



CONSOLIDATED SEWING MACHINE CORP.

— INDUSTRIAL SEWING & CUTTING EQUIPMENT

# Model

# 228R-11

# Instruction / Parts Book

# Catalogue

## Directions

I、Brief	1
II、Main Specification	1
III、Installing the Machine	1
1. Installing the Machine head	1
2. Installing the motor	1
3. Installing the thread wind	2
4. Connecting the clutch lever to pedal	2
5. Installation and adjustment of knee lifter device	2
6. Installing the drip pan	3
7. Installing the thread unwinder	3
IV、Preparation	3
1. Clean the machine	3
2. Examination	4
V、Operation and Adjustment	4
1. Choose the thread	4
2. Install the needle	4
3. Pass the thread	4
4. Winding the bobbin thread and adjustment	5
5. Install the bobbin into the hook	5
6. Adjustment for stitch length and reverse sewing	5
7. Adjusting the tension of bobbin thread and needle thread	6
8. Adjusting the height of feed dog and the pressure of presser bar	7
9. Adjusting the position of hook and needle	7
10. The relation between the hook and hook thread separate bracket	8
11. Adjusting the position of feed dog and needle	9

## Parts catalogue

1. Arm	10~11
2. Thread tension	12~13
3. Post bed	14~15
4. Post bed for twin needle	16~17
5. Upper shaft and needle thread take-up	18~19
6. Presser foot lifter	20~21
7. Reverse feed	22~23
8. Lower shaft	24~25
9. Accessory	26~27

# **Directions**

The directions should be read carefully before  
using the machine and taken adequate maintenance.

## I、Brief

This machine adopts slide drive lever, vertical rotary hook, upper and lower synchronized belt. It can go through materials easily and run smoothly for its large stroke of needle. The stitch length of sewing forward and backward is adjustable. It is suitable for sewing round the corner on leather shoes, sports shoes, leather bags, gloves, caps and etc.

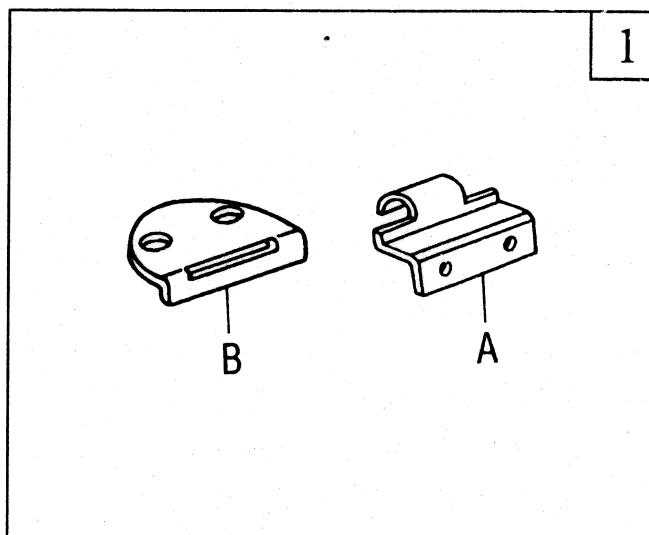
## II、Main specification

Max.Sewing Speed	2500s.p.m
Stitch Length	0~5mm
Stroke of Needle Bar	33.2mm
Thread take-up lever Stroke	61.5mm
Presser Foot Lift Height	7mm by hand 13mm by knee
Needle	DP×F22 14-18
Hook	Vertical rotating hook
Lubrication	Oiling by hand
Needle gauge <mm>	1.2、1.6、2、2.4

## III、Installing the machine

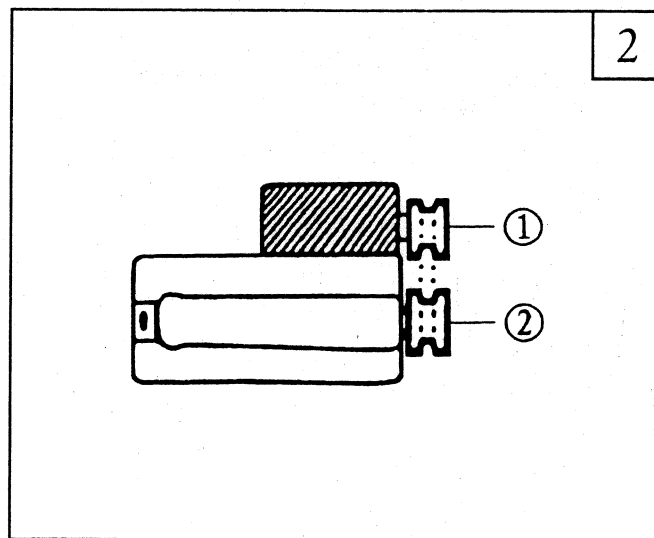
### 1.Installing the machine head(Fig.1)

Please fix the hinge bushing A to the sewing machine bed, and the hinge B into the groove of the table by wood-screws, then fix the machine head on the table.

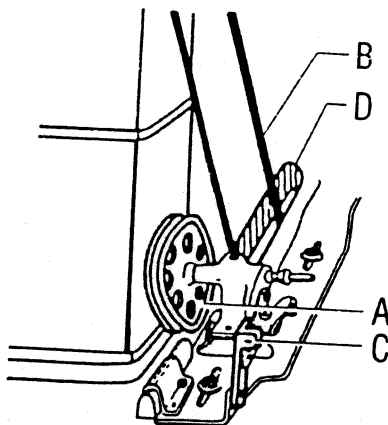


### 2.Installing the motor(Fig.2)

- (1) Install the motor on the bottom of the table with screws, washers and nuts.
- (2) Fix the motor when the groove of the balance wheel ① is confirmed in straight line with the groove of the pulley ② after installing the belt.
- (3) Install the switch, and connect the motor and elec. Power to ensure the motor moves clockwise.
- (4) The tension F of the O belt could be adjusted by moving the motor upwards and downward. The proper tension of O-belt is a slack of 10-12mm when the belt is pressed soft by finger.



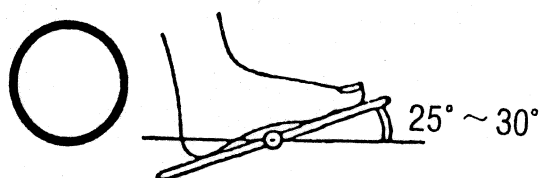
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### 3. Installing the thread wind (Fig.3)

Align the pulley A with the outside of the belt B, and there should be a proper clearance between them so that the pulley is contacted with the belt when the rock lever C is pressed. The bobbin winder should be paralleled to belt slit D of the table.

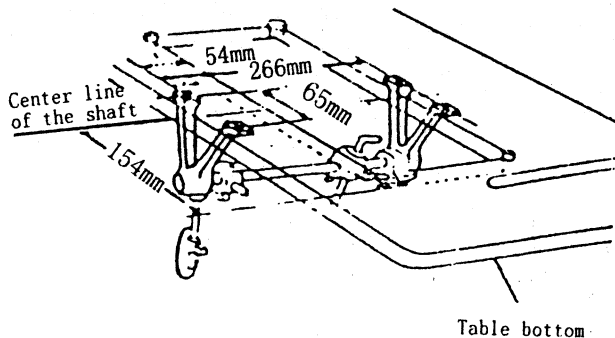
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### 4. Connecting the clutch lever to pedal (Fig.4)

- (1) Adjust the position of the pedal so that the clutch lever and draw bar are in straight line.
- (2) The optimum tilt angle of the pedal against floor is approx. 20~30 degree.

5



### 5. Installation and adjustment of knee lifter device (Fig.5, 6)

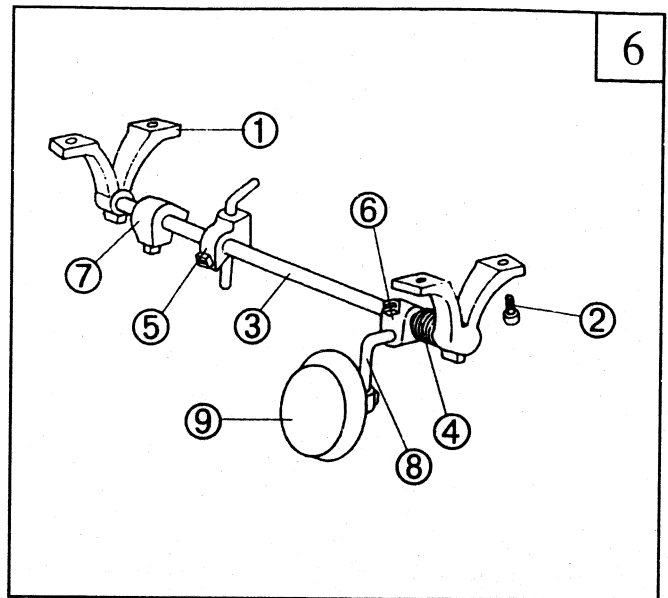
1. Install the knee lifter device correctly at the mark of table bottom shown as fig.5

2. The method of installation (fig.6)

- (1) Put the support ① on the mark of table bottom.
- (2) Fix the support on the table with the wood-screw ②.
- (3) Install the knee lifter lever ③, and put the spring ④, knee lifter crank ⑤, connecting rod joint ⑥, knee lifter position complete ⑦ onto the knee lifter lever orderly.
- (4) Ensure every parts be on their own position, then tighten the screw ②.
- (5) Insert the knee lifter bar ⑧ into the connecting rod joint ⑥, then put the pat ⑨ on the knee lifter bar ⑧.
- (6) Insert one side of the spring ④ into the hold of support ①, another side of the spring be putted of the knee lifter lever.
- (7) Ensure the knee lifter device could work freely after installation.
- (8) Put the machine head on the table, install the knee lifter connecting rod joint complete on the knee lifter connecting rod, and adjust the parts according to the position of connecting rod joint complete.

