201S30004	joint screw	1

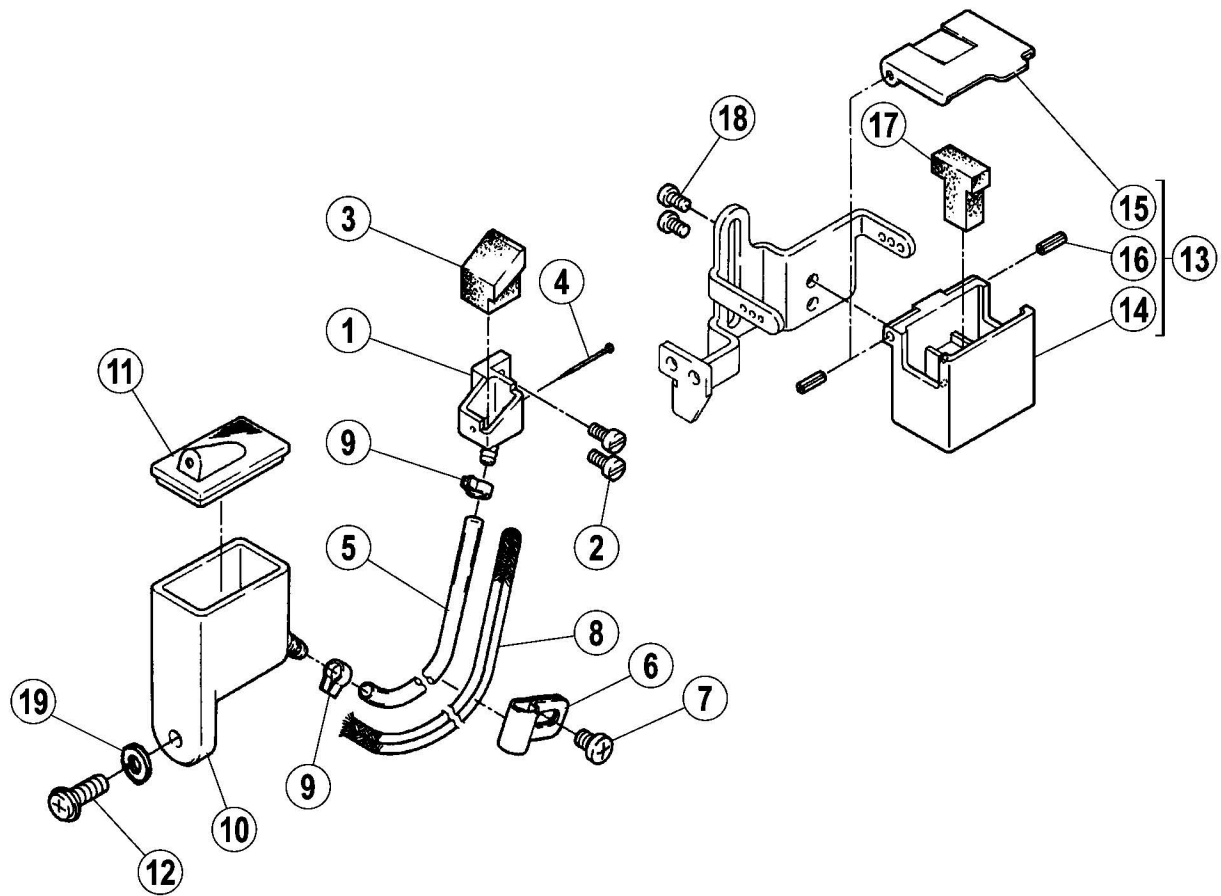
18. Oil Pump Components



18. Oil Pump Components

No.	Parts No.	Description	QTY
1	3012000190	oil pump assy	1
2	30102031	shaft	1
3	30120004	rotor	1
4	30120007	rotor	1
5	30120005	rotor	2
6	30120008	cover	1
7	301s20011	screw	2
8	S05006	screw M4x25	2
9	30125003	worm wheel	1
10	S10002	screw M5x5	2
11	S05004	screw M5x14	2
12	301S30014	joint screw	1
13	30101023	oil reservoir assy	1
14	301S11015	screw	1
15	20528014	washer	1
16	S05007	screw M8x20	5
17	30122025	o ring	1
18	20136001	filter element	1
19	301S30016	bracket / filter element	1
20	1010	o ring 38.7x3.55	1
21	300140	cover	1
22	S01003	screw M4x12	3

