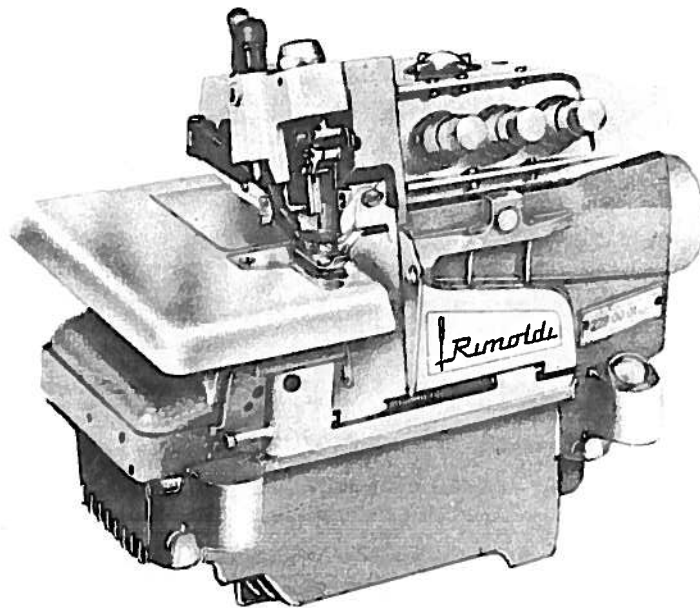


Remoldi



SPARE PARTS CATALOGUE

HEAD **228-00-01**

AND SUBCLASSES

HEAD **228-28-05**

33/A

N. CAT. 652230400 of 20/68

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INTRODUCTION

I. HEAD IDENTIFICATION

a) Identification numbers

1. Every head is identified by:
 - class and sub-class numbers
 - serial number
2. The class and sub-class numbers are engraved on the nameplate on the base of the machine.
3. The head serial number is engraved on a boss on the bottom of the base.

II. TECHNICAL DATA OF CLASS

The heads illustrated in this catalogue are of the single needle overedging type having the following general specifications:

1. Straight needle system RIM 27 - size from 55 to 100
2. Stitch length variable from 6 to 40 stitches per inch
3. Differential ratio up to 3,5 to 1
4. Width of bight from 3/64" – 15/64"
5. Speed from 6,000 to 7,000 r.p.m. according to performance
6. Lubricator by double stage pump
7. Motor: 1/3 HP or 1/2 HP according to sub-class
8. Overall head dimensions 300x240 mm.
9. Weight: about 43 lbs.

III. TECHNICAL DATA BY SUB-CLASS

| HEAD No. | TECHNICAL CHARACTERISTICS | | | | | | SPECIFIC USES | |
|-------------|---------------------------|----------------------|---------------|----------------------------|-----------------|--------|--------------------------|--|
| | No. threads | Width of bight | Diff. pos. | S P E E D | | Knives | | Sp. attach- ments on req. |
| | | | | No. of revs. 1" max. | St. per inch | | | |
| 228-00-01 | 3 | 1 8" 15 64" | | 7000 | 8-30 | st | 100 101 106 107 | ASSEMBLY SEAMING WITH OR WITHOUT CURLED IN EDGES For medium cut knit fabrics in wool, cotton, etc. |
| 228-00-02 | 3 | 5 64" 9 64" | | 7000 | 8-30 | st | 100 101 | For perfectly straight hanging seams on warp knit nylon fabrics etc. |
| 228-00-03 | 3 | 5 64" 9 64" | | 7000 | 8-30 | st | 100 101 106 107 | Same as 228-00-02 but with cutting device adjustable while the machine is in operation. |
| 228-00-04 | 3 | 1 8" 15 64" | | 6500 | 8-20 | st | 106 | For medium and heavy fabrics, with a maximum presser foot throw of 19 64" maximum bight 15 64". |
| 228-00-05 | 3 | 3 32" 5 32" | | 7000 | 8-30 | st | 100 101 106 107 | Same as 228-00-01 but with a slightly narrower bight, for light cotton and woollen cut knit fabrics. |
| 228-00-06 | 3 | 3 64" 1 16" | | 6200 | 20-40 | st | 100 | For closing the toes of nylon stockings. |
| 228-00-07 | 2 | 1 16" 5 64" | | 6200 | 20-40 | st | 100 106 | For closing the toes of belton and cotton socks. |
| 228-00-08 | 3 | 3 64" 1 16" | | 6200 | 14-40 | st | 100 106 | For very light nylon warp knit fabrics, etc. (15 denier), with very fine seam. |
| 228-00-11 | 3 | 5 64" 1 8" | | 7000 | 8-30 | st | 100 106 107 | For very light and light woven fabrics (nylon, satin, very light flannel, etc.) with attachment to turn the fabric downwards into the seam. |
| 228-00-12 | 3 | 3 32" | | 7000 | 8-30 | st | 100 106 107 | For light woven fabrics, with attachment to turn the fabric upwards into the seam. |
| | | | | | | | | ASSEMBLY SEAMING WITH OR WITHOUT CURLED IN EDGES, WITH ATTACHMENTS AND/OR INSERTIONS |
| 228-01-01 | 3 | 1 8" 15 64" | | 7000 | 8-30 | st | 107 | For medium cut knit fabrics in wool, cotton etc. with attachment for inserting a reinforcement tape into the seam. |
| 228-01-02 | 3 | 1 8" 15 64" | | 6500 | 8-20 | st | | For medium and heavy fabrics, with a maximum presser foot throw of 19 64" maximum bight 15 64" with attachment for inserting a reinforcement tape into the seam. |
| 228-01-03 | 3 | 3 32" 5 32" | | 7000 | 8-30 | st | 107 | Same as 228-01-01 but with a slightly narrower bight, for light cotton and woollen cut knit fabrics. |

III. TECHNICAL DATA BY SUB-CLASS

| HEAD No. | TECHNICAL CHARACTERISTICS | | | | | | SPECIFIC USES | |
|-------------|---------------------------|----------------------|---------------|----------------------------|-----------------|--------|--|---|
| | No. threads | Width of bight | Diff. pos. | S P E E D | | Knives | | Sp. attach- ments on req. |
| | | | | No. of revs. 1" max. | St. per inch | | | |
| 228-10-01 | 3-2 | 5 64" 1 3" | | 7000 | 8-30 | si | 100 106 107 | HEMMING |
| | | | | | | | | For wetting knit fabrics in general with invisible seam on right side, with fixed hinged wetting folder - with a blind looper to work also with 2 thread. |
| 228-10-02 | 3-2 | 5 64" 1 8" | | 7000 | 8-30 | si | 100 106 107 | HEMMING |
| | | | | | | | | With folder, throat plate, feed dog and presserfoot specially designed for wetting along the non-stretchy direction of warp knit, jersey fabrics, etc. with invisible seam on right side, with a blind looper to work also with 2 threads |
| 228-10-03 | 3-2 | 5 64" 1 8" | | 7000 | 8-30 | si | 100 106 107 | HEMMING |
| | | | | | | | | Same as 228-10-02 but with wetting folder moveable by means of knee-press, guaranteeing a regular hem even at cross-seams |
| 228-10-05 | 3-2 | 5 64" 1 8" | | 7000 | 8-30 | si | 100 106 107 | HEMMING |
| | | | | | | | | For wetting of knit fabrics with invisible seam on right side, with swingout wetting folder and with work plate cut out to accept preclosed sleeves, with blind looper to work also with 2 threads |
| 228-10-06 | 3-2 | 5 64" 1 8" | | 7000 | 8-30 | si | 100 106 107 | HEMMING |
| | | | | | | | | For wetting of knit fabrics with invisible seam on right side, with blind looper to work also with 2 threads |
| 228-10-07 | 3-2 | 5 64" 1 8" | | 7000 | 8-30 | si | 100 106 107 | HEMMING |
| | | | | | | | | Same as 228-10-01 but with special work plate cut out to accept preclosed sleeves |
| 228-28-01 | 2 | 1 8" 15 64" | | 7000 6500 | 8-14 6-7 | si | 100 106 107 120 121 900 901 902 | OVEREDGING |
| | | | | | | | | For serging and/or overedging light and medium woven and knit fabrics where the use of the differential is particularly requested. |
| 228-28-02 | 3-2 | 1 8" 15 64" | | 7000 6500 | 8-14 6-7 | si | 100 106 107 120 121 900 901 902 | OVEREDGING |
| | | | | | | | | Same as 228-28-01 but with looper to work also with three threads |
| 228-28-07 | 3 | 3 32" 9 64" | | 6000 | 14-40 | si | 100 106 107 | OVEREDGING |
| | | | | | | | | For serging and/or overedging headsquares, veils, scarves, etc. made from lightweight fabrics such as nylon, silk, japonette, etc. turning the edge of the fabric into the seam. |
| 228-28-05 | 2 | 15/64" | | 7000 | 8-14 | si | 100 107 120 121 900 901 | OVEREDGING |
| | | | | | | | | for medium and heavy fabrics |

INSTRUCTIONS : FOR

- INSTALLATION AND TIMING**
- USE**
- MAINTENANCE**

I. INSTALLATION AND SETTING-UP

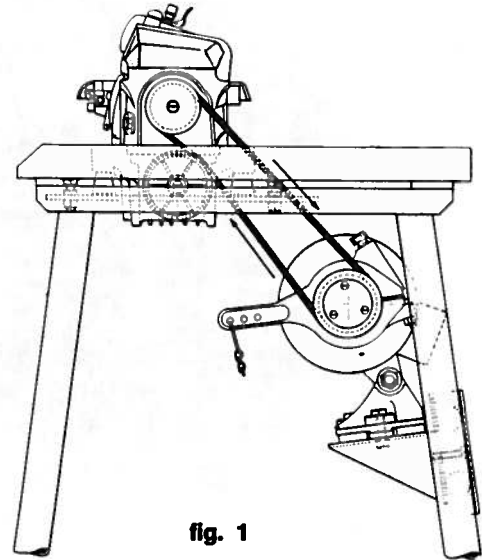
a) Positioning of head

After motor is mounted on stand, proceed as follows:

1. Push the four shock absorbing rubbers onto the appropriate head mounting plate pins.
2. Place the machine head on the table and center the lower head holes onto the shock absorbing pins.

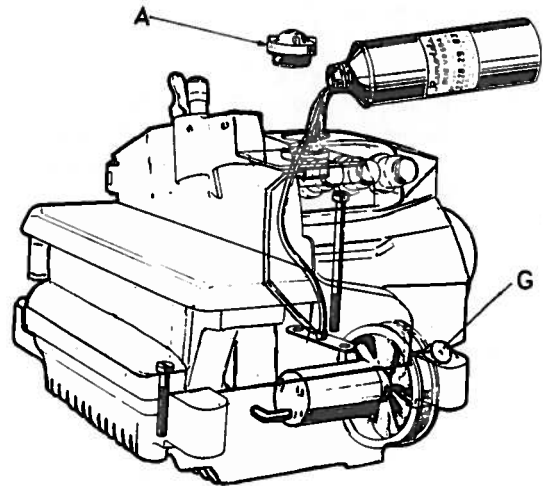
b) Transmission assembly

1. Fit the transmission belt as in fig. 1.
2. Make sure that back of driving belt rides firmly and squarely on pump pulley.
3. Take-up belt play by adjusting motor clamp.
4. Level the machine head by adjusting the nuts of the bolts which fix the plate to the table.
5. Tighten up the lock nuts on these bolts.



c) Filling sump with lubricating oil

1. Unscrew cap A.
2. Pour in 1 3/4 pts. of VR. 604 oil (Esso Standard Teresso 43) (Bear in mind that the sump holds 2 pts.)
3. Check oil level. The oil visible through indicator glass G, should be between the two red lines.
4. Replace and tighten cap 'A'.
5. Put a few drops of oil on the needle clamp guide rod and upper looper bar before starting machine.
6. Run the machine free of work for about 5 minutes, progressively increasing the speed from 1500 r.p.m. to working speed.



d) Assembly and adjustment of sewing parts

Note: The following operations serve to adjust the timing of the machine.

1. Timing gauges required:
 - S. 1665.00 for all operations except No. 4 (fig. 4)
 - S. 1555.00 for operation No. 4 (fig. 4).
2. Preliminary stripping of:
 - Front cover plate
 - The two thread take-ups of the lower looper holder
 - Plate holding thread tensioners
 - Upper plate with oil spy-glass
 - Side plate protecting needle movement
 - Front feed dog.

3. Positioning the needle (fig. 3).

- With the needle plate properly mounted the needle should be centered for passage through the appropriate hole in the throat plate.
- With the needle at top dead centre the distance between the tip of the needle and the work plate, should be 25/64"
- For 228-00-04 and its derivatives, this distance should be 3/8"
- If adjustment of the needle clamp is necessary, loosen bolt A (fig. 3) and set distance with gauge S. 1665.00

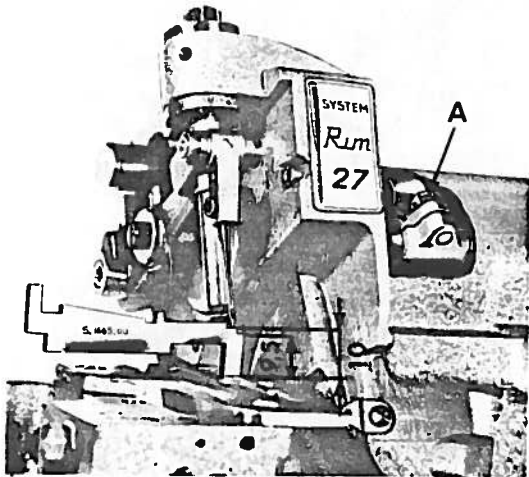


fig. 3

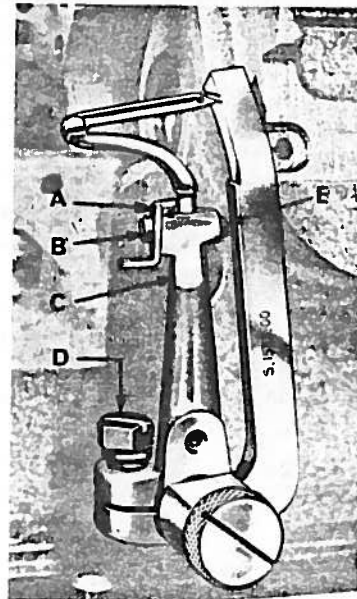


fig. 4

4. Setting lower looper (fig. 4).

Setting height

- Loosen screw E.
- Firmly screw gauge S.1555.00 into the lower looper shaft.
- Adjust looper height so that its point coincides with the lower notch on the gauge. For 228-00-05 and its derivatives, the looper point should coincide with the upper notch.
- Lightly lock looper with screw E.
- Set height of thread guide bracket 'A' by raising it to top of looper shank and lock by tightening up screw B
- Remove gauge S. 1555.00.

Adjusting angle

- Slightly loosen screw D.
- Rest the gauge S.1665.00 on the milled base as in fig. 5; obtain correct inclination by moving lever C and by rotating the looper (previously having only been held in its seating and not locked).
- The exact position corresponds to that given in the setting tables.
- Firmly tighten screw E (fig. 4).

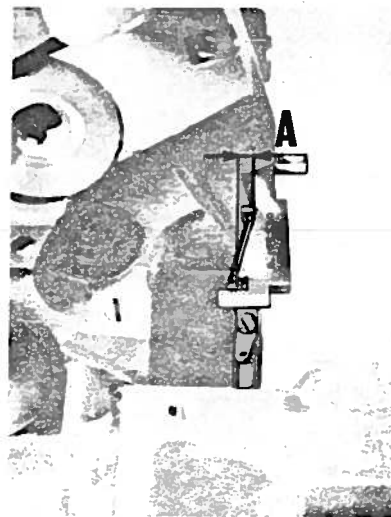


fig. 5

Positioning the looper with respect to the needle fig.6.

- With the looper hand to the left, check the figure given in the timing table.
- Move lever C up and down the shaft it rotates on. When moving from left to right the looper point should pass 0,2 mm. from the bottom of the needle groove.
- Firmly tighten screw D.

5. Setting upper looper.

Note: To obtain the figure of $5/16'' - 23/64''$ in fig. 9 it is necessary to move lever E up or down, at the same time remembering that by doing this the distances in figs. 7 and 8 will increase or decrease.

- Slightly loosen screw B.
- Slightly loosen screw A.
- Adjust the crossing of the upper and lower loopers by rotating the upper until its point grazes the back of the lower.
- Check the settings shown in fig. 7-8-9 (setting table). The upper looper should graze the needle when passing from left to right.
- Should this condition not exist, slightly loosen screw D and push the whole assembly towards the interior or exterior of the machine without altering the settings previously obtained. Ensure perfect kinematic motion.
- Tighten screw D.
- Re-check the crossing of the two loopers and all the other settings.
- Tighten screws A and B.
- To finish off, make sure that all assemblies move freely.

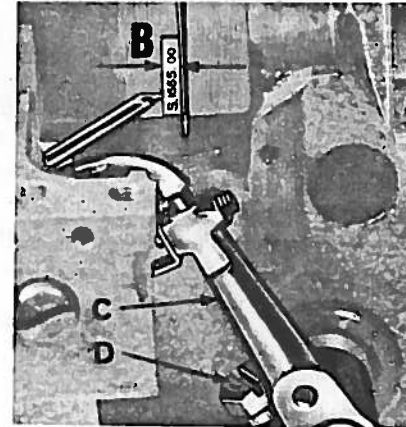


fig. 6

6. Attaching needle guards (fig. 10).

- Attach front needle guard A.
- With the needle at its lowest point, adjust the front needle guard so that the lower looper point grazes the needle.
- Tighten screw C.
- Attach rear needle guard B and adjust until close to the needle, still in the low position.
- Tighten screw D.

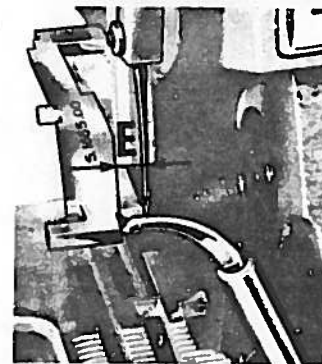


fig. 7

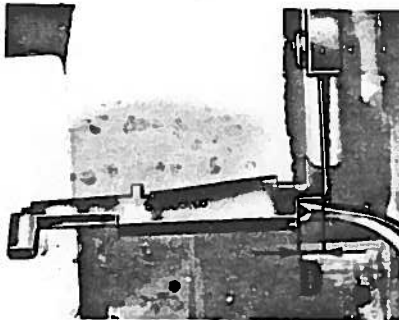


fig. 8

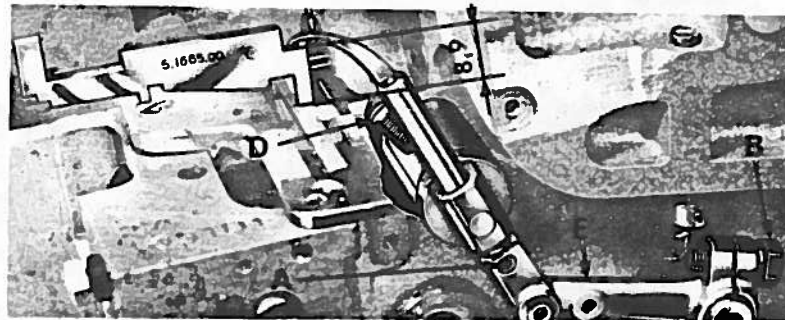


fig. 9

- It must be checked that the needle will not get broken during operation due to any bending causing it to hit the lower looper. To do this, bend the needle towards the interior of the machine and ensure that the looper, when passing from left to right, touches the needle, without breaking it.
- Thread the needle, then bring it right down and gently push it against rear needle guard B.
- The thread should run freely. If it does not it means that the needle is too low and the thread is being caught between the needle and the needle guard.

Note: The looper point should pass through the lower part of the groove on its right hand run, and through the upper part on its left hand run.

- For hard synthetic materials, make the needle bend more against the needle guard.

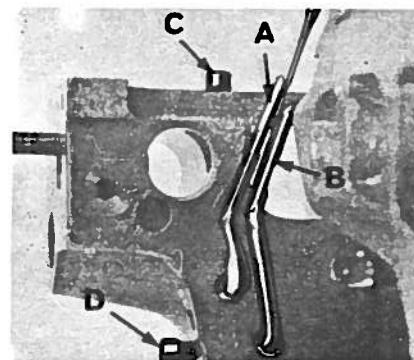


fig. 10

7. Fitting the lower knife (fig. 11).

- Fix bracket P to the knife holder with screw C.
- Insert knife D into its seat.
- The cutting edge of the knife should not protrude above the surface of the plate.
- Tighten screw A.
- With the needle in the lowest position, slide bracket O towards the needle guard and lock bush L and washer G with screw F.
- Ensure that knife holder C slides freely and then adjust it in relation to the width of stitching required.
- Lightly tighten screw N.
- With the needle in the lowest position move bracket P towards front needle guard and lock with screw Q.
- Having positioned the upper knife in contact with the lower, loosen screw N. Spring M, with pin H, creates correct contact pressure between the knives.
- Rest a finger on screw A and thus exert a very light pressure to lock screw N.
- This pressure must be light in order not to cause strong friction between the two knives and their consequent damage.

Note: The following sub-classes:

228-00-05 228-00-07 228-00-08 and their derivatives do not have brackets O and P.

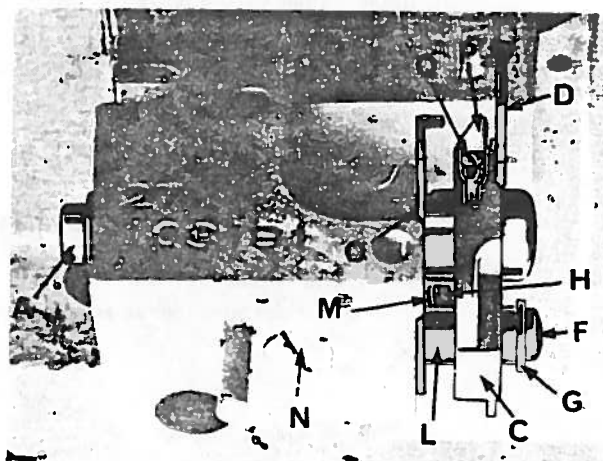


fig.11

8. Fitting and adjusting feed dogs (figs. 12 and 13).

- Fit the rear feed dogs C and D (fig. 12) and match the feed dog slides.
- Inserting a small screw driver through the threaded holes in the slides, tighten, but not completely, screw F, by means of the groove in its point.
- Fit the front differential feed dog E with screw G but do not lock (fig. 13).
- Loosen screw A.
- Adjust the feed dog inclination by rotating the eccentric B.

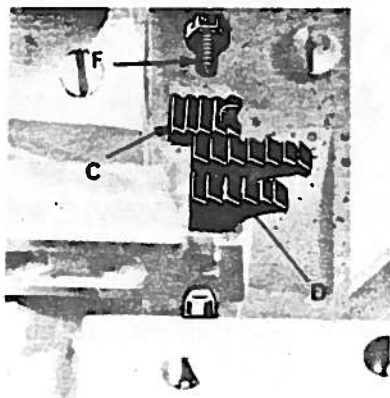


fig.12



fig.13

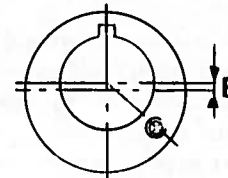
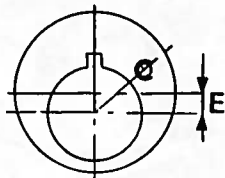
- The feed dog teeth, protruding from the needle plate, should be perfectly parallel with this plate.
- With the feed dogs at the highest point, the distance between their teeth and the plate surface, measured on the front of the feed dog differential, should be 3/64"
- Feed dog C should be lower than the other two feed dogs.
- Lock screws F, G and A.

9. Feed (fig. 14).

Note: The machines illustrated in this manual are supplied with the feed adjusted to suit the work for which the machines are destined.

Should it ever be desired to alter the feed, then procede as follows:

- Substitute eccentric A or eccentric B, or both A and B. For eccentric substitution, according to the length of stitch, consult the appropriate tables. Use extractor drawing No. 280-715.



| ECCENTRICITY E | No stitches per inch | DRAWING No. |
|-------------------|-------------------------------|--------------|
| 2,57 ± 0,03 | 3,5 | 280-0451/3,5 |
| 2,12 ± 0,03 | 4 | 280-0451/4 |
| 1,49 ± 0,03 | 5 | 280-0451/5 |
| 1,06 ± 0,03 | 6 | 280-0451/6 |
| 0,76 ± 0,03 | 7 | 280-0451/7 |
| 0,53 ± 0,03 | 8 | 280-0451/8 |
| 0,36 ± 0,03 | 9 | 280-0451/9 |
| 0,22 ± 0,03 | 10 | 280-0451/10 |
| 0 ± 0,03 | 12 | 280-0451/12 |

| ECCENTRICITY E | No. stitches per inch | DRAWING No. |
|-------------------|--------------------------------|-------------|
| 0,15 ± 0,02 | 14 | 280-0461/14 |
| 0,26 ± 0,02 | 16 | 280-0461/16 |
| 0,35 ± 0,02 | 18 | 280-0461/18 |
| 0,42 ± 0,01 | 20 | 280-0461/20 |
| 0,48 ± 0,01 | 22 | 280-0461/22 |
| 0,53 ± 0,01 | 24 | 280-0461/24 |
| 0,57 ± 0,008 | 26 | 280-0461/26 |
| 0,6 ± 0,008 | 28 | 280-0461/28 |
| 0,63 ± 0,005 | 30 | 280-0461/30 |
| 0,65 ± 0,005 | 32 | 280-0461/32 |
| 0,68 ± 0,005 | 34 | 280-0461/34 |
| 0,7 ± 0,005 | 36 | 280-0461/36 |
| 0,74 ± 0,005 | 40 | 280-0461/40 |
| 0,76 ± 0,005 | 44 | 280,0461/44 |
| 0,8 ± 0,005 | 50 | 280-0461/50 |
| 0,84 ± 0,005 | 60 | 280-0461/60 |
| 0,87 ± 0,005 | 70 | 280-0461/70 |
| 0,88 ± 0,005 | 74 | 280-0461/74 |

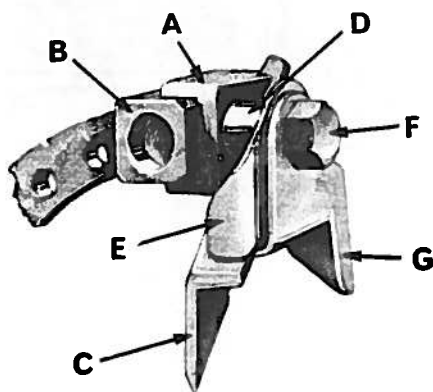


fig. 15

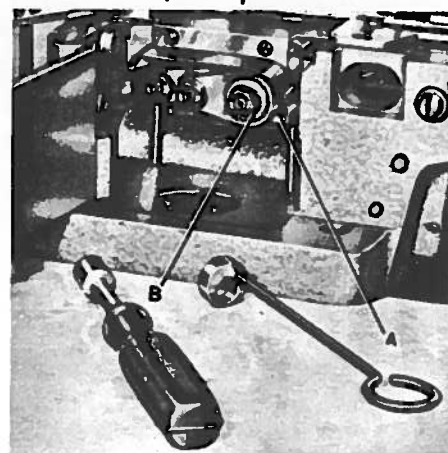


fig. 14

10. Fitting upper knife (fig. 15).

- Fit upper knife C into its seat in block A.
- Attach block D and brackets E and G with bolt F.
- Bracket E should be very near the cutting plane of knife C.
- When knife C is at the bottom of its stroke, its cutting edge should be 1/32" below the cutting edge of the lower knife.
- To obtain this, adjust knife C in its inclined seat and block A on the body of the upper knife holder B.
- Lock bolt F and then make sure that when the upper knife reaches the bottom of its stroke it does not touch the front needle guard.

e) Locking and adjusting presserfoot lever (fig. 16).

- Slide the lever shaft L into bush C to which lever D is hinged
- Insert shaft L and bush C into the appropriate hole in the base.
- Slide lever A and spring E onto shaft L.
- Attach spring clip F to end of shaft L.
- Adjust lever A to eliminate axial play of shaft L.
- Lightly tighten screw B.
- Insert lever D into the guiding fork with the needle at top dead center.
- Connect lever A to the rod joined to the presserfoot raising pedal.
- When the pedal is depressed there should be some free play before lever D is acted upon.

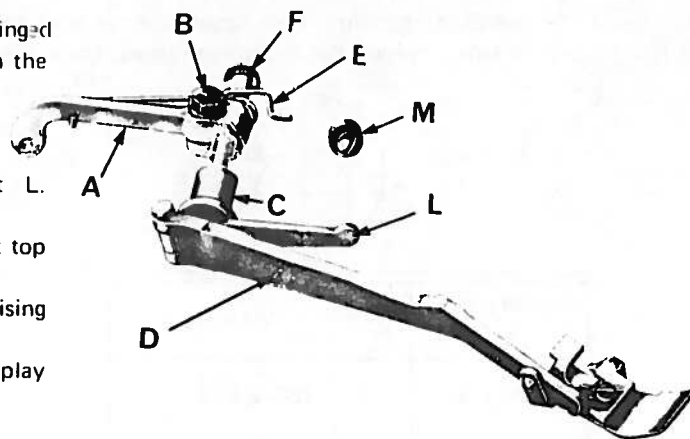


fig. 16

- Adjust the screw in the base under lever A until this raises the presserfoot to the required position.
- Ensure that when the upper looper is in movement it does not touch the presserfoot tongue when this is in its highest position. A better guard against the upper looper and the presser foot tongue hitting, is supplied by adjusting the eccentric washer M which is under lever D and attached to the side cover.
- Lock screw B.

f) Adjusting the front cover plate (fig. 17).

- Adjustment is carried out with the plate closed.
- The movable part C should not interfere with the front needle guard or the lower knife holder.
- Slacken-off nut A.
- Adjust screw B to move the plate to left or right.
- Lock nut A.

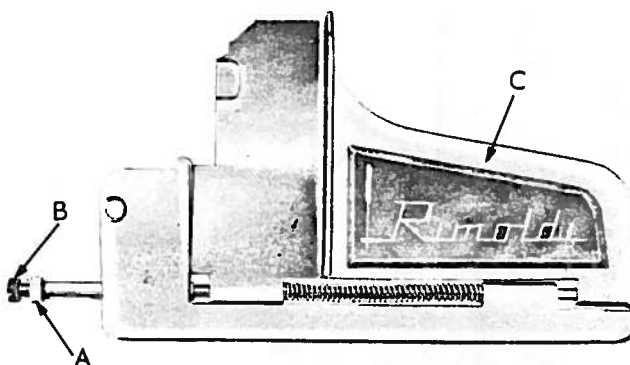


fig. 17

g) Adjusting needle thread take-up

- When working with very hard materials adjust the needle thread take-up 270-274/2 by moving it forward, that is towards the operator.

ELECTRICAL EQUIPMENT FOR LUBRICATION CONTROL (PRESSURE SWITCH)

h) Dismantling and replacing the pressure switch

- Remove the sump from the base and empty the oil.
- Remove the screw fixing the pressure switch bracket to the sump.
- Remove the two screws holding the cable end.
- Remove the plastic tube from the pressure switch which connects to the rubber union.
- Remove the support bracket and fix it to the new pressure switch.
- Attach the cable end with the screws, slide the plastic tube into the pressure switch and replace in sump with appropriate screw.
- Replace the sump and fill with oil as described on page 11 para. c.

Changing the pressure switch bulb.

- Carry out operations 1 and 2 as explained for the substitution of the pressure switch.
- Remove tube, extract the bulb, which has a bayonet fitting, and replace with a new one.
- Re-attach the tube, position the pressure switch in the sump and attach with the screws.
- Replace sump and fill with oil as explained on pag. 11 para. c.

Electrical connection of pressure switch on Zafir motors.

- Plug the connecting cable into the pick-up socket and plug the other end into the 12 V. light socket on the motor.

Note: if connection has to be made to a motor not equipped with a light socket, but equipped with a 12 V. take-off in the connection box, procede as follows:

- Cut a piece of cable to about 5" length and to one end attach a Mignon socket type 13 and to the other the pins of the 12 V. light voltage.
- Plug the connecting cable into the pick-up socket and plug the other end into the Mignon socket.

Regulating flow of lubricating oil through the main shaft. (fig. 18).

- Remove cap
- Adjust index B with a screw driver. (Movement towards the C engraved on the plate, decreases the oil flow, towards the letter A increases flow.

