

PREMIER SERIES

BY

CONSEW®

P1541S-CC



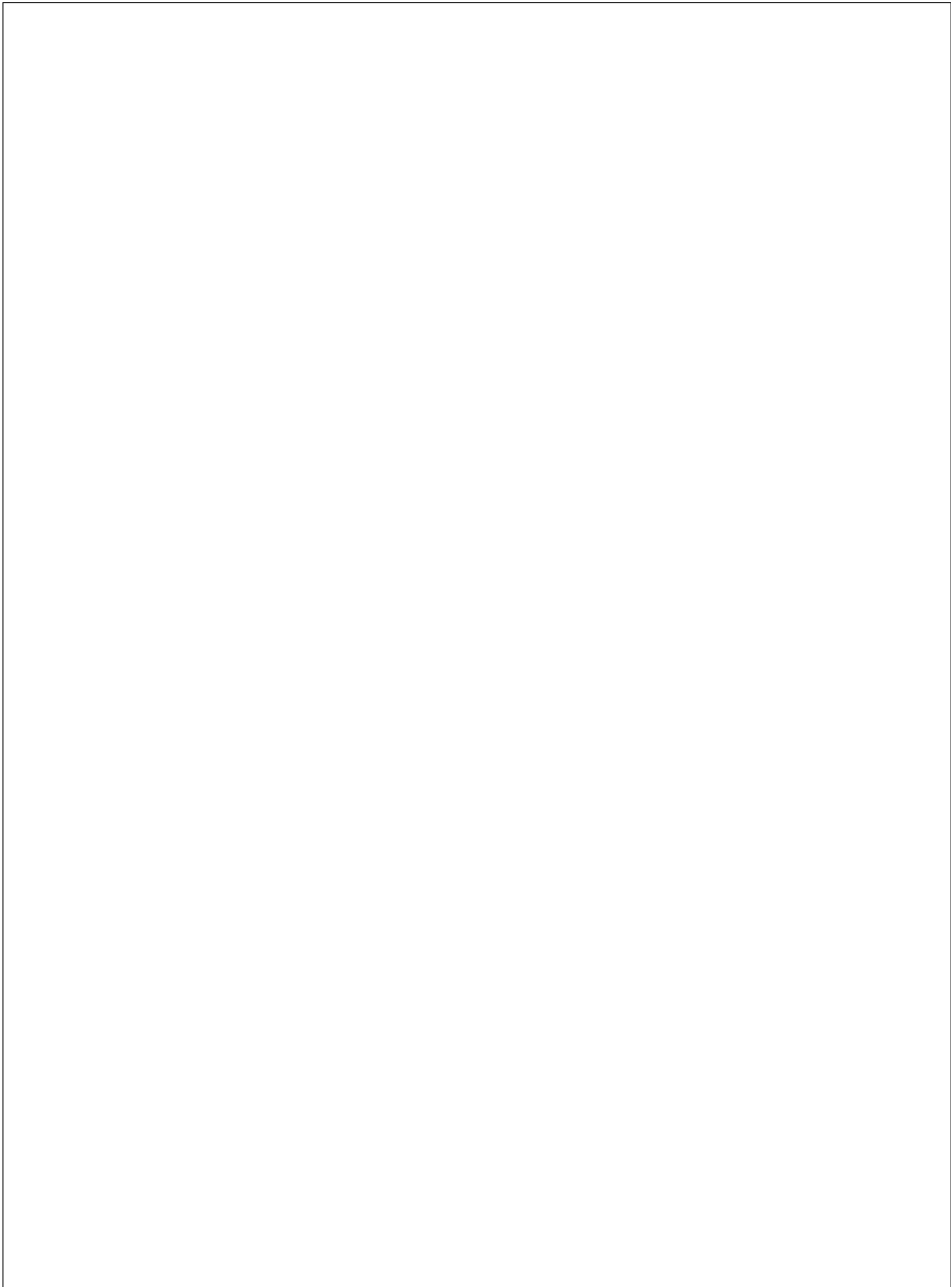
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1. Brief introduction

Machine adopts compound feed and special feeding mechanism, which can ensure smooth feeding, low noise, and beautiful stitch seam. It is constructed with slide link thread take-up, horizontal large rotating hook, and synchronized belt driving system, which ensures high speed, but lower noise.

This machine is suitable for sewing the heavy materials of car seat, sofa, tarpaulins, tents, bag, etc.

3. Installation (Fig.1)

1. Installation of the table connecting hook bracket and rubber cushion.

Fix the connecting hook bracket ① and the rubber cushion ② on the table by screw ③.

2. Installing the oil reservoir.

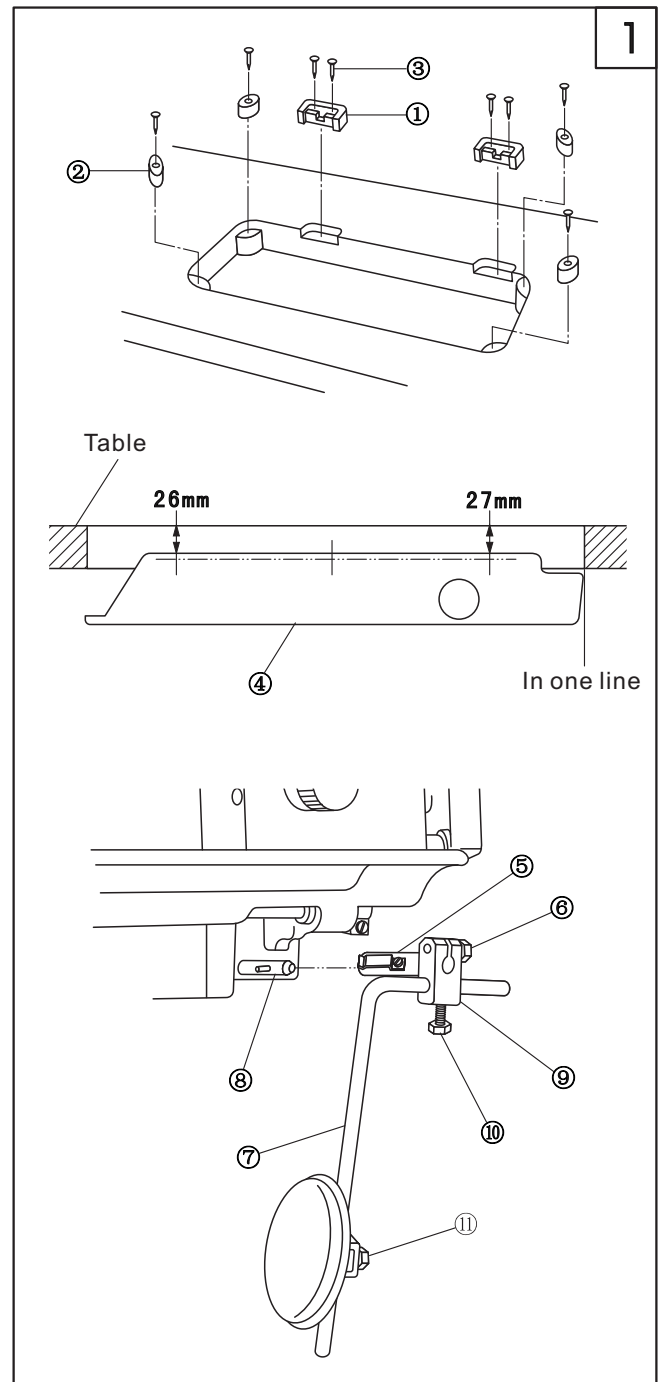
Set the oil reservoir ④ onto the table by six screws as shown in the Fig.1.

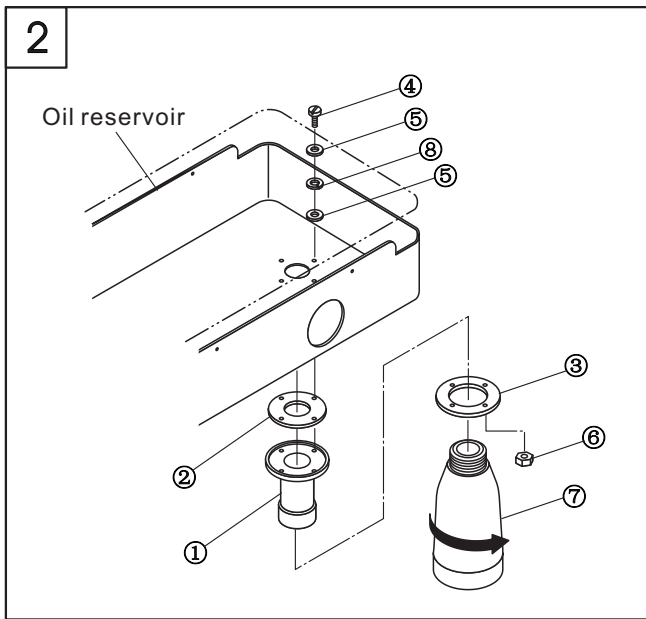
3. Install the knee control connector ⑤, knee control lift crank ⑨ and bent bar ⑦ according to the direction of the knee control lift bar shaft ⑧.

4. Adjust the direction of part ⑥, ⑩, ⑪ by set screw.

2. Main specifications

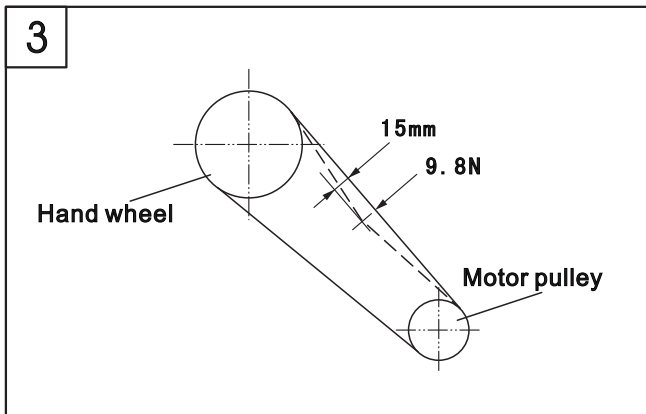
| Application | Medium and heavy duty |
|-----------------------------|--|
| Max. sewing speed | 2000 s.p.m |
| Max. stitch length | 9mm |
| Needle bar stroke | 36mm |
| Needle | DP*17 (Nm125-Nm180) standard Nm160 (23#) |
| Lubrication | Semi-lubrication |
| Hook | Large hook |
| Height of presser foot lift | 9mm by hand, 16mm by knee |
| Motor | 370W clutch motor |





4. Installing the oil pot (Fig. 2)

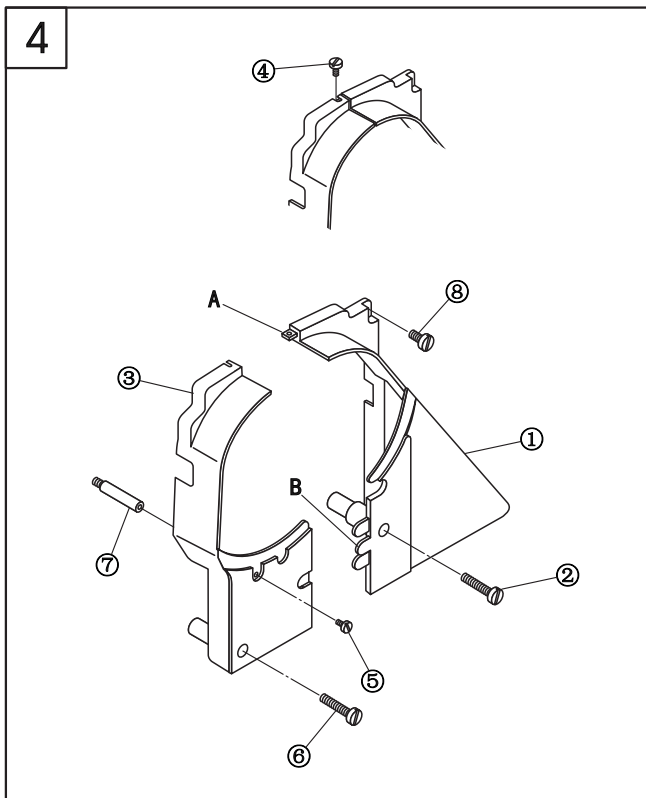
1. Install the bolt ①, oil seal ② and spacer ③ onto the oil reservoir, and then put the cushion ⑤ and spacer ⑧ into the set screw ④, then set it by nut ⑥.
2. Tighten the oil pot ⑦ onto the bolt ①.



5. Adjusting the tension of the belt (Fig.3)

When adjusting the tension of the belt, please adjust the height of the motor, and press down the middle of the belt with the force of 9.8N. There should be a slack of 15mm.

Note: Please turn off the motor before adjustment.



6. Installing the belt cover (Fig.4)

1. Tighten the column ⑦ into the screw hole on the machine head.
2. Install the belt cover (right) ① on the machine head by set screw ② and ⑧.
3. Connect the belt cover (left) ③ to the claw AB of the belt cover (right) ①.
4. Tighten the belt cover (left) ③ by set screws ④, ⑤ and ⑥.

