

# **GLOBAL**

## **FS - 603**

**4-NEEDLE, FEED-OF-THE-ARM, INTERLOCK,  
FLATSEAMING MACHINE  
WITH DOUBLE EDGE FABRIC TRIMMER**

# **INSTRUCTION MANUAL SPARE PARTS LIST**

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# **INSTRUCTION MANUAL**

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Installing the machine head  
(table-mounted type)

CAUTION

Direction in which the machine  
pulley rotates

- 1
- 1
- 2
- 2
- 3
- 4
- 5
- 6
- 7
- 7
- 8
- 8
- 8
- 9
- 9
- 10
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## Installing the machine head (table-mounted type)

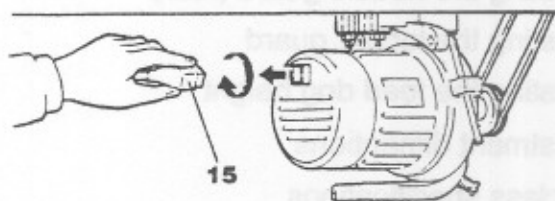
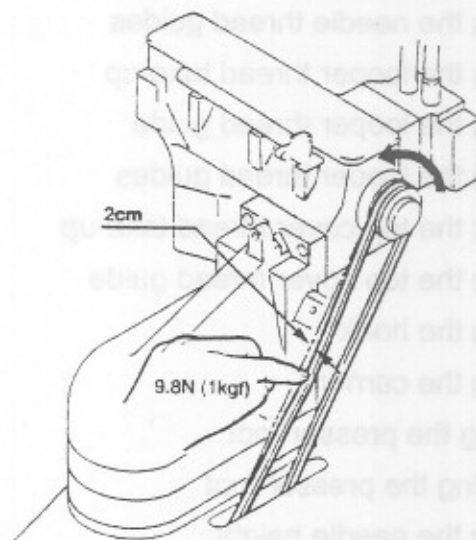
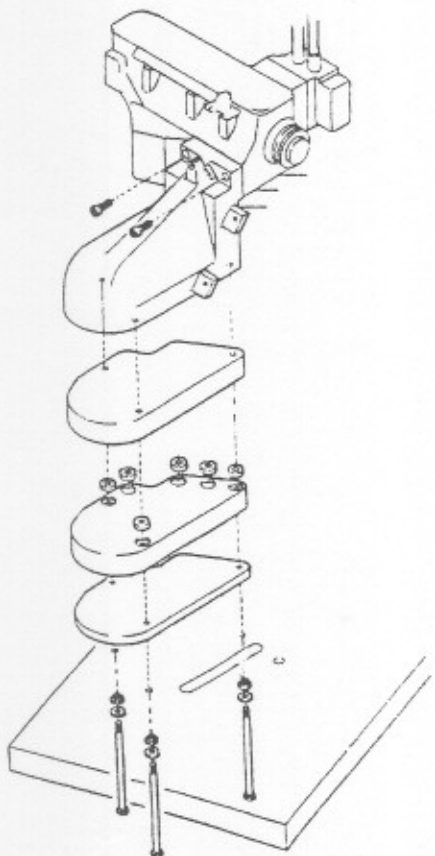
### ⚠ CAUTION

※Always turn off the power, unplug the machine and then well-qualified technicians should install the machine.

1. Firmly Install the machine head onto the machine rest bracket by referring to the illustration. Check there is no play and/or clearance after this installation.
2. Place the V belt. Approximately 2cm deflection should be obtained by pressing the middle of the V belt with 9.8N (1kgf). To achieve this deflection adjust the position of the machine motor.

### Direction in which the machine pulley rotates

The machine pulley rotates counterclockwise as seen from the machine pulley. If the machine pulley rotates in the reverse direction, turn motor connector 15 180 in direction of the arrow before establishing a connection.



## Installing the belt cover

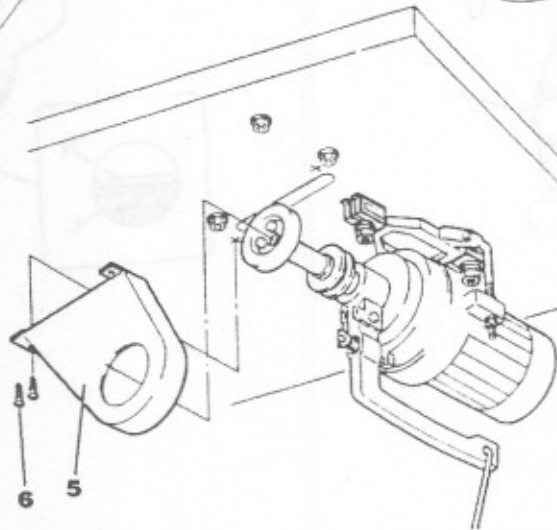
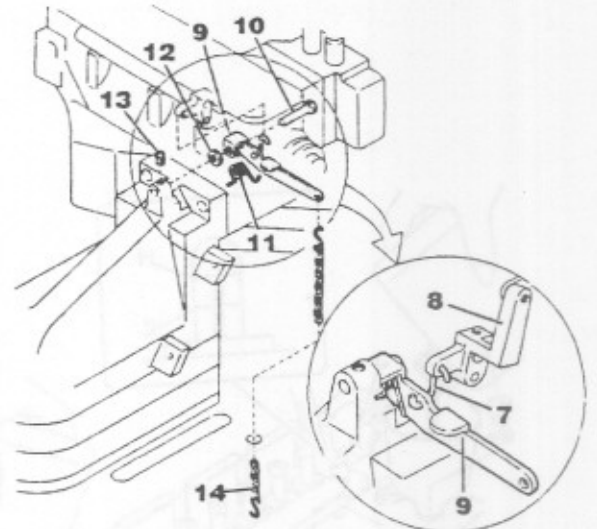
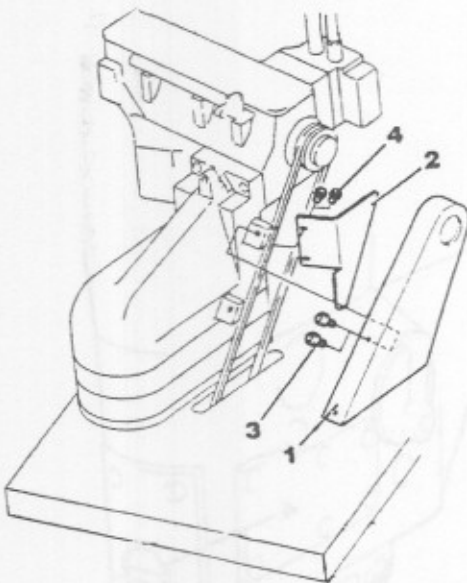
### **CAUTION**

※Always turn off the power, unplug the machine and then well-qualified technicians should install the belt cover.

1. Attach upper belt cover 1 and auxiliary cover 2 to the machine rest bracket with screws 3 and 4 (see the illustration on the right).
2. Install lower belt cover 5 onto the underside of the table with wood screws 6.

## Installing the presser foot lift lever

Join lever 8 attached to the machine and presser foot lift lever 9 with link 7 (see the illustration on the right). Attach presser foot lift lever 9, spring 11 and washer 12 to the machine rest bracket with pin 10. Tighten screw 13. Link presser foot lift lever 9 and the treadle with chain 14.



## Lubrication

### ⚠ CAUTION

※When lubricating the machine and/or replacing the oil, use Shingling recommended oil. Using other oils may damage the machine.

#### 1. Oil

Use Shingling recommended oil  
(P-68 made by Yanase).(ISO Viscosity Grade 68).

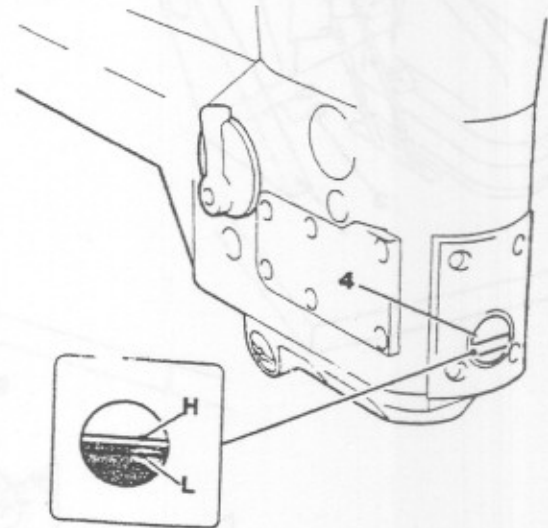
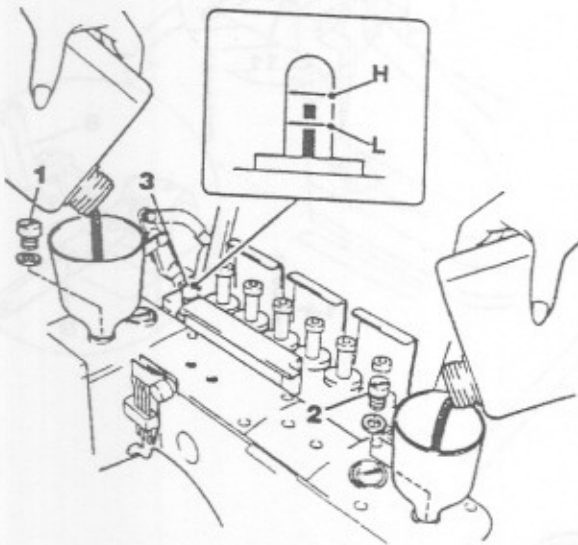
#### 2. To fill the machine with oil

Remove plug screws 1 and 2.  
Fill the machine with oil until the oil level reaches between H and L. After filling the machine replace plug screws 1 and 2.

#### 3. Required amount of oil

(H) on oil gauge 3, 4 : Upper limit  
(L) on oil gauge 3, 4 : Lower limit  
The oil level should always lie between (H) and (L).

#### 4. Manual lubrication



## **⚠ CAUTION**

※Always turn off the power and unplug the machine when you apply oil by hand.

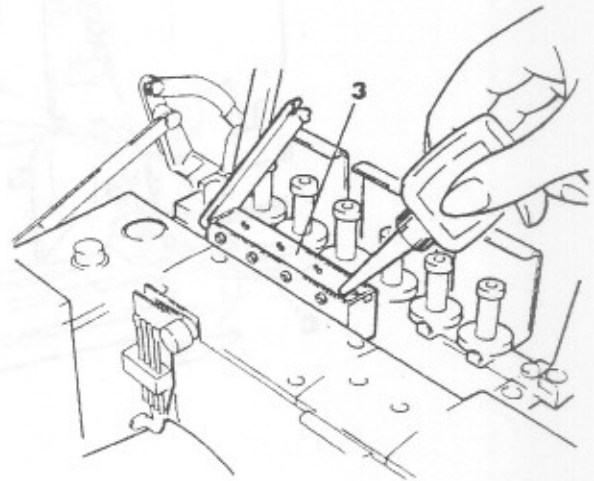
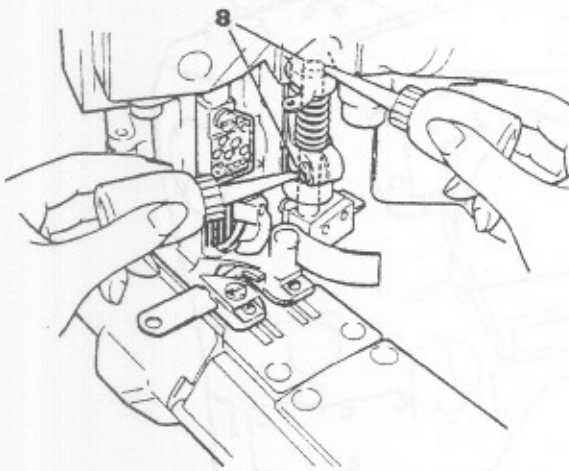
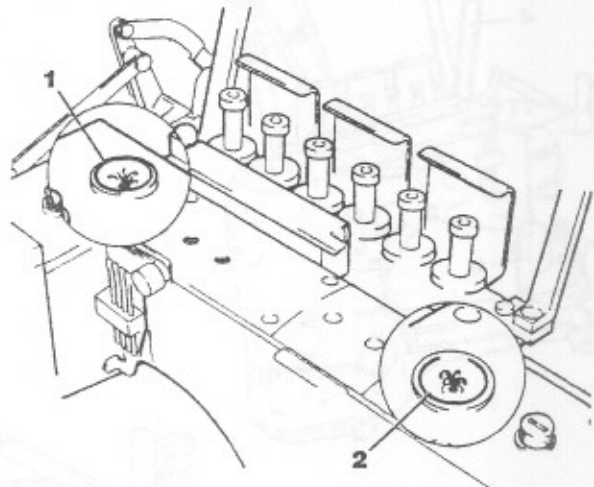
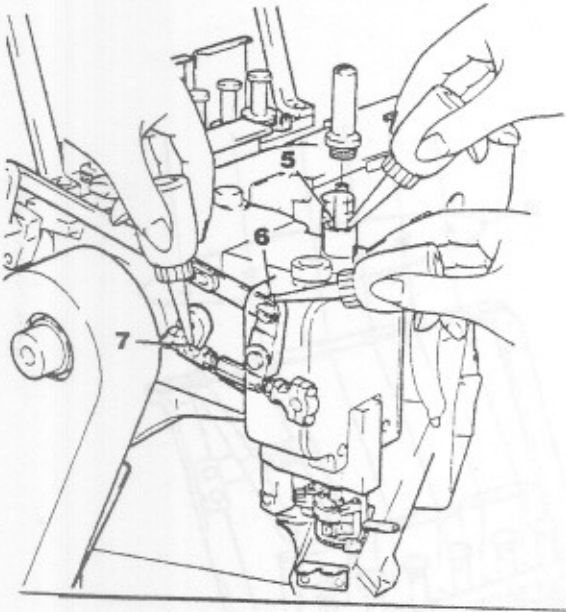
Apply 2 or 3 drops of oil to needle bar 5, presser foot lift link 6, rod 7 and crank 8 by hand when the machine is used for the first time or has been left unused for some time.

### **5. Checking oil circulation**

Run the machine and check for the proper oil flow after filling the machine with oil. This can be seen on the oil flow sight windows 1 and 2.

### **Silicone oil for H.R. device**

If the threads do not move smoothly, fill silicone oil reservoir 3 with silicon oil.



## Threading

### CAUTION

※Always turn off the power and unplug the machine when you thread the machine.

1. Open covers 1, 2, 3 and 4.

2. In case the machine is threaded previously

**A** : Knot the preset thread and the thread being used together to thread the machine.

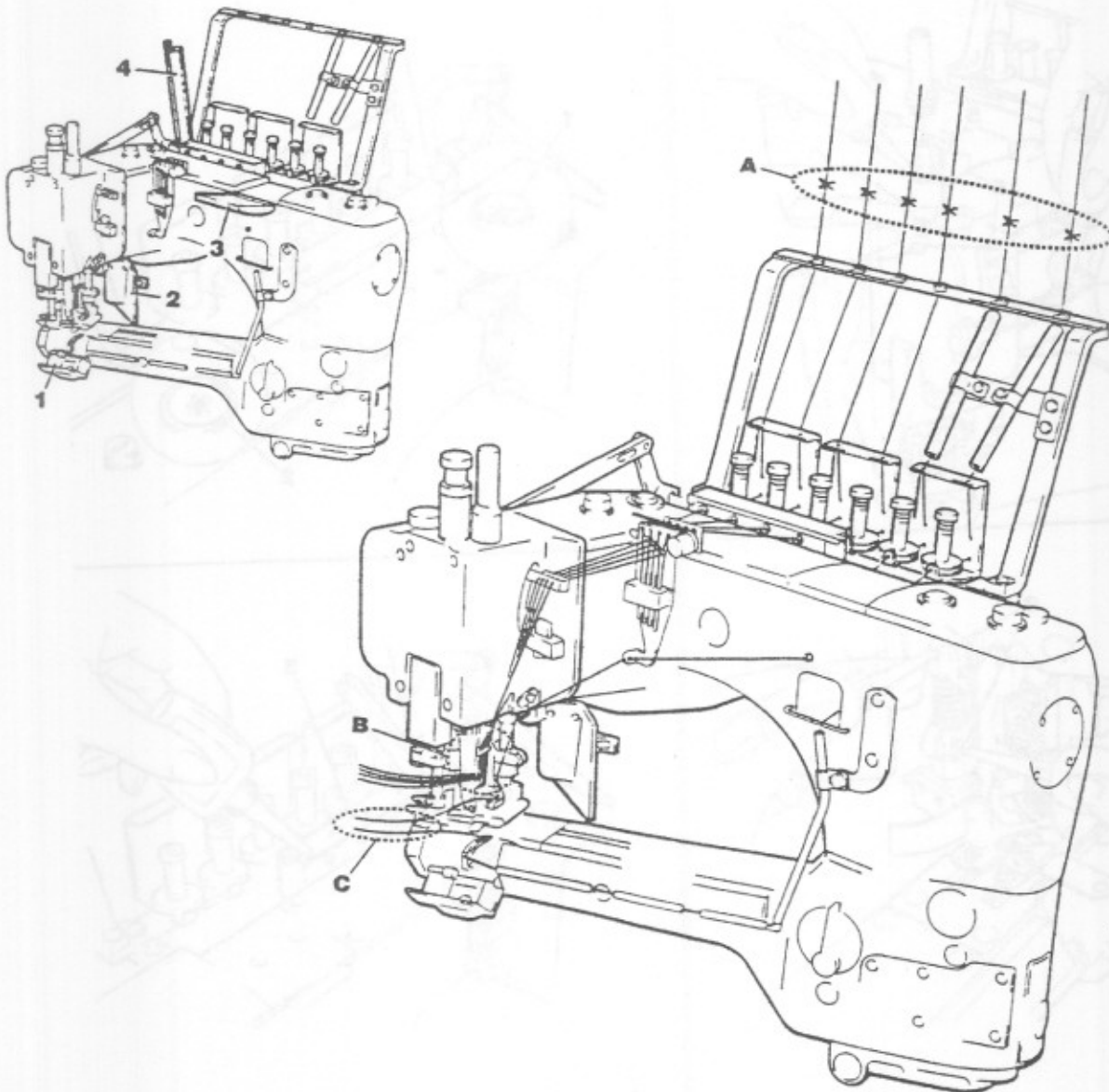
**B** : Needle thread

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

**C** : Looper thread, Top cover thread

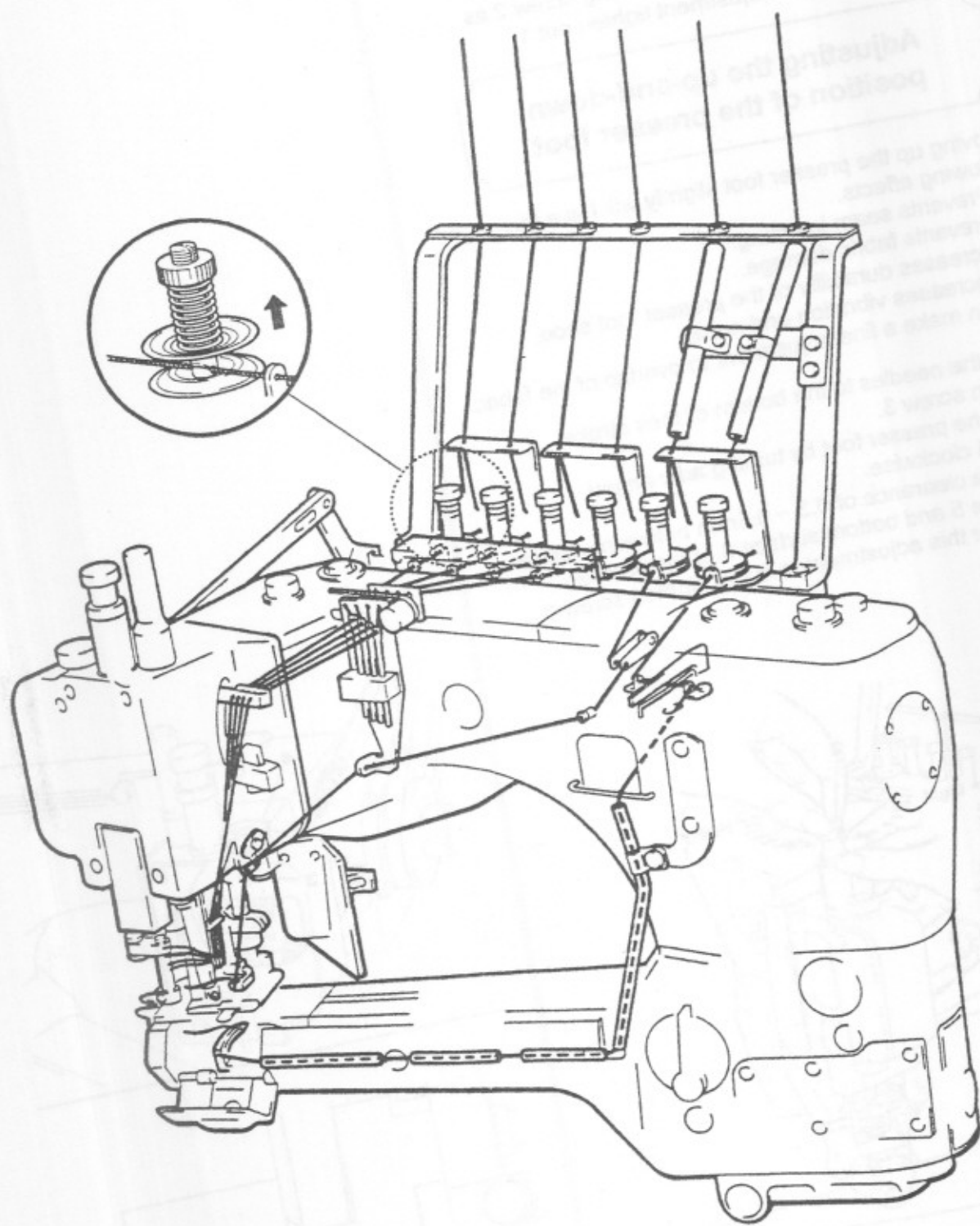
Trim the knots off neatly after passing through the eye of the looper.

Be sure to thread the machine correctly by referring to the threading diagram. (See page 6)





# Threading diagram



## Adjusting presser foot pressure

The presser foot pressure should be as light as possible, yet be sufficient to feed the fabric and obtain the proper stitch formation. Adjustment is made by loosening nut 1 and turning screw 2 as required. After this adjustment tighten nut 1.

## Adjusting the up-and-down position of the presser foot

Moving up the presser foot slightly will have the following effects.