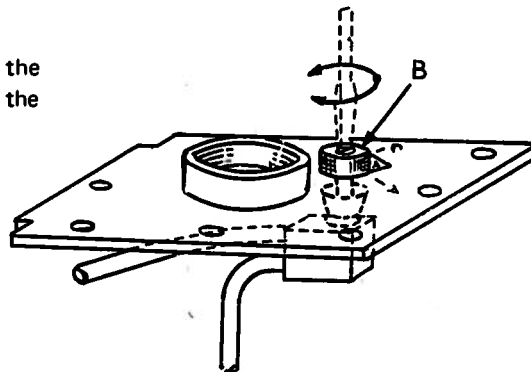
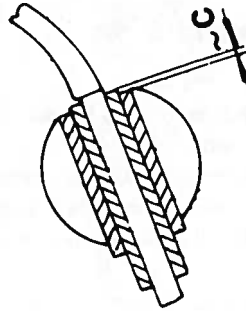


fig. 18

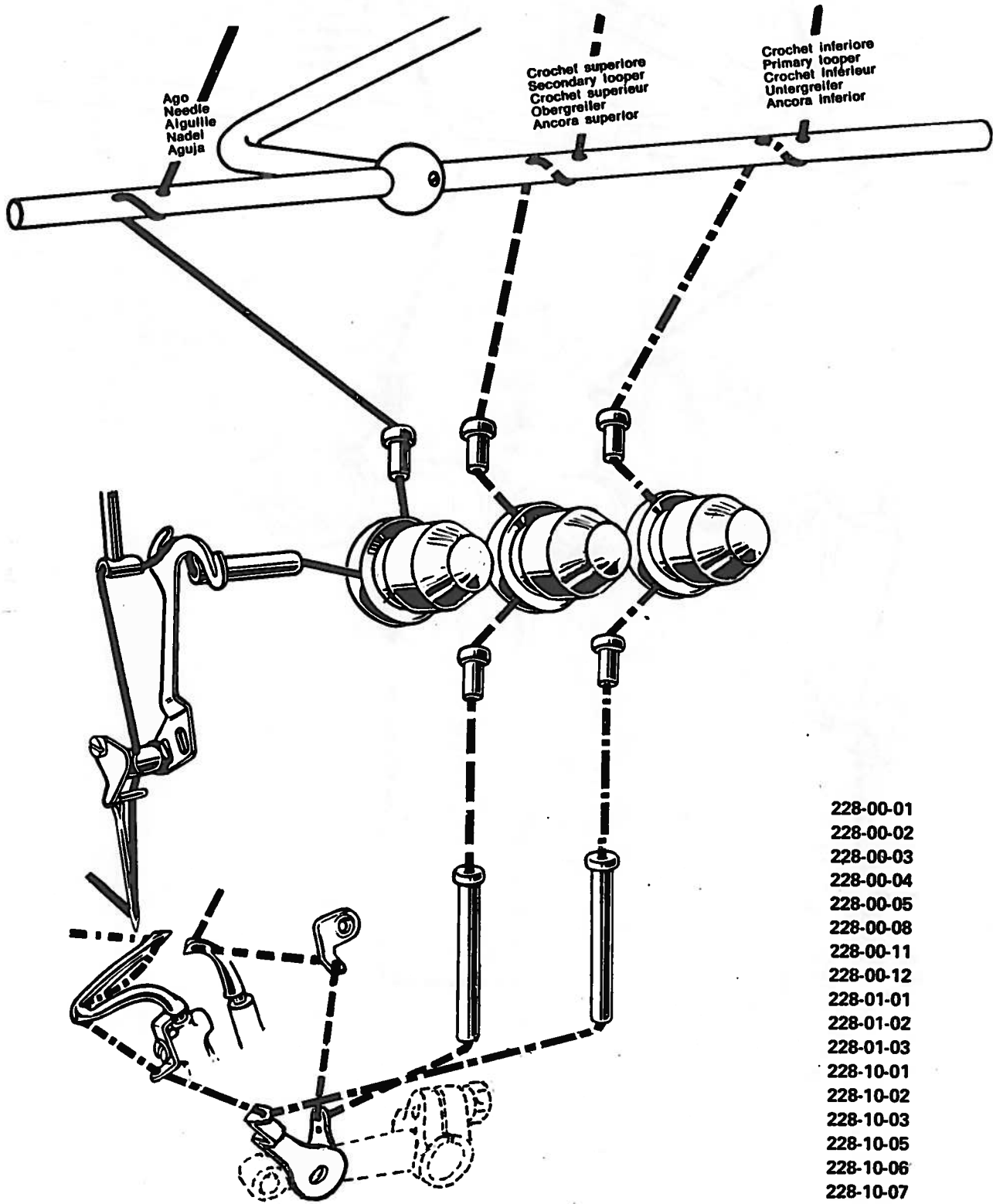
TABLE OF SETTINGS



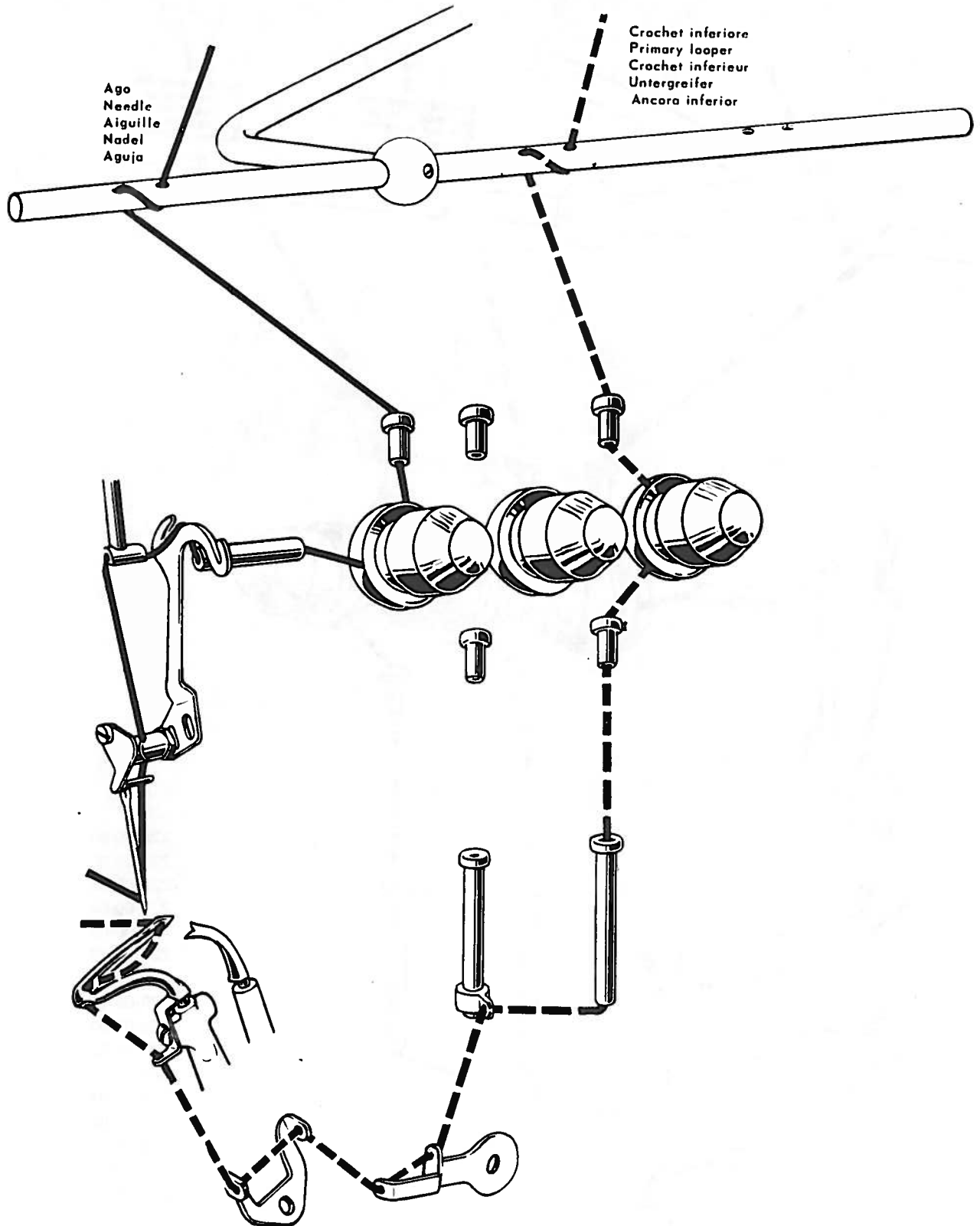
| HEAD SIMBOLS | A | B | C | D | E |
|---|---------|-----|-----|-----|-----|
| 228-00-01 = 228-00-04 = 228-00-05 = 228-00-11 = 228-00-12 = 228-01-01 = 228-01-02 = 228-01-03 = 228-10-01 = 228-10-02 = 228-10-03 = 228-10-05 = 228-10-06 = 228-10-07 = 228-28-01 = 228-28-02 = | 2,5 | 1,5 | 0,8 | 4,5 | 3,5 |
| 228-00-02 = 228-00-03 = 228-00-06 = 228-00-08 = | 2,3 | 1,5 | 0,8 | - | 5 |
| 228-00-07 = 228-28-07 = | 2,3 | 1,5 | 0,8 | 5 | - |
| 228-28-05 | 2,5-2,8 | 2,5 | 0,5 | 4 | - |

II. USE

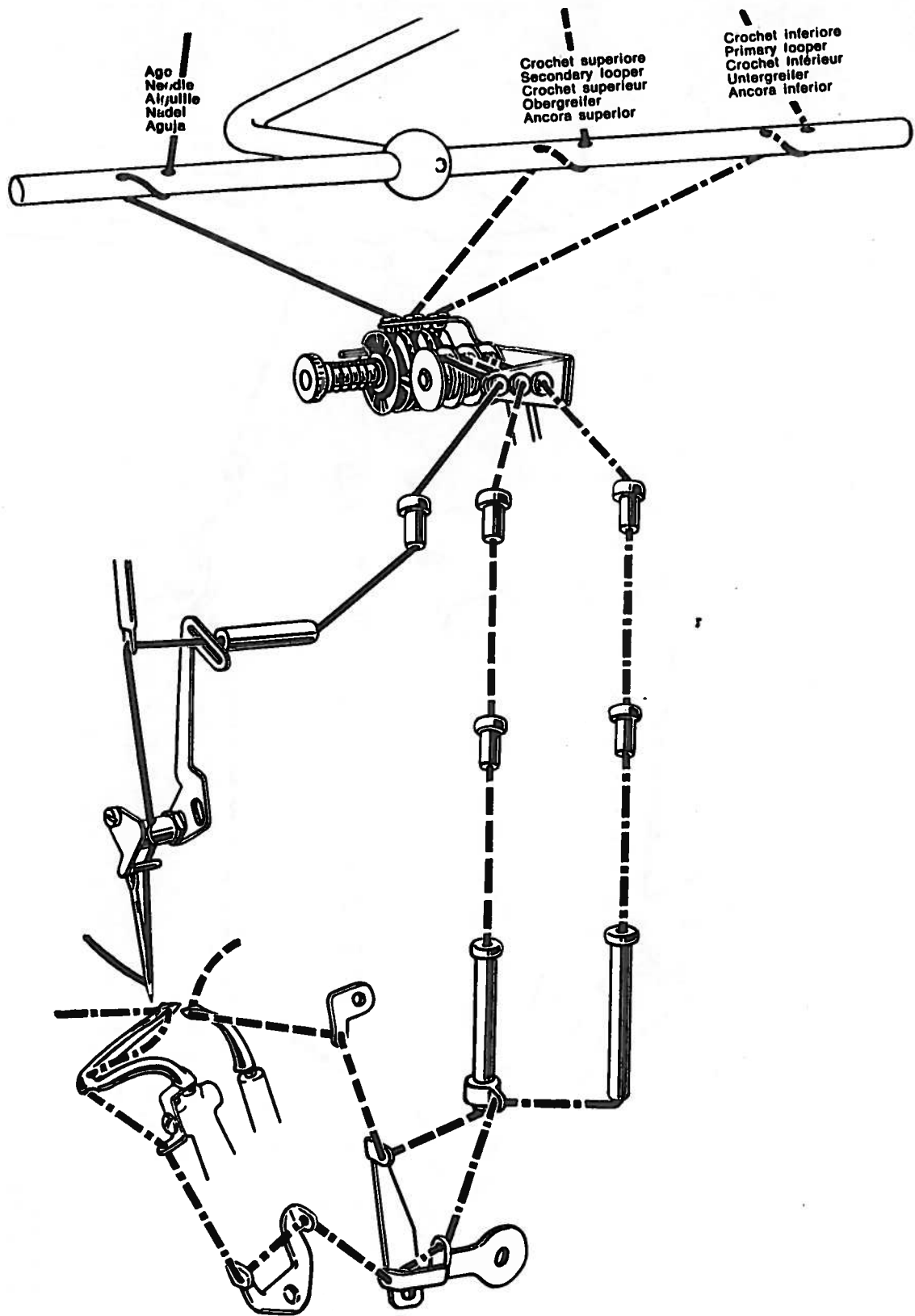
a) Threading



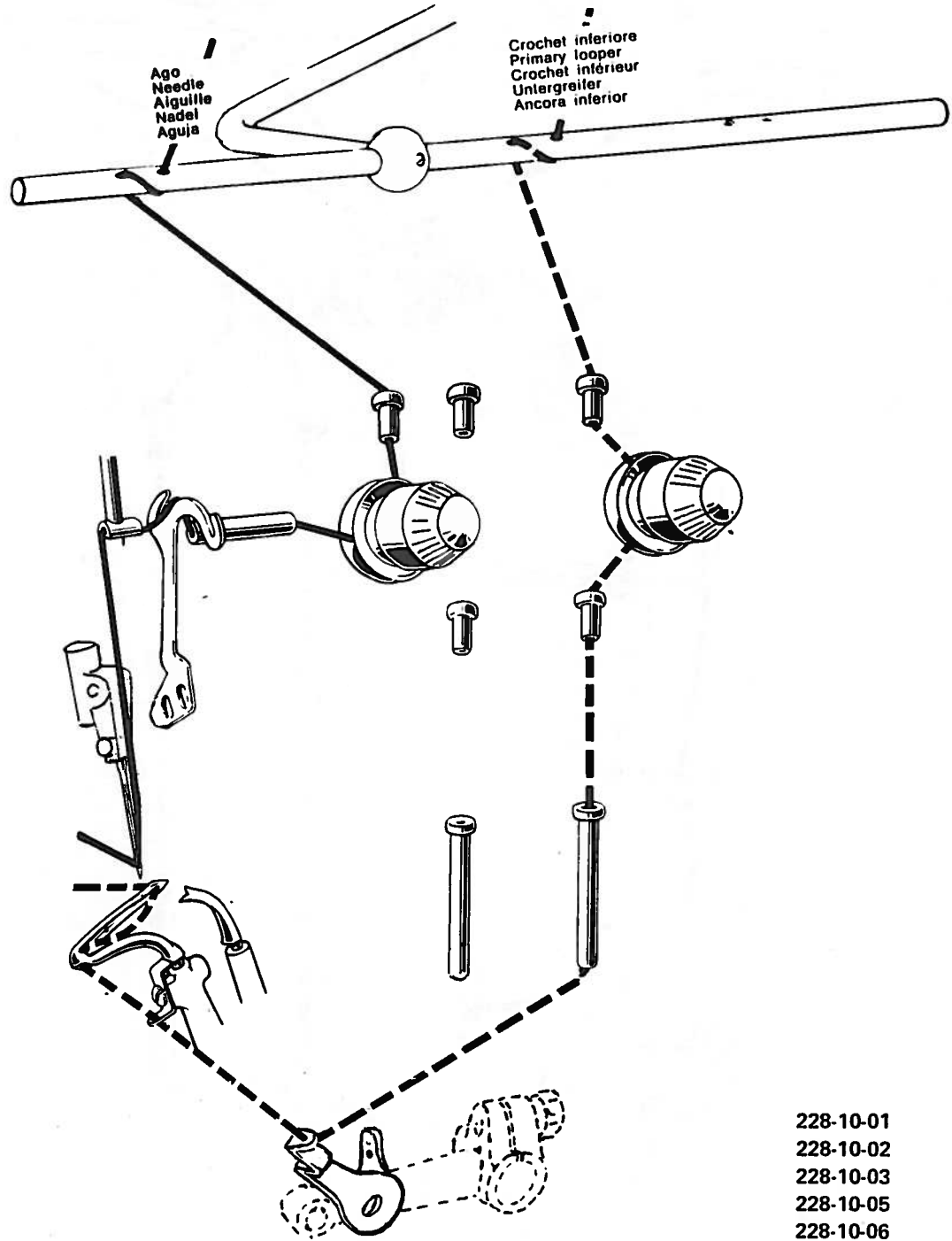
- 228-00-01
- 228-00-02
- 228-00-03
- 228-00-04
- 228-00-05
- 228-00-08
- 228-00-11
- 228-00-12
- 228-01-01
- 228-01-02
- 228-01-03
- 228-10-01
- 228-10-02
- 228-10-03
- 228-10-05
- 228-10-06
- 228-10-07
- 228-28-02
- 228-28-07



228-00-07



228-00-06



- 228-10-01
- 228-10-02
- 228-10-03
- 228-10-05
- 228-10-06
- 228-10-07
- 228-28-01
- 228-28-02
- 228-28-05

b) Changing the needle

1. Switch off the motor
2. Depress the pedal which starts the motor to ensure the machine is completely off.
3. Move the needle to top dead center.
4. Press lever B right down (fig. 19).
5. Remove the presserfoot from its working position.
6. Slacken the needle locking screw half a turn with screw driver 1161/2.
7. Remove the needle.
8. Fit new needle.
9. The notch through which the looper passes should face towards the rear, needle guard, that is towards the interior of the machine.
10. Using the tweezers supplied ensure that the needle touches the end of the needle holder.
11. Tighten the locking screw being careful not to alter the position of the needle.
12. Do not over-tighten.

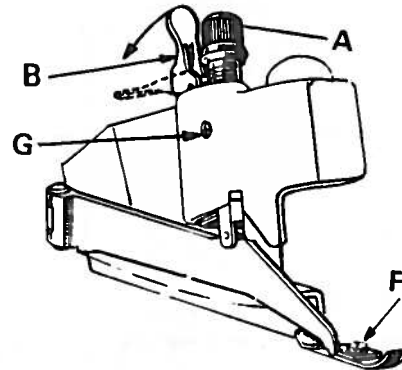


fig. 19

c) Positioning and adjusting presserfoot pressure (fig. 19).

1. Check correct positioning of presserfoot
2. The needle should pass between the presserfoot shoe and tongue.
3. To adjust presserfoot slacken off screw F.
4. Center the presserfoot in the correct position and lock F.
5. To increase or decrease the presserfoot pressure, slacken off screw G with spanner 633-742 and adjust knob A.
6. Lock knob A with screw G.

d) Tension adjustment

1. Tighten the tensioners sufficiently to permit a regular stitch formation.
2. Never tighten too much

e) Stitch length adjustment (fig. 14).

For stitch length adjustment see para. a) 9 Feed, pag. 15.

f) Adjustment of seam width.

The seam width can only be varied to a very limited extent after which the needle plate has to be changed. To vary the width within these fine limits proceed as follows:

1. Slacken off screw N in the lower knife holder (fig. 11).
2. Slacken off screw F (fig. 15).
3. Move upper knife support A (fig. 15) to right or left till desired seam width is obtained.
4. Lock screw F (fig. 15).
5. Lower knife holder re-setting should be carried out in accordance with the instructions in para. a) 7.

g) Faults due to improper handling of the machine

| n° | FAULT | PROBABLE CAUSE |
|----|----------------------------|--|
| 1 | Irregular stitch | <ul style="list-style-type: none"> - Tensioners badly adjusted - Thread take ups badly adjusted - Incorrect threading - Yarns not gauged |
| 2 | Feed and material slipping | <ul style="list-style-type: none"> - Insufficient presserfoot pressure - Bad adjustment of feed dog height and inclination - Knives need sharpening - Differential badly adjusted |
| 3 | Skip stitching | <ul style="list-style-type: none"> - Upper or lower looper badly adjusted with respect to needle consequently blunting looper. - Loopers too far apart when crossing - Loopers too close when crossing with consequent blunting. - Front needle guard too far from needle - Needle badly positioned |
| 4 | Thread breaking | <ul style="list-style-type: none"> - Tensions too tight - Thread wound irregularly on the reel |
| 5 | Needle breaking | <ul style="list-style-type: none"> - Bent needle - Needle badly fitted |
| 6 | Puncturing of material | <ul style="list-style-type: none"> - Blunt needle - Needle size not suitable to throat plate - Needle with unsuitable point |
| 7 | Loss of oil | <ul style="list-style-type: none"> - Screw holding sump to base not tightened enough - Sump plug not screwed up properly - Sump gasket badly fitted. |
| 8 | Lack of lubrication | <ul style="list-style-type: none"> - Oil level too low - Drive belt badly fitted - Upper tube clogged - Lubrication pump filter blocked. |

III. MAINTENANCE

a) Every day

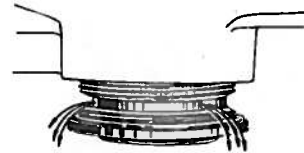
Briefly clean all machine parts relating to feed and stitch formation.

b) Every week

1. Remove needle plate and clean the feed dogs, needle guards and loopers.
2. Open front cover plate and carefully clean inside
3. Carefully clean inside the plate covering the needle movement assembly.

c) Every three months

1. Using the spanner supplied, remove the sump drain plug and drain off oil completely.
2. Remove screw 007-L 20 which attaches filter to plug.
3. Extract filter and clean by immersing in petrol.
4. Air blast filter and sump plug.
5. Soak felt with clean oil.
6. Replace sump plug.
7. Refill machine with 1 3/4 pts. of new VR. 604 oil.



IMPORTANT

fig. 19

In operation 1 para. c) do not completely remove the plug to begin with, so that most of the oil runs out through the side holes in the plug (fig. 19).

d) Knife sharpening

1. When sharpening the knives use the RIMOLDI sharpener and special block which guarantees exact sharpening angle. This block is supplied on request.

e) Instructions for removal of cam shaft

- Necessary tools supplied on request only.
- Pliers model S. 0560/00.
- Pliers model S. 0459/00.
- Extractor S. 0416/00

IMPORTANT

It is absolutely essential that the principal components of the crank-shaft/con-rod assembly are replaced in their original positions. To this aim proceed as follows:

- Replace the T flanges with the lubrication hole towards the bottom.
- Leave the screws holding the con-rod caps in their holes.
- Con-rods J and L are distinguishable one from the other by means of a 2 stamped on the top surface of L and three lines on J.
- The con-rod caps are engraved with similar markings and should be matched to the respective con-rod. Both marks should be on the same side.
- The position of con-rod N is given by the drawing number which should be on the pulley side.
- Carefully follow the cup spring assembly order.

SEQUENCE OF OPERATIONS (fig. 20).

1. Open the side cover.
2. Remove screw D.
3. Using extractor 280-715 extract the eccentrics A and B.
4. Remove con rod caps N, O, J, L.
5. Remove screw Z.
6. Remove pulley cover Y.
7. Slacken off hexagonal screw X.
8. Remove washer W.
9. Extract pulley V.
10. Remove flange T.
11. Remove spacer U.
12. Remove springs S.
13. Extract spring ring P using pliers S. 0453/00 slightly turning the shaft to the right.
14. Extract the shaft.

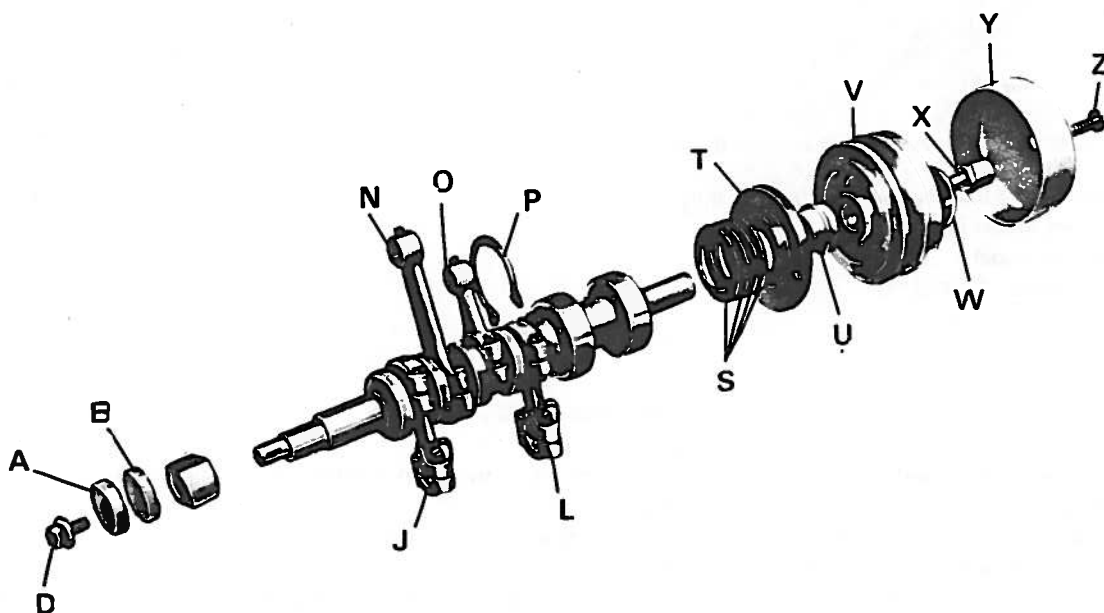


fig.20

SPARE PARTS CATALOGUE

I. HOW TO USE THIS CATALOGUE

a) Introduction

1. This spare parts catalog is made up of a series of tables illustrating the various parts or assemblies which make up the basic head and its sub-classes.
2. In order to make the use of this catalogue easier, the table index shows the position of each assembly inside the head.
3. The conversion assemblies of the basic head and its sub classes are illustrated in single tables.
4. In the tables, the numbers which identify the sub-classes are printed at top right of page in black.
5. On each table the various components of the assembly illustrated, are cross-referenced by a number. The assemblies, whose components cannot be supplied separately, are cross-referenced by a capital letter. Parts and equipment not normally with the machines but which can be supplied on request, are given at the bottom of each table and are illustrated complete with all their particulars at the end of the book.
6. The catalogue has a general numerical index giving the cross-reference numbers of all component parts of the machine and listing the table on which the parts are illustrated.

II. HOW TO ORDER SPARE PARTS

a) All parts

To ensure immediate dispatch of required spare parts, the following instructions should be carefully followed:

1. Quote the serial number of the head.
2. Quote the drawing number of the part required.
3. Give the full name of the part required.
4. The quantity.

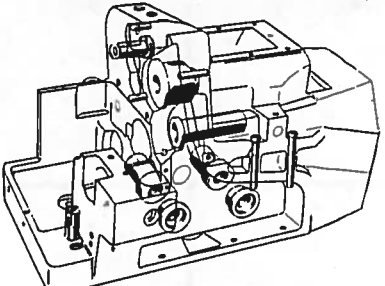
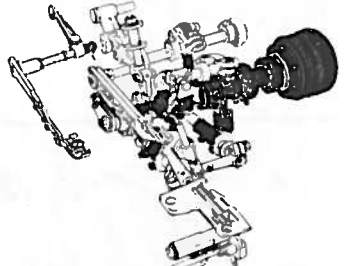
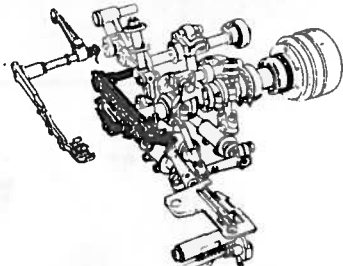
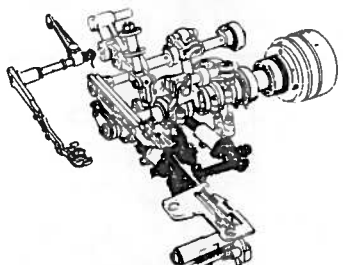
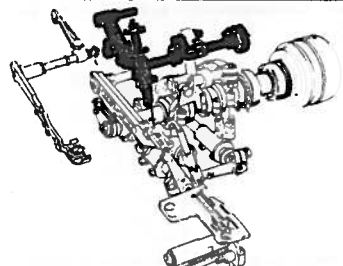
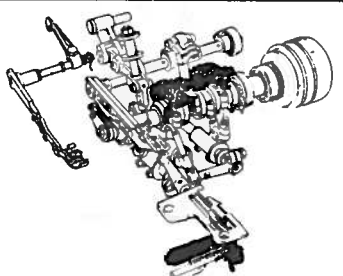
IMPORTANT

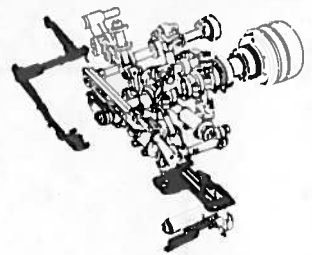



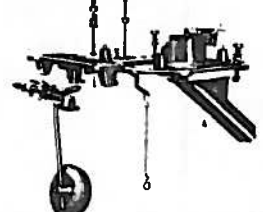


The RIMOLDI Company likes to analyse any cases of breakage, wear or irregularities arising in parts manufactured by them. For this reason they kindly ask you to return such pieces along with the order for spare parts.

b) Needles only

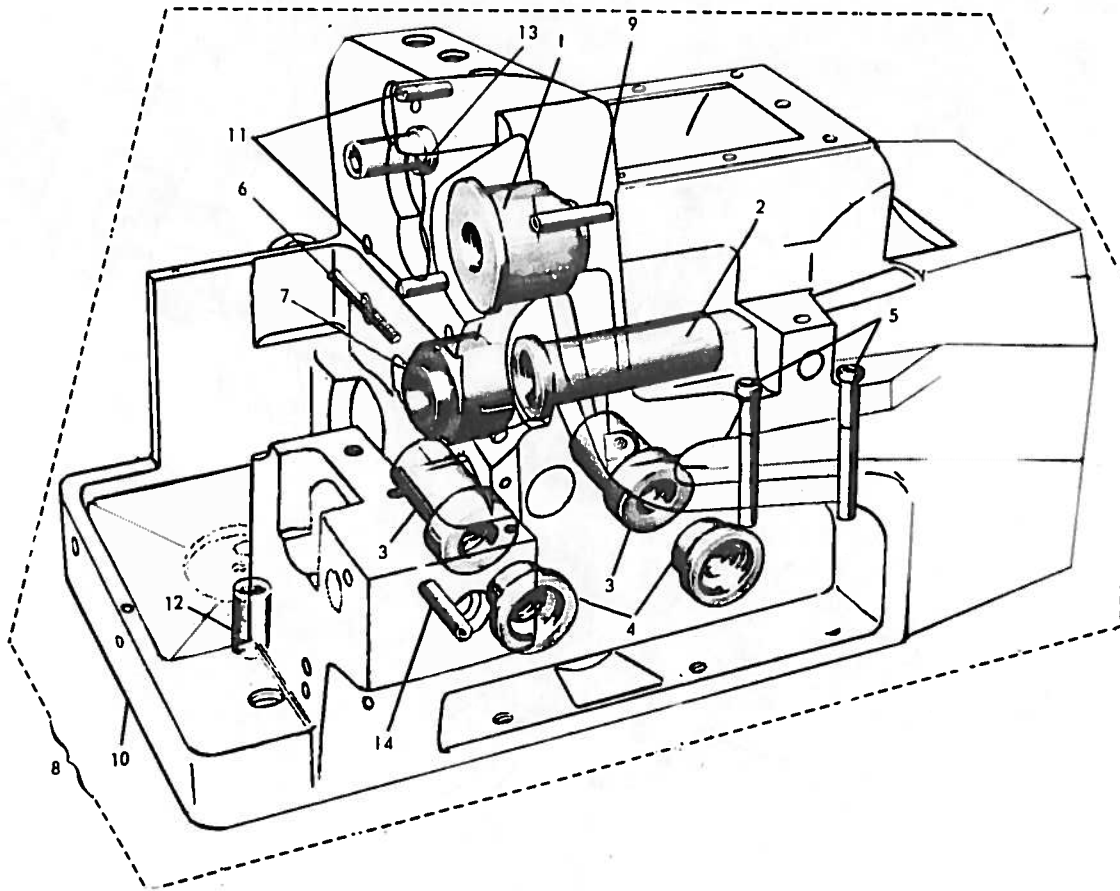
1. Only straight system **RIM 27** needles should be used on the machines illustrated in this manual.
2. The needle system and size are marked on the needle shank.
3. The size indicates the average diameter expressed in hundredths of a millimeter calculated on the blade of the needle.
4. The system and size are also shown on the packets containing RIMOLDI needles.
5. When ordering always give the system and size of the needle required (e.g. n. 100 needles size 90 system: RIM 27).
6. In case of doubt send a sample needle or an empty packet of the type required.
7. For stitching elastic or elasticised materials there are ball point needles classified **SKU**.

INDEX OF TABLES

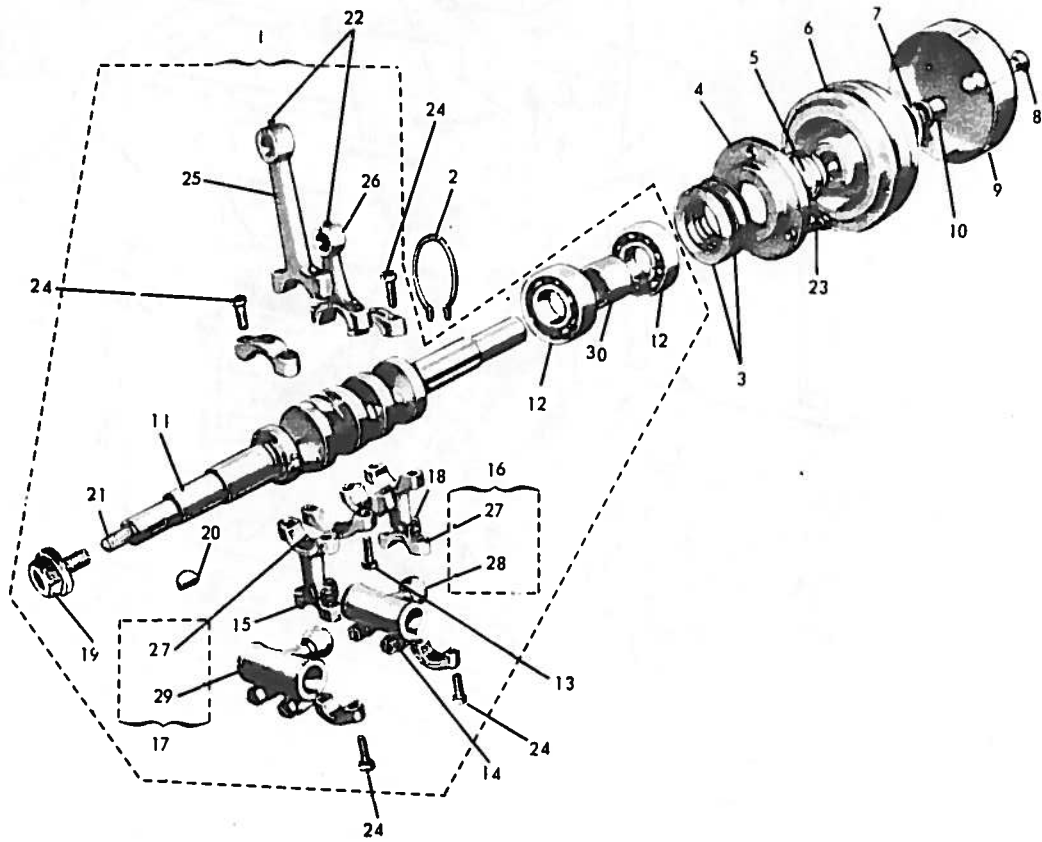
| | |
|---|--|
| BUSHES – THREAD GUIDES STUDS PRESSED INTO THE BASE | Tav. 1  |
| MAIN SHAFT WITH CON-RODS | Tav. 2  |
| DIFFERENTIAL ASSEMBLY | Tav. 3 4  |
| SHAFTS AND CON-RODS OPERATING LOOPER | Tav. 5  |
| NEEDLE DRIVE MECHANISM | Tav. 6  |
| UPPER AND LOWER KNIFE MECHANISM | Tav. 7  |

| | |
|--|--|
| <p>PRESSERFOOT LIFTING MECHANISM – NEEDLE PLATE</p> | <p>Tav. 8 9</p>  |
| <p>CASING – WORK PLATE</p> | <p>Tav. 10 11</p>  |
| <p>THREAD GUIDES AND TENSIONERS</p> | <p>Tav. 12 13</p>  |
| <p>SUMP AND OIL PUMP</p> | <p>Tav. 14</p>  |
| <p>MACHINE MOUNTING BRACKET AND KNEE CONTROL</p> | <p>Tav. 15</p>  |
| <p>REEL HOLDERS AND PEDAL</p> | <p>Tav. 16</p>  |
| <p>ACCESSORIES</p> | <p>Tav. 17</p>  |

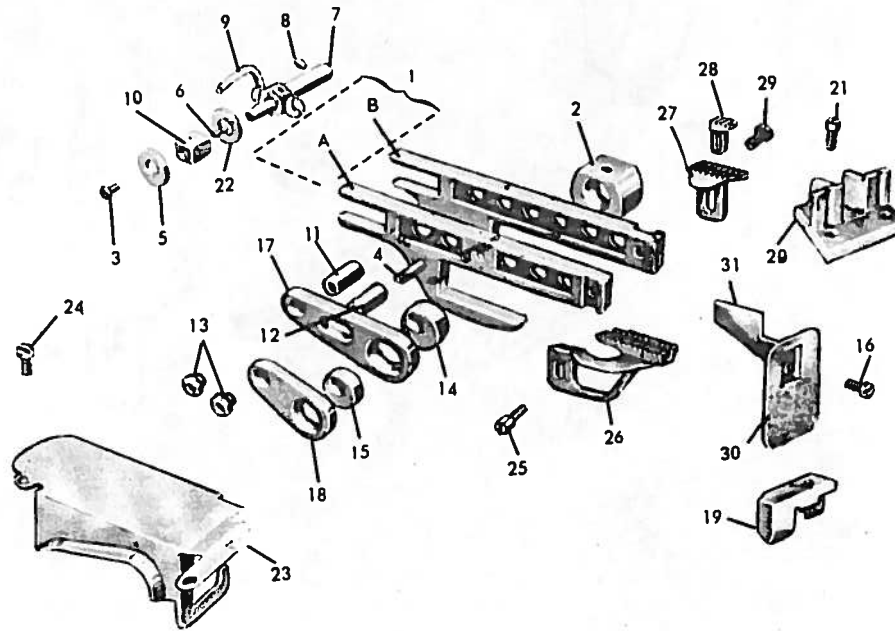
| | | | |
|----------------|---------|------------------|--------------------|
| HEAD 228-00-02 | Tab. 18 | HEAD 228-10-01 | Tab. 30 |
| " 228-00-03 | Tab. 19 | " 228-10-02 | Tab. 31 |
| " 228-00-04 | Tab. 20 | " 228-10-03 | Tab. 32 |
| " 228-00-05 | Tab. 21 | " 228-10-05 | Tab. 33 |
| " 228-00-06 | Tab. 22 | " 228-10-06 | Tab. 34 |
| " 228-00-07 | Tab. 23 | " 228-10-07 | Tab. 35 |
| " 228-00-08 | Tab. 24 | " 228-28-01 | Tab. 36 |
| " 228-00-11 | Tab. 25 | " 228-28-02 | Tab. 37 |
| " 228-00-12 | Tab. 26 | " 228-28-07 | Tab. 38 |
| " 228-01-01 | Tab. 27 | TABLE W1 (100) | Tab. 39 Tab. 40 |
| " 228-01-02 | Tab. 28 | TABLE X1 (101) | Tab. 41 |
| " 228-01-03 | Tab. 29 | PARTS ON REQUEST | Tab. 42 Tab. 43 |