Note: After installing the belt cover, make sure that the belt cover is not touch with the belt and hand wheel.

7. Lubrication (Fig.5)

1.Face plate lubrication

- Loosen the face plate screw;
- Open the face plate ① in the direction of the arrow;
- Lubricate the place as the arrow shows every day;
- Close the face plate;
- Tighten the screw.

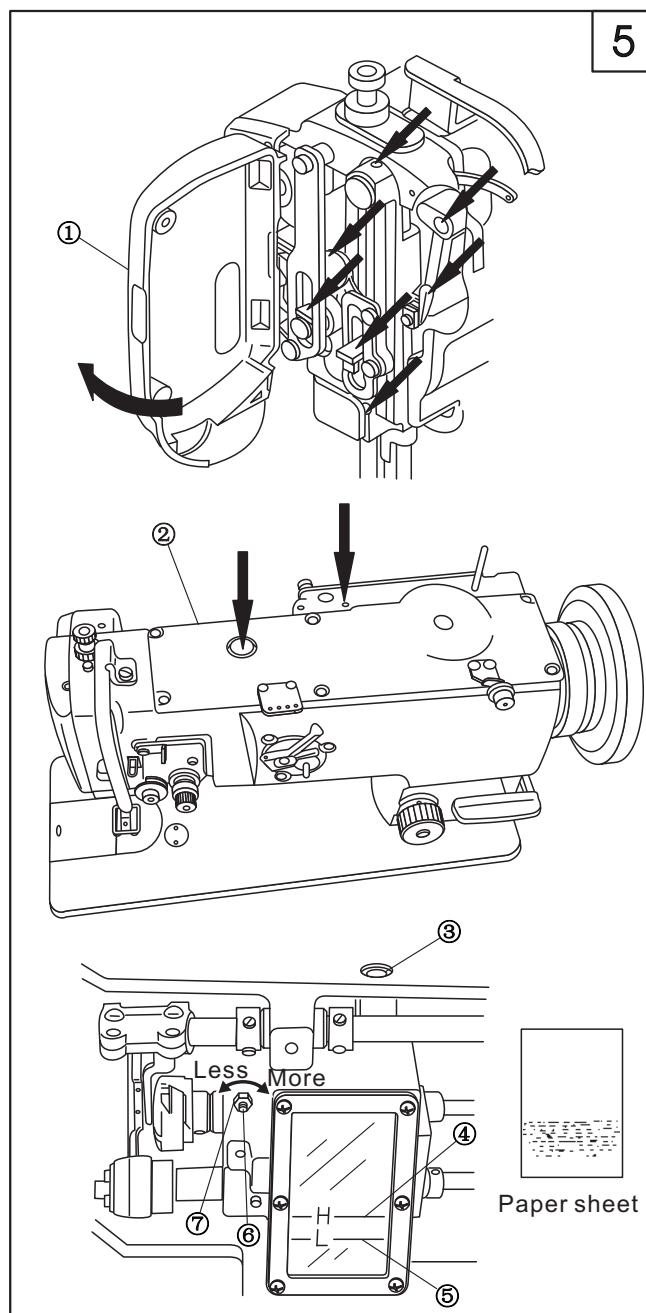
2.Machine body lubrication

- Lubricate the place as the arrows indicate every day;
- When run the machine for the first time or run it again after a long period of non-use, please oil the place as the arrows indicate. Besides, take down the top cover ②, then oil each felt and oil wick.

3.Rotating hook lubrication

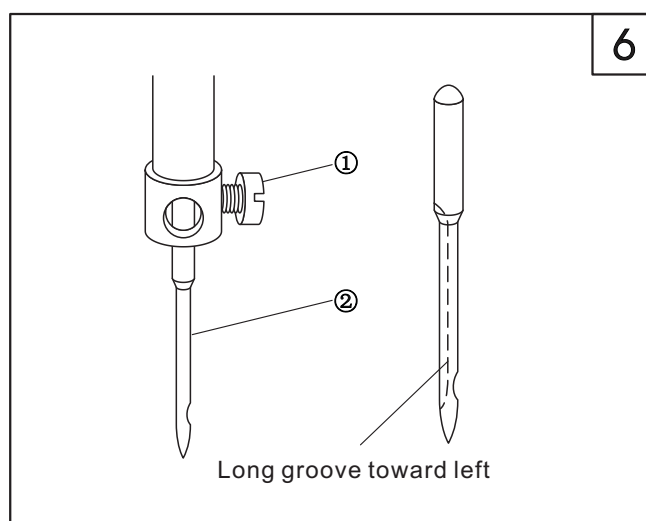
- Add the oil from oil hole ③ until it reaches the red line ④. Check it one time a day. If the oil is under the red line ⑤, it should be refilled.
- When adjusting the oil amount of the rotating hook, loosen the nut ⑦, and then adjust it by adjusting screw ⑥. Turn it rightward, the amount of the oil can be increased; on the contrary, the amount can be reduced.

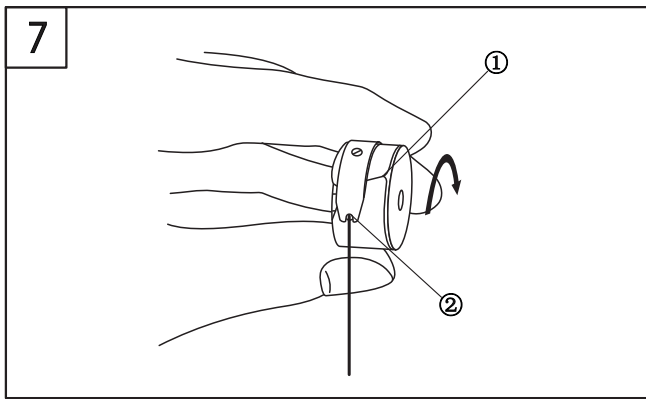
Note: Excess lubrication results in leaking.



8. Installing the needle (Fig.6)

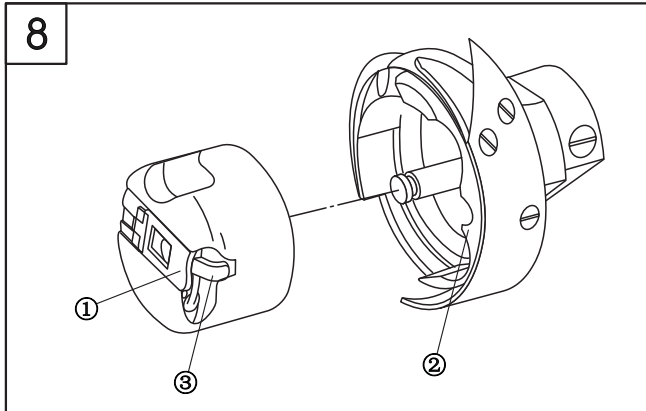
- Turn the balance wheel to raise the needle bar to its highest position;
- Loosen the set screw ② and make the long groove of the needle ① toward leftward;
- Insert the needle into the bottom of the needle bar;
- Tighten the set screw ②.





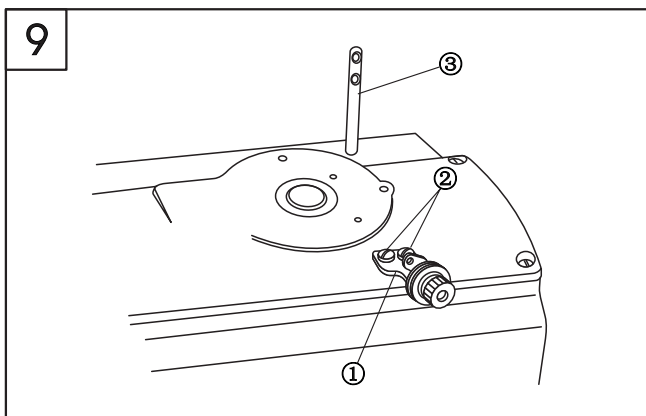
9. Threading the bobbin thread (Fig.7)

1. Insert the bobbin into the hook body, pass the thread through the thread hole ①, then pass down through the thread tension spring ②.
2. Draw the thread downward, then the bobbin will turn in the direction as the figure shows.



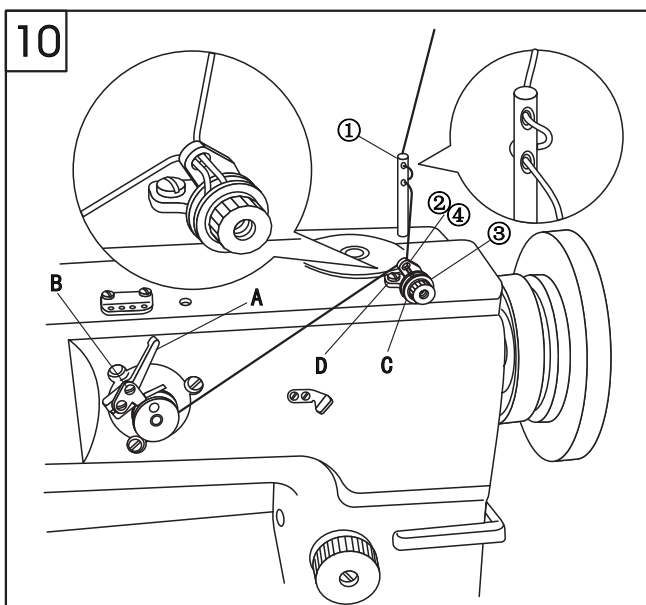
10. Installing the bobbin case (Fig. 8)

1. When taking out the bobbin case, open the gib ① and pull it off.
2. Align the bobbin case with the rotating hook shaft and then insert it. Align the inside of the rotating hook ② and the latch ③, then install the bobbin case by pressing it until "crack" occurs.



11. Installing the winding guider (Fig.9)

1. Set the winding guider ① onto the top cover of the machine head by set screw ②.
2. Insert the bobbin thread guider ③ into the machine head.

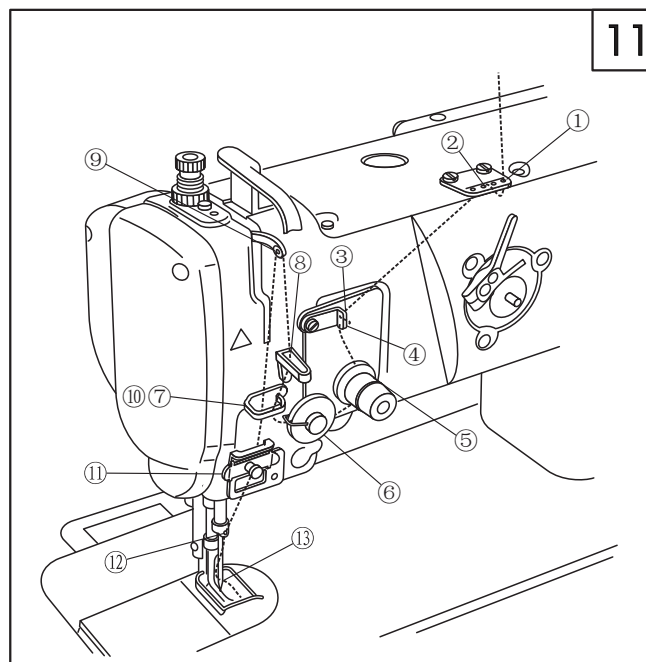


12. Winding the bobbin thread (Fig.10)

1. Thread in numerical order from ① to ④, then wind the bobbin winder.
2. Press down the bar A.
3. Loosen the set screw B and adjust the adjusting plate until the winding amount reaches the 80% of the outside diameter.
4. When the winding is not smooth, move the winding guider C forward and backward, then set it by set screw D.
5. After winding, the winding bar A will separate and stop automatically.

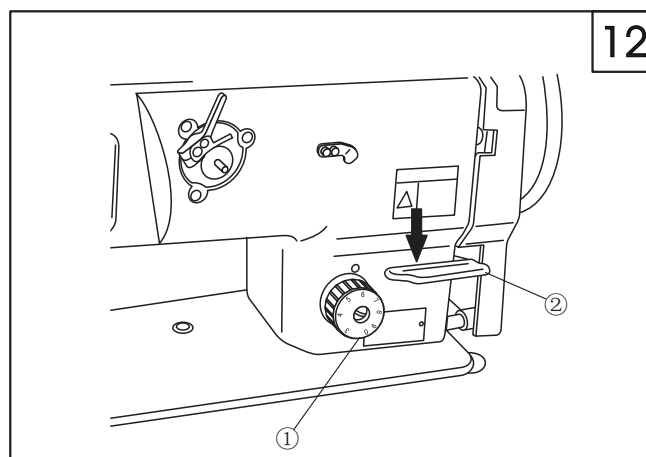
13. Threading (Fig11)

Thread in the order as shown in Fig.



