

GLOBAL

UP 550 AUT

**SINGLE NEEDLE, WALKING FOOT
LOCKSTITCH MACHINE FOR GATHERING**

**INSTRUCTION / OPERATING MANUAL
PARTS MANUAL**

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SERVICE MANUAL

1. Machine introduction

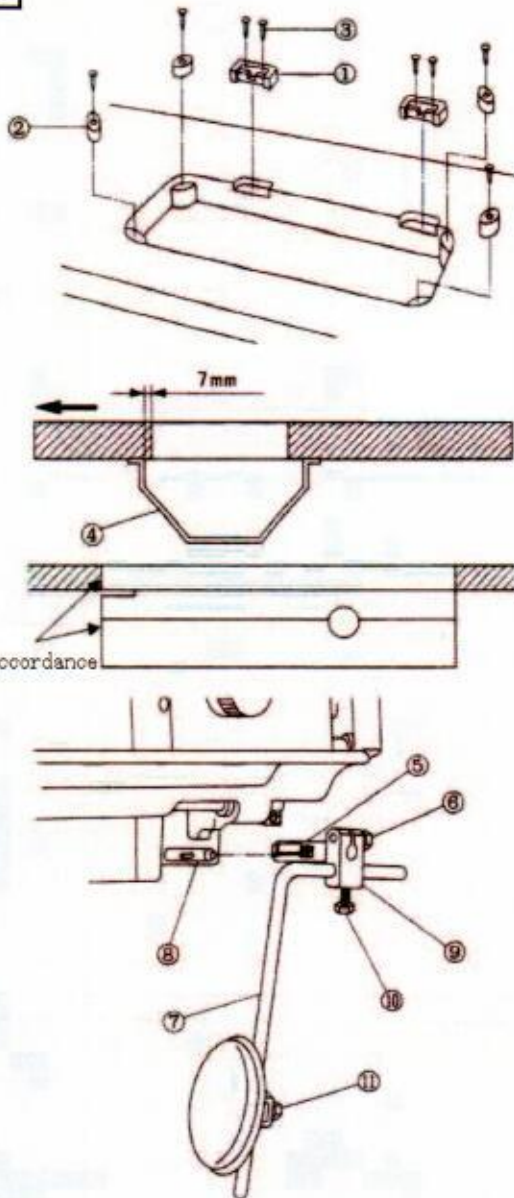
This machine adopts synchronous feeding and unique fabric feeding mechanism to optimize its climbing performance, and features powerful and smooth thick-fabric feeding, even stitches, tidy and nice-looking. Lines are drawn by horizontal-type hook, taken up by slide bar mechanism and driven by synchronous belts on upper and lower shafts, which has ensured high speed and low noise performance.

This product is widely applied in sewing thick materials such as automobile cushion, sofa, purse and tent etc.

2. Main technical specification

Application	Thick fabric
Maximum sewing speed	2500s.p.m
Longest stitch	9mm
Needle bar travel	36mm
Needle	DP×17(Nn125~Nn180)Standard Nn180(24#)
Ways of lubrication	Oiling for oil line (automatic oiling for hook)
Hook	Automatic large vertical lubrication hook
Height of pressure foot	Manual control: 9mm, knee control : 16mm
Power of the motor	370W (specially for sewing machine motor)

1



3. Installation (See Figure 1)

1. Installation of the frame bedplate connection hook block and the frame rubber cushion:

Fix the auxiliary connection hook block (1) and the frame rubber cushion (2) on the bedplate with nails (3).

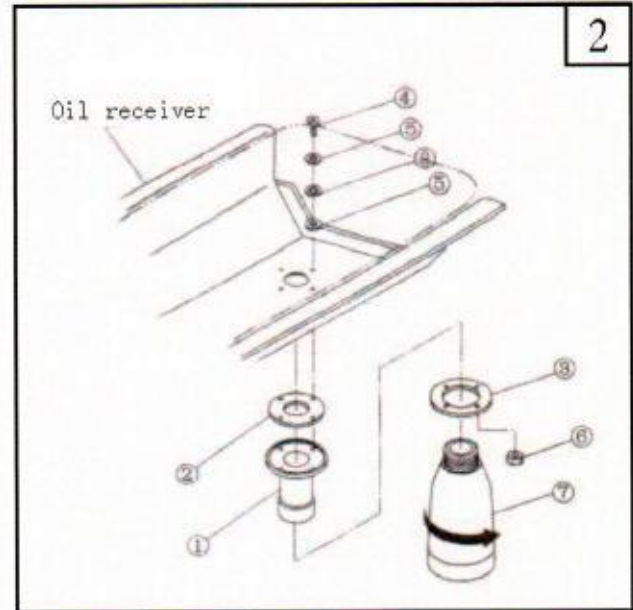
2. Fix the oil tray (4) on the bedplate with eight screw nails according to the position indicated on the figure.

3. Install the kneel-controlled joint (5), kneel-controlled lifting installation crank (9) and curved bar (7) according to the direction of the kneel-controlled lifting bar shaft (8).

4. Adjust the direction of cushion blocks with fixed screws (6) and (10) and (11).

4. Installation of waste oil container (See Figure 2)

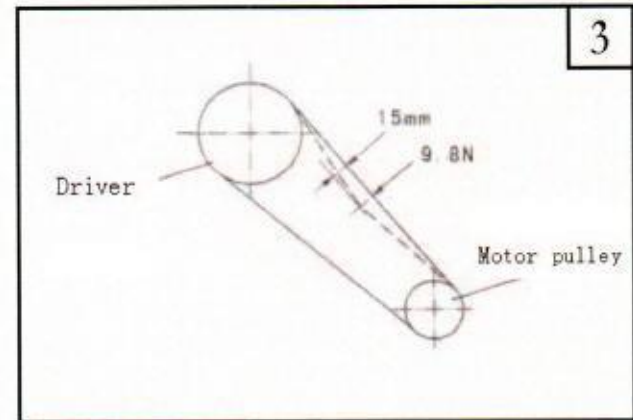
1. Install the oil discharge stopper①, oil seal② and the washer③ on the oil tray. Cover the cushion block⑤ and the washer⑧ on the fixed screw④. Then fix them with nut⑥.
2. Turn the waste oil pot⑦ to the oil discharge stopper① after fixing.



5. Adjusting the belt tension (See Figure 3)

Move the height of the motor when adjusting the belt tension. Press the middle part of the belt with force of 9.8N. The relaxation shall be 15mm at the moment.

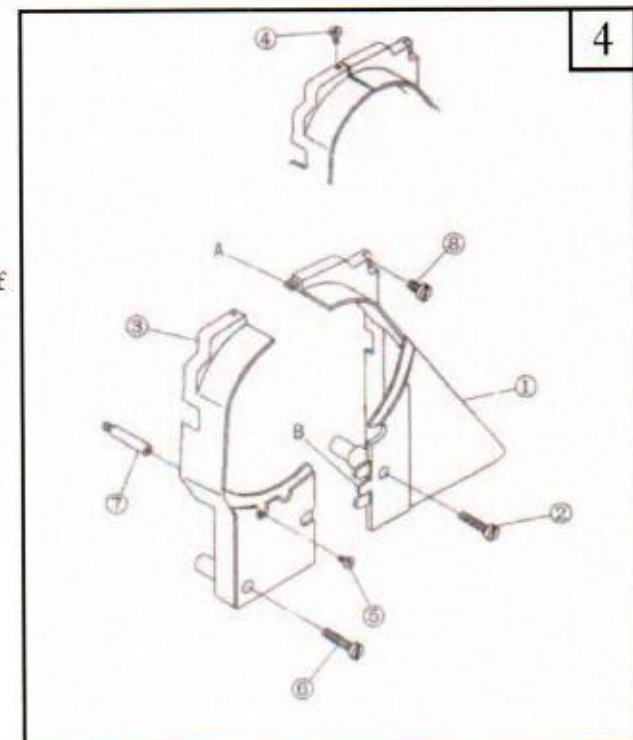
Note: Before adjusting, please cut off the power and ensure that the motor has stopped.



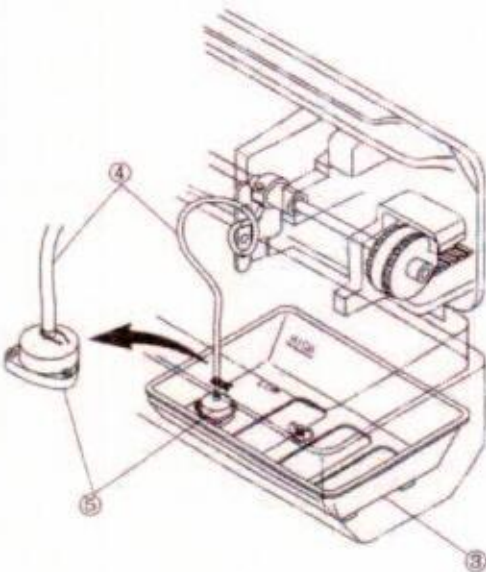
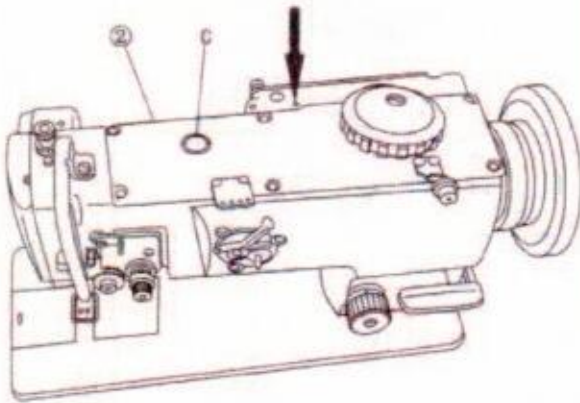
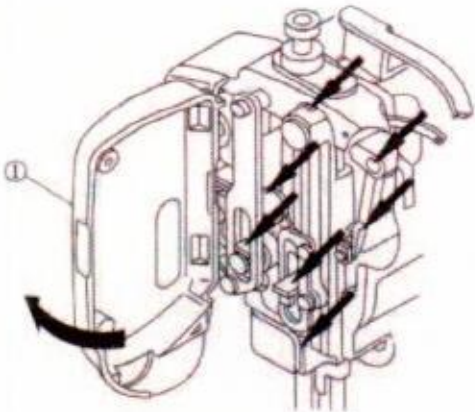
6. Installation of belt cover (See Figure 4)

1. Screw the belt cover support⑦ to the bolt hole on the head.
2. Install the belt cover (right) ① on the head with fixed screws ② and ⑧.
3. Mount the belt cover (left) ③ on the claw AB of belt cover (right) ①.
4. Fix the belt cover (left) ③ with fixed screws ④, ⑤ and ⑥.

Note: Please confirm that the belt cover doesn't contact with the belt and the driving wheel after installing the belt cover.



5



7. Oiling (See Figure 5)

ONE. Oiling of surface

1. Screw off the panel bolts.
2. Open the panel ① to the direction of arrow.
3. Properly oil the part indicated by the arrow in every day.
4. Close the panel.
5. Tighten the bolts.

TWO. Machine oiling

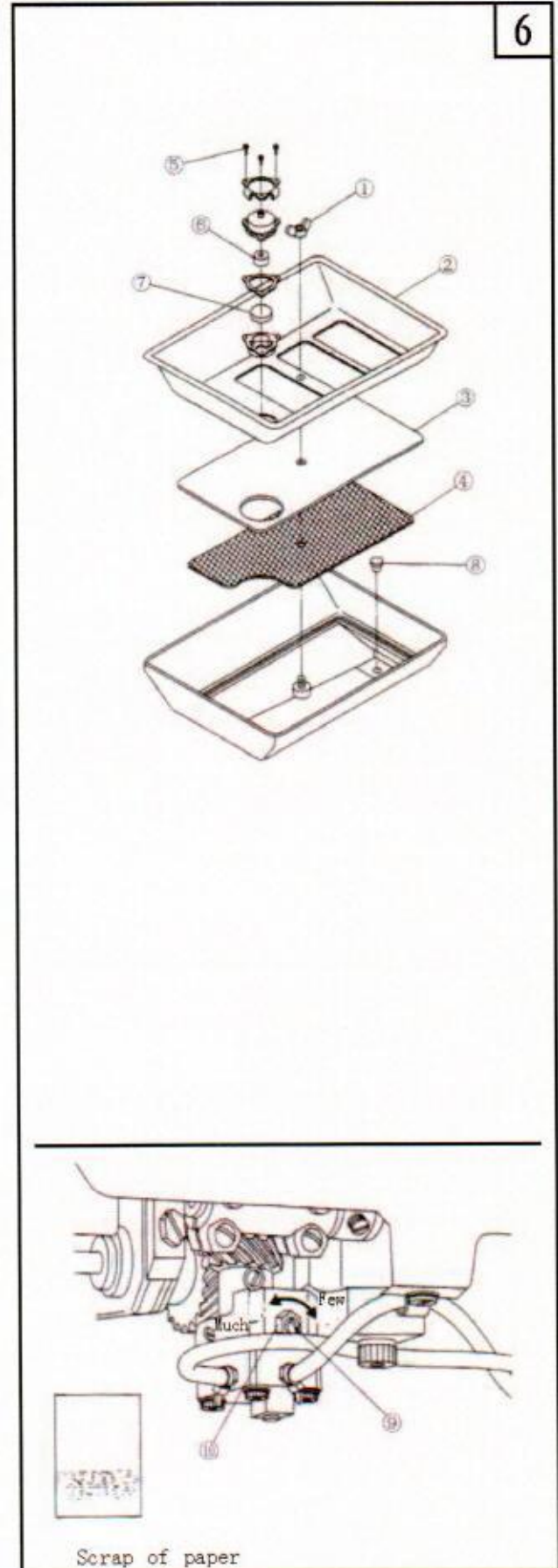
1. Add a proper amount of oil to the parts indicated by the arrow in every day.
2. Before the first operation or when the machine has not been in use for a long time, add oil to the parts indicated by the arrow, and dismantle head cover ② to add a proper amount of oil to each felt and oil line.

THREE. Oil slot oiling

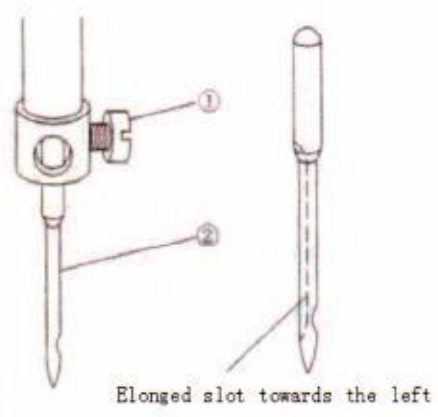
1. Insert the bulge at the bottom of the oil slot ③ into the waste oil hole which is used for receiving oil.
2. Connect the oil pipe ④ with the filter ⑤ of the oil slot. Then fix it with clamp.
3. Add sewing machine oil into the oil slot till the HIGH position.
4. Oil if the level is under LOW.
5. Run the sewing machine after oiling. You can see the oil moving up and down in oil window C in normal condition. (with the revolution more than 1500rpm)

8. Cleaning the oil slot (See Figure 6)

1. Dismantle the oil tube on the oil slot.
2. Remove the butterfly nut① and take down the cover (upper) ②, filter③ and cover (lower) ④ to clean.
3. Take down the fixed screw⑤ of the filter box and clean the filtering core⑥ and magnet⑦ inside it.
4. When changing the engine oil inside the oil slot, dismantle the stop bolt⑧ and then the waste oil can be discharged into the waste oil container. Tighten the stop bolt⑧ after discharging. (Note: Discharge the engine oil before taking out the oil slot.)
5. Put the filtering core⑥ and magnet⑦ into the filter box and fix them with fixed screw ⑤ on the cover (upper)②.
6. Put with the order of cover (lower)④, filter③ and cover (upper)② and then fix them on the oil slot with butterfly screw①.
7. Insert the oil tube into the oil slot and fix with clamp.
8. Loosen the nut⑩ when adjusting the oil quantity of the hook with adjusting screw⑨. When loosening the nut clockwise, the oil quantity decreases; otherwise, it increases.
9. Put the paper near the periphery of the hook for about five seconds. It is proper for the oil quantity if there is oil stain on the paper as shown in the figure.



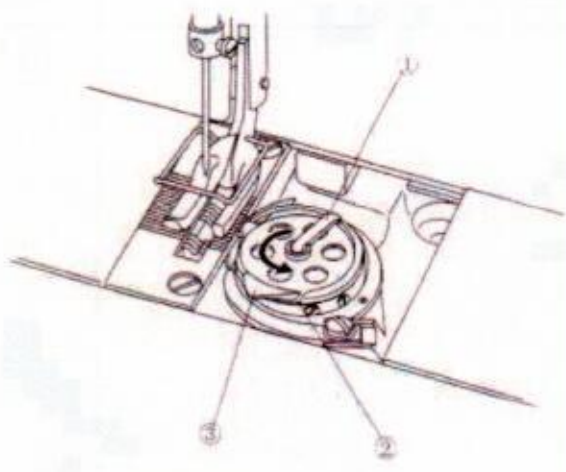
7



9. Installation of needle (See Figure 7)

1. Run the driving wheel and lift the needle bar to the highest position.
2. Loosen the needle fixed bolt ② to make the long slot of the needle ① face the left.
3. Insert the needle into the innermost part.
4. Tighten the needle fixed bolt ②.

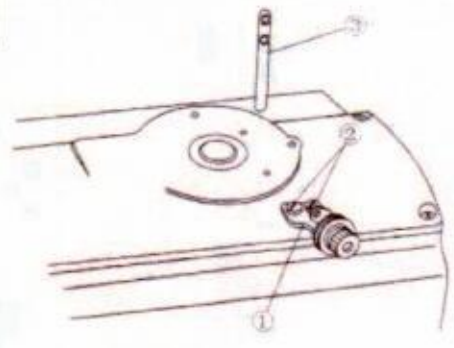
8



10. Threading of the bottom thread (See Figure 8)

1. Cock the washer ① of the hook and draw the core out.
2. During installation, correctly insert the hook shaft and lay down the washer.
3. Inlay the thread into the threading slot ② of the hook. Get past from the underside of the bulge ③ and get into the thread tension spring.
4. The hook core shall turn along the arrow after pulling the bottom thread.

9

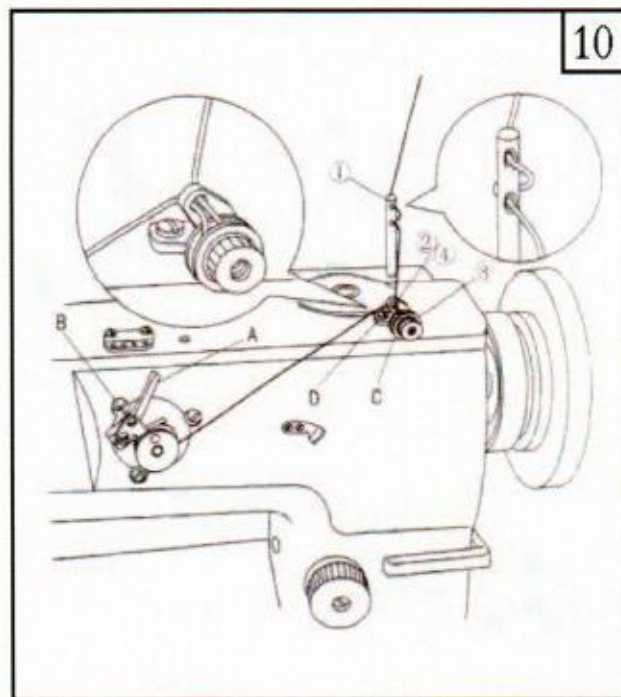


11. Installation of thread winder guide (See Figure 9)

1. Install the thread winder guide ① on the cover with fixed screw ②.
2. Insert the bottom thread guide bar ③ into the stand.

12. Winding the bottom thread
(See Figure 10)

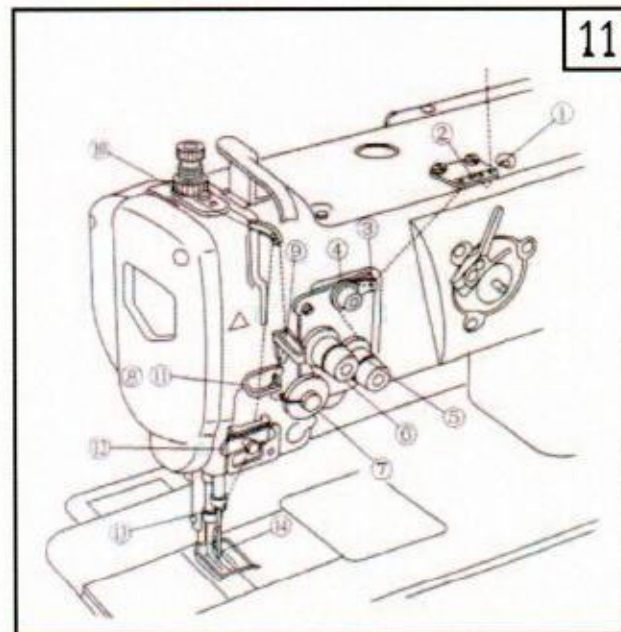
1. Thread according to the order of ①~④ and then wind the coil on the hook core.
2. Press down the winding bar A.
3. Loosen the fixed screw B and adjust the regulating panel to make the thread wind to the position of about 80%.
4. If the winding thread deviates from the course, move the thread winder guide C forward and backward to adjust and then fix with fixed screw D.
5. After the winding is over, the winding rod separates and stops automatically.



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13. Threading (See Figure 11)

Thread according to the order indicated on the figure.