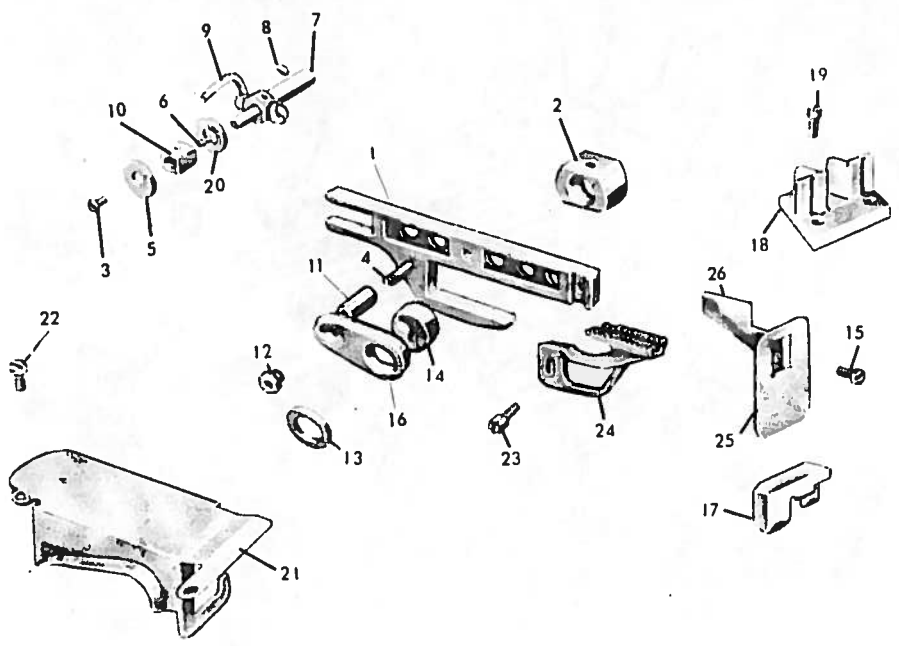
| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|-------------|----------------------------------|--------|---------|-------------|------------------------------------|--------|
| 1 | 270-016 | bush, shaft | 1 | 9 | 270-264 | thread guide needle | 1 |
| 2 | 202125-0-11 | bush knife holder | 1 | 10 | 204107-0-11 | base machine | 1 |
| 3 | 270-058/2 | bush rear | 2 | 11 | 270-642 | studs cover centering | 2 |
| 4 | 270-057/1 | bush front | 2 | 12 | 280-830 | tube oil | 1 |
| 5 | 270-268 | tubes thread guide | 2 | 13 | 270-082/1 | bush presserfoot lift | 1 |
| 6 | 270-938 | bolt bush | 1 | 14 | 270-917 | locking pin presserfoot work plate | 1 |
| 7 | 280-010/3 | bush main shaft | 1 | | | | |
| 8 | 204109-3-11 | base with bush and thread guides | 1 | | | | |



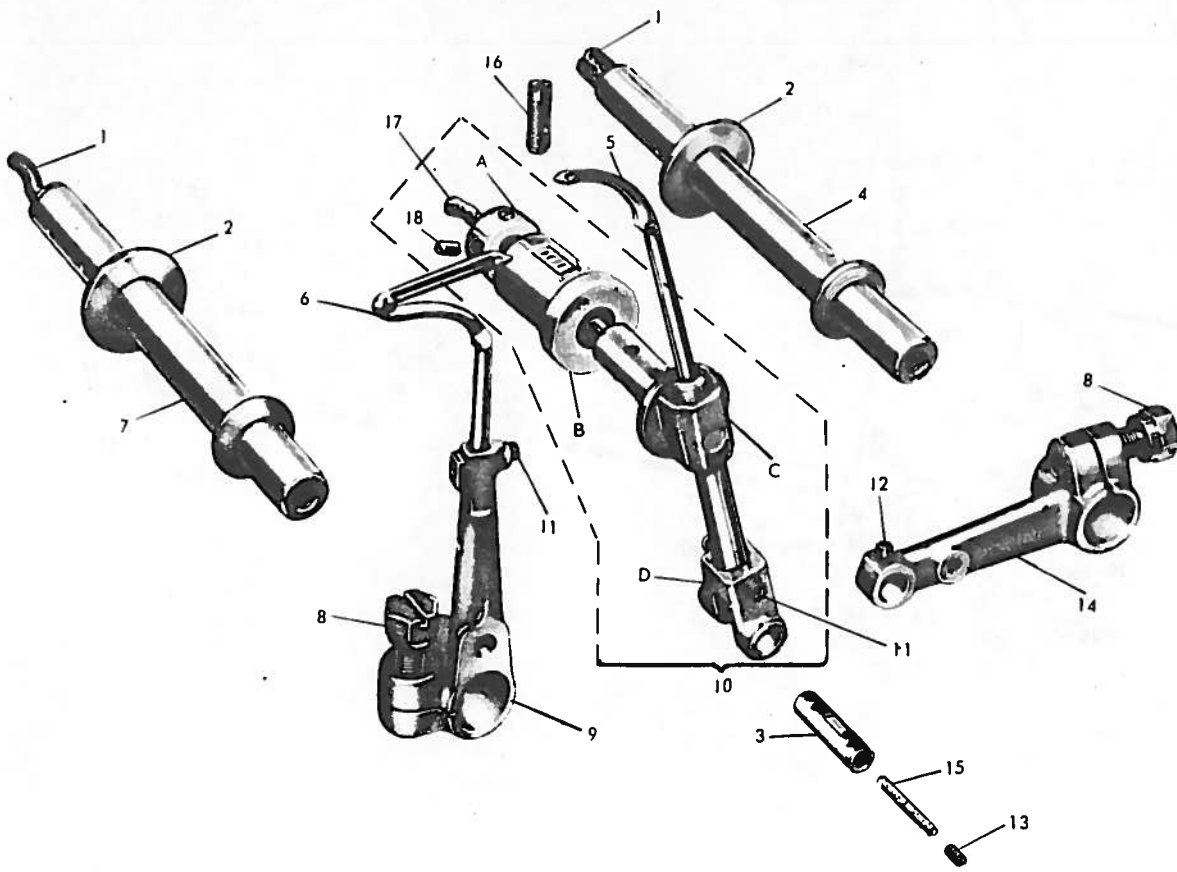
| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|--------------|--|--------|--------------------|-----------------------|----------------------------|--------|
| 1 | PM.280.009/4 | main shaft complete | 1 | 17 | PM.270-059/1 | con-rod with coupling | 1 |
| 2 | 270-704 | seeger ring for right bearing | 1 | 18 | 270-062 | guide con-rod | 2 |
| 3 | 270-705 | spring | 4 | 19 | 280-925/1 | bolt eccentric locking | 1 |
| 4 | 270-620 | flange right side | 1 | 20 | 280-019 | woodruff key | 1 |
| 5 | 270-614 | spacer right | 1 | 21 | 032-D-26 | wick for shaft | 1 |
| 6 | 270-008/1 | pulley | 1 | 22 | 023-N-5,5 | screw gudgeon pin locating | 2 |
| 7 | 270-612/1 | washer with guide | 1 | 23 | 001-E-10 | bolt flange | 3 |
| 8 | 270-981 | bolt pulley fixing | 1 | 24 | 010-D-11,5 | bolt for looper con-rod | 8 |
| 9 | 128-608/5 | cover pulley | 1 | 25 | 280-012/3 | con-rod needle bar | 1 |
| 10 | 270-610 | stud pulley | 1 | 26 | 270-116/2 | con-rod knife shaft | 1 |
| 11 | 280-009/4 | main shaft | 1 | 27 | 270-061/2 | con-rod upper looper | 2 |
| 12 | 270-707 | ball bearing right | 2 | 28 | 270-060/1 | coupling con-rod | 1 |
| 13 | 010-H-13,7 | bolt for con-rod 280-012/3 and 270-116/2 | 4 | 29 | 270-059/1 | coupling con-rod | 1 |
| 14 | 270-975 | bolt coupling | 4 | 30 | 270-613 | spacer bearing | 1 |
| 15 | 290-944 | screw guide fixing | 2 | | | | |
| 16 | PM.270-060/1 | con-rod with coupling | 1 | | | | |
| | | | | FOR HEAD 228 28-05 | | | |
| | | | 1 | PM286 B-003.3 | main shaft complete | | 1 |
| | | | 11 | 280-009/3 | main shaft | | 1 |
| | | | 17 | PM270-060/1 | con-rod with coupling | | 1 |
| | | | 29 | 270-060.1 | coupling con-rod | | 1 |



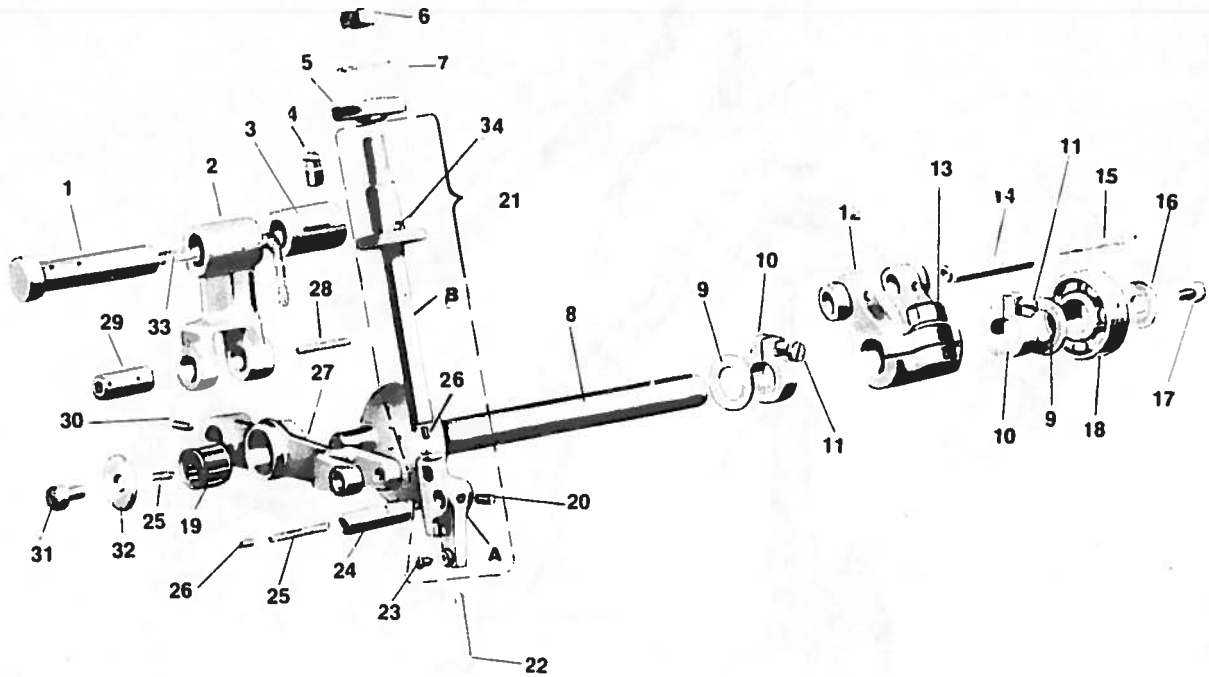
| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|--------------|-------------------------------------|--------|---------|-----------|------------------------------------|--------|
| 1 | PM.280-049/1 | slide differential | 1 | 18 | 280-033/1 | connector slide | 1 |
| 2 | 280-511/1 | block sliding | 1 | 19 | 280-253 | gasket | 1 |
| 3 | 026-C-7 | screw countersunk | 1 | 20 | 270-640/3 | guide block | 1 |
| 4 | 280-023 | bolt for feed dog holder | 2 | 21 | 005-L-11 | screw guide block fixing | 2 |
| 5 | 270-935 | washer | 3 | 22 | 071-H-5 | washer | 1 |
| 6 | 092-B-1 | wick | 1 | 23 | 280-207/2 | guard oil | 1 |
| 7 | 270-039 | eccentric shaft for differential | 1 | 24 | 026-C-7 | screw oil guard fixing | 2 |
| 8 | 270-937/1 | screw shaft fixing | 1 | 25 | 270-978 | screw differential feed dog fixing | 1 |
| 9 | 092-D-11 | wick | 2 | 26 | 270-050 | feed dog differential | 1 |
| 10 | 270-036/1 | block sliding | 1 | 27 | 280-051 | feed dog subsidiary | 1 |
| 11 | 280-035 | bushing joint | 1 | 28 | 270-052 | feed dog chaining | 1 |
| 12 | 280-034 | bushing joint | 1 | 29 | 270-977 | screw subsidiary feed dog fixing | 1 |
| 13 | 280-926 | nut slide | 2 | 30 | 270-250/2 | shield rubber | 1 |
| 14 | 280-0451/10 | eccentric for subsidiary feed dog | 1 | 31 | 270-249/1 | shield | 1 |
| 15 | 280-0451/9 | eccentric for differential feed dog | 1 | A | 280-049/1 | slide main feed dog | 1 |
| 16 | 004-L-7 | screw shield fixing | 2 | B | 280-043/1 | slide subsidiary feed dog | 1 |
| 17 | 280-048/1 | connector slide | 1 | | | | |
| | | | | | | On request: 280-0511 | |
| | | | | | | Tab. 38 | |



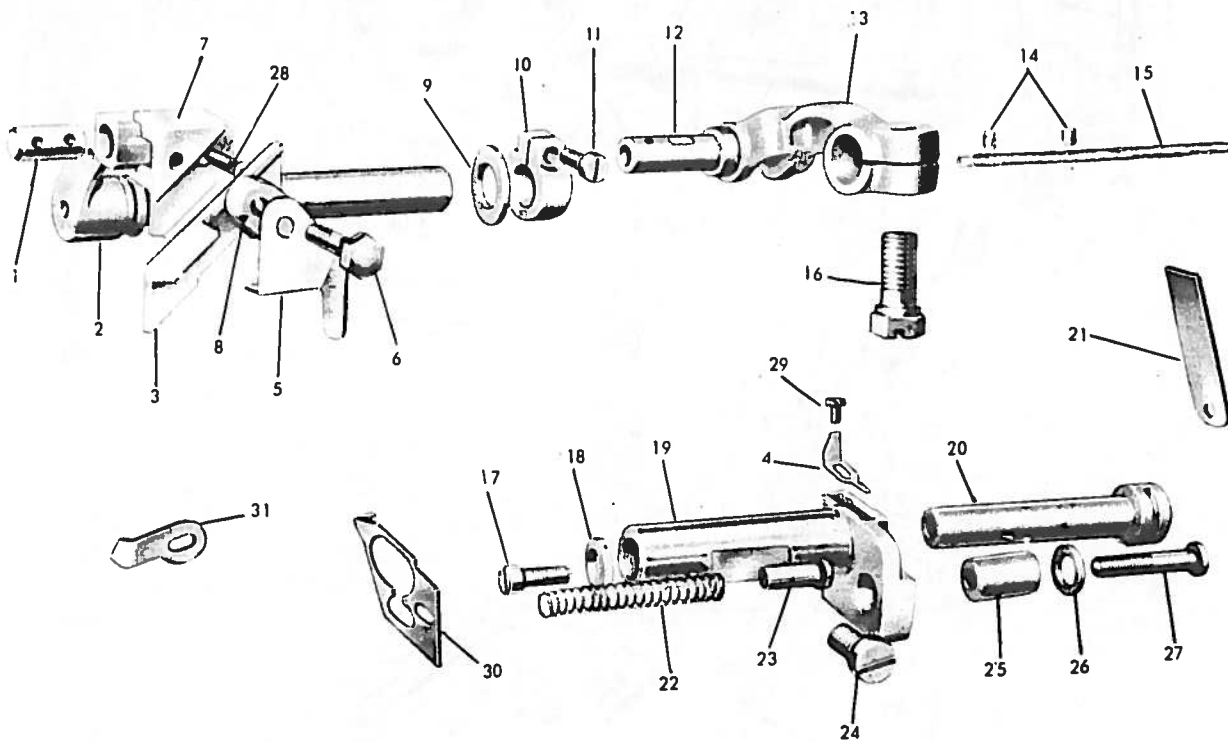
| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|----------------|----------------------------------|--------|---------|--------------|--------------------------|--------|
| 1 | PM 286B-049, 1 | slide differential | 1 | 14 | 280-04561, 5 | eccentric for feed dog | 5 |
| 2 | 286 B-611/1 | block sliding | 1 | 15 | 004 L-7 | screw shield fixing | 2 |
| 3 | 026 C-7 | screw countersunk | 1 | 16 | 280-033, 1 | connector slide | 1 |
| 4 | 280-023 | bolt for feed dog holder | 1 | 17 | 286 B-253 | gasket | 1 |
| 5 | 270-935 | washer | 2 | 18 | 276 B-640, 3 | guide block | 3 |
| 6 | 292 B-1 | wick | 1 | 19 | 005 L-11 | screw guide block fixing | 2 |
| 7 | 270-039 | eccentric shaft for differential | 1 | 20 | 276 B-951, 1 | washer | 1 |
| 8 | 270-937/1 | screw shaft fixing | 1 | 21 | 286 B-207 | guard oil | 1 |
| 9 | 092 D-11 | wick | 2 | 22 | 026 C-7 | screw oil guard fixing | 2 |
| 10 | 276 B-036, 1 | block sliding | 1 | 23 | 270-978 | screw feed dog fixing | 1 |
| 11 | 286 B-034 | bushing joint | 1 | 24 | 286 D-050, 1 | feed dog | 1 |
| 12 | 280-926 | nut slide | 1 | 25 | 276 B-250, 1 | shield rubber | 1 |
| 13 | 286 B-055 | spacer | 1 | 26 | 270-249/1 | shield | 1 |



| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|-------------|--|--------|---------|-------------|---------------------|---|
| 1 | 092-D-16 | wick looper shaft | | 2 | 11 | 270-974/1 | screw looper fixing |
| 2 | 073-N-10 | washer for looper shaft | | 2 | 12 | 016-B-4 | fixing screw for upper looper |
| 3 | 270-070 | gudgeon pin upper looper lever | | 1 | 13 | 016-B-2,5 | grub screw gudgeon pin |
| 4 | 270-064 | shaft upper looper | | 1 | 14 | 270-067 | lever upper looper |
| 5 | 27277-074 | upper looper with small eye | | 1 | 15 | 092-B-1 | gudgeon pin wick |
| 6 | 270-075/2 | lower looper with small eye for cotton | | 1 | 16 | 017-F-11 | screw bush fixing |
| 7 | 270-069 | shaft lower looper | | 2 | 17 | 092-D-7 | wick |
| 8 | 250-471 | bolt looper lever | | 1 | 18 | 016-B-3 | grub screw |
| 9 | 270-068/3 | holder lower looper | | 1 | A | 270-053 | ring play adjustment |
| 10 | G.270-065/3 | guide oscillating with screw bush | | 1 | B | 270-056/2 | bush adjustable |
| | | | | | C | 270-065/3 | guide oscillating |
| | | | | | D | 270-063/2 | holder upper looper |
| | | | | | | | On request: loopers shown in tab. 38 27.277-0745 270-D-074/1 270-075 |
| | | | | | | | FOR HEAD 228-28-05 |
| | | | | 5 | 270 D-074/1 | upper looper, blind | 1 |
| | | | | 6 | 270-075 | lower looper | 1 |

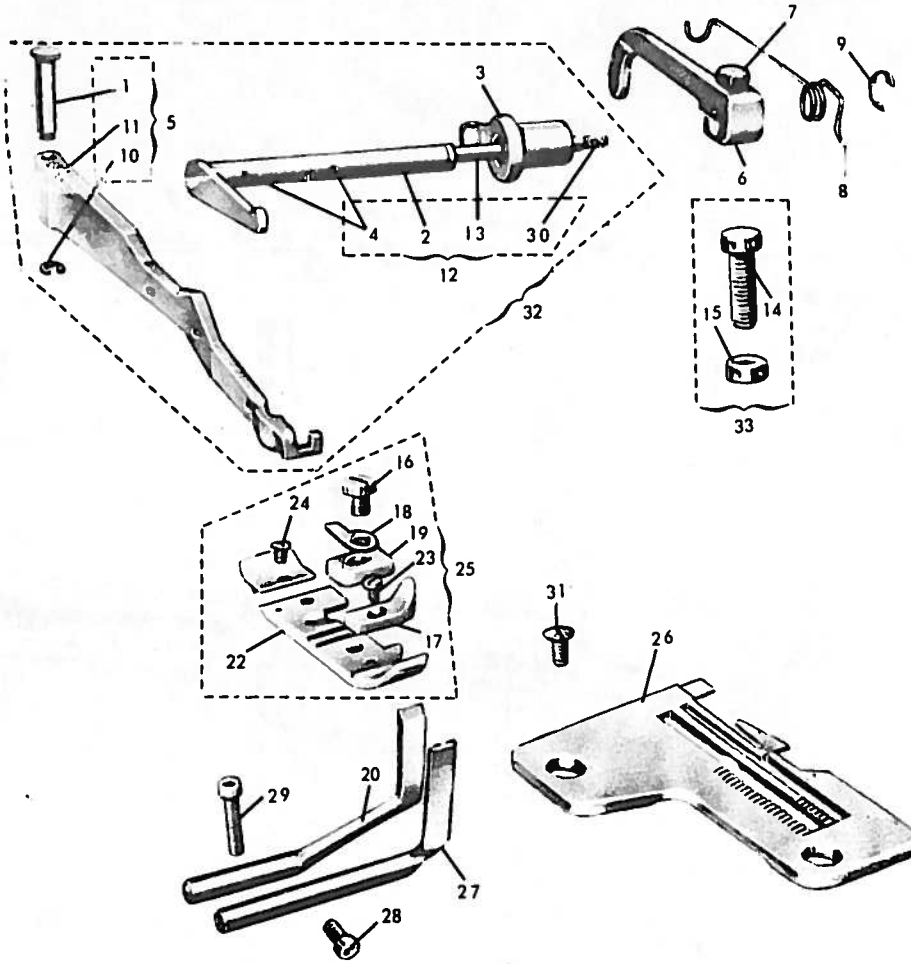


| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|--------------|--------------------------------|--------|--------------------|--------------|---|--------|
| 1 | PM.270-138/1 | shaft for fork lever | 1 | 19 | 250-708/1 | cage, roller bearing for needle drive lever | 1 |
| 2 | PM.270-137/1 | fork lever | 1 | 20 | 016-B-2.5 | screw gudgeon pin fixing | 1 |
| 3 | 270-132/1 | bush for fork lever | 1 | 21 | G.270-025/2 | assembly needle bar | 1 |
| 4 | 270-728/1 | screw bush fixing | 1 | 22 | RIM. 27 | needle | 1 |
| 5 | 290-027/1 | ring for needle guide bar | 1 | A | 270-020/1 | clamp needle holder | 1 |
| 6 | 270-933 | nut for guide bar | 1 | B | 290-025/1 | needle bar | 1 |
| 7 | 270-713 | spring washer | 1 | 23 | 003-A-4.5 | screw retaining needle | 1 |
| 8 | 270-006/1 | shaft operating slide lever | 1 | 24 | 270-130 | gudgeon pin clamp | 1 |
| 9 | 073-F-9 | washer for upper shaft | 2 | 25 | 092-B-1 | wick gudgeon pin | 2 |
| 10 | 270-719 | collar for upper shaft | 2 | 25 | 016-A-2.5 | screw needle bar wick retaining | 2 |
| 11 | 007-C-11 | screw collar | 2 | 27 | 270-135 | bar slide drive | 1 |
| 12 | 270-007/1 | attachment shaft | 1 | 28 | 092-D-5 | wick gudgeon pin | 1 |
| 13 | 270-975/1 | attachment screw for 270-007/1 | 1 | 29 | 270-133/1 | gudgeon pin fork lever | 1 |
| 14 | 270-031/1 | gudgeon pin for attachment | 1 | 30 | 023-N-5.5 | grub screw fixing needle bar drive lever | 1 |
| 15 | 092-D-6 | wick gudgeon pin | 1 | 31 | 001-E-7 | bolt upper shaft end | 1 |
| 16 | 071-E-5 | washer for upper shaft | 1 | 32 | 270-131 | washer shim | 1 |
| 17 | 001-G-10 | bolt washer holding | 1 | 33 | 092-D-11 | wick for shaft | 1 |
| 18 | 270-708 | bearing for upper shaft | 1 | 34 | 092-A-10 | wick | 1 |
| | | | | FOR HEAD 228-28-05 | | | |
| | | | | 21 | G27.77-025/2 | assembly needle bar | 1 |
| | | | | A | 27.77-020 | clamp needle holder | 1 |

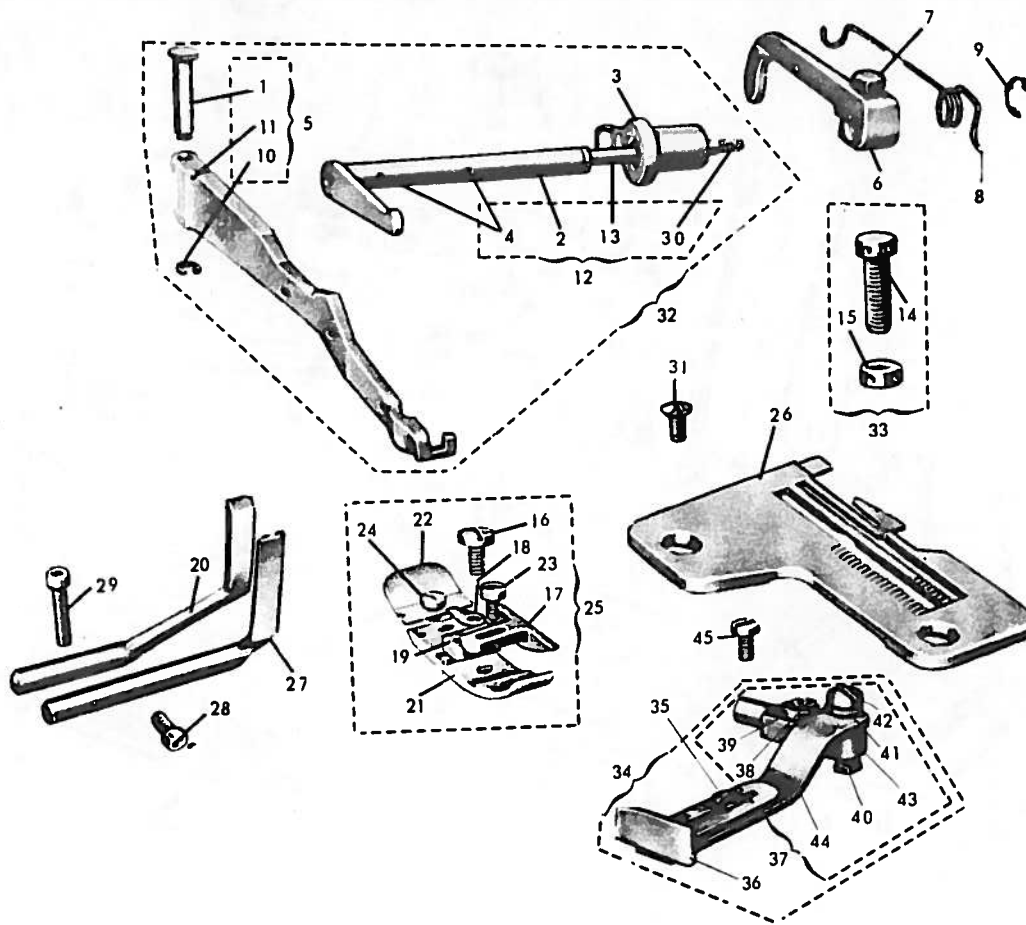


| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|-----------|----------------------------------|--------|---------|-----------|------------------------------------|---------|
| 1 | 270-102 | pin for upper knife holder | 1 | 16 | 250-471 | bolt for upper knife driving lever | 1 |
| 2 | 270-096/1 | holder upper knife | 1 | 17 | 007-P-10 | screw lower knife fixing | 1 |
| 3 | 270-112 | knife upper serrated | 1 | 18 | 071-D-5 | washer lower knife shaft | 1 |
| 4 | 2777-228 | guard | 1 | 19 | 270-104 | holder lower knife | 1 |
| 5 | 128-111 | guard upper knife | 1 | 20 | 270-105 | shaft lower knife holder | 1 |
| 6 | 270-987 | bolt upper knife fixing | 1 | 21 | 270-113/1 | knife lower | 1 |
| 7 | 270-099 | block upper knife holding | 1 | 22 | 270-100 | spring lower knife | 1 |
| 8 | 270-103 | snug upper knife locking | 1 | 23 | 270-106 | pin for lower knife holder | 1 |
| 9 | 073-F-9 | washer for upper knife holder | 1 | 24 | 003-L-12 | bolt knife holder fixing | 1 |
| 10 | 270-719 | lock ring for upper knife holder | 1 | 25 | 270-101 | bush support guide | 1 |
| 11 | 007-C-11 | screw lock ring | 1 | 26 | 070-F-4 | washer bush | 1 |
| 12 | 270-108/1 | gudgeon pin for attaching fork | 1 | 27 | 270-877 | bush support guide | 1 |
| 13 | 270-098 | coupling fork | 1 | 28 | 028-B-5 | bolt for lower knife bush | 1 |
| 14 | 092-C-2 | wicks gudgeon pin | 2 | 29 | 004-A-5 | bolt for upper knife holder | 1 |
| 15 | 092-D-9 | wick knife holder | 1 | 30 | 27.77-227 | screw guard fixing | 1 |
| | | | | | | stop-plate rear needle guard | 1 |
| | | | | | | On request: | |
| | | | | | | 270.112/2 | Tab. 39 |
| | | | | | | 270.113/2 | " 39 |
| | | | | | | FOR HEAD 228-28-05 | |
| | | | | 3 | 276 B-112 | knife upper serrated | 1 |
| | | | | 21 | 277-113 | knife lower | 1 |
| | | | | 31 | 128-110 | waste trimming shield | 1 |

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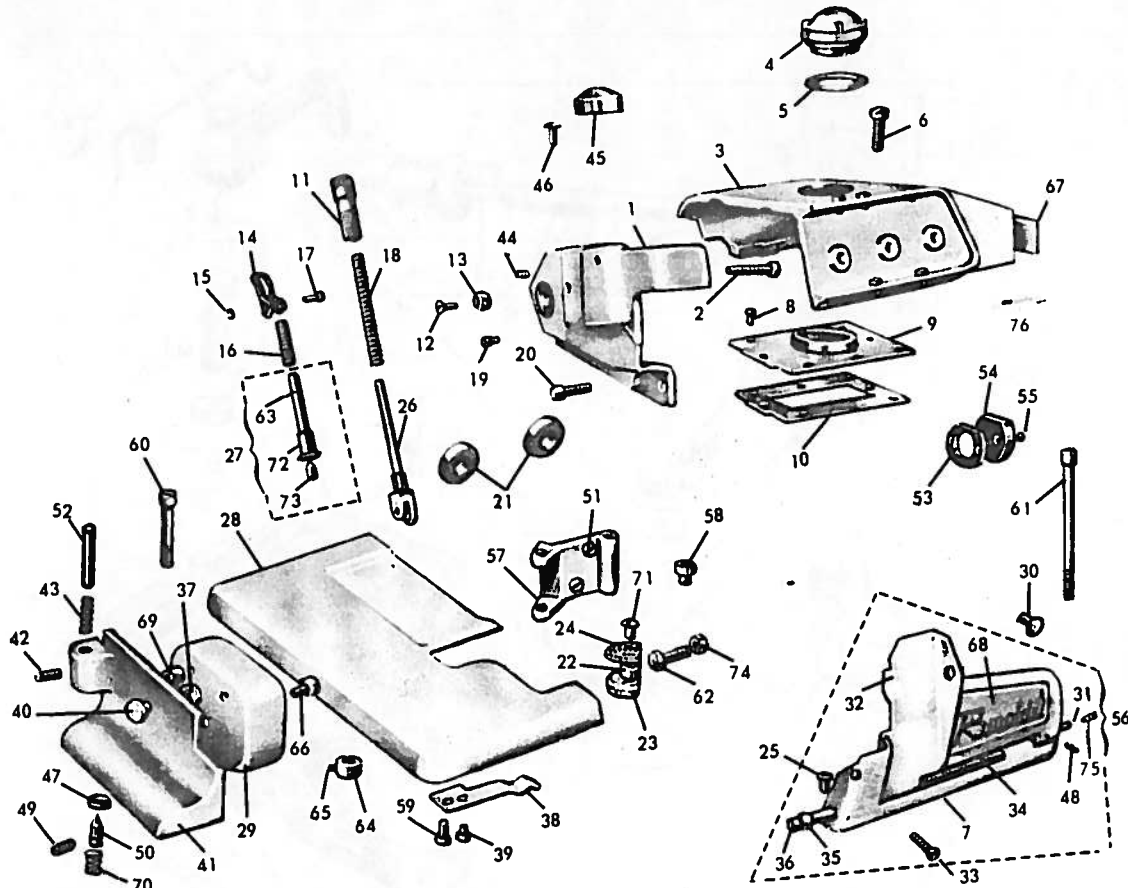


| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|--------------|--------------------------------------|--------|---------|--------------|--------------------------------|--------|
| 1 | 270-077 | pin for presserfoot holder lever | 1 | 18 | 270-196 | locator | 1 |
| 2 | 270-081/1 | shaft of presserfoot raising lever | 1 | 19 | 270-191 | bracket presserfoot fixing | 1 |
| 3 | 270-083 | bush for raisable lever | 1 | 20 | 270-103/1 | rear needle guard | 1 |
| 4 | 092-C-2 | wick | 4 | 21 | 270-184 | shoe presserfoot | 1 |
| 5 | PM.270-076/2 | assembly presserfoot holding lever | 1 | 22 | 270-185 | plate chain guide | 1 |
| 6 | 270-087/1 | lever presserfoot raising | 1 | 23 | 270-989 | screw block | 1 |
| 7 | 270-985 | screw for presserfoot raising lever | 1 | 24 | 001-A-3,2 | screw plate | 1 |
| 8 | 270-089/1 | spring for presserfoot raising lever | 1 | 25 | G.270-181 | assembly presserfoot | 1 |
| 9 | 270-714 | snap ring | 1 | 26 | 270-1141 | needle plate, fine seam | 1 |
| 10 | 270-701 | snap ring | 1 | 27 | 270-107/1 | front needle guard | 1 |
| 11 | 270-076/2 | lever, presserfoot holding, raisable | 1 | 28 | 270-936/2 | bolt fixing front needle guard | 1 |
| 12 | PM.270-081/1 | shaft | 1 | 29 | 270-934/2 | bolt fixing rear needle guard | 1 |
| 13 | 270-073 | pipe | 1 | 30 | 092-D-11 | wick shaft | 1 |
| 14 | 270-085/1 | pin adjusting | 1 | 31 | 032-L-10,5 | screw fixing needle plate | 2 |
| 15 | 270-091 | nut | 1 | 32 | G.270-076/2 | assembly raisable lever | 1 |
| 16 | 004-L-7 | bolt presserfoot tongue | 1 | 33 | PM.270-085/1 | pin adjusting | 1 |
| 17 | 270-183 | block | 1 | | | | |
| | | | | | | On request: | |
| | | | | | | PM.270-188? | Tab 38 |
| | | | | | | G.274-401 | " 3 |
| | | | | | | G.270-1812 | " 38 |
| | | | | | | 270-114 | " 38 |
| | | | | | | 270-1142 | " 38 |
| | | | | | | 270-1143 | " 38 |
| | | | | | | 270-188 | " 35 |
| | | | | | | 001-A-4,3 | " 35 |
| | | | | | | 270-401 | " 38 |