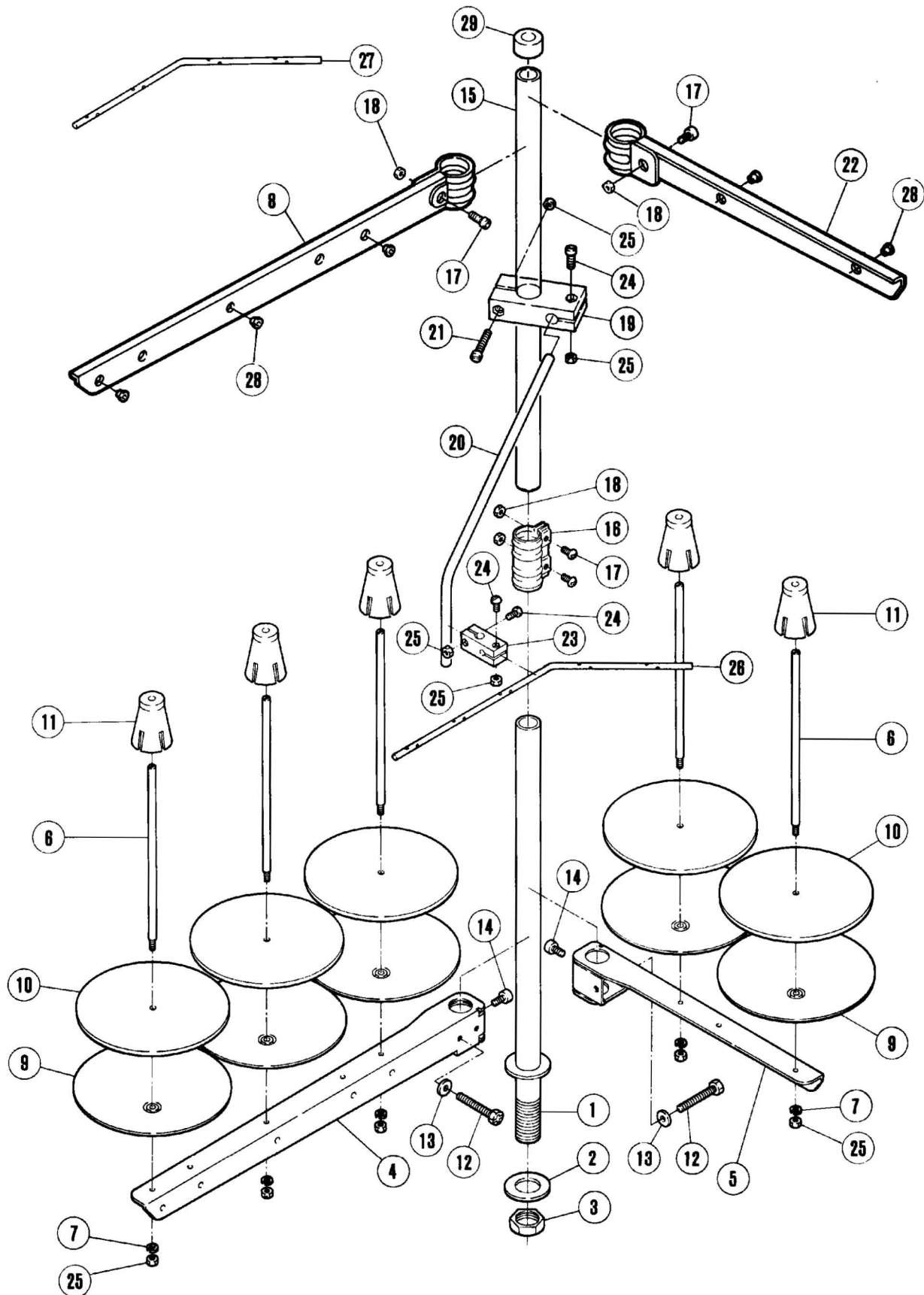
19. HR Device Components



19. HR Device Components

No.	Parts No.	Description	QTY
1	30101027	needle cooler (lower)	1
2	S01015	screw M3x5	2
3	30123012	felt	1
4	30126009	pin	1
5	30121017	tube $\Phi 5 \times \Phi 7$	1
6	30127020	bracket	1
7	S01004	screw M4x8	1
8	30123015	oil wick	1
9	30129006	clamp	2
10	30101026	silicone oil reservoir (lower)	1
11	30122026	cap	1
12	S01005	screw M4x10	1
13	3010102400	silicone oil reservoir (upper) assy	1
14	300141	silicone oil reservoir (upper)	1
15	30112040	cap	1
16	P03008	pin 2x6	2
17	30123011	felt	1
18	S01006	screw M3x4.5	2
19	W01001	washer	1

20. Thread Stand Components

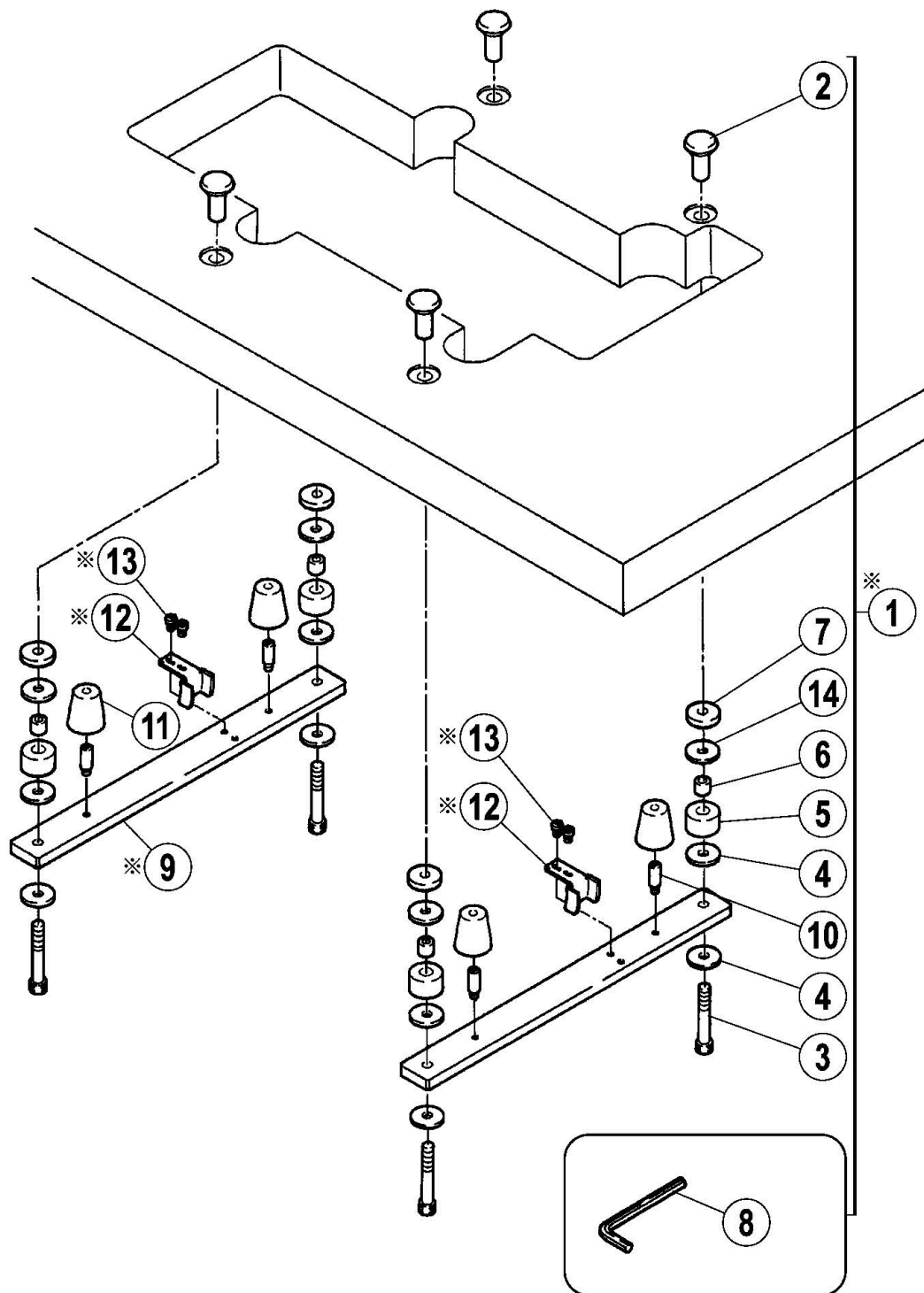


20. Thread Stand Components

No.	Parts No.	Description	QTY
1	30102032	thread bar (lower)	1
2	30128024	washer	2
3	N02001	nut	1
4	30101028	bracket (3 spool)	1
5	30101029	bracket (2-spool)	1
6	30102033	spool pin	5
7	W02002	washer	5
8	30101030	bracket (3-spool)	1
9	30111007	spool tray	5
10	30123014	cushion	5
11	30103044	spool holder	5
12	L02004	screw	2
13	W01003	washer	2
14	S04001	screw	2
15	30102034	thread bar (upper)	1
16	30129005	joint	1
17	S04002	screw	4
18	N01004	nut	4
19	30111008	bracket	1
20	30113018	thread guide bar	1
21	S04003	screw	1
22	30101031	bracket (2-spool)	1
23	30111009	holder	1
24	S04004	screw	3
25	N01005	nut	9
26	30113019	thread guide bar(5 spool)	1
27	30113034	thread guide bar (6 spool)	1
28	30103045	thread guide	5
29	30122027	rod cap	1

21. Machine Supporting Components

machine table mechanism (put in accessory)



