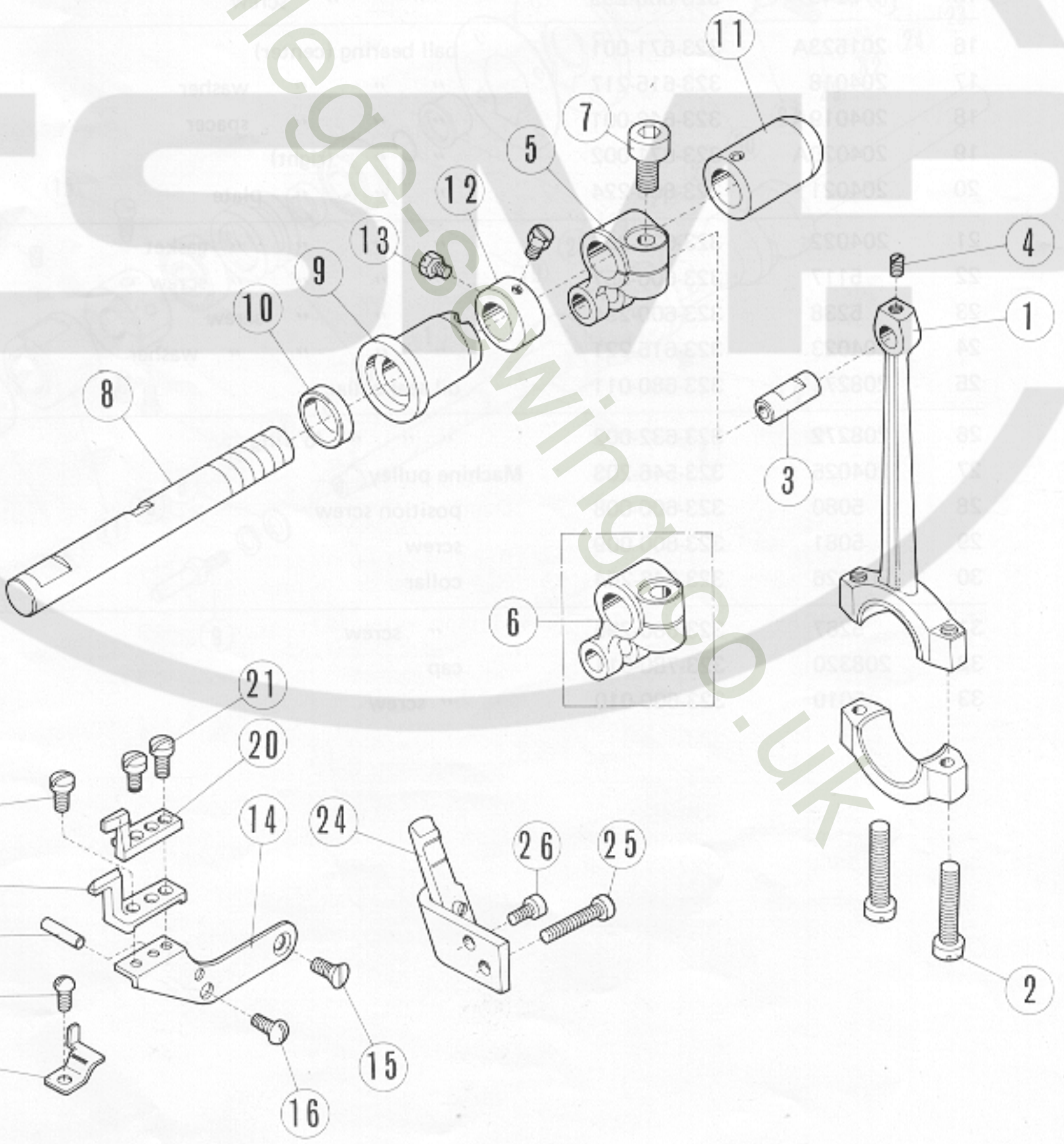
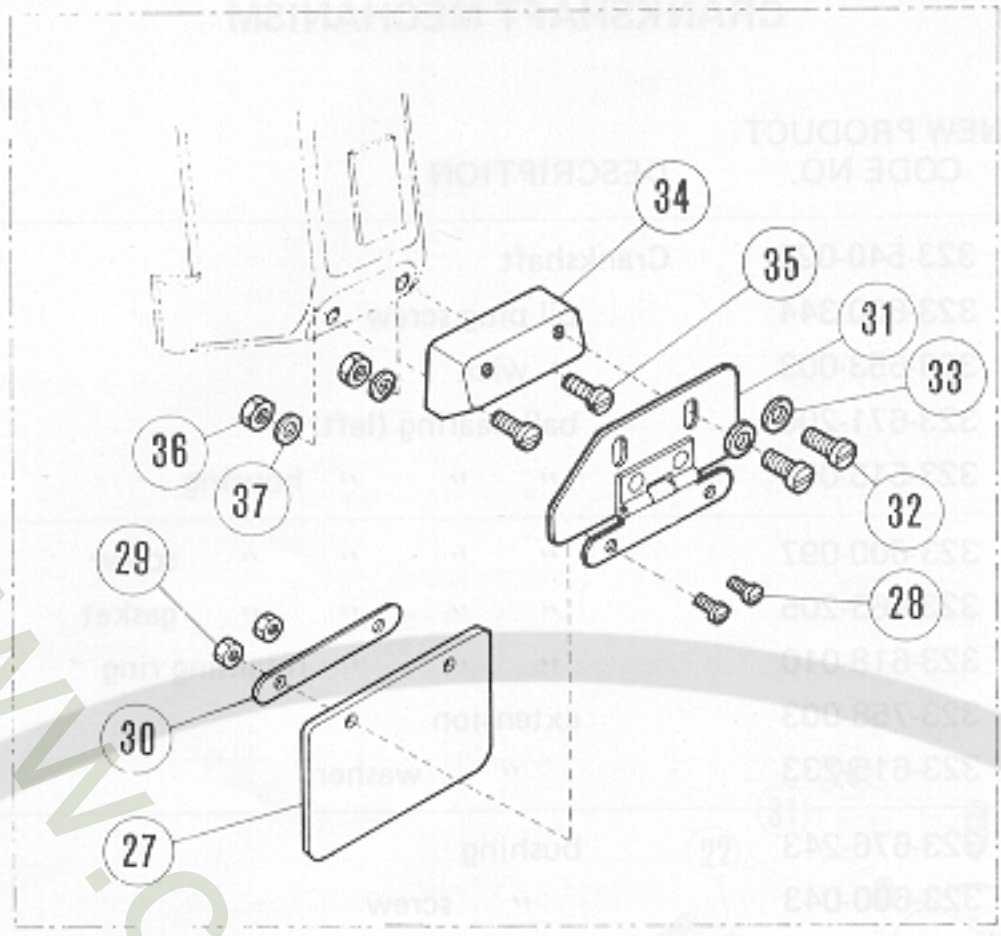


MACHINE BED FRAME

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QTY
1	208600	MFG only	Machine bed frame	1
2	5332	323 600-359	oil hole plug screw (with head)	1
3	2022	323 600-053	" " " " screw	3
4	208502	323 500-019	Machine arm (right)	1
5	204751	323 603-207	gasket	1
6		323 600-001	screw	4
7	201502	323 600-001	dowel pin	1
8	208501	323 500-018	Machine arm (left)	1
9	5237		screw (long)	

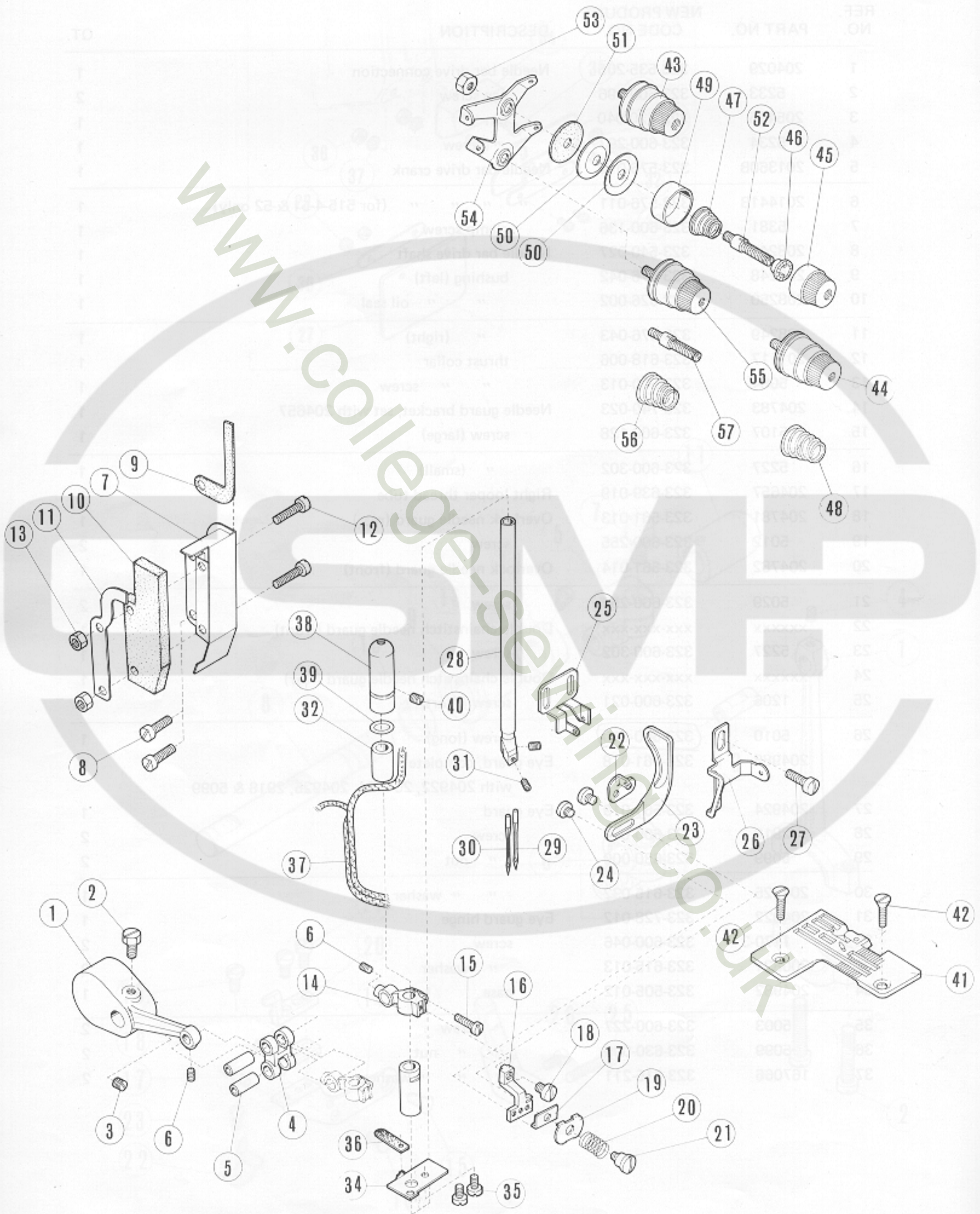
	Page
Machine bed frame .....	2-3
(1) Miscellaneous covers .....	4-5
(2) Miscellaneous covers .....	6-7
Crankshaft mechanism .....	8-9
(1) Needle drive mechanism .....	10-11
(2) Needle drive mechanism .....	12-13
Right looper drive mechanism .....	14-15
Left looper drive mechanism .....	16-17
(1) Double chainstitch looper drive mechanism .....	18-19
(2) Double chainstitch looper drive mechanism .....	20-21
(1) Main and differential feed mechanism .....	22-23
(2) Main and differential feed mechanism .....	24-25
Upper and lower knife mechanism .....	26-27
Presser foot and lift mechanism .....	28-29
(1) Pump lubricating mechanism .....	30-31
(2) Pump lubricating mechanism .....	32-33
Needle and thread lubricator .....	34-35
Attachments .....	36-37
Accessories for semi-submerged installation .....	38-39
Thread stand .....	40-41
Accessories .....	42-43
(1) Optional parts .....	44-45
(2) Optional parts .....	46-47
List of organization parts .....	48-52
Cross number index .....	53-70
Organization chart .....	72



REF NO	PART NO	DESCRIPTION
1	208343	
2	2318	
3	202081	
4	204010	
5	204881	
6	2381	
7	204319	
8	204789	
9	204813	
10	204520	
11	204744	
12	204018	
13	232-600-025	
14	232-600-025	
15	232-600-025	
16	232-600-025	
17	232-600-025	
18	232-600-025	
19	232-600-025	
20	232-600-025	
21	232-600-025	
22	232-600-025	
23	232-600-025	
24	232-600-025	
25	232-600-025	
26	232-600-025	

### (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	1
6	201441B	323-576-011	" " " " (for 515-4-51 & -52 only)	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	1
14	204783	323-740-023	Needle guard bracket, set with 204657	1
15	5107	323-600-128	screw (large)	1
16	5227	323-600-302	" (small)	1
17	204657	323-639-019	Right looper thread tube	1
18	204781	323-561-013	Overlock needle guard (rear)	1
19	5012	323-600-255	screw	2
20	204782	323-561-014	Overlock needle guard (front)	1
21	5029	323-600-256	screw	2
22	xxxxxx	xxx-xxx-xxx	Double chainstitch needle guard (front)	1
23	5227	323-600-302	screw	1
24	xxxxxx	xxx-xxx-xxx	Double chainstitch needle guard (rear)	1
25	1206	323-600-021	screw (short)	1
26	5010	<u>323-600-010</u>	screw (long)	1
	204988	323-561-018	Eye guard, complete with 204922, 204924, 204925, 2918 & 5099	1
27	204924	323-561-019	Eye guard	1
28	2918	323-600-073	screw	2
29	5099	323-630-009	" nut	2
30	204925	323-615-032	" " washer	1
31	204922	323-728-012	Eye guard hinge	1
32	1170-3	323-600-046	screw	2
33	200821	323-615-013	" washer	2
34	204982	323-505-012	base	1
35	5003	323-600-227	" screw	2
36	5099	323-630-009	" " nut	2
37	167066	323-615-211	" " " washer	2



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## (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
	208568	323-510-089	Needle bar connecting link cover, complete with 208560, 208561 & 208562	1
7	208560	323-510-097	cover	1
8	5117	323-600-057	screw	2
9	208561	323-653-017	oil felt	1
10	208562	323-653-018	" felt	1
11	208563	323-800-062	" " plate	1
12	5291	323-600-313	" " " screw	2
13	5099	323-630-003	" " " " nut	4
14	208427	323-683-018	Needle bar clamp	1
15	1170-3	323-600-046	clamp screw	1
16	204706	323-740-014	Needle thread retainer bracket	1
17	202495	323-850-021	guide spacer	1
18	5359	323-600-091	screw	1
19	200041	323-850-221	guide	1
20	200205	323-640-203	" spring	1
21	9070-2	323-600-224	" screw	1
22	204707	323-851-005	Needle thread guide wire	1
23	202706A	323-866-214	Needle thread takeup	1
24	1186	323-600-246	screw	2
25	204276	323-851-213	Needle thread guide	1
26	208399	323-851-023	Needle thread guide	1
27	4009-1	323-600-014	screw	1
28	xxxxxx	xxx-xxx-xxx	Needle bar, complete	1
29	xxxxxx	xxx-xxx-xxx	Overlock needle	1
30	xxxxxx	xxx-xxx-xxx	Double chainstitch needle	1
31	5292	323-600-341	screw	2
32	204625A	323-676-025	Needle bar bushing (upper)	1
33	204627A	323-676-263	Needle bar bushing (lower)	1
34	208616	323-560-053	dust shield	1
35	5053	323-600-015	" " screw	2
36	208617	323-653-019	oil release felt	1
37	202176	323-653-005	" wick	1
38	208621	323-780-012	Needle bar cap	1
39	200030	323-634-204	'o' ring	1
40	1457	323-600-012	screw	1
41	xxxxxx	xxx-xxx-xxx	Needle plate	1
42	1732	323-600-075	screw	2
43	208491	323-900-047	Overlock needle thread tension, complete (see below for its components) (for 516-4 only)	1
44	208492	323-900-049	Overlock needle thread tension, complete (see below for its components) (for 515-4 only)	1
45	208447	323-630-033	nut	1
46	208448	323-676-047	spring bushing	1
47	201037	323-642-001	spring (for 208491)	1
48	201068	323-642-002	spring (for 208492)	1
49	208450	323-780-010	" cup	1
50	201482	323-613-001	disc	2
51	208449	323-650-001	cushion felt	1
52	5143A	323-604-235	post	1
53	5137	323-630-202	" lock nut	1
54	208307	323-851-024	guide	1
55	208488	323-900-045	Double chainstitch needle thread tension, complete (see below for its components)	1
56	201037	323-642-001	spring (heavy)	1
57	5082A	323-604-201	post	1

208491 consists of 208447, 208448, 201037, 208450, 201482 x 2, 208449 & 5134A

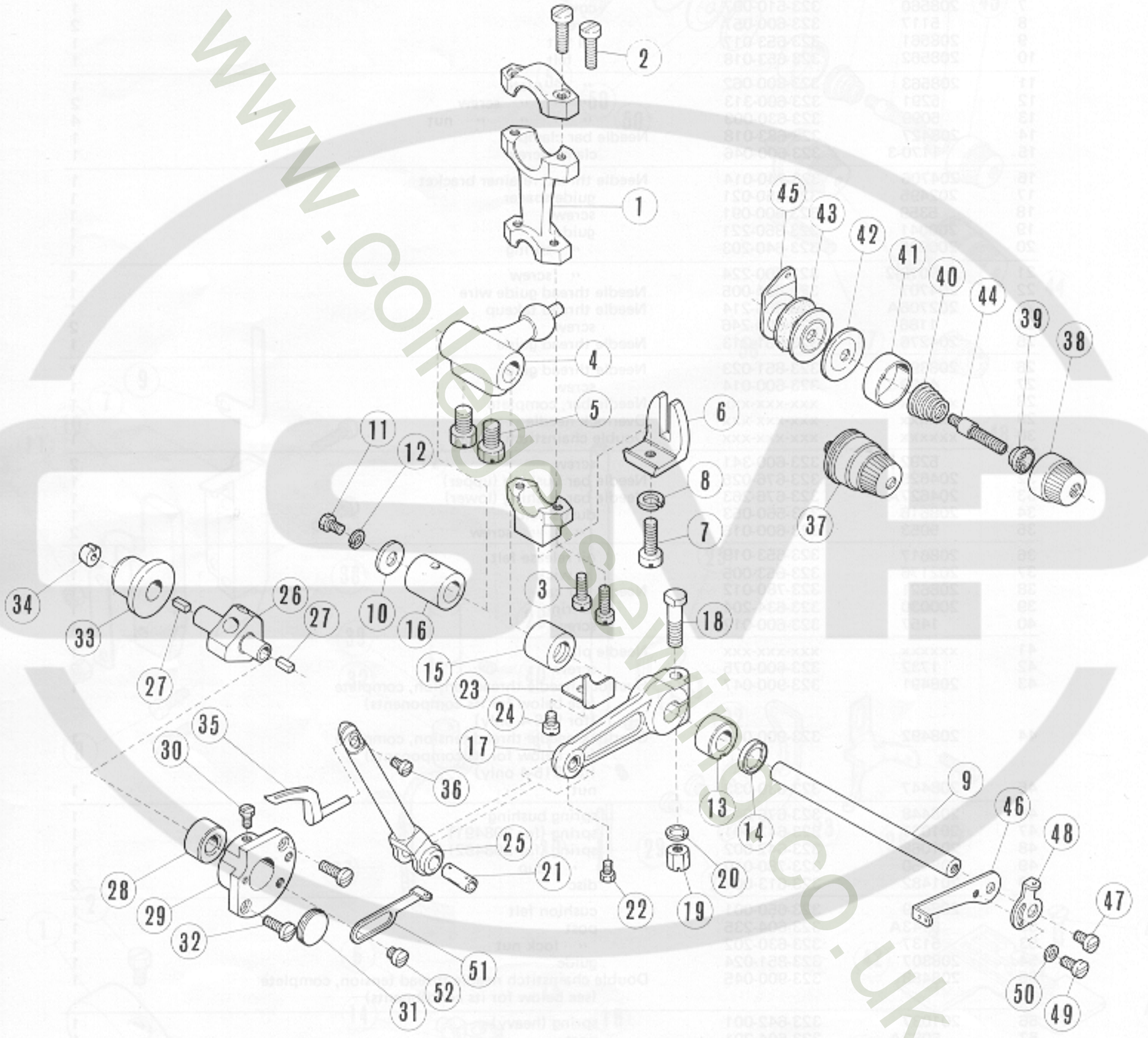
208492 consists of 208447, 208448, 201068, 208450, 201482 x 2, 208449 & 5134A