## 6. Installing the drip pan

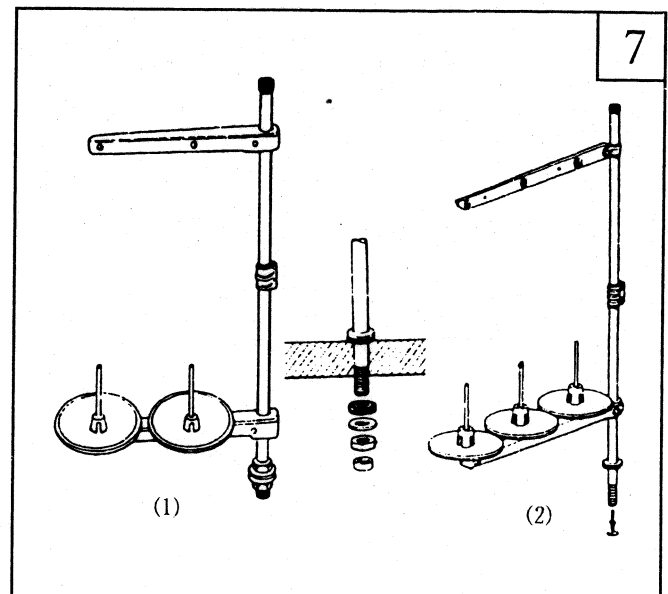
Fix the drip pan on the table with the nails assure the drip pan don't touch with the knee lifter device



## 7. Installing the thread unwinder(Fig.7)

Install the thread unwinder shown as the figure. Locate the thread unwinder at the right back of the table. The machine head doesn't touch with the thread unwinder when it is put down, then tighten the nut C.

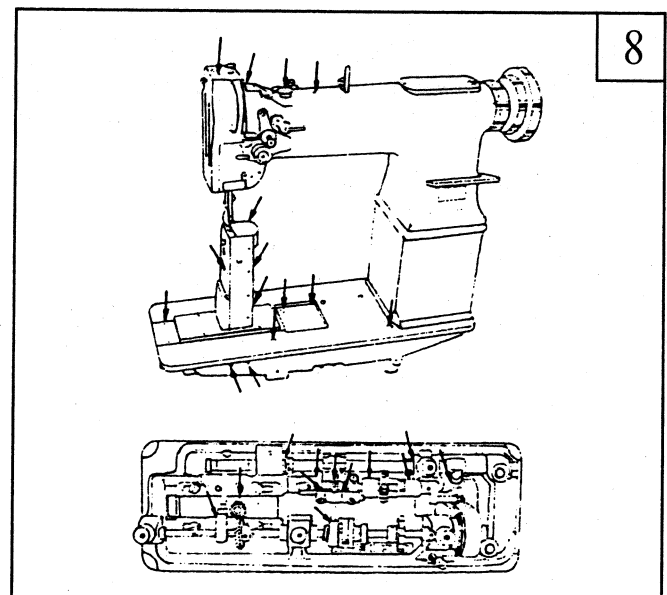
Note: Fig 7(2) thread unwinder is for twin-needle sewing machine



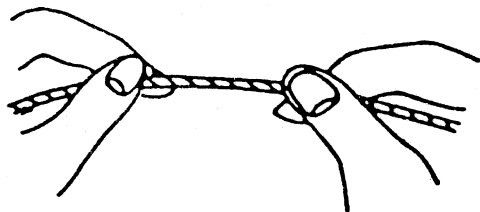
# IV、 Preparation

## 1. Clean the machine(Fig.8)

- (1) Clean the machine, the grease and dust coated on the machine must be removed with clean soft cloth.
- (2) Examination. Turn the balance wheel by hand to see if there is running abrasion, parts collision, uneven resistance of abnormal noise. If these situations exist, adjustment must be made accordingly before running.
- (3) Fill the oil in all the oil holds of the machine.



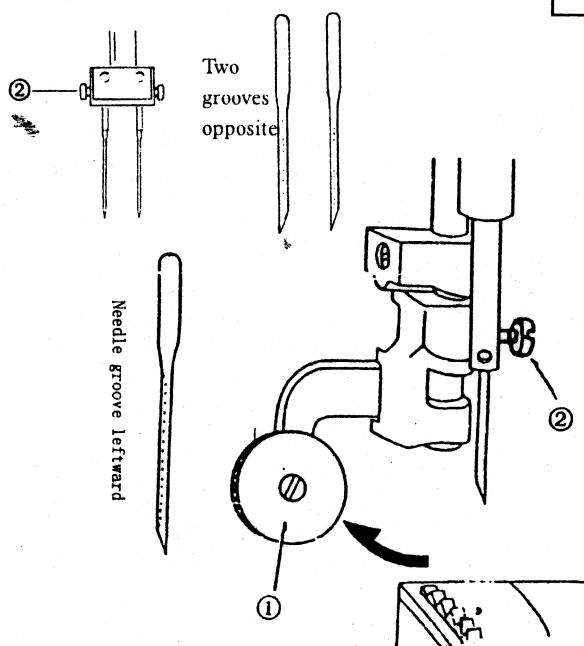
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## 2.Examination

When the machine is put into use or use again after operation for a long time, please lift the roller presser foot and run the machine at lower speed of 1200-1500s. p.m. After running 30 min, then increase up the sewing speed gradually.

10



## V. Operation and Adjustment

### 1.Choose the thread(Fig.9)

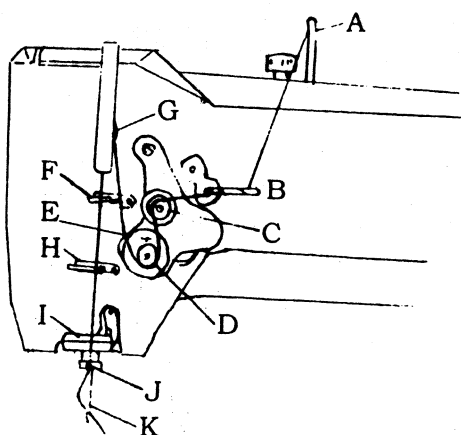
- (1)The thread should be in good quality.
- (2)The thread should be left-handed.
- (3)Holding the thread (shown in Fig.9) , twist it upward by right hand. If it changes into twice, it is right-handed, contrary, it is left-handed.

### 2.Install the needle(Fig.10)

- (1)The needle is DP×F22 14#~18#.
  - (2)Select needle according to the thread.
- Installation:
- (1)Lift the presser foot lifter, turn the balance wheel by hand to lift the thread take-up lever to its highest position.
  - (2)Press the roller presser food ① downward and open it leftward.
  - (3)Loosen the screw ②.
  - (4)Making the needle groove turn to the left side, then fully insert the needle shank up to the bottom of the needle socket.
  - (5)Tighten the screw ②.

Note: In twin-needle machine, two needle grooves is opposite.

11



### 3.Pass the thread(Fig.11)

- (1)Turn the balance wheel by hand to lift the thread take-up lever up to the highest position.
  - (2)Lift the presser foot lifter, press the roller presser downward and open it leftward.
- The order as the Fig.11: Thread pass-by pin A→Three-eye thread guide B→thread tension C→Thread controller plate D→thread take-up spring E→upper thread guide F→thread take-up lever G→upper thread guide F→middle thread guide H→lower thread guide I→needle bar thread guide J→needle K.

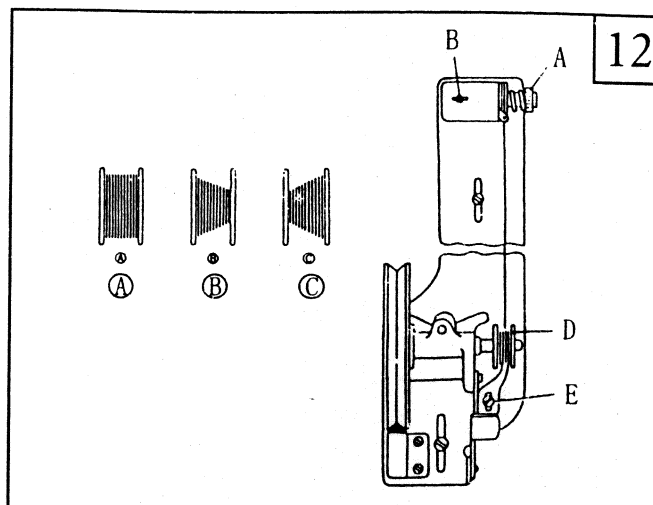
#### 4. Winding the bobbin thread and adjustment (Fig. 12)

##### 1. Winding the thread

The bobbin thread should be neat and tight. If the thread is weak, please enlarge the pressure of the big thread tension disc A. If the thread is not neat, please move the bracket to adjust it. Firstly, loosen the screw. If the thread is wound to one side as Fig. 12(B), please move the bracket rightward. If it is as Fig. 12(C), please move the bracket leftward. Move the bracket until the thread is wound neatly as Fig. 12(A), then tighten the screw.

Note: Nylon or polyester thread should be wound with light tension in particular, otherwise the bobbin D might be broken or deformed.

Don't overfill the bobbin thread, because it makes thread loosening down from the bobbin. The optimum capacity of bobbin thread is fill about 80% of bobbin outside diameter, and this can be adjusted by screw (E).



#### 5. Install the bobbin into the hook (Fig. 13)

(1) Turn the balance wheel by hand to lift the needle bar up to its highest position, open the roller presser foot leftward.

(2) Take off the sliding plate.

(3) Lift the hook door lifter B.

(4) Draw out the bobbin thread 5cm.

(5) Put the bobbin into the hook.

(6) Put down the door lifter B.

(7) Pass the 5cm thread through the hook groove C, then draw out the thread from the bottom of D.

