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(1) NEEDLE DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204029	323-535-205	Needle bar drive connection	1
2	5233	323-600-296	cap screw	2
3	205495	323-620-040	pin	1
4	5234	323-600-297	" screw	1
5	201360B	323-576-010	Needle bar drive crank	1
			(for 1-needle machine models)	
6	201441B	323-576-011	Needle bar drive crank	1
			(for 2-needle machine models and 504-4-65)	
7	5381	323-600-136	clamp screw	1
8	208247	323-540-027	Needle bar drive shaft	1
9	208248	323-676-042	bushing (left)	1
10	208250	323-626-002	" " oil seal	1
11	208249	323-676-043	" (right)	1
12	201117	323-618-006	thrust collar	1
13	5084	323-600-013	" " screw	2
14	202704	323-851-222	Needle thread guide	1
15	208400	323-851-025	" " guide	1
16	4009-1	323-600-014	screw	1
17	204634	323-561-009	Needle guard (front)	1
			(for 1-needle machine models)	
18	204659	323-561-011	Needle guard (front)	1
			(for 2-needle machine models)	
19	1206	323-600-021	screw	1
20	204635	323-561-010	Needle guard (rear)	1
			(for 1-needle machine models)	
21	204660	323-561-011	Needle guard (rear)	1
			(for 2-needle machine models)	
22	1206	323-600-021	screw	1
23	204636	323-740-018	Needle guard bracket	1
24	1175-3	323-600-019	screw	2
25	204884	323-561-017	Movable needle guard (rear) (optional part)	1
			(for 2-needle machine models)	
26	5136	323-600-245	clamp screw	1
27	204762	323-740-037	Edge guide holder bracket base	1
28	1175-2	323-600-002	screw	2
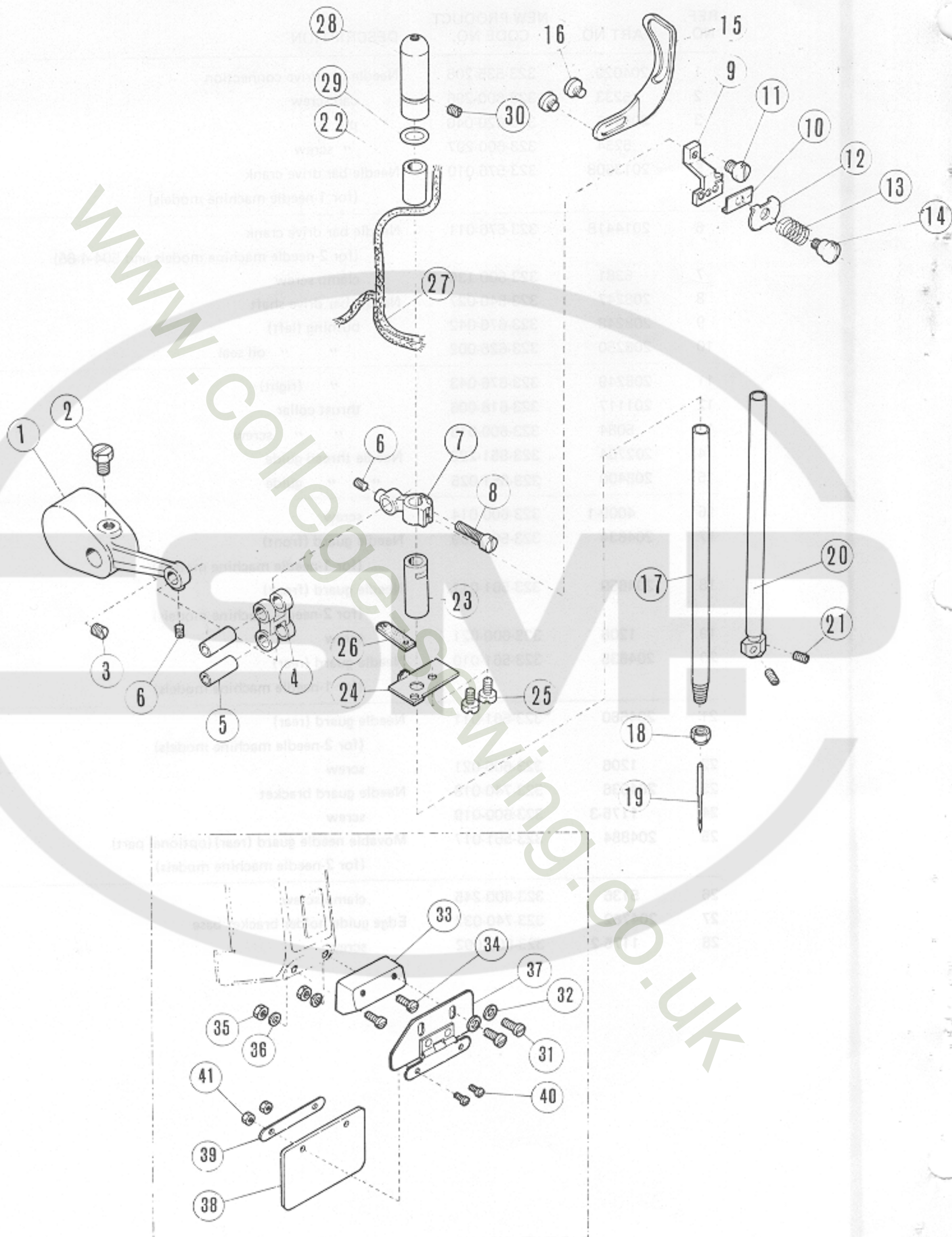
(2) NEEDLE DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208424	323-576-017	Needle bar drive crank (left)	1
2	2022-4	323-600-022	screw (with head)	1
3	2022	323-600-043	screw	1
4	208425	323-730-012	Needle bar connecting link	1
5	200654	323-620-206	pin	2
6	5292	323-600-341	" screw	2
7	208427	323-683-018	Needle bar clamp	1
8	1170-3	323-600-046	clamp screw	1
9	202705A	323-740-016	Needle thread retainer bracket	1
10	202495	323-850-021	guide spacer	1
11	5359	323-600-091	screw	1
12	200041	323-850-221	guide	1
13	200205	323-640-203	" spring	1
14	9070-2	323-600-224	" screw	1
15	202706A	323-866-214	Needle thread takeup	1
16	5299	323-600-300	screw	2
17	204623	323-591-003	Needle bar	1
			(for 1-needle machine models)	
18	3119	323-630-213	Needle clamp nut	1
19	xxxxxx	xxx-xxx-xxx	Needle	1
			(2 pieces required for 2-needle machine models)	
20	xxxxxx	xxx-xxx-xxx	Needle bar, complete	1
			(for 2-needle machine models)	
21	5292	323-600-341	Needle screw	2
22	204625A	323-676-025	Needle bar bushing (upper)	1
23	204627A	323-676-263	Needle bar bushing (lower)	1
24	208616	323-560-053	dust shield	1
25	5053	323-600-015	" screw	2
26	208617	323-653-019	oil release felt	1
27	202176	323-653-005	" wick	1
28	208621	323-780-012	Needle bar cap	1
29	200030	323-634-204	'o' ring	1
30	1457	323-600-012	screw	1
	204988	323-561-018	Eye guard, complete	1
			with 204922, 204924, 204925, 2918 & 5099	
31	1170-3	323-600-046	hinge screw	2
32	200821	323-615-013	" " washer	2
33	204982	323-505-012	" base	1
34	5003	323-600-227	" " screw	2
35	5099	323-630-009	" " " nut	2
36	167066	323-615-211	" " " " washer	2
37	204922	323-728-012	hinge, complete	1
38	204924	323-561-019	guard	1
39	204925	323-615-032	" screw nut washer	1
40	2918	323-600-073	" screw	2
41	5099	323-630-009	" " nut	2
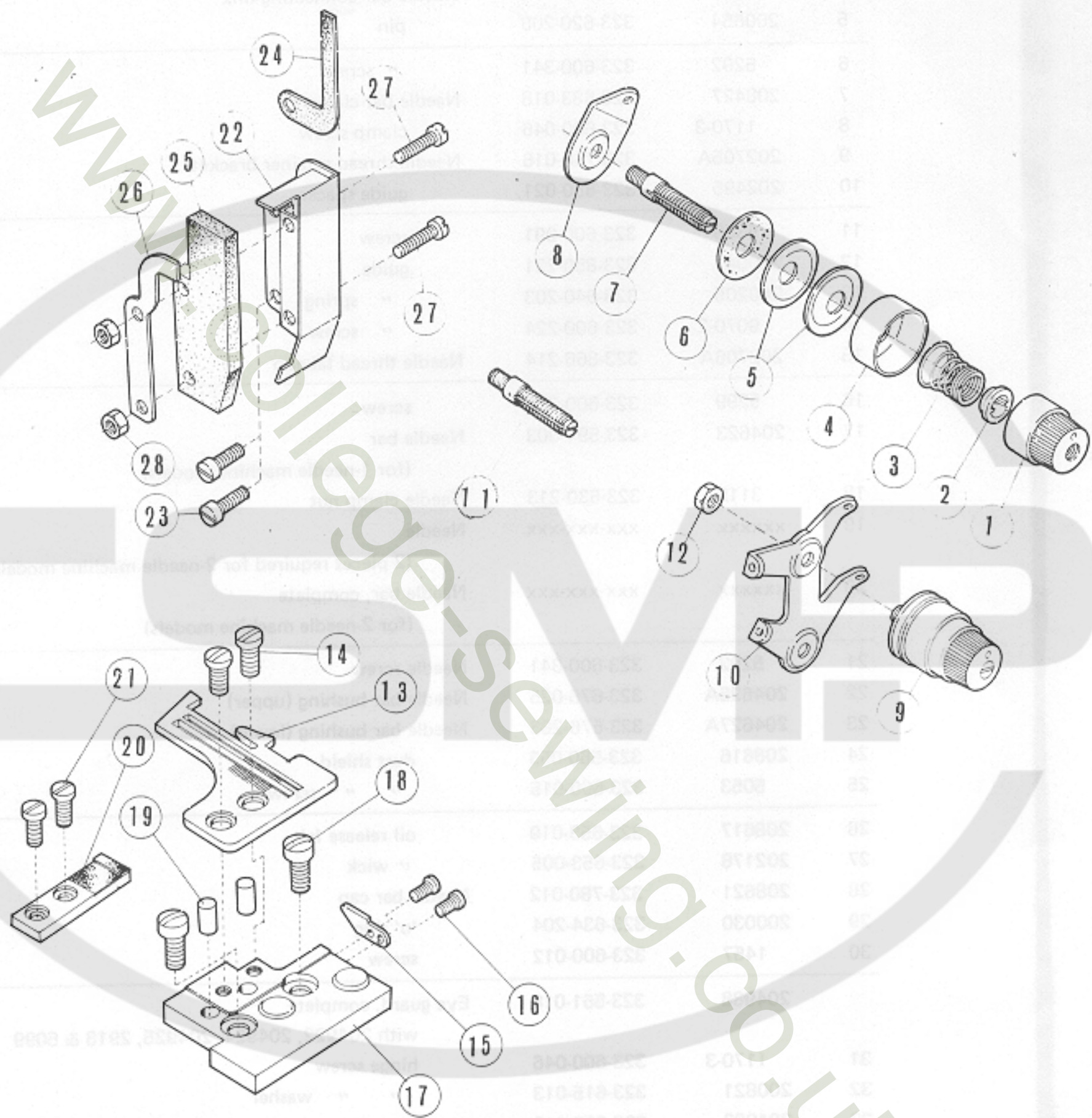
(3) NEEDLE DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
	208488	323-900-045	Needle thread tension, complete with 208447, 208448, 201037, 208450, 201482 x 2, 208449 & 5082A (for 3-thread overlock stitch)	1
1	208447	323-630-033	nut	1
2	208448	323-676-047	spring bushing	1
3	201037	323-642-001	'' (heavy)	1
4	208450	323-780-010	'' cup	1
5	201482	323-613-001	disc	2
6	208449	323-650-001	cushion felt	1
7	5082A	323-604-201	post	1
8	202849	323-800-215	guide	1
9	208491	323-900-048	Needle thread tension, complete with 208447, 208448, 201037, 208450, 201282 x 2, 208449 & 5143A (for 2-needle machine models)	1
10	208307	323-851-024	guide	1
11	5143A	323-604-235	post	1
12	5137	323-630-202	'' nut	1
	208489	323-900-046	Needle thread tension, complete with 208447, 208448, 201086, 208450, 201282 x 2, 208449 & 5082A (for 2-thread overlock stitch)	1
	201086	323-642-003	spring (medium)	1
13	xxxxxx	xxx-xxx-xxx	Needle plate	1
14	4009-1	323-600-014	screw	2
15	204631	323-649-003	key	1
16	5293	323-600-304	'' screw	2
17	204750	323-740-017	Needle plate bracket, set with 204630	1
18	5357	323-600-098	screw	2
19	204630	323-620-017	guide pin	2
20	204632	323-756-003	Needle plate support	1
21	5091	323-600-257	screw	2
	208568	323-510-089	Needle bar connecting link cover, complete with 208560, 208561, 208562, 208563, 5291 & 5099	1
22	208560	323-510-090	Needle bar connecting link cover	1
23	5117	323-600-057	screw	2
24	208561	323-653-017	oil felt	1
25	208562	323-653-018	'' felt	1
26	208563	323-800-062	'' '' plate	1
27	5291	323-600-313	'' '' '' screw	2
28	5099	323-630-003	'' '' '' '' nut	2
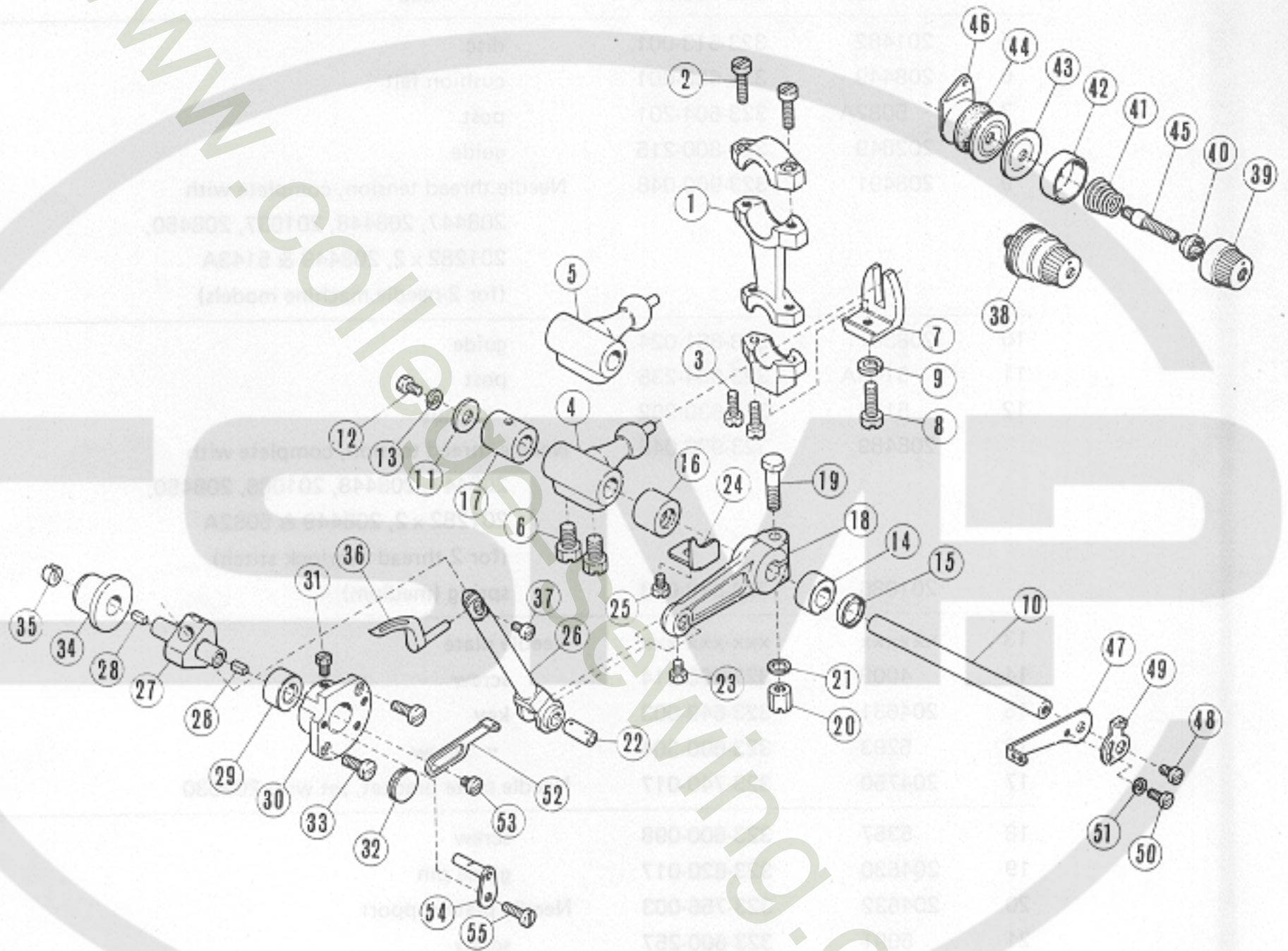
RIGHT LOOPER DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208346	323-525-013	Right looper drive connection	1
2	2213-1	323-600-056	cap screw (large)	2
3	1170-1	323-600-020	" " (small)	2
4	204048A	323-576-213	drive crank	1
5	204788	323-576-007	drive crank (for 514-4-73 and 504-4-65 of 7 & 8mm gauges)	1
6	2022-4	323-600-022	screw	2
7	201074A	323-850-200	guide	1
8	1156	323-600-200	" screw	1
9	202286	323-617-200	" " washer	1
10	204069A	323-540-228	Right looper drive shaft	1
11	204107	323-618-212	thrust washer	1
12	2193	323-600-271	" " screw	1
13	202286	323-617-200	" " " washer	1
14	208299	323-676-048	bushing (front)	1
15	204052A	323-626-201	" " oil seal	1
16	204081	323-676-236	" (center)	1
17	208429	323-676-049	" (rear)	1
18	204055B	323-576-018	Right looper lever crank	1
19	5239	323-630-304	clamp screw	1
20	5286	323-600-225	" " nut	1
21	202045	323-617-204	" " " washer	1
22	208258	323-620-041	pin	1
23	5084	323-600-013	" screw	1
24	208296	323-800-058	set plate	1
25	5147	323-600-206	" " screw	1
26	208319	323-530-028	Right looper lever	1
27	208102	323-851-022	guide	1
28	204274	323-653-209	oil felt	2
	204854	323-676-029	Right looper lever guide bushing (front), complete with 204059, 5084 & 204060	1
29	204059	323-676-248	bushing (front)	1
30	204060	323-515-202	housing	1
31	5084	323-600-013	bushing (front) screw	1
32	208173	323-780-009	housing cap	1
33	1175-2	323-600-002	" screw	2
34	208597	323-676-052	Right looper lever guide bushing (rear)	1
35	208592	323-780-013	cap	1
36	xxxxxx	323-810-xxx	Right looper E51 204990	1
37	1998-2	323-600-024	clamp screw	1
38	208490	323-900-047	Right looper thread tension, complete with 208447, 208448, 201068, 208450, 201482 x 2, 208449 & 5082A	1
39	208447	323-630-033	nut	1
40	208448	323-676-047	spring bushing	1
41	201068	323-642-002	" (light)	1
42	208450	323-780-010	" cup	1
43	201482	323-613-001	disc	2
44	208449	323-650-001	cushion felt	1
45	5082A	323-604-201	post	1
46	202849	323-800-215	guide	1
47	208445	323-866-016	Right looper thread takeup	1
48	202902	323-600-259	screw	1
49	204902	323-866-013	auxiliary	1
50	2921	323-600-026	" screw	1
51	202875	323-615-216	" " washer	1
52	204905	323-851-018	Right looper thread guide wire	1
53	2905	323-600-074	screw	1
54	204656	323-851-010	Looper thread guide, complete	1
55	5012	323-600-255	screw	1
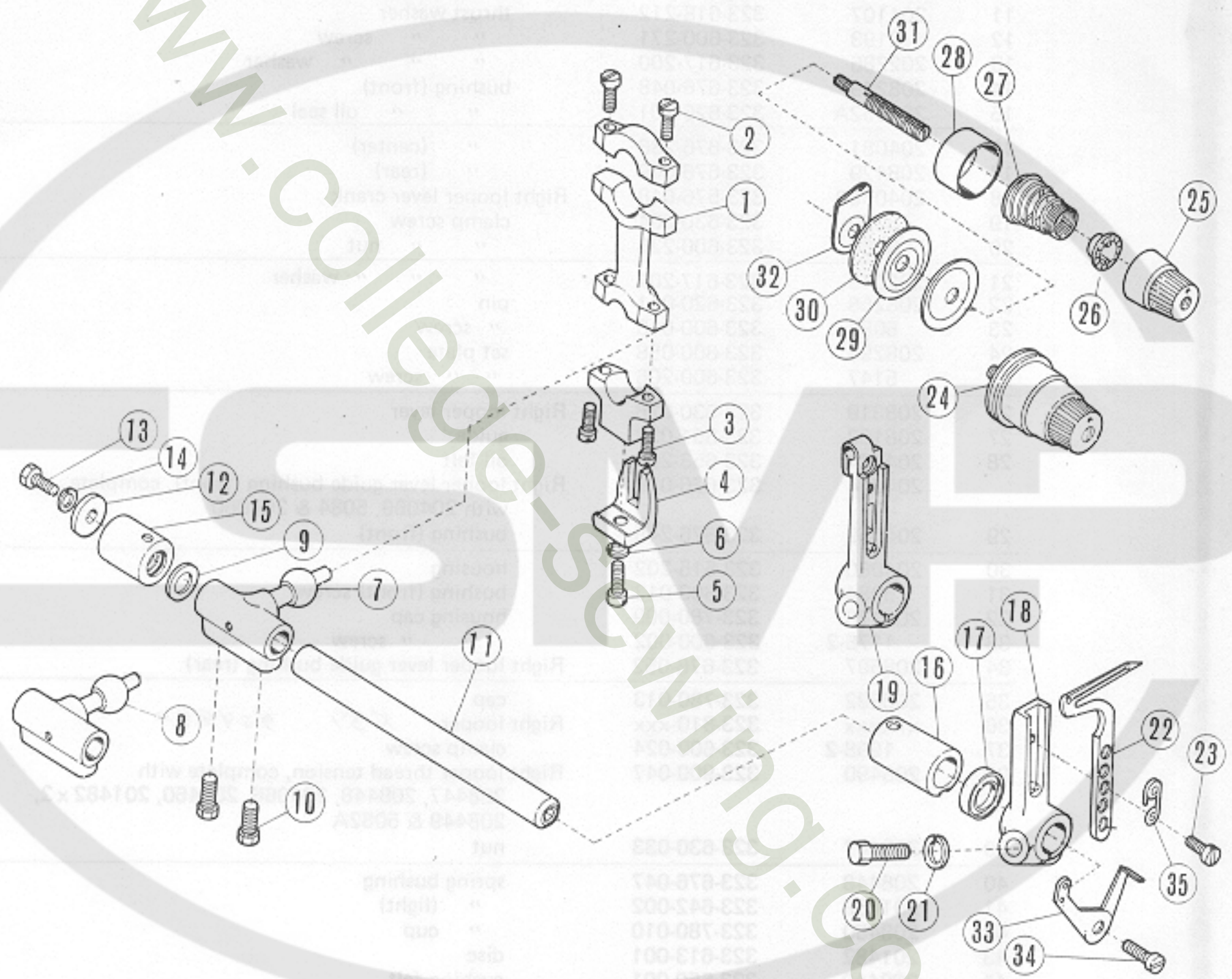
LEFT LOOPER DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208346	323-525-013	Left looper drive connection	1
2	2213-1	323-600-056	cap screw (large)	2
3	1170-1	323-600-020	" " (small)	2
4	201074A	323-850-200	guide	1
5	1156	323-600-200	" screw	1
6	202286	323-617-200	" " washer	1
7	204787	323-576-006	Left looper drive crank	1
			(for 1-needle machine models)	
8	204788	323-576-007	Left looper drive crank	1
			(for 2-needle machine models and 504-4-65)	
9	204789	323-618-010	thrust washer	1
10	2022-4	323-600-022	screw	2
11	204069A	323-540-228	Left looper lever shaft	1
12	204311	323-618-210	thrust washer	1
13	2193	323-600-271	" " screw	1
14	202286	323-617-200	" " " washer	1
15	204054	323-676-235	bushing (rear)	1
16	208293	323-677-046	" (front)	1
17	204052A	323-626-201	" " oil seal	1
18	204664	323-530-010	Left looper lever	1
19	204853	323-530-017	Left looper lever (optional part)	1
			(for Movable Needle Guard, Rear 204884)	
20	5284	323-600-306	clamp screw	1
21	204293	323-616-200	" " washer	1
22	204072	323-810-216	Left looper	1
23	1175-3	323-600-019	screw	1
24	208489	323-900-046	Left looper thread tension, complete	1
			with 208447, 208448, 201086, 208450 x 2,	
			201482, 208449 & 5082A	
25	208447	323-630-033	nut	1
26	208448	323-676-047	spring bushing	1
27	201086	323-642-003	" (medium)	1
28	208450	323-780-010	" cup	1
29	201482	323-613-001	disc	2
30	208449	323-650-001	cushion felt	1
31	5082A	323-604-201	post	1
32	202849	323-800-215	guide	1
33	204786	323-866-005	Left looper thread takeup	1
34	2902	323-600-259	screw	1
35	193174	323-851-217	Left looper thread guide wire	1

