

IMPORTANT SAFETY INSTRUCTIONS

To get the most out of the many functions of this machine and operate it in safety, it is necessary to use this machine correctly.

Please read this instruction Manual carefully before use. We hope you will enjoy the use of your machine for a long time.

Please remember to keep this manual in a safe place.

1. Observe the basic safety measures, including, but not limited to the following ones, whenever you use the machine.
2. Read all the instructions, including, but not limited to this Instruction, Manual before before you use the machine, In addition, keep this Instruction, Manual so that you may read it at anytime when necessary.
3. Use the machine after it has been ascertained that it conforms with safety rules/standards valid in your country.
4. All safety devices must be in position when the machine is ready for work or in operation. The operation without the specified safety devices is not allowed.
5. This machine shall be operated by appropriately-trained operators.
6. For your personal protection, we recommend that you wear safety glasses.
7. For the following, turn off the power switch or disconnect the power plug of the machine from the receptacle.
 - 7-1 For threading needle (s).
 - 7-2 For replacing part (s) of needle, presser foot, throat plate, feed dog, cloth guide etc.
 - 7-3 For repair work,
 - 7-4 When leaving the working place or when the working place is unattended.
8. If you should allow oil, grease, etc. used with the machine and devices to come in contact with your eyes or skin or swallow any of such liquid by mistake, immediately wash the contacted areas and consult a medical doctor.

9. Tampering with the live parts and devices, regardless of whether the machine is powered, is prohibited.
10. Repair, remodeling and adjustment works must only be done by appropriately trained technicians or specially skilled personnel.
11. General maintenance and inspection works have to be done by appropriately trained personnel.
12. Repair and maintenance works of electrical components shall be conducted by qualified electric technicians or under the audit and guidance of specially skilled personnel.
13. Periodically clean the machine throughout the period of use.

14. Grounding the machine is always necessary for the normal operation of the machine.
The machine has to be operated in an environment that is free from strong noise sources such as high-frequency welder.
15. An appropriate power plug has to be attached to the machine by electric technicians,
Power plug has to be connected to a grounded receptacle.

16. The machine is only allowed to be used for the purpose intended. Other uses are not allowed,
17. Remodel or modify the machine in accordance with the safety rules/standards while taking all the effective safety measures. We assume no responsibility for damage caused by remodeling or modification of the machine.

18. Warning hints are marked with the two shown symbols.



Danger of injury to operator or service staff



Items requiring special attention

FOR SAFE OPERATLON



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.



1. To avoid personal injury, never operate the machine with any of the belt cover, finger guard of safety devices removed.
2. 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 operation. In addition, place nothing around them.
3. To avoid personal injury, never put your hand under the needle when you turn "ON" the power switch or operate the machine.
4. To avoid personal injury, never put your fingers into the thread take-up cover while the machine is in operation.
5. The looper 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 looper during operation. In addition, be sure to turn "OFF" the power to the machine when replacing the looper.
6. To avoid possible personal injuries. be careful not to allow your fingers in the machine when tilting/raising the machine head.
7. 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.
8. 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 start of the machine, be sure to turn "OFF" the power to the machine.
9. To avoid electrical shock hazards, never operate the sewing machine with the ground wire for the power supply removed.
10. 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.

BEFORE OPERATION

CAUTION:

To avoid malfunction and damage of the machine, confirm the following:

- Before you put the machine into operation for the first time after the set-up, clean it thoroughly.

Remove all dust gathering during transportation and oil it well.

- Confirm that the voltage has been correctly set.

Confirm that the power plug has been properly connected to the power supply.

- Never use the machine in the state where the voltage type is different from the designated one.
- Confirm that the direction of rotation of the motor pulley is correct.
- Operate your machine at the normal sewing speed or less for the first month after the wet-up.

1. Pre-start check

- 1) The machine shall not be started running until the completion of oiling.
- 2) The rotating direction of the balance wheel, when the machine is started running, shall be in counter-clockwise one. (View from the right side of the balance wheel.) A warning shall be given in advance against making the machine run while balance wheel turning clockwise.
- 3) The machine shall be under operation at less than 4,500 R.P.M. for the first month.
- 4) Check power source, voltage, and phase number to see whether they are in accordance with the ratings on the name plate of the motor to be used.

2. Operating instructions

- 1) Do not put your hands under the lower part of the needle when the machine is running.
- 2) Do not put your fingers into the thread take-up lever cover when the machine is running.
- 3) Only when the machine stops can you turn the balance wheel by hand.
- 4) After the motor switch being turned off, due to inertia, the motor will continue to rotate for a while. Be careful not to have the machine tilted unless it stops.
- 5) Keep away from the balance wheel, V-belt, winder and the motor.
- 6) Do not start running the machine during mounting or replacing the belt cover, finger guard, etc.

3. Specification

Stitch type	Three-needle double-row chain stitch
Speed	Max.4,500 r.p.m.
Needle	TVx7 #9 ~ #21
Stitch length	1.4 ~ 4mm
Stroke of needle bar	30mm
Gauges of double-row Chain stitch	1/8" 5/32" 3/16" 7/32" 1/4" 5/16" 3/8" 1/2"
Thread take-up type	Needle bar thread take up type
Looper	Separately adjustable type, for the range of 1/8" to 1/2"
Needle guard	Oscillating type and rigid type
Light clearance of knee lifter	8-10mm
Oil supply	Impeller-type pump
Lubricating oil	#2 white oil

4. Installation of the machine(Fig.1)

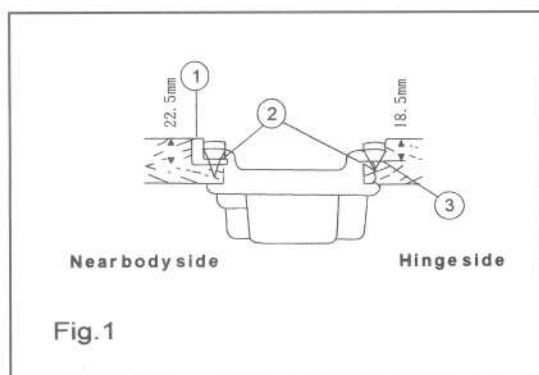


Fig.1

1. To install the oil reservoir:
Put the oil reservoir rubber cushion ① and oil reservoir felt cushion ③ on four corners of the opening of the table, fix them with the wood screws ②, then install the oil reservoir (Fig1).
2. Put the machine connecting hooks into the holes to engage respectively two hinges seated in the table, then place the machine on the four cushions.

5. Oiling

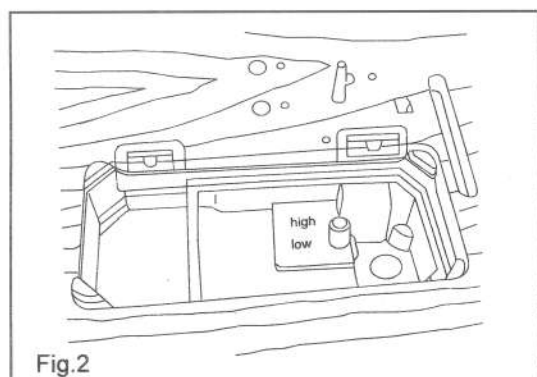
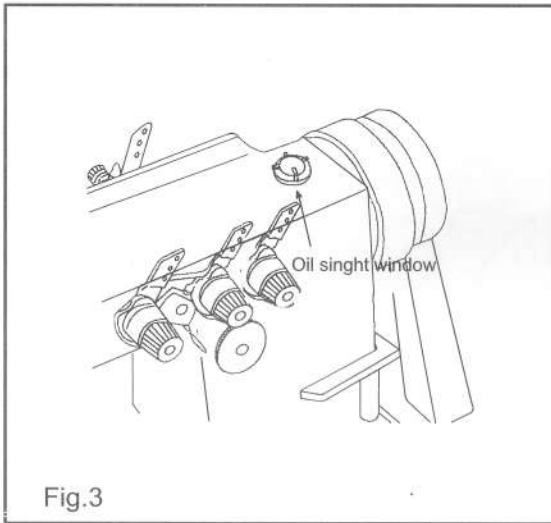


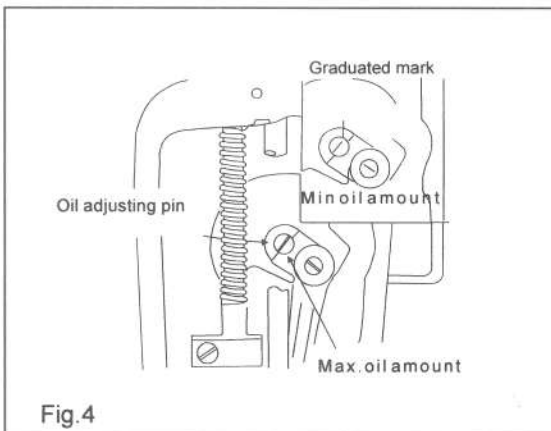
Fig.2

1. Oiling shall be made in oil reservoir and the oil surface also be made to level the mark "High" before the machine is started running (Fig.2).
2. Oiling shall be kept on until the oil surface has been brought above the mark "Low" (Fig3).



3. The normal condition of lubrication is that the oil shall spray onto the oil sight. The amount of oil spraying onto the oil sight is not at all proportional to the total amount of oil in the reservoir. There is nothing to worry about.
4. Only when the drain cover screw is loosened and taken off can old oil be drained out and new oil is supplied again.
5. When a new model or those standing idle for long time is to be operated, presser foot shall be lifted and run idle for about ten minutes.

6. How to regulate oil amount by means of manipulating elements on the face plate (Fig4)



To turn oil-amount adjusting pin to regulate oil amount of the thread take-up crank, min. oil amount will be supplied when the mark of adjusting pin moves to the thread take-up crank as near as you desire, Otherwise, max. oil amount will be supplied.

7. The threading of needle thread.

To thread the eyes of the needles in the order as shown in Fig.5:

- 1) To make thread go through the eye of the needle outwards,(View from the operator's side)
- 2) To pull out 100mm of the remaining thread after needle thread going through the eyes of the needles.

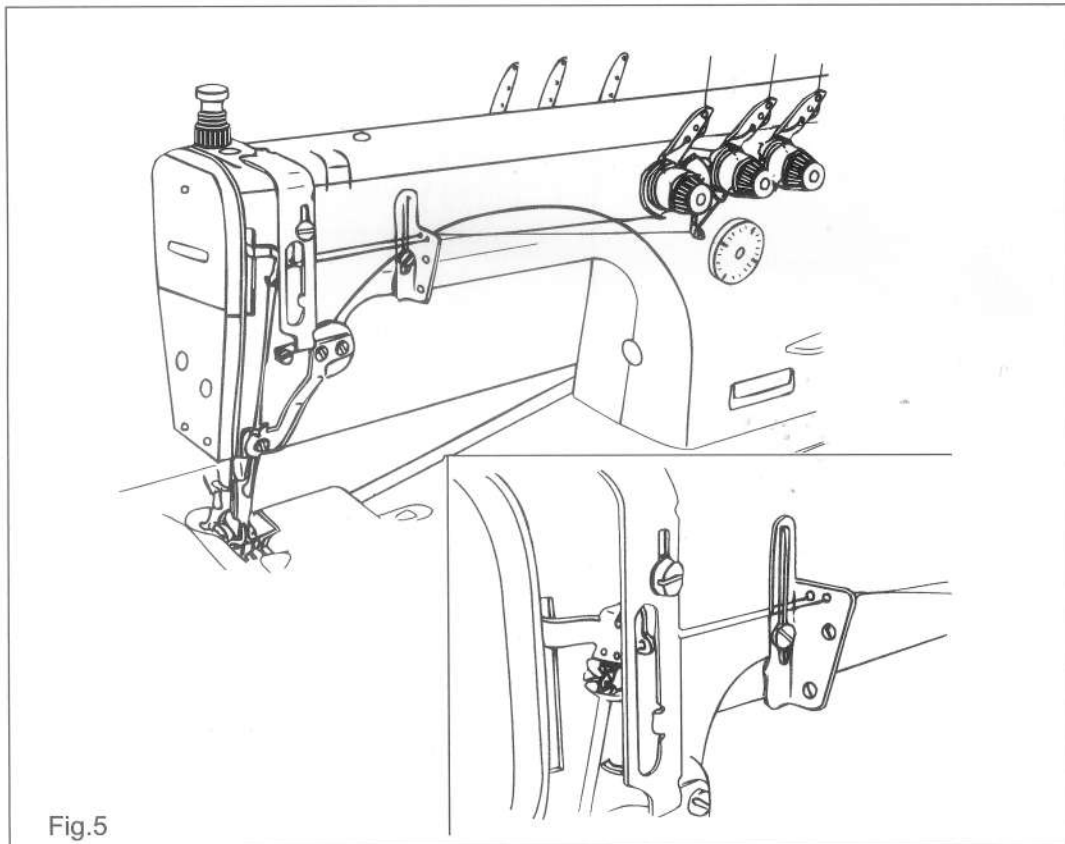
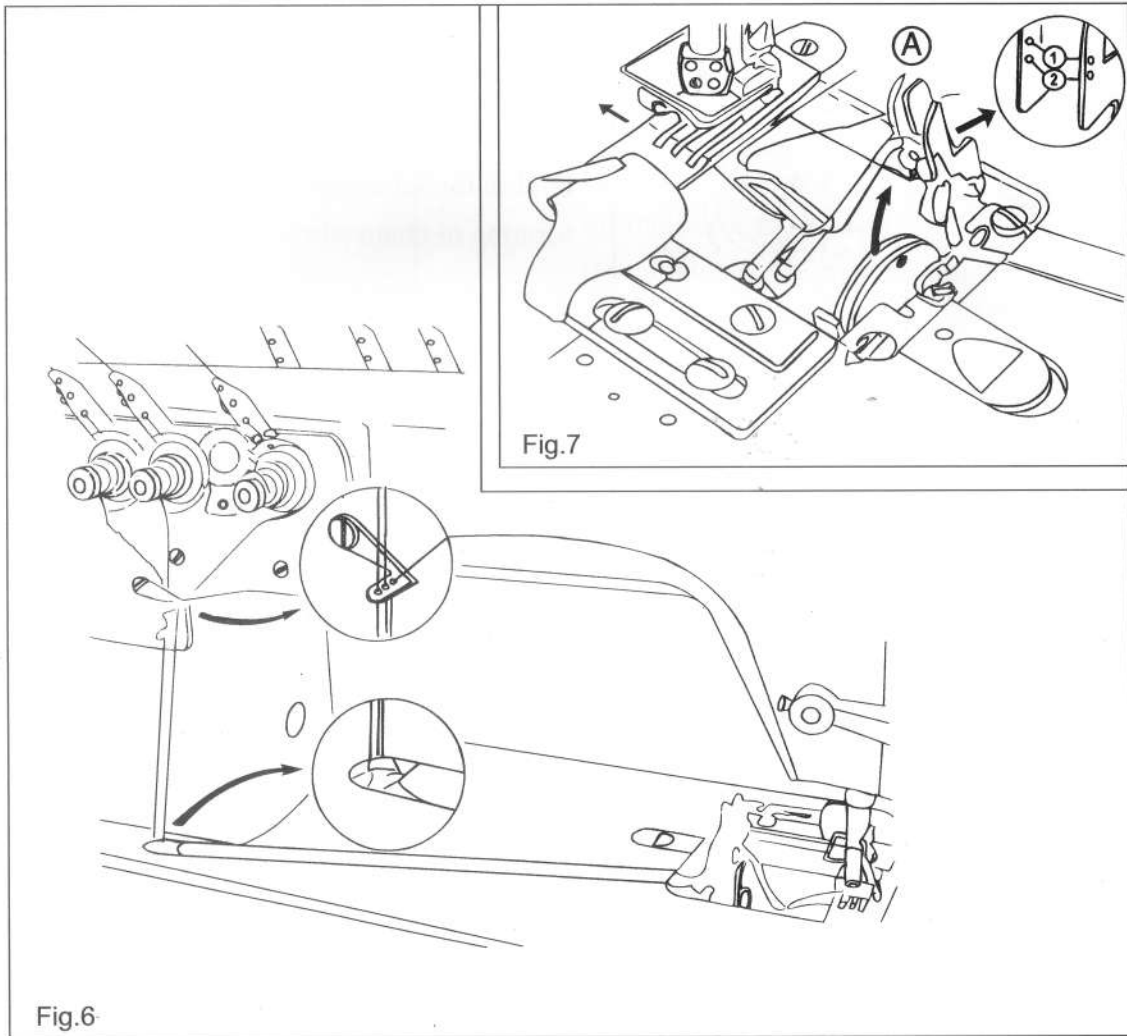