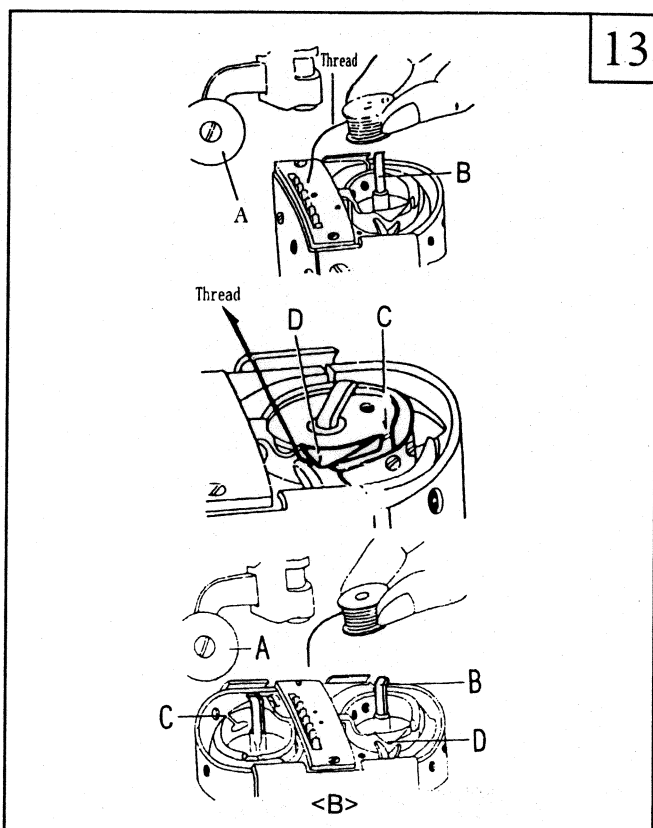
(8) Put the thread out.

(9) Hold the needle thread by left hand, and turn the balance wheel by right hand.

(10) Put the bobbin thread nearby.

(11) Put on the sliding plate.

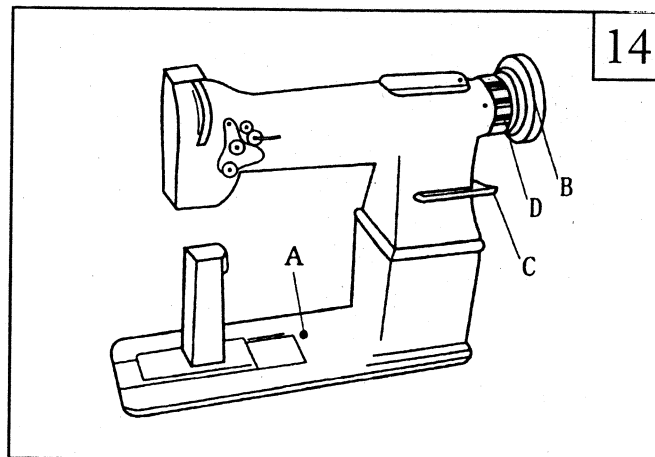
Note: Fig. 13(B) is for twin-needle sewing machine.



#### 6. Adjustment for stitch length and reverse sewing (Fig. 14)

Press the stitch length button A, turn the balance wheel B until the button inserts the eccentric adjusting tray groove, continually press the button A, turn the balance wheel to make the figure which is on the stitch length ring B align with the red mark on the arm.

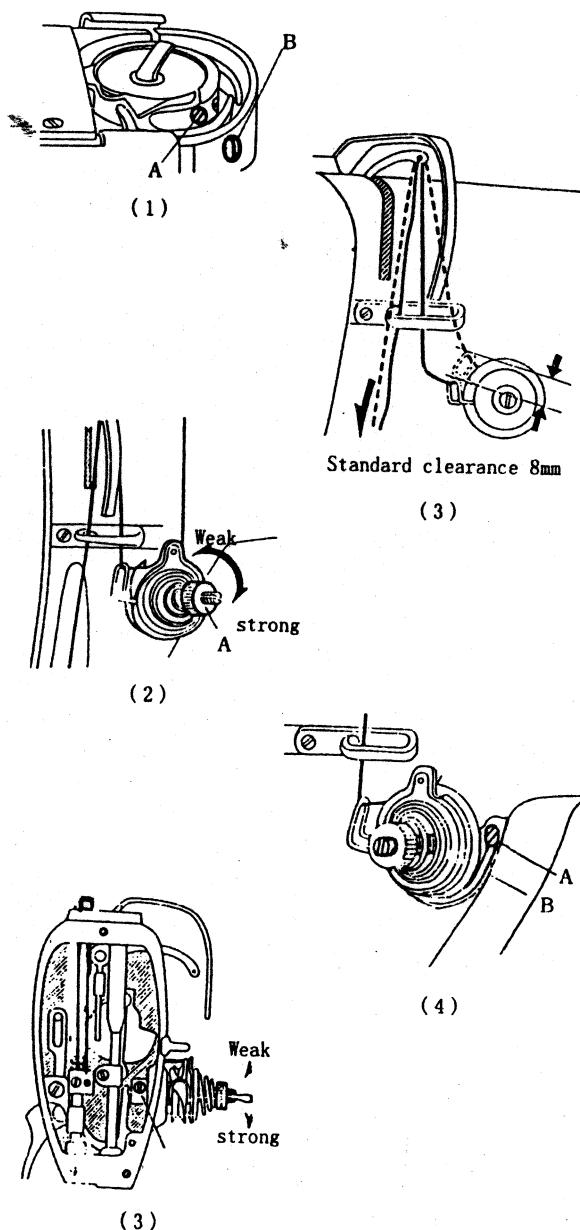
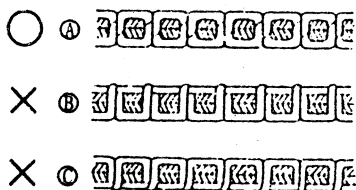
Turn the balance wheel clockwise, the stitch length becomes small, contrary, the stitch length becomes big. The figure on the stitch length ring D indicates the stitch per inch. (25.4mm)





## 7. Adjusting the tension of bobbin thread and needle thread (Fig. 15)

The tension of needle thread and bobbin thread should be suitable. The stitch form shown as (A) is the best. The abnormal stitch form shown as (B) (C) will occur when the tension is tighten or loosen.



## ① Adjusting the tension of bobbin thread

The tension of bobbin thread should be adjusted according to the material.

(1) Turn the balance wheel by hand to lift the thread take-up lever up to its highest position.

(2) Take down the sliding plate, the adjusting screw (A) is shown as (1)

(3) Put the screw-knife into the hold B, then turn the adjusting screw A clockwise, the tension of bobbin thread becomes strong.

(4) If turn the adjusting screw A count-clockwise, the tension of bobbin thread becomes weak.

## ② Adjusting the tension of needle thread.

(1) Adjusting the pressure on thread tension disc.

Adjusting the pressure on thread tension disc to change the tension of needle thread. As Fig. (2), turn the nut (A) clockwise to increase the pressure, contrary, to decrease the pressure.

(2) Adjusting the tension of thread take-up spring

Common material 25g

Thin material 20g

Heavy material 30g

The method of adjusting:

a. Put down the presser foot lifter.

b. Loosen the thread take-up spring shaft screw (A).

c. The tension becomes weak when turns the thread take-up spring shaft clockwise. Contrary, it becomes strong.

d. Tighten the screw A after adjustment.

(3) The swing range of thread take-up spring

The thread take-up spring needs to be able to swing. When the thread take-up lever is at its highest position the normal swing range of thread take-up spring should be:

Common material about 8mm

Thin material over 8mm

Heavy material less 8mm

The method of adjusting swing range

a. Put down the presser foot lifter

b. Loosen the screw A

c. Turn the thread take-up spring disc B counter-clockwise, the swing range increases, contrary, the swing range decreases.

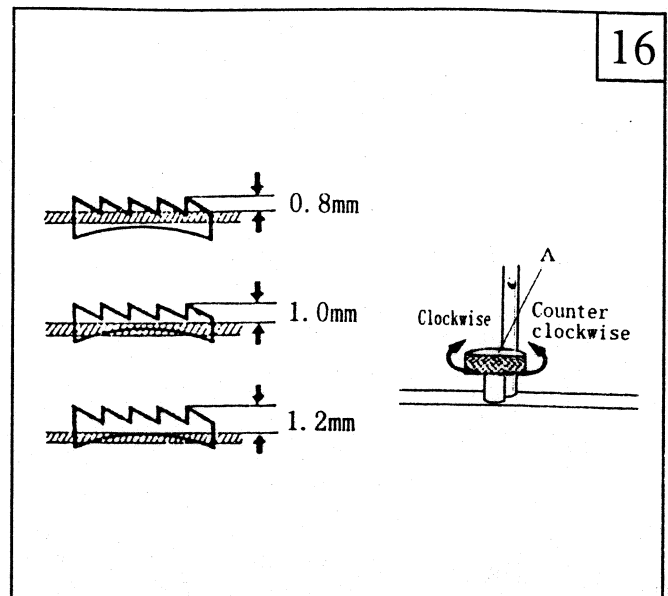
d. Tighten the screw A.

### 8. Adjusting the height of feed dog and the pressure of presser bar (Fig. 16)

In order to fit sewing on different materials, the height of feed dog and pressure of presser bar should be adjusted. Sewing on thin material, if the height of feed dog is too high or pressure of presser bar is strong, the material will be damaged; sewing on heavy material, if the height of feed dog is too low or pressure of presser bar is too weak, the stitch will not be regular.

Thin material	0.8mm
common material	1.0mm
heavy material	1.2mm

The height of feed dog is the height between the feed dog and needle plate when the feed dog is lift up to its highest position.



16

### 9. Adjusting the position of hook and needle (Fig. 17)

#### ① Adjusting the position of hook and needle

Lift the needle up to 2mm away from its lowest position, the correct position between the hook and needle: the hold of needle is 1.6mm lower than the tip of hook; the tip of hook is straight to the needle groove; there is a 0.05mm clearance between the tip of the hook and the needle groove.

#### (1) Adjusting the needle position

- Turn the balance wheel by hand to lift the needle bar up to 2mm away from its lowest position
- Loosen the screw A
- Move the needle bar upper and lower to make the hold of needle is 1.6mm lower than the tip of hook.
- Tighten the screw A after adjustment.

