

Rimoldi®

SPARE PARTS CATALOGUE

CATALOGO PEZZI DI RICAMBIO

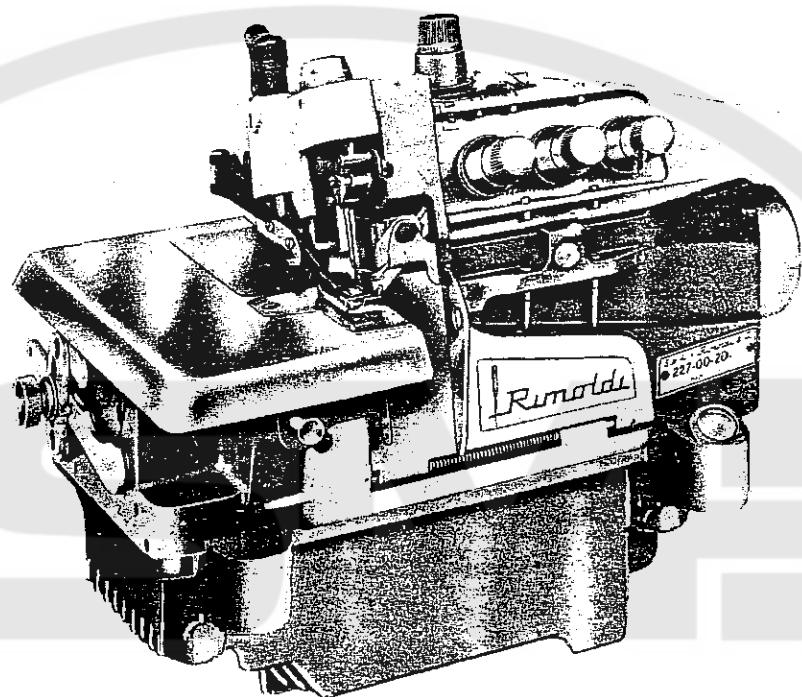
CATALOGUE RECHANGES

ERSATZTEILELISTE

class 227-00-20
and subclasses
227-00-32



Rimoldi



SPARE PARTS CATALOGUE

class **227-00-20**

and subclasses

227-00-32







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INSTRUCTIONS FOR USE

a) Introduction

1. The Spare Parts Catalogue consists of a set of illustrations of the different mechanisms or assemblies making up the basic machine head and its subclasses.
2. For easy look-up, the illustration index shows the position of each assembly on the machine.
3. The conversion groups of the basic head and its subclasses are illustrated in individual drawings.
4. The illustrations show the number identifying subclasses printed in bold type at top right.
5. On each illustration the single parts of the assembly shown are identified by a number. Assemblies of which parts cannot be supplied separately, are identified by capital letters. Parts and devices which are not standard equipment with the machine but which can be supplied on request are listed at the bottom of each illustration page and illustrated complete with all components at the end of the catalogue.
6. The catalogue carries a general list of parts in numerical order by drawing number, covering all the parts in our machines, with the number of the illustration where the part can be found.

II. ORDER PLACING PROCEDURE

a) All spare parts

The following instructions should be carefully followed to make sure that required spare parts are shipped without delay:

1. State machine head serial number
2. State drawing number of spare parts ordered.
3. Write name of spare part required in full.
4. State quantity required.

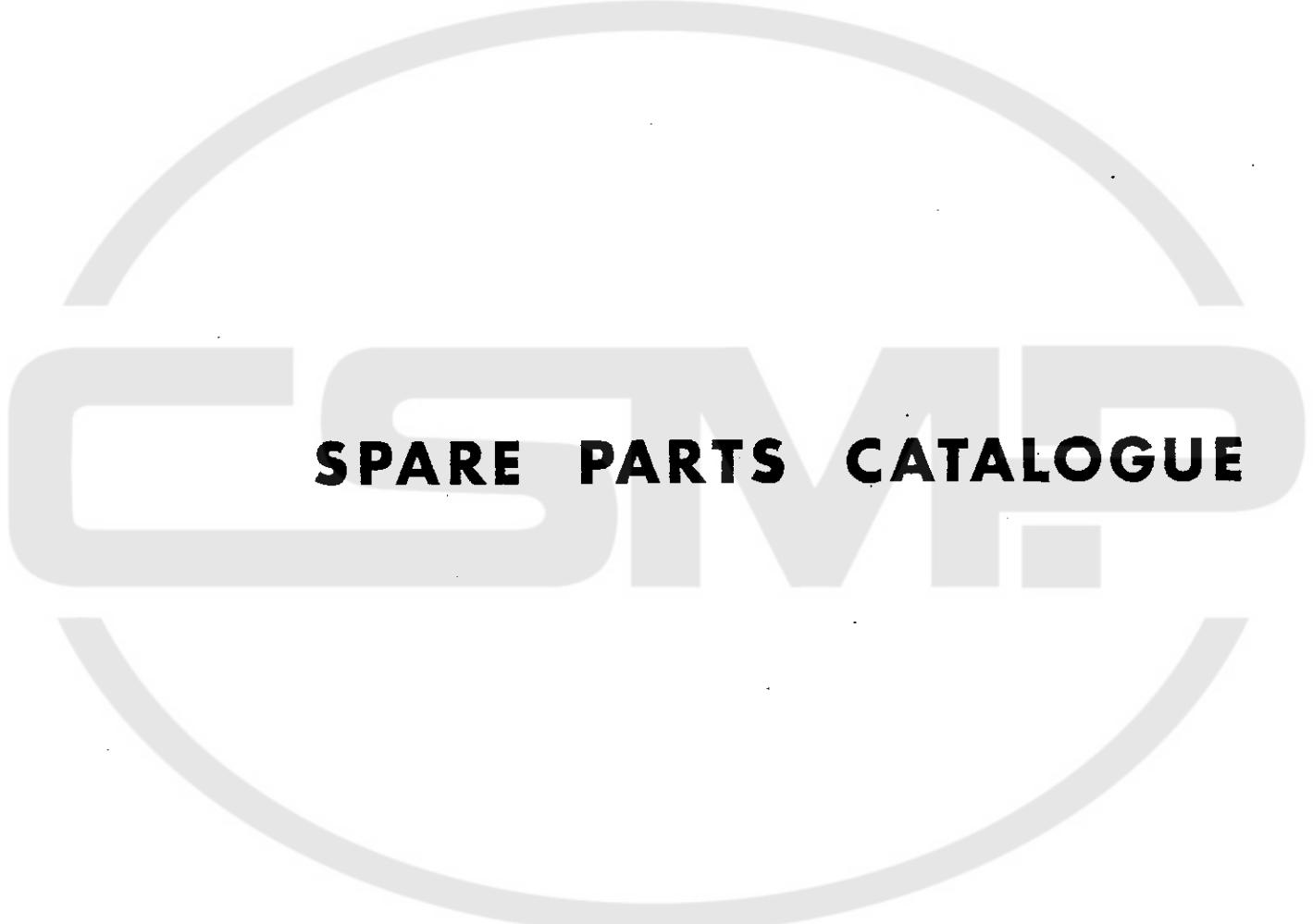
IMPORTANT

RIMOLDI are desirous of thoroughly studying all cases of breakage, wear or unsatisfactory performance encountered with parts they have manufactured. For this reason, such parts should be dispatched together with the spare part order.

b) Needles

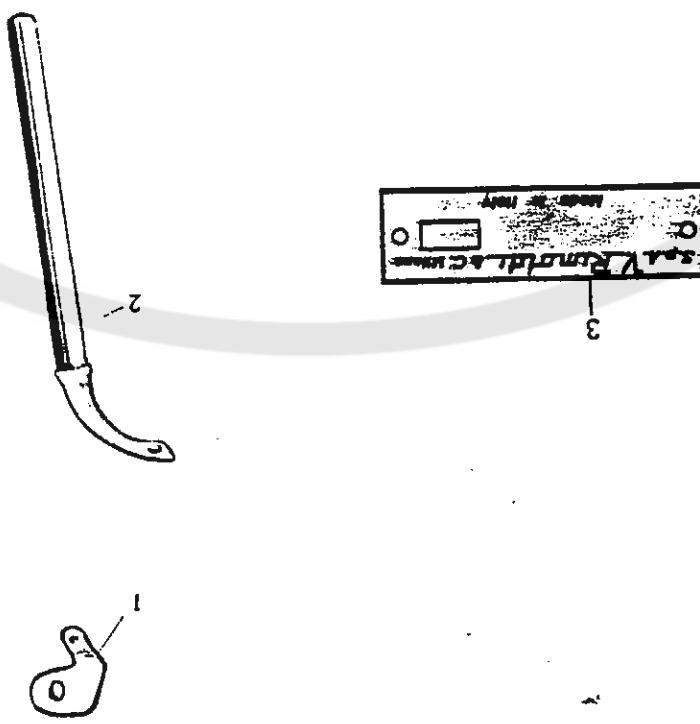
1. Only straight RIM 27 needles should be used on the machine heads illustrated in this catalogue.
2. The needle system and size are marked on the needle shank.
3. The gauge indicates the average diameter in hundredths of a millimetre taken on the blade of the needle.
4. The system and size are also stamped on the RIMOLDI needle envelope.
5. When ordering, always state clearly the required needle system and size. (Example: 100 needles, size 90, system RIM 27).
6. In case of doubt, attach a sample needle or an empty envelope of the needle required.
7. For sewing elastic or elasticised materials special ball-point needles classed as SKU are available.

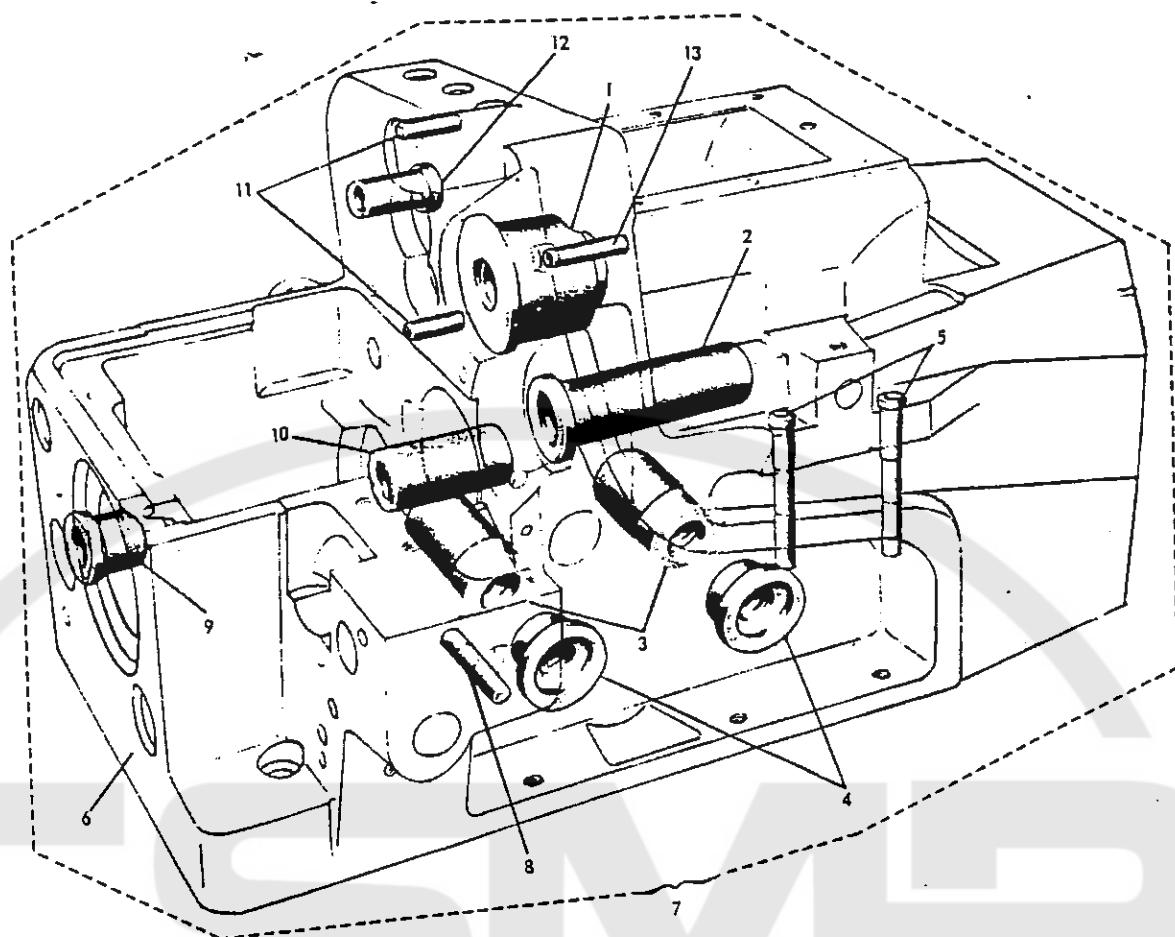




SPARE PARTS CATALOGUE

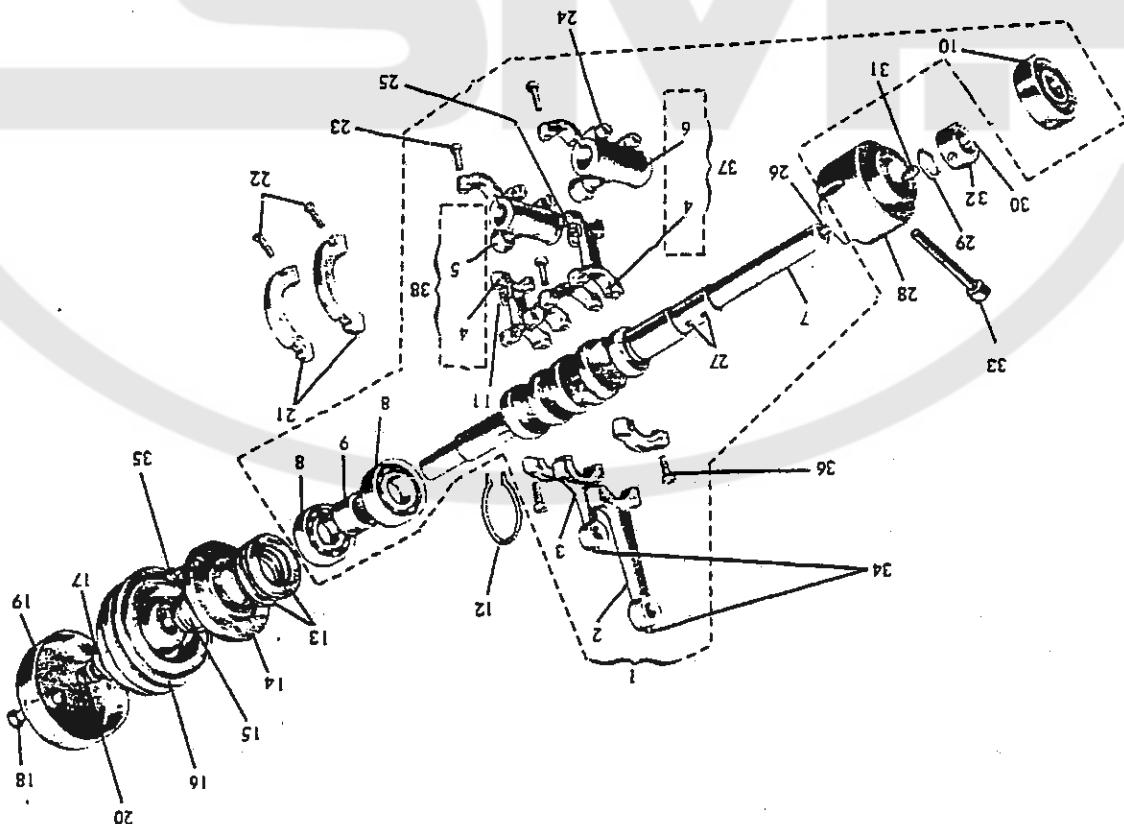
REF.	PART N.	DESCRIPTION	QTY.	REF.	PART N.	DESCRIPTION	QTY.	REF.	PART N.	DESCRIPTION	QTY.
1	21377-142	drive, guide secondary; scope second bay type	1	2	21377-143	drive, type, scope plate	1	3	21377-143	drive, type, scope plate	1
4	21377-145	drive, guide secondary; scope	1	5	21377-146	drive, guide secondary; scope	1	6	21377-147	drive, guide secondary; scope	1
7	21377-148	drive, guide secondary; scope	1	8	21377-149	drive, guide secondary; scope	1	9	21377-150	drive, guide secondary; scope	1

