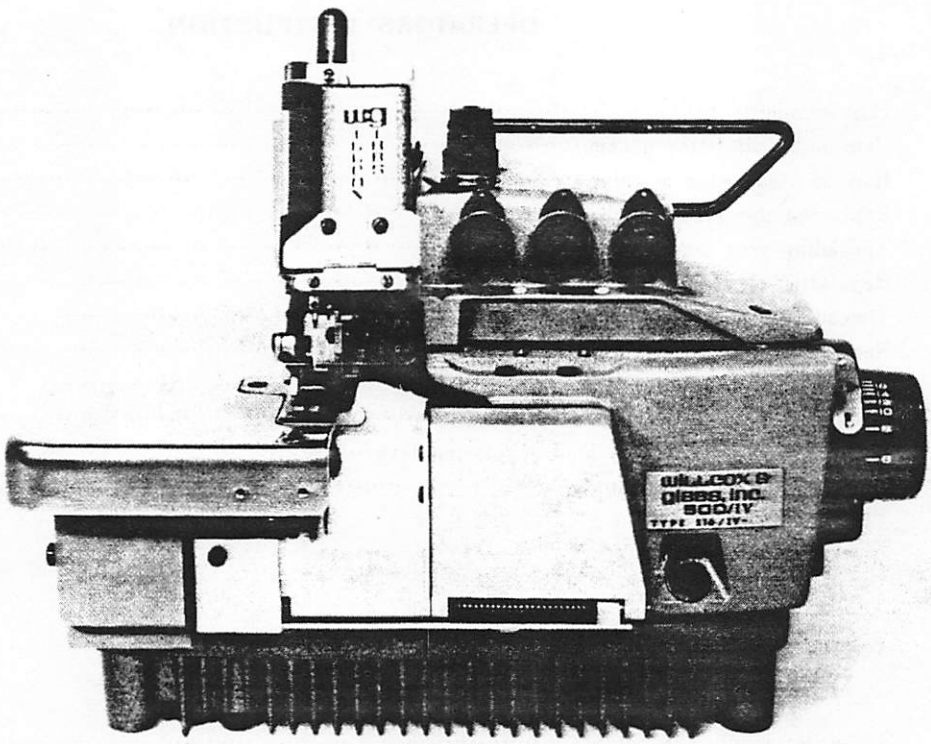
INSTRUCTION & PARTS CATALOG



WILLCOX & GIBBS 500/IV

(overlock & safety stitch)

wg
WILLCOX & GIBBS, INC.
1040 AVENUE OF THE AMERICAS NEW YORK, NEW YORK 10018 (212) 565-7900

From the library of: Superior Sewing Machine & Supply LLC

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INTRODUCTION

The new Willcox & Gibbs 500/IV is the latest design in Overlock and Safety stitch machines. You will benefit from its ease of handling, fast pickup in starting and smooth, quiet running. It is automatically lubricated and ruggedly designed for trouble-free performance. As the operator, you will appreciate these features helping you to gain more production with less fatigue as you operate. Willcox & Gibbs will continue to lead the way in developing new machines that will benefit the Operator, achieve more production – with greater ease.

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LUBRICATION (Fig. 1, 2, 3)

CAUTION: The oil was drained from the machine when shipped. Refill with oil before operating.
The 500/IV features fully automatic lubrication with a concealed forced air cooling system. The oil is pressurized by a pump to the internal surfaces of the connections through the inner Crankshaft.
A new machine should be run at least two weeks at a speed not to exceed 5,000 r.p.m. At the end of two weeks, the original oil should be drained out and replaced.
Operational speed after two weeks run-in may be 6,000 r.p.m.
(Fig. 3).
Use recommended type oil only.

MACHINE SPEED	PULLEY SIZE	DIAMETER in INCHES
4900	631	3 1/8"
5100	632	3 1/4"
5275	633	3 3/8"
5450	634	3 1/2"
5650	635	3 5/8"
5825	636	3 3/4"
6000	637	3 7/8"

Fig. 3

Note: The above pulley size is based on a motor speed of approx. 3,480 r.p.m. (60Hz, 2-pole)

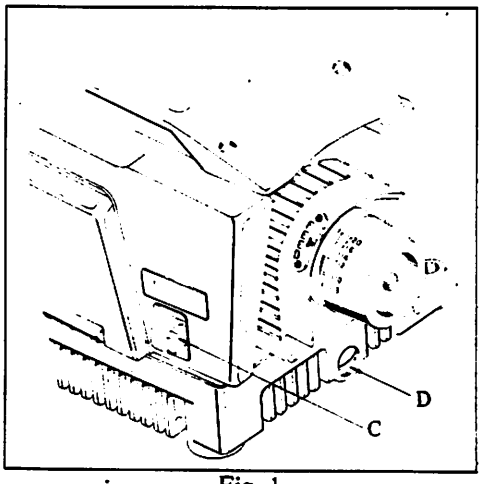

Fig. 1

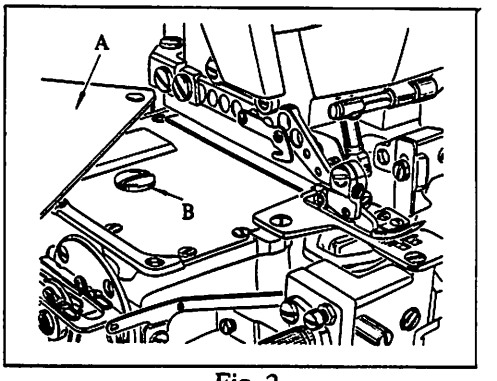

Fig. 2

To replace the oil.
Remove the machine from its stand and set it on a table. Remove Drain Plug (Fig. 1, D) which is located on the Oil Pan just below the Handwheel. Drain oil from machine. Replace the plug and return the machine to its stand.
To refill, swing out the Cloth Plate (Fig. 2, A) to the left and remove the Filler Plug (B).
Pour fresh oil into the reservoir using the funnel supplied with the accessories until the oil reaches the upper line of the Sight Gauge (Fig. 1, C).
The oil level should be kept between the two lines on the Sight Gauge.

CAUTION TO OIL FILTER SCREEN

The Oil Filter Screen (Fig. 4, A) should always be kept clean. Since the lubrication oil is filtered by this Screen and delivered to all the frictional surfaces, clogging of this Screen may cause lack of lubrication and accidential seizure of parts.
Check and clean the Oil Filter Screen every three months, or if necessary, replace with a new Screen when:
the oil jet in the Oil Splash Sight Window is restricted or weak, or the oil contains foam or debris.

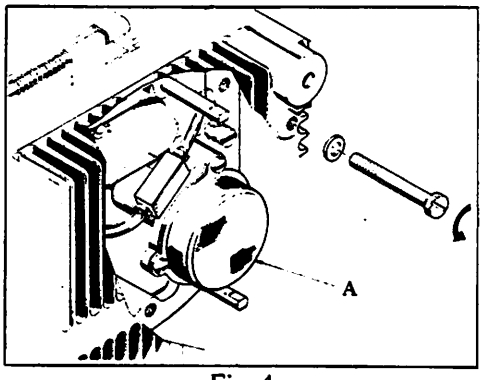

Fig. 4

HOW TO CLEAN YOUR MACHINE

Cleaning the machine is a simple but important operation. It is not necessary to remove any part. Merely release the foot and swing it out to the left. Swing out the covers and remove all the collected lint from around the loopers, feed slots, and under the needle plate. Blow out any loose lint or use a lint brush. Replace covers and return foot to the sewing position.

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REPLACING THE NEEDLES (Fig. 5, 6, 7, 8)

To replace needles, turn the Handwheel until the Needle Bar is in its highest position. Lift up the Hand Lift Lever (Fig. 5, E) and swing foot to the left (F).

503, 504/IV (Fig. 6)

Loosen Needle Clamp Nut (A) and withdraw needle. Insert new needle into the needle hole as far as it will go, and position scarf of the needle to the rear of the machine. Retighten nut (A).

514/IV (Fig. 7)

515, 516/IV (Fig. 8)

Loosen Needle Clamp Screws (B) and withdraw needle. Insert new needle into the needle hole as far as it will go, and position scarf of the needle to the rear of the machine. Retighten screws (B).

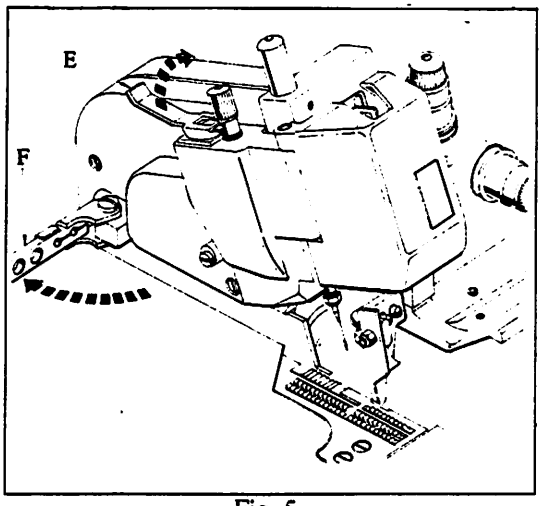

Fig. 5

503, 504/IV

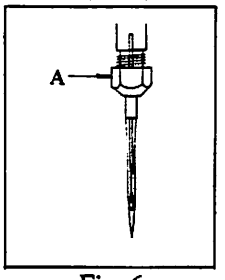

Fig. 6

514/IV

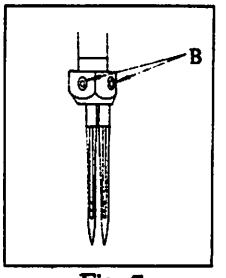

Fig. 7

515, 516/IV

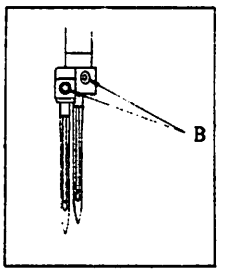

Fig. 8

THREADING YOUR MACHINE (Fig. 9, 10, 11, 12, 13, 14)

When a machine is received, note that it has been threaded correctly. The simplest way to rethread it is to tie the new threads to those already in the machine and pull the new threads through, making sure that the knots will go through the looper eyes and needles.
In case the machine requires a complete rethreading refer to the threading diagrams.

REGULATING THREAD TENSION

The amount of tension required varies with type of material, thread, stitch length, etc.
Adjust individual thread tensions as follows.

To increase tension – Turn nut clockwise.
To decrease tension – Turn nut counterclockwise.

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THREADING DIAGRAMS

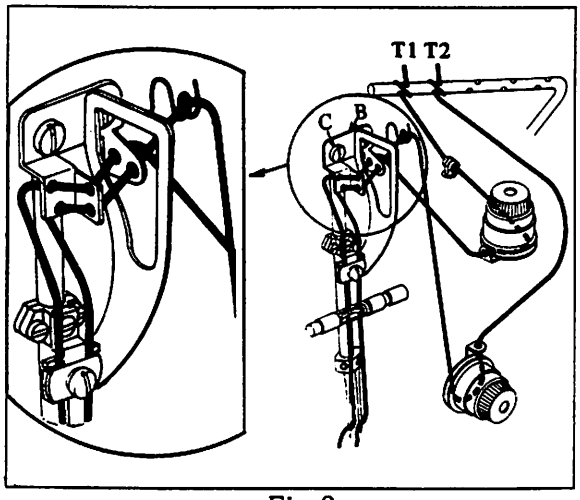

Fig. 9

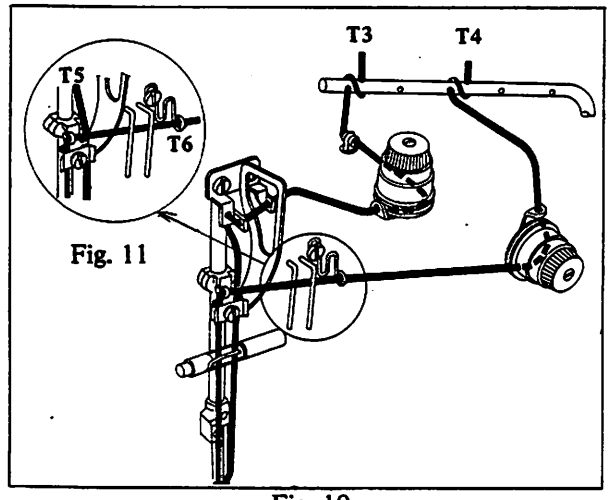

Fig. 10

503/IV, 504/IV, 514/IV

	503/IV	504/IV	514/IV
Left needle thread	Non	Non	T1
Right needle thread	T2	T2	T2
Right looper thread	Non	T8	T8
Left looper thread	T7	T9	T9

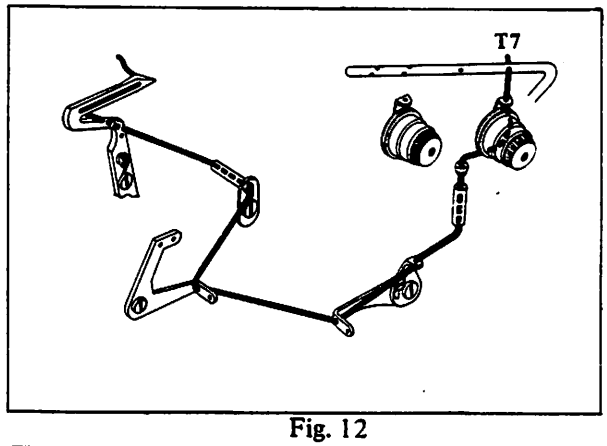

Fig. 12

For the welting operation which requires a loose needle tension, the Needle Thread Guide (Fig. 9, B) may be adjusted.

To decrease tension – Loosen Needle Thread Guide Screws (Fig. 9, C), move Needle Thread Guide down. Retighten screws (C).

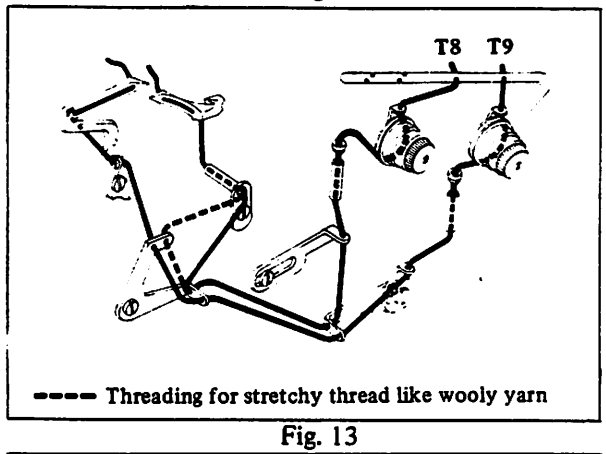

Fig. 13

515/IV, 516/IV

	515/IV	516/IV
Right needle thread	T3	T3
Left needle thread	T4	T4
Right looper thread	Non	T8
Left looper thread	T7	T9
Chainstitch looper thread	T10	T10

Fig. 11: Needle threading for elastic synthetic thread.

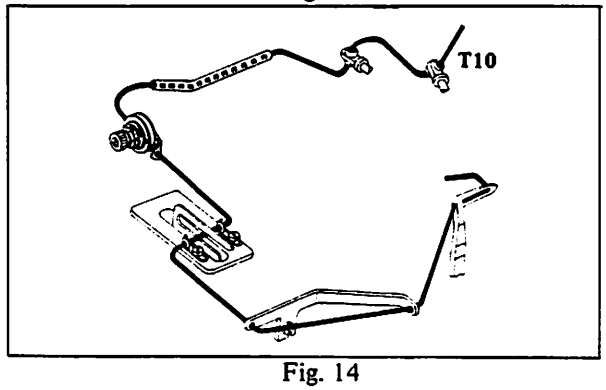

Fig. 14

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REGULATING SEAM WIDTH

515, 516/IV (Fig. 15)

1. Turn the Handwheel until the Upper Knife is at its lowest point.
2. Loosen the Lower Knife Holder Screw (A). Pull the Lower Knife Holder (the Lower Knife Clamp Stud Nut. B) to the left as far as it will go and lightly tighten screw (A).
3. Loosen the Upper Knife Clamp Screws (C) and move the Upper Knife Clamp (D) to the right or left until the desired width is obtained.
4. Tighten the Upper Knife Clamp Screws (C).
5. Loosen the Lower Knife Holder Screw (A), then the Lower Knife Holder will return to position by spring action.
6. Retighten screw (A).

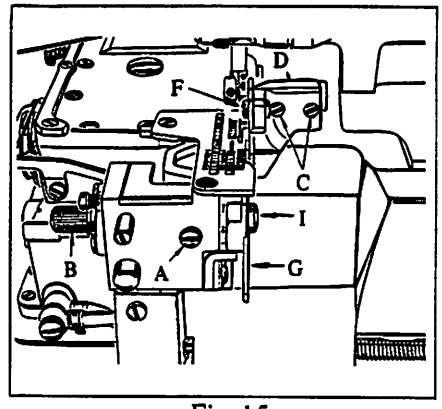

Fig. 15

503, 504, 514/IV (Fig. 16)

1. Turn the Handwheel until the Upper Knife is at its lowest point.
2. Loosen the Lower Knife Holder Screw (A). Push the Lower Knife Holder (the Lower Knife Clamp Screw. E) to the left as far as it will go and lightly tighten screw (A).
3. Loosen the Upper Knife Clamp Screws (C) and move the Upper Knife Clamp (D) to the right or left until the desired width is obtained.
4. Tighten the Upper Knife Clamp Screws (C).
5. Loosen the Lower Knife Holder Screw (A), then the Lower Knife Holder will return to position by spring action.
6. Retighten screw (A).

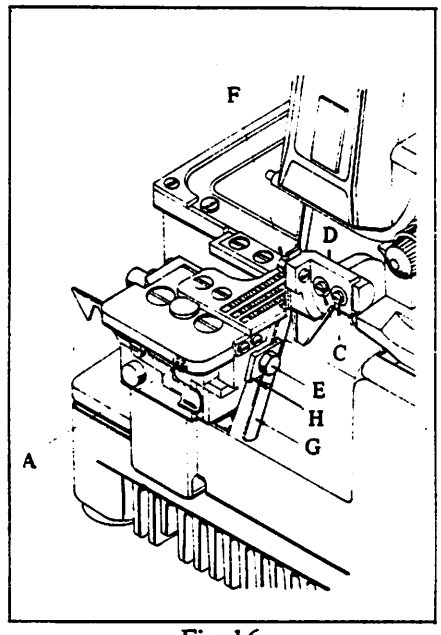

Fig. 16

ADJUSTING THE UPPER AND LOWER KNIVES

UPPER KNIFE

515, 516/IV (Fig. 15, 17)

1. Loosen the Lower Knife Holder Screw (Fig. 15, A). Pull the Lower Knife Holder (the Lower Knife Clamp Stud Nut. B) to the left as far as it will go and lightly tighten screw (A).
2. Remove the Upper Knife Nut (F) and raise the knife to remove. Replace with a new knife but do not tighten nut (F) completely.
3. Turn the Handwheel until the Knife Holder (D) is in its lowest position. Set the Upper Knife so that its cutting edge overlaps the Lower Knife by 1/32" (.5-1.0mm) (Fig. 17).
   Retighten nut (F).
4. Loosen the Lower Knife Holder Screw (A), then the Lower Knife Holder will return to position by spring action.
5. Retighten screw (A).

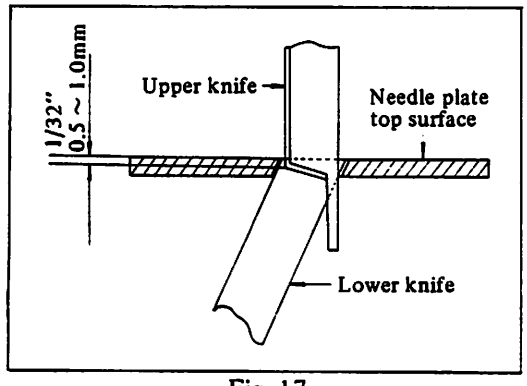

Fig. 17

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ADJUSTING THE UPPER AND LOWER KNIVES (cont'd)

503, 504, 514/IV (Fig. 16, 17)

1. Loosen the Lower Knife Holder Screw (A). Push the Lower Knife Holder (the Lower Knife Clamp Screw. E) to the left as far as it will go and lightly tighten screw (A).
2. Remove the Upper Knife Screw Nut (F) and raise the knife to remove.
   Replace with a new knife but do not tighten nut (F) completely.
3. Turn the Handwheel until the Knife Holder (D) is in its lowest position.
   Set the Upper Knife so that its cutting edge overlaps the Lower Knife by 1/32" (.5-1.0mm) (Fig. 17).
   Retighten nut (F).
4. Loosen the Lower Knife Holder Screw (A), then the Lower Knife Holder will return to position by spring action.
5. Retighten screw (A).

LOWER KNIFE

515, 516/IV (Fig. 15, 17)

1. Loosen the Lower Knife Holder Screw (Fig. 15, A). Pull the Lower Knife Holder (the Lower Knife Clamp Stud Nut. B) to the left as far as it will go and lightly tighten screw (A).
2. Loosen the Clamp Stud Nut (B) and remove the Lower Knife.
3. Insert a new Lower Knife (G) into the groove of the Lower Knife Clamp Stud (I), setting the blade so that the cutting edge is level with the top of the Needle Plate (Fig. 17). Tighten nut (B).
4. Loosen the Lower Knife Holder Screw (A), then the Lower Knife Holder will return to position by spring action.
5. Retighten screw (A).

503, 504, 514/IV (Fig. 16, 17)

1. Loosen the Lower Knife Holder Screw (Fig. 16, A). Push the Lower Knife Holder (the Lower Knife Clamp Screw. E) to the left as far as it will go and tighen screw (A) lightly.
2. Loosen the Lower Knife Clamp Screw (E) and remove the Lower Knife.
3. Insert a new Lower Knife (G) into the Lower Knife Clamp (H), setting the blade so that the cutting edge is level with the top of the Needle Plate (Fig. 17). Tighten screw (E).
4. Loosen the Lower Knife Holder Screw (A), then the Lower Knife Holder will return to position by spring action.
5. Retighten screw (A).

Note: A right angled Upper Knife is also available as an auxiliary sales item.

Knives must be kept sharp. The Lower Knife may be sharpened by use of a grinder while making sure that the correct angle is maintained.

Upper Knife may be sent to our distributors or returned to us for resharpening since it requires special grinding.

REGULATING THE STITCH LENGTH (Fig. 18, 19)

To change the stitch length, swing Cloth Plate to the left. Loosen Feed Eccentric Push Rod Screw (Fig. 18, A) and press in the Eccentric Push Rod (B). While pressing in on the rod, turn the Handwheel in the sewing direction until the rod drops into the hole in the eccentric.

Turn the Handwheel toward the desired stitch length as shown on the Handwheel and cover for a longer or shorter stitch (Fig. 19).

Longer Stitch (less stitches per inch) – Turn Handwheel clockwise.
Shorter Stitch (more stitches per inch) – Turn Handwheel counterclockwise.

When desired stitch length is obtained, release the rod (B) and tighten screw (A)

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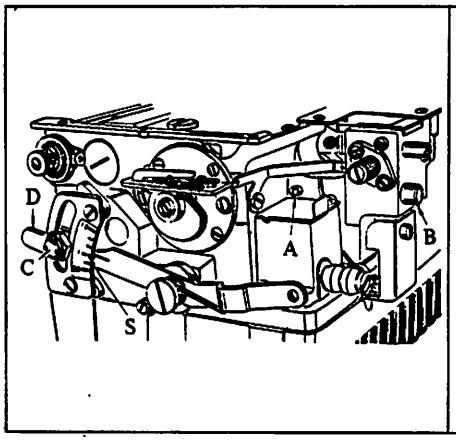
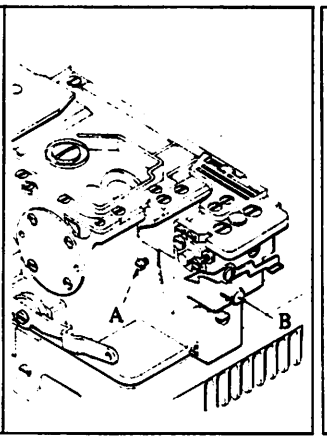


(515, 516)



(503, 504, 514)

Fig. 18

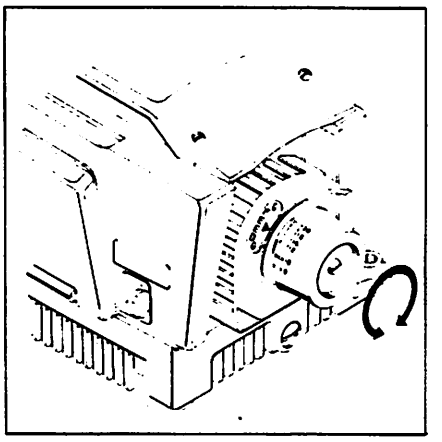


Fig. 19

ADJUSTING THE DIFFERENTIAL FEED REGULATING LEVER (Fig. 18, 20)

The following feed ratios are preset at the factory.
Seaming machines 1/2:1 stretch to 2:1 filling
Shirring machines 1:1 seaming to 3:1 shirring

TO ADJUST:

Seaming Machines – (Fig. 18) Loosen Thumb Nut (C). Line up mark on Differential Lever (D) with setting shown on Indicator Plate (S). Retighten nut (C).

INDICATOR PLATE SETTING	=	DIFFERENTIAL : MAIN FEED RATIO
1.8	=	2 : 1 filling
1	=	1 : 1
0.6	=	1/2 : 1 stretch

Shirring Machines – (Fig. 20) Intermittent shirring can be obtained by use of the Knee Control provided with Shirring Machines. When the range has been set the adjustable stops (E) are positioned and Thumb Nut (C) is left loose.

INDICATOR PLATE SETTING	=	DIFFERENTIAL : MAIN FEED RATIO
3	=	3 : 1 shirring
2	=	2 : 1 shirring
1	=	1 : 1 seaming

Please note all settings are approximate figures that will vary with fabric weights, thread, stitch length, etc.

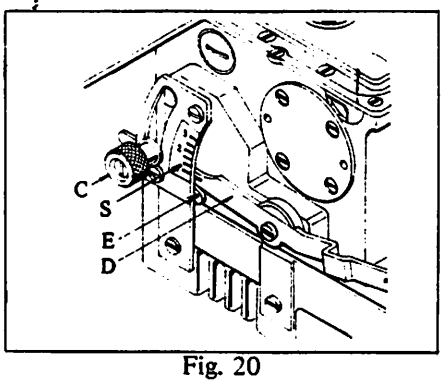


Fig. 20

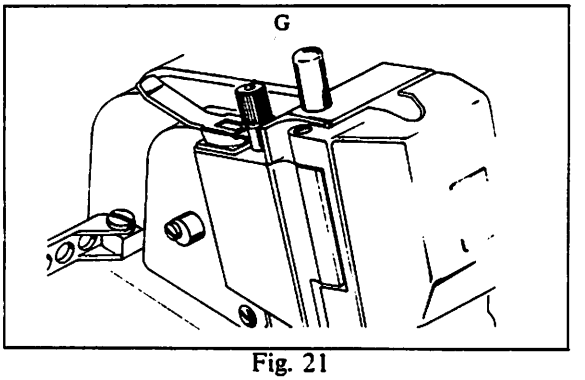


Fig. 21

PRESSURE OF PRESSER FOOT

Pressure of the Presser Foot is regulated by means of the Presser Regulating Thumb Screw (Fig. 21, G). Pressure on the Presser Foot should be just enough to feed material and obtain proper stitch formation. Too much pressure may spoil material and give it more stretch than it needs. Too little pressure may cause uneven feeding or stitches.

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ADJUSTING NEEDLE BAR HEIGHT (Fig. 22, 23, 24)

With a new needle in the machine, turn the Handwheel until the needle is in its highest position. Use Timing Gauge, check the clearance between the point of the needle and the top of the Needle Plate. If clearance is not correct, loosen the Needle Bar Connecting Bracket Screw and reset the Needle Bar correctly. Check to make sure the needle is in the center of the needle hole and tighten the bracket screw securely.

FEDERAL STITCH	MODEL	DIMENSION INCH	DIMENSION MM	FIG.	NOTE
503	503/IV	.410	10.4	22	
504	504/IV	.410	10.4	22	
505	505/IV	.410	10.4	22	
512	514/IV	.465	11.8	23	check to the left needle
514	514/IV	.465	11.8	23	check to the left needle
515	515/IV	.418	10.6	24	check to the right needle
516	516/IV	.418	10.6	24	check to the right needle

EXCEPTIONS:

515 (516)/IV-38, -39 ..... .398" 10.1mm

515 (516)/IV-51, -52 ..... .473" 12.0mm

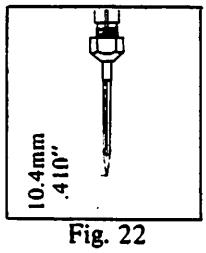

Fig. 22

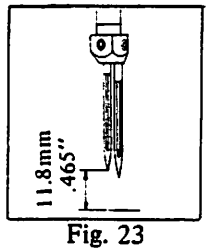

Fig. 23

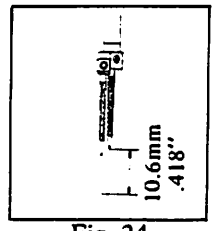

Fig. 24

ADJUSTING NEEDLE GUARDS (Fig. 25, 26, 27, 28)

Machine are fitted with both front and rear needle guards. Set Rear Guard first.

Rear Needle Guard

515, 516/IV (Fig. 25, 27)

Turn Handwheel until Needle Bar is at its lowest position. Loosen two screws (U) holding Needle Guard Bracket. Move bracket until the top of the Overlock needle eye is .020" (0.5mm) below the line (T) of the Needle Guard, Rear. Tighten screws (U). Loosen screw (R) holding Needle Guard, Rear. When point of the Left Looper comes to the centerline of the needle, adjust the Needle Guard (S) back and forth so that it lightly touches the needle. Tighten screw (R).

503, 504, 514/IV (Fig. 26, 27)

Turn Handwheel until Needle Bar is at its lowest position.

Loosen two screws (N) holding Needle Guard Bracket. When point of the Left Looper comes to the centerline of the needle, adjust the Needle Guard (S) back and forth so that it lightly touches the needle. Tighten bracket screws (N).

Front Needle Guard (Fig. 28)

Adjust Needle Guard so there is a space of .004 – .008" (.1 – .2mm) between the Needle and Guard.

CAUTION: Needle Guard must be reset when needle size is changed.

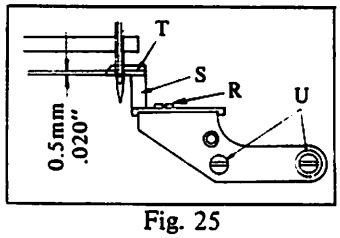

Fig. 25

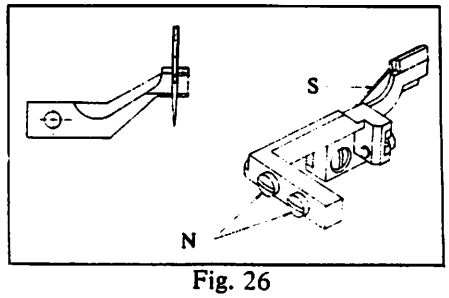

Fig. 26

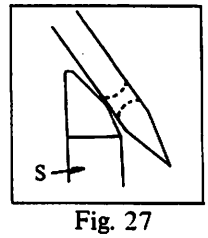

Fig. 27

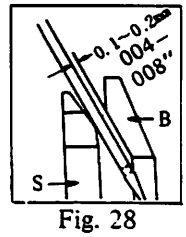

Fig. 28

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LEFT LOOPER ADJUSTMENT (Fig. 29, 30)

Clearance from point of Looper to centerline of Needle

FEDERAL STITCH	MODEL	DIMENSION	
		INCH	MM
503	503/IV	.154 (5/32)	3.9
504	504/IV	.154 (5/32)	3.9
505	504/IV	.154 (5/32)	3.9
512	514/IV	.154 (5/32)	3.9
514	514/IV	.169 (11/64)	4.3
515	515/IV	.154 (5/32)	3.9
516	516/IV	.154 (5/32)	3.9

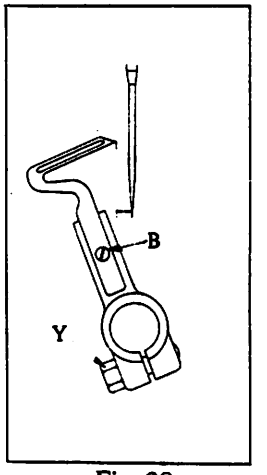

Fig. 29

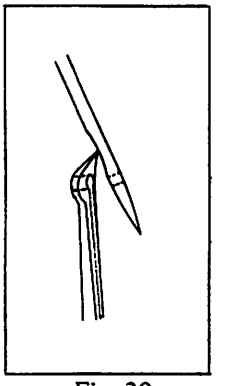
Fig. 30

Insert the Looper into the Looper Lever, making sure it reaches the bottom of slot. Tighten screw (B). Turn the Handwheel until the Looper is in the extremely left position.

Loosen clamp screw (Fig. 29, Y). Set point of Looper from centerline of Needle to correct dimension shown above and lightly tighten screw (Y). Turn Handwheel until Looper point is on the centerline of the Needle. Move Looper Lever, if necessary, along its shaft so that the Looper point just touches the needle at the scarf (Fig. 30), tighten screw (Y). Recheck clearance dimension and tighten screw (Y) securely.

RIGHT LOOPER ADJUSTMENT (Fig. 31, 32, 33, 34, 35)

Clearance from Looper (eye) or Spreader (bottom of V groove) to centerline of Needle (Fig. 31, 32).

FEDERAL STITCH	MODEL	DIMENSION	
		INCH	MM
503	503/IV	.130 (1/8)	3.3
504	504/IV	.130 (1/8)	3.3
505	504/IV	.130 (1/8)	3.3
512*	514/IV*	–0–*	–0–*
514	514/IV	.157 (5/32)	4.0
515	515/IV	.130 (1/8)	3.3
516	516/IV	.130 (1/8)	3.3

* aligned with left needle eye

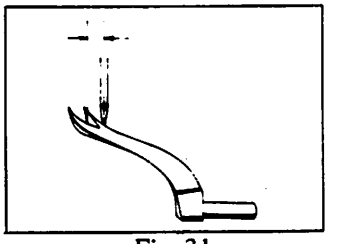
Fig. 31

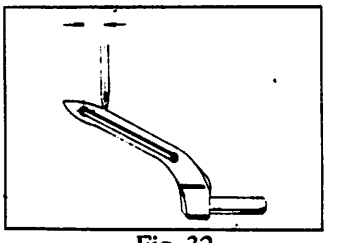
Fig. 32

Turn Handwheel until the Looper is at its extremely left position. Loosen clamp screw (Fig. 35, K) and move Looper until necessary dimension is obtained as listed above.

At the same time, make sure the Looper points cross as shown in Fig. 33.

Clearance between the Needle (N) and Right Looper should be .004 – .008" (0.1 – 0.2mm) (Fig. 34).

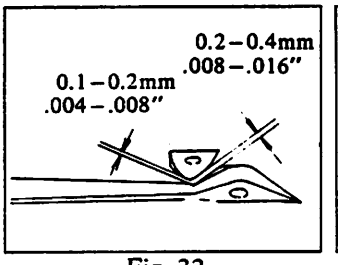

Fig. 33

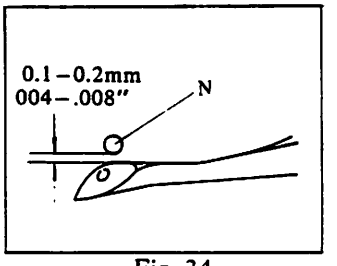

Fig. 34

If the Right Looper strikes the Left Looper in passing, advance or retard the timing by adjusting the Right Looper Lever.

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RIGHT LOOPER LEVER ADJUSTMENT (Fig. 35)

Turn Handwheel until the Right Looper is at its lowest position.
Clearance between Crank Pin and Machine Bed should be:

MODEL	DIMENSION	
	INCH	MM
503/IV	.157 (5/32)	4.0
515/IV	.157 (5/32)	4.0
504/IV	.138 (9/64)	3.5
514/IV	.138 (9/64)	3.5
516/IV	.138 (9/64)	3.5

Note: To check this setting the Oil Pan must be removed.