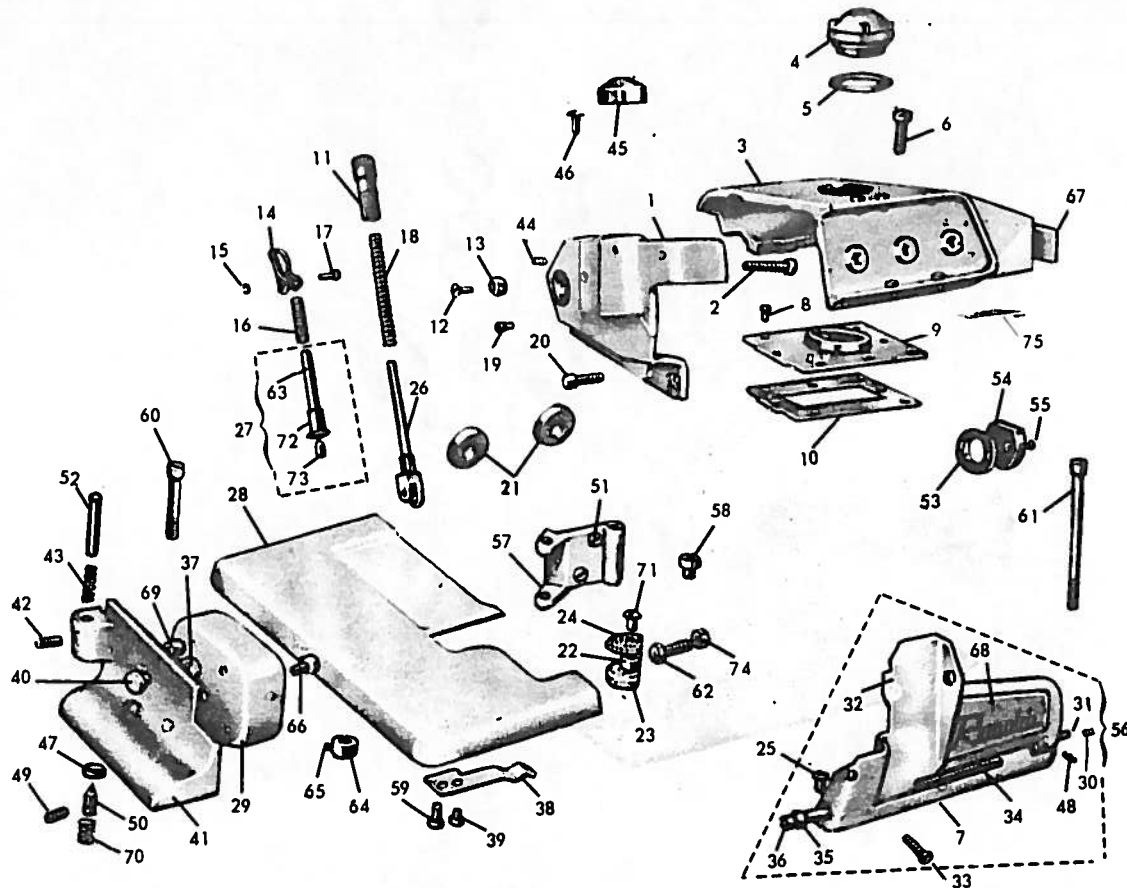


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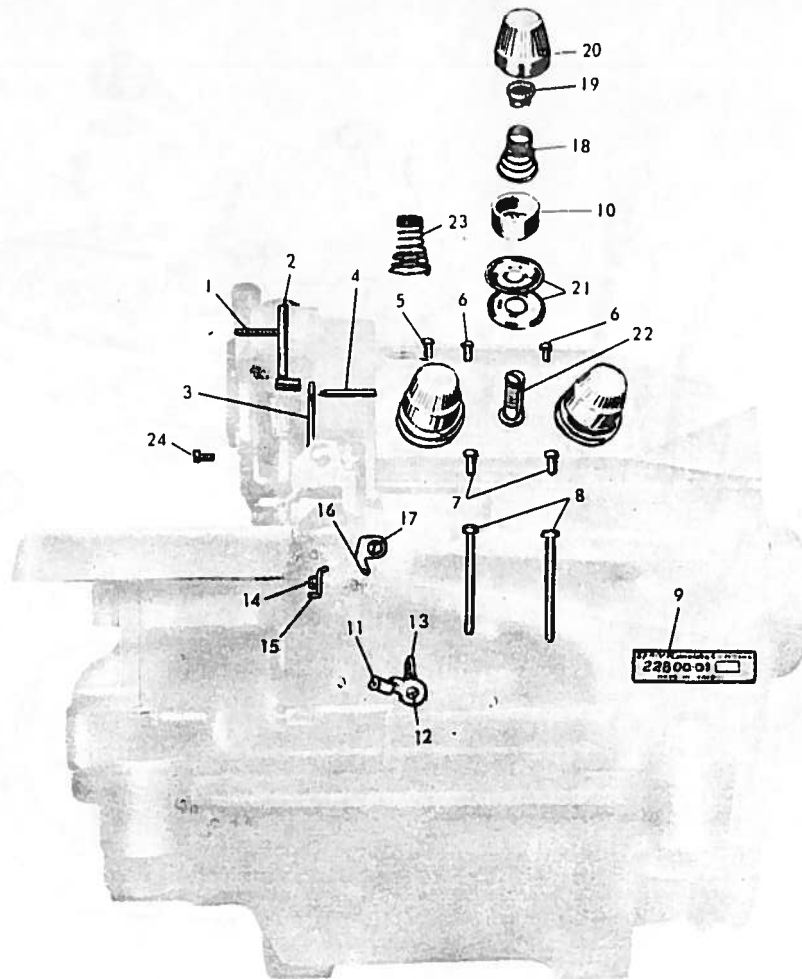
| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|-----------------|--------------------------------------|--------|---------|---------------|--------------------------------|--------|
| 1 | 270-077 | pin for presserfoot holder lever | 1 | 24 | 001 A-3,2 | screw plate | 1 |
| 2 | 270-081/1 | shaft of presserfoot raising lever | 1 | 25 | G276 B-181 | assembly presserfoot | 1 |
| 3 | 270-083 | bush for raisable lever | 1 | 26 | 276 D-114/1 | needle plate, fine seam | 1 |
| 4 | 092 C-2 | wick | 4 | 27 | 27.77-107/1 | front needle guard | 1 |
| 5 | PM 28.778-076/1 | assembly presserfoot holding lever | 1 | 28 | 270-936/2 | bolt fixing front needle guard | 1 |
| 6 | 270-087/1 | lever presserfoot raising | 1 | 29 | 270-934/2 | bolt fixing rear needle guard | 1 |
| 7 | 270-985 | screw for presserfoot raising lever | 1 | 30 | 092 D-11 | wick shaft | 1 |
| 8 | 270-089/1 | spring for presserfoot raising lever | 1 | 31 | 032 L-10,5 | screw fixing needle plate | 1 |
| 9 | 270-714 | snap ring | 1 | 32 | G28.778-076/1 | assembly raisable lever | 1 |
| 10 | 270-701 | snap ring | 1 | 33 | PM270-085/1 | pin adjusting | 1 |
| 11 | 28.778-076/1 | lever presserfoot holding raisable | 1 | 34 | AS276B-403/1 | guide rotating | 1 |
| 12 | PM270-081,1 | shaft | 1 | 35 | 255-404 | screw | 2 |
| 13 | 270-073 | pipe | 1 | 36 | PM276B-403 | guide | 1 |
| 14 | 270-085,1 | pin adjusting | 1 | 37 | G276B-403/1 | support complete | 1 |
| 15 | 270-021 | nut | 1 | 38 | 032F-6.5 | screw for eccentric | 1 |
| 16 | 004 L-7 | bolt presserfoot tongue | 1 | 39 | 605-412 | eccentric | 1 |
| 17 | 276 B-192 | guide | 1 | 40 | 057 E-4 | nut | 1 |
| 18 | 270-196 | locator | 1 | 41 | 276 B-412 | washer spring | 1 |
| 19 | 276 B-191 | bracket presserfoot fixing | 1 | 42 | 011 E-13 | screw collar | 1 |
| 20 | 27.77-109 1 | rear needle guard | 1 | 43 | 276 B-417/1 | support guide | 1 |
| 21 | 276 B-184 | shoe presserfoot | 1 | 44 | 276B-407,1 | support rotating | 1 |
| 22 | 270-185 | plate shain guide | 1 | 45 | 039 R-8,5 | screw guide fixing | 1 |
| 23 | 001 A-5,5 | screw for guide | 1 | | | | |



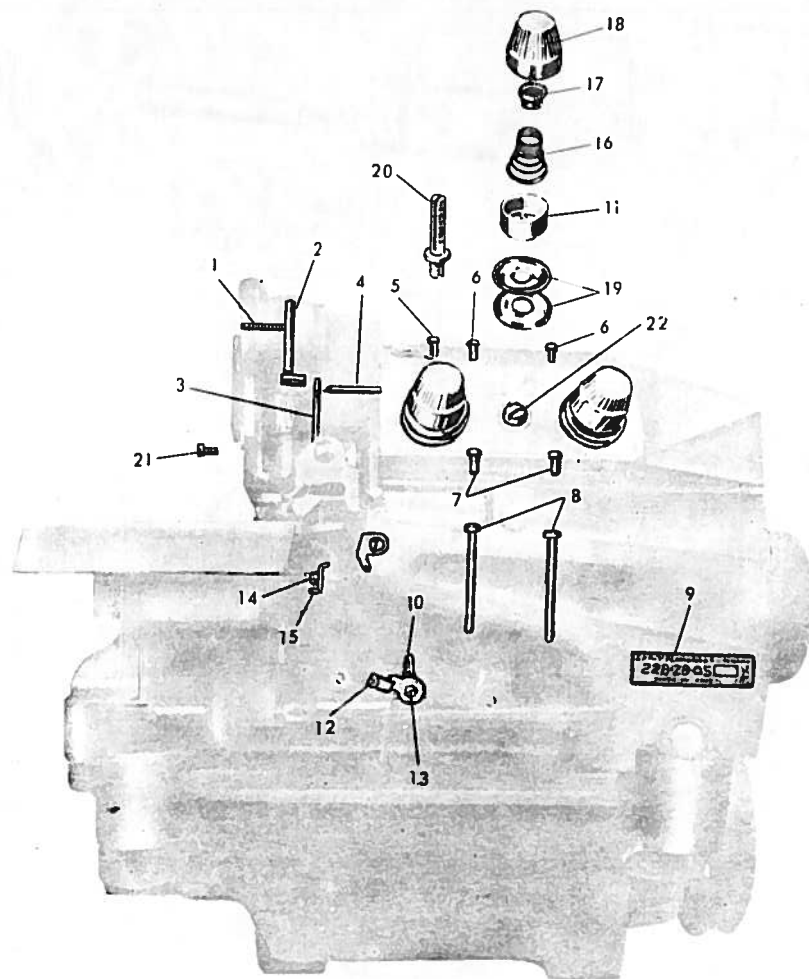
| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|--------------|-----------------------------------|--------|---------|------------|------------------------------------|--------|
| 1 | PM 270-208 3 | side cover with bush | 1 | 39 | 001 D-6 | screw spring clip fixing | 1 |
| 2 | 007 H-25 | bolt for upper cover | 1 | 40 | 608-405 | knob | 1 |
| 3 | PM 270-205 3 | cover with bush | 1 | 41 | 280-009 1 | cover side | 1 |
| 4 | 270-241 2 | cap oil filler | 1 | 42 | 016 B-4 | grub screw | 1 |
| 5 | 270-965 2 | gasket for oil fillet cap | 1 | 43 | 280-136 | spring | 1 |
| 6 | 270-983 | screw cover fixing | 1 | 44 | 270-715 | grub screw locking knob 270-093 | 1 |
| 7 | PM270-218 2 | hinge | 1 | 45 | 270-120 1 | cover shaft | 1 |
| 8 | 007 R-7,5 | screw for fixing plate | 7 | 46 | 270-731 1 | screw for attachment W | 2 |
| 9 | G270-245 4 | plate with bush | 1 | 47 | 280-321 | pad | 1 |
| 10 | 270-246 | gasket plate | 1 | 48 | 270-913 | pin for front cover plate | 1 |
| 11 | 270-093 1 | knob spring regulating | 1 | 49 | 016 D-6 | screw pin | 1 |
| 12 | 032 F-9,5 | screw for eccentric washer | 1 | 50 | 280-226 1 | pin | 1 |
| 13 | 605-412 | washer | 1 | 51 | 001 G-12 | screw kinge | 1 |
| 14 | 270-094 | lever presserfoot release | 1 | 52 | 180-225 | pin | 2 |
| 15 | 270-701 | washer spring | 1 | 53 | 270-624 | gasket cover disc | 1 |
| 16 | 270-086 | spring tie bar | 1 | 54 | 270-623 1 | disc cover | 1 |
| 17 | 270-078 | pin for presserfoot release lever | 1 | 55 | 001 D-10 | screw cover disc | 2 |
| 18 | 270-092 | spring presserfoot pressure | 1 | 56 | G270-216 2 | assembly front cover plate | 1 |
| 19 | 270-993 | screw stop | 1 | 57 | 280-203 2 | hinge | 1 |
| 20 | 270-995 | screw fixing upper cover | 2 | 58 | 280-303 | nipple fixing cover | 1 |
| 21 | 270-066 2 | caps, rear, for bush | 2 | 59 | 001 D-5 | screw spring clip fixing | 1 |
| 22 | 633-925 | spacer | 1 | 60 | 270-373 | bolt short | 1 |
| 23 | 280-945 | disc felt | 1 | 61 | 270-972 | bolt long | 1 |
| 24 | 280-244 1 | filter oil | 1 | 62 | 270-214 | screw fixing work plate | 1 |
| 25 | 01205 A | screw | 3 | 63 | 270-110 | tie bar | 1 |
| 26 | PM270-095 3 | shaft presserfoot alignment | 1 | 64 | 270-718 | ring for fixing work plate | 1 |
| 27 | G270-090 1 | shaft presserfoot release | 1 | 65 | 017 E-4,5 | screw for work plate fixing ring | 2 |
| 28 | PM270-210 3 | plate work | 1 | 66 | 004 L-9 | screw cover fixing | 3 |
| 29 | 280-214 1 | cover | 1 | 67 | 270-174 | nameplate for tension holder cover | 1 |
| 30 | 270-730 2 | plug for blocking hole | 2 | 68 | 270-175 | nameplate on front cover plate | 1 |
| 31 | 270-220 1 | pin for front cover plate | 1 | 69 | 280-215 | spacer | 3 |
| 32 | PM270-217 2 | cover plate with lin | 1 | 70 | 602 E-4434 | spring pin | 1 |
| 33 | 007 F-14 | screw cover plate | 1 | 71 | 001 E-12 | screw fixing filter | 1 |
| 34 | 270-221 | spring for front cover plate | 1 | 72 | 270-090 1 | block tie bar | 1 |
| 35 | 054 D-4 | nut for lock screw | 1 | 73 | 270-022 | grub screw tie bar | 1 |
| 36 | 270-226 | lock screw | 1 | 74 | 057 E-1 | nut for work plate fixing screw | 1 |
| 37 | 053 D-4 | lock nut knob | 1 | 75 | 001 E-5,5 | screw for front cover plate | 1 |
| 38 | 270-212 | spring clip for closing | 1 | 76 | 001 E-5,5 | stop washer | 1 |



| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|----------------|-----------------------------------|--------|---------|--------------|------------------------------------|--------|
| 1 | PM.270-208/3 | side cover with bush | 1 | 38 | 270-212 | spring clip for closing | 1 |
| 2 | 007-H-25 | bolt for upper cover | 1 | 39 | 001-D-6 | screw spring clip fixing | 1 |
| 3 | PM.270-205/3 | cover with bush | 1 | 40 | 608-405 | knob | 1 |
| 4 | 270-241/2 | cap oil filler | 1 | 41 | 280-209/1 | cover side | 1 |
| 5 | 270-965/2 | gasket for oil filler cap | 1 | 42 | 016-B-4 | grub screw | 1 |
| 6 | 270-983 | screw cover fixing | 1 | 43 | 280-236 | spring | 1 |
| 7 | PM.270-218/2 | hinge | 1 | 44 | 270-715 | grub screw locking knob 270-093/1 | 1 |
| 8 | 007-R-7.5 | screw for fixing plate | 7 | 45 | 270-129/1 | cover shaft | 1 |
| 9 | G.270-245 4 | plate with bush | 1 | 46 | 270-731/1 | screw for attachment W1 | 2 |
| 10 | 270-246 | gasket plate | 1 | 47 | 280-921 | pad | 1 |
| 11 | 270-093/1 | knob spring regulating | 1 | 48 | 270-913 | pin for front cover plate | 1 |
| 12 | 032-F-9,5 | screw for eccentric washer | 1 | 49 | 016-D-6 | screw pin | 1 |
| 13 | 605-412 | washer | 1 | 50 | 280-226/1 | pin | 1 |
| 14 | 270-094 | lever presserfoot release | 1 | 51 | 001-G-12 | screw kinge | 2 |
| 15 | 270-701 | washer spring | 1 | 52 | 280-225 | pin | 1 |
| 16 | 270-086 | spring tie bar | 1 | 53 | 270-624 | gasket cover disc | 1 |
| 17 | 270-078 | pin for presserfoot release lever | 1 | 54 | 270-623/1 | disc cover | 1 |
| 18 | 270-092 | spring presserfoot pressure | 1 | 55 | 001-D-10 | screw cover disc | 2 |
| 19 | 270-993 | screw stop | 1 | 56 | G276 B-216 2 | assembly front cover plate | 1 |
| 20 | 270-995 | screw fixing upper cover | 2 | 57 | 280-203/2 | hinge | 1 |
| 21 | 270-066/2 | caps, rear, for bushes | 2 | 58 | 280-303 | nipple fixing cover | 1 |
| 22 | 633-925 | spacer | 1 | 59 | 001-D-4,5 | screw spring clip fixing | 1 |
| 23 | 280-945 | disc felt | 1 | 60 | 270-973 | bolt short | 1 |
| 24 | 280-244/1 | filter oil | 1 | 61 | 270-972 | bolt long | 1 |
| 25 | 01205/A | screw | 3 | 62 | 270-214 | screw fixing work plate | 1 |
| 26 | PM.270-095/3 | shaft presserfoot alignment | 1 | 63 | 270-110 | tie bar | 1 |
| 27 | G.270-090 1 | shaft presserfoot release | 1 | 64 | 270-718 | ring for fixing work plate | 1 |
| 28 | PM.270-210/3 | plate work | 1 | 65 | 017-E-4,5 | screw for work plate fixing ring | 3 |
| 29 | 280-214/1 | cover | 1 | 66 | 004-L-9 | screw cover fixing | 2 |
| 30 | 016 F-5,5 | screw | 1 | 67 | 270-174 | nameplate for tension holder cover | 1 |
| 31 | 270-220/1 | pin for front cover plate | 1 | 68 | 270-175 | nameplate on front cover plate | 1 |
| 32 | PM.276 B-217 2 | cover plate with fin | 1 | 69 | 280-215 | spacer | 3 |
| 33 | 007-F-14 | screw cover plate | 1 | 70 | 602-E-4434 | spring pin | 1 |
| 34 | 270-221 | spring for front cover plate | 1 | 71 | 001-E-12 | screw fixing filter | 1 |
| 35 | 054-D-4 | nut for lock screw | 1 | 72 | 270-090/1 | block tie bar | 1 |
| 36 | 270-226 | lock screw | 1 | 73 | 290-923 | grub screw tie bar | 1 |
| 37 | 053-D-4 | lock nut knob | 1 | 74 | 057-E-4 | nut for work plate fixing screw | 1 |
| | | | | 75 | 270-653 | stop bracket | 1 |

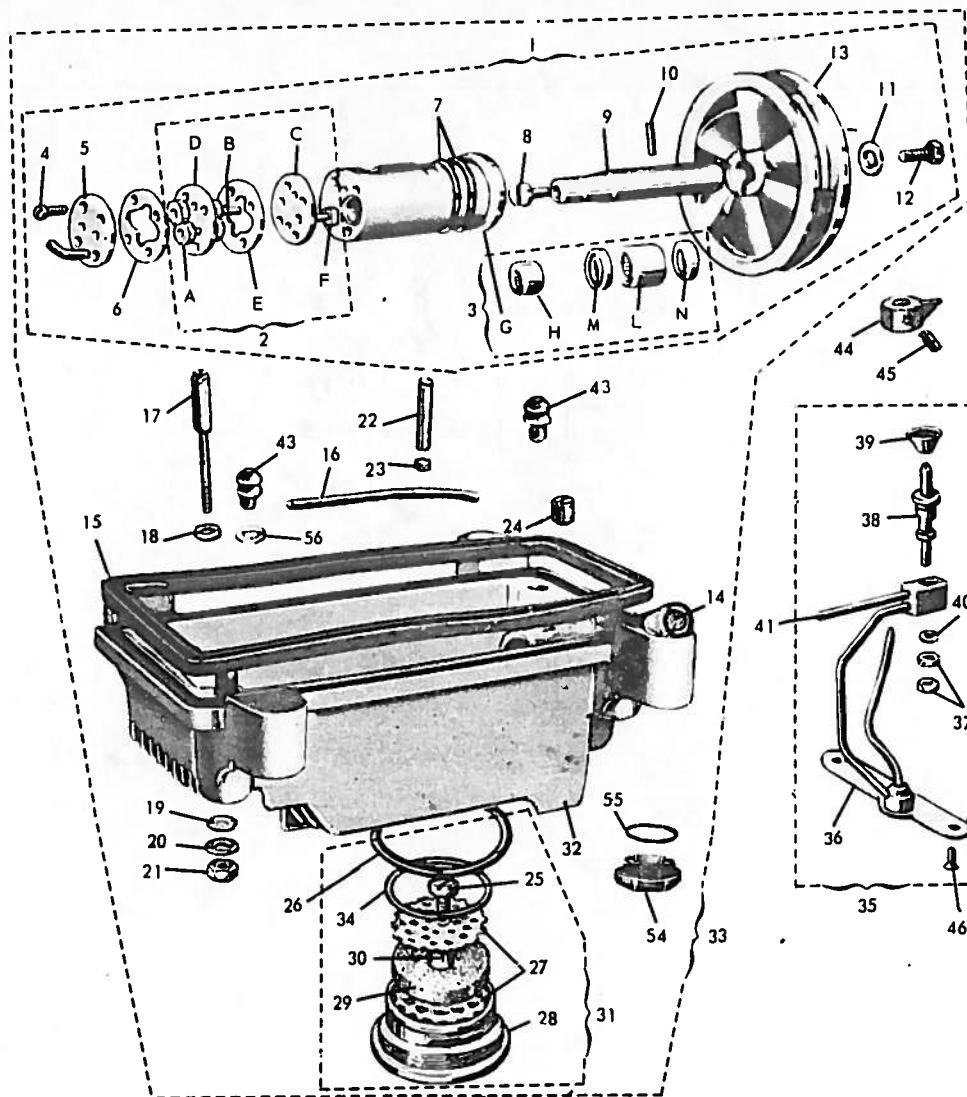


| N° RIF. | N° DISEGNO | DENOMINAZIONE | QUANT. | N° RIF. | N° DISEGNO | DENOMINAZIONE | QUANT. |
|---------|-------------|--|--------|---------|-------------|--------------------------------|--------|
| 1 | 270-941 | screw fixing needle thread, thread-guide | 1 | 13 | 270-270.2 | tensioner upper looper thread | 1 |
| 2 | PM270-263.1 | thread guide for needle thread | 1 | 14 | 004 A-3,2 | screw fixing guard | 1 |
| 3 | 270-274/4 | thread tensioner for needle thread | 1 | 15 | 270-276.1 | guard looper stop | 1 |
| 4 | 270-264 | thread guide needle | 1 | 16 | 270-275.1 | guide upper looper thread | 1 |
| 5 | 270-265 | bush upper thread guide | 1 | 17 | 032 A-6 | screw fixing thread guide | 1 |
| 6 | 270-265/1 | bush upper thread guide | 2 | 18 | 272-232.1 | spring looper | 2 |
| 7 | 270-266 | bush lower thread guide | 2 | 19 | 270-233 | bush upper tension | 2 |
| 8 | 270-268 | tube lower thread guide | 2 | 20 | 202558-2-00 | knob, threaded, for tensioning | 2 |
| 9 | 781001-0-00 | nameplate showing machine class | 1 | 21 | 603-031 | disc tension | 1 |
| 10 | 202556-0-00 | cap tensioner retainer | 3 | 22 | 270-230 | pin, threaded, for tensioning | 3 |
| 11 | 270-269.2 | tensioner lower looper thread | 1 | 23 | 270-232.2 | spring needle | 1 |
| 12 | 004 L-8 | screw fixing thread tensioner | 1 | 24 | 004 N-5,5 | screw fixing thread tensioner | 2 |

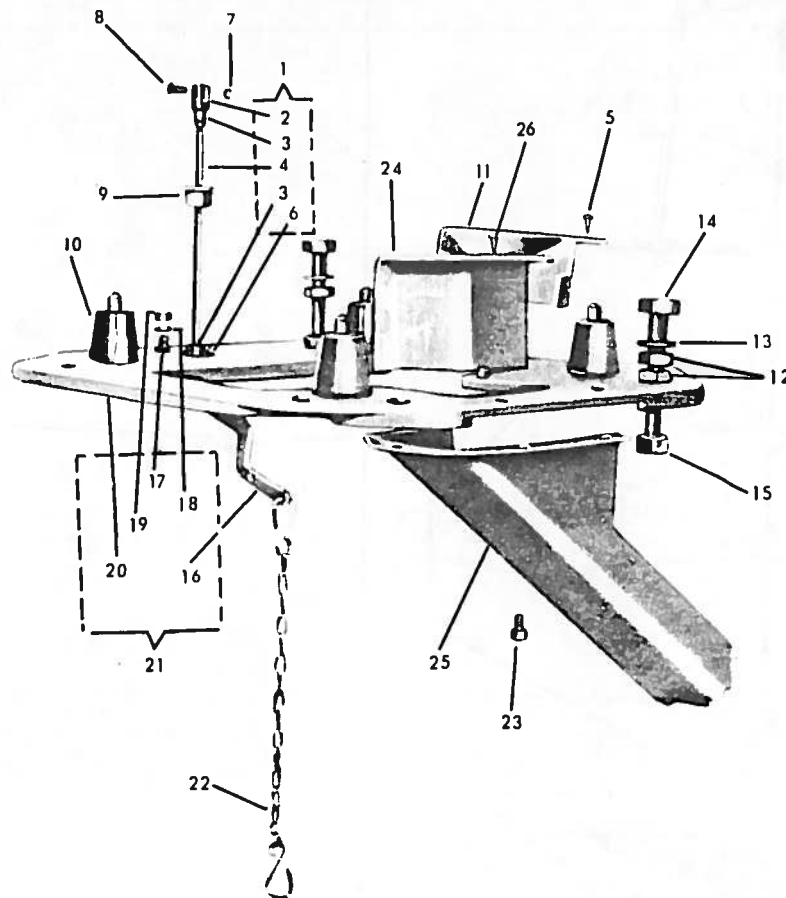


| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|-------------|--|--------|---------|-------------|--------------------------------|--------|
| 1 | 270-941 | screw fixing needle thread, thread-guide | 1 | 12 | 270-269,2 | tensioner lower looper thread | 1 |
| 2 | PM270-263,1 | thread guide for needle thread | 1 | 13 | 004 L-8 | screw fixing thread tensioner | 1 |
| 3 | 270-274,4 | thread tensioner for needle thread | 1 | 14 | 004 A-3,2 | screw fixing guard | 1 |
| 4 | 270-264 | thread guide needle | 1 | 15 | 270-276,1 | guard looper stop | 1 |
| 5 | 270-265 | bush upper thread guide | 1 | 16 | 272-232,1 | spring looper | 2 |
| 6 | 270-265,1 | bush upper thread guide | 2 | 17 | 270-233 | bush upper tension | 2 |
| 7 | 270-266 | bush lower thread guide | 2 | 18 | 202558-2-00 | knob, threaded, for tensioning | 2 |
| 8 | 270-268 | tube lower thread guide | 2 | 19 | 603-031 | disc tension | 4 |
| 9 | 781001-0-00 | nameplate showing machine class | 1 | 20 | 270-230 | pin, threaded, for tensioning | 2 |
| 10 | 270-270,2 | tensioner upper looper thread | 1 | 21 | 004 N-5,5 | screw fixing thread tensioner | 2 |
| 11 | 202556-0-00 | cap tensioner retainer | 2 | 22 | 003 M-7 | screw | 1 |

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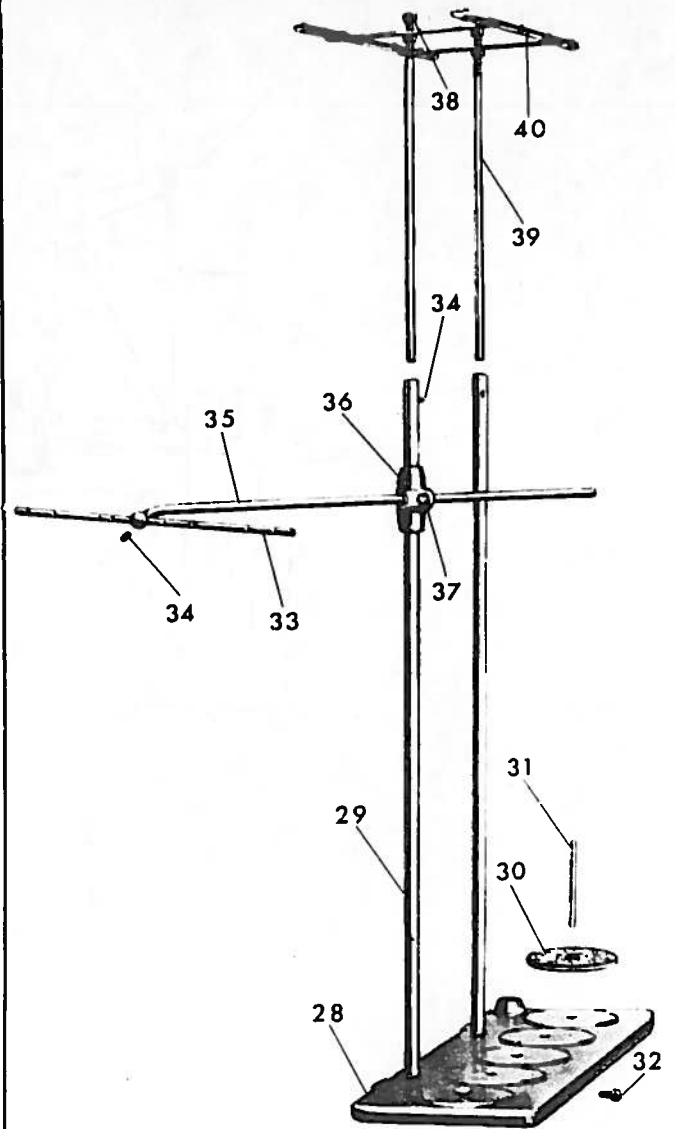
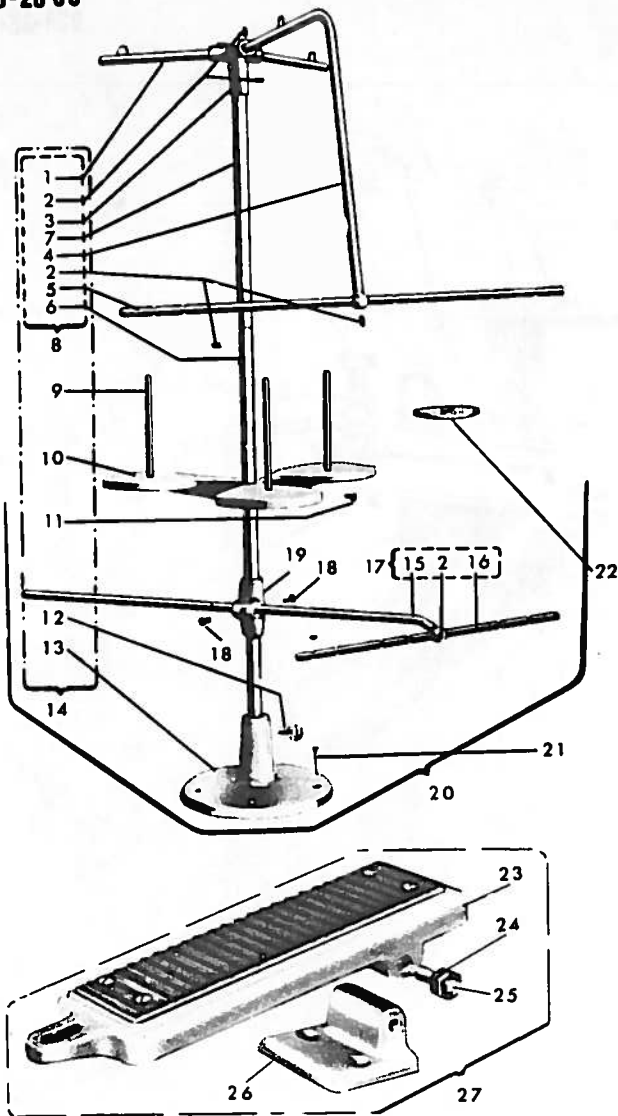


| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|--------------|--------------------|--------|---------|--------------|-----------------------------|--------|
| 1 | G.270-816/1 | assembly oil pump | 1 | 34 | 270-966/1 | gasket | 1 |
| 2 | G.633-833/1 | assembly gear | 1 | 35 | G.270-646 | assembly oil distributor | 1 |
| 3 | PM.270-816/1 | body pump | 1 | 36 | PM.270-646/1 | distributor | 1 |
| 4 | 633-812 | screw | 1 | 37 | 057-A-3 | nut | 2 |
| 5 | PM.633-817/1 | cover | 1 | 38 | 270-650 | valve deviator | 1 |
| 6 | 633-818/1 | washer | 1 | 39 | 270-651 | gasket | 1 |
| 7 | 633-711/1 | gaskets | 2 | 40 | 270-734/1 | washer spring | 1 |
| 8 | 270-824/1 | screw drag | 1 | 41 | 270-652 | pipe connecting | 1 |
| 9 | 270-823/1 | shaft | 1 | | | | |
| 10 | 633-708 | pin spring | 1 | 43 | 633-826/1 | pipe oil pump union | 2 |
| 11 | 633-707 | washer spring | 1 | 44 | 270-645 | pointer for oil distributor | 1 |
| 12 | 039-G-10 | bolt fixing pulley | 1 | 45 | 016-B-2,5 | grub screw pointer | 1 |
| 13 | 270-810/2 | pulley oil pump | 1 | 46 | 028-E-10 | screw | 2 |
| 14 | 633-959/1 | spy glass oil | 1 | | | | |
| 15 | 270-808/1 | gasket | 1 | | | | |
| 16 | 633-842 | pipe | 1 | | | | |
| 17 | 270-811/1 | pin | 2 | | | | |
| 18 | 270-946 | gasket | 2 | | | | |
| 19 | 270-947 | gasket | 2 | | | | |
| 20 | 065-L-6 | washer | 2 | | | | |
| 21 | 059-G-6 | nut | 2 | 54 | 270-432/1 | plug with current pick-ups | 1 |
| 22 | 270-831/1 | pipe | 1 | 55 | 270-430 | gasket rubber | 1 |
| 23 | 270-836 | pad felt | 1 | A | 633-821 | gear | 4 |
| 24 | 017 H-12 | grub screw | 1 | B | 633-822 | pin gear | 1 |
| 25 | 007 L-20 | screw | 1 | C | 633-819 | plate side | 1 |
| 26 | 633-966 | gasket | 1 | D | 633-833 | plate internal | 1 |
| 27 | 270-828/1 | grating | 1 | E | 633-818 | washer internal | 1 |
| 28 | 270-996/2 | plug | 1 | F | 633-834 | pin drag | 1 |
| 29 | 270-827/1 | pad felt | 1 | G | 270-816/1 | body pump | 1 |
| 30 | 633-925 | spacer | 1 | H | 633-814 | sheath roller bearing | 1 |
| 31 | G.270-996/2 | plug sump | 1 | L | 633-813 | sheath roller bearing | 1 |
| 32 | 270-001/2 | sump | 1 | M | 670-702 | ring sealing | 2 |
| 33 | 205520-5-00 | assembly sump | 1 | 56 | 280-946 | spacer for connection pipe | 1 |