Fig.5

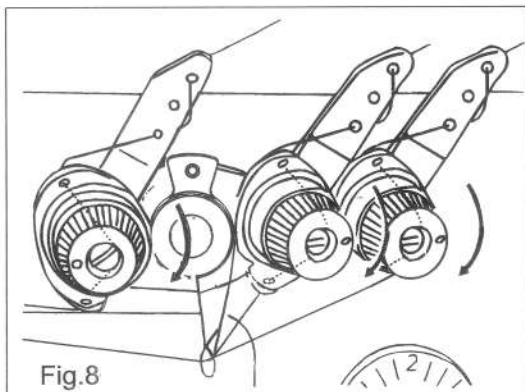
8. The threading of bobbin thread (Fig 6 and 7)

To make bobbin thread going through the eye of the needle in the order as shown in (Fig6 and 7)

- 1) Make the bobbin thread go through the tension guide plate; go through the two holes when thread of harder twist fibre is used and feed gauge is wider than Usual.
- 2) Pull the spring toward the operator, as shown in Fig.7 and part A will rise upwards.
- 3) When threading the looper, the thread shall be made go through the eye of the needle with a tweezer as shown in Fig.7 and 50mm of remaining thread be pulled out.



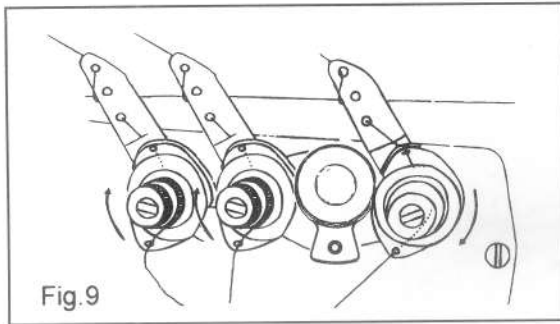
9. Thread tension asm.(Figs 8, 9and 10)



To adjust needle thread tension is accordance what sewing working condition, we can adjust needle thread tension by tension spring. Turn the tension nut clockwise to increase the tension; turn counter-clockwise to decrease the tension.

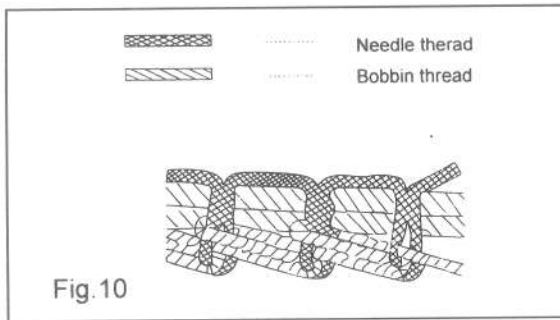
To adjust bobbin thread tension:

Turn tension screw clockwise to increase the tension; turn tension screw counterclockwise to

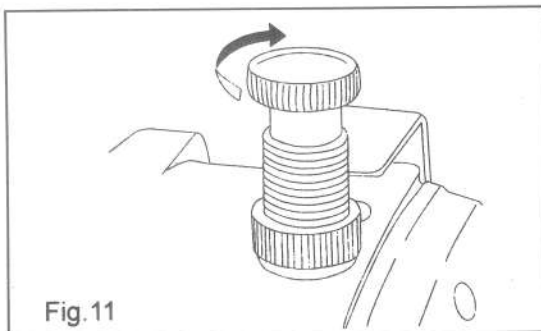


Tension: turn tension screw counterclockwise to decrease the tension.

The relation between the needle thread and the bobbin thread as shown in (Fig.10) depicts the forming of chain stitch.

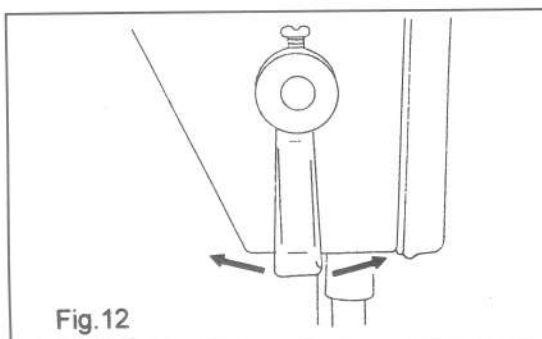


10. Presser foot (Fig.11 and 12)



Adjustment of pressure on presser foot (Fig.11)

Turn pressure regulating thumb screw clockwise to increase the pressure; turn pressure-regulating thumb screw counterclockwise to decrease the pressure. For general fabric the standard height of pressure regulating thumb screw is about 27-30mm (5kg) The presser bar lifter shall be turned either leftward or rightward in order to keep the presser foot under the condition of lifting position.



11. To adjust stitch length (Fig.13)

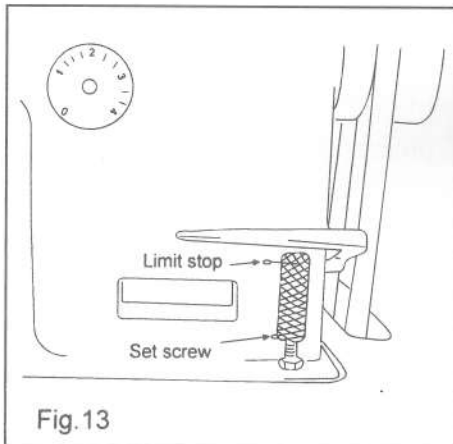


Fig.13

1. Turn feed regulating dial to the figure desired. The value of graduation is shown in millimetre(mm).
2. If you intend to change the stitch length. press down the reverse feed lever while turning the feed regulating dial.
3. Max., stitch length is 4mm: Min.stitch length is 1.4mm.
4. When reverse feed lever is pressed down. tight-needle stitch of 1.4 mm will be formed; this version of stitch is suitable for beginning and end seaming or partaking.
5. The machine can not make reverse stitching.

12 .Setting-up of the needle (Fig14 and15)

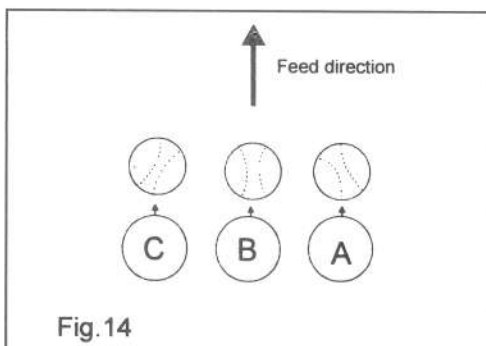


Fig.14

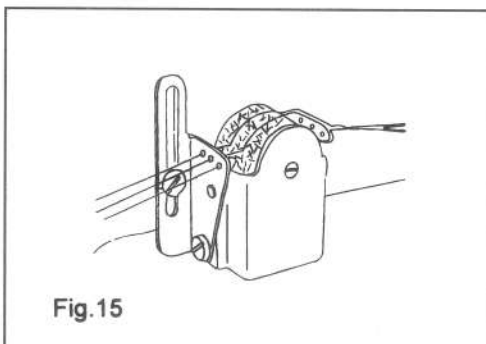
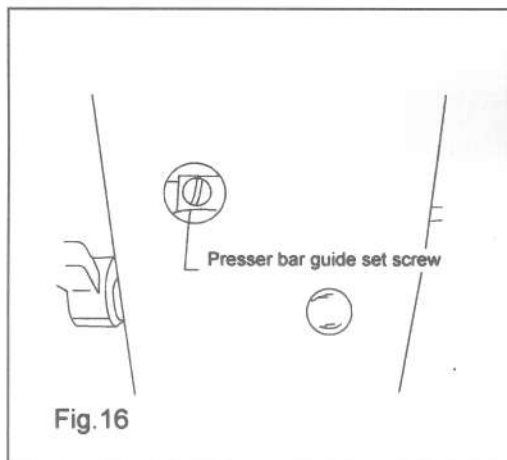


Fig.15

When tharead of chemical fibre is used, the direction of the needle eye shall not be in that one, as shown in part C of Fig. 14. Needle types to be desired fall within the range of #9 to #21 of TV X 7; Oil tank shall be custom-made when thread of chemical fibre is used; silicone oil can be placed like that, as indicated in Fig.15.

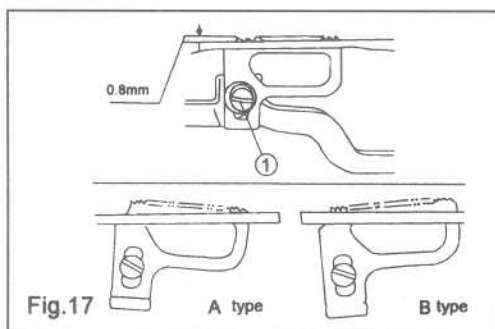
13. Adjustment of the neight of the presser bar:(Fig 16)



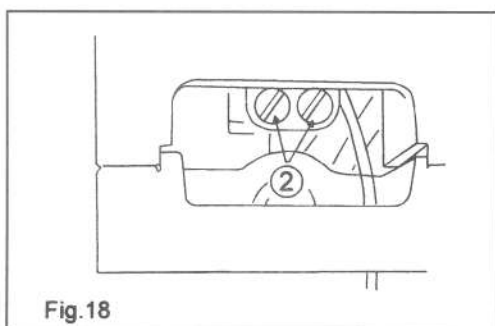
For the requirements of either replacing the presser foot or changing the height and angle of presser foot , the following shall be observed.

1. take off the rubber plug in the hole from the face plate, as shown in Fig.16.
2. Loosen the presser bar guide bracket set screw.
3. After adjusting, retighten the screw.

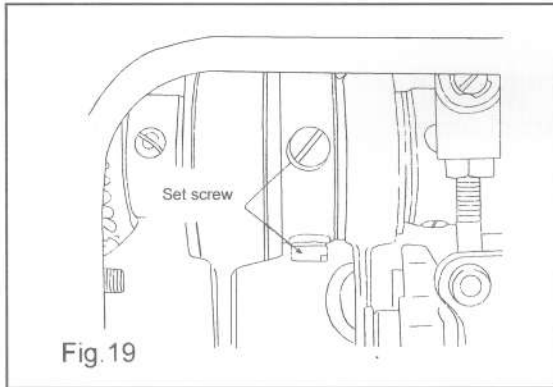
14. Adjustment of the neight of the feed dog (Figs17 and 18)



Loosen the set screw ② as shown in Fig.18, the angle of the feed dog can be adjusted to the specified one of standard version **A** version. and **B** version. The Max. height of 0.8mm of the projection from dog is adjustable by the adjusting of screw ① as shown in Fig.17.

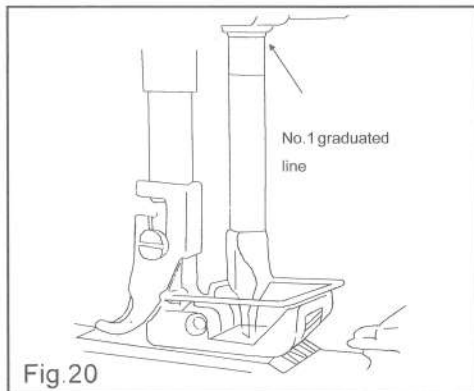


15. The timing of feed dog and needle:(Fig.19)



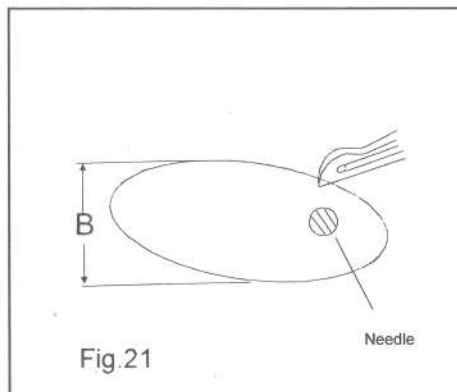
When the point of needle lowering down to the location of 3mm from the upper surface of the throat plate, the feed dog is right at the position below the upper surface of the throat plate. viz. The running of feed dog being well regulated in relation to the motion of needle.

16. Adjustment of the height of needle bar:(Fig20)



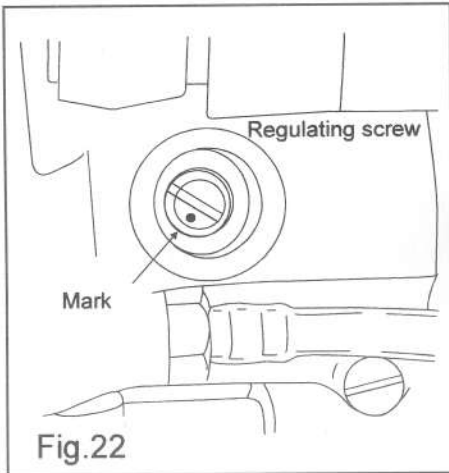
When the needle of TV X 7 is used, if the graduation on the needle bar is at the bottom dead centre, the mark of graduation shall be in line with the lower end of the needle bar bushing, lower, as indicated in Fig20.

17. Adjustment of the needle and looper (Fig 21 and 22)



Adjustment of forward & backward motion of the looper: The dimension of part **B** of the looper in an elliptical motion can be measured, (refer to Fig21). The max dimension of part B is usually 3.7mm. suitable for sewing operation of needles of all kinds of sizes.

