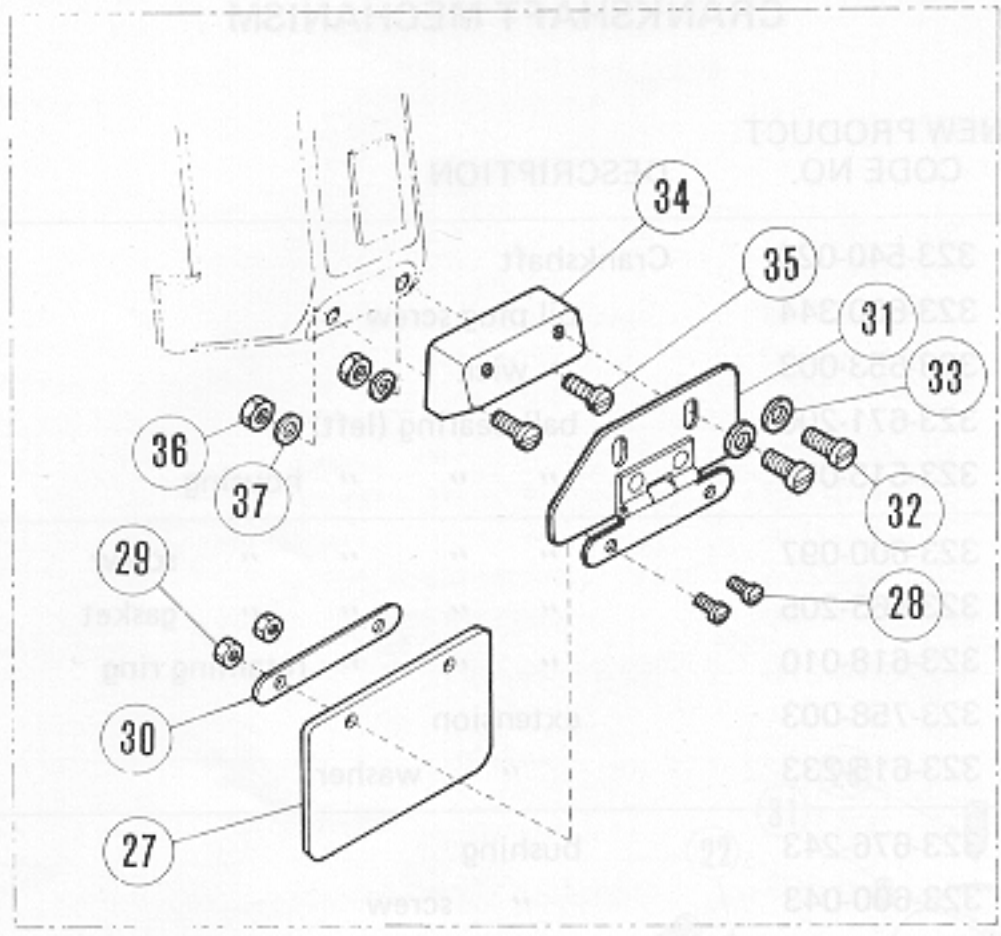


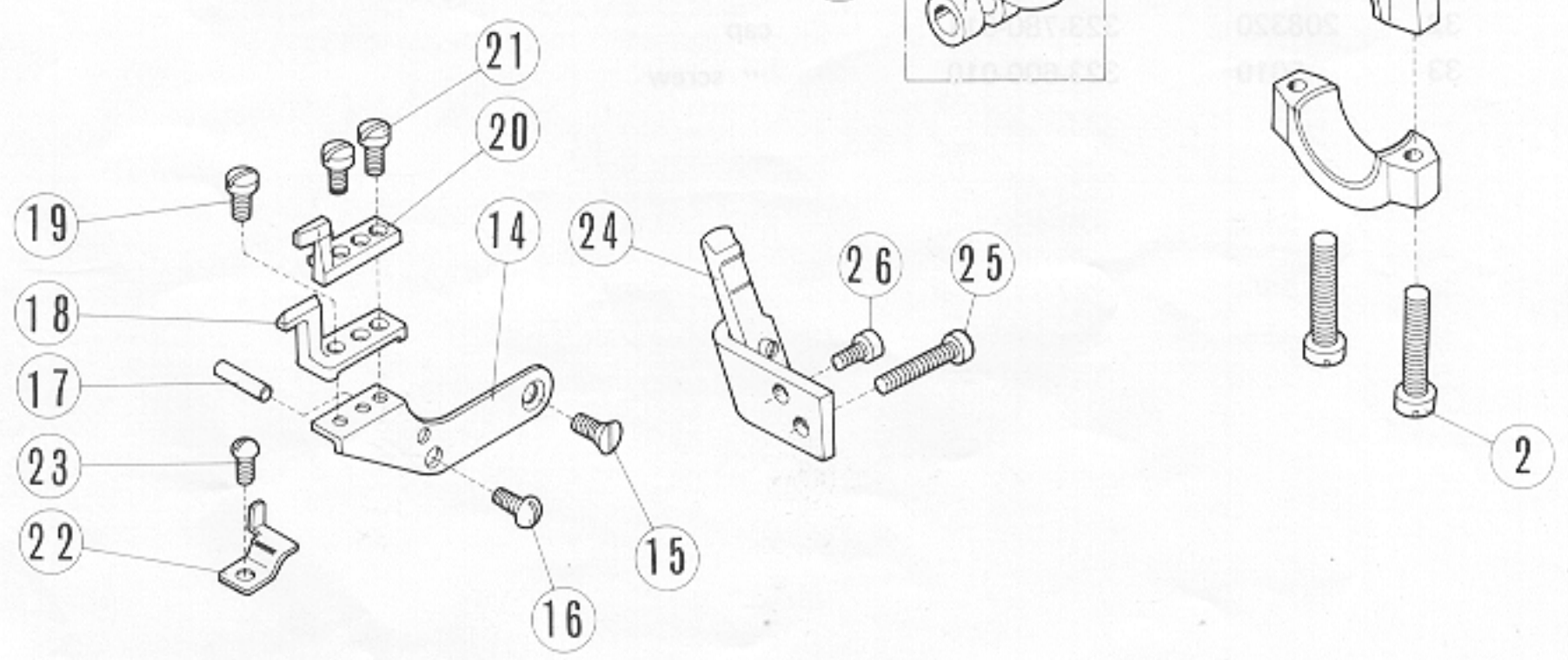
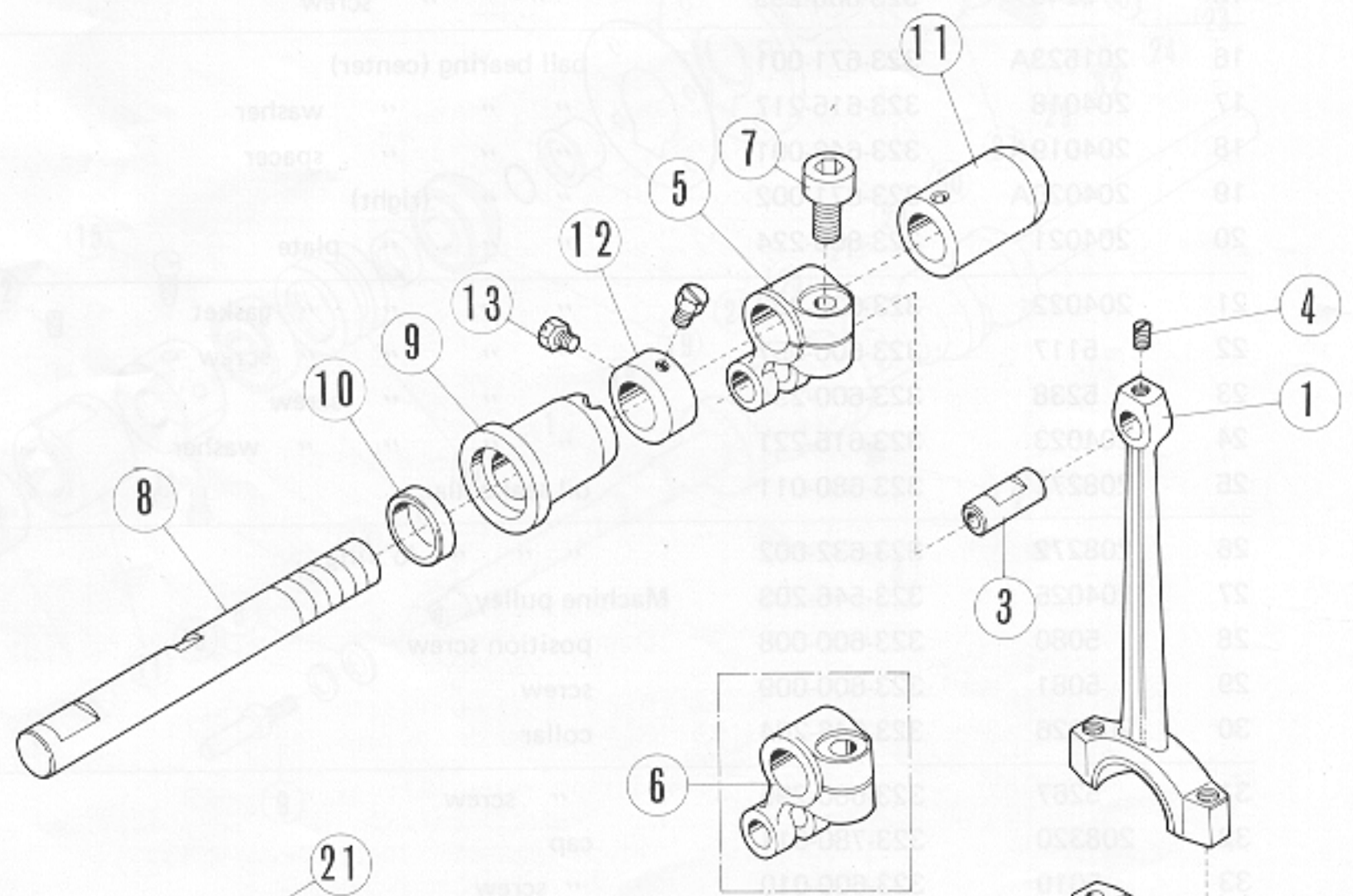
MACHINE BED FRAME

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208600	MFG only	Machine bed frame	1
2	5332	323-600-359	oil hole plug screw (with head)	1
3	2022	323-600-043	" " " " screw	3
4	208602	323-500-019	Machine arm (right)	1
5	204251	323-653-207	gasket	1
6	5078	323-600-001	screw	4
7	201002	323-620-001	dowel pin	1
8	208603	323-500-020	Machine arm (left)	1
9	5237	323-600-327	screw (long)	1

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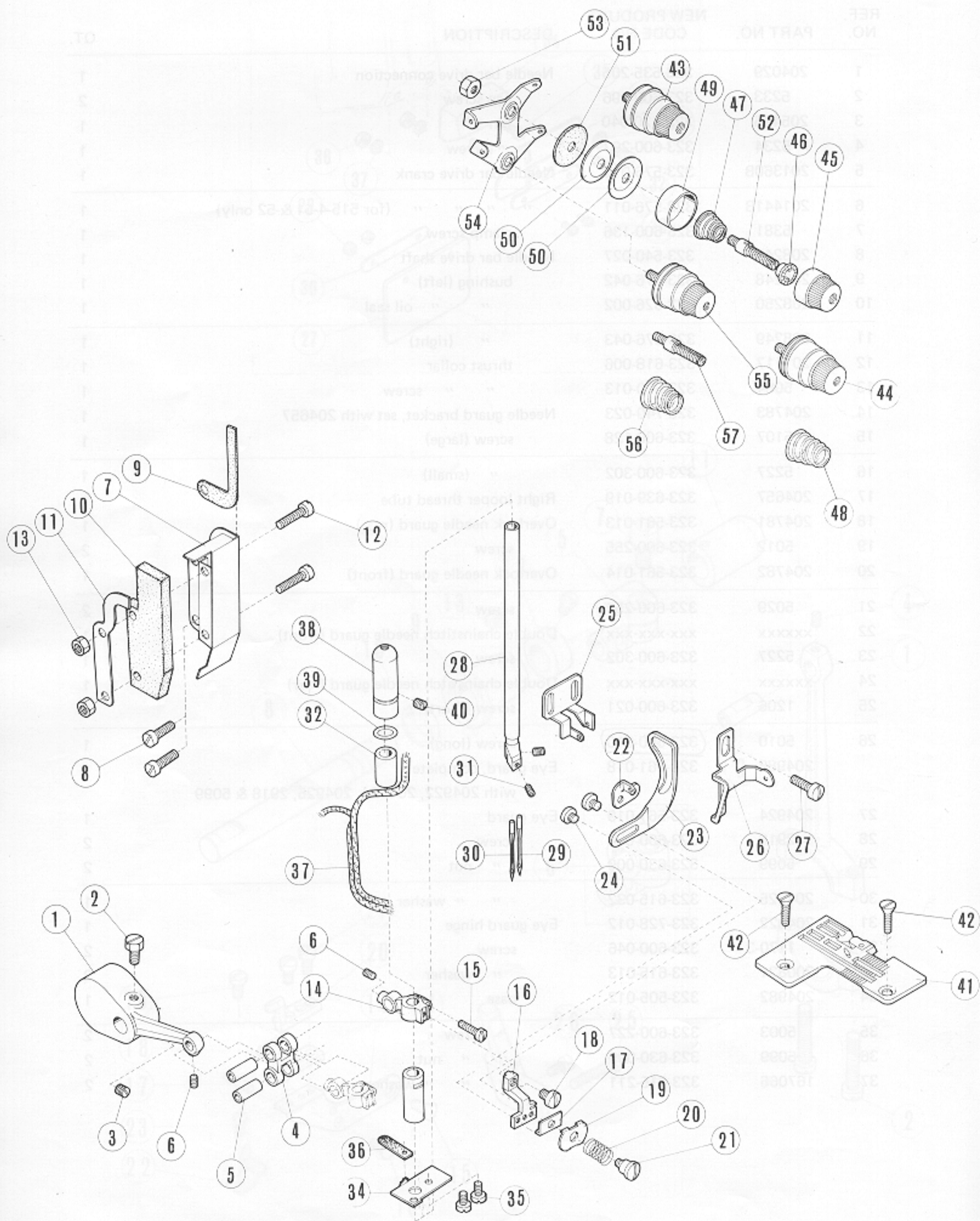
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1	308343	
2	5318	
3	305081	
4	304010	
5	304881	
6	8381	
7	304318	
8	304788	
9	304813	
10	304820	
11	304014	
12	3083	
13	304018	
14	1714	
15	304823	
16	304824	
17	304825	
18	304019	
19	304020	
20	304021	
21	304022	
22	304023	
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29	304030	
30	304031	
31	304032	
32	304033	
33	304034	
34	304035	
35	304036	
36	304037	
37	304038	



(1) NEEDLE DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204029	323-535-205	Needle bar drive connection	1
2	5233	323-600-296	cap screw	2
3	205495	323-620-040	pin	1
4	5234	323-600-297	" screw	1
5	201360B	323-576-010	Needle bar drive crank	1
6	201441B	323-576-011	" " " " (for 515-4-51 & -52 only)	1
7	5381	323-600-136	clamp screw	1
8	208247	323-540-027	Needle bar drive shaft	1
9	208248	323-676-042	bushing (left)	1
10	208250	323-626-002	" " oil seal	1
11	208249	323-676-043	" (right)	1
12	201117	323-618-006	thrust collar	1
13	5084	323-600-013	" " screw	1
14	204783	323-740-023	Needle guard bracket, set with 204657	1
15	5107	323-600-128	screw (large)	1
16	5227	323-600-302	" (small)	1
17	204657	323-639-019	Right looper thread tube	1
18	204781	323-561-013	Overlock needle guard (rear)	1
19	5012	323-600-255	screw	2
20	204782	323-561-014	Overlock needle guard (front)	1
21	5029	323-600-256	screw	2
22	xxxxxx	xxx-xxx-xxx	Double chainstitch needle guard (front)	1
23	5227	323-600-302	screw	1
24	xxxxxx	xxx-xxx-xxx	Double chainstitch needle guard (rear)	1
25	1206	323-600-021	screw (short)	1
26	5010	323-600-010	screw (long)	1
	204988	323-561-018	Eye guard, complete with 204922, 204924, 204925, 2918 & 5099	1
27	204924	323-561-019	Eye guard	1
28	2918	323-600-073	screw	2
29	5099	323-630-009	" nut	2
30	204925	323-615-032	" " washer	1
31	204922	323-728-012	Eye guard hinge	1
32	1170-3	323-600-046	screw	2
33	200821	323-615-013	" washer	2
34	204982	323-505-012	base	1
35	5003	323-600-227	" screw	2
36	5099	323-630-009	" " nut	2
37	167066	323-615-211	" " " washer	2

(1) NEEDLE DRIVE MECHANISM



(2) NEEDLE DRIVE MECHANISM

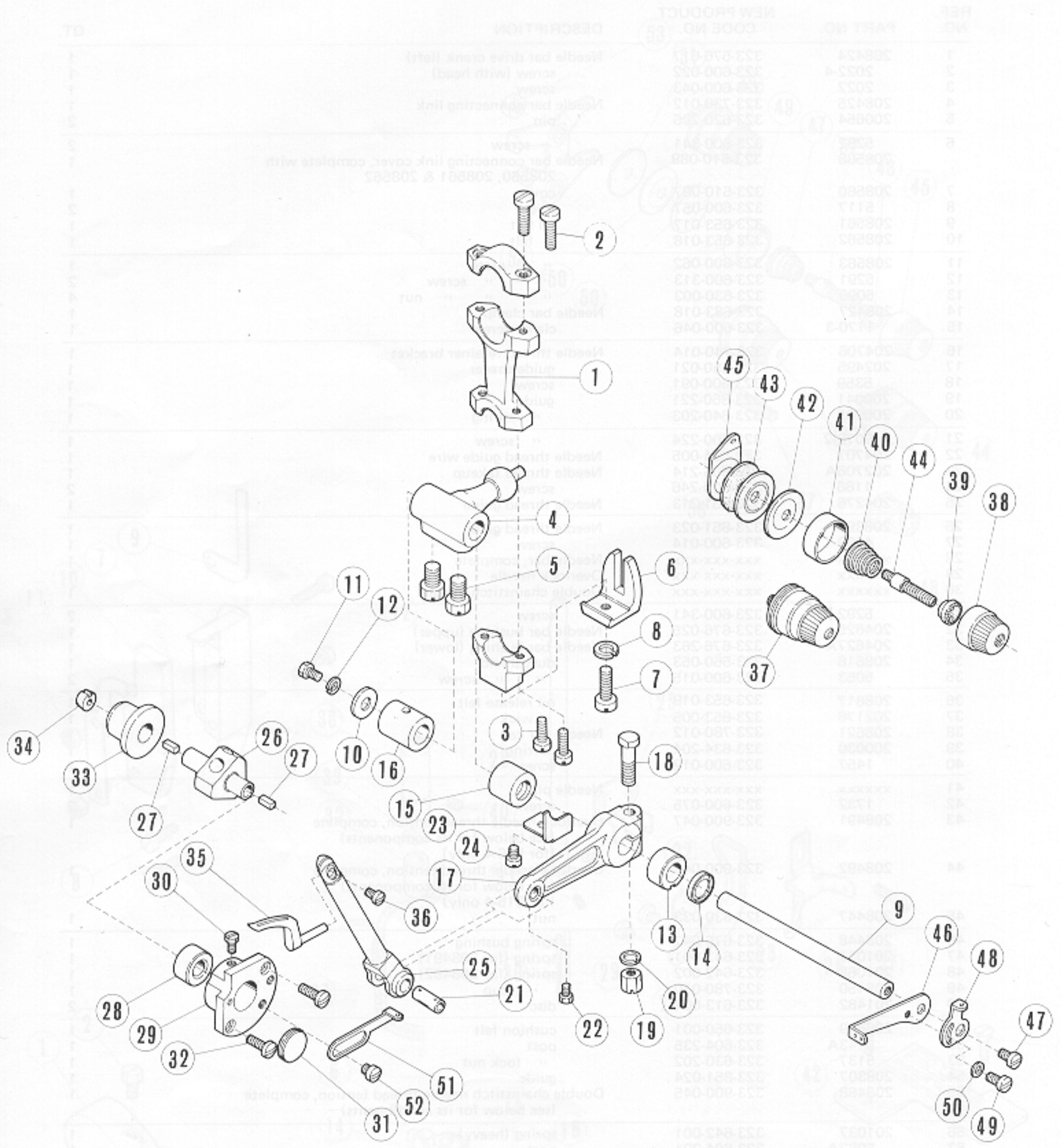
REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208424	323-576-017	Needle bar drive crank (left)	1
2	2022-4	323-600-022	screw (with head)	1
3	2022	323-600-043	screw	1
4	208425	323-730-012	Needle bar connecting link	1
5	200654	323-620-206	pin	2
6	5292	323-600-341	" screw	2
	208568	323-510-089	Needle bar connecting link cover, complete with 208560, 208561 & 208562	1
7	208560	323-510-097	cover	1
8	5117	323-600-057	screw	2
9	208561	323-653-017	oil felt	1
10	208562	323-653-018	" felt	1
11	208563	323-800-062	" " plate	1
12	5291	323-600-313	" " " screw	2
13	5099	323-630-003	" " " " nut	4
14	208427	323-683-018	Needle bar clamp	1
15	1170-3	323-600-046	clamp screw	1
16	204706	323-740-014	Needle thread retainer bracket	1
17	202495	323-850-021	guide spacer	1
18	5359	323-600-091	screw	1
19	200041	323-850-221	guide	1
20	200205	323-640-203	" spring	1
21	9070-2	323-600-224	" screw	1
22	204707	323-851-005	Needle thread guide wire	1
23	202706A	323-866-214	Needle thread takeup	1
24	1186	323-600-246	screw	2
25	204276	323-851-213	Needle thread guide	1
26	208399	323-851-023	Needle thread guide	1
27	4009-1	323-600-014	screw	1
28	xxxxxx	xxx-xxx-xxx	Needle bar, complete	1
29	xxxxxx	xxx-xxx-xxx	Overlock needle	1
30	xxxxxx	xxx-xxx-xxx	Double chainstitch needle	1
31	5292	323-600-341	screw	2
32	204625A	323-676-025	Needle bar bushing (upper)	1
33	204627A	323-676-263	Needle bar bushing (lower)	1
34	208616	323-560-053	dust shield	1
35	5053	323-600-015	" " screw	2
36	208617	323-653-019	oil release felt	1
37	202176	323-653-005	" wick	1
38	208621	323-780-012	Needle bar cap	1
39	200030	323-634-204	'o' ring	1
40	1457	323-600-012	screw	1
41	xxxxxx	xxx-xxx-xxx	Needle plate	1
42	1732	323-600-075	screw	2
43	208491	323-900-047	Overlock needle thread tension, complete (see below for its components) (for 516-4 only)	1
44	208492	323-900-049	Overlock needle thread tension, complete (see below for its components) (for 515-4 only)	1
45	208447	323-630-033	nut	1
46	208448	323-676-047	spring bushing	1
47	201037	323-642-001	spring (for 208491)	1
48	201068	323-642-002	spring (for 208492)	1
49	208450	323-780-010	" cup	1
50	201482	323-613-001	disc	2
51	208449	323-650-001	cushion felt	1
52	5143A	323-604-235	post	1
53	5137	323-630-202	" lock nut	1
54	208307	323-851-024	guide	1
55	208488	323-900-045	Double chainstitch needle thread tension, complete (see below for its components)	1
56	201037	323-642-001	spring (heavy)	1
57	5082A	323-604-201	post	1