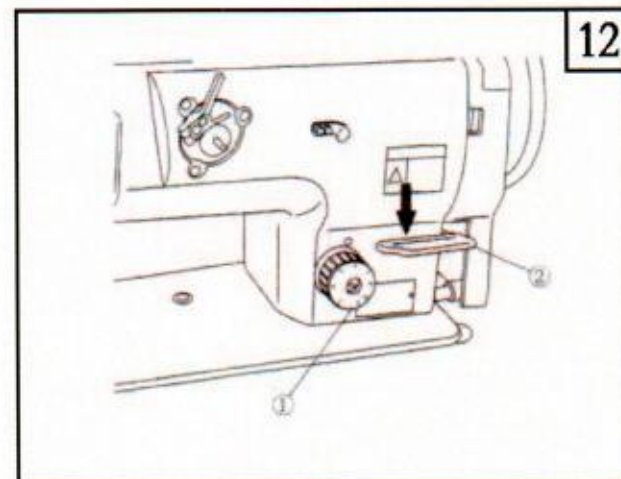


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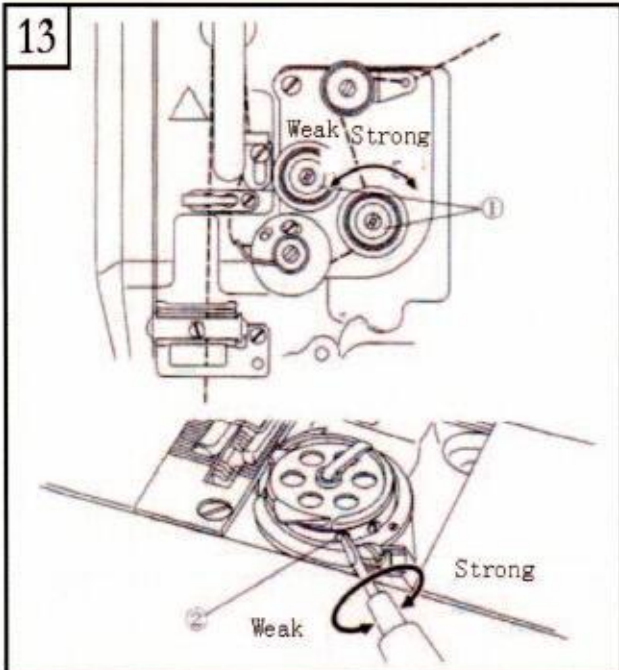
14. Adjusting the length of stitches
(See Figure 12)

Turn the feed adjusting tray ① to the left (or right) and make the adjusting mark aim at the required number.

Press the backstitch spanner ② downward to start and release the spanner to resume the normal stitch.

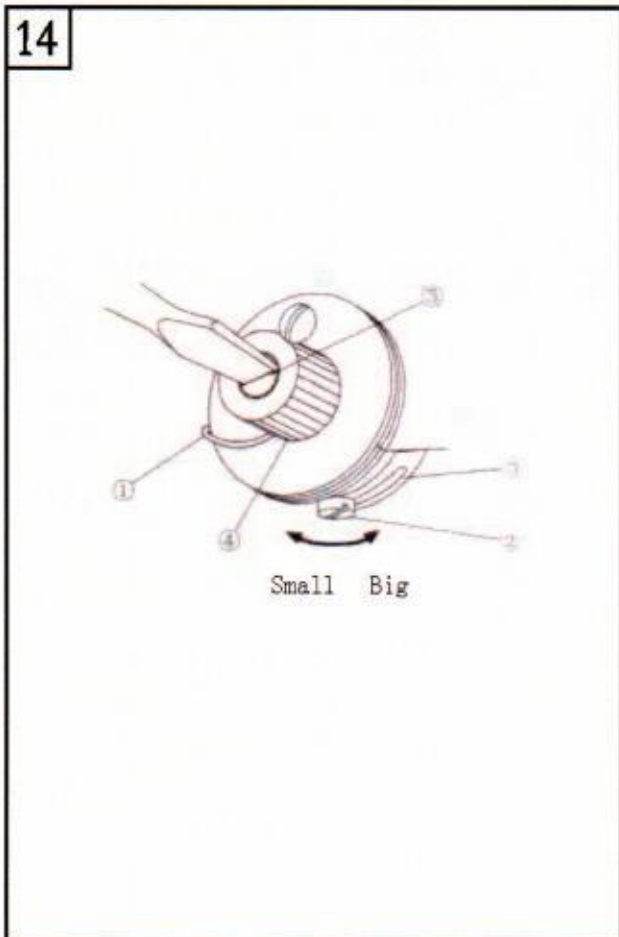


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15. Adjusting the thread tension (Figure 13)

1. Adjusting the tension of feeding thread
Turn the thread tension nut ① clockwise, than the tension of feeding thread increases; otherwise, the tension decreases.
2. Adjusting the tension of bottom thread
Turn the thread tension screw ② clockwise, than the tension of bottom thread increases; otherwise, the tension decreases.

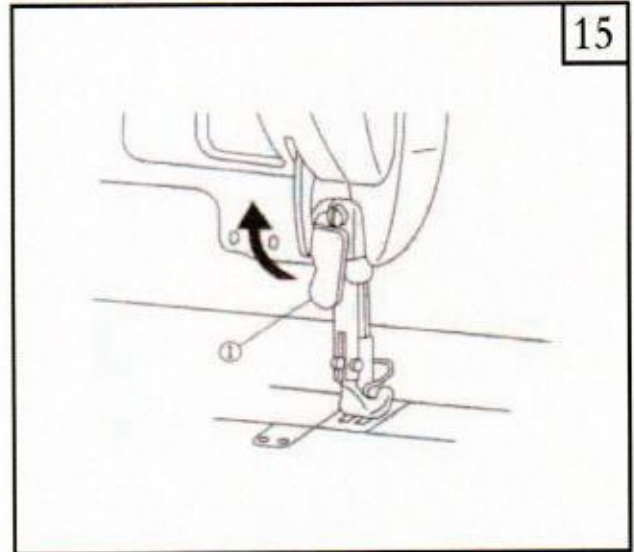


16. Adjusting the take-up spring (See Figure 14)

1. When changing the movement amount of the take-up spring
 - a. Loosen the fixed screw ② of the stopper and move the stopper ③ to the left or right in order to adjust the take-up spring ①.
 - b. The movement amount of the take-up spring increases if moving the stopper to the right; otherwise it decreases.
2. When changing the strength of the take-up spring
Loosen the nut ④. Then turn the spring shaft ⑤ anticlockwise, the strength increases; otherwise, it decreases.

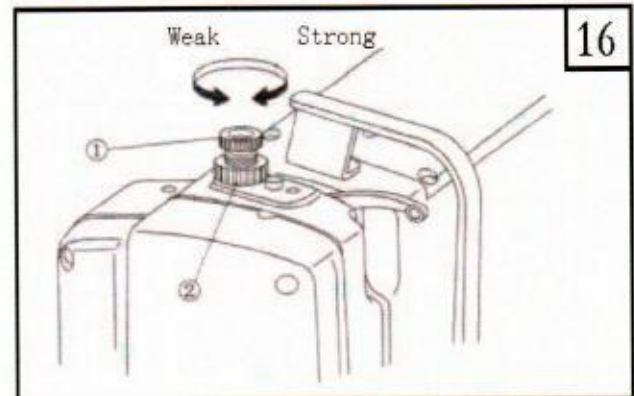
17. Lifting the pressure foot (See Figure 15)

1. When stopping the pressure foot in the rise position, uplift the pressure foot lifting bar① of presser spanner to the arrow position. Stop after the pressure foot rises 9mm.
2. Put down the presser spanner when lowering the pressure foot. It will be back to the original position.



18. Adjusting the pressure of the pressure foot (See Figure 16)

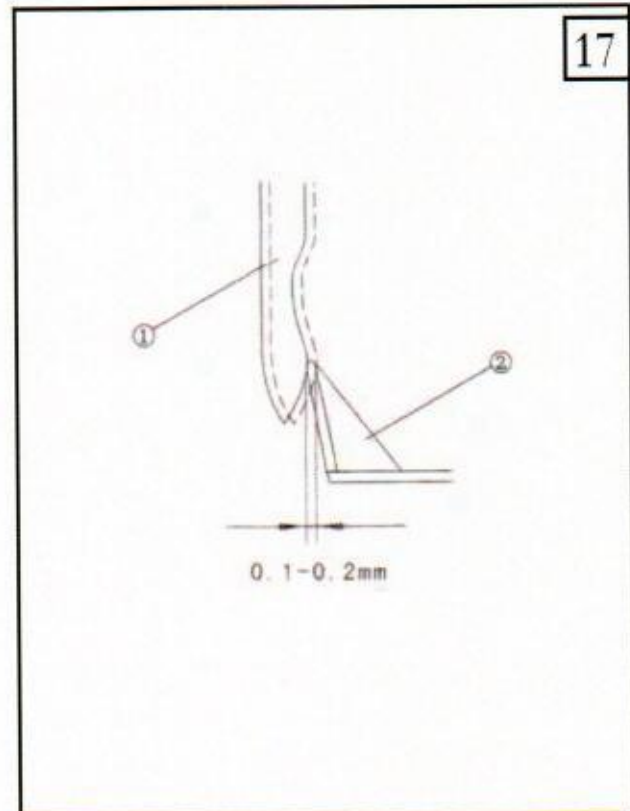
Move the pressure foot adjusting screw① to the right, than the pressure increases; otherwise, it decreases. Tighten the fixed nut② after adjusting.



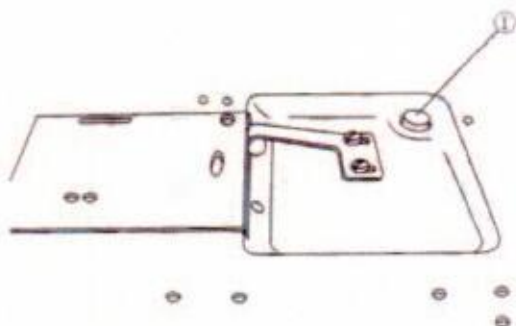
19. Adjusting the hook needle bed (See Figure 17)

Please confirm the position of the needle bed after changing the hook. When it is in standard position, the hook needle bed② is about 0.1~0.2mm away from the side of the needle. If it is incorrect, please curve the hook needle bed for adjusting.

1. When curving the hook needle bed inwards, insert the screwdriver into the outside of the hook needle bed.
2. When curving the hook needle bed outwards, insert the screwdriver into the inside of the hook needle bed.



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20. Resetting of the safety device

(See Figure 18)

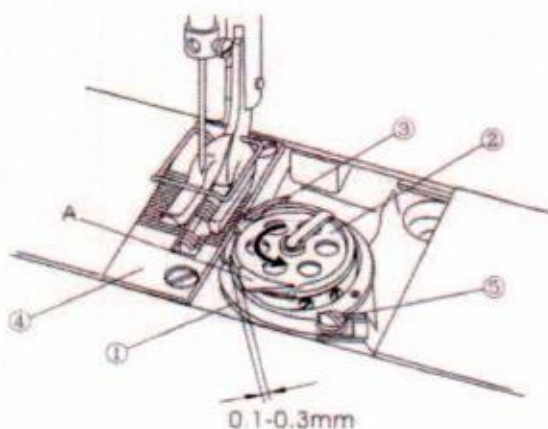
During the sewing, the safety device starts if exerting over-force on the hook. The hook of driving wheel fails to work at the moment. Please eliminate the failures prior to resetting after the safety device starts.

1. Press the button ① on the head and reverse the driving wheel with force.

2. Resetting is finished after you hear the sound of crack.

Note: Run the driving wheel with hands to confirm whether the button ① is reset.

19



21. Adjusting the length of stitches

(See Figure 19)

1. Turn the driving wheel to the normal direction and transfer the middle hook guide ① to the final position.

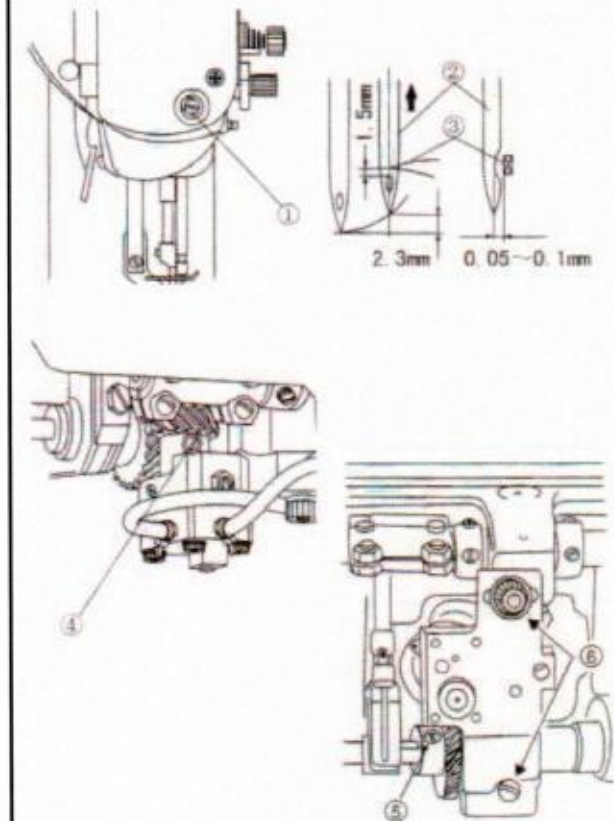
2. Turn ② to the arrow and make the middle hook stopper ③ to the slot of the needle ④.

3. Loosen the fixed screw ⑤ of the middle guide. Adjust the clearance between the middle hook guide and the bulge A of the hook cover to 0.1~0.3mm.

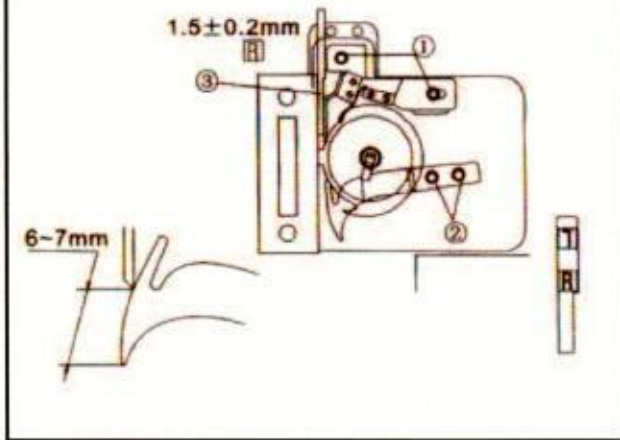
22. Relations between the needle and the hook
(See Figure 20)

1. Turn the adjusting knob of needle distance to 0.
2. Turn the driving wheel. After the lowest point of the needle bar rises to 2.3mm, loosen the needle bar joint screw①. Adjust the distance from the upper part of the needle hole of needle② to the hook top③ to 1.5mm and then tighten.
3. Turn the driving wheel. Rise the needle bar to 2.3mm from the lowest point. Adjust the centers of the hook top③ and the needle② to make them basically the same. Then tighten the fixed screws④ of two screw gears (smaller ones). Aim the first screw with V-shape front of the two fixed screws④ at the V-shape slot of the hook shaft. Then tighten and fix.
4. At the position where the centers of both the hook top③ and the needle② are basically the same, loosen the fixed screw⑥ of hook shaft pillow and then move it to the left or right in order to adjust the clearance between the hook top and the needle to 0.05~0.1mm. Then tighten the fixed screw⑥.
5. Loosen the fixed screw⑤ of two screw gears (bigger ones). Move the screw gear (bigger one) to the left or right to make the centers of the hook top③ and the needle② basically the same. Tighten the fixed screw⑤. Aim the first screw of two fixed screws⑤ at the flat part of the lower shaft and then tighten.

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21



23 Adjusting the cutter (See Figure 21)

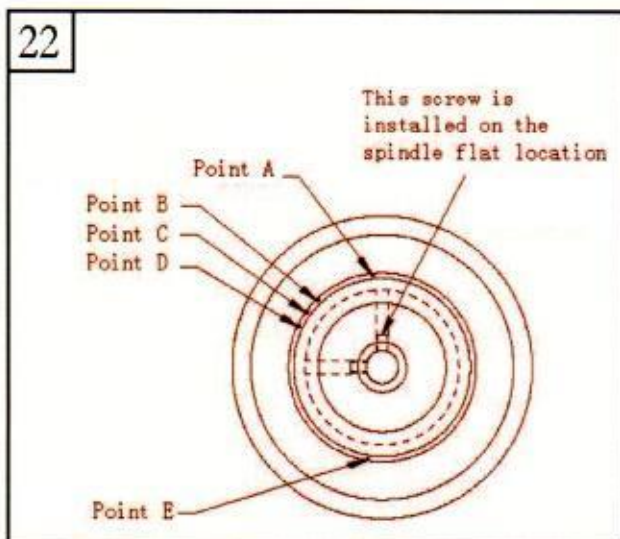
Adjusting the position of fixed cutter:

Loosen the fixed screw (1) of fixed cutter holder with the right and left sides of the fixed cutter front end respectively $1.5 \pm 0.2 \text{ mm}$ and $2 \pm 0.2 \text{ mm}$ away from the needle bed front end. The front and back of the cutter holder are up against the stairs of the shaft pillow and tighten the fixed screw (1). Please use the face R of fixed cutter scale (3) attached to determine the distance.

Adjust the pressure of cutter:

Loosen the fixed screw (2) of the moveable cutter. Turn the upper wheel and shift the moveable cutter to adjust its pressure. If the distance from the front end of moveable cutter to the front end of fixed cutter is $6 \sim 7 \text{ mm}$, the cutter pressure is standard.

22



24. Hand wheel points picture (See Figure 22)

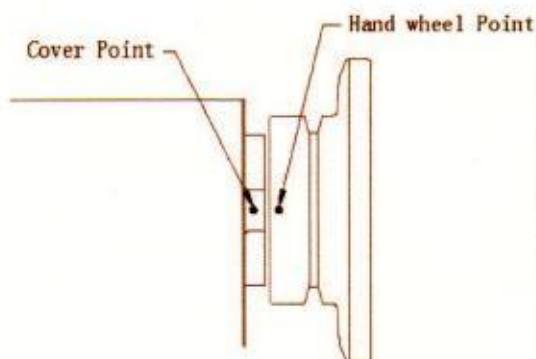
All mentioned hand wheel points (A-E) are subjected to the picture on the left.

25. Suspension position confirmation for the machine (See Figure 23)

When the points on the hand wheel are same as those on the cover, please adjust the every suspension position as follow.

Hand wheel point	Position of the machine
Point B-C	Position of upper stop needle
Point E	Position of lower stop needle
Point A	Thread cutting CAM adjustment
Point A	Reverse the position of lifting needle

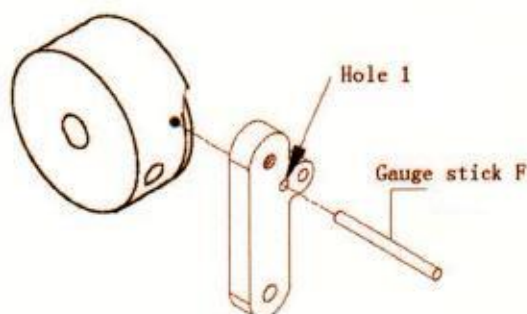
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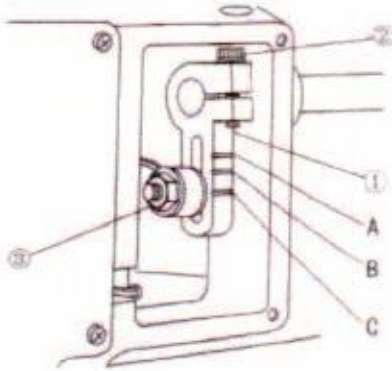
26. Adjustment of thread cutting CAM position (See Figure 24)

1. Make sure the point A on the hand wheel is also on the corresponding position of the cover.
2. Prepare one gauge stick F with 3mm diameter and 70mm length.
3. Please put the gauge stick F into the hole 1 of the parts, and be directed at the thread cutting CAM setting points.
4. Please fix the thread cutting CAM screw, then put out the measurement stick F.

24



21



About up-and-down alternation amount

Scale A	About 5mm
Scale B	About 4mm
Scale C	About 3mm

27. Adjusting the alternation amount of the pressure foot (See Figure 21)

As for the alternative rise amount of the press foot, it is generally adjusted within the long hole of the upper feed crank① when increasing the alternative rise amount. If decreasing the alternative rise amount, adjusting downward and then tighten the nut③.

If the rise amount for the bigger pressure foot and the smaller one differs, move the undersurface of both the bigger pressure foot and the smaller one to the position on the needle bed. Then loosen the fixed screw② of the crank to turn the driving wheel to the front. Tighten the screw②. The rise amount of the bigger pressure foot is more than that of the smaller one. Reverse the driving wheel then the rise amount of the smaller pressure foot is more than that of the bigger one.

Dismantle the right side of the window panel; then you can see the upper feed crank①.

28. List of sewing speed

Up-and-down alternation amount	Stitch: less than 6mm	Stitch: 6mm~9mm
Less than 3mm	2,500rpm	2,000rpm
3mm~4mm	2,000rpm	2,000rpm
4mm~6.5mm	1,600rpm	1,600rpm

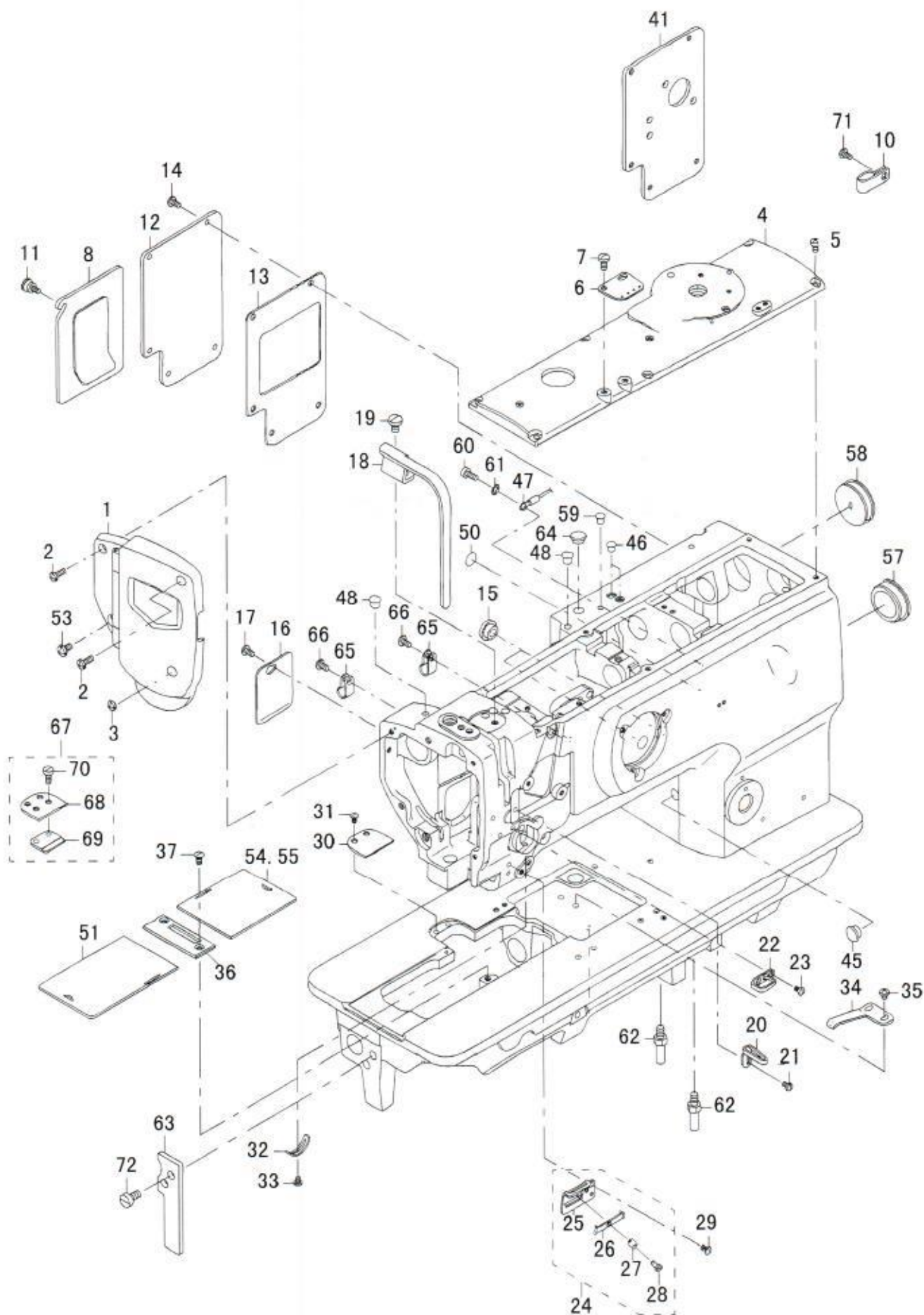
Set the maximum revolution according to different conditions. Please don't exceed the set value.

