



744R10-1

745R10-1



CONTENTS

Operation instruction

1、Brief introduction	1
2、Main specifications	1
3、Installation and operation preparation	1
4、Needle	1
5、Lubrication	2
6、Thread	2
7、Winding the bobbin thread	2
8、Installing the bobbin	3
9、Threading the needle thread	3
10、Adjusting the tension of needle thread and bobbin thread	3
11、Adjusting the stitch length	4
12、Adjusting the presser foot pressure	4
13、Reverse stitching	4
14、Adjusting the feeding	5
15、Adjusting the feed dog	5
16、Adjusting the timing between needle and hook	5
17、Adjusting the height of needle bar	6
18、Adjusting the bobbin case opener	6
19、Adjusting the height of presser foot	6
20、Adjusting the timing of vibrating presser foot	7
21、Adjusting the presser foot movement amount	7
22、Adjusting the thread controller spring	7
23、Replacing the timing belt	8
24、Safety clutch mechanism	8
25、Adjusting the bobbin thread winder	9
26、Adjusting the hook oil amount	9
27、Installing the pedal	9

Parts manual

1、Casting components	10-13
2、Upper shaft and thread take-up components	14-15
3、needle bar rocking frame and upper feed components	16-17
4、Feed components	18-21
5、Hook components	22-23
6、Thread tension components	24-25
7、Accessories	26-27
8、AL(N) Components	28-29

1. Brief introduction

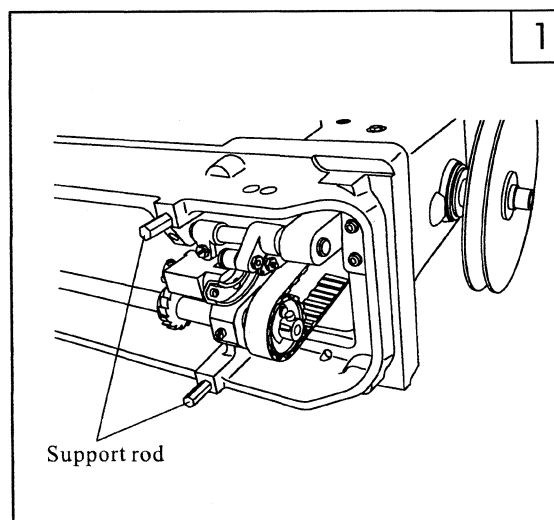
This series machines adopt sliding type take~up lever mechanism, compound feed with needle feed, bottom feed and alternating presser feet and link type feeding mechanism. Driven by timing belt and extra large hook is installed to form seam #301. These machines have the large working space and high lifting height of presser foot so it's suitable for sewing large products. Suitable for stitching tents, canvas, rubber products, heavy leather and furniture

2. Main specifications

Model	744R30	745R30	744R20	745R20	744R10	745R10
Applications	Extra heavy weight materials					
Max Sewing Speed	800spm		1000spm			
Max Stitch length	10mm					
Presser foot lift height	20mm					
Needle	DYX3 #25					
Bobbin	φ 37×13mm					
Working space	762mm×153mm		508mm×153mm		305mm×153mm	
Bed size	1100mm×230mm		846mm×230mm		643mm×230mm	
Motor power	550W, 4P					
Needle gauge	1/4"、1/2"、3/4"、1"、1 1/4"、1 1/2"、1 3/4"、2"、7/8" (Standard1/4")					

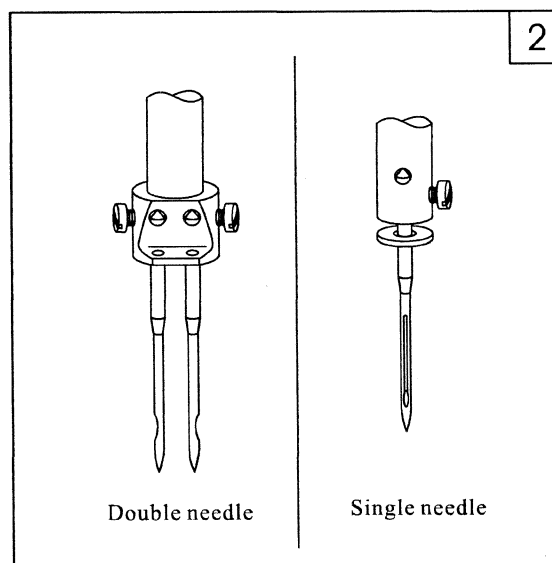
3. Installation and operation preparation(Fig.1)

1. Before test and operation, the places need to lubricated must be oiled, during the testing time, the lubrication should be more frequently.
2. The turn direction of the hand wheel must face to the operator.
3. Please don't run at the max. speed for a new machine, the 90% of the max. speed is acceptable.
4. Before install the machine on the table, please first uninstall the two support rods



4. Needle(Fig.2)

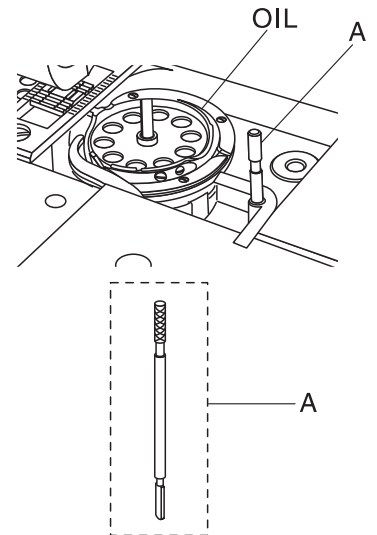
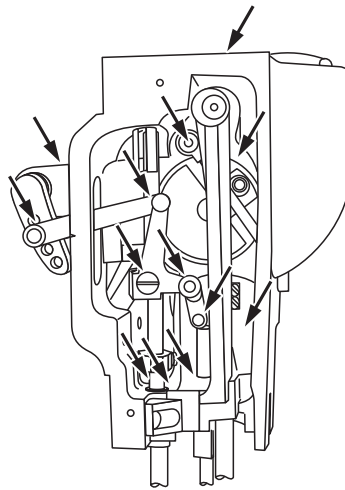
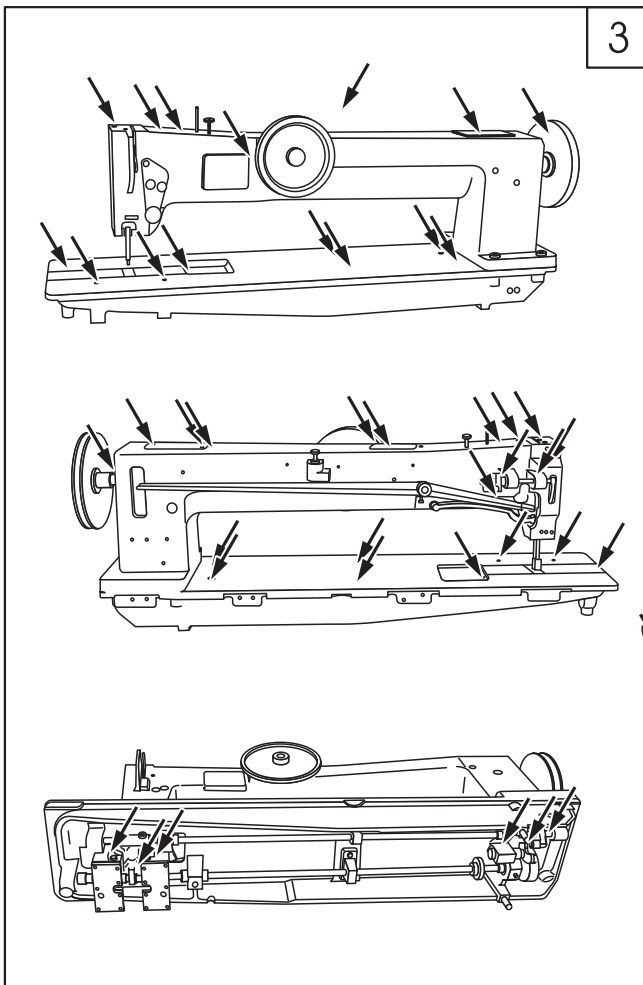
1. The standard needle type is DY×3(24#~26#)
The right need should be choosed according to the thread and materials to be sewn
2. Install the needle: turn the hand wheel to lift the needle bar to its highest position, loosen the needle set screw, fully insert the needle shank up to the bottom of needle bar (single needle) or needle clamp(double needle),for single needle machine, keep the long groove leftward; for double needle machine, keep the long grooves of the two needles opposite with each other, then tighten the needle set screw.



3

5.Lubrication(Fig.3)

- 1.Add 1-2 drops of oil in the places indicated by the arrows.
- 2.Put the oil indicator A out from the hook saddle, and fill oil in it until to the upper reference line.
- 3.Please lubricate at least twice every day if sewing continuously.



4

6.Thread(Fig.4)

Usually, the needle thread should be left twisted, but for double needle machine, the left needle thread should be right twisted.



Left twist

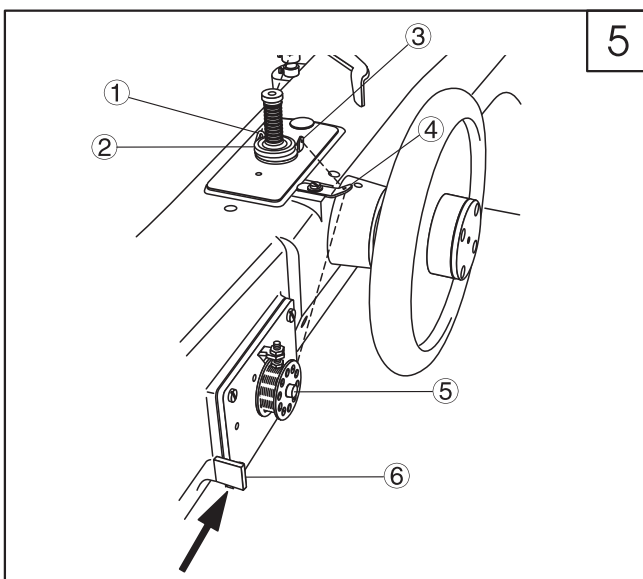


Right twist

5

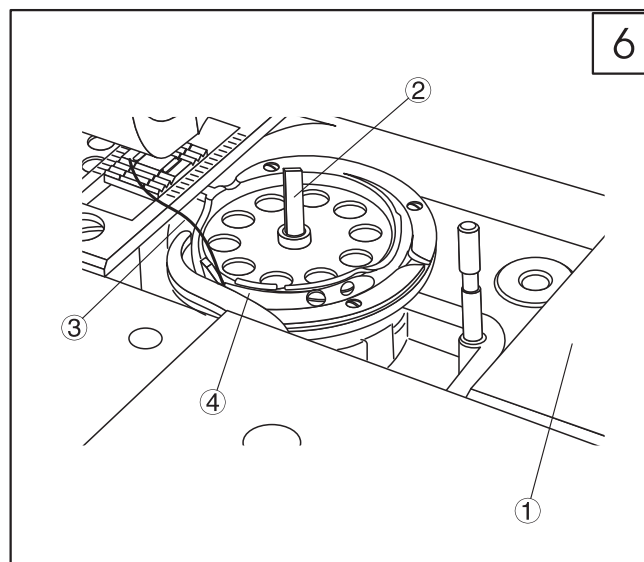
7.Winding the bobbin thread(Fig.5)

- 1.Drawing the bobbin thread through ① ② ③ ④, Wind thread several circles around bobbin and insert the bobbin into the shaft of bobbin winder ⑤.
- 2.put the winder lever ⑥ onto bobbin shown by arrow, then it can be automatic wound when sewing.



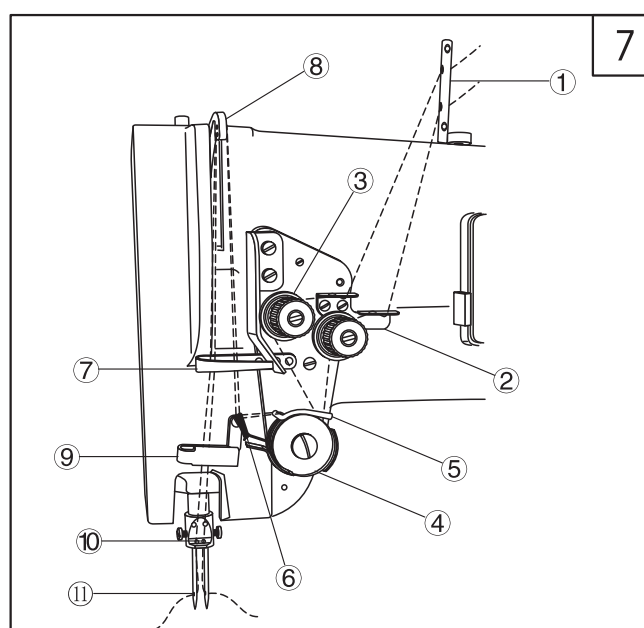
8. Installing the bobbin(Fig.6)

1. Open the slide plate ① and hook latch ②, then put the bobbin in the hook
2. Draw the bobbin thread ③ through hook lace ④ about 4-5cm, then lock the hook latch.
3. Close the slide plate.