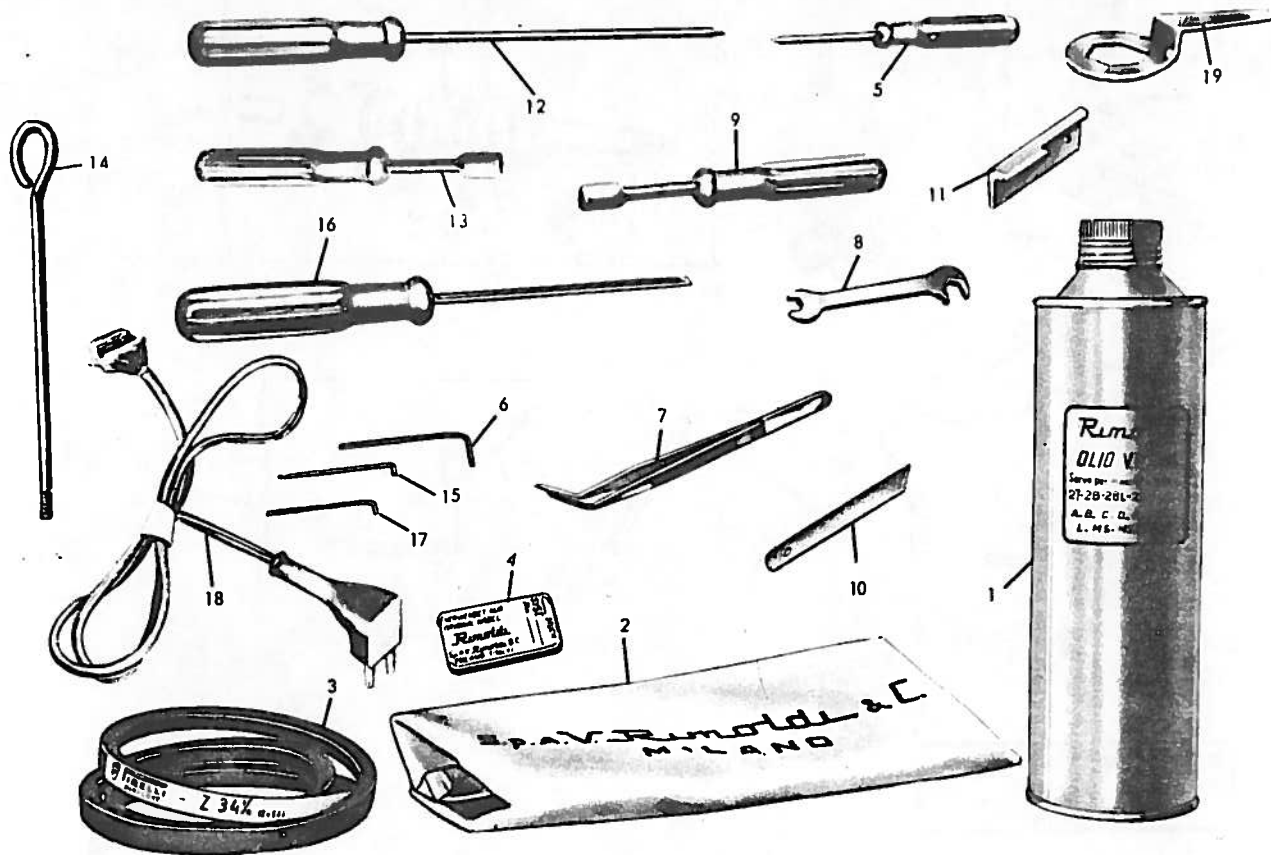


| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|-----------|---|--------|---------|--------------|--------------------------------------|--------|
| 1 | G.270-583 | assembly tie bar | 1 | 12 | 058-M-10 | nut for bolts holding machine | 8 |
| 2 | 270-585 | joint, upper, for presserfoot raising lever | 1 | 13 | 067-H-10 | washer for plate supporting machine | 4 |
| 3 | 059-A-5 | nut for the bar | 2 | 14 | 270-971 | bolt for plate supporting machine | 4 |
| 4 | 270-583 | rod for presserfoot raising lever | 1 | 15 | 051-L-10 | nut for fixing plate to table | 4 |
| 5 | 270-459 | rivet fixing | 7 | 16 | 270-586/1 | lever controlling presserfoot lifter | 1 |
| 6 | 270-557 | joint for presserfoot raising lever | 1 | 17 | 270-584 | support for lever | 1 |
| 7 | 270-701 | ring snap | 2 | 18 | 065-L-6 | washer pin | 1 |
| 8 | 270-558 | pin for joint | 2 | 19 | 059-H-6 | nut for support | 1 |
| 9 | 270-552 | bush, upper, for table | 1 | 20 | PM.270-005/3 | plate with pins | 1 |
| 10 | 270-004 | shock absorber for machine | 4 | 21 | G.270-005/3 | plate machine support | 1 |
| 11 | 270-588 | guard pulley wheel | 1 | 22 | PM.1159 | chain with hook | 1 |
| | | | | 23 | 001-G-10 | On request: screw channel fixing | 3 |
| | | | | 24 | 270-589/1 | mouth waste chute | 1 |
| | | | | 25 | 270-590/1 | waste chute to the right | 1 |
| | | | | " | 270-590/2 | waste chute to the left | 1 |
| | | | | 26 | 270-459 | rivets fixing | 9 |

16



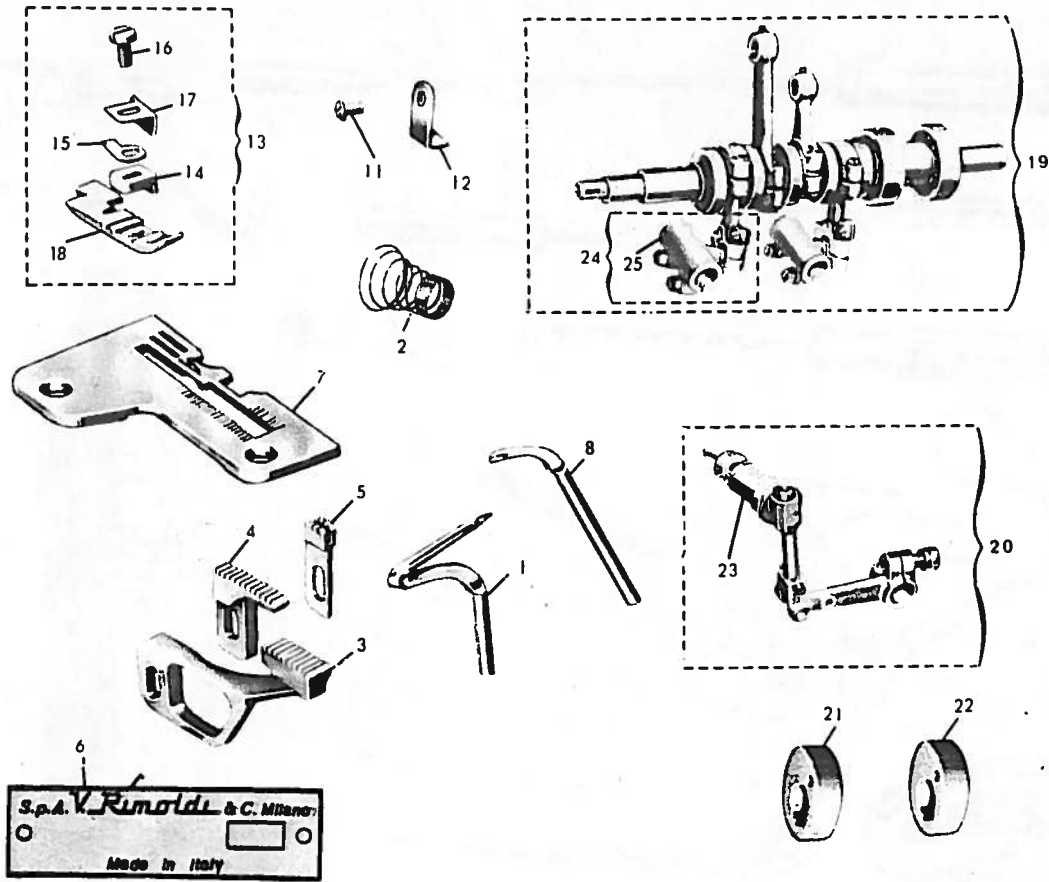
| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|--------------|--------------------------------------|--------|---------|-----------|----------------------|--------|
| | | SUPPLIED WITH HEAD ONLY | | | | SUPPLIED WITH BENCH | |
| 1 | PM.250-133/1 | rod thread guide | 2 | 28 | 490/2 | holder reel | 1 |
| 2 | 016-F-6.5 | grub screw | 8 | 29 | 910-143 | rod main support | 2 |
| 3 | 250-140 | union rod | 1 | 30 | 569 | disc reel support | 5 |
| 4 | PM.250-148/1 | support rod | 1 | 31 | 1146 | pin reel | 5 |
| 5 | 250-137 | rod thread guide | 1 | 32 | 001-G-10 | screws cheesehead | 5 |
| 6 | 250-143 | rod lower main | 1 | 33 | 270-157 | rod thread guide | 1 |
| 7 | 250-130 | rod upper main | 1 | 34 | 016-F-5 | grub screw | 1 |
| 8 | G.250-137 | frame thread guide | 1 | 35 | 270-158/1 | support thread guide | 1 |
| 9 | 1146 | pin reel | 3 | 36 | 605-937 | support for reel pin | 1 |
| 10 | 01142 | plate reel base | 1 | 37 | 605-980 | knob knurled | 2 |
| 11 | 001-G-10 | screw fixing plate | 1 | 38 | 1145 | frame nut fixing | 4 |
| 12 | 001-G-12 | screw fixing rod | 1 | 39 | 910-144 | rod, upper, of frame | 2 |
| 13 | 01141 | base thread guide | 1 | 40 | G.497 | frame thread guide | 1 |
| 14 | AS.250-149 | assembly thread guide frame | 1 | | | | |
| 15 | 270-158/1 | support rod | 1 | | | | |
| 16 | 270-157 | rod thread guide | 1 | | | | |
| 17 | G.270-157 | support with thread guide rod | 1 | | | | |
| 18 | 605-980 | grub screw | 3 | | | | |
| 19 | 605-937 | support | 1 | | | | |
| 20 | AS.270-140 | assembly complete thread guide frame | 1 | | | | |
| 21 | TS.20 x 30 | screw for fixing frame | 2 | | | | |
| 22 | 569 | disc spool support | 3 | | | | |
| 23 | PM.910-914 | pedal | 1 | | | | |
| 24 | 053-H-8 | nut pedal | 2 | | | | |
| 25 | 910-964 | bolt pointed | 2 | | | | |
| 26 | 910-934/1 | support pedal | 1 | | | | |
| 27 | G.910-914/1 | assembly pedal | 1 | | | | |



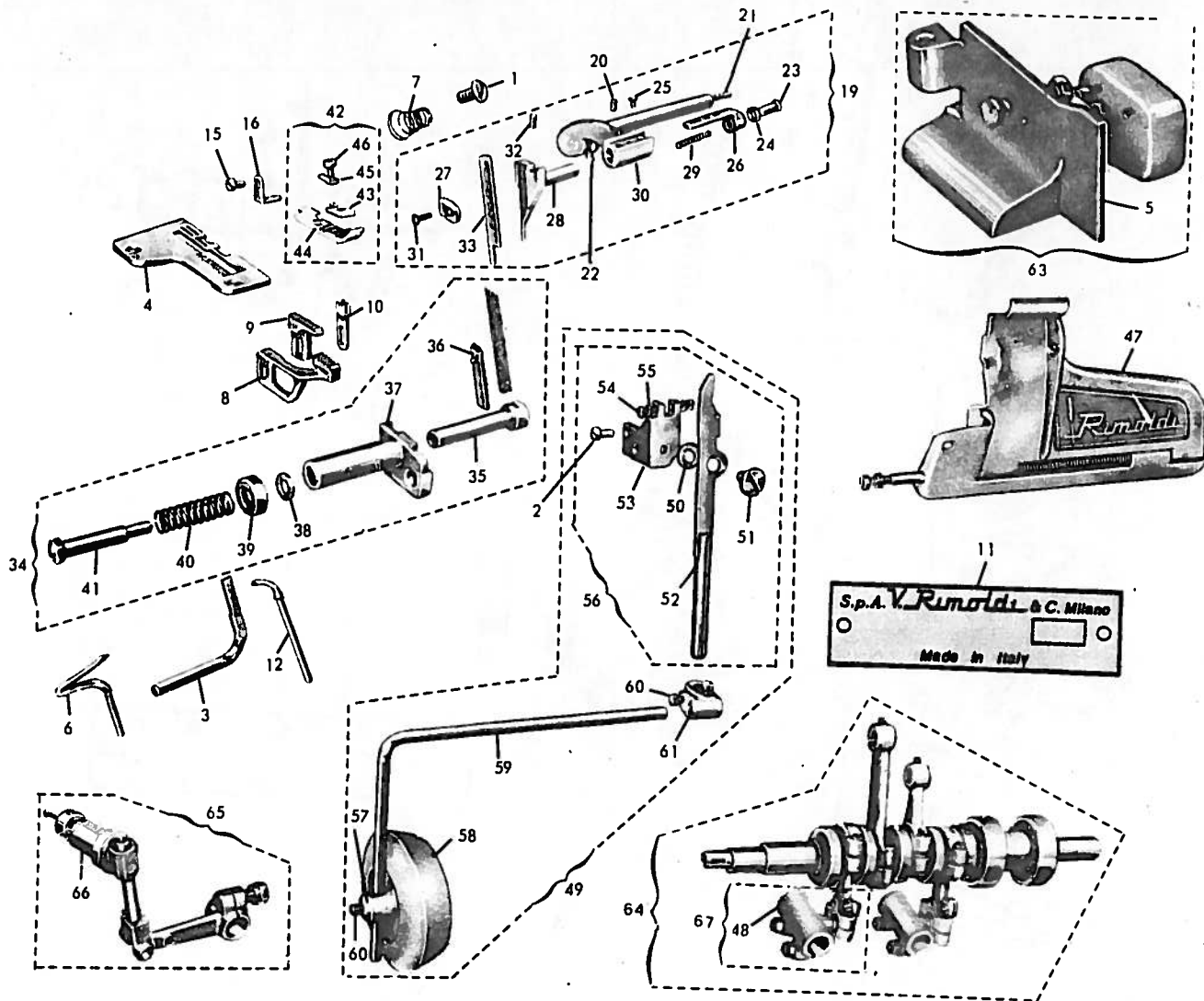
17

| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|------------------------------|-----------|----------------------------|--------|---------|------------|-----------------------|--------|
| 1 | VR. 604 | oil 1 Kg. | 1 | 11 | 270-112 | knife upper | 1 |
| 2 | 1175 | dust cover for machine | 1 | 12 | 01160/2 | screwdriver | 1 |
| 3 | 280-155 | vee belt | 1 | 13 | 280-742 | socket spanner 23/64" | 1 |
| 4 | HIM. 27 | needle | 5 | 14 | 280-745 | extractor eccentric | 1 |
| 5 | 1161/2 | screwdriver | 1 | 15 | 270-743 | allen key 5/64" | 1 |
| 6 | 633-742 | allen key 1/8" for 270-715 | 1 | 16 | 01161/2 | screwdriver | 1 |
| 7 | 1158 | tweezers for threading | 1 | 17 | 641-LY-743 | allen key 3/32" | 1 |
| 8 | 1156/1 | spanner double ended 7 . 9 | 1 | 18 | 270-431 | lead mains | 1 |
| 9 | 270-741 | socket spanner 9/32" | 1 | 19 | 639M-745 | spanner sump plug | 1 |
| 10 | 270-113/1 | knife lower | 1 | | | | |
| On request 270-675/1 Tab. 38 | | | | | | | |

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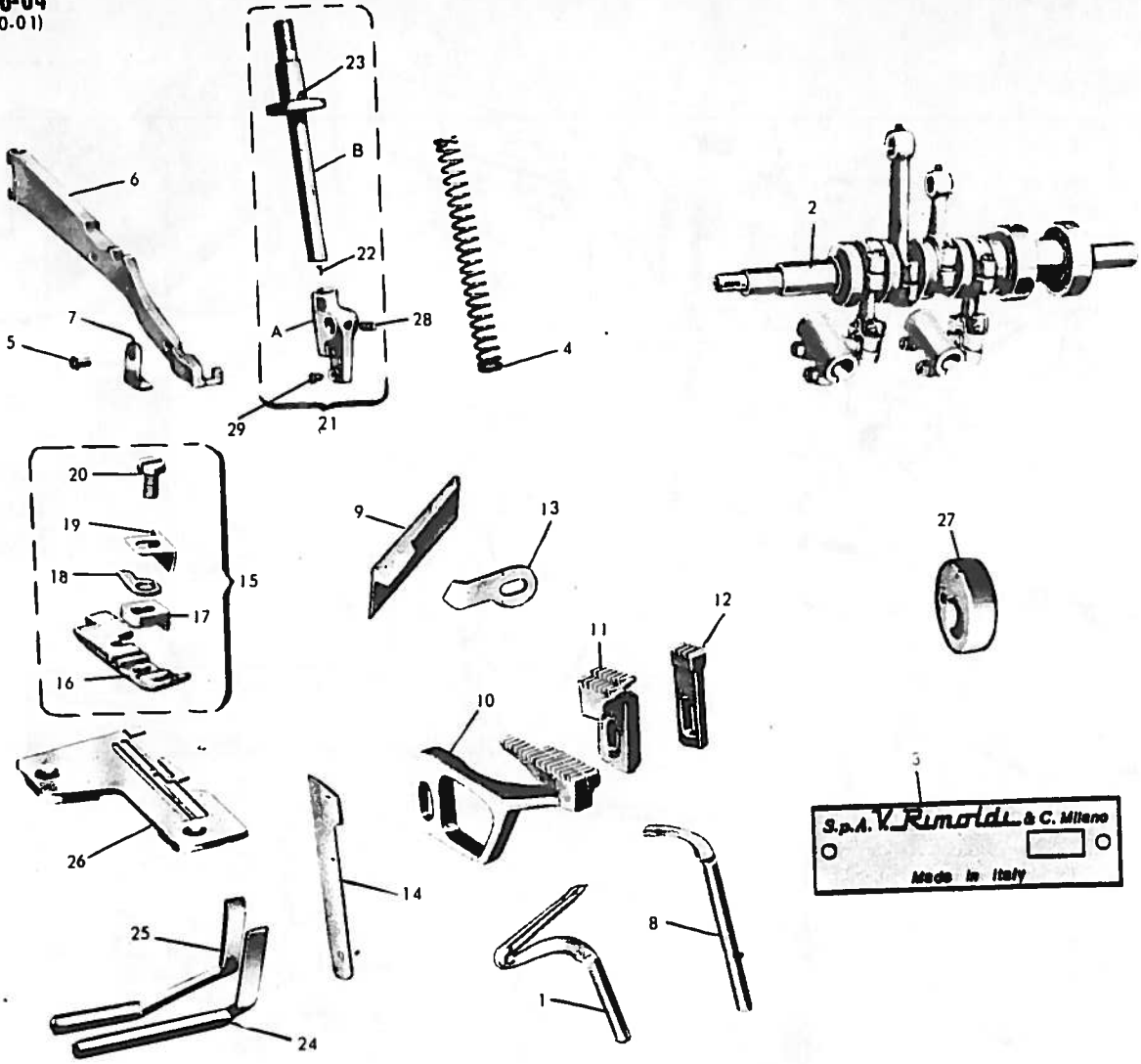
| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|---------------|----------------------------------|--------|---------|------------------|---|--------|
| 1 | 270-0751 | looper lower | 1 | 14 | 272-B-191 | tongue | 1 |
| 2 | 270-232/1 | spring lower looper tension | 1 | 15 | 270-196 | locator | 1 |
| 3 | 272-B-050 | feed dog main | 1 | 16 | 004-L-8 | screw | 1 |
| 4 | 282-B-051 | feed dog subsidiary | 1 | 17 | 27 B-183 | plate | 1 |
| 5 | 272-B-052 | feed dog chaining | 1 | 18 | 272-B-184/1 | slide | 1 |
| 6 | 781002-0-00 | name plate showing machine class | 1 | 19 | G.28.21-C2 009 4 | main shaft assembly | 1 |
| 7 | 272-B-1141 | needle plate bight width 9/64" | 1 | 20 | G.27.21-C2-067/3 | looper drive shaft with connecting rods | 1 |
| 8 | 270-074 | | 1 | 21 | 280-0461/16 | eccentric for main feed dog | 1 |
| | | tensioner lower looper thread | 1 | 22 | 280-0451/12 | eccentric for subsidiary feed dog | 1 |
| 11 | 27.01-P-403/1 | screw fixing guard lever | 1 | 23 | 27.21-C2-056 | bush eccentric for upper looper drive | 1 |
| 12 | 272-186 | guard presserfoot stop | 1 | 24 | PM.27.21-C2-059 | con-rod with coupling | 1 |
| 13 | G.272-B2-181 | assembly presserfoot | 1 | 25 | 27.21-C2-059 | coupling | 1 |
| | | | | | 272-B-0501 | see Tab. 38 | |
| | | | | | 282 B-0511 | see Tab. 38 | |
| | | | | | 272-B-114 | see Tab. 38 | |
| | | | | | 272-092 | see Tab. 38 | |



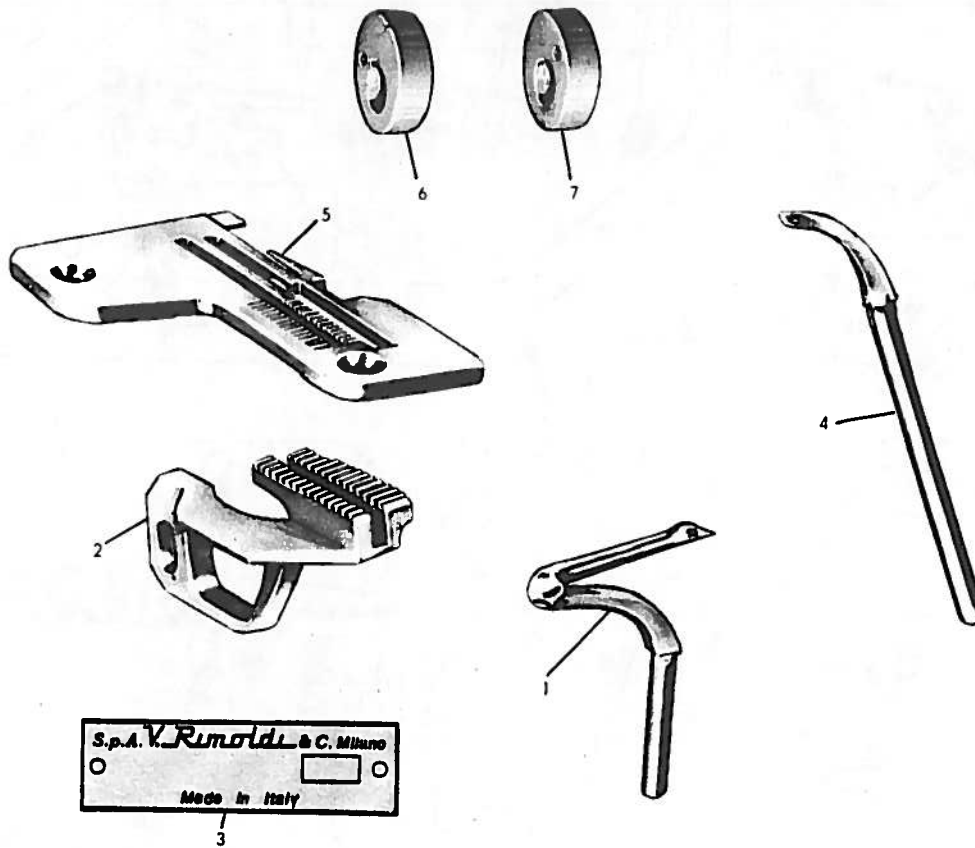
19

| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|---------------|-----------------------------------|--------|---------|------------------|---|--------|
| 1 | 003-M-7 | screw | 1 | 35 | 272-BK-1051 | shaft | 1 |
| 2 | 026-G-10 | screw lever lock | 1 | 36 | PM.272-BK-110 | plate | 1 |
| 3 | 272-BK-107 | front needle guard | 1 | 37 | 272-BK-104 | holder knife | 1 |
| 4 | 272-BK-114 | needle plate bight tongue 1/16" | 1 | 38 | 071-D-5 | washer | 1 |
| 5 | 282-BK-209 | side cover | 1 | 39 | 272-BK-994 | retainer spring | 1 |
| 6 | 270-0751 | looper lower | 1 | 40 | 272-BK-976 | spring | 1 |
| 7 | 270-232/1 | spring lower looper tension | 1 | 41 | 272-BK-986 | bolt | 1 |
| 8 | 272-B-050 | feed dog main | 1 | 42 | G.272-BK-181 | assembly presserfoot | 1 |
| 9 | 282-B-051 | feed dog subsidiary | 1 | 43 | 272-BK-191 | bracket | 1 |
| 10 | 272-B-052 | feed dog churning | 1 | 44 | 272-BK-184 | slide | 1 |
| 11 | 781003-0-00 | name plate showing machine class | 1 | 45 | 270-196 | locator | 1 |
| 12 | 270-074 | looper upper | 1 | 46 | 004-L-7 | screw | 1 |
| 15 | 27.01-P-403/1 | screw guide block fixing | 1 | 47 | G.272-BK-216/2 | assembly front cover plate | 1 |
| 16 | 272-186 | guard presserfoot stop | 1 | 48 | 27.21-C2-059 | coupling | 1 |
| 17 | 280-0451/12 | eccentric for subsidiary feed dog | 1 | 49 | AS.272-BK-903 | knee control, complete | 1 |
| 19 | G.272-BK-096 | holder, upper knife, complete | 1 | 50 | 272-BK-907 | washer | 1 |
| 20 | 092-C-2 | wick | 2 | 51 | 272-BK-906 | screw | 1 |
| 21 | 092-D-11 | wick | 1 | 52 | PM.272-BK-903 | lever | 1 |
| 22 | 092-D-2 | wick | 1 | 53 | 272-BK-905 | support | 1 |
| 23 | 272-BK-991 | screw register | 1 | 54 | 390-974 | screw | 2 |
| 24 | 059-A-5 | nut | 1 | 55 | 057-E-4 | nut | 2 |
| 25 | 004-A-3.2 | screw | 1 | 56 | G.272-BK-903 | lever for moving knife | 1 |
| 26 | 272-BK-102 | guide | 2 | 57 | 270-574 | disc | 1 |
| 27 | 272-BK-103 | locator | 1 | 58 | 270-582 | pad | 1 |
| 28 | 272-BK-099 | holder knife | 1 | 59 | 272-BK-573 | rod | 1 |
| 29 | 272-BK-100 | spring | 1 | 60 | 038-M-9 | screw | 3 |
| 30 | PM.272-BK-096 | lever | 1 | 61 | 270-572 | attachment | 1 |
| 31 | 272-BK-987 | screw | 1 | 62 | 280-0461/16 | eccentric for feed dog | 1 |
| 32 | 255-442 | pin | 1 | 63 | G.282-BK-209/1 | cover, side protection | 1 |
| 33 | 272-BK-112 | knife | 1 | 64 | G.28.21-C2-009/4 | main shaft assembly | 1 |
| 34 | G.272-BK-104 | holder, knife, complete | 1 | 65 | G.27.21-C2-067/3 | looper drive shaft with connecting rods | 1 |
| | | | | 66 | 27.21-C2-056 | bush eccentric | 1 |
| | | | | 67 | PM.27.21-C2-059 | con-rod with coupling | 1 |
| | | | | | | On request: | |
| | | | | | | see Tab. 38 | |
| | | | | | | see Tab. 38 | |
| | | | | | | see Tab. 38 | |

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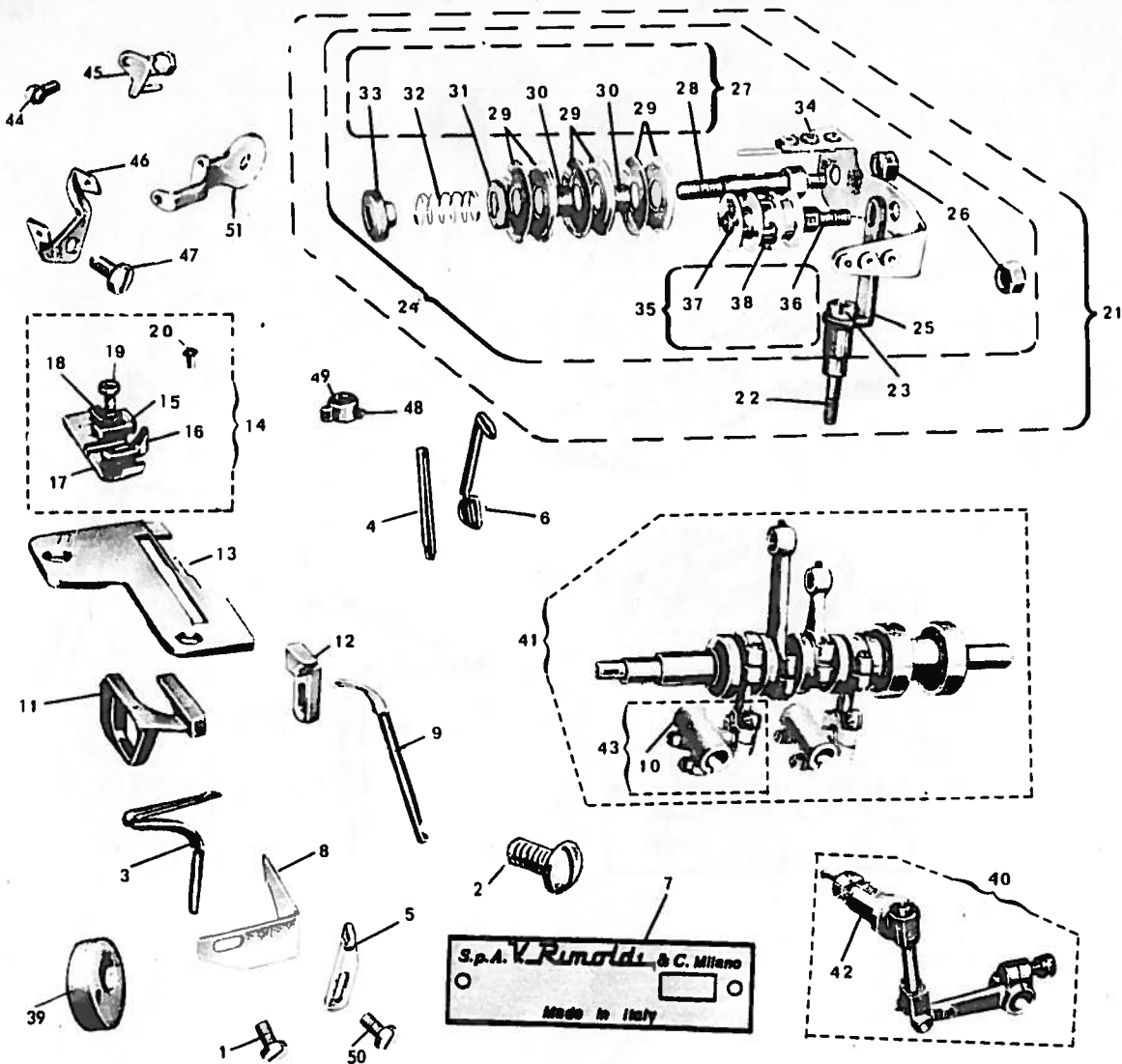


| N° RIF. | N° DISEGNO | DENOMINAZIONE | QUANT. | N° RIF. | N° DISEGNO | DENOMINAZIONE | QUANT. |
|---------|-----------------|------------------------------------|--------|---------|---------------|---------------------------------|--------|
| 1 | 270-075 | looper | 1 | 16 | 277-184 | slide | 1 |
| 2 | G.28.00-B-009/3 | main shaft complete | 1 | 17 | 277-191 | tongue | 1 |
| 3 | 781004-0-00 | name plate showing machine class | 1 | 18 | 270-196 | locator | 1 |
| 4 | 27.01-P-092 | spring presserfoot pressure | 1 | 19 | 277-183 | plate | 1 |
| 5 | 27.01-P-403/1 | screw for bracket | 1 | 20 | 004-L-8 | screw | 1 |
| 6 | 28.778-076/1 | lever presserfoot holding raisable | 1 | 21 | G.27.77-025/2 | needle bar with clamp | 1 |
| 7 | 27.26-186 | guard presserfoot stop | 1 | 22 | 016-A-2.5 | grub screw | 1 |
| 8 | 27.277-0745 | looper upper | 1 | 23 | 092-A-10 | wick | 1 |
| 9 | 276-B-112 | knife upper | 1 | 24 | 27.77-107/1 | front needle guard | 1 |
| 10 | 277-0501 | feed dog main | 1 | 25 | 27.77-109/1 | rear needle guard | 1 |
| 11 | 28.00-B7-051 | feed dog subsidiary | 1 | 26 | 27.77-1141 | needle plate bight width 13/64" | 1 |
| 12 | 277-052 | feed dog chaining | 1 | 27 | 280-0451/5 | eccentric for main feed dog | 1 |
| 13 | 128-110 | guard upper knife holder | 1 | 28 | 016-B-2.5 | screw gudgeon pin fixing | 1 |
| 14 | 277-113 | knife lower | 1 | 29 | 003-A-4.5 | screw for needle clamp | 1 |
| 15 | G.277-181 | assembly presserfoot | 1 | A | 27.77-020 | clamp | 1 |
| 16 | | | | B | 290-025/1 | shaft | 1 |
| | | | | | | On request: | |
| | | | | | 270-075/2 | see Tab. 38 | |
| | | | | | 27.277-074 | see Tab. 38 | |
| | | | | | 28.00-B7-0511 | see Tab. 38 | |
| | | | | | 27.77-1142 | see Tab. 38 | |

