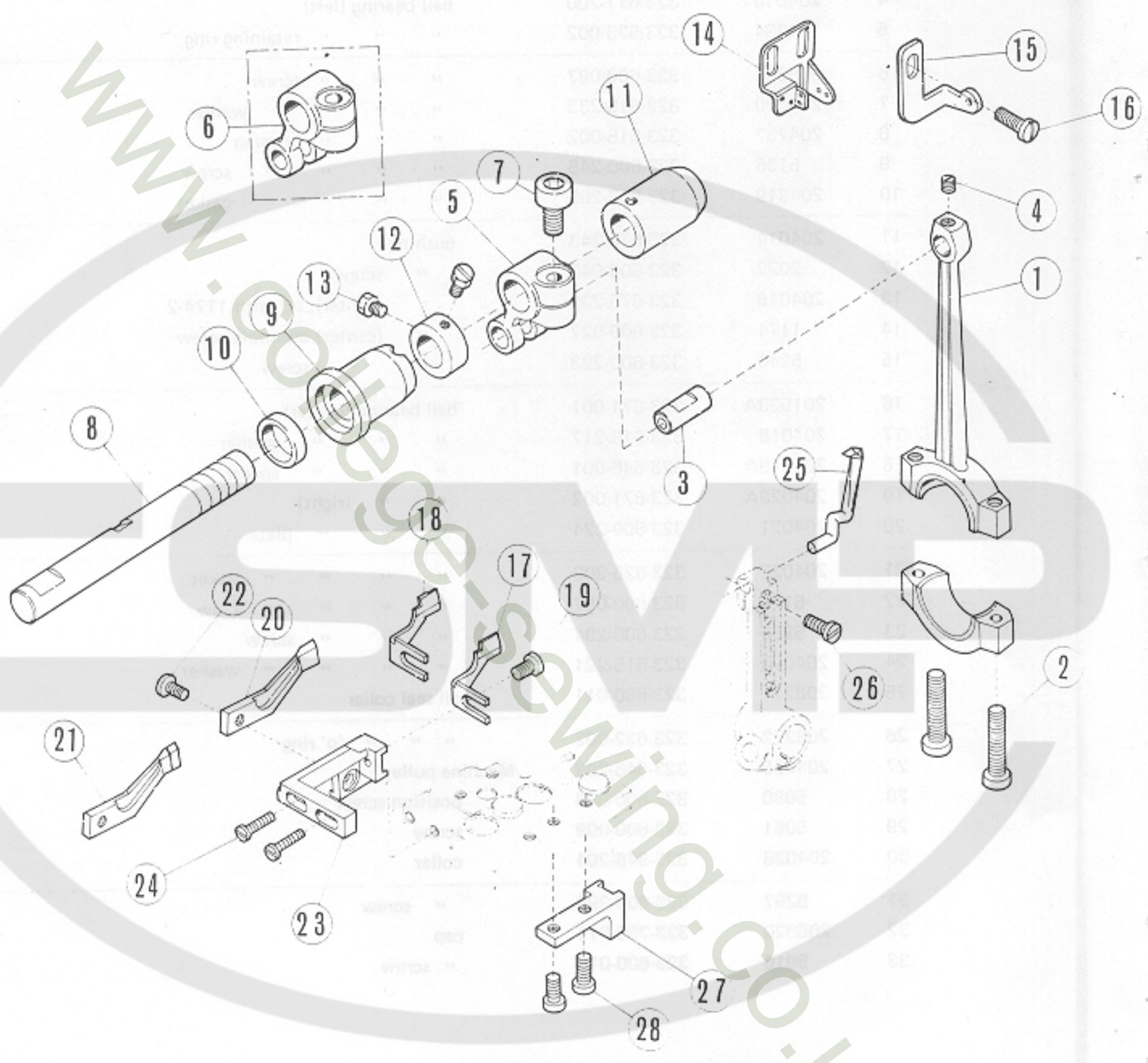


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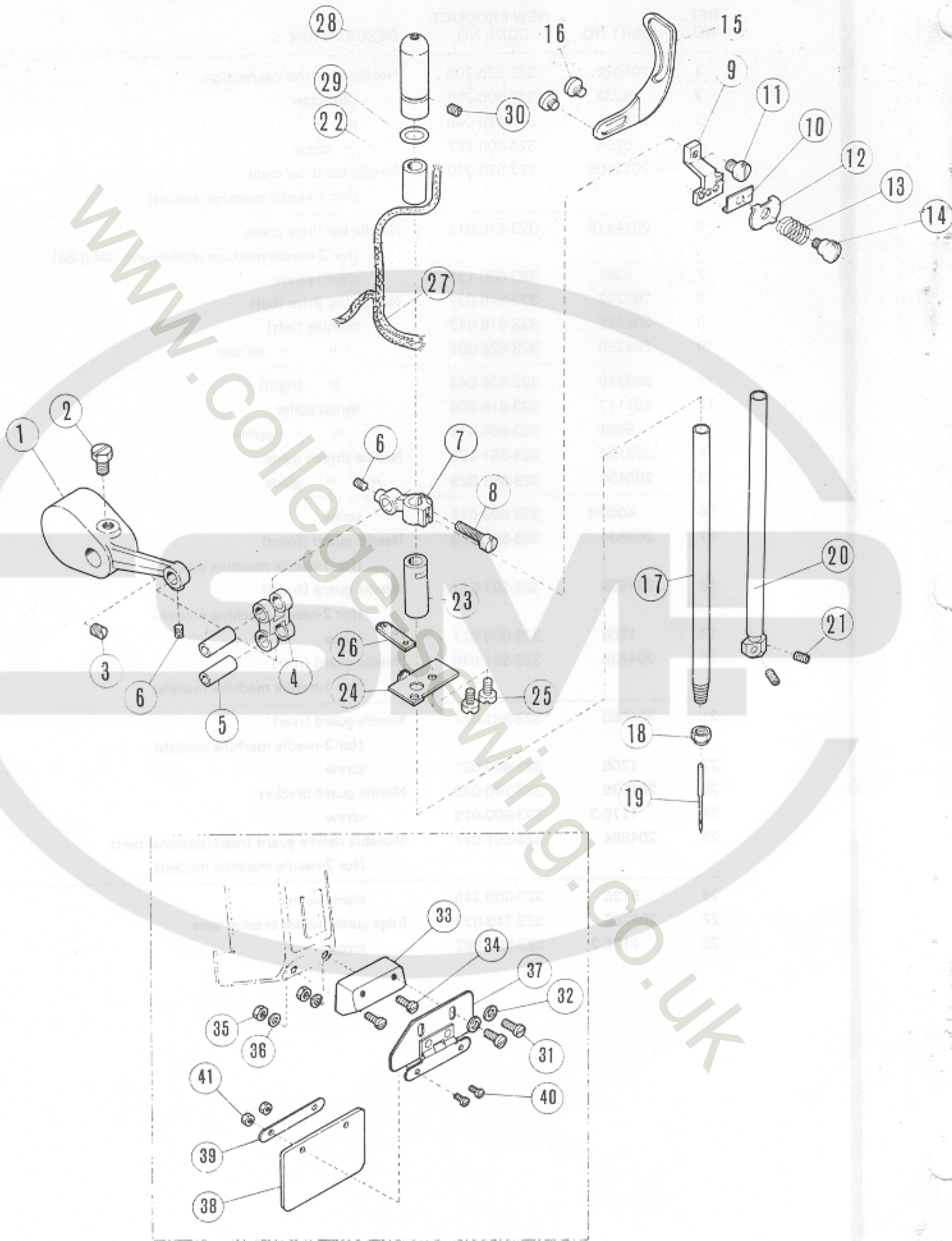
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CRANKSHAFT MECHANISM



(1) NEEDLE DRIVE MECHANISM

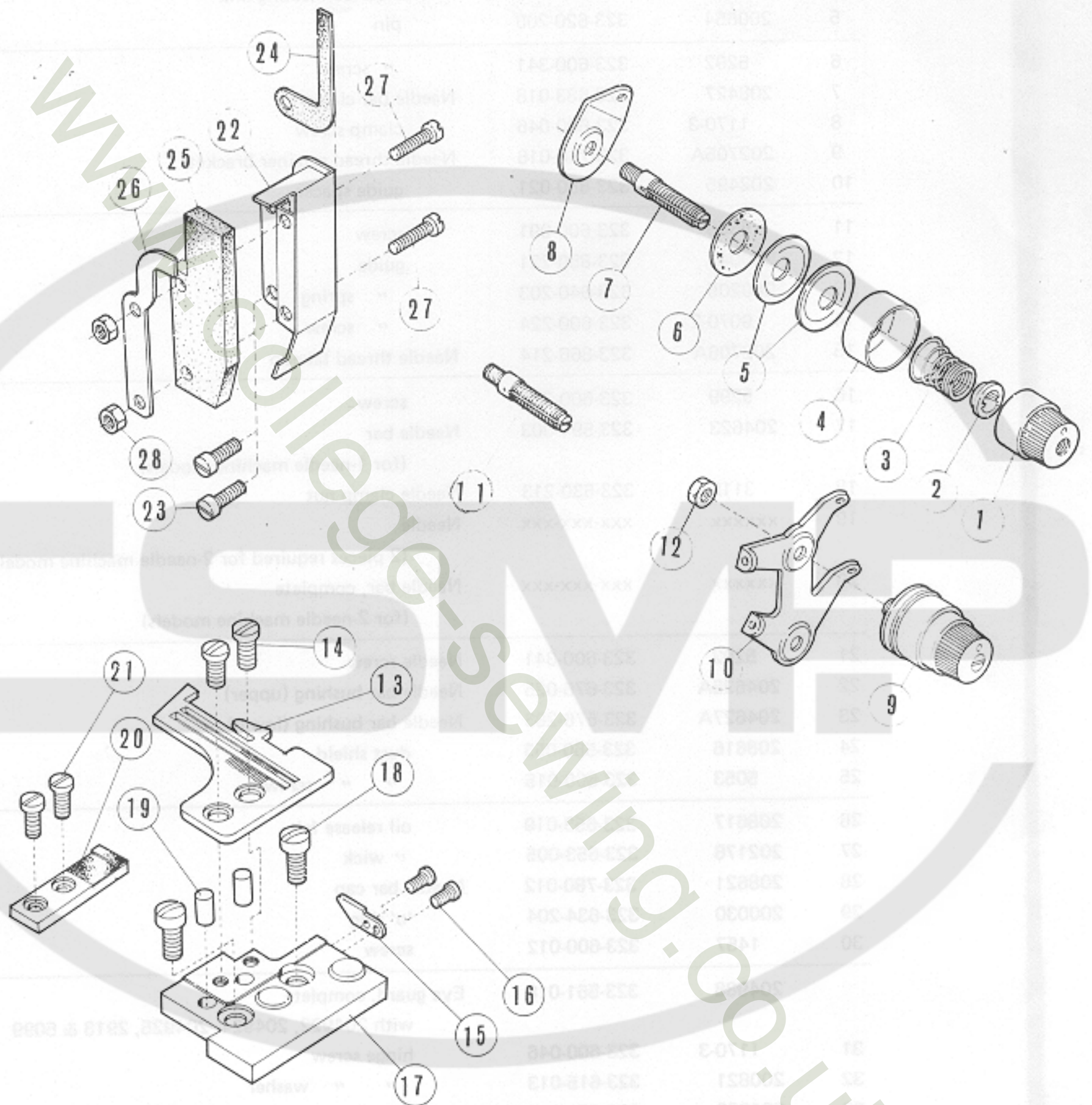
REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204029	323-535-205	Needle bar drive connection	1
2	5233	323-600-296	cap screw	2
3	205495	323-620-040	pin	1
4	5234	323-600-297	" screw	1
5	201360B	323-576-010	Needle bar drive crank (for 1-needle machine models)	1
6	201441B	323-576-011	Needle bar drive crank (for 2-needle machine models and 504-4-65)	1
7	5381	323-600-136	clamp screw	1
8	208247	323-540-027	Needle bar drive shaft	1
9	208248	323-676-042	bushing (left)	1
10	208250	323-626-002	" " oil seal	1
11	208249	323-676-043	" (right)	1
12	201117	323-618-006	thrust collar	1
13	5084	323-600-013	" " screw	2
14	202704	323-851-222	Needle thread guide	1
15	208400	323-851-025	" " guide	1
16	4009-1	323-600-014	screw	1
17	204634	323-561-009	Needle guard (front) (for 1-needle machine models)	1
18	204659	323-561-011	Needle guard (front) (for 2-needle machine models)	1
19	1206	323-600-021	screw	1
20	204635	323-561-010	Needle guard (rear) (for 1-needle machine models)	1
21	204660	323-561-011	Needle guard (rear) (for 2-needle machine models)	1
22	1206	323-600-021	screw	1
23	204636	323-740-018	Needle guard bracket	1
24	1175-3	323-600-019	screw	2
25	204884	323-561-017	Movable needle guard (rear) (optional part) (for 2-needle machine models)	1
26	5136	323-600-245	clamp screw	1
27	204762	323-740-037	Edge guide holder bracket base	1
28	1175-2	323-600-002	screw	2



(2) NEEDLE DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208424	323-576-017	Needle bar drive crank (left)	1
2	2022-4	323-600-022	screw (with head)	1
3	2022	323-600-043	screw	1
4	208425	323-730-012	Needle bar connecting link	1
5	200654	323-620-206	pin	2
6	5292	323-600-341	" screw	2
7	208427	323-683-018	Needle bar clamp	1
8	1170-3	323-600-046	clamp screw	1
9	202705A	323-740-016	Needle thread retainer bracket	1
10	202495	323-850-021	guide spacer	1
11	5359	323-600-091	screw	1
12	200041	323-850-221	guide	1
13	200205	323-640-203	" spring	1
14	9070-2	323-600-224	" screw	1
15	202706A	323-866-214	Needle thread takeup	1
16	5299	323-600-300	screw	2
17	204623	323-591-003	Needle bar (for 1-needle machine models)	1
18	3119	323-630-213	Needle clamp nut	1
19	xxxxxx	xxx-xxx-xxx	Needle (2 pieces required for 2-needle machine models)	1
20	xxxxxx	xxx-xxx-xxx	Needle bar, complete (for 2-needle machine models)	1
21	5292	323-600-341	Needle screw	2
22	204625A	323-676-025	Needle bar bushing (upper)	1
23	204627A	323-676-263	Needle bar bushing (lower)	1
24	208616	323-560-053	dust shield	1
25	5053	323-600-015	" " screw	2
26	208617	323-653-019	oil release felt	1
27	202176	323-653-005	" wick	1
28	208621	323-780-012	Needle bar cap	1
29	200030	323-634-204	'o' ring	1
30	1457	323-600-012	screw	1
	204988	323-561-018	Eye guard, complete with 204922, 204924, 204925, 2918 & 5099	1
31	1170-3	323-600-046	hinge screw	2
32	200821	323-615-013	" " washer	2
33	204982	323-505-012	" base	1
34	5003	323-600-227	" " screw	2
35	5099	323-630-009	" " " nut	2
36	167066	323-615-211	" " " " washer	2
37	204922	323-728-012	hinge, complete	1
38	204924	323-561-019	guard	1
39	204925	323-615-032	" screw nut washer	1
40	2918	323-600-073	" screw	2
41	5099	323-630-009	" " nut	2

(2) NEEDLE DRIVE MECHANISM

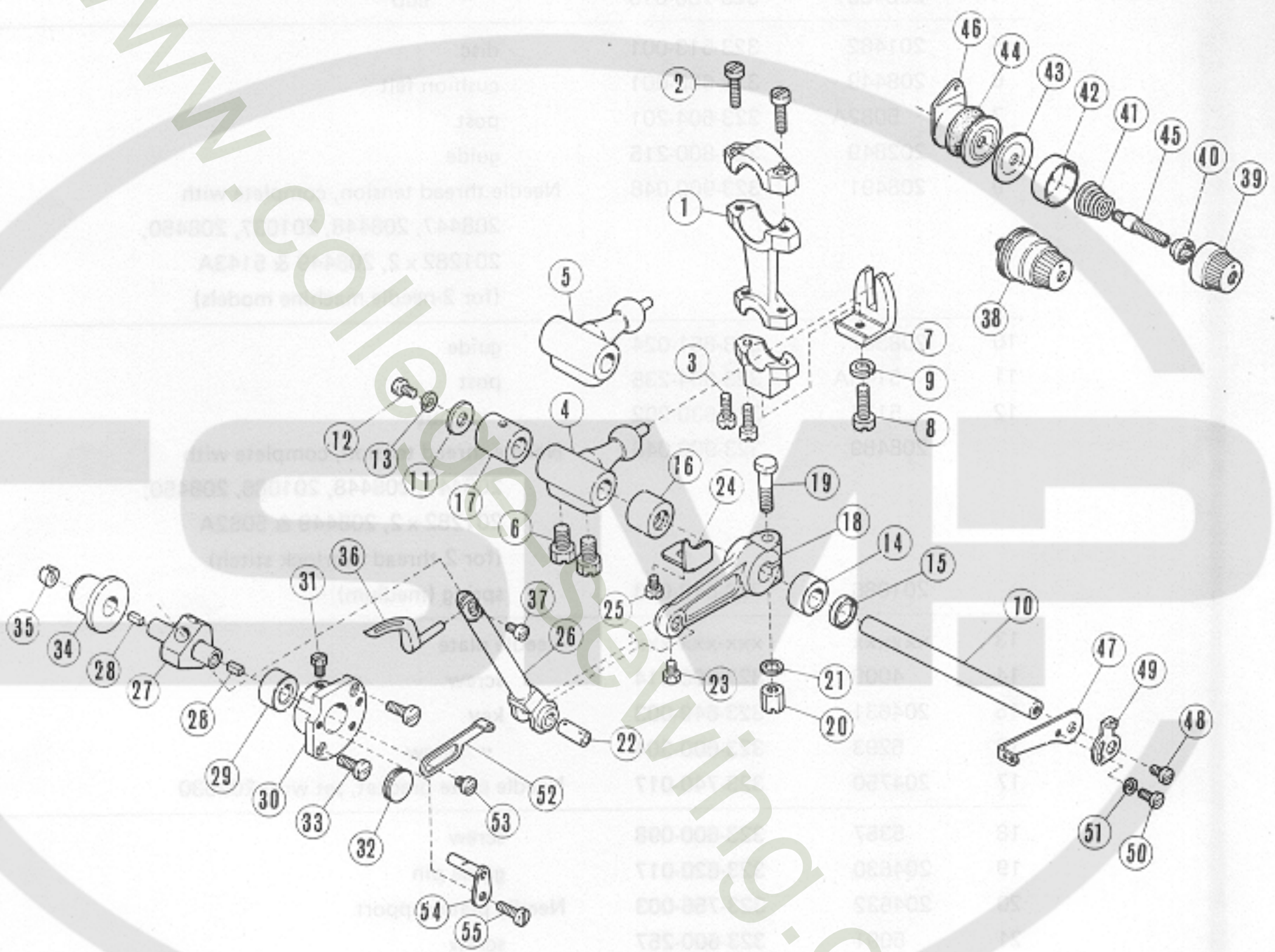


REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION
1	204214	323-600-017	Needle bar drive (left)
2	204214	323-600-022	Needle (with lead)
3	204222	323-600-042	Washer
4	204222	323-600-012	Needle bar connecting link
5	204224	323-600-000	Pin
6	204224	323-600-041	Pin
7	204227	323-600-010	Needle bar drive
8	17003	323-600-040	Needle bar drive
9	204224	323-600-010	Needle bar drive
10	204224	323-600-010	Needle bar drive
11	204222	323-600-010	Needle bar drive
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37	204222	323-600-010	Needle bar drive
38	204222	323-600-010	Needle bar drive
39	204222	323-600-010	Needle bar drive
40	204222	323-600-010	Needle bar drive
41	204222	323-600-010	Needle bar drive

(3) NEEDLE DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
	208488	323-900-045	Needle thread tension, complete with 208447, 208448, 201037, 208450, 201482 x 2, 208449 & 5082A (for 3-thread overlock stitch)	1
1	208447	323-630-033	nut	1
2	208448	323-676-047	spring bushing	1
3	201037	323-642-001	" (heavy)	1
4	208450	323-780-010	" cup	1
5	201482	323-613-001	disc	2
6	208449	323-650-001	cushion felt	1
7	5082A	323-604-201	post	1
8	202849	323-800-215	guide	1
9	208491	323-900-048	Needle thread tension, complete with 208447, 208448, 201037, 208450, 201282 x 2, 208449 & 5143A (for 2-needle machine models)	1
10	208307	323-851-024	guide	1
11	5143A	323-604-235	post	1
12	5137	323-630-202	" nut	1
	208489	323-900-046	Needle thread tension, complete with 208447, 208448, 201086, 208450, 201282 x 2, 208449 & 5082A (for 2-thread overlock stitch)	1
	201086	323-642-003	spring (medium)	1
13	xxxxxx	xxx-xxx-xxx	Needle plate	1
14	4009-1	323-600-014	screw	2
15	204631	323-649-003	key	1
16	5293	323-600-304	" screw	2
17	204750	323-740-017	Needle plate bracket, set with 204630	1
18	5357	323-600-098	screw	2
19	204630	323-620-017	guide pin	2
20	204632	323-756-003	Needle plate support	1
21	5091	323-600-257	screw	2
	208568	323-510-089	Needle bar connecting link cover, complete with 208560, 208561, 208562, 208563, 5291 & 5099	1
22	208560	323-510-090	Needle bar connecting link cover	1
23	5117	323-600-057	screw	2
24	208561	323-653-017	oil felt	1
25	208562	323-653-018	" felt	1
26	208563	323-800-062	" " plate	1
27	5291	323-600-313	" " " screw	2
28	5099	323-630-003	" " " " nut	2