208488 consists of 208447, 208448, 201037, 208450, 201482 x 2, 208449 & 5082A

(2) NEEDLE DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION
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1	30842A	323-610-017	Needle bar drive crank (left)
2	3022-4	323-600-022	Pin (with head)
3	3022	323-600-043	Pin
4	30842B	323-610-012	Needle bar connecting link
5	30086A	323-610-026	Pin
6	30852	323-600-041	Pin
7	30852B	323-610-028	Needle bar connecting link cover, complete with
8	30852C	323-610-029	Pin
9	30852D	323-610-030	Pin
10	30852E	323-610-031	Pin
11	30852F	323-610-032	Pin
12	30852G	323-610-033	Pin
13	30852H	323-610-034	Pin
14	30852I	323-610-035	Pin
15	30852J	323-610-036	Pin
16	30852K	323-610-037	Pin
17	30852L	323-610-038	Pin
18	30852M	323-610-039	Pin
19	30852N	323-610-040	Pin
20	30852O	323-610-041	Pin
21	30852P	323-610-042	Pin
22	30852Q	323-610-043	Pin
23	30852R	323-610-044	Pin
24	30852S	323-610-045	Pin
25	30852T	323-610-046	Pin
26	30852U	323-610-047	Pin
27	30852V	323-610-048	Pin
28	30852W	323-610-049	Pin
29	30852X	323-610-050	Pin
30	30852Y	323-610-051	Pin
31	30852Z	323-610-052	Pin
32	30853	323-610-053	Pin
33	30853A	323-610-054	Pin
34	30853B	323-610-055	Pin
35	30853C	323-610-056	Pin
36	30853D	323-610-057	Pin
37	30853E	323-610-058	Pin
38	30853F	323-610-059	Pin
39	30853G	323-610-060	Pin
40	30853H	323-610-061	Pin
41	30853I	323-610-062	Pin
42	30853J	323-610-063	Pin
43	30853K	323-610-064	Pin
44	30853L	323-610-065	Pin
45	30853M	323-610-066	Pin
46	30853N	323-610-067	Pin
47	30853O	323-610-068	Pin
48	30853P	323-610-069	Pin
49	30853Q	323-610-070	Pin
50	30853R	323-610-071	Pin
51	30853S	323-610-072	Pin
52	30853T	323-610-073	Pin

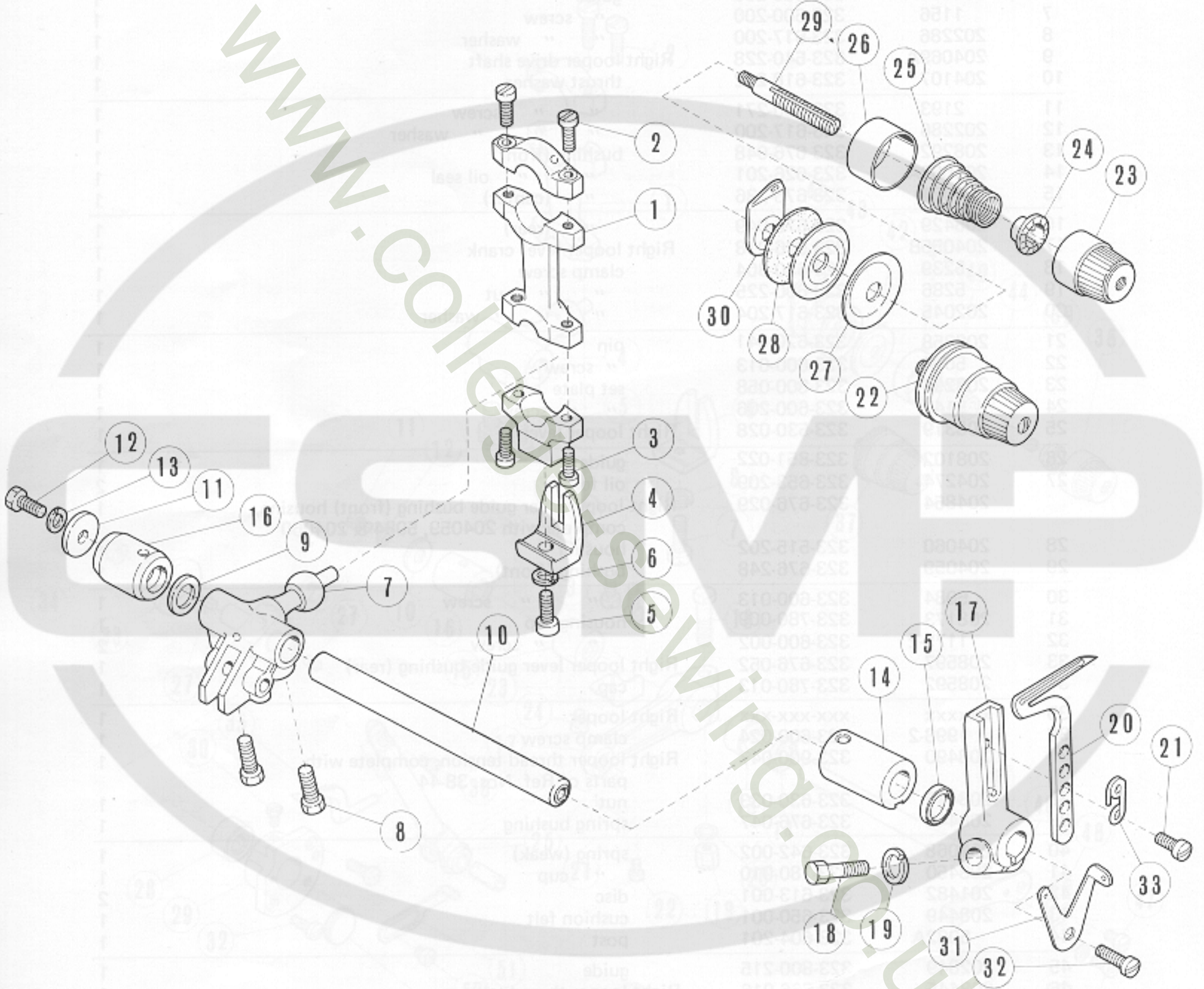


## RIGHT LOOPER DRIVE MECHANISM

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	crank	1
5	2022-4	323-600-022	" screw	2
6	201074A	323-850-200	guide	1
7	1156	323-600-200	" screw	1
8	202286	323-617-200	" " washer	1
9	204069A	323-540-228	Right looper drive shaft	1
10	204107	323-618-212	thrust washer	1
11	2193	323-600-271	" " screw	1
12	202286	323-617-200	" " " washer	1
13	208292	323-676-048	bushing (front)	1
14	204052A	323-626-201	" " oil seal	1
15	204081	323-676-236	" (center)	1
16	208429	323-676-049	" (rear)	1
17	204055B	323-576-018	Right looper lever crank	1
18	5239	323-630-304	clamp screw	1
19	5286	323-600-225	" " nut	1
20	202045	323-617-204	" " " washer	1
21	208258	323-620-041	pin	1
22	5084	323-600-013	" screw	1
23	208296	323-800-058	set plate	1
24	5147	323-600-206	" " screw	1
25	208319	323-530-028	Right looper lever	1
26	208102	323-851-022	guide	1
27	204274	323-653-209	oil felt	2
28	204854	323-676-029	Right looper lever guide bushing (front) housing, complete with 204059, 5084 & 204060	1
29	204060	323-515-202	housing	1
30	204059	323-676-248	bushing (front)	1
31	5084	323-600-013	" " 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	xxx-xxx-xxx	Right looper	1
37	1998-2	323-600-024	clamp screw	1
38	208490	323-900-047	Right looper thread tension, complete with parts of Ref. Nos. 38-44	1
39	208447	323-630-033	nut	1
40	208448	323-676-047	spring bushing	1
41	201068	323-642-002	spring (weak)	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	2902	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

RIGHT LOOPER DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION
1	208346	323-828-013	Right looper drive connection
2	2213-1	323-800-088	cap screw (large)
3	1170-1	323-800-020	" (small)
4	204084A	323-828-213	crank
5	2023-4	323-800-023	" screw
6	201074A	323-828-200	guide
7	1188	323-828-200	" screw
8	202288	323-828-200	" washer
9	204084B	323-828-213	Right looper drive shaft
10	20410	323-828-213	Right looper drive shaft
11	2182	323-828-200	Right looper drive shaft
12	202288	323-828-200	" washer
13	204084B	323-828-213	Right looper drive shaft
14	204084B	323-828-213	Right looper drive shaft
15	204084B	323-828-213	Right looper drive shaft
16	204084B	323-828-213	Right looper drive shaft
17	204084B	323-828-213	Right looper drive shaft
18	204084B	323-828-213	Right looper drive shaft
19	204084B	323-828-213	Right looper drive shaft
20	204084B	323-828-213	Right looper drive shaft
21	204084B	323-828-213	Right looper drive shaft
22	204084B	323-828-213	Right looper drive shaft
23	204084B	323-828-213	Right looper drive shaft
24	204084B	323-828-213	Right looper drive shaft
25	204084B	323-828-213	Right looper drive shaft
26	204084B	323-828-213	Right looper drive shaft
27	204084B	323-828-213	Right looper drive shaft
28	204084B	323-828-213	Right looper drive shaft
29	204084B	323-828-213	Right looper drive shaft
30	204084B	323-828-213	Right looper drive shaft
31	204084B	323-828-213	Right looper drive shaft
32	204084B	323-828-213	Right looper drive shaft
33	204084B	323-828-213	Right looper drive shaft



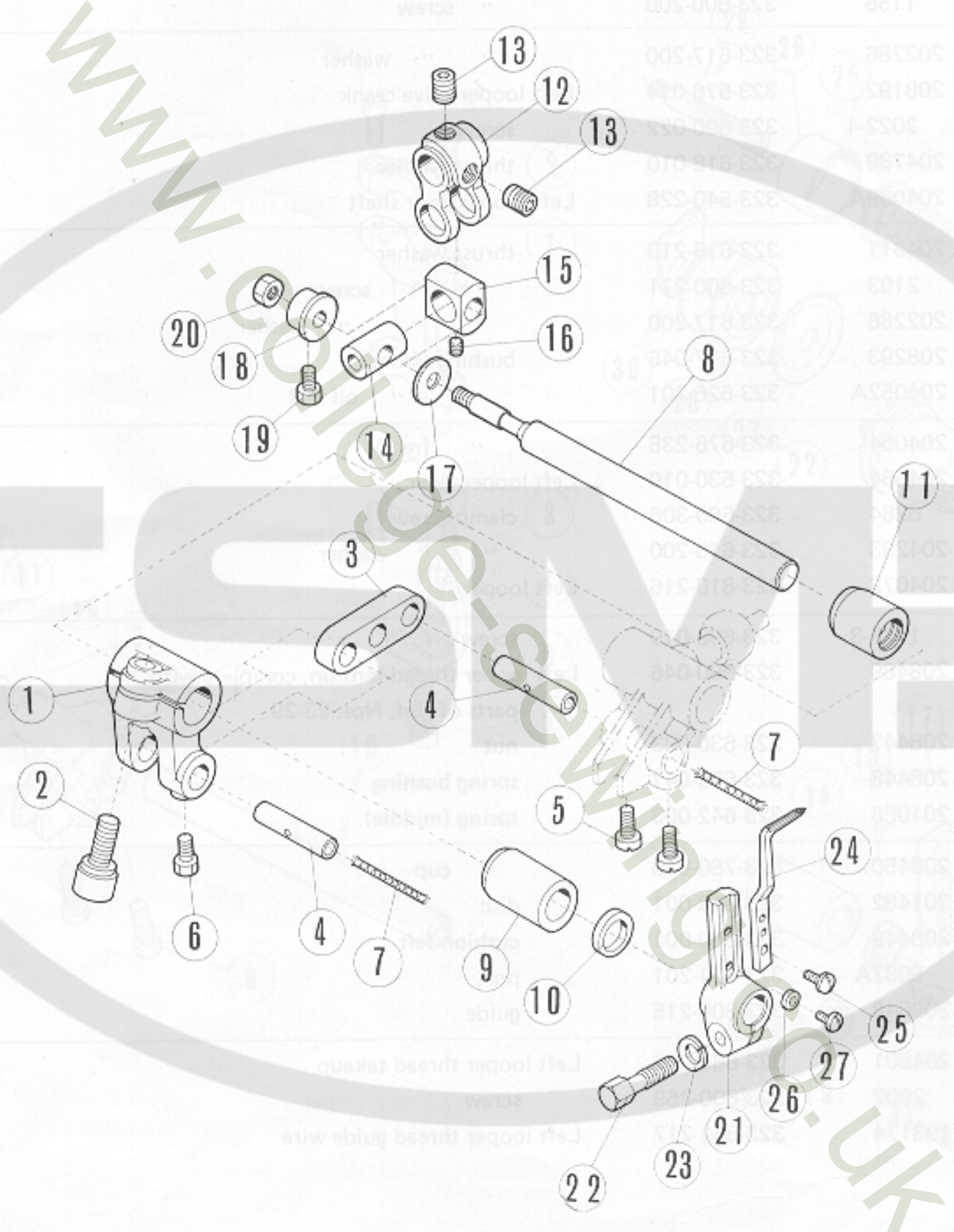


(1) DOU LEFT LOOPER DRIVE MECHANISM MECHANISM

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	208192	323-576-014	Left looper drive crank	1
8	2022-4	323-600-022	screw	2
9	204789	323-618-010	thrust washer	1
10	204069A	323-540-228	Left looper lever shaft	1
11	204311	323-618-210	thrust washer	1
12	2193	323-600-271	" " screw	1
13	202286	323-617-200	" " " washer	1
14	208293	323-677-046	bushing (front)	1
15	204052A	323-626-201	" " oil seal	1
16	204054	323-676-235	" (rear)	1
17	204664	323-530-010	Left looper lever	1
18	5284	323-600-306	clamp screw	1
19	204293	323-616-200	" " washer	1
20	204072	323-810-216	Left looper	1
21	1175-3	323-600-019	screw	1
22	208489	323-900-046	Left looper thread tension, complete with parts of Ref. Nos. 23-29	1
23	208447	323-630-033	nut	1
24	208448	323-676-047	spring bushing	1
25	201086	323-642-003	spring (middle)	1
26	208450	323-780-010	" cup	1
27	201482	323-613-001	disc	2
28	208449	323-650-001	cushion felt	1
29	5082A	323-604-201	post	1
30	202849	323-800-215	guide	1
31	204901	323-866-012	Left looper thread takeup	1
32	2902	323-600-259	screw	1
33	193174	323-851-217	Left looper thread guide wire	1

LEFT LOOPER DRIVE MECHANISM

QTY	DESCRIPTION	NEW PRODUCT CODE NO.	PART NO.	REF. NO.
1	Left looper drive connection	323-828-013	208348	1
2	cap screw (large)	323-800-056	2213-1	2
2	" (small)	323-800-020	1170-1	3
1	guide	323-880-200	201074A	4
1	" screw	323-800-200	1188	5

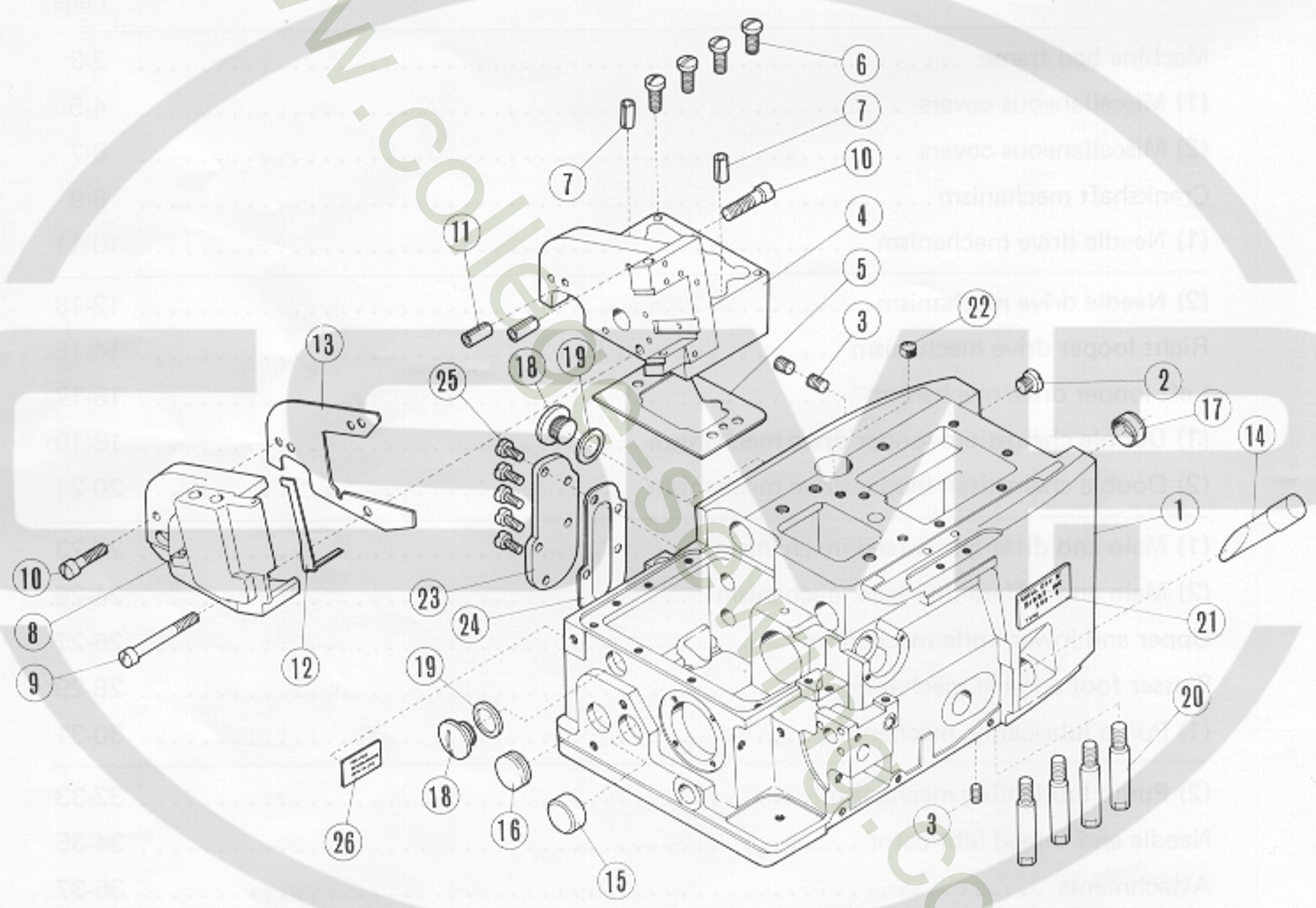


(1) DOUBLE CHAINSTITCH LOOPER DRIVE MECHANISM

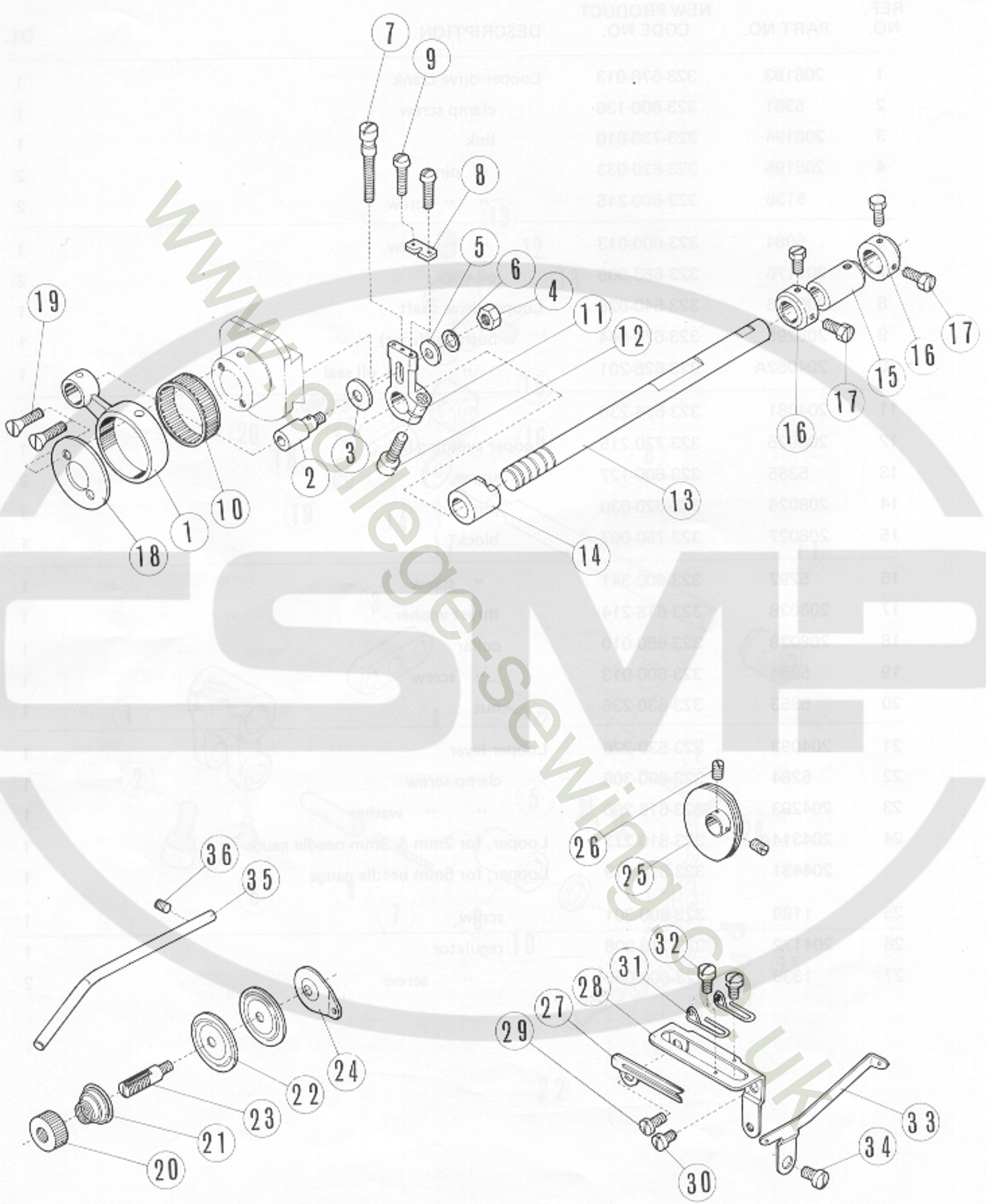
REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208193	323-576-013	Looper drive crank	1
2	5381	323-600-136	clamp screw	1
3	208194	323-730-010	link	1
4	208195	323-620-033	" pin	2
5	5136	323-600-245	" " screw	2
6	5084	323-600-013	" " screw	1
7	202176	323-653-005	oil wick	2
8	208196	323-540-028	Looper drive shaft	1
9	208295	323-676-044	bushing (front)	1
10	204052A	323-626-201	" " oil seal	1
11	204081	323-676-236	" (rear)	1
12	208025	323-730-215	Looper avoiding link	1
13	5385	323-600-127	screw	2
14	208026	323-620-030	pin	1
15	208027	323-750-007	block	1
16	5292	323-600-341	" screw	1
17	208028	323-618-214	thrust washer	1
18	208029	323-680-010	collar	1
19	5084	323-600-013	" screw	1
20	5353	323-630-236	nut	1
21	204093	323-530-226	Looper lever	1
22	5284	323-600-306	clamp screw	1
23	204293	323-616-200	" " washer	1
24	204314A	323-810-217	Looper, for 2mm & 3mm needle gauge	1
	204431	323-810-219	Looper, for 5mm needle gauge	1
25	1189	323-600-301	screw	1
26	204172	323-716-208	regulator	1
27	1333	323-600-048	" screw	2