(1) MAIN AND DIFFERENTIAL FEED DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204100	323-525-232	Feed drive connection	1
2	205495	323-620-040	pin	1
3	5084	323-600-013	" screw	1
4	204084	323-672-200	needle bearing	1
5	204085	323-576-220	Feed drive crank	1
	208333	323-576-020	Feed drive crank (for 503-4-44 and 503-4-48 only)	1
6	5381	323-600-136	clamp screw	1
7	208282	323-580-084	Feed eccentric, complete with 208273, 208279, 208207, 208208, 204354 x 2, 208209, 1196, 208330 & 1175-3	1
8	5312	323-600-351	screw	2
9	208279	MFG only	feed eccentric	1
10	208207	323-787-005	" " liner	1
11	204354	323-620-251	" " pin	2
12	208208	323-800-063	" " spring plate (large)	1
13	208209	323-800-064	" " " " (small)	1
14	1196	323-600-029	" " " " screw	1
15	208409	323-618-018	" " " " " washer	1
16	208283	MFG only	" " retainer	1
17	208330	323-625-002	Feed eccentric stopper, complete	1
18	1175-3	323-600-019	screw	1
19	208410	323-716-013	Feed eccentric regulator	1
	208411	323-900-050	Feed eccentric regulator position gear, complete with 208413, 208463 x 2, 208412 & 5336	1
20	208413	MFG only	position gear bracket	1
21	208412	MFG only	" gear	1
22	208415	323-640-027	spring	2
23	204863	MFG only	pin	2
24	5336	323-600-116	screw	1
	208416	323-900-051	Feed eccentric regulator position internal gear, complete with 208417, 208418 & 5366	1
25	208418	MFG only	internal gear bracket	1
26	208417	MFG only	" gear	1
27	5366	323-600-124	screw	4
28	5312	323-600-351	screw	2
29	208420	323-535-004	Feed eccentric push rod	1
30	5412	323-600-134	screw	1
31	208421	323-640-021	spring	1
32	202522	323-634-200	retaining ring	1
33	204185	323-632-201	'o' ring	1
34	204752	323-540-017	Differential feed shaft	1
35	208294	323-676-045	bushing	1
36	204052A	323-626-201	oil seal	1
37	204754	323-680-007	thrust collar	1
38	5084	323-600-013	" " screw	2
39	204139A	323-502-213	Differential feed shaft arm	1
40	5381	323-600-136	clamp screw	1
41	204140A	323-730-214	Differential feed link	1
42	5316	323-600-347	screw, set with 202522	2
43	202522	323-634-200	screw retaining ring	2
44	204755	323-530-011	Differential feed regulating lever (rear)	1
45	5118	323-600-060	screw	1
46	204883	323-530-018	lever (front)	1
47	1216	323-600-068	" " screw	1
48	204142B	323-800-036	" guide	1
49	5118	323-600-060	" " screw	2
50	204143A	323-891-200	" lift guide	2
51	5321A	323-600-083	" adjust screw	1
52	204870	323-630-017	" " nut	1
53	202868	323-618-209	" " " washer	1
54	204756	323-640-006	Differential feed regulating spring	1
55	204757	323-600-102	latch screw	1
56	204869	323-600-107	Knee controller chain hook latch screw	1

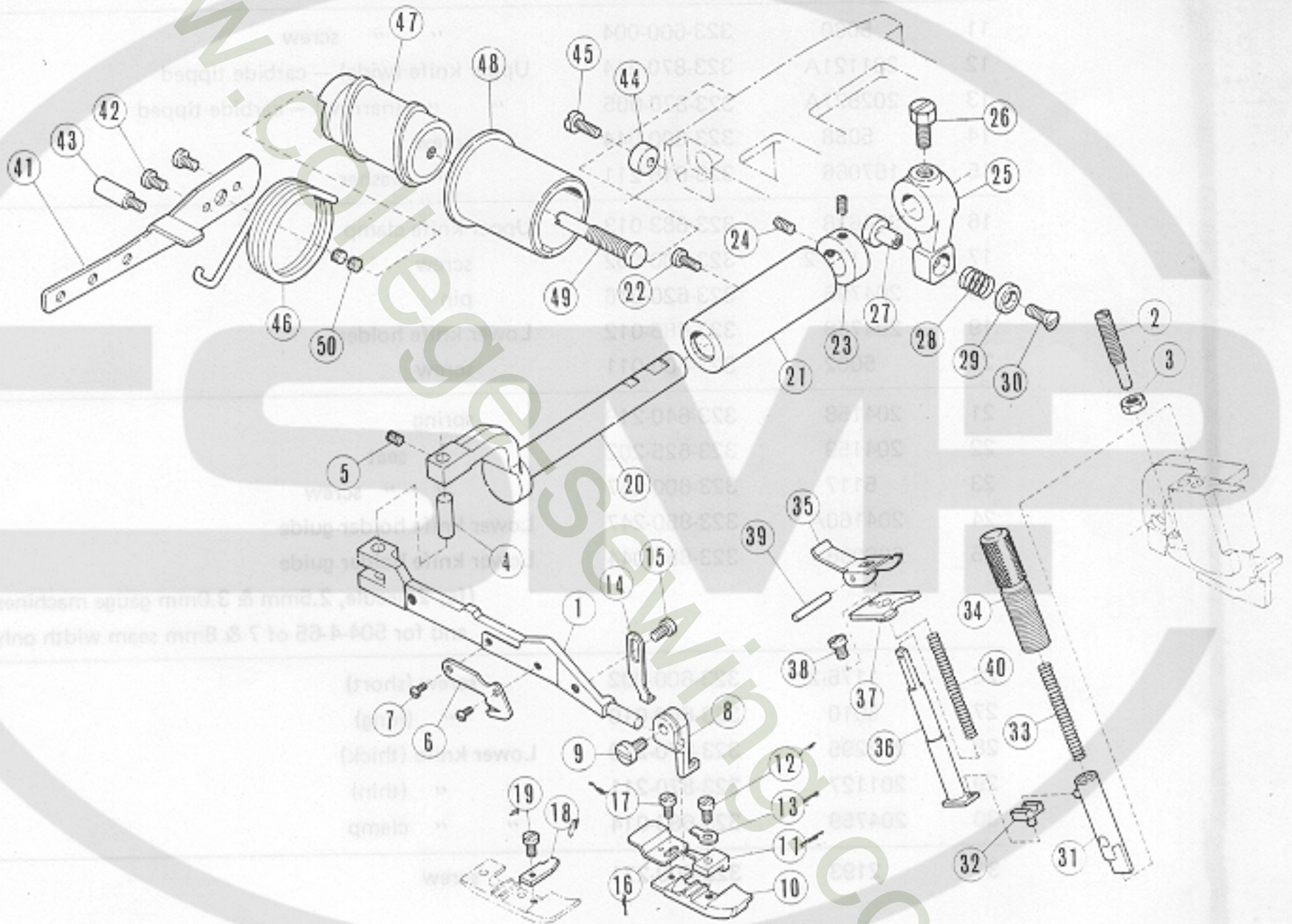## (2) MAIN AND DIFFERENTIAL FEED DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204751	323-540-016	Feed bar shaft	1
2	204107	323-618-212	thrust washer	1
3	4009-1	323-600-014	" " screw	1
4	204054	323-676-235	bushing	2
5	201056	323-618-003	thrust collar	1
6	5084	323-600-013	" " screw	2
7	208284	323-576-019	Main feed regulating crank	1
8	5381	323-600-136	clamp screw	1
9	204111A	323-730-011	Main feed connecting link	1
10	204618	323-653-004	oil felt	1
11	204588	323-686-002	" " retainer	1
12	208285	323-620-035	pin	1
13	5404	323-630-032	" nut	1
14	208286	323-615-036	" " washer	1
15	204114	323-676-251	bushing	1
16	5231	323-600-309	" screw	1
17	204115	323-618-211	" " washer	2
18	208273	323-716-011	Differential feed regulator, complete with 208274, 208275, 208476 & 5029 x 2	1
19	208274	MFG only	segment	1
20	5381	323-600-136	" clamp screw	1
21	208275	MFG only	block	1
22	208276	MFG only	" cover	1
23	5029	323-600-256	" " screw	2
24	5141	323-600-087	" stop screw	1
25	204122	323-525-234	Differential feed connecting link	1
26	204114	323-676-251	bushing	1
27	5231	323-600-309	" screw	1
28	204115	323-618-211	" " washer	2
29	204123A	323-593-003	Main feed bar	1
30	204124	323-593-207	Differential feed bar	1
31	204128A	323-620-252	Feed bar hinge pin	1
32	5084	323-600-013	screw	1
33	204439A	323-615-033	washer	1
34	5317	323-600-355	" screw	1
35	204129A	323-676-261	Feed bar guide bushing	1
36	2133-1	323-600-215	screw	1
37	204810	323-750-003	Feed bar lift block (split)	1
38	201107	323-750-002	" " guide block	2
39	208108	323-850-049	Feed bar guide (right)	1
40	5205	323-600-353	screw	2
41	208107A	323-850-050	Feed bar guide (left), set with 208168	1
42	208168	323-663-019	gasket	1
43	5205	323-600-353	screw	2
44	208109	323-560-046	Feed bar oil splash guard	2
45	208110	323-800-053	insert plate	1
46	5346	323-600-366	screw	4
47	xxxxxx	xxx-xxx-xxx	Main feed dog	1
48	1175-2	323-600-002	screw	1
49	xxxxxx	xxx-xxx-xxx	Auxiliary feed dog	1
50	2922	323-600-229	screw	1
51	xxxxxx	xxx-xxx-xxx	Differential feed dog	1
52	1189	323-600-301	screw	1
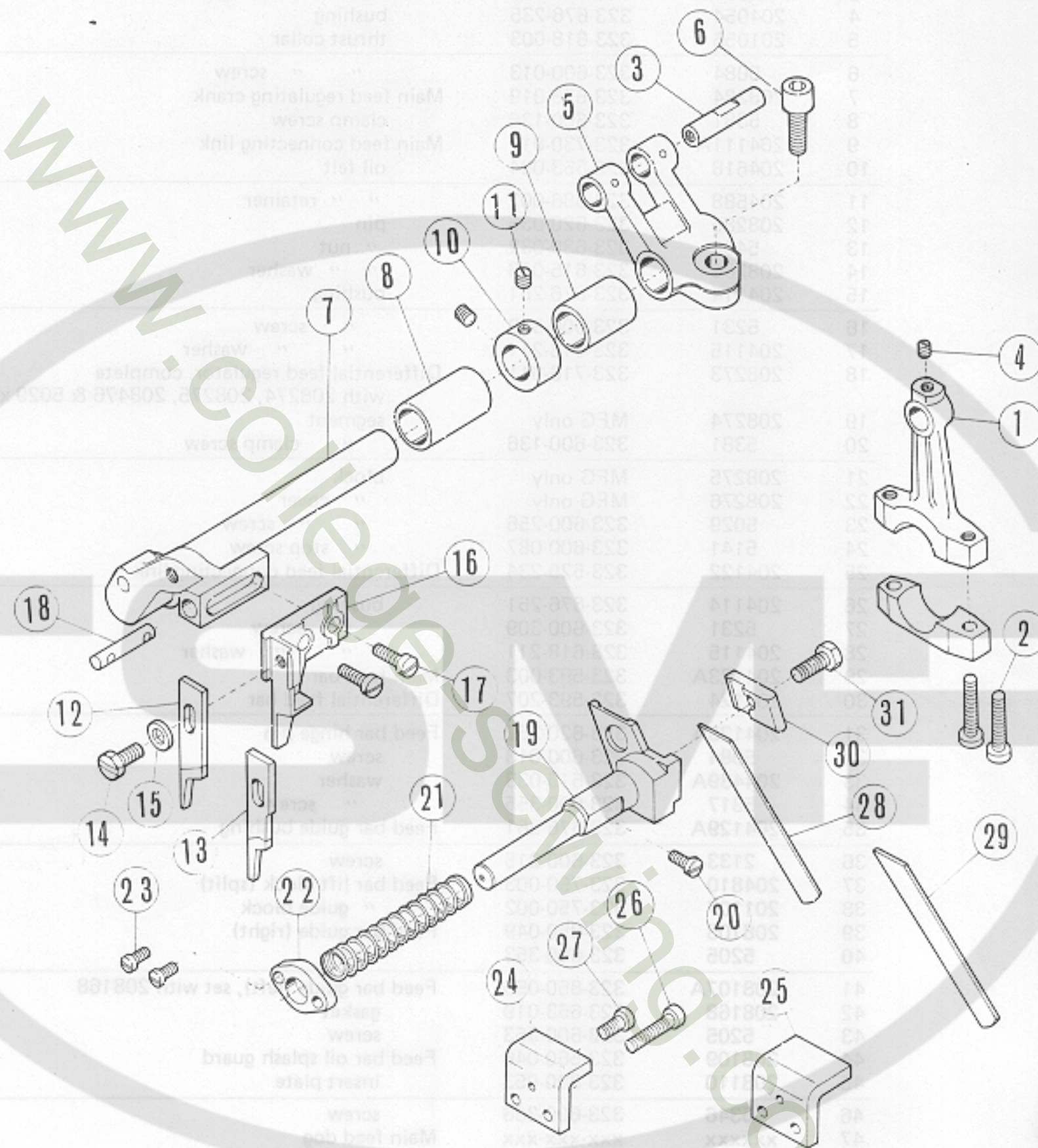
UPPER AND LOWER KNIFE DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204145A	323-525-014	Upper knife drive connection	1
2	5233	323-600-296	cap screw	2
3	204146	323-620-244	pin	1
4	1458	323-600-037	" screw	1
5	204147	323-525-236	Upper knife drive crank	1
6	5381	323-600-136	clamp screw	1
7	204148B	323-685-008	Upper knife lever	1
8	204149	323-676-239	bushing (left)	1
9	204150	323-680-208	" (right)	1
10	201635	323-680-207	thrust coilar	1
11	5060	323-600-004	" " screw	2
12	201121A	323-870-214	Upper knife (wide) — carbide tipped	1
13	202527A	323-870-005	" " (narrow) — carbide tipped	1
14	5088	323-600-044	screw	1
15	167066	323-615-211	" washer	1
16	204638	323-683-013	Upper knife clamp	1
17	1175-2	323-600-002	screw	2
18	204796	323-620-016	pin	1
19	204758	323-685-012	Lower knife holder	1
20	5002	323-600-011	screw	1
21	204158	323-640-219	spring	1
22	204159	323-625-202	" seat	1
23	5117	323-600-057	" " screw	2
24	204160A	323-850-247	Lower knife holder guide	1
25	208096	323-850-044	Lower knife holder guide (for 2-needle, 2.5mm & 3.0mm gauge machines and for 504-4-65 of 7 & 8mm seam width only)	1
26	1175-2	323-600-002	screw (short)	1
27	5010	323-600-010	" (long)	1
28	202295	323-870-210	Lower knife (thick)	1
29	201127	323-870-211	" " (thin)	1
30	204759	323-683-014	" " clamp	1
31	2193	323-600-271	screw	1