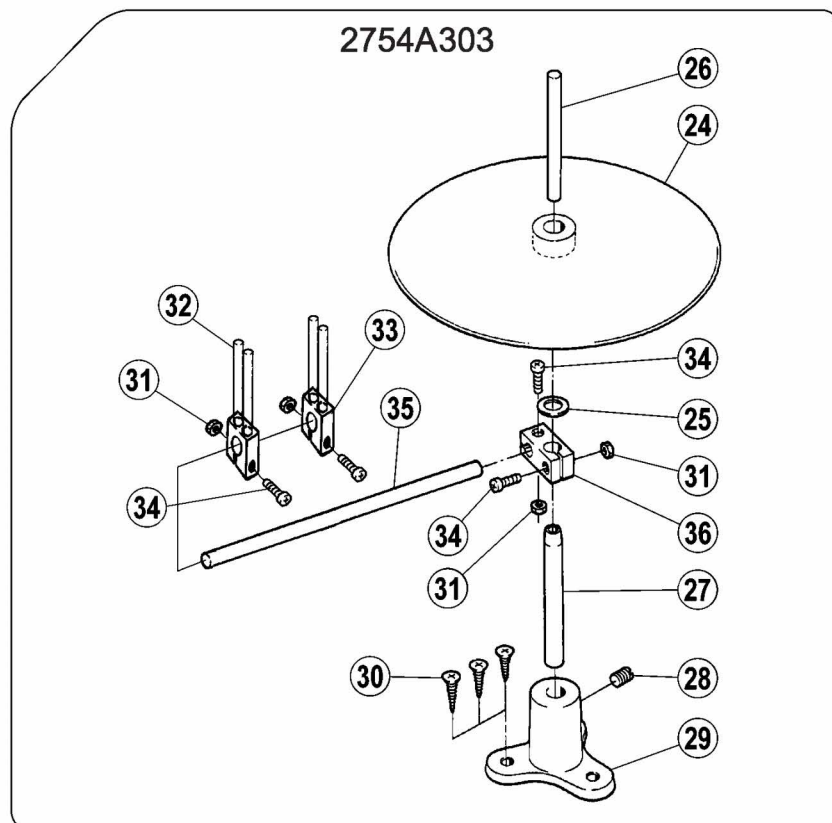
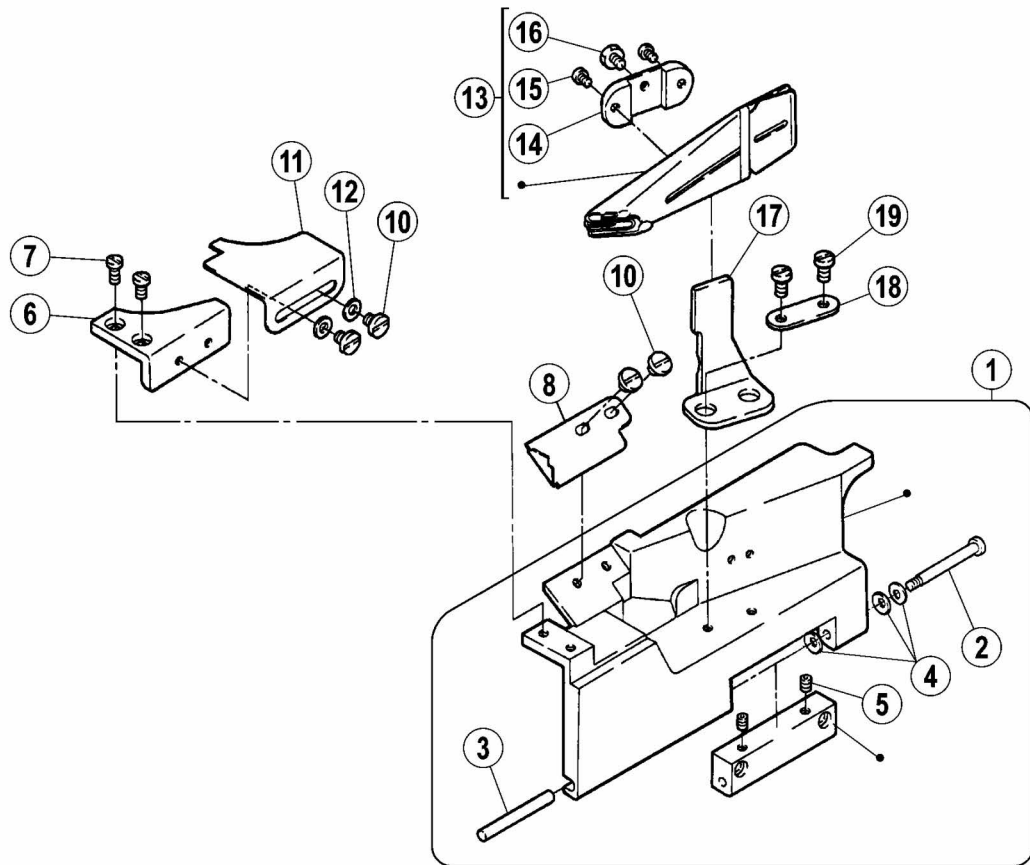
21. Machine Supporting Components

No.	Parts No.	Description	QTY
1	3010103200	screw (set)	1
2	301S16008	nut	4
3	301S30017	bolt	4
4	20131029	washer	8
5	20131030	rubber cushion	4
6	30103080	spacer	4
7	30122031	spacer	4
8	20131056	allen key / 6mm	1
9	30101032	supporting board	2
10	301S30018	screw	4
11	30122029	rubber cushion	4
12	30112041	treadle chain guide	2
13	S01011	screw	4
14	20131029	washer	8

22. Parts For 2754A311/313

No.	Parts No.	Description	QTY
1	301S11024	screw	2
2	W01001	washer	2
3	30112065	fabric guide	1
4	30112066	fabric guide	1
5	30109020	fabric guide	1
6	S01036	screw	2
7	30109021	fabric guide	1
8	W01009	washer	2
9	30112064	bracket	1
10	S01011	screw	2

