

User's Manual



GBH-1011G

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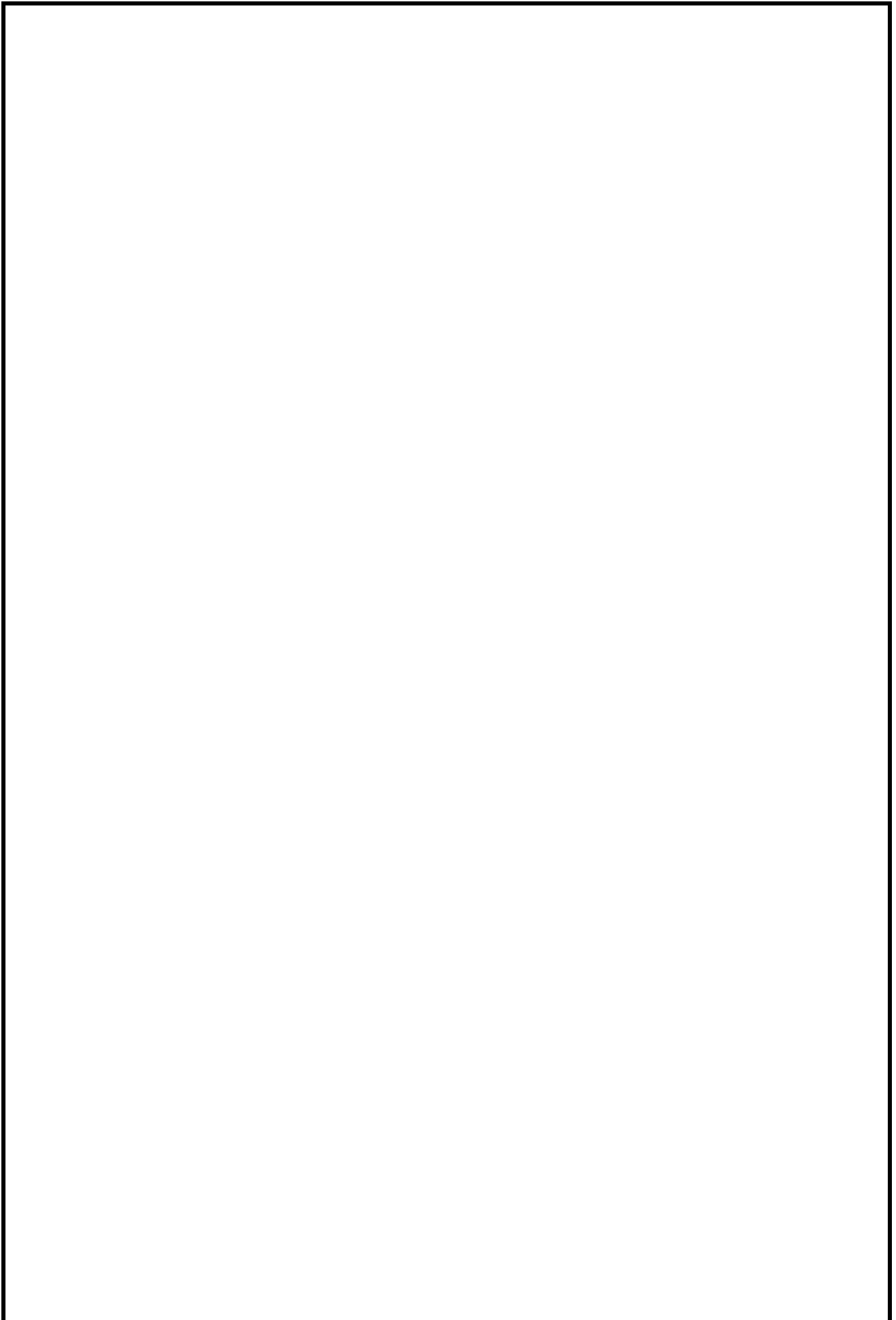
A. BASIC INFORMATION

A.1. BRIEF DESCRIPTION AND INTENDED USE OF THE SEWING MACHINE

Mechanically controlled, automatic sewing machine for sewing buttonholes of the linen type with built-in servomotor 1 x 230 V with easy control of machine start, smooth start and stop. The machine is also equipped with an automatic lifting of the frame, thread trimming and blocking of the hole cut when the thread breaks. All this contributes to reducing noise and machine vibration. Operating comfort helps reduce operator fatigue. The machine allows you to create buttonholes up to 40 mm in size with a 31.8 mm through hole for various types of materials at speeds of up to 3600 rpm. The size of the hole is adjusted mechanically by means of a rod and the stitching density can be changed by replacing the designated gears. Central pressure lubrication ensures steady lubrication of all machine parts.



1	Machine head	5	Control panel (depending on motor type)
2	Working table	6	Control box
3	Stand	7	Pedal-sewing start
4	Spool stand	8	Pedal-presser frame lift



A.2. TECHNICAL PARAMETERS

Model	GBH-1011G
Use	Buttonhole sewing
Stitch type	Double thread (class #301)
Hole size	A = max. 40 mm; B = 2,5 – 5 mm
Number of whips	1x
Intersection size	6,4 – 31,8 mm
Frame lift	12 mm
Needle quantity	1
Needle system	134
Needle size	Nm. 75-90*
Lubrication	Central
Motor	Integrated servomotor 1x230 V
Machine head weight	72 kg
Stand weight	27 kg
Input power	550 W
Ground plan dimensions of the machine including the stand	1070 x 550 mm
Height of the working table	755–810 mm
Height of the machine including the spool stand	1530 mm
Noise data	73 dB / A
Maximum sewing speed	3 600 stitches/min **

* The machine is set for a needle Nm. 90 in manufacturing facility.

**The mentioned sewing speed cannot be exceeded with respect to lifetime period of the machine mechanism. The reaching of the maximum sewing speed is not guaranteed under any conditions. It is usually reduced due to the type of thread, needle, sewing material, stitch length and presser foot steps.

B. SAFETY INSTRUCTIONS

B.1. GENERAL SAFETY INSTRUCTIONS



- Before using the machine, please, read the operation manual carefully, where are mentioned parameters of the machine and specified limits and conditions under which the machine can be used.
- Make sure about the position of ON/OFF button to be able to use it operatively.
- Do not put your fingers in sewing area on any occasion.
- Make sure that electronic cables are not damaged to avoid an injury. Damaged covers must be immediately repaired or replaced for a new one.
- During any mechanical operation such as needle change or threading always make sure to turn off the machine with ON/OFF button or main switch.
- Before cleaning the machine or during its maintenance turn off the machine by pulling the plug out of a socket.
- After finishing work on the machine, turn off the machine with main switch.
- In case of power failure, turn off the machine with main switch.
- Do not adjust the machine in any way that might cause a damage or endanger the safety.
- In case of damaged safety label, order a new one and place it to its original place.
- Make sure to avoid getting caught into the moving mechanisms of the machine with your hair, sleeves or any other loose parts of your clothes.
- Do not use the machine under the influence of alcohol or drugs.

B.2. SAFETY INSTRUCTIONS AFTER DELIVERY



- During the unpacking of the machine, please, follow the marks on the packing.
- Report any visible damage of the order to the carrier. Doublecheck the contents of the package with your order and immediately report any defect to the manufacturer. Later complaints will not be accepted.

B.3. SAFETY INSTRUCTIONS DURING THE MACHINE INSTALLATION AND MAINTENANCE

- The machine should be installed and set up by an instructed person.
- Only an instructed person can manipulate with an electrical circuit.
- Make sure that the electric power, its voltage and circuit breaker enable stable supply of power necessary for a steady performance of the machine.
- Connect a correct earthing.
- It is prohibited to connect all the connectors when the machine is under voltage owing to threat of damage of electronic parts and motor.
- If it is necessary to dismantle any of the covers on the machine, turn of the main switch or unplug the machine from a socket.
- It is allowed to use only spare parts supplied or approved by the manufacturer.
- The machine should be placed out of high frequency and radio waves. Impact of electromagnetic waves generating interference with servo motor can cause a malfunction.

B.4. SAFETY INSTRUCTION FOR A DAILY OPERATION OF THE MACHINE

- Do not plug the machine to the socket if any of the safety covers is removed.
- Check if any of the cables is not damaged to avoid an injury caused by touching an uncovered conductor.
- If you are not sure how to adjust the machine correctly for any concrete operation, contact a machinist responsible.
- The user must ensure an appropriate lightning of the work area and surroundings. 

B.5. WORK AREA OF THE MACHINE



All installation or service work with machine must be made when the machine is unplugged from a socket.

A. Do not use the machine in case the electrical voltage exceeds the tolerance of +/-10%

B. Use a machine under following conditions:

- working temperature: 5-40 °C
- stocking temperature: -10 – 60 °C

C. Humidity between 20 – 80 % (relative humidity)

B.6. CONDITIONS OF ELECTRICAL INSTALLATION OF THE MACHINE

A. Power supply

- Power supply must be in regulated range +/- 10 %.
- Frequency should be regulated (50/60 Hz) +/- 1 %.

B. Electromagnetic compatibility

- Use separated power supply and make sure that the machine is not placed near to products emitting a strong magnetic or high frequency field.

C. Make sure to avoid spilling the fluids to the control box and motors. Protect the control box and motors from splashing liquids.

B.7. DISPOSAL INSTRUCTIONS

For a disposal of the machine contact your local dealer or manufacturer in accordance with legislation.

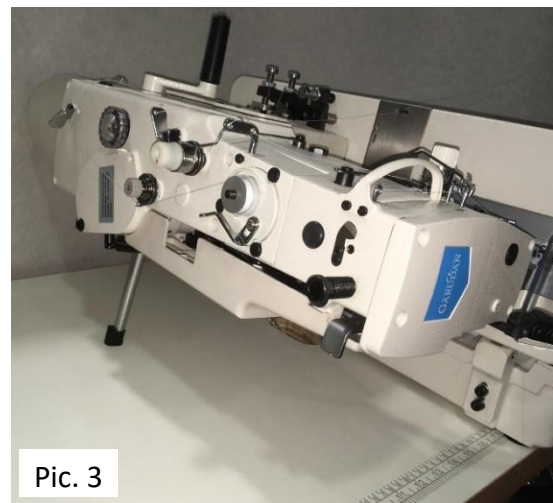
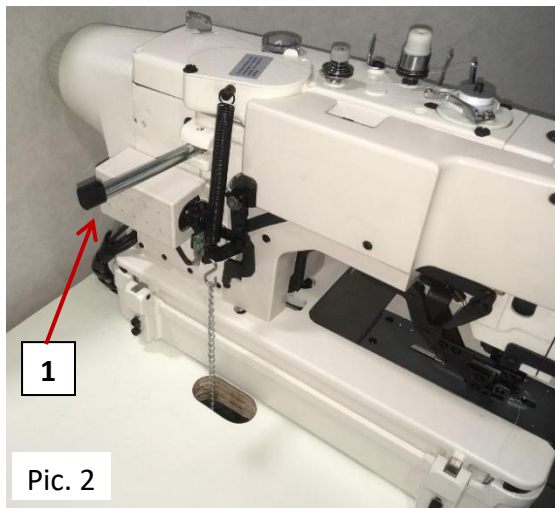
C. INSTALLATION

C.1. OIL FILLING

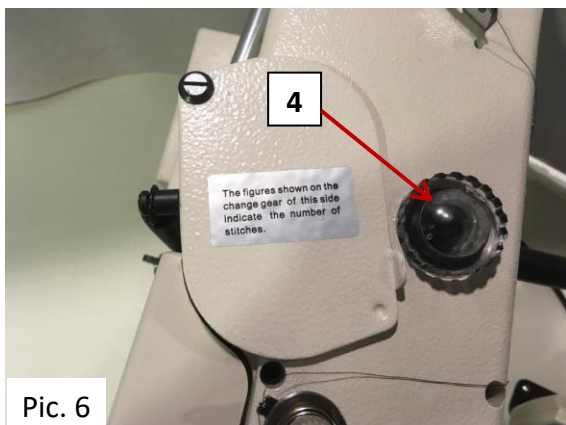
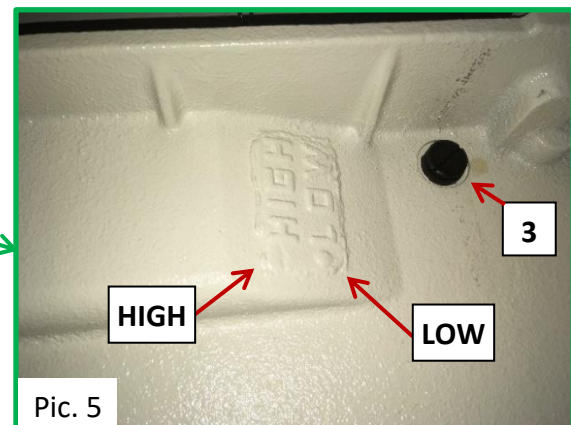
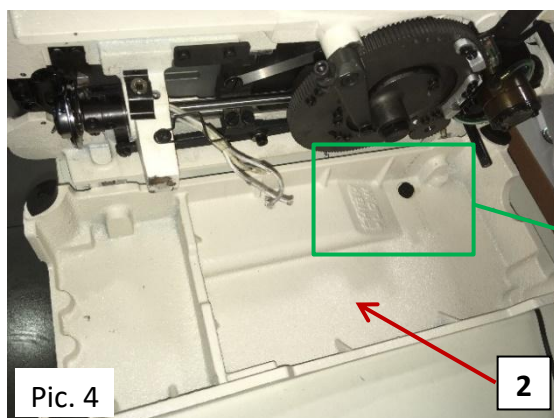
C.1.1. Oil filling

It is necessary to lubricate the machine before the running.

- Tip out the pin (1) as on the pic.2.
- Recline the machine head and lean it against the pin as on the pic. 3.

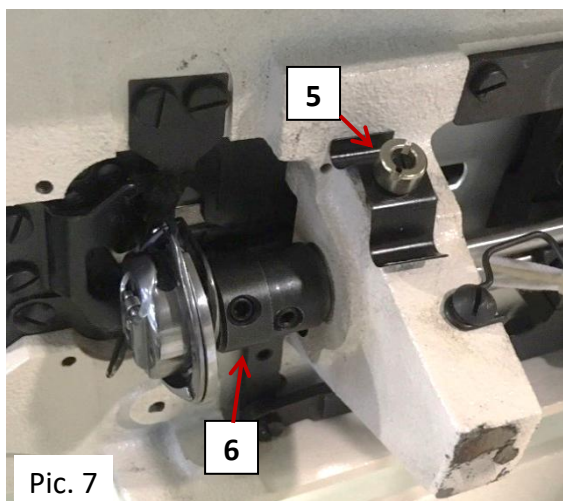


- Fill in the oil tank (2) as on the pic. 4 with oil M22 for sewing machine lubrication so the oil level would be between high and low marks as on the pic. 5. Check the oil level regularly. When it drops below the low mark, it is necessary to fill in the oil. Run the polluted oil off using the screw (3) as on the pic. 5.



- Return the machine head to its position and put the pin back.
- If the oil flows in the machine (4), the lubrication works correctly.

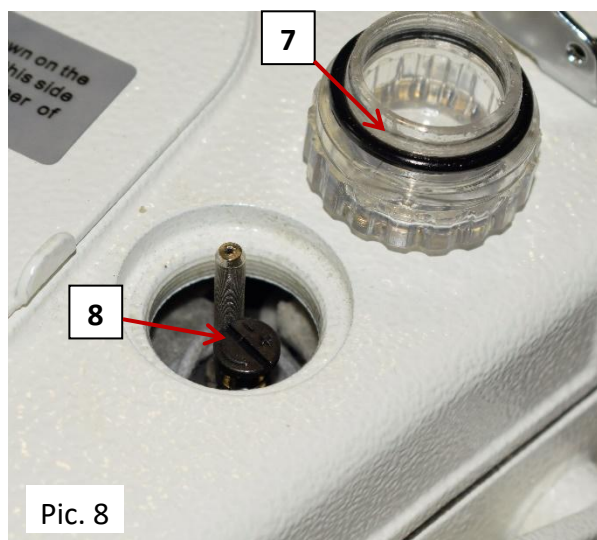
C.1.2. Hook lubrication



Pic. 7

- The adjusting of the amount of the oil getting to the hook can be made by turning the screw (5) for rough adjusting and (6) for delicate adjusting. By turning the screws clockwise, the amount of the oil decreases.

C.1.3. Regulation of the front mechanism lubrication



Pic. 8

- Unscrew the covering (7) on pic. 8.
- Regulate the amount of the oil by turning the screw (8) clockwise (+) or counterclockwise (-).
- Screw the covering back.

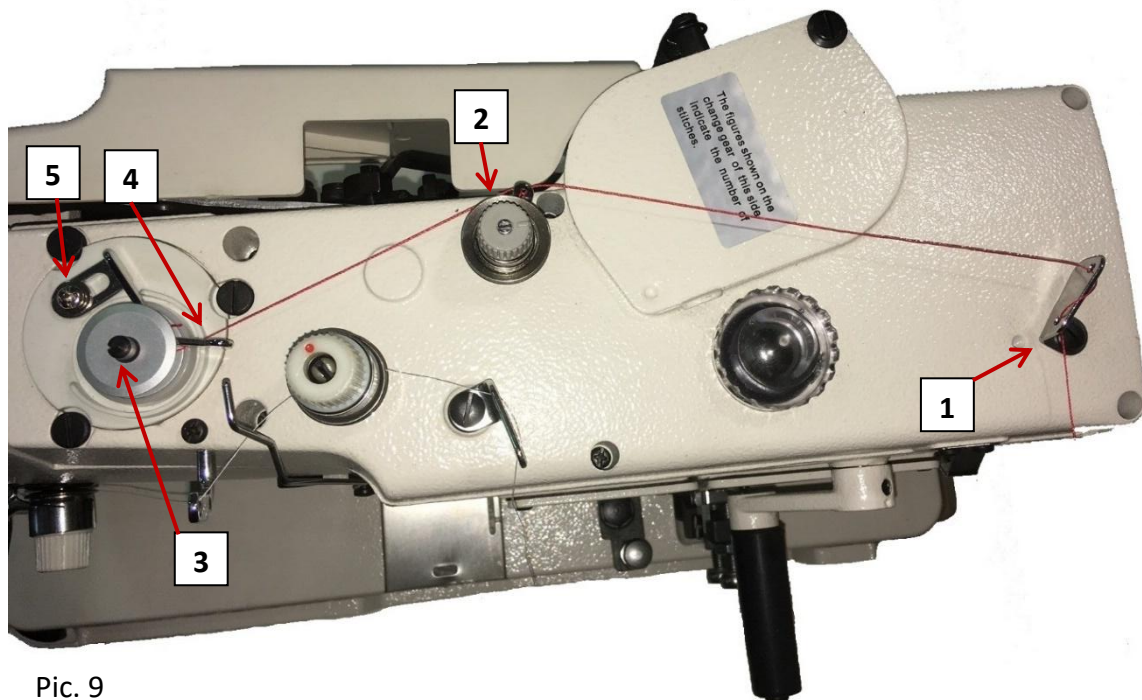
C.2. LOWER THREAD THREADING

C.2.1. Bobbin winding

Fasten the spool stand before the threading in case it is not installed yet.

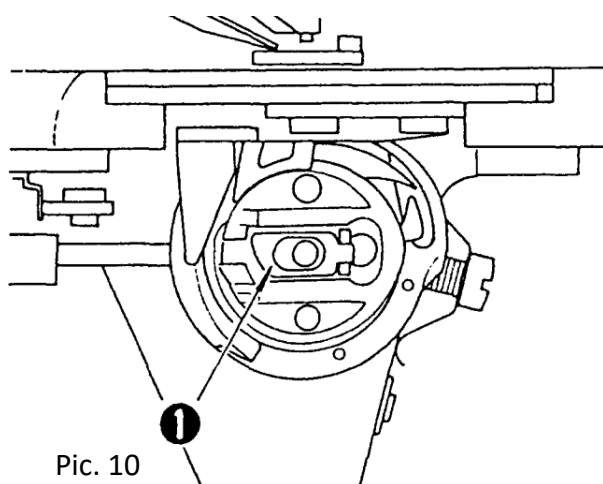
The process is demonstrated on the pic. 9:

- Put the bobbin on the winder shaft (3)
- The thread is led from the spool stand to the guide (1) to the first hole from the back to the front side and to the second hole in the guid from the back to the front side.
- Next lead the thread from the loop of the tensioner, between the tensioner discs and back through the tensioner loop out.
- Wind the thread around the bobbin several times.
- Press the stopper (4) towards to the shaft with bobbin (3).
- The winding starts after pressing the pedal. When the bobbin is fully winded, the winding is automatically stopped, and the stopper (4) jumps back from the shaft (3).
- The position of the stopper and amount of thread winded can be adjusted by the screw (5).



Pic. 9

C.2.2. Bobbin case removing and inserting



Pic. 10

Bobbin case removing:

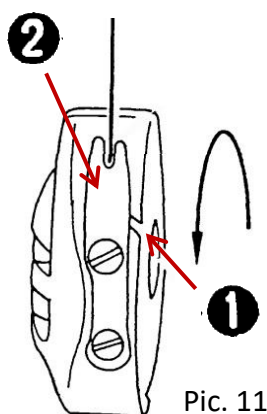
- Turn off the machine.
- Pull the lever (1) on pic. 10.
- Take out the bobbin case from the hook.

Bobbin case inserting:

- Follow the instruction in chapter C.2.3
- Take the lever of the bobbin case and insert it to the hook.
- Loosen the bobbin hook lever and turn the bobbin case by your thumb until it clacks.

To check if the bobbin case is inserted correctly, pull softly the bobbin case lever (1) - it must come back.

C.2.3. Bobbin inserting



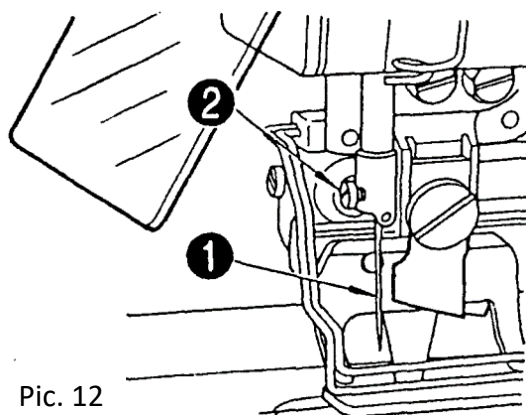
Pic. 11

- Insert the bobbin to the bobbin case so it turns clockwise (pic.11)
- Lead the thread trough the groove (1) under the spring (2) and pull it out.

Note: The bobbin must turn around in the direction marked on the pic 11.

C.3. UPPER THREAD THREADING

C.3.1. Needle insertion



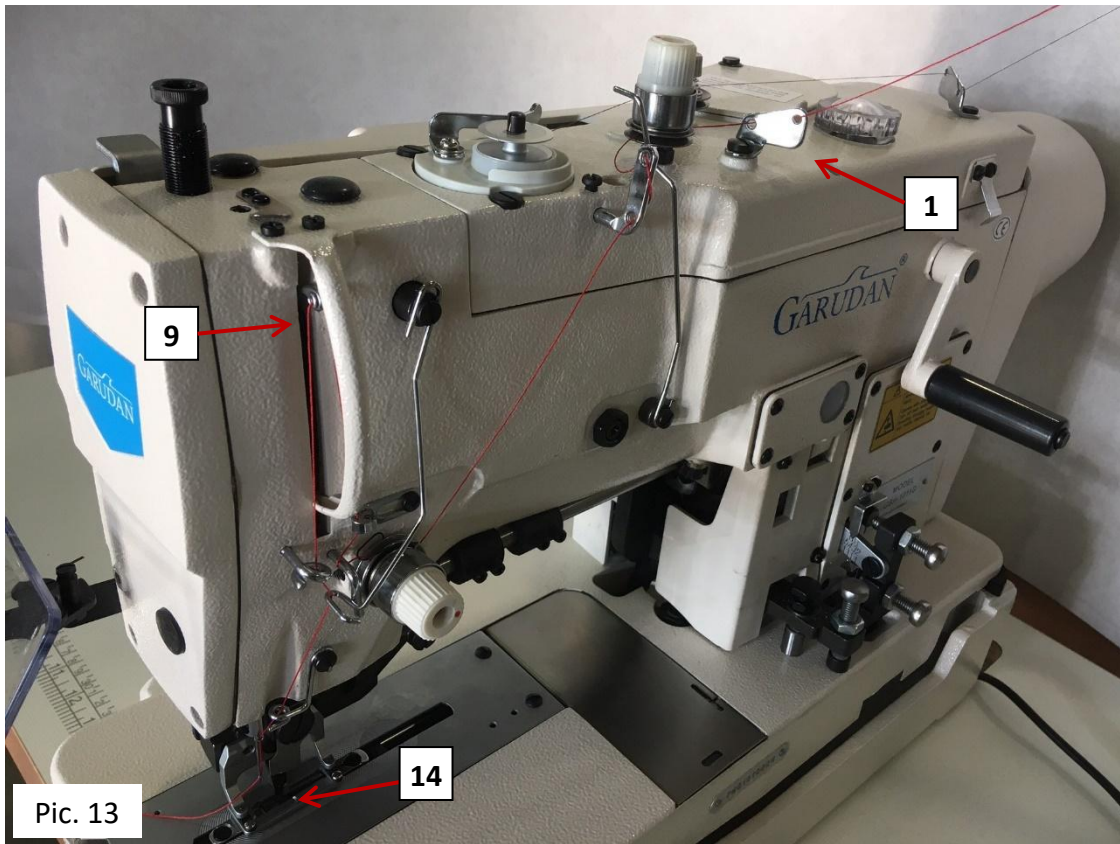
Pic. 12

- Turn off the machine.
- Use the needle in accordance with material used.
- Loosen the screw (2) and insert the needle (1) with the groove in opposite direction from the operator and tighten the screw back (2).

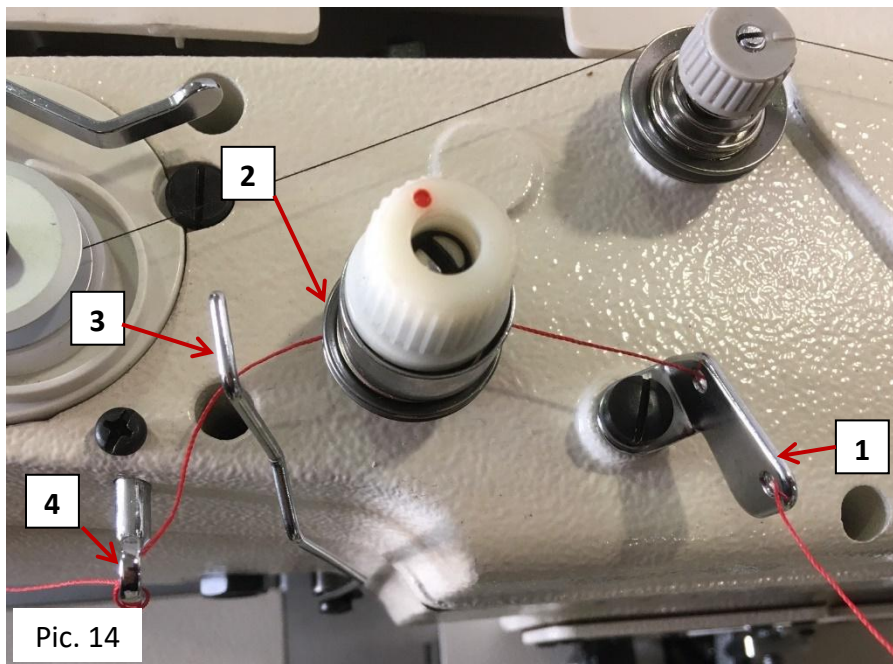
C.3.2. Upper thread threading

Follow the pictures 13 - 17:

- Turn off the machine.

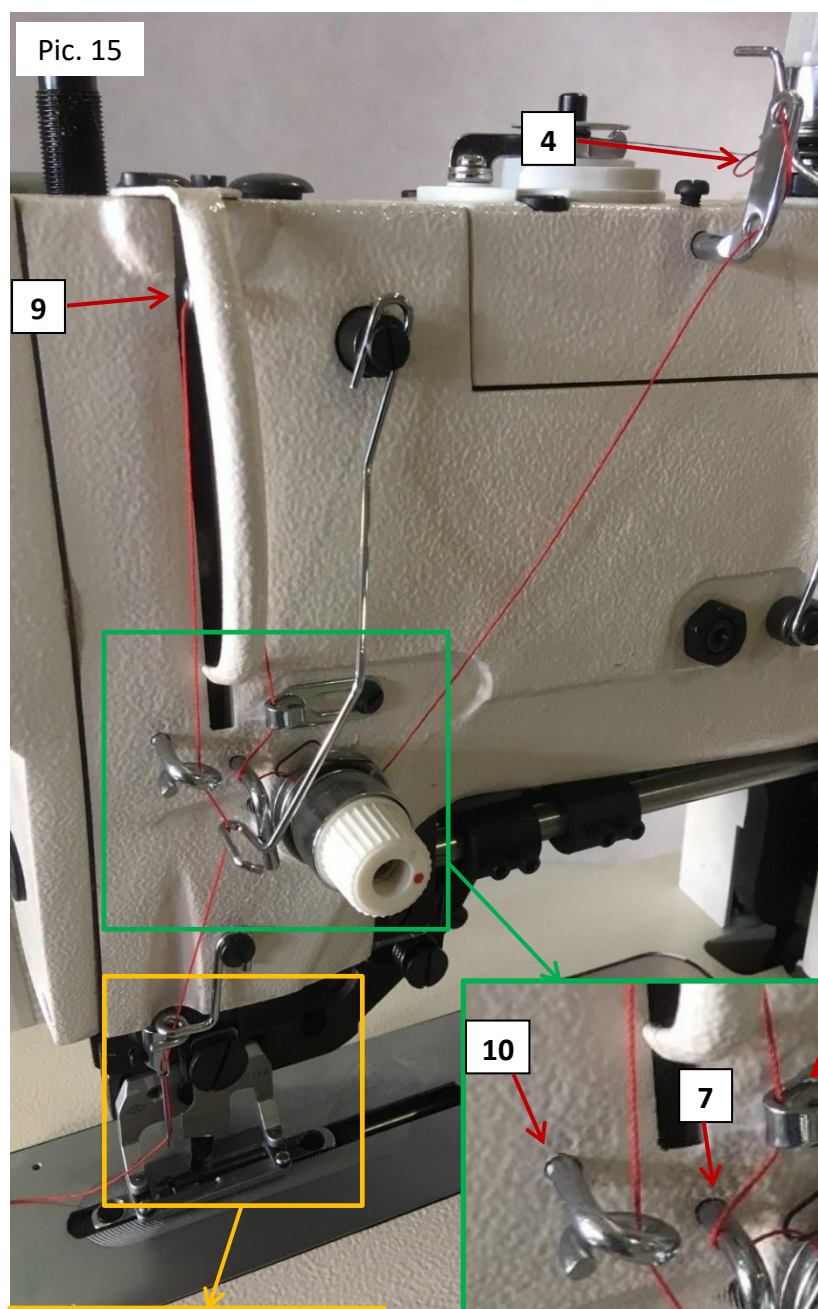


Upper view on picture 13.