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION
1	20146A	323-826-014	Upper knife drive connection
2	6233	323-800-296	cap screw
3	20146	323-620-244	pin
4	1468	323-600-037	" screw
5	20147	323-828-296	Upper knife drive crank
6	6381	323-800-139	clamp screw
7	20146B	323-866-008	Upper knife lever
8	20149	323-676-238	bushing (left)
9	20150	323-660-008	" (right)
10	20152B	323-600-207	drum collar

Diagram labels (parts 1–50): 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50

PRESSER FOOT AND LIFT MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208526	323-502-011	*Presser arm*	1
2	5271	323-600-141	lift regulating screw	1
3	3044	323-630-001	" " " nut	1
4	208549	323-620-042	hinge pin	1
5	5167	325-600-011	" " screw	1
6	201308	323-873-001	Chaincutter knife	1
7	1333	323-600-048	screw	2
8	208525	323-685-022	Presser foot holder	1
9	5136	323-600-245	clamp screw	1
10	xxxxxx	xxx-xxx-xxx	Presser foot body	1
11	xxxxxx	xxx-xxx-xxx	chaining-off finger	1
12	5089	323-600-050	" " screw	1
13	201156	323-643-001	hinge spring	1
14	208547	323-716-014	regulator	1
15	2921	323-600-026	" screw	1
16	xxxxxx	xxx-xxx-xxx	uncurler	1
17	5030	323-600-202	" screw	1
18	xxxxxx	xxx-xxx-xxx	fabric guard	1
19	1231	323-600-051	" " screw	1
20	208534	323-540-031	Foot lift lever shaft	1
21	208535	323-676-050	bushing, complete	1
22	2133-1	323-600-215	bushing screw	1
23	201056	323-618-003	collar	1
24	1457	323-600-012	" screw	2
25	208313	323-530-029	Foot lift intermediate lever	1
26	2022-4	323-600-022	screw	1
27	208314	323-620-036	pin	1
28	208315	323-640-024	" spring	1
29	202757A	323-617-002	" washer	1
30	5317	323-600-355	" screw	1
31	208537	323-592-001	Presser bar	1
32	208479	323-850-055	guide	1
33	208540	323-640-023	spring	1
34	208615	323-600-142	Pressure regulating thumb screw	1
35	208598	323-530-031	Hand lift lever	1
36	202645	323-629-201	spring plunger	1
37	208599	323-676-053	" " bushing	1
38	5029	323-600-256	" " " screw	1
39	202647A	323-620-239	hinge pin	1
40	201395	323-640-228	spring	1
41	204177B	323-530-016	Foot lift lever	1
42	1202	323-600-032	screw	2
43	5232	323-600-314	stop screw	1
44	202683	323-716-209	regulator	1
45	5118	323-600-060	" screw	1
46	204178	323-640-220	spring	1
47	204929	323-710-003	Foot lift cam	1
48	204930	323-676-039	bushing	1
49	208316	323-604-018	regulating screw stud	1
50	2913-2	323-600-316	" " " stop screw	1
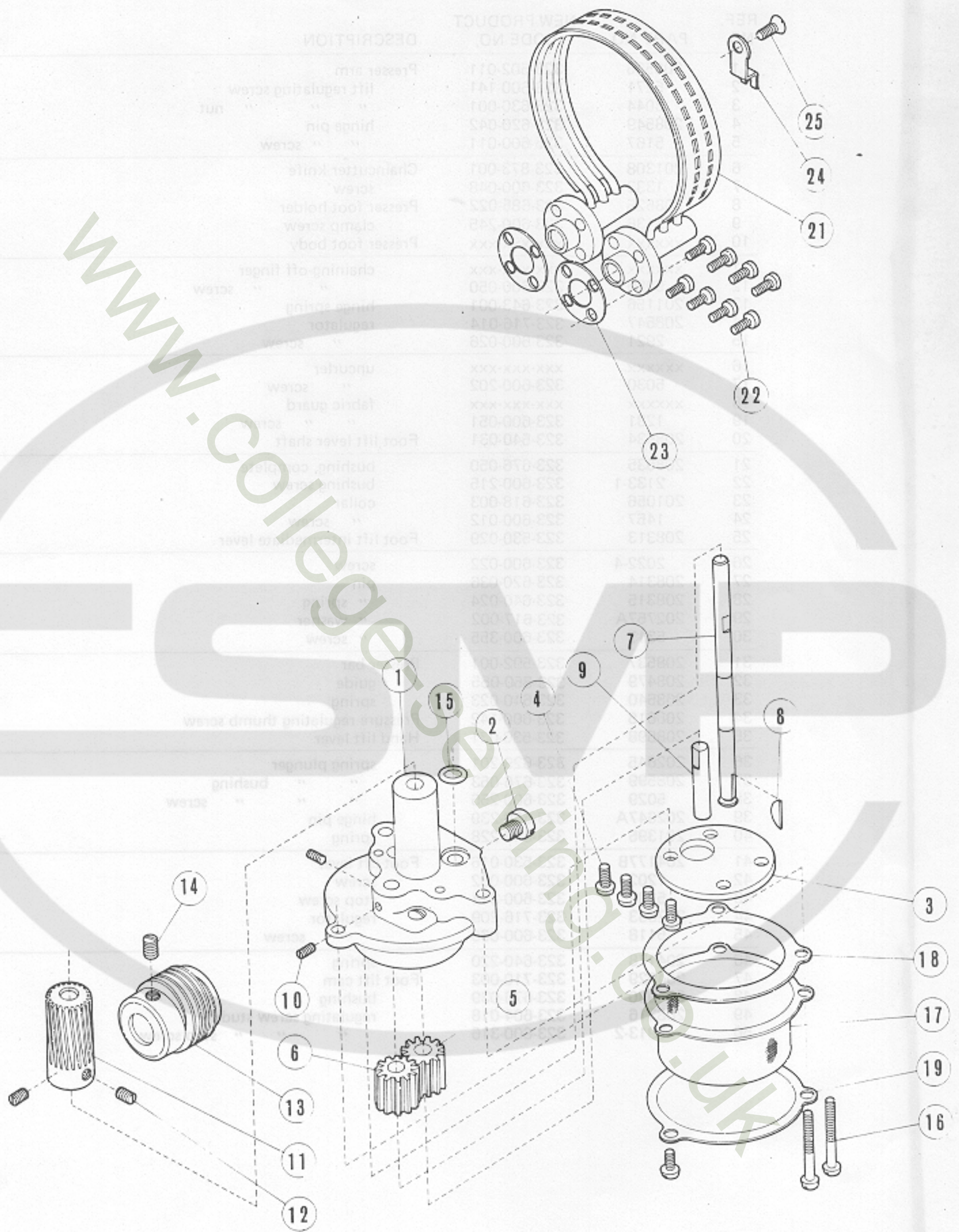
(1) PUMP LUBRICATING MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
	204593	323-900-012	Gear pump, complete	1
			(includes parts of Ref. Nos. 1-12)	
1	204180	323-515-203	Gear pump housing, complete	1
2	5145	323-600-326	Gear pump housing oil plug screw	1
3	201293A	323-800-006	Gear pump casing plate	1
4	5117	323-600-057	screw	4
5	201294	323-764-001	Pump gear (right)	1
6	201295	323-764-002	Pump gear (left)	1
7	204183	323-540-237	Pump gear shaft (long), set with 201009	1
8	201009	323-649-001	key	1
9	204184	323-540-236	Pump gear shaft (short)	1
10	1458	323-600-037	screw	2
11	204187	323-570-204	Worm wheel	1
12	5060	323-600-004	screw	2
13	204186	323-570-203	Worm	1
14	2022	323-600-043	screw	1
15	204185	323-632-201	Gear pump outlet 'o' ring	1
16	5094	323-600-072	Gear pump housing screw	2
17	201338	323-655-002	Oil screen filter	1
18	201311	323-663-001	gasket	1
19	201341	323-508-002	frame	1
20	5117	323-600-057	screw	1
21	204188	323-902-020	Oil cooler assembly	1
22	5117	323-600-057	screw	8
23	204192	323-663-211	gasket	2
24	204189	323-683-214	clamp	1
25	3001	323-600-059	screw	1

MACHINE BED FRAME

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208601	MFG only	Machine bed frame	1
2	5332	323-600-359	oil hole plug screw (with head)	1
3	2022	323-600-043	'' '' '' screw	3
4	208602	323-500-019	Machine arm (right)	1
5	204251	323-663-207	gasket	1
6	5078	323-600-001	screw	1
7	201002	323-620-001	dowel pin	2
8	208603	323-500-020	Machine arm (left)	1
9	5237	323-600-327	screw (long)	1
10	5163	323-600-328	'' (short)	2
11	201002	323-620-001	dowel pin	2
12	208434	323-560-047	oil shield	1
13	208169A	323-663-021	gasket	1
14	204003	323-882-201	Oil sight gauge	1
15	208173	323-780-009	Dead hole plug	1
16	204828	323-627-010	'' '' plug	1
17	5179	323-600-329	'' '' '' screw (small)	2
18	201006	323-615-001	'' '' '' '' '' washer	2
19	204006	323-620-242	Machine bed bottom pin	4
20	208440	323-692-034	Type plate blank — 504-4	1
	208442	323-692-036	'' '' blank — 503-4	1
	208444	323-692-037	'' '' blank — 512-4	1
	208441	323-692-035	'' '' blank — 514-4	1
21	204794A	323-655-007	Machine bed oil filter	1
22	208289	323-800-056	Machine bed cover plate (back)	1
23	208290	323-663-020	gasket	1
24	5117	323-600-057	screw	5
25	202526	323-692-201	Manufacturer's name plate	1
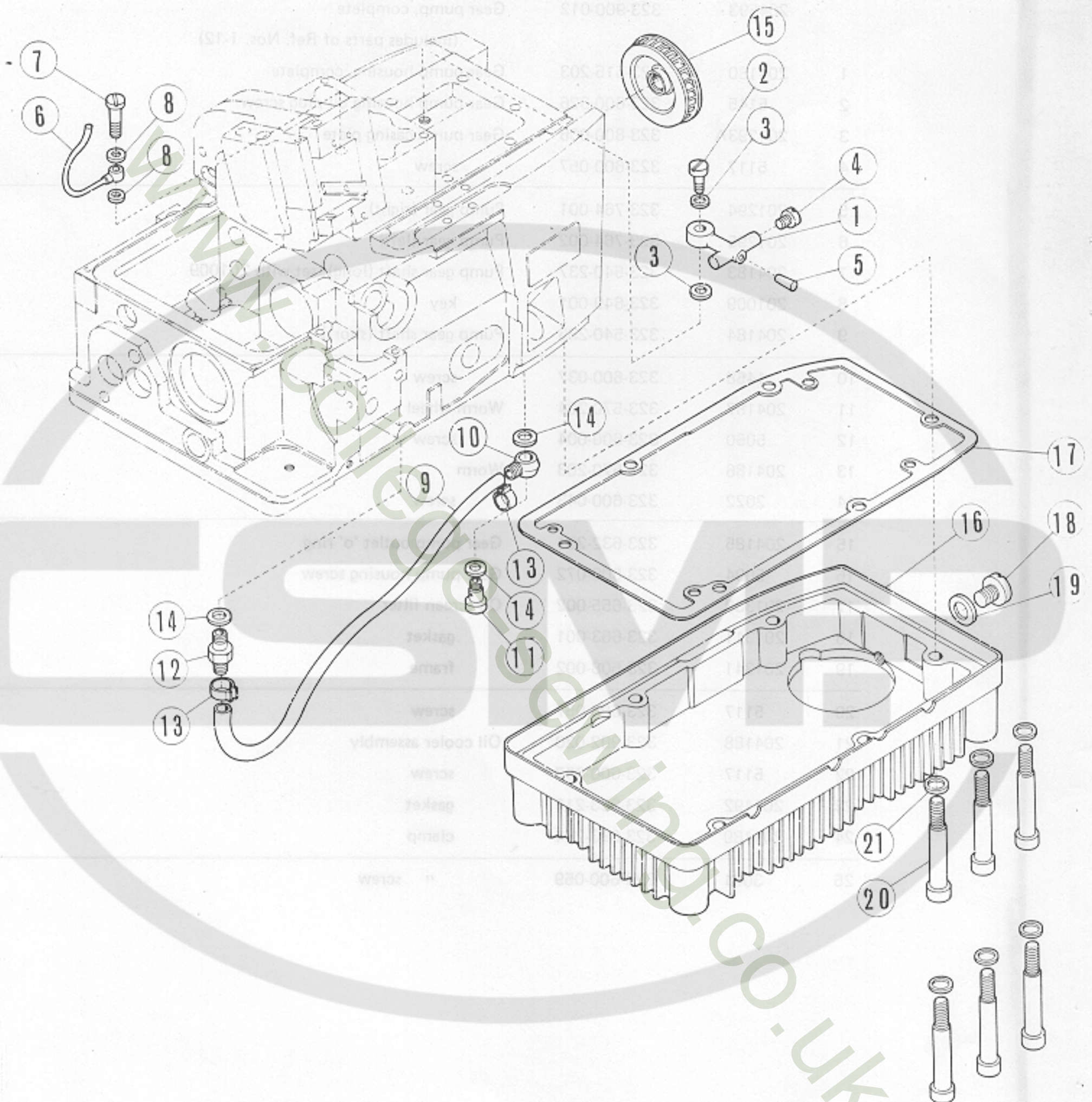
(2) PUMP LUBRICATING MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204193	323-639-232	Oil distributor	1
2	200152	323-604-209	screw	1
3	200138	323-615-209	" washer	2
4	201323	323-600-062	oil splash screw	1
5	202903	323-627-208	" plug	1
6	204194	323-639-233	Oil splash pipe, complete	1
7	201758	323-600-064	screw	1
8	201759	323-615-010	" washer	2
9	200140	323-639-205	Oil tube (for lubricating crankshaft bushing center)	1
10	200136	323-636-200	joint	1
11	200152	323-604-209	" stud	1
12	204196	323-736-200	joint	1
13	200155	323-685-213	" clamp	2
14	200138	323-615-209	joint washer	3
15	204198	323-568-202	Oil cooling fan	1
16	208260	323-713-003	Oil pan	1
17	208318	323-663-023	gasket	1
18	5138B	323-600-354	Oil drain plug screw	1
19	202287A	323-615-229	washer	1
20	5150B	323-605-006	Oil pan bolt	6
21	204806	323-615-029	gasket	6
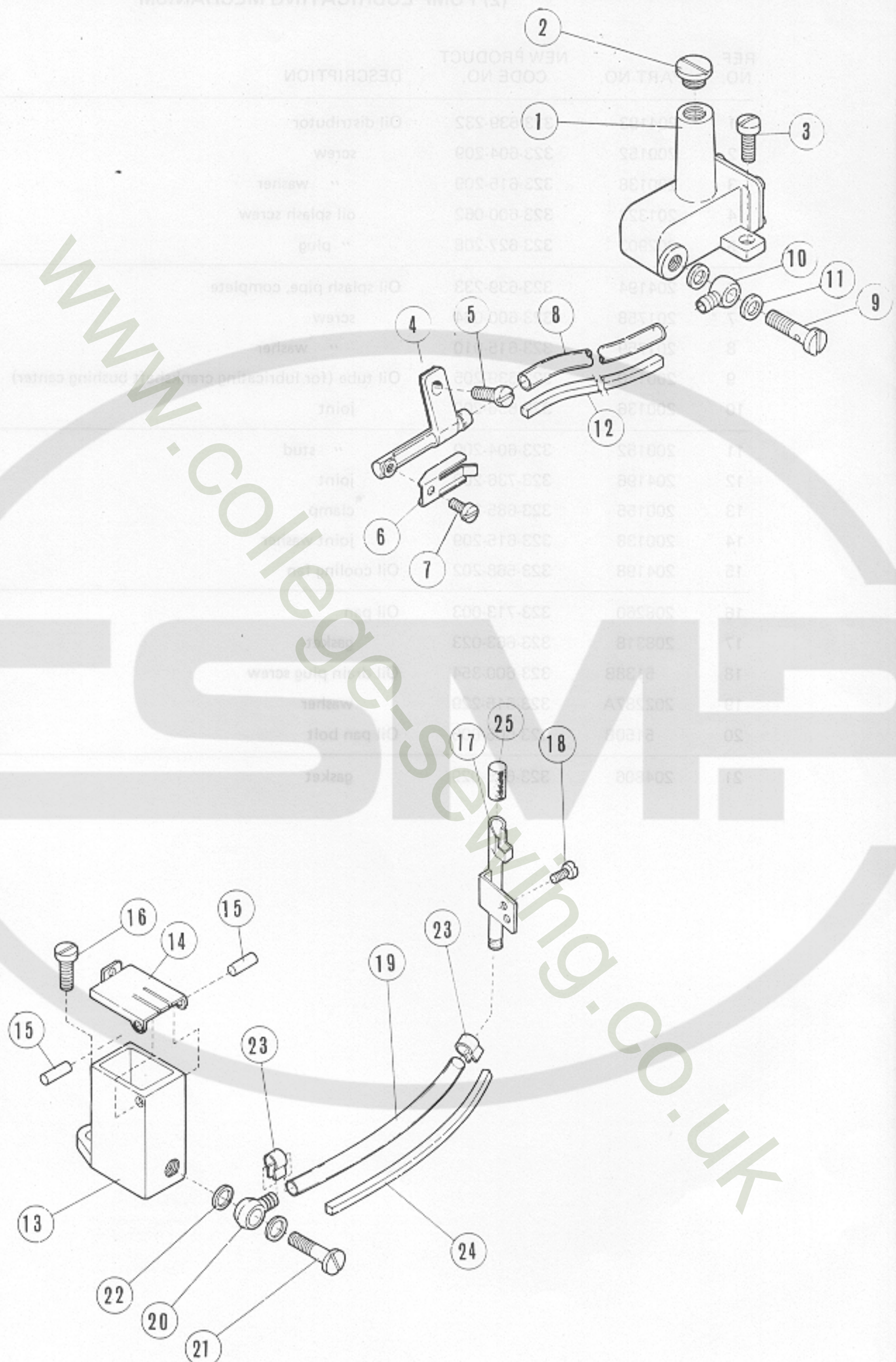
NEEDLE AND THREAD LUBRICATOR
(Optional parts)