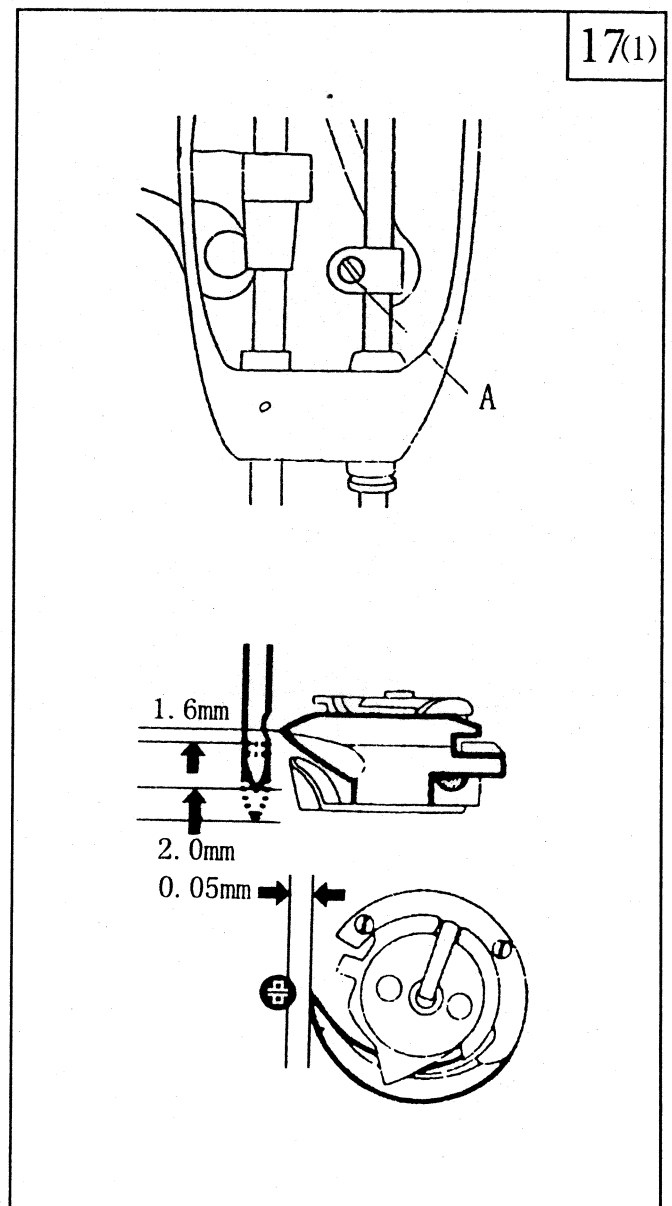
#### (2) Adjusting the position of tip of the hook

- Put away the sliding plate and needle plate
- Put down the machine head ahead
- Take off the small oil reservoir
- Loosen the screw I and gearing screw H (Shown as Fig. 19)
- Turn the balance wheel by hand to lift the needle up to 2mm away from its lowest position.
- Move the tip of hook to make it front to the center of the needle groove.
- Tighten the screw I and gearing screw H after adjustment.
- Put up the small oil reservoir.

#### ② Install and uninstall the hook

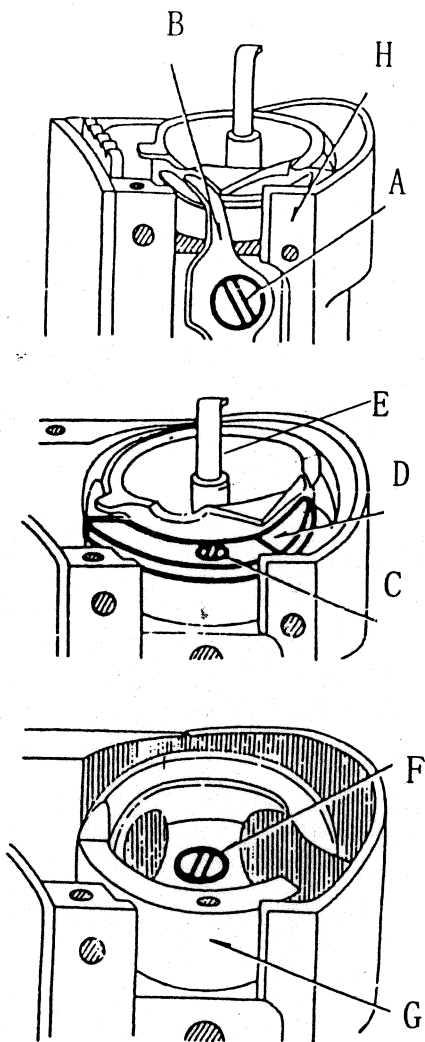
##### (1) Uninstall the hook

- Turn the balance wheel to lift the needle bar to its highest position.
- Take off the sliding plate, needle plate and bobbin.
- Take off the front cover H
- Loosen the screw A, and take out the thread separator



17(1)

17(2)



B.

e. Take off the screw C, and take out the presser plate D.

f. Take out the hook head E.

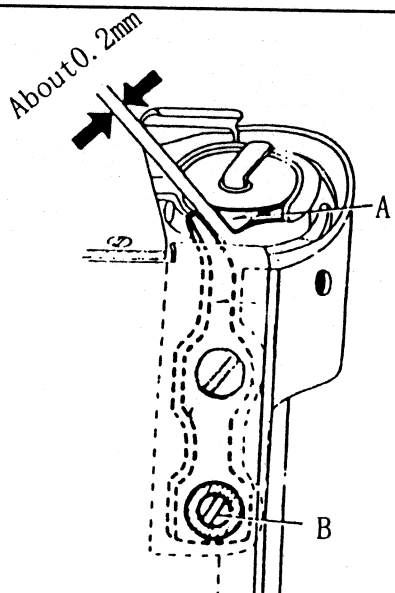
g. Loosen set screw F, take out the hook G.

(2) Install the hook

a. Install the hook in the reverse order of uninstall.

B. Attention should be given to the hook which direction of installing is as of uninstalling.

18



10. The relation between the hook and hook thread separate bracket (Fig. 8)

(1) Take off the sliding plate and front cover for post bed.

(2) Turn the balance wheel until the largest clearance between the hook and the thread separate bracket appeared.

(3) Loosen the screw B to make the clearance become 0.2mm. (Adjust according to the thread).

(4) Tighten the screw B after the adjustment.

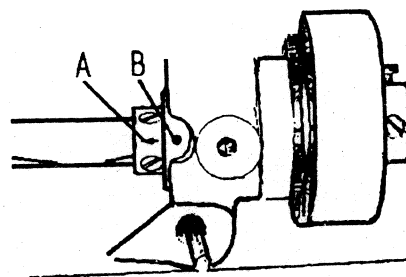
### 11. Adjusting the position of feed dog and needle (Fig.19)

19

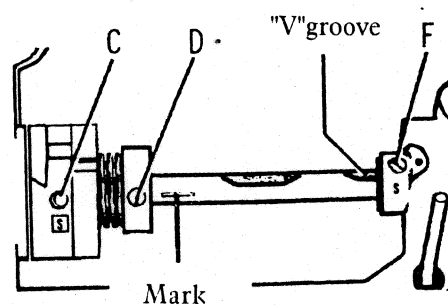
Turn the balance wheel to make the thread take-up lever lift up to its highest position, the arrow A on the rear bushing and the red mark are on one line, as fig <A>; Set the screw F into the "V" groove, and tighten it.

The hold <C>, screw D and the mark on the lower shaft are on one line, as fig. <B>

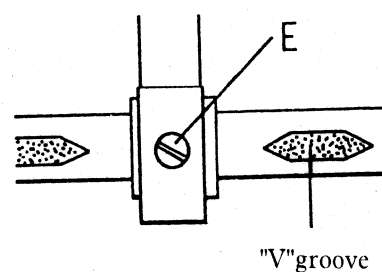
The screw <E> on the lifting cam is straight with the "V" groove as fig. <C>.



(A)



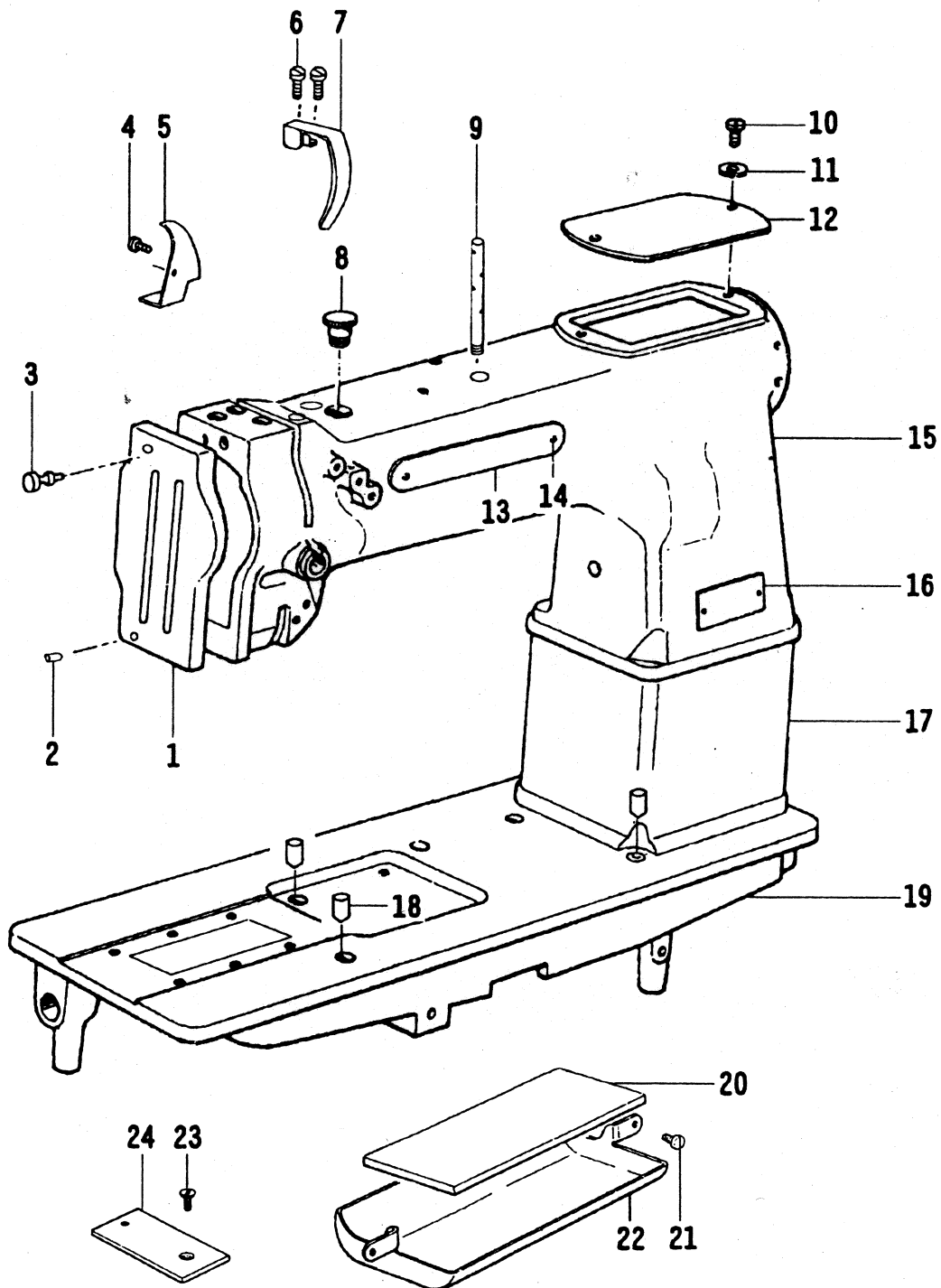
(B)



