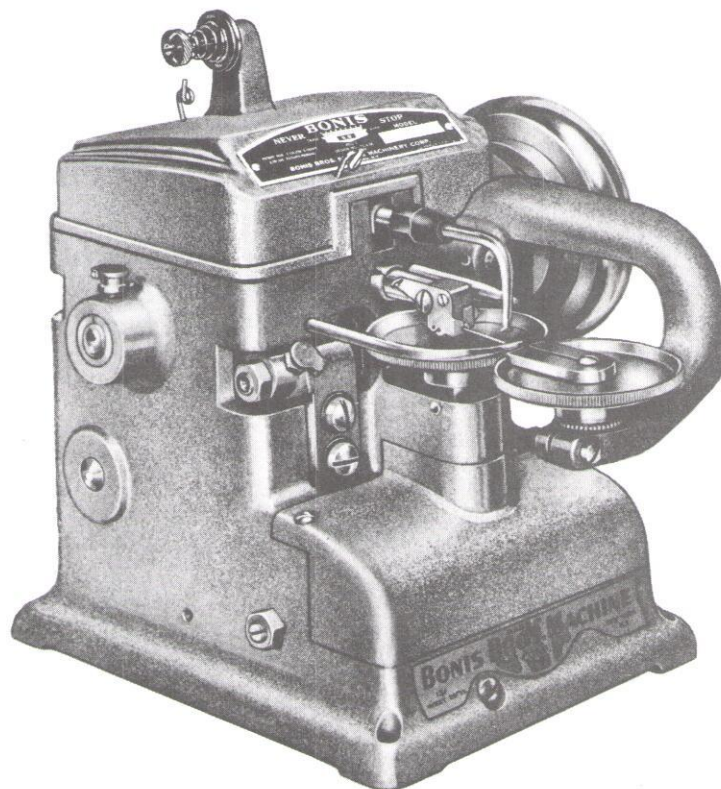


BONIS SEWING MACHINES



BONIS BROS. SEWING MACHINERY CORP.

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BONIS SEWING MACHINES

The Bonis Sewing Machines are designed to produce Whipstitch (Overseam) cup-feed # 501 stitch (chain stitch) single and two thread models in various widths of stitches, tight welted seam to flat butted seams. There are approximately forty different models giving a wide choice for perfect overseam stitching on all types of materials including leathers, acrylics, furs, pile fabrics, knits, synthetics, and all man-made fiber fabrics, rubber, foam rubber, etc., in many different manufacturing areas. The stitch lengths vary from four to thirty-six stitches per inch depending on models.

USE ONLY GENUINE BONIS

NEEDLES and PARTS



It is imperative to use Genuine Bonis Needles ONLY, as all Bonis machines are timed in the factory using Bonis needles, therefore, for trouble-free performance, it is mandatory to use *only* genuine Bonis needles which are of superior quality and perfected by intensive research. They have been designed and made especially for Bonis Machines; precision made with the proper temper and smooth eye. They are also the exact length and perfect fit to produce maximum efficiency in sewing heavy or fine work. They eliminate skipping of stitches; needle and thread breakage.

GENUINE BONIS MACHINE PARTS are equally important. It is not possible to put old parts into a new type machine and make it work right. All Bonis machines and their parts are meticulously manufactured in our own plant under the supervision of fully skilled mechanics and sold by us or our authorized Bonis agents. These agents are located in all important cities of the U.S. and the entire world. They are equipped to give you excellent sales and service. BE SURE to order directly from our New York office or from one of the authentic agents.

WHEN ORDERING PARTS YOU *MUST* STATE MODEL NUMBER OR MACHINE AND PART NUMBER.