208491 consists of 208447, 208448, 201037, 208450, 201482 x 2, 208449 & 5134A

208492 consists of 208447, 208448, 201068, 208450, 201482 x 2, 208449 & 5134A

208488 consists of 208447, 208448, 201037, 208450, 201482 x 2, 208449 & 5082A

(2) NEEDLE DRIVE MECHANISM



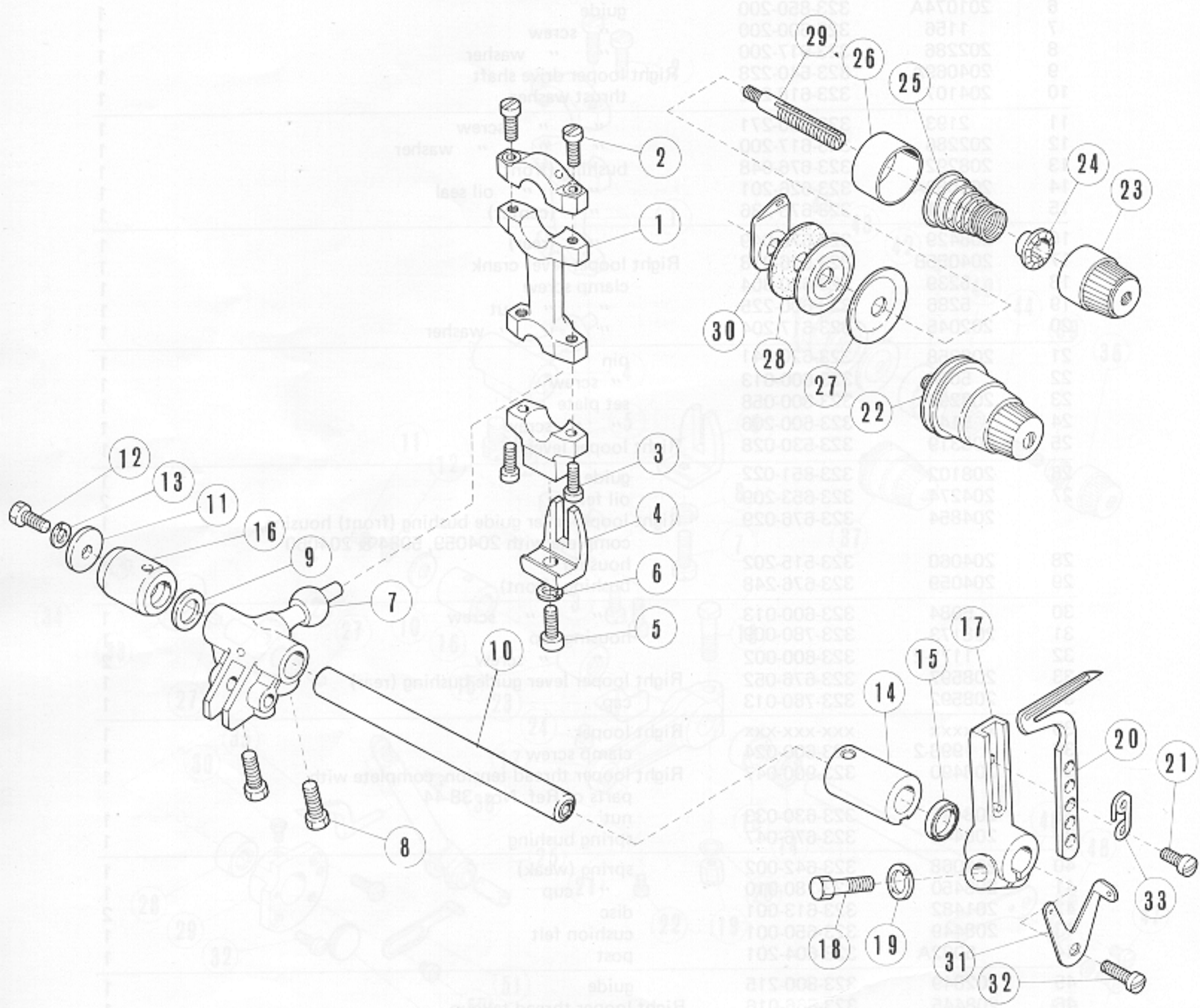
RIGHT LOOPER DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208346	323-525-013	Right looper drive connection	1
2	2213-1	323-600-056	cap screw (large)	2
3	1170-1	323-600-020	" " (small)	2
4	204048A	323-576-213	crank	1
5	2022-4	323-600-022	" screw	2
6	201074A	323-850-200	guide	1
7	1156	323-600-200	" screw	1
8	202286	323-617-200	" " washer	1
9	204069A	323-540-228	Right looper drive shaft	1
10	204107	323-618-212	thrust washer	1
11	2193	323-600-271	" " screw	1
12	202286	323-617-200	" " " washer	1
13	208292	323-676-048	bushing (front)	1
14	204052A	323-626-201	" " oil seal	1
15	204081	323-676-236	" (center)	1
16	208429	323-676-049	" (rear)	1
17	204055B	323-576-018	Right looper lever crank	1
18	5239	323-630-304	clamp screw	1
19	5286	323-600-225	" " nut	1
20	202045	323-617-204	" " " washer	1
21	208258	323-620-041	pin	1
22	5084	323-600-013	" screw	1
23	208296	323-800-058	set plate	1
24	5147	323-600-206	" " screw	1
25	208319	323-530-028	Right looper lever	1
26	208102	323-851-022	guide	1
27	204274	323-653-209	oil felt	2
28	204854	323-676-029	Right looper lever guide bushing (front) housing, complete with 204059, 5084 & 204060	1
29	204060	323-515-202	housing	1
30	204059	323-676-248	bushing (front)	1
31	5084	323-600-013	" " screw	1
32	208173	323-780-009	housing cap	1
33	1175-2	323-600-002	" " screw	2
34	208597	323-676-052	Right looper lever guide bushing (rear)	1
35	208592	323-780-013	cap	1
36	xxxxxx	xxx-xxx-xxx	Right looper	1
37	1998-2	323-600-024	clamp screw	1
38	208490	323-900-047	Right looper thread tension, complete with parts of Ref. Nos. 38-44	1
39	208447	323-630-033	nut	1
40	208448	323-676-047	spring bushing	1
41	201068	323-642-002	spring (weak)	1
42	208450	323-780-010	" cup	1
43	201482	323-613-001	disc	2
44	208449	323-650-001	cushion felt	1
45	5082A	323-604-201	post	1
46	202849	323-800-215	guide	1
47	208445	323-866-016	Right looper thread takeup	1
48	2902	323-600-259	screw	1
49	204902	323-866-013	auxiliary	1
50	2921	323-600-026	" screw	1
51	202875	323-615-216	" " washer	1
52	204905	323-851-018	Right looper thread guide wire	1
53	2905	323-600-074	screw	1

RIGHT LOOPER DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION
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1	208346	323-828-013	Right looper drive connection
2	2213-1	323-800-086	cap screw (large)
3	1170-1	323-800-020	" (small)
4	204084A	323-828-213	crank
5	2023-4	323-800-023	screw
6	201074A	323-828-200	guide
7	1188	323-828-200	screw
8	202288	323-828-200	washer
9	204082	323-828-200	Right looper drive shaft
10	204100	323-828-200	Right looper drive shaft
11	2182	323-828-200	Right looper drive shaft
12	202288	323-828-200	washer
13	204082	323-828-200	Right looper drive shaft
14	204082	323-828-200	Right looper drive shaft
15	204082	323-828-200	Right looper drive shaft
16	204082	323-828-200	Right looper drive shaft
17	204082	323-828-200	Right looper drive shaft
18	204082	323-828-200	Right looper drive shaft
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24	204082	323-828-200	Right looper drive shaft
25	204082	323-828-200	Right looper drive shaft
26	204082	323-828-200	Right looper drive shaft
27	204082	323-828-200	Right looper drive shaft
28	204082	323-828-200	Right looper drive shaft
29	204082	323-828-200	Right looper drive shaft
30	204082	323-828-200	Right looper drive shaft
31	204082	323-828-200	Right looper drive shaft
32	204082	323-828-200	Right looper drive shaft
33	204082	323-828-200	Right looper drive shaft

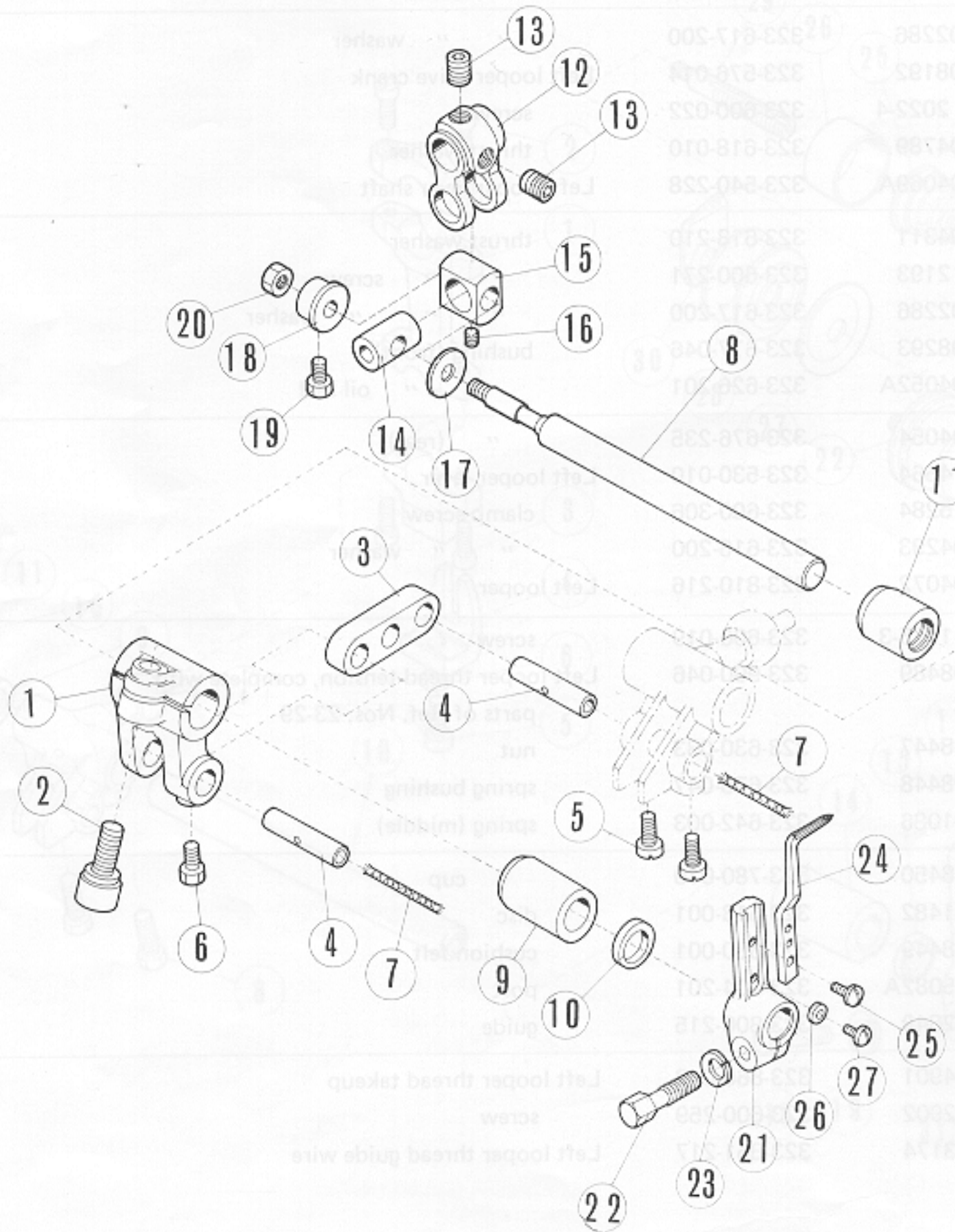


LEFT LOOPER DRIVE MECHANISM MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208346	323-525-013	Left looper drive connection	1
2	2213-1	323-600-056	cap screw (large)	2
3	1170-1	323-600-020	" " (small)	2
4	201074A	323-850-200	guide	1
5	1156	323-600-200	" screw	1
6	202286	323-617-200	" " washer	1
7	208192	323-576-014	Left looper drive crank	1
8	2022-4	323-600-022	screw	2
9	204789	323-618-010	thrust washer	1
10	204069A	323-540-228	Left looper lever shaft	1
11	204311	323-618-210	thrust washer	1
12	2193	323-600-271	" " screw	1
13	202286	323-617-200	" " " washer	1
14	208293	323-677-046	bushing (front)	1
15	204052A	323-626-201	" " oil seal	1
16	204054	323-676-235	" (rear)	1
17	204664	323-530-010	Left looper lever	1
18	5284	323-600-306	clamp screw	1
19	204293	323-616-200	" " washer	1
20	204072	323-810-216	Left looper	1
21	1175-3	323-600-019	screw	1
22	208489	323-900-046	Left looper thread tension, complete with parts of Ref. Nos. 23-29	1
23	208447	323-630-033	nut	1
24	208448	323-676-047	spring bushing	1
25	201086	323-642-003	spring (middle)	1
26	208450	323-780-010	" cup	1
27	201482	323-613-001	disc	2
28	208449	323-650-001	cushion felt	1
29	5082A	323-604-201	post	1
30	202849	323-800-215	guide	1
31	204901	323-866-012	Left looper thread takeup	1
32	2902	323-600-259	screw	1
33	193174	323-851-217	Left looper thread guide wire	1

LEFT LOOPER DRIVE MECHANISM

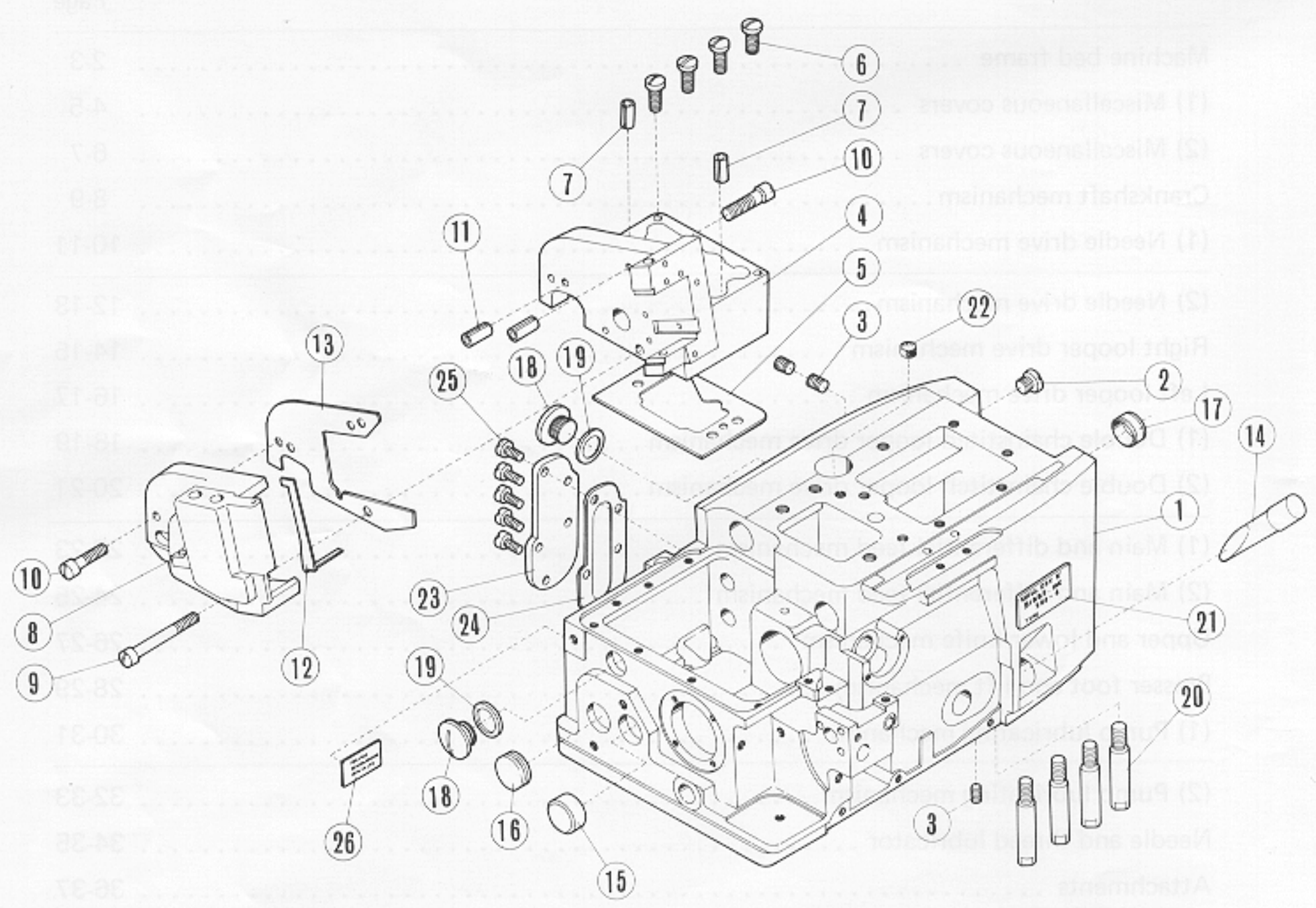
QTY	DESCRIPTION	NEW PRODUCT CODE NO.	PART NO.	REF. NO.
1	Left looper drive connection	323-828-013	208348	1
2	cap screw (large)	323-800-056	2213-1	2
2	" (small)	323-800-020	1170-1	3
1	guide	323-880-200	201074A	4
1	" screw	323-800-200	1188	5



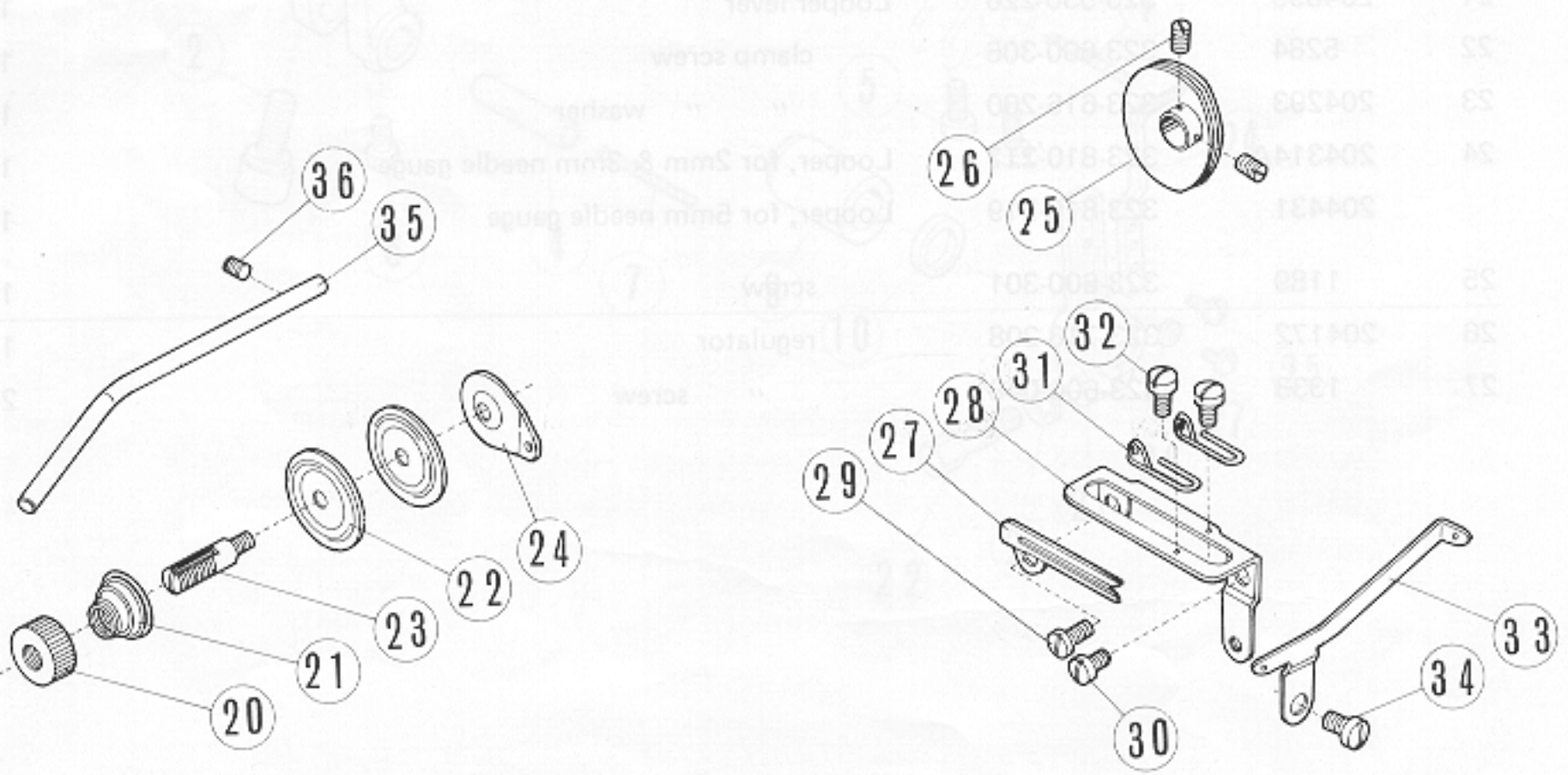
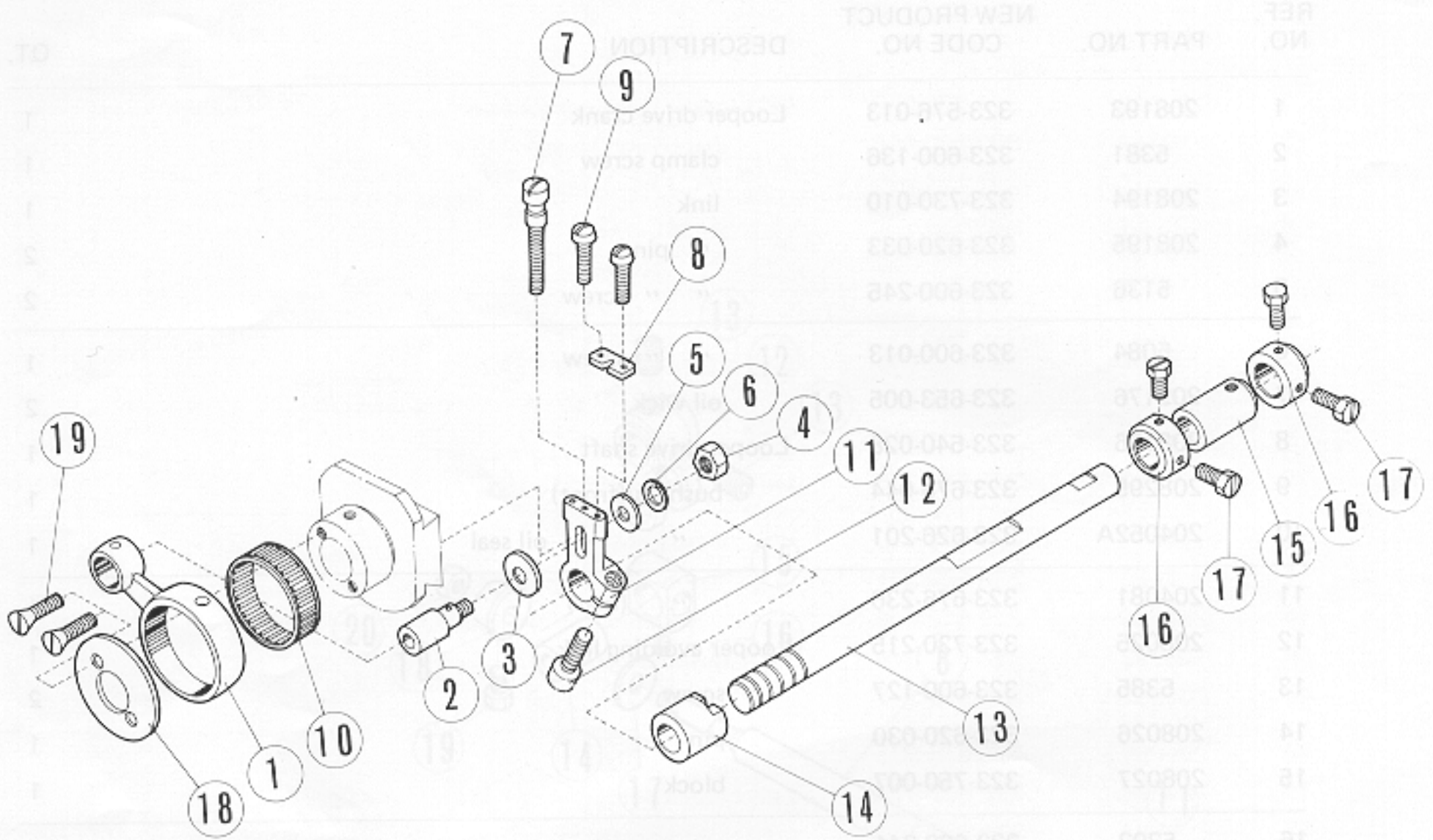
(1) DOUBLE CHAINSTITCH LOOPER DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208193	323-576-013	Looper drive crank	1
2	5381	323-600-136	clamp screw	1
3	208194	323-730-010	link	1
4	208195	323-620-033	" pin	2
5	5136	323-600-245	" " screw	2
6	5084	323-600-013	" " screw	1
7	202176	323-653-005	oil wick	2
8	208196	323-540-028	Looper drive shaft	1
9	208295	323-676-044	bushing (front)	1
10	204052A	323-626-201	" " oil seal	1
11	204081	323-676-236	" (rear)	1
12	208025	323-730-215	Looper avoiding link	1
13	5385	323-600-127	screw	2
14	208026	323-620-030	pin	1
15	208027	323-750-007	block	1
16	5292	323-600-341	" screw	1
17	208028	323-618-214	thrust washer	1
18	208029	323-680-010	collar	1
19	5084	323-600-013	" screw	1
20	5353	323-630-236	nut	1
21	204093	323-530-226	Looper lever	1
22	5284	323-600-306	clamp screw	1
23	204293	323-616-200	" " washer	1
24	204314A	323-810-217	Looper, for 2mm & 3mm needle gauge	1
25	204431	323-810-219	Looper, for 5mm needle gauge	1
25	1189	323-600-301	screw	1
26	204172	323-716-208	regulator	1
27	1333	323-600-048	" screw	2
33	208362	323-851-026	Looper thread guide	1
34	5113	323-620-033	screw	1
35	204099	323-851-030	Looper thread tube	1
36	1157	323-600-012	screw	1

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(1) DOUBLE CHAINSTITCH LOOPER DRIVE MECHANISM

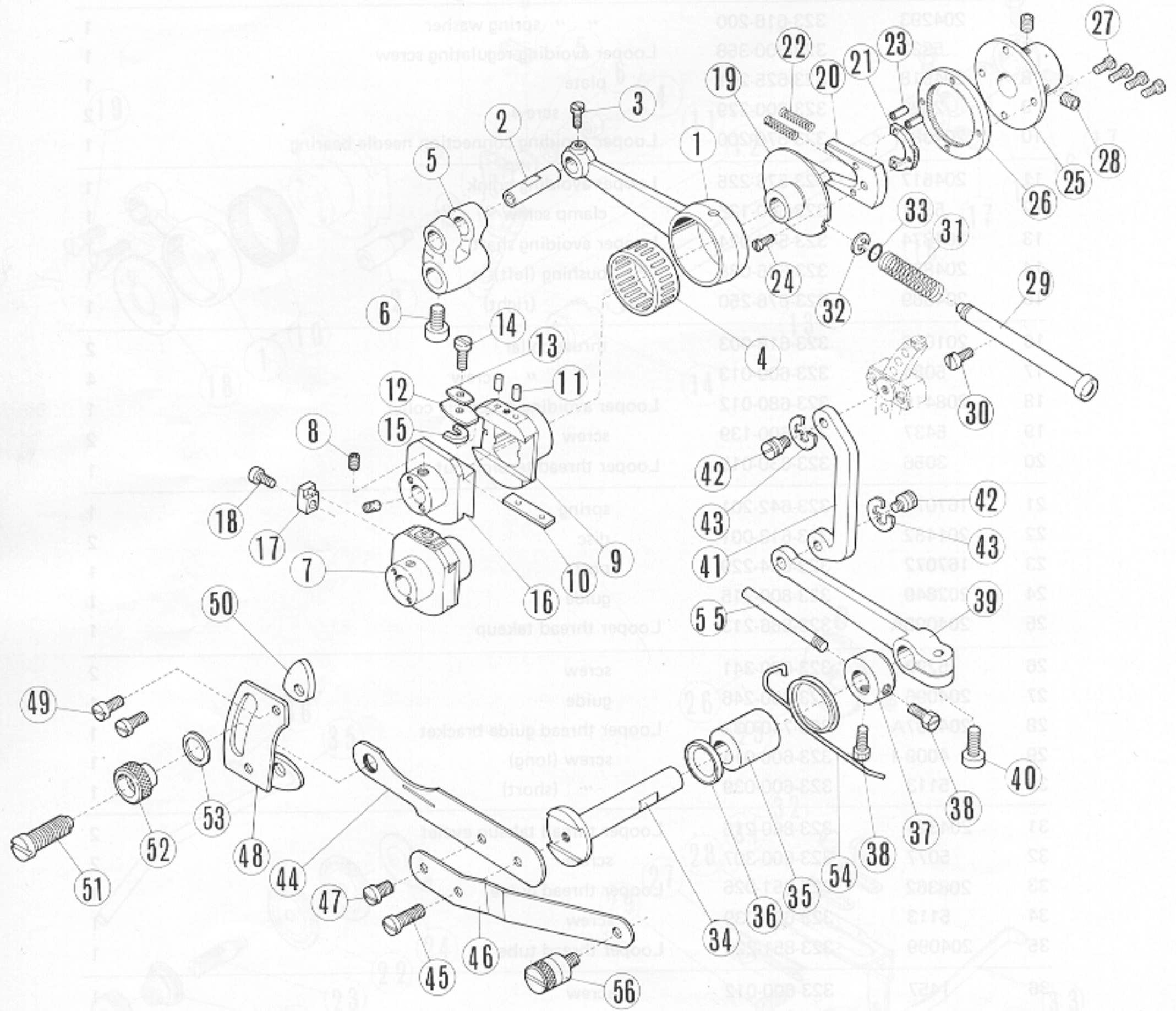


(2) DOUBLE CHAINSTITCH LOOPER DRIVE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204082A	323-525-239	Looper avoiding connection	1
2	208097	323-620-032	pin	1
3	204520	323-615-233	" washer	1
4	5104	325-630-002	" nut	1
5	202433	323-615-027	" " washer	1
6	204293	323-616-200	" " spring washer	1
7	5333	323-600-358	Looper avoiding regulating screw	1
8	204518	323-625-201	plate	1
9	2922	323-600-229	" screw	2
10	204084	323-676-200	Looper avoiding connection needle bearing	1
11	204517	323-576-225	Looper avoiding crank	1
12	5381	323-600-136	clamp screw	1
13	204874	323-540-024	Looper avoiding shaft	1
14	204875	323-676-038	bushing (left)	1
15	204089	323-676-250	" (right)	1
16	201056	323-618-003	thrust collar	2
17	5084	323-600-013	" " screw	4
18	208419	323-680-012	Looper avoiding eccentric collar	1
19	5437	323-600-139	screw	2
20	3056	323-630-015	Looper thread tension nut	1
21	167077	323-642-201	spring	1
22	201482	323-613-001	disc	2
23	167072	323-604-229	post	1
24	202849	323-800-215	guide	1
25	204095A	323-866-213	Looper thread takeup	1
26	5292	323-600-341	screw	2
27	204096	323-850-246	guide	1
28	204097A	323-740-032	Looper thread guide bracket	1
29	4009-1	323-600-014	screw (long)	1
30	5113	323-600-039	" (short)	1
31	204324	323-860-215	Looper thread takeup eyelet	2
32	5077	323-600-307	screw	2
33	208362	323-851-026	Looper thread guide	1
34	5113	323-600-039	screw	1
35	204099	323-851-220	Looper thread tube	1
36	1457	323-600-012	screw	1
48	204142B	323-800-036	" guide	1
49	5118	323-600-080	" screw	2
50	204143A	323-891-200	lift guide	2
51	5321A	323-600-083	" adjust screw	1
52	204870	323-630-017	" " nut	1
53	202868	323-618-209	" " " washer	1
54	204758	323-640-006	Differential feed regulating spring	1
55	204757	323-600-102	latch screw	1
56	204869	323-600-107	Knee controller chain hook latch screw	1