(C)

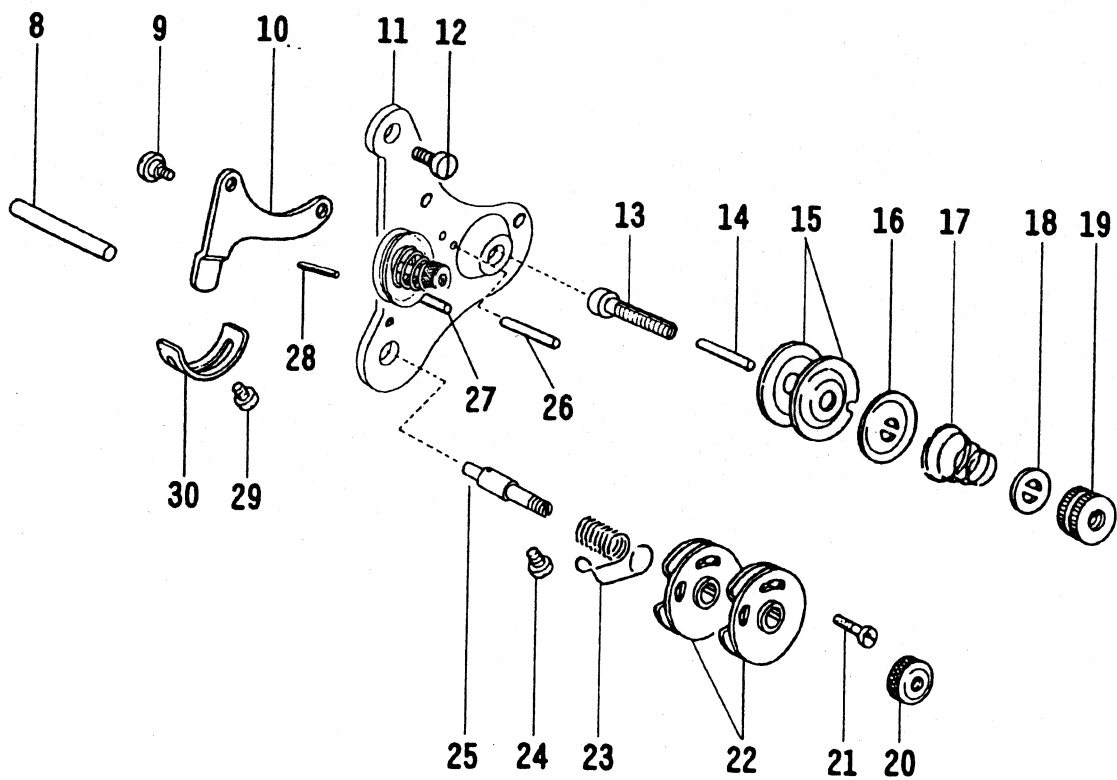
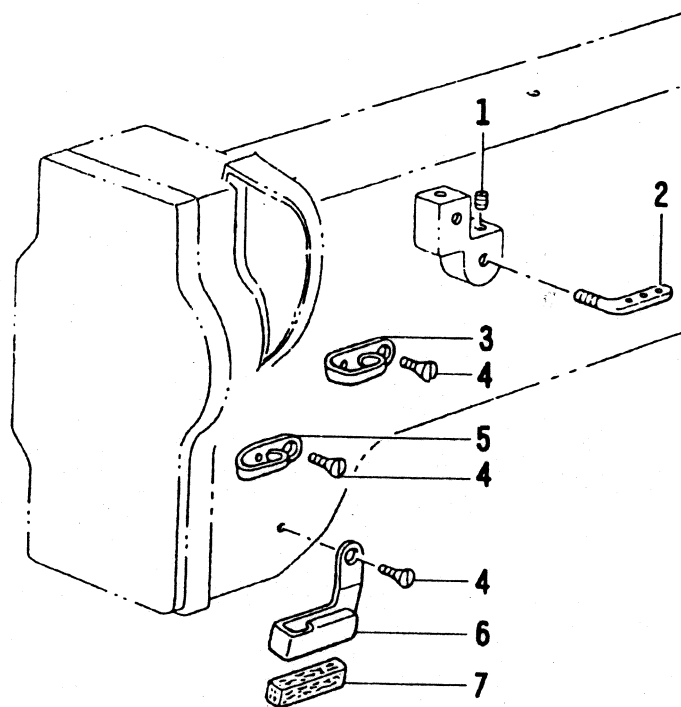
# **Parts catalogue**

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# 1.Arm

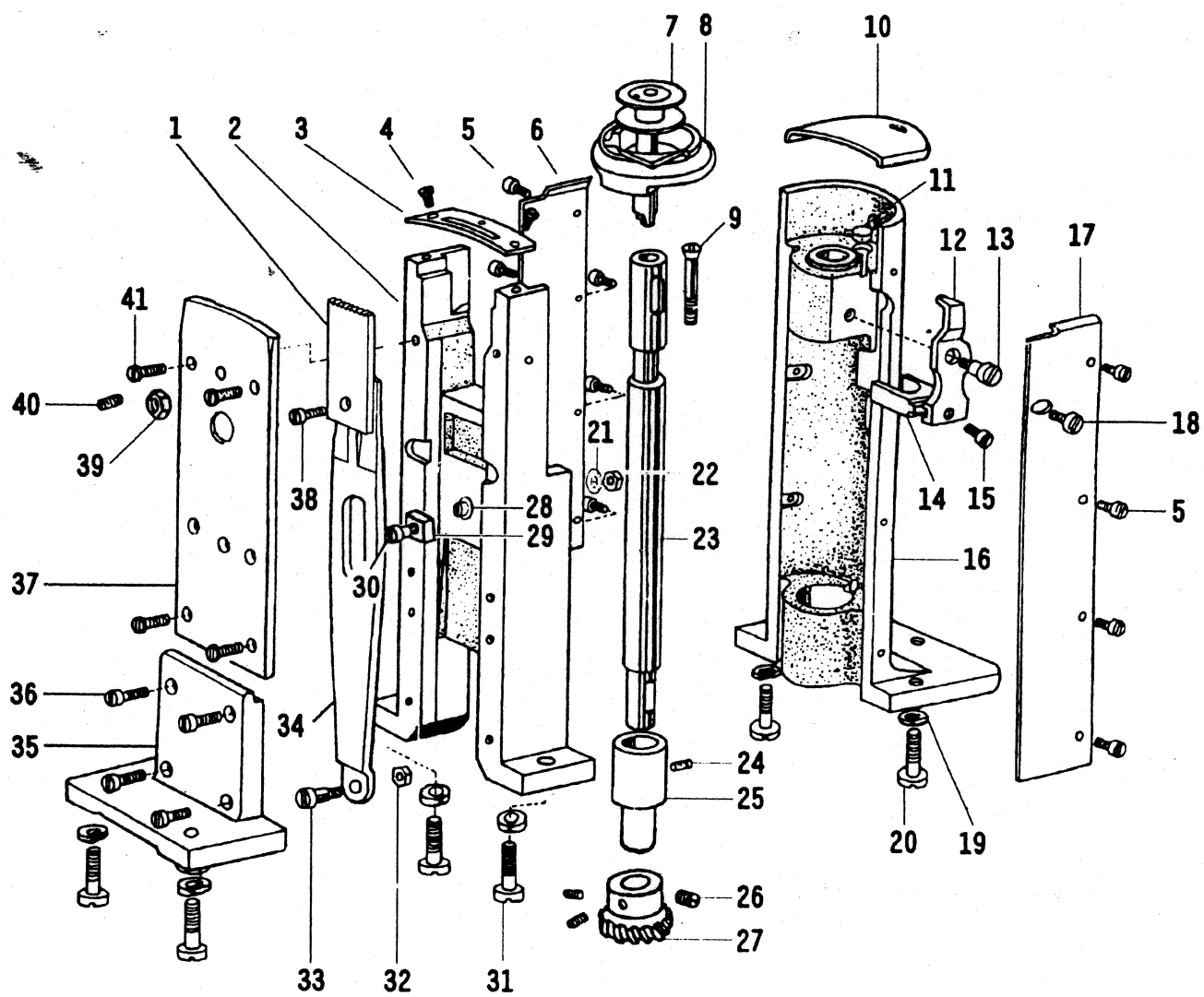
NO.	Name	Quantity		Note
		Single needle	Twin needle	
1	Face plate	1	1	
2	Face plate position pin	1	1	
3	Face plate screw	1	1	
4	Screw	1	1	
5	Oil shield plate	1	1	
6	Screw	2	2	
7	Thread take-up lever guard	1	1	
8	Rubber plug	1	1	
9	Thread guide bar	1		
	Thread guide bar		1	
10	Screw	1	1	
11	Washer	1	1	
12	Upper cover	1	1	
13	Model plate	1	1	
14	Nail	4	4	
15	Arm	1	1	
16	Trade mark	1		
	Trade mark		1	
17	Connector	1	1	
18	Oil cup	3	3	
19	Bed	1	1	
20	Oil felt	1	1	
21	Screw	2	2	
22	Small oil reservoir	1	1	
23	Screw	1	1	
24	Cover	1	1	





