



TYPICAL

TW1-2B/TW1-2BL20

**Single Needle Top and Bottom Feed Extra
Heavy-duty Lockstitch Sewing Machine**

OPERATION INSTRUCTION / PARTS MANUAL

- Please don't adjust and repair the machine by non-professionals,except adjusting stitch.
- Specifications subject to change without notice

TYPICAL SEWING MACHINE WANPING MACHINERY CO.,LTD.

ADD: WANPING TOWN, WUJIANG CITY, JIANGSU
PROVINCE, CHINA

TEL: +86-512-63391278

FAX: +86-512-63391371

POST. CODE: 215223

[Http://www.typicalwpchina.com](http://www.typicalwpchina.com)

E-mail:export@typicalwpchina.cn

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Operation Instruction

1. Brief introduction

Model TW1-2B/2BL20 extra heavy duty top and bottom feed lockstitch sewing machine with large hook adopts single straight needle, link thread take-up, high precise bevel gears driving, large hook catching thread. With special upper feed mechanism, the machine shows its good performance on sewing extra heavy duty and extra thick thread.

It is widely used on sewing suitcases, leather, sofa, tents, bamboo matting, ect.

3. Operation and preparation

(1) Cleaning the machine

Before delivery, the machine parts are coated with rust preventive grease, which maybe hardened and contaminated by dust during storage and shipment. The grease and dust must be removed by clean cloth with gasoline.

(2) Examination

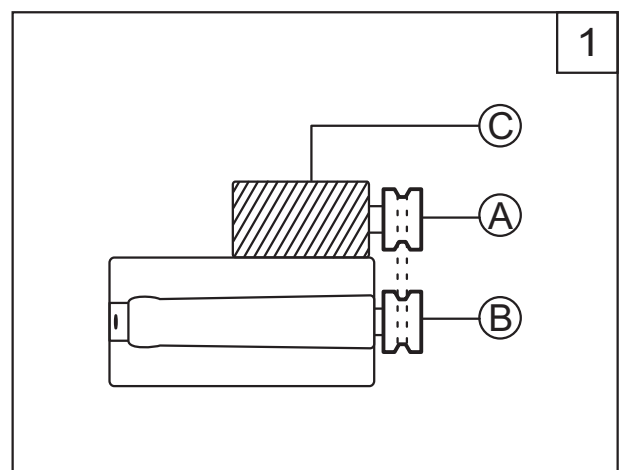
Though every machine is confirmed by strict inspection and test before delivery, the machine parts maybe loosed or deformed after a long distance transportation with jolt. A thorough examination must be performed after cleaning the machine. Turn the balance wheel to see if there is running obstruction, parts collision, uneven resistance or abnormal noise. If there exist adjustment must be made accordingly before running.

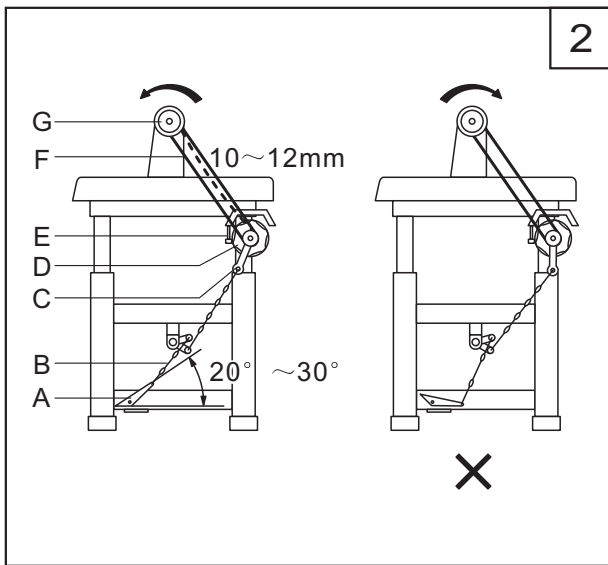
4. Installing the clutch motor (Fig. 1)

Align machine balance wheel belt groove (A) with motor pulley belt groove (B) by moving motor leftward or rightward.

2. Main technical specification

Parameter	Model	TW1-2B	TW1-2BL20
Max. Sewing speed		1200s.p.m	900s.p.m
Max. Stitch length		13mm	
Presser foot lifting		13mm by hand, over 13mm by knee	
Alternate press foot lifting range		4mm~6mm	
Timing of walking foot and feed dog		Max stroke is more than 13mm	
Rotating hook		Extra large hook	
Needle		DDX1 24#~27#	
Lubrication		Lubricated by hand	
Clutch motor		0.5KW	





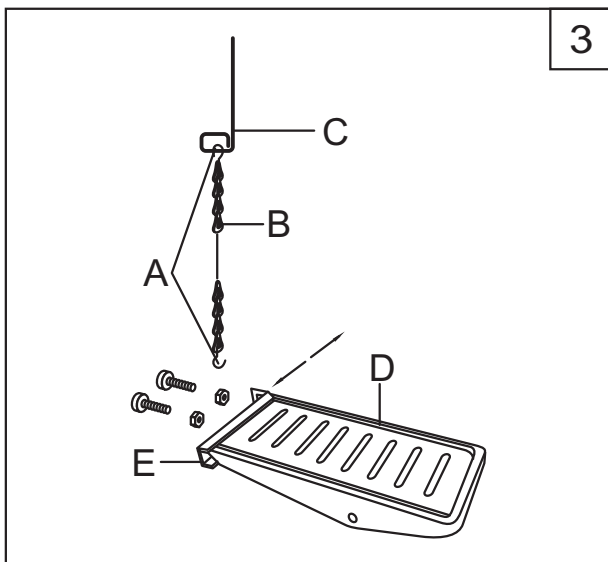
5. Connecting the clutch motor lever to the pedal (Fig. 2)

A. The optimum tilt angle of pedal with floor is approx. 20 ~ 30 degree.

B. Adjust the clutch of motor so that clutch lever (c) and draw bar (B) run in line, the machine would have stable motion and long using.

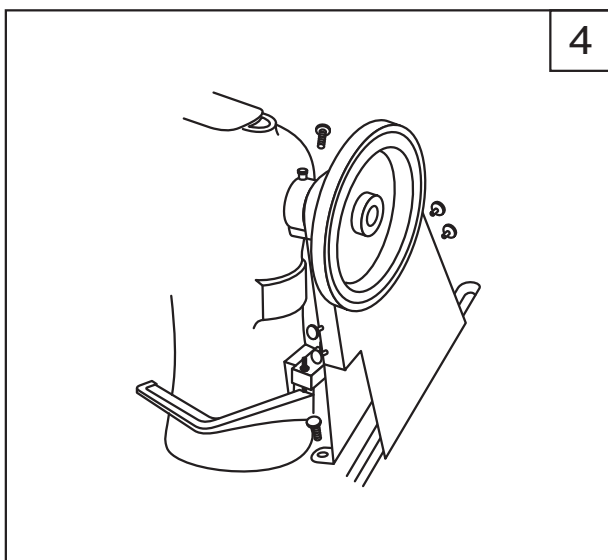
C. The machine balance wheel should rotate counterclockwise for normal sewing when view from opposite side of the balance wheel the motor rotates in the same direction. The rotation can be reversed by reversing (turn over 180 degree) the plug of the motor.

D. Adjust the tension of V-belt (F) by moving the motor vertically. The proper tension of V-belt is a slack of 10 ~ 12mm when the belt is depressed by finger.



6. Connecting the presser foot lift control pedal (Fig. 3)

First the hook A should be connected to the chain B and presser foot lift lever C, then put the pedal complete D on the stand. Move the control pedal E leftward or rightward until the chain becomes on one line. Tighten the bolts and nuts. Finally, connect the finger to the control pedal.

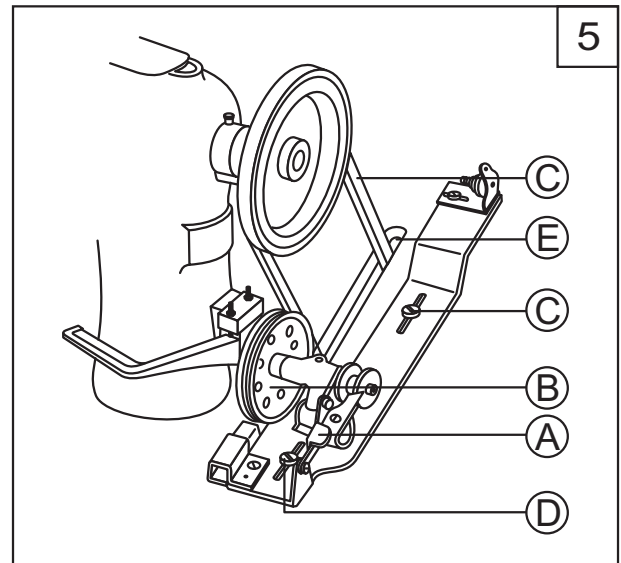


7. Installing the belt guard (Fig. 4)

Please install the belt guard for safety.

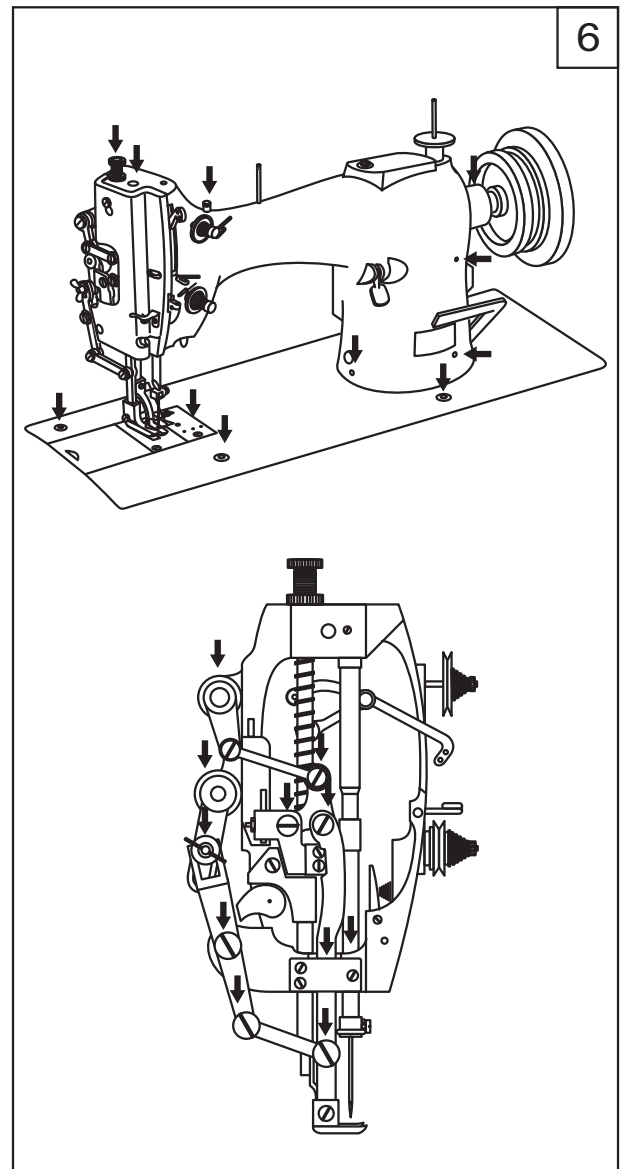
8. Installing the bobbin winder (Fig. 5)