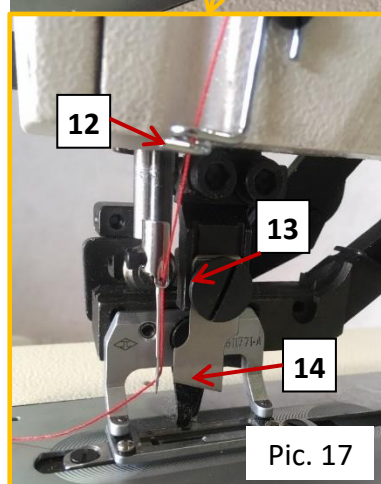
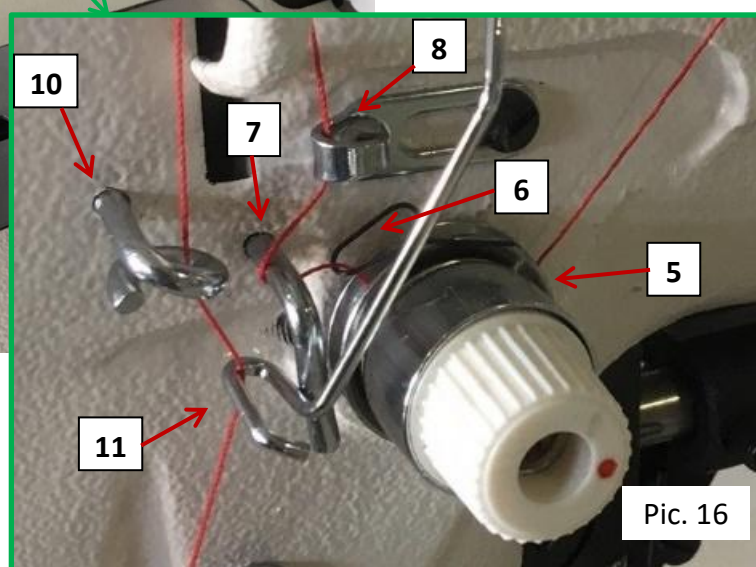


- Lead the thread according to the pic. 14 from the guide (1) between the tensioner discs (2) and next under the spring (3) to the guide (4).

Side view of picture 14



- Follow the picture 16. Lead the thread through the tensioner discs (5), to the tensioner spring (6), next through the holder (7) and to the guide (8).
- Stick the thread through the hole of the thread take up lever from the back to the front (9).
- Lead the thread through the guide (10) and hook it around the guide (11) as in pic. 15.
- Continue according to the picture 17. Lead the thread through the guide (12) and next through the guide on the needle bar (13). Finally, lead the thread through the needle from the back to the front side (14).



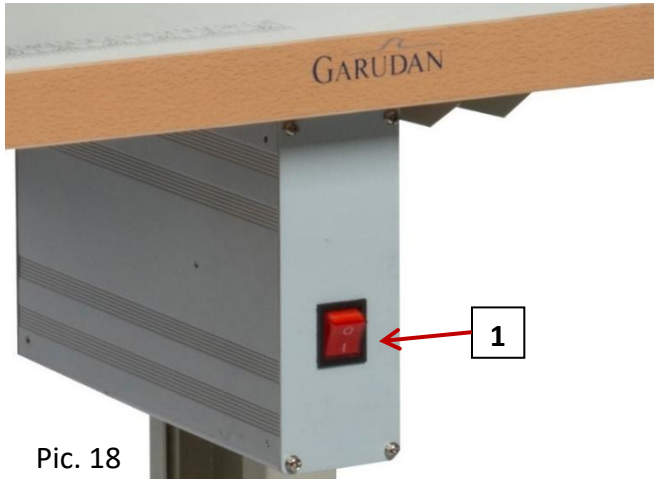
Note: While changing the upper thread, cut it between the spool stand and guide (1). After that, change the thread to a new one.

C.4. TURNING ON THE MACHINE

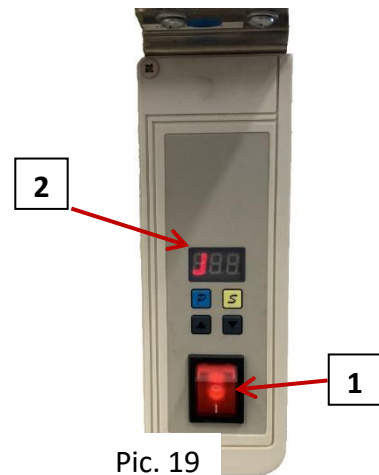
Attention: Do not press the pedal while turning on the machine.



- Turn on the machine with a main switch according to the control box version (pic. 18 for an older version with a separated control panel (pic. 20) and pic 19 for a new version with an integrated control panel located below the table).

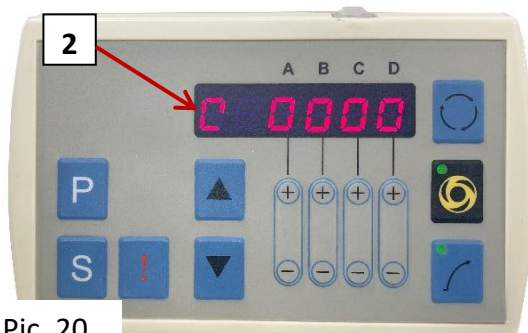


Pic. 18



Pic. 19

- Older version: The control panel lights up with a rotating icon on the pic. 20 signaling that the machine is running. (2)
- New version: The new version of the control box has an integrated control panel (pic 19).



Pic. 20

- Lift the presser frame with a frame lift pedal and insert the material.

Note: In case the machine is turned on and after a period it doesn't sew, the presser frame lift is blocked. Press backwards the pedal of sewing start simultaneously with the presser frame lift pedal to unblock it. Insert the sewing material.

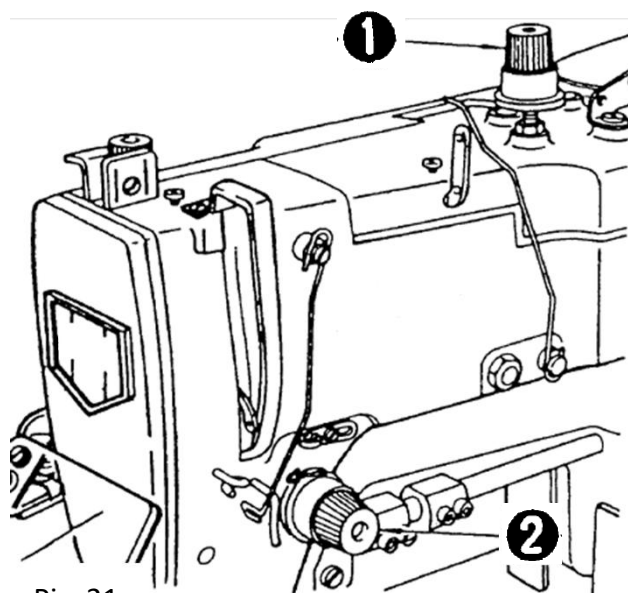
- Press forwards the pedal of sewing start. The hole is sewn, and the thread is trimmed.
- Check the correct tension of the threads (chapter D.1) and buttonhole size (chapter D.2)

Pedal positions – sewing start:

- Position 0: initial position
- Pressing backwards: unblocking the pedal of presser frame lift
- Pressing forward from position 0: the machine starts sewing a buttonhole.

D. MACHINE OPERATION

D.1. THREAD TENSION ADJUSTING



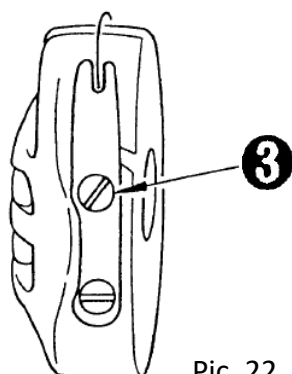
Pic. 21

D.1.1. Upper thread tension adjustment

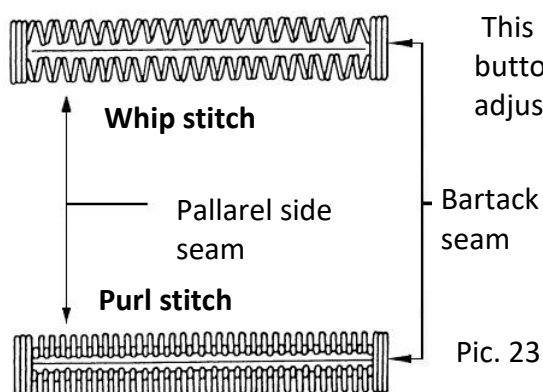
Upper thread tension is adjusted according to the pic.21. The tensioner 1 should be adjusted on 30 % and the tensioner 2 on 70 % of the upper thread tension needed. The first tensioner influences the upper thread tension while sewing the bartack. The second tensioner influences the tension of the upper thread while side sewing. If you turn the tensioner clockwise, the tension increases, while turning them counterclockwise, the tension lowers.

D.1.2. Lower thread tension adjustment

The lower thread tension is adjusted by the screw (3) on the pic.22. By turning the screw clockwise, the tension increases, while turning it counterclockwise, the tension lowers.



Pic. 22



This machine is constructed for two types of buttonholes sewing. Both need individual thread tension adjusting.

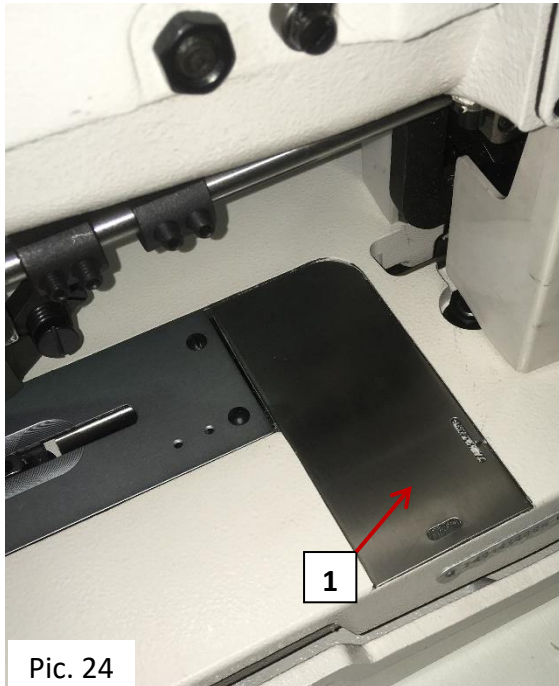
Buttonhole type:

- 1) Whip stitch
- 2) Purl stitch

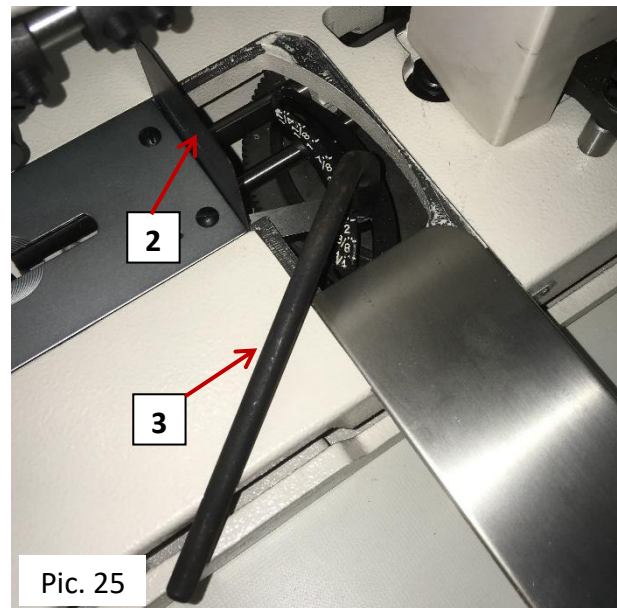
Pic. 23

D.2. BUTTONHOLE SIZE ADJUSTMENT

D.2.1. Buttonhole size adjustment

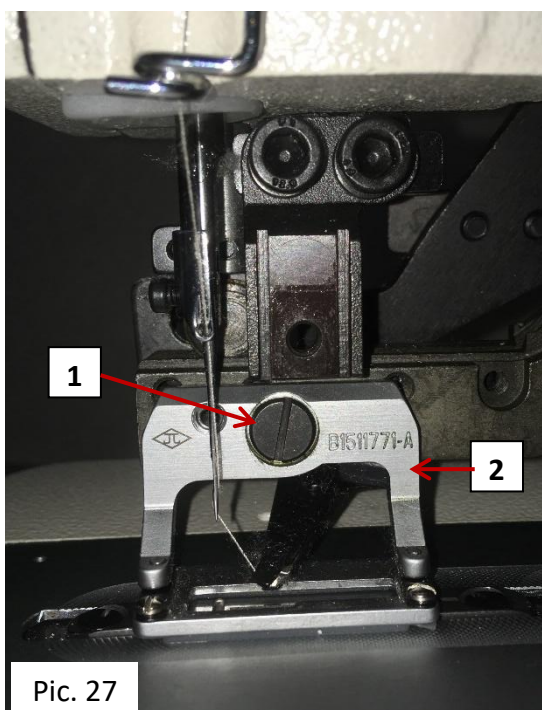


- Slide out the plate (1) on the pic. 24.
- Lift the covering (2) on the pic.25.
- Loosen the nut on the scale on the pic. 26 with a spanner.



- Adjust the size required. The sizes are in inches (1 inch = 2,54 cm).
- Tighten the nut.
- Turn back the covering (2) and the plate (1).
- Change the presser frame according to the buttonhole size (as in ch. D.2.2).
- Change the knife (as in ch. D.2.3).

D.2.2. Presser frame replacement

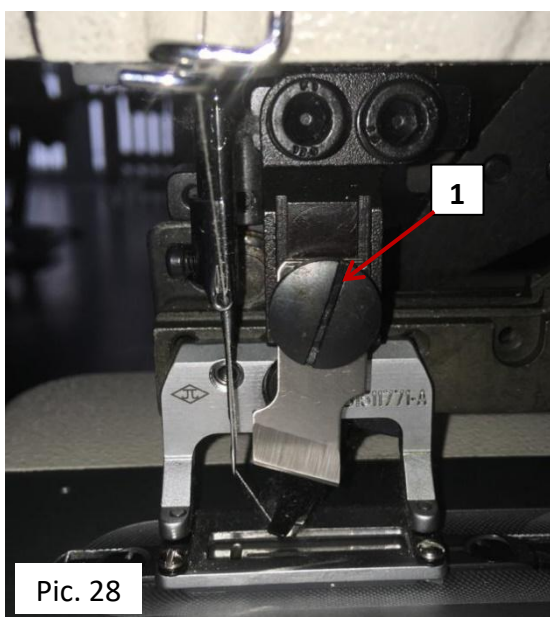


Pic. 27

- It is necessary to replace the presser frame if the buttonhole size is changed. Always use the frame of a same size (or bigger) as the buttonhole size.
- Dismantle the cutting knife according to the chapter D.2.3.
- Loosen and remove the screw (1) as on the pic. 27.
- Remove the presser frame (2).
- Install the size required of a presser frame.
- Install the cutting knife as in chapter D.2.3.

Presser frame (set)	Maximum buttonhole size
B1511-771-0A0	19,0 mm
B1511-772-0A0	25,4 mm
B1511-773-0A0	31,7 mm

D.2.3. Cutting knife replacement

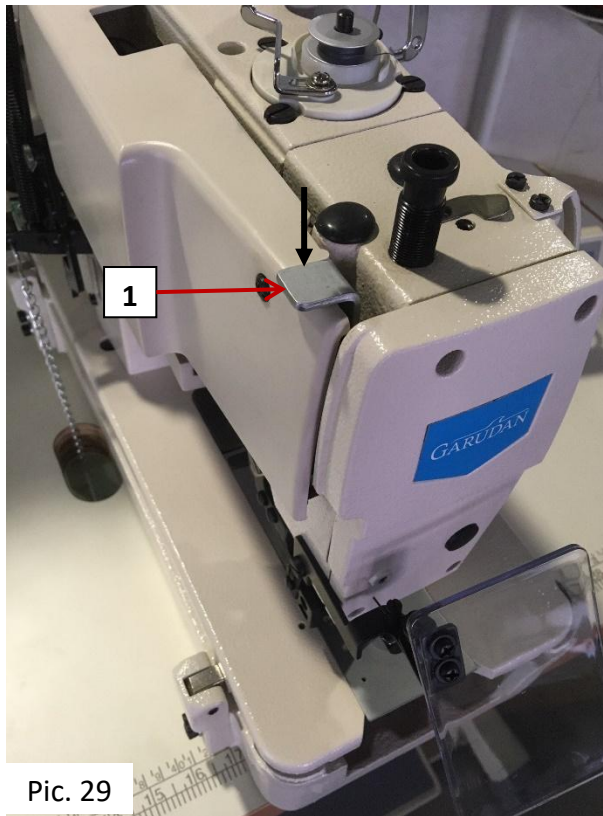


Pic. 28

- Loosen the screw (1) including the washer as on the picture 28.
- Remove the cutting knife.
- Install a cutting knife required on the screw with a washer and adjust its correct position.
- Note: The correct position is the lowest one.
- Install back the screw with a washer and tighten it back.

- Sew a testing buttonhole and check it. In case of need to increase or decrease the cut size repeat the instructions as in D.2.1. In case of narrower or wider bartack repeat the instructions as in D2.2. In case the holes are not cut properly, check the cutting knife size. If the size is not suitable, change the cutting knife as in chapter D.2.3. In case the size of the cutting knife is correct, adjust its position up.

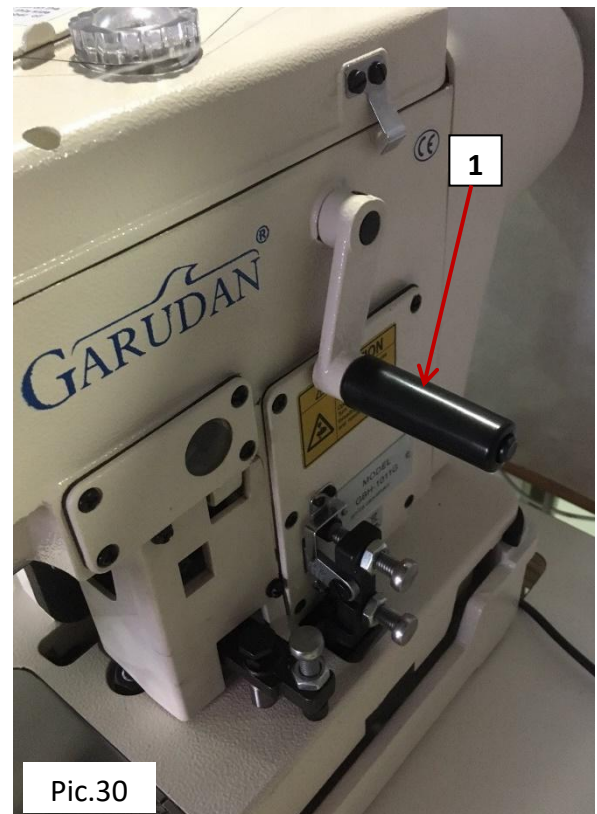
D.2.4. Cutting knife blocking



- In case you do not want to cut the buttonhole after bartacking, press the lever (1) on the pic. 29 in the direction marked by the arrow and hold it ↓ until the machine stops.

D.2.5. Manual feeding

- The manual feeding can be used after emergency stop or after breaking the thread. By turning the crank (1) on the picture 30 the machine starts running again manually. Before using the manual feeding, make sure that the needle is out of the material sewn.

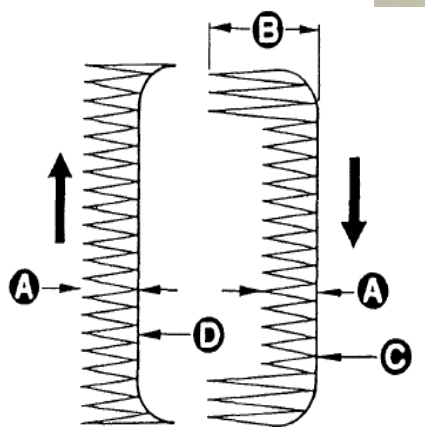


D.2.6. Bartack width adjustment and starting position settings

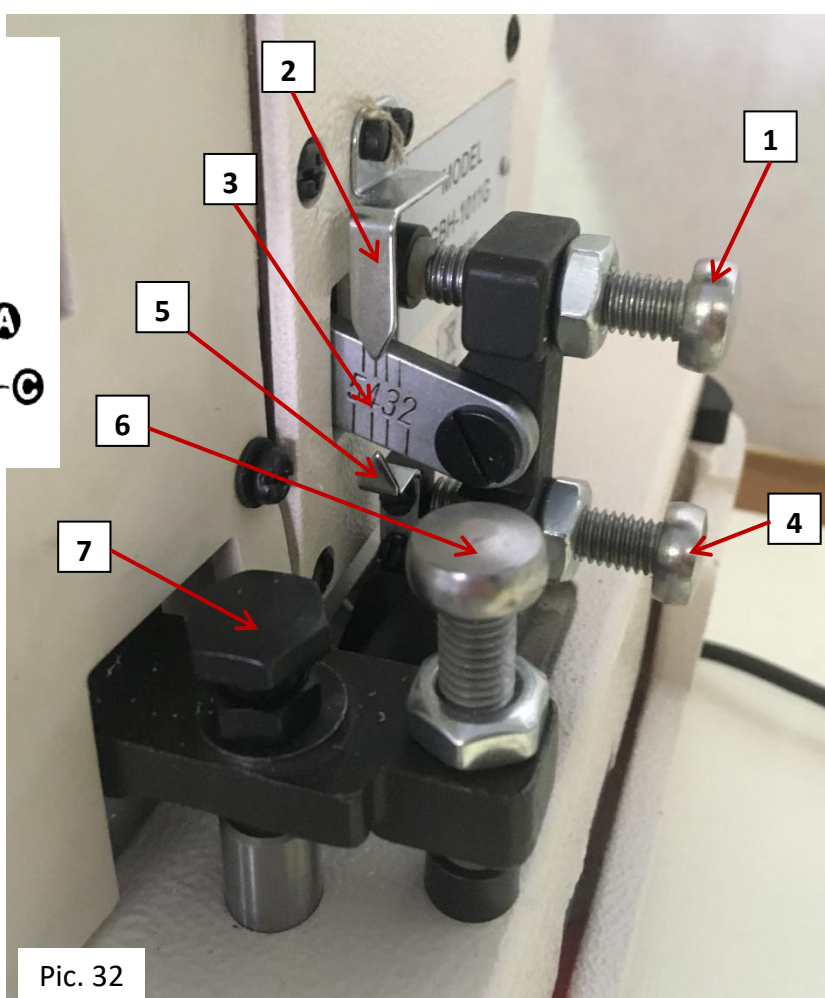
Buttonhole bartack – stitch and bartack width

Starting position

- The needle moves from the right to the left from the right line set as starting position. The adjustment is pictured on pic. 31 and 32.
- 1) To adjust the stitch width (A) loosen the screw (1) and set the pointer (2) to the stitch width required marked on the gauge (3). Attention: The stitch width will be half of the value on the gauge.
- 2) To adjust the bartack width (B) loosen the screw (4) and set the pointer (2) to the width required marked on the gauge (3). The bartack width (B) should be 2x stitch width.
- 3) To adjust the starting position (C) loosen/tighten the screw (6) so the position would be out of the cutting knife. By tightening the screw (6) the starting position moves to the left.



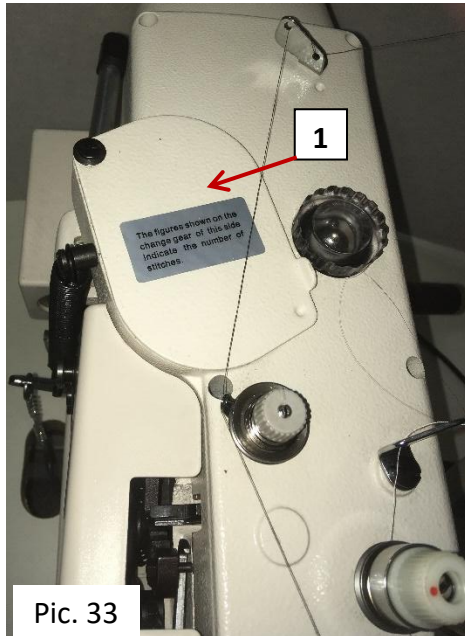
Pic. 31



Pic. 32

D.2.7. Stitch quantity adjustment

The stitch quantity can be adjusted by changing the drive gears as mentioned on the table below. The stitch quantity and symbols are marked on the gears. It is always necessary to use the gear wheels marked with the same symbol.



Pic. 33

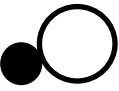
- Lift the covering (1) as on the pic. 33
- Remove the gear wheels K1 and K2 pic. 34
- Insert the gear wheels required. It is necessary to use the gear wheels marked with the same symbol.
- Put back the covering (1).

By



Pic. 34

Combining the gears, we can set the required number of stitches according to the table.:

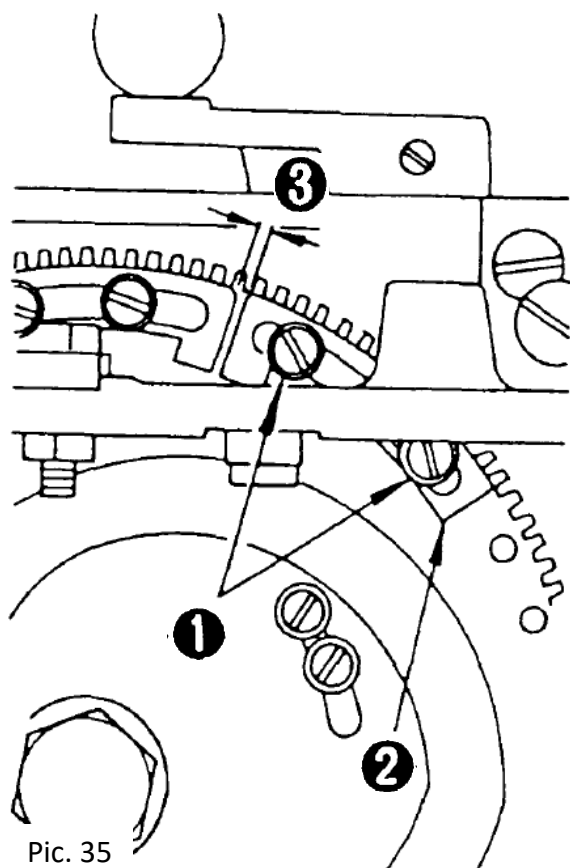
			
			
G	83	225	83
J	100	190	100
L	110	170	110
N	123	152	123

			
			
N	152	123	152
L	170	110	170
J	190	100	190
G	225	83	225

Symbole	Stitch quantity of the small gear wheel	Stitch quantity of the large gear wheel
G	83	225
J	100	190
L	110	170
N	123	152

ATTENTION: Check the moment of switching to lower after changing the gear wheels. (The quantity of the revolutions before the machine stops).

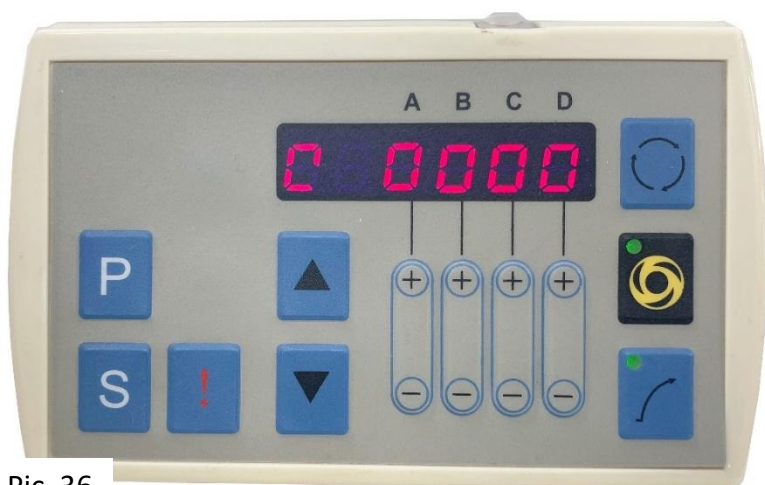
Check and adjust the moment of switching to lower speed as follows:



- loosen the screws (1) as on the pic. 35.
- adjust the position of the low-speed cam (2) to adjust the clearance as on the pic. 35.

stitch quantity 	Clearance set (3)
93 stitches and less	10-12 mm
115 stitches and less	5 mm
123 stitches	0

D.2.8. Control panel



Pic. 36



Pic. 37

D.2.9. Functions of the Control panel

Note: The driving unit allows a use with various sewing machine models with various grades of equipment. If your machine isn't equipped with a certain equipment, some of the functions of the control panel are not available for your machine model.