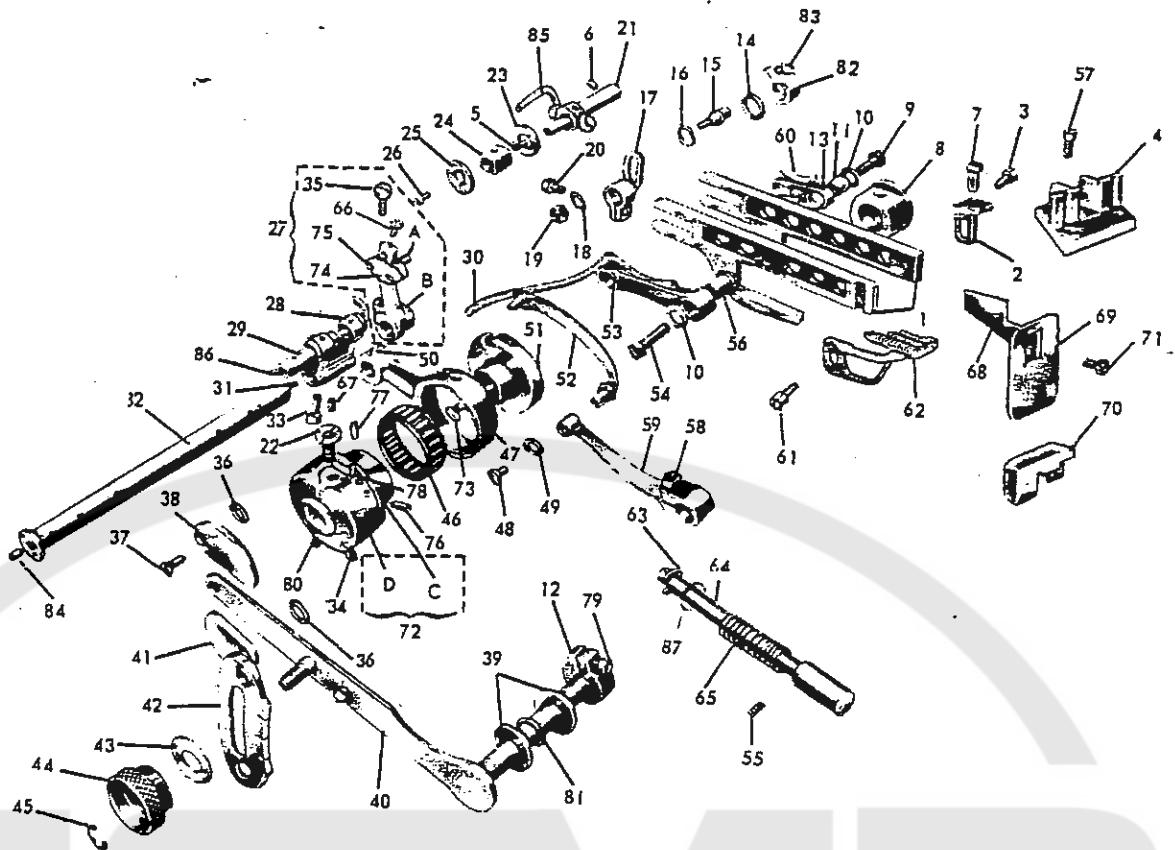




REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-016	bushing, needle bar shaft	1	8	270-912	latch pin, workplate	1
2	270-097/1	bushing, upper knife holder	1	9	202045-0-11	bushing, differential shaft	1
3	270-058/2	rear bushing, looper shaft	2	10	270-042/3	bushing (left), differential shaft	1
4	270-057/1	front bushing, looper shaft	2	11	270-642	pin, coverplate centering	2
5	270-268	guide tube, looper thread	2	12	270-082/1	bushing, presserfoot lifter lever	1
6	202004-0-11	base, machine	1	13	270-264	thread guide, needle	1
7	202005-3-11	base with bushings and thread guides					

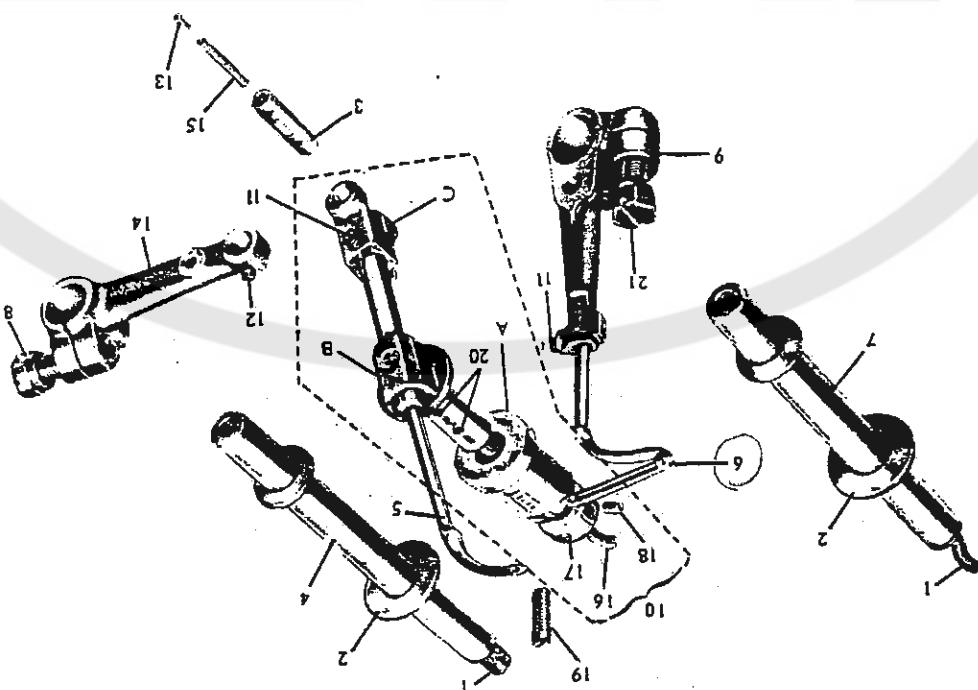
REF.	PART.	Nº	DESCRIPTION	QTY	Nº	PART.	Nº	DESCRIPTION	QTY
1	PM 277-009/3		main shaft, with connecting rods	1	20	270-510		pivot, handwheel	1
2	280-012/3		control rod, needle bar	1	21	270-617/2		rockers	1
3	270-116/2		control rod, knife	1	22	270-999		screws, rocker	1
4	270-061/2		control rod, secondary looper	1	23	010-H-13,7		screws, for control rods 280-012/3	1
5	270-060/1		control rod, secondary looper	1	24	270-975		screws, for control rods 270-116/2	1
6	270-059/1		slipper, primary looper control rod	1	25	290-944		lock-screw, main shaft	2
7	270-009/4		main shaft	1	26	092-D-14		oil-wick, main shaft	2
8	270-707		ball bearing, right	1	27	092-C-2		lock-screw, connecting rod guide	1
9	270-613		ball bearing, left	1	28	270-010/2		wicks	1
10	270-709		spacer, bearing	1	29	074-A-12		bushes, intermediate	1
11	270-062		spacers, cup	1	30	270-722		washer, differential	1
12	270-704		snap-ring, right ball bearing	1	31	270-750		ring, adjustment	1
13	270-705		guide, connecting rod	1	32	010-D-5		cap, main shaft	1
14	260-620		flange, right	1	33	270-938		lock-screw, intermediate bush	1
15	270-614		spacer, main shaft right	1	34	0123-N-6,5		lock-screw, pin	1
16	270-612/1		handwheel	1	35	001-E-10		grub-screws, pin	1
17	270-614		handwheel	1	36	010-D-11,5		screws, right flange	1
18	270-981		washer, with guide	1	37	PM 270-059/1		cover, upper control rod	1
19	270-608/5		cover with handwheel	1	38	PM 270-060/1		sleeve assembly	1
20	PM 276-B-009/6		main shaft, with connecting rods	1					
21	PM 270-009/3		main shaft, with connecting rods	1					
22	270-061/2		control rod, needle bar	1					
23	270-999		control rod, secondary looper	1					
24	270-975		slipper, primary looper control rod	1					
25	010-H-13,7		control rod, secondary looper	1					
26	092-D-14		lock-screw, connecting rod guide	1					
27	092-C-2		oil-wick, main shaft	1					
28	270-010/2		wicks	1					
29	074-A-12		spacer, differential	1					
30	270-722		washer, differential	1					
31	270-750		ring, adjustment	1					
32	0123-N-6,5		cap, main shaft	1					
33	001-E-10		lock-screw, pin	1					
34	010-D-11,5		screws, right flange	1					
35	010-D-5		grub-screws, pin	1					
36	PM 270-059/1		cover, upper control rod	1					
37	PM 270-060/1		cover with handwheel	1					
38	PM 270-060/1		sleeve assembly	1					

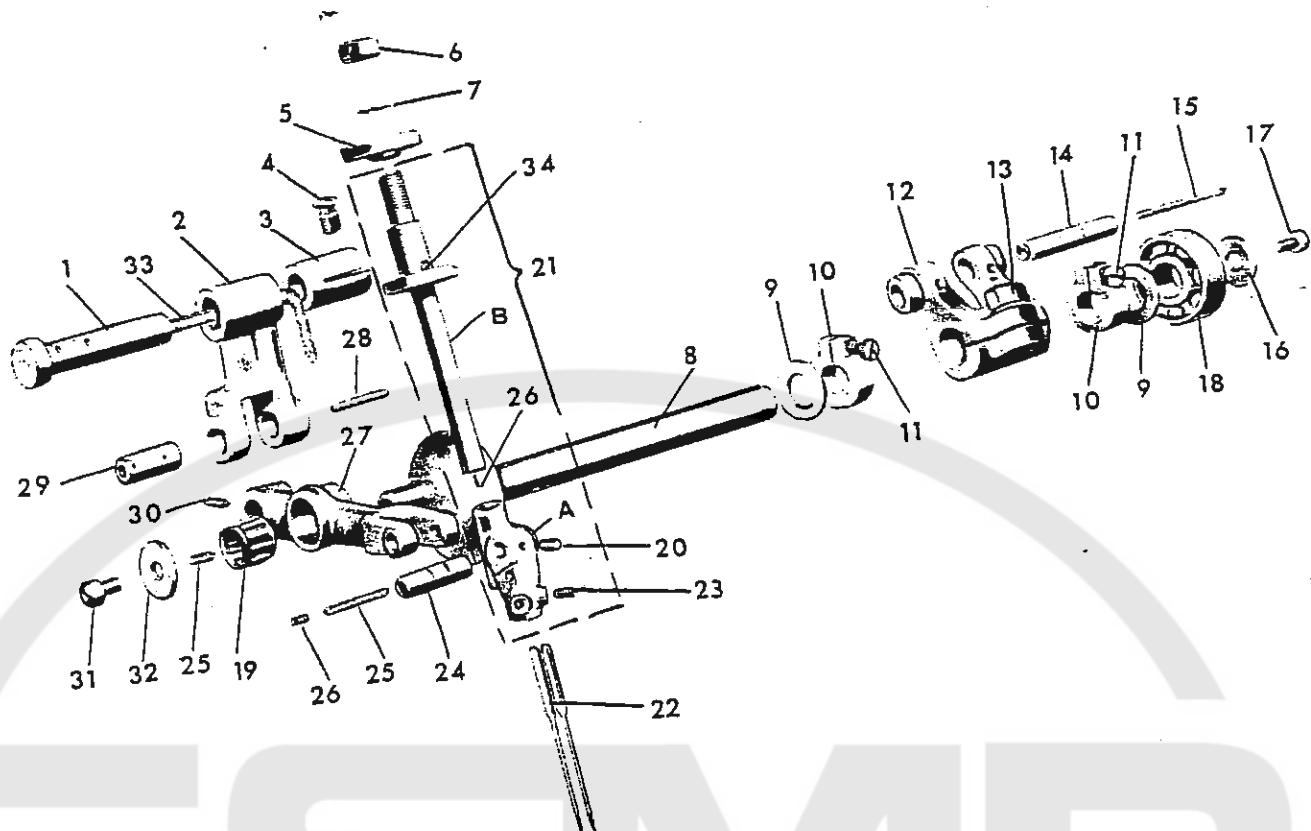




REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	PM.270-049/1	assembly, differential slide	1	47	270-037/3	rod, differential control	1
2	27-27-051	feed dog, rear	1	48	270-984	screw, feed lever	1
3	270-977	screw, attach rear feed dog	1	49	070-B-3	washer, feed lever	1
4	270-640/3	guide block, right differential	1	50	023-N-5,5	securing screw, pin	1
5	092-B-1	oil wick	4	51	270-735	eccentric regulation	1
6	270-937/1	securing screw, differential eccentric shaft	1	52	PM.270-045/2	attachment, differential segment	1
7	27-27-052	feed dog, chaining	1	53	270-033/1	link, differential slide	1
8	270-611/1	eccentric, feed dog lifter	1	54	270-980	securing screw, differential link	1
9	270-979	securing screw, link	1	55	270-943	grub-screw, securing pushbutton	1
10	070-M-4,5	washer, differential links	2	56	270-034	bush for differential slide	1
11	270-035	bush, differential feed slide	1	57	005-L-11	securing screw for guide	2
12	4030-06	collar	1	58	270-997	screw, differential control lever	2
13	270-048	link, differential feed slide	1	59	270-566/1	control lever, differential segment	1
14	073-C-8	washer, pin	1	60	092-D-4	oil wick, differential link	1
15	270-054	pin, differential segment	1	61	270-978	securing screw, front feed dog	1
16	071-M-5,5	washer, diff. ratio increase segment	1	62	27-27-050	front feed dog	1
17	279-047/2	guide segment, diff. ratio increase	1	63	290-700	snap-ring for pushbutton	1
18	070-F-4	washer, diff. ratio pin	1	64	270-736/3	shank, pushbutton	1
19	057-F-4	nut for pin 270-054	1	65	270-738	spring, pushbutton	1
20	270-975	screw, segment	1	66	001A-2,5	screw	1
21	270-039	shaft, differential eccentric	1	67	270-729	set-screw	1
22	270-7391	securing pin	1	68	279-249/1	shield	1
23	071-H-5	washer, differential eccentric shaft	1	69	270-250/2	rubber guard for feed dogs	1
24	270-036/1	sliding block, for differential	1	70	270-253	gasket, slide guide	1
25	270-935	counter-washer	1	71	004-L-7	securing screw, guard	2
26	026-C-7	screw, counter-washer	1	72	PM.270-732/3	housing and cam stitch length eccentric	1
27	PM.270-038/3	complete adjustable differential assembly	1	73	270-734	flat spring	1
28	270-040	yoke, connecting rod	1	74	270-032/3	plate, differential mechanism cursor	1
29	270-031/1	pin, fork yoke	1	75	004-P-6	securing screw, cursor plate	2
30	092-D-6	oil wick, dowel	1	76	270-928	grub-screw, for eccentric slide	2
31	092-D-12	oil wick, rear pivot	1	77	270-929	lock-screw, for grub-screw	2
32	270-041/1	rear pivot, differential	1	78	270-747	gib, eccentric slide	1
33	250-471	screw, yoke	1	79	007-C-11	screw, collar	2
34	017-E-11,5	securing screw, adjustable eccentric	1	80	023-E-12	set-screw, eccentric	1
35	039-H-9	screw, differential segment	1	81	270-595	gasket, differential control lever	1
36	064-F-5	washer, segment	2	82	270-717	collar, differential collar	1
37	270-992	screw, differential segment	2	83	270-927	screw, collar	1
38	270-287/1	upper sector	1	84	270-915	plug, differential pinion bore	1
39	073-A-8	washer, differential drive shaft	2	85	092-D-11	oil wick	1
40	PM.270-562/2	lever, complete differential control	1	86	092-D-23	oil wick	1
41	270-288/1	stop	1	87	270-594	gasket	1
42	270-567	sector with setting marks	1	A	270-046/3	slide for differential adjustment	1
43	065-D-6	washer, knurled knob	1	B	270-038/3	segment for differential adjustment	1
44	270-568	knurled knob, lever lock	1	C	279-733/1	slide, stitch length eccentric cam	1
45	270-702	snap ring	1	D	270-732/3	stitch length eccentric cam	1
46	270-703	needle roller bearing cage	1			for 227-00-32	