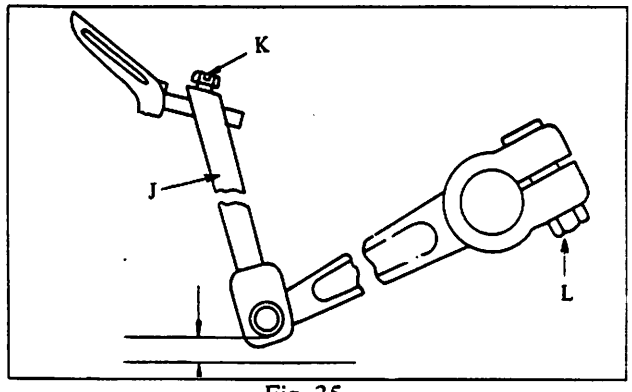

Fig. 35

If adjustment is necessary, loosen clamp screw (L).
Adjust the Looper Lever (J) up or down until the correct setting is obtained. Retighten clamp screw (L). Adjust the Looper back and forth, right and left in the holder. Retime the Looper to the Needle since raising or lowering the lever will alter the distance between the Looper eye and Needle centerline. Securely tighten screw (K) and (L). Replace Oil Pan.

CAUTION: Make sure when tightening screw (L) that you do not twist the Looper Lever causing a bind in the machine.

Various Right Loopers are provided as listed below for use with various size needles.
For ease of identification looper have been marked with a looper marking.

	MODEL	LOOPER MARKING	NEEDLE SIZE IDENTIFICATION			PART NUMBER	
			SINGER	W & G	METRIC	515-516/IV	503-514/IV
2 thread	503-515/IV	1	9-12	027-032	65-80	204278 323-810-215	
		3	13-16	034-040	85-100	204704 323-810-011	204704 323-810-011
		5	17-21	042-051	100-140	204705 323-810-012	
3 thread	504-516/IV	2	9-12	027-032	65-80	204062 323-810-218	204062 323-810-218
		4	13-16	034-040	85-100	204702 323-810-009	204702 323-810-009
		6	17-21	042-051	100-140	204703 323-810-010	204703 323-810-010
4 thread	514/IV	7	9-14	027-036	65-90		204663 323-810-008

CHAINSTITCH LOOPER ADJUSTMENT (Fig. 36, 37, 38)

Clearance from point of Looper to centerline of Needle

MODEL	INCH	MM
515-516/IV	.083 (5/16)	2.1

Insert Chainstitch Looper into Looper Lever (Fig. 36, O) until it touches the Looper Regulator (P).
Tighten screw (Q). Turn Handwheel until the Looper is at its extremely left position (Fig. 37).
Loosen clamp screw (R) and move Looper Lever until the necessary clearance is obtained. Tighten screw (R).

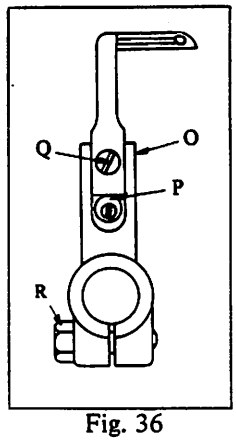

Fig. 36

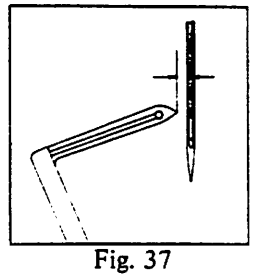
Fig. 37

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CHAINSTITCH LOOPER HEIGHT ADJUSTMENT (Fig. 38)

Turn Handwheel and check the eye to eye relationship of the needle and Looper. The eye of the needle and the eye of the Looper should cross when the Looper is coming in to the needle and on the way back. If the eye to eye relationship is not obtained, adjust the Looper Regulator (Fig. 36, P) to the left or right. This adjustment will raise or lower the Looper eye.
The Looper must be set so that the point of the Looper does not quite touch the needle as it passes. When the above settings are complete, tighten clamp screw (R) securely.

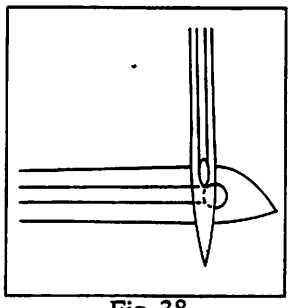

Fig. 38

CHAINSTITCH LOOPER AVOIDING MOTION ADJUSTMENT (Fig. 39)

To change the looper avoiding motion due to the diameter of the needle. When larger or smaller needles are fitted to the machine make the following adjustment.
Swing out Cloth Plate. Remove Bedplate. Loosen Looper Avoiding Connection Pin Nut. Turn Looper Avoiding Regulating Screw. (Fig. 39, G).

Less motion – Turn screw clockwise. This will raise the Looper Avoiding Connection Pin.
More motion – Turn screw counterclockwise. This will lower the Looper Avoiding Connection Pin.

Check that the Chainstitch Needle passes just behind the Chainstitch Looper on the downstroke. Retighten Looper Avoiding Connection Pin Nut. Replace Bedplate and Cloth Plate.

FEED ADJUSTMENT (Fig. 39, 40, 41)

Feed Dogs have generally been preset at the factory with a front to back tilt when the machine was sewn off. Before adjusting feeds, turn the Handwheel until the feeds are at their highest position.

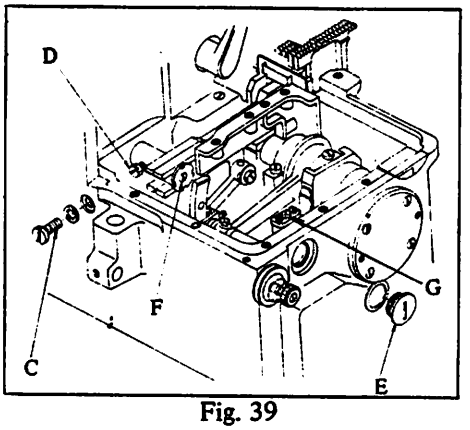

Fig. 39

Standard height of Main Feed is 0.47" (3/64) 1.2mm above the needle plate at its rearend tooth. A straight edge can be placed across the top of the feeds (Fig. 41).
Loosen Feed Dog Screws (Fig. 40, A & B) and raise or lower feeds until the proper height is obtained (Fig. 41).
Retighten screws (A & B).
To tilt the Feed Dogs, remove Plug Screw (Fig. 39, C) and loosen Feed Bar Hinge Pin Screw (D). Remove screw (E) and turn screw (F) until the desired tilt is obtained.
Retighten screw (D) and replace screws (C & E).

Woven materials – Set feeds level
Knit materials – Tilt feeds higher in the front than the rear

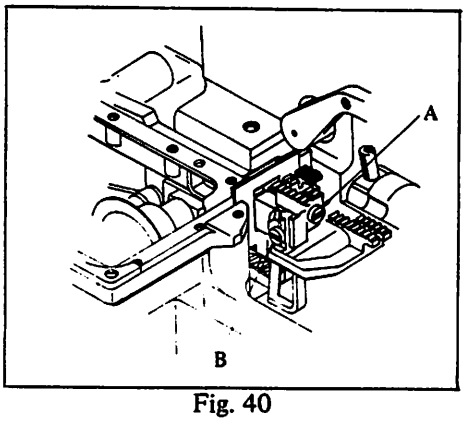

Fig. 40

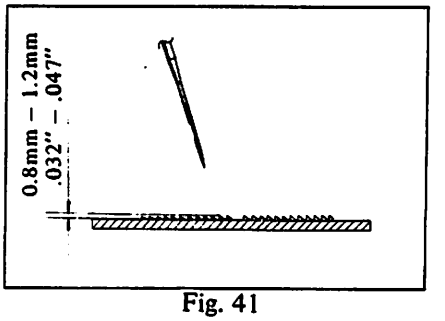

Fig. 41

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PRESSER FOOT ARM ALIGNMENT (Fig. 42)

Loosen screw (S) and move Presser Arm (P) to the right or left until the face of the Presser Arm touches the Machine Arm evenly. Securely tighten screw (S).

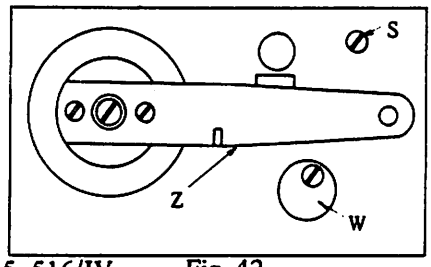

Fig. 42

503, 504, 514/IV

515, 516/IV

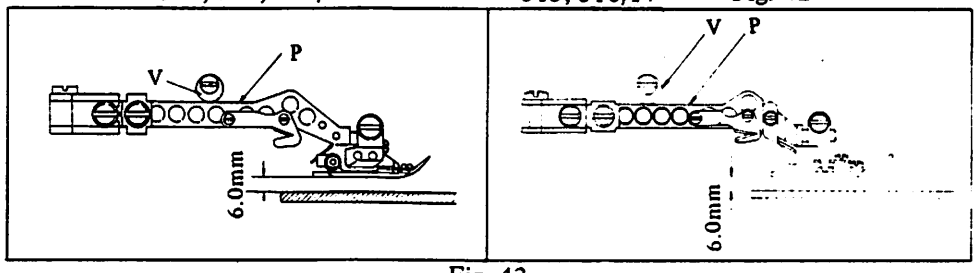

Fig. 43

PRESSER FOOT LIFT ADJUSTMENT (Fig. 42, 43, 44)

Loosen screws holding Regulators (Fig. 42, W & Fig. 43, V). Turn Regulators to allow the highest lift.
Tighten both screws.
Turn Handwheel until Needle Bar is in the lowest position. Remove (2) lock screws (Fig. 44, N).
Turn screw (M) left or right until a lift is obtained of .236" (15/64) 6.0mm.
Replace screws (N). After this setting has been. made, position Regulators (V & W) as stops so they are in contact with the Presser Arm (P) and Foot Lift Lever (Z).

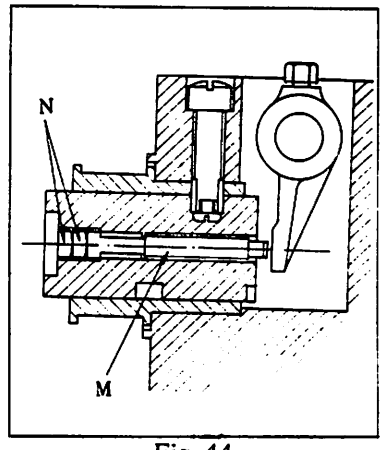

Fig. 44

CHAINSTITCH LOOPER THREAD CONTROL ADJUSTMENT (Fig. 45)

Loosen screws holding Looper Thread Takeup Eyelets (A) and move eyelets until the coiled ends line up with the engraved line on Guide Bracket (B). Tighten both screws.
Turn Handwheel until the Needle Bar is at the highest position. Loosen the two screws holding bracket (B). Set the bracket in a horizontal position. With the left screw loose, position Looper Thread Takeup Guide (D) so that the bottom edge of guide (D) is .060" (1/16) 1.5mm above the top of bracket (B). Tighten both screws securely.

Loosen the two screws holding takeup (C) and turn the Handwheel until the Needle Bar is at the highest position. Set the takeup (C) so that the flat portion is at a 10° angle to bracket (B). Tighten takeup screws. Check to make sure that the takeup clears guide (D).

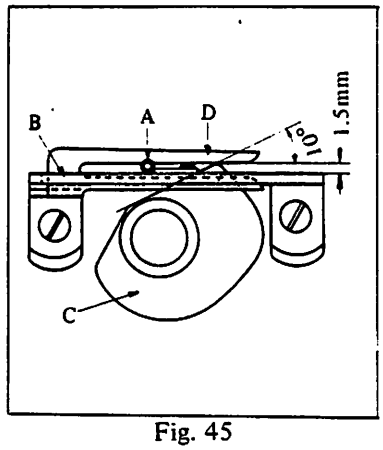

Fig. 45

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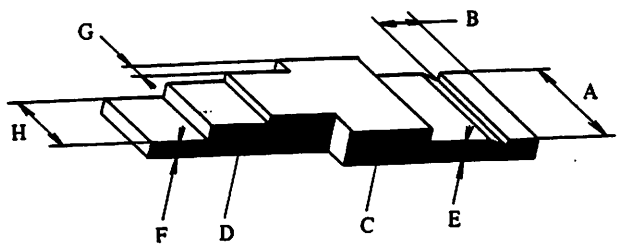
TIMING GAUGES

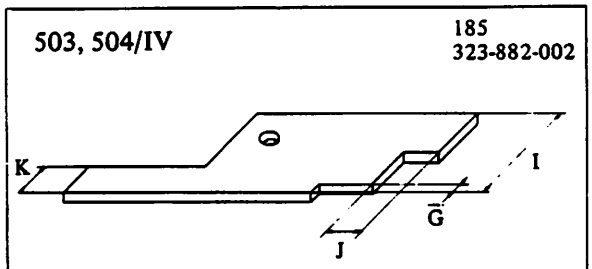
515, 516/IV

117
323-882-203



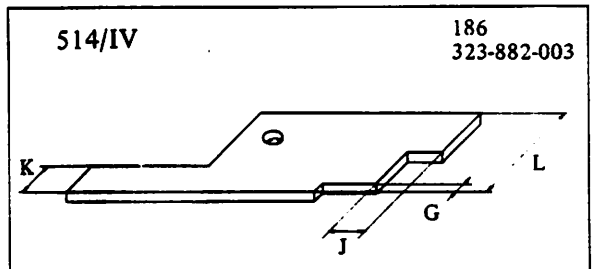
503, 504/IV

185
323-882-002



514/IV

186
323-882-003



RESPECTIVE POSITIONS REQUIRED AT MEASURING	BASIC POSITIONS ON MEASURING
A) Right Needle, at upper dead Point.	from Needle Plate top to Needle Point.
B) Right Looper, at left dead Point.	from Left side of Needle to Looper Thread Eye Center.
C) Left Looper, at left dead Point. (Needle Size 11)	from Left side of Needle to Looper Point.
D) Left Looper, at left dead Point. (Needle Size 14)	from Left side of Needle to Looper Point.
E) Chainstitch Looper, at left dead Point. (Needle Size 11)	from Left side of Needle to Looper Point.
F) Chainstitch Looper, at left dead Point. (Needle Size 14)	from Left side of Needle to Looper Point.
G) Main Feed Dog, at upper dead Point.	from Needle Plate top to top Edges of Teeth.
H) Highest height of Presser Foot lifted.	from Needle Plate top to Sole of Presser Foot.
I) Needle, at upper dead Point.	from Needle Plate top to Needle Point.
J) Right Looper, at left dead Point. (Needle Size 9)	from Left side of Needle to Looper Thread Eye Center.
K) Left Looper, at left dead Point. (Needle Size 9)	from Left side of Needle to Looper Point.
L) Left Needle, at upper dead Point.	from Needle Plate top to Needle Point.

From the library of: Superior Sewing Machine & Supply LLC

MILLIMETER-INCH FRACTION & DECIMAL CONVERSION CHART

MM	APPR. INCH FRACT.	DECIMAL	MM	APPR. INCH FRACT.	DECIMAL	MM	APPR. INCH FRACT.	DECIMAL
0.1		.004	3.4		.134	6.7	17/64	.264
0.2		.008	3.5		.138	6.8		.268
0.3	1/64	.012	3.6	9/64	.142	6.9		.272
0.4	1/64	.016	3.7		.146	7.0		.276
0.5		.020	3.8		.150	7.1	9/32	.280
0.6		.024	3.9		.154	7.2		.283
0.7		.028	4.0	5/32	.157	7.3		.287
0.8	1/32	.032	4.1		.161	7.4		.291
0.9		.035	4.2		.165	7.5	19/64	.295
1.0		.039	4.3		.169	7.6		.299
1.1		.043	4.4	11/64	.173	7.7		.303
1.2	3/64	.047	4.5		.177	7.8		.307
1.3	3/64	.051	4.6		.181	7.9	5/16	.311
1.4		.055	4.7		.185	8.0		.315
1.5		.059	4.8	3/16	.189	8.1		.319
1.6	1/16	.063	4.9		.193	8.2		.323
1.7		.067	5.0		.197	8.3	21/64	.327
1.8		.071	5.1		.201	8.4		.330
1.9		.075	5.2	13/64	.205	8.5		.335
2.0	5/64	.079	5.3		.209	8.6		.339
2.1		.083	5.4		.213	8.7	11/32	.343
2.2		.087	5.5		.217	8.8		.346
2.3		.091	5.6	7/32	.220	8.9		.350
2.4	3/32	.094	5.7		.224	9.0		.354
2.5		.098	5.8		.228	9.1	23/64	.358
2.6		.102	5.9		.232	9.2		.362
2.7		.106	6.0	15/64	.236	9.3		.366
2.8	7/64	.110	6.1		.240	9.4		.370
2.9		.114	6.2		.244	9.5	3/8	.374
3.0		.118	6.3		.248	9.6		.378
3.1		.122	6.4	1/4	.252	9.7		.382
3.2	1/8	.125	6.5		.256	9.8		.386
3.3		.130	6.6		.260	9.9	25/64	.390
			6.7			10.0		.394
			6.8					
20.0	25/32	.787	50.0	1-31/32	1.968	80.0	3-5/32	3.150
30.0	1-3/16	1.181	60.0	1-23/64	2.362	90.0	3-35/64	3.543
40.0	1-37/64	1.575	70.0	2-3/4	2.756	100.0	3-15/16	3.937

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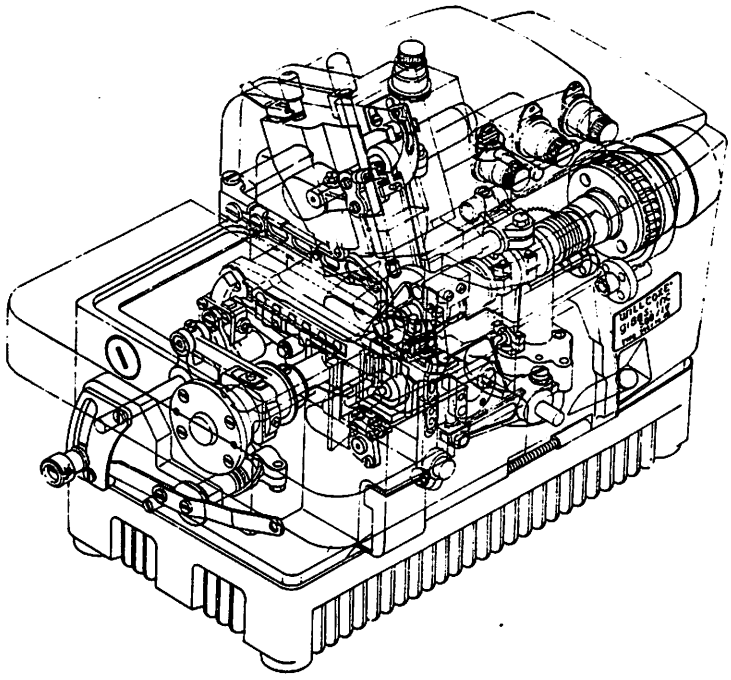
WILLCOX & GIBBS 500/IV

PARTS CATALOG



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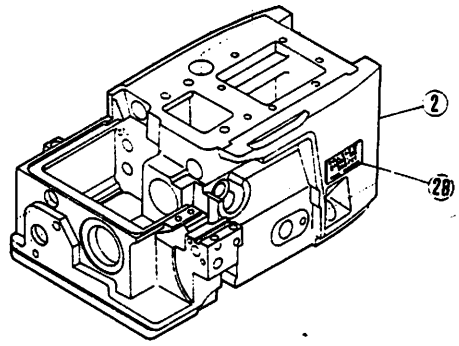
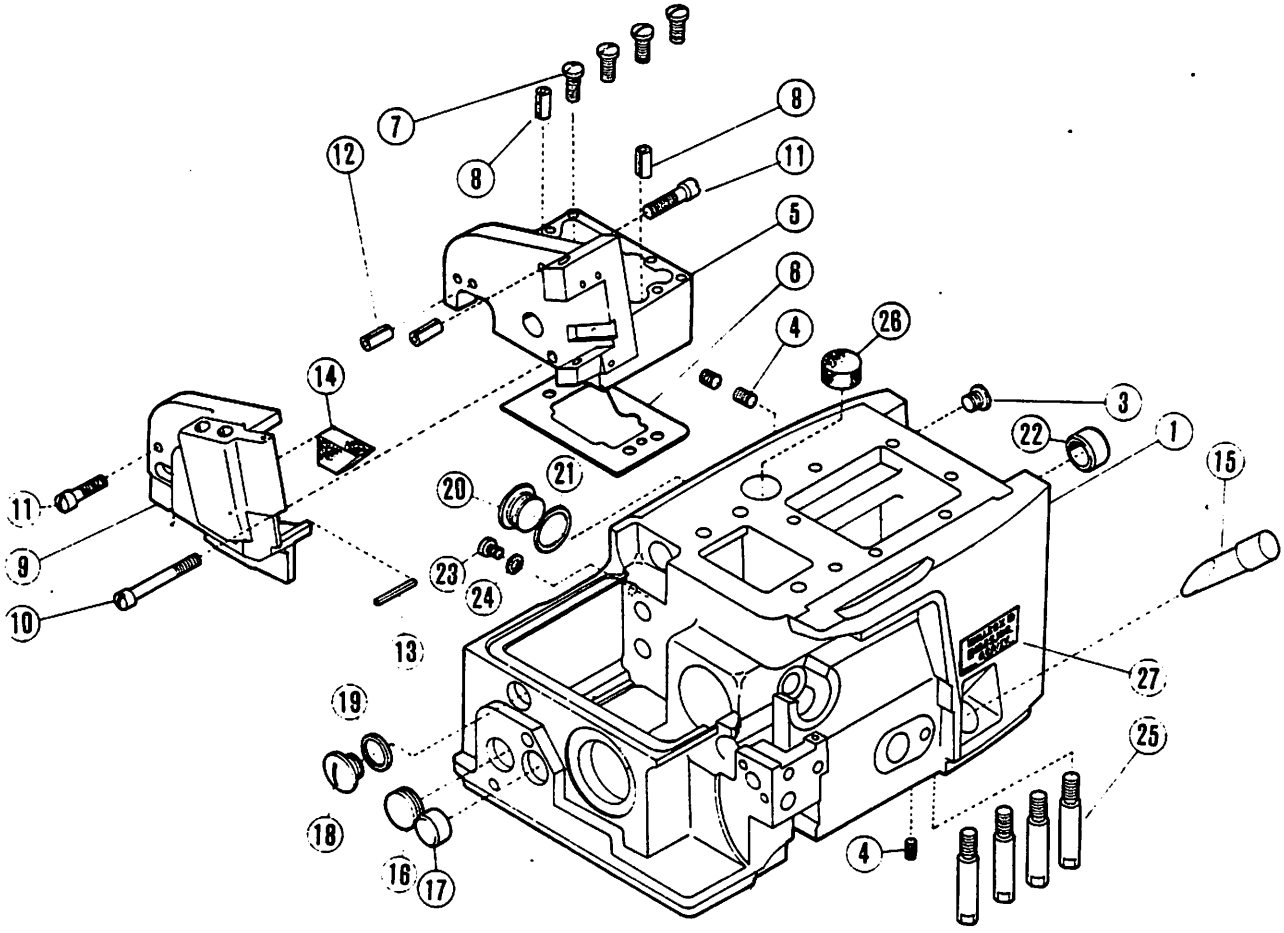
503-516/IV
MACHINE BED FRAME





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503-516/IV
MACHINE BED FRAME

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	503/IV 504/IV 514/IV	515/IV 516/IV
1	323-508-007	204000B	Machine bed frame		x
2	323-508-004	204739	Machine bed frame	x	
3	323-600-359	5332	Machine bed frame oil hole plug screw	x	x
4	323-600-043	2022	Machine bed frame oil hole plug screw (3 used)	x	x
5	323-500-006	204622A	Machine arm (right)	x	x
6	323-663-207	204251	Machine arm (right) oil seal gasket	x	x
7	323-600-001	5078	Machine arm (right) screw (4 used)	x	x
8	323-620-001	201002	Machine arm (right) hinge pin (2 used)	x	x
9	323-500-004	204850	Machine arm (left)	x	x
10	323-600-327	5237	Machine arm (left) screw (long)	x	x
11	323-600-328	5163	Machine arm (left) screw (short) (2 used)	x	x
12	323-620-001	201002	Machine arm (left) hinge pin (2 used)	x	x
13	323-663-213	204277	Machine arm (left) oil shield	x	x
14	323-560-015	204849	Machine arm (left) dust shield	x	x
15	323-882-201	204003	Oil sight gauge	x	x
16	323-627-205	204004	Dead hole plug	x	x
17	323-627-014	205088	Dead hole plug	x	x
18	323-600-329	5179	Construction hole plug screw (small)	x	x
19	323-615-001	201006	Construction hole plug screw (small) washer	x	x
20	323-600-356	5313	Construction hole plug screw (large)	x	x
21	323-615 232	204448	Construction hole plug screw (large) washer	x	x
22	323-627-010	204828	Dead hole plug	x	x
23	323-600-359	5332	Screw driver hole plug screw	x	x
24	323-615-209	200138	Screw driver hole plug screw washer	x	x
25	323-620-242	204006	Machine bed bottom pin (4 used)	x	x
26	323-655-007	204794A	Machine bed oil filter	x	x
27	323-692-224	204334	Model plate for 515/IV-26		
28	323-692-017	204686	Model plate for 504/IV-45		

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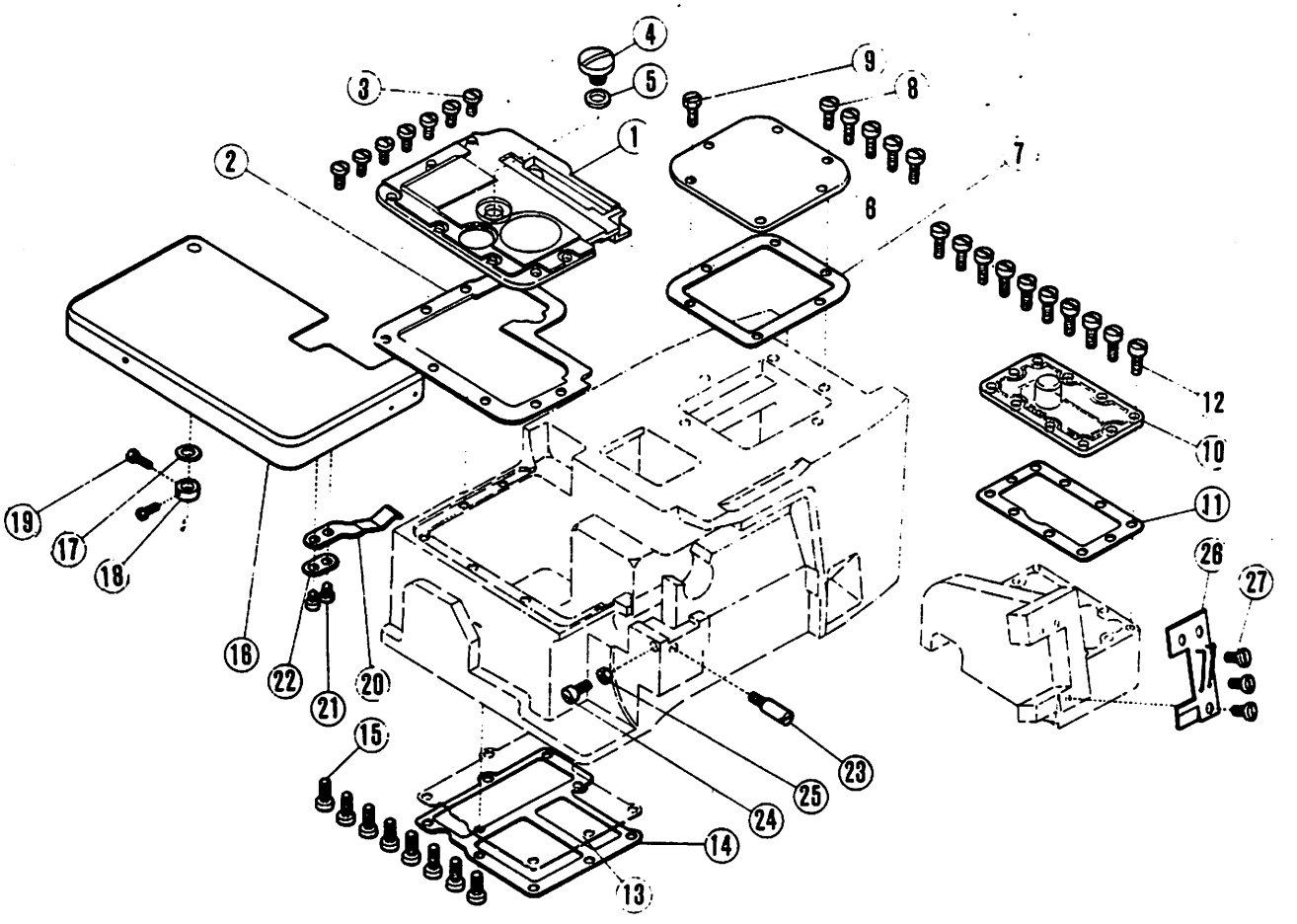
515-516/IV
(1) MAIN FRAME AND MISCELLANEOUS COVERS



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(1) MAIN FRAME AND MISCELLANEOUS COVERS

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION
1	323-800-032	204842	Bedplate
2	323-663-010	204851	Bedplate gasket
3	323-600-014	4009-1	Bedplate screw (7 used)
4	323-600-354	5138B	Oil filler plug screw
5	323-615-229	202287A	Oil filler plug screw washer
6	323-510-247	204208	Machine bed cover
7	323-663-208	204209	Machine bed cover gasket
8	323-600-0	5117	Machine bed cover screw (round head) (5 used)
9	323-600-271	2193	Machine bed cover screw (hex. head)
10	323-510-265	204210A	Machine arm (right) cover plate
11	323-663-209	204211	Machine arm (right) cover plate gasket
12	323-600-057	5117	Machine arm (right) cover plate screw (10 used)
13	323-510-237	204212A	Machine bed bottom cover
14	323-800-034	204213A	Machine bed bottom cover plate
15	323-600-057	5117	Machine bed bottom cover plate screw (8 used)
16	323-802-210	204215	Cloth plate
17	323-615-201	202576	Cloth plate hinge stud thrust washer
18	323-680-001	201139	Cloth plate hinge stud thrust collar
19	323-600-013	5084	Cloth plate hinge stud thrust collar screw (2 used)
20	323-734-204	204218	Cloth plate lock spring
21	323-600-068	1216	Cloth plate lock spring screw (2 used)
22	323-615-015	200162A	Cloth plate lock spring screw washer
23	323-600-314	5232	Cloth plate lock spring latch
24	323-600-011	5002	Cloth plate stop screw
25	323-630-001	3044	Cloth plate stop screw nut
26	323-800-222	204325	Face plate
27	323-600-014	4009-1	Face plate screw (3 used)

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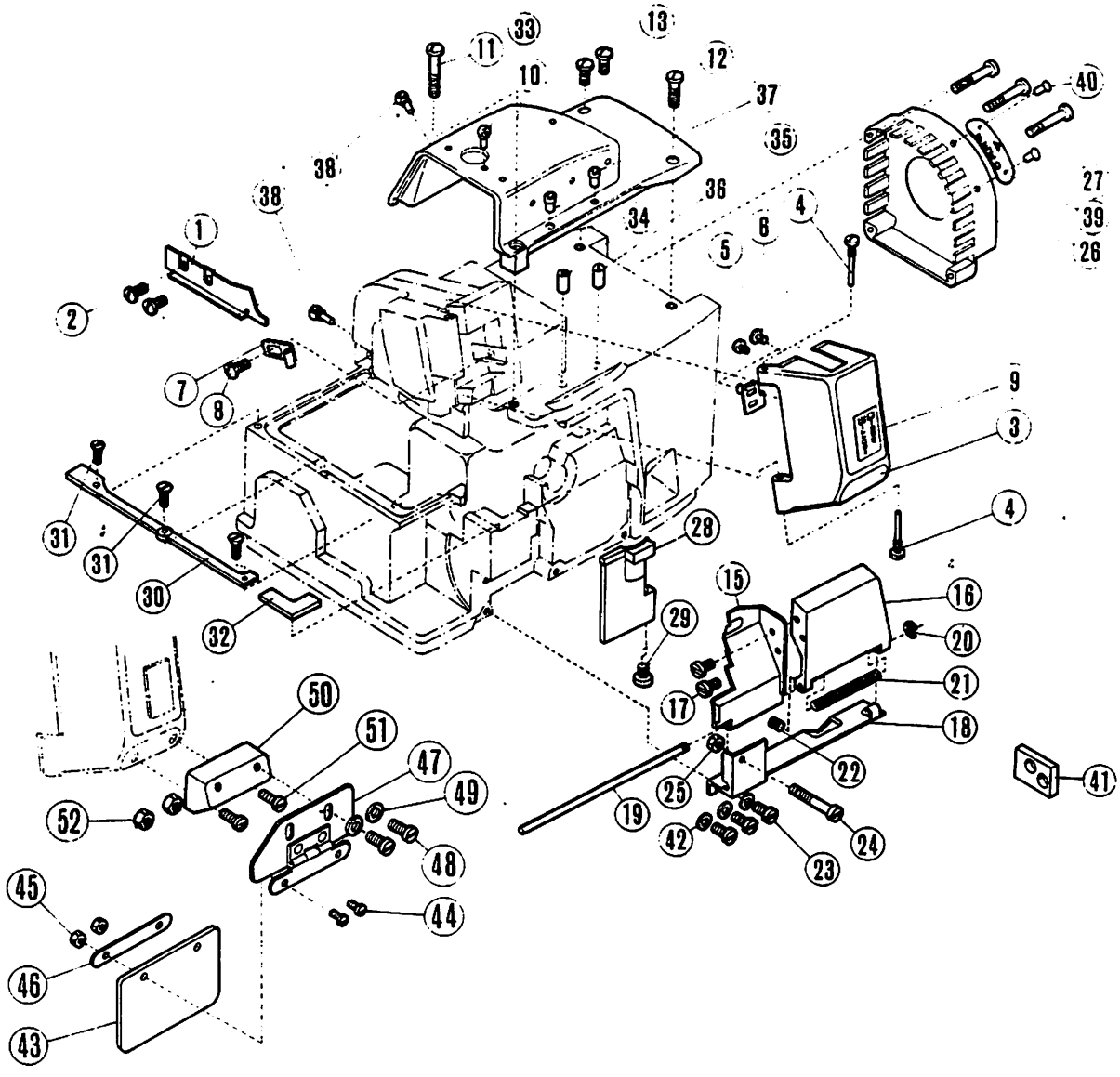
515-516/IV

(2) MAIN FRAME AND MISCELLANEOUS COVERS



From the library of: Superior Sewing Machine & Supply LLC

515-516/IV
(2) MAIN FRAME AND MISCELLANEOUS COVERS

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION
1	323-560-016	204848	Cloth plate fabric guard
2	323-600-014	4009-1	Cloth plate fabric guard screw (2 used)
3	323-510-051	208023	Needle bar cover
4	323-620-240	202653	Needle bar cover hinge pin (2 used)
5	323-641-201	202689	Needle bar cover lock spring
6	323-600-006	1234	Needle bar cover lock spring screw (2 used)
7	323-510-248	204223	Needle bar cover lock spring latch
8	323-600-014	4009-1	Needle bar cover lock spring latch screw
9	323-692-256	204450	Needle bar cover name plate
10	323-510-251	204224	Top cover
11	323-600-072	5094	Top cover screw (long)
12	323-600-038	5095	Top cover screw (medium)
13	323-600-057	5117	Top cover screw (short) (2 used)
14	323-510-054	208012	Front cover, complete with 208002, 208000, 208007, 208009, 200555, 208010, 1459 & 1189x2
15	323-510-050	208002	Front cover (left)
16	323-510-052	208000	Front cover (right)
17	323-600-301	1189	Front cover screw (2 used)
18	323-728-009	208007	Front cover hinge
19	323-622-004	208009	Front cover hinge pin
20	323-634-004	200555	Front cover hinge pin stop ring
21	323-640-015	208010	Front cover hinge spring
22	323-600-034	1459	Front cover hinge pin screw
23	323-600-068	1216	Front cover hinge screw (short) (3 used)
24	323-600-072	5094	Front cover hinge screw (long)
25	323-630-202	5137	Front cover hinge screw (long) nut
26	323-510-030	204650A	Oil cooler cover
27	323-600-072	5094	Oil cooler cover screw (3 used)
28	323-560-014	204799	Right looper lever oil shield
29	323-600-206	5147	Right looper lever oil shield screw
30	323-627-206	204242	Cloth plate rubber
31	323-600-251	5022	Cloth plate rubber screw (3 used)
32	323-627-207	204243	Cloth plate rubber plug
33	323-860-200	201048A	Right needle thread eyelet
34	323-639-225	201072A	Right looper thread tube
35	323-860-213	201048A-1	Right looper thread eyelet
36	323-639-225	201072A	Left looper thread tube
37	323-860-213	201048A-1	Left looper thread eyelet
38	323-860-200	201048A	Chainstitch looper thread eyelet (2 used)
39	323-891-002	204649	Stitch indicator
40	323-628-002	204871	Stitch indicator rivet (2 used)
41	323-800-026	204646	Front cover spacer
42	323-615-018	137906	Front cover hinge screw (short) washer (3 used)
;	323-561-018	204988	Eye guard, complete with parts of Ref. Nos 43-52
43	323-561-019	204924	Eye guard
44	323-600-073	2918	Eye guard screw (2 used)
45	323-630-009	5099	Eye guard screw nut (2 used)
46	323-615-032	204925	Eye guard screw nut washer
47	323-728-012	204922	Eye guard hinge
48	323-600-046	1170-3	Eye guard hinge screw (2 used)
49	323-615-013	200821	Eye guard hinge screw washer (2 used)
50	323-505-012	204982	Eye guard hinge base
51	323-600-227	5003	Eye guard hinge base screw (2 used)
52	323-630-009	5099	Eye guard hinge base screw nut (2 used)