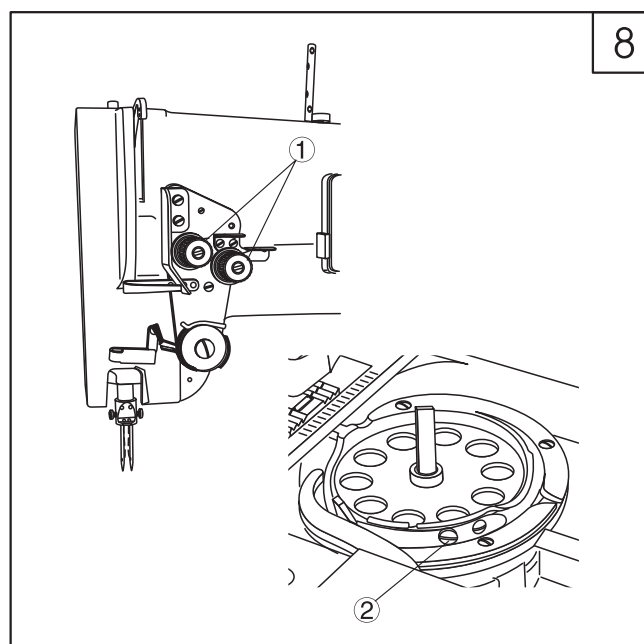
9. Threading the needle thread(Fig.7)

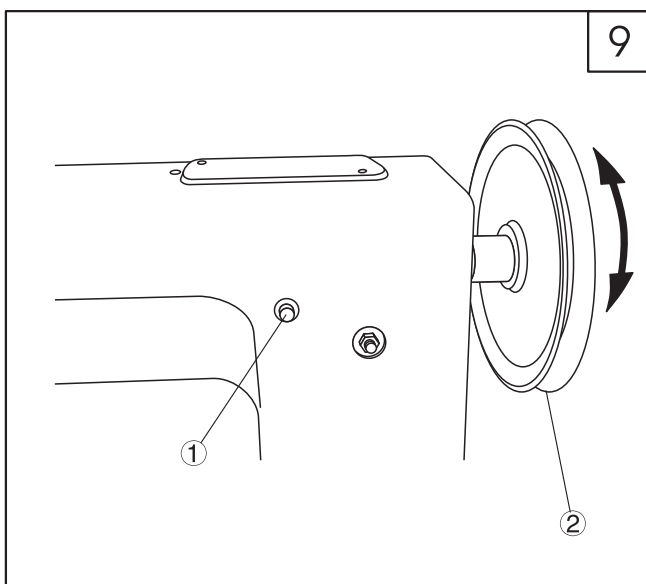
1. Passing the needle thread through thread guide pin ①, thread guide ②, thread tension ③, thread tension ④, lower thread guide rod ⑤, thread controller spring, upper thread guide ⑦, thread take-up lever ⑧, upper thread guide ⑦, lower thread guide ⑨, needle bar ⑩, and needle ⑪.
2. Hold the tip of needle thread by hand; turn the hand wheel to lower the needle bar, then lift it to its highest position, pull the needle thread and the bobbin thread will be drawn up accordingly, inally put the tip of needle thread and bobbin thread toward front under the presser foot.



10. Adjusting the tension of needle thread and bobbin thread(Fig.8)

1. The tension of needle thread is controlled by the thread tension nut ①.
2. The tension of bobbin thread is adjusted by the Screw. Turn the screw clockwise to increase the tension and turn the screw counter-clockwise to decrease the tension

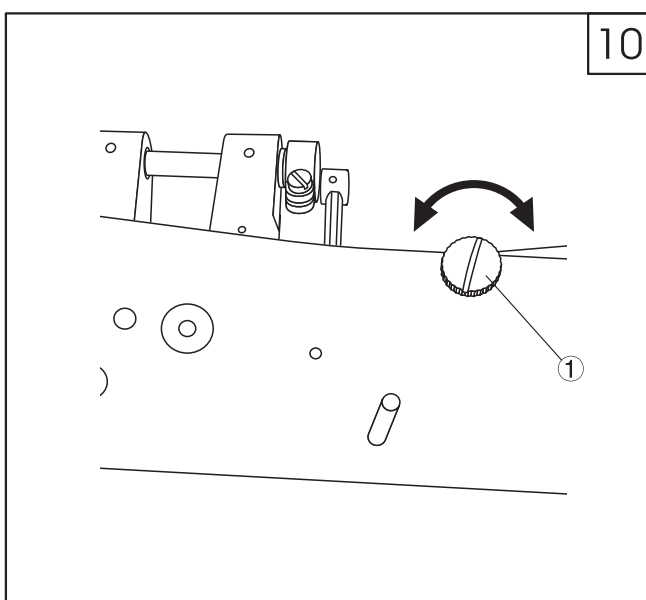




11.Adjusting the stitch length (Fig.9)

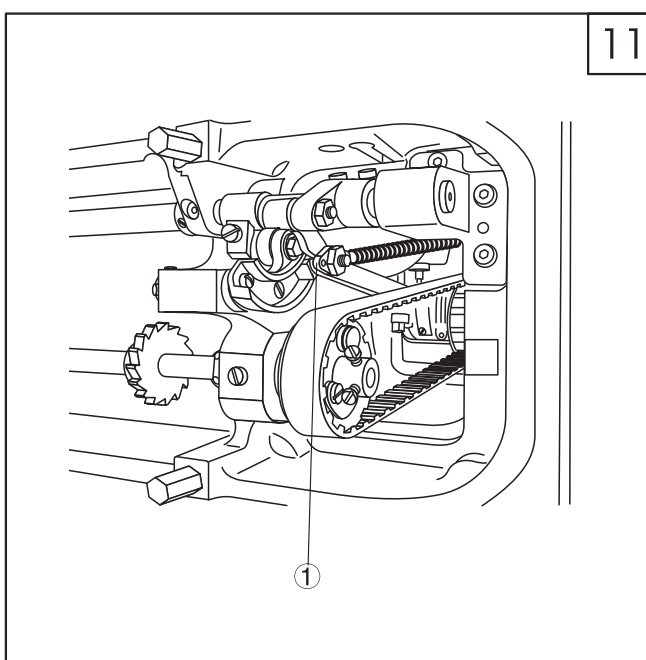
Put the stitch length button ① on the feed eccentric cam,press the button and turn the hand wheel ② slowly to adjust the stitch length.

Turn the hand wheel face to the operator to increase the length, on the contrary, to decrease the length. When the required stitch length is obtained, release the button, and then begin to operate the machine



12.Adjusting the presser foot pressure (Fig.10)

Please turn the pressure regulating screw ① clockwise to increase the presser foot pressure, on the contrary, to decrease the pressure.

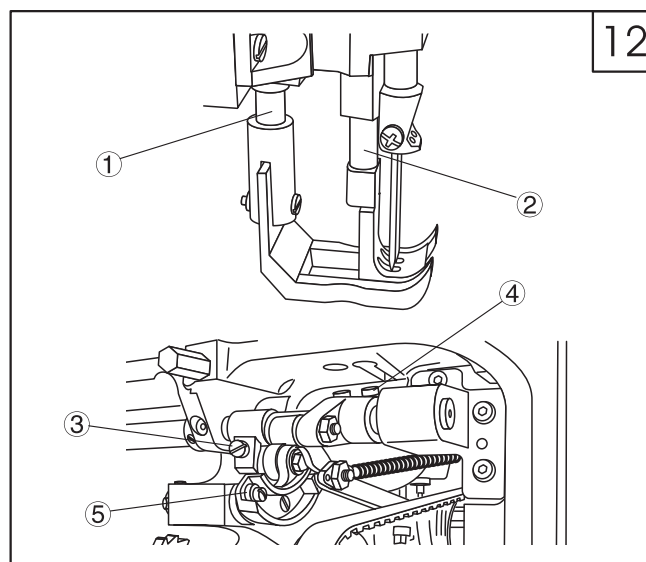


13.Reverse stitching (Fig.11)

Connect the reverse pedal with the block ①, when step on the pedal, the reverse stitching will be run.

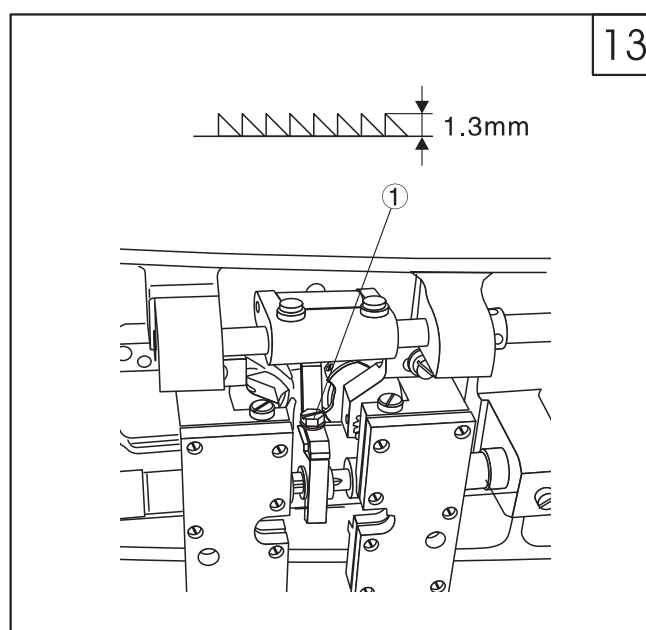
14.Adjusting the feeding(Fig.12)

- 1.Adjust the feed eccentric cam to make the stititch length zero, at this position, the distance between vibrating presser bar ① and presser bar ② is 15.5mm(single needle) or 14.5mm(double needle). To adjust the stitch length by crank screw ③.
- 2.Usually, the position between feed dog and needle is: the needle should drop in the center of needle hole of feed dog. To adjust the position by screw ④.
- 3.After adjustment, please tighten the screws.
- 4.To adjust the eccentric cam ⑤ to control the max. stitch length.



15.Adjusting the feed dog(Fig.13)

The maximum height of feed dog over the surface of needle plate is 1.3mm, To adjust the height by screw ①.



16.Adjusting the timing between needle and hook(Fig.14)

Set the feed eccentric with the button at no feeding position, and confirm the distance between vibrating presser bar and presser bar should be 15.5mm.

- 1.If the needle bar and hook are correctly timed, the point of the hook will be at the center of the needle when the needle raised 3.8 ± 0.5 mm from the lowest point.

For the adjustment of timing, loosen the two screws ① for the hook driving gear, and tap this gear to the right or left in clearance of 2mm on the hook driving shaft until the point of the hook is at the center of the needle.

Tapping to the right gives on earlier hook timing, and to the left gives later hook timing.

Wxcept the above case, to adjust in changing gear condition between hook driving gear ② and hook shaft gear ③.

Securely tinghamten the two screws for hook driving gear after finishing adjustment.

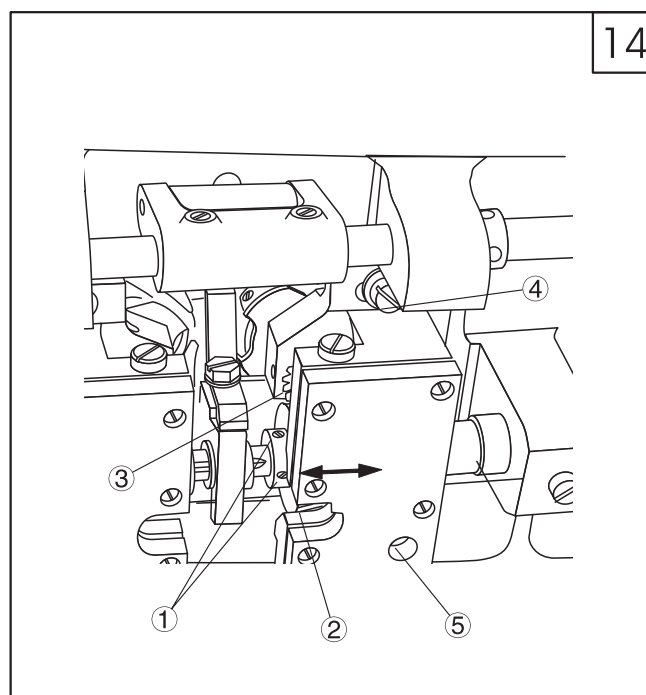
- 2.Normally, the clearance between hook point and scarf of needle is 0.02~0.1mm

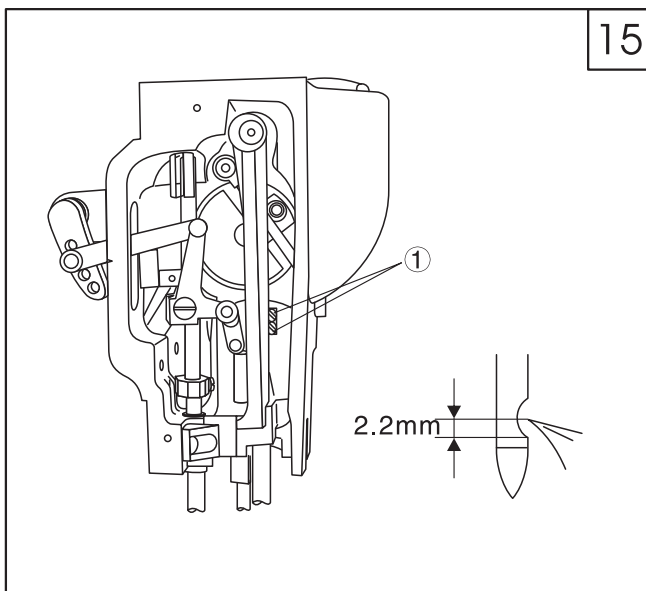
a.Loosen screw ④⑤;

b.Move the hook saddle right or left until the hook point is as close to needle as possible, but without striking it;

c.Tighten the two screws;

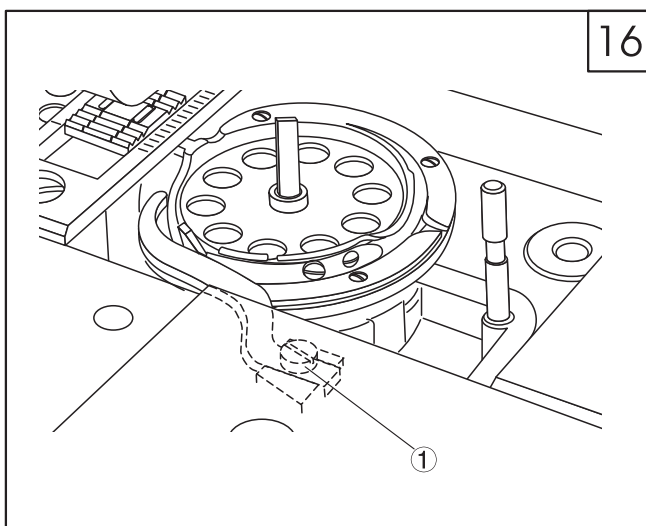
d.Before adjustment, please be sure that the needle doesn't bend.