(2) DOUBLE CHAINSTITCH LOOPER DRIVE MECHANISM

DT.	DESCRIPTION	NEW PRODUCT CODE NO.	PART NO.	REF. NO.
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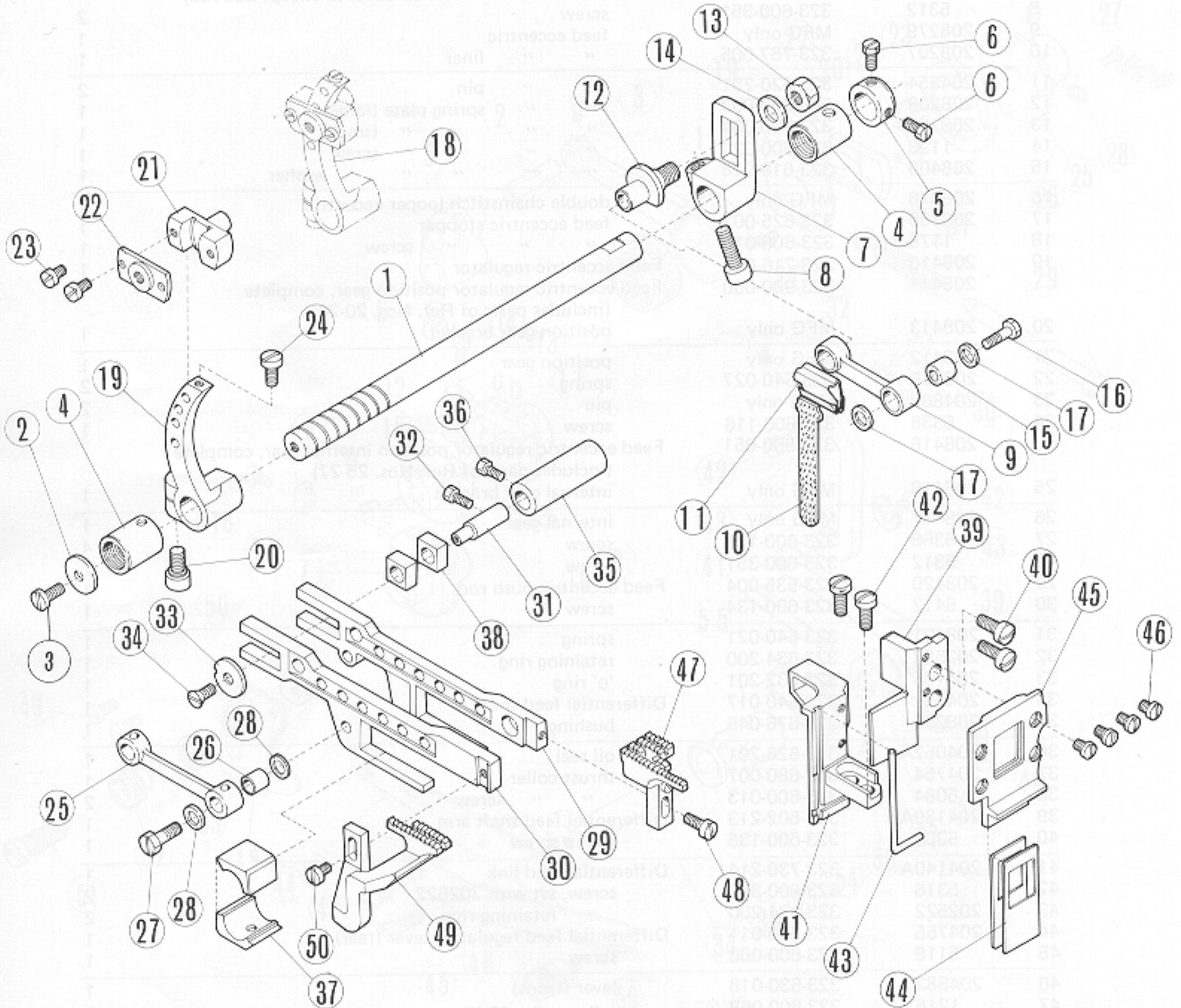


(1) MAIN AND DIFFERENTIAL FEED MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204100	323-525-232	Feed drive connection	1
2	205495	323-620-040	pin	1
3	5084	323-600-013	" screw	1
4	204084	323-672-200	needle bearing	1
5	204085	323-576-220	Feed drive crank	1
6	5381	323-600-136	clamp screw	1
7	208277	323-580-083	Feed & looper eccentric, complete (includes parts of Ref. Nos. 9-18 except 208409)	1
8	5312	323-600-351	screw	2
9	208279	MFG only	feed eccentric	1
10	208207	323-787-005	" " liner	1
11	204354	323-620-251	" " pin	2
12	208208	323-800-063	" " spring plate (large)	1
13	208209	323-800-064	" " " " (small)	1
14	1196	323-600-029	" " " " screw	1
15	208409	323-618-018	" " " " " washer	1
16	208278	MFG only	double chainstitch looper eccentric	1
17	208330	323-625-002	feed eccentric stopper	1
18	1175-3	323-600-019	" " " " screw	1
19	208410	323-716-013	Feed eccentric regulator	1
	208411	323-900-050	Feed eccentric regulator position gear, complete (includes parts of Ref. Nos. 20-24)	1
20	208413	MFG only	position gear bracket	1
21	208412	MFG only	position gear	1
22	208415	323-640-027	spring	2
23	204863	MFG only	pin	2
24	5336	323-600-116	screw	1
	208416	323-900-051	Feed eccentric regulator position internal gear, complete (includes parts of Ref. Nos. 25-27)	1
25	208418	MFG only	internal gear bracket	1
26	208417	MFG only	internal gear	1
27	5366	323-600-124	screw	4
28	5312	323-600-351	screw	2
29	208420	323-535-004	Feed eccentric push rod	1
30	5412	323-600-134	screw	1
31	208421	323-640-021	spring	1
32	202522	323-634-200	retaining ring	1
33	204185	323-632-201	'o' ring	1
34	204752	323-540-017	Differential feed shaft	1
35	208294	323-676-045	bushing	1
36	204052A	323-626-201	oil seal	1
37	204754	323-680-007	thrust collar	1
38	5084	323-600-013	" " screw	2
39	204139A	323-502-213	Differential feed shaft arm	1
40	5381	323-600-136	clamp screw	1
41	204140A	323-730-214	Differential feed link	1
42	5316	323-600-347	screw, set with 202522	2
43	202522	323-634-200	" retaining ring	2
44	204755	323-530-011	Differential feed regulating lever (rear)	1
45	5118	323-600-060	screw	1
46	204883	323-530-018	lever (front)	1
47	1216	323-600-068	" " screw	1
48	204142B	323-800-036	" guide	1
49	5118	323-600-060	" " screw	2
50	204143A	323-891-200	" lift guide	2
51	5321A	323-600-083	" adjust screw	1
52	204870	323-630-017	" " nut	1
53	202868	323-618-209	" " " washer	1
54	204756	323-640-006	Differential feed regulating spring	1
55	204757	323-600-102	latch screw	1
56	204869	323-600-107	Knee controller chain hook latch screw	1

(1) MAIN AND DIFFERENTIAL FEED MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION
1	304100	323-828-232	Feed drive connection
2	202486	323-820-040	pin
3	2084	323-800-013	screw
4	204084	323-822-200	needle bearing
5	204088	323-828-220	Feed drive crank
6	2381	323-800-136	clamp screw
7	208211	323-880-083	Feed & looper eccentric complete (includes parts of Ref. Nos. 8-18 except 208403)
8	323-800-28	323-800-28	screw
9	323-820-027	323-820-027	MRG only
10	323-820-027	323-820-027	MRG only
11	323-820-027	323-820-027	MRG only
12	323-820-027	323-820-027	MRG only
13	323-820-027	323-820-027	MRG only
14	323-820-027	323-820-027	MRG only
15	323-820-027	323-820-027	MRG only
16	323-820-027	323-820-027	MRG only
17	323-820-027	323-820-027	MRG only
18	323-820-027	323-820-027	MRG only
19	323-820-027	323-820-027	MRG only
20	323-820-027	323-820-027	MRG only
21	323-820-027	323-820-027	MRG only
22	323-820-027	323-820-027	MRG only
23	323-820-027	323-820-027	MRG only
24	323-820-027	323-820-027	MRG only
25	323-820-027	323-820-027	MRG only
26	323-820-027	323-820-027	MRG only
27	323-820-027	323-820-027	MRG only
28	323-820-027	323-820-027	MRG only
29	323-820-027	323-820-027	MRG only
30	323-820-027	323-820-027	MRG only
31	323-820-027	323-820-027	MRG only
32	323-820-027	323-820-027	MRG only
33	323-820-027	323-820-027	MRG only
34	323-820-027	323-820-027	MRG only
35	323-820-027	323-820-027	MRG only
36	323-820-027	323-820-027	MRG only
37	323-820-027	323-820-027	MRG only
38	323-820-027	323-820-027	MRG only
39	323-820-027	323-820-027	MRG only
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41	323-820-027	323-820-027	MRG only
42	323-820-027	323-820-027	MRG only
43	323-820-027	323-820-027	MRG only
44	323-820-027	323-820-027	MRG only
45	323-820-027	323-820-027	MRG only
46	323-820-027	323-820-027	MRG only
47	323-820-027	323-820-027	MRG only
48	323-820-027	323-820-027	MRG only
49	323-820-027	323-820-027	MRG only
50	323-820-027	323-820-027	MRG only

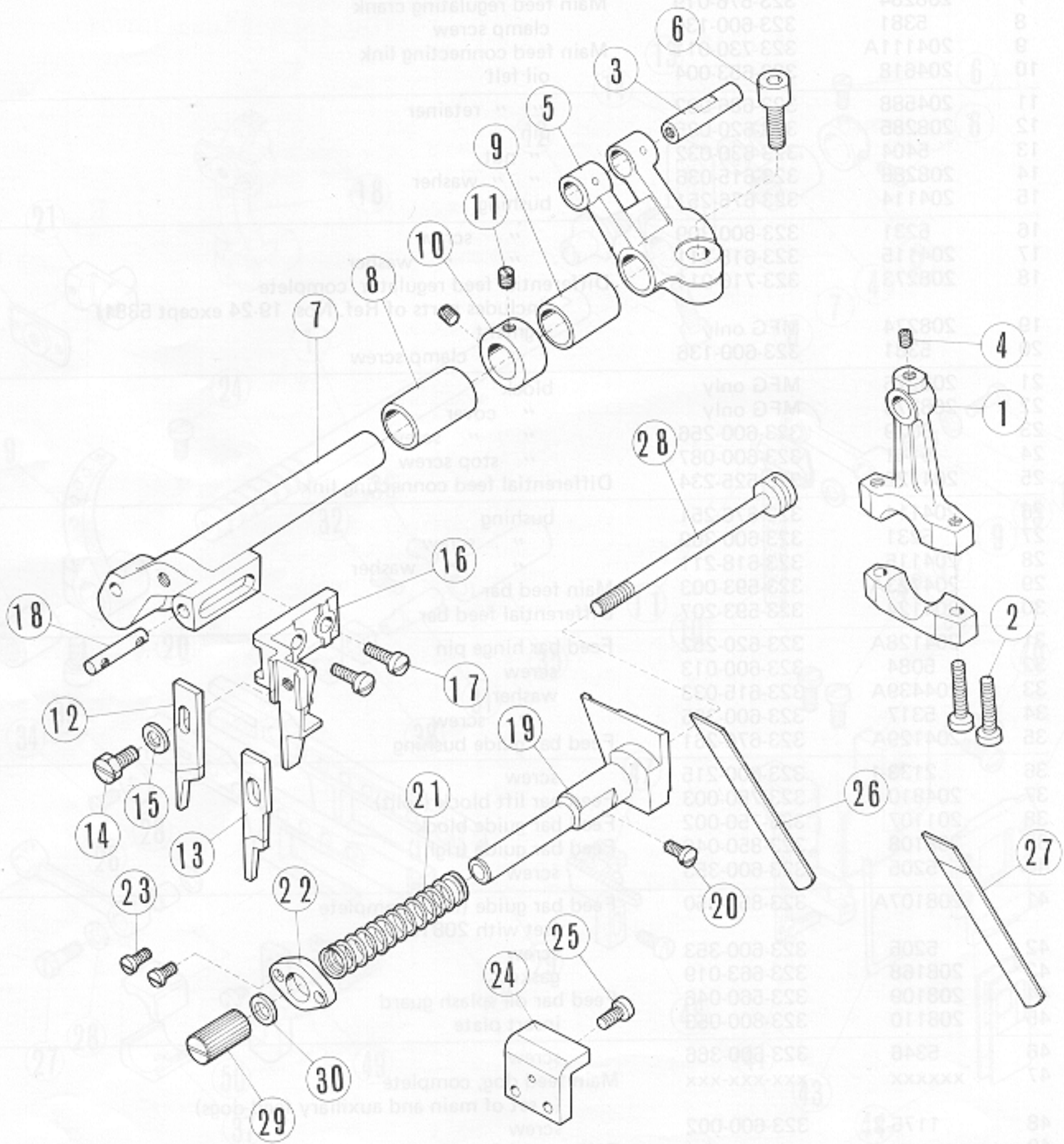


(2) MAIN AND DIFFERENTIAL FEED MECHANISM

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

(2) MAIN AND DIFFERENTIAL FEED MECHANISM

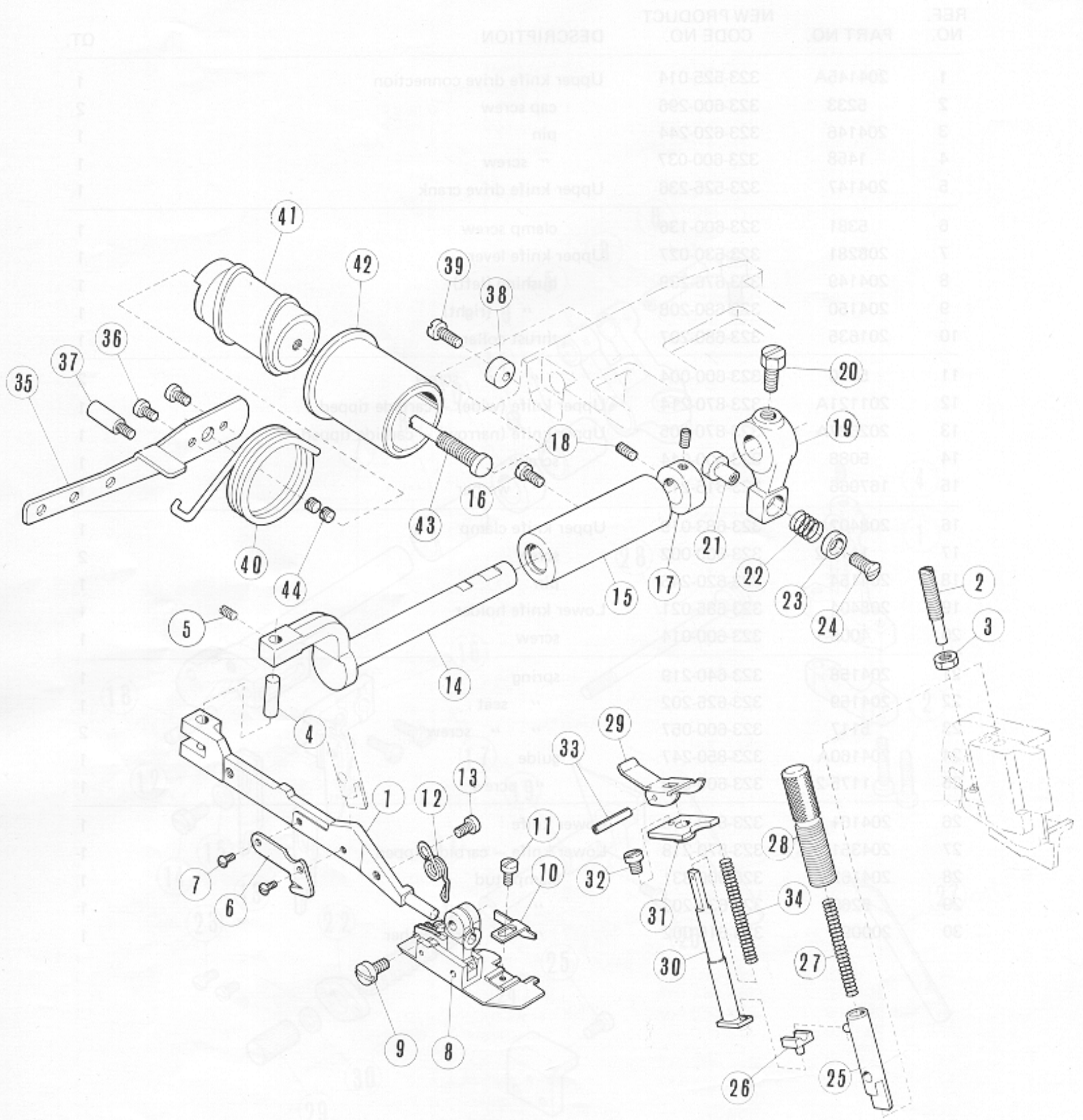
REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION
1	204751	323-640-018	Feed bar shaft
2	204107	323-618-212	thrust washer
3	40081	323-600-014	screw
4	204084	323-616-238	bushing
5	201086	323-618-003	thrust collar
6	6084	323-600-013	screw
7	208284	323-676-018	Main feed regulating crank
8	6381	323-600-010	clamp screw
9	204111A	323-730-004	Main feed connecting link
10	204818	323-600-004	oil felt
11	204888	323-600-004	retainer
12	208286	323-600-004	retainer
13	6404	323-600-004	retainer
14	208288	323-600-004	retainer
15	204114	323-600-004	retainer
16	6391	323-600-004	retainer
17	204115	323-600-004	retainer
18	208289	323-600-004	retainer
19	208290	323-600-004	retainer
20	208291	323-600-004	retainer
21	208292	323-600-004	retainer
22	208293	323-600-004	retainer
23	208294	323-600-004	retainer
24	208295	323-600-004	retainer
25	208296	323-600-004	retainer
26	208297	323-600-004	retainer
27	208298	323-600-004	retainer
28	208299	323-600-004	retainer
29	208300	323-600-004	retainer
30	208301	323-600-004	retainer



UPPER AND LOWER KNIFE MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204145A	323-525-014	Upper knife drive connection	1
2	5233	323-600-296	cap screw	2
3	204146	323-620-244	pin	1
4	1458	323-600-037	" screw	1
5	204147	323-525-236	Upper knife drive crank	1
6	5381	323-600-136	clamp screw	1
7	208281	323-530-027	Upper knife lever	1
8	204149	323-676-239	bushing (left)	1
9	204150	323-680-208	" (right)	1
10	201635	323-680-207	thrust collar	1
11	5060	323-600-004	" " screw	2
12	201121A	323-870-214	Upper knife (wide) - carbide tipped	1
13	202527A	323-870-005	Upper knife (narrow) - carbide tipped	1
14	5088	323-600-044	screw	1
15	167066	323-615-211	" washer	1
16	208402	323-683-019	Upper knife clamp	1
17	1175-2	323-600-002	screw	2
18	204154	323-620-245	pin	1
19	208404	323-685-021	Lower knife holder	1
20	4009-1	323-600-014	screw	1
21	204158	323-640-219	spring	1
22	204159	323-625-202	" seat	1
23	5117	323-600-057	" " screw	2
24	204160A	323-850-247	guide	1
25	1175-2	323-600-002	" screw	1
26	204161	323-870-213	Lower knife	1
27	204351	323-870-218	Lower knife - carbide tipped	1
28	204162	323-600-331	clamp stud	1
29	5260	323-630-203	" " nut	1
30	200098	323-615-002	" " " washer	1
41	204159	323-625-202	" seat	1
42	204160	323-850-247	guide	1
43	208404	323-685-021	Lower knife holder	1
44	20132	323-600-318	" " " stop screw	2

UPPER AND LOWER KNIFE MECHANISM



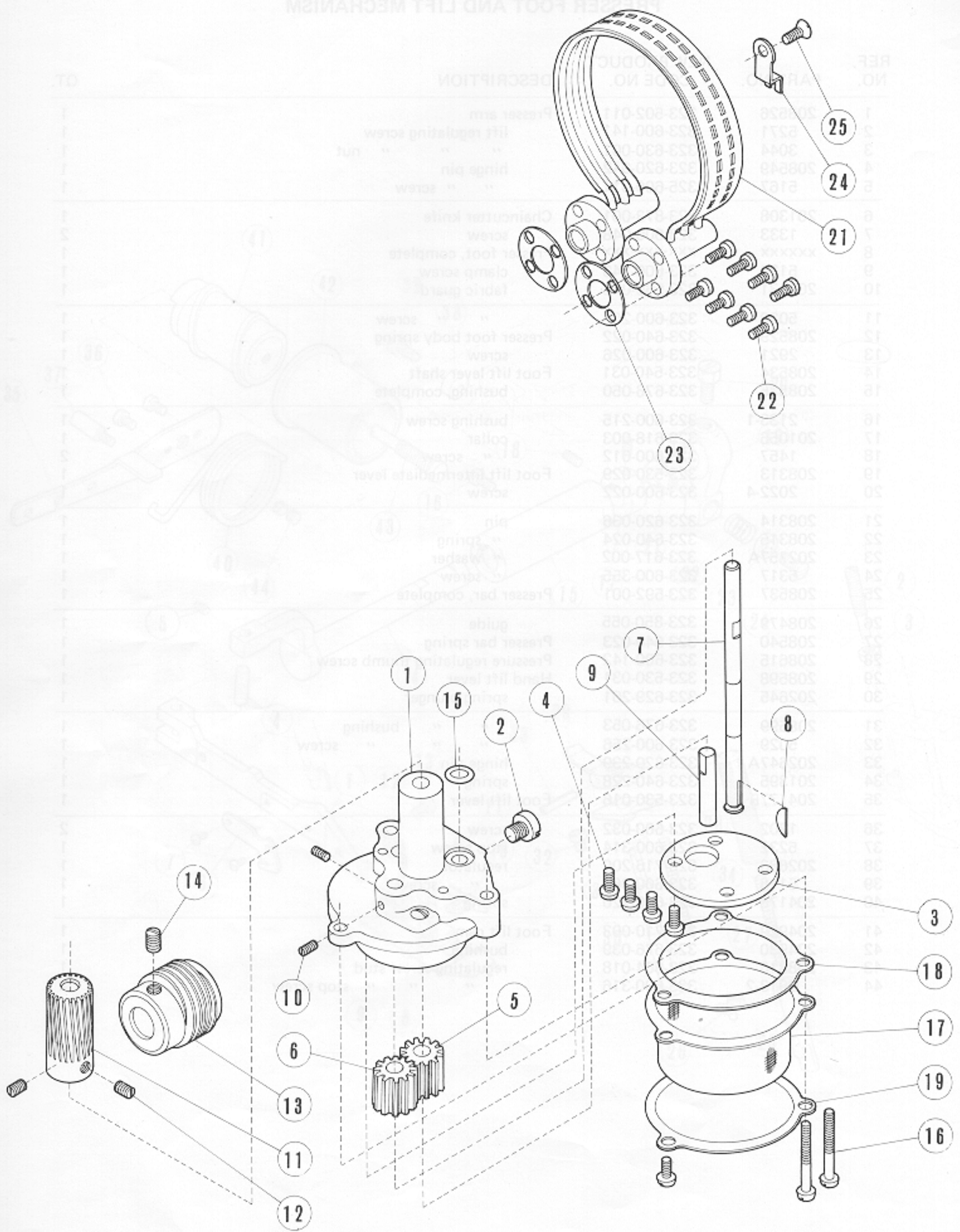
PRESSER FOOT AND LIFT MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208526	323-502-011	Presser arm	1
2	5271	323-600-141	lift regulating screw	1
3	3044	323-630-001	" " " nut	1
4	208549	323-620-042	hinge pin	1
5	5167	325-600-011	" " screw	1
6	201308	323-873-001	Chaincutter knife	1
7	1333	323-600-048	screw	2
8	xxxxxx	xxx-xxx-xxx	Presser foot, complete	1
9	5136	323-600-245	clamp screw	1
10	208531	323-560-045	fabric guard	1
11	5030	323-600-202	" " screw	1
12	208529	323-640-022	Presser foot body spring	1
13	2921	323-600-026	screw	1
14	208534	323-540-031	Foot lift lever shaft	1
15	208535	323-676-050	bushing, complete	1
16	2133-1	323-600-215	bushing screw	1
17	201056	323-618-003	collar	1
18	1457	323-600-012	" screw	2
19	208313	323-530-029	Foot lift intermediate lever	1
20	2022-4	323-600-022	screw	1
21	208314	323-620-036	pin	1
22	208315	323-640-024	" spring	1
23	202757A	323-617-002	" washer	1
24	5317	323-600-355	" screw	1
25	208537	323-592-001	Presser bar, complete	1
26	208479	323-850-055	guide	1
27	208540	323-640-023	Presser bar spring	1
28	208615	323-600-142	Pressure regulating thumb screw	1
29	208598	323-530-031	Hand lift lever	1
30	202645	323-629-201	spring plunger	1
31	208599	323-676-053	" " bushing	1
32	5029	323-600-256	" " " screw	1
33	202647A	323-620-239	hinge pin	1
34	201395	323-640-228	spring	1
35	204177B	323-530-016	Foot lift lever	1
36	1202	323-600-032	screw	2
37	5232	323-600-314	stop screw	1
38	202683	323-716-209	regulator	1
39	5118	323-600-060	" screw	1
40	204178	323-640-220	spring	1
41	204929	323-710-003	Foot lift cam	1
42	204930	323-676-039	bushing	1
43	208316	323-604-018	regulating screw stud	1
44	2913-2	323-600-316	" " " stop screw	2