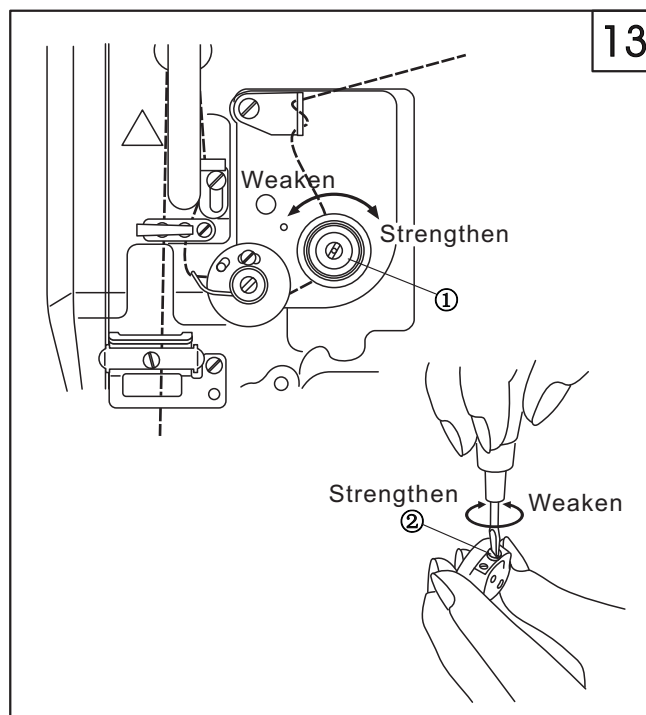
14. Adjusting the stitch length (Fig.12)

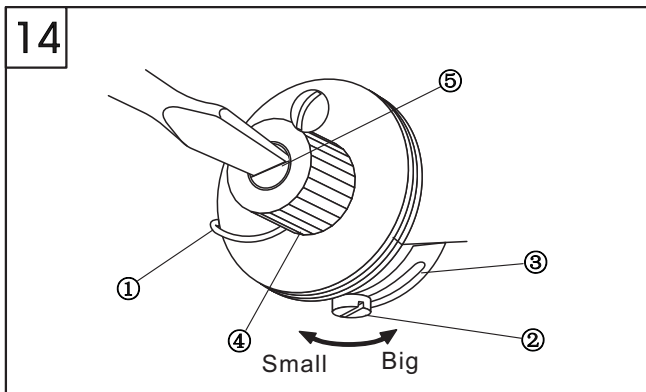
Turn the stitch length dial plate ① leftward and rightward to make the marker align with the required figure. Press down the reverse feed lever ② to start backward sewing, and release it to start normal sewing.



15. Adjusting the thread tension (Fig.13)

1. Adjusting the tension of the needle thread
Turn the nut ① clockwise to increase the tension of the needle thread; on the contrary, to reduce the tension of the needle thread.
2. Adjusting the tension of the bobbin thread.
Turn the screw ② clockwise to increase the tension of the bobbin thread, on the contrary, to reduce the tension of the bobbin thread.

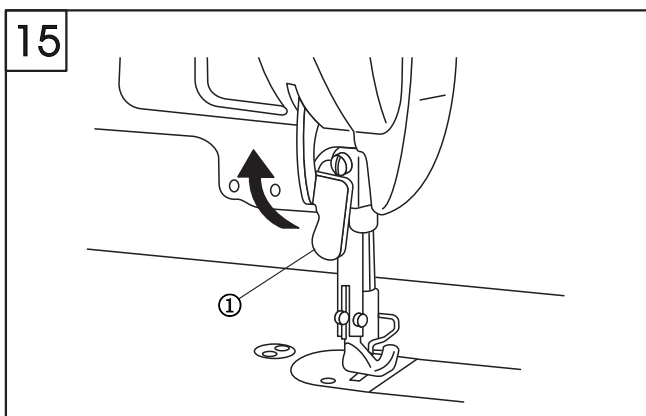




16. Adjusting the thread take-up spring (Fig.14)

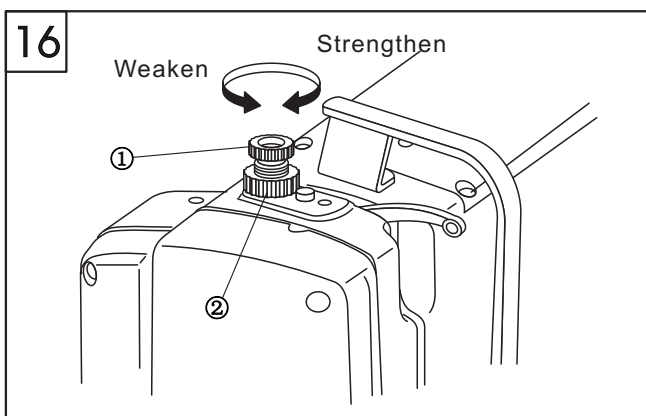
1. Changing the swing range of the thread take-up spring
 - a. Loosen the set screw ②, move the stopper ③ leftward and rightward, then adjust the thread take-up spring ①.
 - b. Move the stopper rightward to increase the swing range of the thread take-up spring; on the contrary, to reduce the swing range of the thread take-up spring.
2. Changing the tension of the thread take-up spring

Loosen the nut ④, turn the spring shaft ⑤ counter-clockwise to increase the tension; turn it clockwise to reduce the tension.



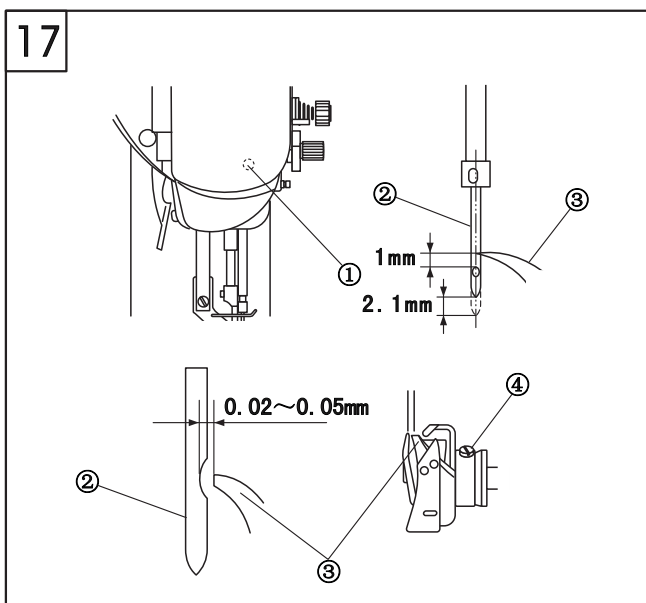
17. Presser foot lifter (Fig.15)

1. Stop the presser foot when it is lifted, lift the lifting bar ① in the direction of the arrow. When the presser foot is lifted by 9mm, then stop it.
2. When lowering the presser foot, put down the lifting bar ① to make the presser foot back to its original place.



18. Adjusting the pressure of the presser foot (Fig.16)

Turn the adjusting screw ① rightward to increase the pressure; turn it leftward to reduce the pressure. After adjustment, tighten the set nut ②.



19. Relationship between needle and rotating hook (Fig.17)

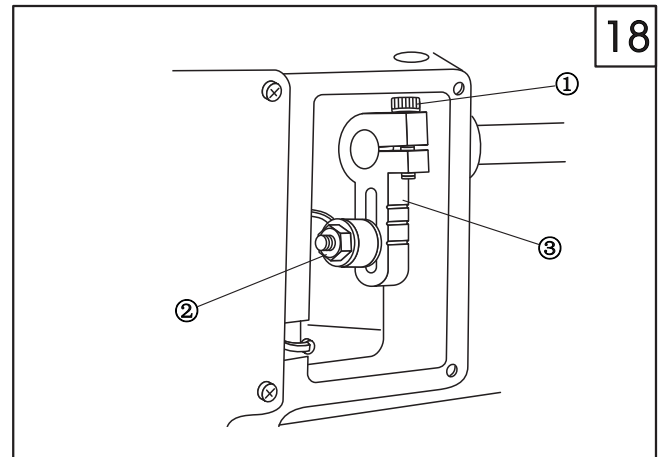
1. Adjust the stitch length dial to 0.
2. Turn the balance wheel to lift the needle bar from its lowest position by 2.1mm. Loosen the screw ①, adjust the distance between up end of the eye of needle ② and rotating hook point ③ to 1mm, then tighten it.
3. Turn the balance wheel to lift the needle bar from its lowest position by 2.1mm. Loosen the two set screws ④, turn the rotating hook, align the rotating hook point ③ with the center of the needle ②, then tighten the two screws ④.
4. Loosen the two set screws ④, move the rotating hook leftward and rightward. Align the rotating hook point ③ and the center of the needle ②, and adjust the clearance between rotating hook point and needle to 0.02-0.05mm, then tighten the screw.

20. Adjusting the alternating amount of presser foot (Fig.18)

When the presser foot is alternating increasingly, adjust it upward in the range of the long hole of the top feed crank ③; when the presser foot is alternating decreasingly, adjust it downward, then tighten the nut ②.

When the lifting amount of the presser and walking foot is different, first align the bottom of the presser foot and walking foot with the surface of the needle plate, then loosen the set screw ①. Turn the balance wheel to the front, the lifting amount of the presser foot is more than that of the walking foot. Turn the balance wheel reversely, the lifting amount of the walking foot is more than that of the presser foot. Finally tighten screw ②

Remove the right side of the window plate, then the top feed crank ③ can be observed.



21. Sewing speed list

| Altenating amount | Stitch less than 6mm | Stitch length between 6mm-9mm |
|-------------------|----------------------|-------------------------------|
| Less than 3mm | 2500s.p.m | 2000s.p.m |
| Between 3~4mm | 2000s.p.m | 2000s.p.m |
| Between 4~6.5mm | 1600s.p.m | 1600s.p.m |