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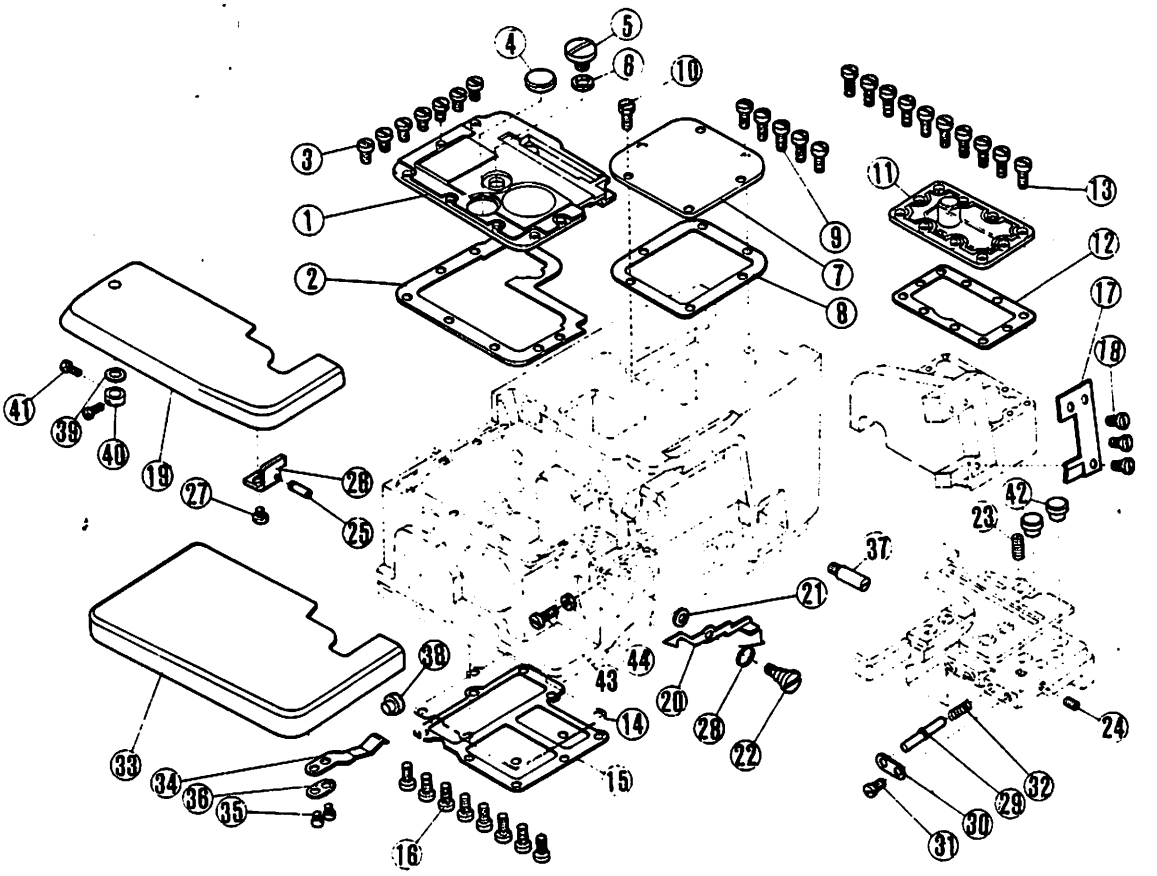
503-514/IV
(1)MAIN FRAME AND MISCELLANEOUS COVERS



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(1) MAIN FRAME AND MISCELLANEOUS COVERS

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION
1	323-800-032	204842	Bedplate
2	323-663-010	204851	Bedplate gasket
3	323-600-014	4009-1	Bedplate screw (7 used)
4	323-627-009	204827	Cloth plate cushion plug (large)
5	323-600-354	5138B	Oil filler plug screw
6	323-615-229	202287A	Oil filler plug screw washer
7	323-510-247	204208	Machine bed cover
8	323-663-208	204209	Machine bed cover gasket
9	323-600-057	5117	Machine bed cover screw (round head) (5 used)
10	323-600-271	2193	Machine bed cover screw (hex. head)
11	323-510-265	204210A	Machine arm (right) cover plate
12	323-663-209	204211	Machine arm (right) cover plate gasket
13	323-600-057	5117	Machine arm (right) cover plate screw (10 used)
14	323-510-237	204212A	Machine bed bottom cover
15	323-800-034	204213A	Machine bed bottom cover plate
16	323-600-057	5117	Machine bed bottom cover plate screw (8 used)
17	323-800-223	202650	Face plate
18	323-600-014	4009-1	Face plate screw (3 used)
19	323-802-002	204740	Cloth plate (narrow) (used with parts of Ref. Nos. 20-32)
20	323-734-003	204742	Cloth plate latch
21	323-618-213	204118	Cloth plate latch spacer
22	323-600-099	5362	Cloth plate latch screw
23	323-600-069	1435	Cloth plate latch adjusting screw
24	323-600-034	1459	Cloth plate latch adjusting screw lock screw
25	323-620-014	204743	Cloth plate latch pin
26	323-740-019	204744	Cloth plate latch pin bracket
27	323-600-032	1202	Cloth plate latch pin bracket screw
28	323-640-007	204745	Cloth plate latch spring
29	323-620-015	204746	Cloth plate push pin
30	323-850-023	204747	Cloth plate push pin guide
31	323-600-015	5053	Cloth plate push pin guide screw
32	323-640-008	204748	Cloth plate push pin spring
33	323-802-003	204798	Cloth plate (wide) (used with parts of Ref. Nos. 34-38)
34	323-734-204	204218	Cloth plate lock spring
35	323-600-068	1216	Cloth plate lock spring screw (2 used)
36	323-615-014	200162	Cloth plate lock spring screw washer
37	323-600-314	5232	Cloth plate lock spring pin-screw
38	323-627-005	204749	Cloth plate cushion plug
39	323-615-201	202576	Cloth plate hinge stud thrust washer
40	323-680-001	201139	Cloth plate hinge stud thrust collar
41	323-600-013	5084	Cloth plate hinge stud thrust collar screw (2 used)
42	323-627-005	204749	Cloth plate cushion plug (small) (2 used)
43	323-600-057	5117	Cloth plate stop screw
44	323-630-001	3044	Cloth plate stop screw nut

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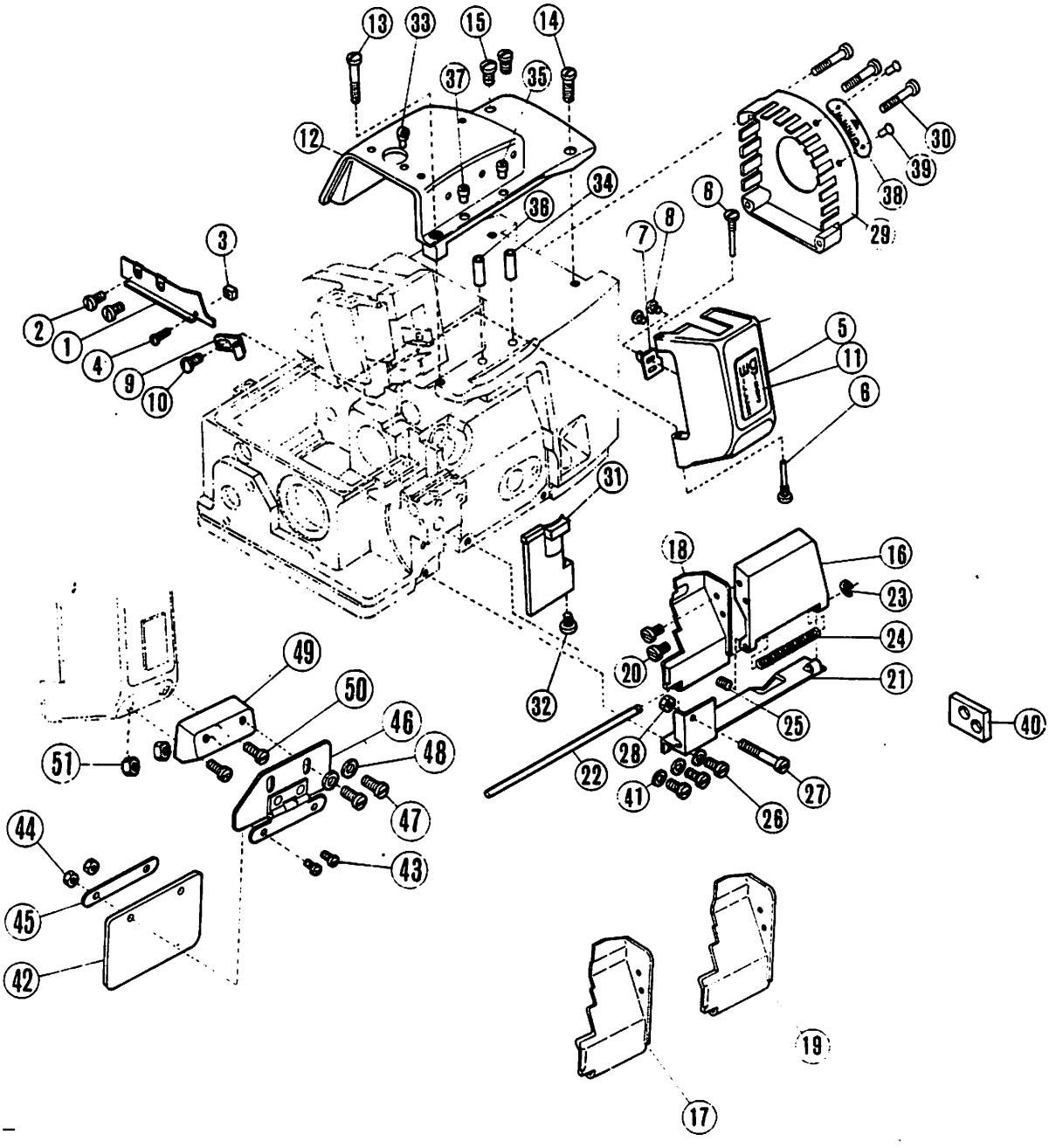
503-514/IV
(2) MAIN FRAME AND
MISCELLANEOUS COVERS



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503-514/IV
(2) MAIN FRAME AND MISCELLANEOUS COVERS

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION
1	323-560-016	204848	Cloth plate fabric guard
2	323-600-014	4009-1	Cloth plate fabric guard screw (2 used)
3	323-646-003	204681	Cloth plate fabric guard spacer
4	323-600-229	2922	Cloth plate fabric guard spacer screw
5	323-510-051	208023	Needle bar cover
6	323-620-240	202653	Needle bar cover hinge pin (2 used)
7	323-641-201	202689	Needle bar cover lock spring
8	323-600-006	1234	Needle bar cover lock spring screw (2 used)
9	323-510-248	204223	Needle bar cover lock spring latch
10	323-600-014	4009-1	Needle bar cover lock spring latch screw
11	323-692-256	204450	Needle bar cover name plate
12	323-510-251	204224	Top cover
13	323-600-072	5094	Top cover screw (long)
14	323-600-038	5095	Top cover screw (medium)
15	323-600-057	5117	Top cover screw (short) (2 used)
16	323-510-052	208000	Front cover (right)
17	323-510-046	208003	Front cover (left) (all 1-needle machines and 2-needle 1.5mm & 2mm gauge machines)
18	323-510-053	208058	Front cover (left) (2-needle 2.5mm & 3mm gauge machines)
19	323-510-048	208005	Front cover (left) (7mm & 8mm gauge)
20	323-600-301	1189	Front cover screw (2 used)
21	323-728-009	208007	Front cover hinge
22	323-622-004	208009	Front cover hinge pin
23	323-634-004	200555	Front cover hinge pin stop ring
24	323-640-015	208010	Front cover hinge spring
25	323-600-034	1459	Front cover hinge pin screw
26	323-600-068	1216	Front cover hinge screw (short) (3 used)
27	323-600-072	5094	Front cover hinge screw (long)
28	323-630-202	5137	Front cover hinge screw (long) nut
29	323-510-030	204650A	Oil cooler cover
30	323-600-072	5094	Oil cooler cover screw (3 used)
31	323-560-014	204799	Right looper lever oil shield
32	323-600-206	5147	Right looper lever oil shield screw
33	323-860-200	201048A	Right needle thread eyelet
34	323-639-225	201072A	Right looper thread tube
35	323-860-213	201048A-1	Right looper thread eyelet
36	323-639-225	201072A	Left looper thread tube
37	323-860-213	201048A-1	Left looper thread eyelet
38	323-891-002	204649	Stitch indicator
39	323-628-002	204871	Stitch indicator rivet
40	323-800-026	204646	Front cover spacer
41	323-615-018	137906	Front cover hinge screw (short) washer (3 used)
	323-561-018	204988	Eye guard, complete with parts of Ref. Nos 42-51
42	323-561-019	204924	Eye guard
43	323-600-073	2918	Eye guard screw (2 used)
44	323-630-009	5099	Eye guard screw nut (2 used)
45	323-615-032	204925	Eye guard screw nut washer
46	323-728-012	204922	Eye guard hinge
47	323-600-046	1170-3	Eye guard hinge screw (2 used)
48	323-615-013	200821	Eye guard hinge screw washer (2 used)
49	323-505-012	204982	Eye guard hinge base
50	323-600-227	5003	Eye guard hinge base screw (2 used)
51	323-630-009	5099	Eye guard hinge base screw nut (2 used)

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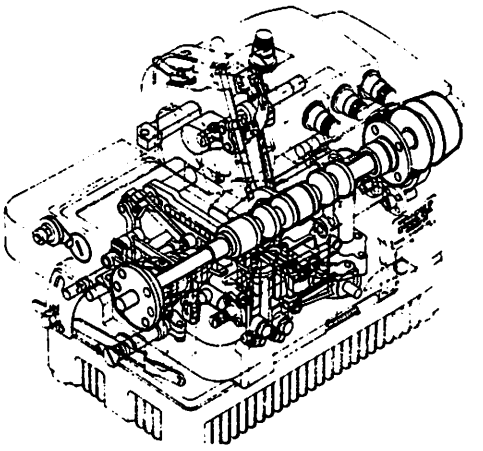
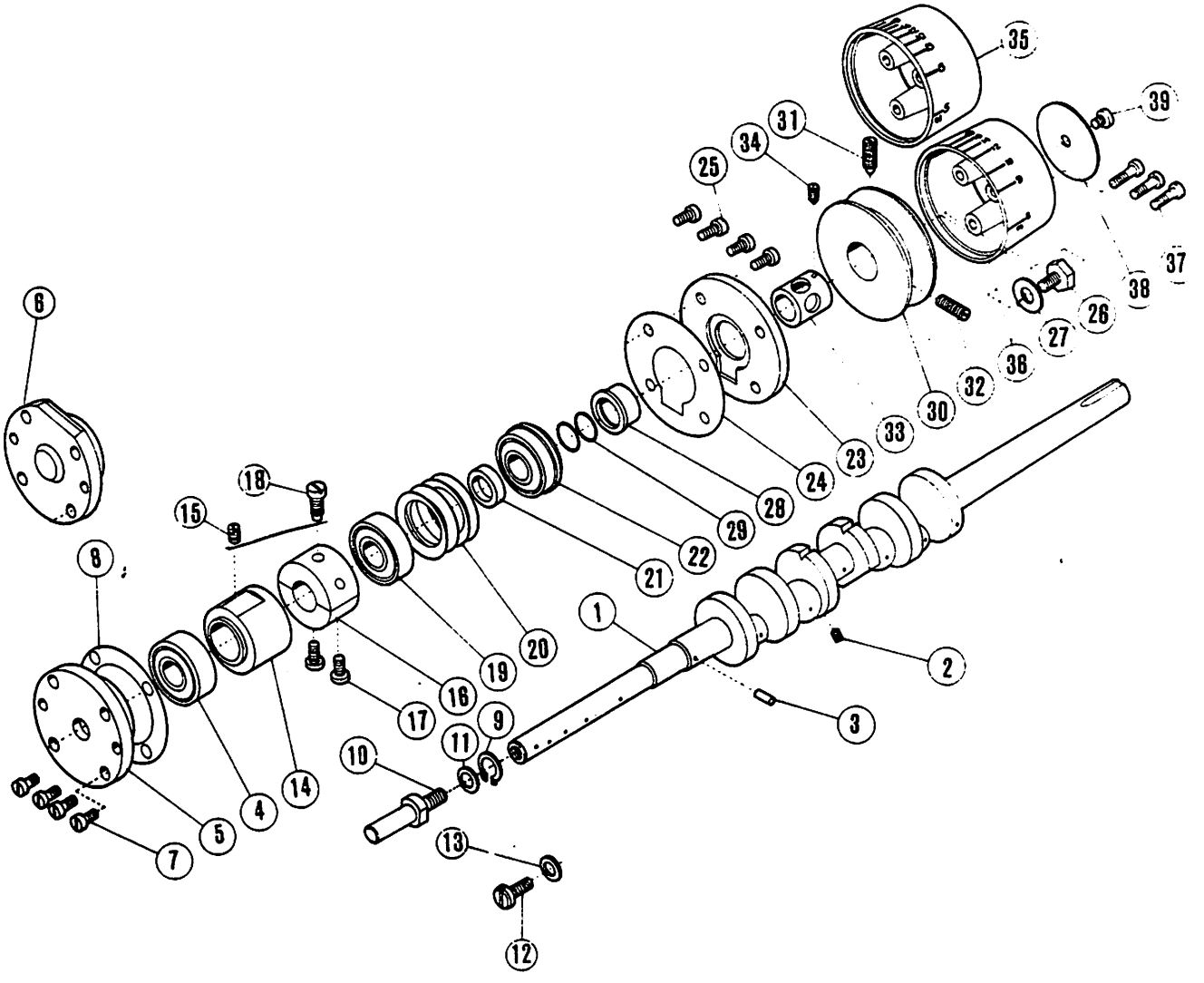
503-516/IV
CRANKSHAFT MECHANISM





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503-516/IV
CRANKSHAFT MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	503/IV 504/IV 514/IV	515/IV 516/IV
1	323-540-015	204733	Crankshaft	x	x
2	323-600-344	5315	Crankshaft oil plug screw	x	x
3	323-653-003	202081	Crankshaft oil wick	x	x
4	323-671-200	204010	Crankshaft ball bearing (left)	x	x
5	323-515-004	204881	Crankshaft ball bearing (left) housing		x
6	323-515-002	204737	Crankshaft ball bearing (left) housing	x	
7	323-600-245	5136	Crankshaft ball bearing (left) housing screw (4 used)	x	x
8	323-663-205	204319	Crankshaft ball bearing (left) housing gasket	x	x
9	323-633-002	204734	Crankshaft ball bearing (left) retaining ring	x	x
10	323-758-003	204873	Crankshaft extension		x
11	323-615-233	204520	Crankshaft extension washer		x
12	323-600-097	5361	Crankshaft ball bearing (left) screw	x	
13	323-615-233	204520	Crankshaft ball bearing (left) screw washer	x	
14	323-676-243	204014	Crankshaft bushing	x	x
15	323-600-043	2022	Crankshaft bushing screw	x	x
16	323-676-232	204016	Crankshaft bushing (center), complete with 1174x2	x	x
17	323-600-027	1174	Crankshaft bushing (center) assembling screw (2 used)	x	x
18	323-600-293	5240	Crankshaft bushing (center) screw	x	x
19	323-671-001	201523A	Crankshaft ball bearing (center)	x	x
20	323-615-217	204018	Crankshaft ball bearing (center) washer (4 used)	x	x
21	323-646-001	204019A	Crankshaft ball bearing (center) spacer	x	x
22	323-671-002	204020A	Crankshaft ball bearing (right)	x	x
23	323-800-224	204021	Crankshaft ball bearing (right) plate	x	x
24	323-626-202	204022	Crankshaft ball bearing (right) plate gasket	x	x
25	323-600-057	5117	Crankshaft ball bearing (right) plate screw (4 used)	x	x
26	323-600-294	5238	Crankshaft ball bearing (right) screw	x	x
27	323-615-221	204023	Crankshaft ball bearing (right) screw washer	x	x
28	323-680-204	204024	Crankshaft oil seal collar	x	x
29	323-632-001	201022	Crankshaft oil seal collar "0" ring (2 used)	x	x
30	323-546-203	204025	Machine pulley	x	x
31	323-600-008	5080	Machine pulley position screw	x	x
32	323-600-009	5081	Machine pulley screw	x	x
33	323-546-204	204026	Machine pulley collar	x	x
34	323-600-295	5267	Machine pulley collar screw	x	x
35	323-780-006	204658	Machine pulley cap – 2:1 diff. feed ratio	x	x
36	323-780-005	204648	Machine pulley cap – 3:1 diff. feed ratio	x	x
37	323-600-010	5010	Machine pulley cap screw (3 used)	x	x
38	323-510-245	204028	Machine pulley cap name plate	x	x
39	323-600-209	5214	Machine pulley cap name plate screw	x	x

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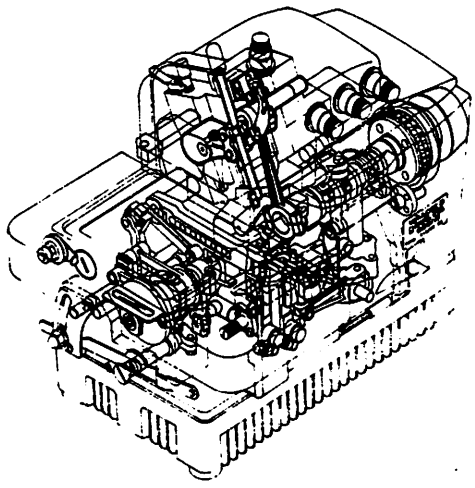
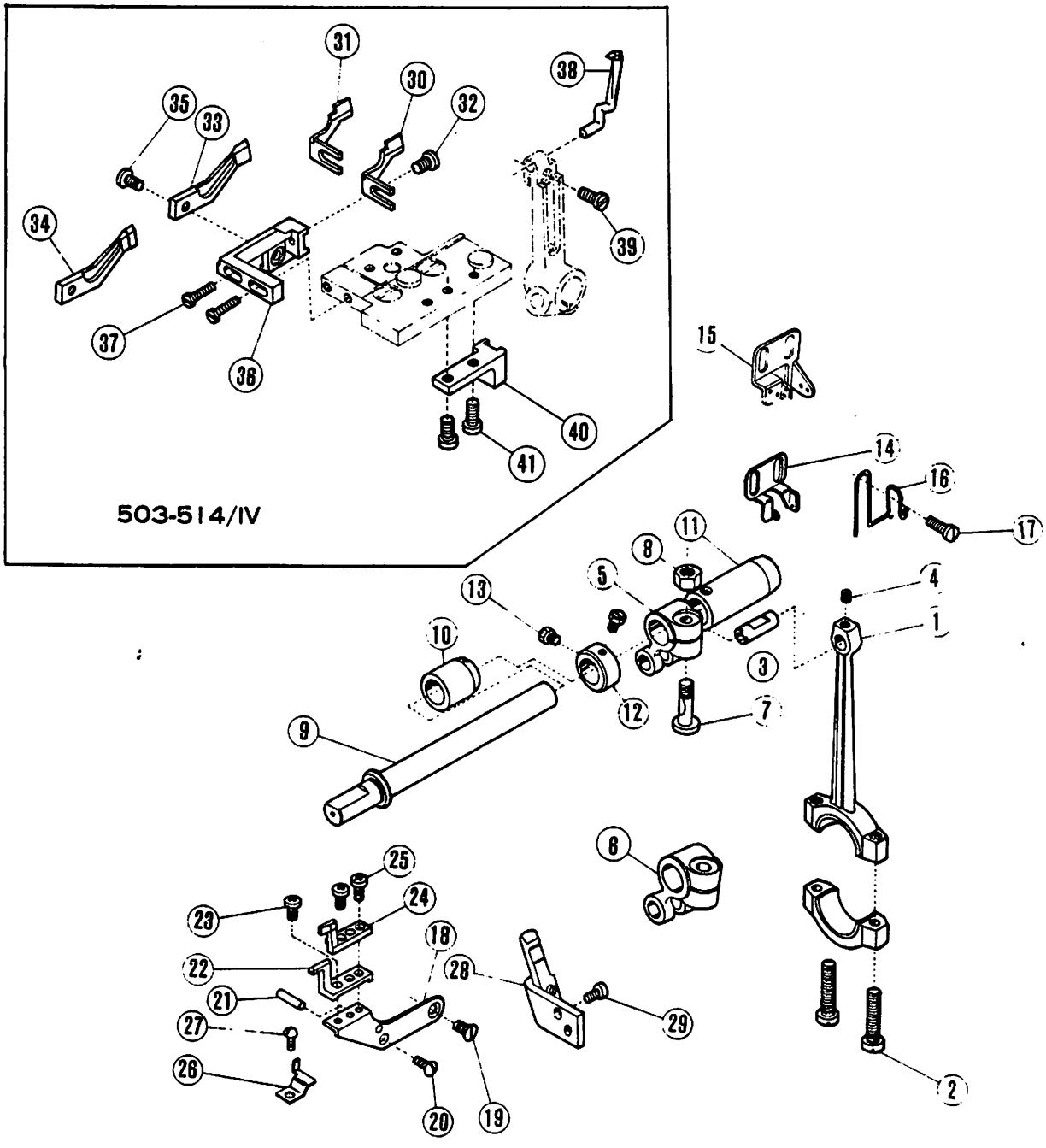
503-516/IV
(1) NEEDLE DRIVE MECHANISM





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503-516/IV
(1) NEEDLE DRIVE MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	503/IV 504/IV 514/IV	515/IV 516/IV
1	323-535-205	204029	Needle bar drive connection	x	x
2	323-600-296	5233	Needle bar drive connection cap screw (2 used)	x	x
3	323-620-237	202711A	Needle bar drive connection pin	x	x
4	323-600-297	5234	Needle bar drive connection pin screw	x	x
5	323-576-004	201360A	Needle bar drive crank (right) (515-516/IV – except 515-516/IV-51 & -52) (503-504/IV – except 504/IV-S-10)		
6	323-576-005	201441A	Needle bar drive crank (right) (514/IV. 515-516/IV-51 & -52. 504/IV-S-10)		
7	323-600-040	5087	Needle bar drive crank (right) clamp screw	x	x
8	323-630-005	5181	Needle bar drive crank (right) clamp screw nut	x	x
9	323-540-232	204031	Needle bar drive shaft	x	x
10	323-676-233	204032	Needle bar drive shaft bushing (left)	x	x
11	323-676-028	204033A	Needle bar drive shaft bushing (right)	x	x
12	323-618-006	201117	Needle bar drive shaft thrust collar	x	x
13	323-600-013	5084	Needle bar drive shaft thrust collar screw (2 used)	x	x
14	323-851-213	204276	Needle thread guide		x
15	323-851-222	202704	Needle thread guide	x	
16	323-851-215	204046	Needle thread guide wire	x	x
17	323-600-014	4009-1	Needle thread guide wire screw	x	x
18	323-740-023	204783	Needle guard bracket		x
19	323-600-228	5061	Needle guard bracket screw (large)		x
20	323-600-302	5227	Needle guard bracket screw (small)		x
21	323-639-019	204657	Right looper thread tube (left)		x
22	*323-561-013	204781	Needle guard (rear), for right needle		x
23	323-600-255	5012	Needle guard (rear) screw		x
24	*323-561-014	204782	Needle guard (front), for right needle		x
25	323-600-256	5029	Needle guard (front) screw (2 used)		x
26	*323-561-xxx		Needle guard (front), for left needle		x
27	323-600-302	5227	Needle guard (front) screw		x
28	*323-561-xxx		Needle guard (rear), for left needle		x
29	323-600-021	1206	Needle guard (rear) screw		x
30	*323-561-xxx		Needle guard (front) – 503-504/IV		
31	*323-561-xxx		Needle guard (front) – 514/IV		
32	323-600-021	1206	Needle guard (front) screw	x	
33	*323-561-xxx		Needle guard (rear) – 503-504/IV		
34	*323-561-xxx		Needle guard (rear) – 514/IV		
35	323-600-021	1206	Needle guard (rear) screw	x	
36	323-740-018	204636	Needle guard bracket	x	
37	323-600-027	1174	Needle guard bracket screw (2 used)	x	
38	323-561-017	204884	Movable type needle guard – optional item (514/IV)		
39	323-600-245	5136	Movable type needle guard screw		
40	323-740-037	204762	Edge guide holder bracket base	x	
41	323-600-019	1175-3	Edge guide holder bracket base screw (2 used)	x	

*See Organization Chart

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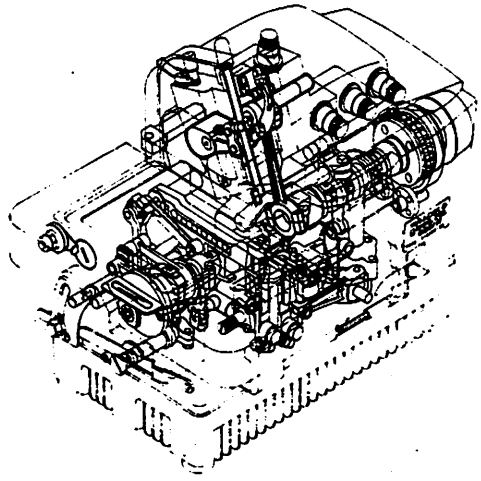
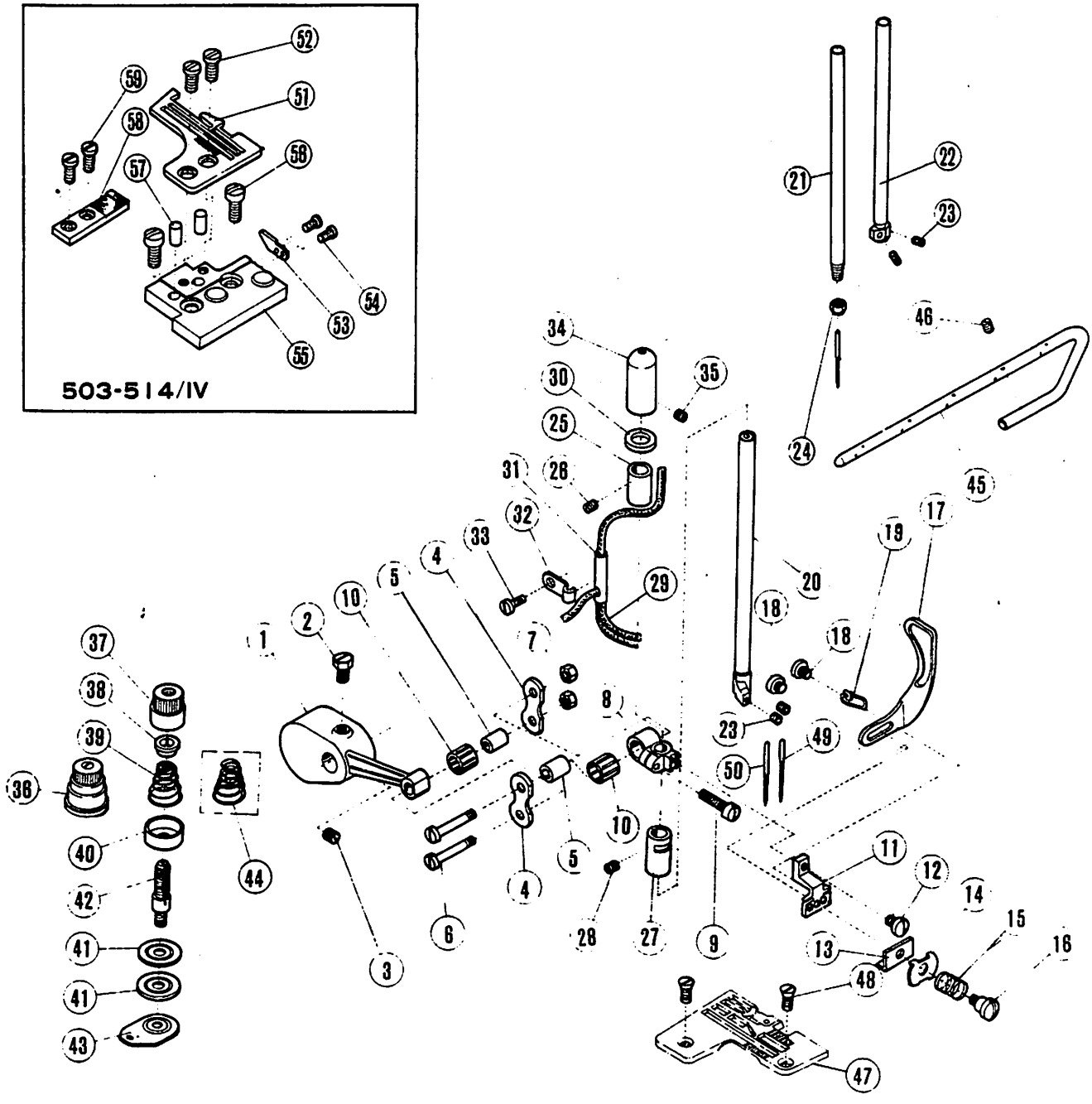
503-516/IV
(2) NEEDLE DRIVE MECHANISM





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503-516/IV
(2) NEEDLE DRIVE MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	503/IV 504/IV 514/IV	515/IV 516/IV
1	323-576-218	202607	Needle bar drive crank (left)	x	x
2	323-600-022	2022-4	Needle bar drive crank (left) screw (with head)	x	x
3	323-600-043	2022	Needle bar drive crank (left) screw	x	x
4	323-730-005	204628	Needle bar connecting link (2 used)	x	x
5	323-676-244	202609	Needle bar connecting link bushing (2 used)	x	x
6	323-600-299	5154	Needle bar connecting link bushing screw (2 used)	x	x
7	323-630-009	5099	Needle bar connecting link bushing screw nut (2 used)	x	x
8	323-740-218	202610	Needle bar connecting bracket	x	x
9	323-600-046	1170-3	Needle bar connecting bracket screw	x	x
10	323-670-200	202611	Needle bar connecting bracket bearing	x	x
11	323-740-016	202705A	Needle thread retainer bracket	x	x
12	323-600-091	5359	Needle thread retainer bracket screw	x	x
13	323-850-021	202495	Needle thread retainer guide spacer	x	x
14	323-850-221	200041	Needle thread retainer guide	x	x
15	323-640-203	200205	Needle thread retainer spring	x	x
16	323-600-224	9070-2	Needle thread retainer spring screw	x	x
17	323-866-214	202706A	Needle thread takeup	x	x
18	323-600-300	5299	Needle thread takeup screw (2 used)	x	x
19	323-851-212	204235	Needle thread guide wire		x
20	*323-843-xxx		Needle bar		x
21	*323-843-xxx		Needle bar	x	
22	*323-843-xxx		Needle bar	x	
23	323-600-341	5292	Needle clamp screw (2 used)	x	x
24	323-630-213	3119	Needle clamp nut	x	
25	323-676-025	204625A	Needle bar bushing (upper)	x	x
26	323-600-012	1457	Needle bar bushing (upper) screw	x	x
27	323-676-263	204627A	Needle bar bushing (lower)	x	x
28	323-600-012	1457	Needle bar bushing (lower) screw	x	x
29	323-653-005	202176	Needle bar bushing oil wick	x	x
30	323-686-009	204626	Needle bar bushing oil wick clamp	x	x
31	323-638-200	201436	Needle bar bushing oil wick tube	x	x
32	323-686-200	201437	Needle bar bushing oil wick tube clamp	x	x
33	323-600-039	5113	Needle bar bushing oil wick tube clamp screw	x	x
34	323-510-240	202615	Needle bar cap cover	x	x
35	323-600-012	1457	Needle bar cap cover screw	x	x
36	323-900-200	202478	Needle thread tension, complete with 201035A, 202278, 201037, 201039, 201482x2 & 5082A (for 3-thread overlock stitch)	x	x
37	323-630-200	201035A	Needle thread tension nut	x	x
38	323-676-202	202278	Needle thread tension spring bushing	x	x
39	323-642-001	201037	Needle thread tension spring (heavy)	x	x
40	323-780-002	201039	Needle thread tension spring cup	x	x
41	323-613-001	201482	Needle thread tension disc (2 used)	x	x
42	323-604-201	5082A	Needle thread tension post	x	x
43	323-800-215	202849	Needle thread tension guide	x	x
	323-900-201	202479	Needle thread tension, complete with 201035A, 202278, 201068, 201039, 201482x2 & 5082A (for 2-thread overlock stitch)		
44	323-642-002	201068	Needle thread tension spring (light)	x	x
45	323-851-216	204045	Top cover thread guide bar	x	x
46	323-600-303	5185	Top cover thread guide bar screw	x	x
47	*323-801-xxx		Needle plate		x
48	323-600-075	1732	Needle plate screw (2 used)		x
49	*		Needle (right)	x	x
50	*		Needle (left)		x
51	*323-801-xxx		Needle plate	x	
52	323-600-014	4009-1	Needle plate screw (2 used)	x	
53	323-649-003	204631	Needle plate key	x	
54	323-600-304	5239	Needle plate key screw (2 used)	x	
55	323-740-017	204750	Needle plate bracket	x	
56	323-600-098	5357	Needle plate bracket screw (2 used)	x	
57	323-620-017	204630	Needle plate bracket guide pin (2 used)	x	
58	323-756-003	204632	Needle plate support	x	
59	323-600-257	5091	Needle plate support screw (2 used)	x	