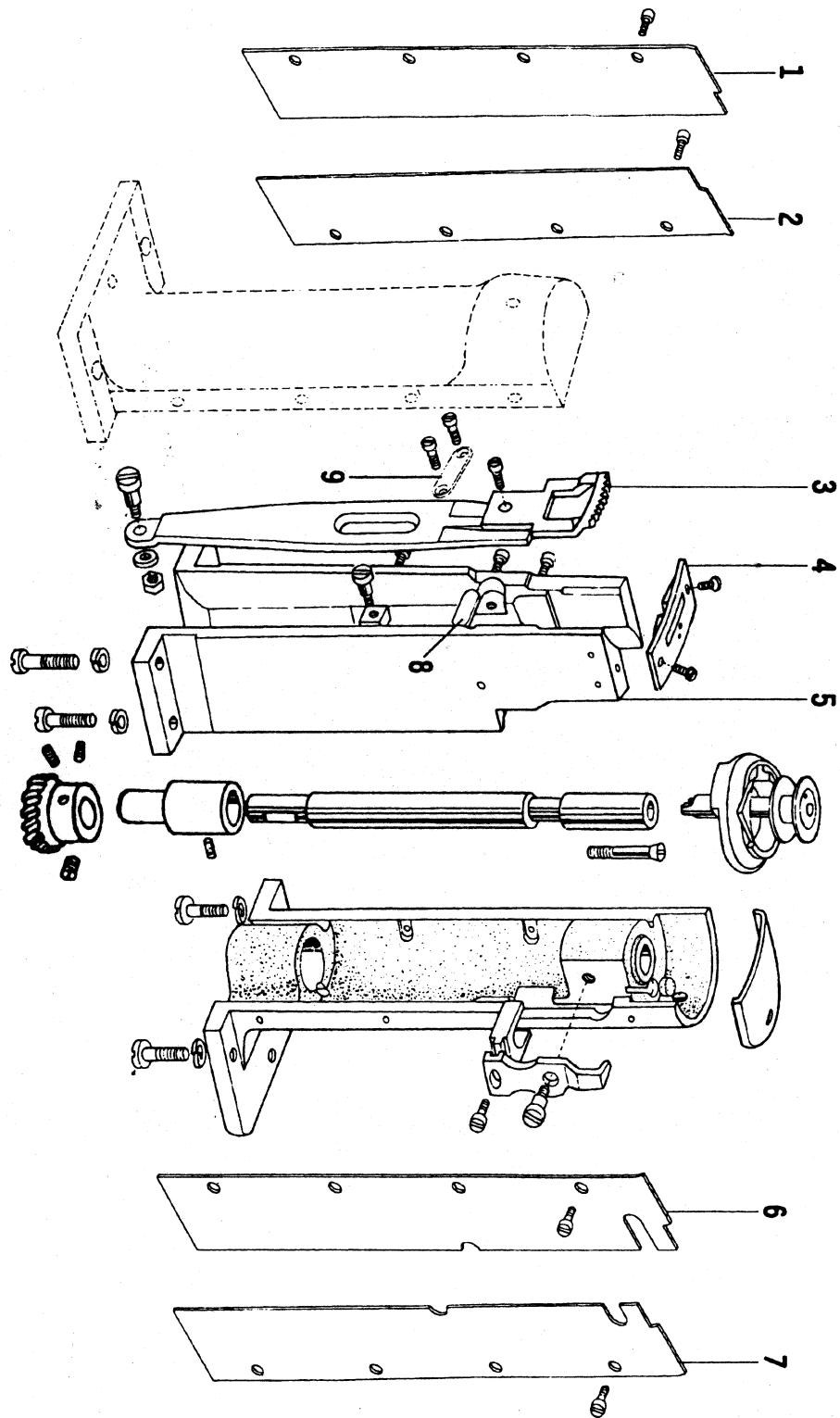
## 2.Thread tension

NO.	Name	Quantity		Note
		Single needle	Twin needle	
1	Screw	1	2	
2	Three hold thread guide	1	2	
3	Thread guide(upper)	1	1	
4	Screw	3	3	
5	Thread guide(middle)	1		
	Thread guide(middle)		1	
6	Thread guide(lower)	1		
	Thread guide(lower)		1	
7	Oil felt	1	1	
8	Thread release lever rob	1	1	
9	Screw	2	2	
10	Thread release lever	1	1	
11	Tension plate	1		
	Tension plate		1	
12	Screw	1	1	
13	Screw	1	2	
14	Thread tension release pin(short)		1	
15	Thread tension disc	2	4	
16	Thread release disc	1	2	
17	Spring	1	2	
18	Stop disc	1	2	
19	Nut	1	2	
20	Nut	1	1	
21	Screw	1		
	Screw		1	
22	Thread check disc complete	1	2	
23	Thread take-up spring	1		
	Thread take-up spring		1	
24	Screw	1	1	
25	Thread take-up spring pin	1		
	Thread take-up spring pin		1	
26	Thread separator pin(long)	1	1	
27	Thread separator pin(short)	1	1	
28	Thread release pin(long)	1	1	
29	Screw	1	1	
30	Position plate	1	1	



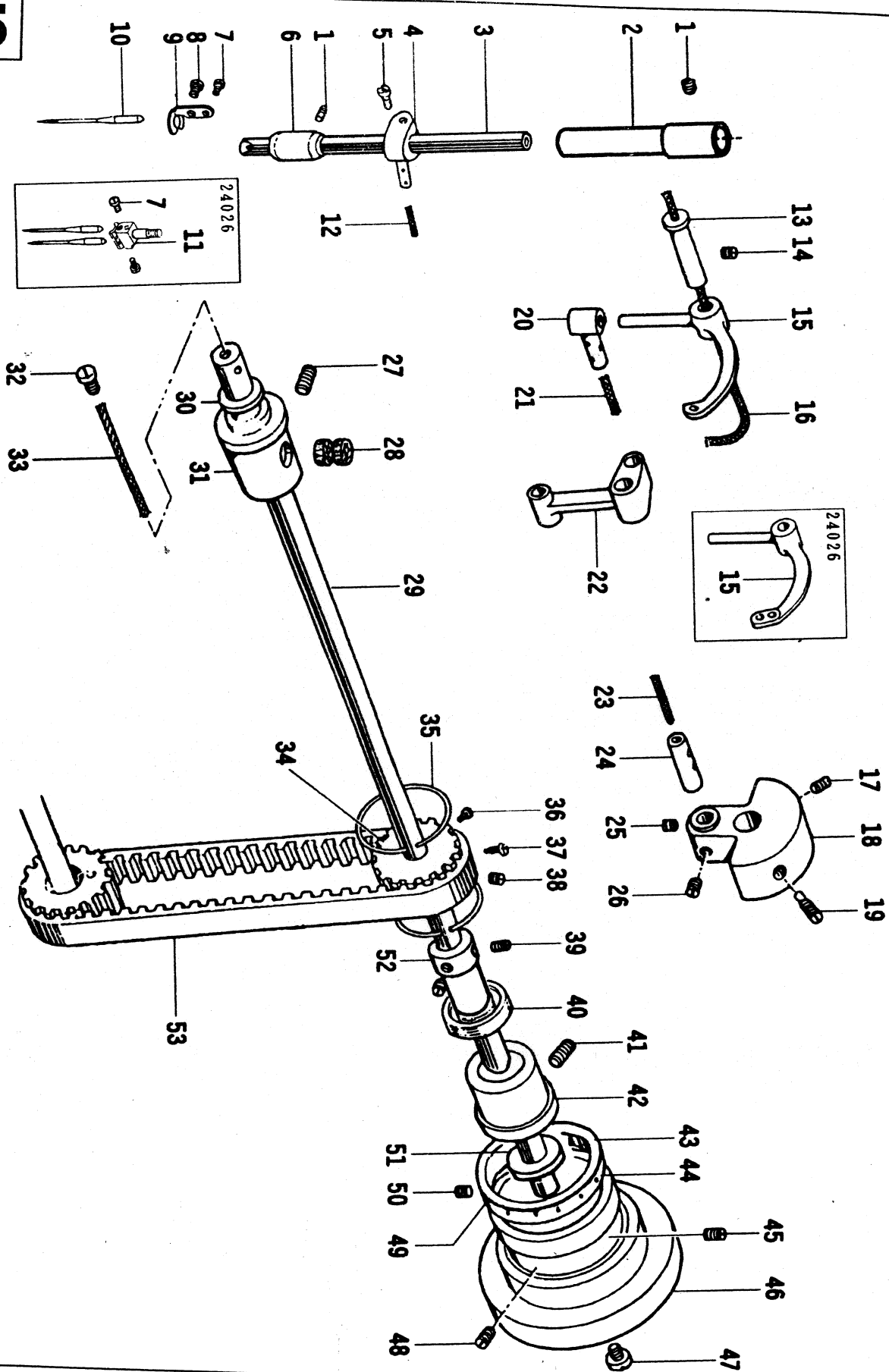
### 3.Post bed

NO.	Name	Quantity		Note
		Single needle	Twin needle	
1	Feed dog	1		
	Feed dog		1	
2	Post-bed for feed	1		
	Post-bed for feed		1	
3	Needle plate	1		
	Needle plate		1	
4	Screw	2	2	
5	Screw	8	16	
6	Back cover	1		
7	Bobbin	1	2	
8	Rotating hook	1		
	Rotating hook		2	
9	Screw	1	2	
10	Slide plate	1	2	
11	Oil felt	1	2	
12	Thread separator	1	2	
13	Screw	1	2	
14	Thread separator bracket	1	2	
15	Screw	1	2	
16	Post-bed for hook shaft	1	2	
17	Front cover	1		
18	Screw	1	3	
19	Washer	6	8	
20	Screw	4	4	
21	Washer	1	1	
22	Nut	1	2	
23	Rotating hook shaft	1	2	
24	Screw	1	2	
25	Bushing	1	2	
26	Screw	3	6	
27	Gear	1	2	
28	Feed plate slide shaft	1	1	
29	Slide block	1	2	
30	Screw	1	2	
31	Screw	2	4	
32	Nut	1	2	
33	Screw	1	2	
34	Feed plate	1	2	
35	Support block	1		
36	Screw	4		
37	Presser plate	1		
38	Screw	1		
39	Nut	1		
40	Screw	1		
41	Screw	4		