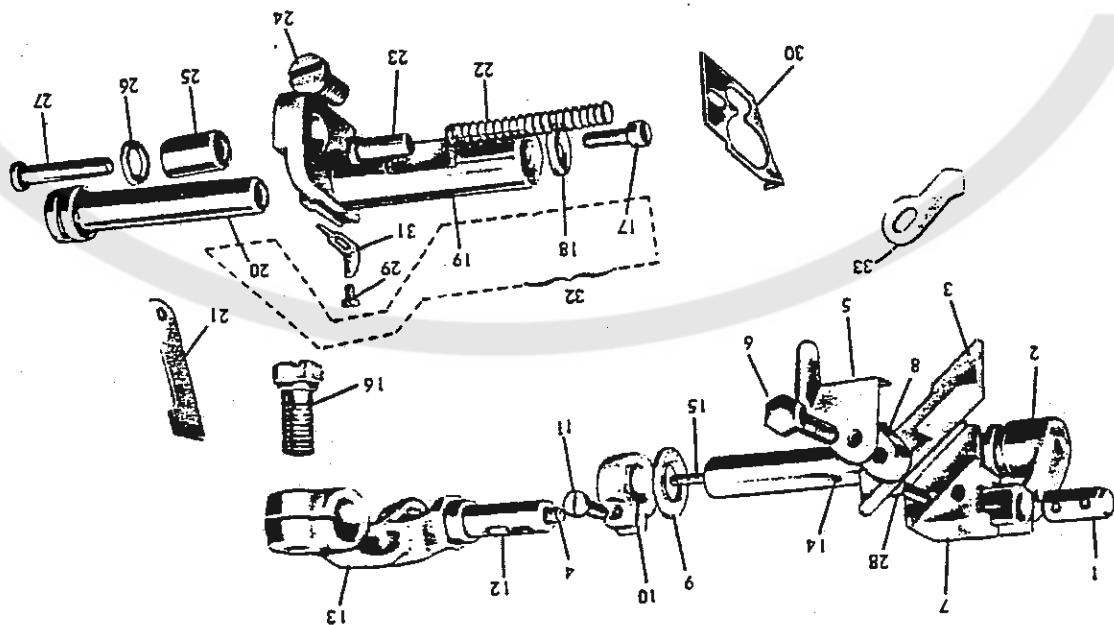
REF.	PART.	DESCRIPTION	ITEM	REF.	PART.	DESCRIPTION	ITEM	REF.	PART.	DESCRIPTION	ITEM
1	092-D-16	Oil wick, for pinions	2	13	046-B-2.5	Ground-screw, for din	2	14	277-77-067	Control lever, secondary looper	1
2	073-N-10	Washers, looper control lever	2	15	092-B-1	Pin, secondary looper control lever	2	16	092-D-7	Oil-wick, for pin	1
3	270-070	Shaft, secondary looper control lever	2	17	270-053	Shim, adjustment	2	18	016-B-3	Set-screw	1
4	270-064	Shaft, secondary looper with large eye	2	19	017-F-11	Screw, primary looper	2	20	092-C-2	Felt tube	1
5	277-074/2	Secondary looper control	1	21	002-F-14	Screw, loopers-holder, secondary	1	22	277-77-063/2	Oscillating guide	1
6	270-075/2	Shaft, primary looper	1	23	270-063/2	Screw, loopers-holder, primary	1	24	016-B-4	Screw, primary looper travel	1
7	250-069	Shaft, primary looper	1	25	277-056/1	Oscillating guide, with screw-type bush	1	26	270-074/1	Screw, primary looper	1
8	250-071	Screw, primary looper lever	1	27	277-075	On request:	1	28	277-0745/2	277-0745/2	1
9	270-068/3	Loopers-holder, primary	1	29	277-0745/2		1	30	277-0745/2		1
10	277-065/3	Oscillating guide, with screw-type bush	1	31	277-0745/2		1	32	277-0745/2		1
11	270-074/1	Screw, primary looper	1	33	277-0745/2		1	34	277-0745/2		1
12	016-B-4	Screw, primary looper travel	1	35	277-0745/2		1	36	277-0745/2		1

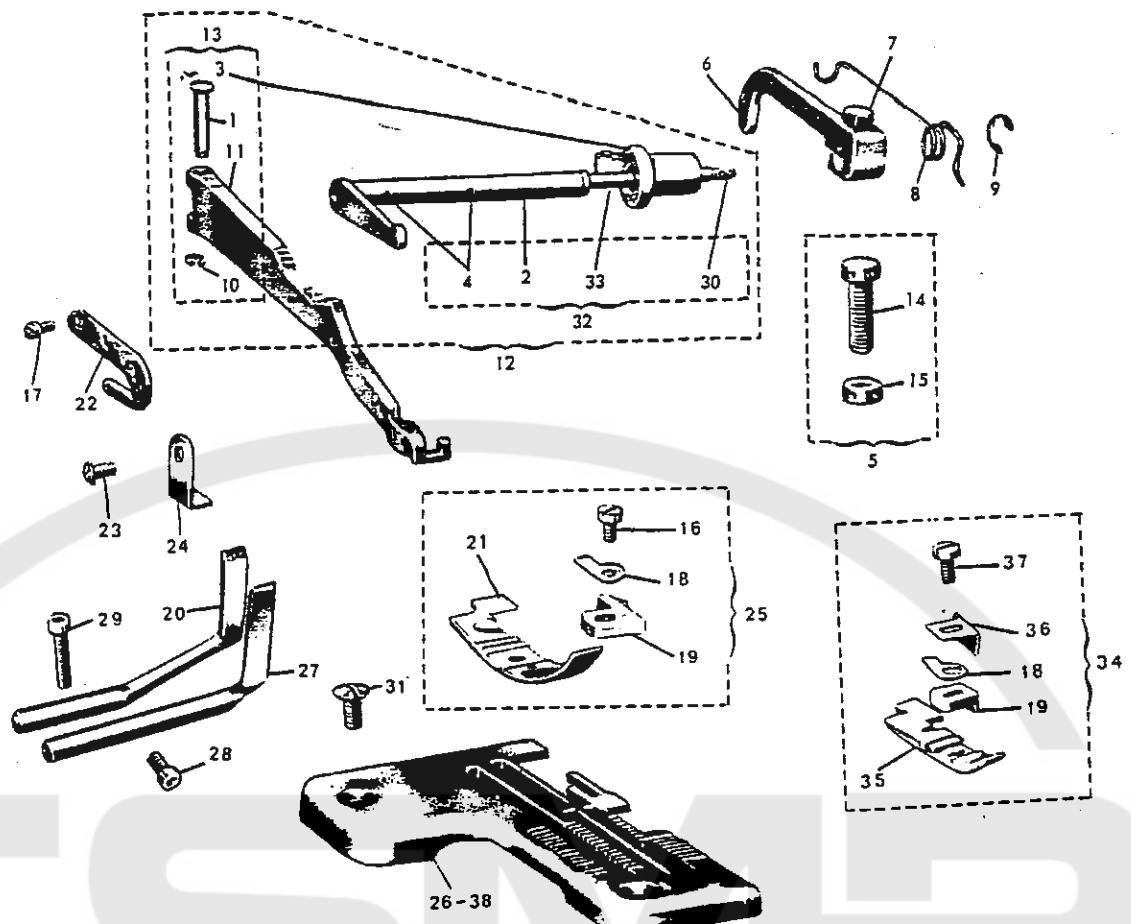




REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	PM.270-138/1	pin, needle lever rocker	1	19	250-708/1	needle bearing cage, needle control lever	1
2	PM.270-137/1	lever, fork	1	20	016-B-2,5	screw, pin securing	1
3	270-132/1	bush, fork lever	1	21	G.27-27-025/4	needle bar assembly with clamp, complete	1
4	270-728/1	securing screw, bush	1	22	RIM.27	needle	1
5	290-027/1	washer, needle rocker pin	1	23	290-944	screw, needle clamp	2
6	270-933	lock-nut, guide pin	1	24	270-130	pin, needle clamp	1
7	270-713	flexible washer	1	25	092-B-1	oil-wick for needle clamp pin	2
8	270-006/1	drive shaft, needle bar	1	26	016-A-2,5	grub-screw, needle bar clamp pin	1
9	073-F-9	washer, upper shaft	2	27	270-135	lever, needle holder slide control	1
10	270-719	collar, upper shaft	2	28	092-D-5	oil-wick for pin	1
11	007-C-11	screw, for collar	2	29	270-133/1	pin, fork lever	1
12	270-007/1	attachment, drive shaft	1	30	023-N-5,5	set-screw, needle bar control lever	1
13	270-975/1	screw, attachment drive shaft	1	31	001-E-7	screw, upper shaft	1
14	270-031/1	pin, attachment drive shaft	1	32	270-131	shim, adjustment	1
15	092-D-6	oil-wick, for pin	1	33	092-D-11	oil-wick, for pin	1
16	071-E-5	washer, upper shaft	1	34	092-A-10	oil-wick, for needle bar	1
17	001-G-10	screw, washer	1	A	27-27-020/3	needle clamp	1
18	270-708	bearing, upper shaft	1	B	290-025/1	needle bar	1

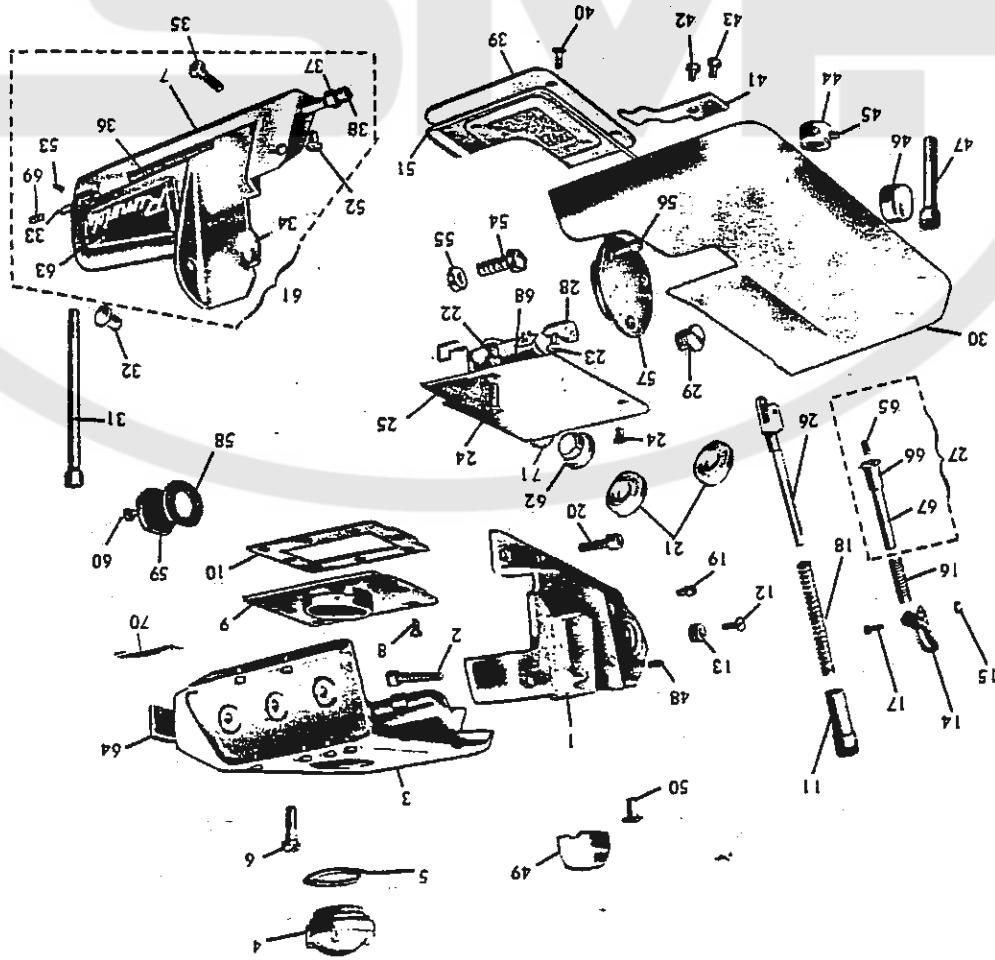
REF.	PART.	DESCRIPTION	REF.	PART.	DESCRIPTION	REF.	PART.	DESCRIPTION
1	270-102	pin, upper knife holder	17	007-P-10	set-screw, lower knife	18	064-L-5	washer, for pin
2	270-096/1	upper knife holder	19	270-104	lower knife holder	20	270-105	pin, lower knife holder
3	270-77-112	oil-wick	21	277-113	lower knife	22	270-100	spring, lower knife
4	092-D-5	lock-pin, upper knife	23	270-106	securing screw, upper knife	24	003-L-12	pressuring screw, lower knife
5	128-111	trimming guard, upper knife	25	270-101	lock-pin, upper knife holder	26	070-F-4	washer, upper knife holder
6	270-987	securing screw, upper knife	27	270-100	lock-pin, lower knife	28	028-B-5	pressuring screw, lower knife
7	270-103	block, upper knife holder	29	270-105	pin, lower knife holder	30	270-877	pin, yoke holder
8	073-F-9	lock-pin, upper knife	31	270-101	lock-pin, lower knife	32	277-227	oil-wick for yoke attachment
9	073-103	washer, upper knife holder	33	128-110	trimming guard upper knife	34	PM 270-104/1	screw, upper knife lever
10	270-719	collar, upper knife holder						
11	007-C-11	pin, yoke attachment						
12	270-108/1	collar, upper knife holder						
13	270-098	pin, upper knife holder						
14	092-C-2	oil-wick for yoke attachment						
15	270-098	oil-wick for yoke attachment						
16	250-471	screw, upper knife lever						