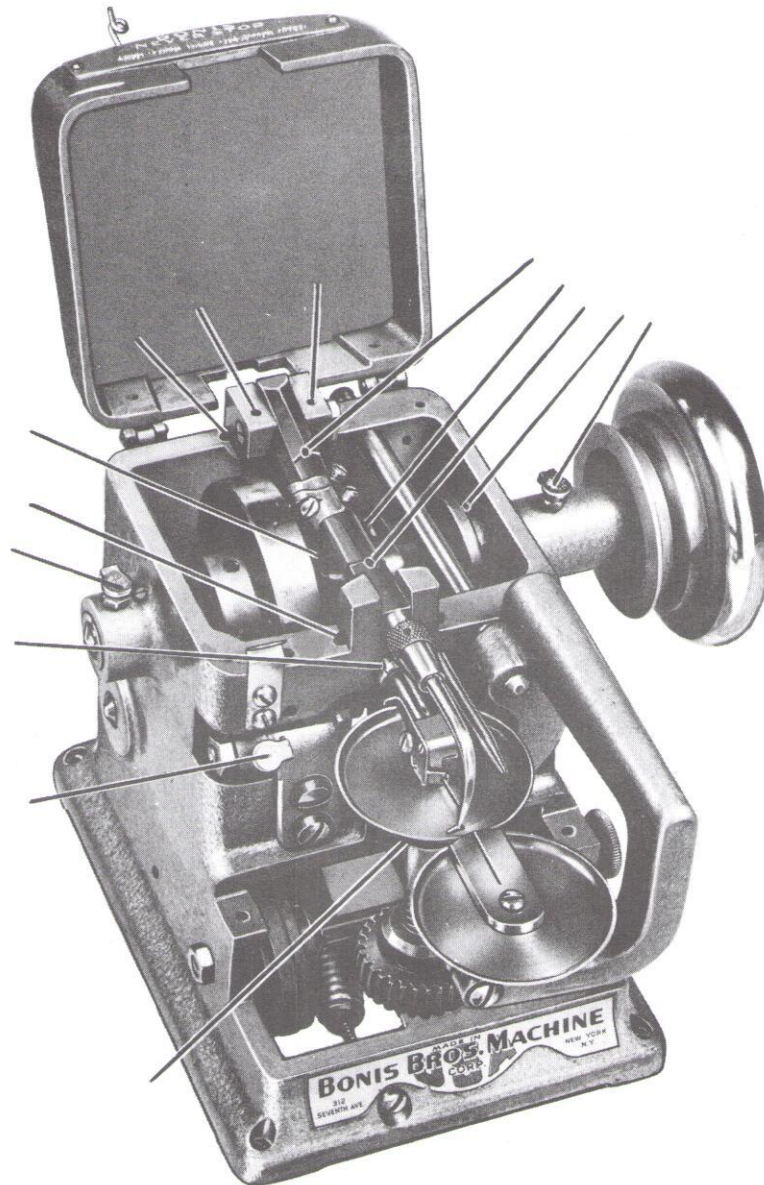
INSTALLATION

Not all machines are placed in the same position on the tables. There are so many variations in mounting the machine head that it is impossible to give accurate instructions for each machine mounting and alignment with pulleys, therefore we have tried to simplify it for you by supplying a template that can be removed from the back of this book. This template is the exact measurement of the Bonis base plate.

Place this template in setting desired, according to work to be done and use template for drilling chain hole (for opening and closing feed arm), oil drainage and markings for 1½" wood screws #213 as illustrated on template.

OILING

Be sure to put oil in cover where indicated in red.



The machine should be oiled at least three times a day or once every two hours of steady running, to maintain maximum speed and trouble-free operation. No. 40 oil is recommended. It is refined oil and will make the machine endure at high speed.

SPEED

The speed of these machines can be 3,000 R.P.M., although we recommend 2,600 R.P.M.