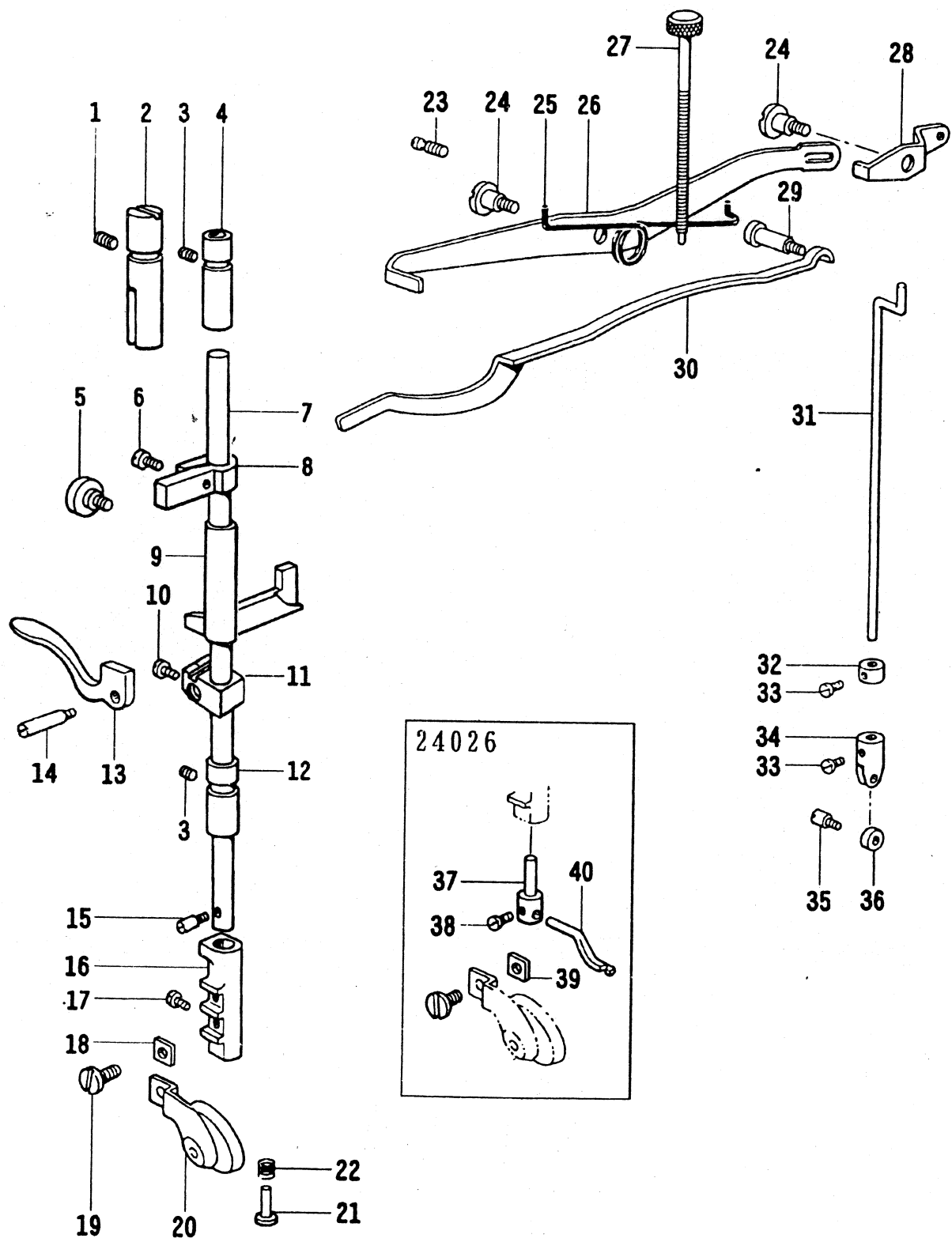
#### 4. Post bed for twin needle

NO.	Name	Quantity		Note
		Single needle	Twin needle	
1	Back cover(left)		1	
2	Back cover(right)		1	
3	Feed dog		1	
4	Needle plate		1	
5	Post bed		1	
6	Front cover(left)		1	
7	Front cover(right)		1	
8	Oil felt		1	
9	Presser plate		1	



## 5.Upper shaft and needle thread take-up

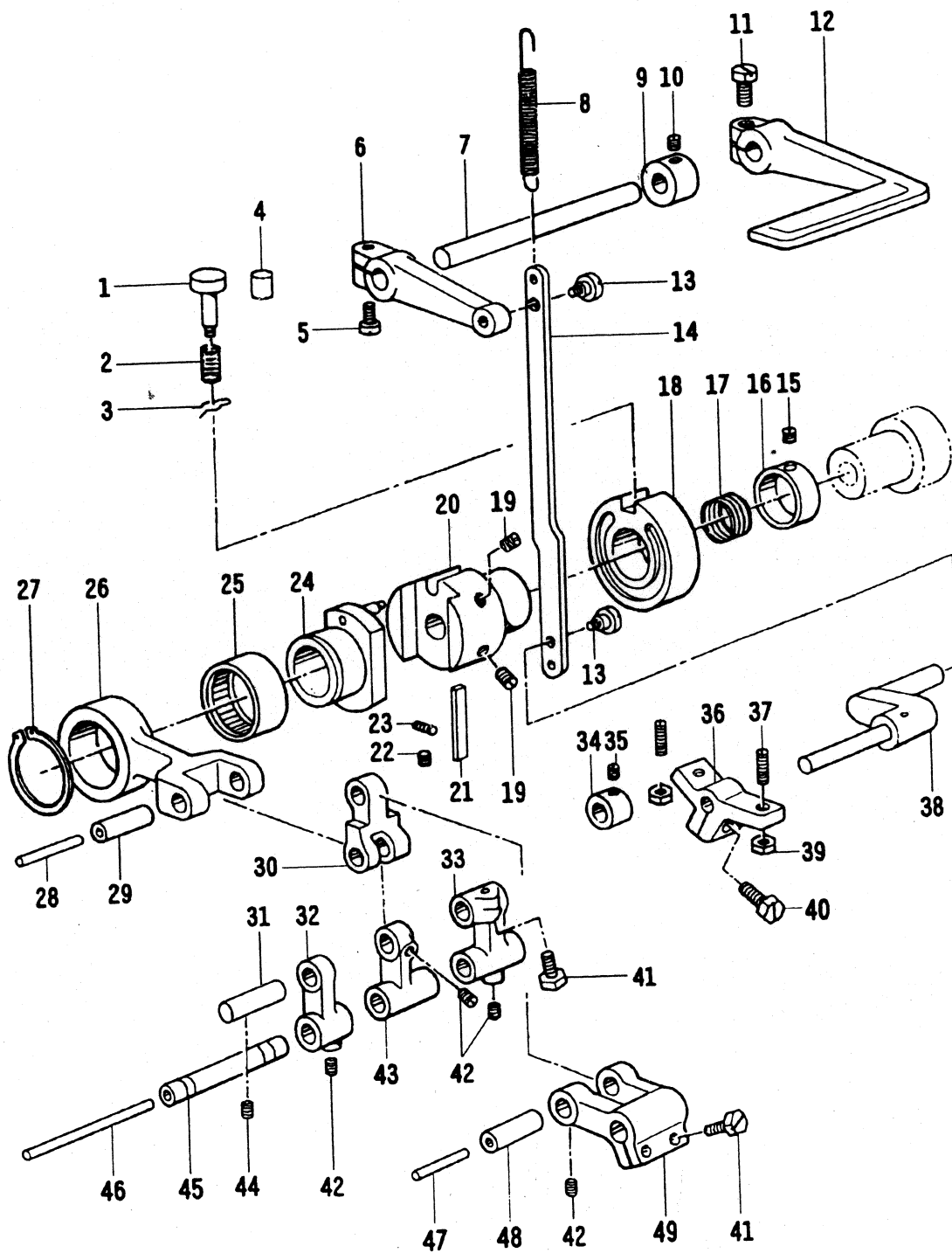
NO.	Name	Quantity		Note
		Single needle	Twin needle	
1	Screw	2	2	
2	Bushing(upper)	1	1	
3	Needle bar	1		
	Needle bar		1	
4	Needle bar adaptor	1	1	
5	Screw	1	1	
6	Bushing(lower)	1	1	
7	Screw	1		
	Screw		2	
8	Screw	1	1	
9	Needle bar thread guide	1	1	
10	Needle	1	2	
11	Needle holder		1	
12	Felt	1	1	
13	Pin	1	1	
14	Screw	1	1	
15	Tread take-up lever	1		
	Tread take-up lever		1	
16	Oil wick	1	1	
17	Screw	1	1	
18	Needle bar crank	1	1	
19	Screw	1	1	
20	Slide block	1	1	
21	Wick	1	1	
22	Needle bar link	1	1	
23	Oil wick	1	1	
24	Pin for needle bar crank	1	1	
25	Screw	1	1	
26	Screw	1	1	
27	Screw	1	1	
28	Oil felt	2	2	
29	Upper shaft	1	1	
30	Washer	1	1	
31	Front bushing	1	1	
32	Screw	1	1	
33	Oil wick	1	1	
34	Synchronized pulley	1	1	
35	SD ring	2	2	
36	Screw	1	1	
37	Screw(long)	1	1	
38	Screw(short)	1	1	
39	Screw	2	2	
40	Bearing	1	1	
41	Screw	1	1	
42	Rear bushing	1	1	
43	Stitch length ring	1	1	
44	Stitch length ring belt	1	1	
45	Screw	1	1	
46	Balance wheel	1	1	
47	Screw	1	1	
48	Screw	1	1	
49	Nail	3	3	
50	Screw	1	1	
51	Retaining ring	1	1	
52	Bushing	1	1	
53	Synchronous belt	1	1	