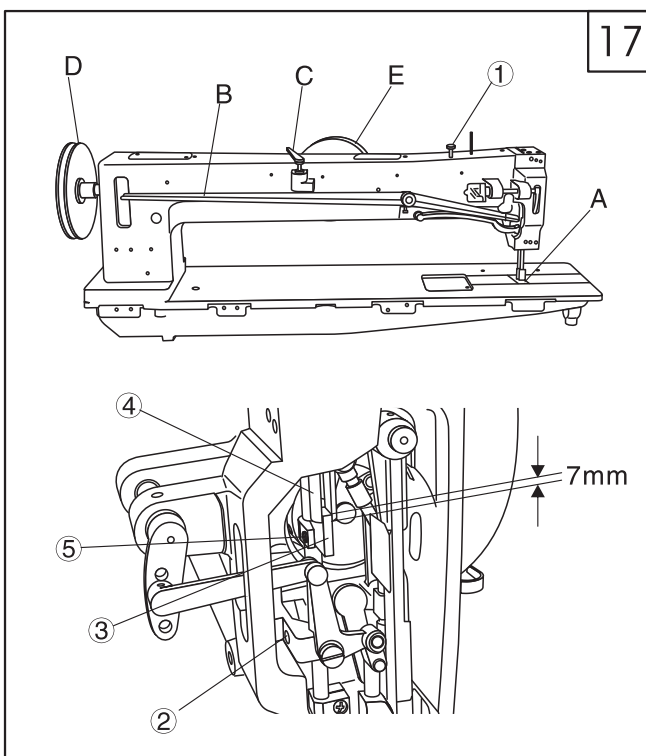
17. Adjusting the height of needle bar (Fig.15)

Normally, the clearance between top of the eye of needle and hook point is 2.2mm. In case the needle bar is incorrectly set, loose the needle bar set screw ① and place the needle bar in correct position as required, and then tighten the screw ①.



18. Adjusting the bobbin case opener (Fig.16)

1. Turn the hand wheel until the top of the opener ② is located at the distance from the needle plate;
2. In this position, adjust it so that the clearance between the inside edge of the opener and the top of the hook is about 0.3~0.8mm;
3. After adjustment, tighten the screw ①.



19. Adjusting the height of presser foot (Fig.17)

The distance between the surface of the needle plate (A) and the presser foot at stopped position is 19mm. When step on the lifting pedal, the stop lever (C) will be released by the lifting lever (B).

1. To change the relative lift of the presser feet, loosen the screw ① at the above condition.
2. The height of lift of the presser feet is adjustable by moving the screw of presser bar lifting bracket.
3. Normally, the distance between presser bar position guide bracket ③ and presser bar position guide ④ is 7mm.

Position of the vibrating presser foot to shift in left and right is to be adjusted by the screw ② for presser bar lifting bracket and the screw for presser bar position guide bracket.

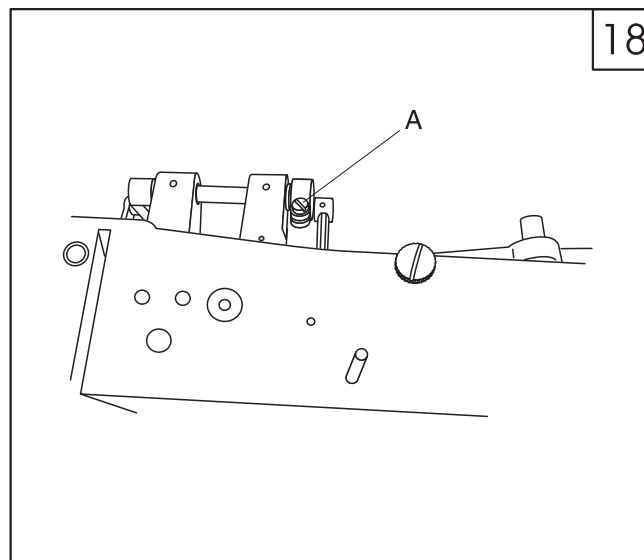
20. Adjusting the timing of vibrating presser foot(Fig.18)

The amount of lift of the presser feet should be regulated according to the thickness of materials to be sewn.

The feet should lift just enough to clear the materials.

As a rule, the walking foot and presser foot should lift at the same height, but some grades of work may require that they lift an unequal height.

To change the relative lift of the presser feet, loosen the screw (A) for lifting rock shaft crank and move the vibrating presser bar upward or downward as required, then tighten the screw (A).

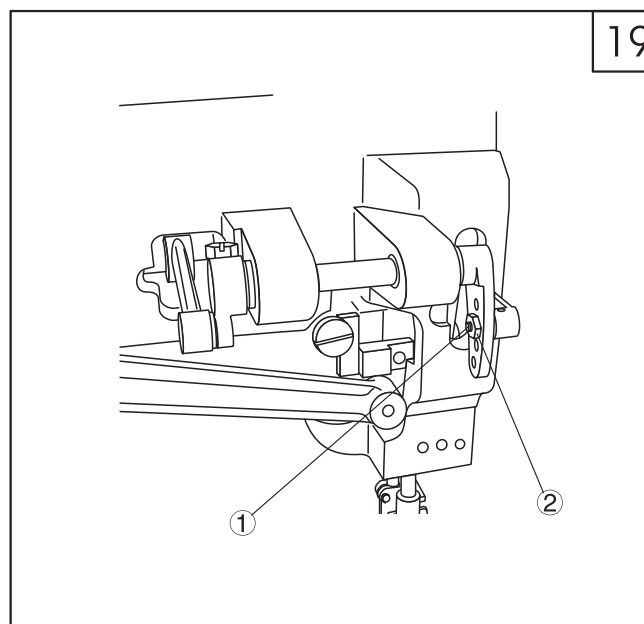


21. Adjusting the presser foot movement amount(Fig.19)

The lifting amount of presser foot and walking foot can be adjusted by the lifting bell crank link screw stud ①. To decrease the movement in setting the stud ① at the upper position, and to increase the movement in setting the stud ① at the lower position, after setting, tighten the stud ① with nut ②.

The clearance for the presser foot and walking foot are being adjusted at maximum, so that the clearance of them should be adjusted according to the materials to be sewn.

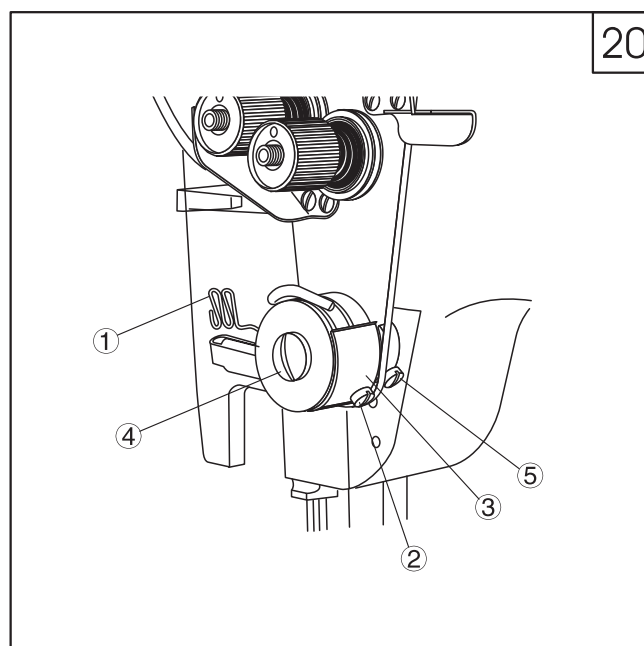
The timing position for the presser feet should be regulated by Fig.18.

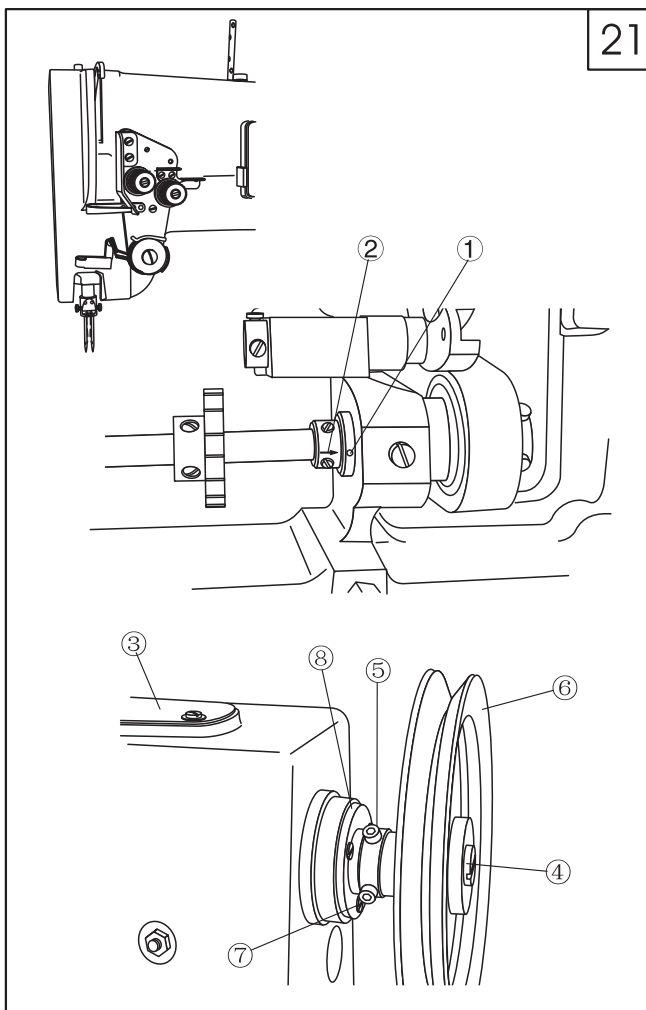


22. Adjusting the thread controller spring(Fig.20)

1. For more or less controller spring ① action on the thread, loosen the screw ② and turn the stop plate ③ to increase or decrease the action.

2. Adjusting the tension of controller spring: loosen the nut ④ and screw ⑤, turn the spring stud screw leftward with a screwdriver to increase the tension, or turn the stud screw rightward to decrease the tension, finally, tighten the screw ⑤.





21

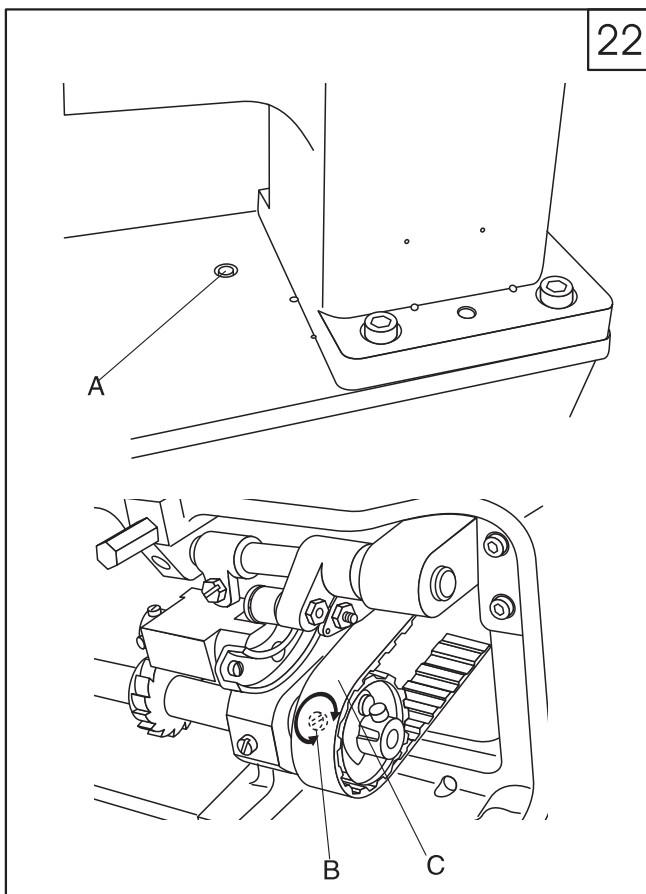
23.Replacing the timing belt(Fig.21)

A. When the timing belt removed from the pulley for adjustment and/or replacing spare parts, it should be replaced by the following processes:

1. Turn the hand wheel to lift the thread take-up lever to its highest position;
2. Turn the hook shaft with the fingers until the arrow mark on the hook driving shaft bush collar ② and the red point mark on the hook driving shaft bush ① are directly in line, then replace the belt over the upper and lower pulley.

B.Replacement of the timing belt when damaged

1. Remove the upper arm plate and oil reservoir ③
2. Loosen the hand wheel set screw ④ and other two screw ⑤, then remove the hand wheel ⑥;
3. Loosen the three screws ⑦ in the upper shaft bush and remove the bush ⑧;
4. Lift the belt up through the arm cap hole after removed the bush as far as possible and draw it out through the space normally occupied by the bush.
5. Replace the timing belt as opposite processes as above for removing it
6. Tighten all of the screws, so as to fit the upper shaft, free from looseness.



22

24.Safety clutch mechanism(Fig.22)

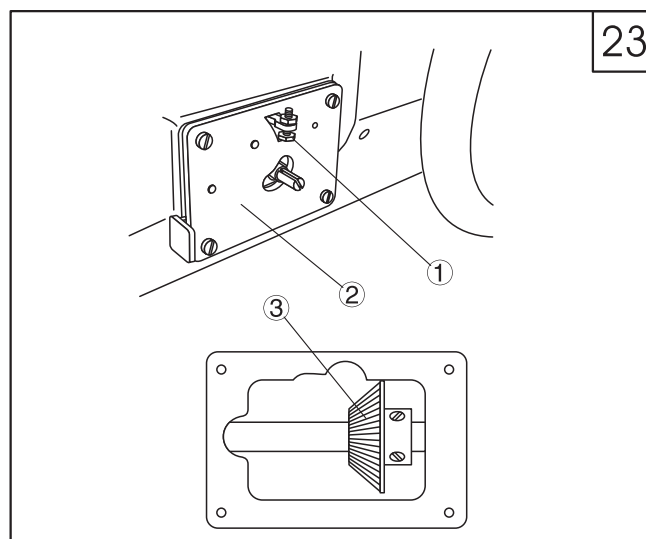
The safety clutch located on the right side of the lower timing pulley, it can prevent damage in the event of thread jamming in the hook by releasing the locking lever in the pulley.

