

PREMIER SERIES

BY



P1255RBL-18

P2339RBL-18

CONTENTS

Operation instruction

1. Brief introduction	1
2. Main specifications	1
3. Machine installation and operation preparation	1
1. Machine installation.....	1-3
2. Operation preparation and notice before running	3-4
4. Machine operation	5-6
1. Coordination among needle, thread and materials.....	5
2. Install the needle	5
3. Winding the bobbin thread	5-6
5. Machine adjustment	6-9
1. Adjust the needle thread tension and bobbin thread tension.....	6-7
2. Adjust the pressure of presser foot	7
3. Adjust the safety clutch device	7-9

Parts manual

1. P2339RBL-18 machine casting components	10-13
2. P1255RBL-18 machine casting components	14-17
3. Upper shaft and presser foot components	18-19
4. Needle bar and lower feed components.....	20-23
5. Lower shaft thread looping components.....	24-25
6. Stitch length adjustment components.....	26-27
7. Knee lifter and winding components	28-29
8. Lubrication components	30-31
9. Accessories.....	32-33

Operation instruction

Brief introduction

Consew P2339RBL-18 adopts a straight double needle and two vertical auto-lubricating hooks for thread looping, and a sliding thread take up lever to form two lines of lockstitch seams. The upper and lower shafts are supported by needle bearings and driven by a toothed belt, plunger oil pump lubrication system, compound feed mechanism of feed dog, walking foot and needle, so even if for long stitch length or sewing long materials, it can deal with them freely.

P1255RBL-18 sewing machine adopts a single straight needle and vertical auto-lubricating hook for thread looping. It has all of the advantages of P2339RBL-18.

Both models are widely used in factories to sew suitcases, tents, cushions, leather goods, apparel, mats, etc.

Machine installation

1. Machine installation

1.1 Location of the machine

The machine must be located on the rigid and flat floor for ensuring its smooth operation and reducing its vibration. Meanwhile, a rubber mat should be inserted between the machine stand and the floor for further reducing the running noise.

1.2 Install the oil pan (Fig. 1)

Put the oil pan into the table cutout and place the four cushions on the four corners of the cutout, finally fix the cushion and oil pan on the table by nail.

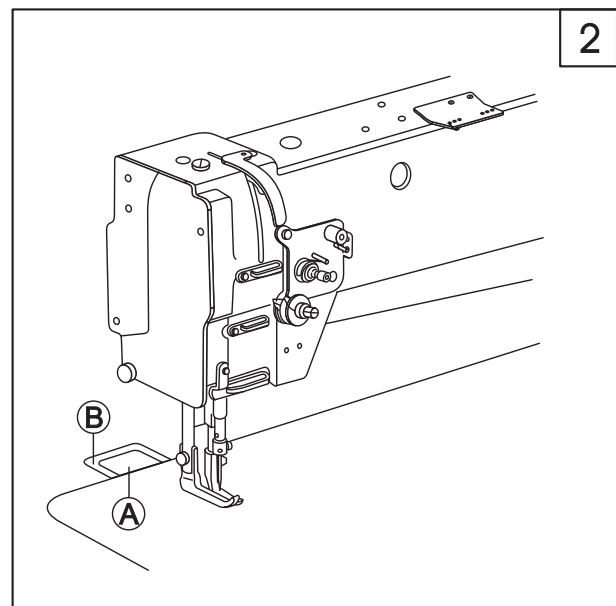
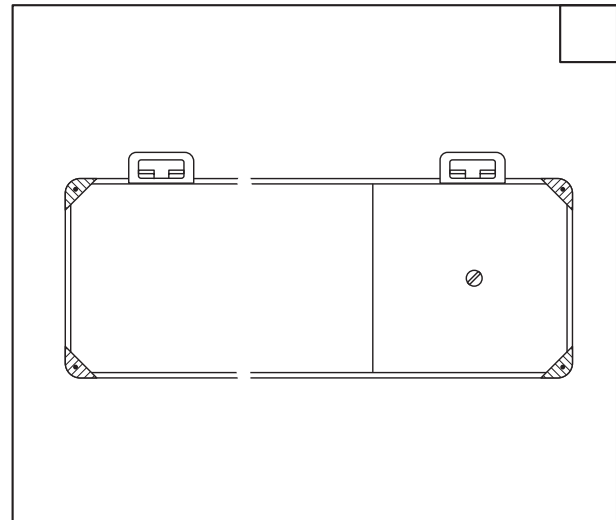
1.3 Install the machine head (Fig. 2)

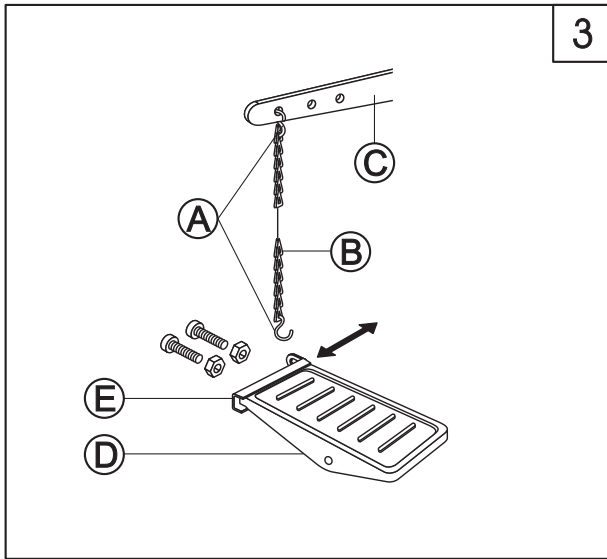
Make the hinge A of machine head engaged with hinge socket B on the table, then turn the machine head till it is seated on the frame of table cutout, please keep the turning freely.

Main specifications

Model	P2339RBL-18	P1255RBL-18
Applications	Medium and heavy weight materials	
Max. Sewing speed	1200s.p.m	
Max. Stitch length	9mm	
Needle bar stroke	36mm	
Presser foot lift height	8mm by hand	
	More than 16mm by pedal	
Hook	Large vertical auto-lubricating hook	
Needle	DP×17 Nm125~180	
Needle gauge	6.4mm (standard)	
Lubrication	Auto-lubricating	

Special needle gauge available (mm):3.2,4,4.8,8,9.5,12.7,16,19,25.4.

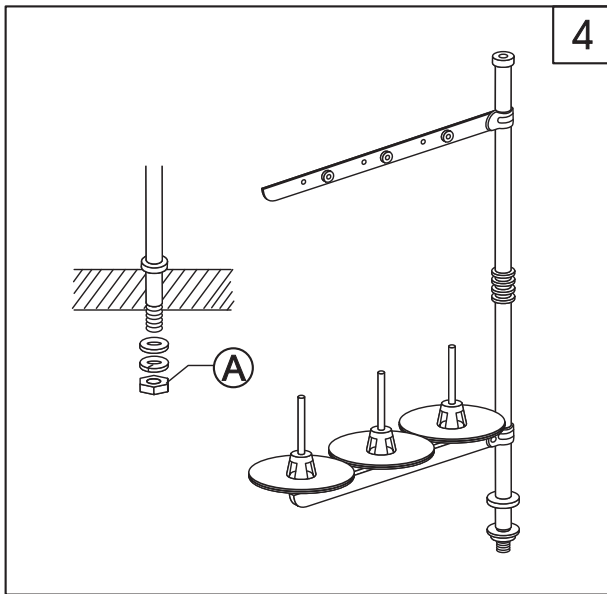




1.4 Install the presser foot lifting controller (Fig. 3)

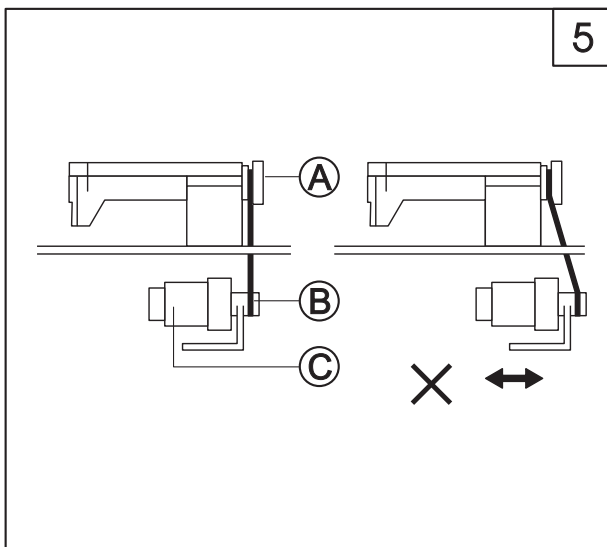
First connect the chain B with presser foot lift lever C by hooks A, then install the pedal assembly D on the rung of the stand, move the controller E leftward or rightward to make the chain in one line, fix it with bolt and nut, finally connect the hook with the controller E.

(An automatic presser foot lifter is also available, please refer to parts manual Part 7. "Knee lifter and winding components")



1.5 Install the thread stand (Fig. 4)

The thread stand should be located on the right backside of the table. Threading should be smooth when sewing. When the machine head is turned backward, it should not be touched with the thread stand, then tighten the nut A.



1.6 Install the motor (Fig. 5)

Move the motor C leftward or rightward to make the hand wheel belt groove A and motor pulley belt groove B run in line.

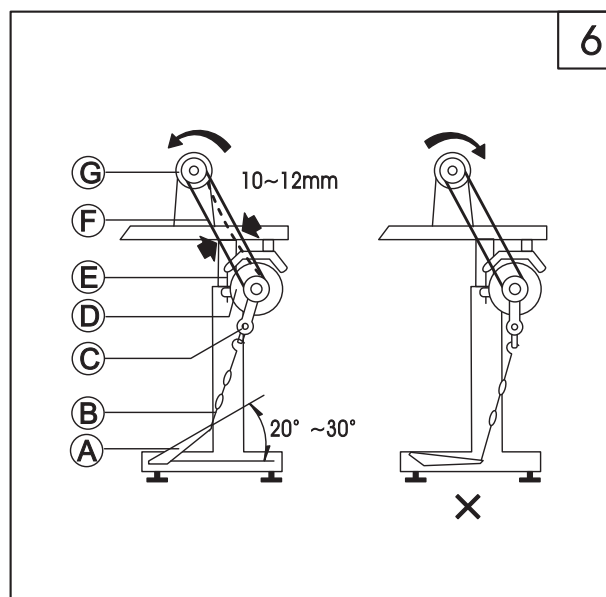
1.7 Connecting the clutch lever to the pedal (Fig. 6)

A. The optimum tilt angle of pedal against floor is approx. $20^{\circ}\sim 30^{\circ}$.

B. Adjust the clutch of motor so that the clutch lever C and draw bar B run in line.

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

D. Adjust the tension of V-belt F by moving the motor up and down. The proper tension of V-belt is a slack of $10\sim 12\text{mm}$ when the belt is depressed at the belt span by finger.



2. Operation preparation and notice before running

2.1 Clearing the machine

Before the head is packed, all of the parts of the machine are coated with anti-rust grease, meanwhile the grease can harden and the dust can cover the machine, surface during long time storage and shipment, so, the dust and grease must be cleared by clean cloth with gasoline.

2.2 Examination

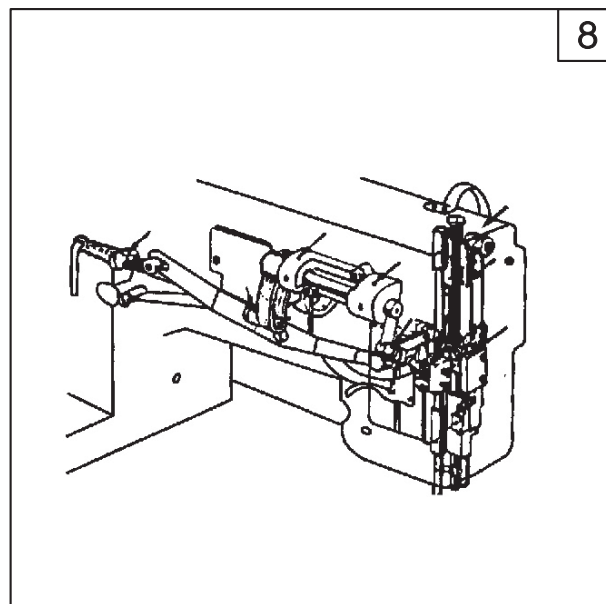
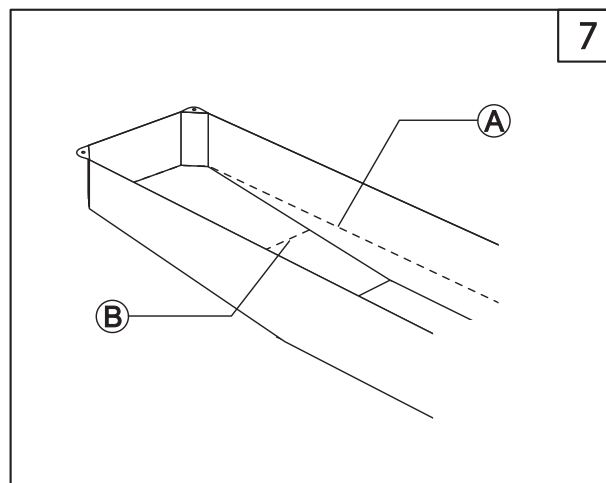
Although every machine is conformed by strict inspection and test before delivery, the parts of the machine may be loose and deformed after long distance transportation with jolt. A thorough examination must be performed. Turn the balance wheel slightly by hand to check if there is running obstruction, parts collision, uneven resistance and abnormal noise. If any of these exist, adjustment must be made accordingly before running.