(3) NEEDLE DRIVE MECHANISM



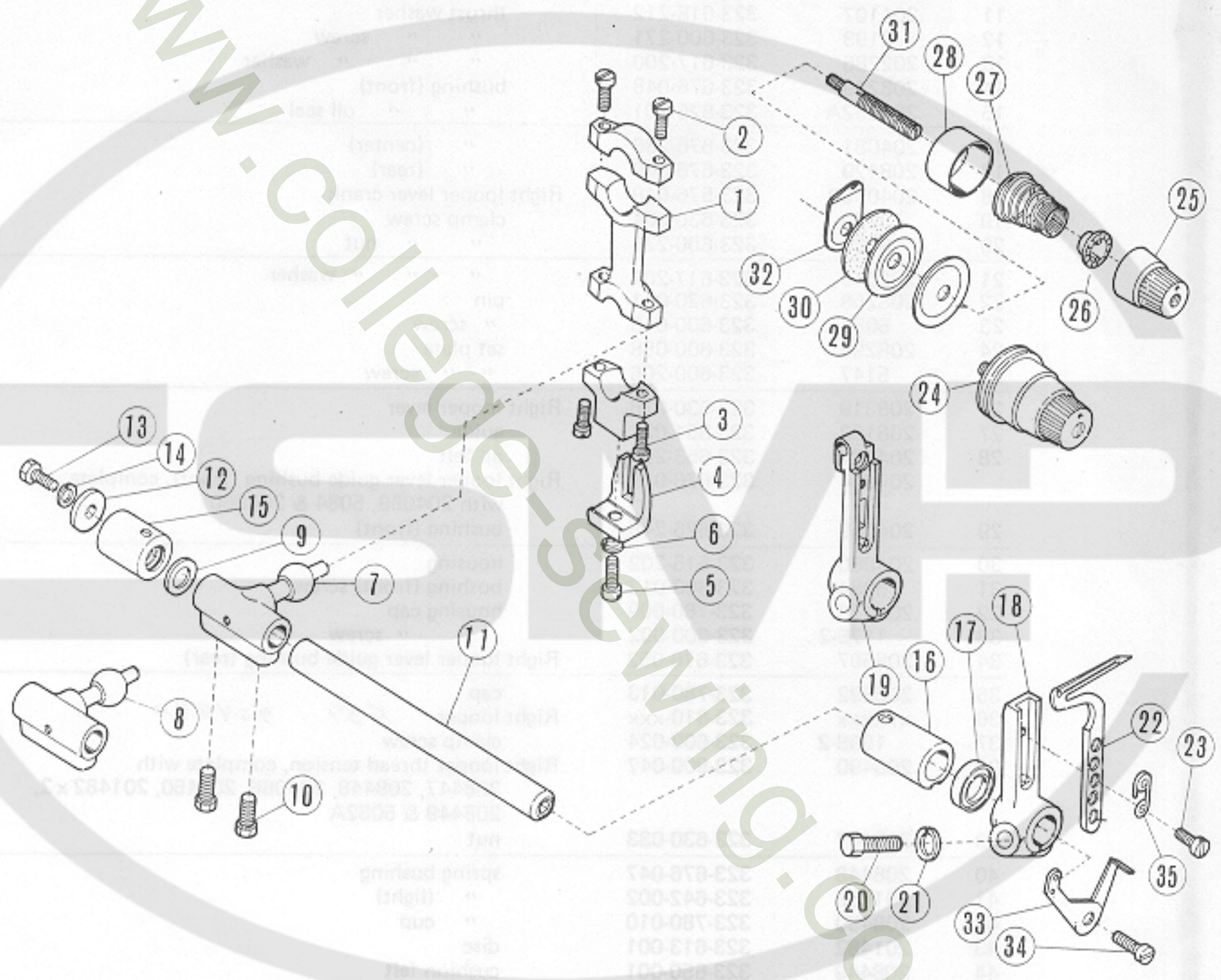
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RIGHT LOOPER DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208346	323-525-013	Right looper drive connection	1
2	2213-1	323-600-056	cap screw (large)	2
3	1170-1	323-600-020	" " (small)	2
4	204048A	323-576-213	drive crank	1
5	204788	323-576-007	drive crank (for 514-4-73 and 504-4-65 of 7 & 8mm gauges)	1
6	2022-4	323-600-022	screw	2
7	201074A	323-850-200	guide	1
8	1156	323-600-200	" screw	1
9	202286	323-617-200	" " washer	1
10	204069A	323-540-228	Right looper drive shaft	1
11	204107	323-618-212	thrust washer	1
12	2193	323-600-271	" " screw	1
13	202286	323-617-200	" " " washer	1
14	208299	323-676-048	bushing (front)	1
15	204052A	323-626-201	" " oil seal	1
16	204081	323-676-236	" (center)	1
17	208429	323-676-049	" (rear)	1
18	204055B	323-576-018	Right looper lever crank	1
19	5239	323-630-304	clamp screw	1
20	5286	323-600-225	" " nut	1
21	202045	323-617-204	" " " washer	1
22	208258	323-620-041	pin	1
23	5084	323-600-013	" screw	1
24	208296	323-800-058	set plate	1
25	5147	323-600-206	" " screw	1
26	208319	323-530-028	Right looper lever	1
27	208102	323-851-022	guide	1
28	204274	323-653-209	oil felt	2
	204854	323-676-029	Right looper lever guide bushing (front), complete with 204059, 5084 & 204060	1
29	204059	323-676-248	bushing (front)	1
30	204060	323-515-202	housing	1
31	5084	323-600-013	bushing (front) screw	1
32	208173	323-780-009	housing cap	1
33	1175-2	323-600-002	" " screw	2
34	208597	323-676-052	Right looper lever guide bushing (rear)	1
35	208592	323-780-013	cap	1
36	xxxxxx	323-810-xxx	Right looper <i>ESI 204990</i>	1
37	1998-2	323-600-024	clamp screw	1
38	208490	323-900-047	Right looper thread tension, complete with 208447, 208448, 201068, 208450, 201482 x 2, 208449 & 5082A	1
39	208447	323-630-033	nut	1
40	208448	323-676-047	spring bushing	1
41	201068	323-642-002	" (light)	1
42	208450	323-780-010	" cup	1
43	201482	323-613-001	disc	2
44	208449	323-650-001	cushion felt	1
45	5082A	323-604-201	post	1
46	202849	323-800-215	guide	1
47	208445	323-866-016	Right looper thread takeup	1
48	202902	323-600-259	screw	1
49	204902	323-866-013	auxiliary	1
50	2921	323-600-026	" screw	1
51	202875	323-615-216	" " washer	1
52	204905	323-851-018	Right looper thread guide wire	1
53	2905	323-600-074	screw	1
54	204656	323-851-010	Looper thread guide, complete	1
55	5012	323-600-255	screw	1

RIGHT LOOPER DRIVE MECHANISM

REF NO	PART NO	NEW PRODUCT CODE NO	DESCRIPTION
1	207048	323-622-013	Right looper drive capstan
2	207048	323-622-013	Right looper drive capstan
3	207048	323-622-013	Right looper drive capstan
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35	207048	323-622-013	Right looper drive capstan



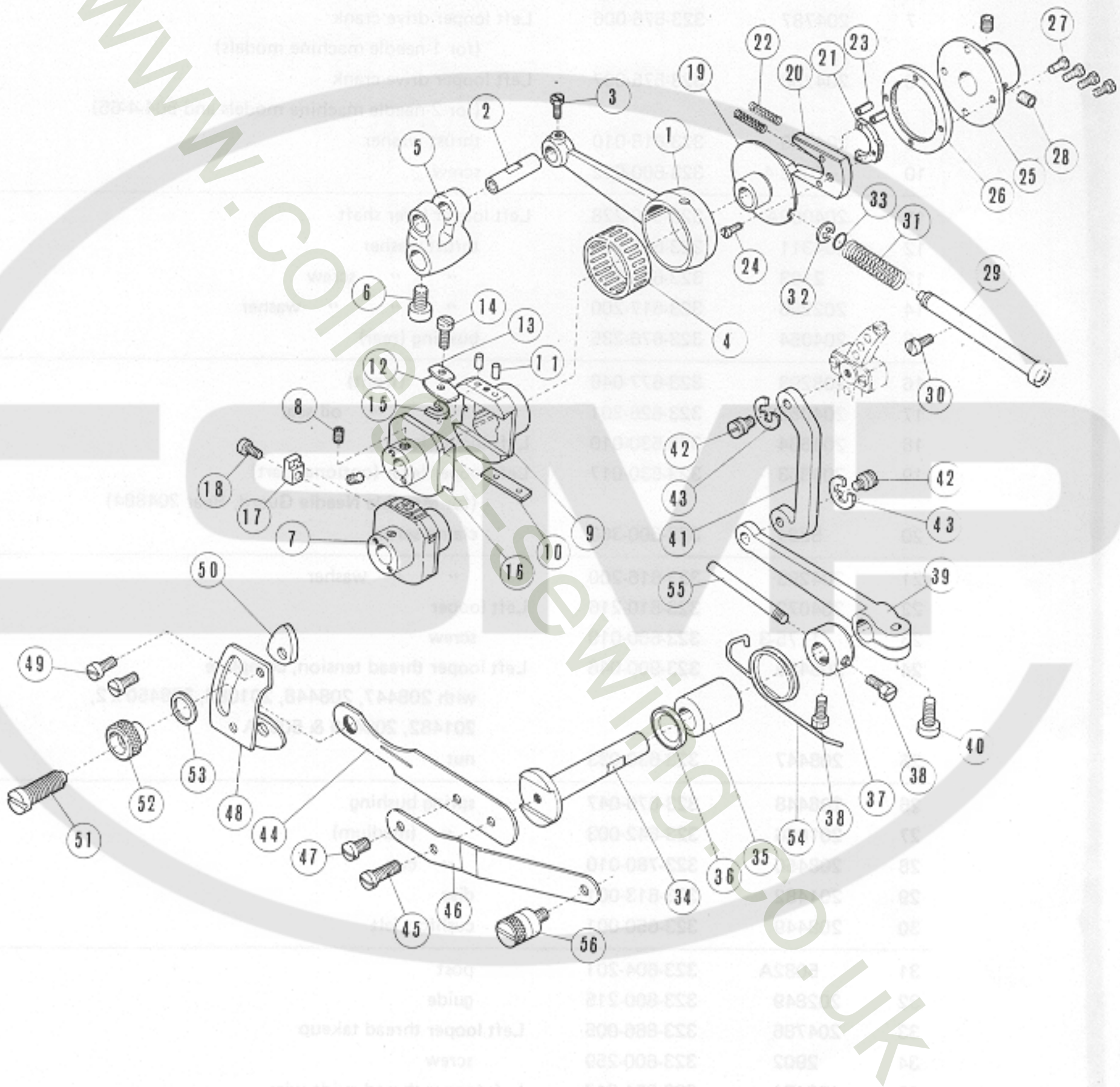
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LEFT LOOPER DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208346	323-525-013	Left looper drive connection	1
2	2213-1	323-600-056	cap screw (large)	2
3	1170-1	323-600-020	" " (small)	2
4	201074A	323-850-200	guide	1
5	1156	323-600-200	" screw	1
6	202286	323-617-200	" " washer	1
7	204787	323-576-006	Left looper drive crank (for 1-needle machine models)	1
8	204788	323-576-007	Left looper drive crank (for 2-needle machine models and 504-4-65)	1
9	204789	323-618-010	thrust washer	1
10	2022-4	323-600-022	screw	2
11	204069A	323-540-228	Left looper lever shaft	1
12	204311	323-618-210	thrust washer	1
13	2193	323-600-271	" " screw	1
14	202286	323-617-200	" " " washer	1
15	204054	323-676-235	bushing (rear)	1
16	208293	323-677-046	" (front)	1
17	204052A	323-626-201	" " oil seal	1
18	204664	323-530-010	Left looper lever	1
19	204853	323-530-017	Left looper lever (optional part) (for Movable Needle Guard, Rear 204884)	1
20	5284	323-600-306	clamp screw	1
21	204293	323-616-200	" " washer	1
22	204072	323-810-216	Left looper screw	1
23	1175-3	323-600-019		1
24	208489	323-900-046	Left looper thread tension, complete with 208447, 208448, 201086, 208450 x 2, 201482, 208449 & 5082A	1
25	208447	323-630-033	nut	1
26	208448	323-676-047	spring bushing	1
27	201086	323-642-003	" (medium)	1
28	208450	323-780-010	" cup	1
29	201482	323-613-001	disc	2
30	208449	323-650-001	cushion felt	1
31	5082A	323-604-201	post	1
32	202849	323-800-215	guide	1
33	204786	323-866-005	Left looper thread takeup	1
34	2902	323-600-259	screw	1
35	193174	323-851-217	Left looper thread guide wire	1

LEFT LOOPER DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION
1	302341	323-600-013	Left looper drive connector
2	32431	323-600-088	Cap screw (large)
3	17701	323-600-020	Washer (small)
4	301074A	323-600-300	Guide
5	1465	323-600-000	Washer
6	302382	323-613-200	Washer
7	302387	323-613-006	Left looper drive crank
8	302387	323-613-006	Left looper drive crank
9	302387	323-613-006	Left looper drive crank
10	302387	323-613-006	Left looper drive crank
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56	302387	323-613-006	Left looper drive crank

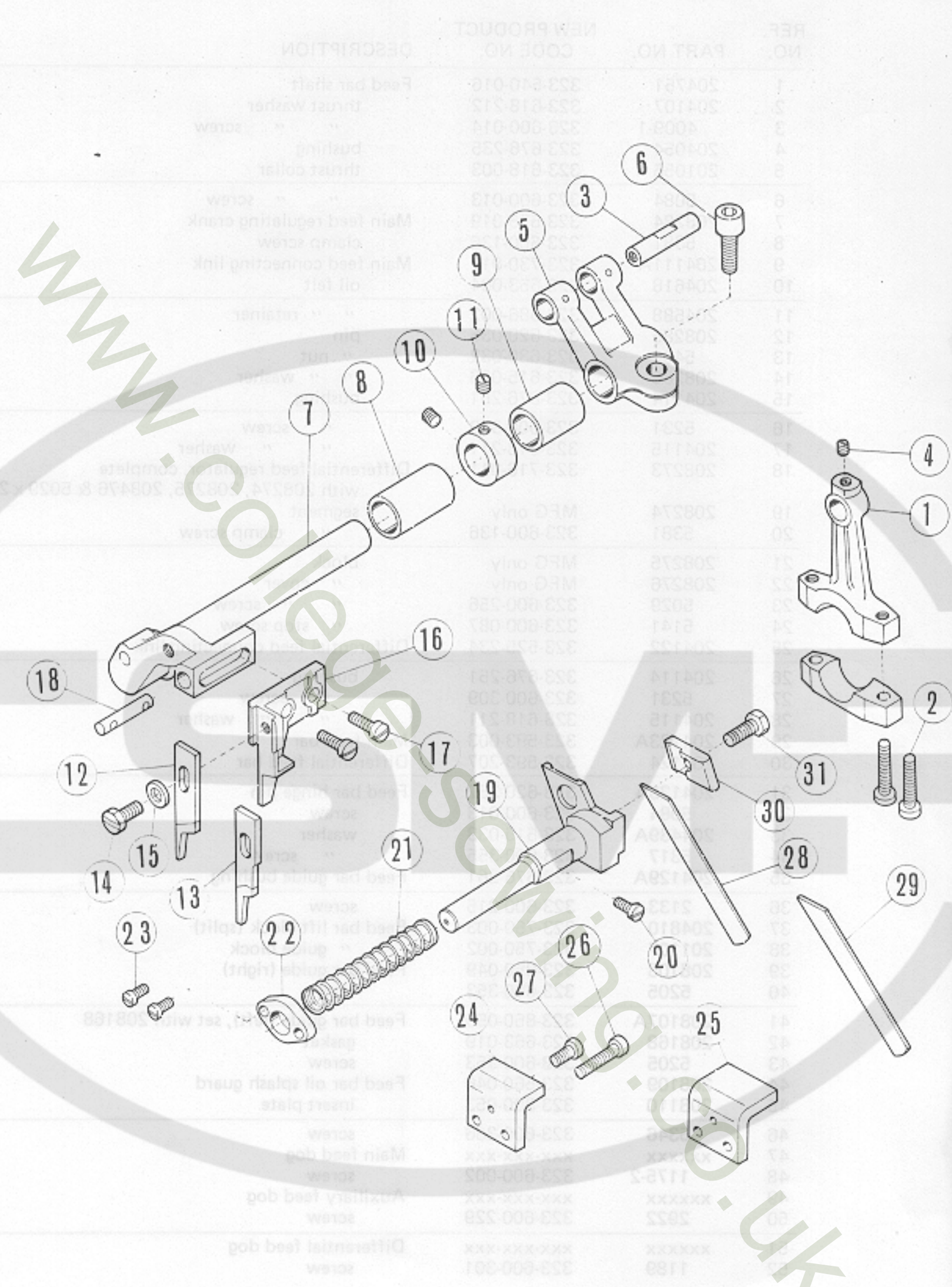


(1) MAIN AND DIFFERENTIAL FEED DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204100	323-525-232	Feed drive connection	1
2	205495	323-620-040	pin	1
3	5084	323-600-013	" screw	1
4	204084	323-672-200	needle bearing	1
5	204085	323-576-220	Feed drive crank	1
	208333	323-576-020	Feed drive crank (for 503-4-44 and 503-4-48 only)	1
6	5381	323-600-136	clamp screw	1
7	208282	323-580-084	Feed eccentric, complete with 208273, 208279, 208207, 208208, 204354 x 2, 208209, 1196, 208330 & 1175-3	1
8	5312	323-600-351	screw	2
9	208279	MFG only	feed eccentric	1
10	208207	323-787-005	" " liner	1
11	204354	323-620-251	" " pin	2
12	208208	323-800-063	" " spring plate (large)	1
13	208209	323-800-064	" " " " (small)	1
14	1196	323-600-029	" " " " screw	1
15	208409	323-618-018	" " " " " washer	1
16	208283	MFG only	" " retainer	1
17	208330	323-625-002	Feed eccentric stopper, complete	1
18	1175-3	323-600-019	screw	1
19	208410	323-716-013	Feed eccentric regulator	1
	208411	323-900-050	Feed eccentric regulator position gear, complete with 208413, 208463 x 2, 208412 & 5336	1
20	208413	MFG only	position gear bracket	1
21	208412	MFG only	" gear	1
22	208415	323-640-027	spring	2
23	204863	MFG only	pin	2
24	5336	323-600-116	screw	1
	208416	323-900-051	Feed eccentric regulator position internal gear, complete with 208417, 208418 & 5366	1
25	208418	MFG only	internal gear bracket	1
26	208417	MFG only	" gear	1
27	5366	323-600-124	screw	4
28	5312	323-600-351	screw	2
29	208420	323-535-004	Feed eccentric push rod	1
30	5412	323-600-134	screw	1
31	208421	323-640-021	spring	1
32	202522	323-634-200	retaining ring	1
33	204185	323-632-201	'o' ring	1
34	204752	323-540-017	Differential feed shaft	1
35	208294	323-676-045	bushing	1
36	204052A	323-626-201	oil seal	1
37	204754	323-680-007	thrust collar	1
38	5084	323-600-013	" " screw	2
39	204139A	323-502-213	Differential feed shaft arm	1
40	5381	323-600-136	clamp screw	1
41	204140A	323-730-214	Differential feed link	1
42	5316	323-600-347	screw, set with 202522	2
43	202522	323-634-200	screw retaining ring	2
44	204755	323-530-011	Differential feed regulating lever (rear)	1
45	5118	323-600-060	screw	1
46	204883	323-530-018	lever (front)	1
47	1216	323-600-068	" " screw	1
48	204142B	323-800-036	" guide	1
49	5118	323-600-060	" " screw	2
50	204143A	323-891-200	" lift guide	2
51	5321A	323-600-083	" adjust screw	1
52	204870	323-630-017	" " nut	1
53	202868	323-618-209	" " " washer	1
54	204756	323-640-006	Differential feed regulating spring	1
55	204757	323-600-102	latch screw	1
56	204869	323-600-107	Knee controller chain hook latch screw	1

(2) MAIN AND DIFFERENTIAL FEED DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204751	323-540-016	Feed bar shaft	1
2	204107	323-618-212	thrust washer	1
3	4009-1	323-600-014	" " screw	1
4	204054	323-676-235	bushing	2
5	201056	323-618-003	thrust collar	1
6	5084	323-600-013	" " screw	2
7	208284	323-576-019	Main feed regulating crank	1
8	5381	323-600-136	clamp screw	1
9	204111A	323-730-011	Main feed connecting link	1
10	204618	323-653-004	oil felt	1
11	204588	323-686-002	" " retainer	1
12	208285	323-620-035	pin	1
13	5404	323-630-032	" nut	1
14	208286	323-615-036	" " washer	1
15	204114	323-676-251	bushing	1
16	5231	323-600-309	" screw	1
17	204115	323-618-211	" " washer	2
18	208273	323-716-011	Differential feed regulator, complete with 208274, 208275, 208476 & 5029 x 2	1
19	208274	MFG only	segment	1
20	5381	323-600-136	" clamp screw	1
21	208275	MFG only	block	1
22	208276	MFG only	" cover	1
23	5029	323-600-256	" " screw	2
24	5141	323-600-087	" stop screw	1
25	204122	323-525-234	Differential feed connecting link	1
26	204114	323-676-251	bushing	1
27	5231	323-600-309	" screw	1
28	204115	323-618-211	" " washer	2
29	204123A	323-593-003	Main feed bar	1
30	204124	323-593-207	Differential feed bar	1
31	204128A	323-620-252	Feed bar hinge pin	1
32	5084	323-600-013	screw	1
33	204439A	323-615-033	washer	1
34	5317	323-600-355	" screw	1
35	204129A	323-676-261	Feed bar guide bushing	1
36	2133-1	323-600-215	screw	1
37	204810	323-750-003	Feed bar lift block (split)	1
38	201107	323-750-002	" " guide block	2
39	208108	323-850-049	Feed bar guide (right)	1
40	5205	323-600-353	screw	2
41	208107A	323-850-050	Feed bar guide (left), set with 208168	1
42	208168	323-663-019	gasket	1
43	5205	323-600-353	screw	2
44	208109	323-560-046	Feed bar oil splash guard	2
45	208110	323-800-053	insert plate	1
46	5346	323-600-366	screw	4
47	xxxxxx	xxx-xxx-xxx	Main feed dog	1
48	1175-2	323-600-002	screw	1
49	xxxxxx	xxx-xxx-xxx	Auxiliary feed dog	1
50	2922	323-600-229	screw	1
51	xxxxxx	xxx-xxx-xxx	Differential feed dog	1
52	1189	323-600-301	screw	1