Button	Description
	Parameter entrance: Press the button to enter/leave the parameter settings
	Parameters editing and saving: Press once to edit, after editing/changing the parameter press again to save.
	Press to interrupt the sewing while the sewing cycle.
	Resets the settings.
	LED icon is not lighted: The bartack can be controlled by pressing the pedal. LED icon is lighted: The bartack is made automatically after pressing the pedal.
	LED icon is lighted: slow start function is on LED icon is not lighted: slow start function is off
	Increases the sewing speed – plus 50 revolutions/min with each press
	Decreases the sewing speed – minus 50 revolutions/min with each press

Note: Older version of the control panel (pic. 36)
Now version of the control panel (pic. 37)

E. MAINTENANCE

E.1. MACHINE LUBRICATION

The machine lubrication is described in chapter C1. Use oil for sewing machines – type M22. It is recommended to Purchase the oil from Garudan company.

E.2. MACHINE CLEANING

Clean the machine daily.

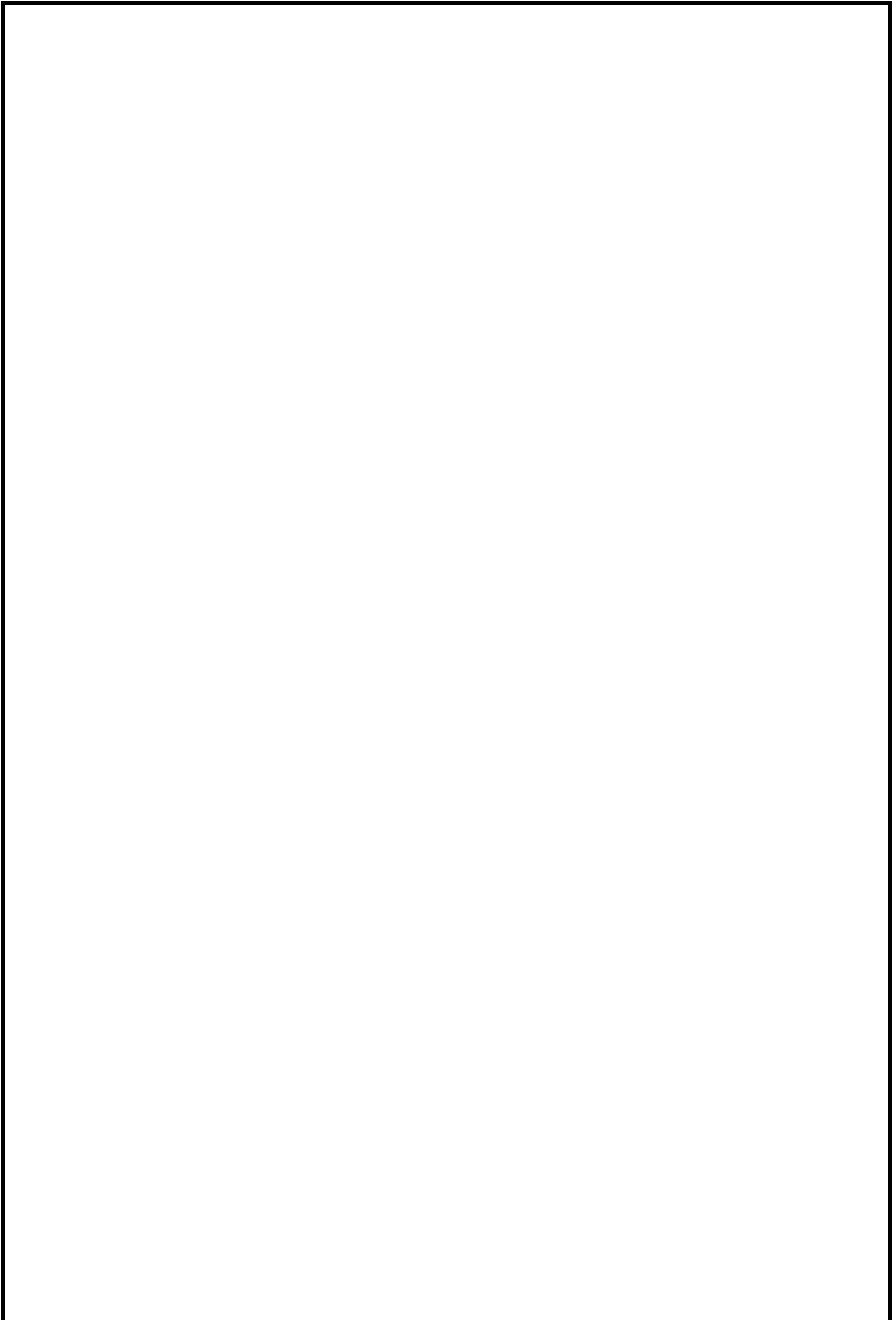
Focus mainly on the needle plate and hook surroundings.

F. MALFUNCTIONS AND THEIR SOLUTIONS

In the table below are mentioned the malfunctions that can be solutioned manually.

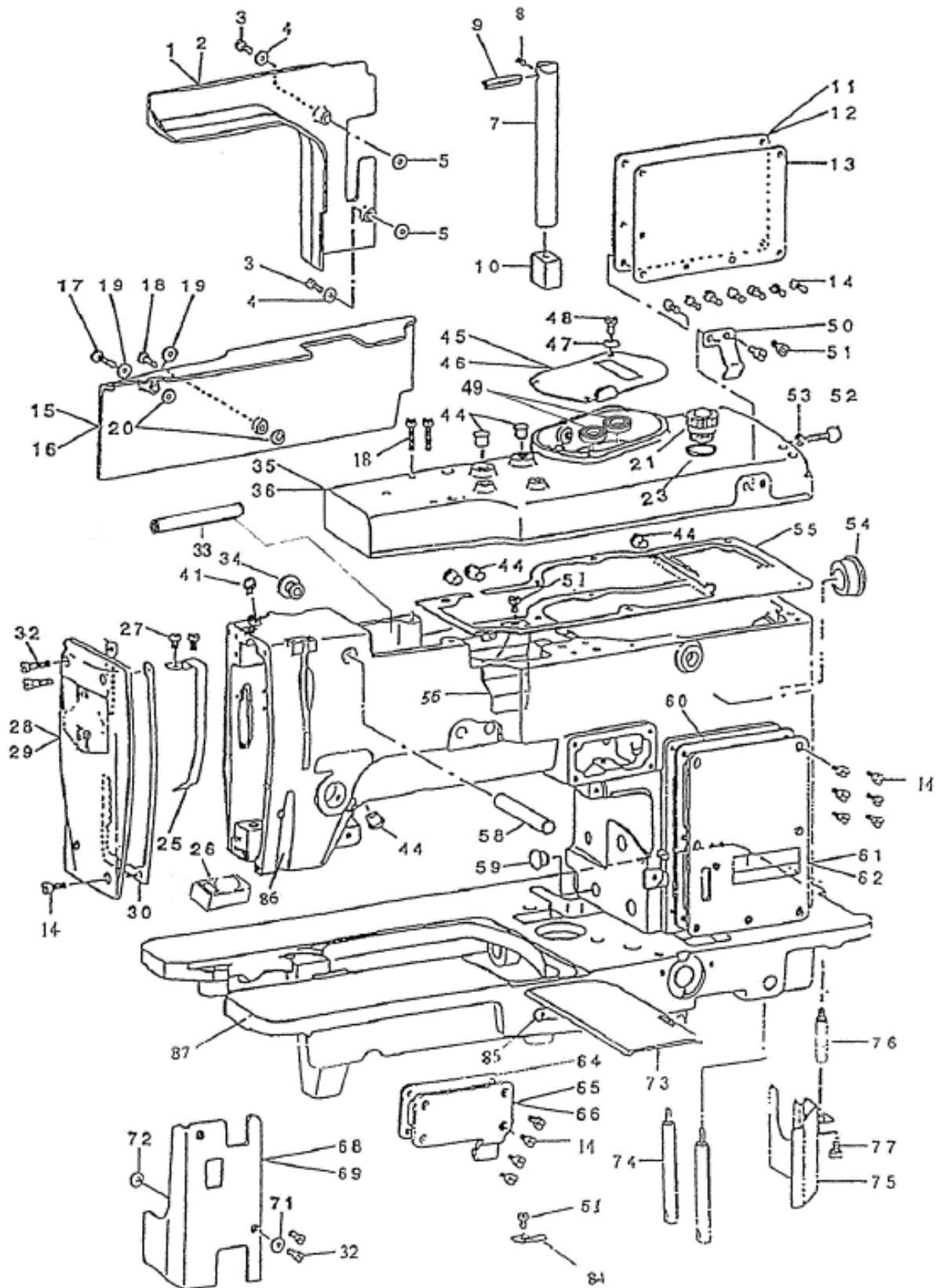
Malfunction	Cause	Solution
Skipped stitches	The needle is damaged	Check or replace the needle (chapter C.3.1)
	The upper thread is threaded incorrectly	Check if all the tensioners and guides were threaded correctly. (chapter C.3.2)
	The bobbin is not winded correctly	Check the bobbin winding and correct bobbin inserting (chapter C.2.)
	The tension is not adjusted correctly	Adjust the upper thread tension (chapter D.1.1.) Adjust the lower thread tension (chapter D.1.2.)
The thread brakes	The needle is damaged	Check or replace the needle (chapter C.3.1)
	The tension is not adjusted correctly	Adjust the upper thread tension (chapter D.1.1.) Adjust the lower thread tension (chapter D.1.2.)
	The upper thread is threaded incorrectly	Check if all the tensioners and guides were threaded correctly. (chapter C.3.2)
	The bobbin is inserted incorrectly	Check if the bobbin is unwinding in a correct direction and if it's inserted to the machine correctly. (chapter C.2.3.)
The interlacing is not correct	The tension is not adjusted correctly	Adjust the upper thread tension (chapter D.1.1.) Adjust the lower thread tension

		(chapter D.1.2.)
	The upper thread is threaded incorrectly	Check if all the tensioners and guides were threaded correctly. (chapter C.3.2)
	The bobbin is inserted incorrectly	Check if the bobbin is unwinding in a correct direction and if it's inserted to the machine correctly. (chapter C.2.3.)
The hole is not cut properly	Incorrect position of the cutting knife	Check the cutting knife position (chapter D.2.3)
	The cutting knife is blunt	Replace the cutting knife (chapter D.2.3)
	The cutting knife is damaged	Replace the cutting knife (chapter D.2.3)
The thread is not trimmed		



G. SPARE PARTS LIST

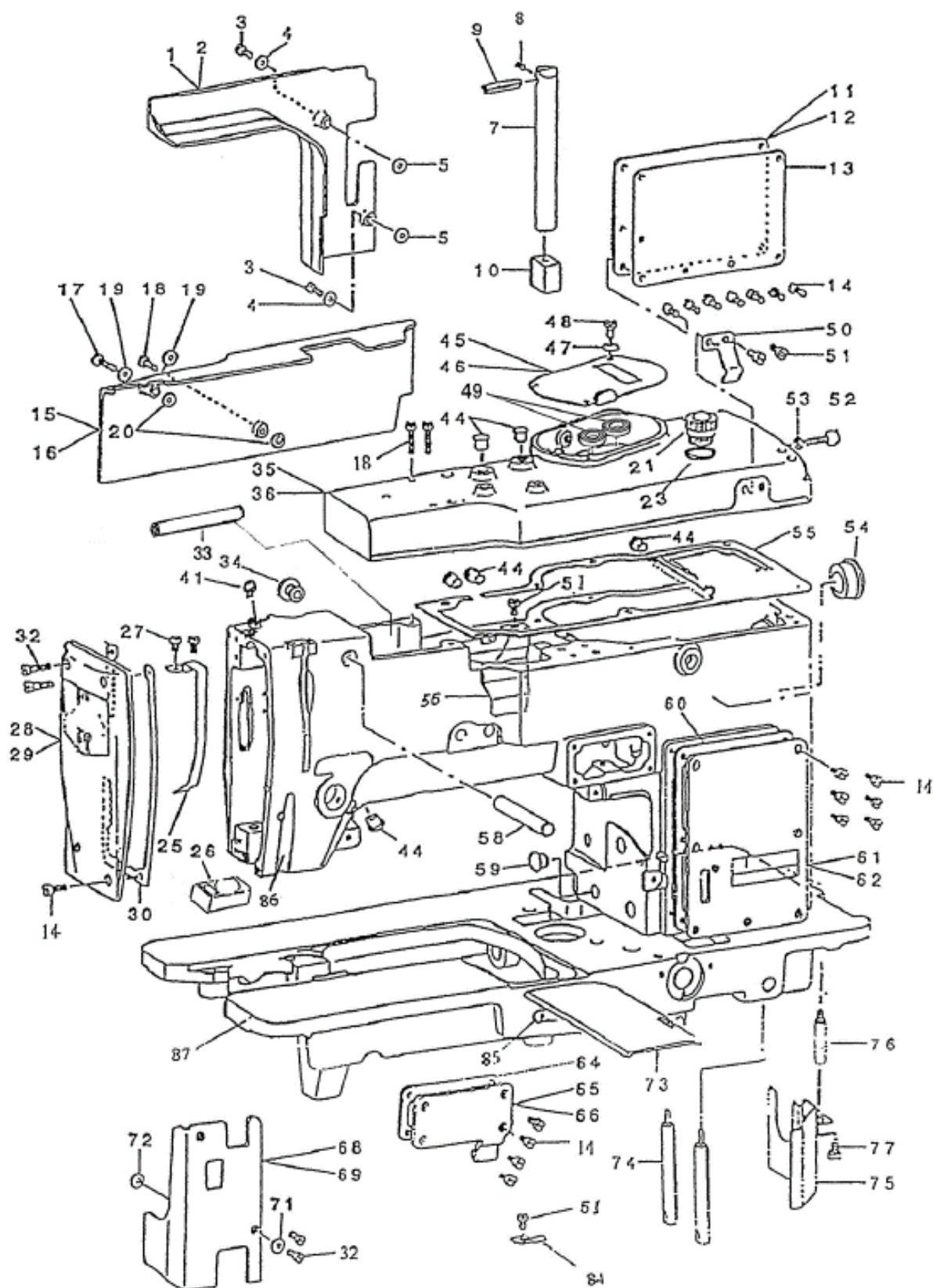
G.1. FRAME & MISCELLANEOUS COVER COMPONENTS (1/2)



G.1. Frame & miscellaneous cover components (1/2)

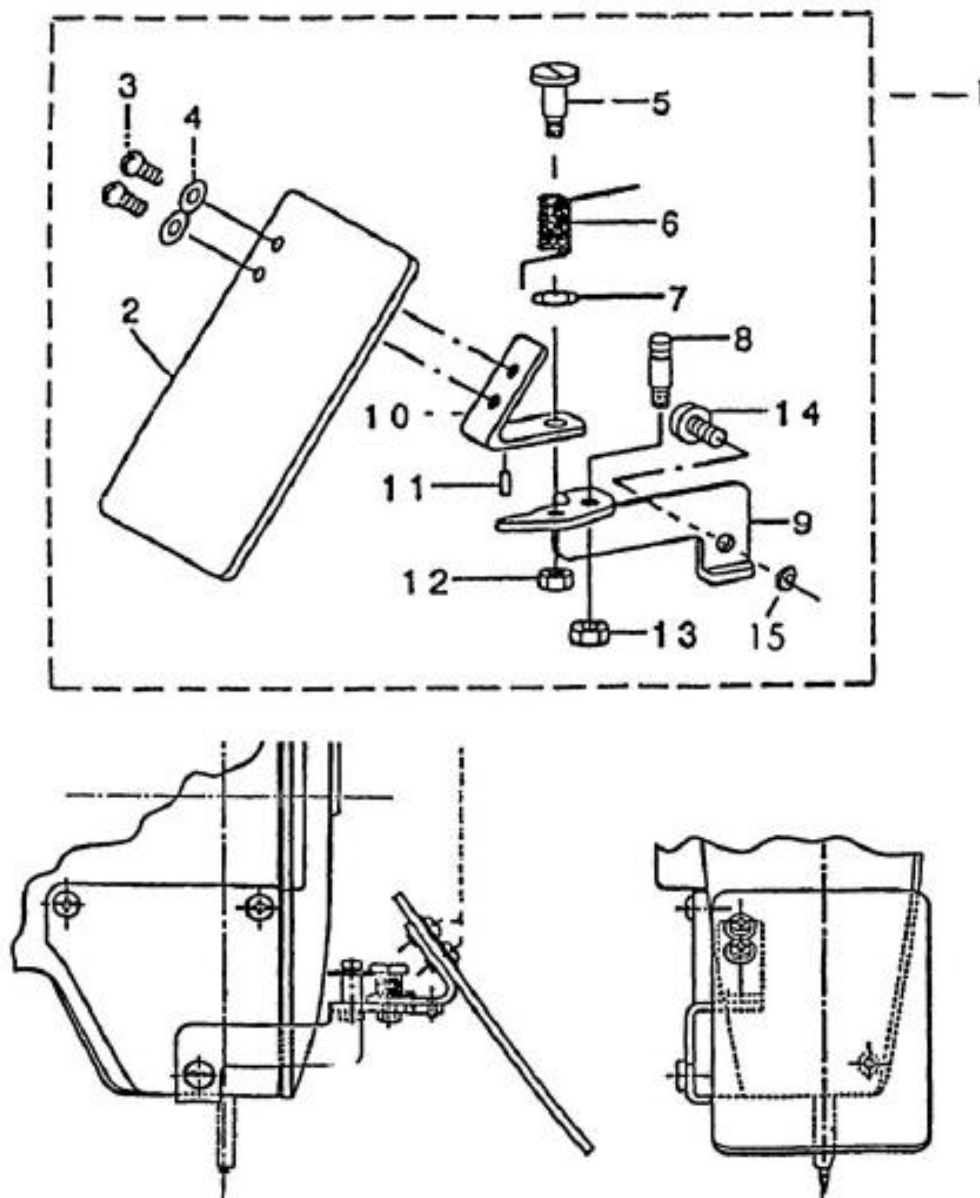
Ref. No	Parts No.	Name of parts	Description	Qty	Note
1	780-10106	FRAME SIDE COVER B		1	
3	780-10107	SCREW	11/64-40 L=12	2	
4	780-10108	WASHER	4,5 x 8 x 0,5	2	
5	780-10109	CUSHION		2	
7	780-10110	MACHINE ARM SUPPORT ROD		1	
8	780-10111	SCREW 11/64-40 L=5	11/64-40 L=5	1	
9	GB879-76	PIN		1	
10	780-10112	RUBBER CUSHION		1	
11	780-10113	SIDE COVER (C)		1	
13	780-10114	SIDE COVER GASKET (C)		1	
14	780-10115	SCREW	11/64-40 L=9	20	
15	780A-10116	FRAME SIDE COVER (C)		1	
17	780-10117	SCREW	11/64-40 L=22	1	
18	780-10118	SCREW	11/64-40 L=18	7	
19	780-10109	CUSHION		2	
20	780-10119	FRAME SIDE COVER GASKET (C)		2	
21	780-OSW	OIL SIGHT WINDOW	M26x1,5	1	
23	68/13452. 1-1992	OIL SIGHT WINDOW GASKET		1	
25	780-10122	THREAD TAKE-UP LEVER OIL GUARD		1	
26	780A-10126	BLOCK OIL PLANK		1	
27	780-10123	SCREW	9/64-40 L=5	2	
28	780A-10124	FACE COVER COMPLETE		1	
30	780A-10125	FACE PLATE GASKET		1	
32	780-10127	SCREW	11/64-40 L=14	4	
33	780A-10128	STEEL PIPE		4	
35	780A-10129	TOP COVER		1	
41	750A-10133	RUBBER PLUG		1	
44	780-10135	RUBBER PLUG		7	
45	780-10136	GEAR CASE COVER		1	
47	GB/T860-1986	DISK SPRING		1	
48	780-10137	HINGE SCREW	D=3,65 H=2,6	1	
49	GB/T13871-1992	RUBBER RING	ø22 x ø35x7	2	
50	780-10139	HAND STOP LATCH		1	
51	780-10140	SCREW	11/64-40 L=7	4	
52	780-10141	BALL SCREW		1	
53	780-10142	NUT	3/16-28	1	
54	780-10143	RUBBER PLUG		1	
55	780A-10144	TOP COVER GASKET REAR		1	
56	780-10145	ARM OIL SHIELD		1	

G.2. FRAME & MISCELLANEOUS COVER COMPONENTS (2/2)



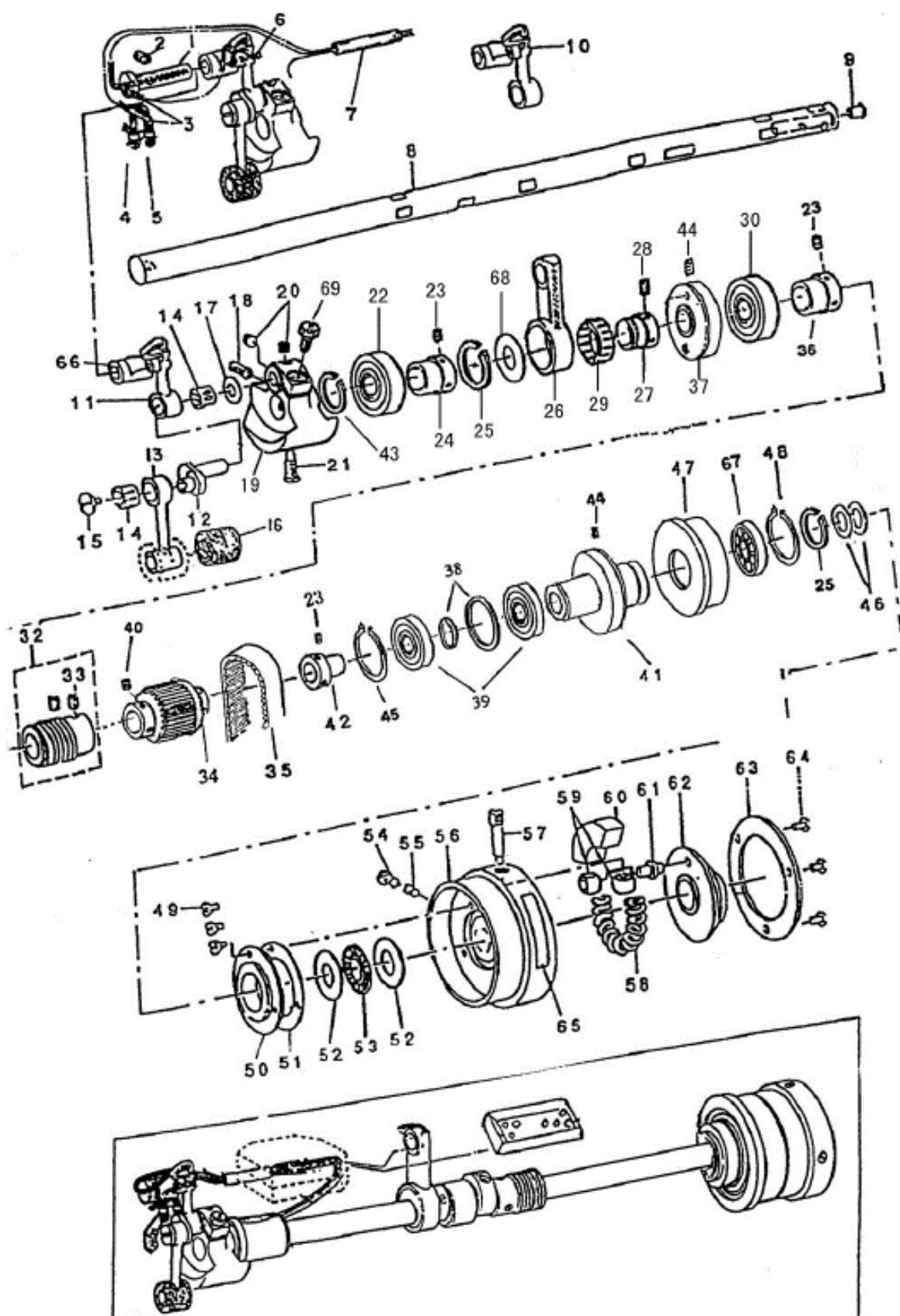
G.2. Frame & miscellaneous cover components (2/2)					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
58	780-10146	KNIFE STOP LEVER SHAFT GUIDE		1	
59	780-10147	RUBBER PLUG		1	
60	780-10148	SIDE COVER (A) GASKET		1	
61	780-10149	SIDE COVER (A)		1	
64	780-10150	OIL SIGHT WINDOW GASKET		1	
65	780A-10151	SIDE COVER B		1	
68	780-10152	SIDE COVER A		1	
71	780-10108	WASHER	4,5 x 8 x 0,5	2	
72	780-10109	CUSHION		2	
73	780-10153	BED SLIDE		1	
74	780A-10155	BED SCREW STUD A		2	
75	780-10156	BED OIL SHIELD		1	
76	780-10157	LOOPER COVER OIL SHIELD STUD		1	
77	780-10158	SCREW	11/64-40 L=5	1	
84	780-10154	BED SLIDE SPRING		1	
86	780-10101	MACHINE HEAD		1	
87	780-10102	SCALEBOARD		1	

G.3. COVER COMPONENT



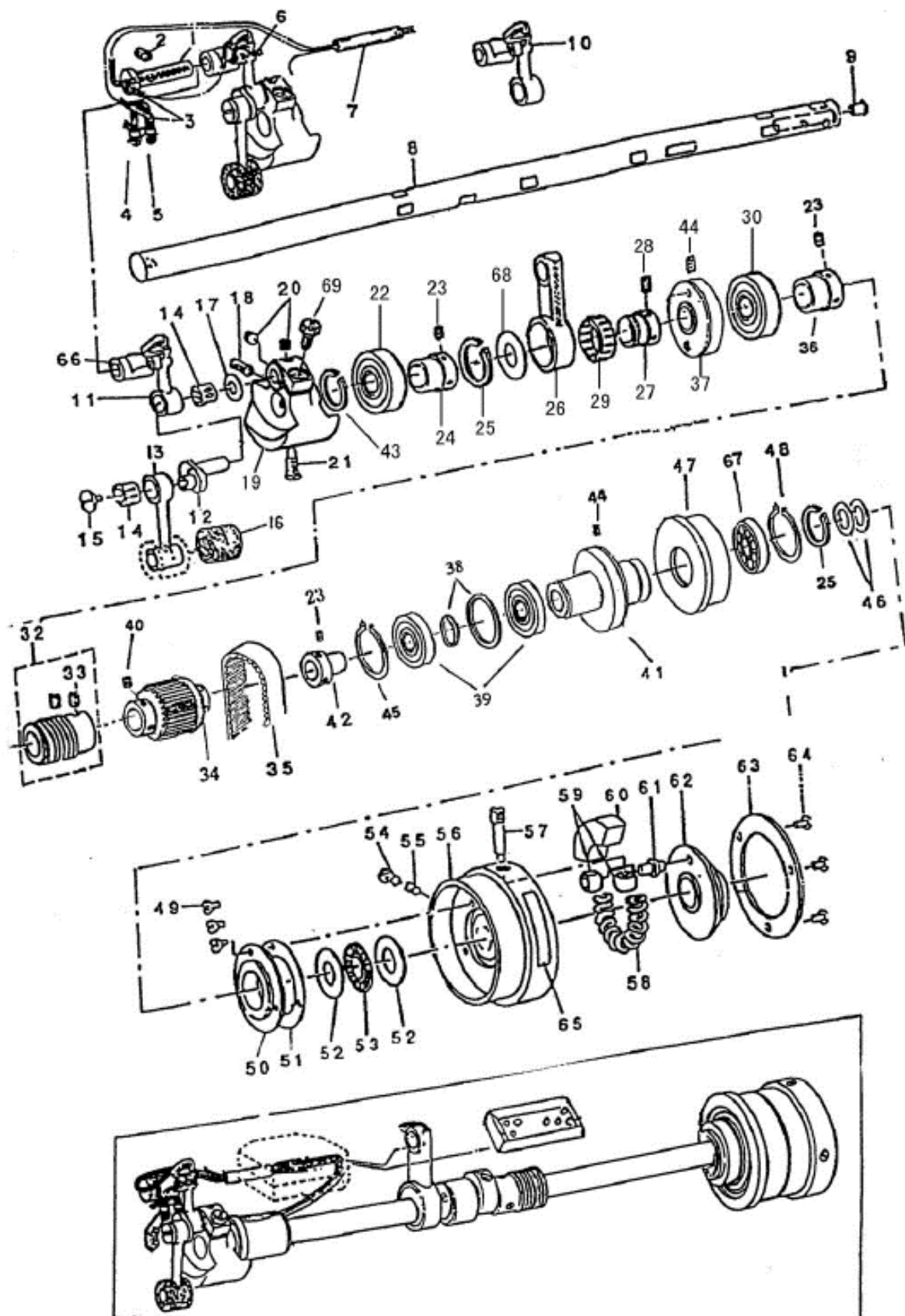
G.3.Cover components					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
1	780-10201	SAFETY PLATE ASM		1	
2	780-10202	SAFETY PLATE		1	
3	780-10203	SCREW	11/64-40 L=7	2	
4	780-10204	WASHER	4,5 x 10 x 0,8	2	
5	780-10205	HINGE SCREW		1	
6	780-10206	SAFETY PLATE RETURN SPRING		1	
7	780-10207	WASHER	7,4 x 11,8 x 0,5	1	
8	780-10208	TENSION SPRING RACK B		1	
9	780-10209	SAFETY PLATE INSTALLING BASE		1	
10	780-10210	SAFETY PLATE INSTALLING PLATE		1	
11	GB879-76	SPRING PIN	2 x 6	1	
12	780-10211	NUT	11/64-40	1	
13	780-10142	NUT	3/16-28	1	
14	780A-10529	SCREW	11/64-40 L=8	1	
15	780A-11432	WASHER	6,5 x 11 x 1	1	