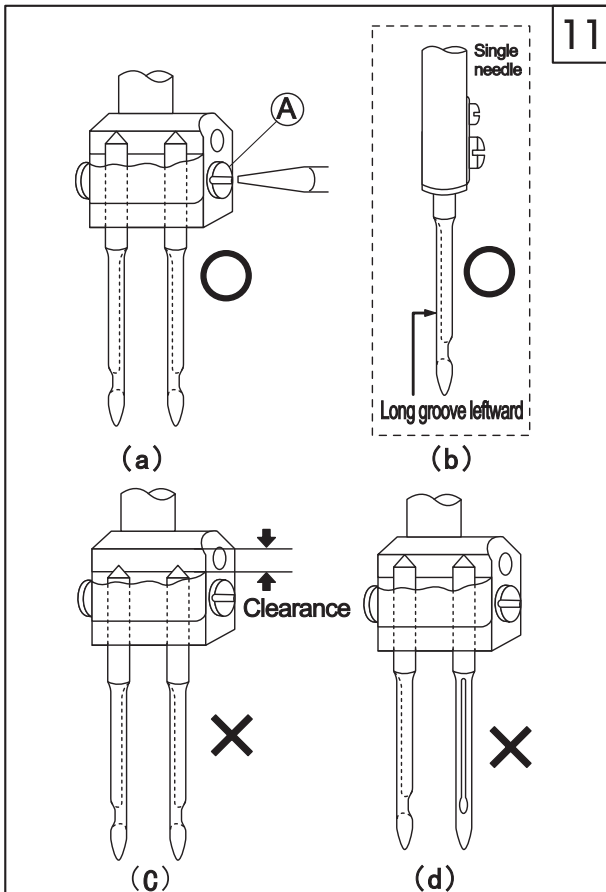
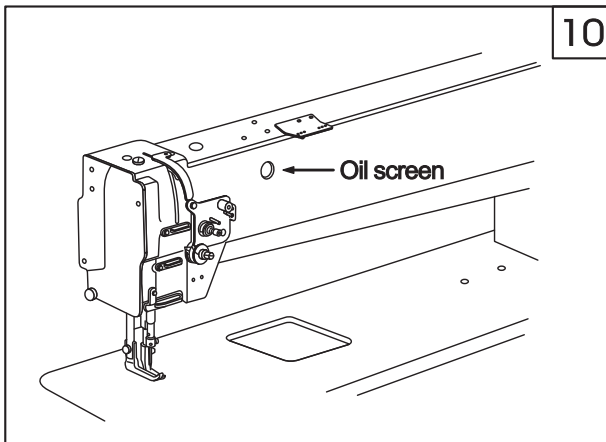
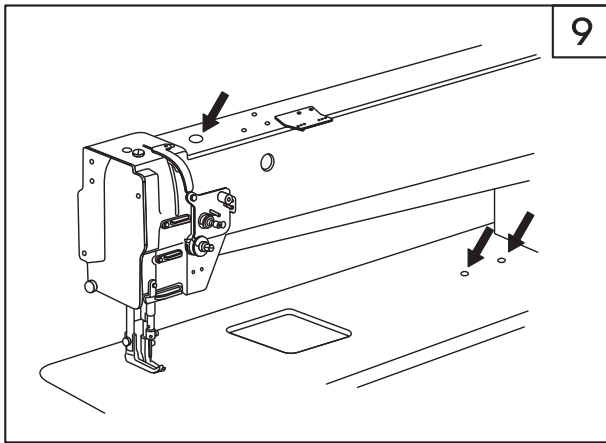
2.3 Notice before running

A. Oiling (Fig. 7)

Oil amount should be filled according to the marks in the oil pan, Mark A refers to the highest of oil amount; Mark B refers to the lowest, be careful that the oil amount should not be lower than Mark B, otherwise the machine parts can not be fed with oil and cause overheat and collision.

Please be sure to use machine oil 18# or HJ-7.





B. When the machine starts for initial time or reuse after a long time, the proper oil amount should be filled in the sections of machine shown by arrows in Fig. 8,9. When it is in operation, please observe the oil sparking in oil screen to check the oil condition.

C. When a new machine starts running, for extending its lift, please run at a medium and low speed (1000s.p.m) for about a month and then raise the speed gradually.

D. Please turn off the power when it is not in use or the operator leaves away from it.

E. Replace the oil every month, when replacing, fully drain off the old oil in the oil pan and add the new one.

F. For P2339RBL-18, the needle gauge options are: 6.4, 3.2,4,4.8,8,9.5,12.7,16,19,24.5mm. To get it, the needle plate, inner and outer presser foot, needle holder, feed dog, left and right sliding plate, thread guide should be changed, the standard needle gauge is 6.4mm, for the other needle gauge, the relevant parts can be ordered from the factory.

Machine operation

1. Coordination among needle, thread and materials

Please use needle DP×17 or 135~17, Nm125~180, the coarseness of needle should be in accordance with the nature of materials. If stitching on heavy weight materials with a slim needle, the needle will be broken easily. Needle skipping or thread breakage will also occur. On the contrary, stitch on tightly materials with a very coarse needle, the materials will be destroyed because of over-big needle hole, so the needle and thread should be properly selected.

2. Install the needle (Fig. 11)

Turn the hand wheel to lift the needle bar to its highest position, loosen the needle set screw A, fully insert the needle shank up to the bottom of needle holder, keep the long grooves of the two needles opposite with each other, then tighten the set screw as shown in Fig.(a), For single needle, keep the long groove of needle facing the left of the operator as shown in Fig.(b).

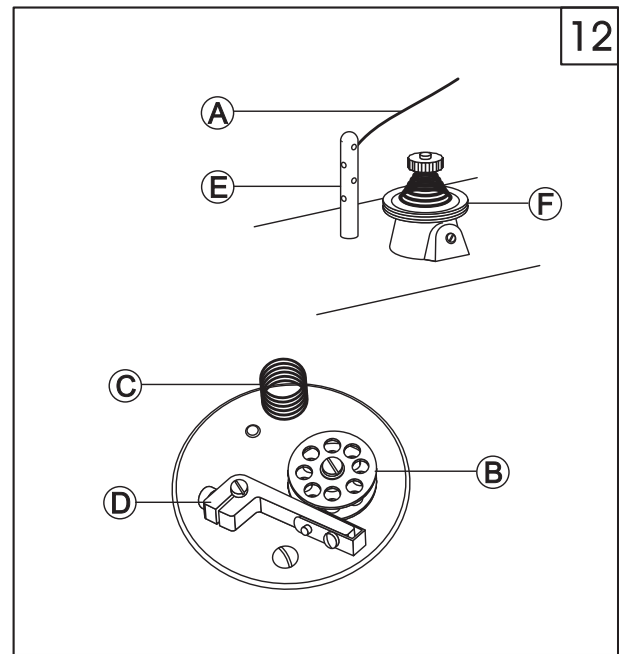
Note: Fig.(c) insufficient insertion or Fig. (D) wrong direction of needle groove is incorrect.

3. Winding the bobbin thread

3.1 The method of winding

Insert the bobbin B into winder shaft, threading the thread A to upper and lower holes of pin E, then to thread tension disc F, draw the thread tip and wind thread several circles around bobbin B, put the winding lever D into bobbin B, then it can automatic winding when sewing. (If only winding, not sewing, please lift the presser foot.)

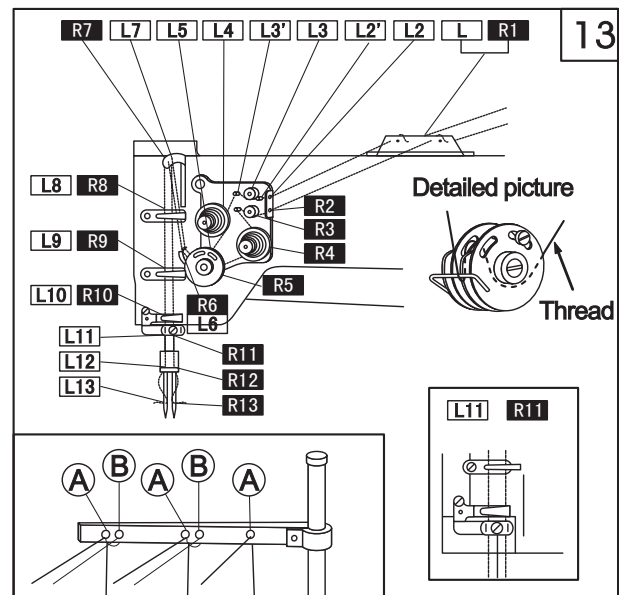
Please don't overfill the bobbin thread, otherwise the thread will loosen down from the bobbin. The optimum capacity of bobbin thread is fill about 80% of bobbin outside diameter, and this can be adjusted by screw D. After finish, thread can be cut by thread cutter shown in Fig. 12. Wind the thread A several circles around cutter C, draw the thread and the thread is cut.



3.2 Threading (Fig. 13)

A. Every thread should be drawn through thread hole A, when using light and smooth thread (polyester or long silk thread), it should be drawn through thread hole B.

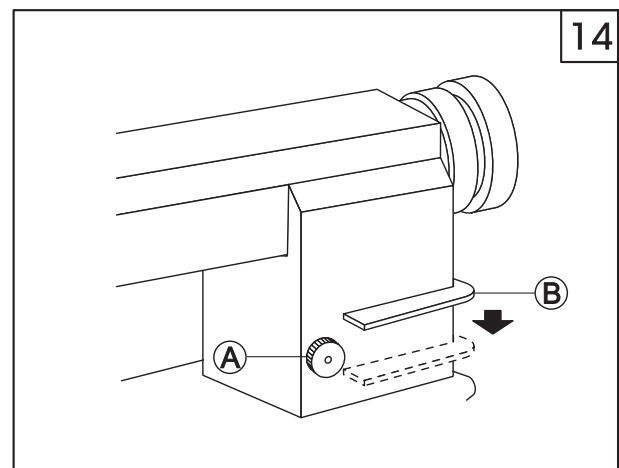
B. Keep the thread take-up lever at its highest position, threading the needle thread in the following numerical order.

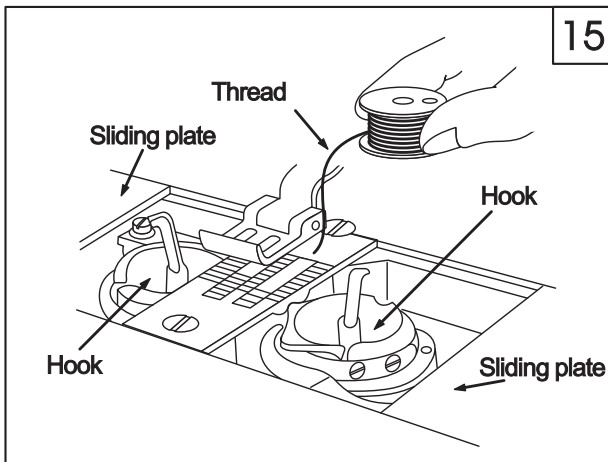


3.3 Stitch length (Fig. 14)

The stitch length can be regulated by stitch length dial A. Turn it counter-clockwise to expand its length and clockwise to shorten its length. The numbers on dial show the sizes of the stitch length in mm.

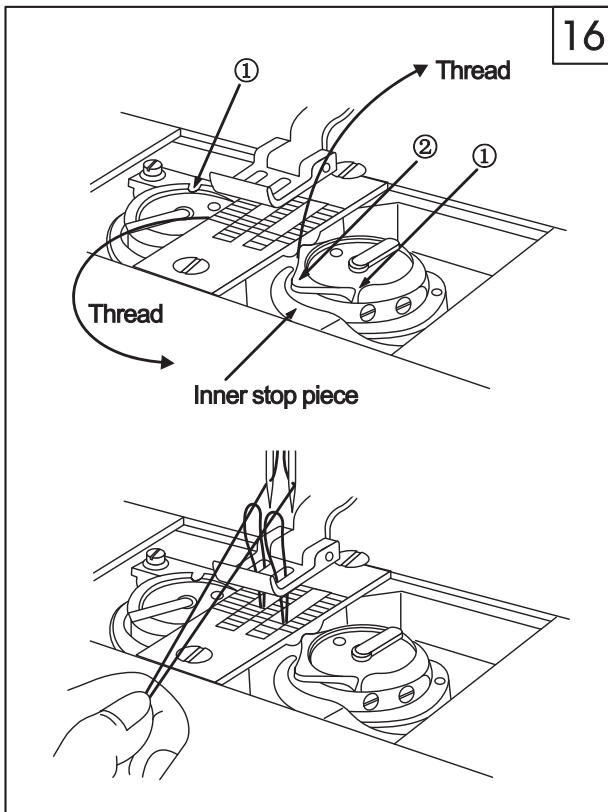
For reverse feed, press down feed lever B to perform reverse sewing. Release the lever, the feed lever can reset automatic and the forward sewing is resumed.