1. Take out jammed thread from the hook;
2. To re-engage the clutch, press down the lock stud(A) by left hand, and turn the hand wheel backward slowly by right hand, then the safety clutch will be released.
3. In case easily releasing the safety clutch, adjust the pressure by the screw(B) after removed the timing belt(C). Turn the screw (B) clockwise to increase the pressure, and turn the screw (B) counter-clockwise to decrease the pressure

25.Adjusting the bobbin thread winder(Fig.23)

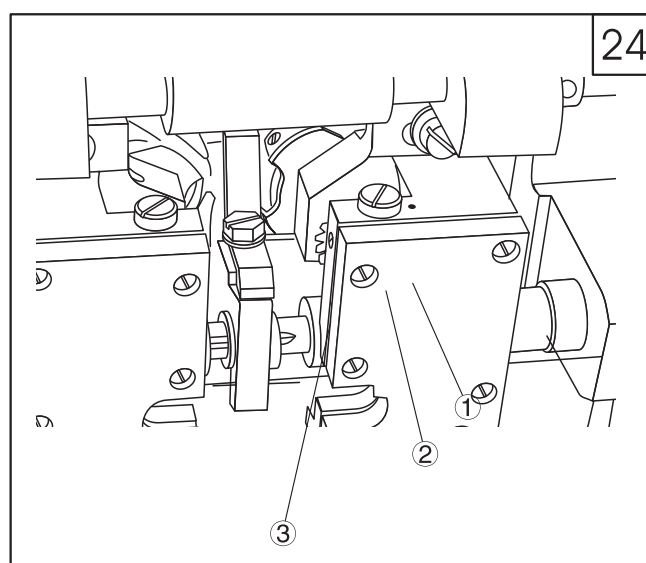
Adjust the volume of winding thread to the bobbin by the adjustment screw ①

Remove the plate ② on the front of the arm and adjust the slippage of the shaft for the winder by the winder driving gear ③ in the upper shaft to shifting right or left.



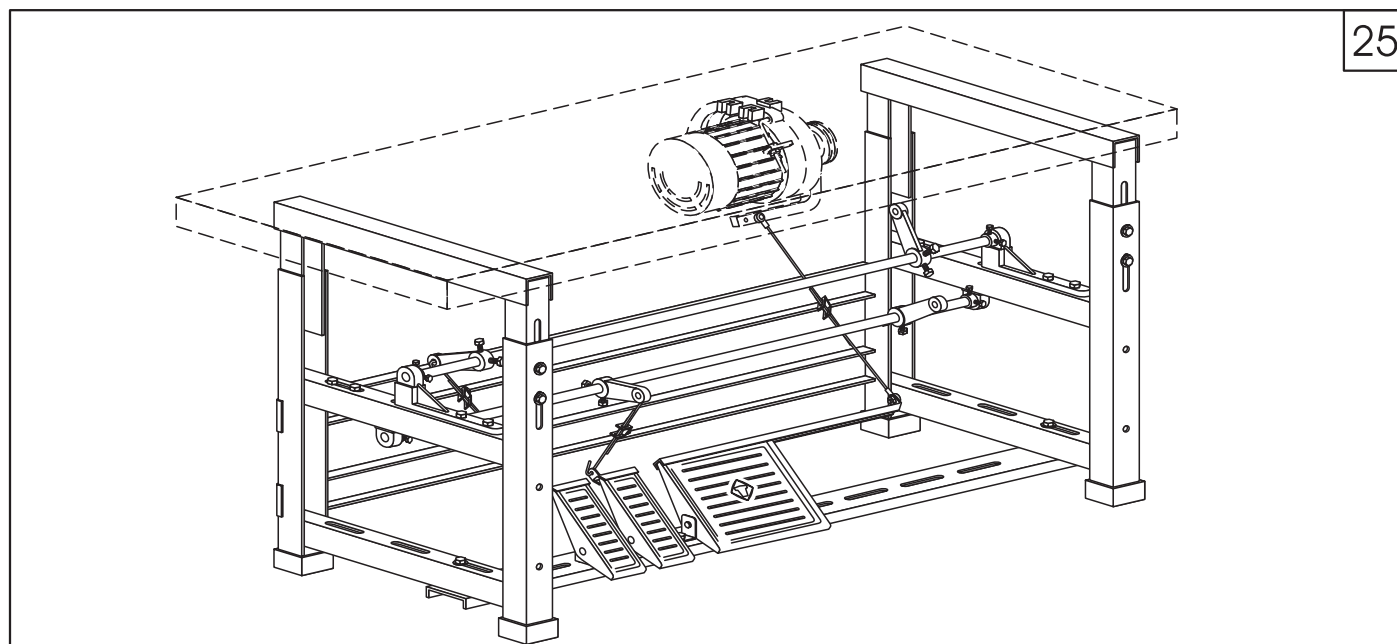
26.Adjusting the hook oil amount(Fig.24)

Loosen the screw ③ for the oil adjustment dial ② and adjust oil supply by truning the oil adjustment dial. When the point mark ① on the hook saddle is in line with the center line o the dial ②,the oil supply will be at the maximum level, when the point mark is at the vertical position of the center line of the dial, the oil supply will stop.



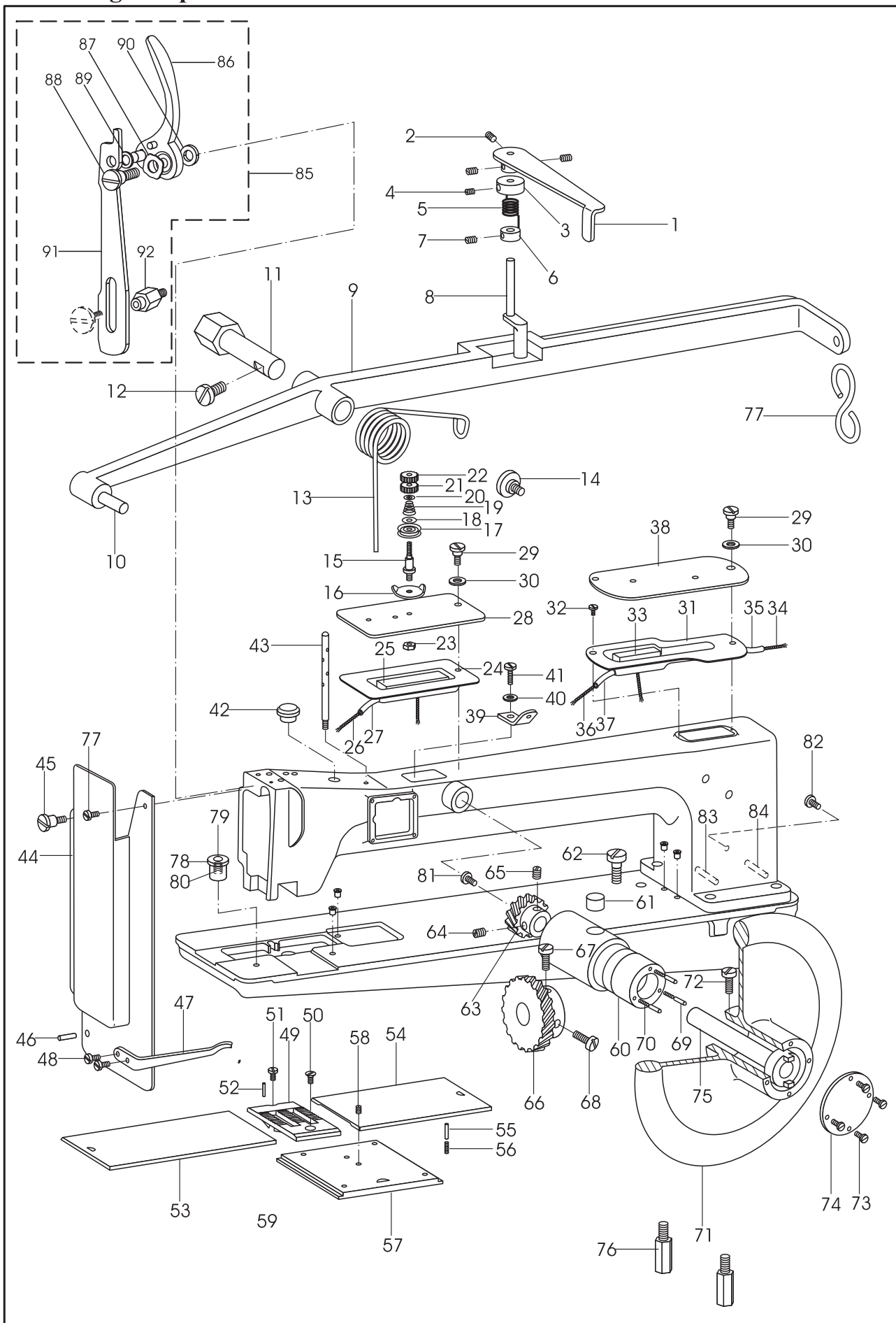
27.Adjusting the pedal(fig.25)

Construct the pedal set complete as shown in the Fig.25



Parts Manual

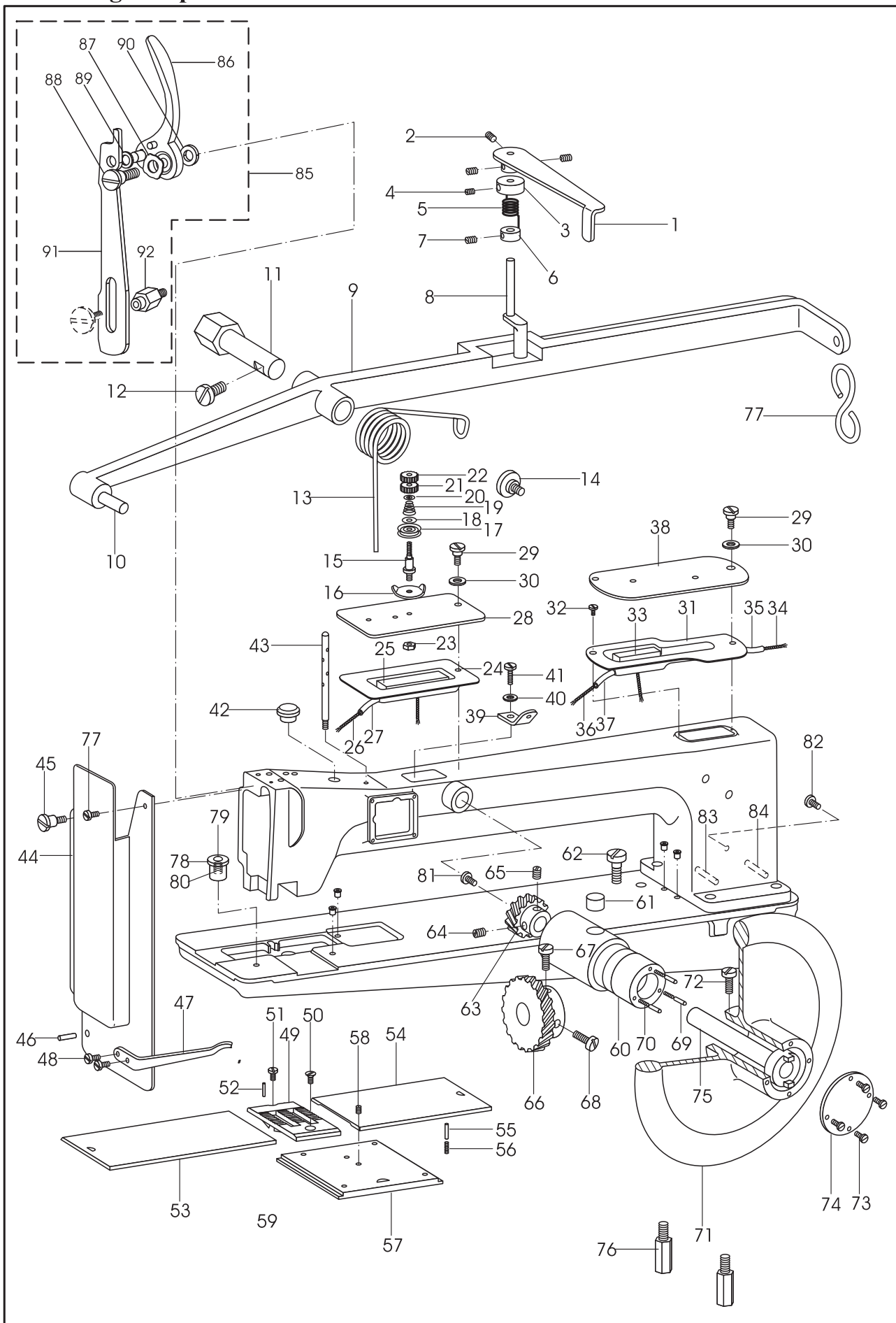
1.Casting components



1. Casting components

Line	Part Number	Description	QTY		Notes
			745R10	744R10	
1	700-1001	Foot lifter lifting handle	-	-	
2	100-1091	Screw	-	-	SM11/64"X40X6
3	700-1002	Collar	-	-	
4	100-1129	Screw	-	-	SM11/64"X40X5
5	700-1003	Spring	-	-	
6	700-1004	Collar	-	-	
7	200-1166	Screw	-	-	SM1/8"X44X5
8	700-1005	Foot lifter lifting latch	-	-	
9	700-1006	Foot lifter lifting lever	-	-	
	700-1007	Foot lifter lifting lever	-	-	
	700-1008	Foot lifter lifting lever	1	1	
10	700-1009	Pin	-	-	
	700-1010	Pin	1	1	
11	700-1011	Stud	-	-	
	700-1012	Stud	1	1	
12	700-1013	Screw	-	-	SM17/64"X32X8.1
13	700-1014	Spring	-	-	
	700-1015	Spring	1	1	
14	700-1016	Screw	1	1	SM17/64"X32X8.1
15	700-1017	Tension stud	1	1	
16	700-1018	Thread guide	1	1	
17	700-1019	Tension disc	2	2	
18	700-1020	Tension release disc	1	1	
19	700-1021	Tension spring	1	1	
20	700-1022	Washer	1	1	
21	700-1023	Nut	1	1	
22	700-1024	Nut	1	1	SM11/64"X40
23	200-1069	Nut	-	-	
24	700-1025	Lubrication oil pad	-	-	
25	700-1026	Oil pad	-	-	
26	700-1027	Oil wick	-	-	L=200mm
27	700-1028	Oil tube	-	-	φ5Xφ3X85
28	700-1029	Cover	-	-	
29	700-1030	Screw	1	1	SM3/16"X28X6.5
30	700-1031	Washer	1	1	
31	700-1032	Lubrication oil cup	1	1	
32	700-1033	Screw	1	1	SM1/8"X44X7
33	700-1034	Oil pad	1	1	45X15X10
34	700-1035	Oil wick	1	1	L=200mm
35	700-1036	Oil tube	1	1	φ5Xφ3X80
36	700-1037	Oil wick	1	1	L=300mm
37	700-1038	Oil tube	1	1	φ5Xφ3X125
38	700-1039	Cover	1	1	
39	700-1040	Bobbin winder thread guide	-	-	
40	700-1041	Washer	-	-	GB/T848 4
41	700-1042	Screw	-	-	SM9/64"X40X8
42	700-1043	Rubber Plug	1	1	
43	700-1044	Thread guide	1	1	
44	700-1045	Face plate	1	1	
45	700-1046	Screw	2	2	SM1/8"X44X7

