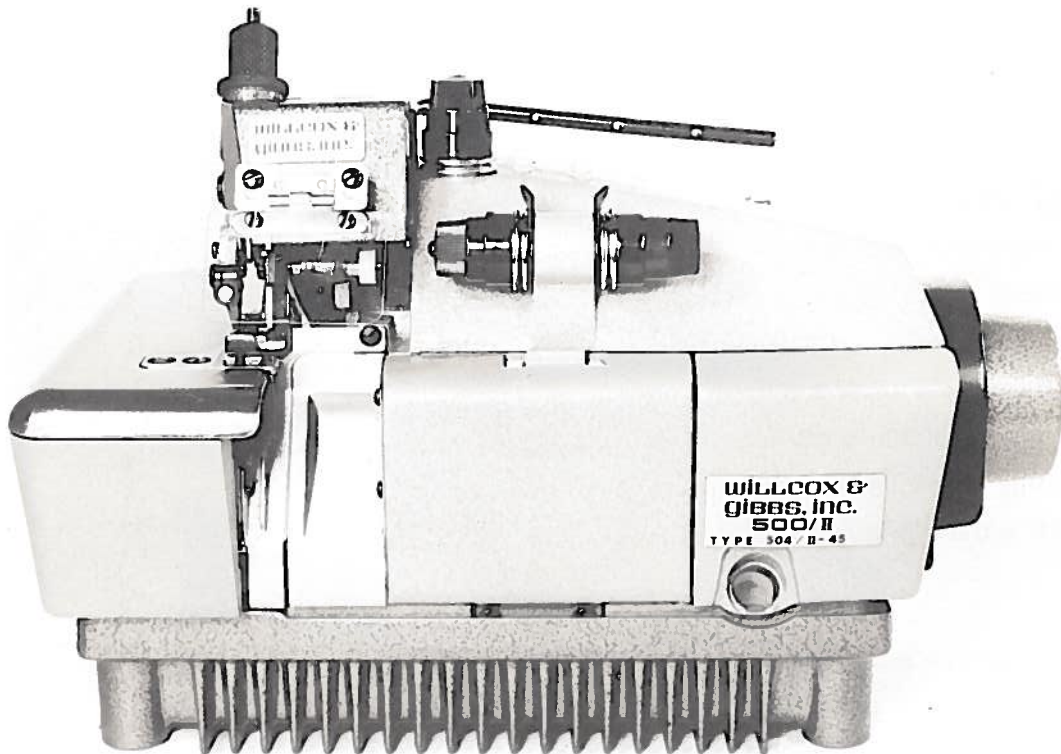


INSTRUCTION & PARTS CATALOG



WILLCOX & GIBBS 500/I & 500/II OVERLOCKS

wg
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OPERATORS' INSTRUCTION

INTRODUCTION

You are about to operate an overlock machine designed by the people who first introduced the overlock. In this machine you will find all the features to assist you, as the operator, to enjoy the easier handling and faster sewing that will help you increase your production. It is easy to thread, feeds smoothly, has automatic lubrication, and runs quietly. The Willcox & Gibbs class 500/I & II machines are the machines known as "THE OPERATOR'S FAVORITES".

HOW TO CLEAN YOUR MACHINE

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

DRIVING MOTOR, PULLEY AND BELTING

Table 1

It must be used with the motor and belting of the following specifications for individual use.

1. Driving motor of 3 phases, 2 poles and 400 watts (1/2HP) is recommended to this machine.
2. Motor speed is approximately 2,900 r.p.m. for 50 Hz or 3,500 r.p.m. for 60 Hz.
3. Belting used should be type M of V-belt.
4. The relation between machine speed and motor pulley diameter is determined by Table 1.

LUBRICATION

Table 2 Fig. 1, 2, 3

CAUTION: Oil was drained from the machine when shipped.
Refill with oil before operating.

The 500/I & II features fully automatic lubrication with a concealed forced air cooling system. Oil is pressurized by a pump to the internal surfaces of the connections.

A new machine should be run at least four weeks at a speed not to exceed 5,000 s.p.m.

At the end of four weeks, original oil should be drained out and replaced.

Operational speed after four weeks run-in may be 7,000 s.p.m.