3.4 Placing bobbin (Fig. 15)

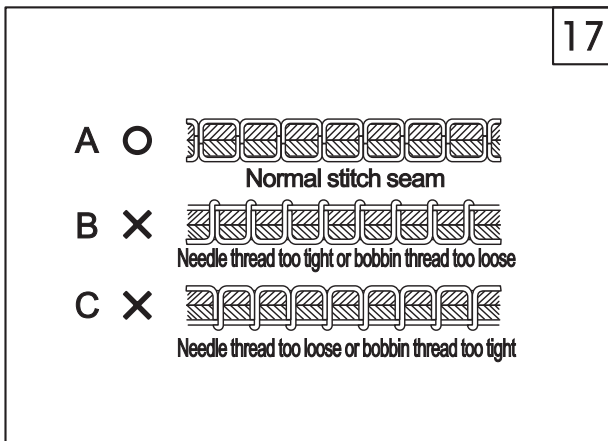
Note: when bobbin is placed into the bobbin case, the thread should be wound properly in the correct direction shown in the figure.



3.5 Drawing thread from the bobbin (Fig. 16)

A. Draw the thread end to bobbin slot ① shown in the figure, and pull it out down through the inner bobbin stop piece.

B. Hold the thread end with left hand, turn the hand wheel slowly and get the bobbin thread, then draw them a little apart from the presser foot.



Machine adjustment

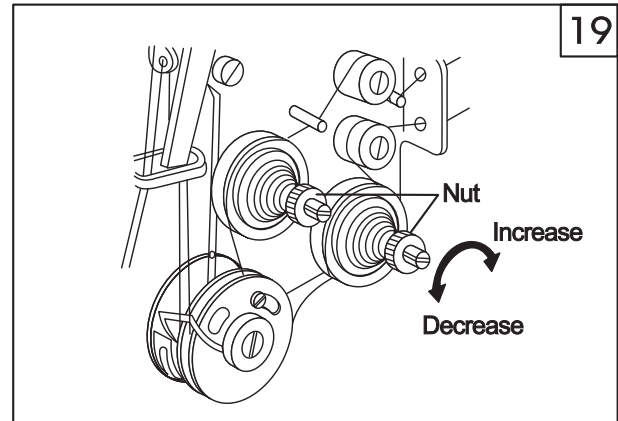
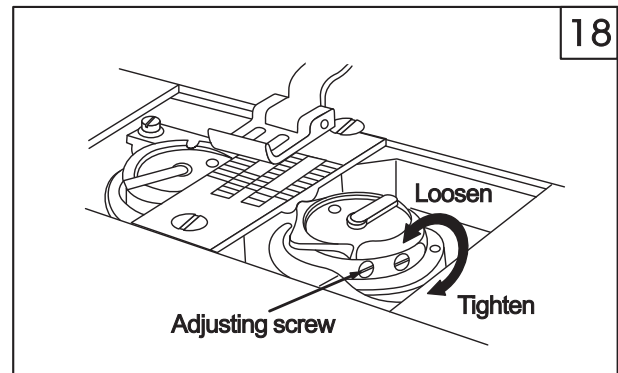
1. Adjust the needle thread tension and bobbin thread tension

All forms of stitches are shown in Fig. 20

The normal stitch of sewing machine is shown in Fig. 17A. If stitch is abnormal, the puckering and thread breakage will occur, the needle thread tension and bobbin thread tension should be adjusted so that the normal stitch can be obtained.

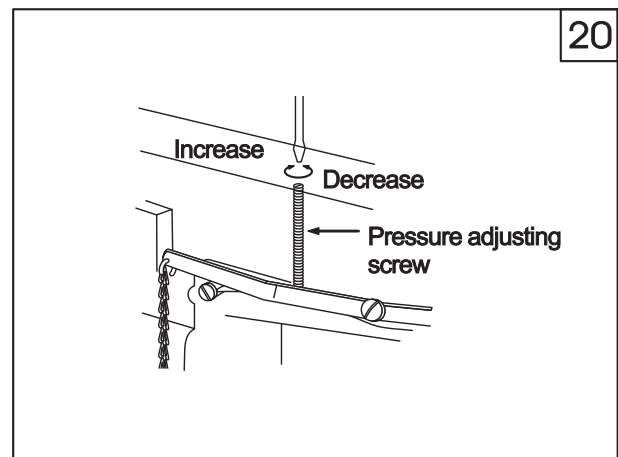
A. If the stitch seam shows as Fig. 17B, indicates that the needle thread tension is too tight or the bobbin thread tension is too loose. Please turn the thread tension nut counter-clockwise to release the needle thread pressure; or turn the bobbin lace adjusting screw with a screwdriver to increase the bobbin thread tension.(See Fig. 18,19)

B. If the needle thread tension is too loose or the bobbin thread tension is too tight shown as Fig. 17C. Please turn the thread tension nut clockwise to increase the needle thread pressure; or turn the bobbin lace adjusting screw with a screwdriver to decrease the bobbin thread tension. (See Fig. 18,19). For special sewing with special thread, the tension needed can be obtained by adjusting the power and stroke of the thread take-up spring.



2. Adjust the pressure of presser foot (Fig.20)

The pressure of presser foot should be adjusted according to the thickness of the sewing materials. If stitch on heavy weight materials, the pressure should be increased by turning the pressure adjusting screw on the back of machine head clockwise, on the contrary, turn it counter-clockwise.



3. Adjust the safety clutch device

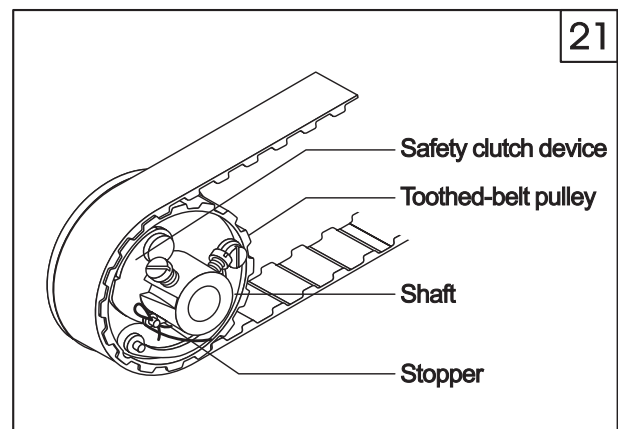
The function of safety clutch device is to prevent the hook and toothed belt from being damaged when the needle thread is drawn into the hook for abnormal load during the operation.

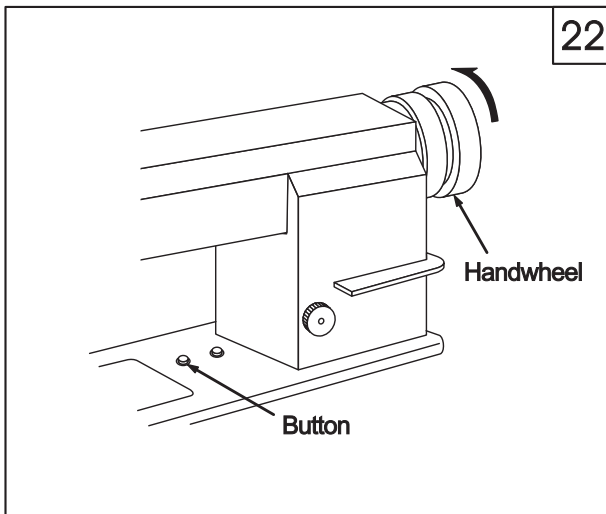
3.1 The function of safety clutch device (Fig.21)

A. When the safety clutch is functioning, the toothed belt will remove the load and the hook shaft will stop rotating, only the upper shaft still rotates, and the machine stops work.

B. Clean off the needle thread which is draw into the hook.

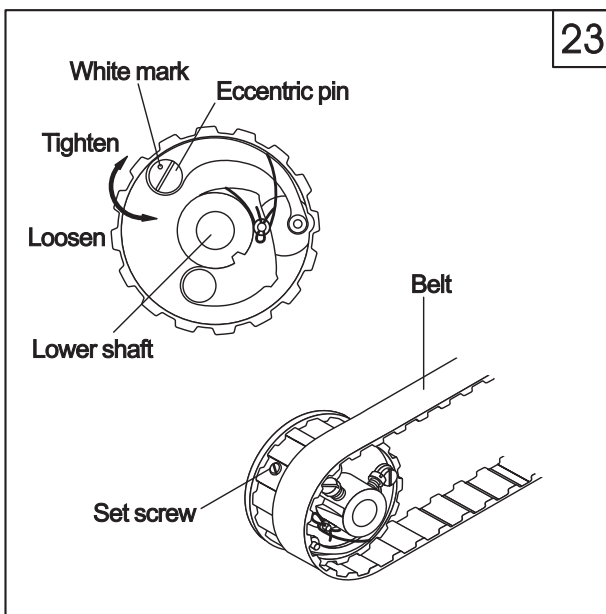
C. Turn the toothed belt shaft by hand to check if the hook shaft can turn smoothly, then reset the safety clutch device.





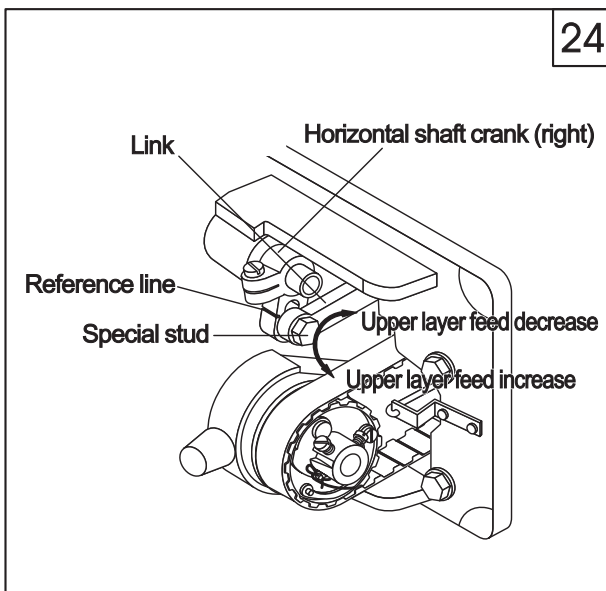
3.2 How to reset the safety clutch device (Fig.22)

- A. While press down the button on the bed surface with left hand, turn the hand wheel slowly with right hand in the direction shown in Fig. 22 (clockwise).
 - B. When the stopper brakes the hand wheel, more strength is needed to turn the balance wheel to reset the safety clutch device.
 - C. Release the button.
 - D. So the resetting is OK and put the bobbin into hook.
- (See Fig.15)



3.3 How to adjust the strength on the safety clutch device (Fig.23)

- A. When the white mark of the eccentric pin aims at the centre of the lower shaft, indicates that the strength on the safety clutch is the minimum. When the white mark points outward, the strength is properly increased.
- B. For adjusting the strength of it, move the belt and loosen the set screw of eccentric pin, and turn the eccentric pin.
- C. After adjustment, please tighten the set screw.



3.4 Adjust the upper feed mechanism (Fig.23)

If the upper and lower feed are not in timing during sewing, the long hole of the horizontal feed crank(right) should be adjusted to get the length of upper feed.

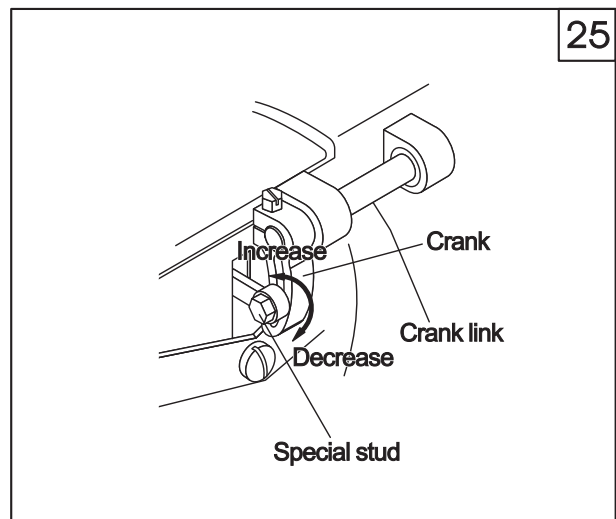
Adjusting as follows:

- A. Loosen the special stud.
- B. Move the stud upward to decrease the amount of upper feed.
- C. Move the stud downward to increase the amount of upper feed. Theoretically, when it is on the reference line of the horizontal feed crank, the upper feed amount equals to the lower feed amount.
- D. After adjustment, tighten the special stud.

3.5 Adjust the vertical stroke of presser foot (Fig. 25)

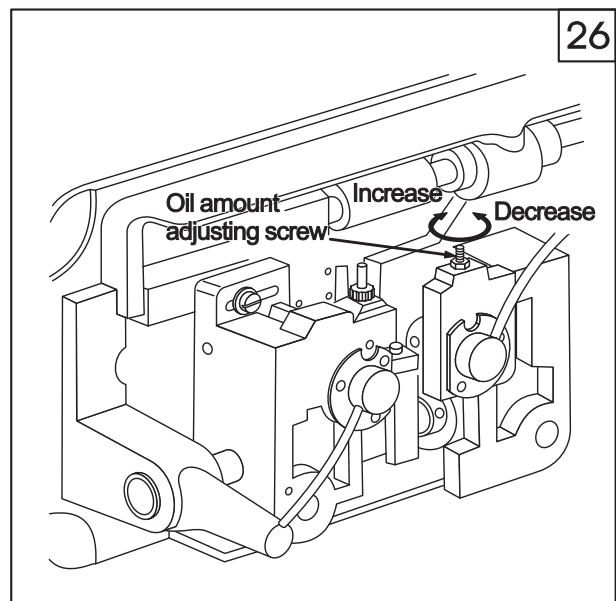
When stitch on the very elastic materials or the thickness of sewing materials changes, the adjustment should be done in the following order:

- A. Loosen the special stud.
- B. When the central line distance between the special stud and the presser foot lifting rear crank becomes shorter, the vertical stroke of presser foot will become longer, on the contrary, the distance becomes longer, the stroke will become shorter.
- C. After adjustment, tighten the special stud. The common vertical stroke of presser foot can be adjusted within the range of 2~6mm.