MACHINE BED FRAME

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208600	MFG only	Machine bed frame	1
2	5332	323-600-359	oil hole plug screw (with head)	1
3	2022	323-600-043	" " " screw	3
4	208602	323-500-019	Machine arm (right)	1
5	204251	323-663-207	gasket	1
6	5078	323-600-001	screw	4
7	201002	323-620-001	dowel pin	1
8	208603	323-500-020	Machine arm (left)	1
9	5237	323-600-327	screw (long)	1
10	5163	323-600-328	" (short)	2
11	201002	323-620-001	dowel pin	2
12	208434	323-560-047	oil shield	1
13	208169A	323-663-021	gasket	1
14	204003	323-882-201	Oil sight gauge	1
15	205088	323-627-014	Looper avoiding shaft (left) cap	1
16	208173	323-780-009	Dead hole plug	1
17	204828	323-627-010	" " plug	1
18	5179	323-600-329	" " " screw (small)	2
19	201006	323-615-001	" " " " " washer	2
20	204006	323-620-242	Machine bed bottom pin	4
21	208406	323-692-033	Type plate blank — 515-4	1
22	204794A	323-655-007	Machine bed oil filter	1
23	208289	323-800-056	Machine bed cover plate (back)	1
24	208290	323-663-020	gasket	1
25	5117	323-600-057	screw	5
26	202526	323-692-201	Manufacture's name plate	1

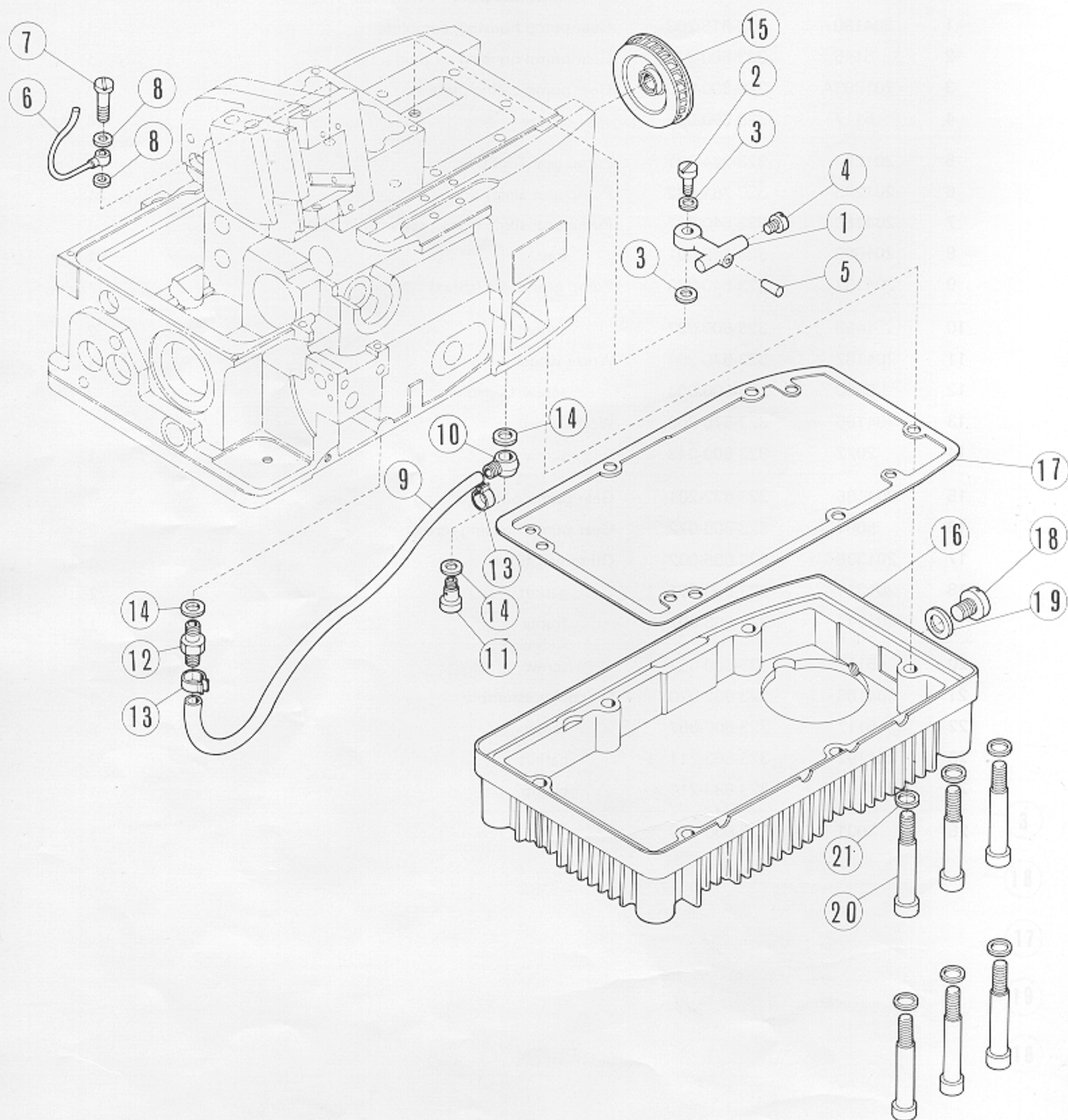
PRESSER FOOT AND LIFT MECHANISM



REF. NO.	DESCRIPTION	QTY.
1	Presser foot body	1
2	Presser foot spring	1
3	Presser bar	1
4	Presser bar spring	1
5	Presser bar guide	1
6	Presser bar spring guide	1
7	Presser bar spring guide	1
8	Presser bar spring guide	1
9	Presser bar spring guide	1
10	Presser bar spring guide	1
11	Presser bar spring guide	1
12	Presser bar spring guide	1
13	Presser bar spring guide	1
14	Presser bar spring guide	1
15	Presser bar spring guide	1
16	Presser bar spring guide	1
17	Presser bar spring guide	1
18	Presser bar spring guide	1
19	Presser bar spring guide	1
20	Presser bar spring guide	1
21	Presser bar spring guide	1
22	Presser bar spring guide	1
23	Presser bar spring guide	1
24	Presser bar spring guide	1
25	Presser bar spring guide	1

(1) PUMP LUBRICATING MECHANISM

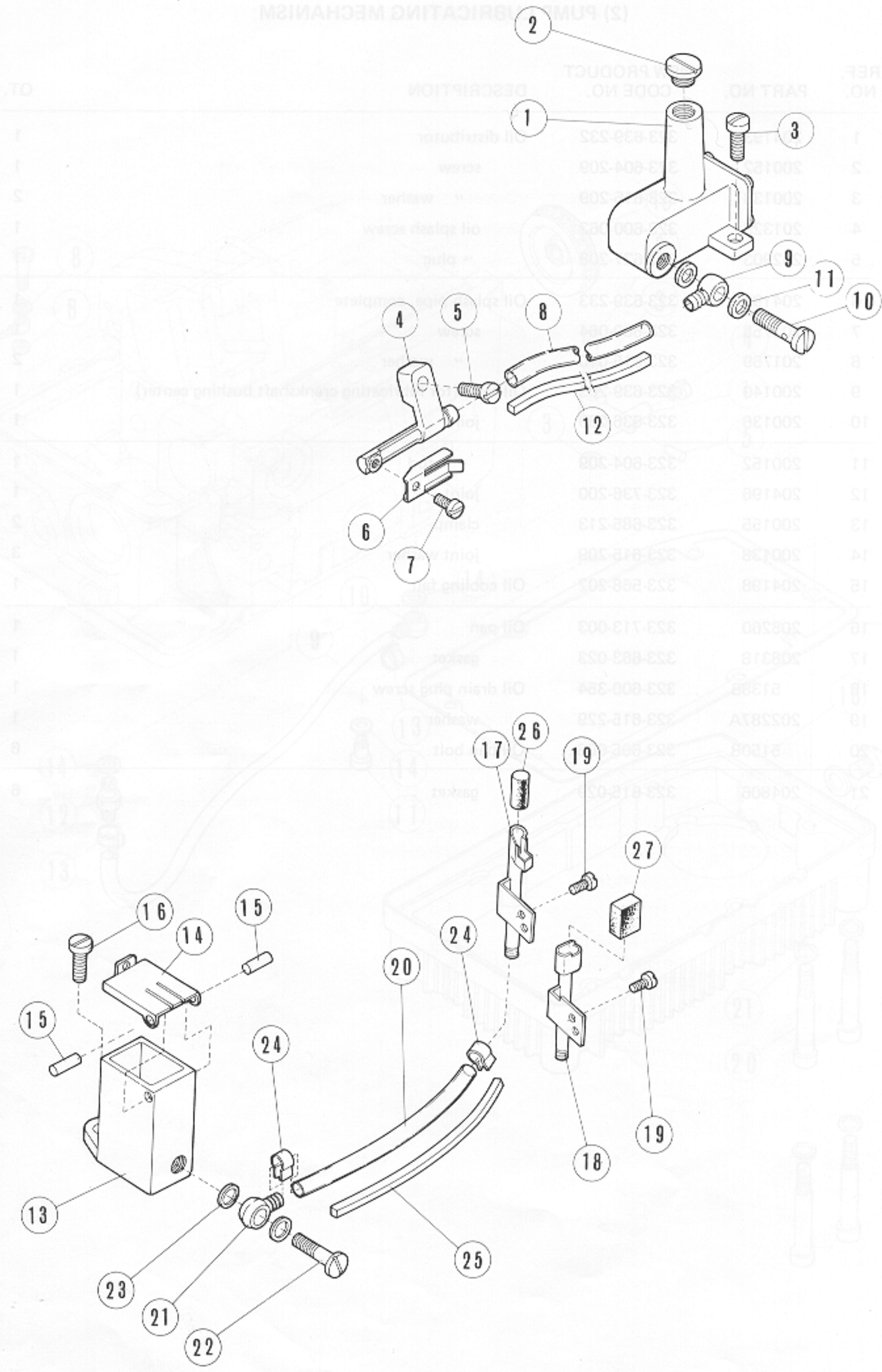
REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204593	323-900-012	Gear pump, complete	1
2	200162	323-604-209	(includes parts of Ref. Nos. 1-12)	1
1	204180	323-515-203	Gear pump housing, complete	1
2	5145	323-600-326	Gear pump housing oil plug screw	1
3	201293A	323-800-006	Gear pump casing plate	1
4	5117	323-600-057	screw	4
5	201294	323-764-001	Pump gear (right)	1
6	201295	323-764-002	Pump gear (left)	1
7	204183	323-540-237	Pump gear shaft (long), set with 201009	1
8	201009	323-649-001	key	1
9	204184	323-540-236	Pump gear shaft (short)	1
10	1458	323-600-037	screw	2
11	204187	323-570-204	Worm wheel	1
12	5060	323-600-004	screw	2
13	204186	323-570-203	Worm	1
14	2022	323-600-043	screw	1
15	204185	323-632-201	Gear pump outlet 'o' ring	1
16	5094	323-600-072	Gear pump housing screw	2
17	201338	323-655-002	Oil screen filter	1
18	201311	323-663-001	gasket	1
19	201341	323-508-002	frame	1
20	5117	323-600-057	screw	1
21	204188	323-902-020	Oil cooler assembly	1
22	5117	323-600-057	screw	8
23	204192	323-663-211	gasket	2
24	204189	323-683-214	clamp	1
25	3001	323-600-059	" screw	1



(2) PUMP LUBRICATING MECHANISM

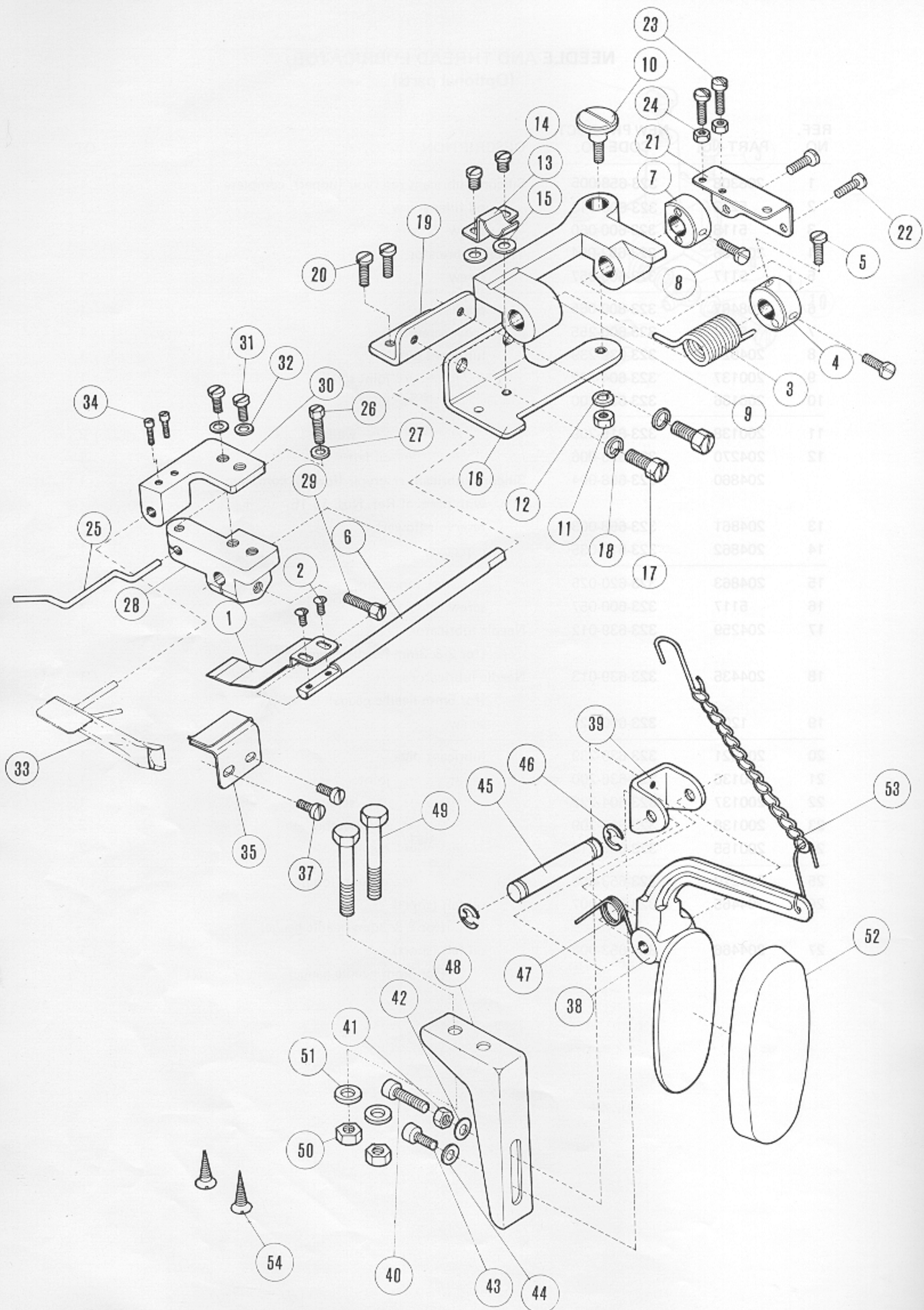
REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204193	323-639-232	Oil distributor	1
2	200152	323-604-209	screw	1
3	200138	323-615-209	" washer	2
4	201323	323-600-062	oil splash screw	1
5	202903	323-627-208	" plug	1
6	204194	323-639-233	Oil splash pipe, complete	1
7	201758	323-600-064	screw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

(2) PUMP LUBRICATING MECHANISM



NEEDLE AND THREAD LUBRICATOR (Optional parts)

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208308	323-658-005	Silicone lubricant reservoir (upper), complete	1
2	5242	323-600-143	oil filler screw	1
3	5118	323-600-060	screw	1
4	208486	323-652-004	Thread lubricator	1
5	5117	323-600-057	screw	1
6	208487	323-800-065	plate	1
7	5012	323-600-255	" screw	1
8	204921	323-639-239	lubricant pipe	1
9	200137	323-604-222	" " joint screw	1
10	200136	323-636-200	" " joint	1
11	200138	323-615-209	" " " washer	2
12	204270	323-653-006	" " oil felt	1
13	204860	323-658-004	Silicone lubricant reservoir (lower), complete with parts of Ref. Nos. 13-15	1
13	204861	323-658-003	reservoir (lower)	1
14	204862	323-510-035	cap cover	1
15	204863	323-620-025	" " hinge pin	2
16	5117	323-600-057	screw	1
17	204259	323-639-012	Needle lubricator (for 2 & 3mm needle gauge)	1
18	204435	323-639-013	Needle lubricator (for 5mm needle gauge)	1
19	1206	323-600-021	screw	1
20	204921	323-639-239	lubricant pipe	1
21	200136	323-636-200	" " joint	1
22	200137	323-604-222	" " " screw	1
23	200138	323-615-209	" " " washer	2
24	200155	323-685-213	" " clamp	2
25	204270	323-653-006	" " oil felt (long)	1
26	204465	323-653-007	oil felt (short) (for 2 & 3mm needle gauge)	1
27	204466	323-653-008	oil felt (short) (for 5mm needle gauge)	1
44	13142	323-615-012	" " " washer	1
45	181	323-620-100	pin	1
46	20222	323-634-200	" " " joint	2
47	196	323-640-100	" " " joint	1
48	197	323-605-100	" " " joint	1
49	5347	323-605-003	" " " joint	2
50	5348	323-630-013	" " " joint	2
51	204986	323-615-021	" " " washer	2
52	198	323-685-001	" " " joint	1
53	189	323-732-002	" " " joint	1
54	5341	323-600-101	" " " joint	2

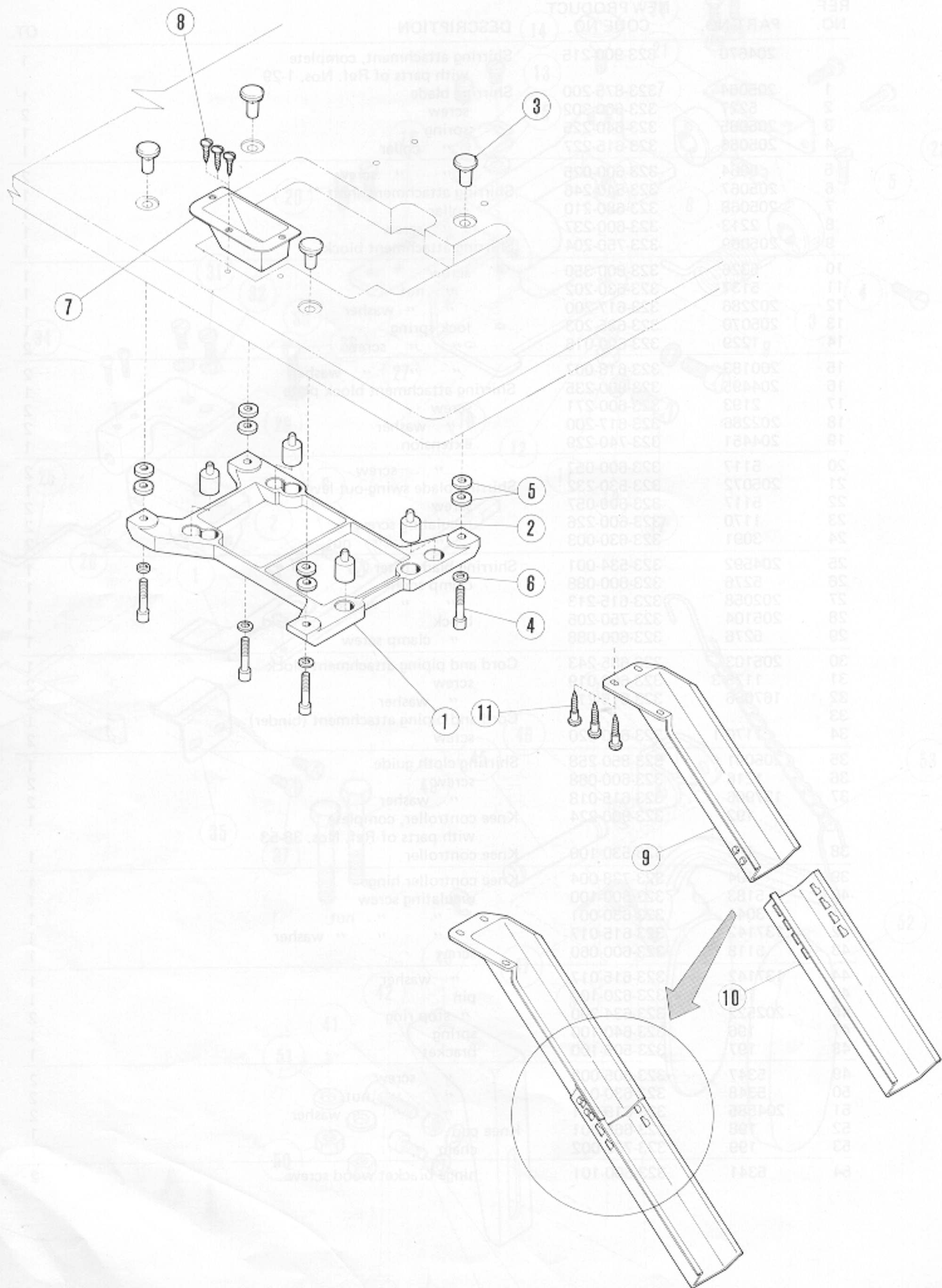


ACCESSORIES FOR SHIRTING INSTALLATION

ATTACHMENTS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
	204670	323-900-215	Shirring attachment, complete with parts of Ref. Nos. 1-29	1
1	205064	323-875-200	Shirring blade	1
2	5227	323-600-302	screw	2
3	205065	323-640-225	spring	1
4	205066	323-615-227	" collar	1
5	5064	323-600-025	" " screw	2
6	205067	323-540-246	Shirring attachment shaft	1
7	205068	323-680-210	collar	1
8	2213	323-600-237	" screw	1
9	205069	323-750-204	Shirring attachment block	1
10	5326	323-600-350	screw	1
11	5137	323-630-202	" nut	1
12	202286	323-617-200	" " washer	1
13	205070	323-625-203	lock spring	1
14	1229	323-600-016	" " screw	2
15	200183	323-618-007	" " " washer	2
16	204495	323-800-235	Shirring attachment block plate	1
17	2193	323-600-271	screw	2
18	202286	323-617-200	" washer	2
19	204451	323-740-229	extension	1
20	5117	323-600-057	" screw	2
21	205072	323-530-232	Shirring blade swing-out lever	1
22	5117	323-600-057	screw	2
23	1170	323-600-226	regulating screw	2
24	3091	323-630-003	" " nut	2
25	204592	323-534-001	Shirring blade lifter	1
26	5276	323-600-088	clamp screw	1
27	202058	323-615-213	" " washer	1
28	205104	323-750-205	block	1
29	5276	323-600-088	" clamp screw	1
30	205103	323-685-243	Cord and piping attachment block	1
31	1175-3	323-600-019	screw	2
32	167066	323-615-211	" washer	2
33			Cord and piping attachment (binder)	1
34	1170-1	323-600-020	screw	2
35	205091	323-850-258	Shirring cloth guide	1
36	1216	323-600-068	screw	2
37	137906	323-615-018	" washer	2
	192	323-900-224	Knee controller, complete with parts of Ref. Nos. 38-53	1
38	193	323-530-100	Knee controller	1
39	194	323-728-004	Knee controller hinge	1
40	5183	323-600-100	regulating screw	1
41	3044	323-630-001	" " nut	1
42	137142	323-615-017	" " " washer	1
43	5118	323-600-060	screw	1
44	137142	323-615-017	" washer	1
45	195	323-620-100	pin	1
46	202522	323-634-200	" stop ring	2
47	196	323-640-100	spring	1
48	197	323-505-100	bracket	1
49	5347	323-605-003	" screw	2
50	5348	323-630-013	" " nut	2
51	204585	323-615-021	" " " washer	2
52	198	323-665-001	Knee pad	1
53	199	323-732-002	chain	1
54	5341	323-600-101	hinge bracket wood screw	2