29. Sewing problems and troubleshooting

Problems	Causes	Troubleshooting
<p>1. Broken stitching (feeding thread residue of 2~3mm on the back of the fabric)</p>	<p>①Scars on the thread, needle top, hook top and the fixed slot on the hook inner circle of the needle bed. ②Strong upper tension. ③The needle touches the hook top. ④The oil is insufficient in the hook. ⑤Weak feeding thread tension. ⑥Powerful take-up spring and small transfer amount. ⑦Over fast or over slow synchronization of the needle and the hook.</p>	<p>○Polish the scars on the hook top with fine sand paper. File the inner circle fixing slot of the hook of the needle bed. ○Reduce the feeding thread tension. ○Refer to the content in 19. Relations between the Needle and the Hook. ○ Adjust the oil quantity (Refer to the content in 7. Oiling.) ○Increase the feeding thread tension. ○Weaken the take-up spring and increase the movement amount. ○Refer to the content in 19. Relations between the Needle and the Hook.</p>
<p>2. Skipped stitching</p>	<p>①Over fast or over slow synchronization of the needle and the hook. ②Weak pressure for the pressure foot. ③Incorrect clearance between the upper part of the needle hole and the hook top. ④Wrong needle type.</p>	<p>○Refer to the content in 19. Relations between the Needle and the Hook. ○Tighten the adjusting screw of the pressure foot. ○Refer to the content in 19. Relations between the Needle and the Hook. ○Change to a little bit bigger needle.</p>
<p>3. poor stringing</p>	<p>①Not threading under the thread tension spring of the hook cover. ②Poor processing of the thread. ③The hook core doesn't slide. ④Weak bottom thread tension. ⑤Strong bottom thread winding. ⑥Damaged needle top.</p>	<p>○Refer to the content in 9. Threading of the Bottom Thread. ○Polish with fine sand paper or file. ○Change the hook core or hook. ○Increase the bottom thread tension. ○Decrease the bottom thread winding tension. ○Change the needle.</p>

PARTSBOOK

1. Frame & miscellaneous cover

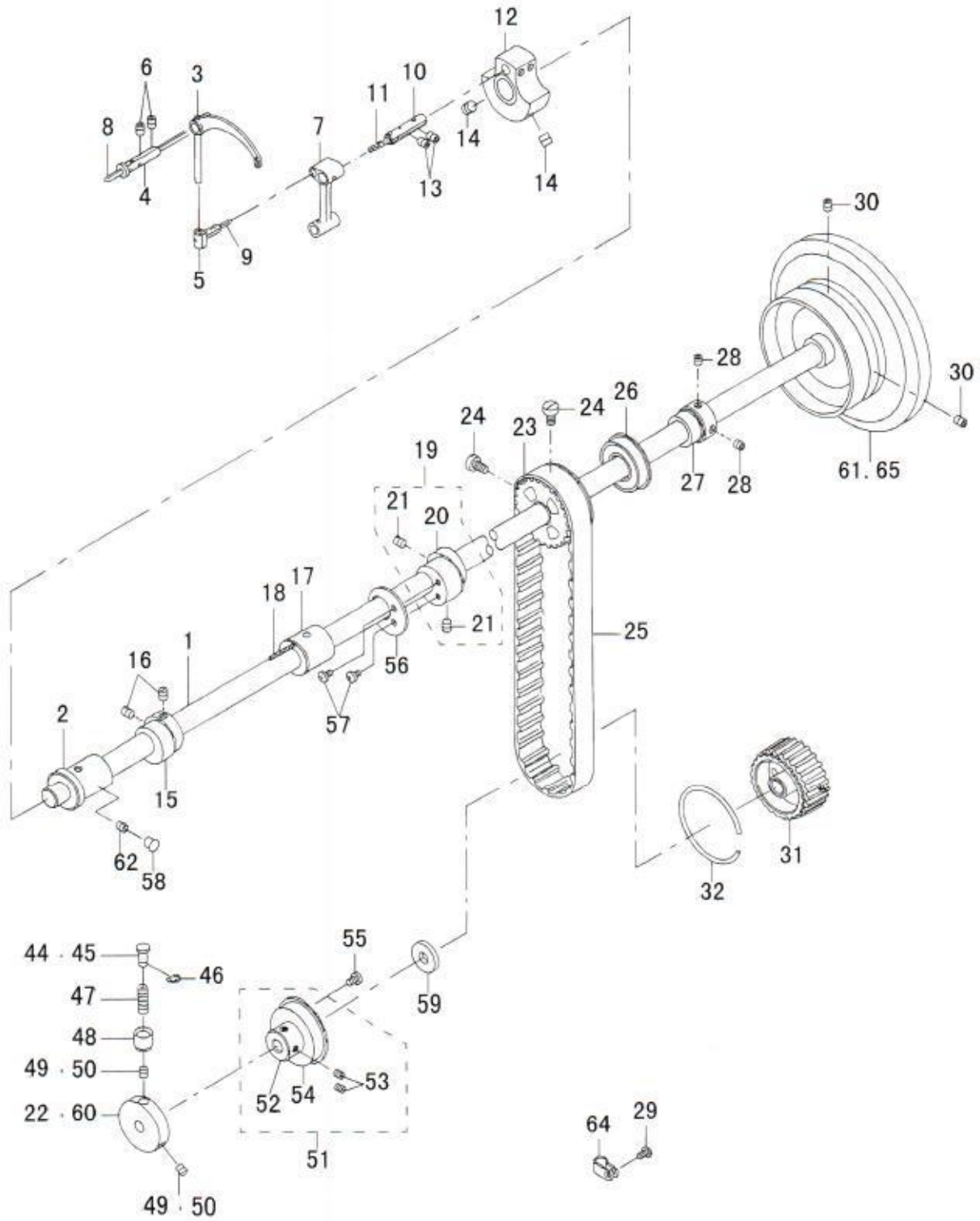


DESCRIPTION

1	40016798	FACE PLATE ASM.	1
2	SS4111215SP	SCREW 11/64-40 L=12	2
3	TA1250406RO	RUBBER PLUG	1
4	21331301	TOP COVER B	1
5	SS4110815SP	SCREW 11/64-40 L=8	6
6	21355904	ARM THREAD GUIDE	1
7	SS7621040SP	SCREW 3/16-32 L= 9.5	2
8	#01 21331756	WINDOW PLATE A ASM.	1
10	#03 D2112555B00	CORD HOLDER LARGE	1
11	21331202	SETSCREW	1
12	#01 21331806	WINDOW PLATE B	1
13	#01 21332002	WINDOW PLATE PACKING B	1
14	SS4110815SP	SCREW 11/64-40 L=8	5
15	TA1250504RO	RUBBER PLUG	2
16	#01 21332309	SIDE COVER	1
17	#01 SS4110815SP	SCREW 11/64-40 L=8	1
18	21331608	BALANCE COVER	1
19	SS7150910TP	SCREW 15/64-28 L=9	1
20	21355805	THREAD GUIDE	1
21	SS5090610SP	SCREW 9/64-40 L=6	1
22	B1129051000	FRAME THREAD GUIDE UPPER	1
23	SS2090710TP	SCREW 9/64-40 L=7.2	2
24	21408554	THREAD GUIDE ASM.	1
25	21408505	THREAD GUIDE PLATE	(1)
26	17912106	NEEDLE THREAD PRESSER PLATE	(1)
27	B1132521000	THREAD PRESSER PLATE SPRING	(1)
28	SD0380551SL	HINGE SCREW D= 3.80 H= 5.5	(1)
29	SS2090710TP	SCREW 9/64-40 L=7.2	1
30	22651202	AUXILIARY COVER	1
31	SS2090710TP	SCREW 9/64-40 L=7.2	2
32	B3138512000	TAKE-UP SPRING ADJUSTING PLATE	1
33	SS7090520TP	SCREW 9/64-40 L= 4.5	1
34	B1111563000	BED SLIDE SPRING	1
35	SS4110515SP	SCREW 11/64-40 L=5	2
36	B1109563000	FALLER	1
37	SS2110920TP	SCREW 11/64-40 L=8.5	2
41	#03 21348909	WIDOW PLATE D	1
45	TA1050504RO	RUBBER PLUG	1
46	TA1050504RO	RUBBER PLUG	2
47	#03 22951552	GROUND WIRE ASM.	1
48	TA1050504RO	RUBBER PLUG	2
50	22901805	GROUND MARK	1
51	21349600	BED SLIDE(LEFT) A	1
53	SS4111215SP	SCREW 11/64-40 L=12	1
54	#03 21349808	BED SLIDE(RIGHT) A	1
55	#01 21349600	BED SLIDE(RIGHT) A	1
57	22619100	CAP	1
58	10201200	RUBBER PLUG	1
59	TA1050504RO	RUBBER PLUG	1
60	#03 SS6111140SP	SCREW 11/64-40 L=11	1
61	#03 WT0530002KS	TOOTHED WASHER D=5.3	2
62	22602601	BED SCREW STUD	2
63	21361407	BED SUPPORT PLATE	1
64	TA1050504RO	RUBBER PLUG	1
65	#03 HX00123000A	CABLE CLIP	2
66	#03 SS4110815SP	SCREW 11/64-40 L=8	2
67	#01 23208556	AUXILIARY COVER ASM.	1
68	#01 23208507	AUXILIARY COVER	(1)
69	#01 23208606	SLIDING PLATE SUPPORT	(1)
70	#01 SS2090710TP	SCREW 9/64-40 L=7.2	4
71	#03 SS4110815SP	SCREW 11/64-40 L=8	1
72	SS6151210SP	SCREW 15/64-28 L=12	2

#01 FOR 1515 #03 FOR 1515AUT

2. Upper shaft, lower shaft driving & balance components

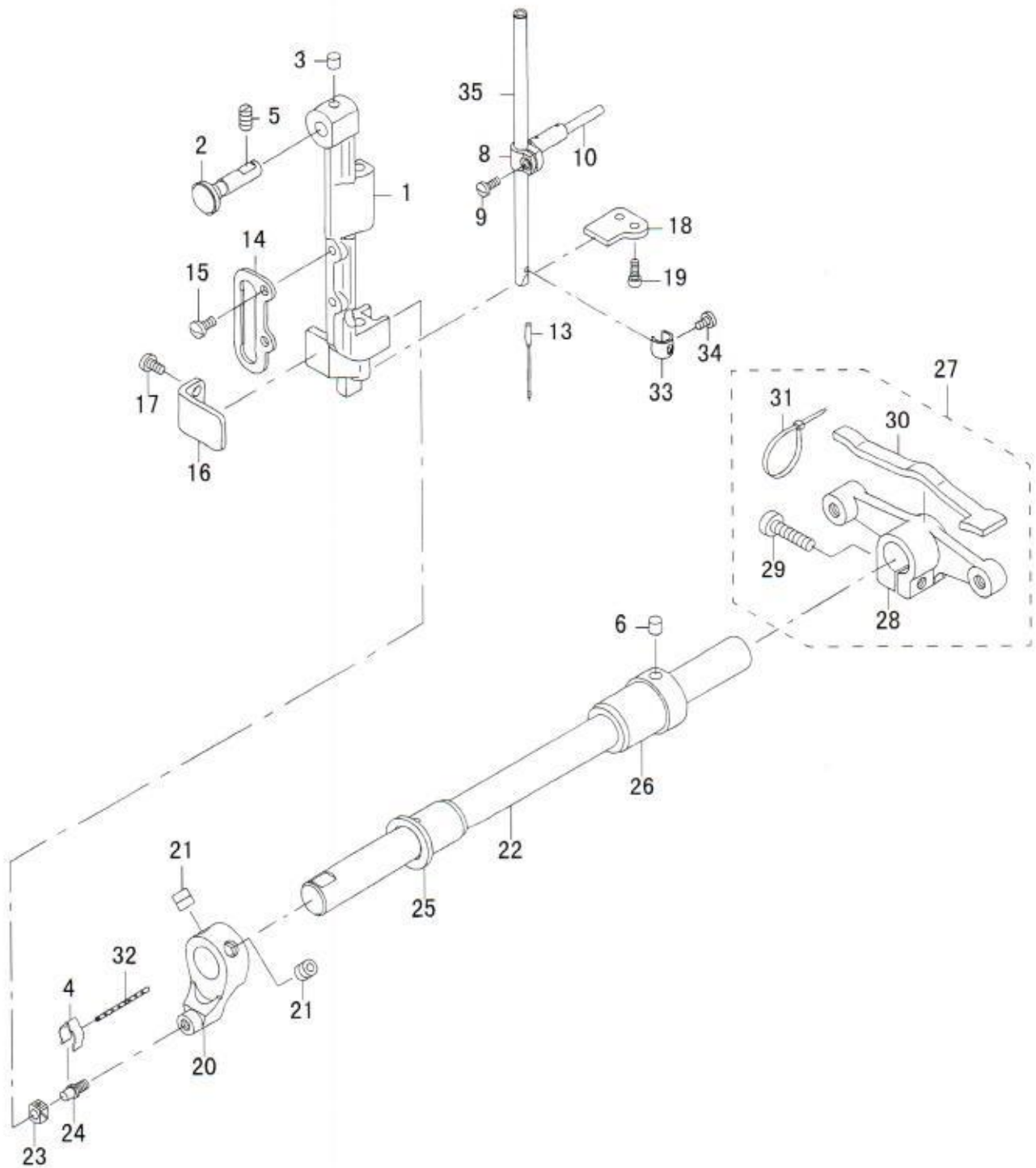


DESCRIPTION

1	21332705	UPPER SHAFT	1
2	21333000	UPPER SHAFT FRONT METAL	1
3	B1905520000	THREAD TAKE-UP LEVER	1
4	B1906051000	TAKE-UP LEVER PIN	1
5	B1907057000	THRUST PIN	1
6	SS8150822TP	SCREW 15/64-28 L=8	1
7	21339106	NEEDLE BAR CRANK ROD	1
8	CQ202000000	OIL WICK	0.45
9	CQ202000000	OIL WICK	0.03
10	B1210051000	NEEDLE BAR CRANK PIN	1
11	CQ202000000	OIL WICK	1
12	21332507	COUNTER WEIGHT (A) (36MM)	1
13	SS8150822TP	SCREW 15/64-28 L=8	2
14	SM8080812TP	SCREW M8X8	2
15	21339502	UPPER FEED CAM (3.5)	1
16	SS8660810TP	SCREW 1/4-40 L=8	2
17	21333109	UPPER SHAFT INNER METAL	1
18	CQ202000000	OIL WICK	0.15
19	21336557	ECCENTRIC CAM A ASM.	1
20	21336508	ECCENTRIC CAM A	1
21	SS8660810TP	SCREW 1/4-40 L=8	2
22	#01 21333703	SAFETY CLUTCH DISC	1
23	22604904	UPPER SPROCKET	1
24	SS6661110SP	SCREW 1/4-40 L=11	2
25	22604300	TIMING BELT	1
26	B1203512000	BUSHING REAR	1
27	21402300	UPPER SHAFT BEARING HOOK	1
28	SM8060602TP	SCREW M6X6	2
29	SS4110815SP	SCREW 11/64-40 L=8	1
30	SS8150822TP	SCREW 15/64-28 L=8	2
31	21387501	SPROCKET WHEEL	1
32	B1214019000	SPROCKET RING	1
43	SS8111010TP	SCREW 9/64-40 L=9.5	1
44	#01 B1312563000A	SAFETY CLUTCH PUSH BUTTON	1
45	#03 21333802	SAFETY CLUTCH PUSH BUTTON	1
46	KHZ6	E-RING	1
47	B1639051000	SPRING	1
48	B1313055000	SAFETY CLUTCH KNOB SLEEVE	1
49	#01 SS8150710TP	SCREW 15/64-28 L=7	2
50	#03 SS8660530TP	SCREW 1/4-40 L= 4.5	2
51	40038700	THRUST COLLAR ASM.	1
52	40038702	THRUST COLLAR	(1)
53	SS8661030SP	SCREW 1/4-40 L=10	(2)
54	SB120000200	BEARING 20X42	1
55	SS7120760SP	SCREW 3/16-28 L= 7.0	2
56	21353008	HORIZONTAL FEED CAM COVER	1
57	SS7110710SP	SCREW 11/64-40 L=7	2
58	TA0750704R0	RUBBER PLUG	1
59	40016148	THRUST COLLAR B WASHER	1
60	#03 21333901	SAFETY CLUTCH DISC	1
61	#01 21334008	FLYWHEEL	1
62	SS8150710TP	SCREW 15/64-28 L=7	1
63	21387907	ADJUSTING PIN (1.2)	1
64	HX00123000A	CABLE CLIP	1
65	#03 21427000	FLYWHEEL	1

#01 FOR 1515 #03 FOR 1515AUT

3. Needle bar rocking

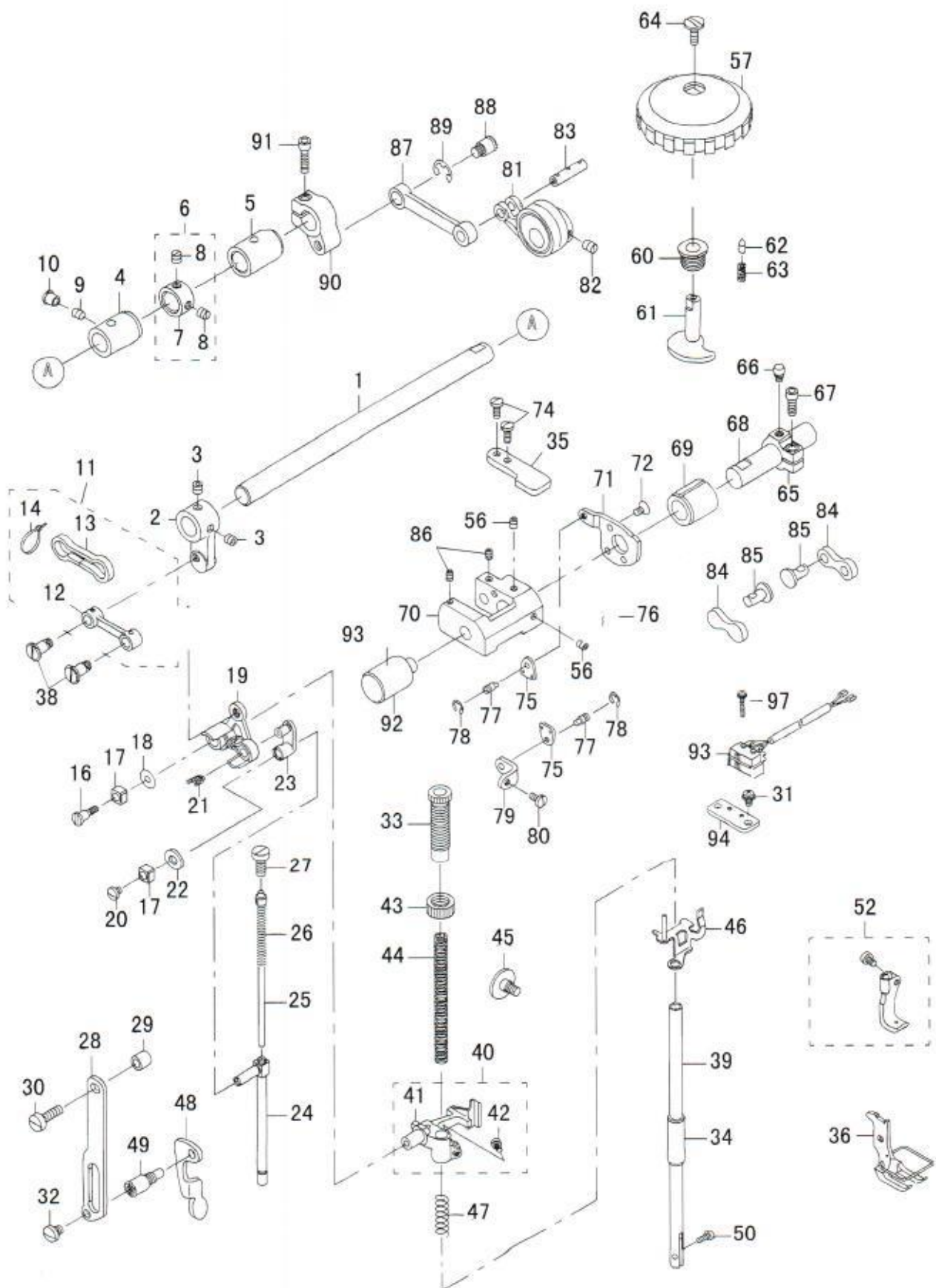


DESCRIPTION

1	B142056000	NEEDLE BAR FRAME	1
2	21405204	HINGE STUD	1
3	22814909	FELT	1
4	B1437051000	OIL WICK RETAINER	1
5	SS8151150TP	SCREW 15/64-28 L=10.5	1
6	22814909	FELT	1
8	B1411521000	NEEDLE ROD HOLDER	1
9	SS7090910SP	SCREW 9/64-40 L= 8.5	1
10	B1412051000	FELT	1
13	MC372001600	NEEDLE SY3355 160	2
14	B1467563000	UPPER FEED BAR GUIDE	1
15	SS7110910TP	SCREW 11/64-40 L= 8.5	2
16	21388400	ROCKING BASE GUIDE	1
17	SS7110830SP	SCREW 11/64-40 L= 7.5	2
18	21338603	ROCKING BASE GUIDE (B)	1
19	SS6091022TP	SCREW	2
20	21338801	ROCKING FRONT ARM	1
21	SM8080812TP	SCREW	2
22	21338900	ROCKING SHAFT	1
23	B1414232000	SQUARE BLOCK	1
24	B1410771000	STUD	1
25	21339304	ROCKING SHAFT FRONT METAL	1
26	40027746	BUSHING REAR	1
27	21339056	ROCKING REAR ARM ASM.	1
28	21339007	ROCKING REAR ARM	1
29	SS6152440SP	SCREW 15/64-28 L=23.5	-1
30	21347406	ROCKING REAR ARM FELT	1
31	EA9500B0100	CABLE BAND	2
32	CQ202000000	OIL WICK	0.05
33	10308609	THREAD GUARD	1
34	SS7080510TP	SCREW 1/8-44 L=4.5	1
35	B1401053000	NEEDLE BAR	1