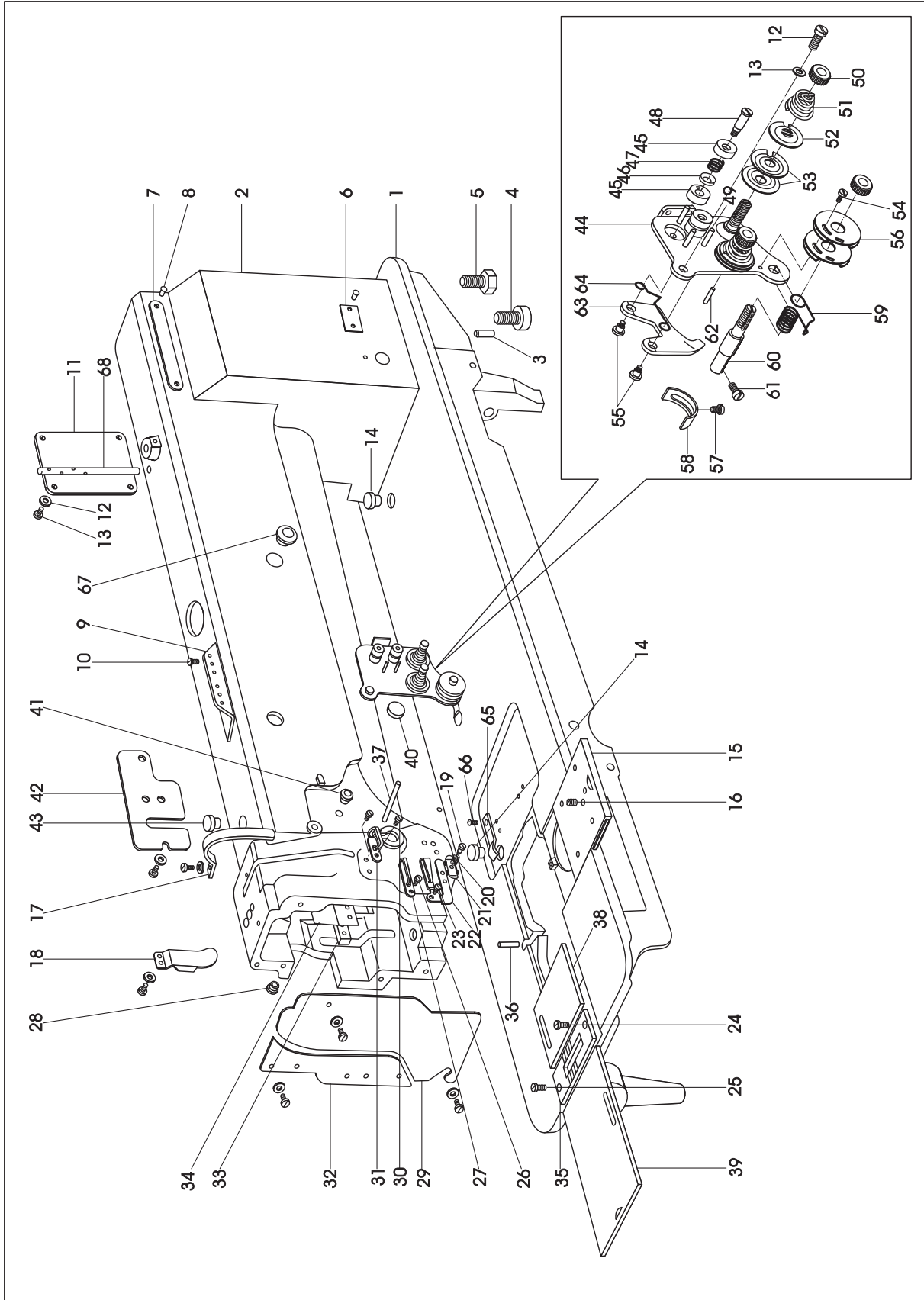
3.6 Adjust the hook oil amount (Fig. 26)

It adopts plunger full auto-lubricating system, even at a very low speed, it still can supply and suck oil very well. Generally, only the hook oil amount can be adjusted, the others cannot be adjusted. The hook oil amount can be controlled by the oil amount adjusting screw. First loosen the nut of adjusting screw, turn the screw clockwise to increase the oil amount, on the contrary, decrease the oil amount. After adjustment, tighten the nut.



Parts manual

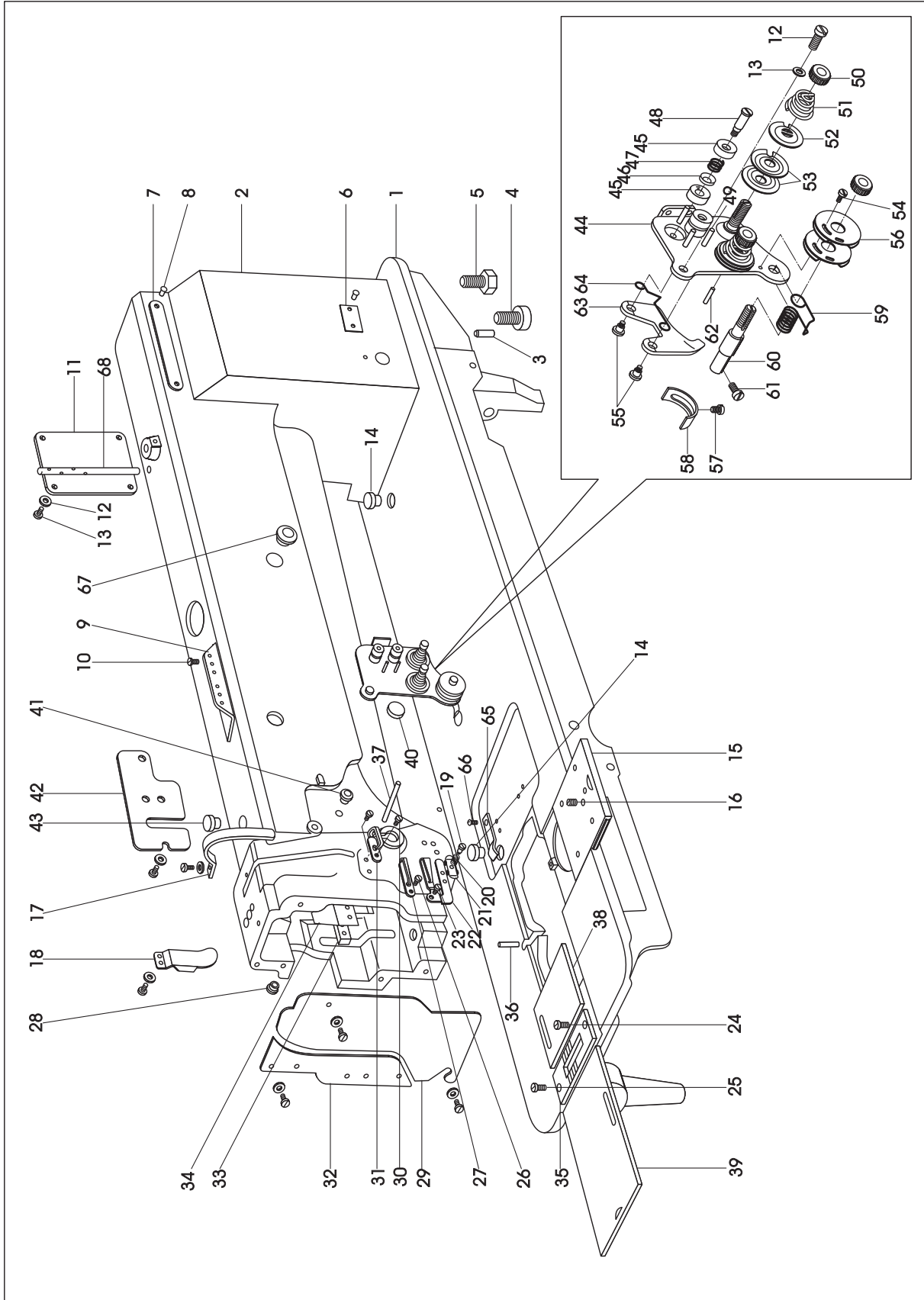
1.P2339RBL-18 machine casting components



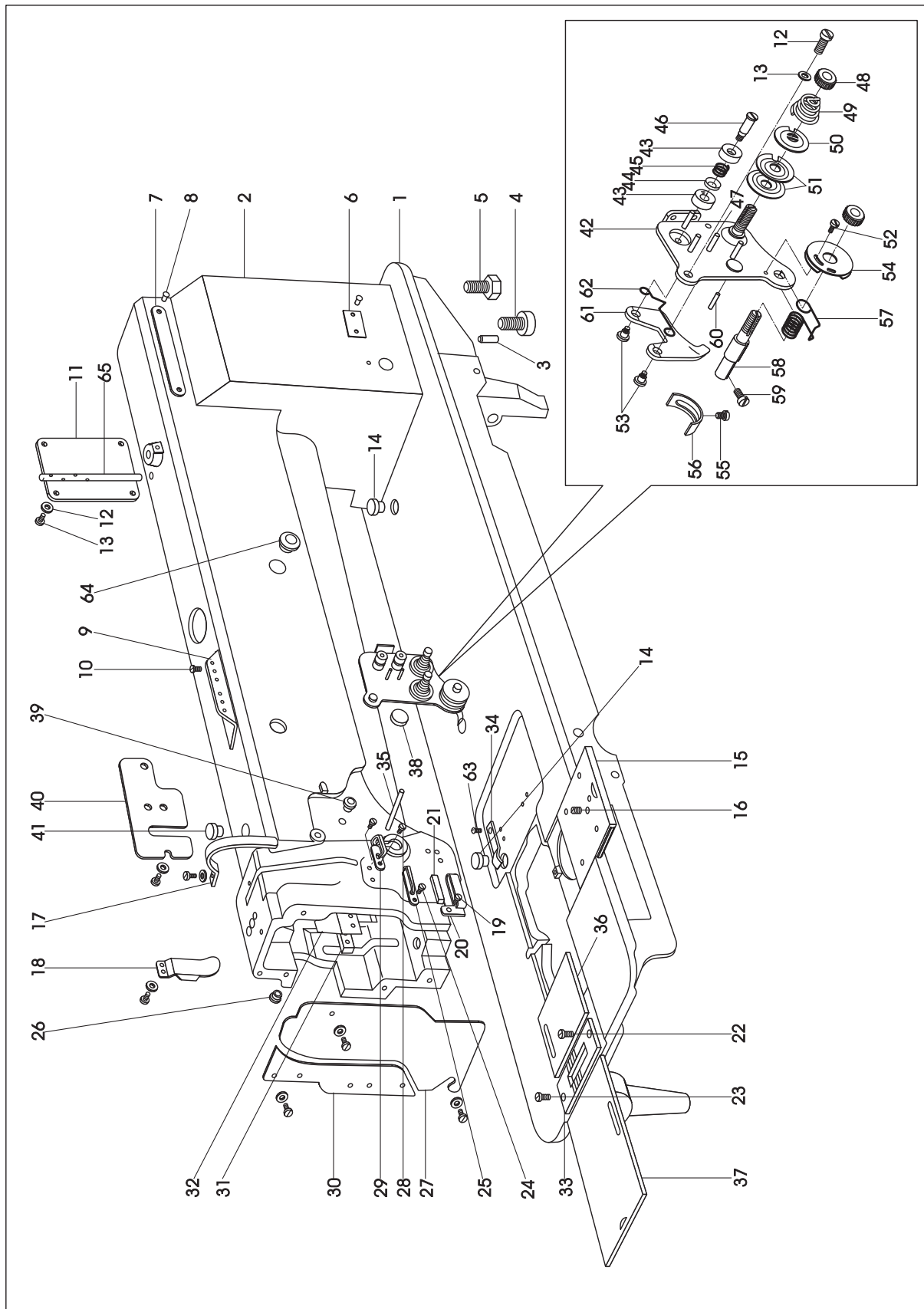
1. P2339RBL-18 Machine casting components