*See Organization Chart

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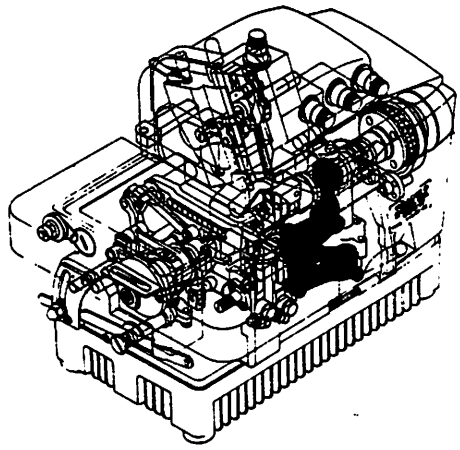
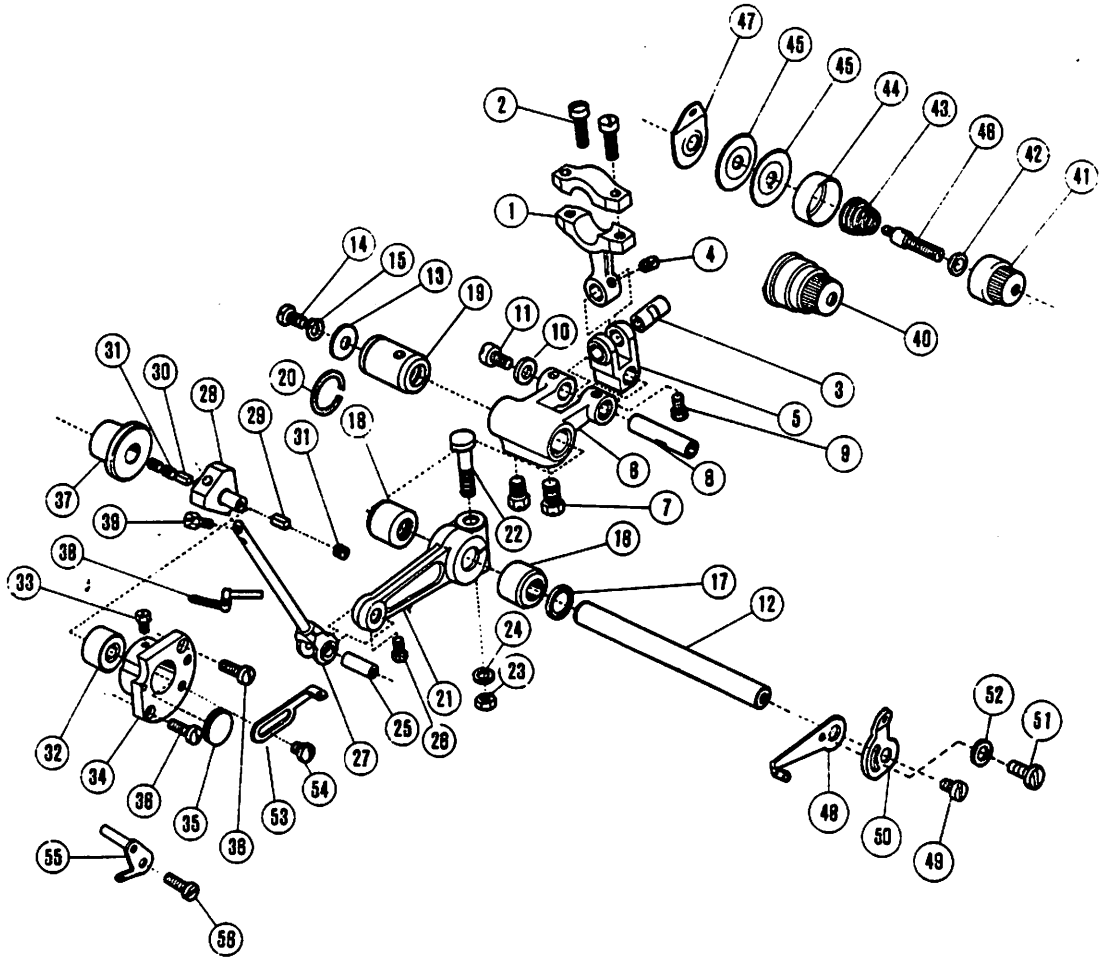
503-516/IV
RIGHT LOOPER DRIVE MECHANISM





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503-516/IV
RIGHT LOOPER DRIVE MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	503/IV 504/IV 514/IV	515/IV 516/IV
1	323-730-208	204292	Right looper drive connection	x	x
2	323-600-056	2213-1	Right looper drive connection cap screw (2 used)	x	x
3	323-620-237	202711A	Right looper drive crank pin	x	x
4	323-600-012	1457	Right looper drive crank pin screw	x	x
5	323-730-209	202709A	Right looper drive connecting link	x	x
6	323-576-217	204332	Right looper drive crank	x	x
7	323-600-022	2022-4	Right looper drive crank screw (2 used)	x	x
8	323-620-238	202712A	Right looper drive crank pin	x	x
9	323-600-013	5084	Right looper drive crank pin screw	x	x
10	323-615-218	202757	Right looper drive crank pin thrust washer	x	x
11	323-600-068	1216	Right looper drive crank pin thrust washer screw	x	x
12	323-540-228	204069A	Right looper lever shaft	x	x
13	323-618-210	204311	Right looper lever shaft thrust washer	x	x
14	323-600-271	2193	Right looper lever shaft thrust washer screw	x	x
15	323-617-200	202286	Right looper lever shaft thrust washer screw washer	x	x
16	323-676-234	204050A	Right looper lever shaft bushing (front)	x	x
17	323-626-201	204052A	Right looper lever shaft bushing (front) oil seal	x	x
18	323-676-236	204081	Right looper lever shaft bushing (center)	x	x
19	323-676-262	204437	Right looper lever shaft bushing (rear), complete with 204438	x	x
20	323-632-203	204438	Right looper lever shaft bushing (rear) stop ring	x	x
21	323-525-229	204055A	Right looper lever crank	x	x
22	323-630-304	5239	Right looper lever crank clamp screw	x	x
23	323-600-225	5286	Right looper lever crank clamp screw nut	x	x
24	323-617-204	202045	Right looper lever crank clamp screw nut washer	x	x
25	323-620-237	202711A	Right looper lever crank pin	x	x
26	323-600-013	5084	Right looper lever crank pin screw	x	x
27	323-530-224	204057A	Right looper lever	x	x
28	323-851-009	204732	Right looper lever guide	x	x
29	323-653-208	204273	Right looper lever guide oil wick (long)	x	x
30	323-653-209	204274	Right looper lever guide oil wick (short)	x	x
31	323-600-041	1457-1	Right looper lever guide oil plug screw (3 used)	x	x
	323-676-029	204854	Right looper lever guide bushing (front) housing, complete with 204059, 5084 & 204060	x	x
32	323-676-248	204059	Right looper lever guide bushing (front)	x	x
33	323-600-013	5084	Right looper lever guide bushing (front) screw	x	x
34	323-515-202	204060	Right looper lever guide bushing (front) housing	x	x
35	323-627-205	204004	Right looper lever guide bushing (front) housing cap	x	x
36	323-600-002	1175-2	Right looper lever guide bushing (front) housing screw (2 used)	x	x
37	323-676-249	204061	Right looper lever guide bushing (rear)	x	x
38	* 323-810-xxx		Right looper	x	x
39	323-600-291	5220	Right looper screw	x	x
40	323-900-202	202480	Right looper thread tension, complete with 201035A, 202278, 201086, 201039, 201482x2 & 5082A	x	x
41	323-630-200	201035A	Right looper thread tension nut	x	x
42	323-676-202	202278	Right looper thread tension spring bushing	x	x
43	323-642-003	201086	Right looper thread tension spring (middle)	x	x
44	323-780-002	201039	Right looper thread tension spring cup	x	x
45	323-613-001	201482	Right looper thread tension disc (2 used)	x	x
46	323-604-201	5082A	Right looper thread tension post	x	x
47	323-800-215	202849	Right looper thread tension guide	x	x
48	323-866-011	204063A	Right looper thread takeup (large)	x	x
49	323-600-259	2902	Right looper thread takeup (large) screw	x	x
50	323-866-013	204902	Right looper thread takeup (small)	x	x
51	323-600-026	2921	Right looper thread takeup (small) screw	x	x
52	323-615-216	202875	Right looper thread takeup (small) screw washer	x	x
53	323-851-018	204905	Right looper thread guide	x	x
54	323-600-074	2905	Right looper thread guide screw	x	x
55	323-851-019	204903	Looper thread guide	x	
56	323-600-255	5012	Looper thread guide screw	x	

*See Organization Chart

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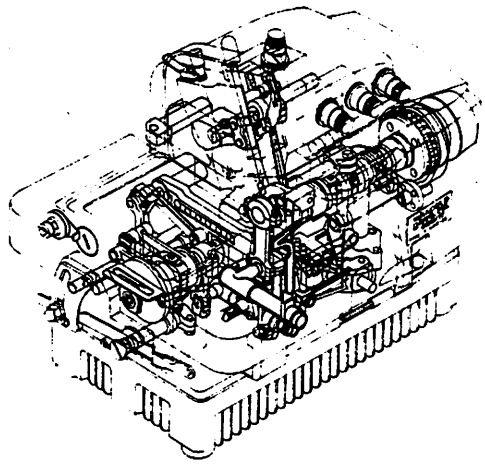
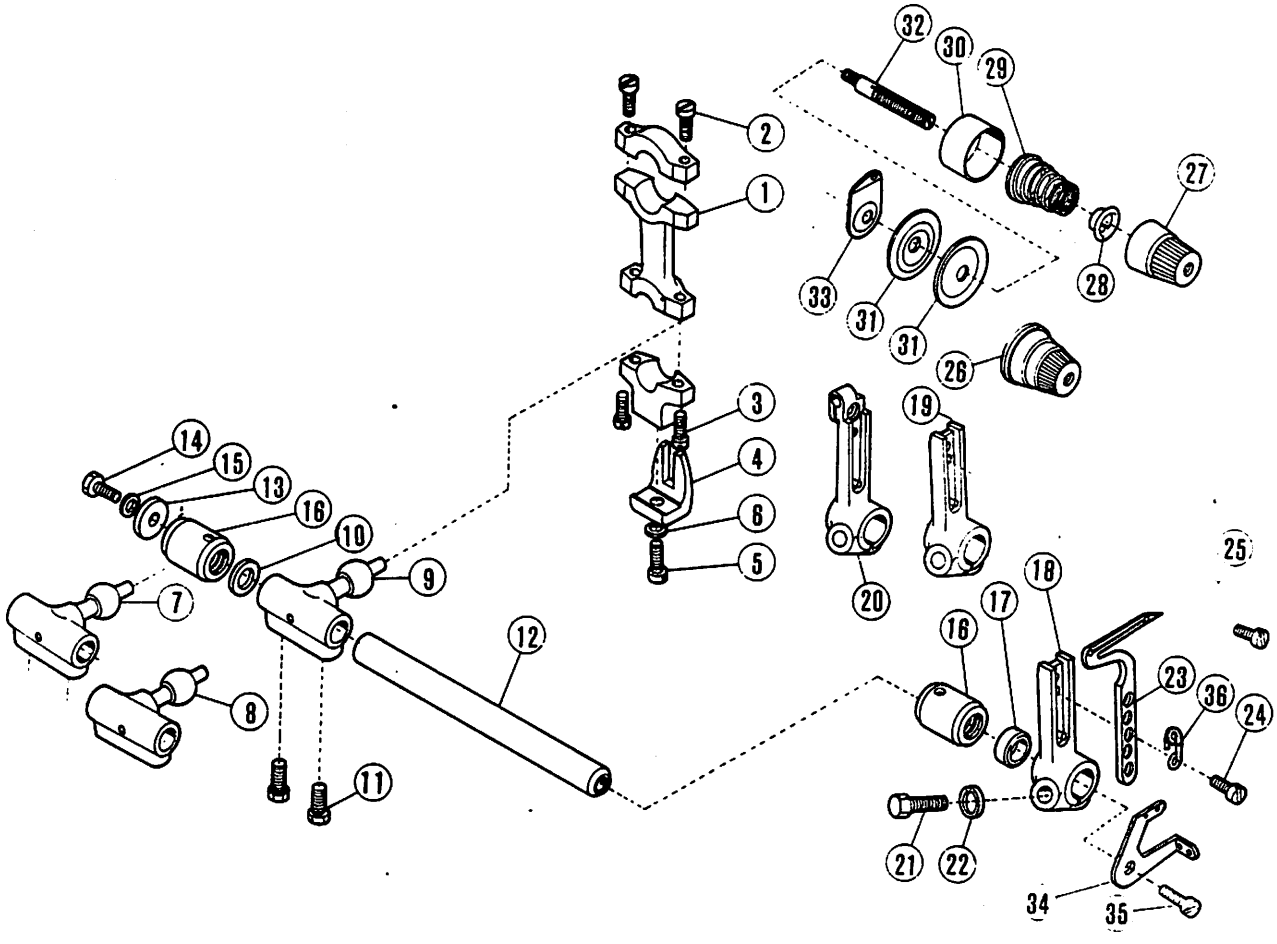
503-516/IV
LEFT LOOPER DRIVE MECHANISM





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503-516/IV
LEFT LOOPER DRIVE MECHANISM

REF. NO	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	503/IV 504/IV 514/IV	515/IV 516/IV
1	323-525-230	204047	Left looper drive connection	x	x
2	323-600-056	2213-1	Left looper drive connection cap screw (large) (2 used)	x	x
3	323-600-020	1170-1	Left looper drive connection cap screw (small) (2 used)	x	x
4	323-850-200	201074A	Left looper drive connection guide	x	x
5	323-600-200	1156	Left looper drive connection guide screw	x	x
6	323-617-200	202286	Left looper drive connection guide screw washer	x	x
7	323-576-006	204787	Left looper drive crank (503-504/IV – except 504/IV-S-10)		
8	323-576-007	204788	Left looper drive crank (514/IV. 504/IV-S-10)		
9	323-576-213	204048A	Left looper drive crank (515-516/IV)		x
10	323-618-010	204789	Left looper drive crank thrust washer	x	x
11	323-600-022	2022-4	Left looper drive crank screw (2 used)	x	x
12	323-540-228	204069A	Left looper lever shaft	x	x
13	323-618-210	204311	Left looper lever shaft thrust washer	x	x
14	323-600-271	2193	Left looper lever shaft thrust washer screw	x	x
15	323-617-200	202286	Left looper lever shaft thrust washer screw washer	x	x
16	323-676-235	204054	Left looper lever shaft bushing (2 used)	x	x
17	323-626-201	204052A	Left looper lever shaft bushing oil seal	x	x
18	323-530-225	204071	Left looper lever		x
19	323-530-010	204664	Left looper lever	x	
20	323-530-017	204853	Left looper lever – optional item. used with movable type needle guard #204884		
21	323-600-306	5284	Left looper lever clamp screw	x	x
22	323-616-200	204293	Left looper lever clamp screw washer	x	x
23	*323-810-xxx		Left looper		
24	323-600-301	1189	Left looper screw	x	
25	323-600-019	1175-3	Left looper screw		x
26	323-900-202	202480	Left looper thread tension, complete with 201035A 202278, 201086, 201039, 201482x2 & 5082A	x	x
27	323-630-200	201035A	Left looper thread tension nut	x	x
28	323-676-202	202278	Left looper thread tension spring bushing	x	x
29	323-642-003	201086	Left looper thread tension spring (middle)	x	x
30	323-780-002	201039	Left looper thread tension spring cup	x	x
31	323-613-001	201482	Left looper thread tension disc (2 used)	x	x
32	323-604-201	5082A	Left looper thread tension post	x	x
33	323-800-215	202849	Left looper thread tension guide	x	x
34	323-866-012	204901	Left looper thread takeup	x	x
35	323-600-259	2902	Left looper thread takeup screw	x	x
36	323-851-217	193174	Left looper thread guide wire	x	x

*See Organization Chart

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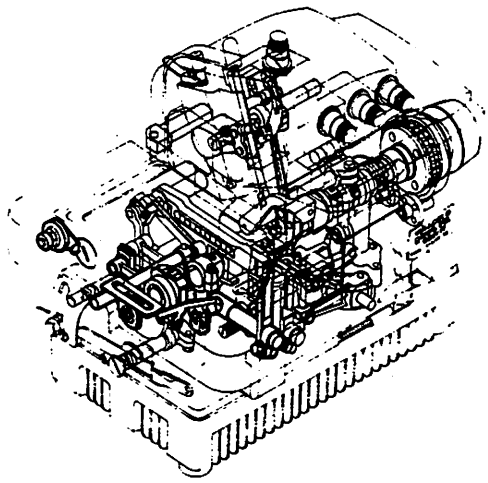
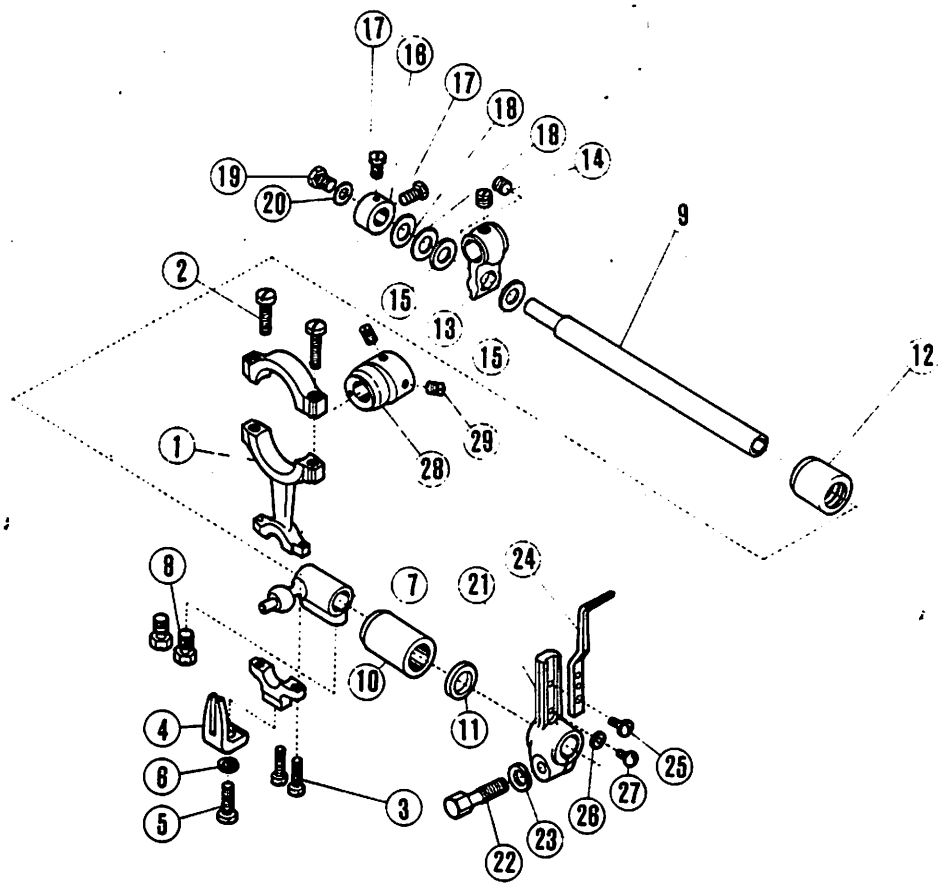
515-516/IV
(1) CHAINSTITCH LOOPER DRIVE MECHANISM





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515-516/IV
(1) CHAINSTITCH LOOPER DRIVE MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION
1	323-525-231	204075	Looper drive connection
2	323-600-296	5233	Looper drive connection cap screw (large) (2 used)
3	323-600-020	1170-1	Looper drive connection cap screw (small) (2 used)
4	323-850-200	201074A	Looper drive connection guide
5	323-600-200	1156	Looper drive connection guide screw
6	323-617-200	202286	Looper drive connection guide screw washer
7	323-576-219	204076	Looper drive crank
8	323-600-022	2022-4	Looper drive crank screw (2 used)
9	323-540-225	204079	Looper drive shaft
10	323-540-234	204080	Looper drive shaft bushing (front)
11	323-626-201	204052A	Looper drive shaft bushing (front) oil seal
12	323-676-236	204081	Looper drive shaft bushing (rear)
13	323-730-211	204090	Looper avoiding link
14	323-600-043	2022	Looper avoiding link screw (2 used)
15	323-618-206	204091	Looper avoiding link thrust washer (2 used)
16	323-680-206	204092	Looper avoiding link collar
17	323-600-013	5084	Looper avoiding link collar screw (2 used)
18	323-643-209	204233	Looper avoiding link spring (2 used)
19	323-600-271	2193	Looper avoiding link spring screw
20	323-615-012	201185	Looper avoiding link spring screw washer
21	323-530-226	204093	Looper lever
22	323-600-306	5284	Looper lever clamp screw
23	323-616-200	204293	Looper lever clamp screw washer
24	*323-810-217	204314A	Looper, for 2 & 3mm needle gauge
	*323-810-219	204431	Looper, for 5mm needle gauge
25	323-600-301	1189	Looper screw
26	323-716-208	204172	Looper regulator
27	323-600-048	1333	Looper regulator screw
28	323-580-208	204077	Looper drive eccentric, complete with 204078
	323-540-233	204078	Looper drive eccentric pin
29	323-600-043	2022	Looper drive eccentric screw (2 used)

*See Organization Chart

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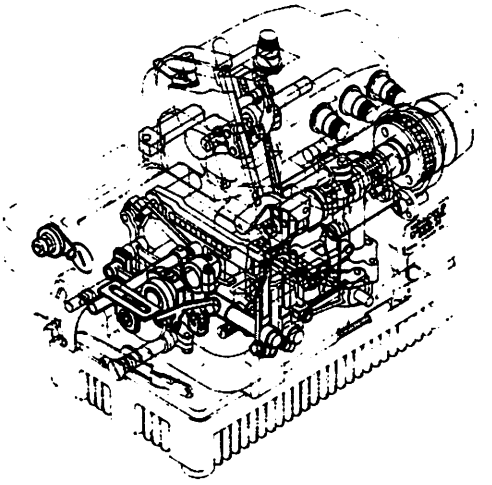
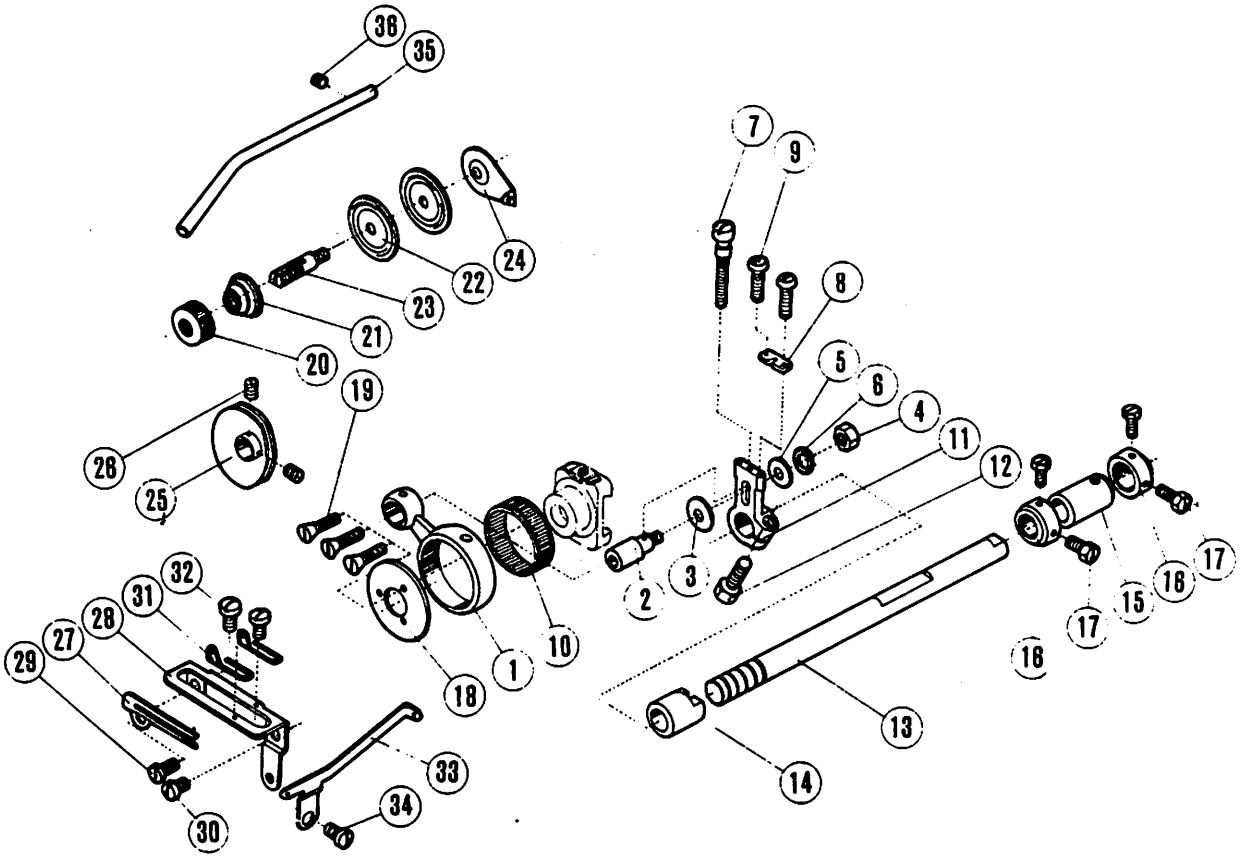
515-516/IV
(2) CHAINSTITCH LOOPER DRIVE MECHANISM





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515-516/IV
(2) CHAINSTITCH LOOPER DRIVE MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION
1	323-525-239	204082A	Looper avoiding connection
2	323-620-253	204519	Looper avoiding connection pin
3	323-615-233	204520	Looper avoiding connection pin washer
4	323-630-001	3044	Looper avoiding connection pin nut
5	323-618-211	204115	Looper avoiding connection pin nut washer
6	323-617-200	202286	Looper avoiding connection pin nut spring washer
7	323-600-358	5333	Looper avoiding regulating screw
8	323-625-201	204518	Looper avoiding regulating screw plate
9	323-600-229	2922	Looper avoiding regulating screw plate screw (2 used)
10	323-672-200	204084	Looper avoiding regulating needle bearing
11	323-576-225	204517	Looper avoiding crank
12	323-600-801	5381	Looper avoiding crank clamp screw
13	323-540-024	204874	Looper avoiding shaft
14	323-676-038	204875	Looper avoiding shaft bushing (left)
15	323-676-250	204089	Looper avoiding shaft bushing (right)
16	323-618-003	201056	Looper avoiding shaft thrust collar (2 used)
17	323-600-013	5084	Looper avoiding shaft thrust collar screw (4 used)
18	323-680-205	204087	Looper avoiding eccentric collar
19	323-600-305	5224	Looper avoiding eccentric collar screw (3 used)
20	323-630-015	3056	Looper thread tension nut
21	323-642-201	167077	Looper thread tension spring
22	323-613-001	201482	Looper thread tension disc (2 used)
23	323-604-229	167072	Looper thread tension post
24	323-800-215	202849	Looper thread tension guide
25	323-866-213	204095A	Looper thread takeup
26	323-600-341	5292	Looper thread takeup screw (2 used)
27	323-850-246	204096	Looper thread takeup guide
28	323-740-032	204097A	Looper thread guide bracket
29	323-600-014	4009-1	Looper thread guide bracket screw (long)
30	323-600-039	5113	Looper thread guide bracket screw (short)
31	323-860-215	204324	Looper thread takeup eyelet (2 used)
32	323-600-307	5077	Looper thread takeup eyelet screw (2 used)
33	323-851-219	204098	Looper thread guide
34	323-600-039	5113	Looper thread guide screw
35	323-851-220	204099	Looper thread tube
36	323-600-012	1457	Looper thread tube screw

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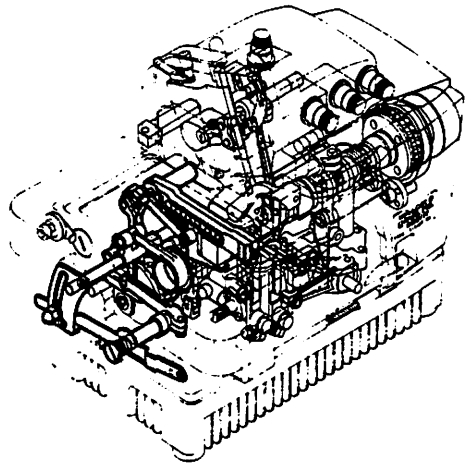
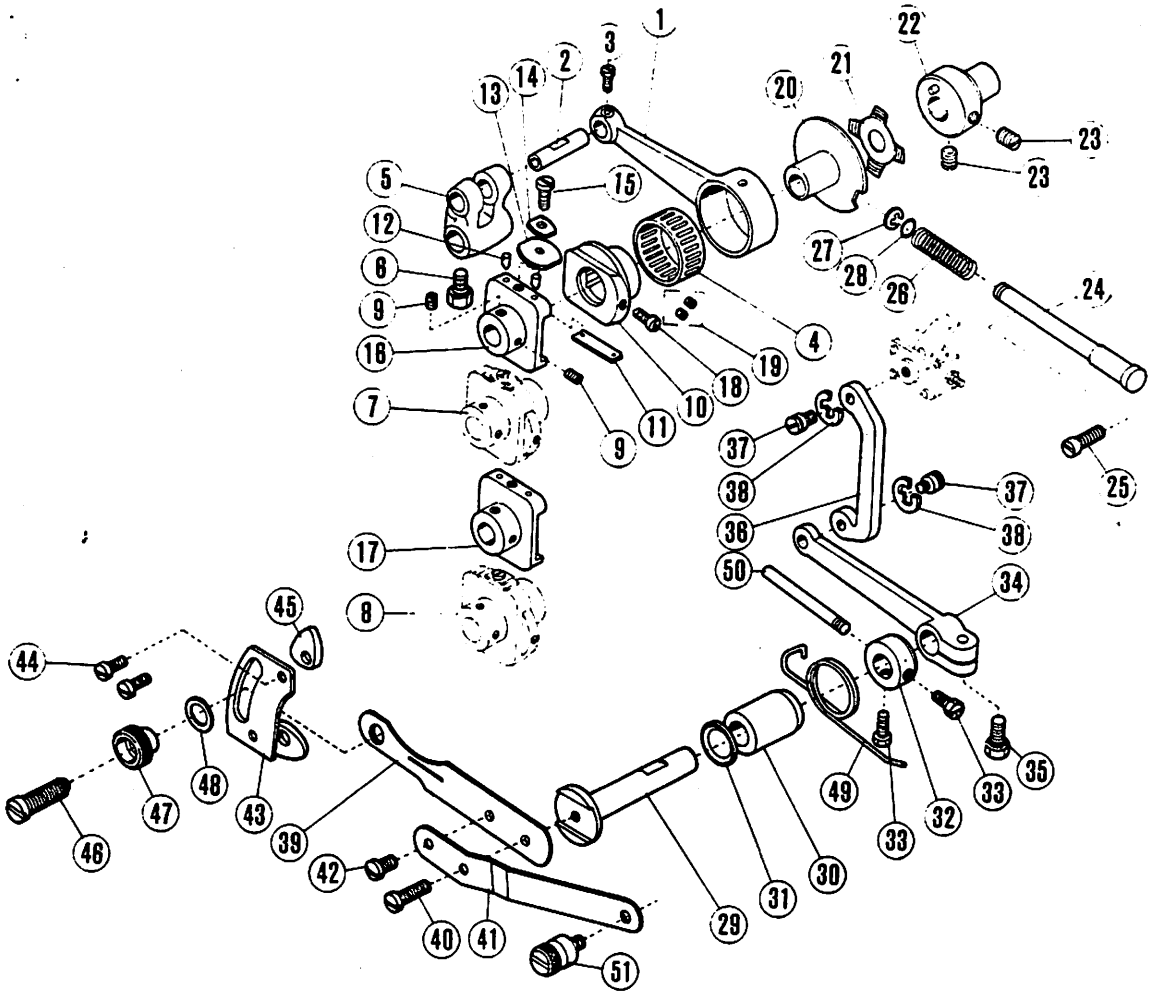
503-516/IV
(1) MAIN AND DIFFERENTIAL FEED MECHANISM





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503-516/IV
(1) MAIN AND DIFFERENTIAL FEED MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	503/IV 504/IV 514/IV	515/IV 516/IV
1	323-525-232	204100	Feed drive connection	x	x
2	323-620-237	202711A	Feed drive connection pin	x	x
3	323-600-013	5084	Feed drive connection pin screw	x	x
4	323-672-200	204084	Feed drive connection needle bearing	x	x
5	323-576-220	204085	Feed drive crank	x	x
6	323-600-801	5381	Feed drive crank clamp screw	x	x
7	323-750-206	204352	Feed & looper eccentric, complete with 204101A 204353, 204354x2, 204355, 204356, 1196 & 204086B		x
8	323-900-013	204736	Feed eccentric, complete with 204101A, 204353, 204354x2, 204355, 204356, 1196 & 204735	x	
9	323-600-351	5312	Feed (& looper) eccentric screw (2 used)	x	x
10	323-580-211	204101A	Feed eccentric	x	x
11	323-787-202	204353	Feed eccentric liner	x	x
12	323-620-251	204354	Feed eccentric liner pin (2 used)	x	x
13	323-643-213	204355	Feed eccentric liner spring plate (large)	x	x
14	323-643-214	204356	Feed eccentric liner spring plate (small)	x	x
15	323-600-029	1196	Feed eccentric liner spring plate screw	x	x
16	323-580-210	204086B	Chainstitch looper eccentric		x
17	323-686-010	204735	Feed eccentric retainer	x	
18	323-600-068	1216	Feed eccentric stop screw (for 2:1 diff. feed ratio)	x	x
19	323-600-034	1459	Feed eccentric oil plug (for 3:1 diff. feed ratio)	x	x
20	323-716-215	204102A	Feed eccentric regulator	x	x
21	323-643-212	204357	Feed eccentric latch spring	x	x
22	323-680-006	204637	Feed eccentric regulator collar, complete with 204078	x	
23	323-600-043	2022	Feed eccentric regulator collar screw (2 used)	x	
	323-540-233	204078	Feed eccentric regulator collar pin	x	
24	323-535-212	204134A	Feed eccentric push rod	x	x
25	323-600-215	2133-1	Feed eccentric push rod screw	x	x
26	323-640-218	204135	Feed eccentric push rod spring	x	x
27	323-634-200	202522	Feed eccentric push rod stop ring	x	x
28	323-632-201	204185	Feed eccentric push rod "o" ring	x	x
29	323-540-017	204752	Diff. feed shaft	x	x
30	323-676-027	204753	Diff. feed shaft bushing	x	x
31	323-626-201	204052A	Diff. feed shaft bushing oil seal	x	x
32	323-680-007	204754	Diff. feed shaft thrust collar	x	x
33	323-600-013	5084	Diff. feed shaft thrust collar screw (2 used)	x	x
34	323-502-213	204139A	Diff. feed shaft arm	x	x
35	323-600-801	5381	Diff. feed shaft arm clamp screw	x	x
36	323-730-214	204140A	Diff. feed link	x	x
37	323-600-347	5316	Diff. feed link screw, complete with 204498 (2 used)	x	x
38	323-634-200	202522	Diff. feed link screw retaining ring (2 used)	x	x
39	323-530-011	204755	Diff. feed regulating lever (rear)	x	x
40	323-600-060	5118	Diff. feed regulating lever (rear) screw	x	x
41	323-530-018	204883	Diff. feed regulating lever (front)	x	x
42	323-600-068	1216	Diff. feed regulating lever (front) screw	x	x
43	323-800-036	204142B	Diff. feed regulating lever guide	x	x
44	323-600-060	5118	Diff. feed regulating lever guide screw (2 used)	x	x
45	323-891-200	204143A	Diff. feed regulating lever lift guide (2 used)	x	x
46	323-600-083	5321A	Diff. feed regulating lever adjusting screw	x	x
47	323-630-017	204870	Diff. feed regulating lever adjusting nut	x	x
48	323-618-209	202868	Diff. feed regulating lever adjusting nut washer	x	x
49	323-640-006	204756	Diff. feed regulating spring	x	x
50	323-600-102	204757	Diff. feed regulating spring latch screw	x	x
51	323-600-107	204869	Knee controller chain hook latch screw	x	x