ATTACHMENTS

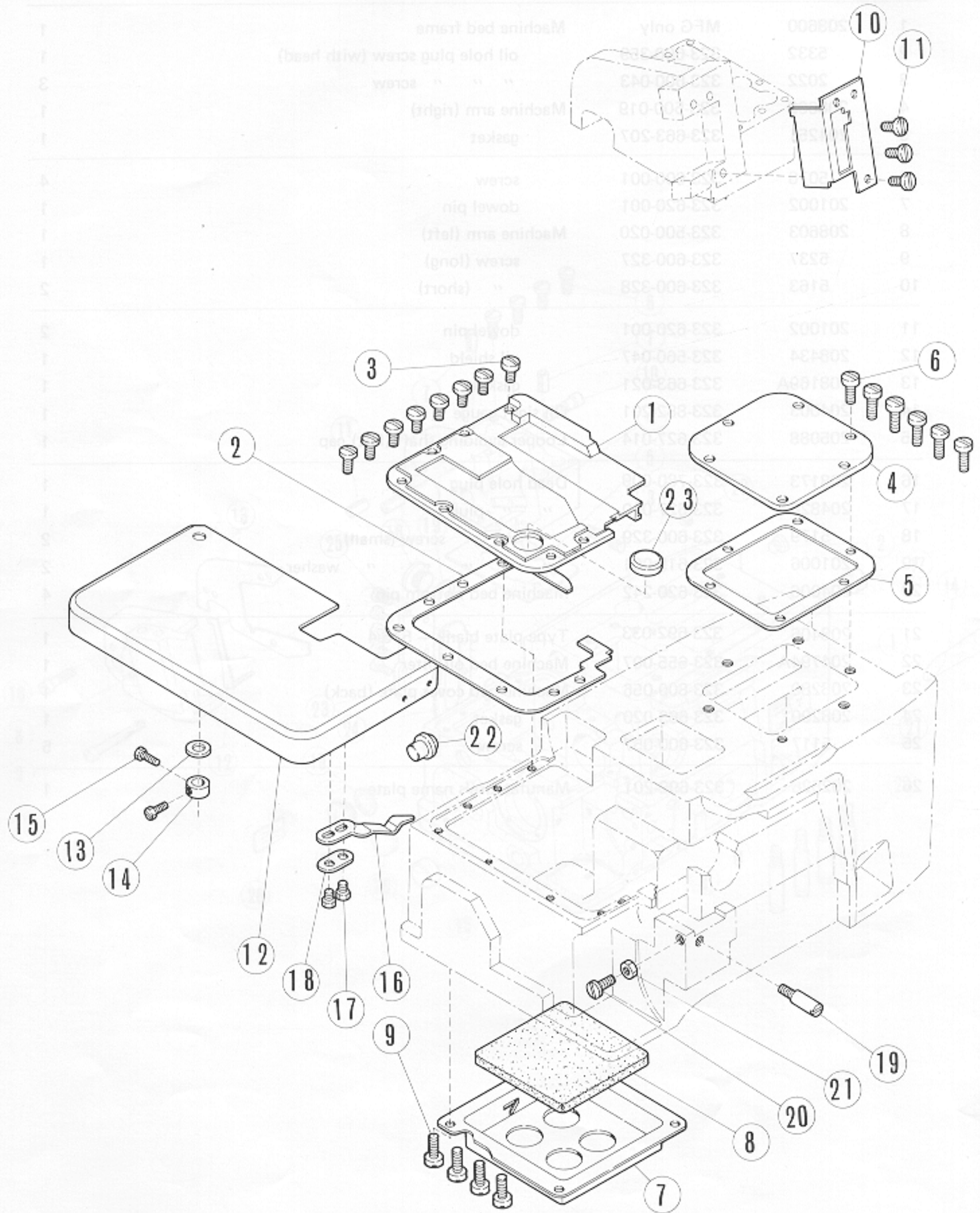


ACCESSORIES FOR SEMI-SUBMERGED INSTALLATION

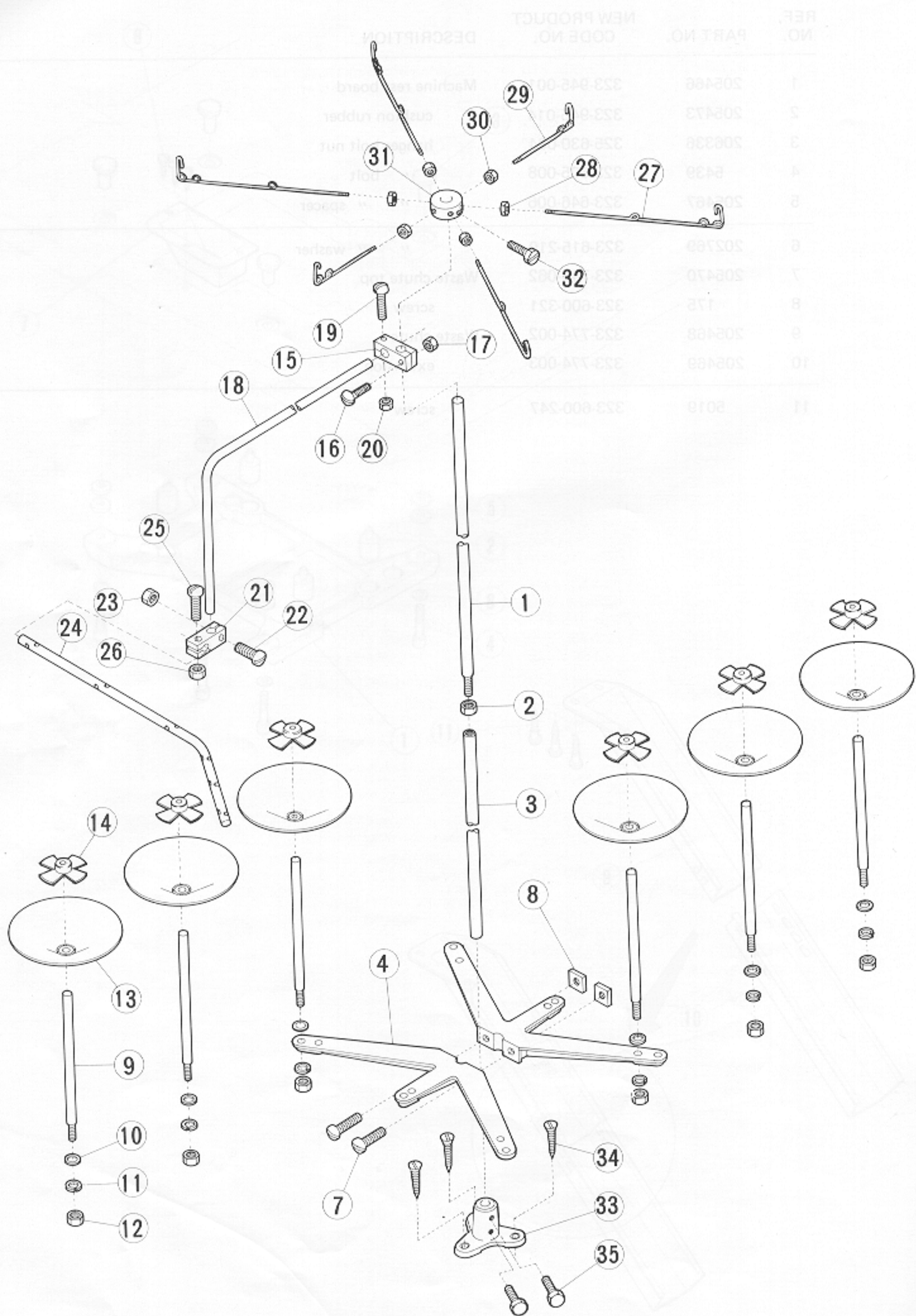
REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT. SPOOLS	QT.
1	205466	323-945-001	Machine rest board	1	1
2	205473	323-945-014	cushion rubber	4	4
3	206336	325-630-004	hanger bolt nut	4	4
4	5439	323-605-008	" bolt	4	4
5	205467	323-646-006	" " spacer	8	8
6	202769	323-615-219	" " washer	4	4
7	205470	323-740-062	Waste chute top	1	1
8	175	323-600-321	screw	3	3
9	205468	323-774-002	Waste chute	1	1
10	205469	323-774-003	extension	1	1
11	5019	323-600-247	screw	4	4
10	224	323-615-028	washer	3	3
11	225	323-617-001	nut spring washer	3	3
12	226	323-630-019	nut	3	3
13	227	323-685-013	Spool tray	3	3
14	228	323-850-031	Spool retaining fin	3	3
15	229	323-740-034	Thread guide bar rod bracket	1	1
16	230	323-600-120	clamp screw	1	1
17	231	323-630-020	" " nut	1	1
18	232	323-635-005	Thread guide bar rod	1	1
19	230	323-600-120	screw	1	1
20	231	323-630-020	" nut	1	1
21	233	323-750-006	Thread guide rod retaining block	1	1
22	230	323-600-120	clamp screw	1	1
23	231	323-630-020	" " nut	1	1
24	293	323-690-004	Thread guide bar	1	1
25	230	323-600-120	clamp screw	1	1
26	231	323-630-020	" " nut	1	1
27	235	323-851-021	Thread guide wire (long)	2	2
28	236	323-630-021	lock nut	2	2
29	237	323-851-020	Thread guide wire (short)	2	2
30	236	323-630-021	lock nut	2	2
31	260	323-685-015	Thread guide wire holder	1	1
	261	323-685-017	holder	1	1
	262	323-685-018	holder	1	1
	238	323-685-014	holder	1	1
32	239	323-600-121	screw	1	1
33	240	323-605-000	Thread stand base	1	1
34	241	323-600-122	wood screw	3	3
35	242	323-600-123	Thread stand lower rod screw	2	2

MACHINE BED FRAME

QTY	DESCRIPTION	NEW PRODUCT CODE NO.	PART NO.	REF. NO.
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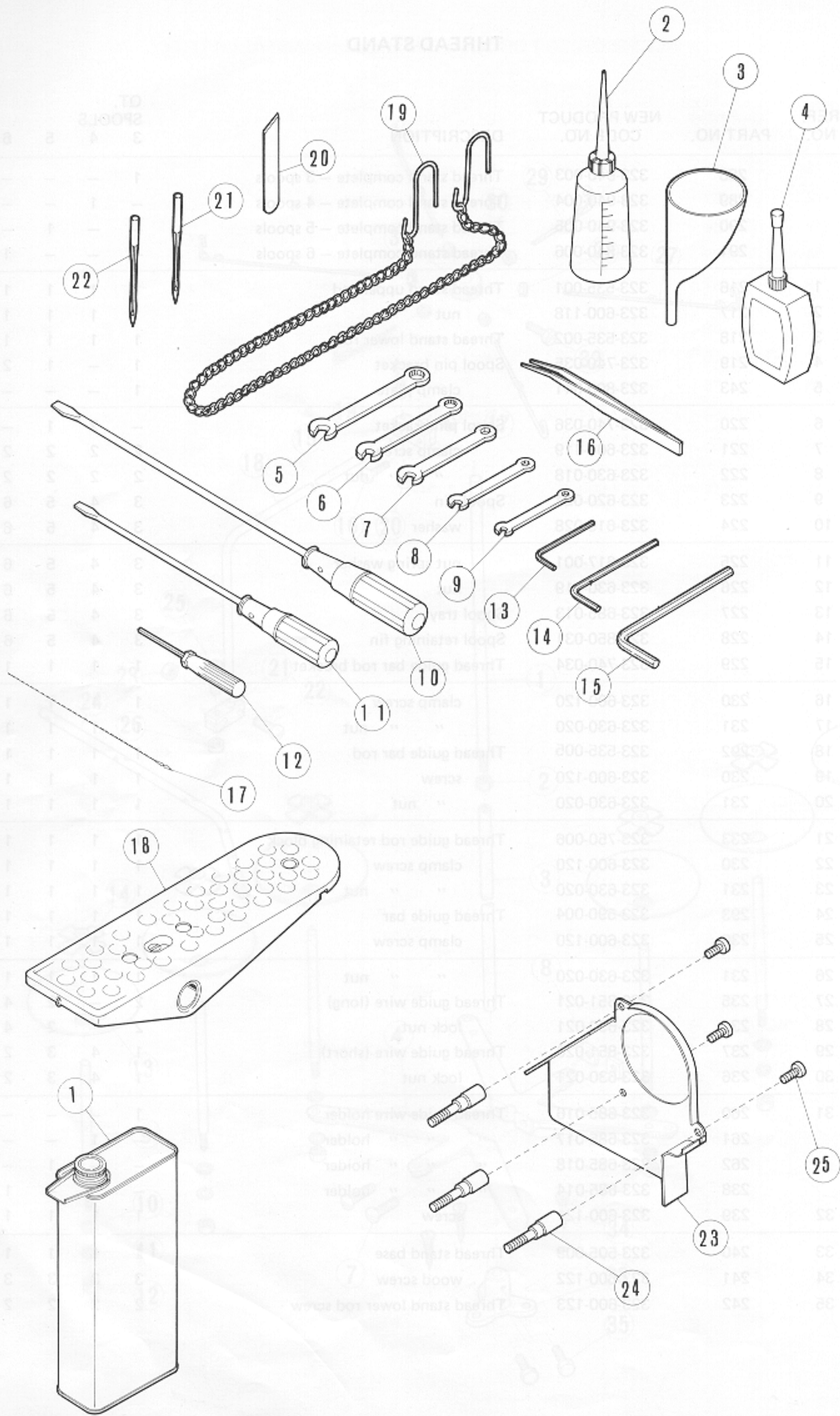
ACCESSORIES FOR SEMI-SUBMERGED INSTALLATION



REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION
1	205486	323-845-00	Machine shaft
2	205473	323-845-01	Machine rubber
3	205336	323-830-01	Machine nut
4	5439	323-845-02	Machine bolt
5	205487	323-845-03	Machine shaft
6	205389	323-815-01	Machine nut
7	205470	323-845-04	Machine nut
8	175	323-800-321	Machine nut
9	205488	323-774-002	Machine shaft
10	205489	323-774-003	Machine shaft
11	5019	323-800-347	Machine nut

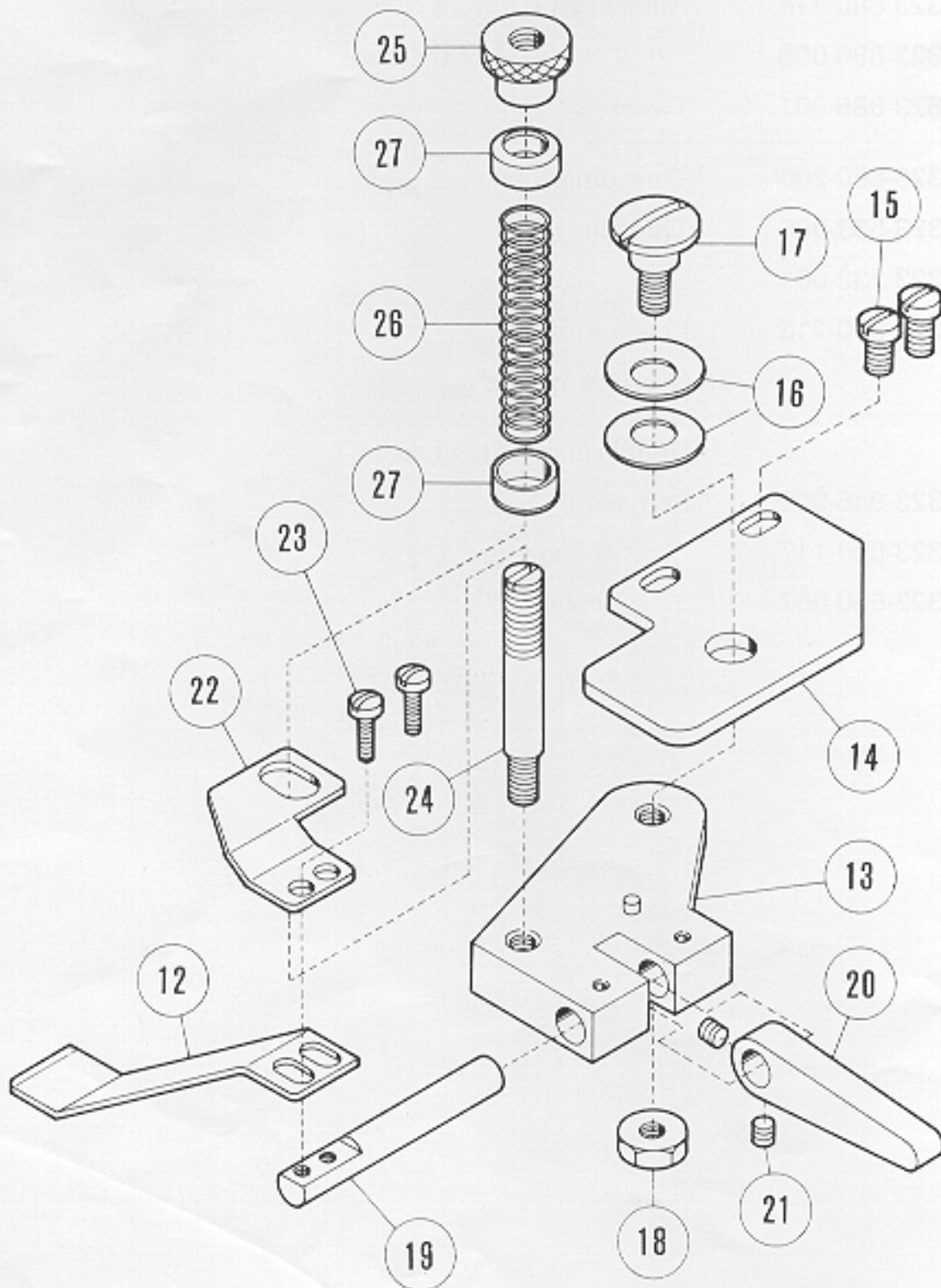
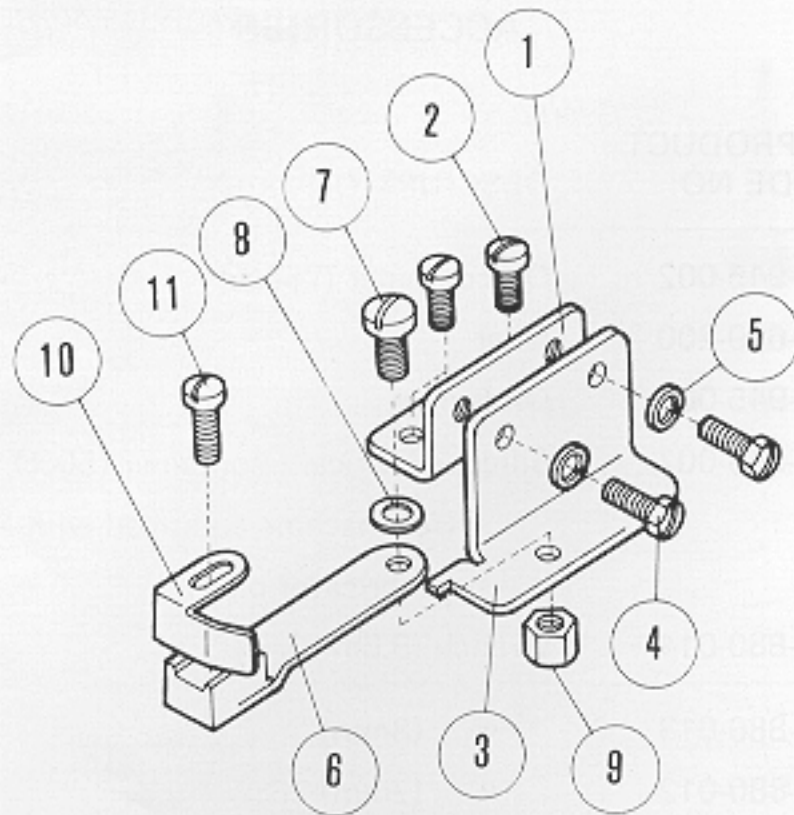
THREAD STAND

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT. SPOOLS			
				3	4	5	6
	288	323-940-003	Thread stand complete — 3 spools	1	—	—	—
	289	323-940-004	Thread stand complete — 4 spools	—	1	—	—
	290	323-940-005	Thread stand complete — 5 spools	—	—	1	—
	291	323-940-006	Thread stand complete — 6 spools	—	—	—	1
1	216	323-535-001	Thread stand upper rod	1	1	1	1
2	217	323-600-118	nut	1	1	1	1
3	218	323-535-002	Thread stand lower rod	1	1	1	1
4	219	323-740-035	Spool pin bracket	1	—	1	2
5	243	323-800-041	clamp plate	1	—	—	—
6	220	323-740-036	Spool pin bracket	—	2	1	—
7	221	323-600-119	clamp screw	2	2	2	2
8	222	323-630-018	“ “ nut	2	2	2	2
9	223	323-620-024	Spool pin	3	4	5	6
10	224	323-615-028	washer	3	4	5	6
11	225	323-617-001	nut spring washer	3	4	5	6
12	226	323-630-019	nut	3	4	5	6
13	227	323-685-013	Spool tray	3	4	5	6
14	228	323-850-031	Spool retaining fin	3	4	5	6
15	229	323-740-034	Thread guide bar rod bracket	1	1	1	1
16	230	323-600-120	clamp screw	1	1	1	1
17	231	323-630-020	“ “ nut	1	1	1	1
18	292	323-535-005	Thread guide bar rod	1	1	1	1
19	230	323-600-120	screw	1	1	1	1
20	231	323-630-020	“ nut	1	1	1	1
21	233	323-750-006	Thread guide rod retaining block	1	1	1	1
22	230	323-600-120	clamp screw	1	1	1	1
23	231	323-630-020	“ “ nut	1	1	1	1
24	293	323-590-004	Thread guide bar	1	1	1	1
25	230	323-600-120	clamp screw	1	1	1	1
26	231	323-630-020	“ “ nut	1	1	1	1
27	235	323-851-021	Thread guide wire (long)	2	—	2	4
28	236	323-630-021	lock nut	2	—	2	4
29	237	323-851-020	Thread guide wire (short)	1	4	3	2
30	236	323-630-021	lock nut	1	4	3	2
31	260	323-685-016	Thread guide wire holder	1	—	—	—
	261	323-685-017	“ “ “ holder	—	1	—	—
	262	323-685-018	“ “ “ holder	—	—	1	—
	238	323-685-014	“ “ “ holder	—	—	—	1
32	239	323-600-121	screw	1	1	1	1
33	240	323-505-009	Thread stand base	1	1	1	1
34	241	323-600-122	wood screw	3	3	3	3
35	242	323-600-123	Thread stand lower rod screw	2	2	2	2