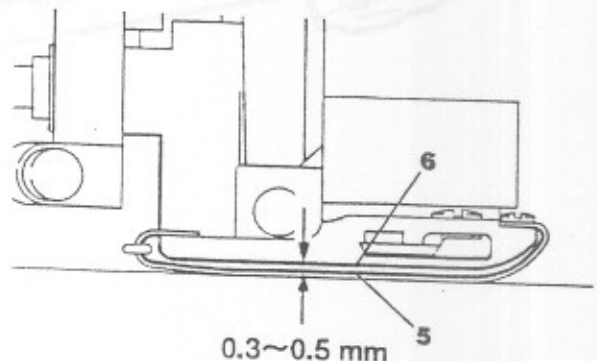
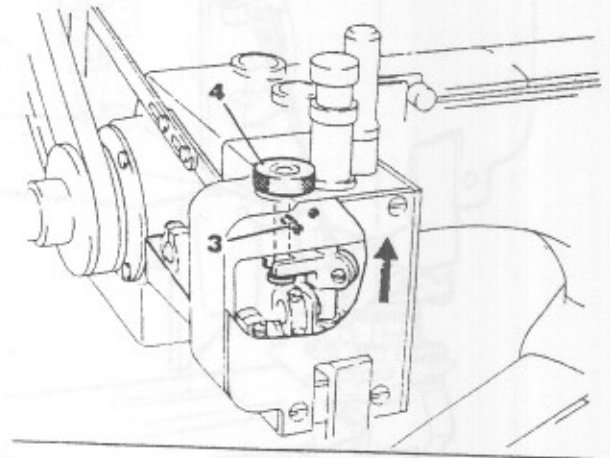
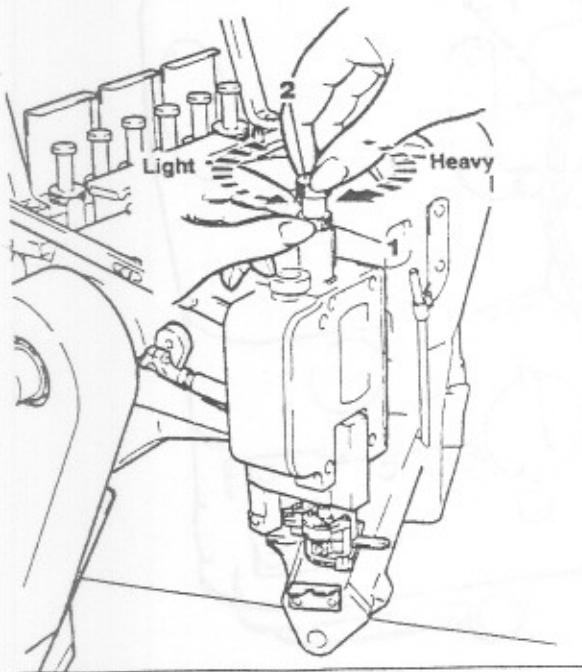
- ⊙ Prevents seam jamming.
- ⊙ Prevents fabric damage.
- ⊙ Increases durability of the presser foot shoe.
- ⊙ Decreases vibration and noise.
- ⊙ Can make a fine adjustment to overlap of the fabric.

Bring the needles to the bottom of their stroke.

Loosen screw 3.

Raise the presser foot by turning adjustment screw 4 clockwise.

Create a clearance of 0.3 ~ 0.5mm between presser foot shoe 5 and bottom surface 6 of the presser foot. After this adjustment is made, tighten screw 3.



## Adjusting the differential feed ratio

To increase the differential feed ratio, turn lever 1 clockwise.

This will shrink the finished fabric. To decrease the differential feed ratio, turn lever 1 counterclockwise. This will stretch the finished fabric.

## Adjusting stitch length

### ⚠ CAUTION

※Always turn off the power and unplug the machine when adjusting the stitch length.

Remove screw 2. Loosen screw 3.

To produce coarse stitches, move up link 4.

To produce fine stitches, move down link 4.

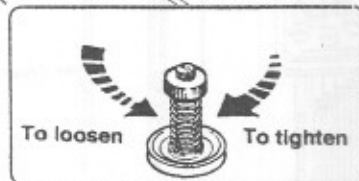
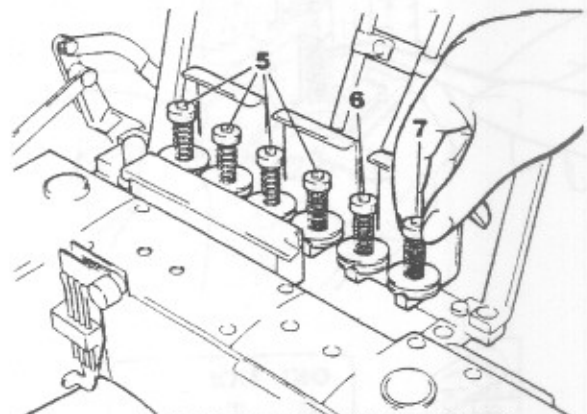
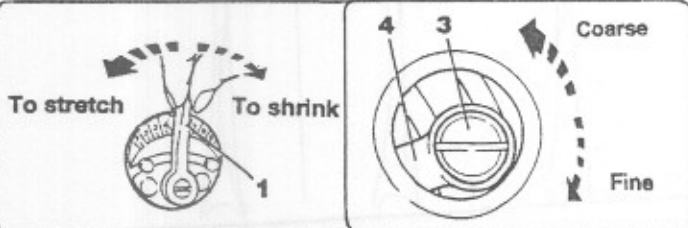
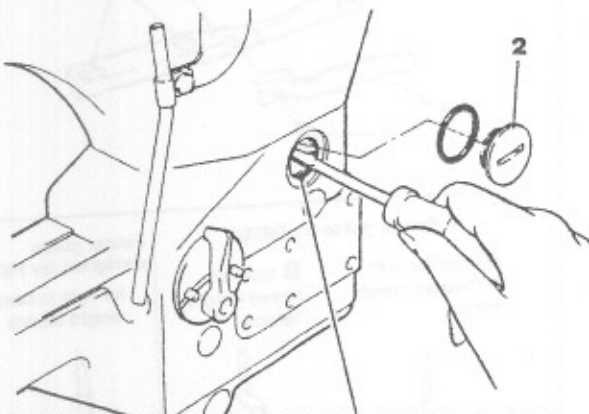
#### Note

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

## Adjusting the thread tension

To obtain the proper thread tension, adjust needle thread tension knobs 5, top cover thread tension knobs 6 and looper thread tension knob 7.

To tighten the thread, turn each knob clockwise.  
To loosen the thread, turn each knob counterclockwise.  
Each thread tension should be as light as possible, yet be sufficient to produce balanced and beautiful stitches.



## Replacing the needle

### ⚠ CAUTION

※ Always turn off the power and unplug the machine when you replace the needle(s).

1. Loosen screw 1 with the small slotted screwdriver supplied with the machine.
2. Remove the old needle(s) by using a pincette (provided as accessories).
3. Fix the needle so that its scarf faces the rear side of machine.
4. Insert a new needle into the needle hole as far it will go by using a pincette.
5. Tighten screw 1 with the small slotted screwdriver supplied with the machine.

## Replacing the fabric guide (SL703, 713)

### ⚠ CAUTION

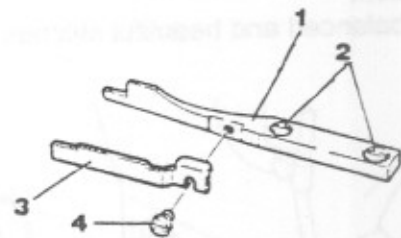
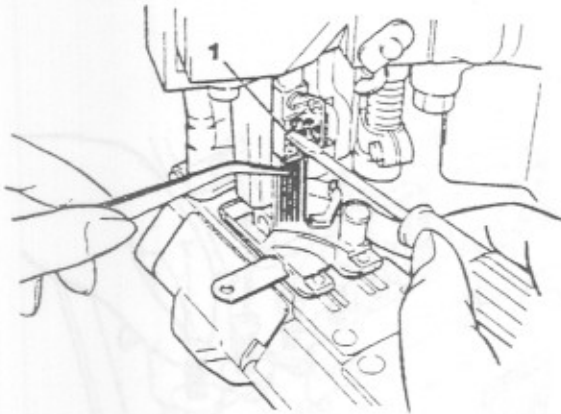
When replacing the fabric guide, always turn off the power and unplug the machine.

Fabric guides

Fabric guide for FS703: Two types of fabric guides are available.

**A** : for light to medium weight fabrics **B** : for heavy weight fabric  
Fabric guide designed for FS713.  
Select one according to the fabric to be used.  
Remove screws 2 and then replace fabric guide 1.

- ◎ If the fabric is sewn unevenly, attach flat spring 3 to fabricguide 1 with screw 4.



Fabric guide for FS703

**A** type for light to medium weight fabrics

**B** type for heavy weight fabrics

Fabric guide designed for FS713 for light to heavy weight fabrics



## Replacing the knives

### ⚠ CAUTION

※ Always turn off the power and shut down the air compressor first, and then well-qualified technicians should replace the knives.

⚠ Pay close attention to the knife edges not to injure your hands and/or finger.

### Replacing the upper knife

Loosen screw 5. Raise upper knife clamp 6. Then replace the upper knife.

⊙ There should be a overlap of 0.5 ~ 1.0mm of upper knife 7 and lower knife 8 with the upper knife at the extreme left end of its travel. Adjustment is made by moving upper knife 7. After this adjustment tighten screw 5.

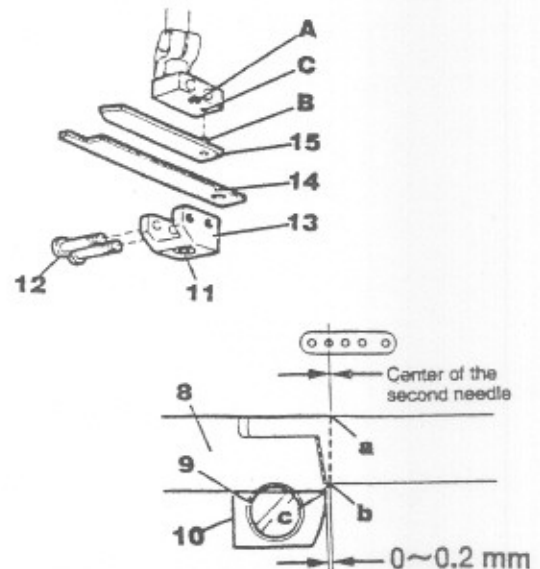
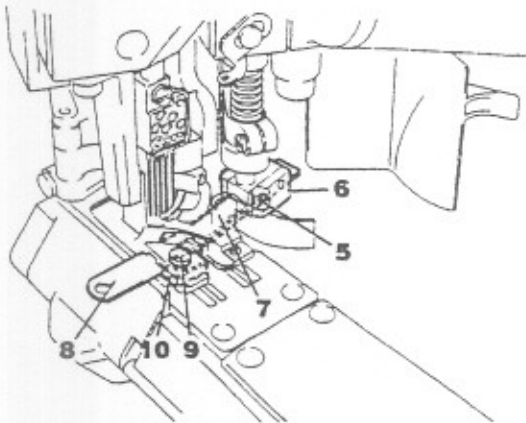
⊙ To adjust the angle in the horizontal direction when the upper and lower knives overlap. Remove parts 11 to 15 in sequence. Turn screw A as required. When replacing the parts, check to make sure screw B does not protrude from the bottom surface of upper knife presser 15, and then fit screw B into hole C.

### Replacing the lower knife

Loosen screw 9. Raise upper knife clamp 6.

⊙ Align point a of the lower knife with the center of the second needle by adjusting the position of the lower knife (standard). A fine adjustment should be made according to the fabric to be used.

⊙ Adjust the position of lower knife clamp 10 so that the distance from point b of lower knife 8 to corner c of lower knife clamp 10 is 0.2mm. After this adjustment tighten screw 9.

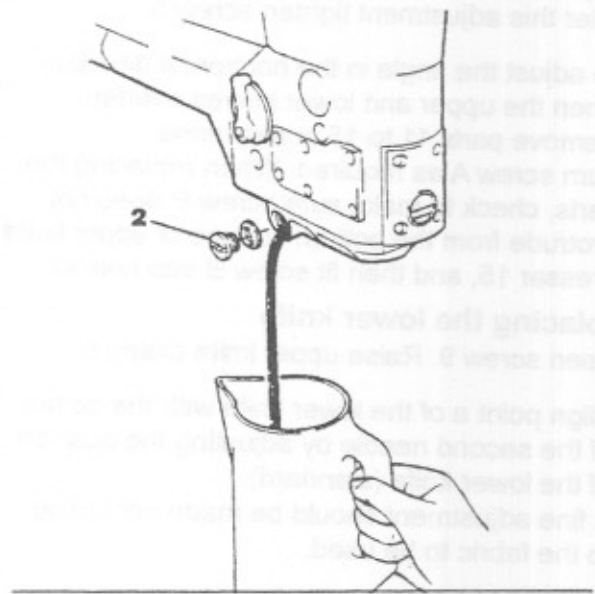
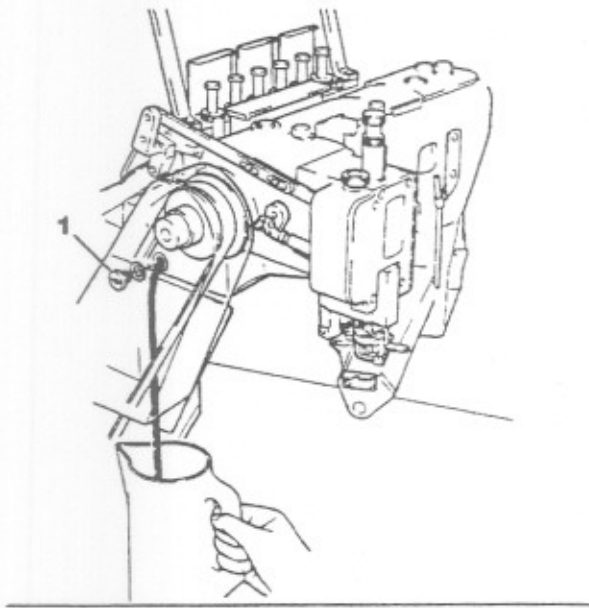


## Oil replacement

Replace the oil one month after the first use and thereafter every six months. If you keep using the old oil, it may cause the damage to the machine.

## To drain the oil

1. Remove plug screws 1 and 2. Drain the oil.
2. After draining the oil replace plug screws 1 and 2.



## Adjusting the needle guard

### ⚠ CAUTION

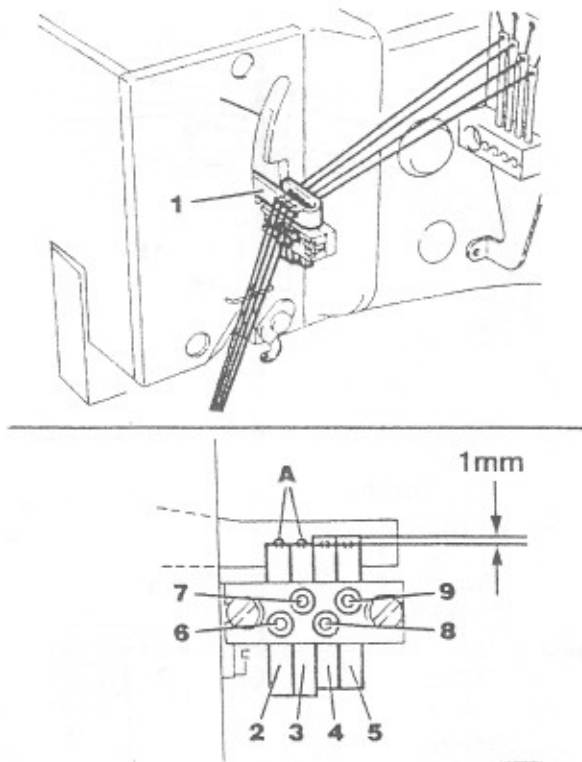
※When adjusting the needle guard, always turn off the power and unplug the machine.

Bring needle thread take-up 1 to the bottom of its travel. Loosen screws 6 and 7. Align the top ends of needle guards 2 and 3 with the centers of eyelets A on needle thread take-up 1 (standard). Tighten screws 6 and 7 temporarily.

Loosen screws 8 and 9. Achieve a distance of 1mm from the top ends of needle thread guards 2 and 3 to those of needle thread guards 4 and 5 by adjusting needle thread guards 4 and 5 (standard). Tighten screws 8 and 9 temporarily.

- ◎To increase the size of the needle thread loop, move up needle guards 2, 3, 4 and 5.
- ◎To decrease the size of the needle thread loop, move down needle guards 2, 3, 4 and 5.

Obtain the proper needle thread loop by moving up or down needle thread guards 2, 3, 4 and 5. After this adjustment tighten screws 6, 7, 8 and 9.



## Adjusting the needle thread guides

There should be a distance of 10mm from the centers of the eyelets on needle thread guides 10 to those on bracket 11.

Adjustment is made by loosening screws 12 and moving up or down needle thread guides 10 (standard). After this adjustment is made, tighten screws 12 temporarily.

⊙To loosen the needle thread, move up needle thread guides 10.

⊙To tighten the needle thread, move down needle thread guides 10.

After this adjustment is made, tighten screws 12.

## Adjusting the needle thread presser spring.

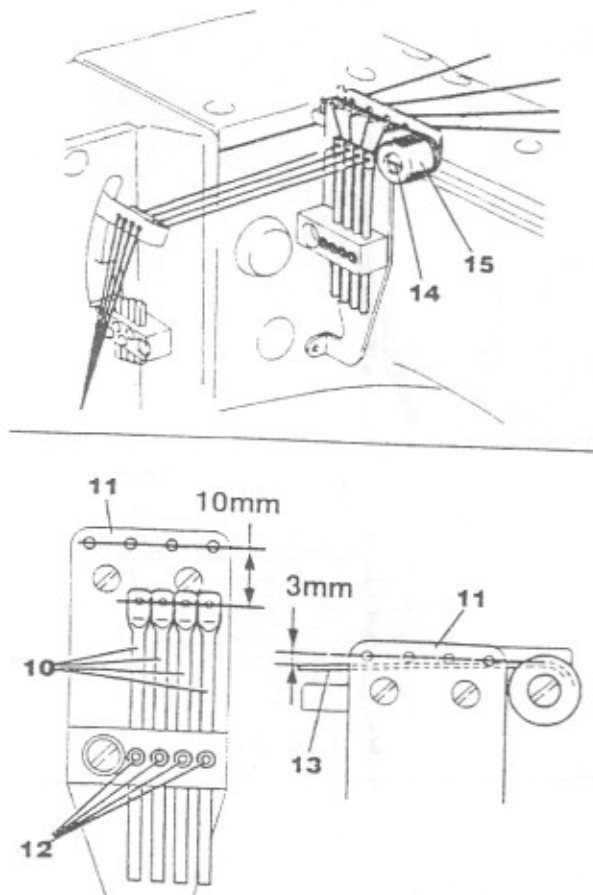
The end of needle thread presser spring 13 should be 3mm lowered from that in the horizontal position.

To make this adjustment, loosen screw 14 and turn knob 15.

After this adjustment is made, tighten screw 14.

※If you want to remove the fabric from the presser foot during sewing, rotate the machine pulley in the reverse direction.

Thanks to needle thread presser spring 13, the needle thread loops are not produced on the front of the needles.





## Adjusting the looper thread take-up

### ⚠ CAUTION

- ※Always turn off the power, unplug the machine and then well-qualified technicians should adjust the looper thread take-up.

Loosen screws 1. Center screw 2 in slot A.

Tighten screw 1 temporarily.

When retainer 4 descends to the position illustrated on the right while the looper is moving to the left from the extreme right end of its travel, the looper thread should cast off from the looper thread take-up at point B.

To make this adjustment, loosen screws 1 and turn looper thread take-up 3 as required.

After this adjustment is made, tighten screws 1.

## Adjusting the looper thread guide

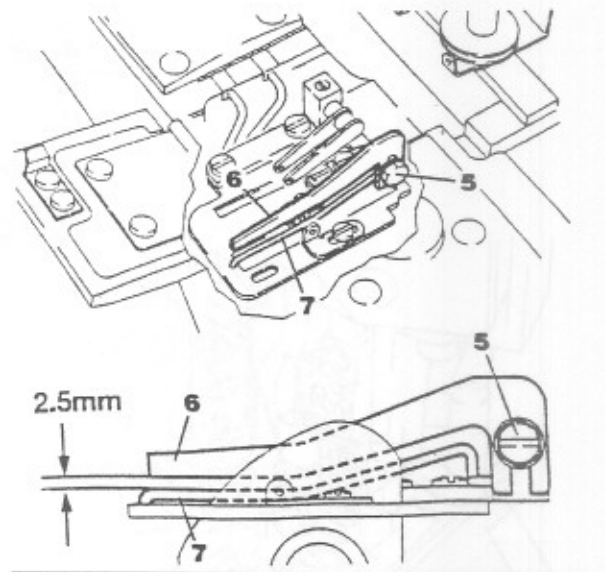
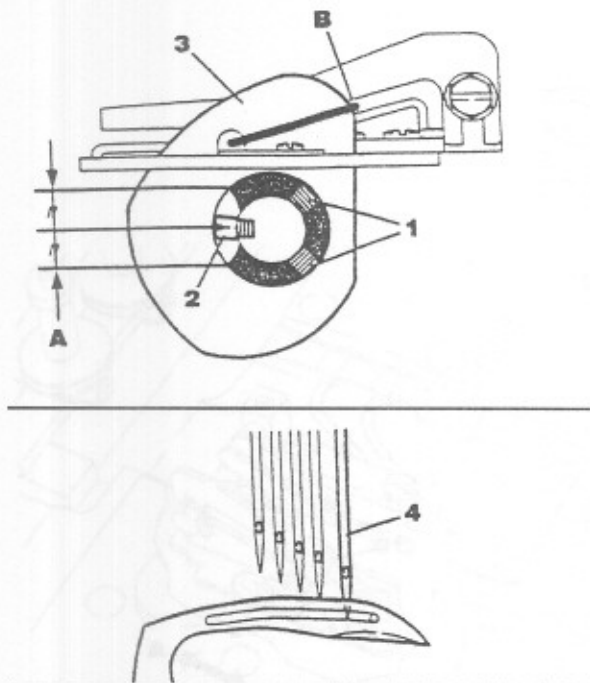
### ⚠ CAUTION

- ※Always turn off the power, unplug the machine and then well-qualified technicians should adjust the looper thread guide.

There should be a 2.5 mm clearance between looper thread guide 6 and looper thread guard 7 (see the illustration on the right).

Adjustment is made by loosening screw 5 and moving looper thread guide 6 up or down.

After this adjustment is made, tighten screw 5.



## Adjusting the looper thread guides

### ⚠ CAUTION

※Always turn off the power, unplug the machine and then well-qualified technicians should adjust the looper thread guides.

Loosen screws 8 and 9. Move looper thread guides 10 and 11 all the way in the direction of A by referring to the illustration on the right (standard). Tighten screws 8 and 9 temporarily.

- ◎To increase the amount of looper thread to be supplied, move looper thread guides 10 and 11 in the direction of B.
- ◎To decrease the amount of looper thread to be supplied, move looper thread guides 10 and 11 in the direction of A.

After this adjustment is made, tighten screws 8 and 9.