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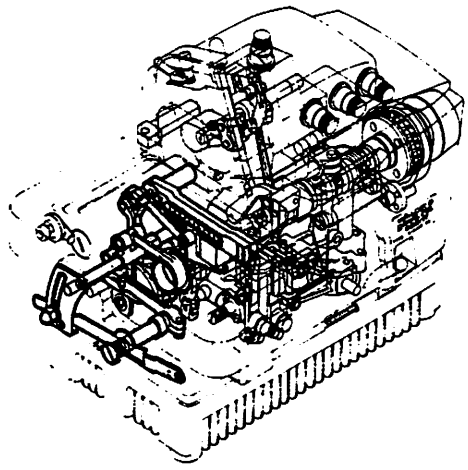
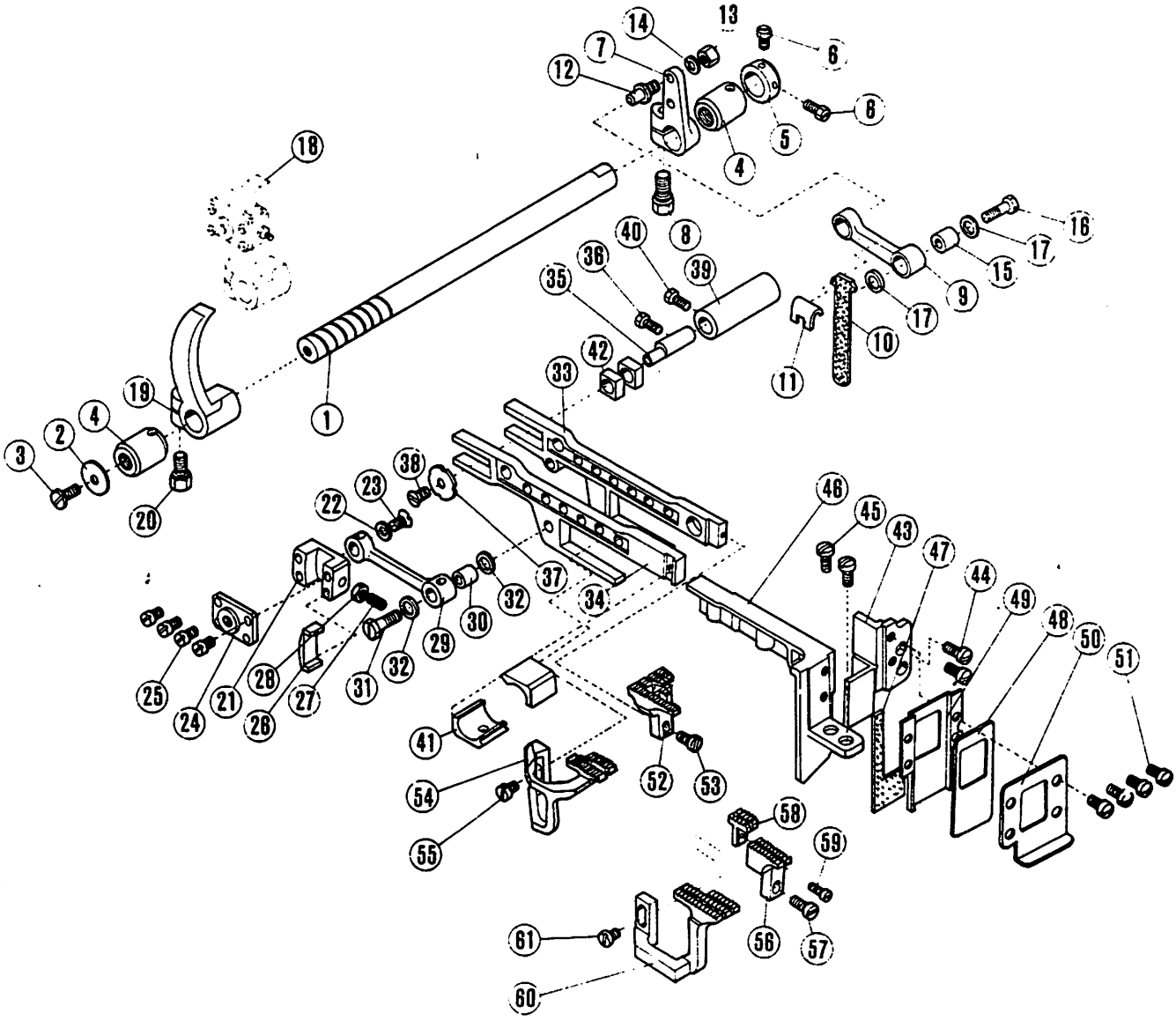
503-516/IV

(2) MAIN AND DIFFERENTIAL FEED MECHANISM





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503-516/IV
(2) MAIN AND DIFFERENTIAL FEED MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	503/IV 504/IV 514/IV	515/IV 516/IV
1	323-540-016	204751	Feed bar shaft	x	x
2	323-618-212	204107	Feed bar shaft thrust washer	x	x
3	323-600-014	4009-1	Feed bar shaft thrust washer screw	x	x
4	323-676-235	204054	Feed bar shaft bushing (2 used)	x	x
5	323-618-003	201056	Feed bar shaft collar	x	x
6	323-600-013	5084	Feed bar shaft collar screw (2 used)	x	x
7	323-576-215	204110A	Main feed regulating crank	x	x
8	323-600-801	5381	Main feed regulating crank clamp screw	x	x
9	323-730-207	204111	Main feed connecting link	x	x
10	323-653-004	204618	Main feed connecting link oil wick	x	x
11	323-686-002	204588	Main feed connecting link oil wick retainer	x	x
12	323-525-233	204112	Main feed connecting link pin	x	x
13	323-630-202	5137	Main feed connecting link pin nut	x	x
14	323-617-200	202286	Main feed connecting link pin nut washer	x	x
15	323-676-251	204114	Main feed connecting link bushing	x	x
16	323-600-309	5231	Main feed connecting link bushing screw	x	x
17	323-618-211	204115	Main feed connecting link bushing screw washer (2 used)	x	x
18	323-716-214	204467	Diff. feed regulator, complete with 204116A, 204117A 204119A, 5029x2, 204121, 1435 & 3044	x	x
19	323-518-202	204116A	Diff. feed regulating segment	x	x
20	323-600-801	5381	Diff. feed regulating segment clamp screw	x	x
21	323-750-203	204117A	Diff. feed regulating block	x	x
22	323-618-213	204118	Diff. feed regulating block thrust washer	x	x
23	323-600-059	3001	Diff. feed regulating block thrust washer screw	x	x
24	323-510-263	204119A	Diff. feed regulating block cover	x	x
25	323-600-256	5029	Diff. feed regulating block cover screw (4 used)	x	x
26	323-770-002	204121	Diff. feed regulating block slide	x	x
27	323-600-069	1435	Diff. feed regulating block slide screw	x	x
28	323-630-001	3044	Diff. feed regulating block slide screw nut	x	x
29	323-525-234	204122	Diff. feed connecting link	x	x
30	323-676-251	204114	Diff. feed connecting link bushing	x	x
31	323-600-309	5231	Diff. feed connecting link bushing screw	x	x
32	323-618-211	204115	Diff. feed connecting link bushing screw washer (2 used)	x	x
33	323-593-003	204123A	Main feed bar	x	x
34	323-593-207	204124	Diff. feed bar	x	x
35	323-620-252	204128A	Feed bar hinge pin	x	x
36	323-600-013	5084	Feed bar hinge pin screw	x	x
37	323-615-231	204439	Feed bar hinge pin washer	x	x
38	323-600-355	5317	Feed bar hinge pin washer screw	x	x
39	323-676-261	204129A	Feed bar guide bushing	x	x
40	323-600-215	2133-1	Feed bar guide bushing screw	x	x
41	323-750-003	204810	Feed bar lift block (split type)	x	x
42	323-750-002	201107	Feed bar guide block (2 used)	x	x
43	323-850-024	204709	Feed bar guide (right)	x	x
44	323-600-353	5205	Feed bar guide (right) screw (2 used)	x	x
	323-850-026	204710A	Feed bar guide (left), complete with 204814A & 204711	x	x
45	323-600-353	5205	Feed bar guide (left) screw (2 used)	x	x
46	323-850-027	204814A	Feed bar guide (left)	x	x
47	323-663-011	204711	Feed bar guide (left) gasket	x	x
48	323-560-012	204712	Feed bar oil splash guard	x	x
49	323-800-031	204713A	Feed bar oil splash guard insert plate	x	x
50	323-800-028	204714	Feed bar oil splash guard plate	x	x
51	323-600-016	1229	Feed bar oil splash guard plate screw (4 used)	x	x
52	*323-830-xxx		Main feed dog, complete with auxiliary feed dog & 2922		x
53	323-600-002	1175-2	Main feed dog screw		x
	*323-830-xxx		Auxiliary feed dog		x
	323-600-229	2922	Auxiliary feed dog screw		x
54	*323-830-xxx		Differential feed dog		x
55	323-600-301	1189	Differential feed dog screw		x
56	*323-830-xxx		Main feed dog	x	
57	323-600-002	1175-2	Main feed dog screw	x	
58	*323-830-xxx		Auxiliary feed dog	x	
59	323-600-229	2922	Auxiliary feed dog screw	x	
60	*323-830-xxx		Differential feed dog	x	
61	323-600-301	1189	Differential feed dog screw	x	

*See Organization Chart

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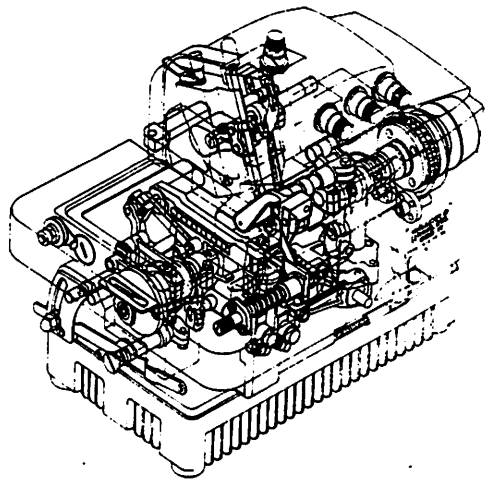
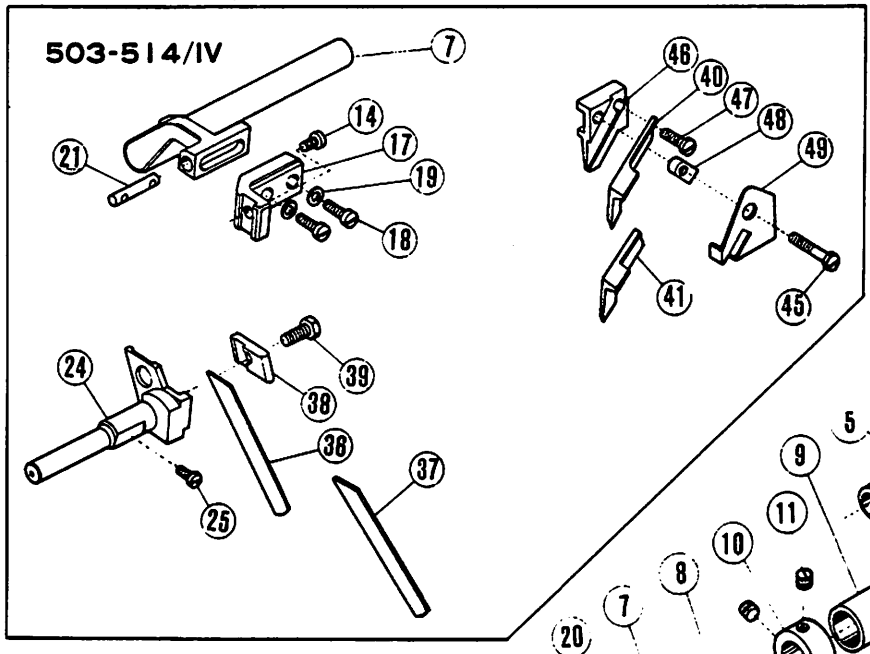
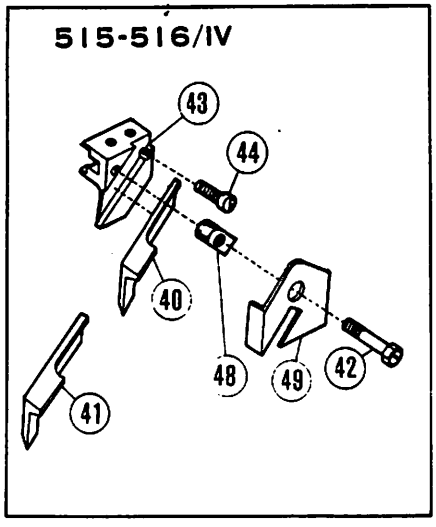
503-516/IV
UPPER AND LOWER KNIFE MECHANISM

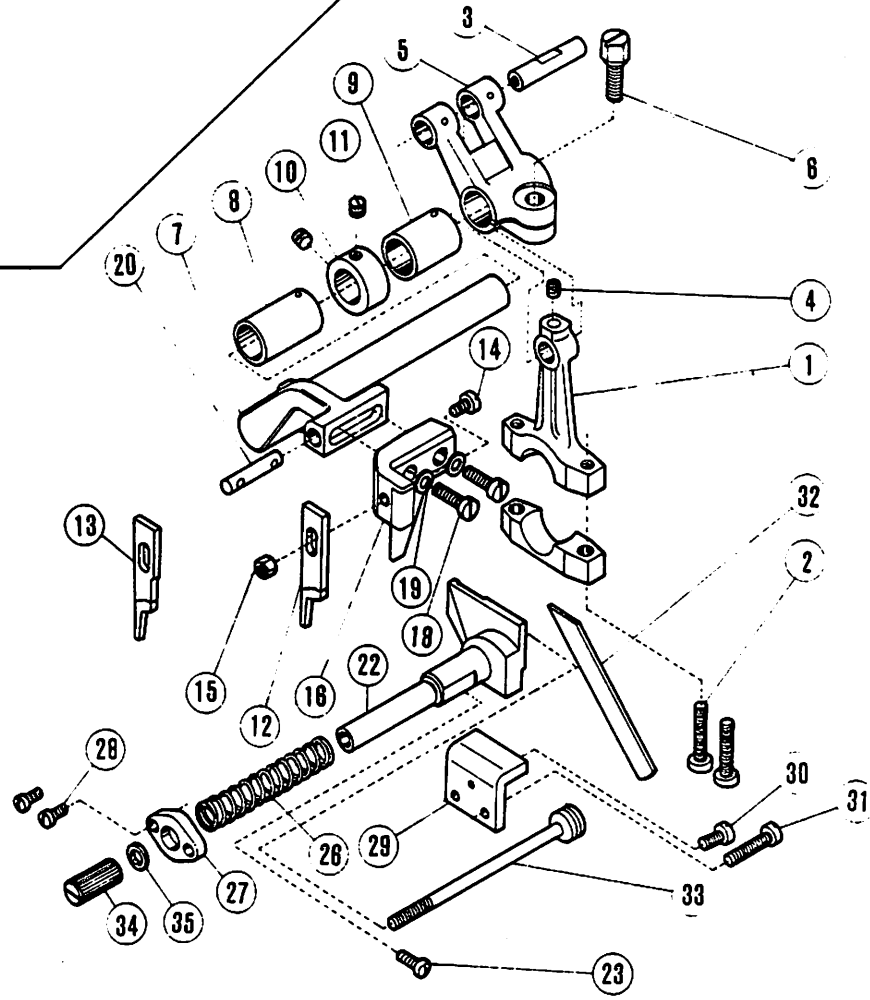


503-514/IV



515-516/IV





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503-516/IV
UPPER AND LOWER KNIFE MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION		503/IV 504/IV 514/IV	515/IV 516/IV
1	323-525-235	204145	Upper knife drive connection		x	x
2	323-600-296	5233	Upper knife drive connection cap screw (2 used)		x	x
3	323-620-244	204146	Upper knife drive connection pin		x	x
4	323-600-297	5234	Upper knife drive connection pin screw		x	x
5	323-525-236	204147	Upper knife drive crank		x	x
6	323-600-801	5381	Upper knife drive crank clamp screw		x	x
7	323-685-008	204148B	Upper knife lever		x	x
8	323-676-239	204149	Upper knife lever bushing (left)		x	x
9	323-680-208	204150	Upper knife lever bushing (right)		x	x
10	323-680-207	201635	Upper knife lever thrust collar		x	x
11	323-600-004	5060	Upper knife lever thrust collar screw (2 used)		x	x
12	*323-870-214	201121A	Upper knife (wide) – carbide tipped		x	x
13	*323-870-207	202527	Upper knife (narrow) – carbide tipped		x	x
14	323-600-090	5339	Upper knife screw		x	x
15	323-630-003	3091	Upper knife screw nut		x	x
16	323-683-217	204231A	Upper knife clamp			x
17	323-683-013	204638	Upper knife clamp		x	
18	323-600-002	1175-2	Upper knife clamp screw (2 used)		x	x
19	323-615-013	200821	Upper knife clamp screw washer (2 used)		x	x
20	323-620-245	204154	Upper knife clamp pin			x
21	323-620-016	204796	Upper knife clamp pin		x	
22	323-685-237	204157	Lower knife holder			x
23	323-600-014	4009-1	Lower knife holder screw			x
24	323-685-012	204758	Lower knife holder		x	
25	323-600-011	5002	Lower knife holder screw		x	
26	323-640-219	204158	Lower knife holder spring		x	x
27	323-625-202	204159	Lower knife holder spring seat		x	x
28	323-600-057	5117	Lower knife holder spring seat screw (2 used)		x	x
29	323-850-247	204160A	Lower knife holder guide		x	x
30	323-600-002	1175-2	Lower knife holder guide screw (short)		x	x
31	323-600-010	5010	Lower knife holder guide screw (long)		x	x
32	*323-870-213	204161	Lower knife			x
33	323-600-331	204162	Lower knife clamp stud			x
34	323-630-203	5260	Lower knife clamp stud nut			x
35	323-615-002	200098	Lower knife clamp stud nut washer			x
36	*323-870-210	202295	Lower knife (thick)		x	
37	*323-870-211	201127	Lower knife (thin)		x	
38	323-683-014	204759	Lower knife clamp		x	
39	323-600-271	2193	Lower knife clamp screw		x	
40	323-870-217	204152	Upper knife (angled)		x	x
41	323-870-004	204835	Upper knife (angled) (carbide tipped)	OPTIONAL ITEMS	x	x
42	323-600-312	5229	Upper knife screw			x
43	323-750-202	204153	Upper knife clamp			x
44	323-600-226	1170	Upper knife clamp screw			x
45	323-600-108	5371	Upper knife screw		x	
46	323-683-015	204830	Upper knife clamp		x	
47	323-600-054	5142	Upper knife clamp screw		x	
48	323-683-213	204155	Upper knife gib		x	x
49	323-560-225	204156	Upper knife guard		x	x

*See Organization Chart

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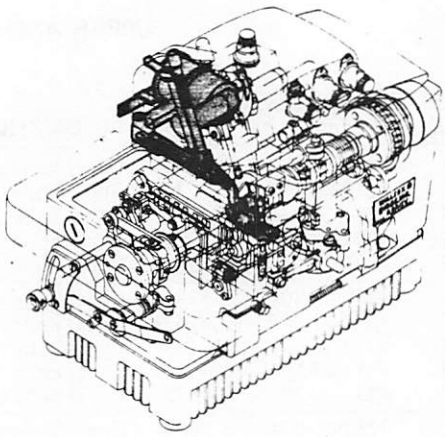
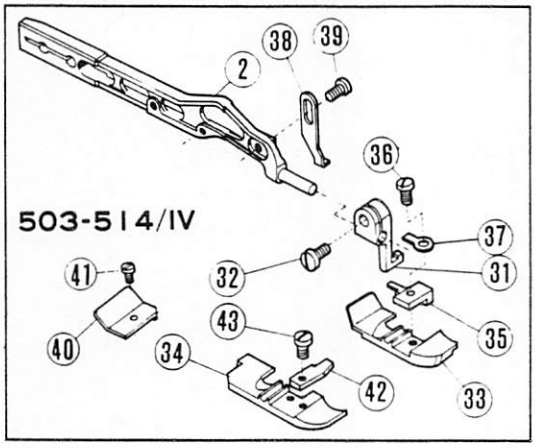
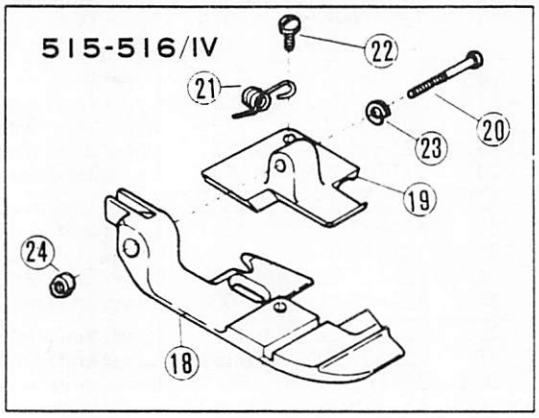
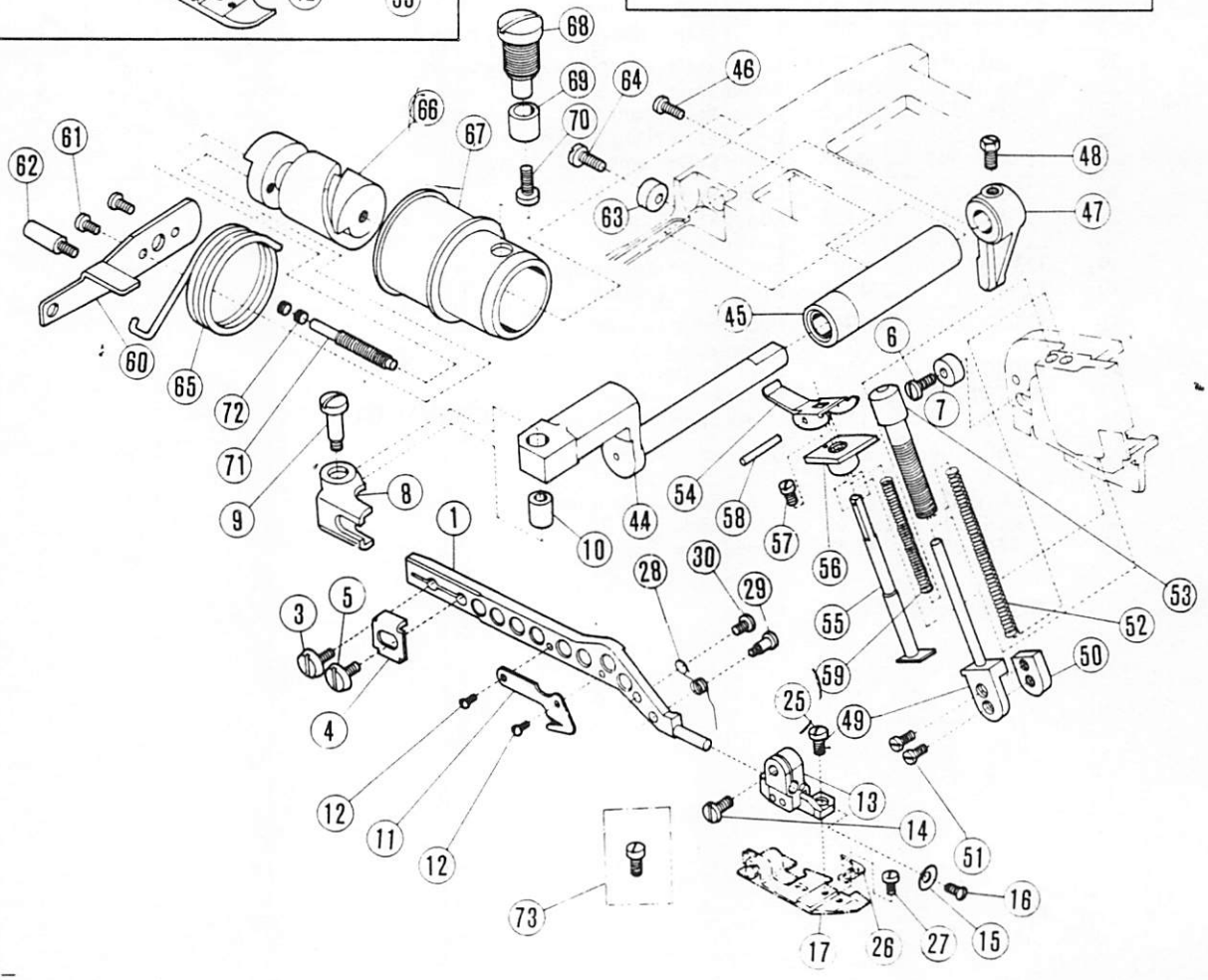
503-516/IV
PRESSER FOOT AND LIFT MECHANISM









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503-516/IV
PRESSER FOOT AND LIFT MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	503/IV 504/IV 514/IV	515/IV 516/IV
1	323-502-209	204163A	Presser arm		x
2	323-502-007	204640A	Presser arm	x	
3	323-600-209	5214	Presser arm screw	x	x
4	323-683-201	202503	Presser arm regulator	x	x
5	323-600-209	5214	Presser arm regulator screw	x	x
6	323-716-209	202683	Presser arm lift regulator	x	x
7	323-600-060	5118	Presser arm lift regulator screw	x	x
8	323-685-240	204237	Presser arm swing-out connection	x	x
9	323-600-047	5164	Presser arm swing-out connection hinge screw	x	x
10	323-680-002	201141	Presser arm swing-out connection hinge screw collar	x	x
11	323-873-001	201308	Chaincutter knife	x	x
12	323-600-048	1333	Chaincutter knife screw (2 used)	x	x
13	323-685-242	204327A	Presser foot holder, complete with 204236B, 204328A & 5323		x
14	323-600-014	4009-1	Presser foot holder bracket screw		x
		204236B	Presser foot holder bracket		x
		204328A	Presser foot holder		x
	323-600-085	5323	Presser foot holder hinge pin-screw		x
15	323-716-208	204172	Presser foot lift regulator		x
16	323-600-307	5077	Presser foot lift regulator screw		x
17	*323-820-xxx		Presser foot, complete		x
18		204169B	Presser foot body (Mfg only)		x
19		204170B	Presser foot auxiliary (Mfg only)		x
20	323-600-104	204496	Presser foot auxiliary hinge pin		x
21	323-633-202	204497	Presser foot auxiliary spring		x
22	323-630-235	5331	Presser foot auxiliary spring screw		x
23	323-640-226	204171B	Presser foot auxiliary hinge pin retaining ring		x
24	323-600-202	5030	Presser foot auxiliary hinge pin nut		x
25	323-600-016	1229	Presser foot screw		x
26	*323-560-xxx		Presser foot fabric guard		x
27	323-600-307	5077	Presser foot fabric guard screw		x
28	323-640-224	204329	Presser foot body spring		x
29	323-600-313	5291	Presser foot body spring screw (large)		x
30	323-600-026	2921	Presser foot body spring screw (small)		x
31	323-685-232	202504A	Presser foot holder bracket	x	
32	323-600-014	4009-1	Presser foot holder bracket screw	x	
33	*323-820-xxx		Presser foot	x	
34	*323-820-xxx		Presser foot	x	
35	*323-863-xxx		Presser foot chaining-off finger	x	
36	323-600-050	5089	Presser foot chaining-off finger screw	x	
37	323-643-001	201156	Presser foot hinge spring	x	
38	323-716-005	204841	Presser foot regulator	x	
39	323-600-026	2921	Presser foot regulator screw	x	
40	*323-560-xxx		Presser foot uncurler	x	
41	323-600-202	5030	Presser foot uncurler screw	x	
42	*323-854-xxx		Presser foot fabric guard	x	
43	323-600-051	1231	Presser foot fabric guard screw	x	
44	323-540-240	204164	Foot lift lever shaft	x	x
45	323-676-240	204165	Foot lift lever shaft bushing	x	x
46	323-600-215	2133-1	Foot lift lever shaft bushing screw	x	x
47	323-530-229	204166	Foot lift intermediate lever	x	x
48	323-600-022	2022-4	Foot lift intermediate lever screw	x	x
49	323-629-200	202641	Presser bar, complete with 202642 & 5053x2	x	x
50	323-850-249	202642	Presser bar guide	x	x
51	323-600-015	5053	Presser bar guide screw (2 used)	x	x
52	323-640-217	201388	Presser bar spring	x	x
53	323-600-317	202643	Pressure regulating thumb screw	x	x
54	323-530-233	202644A	Hand lift lever	x	x
55	323-629-201	202645	Hand lift lever spring plunger	x	x
56	323-676-259	202646A	Hand lift lever spring plunger bushing	x	x
57	323-600-256	5029	Hand lift lever spring plunger bushing screw	x	x
58	323-620-239	202647A	Hand lift lever hinge pin	x	x
59	323-640-228	201395	Hand lift lever spring	x	x
60	323-530-016	204177B	Foot lift lever	x	x
61	323-600-032	1202	Foot lift lever screw (2 used)	x	x
62	323-600-314	5232	Foot lift lever stop screw	x	x
63	323-716-209	202683	Foot lift lever regulator	x	x
64	323-600-060	5118	Foot lift lever regulator screw	x	x
65	323-640-220	204178	Foot lift lever spring	x	x
66	323-710-002	204179A	Foot lift cam	x	x
67	323-676-241	204241	Foot lift cam bushing	x	x
68	323-600-084	204590	Foot lift cam pin screw	x	x
69	323-720-001	204591	Foot lift cam pin roller	x	x
70	323-600-087	5141	Foot lift cam pin roller screw	x	x
71	323-600-315	5236	Foot lift cam regulating screw stud	x	x
72	323-600-316	2913-2	Foot lift cam regulating screw stud stop screw (2)	x	x
73	323-600-026	2921	Cord and piping foot screw		x

*See Organization Chart

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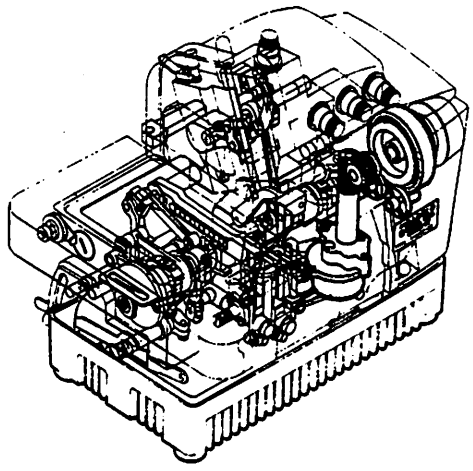
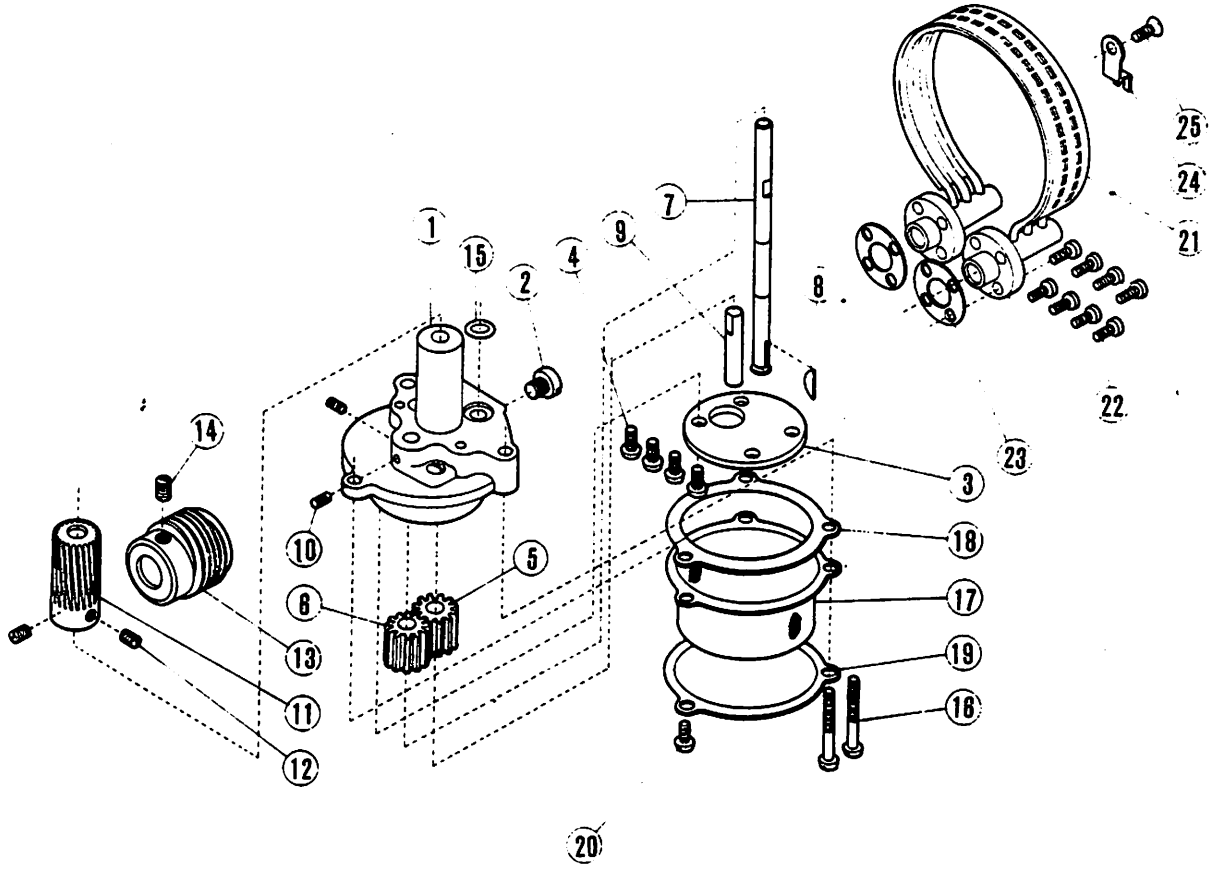
503-516/IV
(1) PUMP LUBRICATING MECHANISM





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503-516/IV
(1) PUMP LUBRICATING MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	503/IV 504/IV 514/IV	515/IV 516/IV
	323-900-012	204593	Gear pump, complete with parts of Ref. Nos. 1 to 12	x	x
1	323-515-203	204180	Gear pump housing	x	x
2	323-600-326	5145	Gear pump housing oil plug screw	x	x
3	323-800-006	201293A	Gear pump casing plate	x	x
4	323-600-057	5117	Gear pump casing plate screw (4 used)	x	x
5	323-764-001	201294	Pump gear (right)	x	x
6	323-764-002	201295	Pump gear (left)	x	x
7	323-540-237	204183	Pump gear shaft (long)	x	x
8	323-649-001	201009	Pump gear shaft (long) key	x	x
9	323-540-236	204184	Pump gear shaft (short)	x	x
10	323-600-037	1458	Pump gear shaft (short) screw (2 used)	x	x
11	323-570-204	204187	Worm wheel	x	x
12	323-600-004	5060	Worm wheel screw (2 used)	x	x
13	323-570-203	204186	Worm	x	x
14	323-600-043	2022	Worm screw	x	x
15	323-632-201	204185	Gear pump outlet 'O' ring	x	x
16	323-600-072	5094	Gear pump housing screw (2 used)	x	x
17	323-655-002	201338	Oil screen filter	x	x
18	323-663-001	201311	Oil screen filter gasket	x	x
19	323-508-002	201341	Oil screen filter frame	x	x
20	323-600-057	5117	Oil screen filter screw	x	x
21	323-902-020	204188	Oil cooler assembly	x	x
22	323-600-054	5142	Oil cooler tube joint screw (8 used)	x	x
23	323-663-211	204192	Oil cooler tube joint gasket (2 used)	x	x
24	323-683-214	204189	Oil cooler tube clamp	x	x
25	323-600-059	3001	Oil cooler tube clamp screw	x	x