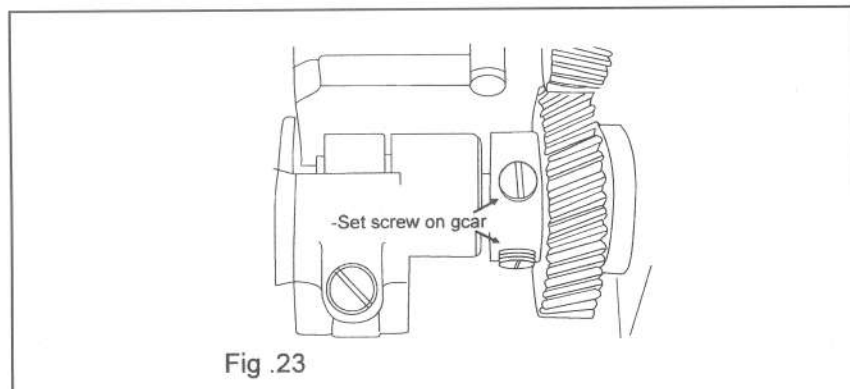
The adjusting procedure is as follows:



- 1) Take off the rubber plug on the crank case of the looper (refer to Fig22).
- 2) Turn the balance wheel by hand.
- 3) First loosen set screw and positioning screw, and then adjust marked screw.
- 4) Turn clockwise the adjustable screw on which punch mark is printed, and the dimension of part B will be increased in value.
- 5) Tighten set screw and positioning screw.

18. The timing of looper in reference to needle (Fig.23)

The looper shall be moved backward to the lowest position while the needle is at the bottom bead centre; loosen the screw on the gear and make timing adjustment of the looper in relation to the needle (refer to Fig23.)



19. Thread-guiding amount of the looper (refer to Fig.24)

- 1) The standard value of the vertical distance of the point of the looper away from the upper end of the eye of the needle is 2mm, then the graduation mark on the lower part of the needle bar shall be in line with the lower end of the needle bar bushing, lower.(refer to Fig.24)
- 2) The value of the strike moved backward by the looper is about 3.5mm.
- 3) The relation between the eye of the needle and the eye of the looper is indicated in Fig.24.
(Note that the left looper and the right one can be separately adjusted.)

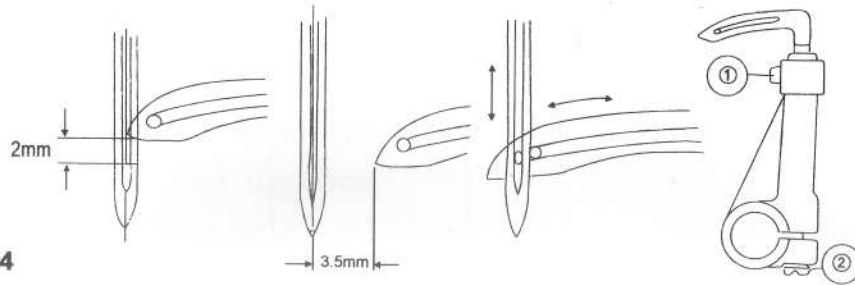


Fig.24

20. The clearance of looper and needle

After adjusting the needle guard, the clearance of a given value between the needle and the looper shall be kept unchanged; the needle shall not touch at the point of the looper when it is pressed down softly. If the clearance is narrower than usual, the side of the needle and the point of the looper are apt to incur breakage due to the impact of the needle side against the looper point.

21. The timing of needle guard(Fig25)

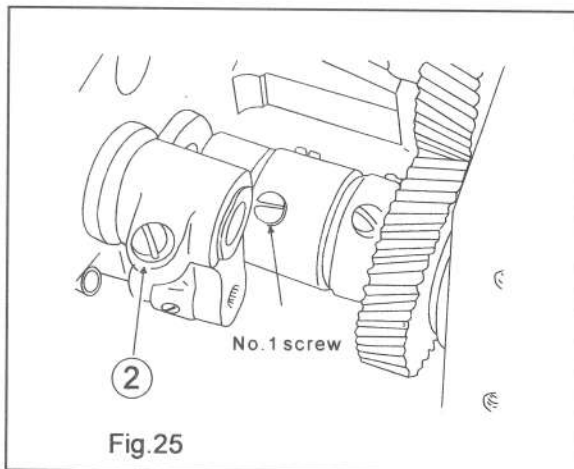
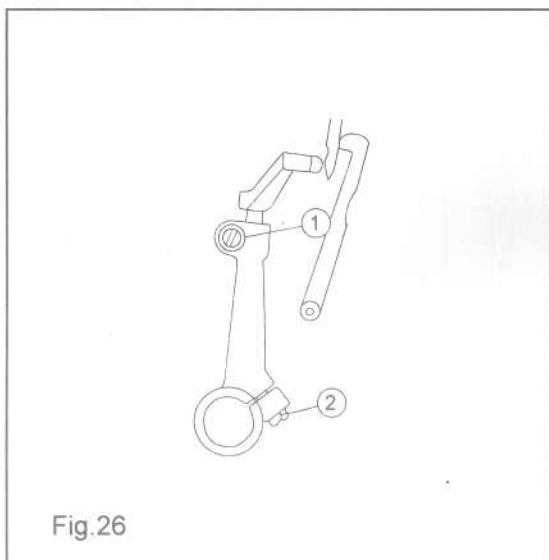


Fig.25

The timing of the needle guard depends on the condition of the plane on the rock shaft of the looper when no. 1 screw has been screwed into this rock shaft.

22. Position of needle guard(Fig 26)

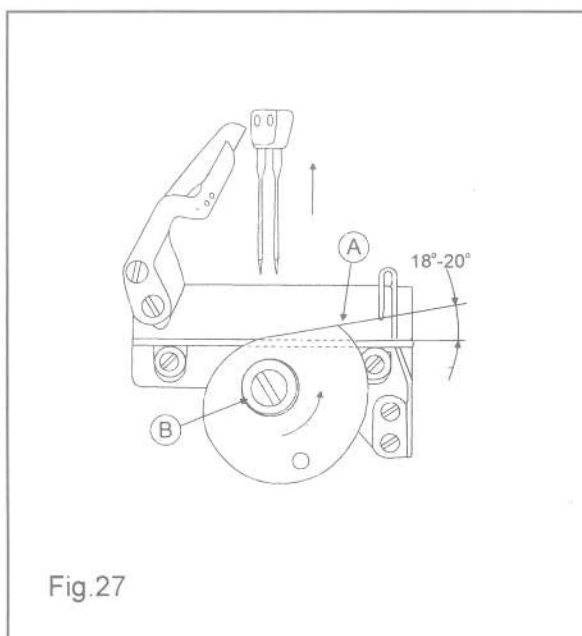
Oscillating the needle guard to make the needle tip contact with needle gauge slightly.



It is recommended that the height adjustment shall not fall within the area of the left counter needle guard. The adjustment can be made by loosening screw ① and ②. The relation between left counter needle guard and the counter needle guard is as represented in Fig 26; the clearance from the needle falls within the range of 0.1 to 0.2mm.

Note that the forced clamp of the needle shall be prohibited when the machine is in motion.

23. Looper thread take-up cam(Fig 27)



It's position can be seen as shown in Fig.27 when the peddle bar is at the top dead centre, the planes of the cam and the steel wire are in parallelism; the projecting part of the cam can slightly rise at the angle of 18 to 20 degrees. first loosen screw B, and then make adjustment, finally tighten the screw firmly. Pay close attention to the following; the needle tip shall entirely come into the thread loop of the looper when the bobbin thread rejecting from the projecting part of the cam.

24. The position of the thread-amount adjusting plate of the thread take-up lever:(Fig 28)

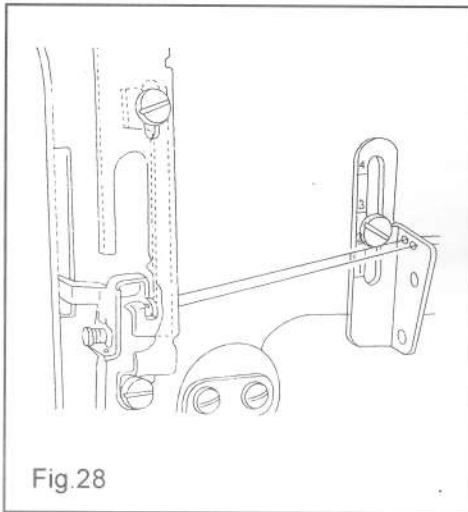


Fig.28

The thread-amount adjusting plate will retain the bobbin at thread when the needle bar is the bottom dead centre; in such a way the loop of the needle thread is to become bigger when the needle thread is hooked. In addition to the foregoing there is a function of the tight pulling of the needle thread loop. The thread-amount adjusting plate usually reduces to the lowest point when a thread finer than normal is used. Note that take-up thread tension lever is another name for thread-amount adjusting plate.

25. Frame thread eyelet: (Fig 29)

The improper-positioning of the frame thread eyelet may be the cause of occurrence of skipping stitch.

The following locations are generally regarded as criteria (refer to Fig29)

Cotton thread #80~ #50	Graduation marked on the frame thread eyelet 2-3
Cotton thread #80~ #50	Graduation marked on the frame thread eyelet 3-4
Thread of chemical fibre #80~ #50	Graduation marked on the frame thread eyelet 1-2
Thread of chemical fibre #80~ #50	Graduation marked on the frame thread eyelet 2-3

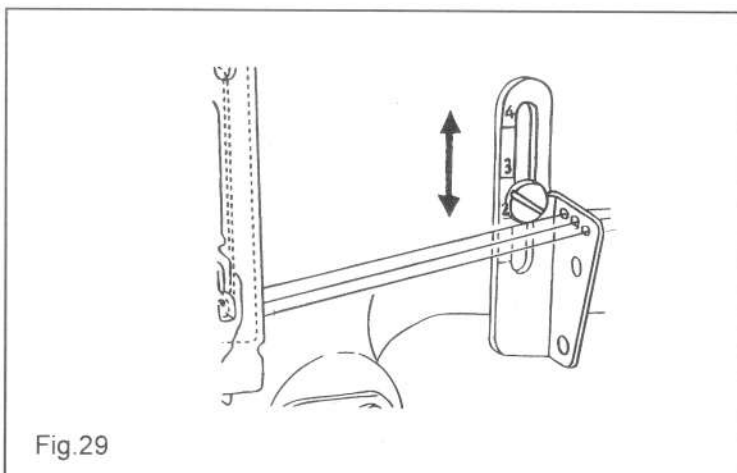


Fig.29

26. Replacement of throat plate: (Fig.30)

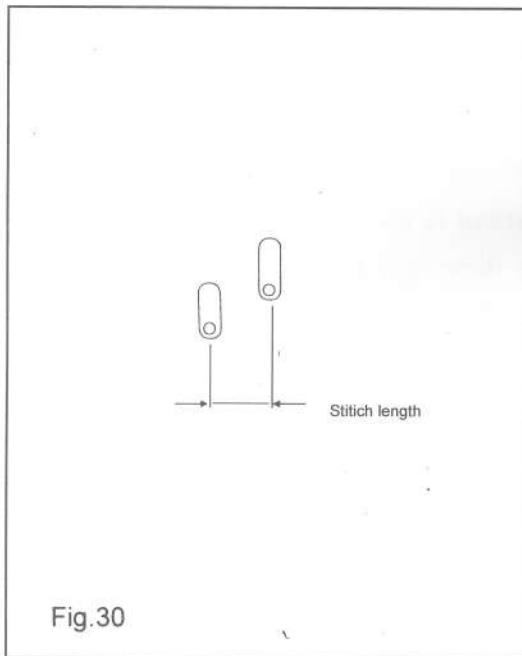


Fig.30

The standard size of the throat plate in parts book, which is stipulated by the manufactory, is $1/4$, equivalent to 6.4mm (Fig.30)

The replacement of the following components is usually needed at the time when changing the gauge of double-row thread stitch.

1. Needle clamp
2. Hinged foot
3. Throat plate
4. Feed dog
5. Rear moving needle guard
6. Curler

The left and right loopers within the range of the sizes of $1/8$ " to $1/2$ " are interchangeable. In addition to the aforesaid, the replacement of slide plate and cam cover shall be made when the width of thread plate is on the increase.

27. Maintenance of the machine

The following shall be adhered in order to keep the machine in good working condition.

(1) Daily checking

- I . The oil shall spray onto the oil sight whe the machine is running.
- II . Repairman shall be sent for when abnormal sound is heard during the operation if the machine.

(2) Locations to be checked once a week:

- I . To take off throat plate, slide plate, and cam cover; to clean dust od the slotted feed dog with a brush.
- II . To turn over the head to rid both the oil filter screen on the oil pumq and the interior of the oil reservoir of oil stain and dust.
- III . Loosen drain hole screw and take it off; drain all the dirty oil from the oil reservoir and reoil it.
- IV . Oil level must be above thr lowest oil-level-indicating line marked "Low"
- V . The black powder, adhering to the magnet in the oil reservoir shall be wiped with sponge cloth.

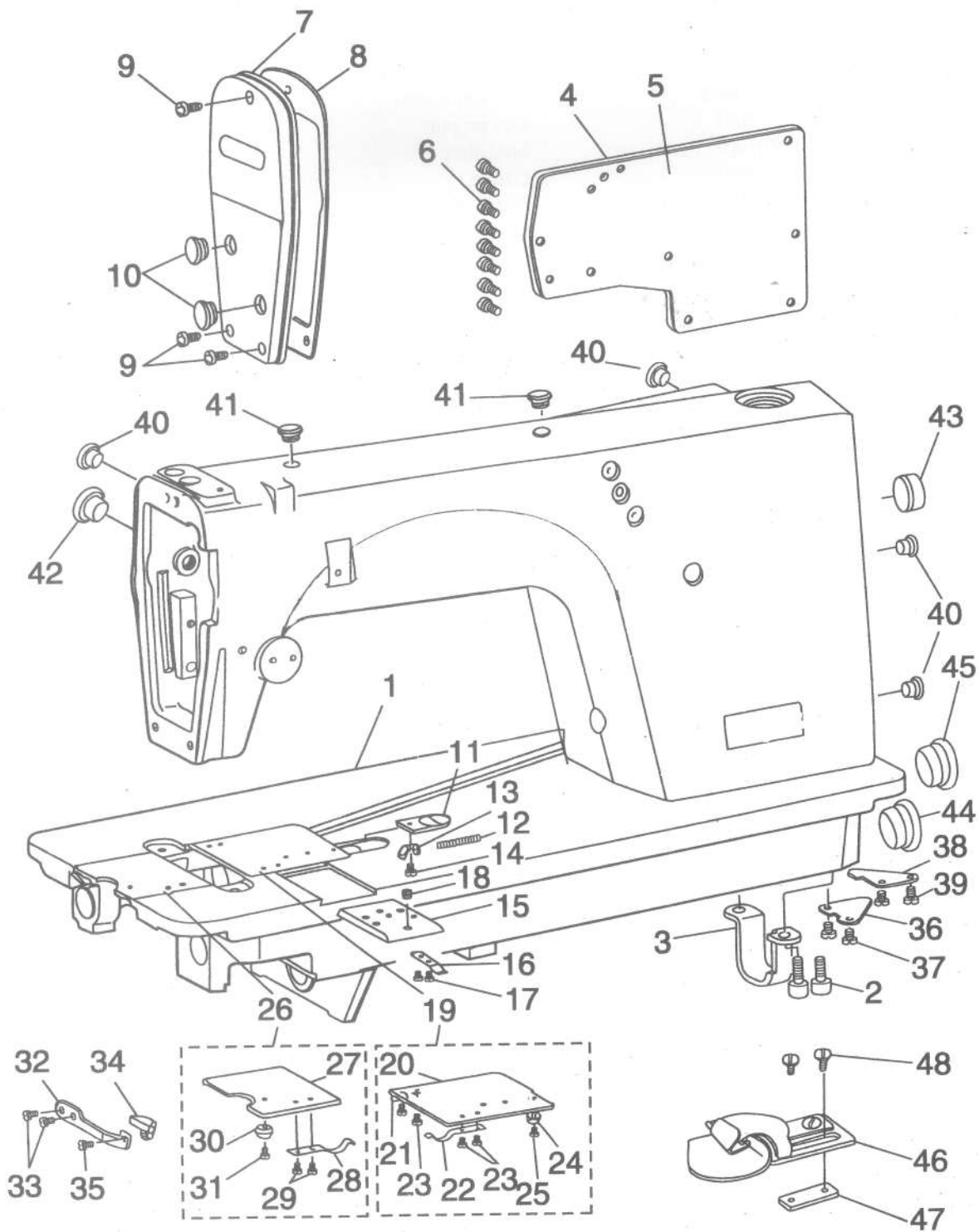
28. ommon breakdowns and measures of trouble shooting.