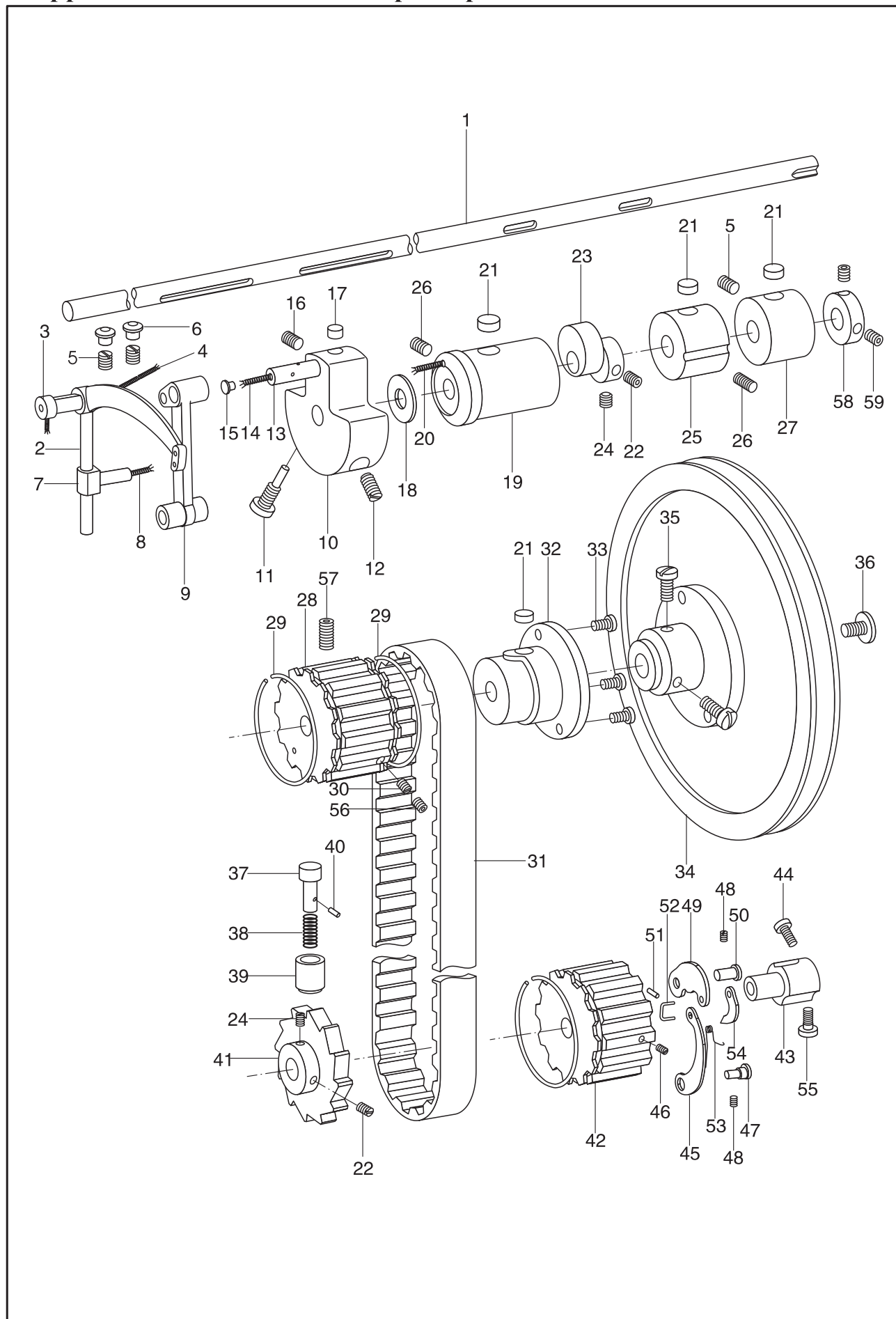
1.Casting components



1. Casting components

Line	Part Number	Description	QTY		Notes
			745R10	744R10	
46	700-1047	Pin	1	1	SM9/64"X40X4.5
47	700-1048	Thread guide	1	1	
48	700-1049	Screw	2	2	
49	700-1050	Needle plate	1	-	
	700-1051	Needle plate	-	1	
50	200-1028	Screw	1	2	SM11/64"X40X8.3
51	200-1029	Screw	1	-	SM9/64"X40X5.4
52	300-1012	Pin	1	-	
53	700-1052	Slide plate (L)	1	-	
	700-1053	Slide plate (L)	-	1	
54	700-1054	Slide plate (R)	1	-	
	700-1055	Slide plate (R)	-	1	
55	700-1056	Screw	1	1	
56	700-1057	Spring	1	1	
57	700-1058	Slide plate (front)	1	1	
58	700-1059	Screw	1	1	SM13/64"X32X4.3
59	700-1060	Spring	1	1	
60	700-1061	Bushing	-	-	
61	700-1062	Oil felt	-	-	
62	700-1063	Screw	-	-	SM17/64"X32X17.5
63	700-1064	Gear (small)	-	-	
64	700-1065	Screw	-	-	SM1/4"X40X5.5
65	700-1066	Screw	-	-	SM1/4"X40X5.5
66	700-1067	Gear (big)	-	-	
67	700-1068	Screw	-	-	SM1/4"X40X13
68	700-1069	Screw	-	-	SM1/4"X40X13
69	700-1070	Pin	-	-	
70	700-1071	Spring	-	-	
71	700-1072	Hand wheel	-	-	
72	700-1073	Screw	-	-	SM1/4"X32
73	100-1123	Screw	-	-	SM11/64"X40X8
74	700-1074	Hand wheel engaging plate	-	-	
75	700-1075	Hand wheel shaft	-	-	
76	700-1076	Machine supporting bolt	3	3	
77	700-1077	Chain hook	1	1	606082
78	700-1078	Ball oiler	5	5	
79	700-1079	Ball	5	5	
80	700-1080	Spring	5	5	
81	700-1081	Screw	-	-	SM17/64"X24X11
82	700-1082	Screw	1	1	256049
83	700-1083	Oil tube (ling)	1	1	
84	700-1084	Oil tube (short)	1	1	
85	700-1085	Manual foot lifter assy.	1	1	
86	700-1086	Lifting Bar	1	1	
87	700-1087	Washer	1	1	
88	700-1088	Screw	1	1	
89	700-1089	Washer	1	1	
90	700-1090	Pin	1	1	GB/T879.1 3X20
91	700-1091	Lifting plate	1	1	
92	700-1092	Screw bar	1	1	

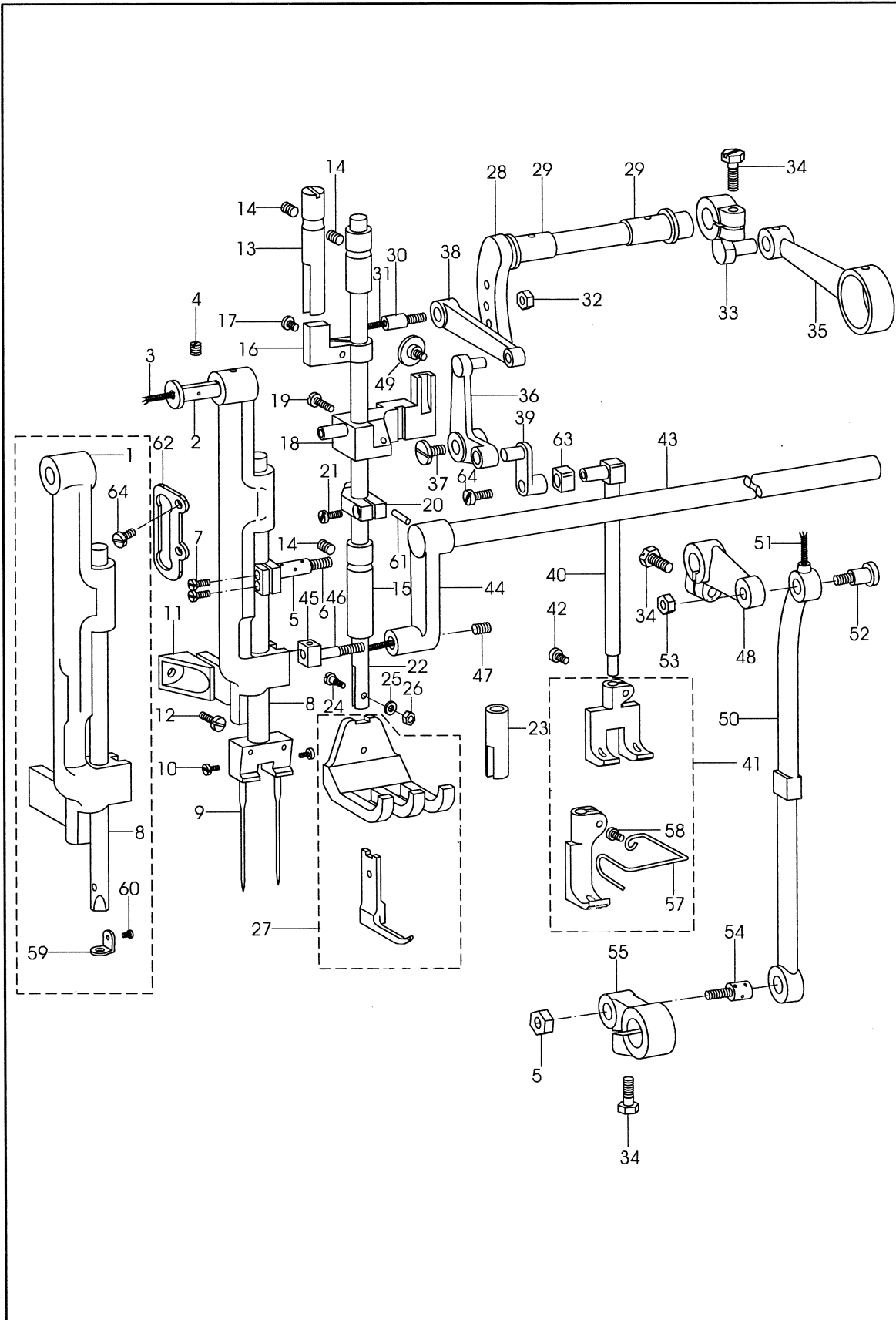
2.Upper shaft and thread take-up componets



2. Upper shaft and thread take-up components

No .	Part Number	Description	QTY		Notes
			745R10	744R10	
1	700-1093	Upper shaft	-	-	
	700-1094	Upper shaft	-	-	
	700-1095	Upper shaft	1	1	
2	700-1096	Thread take-up lever	1	1	
3	700-1097	Hinge stud	1	1	
4	700-1098	Oil wick	1	1	L=200mm
5	700-1099	Screw	3	3	SM17/64"X32X20
6	700-1100	Rubber plug	2	2	
7	700-1101	Take-up lever driving stud	1	1	
8	700-1102	Oil wick	1	1	L=20mm
9	700-1103	Needle bar connecting link	1	1	
10	700-1104	Needle bar crank	1	1	
11	700-1105	Screw	1	1	SM9/32"X28
12	700-1106	Screw	1	1	SM9/32"X28
13	700-1107	Needle bar crank stud	1	1	
14	700-1108	Oil wick	1	1	L=45mm
15	700-1109	Rubber plug	1	1	
16	700-1110	Screw	1	1	SM17/64"X24X6.5
17	700-1111	Screw	1	1	SM17/64"X24X3.5
18	700-1112	Washer	1	1	
19	700-1113	Upper shaft bushing (L)	1	1	
20	700-1108	Oil wick	1	1	L=45mm
21	700-1062	Oil felt	4	4	φ17x10
22	700-1114	Screw	2	2	SM1/4"X32X8
23	700-1115	Feed driving eccentric	1	1	
24	700-1116	Screw	2	2	SM1/4"32X7
25	700-1117	Central bushing (L)	-	-	
26	700-1118	Screw	1	1	SM17/64"X32X11
27	700-1119	Central bushing (R)	1	1	
28	700-1120	Belt pulley	1	1	
29	400-1219	Belt pulley spring flange	3	3	
30	700-1121	Screw	1	1	SM1/4"X28X11
31	700-1122	Timing belt	1	1	
32	700-1123	Upper shaft bushing (R)	1	1	
33	400-1015	Screw	3	3	SM3/1"X32X9.5
34	700-1124	Hand wheel	1	1	
35	700-1125	Screw	2	2	SM17/64"X24X16
36	700-1081	Screw	1	1	SM17/64"X24X11
37	400-1232	Lock button	1	1	
38	400-1234	Spring	1	1	
39	400-1235	Socket	1	1	
40	700-1126	Pin	1	1	GB/T91 1.6X10
41	700-1127	Stop	1	1	
42	700-1128	Safety clutch pulley	1	1	
43	700-1129	Safety clutch collar	1	1	
44	700-1130	Screw	1	1	SM1/4"X32X10.5
45	400-1221	Locking spring lever	1	1	
46	700-1131	Screw	1	1	SM5/32"X40X3.6
47	700-1132	Stud	1	1	
48	400-1228	Screw	2	2	SM7/32"X32X7
49	400-1226	Safety clutch locking lever	1	1	
50	400-1227	Stud	1	1	
51	700-1133	Pin	1	1	GB/T91 1.2X8
52	400-1225	Connecting link	1	1	
53	400-1222	Spring	1	1	
54	400-1224	Latch	1	1	
55	400-1229	Screw	1	1	SM1/4"X32X10.5
56	700-1134	Screw (short)	1	1	SM1/4"X28X6
57	700-1135	Screw (long)	1	1	SM1/4"X28X20
58	700-1136	Collar	1	1	
59	700-1137	Screw	2	2	SM1/4"X32X8