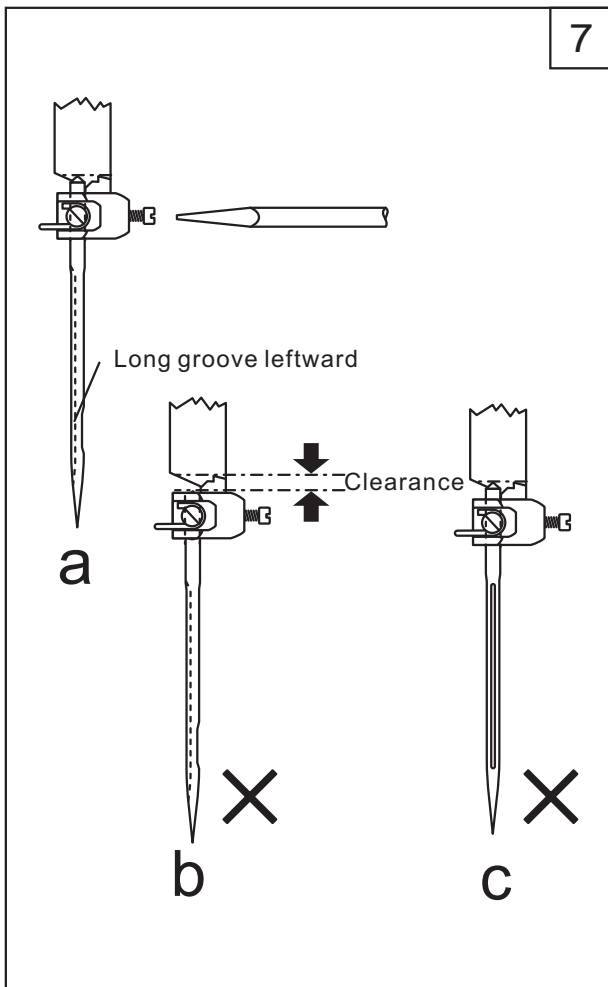
Align pulley (B) of the bobbin winder with the outside of the belt (C). And there should be a proper clearance between them so that the pulley can be contacted with the belt when stop latch thumb lever (A) is depressed. Thereby the belt drivers the pulley (B) while the machine running, the bobbin winder should be parallel with belt slit (E) of the table. Then tighten the two wood screws.



9. Lubrication (Fig. 6)

The places with red marks must be add enough oil after the machine finish running daily. Then keep running the machine for 1 2 minutes.





10. Trail run

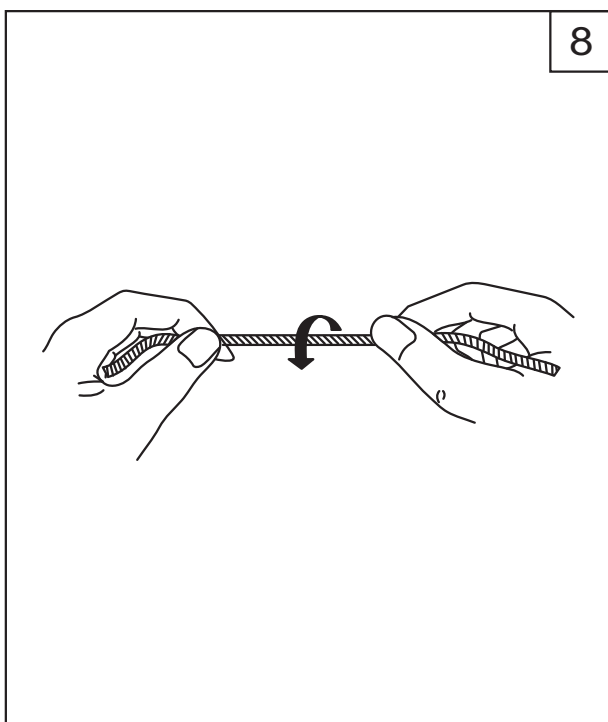
When the machine left out of operation for a quite long time and used again or a new complete machine, remove the rubber plug and face plate on the top of the machine head, oil it thoroughly. Then lift the presser foot and run the machine at a low speed of 200 400 spm. After the machine is lubricated fully, keep trial running the machine for 30 minutes, and then increase the speed gradually. After months running to perfect its performance, then increase up to its proper sewing speed.

11. Installing the needle (Fig. 7)

Turn the balance wheel to lift needle bar to its highest position, loosen needle set screw (1), keeping the long grooves facing to the left side of operator, and now fully insert the needle shank upto the bottom of needle clamp. Last tighten the screw (1) to fix the needle.

Note: Fig (b): no fully insertion

Fig (c): wrong direction of long groove in insertion



12. Coordination among the needle, the thread and the material (Fig. 8)

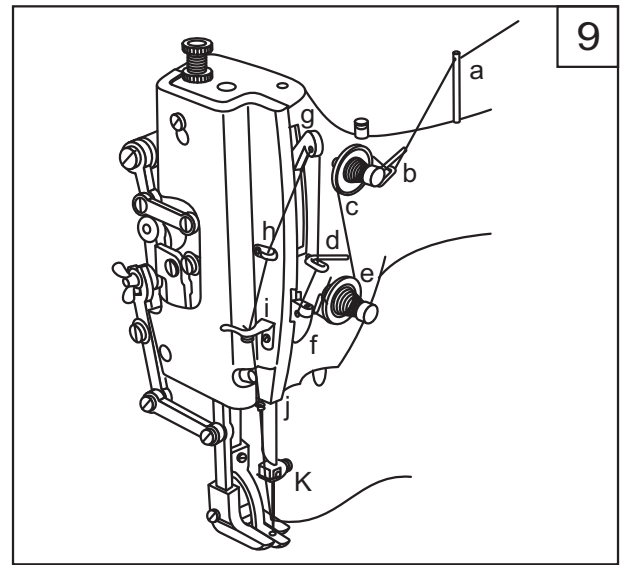
Please use the left-twisted needle thread and the left-twisted or right-twisted bobbin thread. Shown as Fig. 10, holding the thread, twist it with right hand in the direction of arrow, if it becomes tight, it is left-twisted thread. Otherwise, it is right-twisted thread.

Please use the model DDX1 24# 27# needle. The needle must be suitable for the materials. Sewing too heavy-duty materials and using too thin needle, the needle would be broken, thread skipping and breaking. If the needle too heavy, it would damage the fabric. So please choose the suitable needle according to the materials.

13. Threading the needle thread (Fig. 9)

When threading the needle thread, the needle bar must be its highest position. The correct threading steps as below:

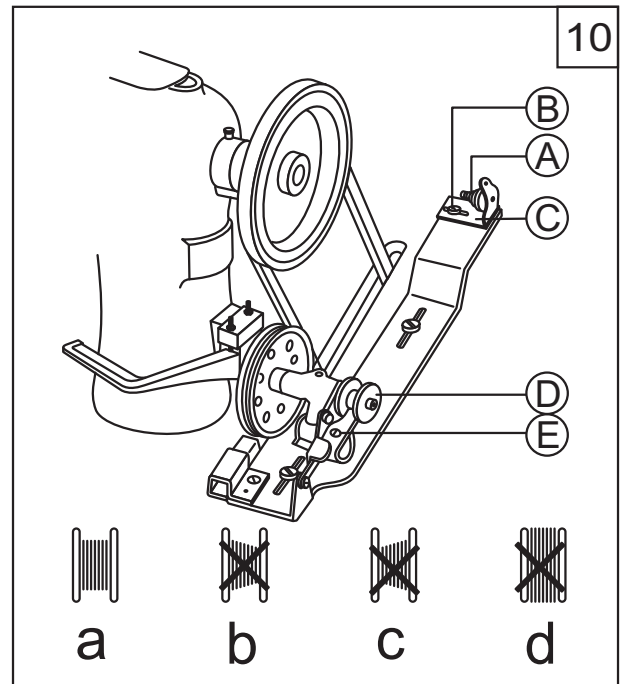
- (a) Long thread retainer
- (b) Short thread retainer
- (c) Small thread tension disc
- (d) Big thread finger
- (e) Big thread tension disc and take-up spring
- (f) Big thread finger
- (g) Thread take-up lever
- (h) Small thread finger
- (i) Thread guide
- (j) Thread retainer
- (k) Thread guide ring



14. Winding adjusting (Fig. 10)

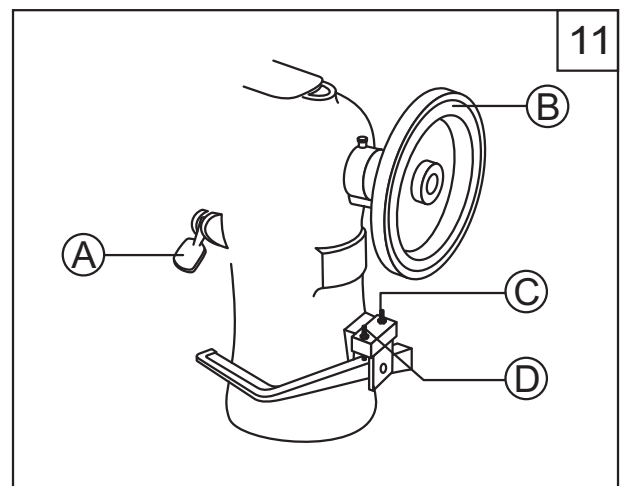
Bobbin thread should be neat and tight. If not, adjust the thread tension by turning tension stud thumbnut (A) of bobbin winder tension bracket. When the bobbin thread layer cannot present a cylindrical shown as Fig. a, loosen the tension bracket screw (B) and move the tension bracket leftward or rightward. If the thread is as shown in Fig. b, move the tension bracket rightward. If the thread is as shown in Fig. c, move the tension bracket leftward. Till the thread as shown in Fig. a, tight the the screw.

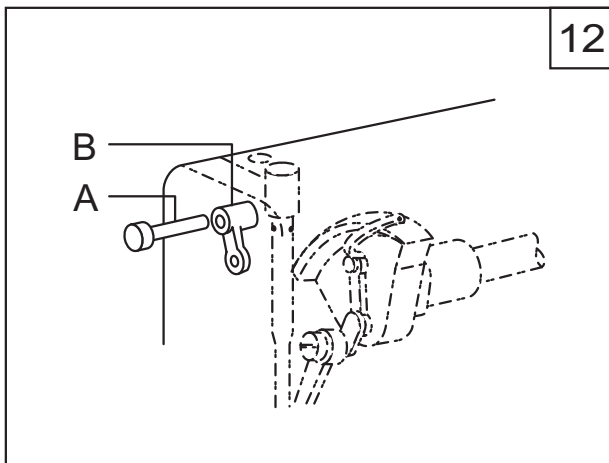
Note: Nylon or polyester thread should be wound with light tension, otherwise bobbin (D) may be broken or deform. Do not overfill the bobbin, the optimum capacity of thread will fill about 80% of bobbin outside diameter. This can be adjusted by stop latch screw (E).