## Adjusting the top cover thread take-up

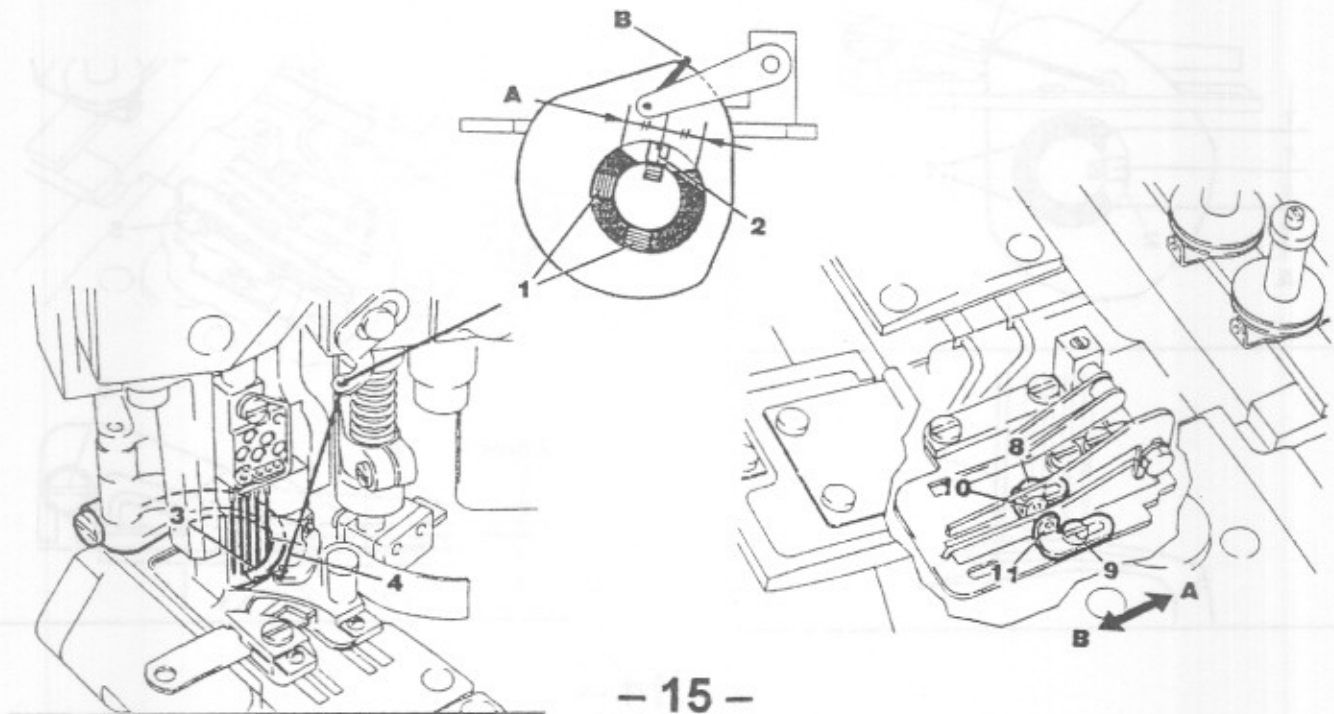
### ⚠ CAUTION

※Always turn off the power, unplug the machine and then well-qualified technicians should adjust the top cover thread take-up.

Loosen screws 1. Center screw 2 in slot A. Tighten screws 1 temporarily.

The top cover thread should cast off from the top cover thread take-up at point B after hook 3 passes over top cover thread 4 while hook 3 travels to the left from the right.

After this adjustment is made, tighten screws 1.



## Adjusting the top cover thread guide

### CAUTION

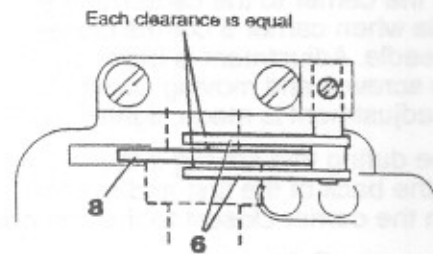
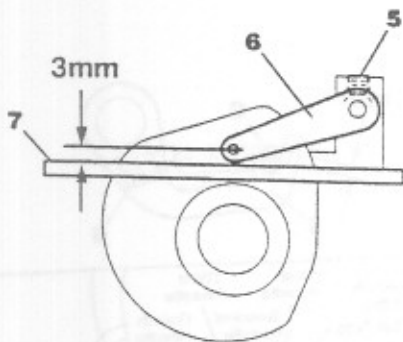
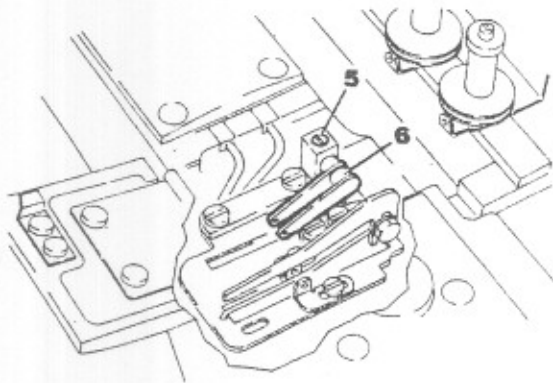
※Always turn off the power, unplug the machine and then well-qualified technicians should adjust the top cover thread guide.

There should be a distance of 3.0mm (standard) from the center of the eyelet on thread guide 6 to the top surface of installation bracket 7.

Adjustment is made by loosening screw 5 and moving thread guide 6. To decrease the amount of top cover thread to be supplied, move up thread guide 6.

After the adjustment tighten screw 5.

※After the above adjustment is made, check to see if each clearance between top cover thread take-up 8 and thread guide 6 is equal.



## Adjusting the hook

### ⚠ CAUTION

※ Always turn off the power, unplug the machine and then well-qualified technicians should adjust the hook.

Bring hook 1 to the extreme right end of its travel. Loosen screw 2.

Achieve a distance of 0.5mm (standard) from hook 1 to retainer 3 (see A in the illustration on the right). After this adjustment is made, tighten screw 2. Check to see during test sewing if top cover thread 4 goes under the hook when the hook moves to the left. If it does not, loosen screw 2 and increase distance A.

After this adjustment is made, slightly press up hook 1. Tighten screw 2.

## Adjusting the carrier

### ⚠ CAUTION

※ Always turn off the power, unplug the machine and then well-qualified technicians should adjust the carrier.

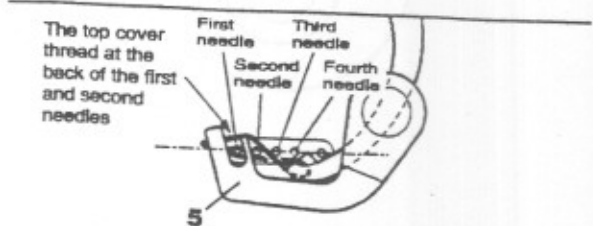
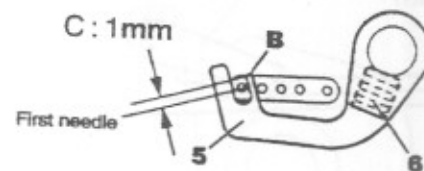
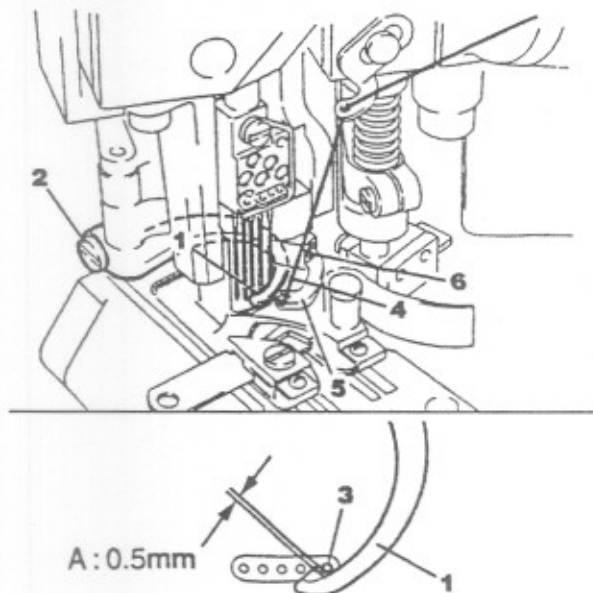
1. There should be a distance of 1mm C from point B of the carrier to the center of the first needle when carrier 5 comes closest to the first needle. Adjustment is made by loosening screw 6 and moving carrier 5. After this adjustment is made, tighten screw 6.

Check to see during test sewing if the top cover thread is at the back of the first and second needles with the carrier closest to the first needle.

If it is not, increase C (be careful that carrier 5 does not contact the first needle).

If the top cover thread reaches the point of the third needle at its back, decrease C.

2. Check to make sure that hook 1 does not contact carrier 5 when they come closest to each other.



## Replacing the presser foot

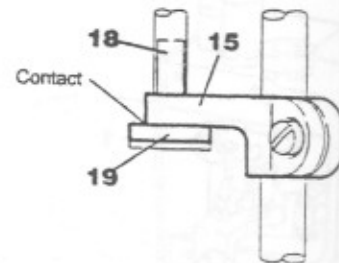
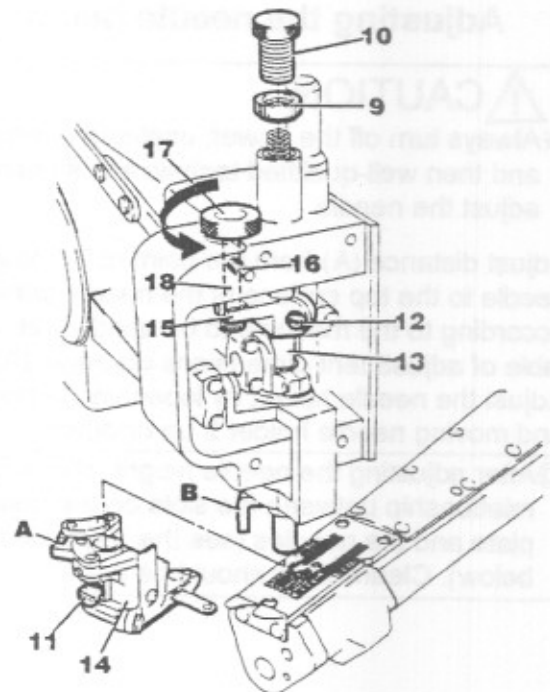
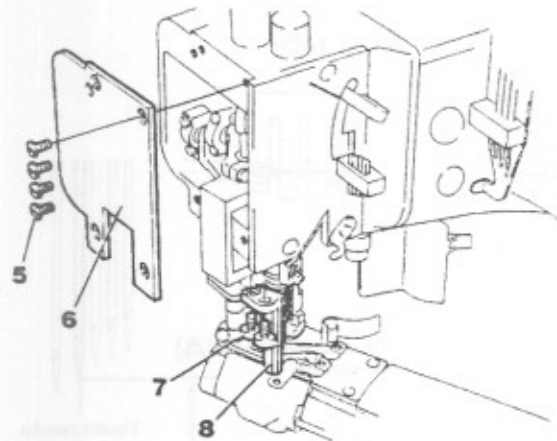
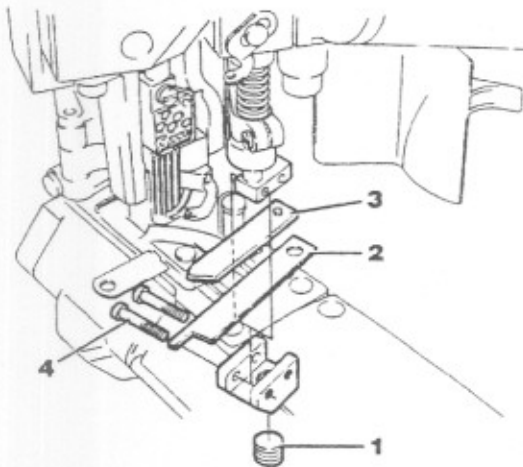
### ⚠ CAUTION

※Always turn off the power, shut down the Compressor and then well-qualified technicians should replace the presser foot.

⚠ Pay close attention to the knife edges not to injure your hands and/or finger.

### Removing the presser foot

1. Bring the needles to the top of their stroke.  
Loosen screw 1. Remove upper knife 2 and auxiliary plate 3 (if it is difficult to remove auxiliary plate 3, loosen screws 4).
2. Remove screws 5, side cover 6, screws 7 and presser foot guide (left) 8.
3. Loosen nut 9 and remove adjustment screw 10.  
Loosen screws 11 and 12. Raise presser bar 13 until it is removed from the presser foot.
4. Remove the presser foot.



## Reinstalling the presser foot

Reinstall the presser foot by following the removal steps in reverse.

- ⊙ When reinstalling the presser foot, fit crank shaft B into segment A. Check to see if the presser foot is parallel with the feed dogs.
- ⊙ Presser foot guide (left) 8 should not move left to right, but slightly move up and down after it is reinstalled.
- ⊙ To reinstall presser bar guide 15, reinstall adjustment screw 10 and bring the presser foot to its lowest position first. Bring guide pin 18 to its lowest position by loosening screw 16 and turning adjustment screw 17 counterclockwise. Check to see if presser bar guide 15 contacts cushion rubber 19 on the guide pin.

Adjust the knives by referring to "Replacing the knives" (see page 20).

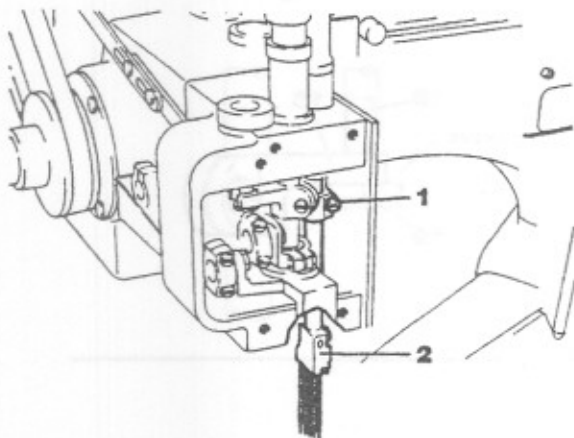
## Adjusting the needle height

### ⚠ CAUTION

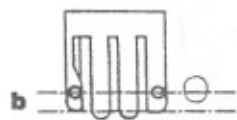
※ Always turn off the power, unplug the machine and then well-qualified technicians should adjust the needle

Adjust distance (A) from the point of the fourth needle to the top surface of the needle plate according to the machine to be used (see the table of adjustment dimensions on page 29). Adjust the needle height by loosening screw 1 and moving needle holder 2 up or down.

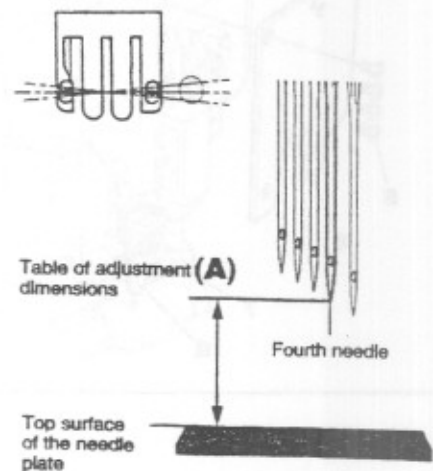
⊙ After adjusting the needle height, check for the relationship between the slots on the needle plate and the needles (see the illustration below). Clearance b should be equal.



OK!



NO!



## Adjusting the looper

### ⚠ CAUTION

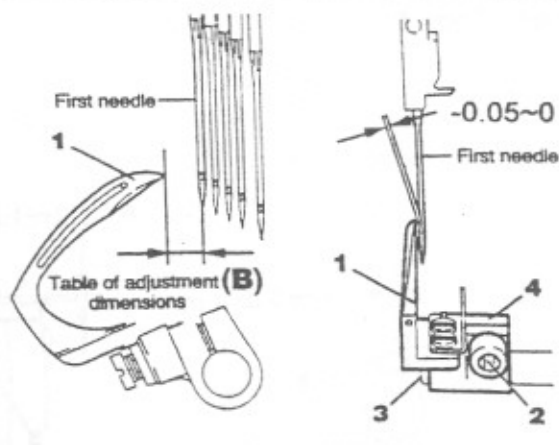
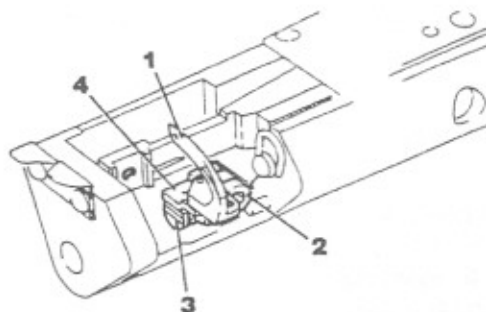
※Always turn off the power, unplug the machine and then well-qualified technicians should adjust the looper.

#### 1. To adjust the looper-needle setting distance

When looper 1 is at the extreme left end of its travel, adjust looper-needle setting distance B from the center of the first needle to the point of the looper according to the machine to be used (see the table of adjustment dimensions on page 29). Adjustment is made by loosening screw 2 and moving looper holder 4 to the left or right. After this adjustment is made, tighten screw 2 temporarily.

#### 2. To adjust the looper front to back

When the point of the looper reaches the center of the first needle from the extreme left end of its travel, there should be a front-to-back distance of  $-0.05\sim 0\text{mm}$  from the first needle to the point of the looper. Adjustment is made by turning screw 3 and moving the looper holder front to back. After this adjustment is made, tighten screw 2.



### Adjusting the needle guard (rear)

#### ⚠ CAUTION

※Always turn off the power, unplug the machine and then well-qualified technicians should adjust the needle guard (rear).

When rear needle guard 1 comes closest to the first needle, there should be a clearance of 0~0.2mm between rear needle guard 1 and the first needle. Adjustment is made by loosening screw 2 and moving the rear needle guard front to back. After this adjustment is made, tighten screw 2.

### Adjusting the looper guard

#### ⚠ CAUTION

※Always turn off the power, unplug the machine and then well-qualified technicians should adjust the looper guard.

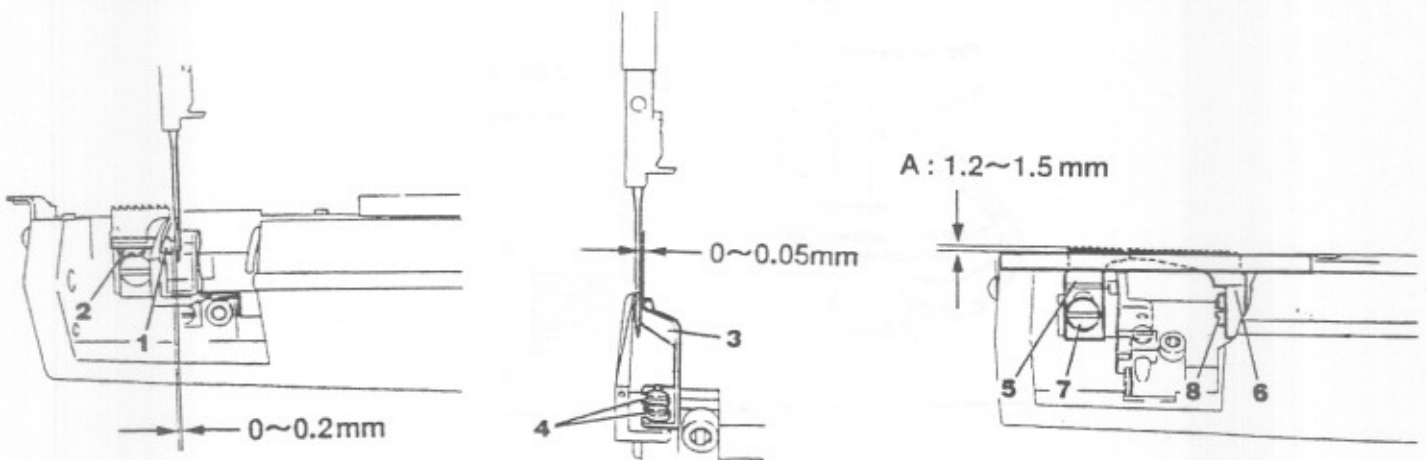
When looper guard 3 comes closest to the first needle, there should be a clearance of 0 ~ 0.05 mm between looper guard 3 and the first needle. Adjustment is made by loosening screws 4 and moving the looper guard front to back. After this adjustment is made, tighten screws 4.

### Adjusting the feed dog height

#### ⚠ CAUTION

※Always turn off the power, unplug the machine and then well-qualified technicians should adjust the feed dog height.

When the feed dogs are at their highest point of travel, there should be a distance of 1.2~1.5mm from the top surface of the needle plate to extended line A from the tips of main 5 and differential 6 feed dogs. Adjustment is made by loosening screws 7 and 8, and moving feed dogs 5 and 6 up or down. After the above adjustment, tighten screws 7 and 8.