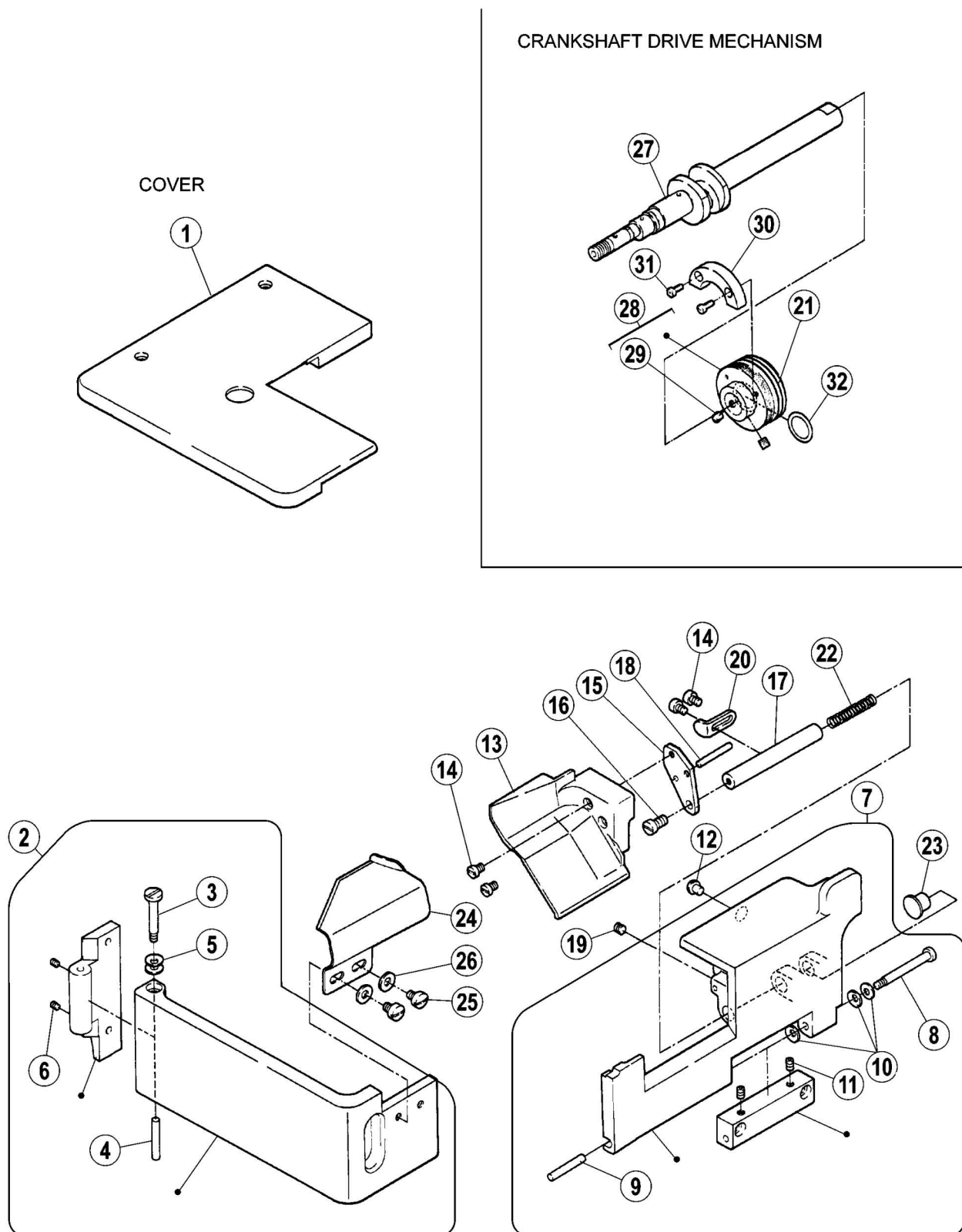
23. Parts For 2754A303



23. Parts For 2754A303

No.	Parts No.	Description	QTY
1	300202	front cover assy	1
2	301S20002	screw	1
3	301S20003	pin	1
4	30128002	spring	2
5	S10002	screw	2
6	300130	front cover (small)	1
7	S01011	screw	2
8	30112061	fabric guard	1
10	S01065	screw	4
11	30112060	auxiliary plate / front cover	1
12	W01004	washer	2
13	3011206800	bracket assy	1
14	30109019	bracket	1
15	301S11021	screw	2
16	L02009	bolt	1
17	30112062	bracket	1
18	30112063	washer	1
19	S01011	screw	2
24	30111019	tape disc	1
25	30128029	washer	1
26	30103060	tape disc post	1
27	30103061	tape disc post	1
28	S09002	scow	1
29	30101049	bracket	1
30	301S30020	screw	3
31	N01005	nut	4
32	30102048	tape disc post	4
33	30101050	holder	2
34	S04004	screw	4
35	30113023	guide post bar	1
36	30111020	bracket	1

24. Parts For 2754A309 (1)

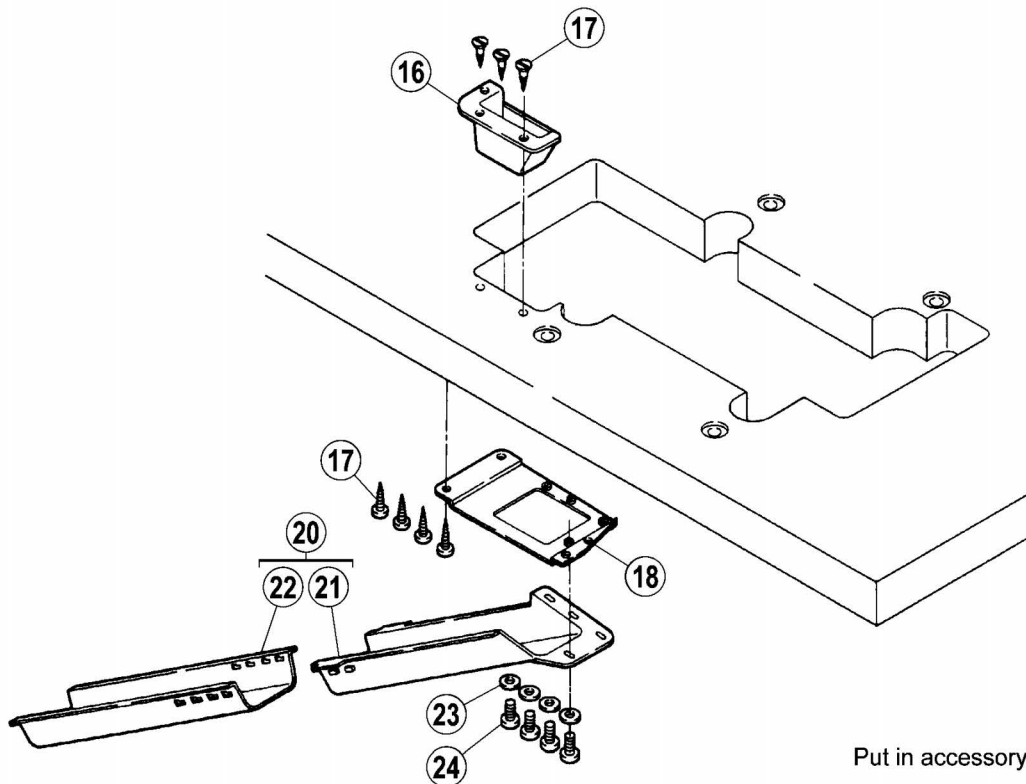
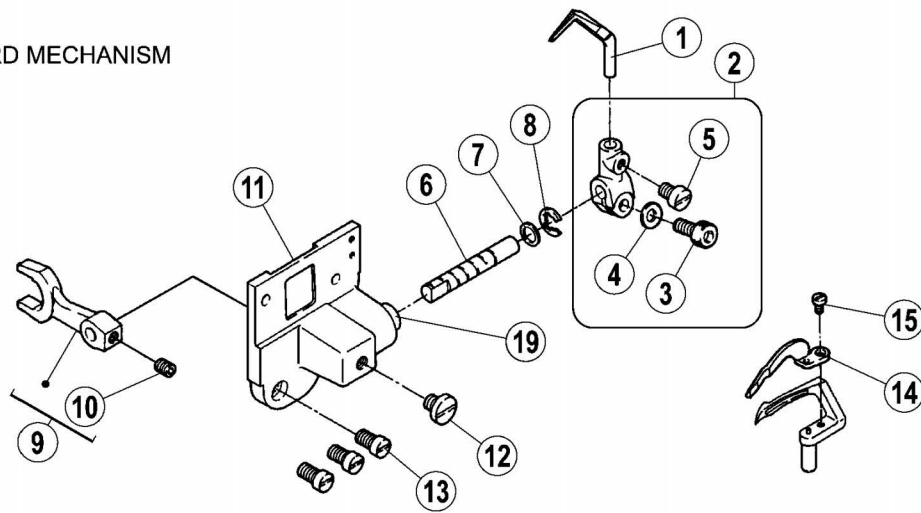


24. Parts For 2754A309 (1)

No.	Parts No.	Description	QTY
1	300471	bed cover (left)	1
2	300203	side cover assy	1
3	301S20004	screw	1
4	301S20005	pin	1
5	30128002	spring	2
6	S10001	screw M3x4	2
7	300142	front cover assy	1
8	301S20002	screw	1
9	301S20003	pin	1
10	30128002	spring	2
11	S10006	screw M5x6	2
12	30122015	cushon	1
13	30112045	front cover (small)	1
14	S01001	screw M4x7	4
15	30112046	bracket	1
16	S01011	screw M5x10	1
17	30102036	shaft	1
18	30126010	pin	1
19	S10002	screw M5x5	1
20	30112047	stopper	1
21	3012400300	bushing	1
22	30127024	spring	1
23	30122030	plug	1
24	30112044	fabric guide	1
26	W01004	washer	2
27	30102049	crankshaft assy	1
28	30103003	bushing	1
29	S10006	screw M5x6	2
30	30109002	balance weight	1
31	S01009	screw M3x7.5	2
32	001001	O ring 15x2.65	1