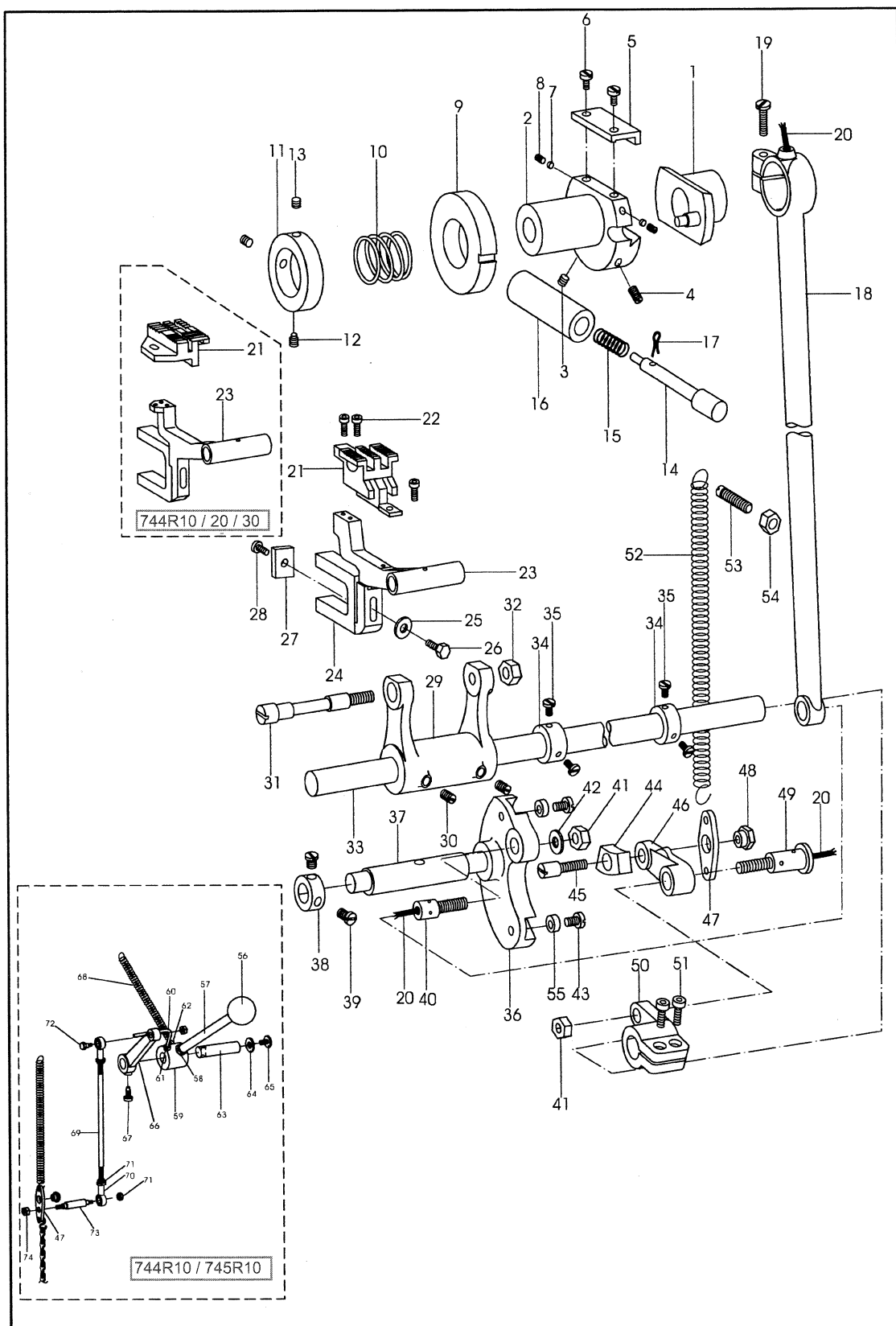
3. Needle bar rocking frame and upper feed components



3. Needle bar rocking frame and upper feed components

No .	Part Number	Description	QTY		Notes
			745R10	744R10	
1	700-1138	Needle bar rocking frame	1	-	L=30mm SM17/64"X32X19.5
	700-1139	Needle bar rocking frame	-	1	
2	700-1140	Stud	1	1	
3	700-1141	Oil wick	1	1	
4	700-1142	Screw	1	1	L=40mm SM9/64"X40X9
5	700-1143	Needle bar connector	1	1	
6	700-1144	Oil wick	1	1	
7	700-1145	Screw	2	2	
8	700-1146	Needle bar	1	-	DD-H14#25 SM3/16"X32X6
	700-1147	Needle bar	-	1	
9	700-1148	Needle	2	1	
10	700-1149	Screw	2	1	
11	700-1150	Position bracket	1	1	SM11/64"X32X9
12	700-1151	Screw	1	1	
13	700-1152	Presser bar position guide	1	1	
14	700-1118	Screw	3	3	
15	700-1153	Presser bar bushing	2	2	SM17/64"X32X11
16	700-1154	Position guide lever	1	1	
17	700-1155	Screw	1	1	
18	700-1156	Presser bar lifting bracket	1	1	
19	700-1157	Screw	1	1	SM11/64"X40X14
20	700-1158	Presser bar spring	1	1	
21	700-1159	Feed bar	1	-	
	700-1160	Feed bar	-	1	
22	700-1161	Presser bar	1	1	SM3/16"X32X13.7
23	700-1162	Holder	1	1	
24	700-1163	Screw	1	1	
25	700-1041	Washer	1	1	
26	700-1164	Nut	1	1	SM0.1339"(3.4)X36 GB/T848 4 SM0.1339"(3.4)X36
27	700-1165	Presser foot	1	-	
28	700-1166	Presser foot	-	1	
29	700-1167	Lifting rock shaft	1	1	
30	700-1168	Bushing	2	2	L=30mm
31	700-1169	Screw stud	1	1	
32	700-1170	Oil wick	1	1	
33	700-1171	Nut	1	1	
34	700-1172	Lifting eccentric	1	1	SM1/4"X28
35	700-1125	Screw	3	3	
36	700-1173	Lifting eccentric connection	1	1	
37	700-1174	Lifting bell crank	1	1	
38	700-1175	Screw	1	1	SM11/64"X40X8
39	700-1176	Link	1	1	
40	700-1177	Vibrating presser bar link	1	1	
41	700-1178	Vibrating presser bar	1	1	
42	700-1179	Walker foot	1	-	SM11/64"X40X7.5
43	700-1180	Walker foot	-	1	
44	700-1181	Screw	1	1	
45	700-1182	Rocking shaft	-	-	
46	700-1183	Rocking shaft	-	-	SM7/32"X32X7
47	700-1184	Rocking shaft	1	1	
48	700-1185	Link	1	1	
49	700-1186	Slide block	1	1	
50	700-1187	Slide block stud	1	1	SM17/64"X32X8.1
51	400-1228	Screw	1	1	
52	700-1188	Crank	1	1	
53	700-1016	Screw	1	1	
54	700-1189	Crank connection	1	1	L=15mm SM17/64"X24X12.5 SM17/64"X24
55	700-1190	Oil wick	1	1	
56	700-1191	Screw	1	1	
57	700-1192	Nut	1	1	
58	700-1193	Screw	1	1	SM0.3091"X20
59	700-1194	Feed reverse crank	1	1	
60	700-1195	Nut	1	1	
61	700-1196	Finger guard	1	1	
62	200-1166	Screw	1	1	SM3/32"X56X2.5
63	700-1197	Needle bar thread guide	-	1	
64	100-1042	Screw	-	1	
65	700-1198	Pin	1	1	
	700-1199	Guider	1	1	
	400-1131	Slide block	2	2	
	700-1200	Screw	1	1	
	200-1019	Screw	2	2	

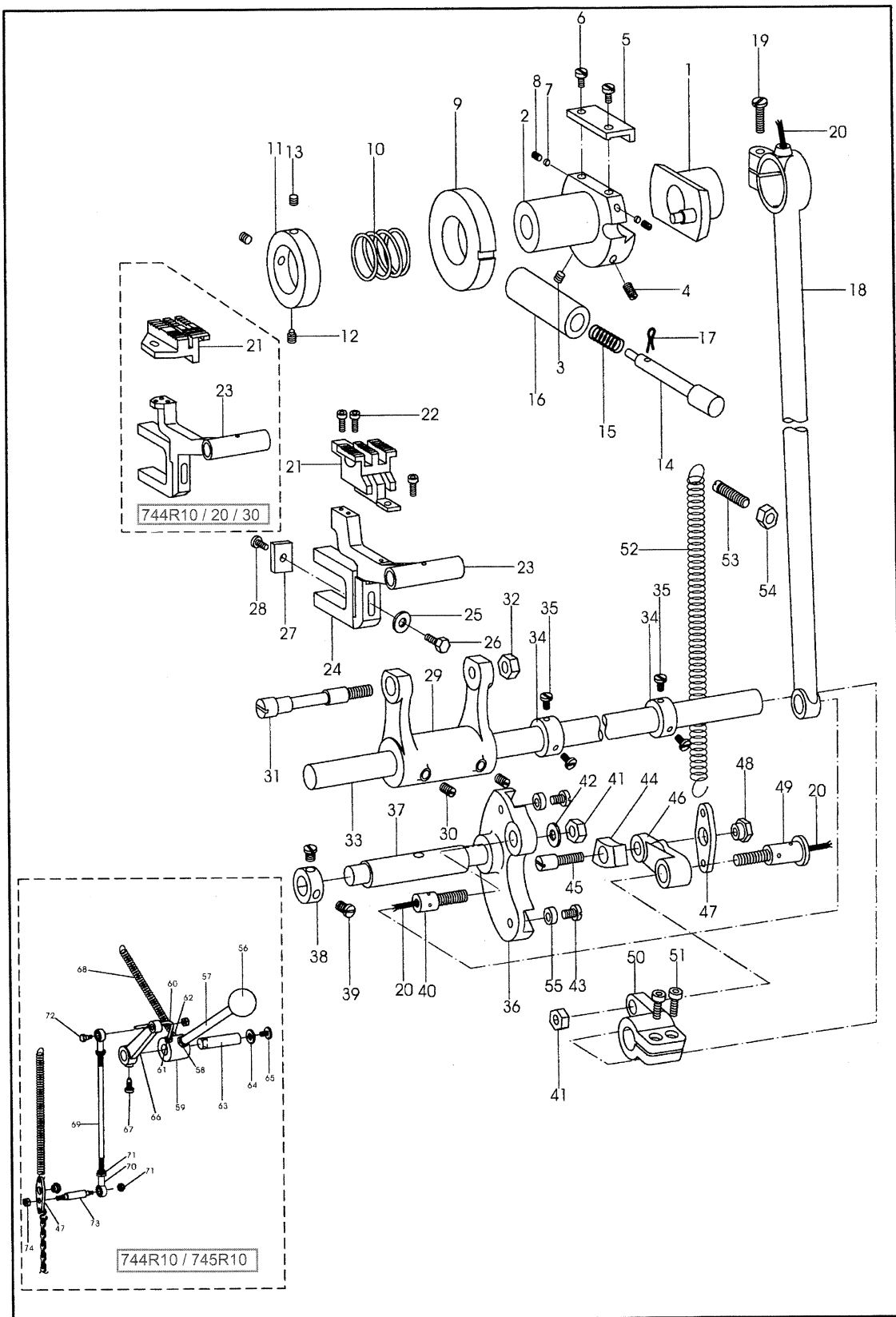
4.Feed components



4. Feed components

No .	Part Number	Description	QTY		Notes
			745R10	744R10	
1	700-1201	Feed driving eccentric	1	1	
2	700-1202	Flange	1	1	
3	700-1203	Screw	1	1	SM3/16"X32X10.5
4	700-1204	Screw	1	1	SM3/16"X32X10.5
5	700-1205	Friction plate	1	1	
6	700-1206	Pinch screw	2	2	SM3/16"X40X11
7	700-1207	Lining metal	2	2	
8	100-1091	Screw	2	2	SM11/64"X40X6
9	700-1208	Adjusting disc	1	1	
10	700-1209	Spring	1	1	
11	700-1210	Collar	1	1	
12	700-1114	Screw	1	1	SM1/4"X32X8
13	700-1211	Screw	2	2	SM1/4"X32X5.5
14	700-1212	Feed regulating stud	1	1	
15	700-1213	Spring	1	1	
16	700-1214	Bushing	1	1	
17	700-1126	Retaining spring	1	1	GB/T91 1.6X10
18	700-1215	Feed driving connection	1	1	
19	700-1157	Screw	1	1	SM11/64"X40X14
20	700-1216	Oil wick	3	3	L=20mm
21	700-1217	Feed dog	1	-	
	700-1218	Feed dog	-	1	
22	700-1219	Screw	3	3	
23	700-1159	Feed bar	1	-	
	700-1160	Feed bar	-	1	
24	700-1220	Feed lifting cam fork	1	1	
25	700-1221	Washer	1	1	GB/T97.2 6
26	700-1222	Screw	1	1	SM7/32"X32X15
27	700-1223	Oil felt	1	1	
28	200-1286	Screw	1	1	SM1/8"X40X3.3
29	700-1224	Feed bar crank	1	1	
30	700-1225	Screw	2	2	SM17/64"X24X7.5
31	700-1226	Feed bar hinge screw	1	1	
32	700-1192	Nut	1	1	SM17/64"X24
33	700-1227	Feed shaft	-	-	
	700-1228	Feed shaft	-	-	
	700-1229	Feed shaft	1	1	
34	700-1230	Collar	2	2	
35	700-1231	Screw	4	4	SM1/4"X32X4.5
36	700-1232	Feed reversing crank	1	1	
37	700-1233	Bushing	1	1	
38	700-1234	Collar	1	1	
39	700-1235	Screw	2	2	SM11/64"X32X6.5
40	700-1236	Hinge screw	1	1	SM0.309" (7.85)X20
41	700-1195	Nut	2	2	SM0.309" (7.85)X20
42	700-1237	Washer	1	1	GB938
43	700-1238	Screw	2	2	SM3/16"X32X11
44	700-1239	Slide block	1	1	
45	700-1240	Hinge screw	1	1	SM15/64"X28X10
46	700-1241	Feed reverse link	1	1	