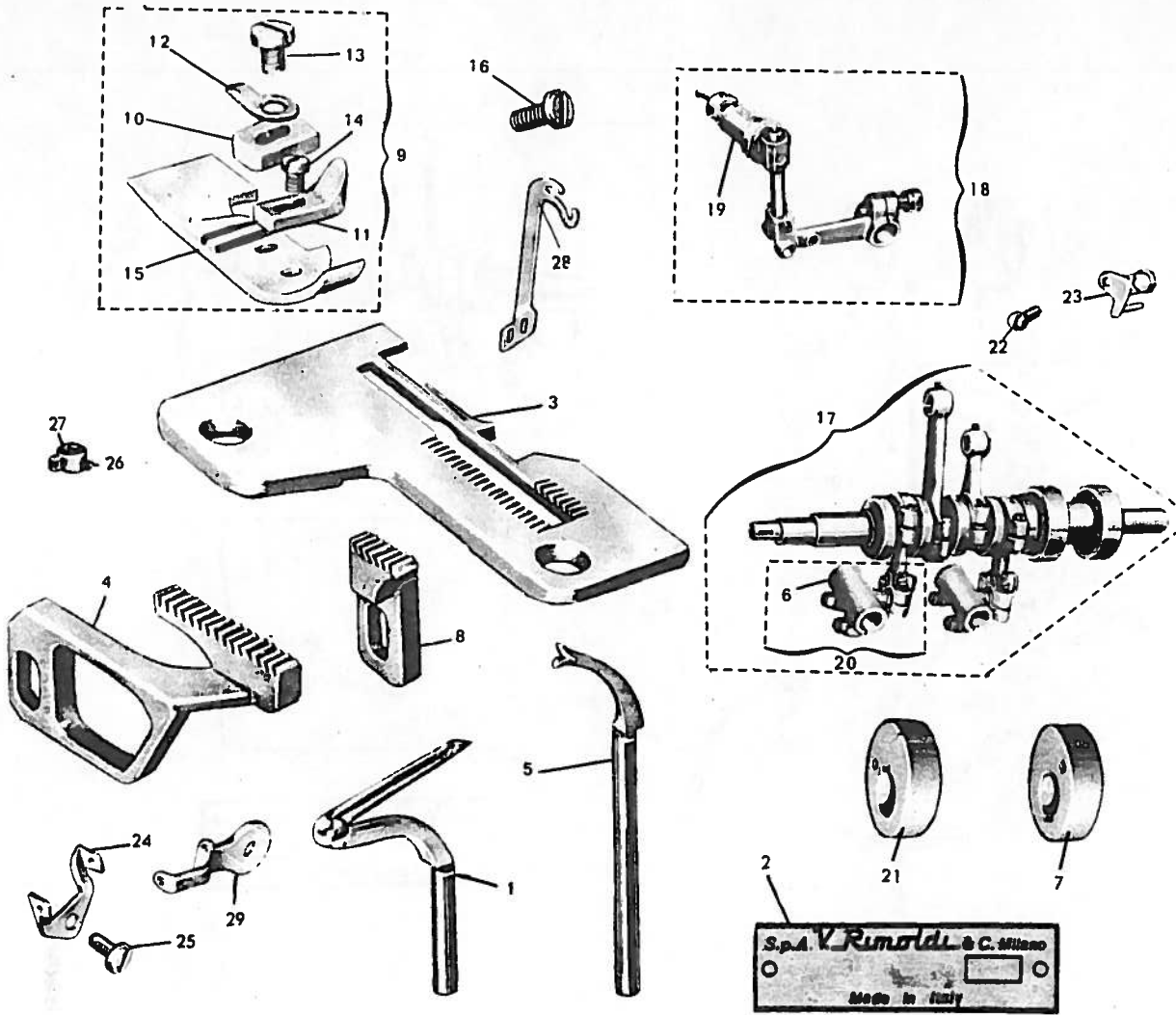


| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|-------------|----------------------------------|--------|---------|-------------|-----------------------------------|--------|
| 1 | 270-075 | lower looper | 1 | 5 | 27.01-1141 | needle plate bight width 1/8" | 1 |
| 2 | 27.01-0501 | feed dog main | 1 | 6 | 280-0451/10 | eccentric for main feed dog | 1 |
| 3 | 781005-0-00 | name plate showing machine class | 1 | 7 | 280-0461/14 | eccentric for subsidiary feed dog | 1 |
| 4 | 27.277-0745 | looper upper | 1 | | | | |
| | | | | | | On request: | |
| | | | | | 270-401 | see Tab. 38 | |
| | | | | | 270-075/2 | see Tab. 38 | |
| | | | | | 27.277-074 | see Tab. 38 | |
| | | | | | 270-D-074/1 | see Tab. 38 | |
| | | | | | PM.270-1882 | see Tab. 38 | |
| | | | | | G.274-401 | see Tab. 38 | |
| | | | | | 001-D-7 | see Tab. 38 | |

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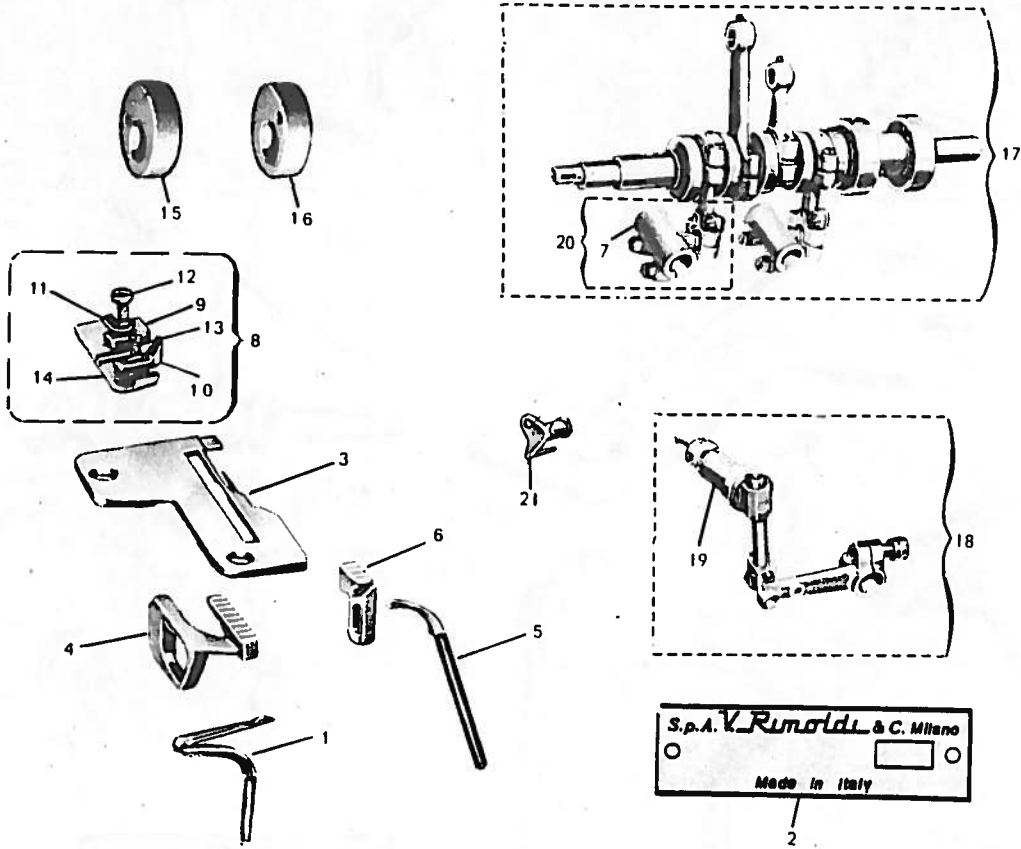


| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|------------------|--------------------------------------|--------|---------|------------------|--|--------|
| 1 | 001-D-7 | screw guide block fixing | 1 | 23 | 001-G-10 | screw | 1 |
| 2 | 003-M-7 | screw cap | 3 | 24 | G.27.21-C-700 | tensions assembly | 1 |
| 3 | 270-075 | lower looper | 1 | 25 | 27.21-C-702 | guide block | 1 |
| 4 | 270-263 | thread guide for needle | 1 | 26 | 057-R-5 | nut | 2 |
| 5 | 270-270 | tensioner upper looper thread | 1 | 27 | PM.27.21-C-708 | shaft with discs | 1 |
| 6 | 270-274 | take-up, needle thread | 1 | 28 | 27.21-C-708 | shaft | 1 |
| 7 | 781006-0-00 | name plate showing machine class | 1 | 29 | 250-031 | disc. tensioner | 6 |
| 8 | 27.21-C-220 | guard, feed dog | 1 | 30 | 27.21-C-709 | spacer | 1 |
| 9 | 270-074 | upper looper | 1 | 31 | 240-035 | retainer spring | 1 |
| 10 | 27.21-C2-059 | coupling | 1 | 32 | 27.21-C-232 | spring | 1 |
| 11 | PM.27.21-C-050 | feed dog main | 1 | 33 | 3710 | knob | 1 |
| 12 | PM.28.21-C-051 | feed dog subsidiary | 1 | 34 | G.27.21-C-703 | plate with bush | 1 |
| 13 | PM.27.21-C-114/1 | needle plate bight width 3/64" 1/16" | 1 | 35 | G.27.21-C-7o4 | thread pulley with shaft | 1 |
| 14 | G.27.21-C-181/2 | assembly presserfoot | 1 | 36 | 3707 | shaft | 1 |
| 15 | 27.21-C-191/2 | tongue | 1 | 37 | 270-701 | snap ring | 1 |
| 16 | 270-183 | block | 1 | 38 | PM.27.21-C-704 | thread pulley | 1 |
| 17 | 278-184/C2 | slide | 1 | 39 | 280-0461/40 | eccentric for subsidiary and main feed dog | 2 |
| 18 | 270-196 | locator | 1 | 40 | G.27.21-C2-067/3 | looper drive shaft with con-rods | 1 |
| 19 | 004-L-7 | screw | 1 | 41 | G.28.21-C2-009 4 | main shaft assembly with con-rod | 1 |
| 20 | 270-989 | screw fixing block | 1 | 42 | 27.21-C2-056 | bush eccentric | 1 |
| 21 | AS.27.21-C-700 | tensions assembly and thread pulley | 1 | 43 | PM.27.21-C2-059 | con-rod with coupling | 1 |
| 22 | 27.21-C-983 | bolt | 1 | 44 | 004-A-5 | screw fixing needle tensioner | 1 |
| | | | | 45 | G.270-262/2 | thread take-up needle thread | 1 |
| | | | | 46 | 270-269/1 | tensioner lower looper thread | 1 |
| | | | | 47 | 036-C-7 | screw for looper thread tensioner | 2 |
| | | | | 48 | 016 B-2,5 | screw fixing thread guide | 1 |
| | | | | 49 | 270-271 | thread guide for lower looper thread | 1 |
| | | | | 50 | 004-L-6 | screw fixing thread tensioner | 1 |
| | | | | 51 | 270-272 | tensioner lower looper thread | 1 |
| | | PM 27.21-C-114 see Tab. 38 | | | | | |
| | | G 27.21 C 181 see Tab. 38 | | | | | |
| | | G 27.21 C 181/1 see Tab. 38 | | | | | |

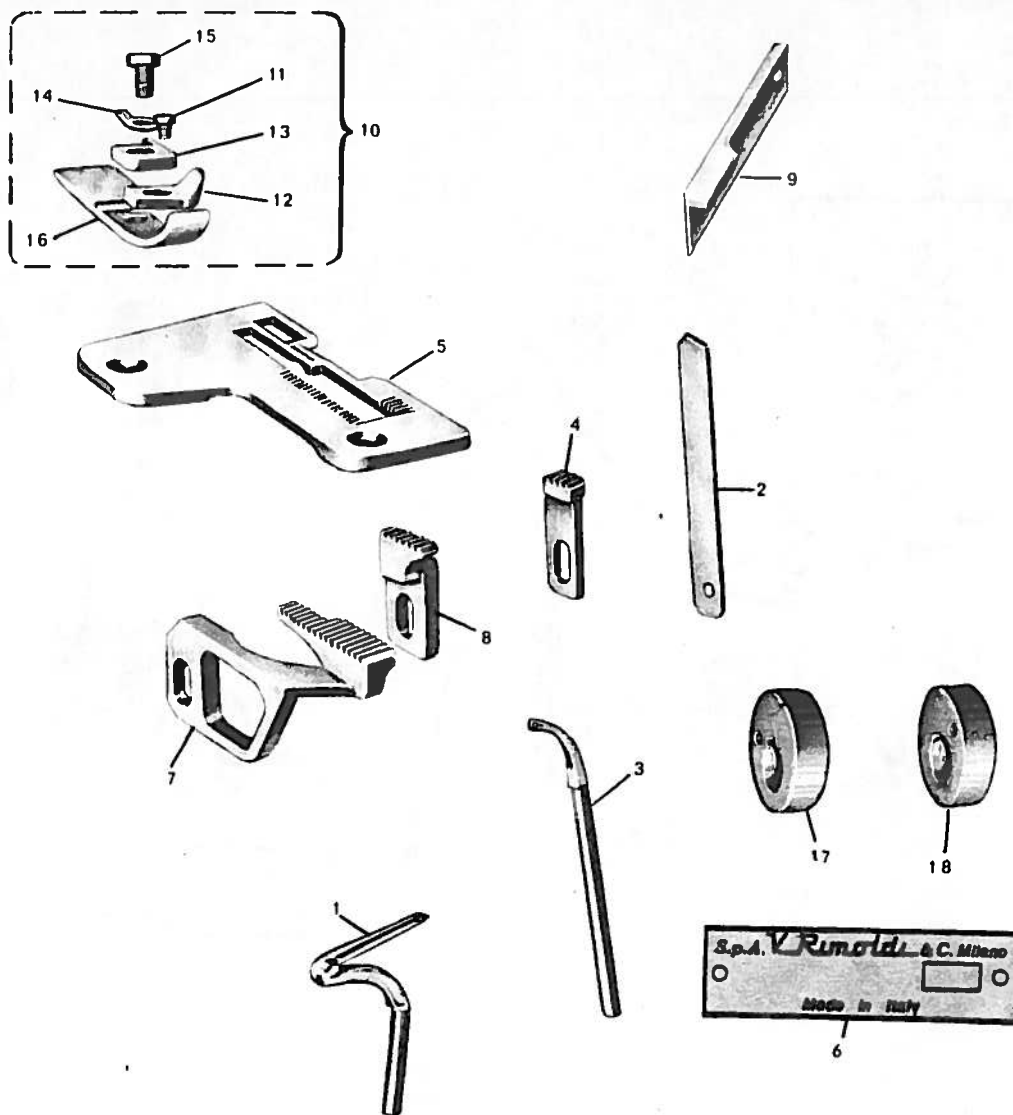


| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|----------------|--|--------|---------|------------------|--------------------------------------|--------|
| 1 | 270-075 | looper lower | 1 | 11 | 270-183 | plate | 1 |
| 2 | 781007-0-00 | name plate showing machine class | 1 | 12 | 270-196 | locator | 1 |
| 3 | 27.21-1143 | needle plate | 1 | 13 | 004-L-7 | screw | 1 |
| 4 | 27.21-C-050 | feed dog main | 1 | 14 | 270-989 | screw | 1 |
| 5 | 27.221-C-074/1 | looper upper blind | 1 | 15 | 27.21-C-184 | slide | 1 |
| 6 | 27.21-C2-059 | coupling | 1 | 16 | 003-M-7 | screw cap | 1 |
| 7 | 280-0461/6 | eccentric for subsidiary and main feed dog | 1 | 17 | G.28.21-C2009/4 | main shaft assembly with con-rod | 1 |
| 8 | 289-051 | feed dog subsidiary | 1 | 18 | G.27.21-C2-067/3 | looper drive shaft with con-rods | 1 |
| 9 | G.27.21-CC-181 | assembly presserfoot | 1 | 19 | 27.21-C2-056 | bush eccentric | 1 |
| 10 | 27.21-CC-191 | tongue | 1 | 20 | PM.27.21-C2-059 | con-rod with coupling | 1 |
| | | | | 21 | 280-0461/30 | eccentric for subsidiary feed dog | 1 |
| | | | | 22 | 004 A-5 | screw fixing needle tensioner | 1 |
| | | | | 23 | G 270-262/2 | thread take-up-needle thread | 1 |
| | | | | 24 | 270-269/1 | tensioner lower looper thread | 1 |
| | | | | 25 | 036 C-7 | screw for looper thread tensioner | 2 |
| | | | | 26 | Q16 B-2.5 | screw fixing thread guide | 1 |
| | | | | 27 | 270-271 | thread guide for lower looper thread | 1 |
| | | | | 28 | 270-274/3 | take-up, needle thread | 1 |
| | | | | 29 | 270-272 | tensioner lower looper thread | 1 |

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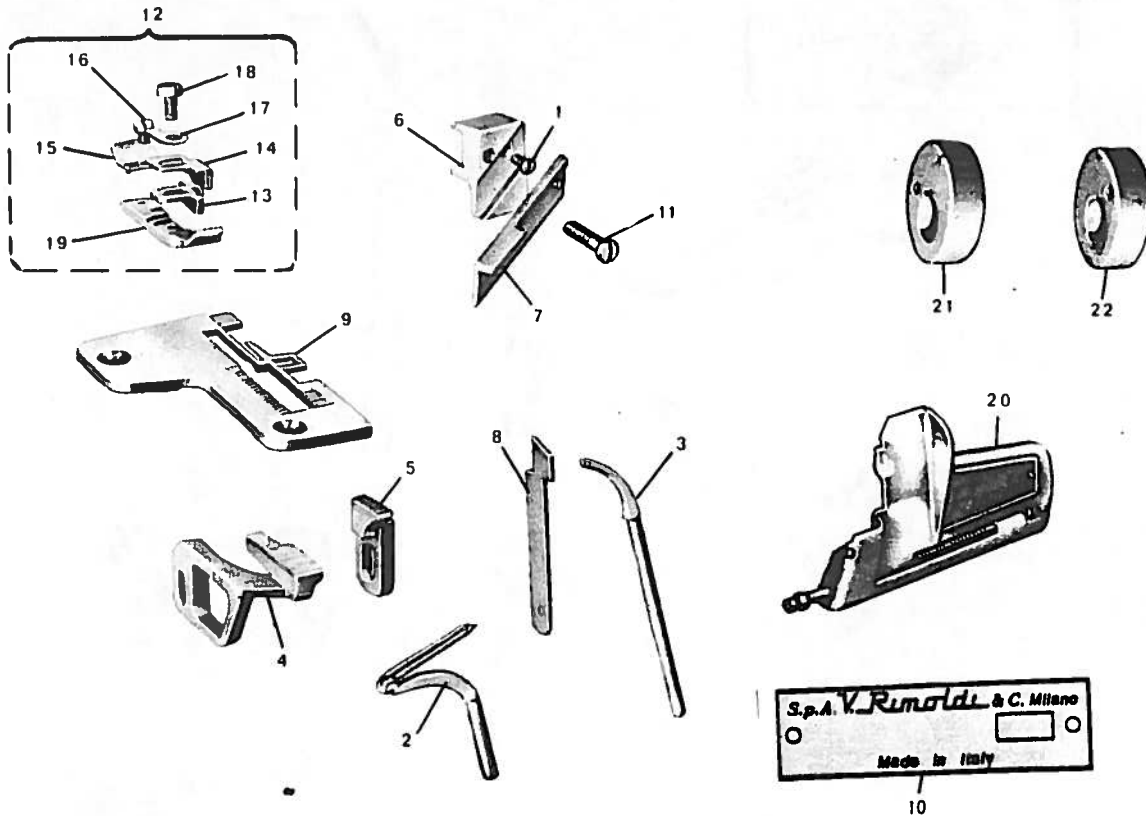


| N° RIF. | N° DISEGNO | DENOMINAZIONE | QUANT. | N° RIF. | N° DISEGNO | DENOMINAZIONE | QUANT. |
|---------|----------------|--|--------|---------|------------------|-----------------------------------|--------|
| 1 | 270-0751 | looper lower | 1 | 12 | 004-L-7 | screw fixing tongue | 1 |
| 2 | 281008-0-00 | name plate showing machine class | 1 | 13 | 270-989 | screw fixing block | 1 |
| 3 | 27.21-1141 | needle plate bight width 3/64" - 1/16" | 1 | 14 | 27.21-C-184 | slide | 1 |
| 4 | 27.21-C-050 | feed dog main | 1 | 15 | 280-0461/16 | eccentric for subsidiary feed dog | 1 |
| 5 | 270-074 | looper, upper, with hole | 1 | 16 | 280-0461.18 | eccentric for main feed dog | 1 |
| 6 | 289-051 | feed dog subsidiary | 1 | 17 | G.28.21-C2009 4 | main shaft assembly with con-rod | 1 |
| 7 | 27.21-C2-059 | coupling | 1 | 18 | G.27.21-C2-067/3 | looper drive shaft with con-rods | 1 |
| 8 | G.27.21-CC-181 | assembly presserfoot | 1 | 19 | 27.21-C2-056 | bush eccentric | 1 |
| 9 | 27.21-CC-191 | tongue | 1 | 20 | PM.27.21-C2-059 | con-rod with coupling | 1 |
| 10 | 270-183 | block | 1 | 21 | G.270-262/3 | thread take-up complete | 1 |
| 11 | 270-196 | locator | 1 | | | | |
| | | | | | | On request: | |
| | | | | | 27.21-1143 | see Tab 38 | |
| | | | | | 272-092 | see Tab 38 | |

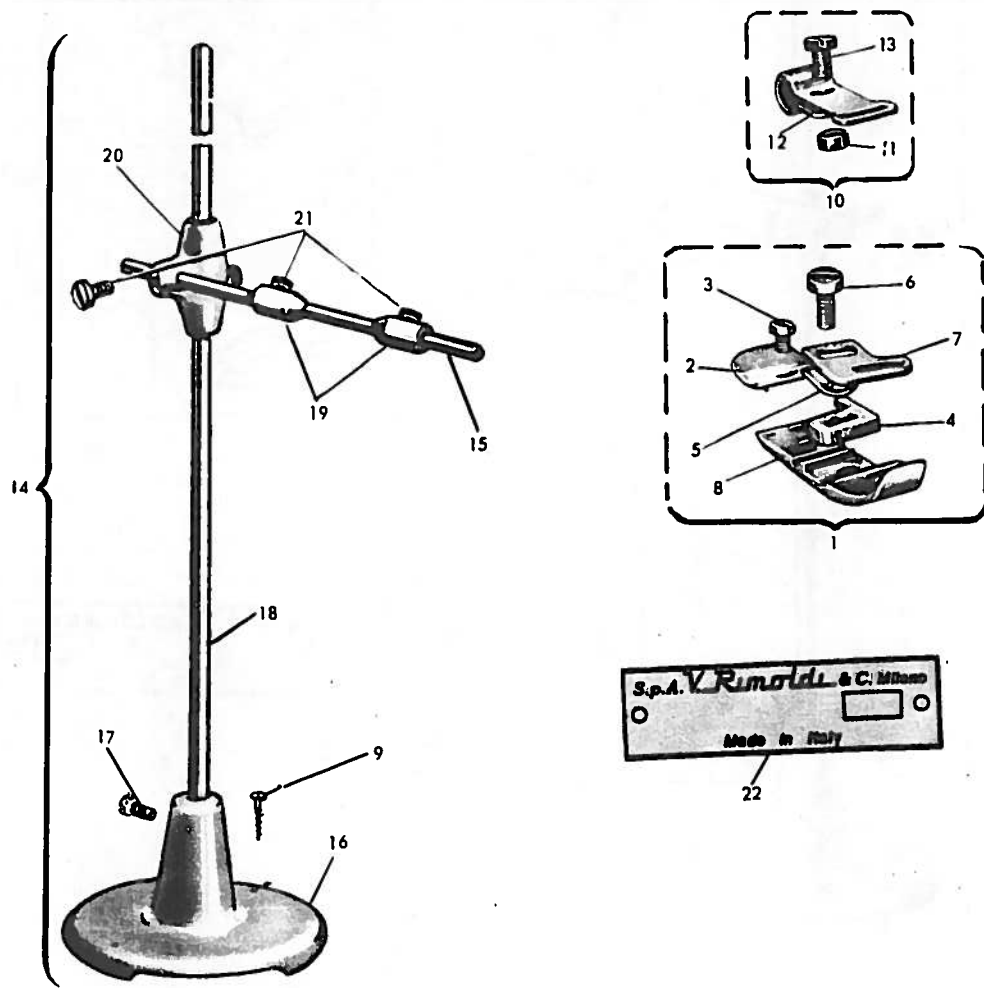


| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|----------------|--------------------------------|--------|---------|-------------|-----------------------------------|--------|
| 1 | 270-075 | looper lower | 1 | 10 | G.278-181 | presserfoot assembly complete | 1 |
| 2 | 27.01-P9-113/1 | knife lower | 1 | 11 | 270-989 | screw fixing block | 1 |
| 3 | 27.277-0745 | looper upper | 1 | 12 | 270-183 | block | 1 |
| 4 | 278-052 | feed dog | 1 | 13 | 278-191 | tongue | 1 |
| 5 | 278-114 | needle plate bight width 5/64" | 1 | 14 | 270-196 | locator | 1 |
| 6 | 781011-0-00 | plate machine class | 1 | 15 | 004-L-7 | screw fixing tongue | 1 |
| 7 | 279-050 | feed dog main | 1 | 16 | 278-184 | shoe | 1 |
| 8 | 289-051 | feed dog subsidiary | 1 | 17 | 280-0451/12 | eccentric for subsidiary feed dog | 1 |
| 9 | 279-112 | knife upper | 1 | 18 | 280-0461/14 | eccentric for main feed dog | 1 |
| | | | | | 278-114/1 | On request: see Tab. 38 | |

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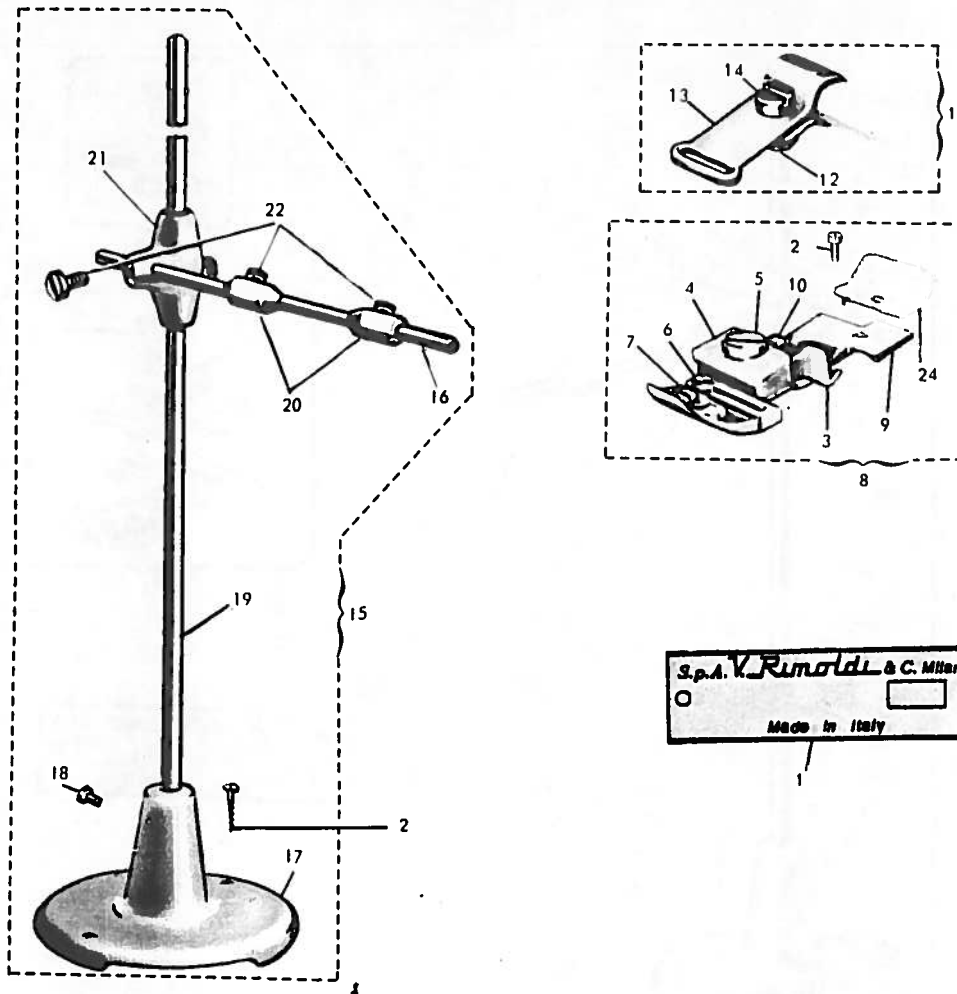


| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|-------------|--------------------------------|--------|---------|-------------|-----------------------------------|--------|
| 1 | 028-B-8 | screw fixing block | 1 | 12 | G.279-181 | presserfoot complete | 1 |
| 2 | 270-075 | looper lower | 1 | 13 | 279-191 | tongue | 1 |
| 3 | 27.277-0745 | looper upper | 1 | 14 | PM.279-183 | block | 1 |
| 4 | 279-050 | feed dog main | 1 | 15 | 275-185 | plate | 1 |
| 5 | 289-051 | feed dog subsidiary | 1 | 16 | 001-A-3,2 | screw fixing plate | 1 |
| 6 | 279-099 | block upper knife holding | 1 | 17 | 270-196 | locator | 1 |
| 7 | 279-112 | knife upper | 1 | 18 | 004 L-7 | screw fixing tongue | 1 |
| 8 | 279-113/1 | knife lower | 1 | 19 | 279-184 | shoe | 1 |
| 9 | 279-114 | needle plate bight width 5/64" | 1 | 20 | G.279-216/2 | cover plate, front, complete | 1 |
| 10 | 781012-0-00 | plate machine class | 1 | 21 | 280-0451/12 | eccentric for subsidiary feed dog | 1 |
| 11 | 279-987 | screw fixing upper knife | 1 | 22 | 280-0461/14 | eccentric for main feed dog | 1 |
| | | | | | | On request: | |
| | | | | | 270-075/2 | see Tab. 38 | |
| | | | | | 27.277-074 | see Tab. 38 | |

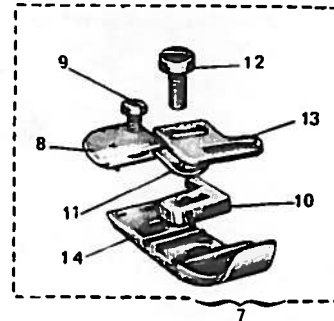
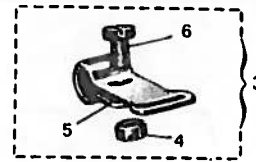
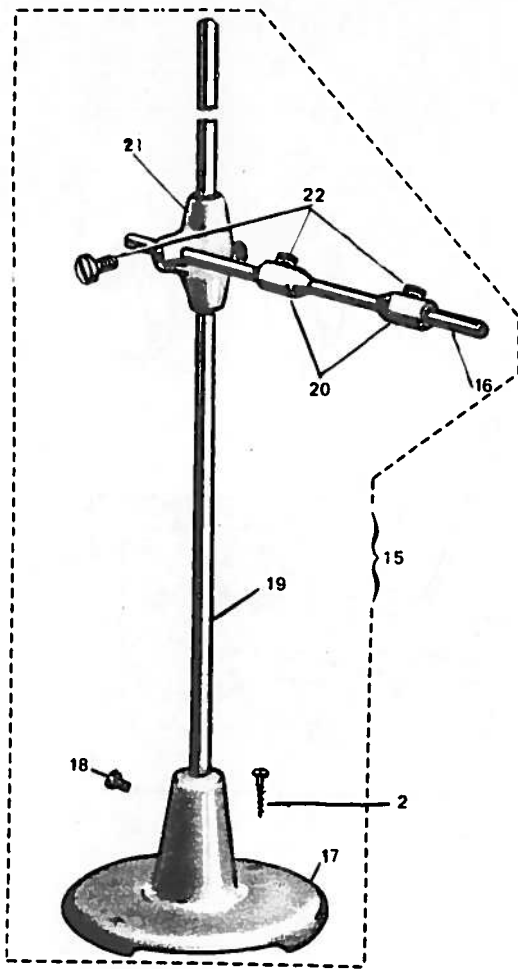


| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|--------------|----------------------|--------|---------|--------------|------------------------|--------|
| 1 | G.270-R-181 | presserfoot complete | 1 | 12 | 270-R-267 | guide tape | 1 |
| 2 | 270-185 | plate | 1 | 13 | 001-C-5,5 | screw | 1 |
| 3 | 001-A-3,2 | screw | 1 | 14 | G.250-R-9373 | support bobbin carrier | 1 |
| 4 | 270-191 | tongue | 1 | 15 | 605-144 | rod upper | 1 |
| 5 | 270-196 | locator | 1 | 16 | 01141 | base | 1 |
| 6 | 004-L-8 | screw | 1 | 17 | 001-G-12 | screw | 1 |
| 7 | 270-R-071 | plate | 1 | 18 | 605-143 | rod | 1 |
| 8 | 270-R-184 | shoe | 1 | 19 | 605-723 | rings cone | 2 |
| 9 | TS.20 x 30 | screw | 2 | 20 | 605-937 | support | 1 |
| 10 | PM.270-R-267 | guide tape | 1 | 21 | 605-980 | screw | 4 |
| 11 | 057-A-3 | nut | 1 | 22 | 781030-0-00 | plate machine class | 1 |

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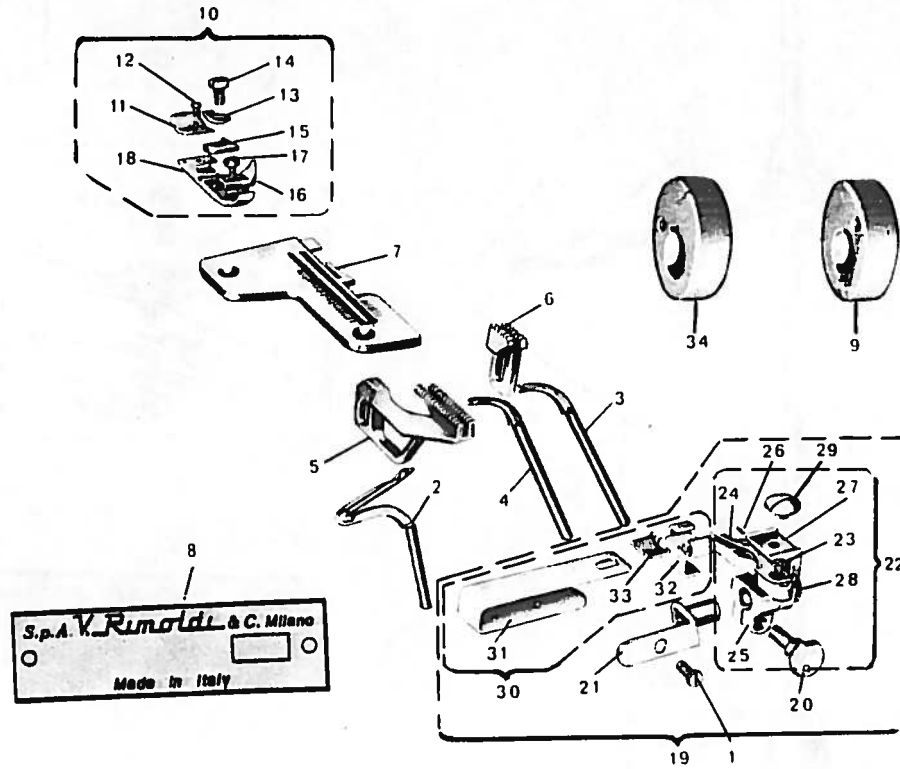


| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|----------------|----------------------|--------|---------------------------|--------------|------------------------------|--------|
| 1 | 781031-0-00 | plate machine class | 1 | 13 | 270-R-267 | guide tape | 1 |
| 2 | 001-A-3,2 | screw plate fixing | 1 | 14 | 001-C-5,5 | bolt | 1 |
| 3 | 277-191 | tongue presserfoot | 1 | 15 | G.250-R-9373 | holder reel | 1 |
| 4 | 27.77-183 | plate | 1 | 16 | 605-144 | rod upper | 1 |
| 5 | 004-L-9 | screw tongue fixing | 1 | 17 | 01141 | base | 1 |
| 6 | 27.277-R-071 | plate tape guiding | 1 | 18 | 001-G-12 | screw | 1 |
| 7 | 004-G-3 | screw plate fixing | 1 | 19 | 605-143 | rod | 1 |
| 8 | G.277-R-181 | presserfoot complete | 1 | 20 | 605-723 | ring conical | 2 |
| 9 | 277-R-184 | shoe presserfoot | 1 | 21 | 605-937 | support | 1 |
| 10 | 27.77-196 | locator | 1 | 22 | 605-980 | knob | 4 |
| 11 | PM.27.77-R-267 | guide tape | 1 | 23 | TS. 20 x 30 | screw for fixing reel holder | 2 |
| 12 | 057-A-3 | nut | 1 | 24 | 277-185 | plate chain guide | 1 |
| | | | | On request: | | | |
| | | | | 270-075/2 see Tab. 38 | | | |
| | | | | 27-277-074 see Tab. 38 | | | |
| | | | | 28.00-87-0511 see Tab. 38 | | | |