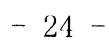
## 6.Presser foot lifter

NO.	Name	Quantity		Note
		Single needle	Twin needle	
1	Screw	3	3	
2	Position guide	1	1	
3	Screw	2	2	
4	Bushing(upper)	1	1	
5	Screw	1	1	
6	Screw	1	1	
7	Presser bar	1	1	
8	Position guide bracket	1	1	
9	Bushing	1	1	
10	Screw	1	1	
11	Spring bracket	1	1	
12	Bushing(lower)	1	1	
13	Presser bar lifer	1	1	
14	Presser bar lifer shaft	1	1	
15	Position pin	1	1	
16	Bushing	1	1	
17	Screw	2	2	
18	Washer	1	1	
19	Screw	1	1	
20	Roller complete	1	1	
21	Spring pin	1		
22	Spring	1		
23	Screw	1	1	
24	Screw	2	2	
25	Spring	1	1	
26	Knee lifting lever	1	1	
27	Screw	1	1	
28	Knee lifting crank	1	1	
29	Screw	1	1	
30	Presser bar spring plate	1	1	
31	Lifting lever connecting rod	1	1	
32	Bushing	1	1	
33	Screw	1	1	
34	Lifting lever connecting rod joint	1	1	
35	Screw	1	1	
36	Slide wheel	1	1	
37	Support		1	
38	Screw		1	
39	Washer		1	
40	Presser foot		1	



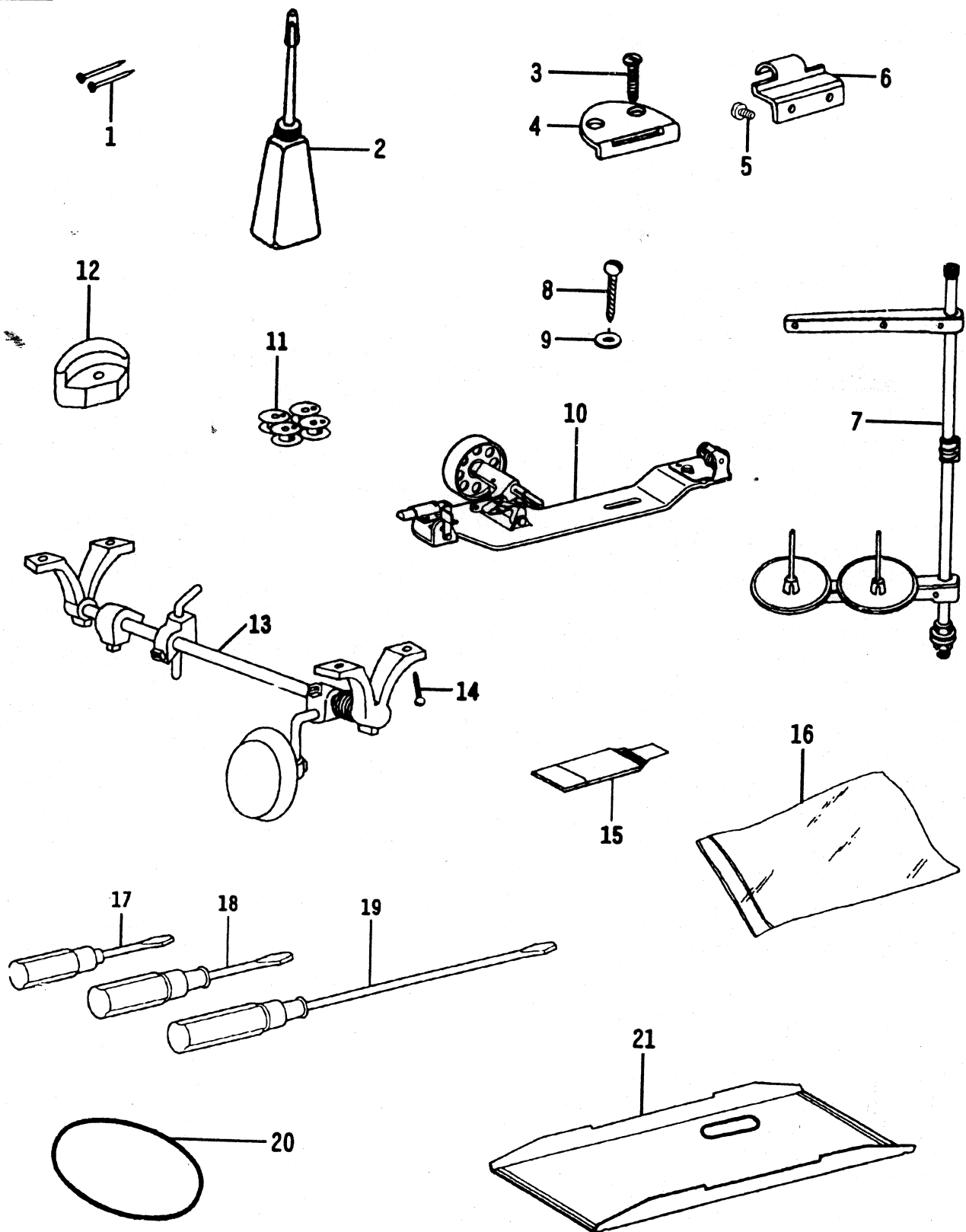
## 7.Reverse feed

NO.	Name	Quantity		Note
		Single needle	Twin needle	
1	Button	1	1	
2	Spring	1	1	
3	Spring clamp	1	1	
4	Rubber plug	2	2	
5	Screw	1	1	
6	Crank	1	1	
7	Reverse feed shaft	1	1	
8	Spring	1	1	
9	Ring	1	1	
10	Screw	1	1	
11	Screw	1	1	
12	Reverse feed lever	1	1	
13	Screw	2	2	
14	Reverse feed link	1	1	
15	Screw	2	2	
16	Collar	1	1	
17	Spring	1	1	
18	Eccentric adjusting dial	1	1	
19	Screw	2	2	
20	Adjusting block	1	1	
21	Adjusting slice	1	1	
22	Screw	2	2	
23	Screw	2	2	
24	Feed cam	1	1	
25	Bearing	1	1	
26	Forked link	1	1	
27	Ring	1	1	
28	Oil wick	1	1	
29	Connecting pin	1	1	
30	Forked link	1	1	
31	Pin(left)	1	1	
32	Link(left)	1	1	
33	Link(right)	1	1	
34	Collar	1	1	
35	Screw	2	2	
36	Crank	1	1	
37	Screw	2	2	
38	Shaft	1	1	
39	Nut	2	2	
40	Screw	1	1	
41	Screw	1	1	
42	Screw	3	3	
43	Link(middle)	1	1	
44	Screw	1	1	
45	Pin	1	1	
46	Oil wick	1	1	
47	Oil wick	1	1	
48	Connecting pin	1	1	
49	Crank	1	1	



## 8.Lower shaft

NO.	Name	Quantity		Note
		Single needle	Twin needle	
1	Bushing(front)	1	1	
2	Oil felt	1	1	
3	Screw	2	2	
4	Lifting cam	1	1	
5	Screw	1	1	
6	Gear	1	2	
7	Screw	1	2	
8	Screw	1	2	
9	Bushing(middle)	1	1	
10	Oil wick	1	1	
11	Screw	1	1	
12	Lower shaft	1	1	
13	Screw	1	1	
14	Oil felt	1	1	
15	Fork	1	1	
16	Feed dog bracket	1	1	
17	Washer	1	1	
18	Screw	3	3	
19	Bushing(rear)	1	1	
20	Screw	3	3	
21	Screw	1	1	
22	Screw	1	1	
23	Bushing	1	1	
24	Bearing	1	1	
25	Ring	1	1	
26	Retainer	2	2	
27	Synchronized pulley	1	1	
28	Screw	2	2	
29	Block	2	2	
30	Screw	2	2	
31	Screw	1	1	
32	Bushing	2	2	
33	Screw	4	4	
34	Collar	2	2	
35	Screw	1	1	
36	Nut	1	1	
37	Feed crank	1	1	
38	Shaft	1	1	
39	Rubber plug	2	2	
40	Screw	1	1	
41	Feed shaft	1	1	



## 9. Accessory

NO.	Name	Quantity		Note
		Single needle	Twin needle	
1	Nail	8	8	
2	Oil pot	1	1	
3	Screw(1)	4	4	
4	Hinge(1)	2	2	
5	Screw(2)	4	4	
6	Hinge(2)	2	2	
7	Thread holder	1		
	Thread holder		1	
8	Wooden screw	2	2	
9	Washer	2	2	
10	Thread winder	1	1	
11	Bobbin	4	8	
12	Cushion	4	4	
13	Knee lifter complete	1	1	
14	Wooden screw	4	4	
15	Needle	1	1	
16	Parts bag	1	1	
17	Screwdriver(small)	1	1	
18	Screwdriver	1	1	
19	Screwdriver(big)	1	1	
20	Belt	1	1	
21	Oil reservoir	1	1	