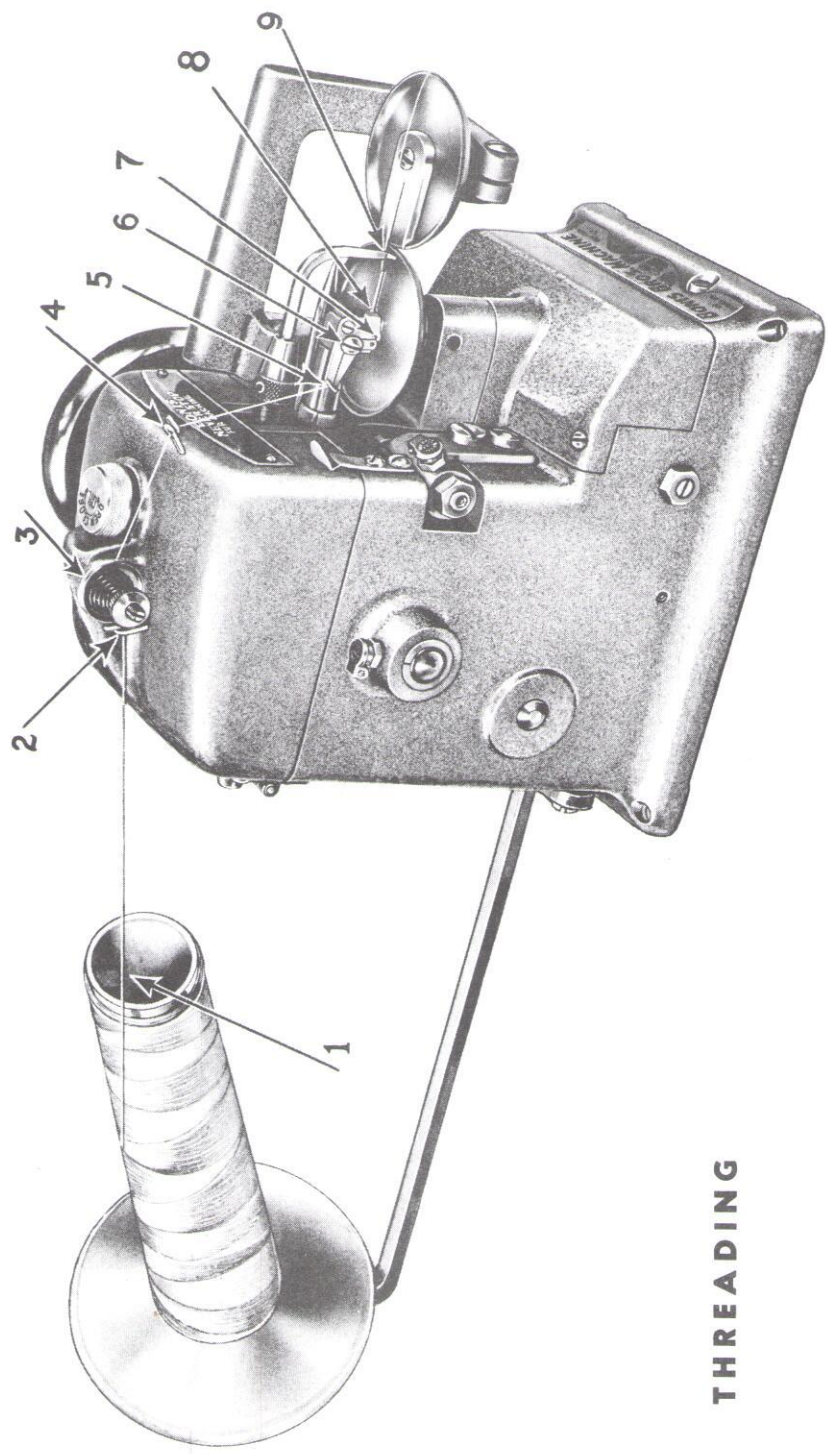
THREADING

To thread the machine; take thread for # 1 spool holder, through # 2 rear pig tail (thread guide) forward and over between the tension discs # 3, from top continue through front pigtail # 4, down and through the hole # 5 in the needle bar tension plate. Now turn the machine pulley until the needle bar tension plunger # 6 opens; holding the thread tight, open front disc and pass thread under the needle and back under the needle bar into thread slot # 7. Loop thread over tension plunger # 6 draw forward, close up under the needle bar and into hole # 8 in the tension plate through which the needle protrudes. Now, from the **underside**, pass the thread up through the needle eye # 9. Make sure you follow these simple instructions by number.