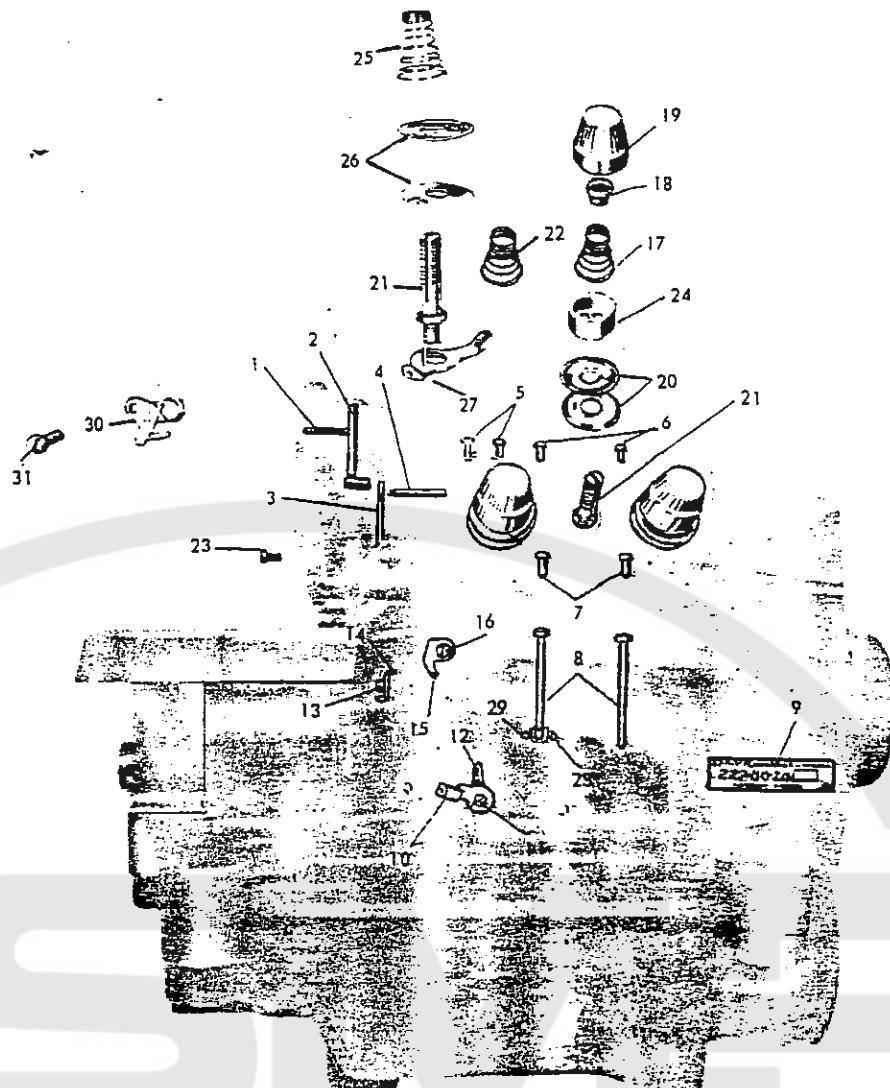




REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-077	pin, presserfoot arm	1	18	27.77-196	bracket, presserfoot	1
2	270-081/1	shaft, presserfoot lifter lever	1	19	272.6B-191	chaining finger, presserfoot	1
3	270-083	bushing, presserfoot lifter lever shaft	1	20	27-277-109/1	needle guard, rear	1
4	092-C-2	oil-wick	4	21	27.26-184	shoe, presserfoot	1
5	PM270-085/1	stop-pin, lever stroke adjustment	1	22	270-188	chain cutter	1
6	270-087/1	lever, presserfoot lifter	1	23	27.01 P-403/1	screw, angle mounting	1
7	270-985	screw, presserfoot lifter lever	1	24	27.26-186	angle stop presserfoot	1
8	2/0-089/1	spring, presserfoot lifter lever	1	25	G 27.277-181	presserfoot assembly	1
9	270-714	snap-ring, presserfoot lifter lever shaft	1	26	27.277-114	needle plate for narrow bight	1
10	270-701	snap-ring	1	27	27.277-107/1	needle guard, front	1
11	27-778-076/1	presserfoot arm	1	28	270-936/2	screw, front needle guard	1
12	G 27-778-076/1	presserfoot arm assembly	1	29	270-934/2	screw, rear needle guard	1
13	PM27.778-076/1	coupling, presserfoot lifter lever	1	30	092-D-11	oil-wick	1
14	270-085/1	stop-pin, presserfoot lifter lever travel	1	31	032-L-10.5	screw, needle plate securing	2
15	270-091	lock-ring, for item 14	1	32	PM 270-081/1	shaft, presserfoot arm, complete	1
16	004-L-8	screw, presserfoot chaining finger	1	33	270-073	tube, protection	1
17	001-A-4.3	screw	1				
34	G27.26-181/1	for 227-00-32	1				
35	27.26-184/1	presserfoot assembly	1				
36	27.77-183	shoe presserfoot	1				
37	Q04-L-9	chaining plate	1				
38	27.26-114/1	screw, presserfoot chaining finger	1				
		needle plate	1				

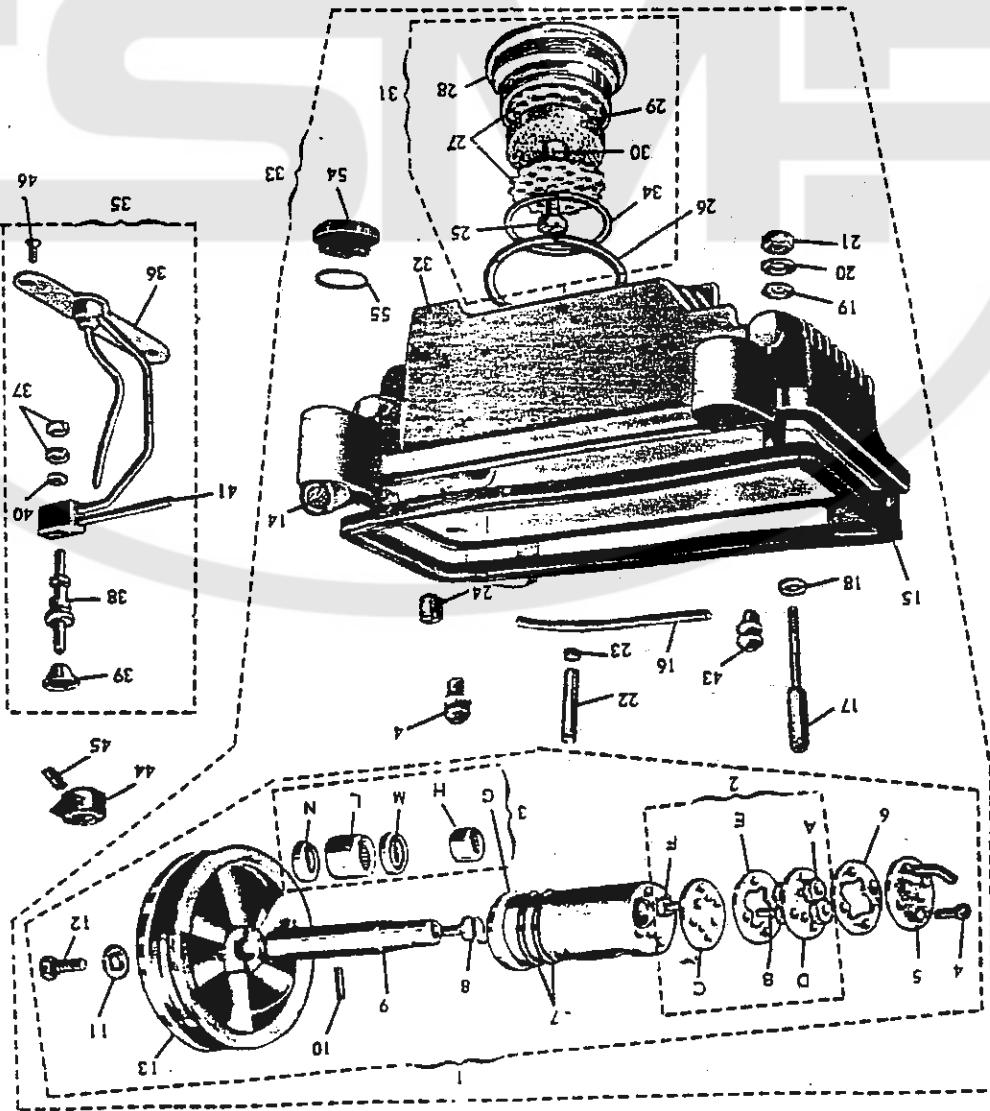
REF.	PART.	DESCRIPTION	REF.	PART.	DESCRIPTION
1	PM.270-208/3	side cover, with bushing	1	35	007-E-14
2	007-H-25	cover, top bushing	1	36	054-D-4
3	PM.270-205/3	cover, with threaded take-up bushing	1	37	054-D-221
4	270-241/2	oil-cap, with window	1	38	270-226
5	270-955/2	packing ring, oil-cap	1	39	G.270-242/3
6	270-983	hinge assembly with guide tubes	1	40	028-E-10
7	PM.270-218/2	cover, cover securing	1	41	270-212
8	007-R-75	screw, securing oil-cap plate	1	42	001-D-6
9	G.270-245/4	oil-cap plate	1	43	001-D-4,5
10	270-246	oil-cap plate gasket	1	44	270-178
11	032-E-9,5	oil-cap plate adjustment	1	45	017-E-4,5
12	270-933/1	stop arm	1	46	270-030
13	605-412	stop, differential shaft seal	1	47	270-973
14	270-094	lever, presserfoot locking	1	48	270-173
15	270-701	lever, presserfoot release	1	49	270-129/1
16	270-086	spring, presserfoot release lever	1	50	270-73/1
17	270-078	spring, presserfoot release rod	1	51	270-231
18	2701-P-092	pin, presserfoot releasing	1	52	01205/A
19	270-993	screw, front cover plate securing	1	53	01205/B
20	270-303	screw, set-screw	1	54	270-214
21	270-066/2	plugs, top cover bushing	2	55	057-E-4
22	270-995	screw, top cover securing	2	56	005-M-10
23	026-E-10	nipple, cover	1	57	270-619
24	026-C-7	plugs, side flange, left	1	58	270-624
25	270-247/1	sealing disc	1	59	270-623/1
26	PM.270-095/3	shaft, presserfoot pressure	1	60	001-D-10
27	270-220/1	screw, splash guard securing	1	61	G.270-216/2
28	270-248/1	releaser rod, presserfoot	1	62	G.270-030/2
29	270-940	screw, plug	1	63	270-175
30	PM.270-210/3	work-plate assembly	1	64	270-174
31	270-972	nameplate, tensioning disc housing cover	1	65	270-923
32	270-220/2	nameplate, front cover plate	1	66	270-09/1
33	270-220/1	block, tie-rod	1	67	270-110
34	PM.270-217/2	cover, splashguard assembly	1	68	PM.270-301

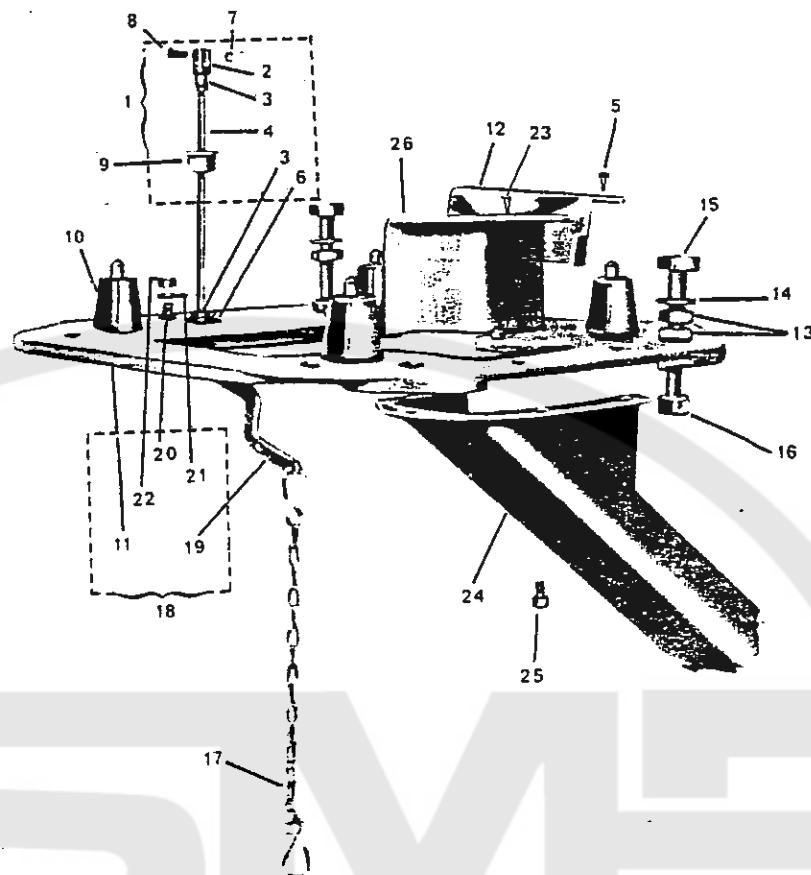




REF. N°	PART. N°	DESCRIPTION	QUANT.	REF. N°	PART. N°	DESCRIPTION	QUANT.
1	270-941	screw, thread guide tube securing	1	17	272-232.1	spring, primary looper	2
2	PM270-263/1	tube, needle thread guide	1	18	270-233	bushing, upper tension	4
3	270-274/3	take-up, needle thread	1	19	202558-2-00	nut, tension adjusting	4
4	270-264	needle thread guide	1	20	603-031	disc, tension	6
5	270-265	bush, upper thread guide	2	21	270-230	pin, tension screw	4
6	270-265/1	bush, upper thread guide	2	22	270-232/2	spring, needle	1
7	270-266	bush, lower thread guide	2	23	004 V-5.5	screw, needle take-up securing	2
8	270-268	tube, lower thread guide	2	24	202556-0-00	cup, tension disc	4
9	780220-0-00	machine type nameplate	1	25	270-232.1	spring needle	1
10	270-269/2	take-up, primary looper	1	26	250-031	disc tension	2
11	004 L-8	screw, take-up securing	1	27	27 27-253	thread guide	1
12	270-270/2	take-up, secondary looper	1	28	016 B-2.5	screw	1
13	004 A-3.2	screw, bracket securing	1	29	27 00-2714	thread guide	1
14	270-276/1	bracket, looper	1	30	27 27-262.2	needle thread take-up assembly	1
15	27.277-2751	thread guide, secondary looper	1	31	004 P-4.5	screw	1
16	032-A-6	screw, thread guide securing	1				
		for 227-00-32					
9	780232-0-00	machine type nameplate	1				
29	270-271	thread guide	1				