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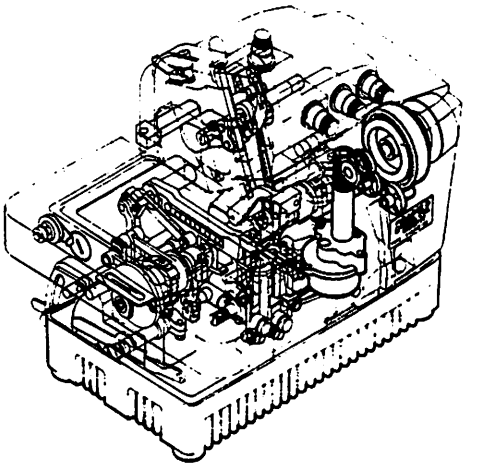
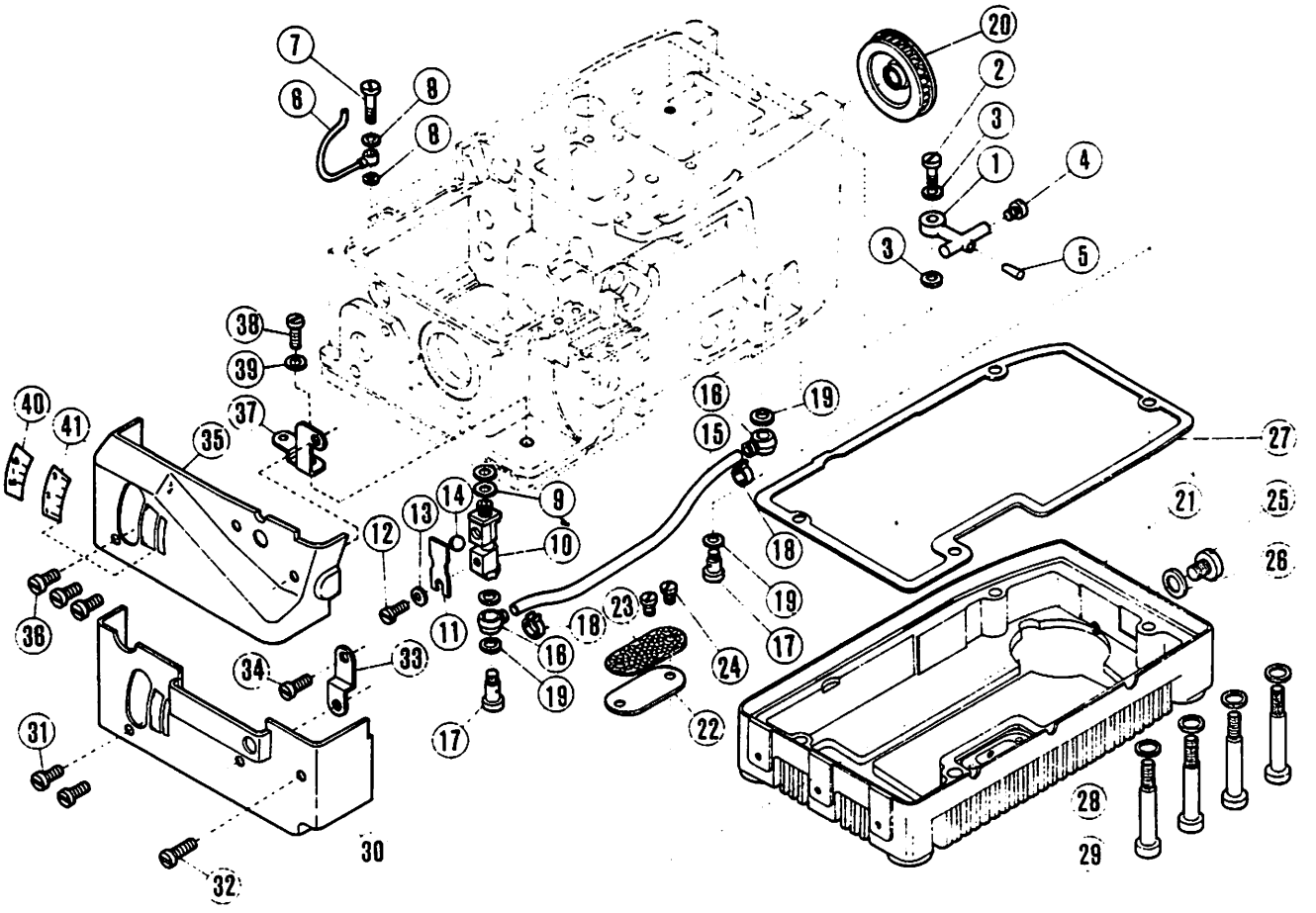
503-516/IV
(2) PUMP LUBRICATING MECHANISM





From the library of: Superior Sewing Machine & Supply LLC

503-516/IV
(2) PUMP LUBRICATING MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	503/IV 504/IV 514/IV	515/IV 516/IV
1	323-639-232	204193	Oil distributor	x	x
2	323-604-209	200152	Oil distributor screw	x	x
3	323-615-209	200138	Oil distributor screw washer (2 used)	x	x
4	323-600-062	201323	Oil distributor splash screw	x	x
5	323-627-208	202903	Oil distributor plug	x	x
6	323-639-233	204194	Oil splash pipe	x	x
7	323-600-064	201758	Oil splash pipe screw	x	x
8	323-615-010	201759	Oil splash pipe screw washer (2 used)	x	x
	323-736-002	204845	Oil pressure relief valve, complete with 204846, 204822, 2921, 202875 & 204847	x	x
9	323-615-209	200138	Oil pressure relief valve casing washer (2 used)	x	x
10		204846	Oil pressure relief valve casing	x	x
11	323-641-001	204822	Oil pressure relief valve spring	x	x
12	323-600-026	2921	Oil pressure relief valve spring screw	x	x
13	323-615-216	202875	Oil pressure relief valve spring screw washer	x	x
14	323-610-001	204847	Oil pressure relief valve ball	x	x
15	323-639-018	200698	Oil tube for lubricating 204016 crankshaft bushing (center)	x	x
16	323-636-200	200136	Oil tube joint (2 used)	x	x
17	323-604-209	200152	Oil tube joint stud (2 used)	x	x
18	323-685-003	202199	Oil tube clamp (2 used)	x	x
19	323-615-209	200138	Oil tube joint washer (4 used)	x	x
20	323-568-202	204198	Oil cooling fan	x	x
21	323-713-201	204200A	Oil pan	x	x
22	323-655-205	204202	Oil pan filter	x	x
23	323-800-221	204203	Oil pan filter plate	x	x
24	323-600-068	1216	Oil pan filter plate screw (2 used)	x	x
25	323-600-354	5138B	Oil drain plug screw	x	x
26	323-615-229	202287A	Oil drain plug screw washer	x	x
27	323-663-206	204201	Oil pan gasket	x	x
28	323-605-006	5150B	Oil pan bolt (4 used)	x	x
29	323-615-029	204806	Oil pan bolt washer (4 used)	x	x
30	323-510-032	204865	Machine cover (left) (for cloth plate (wide) 204798) (used with parts of Ref. Nos. 31-34)	x	x
31	323-600-257	5091	Machine cover (left) screw (short) (2 used)	x	x
32	323-600-109	5182	Machine cover (left) screw (long)	x	x
33	323-646-005	204867	Machine cover (left) spacer	x	x
34	323-600-039	5113	Machine cover (left) spacer screw	x	x
35	323-510-031	204857	Machine cover (left) (for cloth plate (narrow) 204740) (used with parts of Ref. Nos. 36-39)	x	
36	323-600-360	5092	Machine cover (left) screw (3 used)	x	
37	323-646-004	204868	Machine cover (left) spacer	x	
38	323-600-239	2308	Machine cover (left) spacer screw	x	
39	323-615-213	202058	Machine cover (left) spacer screw washer	x	
40	323-891-202	204493	2:1 diff. feed ratio indication plate	x	x
41	323-891-201	204494	3:1 diff. feed ratio indication plate	x	x

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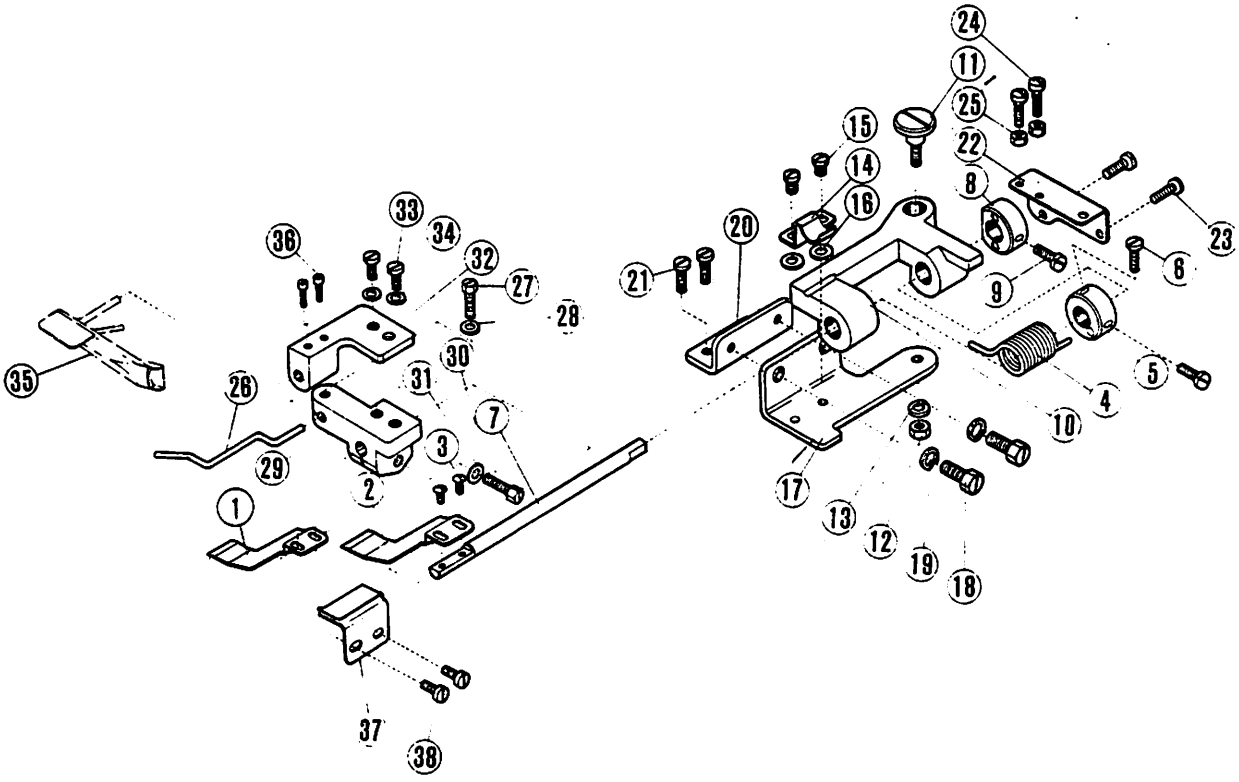
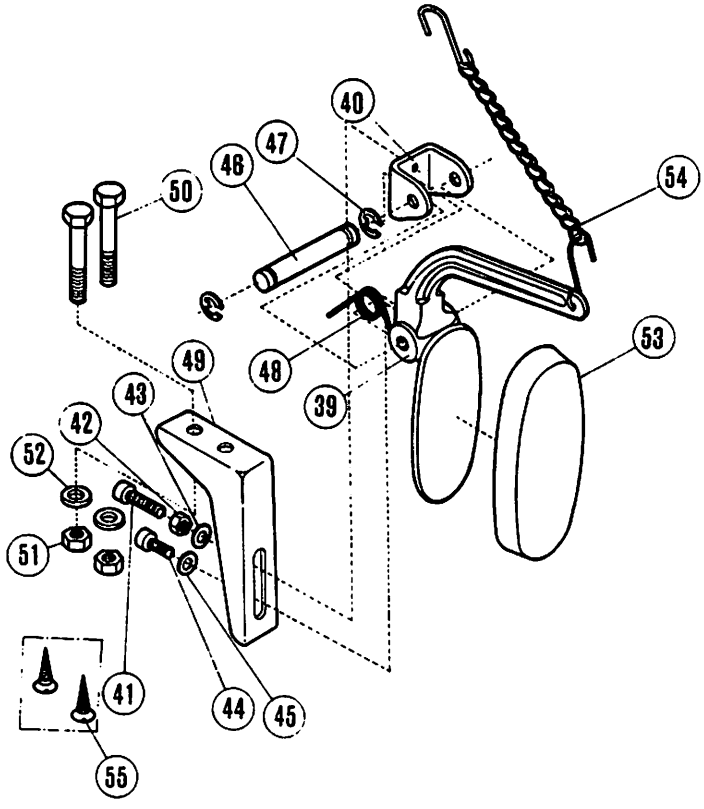
SHIRRING ATTACHMENT



KNEE CONTROLLER



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(1) ATTACHMENTS

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION
	*323-900-215	204670	Shirring attachment, complete – 515-516/IV (used with shirring blade 205064 and parts of Ref. Nos. 3 to 31)
	*323-900-014	204882	Shirring attachment, complete – 504-514/IV (used with shirring blade 205137 and parts of Ref. Nos. 3 to 31)
1	323-875-200	205064	Shirring blade – 515-516/IV
2	323-875-001	205137	Shirring blade – 504-514/IV
3	323-600-302	5227	Shirring blade screw (2 used)
4	323-640-225	205065	Shirring attachment spring
5	323-615-227	205066	Shirring attachment spring collar
6	323-600-025	5064	Shirring attachment spring collar screw (2 used)
7	323-540-246	205067	Shirring attachment shaft
8	323-680-210	205068	Shirring attachment shaft collar
9	323-600-237	2213	Shirring attachment shaft collar screw
10	323-750-204	205069	Shirring attachment block
11	323-600-350	5326	Shirring attachment block screw
12	323-630-202	5137	Shirring attachment block screw nut
13	323-617-200	202286	Shirring attachment block screw nut washer
14	323-625-203	205070	Shirring attachment block lock spring
15	323-600-016	1229	Shirring attachment block lock spring screw (2 used)
16	323-618-007	200183	Shirring attachment block lock spring screw washer (2 used)
17	323-800-235	204495	Shirring attachment block plate
18	323-600-271	2193	Shirring attachment block plate screw (2 used)
19	323-617-200	202286	Shirring attachment block plate screw washer (2 used)
20	323-740-229	204451	Shirring attachment block plate extension
21	323-600-057	5117	Shirring attachment block plate extension screw (2 used)
22	323-530-232	205072	Shirring blade swing-out lever
23	323-600-057	5117	Shirring blade swing-out lever screw (2 used)
24	323-600-226	1170	Shirring blade swing-out lever regulating screw (2 used)
25	323-630-003	3091	Shirring blade swing-out lever regulating screw nut (2 used)
26	323-534-001	204592	Shirring blade lifter
27	323-600-088	5276	Shirring blade lifter screw
28	323-615-213	202058	Shirring blade lifter screw washer
29	323-750-205	205104	Shirring blade lifter block
30	323-600-088	5276	Shirring blade lifter block clamp screw
31	323-615-213	202058	Shirring blade lifter block clamp screw washer
32	323-685-243	205103	Cord and piping attachment block
33	323-600-019	1175-3	Cord and piping attachment block screw (2 used)
34	323-615-211	167066	Cord and piping attachment block screw washer (2 used)
35			Cord and piping attachment (binder)
36	323-600-020	1170-1	Cord and piping attachment screw (2 used)
37	323-850-258	205091	Shirring cloth guide
38	323-600-068	1216	Shirring cloth guide screw (2 used)
	323-900-224	192	Knee controller, complete with parts of Ref. Nos. 39 to 55
39	323-530-100	193	Knee controller
40	323-728-004	194	Knee controller hinge
41	323-600-100	5183	Knee controller hinge regulating screw
42	323-630-001	3044	Knee controller hinge regulating screw nut
43	323-615-017	137142	Knee controller hinge regulating screw nut washer
44	323-600-060	5118	Knee controller hinge screw
45	323-615-017	137142	Knee controller hinge screw washer
46	323-620-100	195	Knee controller hinge pin
47	323-634-200	202522	Knee controller hinge pin stop ring (2 used)
48	323-640-100	196	Knee controller hinge spring
49	323-505-100	197	Knee controller hinge bracket
50	323-605-003	5347	Knee controller hinge bracket screw (2 used)
51	323-630-013	5348	Knee controller hinge bracket screw nut (2 used)
52	323-615-021	204585	Knee controller hinge bracket screw nut washer (2 used)
53	323-665-001	198	Knee pad
54	323-732-002	199	Knee pad chain
55	323-600-101	5341	Knee pad hinge bracket wood screw (2 used)

*See Organization Chart

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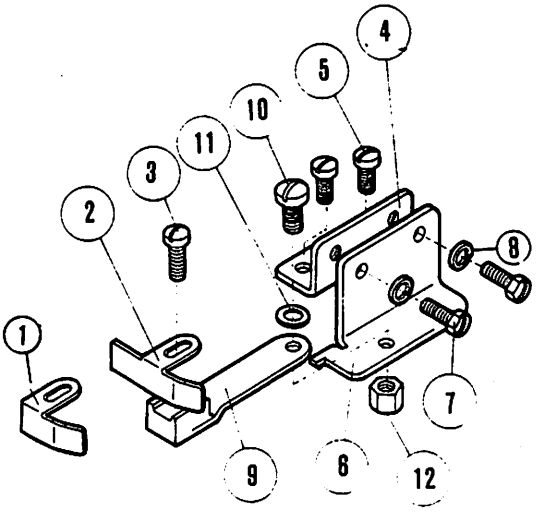
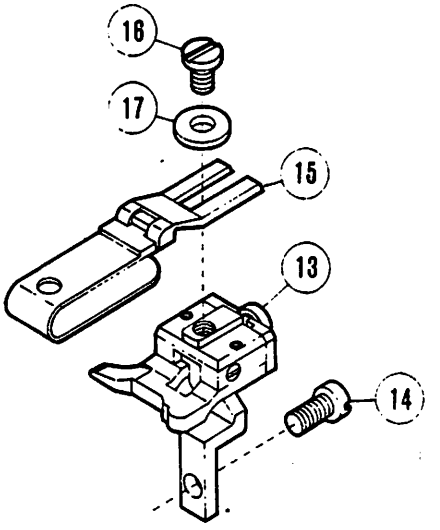
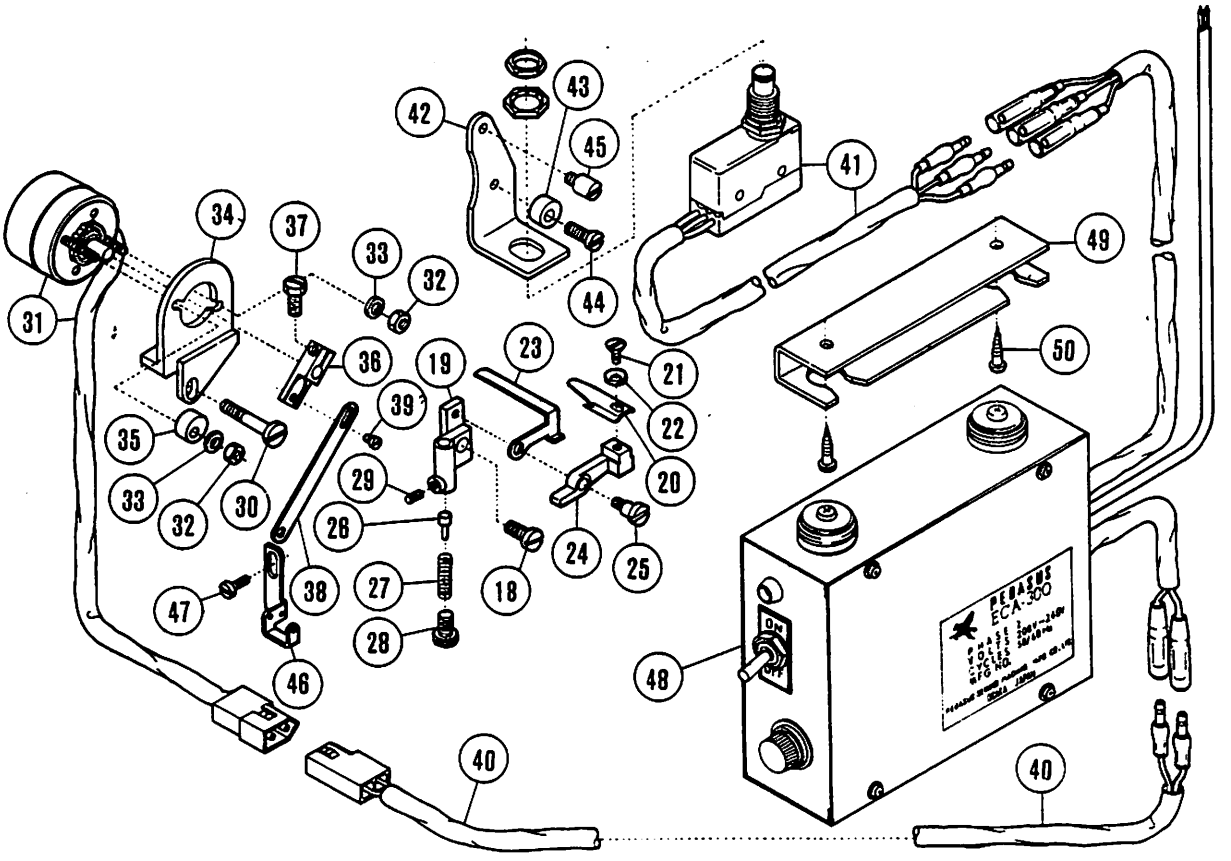
504-516/IV
EDGE GUIDE



503/IV
WELT GUIDE



503-514/IV
BACKTACKER



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(2) ATTACHMENTS

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION
	323-850-256	204449	Edge guide, complete – 515-516/IV (used with guide #201233A and parts of Ref. Nos. 3 to 12)
	323-850-028	204896	Edge guide, complete – 504-514/IV (used with guide #204667 and parts of Ref. Nos. 3 to 12)
1	323-850-013	201233A	Edge guide – 515-516/IV
2	323-850-022	204667	Edge guide – 504-514/IV
3	323-600-032	1202	Edge guide screw
4	323-740-229	204451	Edge guide holder bracket
5	323-600-057	5117	Edge guide holder bracket screw (2 used)
6	323-740-228	204452	Edge guide holder bracket extension
7	323-600-271	2193	Edge guide holder bracket extension screw (2 used)
8	323-617-200	202286	Edge guide holder bracket extension screw washer (2 used)
9	323-740-012	201485	Edge guide holder
10	323-600-079	5184	Edge guide holder screw
11	323-615-015	201191	Edge guide holder screw washer
12	323-630-010	5074	Edge guide holder screw washer nut
	–Welt guide for 504/IV-25		
13	323-505-010	204760	Welt guide base
14	323-600-002	1175-2	Welt guide base screw
15	323-400-001	201211A	Welt guide (1-1/2" hem)
16	323-600-074	2905	Welt guide screw
17	323-615-017	137142	Welt guide screw washer
	–Backtacker for 503-514/IV–		
	323-900-017	303135	Backtacker, complete with parts of Ref. Nos. 19 to 29
18	323-600-019	1175-3	Backtacker screw
19	323-505-011	303037	Backtacker base
20	323-873-002	303038	Backtacker blade
21	323-600-251	5022	Backtacker blade screw
22	323-615-030	303039	Backtacker blade screw washer
23	323-850-038	303040	Backtacker blade guide
24	323-530-021	303041	Backtacker blade lever
25	323-600-361	5368	Backtacker blade lever screw
26	323-620-027	303043	Backtacker blade lever push pin
27	323-640-016	303042	Backtacker blade lever push pin spring
28	323-600-362	5369	Backtacker blade lever push pin adjust screw
29	323-600-341	5292	Backtacker blade lever push pin adjust screw lock screw
	323-900-018	303136	Rotary solenoid, complete with parts of Ref. Nos. 31 to 39
30	323-600-363	5370	Rotary solenoid screw
31	323-795-001	811002	Rotary solenoid
32	323-630-022	5367	Rotary solenoid nut (2 used)
33	323-615-012	201185	Rotary solenoid nut washer (2 used)
34	323-740-041	303046	Rotary solenoid bracket
35	323-716-209	202683	Needle thread pull-off takeup lever regulator
36	323-530-022	303049	Needle thread pull-off takeup lever
37	323-600-271	2193	Needle thread pull-off takeup lever clamp screw
38	323-866-014	303048	Needle thread pull-off takeup
39	323-600-026	2921	Needle thread pull-off takeup screw
40	323-900-019	742008	Rotary solenoid cord, complete
41	323-900-020	706001	Micro-switch, complete
42	323-740-042	303050	Micro-switch bracket
43	323-716-209	202683	Foot lift lever regulator – already in the machine
44	323-600-061	5152	Foot lift lever screw
45	323-600-314	5232	Foot lift lever stop screw – already in the machine
46	323-850-039	303047	Needle thread guide
47	323-600-014	4009-1	Needle thread guide screw – already in the machine
48	323-900-021	760009	Electric controller
49	323-740-043	303009	Electric controller bracket
50	323-600-365	5378	Electric controller bracket screw (2 used)

For more information on Backtacker, see its instruction book.

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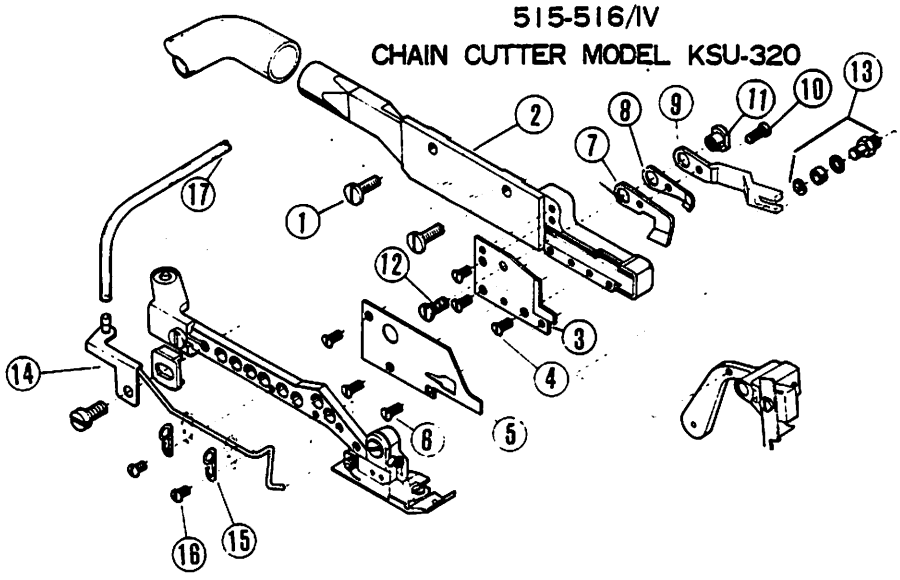
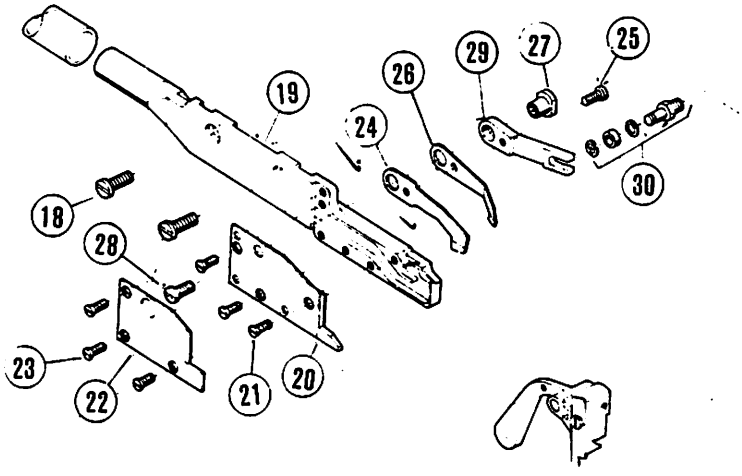
515-516/IV

CHAIN CUTTER MODEL KSU-320

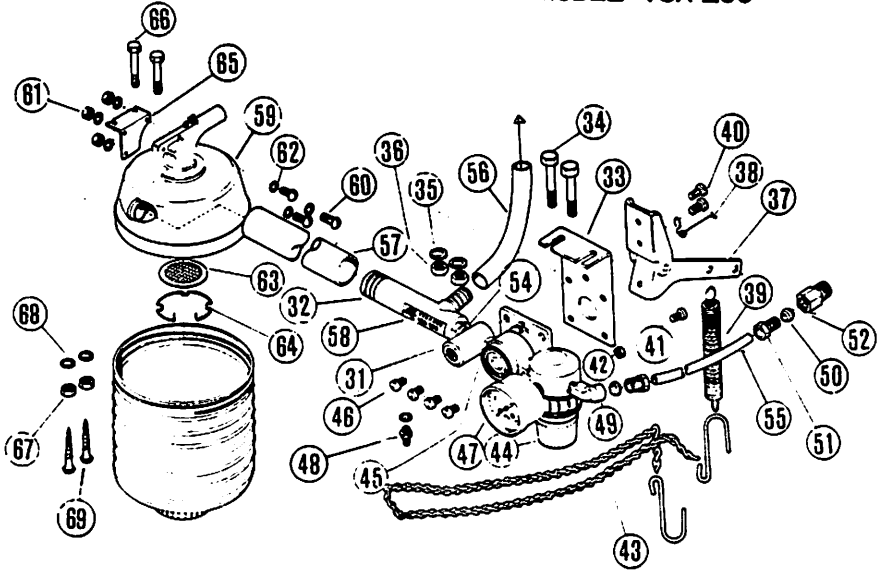


503-514/IV

CHAIN CUTTER MODEL KSU-520



SUCTION DEVICE MODEL VSA-200



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(3) ATTACHMENTS

REF. NO.	NEW PRODUCT CODE NO.	OLD NO	DESCRIPTION
	——Chain Cutter Model KSU-320 for 515-516/IV——		
	323-900-022	303073	Chain cutter frame, complete with parts of Ref. Nos. 2 to 12
1	323-600-014	4009-1	Chain cutter frame screw (2 used)
2	323-508-008	303080	Chain cutter frame
3	323-873-003	303074	Stationary blade
4	323-600-251	5022	Stationary blade screw (3 used)
5	323-560-027	303075	Stationary blade fabric guard
6	323-600-251	5022	Stationary blade fabric guard screw (3 used)
7	323-873-004	303076	Movable blade
8	323-643-007	303077	Movable blade spring
9	323-850-040	303078	Movable blade guide
10	323-600-366	5346	Movable blade screw
11	323-630-023	303079	Movable blade guide screw nut
12	323-600-074	2905	Movable blade guide screw
13	323-620-028	300135	Movable blade guide pin
14	323-639-021	303081A	Air blower
15	323-683-016	303085	Air blower tube clamp (2 used)
16	323-600-048	1333	Air blower tube clamp screw
17	323-639-022	303086	Air blower vinyl tube
	——Chain Cutter Model KSU-520 for 503-514/IV——		
	323-900-024	303138	Chain cutter frame, complete with parts of Ref. Nos. 19 to 29
18	323-600-057	5117	Chain cutter frame screw (2 used)
19	323-508-009	303030	Chain cutter frame
20	323-873-005	303031	Stationary blade
21	323-600-251	5022	Stationary blade screw (3 used)
22	323-560-028	303036	Stationary blade fabric guard
23	323-600-251	5022	Stationary blade fabric guard screw (3 used)
24	323-873-006	303032	Movable blade
25	323-600-124	5366	Movable blade screw
26	323-643-008	303033	Movable blade spring
27	323-630-024	303034	Movable blade guide screw nut
28	323-600-014	4009-1	Movable blade guide screw
29	323-850-041	303035	Movable blade guide
30	323-620-028	300135	Movable blade guide pin
	——Suction Device Model VSA-200——		
31	323-736-003	300027	Needle valve
32	323-651-001	300033	Venturi
33	323-740-044	300037	Air valve bracket
34	323-600-367	5344	Air valve bracket screw (2 used)
35	323-615-021	204585	Air valve bracket screw washer (2 used)
36	323-630-013	5348	Air valve bracket screw nut (2 used)
37	323-716-006	300038	Actuator
38	323-640-017	300042	Actuator hinge spring
39	323-640-018	300043	Actuator spring
40	323-600-014	4009-1	Actuator screw (2 used)
41	323-600-027	1174	Actuator stop screw
42	323-630-003	3091	Actuator stop screw nut
43	323-732-001	126	Actuator chain
44	323-716-007	522001	Air regulator
45	323-736-004	530001	Air valve
46	323-600-039	5113	Air valve screw (4 used)
47	323-891-003	596002	Air pressure gauge
48	323-636-006	601001	Air valve joint
49	323-636-007	601011	Elbow
50	323-635-003	601012	Sleeve (2 used)
51	323-636-011	601013	Nipple joint, for 600005
52	323-636-008	601014	Nipple, for 600005
53	323-636-009	601015	Air valve nipple (right)
54	323-636-010	601016	Air valve nipple (left)
55	323-639-023	600005	Vinyl tube
56	323-639-024	600006	Suction tube
57	323-639-025	600007	Exhaust tube
58	323-692-028	300044	Model plate
59	323-900-023	300105	Waste receptacle complete
60	323-600-364	5354	Waste receptacle screw (3 used)
61	323-630-022	5367	Waste receptacle screw nut (3 used)
62	323-615-012	201185	Waste receptacle screw nut washer (6 used)
63	323-655-009	300107	Air filter
64	323-634-005	300108	Air filter stop ring
65	323-740-045	300109	Waste receptacle bracket
66	323-605-003	5347	Waste receptacle bracket bolt (2 used)
67	323-630-013	5348	Waste receptacle bracket bolt nut (2 used)
68	323-615-021	204585	Waste receptacle bracket bolt nut washer (2 used)
(69)	323-600-101	5341	Waste receptacle bracket wooden screw (2 used)

For more information on Chain Cutter, see its instruction book.