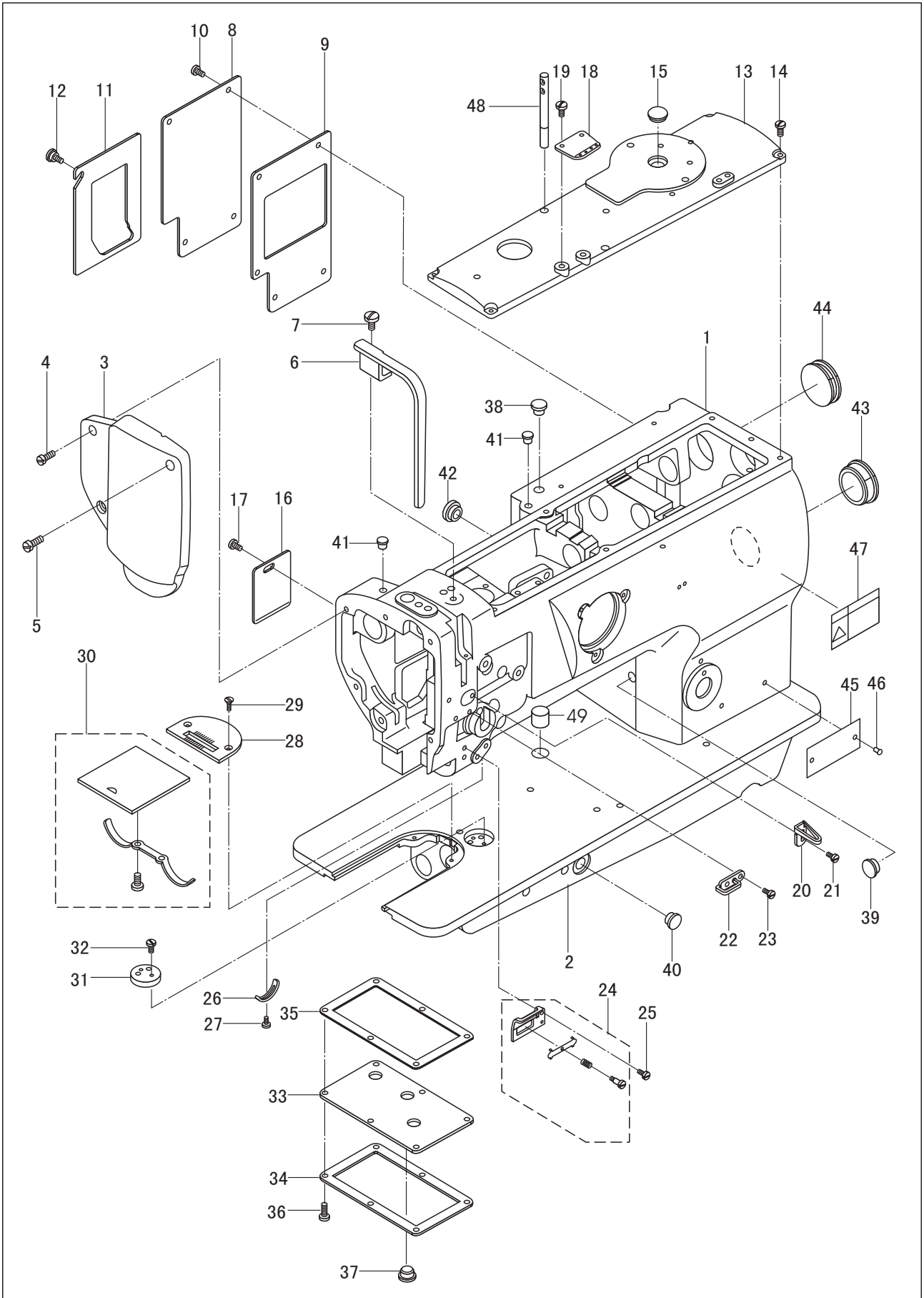
22. Troubleshooting

| Trouble | Possible cause | Remedy |
|---|---|--|
| 1. Thread breaking (2-3mm thread left on the cloth) | <ol style="list-style-type: none"> 1. Damage on the rotating hook set groove of thread way, needle point, rotating hook point and needle plate. 2. Too strong the needle thread tension 3. Collision between needle and rotating hook. 4. Too little the oil of the rotating hook 5. Too weak the needle thread tension. 6. Too strong the tension of the thread take-up spring 7. Over fast or slow the timing between needle and rotating hook | <ol style="list-style-type: none"> 1. Polish the damaged part with sand paper; rasp the middle rotating hook set groove with file. 2. Weaken the needle thread tension. 3. Refer to (19.Relationship between needle and rotating hook.) 4. Adjust the oil amount (Refer to 7. Lubrication) 5. Increase the needle thread tension. 6. Weaken the tension of the thread take-up spring. 7. Refer to (19. Relationship between needle and rotating hook) |
| 2. Puckering | <ol style="list-style-type: none"> 1. Over fast or slow the timing between needle and rotating hook. 2. Too weak the pressure of the presser foot. 3. The clearance between the up end of the needle and the rotating hook is not right. 4. Wrong needle. | <ol style="list-style-type: none"> 1. Refer to (19. Relationship between needle and rotating hook). 2. Tighten the pressr foot adjusting screw. 3. Refer to (19.Relationship between needle and rotating hook.) 4. Replace the needle. |
| 3. Loose stitch | <ol style="list-style-type: none"> 1. Without threading the bobbin thread under the spring of the thread tension of the rotating hook body. 2. Bad work on thread way. 3. No movement of bobbin. 4. Too weak the bobbin thread tension. 5. Too strong the bobbin thread tension. 6. Damage of the needle point. | <ol style="list-style-type: none"> 1. Refer to (9.Threading the bobbin thread) 2. Rast with sand paper or file. 3. Replace the bobbin or rotating hook 4. Increase the bobbin thread tension. 5. Reduce the bobbin thread tension. 6. Replace the needle. |



Parts Manual

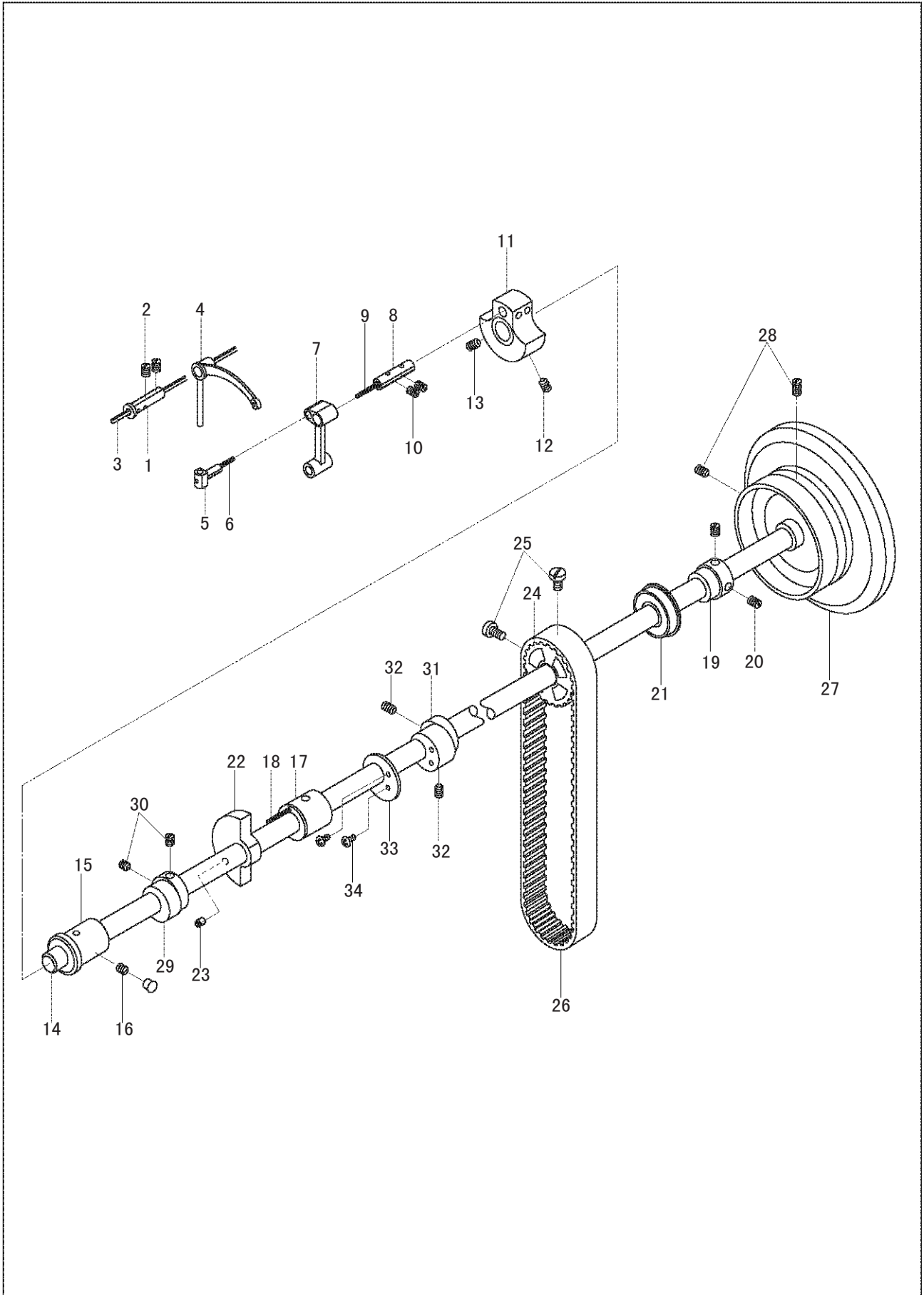
1. Arm and bed



1. Arm and bed

| Line | Part Number | Description | Qt. | Notes |
|------|-------------|-----------------------------|-----|-------------|
| 1 | 400-1001 | Arm | 1 | |
| 2 | 400-1002 | Bed | 1 | |
| 3 | 400-1003 | Face plate assembly | 1 | |
| 4 | 200-1301 | Screw (1) | 2 | SM11/64"X40 |
| 5 | 400-1004 | Screw (2) | 1 | SM15/64"X28 |
| 6 | 400-1005 | Safe guard | 1 | |
| 7 | 400-1006 | Screw | 1 | SM15/64"X28 |
| 8 | 400-1007 | Side cover (1) | 1 | |
| 9 | 400-1008 | Seal spacer | 1 | |
| 10 | 200-1019 | Screw | 5 | SM11/64"X40 |
| 11 | 400-1009 | Side cover (2) | 1 | |
| 12 | 400-1010 | Screw | 1 | SM11/64X40 |
| 13 | 400-1011 | Upper cover | 1 | |
| 14 | 200-1019 | Screw | 6 | SM11/64"X40 |
| 15 | 400-1012 | Rubber plug | 1 | |
| 16 | 400-1013 | Small cover | 1 | |
| 17 | 200-1019 | Screw | 1 | SM11/64"X40 |
| 18 | 400-1014 | Upper thread guide plate | 1 | |
| 19 | 400-1015 | Screw | 2 | SM3/16"X32 |
| 20 | 400-1016 | Upper thread guide | 1 | |
| 21 | 400-1017 | Screw | 1 | SM9/64"X40 |
| 22 | 400-1018 | Middle thread guide | 1 | |
| 23 | 200-1030 | Screw | 2 | SM9/64"X40 |
| 24 | 400-1019 | Lower thread guide assembly | 1 | |
| 25 | 200-1030 | Screw | 1 | SM9/64"X40 |
| 26 | 400-1020 | Position plate | 1 | |
| 27 | 200-1077 | Screw | 1 | SM9/64"X40 |
| 28 | 100-1043 | Needle plate | 1 | |
| 29 | 400-1021 | Screw | 2 | SM11/64"X40 |
| 30 | 400-1022 | Slide plate assembly | 1 | |
| 31 | 400-1023 | Clamp holder | 1 | |
| 32 | 100-1129 | Screw | 2 | SM11/64"X40 |
| 33 | 400-1024 | Oil screen | 1 | |
| 34 | 400-1025 | Presser plate | 1 | |
| 35 | 400-1026 | Seal spacer | 1 | |
| 36 | 400-1027 | Screw | 6 | SM11/64X40 |
| 37 | 400-1028 | Rubber plug | 3 | |
| 38 | 400-1028 | Rubber plug | 1 | |
| 39 | 400-1028 | Rubber plug | 1 | |
| 40 | 400-1028 | Rubber plug | 1 | |
| 41 | 400-1029 | Rubber plug | 2 | |
| 42 | 400-1030 | Rubber plug | 1 | |
| 43 | 400-1031 | Rubber plug | 1 | |
| 44 | 400-1032 | Rubber plug | 1 | |
| 45 | 400-1033 | Model label | 1 | |
| 46 | 400-1034 | Rivet | 2 | GB827 2X5 |
| 47 | 400-1035 | Safety caution label | 1 | |
| 48 | 400-1036 | Upper thread guide bar | 1 | |
| 49 | 400-1037 | plug | / | |

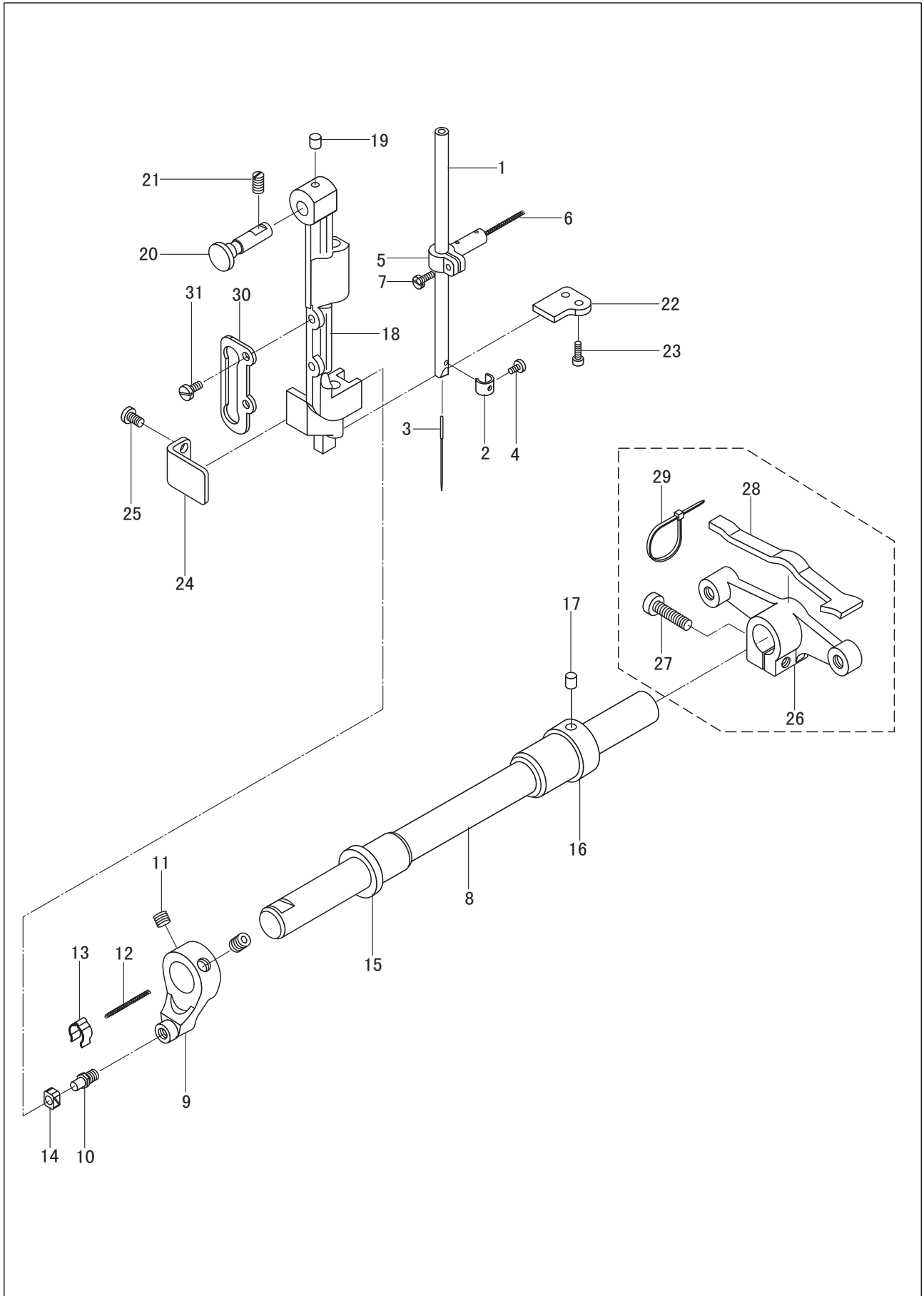
2. Upper shaft and thread take-up mechanism