No.	Breakdown	Cause	Measures to be taken
1	Thread breakage	<ol style="list-style-type: none"> 1. Poor thread quality 2. Thread being too thick 3. Fusing thread due to high temperature of needle caused by machine s operation at high speed 4. Tension being too higher 5. Breakage of needle. looper, throat plate, and needle guard at the location of thread guide 6. Failure to adjust thread amount 	<ol style="list-style-type: none"> 1. Quality thread to be used. 2. Replacement to be made by an appropriate thread 3. Silicone oil to be used and speed to be reduced 4. The tension nut to be loosened 5. First grinding with oil stone and then polishing 6. Adjusting thread amount adjusting plate
2	Skipping stitch	<ol style="list-style-type: none"> 1. Skipping stitch of needle thread (leaking of two stitches due to the loopers failure to hook the needle thread) 2. Skipping stitch of bobbin thread (leaking of one stitch, needle failure to enter the looper eyelet) 3. Skipping stitch when thread of chemical fibre being in use 	<ol style="list-style-type: none"> 1. Adjusting thread-hooking amount of looper 2. Adjusting clearance between looper and needle. 3. The timing of needle in reference to looper 4. Adjusting the thread-amount adjusting plate on thread amount changing conditions. 5. Adjusting the frame thread eyelet. 6. Checking whether the mounting position of the needle is proper or not. 7. To see if the location of needle guard is in an appropriate way and the timing of it is well regulated in relation to another. 8. To see if the needle thread threading is in a proper way. <ol style="list-style-type: none"> 1) Reference to the above cases 1 and 2, as to skipping stitch of the needle of the needle thread. 2) To see if the timing of bobbin thread cam has been well regulated. 3) Increasing tension of bobbin thread a bit higher. 4) To see if the threading of bobbin thread is in a correct way. <ol style="list-style-type: none"> 1) Using silicone oil 2) Reducing speed 3) Using needle for thread of chemical fibre.

		4. Skipping stitch when thread of polyester fibre being in use	1. Reducing speed 2. Silicone oil to be used
3	Twisted stitches	1. Needle thread tension being too low 2. Bobbin thread tension being too low 3. Sewing thread being too thick 4. Improper position of the frame thread eyelet. 5. Improper position of thread take-up tension plate 6. Throat plate	1. Tightening tension nut of needle thread. 2. Tightening tension nut of bobbin thread. 3. Needle of large size to be used. 4. Readjusting it to a proper position. 5. Readjusting its position in an appropriate way 6. The eyelet of throat plate to be used being bigger than normal one.
4	Breakage of needle	1) Needle being bent. 2) The operation of feed dog being not well regulated in reference to the motion of needle. 3) Setting-up of the presser foot 4) The problem of the timing of needle guard remaining unsolved 5) Needle thread tension being too high. 6) Needle being too thick.	1) Needle to be replaced by another of proper size. 2) Readjusting the timing to feed dog in respect to the needle. 3) To make both the centre of the bore of the presser foot and the centre of the eyelet of the throat. 4) The positioning & the timing of the needle guard to be taken into account. 5) Relaxing needle thread 6) Appropriate needle to be used.
5	Puckering	1. Thread tension being too high. 2. The problem of the timing of the bobbin thread cam for thread guiding failing to be solved. 3. The problem of surface finish arising from bobbin thread going through the parts on the thread guide. 4. The force on the presser foot being too great.	1. Decreasing thread tension, esp tension of bobbin thread. 2. Readjusting of the very cam said to solve the timing problem. 3. Surface finishing all the parts on the thread guide. 4. Turning counter-clockwise the pressure-regulating screw.

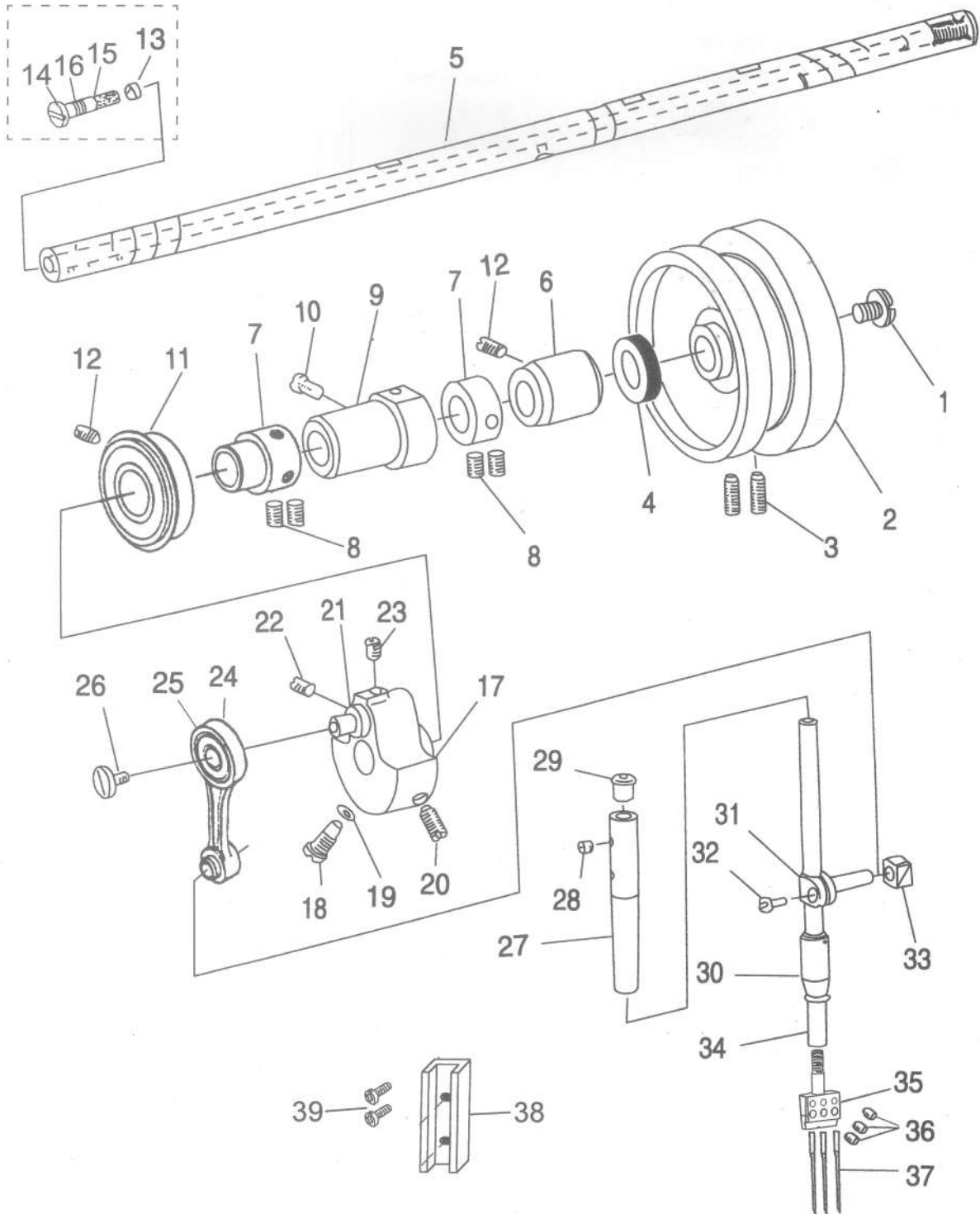
1. Arm bed components

Ref. No.	Parts No.	Description	Arm. Req.
1	125010001	Arm bed complete	1
2	116S13002	Bed screw stud	2
3	12512001	Bed support	1
4	12501001	Side plate	1
5	12522001	Gasket	1
6	116311017	Side plate screw	8
7	12501002	Face plate asm.	1
8	12522002	Face plate gasket	1
9	116S11017	Screw	3
10	125S22011	Rubber plug	2
11	12515001	Cam cover latch	1
12	12527001	Spring	1
13	12512002	Spring suspension	1
14	125S11004	Screw	1
15	12515002	Attachment installing plate	1
16	12512003	Spring	1
17	GS0128	Screw	2
18	GS012	Screw	1
19	1251500300	Cam cover asm	(1)
20	12515008	Cam cover	1
21	12512004	Cam cover	1
22	12512005	Spring	1
23	101S11019	Screw	4
24	12515004	Cam cover guide	1
25	201S11002	Screw	1
26	1251500500	Bed slide asm	(1)
27	12615002	Bed slide	1
28	12512006	Spring	1
29	101S11019	Screw	2
30	12515006	Bed slide guide	1
31	201S11002	Screw	1
32	12512007	Bed slide lock spring	1
33	112S11014	Screw	2
34	12509001	Latch	1
35	101S11027	Screw	1
36	12512008	Bed oil shield	1
37	112S11014	Screw	2
38	12512009	Bed oil shield	1
39	112S11014	Screw	2
40	12522006	Rubber plug	4
41	12522003	Rubber plug	2
42	12522012	Rubber plug	1
43	12522013	Rubber plug	1
44	12522003	Rubber plug	1
45	12522004	Rubber plug	1
46	1251201000	Folder	1
47	12512013	Gasket	1
48	125S11006	Screw	2



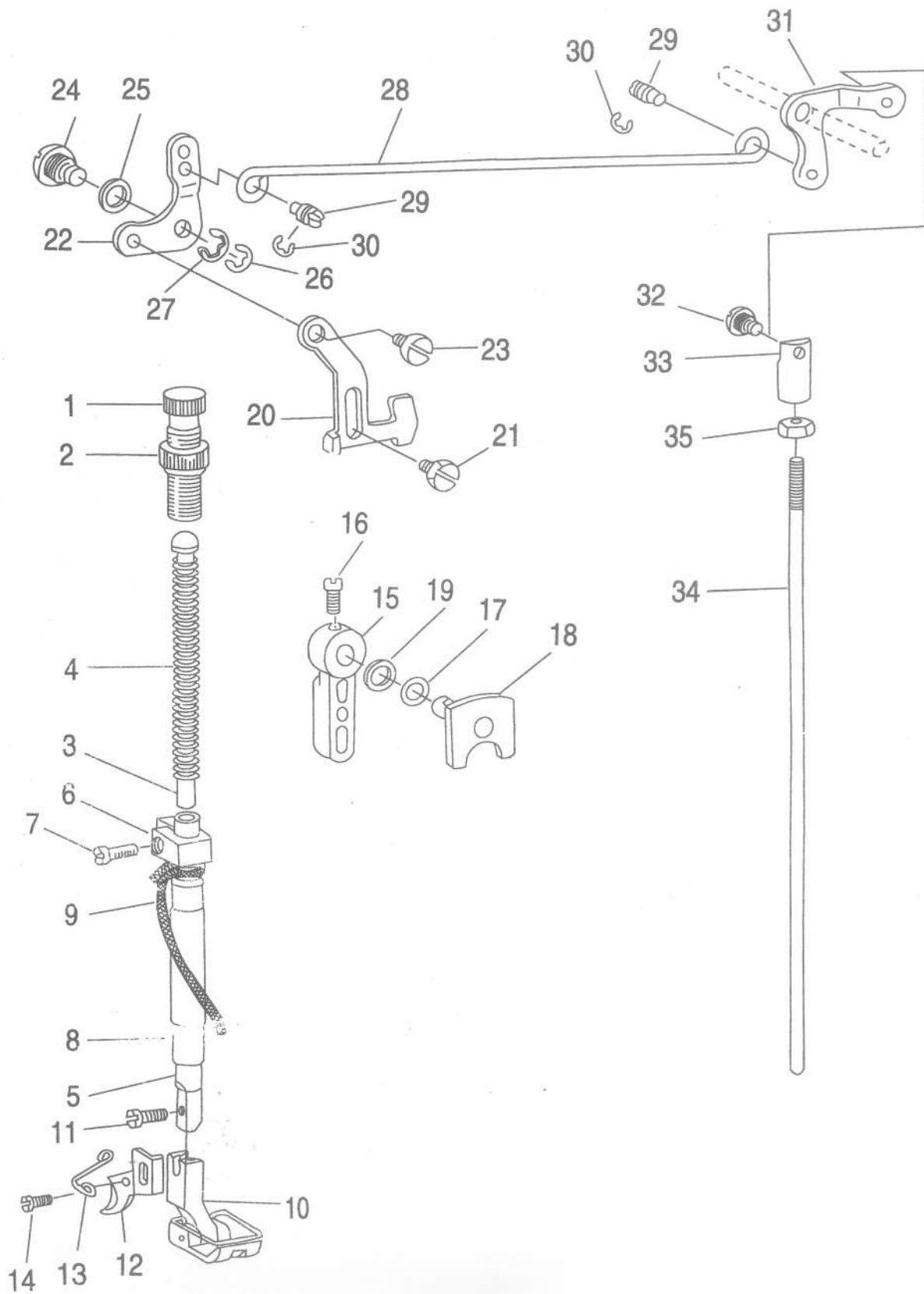
2. Main shaft & needle bar components

Ref. No.	Part No.	Description	Arm. Req.
1	125S11008	End screw	1
2	10135001	Hand wheel	1
3	101S15001	Screw	2
4	12522010	Oil seal	1
5	12502001	Main shaft	1
6	1250300100	Main shaft bushing, rear	1
7	10108001	Main shaft thrust collar	2
8	101S15007	Screw	4
9	12503004	Main shaft bushing intermediate	1
10	101S15007	Screw	1
11	600422N	Main shaft bushing, front	1
12	101S11003	Screw	2
13	GR1470	Roller felt	1
14	GX334	Crank oil adjusting pin	1
15	GO269	Rubber bushing	1
16	GR1471	O-Rubber ring	1
17	12504001	Counterweight asm.	1
18	101S11003	Screw	1
19	12522014	O-Rubber ring	1
20	101S15004	Screw	1
21	12626003	Needle crank	1
22	125S15001	Screw	1
23	101S15002	Screw	1
24	12205002	Needle bar crank rod	1
25	B04008	Needle roller bearing	1
26	101S17001	left twist screw	1
27	12503009	Needle bar bushing upper	1
28	409S15004	Screw	1
29	12522015	Rubber plug	1
30	10103023	Needle bar bushing, lower	1
31	12538001	Needle bar connection asm.	1
32	101S11005	Screw	1
33	10109001	Crank slide block	1
34	12602001	Needle bar	1
35	12634001	Needle clamp(1/4")	1
36	305S14002	Screw	3
37	800182	Needle	3
38	10109002	Needle bag guide	1
39	101S11008	Screw SM11/64 x 40 L=8	2