ACCESSORIES

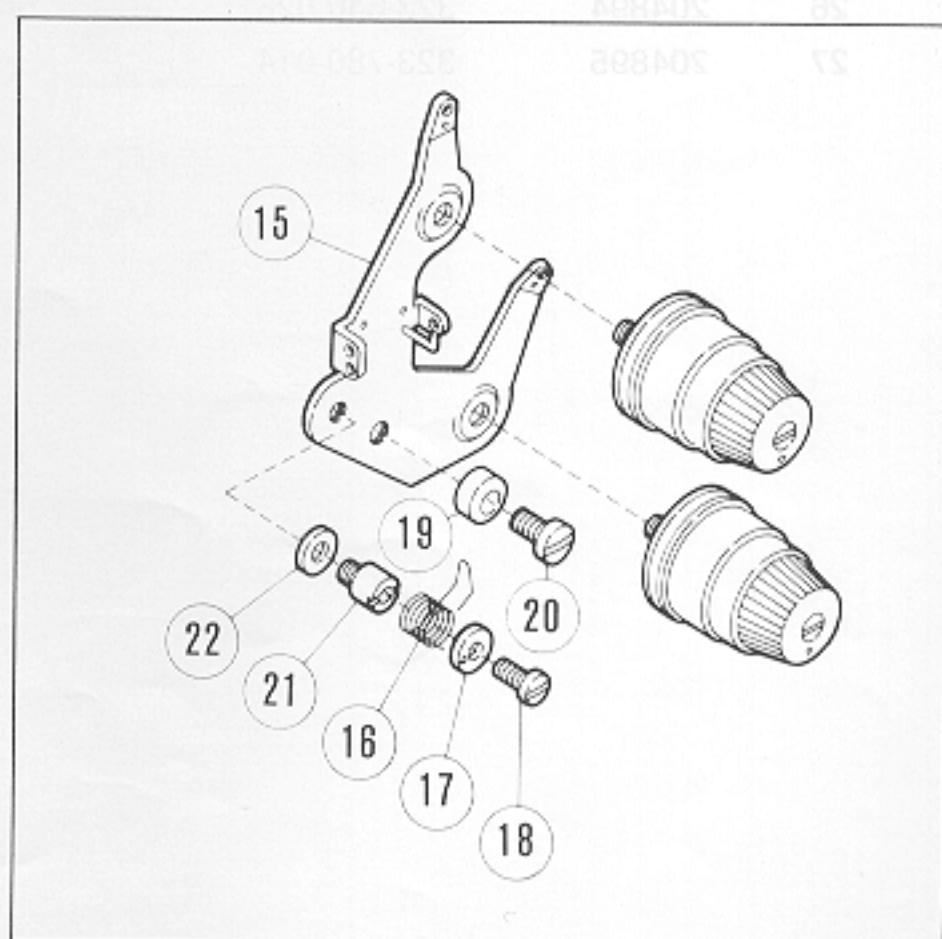
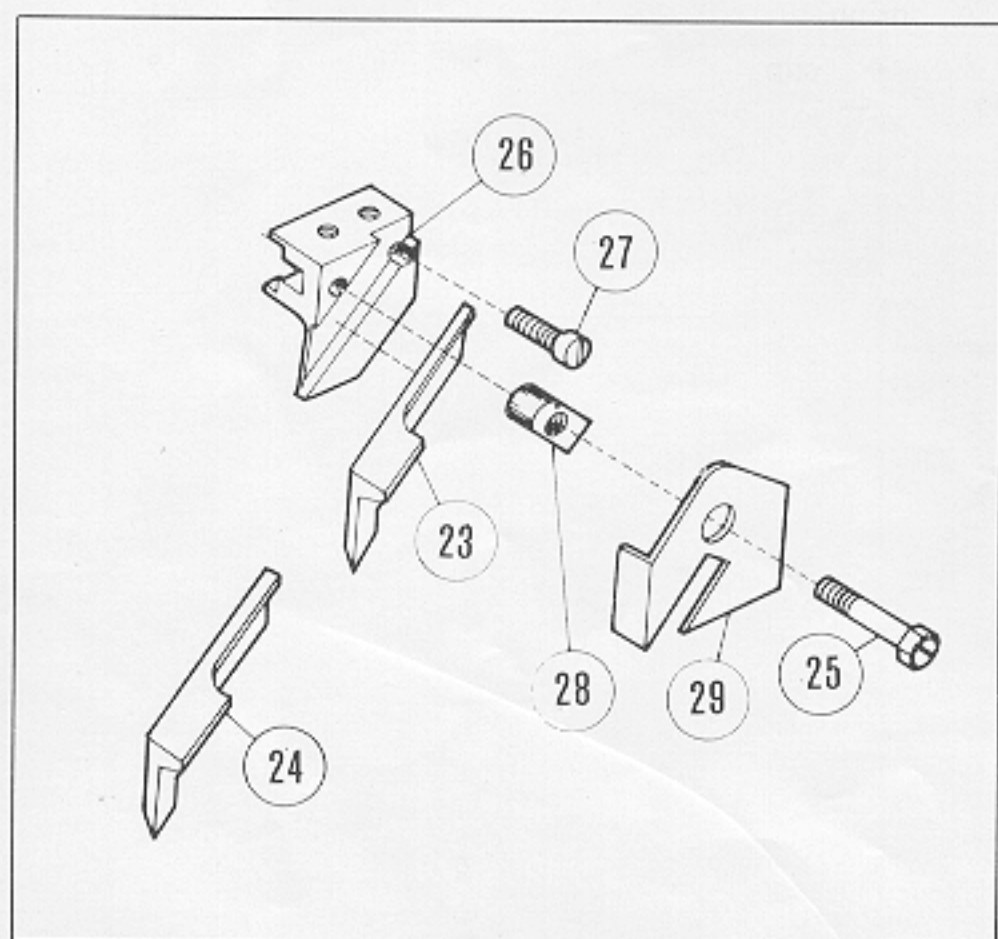
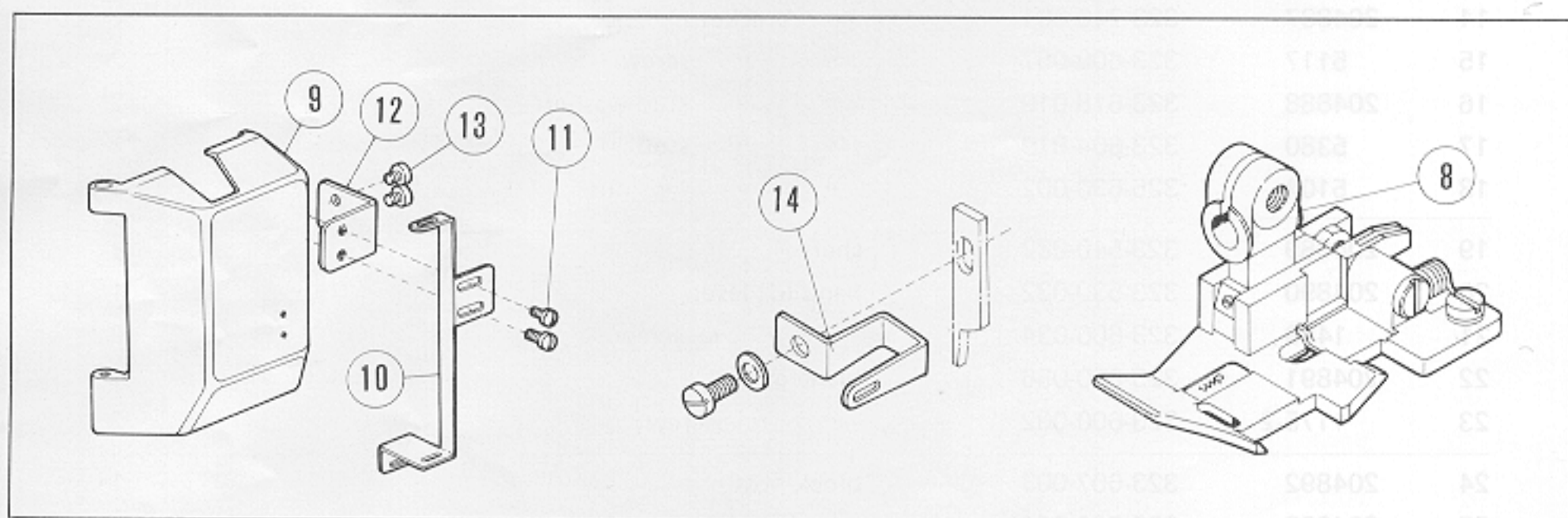
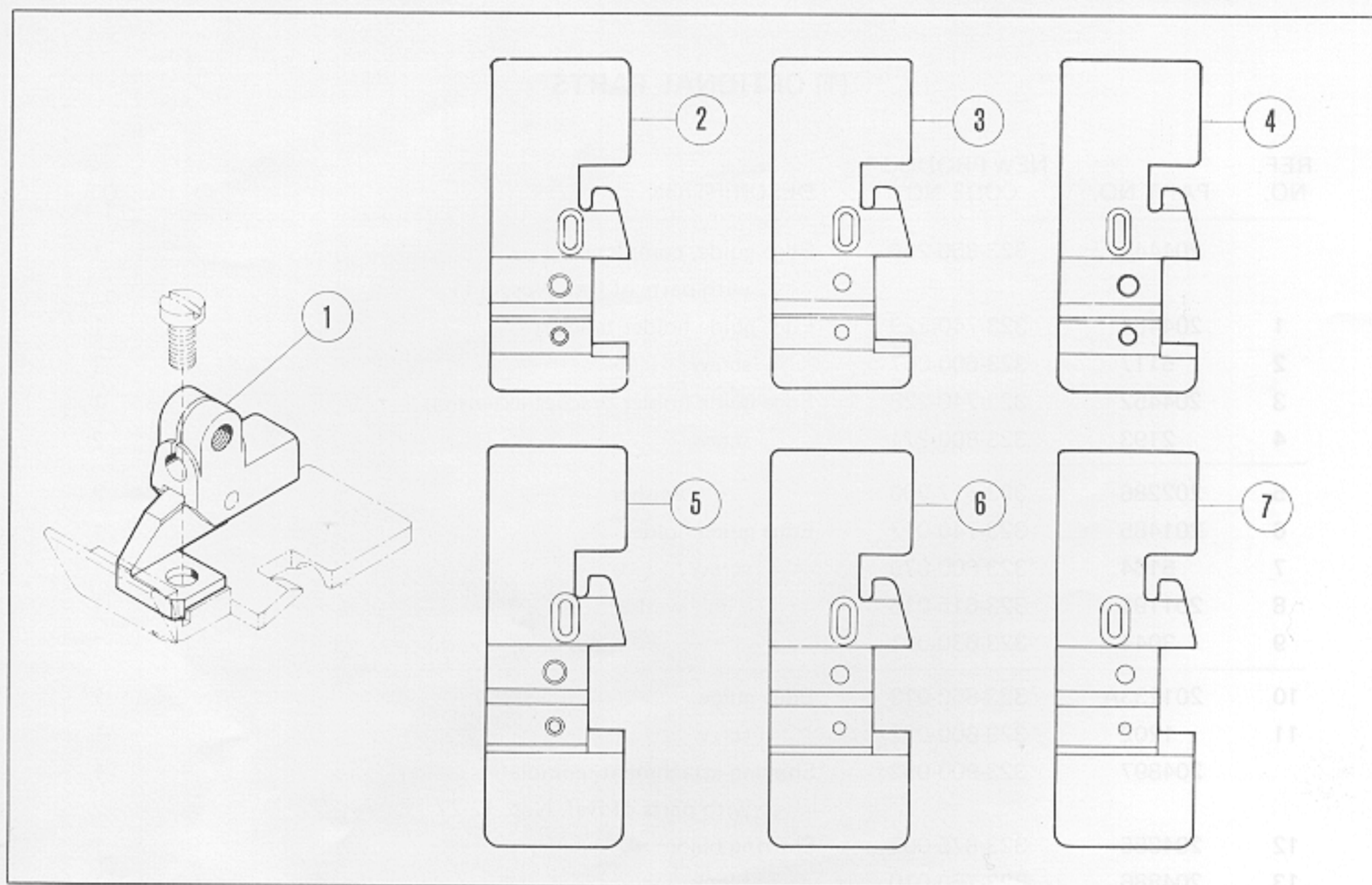
REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	133	323-945-002	Oil container (750cc)	1
2	132	323-659-200	Oiler	1
3	135A	323-945-003	Oil funnel	1
4	178	323-945-007	Silicone lubricant container (50cc)	1
4	2193	323-600-27	(for machine equipped with Needle and Thread Lubricator only)	2
5	286	323-880-014	Wrench (9.5mm)	1
6	285	323-880-013	" (8mm)	1
7	284	323-880-012	" (7mm)	1
8	283	323-880-011	" (6mm)	1
9	282	323-880-010	" (5mm)	1
10	127	323-885-001	Screwdriver (large)	1
11	128	323-885-002	" (medium)	1
12	179	323-885-200	Allen wrench	1
13	182	323-880-214	Allen key (3.17mm)	1
14	200	323-880-005	" " (4.76mm)	1
16	131	323-886-001	Tweezers	1
17	153	323-660-200	Threading wire	1
18	245	323-533-005	Threadle	1
19	126	323-732-001	" chain	1
20	204161	323-870-213	Lower knife	2
21			Overlock needle	10
22			Double chainstitch needle	10
23	205216A	323-945-009	Belt guard	1
24	205217	323-600-117	fixing screw	3
25	5117	323-600-057	screw	3



REF. NO.	PART NO.	NEW PRODUCT CODE NO.
1	133	323 880 01
2	132	323 880 01
3	138A	323 880 01
4	138	323 880 01
5	288	323 880 01
6	288	323 880 01
7	284	323 880 01
8	283	323 880 01
9	285	323 880 01
10	137	323 880 01
11	138	323 880 01
12	139	323 880 01
13	182	323 880 01
14	200	323 880 01
15	131	323 880 01
16	183	323 880 01
17	245	323 880 01
18	138	323 880 01
19	204181	323 880 01
20	205218A	323 880 01
21	205217	323 880 01
22	513	323 880 01
23		
24		
25		
26		
27		

(1) OPTIONAL PARTS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
	204449	323-850-256	Edge guide, complete with parts of Ref. Nos. 1-11	1
1	204451	323-740-229	Edge guide holder bracket	1
2	5117	323-600-057	screw	2
3	204452	323-740-228	Edge guide holder bracket extension	1
4	2193	323-600-271	screw	2
5	202286	323-617-200	" washer	2
6	201485	323-740-012	Edge guide holder	1
7	5184	323-600-079	screw	1
8	201191	323-615-015	" washer	1
9	3044	323-630-001	" " nut	1
10	201233A	323-850-013	Edge guide	1
11	1202	323-600-032	screw	1
	204897	323-900-052	Shirring attachment, complete with parts of Ref. Nos. 12-27	1
12	204885	323-875-002	Shirring blade	1
13	204886	323-750-010	block	1
14	204887	323-740-061	" bracket	1
15	5117	323-600-057	" " screw	2
16	204888	323-618-019	" " stud washer	2
17	5380	323-604-019	" " stud	1
18	5104	325-630-002	" " " nut	1
19	204889	323-540-032	shaft	1
20	204890	323-530-032	hand lift lever	1
21	1459	323-600-034	" " " screw	2
22	204891	323-850-056	blade guide	1
23	1175-2	323-600-002	" " " screw	2
24	204892	323-607-003	block post	1
25	204893	323-630-034	" " thumb nut	1
26	204894	323-640-026	" " spring	1
27	204895	323-780-014	" " " cup	2
20	5117	323-600-057	" screw	
21	204951	323-604-017	stud	
22	202757	323-615-215	washer	
23	204952	323-600-217	Upper knife (angled)	
24	204955	323-582-004	" " (angled) - carbide tipped	
25	5299	323-600-000	screw	
26	208405	323-750-011	clamp	
27	1176	323-600-225	screw	
28	201155	323-850-013	edge guide	
29	201156	323-600-032	screw	



(2) OPTIONAL PARTS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
Cord and piping foot for shirring machine models (515-4-38 and 515-4-39 only)				
1	208554	323-740-063	Cord and piping foot bracket, complete	1
2	204499	323-820-290	Cord and piping foot — 2mm x 3mm (needle gauge x	1
	204500	323-820-291	“ “ “ foot — 2mm x 4mm Cord diameter)	1
	204501	323-820-292	“ “ “ foot — 2mm x 5mm	1
3	204502	323-820-293	“ “ “ foot — 3mm x 3mm	1
	204503	323-820-294	“ “ “ foot — 3mm x 4mm	1
	204504	323-820-295	“ “ “ foot — 3mm x 5mm	1
4	204505	323-820-296	“ “ “ foot — 5mm x 3mm	1
	204506	323-820-297	“ “ “ foot — 5mm x 4mm	1
	204507	323-820-298	“ “ “ foot — 5mm x 5mm	1
Cord and piping foot for seaming machine models (for all machine models except 515-4-38 and 515-4-39)				
5	204508	323-820-264	Cord and piping foot — 2mm x 3mm	1
	204509	323-820-265	“ “ “ foot — 2mm x 4mm	1
	204510	323-820-266	“ “ “ foot — 2mm x 5mm	1
6	204511	323-820-268	“ “ “ foot — 3mm x 3mm	1
	204512	323-820-269	“ “ “ foot — 3mm x 4mm	1
	204513	323-820-270	“ “ “ foot — 3mm x 5mm	1
7	204514	323-820-277	“ “ “ foot — 5mm x 3mm	1
	204515	323-820-278	“ “ “ foot — 5mm x 4mm	1
	204516	323-820-300	“ “ “ foot — 5mm x 5mm	1
Taping foot				
8	208622	323-820-043	Taping foot — 3mm x 5mm (Needle gauge x Tape width)	1
9	204950	323-510-036	Needle bar cover	1
10	205318	323-756-004	Tape support	1
11	1234	323-600-006	screw	2
12	205335	323-850-037	bracket	1
13	1234	323-600-006	“ screw	2
14	205319	323-850-032	Tape guide	1
401 needle thread tension guide (used for 401 needle thread of monofilament)				
15	208484	323-850-057	Needle thread tension guide, complete	1
16	204960	323-642-004	Needle thread tension regulating spring	1
17	204962	323-630-025	adjust nut	1
18	2922	323-600-229	“ “ screw	1
19	202683	323-716-209	regulator	1
20	5117	323-600-057	“ screw	1
21	204961	323-604-017	stud	1
22	202757	323-615-218	“ washer	1
Angled upper knife				
23	204152	323-870-217	Upper knife (angled)	1
24	204835	323-870-004	“ “ (angled) — carbide tipped	1
25	5299	323-600-300	screw	1
26	208403	323-750-011	clamp	1
27	1170	323-600-226	“ screw	1
28	204155	323-683-213	gib	1
29	204156	323-560-225	guard	1

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

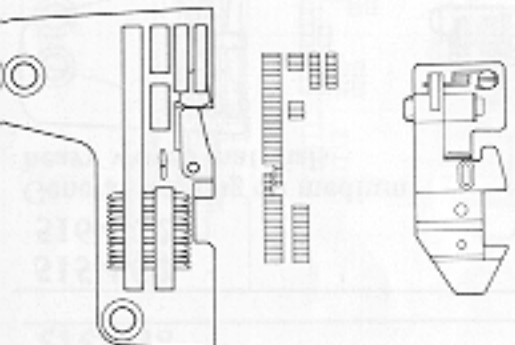
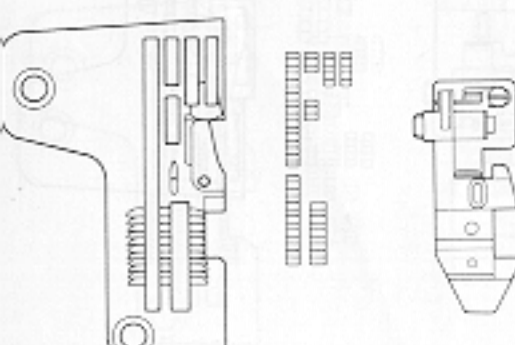
Machine model (Operation)	Gauge (mm) (inch)	Needle plate	Main feed	Differential feed	Presser foot complete	Presser foot fabric guard	Needle guard for 401 needle (front)	Needle guard (rear)	Needle bar complete	Right looper	401 looper	Upper knife	Others		
515-4-26 516-4-26 General seaming on woven and knit fabrics	2x3mm 5/64x1/8"	204343A 323-801-255	208063 323-830-069	208215 323-830-137	208500 323-820-037	208531 323-560-045	204536 323-561-211	204521 323-561-219	204877 323-843-001	204278 <i>215</i> 323-810-215	204314A 323-810-217	201121A 323-870-214	Needle (factory setting) DCx27 #11 423242831		
	2x4mm 5/64x5/32"	204344A 323-801-256	"	"	"	"	"	"	"	<i>Treaded</i>	"	"			
	2x5mm 5/64x3/16"	204345A 323-801-257	"	"	"	"	"	"	"	"	"	"			
	2x6mm 5/64x1/4"	204346A 323-801-258	"	"	"	"	"	"	"	"	"	"			
	3x3mm 1/8x1/8"	204294B 323-801-275	"	"	208501 323-820-038	"	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	"	"	"	"	"	"	"	"	"	"			
	5x3mm 3/16x1/8"	204358A 323-801-263	"	"	208502 323-820-039	"	"	"	204879 323-843-003	"	204431 323-810-219	"		DCx27 #14 423243631	
	5x4mm 3/16x5/32"	204359A 323-801-264	"	"	"	"	"	"	"	"	"	"			
	5x5mm 3/16x3/16"	204360A 323-801-310	"	"	"	"	"	"	"	"	"	"			
	5x6mm 3/16x1/4"	204361A 323-801-266	"	"	"	"	"	"	"	"	"	"			
	515-4-27 516-4-27 General seaming and serging on light weight materials	2x3mm 5/64x1/8"	204362 323-801-267	208065 323-830-071	208218 323-830-138	208503 323-820-040	208531 323-560-045	204536 323-561-211	204521 323-561-219	204877 323-843-001	204278 323-810-215	204314A 323-810-217		202527A 323-870-005	Needle (factory setting) DCx27 #11 423242831
		2x4mm 5/64x5/32"	204363 323-801-268	"	"	"	"	"	"	"	"	"		"	
2x5mm 5/64x3/16"		204364 323-801-269	"	"	"	"	"	"	"	"	"	"			
2x6mm 5/64x1/4"		204365 323-801-270	"	"	"	"	"	"	"	"	"	"			
3x3mm 1/8x1/8"		204366 323-801-271	"	"	208504 323-820-041	"	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	515-4	
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	516-4	
204702 323-810-009	4	13-16	034-040	85-100		
204703 323-810-010	6	17-21	042-051	100-140		

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 (rear)	Needle bar complete	Right looper	401 looper	Upper knife	Others
515-4-28 516-4-28 General seaming on permanent- press fabrics 	2x3mm 5/64x1/8"	204343A 323-801-255	208062 323-830-068	208216 323-830-139	208500 323-820-037	208531 323-560-045	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	"	"	208501 323-820-038	"	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	"	"	"	"	"	"	"	"	"	"	"
515-4-29 516-4-29 General seaming and serging on light to medium weight woven and knit fabrics 	2x3mm 5/64x1/8"	204362 323-801-267	208066 323-830-072	208219 323-830-140	208503 323-820-040	208531 323-560-045	204536 323-561-211	204521 323-561-219	204877 323-843-001	"	"	202527A 323-870-005	
	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	"	"	208504 323-820-041	"	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	515-4
204704 323-810-011	3		13-16	034-040	85-100	
204705 323-810-012	5		17-21	042-051	100-140	

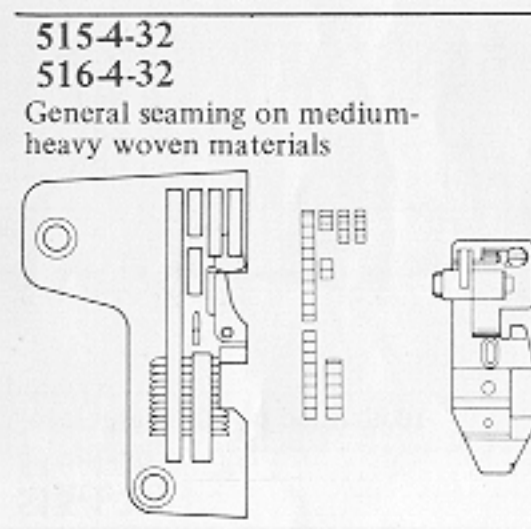
Right looper			for needle size			Model
Part number	Mark		Singer	W & G	Metric	
204062 323-810-218	2		9-12	027-032	65-80	516-4
204702 323-810-009	4		13-16	034-040	85-100	
204703 323-810-010	6		17-21	042-051	100-140	

(1) MISCELLANEOUS COVERS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208317	323-800-057	Bedplate	1
2	208422	323-663-024	gasket	1
3	4009-1	323-600-014	screw	8
4	208341	323-800-055	Bed cover plate (right)	1
5	208342	323-663-022	gasket	1
6	5117	323-600-057	screw	6
7	208347	323-510-078	Machine bed bottom cover	1
8	208348	323-655-011	oil filter	1
9	5117	323-600-057	screw	4
10	208430	323-800-061	Face plate	1
11	4009-1	323-600-014	screw	3
12	208610	323-802-014	Cloth plate, complete	1
13	202576	323-615-201	hinge stud thrust washer	1
14	201139	323-680-001	" " " collar	1
15	5084	323-600-013	" " " " screw	2
16	204218	323-734-204	lock spring	1
17	1216	323-600-068	" " screw	2
18	200162A	323-615-015	" " " washer	1
19	5232	323-600-314	" " latch	1
20	5441	323-600-140	stop screw	1
21	3044	323-630-001	" " nut	1
22	208482	323-627-018	cushion (small)	1
23	204827	323-627-009	" (large)	1
24	201048A	323-617-200	Double chainstitch looper thread eyelet	1
25	201049A	323-617-200	Right looper thread eyelet	1
26	201050A	323-617-200	Right looper thread tube	1
27	201051A	323-617-200	Left looper thread eyelet	1
28	201052A	323-617-200	Left looper thread tube	1
29	201053A	323-617-200	Double chainstitch looper thread eyelet	1
30	201054A	323-617-200	Stitch indicator	1
31	204871	323-627-009	rivet	1
32	204865A	323-627-009	Machine cover (left)	1
33	5091	323-600-057	screw (short)	2
34	5182	323-600-057	" (long)	1
35	204868	323-600-014	spacer	1
36	2302	323-600-014	" screw	1
37	202286	323-617-200	" " " " " " "	1
38	208340	323-801-004	Diff. feed ratio indication plate	1

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 (rear)	Needle bar complete	Right looper	401 looper	Upper knife	Others
515-4-31 516-4-31 Seaming on coarse woven fabrics	2x3mm 5/64x1/8"	204370 323-801-279	208070 323-830-076	208223 323-830-141	208500 323-820-037	208531 323-560-045	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	208501 323-820-038	..	204042 323-561-218	204522 323-561-220	204878 323-843-002	
	3x4mm 1/8x5/32"	204375 323-801-284	Needle (factory setting)
	3x5mm 1/8x3/16"	204376 323-801-285	DCx27 #16 423244031
	3x6mm 1/8x1/4"	204377 323-801-286	
	5x3mm 3/16x1/8"	204378 323-801-287	208064 323-830-070	208225 323-830-142	208502 323-820-039	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	



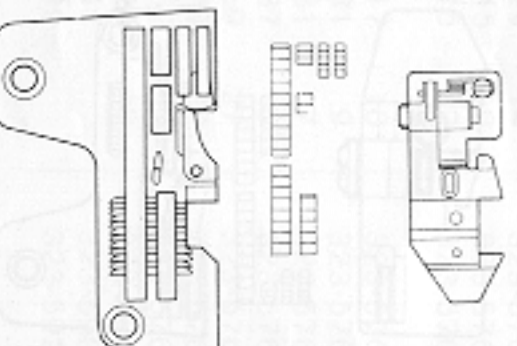
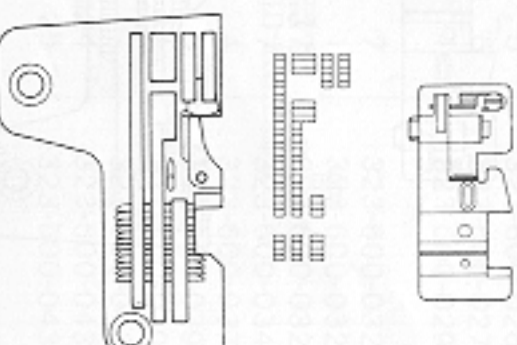
515-4-32 516-4-32 General seaming on medium-heavy woven materials	3x3mm 1/8x1/8"	204366 323-801-271	208067 323-830-073	208220 323-830-145	208504 323-820-041	208531 323-560-045	204878 323-843-002	..	204314A 323-810-217	202527A 323-870-005	
	3x4mm 1/8x5/32"	204367 323-801-272	Needle (factory setting)
	3x5mm 1/8x3/16"	204368 323-801-273	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	515-4
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	516-4
204702 323-810-009	4	13-16	034-040	85-100	
204703 323-810-010	6	17-21	042-051	100-140	

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 (rear)	Needle bar complete	Right looper	401 looper	Upper knife	Others
515-4-33 516-4-33 Seaming and turning corners on coarse woven materials	3x3mm 1/8x1/8"	204294B 323-801-275	208064 323-830-070	208217 323-830-136	208501 323-820-038	208531 323-560-045	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	"	"	"	"	"	"	"	"	"	"	
	5x3mm 3/16x1/8"	204358A 323-801-263	"	"	208502 323-820-039	"	"	"	204879 323-843-003	"	204431 323-810-219	"	Needle (factory setting) DCx27 #16 423244031
	5x4mm 3/16x5/32"	204359A 323-801-264	"	"	"	"	"	"	"	"	"	"	
	5x5mm 3/16x3/16"	204360A 323-801-310	"	"	"	"	"	"	"	"	"	"	
	5x6mm 3/16x1/4"	204361A 323-801-266	"	"	"	"	"	"	"	"	"	"	
	515-4-38 516-4-38 3:1 intermittent (knee controlled) shirring on dress weight materials	2x3mm 5/64x1/8"	204935 323-801-050	208074 323-830-080	204420 323-830-291	208507 323-820-034	208532 323-560-054	204536 323-561-211	204521 323-561-219	204877 323-843-001	204278 323-810-215	204314A 323-810-217	"
	2x4mm 5/64x5/32"	204936 323-801-051	"	"	"	"	"	"	"	"	"	"	
	2x5mm 5/64x3/16"	204937 323-801-052	"	"	"	"	"	"	"	"	"	"	
	2x6mm 5/64x1/4"	204938 323-801-053	"	"	"	"	"	"	"	"	"	"	
	3x3mm 1/8x1/8"	204939 323-801-054	"	"	208508 323-820-035	"	204042 323-561-218	204522 323-561-220	204878 323-843-002	204704 323-810-011	"	"	Shirring attachment
	3x4mm 1/8x5/32"	204940 323-801-055	"	"	"	"	"	"	"	"	"	"	
	3x5mm 1/8x3/16"	204941 323-801-056	"	"	"	"	"	"	"	"	"	"	
	3x6mm 1/8x1/4"	204942 323-801-057	"	"	"	"	"	"	"	"	"	"	
	5x3mm 3/16x1/8"	204943 323-801-058	208076 323-830-082	204422 323-830-295	208509 323-820-036	"	"	"	204879 323-843-003	"	204431 323-810-219	"	DCx27 #14 423243631
	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	515-4
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	516-4
204702	323-810-009	4	13-16	034-040	85-100	
204703	323-810-010	6	17-21	042-051	100-140	

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 (rear)	Needle bar complete	Right looper	401 looper	Upper knife	Others
515-4-39 516-4-39 3:1 intermittent (knee controlled) shirring on medium heavy materials	2x3mm 5/64x1/8"	204935 323-801-050	208075 323-830-081	204421 323-830-245	208507 323-820-034	208532 323-560-054	204536 323-561-211	204521 323-561-219	204877 323-843-001	204278 323-810-215	204314A 323-810-217	201121A 323-870-214	Needle (factory setting)
	2x4mm 5/64x5/32"	204936 323-801-051	"	"	"	"	"	"	"	"	"	"	DCx27 #16 423244031
	2x5mm 5/64x3/16"	204937 323-801-052	"	"	"	"	"	"	"	"	"	"	"
	2x6mm 5/64x1/4"	204938 323-801-053	"	"	"	"	"	"	"	"	"	"	"
	3x3mm 1/8x1/8"	204939 323-801-054	"	"	208508 323-820-035	"	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	208077 323-830-083	204423 323-830-297	208509 323-820-036	"	"	"	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	"	"	"	"	"	"	"	"	"	"	"
515-4-51. 516-4-51 Seaming and crossing seams on heavy coarse woven materials	5x5mm 3/16x3/16"	204700 323-801-034	208064 323-830-070	208225 323-830-142	208506 323-820-033	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
515-4-52. 516-4-52 Seaming and crossing seams on heavy coarse woven materials	5x5mm 3/16x3/16"	204528 323-801-358	"	208217 323-830-136	"	"	"	"	"	"	"	"	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