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208308	323-658-005	Silicone lubricant reservoir (upper), complete	1
2	5242	323-600-143	oil filler screw	1
3	5118	323-600-060	screw	1
4	208446	323-639-034	Thread lubricator	1
5	5117	323-600-057	screw	1
6	208487	323-800-065	plate	1
7	5012	323-600-255	" screw	1
8	204921	323-639-239	lubricant pipe	1
9	200137	323-604-222	" " joint screw	1
10	200136	323-636-200	" " joint	1
11	200138	323-615-209	" " " washer	2
12	204270	323-653-006	" " oil felt	1
	204860	323-658-004	Silicone lubricant reservoir (lower), complete with parts of Ref. Nos. 13-15	1
13	204861	323-658-003	reservoir (lower)	1
14	204862	323-510-035	cap cover	1
15	204863	323-620-025	" " hinge pin	2
16	5117	323-600-057	screw	1
17	204651		Needle lubricator	1
18	1206	323-600-021	screw	1
19	204921	323-639-239	lubricant pipe	1
20	200136	323-636-200	" " joint	1
21	200137	323-604-222	" " " screw	1
22	200138	323-615-209	" " " washer	2
23	200155	323-685-213	" " clamp	2
24	204270	323-653-006	" " oil felt	1
25	204465	323-653-007	oil felt	1

ACCESSORIES FOR SEMI-SUBMERGED INSTALLATION

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	205466	323-945-001	Machine rest board	1
2	205473	323-945-014	cushion rubber	4
3	206336	325-630-004	hanger bolt nut	4
4	5439	323-605-008	" bolt	4
5	205467	323-646-006	" " spacer	8
6	202769	323-615-219	" " washer	4
7	205470	323-740-062	Waste chute top	1
8	175	323-600-321	screw	3
9	205468	323-774-002	Waste chute	1
10	205469	323-774-003	extension	1
11	5019	323-600-247	screw	4
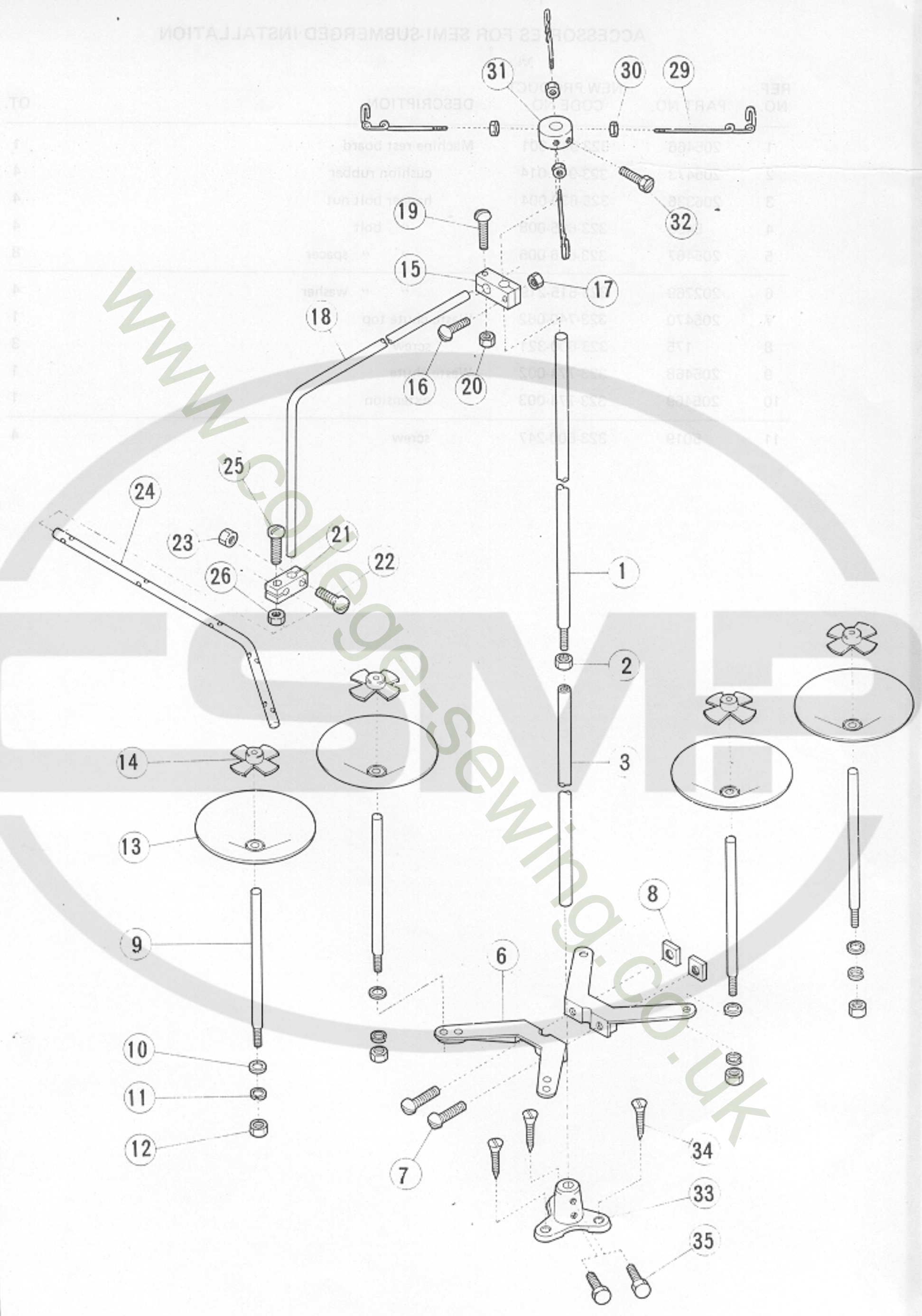
THREAD STAND

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT. SPOOLS 3	QT. SPOOLS 4
	288	323-940-003	Thread stand complete — 3 spools	1	—
	289	323-940-004	Thread stand complete — 4 spools	—	1
1	216	323-535-001	Thread stand upper rod	1	1
2	217	323-600-118	nut	1	1
3	218	323-535-002	Thread stand lower rod	1	1
4	219	323-740-035	Spool pin bracket	1	—
5	243	323-800-041	clamp plate	1	—
6	220	323-740-036	Spool pin bracket	—	2
7	221	323-600-119	clamp screw	2	2
8	222	323-630-018	" " nut	2	2
9	223	323-620-024	Spool pin	3	4
10	224	323-615-028	washer	3	4
11	225	323-617-001	nut spring washer	3	4
12	226	323-630-019	nut	3	4
13	227	323-685-013	Spool tray	3	4
14	228	323-850-031	Spool retaining fin	3	4
15	229	323-740-034	Thread guide bar rod bracket	1	1
16	230	323-600-120	clamp screw	1	1
17	231	323-630-020	" " nut	1	1
18	292	323-535-005	Thread guide bar rod	1	1
19	230	323-600-120	screw	1	1
20	231	323-630-020	" nut	1	1
21	233	323-750-006	Thread guide rod retaining block	1	1
22	230	323-600-120	clamp screw	1	1
23	231	323-630-020	" " nut	1	1
24	293	323-590-004	Thread guide bar	1	1
25	230	323-600-120	clamp screw	1	1
26	231	323-630-020	" " nut	1	1
27	235	323-851-021	Thread guide wire (long)	2	—
28	236	323-630-021	lock nut	2	—
29	237	323-851-020	Thread guide wire (short)	1	4
30	236	323-630-021	lock nut	1	4
31	260	323-685-016	Thread guide wire holder	1	—
	261	323-685-017	" " holder	—	1
32	239	323-600-121	screw	1	1
33	240	323-505-009	Thread stand base	1	1
34	241	323-600-122	wood screw	3	3
35	242	323-600-123	Thread stand lower rod screw	2	2
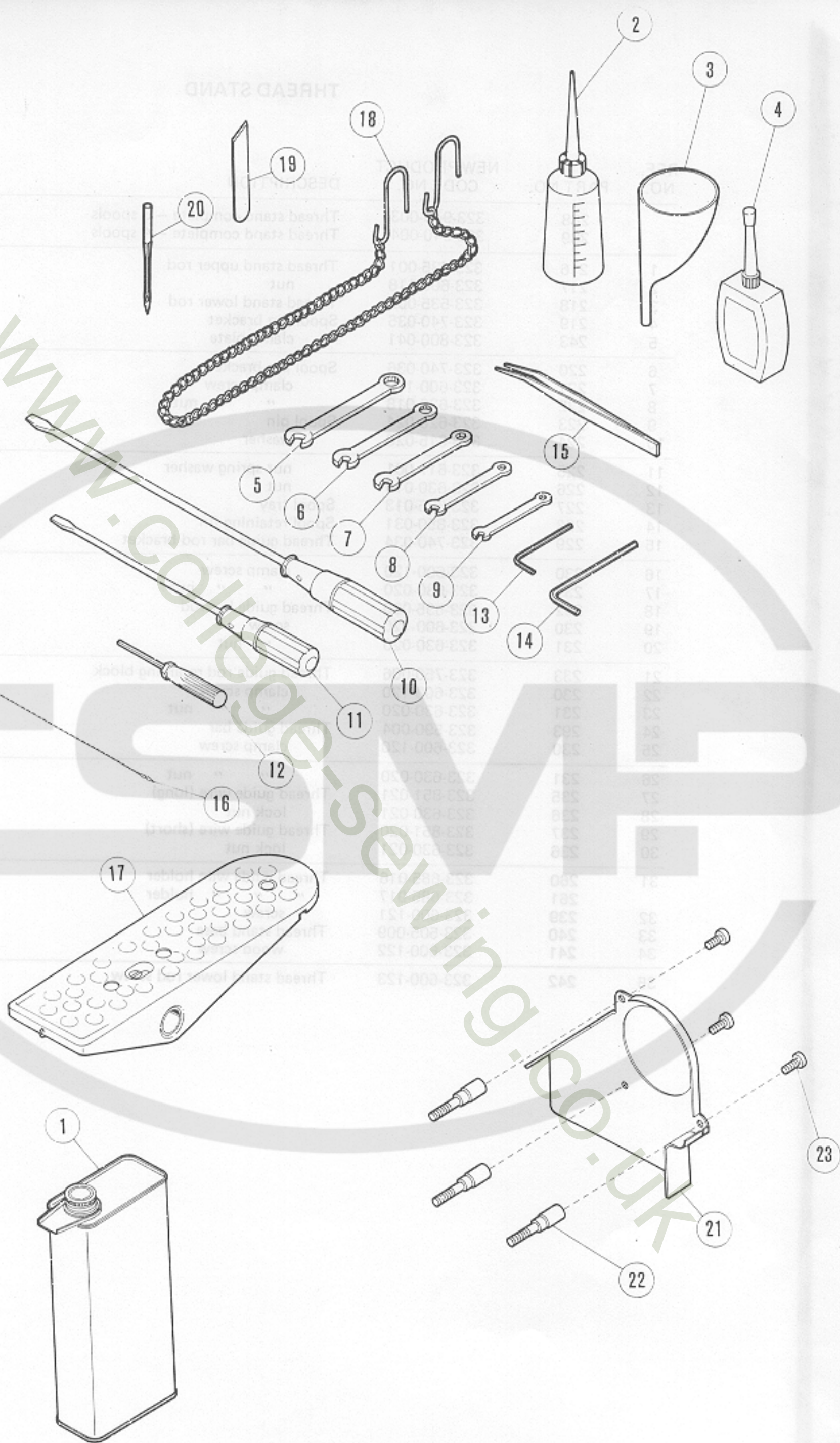
ACCESSORIES