15. Adjusting the forward stitch length and reverse stitch length (Fig. 11)

Stitch length can be adjusted by moving adjusting spanner (A). Turning the adjusting spanner clockwise, the stitch will be shorter. Otherwise, the stitch length will be longer. After finishing adjustment, take a paper to test the stitch length until obtaining the satisfied stitch length. Then check if the forward stitch length is same as reverse stitch length. If the reverse stitch length is shorter than forward stitch, turn the screw (C) counter clockwise, and then tighten the nut. Otherwise, turn the screw clockwise. It also can be adjusted by turn screw (D).

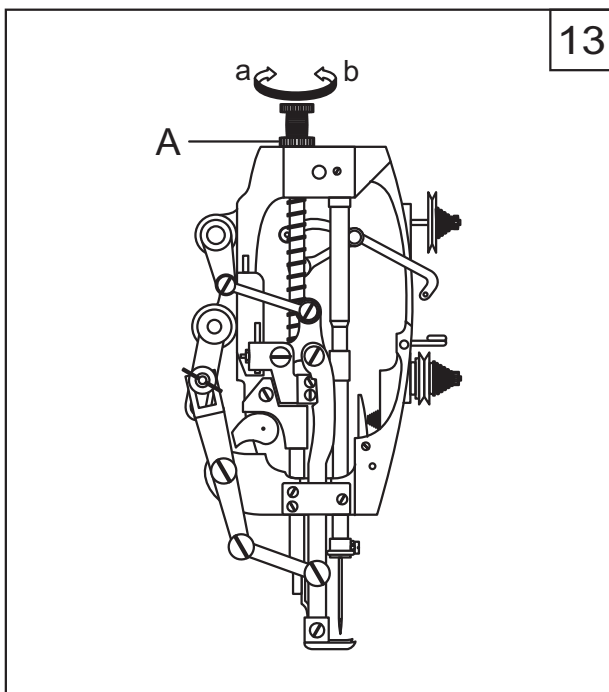




16. Oiling the thread take-up parts (Fig. 12)

Thread take-up parts adopt woolen thread oiling. After a long time using, its function lost. So it must be replaced with a new one. Steps as below:

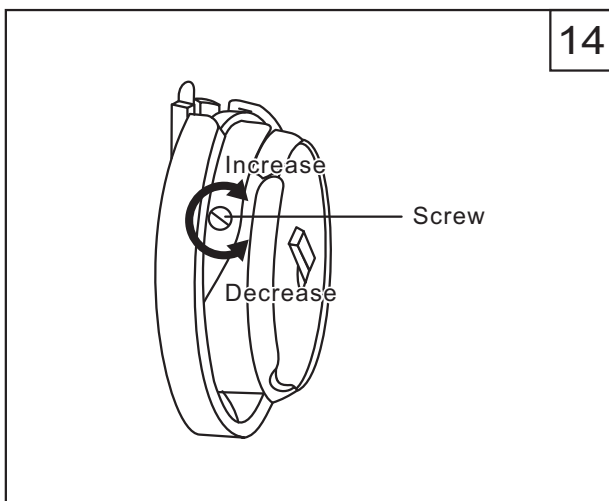
- (1) Open the faceplate remove the pressure screw, lock nut and adjusting bar.
- (2) Remove the pin (A) and draw out the old oil wick.
- (3) Draw out the oil wick in the part (B).
- (4) Change the new oil wicks.
- (5) Installing is a reverse sequence.



17. Adjusting the pressure of presser foot (Fig. 13)

Pressure on presser foot is to be adjusted in accordance with materials to be sewn. Loosen the locknut (A). If heavy materials to be sewn, turn the presser regulation thumbscrew clockwise as shown in Fig (a) to increase the pressure. While light materials to be sewn, turn the pressure regulating thumbscrew counter clockwise as show in Fig. (b) to decrease the presser on presser foot. Then tighten the lock nut (A).

The pressure on presser foot is proper as the materials can be fed normally.



18. Installing the bobbin and adjusting the thread tension (Fig. 14)

The tension on thread can be adjusted according to the materials and different types of thread. Normally, adjust the thread tension according to the sewing stitches. Adjust the sewing stitches by changing the tension on bobbin thread and needle thread.

Increase or decrease the bobbin thread tension by using the small screwdriver to turn the screw on bobbin case.

Depend on the tension on bobbin case, by changing the take-up spring tension & range, the tension of tension spring, the position of tension disc and thread finger to adjust the needle thread tension.

19. Adjusting the thread take-up spring (Fig. 15)

The normal sewing range of thread take-up spring is 5 – 8mm. For sewing light duty materials (small stitch length), weaken the spring tension and widen the sewing range of spring. While for sewing heavy duty materials, strengthen the spring tension and shorten the sewing range of spring.

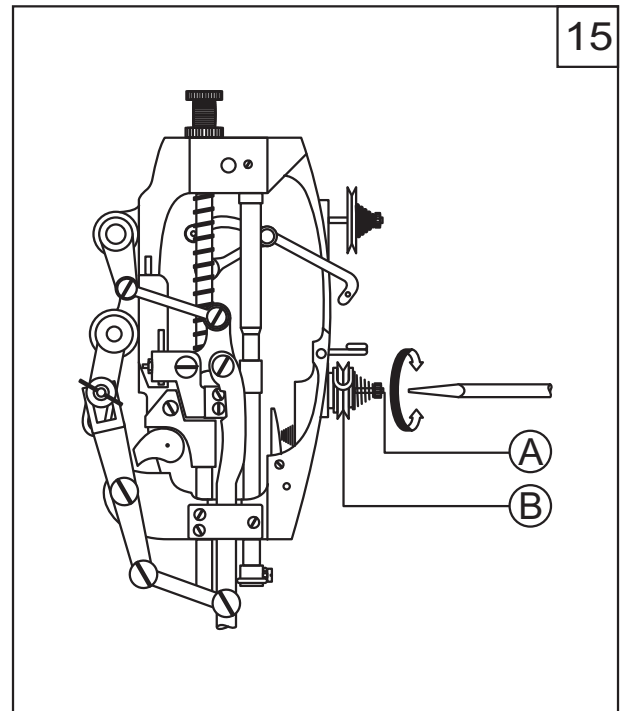
(1) Adjusting the thread take-up spring tension

Turn the tension screw (A) clockwise for increasing the tension. Otherwise turn the tension screw (A) counter clockwise for decreasing the tension.

(2) Adjusting the sewing range of thread take-up spring

Loosen the tension screw (A) and then turn the tension disc (B). Turn the tension disc clockwise for increasing the range of thread take-up spring. Otherwise, turn the tension disc counter clockwise for decreasing the range of thread take-up spring.

Before delivery, the thread take-up spring is properly adjusted. Readjustment is needed only in the case of sewing special materials or with special thread.



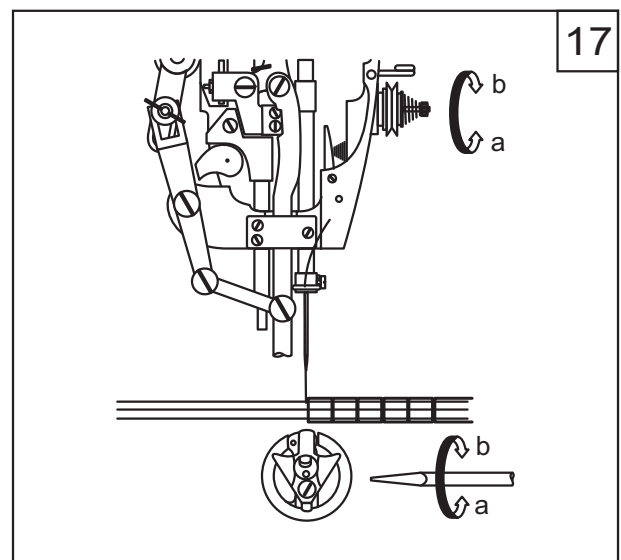
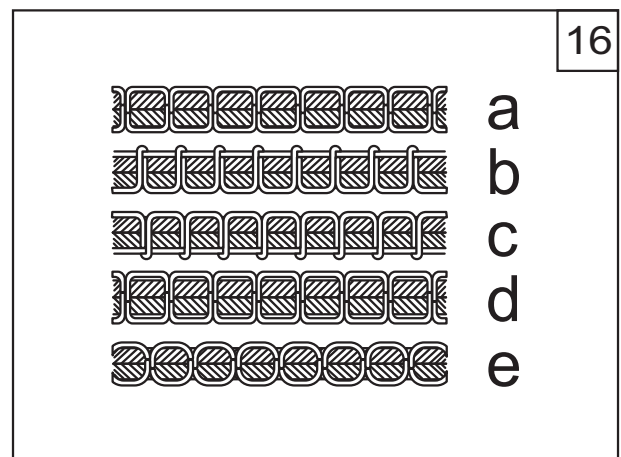
20. Adjusting the tension of needle thread and bobbin thread (Fig. 16,17)

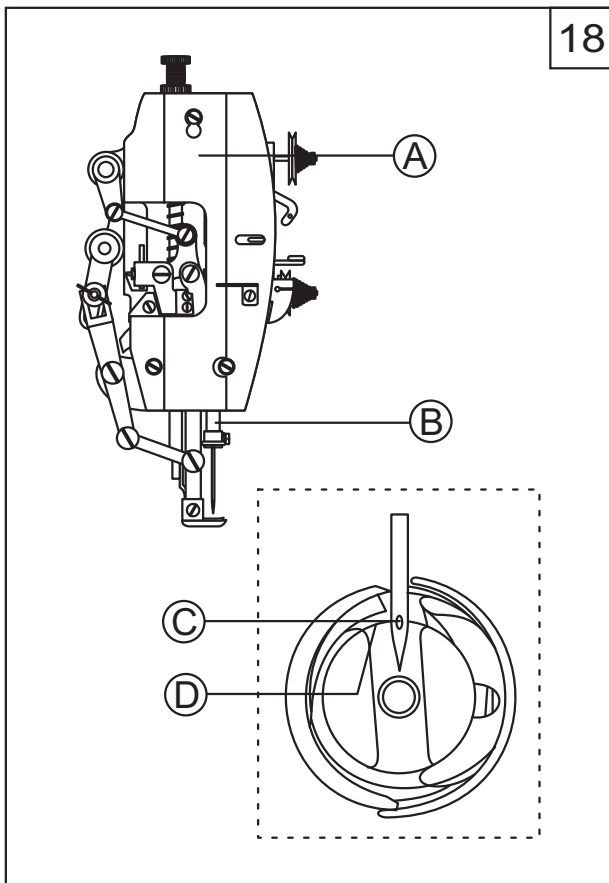
Normal stitch should be as shown in fig (a). When abnormal stitches occur with puckering or thread breakage, the tension of needle thread and bobbin thread must be adjusted. A

a. If the needle thread is too strong or the bobbin thread is too weak, turn the tension regulating thumb nut counter clockwise to make the needle thread get less tension or tighten the bobbin case tension regulating screw with a small screw driver to make the bobbin thread get more tension. A

b. If the needle thread tension is too weak or the bobbin thread is too strong, turn the tension regulating thumb nut clockwise to make the needle thread get more tension or turn the bobbin case tension regulating screw counter clockwise with a small screw driver to make the bobbin thread get less tension. A

c. Other abnormal stitches as shown in Fig (d), (e), adjustment can be made which reference to the above methods.