G.4. MAIN SHAFT COMPONENTS (1/2)



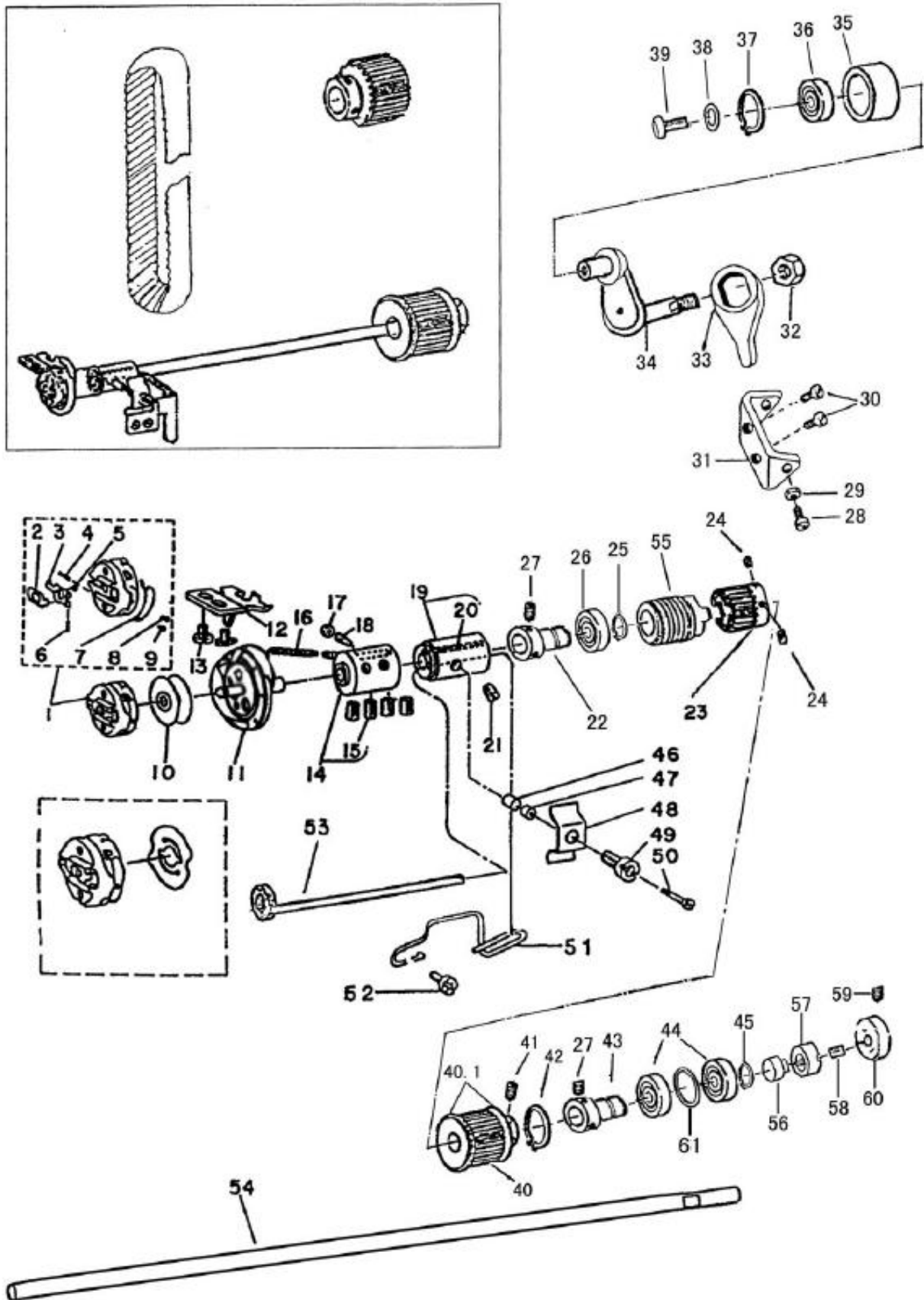
G.4. Main shaft components (1/2)					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
1	780-10301	HINGE STUD		1	
2	780-10302	SCREW	15/64-28 L=10,5	1	
3	780-10303	OIL WICK		1	
4	780A-10304	OIL WICK		1	
5	780A-10305	OIL WICK		1	
6	780-10306	OIL WICK SNAP RING		1	
7	780-10307	VINYL PIPE		1	
8	780A-10308	MAIN SHAFT		1	
9	780-10309	RUBBER PLUG		1	
10	780-10310	THREAD TAKE-UP LEVER ASM CER		1	
11	780-10312	THREAD TAKE-UP LEVER ASM		1	
12	780-10313	NEEDLE BAR CRANK		1	
13	780-10314	NEEDLE BAR CRANK CONNECTING RO		1	
14	GB2581-76	NEEDLE BEARING		2	
15	780-10315	LEFT SCREW		1	
16	780-10316	OIL FELT WASHER		1	
17	780-10317	NEEDLE ROD CRANK WASHER		1	
18	780-10318	SCREW	9/32-28 L=16	1	
19	780-10319	COUNTERWEIGHT		1	
20	780-10320	SCREW	1/4-40 L=5	2	
21	780-10321	SCREW	9/32-28 L=15,8	1	
22	6204-22	BUSHING FRONT		1	
23	780-10331	SCREW	1/4-40 L=6	6	
24	780A-10324	BUSHING FRONT POSITION SET		1	
25	GB/T894.1-1986	RETAINING RING 25		1	
26	780A-10326	KNIFE BAR DRIVING CONNECTING R		1	
27	780A-10327	KNIFE BAR DRIVING ECCENTRIC		2	
28	780-10328	SCREW	1/4-40 L=8	1	
29	9240/25xa29x12,5	NEEDLE BEARING		1	
30	61904-Z	BEARING		1	
31	780-10302	SCREW	15/64-28 L=10,5	1	
32	780-10330	TENSION POST NO. 3		1	
33	780-10331	SCREW	1/4-40 L=6	2	
34	780A-10332	UPPER SHAFT SPROCKET		1	
35	780A-10336	TIMING BELT		1	
36	780A-10334	BUSHING CENTER POSITION SET		1	
37	780A-10333	BUSHING CENTER SET		1	
38	780A-10335	BUSHING BEHIND RING		2	
39	61904-Z	BUSHING BEHIND		2	

G.5. MAIN SHAFT COMPONENTS (2/2)



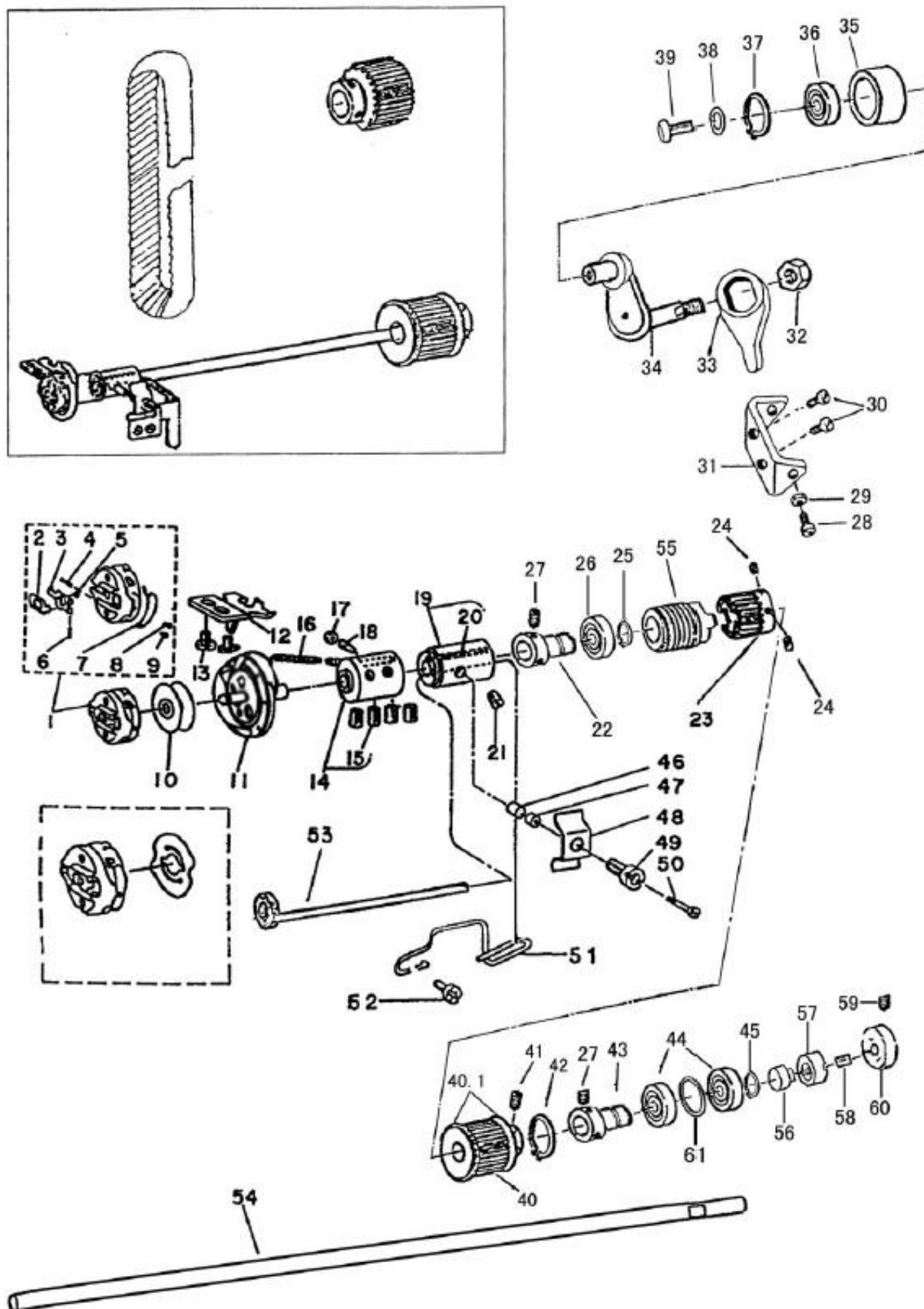
G.5. Main shaft components (2/2)					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
40	GB/T77-2000	SCREW	M67	2	
41	780A-10337	BUSHING BEHIND BASE		1	
42	780A-10338	BUSHING BEHIND POSITION SET		1	
43	GB/T894. 1-1986	RETAINING RING 20		1	
44	780-10323	SCREW	15/64-28 L=7	2	
45	GB/T893. 1-1986	RETAINING RING 37		1	
46	780-10341	WASHER B		1	
47	780-10342	LOOSE PULLEY ASM		1	
48	GB894-76	RETAINING RING 30		1	
49	780-10343	SCREW	9/64-40 L=3,5	3	
50	780-10344	MAIN SHAFT THRUST SEEL		1	
51	780-10345	GASKET		1	
52	780-10346	THRUST WASHER A		2	
53	JB2581-76	BEARING		1	
54	780-10348	SCREW	1/4-40 L=5,0	1	
55	780-10320	SCREW	1/4-40 L=5	1	
56	780-10349	DRIVING PULLEY		1	
57	780-10350	SCREW (C)		1	
58	780-10351	STOP CAM PRESSURE SPRING		1	
59	780-10352	STOP MOTION CAM PIN SLIDE BLOC		2	
60	780-10353	BAKE ITE SEGMENT		1	
61	780-10354	STOP MOTION CAM POSITION PIN		1	
62	780-10355	STOP MOTION CAM		1	
63	780-10356	STOP MOTION CAM PRESSER PLATE		1	
64	780-10140	SCREW	11/64-40 L=7	3	
65	780-10357	DIRE TION LABEL		1	
66	780-10311	HINGE CRANK		1	
67	GB278-76	BEARING		1	
68	780A-10358	ECCENTRIC CAM RETAINING RING		1	

G.6. HOOK DRIVING SHAFT COMPONENTS (1/2)



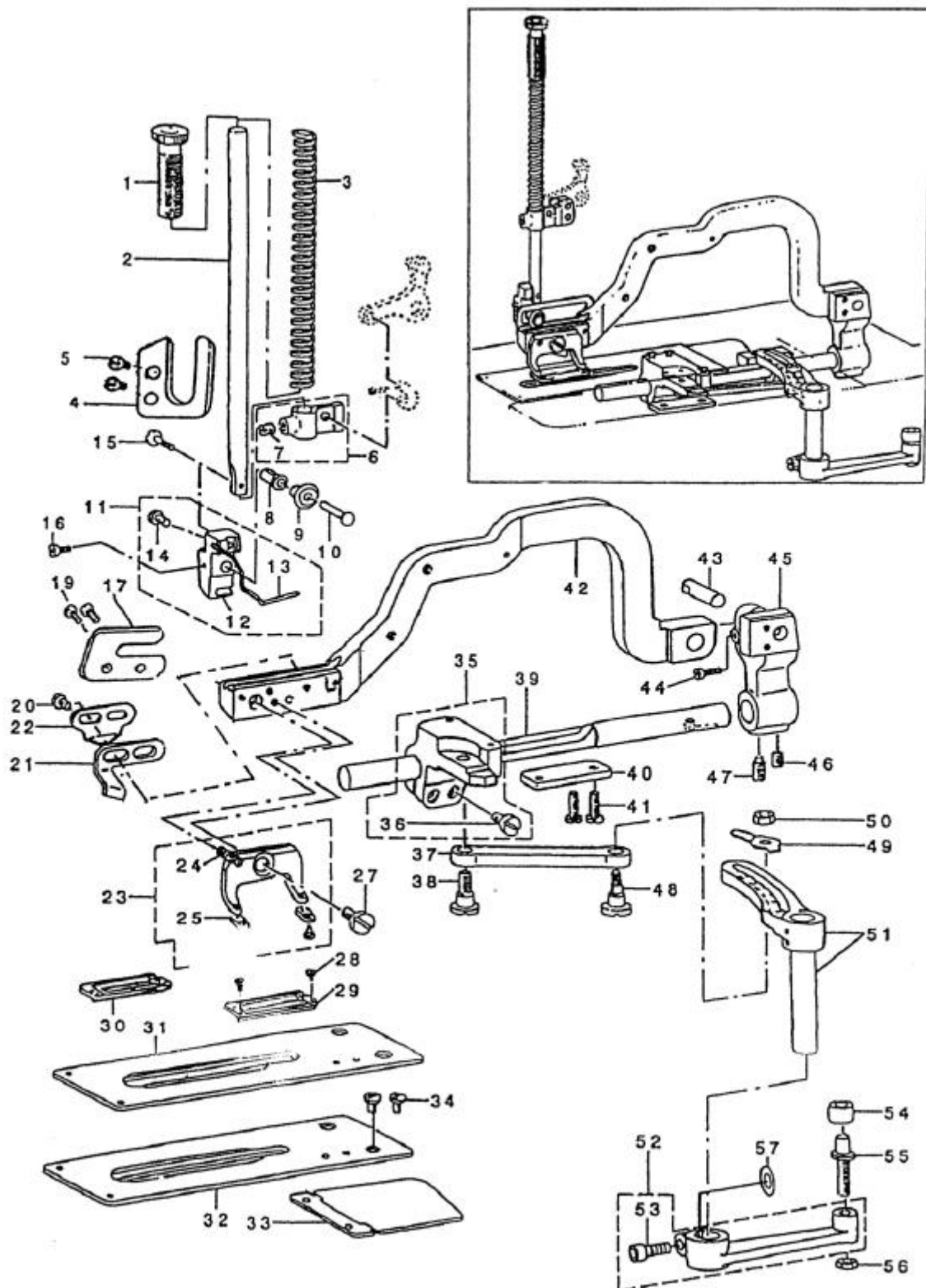
G.6. Hook driving shaft components (1/2)					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
1	SC70-771	BOBBIN CASSE ASM		1	
10	780-10401	BOBBIN		1	
11	B1808-771-0AC	HOOK ASM			
12	780-10402	BOBBIN CASE POSITIONING PLATE			
13	780-10158	SCREW	11/64-40 L=5	2	
14	780-10403	HOOK SLEEVE ASM		1	
15	780-10404	SCREW	¼-40 L=6	4	
16	780-10405	OIL WIOK		1	
17	780-10406	NUT	9/64-40	1	
18	780-10407	ADJUSTING SCREW		1	
19	780-10408	BUSHING ASM FRONT		1	
20	780-10405	OIL WIOK		1	
21	780-10323	SCREW	15/64-28 L=7	3	
22	780A-10409	BEARING BUSH, INTERMEDIATE		1	
23	780A-10410	PINION ASM		1	
24	780-10331	SCREW	¼-40 L=6	2	
25	GB894-76	RETAINING RING	ø12	1	
26	6001	BEARING	28 x 12 x 8	1	
27	780-11117	SCREW	3/16-32 L=5	4	
28	GB/T70. 1-2000	SCREW	M4 x 14	2	
29	GB52-76	NUT	M4	2	
30	780-10631	SCREW	9/64-40 L=8	2	
31	780A-10411	REGULATE A POLE SHELF		1	
32	780A-10412	NUT	5/16-20	1	
33	780A-10413	REGULATE ACCESSORIES		1	
34	780A-10414	CONNECT A POLE, BRING TO THE STRETCH STALK		1	
35	780A-10415	BRING TO THE STRETCH A ROUND		1	
36	6000	BEARING	26 x 10 x 8		
37	GB893-76	RETAINING RING	ø26	1	
38	9-2-185	WASHER	4,8 x 11,5 x 2	1	
39	780-11512	SCREW	3/16-32 L9,5	1	
40	780A-10417	HOOK DRIVING SHAFT SPROCKET		1	
41	GB/T77-2000	SCREW	M6 x 7	2	
42	GB893-76	RETAINING RING	ø32	1	
43	780A-10418	BEARING BUSH, REAR		1	
44	6002	BEARING	32 x 15 x 9	2	
45	GB894-76	RETAINING RING	ø15	1	
46	780-10426	HOOK OIL SUPPLY RUBBER ASM		1	
47	780-10427	BUSHINO		1	

G.7. HOOK DRIVING SHAFT COMPONENTS (2/2)



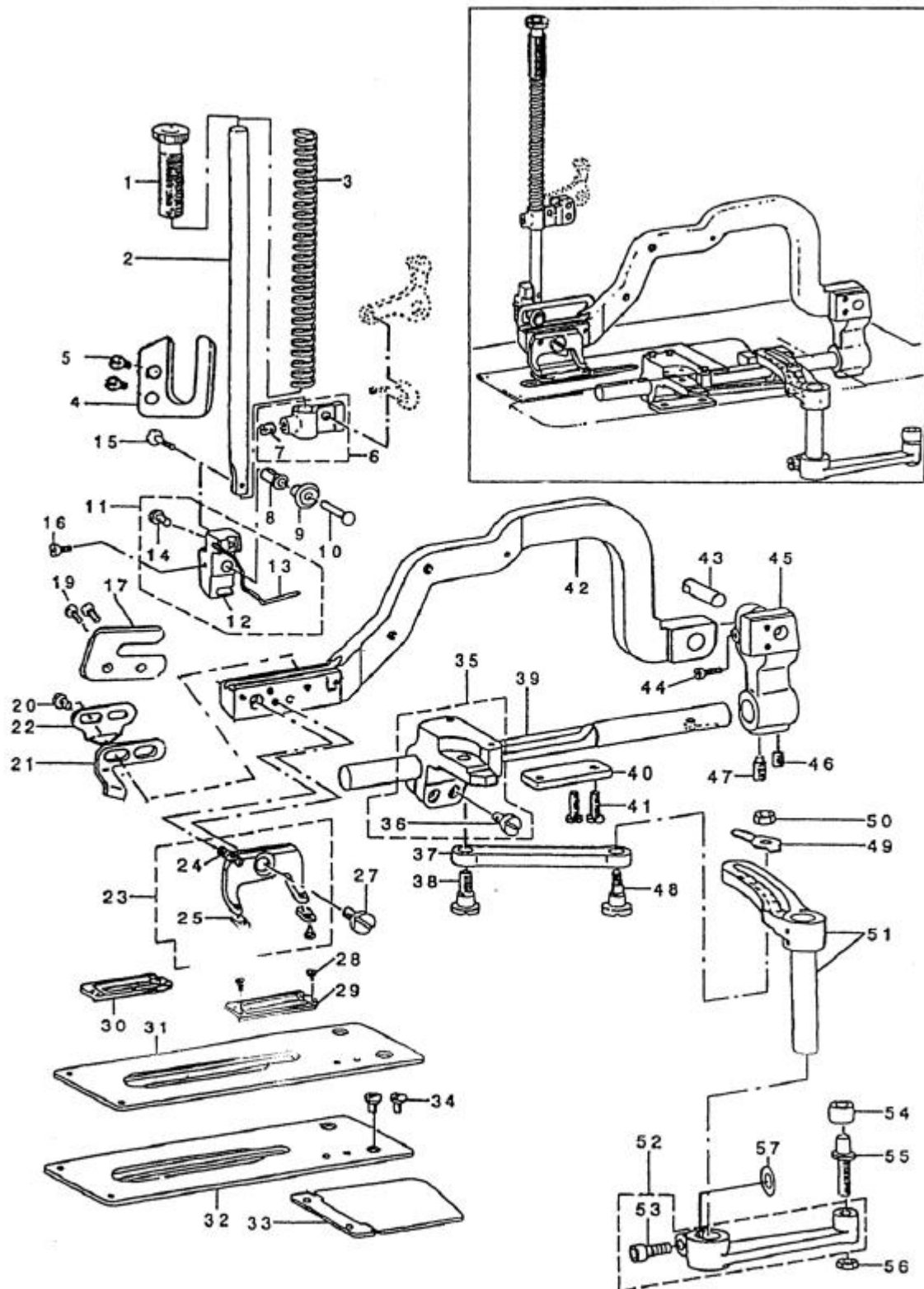
G.7. Hook driving shaft components (2/2)					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
48	780-10428	PLATE SPRING		1	
49	780-10429	HOOK OIL ADJUSTING SCREW		1	
50	780-10430	POSITIONNG SCREW		1	
51	780-10431	OIL SUPPLY FELT HOLDER		1	
52	780-10432	SCREW	15/64-28 L=7	1	
53	780-10434	OIL SUPPLY FELT		1	
54	780A-10435	HOOK DRIVING SHAFT		1	
55	780A-10436	OIL PUMP WORM ASM		1	
56	780A-10437	MAT PIECE		1	
57	780A-10438	BEARING REGULATE NUT, REAR		1	
58	780A-10439	SCREW	9/16-24 L=8	1	
59	780-10111	SCREW	11/64-40 L=5	1	
60	780A-10440	BEARING PEG, REAR		1	
61	780A-10441	BUSIHING BEHIND RING		1	

G.8. PRESSER BAR. WORK CLAMP CARRIER COMPONENTS (1/2)



G.8. Presser bar work clamp carrier components (1/2)					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
1	780-10501	PRESSER SPRING REGULATOR		1	
2	780A-10502	PRESSER BAR		1	
3	780-10503	PRESSER SPRING		1	
4	780A-10504	PRESSER BAR GUIDE BRACKET		1	
5	780-10512	SCREW	9/64-40 L=6,8	2	
6	780A-10506	PRESSER BAR POSITION BRACKET A		1	
7	780-10328	SCREW	1/4-40 L=8	1	
8	780-10507	COLLAR		1	
9	780-10508	SLIDE ROLLER		1	
10	780-10509	CONNECTING PIN		1	
11	780-10510	BRACKET ASM		1	
12	780-10510	BRACKET		1	
13	780-10511	FINGER GUARD		1	
14	780-10512	SCREW	9/64-40 L=6,8	1	
15	780-10513	SCREW	9/64-40 L=15	1	
16	780-10140	SCREW	11/64-40 L=7	1	
17	780A-10514	WORK CLAMP BRACKET		1	
19	780-10631	SCREW	9/64-40 L=8,5	2	
20	780-10516	SCREW	11/64-40 L=7,8	2	
21	780-10517	NEEDLE THREAD TRIMMER GUIDE A		1	
22	780-10518	NEEDLE THREAD TRIMMER GUIDE B		1	
23	780-10519	FORK CLAMP CHECK HOLDER ASM		1	
24	780-10520	WORK CLAMP CHECK HOLDER SPRING		1	
25	780-10521	WORK CLAMP CHECK SPRING		2	
26	780-10522	WORK CLAMP CHECK SPRING SET PI		2	
27	780-10523	HINGE SCREW		1	
28	780-10524	SCREW	3/32-56 L=1,9	2	
29	780-10525	WORK CLAMP CHECK		1	
31	780-10527	WORK CLAMP CARRIER		1	
33	780-10528	BRACKET COVER		1	
34	780-10529	SCREW	11/64-40 L=8	2	
35	780-10530	WORK CLAMP ARM BRACKET ASM		1	
36	780-10531	SCREW	15/64-28 L=14	1	
37	780-10532	YORK CLAMP CARRIER BRACKET PIT		1	
38	780-10533	HINGE SCREW	D=8,73 H=6,0	1	
39	780-10534	WORK CLAMP ARM SLIDE ROD		1	
40	780-10535	WORK CLAMP CARTER BRACKET GUID		1	
41	780-10536	SCREW	11/64-40 L=9,5	2	
42	780A-10537	WORK CLAMP			

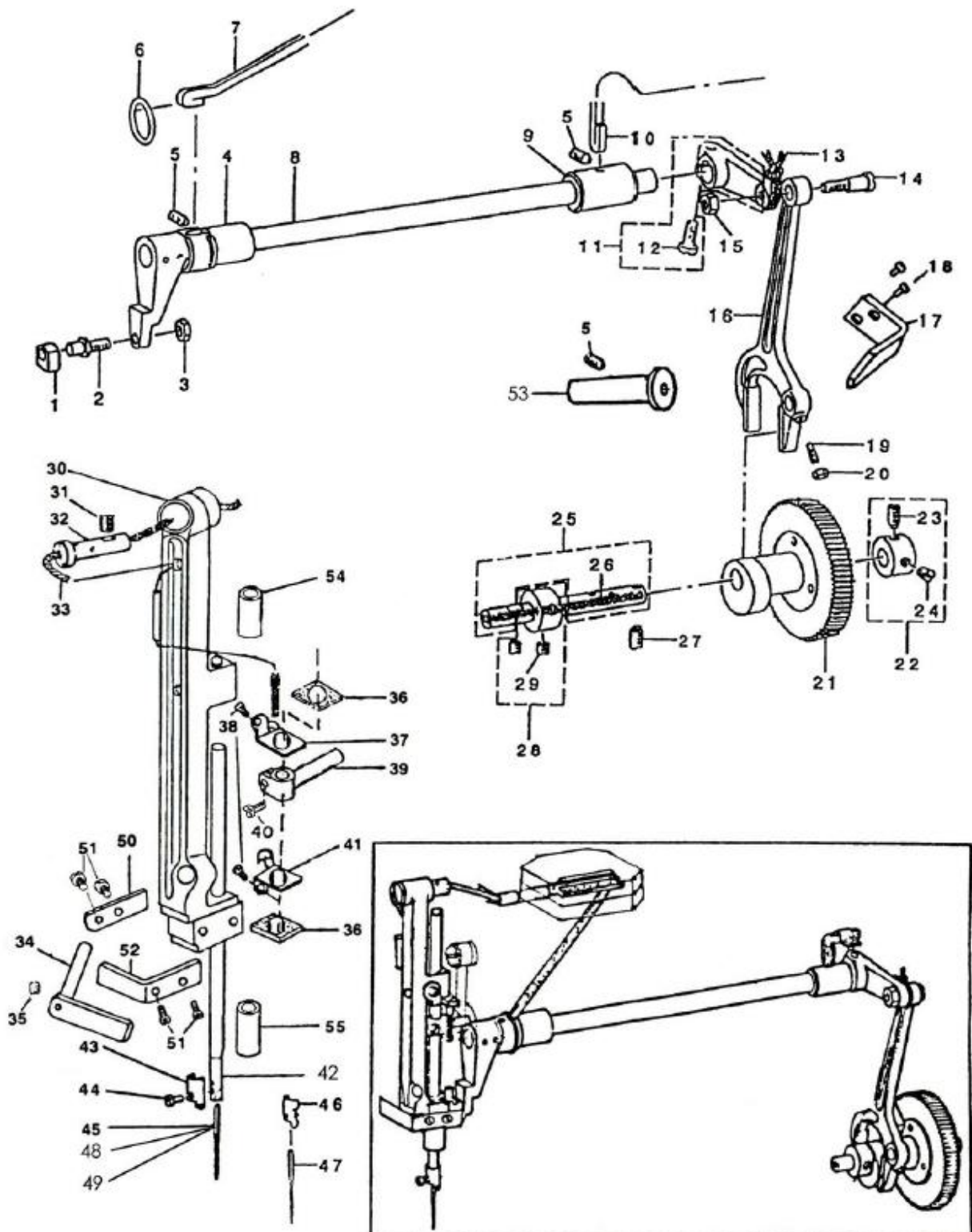
G.9. PRESSER BAR. WORK CLAMP CARRIER COMPONENTS (2/2)



G.9. Presser bar work clamp carrier components (2/2)