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	134	323-945-015	Oil container (750cc)	1
2	137	323-659-015	Oiler	1
3	135A	323-945-003	Oil funnel	1
4	178	323-945-007	Silicone lubricant container (50cc) (for machine equipped with Needle and Thread Lubricator)	1
5	286	323-880-014	Wrench (9.5mm)	1
6	285	323-880-013	" (8mm)	1
7	284	323-880-012	" (7mm)	1
8	283	323-880-011	" (6mm)	1
9	282	323-880-010	" (5mm)	1
10	127	323-885-001	Screwdriver (large)	1
11	128	323-885-002	" (medium)	1
12	179	323-885-200	Allen wrench (1.56mm)	1
13	182	323-880-214	Allen key (3.17mm)	1
14	200	323-880-005	Allen key (4.76mm)	1
15	131	323-886-001	Tweezers	1
16	153	323-660-200	Threading wire	1
17	245	323-533-005	Treadle	1
18	126	323-732-001	Treadle chain	1
19	xxxxxx	xxx-xxx-xxx	Lower knife	2
20	xxxxxx	xxx-xxx-xxx	Needle	10
21	205216	323-945-009	Belt guard	1
22	205217	323-600-117	fixing screw	3
23	5117	323-600-057	screw	3
	272		Allen key (6.0mm) (not shown)	1
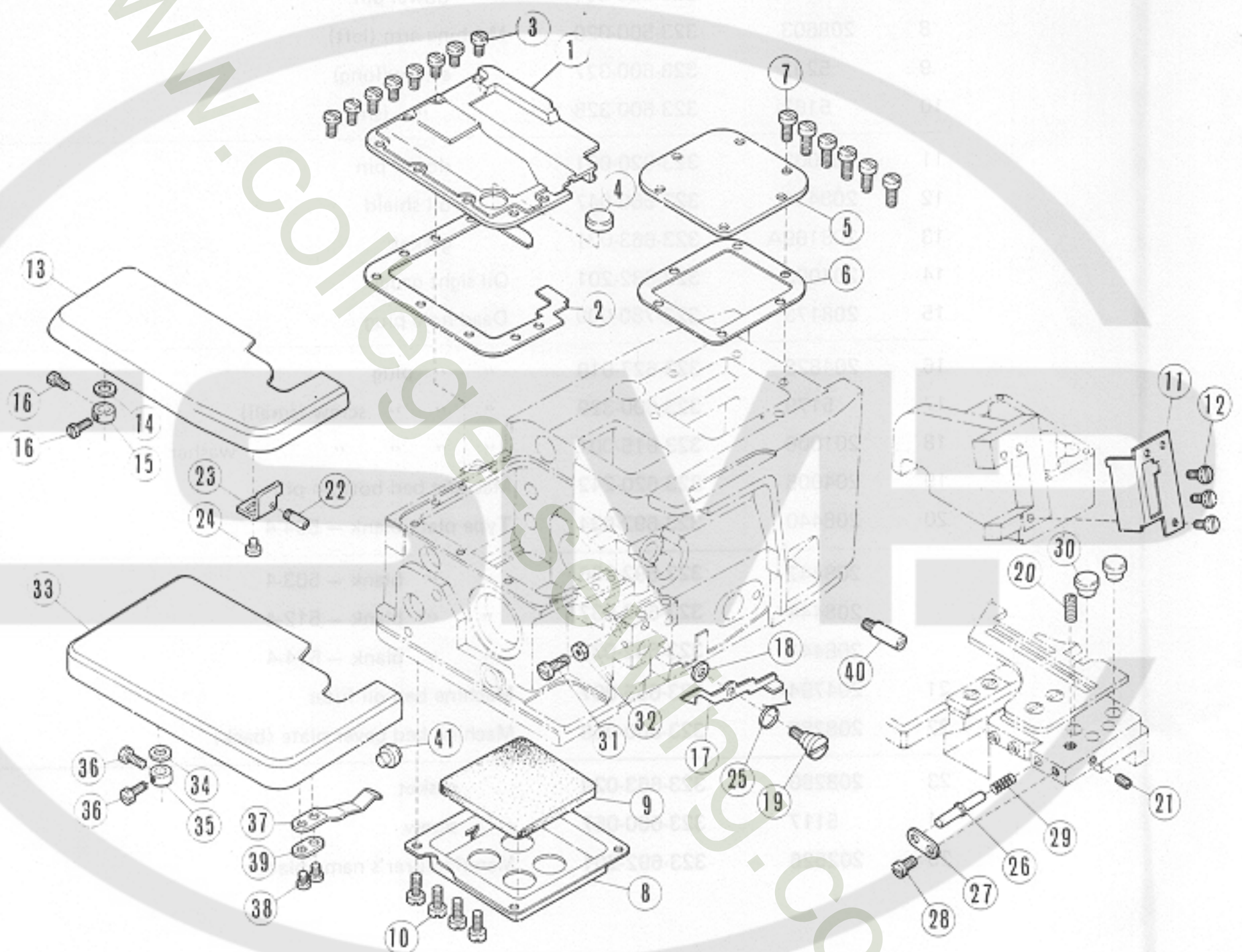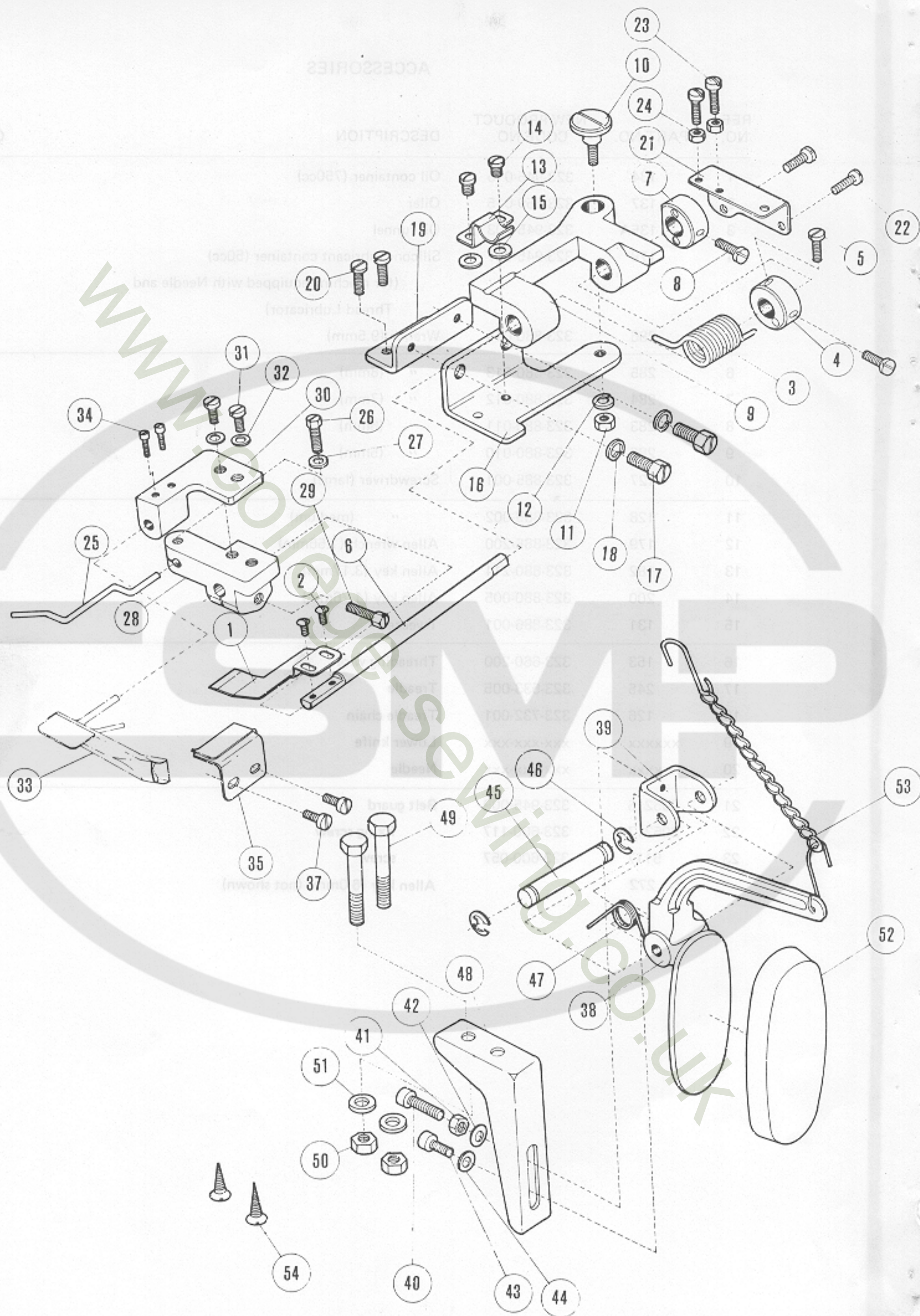
ATTACHMENTS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
	204882	323-900-014	Shirring attachment, complete with parts of Ref. Nos. 1-29	1
1	205137	323-875-001	Shirring blade	1
2	5227	323-600-302	screw	2
3	205065	323-640-225	spring	1
4	205066	323-615-227	" collar	1
5	5064	323-600-025	" " screw	2
6	205067	323-540-246	Shirring attachment shaft	1
7	205068	323-680-210	collar	1
8	2213	323-600-237	" screw	1
9	205069	323-750-204	Shirring attachment block	1
10	5326	323-600-350	screw	1
11	5137	323-630-202	" nut	1
12	202286	323-617-200	" " washer	1
13	205070	323-625-203	lock spring	1
14	1229	323-600-016	" " screw	2
15	200183	323-618-007	" " " washer	2
16	204495	323-800-235	Shirring attachment block plate	1
17	2193	323-600-271	screw	2
18	202286	323-617-200	" washer	2
19	204451	323-740-229	extension	1
20	5117	323-600-057	" screw	2
21	205072	323-530-232	Shirring blade swing-out lever	1
22	5117	323-600-057	screw	2
23	1170	323-600-226	regulating screw	2
24	3091	323-630-003	" " nut	2
25	204592	323-534-001	Shirring blade lifter	1
26	5276	323-600-088	clamp screw	1
27	202058	323-615-213	" " washer	1
28	205104	323-750-205	block	1
29	5276	323-600-088	" clamp screw	1
30	205103	323-685-243	Cord and piping attachment block	1
31	1175-3	323-600-019	screw	2
32	167066	323-615-211	" washer	2
33			Cord and piping attachment (binder)	1
34	1170-1	323-600-020	screw	2
35	205091	323-850-258	Shirring cloth guide	1
36	1216	323-600-068	screw	2
37	137906	323-615-018	" washer	2
	192	323-900-224	Knee controller, complete with parts of Ref. Nos. 38-53	1
38	193	323-530-100	Knee controller	1
39	194	323-728-004	Knee controller hinge	1
40	5183	323-600-100	regulating screw	1
41	3044	323-630-001	" " nut	1
42	137142	323-615-017	" " " washer	1
43	5118	323-600-060	screw	1
44	137142	323-615-017	" washer	1
45	195	323-620-100	pin	1
46	202522	323-634-200	" stop ring	2
47	196	323-640-100	spring	1
48	197	323-505-100	bracket	1
49	5347	323-605-003	" screw	2
50	5348	323-630-013	" " nut	2
51	204585	323-615-021	" " " washer	2
52	198	323-665-001	Knee pad	1
53	199	323-732-002	chain	1
54	5341	323-600-101	hinge bracket wood screw	2
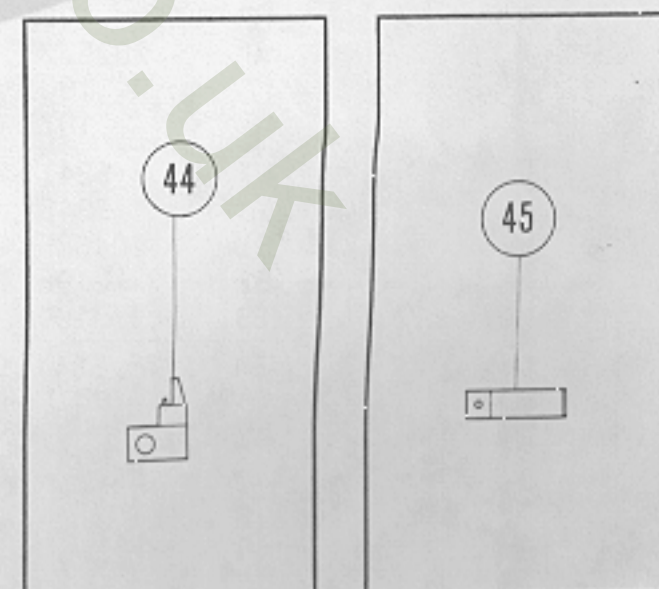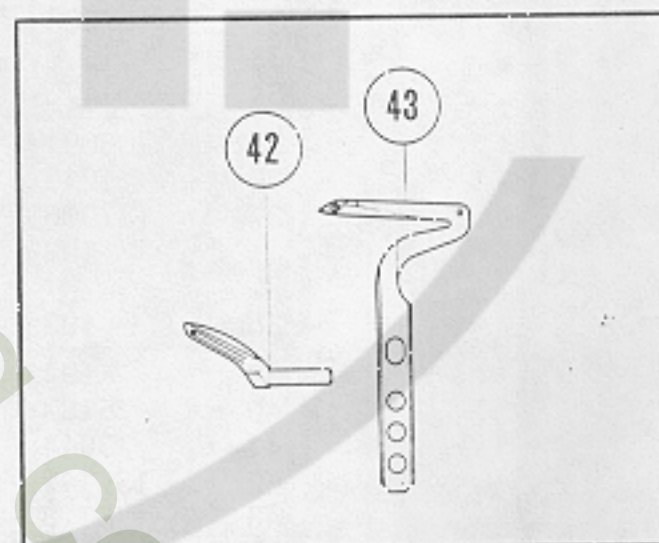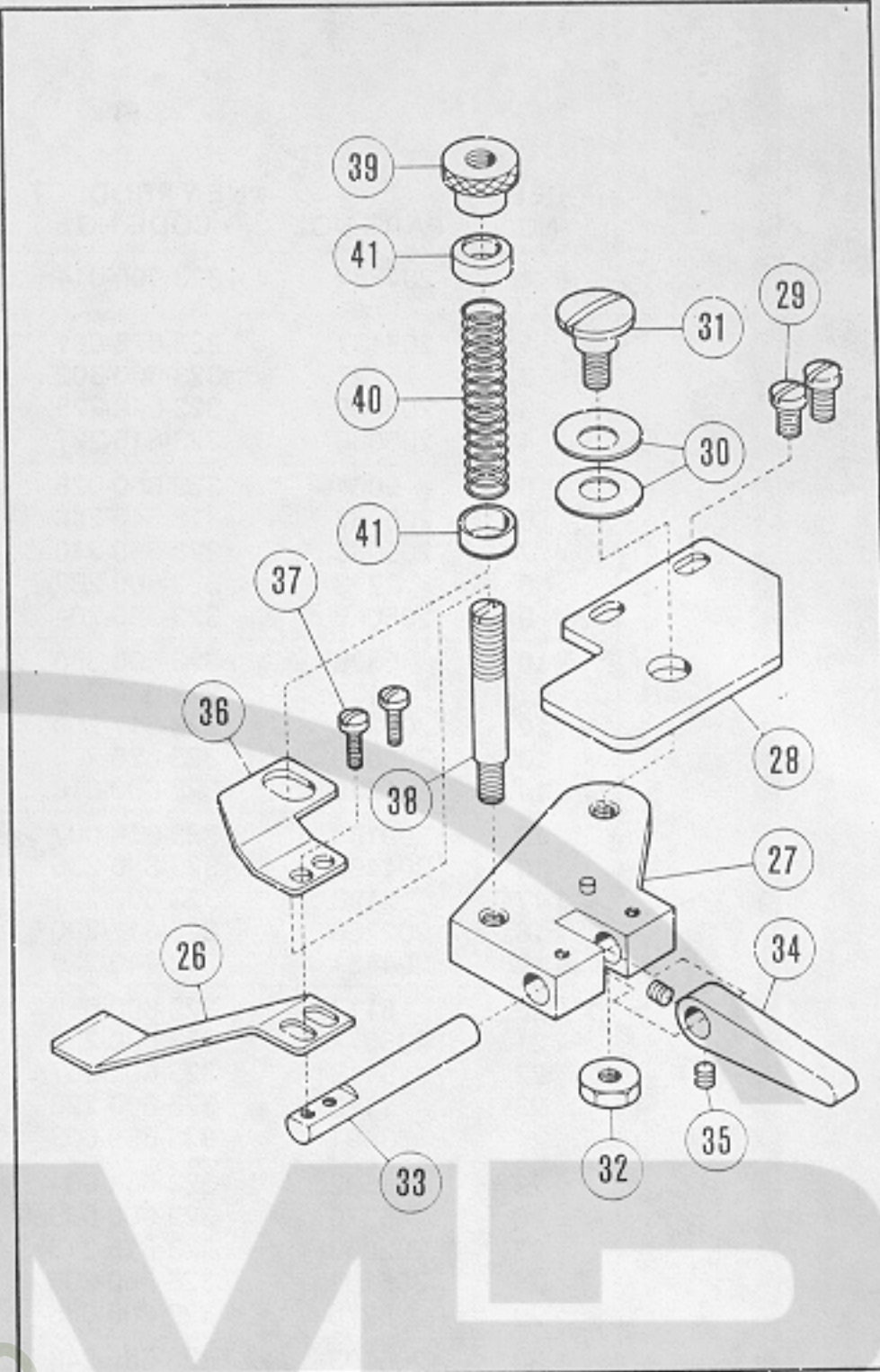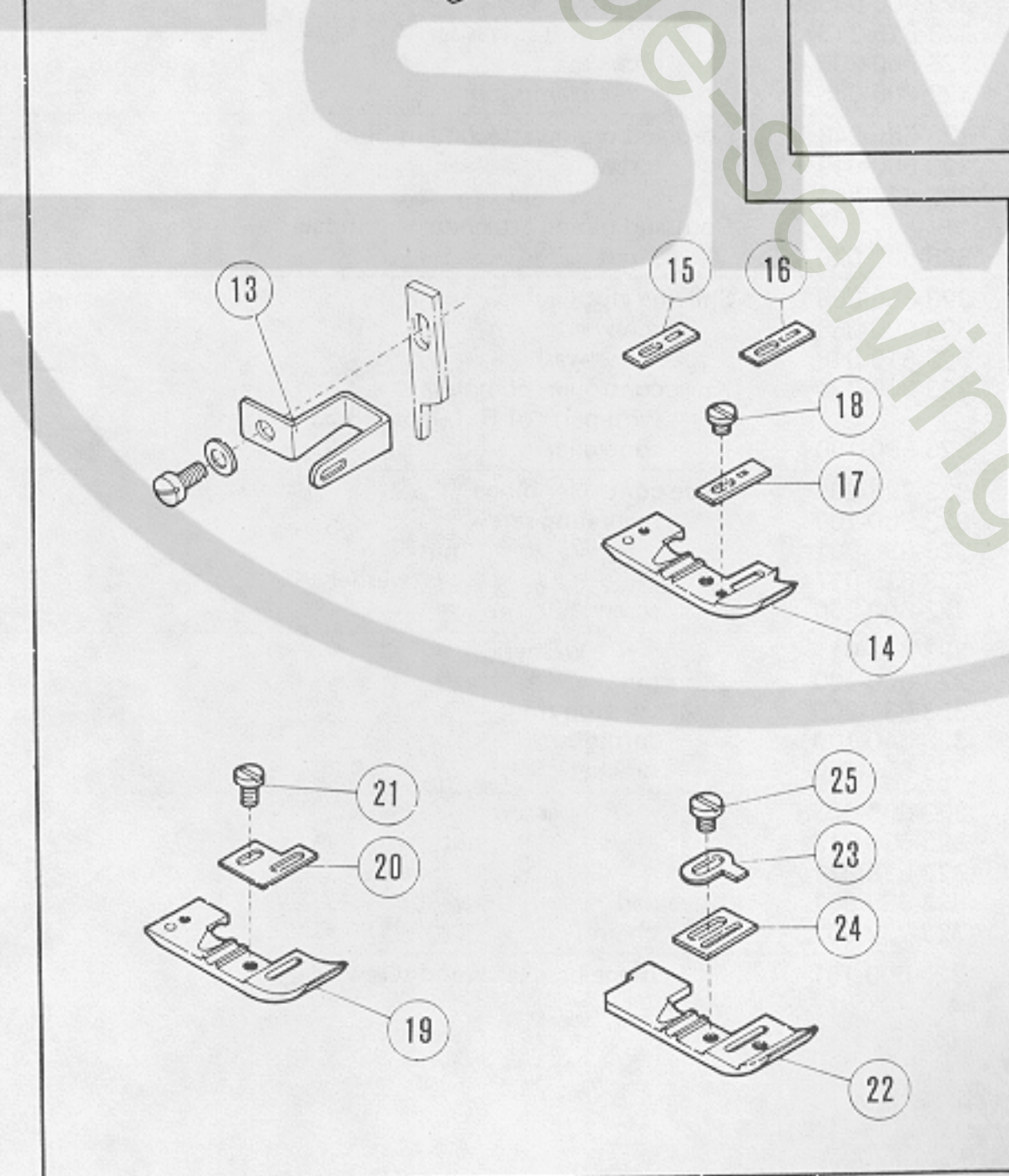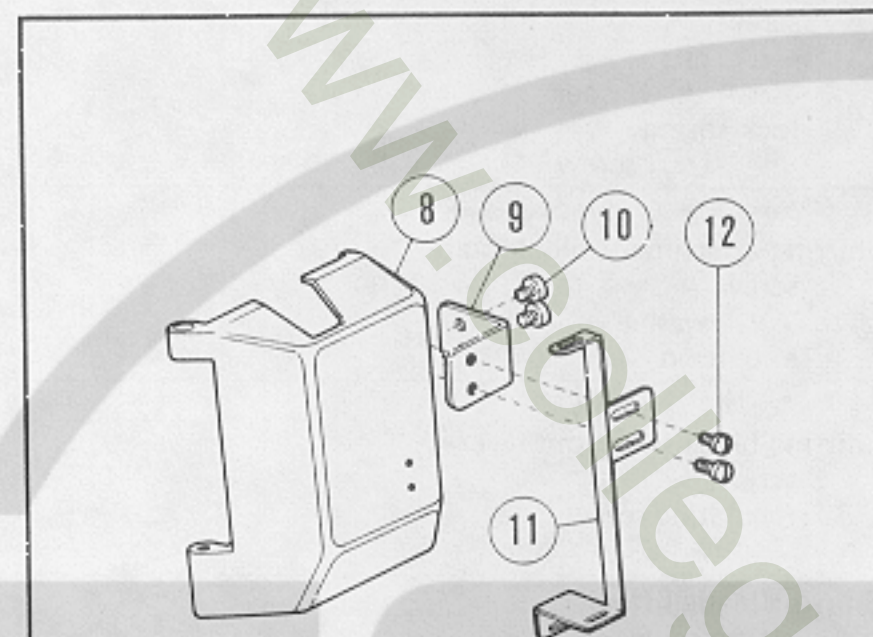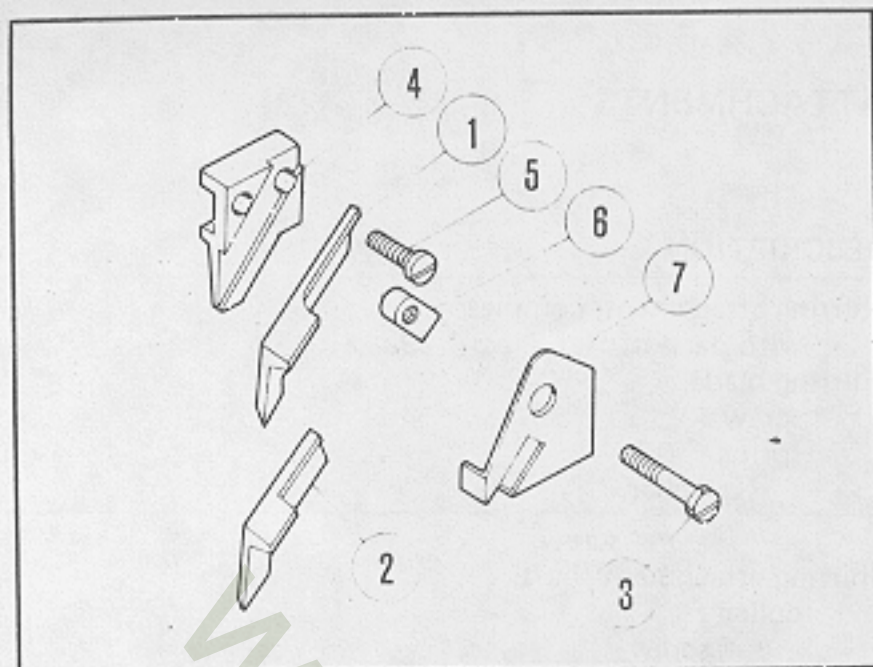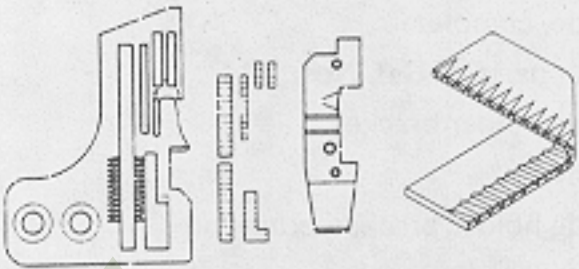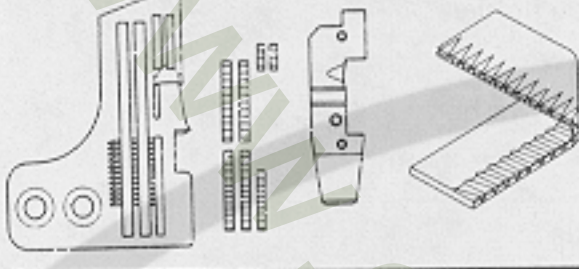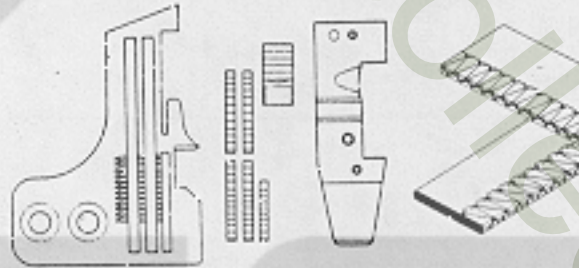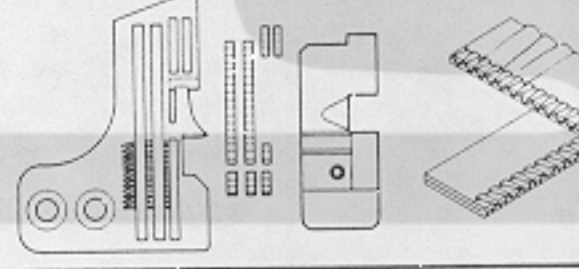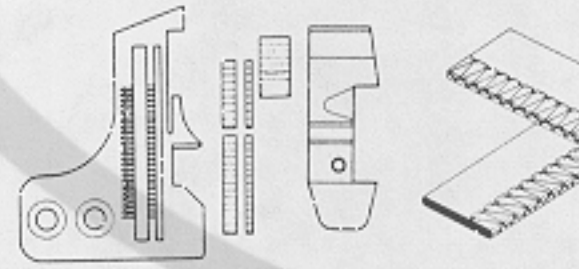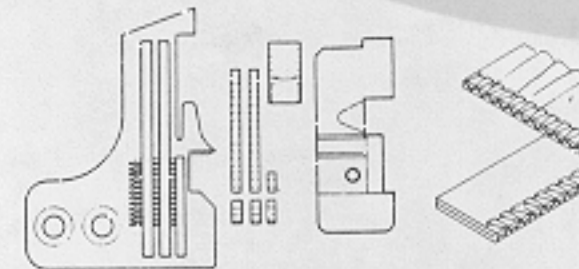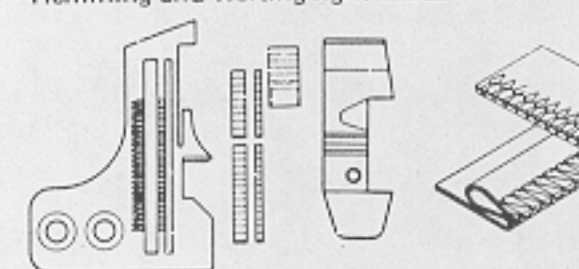
REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
			UPPER KNIFE (ANGLED)	
1	204152	323-870-217	Upper knife (angled)	1
2	204835	323-870-004	" " (angled) — carbide tipped	1
3	5371	323-600-108	screw	1
4	204830	323-683-015	clamp	1
5	5142	323-600-054	" screw	1
6	204155	323-683-213	gib	1
7	204156	323-560-225	guard	1
			TAPING AND ELASTIC BAND FOOT	
8	204950	323-510-036	Needle bar cover	1
9	205335	323-740-040	Tape support bracket	1
10	1234	323-600-006	screw	2
11	205318	323-756-004	Tape support	1
12	1234	323-600-006	screw	2
13	205319	323-850-032	Tape guide	1
14	205328	323-820-029	Elastic band foot	1
15	205330	323-850-034	guide — for 2.7mm band width only	1
16	205331	323-850-035	guide — for 4.4mm band width only	1
17	205332	323-850-036	guide — for 5.0mm band width only	1
18	5077	323-600-307	guide screw	1
19	205329	323-820-030	Taping foot — for 9.0mm band width only	1
20	205333	323-580-037	guide	1
21	5366	323-600-124	" screw	1
22	205314	323-820-028	Taping foot — for tape up to 10mm tape width	1
23	205315	323-850-033	guide	1
24	205316	323-740-039	" bracket	1
25	2921	323-600-026	" " screw	1
			SHIRRING ATTACHMENT — PLAIN TYPE	
	204898	323-900-053	Shirring attachment, complete with parts of Ref. Nos. 26-41	1
26	204966	323-875-003	blade	1
27	204886	323-750-010	block	1
28	204887	323-740-061	" bracket	1
29	5117	323-600-057	" " screw	2
30	204888	323-618-019	" " stud washer	2
31	5380	323-604-019	" " stud	1
32	5104	325-630-002	" " " nut	1
33	204889	323-540-032	shaft	1
34	204890	323-530-032	hand lift lever	1
35	1459	323-600-034	" " " screw	2
36	204891	323-850-056	blade guide	1
37	1175-2	323-600-002	" " screw	2
38	204892	323-607-003	block post	1
39	204893	323-630-034	" " thumb nut	1
40	204894	323-640-026	" " spring	1
41	204895	323-780-014	" " " cup	2
			OTHER OPTIONAL PARTS AVAILABLE	
42	204990	323-810-231	Right looper, for woolen yarn	1
43	204991	323-810-232	Left looper, for woolen yarn	1
44	204906	323-863-017	Presser foot chaining-off finger (2-needle machines for knits)	1
45	202281	323-758-004	Welt guide extension (especially designed for welting tricot fabrics)	1
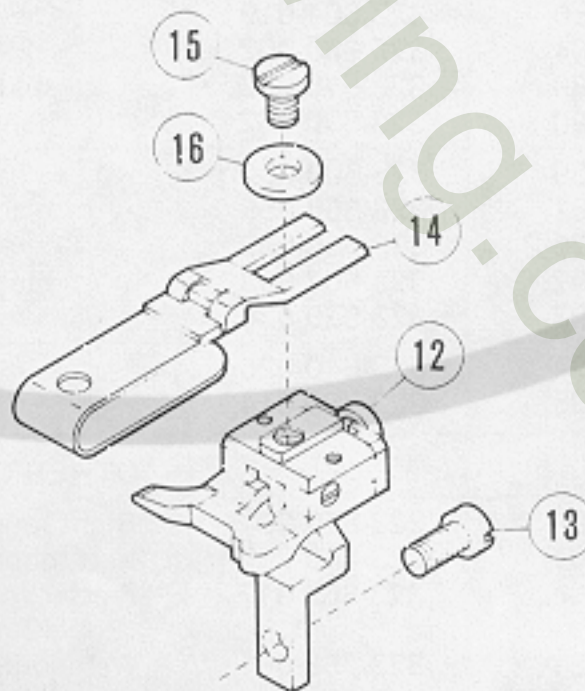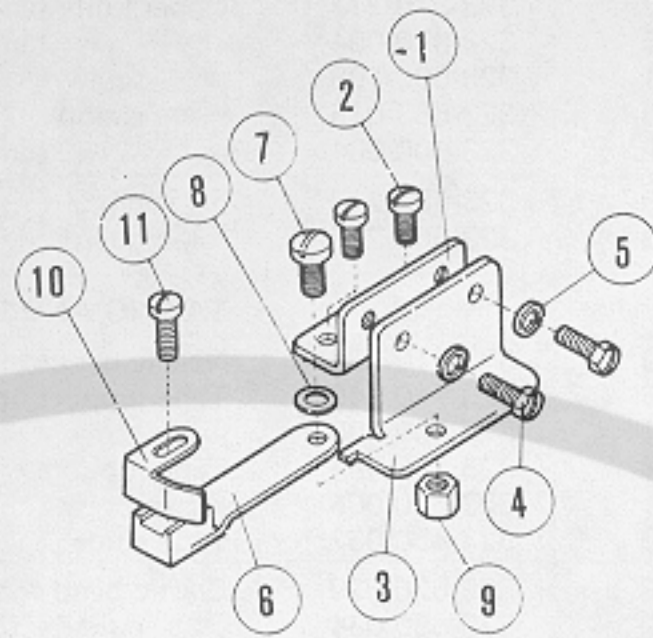
OPTIONAL PARTS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
	204896	323-850-028	Edge guide, complete with parts of Ref. Nos. 1-11	1
1	204451	323-740-229	Edge guide holder bracket	1
2	5117	323-600-057	screw	2
3	204452	323-740-228	Edge guide holder bracket extension	1
4	2193	323-600-271	screw	2
5	202286	323-617-200	" washer	2
6	201485	323-740-012	Edge guide holder	1
7	5184	323-600-079	. screw	1
8	201191	323-615-015	" washer	1
9	3044	323-630-001	" " nut	1
10	204667	323-850-022	Edge guide	1
11	1202	323-600-032	screw	1
12	204760A	323-505-016	Welt guide holder	1
13	1175-2	323-600-002	screw	1
14	201211A	323-400-001	Welt guide	1
15	2905	323-600-074	screw	1
16	201185	323-615-012	" washer	1