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4. Pressure adjusting & upper feed mechanism

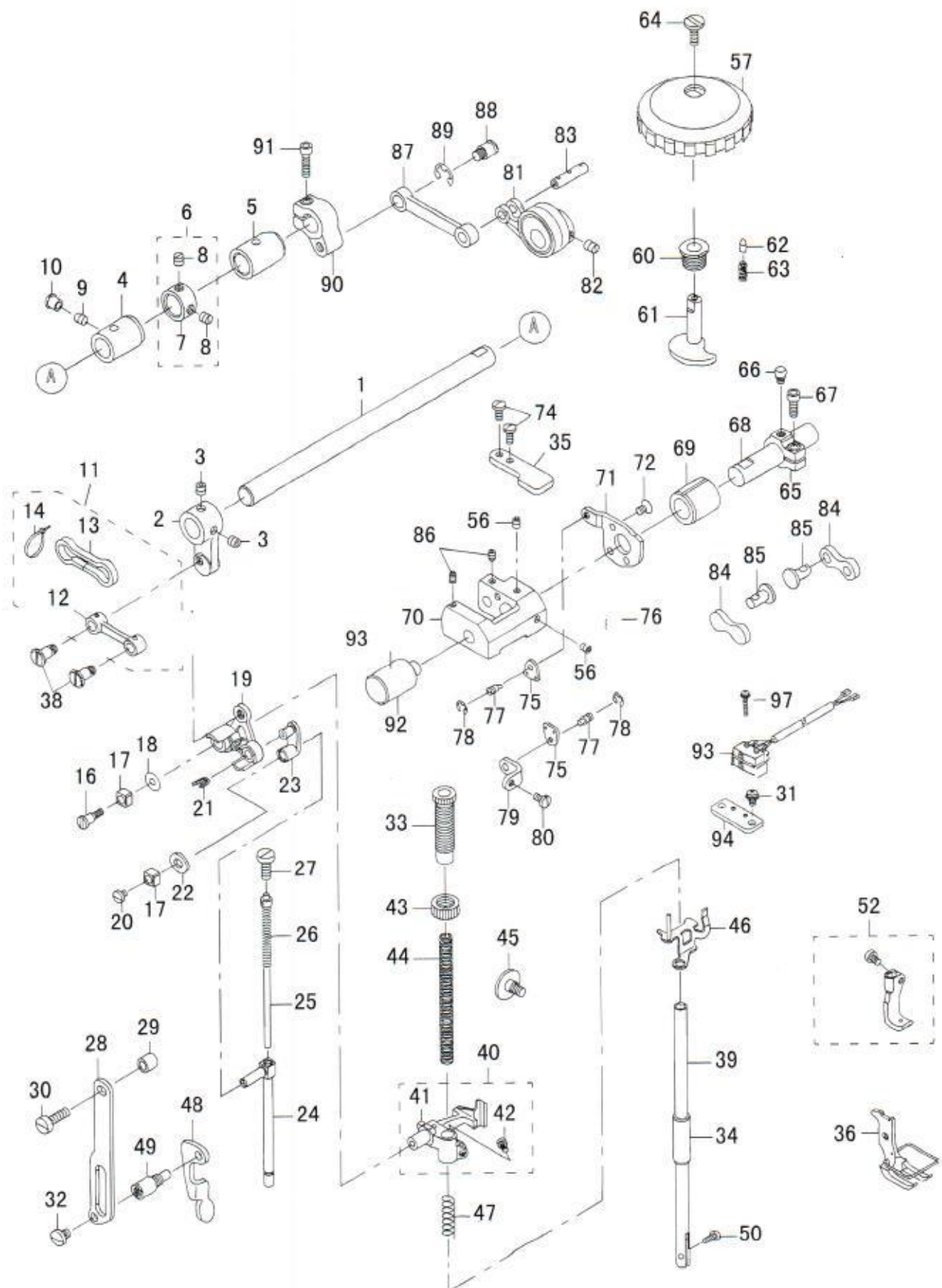


DESCRIPTION

1	21340401	UPPER FEED SHAFT	1
2	21340500	UPPER FEED FRONT ARM	1
3	SS8660612TP	SCREW 1/4-40 L=6	2
4	21341904	FRONT METAL	1
5	21378302	FEED SHAFT METAL	1
6	22904155	MAIN SHAFT THRUST COLLAR ASM.	1
7	22904106	MAIN SHAFT THRUST COLLAR	-1
8	SS8660610TP	SCREW 1/4-40 L=6	2
9	SS8150822TP	SCREW 15/64-28 L=7	1
10	TA0750704RO	RUBBER PLUG	1
11	40033027	UPPER FEED LINK ASM.	1
12	21339908	UPPER FEED LINK	-1
13	21347109	FELT	-1
14	EA9500B0000	CLIP CV-70S	-2
16	SD0640701SP	SCREW	1
17	B1414555000	SLIDE BLOCK	2
18	WP0501046SC	WASHER 5 X 13 X 1	1
19	21340807	TRIANGULAR LEVER ASM.	1
20	SS7110710SP	SCREW 11/64-40 L=7	1
21	CQ252000000	OIL WICK	0.02
22	10509701	FELT	1
23	B1465053000	WALKING BAR DRIVING LINK	1
24	B1466563000	WALKING BAR A	1
25	B14670530A0	WALKING BAR ASM.	1
26	B1468053000	WALKING BAR SPRING	1
27	SS6151780SP	SCREW 15/64-28 L=17.0	1
28	21406509	UPPER FEED GUIDE PLATE	1
29	13514310	ROLLER	
30	SS6151920SP	SCREW 15/64-28 L=19.0	1
31	#03 SM6040800SP	SCREW M4 L=8	2
32	SS7150740SP	SCREW 15/64-28 L=7	1
33	21340906	PRESSER ADJUSTING SCREW	1
34	B1510155000	PRESSER BAR LOWER BUSHING	1
35	21339700	UPPER FEED STOPPER PLATE	1
36	B1525241HA0	PRESSER FOOT ASM. 3/8	1
37	SS4110815SP	SCREW 1/4-40 L=8	2
38	B3016141H00	SCREW	2
39	B1501241H00	PRESSER BAR	1
40	21341052	PRESSER BAR HOLDER A ASM.	1
41	21341053	PRESSER BAR HOLDER A	1
42	SS7110910TP	SCREW 11/64-40 L= 8.5	1
43	B1511555000	PRESSER SPRING REGULATOR NUT	1
44	B1502246000	PRESSER SPRING	1
45	SD0800481SP	HINGE SCREW D= 8 H= 4.9	1
46	21341151	HOLDING PLATE COMPL.	1
47	B1462053000	THREAD RELEASE SPRING	1
48	21406103	PRESSER LIFTER LEVER	1
49	21406608	GUIDE PLATE SPACER	1
50	SS6090910TP	SCREW 9/64-40 L=9	1

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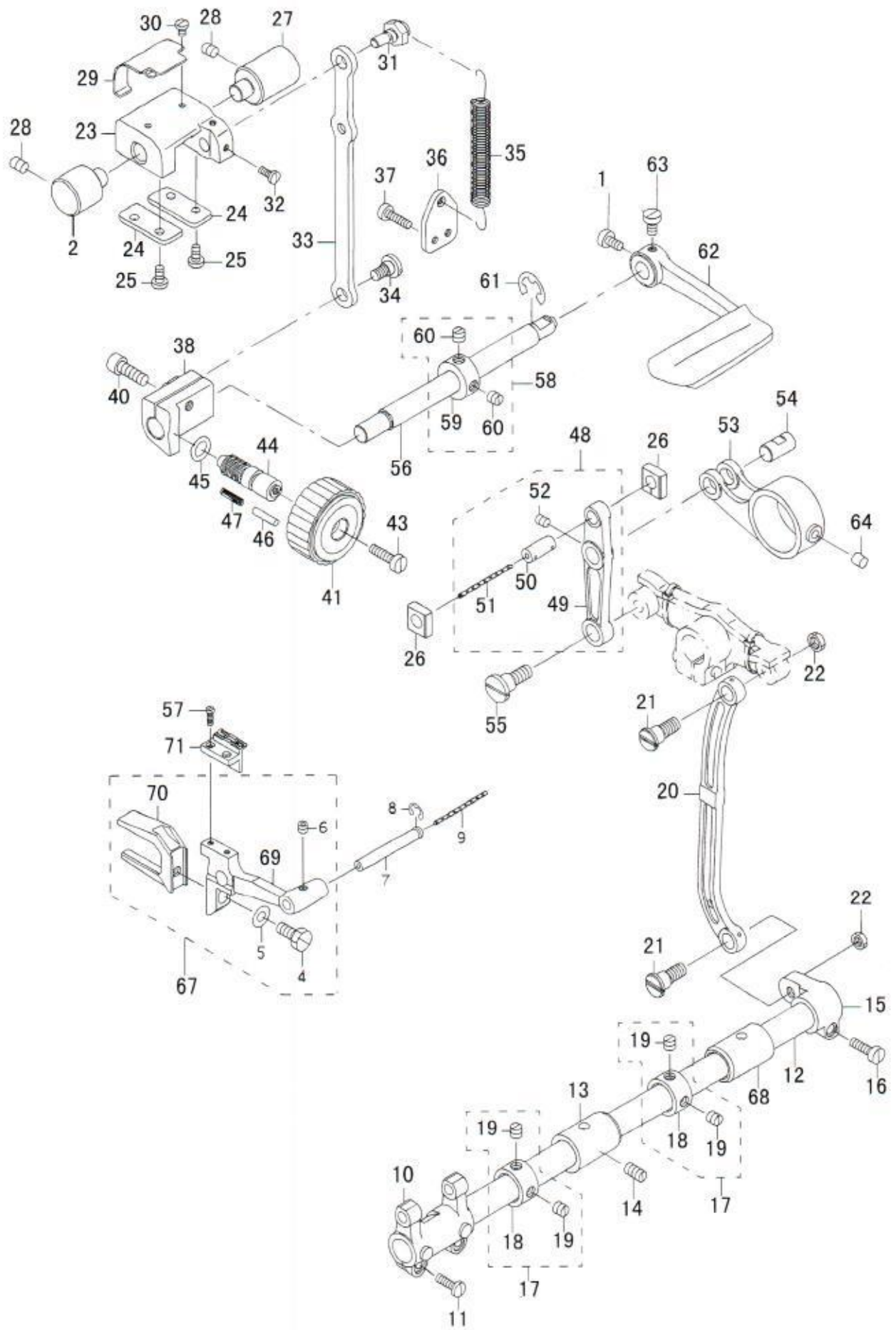
4. Pressure adjusting & upper feed mechanism



DESCRIPTION

52	B1470241H00	WALKING FOOT ASM.	1
56	SM8050602TP	SCREW M5 L=6	2
57	10774354	UPPER AND LOWER DIAL ASM.	(1)
60	10715100	VERTICAL DIAL SHAFT BUSHING	1
61	10715001	VERTICAL ADJUSTING CAM	1
62	10715704	VERTICAL DIAL PIN	1
63	B152652700G	SPRING	1
64	SS6110630TP	SCREW 11/64-40 L=6	1
65	21341607	VERTICAL ADJUSTING ARM	1
66	10715308	PIN	1
67	SM6051402TP	SCREW M5X0.8 L=14	1
68	21341508	VERTICAL CHANGE BASE SHAFT	1
69	10718203	FEED SHAFT FRONT METAL	1
70	10714202	VERTICAL CHANGE BELT	1
71	21438106	STOPPER PLATE B	1
72	SM1050801SR	SCREW M5 L=8	1
74	SS4110815SP	SCREW	2
75	10713501	SPRING HOOK	2
76	10716504	VERTICAL SHAFT SPRING	1
77	B3416552000	CONNECTING ROD HINGE SCREW	2
78	RE0500000K0	E-RING	2
79	21339809	UPPER FEED DOG SPRING HOOK	1
80	SS7110830SP	SCREW 11/64-40 L= 7.5	1
81	10713766A	ECCENTRIC ROD (SET)	1
82	SS8660810TP	SCREW 1/4-40 L=8	2
83	10713808	CONNECTION LINK PIN B	1
84	10714509	CONNECTION LINK B	2
85	10714608	CONNECTION LINK B SUPPORT PIN	2
86	SM8050602TP	SCREW M5 L=6	2
87	21340005	UPPER FEED LINK (B)	1
88	21048707	HINGE SCREW	1
89	RE0800000K0	E-SHAPED SNAP RING (8MM)	1
90	21340302	UPPER FEED REAR ARM (B)	1
91	SM6052002TP	SCREW M5 L=20	1
92	21337803	FEED ADJUSTING BASE SUPPORT	1
93	#03 40024852	VERTICAL DETECTOR SWITCH ASM	1
94	#03 020494	VERTICAL DETECTOR SWITCH ASM.	1
97	#03 020497	SCREW M2.5*16	2
		#01 FOR 1515 #03 FOR 1515AUT	

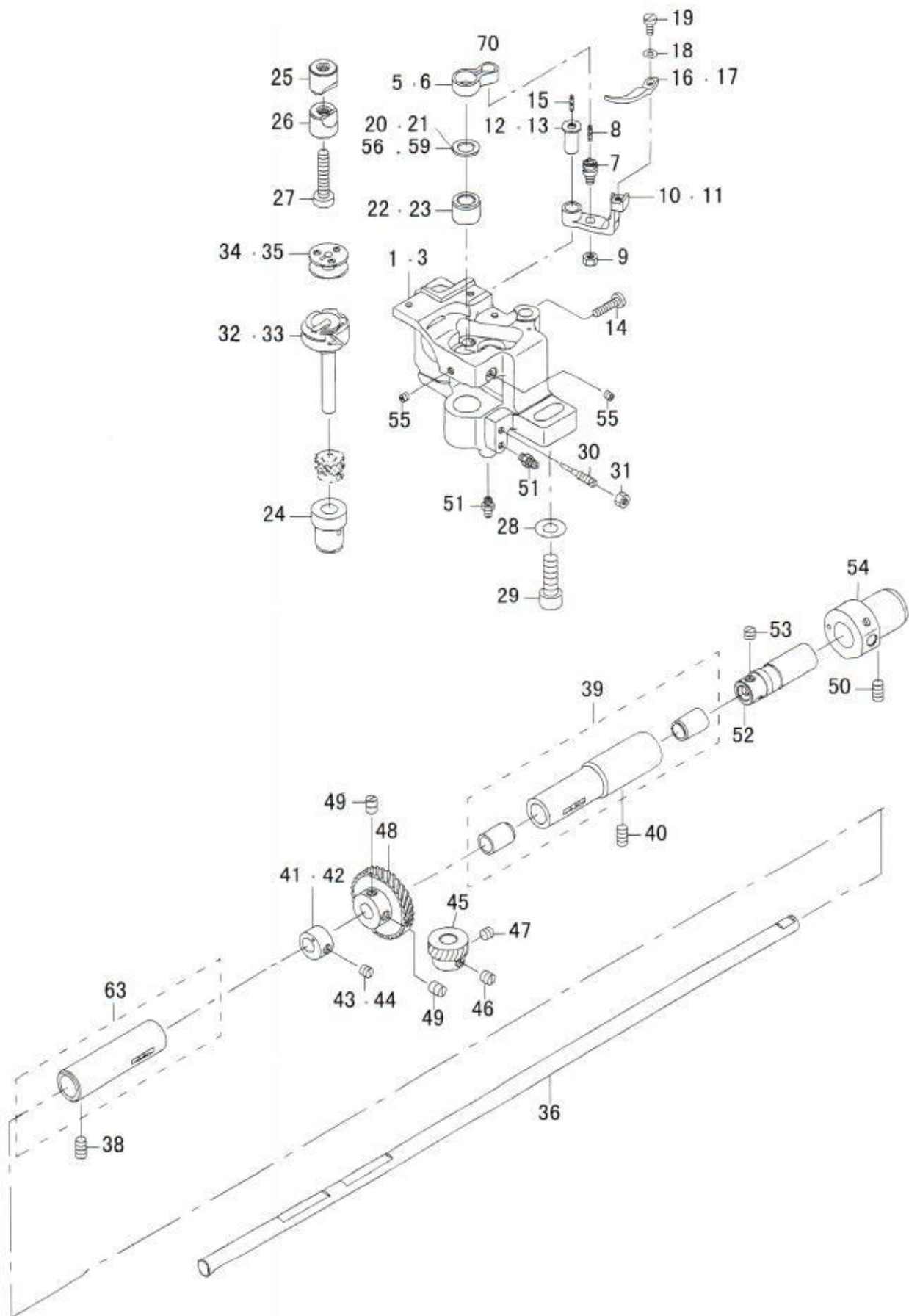
5. Feed mechanism



DESCRIPTION

1	SS7150910TP	SCREW 15/64-28 L=9	1
2	21430400	FEED ADJUSTING BASE SUPPORT	1
4	SS9151440CP	SCREW 15/64-28 L=14	1
5	WP0621016SD	WASHER 6. 2X13X1	1
6	SM8050502TP	SCREW M5 L=5	1
7	B1604012000A	FEED BAR SHAFT	1
8	RE0500711KP	SNAP RING 5	1
9	CQ202000000	OIL WICK	0.14
10	B1603512000	FEED ROCKER	1
11	SS7111410SP	SCREW 11/64-40 L=14	2
12	22609408	FEED ROCK SHAFT	1
13	21378302	FEED SHAFT METAL	1
14	020514	SCREW 11/64-40 L=8.5	2
15	22609309	FEED ROCKER SHAFT CRANK	1
16	SS6121610TP	SCREW 3/16-28 L=15.5	1
17	22904155	MAIN SHAFT THRUST COLLAR ASM.	2
18	22904106	MAIN SHAFT THRUST COLLAR	(1)
19	SS8660610TP	SCREW 1/4-40 L=6	(2)
20	10205201	NEEDLE BAR FRAME ROD	1
21	SD0900701TP	HINGE SCREW D= 9 H= 7	1
22	NS6680320SP	NUT 9/32-28	1
23	21337506	FEED ADJUSTING BASE	1
24	21337704	FEED ADJUSTING BASE COVER	2
25	SS7110910TP	SCREW 11/64-40 L= 8.5	4
26	21337407	SQUARE BLOCK	2
27	21337803	FEED ADJUSTING BASE SUPPORT	2
28	SS8150822TP	SCREW 15/64-28 L=8	2
29	21338306	FELT SUPPORT	1
30	SS5090610SP	SCREW 9/64-40 L=6	2
31	21337902	ECCENTRIC PIN	1
32	SS709010TP	SCREW 9/64-40 L= 8.5	2
33	21337308	FEED ADJUSTING ROD	1
34	SD0800402TP	HINGE SCREW D= 8 H= 4	1
35	21337605	SPRING	1
36	21338009	SPRING HOOK	1
37	SS7111410TP	SCREW 11/64-40 L=16	2
38	21337209	FEED ADJUSTING A	1
39	B1610512000	FEED DRIVING SLIDE BLOCK	1
40	SM6061802TP	SCREW M6 L=18	1
41	21336805	FEED DIAL A	1
43	SS6121860SP	SCREW 3/16-28 L=18	1
44	11009909	FEED REGULATOR SCREW	1
45	RO092270200	RUBBER RING	1
46	11652701	FEED REGULATOR PIN	1
47	22912109	FEED REGULATOR PIN SPRING	1
48	21336656	FEED LINK ASM.	1
49	21336607	FEED LINK	(1)
50	B1418761000	CONNECTING FORKED LINK PIN	1
51	CQ202000000	OIL WICK	0.04
52	SM8050502TP	SCREW M5X6	1
53	21336706	FEED ROD A	1
54	21338207	FEED LINK PIN	1
55	SD1000801SH	HINGE SCREW D=10 H=8	1
56	21336300	BACKWARD FEED LEVER SHAFT	1
57	SS6580752TP	SCREW 1/8-40 L=7	2
58	CS1201010SH	THRUST COLLAR ASM. D=12 W=10	1
59	CS1201011SH	THRUST COLLAR D=12 W=10	(1)
60	SS8660610TP	SCREW 1/4-40 L=6	(2)
61	RE0900000K0	E-RING 9	1
62	22610505	REVERSE FEED ROCK SHAFT	1
63	SS6120930TP	SCREW 3/16-28 L=9	2
64	22814909	FELT	1
67	21364252	FEED BASE ASM.	1
68	020568	FEED SHAFT METAL	1
69	21336003	FEED BASE	1
70	10107902	FEED BAR FORK	1
71	B1109562000	FEED	1