25. Parts For 2754A309 (2)

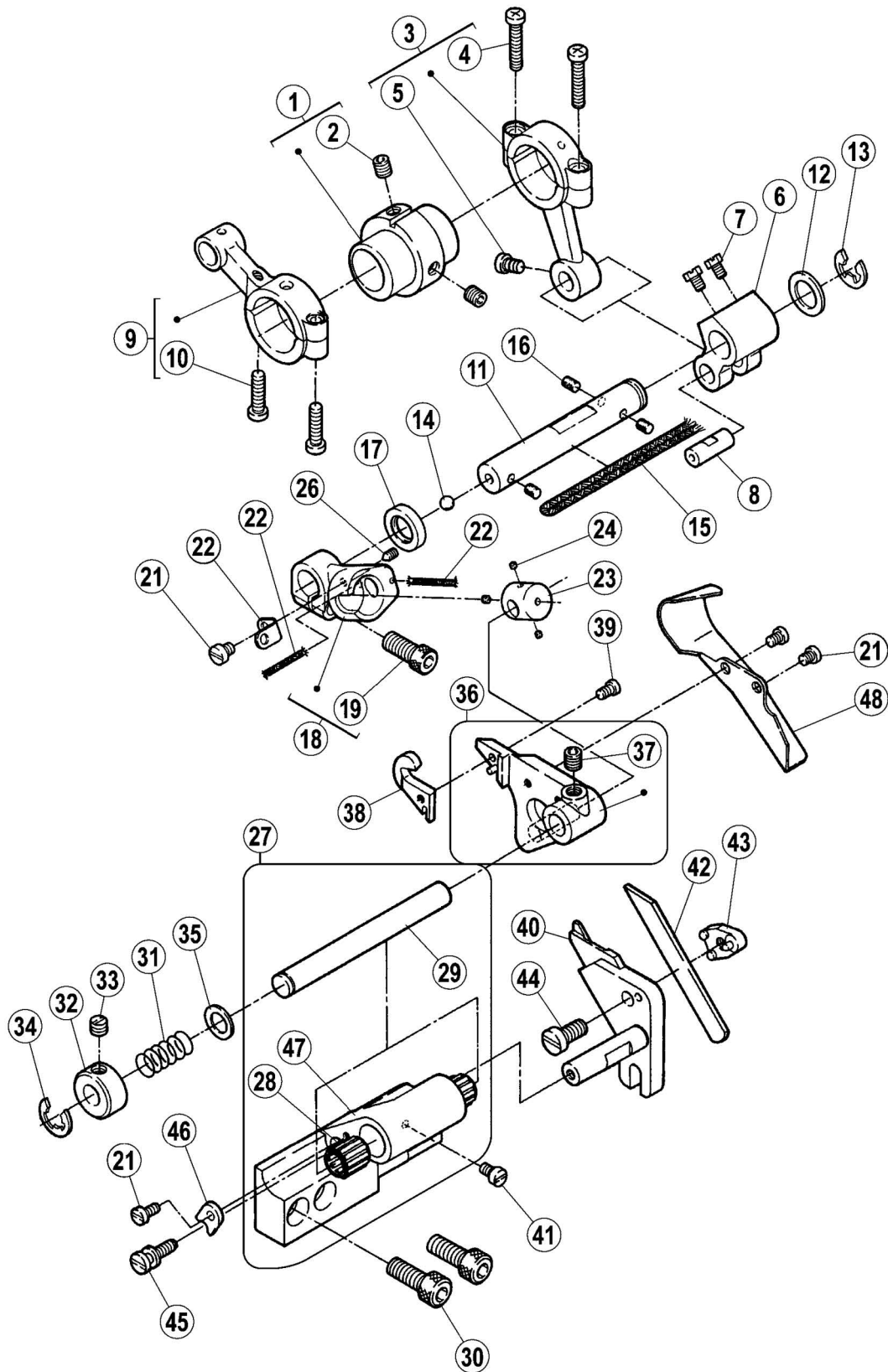
NEEDLE GUARD MECHANISM



25. Parts For 2754A309 (2)

No.	Parts No.	Description	QTY
1	30117002	needle guard (rear)	1
2	3011700600	lever assy	1
3	S05003	bolt M5x10	1
4	W02001	wiasher 5	1
5	S01002	screw M4x6.5	1
6	30102037	shaft	1
7	30128035	washer	1
8	H05013	ring 6	1
9	30106003	lever	1
10	S10002	screw M5x5	1
11	30101036	bracket	1
12	301S11016	screw	1
13	S01004	screw M4x7.8	3
14	30117003	needle guard (front)	1
15	S01012	screw M2.5x4	1
16	30111013	waste chute top (C)	1
17	301S30019	screw	7
18	30112048	bracket	1
19	30103046	bushing	1
20	3011101400	waste chute assy	1
21	30111014	waste chute top (A)	1
22	30111015	waste chute top (B)	1
23	30128036	washer	4
24	S01005	screw M4x10	4

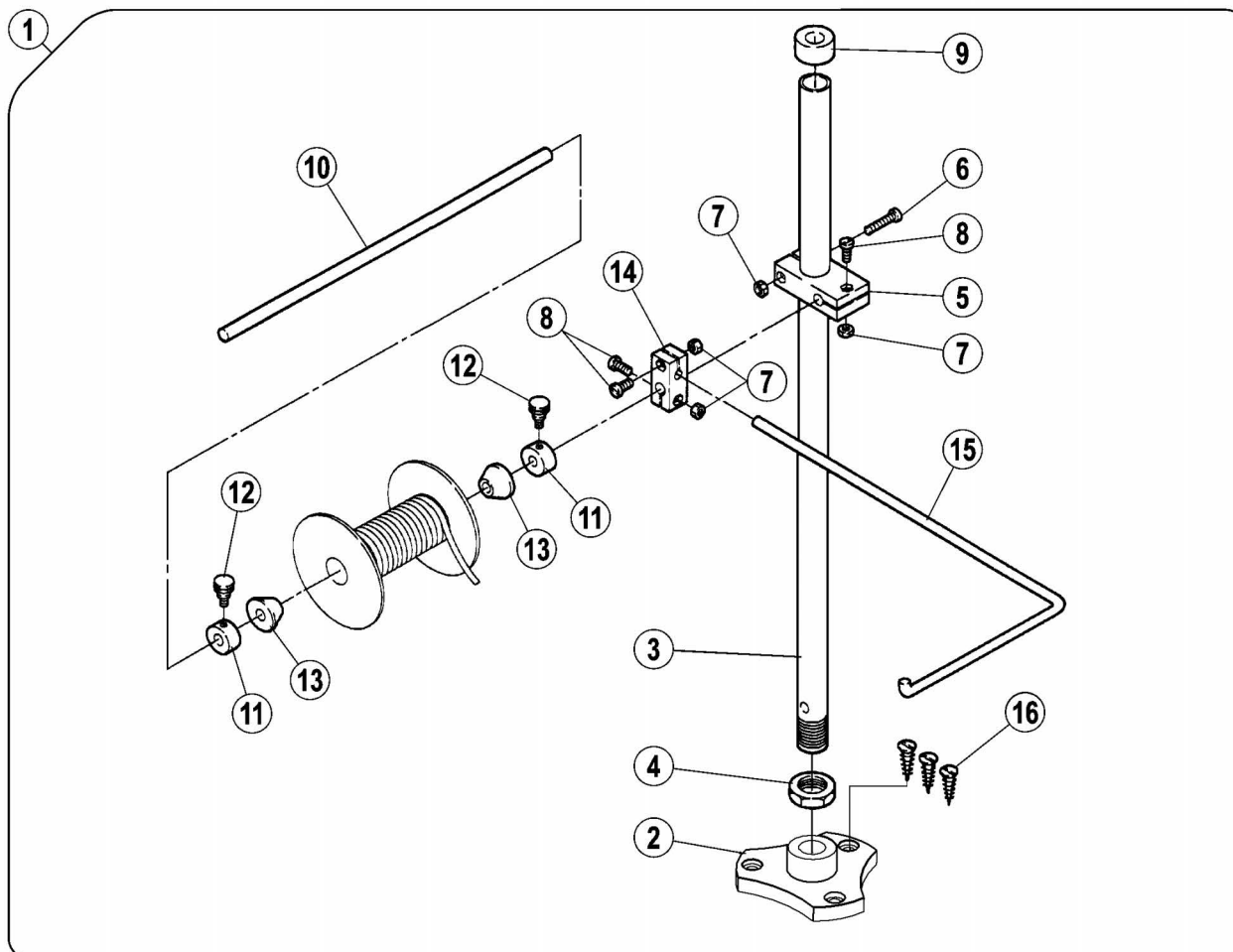
26. Parts For 2754A309 (3)