LIST OF ORGANIZATION PARTS
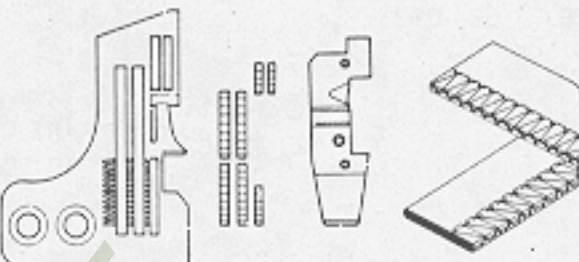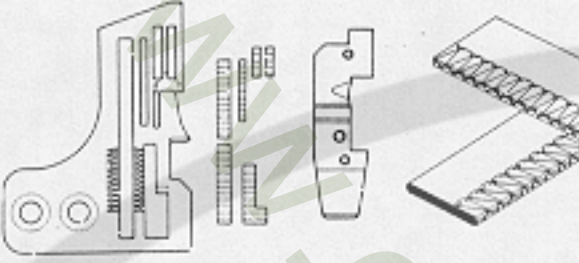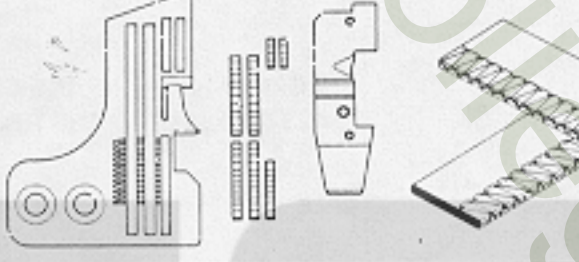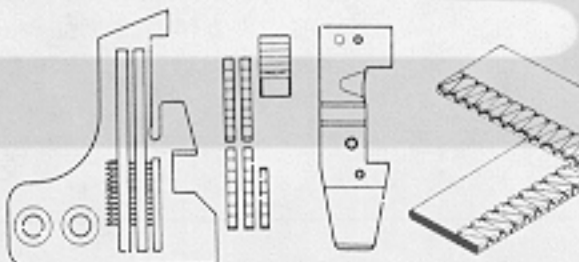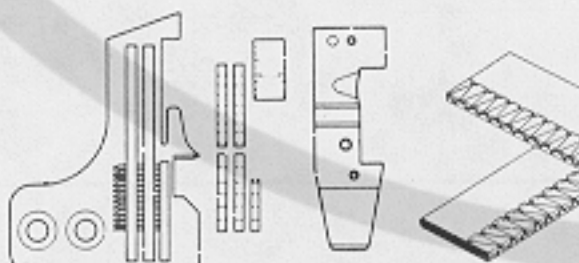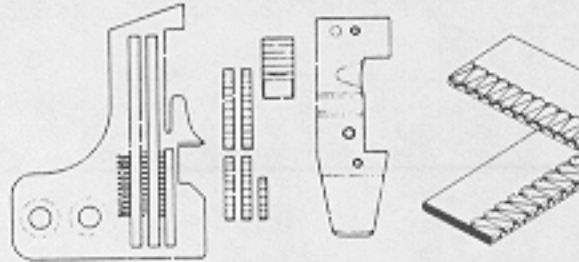
Machine model	Gauge (mm) (inch)	Needle plate	Feed dogs main	Feed dogs aux.	Feed dogs diff.	Right looper # = mark stamped		Lower knife
503-4-44 Serging trousers.	3mm 1/8"	205320 801-062	208336 830-134	208338 830-136	204907 830-060	204704 810-011	#3	202295 870-210
	4mm 5/32"	205321 801-063	"	"	"	"	"	"
	5mm 3/16"	205322 801-064	"	"	"	"	"	"
	6mm 1/4"	205323 801-065	"	"	"	"	"	"
503-4-48 Serging trousers.	3mm 1/8"	205324 801-066	208337 830-135		204690 830-057	"	"	201127 870-211
	4mm 5/32"	205325 801-067	"		"	"	"	"
	5mm 3/16"	205326 801-068	"		"	"	"	202295 870-210
	6mm 1/4"	205327 801-069	"		"	"	"	"
504-4-7 Plain seaming for underwear.	3mm 1/8"	202542E 801-026	204675A 830-096	204674 830-054	204676 830-033	204062 810-218	#2	201127 870-211
	4mm 5/32"	202546E 801-027	"	"	"	"	"	"
	5mm 3/16"	202596E 801-028	"	"	"	"	"	202295 870-210
	6mm 1/4"	202597E 801-029	"	"	"	"	"	"
504-4-17 Intermittent shirring.	3mm 1/8"	205239 801-360	204723A 830-108	204677 830-037	204724 830-036	204702 810-009	#4	201127 870-211
	4mm 5/32"	205240 801-361	"	"	"	"	"	"
	5mm 3/16"	205241 801-362	"	"	"	"	"	202295 870-210
	6mm 1/4"	205242 801-363	"	"	"	"	"	"
504-4-19 Seaming light knit goods.	2mm 5/64"	202616 801-038	204729A 830-103	204674 830-054	204730 830-059	204062 810-218	#2	"
	3mm 1/8"	202617 801-039	"	"	"	"	"	"
	4mm 5/32"	202618 801-222	"	"	"	"	"	"
	5mm 3/16"	204913 801-045	"	"	"	"	"	"
504-4-21 Intermittent shirring.	3mm 1/8"	202542E 801-026	204723A 830-108		204724 830-036	"	"	201127 870-211
	4mm 5/32"	202546E 801-027	"	"	"	"	"	"
	5mm 3/16"	202596E 801-028	"	"	"	"	"	202295 870-210
	6mm 1/4"	202597E 801-029	"	"	"	"	"	"
504-4-25 Hemming and welting light knits.	2mm 5/64"	202616 801-038	204729A 830-103	"	204730 830-059	"	"	"
	3mm 1/8"	202617 801-039	"	"	"	"	"	"
	4mm 5/32"	202618 801-222	"	"	"	"	"	"
	5mm 3/16"	204913 801-045	"	"	"	"	"	"

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Note: All product code numbers begin with prefix 323-.

| Presser foot | | | | Needle bar complete | Needle guard | | Needle factory set | Attachment on machine (available by option) |
body	chaining-off finger	fabric guard	uncurler		front	rear		
202799 820-286	201224B 863-007	201265B 854-200	205342A 560-041'	204623 591-003	204634 561-009	204635 561-010		
"	"	"	"	"	"	"	DCx1 #14 423-223-631	Edge guide (KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
"	"	"	"	"	"	"	DCx1 #14 423-223-631	Edge guide (KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
201230C 820-019	"	"	204668 560-020	"	"	"		
"	"	"	"	"	"	"	DCx1 #11 423-222-831	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
205135 820-013	– – –	– – –	"	"	"	"		
"	– – –	– – –	"	"	"	"	DCx27 #14 423-243-631	Shirring attachment (KS Chain Cutter)
205136 820-014	– – –	– – –	– – –	"	"	"		
"	– – –	– – –	"	"	"	"		
201473B 820-022	201224B 863-007	– – –	205342A 560-041	"	"	"		
"	"	– – –	"	"	"	"	DCx1 #9 423-222-631	(KS Chain Cutter) (BT Backtacker)
"	"	– – –	"	"	"	"		
"	"	– – –	"	"	"	"		
205135 820-013	– – –	– – –	"	"	"	"		
"	– – –	– – –	"	"	"	"	DCx1 #11 423-222-831	Shirring attachment (KS Chain Cutter)
205136 820-014	– – –	– – –	"	"	"	"		
"	– – –	– – –	"	"	"	"		
201152E 820-021	201155C 863-217	– – –	"	"	"	"		
"	"	– – –	"	"	"	"	DCx1 #9 423-222-631	Welt guide (KS Chain Cutter)
"	"	– – –	"	"	"	"		

LIST OF ORGANIZATION PARTS

Machine model	Gauge (mm) (inch)	Needle plate	Feed dogs main	aux.	diff.	Right looper # = mark stamped		Lower knife
504-4-43 Plain seaming on light knits.	3mm 1/8"	205235 801-340	204721A 830-097	204677 830-037	204722 830-035	204702 810-009	#4	201127 870-211
	4mm 5/32"	205236 801-341	"	"	"	"	"	"
	5mm 3/16"	205237 801-342	"	"	"	"	"	202295 870-210
	6mm 1/4"	205238 801-343	"	"	"	"	"	"
504-4-45 Plain seaming medium heavy knits.	3mm 1/8"	205231 801-344	204692A 830-093	"	204693 830-034	"	"	201127 870-211
	4mm 5/32"	205232 801-345	"	"	"	"	"	"
	5mm 3/16"	205233 801-346	"	"	"	"	"	202295 870-210
	6mm 1/4"	205234 801-347	"	"	"	"	"	"
504-4-47 Seaming woven and knits.	3mm 1/8"	205239 801-360	204675A 830-096	"	204676 830-033	"	"	201127 870-211
	4mm 5/32"	205240 801-361	"	"	"	"	"	"
	5mm 3/16"	205241 801-362	"	"	"	"	"	202295 870-210
	6mm 1/4"	205242 801-363	"	"	"	"	"	"
504-4-65 Seaming for jeans.	3mm 1/8"	202542E 801-026	204678A 830-094	204674 830-054	204679 830-056	204703 810-110	#6	201127 870-211
	4mm 5/32"	202546E 801-027	"	"	"	"	"	"
	5mm 3/16"	202596E 801-028	"	"	"	"	"	202295 870-210
	6mm 1/4"	202597E 801-029	"	"	"	"	"	"
	7mm 9/32"	204797 801-042	"	"	"	"	"	"
	8mm 5/16"	204731 801-041	"	"	"	"	"	"
504-4-66 Seaming bulky knitwear.	3mm 1/8"	202542E 801-026	"	"	204691 830-058	204702 810-009	#4	201127 870-211
	4mm 5/32"	202546E 801-027	"	"	"	"	"	"
	5mm 3/16"	202596E 801-028	"	"	"	"	"	202295 870-210
	6mm 1/4"	202597E 801-029	"	"	"	"	"	"
504-4-69 Seaming knits.	3mm 1/8"	202542E 801-026	204675A 830-096	"	204690 830-057	204062 810-218	#2	201127 870-211
	4mm 5/32"	202546E 801-027	"	"	"	"	"	"
	5mm 3/16"	202596E 801-028	"	"	"	"	"	202295 870-210
	6mm 1/4"	202597E 801-029	"	"	"	"	"	"
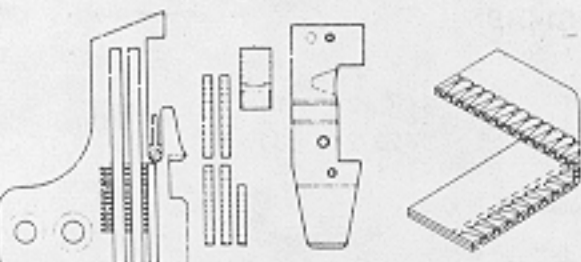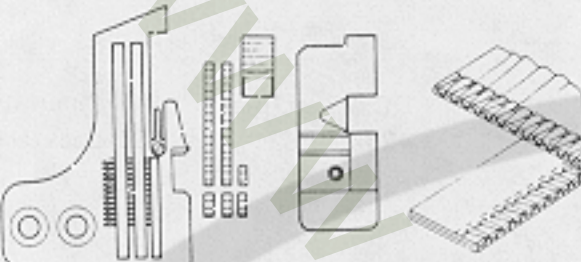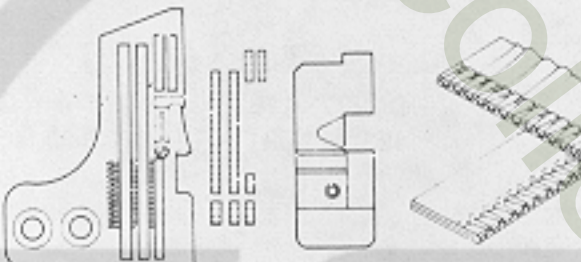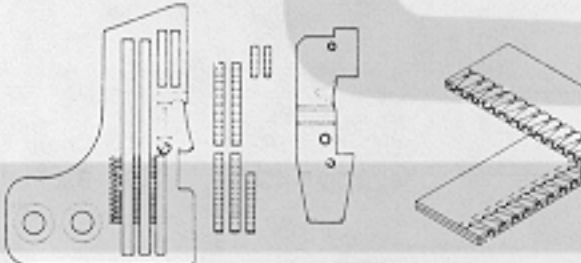
Note: All product code numbers begin with prefix 323-

Presser foot				Needle bar complete	Needle guard		Needle factory set	Attachment on machine (available by option)
body	chaining-off finger	fabric guard	uncurler		front	rear		
205252 820-285	201224B 863-007	201265B 854-200	205342A 560-041	204623 591-003	204634 561-009	204635 561-010		
"	"	"	"	"	"	"	DCx27 #14 423-243-631	(KS Chain Cutter)
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
202799 820-286	"	"	"	"	"	"		
"	"	"	"	"	"	"	DCx27 #14 423-243-631	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
205253 820-287	"	"	"	"	"	"		
"	"	"	"	"	"	"	DCx27 #16 423-244-031	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
201230C 820-019	"	"	204668 560-020	"	"	"		
"	"	"	"	"	"	"		
"	"	"	"	"	"	"	DCx1 #18 423-224-431	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
"	"	"	"	"	"	"	DCx1 #14 423-223-631	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		
"	"	"	"	"	"	"	DCx1 #11 423-222-831	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	"	"	"	"	"	"		