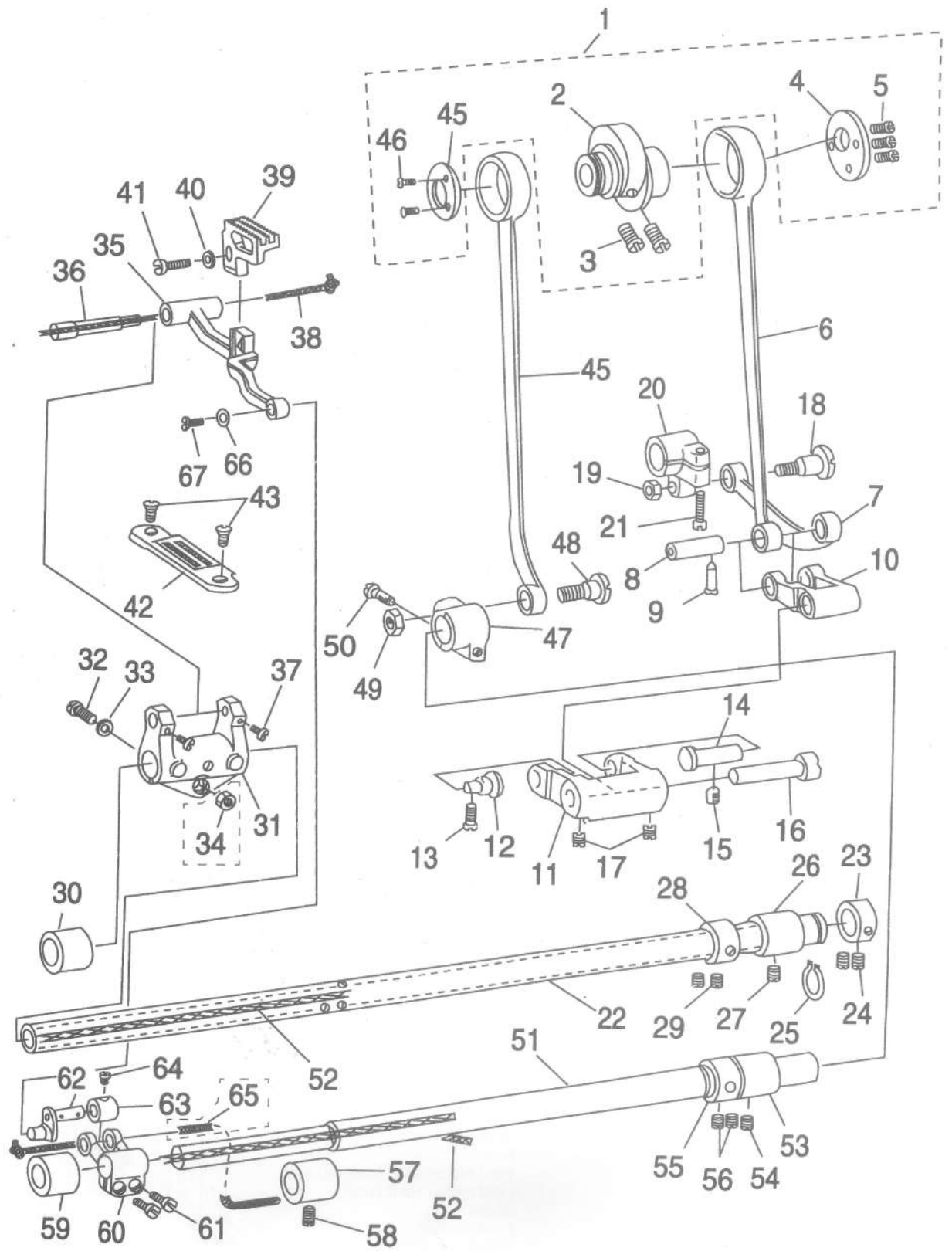
3. Presser bar components

Ref. No.	Part No.	Description	Amt. Req.
1	125S30001	Presser spring regulator	1
2	101S16002	Nut	1
3	10102003	Presser bar guide bar	1
4	10127005	Presser spring	1
5	12502002	Presser bar	1
6	12509002	Presser guide bracket asm.	1
7	409S11021	Screw	1
8	10103012	Presser bar bushing,lower	1
9	10123001	Oil wick	1
10	1251600100	Presser foot asm	1
11	101S11009	Screw	1
12	12519001	Thread knife	1
13	12527003	Thread knife guide	1
14	201S11002	Screw	1
15	12511002	Hand lifter	1
16	101S11001	Screw	1
17	12528002	Washer	1
18	1251000100	Hand lifter cam asm.	1
19	001004	Rubber ring	1
20	12512057	Lifting lever	1
21	125S20003	Hinge screw	1
22	12512014	Lifting link for lifting lever	1
23	125S20001	Hinge screw	1
24	125S11001	Hinge pin	1
25	12528003	Lifting lever gasket	1
26	12529001	Snap ring	1
27	H05009	Snap ring	1
28	12512015	Lifting lever connecting rod	1
29	125S11002	Screw	2
30	12529002	Snap ring	2
31	12529002	Lifting levr link rear	1
32	125S2004	Hinge screw	1
33	12526003	Swivel	1
34	12512019	Lifting lever connecting rod,vertical	1
35	116S16006	Nut	1



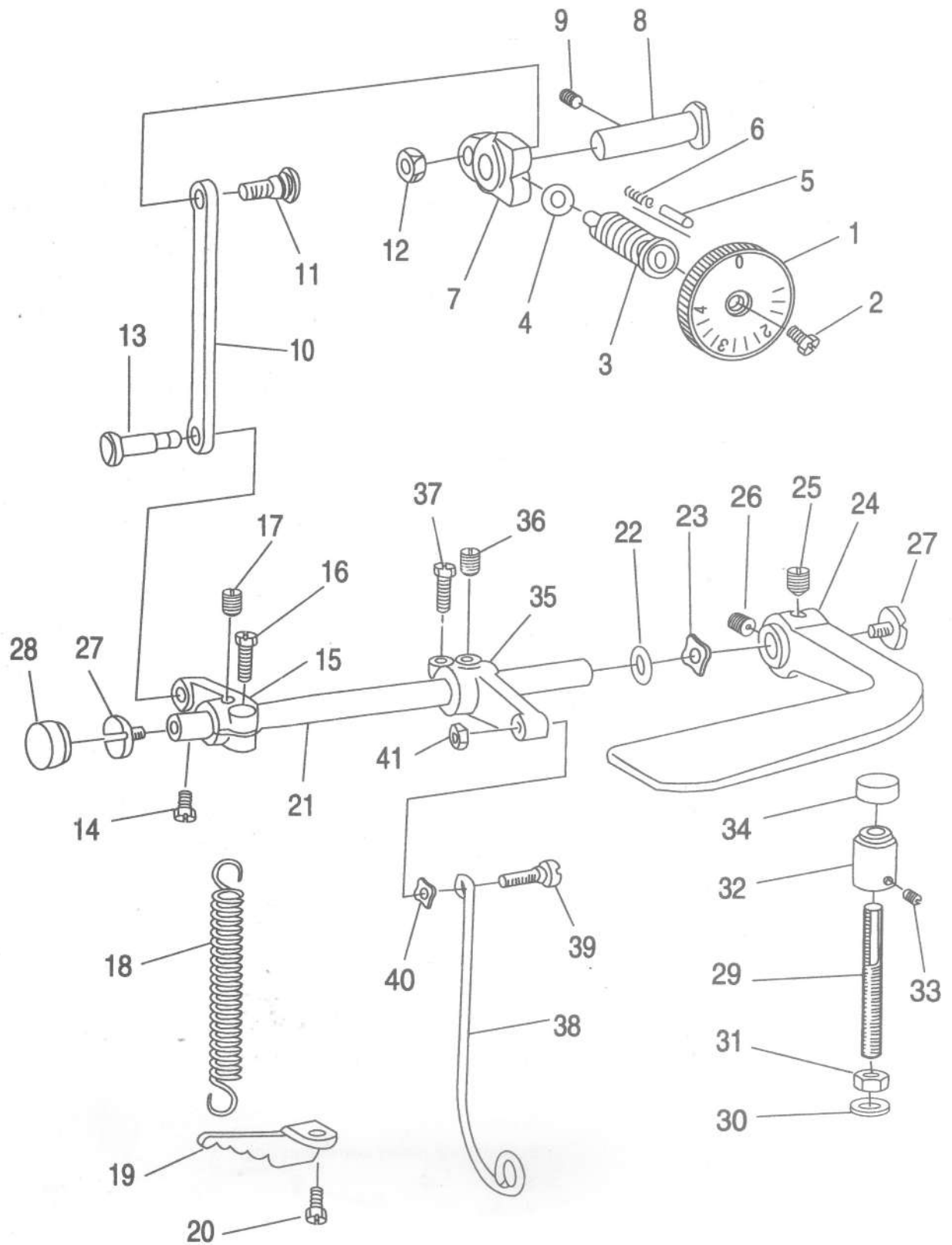
4. Feed mechanism components

Ref. No.	Part No.	Description
1	1251000300	Feed eccentric cam asm.
2	12510004	Feed eccentric cam
3	101S11013	Screw
4	12512018	Feed eccentric thrust washer
5	125S17001	Screw
6	12505001	Feed rocker shaft connecting rod
7	12505002	Connecting rod
8	12526004	Connecting pin
9	206S11001	Screw
10	12504002	Feed driving rocker asm
11	12501003	Feed driving rocker
12	12526005	Hinge stud
13	125S11009	Screw
14	12526006	Hinge pin
15	125S11010	Screw
16	12526007	Hinge pin
17	125S11011	Screw
18	125S20002	Hinge screw
19	409S11015	Nut
20	12504003	Feed rocker shaft crank
21	409S11015	Screw
22	12502004	Feed rocket shaft
23	12508002	Thrust collar
24	405S15006	Screw
25	12529003	Retaining ring
26	12503012	Bushing rear
27	125S11012	Screw
28	10108003	Thrust collar
29	101S15002	Screw
30	12503013	Feed rocker shaft bushing,frong
31	12507001	Feed rocker
32	409S11015	Screw
33	12528004	Washer
34	GL20	Nut
35	12507002	Feed bar
36	12526008	Feed bar shaft
37	125S11003	Screw
38	10123008	Oil wick
39	12514001	Reed dog(1/4)
40	12528005	Washer
41	409S11021	Screw
42	12515007	Throat plate(1/4)
43	125S17002	Screw
44	12505003	Feed driving shaft connecting rod
45	12512019	Feed driving eccentric thrust washer
46	125S17003	Screw
47	12504004	Feed driving shaft crank rear
48	125S20002	Hinge screw
49	409S16015	Nut
50	409S11015	Screw
51	12502005	Feed driving shaft
52	10123008	Oil wick
53	12503012	Bushing, rear
54	101S15006	Screw
55	10108003	Thrust collar
56	101S15002	Screw
57	12503017	Bushing, intermediate
58	101S15006	Screw
59	12503020	Feed rocker shaft bushing, front
60	12504005	Feed rocker shaft crank
61	201S11026	Screw
62	12505004	Feed bar link
63	12508003	Thrust collar
64	125S15003	Screw
65	GR1837	Oil wick
66	12528001	Counter-sunk washer
67	125S11013	Screw



5. Feed regulating components

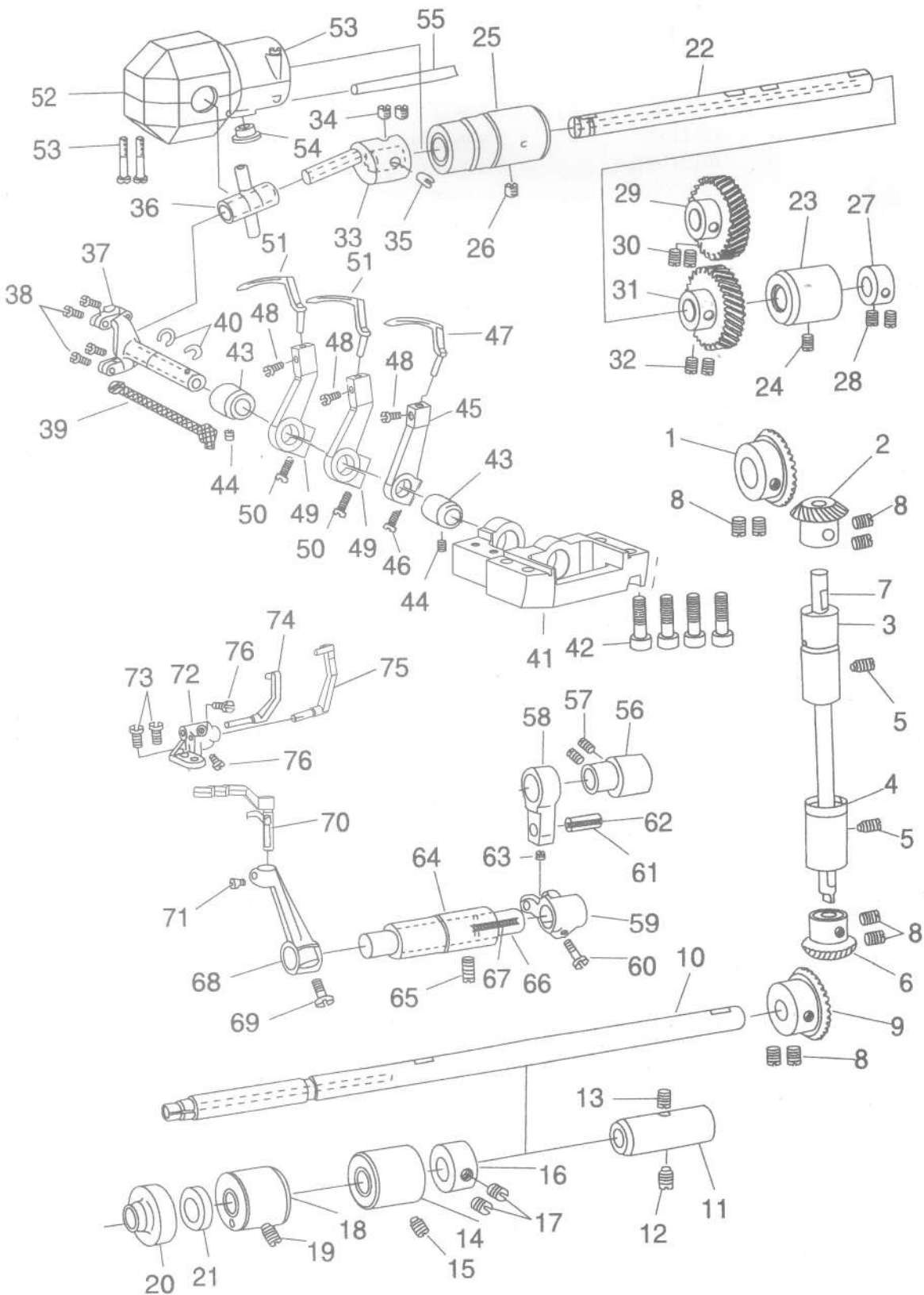
Ref. No.	Part No.	Description	Amt. Req.
1	1251100300	Stitch dial asm	1
2	101S11022	Screw	1
3	12526009	Feed regulating screw	1
4	001040	O-Rubber ring	1
5	12526010	Stitch dial lock pin	1
6	10127010	Stitch dial lock spring	1
7	12504006	Feed regulator	1
8	12526011	Hinge pin	1
9	101S15006	Screw	1
10	12505005	Feed regulator connecting rod	1
11	125S30006	Hinge Screw	1
12	116S11017	Nut	1
13	12526012	Tension spring suspension stud	1
14	116S11017	Screw	1
15	12504007	Tension spring suspension crank	1
16	101S11016	Clamp Screw	1
17	101S15006	Screw	1
18	12527004	Tension spring	1
19	12512020	Suspension bracket	1
20	125S11014	Screw	1
21	12502006	Reverse feed control lever shaft	1
22	001014	Rubber ring,large	1
23	12528006	Waved washer	1
24	10101005	Reverse feed control lever	1
25	101S15011	Screw	1
26	101S15007	Screw	1
27	125S11015	End screw	2
28	12522016	Rubber plug	1
29	125S30007	Screw	1
30	12528007	Washer	1
31	209S16006	Nut	1
32	12509003	Lever stopper	1
33	125S15004	Screw	1
34	12522009	Rubber cushion	1
35	12504008	Control lever crank,rear	1
36	101S15006	Screw	1
37	101S11021	Screw	1
38	12512021	Feed driving rocker arm connecting	1
39	125S20005	Screw	1
40	12528008	Washer	1
41	401S16004	Nut	1