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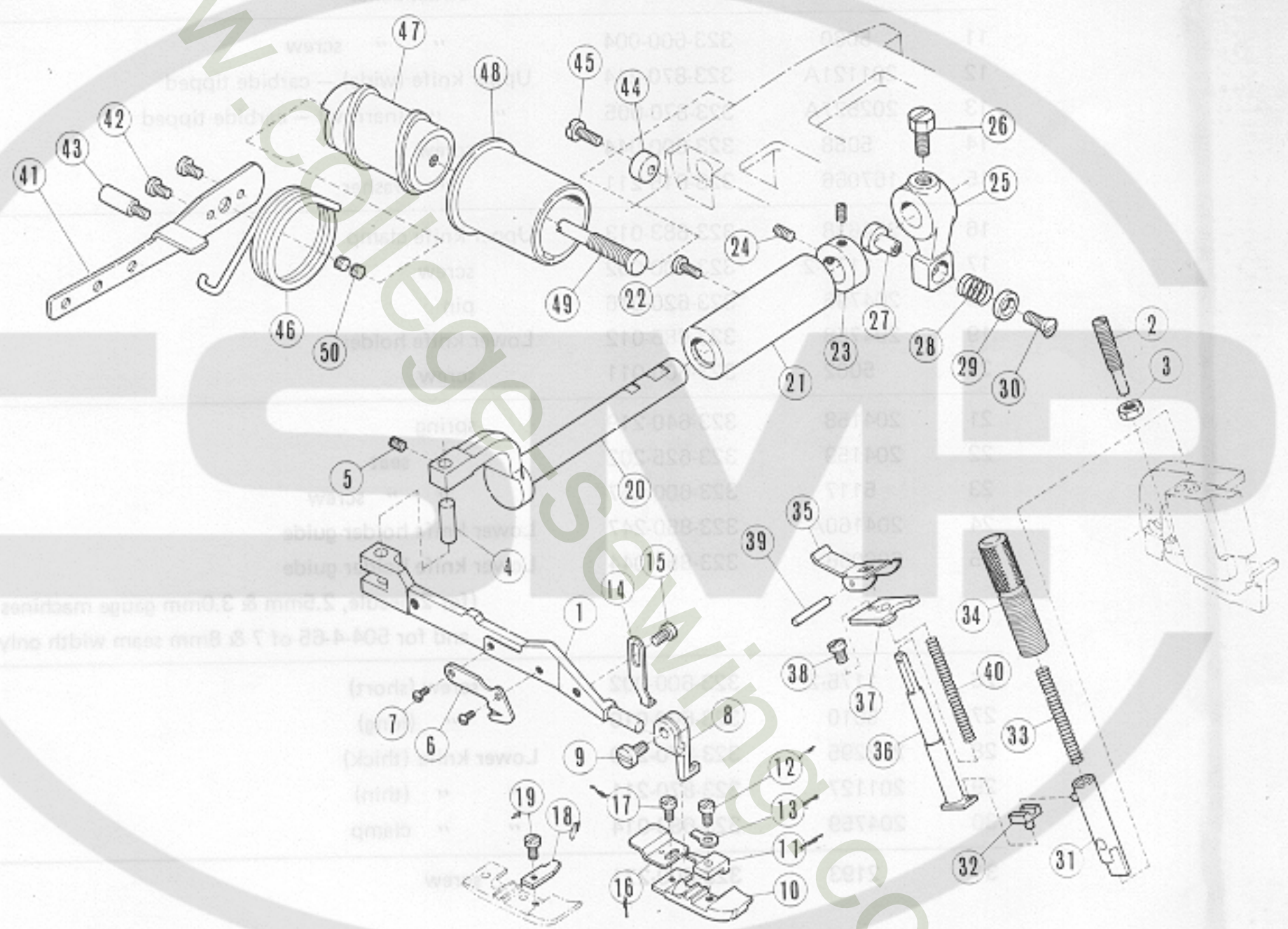
REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION
1	304751	323-610-016	Feed bar shaft
2	304107	323-618-212	Thrust washer
3	40091	323-600-014	Screw
4	301051	323-618-225	Pushing
5	301071	323-618-003	Thrust collar
6	301071	323-618-003	Thrust collar
7	301071	323-618-003	Thrust collar
8	301071	323-618-003	Thrust collar
9	301071	323-618-003	Thrust collar
10	301071	323-618-003	Thrust collar
11	301071	323-618-003	Thrust collar
12	301071	323-618-003	Thrust collar
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15	301071	323-618-003	Thrust collar
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23	301071	323-618-003	Thrust collar
24	301071	323-618-003	Thrust collar
25	301071	323-618-003	Thrust collar
26	301071	323-618-003	Thrust collar
27	301071	323-618-003	Thrust collar
28	301071	323-618-003	Thrust collar
29	301071	323-618-003	Thrust collar
30	301071	323-618-003	Thrust collar
31	301071	323-618-003	Thrust collar

UPPER AND LOWER KNIFE DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204145A	323-525-014	Upper knife drive connection	1
2	5233	323-600-296	cap screw	2
3	204146	323-620-244	pin	1
4	1458	323-600-037	" screw	1
5	204147	323-525-236	Upper knife drive crank	1
6	5381	323-600-136	clamp screw	1
7	204148B	323-685-008	Upper knife lever	1
8	204149	323-676-239	bushing (left)	1
9	204150	323-680-208	" (right)	1
10	201635	323-680-207	thrust coilar	1
11	5060	323-600-004	" " screw	2
12	201121A	323-870-214	Upper knife (wide) – carbide tipped	1
13	202527A	323-870-005	" " (narrow) – carbide tipped	1
14	5088	323-600-044	screw	1
15	167066	323-615-211	" washer	1
16	204638	323-683-013	Upper knife clamp	1
17	1175-2	323-600-002	screw	2
18	204796	323-620-016	pin	1
19	204758	323-685-012	Lower knife holder	1
20	5002	323-600-011	screw	1
21	204158	323-640-219	spring	1
22	204159	323-625-202	" seat	1
23	5117	323-600-057	" " screw	2
24	204160A	323-850-247	Lower knife holder guide	1
25	208096	323-850-044	Lower knife holder guide (for 2-needle, 2.5mm & 3.0mm gauge machines and for 504-4-65 of 7 & 8mm seam width only)	1
26	1175-2	323-600-002	screw (short)	1
27	5010	323-600-010	" (long)	1
28	202295	323-870-210	Lower knife (thick)	1
29	201127	323-870-211	" " (thin)	1
30	204759	323-683-014	" " clamp	1
31	2193	323-600-271	screw	1

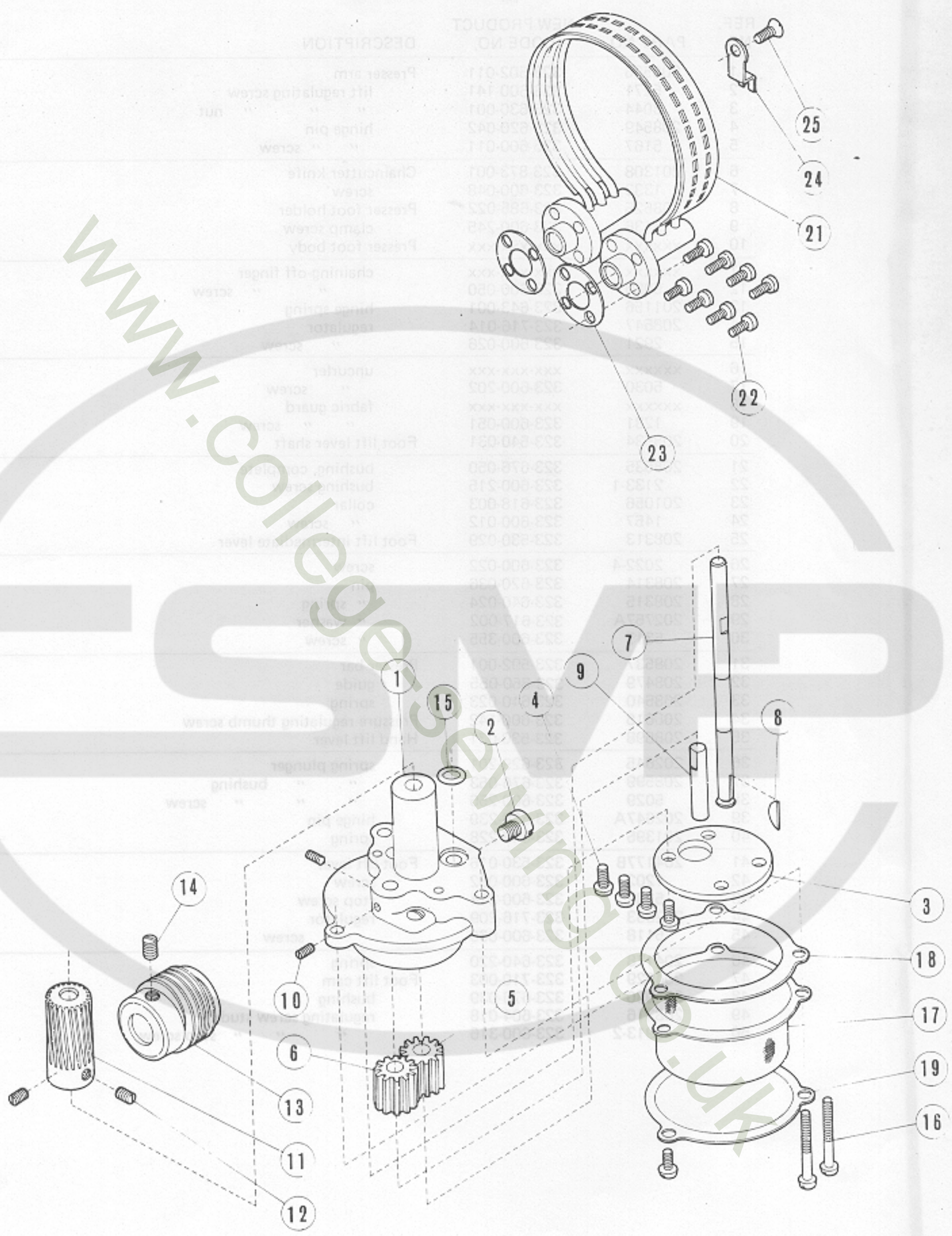
UPPER AND LOWER KNIFE DRIVE MECHANISM

REF NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION
1	204145A	323-828-014	Upper knife drive connection
2	8233	323-800-298	cap screw
3	204146	323-820-244	pin
4	1488	323-800-037	" screw
5	204147	323-828-238	Upper knife drive crank
6	6381	323-800-138	clamp screw
7	204148B	323-888-008	Upper knife lever
8	204149	323-876-238	pushing (left)
9	204150	323-800-207	pushing (right)
10	201632	323-800-207	driving roller
11	8233	323-800-014	screw
12	8233	323-876-238	carbide tipped
13	8233	323-876-238	carbide tipped
14	8233	323-876-238	carbide tipped
15	8233	323-876-238	carbide tipped
16	8233	323-876-238	carbide tipped
17	8233	323-876-238	carbide tipped
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36	8233	323-876-238	carbide tipped
37	8233	323-876-238	carbide tipped
38	8233	323-876-238	carbide tipped
39	8233	323-876-238	carbide tipped
40	8233	323-876-238	carbide tipped
41	8233	323-876-238	carbide tipped
42	8233	323-876-238	carbide tipped
43	8233	323-876-238	carbide tipped
44	8233	323-876-238	carbide tipped
45	8233	323-876-238	carbide tipped
46	8233	323-876-238	carbide tipped
47	8233	323-876-238	carbide tipped
48	8233	323-876-238	carbide tipped
49	8233	323-876-238	carbide tipped
50	8233	323-876-238	carbide tipped



PRESSER FOOT AND LIFT MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208526	323-502-011	Presser arm	1
2	5271	323-600-141	lift regulating screw	1
3	3044	323-630-001	" " " nut	1
4	208549	323-620-042	hinge pin	1
5	5167	325-600-011	" " screw	1
6	201308	323-873-001	Chaincutter knife	1
7	1333	323-600-048	screw	2
8	208525	323-685-022	Presser foot holder	1
9	5136	323-600-245	clamp screw	1
10	xxxxxx	xxx-xxx-xxx	Presser foot body	1
11	xxxxxx	xxx-xxx-xxx	chaining-off finger	1
12	5089	323-600-050	" " screw	1
13	201156	323-643-001	hinge spring	1
14	208547	323-716-014	regulator	1
15	2921	323-600-026	" screw	1
16	xxxxxx	xxx-xxx-xxx	uncurler	1
17	5030	323-600-202	" screw	1
18	xxxxxx	xxx-xxx-xxx	fabric guard	1
19	1231	323-600-051	" " screw	1
20	208534	323-540-031	Foot lift lever shaft	1
21	208535	323-676-050	bushing, complete	1
22	2133-1	323-600-215	bushing screw	1
23	201056	323-618-003	collar	1
24	1457	323-600-012	" screw	2
25	208313	323-530-029	Foot lift intermediate lever	1
26	2022-4	323-600-022	screw	1
27	208314	323-620-036	pin	1
28	208315	323-640-024	" spring	1
29	202757A	323-617-002	" washer	1
30	5317	323-600-355	" screw	1
31	208537	323-592-001	Presser bar	1
32	208479	323-850-055	guide	1
33	208540	323-640-023	spring	1
34	208615	323-600-142	Pressure regulating thumb screw	1
35	208598	323-530-031	Hand lift lever	1
36	202645	323-629-201	spring plunger	1
37	208599	323-676-053	" " bushing	1
38	5029	323-600-256	" " " screw	1
39	202647A	323-620-239	hinge pin	1
40	201395	323-640-228	spring	1
41	204177B	323-530-016	Foot lift lever	1
42	1202	323-600-032	screw	2
43	5232	323-600-314	stop screw	1
44	202683	323-716-209	regulator	1
45	5118	323-600-060	" screw	1
46	204178	323-640-220	spring	1
47	204929	323-710-003	Foot lift cam	1
48	204930	323-676-039	bushing	1
49	208316	323-604-018	regulating screw stud	1
50	2913-2	323-600-316	" " " stop screw	1



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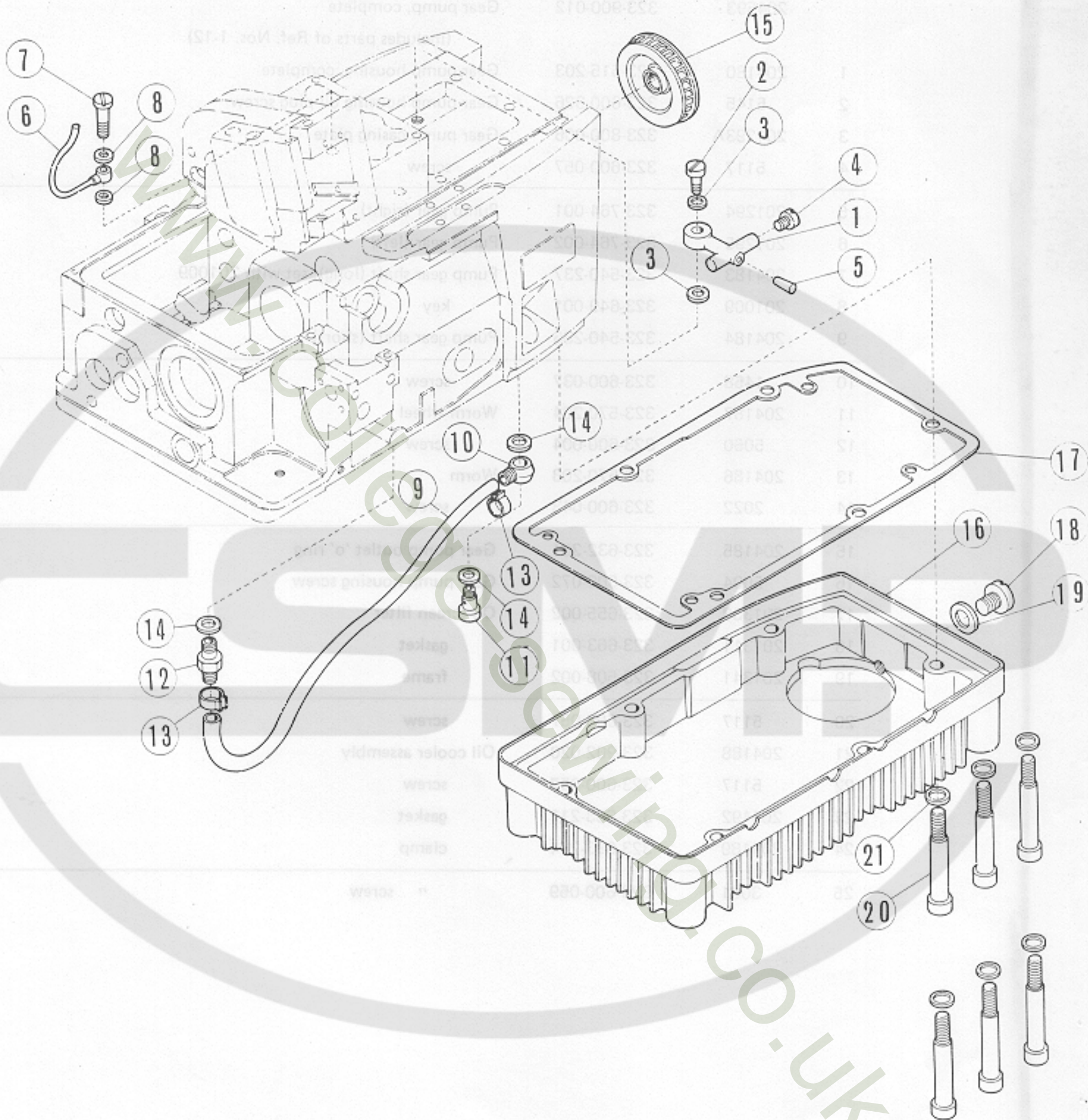
(1) PUMP LUBRICATING MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
	204593	323-900-012	Gear pump, complete (includes parts of Ref. Nos. 1-12)	1
1	204180	323-515-203	Gear pump housing, complete	1
2	5145	323-600-326	Gear pump housing oil plug screw	1
3	201293A	323-800-006	Gear pump casing plate	1
4	5117	323-600-057	screw	4
5	201294	323-764-001	Pump gear (right)	1
6	201295	323-764-002	Pump gear (left)	1
7	204183	323-540-237	Pump gear shaft (long), set with 201009	1
8	201009	323-649-001	key	1
9	204184	323-540-236	Pump gear shaft (short)	1
10	1458	323-600-037	screw	2
11	204187	323-570-204	Worm wheel	1
12	5060	323-600-004	screw	2
13	204186	323-570-203	Worm	1
14	2022	323-600-043	screw	1
15	204185	323-632-201	Gear pump outlet 'o' ring	1
16	5094	323-600-072	Gear pump housing screw	2
17	201338	323-655-002	Oil screen filter	1
18	201311	323-663-001	gasket	1
19	201341	323-508-002	frame	1
20	5117	323-600-057	screw	1
21	204188	323-902-020	Oil cooler assembly	1
22	5117	323-600-057	screw	8
23	204192	323-663-211	gasket	2
24	204189	323-683-214	clamp	1
25	3001	323-600-059	" screw	1

MACHINE BED FRAME

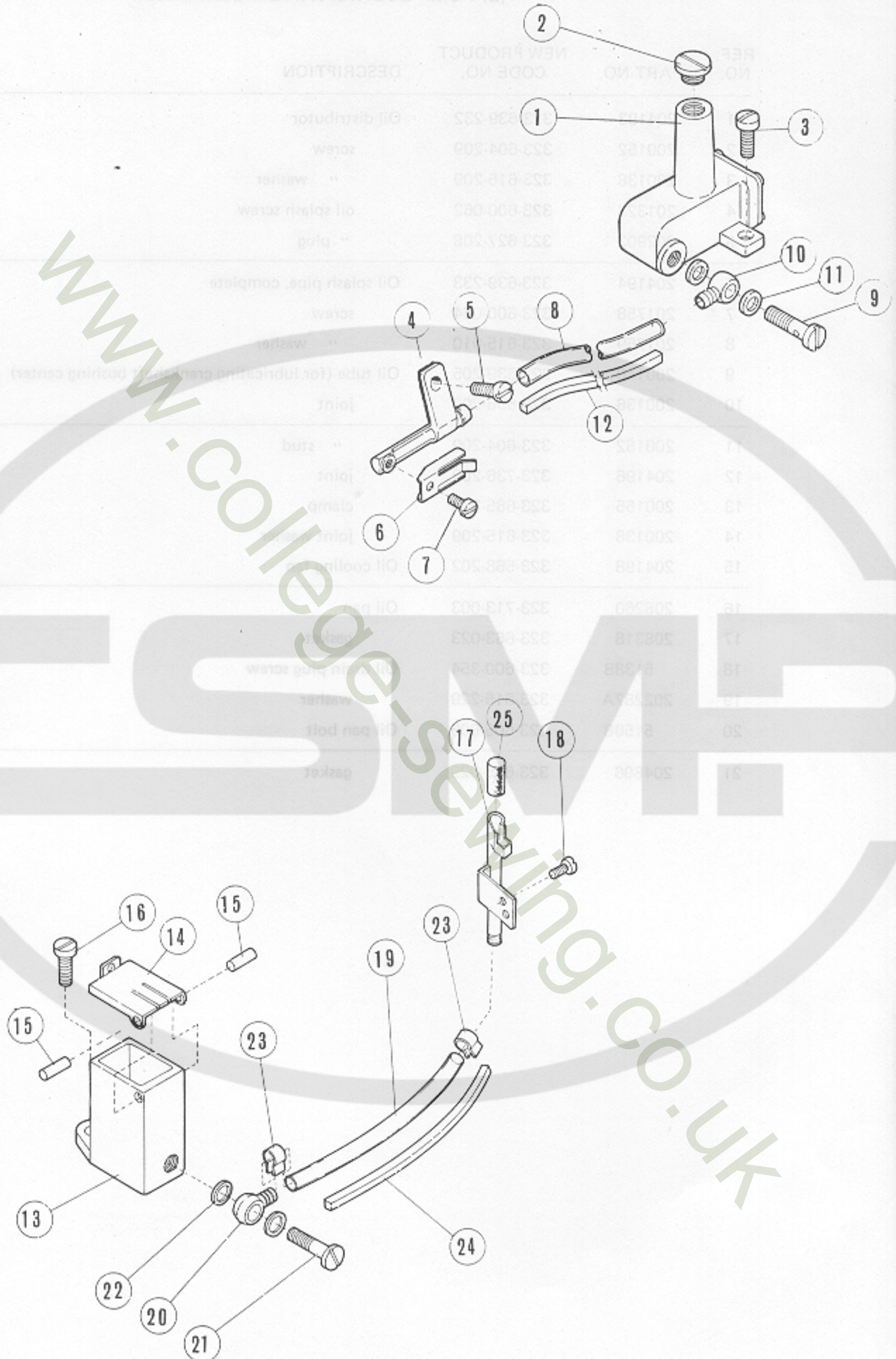
REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208601	MFG only	Machine bed frame	1
2	5332	323-600-359	oil hole plug screw (with head)	1
3	2022	323-600-043	" " " screw	3
4	208602	323-500-019	Machine arm (right)	1
5	204251	323-663-207	gasket	1
6	5078	323-600-001	screw	1
7	201002	323-620-001	dowel pin	2
8	208603	323-500-020	Machine arm (left)	1
9	5237	323-600-327	screw (long)	1
10	5163	323-600-328	" (short)	2
11	201002	323-620-001	dowel pin	2
12	208434	323-560-047	oil shield	1
13	208169A	323-663-021	gasket	1
14	204003	323-882-201	Oil sight gauge	1
15	208173	323-780-009	Dead hole plug	1
16	204828	323-627-010	" " plug	1
17	5179	323-600-329	" " " screw (small)	2
18	201006	323-615-001	" " " " " washer	2
19	204006	323-620-242	Machine bed bottom pin	4
20	208440	323-692-034	Type plate blank - 504-4	1
	208442	323-692-036	" " blank - 503-4	1
	208444	323-692-037	" " blank - 512-4	1
	208441	323-692-035	" " blank - 514-4	1
21	204794A	323-655-007	Machine bed oil filter	1
22	208289	323-800-056	Machine bed cover plate (back)	1
23	208290	323-663-020	gasket	1
24	5117	323-600-057	screw	5
25	202526	323-692-201	Manufacturer's name plate	1