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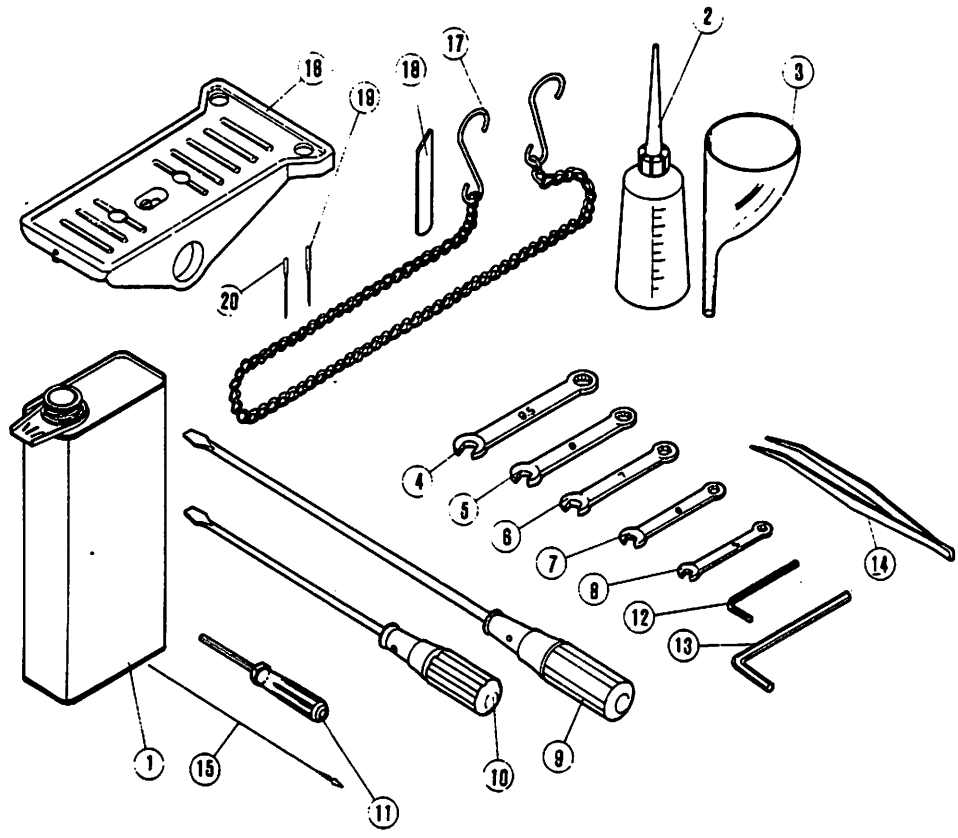
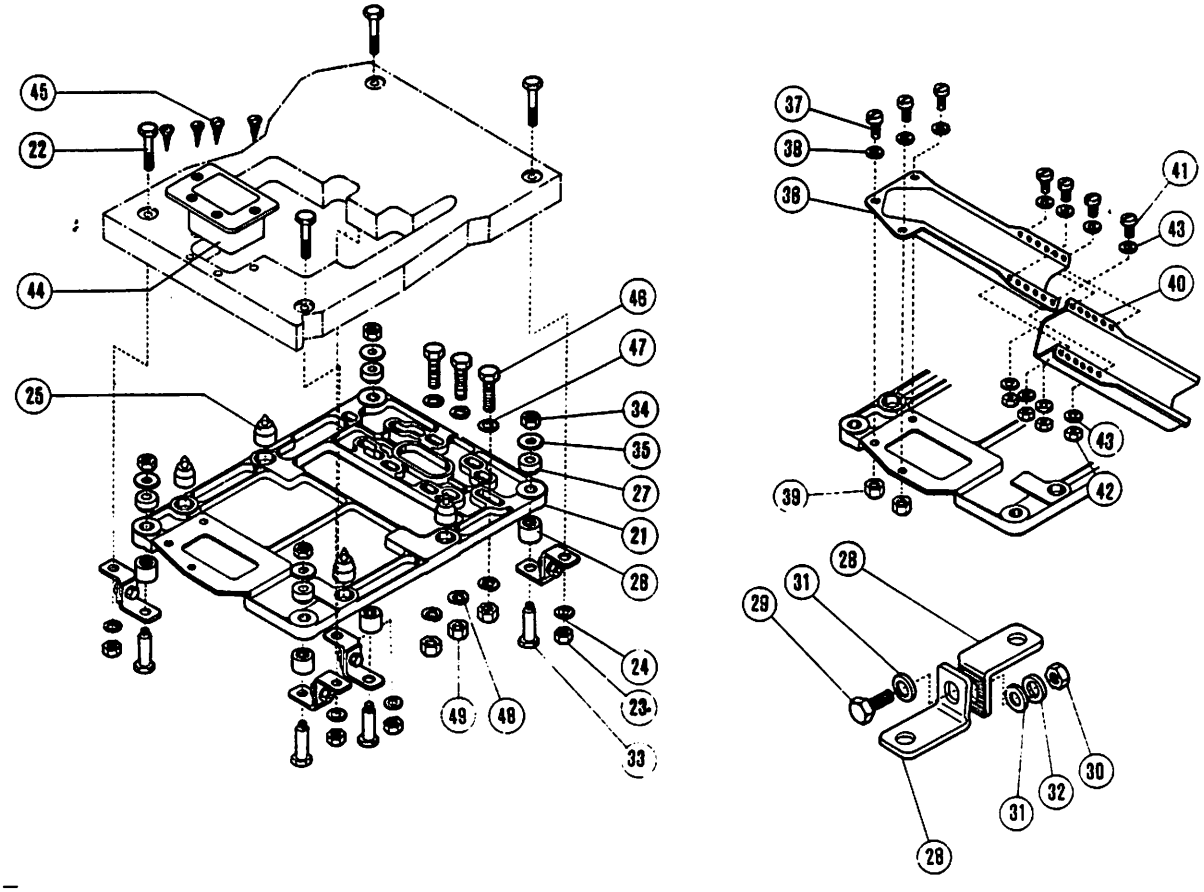
ACCESSORIES



ACCESSORIES FOR SEMI-SUBMERGED INSTALLATION



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ACCESSORIES

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION
1	323-945-002	133	Oil container
2	323-659-200	132	Oiler
3	323-945-003	135A	Oil funnel
4	323-880-211	130A-9.5	Wrench (9.5mm)
5	323-880-210	130A-8	Wrench (8.0mm)
6	323-880-209	130A-7	Wrench (7.0mm)
7	323-880-208	130A-6	Wrench (6.0mm)
8	323-880-200	130A-5	Wrench (5.0mm)
9	323-885-001	127	Screw driver (large)
10	323-885-002	128	Screw driver (medium)
11	323-885-200	179	Allen wrench
12	323-880-214	182	Allen key (3.17mm)
13	323-880-005	200	Allen key (4.76mm)
14	323-886-001	131	Tweezers
15	323-660-200	153	Threading wire
16	323-533-005	245	Treadle
17	323-732-001	126	Treadle chain
18	323-870-213	204161	Lower knife
19			Needle (10 pieces)
20			Needle (10 pieces) (for 2-needle machine)
	– Accessories for semi-submerged installation –		
21	323-945-213	204301C	Machine rest board
22	323-605-202	204303	Machine rest board hanger bolt (4 used)
23	323-630-204	5221	Machine rest board hanger bolt nut (4 used)
24	323-615-203	202700	Machine rest board hanger bolt nut washer (4 used)
25	323-945-202	202691	Machine isolating rubber (4 used)
26	323-945-208	202693A	Machine rest board isolating rubber (lower) (4 used)
27	323-627-204	202765	Machine rest board isolating rubber (upper) (4 used)
28	323-740-223	202768	Machine rest board hanger bracket (8 used)
29	323-600-324	5296	Machine rest board hanger bracket screw (4 used)
30	323-630-228	5297	Machine rest board hanger bracket screw nut (4 used)
31	323-615-219	202769	Machine rest board hanger bracket screw nut washer (8 used)
32	323-616-001	201477	Machine rest board hanger bracket screw nut spring wasner (8 used)
33	323-605-203	202766	Machine rest board set bolt (4 used)
34	323-630-229	5298	Machine rest board set bolt nut (4 used)
35	323-615-220	202767	Machine rest board set bolt nut washer (4 used)
36	323-774-001	201348B	Waste chute
37	323-600-217	5017	Waste chute screw (3 used)
38	323-615-002	200098	Waste chute screw washer (3 used)
39	323-630-001	3044	Waste chute screw nut (3 used)
40	323-774-200	201349B	Waste chute extension
41	323-600-060	5118	Waste chute extension screw (4 used)
42	323-630-001	3044	Waste chute extension screw nut (4 used)
43	323-615-002	200098	Waste chute extension screw nut washer (8 used)
44	323-740-013	201346A	Waste chute top
45	323-600-321	175	Waste chute top wood screw (4 used)
46	323-605-204	5302	Motor hanger bolt (3 used)
47	323-615-219	202769	Motor hanger bolt washer (6 used)
48	323-616-001	201477	Motor hanger bolt spring washer (3 used)
49	323-630-228	5297	Motor hanger bolt nut (3 used)

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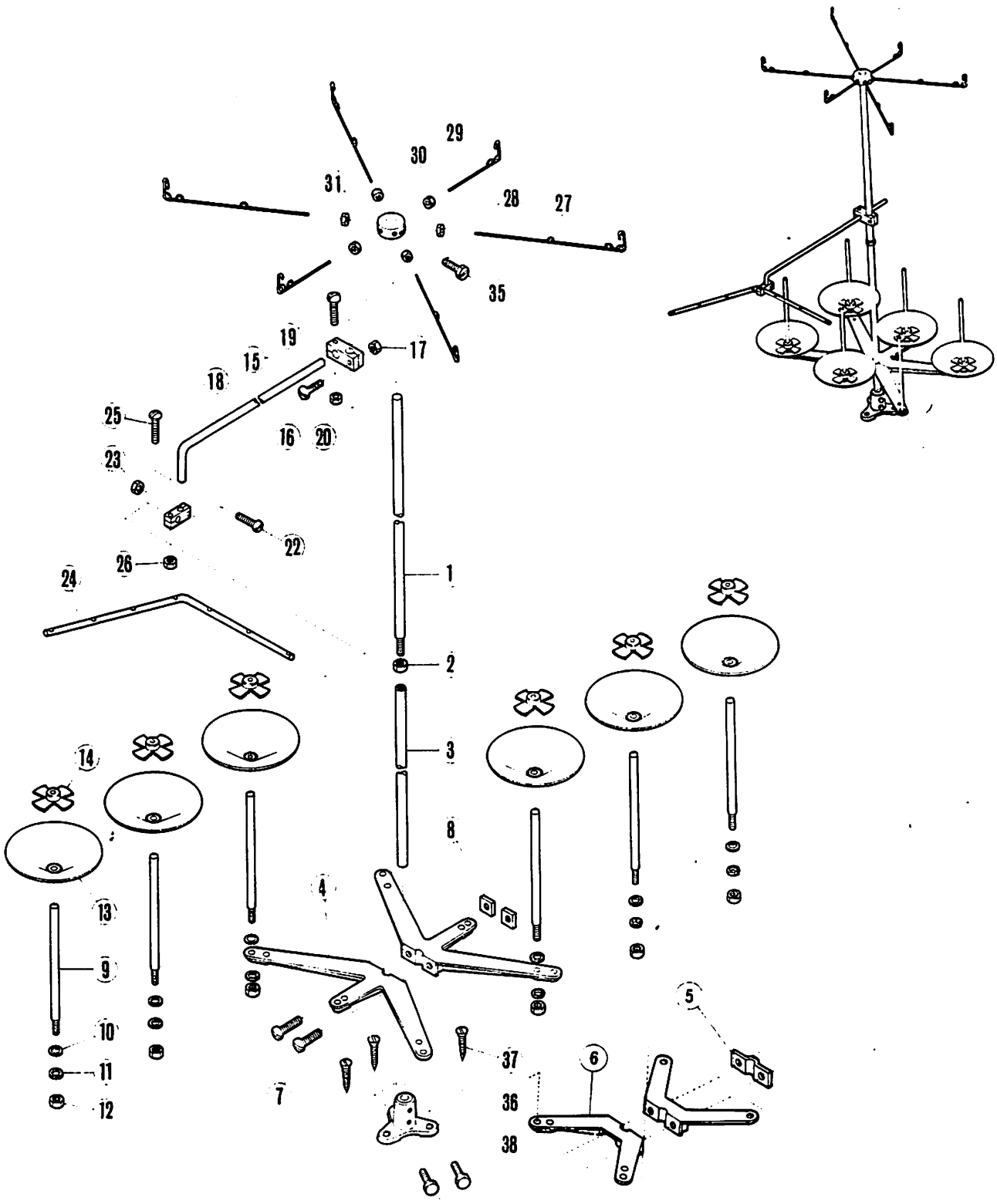

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THREAD STAND

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	NOS. REQUIRED FOR SPOOLS OF 3	4	5	6
	323-940-205	208	Thread stand, complete – 3 spools	1	–	–	–
	323-940-206	209	Thread stand, complete – 4 spools	–	1	–	–
	323-940-207	214	Thread stand, complete – 5 spools	–	–	1	–
	323-940-208	210	Thread stand, complete – 6 spools	–	–	–	1
1	323-535-001	216	Thread stand upper rod	1	1	1	1
2	323-600-118	217	Thread stand upper rod screw	1	1	1	1
3	323-535-002	218	Thread stand lower rod	1	1	1	1
4	323-740-035	219	Spool pin bracket	1	–	1	2
5	323-800-041	243	Spool pin bracket clamp plate	1	–	–	–
6	323-740-036	220	Spool pin bracket	–	2	1	–
7	323-600-119	221	Spool pin bracket clamp screw	2	2	2	2
8	323-630-018	222	Spool pin bracket clamp screw nut	2	2	2	2
9	323-620-024	223	Spool pin	3	4	5	6
10	323-615-028	224	Spool pin washer	3	4	5	6
11	323-617-001	225	Spool pin nut spring washer	3	4	5	6
12	323-630-019	226	Spool pin nut	3	4	5	6
13	323-685-013	227	Spool tray	3	4	5	6
14	323-850-031	228	Spool retaining fin	3	4	5	6
15	323-740-034	229	Thread guide bar rod bracket	1	1	1	1
16	323-600-120	230	Thread guide bar rod bracket clamp screw	1	1	1	1
17	323-630-020	231	Thread guide bar rod bracket clamp screw nut	1	1	1	1
18	323-535-003	232	Thread guide bar rod	1	1	1	1
19	323-600-120	230	Thread guide bar rod screw	1	1	1	1
20	323-630-020	231	Thread guide bar rod screw nut	1	1	1	1
21	323-750-006	233	Thread guide rod retaining block	1	1	1	1
22	323-600-120	230	Thread guide rod retaining block clamp screw	1	1	1	1
23	323-630-020	231	Thread guide rod retaining block clamp screw nut	1	1	1	1
24	323-590-003	234	Thread guide bar	1	1	1	1
25	323-600-120	230	Thread guide bar clamp screw	1	1	1	1
26	323-630-020	231	Thread guide bar clamp screw nut	1	1	1	1
27	323-851-021	235	Thread guide wire (long)	2	–	2	4
28	323-630-021	236	Thread guide wire (long) lock nut	2	–	2	4
29	323-851-020	237	Thread guide wire (short)	1	4	3	2
30	323-630-021	236	Thread guide wire (short) lock nut	1	4	3	2
31	323-685-016	260	Thread guide wire holder – 3 spools	1	–	–	–
32	323-685-017	261	Thread guide wire holder – 4 spools	–	1	–	–
33	323-685-018	262	Thread guide wire holder – 5 spools	–	–	1	–
34	323-685-014	238	Thread guide wire holder – 6 spools	–	–	–	1
35	323-600-121	239	Thread guide wire holder screw	1	1	1	1
36	323-505-009	240	Thread stand base	1	1	1	1
37	323-600-122	241	Thread stand base wood screw	3	3	3	3
38	323-600-123	242	Thread stand base rod screw	2	2	2	2

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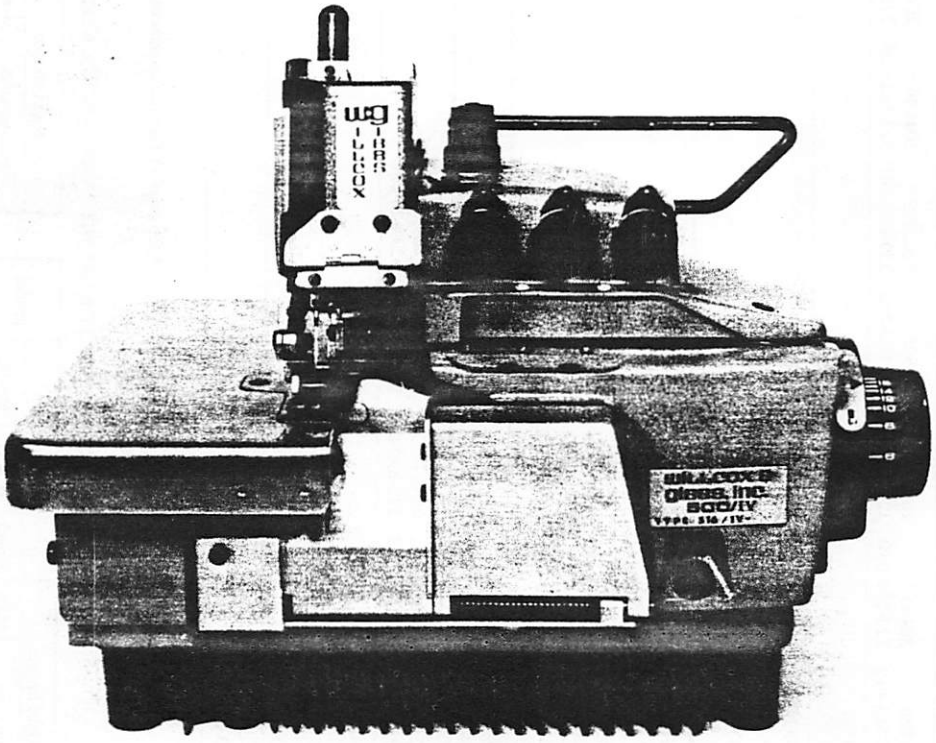
ORGANIZATION CHARTS



From the library of: Superior Sewing Machine & Supply LLC

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

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Auxiliary feed	Presser foot complete	Needle guard (front)	(rear)	Needle bar	Right looper	Lower knife	Others
503/IV-44 Serging trousers	3mm 1/8"	205320 323-801-062	204692 323-830-030	204907 323-830-060	204908 323-830-055	*202993 323-820-281	204634 323-561-009	204635 323-561-010	204623 323-591-003	204704 323-810-011	202295 323-870-210	
	4mm 5/32"	205321 323-801-063	"	"	"	"	"	"	"	"	"	Needle (factory setting) DCx1 #14 423223631 Edge guide
	5mm 3/16"	205322 323-801-064	"	"	"	"	"	"	"	"	"	
	6mm 1/4"	205323 323-801-065	"	"	"	"	"	"	"	"	"	
503/IV-48 Serging trousers	3mm 1/8"	205324 323-801-066	204909 323-830-053	204690 323-830-057	"	"	"	"	"	"	201127 323-870-211	
	4mm 5/32"	205325 323-801-067	"	"	"	"	"	"	"	"	"	Needle (factory setting) DCx1 #14 423223631 Edge guide
	5mm 3/16"	205326 323-801-068	"	"	"	"	"	"	"	"	202295 323-870-210	
	6mm 1/4"	205327 323-801-069	"	"	"	"	"	"	"	"	"	
504/IV-7 Plain seaming for underwear	3mm 1/8"	202542E 323-801-026	204675 323-830-029	204676 323-830-033	204674 323-830-054	*204956 323-820-026	"	"	"	204062 323-810-218	201127 323-870-211	
	4mm 5/32"	202546E 323-801-027	"	"	"	"	"	"	"	"	"	Needle (factory setting) DCx1 #11 423222831
	5mm 3/16"	202596E 323-801-028	"	"	"	"	"	"	"	"	202295 323-870-210	
	6mm 1/4"	202597E 323-801-029	"	"	"	"	"	"	"	"	"	

*See page 77 for its components.

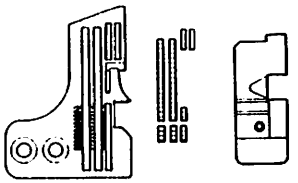
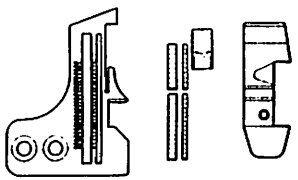
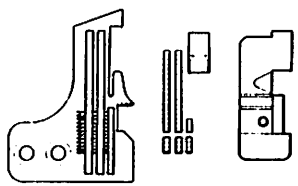
RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204278 323-810-215	1	9-12	027-032	65-80	503/IV
204704 323-810-011	3	13-16	034-040	85-100	
204705 323-810-012	5	17-21	042-051	100-140	

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204062 323-810-218	2	9-12	027-032	65-80	504/IV
204702 323-810-009	4	13-16	034-040	85-100	
204703 323-810-010	6	17-21	042-051	100-140	
204663 323-810-008	7	9-14	027-036	65-90	514/IV

From the library of: Superior Sewing Machine & Supply LLC

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

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Auxiliary feed	Presser foot complete	Needle guard (front)	Needle guard (rear)	Needle bar	Right looper	Lower knife	Others
504/IV-17 Intermittent shirring	3mm 1/8"	205239 323-801-360	204723 323-830-032	204724 323-830-036	204677 323-830-037	*204951 323-820-017	204634 323-561-009	204635 323-561-010	204623 323-591-003	204702 323-810-009	201127 323-870-211	
	4mm 5/32"	205240 323-801-361	"	"	"	"	"	"	"	"	"	Needle (factory setting) DCx27 #14 423243631 Shirring attachment
	5mm 3/16"	205241 323-801-362	"	"	"	*204952 323-820-018	"	"	"	"	202295 323-870-210	
	6mm 1/4"	205242 323-801-363	"	"	"	"	"	"	"	"	"	
504/IV-19 Seaming light knit goods	2mm 5/64"	202616 323-801-038	204729 323-830-052	204730 323-830-059	204674 323-830-054	*204953 323-820-023	"	"	"	204062 323-810-218	"	
	3mm 1/8"	202617 323-801-039	"	"	"	"	"	"	"	"	"	Needle (factory setting) DCx1 #9 423222631
	4mm 5/32"	202618 323-801-222	"	"	"	"	"	"	"	"	"	
	5mm 3/16"	204913 323-801-045	"	"	"	"	"	"	"	"	"	
504/IV-21 Intermittent shirring	3mm 1/8"	202542E 323-801-026	204723 323-830-032	204724 323-830-036	"	*204951 323-820-017	"	"	"	"	201127 323-870-211	
	4mm 5/32"	202546E 323-801-027	"	"	"	"	"	"	"	"	"	Needle (factory setting) DCx1 #11 423222831 Shirring attachment
	5mm 3/16"	202596E 323-801-028	"	"	"	*204952 323-820-018	"	"	"	"	202295 323-870-210	
	6mm 1/4"	202597E 323-801-029	"	"	"	"	"	"	"	"	"	

*See page 77 for its components.

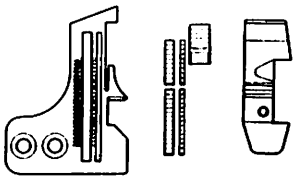
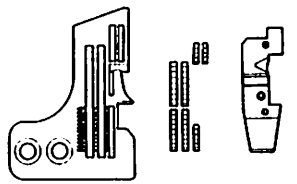
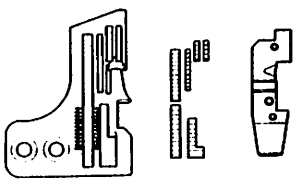
RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

Right looper Part number	Mark	for needle size Singer	W & G	Metric	Model
204278 323-810-215	1	9-12	027-032	65-80	503/IV
204704 323-810-011	3	13-16	034-040	85-100	
204705 323-810-012	5	17-21	042-051	100-140	

Right looper Part number	Mark	for needle size Singer	W & G	Metric	Model
204062 323-810-218	2	9-12	027-032	65-80	504/IV
204702 323-810-009	4	13-16	034-040	85-100	
204703 323-810-010	6	17-21	042-051	100-140	
204663 323-810-008	7	9-14	027-036	65-90	514/IV

From the library of: Superior Sewing Machine & Supply LLC

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

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Auxiliary feed	Presser foot complete	Needle guard (front)	Needle guard (rear)	Needle bar	Right looper	Lower knife	Others
504/IV-25 Hemming light knits	2mm 5/64"	202616 323-801-038	204729 323-830-052	204730 323-830-059	204674 323-830-054	*205226 323-820-220	204634 323-561-009	204635 323-561-010	204623 323-591-003	204062 323-810-218	202295 323-870-210	
	3mm 1/8"	202617 323-801-039	"	"	"	"	"	"	"	"	"	Needle (factory setting) DCx1 #9 423222631 Welt guide
	4mm 5/32"	202618 323-801-222	"	"	"	"	"	"	"	"	"	
	5mm 3/16"	204913 323-801-045	"	"	"	"	"	"	"	"	"	
504/IV-43 Seaming light knits	3mm 1/8"	205235 323-801-340	204721 323-830-031	204722 323-830-035	204677 323-830-037	*202992 323-820-280	"	"	"	204702 323-810-009	201127 323-870-211	
	4mm 5/32"	205236 323-801-341	"	"	"	"	"	"	"	"	"	Needle (factory setting) DCx27 #14 423243631
	5mm 3/16"	205237 323-801-342	"	"	"	"	"	"	"	"	202295 323-870-210	
	6mm 1/4"	205238 323-801-343	"	"	"	"	"	"	"	"	"	
504/IV-45 Seaming medium-heavy knits	3mm 1/8"	205231 323-801-344	204692 323-830-030	204693 323-830-034	"	*202993 323-820-281	"	"	"	"	201127 323-870-211	
	4mm 5/32"	205232 323-801-345	"	"	"	"	"	"	"	"	"	Needle (factory setting) DCx27 #14 423243631
	5mm 3/16"	205233 323-801-346	"	"	"	"	"	"	"	"	202295 323-870-210	
	6mm 1/4"	205234 323-801-347	"	"	"	"	"	"	"	"	"	

*See page 77 for its components.

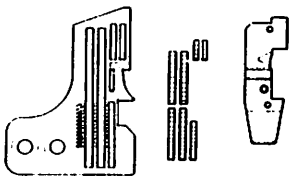
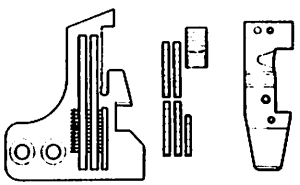
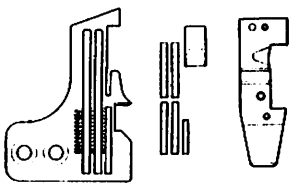
RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204278 323-810-215	1	9-12	027-032	65-80	503/IV
204704 323-810-011	3	13-16	034-040	85-100	
204705 323-810-012	5	17-21	042-051	100-140	

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204062 323-810-218	2	9-12	027-032	65-80	504/IV
204702 323-810-009	4	13-16	034-040	85-100	
204703 323-810-010	6	17-21	042-051	100-140	
204663 323-810-008	7	9-14	027-036	65-90	514/IV

From the library of: Superior Sewing Machine & Supply LLC

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

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Auxiliary feed	Presser foot complete	Needle guard (front)	Needle guard (rear)	Needle bar	Right looper	Lower knife	Others
504/IV-47 Seaming woven and knits	3mm 1/8"	205239 323-801-360	204675 323-830-029	204676 323-830-033	204677 323-830-037	*202994 323-820-282	204634 323-561-009	204635 323-561-010	204623 323-591-003	204702 323-810-009	201127 323-870-211	
	4mm 5/32"	205240 323-801-361	"	"	"	"	"	"	"	"	"	Needle (factory setting) DCx27 #16 423244031
	5mm 3/16"	205241 323-801-362	"	"	"	"	"	"	"	"	202295 323-870-210	
	6mm 1/4"	205242 323-801-363	"	"	"	"	"	"	"	"	"	
504/IV-S-10 Seaming jeans	3mm 1/8"	202542E 323-801-026	204678 323-830-051	204679 323-830-056	204674 323-830-054	*204956 323-820-026	"	"	"	204703 323-810-010	201127 323-870-211	
	4mm 5/32"	202546E 323-801-027	"	"	"	"	"	"	"	"	"	
	5mm 3/16"	202596E 323-801-028	"	"	"	"	"	"	"	"	202295 323-870-210	Needle (factory setting) DCx1 #18 423224431
	6mm 1/4"	202597E 323-801-029	"	"	"	"	"	"	"	"	"	
	7mm 9/32"	204797 323-801-042	"	"	"	"	"	"	"	"	"	
	8mm 5/16"	204731 323-801-041	"	"	"	"	"	"	"	"	"	
504/IV-S-16 Seaming bulky knitwear	3mm 1/8"	202542E 323-801-026	204678 323-830-051	204691 323-830-058	"	"	"	"	"	204702 323-810-009	201127 323-870-211	
	4mm 5/32"	202546E 323-801-027	"	"	"	"	"	"	"	"	"	
	5mm 3/16"	202596E 323-801-028	"	"	"	"	"	"	"	"	202295 323-870-210	Needle (factory setting) DCx1 #14 423223631
	6mm 1/4"	202597E 323-801-029	"	"	"	"	"	"	"	"	"	

*See page 77 for its components.

RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204278 323-810-215	1	9-12	027-032	65-80	503/IV
204704 323-810-011	3	13-16	034-040	85-100	
204705 323-810-012	5	17-21	042-051	100-140	

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204062 323-810-218	2	9-12	027-032	65-80	504/IV
204702 323-810-009	4	13-16	034-040	85-100	
204703 323-810-010	6	17-21	042-051	100-140	
204663 323-810-008	7	9-14	027-036	65-90	514/IV

From the library of: Superior Sewing Machine & Supply LLC

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

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Auxiliary feed	Presser foot complete	Needle guard (front)	Needle guard (rear)	Needle bar	Right looper	Lower knife	Others
504/IV-S-17 Seaming knits	3mm 1/8"	202542E 323-801-026	204675 323-830-029	204690 323-830-057	204674 323-830-054	*204956 323-820-026	204634 323-561-009	204635 323-561-010	204623 323-591-003	204062 323-810-218	201127 323-870-211	
	4mm 5/32"	202546E 323-801-027	"	"	"	"	"	"	"	"	"	Needle (factory setting) DCx1 #11 423222831
	5mm 3/16"	202596E 323-801-028	"	"	"	"	"	"	"	"	202295 323-870-210	
	6mm 1/4"	202597E 323-801-029	"	"	"	"	"	"	"	"	"	
514/IV-11 2-needle seaming woven fabrics	2x2mm 5/64x5/64"	205255 323-801-047	"	204676 323-830-033	"	*204954 323-820-024	204659 323-561-011	204660 323-561-012	204624 323-591-004	204663 323-810-008	201127 323-870-211	
	2x3mm 5/64x1/8"	"	"	"	"	"	"	"	"	"	202295 323-870-210	Needle (factory setting) DCx1 #14 423223631
	2x4mm 5/64x5/32"	202554E 323-801-030	"	"	"	*204955 323-820-025	"	"	"	"	"	
	2x5mm 5/64x3/16"	202499E 323-801-031	"	"	"	"	"	"	"	"	"	
514/IV-12 2-needle seaming woven fabrics	2x3mm 5/64x1/8"	202702 323-801-070	204692 323-830-030	204693 323-830-034	"	*204954 323-820-024	"	"	"	"	"	
	2x4mm 5/64x5/32"	202675 323-801-315	"	"	"	*204955 323-820-025	"	"	"	"	"	Needle (factory setting) DCx1 #11 423222831
	3x5mm 1/8x3/16"	204914 323-801-046	204838 323-830-042	"	"	*202998 323-820-299	"	"	204837 323-591-006	"	"	

cf. left bottom in this page - sketch for 3x5mm gauge

*See page 77 for its components.

504/IV-S-17

514/IV-11

514/IV-12

514/IV-12

RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

Right looper Part number	Mark	for needle size Singer	W & G	Metric	Model
204278 323-810-215	1	9-12	027-032	65-80	503/IV
204704 323-810-011	3	13-16	034-040	85-100	
204705 323-810-012	5	17-21	042-051	100-140	

Right looper Part number	Mark	for needle size Singer	W & G	Metric	Model
204062 323-810-218	2	9-12	027-032	65-80	504/IV
204702 323-810-009	4	13-16	034-040	85-100	
204703 323-810-010	6	17-21	042-051	100-140	
204663 323-810-008	7	9-14	027-036	65-90	514/IV

From the library of: Superior Sewing Machine & Supply LLC

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

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Auxiliary feed	Presser foot complete	Needle guard (front)	Needle guard (rear)	Needle bar	Right looper	Lower knife	Others
514/IV-20 2-needle seaming light knits	1.5x2mm 1/16x5/64"	204910 323-801-043	204729 323-830-052	204730 323-830-059	204674 323-830-054	*204954 323-820-024	204659 323-561-011	204660 323-561-012	204872 323-591-007	204663 323-810-008	202295 323-870-210	Needle (factory setting) DCx3 #9
	1.5x3mm 1/16x1/8"	204911 323-801-044	"	"	"	"	"	"	"	"	"	
	2x2mm 5/64x5/64"	205256 323-801-048	"	"	"	"	"	"	204624 323-591-004	"	"	DCx1 #9 423222631
	2x3mm 5/64x1/8"	205257 323-801-049	"	"	"	"	"	"	"	"	"	
514/IV-22 2-needle intermittent shirring	2x2mm 5/64x5/64"	205255 323-801-047	204723 323-830-032	204724 323-830-036	"	*204952 323-820-018	"	"	"	"	201127 323-870-211	Needle (factory setting) DCx1 #14 423223631 Shirring attachment
	2x3mm 5/64x1/8"	"	"	"	"	"	"	"	"	"	202295 323-870-210	
	2x4mm 5/64x5/32"	205554E 323-801-030	"	"	"	"	"	"	"	"	"	
	2x5mm 5/64x3/16"	202499E 323-801-031	"	"	"	"	"	"	"	"	"	
514/IV-23 2-needle intermittent shirring	2x4mm 5/64x5/32"	205243 323-801-364	"	"	204677 323-830-037	"	"	"	"	"	"	Needle (factory setting) DCx27 #14 423243631 Shirring attachment
	2x5mm 5/64x3/16"	205244 323-801-365	"	"	"	"	"	"	"	"	"	

514/IV-20 514/IV-22 514/IV-23

*See page 77 for its components.

RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204278 323-810-215	1	9-12	027-032	65-80	503/IV
204704 323-810-011	3	13-16	034-040	85-100	
204705 323-810-012	5	17-21	042-051	100-140	

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204062 323-810-218	2	9-12	027-032	65-80	504/IV
204702 323-810-009	4	13-16	034-040	85-100	
204703 323-810-010	6	17-21	042-051	100-140	
204663 323-810-008	7	9-14	027-036	65-90	514/IV

From the library of: Superior Sewing Machine & Supply LLC

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

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Auxiliary feed	Presser foot complete	Needle guard (front)	Needle guard (rear)	Needle bar	Right looper	Lower knife	Others
514/IV-41 2-needle seaming on stretch fabrics	2x4mm 5/64x5/32"	205243 323-801-364	204675 323-830-029	204676 323-830-033	204677 323-830-037	*202995 323-820-283	204659 323-561-011	204660 323-561-012	204624 323-591-004	204663 323-810-008	202295 323-870-210	Needle (factory setting) DCx27 #14 423243631
	2x5mm 5/64x3/16"	205244 323-801-365	"	"	"	"	"	"	"	"	"	
514/IV-42 2-needle seaming on stretch fabrics	2x3mm 5/64x1/8"	202982 323-801-355	204692 323-830-030	204693 323-830-034	"	*202996 323-820-284	"	"	"	"	"	
	2x4mm 5/64x5/32"	202983 323-801-356	"	"	"	*202997 323-820-289	"	"	"	"	"	Needle (factory setting) DCx27 #14 423243631
	3x5mm 1/8x3/16"	205245 323-801-357	204838 323-830-042	"	"	*202998 323-820-299	"	"	204837 323-591-006	"	"	
514/IV-S-11 2-needle seaming bulky knits	2x3mm 5/64x1/8"	205255 323-801-047	204678 323-830-051	204691 323-830-058	204674 323-830-054	*204954 323-820-024	"	"	204624 323-591-004	"	"	Needle (factory setting) DCx1 #14 423223631
	2x4mm 5/64x5/32"	202554E 323-801-030	"	"	"	*204955 323-820-025	"	"	"	"	"	

cf. left bottom in this page - sketch for 3x5mm gauge

*See page 77 for its components.

514/IV-41 514/IV-42 514/IV-S-11

514/IV-42

RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

Right looper Part number	Mark	for needle size Singer	W & G	Metric	Model
204278 323-810-215	1	9-12	027-032	65-80	503/IV
204704 323-810-011	3	13-16	034-040	85-100	
204705 323-810-012	5	17-21	042-051	100-140	

Right looper Part number	Mark	for needle size Singer	W & G	Metric	Model
204062 323-810-218	2	9-12	027-032	65-80	504/IV
204702 323-810-009	4	13-16	034-040	85-100	
204703 323-810-010	6	17-21	042-051	100-140	
204663 323-810-008	7	9-14	027-036	65-90	514/IV

From the library of: Superior Sewing Machine & Supply LLC

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

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Auxiliary feed	Presser foot complete	Needle guard (front)	Needle guard (rear)	Needle bar	Right looper	Lower knife	Others
514/IV-S-13 2-needle seaming light knits	1.5x2mm 1/16x5/64"	202899 323-801-071	204692 323-830-030	204693 323-830-034	204674 323-830-054	*204954 323-820-024	204659 323-561-011	204660 323-561-012	204872 323-591-007	204663 323-810-008	202295 323-870-210	Needle (factory setting) DCx3 #9
	1.5x3mm 1/16x1/8"	202674 323-801-040	"	"	"	"	"	"	"	"	"	
	2x3mm 5/64x1/8"	202702 323-801-070	"	"	"	"	"	"	204624 323-591-004	"	"	DCx1 #9 423222631
	2x4mm 5/64x5/32"	202675 323-801-315	"	"	"	*204955 323-820-025	"	"	"	"	"	
514/IV-S-14 2-needle seaming knits	2x2mm 5/64x5/64"	205255 323-801-047	204675 323-830-029	204690 323-830-057	"	*204954 323-820-024	"	"	"	"	201127 323-870-211	
	2x3mm 5/64x1/8"	"	"	"	"	"	"	"	"	"	202295 323-870-210	Needle (factory setting) DCx1 #11 423222831
	2x4mm 5/64x5/32"	202554E 323-801-030	"	"	"	*204955 323-820-025	"	"	"	"	"	
514/IV-S-15 2-needle seaming knits	2x2mm 5/64x5/64"	205255 323-801-047	"	204676 323-830-033	"	*204954 323-820-024	"	"	"	"	201127 323-870-211	
	2x3mm 5/64x1/8"	"	"	"	"	"	"	"	"	"	202295 323-870-210	Needle (factory setting) DCx1 #9 423222631
	2x4mm 5/64x5/32"	202554E 323-801-030	"	"	"	*204955 323-820-025	"	"	"	"	"	

*See page 77 for its components.

RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

Right looper Part number	Mark	for needle size Singer	W & G	Metric	Model
204278 323-810-215	1	9-12	027-032	65-80	503/IV
204704 323-810-011	3	13-16	034-040	85-100	
204705 323-810-012	5	17-21	042-051	100-140	

Right looper Part number	Mark	for needle size Singer	W & G	Metric	Model
204062 323-810-218	2	9-12	027-032	65-80	504/IV
204702 323-810-009	4	13-16	034-040	85-100	
204703 323-810-010	6	17-21	042-051	100-140	
204663 323-810-008	7	9-14	027-036	65-90	514/IV

From the library of: Superior Sewing Machine & Supply LLC

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

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Auxiliary feed	Presser foot complete	Needle guard (front)	Needle guard (rear)	Needle bar	Right looper	Lower knife	Others
514/IV-S-18 2-needle intermittent shirring	2x2mm 5/64x5/64"	205255 323-801-047	204723 323-830-032	204724 323-830-036	204674 323-830-054	*204952 323-820-018	204659 323-561-011	204660 323-561-012	204624 323-591-004	204663 323-810-008	201127 323-870-211	Needle (factory setting) DCx1 #14 423223631 Shirring attachment
	2x3mm 5/64x1/8"	"	"	"	"	"	"	"	"	"	202295 323-870-210	
	2x4mm 5/64x5/32"	202554E 323-801-030	"	"	"	"	"	"	"	"	"	
514/IV-S-19 2-needle seaming	2x4mm 5/64x5/32"	205243 323-801-364	204675 323-830-029	204676 323-830-033	204677 323-830-037	*202995 323-820-283	"	"	"	"	"	Needle (factory setting) DCx1 #14 423223631
514/IV-S-20 2-needle seaming	1.5x3mm 1/16x1/8"	202981 323-801-354	204692 323-830-030	204693 323-830-034	"	*202996 323-820-284	"	"	204872 323-591-007	"	"	Needle (factory setting) DCx3 #9
	2x3mm 5/64x1/8"	202982 323-801-355	"	"	"	"	"	"	204624 323-591-004	"	"	DCx1 #11 423222831
	2x4mm 5/64x5/32"	202983 323-801-356	"	"	"	*202997 323-820-289	"	"	"	"	"	

*See page 77 for its components.

RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204278 323-810-215	1	9-12	027-032	65-80	503/IV
204704 323-810-011	3	13-16	034-040	85-100	
204705 323-810-012	5	17-21	042-051	100-140	

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204062 323-810-218	2	9-12	027-032	65-80	504/IV
204702 323-810-009	4	13-16	034-040	85-100	
204703 323-810-010	6	17-21	042-051	100-140	
204663 323-810-008	7	9-14	027-036	65-90	514/IV

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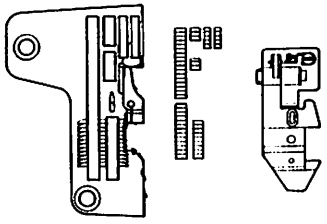
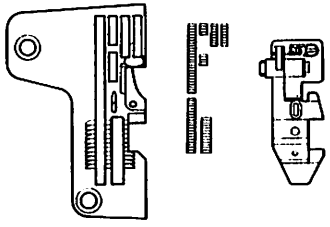
COMPONENT PARTS – PRESSER FOOT COMPLETE

Presser foot complete	body	chaining-off finger	chaining-off finger screw	hinge spring	fabric guard	fabric guard screw	uncurler	uncurler screw
202992 323-820-280	205252 323-820-285	201224B 323-863-007	5089 323-600-050	201156 323-643-001	201265B 323-854-200	1231 323-600-051	205342 323-560-021	5030 323-600-202
202993 323-820-281	202799 323-820-286	"	"	"	"	"	"	"
202994 323-820-282	205253 323-820-287	"	"	"	"	"	"	"
202995 323-820-283	"	201310A 323-863-201	"	"	"	"	"	"
202996 323-820-284	202799 323-820-286	201396B 323-863-215	"	"	"	"	"	"
202997 323-820-289	"	201310A 323-863-201	"	"	"	"	"	"
202998 323-820-299	205254 323-820-288	201461A 323-863-216	"	"	"	"	"	"
204951 323-820-017	205135 323-820-013	— — —	"	"	— — —	— — —	"	"
204952 323-820-018	205136 323-820-014	— — —	"	"	— — —	— — —	"	"
204953 323-820-023	201473B 323-820-022	201224B 323-863-007	"	"	— — —	— — —	"	"
204954 323-820-024	201230C 323-820-019	201396B 323-863-215	"	"	201265B 323-854-200	1231 323-600-051	204668 323-560-020	"
204955 323-820-025	"	201310A 323-863-201	"	"	"	"	"	"
204956 323-820-026	"	201224B 323-863-007	"	"	"	"	"	"
205226 323-820-220	201152E 323-820-021	201155C 323-863-217	"	"	— — —	— — —	205342 323-560-021	"

From the library of: Superior Sewing Machine & Supply LLC

COMMON PARTS: 204782 (323-561-014) – Needle guard (front) for right needle
204781 (323-561-013) – Needle guard (rear) for right needle
204072 (323-810-216) – Left looper
204161 (323-870-213) – Lower knife

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Presser foot complete	Presser foot fabric guard	Needle guard for 401 needle (front)	Needle guard for 401 needle (rear)	Needle bar complete	Right looper	401 looper	Upper knife	Others
515/IV-26 **516/IV-26** General seaming on woven and knit fabrics	2x3mm 5/64x1/8"	204343A 323-801-255	204248B 323-830-314	204250B 323-830-316	204349A 323-820-255	204173A 323-560-221	204536 323-561-211	204521 323-561-219	204877 323-843-001	204278 323-810-215	204314A 323-810-217	201121A 323-870-214	
	2x4mm 5/64x5/32"	204344A 323-801-256	"	"	"	"	"	"	"	"	"	"	Needle (factory setting) DCx27 #11 423242831
	2x5mm 5/64x3/16"	204345A 323-801-257	"	"	"	"	"	"	"	"	"	"	
	2x6mm 5/64x1/4"	204346A 323-801-258	"	"	"	"	"	"	"	"	"	"	
	3x3mm 1/8x1/8"	204294B 323-801-275	"	"	204167B 323-820-260	"	204042 323-561-218	204522 323-561-220	204878 323-843-002	204704 323-810-011	"	"	
	3x4mm 1/8x5/32"	204039B 323-801-276	"	"	"	"	"	"	"	"	"	"	
	3x5mm 1/8x3/16"	204252B 323-801-277	"	"	"	"	"	"	"	"	"	"	
	3x6mm 1/8x1/4"	204295B 323-801-278	"	"	"	"	"	"	"	"	"	"	DCx27 #14 423243631
	5x3mm 3/16x1/8"	204358A 323-801-263	"	"	204433A 323-820-257	"	"	"	204879 323-843-003	"	204431 323-810-219	"	
	5x4mm 3/16x5/32"	204359A 323-801-264	"	"	"	"	"	"	"	"	"	"	
	5x5mm 3/16x3/16"	204360A 323-801-310	"	"	"	"	"	"	"	"	"	"	
	5x6mm 3/16x1/4"	204361A 323-801-266	"	"	"	"	"	"	"	"	"	"	
515/IV-27 **516/IV-27** General seaming and serging on light weight materials	2x3mm 5/64x1/8"	204362 323-801-267	204395 323-830-244	204409 323-830-243	204440 323-820-258	204447 323-560-234	204536 323-561-211	204521 323-561-219	204877 323-843-001	204278 323-810-215	204314A 323-810-217	202527 323-870-207	
	2x4mm 5/64x5/32"	204363 323-801-268	"	"	"	"	"	"	"	"	"	"	
	2x5mm 5/64x3/16"	204364 323-801-269	"	"	"	"	"	"	"	"	"	"	
	2x6mm 5/64x1/4"	204365 323-801-270	"	"	"	"	"	"	"	"	"	"	Needle (factory setting) DCx27 #11 423242831
	3x3mm 1/8x1/8"	204366 323-801-271	"	"	204443 323-820-259	"	204042 323-561-218	204522 323-561-220	204878 323-843-002	"	"	"	
	3x4mm 1/8x5/32"	204367 323-801-272	"	"	"	"	"	"	"	"	"	"	
	3x5mm 1/8x3/16"	204368 323-801-273	"	"	"	"	"	"	"	"	"	"	
	3x6mm 1/8x1/4"	204369 323-801-274	"	"	"	"	"	"	"	"	"	"	

RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204278 323-810-215	1	9-12	027-032	65-80	515/IV
204704 323-810-011	3	13-16	034-040	85-100	
204705 323-810-012	5	17-21	042-051	100-140	

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204062 323-810-218	2	9-12	027-032	65-80	516/IV
204702 323-810-009	4	13-16	034-040	85-100	
204703 323-810-010	6	17-21	042-051	100-140	

From the library of: Superior Sewing Machine & Supply LLC

COMMON PARTS: 204782 (323-561-014) – Needle guard (front) for right needle
204781 (323-561-013) – Needle guard (rear) for right needle
204072 (323-810-216) – Left looper
204161 (323-870-213) – Lower knife

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Presser foot complete	Presser foot fabric guard	Needle guard for 401 needle (front)	Needle guard for 401 needle (rear)	Needle bar complete	Right looper	401 looper	Upper knife	Others
515/IV-28 **516/IV-28** General seaming on permanent-press fabrics	2x3mm 5/64x1/8"	204343A 323-801-255	204125B 323-830-237	204254B 323-830-238	204349A 323-820-255	204173A 323-560-221	204536 323-561-211	204521 323-561-219	204877 323-843-001	204278 323-810-215	204314A 323-810-217	201121A 323-870-214	
	2x4mm 5/64x5/32"	204344A 323-801-256	"	"	"	"	"	"	"	"	"	"	
	2x5mm 5/64x3/16"	204345A 323-801-257	"	"	"	"	"	"	"	"	"	"	
	2x6mm 5/64x1/4"	204346A 323-801-258	"	"	"	"	"	"	"	"	"	"	Needle (factory setting)
	3x3mm 1/8x1/8"	204294B 323-801-275	"	"	204167B 323-820-260	"	204042 323-561-218	204522 323-561-220	204878 323-843-002	"	"	"	DCx27 #11 423242831
	3x4mm 1/8x5/32"	204039B 323-801-276	"	"	"	"	"	"	"	"	"	"	
	3x5mm 1/8x3/16"	204252B 323-801-277	"	"	"	"	"	"	"	"	"	"	
	3x6mm 1/8x1/4"	204295B 323-801-278	"	"	"	"	"	"	"	"	"	"	
515/IV-29 **516/IV-29** General seaming and serging on light to medium weight woven and knit fabrics	2x3mm 5/64x1/8"	204362 323-801-267	204396 323-830-248	204410 323-830-247	204440 323-820-258	204447 323-560-234	204536 323-561-211	204521 323-561-219	204877 323-843-001	"	"	202527 323-870-207	
	2x4mm 5/64x5/32"	204363 323-801-268	"	"	"	"	"	"	"	"	"	"	Needle (factory setting)
	2x5mm 5/64x3/16"	204364 323-801-269	"	"	"	"	"	"	"	"	"	"	DCx27 #11 423242831
	2x6mm 5/64x1/4"	204365 323-801-270	"	"	"	"	"	"	"	"	"	"	
	3x3mm 1/8x1/8"	204366 323-801-271	"	"	204443 323-820-259	"	204042 323-561-218	204522 323-561-220	204878 323-843-002	204704 323-810-011	"	"	
	3x4mm 1/8x5/32"	204367 323-801-272	"	"	"	"	"	"	"	"	"	"	DCx27 #14 423243631
	3x5mm 1/8x3/16"	204368 323-801-273	"	"	"	"	"	"	"	"	"	"	
	3x6mm 1/8x1/4"	204369 323-801-274	"	"	"	"	"	"	"	"	"	"	

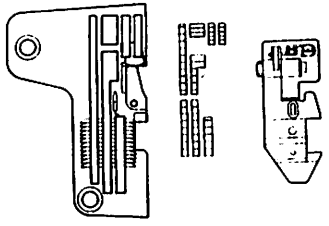
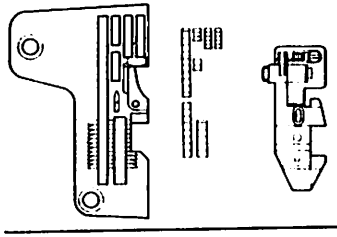
RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204278 323-810-215	1	9-12	027-032	65-80	515/IV
204704 323-810-011	3	13-16	034-040	85-100	
204705 323-810-012	5	17-21	042-051	100-140	

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204062 323-810-218	2	9-12	027-032	65-80	516/IV
204702 323-810-009	4	13-16	034-040	85-100	
204703 323-810-010	6	17-21	042-051	100-140	

From the library of: Superior Sewing Machine & Supply LLC

COMMON PARTS: 204782 (323-561-014) – Needle guard (front) for right needle
204781 (323-561-013) – Needle guard (rear) for right needle
204072 (323-810-216) – Left looper
204161 (323-870-213) – Lower knife

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Presser foot complete	Presser foot fabric guard	Needle guard for 401 needle (front)	Needle guard for 401 needle (rear)	Needle bar complete	Right looper	401 looper	Upper knife	Others
515/IV-31 **516/IV-31** Seaming on coarse woven fabrics	2x3mm 5/64x1/8"	204370 323-801-279	204400 323-830-260	204414 323-830-259	204349A 323-820-255	204173A 323-560-221	204536 323-561-211	204521 323-561-219	204877 323-843-001	204704 323-810-011	204314A 323-810-217	201121A 323-870-214	
	2x4mm 5/64x5/32"	204371 323-801-280	"	"	"	"	"	"	"	"	"	"	
	2x5mm 5/64x3/16"	204372 323-801-281	"	"	"	"	"	"	"	"	"	"	
	2x6mm 5/64x1/4"	204373 323-801-282	"	"	"	"	"	"	"	"	"	"	
	3x3mm 1/8x1/8"	204374 323-801-283	"	"	204167B 323-820-260	"	204042 323-561-218	204522 323-561-220	204878 323-843-002	"	"	"	
	3x4mm 1/8x5/32"	204375 323-801-284	"	"	"	"	"	"	"	"	"	"	Needle (factory setting) DCx27 #16 423244031
	3x5mm 1/8x3/16"	204376 323-801-285	"	"	"	"	"	"	"	"	"	"	
	3x6mm 1/8x1/4"	204377 323-801-286	"	"	"	"	"	"	"	"	"	"	
	5x3mm 3/16x1/8"	204378 323-801-287	204394 323-830-262	204416 323-830-261	204433A 323-820-257	"	"	"	204879 323-843-003	"	204431 323-810-219	"	
	5x4mm 3/16x5/32"	204379 323-801-288	"	"	"	"	"	"	"	"	"	"	
	5x5mm 3/16x3/16"	204380 323-801-289	"	"	"	"	"	"	"	"	"	"	
	5x6mm 3/16x1/4"	204381 323-801-290	"	"	"	"	"	"	"	"	"	"	
515/IV-32 **516/IV-32** General seaming on medium-heavy woven materials	3x3mm 1/8x1/8"	204366 323-801-271	204397 323-830-264	204411 323-830-263	204443 323-820-259	204447 323-560-234	"	"	204878 323-843-002	"	204314A 323-810-217	202527 323-870-207	
	3x4mm 1/8x5/32"	204367 323-801-272	"	"	"	"	"	"	"	"	"	"	
	3x5mm 1/8x3/16"	204368 323-801-273	"	"	"	"	"	"	"	"	"	"	Needle (factory setting) DCx27 #16 423244031
	3x6mm 1/8x1/4"	204369 323-801-274	"	"	"	"	"	"	"	"	"	"	

RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

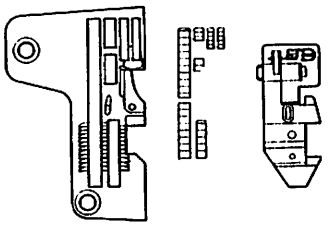
Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204278 323-810-215	1	9-12	027-032	65-80	515/IV
204704 323-810-011	3	13-16	034-040	85-100	
204705 323-810-012	5	17-21	042-051	100-140	

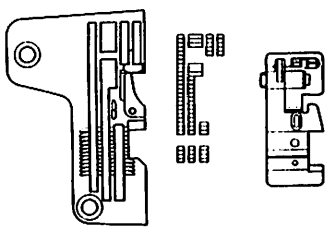
Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204062 323-810-218	2	9-12	027-032	65-80	516/IV
204702 323-810-009	4	13-16	034-040	85-100	
204703 323-810-010	6	17-21	042-051	100-140	

From the library of: Superior Sewing Machine & Supply LLC

COMMON PARTS: 204782 (323-561-014) – Needle guard (front) for right needle
204781 (323-561-013) – Needle guard (rear) for right needle
204072 (323-810-216) – Left looper
204161 (323-870-213) – Lower knife

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Presser foot complete	Presser foot fabric guard	Needle guard for 401 needle (front)	Needle guard for 401 needle (rear)	Needle bar complete	Right looper	401 looper	Upper knife	Others
515/IV-33 **516/IV-33** Seaming and turning corners on coarse woven materials	3x3mm 1/8x1/8"	204294B 323-801-275	204394 323-830-262	204408 323-830-267	204167B 323-820-260	204173A 323-560-221	204042 323-561-218	204522 323-561-220	204878 323-843-002	204704 323-810-011	204314A 323-810-217	201121A 323-870-214	
	3x4mm 1/8x5/32"	204039B 323-801-276	"	"	"	"	"	"	"	"	"	"	
	3x5mm 1/8x3/16"	204252B 323-801-277	"	"	"	"	"	"	"	"	"	"	
	3x6mm 1/8x1/4"	204295B 323-801-278	"	"	"	"	"	"	"	"	"	"	Needle (factory setting) DCx27 #16 423244031
	5x3mm 3/16x1/8"	204358A 323-801-263	"	"	204433A 323-820-257	"	"	"	204879 323-843-003	"	204431 323-810-219	"	
	5x4mm 3/16x5/32"	204359A 323-801-264	"	"	"	"	"	"	"	"	"	"	
	5x5mm 3/16x3/16"	204360A 323-801-310	"	"	"	"	"	"	"	"	"	"	
	5x6mm 3/16x1/4"	204361A 323-801-266	"	"	"	"	"	"	"	"	"	"	
515/IV-38 **516/IV-38** 3:1 intermittent (knee controlled) shirring on dress weight materials	2x3mm 5/64x1/8"	204935 323-801-050	204931 323-830-061	204420 323-830-291	204454 323-820-271	204460 323-560-235	204536 323-561-211	204521 323-561-219	204877 323-843-001	204278 323-810-215	204314A 323-810-217	"	Needle (factory setting) DCx27 #11 423242831
	2x4mm 5/64x5/32"	204936 323-801-051	"	"	"	"	"	"	"	"	"	"	
	2x5mm 5/64x3/16"	204937 323-801-052	"	"	"	"	"	"	"	"	"	"	
	2x6mm 5/64x1/4"	204938 323-801-053	"	"	"	"	"	"	"	"	"	"	Shirring attachment
	3x3mm 1/8x1/8"	204939 323-801-054	"	"	204456 323-820-272	"	204042 323-561-218	204522 323-561-220	204878 323-843-002	204704 323-810-011	"	"	
	3x4mm 1/8x5/32"	204940 323-801-055	"	"	"	"	"	"	"	"	"	"	
	3x5mm 1/8x3/16"	204941 323-801-056	"	"	"	"	"	"	"	"	"	"	
	3x6mm 1/8x1/4"	204942 323-801-057	"	"	"	"	"	"	"	"	"	"	DCx27 #14 423243631
	5x3mm 3/16x1/8"	204943 323-801-058	204933 323-830-063	204422 323-830-295	204458 323-820-273	"	"	"	204879 323-843-003	"	204431 323-810-219	"	
	5x4mm 3/16x5/32"	204944 323-801-059	"	"	"	"	"	"	"	"	"	"	
	5x5mm 3/16x3/16"	204945 323-801-060	"	"	"	"	"	"	"	"	"	"	
	5x6mm 3/16x1/4"	204946 323-801-061	"	"	"	"	"	"	"	"	"	"	





RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204278 323-810-215	1	9-12	027-032	65-80	515/IV
204704 323-810-011	3	13-16	034-040	85-100	
204705 323-810-012	5	17-21	042-051	100-140	

Right looper		for needle size			Model
Part number	Mark	Singer	W & G	Metric	
204062 323-810-218	2	9-12	027-032	65-80	516/IV
204702 323-810-009	4	13-16	034-040	85-100	
204703 323-810-010	6	17-21	042-051	100-140	

From the library of: Superior Sewing Machine & Supply LLC

COMMON PARTS: 204782 (323-561-014) – Needle guard (front) for right needle
204781 (323-561-013) – Needle guard (rear) for right needle
204072 (323-810-216) – Left looper
204161 (323-870-213) – Lower knife

Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Presser foot complete	Presser foot fabric guard	Needle guard for 401 needle (front)	Needle guard for 401 needle (rear)	Needle bar complete	Right looper	401 looper	Upper knife	Others
515/IV-39 **516/IV-39** 3:1 intermittent (knee controlled) shirring on medium heavy materials	2x3mm 5/64x1/8"	204935 323-801-050	204932 323-830-062	204421 323-830-245	204454 323-820-271	204460 323-560-235	204536 323-561-211	204521 323-561-219	204877 323-843-001	204278 323-810-215	204314A 323-810-217	201121A 323-870-214	
	2x4mm 5/64x5/32"	204936 323-801-051	"	"	"	"	"	"	"	"	"	"	Needle (factory setting)
	2x5mm 5/64x3/16"	204937 323-801-052	"	"	"	"	"	"	"	"	"	"	DCx27 #16 423244031
	2x6mm 5/64x1/4"	204938 323-801-053	"	"	"	"	"	"	"	"	"	"	
	3x3mm 1/8x1/8"	204939 323-801-054	"	"	204456 323-820-272	"	204042 323-561-218	204522 323-561-220	204878 323-843-002	204704 323-810-011	"	"	
	3x4mm 1/8x5/32"	204940 323-801-055	"	"	"	"	"	"	"	"	"	"	Shirring attachment
	3x5mm 1/8x3/16"	204941 323-801-056	"	"	"	"	"	"	"	"	"	"	
	3x6mm 1/8x1/4"	204942 323-801-057	"	"	"	"	"	"	"	"	"	"	
	5x3mm 3/16x1/8"	204943 323-801-058	204934 323-830-064	204423 323-830-297	204458 323-820-273	"	"	"	204879 323-843-003	"	204431 323-810-219	"	
	5x4mm 3/16x5/32"	204944 323-801-059	"	"	"	"	"	"	"	"	"	"	
	5x5mm 3/16x3/16"	204945 323-801-060	"	"	"	"	"	"	"	"	"	"	
	5x6mm 3/16x1/4"	204946 323-801-061	"	"	"	"	"	"	"	"	"	"	
515/IV-51 516/IV-51 Seaming and crossing seams on heavy coarse woven materials	5x5mm 3/16x3/16"	204700 323-801-034	204394 323-830-262	204416 323-830-261	204915 323-820-027	204683 323-560-029	"	"	"	204705 323-810-012	"	"	Needle (factory setting)
	5x6mm 3/16x1/4"	204701 323-801-035	"	"	"	"	"	"	"	"	"	"	DCx1 #21 (B-27 #120) 423225231
515/IV-52 516/IV-52 Seaming and crossing seams on heavy coarse woven materials	5x5mm 3/16x3/16"	204528 323-801-358	"	204408 323-830-267	"	"	"	"	"	"	"	"	Needle (factory setting)
	5x6mm 3/16x1/4"	204529 323-801-359	"	"	"	"	"	"	"	"	"	"	DCx1 #21 (B-27 #120) 423225231

See page 81 for RIGHT LOOPER REFERENCE TABLE

From the library of: Superior Sewing Machine & Supply LLC

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323-502-209	204163A	51	1
323-502-213	204139A	45	34
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323-505-010	204760	59	13
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323-510-248	204223	29	9
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323-510-251	204224	29	12
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323-510-265	204210A	23	10
323-510-265	204210A	27	11
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323-518-202	204116A	47	19
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323-525-231	204075	41	1
323-525-232	204100	45	1
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323-525-236	204147	49	5
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323-535-002	218	65	3
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323-561-219	204521	82	
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323-576-218	202607	35	1
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323-576-225	204517	43	11
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323-590-003	234	65	24
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303085	323-683-016	61	15
303135	323-900-017	59	
303138	323-900-024	61	
304692	323-830-030	70	
522001	323-716-007	61	44
530001	323-736-004	61	45
596002	323-891-003	61	47
600005	323-639-023	61	55
600006	323-639-024	61	56
600007	323-639-025	61	57
601001	323-636-006	61	48
601011	323-636-007	61	49
601012	323-635-003	61	50
601013	323-636-011	61	51
601014	323-636-008	61	52
601015	323-636-009	61	53
601016	323-636-010	61	54
706001	323-900-020	59	41
742008	323-900-019	59	40
760009	323-900-021	59	48
811002	323-795-001	59	31
Parts for Eye guard			
1170-3	323-600-046	25	48
1170-3	323-600-046	29	47
2918	323-600-073	25	44
2918	323-600-073	29	43
5003	323-600-227	25	51
5003	323-600-227	29	50
5099	323-630-009	25	45
5099	323-630-009	25	52
5099	323-630-009	29	44
5099	323-630-009	29	51
200821	323-615-013	25	49
200821	323-615-013	29	48
204922	323-728-012	25	47
204922	323-728-012	29	46
204924	323-561-019	25	43
204924	323-561-019	29	42
204925	323-615-032	25	46
204925	323-615-032	29	45
204982	323-505-012	25	50
204982	323-505-012	29	49
204988	323-561-018	25	
204988	323-561-018	29	

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SEWING ORGANIZATIONS FOR 500/IV LINE

TYPE NO.	NO. OF THRDS.	FEDERAL STITCH	FEED DESIGN	FEED RATIO	OPERATION AND FABRIC
503/IV-44	2	503	2 row wide - medium	1.5:1	serging woven fabric
503/IV-48	2	503	3 row long - medium	1.5:1	serging woven fabric
504/IV-7	3	504	3 row long - medium	2:1	seaming woven & knits
504/IV-17	3	504	3 row long - medium	3:1	shirring-intermittent
504/IV-19	3	504	2 row narrow-medium	2:1	seaming light knits
504/IV-21	3	504	3 row long - medium	3:1	shirring-intermittent
504/IV-25	3	505	2 row narrow-medium	2:1	hemming light knits
504/IV-43	3	504	3 row short -medium	2:1	seaming light knits
504/IV-45	3	504	2 row wide - medium	2:1	seaming medium-heavy knits
504/IV-47	3	504	3 row long - medium	2:1	seaming woven and knits
504/IV-S-10	3	504	3 row long - coarse	2:1	seaming jeans
504/IV-S-16	3	504	3 row long - coarse	3:1	seaming bulky knitwear
504/IV-S-17	3	504	3 row long - medium	3:1	seaming knits
504/IV-S-45	3	504	2 row wide - medium	3:1	seaming sweaters
504/IV-S-47	3	504	3 row long - medium	3:1	seaming sweaters
514/IV-11	4	512	3 row long - medium	2:1	2 needle seaming woven fabrics
514/IV-12	4	512	2 row wide - medium	2:1	2 needle seaming woven fabrics
514/IV-20	4	514	2 row narrow-medium	2:1	2 needle seaming light knits
514/IV-22	4	512	3 row long - medium	3:1	2 needle shirring-intermittent
514/IV-23	4	512	3 row long - medium	3:1	2 needle shirring-intermittent
514/IV-41	4	512	3 row long - medium	2:1	2 needle seaming
514/IV-42	4	512	2 row wide - medium	2:1	2 needle seaming
514/IV-S-11	4	514	3 row long - coarse	3:1	2 needle seaming bulky knits
514/IV-S-13	4	514	2 row wide - medium	2:1	2 needle seaming light knits
514/IV-S-14	4	514	3 row long - medium	3:1	2 needle seaming knits
514/IV-S-15	4	514	3 row long - medium	2:1	2 needle seaming knits
514/IV-S-18	4	514	3 row long - medium	3:1	2 needle shirring-intermittent
514/IV-S-19	4	514	3 row long - medium	2:1	2 needle seaming
514/IV-S-20	4	514	2 row wide - medium	2:1	2 needle seaming
514/IV-S-41	4	512	3 row long - medium	3:1	2 needle seaming
515/IV-26	4	515	2 row wide - medium	2:1	seaming
515/IV-27	4	515	2 row narrow-fine	2:1	seaming
515/IV-28	4	515	2 row wide - fine	2:1	seaming
515/IV-29	4	515	2 row narrow-medium	2:1	seaming
515/IV-30	4	515	3 row wide - medium	2:1	seaming
515/IV-31	4	515	3 row wide - coarse	2:1	seaming
515/IV-32	4	515	2 row narrow-coarse	2:1	seaming
515/IV-33	4	515	2 row wide - coarse	2:1	seaming
515/IV-34	4	515	3 row narrow-fine	2:1	seaming
515/IV-35	4	515	3 row narrow-medium	2:1	seaming
515/IV-36	4	515	3 row narrow-coarse	2:1	seaming
515/IV-37	4	515	3 row wide - fine	2:1	seaming
515/IV-38	4	515	3 row wide - medium	3:1	shirring- intermittent
515/IV-39	4	515	3 row wide - coarse	3:1	shirring- intermittent
515/IV-51	4	515	3 row wide - coarse	2:1	seaming - tractor foot
515/IV-52	4	515	2 row wide - coarse	2:1	seaming - tractor foot
516/IV-26	5	516	2 row wide - medium	2:1	seaming
516/IV-27	5	516	2 row narrow-fine	2:1	seaming
516/IV-28	5	516	2 row wide - fine	2:1	seaming
516/IV-29	5	516	2 row narrow-medium	2:1	seaming
516/IV-30	5	516	3 row wide - medium	2:1	seaming
516/IV-31	5	516	3 row wide - coarse	2:1	seaming
516/IV-32	5	516	2 row narrow-coarse	2:1	seaming
516/IV-33	5	516	2 row wide - coarse	2:1	seaming
516/IV-34	5	516	3 row narrow-fine	2:1	seaming
516/IV-35	5	516	3 row narrow-medium	2:1	seaming
516/IV-36	5	516	3 row narrow-coarse	2:1	seaming
516/IV-37	5	516	3 row wide - fine	2:1	seaming
516/IV-38	5	516	3 row wide - medium	3:1	shirring-intermittent
516/IV-39	5	516	3 row wide - coarse	3:1	shirring-intermittent
516/IV-51	5	516	3 row wide - coarse	2:1	seaming - tractor foot
516/IV-52	5	516	2 row wide - coarse	2:1	seaming - tractor foot

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CLASS 500 MACHINES

NEEDLE	O O O	Φ Φ O
CAPACITY	O ● O	● ● ●

FEDERAL STITCH	MACHINE CLASS I	II	III	IV	V	VI	TYPE NO.	OPERATION	MATERIAL L	M	H	W	K	PEED & PLATE PATTERN Rows 1	2	3	Width W	N	Length L	S	Pitch F	M	C	FEED MECHANISM PLAIN DIFFERENTIAL Fixed 1/2:1	Intermittent 1:1	2:1	3:1	NO. OF THREADS
504	O						-1	seaming	O			O		O					O		O				O			3
504	O						-2	seaming & stretch	O			O		O					O		O				O			3
504	O	O					-3	seaming		O			O			O			O			O				O			3
503	O	O					-4	serging		O	O		O				O			O			O						2
504	O	O				O	-5	seaming		O			O				O			O						O			3
504	O	O					-6	seaming & stretch		O			O		O					O			O			O				3
504	O	O			O	O	-7	seaming			O	O	O			O			O			O				O		O		3
503	O	O					-8	serging	O			O			O				O			O		O						2
504	O						-9	downturn hemming	O			O		O					O			O		O						3
504	O						-10	upturn hemming		O		O		O					O			O				O				3
514(512)	O	O			O	O	-11	2needle seaming		O			O			O			O			O				O		O		4
514(512)	O	O			O	O	-12	2needle seaming		O			O		O				O			O				O		O		4
							-13	OBSOLETE																						
504	O						-14	Shell Stitch	O					O												O				3
							-15	OBSOLETE																						
504				O		O	-16																							
							-17	3:1 shir		O		O	O			O			O			O						O		3
							-18																							
504				O			-19	seaming	O				O	O			O					O						O		3
514				O			-20	2needle seaming	O				O	O			O					O						O		4
504				O			-21	3:1 shir		O		O	O			O			O			O							O	3
514(512)				O			-22	2needle 3:1 shir		O		O	O			O			O			O							O	4
514(512)				O		O	-23	2needle 3:1 shir		O		O	O			O			O			O							O	4
							-24																							
504(505)	O			O	O		-25	hemming	O				O		O			O				O				O		O		2-3
516				O			-26	seaming		O		O	O		O		O			O			O						O		4-5
515,516				O			-27	seaming	O			O	O		O			O			O							O		4-5
515,516				O			-28	seaming	O			O	O		O		O			O								O		4-5
515,516				O			-29	seaming	O			O	O		O			O			O							O		4-5
515,516				O			-30	seaming		O		O	O			O	O				O							O		4-5
515,516				O			-31	seaming			O		O			O				O								O		4-5
515,516				O			-32	seaming		O		O	O		O			O			O							O		4-5
515,516				O			-33	seaming		O			O		O		O				O							O		4-5
515,516				O			-34	seaming	O			O	O			O			O			O							O		4-5
515,516				O			-35	seaming		O		O	O			O		O				O							O		4-5
515,516				O			-36	seaming			O		O			O		O			O							O		4-5
515,516				O			-37	seaming	O			O	O			O	O			O								O		4-5
515,516				O			-38	3:1 shir		O		O	O			O	O				O								O	4-5
515,516				O			-39	3:1 shir			O	O	O				O	O				O							O	4-5
							-40																							
514(512)	O	O		O	O	O	-41	2 needle seaming		O			O			O	O		O			O				O		O		4
514 (512)	O	O		O	O	O	-42	2 needle seaming		O			O		O		O			O			O				O		O		4
504	O	O		O	O	O	-43	seaming		O			O			O			O			O				O		O		3
503				O			-44	serging		O		O			O		O.			O								O		2
504	O	O		O	O	O	-45	seaming & stretch		O			O		O		O			O						O		O		3
							-46																							
504	O	O		O	O	O	-47	seaming			O		O			O			O			O				O		O		3
503				O			-48	serging			O	O				O			O			O						O		2
							-49																							
							-50																							
516				O			-51	seaming-tractorfoot			O	O	O			O		O				O						O		4-5
516				O			-52	seaming-tractorfoot			O	O	O		O			O				O						O		4-5
504				O			S-10	seaming			O		O			O			O			O						O		3
514				O			S-11	2needle seaming			O		O			O			O			O							O		4
							S-12																							
514				O			S-13	2needle seaming	O				O		O		O					O						O		4
514				O			S-14	2needle seaming		O			O			O			O			O							O		4
514				O			S-15	2needle seaming	O				O			O			O			O						O			4
504				O			S-16	seaming			O		O			O			O				O						O		3
504				O			S-17	seaming		O			O			O			O			O							O		3
514				O			S-18	2needle shir		O			O			O			O			O							O		4
514				O			S-19	2needle seaming		O			O			O			O			O						O			4
514				O			S-20	2needle seaming		O			O		O			O				O						O			4
514(512)				O			S-41	2needle seaming		O			O			O			O			O							O		4
504				O			S-45	seaming		O			O		O			O				O							O		3
504				O			S-47	seaming			O	O	O			O			O			O							O		3

NEEDLE
Curved O
Straight Φ

CAPACITY
Low Lift - 1/8 x 5/32" O
High Lift- 1/4 x 1/4" ●

MATERIAL
L- Light
M- Medium
H- Heavy
W- Woven
K- Knit

FEED AND PLATE PATTERN
W- Wide
N- Narrow
L- Long
S- Short

F-Fine (25 teeth per inch)
M-Medium (16 teeth per inch)
C-Coarse (10 teeth per inch)

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