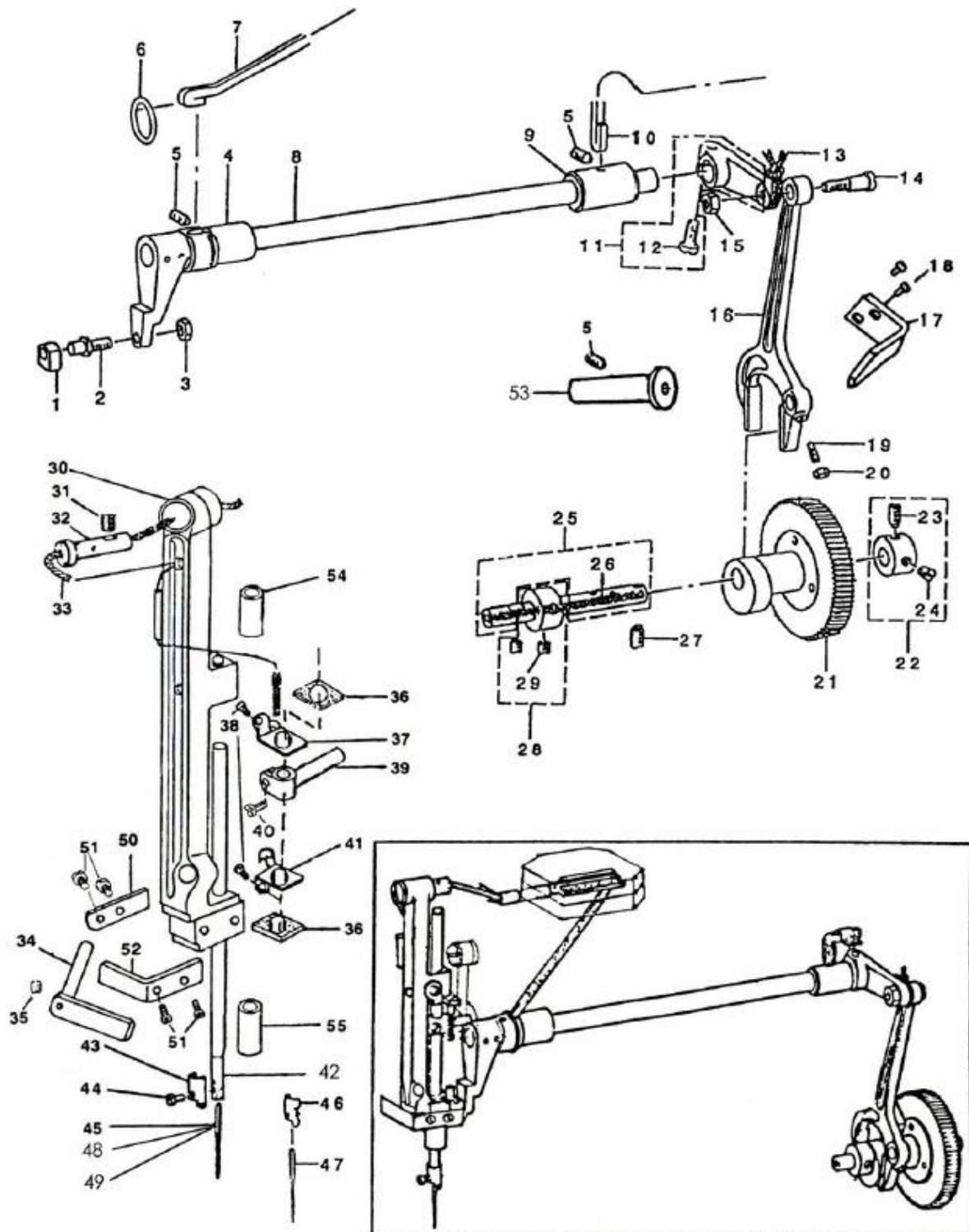
Ref. No	Parts No.	Name of parts	Description	Qty	Note
43	780-10538	CONNECTING PIN		1	
44	780-10539	SCREW		1	
45	780-10540	BEARING ARM		1	
46	780-10323	SCREW	15/64-28 L=7	1	
47	780-10541	SET-SCREW		1	
48	780-10542	LENGTH REGULATING HINGE STUD		1	
49	780-10543	LENGTH REGULATING SHAFT GUIDE		1	
50	780-10544	NUT	15/64-28	1	
51	780-10545	LENGTH REGULATING SCALE ASM		1	
52	780-10546	CLOTH FEED ARM ASM		1	
53	GB70-76	SCREW	M6 L=16	1	
54	780A-10547	ROLLER		1	
55	780-10548	BELL CRANK ROLLER STUD		1	
56	780-10544	NUT	15/64-28	1	
57	780-10549	WASHER	6,5 x 13 x 0,8	1	

G.10. NEEDLE BAR FRAME COMPONENTS (1/2)



G.10. Needle bar frame components (1/2)					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
1	780A-10601	SQUARE BLOCK		1	
2	780A-10602	STUD		1	
3	780-10544	NUT	15/64-28	1	
4	780A-10603	BUSHING		1	
5	780-10302	SCREW	15/64-28 L=10,5	3	
6	6GB1235-76	RUBBER RING		1	
7	780-10605	OIL WICK		1	
8	780A-10606	FRAME ROCK SHAFT CRANK		1	
9	780-10607	BUSHING REAR		1	
10	780-10608	OIL FELT		1	
11	780A-10609	FRAME ROCK SHAFT CRANK ASM R		1	
12	780-10610	SCREW	15/64-28 L=12	1	
13	780-10611	OIL WICK		1	
14	780-10612	HINGE SCREW	D=7,94	1	
15	780-10613	NUT	1/4-24	1	
16	780-10614	NEEDLE BAR PITMAN		1	
17	780A-10615	ROCK SHAFT CONNECTION GUIDE		1	
18	780A-10616	SCREW	9/64-40 L=8,5	1	
19	780-10617	SCREW	11/64-40 L=12	1	
20	780-10211	NUT	11/64-40	1	
21	780-10618	NEEDLE DRIVING GEAR ASM		1	
22	780-10619	THRUST COLLAR ASM	D=9,53	1	
23	780-10541	SET-SCREW		1	
24	780-10323	SCREW	15/64-28 L=7	1	
25	780-10620	KNIFE DRIVING SHAFT ASM		1	
26	780-10621	OIL WICK		/	
27	780-10541	SET-SCREW		/	
28	780-10619	THRUST COLLAR ASM	D=9,53	/	
29	780-10323	SCREW	15/64-28 L=7	1	
30	780A-10622	NEEDLE BAR FRAME		1	
31	5-41-185	SCREW	15/64-28 L=8	1	
32	780A-10624	HINGE STUD		1	
33	780-10611	OIL WICK		1	
34	780A-10625	POSITION BRACKET		1	
35	780-11116	SCREW	15/64-28 L=4,7	1	
36	780-10626	OIL FELT		1	
37	780A-10627	ROCK SHAFT CONNECTION GUIDE		1	
38	780-10628	SCREW	9/64-40 L=4,5	1	
39	780A-10629	NEEDLE BAR CONNECTION		1	

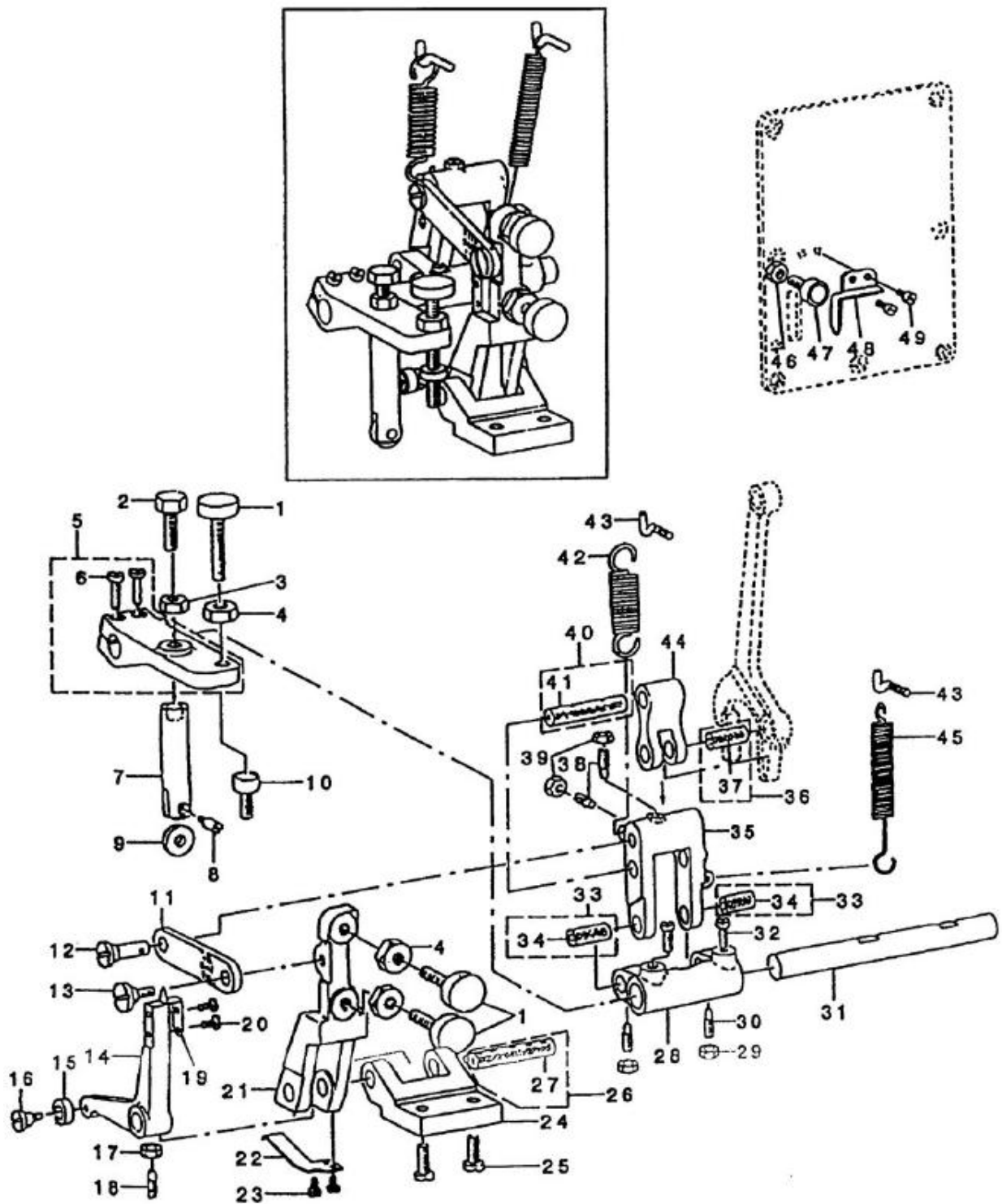
G.11. NEEDLE BAR FRAME COMPONENTS (2/2)



G.11. Needle bar frame components (2/2)

Ref. No	Parts No.	Name of parts	Description	Qty	Note
40	780-10631	SCREW	9/64-40 L=8,5	1	
41	780A-10632	OIL FELT RETAINER LOWER		2	
42	780-10633	NEEDLE BAR		1	
43	780-10634	NEEDLE BAR BOBBIN THREAD GUIDE		1	
44	780-10635	SCREW	1/8-44 L=4,5	1	
45	DPX5	NEEDLE DPX5	Nm.75/11	1	
46	780-10636	NEEDLE BAR BOBBIN THREAD GUIDE		1	
47	134SES	NEEDLE 134SES	Nm.75/11	1	
48	DPX5	NEEDLE DPX5	Nm.90/14	1	
49	134	NEEDLE 134	Nm.75/11	1	
50	780A-10637	LEFT STATOR		1	
51	780-10512	SCREW	9/64-40 L=6,8	4	
52	780A-10638	RIGHT STATOR		1	
53	780A-10639	AXIS		1	
54	780A-10640	NEEDLE BAR BUSH (HIGH)		1	
55	780A-10641	NEEDLE BAR BUSH (LOW)		1	

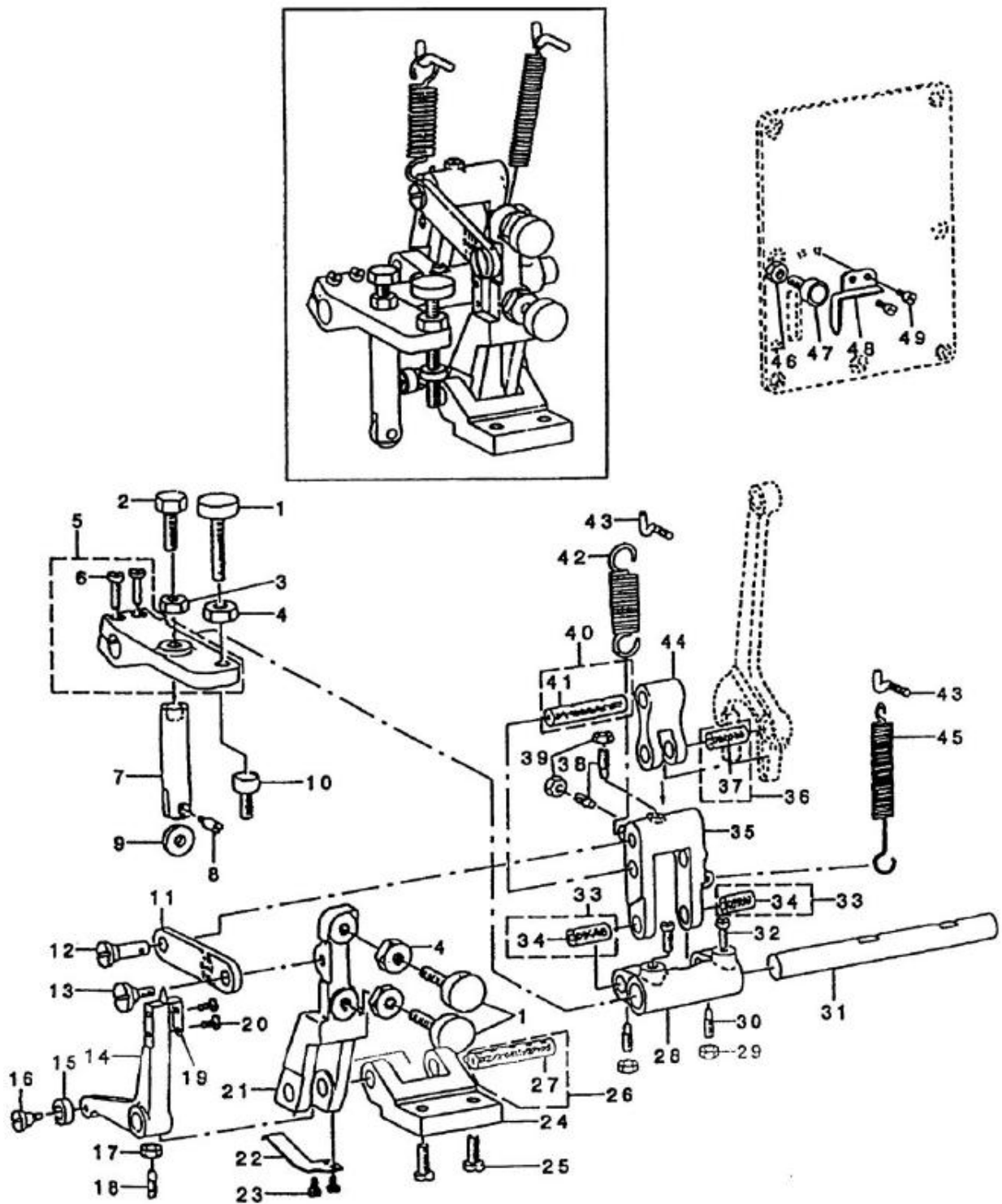
G.12. OVEREDGING WIDTH ADJUSTING COMPONENTS (1/2)



G.12. Overedging width adjusting components (1/2)

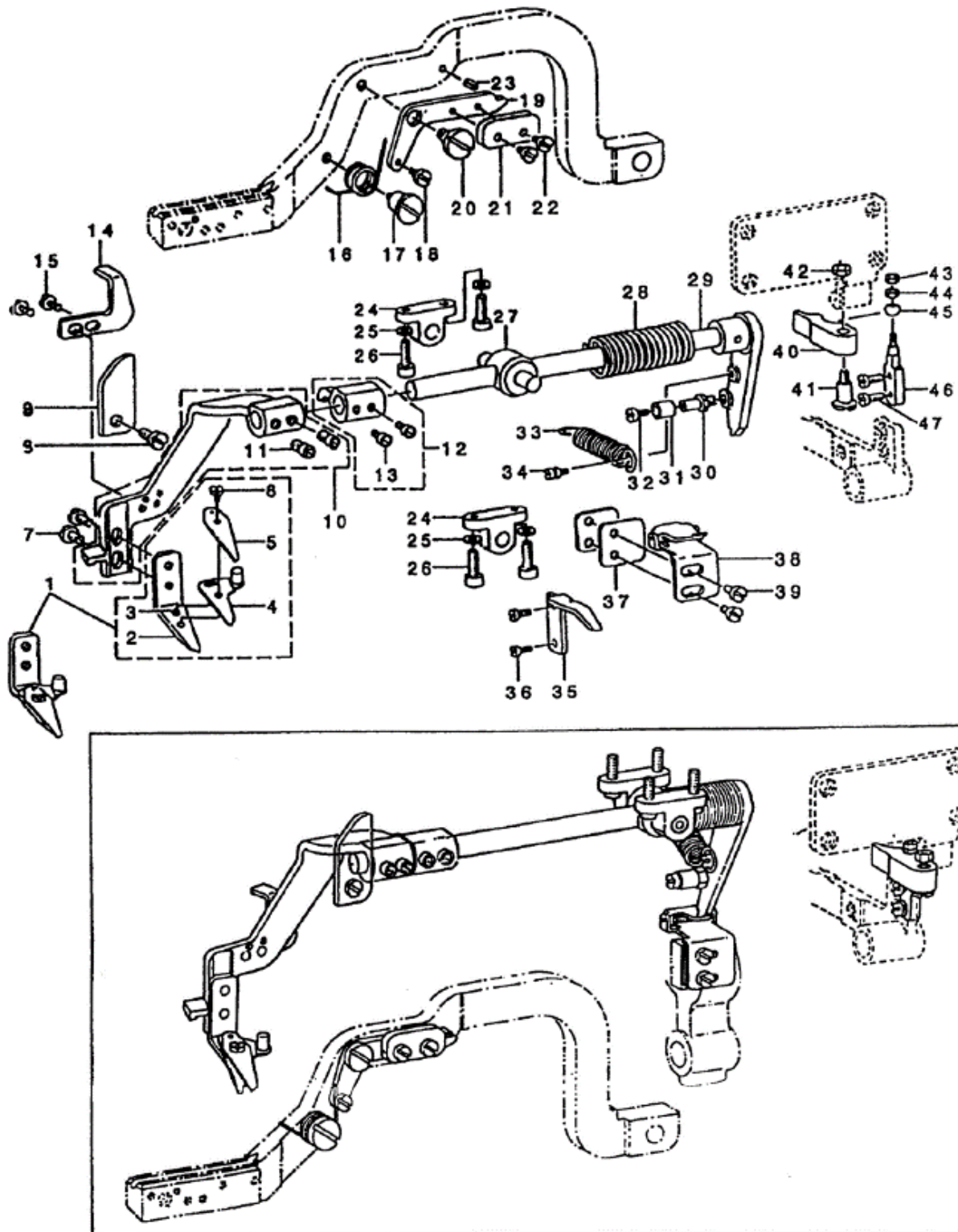
Ref. No	Parts No.	Name of parts	Description	Qty	Note
1	780-10701	STICH WIDTH REGULATING SCREW		3	
2	780-10733	SCREW	M8 L=20	1	
3	780-10732	NUT	M8	1	
4	GB41-76	WU BS		3	
5	780-10702	REPOSITIONING LEVER ASM		1	
6	780-10703	SCREW	3/16-28 L=12	2	
7	780-10704	TRIPPING ROD ASM		1	
8	780-10705	PIN		1	
9	780-10706	ROLLER		1	
10	780-10707	REGULATING LEVER STOPPER AS		1	
11	780-10708	REGULATING LEVER CONNECTION		1	
12	780-10709	REGULATING HINGE PIN		1	
13	780-10710	HINGE SCREW	D=7,94 H=4,3	1	
14	780-10711	BELL CRANK		1	
15	780-10712	ROLLER		1	
16	780-10713	HINGE SCREW	D=6,35 H=4,7	1	
17	780-10211	NUT	11/64-40	1	
18	780-10617	SCREW	11/64-40 L=12	1	
19	780-10714	BARRED WIDTH INDICATOR		1	
20	780-10635	SCREW	1/8-44 L=4,5	2	
21	780-10715	REGULATING LEVER		1	
22	7380-10716	ISPRING		1	
23	780-10635	SCREW	1/8-44 L=4,5	2	
24	780-10717	REGULATING LEVER BRACKET		1	
25	780-10610	SCREW	15/64-28 L=12	2	
26	780-10718	REGULATING LEVER SHAFT ASM		1	
27	780-10736	OIL WICK		1	
28	780-10719	BEARING BRACKET		1	
29	780-10211	NUT	11/64-40	1	
30	780-10617	SCREW	11/64-40 L=12	1	
31	780-10720	NEEDLE THROW REPOSITIONING SHA		1	
32	780-10721	SCREW	15/64-28 L=9	2	
33	780-10722	BEARING BRACKET ASM		2	
34	780-10737	OIL WICK		2	
35	780-10723	REPOSITIONING LIVER LINK		1	
36	780-10724	CONNECTING FORKED LINK PIN ASM		1	
37	780-10734	OIL WICK		1	
38	780-10617	SCREW	11/64-40 L=12	2	
39	780-10211	NUT	11/64-40	2	

G.13. OVEREDGING WIDTH ADJUSTING COMPONENTS (2/2)



G.13. Overedging width adjusting components (2/2)					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
40	780-10725	CONNECTING STUD ASM		1	
41	780-10735	OIL WICK		1	
42	780-10726	SPRING		1	
43	780-10727	SUSPENSION SCREW		2	
44	780-10728	CONNECTING FORKED LINK		1	
45	780-10729	SPRING		1	
46	780-10544	NUT	15/64-28	1	
47	780-10707	REGULATING LEVER STOPPER ASM		1	
48	780-10731	SEAM WIDTH INDICATOR		1	
49	780-10635	SCREW	1/8-44 L=4,5	2	

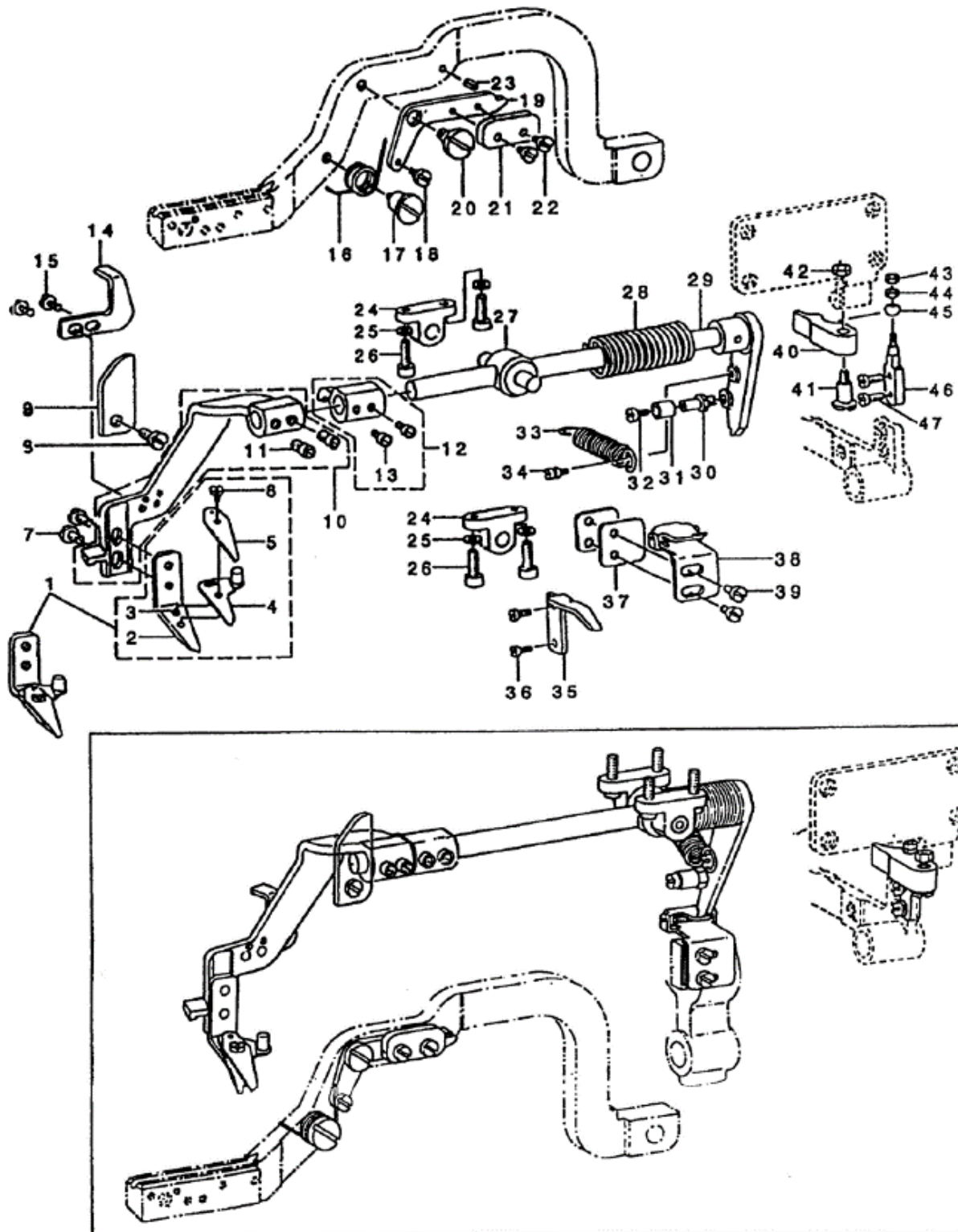
G.14. NEEDLE THREAD TRIMER COMPONENTS (1/2)



G.14. Needle thread trimer components (1/2)

Ref. No	Parts No.	Name of parts	Description	Qty	Note
1	780-10801	NEEDLE THREAD TRIMMER ASM		1	
2	780-10802	NEEDLE THREAD TRIMMER, LOWE		1	
3	780-10803	POSITION PIN		1	
4	780-10804	NEEDLE THREAD TRIMMER. UPPEH		1	
5	780-10805	NEEDLE THREAD PRESSER SPRNG		1	
6	780-10806	HINGE SCREW	D=4 H=1,8	1	
7	780-10158	SCREW	11/64-40 L=5	2	
8	7830-10807	NEEDLE THREAD TRIMMER SHAFT		1	
9	780-10808	SCREW	15/64-28 L=7	1	
10	780A-10809	THREAD TRIMMER HOLDER ASM		1	
11	GB-T78-1985	SCREW	M6 L=10	2	
12	780-10811	DIFFERENTIAL HOLDER ASM		1	
13	GB-T78-1985	SCREW	M6 L=10	2	
14	780A-10812	LIMITING PLATE		1	
15	780-10516	SCREW	11/64-40 L=7,8	2	
16	780-10813	DRIVING CAM SPRING		1	
17	780-10814	DRIVING CAM SPRING AXLE		1	
18	780-10815	HINGE SCREW	D=4,5 H=4	1	
19	780-10816	DRIVING CAM INSTALLING PLATE		1	
20	780-10817	HINGE SCREW	D=7,94 H=3,0	1	
21	780-10818	DRIVING CAM		2	
22	780-10512	SCREW	9/64-40 L=6,8	2	
23	GB/T879-1986	SPRING PIN	3,0 x 10	1	
24	780-10819	BRACKET		1	
25	780-10820	SPRING WASHER	5,2 x 8,2 x 1	4	
26	780-10821	SCREW	3/16-32 L=12,0	4	
27	780-10822	UNIVERSAL JOINT		1	
28	780-10823	THREAD TRIMMER SPRING B		1	
29	780-10824	NEEDLE THREAD TRIMMER SHAFT		1	
30	780-10825	STUD		1	
31	780-10826	CAM ROLL		1	
32	780-10827	SCREW	1/8-44 L=6	1	
33	780-10828	THREAD TRIMMER SPRING A		1	
34	780-10829	SUSPENSION SCREW		1	
35	780-10830	LATCH PRESSER ARM		1	
36	780-10512	SCREW	9/64-40 L=6,8	2	
37	780-10831	SPACER		1	
38	780-10832	LOCKING BRACKET LATCH ASM		1	
39	780-10516	SCREW	11/64-40 L=7,8	2	