REF. NO. PART NO. NEW PRODUCT CODE NO. DESCRIPTION



(2) PUMP LUBRICATING MECHANISM

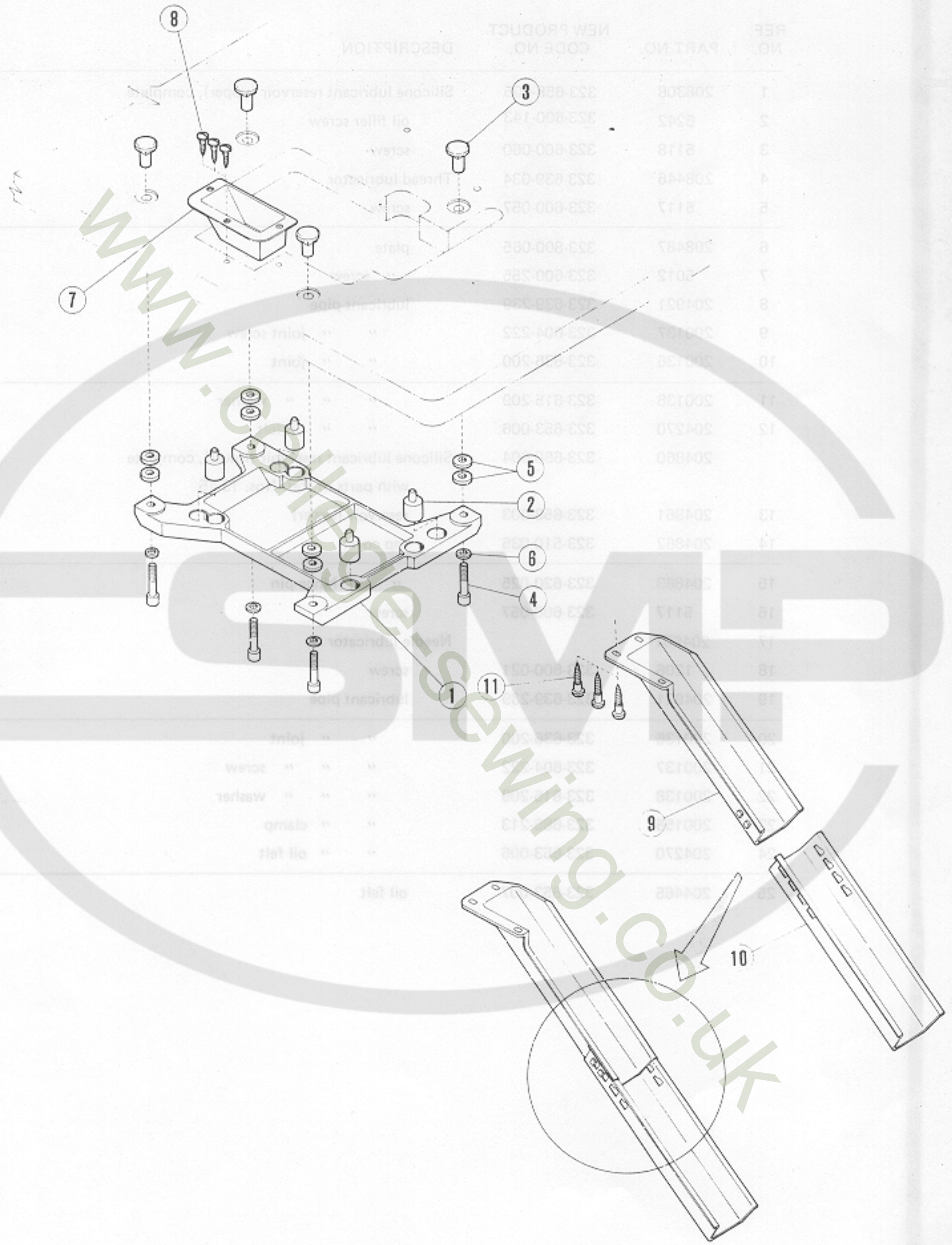
REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204193	323-639-232	Oil distributor	1
2	200152	323-604-209	screw	1
3	200138	323-615-209	" washer	2
4	201323	323-600-062	oil splash screw	1
5	202903	323-627-208	" plug	1
6	204194	323-639-233	Oil splash pipe, complete	1
7	201758	323-600-064	screw	1
8	201759	323-615-010	" washer	2
9	200140	323-639-205	Oil tube (for lubricating crankshaft bushing center)	1
10	200136	323-636-200	joint	1
11	200152	323-604-209	" stud	1
12	204196	323-736-200	joint	1
13	200155	323-685-213	clamp	2
14	200138	323-615-209	joint washer	3
15	204198	323-568-202	Oil cooling fan	1
16	208260	323-713-003	Oil pan	1
17	208318	323-663-023	gasket	1
18	51388	323-600-354	Oil drain plug screw	1
19	202287A	323-615-229	washer	1
20	5150B	323-605-006	Oil pan bolt	6
21	204806	323-615-029	gasket	6



**NEEDLE AND THREAD LUBRICATOR
(Optional parts)**

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208308	323-658-005	Silicone lubricant reservoir (upper), complete	1
2	5242	323-600-143	oil filler screw	1
3	5118	323-600-060	screw	1
4	208446	323-639-034	Thread lubricator	1
5	5117	323-600-057	screw	1
6	208487	323-800-065	plate	1
7	5012	323-600-255	" screw	1
8	204921	323-639-239	lubricant pipe	1
9	200137	323-604-222	" " joint screw	1
10	200136	323-636-200	" " joint	1
11	200138	323-615-209	" " " washer	2
12	204270	323-653-006	" " oil felt	1
	204860	323-658-004	Silicone lubricant reservoir (lower), complete with parts of Ref. Nos. 13-15	1
13	204861	323-658-003	reservoir (lower)	1
14	204862	323-510-035	cap cover	1
15	204863	323-620-025	" " hinge pin	2
16	5117	323-600-057	screw	1
17	204651		Needle lubricator	1
18	1206	323-600-021	screw	1
19	204921	323-639-239	lubricant pipe	1
20	200136	323-636-200	" " joint	1
21	200137	323-604-222	" " " screw	1
22	200138	323-615-209	" " " washer	2
23	200155	323-685-213	" " clamp	2
24	204270	323-653-006	" " oil felt	1
25	204465	323-653-007	oil felt	1

NEEDLE AND THREAD LUBRICATOR
(Optional parts)

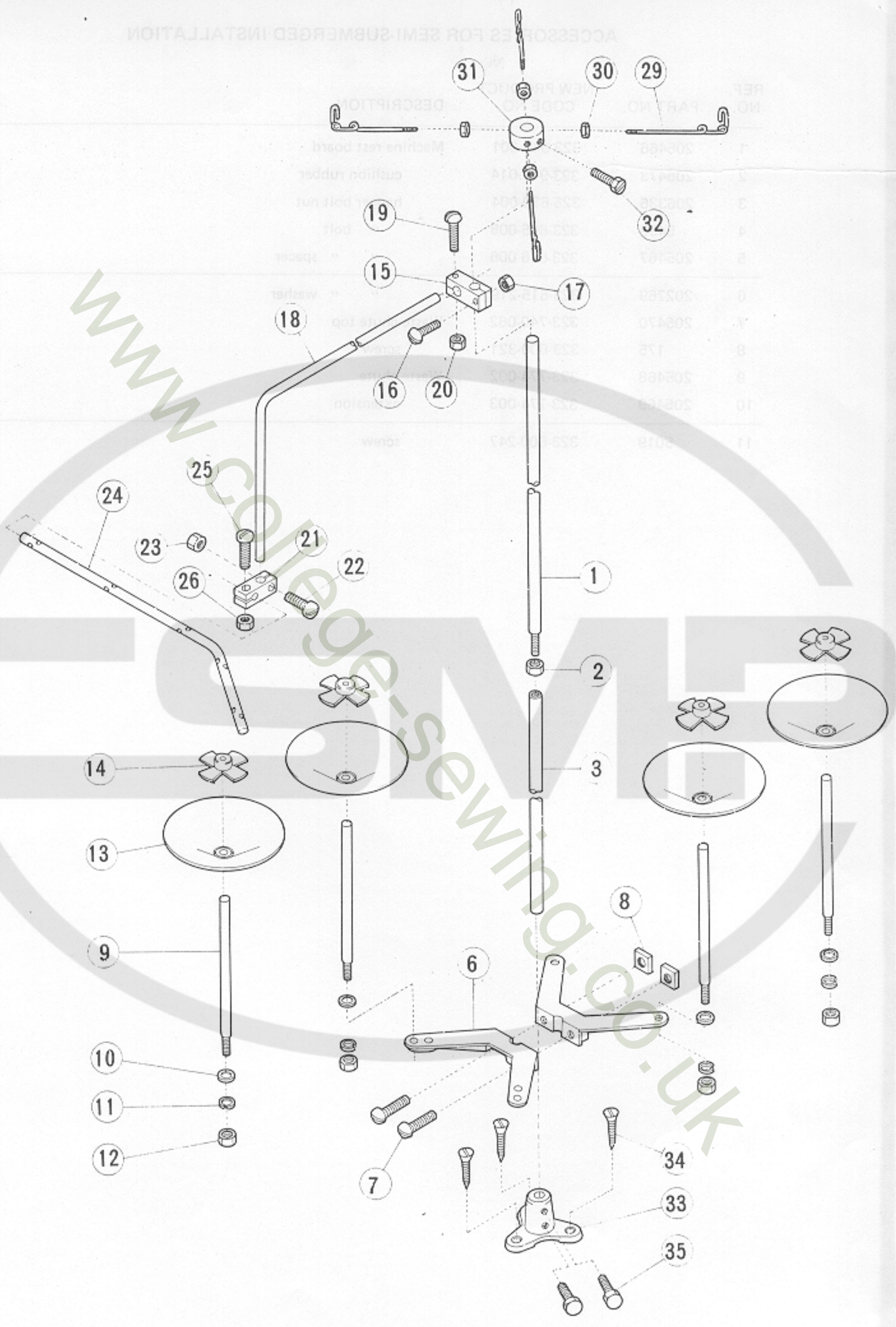


REF NO	PART NO	NEW PRODUCT CODE NO	DESCRIPTION
1	208308	323-680-000	Needle and Thread Lubricator Housing
2	8242	323-600-143	Oil Filter Screw
3	8118	323-600-080	Screw
4	208448	323-639-034	Thread Lubricator
5	8117	323-600-057	Washer
6	208487	323-600-088	Plate
7	2012	323-600-288	Lubricant Felt
8	201921	323-639-239	Lubricant Felt
9	201137	323-604-222	Joint Seal
10	201138	323-600-200	Joint Seal
11	200138	323-618-209	Joint Seal
12	204270	323-683-008	Joint Seal
13	201880	323-680-004	Silicone Lubricant Compound
14	204881	323-680-003	Joint Seal
15	201882	323-610-038	Joint Seal
16	204883	323-620-028	Joint Seal
17	8117	323-600-057	Washer
18	201137	323-604-222	Joint Seal
19	201138	323-600-200	Joint Seal
20	204270	323-683-008	Joint Seal
21	204885	323-600-000	Oil Felt

ACCESSORIES FOR SEMI-SUBMERGED INSTALLATION

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	205466	323-945-001	Machine rest board	1
2	205473	323-945-014	cushion rubber	4
3	206336	325-630-004	hanger bolt nut	4
4	5439	323-605-008	" bolt	4
5	205467	323-646-006	" " spacer	8
6	202769	323-615-219	" " washer	4
7	205470	323-740-062	Waste chute top	1
8	175	323-600-321	screw	3
9	205468	323-774-002	Waste chute	1
10	205469	323-774-003	extension	1
11	5019	323-600-247	screw	4

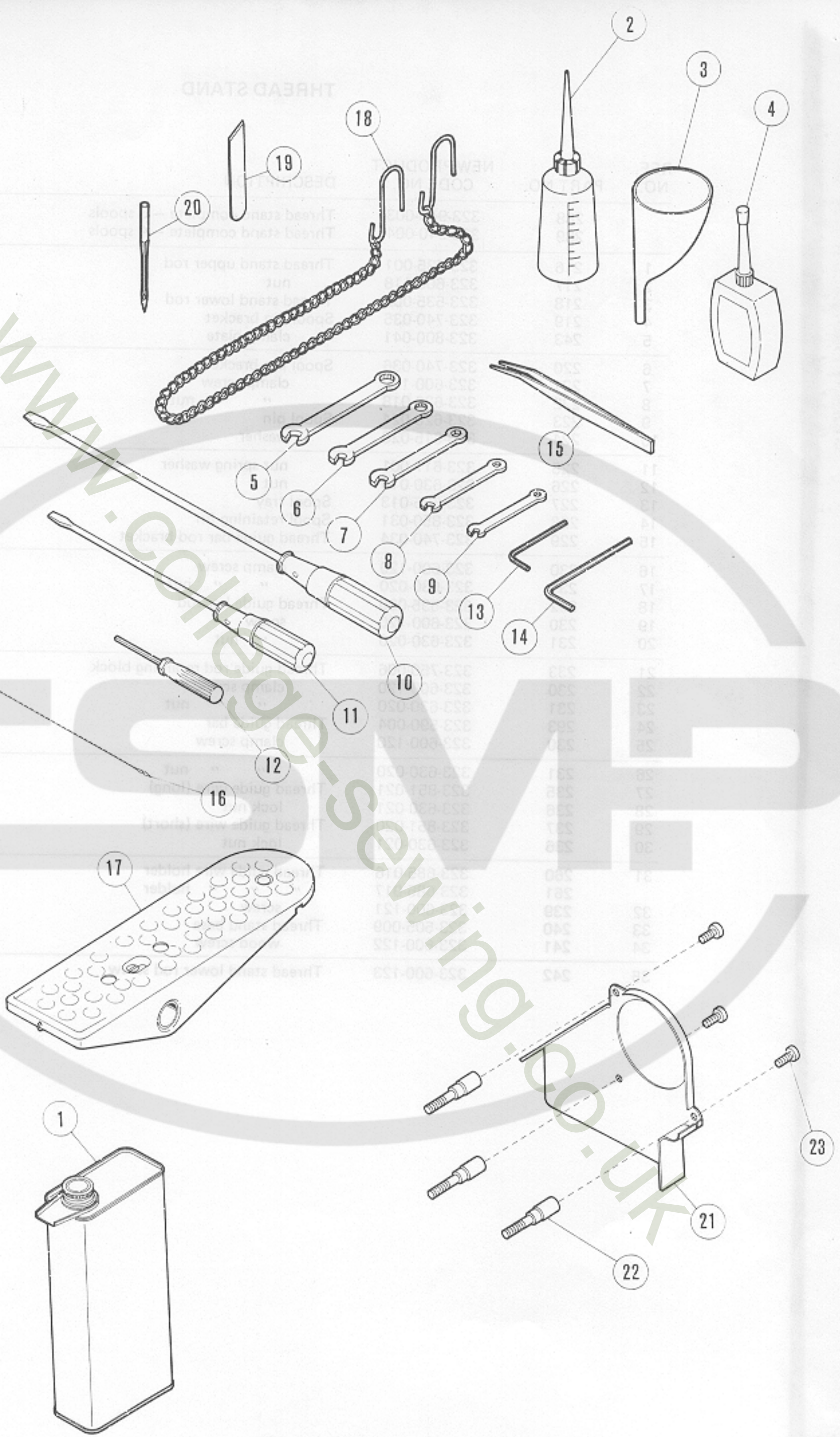
QTY	DESCRIPTION	REF. NO.
1	Machine rest board	305488
4	Cushion rubber	323014
4	Bolt	323004
8	Spacer	323008
4	Washer	307388
1	Support top	323002
3	Support	178
1	Support	305488
1	Support	305488
4	Support	323003
4	Support	323027



THREAD STAND

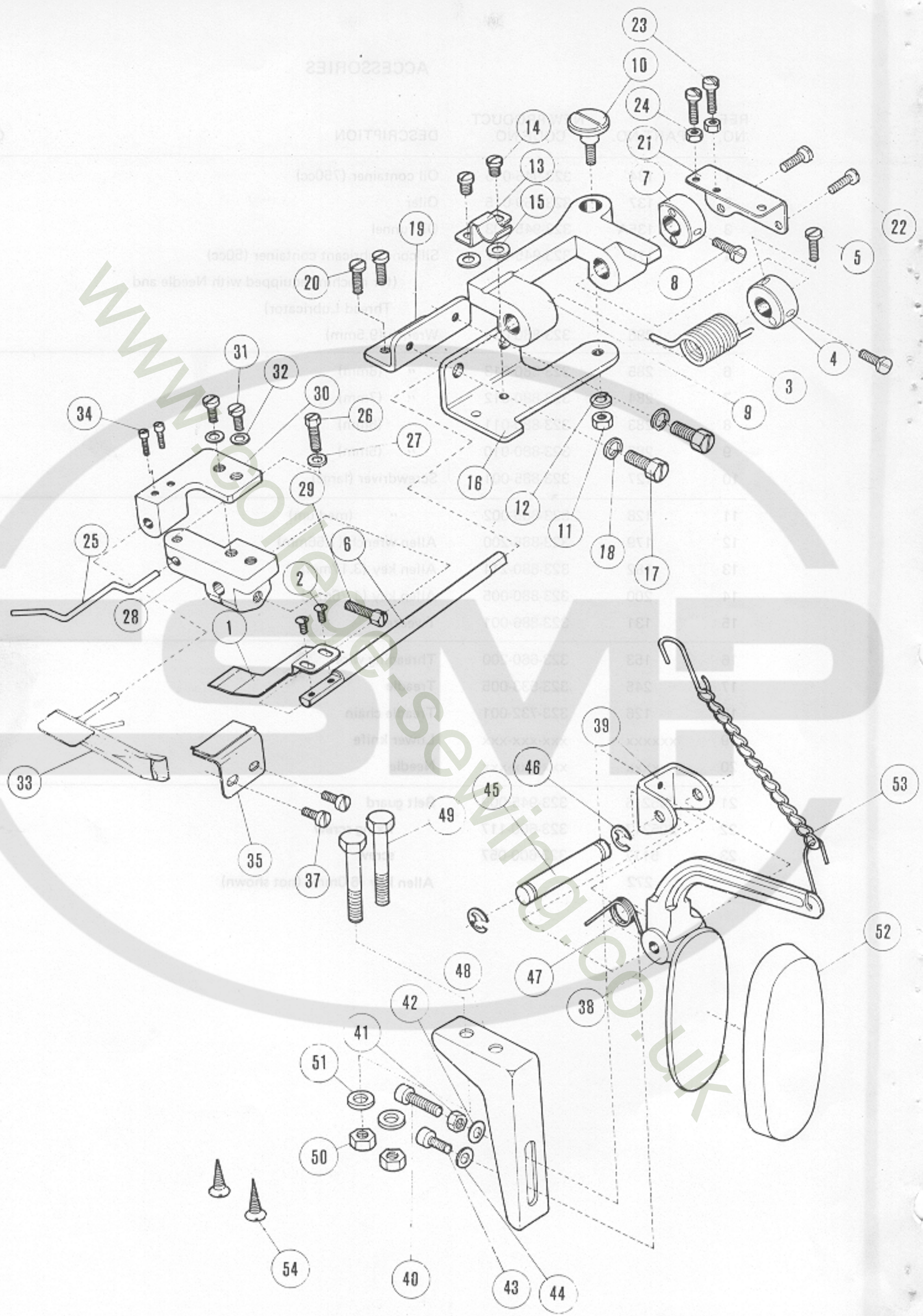
REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT. SPOOLS	
				3	4
	288	323-940-003	Thread stand complete – 3 spools	1	–
	289	323-940-004	Thread stand complete – 4 spools	–	1
1	216	323-535-001	Thread stand upper rod	1	1
2	217	323-600-118	nut	1	1
3	218	323-535-002	Thread stand lower rod	1	1
4	219	323-740-035	Spool pin bracket	1	–
5	243	323-800-041	clamp plate	1	–
6	220	323-740-036	Spool pin bracket	–	2
7	221	323-600-119	clamp screw	2	2
8	222	323-630-018	“ “ nut	2	2
9	223	323-620-024	Spool pin	3	4
10	224	323-615-028	washer	3	4
11	225	323-617-001	nut spring washer	3	4
12	226	323-630-019	nut	3	4
13	227	323-685-013	Spool tray	3	4
14	228	323-850-031	Spool retaining fin	3	4
15	229	323-740-034	Thread guide bar rod bracket	1	1
16	230	323-600-120	clamp screw	1	1
17	231	323-630-020	“ “ nut	1	1
18	292	323-535-005	Thread guide bar rod	1	1
19	230	323-600-120	screw	1	1
20	231	323-630-020	“ nut	1	1
21	233	323-750-006	Thread guide rod retaining block	1	1
22	230	323-600-120	clamp screw	1	1
23	231	323-630-020	“ “ nut	1	1
24	293	323-590-004	Thread guide bar	1	1
25	230	323-600-120	clamp screw	1	1
26	231	323-630-020	“ “ nut	1	1
27	235	323-851-021	Thread guide wire (long)	2	–
28	236	323-630-021	lock nut	2	–
29	237	323-851-020	Thread guide wire (short)	1	4
30	236	323-630-021	lock nut	1	4
31	260	323-685-016	Thread guide wire holder	1	–
	261	323-685-017	“ “ “ holder	–	1
32	239	323-600-121	screw	1	1
33	240	323-505-009	Thread stand base	1	1
34	241	323-600-122	wood screw	3	3
35	242	323-600-123	Thread stand lower rod screw	2	2