Line	Part Number	Description	Qt.	Notes
1	300-1002	Machine bed	1	
2	200-1004	Machine arm	1	
3	200-1373	Pin	2	A6X30 GB117-86
4	200-1374	Screw	1	M10X35 GB70-85
5	200-1375	Screw	3	M10X35 GB5781-85
6	300-1005	Model label	1	
7	300-1006	Brand label	1	
8	200-1376	Rivet	4	φ2.5X5 GB827-86
9	200-1016	Upper thread guide	1	
10	200-1017	Screw	2	SM11/64"X40/8
11	200-1018	Back cover	1	
12	200-1019	Screw	15	SM11/64"X40/9
13	200-1377	Washer	15	
14	200-1020	Cover	2	
15	200-1021	Front slide plate	1	
16	200-1022	Screw	1	SM11/64"X32/5.4
17	200-1023	Thread take-up lever cover	1	
18	200-1024	Back front cover	1	
19	300-1007	Screw	1	
20	300-1008	Spring	1	
21	300-1009	Thread retainer	1	
22	300-1010	Lower thread finger	1	
23	200-1025	Screw	1	SM9/64"X40/6.5
24	200-1028	Screw	1	
25	200-1029	Screw	1	SM11/64"X40
26	200-1030	Screw	1	SM9/64"X40
27	200-1031	Middle thread finger	1	
28	200-1032	Rubber plug (φ8.5)	2	
29	200-1033	Face plate	1	
30	200-1034	Screw	2	SM3/16"X28
31	200-1035	Upper thread finger	1	
32	200-1036	Guide set plate	1	
33	200-1037	Oil stopper set plate	1	
34	200-1038	Oil stopper	1	
35	300-1011	Needle plate	1	
36	300-1012	Pin shaft	1	
37	200-1042	Thread releasing lever	1	
38	200-1043	Right sliding plate	1	
39	200-1044	Left sliding plate	1	
40	200-1045	Rubber plug (φ14.5)	1	
41	200-1047	Rubber plug (φ12.7)	1	
42	200-1048	Back fitting cover	1	
43	200-1050	Rubber plug (φ12.7)	1	
44	200-1052	Thread tension fixing bracket assembly	1	
45	200-1054	Thread guide bracket	2	

1.P2339RBL-18 machine casting components



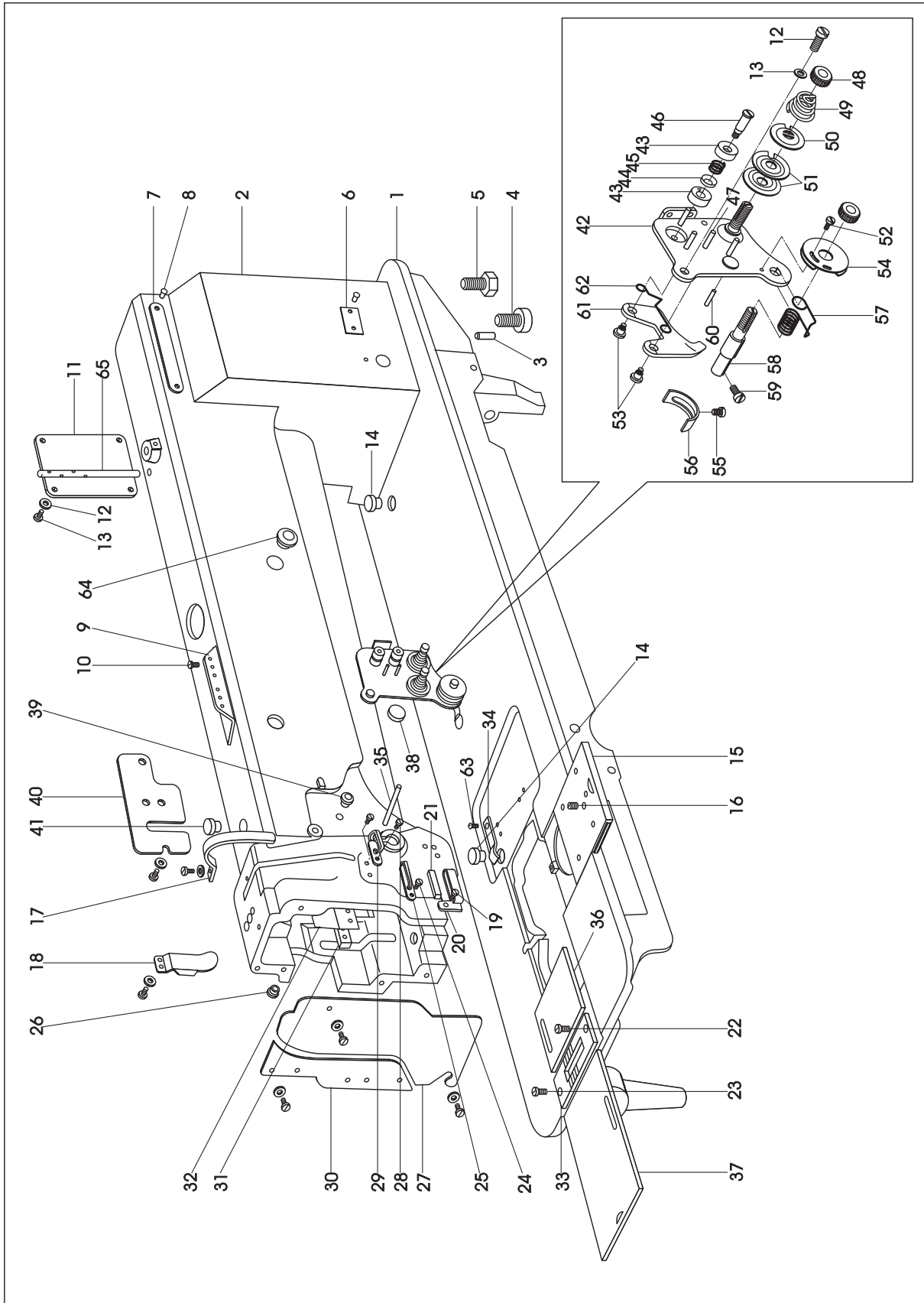
2. P1255RBL-18 machine casting components



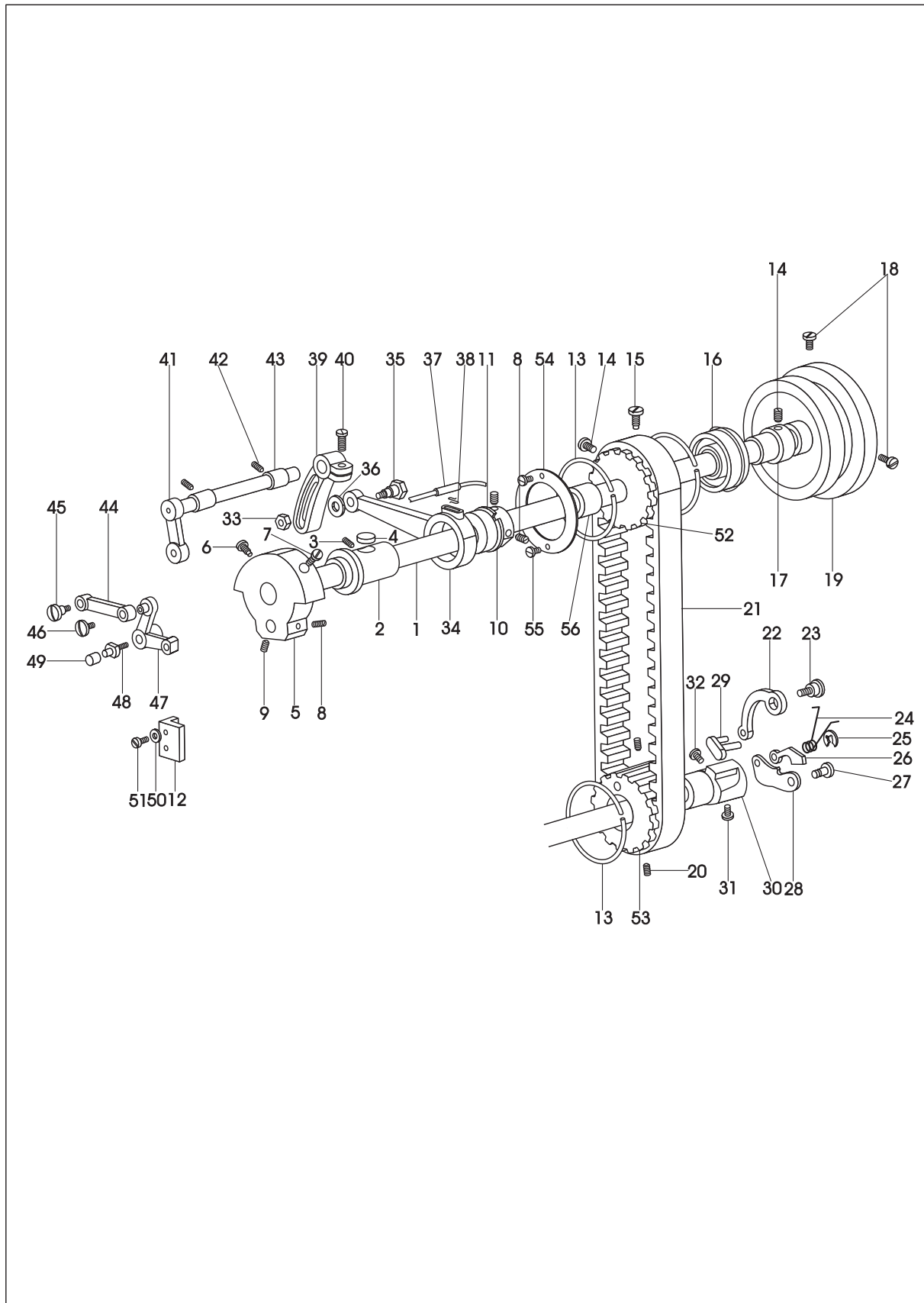
2. P1255RBL-18 Machine casting components

Line	Part Number	Description	Qt.	Notes
1	200-1001	Machine bed	1	
2	200-1004	Machine arm	1	
3	200-1373	Pin	2	A6X30 GB117-86
4	200-1374	Screw	1	M10X35 GB70-85
5	200-1375	Screw	3	M10X35 GB5781-85
6	200-1011	Model label	1	
7	200-1013	Brand label	1	
8	200-1376	Rivet	4	φ2.5X5 GB827-86
9	200-1016	Upper thread guide	1	
10	200-1017	Screw	2	SM11/64"X40/8
11	200-1018	Back cover	1	
12	200-1019	Screw	15	SM11/64"X40/9
13	200-1377	Washer	15	
14	200-1020	Cover	2	
15	200-1021	Front slide plate	1	
16	200-1022	Screw	1	SM11/64"X32/5.4
17	200-1023	Thread take-up lever cover	1	
18	200-1024	Back front cover	1	
19	200-1025	Screw	1	
20	200-1026	Lower thread finger	1	
21	200-1027	Oil felt	1	
22	200-1028	Screw	1	
23	200-1029	Screw	1	
24	200-1030	Screw	1	
25	200-1031	Middle thread finger	1	
26	200-1032	Rubber plug (φ8.5)	1	
27	200-1033	Face plate	1	
28	200-1034	Screw	2	SM3/16"X28
29	200-1035	Upper thread finger	1	
30	200-1036	Guide set plate	1	
31	200-1037	Oil stopper set plate	1	
32	200-1038	Oil stopper	1	
33	200-1039	Needle plate	1	
34	200-1040	Right sliding plate spring retainer	1	
35	200-1042	Thread releasing lever	1	
36	200-1043	Right sliding plate	1	
37	200-1044	Left sliding plate	1	
38	200-1045	Rubber plug (φ14.5)	1	
39	200-1047	Rubber plug (φ12.7)	1	
40	200-1048	Back fitting cover	1	
41	200-1028	Rubber plug (φ12.7)	1	
42	200-1052	Thread tension fixing bracket assembly	1	
43	200-1054	Thread guide bracket	1	
44	200-1056	Thread guide plate	1	
45	200-1058	Spring	1	