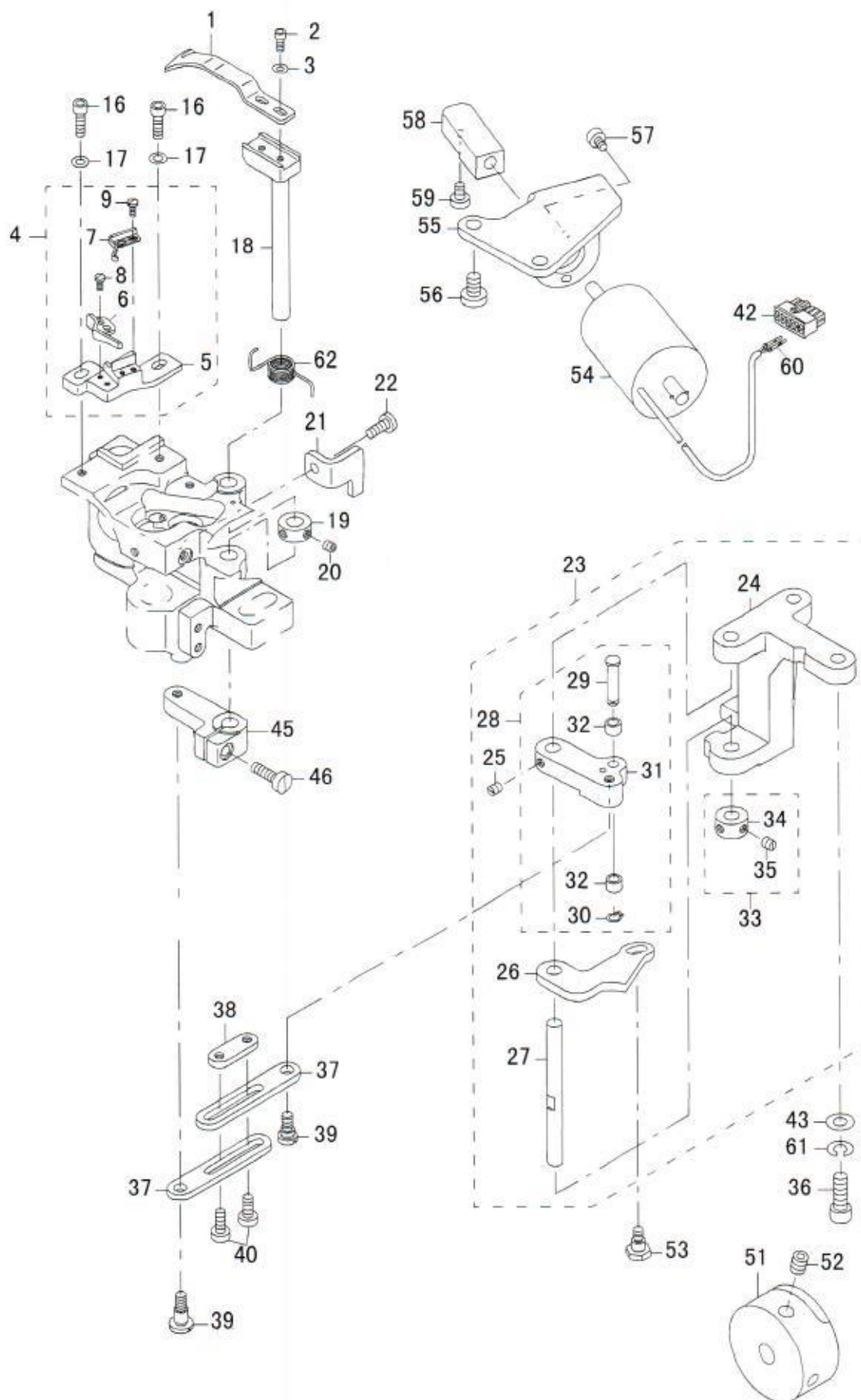
6. Hook shaft & upper feed mechanism



DESCRIPTION			
1	#03	21390000	HOOK SHAFT BASE (RIGHT) 1
3	#01	21335104	HOOK SHAFT BASE (RIGHT) 1
5	#03	21334909	INNER HOOK GUIDE LINK 1
6	#01	21334909	BOBBIN CASE OPENING LEVER LINK 1
7		B1821051000	CRANK SCREW STUD 1
8		CQ202000000	OIL WICK 0.02
9		NS6110420SP	NUT 11/64-40 1
10	#03	21335500	GUIDE ARM (FOR THREAD CUTTING) 1
11	#01	B1822563000	BOBBIN CASE OPENING LEVER CRAN 1
12	#03	21335708	INNER HOOK GUIDE ARM SHAFT 1
13	#01	B1823051000	OPENING LEVER CRANK PIN 1
14		SS7111810TP	SCREW 11/64-40 L=18 1
15		CQ202000000	OIL WICK 0.02
16	#03	21335807	INNER HOOK GUIDE 1
17	#01	B1824563000	BOBBIN CASE OPENING LEVER 1
18		WP0371016SD	WASHER 3. 7X8X1 1
19		SS6090810SP	SCREW 9/64-40 L= 7.5 1
20		10111102	THRUST WASHER 1.3 1
21		10112704	THRUST WASHER 1.8 (1)
22	#03	21378401	HOOK SHAFT UPPER METAL 1
23	#01	21378500	HOOK SHAFT UPPER METAL 1
24		21334701	HOOK SHAFT LOWER METAL 1
25		10109908	SADDLE INSTALLING BLOCK UPPER 1
26		10112407	SADDLE INSTALLING BLOCK LOWER 1
27		SS6153040SP	SCREW 15/64-28 L=30 1
28		WP0850002SP	WASHER 8. 5X18X1.6 1
29		SM6082502TP	SCREW M8 L=25 1
30		B1834512000A	OIL ADJUSTING SCREW 1
31		NS6110420SP	NUT 11/64-40 2
32	#03	21387055	THREAD TRIMMER HOOK ASM. 1
33	#01	B18305630A0	VERTICAL-AXIS SEWING HOOK ASM. 1
34	#03	21334800	ALUMINUM BOBBIN WITH KNURL 1
35	#01	B9117563000	BOBBIN 1
36		21361704	LOWER SHAFT 1
38		SS8151150TP	SCREW 15/64-28 L=10.5 1
39		B18035150A0	BUSHING ASM. INTERMEDIATE 1
40		SS8151150TP	SCREW 15/64-28 L=10.5 1
41	#03	21378104	FEED DRIVING ECCENTRIC 1
42	#01	22609804	FEED DRIVING CAM 1
43	#03	SS8150510TP	SCREW 15/64-28 L= 4.7 1
44	#01	SS8660530TP	SCREW 1/4-40 L= 4.5 1
45		B1817051000	HOOK DRIVING SHAFT GEAR SMALL 1
46		SS8660670SP	SCREW 1/4-40 L= 6.1 1
47		SS8660530TP	SCREW 1/4-40 L= 4.5 1
48		B1816051000	HOOK DRIVING SHAFT GEAR LARGE 1
49		SS8660810TP	SCREW 1/4-40 L=8 2
50		SS8151150SP	SCREW 15/64-28 L=10.5 1
51		SQ1110401MZ	CONNECTING SCREW 2
52		22611909	OIL PUMP SHAFT 1
53		SS8660530TP	SCREW 1/4-40 L= 4.5 1
54		22611701	PLUNGER BUSHING B 1
55		SS8110422TP	SCREW 11/64-40 L=4 1
56		10109700	THRUST WASHER A 1
59		10111003	THRUST WASHER 1.1 1
63		B1802563000A	BUSHING ASM. FRONT 1

#01 FOR 1515 #03 FOR 1515AUT

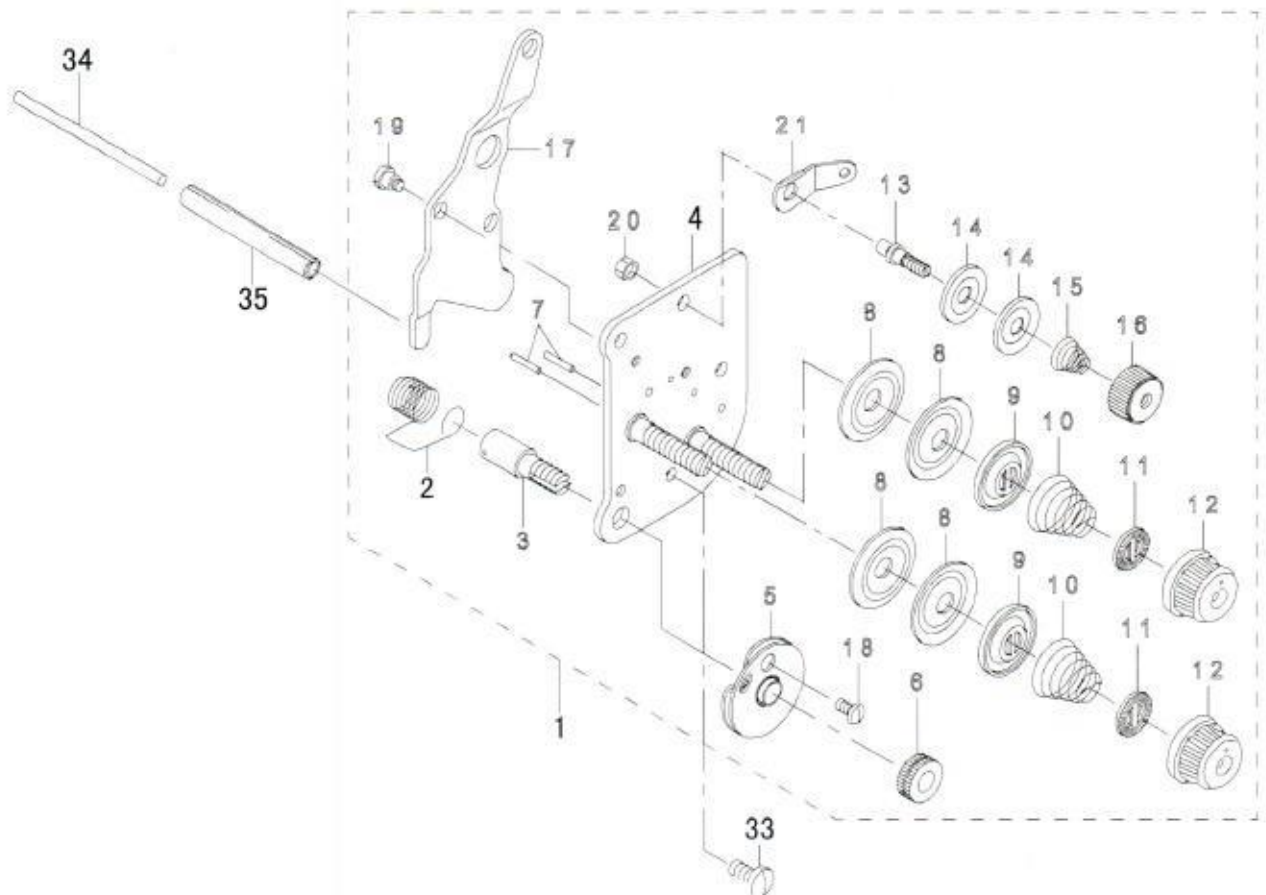
7. Thread cutting components (for WF1515AUT)



DESCRIPTION

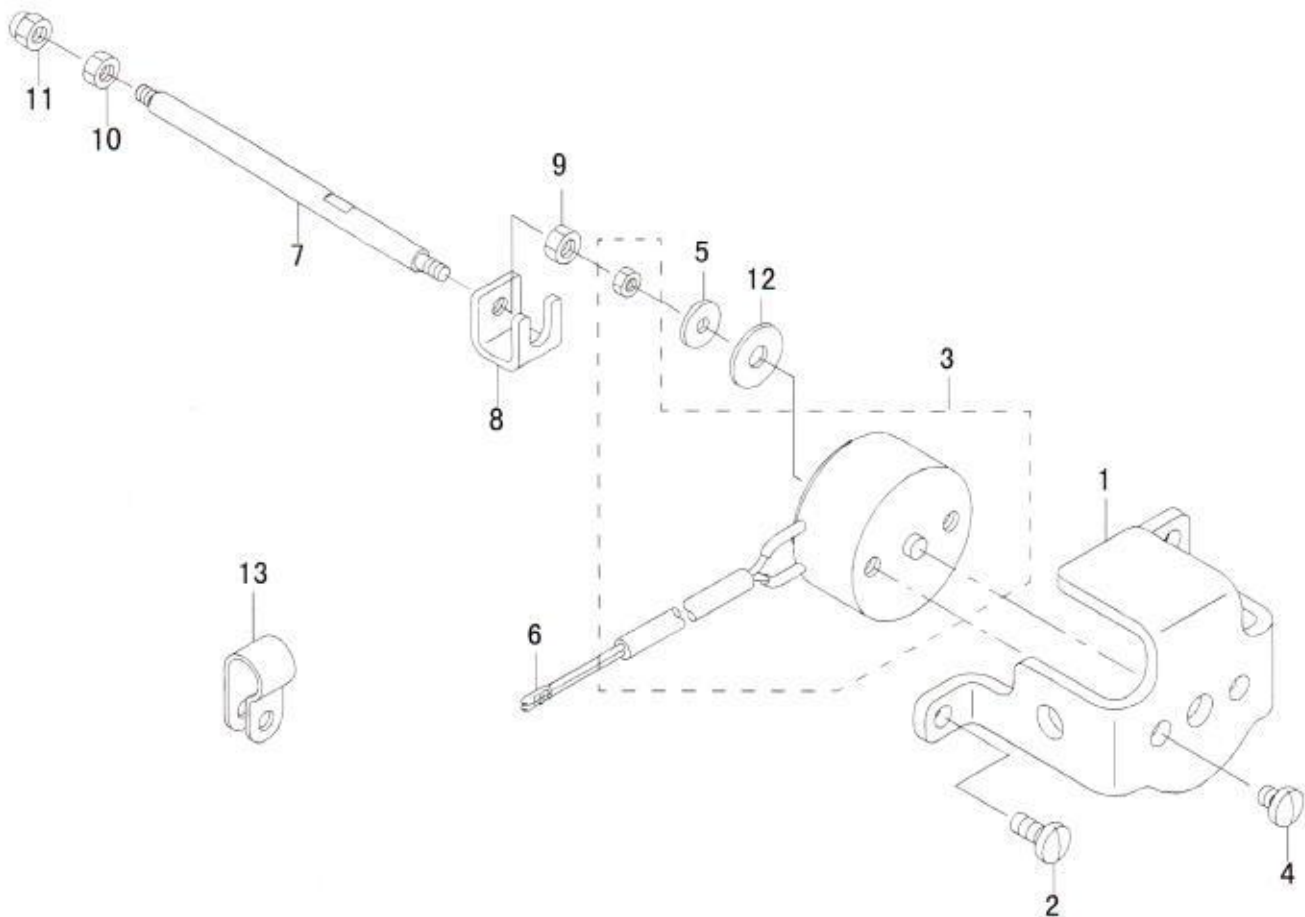
1	21389200	MOVING KNIFE	1
2	SM6030802TP	SCREW M3X0.5 L=8	2
3	WP0320501SC	WASHER M3	2
4	21389556	FIXED KNIFE BASE (RIGHT) ASM.	1
5	21389507	FIXED KNIFE BASE (RIGHT)	1
6	21389309	FIXED KNIFE	1
7	21389408	CLAMP SPRING	1
8	SS7060610SP	SCREW 3/32-56 L= 5.5	2
9	SS7060610SP	SCREW 3/32-56 L= 5.5	2
16	SS7111120SP	SCREW 11/64-40 L=10.5	2
17	40090530	WASHER M5	2
18	21354907	MOVING KNIFE SHAFT	1
19	CS0790731SH	THRUST COLLAR	1
20	SS8110422TP	SCREW 11/64-40 L=4	2
21	21354501	THREAD CUTTING STOPPER (RIGHT)	1
22	SS7111120SP	SCREW 11/64-40 L=10.5	1
23	21353750	VERTICAL FITTING BASIS ASM.	1
24	21353701	VERTICAL FITTING BASIS	1
25	SS8110510SP	SCREW 11/64-40 L=5	2
26	21354006	THREAD CUTTING DRIVING PLATE	1
27	10116804	SHAFT	1
28	21353859	THREAD CUTTING ROLLER ARM	1
29	21353909	CAM ROLLER SHAFT	1
30	D2430555B00	SNAP RING	1
31	21353800	THREAD CUTTING ROLLER ARM	1
32	D2427555B00B	CAM ROLLER	2
33	CS070081BSH	THRUST COLLAR ASM. D=7 W=8	1
34	CS0700811SH	THRUST COLLAR D=7 W=8	1
35	SS8110510SP	SCREW 11/64-40 L=5	2
36	SS6151812TP	SCREW 15/64-28 L=18	2
37	21354105	CONNECTING PLATE	2
38	21354204	STOPPING PLATE	1
39	SD0640325SP	HINGE SCREW	2
40	SS6111010SP	SCREW 11/64-40 L= 9.5	2
42	HK034610120	HOUSING 12P	1
43	WP0621016SD	WASHER 6.2X13X1	2
45	21389705	ROCKING ARM (RIGHT)	1
46	SS6121610TP	SCREW 3/16-28 L=15.5	1
48	SS6121610TP	SCREW 3/16-28 L=15.5	1
49	SD0640451TP	HINGE SCREW D=6.35 H=4.5	1
51	21389911	THREAD TRIMMER CAM	1
52	SS8660612TP	SCREW 1/4-40 L=6	2
53	SD0640482SP	HINGE SCREW D= 6.35 H= 4.8	1
54	21355102	THREAD CUTTING SOLENOID	1
55	21354600	SOLENOID FITTING PLATE	1
56	SS6151210SP	SCREW 15/64-28 L=12	2
57	SM6040800SP	SCREW	2
58	21354709	SOLENOID CONNECTING PLATE	1
59	SS7110720SP	SCREW 11/64-40 L=7	2
60	HK03464000A	TERMINAL FEMALE	2
61	WS0610002KP	SPRING WASHER	2
62	21390208	MAINTENANCE SPRING	2

8. Thread tension components



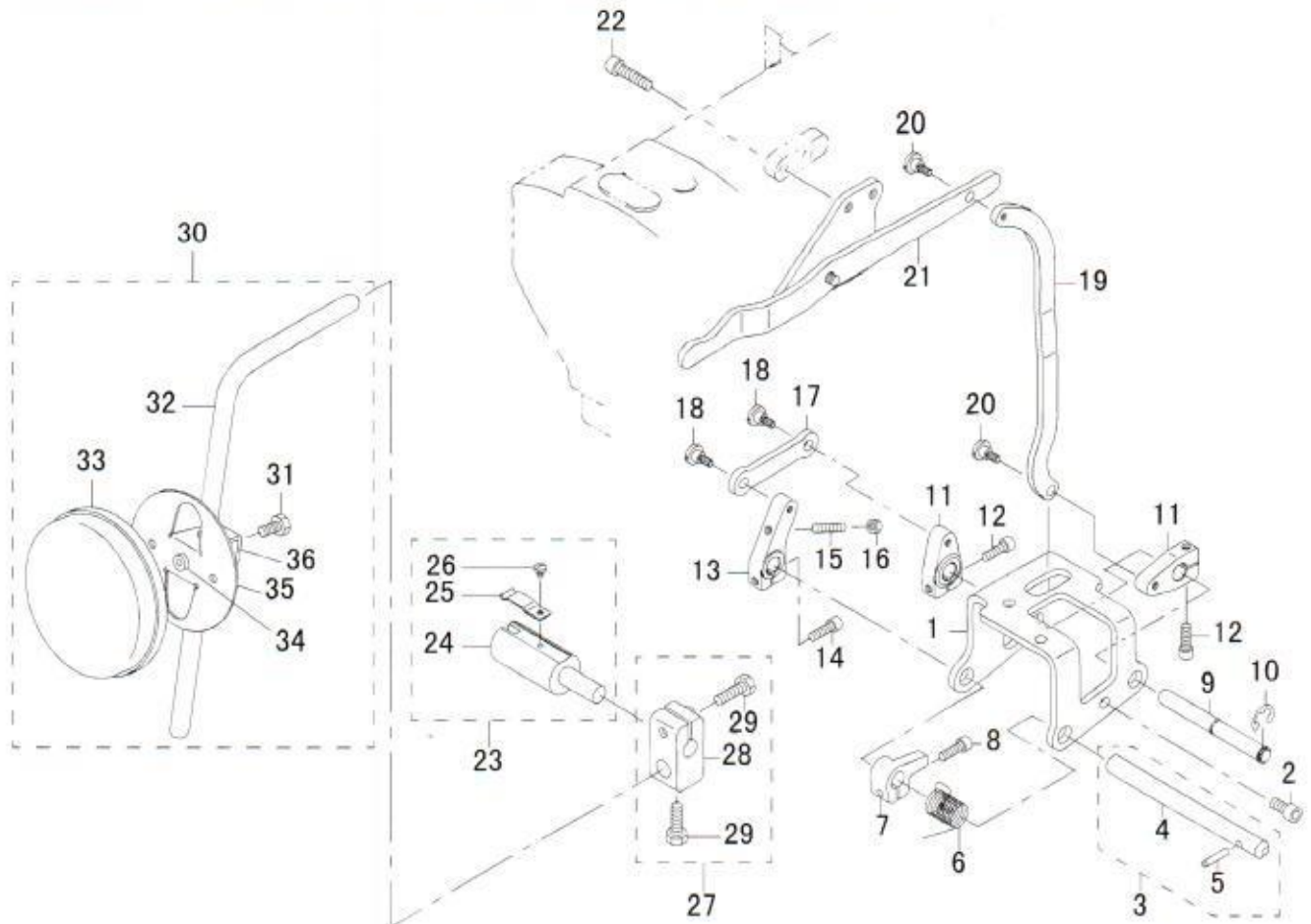
DESCRIPTION				
1	21409065	THREAD TENSION ASM.		1
2	3128520000	THREAD TAKE-UP SPRING A		<1>
3	10320109	SCREW STUD		<1>
4	21409057	THREAD POST BASE COMPL.		<1>
5	B13130510AO	TAKE-UP SPRING GUIDE DISC ASM.		<1>
6	10320208	THRED TENSION STUD NUT		<1>
7	B3127051000	TENSION RELEASE PIN SHORT		<2>
8	B3126012000	THREAD TENSION DISC		<4>
9	22617906	THREAD TENSION DISC PRESSER		<2>
10	B3129053000	TENSION SPRING		<1>
11	B3120125000	ROTATING STOPPER		<2>
12	B3125012000	THREAD TENSION NUT		<2>
13	10124204	THREAD TENSION POST A		<1>
14	B3214047000	BOBBIN WINDER TENSION DISC		<2>
15	D3168555H0B	TENSION SPRING NO. 1		<1>
16	11072402	THREAD TENSION NUT		<1>
17	21441100	THREAD RELEASE PLATE		<1>
18	SS4080620TP	SCREW STUD		<1>
19	SD0470281SP	HINGE SCREW D=4.7 H=2.8		<1>
20	NS6110310SP	NUT 11/64-40		<1>
21	D3162555B00	THREAD GUIDE		<1>
33	SS7110910TP	SCREW 11/64-40 L= 8.5		<1>
34	21348206	TENSION RELEASE BAR		<1>
35	PS0600502KP	SPRING PIN		<1>