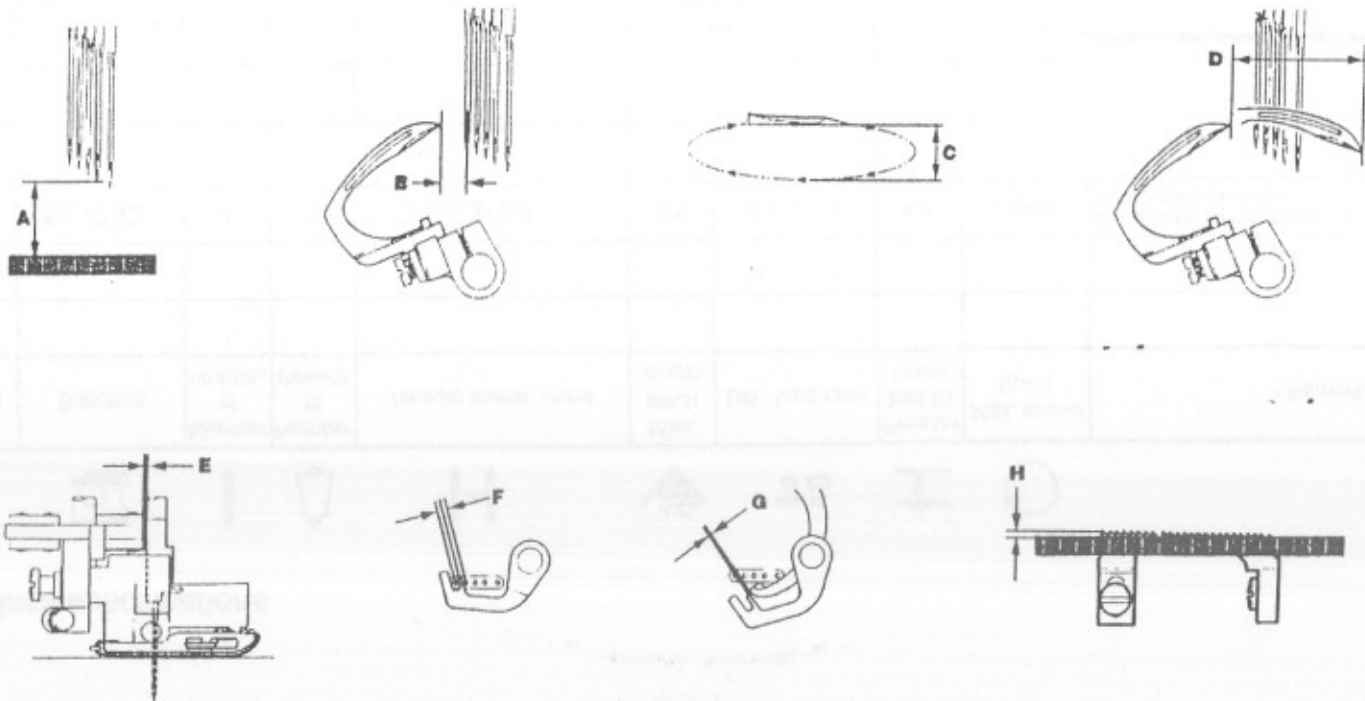




# Adjustment dimensions

( mm )

Subclass	x□□□	Needle heightg (Fourth needle)  (A)	Looper			Carrier			Main feed dog height  (H)
			Looper-needle setting distance  (B)	Front-to-back movement  (C)	Travel  (D)	Distance to the needle holder  (E)	Position  (F)	Distance to the hook  (G)	
SL-701 SL-703 SL-713	452	13.6mm	4.3~4.5mm	2.3~2.4mm	24.9mm	0.4mm	Middle of the first and second needles	0.4~0.7mm	1.2~1.5mm
	460	13.3mm	4.1~4.3mm	2.3~2.4mm	24.9mm	0.4mm		0.4~0.7mm	



# SL-700 Series subclass specifications

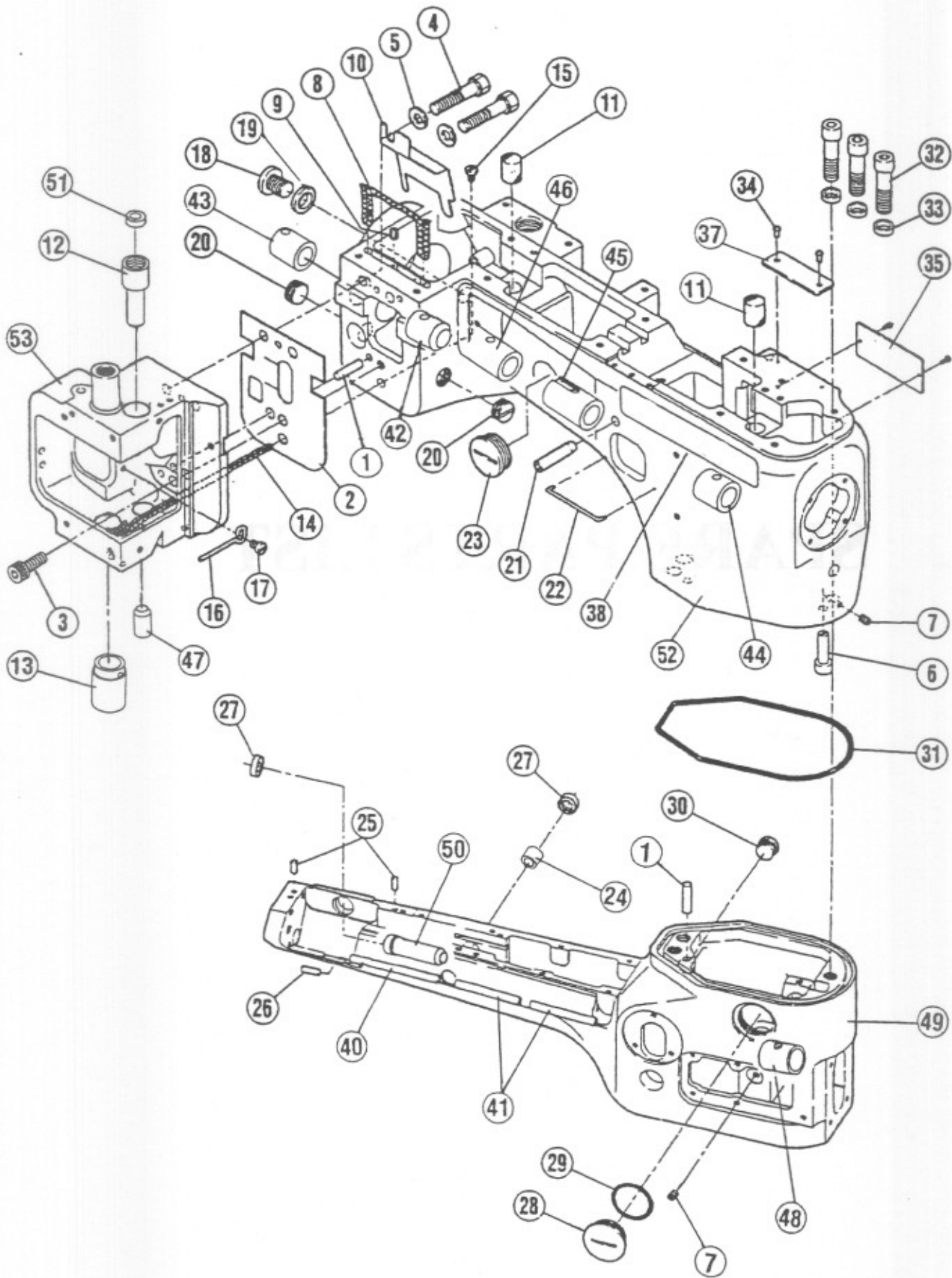
## SL-700 Series



Application	Fabric weight	Subclass	Number of needles	Number of threads	Needle space (mm)	Max. stitch length	Diff. feed ratio	Presser foot lift (mm)	Max. speed (rpm)	Remarks
Flatseaming										
	light-medium	SL-703	4	6	5.2·6.0	2.5	0.7~1.5	5.5	4,200	Double edge trimming, with a groove 3.3mm deep on the back of the presser foot
										Knives located toward the operator, double edge trimming

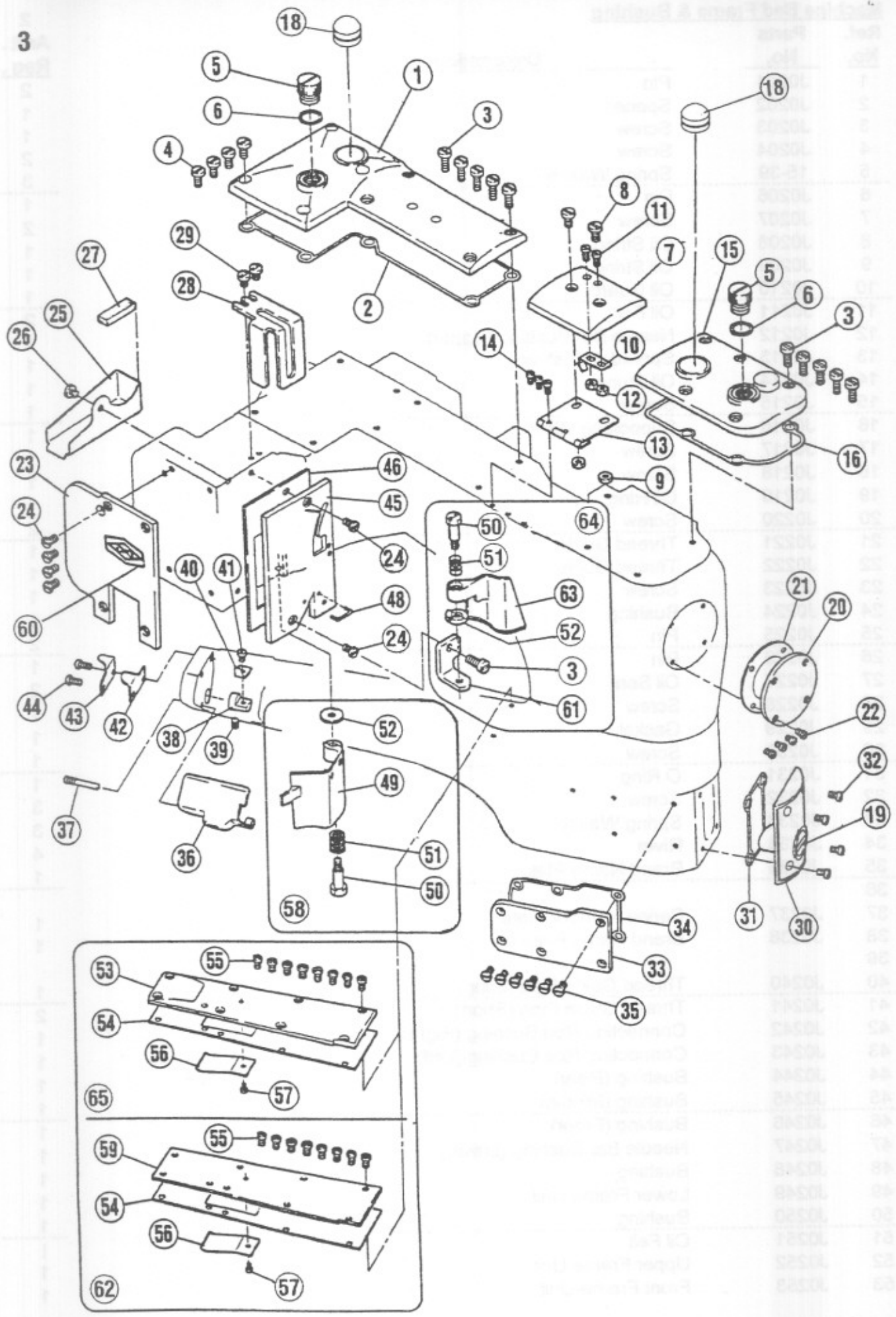


# SPARE PARTS LIST



**Machine Bed Frame & Bushing**

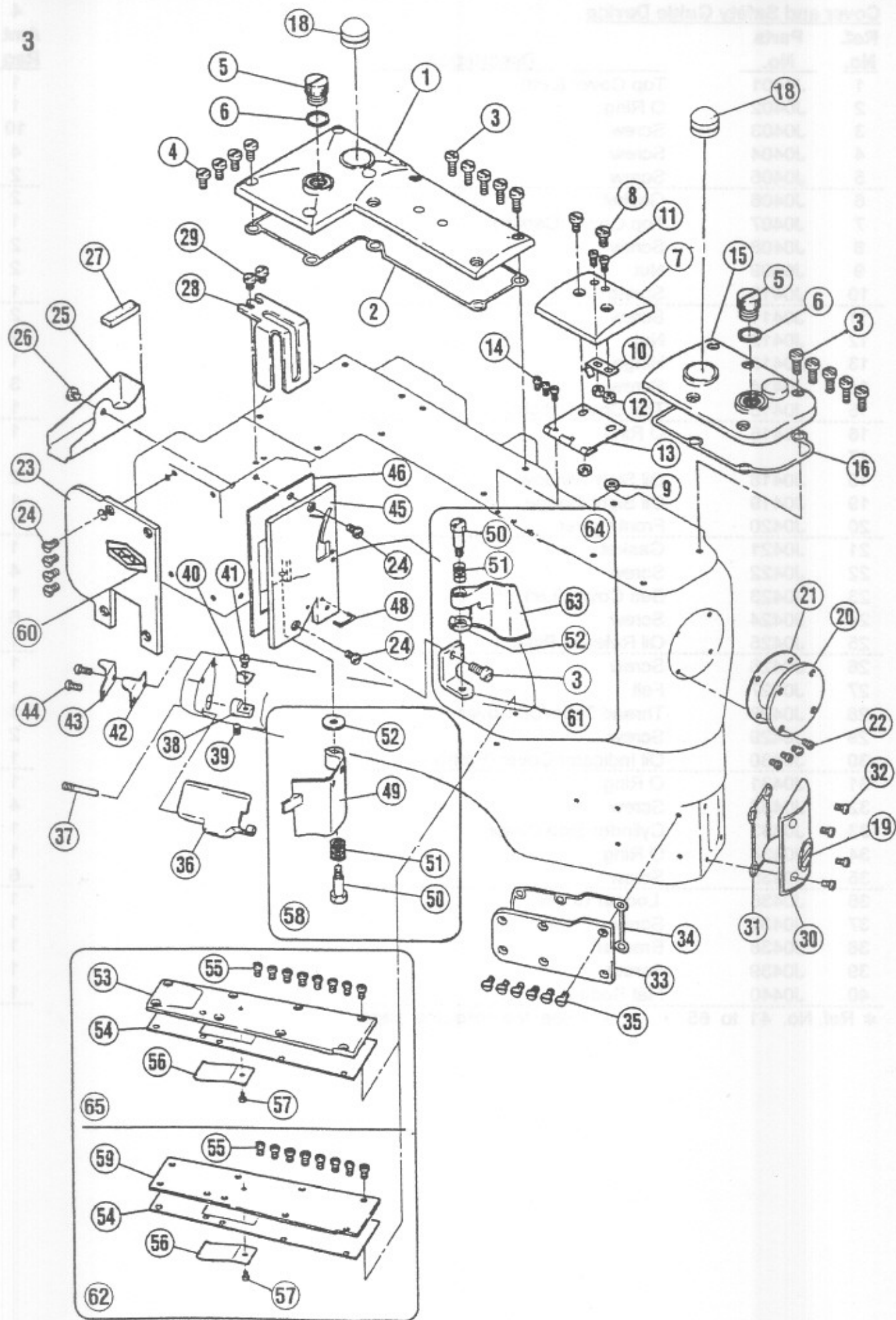
Ref. No.	Parts No.	Description	Amt. Req.
1	J0201	Pin	2
2	J0202	Spacer	1
3	J0203	Screw	1
4	J0204	Screw	2
5	15-39	Spring Washer	3
6	J0206	Pin	1
7	J0207	Screw	2
8	J0208	Oil String	1
9	J0209	Oil String	1
10	J0210	Oil Guard	1
11	J0211	Oil Felt	2
12	J0212	Needle Bar Bushing (Upper)	1
13	J0213	Spreader Bushing	1
14	J0214	Oil String	1
15	J0215	Screw	1
16	J0216	Supporting Wire	1
17	J0217	Screw	1
18	J0218	Screw	1
19	J0219	Oil Ring	1
20	J0220	Screw	2
21	J0221	Thread Guide	1
22	J0222	Thread Guide	1
23	J0223	Screw	1
24	J0224	Bushing	1
25	J0225	Pin	2
26	J0226	Pin	1
27	J0227	Oil Seal	2
28	J0228	Screw	1
29	J0229	Gasket	1
30	J0230	Screw	1
31	J0231	O Ring	1
32	J0232	Screw	3
33	J0233	Spring Washer	3
34	J0234	Rivet	4
35	J0235	Brand Name Plate	1
36			
37	J0237	Series Number Plate	1
38	J0238	Brand Name Plate	1
39			
40	J0240	Thread Guide Pipe (Long)	1
41	J0241	Thread Guide Pipe (Short)	2
42	J0242	Connecting Rod Bushing (Right)	1
43	J0243	Connecting Rod Bushing (Left)	1
44	J0244	Bushing (Rear)	1
45	J0245	Bushing (Middle)	1
46	J0246	Bushing (Front)	1
47	J0247	Needle Bar Bushing (Lower)	1
48	J0248	Bushing	1
49	J0249	Lower Frame Unit	1
50	J0250	Bushing	1
51	J0251	Oil Felt	1
52	J0252	Upper Frame Unit	1
53	J0253	Front Frame Unit	1



**Cover and Safety Guide Device**

<b>Ref. No.</b>	<b>Parts No.</b>	<b>Description</b>	<b>4 Amt. Req.</b>
1	J0401	Top Cover (Left)	1
2	J0402	O Ring	1
3	J0403	Screw	10
4	J0404	Screw	4
5	J0405	Screw	2
6	J0406	Gasket	2
7	J0407	Top Cover (Center)	1
8	J0408	Screw	2
9	J0409	Nut	2
10	J0410	Spring	1
11	J0411	Screw	2
12	J0412	Nut	2
13	J0413	Hinge	1
14	J0414	Screw	3
15	J0415	Top Cover (Right)	1
16	J0416	O Ring	1
17			
18	J0418	Oil Sigh Window	2
19	J0419	Oil Sight Gauge	1
20	J0420	Front Cover	1
21	J0421	Gasket	1
22	J0422	Screw	4
23	J0423	Bed Cover (Left)	1
24	J0424	Screw	6
25	J0425	Oil Release Plate	1
26	J0426	Screw	1
27	J0427	Felt	1
28	J0428	Thread Take-Up Cover	1
29	J0429	Screw	2
30	J0430	Oil Indicator Cover (Front)	1
31	J0431	O Ring	1
32	J0432	Screw	4
33	J0433	Cylinder Side Cover	1
34	J0434	O Ring	1
35	J0435	Screw	6
36	J0436	Looper Cover	1
37	J0437	Screw	1
38	J0438	Bracket	1
39	J0439	Screw	1
40	J0440	Flat Spring	1

\* Ref. No. 41 to 65 . . . . See the following page

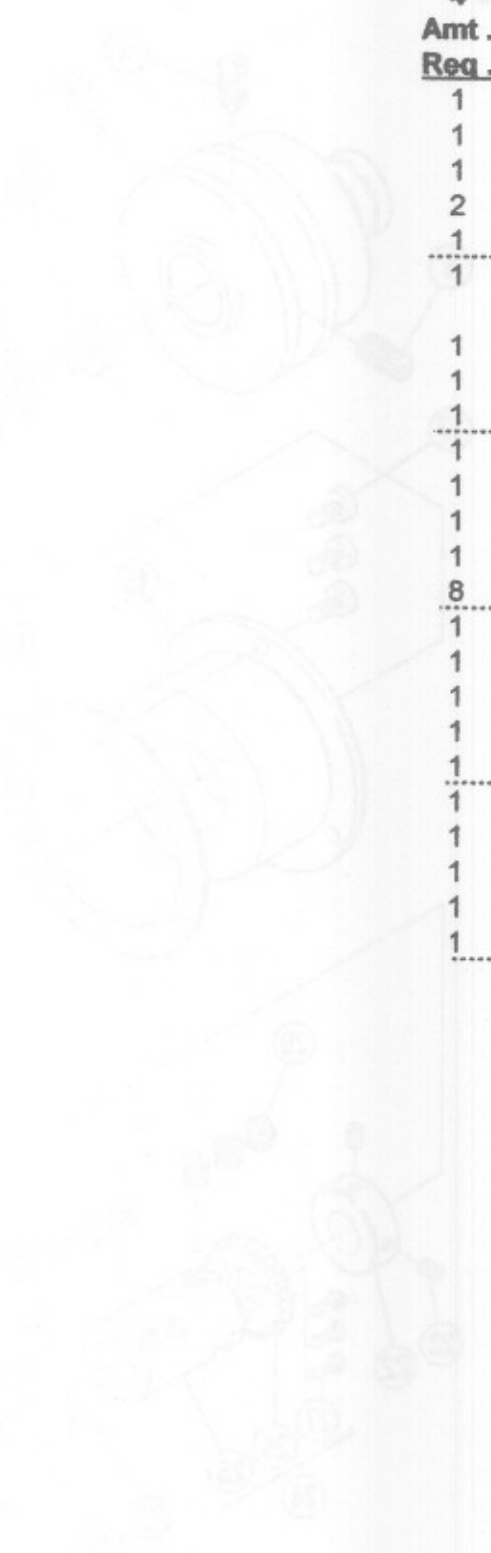




**Outer Covers and Safety Guide Device**

<b>Ref. No.</b>	<b>Parts No.</b>	<b>Description</b>	<b>4 Amt. Req.</b>
41	J0441	Screw	1
42	J0442	Chain Cutter	1
43	J0443	Chain Cutter Guard	1
44	J0444	Screw	2
45	J0445	Bed Cover (Front)	1
46	J0446	Gasket	1
47			
48	J0448	Needle Thread Guide	1
49	J0449	Finger Guide	1
50	J0450	Screw	1
51	J0451	Spring	1
52	J0452	Location Ring	1
53	J0453	Single Trimming Bed	1
54	J0454	Gasket	1
55	J0455	Screw	8
56	J0456	Spring	1
57	J0457	Screw	1
58	J0458	Safety Cover Assy (Short)	1
59	J0459	Lower Base Cover	1
60	J0460	Brand Name Plate	1
61	J0461	Bracket	1
62	J0462	Trimming Lower Base Cover Assy	1
63	J0463	Finger Safety Guide	1
64	J0464	Safety Cover Assy (Long)	1
65	J0465	Single Trimming Bed Assy	1

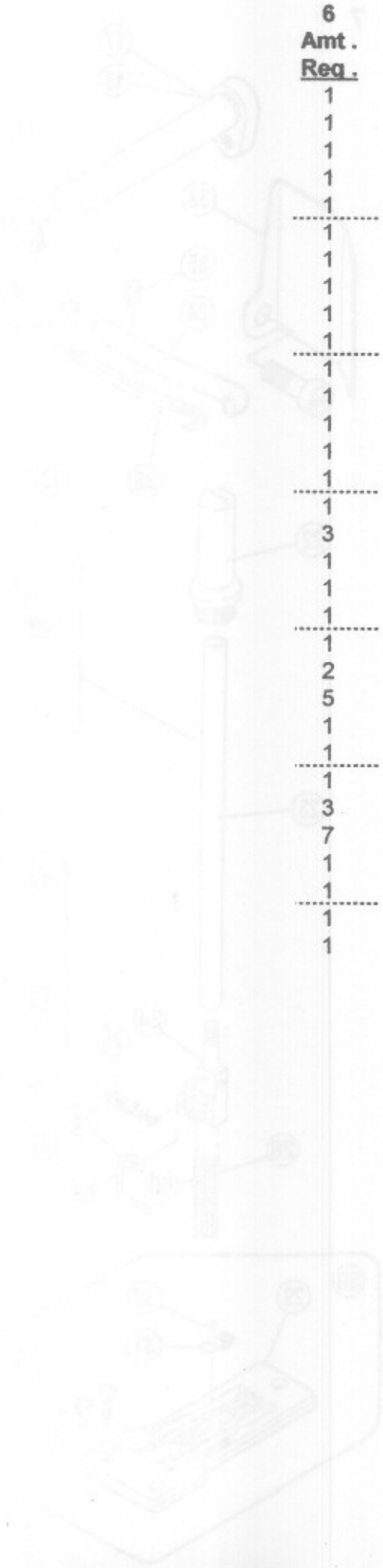
\*Ref. No. 1 to 40 . . . . See the preceding page.