6. Looper thread retainer components

Ref. No.	Part No.	Description	Amt. Req.
1	10125004	Gear asm.	1
2	10125003	Pinion asm.	1
3	12503021	Bushing,upper	1
4	1250302200	Bushing,lower	1
5	125S15002	Screw	2
6	10125003	Gear asm	1
7	12502007	Upright,shaft	1
8	101S15007	Bushing,front asm,screw	8
9	12525001	Gear asm	1
10	12502008	Lower shaft asm	1
11	12503025	Bushing,rear	1
12	125S15002	Screw	1
13	GR1847	Felt	1
14	1250302600	Bushing,intermediate	1
15	125S15002	Screw	1
16	12508004	Thrust collar asm	1
17	101S15007	Screw	2
18	1250303200	Bushing,front	1
19	125S15002	Screw	1
20	12503046	Looper thread guard bushing	1
21	1252200700	Oil seal	1
22	12502009	Looper rocker shaft	1
23	1250303500	Bushing,intermediate	1
24	125S15002	Screw	1
25	1250303800	Bushing,front	1
26	101S15006	Screw	1
27	12508005	Thrust collar asm	1
28	101S15007	Screw	2
29	12525002	Gear asm.upper	1
30	101S15007	Screw	2
31	12525003	Gear asm.lower	1
32	101S15007	Screw	2
33	12504009	Looper crank asm.	1
34	101S15007	Screw	2
35	125S30008	Looper crank adjusting screw	1
36	1250401000	Trunnion asm.	1
37	1250201000	Looper rocker shaft asm	1
38	125S11003	Screw	4

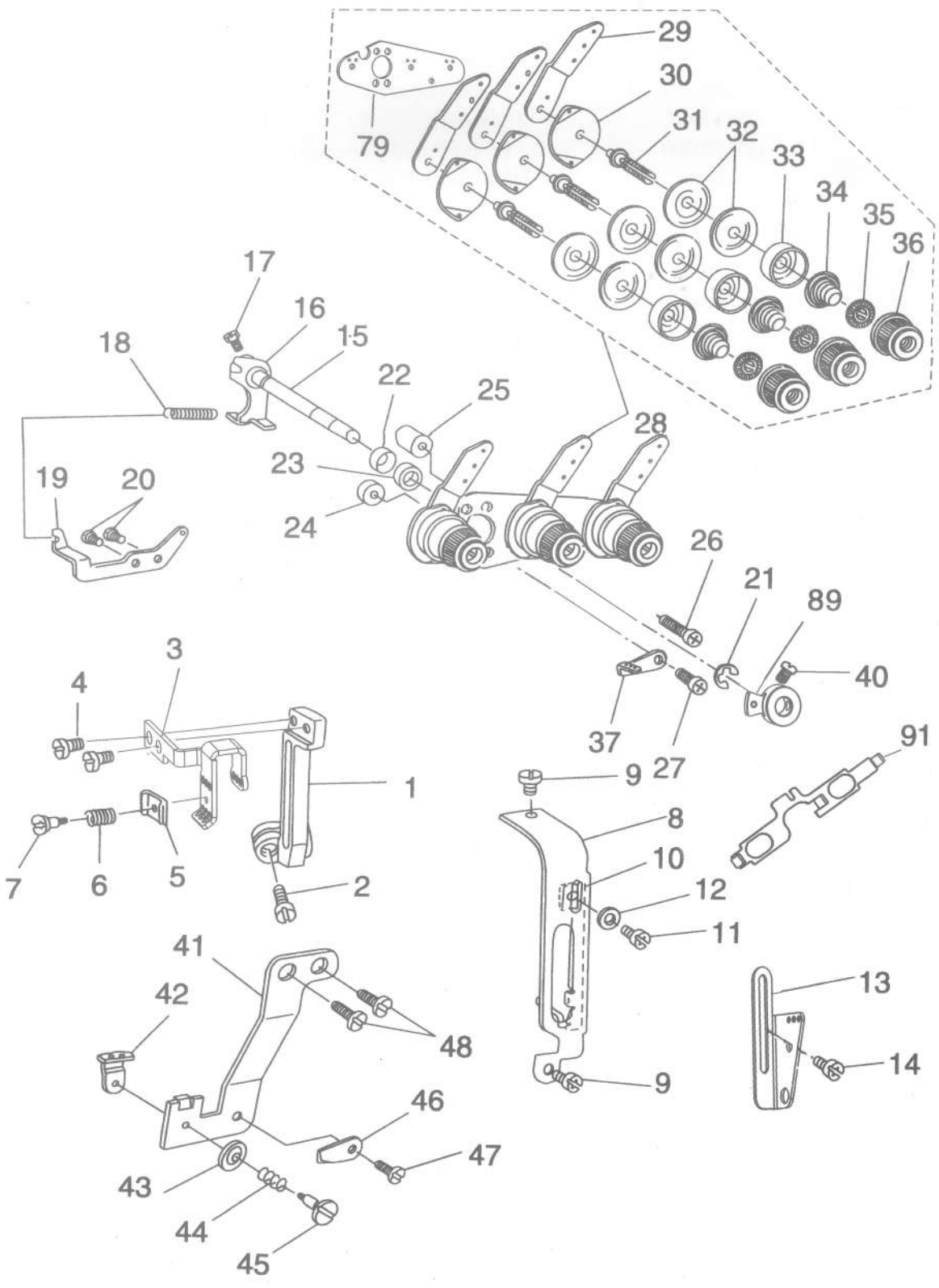
Ref. No.	Part No.	Description	Amt. Req.
39	10123008	Oil wick	1
40	12529004	Snap ring	2
41	12501005	Looper mounting base	1
42	125S13001	Screw	4
43	12503042	Bushing,rear	2
44	405S15006	Screw	2
45	12504012	Looper holder asm.(left)	1
46	409S11015	Screw	1
47	12517001	Looper(left)	1
48	209S11012	Screw	3
49	12504013	Looper holder asm.(right)	2
50	409S11015	Screw	1
51	12517002	Looper(right)	1
52	1251202200	Crank cover asm	1
53	125S11007	Screw	3
54	12522016	Rubber plug	1
55	12521001	Vinyl tube	1
56	12510005	Needle guard cam asm.	1
57	101S15006	Screw	2
58	12505007	Needle guard crank rod	1
59	12504014	Rear needle guard rocker fork	1
60	101S11020	Screw	1
61	12526014	Pin	1
62	10123008	Oil wick	1
63	40515006	Screw	1
64	12503043	Bushing	1
65	101S15006	Screw	1
66	12502012	Needle guard driving shaft asm	1
67	10128008	Oil wick	1
68	12504015	Rear needle guard rocker arm asm.	1
69	409S11015	Screw	1
70	12517003	Driving needle guard(1/4)	1
71	125S11003	Screw	1
72	12501006	Needle guard base	1
73	125S11016	Screw	2
74	12517004	Counter needle guard,left	1
75	12517005	Counter needle guard,right	1
76	101S11005	Screw	2

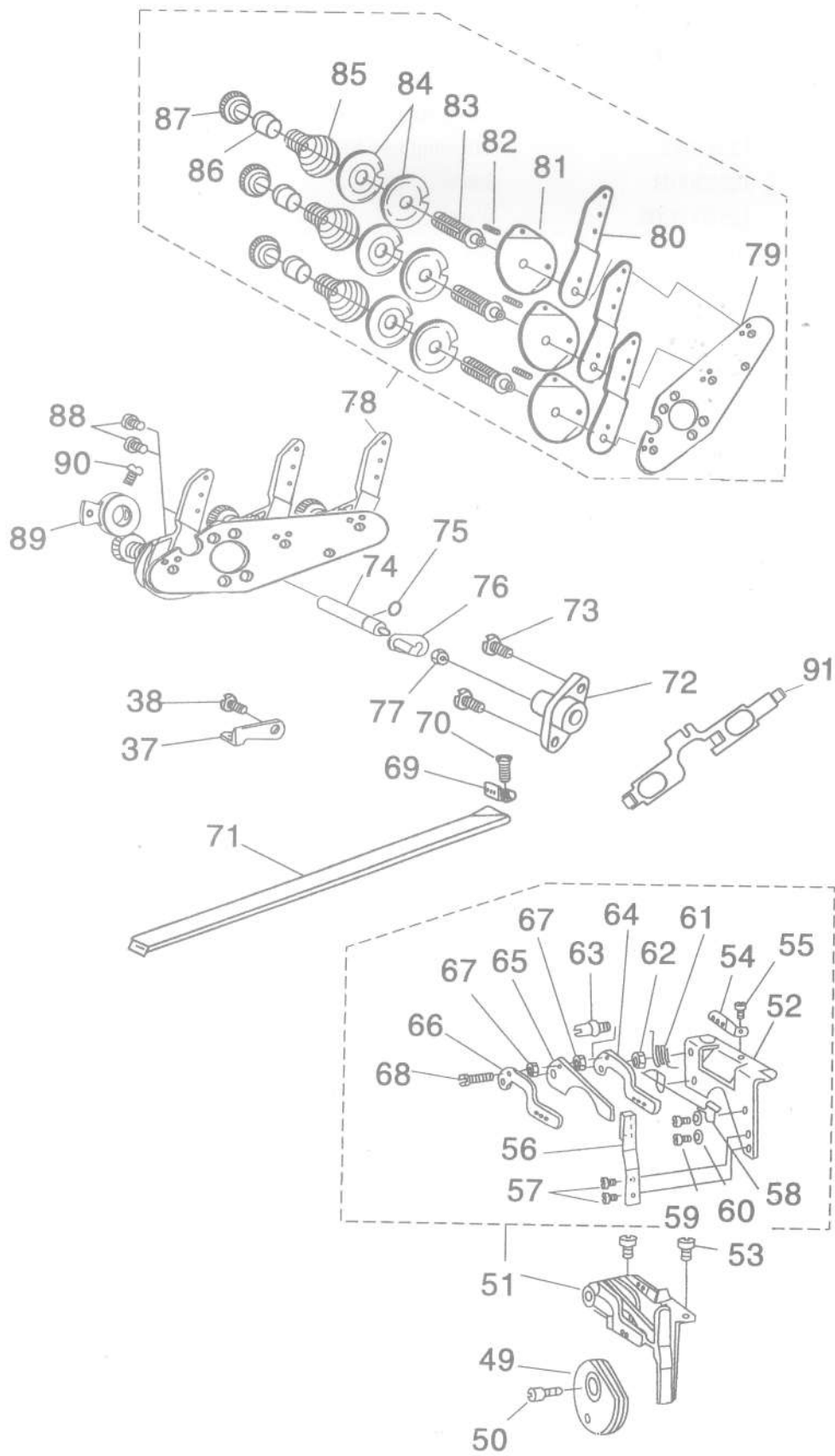


7. Thread take-up,tension,and tension releasing assembly complete

Ref. No.	Part No.	Description	Amt. Req.
1	12505008	Thread take-up lever	1
2	125S11017	Screw	1
3	12512025	Thread take-up	1
4	101S11005	Screw	2
5	12512026	Tension plate	1
6	12527014	Tension spring	1
7	125S11018	Screw	1
8	12512027	Thread take-up lever guard	1
9	112S11014	Screw	2
10	12512028	Take-up thread tension lever	1
11	112S11014	Screw	1
12	W01009	Washer	1
13	126120001	Frame thread eyelet	1
14	112S11014	Screw	1
15	12502013	Tension release shaft	1
16	1250401600	Tension release arm asm.	1
17	101S11012	Screw	1
18	12527015	Spring	1
19	12512031	Suspension bracket	1
20	125S11019	Screw	2
21	H05013	Snap ring	1
22	12522017	Oil seal ring	1
23	12509004	Tension release shaft spacer	1
24	12509005	Spacer (A) for installing plate	1
25	12509006	Spacer (B) for installing plate	1
26	125S30009	Screw	1
27	125S30010	Screw	1
28	1251300100	Needle thread tension asm.	(1)
29	12512032	Needle thread tension guide plate	3
30	12512033	Tension thread guide	3
31	125S30003	Looper thread tension post	3
32	10112005	Tension disc	6
33	12511004	Tension disc presser rube	3
34	10127002	Tension spring	3
35	10112007	Tension disc stopper	3
36	12511009	Tension nut	3
37	12512035	Frame thread guide	2
38	112S11014	Screw	1
39	12504017	Tension release latch	1
40	101S11012	Screw	1
41	GR1907	Tension controller installing plate	1
42	GR1908	Take-up thread guide	1
43	GR1493	Attachment installing plate	1
44	GW229	Take-up thread tension spring	1
45	GS0149	Take-up thread tension post	1