26. Parts For 2754A309 (3)

No.	Parts No.	Description	QTY
1	30110009	eccentric assy	1
2	S10006	screw M5x6	2
3	3010500600	ccnnection assy	1
4	S01008	screw M3.5x13	4
5	S01010	screw M4x8	1
6	30104007	crank	1
7	301S12001	screw	2
8	30126003	pin	1
9	30105009	connection assy	1
10	S01008	screw M3.5x13	2
11	30102038	shaft	1
12	30128008	washer	1
13	H05001	ring 10	1
14	30209009	ball	1
15	20523001	oil wick	1
16	30123001	felt	3
17	30122019	oil seal	1
18	30104028	lever assy	1
19	S05004	screw M5x14	1
21	S01006	screw M3x4.5	4
22	30123015	oil wick	2
23	30102039	block	1
24	30123008	felt	3
26	S12002	screw M3x4	1
27	3010104000	bracket assy	1
28	30103085	needle bearing	2
29	30102040	shaft	1
30	S05019	screw M6x16.3	2
31	30127022	spring	1
32	30108006	collar	1
33	209S14008	screw	1
34	H05013	ring	1
35	30128026	washer	1
36	30101037	upper knife lever assy	1
37	S10003	screw M6x0.75x5	1
38	30119001	upper knife	1
39	301S11017	screw	1
40	30101039	lower knife holder	1
41	301S11025	screw	1
42	30119002	lower knife	1
43	30101038	lower knife clamp	1
44	S01011	screw M5x10	1
45	301S30021	screw	1
46	30112051	guide	1
47	30101040	bracket assy	1
48	30112050	chip guard	1

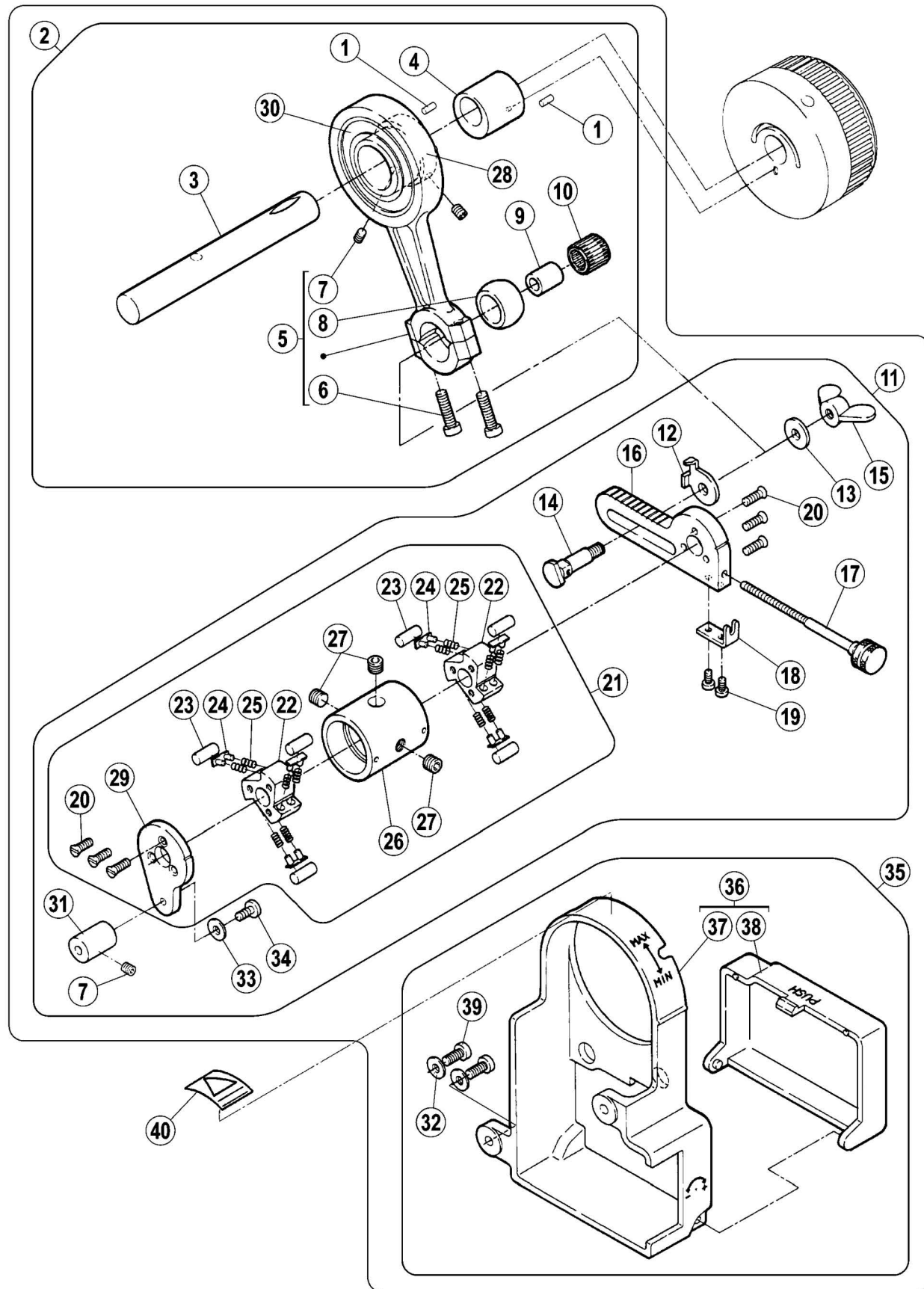
27. Parts For 2754A308/309 (1)



27. Parts For 2754A308/309 (1)

No.	Parts No.	Description	QTY
1	3010204100	reel stand assy	1
2	30103047	bracket	1
3	30102042	rod	1
4	N02001	nut M6x0.75	1
5	30111008	bracket	1
6	S04003	screw M4x25	1
7	N01005	nut M4	4
8	S04004	screw M4x15	3
9	30122027	rod cap	1
10	30102043	shaft	1
11	30103048	collar	2
12	S01068	screw M4x8	2
13	30103064	reel guide	2
14	30111009	bracket	1
15	30113020	rod	1
16	301S30022	screw	3