2. P1255RBL-18 machine casting components



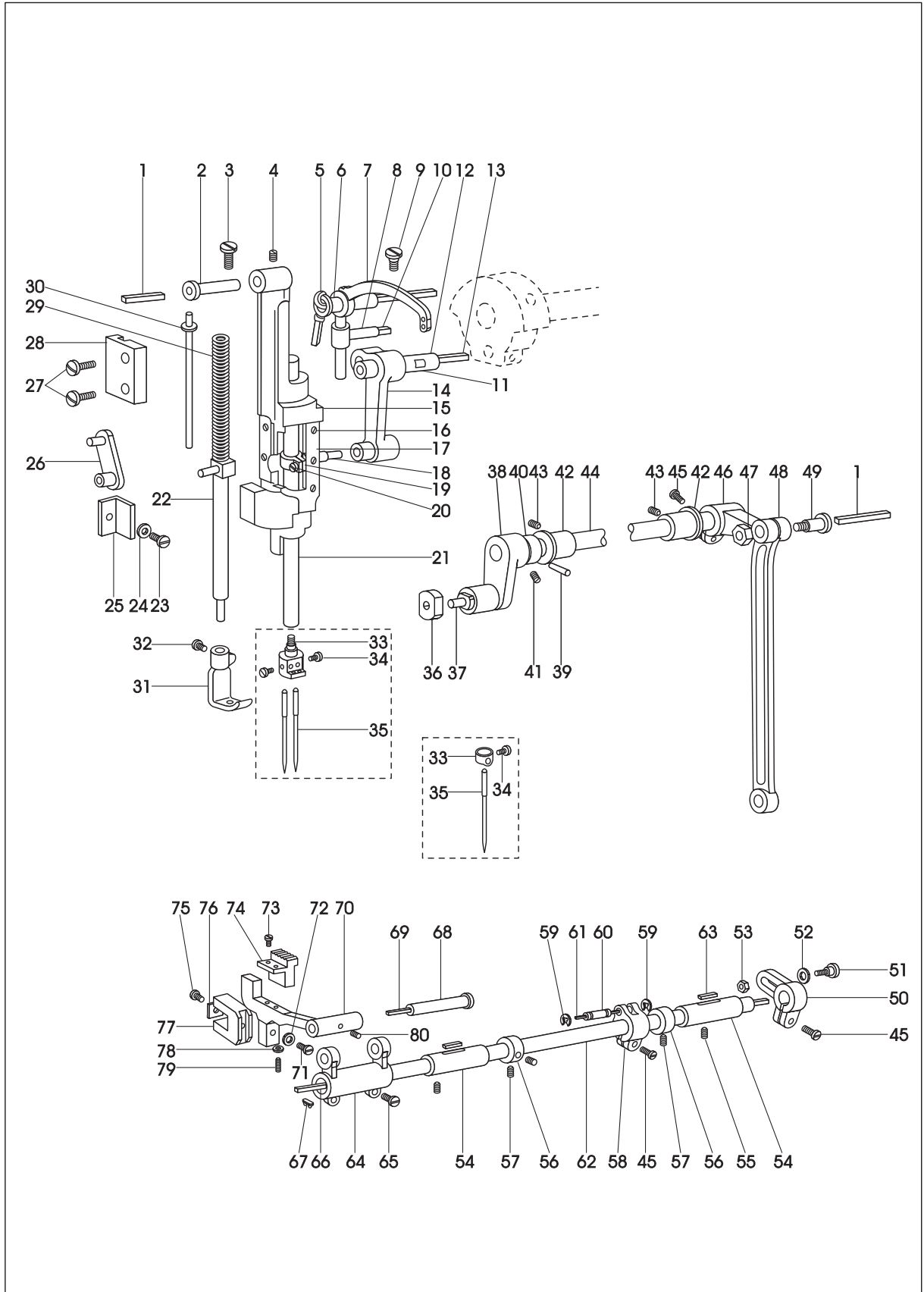
3. Upper shaft and presser foot components



3. Upper shaft and presser foot components

Line	Part Number	Description	Qt.	Notes
1	200-1101	Upper shaft	1	
2	200-1102	Upper shaft bushing (front)	1	
3	200-1103	Screw	1	SM1/4"X24/13
4	200-1104	Oil felt	1	Wool felt
5	200-1105	Needle crank	1	
6	200-1106	Screw	1	SM9/32"/28
7	200-1108	Screw	1	
8	200-1109	Screw	3	SM1/4"X40/7
9	200-1110	Screw	1	SM1/4"X40/4
10	200-1111	Eccentric cam	1	
11	200-1379	Stop ring	1	φ25 GB894.1-86
12	200-1114	Slot for front crank sliding block	1	
13	200-1116	Stop ring	3	
14	200-1117	Screw	3	SM15/64"X28/8.5
15	200-1119	Screw	1	SM15/64"X28/15
16	200-1380	Ball bearing	1	
17	200-1122	Upper shaft bushing (rear)	1	
18	200-1123	Screw	2	SM15/64"X28/12
19	200-1124	Hand wheel	1	
20	200-1125	Screw	2	SM15/64"X28/4.5
21	200-1126	Toothed belt	1	
22	200-1127	Spring plate	1	
23	200-1128	Pin	1	
24	200-1129	Spring	1	
25	200-1381	Split stop ring	1	φ3 GB896-86
26	200-1132	Stop plate	1	
27	200-1133	Nail	1	
28	200-1134	Braking plate	1	
29	200-1135	Connector	1	
30	200-1136	Bushing	1	
31	200-1137	Screw	1	SM15/64"X28/10.5
32	200-1138	Screw	1	SM15/64"X28/10
33	200-1139	Nut	1	
34	200-1140	Link lever	1	
35	200-1141	Bolt	1	
36	200-1474	Washer	1	Washer 6 GB95-85
37	200-1143	Oil pipe assembly	1	
38	100-1241	Spring	1	
39	200-1144	Presser foot lifting crank (rear)	1	
40	200-1145	Screw	3	SM1/4"X24/16
41	200-1146	Presser foot lifting crank (front)	1	
42	200-1147	Screw	2	SM1/4"X24/8
43	200-1148	Bushing	2	
44	200-1149	Link lever	1	
45	200-1150	Screw	1	
46	200-1151	Screw	1	SM11/64"X40/6
47	200-1152	Presser foot lifting movable plate	1	
48	200-1153	Rolling ball shaft	1	
49	200-1154	Rolling ball	1	
50	200-1155	Washer	2	Washer 4 GB848-85
51	200-1156	Screw	2	SM11/64"X40/10
52	200-1157	Upper shaft timing pulley	1	
53	200-1128	Lower shaft timing pulley	1	
54	200-1160	Bobbin winding shaft	1	
55	200-1161	Screw	2	
56	200-1162	Upper shaft bushing (middle)	1	

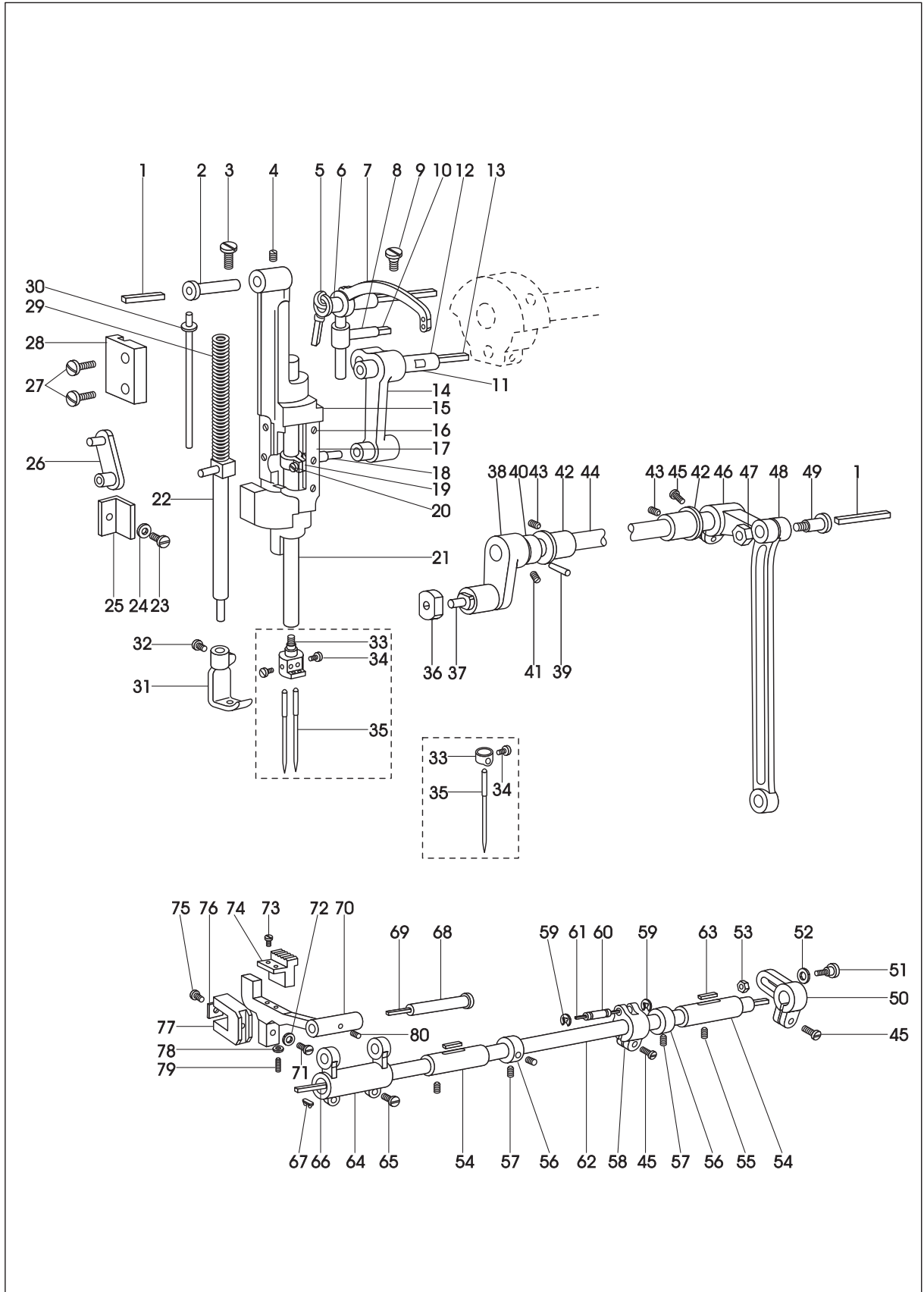
4. Needle bar and lower shaft components



4. Needle bar and lower feed components

Line	Part Number	Description	Qt.	Notes
1	200-1382	Oil wick	2	φ2.5X80 cotton thread
2	200-1383	Shaft for needle bar rocking frame	1	
3	200-1384	Screw	1	SM5/16"X28/10
4	100-1049	Screw	1	SM15/64"X28/8
5	200-1385	Oil wick	1	φ2.5X240 cotton thread
6	200-1386	Bushing	1	
7	200-1387	Thread take-up lever	1	
8	200-1388	Thread take-up lever sliding block	1	
9	200-1123	Screw	1	SM15/64"X28/12
10	200-1389	Oil wick	1	φ3x25
11	200-1390	Plug	1	
12	200-1391	Needle bar crank pin	1	
13	200-1392	Oil wick	1	φ3x80 cotton thread
14	200-1393	Needle bar link	1	
15	200-1394	Needle bar rocking frame	1	
16	200-1395	Screw	6	SM3/32"X56/4.6
17	200-1396	Shim needle bar rocking frame	2	
18	200-1397	Oil felt	1	
19	200-1398	Needle bar connector	1	
20	200-1399	Screw	1	SM9/64"X40/8.5
21	200-1400	Needle bar	1	P2339RBL-18
	200-1401	Needle bar	1	P1255RBL-18
22	200-1402	rocking presser bar	1	
23	200-1403	Screw	1	SM11/64"X40/12
24	200-1377	Washer	1	Washer GB848-85
25	200-1165	Needle bar holder guide	1	
26	200-1404	Presser bar link	1	
27	200-1405	Screw	2	SM11/64"X40/15
28	200-1406	Guiding plate	1	
29	200-1407	Spring	1	
30	200-1408	Spring bar	1	
31	200-1409	Inner presser foot	1	P2339RBL-18
	100-1192	Inner presser foot	1	P1255RBL-18
32	100-1027	Screw	1	
33	200-1410	Needle holder	1	P2339RBL-18
	100-1077	Needle bar thread guide	1	P1255RBL-18
34	200-1411	Needle holder screw	2	P2339RBL-18
	200-1166	Needle set screw	1	P1255RBL-18
35	200-1167	Needle	2	DPX17-23
36	200-1412	Needle bar rocking sliding bar	1	
37	200-1413	Sliding block shaft	1	
38	200-1414	Needle bar rocking left crank	1	
39	200-1415	Pin	1	A4X24 GB117-86
40	200-1416	Washer	1	
41	200-1417	Screw	2	

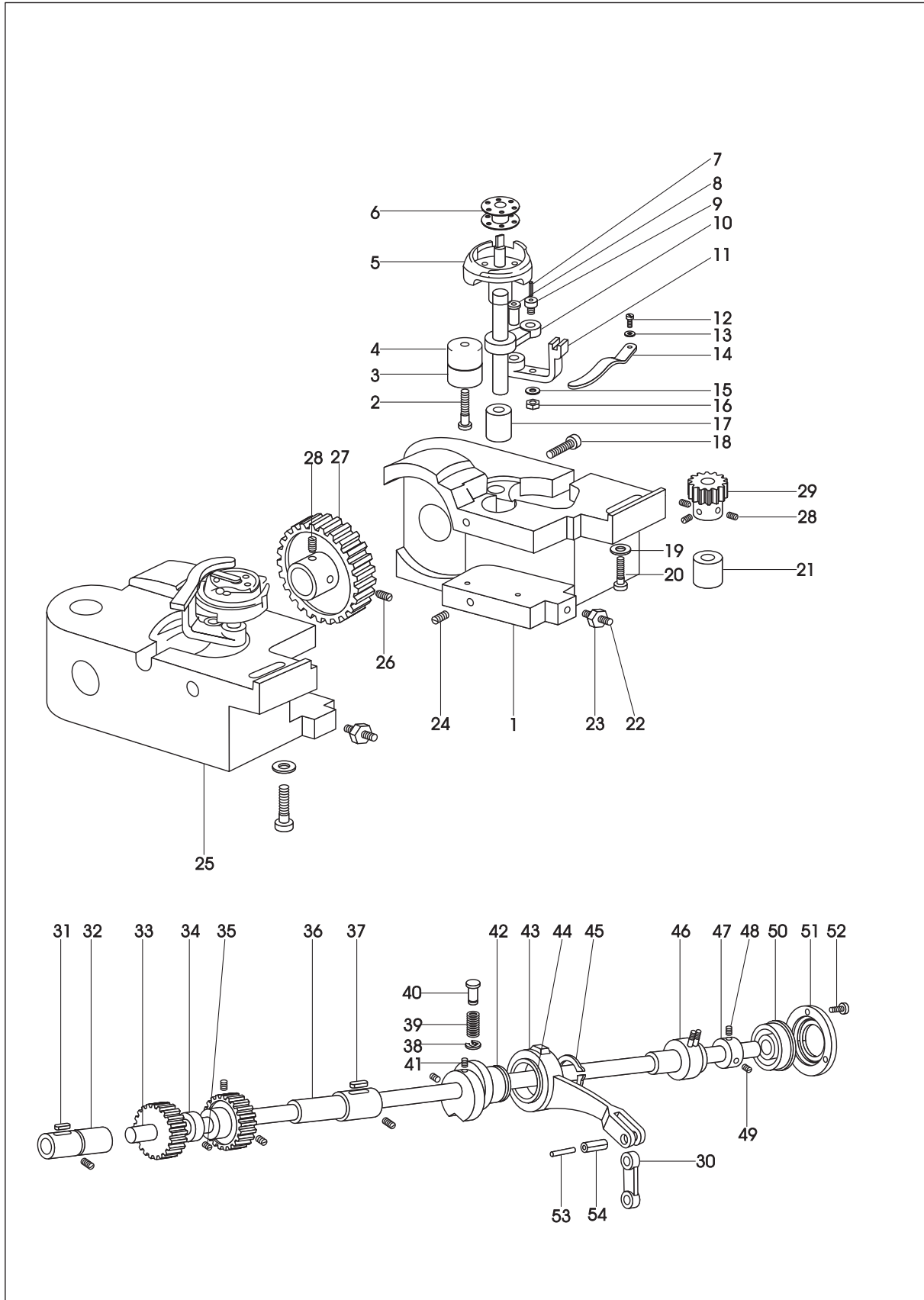
4. Needle bar and lower shaft components