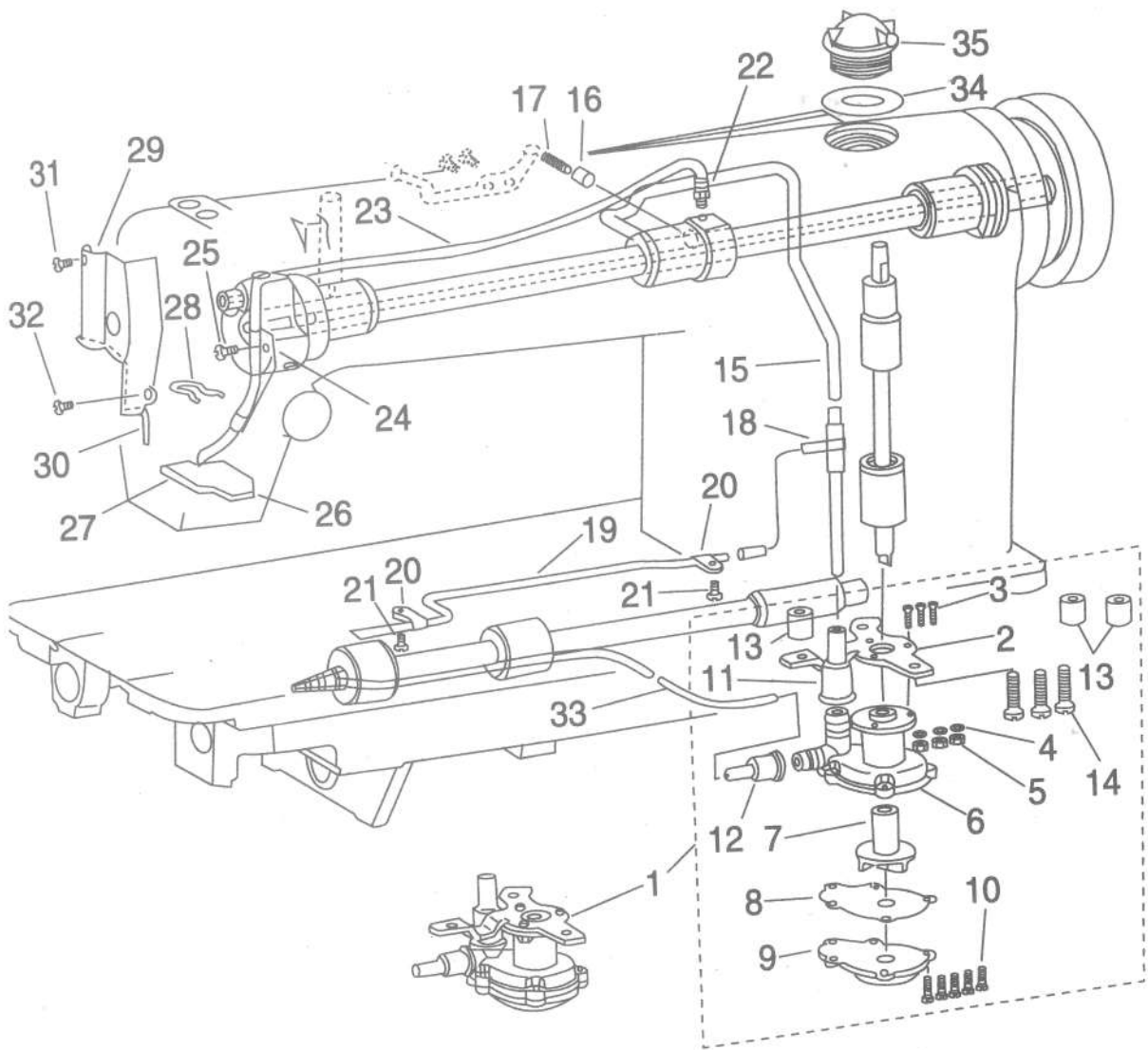
Ref. No.	Part No.	Description	Amt. Req.
46	GR1986	Thread tension release guide latch	1
47	GS043	Screw	1
48	GS010	Screw	2
49	1251000600	Looper thread take-up cam	1
50	125S17004	Screw	1
51	1251300200	Looper thread guide asm.	1
52	12512040	Thread guide plate	1
53	112S11014	Screw	2
54	12512014	Looper thread guide	1
55	125S11004	Screw	1
56	12512042	Thread guide stopper spring	1
57	125S11004	Screw	2
58	12527007	Cast-off wire	1
59	101S11027	Screw	2
60	W01005	Washer	2
61	12527008	Thread guide spring	1
62	114S16004	Nut	1
63	125S30002	Thread guide stud	1
64	12512043	Looper thread guide,right	1
65	12512044	Cast-off plate	1
66	12512045	Looper thread guide,left	1
67	12509007	Collar	2
68	125S11005	Screw	1
69	12512046	Looper thread guide	1
70	125S17005	Screw	1
71	12512047	Looper thread guide tube	1
72	12504018	Tension release shaft bushing	1
73	125S11020	Screw	2
74	12502014	Looper thread release shaft	1
75	001004	Rubber ring	1
76	1250401900	Tension release arm asm.	1
77	114S16004	Nut	1
78	1251300300	Lower thread tension asm.	(1)
79	12512057	Tension installing plate	3
80	12512049	Looper thread tension control plate	3
81	12512050	Thread guide	3
82	P01009	Spring pin	3
83	125S30003	Looper thread tension post	3
84	12512051	Tension disc	6
85	12527009	Looper thread tension spring	3
86	12509008	Tension spring bushing	3
87	125 S16001	Tension post nut	3
88	125S11014	Screw	2
89	12504020	Looper thread release latch	1
90	101S11012	Screw	1





8. Lubrication

Ref. No.	Part No.	Description	Amt. Req.
1	1252000100	Lubricating oil pump asm.	(1)
2	12512052	Oil pump installing base	1
3	125S30011	Screw	3
4	1252000200	Washer	3
5	GL138	Nut	3
6	12520005	Lubricating oil	1
7	12520003	Oil pump impeller	1
8	12512053	Oil pump impeller cover	1
9	1252000400	Lubricating oil pump cover	1
10	125S30012	Screw	5
11	12536002	Rubber joint	1
12	12536003	Rubber joint	1
13	12509011	Collar	3
14	125330009	Screw	3
15	12521002	Main shaft oil tube	1
16	12526018	Oil return pump plunger	1
17	12527010	Plunger spring	1
18	12536003	Oil sight window base	1
19	12521003	Gear oil pipe	1
20	12512054	Holder	2
21	112S11014	Screw	2
22	GS055	Connecting screw	1
23	12521001	Oil return tube asm.	1
24	12512055	Oil return tube holder	1
25	112S11014	Screw	1
26	GR1567	Oil felt presser	1
27	10423002	Oil felt	1
28	12527011	Oil felt presser	1
29	12512056	Arm oil shield	1
30	10123001	Oil wick	1
31	GS069	Screw	1
32	112S11014	Screw	1
33	12521005	Oil tube	1
34	10122019	O-Rubber ring	1
35	10111004	Oil sight window	1

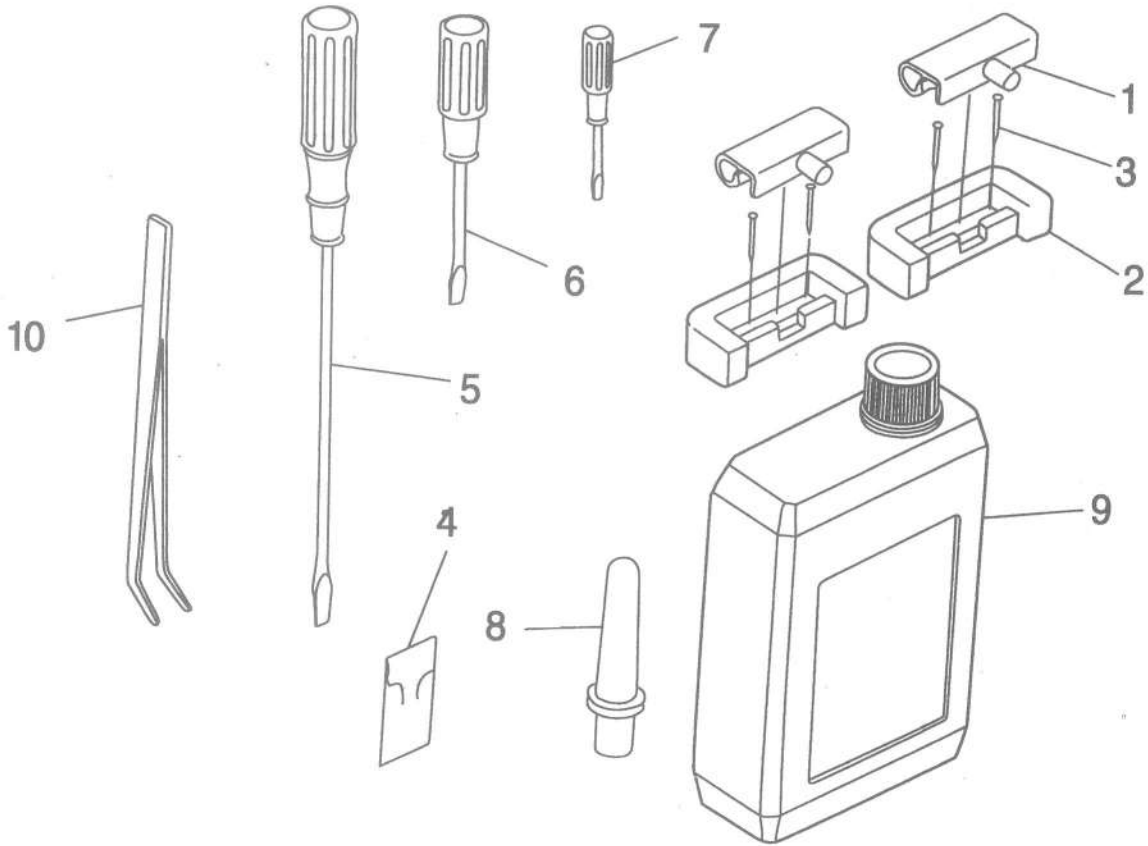
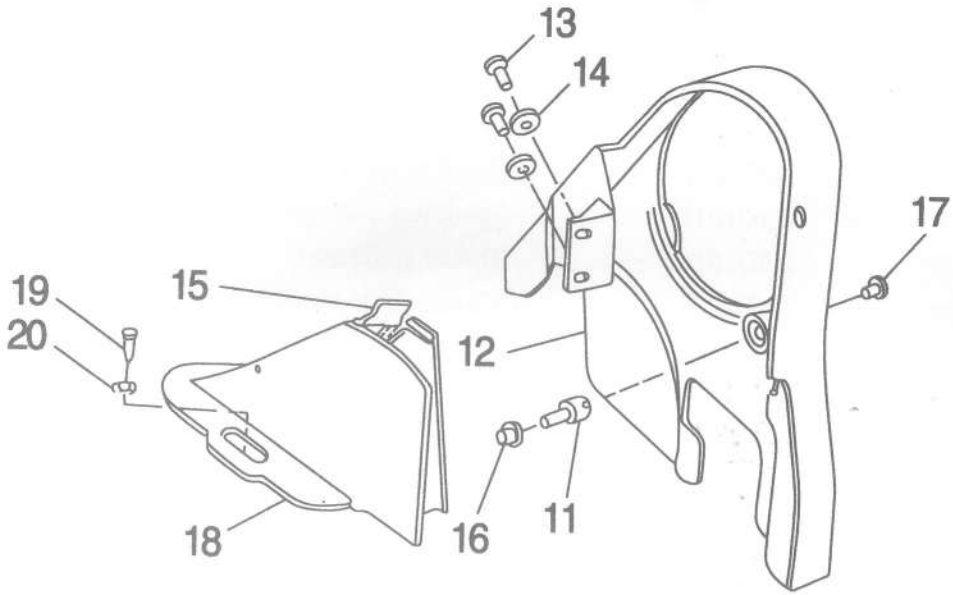


9. Oil reservoir & knee lifter components

Ref. No.	Part No.	Description	Amt. Req.
1	1250100700	Oil reservoir asm.	(1)
2	12501009	Oil reservoir	1
3	10131001	Oil reservoir magnet	1
4	1252202000	Gasket	2
5	12522019	Gasket	1
6	10122031	Rubber cushion	4
7	10122032	Oil reservoir felt cushion	2
8	10122023	Oil reservoir rubber cushion	2
9	101S30010	Nail	4
10	101S11028	Oil drain cap gasket	2
11	12531004	Oil drain screw	2
12	1251205800	Knee press lifter rod	1
13	12512059	Lifting	1
14	101S12002	Positioning screw	1
15	101S15012	Positioning screw	1
16	101S16004	Nut	1
17	GS058	Positioning screw	1
18	GL21	Nut	1
19	10127026	Spring	1
20	H05010	Thrust ring	1
21	12502015	Knee press rod	1
22	10101008	Bearing bracket	1
23	101S12003	Clamp screw	2
24	10112028	Knee lifter plate rod	1
25	10112030	knee press plate cover joint	1
26	101S12004	Screw	1
27	10112029	Knee press plate	1
28	GW262	Knee press plate spring	1
29	GS060	Screw	1
30	10122025	Knee press plate cover	1

10. Machine head accessories

Ref. No.	Part No.	Description	Amt. Req.
1	1011203100	Machine hinge plate asm.	2
2	10122026	Machine hinge plate	2
3	101S30010	Nail	4
4	800182	Needle	1pack
5	10131002	Screw driver (L)	1
6	10131003	Screw driver (M)	1
7	10131004	Screw driver (S)	1
8	10111011	Machine rest pin	1
9	1011101200	Lubricating unit case asm.	1
10	20131051	Tweezer	1
11	101S30012	Belt cover support stud	1
12	10111006	Belt-cover A	1
13	101S11030	Screw	2
14	10128007	Washer	2
15	10111009	Belt-cover B cover asm.	1
16	GL38	Nut	1
17	101S11029	Screw	1
18	10111009	Belt-cover B	1
19	101S30011	Driving belt cover wood screw	2
20	101280006	Wood screw washer	2



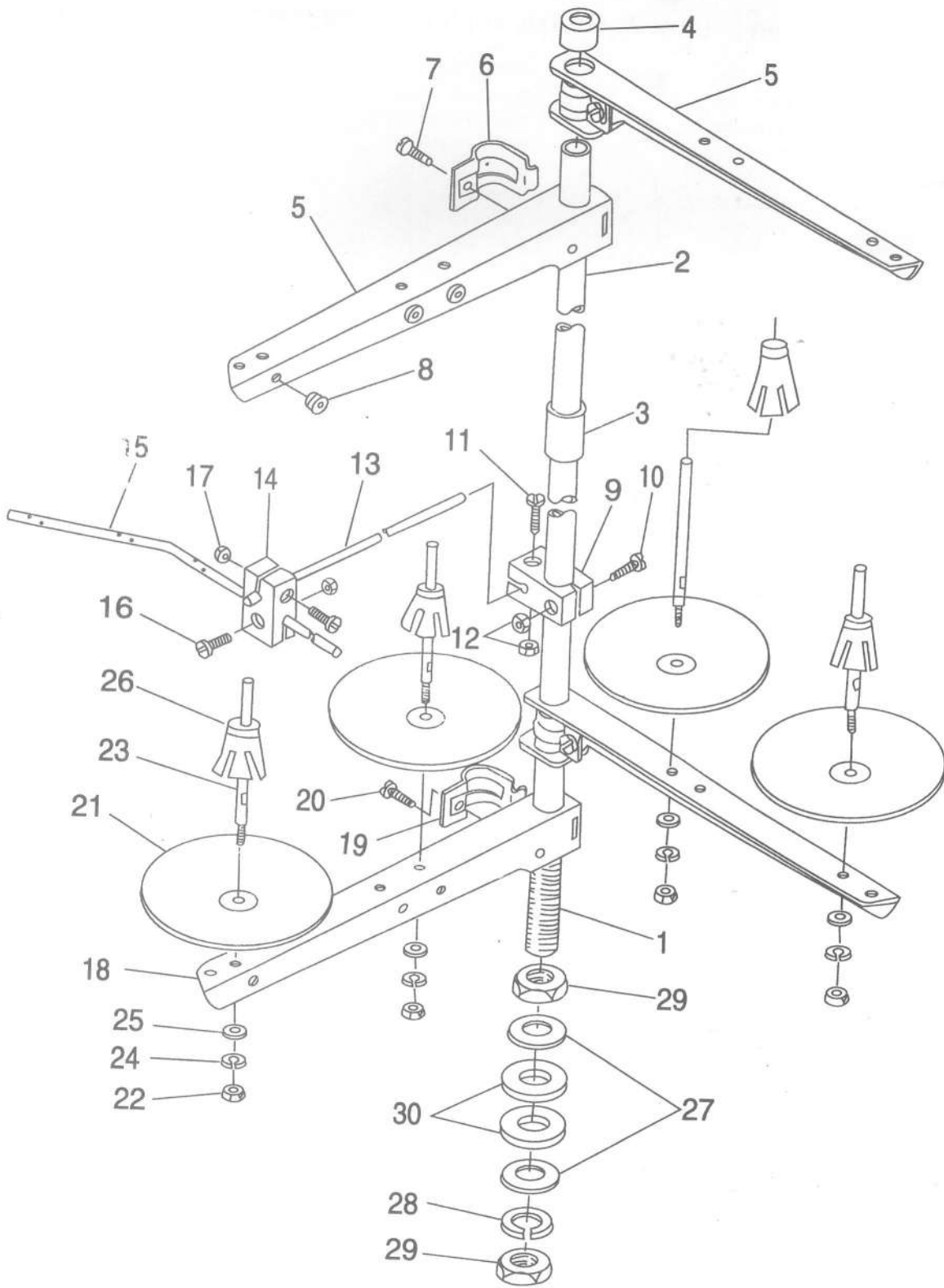
11. Quadruple-thread spool stand asm.