TABLE OF CONTENTS

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(1) DOUBLE CHAINSTITCH LOOPER DRIVE MECHANISM



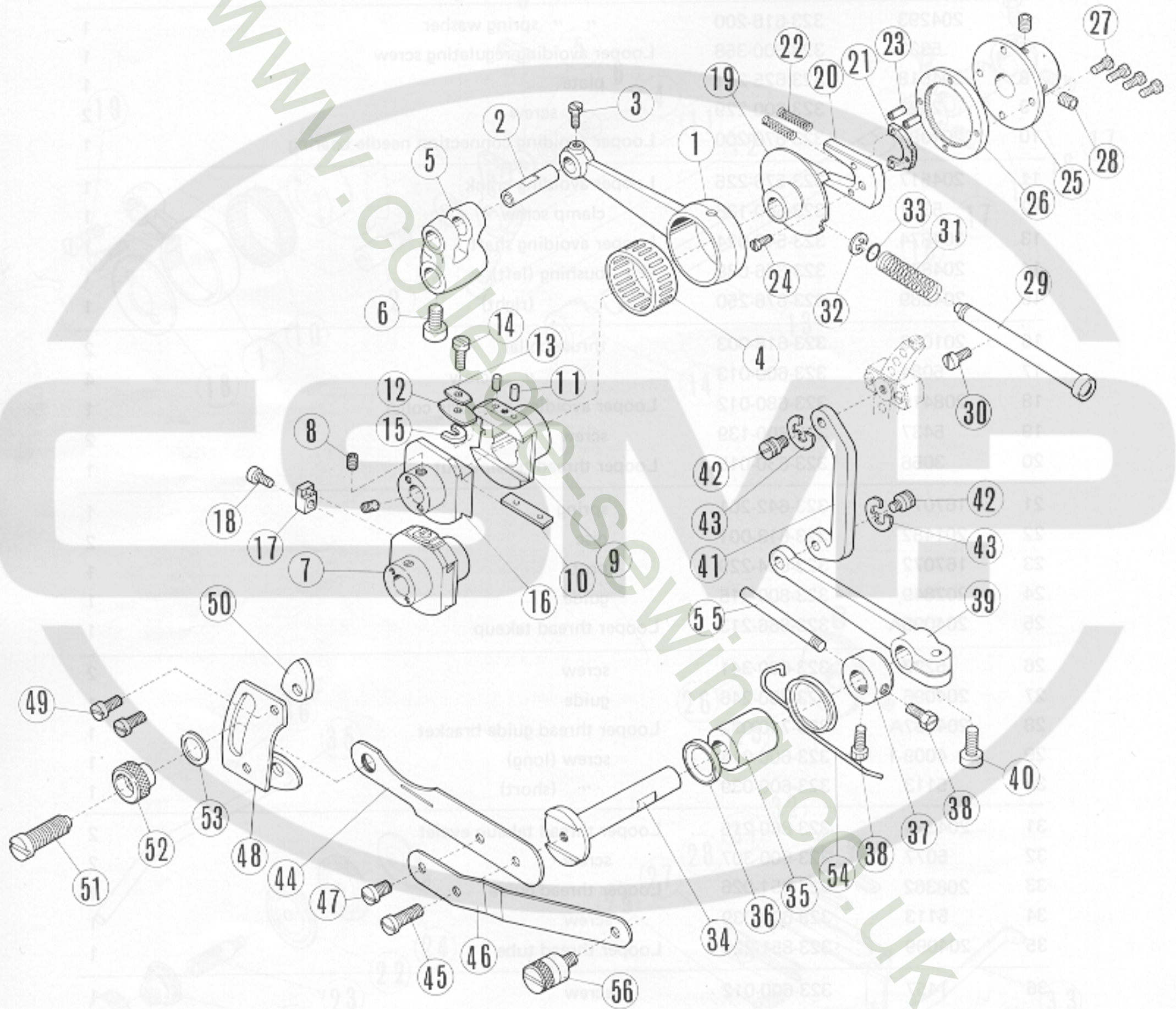
## (2) DOUBLE CHAINSTITCH LOOPER DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204082A	323-525-239	Looper avoiding connection	1
2	208097	323-620-032	pin	1
3	204520	323-615-233	" washer	1
4	5104	325-630-002	" nut	1
5	202433	323-615-027	" " washer	1
6	204293	323-616-200	" " spring washer	1
7	5333	323-600-358	Looper avoiding regulating screw	1
8	204518	323-625-201	plate	1
9	2922	323-600-229	" screw	2
10	204084	323-676-200	Looper avoiding connection needle bearing	1
11	204517	323-576-225	Looper avoiding crank	1
12	5381	323-600-136	clamp screw	1
13	204874	323-540-024	Looper avoiding shaft	1
14	204875	323-676-038	bushing (left)	1
15	204089	323-676-250	" (right)	1
16	201056	323-618-003	thrust collar	2
17	5084	323-600-013	" " screw	4
18	208419	323-680-012	Looper avoiding eccentric collar	1
19	5437	323-600-139	screw	2
20	3056	323-630-015	Looper thread tension nut	1
21	167077	323-642-201	spring	1
22	201482	323-613-001	disc	2
23	167072	323-604-229	post	1
24	202849	323-800-215	guide	1
25	204095A	323-866-213	Looper thread takeup	1
26	5292	323-600-341	screw	2
27	204096	323-850-246	guide	1
28	204097A	323-740-032	Looper thread guide bracket	1
29	4009-1	323-600-014	screw (long)	1
30	5113	323-600-039	" (short)	1
31	204324	323-860-215	Looper thread takeup eyelet	2
32	5077	323-600-307	screw	2
33	208362	323-851-026	Looper thread guide	1
34	5113	323-600-039	screw	1
35	204099	323-851-220	Looper thread tube	1
36	1457	323-600-012	screw	1
48	204142B	323-800-036	" guide	1
49	5118	323-600-080	" 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	204758	323-640-006	Differential feed regulating spring	1
55	204757	323-600-102	latch screw	1
56	204868	323-600-107	Knee controller chain hook latch screw	1

(2) DOUBLE CHAINSTITCH LOOPER DRIVE MECHANISM

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

1	Looper avoiding connection	323 828-239	204082A	1
2	pin	323 620-032	208097	2
3	washer	323 618-233	204520	3
4	nut	323 630-002	6104	4
5	washer	323 618-027	202433	5



## (1) MAIN AND DIFFERENTIAL FEED 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
6	5381	323-600-136	clamp screw	1
7	208277	323-580-083	Feed & looper eccentric, complete (includes parts of Ref. Nos. 9-18 except 208409)	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	208278	MFG only	double chainstitch looper eccentric	1
17	208330	323-625-002	feed eccentric stopper	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 (includes parts of Ref. Nos. 20-24)	1
20	208413	MFG only	position gear bracket	1
21	208412	MFG only	position 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 (includes parts of Ref. Nos. 25-27)	1
25	208418	MFG only	internal gear bracket	1
26	208417	MFG only	internal 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	" 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



(1) MAIN AND DIFFERENTIAL FEED MECHANISM

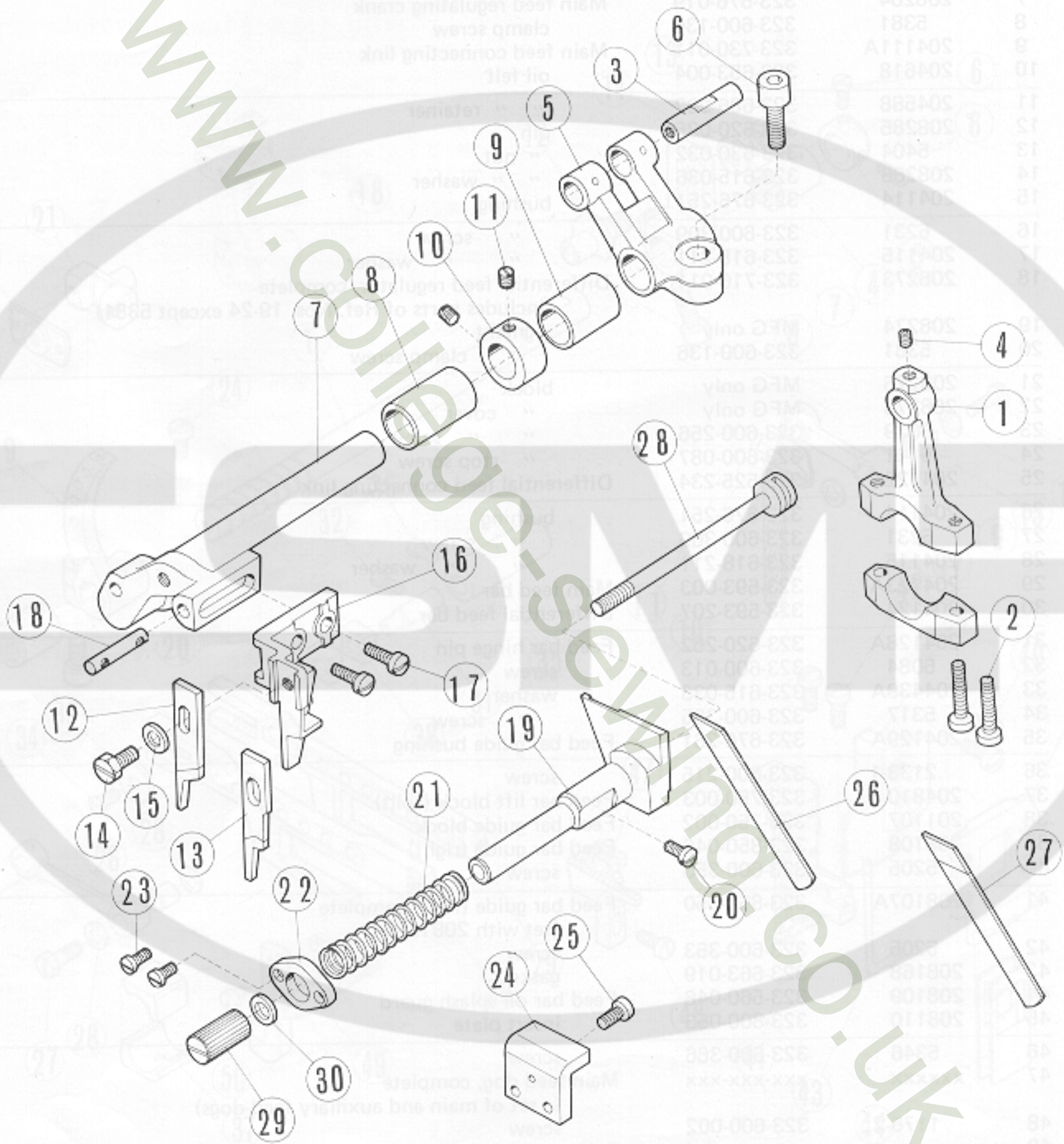
REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION
1	304100	323-828-232	Feed drive connection
2	202486	323-820-040	pin
3	8084	323-800-013	screw
4	204084	323-822-200	needle bearing
5	204086	323-828-220	Feed drive crank
6	8281	323-800-138	clamp screw
7	208217	323-880-083	Feed & looper eccentric complete (includes parts of Ref. Nos. 8-18 except 10)
8	8212	323-800-282	screw
9	208219	323-787-025	lead eccentric
10	208219	323-787-025	MRG only
11	208219	323-787-025	MRG only
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35	208219	323-787-025	MRG only
36	208219	323-787-025	MRG only
37	208219	323-787-025	MRG only
38	208219	323-787-025	MRG only
39	208219	323-787-025	MRG only
40	208219	323-787-025	MRG only
41	208219	323-787-025	MRG only
42	208219	323-787-025	MRG only
43	208219	323-787-025	MRG only
44	208219	323-787-025	MRG only
45	208219	323-787-025	MRG only
46	208219	323-787-025	MRG only
47	208219	323-787-025	MRG only
48	208219	323-787-025	MRG only
49	208219	323-787-025	MRG only
50	208219	323-787-025	MRG only
51	8214	323-800-083	adjust screw
52	208870	323-830-012	nut
53	202888	323-818-209	washer
54	204758	323-840-008	Differential feed regulating spring
55	204757	323-800-102	latch screw
56	204850	323-800-107	Knee controller chain hook latch screw

## (2) MAIN AND DIFFERENTIAL FEED 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 (includes parts of Ref. Nos. 19-24 except 5381)	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	Feed bar 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), complete (set with 208168)	1
42	5205	323-600-353	screw	2
43	208168	323-663-019	gasket	1
44	208109	323-560-046	Feed bar oil splash guard	1
45	208110	323-800-053	insert plate	1
46	5346	323-600-366	screw	4
47	xxxxxx	xxx-xxx-xxx	Main feed dog, complete (a set of main and auxiliary feed dogs)	1
48	1175-2	323-600-002	screw	1
49	xxxxxx	xxx-xxx-xxx	Differential feed dog	1
50	1175-3	323-600-019	screw (for 2:1 diff. feed dog)	1
	1189	323-600-301	screw (for 3:1 diff. feed dog)	1

(2) MAIN AND DIFFERENTIAL FEED MECHANISM

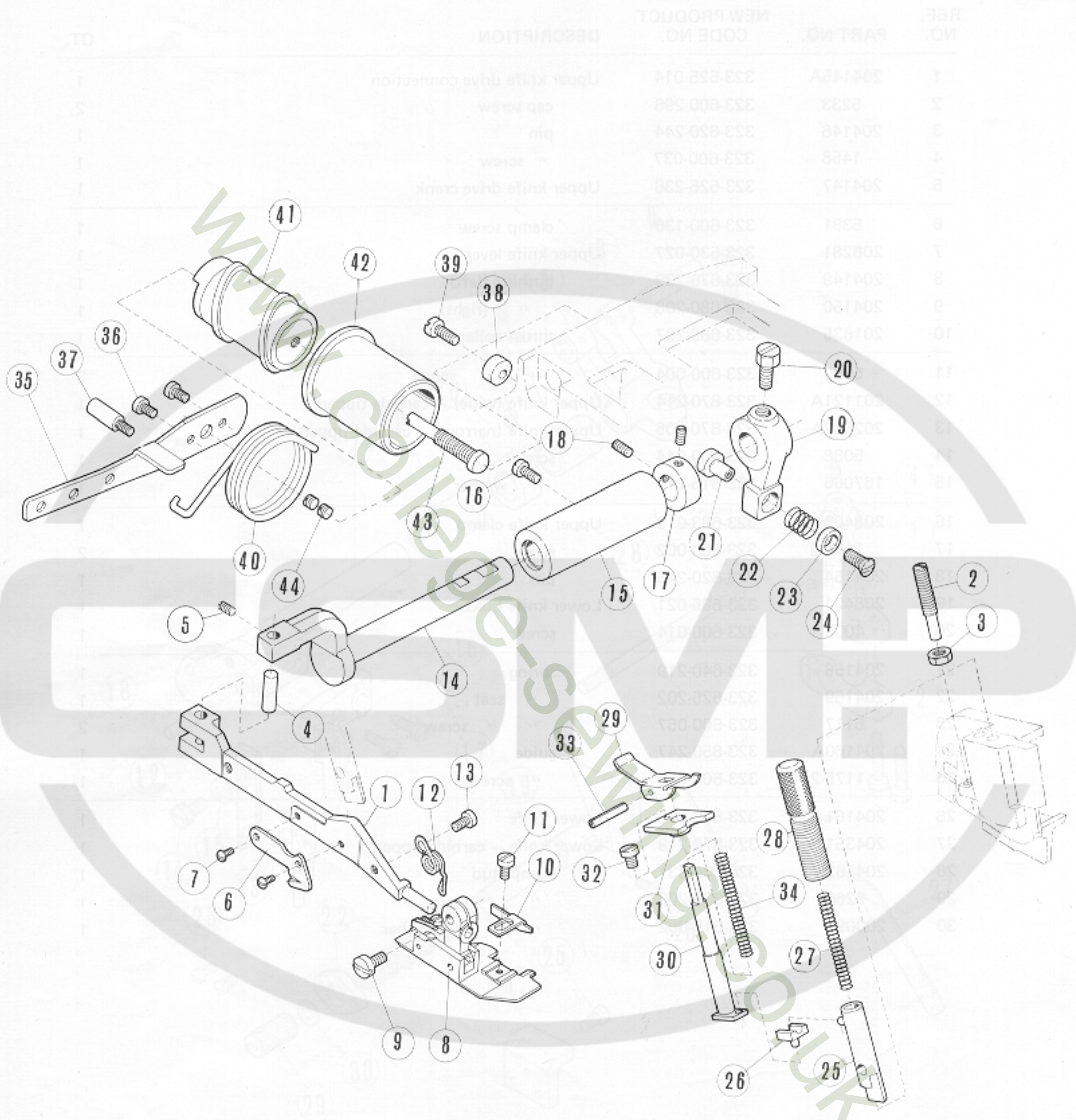
REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QTY.
1	204751	323-640-018	Feed bar shaft	1
2	204107	323-618-212	thrust washer	1
3	4009-1	323-600-014	" " screw	1
4	204084	323-616-236	pushing	1
5	201086	323-618-003	thrust collar	1
6	5084	323-600-013	" " screw	1
7	208284	323-616-018	Main feed regulating crank	1
8	5381	323-600-010	clamp screw	1
9	204111A	323-730-004	Main feed connecting link	1
10	204818	323-616-004	oil felt	1
11	204588	323-616-004	oil felt	1
12	208286	323-616-004	oil felt	1
13	5404	323-616-004	oil felt	1
14	208286	323-616-004	oil felt	1
15	204111	323-616-004	oil felt	1
16	5381	323-600-010	clamp screw	1
17	204111	323-616-004	oil felt	1
18	208286	323-616-004	oil felt	1
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2	208286	323-616-004	oil felt	1
3	208286	323-616-004	oil felt	1
4	208286	323-616-004	oil felt	1



## UPPER AND LOWER KNIFE 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	208281	323-530-027	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 collar	1
11	5060	323-600-004	" " screw	2
12	201121A	323-870-214	Upper knife (wide) – carbide tipped	1
13	202527A	323-870-005	Upper knife (narrow) – carbide tipped	1
14	5088	323-600-044	screw	1
15	167066	323-615-211	" washer	1
16	208402	323-683-019	Upper knife clamp	1
17	1175-2	323-600-002	screw	2
18	204154	323-620-245	pin	1
19	208404	323-685-021	Lower knife holder	1
20	4009-1	323-600-014	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	guide	1
25	1175-2	323-600-002	" screw	1
26	204161	323-870-213	Lower knife	1
27	204351	323-870-218	Lower knife – carbide tipped	1
28	204162	323-600-331	clamp stud	1
29	5260	323-630-203	" " nut	1
30	200098	323-615-002	" " " washer	1
41	204163	323-600-002	Foot knife clamp	1
42	204164	323-600-002	bushing	1
43	204165	323-600-002	regulating screw stud	1
44	204166	323-600-002	clamp	2