4. Needle bar and lower feed components

Line	Part Number	Description	Qt.	Notes
42	200-1418	Bushing	2	
43	200-1147	Screw	2	SM1/4"X24/8
44	200-1419	Needle bar rocking shaft	1	
45	200-1145	Screw	3	
46	200-1420	Rear crank	1	
47	200-1421	Nut	1	
48	200-1422	Link lever	1	
49	200-1423	Screw	1	
50	200-1424	Feed shaft right crank	1	
51	200-1425	Pin	1	
52	200-1426	Washer	1	
53	200-1139	Nut	1	
54	200-1427	Feed shaft bushing	2	
55	200-1103	Screw	2	
56	200-1428	Collar	2	
57	200-1110	Screw	4	SM1/4"X40/4
58	200-1429	Feed crank	1	
59	200-1171	Split stop ring	2	Stop ring 5 GB896-86
60	200-1430	Crank pin	1	
61	200-1431	Oil wick	1	φ3x55 cotton thread
62	200-1432	Feed shaft	1	
63	200-1433	Oil felt	2	Wool felt
64	200-1434	Connecting crank (left)	1	
65	200-1435	Screw	2	SM3/16"X28/12
66	200-1238	Oil wick	1	φ2.5X430 cotton thread
67	200-1436	Oil wick clamp	1	
68	200-1437	Crank shaft	1	
69	200-1438	Oil wick	1	
70	200-1439	Feed dog support	1	P2339RBL-18
	200-1440	Feed dog support	1	P1255RBL-18
71	100-1201	Screw	1	SM15/64"X28/16
72	200-1142	Washer	1	Washer 6 GB95-85
73	200-1441	Screw	2	SM1/8"X40/7
74	200-1442	Feed dog	1	P2339RBL-18
	200-1443	Feed dog	1	P1255RBL-18
75	200-1444	Screw	1	SM1/8"X40/13.5
76	200-1445	Oil felt	1	Wool felt
77	200-1446	Feed dog lifting fork	1	
78	200-1447	Nut	1	
79	200-1448	Screw	1	SM1/8"X40/13.5
80	200-1449	Screw	1	SM11/64"X40/6

5. Lower shaft thread looping components

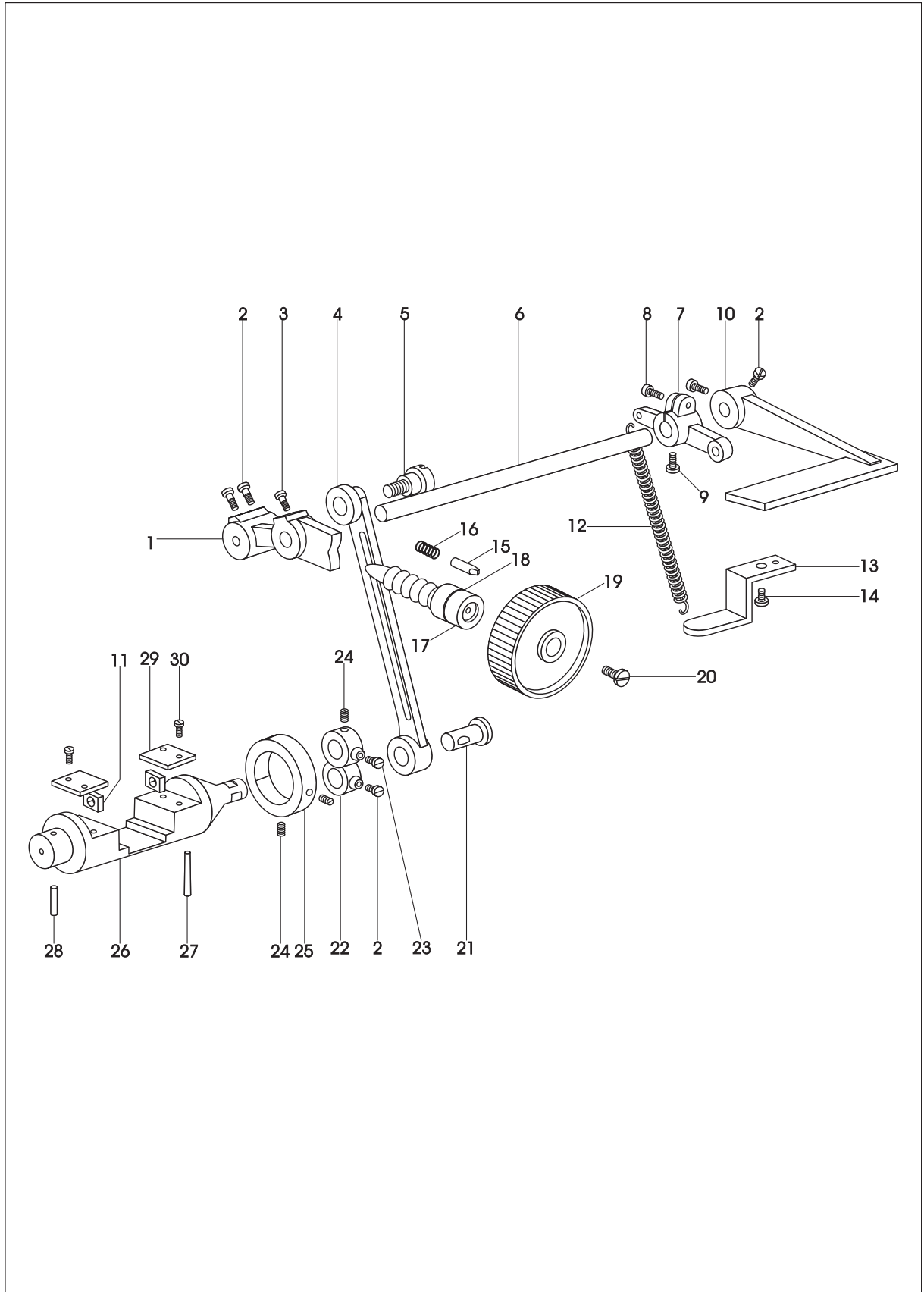


5. Lower shaft thread looping components

Line	Part Number	Description	Qt.	Notes
1	200-1178	Right hook saddle	1	
2	200-1179	Screw	2 (1)	SM14/64"X28
3	200-1180	Upper bushing	2 (1)	
4	200-1181	Lower bushing	2 (1)	
5	200-1182	Rotary hook assembly	2 (1)	
6	200-1183	Bobbin	2 (1)	
7	200-1184	Oil wick	2 (1)	φ2.5X14 cotton thread
8	200-1185	Hinge shaft	2 (1)	
9	200-1186	Screw	2 (1)	SM3/16"X32
10	200-1187	Link lever	2 (1)	
11	200-1188	Inner hook finger bracket	2 (1)	
12	200-1116	Screw	2 (1)	SM9/64"X40/4.5
13	200-1155	Washer	2 (1)	Washer 4 GB848-85
14	200-1189	Inner hook finger	2 (1)	
15	200-1155	Washer	2 (1)	Washer 4 GB848-85
16	200-1191	Nut	2 (1)	SM3/16"X32
17	200-1192	Upper bushing	2 (1)	
18	200-1193	Screw	2 (1)	SM3/16"X28/14.5
19	200-1142	Washer	2 (1)	Stop ring 6 GB95-85
20	200-1195	Screw	2 (1)	SM1/4"X24/20
21	200-1196	Lower bushing	2 (1)	
22	200-1198	Nut	2 (1)	SM3/16"X28
23	200-1199	Screw	2 (1)	SM3/16"X28/25.5
24	200-1125	Screw	2 (1)	SM1/4"X40/5
25	200-1201	Left hook saddle	1	
26	200-1202	Screw	2 (1)	SM1/4"X40/4
27	200-1203	Spiral gear	2 (1)	
28	200-1110	Screw	8 (4)	
29	200-1204	Spiral gear	2	
30	200-1206	Feed link	1	
31	200-1207	Lower shaft bushing (left)	1	
32	200-1208	Oil wick	1	φ25x45 cotton thread
33	200-1211	Lower shaft bushing (left)	1	
34	200-1450	Feed dog lifting cam	1	
35	200-1123	Screw	1	SM15/64"X28/12
36	200-1214	Lower shaft bushing (right)	1	
37	200-1215	Oil wick	1	φ2.5X85 cotton thread
38	200-1171	Stop ring	1	Stop ring 5 GB896-86
39	200-1217	Spring	1	
40	200-1218	Button	1	
41	200-1219	Screw	2	SM15/64"X28/13.5
42	200-1220	Feed cam	1	
43	200-1221	Feed link	1	
44	200-1451	Needle bearing	1	
45	200-1225	Stop ring	1	Stop ring 26 GB894.1-86
46	200-1206	Lower shaft bushing assembly (middle)	1	
47	200-1226	Lower shaft bushing (rear)	1	
48	200-1110	Screw	1	SM1/4"X40/4
49	200-1202	Screw	1	SM1/4"X40/5
50	200-1452	Bearing	1	
51	200-1229	Bearing pressing ring	1	
52	200-1230	Screw	3	SM9/64"X40/7
53	200-1231	Oil wick	1	
54	200-1233	Pin	1	