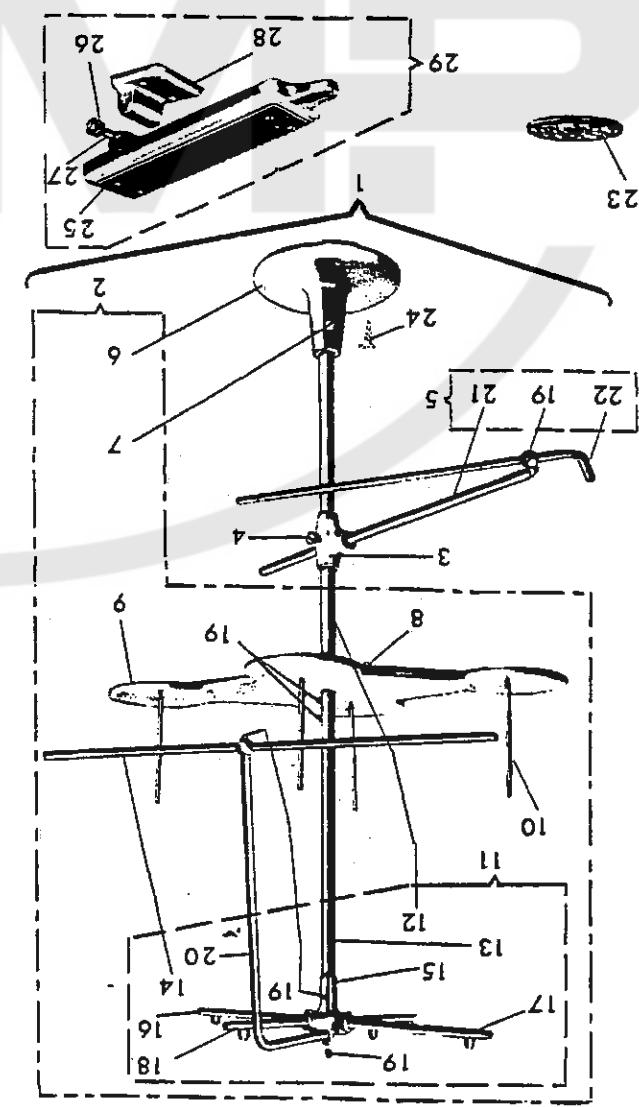
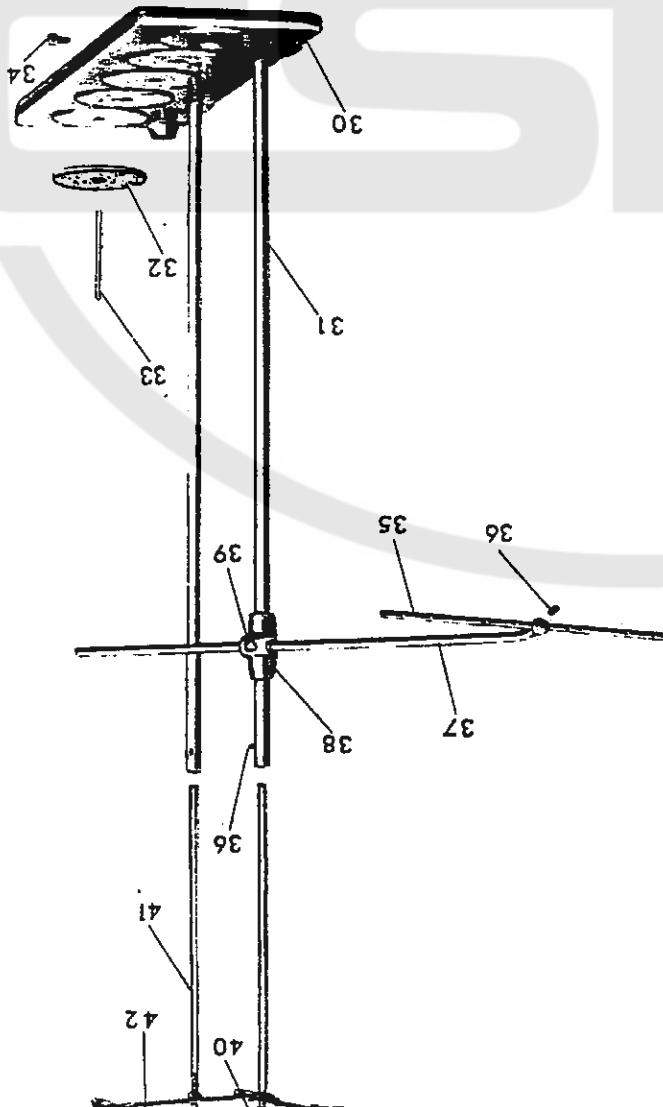
REF.	PART.	DESCRIPTION	REF.	N°	REF.	N°	DESCRIPTION
1	G.270-816/1	oil pump assembly	1	34	270-966/1	gasket	oil distributor assembly
2	G.633-833/1	oil pump assembly	1	35	G.270-646	gasket	oil distributor assembly
3	PM.270-816/1	pump unit	1	36	PM.270-645/1	nut	oil distributor
4	633-818/1	cover	1	37	957-A-3	valve	
5	PM.633-817/1	screw	1	38	270-650	washer	
6	633-711/1	gasket	1	39	270-651	valve	
7	270-824/1	worm	2	40	270-734/1	flexible washer	
8	633-711/1	gasket	1	41	270-652	junction tube	
9	270-824/1	shaft	1	42	633-826/1	cup spring	coupling tube, oil pump
10	633-823/1	flexible pin	1	43	633-826/1	cup spring	coupling tube, oil pump
11	633-707	cup	1	44	270-645	pinion	pinion, oil pump
12	033-959/1	cup	1	45	016-B-2,5	pinion	pinion, oil pump
13	270-810/2	cup	1	46	028-E-10	pinion	pinion, oil pump
14	633-959/1	cup	1	47	016-B-2,5	pinion	pinion, oil pump
15	270-808/1	cup	1	48	028-E-10	pinion	pinion, oil pump
16	633-842	tube	1	49	016-B-2,5	pinion	pinion, oil pump
17	270-811/1	tube	1	50	270-430	current plug	current plug
18	270-846	nut	2	51	270-821/2	rubber gasket	rubber gasket
19	270-947	gasket	1	52	533-819	gear plate, side	gear plate, side
20	065-L-5	gasket	1	53	533-819	gear wheel pin	gear wheel pin
21	059-G-6	pin	1	54	533-822/2	gear wheel	gear wheel
22	270-836	tube	1	55	270-432/1	currennt plug	currennt plug
23	017-H-12	feet pad	2	56	270-430	currennt plug	currennt plug
24	270-836	feet pad	2	57	270-821/2	rubber gasket	rubber gasket
25	007-L-20	grub-screw	1	58	533-818/1	gear plate, inner	gear plate, inner
26	633-966	scREW	1	59	533-818/1	drive shaft	drive shaft
27	270-998/1	disc	1	60	633-813	roller housing	roller housing
28	270-998/2	disc	1	61	633-813	housing, pump	housing, pump
29	633-925	feet disc	1	62	633-813	seal ring	seal ring
30	270-001/2	plugs	1	63	633-813	oil pump and sump assembly complete	oil pump and sump assembly complete
31	G.270-996/2	spacers	1	64	633-813	oil sump	oil sump
32	270-001/2	plugs	1	65	670-702	oil pump and sump assembly complete	oil pump and sump assembly complete
33	205520-5-00		1	66			

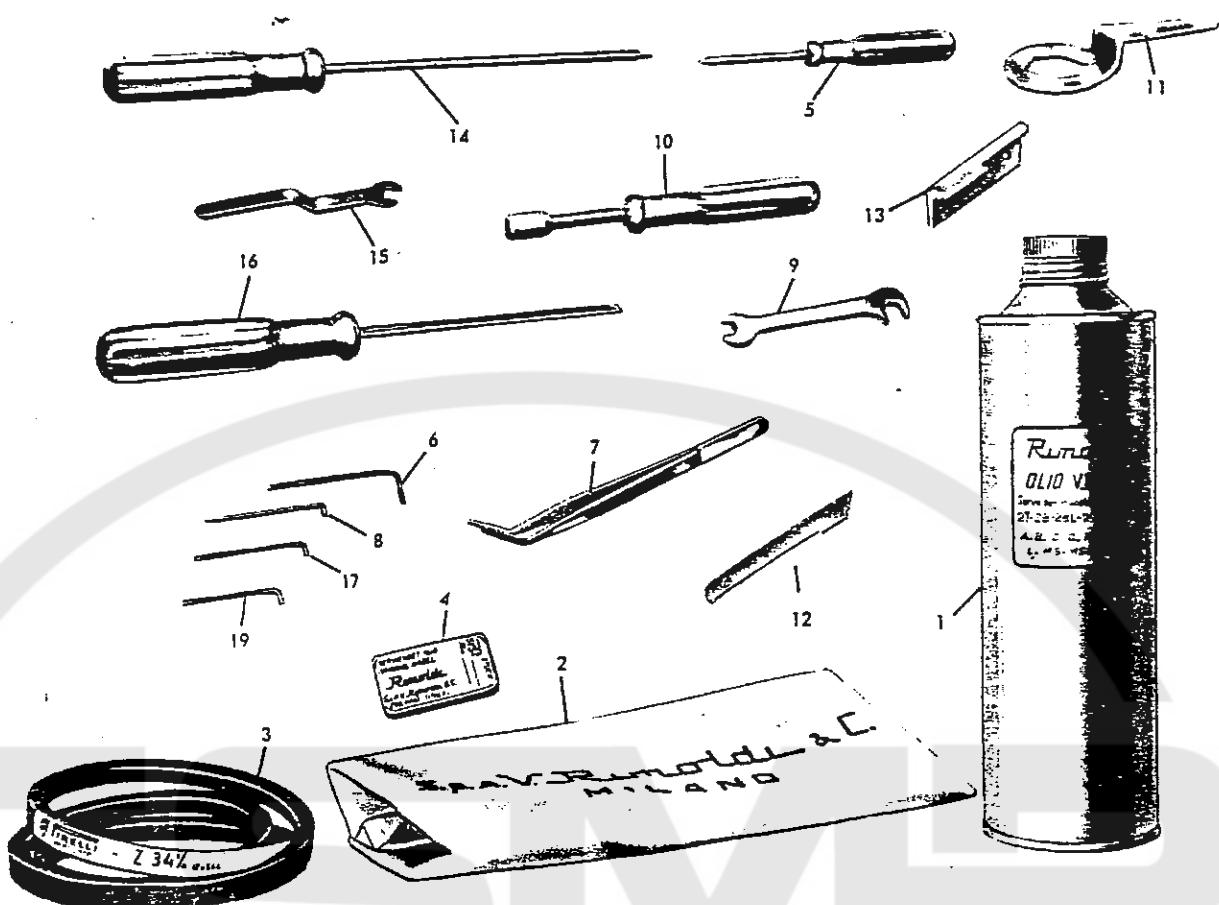




REF. Nº	PART. Nº	DESCRIPTION	QUANT.	REF. Nº	PART. Nº	DESCRIPTION	QUANT.
1	G.270-583	tie-rod assembly, presserfoot lifter lever	1	23	270-558	ON REQUEST	
2	270-585	coupling, presserfoot lifter lever upper	1	24	270-590/1	pin	1
3	059-A-5	lock-nut, lifter lever tie-rod	2		270-590/2	waste chute (long - right)	1
4	270-583	rod, presserfoot lifter lever	1			waste chute (left)	1
5	270-459	lock-screw, flywheel guard	7	25	001-G-10	screw, waste chute securing	3
6	270-557	coupling, presserfoot lifter lever	1	26	270-589/1	waste chute -short	1
7	270-701	snap-rings	3				
8	270-558	pin, for coupling	2				
9	270-552	bushing, upper plate	1				
10	270-004	rubber mounts, machine	4				
11	PM.270-005/3	bearing plate, with pins	1				
12	270-588	guard, flywheel	1				
13	058-M-10	nut, machine bearing screw	8				
14	067-H-10	washer, machine bearing plate	4				
15	270-971	screw, machine bearing plate	4				
16	051-L-10	nut, machine plate mounting bolt	4				
17	PM.1159	chain with hook	1				
18	G.270-005/3	machine bearing plate	1				
19	270-586/1	lever, presserfoot lifter	1				
20	270-584	pivot, presserfoot lifter lever	1				
21	065-L-6	washer	3				
22	059-H-6	nut, presserfoot lifter lever pivot	1				

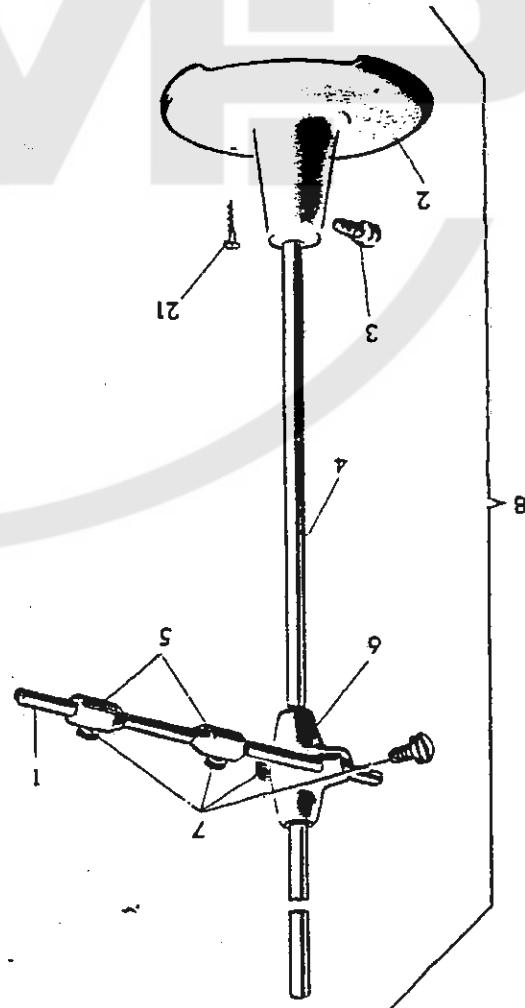
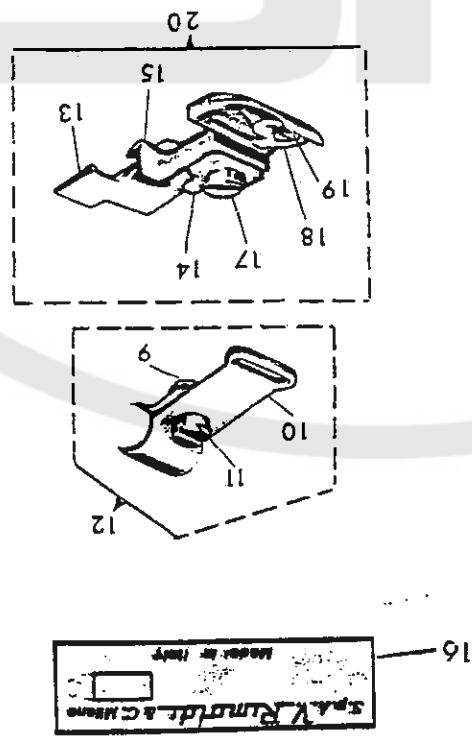
Nº	DISGENO	DISGENO	DESIGNAZIONE	UNN.	Nº	DISGENO	DESIGNAZIONE	UNN.	Nº	DISGENO	DESIGNAZIONE
1	AS.277-140		SUPPLIED WITH HEAD ONLY		1	30	490/2				
2			thread strand assembly		1	31	910-143				
3	605-937		bracket		1	32	569				
4	605-980		lock-screw		2	33	1146				
5	327-22-157		bar sustaining with thread guide rod		2	34	001-3-10				
6	01141		base, thread strand		1	35	016-5				
7	001-G-12		screws, rod securing		1	36	016-5				
8	280-142		plate, plate securing		1	37	220-158/1				
9	280-137		screws, rod securing		1	38	605-937				
10	11146		plate, thread spool		1	39	605-980				
11	3260-137		frame, thread spool		1	40	11145				
12	250-143		bar, thread rod sustaining		1	41	910-144				
13	250-120		upright, main upper		1	42	605-937				
14	250-137		upright, main lower		1	43	11145				
15	260-140		rod, thread guide		1	44	910-144				
16	PM 260-134/1		connection piece, rod		1	45	605-937				
17	PM 260-133/1		rod, thread guide		1	46	11145				
18	PM 260-135/1		rod, thread guide		1	47	G 497				
19	01145		guide-screw		1	48					
20	PM 250-148/1		grub-screw		1	49					
21	277-158/1		rod, thread guide		1	50					
22	277-137		rod, thread guide		1	51					
23	569		rod, thread guide		1	52					
24	5 20 X 30		pedal, thread spool		1	53					
25	PM 910-914		screw, thread strand securing		1	54					
26	053-H-8		pedal		1	55					
27	910-964		pedal, sharp		1	56					
28	910-934/1		base, pedal		1	57					
29	3 910-914/1		pedal assembly complete		1	58					