(1) MISCELLANEOUS COVERS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208317	323-800-057	Bed plate, complete	1
2	208422	323-663-024	gasket	1
3	4009-1	323-600-014	screw	8
4	204827	323-627-009	Cloth plate cushion (large)	1
5	208341	323-800-055	Bed cover plate (right)	1
6	208342	323-663-022	gasket	1
7	5117	323-600-057	screw	6
8	208347	323-510-078	Machine bed bottom cover	1
9	208348	323-655-011	oil filter	1
10	5117	323-600-057	screw	4
11	208430	323-800-061	Face plate, complete	1
12	4009-1	323-600-014	screw	3
13	208611	323-802-015	Cloth plate (narrow), complete	1
14	202576	323-615-201	hinge stud thrust washer	1
15	201139	323-680-001	" " " collar	1
16	5084	323-600-013	" " " " screw	2
17	204742	323-734-003	latch	1
18	204118	323-618-213	" spacer	1
19	5362	323-600-099	" screw	1
20	1435	323-600-069	" adjust screw	1
21	1459	323-600-034	" " " lock screw	1
22	204743	323-620-014	" pin	1
23	204744	323-740-019	" " bracket	1
24	1202	323-600-032	" " " screw	1
25	204745	323-640-007	spring	1
26	204746	323-620-015	push pin	1
27	204747	323-850-023	" " guide	1
28	5053	323-600-015	" " " screw	1
29	204748	323-640-008	" " spring	1
30	204749	323-627-005	rubber plug (small)	2
31	5441	323-600-140	stop screw	1
32	3044	323-630-001	" " nut	1
33	208612	323-802-016	Cloth plate (wide), complete	1
34	202576	323-615-201	hinge stud thrust washer	1
35	201139	323-680-001	" " " collar	1
36	5084	323-600-013	" " " " screw	2
37	204218	323-734-204	lock spring	1
38	1216	323-600-068	" " screw	2
39	200162A	323-615-015	" " " washer	1
40	5232	323-600-314	" " pin	1
41	208482	323-627-018	rubber plug (small)	1

Machine model	Gauge (mm) (inch)	Needle plate	Feed dogs main	aux.	diff.	Right looper # = mark stamped		Lower knife
512-4-61 Two needle seaming for woven fabrics.	2x2mm 5/64x5/64"	205255 801-047	204675A 830-096	204674 830-037	204676 830-033	204663 810-008	#7	201127 870-211
	2x3mm 5/64x1/8"	205255 801-047	"	"	"	"	"	202295 870-210
	2x4mm 5/64x5/32"	202554E 801-030	"	"	"	"	"	"
	2x5mm 5/64x3/16"	202499E 801-031	"	"	"	"	"	"
512-4-62 Two needle intermittent shirring.	2x2mm 5/64x5/64"	205255 801-047	204723A 830-108	"	204724 830-036	"	"	201127 870-211
	2x3mm 5/64x1/8"	205255 801-047	"	"	"	"	"	202295 870-210
	2x4mm 5/64x5/32"	202554E 801-030	"	"	"	"	"	"
	2x5mm 5/64x3/16"	202499E 801-031	"	"	"	"	"	"
512-4-63 Two needle intermittent shirring.	2x4mm 5/64x5/32"	205243 801-364	"	204677 830-037	"	"	"	"
	2x5mm 5/64x3/16"	205244 801-365	"	"	"	"	"	"
512-4-64 Two needle seaming on stretch fabrics.	2x4mm 5/64x5/32"	205243 801-364	204675A 830-096	"	204676 830-033	"	"	"
	2x5mm 5/64x3/16"	205244 801-365	"	"	"	"	"	"

REFERENCE TABLE FOR 'NEW -4' VS 'MARK/IV' MACHINE MODELS

New -4 machine models	Mark/IV machine models	New -4 machine models	Mark/IV machine models
503-4-44	503/IV-44	512-4-61	514/IV-11
503-4-48	503/IV-48	512-4-62	514/IV-22
504-4-7	504/IV-7	512-4-63	514/IV-23
504-4-17	504/IV-17	512-4-64	514/IV-41
504-4-19	504/IV-19	512-4-53	– – –
504-4-21	504/IV-21	512-4-57	– – –
504-4-25	504/IV-25	512-4-73	514/IV-56
504-4-43	504/IV-43	514-4-20	514/IV-20
504-4-45	504/IV-45	514-4-61	514/IV-S-15
504-4-47	504/IV-47	514-4-62	514/IV-S-18
504-4-65	504/IV-S-10	514-4-64	514/IV-S-19
504-4-66	504/IV-S-16	514-4-67	514/IV-S-11
504-4-69	504/IV-S-17	514-4-73	– – –
		514-4-68	514/IV-S-14

| Presser foot | | | | Needle bar complete | Needle guard | | Needle factory set | Attachment on machine (available by option) |
body	chaining-off finger	fabric guard	uncurler		front	rear		
201230C 820-019	201396B 863-215	201265B 854-200	204668 560-020	204624 591-004	204659 561-011	204660 561-012		
"	"	"	"	"	"	"	DCx1 #14 423-223-631	
"	201310A 863-201	"	"	"	"	"		
"	"	"	"	"	"	"		
205136 820-014	— — —	— — —	205342A 560-041	"	"	"		
"	— — —	— — —	"	"	"	"	DCx1 #14 423-223-631	
"	— — —	— — —	"	"	"	"		
"	— — —	— — —	"	"	"	"		
"	— — —	— — —	"	"	"	"	DCx27 #14 423-243-631	Shirring attachment
"	— — —	— — —	"	"	"	"		
205253 820-287	201310A 863-201	201265B 854-200	205342A 560-041	"	"	"	DCx27 #14 423-243-631	
"	"	"	"	"	"	"		
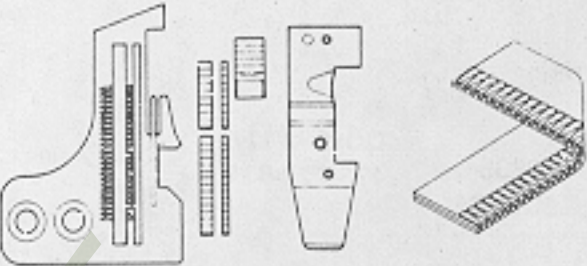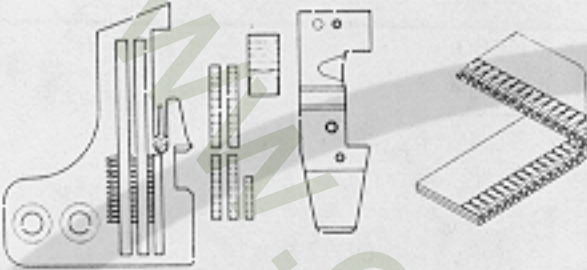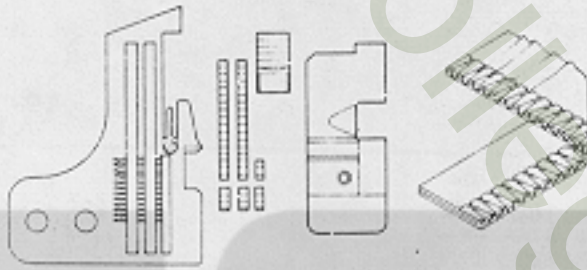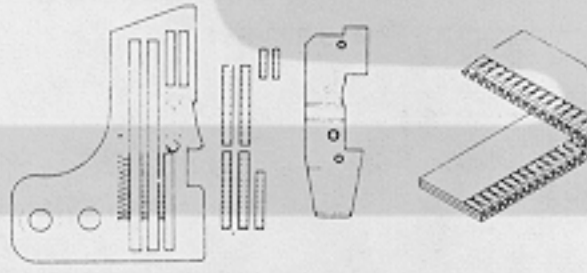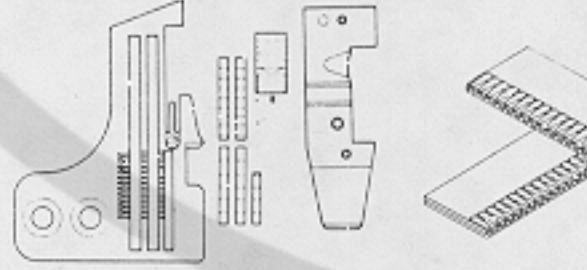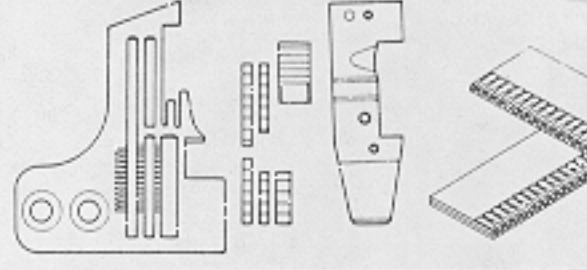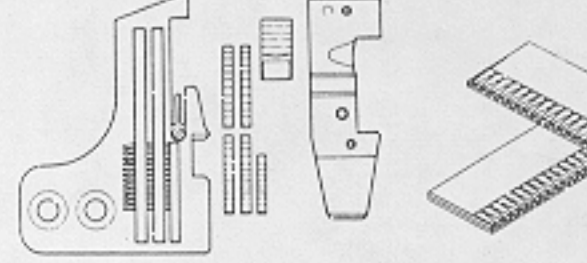
LIST OF ORGANIZATION PARTS

Machine model	Gauge (mm) (inch)	Needle plate	Feed dogs			Right looper # = mark stamped		Lower knife
			main	aux.	diff.			
512-4-53 Two needle seaming for woven fabrics.	2x3mm 5/64x1/8"	208322 801-128	208039 830-086	204674 830-037	208041 830-088	204702 810-009	#4	201127 870-211
	2x4mm 5/64x5/32"	208323 801-129	"	"	"	"	"	"
	2x5mm 5/64x3/16"	208324 801-130	"	"	"	"	"	202295 870-210
	3x3mm 1/8x1/8"	208033 801-086	"	"	"	"	"	201127 870-211
	3x4mm 1/8x5/32"	208034 801-087	"	"	"	"	"	202295 870-210
	3x5mm 1/8x3/16"	208035 801-088	"	"	"	"	"	"
512-4-57 Two needle seaming on stretch fabrics.	2x3mm 5/64x1/8"	208325 801-131	"	208095 830-092	"	204663 810-008	#7	201127 870-211
	2x4mm 5/64x5/32"	208326 801-132	"	"	"	"	"	"
	2x5mm 5/64x3/16"	208327 801-133	"	"	"	"	"	202295 870-210
	3x3mm 1/8x1/8"	208036 801-089	"	"	"	"	"	201127 870-211
	3x4mm 1/8x5/32"	208037 801-090	"	"	"	"	"	202295 870-210
	3x5mm 1/8x3/16"	208038 801-091	"	"	"	"	"	"
512-4-73 Two needle seaming on bulky knits.	2.5x2.5mm 3/32x3/32"	208030 801-083	208040 830-087	204674 830-037	208044 830-091	"	"	201127 870-211
	2.5x4mm 3/32x5/32"	208031 801-084	"	"	"	"	"	202295 870-210
	2.5x5mm 3/32x3/16"	208032 801-085	"	"	"	"	"	"
	3x3mm 1/8x1/8"	208033 801-086	"	"	"	"	"	201127 870-211
	3x4mm 1/8x5/32"	208034 801-087	"	"	"	"	"	202295 870-210
	3x5mm 1/8x3/16"	208035 801-088	"	"	"	"	"	"

Note: All product code numbers begin with prefix 323-.

| Presser foot | | | | Needle bar complete | Needle guard | | Needle factory set | Attachment on machine (available by option) |
body	chaining-off finger	fabric guard	uncurler		front	rear		
201230C 820-019	201396B 863-215	201265B 854-200	204668 560-020	204624 591-004	204659 561-011	204660 561-012		
"	201310A 863-201	"	"	"	"	"		
"	"	"	"	"	"	"	DCx1 #11 423-222-831	(BT Backtacker)
"	208049 863-015	"	"	208047 591-009	208053 561-023	208054 561-024		
"	208050 863-016	"	"	"	"	"		
"	"	"	"	"	"	"		
202799 820-286	201396B 863-215	"	205342A 560-041	204624 591-004	204659 561-011	204660 561-012		
"	201310A 863-201	"	"	"	"	"		
"	"	"	"	"	"	"	DCx27 #14 423-243-631	
205253 320-287	208049 863-015	"	"	208047 591-009	208053 561-023	"		
"	208050 863-016	"	"	"	"	"		
"	"	"	"	"	"	"		
201230C 820-019	208049 863-015	"	204668 560-020	208045 591-008	208051 561-021	208052 561-022		
"	208050 863-016	"	"	"	"	"		
"	"	"	"	"	"	"	DCx1 #14 423-223-631	
"	208049 863-015	"	"	208047 591-009	208053 561-023	208054 561-024		
"	208050 863-016	"	"	"	"	"		
"	"	"	"	"	"	"		

Machine model	Gauge (mm) (inch)	Needle plate	Feed dogs main	aux.	diff.	Right looper # = mark stamped		Lower knife
514-4-20 Two needle seaming on light knits.	1.5x2mm 1/16x5/64"	204910 801-043	204729A 830-103	204674 830-054	204730 830-059	204963 810-227	#8	202295 870-210
	1.5x3mm 1/16x1/8"	204911 801-044	"	"	"	"	"	"
	2x2mm 5/64x5/64"	205256 801-048	"	"	"	"	"	"
	2x3mm 5/64x1/8"	205257 801-049	"	"	"	"	"	"
514-4-61 Two needle seaming knits.	2x2mm 5/64x5/64"	205255 801-047	204675A 820-096	"	204676 830-033	"	"	201127 870-211
	2x3mm 5/64x1/8"	205255 801-047	"	"	"	"	"	202295 870-210
	2x4mm 5/64x5/32"	202554E 801-030	"	"	"	"	"	"
514-4-62 Two needle intermittent shirring.	2x2mm 5/64x5/64"	205255 801-047	204723A 830-108	"	204724 830-036	204964 810-228	#9	201127 870-211
	2x3mm 5/64x1/8"	205255 801-047	"	"	"	"	"	202295 870-210
	2x4mm 5/64x5/32"	202554E 801-030	"	"	"	"	"	"
514-4-64 Two needle seaming.	2x4mm 5/64x5/32"	205243 801-364	204675A 830-096	204677 830-037	204676 830-033	"	"	
514-4-67 Two needle seaming for bulky knitwear.	2x2mm 5/64x5/64"	205255 801-047	204678A 830-094	204674 830-054	204691 830-058	"	"	201127 870-211
	2x3mm 5/64x1/8"	205255 801-047	"	"	"	"	"	202295 870-210
	2x4mm 5/64x5/32"	202554E 801-030	"	"	"	"	"	"
514-4-73 Two needle seaming for bulky knitwear.	2.5x2.5mm 3/32x3/32"	208030 801-083	208040 830-087	"	208044 830-091	"	"	201127 870-211
	2.5x4mm 3/32x5/32"	208031 801-084	"	"	"	"	"	202295 870-210
514-4-68 Two needle seaming for knitwear.	2x2mm 5/64x5/64"	205255 801-047	204675A 830-096	"	204690 830-058	204963 810-227	#8	201127 870-211
	2x3mm 5/64x1/8"	205255 801-047	"	"	"	"	"	202295 870-210
	2x4mm 5/64x5/32"	202554E 801-030	"	"	"	"	"	"

Note: All product code numbers begin with prefix 323-.

COMMON PARTS: 204072 (323-810-216) — Left looper
201121A (323-870-214) — Upper knife

| Presser foot | | | | Needle bar complete | Needle guard | | Needle factory set | Attachment on machine (available by option) |
body	chaining-off finger	fabric guard	uncurler		front	rear		
201230C 820-019	201396B 863-215	201265B 854-200	204668 560-020	204872 591-007	204659 561-011	204660 561-012	DCx3 #9	
"	"	"	"	"	"	"		(KS Chain Cutter) (BT Backtacker)
"	"	"	"	204624 591-004	"	"	DCx1 #9 423-222-631	
"	"	"	"	"	"	"		
"	"	"	"	"	"	"	DCx1 #9 423-222-631	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	201310A 863-201	"	"	"	"	"		
205136 820-014	---	---	205342A 560-041	"	"	"	DCx1 #14 423-223-631	Shirring attachment (KS Chain Cutter)
"	---	---	"	"	"	"		
"	---	---	"	"	"	"		
205253 820-287	201310A 863-201	201265B 854-200	"	"	"	"	DCx1 #14 423-223-631	(KS Chain Cutter)
201230C 820-019	201396B 863-215	"	204668 560-020	"	"	"	DCx1 #14 423-223-631	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	201310A 863-201	"	"	"	"	"		
"	208049 863-015	"	"	208045 591-008	208051 561-021	208052 561-022	DCx1 #14 423-223-631	(KS Chain Cutter) (BT Backtacker)
"	208050 863-016	"	"	"	"	"		
"	201396B 863-215	"	"	204624 591-004	204659 561-011	204660 561-012	DCx1 #11 423-222-831	(KS Chain Cutter) (BT Backtacker)
"	"	"	"	"	"	"		
"	201310A 863-201	"	"	"	"	"		

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323-600-014	4009-1	7	10
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202849	323-800-215	15	8	204183	323-540-237	29	7	204664	323-530-010	19	18
202849	323-800-215	17	46	204184	323-540-236	29	9	204668	323-560-020	47	
202849	323-800-215	19	32	204185	323-632-201	21	33	204668	323-560-020	49	
202868	323-618-209	21	53	204185	323-632-201	29	15	204668	323-560-020	51	
202875	323-615-216	17	51	204186	323-570-203	29	13	204668	323-560-020	53	
202903	323-627-208	31	5	204187	323-570-204	29	11	204668	323-560-020	55	
204003	323-882-201	3	14	204188	323-902-020	29	21	204674	323-830-054	46	
204006	323-620-242	3	19	204189	323-683-214	29	24	204674	323-830-054	48	
204010	323-671-200	9	4	204192	323-663-211	29	23	204674	323-830-054	50	
204014	323-676-243	9	11	204193	323-639-232	31	1	204674	323-830-054	52	
204016	323-676-232	9	13	204194	323-639-233	31	6	204674	323-830-054	54	
204018	323-615-217	9	17	204196	323-736-200	31	12	204675A	323-830-096	46	
204019A	323-646-001	9	18	204198	323-568-202	31	15	204675A	323-830-096	48	
204020A	323-671-002	9	19	204218	323-734-204	5	37	204675A	323-830-096	54	
204021	323-800-224	9	20	204223	323-510-248	7	9	204676	323-830-033	46	
204022	323-626-202	9	21	204251	323-663-207	3	5	204676	323-830-033	48	
204023	323-615-221	9	24	204259	323-639-012	33	17	204676	323-830-033	54	
204025	323-546-203	9	27	204270	323-653-006	33	12	204677	323-830-037	46	
204026	323-546-204	9	30	204270	323-653-006	33	24	204677	323-830-037	48	
204029	323-535-205	11	1	204274	323-653-209	17	28	204677	323-830-037	50	
204048A	323-576-213	17	4	204293	323-616-200	19	21	204677	323-830-037	54	
204052A	323-626-201	17	15	204311	323-618-210	19	12	204678A	323-830-094	48	
204052A	323-626-201	19	17	204319	323-663-205	9	10	204678A	323-830-094	54	
204052A	323-626-201	21	36	204354	323-620-251	21	11	204679	323-830-056	48	
204054	323-676-235	19	15	204439A	323-615-033	23	33	204681	323-646-003	7	3
204054	323-676-235	23	4	204450	323-692-256	7	11	204690	323-830-057	46	
204055B	323-576-018	17	18	204451	323-740-229	41	19	204690	323-830-057	48	
204059	323-676-248	17	29	204451	323-740-229	45	1	204690	323-830-057	54	
204060	323-515-202	17	30	204452	323-740-228	45	3	204691	323-830-058	48	
204062	323-810-218	46		204465	323-653-007	33	25	204691	323-830-058	54	
204062	323-810-218	48		204495	323-800-235	41	16	204693	323-830-034	48	
204069A	323-540-228	17	10	204520	323-615-233	9	7	204702	323-810-009	46	
204069A	323-540-228	19	11	204585	323-615-021	41	51	204702	323-810-009	48	
204072	323-810-216	19	22	204588	323-686-002	23	11	204702	323-810-009	52	