UPPER AND LOWER KNIFE MECHANISM



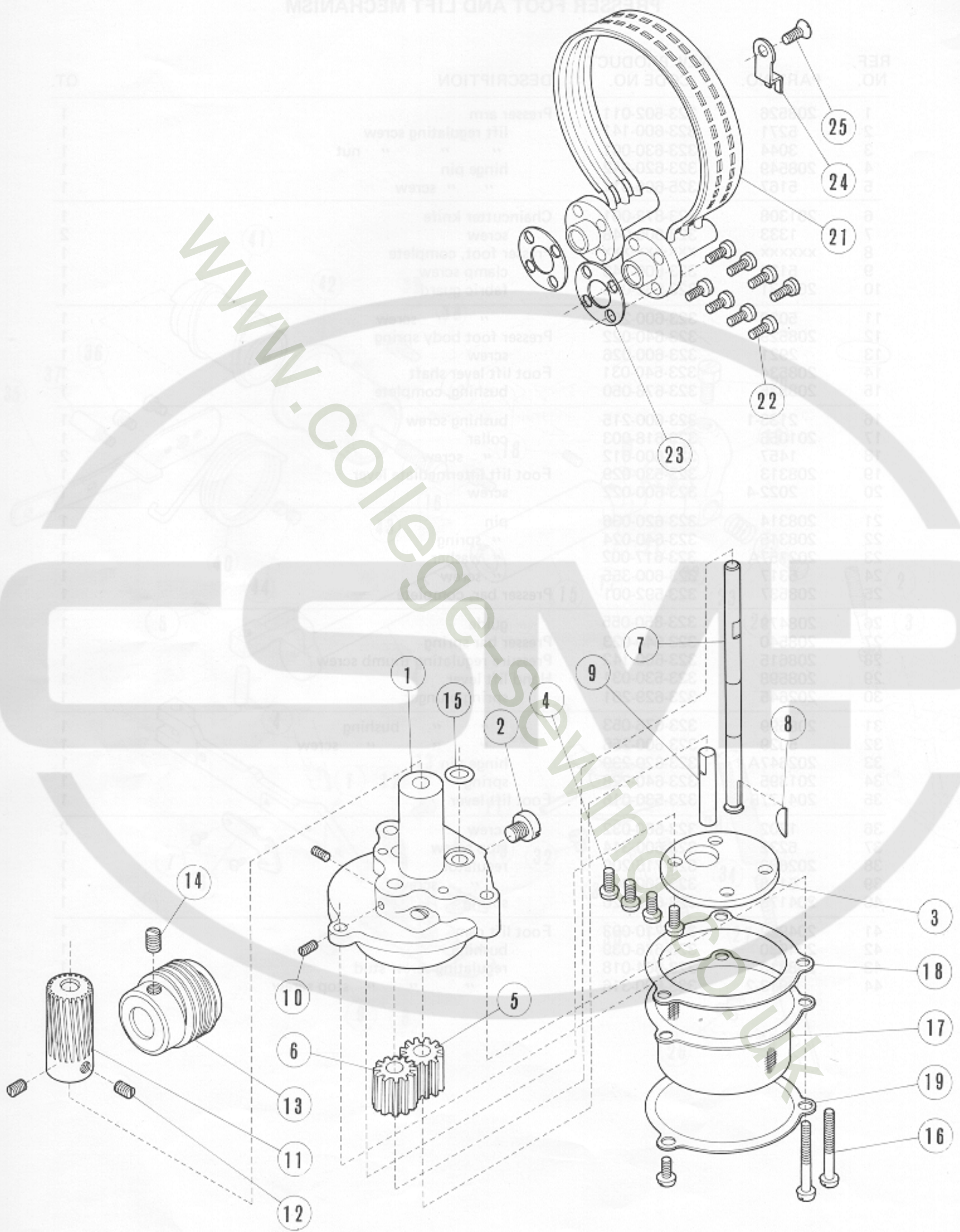
## PRESSER FOOT AND LIFT MECHANISM

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	xxxxxx	xxx-xxx-xxx	Presser foot, complete	1
9	5136	323-600-245	clamp screw	1
10	208531	323-560-045	fabric guard	1
11	5030	323-600-202	" " screw	1
12	208529	323-640-022	Presser foot body spring	1
13	2921	323-600-026	screw	1
14	208534	323-540-031	Foot lift lever shaft	1
15	208535	323-676-050	bushing, complete	1
16	2133-1	323-600-215	bushing screw	1
17	201056	323-618-003	collar	1
18	1457	323-600-012	" screw	2
19	208313	323-530-029	Foot lift intermediate lever	1
20	2022-4	323-600-022	screw	1
21	208314	323-620-036	pin	1
22	208315	323-640-024	" spring	1
23	202757A	323-617-002	" washer	1
24	5317	323-600-355	" screw	1
25	208537	323-592-001	Presser bar, complete	1
26	208479	323-850-055	guide	1
27	208540	323-640-023	Presser bar spring	1
28	208615	323-600-142	Pressure regulating thumb screw	1
29	208598	323-530-031	Hand lift lever	1
30	202645	323-629-201	spring plunger	1
31	208599	323-676-053	" " bushing	1
32	5029	323-600-256	" " " screw	1
33	202647A	323-620-239	hinge pin	1
34	201395	323-640-228	spring	1
35	204177B	323-530-016	Foot lift lever	1
36	1202	323-600-032	screw	2
37	5232	323-600-314	stop screw	1
38	202683	323-716-209	regulator	1
39	5118	323-600-060	" screw	1
40	204178	323-640-220	spring	1
41	204929	323-710-003	Foot lift cam	1
42	204930	323-676-039	bushing	1
43	208316	323-604-018	regulating screw stud	1
44	2913-2	323-600-316	" " " stop screw	2

## MACHINE BED FRAME

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208600	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	4
7	201002	323-620-001	dowel pin	1
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	205088	323-627-014	Looper avoiding shaft (left) cap	1
16	208173	323-780-009	Dead hole plug	1
17	204828	323-627-010	" " plug	1
18	5179	323-600-329	" " " screw (small)	2
19	201006	323-615-001	" " " " " washer	2
20	204006	323-620-242	Machine bed bottom pin	4
21	208406	323-692-033	Type plate blank – 515-4	1
22	204794A	323-655-007	Machine bed oil filter	1
23	208289	323-800-056	Machine bed cover plate (back)	1
24	208290	323-663-020	gasket	1
25	5117	323-600-057	screw	5
26	202526	323-692-201	Manufacture's name plate	1

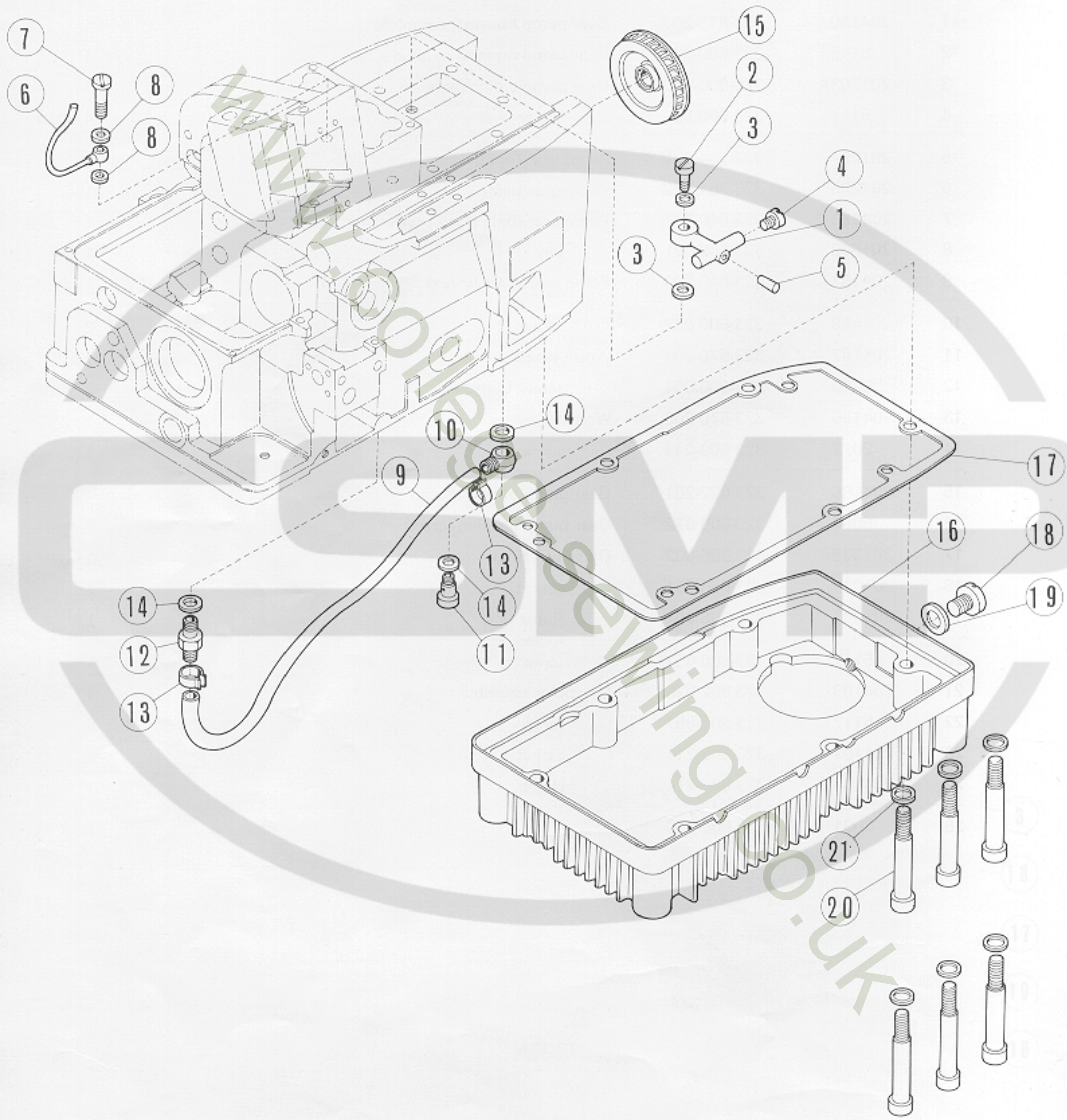
PRESSER FOOT AND LIFT MECHANISM





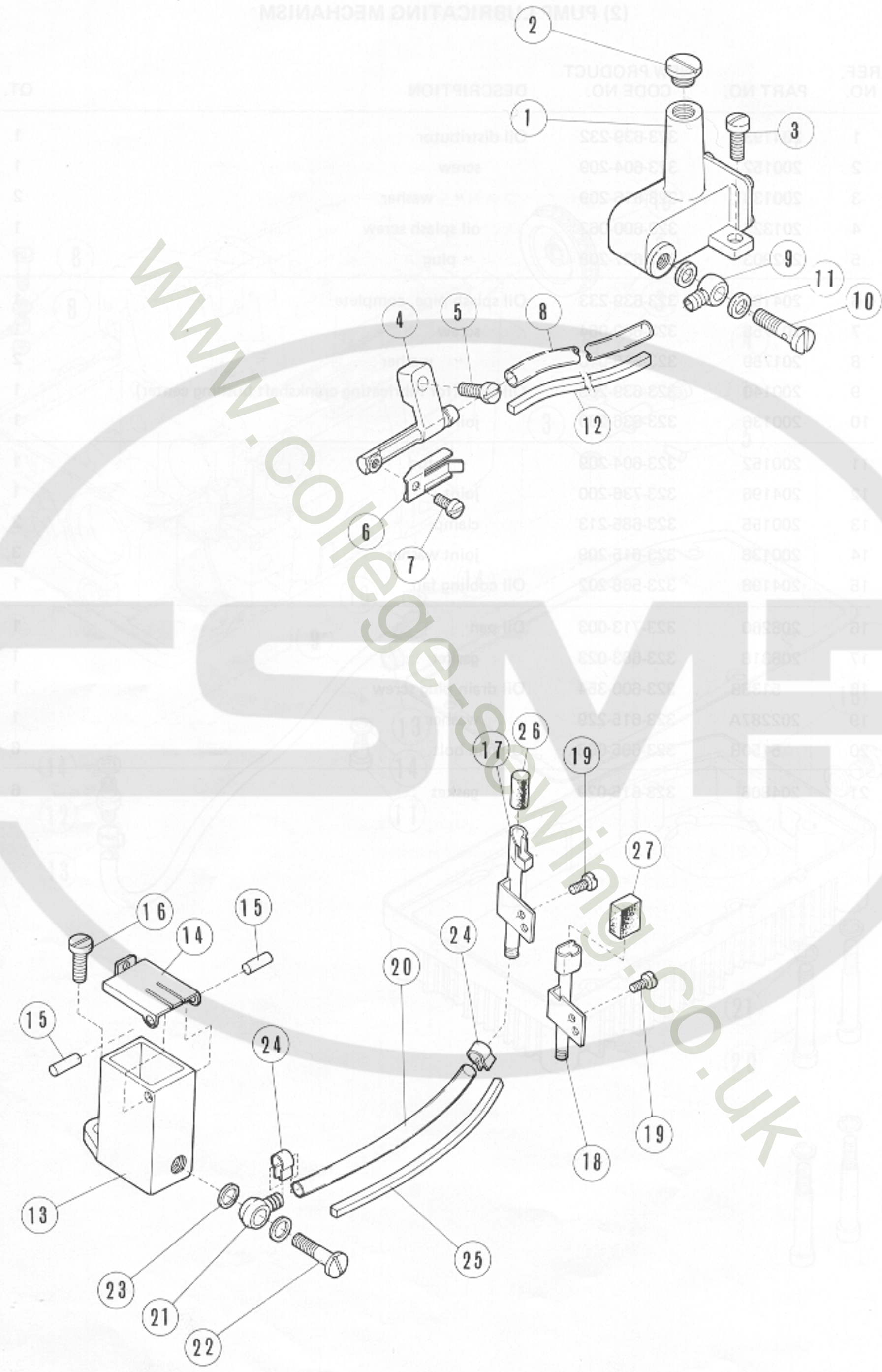
(1) PUMP LUBRICATING MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204593	323-900-012	Gear pump, complete	1
2	200162	323-604-208	(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



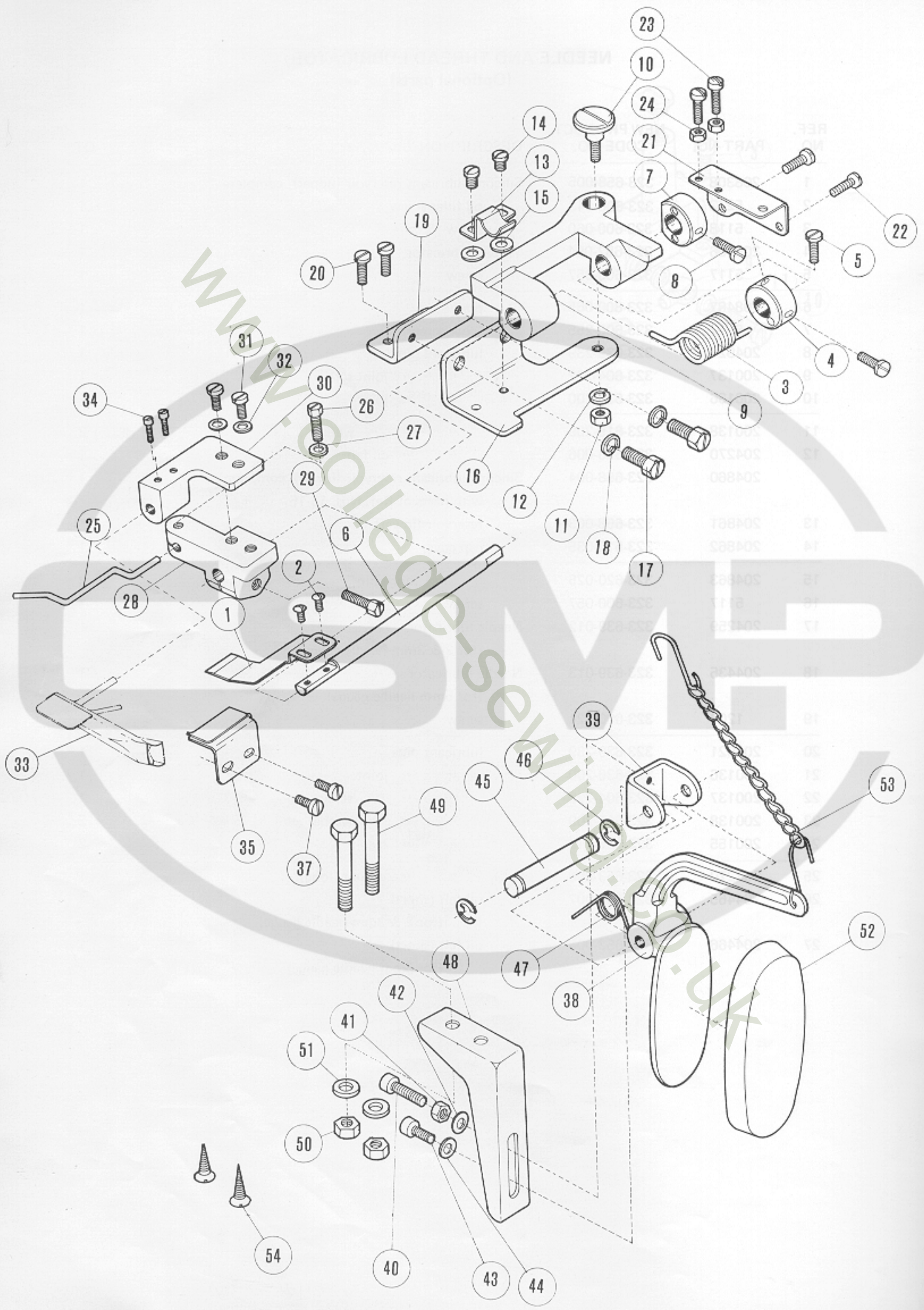
(2) PUMP LUBRICATING MECHANISM

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	5138B	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	208486	323-652-004	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
13	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	204259	323-639-012	Needle lubricator (for 2 & 3mm needle gauge)	1
18	204435	323-639-013	Needle lubricator (for 5mm needle gauge)	1
19	1206	323-600-021	screw	1
20	204921	323-639-239	lubricant pipe	1
21	200136	323-636-200	" " joint	1
22	200137	323-604-222	" " " screw	1
23	200138	323-615-209	" " " washer	2
24	200155	323-685-213	" " clamp	2
25	204270	323-653-006	" " oil felt (long)	1
26	204465	323-653-007	oil felt (short) (for 2 & 3mm needle gauge)	1
27	204466	323-653-008	oil felt (short) (for 5mm needle gauge)	1
44	13114	323-615-012	" " " washer	1
45	181	323-620-188	pin	1
46	20222	323-634-200	oil filler screw	2
47	196	323-640-100	oil filler screw	1
48	197	323-605-100	oil filler screw	1
49	5347	323-605-003	screw	2
50	5348	323-630-013	" " " screw	2
51	204986	323-615-021	" " " washer	2
52	198	323-685-001	clamp	1
53	189	323-732-002	oil filler screw	1
54	5341	323-600-101	oil filler screw	2