REF. Nº	PART. Nº	DESCRIPTION	QUANT.	REF. Nº	PART. Nº	DESCRIPTION	QUANT.
1	VR.504	oil, 1 quart can	1	10	270-741	pipe-wrench, 9/32"	1
2	1175	machine cover	1	11	639-M-745	wrench for oil sump plug	1
3	280-155	vee-belt	1	12	277-113	knife, lower	1
4	RIM.27	needle, RIM.27	5	13	277-112	knife, upper	1
5	1161/2	screwdriver	1	14	01160/2	screwdriver	1
6	533-742	hex. wrench, 1/8". for 270-715	1	15	270-745	hex. wrench, 9/32"	1
7	1158	pincers, threading	1	16	01161/2	screwdriver	1
8	641-LY-743	hex. wrench 3/32"	1	17	270-743	hex. wrench, 5/64"	1
9	1156/1	wrench, double-ended	1	18	270-431	power cable and plug	1
			19	290-746		hex. wrench 1/16" for needles	1
On request:				270-575/1		Tab. 75	

REF.	PA. Nº	DESCRIPTION	REF. Nº	PART.	REF. Nº	DESCRIPTION	REF. Nº	PA. Nº
1	605-144	bar, rcd.	1	12	PMC778-267	guide, reinforcing type, complete	1	13
2	01141	base	1	13	21277F-184	guide, chainring type, complete	1	14
3	001-G-12	screw	1	14	27771-196	lug, chainring plate	1	15
4	605-143	upright	1	15	27768-191	lug, chainring plate	1	16
5	605-723	tapestry sleeve	1	16	W80256-0-03	machine, type nameplate	4	18
6	605-927	bracket	1	17	034L-8	plate	1	18
7	605-380	Knurled head screw	1	18	21277R-071	screw	1	19
8	G250R-9373	elastic reel stand	1	19	004G-3	screw	1	20
9	057A-3	guide, reinforcing tape	1	21	TS 23X30	pressfoot, complete	1	21
10	27778-267	guide, reinforcement	1	22	G2777F-181	screw, frame securing	1	22
11	001-C-5.5							



I. HEAD IDENTIFICATION

a) Identification numbers

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



II. TECHNICAL DATA BY MACHINE CLASS

The machines depicted in this catalogue are overedging machines with 2 needles, needle gauge 3/32", with the following general characteristics:

1. Straight needle, system RIM 27/Fmb - Thickness 80 - 100.
2. Differential can be regulated while machine is running.
3. Push-button stitch length adjustment.
4. Stitch length variable from 6 to 30 stitches per inch.
5. Differential feed ratio: up to 3,5:1 and also up to 4:1.
6. Width of bight: from 3/16" to 5/16".
7. Speed: from 6000 to 6500 RPM, depending on the type of application and manufacture.
8. Lubrication: by pump.
9. Motor: 1/3 HP or 1/2 HP, according to subclasses.
10. Outer dimensions of machine head: 12" x 9.3/4".
11. Weight: approx. 45 lbs.



I. INSTALLATION AND TIMING

a) Positioning of head

After motor is mounted on stand, proceed as follows:

1. Force-fit the four rubber shock absorber pads on to the pins provided on the machine head bearing plate
2. Place machine head on table centering the lower holes in the head on the shock absorber pad pins.

b) Assembly of transmission

1. Install driving belt as shown in diagram 1.
2. Check that reverse of driving belt rides firmly and squarely on pump pulley, without slipping.
3. Adjust belt tension by loosening motor clamp
4. Level machine head by adjusting machine cradle bolts.
5. Tighten up machine cradle bolt lock-nuts.

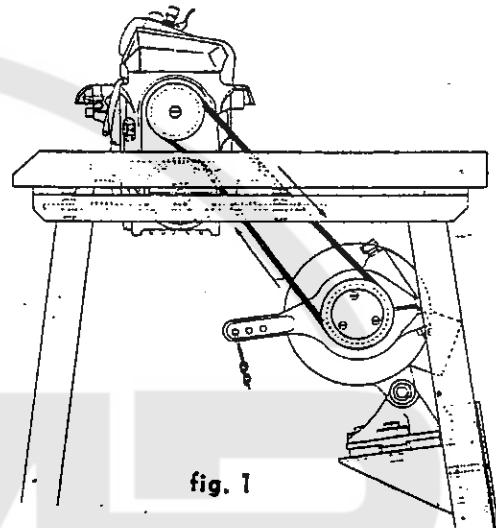


fig. 1

c) Filling lube oil sump (fig. 2)

1. Unscrew threaded cap 'A'.
2. Pour in 1 and 3/4 pts Esso Standard Teresso 43 oil.
3. Check through oil-window that oil level is between the two red lines.
4. Replace and tighten cap 'A'.
5. Before starting up the machine, the following points should be lubricated:
 - needle clamp guide rod
 - upper looper bar
6. Start machine slowly, letting it idle for about 5 minutes and gradually rev up from 1500 r.p.m. to rated operating speed.

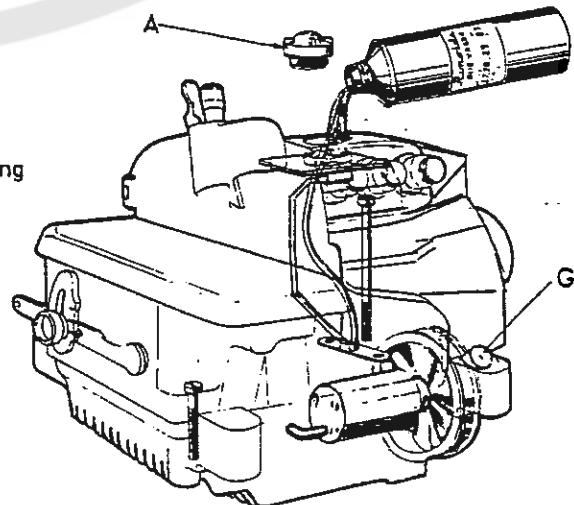


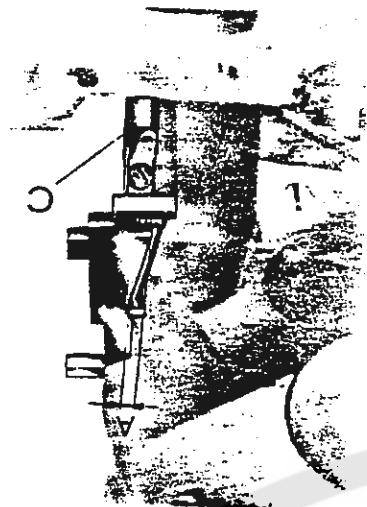
fig. 2

d) Assembly and adjustment of sewing parts

Note: The operations described below are for machine timing

1. Timing gauges required:
 - S.1686.00 for all operations except operation 4 (fig. 4).
 - S.1555.00 for operation N. 4
2. Preliminary disassembly of:
 - Front cover plate
 - Both thread take-ups of lower looper holder
 - Side Cover Plate (casing) of needle movement
 - Upper plate with oil indicator cap
 - Side plate protecting needle movement
 - Main feed dog

Fig. 5



- Setting the primary looper in relation to the needle:
- Slightly loosen screw 'D'
- Place timing gauge S.1686.00 on milled surface of base as shown in fig. 5; shift lever C and turn looper (which has been set in place but not locked) until correct angle is obtained.
- Correct position can be checked by reference to the timing table.
- Firmly tighten up screw E (fig. 4).
- When the primary looper has completed its stroke to the left and with the needle in its lowest position, the distance between the needle point and the needle should be as indicated in fig. 6.
- If adjustment is necessary move lever C along its rotation axis, in its stroke from left to right the looper point should pass 1/64" from the bottom of the needle slot.
- Set the primary looper in relation to the needle as follows:

Setting angle

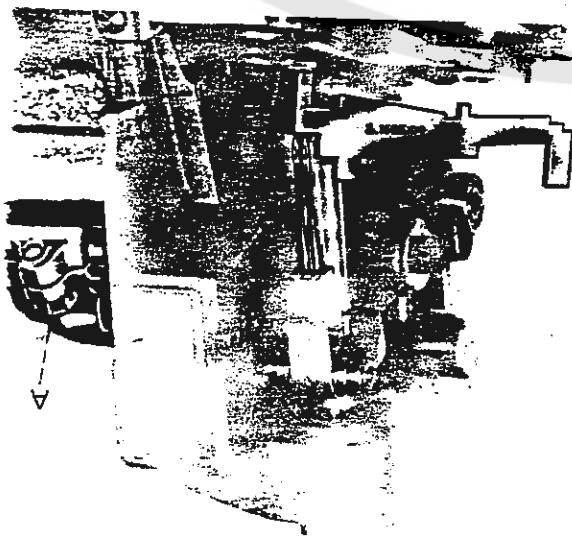
Fig. 4

- remove looper height gauge S.1555.00.
- retighten screws B and E.
- set thread guide bracket A by raising thread guide bracket to the top of the primary looper shank.
- slightly tighten screw E (fig. 4).
- raise or lower looper so that its point contacts the upper line on timing gauge S.1555.00.
- special screw supplied with gauge as shown in fig. 4.
- mount looper height gauge S.1555.00 on the primary looper shaft with special screw.
- loosen screw E.

SETTING OF HEIGHT

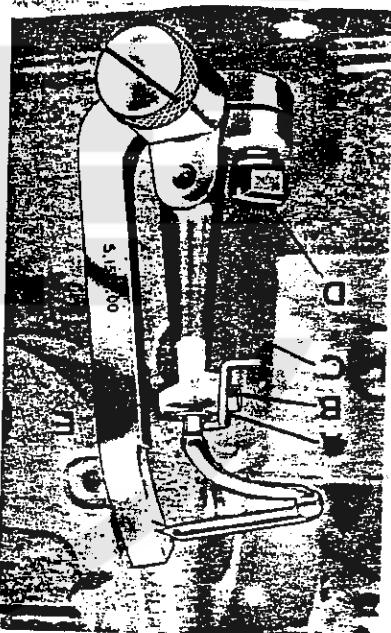
4. Setting Primary Looper (fig. 4)

Fig. 3



- If adjustment is necessary, loosen screw A (fig. 3) and move needle bar clamp up or down, using needle gauge S.1686.00 as indicated in fig. 3 to obtain the correct setting. Retighten screw A.

- If the needle plate is in proper position, the needles must be centered for passage through the respective needle holes of the needle plate.
- The distance between the needle points and the top surface of the needle plate is 1 1/32 inch when the needle is at its highest point.



3. Setting of needle (fig. 3).

5. Timing Secondary Looper

Note: To set the dimension 11/32" in Fig. 8, rotate lever E upwards or downwards: remember that by doing this the dimensions in Fig. 7 will be increased or decreased.

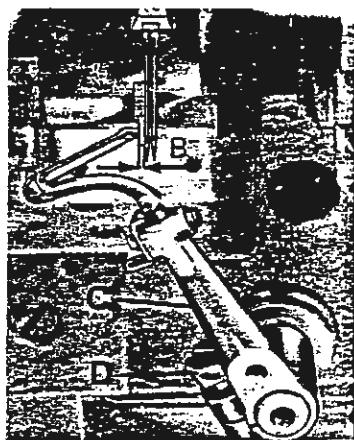


fig. 6

- Slightly loosen screw B.
- Slightly loosen screw A.
- Adjust crossing of secondary and primary looper rotating the secondary so that its tip passes behind the primary looper barely skimming it.
- Check distances given in figures 7-8 (see timing table).
- During its left to right motion the secondary looper should barely skim the needle.

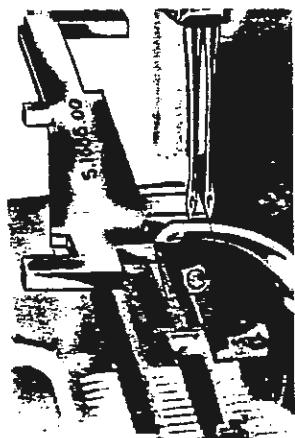
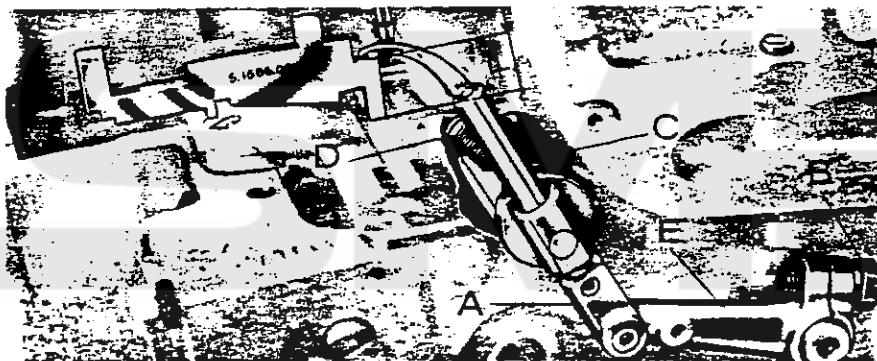


fig. 7

- If adjustment is required, slightly loosen Screw D and push the complete looper assembly inwards or outwards, avoiding any change in the distance already fixed. Make sure all parts move smoothly.
- Lock-screw D.
- Recheck to make sure the two loopers are crossing smoothly and verify all the other settings.
- Tighten up screws A and B.
- Finally, make sure all the assembly are moving smoothly.



6. Setting the needle guards (fig. 9)

fig. 8

- To set front needle guard A, loosen screw C.
 - With needles at their lowest position, set front needle guard so that it touches the needles.
 - Retighten screw C.
 - To set rear needle guard B, loosen screw D.
 - With needles in their lowest position, set rear needle guard so that it touches needles without deflection.
 - Retighten screw D.
 - It must be checked that when working, any eventual slight bending of the needles does not cause them to break through impact with the primary looper. To do this, bend the needles slightly towards the inner part of the machine and check that the primary looper, during its stroke from left to right, passes without breaking them. If this is not the case, the needle guards need to be positioned correctly by bending them slightly just above the shanks, where the part is not so hard. Check that each needle operates in the corresponding plane of the front and rear needle guards.
 - Thread the needles, bringing them to their lowest position and pushing them slightly against rear needle guard B.
 - The thread must run freely. If this is not the case it means that the needle is too low and the thread is trapped between needle and needle guard.
- NOTE:**
- The point of the looper, in its stroke from left to right, must enter the needle scarf in its upper portion and in its stroke to the left, in the lower portion.
 - For very hard synthetic fabrics the needle must flex considerably on the front needle guard.

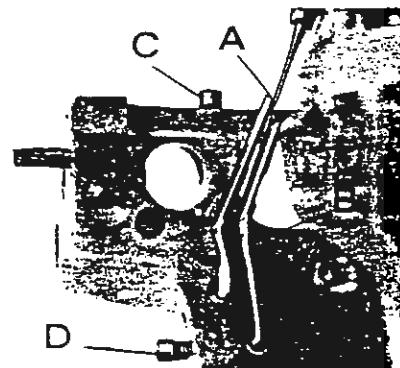


fig. 9

If feed mechanism adjustment is required, proceed as follows:

Note: The machine heads illustrated in this catalogue are supplied with the feed mechanism already set for the type of use to which they will be put.