SETTING OF NEEDLE

Turn the belt wheel until looper swings out of the way of needle path and open feed discs. Hold the needle with short groove up. Place it into needle groove in needle bar slot where clamp holds it and push it back as far as it will go. Tighten the clamp screw. Never release the needle clamp more than necessary to free needle; make sure there is no broken piece of needle left in the groove.

Caution: The short groove of needle must face UP and the long groove face on the UNDER side. The machine will not sew properly if needle is inserted on reverse side.



THREADING

Keep Your Machines Clean

MINOR ADJUSTMENTS

When operating your machine, if it does not function properly, if it skips, or the thread breaks often, it may need some minor adjustment which you can very well do.

1—Check front disc and see that it is running smoothly and not clogged with loose fur, remove needle plate, take wheel apart, wipe off entire wheel, rollers and stud. By doing this you will get excellent results in producing a proper even seam. It also eliminates skipping and thread breakage.

2—Make sure needle plate slot is free of ridges and any foreign matter. Also be sure needle is not bent, see that tension is free of dirt. Take it apart and clean it.

See that thread runs through eye of needle freely.

3—Loosen two screws in needle bar yoke inside machine and push back needle bar a little. Sometimes it has to be moved one way or the other for better sewing results.

Take care of your Bonis Machine and it will take care of you with maximum efficiency under severe tests.

REMOVAL AND REPLACEMENT OF PARTS: LOOPER, WHEELS, NEEDLE BAR and THREAD GUIDES

It is advisable not to try to replace any but the above named parts as we have trained mechanics for this work. If any other parts are needed, we suggest sending the machine to our factory where these trained mechanics can make your replacements with a minimum of time and trouble.

INSTALLATION OF FEED DISCS #18R & 18F REPLACEMENT

18R-Back Wheel has two screws (# 202) which are attached to the back shaft # 106 and also is driven by the gear # 17 which has two screws (202). Loosen these screws to remove back wheel, careful not to hit needle bar (# 113) and drive shaft out of wheel.

Replace the wheel by driving shaft back up into wheel (# 18R) until shaft is flush with inside of wheel, then tighten the two screws (202) on back wheel # 18R, then follow instructions in setting of wheel (Step 1).

18F Disc. Simply loosen screw (# 210) on Feed Disc Arm # 119 and unscrew complete disc for replacement. When installing 18F disc, screw disc into arm (# 19) and follow (Step 2).

**(When ordering discs please specify
model of machine and size disc required.)**

SETTING OF MACHINE

1—Setting of Wheels (18F & 18R) (18FB & 18R)

(Step 1) Set the back wheel 18R up to the needle, leaving enough room for the cotton to pull freely between the needle and the back wheel. Tighten both set screws (#202) on gear # 17.

(Step 2) Set the 18F Front wheel a fraction below the back wheel allowing for the pitch in the needle bar.

(Step 3) Turn the needle plate to meet the needle. Set needle to run straight into needle plate slot, making sure that there is about .033 play between the needle and the bottom of needle plate slot. When this is set, proceed to Step 4.