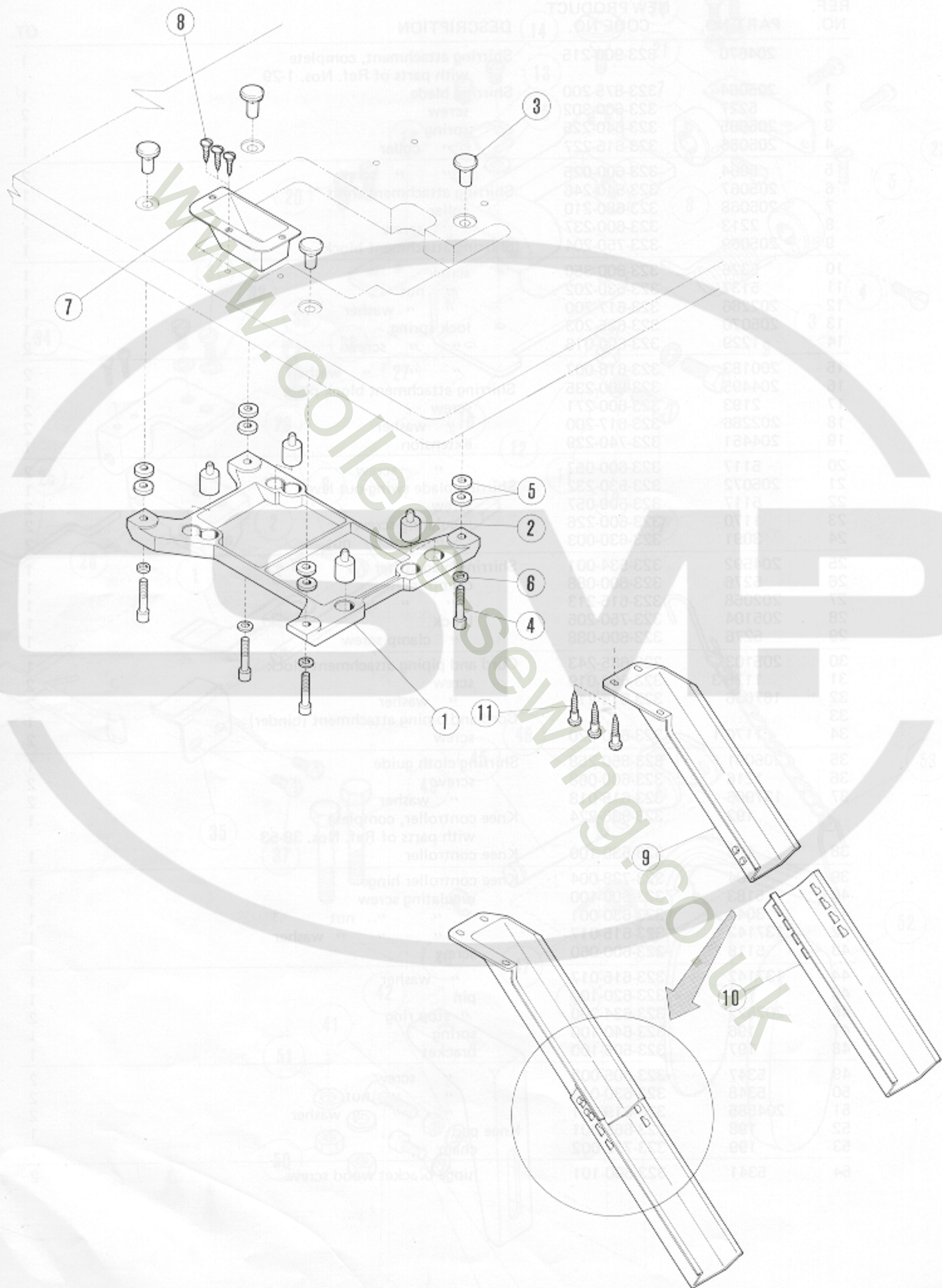


ACCESSORIES FOR SHIRTING INSTALLATION

ATTACHMENTS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
	204670	323-900-215	Shirring attachment, complete with parts of Ref. Nos. 1-29	1
1	205064	323-875-200	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

ATTACHMENTS



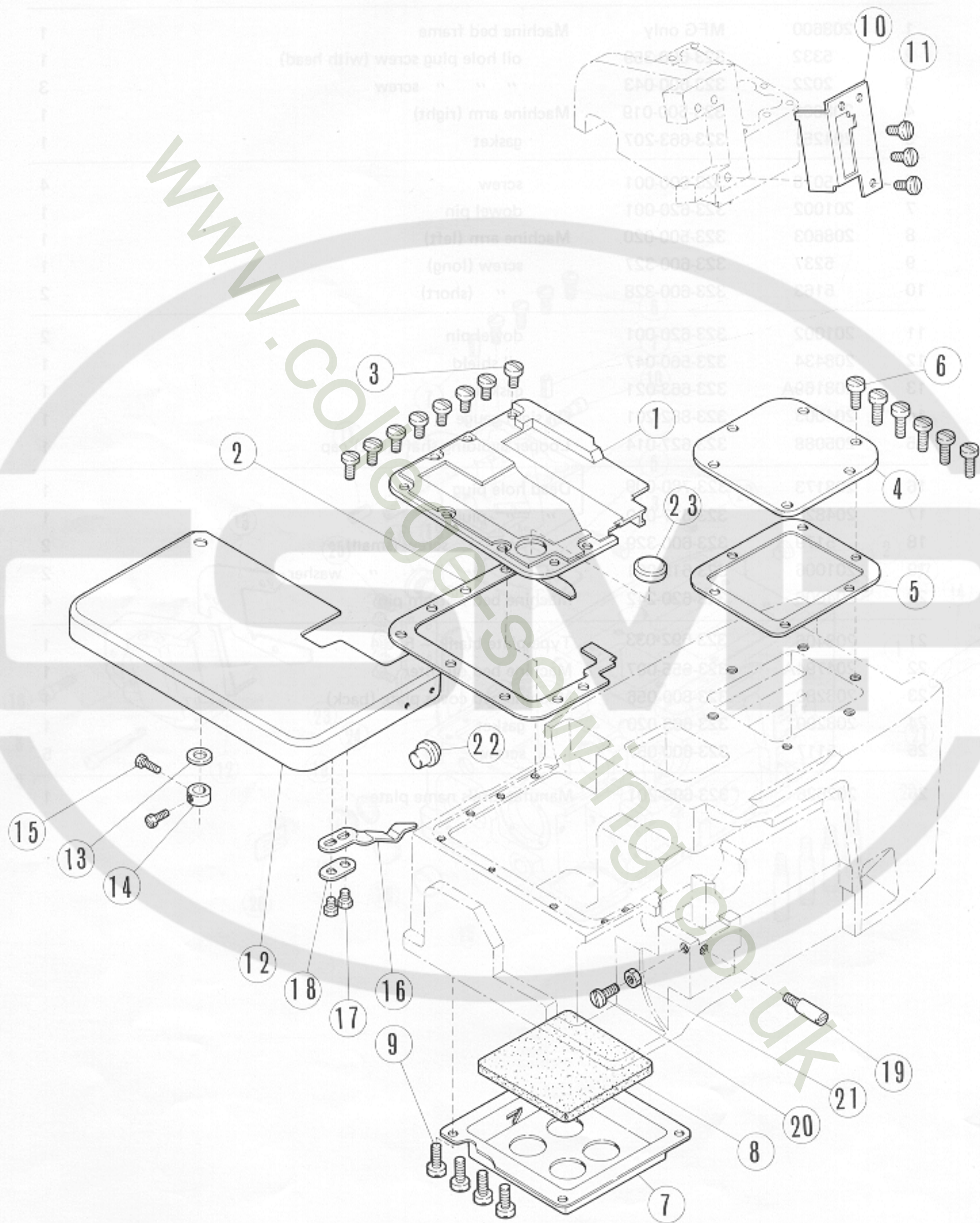


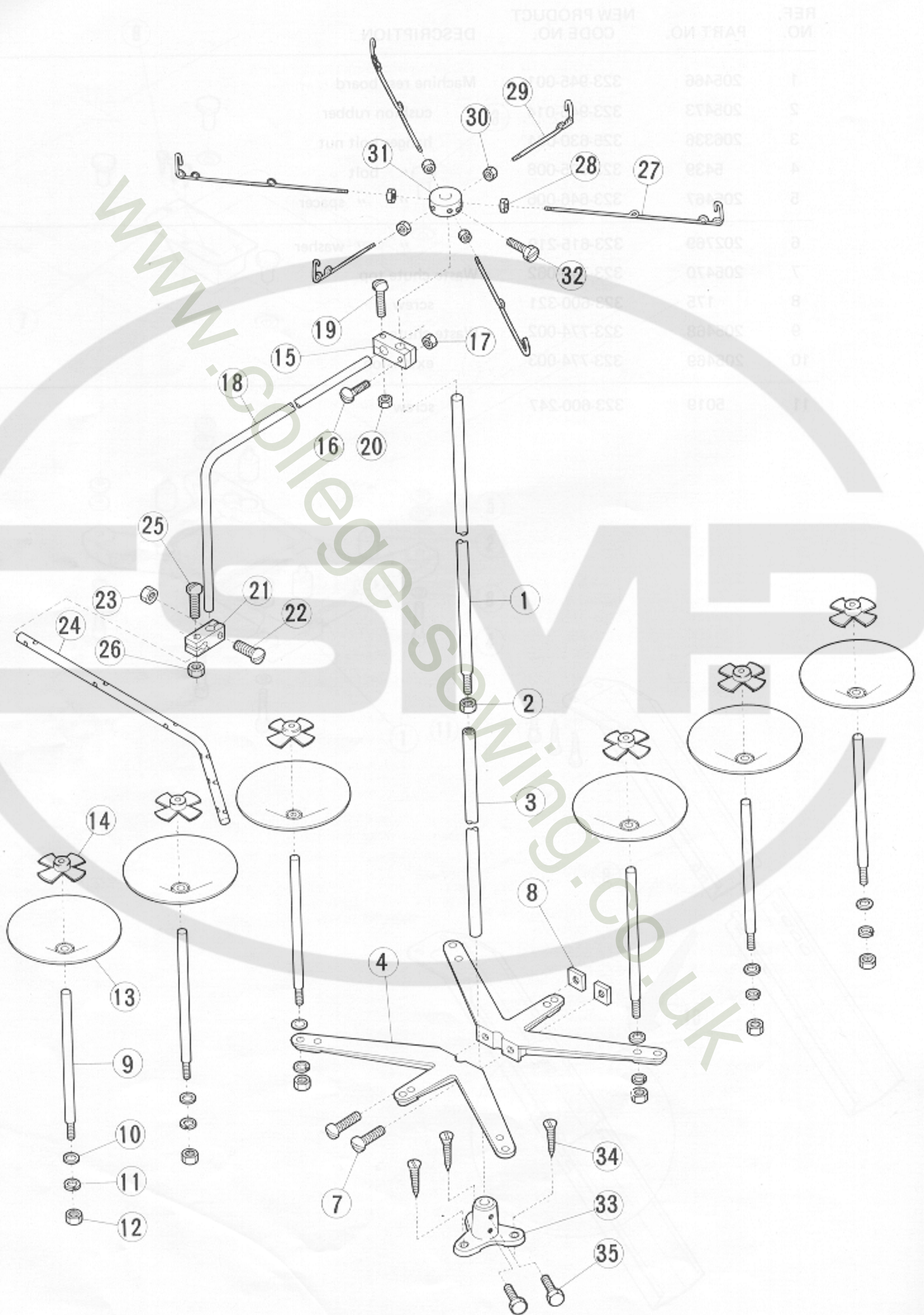
ACCESSORIES FOR SEMI-SUBMERGED INSTALLATION

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT. SPOOLS	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
10	224	323-615-219	washer		4
11	225	323-615-219	nut spring washer		4
12	226	323-630-011	nut		4
13	227	323-685-013	spool tray		4
14	228	323-850-031	retaining fin		5
15	229	323-740-034	guide bar rod bracket		1
16	230	323-600-120	screw		1
17	231	323-630-020	nut		1
18	232	323-630-004	thread guide bar		1
19	230	323-600-120	screw		1
20	231	323-630-020	nut		1
21	233	323-750-006	thread guide retaining bracket		1
22	230	323-600-120	clamp screw		1
23	231	323-630-020	nut		1
24	293	323-690-004	thread guide bar		1
25	230	323-600-120	clamp screw		1
26	231	323-630-020	nut		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)		2
30	236	323-630-021	lock nut		2
31	260	323-685-015	thread guide wire holder		1
	261	323-685-017	holder		1
	262	323-685-018	holder		1
	238	323-685-014	holder		1
32	239	323-600-121	screw		1
33	240	323-605-000	thread stand base		1
34	241	323-600-122	wood screw		3
35	242	323-600-123	thread stand lower rod screw		2

MACHINE BED FRAME

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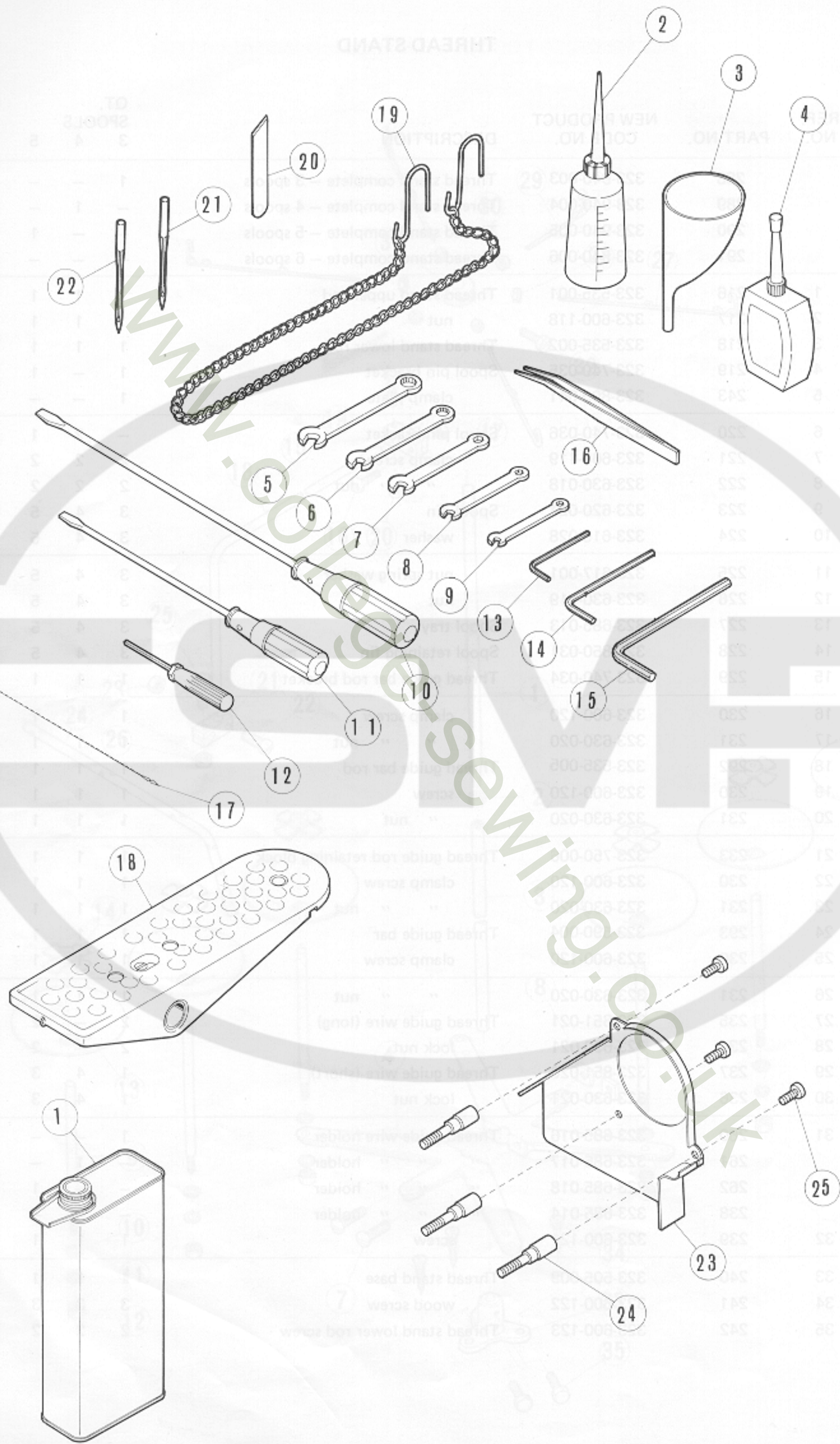




REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION
1	205486	323-945-00	Machine head
2	205473	323-945-01	Machine rubber
3	205336	323-930-01	Machine nut
4	5439	323-945-08	Machine bolt
5	205487	323-945-09	Machine spacer
6	205389	323-815-2	Machine washer
7	205470	323-945-02	Machine screw
8	175	323-900-321	Machine screw
9	205488	323-774-002	Machine screw
10	205489	323-774-003	Machine screw
11	5019	323-900-247	Machine screw

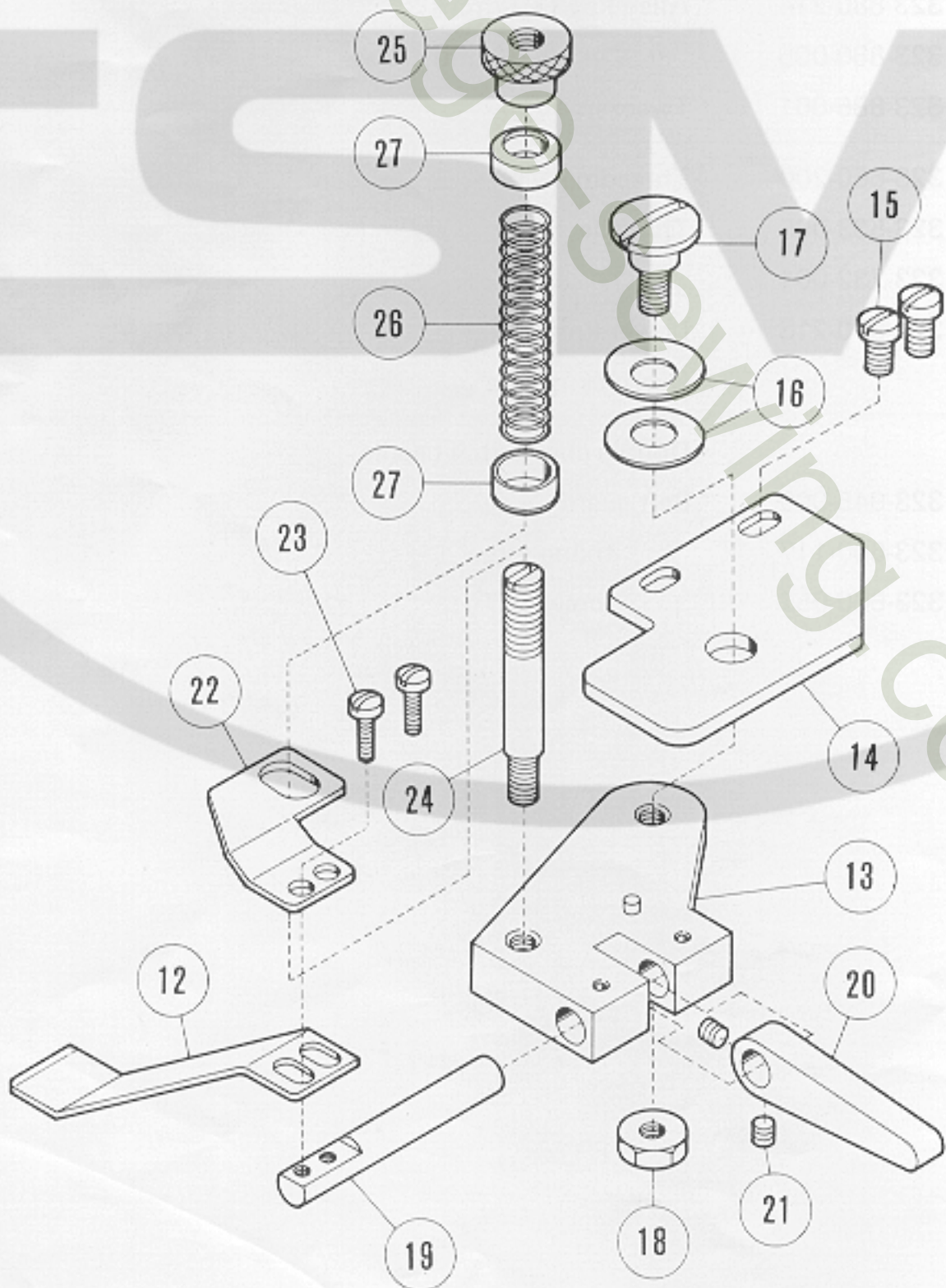
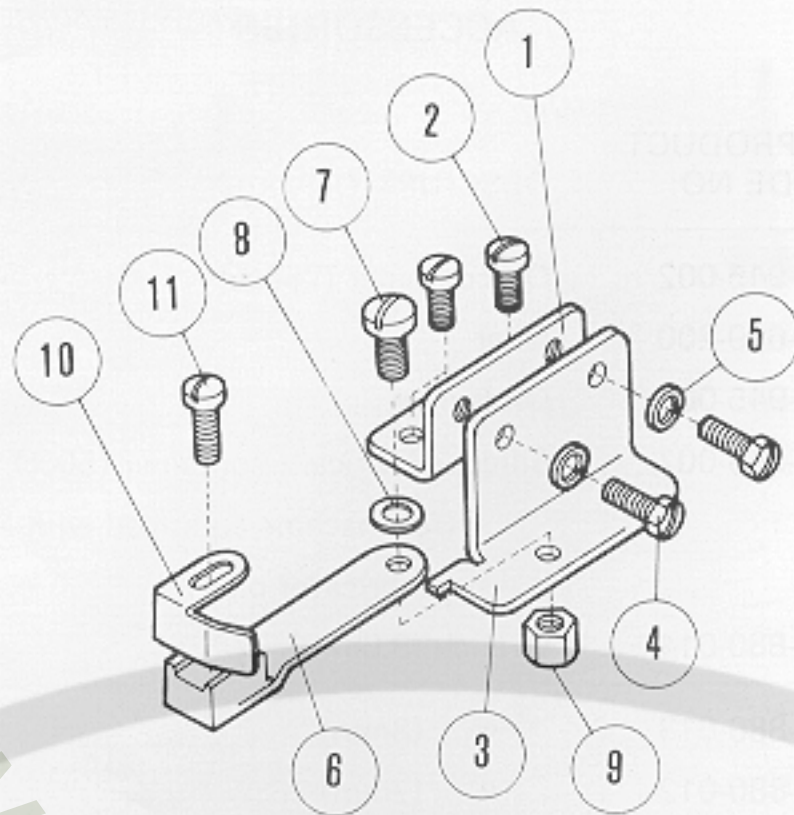
## THREAD STAND