Operational speed is depending upon operation being performed and ability of operator.

Life time of machine depends on quality oil used. For lubricant for 500/I & II, use oil as specified in Table 2.

Use recommended type oil only.

Changing oil

1. Remove the machine from its stand and set it on a table.
2. Remove drain plug ① and drain oil from the machine.
3. Replace drain plug ① and return the machine to its stand.
4. Remove filler plug ②.
5. Pour fresh oil into reservoir (700cc Capacity) using funnel supplied with accessories, until oil reaches upper line of gauge ③.
6. Replace filler plug ②.
7. Run machine and check oil circulation at oil splash sight window ④.
8. Oil level should be kept between two lines on gauge ③.
9. Change oil entirely every three months.

OIL SCREEN FILTER

Filter ⑧ should be always kept clean. Since lubrication oil is filtered by this and delivered to all frictional surfaces, clogging of this filter may cause lack of lubrication and accidental seizure of parts. Check and clean filter ⑧ every three months, or if necessary, replace with a new filter when:

Oil jet in window ④ is restricted or weak, or oil contained foam or debris.

Changing filter

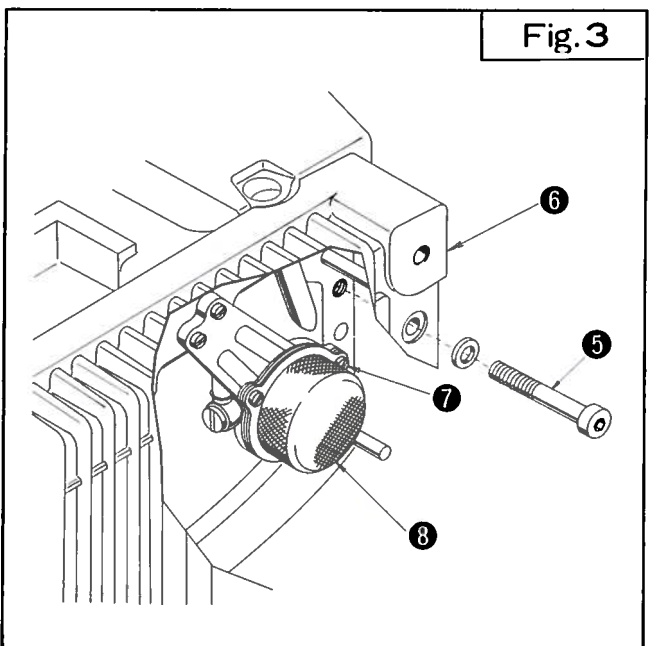
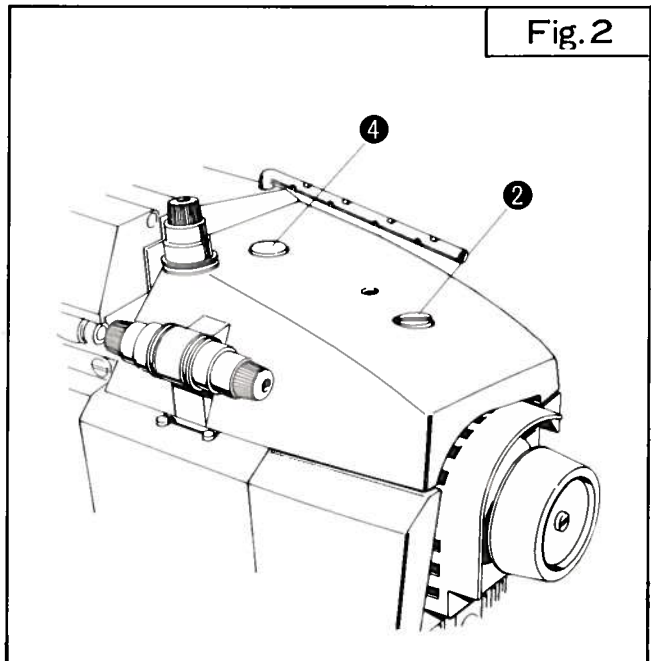
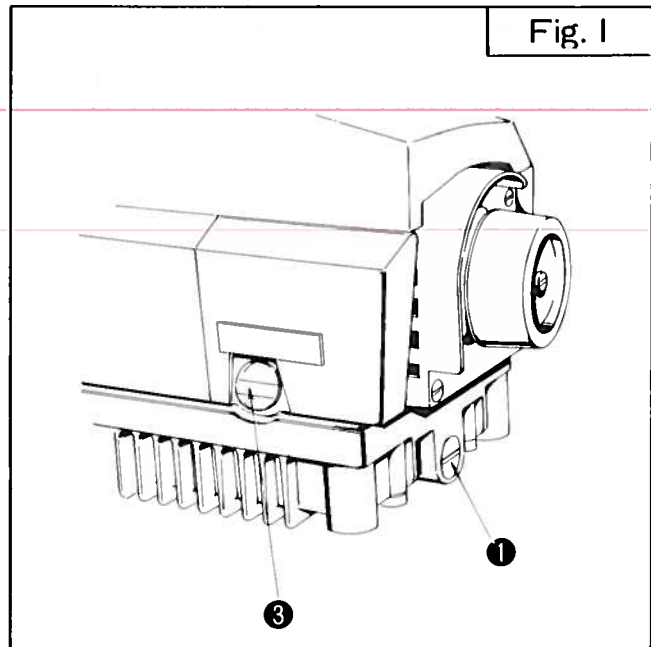
1. Drain oil from the machine.
2. Remove bolts ⑤ and oil pan ⑥.
3. Remove screws ⑦ and filter ⑧.
4. Clean filter ⑧ with petrol and blow it with low pressure air.
5. Replace filter ⑧ and tighten screws ⑦.
6. Replace oil pan ⑥ and tighten bolts ⑤.
7. Fill reservoir with oil on a level of upper line of gauge ③.