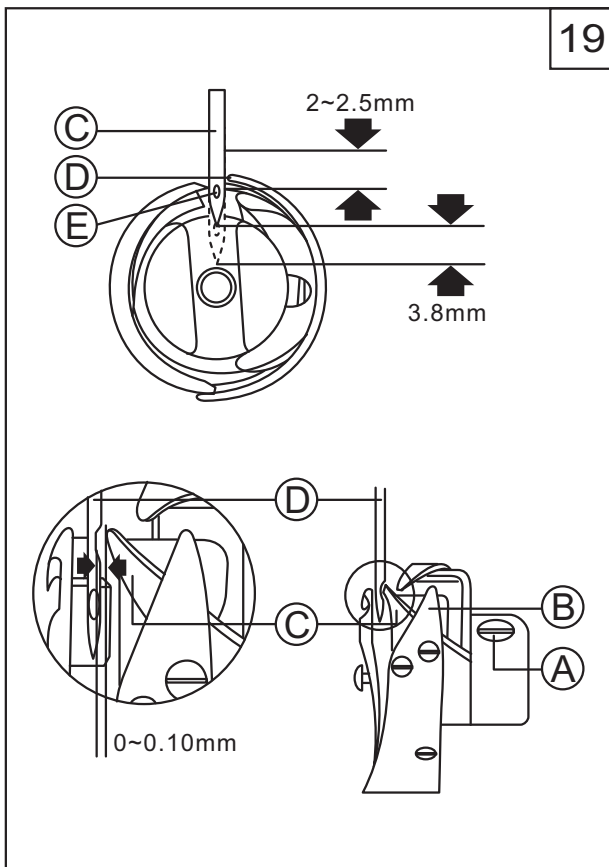




21. Timing between the needle and the rotating hook (Fig. 18,19)

(1) Adjusting the position of needle bar.

Turn the balance wheel to make the needle bar (B) to its lowest position. Remove the face plate (A), and move the needle bar (B) vertically to locate the timing position (the timing position of the needle bar is: when the needle bar at its lowest position, the center of needle eye (C) coincide with the inside surface (D) of rotating hook). Tighten the screw.



(2) Adjusting timing between rotating hook and needle.

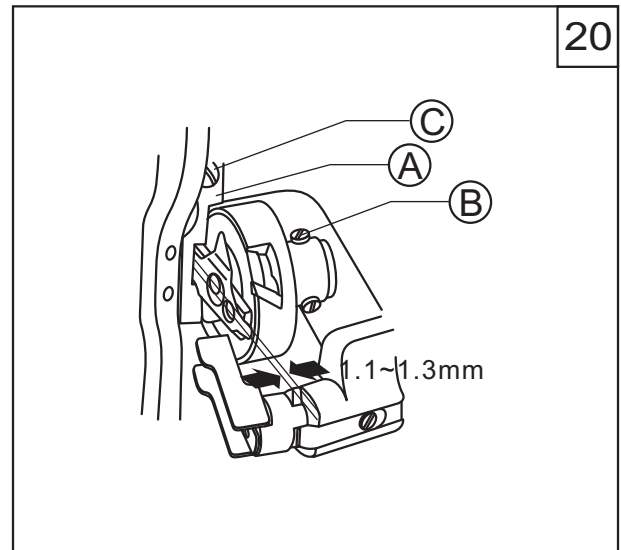
The motive relation between rotating hook and needle affects the sewing quality. Standard timing relation is: Turn the balance wheel to locate the needle bar to its lowest position and lift back 3.8mm height. The rotating hook head point (D) should be coincides with the needle centerline (C). At this time, the hook head point (D) is 2~2.5mm higher than the needle eye (E).

When adjusting the timing relation, also please notice the clearance between the hook head point and side of needle. The clearance should be 0~0.1mm.

22. Installing and uninstalling the hook (Fig. 20)

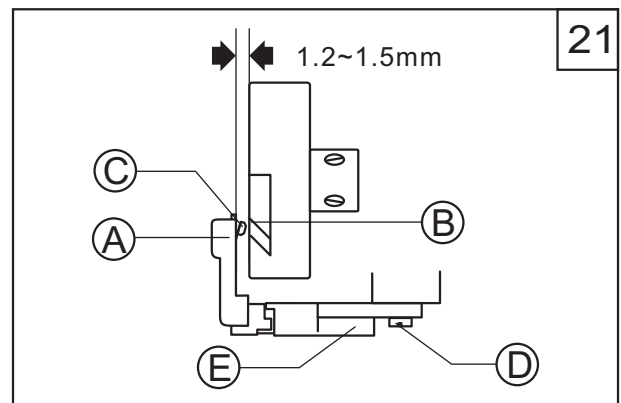
Lift the needle bar to its highest position; remove the needle plate, needle and bobbin case. Loosen the bobbin case holder bracket screw (C), and take out position bracket (A). Then loosen the set screw (B) to make the rotating hook can be turned freely on its axis. Turn the balance wheel to raise feed dog support. At this time, take down the rotating hook slowly while turning it to keep away from the feed dog support. Installing the hook can be done in reverse sequence.

The projecting flange of position bracket (A) should be engaged in the notch of the bobbin case holder. And the clearance between them should be 1.1 ~ 1.3mm.



23. Installing the hook stop bracket (Fig. 21)

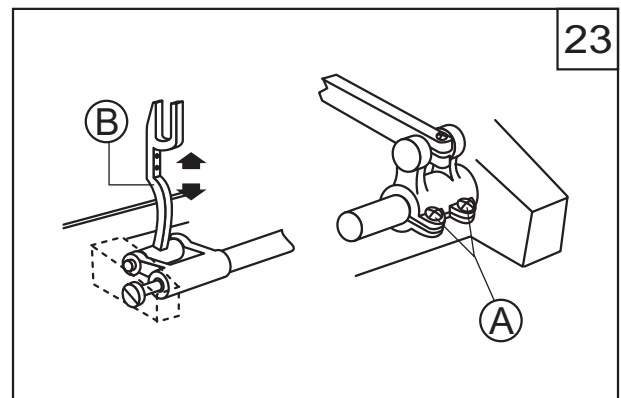
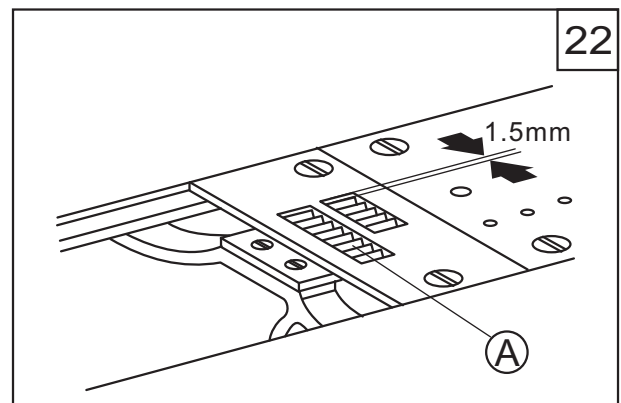
Before installing the stop bracket (E), loosen the screw (D) first. Adjust the clearance between the stop bracket and hook to keep it be 1.2 ~ 1.5mm. And keep the elastic tension of stop spring head (C) 1 ~ 1.2mm so that the stop spring head can limit the bobbin case effectively. Besides, please don't let the (C) touch the (B) by adjust their position. Last tighten the screw (D).

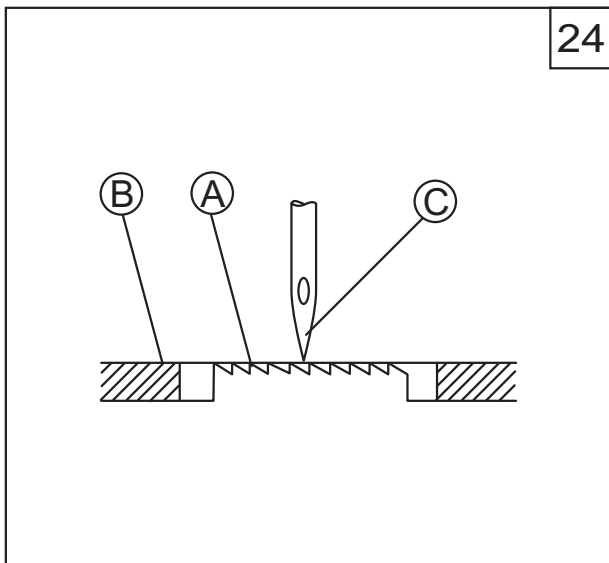


24. Installing the Feed dog (Fig. 22,23)

A. When the feed amount is at the max., the front end of feed dog (A) is near the front of needle plate slot. The gauge between them is 1.5mm. This is the standard position of feed dog.

B. To adjust the position of feed dog, move the feed to the front end of needle plate, loosen the screw (A) (See Fig23b), move the feed dog support (B) in the direction show by arrow in Fig. 23b to adjust it. After adjustment, tighten the screw (A).



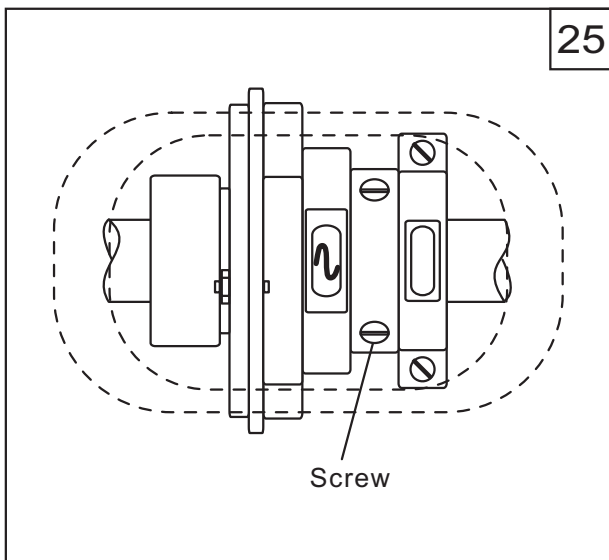


25. Feed timing adjustment (Fig. 24,25,26)

(1) Standard position

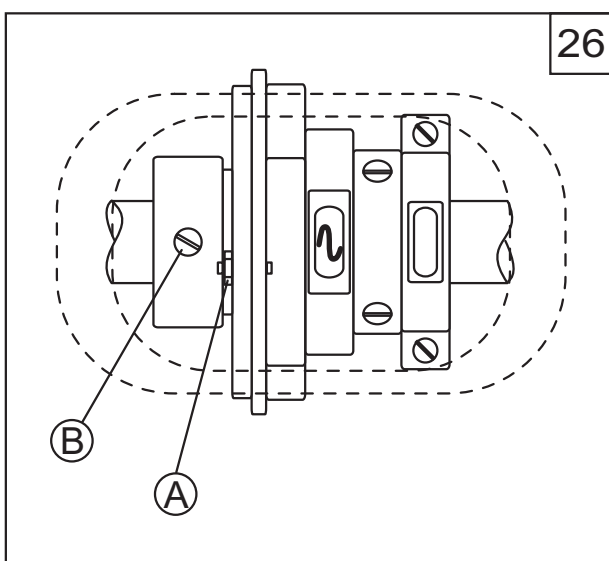
Turn the balance wheel to lower feed dog (A) until it is horizontal with the surface (B) of needle plate. At this moment, the tip of needle (C) should be horizontal with the surface of needle plate and feed dog.