9. Feed mechanism (fig. 13).

- Lock screws F, G, and A.
- Feed dog C should be lower than the other two.
- And the needle plate at the front of the differential feed dog.
- When the feed dogs are at their highest position, there should be a clearance of 1,3 mm. between the teeth and the feed dog visible through the needle plate should be absolutely flush with the latter.

fig. 11

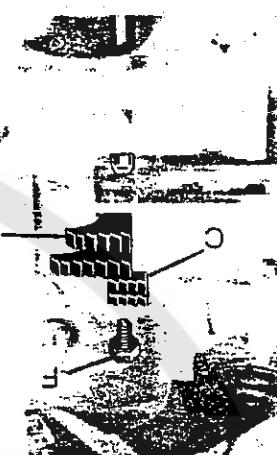
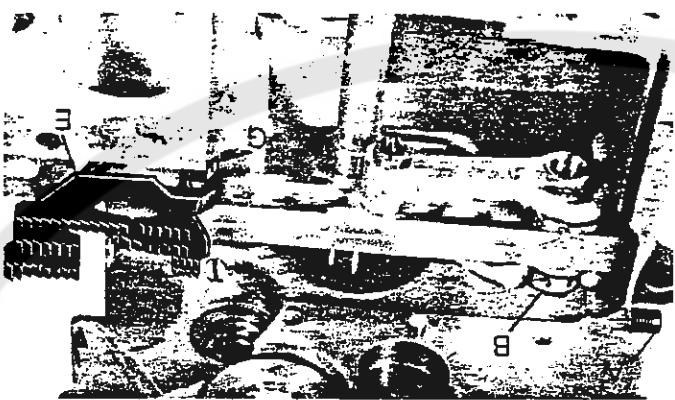


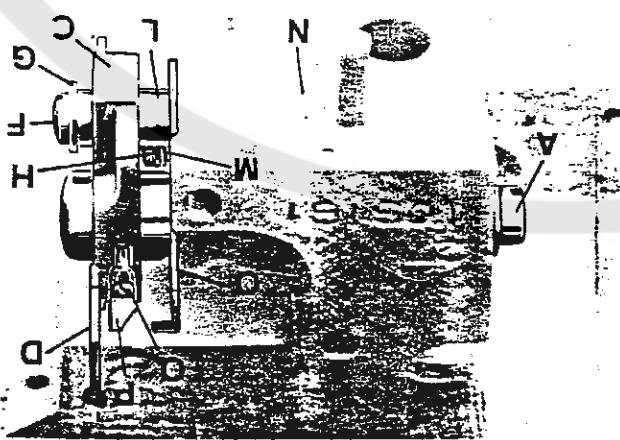
fig. 12



- Adjust feed dog angle by rotating eccentric B.
- Slacken screw A.
- Mount the front differential feed dog E with screw G but do not tighten it up fully (fig. 12).
- With a small screwdriver pushed through the threaded holes on the levers, tighten screw F slightly, inserting the screwdriver into the groove on the tip of the screw.
- Mount rear feed dogs C and D (fig. 11) and match the feed dog slides.
- Remove Plexiglass plate beneath work plate.

8. Mounting and setting Feed Dogs (figures 11 and 12)

fig. 10



- Mount guide block P on knife-holder C moves smoothly and adjust setting for required light.
- Tighten up screw A.
- With the needles in its lowest position, bring angle stop Q close to the needle guard, lock bushing L and washer G by tightening up screw F.
- Tighten up screw Q.
- With cutting edge of the trimmer knife must be flush with the rear needle guard.
- Slide knife D into place.
- Mount guide block P on knife-holder with screw Q.
- Check that knife holder C moves smoothly and adjust setting for required light.
- Tighten up screw N.
- With needles in its lowest position, bring guide block P to front needle guard and lock it by tightening up screw Q.
- Press one finger lightly against screw A and tighten up screw N firmly.
- Pressure should be lightly exerted to avoid generating friction between the two knives resulting in their hardening.
- Press one finger lightly against screw M and pin H.
- Trimmer knife, slacken screw N. The proper pressure is applied between the knives by spring M and pin H.
- After setting upper trimmer knife touching lower trimmer knife, slacken screw N.
- Press one finger lightly against screw A and tighten up screw N firmly.
- Pressure should be lightly exerted to avoid generating friction between the two knives resulting in their hardening.

7. Mounting lower trimmer knife (fig. 10)

1. Inactivation of differential feed:

- Slacken nut B using wrench A supplied with the machine head, and raise pin Q on rear feed dog lever as high as it will go.
- Tighten up nut B; lower lever H against stop F and lock knurled knob R manually.

2. Setting differential feed for ratio 2 : 1

- Slacken nut B.
- Set pin Q at highest position.
- Lock nut B.
- Lower lever H against stop G.

3. Setting differential feed for ratio 3,5 : 1

- Slacken nut B.
- Set pin Q in lowest position.
- Lock nut B.
- Lower lever H against stop G.

4. Setting differential feed for ratio 4 : 1

- Raise cursor C to its highest position on slide-bar S
- Proceed as for item 3
- The differential ratio can be changed while the machine is in operation by adjusting lever E.

5. Setting negative differential feed

- Slacken nut B.
- Set pin Q at highest position.
- Shift cursor C in lowest position.

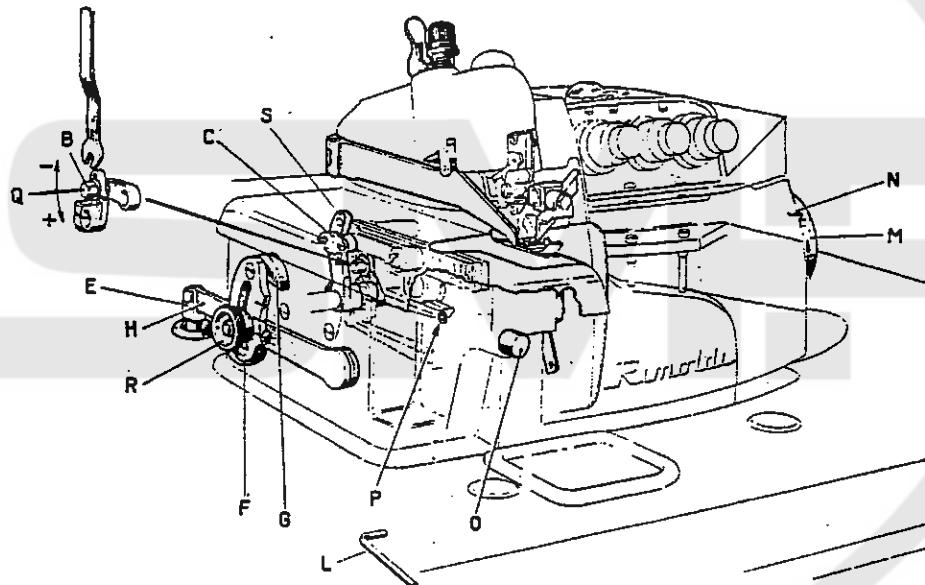


fig. 13

10. Mounting upper trimmer knife (fig. 14).

- Mount upper trimmer knife C on knife holder block
- Mount knife holder block D and trimming guards E and G with screw F.
- Trimming guard E should be very close to cutting edge of knife C.
- When trimmer knife C is at its lowest position, its cutting edge should overlap the cutting edge of lower trimmer knife by 1/32".
- For this adjustment, shift trimmer knife in its slanting seat and knife holder block A on the upper knife holder B.
- Tighten up screw F and check that the upper knife, when in lowest position, does not touch front needle guard.

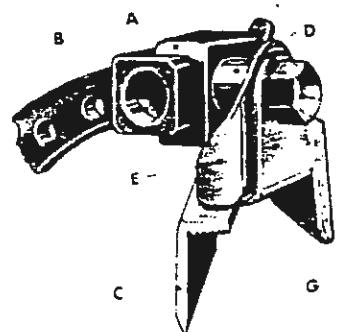
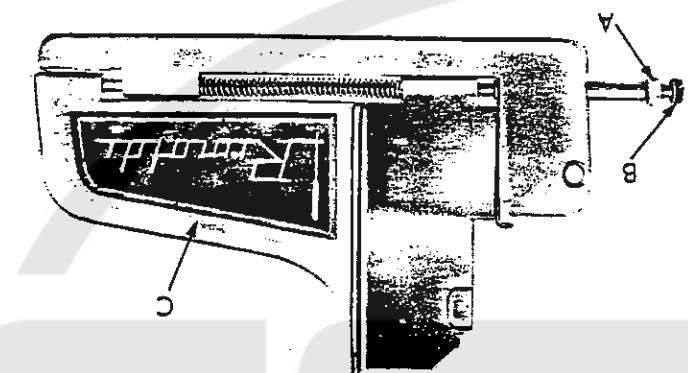
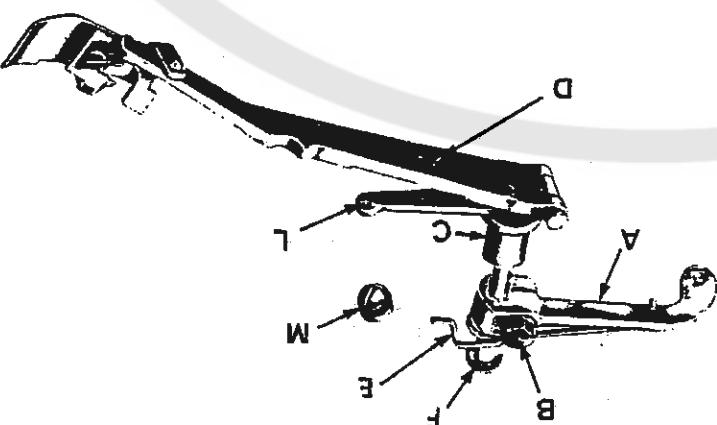


fig. 14



f) Adjustment of front cover plate (fig. 16).

- Adjust lifter lever A, by regulating screw in base beneath the lever, so that it lifts presserfoot to required position.
- Check movement of secondary looper; the latter should not impinge on presserfoot during finger when presserfoot is at its highest position. This undesirable condition can be prevented by adjusting eccentric washer M, below presserfoot bearing arm D, on slide cover.
- Tighten up screw B.
- The front cover plate should be closed before adjustment.
- The moving part C should not interfere with the front ment.
- The cover plate can be shifted towards left or right by needle guard of the lower knife holder.
- Adjusting screw B.
- Lock nut A.



e) Positioning and adjustment of presserfoot arm (fig. 15).

- Insert presserfoot arm shaft L in bushing C on which presserfoot bearing arm is hinged.
- Insert presserfoot arm shaft L in bushing C into hole provided in baseplate.
- Slide lever A and spring E on to shaft L.
- Slide snapring F on to shaft L.
- Set lifter lever A so that there is no end-play on presser foot arm shaft L.
- Slightly tighten screw B.
- Engage lifter lever A with presserfoot lifting foot pedal.
- When pedal is depressed it should have a slight idle stroke before actuating presserfoot bearing arm D.
- Adjust lifter lever A with presserfoot bearing arm D.
- With needle at highest position, insert presserfoot bear ing arm D in guide fork.
- With needle at highest position, insert presserfoot bearing arm D in guide fork.
- Tighten up screw B.
- Adjust lever A so that there is no end-play on presser foot arm shaft L.
- Set lifter lever A on to shaft L.
- Insert presserfoot bearing arm C into hole which bushing C is hinged.
- Insert presserfoot arm shaft L in bushing C on which presserfoot bearing arm is hinged.

- For making up very tough fabrics, needle take-up 270-274/2 should be shifted forwards, towards open-
- Adjustement of needle take-up

ELECTRIC LUBRICATION CONTROL DEVICE (PRESSURE SWITCH)

h) Disassembly and replacement of pressure switch

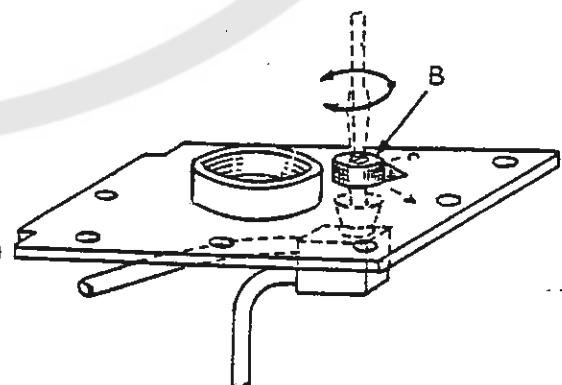
- Take down oil cup from baseplate and drain out oil.
- Remove screw by which pressure switch bracket is mounted on oil cup..
- Slacken the two screws on the electric wire terminal lugs.
- Slip plastic tube connecting pressure switch to rubber connection off the pressure switch.
- Remove bracket and fix it to new pressure switch.
- Screw down electric wire lugs, slip plastic tube into pressure switch and mount switch on oil cup using the screws previously removed.
- Re-install oil cup and fill with oil as instructed on page 11, par c.

Replacement of pressure switch lamp

- Proceed as described under items 1 and 2 for replacement of pressure switch.
- Remove rubber tube, remove lamp (bayonet cap) and replace with new lamp.
- Re-install rubber tube, replace pressure switch in position and fasten firmly to oil with screw
- Re-install oil cup and fill with oil as instructed on page 11, par c

Electrical connection of pressure switch on Zefir motors

- Plug cable to current socket and insert plug at other end of cable in 12 V. light socket on motor.
Note: If no light socket is provided on the motor to be connected, but the voltage connection box is provided with 12 V. connections, proceed as follows:
 - Mount a Mignon socket pitch 13 at one end of a cable 4 - 5 inches long and at the other connect it to the 12 V. light terminal lugs.
 - Plug cable to current socket at one end and to the above Mignon socket at the other.

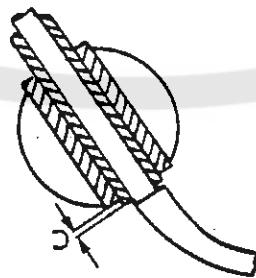


Adjustment of forced feed lubrication rate to main shaft (fig. 18)

- Remove cover.
- Using a screwdriver, turn indicator B in required direction (Turning towards the letter C pushed on the plate, the rate of flow is decreased, turning the indicator towards the letter A, the rate of flow is increased).