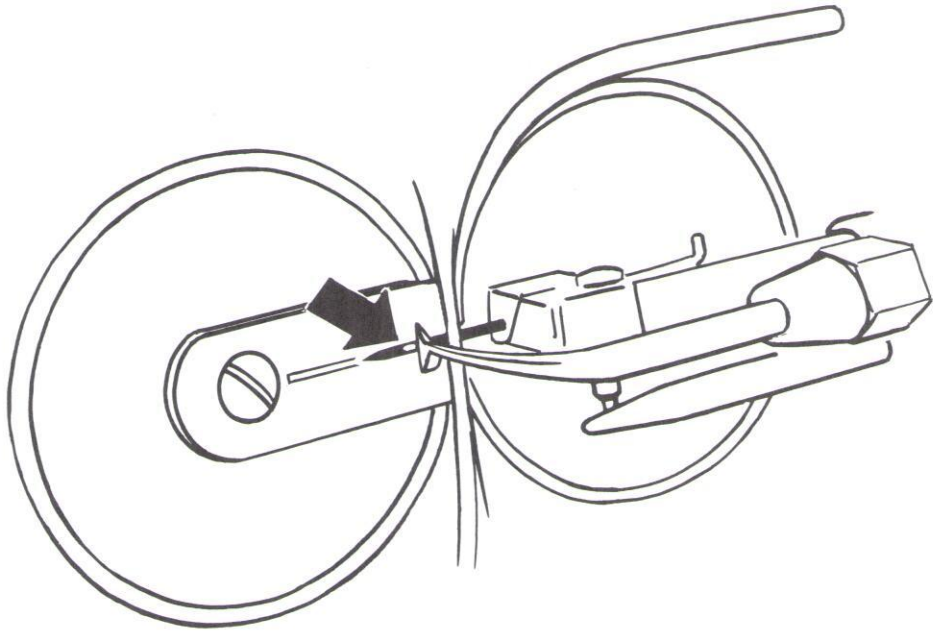
(Step 4) Needle bar should be set out to approximately 1/32nd inch away from rim of back wheel and must appear to be aligned straight. Then tighten needle bar yoke screws. Check needle penetration seeing that the needle when entering material used will enter straight not striking the sides of needle slot.

SETTING OF LOOPER #114

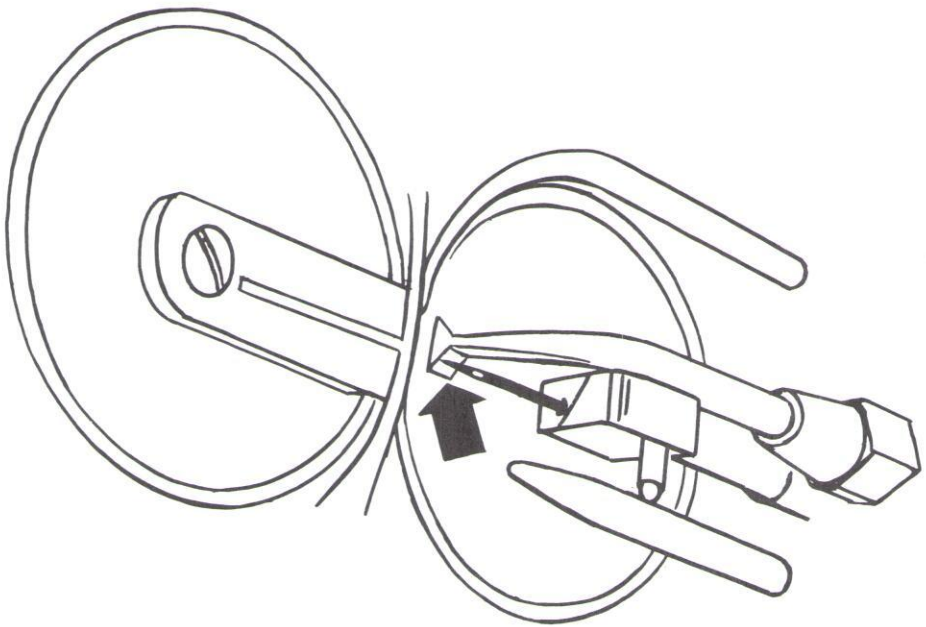
2—When you have completed step number 1 and needle bar is set, put looper into looper shaft (624) and set in position so that the looper when crossing over the needle plate and the eye of the needle has passed half way across the length of the shoe of the looper (see A diagram). Turning the belt wheel to turn the looper toward the back wheel, make sure that when the looper comes against the side of the needle that it is not striking the needle (only brushing against it). See B diagram. Setting of looper in *back stroke motion* the looper heel goes under the needle. Make sure that the needle is not protruding.