MACHINE SPEED (S.P.M.)	50 Hz MOTOR PULLEY DIAMETER		
	MM	INCHES	PULLEY SIZE in U.S.A.
4,600	95	3-3/4	636
5,000	105	4-1/8	641
5,300	110	4-3/8	643
5,500	115	4-1/2	644
5,800	120	4-3/4	646
6,000	125	4-7/8	647
6,300	130	5-1/8	651
6,700	140	5-1/2	654
7,000	145	5-3/4	656

MACHINE SPEED (S.P.M.)	60 Hz MOTOR PULLEY DIAMETER		
	MM	INCHES	PULLEY SIZE in U.S.A.
4,600	80	3-1/8	631
5,000	85	3-3/8	633
5,300	90	3-5/8	635
5,500	95	3-3/4	636
5,800	100	4	640
6,000	105	4-1/8	641
6,300	110	4-3/8	643
6,700	115	4-1/2	644
7,000	120	4-3/4	646

Table 1

Note 1: Machine pulley diameter is 60mm (2.36").
 Note 2: Motor pulley diameter should be measured in its outer diameter.



		Brand "A"	Brand "B"
Kinematic Viscosity (centistokes)	100° F	19.01	14.57
	210° F	4.04	3.57
Viscosity Index	VI (A)	130.0	147.5
	VI (B)	123.5	142.5
Pour Point (°F)		-59.0	-63.5
Load Carrying Capacity (kg/cm ²)		more than 12 (170 psi.)	more than 12 (170 psi.)

Table 2

THREADING YOUR MACHINE

Table 3, 4 Fig. 4, 5, 6, 7, 8, 9, 10

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

In case the machine requires a complete rethreading, refer to Threading Diagrams Fig. 4 to 10, Table 3 and 4.

500/I Fig. 4, 5, 6, 7, 8

Thread Federal stitch	Right needle	Left needle	Right looper	Left looper
503	T1	Non	Non	T4
504	T1	Non	T5	T6
512	T3	T2	T7	T8
514	T3	T2	T5	T6

Table 3

REGULATING THREAD TENSION

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

To increase tension – Turn nut clockwise.

To decrease tension – Turn nut anti-clockwise.

Tension on thread should be just enough to secure proper stitch formation.

Normally, you should have more tension on the needle threads and less tension on the looper threads.