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT. SPOOLS			
				3	4	5	6
	288	323-940-003	Thread stand complete — 3 spools	1	—	—	—
	289	323-940-004	Thread stand complete — 4 spools	—	1	—	—
	290	323-940-005	Thread stand complete — 5 spools	—	—	1	—
	291	323-940-006	Thread stand complete — 6 spools	—	—	—	1
1	216	323-535-001	Thread stand upper rod	1	1	1	1
2	217	323-600-118	nut	1	1	1	1
3	218	323-535-002	Thread stand lower rod	1	1	1	1
4	219	323-740-035	Spool pin bracket	1	—	1	2
5	243	323-800-041	clamp plate	1	—	—	—
6	220	323-740-036	Spool pin bracket	—	2	1	—
7	221	323-600-119	clamp screw	2	2	2	2
8	222	323-630-018	“ “ nut	2	2	2	2
9	223	323-620-024	Spool pin	3	4	5	6
10	224	323-615-028	washer	3	4	5	6
11	225	323-617-001	nut spring washer	3	4	5	6
12	226	323-630-019	nut	3	4	5	6
13	227	323-685-013	Spool tray	3	4	5	6
14	228	323-850-031	Spool retaining fin	3	4	5	6
15	229	323-740-034	Thread guide bar rod bracket	1	1	1	1
16	230	323-600-120	clamp screw	1	1	1	1
17	231	323-630-020	“ “ nut	1	1	1	1
18	292	323-535-005	Thread guide bar rod	1	1	1	1
19	230	323-600-120	screw	1	1	1	1
20	231	323-630-020	“ nut	1	1	1	1
21	233	323-750-006	Thread guide rod retaining block	1	1	1	1
22	230	323-600-120	clamp screw	1	1	1	1
23	231	323-630-020	“ “ nut	1	1	1	1
24	293	323-590-004	Thread guide bar	1	1	1	1
25	230	323-600-120	clamp screw	1	1	1	1
26	231	323-630-020	“ “ nut	1	1	1	1
27	235	323-851-021	Thread guide wire (long)	2	—	2	4
28	236	323-630-021	lock nut	2	—	2	4
29	237	323-851-020	Thread guide wire (short)	1	4	3	2
30	236	323-630-021	lock nut	1	4	3	2
31	260	323-685-016	Thread guide wire holder	1	—	—	—
	261	323-685-017	“ “ “ holder	—	1	—	—
	262	323-685-018	“ “ “ holder	—	—	1	—
	238	323-685-014	“ “ “ holder	—	—	—	1
32	239	323-600-121	screw	1	1	1	1
33	240	323-505-009	Thread stand base	1	1	1	1
34	241	323-600-122	wood screw	3	3	3	3
35	242	323-600-123	Thread stand lower rod screw	2	2	2	2



## ACCESSORIES

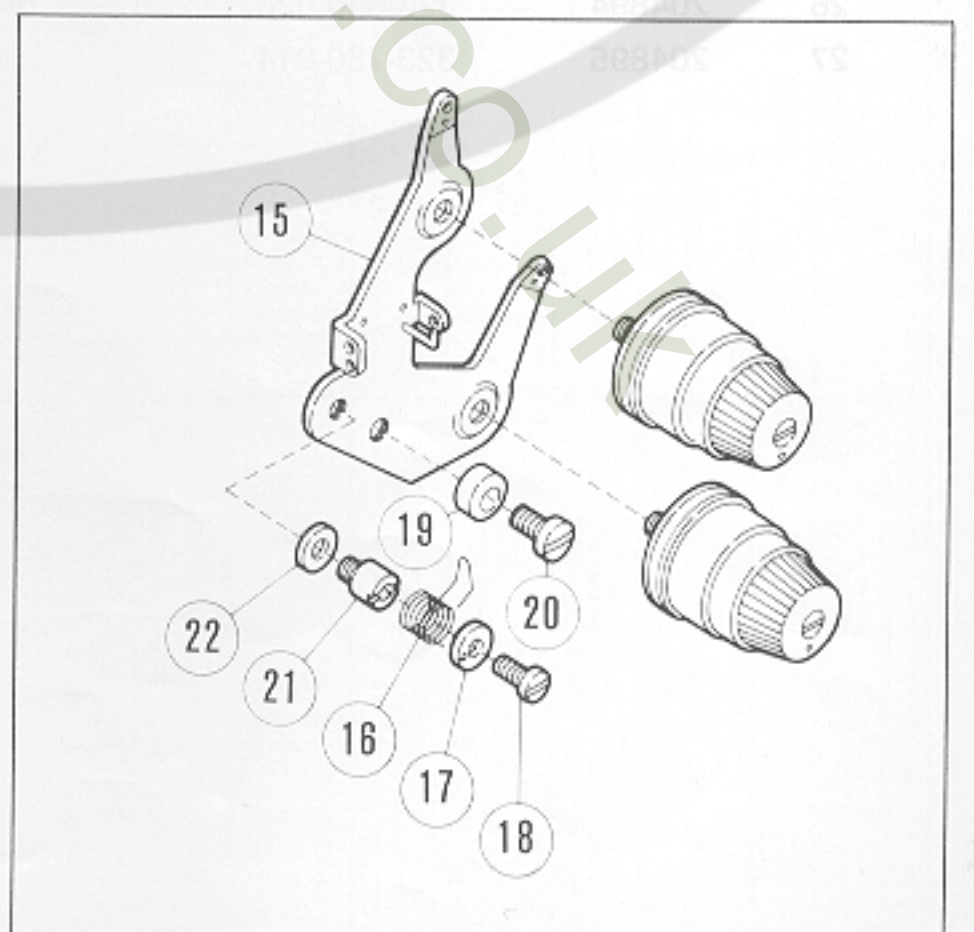
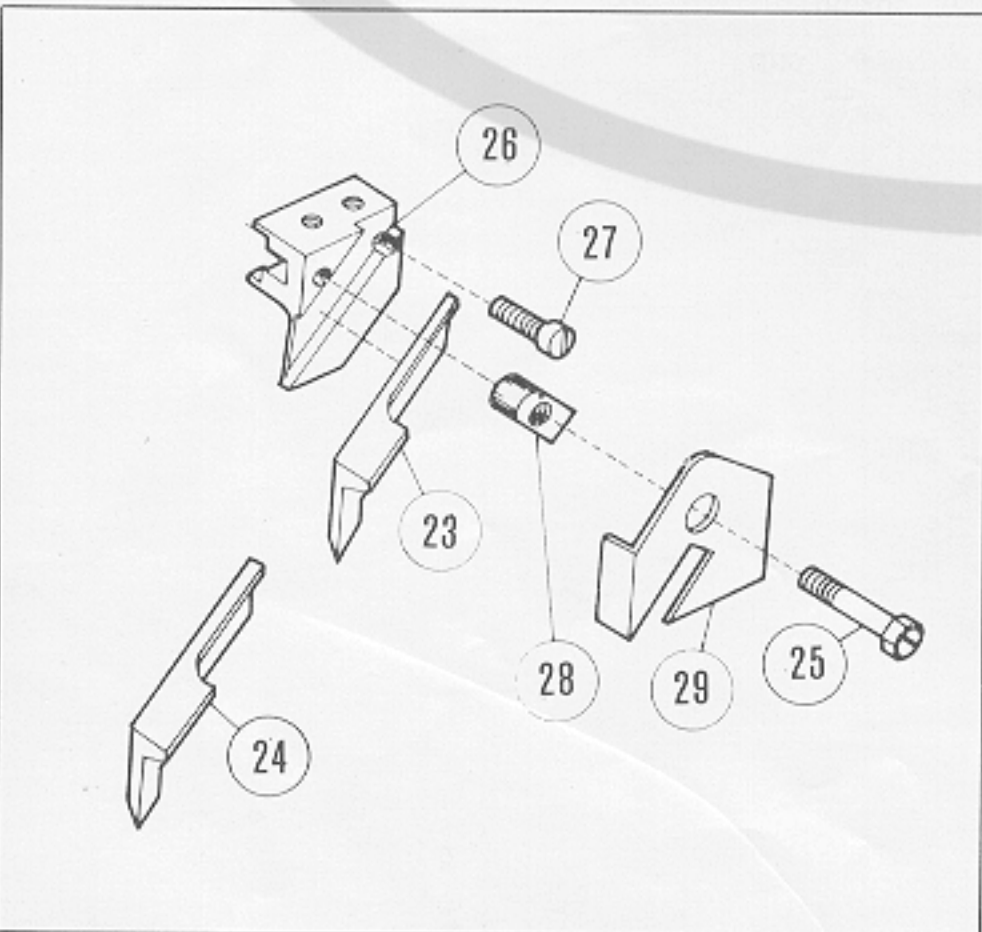
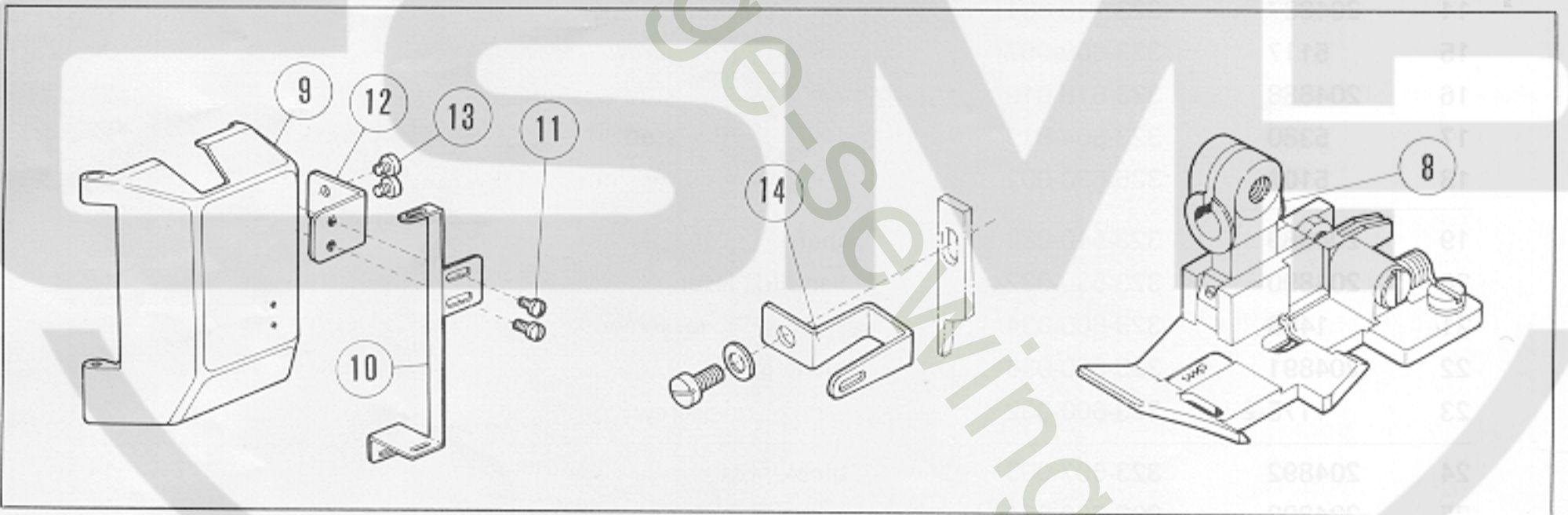
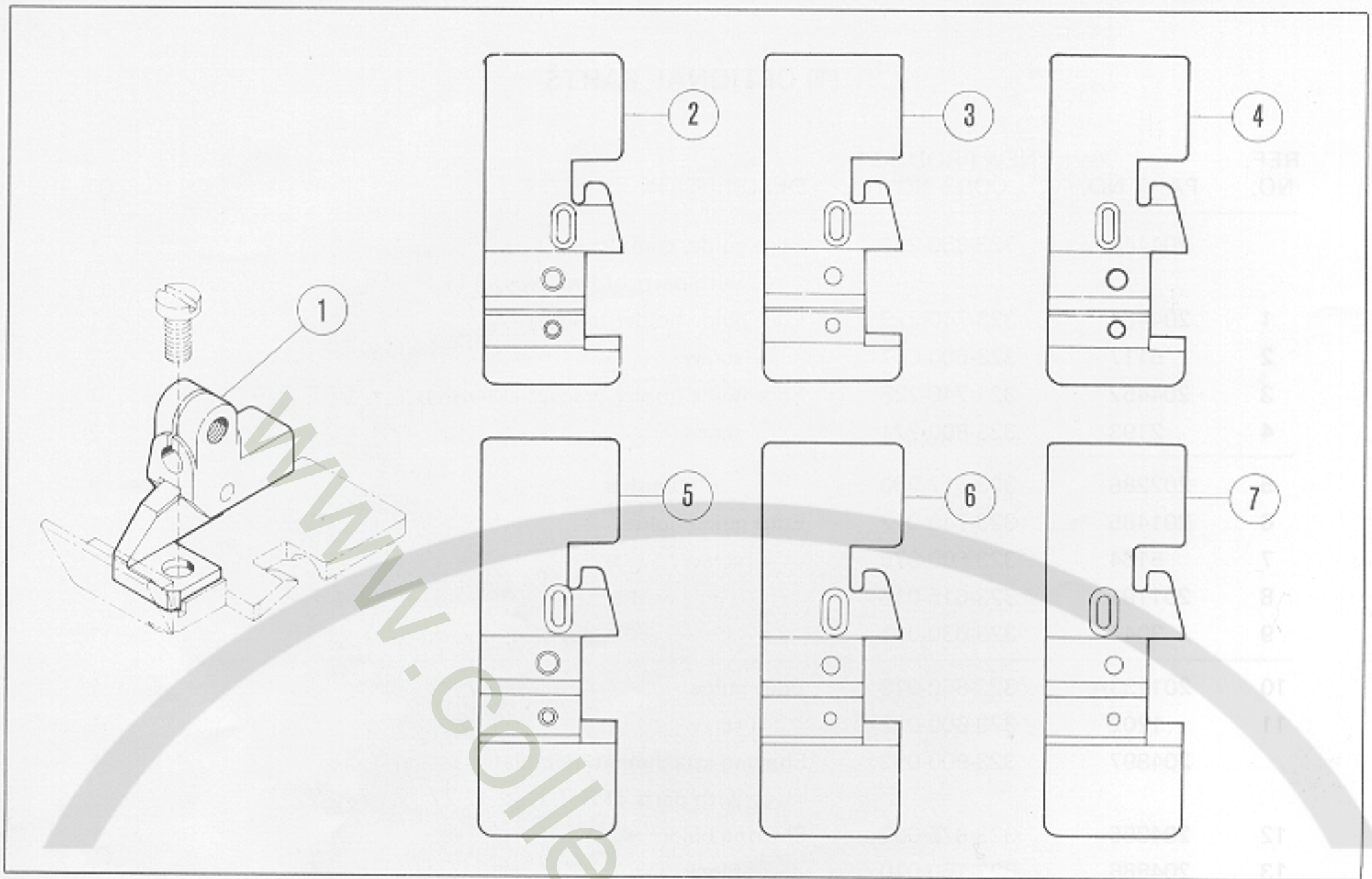
REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	133	323-945-002	Oil container (750cc)	1
2	132	323-659-200	Oiler	1
3	135A	323-945-003	Oil funnel	1
4	178	323-945-007	Silicone lubricant container (50cc)	1
4		323-600-27	(for machine equipped with Needle and Thread Lubricator only)	2
5	286	323-880-014	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
13	182	323-880-214	Allen key (3.17mm)	1
14	200	323-880-005	" " (4.76mm)	1
16	131	323-886-001	Tweezers	1
17	153	323-660-200	Threading wire	1
18	245	323-533-005	Threadle	1
19	126	323-732-001	" chain	1
20	204161	323-870-213	Lower knife	2
21			Overlock needle	10
22			Double chainstitch needle	10
23	205216A	323-945-009	Belt guard	1
24	205217	323-600-117	fixing screw	3
25	5117	323-600-057	screw	3



(1) OPTIONAL PARTS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
	204449	323-850-256	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	201233A	323-850-013	Edge guide	1
11	1202	323-600-032	screw	1
	204897	323-900-052	Shirring attachment, complete with parts of Ref. Nos. 12-27	1
12	204885	323-875-002	Shirring blade	1
13	204886	323-750-010	block	1
14	204887	323-740-061	" bracket	1
15	5117	323-600-057	" " screw	2
16	204888	323-618-019	" " stud washer	2
17	5380	323-604-019	" " stud	1
18	5104	325-630-002	" " " nut	1
19	204889	323-540-032	shaft	1
20	204890	323-530-032	hand lift lever	1
21	1459	323-600-034	" " " screw	2
22	204891	323-850-056	blade guide	1
23	1175-2	323-600-002	" " screw	2
24	204892	323-607-003	block post	1
25	204893	323-630-034	" " thumb nut	1
26	204894	323-640-026	" " spring	1
27	204895	323-780-014	" " " cup	2
20	5117	323-600-057	" screw	2
21	204961	323-615-017	stud	1
22	202757	323-615-235	band	1
Angled upper knife				
23	204892	323-607-003	Upper knife (angled)	1
24	204895	323-780-014	" (angled) - carbide tipped	1
25	5249	323-600-000	screw	1
26	208403	323-750-011	clamp	1
27	1176	323-600-226	screw	1
28	201155	323-615-013	rod	1
	201156	323-615-026	guard	1





## (2) OPTIONAL PARTS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
Cord and piping foot for shirring machine models (515-4-38 and 515-4-39 only)				
1	208554	323-740-063	Cord and piping foot bracket, complete	1
2	204499	323-820-290	Cord and piping foot – 2mm x 3mm (needle gauge x	1
	204500	323-820-291	“ “ “ foot – 2mm x 4mm Cord diameter)	1
	204501	323-820-292	“ “ “ foot – 2mm x 5mm	1
3	204502	323-820-293	“ “ “ foot – 3mm x 3mm	1
	204503	323-820-294	“ “ “ foot – 3mm x 4mm	1
	204504	323-820-295	“ “ “ foot – 3mm x 5mm	1
4	204505	323-820-296	“ “ “ foot – 5mm x 3mm	1
	204506	323-820-297	“ “ “ foot – 5mm x 4mm	1
	204507	323-820-298	“ “ “ foot – 5mm x 5mm	1
Cord and piping foot for seaming machine models (for all machine models except 515-4-38 and 515-4-39)				
5	204508	323-820-264	Cord and piping foot – 2mm x 3mm	1
	204509	323-820-265	“ “ “ foot – 2mm x 4mm	1
	204510	323-820-266	“ “ “ foot – 2mm x 5mm	1
6	204511	323-820-268	“ “ “ foot – 3mm x 3mm	1
	204512	323-820-269	“ “ “ foot – 3mm x 4mm	1
	204513	323-820-270	“ “ “ foot – 3mm x 5mm	1
7	204514	323-820-277	“ “ “ foot – 5mm x 3mm	1
	204515	323-820-278	“ “ “ foot – 5mm x 4mm	1
	204516	323-820-300	“ “ “ foot – 5mm x 5mm	1
Taping foot				
8	208622	323-820-043	Taping foot – 3mm x 5mm (Needle gauge x Tape width)	1
9	204950	323-510-036	Needle bar cover	1
10	205318	323-756-004	Tape support	1
11	1234	323-600-006	screw	2
12	205335	323-850-037	bracket	1
13	1234	323-600-006	“ screw	2
14	205319	323-850-032	Tape guide	1
401 needle thread tension guide (used for 401 needle thread of monofilament)				
15	208484	323-850-057	Needle thread tension guide, complete	1
16	204960	323-642-004	Needle thread tension regulating spring	1
17	204962	323-630-025	adjust nut	1
18	2922	323-600-229	“ “ screw	1
19	202683	323-716-209	regulator	1
20	5117	323-600-057	“ screw	1
21	204961	323-604-017	stud	1
22	202757	323-615-218	“ washer	1
Angled upper knife				
23	204152	323-870-217	Upper knife (angled)	1
24	204835	323-870-004	“ “ (angled) – carbide tipped	1
25	5299	323-600-300	screw	1
26	208403	323-750-011	clamp	1
27	1170	323-600-226	“ screw	1
28	204155	323-683-213	gib	1
29	204156	323-560-225	guard	1

COMMON PARTS: 204782 (323-561-014) – Needle guard (front) for right needle  
 204781 (323-561-013) – Needle guard (rear) for right needle  
 204072 (323-810-216) – Left looper  
 204161 (323-870-213) – Lower knife