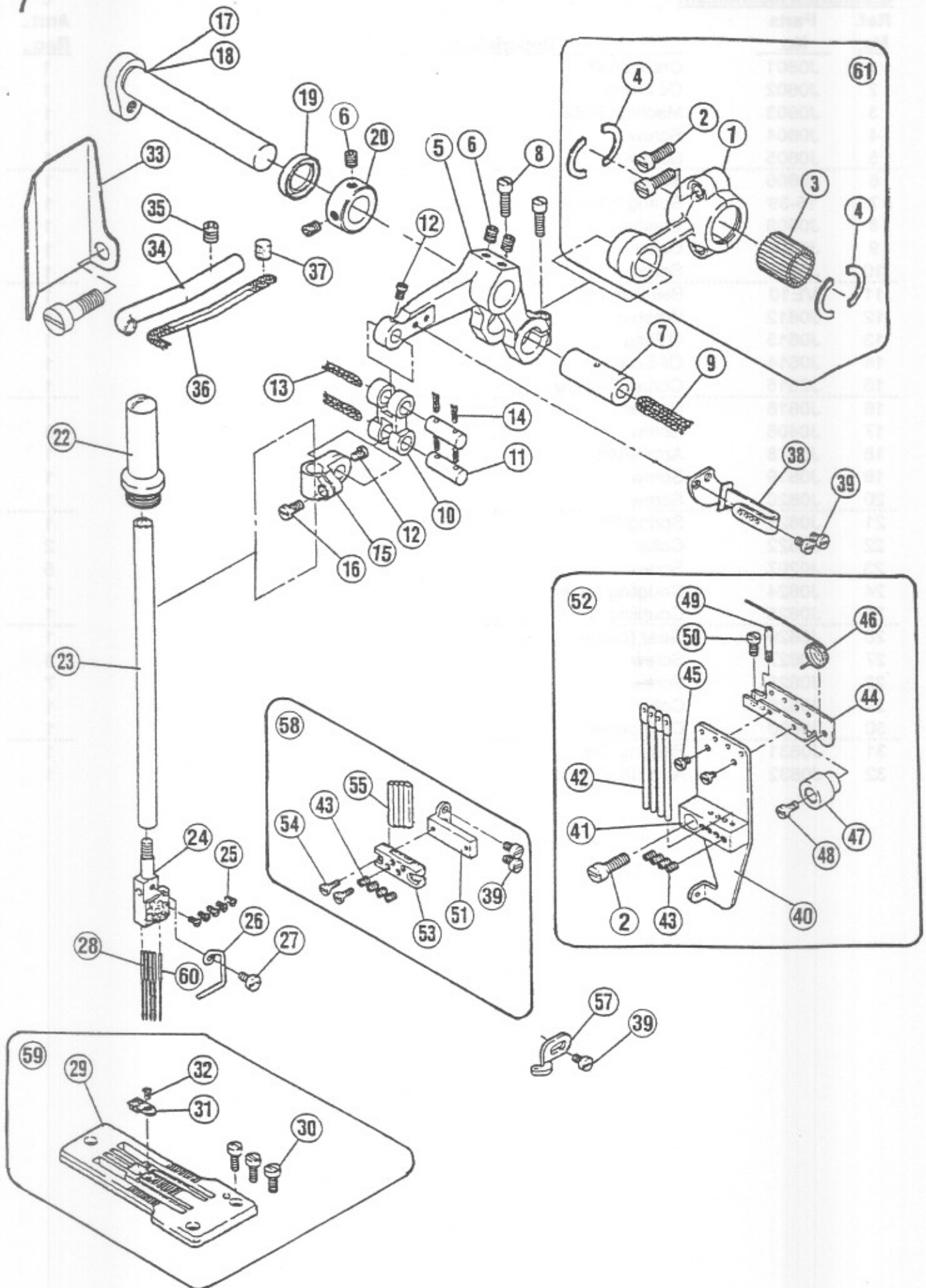




### Crankshaft Mechanism

Ref. No.	Parts No.	Description	6 Amt. Req.
1	J0601	Crankshaft	1
2	J0602	Oil String	1
3	J0603	Machine Pulley	1
4	J0604	Screw	1
5	J0605	Screw	1
6	J0606	Screw	1
7	15-39	Spring Washer	1
8	J0608	Washer	1
9	J0609	Collar	1
10	J0610	Screw	1
11	VE10	Ball Bearing	1
12	J0612	Washer	1
13	J0613	O Ring	1
14	J0614	Oil Seal	1
15	J0615	Connecting Rod	1
16	J0616	Gasket	1
17	J0408	Screw	3
18	J0618	Arm Shaft	1
19	J0619	Screw	1
20	J0620	Screw	1
21	J0621	Spring Pin	1
22	J0622	Collar	2
23	J0207	Screw	5
24	J0624	Coupling Assy	1
25	J0625	Coupling	1
26	J0626	Gear (Large)	1
27	J0627	Screw	3
28	J0628	Screw	7
29	J0629	Collar	1
30	J0630	Oil Stopper	1
31	J0631	Bearing Set	1
32	J0632	Arm Shaft Assy	1

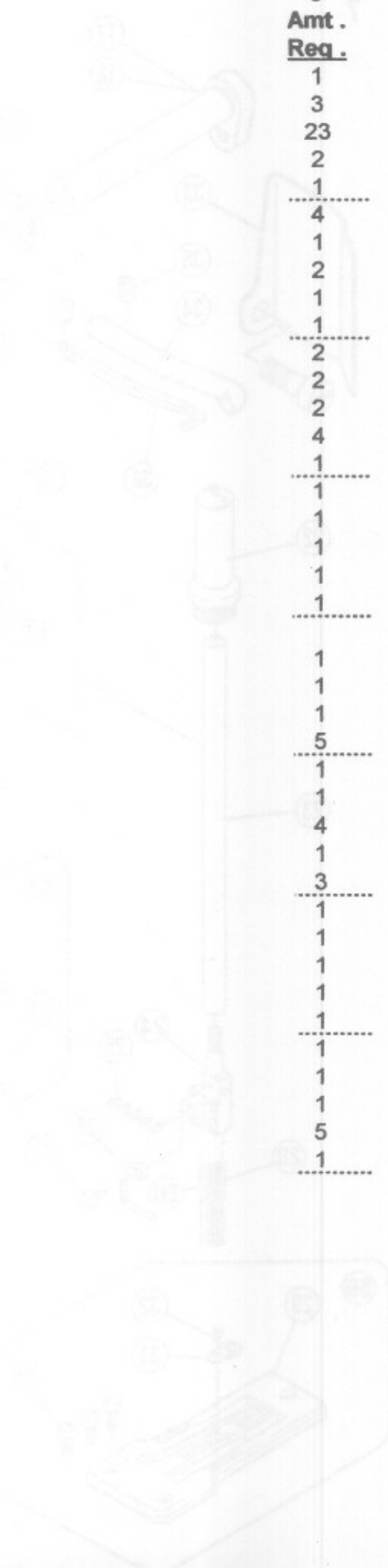


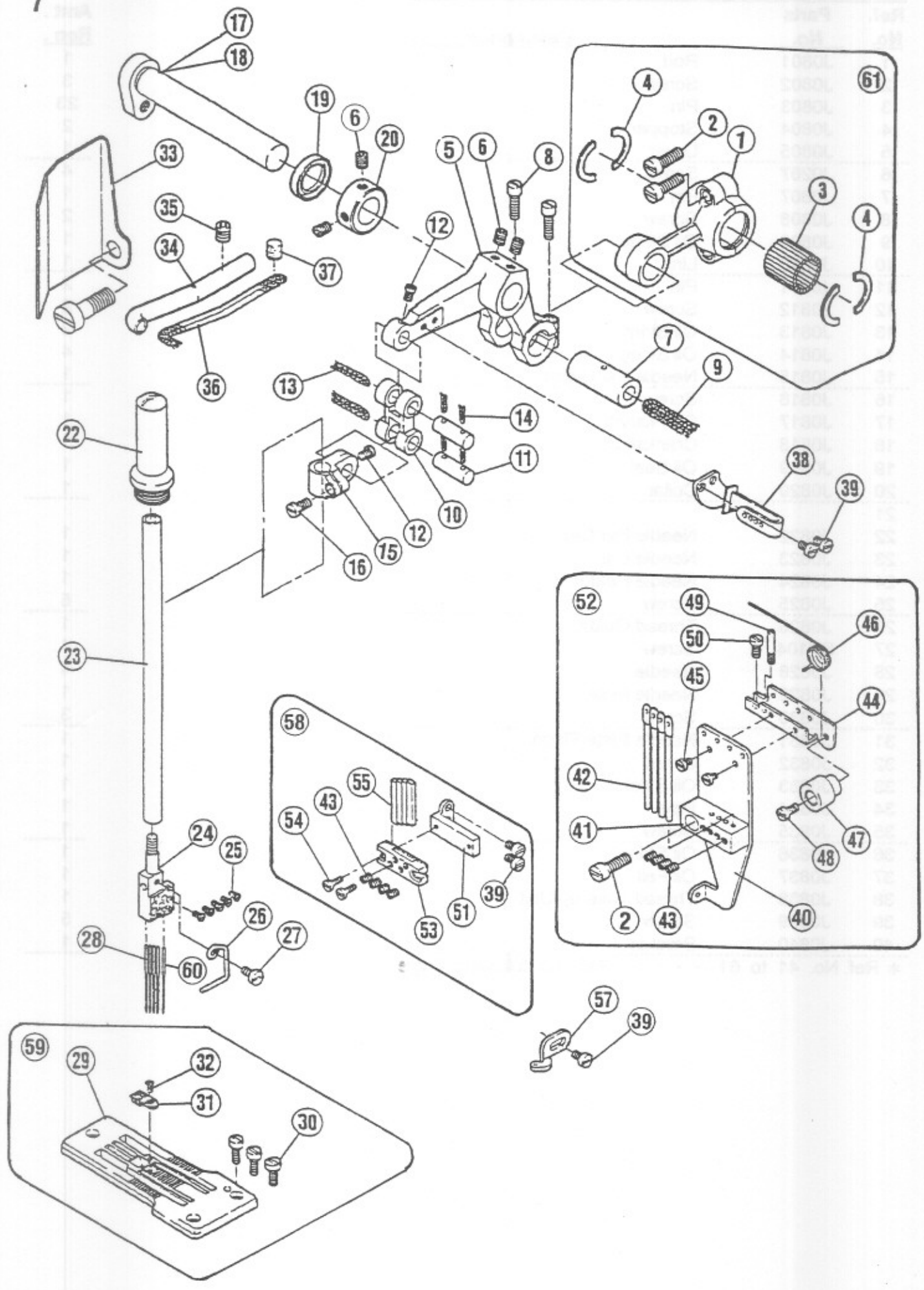


**Needle Drive Mechanism & Spreader Thread Handling**

Ref. No.	Parts No.	Description	8 Amt. Req.
1	J0801	Rod	1
2	J0802	Screw	3
3	J0803	Pin	23
4	J0804	Stopper	2
5	J0805	Lever	1
-----			
6	J0207	Screw	4
7	J0807	Pin	1
8	J0808	Screw	2
9	J0809	Oil String	1
10	J0810	Link	1
-----			
11	J0811	Pin	2
12	J0812	Screw	2
13	J0813	Oil String	2
14	J0814	Oil String	4
15	J0815	Needle Bar Clamp	1
-----			
16	J0816	Screw	1
17	J0817	Crankshaft	1
18	J0818	Crankshaft	1
19	J0819	Oil Seal	1
20	J0820	Collar	1
-----			
21			
22	J0822	Needle Bar Cap	1
23	J0823	Needle Bar	1
24	J0824	Needle Holder	1
25	J0825	Screw	5
-----			
26	J0826	Thread Guide	1
27	SV104	Screw	1
28	J0828	Needle	4
29	J0829	Needle Plate	1
30	J0830	Screw	3
-----			
31	J0831	Needle Plate Finger	1
32	J0832	Screw	1
33	J0833	Oil Shield	1
34	J0834	Pipe	1
35	J0835	Screw	1
-----			
36	J0836	Oil String	1
37	J0837	Oil Felt	1
38	J0838	Thread Take-up Unit	1
39	J0839	Screw	5
40	J0840	Bracket	1

\* Ref. No. 41 to 61 . . . . . See the following page



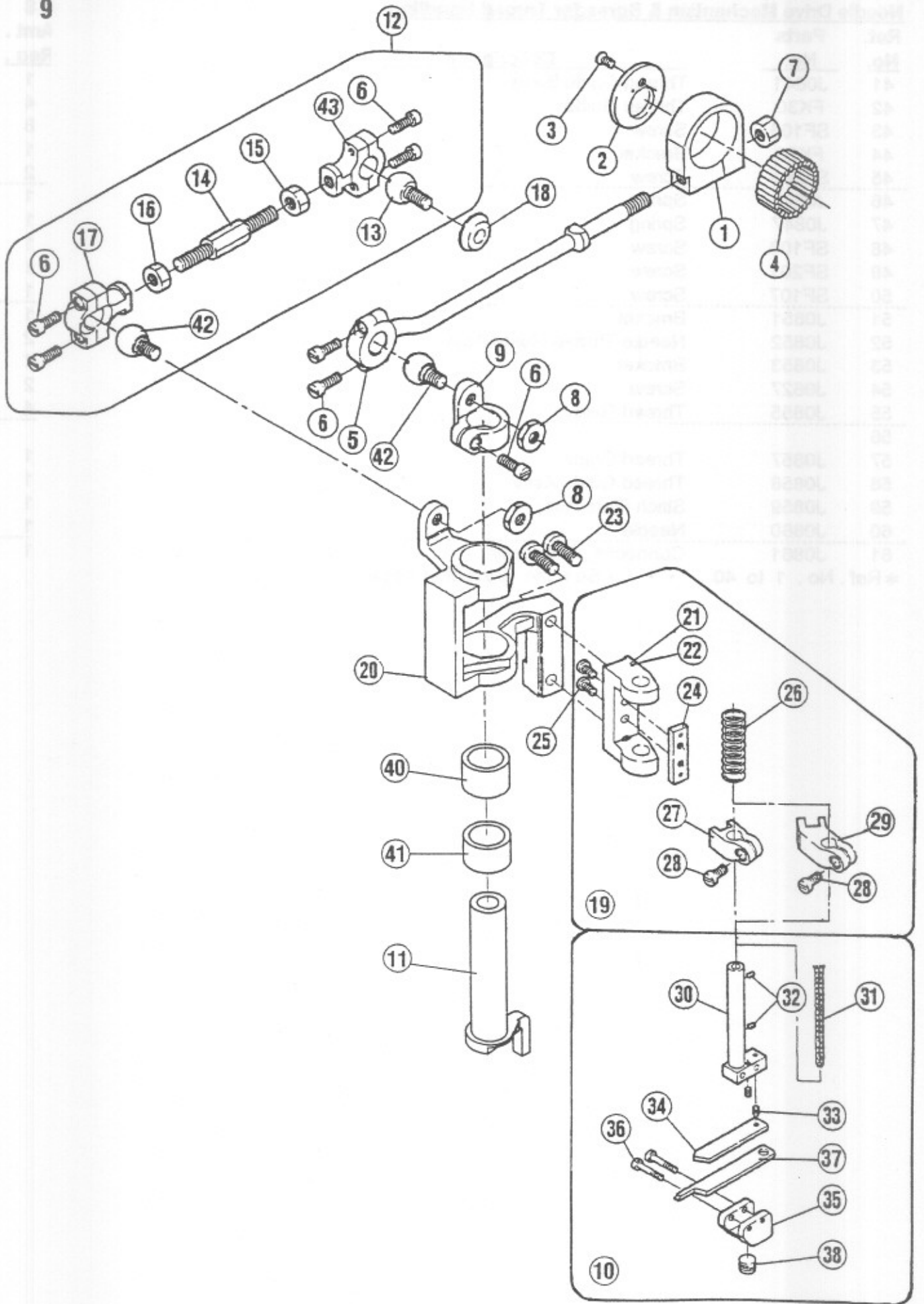


**Needle Drive Mechanism & Spreader Thread Handling**

Ref. No.	Parts No.	Description	8 Amt. Req.
41	J0841	Thread Guide Base	1
42	FK30	Thread Guide	4
43	SF106	Screw	8
44	FK29	Bracket	1
45	SF205	Screw	2
-----			
46	J0846	Spring	1
47	J0847	Spring	1
48	SF108	Screw	1
49	SF201	Screw	1
50	SF107	Screw	1
-----			
51	J0851	Bracket	1
52	J0852	Needle Thread Guide Assy	2
53	J0853	Bracket	1
54	J0627	Screw	2
55	J0855	Thread Guide	4
-----			
56			
57	J0857	Thread Guide	1
58	J0858	Thread Guide Assy	1
59	J0859	Stitch Plate Assy	1
60	J0860	Needle	1
-----			
61	J0861	Connecting Unit Assy	1

\* Ref. No. 1 to 40 . . . . . See the preceding page.

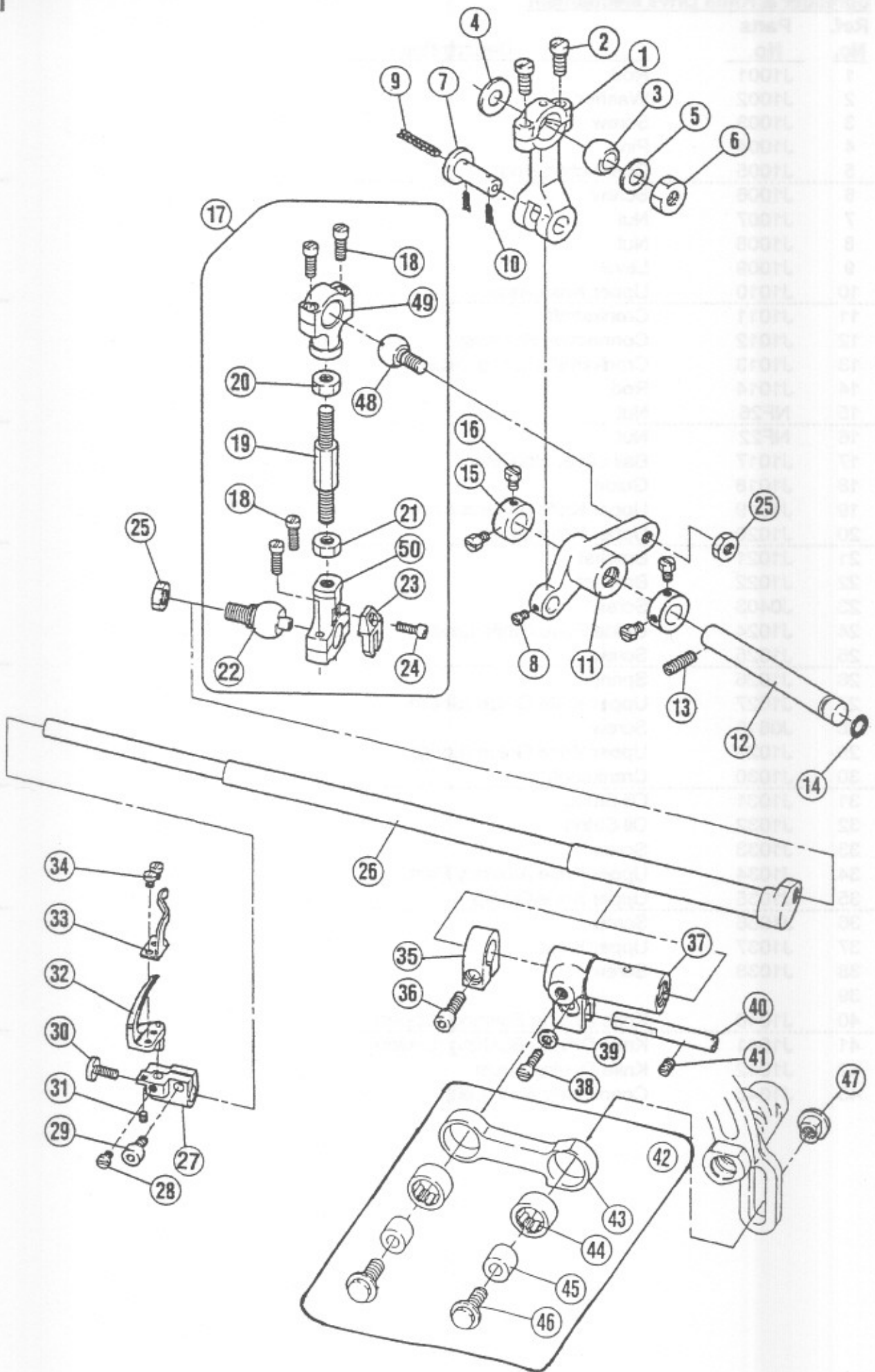






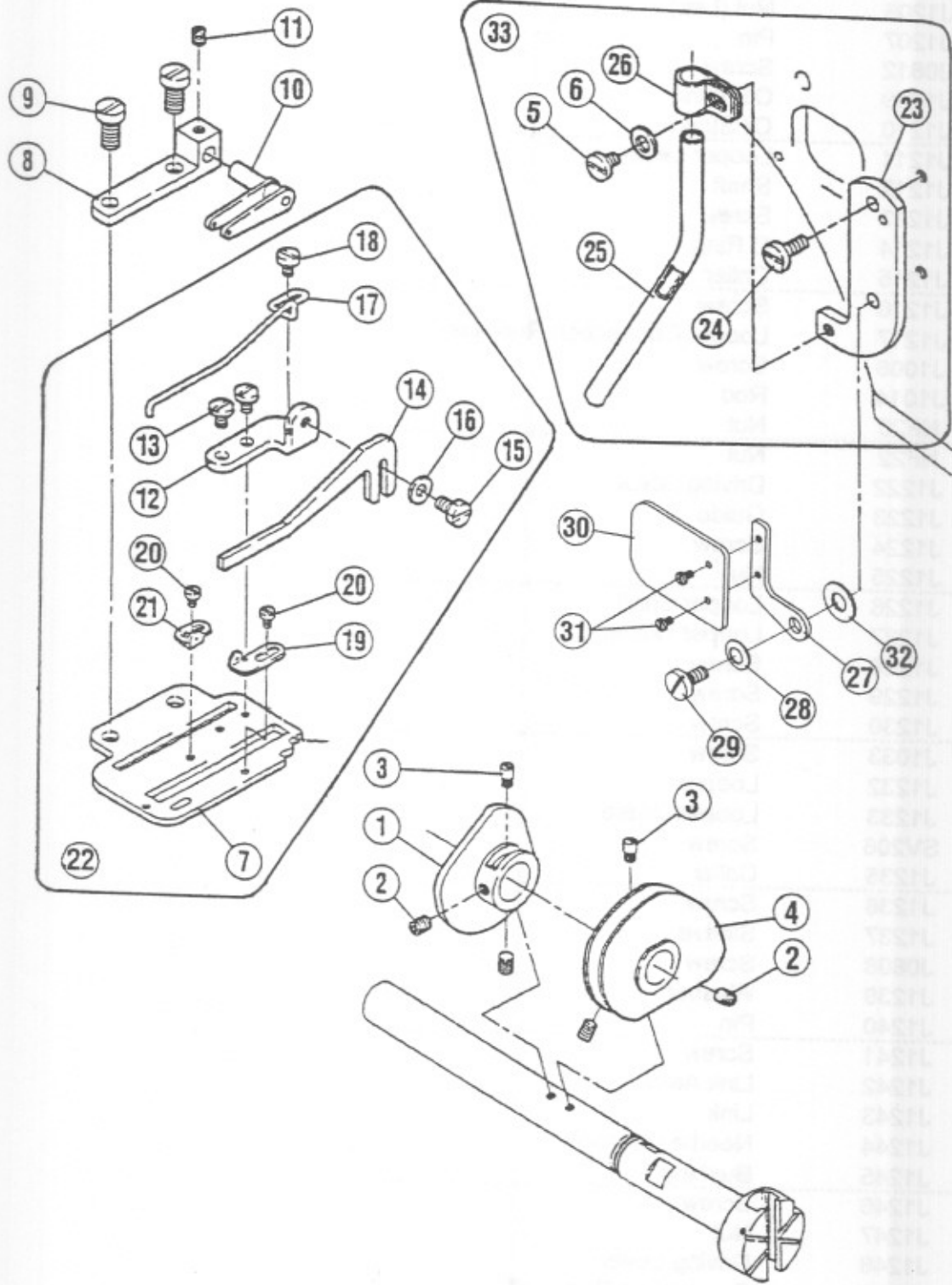
**Spreader & Knife Drive Mechanism**

<b>Ref. No.</b>	<b>Parts No.</b>	<b>Description</b>	<b>10 Amt. Req.</b>
1	J1001	Rod	1
2	J1002	Washer	1
3	J1003	Screw	1
4	J1004	Pin	27
5	J1005	Connection Rod	1
6	J1006	Screw	8
7	J1007	Nut	1
8	J1008	Nut	2
9	J1009	Lever	1
10	J1010	Upper Knife Assy	1
11	J1011	Crankshaft	1
12	J1012	Connection Bar Assy	1
13	J1013	Crankshaft Driving Lever	1
14	J1014	Rod	1
15	NF26	Nut	1
16	NF22	Nut	1
17	J1017	Ball Lever Housing	1
18	J1018	Guide	1
19	J1019	Upper Knife Bracket Assy	1
20	J1020	Upper Knife Lever	1
21	J1021	Bracket	1
22	J1022	Bracket	1
23	J0403	Screw	2
24	J1024	Guide Plate (Knife Lever)	1
25	J1025	Screw	2
26	J1026	Spring	1
27	J1027	Upper Knife Guide (Short)	1
28	J0816	Screw	2
29	J1029	Upper Knife Guide (Long)	1
30	J1030	Crankshaft	1
31	J1031	Oil String	1
32	J1032	Oil String	2
33	J1033	Screw	2
34	J1034	Upper Knife Auxiliary Plate	1
35	J1035	Upper Knife Clamp	1
36	J1036	Screw	2
37	J1037	Upper Knife	1
38	J1038	Screw	1
39			
40	J1040	Knife Driving Bushing (Upper)	1
41	J1041	Knife Driving Bushing (Lower)	1
42	J1042	Knife Driving Lever	2
43	J1043	Connecting Rod (Left)	1