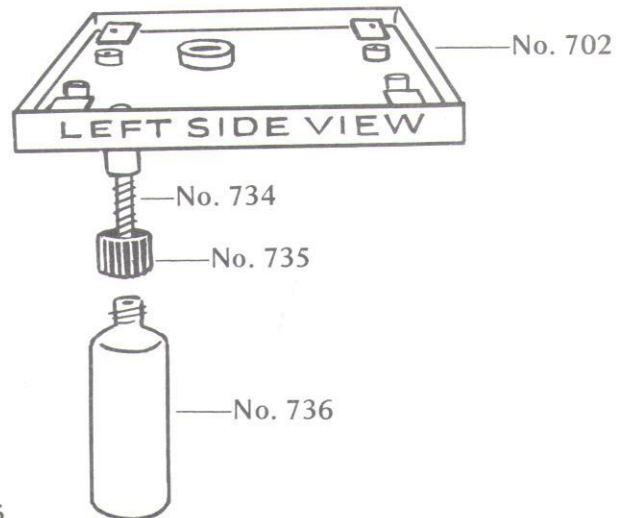
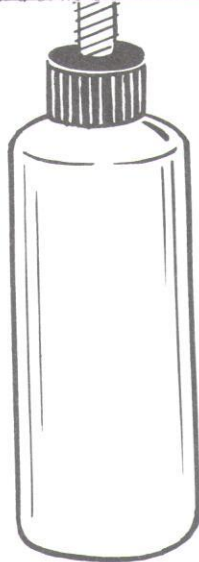
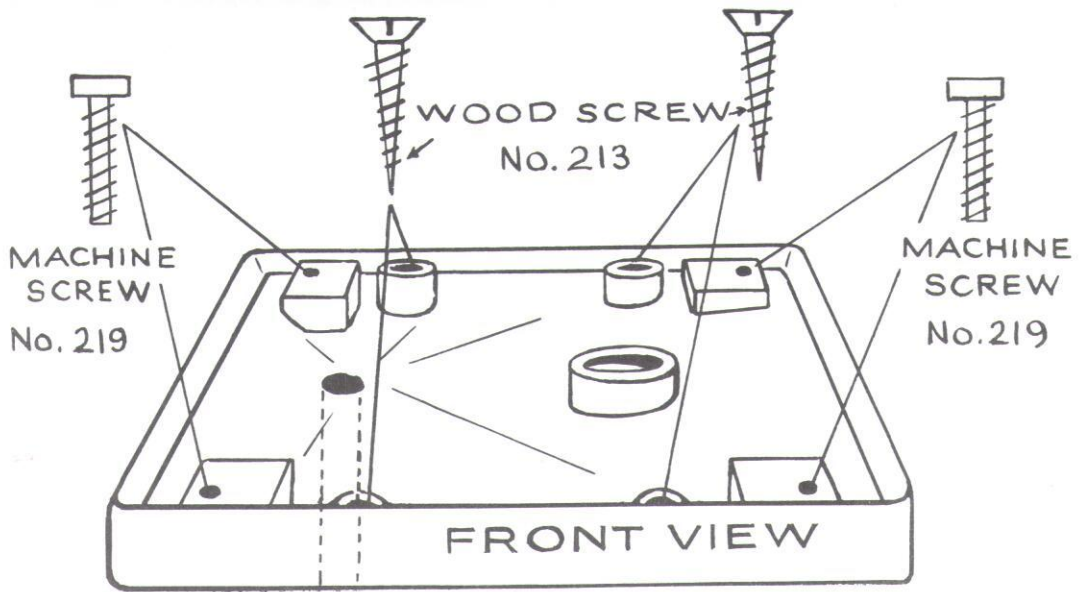
By following this looper setting, the needle will be in perfect position to lock the stitch before penetrating the material for the next stitch.

(DIAGRAM A)



(DIAGRAM B)





10/32 Filster Head
Machine Screw 7/8" Long
ON MACHINE SCREWS DO NOT DRILL HOLES

PLASTIC BASE BONIS NO.702

Base Plate Oil Pipe No.734	}	No.702 Complete
Plastic Oil Pipe Cap No.735		
Plastic Oil Jar No.736		