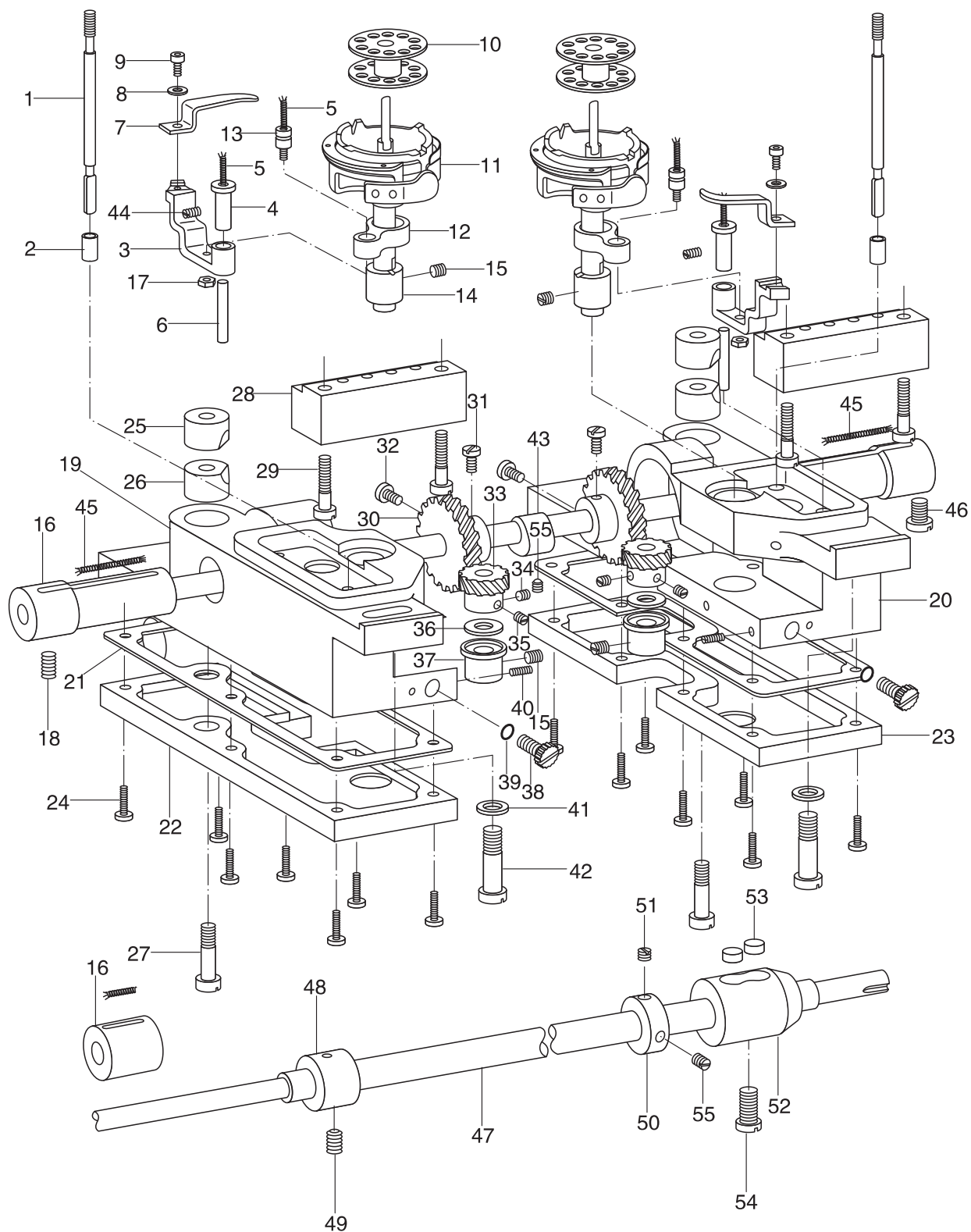
4.Feed components



4. Feed components

			QTY		Notes
No .	Part Number	Description	745R10	744R10	
47	700-1242	Connecting link	1	1	SM15/64"X28 M6X1X20
48	700-1243	Nut	1	1	
49	700-1244	Hinge screw	2	2	
50	700-1245	Feed crank	1	1	
51	700-1246	Screw	2	2	
52	700-1247	Spring	1	1	SM5/16"X24
53	700-1248	Spring holder	1	1	
54	700-1249	Nut	1	1	
55	700-1250	Eccentric cam	2	2	
56	700-1251	Handle	1	1	
57	700-1252	Reverse stitch lever	1	1	SM5/16"X28 M5
58	700-1253	Nut	1	1	
59	700-1254	Bush	1	1	
60	700-1255	Stop lever	1	1	
61	700-1256	Nut	1	1	
62	700-1257	Spring hook	1	1	SM3/16"X28X7
63	700-1258	Shaft	1	1	
64	700-1259	Washer	1	1	
65	700-1260	Screw	1	1	
66	700-1261	Crank	1	1	
67	100-1145	Screw	1	1	M5X0.8
68	700-1262	Spring	1	1	
69	700-1263	Lever	1	1	
70	700-1264	Connector Assy.	2	2	
71	700-1265	Nut	4	4	
72	700-1266	Screw bar	1	1	
73	700-1267	Screw shaft	1	1	
74	700-1268	Nut	1	1	

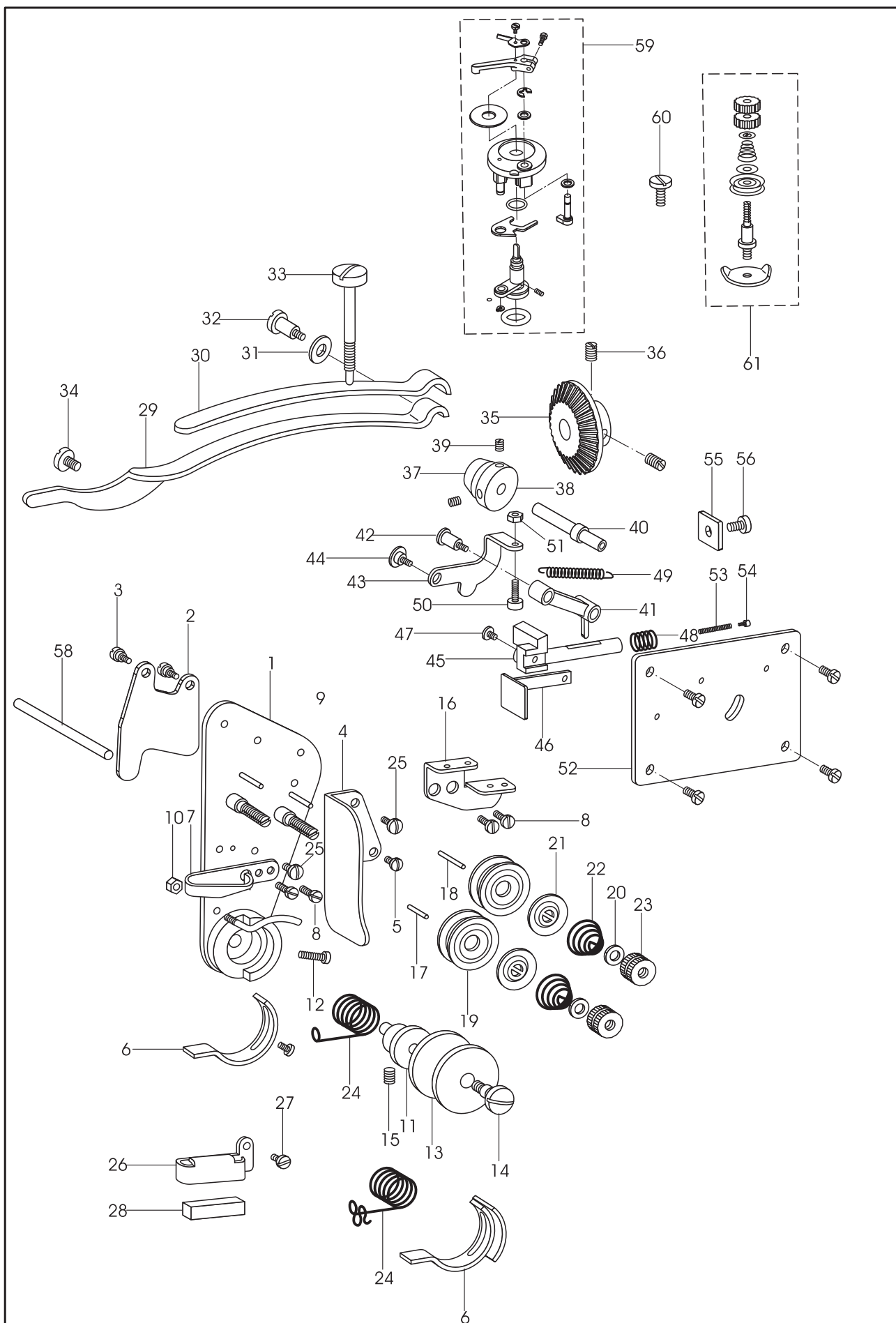
5.Hook components



5. Hook components

No .	Part Number	Description	QTY		Notes
			745R10	744R10	
1	700-1269	Oil gauge	2	1	φ5x10
2	700-1270	Oil gauge guide	2	1	
3	700-1271	Bobbin case opener lever	2	1	
4	700-1272	Hinge stud	2	1	
5	700-1273	Oil wick	4	2	
6	700-1274	Oil tube	2	1	GB/T848 3 M3X0.5X6
7	700-1275	Bobbin case opener	2	1	
8	400-1305	Washer	2	1	
9	700-1276	Screw	2	1	
10	700-1277	Bobbin	2	1	
11	700-1278	Hook	2	1	SM7/32"X32x5.5
12	700-1279	Bobbin case opener link	2	1	
13	700-1280	Roller	2	1	
14	700-1281	Bushing	2	1	
15	700-1282	Screw	4	2	
16	700-1283	Bushing (L)	2	1	SM11/64"X40 SM5/16"X24X12.5
	700-1284	Bushing (L)	-	1	
17	700-1285	Nut	2	1	
18	700-1286	Screw	1	1	
19	700-1287	Left hook saddle	1	-	
20	700-1288	Right hook saddle	1	1	SM9/64"X40X11
21	700-1289	Gasket	2	1	
22	700-1290	Oil reservoir (L)	1	-	
23	700-1291	Oil reservoir (R)	1	1	
24	700-1292	Screw	14	7	
25	700-1293	Collar (upper)	2	1	SM15/64"X28X32
26	700-1294	Collar (lower)	2	1	
27	200-1179	Screw	2	1	
28	700-1295	Block	2	1	
29	700-1296	Screw	4	2	
30	700-1297	Hook driving gear	2	1	SM1/4"X40X9 SM1/4"X40X8
31	700-1298	Screw	2	1	
32	700-1299	Screw	2	1	
33	700-1300	Hook driving pinion	2	1	
34	700-1301	Screw A	2	2	
35	700-1302	Screw B	2	1	SM1/4"X40X5.5 SM1/4"X40X4.5
36	700-1303	Washer	2	1	
37	700-1304	Bushing (lower)	2	1	
38	700-1305	Oil regulating dial	2	1	
39	700-1306	Dial ring	2	1	
40	700-1307	Screw	2	1	SM1/8"X40X8 SM17/64"X24
41	700-1308	Washer	2	1	
42	700-1309	Screw	2	1	
43	700-1310	Feed lifting cam	1	1	
44	700-1311	Screw	2	1	
45	700-1312	Oil wick	2	1	L=90mm SM17/64"X32X17.5
46	700-1063	Screw	1	1	
47	700-1313	Lower shaft	-	-	
	700-1314	Lower shaft	-	-	
	700-1315	Lower shaft	1	1	
48	700-1316	Bushing (middle)	1	1	SM1/4"X32X7 SM1/4"X32X4.5
49	700-1116	Screw	1	1	
50	700-1230	Collar	1	1	
51	700-1231	Screw	2	2	
52	700-1317	Bushing (right)	1	1	
53	700-1062	Oil felt	1	1	φ17x10 SM17/64"X32X13 SM1/4"X32X5.5
54	700-1318	Screw	1	1	
55	700-1319	Screw	2	2	