Adjustment can be done by adjusting the position of feed cam and feed dog lift cam.



(2) Installing the feed dog lift cam

Open the backside cover; turn the balance wheel by left hand counter clockwise to lift the needle bar to its highest position. Now the first screw of lift cam (direction of counter clockwise) has a tilt angle with counter-clockwise is 45 degree. Then tighten the screw.



(3) Installing the feed cam

After finish installing the feed dog lift cam, then install the feed cam. Take the feed dog lift cam as a reference, when the needle bar at its highest position, the screw (A) has a tilt angle with counter-clockwise is 30 degree. Last tighten the screw (B)

26. Upper feed adjustment (Fig. 27)

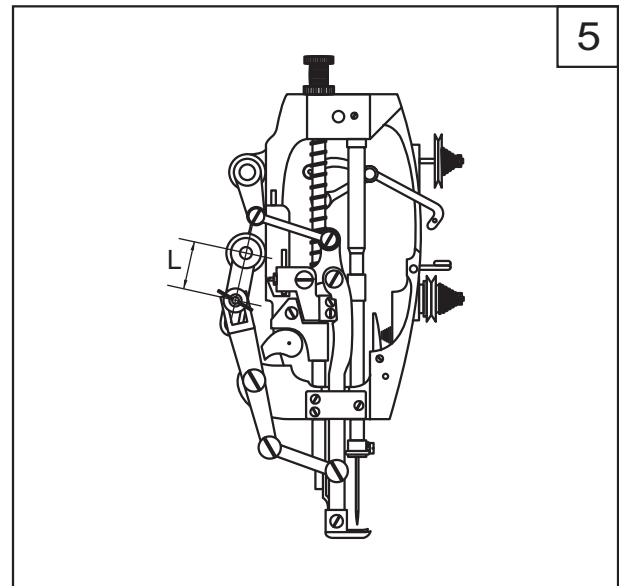
During the sewing, the center gauge (L) between the walking foot sliding block and its shaft can be adjusted according to the differences of the friction coefficients of the materials and the sewing process.

Method:

Increase L- the upper feed amount enlarged

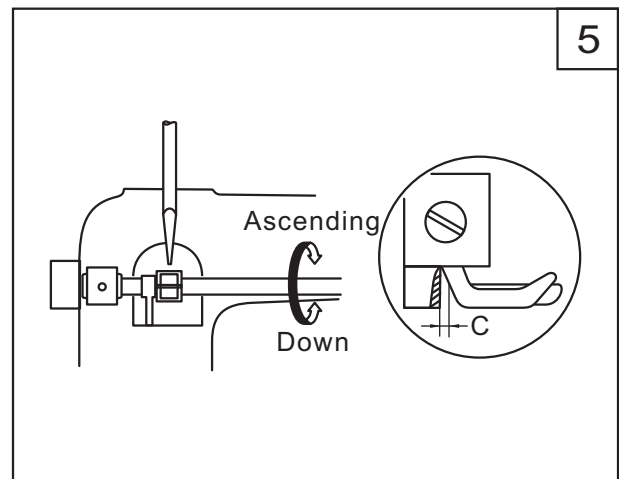
Reduce L- the upper feed amount shortened

For special sewing requirements, for example, the upper layer of materials needs more amounts than the low layer needs. In this case, adjustment can be done in the range of above theory for operation.



27. Adjusting the clearance between presser foot and walking foot (Fig. 28)

In sewing operation, for preventing the walking foot from striking on the presser foot a proper clearance (C) of approx. 1.5mm should be maintained between them. When the clearance is too small or too big, it is necessary to adjust. Loose rear crank screw and turn the rock shaft, then the walking foot moves near the needle bar. When adjusting, be sure to note the fixed number of the clearance (C).



28. Periodical cleaning (Fig. 29)

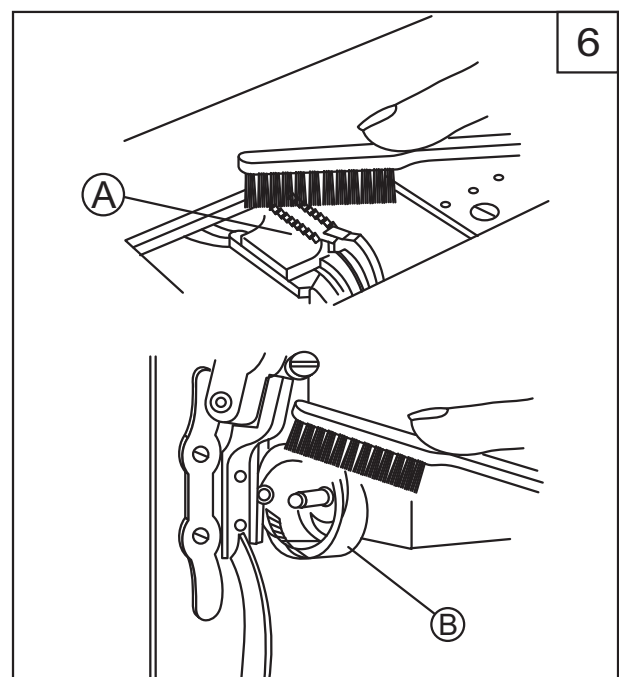
Clean the feed dog, the rotating hook and bobbin case according to the machine use condition.

(1) Cleaning the feed dog

Remove the needle plate, clean off the dust and lint in the slit of feed dog (A), then re-install the needle plate.

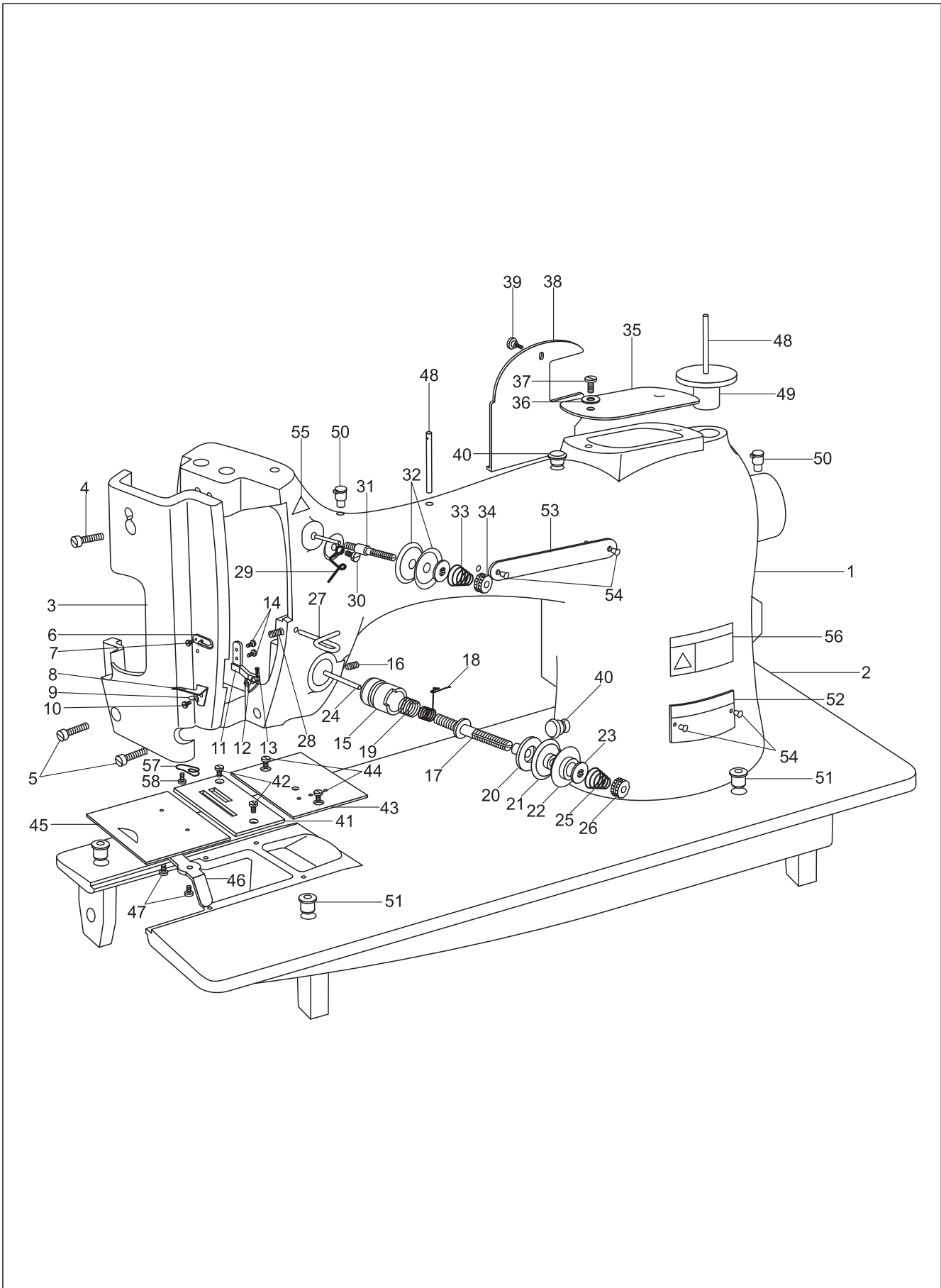
(2) Cleaning the rotating hook

Clean off all the dust around the rotation hook (B) and cleaning the bobbin case with soft cloth.