Ref. No.	Part No.	Description	Amt. Req.
1	20631027	Spool rest rod (upper)	1
2	20631012	Spool rest rod (lower)	1
3	20631016	Spool rested joint	1
4	20631011	Spool test rod rubber cap	1
5	20631014	Thread guide asm.	2*
6	20631025	Thread guide asm joint	2*
7	206S16008	Screw	2*
8	20631030	Thread guide ring	6**
9	20631017	Thread guide arm holder	1
10	206S30025	Screw	1
11	206S30023	Screw	1
12	206S16006	Nut	2
13	20631022	Thread guide arm	1
14	20631015	Thread guide arm holder	1
15	30113019	Lower thread guide	1
16	206S30027	Screw	2
17	206S16006	Nut	2
18	20631029	Spool rest arm.	2*
19	20631025	Thread guide arm joint	2*
20	206S16008	Screw	2*
21	20631024	Spool test	4***
22	206S16006	Nut	4***
23	20631023	Spool pin	4***
24	20631031	Spring washer	4***
25	20631018	Washer	4***
26	20631021	Spool cushion	4
27	20631028	Washer	2
28	20631018	Spring washer	1
29	206S16007	Nut	2
30	GR1753	Rubber washer	2

* 1pcs. for model JK-8558W/8560W-1

** 3pcs. for model JK-8558W/8560W-3

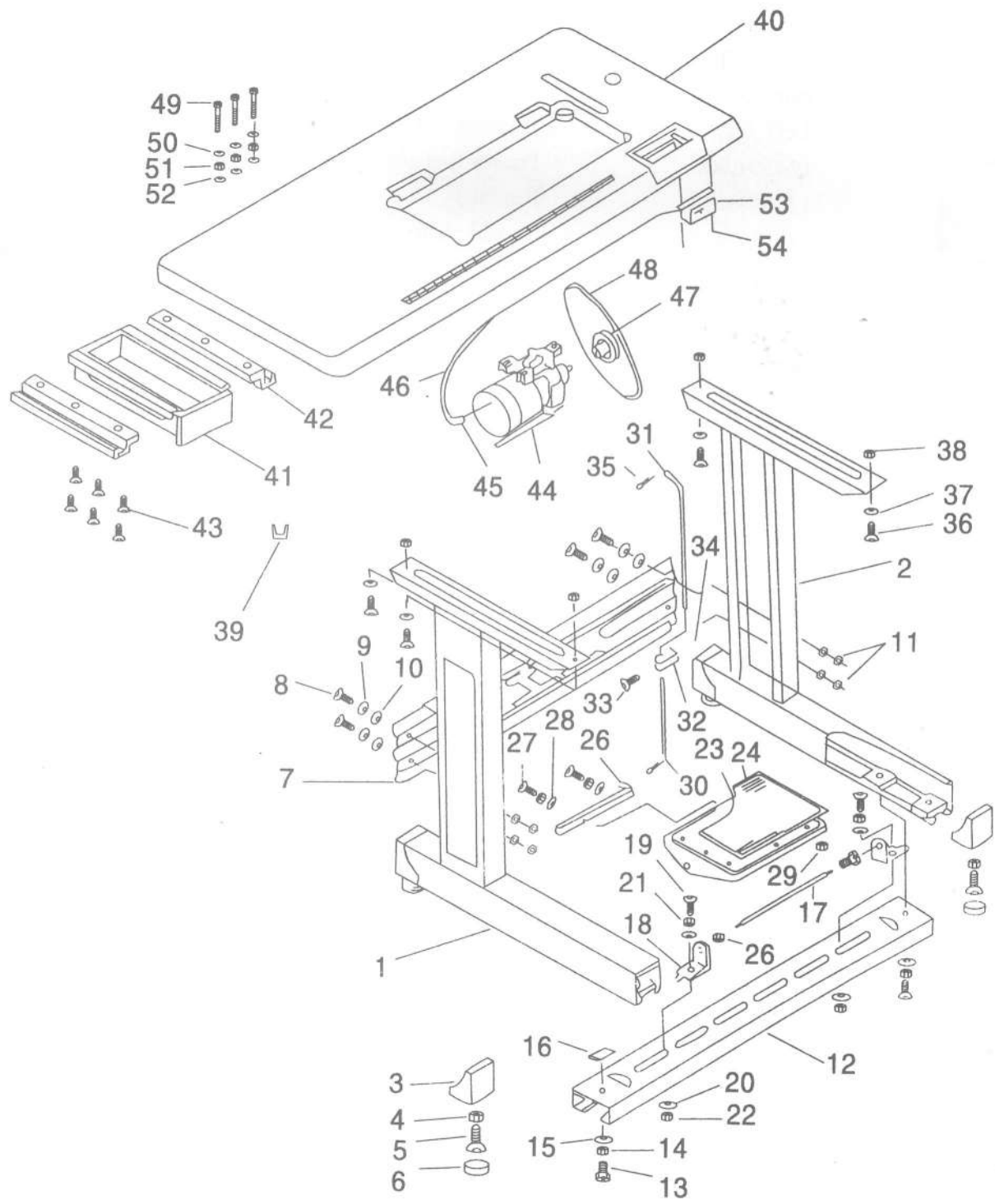
*** 2pcs. for model JK-8558W/8560W-2



12. Machine stand , table & electric appliance components *

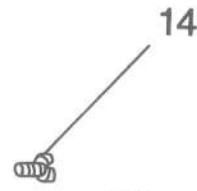
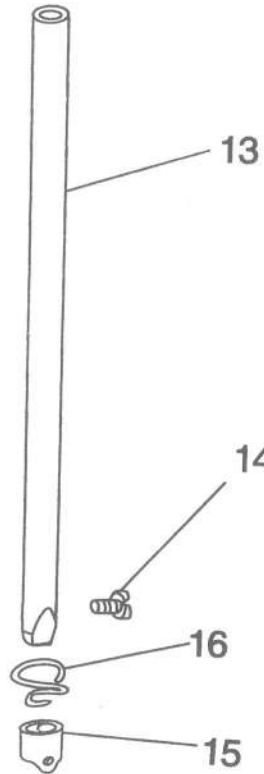
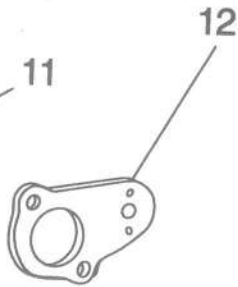
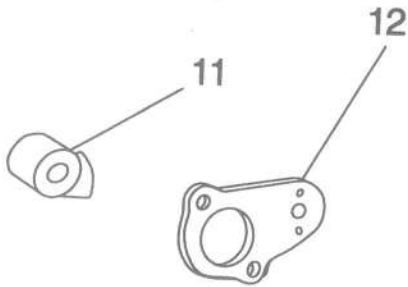
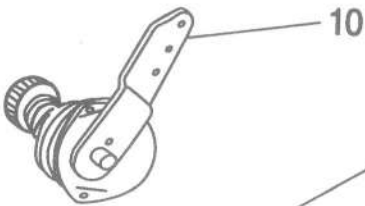
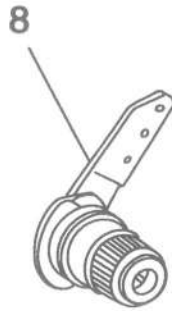
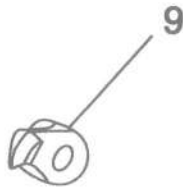
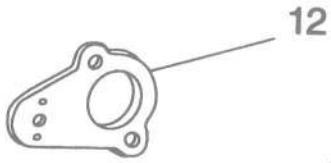
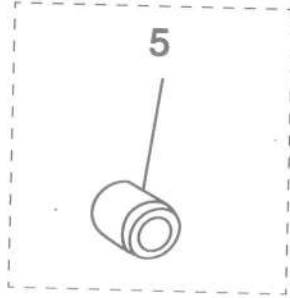
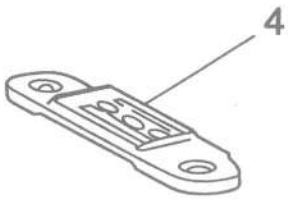
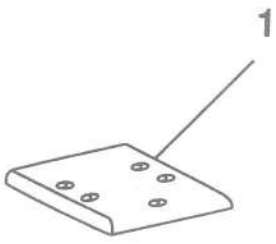
Ref. No.	Part No.	Description	Amt. Req.
1	1011204200	Stand side asm. left	1
2	1011204300	Stand side asm. right	1
3	10111015	Rubber cushion	4
4	N01010	Nut	4
5	101S30015	Screw	4
6	10122029	Space ring	4
7	10112044	Stand side support	1
8	L02014	Screw	4
9	10128011	Spring washer	4
10	W01010	Washer	8
11	N01011	Nut	4
12	10112045	Treadle brace	1
13	L02014	Screw	2
14	10128011	Spring washer	2
15	W01010	Washer	2
16	10112046	Treadle brace locknut plate	2
17	10102013	Treadle shaft	1
18	10112047	Treadle brakket	2
19	L02014	Screw	2
20	W01010	Washer	4
21	10128011	Spring washer	2
22	N01011	Nut	2
23	10112048	Trcable	1
24	10122030	Gas Ket	1
25	10103023	Collar	2
26	10112049	Treadle pitman	1
27	L02015	Screw	2
28	W01003	Washer	4
29	N01012	Nut	2
30	10112050	Pitman rod, lower	1
31	10127019	Spring	1
32	10112051	pitman rod, upper	1
33	10112052	Joint	1
34	L02015	Joint screw	1
35	N01012	Nut	1
36	10129001	Pitman rod split pin (upper)	1
37	101S30016	Table Wood screw	4
38	10128012	Table Wood screw washer	4
39	10128013	Table washer	4
40	10132002	Table	1
41	10111016	Drawer	1
42	10111017	Drawer rail	2
43	101S30017	Drawer rail wood screw	6
44	10133001	Motor GFC4024 motor	1
45	10130002	Motor connecting wire plug	1
46	10130003	Motor wire	1
47	10135004	Motor pulley	1
48	10135002	Machine driving beit	1
49	101S30018	Screw	3
50	10128014	Washer	3
51	10128011	Spring washer	3
52	N01011	Nut	3
53	10130004	Power source switch	1
54	101S30019	Power source switch wood screw	2

* Note that parts above mentioned shall be purchased in a separate order.
 * Note that parts above mentioned shall be purchased in a separate order.










13. Model one-needle high speed chainstitcher




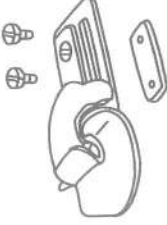
Ref. No.	Part No.	Description	Amt. Req.
1	12515002	Attachment installing plate	1
2	1251601000	Presser foot asm.	1
3	12514006	Feed dog	1
4	12515016	Thread plate	1
5	GR1998	Thread collar	1
6	12517009	Driving needle guard	1
7	12514007	Counter needle guard	1
8	1251300400	Needle thread tension asm.	1
9	12504017	Tension release latch	1
10	1251300500	Lower thread tension asm.	1
11	12504020	Looper thread release latch	1
12	12512065	Tension installing plate	2
13	11402005	Needle bar	1
14	101S11006	Screw	1
15	10113002	Needle bar thread guide	1
16	10113009	Thread guide	1



JK-8558-1/8558W-1/8560W-1

Name	Throat plate	Needles clamp	Presser foot asm.	Feed dog	Rear moving needle guard	Right fix needle guard	Left needle guard
							
Specifications							
*1 1/8"(3.2mm)	12615004	12634002	1261500500	12614002			
2 5/32"(4.0mm)	12615007	12634005	1261600700	12614005			
3 3/16"(4.8mm)	12615005	12634003	1261400400	12614003	12617002		
4 7/32"(5.6mm)	12615008	12634006	1261600500	12614006			
5 1/4"(6.4mm)	12615003	12634001	1261600100	12614001			
6 5/16"(7.9mm)	12615009	12634007	1261600600	12614007			
7 3/8"(9.5mm)	12615006	12634004	1261600300	12614004	12517007		
8 1/2"(12.7mm)	12615010	12634008	1261600700	12614008			
JK-8558-3/8558W-3							
9 0	12515017	12534006	1251601100	1251400	12517010	12605001	12605001

14. JK-8558-1/8558W-1/8560W-1

Name		Right loopet	Left loopet	Bed stide	Cam cover	Folder	
Specifications *1 1/8"(3.2mm) 2 5/32"(4.0mm) 3 3/16"(4.8mm) 4 7/32"(5.6mm) 5 1/4"(6.4mm) 6 5/16"(7.9mm) 7 3/8"(9.5mm) 8 1/2"(12.7mm)							
		12517002		12517001		1251206200	
		12517002		12517001		12615002	
		12517002		12517001		1251206100	
		12517002		12517001		1251206300	
		12517002		12517001		1251206500	
		12517002		12517001		1251206600	
		12517002		12517001		1251206400	
		12517002		12517001		12615003	
JK-8558-3/8558W-3							
9	0	12517002	12517001	12615001	12615002		