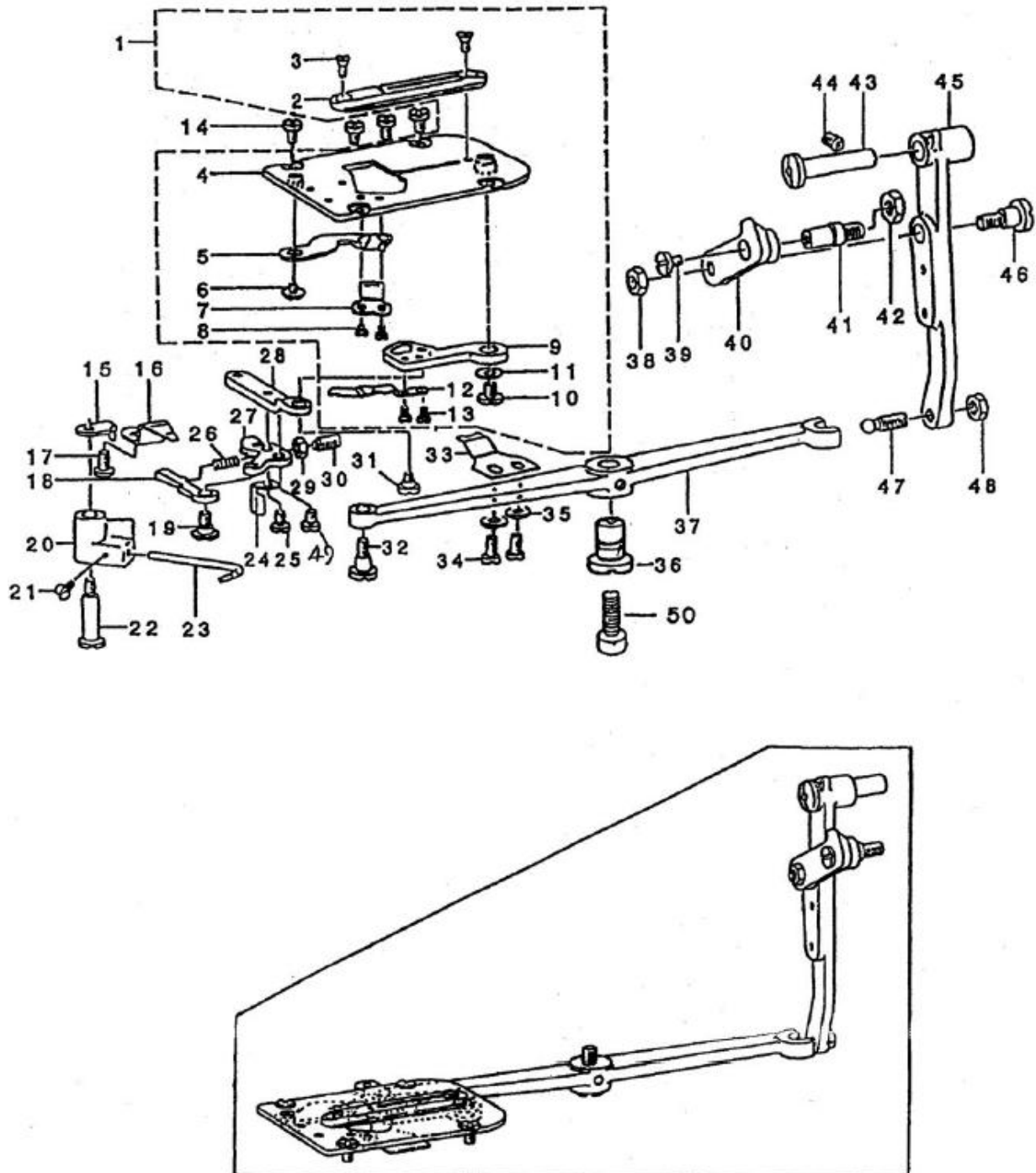
G.15. NEEDLE THREAD TRIMER COMPONENTS (2/2)



G.15. Needle thread trimmer components (2/2)

Ref. No	Parts No.	Name of parts	Description	Qty	Note
40	780-10833	THREAD TRIMMING SHAFT SEGMENT		1	
41	780-10834	HINGE SCREW	D=6,35 H=10	1	
42	7380-10211	NUT	11/64-40	1	
43	780-10836	NUT	1/8-44	1	
44	780-10835	NUT	1/8-44	1	
45	780-10837	ROLLER		1	
46	780-10838	STUD		1	
47	780-10516	SCREW	11/64-40 L=7,8	2	

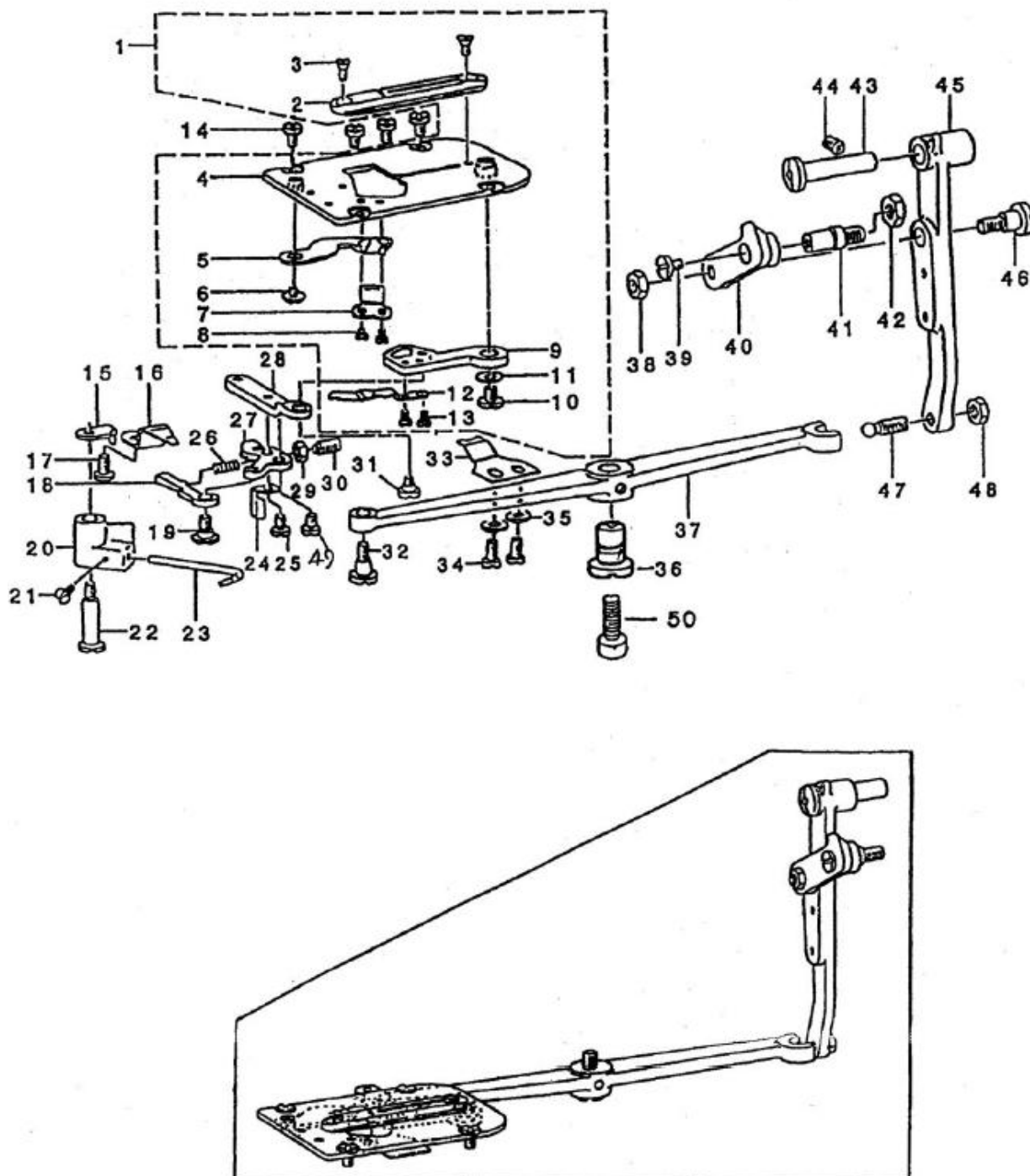
G.16. BOBBIN THREAD TRIMER COMPONENTS (1/2)



G.16. Bobbin thread trimer components (1/2)

Ref. No	Parts No.	Name of parts	Description	Qty	Note
1	780-10901	NEEDLE PLATE ASM		1	
2	780-10902	NEEDLE PLATE		1	
3	780-10903	SCREW	9/64-40 L=5	2	
4	780-10904	THROAT PLATE BASE ASM		1	
5	780-10905	BOBBIN TIREAD TRIMMER BLADE		1	
6	780-10906	SCREW	9/64 40 L=3.2	1	
7	780-10907	COUNTER KNIFE		1	
8	780-10908	SCREW	1/8-44 L=3,4	2	
9	780-10909	BOBBIN THREAD TRIMMER LEVER		1	
10	780-10910	SCREW	11/64-40 L=4,8	1	
11	780-10911	MASHER	4,0 x 20 x 1	1	
12	780-10912	BOBBIN THREAD PULLER		1	
13	780-10913	SCREW	9/64-40 L=4	2	
14	780-10914	SCREW	9/64-40 L=6	4	
15	780-10915	HOOK THREAD PRESSER STOPPER		1	
16	780-10916	PRESSER PLATE		1	
17	780-10516	SCREW	11/64-40 L=7,8	1	
18	780-10917	BOBBIN PICKER PRESSER PLATE]		1	
19	780-10918	HINGE SCREW		1	
20	780-10919	BOBBIN PICKER BRACKET		1	
21	780-10920	SCREW	9/64-40 L=6,1	1	
22	780-10921	BOBBIN PICKER BRACKET SHAFT		1	
23	780-10922	BOBBIN WINDER TRIP LATCH		1	
24	780-10923	SAFETY STOPPE		1	
25	780-10924	SCREW	11/64-40 L=6	1	
26	780-10925	PRESSER PLATE ADJUSTING SPRING		1	
27	780-10926	PRESSER PLATE MOUNTING BASE		1	
28	780-10927	BOBBIN THREAD TRIMMER LINK		1	
29	780-10928	NUT	3/16-28	1	
30	780-10929	RRESSER PLATE ADJUSTING SCREW		1	
31	780-10930	INGE SCREW	D=6,35 1=3,2	1	
32	780-10931	IHINGE SCREW	D=6,35 H=6	1	
33	780-10932	BOBBIN THREAD GUIDE		1	
34	780-10933	SCREW	9/64-40 L=5,0	2	
35	780-10108	WASHER	4,5 x 8 x 0,5	2	
36	780A-10934	LACK OF IMPARTIALITY THE SET		1	
37	780A-10935	BOBBIN THREAD TRIVMER DRIVING		1	
38	780-10544	NUT	15/64-28	1	
39	780-10936	SCREW	11/64-40 L=4,8	1	

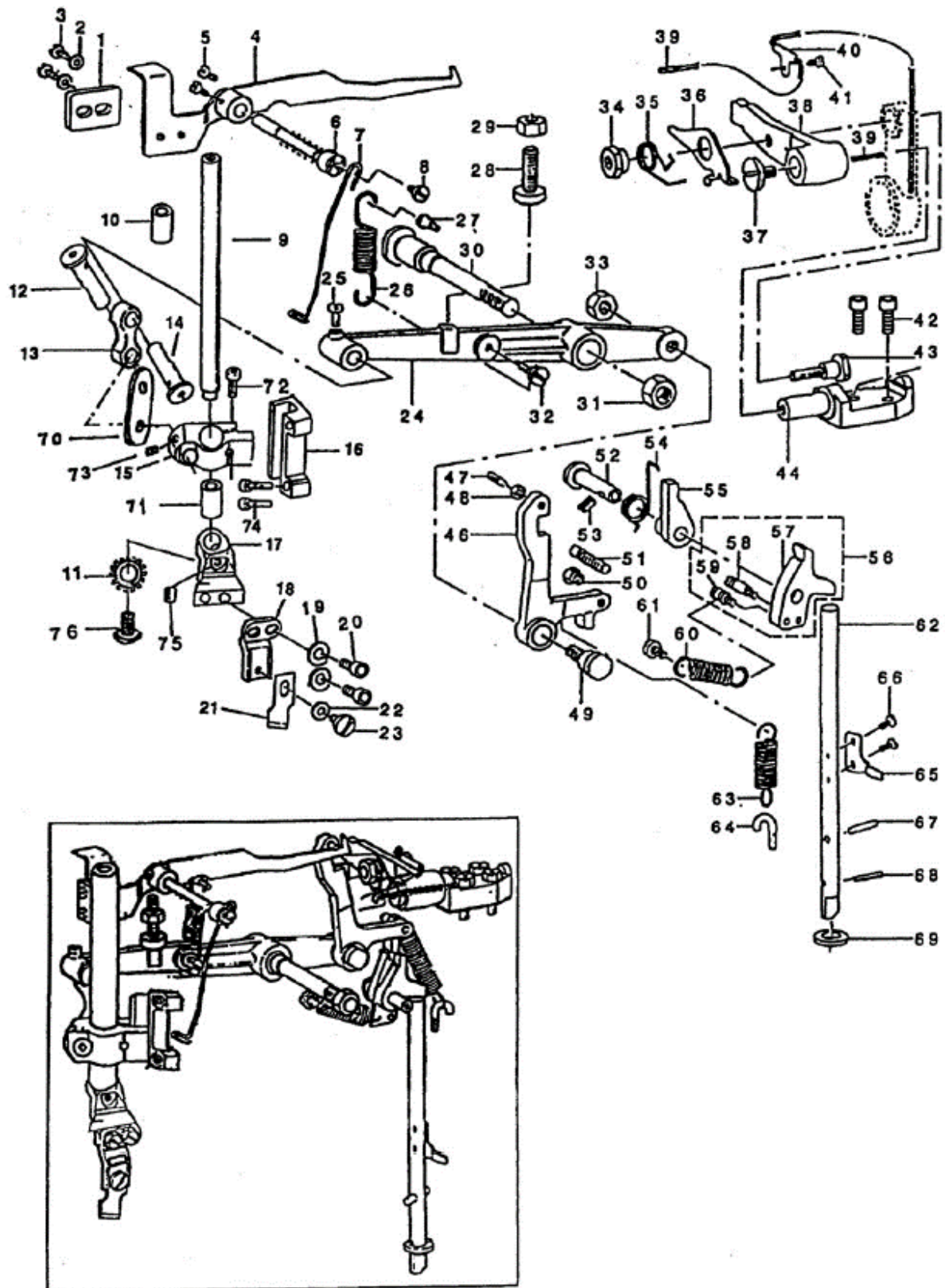
G.17. BOBBIN THREAD TRIMER COMPONENTS (2/2)



G.17. Needle thread trimmer components (2/2)

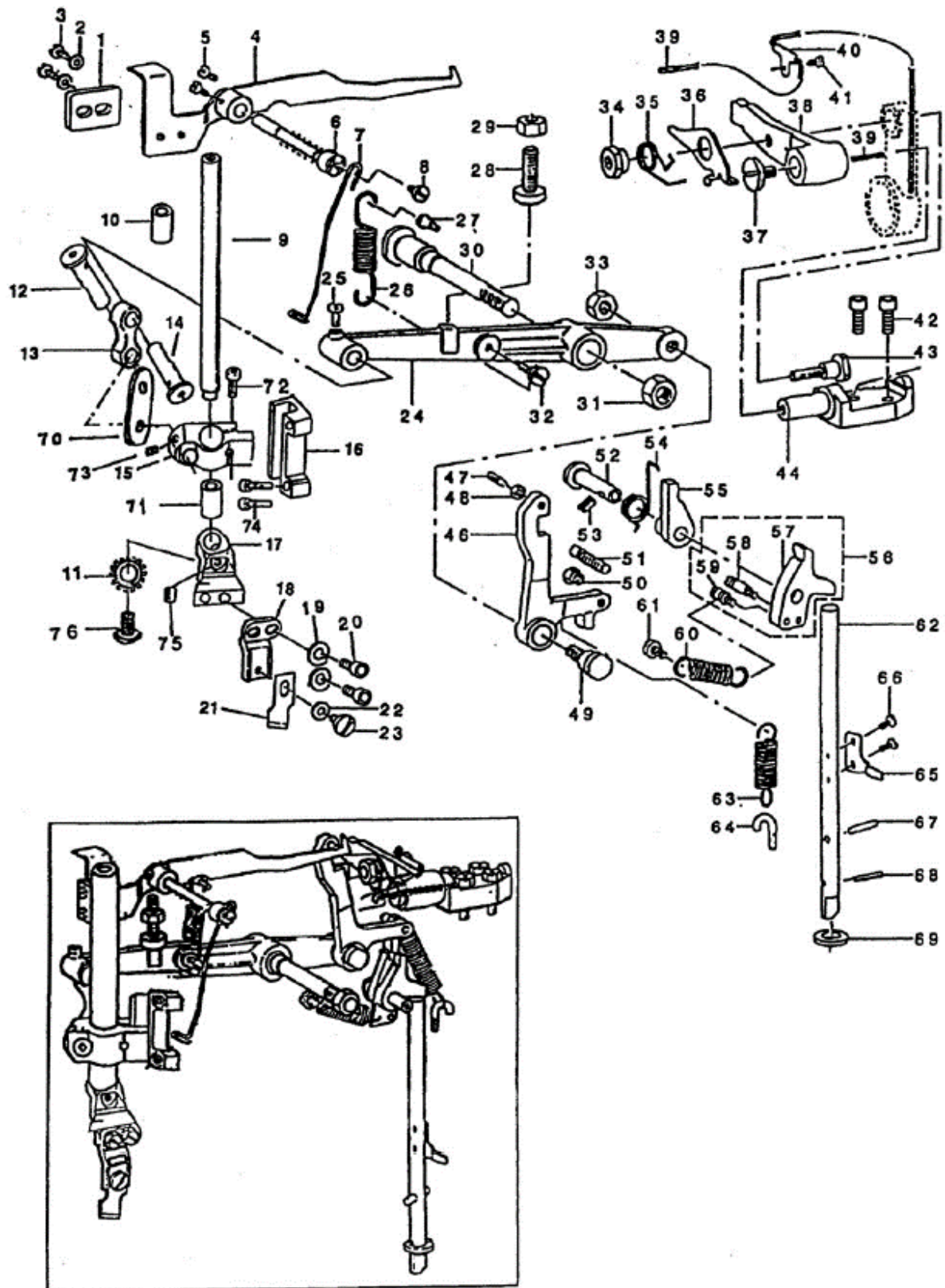
Ref. No	Parts No.	Name of parts	Description	Qty	Note
40	780-10937	CONNECTING LINK		1	
41	780-10938	STOP SCREW		1	
42	780-10939	NUT	9/32-28	1	
43	780-10940	HING STUD		1	
44	780-10323	SCREW	15/64-28 L=7	1	
45	780-10941	BOBBIN THREAD TRIMMER DRIVING		1	
46	780-10942	HINGE SCREW	D=7,94 H=6,4	1	
47	780-10943	BALL SCREW		1	
48	780-10544	NUT	15/64-28	1	
49	780-10203	SCREW	11/64-40 L=7	1	
50	780A-10944	SCREW		1	

G.18. KNIFE BAR COMPONENTS (1/2)



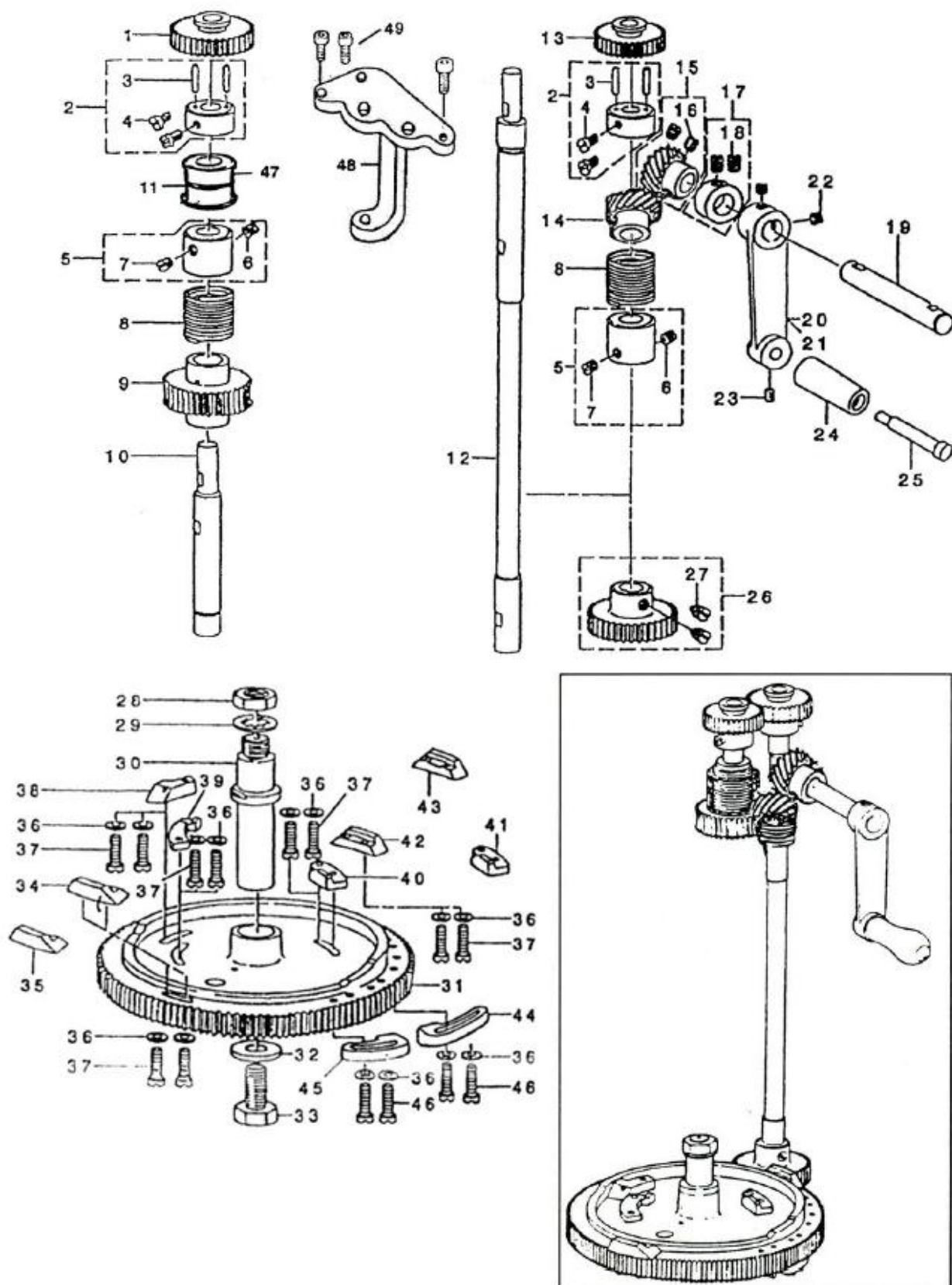
G.18. Knife bar components (1/2)					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
1	780-11001	KNIFE STOP LEVER BRACKET		1	
2	780-11002	WASHER	4,8 x 8 x 0,8	2	
3	780-10516	SCREW	11/64-40 L=7,8	2	
4	780-11004	KNIFE STOP LEVER		1	
5	780-11005	SCREW	11/64-40 L=4,8	2	
6	780-11006	KNIFE STOP LEVER HINGE STUD		1	
7	780-11007	THREAD CHECK WIRE		1	
8	780-10516	SCREW	11/64-40 L=7,8	1	
9	780A-11008	KNIFE BAR		1	
10	780A-11009	KNIFE BAR SET		1	
11	GB/T862. 1-1987	LOCK TIGHT WASHER	ø6	1	
12	780A-11010	SELL THE STALK		1	
13	780A-11011	KNIFE BAR CONNECTING LINK		1	
14	780A-11012	SELL THE STALK		1	
15	780A-11013	KNIFE STUD RETAINER (B)		1	
16	780A-11014	KNIFE BAR DIRECTION		1	
17	780A-11058	KNIFE BAR HOLDER		2	
18	780-11015	KNIFE HOLDER		1	
19	GB 93-76	SPRING WASHER	6,5 x 11 x 1,3	2	
20	GB 70-76	SCREW	M6 L=12	2	
21	780-11016	KNIFE	½"	1	
22	780-11017	WASHER	5 x 10,5 x 1	1	
23	780-11018	SCREW	3/16-32 L=6,5	1	
24	780A-11019	KNIFE BAR DRIVING LEVER		1	
25	780-11020	SCREW	11/64-40 L=8	1	
26	780-11021	SPRING		1	
27	780-11022	HINGE SCREW	D=5,5 H=5	1	
28	780-11023	KNIFE BAR DRIVING LEVER		1	
29	780-11024	NUT	5/16-18	1	
30	780-11025	KNIFE BAR DRIVING LEVER SIHAFT		1	
31	780-11026	NUT	3/8-28	1	
32	780-11027	HINGE SCREW	D=7,9 H=2,0	1	
33	780-11028	NUT	5/16-24	1	
34	780-11029	KNIFE BAR DRIVING CRANK NUT		1	
35	780-11030	TENSION SPRING		1	
36	780-11031	LATCH		1	
37	780-11032	SCREW	1/4-24 L=9,5	1	
38	780-11033	KNIFE BAR DRIVING CRANK		1	
39	780-11041	OIL WICK		1	

G.19. KNIFE BAR COMPONENTS (2/2)



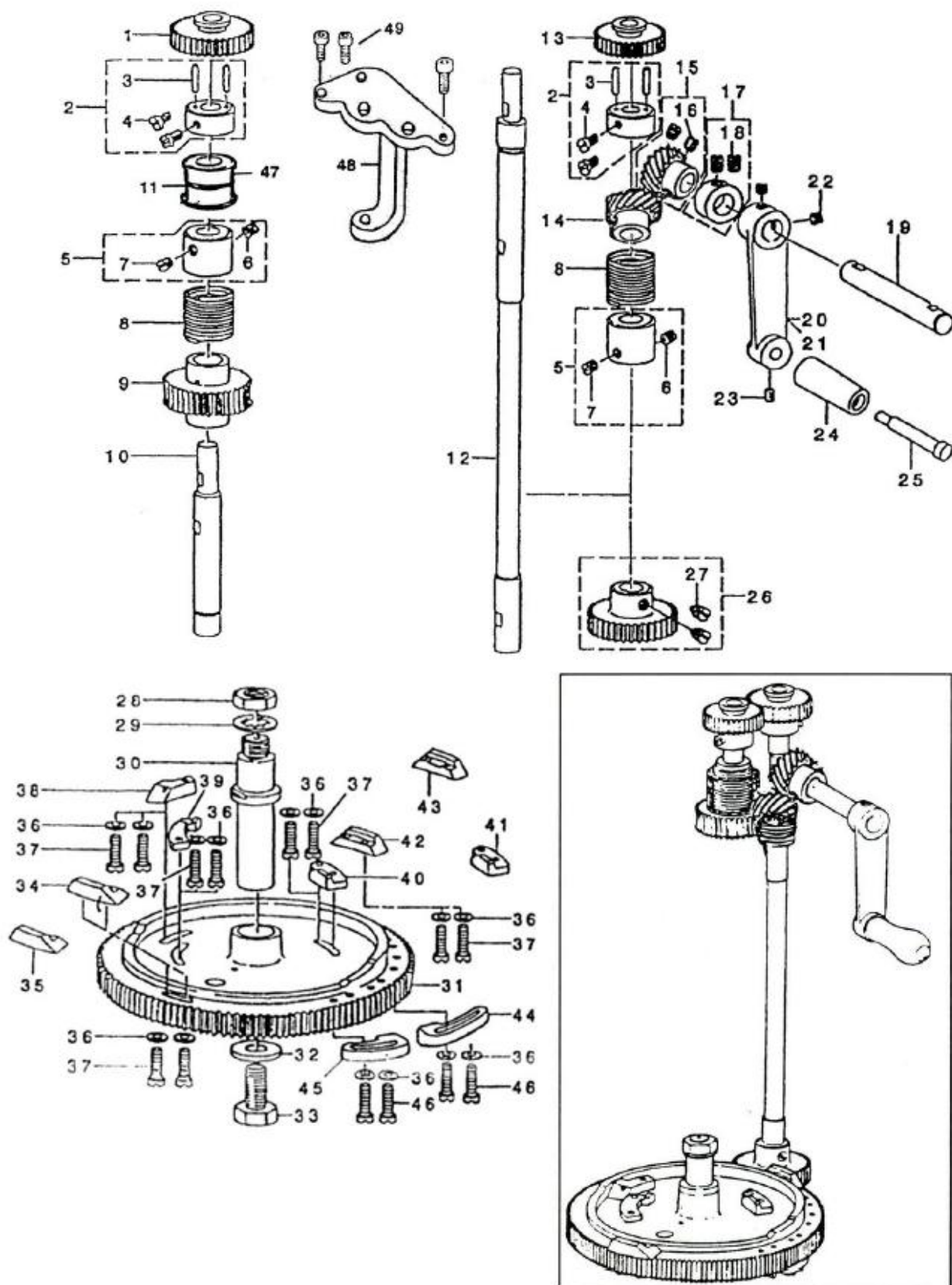
G.19. Knife bar components (2/2)					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
40	780-11034	OIL WICK HOLDER		1	
41	780-10123	SCREW	9/64-40 L=6	1	
42	GB 70-76	SCREW	M6 L=20	2	
43	780-11036	HINGE SCREW	D=11,11 H=9,0	1	
44	780A-11037	KNIFE BAR DRIVING CRANK SHAFT		1	
46	780-11039	KNIFE BAR DRIVING LEVER BELL		1	
47	780-11040	SCREW	11/64-40 L=15,5	1	
48	780-10211	NUT	11/64-40	1	
49	780-11036	HINGE SCREW	D=11,11 H=9,0	1	
50	780-11042	NUT		1	
51	780-11043	PIN		1	
52	780-10940	HING STUD		1	
53	780-10323	SCREW	15/64-28 L=7	1	
54	780-11045	TENSION SPRING		1	
55	780-11046	RATCHET PAWL (B)		1	
56	780-11047	HOOK DIFFERENTIAL CLICK A ASM		1	
57	780-11048	HOOK DIFFERENTIAL CLICK A		1	
58	780-11049	SPRING SUSPENSION		1	
59	780-11050	THREAD CUTTING LINK SPRING		1	
60	780-11051	TENSION SPRING		1	
61	780-11052	HTNGE SCREW	D=5,30 H=2,2	1	
62	780-11053	DRIVING ROD		1	
63	780-11054	TENSION SPRING		1	
64	780-11055	SUSPENSION SCREW		1	
65	780-11056	FINGER		1	
66	780-10512	SCREW	9/64-40 L=6,8	2	
67	GB 119-76	POSITIONING PIN (B)		1	
68	GB 879-76	SPRING PIN	3 x 18	1	
69	780-11057	THRUST WASHER		1	
70	780A-11059	DEFEND OIL PLANK		1	
71	780A-11160A	KNIFE BAR NEXT		1	
72	780A-11061A	SCREW	3/16-32 L=9	1	
73	780-10824.3	SCREW	3/16-32 L=6,2	1	
74	780A-11063A	SCREW	11/64-40 L=18	2	
75	185-5/31-YD6150850	SCREW	15/64-28 L=8	1	
76	780A-11065A	SCREW	15/64-28 L=15	1	