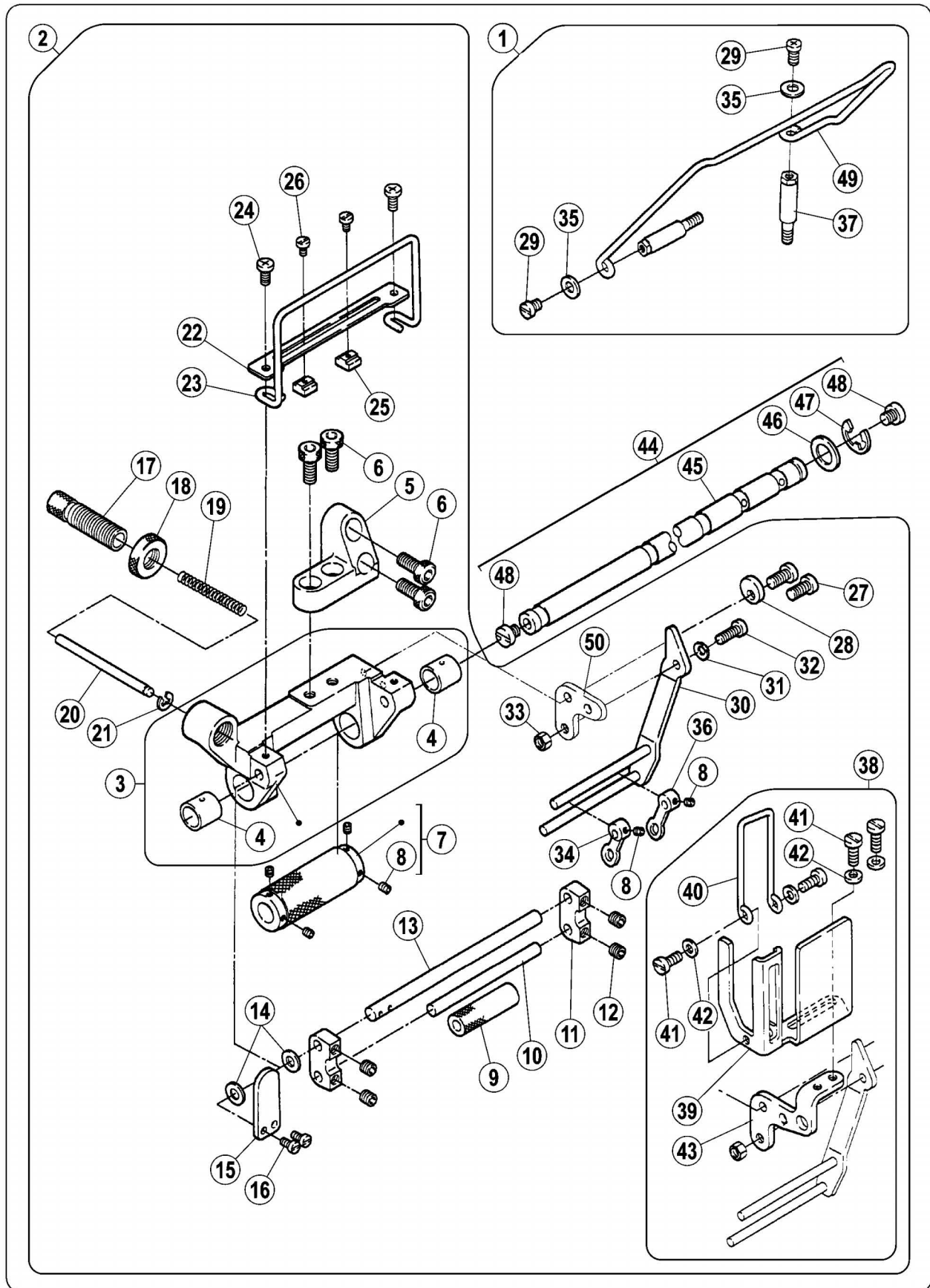
28. Parts For 2754A308/309 (2)



28. Parts For 2754A308/309 (2)

No.	Parts No.	Description	QTY
1	P03008	pin 2x6	2
2	3010501500	eccentric connection assy	1
3	30103049	shaft	1
4	30103050	eccentric assy	1
5	3010501900	connection assy	1
6	S04005	screw M4x15.5	2
7	S10002	screw M5x5	3
8	30103051	ball stud	1
9	30103052	bushing	1
10	B07014	needle bearing 10x13x13	1
11	3010104100	crank assy	1
12	30112052	indicator	1
13	30128027	washer	1
14	301S20012	pin	1
15	301S16009	butterfly nut	1
16	30101041	crank	1
17	301 S30023	screw	1
18	30112053	set plate	1
19	S01006	screw M3x5	2
20	301S11019	scrcw	6
21	3010305300	clutch assy	1
22	30101042	clutch	2
23	30126011	pin	6
24	30112054	guide assy	6
25	30127023	spring	12
26	30103053	sleeve	1
27	S10003	screw M6x0.75x5	3
28	30103054	bushing	1
29	30101043	stop plate	1
30	B04006	beadng 6028z	1
31	30126012	pin	1
32	W01001	washer 4	2
33	W01001	washer 4	1
34	201S11016	screw	1
35	3011101700	cover assy	1
36	3011101600	md cover assy	1
37	30111016	md cover	1
38	30111017	cover	1
39	S01005	screw M4x10	2
40	30137006	sticker	1

29. Parts For 2754A308/309 (3)

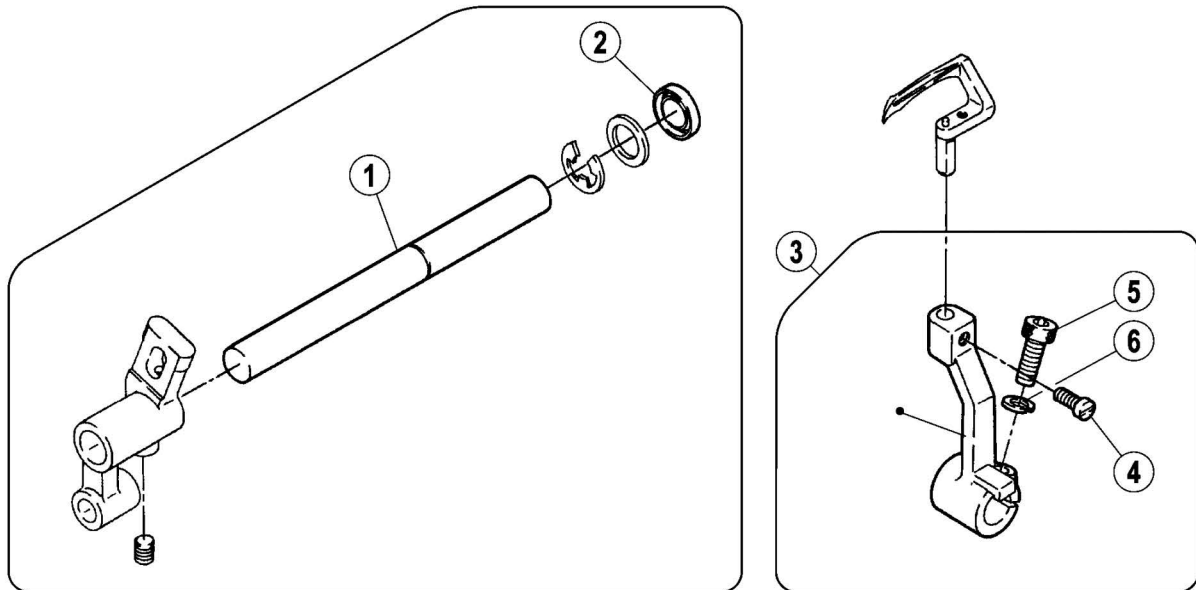


29. Parts For 2754A308/309 (3)

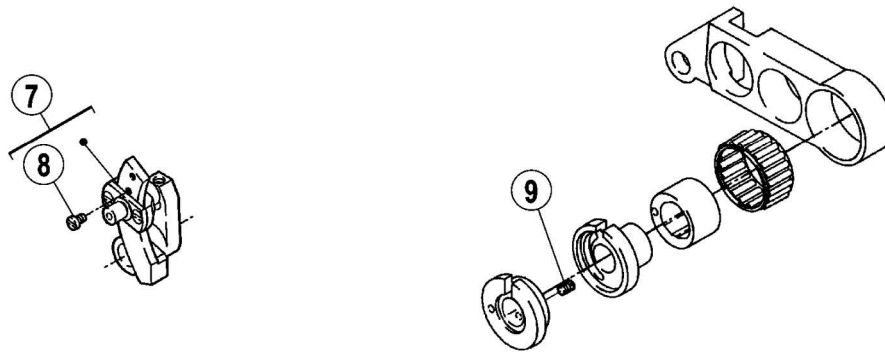
No.	Parts No.	Description	QTY
1	3010304400	lace guide assy	1
2	3010104500	elastic feed base assy	1
3	300144	bracket assy	1
4	30103055	bushing	2
5	300143	bracket	1
6	S05019	bolt M6x16.3	4
7	3010305700	roller assy	1
8	S10005	screw M3x3	6
9	30103059	roller	1
10	30102045	shaft	1
11	30109018	bracket	2
12	S10002	screw M5x5	4
13	30102046	shaft	1
14	W01003	washer 6	2
15	30112059	lever	1
16	S01015	screw M3x5	2
17	301S30027	screw	1
18	301S16011	nut	1
19	30127024	spring	1
20	30126013	shaft	1
21	H05003	ring 5	1
22	30112055	guide	1
23	30113022	lace guide	1
24	S01002	screw M4x6.5	2
25	301S16010	guide	2
26	301S11018	screw	2
27	S01004	screw M4x7.8	2
28	30128028	stopper	1
29	S01004	screw M4x7.8	2
30	3011205600	bracket	1
31	30128020	spring	1
32	S05049	bolt M4x10	1
33	N01001	nut M4	1
34	30105017	lace guide	1
35	W01004	washer	2
36	30105018	lace guide	1
37	301S30025	screw	2
38	3011208300	thread take-up guard assy	1
39	30112083	thread take-up guard	1
40	30112084	finger guard	1
41	S01001	screw M4x7	3
42	W01001	washer 4	3
43	30118087	bracket	1
44	3010304400	shaft assy	1
45	30103044	shaft	1
46	30128008	washer	1
47	H05001	ring 10	1
48	301S11020	screw	2
49	30113021	lace guide	1
50	30112058	bracket	1