Parts Manual

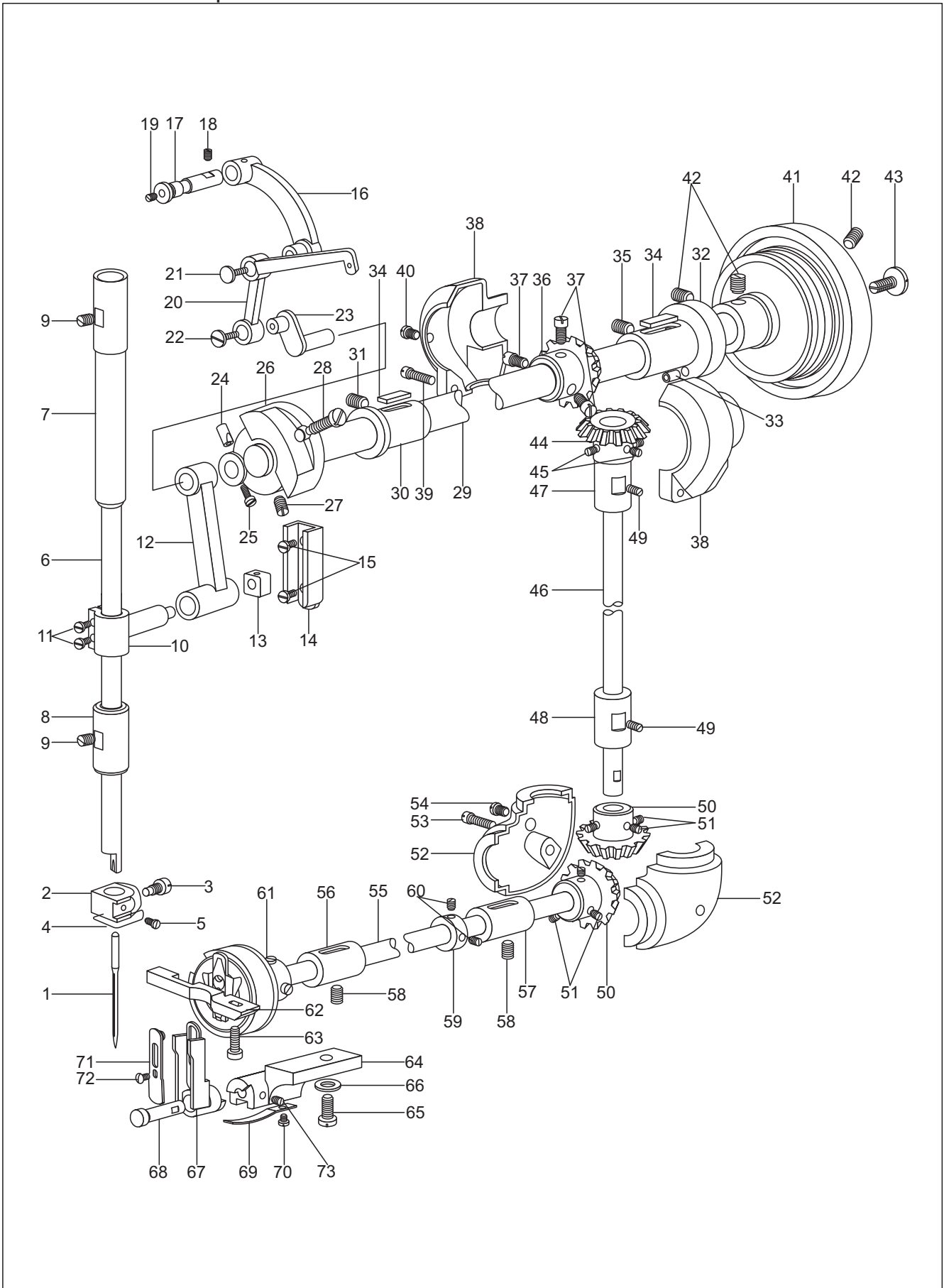
1. Arm and bed



1. Arm and bed

No.	Part number	Parts name	Qt.	Remark
1	6K4-001	Arm	1	TW1-2B
	8KT4-001	Arm	1	TW1-2BL20
2	6K4-002	Bed	1	TW1-2B
	KT4-002	Bed	1	TW1-2BL20
3	6K4-003	Face plate	1	
4	6K4-004	Big screw for face plate	1	
5	6K2-015	Small screw for face plate	2	
6	6K4-005	Upper thread finger of face plate	1	
7	6K1-004	Screw for upper thread finger	1	
8	6K4-006	Lower thread finger of face plate	1	
9	6K4-007	Retainer ring	11	
10	6K1-004	Screw for lower thread finger	1	
11	6K4-008	Thread bracket	1	
12	6K4-009	Thread cover	1	
13	6K4-010	Set screw	1	
14	6K4-011	Screw	2	
15	6K4-012	Thread tension bracket	1	
16	6K4-017	Set screw for tension bracket	1	
17	6K4-013	Thread tension pin	1	
18	6K4-014	Take-up spring	1	
19	6K4-015	Adjusting spring	1	
20	6K4-016	Adjusting plate	1	
21	6K4-017	Thread tension plate (inner)	1	
22	6K4-018	Thread tension plate (exerior)	1	
23	6K4-019	Thread releasing plate	1	
24	6K4-020	Thread releasing pin	1	
25	6K4-021	Thread tension spring	2	
26	6K4-022	Thread tension nut	1	
27	6K4-023	Lower thread finger	1	
28	6K1-018	Set screw for lower thread finger	1	
29	6K4-024	Upper thread finger	1	
30	6K4-011	Set screw for upper lower finger	1	
31	6K4-025	Thread tension pin	1	
32	6K4-026	Thread tension plate	2	
33	6K4-027	Thread tension spring	1	
34	6K4-022	Thread tension nut	1	
35	6K4-028	Upper cover plate	1	
36	6WF2-023	Washer	1	
37	6WF2-022	Screw for upper cover plate	1	
38	6K4-029	Rear cover plate	1	
39	6K4-030	Screw for rear cover plate	1	
40	6K4-031	Rubber plug	2	
41	6K4-032	Needle plate	1	
42	6K4-033	Screw for needle plate	2	
43	6K4-034	Right sliding plate	1	
44	6K4-033	Screw for left sliding plate	2	
45	6K4-035	Left sliding plate	1	
46	6K4-036	Springy Lever	1	
47	6K2-052	Screw for left sliding plate	2	
48	6K4-037	Thread pin	2	
49	6K4-038	Bracket for thread pin	1	
50		Oil cup	2	
51		Oil cup	4	
52	6K4-039	Model plate	1	TW1-2B
	8KT4-002	Model plate	1	TW1-2BL20
53	6K4-040	Brand plate	1	
54		Rivet	4	
55	6K4-041	Deltoid danger label	1	
56	KT-005	Caution Label	1	
57	6K4-043	Thread spring	1	
58	6K4-041	Screw	1	

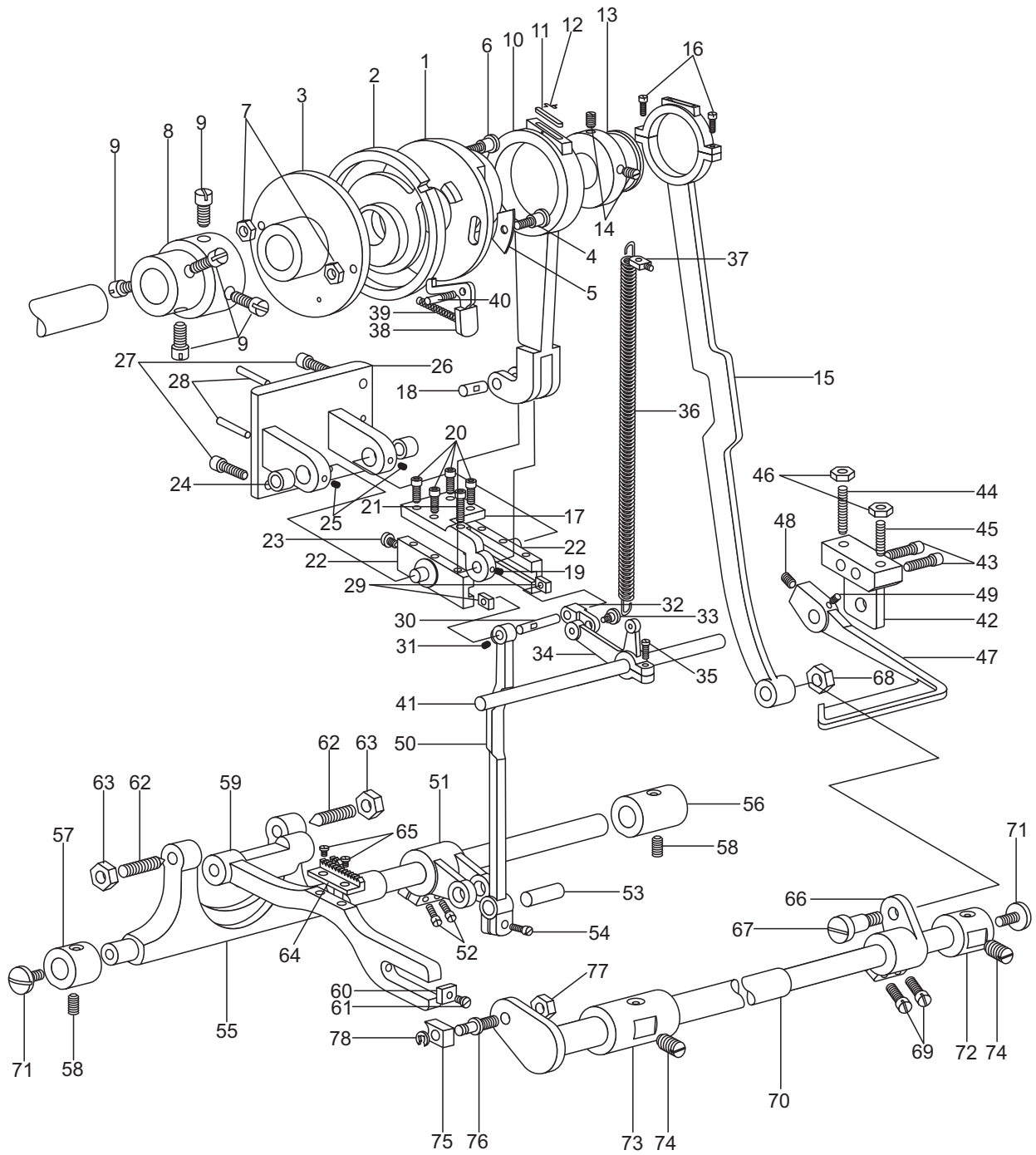
2. Thread take-up mechanism



2. Thread take-up mechanism

No.	Part number	Parts name	Qt.	Remark
1		Needle	1	
2	6K1-001	Needle clamp	1	
3	6K1-002	Screw	1	
4	6K1-003	Thread guide	1	
5	6K1-004	Screw	1	
6	6K1-005	Needle bar	1	
7	6K1-006	Upper bushing for needle bar	1	
8	6K1-007	Lower bushing for needle bar	1	
9	6K1-008	Bushing screw	2	
10	6K1-009	Needle bar connector	1	
11	6K1-010	Set screw	2	
12	6K1-011	Link for needle bar	1	
13	6K1-012	Sliding block	1	
14	6K1-013	Railway for sliding block	1	
15	6K1-014	Screw	2	
16	6K1-015	Take-up link	1	
17	6K1-016	Pin	1	
18	6K1-017	Set screw for pin	1	
19	6K1-018	Screw	1	
20	6K1-019	Take-up lever	1	
21	6K1-020	Connecting screw	1	
22	6K1-021	Screw for take-up lever	1	
23	6K1-022	Take-up crank	1	
24	6K1-023	Position pole for take-up crank	1	
25	6K1-024	Screw	1	
26	6K1-025	Needle bar crank	1	
27	6K1-026	Set screw	1	
28	6K1-027	Position screw	1	
29	6K1-028	Upper shaft	1	TW1-2B
	8KT1-001	Upper shaft	1	TW1-2BL20
30	6K1-029	Front bushing for upper shaft	1	
31	6K1-030	Screw for front bushing	1	
32	6K1-031	Rear bushing for upper shaft	1	
33	6K1-032	Oil pipe	1	
34	6K1-033	Oil felt	2	
35	6K1-034	Screw	1	
36	6K1-035	Upper shaft bevel gear	1	
37	6K1-036	Screw	3	
38	6K1-037	Oil cover	1	
39	6K1-038	Set screw	1	
40	6K1-039	Screw	1	
41	6K1-040	Balance Wheel	1	
42	6K1-041	Screw	3	
43	6K1-042	Screw	1	
44	6K1-043	Vertical shaft bevel gear	1	
45	6K1-044	Screw	3	
46	6K1-045	Vertical shaft	1	
47	6K1-046	Upper bushing for vertical shaft	1	
48	6K1-047	Lower shaft for vertical shaft	1	
49	6K1-048	Set screw for bushing	2	
50	6K1-049	Lower bevel gear	2	
51	6K1-044	Screw	6	
52	6K1-050	Oil cover for lower bevel gear	1	
53	6K1-038	Set screw	1	
54	6K1-039	Screw	1	
55	6K1-051	Lower shaft	1	TW1-2B
	8KT1-001	Lower shaft	1	TW1-2BL20
56	6K1-052	Front bushing for lower shaft	1	
57	6K1-053	Rear bushing for lower shaft	1	
58	61K-041	Screw	2	
59	6K1-054	Collar	1	
60	6K1-008	Screw for collar	2	
61	6K1-055	Hook assembly	1	
62	6K1-056	Position hook	1	
63	6K1-057	Screw	1	
64	6K1-058	Stopping bracket	1	
65	6K1-059	Screw	1	
66		Washer	1	
67	6K1-060	Stopping frame	1	
68	6K1-061	Stopping frame shaft	1	
69	6K1-062	Springy lever	1	
70	6K1-063	Screw	1	
71	6K1-064	Stopping springy lever	1	
72	6K1-004	Screw	1	
73	6K1-065	Screw for stopping frame shaft	1	