2. Upper shaft and thread take-up mechanism

| Line | Part Number | Description | Qt. | Notes |
|------|-------------|--------------------------------|-----|-------------|
| 1 | 400-1038 | Thread take-up lever pin shaft | 1 | 103530 |
| 2 | 100-1049 | Screw | 2 | SM15/64"X28 |
| 3 | 400-1039 | Oil wick | 1 | φ2.5X155 |
| 4 | 400-1040 | Thread take-up lever | 1 | |
| 5 | 400-1041 | Slide block | 1 | |
| 6 | 400-1042 | Oil wick | 1 | |
| 7 | 400-1043 | Needle bar link | 1 | |
| 8 | 400-1044 | Needle bar crank pin | 1 | |
| 9 | 400-1045 | Oil wick | 1 | |
| 10 | 100-1049 | Screw | 2 | SM15/64"X28 |
| 11 | 400-1046 | Needle bar crank | 1 | |
| 12 | 100-1071 | Screw | 1 | SM9/32"X28 |
| 13 | 400-1047 | Screw | 1 | SM9/32"X28 |
| 14 | 400-1048 | Upper shaft | 1 | |
| 15 | 400-1049 | Upper shaft front bushing | 1 | |
| 16 | 100-1049 | Screw | 1 | SM15/64"X28 |
| 17 | 400-1050 | Upper shaft middle bushing | 1 | |
| 18 | 400-1051 | Oil wick | 1 | φ2x120 |
| 19 | 400-1052 | Bearing bushing | 1 | |
| 20 | 400-1053 | Screw | 2 | |
| 21 | 400-1054 | Upper bearing | 1 | 6005-2ZNR |
| 22 | 400-1055 | Balance shock | 1 | |
| 23 | 400-1056 | Screw | 2 | SM15/64"X28 |
| 24 | 400-1057 | Synchronized pulley assembly | 1 | |
| 25 | 400-1058 | Screw | 2 | SM1/4"X40 |
| 26 | 400-1059 | Synchronized belt | 1 | 540-8YU-15 |
| 27 | 400-1060 | Hand wheel | 1 | |
| 28 | 100-1049 | Screw | 2 | SM15/64"X28 |
| 29 | 400-1061 | Lift eccentric cam | 1 | |
| 30 | 200-1109 | Screw | 2 | SM1/4"X40 |
| 31 | 400-1062 | Feed eccentric cam | 1 | |
| 32 | 200-1109 | Screw | 2 | SM1/4"X40 |
| 33 | 400-1063 | Retaining block | 1 | |
| 34 | 400-1064 | Screw | 2 | SM11/64"X40 |
| | | | | |
| | | | | |

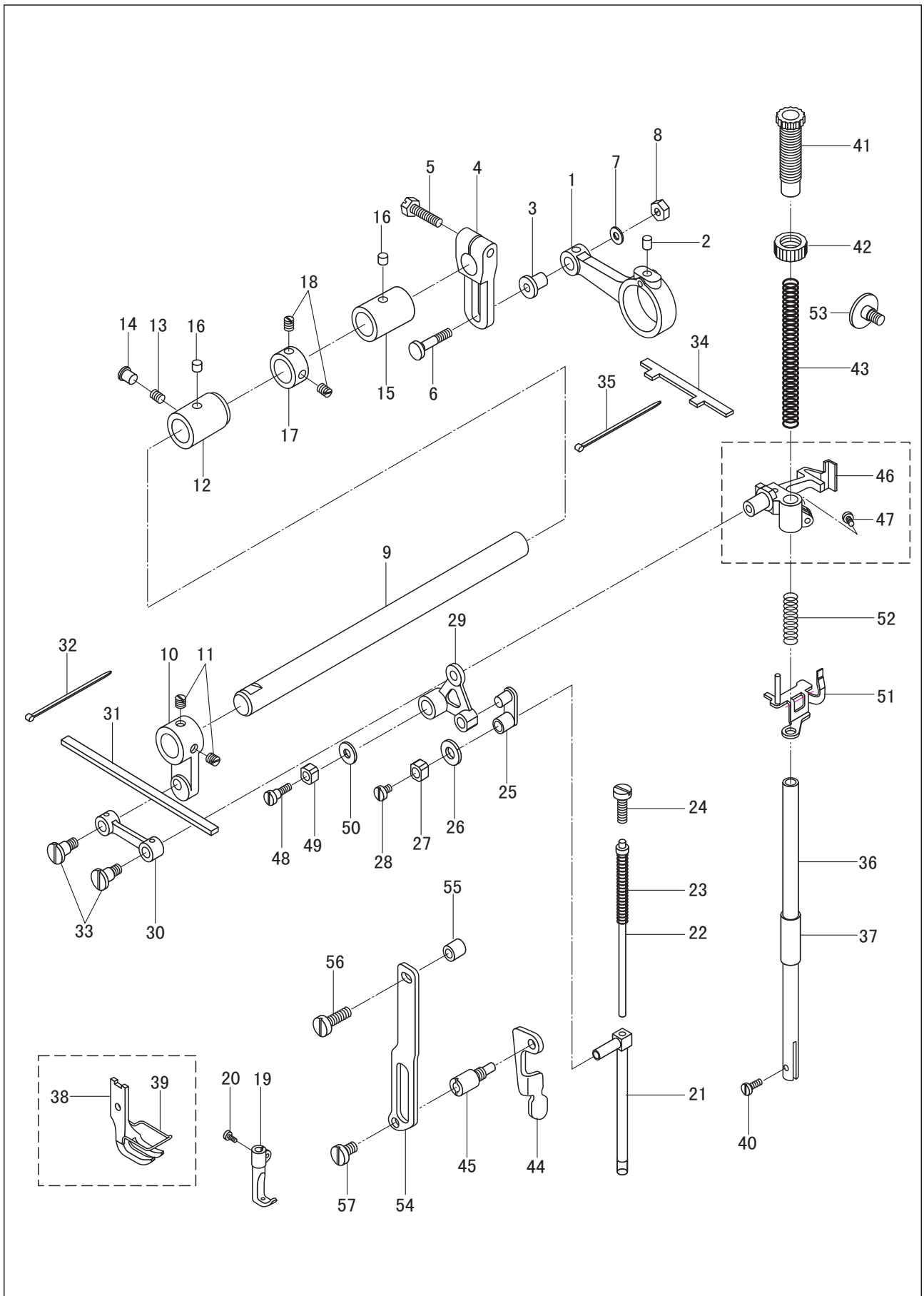
3. Needle bar vibrating parts



3. Needle bar vibrating parts

| Line | Part Number | Description | Qt. | Notes |
|------|-------------|-------------------------------|-----|-------------|
| 1 | 400-1065 | Needle bar | 1 | |
| 2 | 400-1066 | Needle bar thread guide | 1 | |
| 3 | 400-1067 | Needle | 1 | 135X17#23 |
| 4 | 200-1166 | Screw | 1 | SM1X8"X44 |
| 5 | 400-1068 | Needle bar adapter | 1 | |
| 6 | 400-1069 | Oil wick | 1 | |
| 7 | 400-1070 | Screw | 1 | SM9X64"X40 |
| 8 | 400-1071 | Vibrating shaft | 1 | |
| 9 | 400-1072 | Crank | 1 | |
| 10 | 400-1073 | Crank pin | 1 | |
| 11 | 400-1074 | Screw | 2 | GB/T80 M8X8 |
| 12 | 400-1075 | Oil felt | 1 | φ1.5 20 |
| 13 | 400-1076 | Spring | 1 | |
| 14 | 400-1077 | Slide block | 1 | |
| 15 | 400-1078 | Vibrating shaft front bushing | 1 | |
| 16 | 400-1079 | Vibrating shaft rear bushing | 1 | |
| 17 | 400-1080 | Oil felt | 1 | |
| 18 | 400-1081 | Needle bar vibrating bracket | 1 | |
| 19 | 400-1080 | Oil felt | 1 | |
| 20 | 400-1082 | Hinge shaft | 1 | |
| 21 | 200-1123 | Screw | 1 | SM15/64"X28 |
| 22 | 400-1083 | Position plate (1) | 1 | |
| 23 | 400-1084 | Screw | 2 | SM9/64"X40 |
| 24 | 400-1085 | Position plate (2) | 1 | |
| 25 | 200-1019 | Screw | 2 | SM11/64"X40 |
| 26 | 400-1086 | Driven crank | 1 | |
| 27 | 400-1087 | Screw | 1 | SM15/64"X28 |
| 28 | 400-1088 | Oil felt | 1 | |
| 29 | 400-1089 | Wire | 2 | |
| 30 | 400-1090 | Guide rail | 1 | |
| 31 | 200-1019 | Screw | 2 | SM11/64"X40 |
| | | | | |
| | | | | |
| | | | | |