G.20. FEED CAM & TRIOING SEGMENT COMPONENTS (1/2)



G.20. Feed cam & tripping segment components (1/2)					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
1	780-11128	SPUR GEAR (152)		1	
2	780-11101	SPUR GEAR BUSHING ASM		2	
3	780-11102	SPUR GEAR BUSHING PIN		4	
4	780A-11103	SCREW	3/16-28 L=6	4	
5	780A-11104	CLUTCH COLLAR ASM		2	
6	780A-11105	SCREW	15/64-28 L=5	2	
7	780A-11105	SCREW	15/64-28 L=5	2	
8	780-11106	CLUTCH SPRING		2	
9	780A-11107	FEED CAM DRIVING WORM WHEEL		1	
10	780A-11108	FEED CAM DRIVING WORM WHEEL SH		1	
11	7380-11109	OIL FELT		1	
12	780A-11110	FEED CAM DRIVING SHAFT		1	
13	780-12127	SPUR GEAR (123)		1	
14	780A-11111	SPIRAL WHEEL GEAR (BOOTOM)		1	
15	780A-11112	SPIRAL WHEEL GEAR (TOP)		1	
16	780A-11105	SCREW	15/64-28 L=5	2	
17	780-11113	THRUST COLLAR ASM	D=11,11 W=1	1	
18	780-10333	SCREW	1/4-40 L=4,5	2	
19	780A-11114	HANDLE CRANK SHAFT		1	
20	780-11115	HANDLE CRANK		1	
22	780-11116	SCREW	15/64-28 L=4,7	2	
23	780-11117	SCREW	3/16-32 L=6	1	
24	780-11118	HANDLE SHAFT		1	
25	780-11119	HANDLE SHAFT		1	
26	780A-11120	FEED CAM DRIVING GEAR ASM		1	
27	8-53-185	SCREW	15/64-28 L=6,5	2	
28	780-11132	NUT M12		1	
29	780-11121	THRUST WASHER		1	
30	780-11122	FEED CAM SHAFT		1	
31	780-11123	FEED CAM		1	
32	780-11124	WASHER	9,8 x 24,0 x 2,6	1	
33	780-11125	SCREW	3/8-18 L=15	1	
34	780-11126	BAR TRIPPING SEGMENT		1	
36	780-11002	WASHER	4,8 x 8,4 x 0,8	14	
37	780-11128	SCREW	11/64-40 L=16	10	
38	780-11129	KNIFE TRIPPING SEGMENT		1	
39	780-11130	TENSION RELEASE TRIPPING SEGME		1	
40	780-11131	TENSION RELEASE TRIPPING SEGME		1	
42	780-11126	BAR TRIPPING SEGMENT		1	

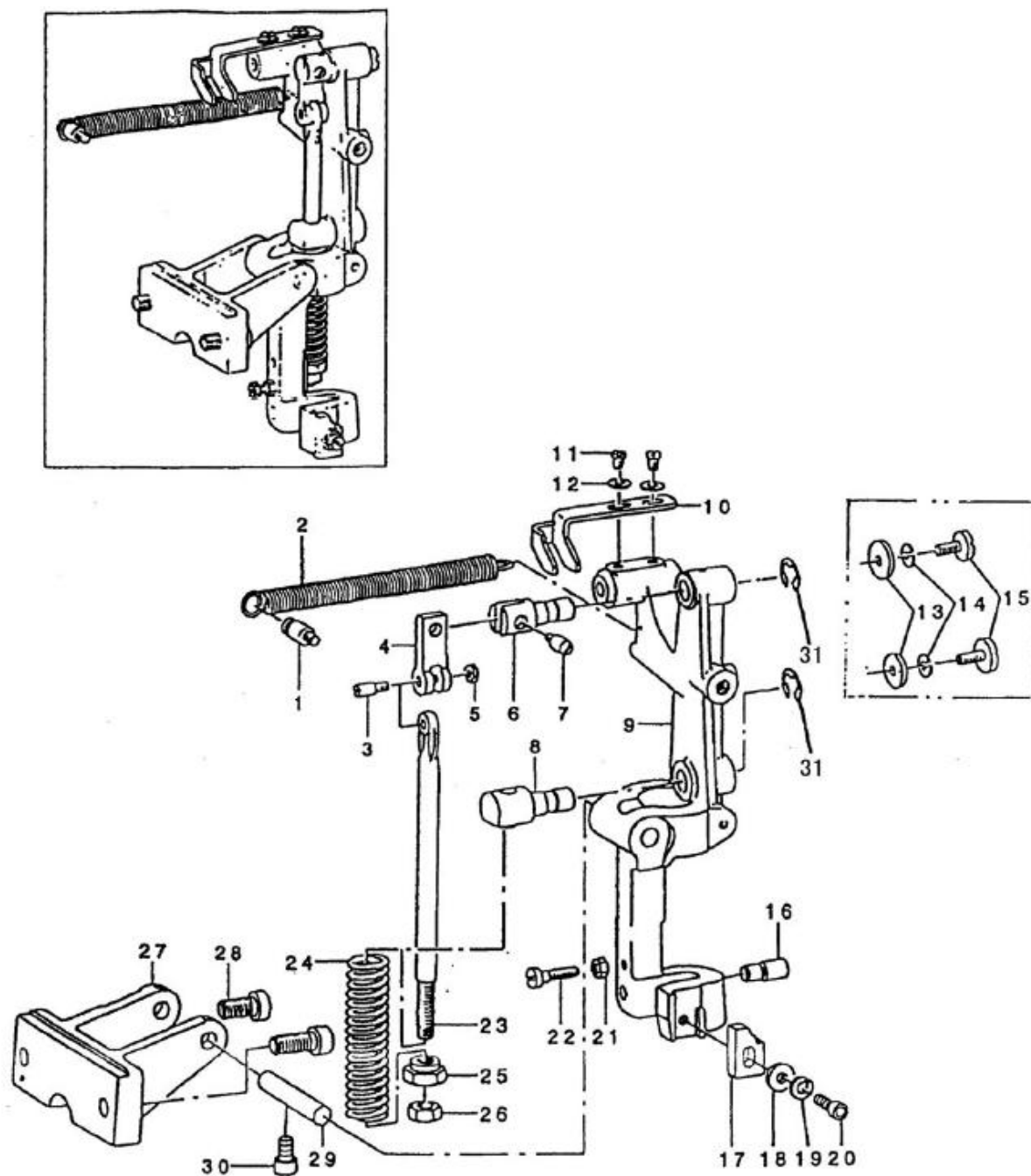
G.21. FEED CAM & TRIOING SEGMENT COMPONENTS (2/2)



G.21. Feed cam & triooing segment components (2/2)

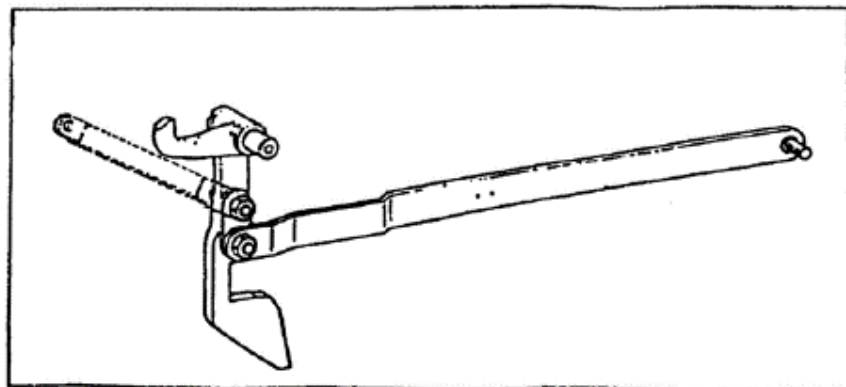
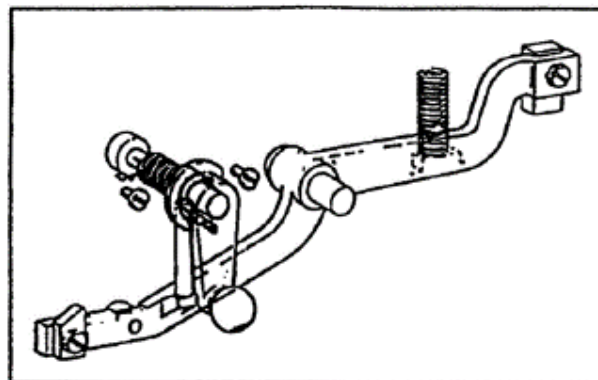
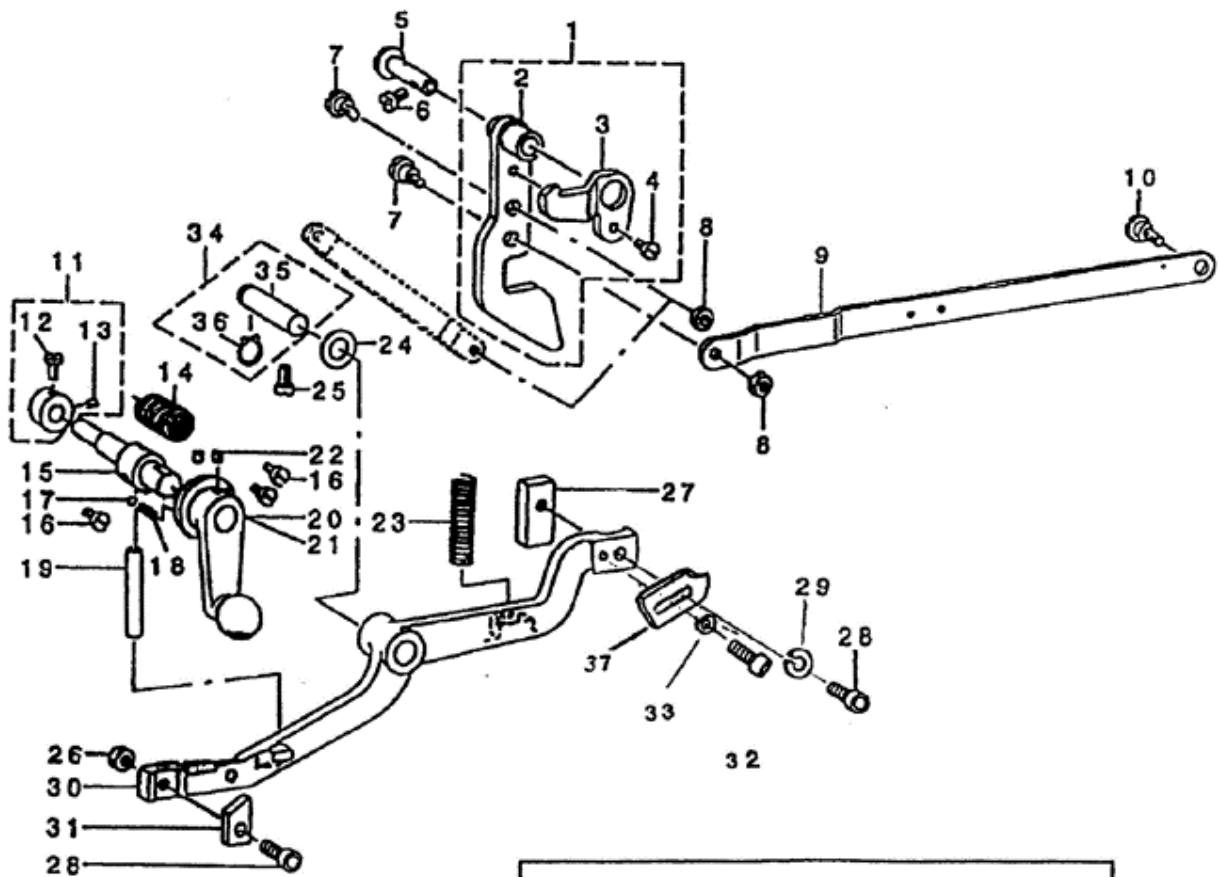
Ref. No	Parts No.	Name of parts	Description	Qty	Note
44	780-11134	LOW-SPEED CAM		1	
45	780-11135	STOPPER CAM		1	
46	780-10127	SCREW	11/64-40 L=14	4	
47	780A-11136]	FASTNESS BUSHING		1	
48	780A-11137}	WHEEL GEAR FIXED POSITION		1	
49	4-26-185	SCREW	15/64-28 L=16	3	

G.22. STOP-MOTION COMPONENTS



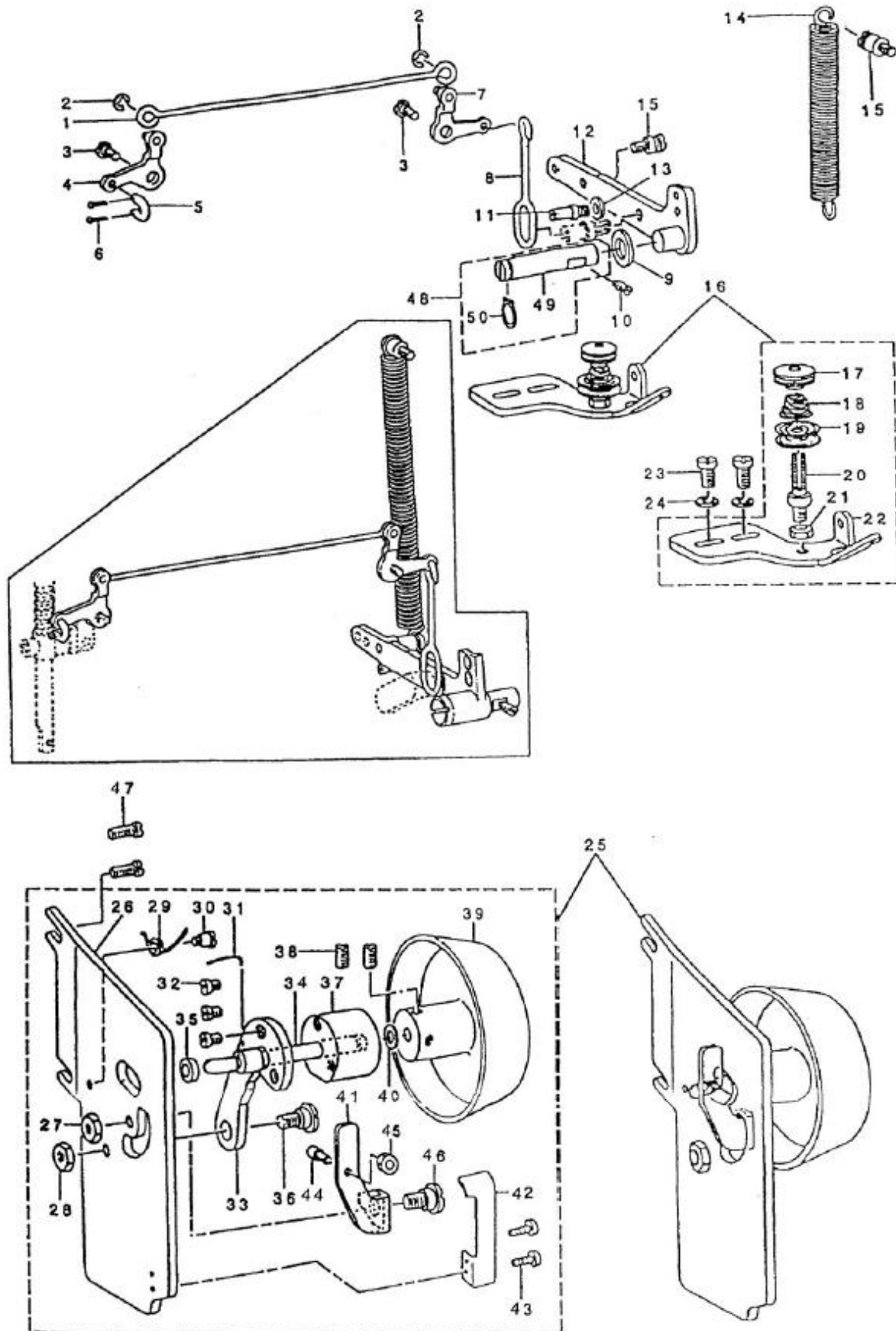
G.22. STOP-motion components					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
1	780-11201	SUSPENSION SCREW (A)		1	
2	780-11202	TENSION SPRING		1	
3	780-11203	STOP LINK ROD HINGE SCREW		1	
4	780-11204	STOP LINK		1	
5	780-11205	NUT	3/16-32	1	
6	780-10206	STOP LINK HINGE STUD		1	
7	780-11207	STOP LINK CONNECTING SCREW		1	
8	780-11208	STOP LINK ROD HINGE STUD		1	
9	780A-11209	TOP MOTION LEVER		1	
10	780-11210	BELT SHIFTER		1	
11	780-10808	CREW	15/64-28 L=7	2	
12	780-11211	WASHER	6,5 x 13 x 0,8	2	
13	780-11212	WASHER	6,1 x 18,5 x 2	2	
14	GB93-76	WASHER		2	
15	780-11213	SCREW	15/64-28 L=13,0	2	
16	780-11214	STOP PIN		1	
17	780-11215	LATCH. A		1	
18	GB97-76	MASHER	6,1 x 15,2 x 2,5	1	
19	GB93-76	WASHER		1	
20	GB70-76	SCREW	M6 L=20	1	
21	780-11217	NUT	15/64-28	1	
22	780-11218	CREW	15/64-28 L=30	1	
23	780-11219	STOP LINK ROD		1	
24	780-11220	STOP LINK ROD PRESSURE SPRING		1	
25	780-11221	NUT FOR STOP LINK ROD		1	
26	780-11222	NUT	3/8-18	1	
27	780-11223	STOP MOTION LEVER BRACKET		1	
28	GB70-76	SCREW	M10 L=20	2	
29	780-11224	PIN		1	
30	GB70-76	SCREW	M6 L=16	1	
31	GB894-76	RETAINING RING	ø11	1	

G.23. TRIPPING LEVER COMPONENTS



G.23. Tripping lever components					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
1	780-11301A	STARTING LINK ASM		1	
2	780-11301B	STARTING LINK COMPL		1	
3	780-11302	SAFETY BASE		1	
4	780-10140	SCREW	11/64-40 L=7	1	
5	780-10940	HING STUD		1	
6	780-10721	SCREW	15/64-28 L=9	1	
7	780-11304	HINGE SCREW		2	
8	780-10544	NUT	15/64-28	2	
9	780-11305	STARTING LINK DRIVING ROD		1	
10	780-11306	HINGE SCREW	D=7,94 H=4,5	1	
11	780-11307	THRUST COLLAR ASM	D=7,94 W=10	1	
12	780-10140	SCREW	11/64-40 L=7	1	
13	780-10111	SCREW	11/64-40 L=5	1	
14	780-11308	CRANK SHAFT TENSION SPRING		1	
15	780-11309	HAND STOP CRANK SHAFT		1	
16	780-10536	SCREW	11/64-40 L=9.5	2	
17	GB308-77	HAND STOP CRANK SHAFT BALL		1	
18	780-11310	CRANK SHAFT PRESSURE SPRING		1	
19	780-11311	HAND STOP ROD		1	
20	780-11312	HAND STOP CRANK ASM		1	
22	780-11116	SCREW	15/64-28 L=4,7	2	
23	780-11313	RIPPING LEVER TENSION SPRING		1	
24	780-11314	WASHER		1	
25	780-10721	SCREW	15/64-28 L=9	1	
26	GB/T6170-1986	NUT	M6	1	
27	780-11315	LATCH (B)		1	
28	GB70-76	SCREW	M6 L=22	1	
29	GB93-76	SPRING WASHER	6,5 x 12,5 x 1,5	1	
30	780A-11317	TRIPPING LEVER		1	
31	780-11318	TRIPPING DOG		1	
32	GB70-76	SCREW	M5 L=12	1	
33	GB93-76	WASHER	ø5	1	
34	780-11321	TRIPPING LEVER HINGE PIN ASM		1	
35	780-11322	TRIPPING LEVER HINGE PIN		1	
36	GB894-76	RETAINING RING		1	
37	780A-11323	STARTING PIECE		1	

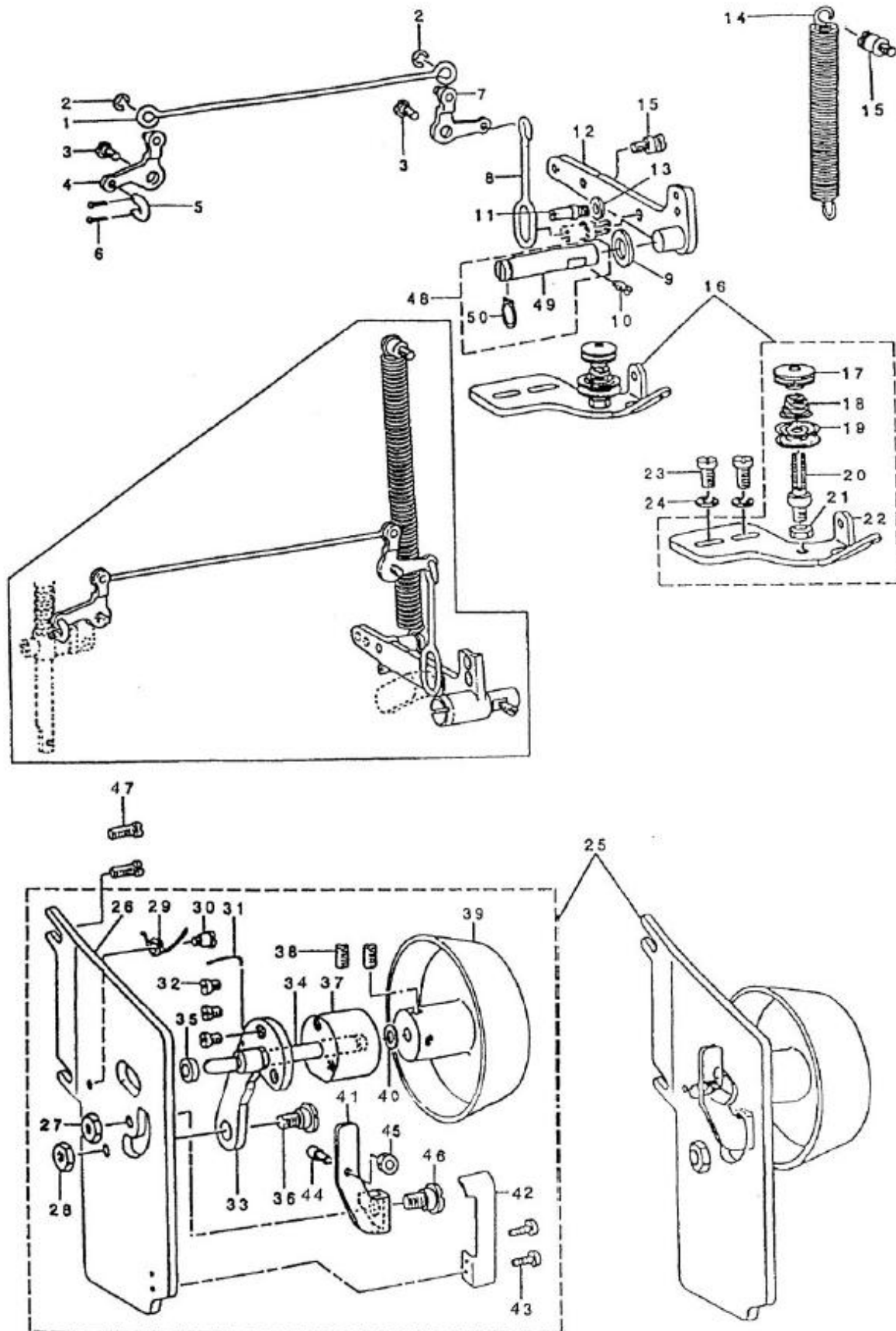
G.24. LIFTING LEVER & BOBBIN WINDER COMPONENTS (1/2)



G.24. Lifting lever & bobbin wnder components (1/2)

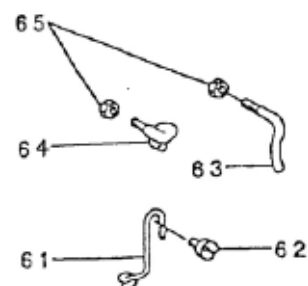
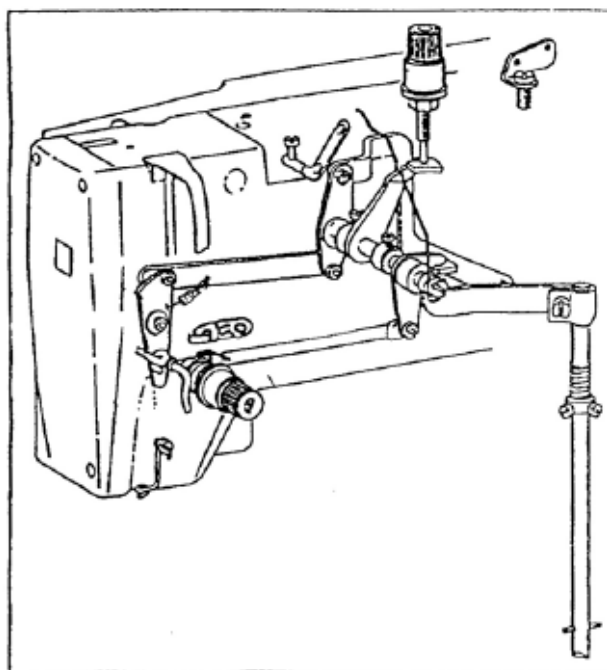
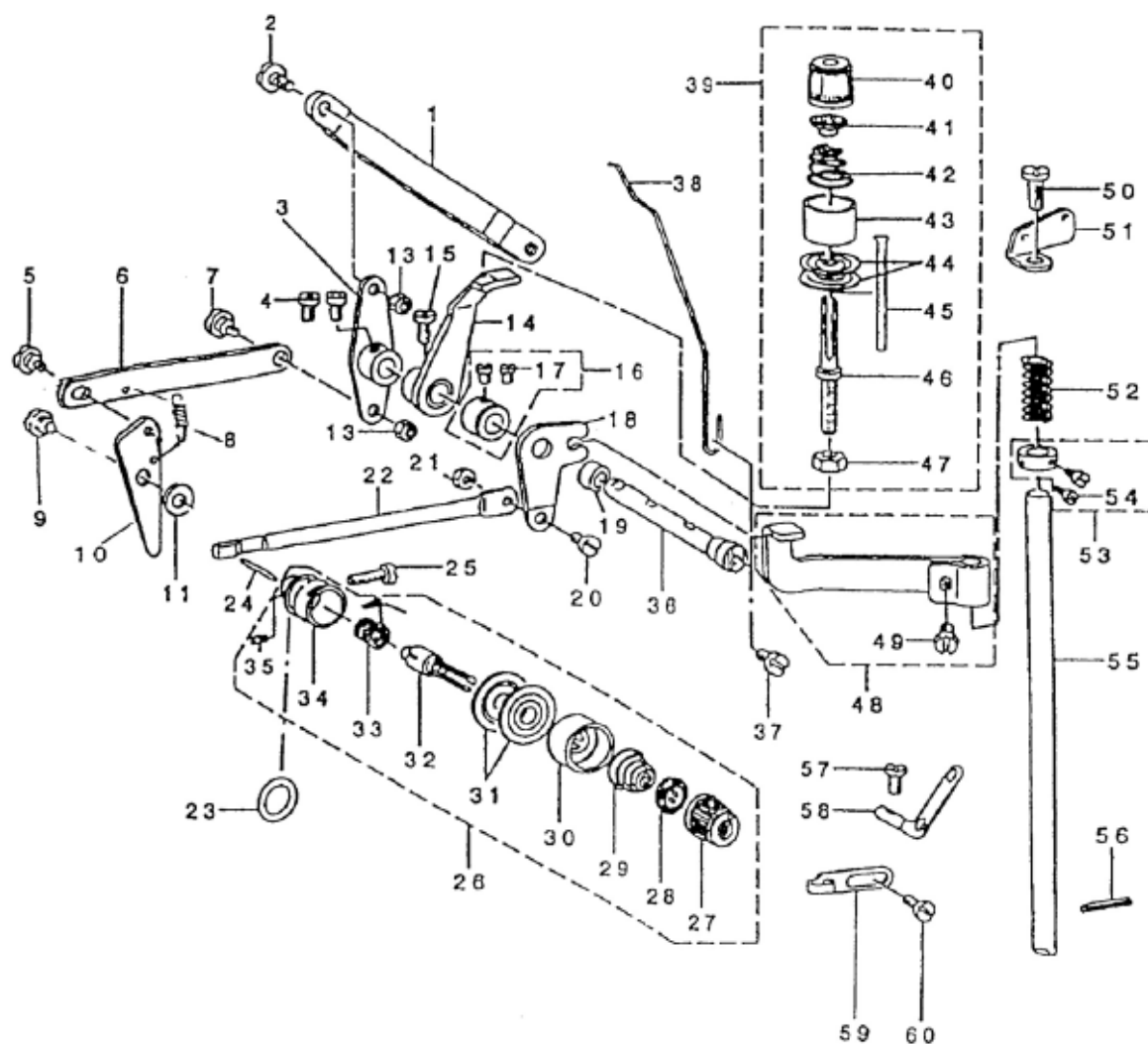
Ref. No	Parts No.	Name of parts	Description	Qty	Note
1	780-11401	PRESSER BAR LIFTING ROD LONG		1	
2	GB896-76	E-RING		2	
3	780-11402	TINGE SCREW	D=7,24 H=3,3	2	
4	780A-11403	LEVER ASM FRONT		1	
5	780-11404	LINK		1	
6	GB91-76	SPLIT PIN		2	
7	780-11405	LEVER ASM REAR		1	
8	780-11406	PRESSER BAR LIFTING ROD		1	
9	780-11314	WASHER		1	
10	780-10302	SCREW	15/64-28 L=10,5	1	
11	780-11407	LIFTING LEVER STOPPER		1	
12	780-11408	PRESSER BAR LIFTING LEVER ASM		1	
13	780-11409	WASHER	7,4 x 11,8 x 0,5	1	
14	780-11410	PRESSER FOOT LIFTING SPRING		1	
15	780-11201	SUSPENSION SCREW (A)		1	
16	780-11412	BOBBIN WINDER TENSING ASM		1	
17	780-11413	BOBBIN WINDER TENSION NUT		1	
18	780-11414	BOBBIN WINDER TENSION SPRING		1	
19	780-11415	BOBBIN WINDER TENSION DISC		2	
20	780-11416	BOBBIN WINDER TENSION POST		1	
21	780-10211	NUT	11/64-40	1	
22	780-11417	BOBBIN WINDER TENSION BRACKET		1	
23	780-10516	SCREW	11/64-40 L=7,8	2	
24	780-11418	WASHER	4,8 x 11,5 x 2	2	
25	780-11419	BOBBIN WINDER ASM		1	
26	780-11420	BOBBIN WINDER BRACKET		1	
27	780-10211	NUT	11/64-40	1	
28	780-10544	NUT	15/64-28	1	
29	780-11421	BOBBIN WINDER SPRING		1	
30	780-11422	HINGE SCREW	D=4,5 H=4	1	
31	780-11423	BOBBIN STOP SPRING		1	
32	780-11424	SCREW	9/64-40 L=6	3	
33	780-11425	PULLEY SHAFT BASE		1	
34	780-11426	BOBBIN WINDER SHAFT		1	
35	780-11427	COLLAR		1	
36	780-11428	HINGE SCREW	D=7,94 H=4,3	1	
37	780-11429	BOBBIN WINDER SHAFT BUSHING		1	
38	780-11430	SCREW	3/16-28 L=7	2	
39	780-11431	BOBBIN WINDER DRIVING PULLEY		1	