30. Parts For 2754A300

LOOPER MECHANISM



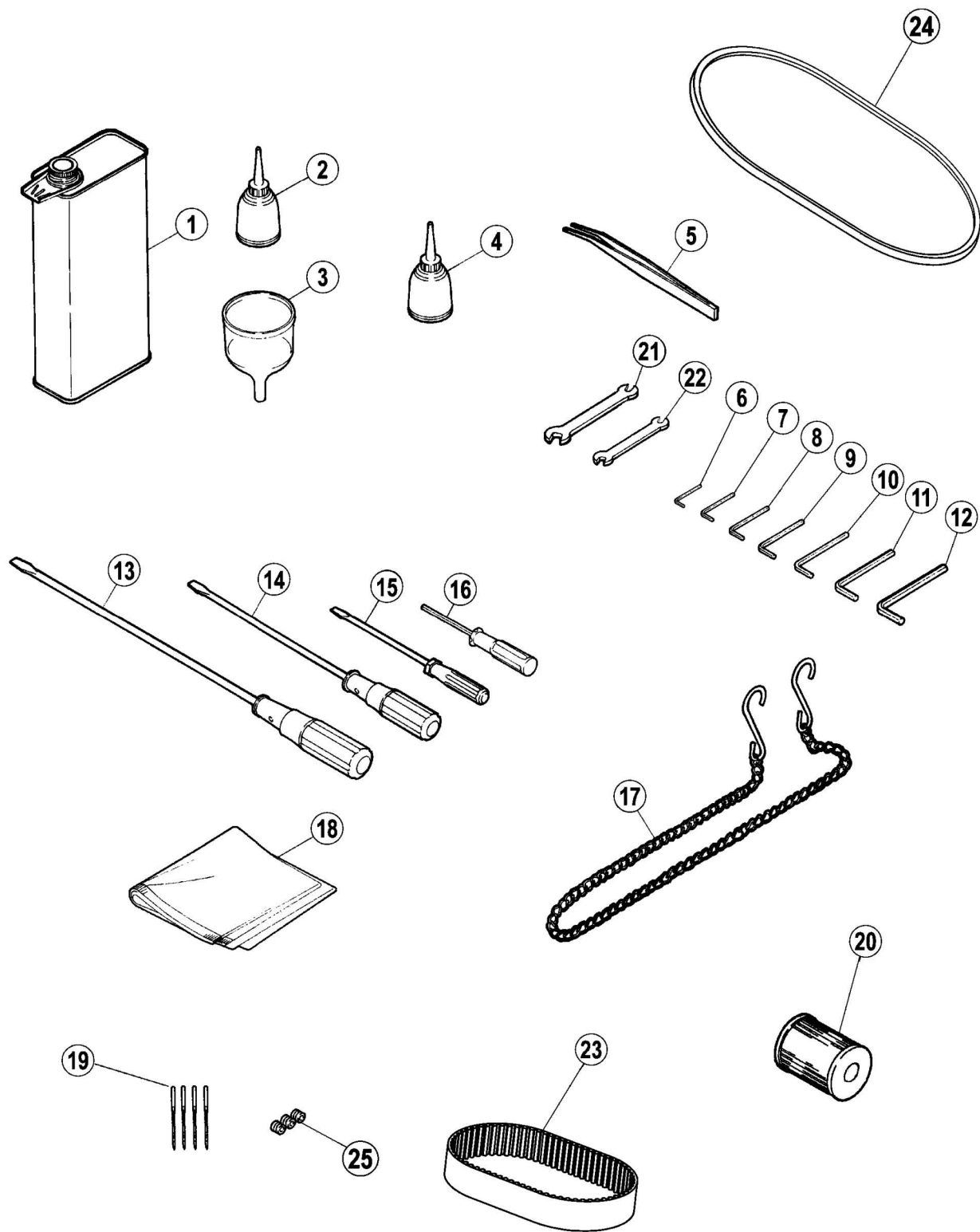
FEED MECHANISM



30. Parts For 2754A300

No.	Parts No.	Description	QTY
1	30102051	shaft	1
2	30122008	oil seal	1
3	30104012	looper holder assy	1
4	S01004	screw	1
5	S05004	screw	1
6	W02001	washer	1
7	30104014	crank	1
8	S01012	screw	1
9	301S30029	screw	1

31. Accessories Components



31. Accessories Comonents

No.	Paris No.	Description	QTY
1	20131037	oil container	1
2	20131038	oiler	1
3	20131039	oil funnel	1
4	20131038	silicone container	1
5	20131051	tweezers	1
6	30131007	allen key / 1.5mm	1
7	20131046	allen key / 2mm	1
8	30131010	allen key / 3mm	1
9	30131012	allen key / 4mm	1
10	20131047	allen key / 5mm	1
11	20131056	allen key / 6mm	1
12	30131009	allen koy / 8m	1
13	10131002	screwdriver (large)	1
14	10131003	screwdriver (medium)	1
15	10131004	screwdriver (small)	1
16	20131044	allen key driver (1.5mm)	1
17	30131018	chain	1
18	10131005	dust cover	1
19	30117001	needle	3
20	20136001	filter element	1
21	30131005	wrench / (7mm-9mm)	1
22	30131006	wrench / (8mm 10mm)	1
23	30135005	small timing belt	1
24	30135004	V-belt	1
25	S10005	screw	3

GAUGE PARTS LIST (1)



MACHINE TYPE /SPEC.	GAUGE	NEEDLE HOLDER	NEEDLE PLATE	MAIN FEED DOG	DIFF. FEED DOG	PRESSER FOOT	LOOPER	NEEDLE GUARD		SPREADER	NEEDLE
								FRONT	REAR		
2754A331	356	30134001	30115002	3011400700		3011601300	3011700900		30117002	30117005	3561-06-75/11
	364	30134002	30115003			3011601400					
2754A303	356	30134001	30115006	30114006	30114005	30116005	3011700900		30117002	30117005	3561-06-75/11
	364	30134002	30115007			30116006					

GAUGE PARTS LIST (2)



MACHINE TYPE /SPEC.	GAUGE	NEEDLE HOLDER	NEEDLE PLATE	MAIN FEED DOG	DIFF. FEED DOG	PRESSER FOOT	LOOPER	NEEDLE GUARD		SPREADER	NEEDLE
								FRONT	REAR		
2754A313	356	30134001	30115002	3011400700		3011601300	3011700900	30117002	30117005	3561-06-75/11	
	364	30134002	30115003			3011601400					
2754A309	356	30134001	30115004	30114004	30114003	30116003	3011700900	30117002	30117005	3561-06-75/11	
	364	30134002	30115005			30116004					
2754A308	356	30134001	30115002	3011400700		30116003	3011700900	30117002	30117005	3561-06-75/11	
	364	30134002	30115003			30116004					
2754A311	356	30134001	30115004	3011400700		3011601300	3011700900	30117002	30117005	3561-06-75/11	
	364	30134002	30115005			3011601300					
2754A300-0xxH	356	30134003	30115008	3011400700		30116007	3011700900	30117002	30117005	3561-06-75/11	
	364	30134005	30115011			30116017					