9. Threaf release components(for WF1515AUT)



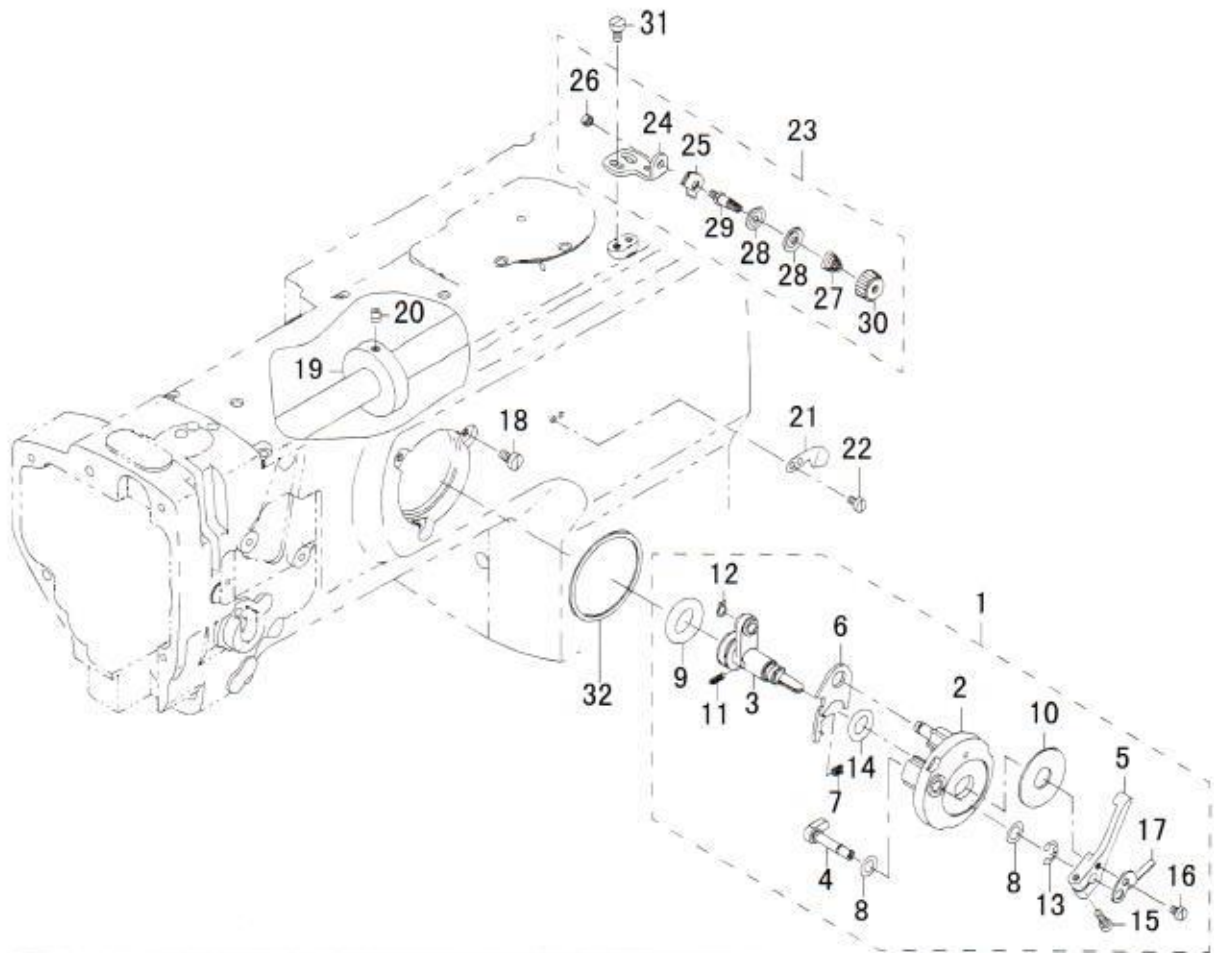
DESCRIPTION				
1	21441407	SOLENOID INSTALLING PLATE		1
2	SS7110910TP	SCREW 11/64-40 L= 8.5		2
3	21363106	TENSION RELEASE SOLENOID		1
4	SS7110570SP	SCREW 11/64-40 L= 4.8		2
5	WP0371016SD	WASHER 3.7X8X1		1
6	HK03464000B	PIN CONTACT		2
7	21441209	TENSION RELEASE BAR		1
8	21441308	COUPLING		1
9	NM6040001SN	NUT M4X0.7		1
10	LM5	NUT M5X0.8		1
11	NM7040062SB	NUT M4		1
12	WP0501046SC	WASHER 5 X 13 X 1		1
13	HX00123000A	CABLE CLIP		1

10. Knee lifting components(for WF1515)



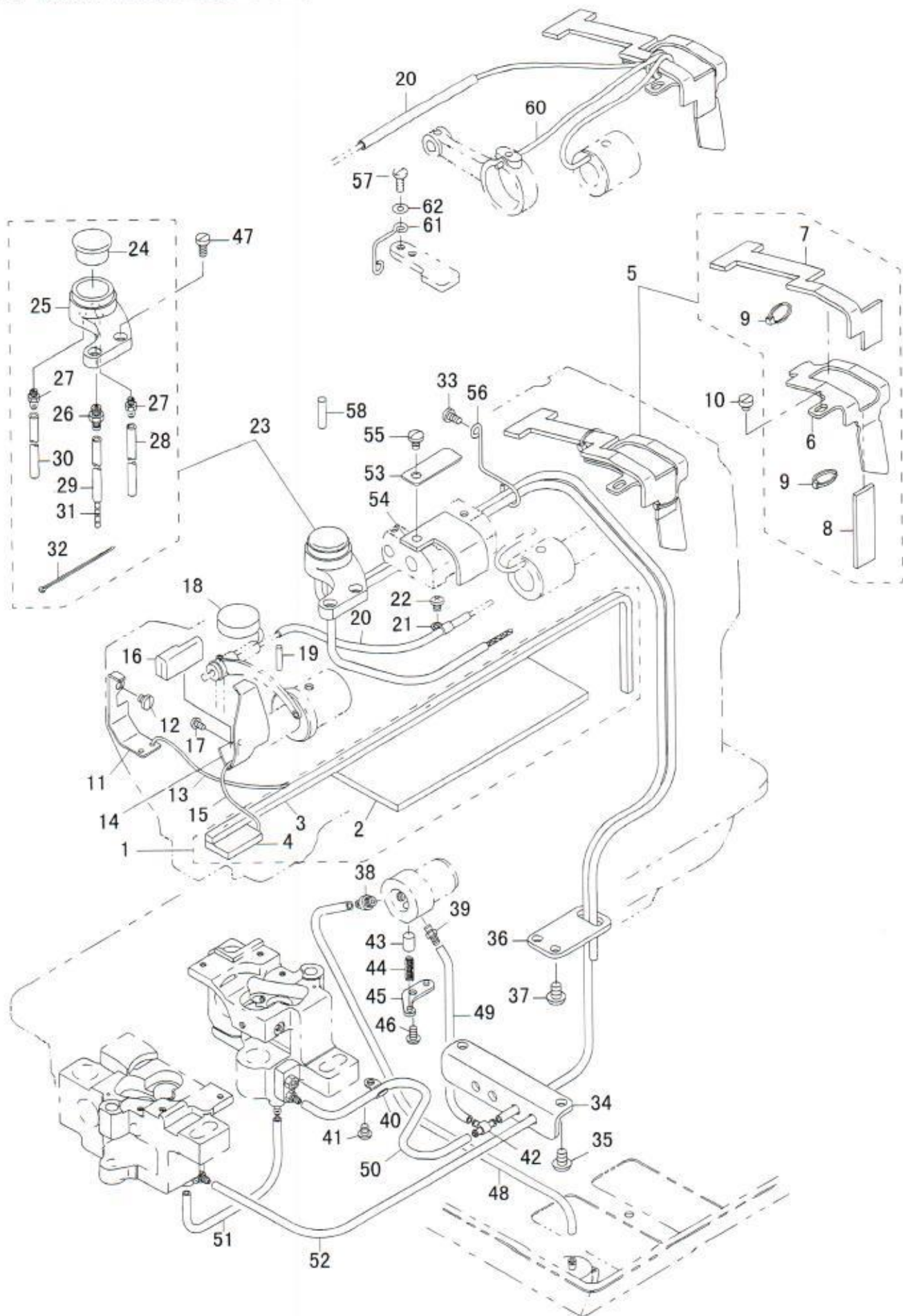
DESCRIPTION				
1	21343207	KNEE LIFTER SHAFT BASIS		1
2	SM6061202TP	SCREW M6 L=12		3
3	21342555	KNEE LIFTER SHAFT A ASM.		1
4	21342506	KNEE LIFTER SHAFT A		1
5	21342605	KNEE LIFTER SHAFT PIN		1
6	21343702	KNEE LIFTER SHAFT A SPRING		1
7	21343801	KNEE LIFTER SPRING RACK		1
8	SM6051602TP	SCREW M5X0.8 L=16		1
9	21342704	KNEE LIFTER SHAFT B		1
10	KHZ8	E-SHAPED SNAP RING (8MM)		1
11	21343009	KNEE LIFTER LEVER B		2
12	SM6052002TP	SCREW M5 L=20		2
13	21342803	KNEE LIFTER LEVER A		1
14	SM6052002TP	SCREW M5 L=20		1
15	SM8052502TP	SCREW M5X0.8 L=25		1
16	NM6050001SD	NUT M5X0.8		1
17	21342902	KNEE LIFTER LINK		1
18	SD0700451TP	HINGE SCREW D=7 H=4.5		2
19	21343405	KNEE LIFTER CONNECTING PLATE		1
20	SD0700451TP	HINGE SCREW D=7 H=4.5		2
21	21343355	KNEE LIFTER LEVER		1
22	SM6062502TP	SCREW M6 L=25		2
23	22863252	KNEE LIFTER JOINT ASM.		1
24	22863203	KNEE LIFTER JOINT		1
25	B3428521000	PRESSER SPRING		1
26	SS7090510SP	SCREW 9/64-40 L= 4.6		1
27	22932453	BRACKET ASM.		1
28	22932404	BRACKET		1
29	22934707	SCREW		2
30	21343157	KNEE PRESS PLATE ASM.		1
31	SM9061203SE	SCREW M6 L=12		1
32	21343108	KNEE PRESS LEVER		1
33	22934509	KNEE PAD PLATE COVER		1
34	22934400	KNEE PAD PLATE RUBBER		1
35	22934202	KNEE PAD PLATE		1
36	22934301	KNEE PAD PLATE SUPPORT		1

11. Lower thread winder mechanism component



DESCRIPTION				
1	21357967	BOBBIN DEVICE ASM.		1
2	22537658	BOBBIN FITTING BASIS COMPL.		1
3	21357959	BOBIN SHAFT COMPL.		1
4	22538151	BOBBIN CAM SHAFT COMPL.		1
5	23636202	BOBBIN LEVER		1
6	21356001	ADJUSTING PLATE		1
7	B152989000CA	PRESSUR FOOT SPRING		1
8	10618304	VERTICAL ROLLER WASHER		2
9	21358205	BOBBIN FRICTION GEAR		1
10	B3205210000	CUSHION		1
11	B1148555000	SPRING		1
12	RC0560711KP	RETAINING RING		1
13	RE0500000K0	E-RING		1
14	RO092270200	RUBBER RING		1
15	SS7091410SP	SCREW 9/64-40 L=13.5		1
16	SS6090520SP	SCREW 9/64-40 L= 5.0		1
17	14512503	BOBBIN ADJUSTING PLATE		1
18	SS6110810TP	SCREW 11/64-40 L=8		3
19	10704807	BOBBIN FRICTION WHEEL		1
20	SM8050602TP	SCREW M5 L=6		2
21	10502300	THREAD CUTTER		1
22	SS6090620SP	SCREW 9/64-40 L=6		2
23	21355755	LOWER THREAD GUIDE ASM.		1
24	21355706	FITTING BASE		1
25	D3162555B00	THREAD GUIDE		1
26	NS6110310SP	NUT 11/64-40		1
27	D3168555H0B	TENSION SPRING NO.1		1
28	B3214047000	BOBBIN WINDER TENSION DISC		2
29	21378708	THREAD TENSION POST		1
30	11072402	THREAD TENSION NUT		1
31	SM6040800SP	SCREW		2
32	22538706	PACKING		1

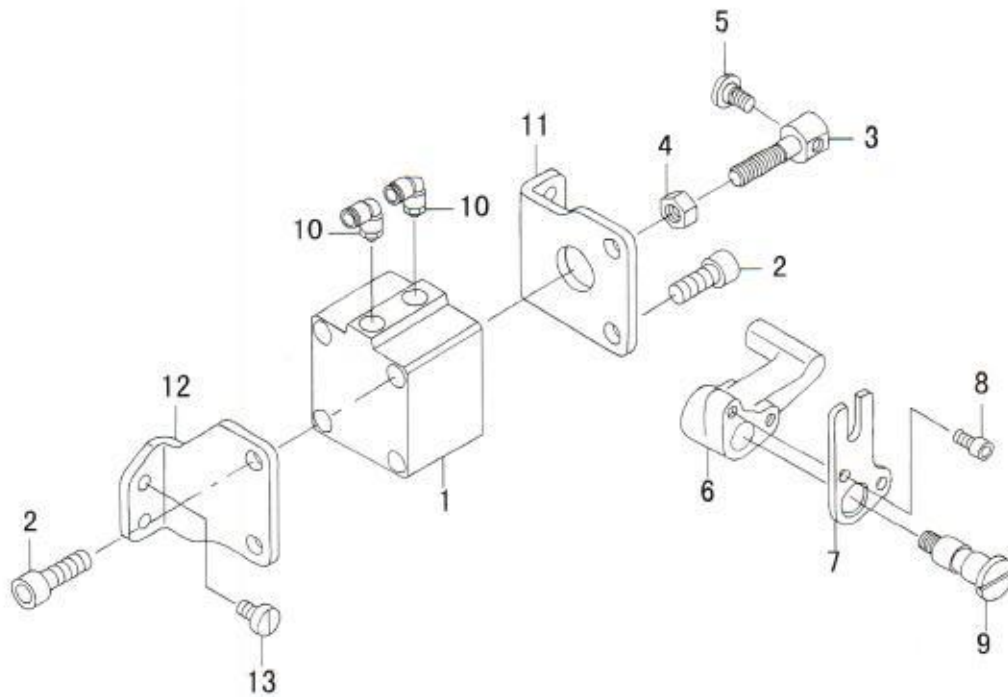
12. Lubrication components



DESCRIPTION

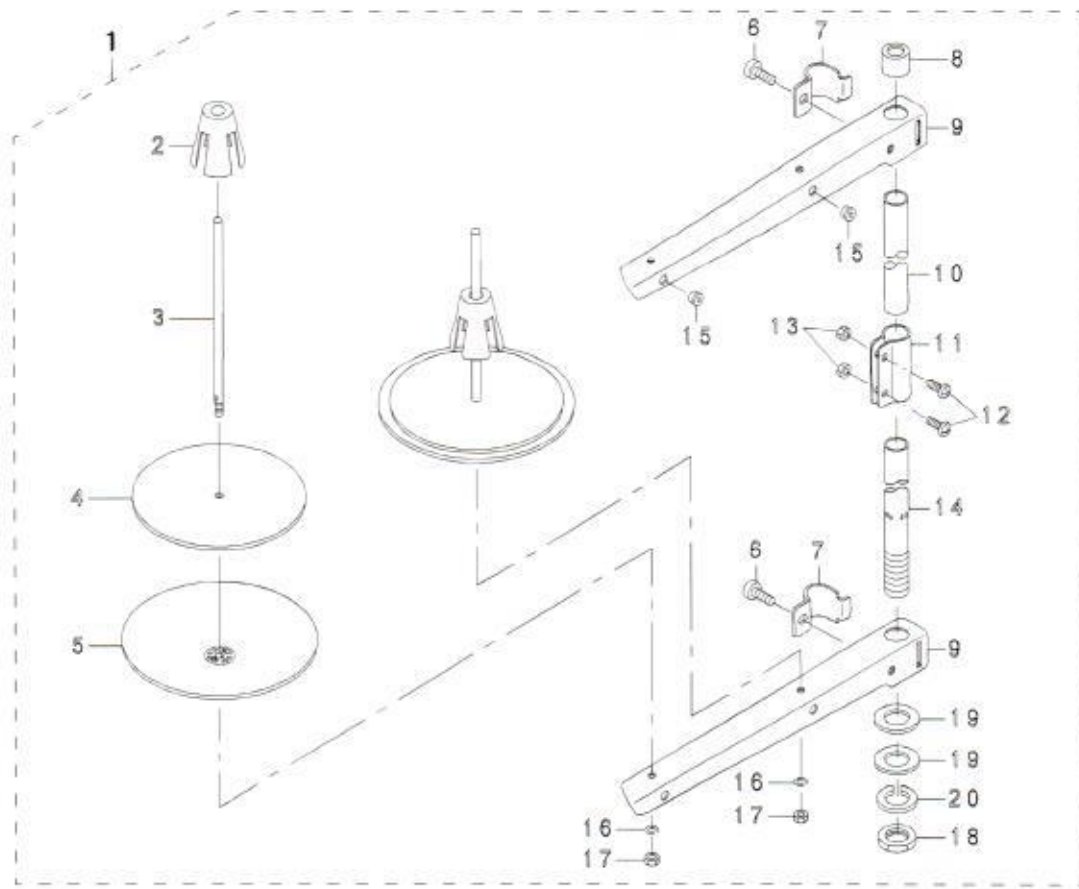
1	21345756	ARM ONCE THROUGH OIL FELT ASM.	1
2	21345707	ARM ONCE THROUGH FELT A	1
3	21345806	FELT B	1
4	21345905	FACE ONCE THROUGH FELT	1
5	21346358	FELT SUPPORT ASM.	1
6	21346309	FELT	1
7	21346507	FEED CHANGE FELT	1
8	21346408	FELT	1
9	EA9500B0000	CLIP CV-70S	2
10	SS7110710SP	SCREW 11/64-40 L=4.3	1
11	21340708	UPPER FEED OIL BAR PLATE	1
12	SS7110710SP	SCREW 11/64-40 L=5	1
13	CQ202000000	OIL WICK	0.2
14	21347000	TAKE-UP OIL PLATE	1
15	CQ202000000	OIL WICK	0.25
16	21347208	TAKE-UP LUBRICATION FELT	1
17	SS3090610SP	SCREW 9/64-40 L=6	1
18	21346002	FELT	1
19	B1412051000	FELT	1
20	BT0600402EA	OIL TUBE	0.12
21	B3538112000	OIL RETURN TUBE HOLDER	1
22	SS4110615SP	SCREW 11/64-40 L=6	1
23	40051503	ARM OIL TANK ASM.	1
24	B3520586000	OIL SIGHT WINDOW	1
25	21345608	ARM OIL TANK	1
26	SQ1110401MZ	CONNECTING SCREW	1
27	SQ1150451MZ	CONNECTING SCREW	2
28	23630007	TUBE	0.5
29	23630007	TUBE	0.2
30	23630007	TUBE	0.6
31	CQ252000000	OIL WICK	0.7
32	EA9500B0100	CABLE BAND	3
33	SS7110830SP	SCREW 11/64-40 L= 7.5	1
34	21345103	LUBRICATION BRACKET	1
35	SS7150910TP	SCREW 15/64-28 L=9	2
36	21345202	OIL PIPE STAY	1
37	SS7150910TP	SCREW 15/64-28 L=9	2
38	40064409	CONNECTION SCREW ASM.	1
39	SQ1110401MZ	CONNECTING SCREW	1
40	B3538112000	OIL RETURN TUBE HOLDER	1
41	SS4110615SP	SCREW 11/64-40 L=6	1
42	13765607	OIL CONNEC. ARM	1
43	B3534155000	PLUNGER	1
44	B1214038000	PLUNGER SPRING	1
45	B3524552000	PLUNGER THRUST PLATE	1
46	SS4110815SP	SCREW 11/64-40 L=8	1
47	SS6111010SP	SCREW 11/64-40 L= 9.5	2
48	23630007	TUBE	0.36
49	23630007	TUBE	0.08
50	23630007	TUBE	0.22
51	23630007	TUBE	0.1
52	23630007	TUBE	0.5
53	21338306	LUBRICATION FELT PRESSER	1
54	SS5090610SP	MUTUAL VERTICAL CHANGE FELT	1
55	LS5E8	SCREW M5-8	1
56	21346606	PIPE SUPPORT	1
57	SS4110815SP	SCREW 11/64-40 L=8	1
58	PS0500202KP	SPRING PIN 5X20	1
60	CQ202000000	OIL WICK	0.2

13. Automatic presser lifting mechanism(for WF1515AUT)



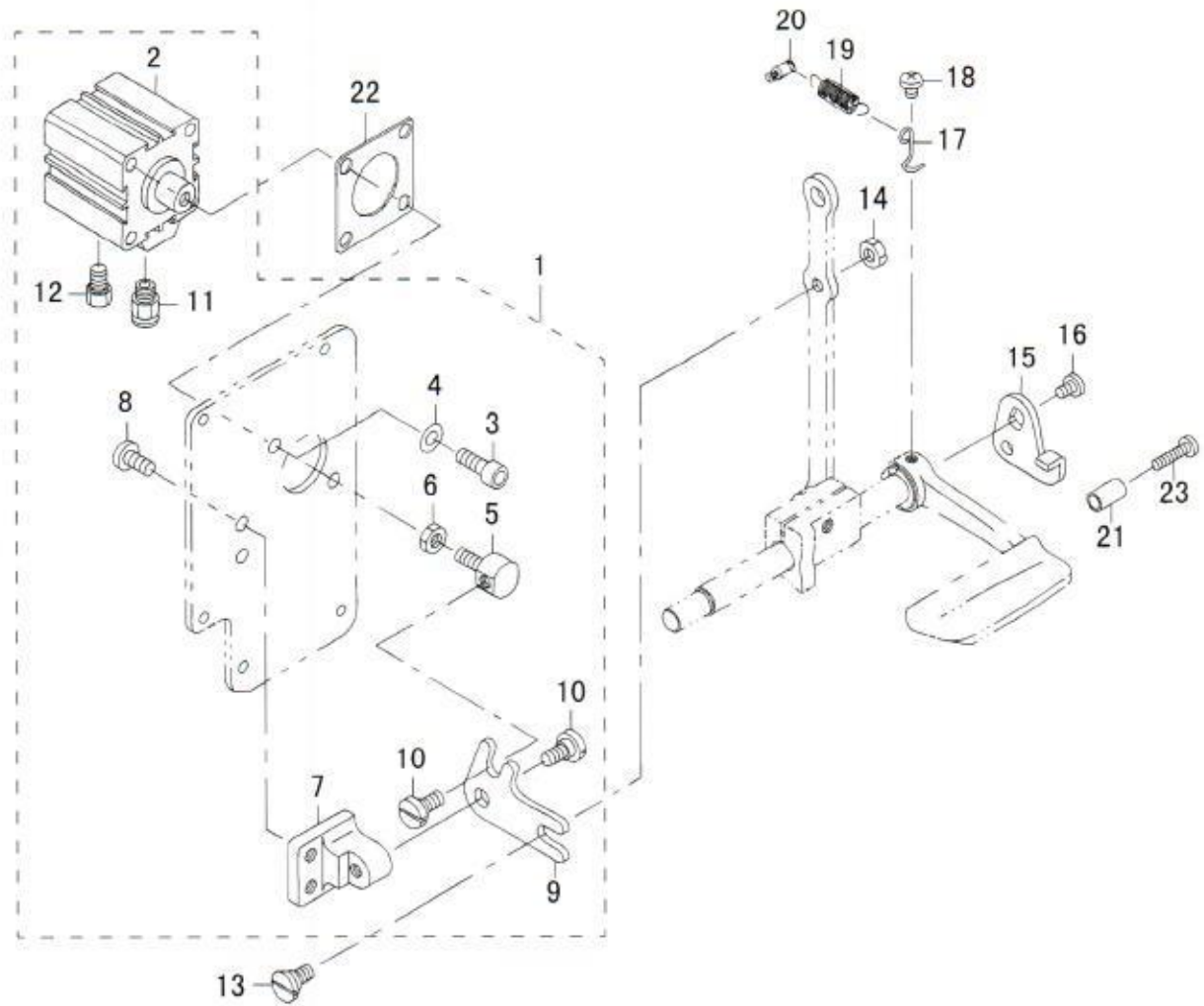
DESCRIPTION				
1	PA400150100	AIR CYLINDER		1
2	LS8A20	SCREW M8 L=20		4
3	21356506	CYLINDER CONNECTING SCREW		1
4	LM8	NUT M8		1
5	SD0720331SP	HINGE SCREW D= 7.24 H= 3.3		1
6	21356605	LEVER A		1
7	21356803	LEVER B		1
8	SM6051002TP	SCREW M5X0.8 L=10		2
9	21356704	SHAFT		1
10	SPL6-01	ELBOW		2
11	21356308	CYLINDER STAY (FRONT)		1
12	21356407	CYLINDER STAY (REAR)		1
13	SS6151210SP	SCREW 15/64-28 L=12		4