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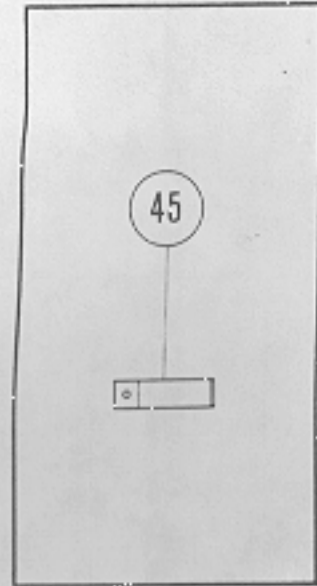
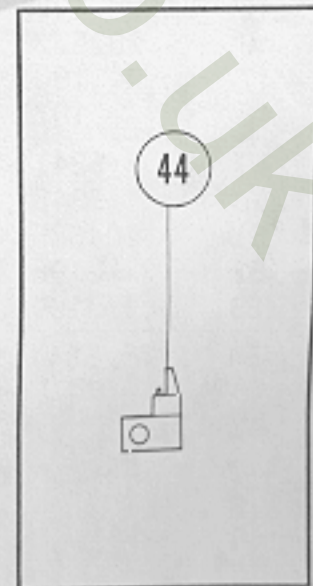
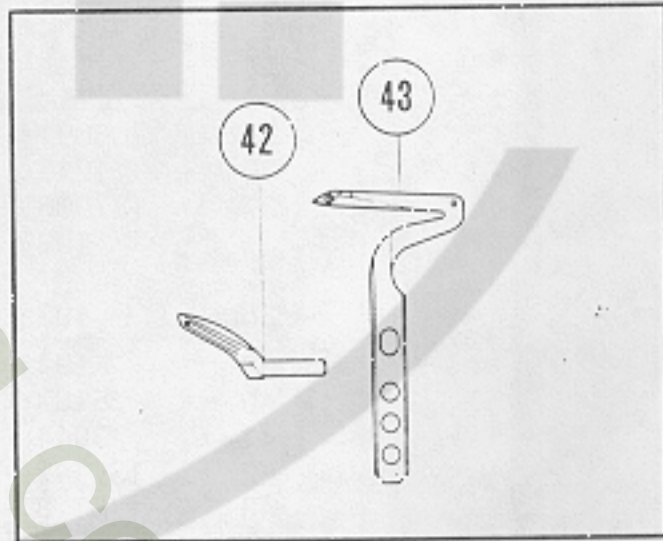
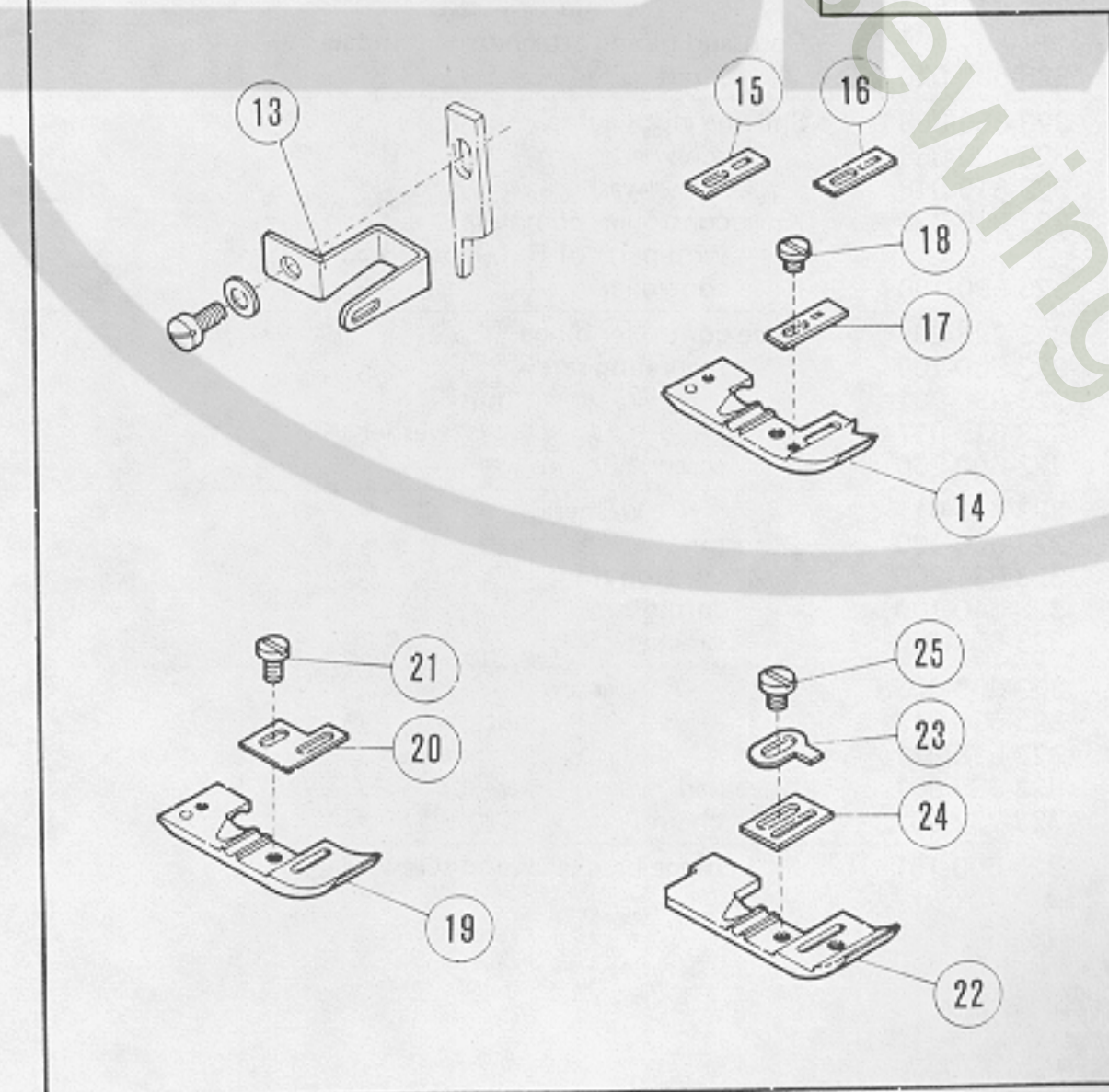
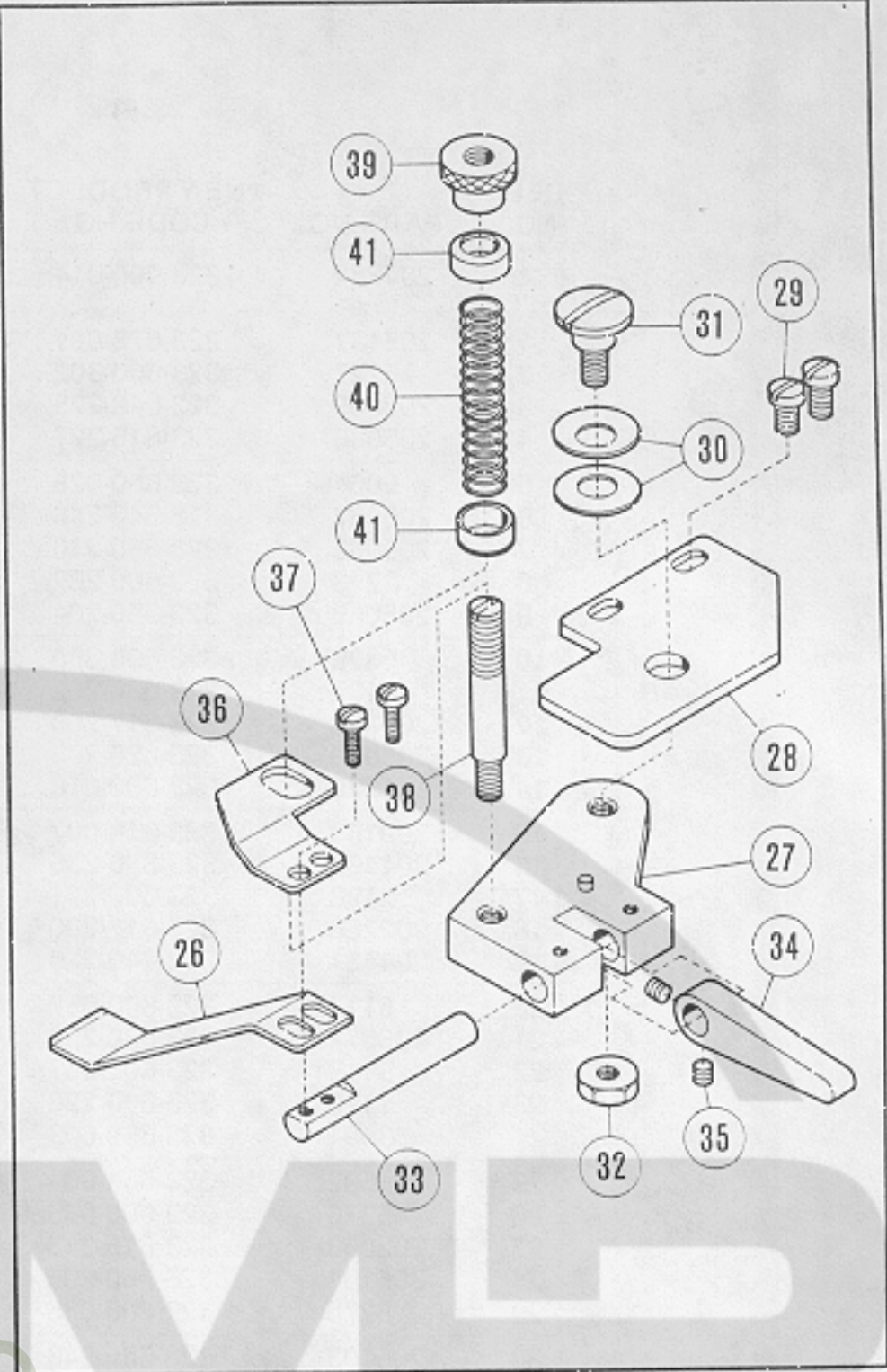
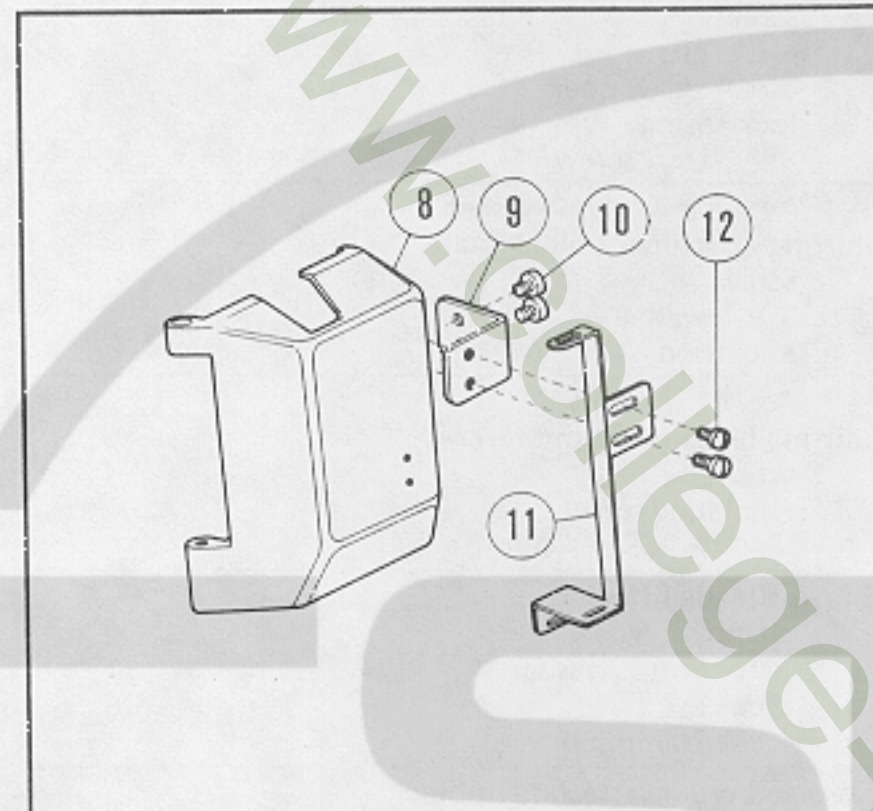
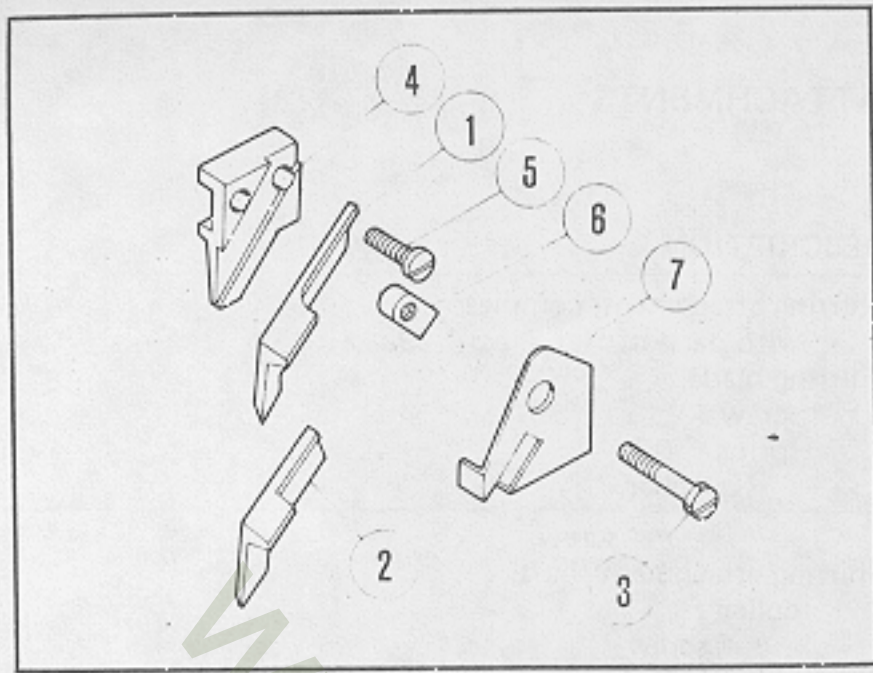
ACCESSORIES

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	134	323-945-015	Oil container (750cc)	1
2	137	323-659-015	Oiler	1
3	135A	323-945-003	Oil funnel	1
4	178	323-945-007	Silicone lubricant container (50cc) (for machine equipped with Needle and Thread Lubricator)	1
5	286	323-880-014	Wrench (9.5mm)	1
6	285	323-880-013	" (8mm)	1
7	284	323-880-012	" (7mm)	1
8	283	323-880-011	" (6mm)	1
9	282	323-880-010	" (5mm)	1
10	127	323-885-001	Screwdriver (large)	1
11	128	323-885-002	" (medium)	1
12	179	323-885-200	Allen wrench (1.56mm)	1
13	182	323-880-214	Allen key (3.17mm)	1
14	200	323-880-005	Allen key (4.76mm)	1
15	131	323-886-001	Tweezers	1
16	153	323-660-200	Threading wire	1
17	245	323-533-005	Treadle	1
18	126	323-732-001	Treadle chain	1
19	xxxxxx	xxx-xxx-xxx	Lower knife	2
20	xxxxxx	xxx-xxx-xxx	Needle	10
21	205216	323-945-009	Belt guard	1
22	205217	323-600-117	fixing screw	3
23	5117	323-600-057	screw	3
	272		Allen key (6.0mm) (not shown)	1



ATTACHMENTS

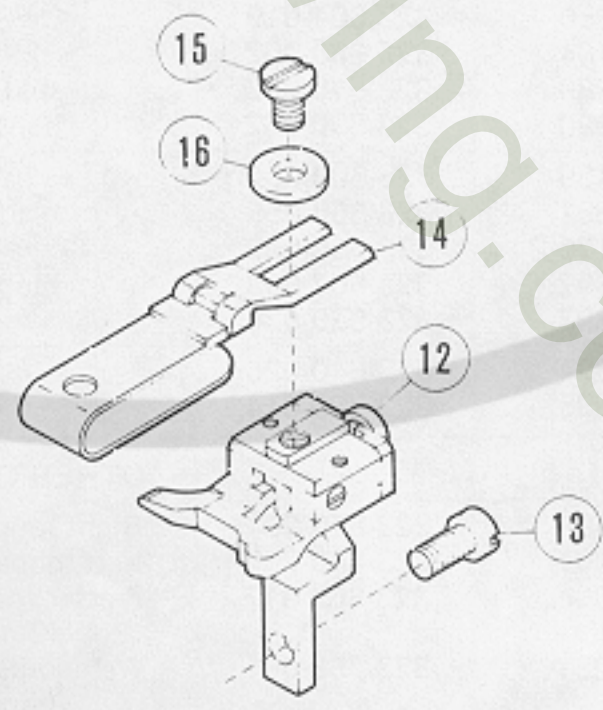
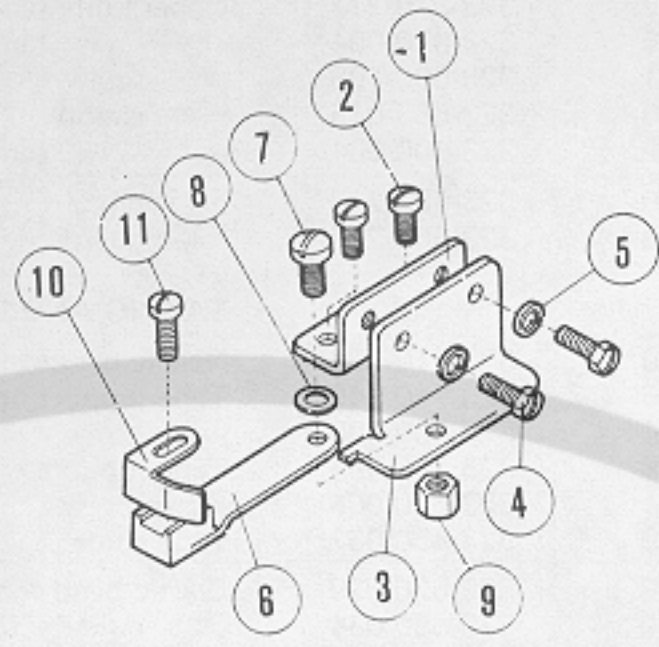
REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
	204882	323-900-014	Shirring attachment, complete with parts of Ref. Nos. 1-29	1
1	205137	323-875-001	Shirring blade	1
2	5227	323-600-302	screw	2
3	205065	323-640-225	spring	1
4	205066	323-615-227	" collar	1
5	5064	323-600-025	" " screw	2
6	205067	323-540-246	Shirring attachment shaft	1
7	205068	323-680-210	collar	1
8	2213	323-600-237	" screw	1
9	205069	323-750-204	Shirring attachment block	1
10	5326	323-600-350	screw	1
11	5137	323-630-202	" nut	1
12	202286	323-617-200	" " washer	1
13	205070	323-625-203	lock spring	1
14	1229	323-600-016	" " screw	2
15	200183	323-618-007	" " " washer	2
16	204495	323-800-235	Shirring attachment block plate	1
17	2193	323-600-271	screw	2
18	202286	323-617-200	" washer	2
19	204451	323-740-229	extension	1
20	5117	323-600-057	" screw	2
21	205072	323-530-232	Shirring blade swing-out lever	1
22	5117	323-600-057	screw	2
23	1170	323-600-226	regulating screw	2
24	3091	323-630-003	" " nut	2
25	204592	323-534-001	Shirring blade lifter	1
26	5276	323-600-088	clamp screw	1
27	202058	323-615-213	" " washer	1
28	205104	323-750-205	block	1
29	5276	323-600-088	" clamp screw	1
30	205103	323-685-243	Cord and piping attachment block	1
31	1175-3	323-600-019	screw	2
32	167066	323-615-211	" washer	2
33			Cord and piping attachment (binder)	1
34	1170-1	323-600-020	screw	2
35	205091	323-850-258	Shirring cloth guide	1
36	1216	323-600-068	screw	2
37	137906	323-615-018	" washer	2
	192	323-900-224	Knee controller, complete with parts of Ref. Nos. 38-53	1
38	193	323-530-100	Knee controller	1
39	194	323-728-004	Knee controller hinge	1
40	5183	323-600-100	regulating screw	1
41	3044	323-630-001	" " nut	1
42	137142	323-615-017	" " " washer	1
43	5118	323-600-060	screw	1
44	137142	323-615-017	" washer	1
45	195	323-620-100	pin	1
46	202522	323-634-200	" stop ring	2
47	196	323-640-100	spring	1
48	197	323-505-100	bracket	1
49	5347	323-605-003	" screw	2
50	5348	323-630-013	" " nut	2
51	204585	323-615-021	" " " washer	2
52	198	323-665-001	Knee pad	1
53	199	323-732-002	chain	1
54	5341	323-600-101	hinge bracket wood screw	2



OPTIONAL PARTS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
UPPER KNIFE (ANGLED)				
1	204152	323-870-217	Upper knife (angled)	1
2	204835	323-870-004	" " (angled) - carbide tipped	1
3	5371	323-600-108	screw	1
4	204830	323-683-015	clamp	1
5	5142	323-600-054	" screw	1
6	204155	323-683-213	gib	1
7	204156	323-560-225	guard	1
TAPING AND ELASTIC BAND FOOT				
8	204950	323-510-036	Needle bar cover	1
9	205335	323-740-040	Tape support bracket	1
10	1234	323-600-006	screw	2
11	205318	323-756-004	Tape support	1
12	1234	323-600-006	screw	2
13	205319	323-850-032	Tape guide	1
14	205328	323-820-029	Elastic band foot	1
15	205330	323-850-034	guide - for 2.7mm band width only	1
16	205331	323-850-035	guide - for 4.4mm band width only	1
17	205332	323-850-036	guide - for 5.0mm band width only	1
18	5077	323-600-307	guide screw	1
19	205329	323-820-030	Taping foot - for 9.0mm band width only	1
20	205333	323-580-037	guide	1
21	5366	323-600-124	" screw	1
22	205314	323-820-028	Taping foot - for tape up to 10mm tape width	1
23	205315	323-850-033	guide	1
24	205316	323-740-039	" bracket	1
25	2921	323-600-026	" " screw	1
SHIRRING ATTACHMENT - PLAIN TYPE				
	204898	323-900-053	Shirring attachment, complete with parts of Ref. Nos. 26-41	1
26	204966	323-875-003	blade	1
27	204886	323-750-010	block	1
28	204887	323-740-061	" bracket	1
29	5117	323-600-057	" " screw	2
30	204888	323-618-019	" " stud washer	2
31	5380	323-604-019	" " stud	1
32	5104	325-630-002	" " " nut	1
33	204889	323-540-032	shaft	1
34	204890	323-530-032	hand lift lever	1
35	1459	323-600-034	" " " screw	2
36	204891	323-850-056	blade guide	1
37	1175-2	323-600-002	" " screw	2
38	204892	323-607-003	block post	1
39	204893	323-630-034	" " thumb nut	1
40	204894	323-640-026	" " spring	1
41	204895	323-780-014	" " " cup	2
OTHER OPTIONAL PARTS AVAILABLE				
42	204990	323-810-231	Right looper, for woolen yarn	1
43	204991	323-810-232	Left looper, for woolen yarn	1
44	204906	323-863-017	Presser foot chaining-off finger (2-needle machines for knits)	1
45	202281	323-758-004	Welt guide extension (especially designed for wetting tricot fabrics)	1

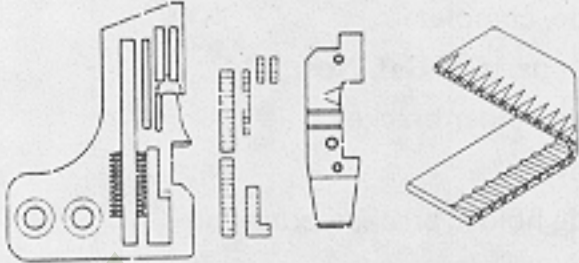
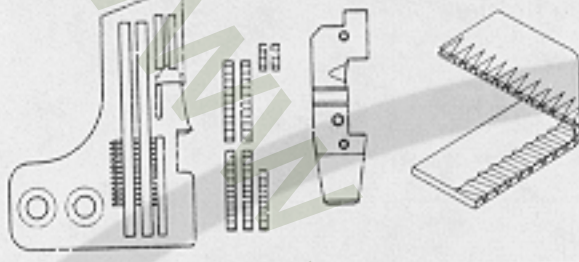
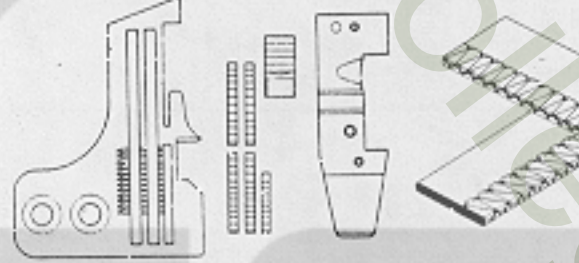
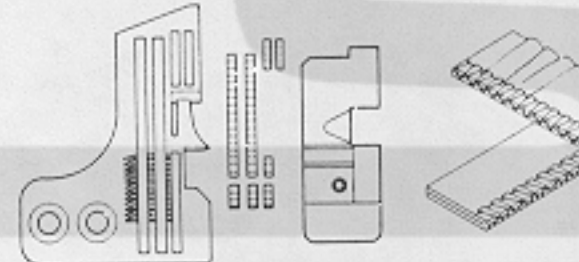
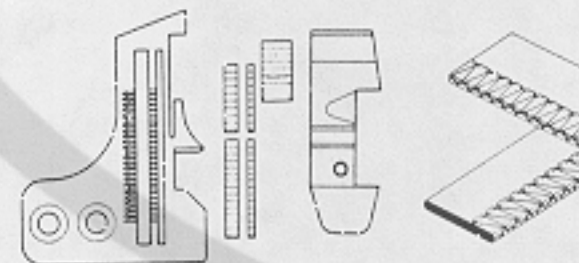
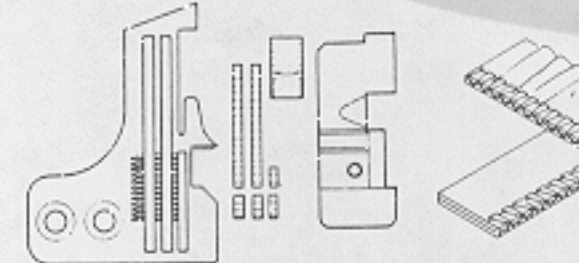
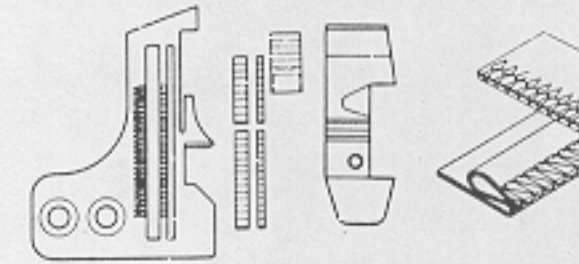
OPTIONAL PART