**Looper Drive Mechanism**

<b>Ref. No.</b>	<b>Parts No.</b>	<b>Description</b>	<b>12 Amt. Req.</b>
1	J1201	Looper Connection Rod	1
2	SV312	Screw	2
3	J1203	Driving Lever	1
4	J1204	Washer	1
5	J0205	Washer	1
6	J1206	Nut (Left)	1
7	J1207	Pin	1
8	J0812	Screw	1
9	J1209	Oil String	1
10	J1210	Oil String	2
11	J1211	Looper Lever	1
12	J1212	Shaft	1
13	J1213	Screw	1
14	J1214	O Ring	1
15	J1215	Collar	2
16	J1216	Screw	4
17	J1217	Looper Connection Rod Assy	1
18	J1006	Screw	4
19	J1014	Rod	1
20	NF26	Nut	1
21	NF22	Nut	1
22	J1222	Driving Lever	1
23	J1223	Guide	1
24	J1224	Screw	1
25	J1225	Nut	2
26	J1226	Looper Shaft	1
27	J1227	Looper Holder	1
28	J1228	Screw	1
29	J1229	Screw	1
30	J1230	Screw	1
31	J1033	Screw	1
32	J1232	Looper	1
33	J1233	Looper Guard	1
34	SV206	Screw	2
35	J1235	Collar	1
36	J1236	Screw	1
37	J1237	Sleeve	1
38	J0808	Screw	1
39	J1239	Washer	1
40	J1240	Pin	1
41	J1241	Screw	1
42	J1242	Link Assy	1
43	J1243	Link	1
44	J1244	Needle Bearing	2
45	J1245	Bushing	2
46	J1246	Screw	2
47	J1247	Nut	1
48	J1248	Driving Lever	1
49	J1043	Connecting Rod (Left)	1
50	J1250	Connecting Rod	1



**Top Cover & Looper Thread Handling**

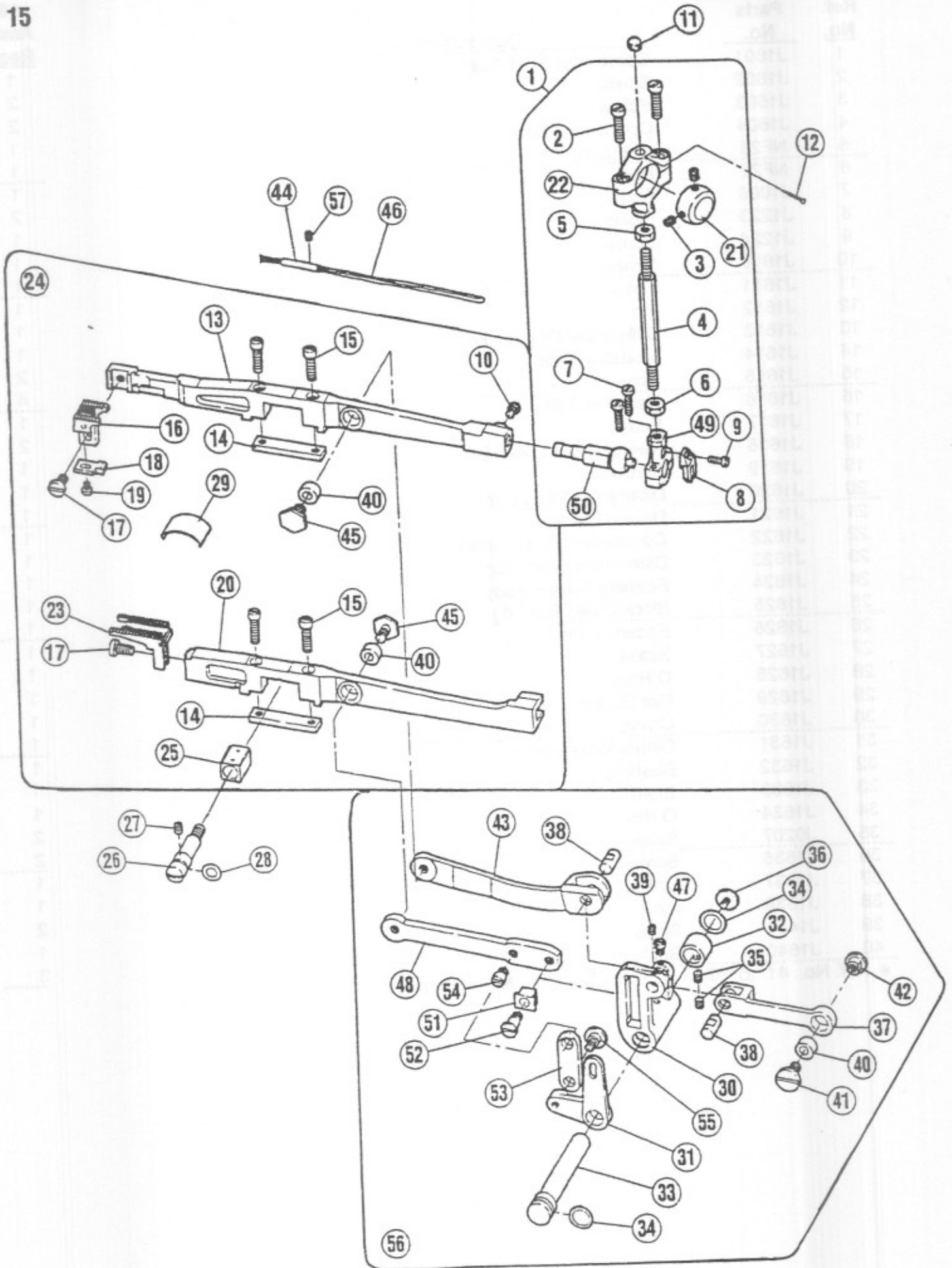
<b>Ref. No.</b>	<b>Parts No.</b>	<b>Description</b>	<b>14 Amt. Req.</b>
1	J1401	Top Cover Thread Take-Up	1
2	J1402	Screw	4
3	J1403	Screw	2
4	J1404	Looper Thread Take-Up	1
5	J0426	Screw	1
6	WF04	Screw	1
7	J1407	Bracket	1
8	J1408	Bracket	1
9	J1409	Screw	2
10	J1410	Thread Take-Up Guide	1
11	J1411	Screw	1
12	J1412	Bracket	1
13	J1413	Screw	2
14	J1414	Looper Thread Guide	1
15	J1415	Screw	1
16	J1416	Washer	1
17	J1417	Thread Support	1
18	J1418	Screw	1
19	J1419	Thread Guide	1
20	J0845	Screw	2
21	J1421	Thread Guide	1
22	J1422	Looper Thread Guide Assy	1
23	J1423	Bracket	1
24	J0408	Screw	1
25	J1425	Pipe	1
26	J1426	Bracket	1
27	VD27	Eye Guard Holder	1
28	FA26	Conical Spring Washer	1
29	SV126	Screw ( SM11/64-40 )	1
30	VD25	Eye Guard	1
31	SV104	Screw ( SM3/32-56×5 )	2
32	FA24	Washer	1
33	J1433	Pipe Thread Guide Assy	1



**Feed Mechanism ( 1 )**

<u>Ref. No.</u>	<u>Parts No.</u>	<u>Description</u>	<u>16 Amt. Req.</u>
1	J1601	Connection Rod Assy	1
2	J1602	Screw	2
3	J1603	Screw	2
4	J1604	Connecting Bar	1
5	NF26	Nut (Left)	1
6	NF22	Nut	1
7	J1006	Screw	2
8	J1223	Guide	1
9	J1224	Screw	1
10	J1610	Screw	1
11	J1611	Felt	1
12	J1612	Pin	1
13	J1613	Differential Feed Bar	1
14	J1614	Auxiliary Plate	2
15	J1615	Screw	4
16	J1616	Main Feed Dog	1
17	J1617	Screw	2
18	J1618	Needle Guard (Rear)	1
19	J1619	Screw	1
20	J1620	Differential Feed Bar	1
21	J1621	Driving Lever	1
22	J1622	Connecting Rod (Large)	1
23	J1623	Differential Feed Dog	1
24	J1624	Feeding Device Assy	1
25	J1625	Block (Feed Bar Lift)	1
26	J1626	Eccentric Pin	1
27	J1627	Screw	1
28	J1628	O Ring	1
29	J1629	Flat Spring	1
30	J1630	Crank	1
31	J1631	Differential Lever	1
32	J1632	Bushing	1
33	J1633	Shaft	1
34	J1634	O Ring	2
35	J0207	Screw	2
36	J1636	Screw	1
37	J1637	Link	1
38	J1638	Pin	2
39	J1411	Screw	1
40	J1640	Bushing	3

\* Ref. No. 41 to 57 . . . . See the following page



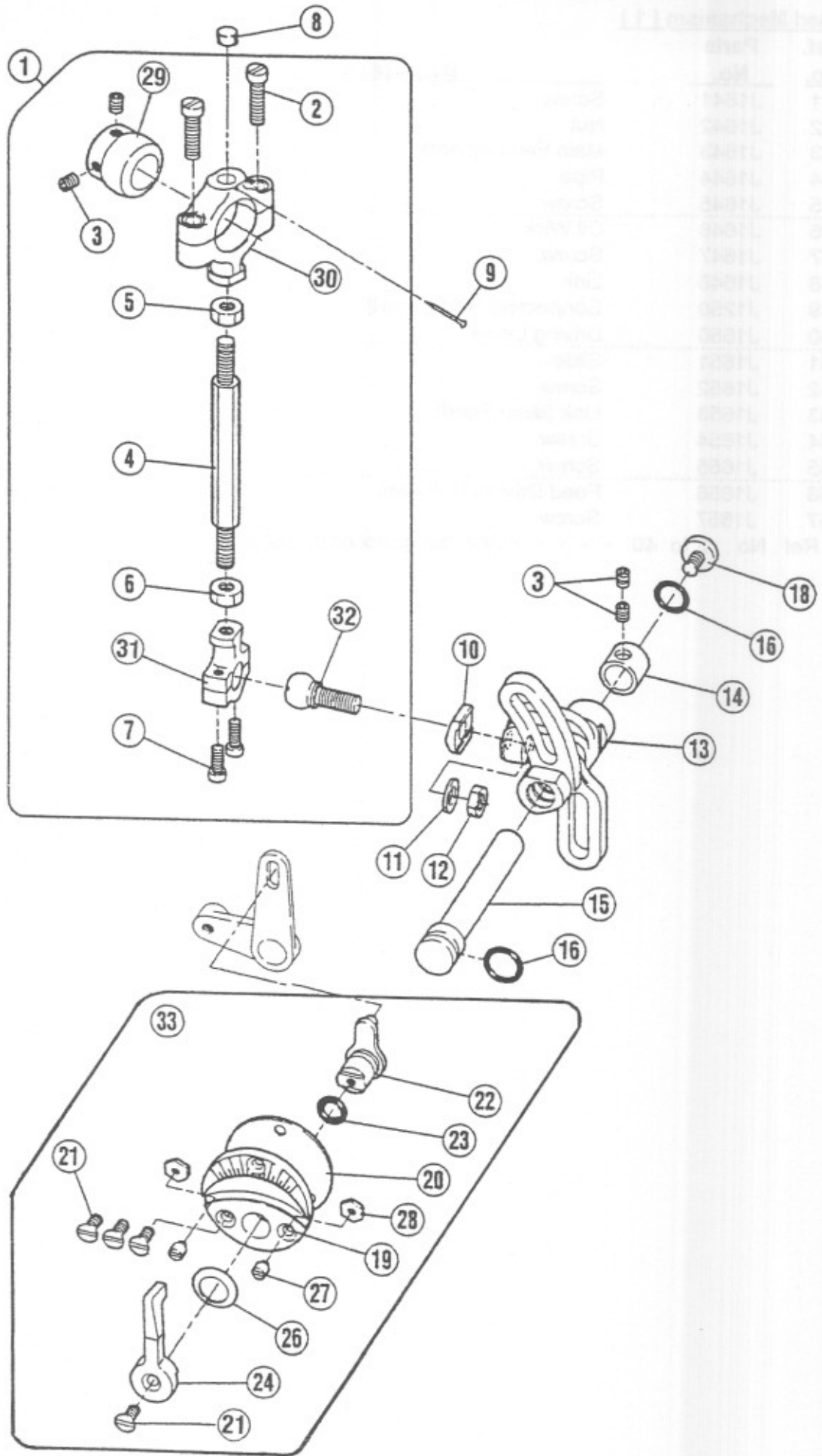


**Feed Mechanism ( 1 )**

<u>Ref. No.</u>	<u>Parts No.</u>	<u>Description</u>	<u>16 Amt. Req.</u>
41	J1641	Screw	1
42	J1642	Nut	1
43	J1643	Main Feeding Arm	1
44	J1644	Pipe	1
45	J1645	Screw	2
-----			
46	J1646	Oil Wick	1
47	J1647	Screw	1
48	J1648	Link	1
49	J1250	Connecting Rod (Small)	1
50	J1650	Driving Lever	1
-----			
51	J1651	Slide	1
52	J1652	Screw	1
53	J1653	Link (Main Feed)	1
54	J1654	Screw	1
55	J1655	Screw	1
-----			
56	J1656	Feed Driving Unit Assy	1
57	J1657	Screw	1

\*Ref. No. 1 to 40 . . . . . See the preceding page.



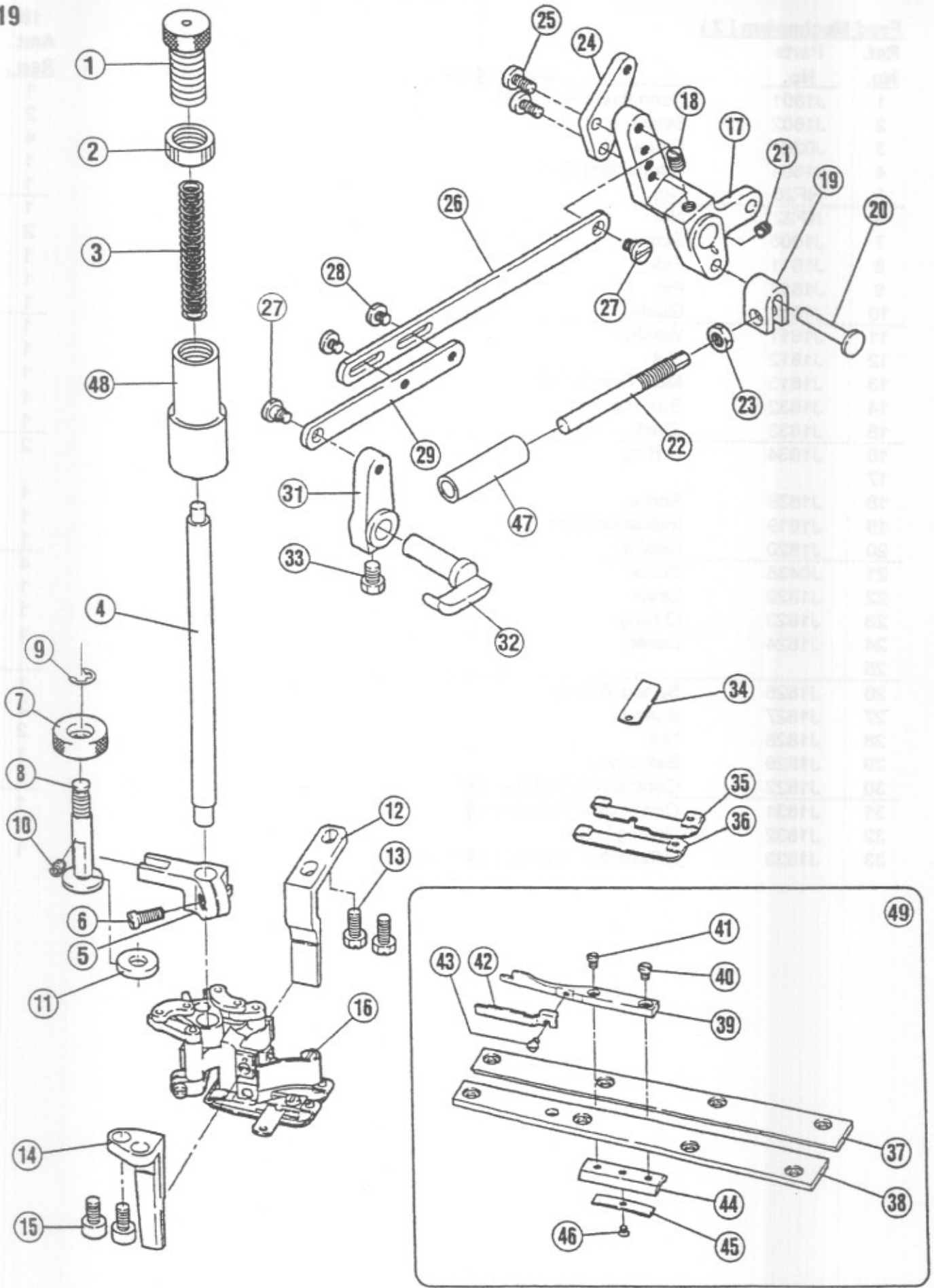


**Feed Mechanism ( 2 )**

Ref. No.	Parts No.	Description	18 Amt. Req.
1	J1801	Connecting Rod Assy	1
2	J1602	Screw	2
3	J0207	Screw	4
4	J1604	Connecting Bar	1
5	NF26	Nut	1
6	NF22	Nut	1
7	J1006	Screw	2
8	J1611	Felt	1
9	J1612	Pin	1
10	J1810	Guide	1
11	J1811	Washer	1
12	J1812	Nut	1
13	J1813	Main Feed Crank	1
14	J1632	Bushing	1
15	J1633	Shaft	1
16	J1634	O Ring	2
17			
18	J1636	Screw	1
19	J1819	Indication Plate	1
20	J1820	Gasket	1
21	J0435	Screw	4
22	J1822	Lever	1
23	J1823	O Ring	1
24	J1824	Lever	1
25			
26	J1826	Spring Washer	1
27	J1827	Screw	2
28	J1828	Nut	2
29	J1829	Ball Lever	1
30	J1622	Connecting Rod (Large)	1
31	J1831	Connecting Rod (Small)	1
32	J1832	Driving Lever	1
33	J1833	Differential Feeding Indicator Assy	1