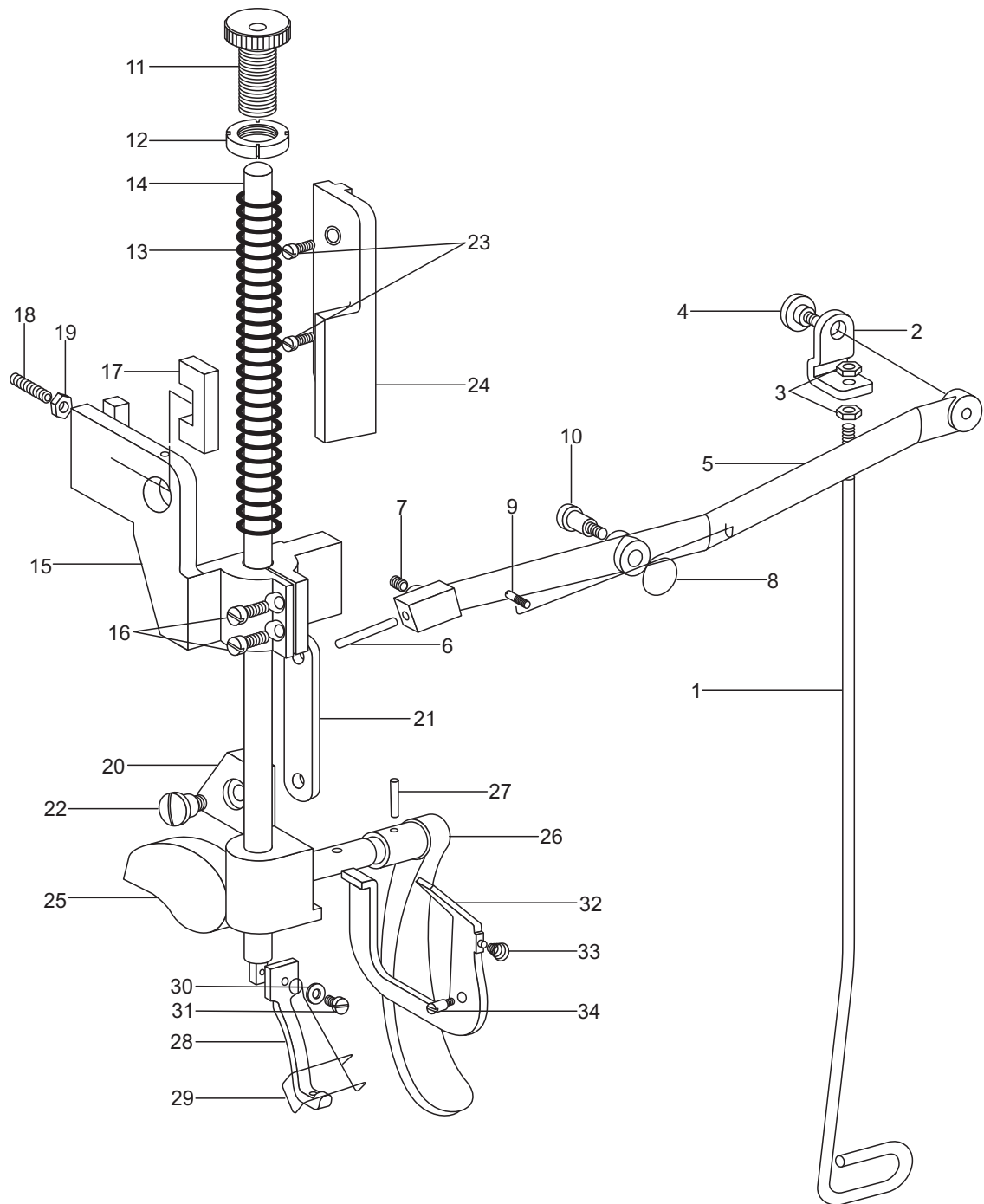
3. Bottom feed mechanism



3. Bottom feed mechanism

No.	Part number	Parts name	Qt.	Remark
1	6K2-001	Feed cam	1	
2	6K2-002	Regulating plate for eccentricity	1	
3	6K2-003	Set plate for eccentricity	1	
4	6K2-004	Screw	1	
5	6K2-005	Washer	1	
6	6K2-006	Screw	1	
7	6K2-007	Nut	2	
8	6K2-008	Bushing for feed cam	1	
9	6K2-009	Screw	5	
10	6K2-010	Big feed link	1	
11	6K2-011	Oil felt	1	
12	6K2-012	Position spring	1	
13	6K2-013	Lifting cam	1	
14	6K2-017	Screw	2	
15	6K2-014	Big lifting link	1	
16	6K2-015	Screw	2	
17	6K2-016	Feed connecting plate	1	
18	6K2-017	Connecting pin	1	
19	6K2-018	Screw for connecting pin	1	
20	6K2-019	Set screw (shot)	4	
21	6K2-020	Set screw (long)	1	
22	6K2-021	Swing plate	2	
23	6K2-022	Stopping screw	2	
24		Needle bearing	2	
25	6K1-018	Set screw for needle bearing	2	
26	6K2-023	Swing plate bracket	1	
27	6K2-024	Screw	3	
28		Taper pin	2	
29	6K2-025	Sliding block	2	
30	6K2-026	Pin shaft	1	
31	6K2-018	Set screw	1	
32	6K2-027	Small link	1	
33	6K2-028	Screw	1	
34	6K2-029	Big link	1	
35	6K2-030	Set screw	1	
36	6K2-031	Spring	1	
37	6K2-032	Position pin	1	
38	6K2-033	Stitch regulating spanner	1	
39	6K2-034	Spring	1	
40	6K2-035	Set screw for spanner	1	
41	6K2-036	Reverse feed shaft	1	
42	6K2-037	Stopping bracket	1	
43	6K2-024	Screw	2	
44	6K2-038	Stopping regulating screw (long)	1	
45	6K2-039	Stopping regulating screw (short)	1	
46	6K2-040	Nut	2	
47	6K2-041	Spanner	1	
48	6K2-042	Screw	1	
49	6K2-043	Screw	1	
50	6K2-044	Feed link	1	
51	6K2-045	Feed cam	1	
52	6K1-048	Screw for feed cam	2	
53	6K2-046	Pin shaft	1	
54	6K2-015	Set screw	1	
55	6K2-047	Feed shaft	1	TW1-2B
	8KT2-001	Feed shaft	1	TW1-2BL20
56	6K2-048	Rear bushing for feed shaft	1	
57	6K2-049	Front bushing for feed shaft	1	
58	6K2-050	Screw	2	
59	6K2-051	Feed dog support	1	
60		Felt	1	
61	6K2-052	Screw	1	
62	20T3-006	Screw	2	
63	6K2-053	Nut	2	
64	6K2-054	Feed dog	1	
65	6K1-014	Screw for feed dog	2	
66	6K2-055	Lifting crank	1	
67	6K2-056	Connecting screw	1	
68	6K2-057	Nut	1	
69	6K2-058	Set screw	2	
70	6K2-015	Lifting shaft	1	TW1-2B
	8KT2-002	Lifting shaft	1	TW1-2BL20
71	6K2-059	Screw	2	
72	6K2-060	Rear bushing for lifting shaft	1	
73	6K2-061	front bushing for lifting shaft	1	
74	6K1-041	Screw	2	
75	6K2-062	Sliding block	1	
76	6K2-063	Screw	1	
77	6K2-064	Nut	1	
78		Split retainer	1	