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Presser foot complete	Presser foot fabric guard	Needle guard for 401 needle (front)	Needle guard (rear)	Needle bar complete	Right looper	401 looper	Upper knife	Others	
515-4-26 516-4-26 General seaming on woven and knit fabrics	2x3mm 5/64x1/8"	204343A 323-801-255	208063 323-830-069	208215 323-830-137	208500 323-820-037	208531 323-560-045	204536 323-561-211	204521 323-561-219	204877 323-843-001	204278 <i>215</i> 323-810-215	204314A 323-810-217	201121A 323-870-214		
	2x4mm 5/64x5/32"	204344A 323-801-256	"	"	"	"	"	"	"	<i>Treaded</i>	"	"	Needle (factory setting) DCx27 #11 423242831	
	2x5mm 5/64x3/16"	204345A 323-801-257	"	"	"	"	"	"	"	"	"	"		
	2x6mm 5/64x1/4"	204346A 323-801-258	"	"	"	"	"	"	"	"	"	"		
	3x3mm 1/8x1/8"	204294B 323-801-275	"	"	208501 323-820-038	"	204042 323-561-218	204522 323-561-220	204878 323-843-002	204704 323-810-011	"	"		
	3x4mm 1/8x5/32"	204039B 323-801-276	"	"	"	"	"	"	"	"	"	"		
	3x5mm 1/8x3/16"	204252B 323-801-277	"	"	"	"	"	"	"	"	"	"		
	3x6mm 1/8x1/4"	204295B 323-801-278	"	"	"	"	"	"	"	"	"	"	DCx27 #14 423243631	
	5x3mm 3/16x1/8"	204358A 323-801-263	"	"	208502 323-820-039	"	"	"	204879 323-843-003	"	204431 323-810-219	"		
	5x4mm 3/16x5/32"	204359A 323-801-264	"	"	"	"	"	"	"	"	"	"		
	5x5mm 3/16x3/16"	204360A 323-801-310	"	"	"	"	"	"	"	"	"	"		
	5x6mm 3/16x1/4"	204361A 323-801-266	"	"	"	"	"	"	"	"	"	"		
	515-4-27 516-4-27 General seaming and serging on light weight materials	2x3mm 5/64x1/8"	204362 323-801-267	208065 323-830-071	208218 323-830-138	208503 323-820-040	208531 323-560-045	204536 323-561-211	204521 323-561-219	204877 323-843-001	204278 323-810-215	204314A 323-810-217	202527A 323-870-005	
		2x4mm 5/64x5/32"	204363 323-801-268	"	"	"	"	"	"	"	"	"	"	
2x5mm 5/64x3/16"		204364 323-801-269	"	"	"	"	"	"	"	"	"	"		
2x6mm 5/64x1/4"		204365 323-801-270	"	"	"	"	"	"	"	"	"	"		
3x3mm 1/8x1/8"		204366 323-801-271	"	"	208504 323-820-041	"	204042 323-561-218	204522 323-561-220	204878 323-843-002	"	"	"	Needle (factory setting) DCx27 #11 423242831	
3x4mm 1/8x5/32"		204367 323-801-272	"	"	"	"	"	"	"	"	"	"		
3x5mm 1/8x3/16"		204368 323-801-273	"	"	"	"	"	"	"	"	"	"		
3x6mm 1/8x1/4"		204369 323-801-274	"	"	"	"	"	"	"	"	"	"		

RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

Right looper			for needle size			Model
Part number	Mark		Singer	W & G	Metric	
204278 323-810-215	1		9-12	027-032	65-80	515-4
204704 323-810-011	3		13-16	034-040	85-100	
204705 323-810-012	5		17-21	042-051	100-140	

Right looper			for needle size			Model
Part number	Mark		Singer	W & G	Metric	
204062 323-810-218	2		9-12	027-032	65-80	516-4
204702 323-810-009	4		13-16	034-040	85-100	
204703 323-810-010	6		17-21	042-051	100-140	

COMMON PARTS: 204782 (323-561-014) – Needle guard (front) for right needle  
 204781 (323-561-013) – Needle guard (rear) for right needle  
 204072 (323-810-216) – Left looper  
 204161 (323-870-213) – Lower knife

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Presser foot complete	Presser foot fabric guard	Needle guard for 401 needle (front)	Needle guard (rear)	Needle bar complete	Right looper	401 looper	Upper knife	Others
<b>515-4-28</b> <b>516-4-28</b> General seaming on permanent- press fabrics 	2x3mm 5/64x1/8"	204343A 323-801-255	208062 323-830-068	208216 323-830-139	208500 323-820-037	208531 323-560-045	204536 323-561-211	204521 323-561-219	204877 323-843-001	204278 323-810-215	204314A 323-810-217	201121A 323-870-214	
	2x4mm 5/64x5/32"	204344A 323-801-256	"	"	"	"	"	"	"	"	"	"	"
	2x5mm 5/64x3/16"	204345A 323-801-257	"	"	"	"	"	"	"	"	"	"	"
	2x6mm 5/64x1/4"	204346A 323-801-258	"	"	"	"	"	"	"	"	"	"	Needle (factory setting)
	3x3mm 1/8x1/8"	204294B 323-801-275	"	"	208501 323-820-038	"	204042 323-561-218	204522 323-561-220	204878 323-843-002	"	"	"	DCx27 #11 423242831
	3x4mm 1/8x5/32"	204039B 323-801-276	"	"	"	"	"	"	"	"	"	"	"
	3x5mm 1/8x3/16"	204252B 323-801-277	"	"	"	"	"	"	"	"	"	"	"
	3x6mm 1/8x1/4"	204295B 323-801-278	"	"	"	"	"	"	"	"	"	"	"
<b>515-4-29</b> <b>516-4-29</b> General seaming and serging on light to medium weight woven and knit fabrics 	2x3mm 5/64x1/8"	204362 323-801-267	208066 323-830-072	208219 323-830-140	208503 323-820-040	208531 323-560-045	204536 323-561-211	204521 323-561-219	204877 323-843-001	"	"	202527A 323-870-005	
	2x4mm 5/64x5/32"	204363 323-801-268	"	"	"	"	"	"	"	"	"	"	Needle (factory setting)
	2x5mm 5/64x3/16"	204364 323-801-269	"	"	"	"	"	"	"	"	"	"	DCx27 #11 423242831
	2x6mm 5/64x1/4"	204365 323-801-270	"	"	"	"	"	"	"	"	"	"	"
	3x3mm 1/8x1/8"	204366 323-801-271	"	"	208504 323-820-041	"	204042 323-561-218	204522 323-561-220	204878 323-843-002	204704 323-810-011	"	"	
	3x4mm 1/8x5/32"	204367 323-801-272	"	"	"	"	"	"	"	"	"	"	DCx27 #14 423243631
	3x5mm 1/8x3/16"	204368 323-801-273	"	"	"	"	"	"	"	"	"	"	"
	3x6mm 1/8x1/4"	204369 323-801-274	"	"	"	"	"	"	"	"	"	"	"

RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204278 323-810-215	1	9-12	027-032	65-80	515-4
204704 323-810-011	3	13-16	034-040	85-100	
204705 323-810-012	5	17-21	042-051	100-140	

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204062 323-810-218	2	9-12	027-032	65-80	516-4
204702 323-810-009	4	13-16	034-040	85-100	
204703 323-810-010	6	17-21	042-051	100-140	

(1) MISCELLANEOUS COVERS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208317	323-800-057	Bedplate	1
2	208422	323-663-024	gasket	1
3	4009-1	323-600-014	screw	8
4	208341	323-800-055	Bed cover plate (right)	1
5	208342	323-663-022	gasket	1
6	5117	323-600-057	screw	6
7	208347	323-510-078	Machine bed bottom cover	1
8	208348	323-655-011	oil filter	1
9	5117	323-600-057	screw	4
10	208430	323-800-061	Face plate	1
11	4009-1	323-600-014	screw	3
12	208610	323-802-014	Cloth plate, complete	1
13	202576	323-615-201	hinge stud thrust washer	1
14	201139	323-680-001	" " " collar	1
15	5084	323-600-013	" " " " screw	2
16	204218	323-734-204	lock spring	1
17	1216	323-600-068	" " screw	2
18	200162A	323-615-015	" " " washer	1
19	5232	323-600-314	" " latch	1
20	5441	323-600-140	stop screw	1
21	3044	323-630-001	" " nut	1
22	208482	323-627-018	cushion (small)	1
23	204827	323-627-009	" (large)	1
24	208340	323-801-004	Diff. feed ratio indication plate	1
25	208340	323-801-004	Diff. feed ratio indication plate	1
26	208340	323-801-004	Diff. feed ratio indication plate	1
27	208340	323-801-004	Diff. feed ratio indication plate	1
28	208340	323-801-004	Diff. feed ratio indication plate	1
29	208340	323-801-004	Diff. feed ratio indication plate	1
30	208340	323-801-004	Diff. feed ratio indication plate	1
31	208340	323-801-004	Diff. feed ratio indication plate	1
32	208340	323-801-004	Diff. feed ratio indication plate	1
33	208340	323-801-004	Diff. feed ratio indication plate	1
34	208340	323-801-004	Diff. feed ratio indication plate	1
35	208340	323-801-004	Diff. feed ratio indication plate	1
36	208340	323-801-004	Diff. feed ratio indication plate	1
37	208340	323-801-004	Diff. feed ratio indication plate	1
38	208340	323-801-004	Diff. feed ratio indication plate	1
39	208340	323-801-004	Diff. feed ratio indication plate	1
40	208340	323-801-004	Diff. feed ratio indication plate	1
41	208340	323-801-004	Diff. feed ratio indication plate	1
42	208340	323-801-004	Diff. feed ratio indication plate	1
43	208340	323-801-004	Diff. feed ratio indication plate	1
44	208340	323-801-004	Diff. feed ratio indication plate	1
45	208340	323-801-004	Diff. feed ratio indication plate	1
46	208340	323-801-004	Diff. feed ratio indication plate	1
47	208340	323-801-004	Diff. feed ratio indication plate	1
48	208340	323-801-004	Diff. feed ratio indication plate	1
49	208340	323-801-004	Diff. feed ratio indication plate	1
50	208340	323-801-004	Diff. feed ratio indication plate	1
51	208340	323-801-004	Diff. feed ratio indication plate	1
52	208340	323-801-004	Diff. feed ratio indication plate	1

COMMON PARTS: 204782 (323-561-014) – Needle guard (front) for right needle  
 204781 (323-561-013) – Needle guard (rear) for right needle  
 204072 (323-810-216) – Left looper  
 204161 (323-870-213) – Lower knife

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Presser foot complete	Presser foot fabric guard	Needle guard for 401 needle (front)	Needle guard (rear)	Needle bar complete	Right looper	401 looper	Upper knife	Others
<b>515-4-31</b> <b>516-4-31</b> Seaming on coarse woven fabrics	2x3mm 5/64x1/8"	204370 323-801-279	208070 323-830-076	208223 323-830-141	208500 323-820-037	208531 323-560-045	204536 323-561-211	204521 323-561-219	204877 323-843-001	204704 323-810-011	204314A 323-810-217	201121A 323-870-214	
	2x4mm 5/64x5/32"	204371 323-801-280	"	"	"	"	"	"	"	"	"	"	
	2x5mm 5/64x3/16"	204372 323-801-281	"	"	"	"	"	"	"	"	"	"	
	2x6mm 5/64x1/4"	204373 323-801-282	"	"	"	"	"	"	"	"	"	"	
	3x3mm 1/8x1/8"	204374 323-801-283	"	"	208501 323-820-038	"	204042 323-561-218	204522 323-561-220	204878 323-843-002	"	"	"	
	3x4mm 1/8x5/32"	204375 323-801-284	"	"	"	"	"	"	"	"	"	"	Needle (factory setting)
	3x5mm 1/8x3/16"	204376 323-801-285	"	"	"	"	"	"	"	"	"	"	DCx27 #16 423244031
	3x6mm 1/8x1/4"	204377 323-801-286	"	"	"	"	"	"	"	"	"	"	
	5x3mm 3/16x1/8"	204378 323-801-287	208064 323-830-070	208225 323-830-142	208502 323-820-039	"	"	"	204879 323-843-003	"	204431 323-810-219	"	
	5x4mm 3/16x5/32"	204379 323-801-288	"	"	"	"	"	"	"	"	"	"	
	5x5mm 3/16x3/16"	204380 323-801-289	"	"	"	"	"	"	"	"	"	"	
	5x6mm 3/16x1/4"	204381 323-801-290	"	"	"	"	"	"	"	"	"	"	
<b>515-4-32</b> <b>516-4-32</b> General seaming on medium- heavy woven materials	3x3mm 1/8x1/8"	204366 323-801-271	208067 323-830-073	208220 323-830-145	208504 323-820-041	208531 323-560-045	"	"	204878 323-843-002	"	204314A 323-810-217	202527A 323-870-005	
	3x4mm 1/8x5/32"	204367 323-801-272	"	"	"	"	"	"	"	"	"	"	
	3x5mm 1/8x3/16"	204368 323-801-273	"	"	"	"	"	"	"	"	"	"	Needle (factory setting)
	3x6mm 1/8x1/4"	204369 323-801-274	"	"	"	"	"	"	"	"	"	"	DCx27 #16 423244031

RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204278 323-810-215	1	9-12	027-032	65-80	515-4
204704 323-810-011	3	13-16	034-040	85-100	
204705 323-810-012	5	17-21	042-051	100-140	

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204062 323-810-218	2	9-12	027-032	65-80	516-4
204702 323-810-009	4	13-16	034-040	85-100	
204703 323-810-010	6	17-21	042-051	100-140	

COMMON PARTS: 204782 (323-561-014) – Needle guard (front) for right needle  
 204781 (323-561-013) – Needle guard (rear) for right needle  
 204072 (323-810-216) – Left looper  
 204161 (323-870-213) – Lower knife

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Presser foot complete	Presser foot fabric guard	Needle guard for 401 needle (front)	Needle guard (rear)	Needle bar complete	Right looper	401 looper	Upper knife	Others
<b>515-4-33</b> <b>516-4-33</b> Seaming and turning corners on coarse woven materials	3x3mm 1/8x1/8"	204294B 323-801-275	208064 323-830-070	208217 323-830-136	208501 323-820-038	208531 323-560-045	204042 323-561-218	204522 323-561-220	204878 323-843-002	204704 323-810-011	204314A 323-810-217	201121A 323-870-214	
	3x4mm 1/8x5/32"	204039B 323-801-276	"	"	"	"	"	"	"	"	"	"	
	3x5mm 1/8x3/16"	204252B 323-801-277	"	"	"	"	"	"	"	"	"	"	
	3x6mm 1/8x1/4"	204295B 323-801-278	"	"	"	"	"	"	"	"	"	"	
	5x3mm 3/16x1/8"	204358A 323-801-263	"	"	208502 323-820-039	"	"	"	204879 323-843-003	"	204431 323-810-219	"	Needle (factory setting) DCx27 #16 423244031
	5x4mm 3/16x5/32"	204359A 323-801-264	"	"	"	"	"	"	"	"	"	"	
	5x5mm 3/16x3/16"	204360A 323-801-310	"	"	"	"	"	"	"	"	"	"	
	5x6mm 3/16x1/4"	204361A 323-801-266	"	"	"	"	"	"	"	"	"	"	
<b>515-4-38</b> <b>516-4-38</b> 3:1 intermittent (knee controlled) shirring on dress weight materials	2x3mm 5/64x1/8"	204935 323-801-050	208074 323-830-080	204420 323-830-291	208507 323-820-034	208532 323-560-054	204536 323-561-211	204521 323-561-219	204877 323-843-001	204278 323-810-215	204314A 323-810-217	"	Needle (factory setting) DCx27 #11 423242831
	2x4mm 5/64x5/32"	204936 323-801-051	"	"	"	"	"	"	"	"	"	"	
	2x5mm 5/64x3/16"	204937 323-801-052	"	"	"	"	"	"	"	"	"	"	
	2x6mm 5/64x1/4"	204938 323-801-053	"	"	"	"	"	"	"	"	"	"	Shirring attachment
	3x3mm 1/8x1/8"	204939 323-801-054	"	"	208508 323-820-035	"	204042 323-561-218	204522 323-561-220	204878 323-843-002	204704 323-810-011	"	"	
	3x4mm 1/8x5/32"	204940 323-801-055	"	"	"	"	"	"	"	"	"	"	
	3x5mm 1/8x3/16"	204941 323-801-056	"	"	"	"	"	"	"	"	"	"	
	3x6mm 1/8x1/4"	204942 323-801-057	"	"	"	"	"	"	"	"	"	"	
	5x3mm 3/16x1/8"	204943 323-801-058	208076 323-830-082	204422 323-830-295	208509 323-820-036	"	"	"	204879 323-843-003	"	204431 323-810-219	"	DCx27 #14 423243631
	5x4mm 3/16x5/32"	204944 323-801-059	"	"	"	"	"	"	"	"	"	"	
	5x5mm 3/16x3/16"	204945 323-801-060	"	"	"	"	"	"	"	"	"	"	
	5x6mm 3/16x1/4"	204946 323-801-061	"	"	"	"	"	"	"	"	"	"	

RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

Right looper			for needle size			Model
Part number	Mark		Singer	W & G	Metric	
204278	323-810-215	1	9-12	027-032	65-80	515-4
204704	323-810-011	3	13-16	034-040	85-100	
204705	323-810-012	5	17-21	042-051	100-140	

Right looper			for needle size			Model
Part number	Mark		Singer	W & G	Metric	
204062	323-810-218	2	9-12	027-032	65-80	516-4
204702	323-810-009	4	13-16	034-040	85-100	
204703	323-810-010	6	17-21	042-051	100-140	

COMMON PARTS: 204782 (323-561-014) – Needle guard (front) for right needle  
 204781 (323-561-013) – Needle guard (rear) for right needle  
 204072 (323-810-216) – Left looper  
 204161 (323-870-213) – Lower knife

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Presser foot complete	Presser foot fabric guard	Needle guard for 401 needle (front)	Needle guard (rear)	Needle bar complete	Right looper	401 looper	Upper knife	Others
<b>515-4-39</b> <b>516-4-39</b> 3:1 intermittent (knee controlled) shirring on medium heavy materials	2x3mm 5/64x1/8"	204935 323-801-050	208075 323-830-081	204421 323-830-245	208507 323-820-034	208532 323-560-054	204536 323-561-211	204521 323-561-219	204877 323-843-001	204278 323-810-215	204314A 323-810-217	201121A 323-870-214	Needle (factory setting)
	2x4mm 5/64x5/32"	204936 323-801-051	"	"	"	"	"	"	"	"	"	"	DCx27 #16 423244031
	2x5mm 5/64x3/16"	204937 323-801-052	"	"	"	"	"	"	"	"	"	"	"
	2x6mm 5/64x1/4"	204938 323-801-053	"	"	"	"	"	"	"	"	"	"	"
	3x3mm 1/8x1/8"	204939 323-801-054	"	"	208508 323-820-035	"	204042 323-561-218	204522 323-561-220	204878 323-843-002	204704 323-810-011	"	"	"
	3x4mm 1/8x5/32"	204940 323-801-055	"	"	"	"	"	"	"	"	"	"	Shirring attachment
	3x5mm 1/8x3/16"	204941 323-801-056	"	"	"	"	"	"	"	"	"	"	"
	3x6mm 1/8x1/4"	204942 323-801-057	"	"	"	"	"	"	"	"	"	"	"
	5x3mm 3/16x1/8"	204943 323-801-058	208077 323-830-083	204423 323-830-297	208509 323-820-036	"	"	"	204879 323-843-003	"	204431 323-810-219	"	"
	5x4mm 3/16x5/32"	204944 323-801-059	"	"	"	"	"	"	"	"	"	"	"
	5x5mm 3/16x3/16"	204945 323-801-060	"	"	"	"	"	"	"	"	"	"	"
	5x6mm 3/16x1/4"	204946 323-801-061	"	"	"	"	"	"	"	"	"	"	"
<b>515-4-51. 516-4-51</b> Seaming and crossing seams on heavy coarse woven materials	5x5mm 3/16x3/16"	204700 323-801-034	208064 323-830-070	208225 323-830-142	208506 323-820-033	204683 323-560-029	"	"	"	204705 323-810-012	"	"	Needle (factory setting)
	5x6mm 3/16x1/4"	204701 323-801-035	"	"	"	"	"	"	"	"	"	"	DCx1 #21 (B-27 #120) 423225231
<b>515-4-52. 516-4-52</b> Seaming and crossing seams on heavy coarse woven materials	5x5mm 3/16x3/16"	204528 323-801-358	"	208217 323-830-136	"	"	"	"	"	"	"	"	Needle (factory setting)
	5x6mm 3/16x1/4"	204529 323-801-359	"	"	"	"	"	"	"	"	"	"	DCx1 #21 (B-27 #120) 423225231

See page 81 for RIGHT LOOPER REFERENCE TABLE













# CROSS NUMBER INDEX

(new product code numbers vs part numbers)