CROSS NUMBER INDEX

(new product code numbers vs part numbers)

NEW PRODUCT CODE NO.	OLD NO.	PAGE	REF NO.	NEW PRODUCT CODE NO.	OLD NO.	PAGE	REF NO.	NEW PRODUCT CODE NO.	OLD NO.	PAGE	REF NO.
	5302A	39	12	323-560-045	208531	50		323-593-003	204123A	25	29
	208415	23	22	323-560-045	208531	51		323-593-207	204124	25	30
323-500-019	208602	3	4	323-560-046	208109	25	44	323-600-001	5078	3	6
323-500-020	208603	3	8	323-560-047	208434	3	12	323-600-002	1175-2	15	32
323-502-011	208526	29	1	323-560-051	204848A	7	1	323-600-002	1175-2	25	48
323-502-213	204139A	23	39	323-560-052	208604	7	32	323-600-002	1175-2	27	17
323-505-009	240	41	33	323-560-053	208616	13	34	323-600-002	1175-2	27	25
323-505-012	204982	11	34	323-560-054	208532	51		323-600-002	1175-2	45	23
323-505-100	197	37	48	323-560-054	208532	52		323-600-004	5060	27	11
323-508-002	201341	31	19	323-560-225	204156	47	29	323-600-004	5060	31	12
323-510-030	204650A	7	30	323-561-013	204781	11	18	323-600-006	1234	7	6
323-510-035	204862	35	14	323-561-014	204782	11	20	323-600-006	1234	47	11
323-510-036	204950	47	9	323-561-018	204988	11	27	323-600-006	1234	47	13
323-510-043	208001	7	18	323-561-019	204924	11	27	323-600-008	5080	9	28
323-510-078	208347	5	7	323-561-211	204536	48		323-600-009	5081	9	29
323-510-079	208299	7	11	323-561-211	204536	48		323-600-010	5010	9	33
323-510-086	208023A	7	3	323-561-211	204536	49		323-600-010	5010	11	26
323-510-087	208401	7	19	323-561-211	204536	49		323-600-012	1457	13	40
323-510-088	204865A	7	46	323-561-211	204536	50		323-600-012	1457	21	36
323-510-089	208568	13		323-561-211	204536	50		323-600-012	1457	29	18
323-510-097	208560	13	7	323-561-211	204536	51		323-600-013	5084	5	15
323-510-248	204223	7	7	323-561-211	204536	51		323-600-013	5084	11	13
323-515-004	204881	9	5	323-561-211	204536	52		323-600-013	5084	15	22
323-515-202	204060	15	28	323-561-211	204536	52		323-600-013	5084	15	30
323-515-203	204180	31	1	323-561-218	204042	48		323-600-013	5084	19	6
323-525-013	208346	15	1	323-561-218	204042	48		323-600-013	5084	19	19
323-525-013	208346	17	1	323-561-218	204042	49		323-600-013	5084	21	17
323-525-232	204100	23	1	323-561-218	204042	49		323-600-013	5084	23	3
323-525-234	204122	25	25	323-561-218	204042	50		323-600-013	5084	23	38
323-525-235	204145	27	1	323-561-218	204042	50		323-600-013	5084	25	6
323-525-236	204147	27	5	323-561-218	204042	51		323-600-013	5084	25	32
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323-530-010	204664	17	17	323-561-218	204042	52		323-600-014	4009-1	5	11
323-530-011	204755	23	44	323-561-218	204042	52		323-600-014	4009-1	7	2
323-530-016	204177B	29	35	323-561-219	204521	48		323-600-014	4009-1	7	8
323-530-018	204883	23	46	323-561-219	204521	48		323-600-014	4009-1	13	27
323-530-027	208281	27	7	323-561-219	204521	49		323-600-014	4009-1	21	29
323-530-028	208319	15	25	323-561-219	204521	49		323-600-014	4009-1	25	3
323-530-029	208313	29	19	323-561-219	204521	50		323-600-014	4009-1	27	20
323-530-031	208598	29	29	323-561-219	204521	50		323-600-015	5053	13	35
323-530-032	204890	45	20	323-561-219	204521	51		323-600-016	1229	37	14
323-530-100	193	37	38	323-561-219	204521	51		323-600-019	1175-3	17	21
323-530-226	204093	19	21	323-561-219	204521	52		323-600-019	1175-3	23	18
323-530-232	205072	37	21	323-561-219	204521	52		323-600-019	1175-3	25	50
323-533-005	245	43	17	323-561-220	204522	48		323-600-019	1175-3	37	31
323-534-001	204592	37	25	323-561-220	204522	48		323-600-020	1170-1	15	3
323-535-001	216	41	1	323-561-220	204522	49		323-600-020	1170-1	17	3
323-535-002	218	41	3	323-561-220	204522	49		323-600-020	1170-1	37	34
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323-535-025	204029	11	1	323-561-220	204522	51		323-600-022	2022-4	13	2
323-540-016	204751	25	1	323-561-220	204522	51		323-600-022	2022-4	15	5
323-540-017	204752	23	34	323-561-220	204522	52		323-600-022	2022-4	17	8
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323-540-029	208343	9	1	323-570-204	204187	31	11	323-600-026	2921	15	49
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323-600-046	1170-3	11	32	323-600-136	5381	21	12	323-600-326	5145	31	2
323-600-046	1170-3	13	15	323-600-136	5381	23	6	323-600-327	5237	3	9
323-600-048	1333	19	27	323-600-136	5381	23	40	323-600-328	5163	3	10
323-600-048	1333	29	7	323-600-136	5381	25	8	323-600-329	5179	3	18
323-600-056	2213-1	15	2	323-600-136	5381	25	20	323-600-331	204162	27	28
323-600-056	2213-1	17	2	323-600-136	5381	27	6	323-600-341	5292	13	6
323-600-057	5117	3	25	323-600-139	5437	21	19	323-600-341	5292	13	31
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323-600-057	5117	5	9	323-600-141	5271	29	2	323-600-341	5292	21	26
323-600-057	5117	9	22	323-600-142	208615	29	28	323-600-344	5315	9	2
323-600-057	5117	13	8	323-600-143	5242	35	2	323-600-347	5316	23	42
323-600-057	5117	27	23	323-600-200	1156	15	7	323-600-350	5326	37	10
323-600-057	5117	31	4	323-600-200	1156	17	5	323-600-351	5312	23	8
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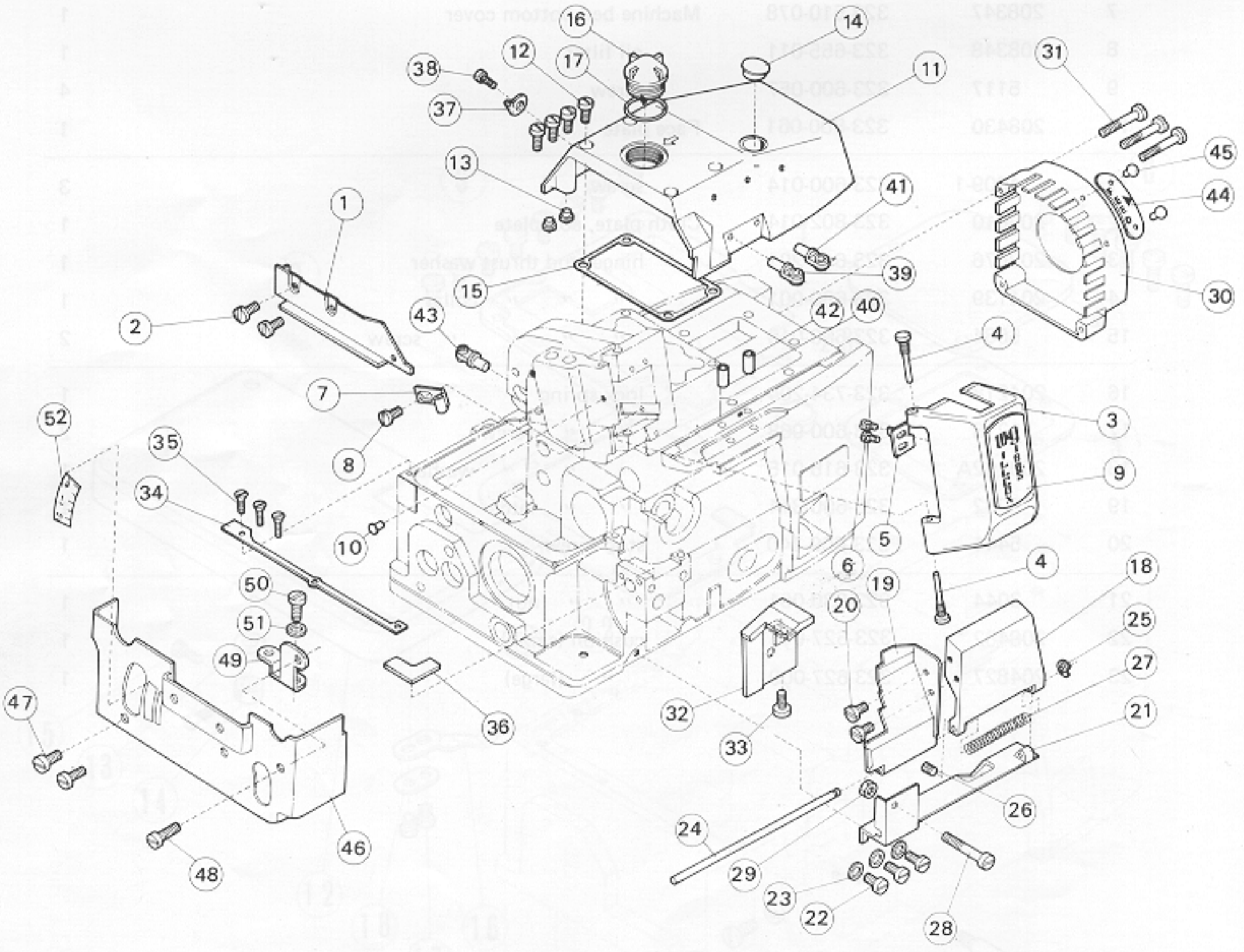
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131	323-886-001	43	15	1170-1	323-600-020	15	3	3044	323-630-001	37	41
132	323-659-200	43	2	1170-1	323-600-020	17	3	3044	323-630-001	45	9
133	323-945-002	43	1	1170-1	323-600-020	37	34	3056	323-630-015	21	20
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179	323-885-200	43	12	1175-2	323-600-002	25	48	4009-1	323-600-014	7	8
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196	323-640-100	37	47	1175-3	323-600-019	25	50	5010	323-600-010	9	33
197	323-505-100	37	48	1175-3	323-600-019	37	31	5010	323-600-010	11	26
198	323-665-001	37	52	1189	323-600-301	7	20	5012	323-600-255	11	19
199	323-732-002	37	53	1189	323-600-301	19	25	5012	323-600-255	35	7
200	323-880-005	43	14	1189	323-600-301	25		5019	323-600-247	39	11
216	323-535-001	41	1	1196	323-600-029	23	14	5022	323-600-251	7	35
217	323-600-118	41	2	1202	323-600-032	7	22	5029	323-600-256	11	21
218	323-535-002	41	3	1202	323-600-032	29	36	5029	323-600-256	25	23
219	323-740-035	41	4	1202	323-600-032	45	11	5029	323-600-256	29	32
220	323-740-036	41	6	1206	323-600-021	11	25	5030	323-600-202	29	11
221	323-600-119	41	7	1206	323-600-021	35	19	5053	323-600-015	13	35
222	323-630-018	41	8	1216	323-600-068	5	17	5060	323-600-004	27	11
223	323-620-024	41	9	1216	323-600-068	23	47	5060	323-600-004	31	12
224	323-615-028	41	10	1216	323-600-068	37	36	5064	323-600-025	37	5
225	323-617-001	41	11	1229	323-600-016	37	14	5077	323-600-307	21	32
226	323-630-019	41	12	1234	323-600-006	7	6	5078	323-600-001	3	6
227	323-685-013	41	13	1234	323-600-006	47	11	5080	323-600-008	9	28
228	323-850-031	41	14	1234	323-600-006	47	13	5081	323-600-009	9	29
229	323-740-034	41	15	1333	323-600-048	19	27	5082A	323-604-201	13	57
230	323-600-120	41	16	1333	323-600-048	29	7	5082A	323-604-201	15	44
230	323-600-120	41	19	1457	323-600-012	13	40	5082A	323-604-201	17	29
230	323-600-120	41	22	1457	323-600-012	21	36	5084	323-600-013	5	15
230	323-600-120	41	25	1457	323-600-012	29	18	5084	323-600-013	11	13
231	323-630-020	41	17	1458	323-600-037	31	10	5084	323-600-013	15	22
231	323-630-020	41	20	1459	323-600-034	45	21	5084	323-600-013	15	30
231	323-630-020	41	23	1732	323-600-075	13	42	5084	323-600-013	19	6
231	323-630-020	41	26	1998-2	323-600-024	15	36	5084	323-600-013	19	19
233	323-750-006	41	21	2022	323-600-043	3	3	5084	323-600-013	21	17
235	323-851-021	41	27	2022	323-600-043	9	12	5084	323-600-013	23	3
236	323-630-021	41	28	2022	323-600-043	13	3	5084	323-600-013	23	38
236	323-630-021	41	30	2022	323-600-043	31	14	5084	323-600-013	25	6
237	323-851-020	41	29	2022-4	323-600-022	13	2	5084	323-600-013	25	32
238	323-685-014	41		2022-4	323-600-022	15	5	5088	323-600-044	27	14
239	323-600-121	41	32	2022-4	323-600-022	17	8	5091	323-600-257	7	38
240	323-505-009	41	33	2022-4	323-600-022	29	20	5091	323-600-257	7	47
241	323-600-122	41	34	2133-1	323-600-215	25	36	5094	323-600-072	7	28
242	323-600-123	41	35	2133-1	323-600-215	29	16	5094	323-600-072	7	31
243	323-800-041	41	5	2193	323-600-271	15	11	5094	323-600-072	31	16
245	323-533-005	43	17	2193	323-600-271	17	12	5099	323-630-003	13	13
260	323-685-016	41	31	2193	323-600-271	37	17	5099	323-630-009	11	29
261	323-685-017	41		2193	323-600-271	45	4	5099	323-630-009	11	36
262	323-685-018	41		2213	323-600-237	37	8	5104	325-630-002	21	4
282	323-880-010	43	9	2213-1	323-600-056	15	2	5104	325-630-002	45	18
283	323-880-011	43	8	2213-1	323-600-056	17	2	5107	323-600-128	11	15
284	323-880-012	43	7	2902	323-600-259	7	50	5113	323-600-039	21	30
285	323-880-013	43	6	2902	323-600-259	15	47	5113	323-600-039	21	34
286	323-880-014	43	5	2902	323-600-259	17	32	5117	323-600-057	3	25
288	323-940-003	41		2905	323-600-074	15	52	5117	323-600-057	5	6
289	323-940-004	41		2913-2	323-600-316	29	44	5117	323-600-057	5	9
290	323-940-005	41		2918	323-600-073	11	28	5117	323-600-057	9	22
291	323-940-006	41		2921	323-600-026	15	49	5117	323-600-057	13	8
292	323-535-005	41	18	2921	323-600-026	29	13	5117	323-600-057	27	23
293	323-590-004	41	24	2922	323-600-229	21	9	5117	323-600-057	31	4
1156	323-600-200	15	7	2922	323-600-229	47	18	5117	323-600-057	31	20

(7) MISCELLANEOUS COVERS

DT.	DESCRIPTION	NEW PRODUCT CODE NO.	PART NO.	REF. NO.
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1	Bedplate	323-800-057	208317	1
1	Gasket	323-683-024	208422	2
8	Screw	323-800-014	6009-1	3
1	Bed cover plate (right)	323-800-058	208347	4
1	Gasket	323-683-023	208342	5
8	Screw	323-800-057	6117	6
1	Machine bottom cover	323-800-078	208347	7
1	Gasket	323-683-024	208348	8
1	Screw	323-800-014	6117	9
1	Gasket	323-683-023	208430	10



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5117	323-600-057	35	5	5315	323-600-344	9	2	201009	323-649-001	31	8
5117	323-600-057	35	16	5316	323-600-347	23	42	201037	323-642-001	13	47
5117	323-600-057	37	20	5317	323-600-355	25	34	201037	323-642-001	13	56
5117	323-600-057	37	22	5317	323-600-355	29	24	201048A	323-860-200	7	39
5117	323-600-057	43	24	5321A	323-600-083	23	51	201048A	323-860-200	7	41
5117	323-600-057	45	2	5326	323-600-350	37	10	201048A	323-860-200	7	43
5117	323-600-057	45	15	5332	323-600-359	3	2	201056	323-618-003	21	16
5117	323-600-057	47	20	5333	323-600-358	21	7	201056	323-618-003	25	5
5118	323-600-060	23	45	5336	323-600-116	23	24	201056	323-618-003	29	17
5118	323-600-060	23	49	5341	323-600-101	37	54	201068	323-642-002	13	48
5118	323-600-060	29	39	5346	323-600-366	25	46	201068	323-642-002	15	40
5118	323-600-060	35	3	5347	323-605-003	37	49	201072A	323-639-225	7	40
5118	323-600-060	37	43	5348	323-630-013	37	50	201072A	323-639-225	7	42
5136	323-600-245	19	5	5353	323-630-236	19	20	201074A	323-850-200	15	6
5136	323-600-245	29	9	5359	323-600-091	13	18	201074A	323-850-200	17	4
5137	323-630-202	7	29	5361	323-600-097	9	6	201086	323-642-003	17	25
5137	323-630-202	13	53	5366	323-600-124	23	27	201107	323-750-002	25	38
5137	323-630-202	37	11	5380	323-604-019	45	17	201117	323-618-006	11	12
5138B	323-600-354	33	18	5381	323-600-136	11	7	201121A	323-870-214	27	12
5141	323-600-087	25	24	5381	323-600-136	19	2	201121A	323-870-214	48	
5143A	323-604-235	13	52	5381	323-600-136	21	12	201121A	323-870-214	48	
5145	323-600-326	31	2	5381	323-600-136	23	6	201121A	323-870-214	49	
5146	323-600-264	7	26	5381	323-600-136	23	40	201121A	323-870-214	49	
5147	323-600-206	7	33	5381	323-600-136	25	8	201121A	323-870-214	50	
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5152	323-600-061	7	12	5385	323-600-127	19	13	201121A	323-870-214	51	
5163	323-600-328	3	10	5404	323-630-032	25	13	201121A	323-870-214	52	
5167	325-600-011	29	5	5412	323-600-134	23	30	201121A	323-870-214	52	
5179	323-600-329	3	18	5437	323-600-139	21	19	201139	323-680-001	5	14
5182	323-600-109	7	48	5439	323-605-008	39	4	201191	323-615-015	45	8
5183	323-600-100	37	40	5441	323-600-140	5	20	201233A	323-850-013	45	10
5184	323-600-079	45	7	9070-2	323-600-224	13	21	201293A	323-800-006	31	3
5205	323-600-359	25	40	137142	323-615-017	37	42	201294	323-764-001	31	5
5205	323-600-353	25	42	137142	323-615-017	37	44	201295	323-764-002	31	6
5227	323-600-303	11	16	137906	323-615-018	7	23	201308	323-873-001	29	6
5227	323-600-302	11	23	137906	323-615-018	37	37	201311	323-663-001	31	18
5227	323-600-302	37	2	167066	323-615-211	11	37	201323	323-600-062	33	4
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5232	323-600-314	5	19	167072	323-604-229	21	23	201360B	323-576-010	11	5
5232	323-600-314	29	37	167077	323-642-201	21	21	201395	323-640-228	29	34
5233	323-600-296	11	2	167079	323-860-211	7	37	201441B	323-576-011	11	6
5233	323-600-296	27	2	193174	323-851-217	17	33	201477	323-616-001	39	14
5234	323-600-297	11	4	200030	323-634-204	13	39	201482	323-613-001	13	50
5234	323-600-297	27	4	200041	323-850-221	13	19	201482	323-613-001	15	42
5237	323-600-327	3	9	200098	323-615-002	27	30	201482	323-613-001	17	27
5238	323-600-294	9	23	200136	323-636-200	33	10	201482	323-613-001	21	22
5239	323-630-304	15	18	200136	323-636-200	35	10	201485	323-740-012	45	6
5240	323-600-293	9	15	200136	323-636-200	35	21	201523A	323-671-001	9	16
5242	323-600-143	35	2	200137	323-604-222	35	9	201635	323-680-207	27	10
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5271	323-600-141	29	2	200138	323-615-209	33	14	202045	323-617-204	15	20
5276	323-600-088	37	26	200138	323-615-209	35	11	202058	323-615-213	37	27
5276	323-600-088	37	29	200138	323-615-209	35	23	202081	323-653-003	9	3
5284	323-600-306	17	18	200140	323-639-205	33	9	202176	323-653-005	13	37
5284	323-600-306	19	22	200152	323-604-209	33	2	202176	323-653-005	19	7
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5292	323-600-341	21	26	200205	323-640-203	13	20	202286	323-617-200	37	12
5297	323-630-228	39	15	200555	323-634-004	7	25	202286	323-617-200	37	18
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202522	323-634-200	23	43	204081	323-676-236	15	15	204252B	323-801-277	49	
202522	323-634-200	37	46	204081	323-676-236	19	11	204252B	323-801-277	51	
202526	323-692-201	3	26	204082A	323-525-239	21	1	204252B	323-801-277	51	
202527	323-870-207	48		204084	323-672-200	23	4	204259	323-639-012	35	17
202527	323-870-207	49		204084	323-672-200	21	10	204270	323-653-006	35	12
202527	323-870-207	50		204085	323-576-220	23	5	204270	323-653-006	35	25
202527A	323-870-005	27	13	204089	323-676-250	21	15	204274	323-653-209	15	27
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202527A	323-870-005	49		204095A	323-866-213	21	25	204278	323-810-215	48	
202527A	323-870-005	50		204096	323-850-246	21	27	204278	323-810-215	48	
202576	323-615-201	5	13	204097A	323-740-032	21	28	204278	323-810-215	49	
202645	323-629-201	29	30	204098	323-851-219	21	33	204278	323-810-215	49	
202647A	323-620-239	29	33	204099	323-851-220	21	35	204278	323-810-215	51	
202653	323-620-240	7	4	204100	323-525-232	23	1	204278	323-810-215	51	
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202683	323-716-209	47	19	204107	323-618-212	25	2	204278	323-810-215	52	
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202706A	323-866-214	13	23	204114	323-676-251	25	15	204293	323-616-200	19	23
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202769	323-615-219	39	6	204115	323-618-211	25	28	204294B	323-801-275	48	
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202875	323-615-216	15	50	204129A	323-676-261	25	35	204295B	323-801-278	48	
202903	323-627-208	33	5	204139A	323-502-213	23	39	204295B	323-801-278	48	
204003	323-882-201	3	14	204140A	323-730-214	23	41	204295B	323-801-278	49	
204006	323-620-242	3	20	204142B	323-800-036	23	48	204295B	323-801-278	49	
204010	323-671-200	9	4	204143A	323-891-200	23	50	204295B	323-801-278	51	
204014	323-676-243	9	11	204145	323-525-235	27	1	204295B	323-801-278	51	
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204019A	323-646-001	9	18	204149	323-676-239	27	8	204314A	323-810-217	48	
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204026	323-546-204	9	30	204158	323-640-219	27	21	204314A	323-810-217	51	
204029	323-535-205	11	1	204159	323-625-202	27	22	204314A	323-810-217	51	
204039B	323-801-276	48		204160A	323-850-247	27	24	204314A	323-810-217	51	
204039B	323-801-276	48		204161	323-870-213	27	26	204314A	323-810-217	52	
204039B	323-801-276	49		204161	323-870-213	43	19	204314A	323-810-217	52	
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204039B	323-801-276	51		204177B	323-530-016	29	35	204343A	323-801-255	48	
204042	323-561-218	48		204178	323-640-220	29	40	204343A	323-801-255	48	
204042	323-561-218	48		204180	323-515-203	31	1	204343A	323-801-255	49	
204042	323-561-218	49		204183	323-540-237	31	7	204343A	323-801-255	49	
204042	323-561-218	49		204184	323-540-236	31	9	204344A	323-801-256	48	
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204042	323-561-218	51		204186	323-570-203	31	13	204344A	323-801-256	49	
204042	323-561-218	51		204187	323-570-204	31	11	204345A	323-801-257	48	
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204054	323-676-235	25	4	204223	323-510-248	7	7	204354	323-620-251	23	11
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204060	323-515-202	15	28	204251	323-663-207	3	5	204358A	323-801-263	51	
204069A	323-540-228	15	9	204252B	323-801-277	48		204358A	323-801-263	51	
204069A	323-540-228	17	10	204252B	323-801-277	48		204359A	323-801-264	48	