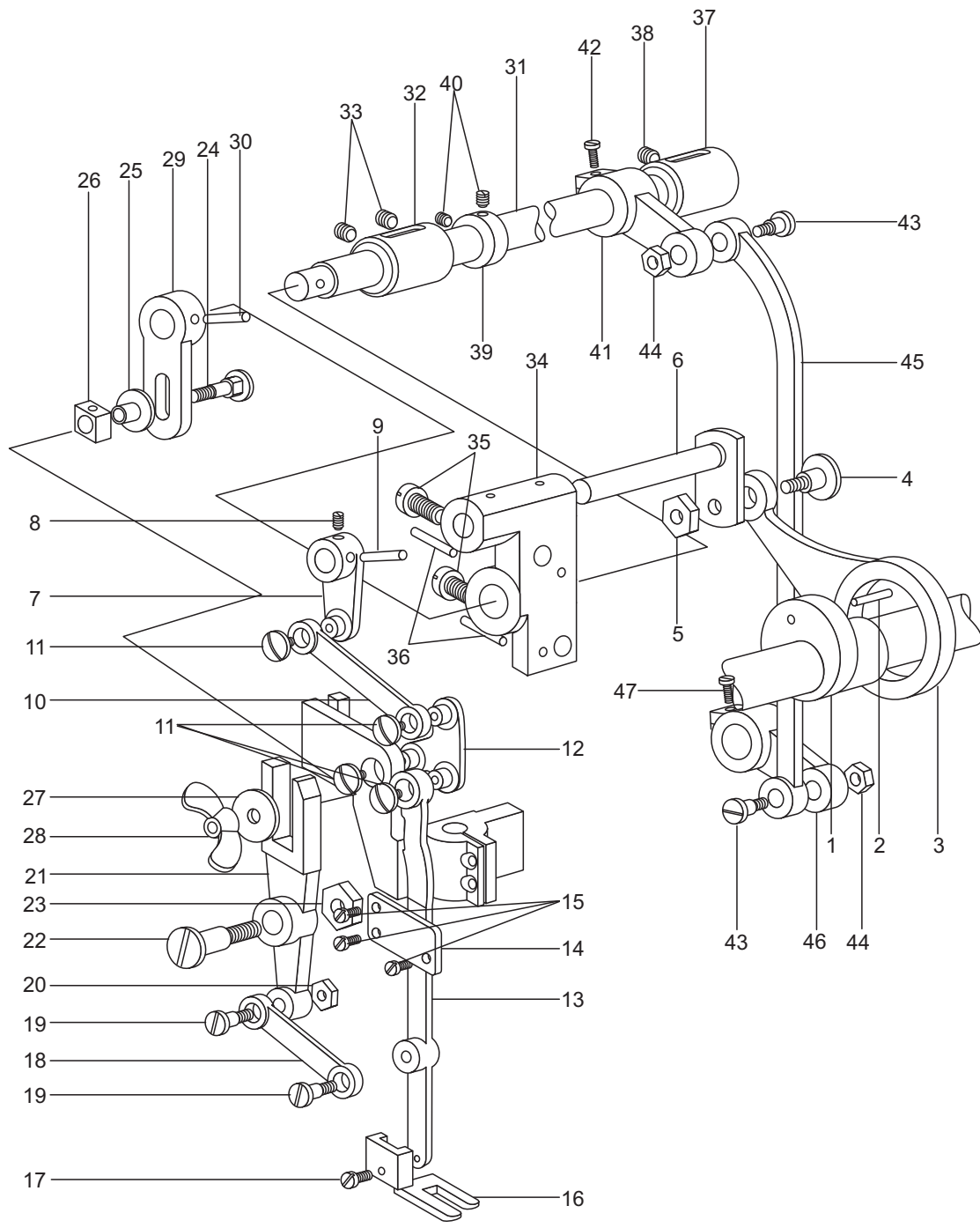
4. Presser bar mechanism



4. Presser bar mechanism

No.	Part number	Parts name	Qt.	Remark
1	6K3-001	Pulling bar	1	
2	6K3-002	Connector for pulling bar	1	
3	6K2-007	Nut	2	
4	6K3-003	Screw	1	
5	6K3-004	Lever	1	TW1-2B
	8KT3-001	Lever	1	TW1-2BL20
6	6K3-005	Pin	1	
7	6K1-065	Screw	1	
8	6K3-006	Spring for lever	1	
9	6K3-007	Position pin	1	
10	6K3-008	Screw for lever	1	
11	6K3-009	Pressure adjusting screw	1	
12	6K3-010	Pressure adjusting nut	1	
13	6K3-011	Pressure adjusting spring	1	
14	6K3-012	Presser bar	1	
15	6K3-013	Guide bracket	1	
16	6K3-014	Screw for guide bracket	2	
17	6K3-015	Stopping block	1	
18	6K3-016	Screw	1	
19	6K3-017	Lock nut	1	
20	6K3-018	Bend guide bracket	1	
21	6K3-019	Pothook	1	
22	6K3-020	Screw	1	
23	6K3-021	Position bracket	1	
24	6K3-022	Screw for position bracket	2	
25	6K3-023	Presser lifting cam	1	
26	6K2-024	Presser lifting spanner	1	
27		Taper pin	1	GB117-86 A3×12
28	6K3-025	Small presser foot	1	
29	6K3-026	Finger guard	1	
30		Washer	1	GB97.1-85-5
31	6K1-057	Screw for small presser foot	1	
32	6K3-027	Tension finger	1	
33	6K3-028	Tension spring	1	
34	6K3-029	Screw	1	

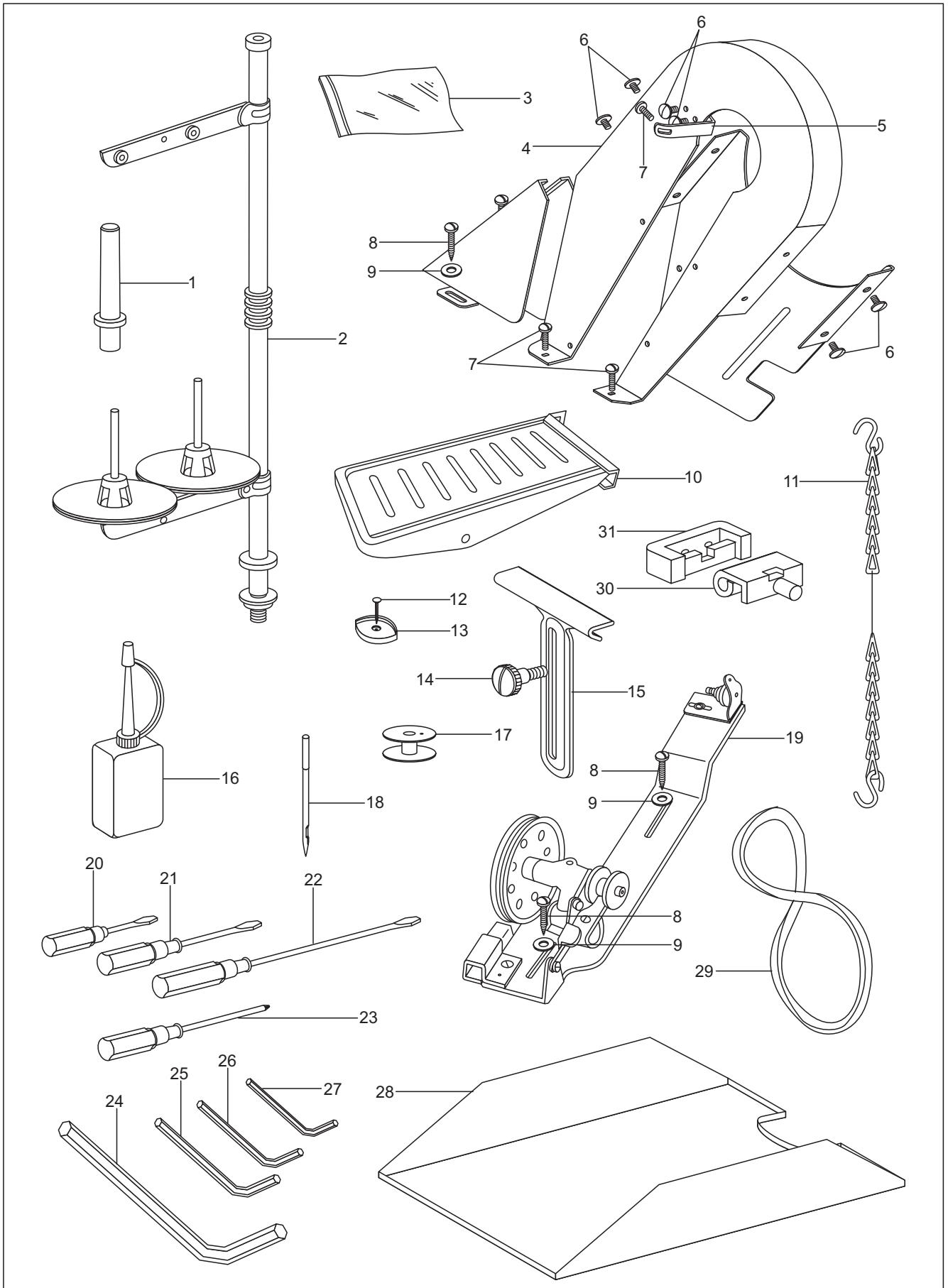
5. Upper feed mechanism



5. Upper feed mechanism

No.	Part number	Parts name	Qt.	Remark
1	6K5-001	Cam for presser foot lifting	1	
2	6K5-002	Pin	1	
3	6K5-003	Big link for presser foot lifting	1	
4	6K5-004	Screw	1	
5	6K5-005	Nut	1	
6	6K5-006	Presser foot lifting shaft	1	
7	6K5-007	Crank	1	
8	6K1-008	Screw	1	
9		Taper pin	1	GB117-86 A4×25
10	6K5-008	Small link	1	
11	6K5-009	Screw	4	
12	6K5-010	Presser foot lifting swing plate	1	
13	6K5-011	Walking foot lever	1	
14	6K5-012	Guide plate	1	
15	6K1-014	Screw	3	
16	6K5-013	Big presser foot	1	
17	6K5-014	Screw for big presser foot	1	
18	6K5-015	Walking foot link	1	
19	6K5-016	Screw	2	
20	6K5-017	Nut	1	
21	6K5-018	Fork link	1	
22	6K5-019	Set screw	1	
23	6K2-057	Nut	1	
24	6K5-020	Connecting screw	1	
25	6K5-021	Bush	1	
26	6K5-022	Sliding block	1	
27	6K5-023	Washer	1	
28	6K5-024	Papilionaceous nut	1	
29	6K5-025	Front crank for vibrating shaft	1	
30		Taper pin	1	GB117-86 A4×27
31	6K5-026	Vibrating shaft	1	TW1-2B
	8KT5-001	Vibrating shaft	1	TW1-2BL20
32	6K5-027	Front bushing for vibrating shaft	1	
33	6K5-028	Screw	2	
34	6K5-029	Feed bracket	1	
35	6K1-059	Set screw	2	
36		Taper pin	2	GB117-86 A4×25
37	6K5-030	Rear bushing for vibrating shaft	1	
38	6K5-028	Screw	1	
39	6K5-031	Collar	1	
40	6K1-018	Screw	2	
41	6K5-032	Rear crank for vibrating shaft	1	
42	6K1-048	Screw	1	
43	6K5-033	Connecting screw	2	
44	6K5-034	Connecting nut	2	
45	6K5-035	Big vibrating link	1	
46	6K5-036	Lower crank for vibrating shaft	1	
47	6K1-048	Set screw	1	

6. Accessories



6. Accessories

No.	Part number	Parts name	Qt.	Remark
1		Machine head stay bar	1	
2	4F-007	Spool stand assembly	1	
3	33TF-010	Parts bag	2	
4	6K6-003	Belt cover assembly	1	
5	6K6-004	Position bracket	1	
6	6K6-005	Screw	6	
7	6K4-003	Set screw	3	
8		Screw	4	GB5282-85 ST4.8×19
9		Washer	4	GB848-85-6
10		Pedal assembly	1	
11		Chain belt with S hook	1	Length 1000mm
12		Set screw for oil pan	8	Length 22mm
13	6K6-006	Cushion	4	
14	6K4-030	Screw	1	
15	6K6-007	Bracket	1	
16	33TF-011	Oil pot	1	
17	6K6-008	Bobbin	6	
18		Needle	3	DD×1 24# 2 7#
19	6K6-009	Bobbin winder assembly	1	
20	33TF-014	Screwdriver (Small)	1	
21	33TF-013	Screwdriver (Medium)	1	
22	33TF-012	Screwdriver (Big)	1	
23	35WF6-002	Cross screwdriver	1	
24		Spanner	1	S=5
25		Spanner	1	S=3
26		Spanner	1	S=2.5
27		Spanner	1	S=2
28	6K6-002	Oil pan	1	TW1-2B
	8KT6-002	Oil pan	1	TW1-2BL20
29		V-belt	1	Length 1270mm
30	22T9-007F1	Hinge	2	
31	22T9-007F2	Hinge cover	2	