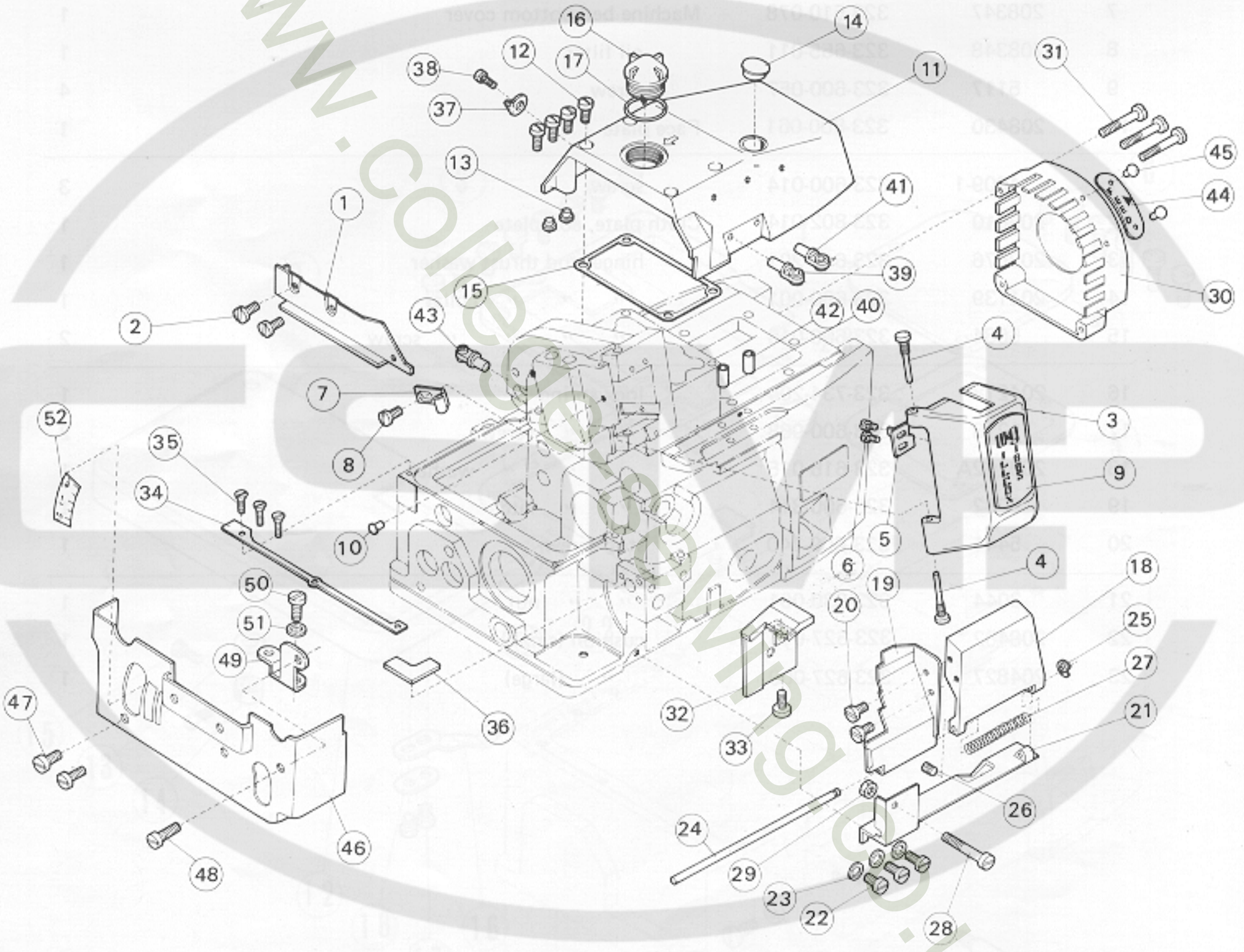
NEW PRODUCT CODE NO.	OLD NO.	PAGE	REF NO.	NEW PRODUCT CODE NO.	OLD NO.	PAGE	REF NO.	NEW PRODUCT CODE NO.	OLD NO.	PAGE	REF NO.
323-843-002	204878	48		323-870-214	201121A	49		323-870-214	201121A	50	
323-843-002	204878	48		323-870-214	201121A	50		323-870-214	201121A	50	
323-843-002	204878	49		323-870-214	201121A	51		323-870-214	201121A	51	
323-843-002	204878	49		323-870-214	201121A	51		323-870-214	201121A	51	
323-843-002	204878	50		323-870-214	201121A	52		323-870-214	201121A	52	
323-843-002	204878	50		323-870-214	201121A	52		323-870-217	204152	47	23
323-843-002	204878	51		323-870-218	204351	27	27	323-873-001	201308	29	6
323-843-002	204878	51									
323-843-002	204878	52		323-875-002	204885	45	12				
323-843-002	204878	52		323-875-200	205064	37	1				
				323-880-005	200	43	14				
323-843-003	204879	48		323-880-010	282	43	9				
323-843-003	204879	48		323-880-011	283	43	8				
323-843-003	204879	50		323-880-012	284	43	7				
323-843-003	204879	50		323-880-013	285	43	6				
323-843-003	204879	51		323-880-014	286	43	5				
323-843-003	204879	51		323-880-214	182	43	13				
323-843-003	204879	52		323-882-201	204003	3	14				
323-843-003	204879	52									
323-850-013	201233A	45	10	323-885-001	127	43	10				
323-850-021	202495	13	17	323-885-002	128	43	11				
				323-885-200	179	43	12				
323-850-031	228	41	14	323-886-001	131	43	15				
323-850-032	205319	47	14	323-891-002	204649	7	44				
323-850-037	205335	47	12	323-891-004	208340	7	52				
323-850-049	208108A	25	39	323-891-200	204143A	23	50				
323-850-050	208107A	25	41	323-900-012	204593	31					
323-850-055	208479	29	26	323-900-045	208488	13	55				
323-850-056	204891	45	22	323-900-046	208489	17	22				
323-850-057	208484	47	15								
323-850-200	201074A	15	6	323-900-047	208490	15	37				
323-850-200	201074A	17	4	323-900-047	208491	13	43				
				323-900-049	208492	13	44				
323-850-221	200041	13	19	323-900-050	208411	23					
323-850-246	204096	21	27	323-900-051	208416	23					
323-850-247	204160A	27	24	323-900-052	204897	45					
323-850-256	204449	45	5	323-900-215	204670	37					
323-850-258	205091	37	35	323-900-224	192	37					
323-851-005	204707	13	22	323-902-020	204188	31	21				
323-851-018	204905	15	51	323-940-003	288	41					
323-851-020	237	41	29								
323-851-021	235	41	27	323-940-004	289	41					
323-851-022	208102	15	26	323-940-005	290	41					
				323-940-006	291	41					
323-851-023	208399	13	26	323-945-001	205466	39	1				
323-851-024	208307	13	54	323-945-002	133	43	1				
323-851-213	204276	13	25	323-945-003	135A	43	3				
323-851-217	193174	17	33	323-945-007	178	43	4				
323-851-219	204098	21	33	323-945-009	205216A	43	22				
323-851-219	204098	21	33	323-945-014	205473	39	2				
323-851-220	204099	21	35	325-600-011	5167	29	5				
323-860-200	201048A	7	39								
323-860-200	201048A	7	41	325-615-006	206337	39	13				
323-860-200	201048A	7	43	325-630-002	5104	21	4				
323-860-211	167079	7	37	325-630-002	5104	45	18				
				325-630-004	206336	39	3				
323-860-215	204324	21	31								
323-866-012	204901	17	31								
323-866-013	204902	15	48								
323-866-016	208445	15	46								
323-866-213	204095A	21	25								
323-866-214	202706A	13	23								
323-870-004	204835	47	24								
323-870-005	202527A	27	13								
323-870-005	202527A	48									
323-870-005	202527A	49									
323-870-005	202527A	50									
323-870-207	202527	48									
323-870-207	202527	49									
323-870-207	202527	50									
323-870-213	204161	27	26								
323-870-213	204161	43	19								
323-870-214	201121A	27	12								
323-870-214	201121A	48									
323-870-214	201121A	48									
323-870-214	201121A	49									



(7) MISCELLANEOUS COVERS

DT.	DESCRIPTION	NEW PRODUCT CODE NO.	PART NO.	REF. NO.
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1	Bedplate	323-800-057	208317	1
1	Gasket	323-683-024	208422	2
8	Screw	323-800-014	4009-1	3
1	Bed cover plate (right)	323-800-058	208347	4
1	Gasket	323-683-022	208342	5
8	Screw	323-800-057	417	6













### CROSS NUMBER INDEX

(part numbers vs new product code numbers)

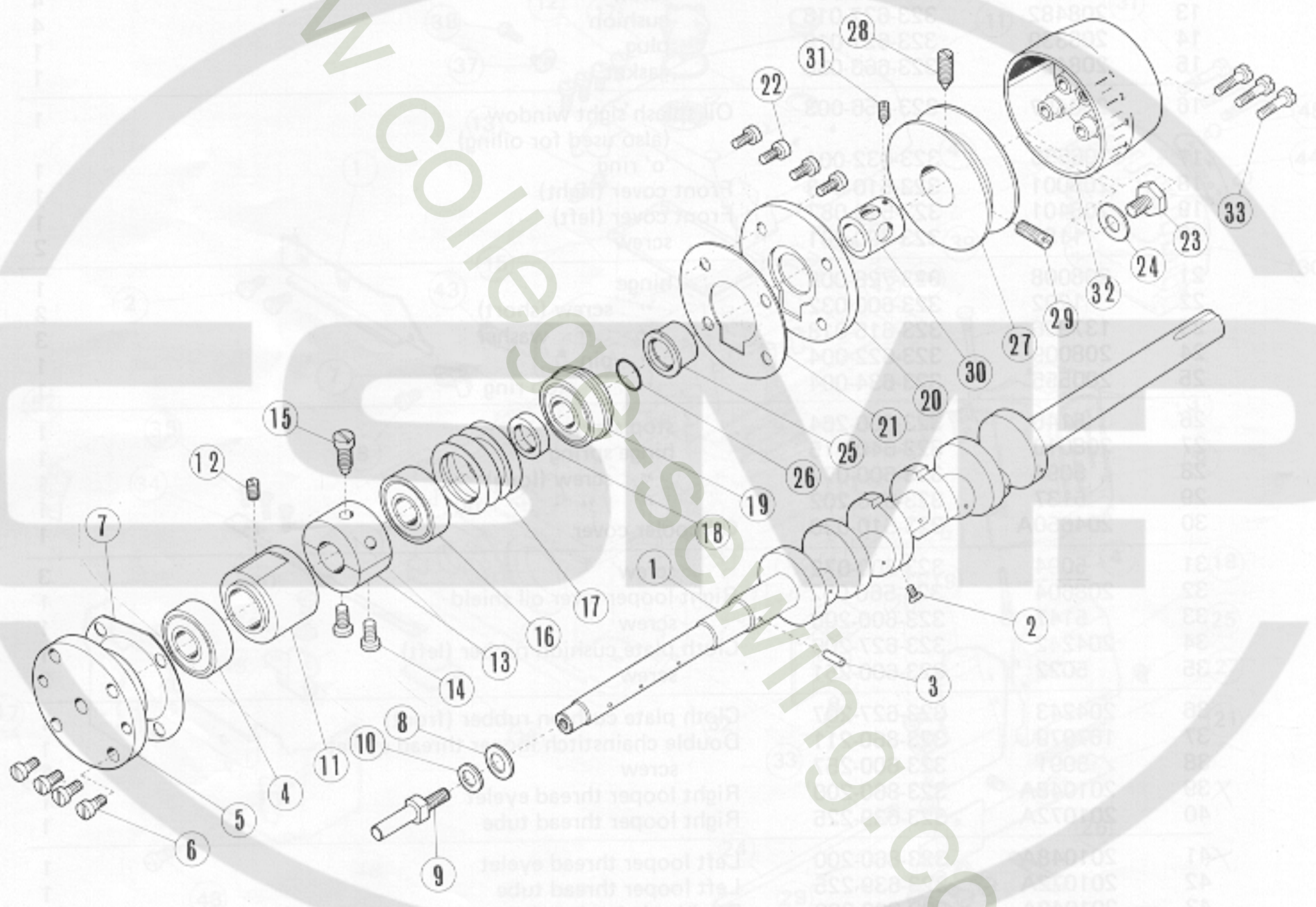
OLD NO.	NEW PRODUCT CODE NO.	PAGE	REF NO.	OLD NO.	NEW PRODUCT CODE NO.	PAGE	REF NO.	OLD NO.	NEW PRODUCT CODE NO.	PAGE	REF NO.
208299	323-510-079	7	11	208501	323-820-038	29	8				
208307	323-851-024	13	54	208501	323-820-038	48					
208308	323-658-005	35	1	208501	323-820-038	49					
208313	323-530-029	29	19	208501	323-820-038	50					
208314	323-620-036	29	21	208501	323-820-038	51					
208315	323-640-024	29	22	208502	323-820-039	48					
208316	323-604-018	29	43	208502	323-820-039	50					
208317	323-800-057	5	1	208502	323-820-039	51					
208318	323-663-023	33	17	208503	323-820-040	48					
208319	323-530-028	15	25	208503	323-820-040	49					
208320	323-780-011	9	32	208504	323-820-041	48					
208330	323-625-802	23	17	208504	323-820-041	49					
208339	323-627-019	7	14	208504	323-820-041	50					
208340	323-891-004	7	52	208506	323-820-033	52					
208341	323-800-055	5	4	208507	323-820-034	51					
208342	323-663-022	5	5	208507	323-820-034	52					
208343	323-540-029	9	1	208508	323-820-035	51					
208346	323-525-013	15	1	208508	323-820-035	52					
208346	323-525-013	17	1	208509	323-820-036	51					
208347	323-510-078	5	7	208509	323-820-036	52					
208348	323-655-011	5	8	208526	323-502-011	29	1				
208399	323-851-023	13	26	208529	323-640-022	29	12				
208401	323-510-087	7	19	208531	323-560-045	29	10				
208402	323-683-019	27	16	208531	323-560-045	48					
208403	323-750-011	47	26	208531	323-560-045	49					
208404	323-685-021	27	19	208531	323-560-045	50					
208406	323-692-033	3	21	208531	323-560-045	51					
208409	323-618-018	23	15	208532	323-560-054	51					
208410	323-716-013	23	19	208532	323-560-054	52					
208411	323-900-050	23		208534	323-540-031	29	14				
208415		23	22	208535	323-676-050	29	15				
208416	323-900-051	23		208537	323-592-001	29	25				
208419	323-680-012	21	18	208540	323-640-023	29	27				
208420	323-535-004	23	29	208549	323-620-042	29	4				
208421	323-640-021	23	31	208554	323-740-063	47	1				
208422	323-663-024	5	2	208560	323-510-097	13	7				
208424	323-576-017	13	1	208561	323-653-017	13	9				
208425	323-730-012	13	4	208562	323-653-018	13	10				
208427	323-683-018	13	14	208563	323-800-062	13	11				
208429	323-676-049	15	16	208568	323-510-089	13					
208430	323-800-061	5	10	208592	323-780-013	15	34				
208434	323-560-047	3	12	208597	323-676-052	15	33				
208445	323-866-016	15	46	208598	323-530-031	29	29				
208447	323-630-033	13	45	208599	323-676-053	29	31				
208447	323-630-033	15	38	208602	323-500-019	3	4				
208447	323-630-033	17	23	208603	323-500-020	3	8				
208448	323-676-047	13	46	208604	323-560-052	7	32				
208448	323-676-047	15	39	208610	323-802-014	5	12				
208448	323-676-047	17	24	208615	323-600-142	29	28				
208449	323-650-001	13	51	208616	323-560-053	13	34				
208449	323-650-001	15	43	208617	323-653-019	13	36				
208449	323-650-001	17	28	208621	323-780-012	13	38				
208450	323-780-010	13	49	208622	323-820-043	47	8				
208450	323-780-010	15	41								
208450	323-780-010	17	26								
208479	323-850-055	29	26								
208481	323-663-030	7	15								
208482	323-627-018	5	22								
208482	323-627-018	7	13								
208484	323-850-057	47	15								
208486	323-652-004	35	4								
208487	323-800-065	35	6								
208488	323-900-045	13	55								
208489	323-900-046	17	22								
208490	323-900-047	15	37								
208491	323-900-047	13	43								
208492	323-900-049	13	44								
208500	323-820-037	48									
208500	323-820-037	49									
208500	323-820-037	50									

## (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	208023A	323-510-086	Needle bar cover	1
4	202653	323-620-240	hinge pin	1
5	202689	323-641-201	lock spring	1
6	1234	323-600-006	" " screw	2
7	204223	323-510-248	" " latch	1
8	4009-1	323-600-014	" " " screw	1
9	204450	323-692-256	name plate	1
10	198192	323-627-020	cushion rubber	1
11	208299	323-510-079	Top cover	1
12	5152	323-600-061	screw	4
13	208482	323-627-018	cushion	4
14	208339	323-627-019	plug	1
15	208481	323-663-030	gasket	1
16	206457	323-656-003	Oil splash sight window (also used for oiling)	1
17	206550	323-632-004	'o' ring	1
18	208001	323-510-043	Front cover (right)	1
19	208401	323-510-087	Front cover (left)	1
20	1189	323-600-301	screw	2
21	208008	323-728-008	hinge	1
22	1202	323-600-032	" screw (short)	3
23	137906	323-615-018	" " washer	3
24	208009	323-622-004	" pin	1
25	200555	323-634-004	" " stop ring	1
26	5146	323-600-264	stop screw	1
27	208010	323-640-015	hinge spring	1
28	5094	323-600-072	" screw (long)	1
29	5137	323-630-202	" " " nut	1
30	204650A	323-510-030	Oil cooler cover	1
31	5094	323-600-072	screw	3
32	208604	323-560-052	Right looper lever oil shield	1
33	5147	323-600-206	screw	1
34	204242	323-627-206	Cloth plate cushion rubber (left)	1
35	5022	323-600-251	screw	3
36	204243	323-627-207	Cloth plate cushion rubber (front)	1
37	167079	323-860-211	Double chainstitch looper thread eyelet	1
38	5091	323-600-257	screw	1
X39	201048A	323-860-200	Right looper thread eyelet	1
40	201072A	323-639-225	Right looper thread tube	1
X41	201048A	323-860-200	Left looper thread eyelet	1
42	201072A	323-639-225	Left looper thread tube	1
43	201048A	323-860-200	Double chainstitch looper thread eyelet	1
44	204649	323-891-002	Stitch indicator	1
45	204871	323-628-002	rivet	1
46	204865A	323-510-088	Machine cover (left)	1
47	5091	323-600-257	screw (short)	2
48	5182	323-600-109	" (long)	1
49	204868	323-646-004	spacer	1
50	2902	323-600-259	" screw	1
51	202286	323-617-200	" " washer	1
52	208340	323-891-004	Diff. feed ratio indication plate	1

(2) MISCELLANEOUS COVERS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION
1	204818A	323-660-051	Cloth plate fabric guard
2	4009-1	323-600-014	screw
3	208023A	323-610-088	Needle bar cover
4	202683	323-620-240	hinge pin
5	202689	323-641-201	lock spring
6	1234	323-600-006	" " " " screw
7	204223	323-610-248	" " " " latch
8	4009-1	323-600-014	" " " " screw
8	204450	323-682-256	name plate
10	198182	323-627-620	cushion rubber
11	208299	323-610-079	For screw
12	208182	323-600-051	screw
13	208182	323-600-051	nut
14	208182	323-600-051	washer
15	208182	323-600-051	nut
16	208182	323-600-051	washer
17	208182	323-600-051	nut
18	208182	323-600-051	washer
19	208182	323-600-051	nut
20	208182	323-600-051	washer
21	208182	323-600-051	nut
22	208182	323-600-051	washer
23	208182	323-600-051	nut
24	208182	323-600-051	washer
25	208182	323-600-051	nut
26	208182	323-600-051	washer
27	208182	323-600-051	nut
28	208182	323-600-051	washer
29	208182	323-600-051	nut
30	208182	323-600-051	washer
31	208182	323-600-051	nut
32	208182	323-600-051	washer
33	208182	323-600-051	nut



REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION
46	20108A	323-610-088	Machine cover (left)
47	20108A	323-600-257	screw (short)
48	20108A	323-600-109	" " (long)
49	20468	323-646-004	spacer
50	2802	323-600-259	" " " " screw
51	202386	323-617-200	" " " " washer
52	208340	323-681-004	Diff. feed ratio indication plate

## 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	" wick	1
4	204010	323-671-200	ball bearing (left)	1
5	204881	323-515-004	" " " housing	1
6	5361	323-600-097	" " " " screw	4
7	204319	323-663-205	" " " " gasket	1
8	204789	323-618-010	" " " retaining ring	1
9	204873	323-758-003	extension	1
10	204520	323-615-233	" washer	1
11	204014	323-676-243	bushing	1
12	2022	323-600-043	" screw	1
13	204016	323-676-232	" (center)	1
14	1174	323-600-027	" " 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
34	1703	323-500-046	screw	2
35	200821	323-615-013	" washer	2
36	204982	323-505-012	nut	1
37	5003	323-600-027	screw	2
38	5099	323-630-028	" nut	2
39	167086	323-615-211	"	2