500/II Fig. 4, 5, 9, 10

Thread Federal stitch	Right needle	Left needle	Right looper	Left looper
503	T1	Non	Non	T9
504	T1	Non	T10	T11
512	T3	T2	T10	T11
514	T3	T2	T10	T11

Table 4

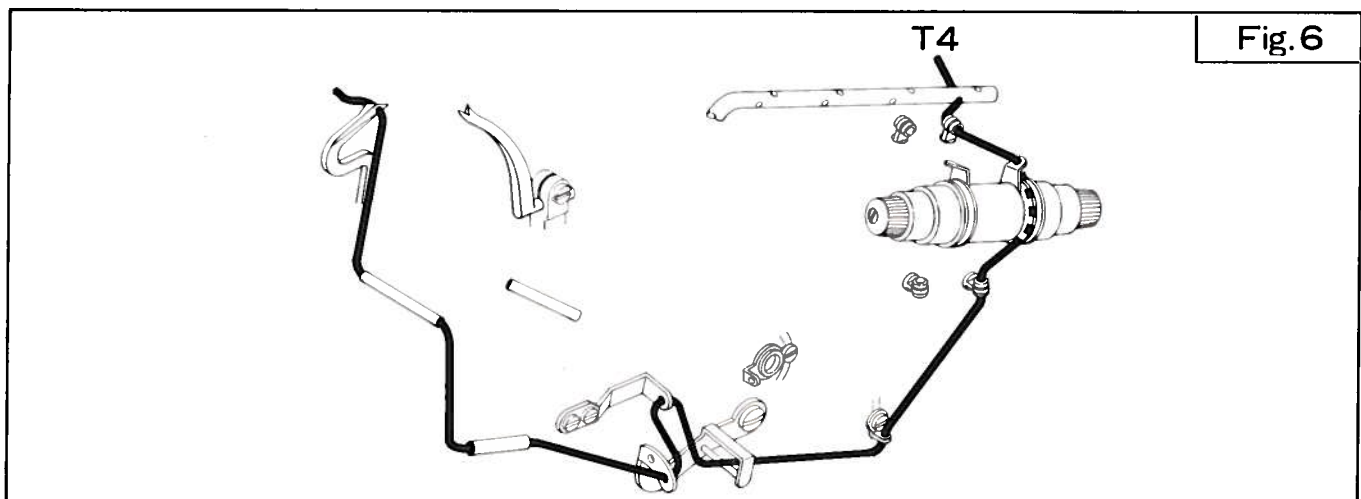
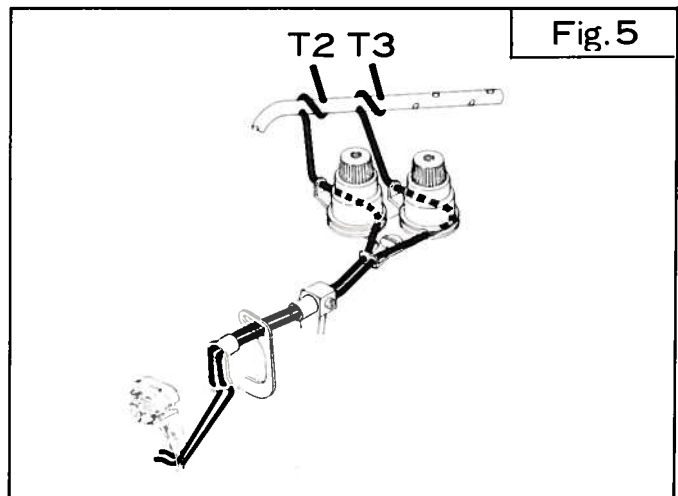
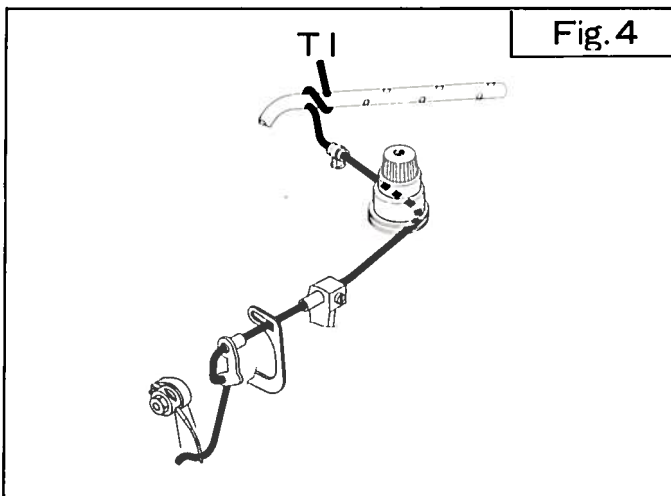