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204359A	323-801-264	51		204381	323-801-290	50		204529	323-801-359	52	
204359A	323-801-264	51		204381	323-801-290	50		204529	323-801-359	52	
204360A	323-801-310	48		204408	323-830-267	52		204536	323-561-211	48	
204360A	323-801-310	48		204420	323-830-291	51		204536	323-561-211	48	
204360A	323-801-310	51		204421	323-830-245	52		204536	323-561-211	49	
204360A	323-801-310	51		204422	323-830-295	51		204536	323-561-211	49	
204361A	323-801-266	48		204423	323-830-297	52		204536	323-561-211	50	
204361A	323-801-266	48		204431	323-810-219	19		204536	323-561-211	50	
204361A	323-801-266	51		204431	323-810-219	48		204536	323-561-211	51	
204361A	323-801-266	51		204431	323-810-219	48		204536	323-561-211	51	
204362	323-801-267	48		204431	323-810-219	50		204536	323-561-211	52	
204362	323-801-267	48		204431	323-810-219	50		204536	323-561-211	52	
204362	323-801-267	49		204431	323-810-219	51		204585	323-615-021	37	51
204362	323-801-267	49		204431	323-810-219	51		204588	323-686-002	25	11
204363	323-801-268	48		204431	323-810-219	52		204592	323-534-001	37	25
204363	323-801-268	48		204431	323-819-219	52		204593	323-900-012	31	
204363	323-801-268	49		204435	323-635-013	35	18	204618	323-653-004	25	10
204363	323-801-268	49		204439A	323-610-033	25	33	204625A	323-676-025	13	32
204364	323-801-269	48		204449	323-850-256	45		204627A	323-676-263	13	33
204364	323-801-269	48		204450	323-692-256	7	9	204646	323-800-026	7	53
204364	323-801-269	49		204451	323-740-229	37	19	204649	323-891-002	7	44
204364	323-801-269	49		204451	323-740-229	45	1	204650A	323-510-030	7	30
204365	323-801-270	48		204452	323-740-228	45	3	204657	323-639-019	11	17
204365	323-801-270	49		204465	323-653-007	35	26	204664	323-530-010	17	17
204365	323-801-270	49		204466	323-653-008	35	27	204670	323-900-215	37	
204366	323-801-271	48		204495	323-800-235	37	16	204683	323-560-029	52	
204366	323-801-271	49		204499	323-820-290	47	2	204700	323-801-034	52	
204366	323-801-271	49		204500	323-820-291	47		204700	323-801-034	52	
204366	323-801-271	50		204501	323-820-292	47		204701	323-801-035	52	
204366	323-801-271	50		204502	323-820-293	47	3	204701	323-801-035	52	
204367	323-801-272	48		204503	323-820-294	47		204704	323-810-011	48	
204367	323-801-272	48		204504	323-820-295	47		204704	323-810-011	48	
204367	323-801-272	49		204505	323-820-296	47	4	204704	323-810-011	49	
204367	323-801-272	49		204506	323-820-297	47		204704	323-810-011	49	
204367	323-801-272	50		204507	323-820-298	47		204704	323-810-011	50	
204367	323-801-272	50		204508	323-820-264	47	5	204704	323-810-011	50	
204368	323-801-273	48		204509	323-820-265	47		204704	323-810-011	51	
204368	323-801-273	48		204510	323-820-266	47		204704	323-810-011	51	
204368	323-801-273	49		204511	323-820-268	47	6	204704	323-810-011	52	
204368	323-801-273	49		204512	323-820-269	47		204704	323-810-011	52	
204368	323-801-273	50		204513	323-820-270	47		204705	323-810-012	52	
204368	323-801-273	50		204514	323-820-277	47	7	204705	323-810-012	52	
204369	323-801-274	48		204515	323-820-278	47		204706	323-740-014	13	16
204369	323-801-274	48		204516	323-820-300	47		204707	323-851-005	13	22
204369	323-801-274	49		204517	323-576-225	21	11	204751	323-540-016	25	1
204369	323-801-274	49		204518	323-625-201	21	8	204752	323-540-017	23	34
204369	323-801-274	50		204520	323-615-233	9	10	204754	323-680-007	23	37
204369	323-801-274	50		204520	323-615-233	21	3	204755	323-530-011	23	44
204370	323-801-279	50		204521	323-561-219	48		204756	323-640-006	23	54
204370	323-801-279	50		204521	323-561-219	48		204757	323-600-102	23	55
204371	323-801-280	50		204521	323-561-219	49		204781	323-561-013	11	18
204371	323-801-280	50		204521	323-561-219	49		204782	323-561-014	11	20
204372	323-801-281	50		204521	323-561-219	50		204783	323-740-023	11	14
204372	323-801-281	50		204521	323-561-219	50		204789	323-618-010	9	8
204373	323-801-282	50		204521	323-561-219	51		204789	323-618-010	17	9
204373	323-801-282	50		204521	323-561-219	51		204794A	323-655-007	3	22
204374	323-801-283	50		204521	323-561-219	52		204806	323-615-029	33	21
204374	323-801-283	50		204521	323-561-219	52		204810	323-750-003	25	37
204375	323-801-284	50		204522	323-561-220	48		204827	323-627-009	5	23
204375	323-801-284	50		204522	323-561-220	48		204828	323-627-010	3	17
204376	323-801-285	50		204522	323-561-220	49		204835	323-870-004	47	24
204376	323-801-285	50		204522	323-561-220	49		204848A	323-560-051	7	1
204377	323-801-286	50		204522	323-561-220	50		204854	323-676-029	15	
204377	323-801-286	50		204522	323-561-220	50		204860	323-658-004	35	
204378	323-801-287	50		204522	323-561-220	51		204861	323-658-003	35	13
204378	323-801-287	50		204522	323-561-220	51		204862	323-510-035	35	14
204379	323-801-288	50		204522	323-561-220	52		204863	323-620-025	35	15
204379	323-801-288	50		204522	323-561-220	52		204865A	323-510-088	7	46
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204870	323-630-017	23	52	204938	323-801-053	51		208009	323-622-004	7	24
204872	323-628-002	7	45	204938	323-801-053	52		208010	323-640-015	7	27
204873	323-758-003	9	9	204938	323-801-053	52		208023A	323-510-086	7	3
204874	323-540-024	21	13	204939	323-801-054	51		208025	323-730-215	19	12
204875	323-676-038	21	14	204939	323-801-054	51		208026	323-620-030	19	14
204877	323-843-001	48		204939	323-801-054	52		208027	323-750-007	19	15
204877	323-843-001	48		204939	323-801-054	52		208028	323-618-214	19	17
204877	323-843-001	49		204940	323-801-055	51		208029	323-680-010	19	18
204877	323-843-001	49		204940	323-801-055	51		208062	323-830-068	49	
204877	323-843-001	50		204940	323-801-055	52		208063	323-830-069	48	
204877	323-843-001	50		204940	323-801-055	52		208064	323-830-070	50	
204877	323-843-001	51		204941	323-801-056	51		208064	323-830-070	51	
204877	323-843-001	51		204941	323-801-056	51		208064	323-830-070	52	
204877	323-843-001	52		204941	323-801-056	52		208065	323-830-071	48	
204877	323-843-001	52		204941	323-801-056	52		208066	323-830-072	49	
204878	323-843-002	48		204942	323-801-057	51		208067	323-830-073	50	
204878	323-843-002	48		204942	323-801-057	51		208070	323-830-076	50	
204878	323-843-002	49		204942	323-801-057	52		208074	323-830-080	51	
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204878	323-843-002	51		204943	323-801-058	52		208097	323-620-032	21	2
204878	323-843-002	51		204943	323-801-058	52		208102	323-851-022	15	26
204878	323-843-002	52		204944	323-801-059	51		208107A	323-850-050	25	41
204878	323-843-002	52		204944	323-801-059	51		208108	323-850-049	25	39
204879	323-843-003	48		204944	323-801-059	52		208109	323-560-046	25	44
204879	323-843-003	48		204944	323-801-059	52		208110	323-800-053	25	45
204879	323-843-003	50		204945	323-801-060	51		208168	323-663-019	25	43
204879	323-843-003	50		204945	323-801-060	51		208169A	323-663-021	3	13
204879	323-843-003	51		204945	323-801-060	52		208173	323-780-009	3	16
204879	323-843-003	51		204946	323-801-061	51		208173	323-780-009	15	31
204879	323-843-003	52		204946	323-801-061	51		208192	323-576-014	17	7
204879	323-843-003	52		204946	323-801-061	52		208193	323-576-013	19	1
204881	323-515-004	9	5	204946	323-801-061	52		208194	323-730-010	19	3
204883	323-530-018	23	46	204950	323-510-036	47	9	208195	323-620-033	19	4
204885	323-875-002	45	12	204960	323-642-004	47	16	208196	323-540-028	19	8
204886	323-750-010	45	13	204961	323-604-017	47	21	208207	323-787-005	23	10
204887	323-740-061	45	14	204962	323-630-025	47	17	208208	323-800-063	23	12
204888	323-618-019	45	16	204982	323-505-012	11	34	208209	323-800-064	23	13
204889	323-540-032	45	19	204988	323-561-018	11	27	208215	323-830-137	48	
204890	323-530-032	45	20	205064	323-875-200	37	1	208216	323-830-139	49	
204891	323-850-056	45	22	205065	323-640-225	37	3	208217	323-830-136	51	
204892	323-607-003	45	24	205066	323-615-227	37	4	208218	323-830-138	48	
204893	323-630-034	45	25	205067	323-540-246	37	6	208219	323-830-140	49	
204894	323-640-026	45	26	205068	323-680-210	37	7	208220	323-830-145	50	
204895	323-780-014	45	27	205069	323-750-204	37	9	208223	323-830-141	50	
204897	323-900-052	45		205070	323-625-203	37	13	208225	323-830-142	50	
204901	323-866-012	17	31	205072	323-530-232	37	21	208225	323-830-142	52	
204902	323-866-013	15	48	205088	323-627-014	3	15	208247	323-540-027	11	8
204905	323-851-018	15	51	205091	323-850-258	37	35	208248	323-676-042	11	9
204921	323-639-239	35	8	205103	323-685-243	37	30	208249	323-676-043	11	11
204921	323-639-239	35	20	205104	323-750-205	37	28	208250	323-626-002	11	10
204922	323-728-012	11	31	205216A	323-945-009	43	22	208258	323-620-041	15	21
204924	323-561-019	11	27	205217	323-600-117	43	23	208260	323-713-003	33	16
204925	323-615-032	11	30	205318	323-756-004	47	10	208271	323-680-011	9	25
204929	323-710-003	29	41	205319	323-850-032	47	14	208272	323-632-002	9	26
204930	323-676-039	29	42	205335	323-850-037	47	12	208273	323-716-011	25	18
204935	323-801-050	51		205466	323-945-001	39	1	208277	323-580-083	23	7
204935	323-801-050	51		205467	323-646-006	39	5	208281	323-530-027	27	7
204935	323-801-050	52		205468	323-774-002	39	9	208284	323-576-019	25	7
204935	323-801-050	52		205469	323-774-003	39	10	208285	323-620-035	25	12
204936	323-801-051	51		205470	323-740-062	39	7	208286	323-615-036	25	14
204936	323-801-051	51		205473	323-945-014	39	2	208289	323-800-056	3	23
204936	323-801-051	52		205495	323-620-040	11	3	208290	323-663-020	3	24
204936	323-801-051	52		205495	323-620-040	23	2	208292	323-676-048	15	13
204937	323-801-052	51		206336	325-630-004	39	3	208293	323-677-046	17	14
204937	323-801-052	51		206337	325-615-006	39	13	208294	323-676-045	23	35
204937	323-801-052	52		206457	323-656-003	7	16	208295	323-676-044	19	9
204937	323-801-052	52		208001	323-510-043	7	18	208296	323-800-058	15	23

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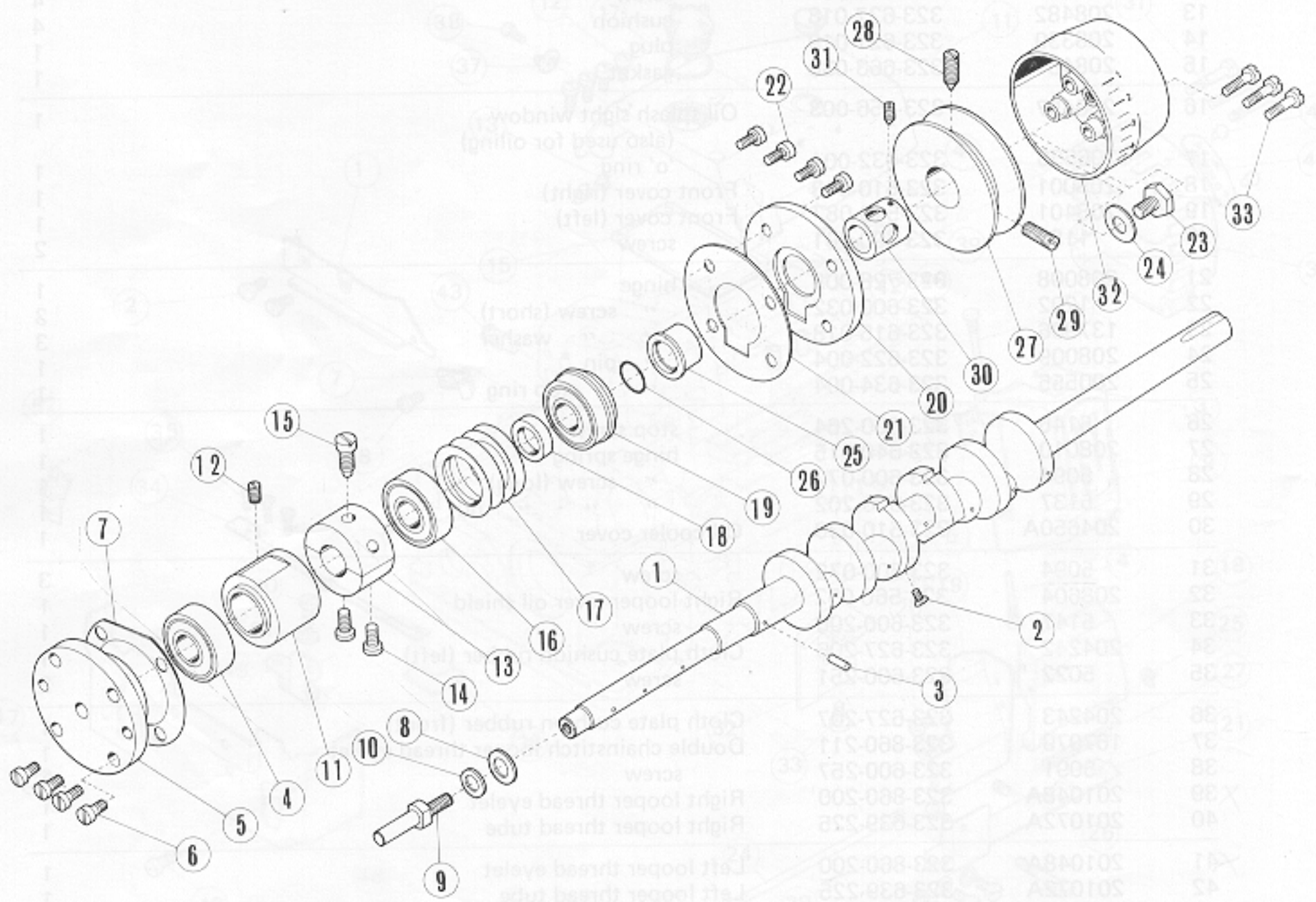
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208307	323-851-024	13	54	208501	323-820-038	48					
208308	323-658-005	35	1	208501	323-820-038	49					
208313	323-530-029	29	19	208501	323-820-038	50					
208314	323-620-036	29	21	208501	323-820-038	51					
208315	323-640-024	29	22	208502	323-820-039	48					
208316	323-604-018	29	43	208502	323-820-039	50					
208317	323-800-057	5	1	208502	323-820-039	51					
208318	323-663-023	33	17	208503	323-820-040	48					
208319	323-530-028	15	25	208503	323-820-040	49					
208320	323-780-011	9	32	208504	323-820-041	48					
208330	323-625-802	23	17	208504	323-820-041	49					
208339	323-627-019	7	14	208504	323-820-041	50					
208340	323-891-004	7	52	208506	323-820-033	52					
208341	323-800-055	5	4	208507	323-820-034	51					
208342	323-663-022	5	5	208507	323-820-034	52					
208343	323-540-029	9	1	208508	323-820-035	51					
208346	323-525-013	15	1	208508	323-820-035	52					
208346	323-525-013	17	1	208509	323-820-036	51					
208347	323-510-078	5	7	208509	323-820-036	52					
208348	323-655-011	5	8	208526	323-502-011	29	1				
208399	323-851-023	13	26	208529	323-640-022	29	12				
208401	323-510-087	7	19	208531	323-560-045	29	10				
208402	323-683-019	27	16	208531	323-560-045	48					
208403	323-750-011	47	26	208531	323-560-045	49					
208404	323-685-021	27	19	208531	323-560-045	50					
208406	323-692-033	3	21	208531	323-560-045	51					
208409	323-618-018	23	15	208532	323-560-054	51					
208410	323-716-013	23	19	208532	323-560-054	52					
208411	323-900-050	23		208534	323-540-031	29	14				
208415		23	22	208535	323-676-050	29	15				
208416	323-900-051	23		208537	323-592-001	29	25				
208419	323-680-012	21	18	208540	323-640-023	29	27				
208420	323-535-004	23	29	208549	323-620-042	29	4				
208421	323-640-021	23	31	208554	323-740-063	47	1				
208422	323-663-024	5	2	208560	323-510-097	13	7				
208424	323-576-017	13	1	208561	323-653-017	13	9				
208425	323-730-012	13	4	208562	323-653-018	13	10				
208427	323-683-018	13	14	208563	323-800-062	13	11				
208429	323-676-049	15	16	208568	323-510-089	13					
208430	323-800-061	5	10	208592	323-780-013	15	34				
208434	323-560-047	3	12	208597	323-676-052	15	33				
208445	323-866-016	15	46	208598	323-530-031	29	29				
208447	323-630-033	13	45	208599	323-676-053	29	31				
208447	323-630-033	15	38	208602	323-500-019	3	4				
208447	323-630-033	17	23	208603	323-500-020	3	8				
208448	323-676-047	13	46	208604	323-560-052	7	32				
208448	323-676-047	15	39	208610	323-802-014	5	12				
208448	323-676-047	17	24	208615	323-600-142	29	28				
208449	323-650-001	13	51	208616	323-560-053	13	34				
208449	323-650-001	15	43	208617	323-653-019	13	36				
208449	323-650-001	17	28	208621	323-780-012	13	38				
208450	323-780-010	13	49	208622	323-820-043	47	8				
208450	323-780-010	15	41								
208450	323-780-010	17	26								
208479	323-850-055	29	26								
208481	323-663-030	7	15								
208482	323-627-018	5	22								
208482	323-627-018	7	13								
208484	323-850-057	47	15								
208486	323-652-004	35	4								
208487	323-800-065	35	6								
208488	323-900-045	13	55								
208489	323-900-046	17	22								
208490	323-900-047	15	37								
208491	323-900-047	13	43								
208492	323-900-049	13	44								
208500	323-820-037	48									
208500	323-820-037	49									
208500	323-820-037	50									

(2) MISCELLANEOUS COVERS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	204848A	323-560-051	Cloth plate fabric guard	1
2	4009-1	323-600-014	screw	2
3	208023A	323-510-086	Needle bar cover	1
4	202653	323-620-240	hinge pin	1
5	202689	323-641-201	lock spring	1
6	1234	323-600-006	" " screw	2
7	204223	323-510-248	" " latch	1
8	4009-1	323-600-014	" " " screw	1
9	204450	323-692-256	name plate	1
10	198192	323-627-020	cushion rubber	1
11	208299	323-510-079	Top cover	1
12	5152	323-600-061	screw	4
13	208482	323-627-018	cushion	4
14	208339	323-627-019	plug	1
15	208481	323-663-030	gasket	1
16	206457	323-656-003	Oil splash sight window (also used for oiling)	1
17	206550	323-632-004	'o' ring	1
18	208001	323-510-043	Front cover (right)	1
19	208401	323-510-087	Front cover (left)	1
20	1189	323-600-301	screw	2
21	208008	323-728-008	hinge	1
22	1202	323-600-032	" screw (short)	3
23	137906	323-615-018	" " washer	3
24	208009	323-622-004	" pin	1
25	200555	323-634-004	" " stop ring	1
26	5146	323-600-264	stop screw	1
27	208010	323-640-015	hinge spring	1
28	5094	323-600-072	" screw (long)	1
29	5137	323-630-202	" " " nut	1
30	204650A	323-510-030	Oil cooler cover	1
31	5094	323-600-072	screw	3
32	208604	323-560-052	Right looper lever oil shield	1
33	5147	323-600-206	screw	1
34	204242	323-627-206	Cloth plate cushion rubber (left)	1
35	5022	323-600-251	screw	3
36	204243	323-627-207	Cloth plate cushion rubber (front)	1
37	167079	323-860-211	Double chainstitch looper thread eyelet	1
38	5091	323-600-257	screw	1
X39	201048A	323-860-200	Right looper thread eyelet	1
40	201072A	323-639-225	Right looper thread tube	1
X41	201048A	323-860-200	Left looper thread eyelet	1
42	201072A	323-639-225	Left looper thread tube	1
43	201048A	323-860-200	Double chainstitch looper thread eyelet	1
44	204649	323-891-002	Stitch indicator	1
45	204871	323-628-002	rivet	1
46	204865A	323-510-088	Machine cover (left)	1
47	5091	323-600-257	screw (short)	2
48	5182	323-600-109	" (long)	1
49	204868	323-646-004	spacer	1
50	2902	323-600-259	" screw	1
51	202286	323-617-200	" " washer	1
52	208340	323-891-004	Diff. feed ratio indication plate	1

(2) MISCELLANEOUS COVERS

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION
1	204818A	323-880-081	Cloth plate fabric guard
2	4009-1	323-800-014	screw
3	208023A	323-810-088	Needle bar cover
4	202883	323-820-240	hinge pin
5	202889	323-841-201	lock spring
6	1234	323-800-006	" " " " screw
7	204223	323-810-248	" " " " latch
8	4009-1	323-800-014	" " " " screw
8	204450	323-882-258	name plate
10	198182	323-827-820	cushion rubber
11	208299	323-810-079	Top cover (R)
12	8-52	323-800-081	screw
13	208182	323-800-076	brush
14	323-800-076	323-800-076	brush
15	323-800-076	323-800-076	brush
16	323-800-076	323-800-076	brush
17	323-800-076	323-800-076	brush
18	323-800-076	323-800-076	brush
19	323-800-076	323-800-076	brush
20	323-800-076	323-800-076	brush
21	323-800-076	323-800-076	brush
22	323-800-076	323-800-076	brush
23	323-800-076	323-800-076	brush
24	323-800-076	323-800-076	brush
25	323-800-076	323-800-076	brush
26	323-800-076	323-800-076	brush
27	323-800-076	323-800-076	brush
28	323-800-076	323-800-076	brush
29	323-800-076	323-800-076	brush
30	323-800-076	323-800-076	brush
31	323-800-076	323-800-076	brush
32	323-800-076	323-800-076	brush
33	323-800-076	323-800-076	brush
34	323-800-076	323-800-076	brush
35	323-800-076	323-800-076	brush
36	323-800-076	323-800-076	brush
37	323-800-076	323-800-076	brush
38	323-800-076	323-800-076	brush
39	323-800-076	323-800-076	brush
40	323-800-076	323-800-076	brush
41	323-800-076	323-800-076	brush
42	323-800-076	323-800-076	brush
43	323-800-076	323-800-076	brush
44	323-800-076	323-800-076	brush
45	323-800-076	323-800-076	brush
46	323-800-076	323-800-076	brush
47	8091	323-800-287	Machine cover (left) screw (short)
48	8182	323-800-108	" " (long)
49	204888	323-848-004	spacer
50	2802	323-800-259	" " " " screw
51	202288	323-817-200	" " " " washer
52	208240	323-881-004	Diff. feed ratio indication plate



CRANKSHAFT MECHANISM

REF. NO.	PART NO.	NEW PRODUCT CODE NO.	DESCRIPTION	QT.
1	208343	323-540-029	Crankshaft	1
2	5315	323-600-344	oil plug screw	1
3	202081	323-653-003	" wick	1
4	204010	323-671-200	ball bearing (left)	1
5	204881	323-515-004	" " " housing	1
6	5361	323-600-097	" " " " screw	4
7	204319	323-663-205	" " " " gasket	1
8	204789	323-618-010	" " " retaining ring	1
9	204873	323-758-003	extension	1
10	204520	323-615-233	" washer	1
11	204014	323-676-243	bushing	1
12	2022	323-600-043	" screw	1
13	204016	323-676-232	" (center)	1
14	1174	323-600-027	" " assembly screw	2
15	5240	323-600-293	" " screw	1
16	201523A	323-671-001	ball bearing (center)	1
17	204018	323-615-217	" " " washer	4
18	204019A	323-646-001	" " " spacer	1
19	204020A	323-671-002	" " (right)	1
20	204021	323-800-224	" " " plate	1
21	204022	323-626-202	" " " " gasket	1
22	5117	323-600-057	" " " " screw	4
23	5238	323-600-294	" " " screw	1
24	204023	323-615-221	" " " " washer	1
25	208271	323-680-011	oil seal collar	1
26	208272	323-632-002	" " " 'o' ring	1
27	204025	323-546-203	Machine pulley	1
28	5080	323-600-008	position screw	1
29	5081	323-600-009	screw	1
30	204026	323-546-204	collar	1
31	5267	323-600-295	" screw	1
32	208320	323-780-011	cap	1
33	5010	323-600-010	" screw	3
34	5013	323-600-013	" screw	2
35	5014	323-600-014	" screw	2
36	5015	323-600-015	" screw	1
37	5016	323-600-016	" screw	2
38	5017	323-600-017	" screw	2
39	5018	323-600-018	" screw	2
40	5019	323-600-019	" screw	2
41	5020	323-600-020	" screw	2
42	5021	323-600-021	" screw	2
43	5022	323-600-022	" screw	2
44	5023	323-600-023	" screw	2
45	5024	323-600-024	" screw	2
46	5025	323-600-025	" screw	2
47	5026	323-600-026	" screw	2
48	5027	323-600-027	" screw	2
49	5028	323-600-028	" screw	2
50	5029	323-600-029	" screw	2
51	5030	323-600-030	" screw	2
52	5031	323-600-031	" screw	2
53	5032	323-600-032	" screw	2
54	5033	323-600-033	" screw	2
55	5034	323-600-034	" screw	2
56	5035	323-600-035	" screw	2
57	5036	323-600-036	" screw	2
58	5037	323-600-037	" screw	2
59	5038	323-600-038	" screw	2
60	5039	323-600-039	" screw	2
61	5040	323-600-040	" screw	2
62	5041	323-600-041	" screw	2
63	5042	323-600-042	" screw	2
64	5043	323-600-043	" screw	2
65	5044	323-600-044	" screw	2
66	5045	323-600-045	" screw	2
67	5046	323-600-046	" screw	2
68	5047	323-600-047	" screw	2
69	5048	323-600-048	" screw	2
70	5049	323-600-049	" screw	2
71	5050	323-600-050	" screw	2
72	5051	323-600-051	" screw	2
73	5052	323-600-052	" screw	2
74	5053	323-600-053	" screw	2
75	5054	323-600-054	" screw	2
76	5055	323-600-055	" screw	2
77	5056	323-600-056	" screw	2
78	5057	323-600-057	" screw	2
79	5058	323-600-058	" screw	2
80	5059	323-600-059	" screw	2
81	5060	323-600-060	" screw	2
82	5061	323-600-061	" screw	2
83	5062	323-600-062	" screw	2
84	5063	323-600-063	" screw	2
85	5064	323-600-064	" screw	2
86	5065	323-600-065	" screw	2
87	5066	323-600-066	" screw	2
88	5067	323-600-067	" screw	2
89	5068	323-600-068	" screw	2
90	5069	323-600-069	" screw	2
91	5070	323-600-070	" screw	2
92	5071	323-600-071	" screw	2
93	5072	323-600-072	" screw	2
94	5073	323-600-073	" screw	2
95	5074	323-600-074	" screw	2
96	5075	323-600-075	" screw	2
97	5076	323-600-076	" screw	2
98	5077	323-600-077	" screw	2
99	5078	323-600-078	" screw	2
100	5079	323-600-079	" screw	2