OPTIONAL PARTS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
	204896	323-850-028	Edge guide, complete with parts of Ref. Nos. 1-11	1
1	204451	323-740-229	Edge guide holder bracket	1
2	5117	323-600-057	screw	2
3	204452	323-740-228	Edge guide holder bracket extension	1
4	2193	323-600-271	screw	2
5	202286	323-617-200	" washer	2
6	201485	323-740-012	Edge guide holder	1
7	5184	323-600-079	screw	1
8	201191	323-615-015	" washer	1
9	3044	323-630-001	" " nut	1
10	204667	323-850-022	Edge guide	1
11	1202	323-600-032	screw	1
12	204760A	323-505-016	Welt guide holder	1
13	1175-2	323-600-002	screw	1
14	201211A	323-400-001	Welt guide	1
15	2905	323-600-074	screw	1
16	201185	323-615-012	" washer	1

LIST OF ORGANIZATION PARTS

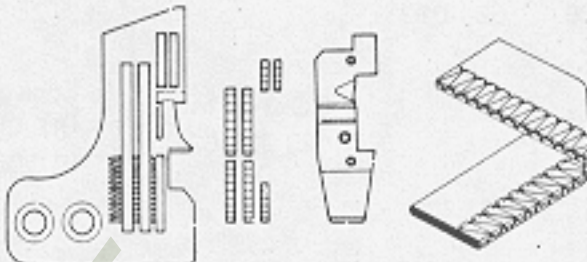
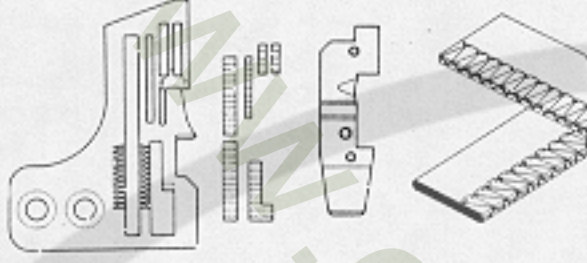
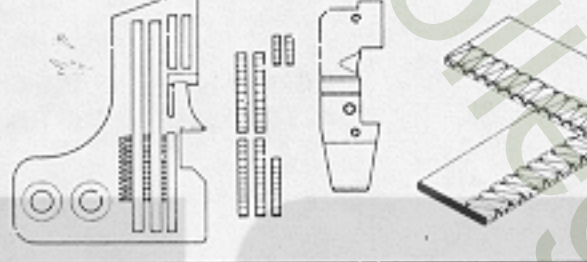
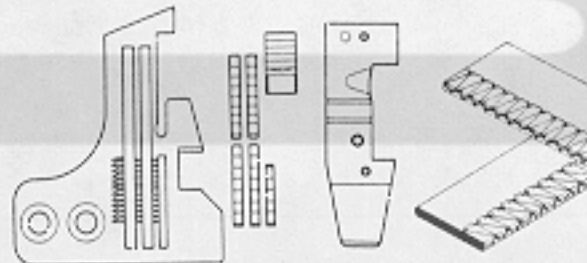
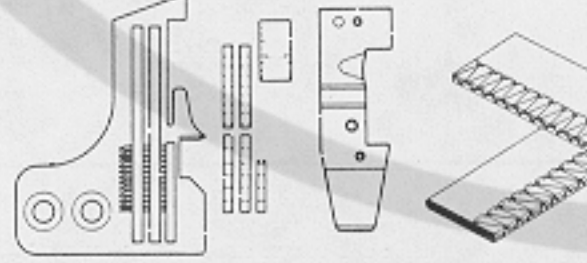
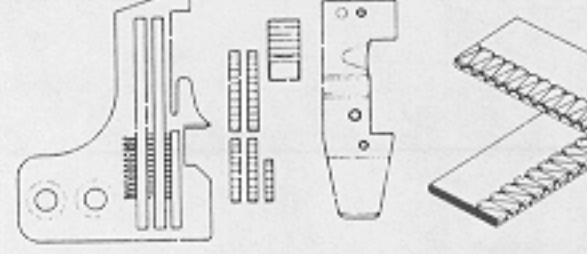
Machine model	Gauge (mm) (inch)	Needle plate	Feed dogs			Right looper # = mark stamped	Lower knife
			main	aux.	diff.		
503-4-44 Serging trousers. 	3mm 1/8"	205320 801-062	208336 830-134	208338 830-136	204907 830-060	204704 810-011	#3 202295 870-210
	4mm 5/32"	205321 801-063	"	"	"	"	"
	5mm 3/16"	205322 801-064	"	"	"	"	"
	6mm 1/4"	205323 801-065	"	"	"	"	"
503-4-48 Serging trousers. 	3mm 1/8"	205324 801-066	208337 830-135	"	204690 830-057	"	201127 870-211
	4mm 5/32"	205325 801-067	"	"	"	"	"
	5mm 3/16"	205326 801-068	"	"	"	"	202295 870-210
	6mm 1/4"	205327 801-069	"	"	"	"	"
504-4-7 Plain seaming for underwear. 	3mm 1/8"	202542E 801-026	204675A 830-096	204674 830-054	204676 830-033	204062 810-218	#2 201127 870-211
	4mm 5/32"	202546E 801-027	"	"	"	"	"
	5mm 3/16"	202596E 801-028	"	"	"	"	202295 870-210
	6mm 1/4"	202597E 801-029	"	"	"	"	"
504-4-17 Intermittent shirring. 	3mm 1/8"	205239 801-360	204723A 830-108	204677 830-037	204724 830-036	204702 810-009	#4 201127 870-211
	4mm 5/32"	205240 801-361	"	"	"	"	"
	5mm 3/16"	205241 801-362	"	"	"	"	202295 870-210
	6mm 1/4"	205242 801-363	"	"	"	"	"
504-4-19 Seaming light knit goods. 	2mm 5/64"	202616 801-038	204729A 830-103	204674 830-054	204730 830-059	204062 810-218	#2 201127 870-211
	3mm 1/8"	202617 801-039	"	"	"	"	"
	4mm 5/32"	202618 801-222	"	"	"	"	"
	5mm 3/16"	204913 801-045	"	"	"	"	"
504-4-21 Intermittent shirring. 	3mm 1/8"	202542E 801-026	204723A 830-108	"	204724 830-036	"	201127 870-211
	4mm 5/32"	202546E 801-027	"	"	"	"	"
	5mm 3/16"	202596E 801-028	"	"	"	"	202295 870-210
	6mm 1/4"	202597E 801-029	"	"	"	"	"
504-4-25 Hemming and welting light knits. 	2mm 5/64"	202616 801-038	204729A 830-103	"	204730 830-059	"	201127 870-211
	3mm 1/8"	202617 801-039	"	"	"	"	"
	4mm 5/32"	202618 801-222	"	"	"	"	"
	5mm 3/16"	204913 801-045	"	"	"	"	"

Note: All product code numbers begin with prefix 323-

COMMON PARTS: 204072 (323-810-216) – Left looper
201121A (323-870-214) – Upper knife

Presser foot				Needle bar complete	Needle guard		Needle factory set	Attachment on machine (available by option)
body	chaining- off finger	fabric guard	uncurler		front	rear		
202799 820-286	201224B 863-007	201265B 854-200	205342A 560-041	204623 591-003	204634 561-009	204635 561-010		
"	"	"	"	"	"	"	DCx1 #14 423-223-631	Edge guide (KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
"	"	"	"	"	"	"	DCx1 #14 423-223-631	Edge guide (KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
201230C 820-019	"	"	204668 560-020	"	"	"		
"	"	"	"	"	"	"	DCx1 #11 423-222-831	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
205135 820-013	---	---	---	"	"	"		
"	---	---	---	"	"	"	DCx27 #14 423-243-631	Shirring attachment (KS Chain Cutter)
205136 820-014	---	---	---	"	"	"		
"	---	---	---	"	"	"		
201473B 820-022	201224B 863-007	---	205342A 560-041	"	"	"		
"	"	---	"	"	"	"	DCx1 #9 423-222-631	(KS Chain Cutter) (BT Backtacker)
"	"	---	"	"	"	"		
"	"	---	"	"	"	"		
205135 820-013	---	---	"	"	"	"		
"	---	---	"	"	"	"	DCx1 #11 423-222-831	Shirring attachment (KS Chain Cutter)
205136 820-014	---	---	"	"	"	"		
"	---	---	"	"	"	"		
201152E 820-021	201155C 863-217	---	"	"	"	"		
"	"	---	"	"	"	"	DCx1 #9 423-222-631	Welt guide (KS Chain Cutter)
"	"	---	"	"	"	"		
"	"	---	"	"	"	"		

LIST OF ORGANIZATION PARTS

Machine model	Gauge (mm) (inch)	Needle plate	Feed dogs			Right looper # = mark stamped	Lower knife
			main	aux.	diff.		
504-4-43 Plain seaming on light knits. 	3mm 1/8"	205235 801-340	204721A 830-097	204677 830-037	204722 830-035	204702 810-009 #4	201127 870-211
	4mm 5/32"	205236 801-341	"	"	"	"	"
	5mm 3/16"	205237 801-342	"	"	"	"	202295 870-210
	6mm 1/4"	205238 801-343	"	"	"	"	"
504-4-45 Plain seaming medium heavy knits. 	3mm 1/8"	205231 801-344	204692A 830-093	"	204693 830-034	"	201127 870-211
	4mm 5/32"	205232 801-345	"	"	"	"	"
	5mm 3/16"	205233 801-346	"	"	"	"	202295 870-210
	6mm 1/4"	205234 801-347	"	"	"	"	"
504-4-47 Seaming woven and knits. 	3mm 1/8"	205239 801-360	204675A 830-096	"	204676 830-033	"	201127 870-211
	4mm 5/32"	205240 801-361	"	"	"	"	"
	5mm 3/16"	205241 801-362	"	"	"	"	202295 870-210
	6mm 1/4"	205242 801-363	"	"	"	"	"
504-4-65 Seaming for jeans. 	3mm 1/8"	202542E 801-026	204678A 830-094	204674 830-054	204679 830-056	204703 810-110 #6	201127 870-211
	4mm 5/32"	202546E 801-027	"	"	"	"	"
	5mm 3/16"	202596E 801-028	"	"	"	"	202295 870-210
	6mm 1/4"	202597E 801-029	"	"	"	"	"
	7mm 9/32"	204797 801-042	"	"	"	"	"
	8mm 5/16"	204731 801-041	"	"	"	"	"
504-4-66 Seaming bulky knitwear. 	3mm 1/8"	202542E 801-026	"	"	204691 830-058	204702 810-009 #4	201127 870-211
	4mm 5/32"	202546E 801-027	"	"	"	"	"
	5mm 3/16"	202596E 801-028	"	"	"	"	202295 870-210
	6mm 1/4"	202597E 801-029	"	"	"	"	"
504-4-69 Seaming knits. 	3mm 1/8"	202542E 801-026	204675A 830-096	"	204690 830-057	204062 810-218 #2	201127 870-211
	4mm 5/32"	202546E 801-027	"	"	"	"	"
	5mm 3/16"	202596E 801-028	"	"	"	"	202295 870-210
	6mm 1/4"	202597E 801-029	"	"	"	"	"

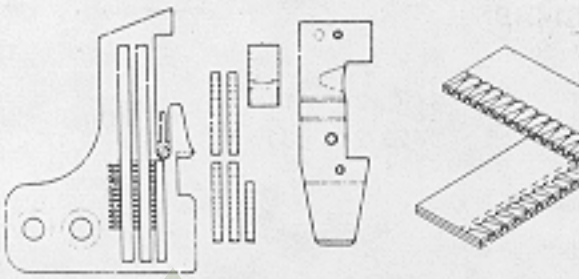
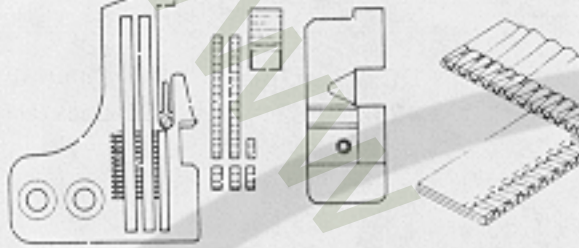
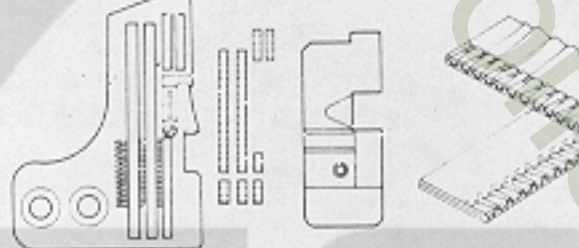
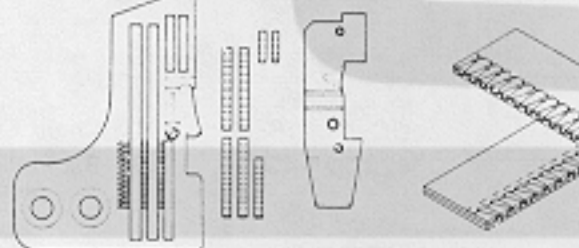
Note: All product code numbers begin with prefix 323-

Presser foot				Needle bar complete	Needle guard		Needle factory set	Attachment on machine (available by option)
body	chaining- off finger	fabric guard	uncurler		front	rear		
205252 820-285	201224B 863-007	201265B 854-200	205342A 560-041	204623 591-003	204634 561-009	204635 561-010		
"	"	"	"	"	"	"	DCx27 #14 423-243-631	(KS Chain Cutter)
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
202799 820-286	"	"	"	"	"	"		
"	"	"	"	"	"	"	DCx27 #14 423-243-631	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
205253 820-287	"	"	"	"	"	"		
"	"	"	"	"	"	"	DCx27 #16 423-244-031	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
201230C 820-019	"	"	204668 560-020	"	"	"		
"	"	"	"	"	"	"		
"	"	"	"	"	"	"	DCx1 #18 423-224-431	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
"	"	"	"	"	"	"	DCx1 #14 423-223-631	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
"	"	"	"	"	"	"	DCx1 #11 423-222-831	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		

(1) MISCELLANEOUS COVERS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208317	323-800-057	Bed plate, complete	1
2	208422	323-663-024	gasket	1
3	4009-1	323-600-014	screw	8
4	204827	323-627-009	Cloth plate cushion (large)	1
5	208341	323-800-055	Bed cover plate (right)	1
6	208342	323-663-022	gasket	1
7	5117	323-600-057	screw	6
8	208347	323-510-078	Machine bed bottom cover	1
9	208348	323-655-011	oil filter	1
10	5117	323-600-057	screw	4
11	208430	323-800-061	Face plate, complete	1
12	4009-1	323-600-014	screw	3
13	208611	323-802-015	Cloth plate (narrow), complete	1
14	202576	323-615-201	hinge stud thrust washer	1
15	201139	323-680-001	" " " collar	1
16	5084	323-600-013	" " " " screw	2
17	204742	323-734-003	latch	1
18	204118	323-618-213	" spacer	1
19	5362	323-600-099	" screw	1
20	1435	323-600-069	" adjust screw	1
21	1459	323-600-034	" " " lock screw	1
22	204743	323-620-014	" pin	1
23	204744	323-740-019	" " bracket	1
24	1202	323-600-032	" " " screw	1
25	204745	323-640-007	spring	1
26	204746	323-620-015	push pin	1
27	204747	323-850-023	" " guide	1
28	5053	323-600-015	" " " screw	1
29	204748	323-640-008	" " spring	1
30	204749	323-627-005	rubber plug (small)	2
31	5441	323-600-140	stop screw	1
32	3044	323-630-001	" " nut	1
33	208612	323-802-016	Cloth plate (wide), complete	1
34	202576	323-615-201	hinge stud thrust washer	1
35	201139	323-680-001	" " " collar	1
36	5084	323-600-013	" " " " screw	2
37	204218	323-734-204	lock spring	1
38	1216	323-600-068	" " screw	2
39	200162A	323-615-015	" " " washer	1
40	5232	323-600-314	" " pin	1
41	208482	323-627-018	rubber plug (small)	1

LIST OF ORGANIZATION PARTS

Machine model	Gauge (mm) (inch)	Needle plate	Feed dogs			Right looper # = mark stamped	Lower knife
			main	aux.	diff.		
512-4-61							
Two needle seaming for woven fabrics.							
	2x2mm 5/64x5/64"	205255 801-047	204675A 830-096	204674 830-037	204676 830-033	204663 810-008	#7 870-211
	2x3mm 5/64x1/8"	205255 801-047	"	"	"	"	202295 870-210
	2x4mm 5/64x5/32"	202554E 801-030	"	"	"	"	"
	2x5mm 5/64x3/16"	202499E 801-031	"	"	"	"	"
512-4-62							
Two needle intermittent shirring.							
	2x2mm 5/64x5/64"	205255 801-047	204723A 830-108	"	204724 830-036	"	201127 870-211
	2x3mm 5/64x1/8"	205255 801-047	"	"	"	"	202295 870-210
	2x4mm 5/64x5/32"	202554E 801-030	"	"	"	"	"
	2x5mm 5/64x3/16"	202499E 801-031	"	"	"	"	"
512-4-63							
Two needle intermittent shirring.							
	2x4mm 5/64x5/32"	205243 801-364	"	204677 830-037	"	"	"
	2x5mm 5/64x3/16"	205244 801-365	"	"	"	"	"
512-4-64							
Two needle seaming on stretch fabrics.							
	2x4mm 5/64x5/32"	205243 801-364	204675A 830-096	"	204676 830-033	"	"
	2x5mm 5/64x3/16"	205244 801-365	"	"	"	"	"

REFERENCE TABLE FOR 'NEW -4' VS 'MARK/IV' MACHINE MODELS

New -4 machine models	Mark/IV machine models
503-4-44	503/IV-44
503-4-48	503/IV-48
504-4-7	504/IV-7
504-4-17	504/IV-17
504-4-19	504/IV-19
504-4-21	504/IV-21
504-4-25	504/IV-25
504-4-43	504/IV-43
504-4-45	504/IV-45
504-4-47	504/IV-47
504-4-65	504/IV-S-10
504-4-66	504/IV-S-16
504-4-69	504/IV-S-17

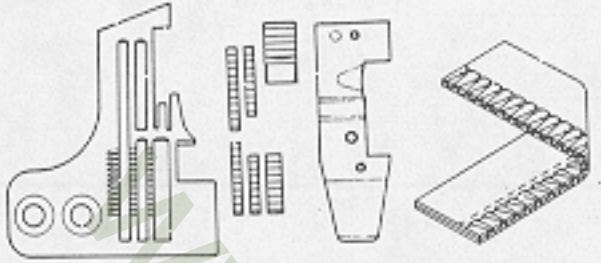
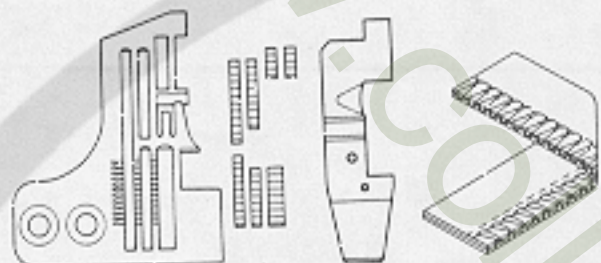
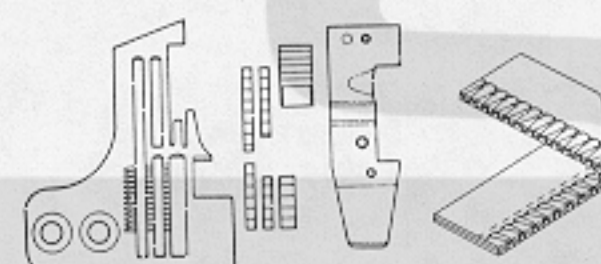
New -4 machine models	Mark/IV machine models
512-4-61	514/IV-11
512-4-62	514/IV-22
512-4-63	514/IV-23
512-4-64	514/IV-41
512-4-53	---
512-4-57	---
512-4-73	514/IV-56
514-4-20	514/IV-20
514-4-61	514/IV-S-15
514-4-62	514/IV-S-18
514-4-64	514/IV-S-19
514-4-67	514/IV-S-11
514-4-73	---
514-4-68	514/IV-S-14

Note: All product code numbers begin with prefix 323-

COMMON PARTS: 204072 (323-810-216) – Left looper
201121A (323-870-214) – Upper knife

Presser foot				Needle bar complete	Needle guard		Needle factory set	Attachment on machine (available by option)
body	chaining- off finger	fabric guard	uncurler		front	rear		
201230C 820-019	201396B 863-215	201265B 854-200	204668 560-020	204624 591-004	204659 561-011	204660 561-012		
"	"	"	"	"	"	"		
"	201310A 863-201	"	"	"	"	"		DCx1 #14 423-223-631
"	"	"	"	"	"	"		
205136 820-014	---	---	205342A 560-041	"	"	"		
"	---	---	"	"	"	"		DCx1 #14 423-223-631
"	---	---	"	"	"	"		
"	---	---	"	"	"	"		
"	---	---	"	"	"	"		
"	---	---	"	"	"	"		DCx27 #14 423-243-631
"	---	---	"	"	"	"		Shirring attachment
205253 820-287	201310A 863-201	201265B 854-200	205342A 560-041	"	"	"		
"	"	"	"	"	"	"		DCx27 #14 423-243-631