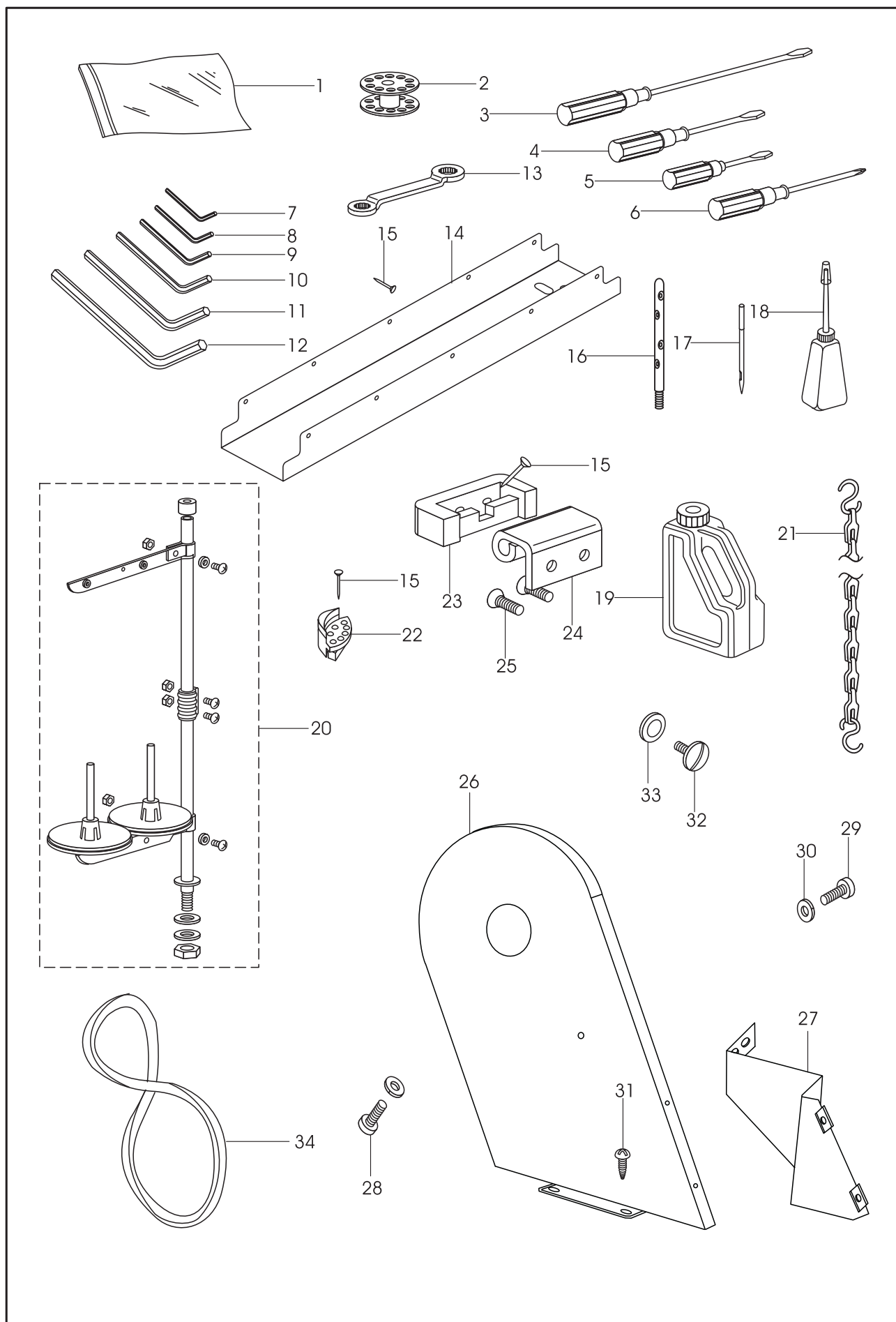
6.Thread tension components



6. Thread tension components

No .	Part Number	Description	QTY		Notes
			745R10	744R10	
1	700-1320	Tension bracket CPL.	1	1	
	700-1321	Tension bracket CPL.	-	1	
2	700-1322	Tension release lever	1	1	
	700-1323	Tension release lever	-	1	
3	700-1324	Screw	2	2	SM9/64"X40X2.5
4	700-1325	Covering plate	1	1	SM9/64"X40X6
5	700-1326	Screw	1	1	
6	700-1327	Thread controller spring stop	1	1	
	700-1328	Thread controller spring stop	-	1	
7	700-1329	Thread guide	1	1	SM9/64"X40X4
8	700-1330	Screw	4	4	
9	700-1331	Thread guide (lower)	1	1	
	700-1332	Thread guide (lower)	-	1	
10	700-1333	Nut	1	1	SM1/8"X40
11	700-1334	Thread controller spring stud	1	1	
12	700-1151	Screw	1	1	SM11/64"X32X9
13	700-1335	Thread controller disc	2	1	
14	700-1336	Thread controller stud	1	1	
	700-1337	Thread controller stud	-	1	
15	700-1338	Screw	1	1	SM11/64"X32X4
16	700-1339	Thread guide	1	1	
	700-1340	Thread guide	-	1	
17	700-1341	Tension release (short)	1	1	
18	700-1342	Tension release (long)	1	-	
19	700-1019	Tension disc	4	2	
20	700-1343	Washer	2	1	
21	700-1344	Tension release disc	2	1	
22	700-1345	Tension spring	2	1	
23	700-1346	Tension nut	2	1	SM11/64"X32X6.5
24	700-1347	Tension controller spring	1	1	
	700-1348	Tension controller spring	-	1	
25	700-1235	Screw	2	2	
26	700-1349	Thread guide	1	-	SM9/64"X40X6.5
27	700-1350	Screw	1	-	
28	700-1351	Felt	1	-	
29	700-1352	Presser bar spring (flat)	1	1	
30	700-1353	Presser bar spring (auxiliary)	1	1	
31	700-1354	Washer	1	1	
32	700-1355	Screw	1	1	
33	700-1356	Regulating screw	1	1	
34	700-1016	Screw	1	1	
35	700-1357	Bobbin winder driving gear	-	-	
	700-1358	Bobbin winder driving gear	1	1	SM1/4"X40X7
36	400-1203	Screw	-	-	
	400-1191	Screw	2	2	
37	700-1359	Friction roller	1	1	SM11/64"X40
38	700-1360	Friction roller base	1	1	
39	200-1273	Screw	2	2	
40	700-1361	Bobbin winder shaft	1	1	
41	700-1362	Bobbin winder link	1	1	
42	700-1363	Screw	1	1	
43	700-1364	Connecting plate	1	1	
44	700-1365	Screw	1	1	
45	700-1366	Bobbin winder release lever	1	1	M4X5
46	700-1367	Bobbin winder set lever	1	1	
47	700-1368	Screw	1	1	
48	700-1369	Reset spring	1	1	
49	700-1370	Reset spring	1	1	GB/T6170 M4
50	700-1371	Screw	1	1	
51	700-1372	Locking nut	1	1	
52	700-1373	Bobbin winder bracket	1	1	
53	700-1374	Spring	1	1	
54	700-1375	Stop bud	1	1	
55	700-1376	Stopper	1	1	
56	400-1146	Screw	1	1	SM11/64"X40X6
57	700-1151	Screw	4	4	SM11/64"X32X9
58	700-1377	Tension release pin	1	1	
59	700-1378	Bobbin thread winder assy.	1	1	
60	400-1244	Screw	3	3	
61	700-1379	Bobbin thread tension assy.	1	1	

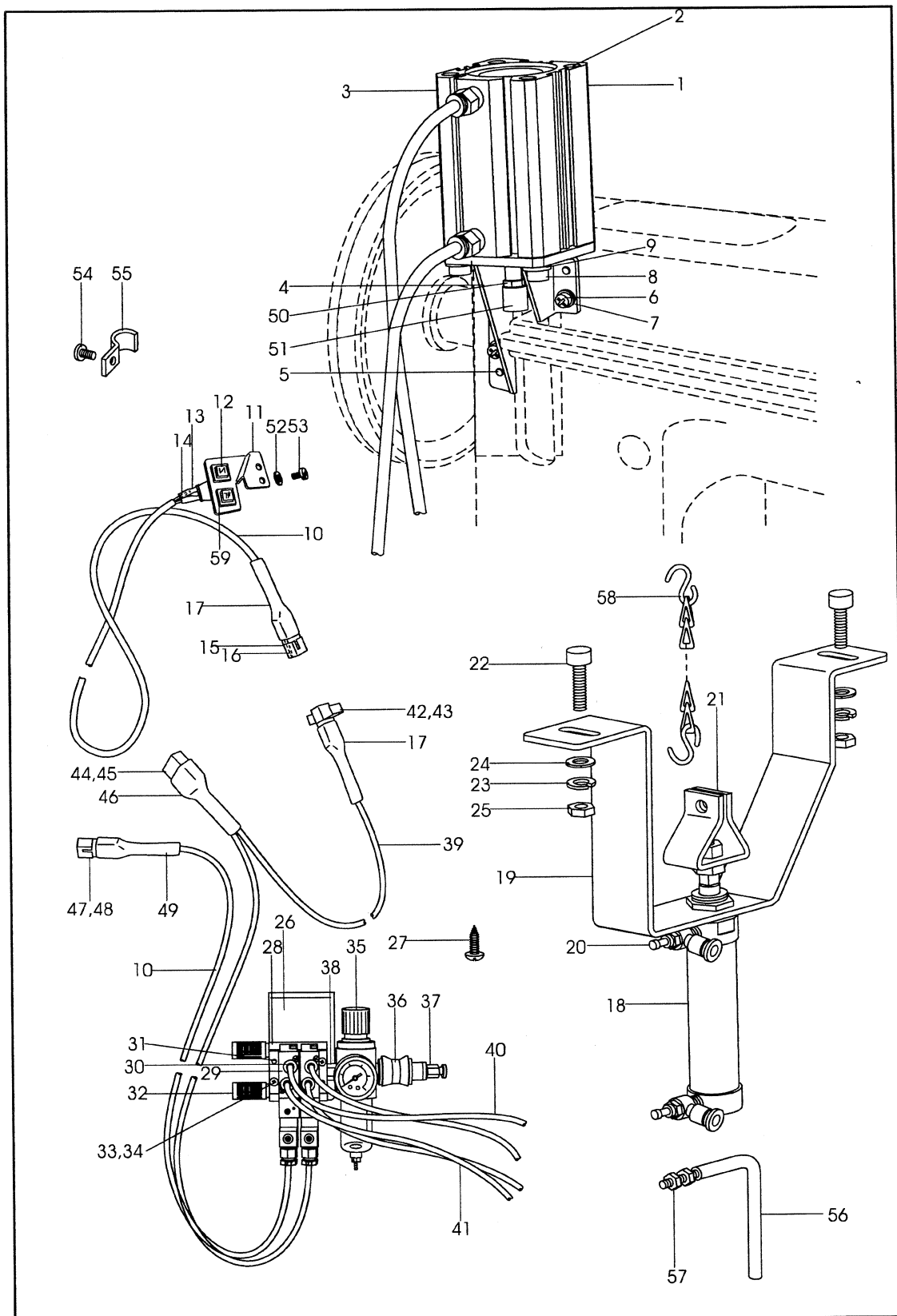
7.Accessories



7. Accessories

No .	Part Number	Description	QTY		Notes
			745R10	744R10	
1	100-1299	Parts bag	1	1	
2	700-1277	Bobbin	12	5	
3	100-1302	Screwdriver (big)	1	1	
4	100-1301	Screwdriver (middle)	1	1	
5	100-1300	Screwdriver (small)	1	1	
6	700-1380	Screwdriver (middle)	1	1	
7	700-1381	Allen key	1	1	S=1/16"
8	700-1382	Allen key	1	1	S=2mm
9	200-1362	Allen key	1	1	S=2.5mm
10	200-1361	Allen key	1	1	S=3mm
11	700-1383	Allen key	1	1	S=4mm
12	700-1384	Allen key	1	1	S=5mm
13	700-1385	Wrench	1	1	10X11
14	700-1386	Drip Pan	-	-	SG162-79 L=22
	700-1387	Drip Pan	-	-	
	700-1388	Drip Pan	1	1	
15	700-1389	Nail	13	13	
16	700-1044	Thread guide pin	1	1	
17	700-1390	Needle	6	3	DD-H14 #25
18	100-1309	Oil pot	1	1	
19	100-1314	Oil tank	1	1	
20	300-1025	Thread stand	1	-	
	100-1315	Thread stand	-	1	
21	700-1391	Chain	1	1	
22	700-1392	Vibration free pad	4	4	
23	100-1311	Machine hinge cushion	3	3	
24	700-1393	Machine hinge	3	3	
25	700-1394	Screw	6	6	SM17/64"X32X7.5
26	700-1395	Belt cover (1)	1	1	
27	700-1396	Belt cover (2)	1	1	
28	100-1264	Screw (1)	2	2	SM15/64"X28X8
29	700-1397	Screw (2)	2	2	GB/T818 M5X12
30	700-1398	Washer	2	2	GB/T97.2 5
31	700-1399	Screw	2	2	GB845 ST6X20
32	100-1054	Screw	2	2	SM11/64"X40X9
33	200-1377	Washer	2	2	
34	700-1400	Belt	1	1	54V

8. -AL(N) components



8.-AL(N) components

No .	Part Number	Description	Qty	Notes
1	700-1401	Cylinder	1	ACQ50X60
2	700-1402	Screw	2	APH6-02
3	700-1403	Joint	2	
4	700-1404	Support	1	
5	700-1198	Fixed pin	2	
6	700-1405	Screw	3	GB/T70.1 M5X14
7	700-1406	Washer	3	GB93.5
8	700-1407	Screw	2	GB/T70.1 M8X25
9	700-1408	Washer	2	GB93 8
10	700-1409	Switch wire	3	L=140MM
11	700-1410	Fixed plate	1	
12	700-1411	Button	1	
13	700-1412	Cover	2	
14	700-1413	Plug	2	
15	700-1414	Cover (1)	1	
16	700-1415	3191 pin	2	MAL25X50
17	700-1416	Cover	2	
18	700-1417	Cylinder	1	
19	700-1418	Plate	1	
20	700-1419	Joint	2	
21	700-1420	Bracket	1	GB/T70.1-2000 M8X80
22	700-1421	Screw	2	
23	700-1408	Washer	2	
24	700-1422	Washer	2	
25	700-1423	Nut	2	
26	700-1424	Plate	1	GB100 3X16
27	700-1425	Screw	2	
28	700-1426	Bracket	1	
29	700-1427	Electric valve	2	
30	700-1428	Joint	4	
31	700-1429	Closed joint	3	G1/4
32	700-1430	Silence	2	GB/T818 M4X30
33	700-1431	Screw	4	
34	700-1432	Nut	4	
35	700-1433	Air regulator	1	
36	700-1434	Handle adjusting valve	1	
37	700-1435	Joint	1	APC8-02
38	700-1436	Joint	1	L=950mm
39	700-1437	Wire	1	
40	700-1438	Air pipe	2	
41	700-1439	Air pipe	2	PU6X4 L1300mm
42	700-1440	Cover (2)	1	
43	700-1441	3191 pin	2	
44	700-1414	Cover	1	
45	700-1442	3191 pin	4	
46	700-1443	Cover	1	GB/T6170 M10
47	700-1414	Cover	1	
48	700-1444	3191 pin	2	
49	700-1445	Cover	1	
50	700-1446	Nut	1	
51	200-1377	Joint	1	SM9/64"X40X12
52	100-1112	Washer	1	
53	700-1448	Screw	1	
54	700-1449	Screw	6	
55	700-1450	Wire clamp	6	
56	700-1451	Support	1	SM15/64"X28
57	700-1452	Nut	2	
58	700-1453	Chain	1	
59	700-1454	Button	1	