14. Thread stand components



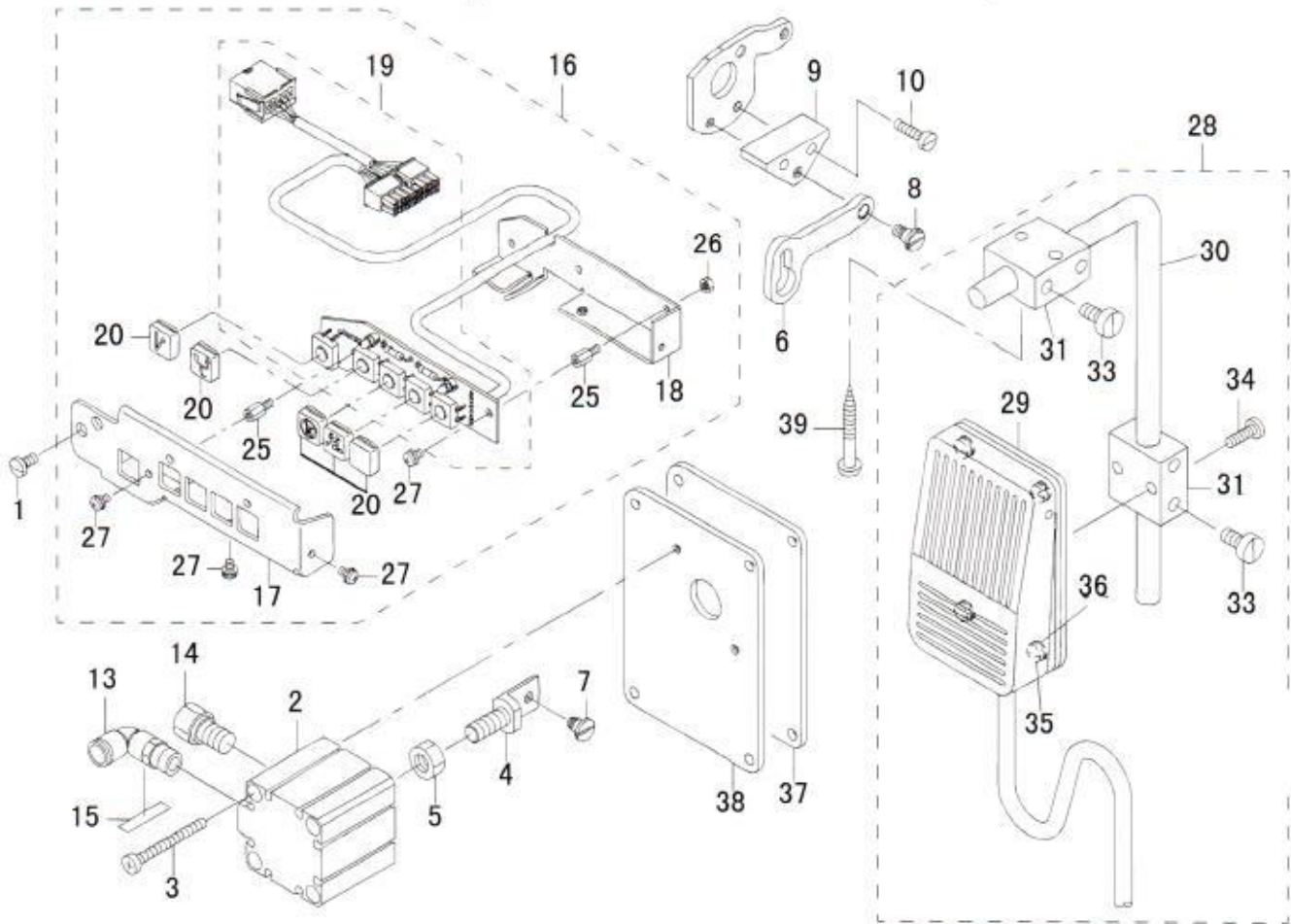
DESCRIPTION				
1	22930358	THREAD STAND ASM.		1
2		SPOOL RETAINER		(2)
3		SPOOL PIN		(2)
4		SPOOL REST CUSHION		(2)
5		SPOOL REST		(2)
6		SCREW M6 L=16		(2)
7		THREAD GUIDE ARM JOINT		(2)
8		SPOOL REST ROD RUBBER CAP		(1)
9		SPOOL REST ARM		(2)
10		SPOOL REST ROD UPPER		(1)
11		SPOOL REST ROD JOINT		(1)
12		SCREW M5 L=14		(2)
13		NUT M5		(2)
14		SPOOL REST ROD LOWER		(1)
15		THREAD GUIDE		(2)
16		SPRING WASHER		(2)
17		NUT M5		(2)
18		NUT M16X1.5		(1)
19		WASHER 16X30X2.6		(2)
20		SPRING WASHER		(1)

15. Automatic back components (for WF1515AUT)



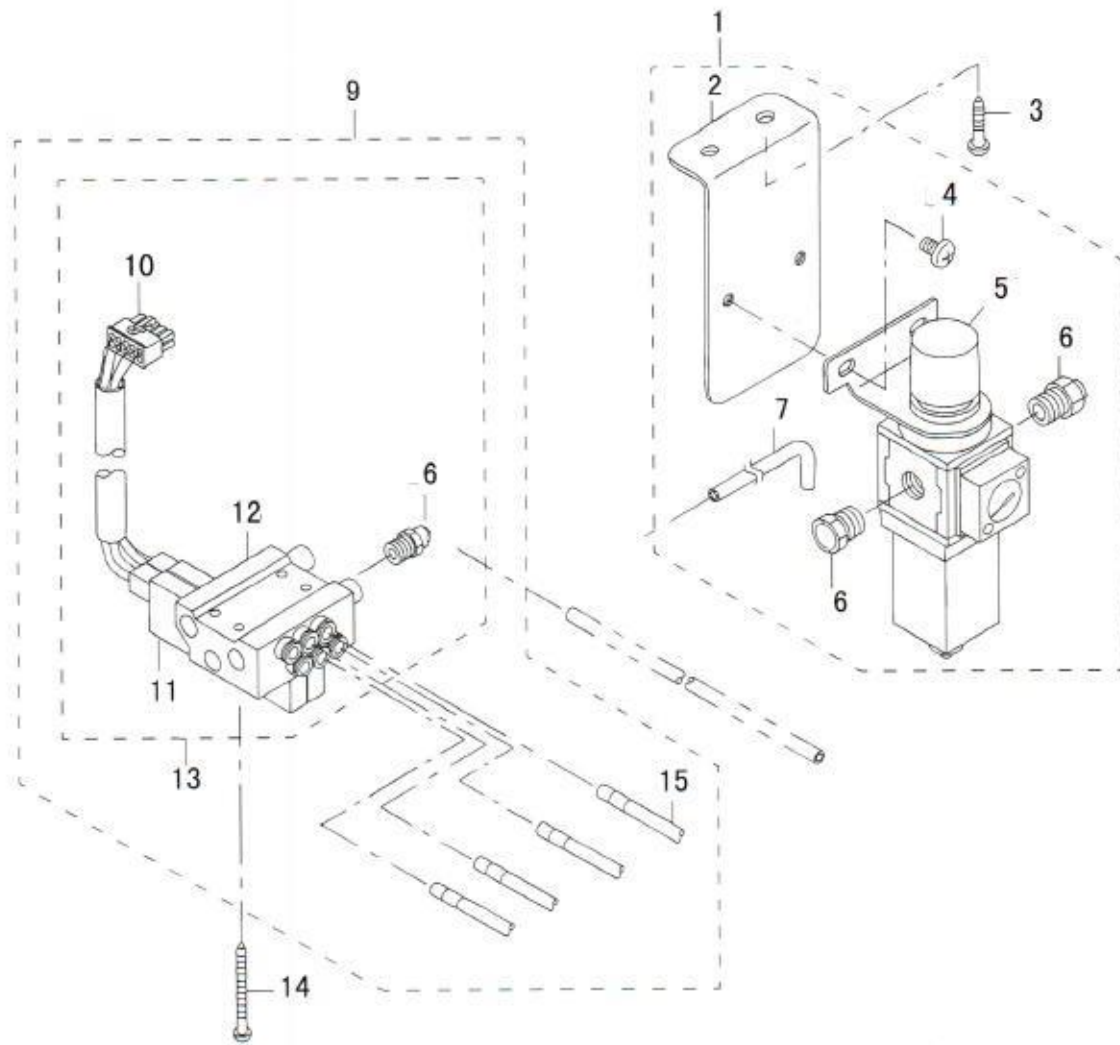
DESCRIPTION				
1	21348958	WINDOW PLATE ASM.		1
2	PA320150200	JIG CYLINDER		1
3	LS6A16	SCREW M6 L=16		2
4	WP0641601SD	WASHER M6		2
5	21348602	CYLINDER CONNECTING SCREW		1
6	NM6060003SC	NUT M6		1
7	21348503	FITTING BASE		1
8	SS7150910TP	SCREW 15/64-28 L=9		2
9	21348701	BACKWARD FEED LINK		1
10	SD0800352SP	HINGE SCREW D= 8 H= 3.5		2
11	SPC6-01	HALF UNION		1
12	PST01	MUFFLER		1
13	SD0800402TP	HINGE SCREW D= 8 H= 4		1
14	NS6150430SP	NUT 15/64-28		1
15	22656102	REVERSE FEED LINK (1)		1
16	SS7120760SP	SCREW 3/16-28 L= 7.0		1
17	22656003	SPRING SUSPENSION		1
18	SS4120615SP	SCREW 3/16-28 L=6		1
19	13515606	SPRING		1
20	10120004	SPRING SUSPENSION		1
21	11100500	REVERSE FEED LEVER STOPPER		1
22	21349105	CYLINDER PACKING		1
23	SS7112810SP	SCREW 11/64-40 L=28		1

16. DL mechanism components(for WF1515AUT)



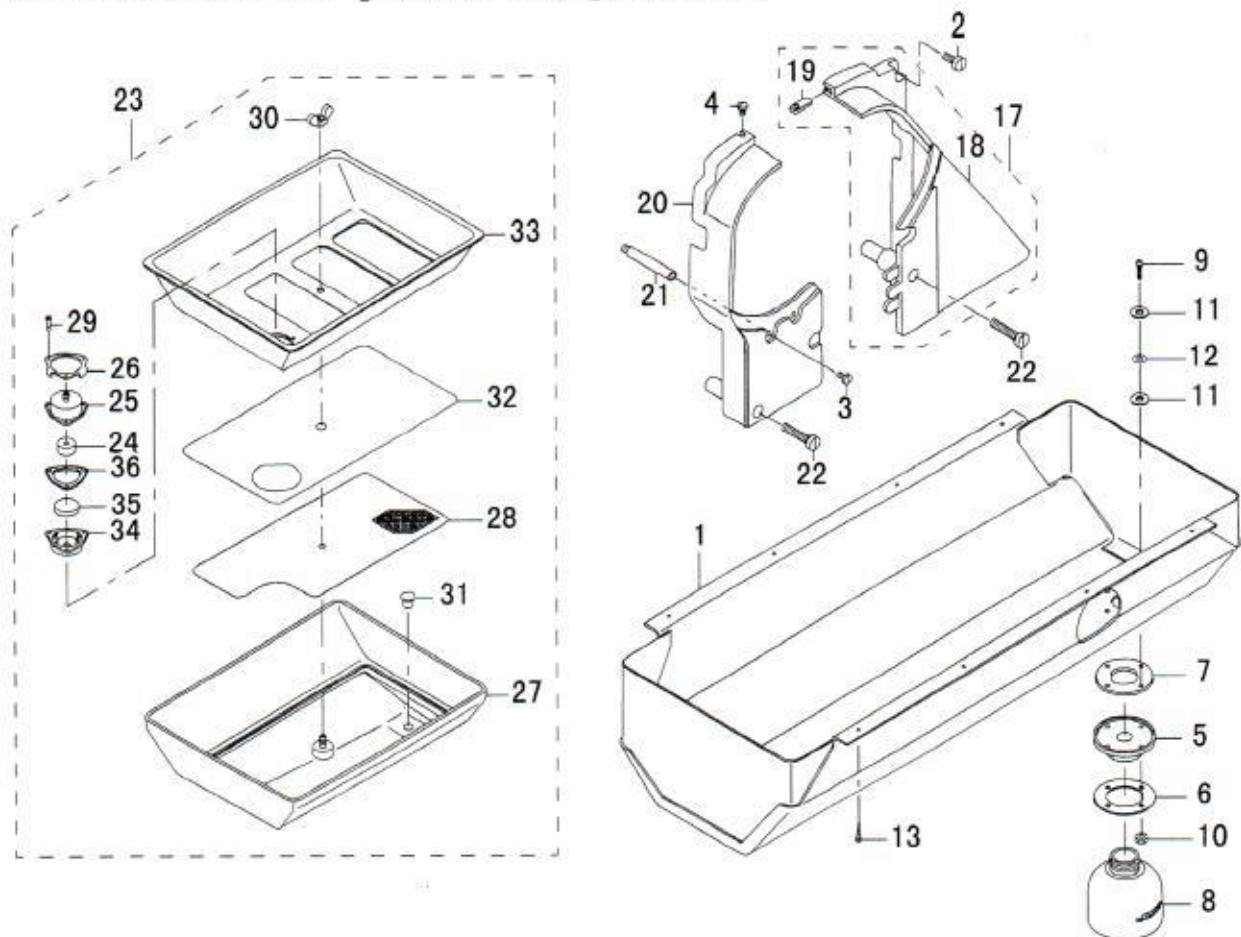
DESCRIPTION			
1	SS7110840SP	SCREW 11/64-40 L=7.8	2
2	PA320200100	JIG CYLINDER	1
3	SM6044002TP	SCREW	2
4	21438403	CYLYNDER CONNECTING SCREW	1
5	LM6	NUT M6	1
6	21438502	MUTUAL VERTICAL LINK	1
7	SD0600403TP	HINGE SCREW	1
8	SD0600454TP	SHOULDER SCREW	1
9	21438601	MUTUAL VERTICAL LINK SPASER	1
10	SS6111610SP	SCREW 11/64-40 L=16	2
13	SPC4-01	ELBOW	1
14	PST-01	MUFFLER	1
15	HX00295000C	WIRE MARK (4)	1
16	40024849	5RANGE SWITCH ASM.	1
17	21442603	SWITCH COVER	1
18	21442702	SWITCH CIRCUIT FITTING BASE	1
19	40024848	5RANGE SWITCH SUB(A) ASM.	1
20	21442900	KEY TOP	5
25	HX00354000N	SPACER	4
26	LM3	NUT M3	3
27	LS3E6	SCREW M3X6	4
28	40025036	KNEE SWITCH ASM.	1
29	40025035	KNEE SWITCH ASM.	1
30	MAT80231T00	DRIVING BAR T002	1
31	MAT80230T00	KNEE SWITCH SUPPORT BASE	2
33	SS6151220SP	SCREW 15/64-28 L=11.5	4
34	SS7111410SP	SCREW 11/64-40 L=14	2
35	SS7110710SL	SCREW 11/64-40 L=7.0	4
36	WP0480856SP	WASHER 4.8X8.4X0.8	4
37	21437306	WINDOW PLATE E PACKING	1
38	21437207	WINDOW PLATE F	1
39	SK3514000SC	WOOD SCREW D=5.1 L=40	2

17. Air mechanism components (for WF1515AUT)



DESCRIPTION				
1	40038722	AIR APPARATUS (B) ASM.		1
2	40038723	Mounting panel		2
3	021703	SCREW D=4.1 L=20		2
4	021704	SCREW M6 L=10		2
5	RR2000	FILTER REGULATOR		1
6	SPC8-02	NIPPLE		3
7	SNS8MM	TUBE Φ 8		1
9	40024965	ELECTROMAGNETIC VALVE ASM.		1
10	021710	RECEPTACLE		<1>
11	4V21008B	ELECTROMAGNETIC VALVE C		<3>
12	GAKA2302B00	FILTER REGULATOR MOUNTING PLAT		<1>
13	021713	ELECTROMAGNETIC VALVE (C) ASM.		1
14	021714	SCREW D=4.1 L=50		4
15	BT0600401EB	TUBE Φ 6		1

18. Accessories parts components



DESCRIPTION			
1	21351457	OIL RESERVOIR ASM.	1
2	SS6151440SP	SCREW 15/64-28 L=14	1
3	SS7110840SP	SCREW 11/64-40 L=7.8	1
4	SS5110740TP	SCREW 11/64-40 L= 6.5	1
5	40025299	OIL POT JOINT	1
6	21379003	OIL MANAGEMENT WASHER	1
7	B8112220000	OIL SEAL	1
8	40025300	OIL POT	1
9	SM3031401SE	SCREW M3X0.5 L=14	4
10	NM6030001SC	NUT M3	4
11	10748101	OIL REMOVING SETSCREW PACKING	8
12	WP0320501SC	WASHER M3	4
13	SK3241601SC	WOOD SCREW D=2.4 L=16	8
17	21351150	BELT COVER ASM. (RIGHT)	1
18	21351101	BELT COVER (RIGHT)	1
19	21351002	BELT COVER AUXILIARY PLATE	1
20	21351200	BELT COVER (LEFT)	1
21	D8232241E00	BELT COVER SUPPORT A	1
22	SS6153040SP	SCREW 15/64-28 L=30	2
23	21345350	OIL TANK ASM.	1
24	10727303	FILTER	1
25	10727204	FILTER CAP	1
26	10753002	FILTER PLATE	1
27	21345301	OIL TANK	1
28	21346804	COVER (LOWER)	1
29	SM6021000TP	SCREW	-3
30	NM9050001SC	WING NUT M5X0.8	1
31	TA0800704R0	RUBBER PLUG	1
32	21346903	FILTER	1
33	21346705	COVER (REAR)	1
34	21345509	FILTER CASE	1
35	B8228125000	OIL RESERVOIR MAGNET	1
36	10739209	FILTER PACKING	1