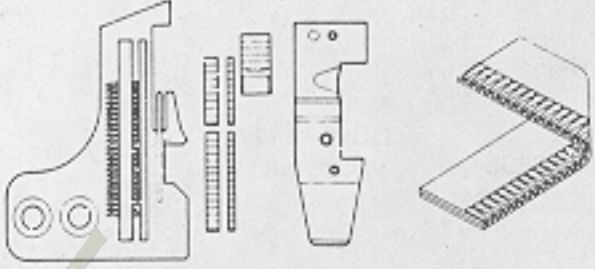
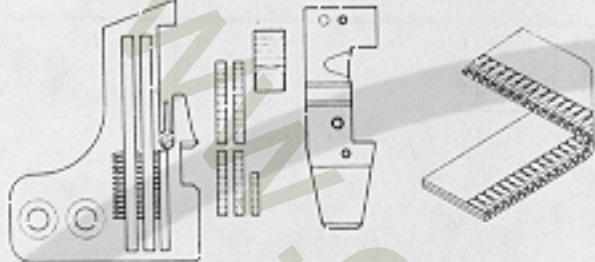

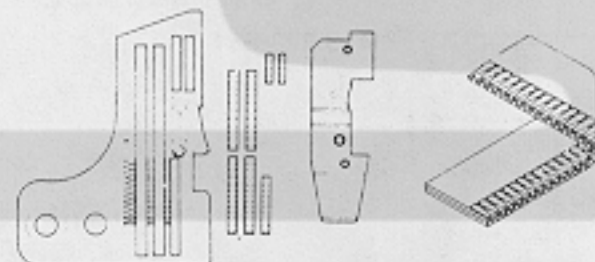
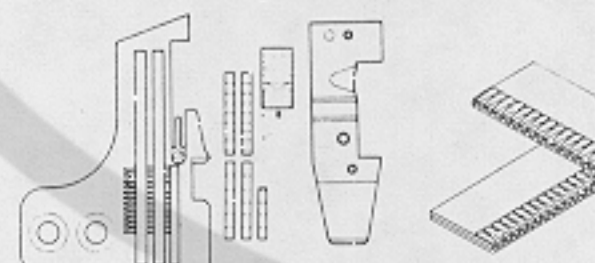
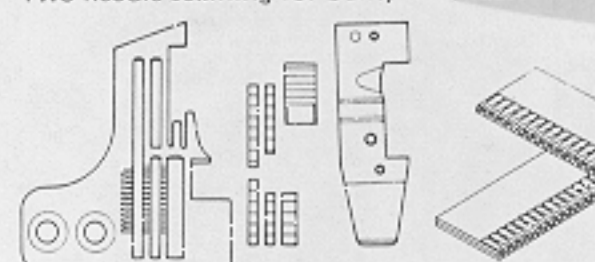
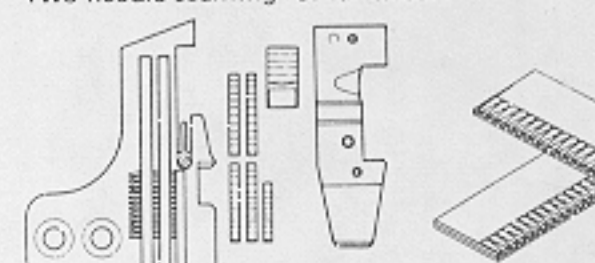
LIST OF ORGANIZATION PARTS

Machine model	Gauge (mm) (inch)	Needle plate	Feed dogs			Right looper # = mark stamped	Lower knife
			main	aux.	diff.		
512-4-53 Two needle seaming for woven fabrics. 	2x3mm	208322	208039	204674	208041	204702	201127
	5/64x1/8"	801-128	830-086	830-037	830-088	810-009 #4	870-211
	2x4mm	208323	"	"	"	"	"
	5/64x5/32"	801-129	"	"	"	"	"
	2x5mm	208324	"	"	"	"	202295
	5/64x3/16"	801-130	"	"	"	"	870-210
	3x3mm	208033	"	"	"	"	201127
	1/8x1/8"	801-086	"	"	"	"	870-211
	3x4mm	208034	"	"	"	"	202295
	1/8x5/32"	801-087	"	"	"	"	870-210
3x5mm	208035	"	"	"	"	"	
1/8x3/16"	801-088	"	"	"	"	"	
512-4-57 Two needle seaming on stretch fabrics. 	2x3mm	208325	"	208095	"	204663	201127
	5/64x1/8"	801-131	"	830-092	"	810-008 #7	870-211
	2x4mm	208326	"	"	"	"	"
	5/64x5/32"	801-132	"	"	"	"	"
	2x5mm	208327	"	"	"	"	202295
	5/64x3/16"	801-133	"	"	"	"	870-210
	3x3mm	208036	"	"	"	"	201127
	1/8x1/8"	801-089	"	"	"	"	870-211
	3x4mm	208037	"	"	"	"	202295
	1/8x5/32"	801-090	"	"	"	"	870-210
3x5mm	208038	"	"	"	"	"	
1/8x3/16"	801-091	"	"	"	"	"	
512-4-73 Two needle seaming on bulky knits. 	2.5x2.5mm	208030	208040	204674	208044	"	201127
	3/32x3/32"	801-083	830-087	830-037	830-091	"	870-211
	2.5x4mm	208031	"	"	"	"	202295
	3/32x5/32"	801-084	"	"	"	"	870-210
	2.5x5mm	208032	"	"	"	"	"
	3/32x3/16"	801-085	"	"	"	"	"
	3x3mm	208033	"	"	"	"	201127
	1/8x1/8"	801-086	"	"	"	"	870-211
	3x4mm	208034	"	"	"	"	202295
	1/8x5/32"	801-087	"	"	"	"	870-210
3x5mm	208035	"	"	"	"	"	
1/8x3/16"	801-088	"	"	"	"	"	

Note: All product code numbers begin with prefix 323-

Presser foot body	chaining- off finger	fabric guard	uncurler	Needle bar complete	Needle guard		Needle factory set	Attachment on machine (available by option)
					front	rear		
201230C 820-019	201396B 863-215	201265B 854-200	204668 560-020	204624 591-004	204659 561-011	204660 561-012		
"	201310A 863-201	"	"	"	"	"		
"	"	"	"	"	"	"		
"	208049 863-015	"	"	208047 591-009	208053 561-023	208054 561-024	DCx1 #11 423-222-831	(BT Backtacker)
"	208050 863-016	"	"	"	"	"		
"	"	"	"	"	"	"		
202799 820-286	201396B 863-215	"	205342A 560-041	204624 591-004	204659 561-011	204660 561-012		
"	201310A 863-201	"	"	"	"	"		
"	"	"	"	"	"	"		
205253 820-287	208049 863-015	"	"	208047 591-009	208053 561-023	"	DCx27 #14 423-243-631	
"	208050 863-016	"	"	"	"	"		
"	"	"	"	"	"	"		
201230C 820-019	208049 863-015	"	204668 560-020	208045 591-008	208051 561-021	208052 561-022		
"	208050 863-016	"	"	"	"	"		
"	"	"	"	"	"	"		
"	208049 863-015	"	"	208047 591-009	208053 561-023	208054 561-024	DCx1 #14 423-223-631	
"	208050 863-016	"	"	"	"	"		
"	"	"	"	"	"	"		

LIST OF ORGANIZATION PARTS

Machine model	Gauge (mm) (inch)	Needle plate	Feed dogs			Right looper # = mark stamped	Lower knife
			main	aux.	diff.		
514-4-20 Two needle seaming on light knits. 	1.5x2mm 1/16x5/64"	204910 801-043	204729A 830-103	204674 830-054	204730 830-059	204963 810-227 #8	202295 870-210
	1.5x3mm 1/16x1/8"	204911 801-044	"	"	"	"	"
	2x2mm 5/64x5/64"	205256 801-048	"	"	"	"	"
	2x3mm 5/64x1/8"	205257 801-049	"	"	"	"	"
514-4-61 Two needle seaming knits. 	2x2mm 5/64x5/64"	205255 801-047	204675A 820-096	"	204676 830-033	"	201127 870-211
	2x3mm 5/64x1/8"	205255 801-047	"	"	"	"	202295 870-210
	2x4mm 5/64x5/32"	202554E 801-030	"	"	"	"	"
514-4-62 Two needle intermittent shirring. 	2x2mm 5/64x5/64"	205255 801-047	204723A 830-108	"	204724 830-036	204964 810-228 #9	201127 870-211
	2x3mm 5/64x1/8"	205255 801-047	"	"	"	"	202295 870-210
	2x4mm 5/64x5/32"	202554E 801-030	"	"	"	"	"
514-4-64 Two needle seaming. 	2x4mm 5/64x5/32"	205243 801-364	204675A 830-096	204677 830-037	204676 830-033	"	"
514-4-67 Two needle seaming for bulky knitwear. 	2x2mm 5/64x5/64"	205255 801-047	204678A 830-094	204674 830-054	204691 830-058	"	201127 870-211
	2x3mm 5/64x1/8"	205255 801-047	"	"	"	"	202295 870-210
	2x4mm 5/64x5/32"	202554E 801-030	"	"	"	"	"
514-4-73 Two needle seaming for bulky knitwear. 	2.5x2.5mm 3/32x3/32"	208030 801-083	208040 830-087	"	208044 830-091	"	201127 870-211
	2.5x4mm 3/32x5/32"	208031 801-084	"	"	"	"	202295 870-210
514-4-68 Two needle seaming for knitwear. 	2x2mm 5/64x5/64"	205255 801-047	204675A 830-096	"	204690 830-058	204963 810-227 #8	201127 870-211
	2x3mm 5/64x1/8"	205255 801-047	"	"	"	"	202295 870-210
	2x4mm 5/64x5/32"	202554E 801-030	"	"	"	"	"

Note: All product code numbers begin with prefix 323-

Presser foot				Needle bar complete	Needle guard		Needle factory set	Attachment on machine (available by option)
body	chaining-off finger	fabric guard	uncurler		front	rear		
201230C 820-019	201396B 863-215	201265B 854-200	204668 560-020	204872 591-007	204659 561-011	204660 561-012	DCx3 #9	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	"	"	"	204624 591-004	"	"	DCx1 #9 423-222-631	
"	"	"	"	"	"	"		
"	"	"	"	"	"	"	DCx1 #9 423-222-631	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	201310A 863-201	"	"	"	"	"	DCx1 #14 423-223-631	Shirring attachment (KS Chain Cutter)
"	"	"	"	"	"	"		
205136 820-014	---	---	205342A 560-041	"	"	"	DCx1 #14 423-223-631	(KS Chain Cutter)
"	---	---	"	"	"	"		
"	---	---	"	"	"	"	DCx1 #14 423-223-631	(KS Chain Cutter)
"	---	---	"	"	"	"		
205253 820-287	201310A 863-201	201265B 854-200	"	"	"	"	DCx1 #14 423-223-631	(KS Chain Cutter)
"	"	"	"	"	"	"		
201230C 820-019	201396B 863-215	"	204668 560-020	"	"	"	DCx1 #14 423-223-631	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	201310A 863-201	"	"	"	"	"	DCx1 #14 423-223-631	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	208049 863-015	"	"	208045 591-008	208051 561-021	208052 561-022	DCx1 #14 423-223-631	(KS Chain Cutter) (BT Backtacker)
"	208050 863-016	"	"	"	"	"		
"	201396B 863-215	"	"	204624 591-004	204659 561-011	204660 561-012	DCx1 #11 423-222-831	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	201310A 863-201	"	"	"	"	"	DCx1 #11 423-222-831	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		

CROSS NUMBER INDEX

(new product code numbers vs part numbers)

NEW PRODUCT CODE NO.	PART NO.	PAGE	REF NO.	NEW PRODUCT CODE NO.	PART NO.	PAGE	REF NO.	NEW PRODUCT CODE NO.	PART NO.	PAGE	REF NO.
	206550	7	19	323-560-041	205342A	47		323-600-002	1175-2	45	13
323-400-001	201211A	45	14	323-560-041	205342A	49		323-600-004	5060	25	11
323-500-019	208602	3	4	323-560-041	205342A	51		323-600-004	5060	29	12
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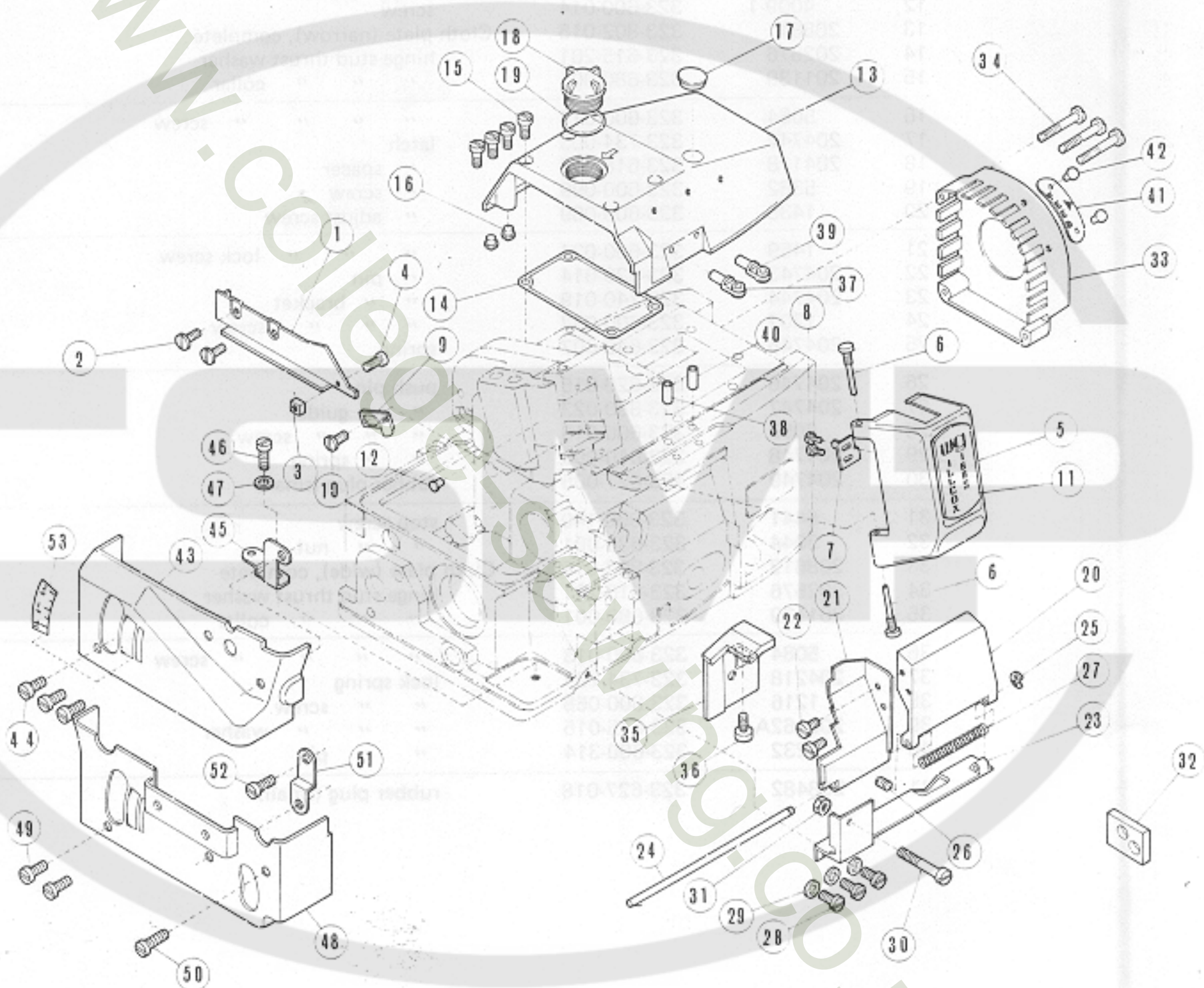
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323-630-001	3044	41	41	323-649-001	201009	29	8	323-680-208	204150	25	9
323-630-001	3044	45	9	323-649-003	204631	15	15	323-680-210	205068	41	7
323-630-003	3091	41	24	323-650-001	208449	15	6	323-683-013	204638	25	16
323-630-003	5099	15	28	323-650-001	208449	17	44	323-683-014	204759	25	30
323-630-013	5348	41	50	323-650-001	208449	19	30	323-683-015	204830	43	4
323-630-017	204870	21	52	323-653-003	202081	9	3	323-683-018	208427	13	7
323-630-018	222	37	8	323-653-004	204618	23	10	323-683-213	204155	43	6
323-630-019	226	37	12	323-653-005	202176	13	27	323-683-214	204189	29	24
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323-630-020	231	37	20	323-653-006	204270	33	24	323-685-012	204758	25	19
323-630-020	231	37	23	323-653-007	204465	33	25	323-685-013	227	37	13
323-630-020	231	37	26	323-653-017	208561	15	24	323-685-014	238	37	
323-630-021	236	37	28	323-653-018	208562	15	25	323-685-016	260	37	31
323-630-021	236	37	30	323-653-019	208617	13	26	323-685-017	261	37	
323-630-032	5404	23	13	323-653-209	204274	17	28	323-685-018	262	37	
323-630-033	208447	15	1	323-655-002	201338	29	17	323-685-022	208525	27	8
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323-685-243	205103	41	30	323-800-057	208317	5	1	323-801-347	205234	48	
323-686-002	204588	23	11	323-800-058	208296	17	24	323-801-360	205239	46	
323-692-034	208440	3	20	323-800-061	208430	5	11	323-801-360	205239	48	
323-692-035	208441	3		323-800-062	208563	15	26	323-801-361	205240	46	
323-692-036	208442	3		323-800-063	208208	21	12	323-801-361	205240	48	
323-692-037	208444	3		323-800-064	208209	21	13	323-801-362	205241	46	
323-692-201	202526	3	25	323-800-065	208487	33	6	323-801-362	205241	48	
323-692-256	204450	7	11	323-800-215	202849	15	8	323-801-363	205242	46	
323-710-003	204929	27	47	323-800-215	202849	17	46	323-801-363	205242	48	
323-713-003	208260	31	16	323-800-215	202849	19	32	323-801-364	205243	50	
323-716-011	208273	23	18	323-800-224	204021	9	20	323-801-364	205243	54	
323-716-013	208410	21	19	323-800-235	204495	41	16	323-801-365	205244	50	
323-716-014	208547	27	14	323-801-026	202542E	46		323-802-015	208611	5	13
323-716-209	202683	27	44	323-801-026	202542E	48		323-802-016	208612	5	33
323-728-004	194	41	39	323-801-027	202546E	46		323-810-008	204663	50	
323-728-008	208008	7	23	323-801-027	202546E	48		323-810-008	204663	52	
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323-730-012	208425	13	4	323-801-028	202596E	48		323-810-009	204702	48	
323-730-214	204140A	21	41	323-801-029	202597E	46		323-810-009	204702	52	
323-732-001	126	39	18	323-801-029	202597E	48		323-810-011	204704	46	
323-732-002	199	41	53	323-801-030	202554E	50		323-810-110	204703	48	
323-734-003	204742	5	17	323-801-030	202554E	54		323-810-216	204072	19	22
323-734-204	204218	5	37	323-801-031	202499E	50		323-810-218	204062	46	
323-736-200	204196	31	12	323-801-038	202616	46		323-810-218	204062	48	
323-740-012	201485	45	6	323-801-039	202617	46		323-810-227	204963	54	
323-740-016	202705A	13	9	323-801-041	204731	48		323-810-228	204964	54	
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323-740-018	204636	11	23	323-801-043	204910	54		323-810-232	204991	43	43
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323-740-034	229	37	15	323-801-045	204913	46		323-820-014	205136	47	
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323-740-039	205316	43	24	323-801-049	205257	54		323-820-019	201230C	49	
323-740-040	205335	43	9	323-801-062	205320	46		323-820-019	201230C	51	
323-740-061	204887	43	28	323-801-063	205321	46		323-820-019	201230C	53	
323-740-062	205470	35	7	323-801-064	205322	46		323-820-019	201230C	55	
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323-740-229	204451	45	1	323-801-067	205325	46		323-820-028	205314	43	22
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323-750-006	233	37	21	323-801-083	208030	52		323-820-285	205252	49	
323-750-010	204886	43	27	323-801-083	208030	54		323-820-286	202799	47	
323-750-204	205069	41	9	323-801-084	208031	52		323-820-286	202799	49	
323-750-205	205104	41	28	323-801-084	208031	54		323-820-286	202799	53	
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323-758-004	202281	43	45	323-801-086	208033			323-820-287	205253	53	
323-764-001	201294	29	5	323-801-087	208034	52		323-820-287	205253	55	
323-764-002	201295	29	6	323-801-087	208034			323-830-033	204676	46	
323-774-002	205468	35	9	323-801-088	208035	52		323-830-033	204676	48	
323-774-003	205469	35	10	323-801-088	208035			323-830-033	204676	54	
323-780-009	208173	3	15	323-801-089	208036	52		323-830-034	204693	48	
323-780-009	208173	17	32	323-801-090	208037	52		323-830-035	204722	48	
323-780-010	208450	15	4	323-801-091	208038	52		323-830-036	204724	46	
323-780-010	208450	17	42	323-801-128	208322	52		323-830-036	204724	50	
323-780-010	208450	19	28	323-801-129	208323	52		323-830-036	204724	54	
323-780-011	208320	9	32	323-801-130	208324	52		323-830-037	204677	46	
323-780-012	208621	13	28	323-801-131	208325	52		323-830-037	204677	48	
323-780-013	208592	17	35	323-801-132	208326	52		323-830-037	204677	50	
323-780-014	204895	43	41	323-801-133	208327	52		323-830-037	204677	54	
323-787-005	208207	21	10	323-801-222	202618	46		323-830-054	204674	46	
323-800-006	201293A	29	3	323-801-340	205235	48		323-830-054	204674	48	
323-800-026	204646	7	32	323-801-341	205236	48		323-830-054	204674	50	
323-800-036	204142B	21	48	323-801-342	205237	48		323-830-054	204674	52	
323-800-041	243	37	5	323-801-343	205238	48		323-830-054	204674	54	
323-800-053	208110	23	45	323-801-344	205231	48		323-830-056	204679	48	
323-800-055	208341	5	5	323-801-345	205232	48		323-830-057	204690	46	