G.25. LIFTING LEVER & BOBBIN WINDER COMPONENTS (2/2)



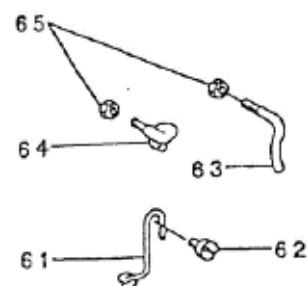
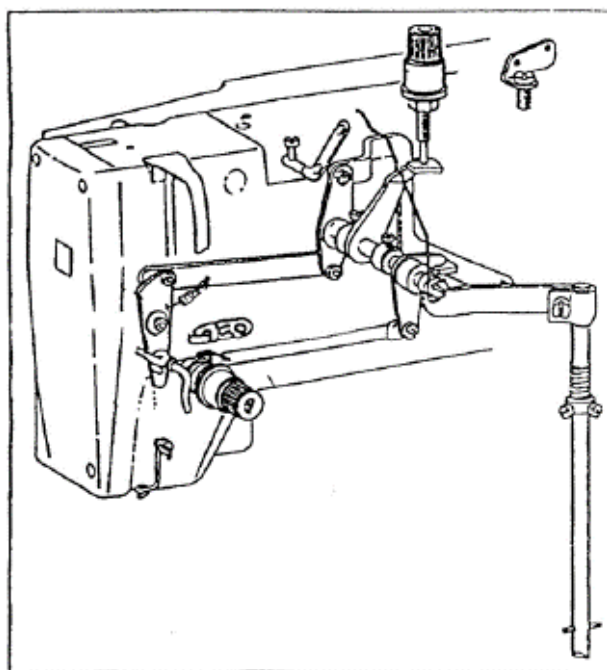
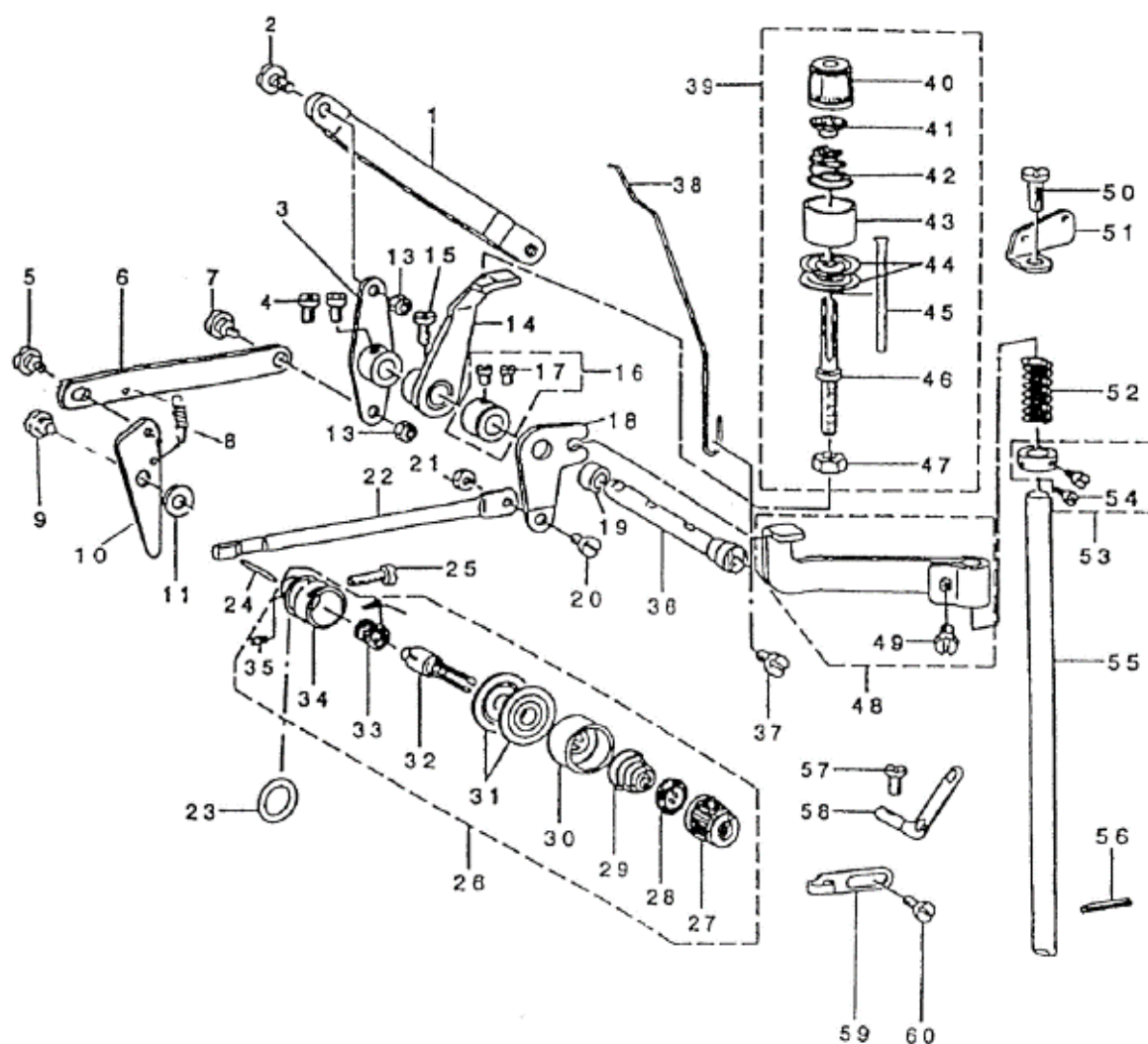
G.24. Lifting lever & bobbin wnder components (2/2)					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
40	780-11432	WASHER	6,5 x 11 x 1	1	
41	780-11433	BOBBIN WINDER TRIP LATCH		1	
42	780-11434	BOBBIN GUIDE SPRING		1	
43	780-10628	SCREW	9/64-40 L=4,5	2	
44	780-11435	ADJUSTING SCREW		1	
45	780-10835	NUT	1/8-44	1	
46	780-11437	HINGE SCREW	D=7,24 H=2,2	1	
47	780-10516	SCREW	11/64-40 L=7,8	2	
48	780-11321	TRIPPING LEVER HINGE PIN ASM		1	
49	780-11322	TRIPPING LEVER HINGE PIN		1	
50	GB894-76	RETAINING RING	ø11	1	

G.26. THREAD TENSION COMPONENTS (1/2)



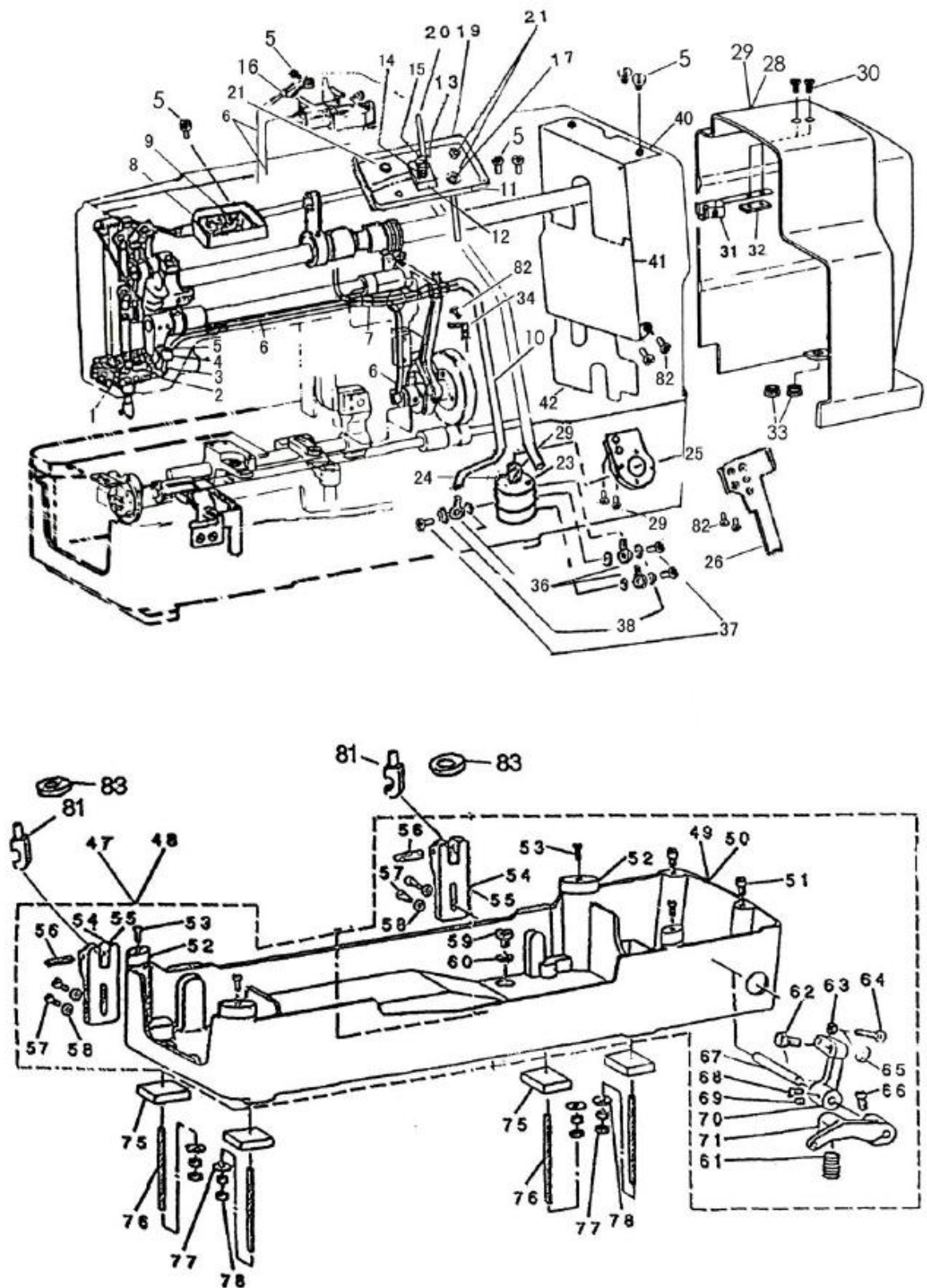
G.26. Thread tension components (1/2)					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
1	780-11501	TENSION RELEASE LINK		1	
2	780-11502	HINGE SCREW	D=6,35 H=3,9	1	
3	780-11503	TENSION RELEASE LEVER		1	
4	780-10414	SCREW	1/4-40 L=7,0	2	
5	780A-11504	HINGE SCREW	D=6,35 H=2,4	1	
6	780A-11505	BLOCKNG LINK		1	
7	780-11502	HINGE SCREW	D=6,35 H=3,9	1	
8	780A-11507	BLOCKNG ARM SPRING		1	
9	780A-11508	HINGE SCREW	D=7,94 H=3,1	1	
10	780A-11509	BLOCKNG ARM		1	
11	780A-11510	BLOCKNG ARM BRACKET		1	
13	780-10928	NUT	3/16-28	2	
14	780-11511	TENSION RELEASE LEVER		1	
15	780-11512	SCREW	3/16-32 L=9,5	1	
16	780-11307	THRUST COLLAR ASM	D=7,94 W=10	1	
17	780-11140	SCREW	11/64-40 L=7	2	
18	780-11514	TENSION RELEASE CRANK NO.2		1	
19	780-11515	TENSION RELEASE LEVER COLLAR		1	
20	780-11516	HINGE SCREW	D=5 H=3	1	
21	780-10406	NUT	9/64-40	1	
22	780-11517	TENSION RELEASE ROD		1	
23	GB1235-76	RUBBER RING		1	
24	780A-11518	TENSION RELEASE PIN.NO.2		1	
25	780-11128	SCREW	11/64 40 L=16	1	
26	780-11519	TENSION CONTROLLER NO.2 ASM		1	
27	780-11520	HIIREAD TENSION PICK-UP (RED)		1	
28	780-11521	TENSION SPRING BUSHING		1	
29	780-11522	TENSION SPRING RED		1	
30	780-11523	THREAD TENSION DISK PRESSER		1	
31	780-10524	THREAD TENSION DISK		2	
32	780-11525	TENSION POST NO. 3		1	
33	780-11526	THREAD TAKE-UP SPRING		1	
34	780-11527	TENSION POST SOCKET		1	
35	780-11528	SCREW	9/64 40 L=5,5	1	
36	780-11529	TENSION RELEASE LEVER SHAFT]		1	
37	780-11516	SCREW	11/64-40 L=7,8	1	
38	780A-11530]	THREAD PULLING WIRE		1	
39	780-11531	TENSION CONTROLLER NO.1 ASM		1	
40	780-11520	THREAD TENSION PICK-UP (RED)		1	

G.27. THREAD TENSION COMPONENTS (2/2)



G.27. Thread tension components (2/2)					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
41	780-11521	TENSION SPRING BUSHING		1	
42	780-11532	TENSION SPRING NO.1		1	
43	780-11523	THREAD TENSION DISK PRESSER		1	
44	780-11524	TIREAD TENSION DISK		2	
45	780A-11533	TENSION RELEASE PIN NO.2		1	
46	780-11534	TENSION POST NO.2		1	
47	780-10613	NUT	1/4-24	1	
48	780-11535	TENSION RELEASE ARM ASM		1	
49	780-11536	SCREW	1/4-40 L=8,5	1	
50	780-10610	SCREW	15/64-28 L=12	1	
51	780-11537	THREAD GUIDE PLATE		1	
52	780-11538	SPRING		1	
53	780-11539	THRUST COLLAR ASM		1	
54	780-10628	SCREW	9/64-40 L=4, 5	2	
55	780-11540	TENSION RELEASE ROD		1	
56	GB879-76	SPRING PIN	3 x 18	1	
57	780-11140	SCREW	11/64-40 L=7	1	
58	780-11541	THREAD EYELET		1	
59	780-11542	ARM THREAD GUIDE A		1	
60	780-10512	SCREW	9/64-40 L=6,8	1	
61	780-11543	NEEDLE BAR THREAD GUIDE		1	
62	780-10516	SCREW	11/64-40 L=7,8	1	
63	780-11544	TENSION THREAD GUIDE NO.2		1	
64	780A-11545	THREAD GUIDE		1	
65	780-10406	NUT	9/64-40	2	

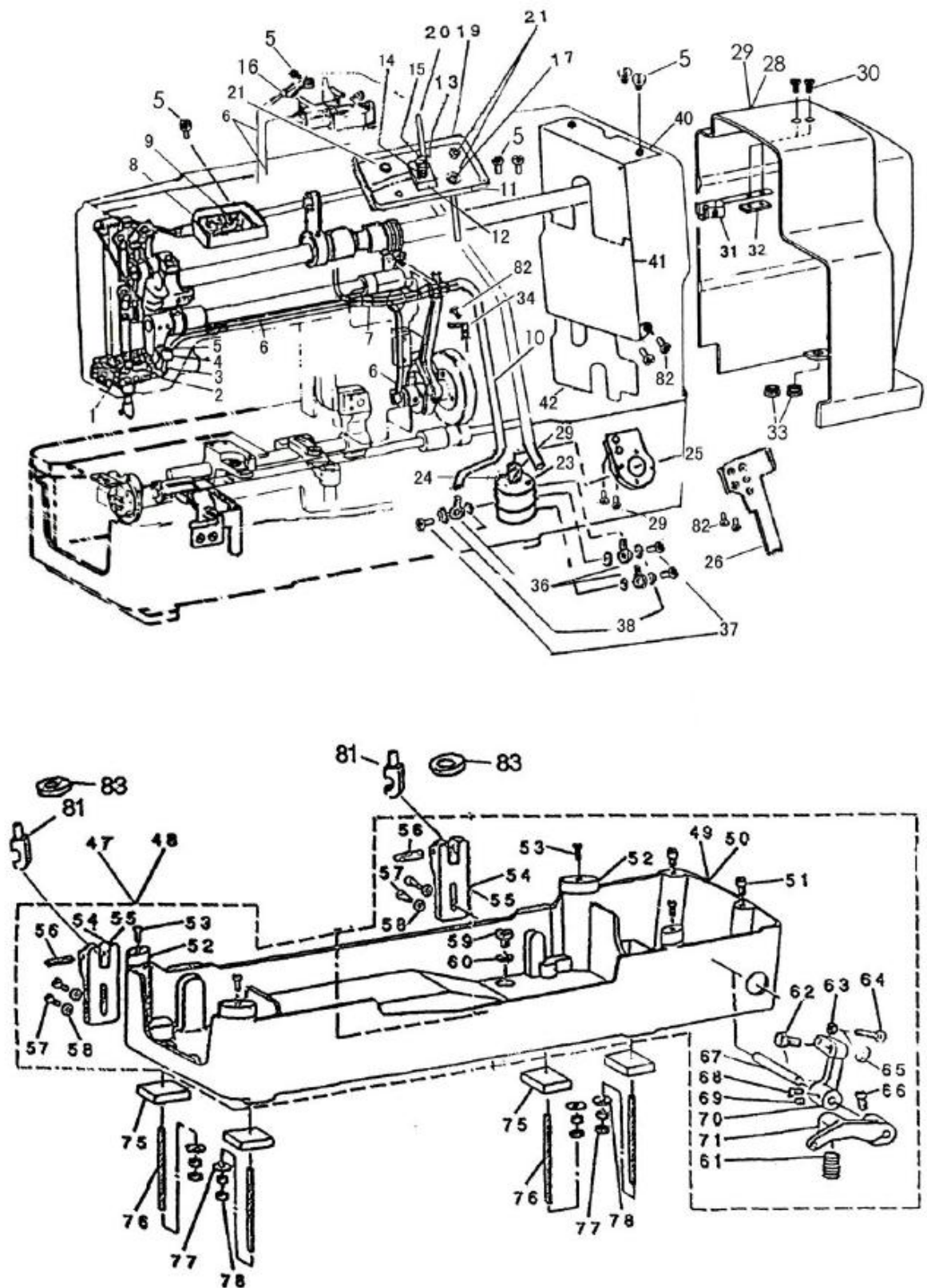
G.28. LUBRICATION MECHANISM COMPONENTS (1/2)



G.28. Lubrication mechanism components (1/2)

Ref. No	Parts No.	Name of parts	Description	Qty	Note
1	780A-11601	OIL FELT PRESSURE SPRING		1	
2	780A-11602	OIL RETURN FELT (A)		1	
3	780-11603	OIL RETURN TUBE		1	
4	780A-11604	CABLE HOLDER		1	
5	780-10140	SCREW	11/64-40 L=7	6	
6	780-11605	OIL RETURN FELT		1	
7	780A-11606	OIL WICK		1	
8	780A-11607	FOUNT		1	
9	780A-11608	OIL FELT		1	
10	780A-11609	VINYL PIPE		1	
11	780A-11610	OIL RECEIVER ASM		1	
13	780A-11611	OIL ADJUSTING SCREW BASE		1	
14	780A-11612	OIL ADJUSTING SCREW		1	
15	780A-11613	OIL ADJUSTING SPRING		1	
17	780A-11615	VINYL PIPE		1	
19	780A-11616	OIL FELT		1	
20	780A-11617	OIL MARK SCREW		1	
21	780-11013	NUT	1/4	4	
23	780A-11619	OIL PUMP		1	
24	780A-11620	OIL PUMP WORM GEAR		1	
25	780A-11621	OTL PUMP PLANK		1	
26	780A-11622	VINYL PIPE PLANK		1	
28	780-11623	BELT GUARD		1	
29	780-10107	SCREW	11/64-40 L=12	2	
30	780-11624	SCREW	11/64-40 L=8,5	2	
31	780-11625	BELT GUARD SET SCREW		1	
32	780-11626	BOTTOM GUIDE		1	
33	780-11627	RUBBER BUSIING		2	
34	780A-11657	VINYL PIPE FIX LATCH		1	
36	780A-11648	VINYL PIPE CONNECTING		3	
37	780A-11649	VINYL PIPE CONNECTING SCREW		3	
38		WASHER	ø6,5 x ø10,5 x 1	6	
40	780A-11630	OIL COVER (TOP)		1	
41	780A-11631	OIL COVER (MIDDLE)		1	
42	780A-11632	OIL COVER (BOTTOM)		1	
47	780-11636	MACHINE BASE ASM		1	
49	780-11637	OIL RESERVOIR		1	
51	780-11638	GUIDE PIN		2	
52	780-11639	RUBBER CUSHION		4	

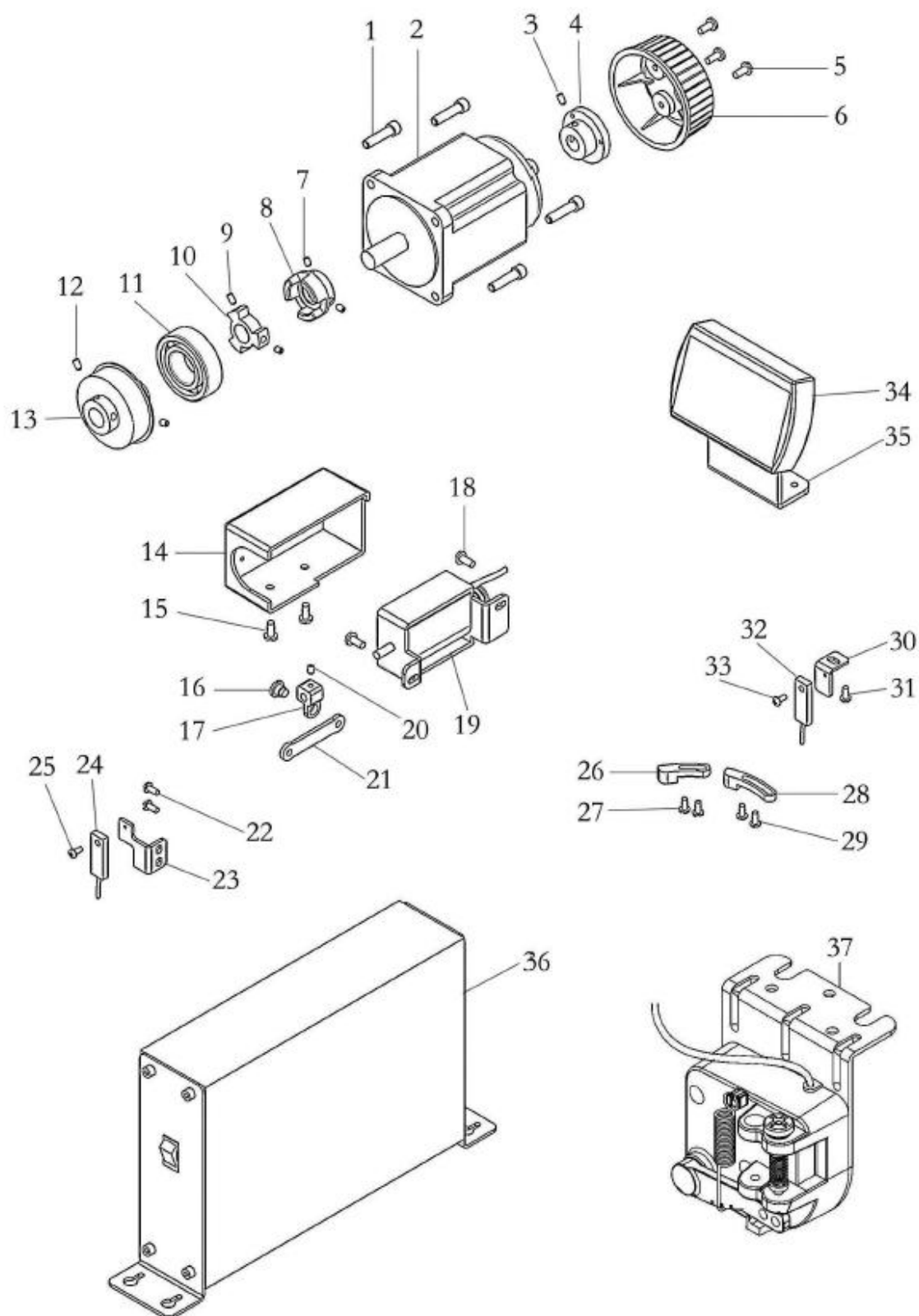
G.29. LUBRICATION MECHANISM COMPONENTS (2/2)



G.29. Lubrication mechanism components (2/2)

Ref. No	Parts No.	Name of parts	Description	Qty	Note
53	780-10338	SCREW	11/64-40 L=10,5	4	
54	780-11640	HINGE HOLDER		2	
56	GB879-76	PIN		2	
57	GB70-76	SCREW	M6 L=20	4	
58	GB93-76	WASHER	M6	4	
59	780-11643	SCREW		1	
60	780-11644	OIL DRAIN CAP GASKET		1	
61	780-11645	STARTING LEVER PRESSURE SPRING		1	
62	780-10733	SCREW	M8 L=20	1	
63	780-10544	NUT	15/64-28	1	
64	780-11646	STOP SCREW ASM		1	
65	GB/T6175-1986	NUT	M8	1	
66	780-10610	SCREW	15/64-28 L=12	1	
67	780A-11647	STARTING LINK SHAFT		1	
68	780-11648	SCREW		1	
69	780-10323	SCREW	15/64-28 L=7	1	
70	780-11649	STARTING LINK		1	
71	780-11650	STARTING LEVER		1	
75	780-11653	MACHINE BASE FELT PAD		4	
76	780-11654	MACHINE BASE SCREW STUD		4	
77	780-11655	WASHER	6,1 x 18,5 x 2	4	
78	780-10544	NUT	15/64-28	4	
81	780-11658	CONNECTION STUD		2	
82	780-10512	SCREW	9/64-40 L=6,8	7	
83	780-11660	RUBBER WASHER		2	

G.30. ELECTRICAL CONTROL COMPONENTS



G.26. Electrical control components					
Ref. No	Parts No.	Name of parts	Description	Qty	Note
1	GB70	SCREW	M5 L=30	4	
2	19-02-791	MOTOR		1	
3	GB77	SCREW	M5 L=6	2	
4	19-04-791	HANDWHEEL RETAINER		1	
5	GB	SCREW	M4 L=10	3	
6	19-06-791	HANDWHEEL		1	
7	GB77	SCREW	M6 L=6	3	
8	19-08-791	COUPLING A		1	
9	GB77	SCREW	M6 L=6	3	
10	19-10-791	COUPLING B		1	
11	GB	BEARING	6205Z	1	
13	GB77	SCREW	M5 L=6	2	
14	19-13-791	SPROCKET WHEEL		1	
15	19-14-791	SOLENOID COVER		1	
16	GB	SCREW	M5 L=6	2	
17	11306-780	HINGE SEREW		2	
18	19-17-791	CONNECTION BLOCK		1	
19	10516-780	SCREW SM	11/64-40 L=7,8	2	
20	19-19-791	SOLENOID		1	
21	19-20-791	SCREW SM	11/64-40 L=6	2	
22	19-21-791	CONNECTION PLATE		1	
23	10516-780	SCREW SM	11/64-40 L=7,8	2	
24	19-23-791	SMALL BRACKET		1	
25	19-24-791	START SENSOR		1	
26	GB	SCREW	M3 L=4	1	
27	19-26-791	STOP INDUCTION BLOCK		1	
28	10127-780	SCREW SM	11/64-40 L=14	2	
29	19-28-791	SLOW INDUCTION BLOCK		1	
30	10127-780	SCREW SM	11/64-40 L=14	2	
31	19-30-791	SENSOR SUPPORT		1	
32	10516-780	SCREW SM	11/64-40 L=7,8	1	
33	19-32-791	STOP SENSOR		1	
34	GB	SCREW	M3 L=8	1	
35	19-34-791	DISPLAY PANEL		1	
36	19-35-791	DISPLAY SCREEN BRACKET		1	
37	19-36-791	ELECTRIC CONTROL BOX		1	