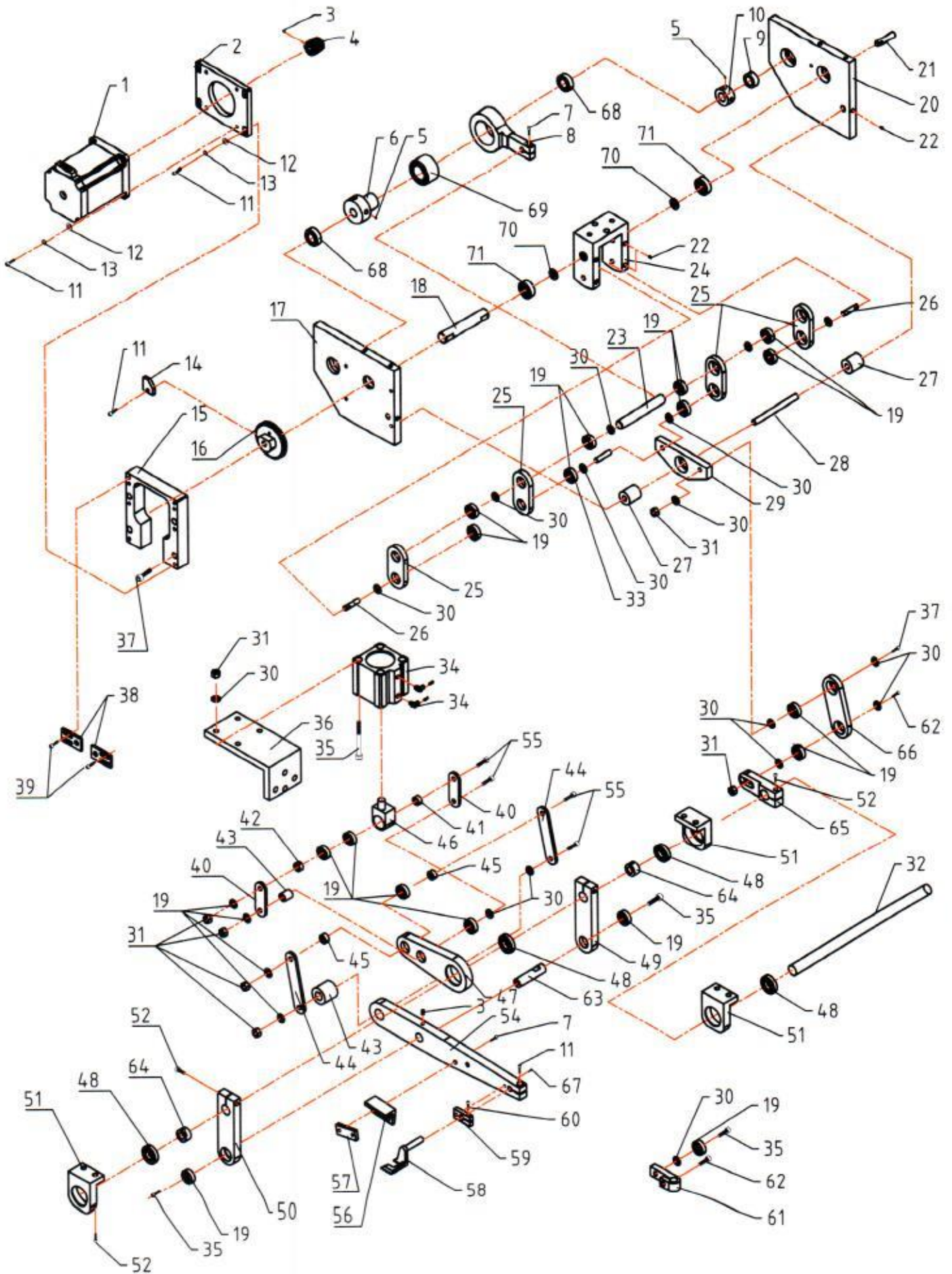
GLOBAL

UP 550 AUT

**SINGLE NEEDLE, WALKING FOOT
LOCKSTITCH MACHINE FOR GATHERING**

SPECIAL PARTS

1. 上推齿部分

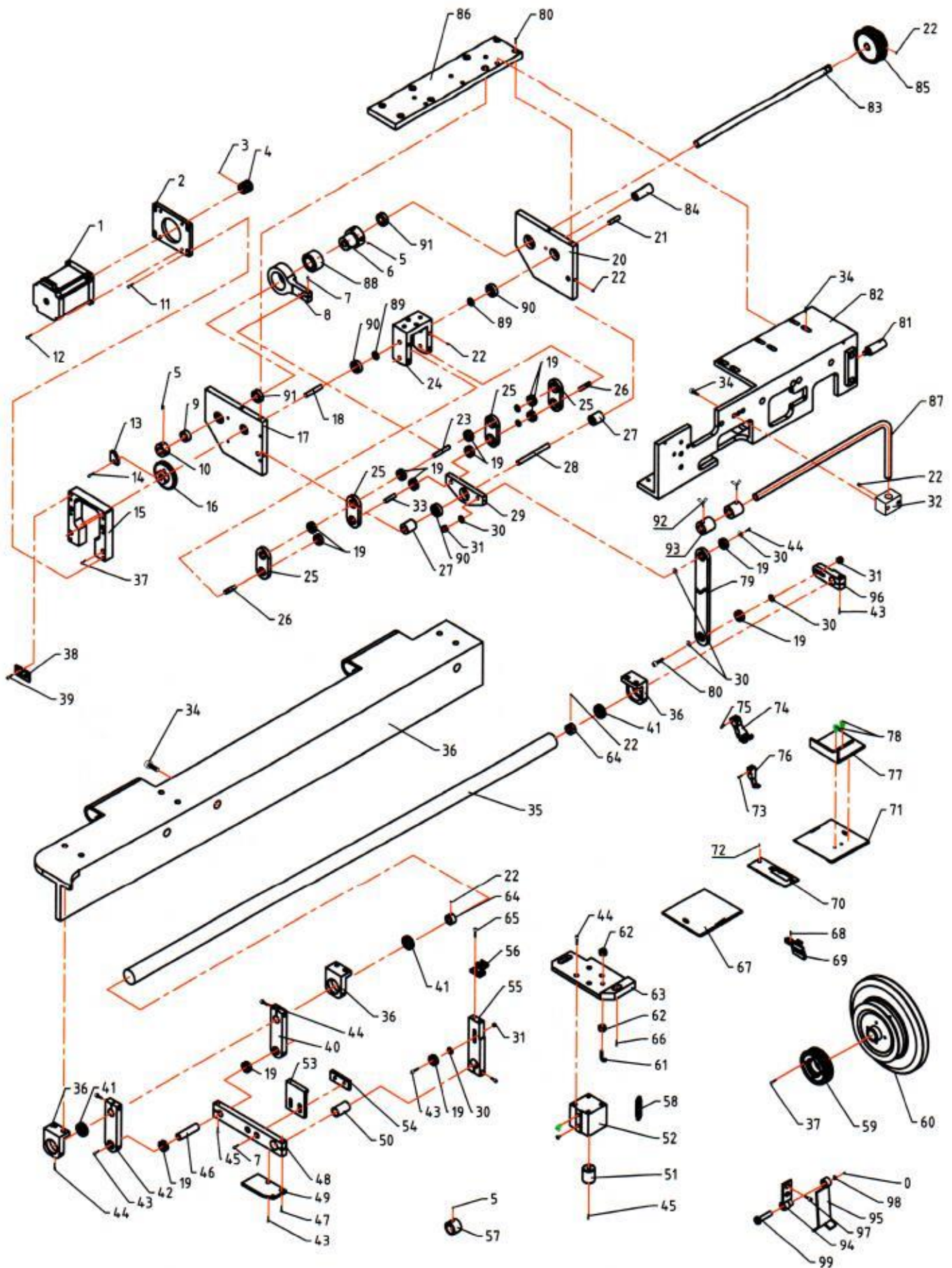


1. 上推齿部分零件清单

序号	零件号	名称	型号规格	数量	备注
1		同步电机		1	
2		电机固定板		1	
3		内六角平头紧定螺钉		2	
4		主动齿轮		1	
5		内六角平头紧定螺钉		2	
6		偏心轮		1	
7		内六角半圆头螺钉		3	
8		推动连杆		1	
9		挡套		2	
10		挡圈		2	
11		内六角圆柱头螺钉		10	
12		平垫		8	
13		弹垫		8	
14		定位挡块		1	
15		电机座		1	
16		从动齿轮		1	
17		电机端竖板		1	
18		从动齿轮轴		1	
19		轴承		22	
20		竖板		1	
21		摆架轴		1	
22		内六角平头紧定螺钉		4	
23		连砑推轴		1	
24		摆架		1	
25		连杆		4	
26		摆架连杆轴		2	
27		挡圈		2	
28		摆板心轴		1	
29		摆板		1	
30		平垫		5	
31		六角螺母		8	
32		上过渡轴		1	
33		摆板连接轴		1	
34		气缸		1	
35		内六角圆柱头螺钉		6	
36		抬大压脚气缸座		1	
37		内六角圆柱头螺钉		4	
38		接近开关座		2	
39		内六角圆柱头螺钉		4	
40		上拉杆		2	
41		挡圈		1	
42		挡套		1	
43		挡套		2	

44		下拉杆		2	
45		挡套		2	
46		气缸头		1	
47		过渡杆		1	
48		轴承		4	
49		摆动杆		1	
50		摆动杆		1	
51		轴承座		3	
52		内六角圆柱头螺钉		9	
53		垫圈		1	
54		上推齿杆		1	
55		内六角圆柱头螺钉		4	
56		上推齿杆限位件		1	
57		上推齿杆限位件固定板		1	
58		上推齿		1	
59		上推齿附夹		1	
60		内六角圆柱头螺钉		1	
61		定位夹		1	
62		内六角圆柱头螺钉		1	
63		竖杆联轴		1	
64		挡圈		2	
65		摆杆		1	
66		连杆		1	
67		内六角圆柱头螺钉		1	
68		轴承		2	
69		轴承		1	
		轴承内圈		1	
70		平垫		2	
71		轴承		3	
72		螺纹弯头		2	

2. 下推齿部分



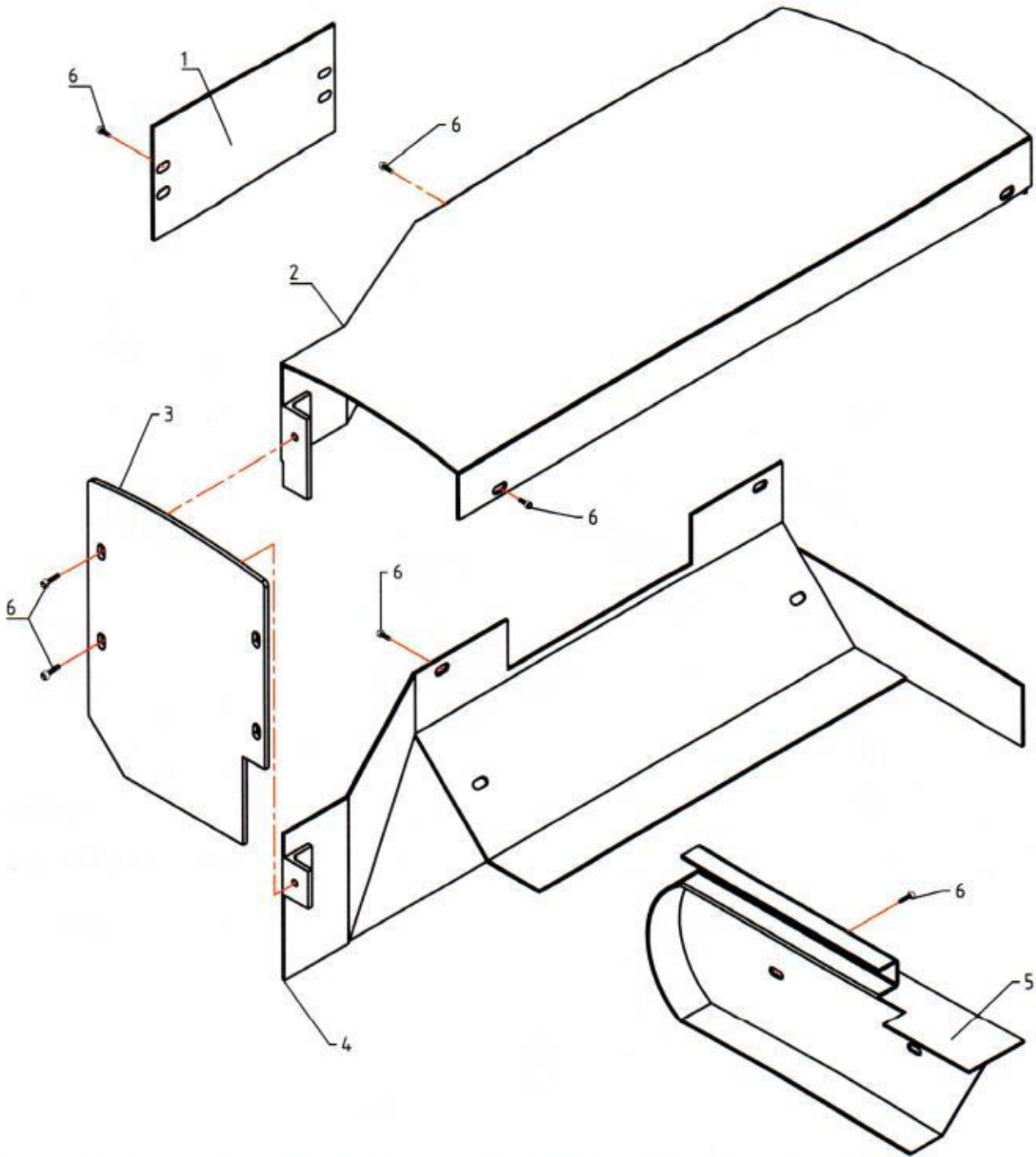
2. 下推齿部分零件清单

序号	零件号	名称	型号规格	数量	备注
1		同步电机		1	
2		电机固定板		1	
3		内六角平头紧定螺钉		2	
4		主动齿轮		1	
5		内六角平头紧定螺钉		4	
6		偏心轮		1	
7		内六角圆柱头螺钉		5	
8		推动连杆		1	
9		挡套		2	
10		挡圈		2	
11		内六角圆柱头螺钉		10	
12		平垫		8	
13		弹垫		8	
14		定位挡块		1	
15		电机座		1	
16		从动齿轮		1	
17		电机端竖板		1	
18		从动齿轮轴		1	
19		轴承		13	
20		竖板		1	
21		摆架轴		1	
22		内六角平头紧定螺钉		10	
23		连砭推轴		1	
24		摆架		1	
25		连杆		4	
26		摆架连杆轴		2	
27		挡圈		2	
28		摆板心轴		1	
29		摆板		1	
30		平垫		5	
31		六角螺母		8	
32		带架座		1	
33		摆板连接轴		1	
34		内六角圆柱头螺钉		9	
35		下过渡轴		1	
36		附板		1	
37		内六角圆柱头螺钉		8	
38		接近开关座		1	
39		内六角圆柱头螺钉		2	
40		摆动杆		1	
41		轴承		3	
42		摆动杆		1	
43		内六角圆柱头螺钉		7	
44		内六角圆柱头螺钉		13	
45		内六角圆柱头螺钉		1	
46		竖杆联轴		1	
47		内六角圆柱头螺钉		1	

序号	名称	数量	备注
48	下连杆	1	
49	大牙齿下压推板	1	
50	下连杆与大牙齿座连轴	1	
51	下气缸顶	1	
52	气缸	1	
53	调节板	1	
54	上推齿杆限位件固定板	1	
55	大牙齿座	1	
56	大牙齿	1	
57	偏心轮	1	
58	下复位板拉簧	1	
59	主动同步带轮	1	
60	皮带轮	1	
61	推板复位弹簧钩	1	
62	六角螺母	2	
63	下气缸座板	1	
64	挡圈	2	
65	内六角圆柱头螺钉	2	
66	内六角圆柱头螺钉	2	
67	左推板	1	
68	送布牙螺钉	2	
69	送布牙	1	
70	针板	1	
71	右推板	1	
72	针板螺钉	2	
73	内六角圆柱头螺钉	1	
74	外压脚	1	
75	内六角圆柱头螺钉	1	
76	内压脚	1	
77	上推齿定位板	1	
78	滚花高头螺钉	2	
79	下竖杆	1	
80	内六角圆柱头螺钉	7	
81	同步皮带罩撑杆	1	
82	后座	1	
83	被动同步带轮轴	1	
84	同步皮带罩撑杆	1	
85	被动同步带轮	1	
86	顶板	1	
87	带架杆	1	
88	轴承	1	
89	平垫	5	
90	轴承	3	
91	轴承	2	
92	蝶形螺钉	2	
93	带盘挡圈	2	
94	撑座	1	
95	撑杆	1	
96	摆杆	1	

序号		名称		数量	
97		内六角圆柱头螺钉		1	
98		平垫		1	
99		销轴		1	
0		内六角圆柱头螺钉		1	

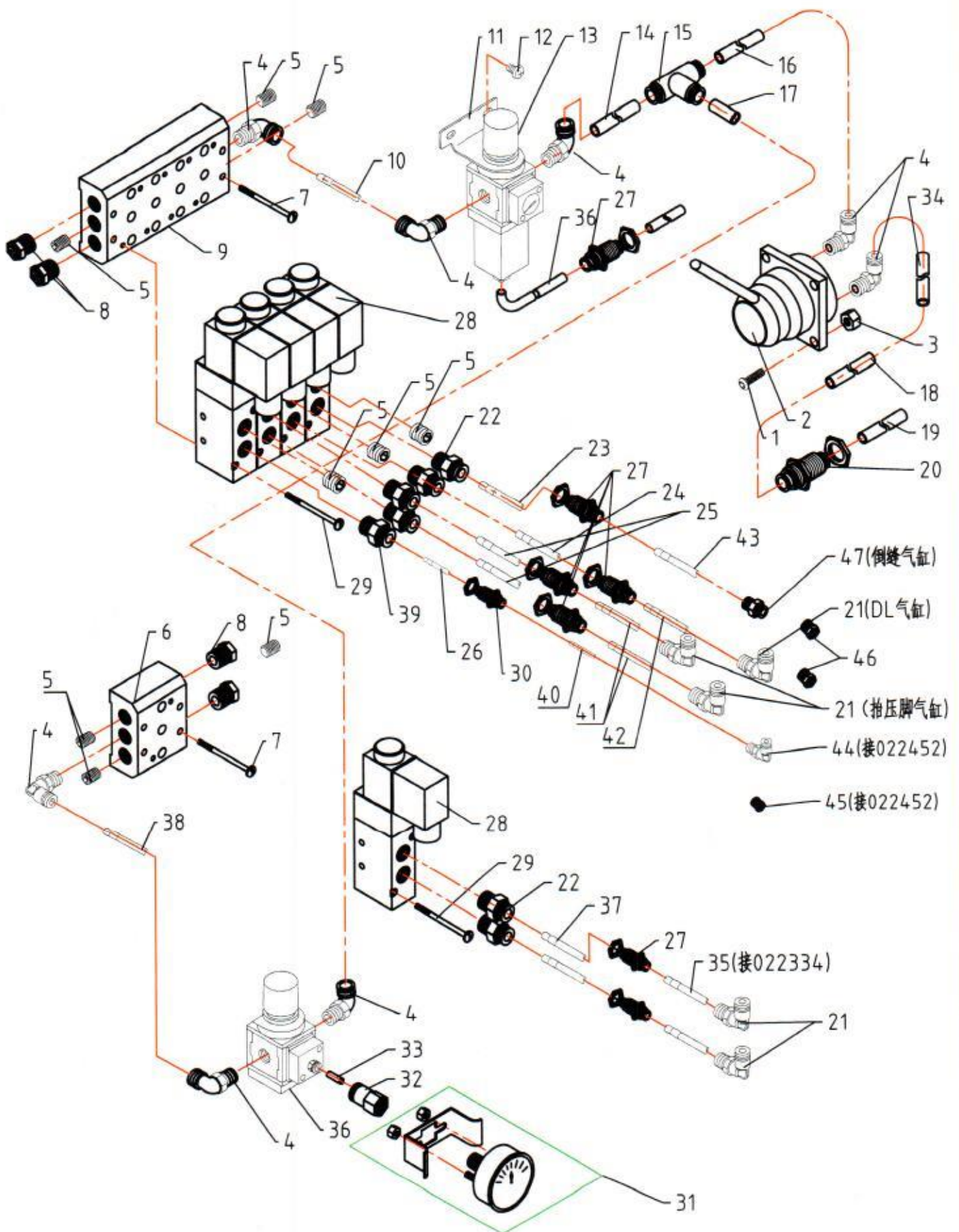
3. 护罩部分



2. 防护罩部分零件清单

序号	零件号	名称	型号规格	数量	备注
1		护罩盖板		1	
2		上护罩		1	
3		护罩左端盖		1	
4		下护罩		1	
5		同步带罩		1	
6		内六角平圆头螺钉		16	

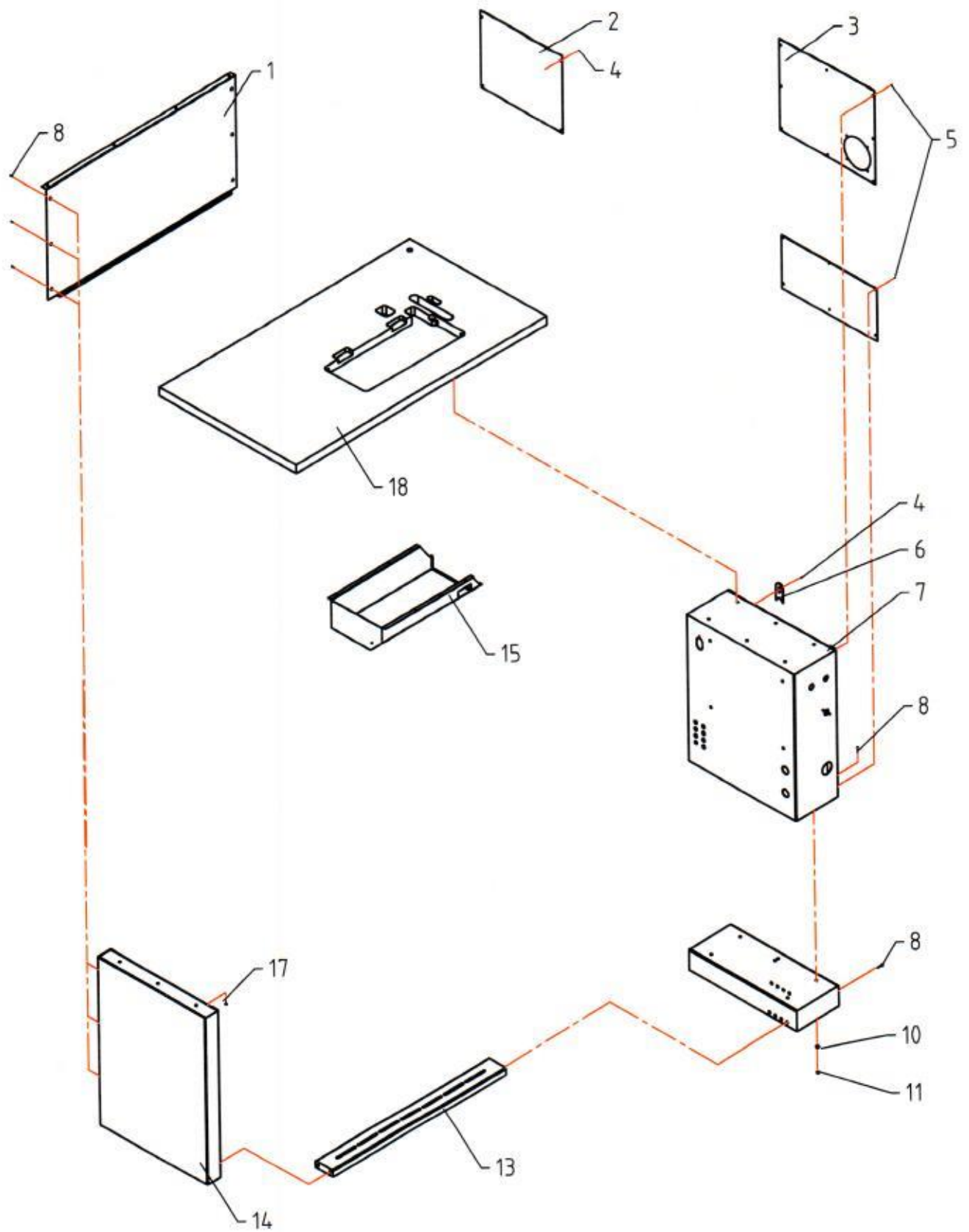
4. 气动控制部分



4. 气控部分零件清单

序号	零件号	名称	型号规格	数量	备注
1		内六角圆平头螺钉		4	
2		手转阀		1	
3		六角螺母		4	
4		螺纹弯通		8	
5		堵头		9	
6		电磁阀底座		1	
7		内六角平圆头螺钉		4	
8		消声器		4	
9		电磁阀底座		1	
10		气管		1	
11		托架		1	
12		十字机丝		2	
13		调压过滤阀		1	
14		气管		1	
15		Y型三通		1	
16		气管		1	
17		气管		1	
18		螺纹弯通		8	
19		气管		1	
20		快速接头		1	
21		螺纹弯通		5	
22		螺纹直通		6	
23		气管		2	
24		气管		2	
25		气管		2	
26		气管		2	
27		快速接头		7	
28		电磁阀		5	
29		十字机丝		10	
30		快速接头		1	
31		气压表组件		1	
32		内螺纹直通		1	
33		气管		1	
34		气管		1	
35		气管		1	
36		调压过滤阀		1	
37		气管		2	
38		气管		1	
39		螺纹直通		1	
40		气管		2	
41		气管		1	
42		气管		1	
43		气管		1	
44		螺纹弯通		1	
45		消声器		1	
46		消声器		2	
47		螺纹直通		1	

5. 板架控制箱



5. 板架控制箱部分

序号	零件号	名称	型号规格	数量	备注
1		后连板		1	
2		电气安装板		1	
3		上盖板		1	
4		十字槽盘头螺钉		5	
5		内六角圆平头螺钉		14	
6		过线口封		1	
7		机架控制箱		1	
8		内六角圆柱头螺钉		14	
9		机架控制箱底座		1	
10		平垫		20	
11		六角螺母		6	
12		下撑挡		1	
13		机架左立板		1	
14		油底盒		1	
15		十字槽六角头自攻螺钉		9	
16		台板		1	