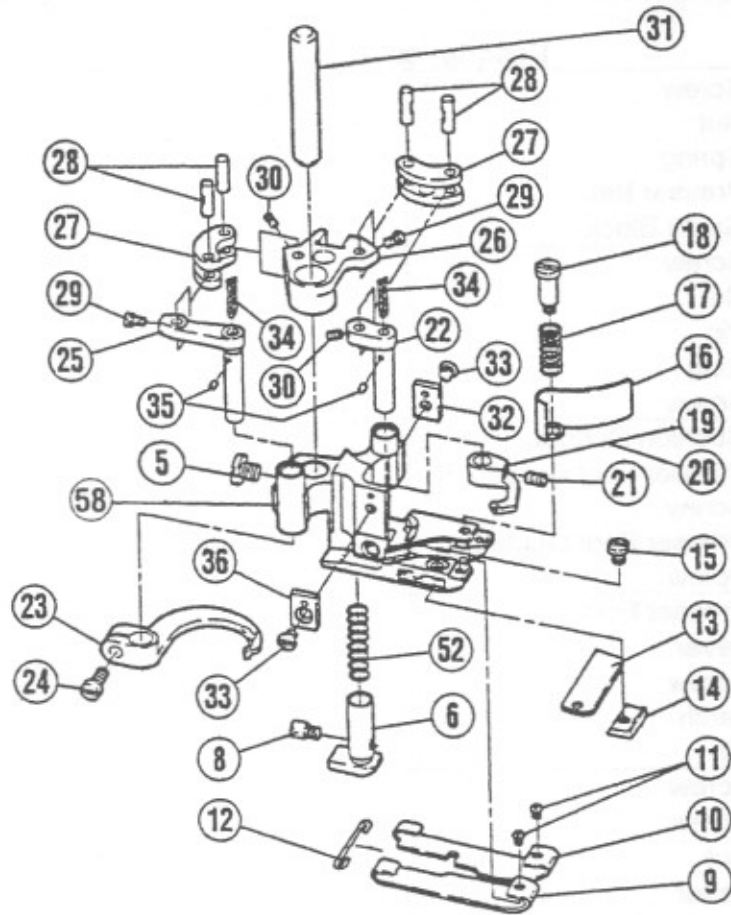
19



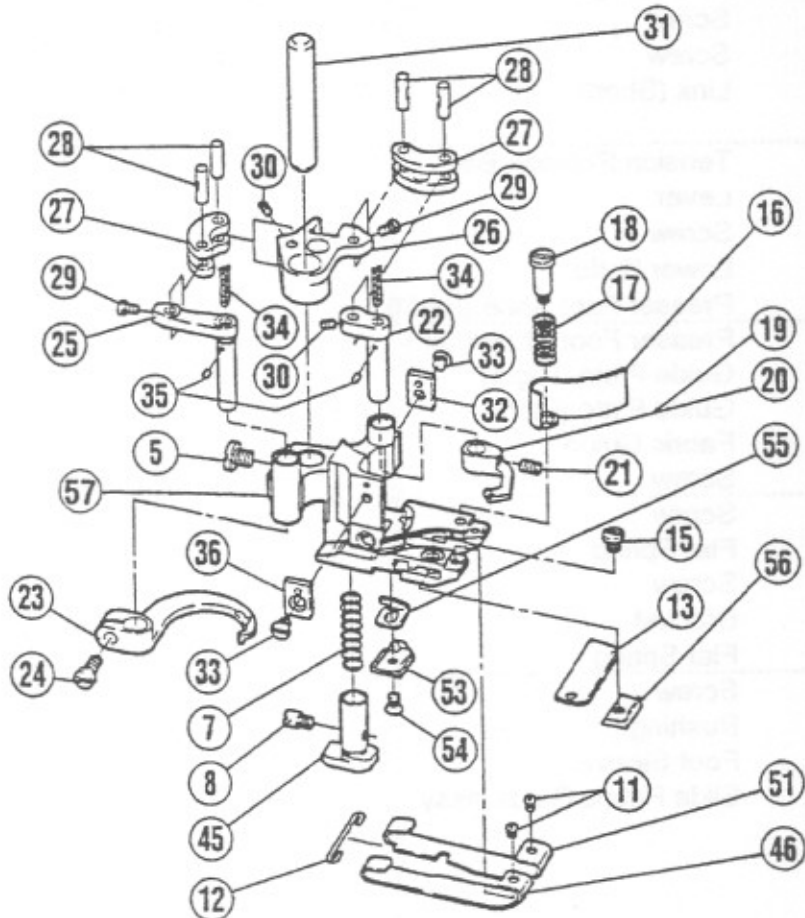
**Presser Foot Driving Mechanism**

Ref. No.	Parts No.	Description	20 Amt. Req.
1	J2001	Screw	1
2	J2002	Nut	1
3	J2003	Spring	1
4	J2004	Presser Bar	1
5	J2005	Guide Block	1
6	J2006	Screw	1
7	J2007	Nut	1
8	J2008	Pin	1
9	16-28	Ring	1
10	J2010	Screw	1
11	J2011	Cushion Rubber	1
12	J2012	Presser Foot Guide ( R )	1
13	J2013	Screw	2
14	J2014	Presser Foot Guide (L)	1
15	J2015	Screw	2
16		Presser Foot	1
17	J2017	Lever	1
18	J1409	Screw	1
19	J2019	Latch	1
20	J2020	Pin	1
21	J1402	Screw	1
22	J2022	Screw	1
23	J1225	Nut	1
24	J2024	Lever	1
25	J0408	Screw	2
26	J2026	Link (Long)	1
27	J2027	Screw	2
28	J2619	Screw	2
29	J2029	Link (Short)	1
30			
31	J2031	Tension Release Bar	1
32	J2032	Lever	1
33	J2033	Screw	1
34		Lower Knife	1
35		Presser Foot Shoe (Right)	1
36		Presser Foot Shoe (Left)	1
37	J2037	Guide Plate (Right)	1
38	J2038	Guide Plate (Left)	1
39	J2039	Fabric Guide	1
40	J0845	Screw	1
41	J2041	Screw	1
42	J2042	Flat Spring	1
43	J2043	Screw	1
44	J2044	Bracket	1
45	J2045	Flat Spring	1
46	J2046	Screw	1
47	J2047	Bushing	1
48	J2048	Foot Sleeve	1
49	J2049	Slide Fabric Guide Assy	1

- ① SL-701A×452
- ② SL-701A×460
- ③ SL-701B×452
- ④ SL-701B×460



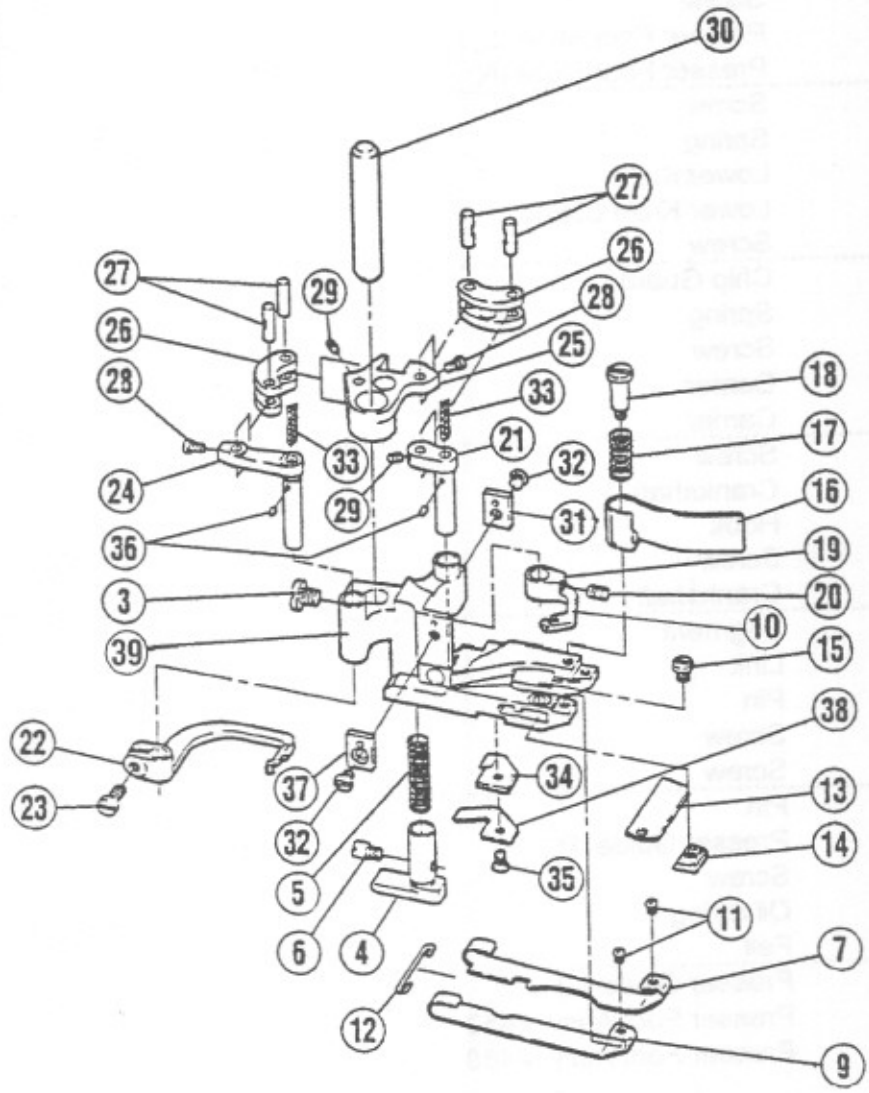
- ③⑦ SL-703A×452
- ③⑧ SL-703A×460



**Presser Foot Mechanism ( 1 )**

Ref. No.	Parts No.	Description	22 Amt. Req.
1	J2201	Presser Foot Assy. #452	1
2	J2202	Presser Foot Assy. #460	1
3	J2203	Presser Foot Assy. #452	1
4	J2204	Presser Foot Assy. #460	1
5	J2205	Screw	1
6	J2206	Fabric Guard	1
7	J2207	Spring	1
8	J2208	Screw	1
9	J2209	Presser Foot Shoe (L)	1
10	J2210	Presser Foot Shoe (R)	1
11	J2211	Screw	2
12	J2212	Spring	1
13	J2213	Lower Knife	1
14	J2214	Lower Knife Clamp	1
15	J2215	Screw	1
16	J2216	Chip Guard	1
17	J2217	Spring	1
18	J2218	Screw	1
19	J2219	Carrier	1
20	J2220	Carrier	1
21	J2221	Screw	1
22	J2222	Crankshaft	1
23	J2223	Hook	1
24	J2224	Screw	1
25	J2225	Crankshaft	1
26	J2226	Segment	1
27	J2227	Link	2
28	J2228	Pin	4
29	J2229	Screw	2
30	J2230	Screw	2
31	J2231	Pin	1
32	J2232	Presser Guide (R)	1
33	J2233	Screw	2
34	J2234	Oil String	2
35	J2235	Felt	2
36	J2236	Presser Guide (L)	1
37	J2237	Presser Foot Assy. #452	1
38	J2238	Presser Foot Assy. #460	1
45	J2245	Presser Foot Assy	1
46	J2246	Presser Foot Shoe (L)	1
51	J2251	Presser Foot Shoe (R)	1
52	J2252	Spring	1
53	J2253	Presser Foot Finger	1
54	J2254	Screw	1
55	J2255	Fabric Guide	1
56	J2256	Lower Knife Clamp	1
57	J2257	Main Presser Foot (Thick)	1
58	J2258	Main Presser Foot (Thin)	1

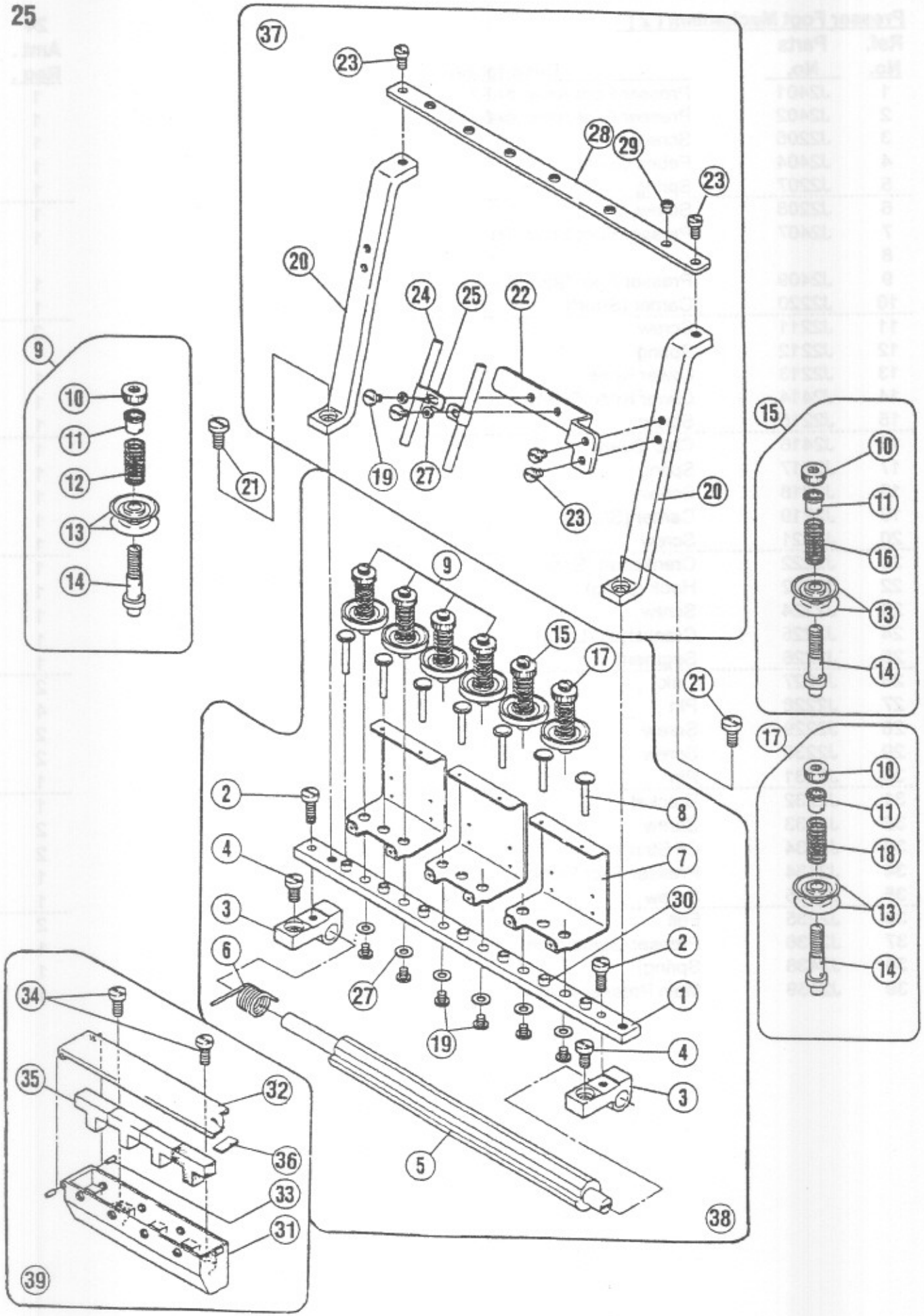
- ① SL-713x452
- ② SL-713x460





**Presser Foot Mechanism ( 2 )****24  
Amt .  
Req .**

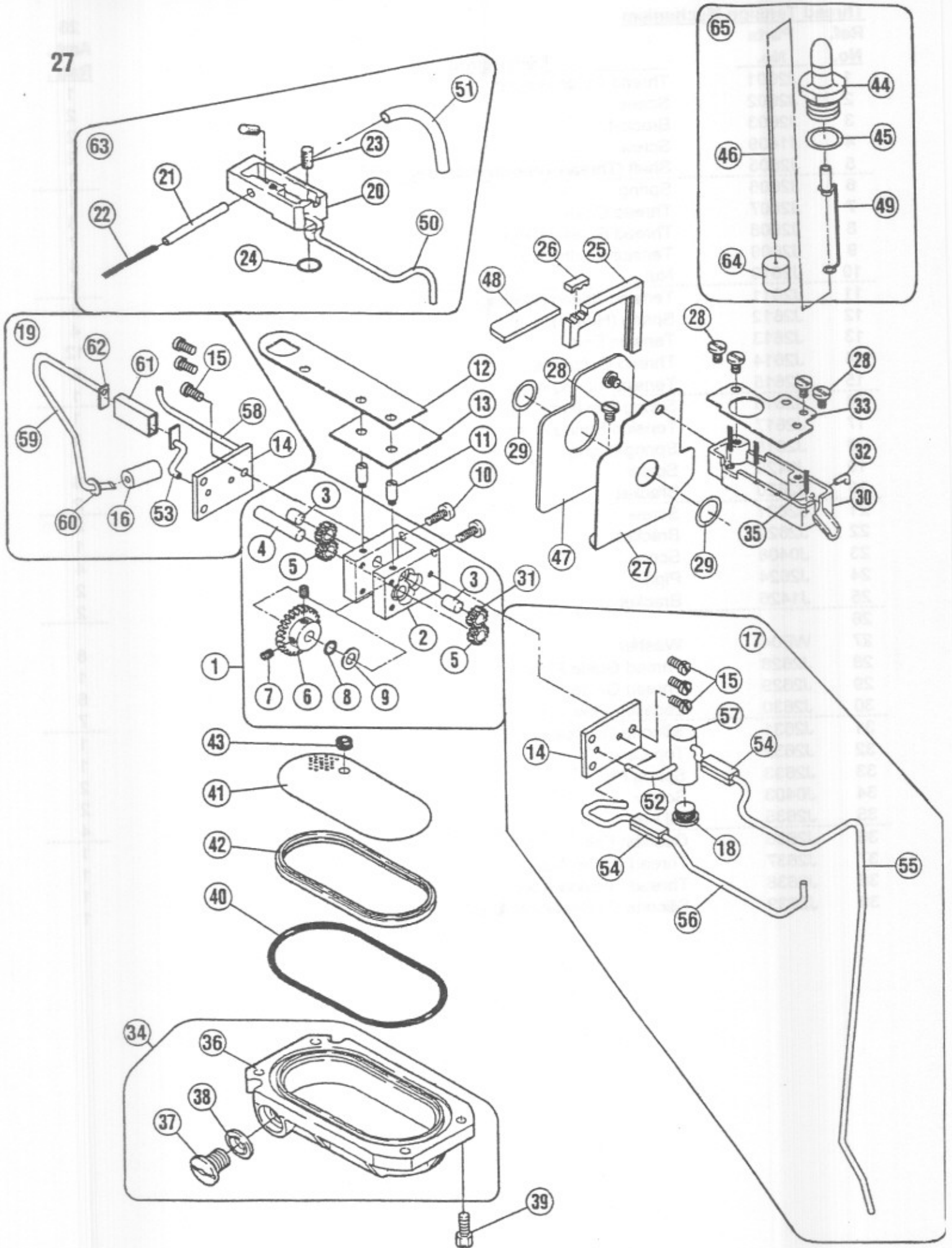
<b>Ref. No.</b>	<b>Parts No.</b>	<b>Description</b>	
1	J2401	Presser Foot Assy. #452	1
2	J2402	Presser Foot Assy. #460	1
3	J2205	Screw	1
4	J2404	Fabric Guide	1
5	J2207	Spring	1
6	J2208	Screw	1
7	J2407	Presser Foot Shoe (R)	1
8			
9	J2409	Presser Foot Shoe (L)	1
10	J2220	Carrier (Short)	1
11	J2211	Screw	2
12	J2212	Spring	1
13	J2213	Lower Knife	1
14	J2414	Lower Knife Clamp	1
15	J2215	Screw	1
16	J2416	Chip Guard	1
17	J2217	Spring	1
18	J2218	Screw	1
19	J2219	Carrier (Short)	1
20	J2221	Screw	1
21	J2222	Crankshaft (Short)	1
22	J2422	Hook (Long)	1
23	J2224	Screw	1
24	J2225	Crankshaft (Long)	1
25	J2226	Segment	1
26	J2227	Link	2
27	J2228	Pin	4
28	J2229	Screw	2
29	J2230	Screw	2
30	J2231	Pin	1
31	J2232	Bracket	1
32	J2233	Screw	2
33	J2234	Oil String	2
34	J2434	Presser Foot Finger	1
35	J2435	Screw	1
36	J2235	Felt	2
37	J2236	Presser Guide (Left)	1
38	J2438	Spring	1
39	J2439	Main Presser Foot	1



**Thread Tension Mechanism**

<b>Ref. No.</b>	<b>Parts No.</b>	<b>Description</b>	<b>26 Amt. Req.</b>
1	J2601	Thread Guide Bracket	1
2	J2602	Screw	2
3	J2603	Bracket	2
4	J1409	Screw	2
5	J2605	Shaft (Thread Tension Release)	1
6	J2606	Spring	1
7	J2607	Thread Guide	3
8	J2608	Thread Releaser Pin	7
9	J2609	Tension Spring Assy	4
10	J2610	Nut	6
11	J2611	Tension Spring Bushing	6
12	J2612	Spring (Heavy)	4
13	J2613	Tension Disc	12
14	J2614	Thread Guide Bar	6
15	J2615	Tension Spring Assy	1
16	J2616	Spring (Medium)	1
17	J2617	Tension Spring Assy	1
18	J2618	Spring (Light)	1
19	J0426	Screw	8
20	J2620	Bracket	2
21	J2621	Screw	2
22	J2622	Bracket	1
23	J0408	Screw	4
24	J2624	Pipe	2
25	J1426	Bracket	2
26			
27	WF04	Washer	8
28	J2628	Thread Guide Plate	1
29	J2629	Thread Guide	6
30	J2630	Location Pipe	7
31	J2631	Silicone Oil Reservoir	1
32	J2632	Top Cover	1
33	J2633	Spring Pin	2
34	J0403	Screw	2
35	J2635	Oil Felt	4
36	J2636	Cushion Felt	1
37	J2637	Thread Eyelet Assy	1
38	J2638	Thread Tension Assy	1
39	J2639	Silicone Oil Reservoir Assy.	1

27

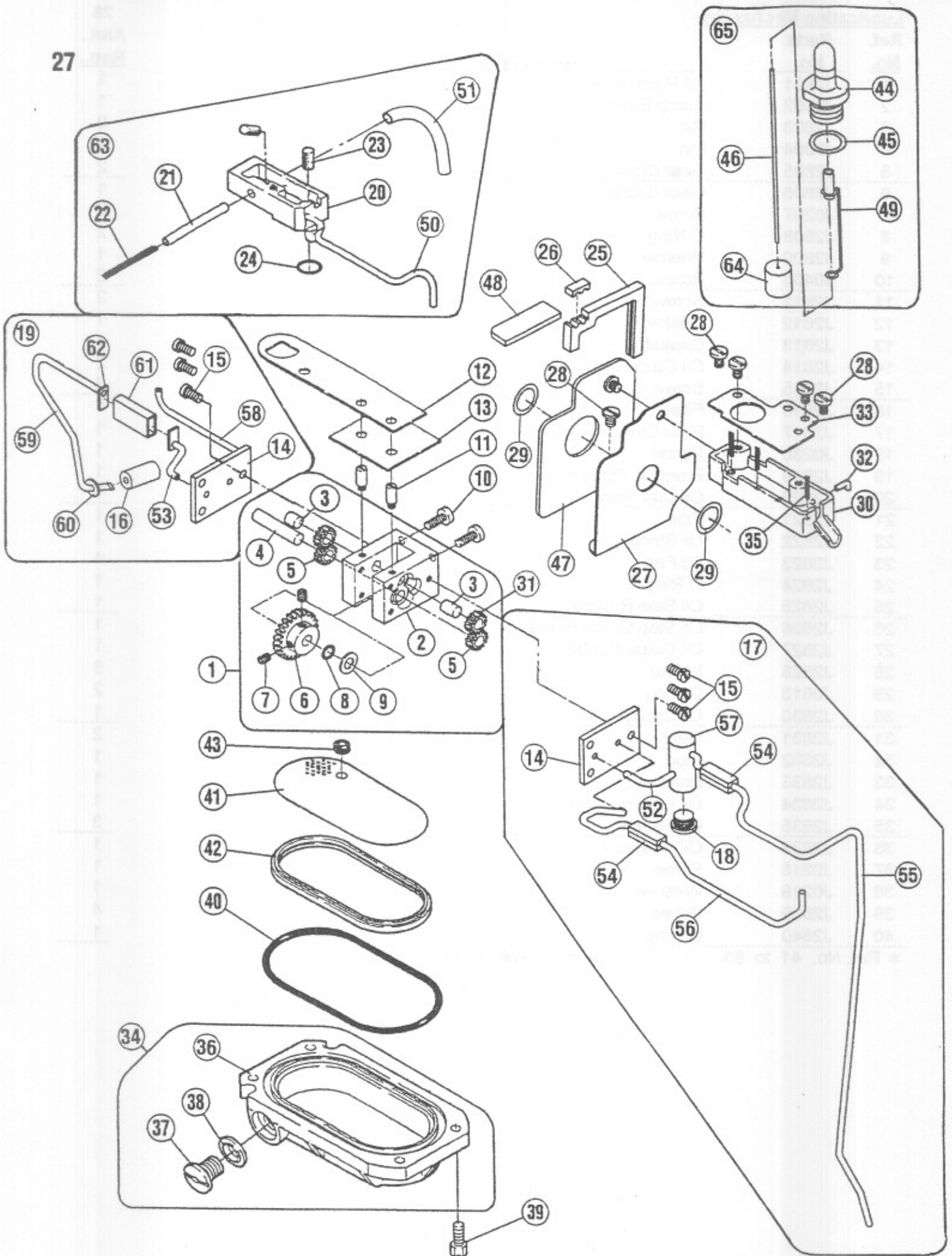


**Lubricating Mechanism**

<b>Ref. No.</b>	<b>Parts No.</b>	<b>Description</b>	<b>28 Amt. Req.</b>
1	J2801	Oil Pump Assy	1
2	J2802	Pump Base	1
3	J2803	Pin	2
4	J2804	Pin	2
5	J2805	Gear (Small)	2
6	J2806	Gear (Large)	1
7	J0207	Screw	2
8	J2808	O Ring	2
9	J2809	Washer	1
10	J0403	Screw	2
11	J2811	Screw	2
12	J2812	Gasket	1
13	J2813	Gasket	1
14	J2814	Oil Guide Cover	2
15	J2815	Screw	6
16	J2816	Filter	1
17	J2817	Rear Oil Pipe Assy	1
18	J0230	Screw	1
19	J2819	Front Oil Pipe Assy	1
20	J2820	Oil Cup Assy	1
21	J2821	Pipe	1
22	J2822	Oil String	1
23	J2823	Oil Felt	4
24	J2824	O Ring	1
25	J2825	Oil Stop Rubber	1
26	J2826	Oil Stop Guide (Small)	1
27	J2827	Oil Guide Rubber	1
28	J2828	Screw	6
29	J0613	O Ring	2
30	J2830	Oil Cup (Front)	1
31	J2831	Gear	2
32	J2832	Pipe	1
33	J2833	Bracket	1
34	J2834	Oil Reservoir Assy	1
35	J2835	Oil String	3
36	J2836	Oil Reservoir	1
37	J0218	Screw	1
38	J0219	Washer	1
39	J2839	Screw	4
40	J2840	O Ring	1