fig.18

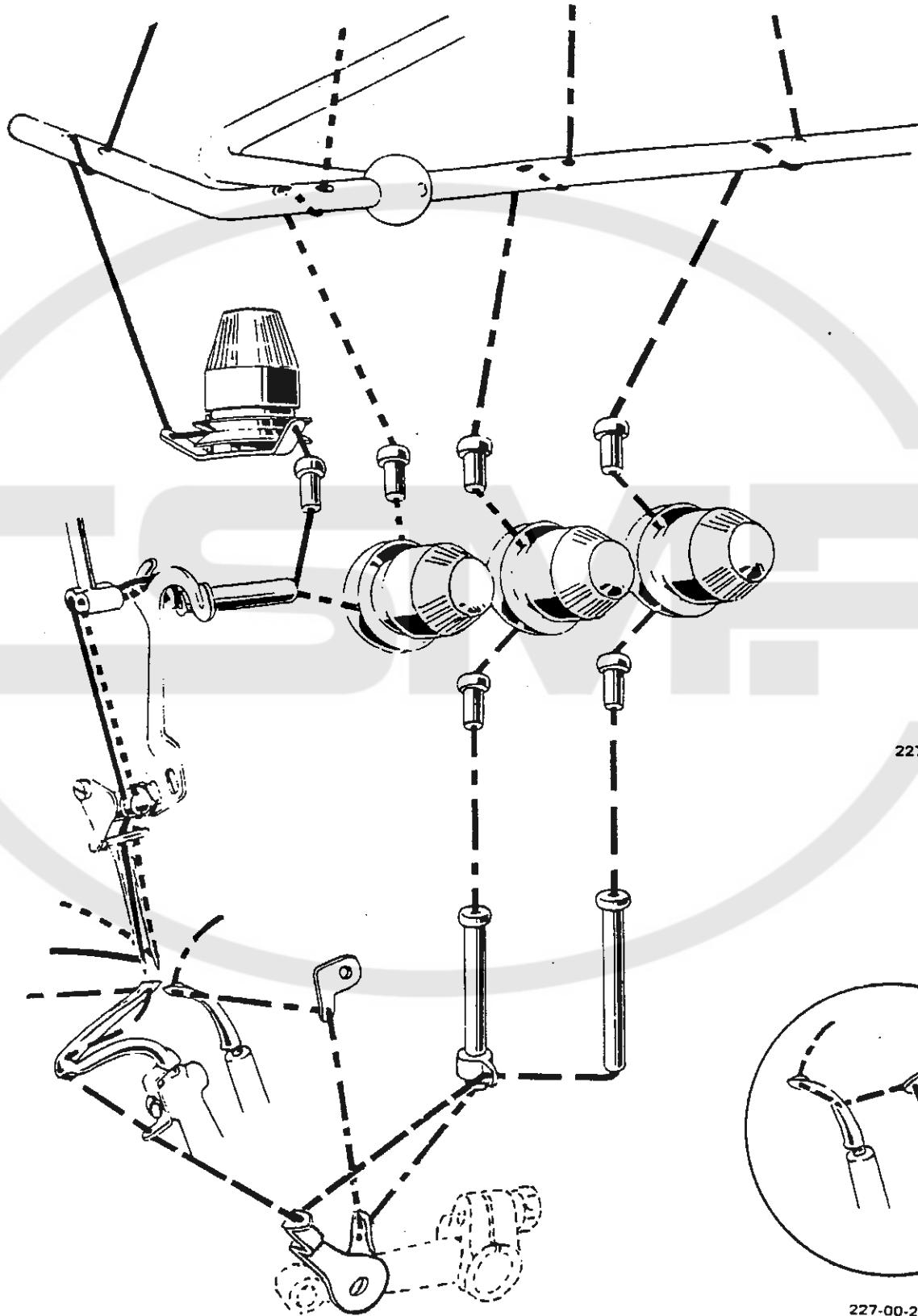
MACHINE HEAD NUMBERS	A	B	C	D	E
227-00-32	2,5+2,8	1,5	3,3+3,5	0,5	—
227-00-20	2,5+3	1,5	8,5	0,3	—
227-01-07					8,8
227-00-21		2,5+3	1,5	3,5	0,3



T I M I N G T A B L E

II - USE

a - Threading



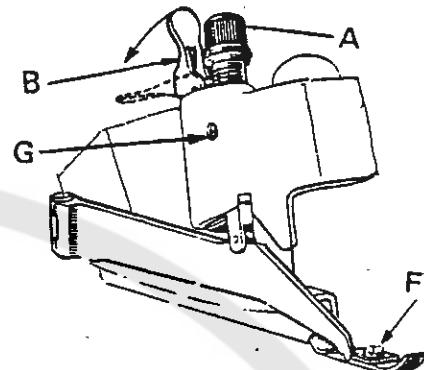
227-00-32

227-00-20



b) Needle change

1. Switch off motor.
2. Depress motor driving pedal to check that machine is absolutely motionless.
3. Set needle at top dead centre.
4. Lower lever B as far as it will go (fig. 19).
5. Swing out presserfoot from usual working position.
6. Slacken needle set-screw by one half-turn using screwdriver 290-746.
7. Remove needle.
8. Insert new needle.
9. The needle scarf should face the rear needle guard, i.e. towards the rear of the machine.
10. Using pincers supplied with machine kit, check that needle touches the bottom of the hole.
11. Retighten needle set-screw without displacing the needle, but do not apply excessive force.



c) Positioning and adjustment of presserfoot (fig. 19)

fig. 19

1. Check that presserfoot is in proper position.
2. Needle should pass between pressurefoot shoe and chaining finger.
3. To adjust presserfoot slacken screw F.
4. Center presserfoot in proper position and tighten up screw F.
5. Presserfoot pressure is increased or slackened by loosening screw G with wrench 633-742 and adjusting knurled knob A.
6. Lock knob A by tightening up screw G with wrench 633-742.

d) Tensioning discs adjustment

1. Tighten tension discs just enough for even stitch formation.
2. Avoid over-tightening.

e) Stitch length adjustment (fig. 13)

1. Slacken screw P using appropriate wrench.
2. Depress pushbutton O and turn handwheel M until tip of pushbutton slips into the notch on the regulator.
3. Holding pushbutton O firm, turn handwheel M vigorously until indicator N shows the desired length on the handwheel.
4. Tighten up screw P firmly.

f) Seam width adjustment

Seam width can be adjusted within a very narrow range beyond which the needle plate must be changed. To vary seam width within the above narrow range, proceed as follows:

1. Slacken screw N of lower knife holder (fig. 10).
2. Slacken screw F (fig. 14).
3. Shift upper knife holder block A (fig. 14) to right or left until desired seam width is obtained.
4. Tighten up screw F (fig. 14).
5. Lower knife holder should be checked and set as described in paragraph d) 7.

No.	TRROUBLE	PROBABLE CAUSE
1	Uneven stitching	- Thread take-ups incorrectly adjusted - Wrong thread tension - Yarns not gauged
2	Feed and Fabric slipping sideways	- Presser foot pressure too light - Height and slant of feed dogs not properly adjusted - Knives require sharpening - Differential badly adjusted
3	Machiné skipping	- Primary or Secondary looper badly adjusted in respect of needle so that loopers too far apart at crossing - Looper becomes blunted - Needle not set in proper position - Front needle guard too far from needle - Loopers too near at crossing, thus becoming blunted - Tension too tight - Yarn irregularly wound on reel
4	Thread breaking	- Machine skipping
5	Needle breaking	- Needle bent - Needle badly mounted
6	Fabric being punctured	- Blunt needle - Needle size unsuitable for plate - Needle point unsuitable
7	Oil leaking	- Screws mounting oil cup on base not sufficiently tightened up - Oil cup plug not screwed down tightly - Oil cup gasket badly mounted
8	Failure lubrication	- Oil level too low - V-belt incorrectly mounted - Upper tube clogged - Lubrication pump filter clogged

III. MAINTENANCE

a) Daily

Lightly clean feed and stitch formation mechanisms.

b) Weekly

1. Thoroughly clean, removing needle plate, feed dogs, front and rear needle guard and loopers.
2. Open front cover plate and carefully clean front cavity.
3. Clean inside the needle movement mechanism casing.

c) Quarterly

1. Using wrench provided with service kit, remove plug beneath oil sump and drain off oil completely.
2. Unscrew screw 007-M-15 by which filter is mounted on drain plug.
3. Remove filter and clean thoroughly by immersing in gasoline.
4. Blow filter and plug with jet of compressed air.
5. Soak felt gasket with clean oil.
6. Replace plug.
7. Fill oil cup with 1 and 3/4 pts fresh VR 604 oil.

IMPORTANT

When following instructions given in paragraph c, 1, do not unscrew drain plug completely immediately, but allow most of the oil to drain out from the side slots in the plug as shown in (fig. 20).

d) Sharpening knives

1. Sharpen knives using RIMOLDI knife sharpener and the special block provided, which assures the exact angle of sharpening. The sharpening block is supplied on request.

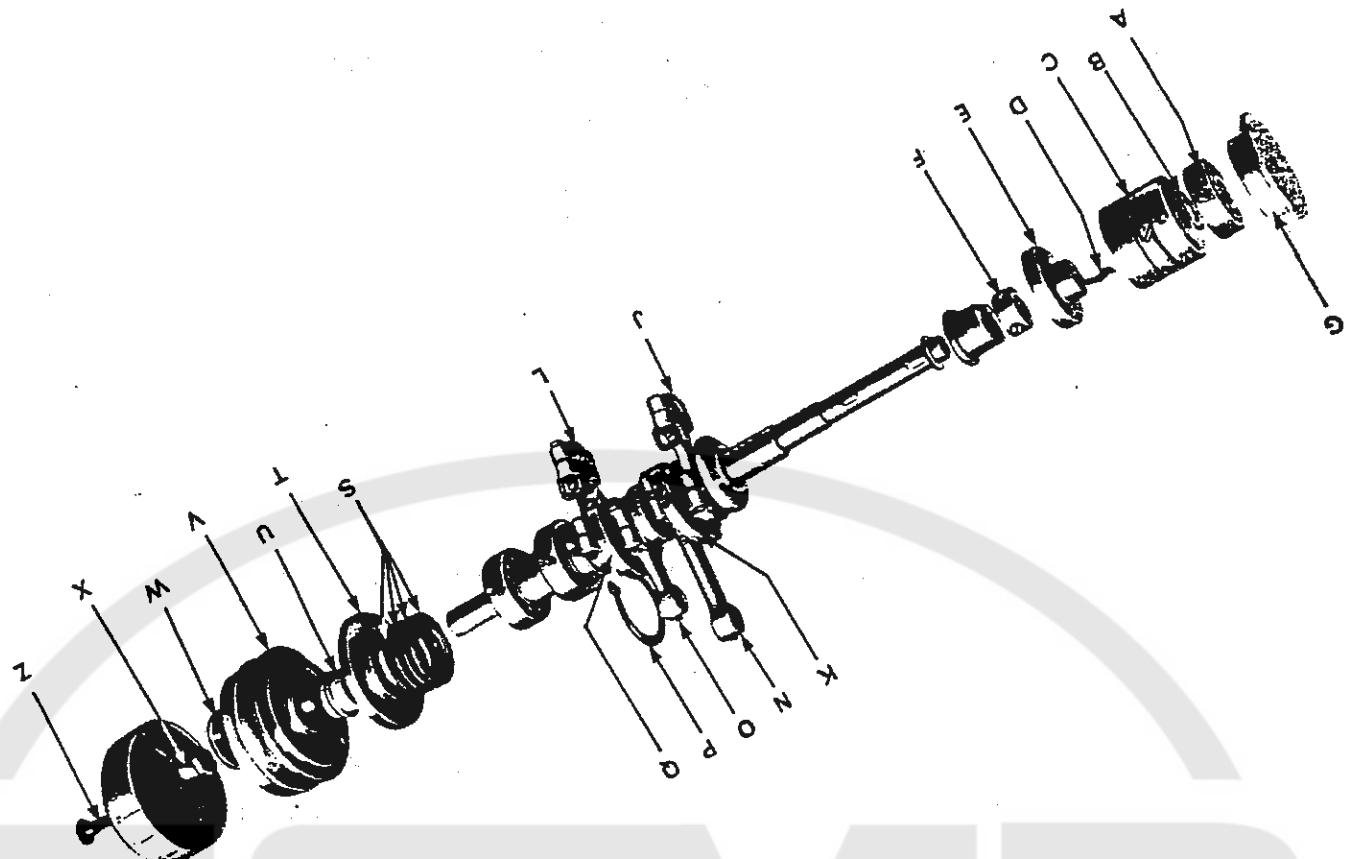
e) Instructions for taking down and removing cam shaft (if necessary).

- Tools required supplied on request only.
- Pincers type S. 0560/00
- Pincers type S. 0459/00
- Puller type S. 0416/00

IMPORTANT

It is absolutely necessary for the main parts of the shaft-connecting rod assembly to be re-installed in their original position. Therefore proceed as follows:

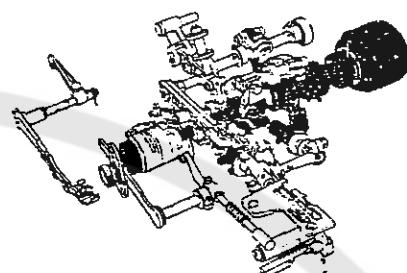
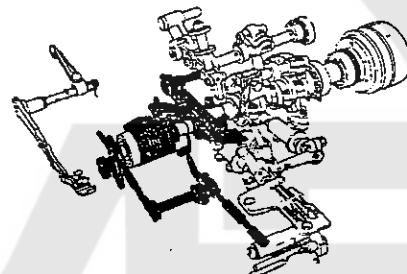
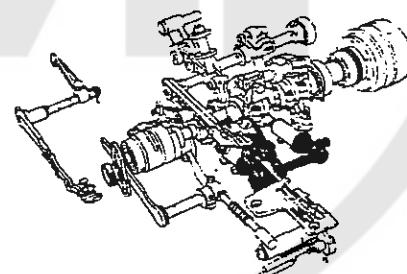
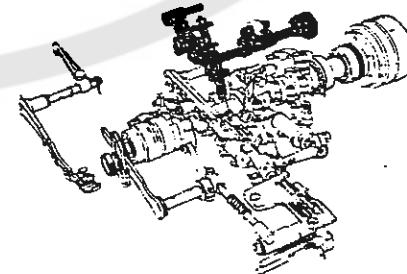
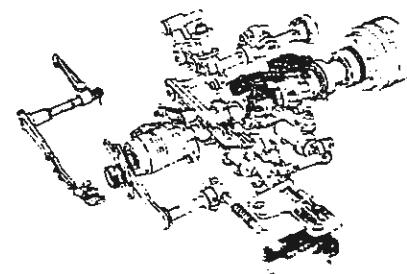
- Re-install flanges G and I with lubrication hole facing downwards.
- Leave all connecting rod lock-screws in their own holes.
- Connecting rods J and L are identified by a 2 punched on the L big-end and three lines on the J rod surface.
- For positioning the connecting rod cap a reference mark is provided on both the cap and connecting rod. Both marks should be on the same side.
- For positioning connecting rod N reference is made to the drawing number on the handwheel side.
- Cup springs should be installed in the original order.



1. Turn stitch length to reference 5 on handwheel.
2. Remove screw Z.
3. Turn stitch length to reference 0 on handwheel.
4. Remove flange G.
5. Slacken the two screws on eccentric C.
6. Remove ball bearing A and eccentric C, using puller S. 0416/99.
7. Remove spring D from regulator E, using pliers S. 0560/00.
8. Slacken screws on ring F.
9. Remove caps from connecting rods N, O, J, L.
10. Remove cover Y from handwheel.
11. Slacken hex screw X.
12. Remove washer W.
13. Remove handwheel V.
14. Remove flange T.
15. Slide off spacer U.
16. Remove cup spring S.
17. Pull off snap-ring P using pliers S. 0459/00, slightly shifting cam to the right.
18. Remove sectors K and Q.
19. Remove shaft.

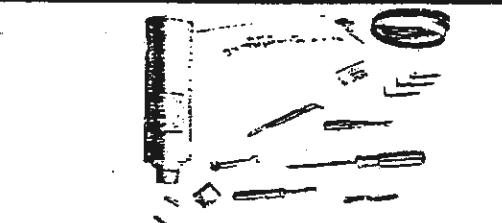
OPERATION SEQUENCE

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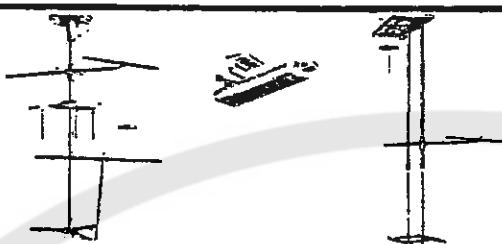
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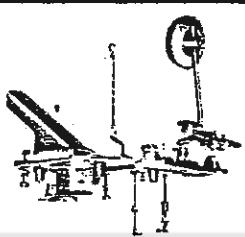
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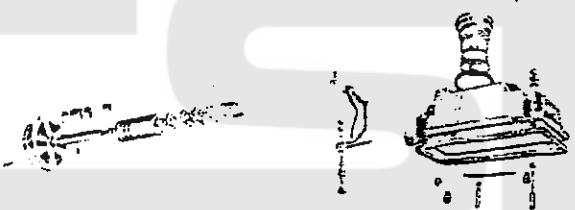
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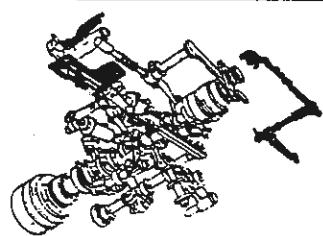
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