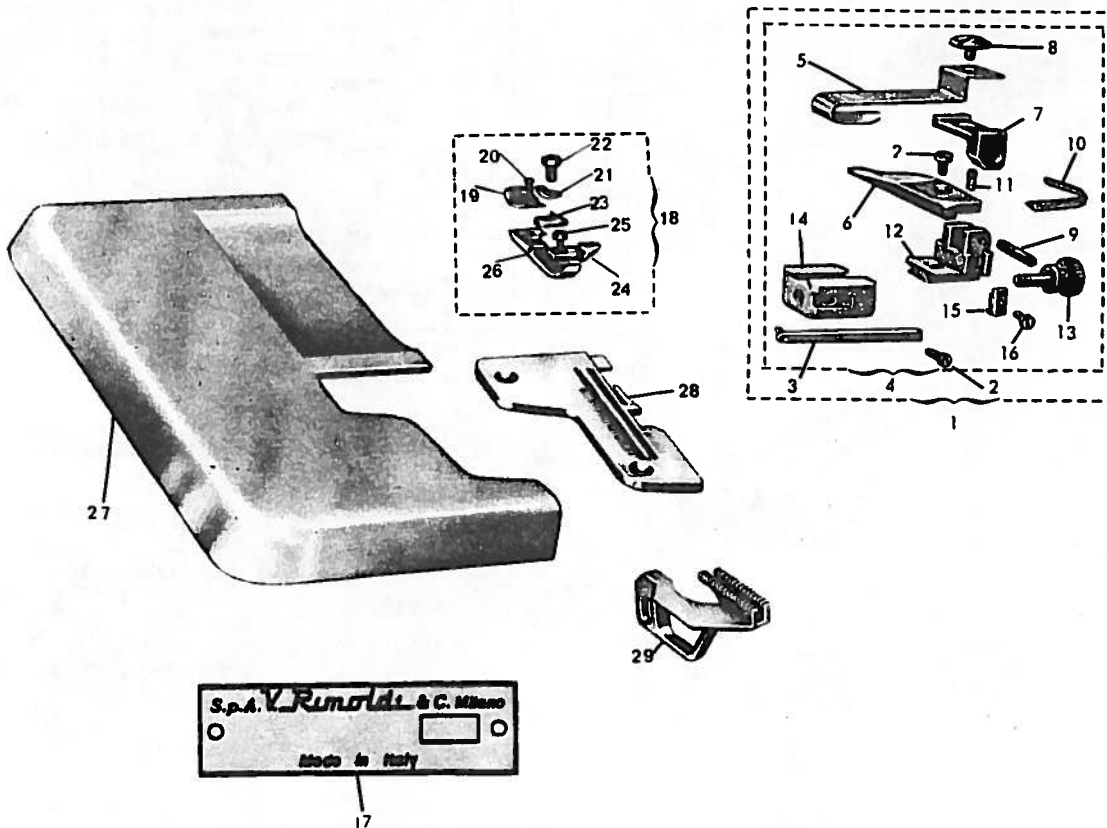


| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|--------------|----------------------|--------|---------|--------------|--------------|--------|
| 1 | 781032-0-00 | plate machine class | 1 | 12 | 004-L-8 | bolt | 1 |
| 2 | TS 20 x 30 | screw | 2 | 13 | 270-R-071 | plate | 1 |
| 3 | PM.270-R-267 | tape guide | 1 | 14 | 270-R-184 | shoe | 1 |
| 4 | 057-A-3 | nut | 1 | 15 | G.250-R-9373 | holder reel | 1 |
| 5 | 270-R-267 | tape guide | 1 | 16 | 605-144 | rod upper | 1 |
| 6 | 001-C-5,5 | bolt | 1 | 17 | 01141 | base | 1 |
| 7 | G.270-R-181 | presserfoot complete | 1 | 18 | 001-G-12 | screw | 1 |
| 8 | 270-185 | plate | 1 | 19 | 605-143 | rod | 1 |
| 9 | 001-A-3,2 | screw fixing plate | 1 | 20 | 605-723 | ring conical | 2 |
| 10 | 270-191 | tongue | 1 | 21 | 605-937 | support | 1 |
| 11 | 270-196 | locator | 1 | 22 | 605-980 | screw | 4 |

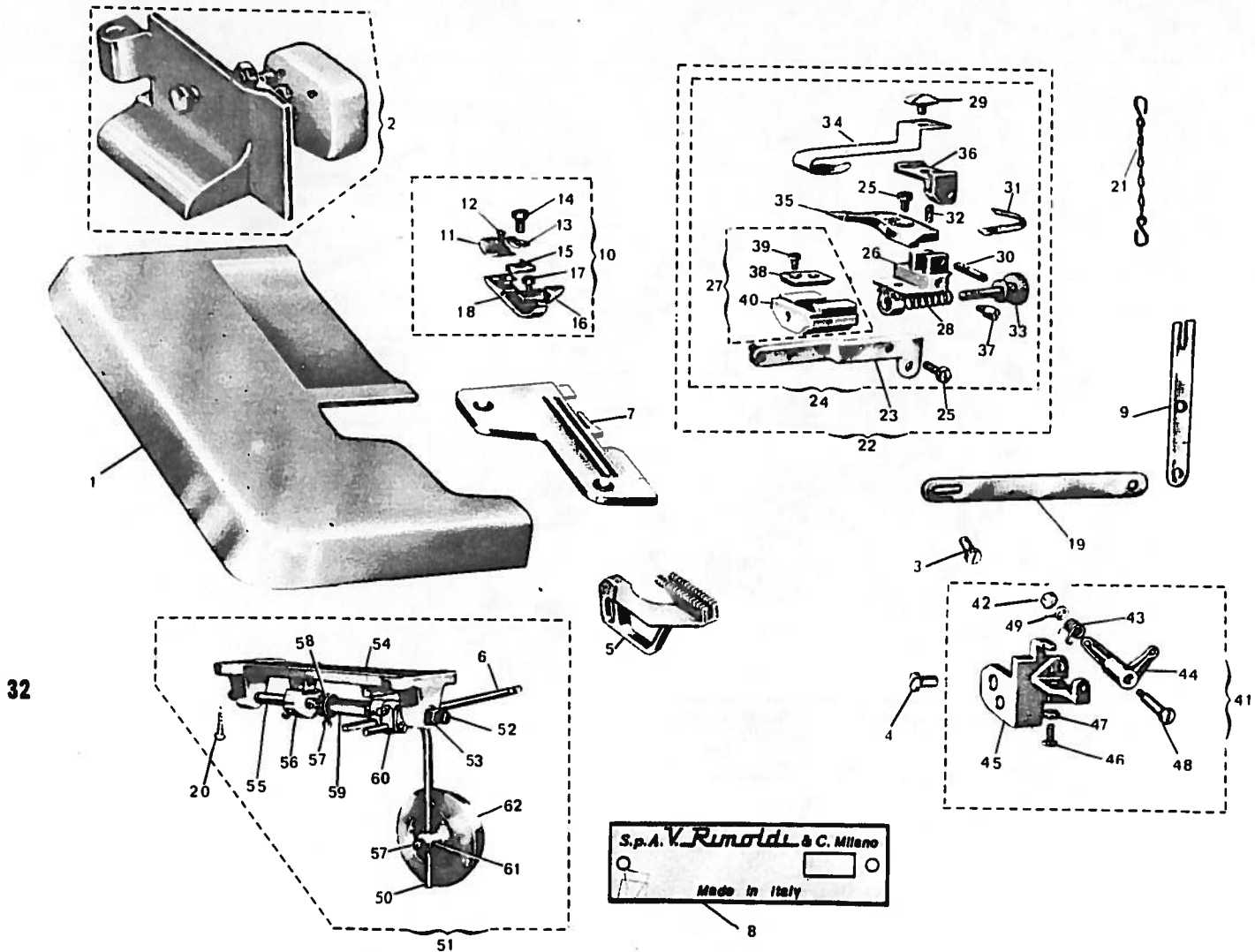
30



| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|-------------|-----------------------------------|--------|-------------|------------|-----------------------------|--------|
| 1 | 001-D-7 | screw for fixing guide | 1 | 18 | 275-1B4 | shoe | 1 |
| 2 | 270-075 | looper lower | 1 | 19 | AS 275-413 | hemming guide complete | 1 |
| 3 | 270-D-074/1 | looper upper blind | 1 | 20 | 275-426 | bolt | 1 |
| 4 | 27-277-0745 | looper upper with eye | 1 | 21 | PM 275-417 | support | 1 |
| 5 | 275-050 | feed dog main | 1 | 22 | PM 275-408 | body guide | 1 |
| 6 | 285-051 | feed dog subsidiary | 1 | 23 | 275-403 | screw | 1 |
| 7 | 275-114 | needle plate bight width 1/8" | 1 | 24 | 275-411 | plate | 1 |
| 8 | 781060-0-00 | plate machine class | 1 | 25 | 275-408 | body guide | 1 |
| 9 | 280-0451/12 | eccentric for subsidiary feed dog | 1 | 26 | 275-410 | pin | 2 |
| 10 | G.275-181 | presserfoot complete | 1 | 27 | 275-409 | hinge | 1 |
| 11 | 275-185 | plate | 1 | 28 | 275-425 | knob | 1 |
| 12 | 001-A-3,2 | screw plate fixing | 1 | 29 | 275-404 | screw | 1 |
| 13 | 270-196 | locator | 1 | 30 | PM 275-407 | plate with spring | 1 |
| 14 | 004-L-7 | screw tongue fixing | 1 | 31 | 275-407 | plate | 1 |
| 15 | 275-191 | tongue | 1 | 32 | 275-415 | guide sliding | 1 |
| 16 | 275-183 | block | 1 | 33 | 275-416 | spring | 1 |
| 17 | 270-989 | screw | 1 | 34 | 280-0451/8 | eccentric for main feed dog | 1 |
| | | | | | | On request: | |
| | | | | 270-075 2 | | see tab. 38 | |
| | | | | 27-277-074 | | see tab. 38 | |
| | | | | 275-1141 | | see tab. 38 | |
| | | | | PM 275-1882 | | see tab. 38 | |
| | | | | 285-0511 | | see tab. 38 | |

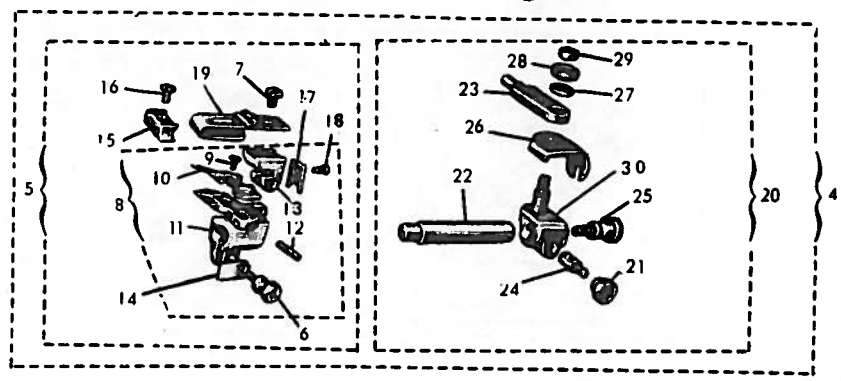
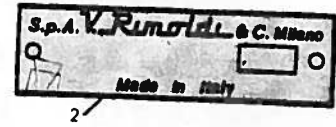
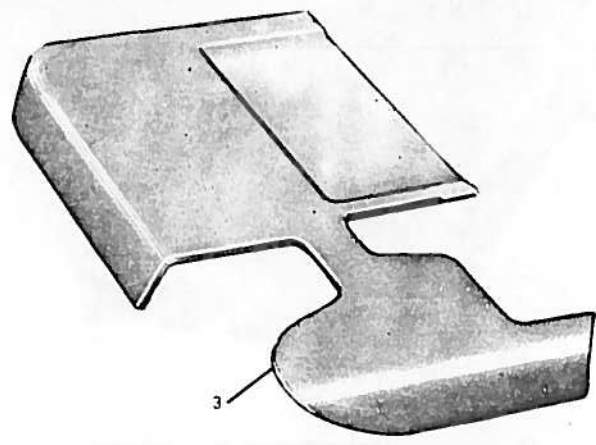


| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|--------------|------------------------|--------|---------|----------------|-------------------------------|--------|
| 1 | AS.275-B-413 | hemming guide complete | 1 | 16 | 005-D-5 | screw | 1 |
| 2 | 001-D-6 | screw | 2 | 17 | 781061-0-00 | plate machine class | 1 |
| 3 | PM.275-B-417 | support | 1 | 18 | G.275-B-181 | presserfoot complete | 1 |
| 4 | G.275-B-413 | guide hemming | 1 | 19 | 275-185 | plate | 1 |
| 5 | 275-B-407 | plate hemming | 1 | 20 | 001-A-3,2 | screw plate fixing | 1 |
| 6 | 275-B-411 | guide | 1 | 21 | 275-B-196 | locator | 1 |
| 7 | 275-B-409 | block | 1 | 22 | 004-L-7 | screw tongue fixing | 1 |
| 8 | 275-404 | screw | 1 | 23 | 275-B-191 | tongue | 1 |
| 9 | 275-B-410 | pin threaded | 1 | 24 | 275-B-183 | block | 1 |
| 10 | 275-B-430 | spring leaf | 1 | 25 | 270-989 | screw | 1 |
| 11 | 275-B-403 | screw stop | 1 | 26 | 275-B-184 | shoe | 1 |
| 12 | 275-B-406 | slide | 1 | 27 | G.275-B-210/3 | work plate | 1 |
| 13 | 275-B-425 | screw adjustment | 1 | 28 | 275-B-114 | needle plate bight width 1/8" | 1 |
| 14 | 275-B-408 | body guide | 1 | 29 | 275-B-050 | feed dog main | 1 |
| 15 | 275-B-418 | locator | 1 | | | | |
| | | | | | | On request: | |
| | | | | | AS 275-B-413/1 | Tab. 39 | |

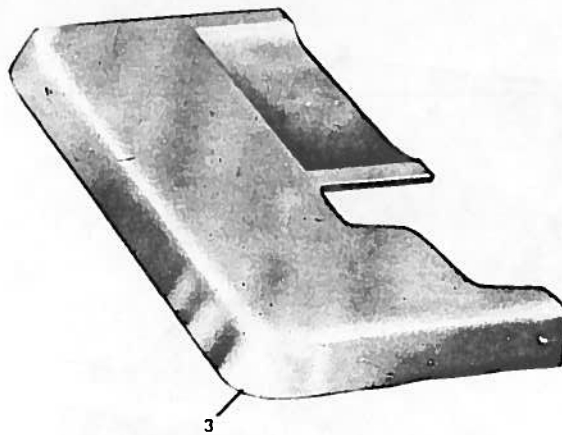


| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|-----------------|-------------------------------|--------|---------|---------------|---------------------------------|--------|
| 1 | G.275-B-210/3 | work plate | 1 | 31 | 275-B-430 | spring leaf | 1 |
| 2 | G.282-BK-209/1 | cover side | 1 | 32 | 275-B-403 | screw stop | 1 |
| 3 | 012-H-5 | screw for lever junction | 3 | 33 | 275-BS-4252 | screw adjustment | 1 |
| 4 | 001-G-10 | screw fixing lever assembly | 2 | 34 | 275-B-407 | plate hem | 1 |
| 5 | 275-B-050 | feed dog main | 1 | 35 | 275-B-411 | guide | 1 |
| 6 | 620-565 | rod | 1 | 36 | 275-B-409 | block | 1 |
| 7 | 275-B-114 | needle plate bight width 1/8" | 1 | 37 | 275-BS-6412 | pin threaded | 1 |
| 8 | 781062-0-00 | plate machine class | 1 | 38 | 275-BS-4142 | guide | 1 |
| 9 | 275-BS-6002 | lever moving vertical guide | 1 | 39 | 004-A-3,2 | screw | 2 |
| 10 | G.275-B-181 | presserfoot complete | 1 | 40 | 275-BS-4082 | body | 1 |
| 11 | 275-185 | plate | 1 | 41 | G.275-BS-6012 | lever assembly for moving guide | 1 |
| 12 | 001-A-3,2 | screw fixing plate | 1 | 42 | 053-D-4 | nut | 1 |
| 13 | 275-B-196 | locator | 1 | 43 | 275-BS-6052 | spring | 1 |
| 14 | 004-L-7 | screw fixing tongue | 1 | 44 | 275-BS-6032 | transmission | 1 |
| 15 | 275-B-191 | tongue | 1 | 45 | 275-BS-6012 | support | 1 |
| 16 | 275-B-183 | block | 1 | 46 | 039-D-5 | screw | 1 |
| 17 | 270-989 | screw | 1 | 47 | 057-B-3 | nut | 1 |
| 18 | 275-B-184 | shoe | 1 | 48 | 275-BS-6062 | pin | 1 |
| 19 | 275-BS-5992 | lever horizontal connecting | 1 | 49 | 063-N-4 | washer | 1 |
| 20 | TS. 22 x 35 | screw fixing knee control | 1 | 50 | 270-573 | rod | 1 |
| 21 | PM. 275-BS-1482 | chain | 4 | 51 | G. 620-570 | knee control complete | 1 |
| 22 | AS 275-BS-4132 | assembly movable hem guide | 1 | 52 | 270-998 | screw pointed | 2 |
| 23 | PM.275-BS-4172 | support | 1 | 53 | 059-P.8 | nut hexagonal | 2 |
| 24 | G.275-BS-4132 | guide complete | 1 | 54 | 620 570 | support | 1 |
| 25 | 001-D-6 | screw | 2 | 55 | 270-571 | shaft | 1 |
| 26 | 275-BS-4062 | slide | 1 | 56 | 270-579 | anchor | 1 |
| 27 | PM.275-BS-4082 | body guide | 1 | 57 | 038-M-9 | screw hexagonal | 9 |
| 28 | 275-BS-4152 | spring | 1 | 58 | 270-720 | ring spring tensioning | 1 |
| 29 | 275-404 | screw | 1 | 59 | 270-575 | spring | 1 |
| 30 | 275-B-410 | pin threaded | 1 | 60 | 620-572 | union | 2 |
| | | | 1 | 61 | 270-574 | disc | 1 |
| | | | 1 | 62 | 270-582 | pad disc | 1 |

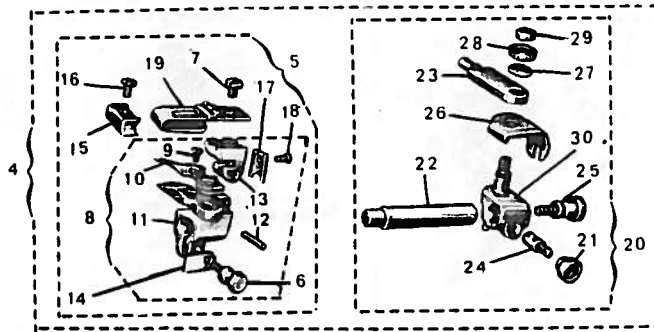
On request:
AS.275-BS-4132 1 Tab 39



| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|---------------|---------------------|--------|---------|--------------|----------------------|--------|
| 1 | 039-R-8,5 | body guide fixing | 1 | 16 | 255-404 | screw | 1 |
| 2 | 781064-0-00 | plate machine clas | 1 | 17 | 27.53-2221 | plate guide blocking | 1 |
| 3 | G.27.53-210/3 | washer plate comple | 1 | 18 | 001-C-4 | screw | 1 |
| 4 | AS.27.53-4132 | heating guide iron | 1 | 19 | PM.255-434 | spring with hinge | 1 |
| 5 | PM.27.53-4081 | guide | 1 | 20 | G.27.53-3792 | attachment complete | 1 |
| 6 | 275-426 | screw locking | 1 | 21 | 250-980 | knob | 1 |
| 7 | 275-404 | screw | 1 | 22 | 27.53-4011 | rod | 1 |
| 8 | PM.275-408 | body with hinge | 1 | 23 | 27.53-4172 | support | 1 |
| 9 | 275-404 | screw | 2 | 24 | 27.53-4181 | pawl | 1 |
| 10 | 275-411 | plate | 1 | 25 | 27.53-4251 | knob | 1 |
| 11 | 275-408 | body side | 1 | 26 | 27.53-2201 | washer spring | 1 |
| 12 | 275-410 | pin | 1 | 27 | 27.53-4121 | knob | 1 |
| 13 | 275-409 | hinge | 1 | 28 | 27.53-4261 | nut | 1 |
| 14 | 27.53-2231 | plate stop | 1 | 29 | 27.53-2211 | nut | 1 |
| 15 | 255-415 | block | 1 | 30 | 27.53-4071 | support rotating | 1 |

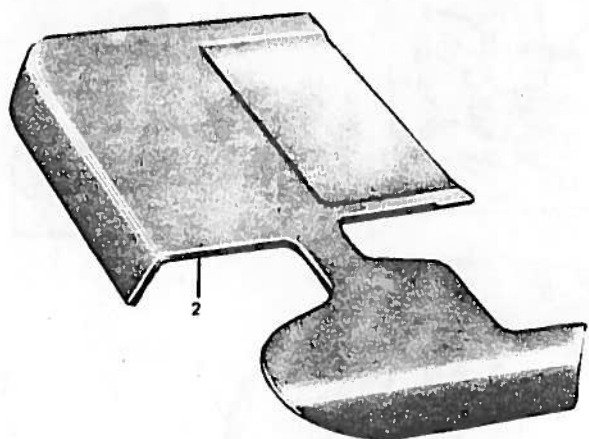


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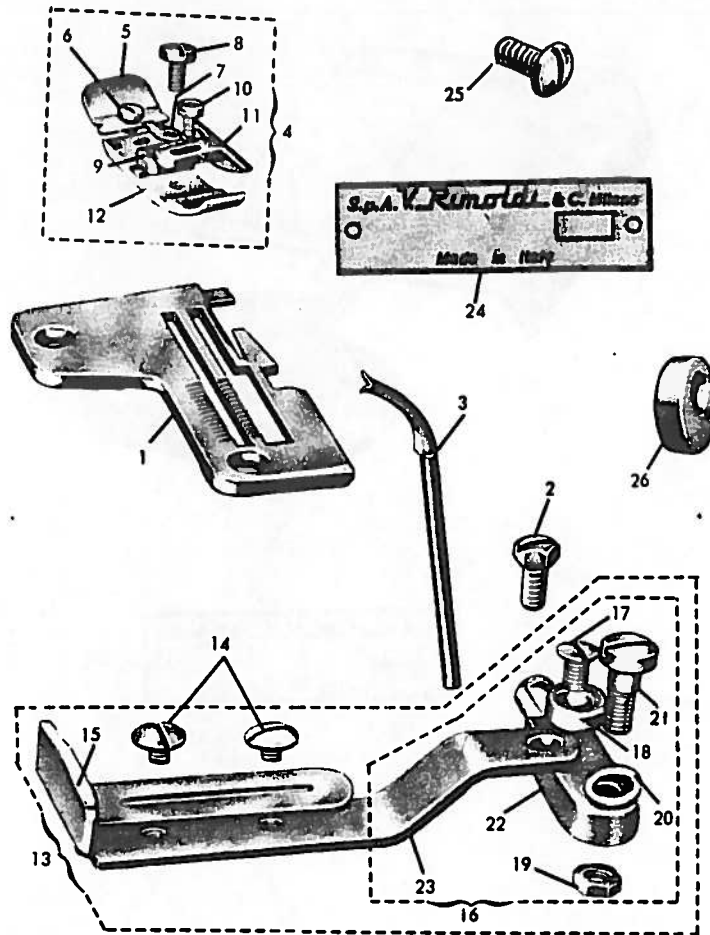


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| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|---------------|------------------------|--------|---------|--------------|----------------------|--------|
| 1 | 039-R-8,5 | screw guide fixing | 1 | 16 | 255-404 | screw | 1 |
| 2 | 781065-0-00 | plate machine class | 1 | 17 | 27 53-2221 | plate guide blocking | 1 |
| 3 | G.27.54-210/3 | work plate complete | 1 | 18 | 001-C-4 | screw | 1 |
| 4 | AS.27.53-4132 | hemming guide complete | 1 | 19 | PM.255-434 | spring with hinge | 1 |
| 5 | PM.27.53-4081 | guide | 1 | 20 | G.27 53-3792 | attachment complete | 1 |
| 6 | 275-426 | screw locking | 1 | 21 | 250-980 | knob | 1 |
| 7 | 275-404 | screw | 1 | 22 | 27 53 4011 | rod | 1 |
| 8 | PM.275-408 | body with hinge | 1 | 23 | 27 53 4172 | support | 1 |
| 9 | 275-404 | screw | 2 | 24 | 27 53 4181 | pawl | 1 |
| 10 | 275-411 | plate | 1 | 25 | 27 53 4251 | knob | 1 |
| 11 | 275-408 | body guide | 1 | 26 | 27 53 4201 | fork | 1 |
| 12 | 275-410 | pin | 1 | 27 | 27 53 4121 | washer spring | 1 |
| 13 | 275-409 | hinge | 1 | 28 | 27 53 4251 | knob | 1 |
| 14 | 27 53-2231 | plate stop | 1 | 29 | 27 53-2211 | nut | 1 |
| 15 | 255-415 | block | 1 | 30 | 27 53-4071 | support rotating | 1 |



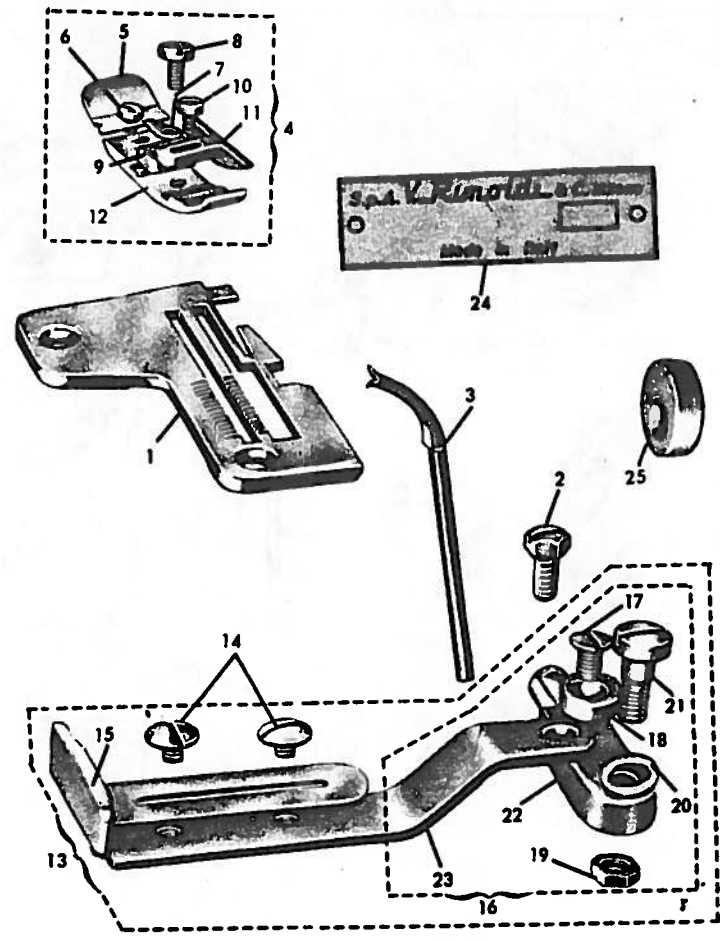
| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION. | QUANT. |
|---------|--------------|---------------------|--------|---------|----------|--------------|--------|
| 1 | 781066-0-00 | plate machine class | 1 | | | | |
| 2 | G.27.53210/3 | work plate complete | 1 | | | | |



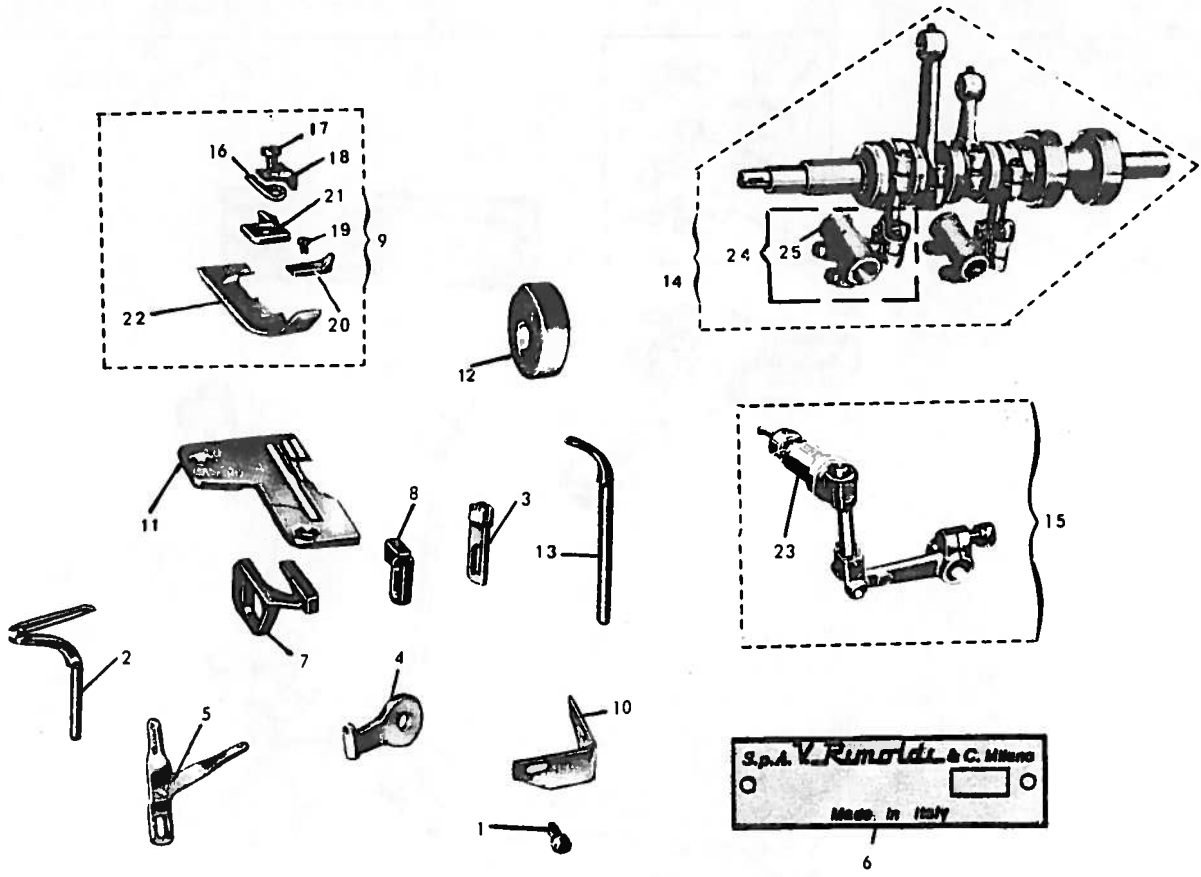
36

| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|----------------|---------------------------------|--------|---------|---------------|---------------------|--------|
| 1 | 270-1142 | needle plate bight width 11/64" | 1 | 14 | 255-404 | screws | 2 |
| 2 | 039-R-8,5 | screw guide fixing | 1 | 15 | PM.276-B-403 | guide | 1 |
| 3 | 270-D-074/1 | looper upper blind | 1 | 16 | G.276-B-403/1 | support complete | 1 |
| 4 | G.274-B1-1811 | presserfoot complete | 1 | 17 | 032-F-6,5 | screw for eccentric | 1 |
| 5 | 270-185 | plate | 1 | 18 | 605-412 | eccentric | 1 |
| 6 | 001-A-3,2 | screw plate fixing | 1 | 19 | 057 E-4 | nut | 1 |
| 7 | 270-196 | locator | 1 | 20 | 276-B-412 | washer spring | 1 |
| 8 | 004-L-7 | screw tongue fixing | 1 | 21 | 011-E-13 | screw collar | 1 |
| 9 | 270-191 | tongue | 1 | 22 | 276-B-417/1 | support guide | 1 |
| 10 | 001-A-5,5 | screw guide fixing | 1 | 23 | 276-B-407/1 | support rotating | 1 |
| 11 | 274-B1-1921 | guide | 1 | 24 | 781110-0-00 | plate machine class | 1 |
| 12 | 276-B-184 | shoe | 1 | 25 | 003-M 7 | screw cap | 1 |
| 13 | AS.276-B-403/1 | guide rotating | 1 | 26 | 280-0451/6 | eccentric feed dog | 2 |

On request:
270075 Tab. 38



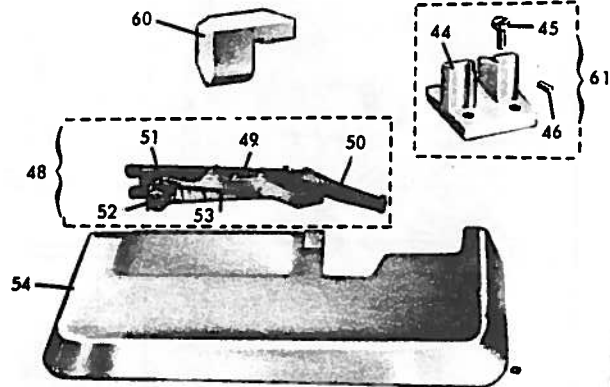
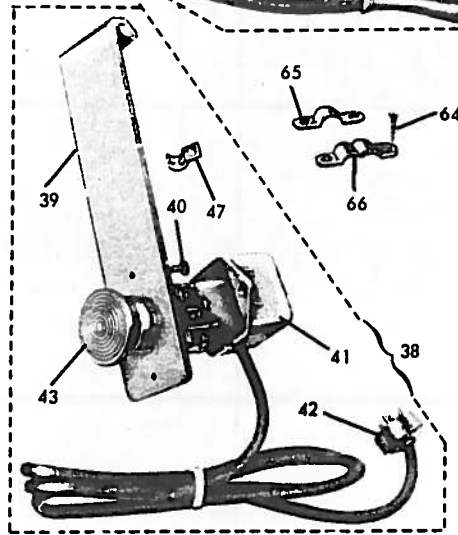
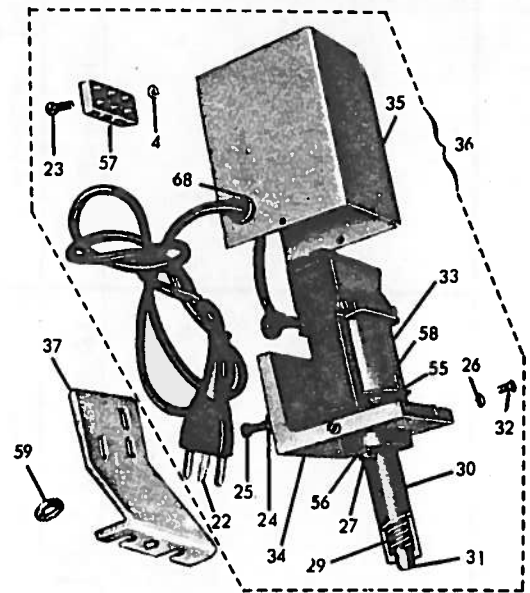
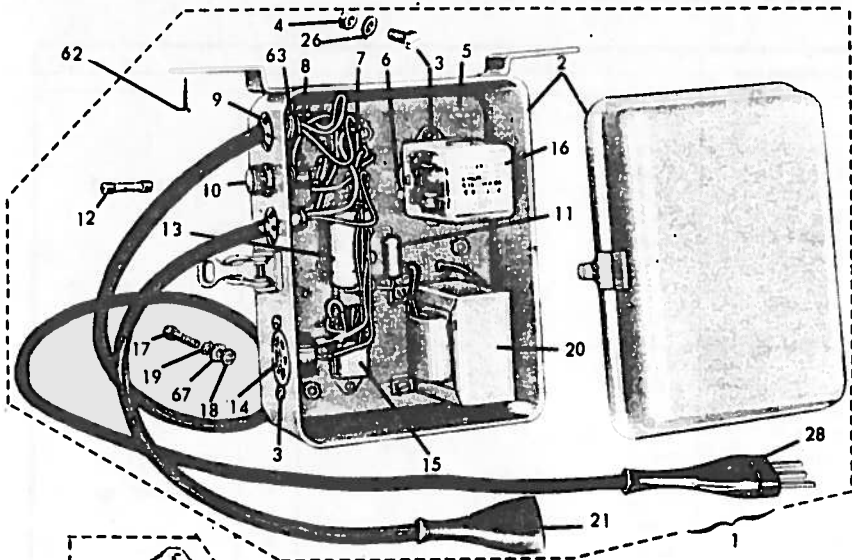
| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------------------|----------------|---------------------------------|--------|---------|---------------|---------------------|--------|
| 1 | 270-1142 | needle plate bight width 11/64" | 1 | 14 | 255-404 | screws | 2 |
| 2 | 039-R-8,5 | screw guide fixing | 1 | 15 | PM.276-B-403 | guide | 1 |
| 3 | 270-D-074/1 | looper upper blind | 1 | 16 | G.276-B-403/1 | support complete | 1 |
| 4 | G.274-B1-1811 | presserfoot complete | 1 | 17 | 032-F-6,5 | screw for eccentric | 1 |
| 5 | 270-185 | plate | 1 | 18 | 605-412 | eccentric | 1 |
| 6 | 001-A-3,2 | screw plate fixing | 1 | 19 | 057-E-4 | nut | 1 |
| 7 | 270-196 | locator | 1 | 20 | 276-B-412 | washer spring | 1 |
| 8 | 004-L-7 | screw tongue fixing | 1 | 21 | 011-E-13 | screw collar | 1 |
| 9 | 270-191 | tongue | 1 | 22 | 276-B-417/1 | support guide | 1 |
| 10 | 001-A-5,5 | screw guide fixing | 1 | 23 | 276-B-407/1 | support rotating | 1 |
| 11 | 274-B1-1921 | guide | 1 | 24 | 781111-0-00 | plate machine class | 1 |
| 12 | 276-B-184 | shoe | 1 | 25 | 280-0451/6 | eccentric feed dog | 2 |
| 13 | AS.276-B-403/1 | guide rotating | 1 | | | | |
| On request: | | | | | | | |
| 270075 Tab. 38 | | | | | | | |
| 27.277-0745 Tab. 38 | | | | | | | |