Note: the figure in the bracket is the parts quantity of P1255RBL-18

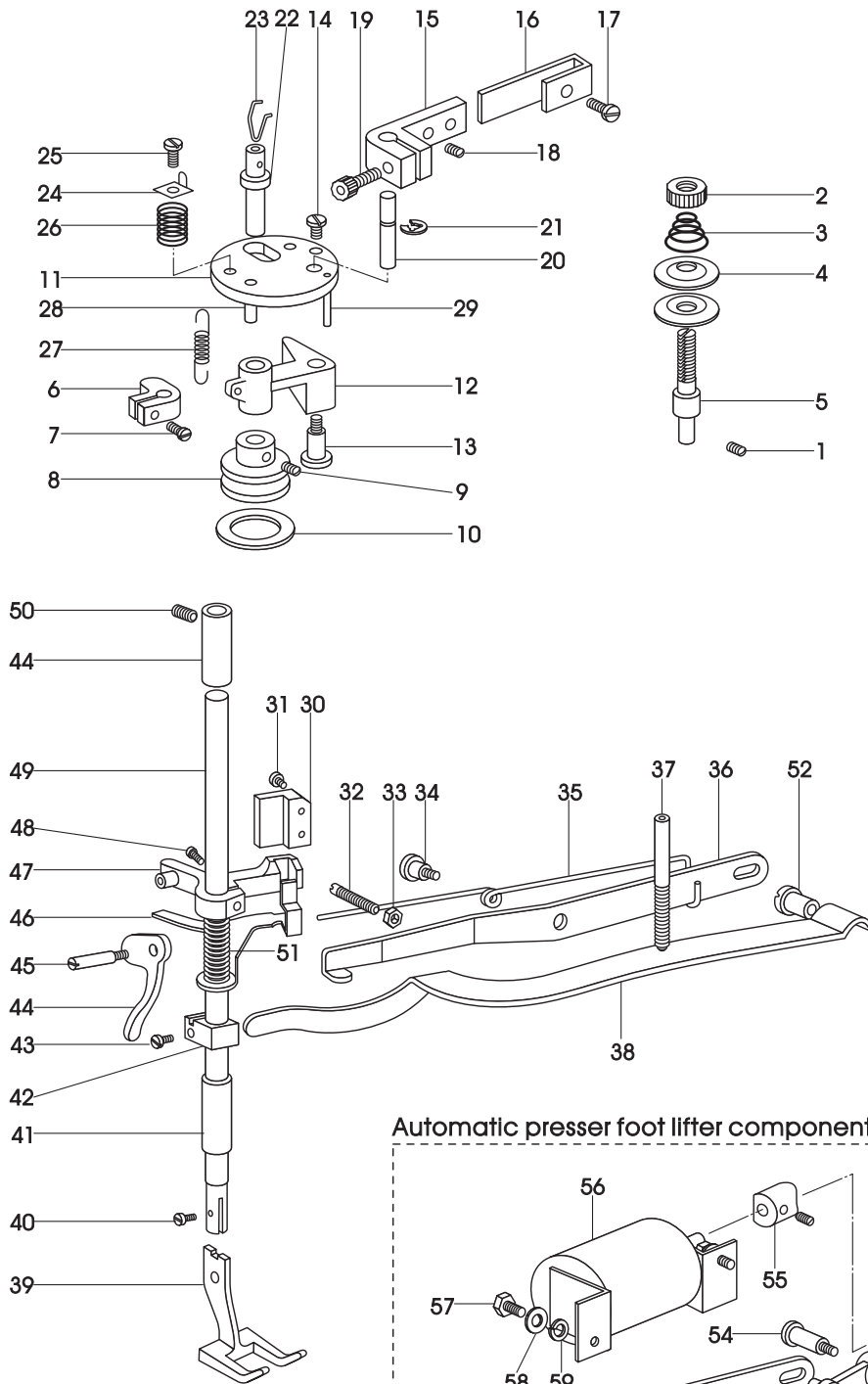
6. Stitch length adjustment components



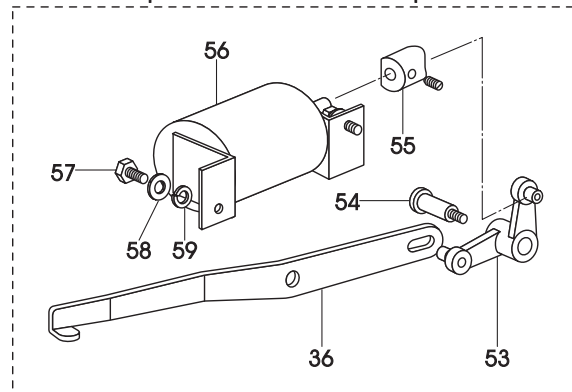
6. Stitch length adjustment components

Line	Part Number	Description	Qt.	Notes
1	200-1237	Stitch length adjusting rocking lever	1	
2	200-1238	Screw	5	SM15/64"X28/8.5
3	200-1239	Set screw	1	SM15/64"X28/12
4	200-1240	Stitch length link	1	
5	200-1241	Eccentric shaft	1	
6	200-1242	Reverse feed shaft	1	
7	200-1243	Reverse feed crank	1	
8	200-1244	Screw	1	SM15/64"X28/13
9	200-1245	Screw	1	SM15/64"X40/10.5
10	200-1246	Reverse feed lever	1	
11	200-1247	Sliding block	2	
12	200-1248	Crank spring	1	
13	200-1249	Spring bracket	1	
14	200-1250	Screw	1	SM11/64"X40/8
15	200-1251	Stop pin	1	
16	200-1252	Spring	1	
17	200-1254	Screw bar	1	
18	200-1453	O' type seal	1	14X2.4 GB1235-86
19	200-1256	Stitch length dial	1	
20	200-1165	Screw	1	
21	200-1257	Stitch length adjusting crank shaft	1	
22	200-1258	Stitch length adjusting crank	1	
23	200-1138	Screw	1	SM15/64"X28/10
24	200-1259	Screw	3	SM15/64"X28/6
25	200-1260	Collar	1	
26	200-1261	Reverse feed adjusting bracket	1	
27	200-1262	Oil wick	1	φ3x26 cotton thread
28	200-1263	Oil wick	1	φ4x16 cotton thread
29	200-1264	Guiding plate	2	
30	200-1019	Screw	4	SM11/64"x40/9

7. Knee lifter and winding components



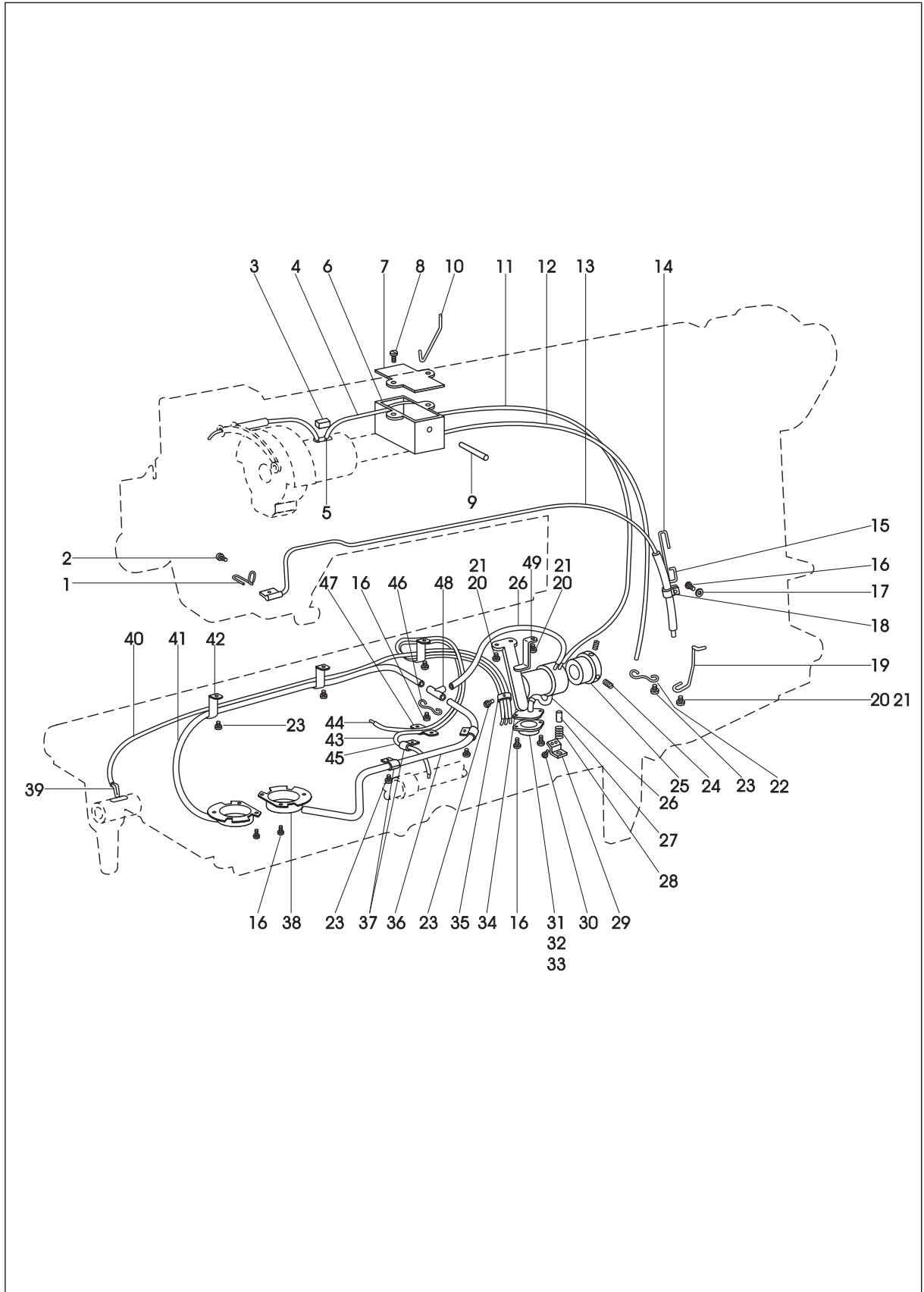
Automatic presser foot lifter components



7. Knee lifter and winding components

Line	Part Number	Description	Qt.	Notes
1	200-1266	Screw	1	
2	200-1267	Nut	1	
3	100-1017	Thread tension spring	1	
4	100-1019	Thread tension disc	2	
5	200-1268	Thread tension shaft	1	
6	200-1269	Crank	1	
7	200-1270	Screw	1	
8	200-1272	Bobbin winding pulley	1	
9	200-1273	Screw	2	
10	200-1274	Friction ring	1	
11	200-1275	Winder base	1	
12	200-1277	Winding crank	1	
13	200-1279	Pin	1	
14	200-1281	Screw (lower)	1	
15	200-1283	Winding spanner	1	
16	200-1285	Spring lever	1	
17	200-1286	Screw	1	
18	200-1288	Screw	1	
19	200-1289	Screw	1	
20	200-1290	Winding spanner shaft	1	
21	200-1291	Stop ring	1	Stop ring 3.5 GB896-86
22	200-1292	Winder shaft	1	
23	200-1293	Locking ring	1	
24	200-1294	Bobbin thread trimmer	1	
25	200-1295	Screw (upper)	1	
26	200-1296	Spring	1	
27	200-1297	Spring	1	
28	200-1298	Positioning pin	1	
29	200-1299	Positioning pin	1	
30	200-1300	Slot for sliding block	1	
31	200-1301	Screw	2	SM1/64"X40/12
32	200-1303	Screw	1	SM1/4"X24/16.5
33	200-1304	Nut	1	
34	200-1305	Screw	1	
35	200-1306	Spring	1	
36	300-1024	Knee lifting lever	1	(For presser foot lifter by pedal)
	200-1454	Knee lifting lever	1	(For automatic presser foot lifter)
37	200-1455	Screw	1	
38	200-1456	Presser bar spring lever	1	
39	200-1457	Outer presser foot	1	P2339RBL-18
	200-1458	Outer presser foot	1	P1255RBL-18
40	200-1459	Screw	1	
41	200-1460	Presser bar bushing	2	
42	200-1461	Presser bar spring lever bracket	1	
43	200-1399	Screw	1	SM9/64"X40/8.5
44	200-1462	Presser foot lifting bar	1	
45	200-1463	Screw	1	
46	200-1464	Thread releasing plate	1	
47	200-1465	Presser bar guiding bracket	1	
48	200-1405	Screw	1	SM11/64"X40/15
49	200-1466	Presser bar	1	
50	200-1462	Screw	2	SM1/4"X24X23
51	200-1467	Thread releasing spring lever	1	
52	200-1468	Screw	1	
53	200-1469	Crank assembly	1	
54	200-1470	Screw	1	
55	200-1471	Block	1	
56	200-1472	Solenoid assembly	1	PF-9
57	200-1473	Screw	2	
58	200-1474	Washer	2	GB93-8
59	200-1475	Washer	2	GB97.1-8

8. Lubrication components



8. Lubrication components

Line	Part Number	Description	Qt.	Notes
1	200-1311	Oil felt press spring	1	
2	200-1312	Screw	1	SM3/16"X28/12
3	200-1313	Oil felt	1	Wool felt
4	200-1314	Oil pipe	1	3DX0.5X60
5	200-1315	Oil wick	1	Cotton thread
6	200-1316	Oil cup	1	
7	200-1317	Oil cup cover	1	
8	200-1476	Screw	2	M4X16 GB69-85
9	200-1320	Pin	1	
10	200-1321	Oil wick press spring	1	
11	200-1322	Oil pipe	1	3DX1X400
12	200-1323	Oil draining pipe	1	5DX1X400
13	200-1324	Oil wick	1	φ2.5X550 cotton thread
14	200-1325	Oil pipe positioning clamp	1	
15	200-1326	Needle bar oil returning pipe	1	3DX0.5X150
16	200-1084	Screw	10	SM9/64"X40/9
17	200-1477	Washer	1	Washer 4 GB7246/87
18	200-1328	Oil returning pipe clamp	1	
19	200-1329	Set spring	1	
20	200-1019	Screw	4	SM11/64"X40/9
21	200-1377	Washer	4	
22	200-1330	Oil draining pipe end clamp	1	
23	200-1077	Screw	8	SM9/64"X40/4.5
24	200-1331	Screw	2	SM11/64"X40/10
25	200-1332	Bushing	1	
26	200-1333	Oil pipe	2	3DX1X90
27	200-1334	Plunger	1	
28	200-1335	Plunger spring	1	
29	200-1336	Pluner spring stopper	1	
30	200-1337	Screw	1	SM1/8"X44/4.5
31	200-1338	Oil filter	1	
32	200-1339	Washer	1	
33	200-1340	Filter net	1	
34	200-1341	Oil filter fixing plate	1	
35	200-1342	Oil pipe clamp	1	
36	200-1343	Oil pipe for right hook saddle	1	
37	200-1344	Oil pipe clamp	3	
38	200-1345	Oil tray assembly	1	
39	200-1346	Oil wick	1	φ2.5X430 cotton thread
40	200-1347	Oil pipe	1	3DX0.5X410
41	200-1348	Oil pipe	1	3DX1X445(P2339RBL-18)
42	200-1312	Oil pipe clamp	3	
43	200-1349	Oil pipe	2	3DX0.5X220
44	200-1350	Oil wick	1	φ2.5X300
45	200-1351	Oil wick	1	φ2.5X240
46	200-1352	Clamp	1	P2339RBL-18
47	200-1353	Oil pipe clamp	1	
48	200-1354	Oil nozzle assembly	1	P2339RBL-18
49	200-1355	Oil filter fixing bracket	1	

9. Accessories