\* Ref. No. 41 to 65 . . . . . See the following page

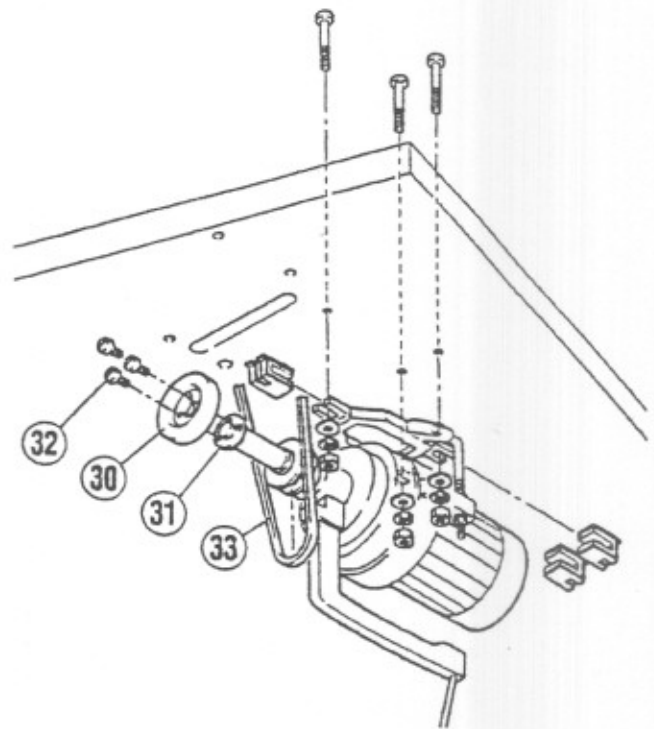
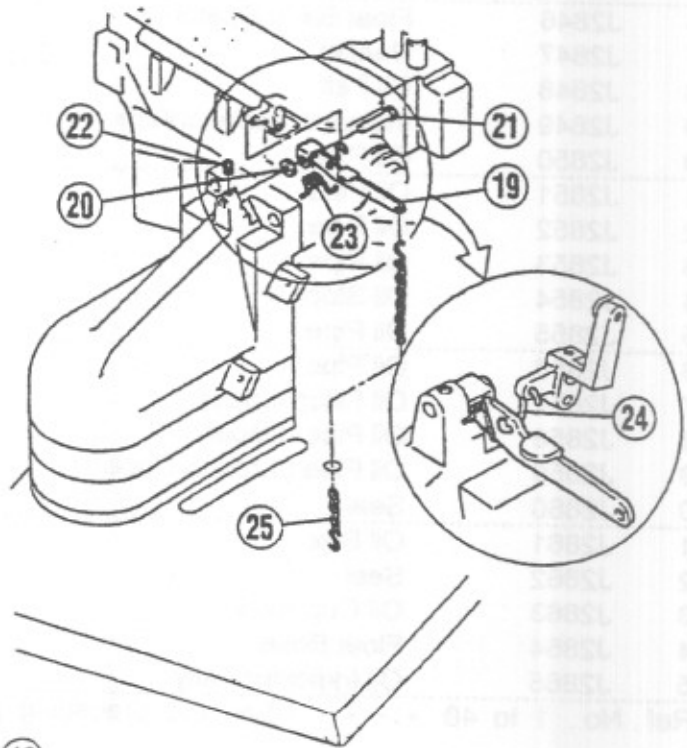
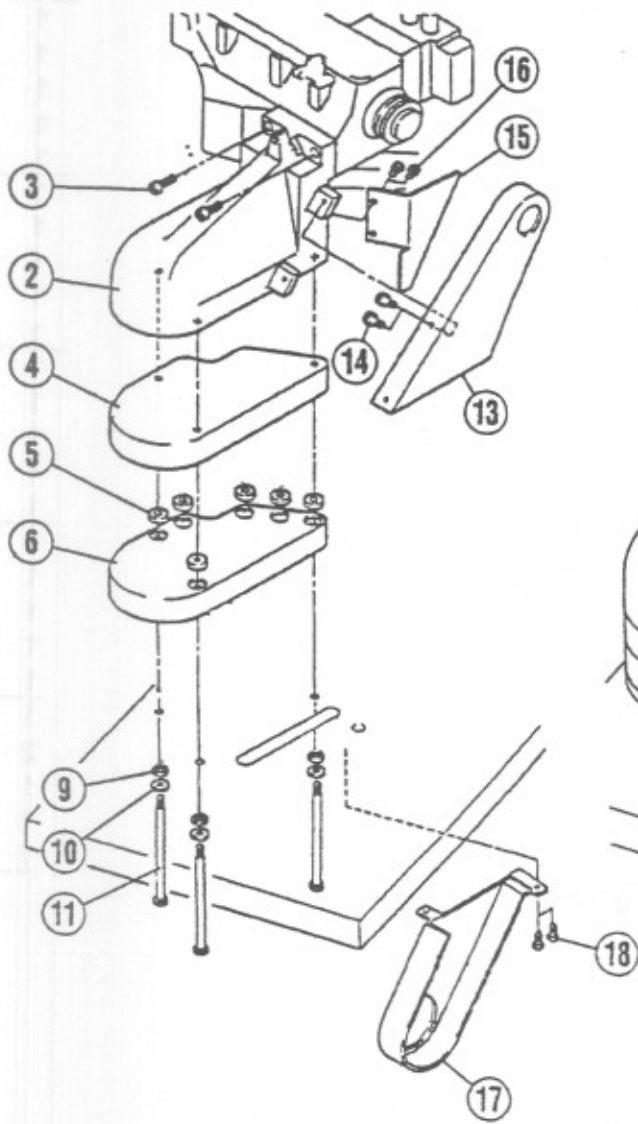
27



**Lubricating Mechanism****28  
Amt .  
Req .**

<b>Ref. No.</b>	<b>Parts No.</b>	<b>Description</b>	
41	J2841	Filter	1
42	J2842	Filter Support	1
43	J2843	Pipe Guide	1
44	J2844	Oil Sight Gauge	1
45	J2845	O Ring	1
-----			
46	J2846	Float Bar Indicator	1
47	J2847	Gasket	1
48	J2848	Oil Felt	1
49	J2849	Indicator Support Wire	1
50	J2850	Oil Pipe	1
-----			
51	J2851	Oil Pipe	1
52	J2852	Oil Pipe	1
53	J2853	Oil Pipe	1
54	J2854	Oil Stopper	4
55	J2855	Oil Pipe	1
-----			
56	J2856	Oil Pipe	1
57	J2857	Oil Filter (Upper)	1
58	J2858	Oil Pipe (Upper)	1
59	J2859	Oil Pipe ( Long & Upper)	1
60	J2860	Seal	1
-----			
61	J2861	Oil Box	1
62	J2862	Seal	2
63	J2863	Oil Cup Assy	1
64	J2864	Float Base	1
65	J2865	Oil Indicator Assy	1

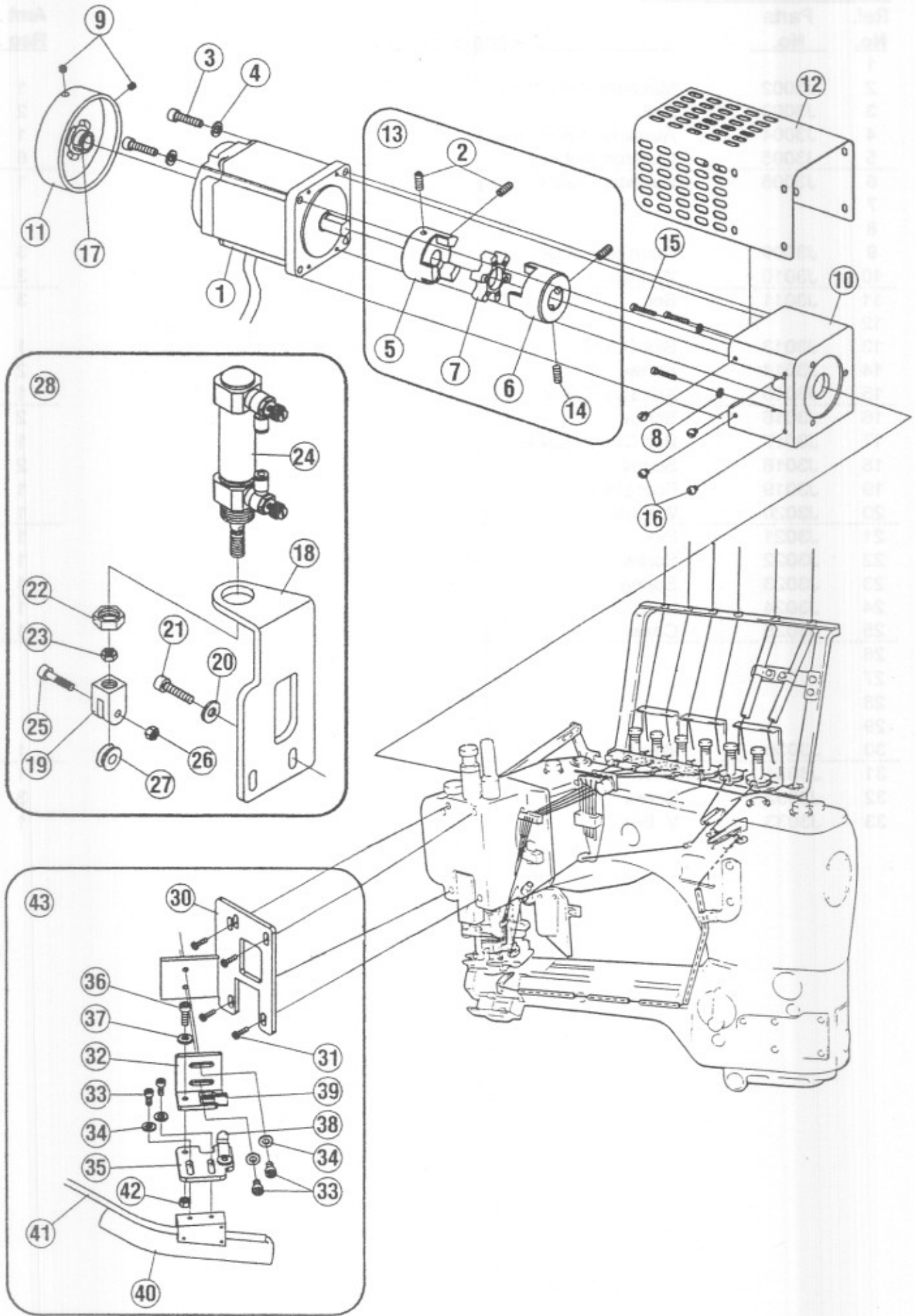
\*Ref. No. 1 to 40 . . . . . See the preceding page.





**Miscellaneous Covers ( 1 )**

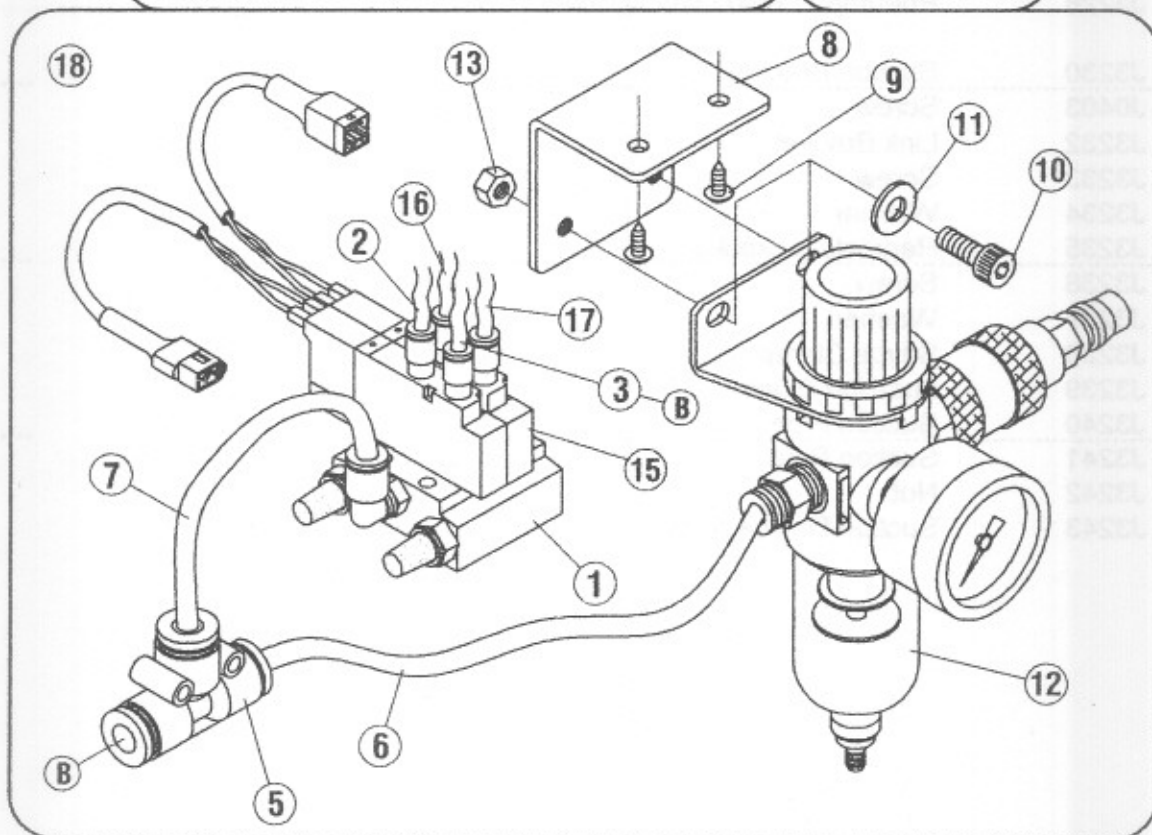
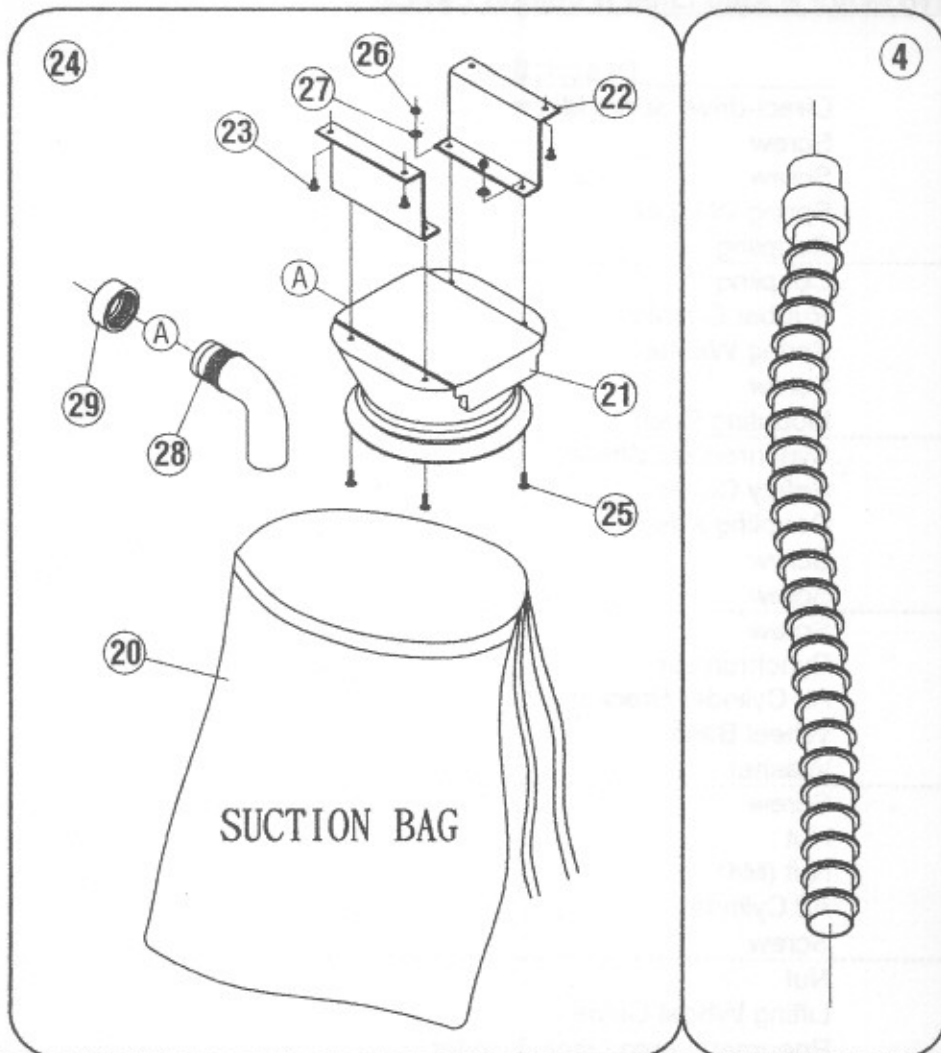
<u>Ref. No.</u>	<u>Parts No.</u>	<u>Description</u>	<u>30 Amt. Req.</u>
1			
2	J3002	Machine Rest Board	1
3	J3003	Bolt	2
4	J3004	Auxiliary Plate (Upper)	1
5	J3005	Cushion Rubber	6
6	J3006	Auxiliary Plate (Lower)	1
7			
8			
9	J3009	Cushion Rubber	3
10	J3010	Washer	3
11	J3011	Bolt	3
12			
13	J3013	Belt Cover	1
14	J3014	Screw	2
15	J3015	Auxiliary Cover	1
16	J3016	Screw	2
17	J3017	Belt Cover (Lower)	1
18	J3018	Screw	2
19	J3019	Foot Lifter	1
20	J3020	Washer	1
21	J3021	Pin	1
22	J3022	Screw	1
23	J3023	Spring	1
24	J3024	Link	1
25	J3025	Chain	1
26			
27			
28			
29			
30	J3030	Wheel	1
31	J3031	Shaft	1
32	J3032	Screw	3
33	J3033	V Belt	1



**Direct-drive Servo Motor & Auto Lifter & Venturi Device**

32

Ref. No.	Parts No.	Description	Amt. Req.
1	J3201	Direct-drive Servo Motor	1
2	SF242	Screw	3
3	SF243	Screw	4
4	J0205	Spring Washer	4
5	J3205	Coupling	1
6	J3206	Coupling	1
7	J3207	Rubber Cushion	1
8	SW06	Spring Washer	3
9	SV250	Screw	2
10	J3210	Mounting Base	1
11	J3211	Synchronizer Wheel	1
12	J3212	Safety Cover	1
13	J3213	Coupling Assy	1
14	SV239	Screw	1
15	J3215	Screw	3
16	J3216	Screw	8
17	J3217	Synchronizer	1
18	J3218	Air Cylinder Bracket	1
19	J3219	Wheel Base	1
20	WF06	Washer	2
21	J3221	Screw	2
22	J3222	Nut	1
23	J3223	Nut (M8)	1
24	J3224	Air Cylinder	1
25	22-16	Screw	1
26	NV12	Nut	1
27	22-15	Lifting Wheel Guide	1
28	J3228	Pneumatic Auto Lifter Cylinder	1
29			
30	J3230	Suction Bracket	1
31	J0403	Screw	4
32	J3232	Link Bracket	1
33	J3233	Screw	4
34	J3234	Washer	4
35	J3235	Regulating Bracket	1
36	J3236	Screw	1
37	J3237	Washer	1
38	J3238	S type Clamp	1
39	J3239	Location Block	1
40	J3240	Suction Pipe	1
41	J3241	Suction Pipe	1
42	J3242	Nut	1
43	J3243	Suction Device Assy	1



**Pneumatic Auto Lifter & Ventri Device**

<b>Ref.</b>	<b>Parts</b>		<b>34</b>
<b>No.</b>	<b>No.</b>	<b>Description</b>	<b>Amt .</b>
			<b>Req .</b>
1	J3401	Air Solenoid Base	1
2	J3402	Pipe	1
3	J3403	Pipe	1
4	J3404	Plastic Tube	1
5	27-19	T-Type Air Connector	1
6	J3406	Pipe	1
7	J3407	Pipe	1
8	23-08	Regulator Support	1
9	15-24	Wooden Screw	2
10	SV266	Screw (M6-1.0×10)	2
11	WF06	Spring Washer	2
12	23-12	Pressure Meter	1
13	NF31	Nut	2
14			1
15	J3415	Air Solenoid Base	1
16	J3416	Pipe	1
17	J3417	Pipe	1
18	J3418	Air Solenoid, Complete Set	1
19			1
20	27-15	Suction Bag	1
21	27-01	Suction Bag Holder	1
22	27-02	Z-Type Bracket	1
23	27-03	Wooden Screw	4
24	27-04	Suction Bag Assy	1
25	27-05	Screw	4
26	27-06	Nut	4
27	27-07	Washer	4
28	27-09	Plastic Tube	1
29	27-10	Plastic Nut	1