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| N° RIF. | N° DISEGNO | DENOMINAZIONE | QUANT. | N° RIF. | N° DISEGNO | DENOMINAZIONE | QUANT. |
|---------|-----------------|--|--------|---------|------------------|---|--------|
| 1 | 001-D-7 | screw guide block fixing | 1 | 14 | G.28.21-C2-009 4 | main shaft assembly | 1 |
| 2 | 270-0751 | looper lower | 1 | 15 | G.27.21-C2-067/3 | looper drive shaft with connecting rods | 1 |
| 3 | 272-B-052 | feed dog chainer | 1 | 16 | 270-196 | locator | 1 |
| 4 | 272-B-270 | tensioner upper looper thread | 1 | 17 | 004-L-8 | screw | 1 |
| 5 | 272-B-272 | tensioner lower looper thread | 1 | 18 | 27.21-C-183/1 | plate | 1 |
| 6 | 781116-0-00 | name plate showing machine class | 1 | 19 | 270-989 | screw | 1 |
| 7 | PM.27.21-C-050 | feed dog main | 1 | 20 | 270-183 | block | 1 |
| 8 | PM.28.21-C-051 | feed dog subsidiary | 1 | 21 | 27.21-C-191/1 | tongue | 1 |
| 9 | G.27.21-C-181/1 | assembly presserfoot | 1 | 22 | 27.21-C-184/1 | slide | 1 |
| 10 | 27.21-C-220 | guard, holder feed dog | 1 | 23 | 27.21-C2-056 | bush eccentric | 1 |
| 11 | PM.27.21-S-114 | needle plate | 1 | 24 | PM.27.21-C2-059 | con-rod with coupling | 1 |
| 12 | 280-0461/40 | eccentric for main and subsidiary feed dog | 2 | 25 | 27.21-C2-059 | coupling | 1 |
| 13 | 270-074 | looper upper | 1 | | | | |

**SOLENOID
CHAIN CUTTING
ATTACHMENT
(W1) 100**



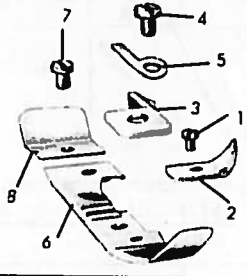
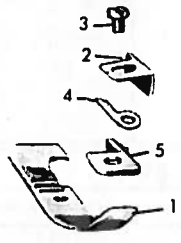
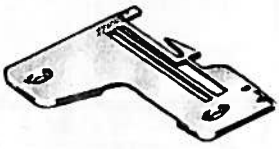
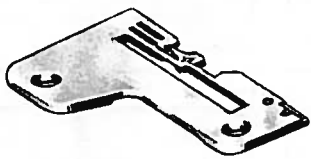
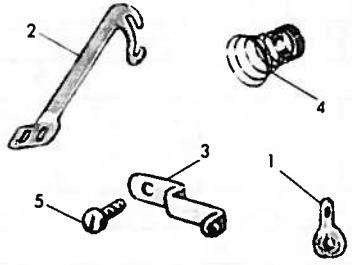
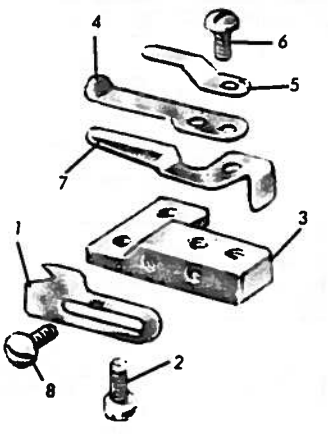
WARNING: the apparatus is designed for 220 V. For different voltages run through an autotransformer type SUT. 1745.00 with relative connectors type PM. T 11-127.

| REF. N° | PART. N° | DESCRIPTION | QUANT. | REF. N° | PART. N° | DESCRIPTION | QUANT. |
|---------|---------------|----------------------|--------|---------|-----------------|----------------------------|--------|
| 1 | AS.270-W1-333 | control box complete | 1 | 35 | PM.270-W1-343 | cover solenoid | 1 |
| 2 | G.270-W1-333 | control box electric | 1 | 36 | AS.270-W1-351 | assembly complete solenoid | 1 |
| 3 | C.001-C-10 | screw | 11 | 37 | 270-W1-323 | bracket | 1 |
| 4 | 057-B-3 | nut | 13 | 38 | G.270-W-3340 | push-button complete | 1 |
| 5 | 270-W1-373 | panel | 1 | 39 | 270-W-3300 | bracket push-button | 1 |
| 6 | 270-W1-378 | base | 1 | 40 | 001-E-5 | screw | 4 |
| 7 | T 11-22 | anchoring | 1 | 41 | 270-W-3310 | cover | 1 |
| 8 | T 11-30 | cable terminal | 1 | 42 | 270-W-3700 | plug 4-pin | 1 |
| 9 | 270-W1-3721 | grommet | 2 | 43 | 270-W-3340 | push-button | 1 |
| 10 | 270-W1-363 | fuse holder | 1 | 44 | 270-W-6400/3 | bracket slide guide | 1 |
| 11 | T 11-16/3 | resistor | 1 | 45 | 008-A-12 | screw | 1 |
| 12 | T 11-33/3 | fuse | 1 | 46 | 270-716 | screw | 1 |
| 13 | T 11-21 | condenser electronic | 1 | 47 | 122-T-37 | guide cable | 2 |
| 14 | 270-W-3680 | socket push-button | 1 | 48 | G.270-W-3220/1 | lever complete | 1 |
| 15 | T 11-14 | rectifier | 1 | 49 | 270-W-3220 | lever chain cutting | 1 |
| 16 | 270-W1-379 | relay | 1 | 50 | PM.270-W-0760/1 | lever, presserfoot holder | 1 |
| 17 | C.001-E-30 | screw | 3 | 51 | 270-W-3280 | washer | 1 |
| 18 | 053-D-4 | nut | 3 | 52 | 270-W-3250 | screw for spring | 1 |
| 19 | 063-L-4 | washer | 6 | 53 | 270-W-3240 | spring knife return | 1 |
| 20 | T 11-13 | transformer socket | 1 | 54 | G.270-W1-210/3 | work plate | 1 |
| 21 | 270-W1-369 | socket | 1 | 55 | 270-W-3540 | washer | 4 |
| 22 | 270-W1-372 | plug with earth | 2 | 56 | 633-710/1 | washer | 2 |
| 23 | C.001-C-14 | screw | 2 | 57 | 122-T-215 | board terminal | 1 |
| 24 | 064-L-5 | washer | 3 | 58 | 001-E-8 | screw | 4 |
| 25 | 270-W-3550 | screw | 3 | 59 | 065-C-6 | washer | 2 |
| 26 | 270-W1-355 | washer star | 12 | 60 | 280-253 TC 30 | gasket for slide guide | 1 |
| 27 | 001-E-12 | screw | 2 | 61 | G.270-W-6400/3 | bracket slide guide | 1 |
| 28 | T 11-126 | plug with earth | 1 | 62 | TT 20 x 25 | screw wood | 4 |
| 29 | 270-W1-346 | spring | 1 | 63 | 270-W1-328 | holder cable | 2 |
| 30 | 270-W1-345 | sleeve | 1 | 64 | 270-459 | nail for cable guide | 30 |
| 31 | 270-W1-349 | contact point | 1 | 65 | 546 | guide single cable | 10 |
| 32 | C.001-C-7 | screw | 3 | 66 | 547 | guide double cable | 5 |
| 33 | 270-W1-351 | solenoid | 1 | 67 | T 11-355 | washer star | 3 |
| 34 | PM.270-W1-332 | bracket | 1 | 68 | 270-W1-323 | grommet | 1 |



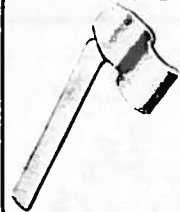
DETAILS OF SOLENOID ATTACHMENT 100 (W1)



| | Ref No. | Drawing No. | Denomination | Quant | FOR USE WITH | |
|---|--------------------------|---------------|--------------|-----------------------|--------------------------------|--|
| | G. 272-B2-W1-181 | | | | | |
| | 1 | 272-B2W1-184 | shoe | 1 | 228-00-02-100 | |
| | 2 | 272-B-183 | plate | 1 | | |
| | 3 | 004-L-8 | screw | 1 | | |
| | 4 | 270-196 | locator | 1 | | |
| | 5 | 272-B-191 | tongue | 1 | | |
| | 6 | 001-A-4 | screw | 1 | | |
| 7 | 275-W-185 | plate | 1 | | | |
| | G. 270-W-181 | | | | | |
| | 1 | 270-184 | shoe | 1 | 228-00-01-100 228-00-05-100 | |
| | 2 | 270-183 | block | 1 | | |
| | 3 | 270-989 | screw | 1 | | |
| | 4 | 270-191 | tongue | 1 | | |
| | 5 | 004-L-7 | screw | 1 | | |
| | 6 | 270-196 | locator | 1 | | |
| | 7 | 001-A-3,2 | screw | 1 | | |
| 8 | 270-W-185 | plate | 1 | | | |
| | G. 275-W-181 | | | | | |
| | 1 | 275-184 | shoe | 1 | 228-10-01-100 228-10-06-100 | |
| | 2 | 275-183 | block | 1 | | |
| | 3 | 270-989 | screw | 1 | | |
| | 4 | 275-191 | tongue | 1 | | |
| | 5 | 004-L-7 | screw | 1 | | |
| | 6 | 270-196 | locator | 1 | | |
| | 7 | 001-A-3,2 | screw | 1 | | |
| 8 | 275-W-185 | plate | 1 | | | |
| | G. 27-21-CW-181/2 | | | | | |
| | 1 | 278-W-184/C 2 | shoe | 1 | 228-00-06-100 | |
| | 2 | 270-183 | block | 1 | | |
| | 3 | 270-989 | screw | 1 | | |
| | 4 | 2721-C-191/2 | tongue | 1 | | |
| | 5 | 004-L-7 | screw | 1 | | |
| | 6 | 270-196 | locator | 1 | | |
| | 7 | 001-A-3,2 | screw | 1 | | |
| 8 | 270-W-185 | plate | 1 | | | |
| | G. 27-21-CCW-181 | | | | | |
| | 1 | 2721-CC-W-184 | shoe | 1 | 228-00-07-100 | |
| | 2 | 270-183 | block | 1 | | |
| | 3 | 270-989 | screw | 1 | | |
| | 4 | 2721-CC-191 | tongue | 1 | | |
| | 5 | 004-L-7 | screw | 1 | | |
| | 6 | 270-196 | locator | 1 | | |
| | 7 | 001-A-3,2 | screw | 1 | | |
| 8 | 270-W-185 | plate | 1 | | | |
| | G. 27-54-W1-210/3 | | | | G. 275-B W1-210/3 | |
| | FOR USE WITH | | | FOR USE WITH | | |
| | 228-10-06 | | | 228-10-02 - 228-10-03 | | |
| | G. 27-53-W1-210 | | | | | |
| | FOR USE WITH | | | | | |
| | 228-10-05 - 228-10-07 | | | | | |




DETAILS OF CHAIN STAMPING ATTACHMENT (X1) 101

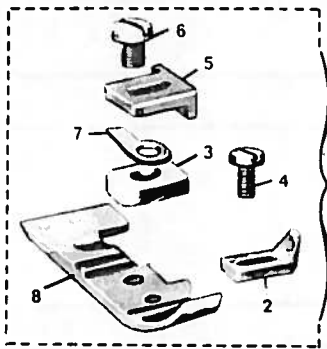
| | | | | | | |
|--|----------------|-------------------------|-------------|--------------------|---------------|---|
|  | G.270-X1-181 | Ref. No. | Drawing No. | Denomination | Quant. | FOR USE WITH |
| | | 1 | 270-989 | screw block fixing | 1 | 228-00-01-101 228-00-05-101 |
| 2 | 270-183 | block | 1 | | | |
| 3 | 270-X1-191 | tongue | 1 | | | |
| 4 | 004-L-7 | screw tongue fixing | 1 | | | |
| 5 | 270-196 | locator | 1 | | | |
| 6 | 270-184 | shoe | 1 | | | |
| 7 | 001-A-3,2 | screw plate fixing | 1 | | | |
| 8 | 270-185 | plate | 1 | | | |
| N.B. - When transformation from 228-00-01 to 228-00-01/101 is carried out at the customer's works, only the tongue drawing No. 270-X1-191 is supplied and not the complete presserfoot. | | | | | | |
|  | G.272-B2X1-181 | 1 | 272-B2-184 | shoe | 1 | FOR USE WITH |
| | | 2 | 272-B-183 | plate | 1 | 228-00-02-101 |
| 3 | 004-L-8 | screw | 1 | | | |
| 4 | 270-196 | locator | 1 | | | |
| 5 | 272-BX-1-191 | tongue | 1 | | | |
| N.B. - When transformation from 228-00-02 to 228-00-02/101 is carried out at the customer's works, only the tongue drawing No. 272-BX1-191 is supplied and not the complete presserfoot. | | | | | | |
|  | 270-X1-1141 | FOR USE WITH | | 2701-X1-1141 | FOR USE WITH | |
| | | 228-00-01-101 | | | 228-00-05-101 | |
|  | 272-BX1-114 | FOR USE WITH | | | | |
| | | 228-00-02-101 | | | | |
|  | | Ref. No. | Drawing No. | Denomination | Quant. | FOR USE WITH |
| | | 1 | 270-270/2 | thread guide | 1 | 228-00-01-101 228-00-02-101 228-00-05-101 |
| 2 | 270-274/4 | needle thread tensioner | 1 | | | |
| 3 | 270-269/2 | thread tensioner | 1 | | | |
| 4 | 270-232/1 | spring | 1 | | | |
| 5 | 004-L-8 | screw | 1 | | | |
|  | G.270-X1-4452 | 1 | 270-X1-4472 | knife | 1 | 228-00-01-101 228-00-05-101 228-00-02-101 |
| | | 2 | 001-B-6 | screw | 2 | |
| 3 | 270-X1-4452 | body | 1 | | | |
| 4 | 270-X1-4482 | spring | 1 | | | |
| 5 | 270-X1-4502 | plate | 1 | | | |
| 6 | 2701-PDB-4042 | screw | 1 | | | |
| 7 | 270-X1-4462 | cover | 2 | | | |
| 8 | 3647/B | screw | 2 | | | |

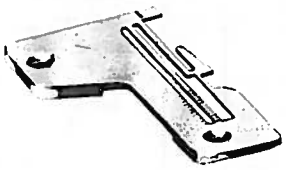
41

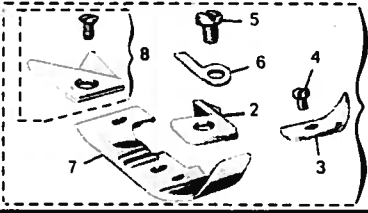
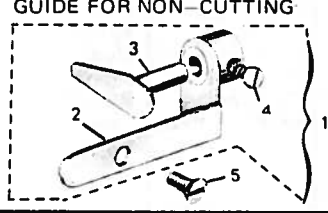
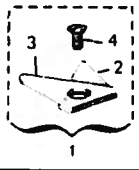
| | | | | | | |
|--|--|---|--|---|--|---|
| BLIND UPPER LOOPER  | 270-D-074/1 FOR USE WITH 228-00-01 228-00-05 | UPPER LOOPER WITH EYE  | 27.277-0745 FOR USE WITH 228-00-01 228-28-02 | 27.277-074 FOR USE WITH 228-00-04 228-01-02 228-10-01 228-00-05 | FIXED GUIDE FOR NON-CUTTING  | 270-401 FOR USE WITH 228-00-05 |
| | FOR USE WITH | | FOR USE WITH | | | FOR USE WITH |

| | | | | | | | |
|--|---|--|---|---|--|--|--|
| LOWER LOOPER  | 270-075 FOR USE WITH 228-00-01 228-28-01 228-28-02 | 270-075/2 FOR USE WITH 228-00-04 228-00-05 228-01-02 228-10-01 | SUBSIDIARY FEED DOG  | 2800-B7-0511 FOR USE WITH 228-00-04 228-01-02 | 282-B-0511 FOR USE WITH 228-00-02 | 285-0511 FOR USE WITH 228-10-01 | 280-0511 FOR USE WITH 228-00-01 |
| | FOR USE WITH | | | FOR USE WITH | | | |

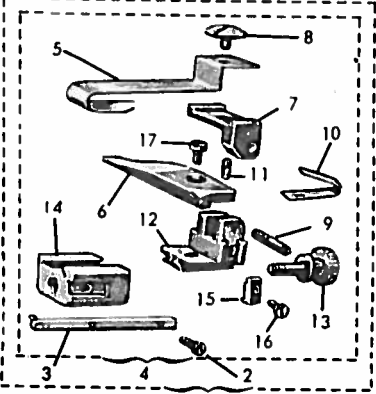
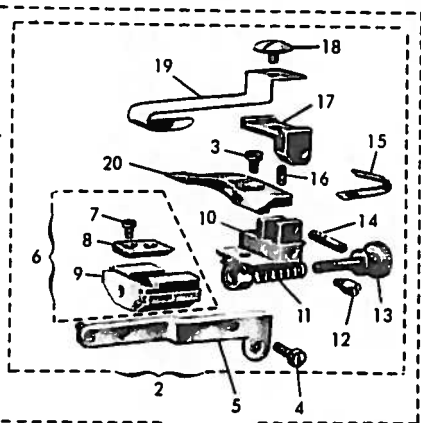



| | | | | | | |
|---|--|---|--|---|--|---|
| MAIN FEED DOG  | 272-B-0501 FOR USE WITH 228-00-02 | PRESSERFOOT PRESSURE SPRING  | 272-092 FOR USE WITH 228-00-08 228-00-02 | KNIFE SHARPENING BLOCK  | 272-BK-675 FOR USE WITH 228-00-03 | 270-675/1 FOR USE WITH 228-00-01 |
| | FOR USE WITH | | FOR USE WITH | | FOR USE WITH | |

| | | | |
|--|---|---|---------------------------|
|  | 1 G. 2721-C-181 2 270-183 3 2721-C-191 4 270-989 5 2700-1834 6 004-L-8 7 270-196 8 2721-C-184 | presserfoot complete block tongue screw block fixing plate screw plate fixing locator shoe | FOR USE WITH 228-00-06 |
| | 1 G. 2721-C-181/1 2 270-183 3 2721-C-191 4 270-989 5 2721-C-183/1 6 004-L-8 7 270-196 8 2721-C-184 | presserfoot complete block tongue screw block fixing plate screw plate fixing locator shoe | FOR USE WITH 228-00-06 |
| | FOR USE WITH | | 228-00-06 |
| | FOR USE WITH | | 228-00-06 |

| | | | | | |
|--|--|---|--|--|---|
| NEEDLE PLATE  | 270-1142 FOR USE WITH 228-00-01 | 270-1143 FOR USE WITH 228-00-01 | 270-114 FOR USE WITH 228-00-01 | 272-B-114 FOR USE WITH 228-00-02 | 275-1141 FOR USE WITH 228-10-01 |
| | FOR USE WITH | | | | |
| | 272-BK-114/1 FOR USE WITH 228-00-03 | 272-BK-1141 FOR USE WITH 228-00-03 | 27.21-1143 FOR USE WITH 228-00-08 | 27.77-1142 FOR USE WITH 228-00-04 | PM.2721-C-114 FOR USE WITH 228-00-06 |
| | FOR USE WITH | | | | |

| | | | | | | | | |
|---|---|--|--|--|--|---|--|--|
|  | 1 G. 270-1812 2 270-191 3 270-183 4 270-989 5 004-L-7 6 270-196 7 270-184 8 PM. 270-1882 | presserfoot complete tongue block screw block fixing screw tongue fixing locator shoe device thread cutting | GUIDE FOR NON-CUTTING  | 1 G. 274-401 2 PM. 274-417 3 PM. 274-402 4 003-A-4,5 5 001-D-7 | guide complete bracket guide screw screw | THREAD CUTTING DEVICE  | 1 PM.270-1882 2 270-1872 3 270-1882 4 028-A-3,5 | device complete blade blade screw |
| | FOR USE WITH | | | FOR USE WITH | | | FOR USE WITH 228-00-01 228-00-05 | |
| | FOR USE WITH | | | FOR USE WITH | | | FOR USE WITH 228-10-01 | |
| | FOR USE WITH | | | FOR USE WITH | | | FOR USE WITH 228-10-01 | |

PARTS SUPPLIED ON REQUEST ONLY

| | | | |
|--|---|---|--------------------------------------|
|  | <p>1 AS 275-B-413/1 2 001-D-6 3 PM 275-B-417 4 G 275-B-413/1 5 275-B-407/B 6 275-B-411/1 7 275-B-409 8 275-404 9 275-B-410 10 275-B-430 11 275-B-403 12 275-B-406 13 275-B-425 14 275-B-408 15 275-B-418 16 005-D-5 17 004-R-5</p> | <p>guide hemming screw support guide plate hemming guide block screw pin threaded spring leaf screw stop shoe screw adjustment body guide locator screw screw</p> | <p>FOR USE WITH</p> <p>228-10-02</p> |
|  | <p>1 AS 275-BS-4132/1 2 G 275-BS-4132/1 3 004-R-5 4 001-D-6 5 PM 275-BS-4172 6 PM 275-BS-4082 7 004-A-3,2 8 275-BS-4142 9 275-BS-4082 10 275-BS-4062 11 275-BS-4152 12 275-BS-6412 13 275-BS-4252 14 275-B-410 15 275-B-430 16 275-B-403 17 275-B-409 18 275-404 19 275-B-407/B 20 275-B-411/1</p> | <p>guide hemming guide screw screw support body guide screw guide body shoe spring pin threaded screw adjustment pin threaded spring leaf screw stop block screw plate hemming guide</p> | <p>FOR USE WITH</p> <p>228-10-03</p> |
| <p>CHAIN CUTTER</p> <p>270-188</p> <p>FOR USE WITH</p> <p>228-00-01</p>  | <p>UPPER KNIFE</p> <p>270-113/2</p> <p>FOR USE WITH</p> <p>228-00-01</p>  | <p>LOWER KNIFE</p> <p>270-112/2</p> <p>FOR USE WITH</p> <p>228-00-01</p>  | |

GENERAL LIST OF PARTS

| N° | | N° | | N° | | N° | |
|------------|--------------|--------------|-------------|--------------|-------------|--------------|-----------------------------------|
| DIS. | TAV. | DIS. | TAV. | DIS. | TAV. | DIS. | TAV. |
| Rim. 27 | 5-13 | 039-G-10 | 10 | 250-137 | 12 | 270-100 | 6 |
| 001-A-3,2 | 1-22-23-24 | 039-R-8,5 | 30-32-33 | G.250-137 | 12 | 270-101 | 6 |
| | 25-26-27-32 | 051-L-10 | 11 | 250-140 | 12 | 270-102 | 6 |
| | 33-36-37 | 053-D-4 | 8-28-35 | 250-143 | 12 | 270-103 | 6 |
| 001-A-4 | 36 | 053-H-8 | 12 | PM.250-148/1 | 12 | 270-104 | 6 |
| 001-A-5,5 | 32-33 | 054-D-4 | 8 | AS.250-149 | 12 | 270-105 | 6 |
| 001-B-6 | 37 | 057-A-3 | 10-23-24-25 | 250-471 | 4-6 | 270-106 | 6 |
| 001-C-4 | 29-30 | 057-B-3 | 28-35 | 250-708/1 | 5 | 270-107/1 | 1 |
| 001-C-5,5 | 23-24-25 | 057-E-4 | 8-15-32-33 | 250-980 | 29-30 | 270-108/1 | 6 |
| 001-D-4,5 | 8 | 057-R-5 | 18 | G.250-R-9373 | 23-24-25 | 270-109/1 | 1 |
| 001-D-6 | 8-27-28-39 | 058-M-10 | 11 | 255-404 | 29-30-32-33 | 270-110 | 8 |
| 001-D-7 | 18-26-28-34 | 059-A-5 | 11-15 | 255-415 | 29-30 | 270-112 | 6-13 |
| | 38 | 059-G-6 | 10 | PM.255-434 | 29-30 | 270-113/1 | 6-13 |
| 001-D-10 | 8 | 059-H-6 | 11 | 255-442 | 15 | 270-116/2 | 2 |
| 001-E-5 | 35 | 059-P-8 | 28 | 270-001/2 | 10 | 270-129/1 | 8 |
| 001-E-7 | 5-10 | 063-L-4 | 35 | 270-004 | 11 | 270-130 | 5 |
| 001-E-8 | 35 | 063-N-4 | 28 | G.270-005/3 | 11 | 270-131 | 5 |
| 001-E-10 | 2 | 064-L-5 | 35 | PM.270-005/3 | 11 | 270-132/1 | 5 |
| 001-E-12 | 8-35 | 065-C-6 | 35 | 270-006/1 | 5 | 270-133 | 21 |
| 001-G-10 | 5-12,18-28 | 065-L-6 | 10-11 | 270-007/1 | 5 | 270-133/1 | 5 |
| 001-G-12 | 8-12-23-24 | 067-H-10 | 11 | 270-008/1 | 2 | 270-135 | 5 |
| | 25 | 070-F-4 | 6 | 270-016 | 1 | PM.270-137 | 5 |
| C001-C-7 | 35 | 071-D-5 | 6-15 | 270-020/1 | 5 | PM.270-138/1 | 5 |
| C001-C-10 | 35 | 071-E-5 | 5 | G.270-025/2 | 5 | AS.270-140 | 12 |
| C001-C-14 | 35 | 071-H-5 | 3 | 270-031/1 | 5 | 270-157 | 12 |
| C001-E-30 | 35 | 073-F-9 | 5-6 | 270-036/1 | 3 | G.270-157 | 12 |
| 003-A-4,5 | 5-16-38 | 073-N-10 | 4 | 270-039 | 3 | 270-158/1 | 12 |
| 003-L-12 | 6 | 092-A-10 | 5-16 | 270-050 | 3 | 270-174 | 8 |
| 003-M-7 | 15-18-19-32 | 092-B-1 | 3-4-5 | 270-051 | 3 | 270-175 | 8 |
| 004-A-3,2 | 9-15-39 | 092-C-2 | 1-6-15 | 270-052 | 3 | G.270-181 | 1 |
| 004-A-5 | 6-9 | 092-D-2 | 15 | 270-053 | 4 | 270-183 | 1-16-18-19- 20-34-36-37- 38 |
| 004-G-3 | 24 | 092-D-5 | 5 | 270-056/2 | 4 | | |
| 004-L-6 | 9 | 092-D-6 | 5 | 270-057/1 | 1 | 270-184 | 1-36-37-38 |
| 004-L-7 | 1-3-15-18-19 | 092-D-7 | 4 | 270-058/2 | 1 | 270-185 | 1-23-25-32 |
| | 20-21-22-26 | 092-D-9 | 6 | 270-059/1 | 2 | | 33-37 |
| | 27-28-32-33 | 092-D-11 | 1-3-5-15 | PM.270-059/1 | 2 | | 1-23-25-32 |
| | 36-37-38 | 092-D-16 | 4 | 270-060/1 | 2 | 270-191 | 33-36-38 |
| | 36-37-38 | 092-D-26 | 2 | PM.270-060/1 | 2 | | 1-15-16-18 |
| 004-L-8 | 16-23-25-34 | T11-13 | 35 | 270-061/2 | 2 | 270-196 | 19-20-21-22 |
| | 36-37-38 | T11-14 | 35 | 270-062 | 2 | | 23-25-26-32 |
| 004-L-9 | 8-24 | T11-16/3 | 35 | 270-063/2 | 4 | | 34-36-37-38 |
| 004-N-5,5 | 9 | T11-21 | 35 | 270-064 | 4 | | |
| 004-R-5 | 39 | T11-22 | 35 | 270-065/3 | 4 | PM.270-205/3 | 8 |
| 005-D-5 | 27-39 | T11-30 | 35 | G.270-065/3 | 4 | PM.270-208/3 | 8 |
| 005-L-11 | 3 | T11-33/3 | 35 | 270-066/2 | 8 | PM.270-210/3 | 8 |
| 007-C-11 | 5-6 | T11-126 | 35 | 270-067 | 4 | 270-212 | 8 |
| 007-F-14 | 8 | T11-355 | 35 | 270-068/3 | 4 | 270-214 | 8 |
| 007-H-25 | 8 | TS 20 x 30 | 12-23-24-25 | 270-069 | 4 | G.270-216/2 | 8 |
| 007-L-20 | 10 | TS.22 x 35 | 28 | 270-070 | 4 | PM.270-218/2 | 8 |
| 007-P-10 | 6 | TT.20 x 35 | 35 | 270-073 | 1 | 270-220 | 8 |
| 007-R-7,5 | 8 | 122 T 37 | 35 | 270-074 | 14-15-18-20 | 270-221 | 8 |
| 008-A-12 | 35 | 122 T 215 | 35 | | 34 | 270-226 | 8 |
| 010-D-11,5 | 2 | VR. 604 | 13 | 270-075 | 16-17-18-19 | 270-230 | 9 |
| 010-H-13,7 | 2 | 01141 | 12-23-24-25 | | 21-22-26 | 270-232/1 | 14-37 |
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| 016-D-6 | 8 | 546 | 35 | 270-081/1 | 1 | 270-246 | 8 |
| 016-F-5 | 12 | 547 | 35 | PM.270-081/1 | 1 | 270-248/1 | 3 |
| 016-F-6,5 | 12 | 569 | 12 | 270-082/1 | 1 | 270-250/2 | 3 |
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| 017-F-11 | 4 | 1146 | 12 | 270-085/1 | 1 | 270-258 | 9 |
| 017-H-12 | 10 | 1156/1 | 13 | PM.270-085/1 | 1 | 270-259 | 9 |
| 023-N-5,5 | 2-5 | 1158 | 13 | 270-086 | 8 | 270-261/1 | 9 |
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| 026-G-10 | 15 | 1161/2 | 13 | 270-089/1 | 1 | PM.270-262/2 | 9 |
| 028-A-3,5 | 38 | 1175 | 13 | 270-090/1 | 8 | G.270-262/3 | 15-20 |
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| 028-B-8 | 22 | 3707 | 18 | 270-091 | 1 | 270-263 | 18 |
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| 032-F-9,5 | 8 | 128-605/5 | 2 | PM.270-095/3 | 8 | 270-266 | 9 |
| 032-L-10,5 | 1 | 240-035 | 18 | 270-096/1 | 6 | 270-268 | 1-9 |
| 036-C-7 | 9 | 250-031 | 18 | 270-097/1 | 1 | 270-269/1 | 9 |
| 038-M-9 | 15-28 | 250-130 | 12 | 270-098 | 6 | 270-269/2 | 37 |
| 039-D-6 | 28 | PM.250-133/1 | 12 | 270-099 | 6 | 270-270 | 20 |
| 016-E-5,5 | 8 | | | | | | |

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| DIS | TAV | DIS | TAV | DIS | TAV | DIS | TAV |
| 270-270 1 | 9 | 270-877 | 6 | 270-W1-355 | 35 | 275-416 | 26 |
| 270-270 2 | 37 | 270-912 | 1 | 270-W1-363 | 35 | PM.275-417 | 26 |
| 270-271 | 9 | 270-913 | 8 | 270-W1-369 | 35 | 275-425 | 26 |
| 270-272 | 9 | 270-925 1 | 2 | 270-W1-372 | 35 | 275-426 | 26-29-30 |
| 270-274 | 18 | 270-933 | 5 | 270-W1-373 | 35 | 275-1872 | 38 |
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| 270-827 1 | 10 | 270-W1-349 | 35 | 275-410 | 26-29-30 | 278-191 | 21 |
| 270-828 1 | 10 | 270-W1-351 | 35 | 275-411 | 26-29-30 | 279-050 | 21-22 |
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| 270-836 | 10 | | | 275-415 | 26 | 279-112 | 21-22 |

| N° DIS | TAV. | N° DIS. | TAV. | N° DIS. | TAV. | N° DIS. | TAV. |
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| 279-113/1 | 22 | 27-221-C-074/1 | 19 | 620-572 | 28 | | |
| 279-114 | 22 | 27277-074 | 4 | 280-155 | 13 | | |
| G.279-181 | 22 | 27277-R-071 | 24 | 633-707 | 10 | | |
| PM.279-183 | 22 | 280-002/1 | 1 | 633-708 | 10 | | |
| 279-184 | 22 | G.280-002/2 | 1 | 633-710/1 | 35 | | |
| 279-191 | 22 | 280-009/4 | 2 | 633-711/1 | 10 | | |
| G.279-216/2 | 22 | PM.280-009/4 | 2 | 633-742 | 13 | | |
| 279-987 | 22 | 280-010/3 | 1 | 633-812 | 10 | | |
| 2700-1834 | 38 | 280-012/3 | 2 | 633-813 | 10 | | |
| 27.01-0501 | 17 | 280-019 | 2 | 633-814 | 10 | | |
| 27.01-1141 | 17 | 280-023 | 3 | PM.633-817/1 | 10 | | |
| 27.01-P-092 | 16 | 280-033/1 | 3 | 633-818/1 | 10 | | |
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| 27.21-1143 | 19 | 280-049/1 | 3 | 633-925 | 8 | | |
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| 2721-C-191 | 38 | 280-244/1 | 8 | 670-702 | 10 | | |
| 2721-C-191/1 | 34-38 | 280-253 | 3 | 781001-0-00 | 9 | | |
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| 2721-C-232 | 18 | 280-303 | 8 | 781006-0-00 | 18 | | |
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| G.2721-C-704 | 18 | 280-926 | 3 | 781031-0-00 | 24 | | |
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| 2721-C-708 | 18 | 280-946 | 10 | 781060-0-00 | 26 | | |
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| 2721-C-709 | 18 | 280-0451/5 | 16 | 781062-0-00 | 28 | | |
| 2721-C-983 | 18 | 280-0451/6 | 33 | 781065-0-00 | 30 | | |
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| PM.2721-C2-009/4 | 19 | 280-0451/12 | 26 | 910-144 | 12 | | |
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