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204704	323-810-011	46	
204721A	323-830-097	48	
204722	323-830-035	48	
204723A	323-830-108	46	
204723A	323-830-108	50	
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204731	323-801-041	48	
204734	323-633-002	9	5
204737	323-515-002	9	8
204742	323-734-003	5	17
204743	323-620-014	5	22
204744	323-740-019	5	23
204745	323-640-007	5	25
204746	323-620-015	5	26
204747	323-850-023	5	27
204748	323-640-008	5	29
204749	323-627-005	5	30
204750	323-740-017	15	17
204751	323-540-016	23	1
204752	323-540-017	21	34
204754	323-680-007	21	37
204755	323-530-011	21	44
204756	323-640-006	21	54
204757	323-600-102	21	55
204758	323-685-012	25	19
204759	323-683-014	25	30
204760A	323-505-016	45	12
204762	323-740-037	11	27
204786	323-866-005	19	33
204787	323-576-006	19	7
204788	323-576-007	17	5
204788	323-576-007	19	8
204789	323-618-010	19	9
204794A	323-655-007	3	21
204796	323-620-016	25	18
204797	323-801-042	48	
204806	323-615-029	31	21
204810	323-750-003	23	37
204827	323-627-009	5	4
204828	323-627-010	3	16
204830	323-683-015	43	4
204835	323-870-004	43	2
204848A	323-560-051	7	1
204853	323-530-017	19	19
204854	323-676-029	17	
204857A	323-510-091	7	43
204860	323-658-004	33	
204861	323-658-003	33	13
204862	323-510-035	33	14
204863	323-620-025	33	15
204865A	323-510-088	7	48
204867	323-646-005	7	51
204868	323-646-004	7	45
204869	323-600-107	21	56
204870	323-630-017	21	52
204871	323-628-002	7	42
204872	323-591-007	55	
204882	323-900-014	41	
204883	323-530-018	21	46
204884	323-561-017	11	25
204886	323-750-010	43	27
204887	323-740-061	43	28

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204888	323-618-019	43	30
204889	323-540-032	43	33
204890	323-530-032	43	34
204891	323-850-056	43	36
204892	323-607-003	43	38
204893	323-630-034	43	39
204894	323-640-026	43	40
204895	323-780-014	43	41
204896	323-850-028	45	
204898	323-900-053	43	
204902	323-866-013	17	49
204905	323-851-018	17	52
204906	323-863-017	43	44
204907	323-830-060	46	
204910	323-801-043	54	
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204913	323-801-045	46	
204921	323-639-239	33	19
204921	323-639-239	33	8
204929	323-710-003	27	47
204930	323-676-039	27	48
204950	323-510-036	43	8
204963	323-810-227	54	
204964	323-810-228	54	
204966	323-875-003	43	26
204990	323-810-231	43	42
204991	323-810-232	43	43
205065	323-640-225	41	3
205066	323-615-227	41	4
205067	323-540-246	41	6
205068	323-680-210	41	7
205069	323-750-204	41	9
205070	323-625-203	41	13
205072	323-530-232	41	21
205091	323-850-258	41	35
205103	323-685-243	41	30
205104	323-750-205	41	28
205135	323-820-013	47	
205136	323-820-014	47	
205136	323-820-014	51	
205136	323-820-014	55	
205137	323-875-001	41	1
205216	323-945-009	39	21
205217	323-600-117	39	22
205231	323-801-344	48	
205232	323-801-345	48	
205233	323-801-346	48	
205234	323-801-347	48	
205235	323-801-340	48	
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205239	323-801-360	46	
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205240	323-801-361	46	
205240	323-801-361	48	
205241	323-801-362	46	
205241	323-801-362	48	
205242	323-801-363	46	
205242	323-801-363	48	
205243	323-801-354	50	
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205244	323-801-365	50	
205252	323-820-285	49	
205253	323-820-287	49	
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205253	323-820-287	53	
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205255	323-801-047	50	
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205257	323-801-049	54	
205314	323-820-028	43	22
205315	323-850-033	43	23
205316	323-740-039	43	24
205318	323-756-004	43	11
205319	323-850-032	43	13
205320	323-801-062	46	
205321	323-801-063	46	
205322	323-801-064	46	
205323	323-801-065	46	
205324	323-801-066	46	
205325	323-801-067	46	
205326	323-801-068	46	
205327	323-801-069	46	
205328	323-820-029	43	14
205329	323-820-030	43	19
205330	323-850-034	43	15
205331	323-850-035	43	16
205332	323-850-036	43	17
205333	323-580-037	43	20
205335	323-740-040	43	9
205342A	323-560-041	47	
205342A	323-560-041	49	
205342A	323-560-041	51	
205342A	323-560-041	53	
205342A	323-560-041	55	
205466	323-945-001	35	1
205467	323-646-006	35	5
205468	323-774-002	35	9
205469	323-774-003	35	10
205470	323-740-062	35	7
205473	323-945-014	35	2
205495	323-620-040	11	3
205495	323-620-040	21	2
206336	325-630-004	35	3
206457	323-656-003	7	18
206550		7	19
208001	323-510-043	7	20
208003	323-510-046	7	21
208005	323-510-048	7	
208008	323-728-008	7	23
208009	323-620-026	7	24
208010	323-640-015	7	27
208023A	323-510-086	7	5
208030	323-801-083	52	
208030	323-801-083	54	
208031	323-801-084	52	
208031	323-801-084	54	
208032	323-801-085	52	
208033	323-801-086	52	
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208035	323-801-088	52	
208035	323-801-088		
208036	323-801-089	52	
208037	323-801-090	52	
208038	323-801-091	52	
208039	323-830-086	52	
208040	323-830-087	52	
208040	323-830-087	54	
208041	323-830-088	52	
208044	323-830-091	52	
208044	323-830-091	54	
208045	323-591-008	53	
208045	323-591-008	55	
208047	323-591-009	53	
208049	323-863-015	53	
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208050	323-863-016	53		208346	323-525-013	19	1	208621	323-780-012	13	28
208050	323-863-016	55		208347	323-510-078	5	8	204667	323-850-022	45	10
208051	323-561-021	53		208348	323-655-011	5	9	204692A	323-830-093	47	
208051	323-561-021	55		208400	323-851-025	11	15				
208052	323-561-022	53		208409	323-618-018	21	15				
208052	323-561-022	55		208410	323-716-013	21	19				
208053	323-561-023	53		208411	323-900-050	21					
208054	323-561-024	53		208416	323-900-051	21					
208058	323-510-053	7		208420	323-535-004	21	29				
208095	323-830-092	52		208421	323-640-021	21	31				
208096	323-850-044	25	25	208422	323-663-024	5	2				
208102	323-851-022	17	27	208424	323-576-017	13	1				
208107A	323-850-050	23	41	208425	323-730-012	13	4				
208108	323-850-049	23	39	208427	323-683-018	13	7				
208109	323-560-046	23	44	208429	323-676-049	17	17				
208110	323-800-053	23	45	208430	323-800-061	5	11				
208168	323-663-019	23	42	208434	323-560-047	3	12				
208169A	323-663-021	3	13	208440	323-692-034	3	20				
208173	323-780-009	3	15	208441	323-692-035	3					
208173	323-780-009	17	32	208442	323-692-036	3					
208207	323-787-005	21	10	208444	323-692-037	3					
208208	323-800-063	21	12	208445	323-866-016	17	47				
208209	323-800-064	21	13	208446	323-639-034	33	4				
208247	323-540-027	11	8	208447	323-630-033	15	1				
208248	323-676-042	11	9	208447	323-630-033	17	39				
208249	323-676-043	11	11	208447	323-630-033	19	25				
208250	323-626-002	11	10	208448	323-676-047	15	2				
208258	323-620-041	17	22	208448	323-676-047	17	40				
208260	323-713-003	31	16	208448	323-676-047	19	26				
208271	323-680-011	9	25	208449	323-650-001	15	6				
208272	323-632-002	9	26	208449	323-650-001	17	44				
208273	323-716-011	23	18	208449	323-650-001	19	30				
208282	323-580-084	21	7	208450	323-780-010	15	4				
208284	323-575-019	23	7	208450	323-780-010	17	42				
208285	323-620-035	23	12	208450	323-780-010	19	28				
208286	323-615-036	23	14	208479	323-850-055	27	32				
208289	323-800-056	3	22	208481	323-850-057	7	14				
208290	323-663-020	3	23	208482	323-627-018	5	41				
208293	323-677-046	19	16	208482	323-627-018	7	16				
208294	323-676-045	21	35	208487	323-800-065	33	6				
208296	323-800-058	17	24	208488	323-900-045	15					
208299	323-510-079	7	13	208489	323-900-046	15					
208299	323-676-048	17	14	208489	323-900-046	19	24				
208307	323-851-024	15	10	208490	323-900-047	17	38				
208308	323-658-005	33	1	208491	323-900-048	15	9				
208313	323-530-029	27	25	208525	323-685-022	27	8				
208314	323-620-036	27	27	208526	323-502-011	27	1				
208315	323-640-024	27	28	208534	323-540-031	27	20				
208316	323-604-018	27	49	208535	323-676-050	27	21				
208317	323-800-057	5	1	208537	323-592-001	27	31				
208318	323-663-023	31	17	208540	323-640-023	27	33				
208319	323-530-028	17	26	208547	323-716-014	27	14				
208320	323-780-011	9	32	208549	323-620-042	27	4				
208322	323-801-128	52		208560	323-510-090	15	22				
208323	323-801-129	52		208561	323-653-017	15	24				
208324	323-801-130	52		208562	323-653-018	15	25				
208325	323-801-131	52		208563	323-800-062	15	26				
208326	323-801-132	52		208568	323-510-089	15					
208327	323-801-133	52		208592	323-780-013	17	35				
208330	323-625-002	21	17	208597	323-676-052	17	34				
208333	323-576-020	21		208598	323-530-031	27	35				
208336	323-830-134	46		208599	323-676-053	27	37				
208337	323-830-135	46		208602	323-500-019	3	4				
208338	323-830-136	46		208603	323-500-020	3	8				
208339	323-627-019	7	17	208604	323-560-052	7	35				
208340	323-891-004	7	53	208611	323-802-015	5	13				
208341	323-802-055	5	5	208612	323-802-016	5	33				
208342	323-663-022	5	6	208615	323-600-142	27	34				
208343	323-540-029	9	1	208616	323-560-053	13	24				
208346	323-525-013	17	1	208617	323-653-019	13	26				

(2) MISCELLANEOUS COVERS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204848A	323-560-051	Cloth plate fabric guard	1
2	4009-1	323-600-014	screw	2
3	204681	323-646-003	spacer	1
4	2922	323-600-229	" screw	1
5	208023A	323-510-086	Needle bar cover	1
6	202653	323-620-240	hinge pin	2
7	202689	323-641-201	lock spring	1
8	1234	323-600-006	" " screw	2
9	204223	323-510-248	" " latch	1
10	4009-1	323-600-014	" " " screw	1
11	204450	323-692-256	name plate	1
12	192107-1	325-627-002	cushion rubber	1
13	208299	323-510-079	Top cover	1
14	208481	323-663-030	gasket	1
15	5152	323-600-061	screw	4
16	208482	323-627-018	cushion	2
17	208339	323-627-019	plug	1
18	206457	323-656-003	Oil splash sight window (also used for oiling)	1
19	206550	323-632-004	'o' ring	1
20	208001	323-510-043	Front cover (right)	1
21	208003	323-510-046	Front cover (left) (for 1-needle machines and 2-needle 1.5mm & 2.0mm needle gauge machines)	1
	208005	323-510-048	Front cover (left) (for 504-4-65 only)	1
	208058	323-510-053	Front cover (left) (for 2-needle 2.5mm & 3.0mm needle gauge machines)	1
22	1189	323-600-301	screw	2
23	208008	323-728-008	hinge	1
24	208009	323-620-026	" pin	1
25	200555	323-634-004	" " retaining ring	1
26	5146	323-600-264	" screw	1
27	208010	323-640-015	" spring	1
28	1216	323-600-068	" screw (small)	3
29	137906	323-615-018	" " washer	3
30	5094	323-600-072	" screw (long)	1
31	5137	323-630-202	" " nut	1
32	204646	323-800-026	spacer	1
33	204650A	323-510-030	Oil cooler cover	1
34	5094	323-600-072	screw	3
35	208604	323-560-052	Right looper lever oil shield, complete	1
36	5147	323-600-206	screw	1
37	201048A	323-860-200	Right looper thread eyelet	1
38	201072A	323-639-225	" " " tube	1
39	201048A	323-860-200	Left looper thread eyelet	1
40	201072A	323-639-225	" " " " tube	1
41	204649	323-891-002	Stitch indicator	1
42	204871	323-628-002	rivet	2
43	204857A	323-510-091	Machine cover (left) (used with Cloth Plate, Narrow 208611)	1
44	5091	323-600-257	screw	3
45	204868	323-646-004	spacer	1
46	2902	323-600-259	" screw	1
47	202286	323-617-200	" " washer	1
48	204865A	323-510-088	Machine cover (left) (used with Cloth Plate, Wide 208612)	1
49	5091	323-600-257	screw (short)	2
50	5182	323-600-109	" (long)	1
51	204867	323-646-005	spacer	1
52	5113	323-600-039	" screw	1
53	208340	323-891-004	Diff. feed ratio indication plate	1
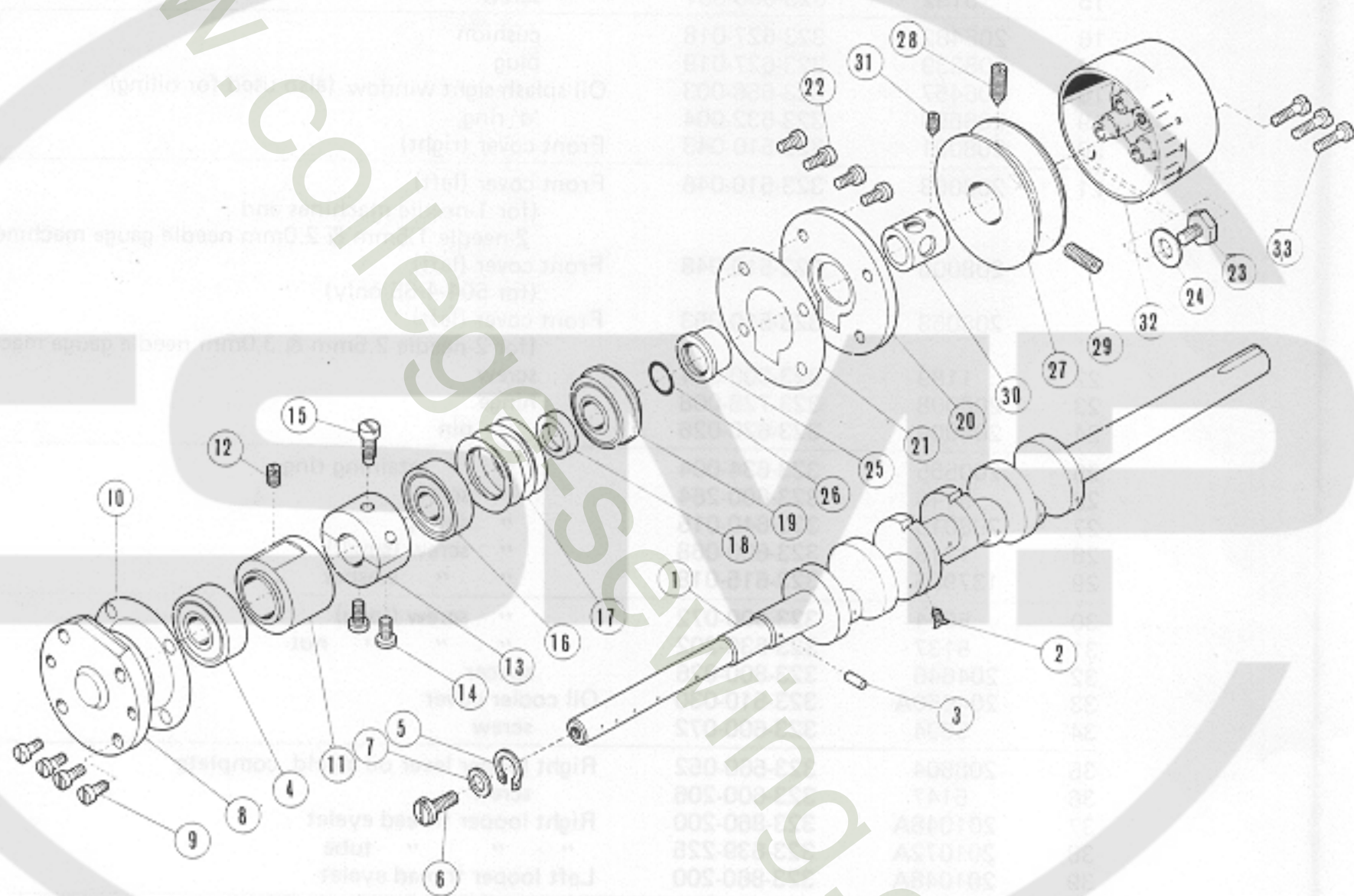
CRANKSHAFT MECHANISM

REF NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208343	323-540-029	Crankshaft	1
2	5315	323-600-344	oil plug screw	1
3	202081	323-653-003	" felt	1
4	204010	323-671-200	ball bearing (left)	1
5	204734	323-633-002	" " " retaining ring	1
6	5361	323-600-097	" " " screw	1
7	204520	323-615-233	" " " " washer	1
8	204737	323-515-002	" " " housing	1
9	5136	323-600-245	" " " " screw	4
10	204319	323-663-205	" " " " gasket	1
11	204014	323-676-243	bushing	1
12	2022	323-600-043	" screw	1
13	204016	323-676-232	" (center), set with 1174-2	1
14	1174	323-600-027	" (center) assembly screw	2
15	5240	323-600-293	" " screw	1
16	201523A	323-671-001	ball bearing (center)	1
17	204018	323-615-217	" " " washer	4
18	204019A	323-646-001	" " " spacer	1
19	204020A	323-671-002	" " (right)	1
20	204021	323-800-224	" " " plate	1
21	204022	323-626-202	" " " " gasket	1
22	5117	323-600-057	" " " " screw	4
23	5238	323-600-294	" " " screw	1
24	204023	323-615-221	" " " " washer	1
25	208271	323-680-011	oil seal collar	1
26	208272	323-632-002	" " 'o' ring	1
27	204025	323-546-203	Machine pulley	1
28	5080	323-600-008	position screw	1
29	5081	323-600-009	screw	1
30	204026	323-546-204	collar	1
31	5267	323-600-295	" screw	1
32	208320	323-780-011	cap	1
33	5010	323-600-010	" screw	3