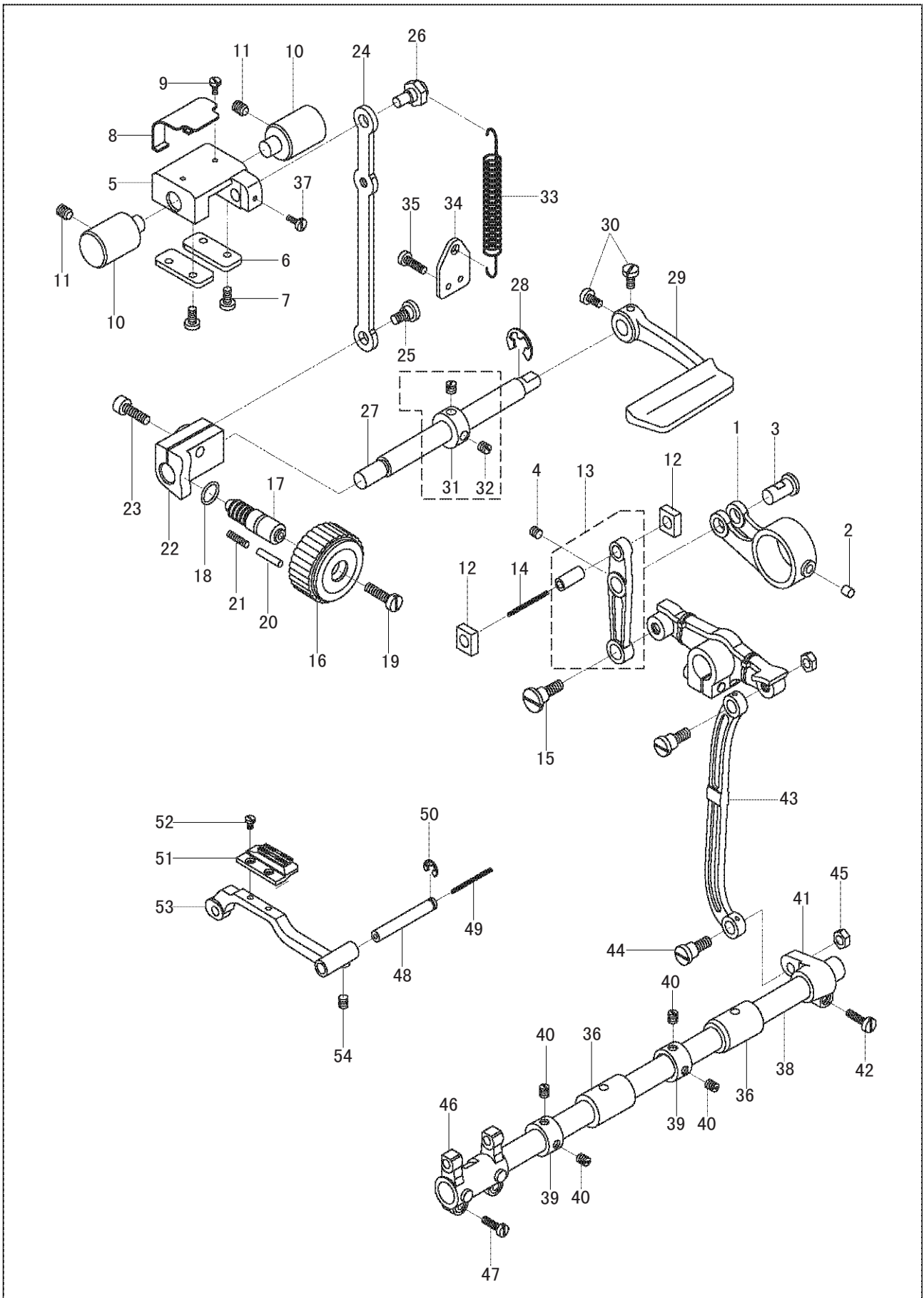
4. Upper feed parts



4. Upper feed parts

| Line | Part Number | Description | Qt. | Notes |
|------|-------------|---------------------------------|-----|-----------------|
| 1 | 400-1091 | Connecting bar | 1 | |
| 2 | 400-1080 | Oil felt | 1 | |
| 3 | 400-1092 | Connecting pin | 1 | |
| 4 | 400-1093 | Adjusting crank | 1 | |
| 5 | 400-1094 | Screw | 1 | GB5781-86 M6X22 |
| 6 | 400-1095 | Screw | 1 | SM11/64"X40 |
| 7 | 400-1096 | Washer | 1 | |
| 8 | 400-1097 | Nut | 1 | SM11/64"X40 |
| 9 | 400-1098 | Upper feed shaft | 1 | |
| 10 | 400-1099 | Upper feed crank | 1 | |
| 11 | 400-1100 | Screw | 2 | SM1/4"X40 |
| 12 | 400-1101 | Upper feed shaft bushing (left) | 1 | |
| 13 | 100-1049 | Screw | 1 | SM15/64"X28 |
| 14 | 400-1029 | Rubber plug | 1 | |
| 15 | 400-1102 | Upper feed bushing (right) | 1 | |
| 16 | 400-1103 | Oil wick | 2 | φ6x10 |
| 17 | 400-1104 | Collar | 1 | |
| 18 | 400-1105 | Screw | 2 | SM1/4"x40 |
| 19 | 400-1106 | Walking foot | 1 | |
| 20 | 400-1107 | Screw | 1 | SM11/64"X40 |
| 21 | 400-1108 | Walking foot lifting bar | 1 | |
| 22 | 400-1109 | Spring guide assembly | 1 | |
| 23 | 400-1110 | Presser spring | 1 | |
| 24 | 400-1111 | Screw | 1 | SM15/64"X28 |
| 25 | 400-1112 | Link | 1 | |
| 26 | 400-1113 | Oil felt | 1 | |
| 27 | 400-1114 | Slide block | 1 | |
| 28 | 100-1284 | Screw | 1 | SM11/64"X40 |
| 29 | 400-1115 | Foot lifting plate | 1 | |
| 30 | 400-1116 | Foot lifting link | 1 | |
| 31 | 400-1117 | Oil felt | 1 | |
| 32 | 400-1118 | Binding cord | 2 | |
| 33 | 400-1119 | Screw | 2 | |
| 34 | 400-1120 | Oil felt | 1 | |
| 35 | 400-1118 | Binding cord | 1 | |
| 36 | 400-1121 | Presser bar | 1 | |
| 37 | 400-1122 | Presser bar bushing | 1 | |
| 38 | 400-1123 | Presser foot | 1 | |
| 39 | 400-1124 | Finger guard | 1 | |
| 40 | 400-1070 | Screw | 1 | SM9/64"X40 |
| 41 | 400-1125 | Screw | 1 | SM1/2"X28 |
| 42 | 100-1110 | Nut | 1 | SM1/2"X28 |
| 43 | 400-1126 | Spring | 1 | |
| 44 | 400-1127 | Presser foot lifting bar | 1 | |
| 45 | 400-1128 | Lifting bar shift | 1 | |
| 46 | 400-1129 | Releasing bracket | 1 | |
| 47 | 200-1019 | Screw | 1 | SM11/64"X40 |
| 48 | 400-1130 | Screw | 1 | |
| 49 | 400-1131 | Slide block | 1 | |
| 50 | 400-1132 | Washer | 1 | |
| 51 | 400-1133 | Releasing plate | 1 | |
| 52 | 400-1134 | Spring | 1 | |
| 53 | 400-1135 | Screw | 1 | SM1/4"X28 |
| 54 | 400-1136 | Presser bar guide plate | 1 | |
| 55 | 400-1137 | Washer | 1 | |
| 56 | 400-1138 | Screw (upper) | 1 | SM15/64"X28 |
| 57 | 400-1139 | Screw (lower) | 1 | SM15/64"X28 |

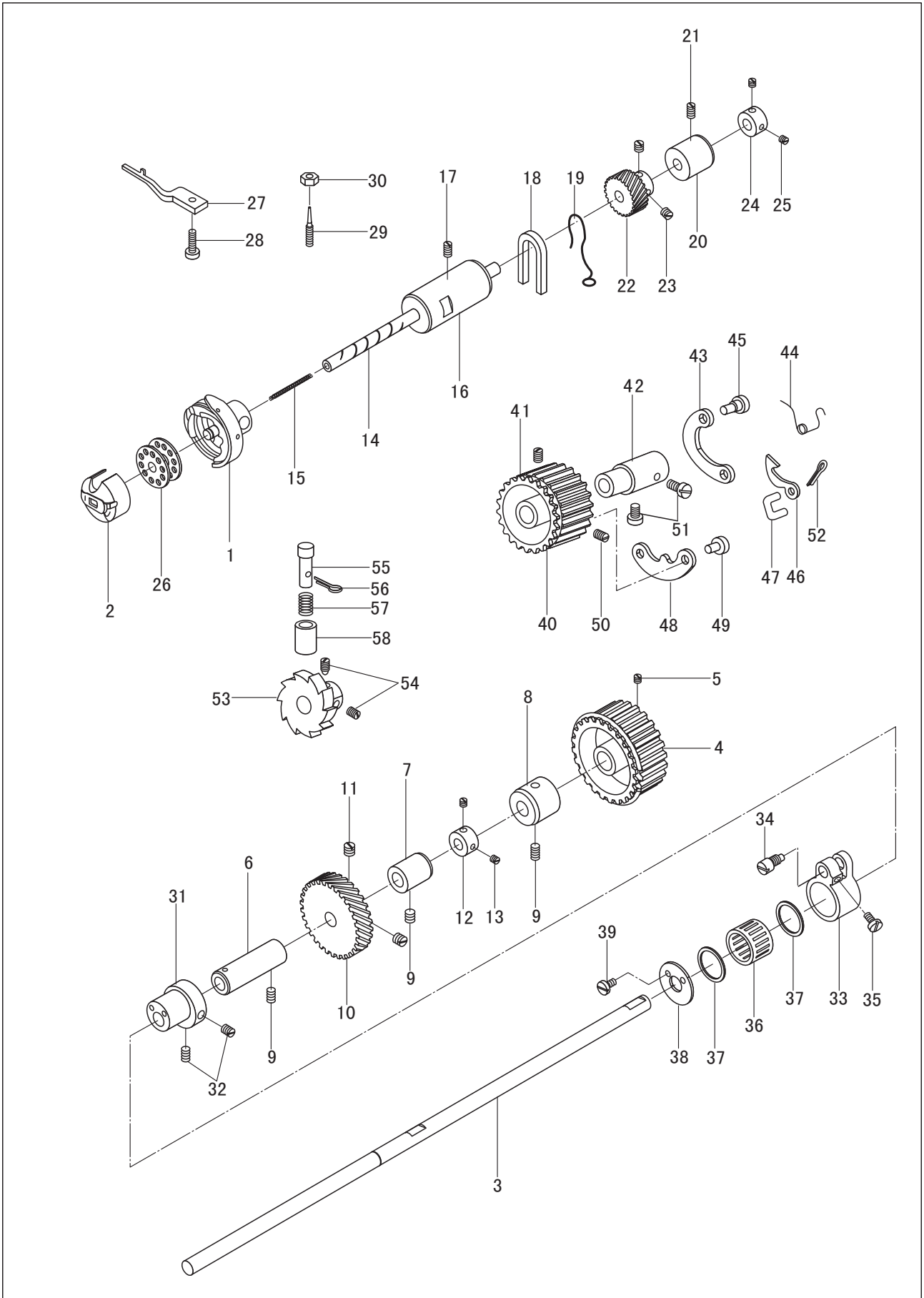
5. Feed parts



5. Feed parts

| Line | Part Number | Description | Qt. | Notes |
|------|-------------|------------------------------|-----|-------------|
| 1 | 400-1140 | Feed link | 1 | |
| 2 | 400-1141 | Oil felt | 1 | |
| 3 | 400-1142 | Link pin | 1 | |
| 4 | 100-1089 | Screw | 1 | |
| 5 | 400-1143 | Reverse feed bracket | 1 | |
| 6 | 400-1144 | Retaining plate | 2 | |
| 7 | 200-1019 | Screw | 4 | SM11/64"X40 |
| 8 | 400-1145 | Presser plate | 1 | |
| 9 | 400-1146 | Screw | 2 | SM11/64"X40 |
| 10 | 400-1147 | Reverse feed bracket shaft | 2 | |
| 11 | 100-1049 | Screw | 2 | SM15/64"X40 |
| 12 | 400-1148 | Slide block | 2 | |
| 13 | 400-1149 | Feed vibrating bar assembly | 1 | |
| 14 | 400-1150 | Oil wick | 1 | φ1.5 35 |
| 15 | 400-1151 | Screw | 1 | |
| 16 | 400-1152 | stitch length adjusting dial | 1 | |
| 17 | 400-1153 | Bolt | 1 | |
| 18 | 400-1154 | Seal ring | 1 | |
| 19 | 400-1155 | Screw | 1 | SM3/16"X28 |
| 20 | 400-1156 | Stop pin | 1 | |
| 21 | 400-1157 | Spring | 1 | |
| 22 | 400-1158 | Stitch length holder | 1 | |
| 23 | 400-1159 | Screw | 1 | |
| 24 | 400-1160 | Link | 1 | |
| 25 | 400-1161 | Screw | 1 | |
| 26 | 400-1162 | Eccentric pin | 1 | |
| 27 | 400-1163 | Reverse feed lever shaft | 1 | |
| 28 | 400-1164 | Retainer | 1 | GB896-86-9 |
| 29 | 400-1165 | Reverse feed lever | 1 | |
| 30 | 400-1166 | Screw | 2 | SM3/16"X28 |
| 31 | 400-1167 | Collar | 1 | |
| 32 | 400-1105 | Screw | 2 | SM1/4"X40 |
| 33 | 400-1168 | Spring | 1 | |
| 34 | 400-1169 | Spring hook | 1 | |
| 35 | 200-1405 | Screw | 2 | SM11/64"X40 |
| 36 | 400-1102 | Feed shaft bushing | 2 | |
| 37 | 400-1170 | Screw | 2 | |
| 38 | 400-1171 | Feed shaft | 1 | |
| 39 | 400-1104 | Collar | 2 | |
| 40 | 400-1105 | Screw | 4 | SM1/4"X40 |
| 41 | 400-1172 | Crank | 1 | |
| 42 | 400-1173 | Screw | 1 | SM3/16"X28 |
| 43 | 400-1174 | Link | 1 | |
| 44 | 400-1175 | Screw | 2 | |
| 45 | 400-1176 | Nut | 2 | SM9/32"X28 |
| 46 | 400-1177 | Feed crank | 1 | |
| 47 | 200-1405 | Screw | 2 | SM11/64"X40 |
| 48 | 400-1178 | Connecting pin | 1 | |
| 49 | 400-1179 | Oil wick | 1 | φ3 50 |
| 50 | 400-1180 | Retainer | 1 | GB896 5 |
| 51 | 400-1181 | Feed dog | 1 | |
| 52 | 400-1182 | Screw | 2 | SM1/8"X44 |
| 53 | 400-1183 | Feed dog support | 1 | |
| 54 | 400-1184 | Screw | 1 | |