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1	20637	323-800-024	Bed plate complete
2	20642	323-800-024	Bracket
3	41001	323-800-018	Bracket
4	20187	323-800-009	Clamp plate cushion (right)
5	20834	323-800-026	Bed cover plate (right)
6	20638	323-800-023	Bracket
7	2117	323-800-027	Screw
8	20643	323-810-019	Machine bed bottom cover
9	20838	323-800-011	Oil filter
10	2117	323-800-027	Screw
11	20430	323-800-021	Face plate complete
12	40021	323-800-021	Lock screw
13	20644	323-800-021	Lock screw
14	20645	323-800-021	Lock screw
15	20646	323-800-021	Lock screw
16	20647	323-800-021	Lock screw
17	20648	323-800-021	Lock screw
18	20649	323-800-021	Lock screw
19	20650	323-800-021	Lock screw
20	20651	323-800-021	Lock screw
21	20652	323-800-021	Lock screw
22	20653	323-800-021	Lock screw
23	20654	323-800-021	Lock screw
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25	20656	323-800-021	Lock screw
26	20657	323-800-021	Lock screw
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29	20660	323-800-021	Lock screw
30	20661	323-800-021	Lock screw
31	20662	323-800-021	Lock screw
32	20663	323-800-021	Lock screw
33	20664	323-800-021	Lock screw
34	20665	323-800-021	Lock screw
35	20666	323-800-021	Lock screw
36	20667	323-800-021	Lock screw
37	20668	323-800-021	Lock screw
38	20669	323-800-021	Lock screw
39	20670	323-800-021	Lock screw
40	20671	323-800-021	Lock screw
41	20672	323-800-021	Lock screw
42	20673	323-800-021	Lock screw
43	20674	323-800-021	Lock screw
44	20675	323-800-021	Lock screw
45	20676	323-800-021	Lock screw
46	20677	323-800-021	Lock screw
47	20678	323-800-021	Lock screw
48	20679	323-800-021	Lock screw
49	20680	323-800-021	Lock screw
50	20681	323-800-021	Lock screw
51	20682	323-800-021	Lock screw
52	20683	323-800-021	Lock screw
53	20684	323-800-021	Lock screw



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323-830-059	204730	46		323-863-201	201310A	55					
323-830-059	204730	54		323-863-215	201396B	51					
323-830-060	204907	46		323-863-215	201396B	53					
323-830-086	208039	52		323-863-215	201396B	55					
323-830-087	208040	52		323-863-217	201155C	47					
323-830-087	208040	54		323-866-005	204786	19	33				
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323-830-091	208044	52		323-866-016	208445	17	47				
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323-830-094	204678A	48		323-870-210	202295	25	28				
323-830-094	204678A	54		323-870-210	202295	46					
323-830-096	204675A	46		323-870-210	202295	48					
323-830-096	204675A	48		323-870-210	202295	50					
323-830-096	204675A	54		323-870-210	202295	52					
323-830-097	204721A	48		323-870-210	202295	54					
323-830-103	204729A	46		323-870-211	201127	25	29				
323-830-103	204729A	54		323-870-211	201127	46					
323-830-108	204723A	46		323-870-211	201127	48					
323-830-108	204723A	50		323-870-211	201127	50					
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323-830-134	208336	46		323-870-211	201127	54					
323-830-135	208337	46		323-870-214	201121A	25	12				
323-830-136	208338	46		323-870-217	204152	43	1				
323-850-021	202495	13	10	323-873-001	201308	27	6				
323-850-022	204667	45	10	323-875-001	205137	41	1				
323-850-023	204747	5	27	323-875-003	204966	43	26				
323-850-028	204896	45		323-880-005	200	39	14				
323-850-031	228	37	14	323-880-010	282	39	9				
323-850-032	205319	43	13	323-880-011	283	39	8				
323-850-033	205315	43	23	323-880-012	284	39	7				
323-850-034	205330	43	15	323-880-013	285	39	6				
323-850-035	205331	43	16	323-880-014	286	39	5				
323-850-036	205332	43	17	323-880-214	182	39	13				
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323-850-050	208107A	23	41	323-885-002	128	39	11				
323-850-055	208479	27	32	323-885-200	179	39	12				
323-850-056	204891	43	36	323-886-001	131	39	15				
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323-850-200	201074A	19	4	323-891-200	204143A	21	50				
323-850-221	200041	13	12	323-900-012	204593	29					
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323-851-010	204656	17	54	323-900-046	208489	15					
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323-854-200	201265B	49		323-940-004	289	37					
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323-860-200	201048A	7	39	323-945-003	135A	39	3				
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323-863-007	201224B	49		323-945-009	205216	39	21				
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128	323-885-002	39	11	1170-1	323-600-020	17	3	2922	323-600-229	7	4
131	323-886-001	39	15	1170-1	323-600-020	19	3	2922	323-600-229	23	50
134	323-945-015	39	1	1170-1	323-600-020	41	34	3001	323-600-059	29	25
135A	323-945-003	39	3	1170-3	323-600-046	13	8	3044	323-630-001	5	32
137	323-659-015	39	2	1174	323-600-027	9	14	3044	323-630-001	27	3
153	323-660-200	39	16	1175-2	323-600-002	11	28	3044	323-630-001	41	41
175	323-600-321	35	8	1175-2	323-600-002	17	33	3044	323-630-001	45	9
178	323-945-007	39	4	1175-2	323-600-002	23	48	3091	323-630-003	41	24
179	323-885-200	39	12	1175-2	323-600-002	25	17	3119	323-630-213	13	18
182	323-880-214	39	13	1175-2	323-600-002	25	26	4009-1	323-600-014	5	3
192	323-900-224	41		1175-2	323-600-002	43	37	4009-1	323-600-014	5	12
193	323-530-100	41	38	1175-2	323-600-002	45	13	4009-1	323-600-014	7	2
194	323-728-004	41	39	1175-3	323-600-019	11	24	4009-1	323-600-014	7	10
195	323-620-100	41	45	1175-3	323-600-019	19	23	4009-1	323-600-014	11	16
196	323-640-100	41	47	1175-3	323-600-019	21	18	4009-1	323-600-014	15	14
197	323-505-100	41	48	1175-3	323-600-019	41	31	4009-1	323-600-014	23	3
198	323-665-001	41	52	1189	323-600-301	7	22	5002	323-600-011	25	20
199	323-732-002	41	53	1189	323-600-301	23	52	5010	323-600-010	9	33
200	323-880-005	39	14	1196	323-600-029	21	14	5010	323-600-010	25	27
216	323-535-001	37	1	1202	323-600-032	5	24	5012	323-600-255	17	55
217	323-600-118	37	2	1202	323-600-032	27	42	5012	323-600-255	33	7
218	323-535-002	37	3	1202	323-600-032	45	11	5019	323-600-247	35	11
219	323-740-035	37	4	1206	323-600-021	11	19	5029	323-600-256	23	23
220	323-740-036	37	6	1206	323-600-021	11	22	5029	323-600-256	27	38
221	323-600-119	37	7	1206	323-600-021	33	18	5030	323-600-202	27	17
222	323-630-018	37	8	1216	323-600-068	5	38	5053	323-600-015	5	28
223	323-620-024	37	9	1216	323-600-068	7	28	5053	323-600-015	13	25
224	323-615-028	37	10	1216	323-600-068	21	47	5060	323-600-004	25	11
225	323-617-001	37	11	1216	323-600-068	41	36	5060	323-600-004	29	12
226	323-630-019	37	12	1229	323-600-016	41	14	5064	323-600-025	41	5
227	323-685-013	37	13	1231	323-600-051	27	19	5077	323-600-307	43	18
228	323-850-031	37	14	1234	323-600-006	7	8	5078	323-600-001	3	6
229	323-740-034	37	15	1234	323-600-006	43	10	5080	323-600-008	9	28
230	323-600-120	37	16	1234	323-600-006	43	12	5081	323-600-009	9	29
230	323-600-120	37	19	1333	323-600-048	27	7	5082A	323-604-201	15	7
230	323-600-120	37	22	1435	323-600-069	5	20	5082A	323-604-201	17	45
230	323-600-120	37	25	1457	323-600-012	13	30	5082A	323-604-201	19	31
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231	323-630-020	37	23	1458	323-600-037	29	10	5084	323-600-013	11	13
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204745	323-640-007	5	25	204930	323-676-039	27	48	205333	323-580-037	43	20
204746	323-620-015	5	26	204950	323-510-036	43	8	205335	323-740-040	43	9
204747	323-850-023	5	27	204963	323-810-227	54		205342A	323-560-041	47	
204748	323-640-008	5	29	204964	323-810-228	54		205342A	323-560-041	49	
204749	323-627-005	5	30	204966	323-875-003	43	26	205342A	323-560-041	51	
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204751	323-540-016	23	1	204991	323-810-232	43	43	205342A	323-560-041	55	
204752	323-540-017	21	34	205065	323-640-225	41	3	205466	323-945-001	35	1
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204756	323-640-006	21	54	205068	323-680-210	41	7	205469	323-774-003	35	10
204757	323-600-102	21	55	205069	323-750-204	41	9	205470	323-740-062	35	7
204758	323-685-012	25	19	205070	323-625-203	41	13	205473	323-945-014	35	2
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204787	323-576-006	19	7	205135	323-820-013	47		206550		7	19
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204797	323-801-042	48		205217	323-600-117	39	22	208010	323-640-015	7	27
204806	323-615-029	31	21	205231	323-801-344	48		208023A	323-510-086	7	5
204810	323-750-003	23	37	205232	323-801-345	48		208030	323-801-083	52	
204827	323-627-009	5	4	205233	323-801-346	48		208030	323-801-083	54	
204828	323-627-010	3	16	205234	323-801-347	48		208031	323-801-084	52	
204830	323-683-015	43	4	205235	323-801-340	48		208031	323-801-084	54	
204835	323-870-004	43	2	205236	323-801-341	48		208032	323-801-085	52	
204848A	323-560-051	7	1	205237	323-801-342	48		208033	323-801-086	52	
204853	323-530-017	19	19	205238	323-801-343	48		208033	323-801-086		
204854	323-676-029	17		205239	323-801-360	46		208034	323-801-087	52	
204857A	323-510-091	7	43	205239	323-801-350	48		208034	323-801-087		
204860	323-658-004	33		205240	323-801-361	46		208035	323-801-088	52	
204861	323-658-003	33	13	205240	323-801-361	48		208035	323-801-088		
204862	323-510-035	33	14	205241	323-801-362	46		208036	323-801-089	52	
204863	323-620-025	33	15	205241	323-801-362	48		208037	323-801-090	52	
204865A	323-510-088	7	48	205242	323-801-363	46		208038	323-801-091	52	
204867	323-646-005	7	51	205242	323-801-363	48		208039	323-830-086	52	
204868	323-646-004	7	45	205243	323-801-354	50		208040	323-830-087	52	
204869	323-600-107	21	56	205243	323-801-364	54		208040	323-830-087	54	
204870	323-630-017	21	52	205244	323-801-365	50		208041	323-830-088	52	
204871	323-628-002	7	42	205252	323-820-285	49		208044	323-830-091	52	
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204882	323-900-014	41		205253	323-820-287	51		208045	323-591-008	53	
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204884	323-561-017	11	25	205253	323-820-287	55		208047	323-591-009	53	
204886	323-750-010	43	27	205255	323-801-047	50		208049	323-863-015	53	
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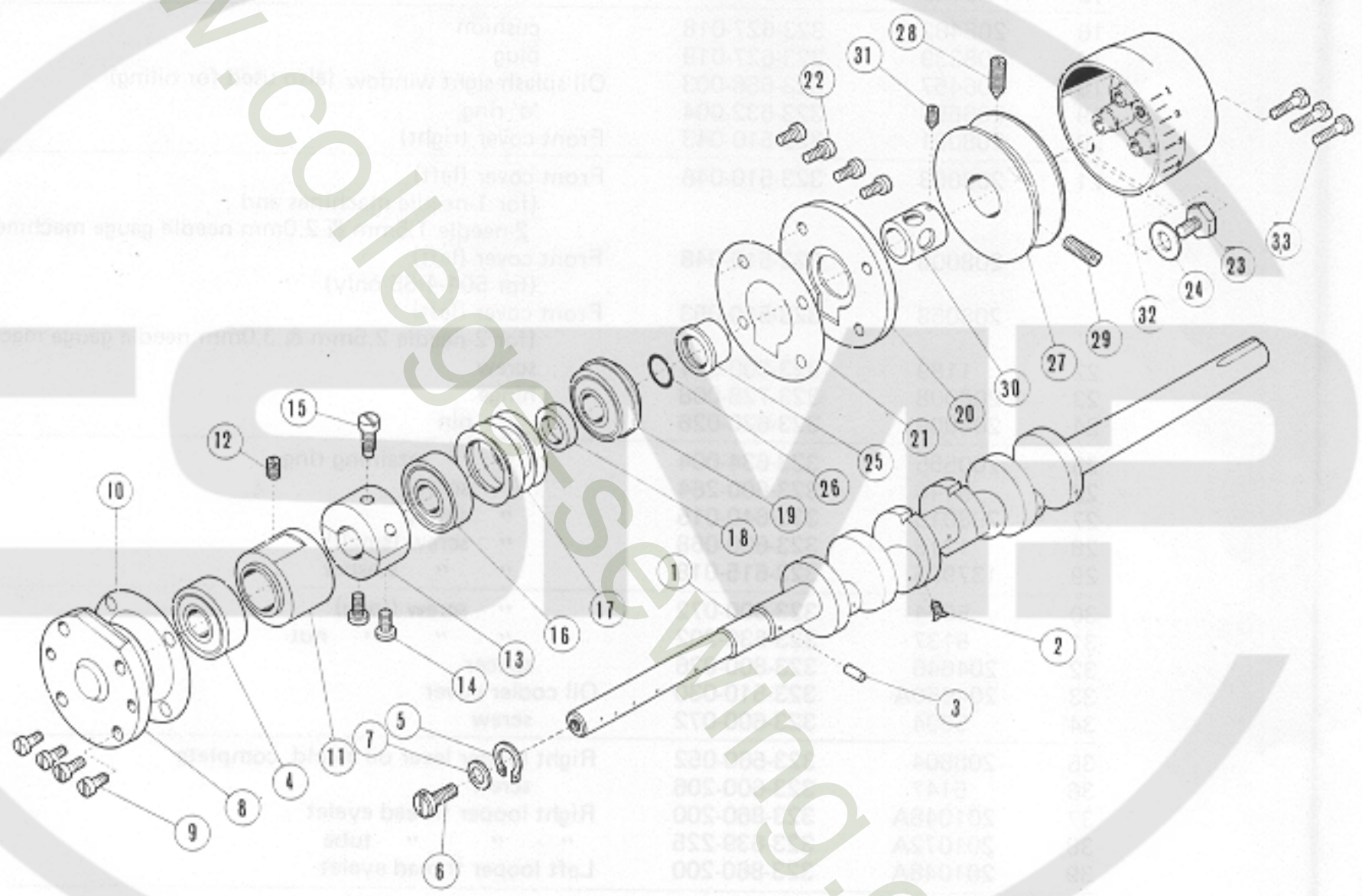
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208050	323-863-016	55		208347	323-510-078	5	8	204667	323-850-022	45	10
208051	323-561-021	53		208348	323-655-011	5	9	204692A	323-830-093	47	
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208052	323-561-022	53		208409	323-618-018	21	15				
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208107A	323-850-050	23	41	208425	323-730-012	13	4				
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208110	323-800-053	23	45	208430	323-800-061	5	11				
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208169A	323-663-021	3	13	208440	323-692-034	3	20				
208173	323-780-009	3	15	208441	323-692-035	3					
208173	323-780-009	17	32	208442	323-692-036	3					
208207	323-787-005	21	10	208444	323-692-037	3					
208208	323-800-063	21	12	208445	323-866-016	17	47				
208209	323-800-064	21	13	208446	323-639-034	33	4				
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208248	323-676-042	11	9	208447	323-630-033	17	39				
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208250	323-626-002	11	10	208448	323-676-047	15	2				
208258	323-620-041	17	22	208448	323-676-047	17	40				
208260	323-713-003	31	16	208448	323-676-047	19	26				
208271	323-680-011	9	25	208449	323-650-001	15	6				
208272	323-632-002	9	26	208449	323-650-001	17	44				
208273	323-716-011	23	18	208449	323-650-001	19	30				
208282	323-580-084	21	7	208450	323-780-010	15	4				
208284	323-575-019	23	7	208450	323-780-010	17	42				
208285	323-620-035	23	12	208450	323-780-010	19	28				
208286	323-615-036	23	14	208479	323-850-055	27	32				
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208293	323-677-046	19	16	208482	323-627-018	7	16				
208294	323-676-045	21	35	208487	323-800-065	33	6				
208296	323-800-058	17	24	208488	323-900-045	15					
208299	323-510-079	7	13	208489	323-900-046	15					
208299	323-676-048	17	14	208489	323-900-046	19	24				
208307	323-851-024	15	10	208490	323-900-047	17	38				
208308	323-658-005	33	1	208491	323-900-048	15	9				
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208314	323-620-036	27	27	208526	323-502-011	27	1				
208315	323-640-024	27	28	208534	323-540-031	27	20				
208316	323-604-018	27	49	208535	323-676-050	27	21				
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208323	323-801-129	52		208561	323-653-017	15	24				
208324	323-801-130	52		208562	323-653-018	15	25				
208325	323-801-131	52		208563	323-800-062	15	26				
208326	323-801-132	52		208568	323-510-089	15					
208327	323-801-133	52		208592	323-780-013	17	35				
208330	323-625-002	21	17	208597	323-676-052	17	34				
208333	323-576-020	21		208598	323-530-031	27	35				
208336	323-830-134	46		208599	323-676-053	27	37				
208337	323-830-135	46		208602	323-500-019	3	4				
208338	323-830-136	46		208603	323-500-020	3	8				
208339	323-627-019	7	17	208604	323-560-052	7	35				
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208341	323-800-055	5	5	208612	323-802-016	5	33				
208342	323-663-022	5	6	208615	323-600-142	27	34				
208343	323-540-029	9	1	208616	323-560-053	13	24				
208346	323-525-013	17	1	208617	323-653-019	13	26				

(2) MISCELLANEOUS COVERS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204848A	323-560-051	Cloth plate fabric guard	1
2	4009-1	323-600-014	screw	2
3	204681	323-646-003	spacer	1
4	2922	323-600-229	" screw	1
5	208023A	323-510-086	Needle bar cover	1
6	202653	323-620-240	hinge pin	2
7	202689	323-641-201	lock spring	1
8	1234	323-600-006	" " screw	2
9	204223	323-510-248	" " latch	1
10	4009-1	323-600-014	" " " screw	1
11	204450	323-692-256	name plate	1
12	192107-1	325-627-002	cushion rubber	1
13	208299	323-510-079	Top cover	1
14	208481	323-663-030	gasket	1
15	5152	323-600-061	screw	4
16	208482	323-627-018	cushion	2
17	208339	323-627-019	plug	1
18	206457	323-656-003	Oil splash sight window (also used for oiling)	1
19	206550	323-632-004	'o' ring	1
20	208001	323-510-043	Front cover (right)	1
21	208003	323-510-046	Front cover (left) (for 1-needle machines and 2-needle 1.5mm & 2.0mm needle gauge machines)	1
	208005	323-510-048	Front cover (left) (for 504-4-65 only)	1
	208058	323-510-053	Front cover (left) (for 2-needle 2.5mm & 3.0mm needle gauge machines)	1
22	1189	323-600-301	screw	2
23	208008	323-728-008	hinge	1
24	208009	323-620-026	" pin	1
25	200555	323-634-004	" " retaining ring	1
26	5146	323-600-264	" screw	1
27	208010	323-640-015	" spring	1
28	1216	323-600-068	" screw (small)	3
29	137906	323-615-018	" " washer	3
30	5094	323-600-072	" screw (long)	1
31	5137	323-630-202	" " " nut	1
32	204646	323-800-026	spacer	1
33	204650A	323-510-030	Oil cooler cover	1
34	5094	323-600-072	screw	3
35	208604	323-560-052	Right looper lever oil shield, complete	1
36	5147	323-600-206	screw	1
37	201048A	323-860-200	Right looper thread eyelet	1
38	201072A	323-639-225	" " " tube	1
39	201048A	323-860-200	Left looper thread eyelet	1
40	201072A	323-639-225	" " " tube	1
41	204649	323-891-002	Stitch indicator	1
42	204871	323-628-002	rivet	2
43	204857A	323-510-091	Machine cover (left) (used with Cloth Plate, Narrow 208611)	1
44	5091	323-600-257	screw	3
45	204868	323-646-004	spacer	1
46	2902	323-600-259	" screw	1
47	202286	323-617-200	" " washer	1
48	204865A	323-510-088	Machine cover (left) (used with Cloth Plate, Wide 208612)	1
49	5091	323-600-257	screw (short)	2
50	5182	323-600-109	" (long)	1
51	204867	323-646-005	spacer	1
52	5113	323-600-039	" screw	1
53	208340	323-891-004	Diff. feed ratio indication plate	1

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REF NO	PART NO	NEW PRODUCT CODE NO	DESCRIPTION
1	20188A	323-600-101	Clutch plate fabric guard
2	20188T	323-600-014	screw
3	20188L	323-600-003	spacer
4	20188S	323-600-228	washer
5	20188ZA	323-610-088	Machine cover (left)
6	20188B	323-600-210	screw (short)
7	20188R	323-600-201	screw (long)
8	20188C	323-600-008	spacer
9	20188D	323-610-288	Machine cover (right)
10	20188F	323-600-014	screw
11	20188G	323-600-288	screw
12	20188H	323-610-012	Clutch indicator
13	20188J	323-600-019	Top cover
14	20188K	323-600-010	gear
15	20188L	323-600-081	screw
16	20188M	323-600-018	Clutch
17	20188N	323-600-018	Clutch
18	20188O	323-600-003	Clutch
19	20188P	323-600-003	Clutch
20	20188Q	323-610-048	Front cover (left)
21	20188R	323-610-048	Front cover (right)
22	20188S	323-600-003	Clutch
23	20188T	323-600-003	Clutch
24	20188U	323-600-003	Clutch
25	20188V	323-600-003	Clutch
26	20188W	323-600-003	Clutch
27	20188X	323-600-003	Clutch
28	20188Y	323-600-003	Clutch
29	20188Z	323-600-003	Clutch
30	20188AA	323-600-003	Clutch
31	20188AB	323-600-003	Clutch
32	20188AC	323-600-003	Clutch
33	20188AD	323-600-003	Clutch

CRANKSHAFT MECHANISM

REF NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208343	323-540-029	Crankshaft	1
2	5315	323-600-344	oil plug screw	1
3	202081	323-653-003	" felt	1
4	204010	323-671-200	ball bearing (left)	1
5	204734	323-633-002	" " " retaining ring	1
6	5361	323-600-097	" " " screw	1
7	204520	323-615-233	" " " " washer	1
8	204737	323-515-002	" " " housing	1
9	5136	323-600-245	" " " " screw	4
10	204319	323-663-205	" " " " gasket	1
11	204014	323-676-243	bushing	1
12	2022	323-600-043	" screw	1
13	204016	323-676-232	" (center), set with 1174-2	1
14	1174	323-600-027	" (center) assembly screw	2
15	5240	323-600-293	" " screw	1
16	201523A	323-671-001	ball bearing (center)	1
17	204018	323-615-217	" " " washer	4
18	204019A	323-646-001	" " " spacer	1
19	204020A	323-671-002	" " (right)	1
20	204021	323-800-224	" " " plate	1
21	204022	323-626-202	" " " " gasket	1
22	5117	323-600-057	" " " " screw	4
23	5238	323-600-294	" " " screw	1
24	204023	323-615-221	" " " " washer	1
25	208271	323-680-011	oil seal collar	1
26	208272	323-632-002	" " " 'o' ring	1
27	204025	323-546-203	Machine pulley	1
28	5080	323-600-008	position screw	1
29	5081	323-600-009	screw	1
30	204026	323-546-204	collar	1
31	5267	323-600-295	" screw	1
32	208320	323-780-011	cap	1
33	5010	323-600-010	" screw	3