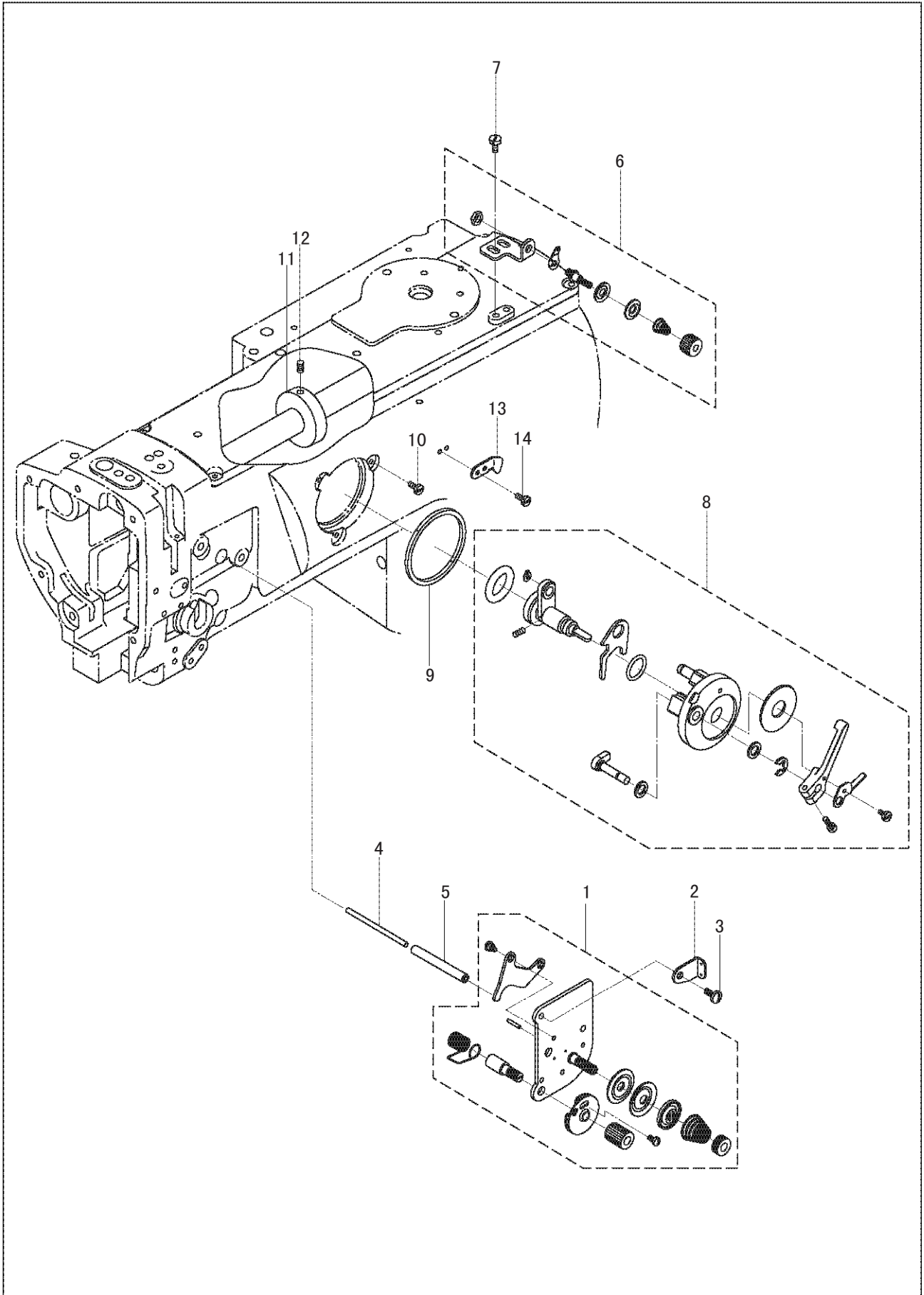
6. Lower shaft mechanism



6. Lower shaft mechanism

| Line | Part Number | Description | Qt. | Notes |
|------|-------------|-------------------------------------|-----|---------------|
| 1 | 400-1185 | Hook CPL | 1 | |
| 2 | 100-1250 | Bobbin case CPL | 1 | |
| 3 | 400-1186 | Lower shaft | 1 | |
| 4 | 400-1187 | Lower shaft synchronized pulley CPL | 1 | |
| 5 | 400-1058 | Screw | 2 | SM1/4"X40 |
| 6 | 400-1188 | Lower shaft bushing (L) | 1 | |
| 7 | 400-1189 | Lower shaft bushing (M) | 1 | |
| 8 | 400-1190 | Lower shaft bushing (R) | 1 | |
| 9 | 400-1191 | Screw | 3 | SM15/64"X28 |
| 10 | 400-1192 | Lower shaft gear | 1 | |
| 11 | 400-1100 | Screw | 2 | SM1/4"X40 |
| 12 | 400-1193 | Collar | 1 | |
| 13 | 400-1194 | Screw | 2 | SM11/16"X40 |
| 14 | 400-1195 | Hook driving shaft | 1 | |
| 15 | 400-1196 | Oil wick | 1 | |
| 16 | 400-1197 | Hook driving shaft bushing (L) | 1 | |
| 17 | 400-1198 | Screw | 1 | SM15/64"X28 |
| 18 | 400-1199 | Oil felt | 1 | |
| 19 | 400-1200 | Spring | 1 | |
| 20 | 400-1201 | Hook driving shaft bushing (R) | 1 | |
| 21 | 400-1198 | Screw | 1 | SM15/64"X28 |
| 22 | 400-1202 | Hook driving gear | 1 | |
| 23 | 400-1203 | Screw | 2 | SM1/4"X40 |
| 24 | 400-1204 | Collar | 1 | |
| 25 | 400-1205 | Screw | 2 | SM11/64"X40 |
| 26 | 400-1206 | Bobbin | 1 | |
| 27 | 400-1207 | Bobbin case opener | 1 | |
| 28 | 400-1208 | Screw | 1 | SM11/64"X40 |
| 29 | 400-1209 | Screw | 1 | SM11/64"X40 |
| 30 | 400-1097 | Nut | 1 | SM11/64"X40 |
| 31 | 400-1210 | Eccentric cam | 1 | |
| 32 | 400-1211 | Screw | 2 | SM15/64"X28 |
| 33 | 400-1212 | Feed dog lift link | 1 | |
| 34 | 400-1213 | Eccentric pin | 1 | |
| 35 | 400-1214 | Screw | 1 | SM11/64"X40 |
| 36 | 400-1215 | Bearing | 1 | K202417 |
| 37 | 400-1216 | Retainer | 2 | |
| 38 | 400-1217 | Cover | 1 | |
| 39 | 400-1146 | Screw | 2 | SM9/64"X40 |
| 40 | 400-1218 | Lower shaft synchronized pulley | 1 | |
| 41 | 400-1219 | Retaining ring | 1 | |
| 42 | 400-1220 | Pulley bushing | 1 | 103614 |
| 43 | 400-1221 | Spring plate | 1 | |
| 44 | 400-1222 | Spring plate | 1 | |
| 45 | 400-1223 | Pin | 1 | |
| 46 | 400-1224 | Stop plate | 1 | |
| 47 | 400-1225 | Link | 1 | |
| 48 | 400-1226 | Clutch plate | 1 | |
| 49 | 400-1227 | Clutch plate pin | 1 | |
| 50 | 400-1228 | Screw | 2 | |
| 51 | 400-1229 | Screw | 2 | |
| 52 | 400-1230 | Pin | 1 | GB/T991 1.2X8 |
| 53 | 400-1231 | Clutch wheel | 1 | |
| 54 | 100-1089 | Screw | 2 | |
| 55 | 400-1232 | Button | 1 | |
| 56 | 400-1233 | Pin | 1 | |
| 57 | 400-1234 | Spring plate | 1 | |
| 58 | 400-1235 | Button bushing | 1 | |

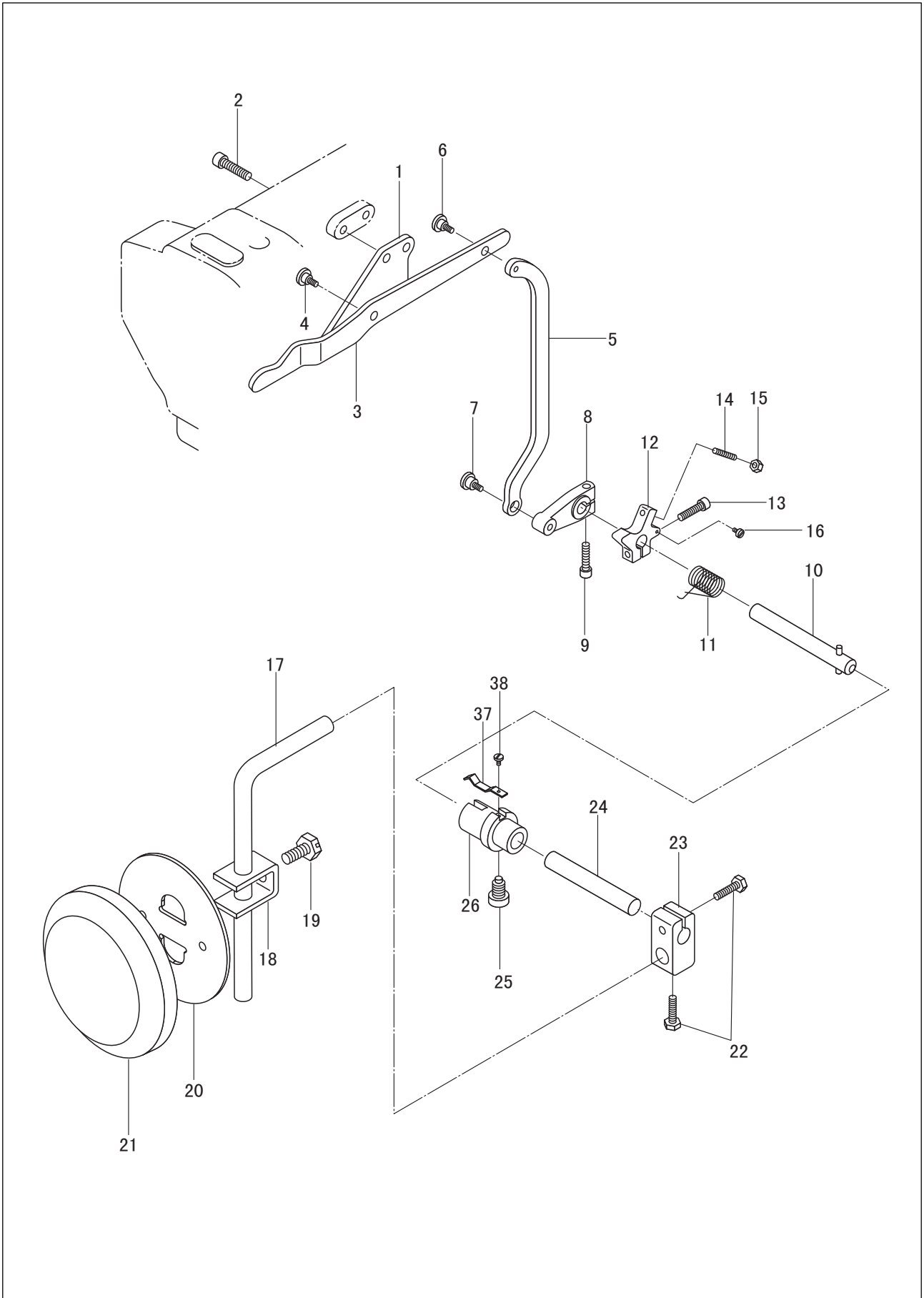
7. Thread tension and bobbin thread winder mechanism



7. Thread tension and bobbin thread winder mechanism

| Line | Part Number | Description | Qt. | Notes |
|------|-------------|--------------------------------|-----|----------------|
| 1 | 400-1236 | Thread tension plate assembly | 1 | |
| 2 | 400-1237 | Thread guide plate | 1 | |
| 3 | 200-1019 | Screw | 2 | SM11/64"X40 |
| 4 | 400-1238 | Thread releasing bar | 1 | |
| 5 | 400-1239 | Thread releasing bar bushing | 1 | GB/T879.1 6X55 |
| 6 | 400-1240 | Bobbin thread tension assembly | 1 | |
| 7 | 400-1241 | Screw | 1 | |
| 8 | 400-1242 | Thread winder assembly | 1 | |
| 9 | 400-1243 | Friction ring | 1 | |
| 10 | 400-1244 | Screw | 3 | SM11/64"X40 |
| 11 | 400-1245 | Friction wheel | 1 | |
| 12 | 100-1089 | Screw | 2 | |
| 13 | 400-1246 | Cutter | 1 | |
| 14 | 100-1047 | Screw | 2 | |
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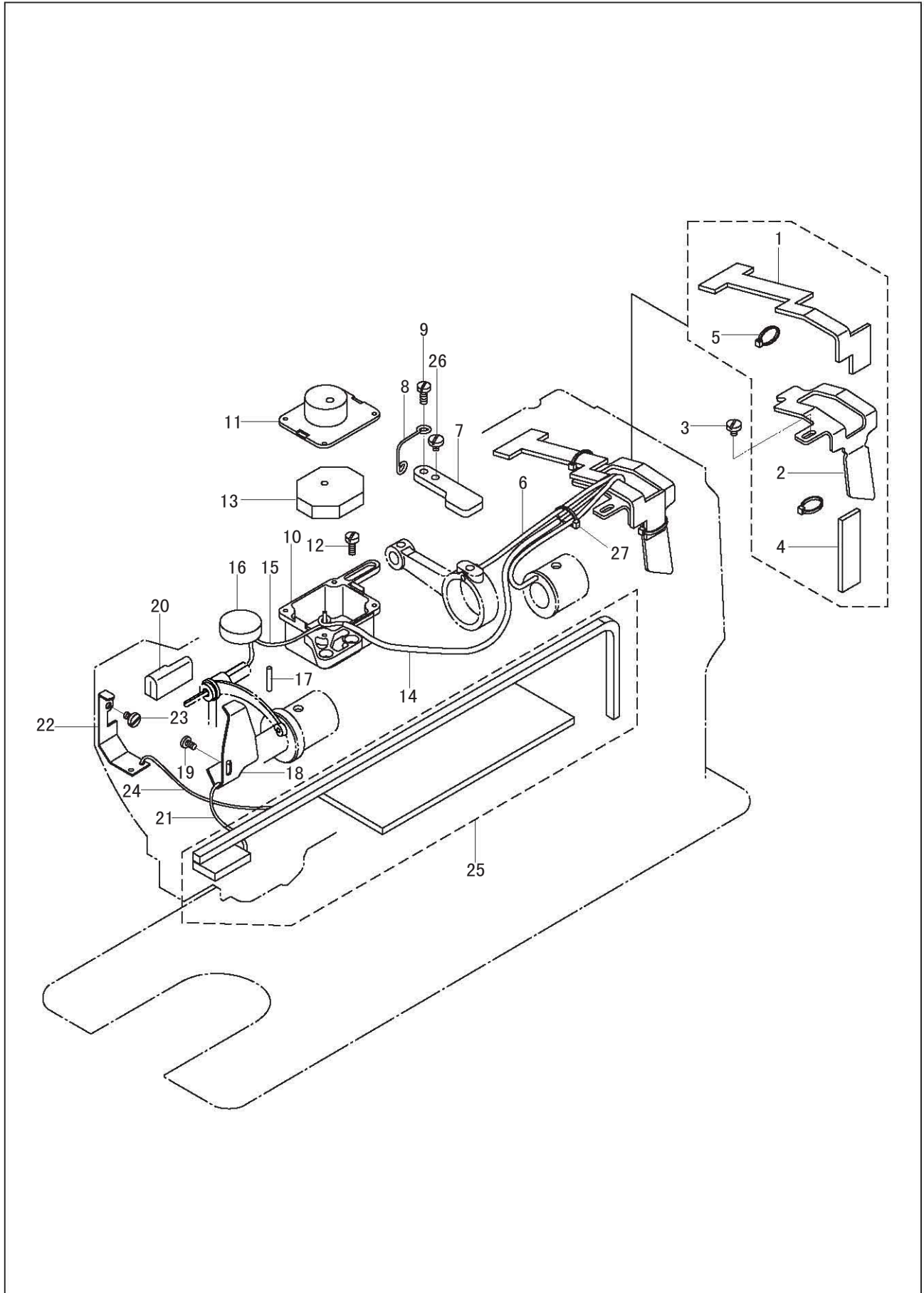
8. Knee lifter mechanism



8. Knee lifter mechanism

| Line | Part Number | Description | Qt. | Notes |
|------|-------------|------------------------------|-----|---------------|
| 1 | 400-1247 | Knee control lever support | 1 | |
| 2 | 400-1248 | Screw | 2 | |
| 3 | 400-1249 | Knee control lever support | 1 | |
| 4 | 400-1250 | Screw | 1 | SM1/4"X40 |
| 5 | 400-1251 | Knee control connecting rod | 1 | |
| 6 | 400-1252 | Screw | 1 | SM11/64"X40 |
| 7 | 400-1250 | Screw | 1 | SM1/4"X40 |
| 8 | 400-1253 | Crank | 1 | |
| 9 | 400-1254 | Screw | 1 | |
| 10 | 400-1255 | Knee control revolving shaft | 1 | |
| 11 | 400-1256 | Spring | 1 | |
| 12 | 400-1257 | Position block | 1 | |
| 13 | 400-1254 | Screw | 1 | |
| 14 | 400-1258 | Screw | 1 | GB/T77 M5X25 |
| 15 | 400-1259 | Nut | 1 | GB/T6172.1 M5 |
| 16 | 400-1260 | Screw | 1 | SM9/64"X40 |
| 17 | 100-1329 | Knee control bell bent bar | 1 | |
| 18 | 100-1331 | Bell bracket | 1 | |
| 19 | 100-1332 | Screw | 1 | |
| 20 | 100-1330 | Knee control bell | 1 | |
| 21 | 100-1333 | Cushion | 1 | |
| 22 | 400-1261 | Screw | 2 | SM5/16"X24 |
| 23 | 400-1262 | Bell bent adapter | 1 | |
| 24 | 400-1263 | Knee control connecting bar | 1 | |
| 25 | 400-1264 | Screw | 1 | SM5/16"X24 |
| 26 | 400-1265 | Connecting bushing | 1 | |
| 27 | 400-1266 | Spring | 1 | |
| 28 | 400-1267 | Screw | 1 | SM9/64"X40 |
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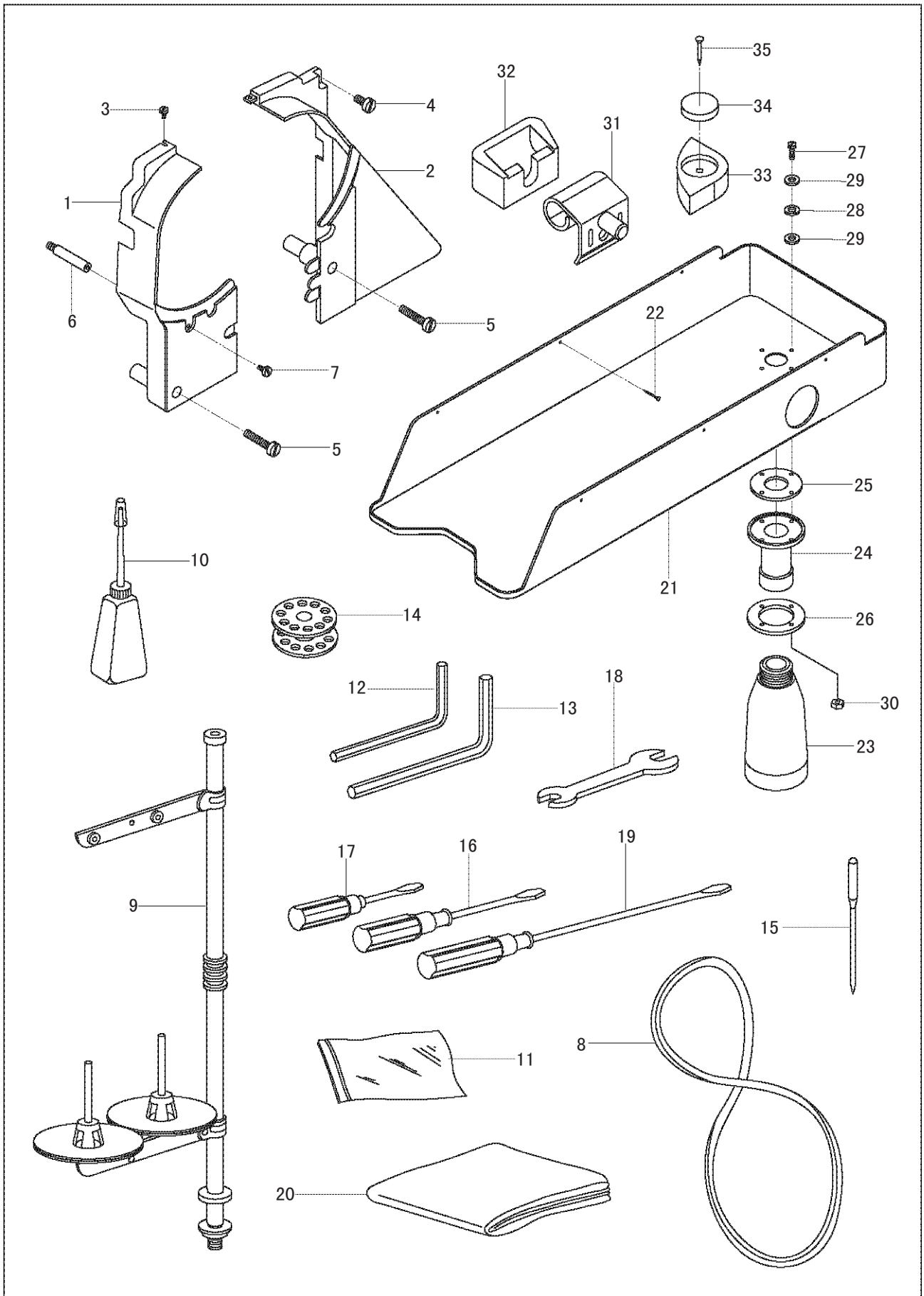
9. Lubrication



9. Lubrication

| Line | Part Number | Description | Qt. | Notes |
|------|-------------|---------------------|-----|-------------|
| 1 | 400-1268 | Oil felt | 1 | |
| 2 | 400-1269 | Oil felt support | 1 | |
| 3 | 200-1019 | Screw | 1 | SM11/64"X40 |
| 4 | 400-1270 | Small oil felt | 1 | |
| 5 | 400-1118 | Binding cord | 3 | |
| 6 | 400-1271 | Oil wick | 1 | φ2x190 |
| 7 | 400-1272 | Press plate | 1 | |
| 8 | 400-1273 | Hook | 1 | |
| 9 | 400-1274 | Screw | 1 | SM11/64"X40 |
| 10 | 400-1275 | Oil pot | 1 | |
| 11 | 400-1276 | Oil pot cover | 1 | |
| 12 | 400-1277 | Screw | 2 | SM11/64"X40 |
| 13 | 400-1278 | Oil felt | 2 | |
| 14 | 400-1279 | Oil tube | 1 | φ3x φ5X180 |
| 15 | 400-1196 | Oil wick | 1 | φ2x380 |
| 16 | 400-1280 | Oil felt 1 | 1 | |
| 17 | 400-1281 | Oil felt 2 | 1 | |
| 18 | 400-1282 | Oil retaining plate | 1 | |
| 19 | 400-1146 | Screw | 1 | SM9/64"X40 |
| 20 | 400-1283 | Oil felt | 1 | |
| 21 | 400-1284 | Oil wick | 1 | φ2x250 |
| 22 | 400-1285 | Oil retaining plate | 1 | |
| 23 | 400-1286 | Screw | 1 | SM11/64"X40 |
| 24 | 400-1287 | Oil wick | 1 | φ2x250 |
| 25 | 400-1283 | Oil felt assembly | 1 | |
| 26 | 200-1019 | Screw | 1 | SM11/64"X40 |
| 27 | 400-1118 | Binding cord | 1 | |
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10. Accessories



10. Accessories

| Line | Part Number | Description | Qt. | Notes |
|------|-------------|--------------------------|-----|-----------------------|
| 1 | 400-1288 | Safety guard 1 | 1 | |
| 2 | 400-1289 | Safety guard 2 | 1 | |
| 3 | 400-1290 | Screw | 1 | SM11/64"X40 |
| 4 | 400-1291 | Screw 1 | 1 | SM15/64"X28 |
| 5 | 200-1179 | Screw 2 | 2 | SM15/64"X28 |
| 6 | 400-1292 | Column | 1 | |
| 7 | 400-1274 | Screw | 1 | SM11/64X40 |
| 8 | 400-1293 | V-belt | 1 | 42V |
| 9 | 200-1368 | Spool stand | 1 | |
| 10 | 100-1309 | Small oil pot | 1 | |
| 11 | 100-1299 | Parts bag | 2 | |
| 12 | 400-1294 | Spanner | 1 | S=2.5mm GB/T5356-1998 |
| 13 | 400-1295 | Spanner | 1 | S=3MM GB/T5356-1998 |
| 14 | 400-1206 | Bobbin | 6 | |
| 15 | 100-1078 | Needle | 3 | 135X17#23 |
| 16 | 100-1301 | Screwdriver (medium) | 1 | |
| 17 | 100-1300 | Screwdriver (small) | 1 | |
| 18 | 400-1296 | Double ended spanner | 1 | 9X10 |
| 19 | 100-1302 | Screwdriver (big) | 1 | |
| 20 | 400-1297 | Machine head cover | 1 | |
| 21 | 400-1298 | Oil reservoir | 1 | |
| 22 | 400-1299 | Screw | 6 | SG162 19 |
| 23 | 400-1300 | Oil pot | 1 | |
| 24 | 400-1301 | Adapter | 1 | |
| 25 | 400-1302 | Seal ring | 1 | |
| 26 | 400-1303 | Presser plate | 1 | |
| 27 | 400-1304 | Connecting screw | 4 | GB/T818 M3X14 |
| 28 | 400-1305 | Spacer | 4 | GB/T848 3 |
| 29 | 400-1306 | Seal spacer | 8 | |
| 30 | 400-1307 | Connecting nut | 4 | GB/T6170 M3 |
| 31 | 400-1308 | Connecting hook assembly | 2 | |
| 32 | 400-1309 | Rubber cushion | 2 | |
| 33 | 400-1310 | Rubber cushion | 4 | |
| 34 | 400-1311 | Oil felt | 4 | |
| 35 | 400-1312 | Screw | 4 | GB349-88-1 |
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