Fig. 7

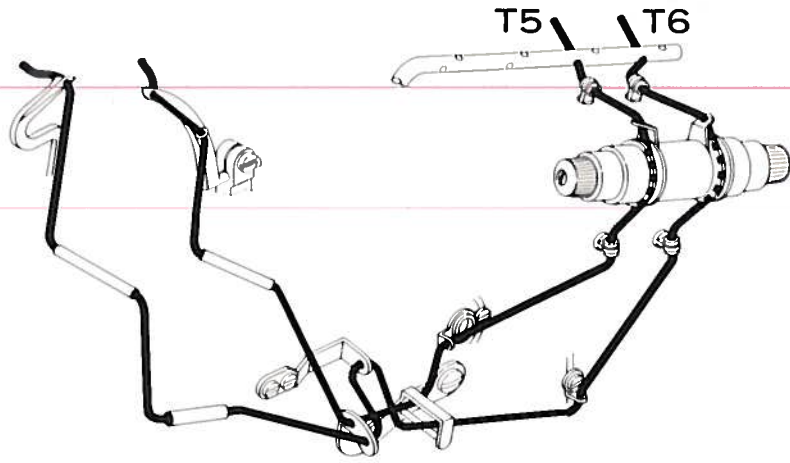


Fig. 8

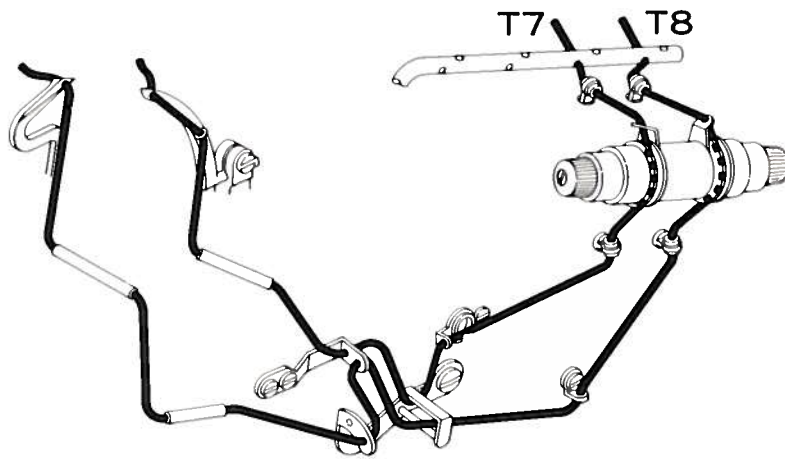


Fig. 9

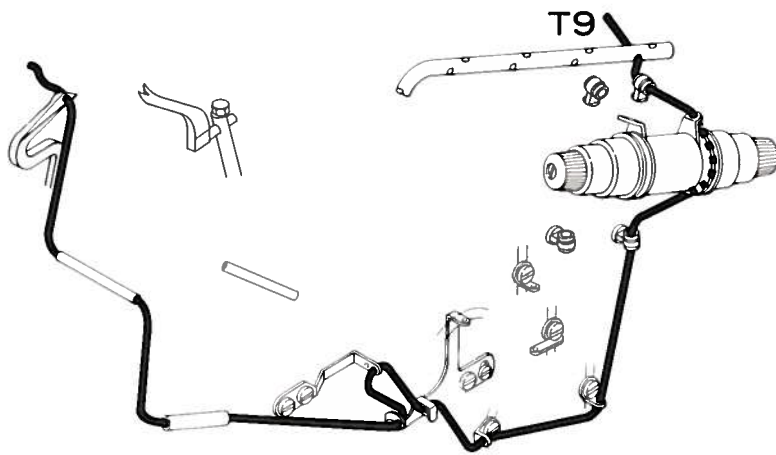
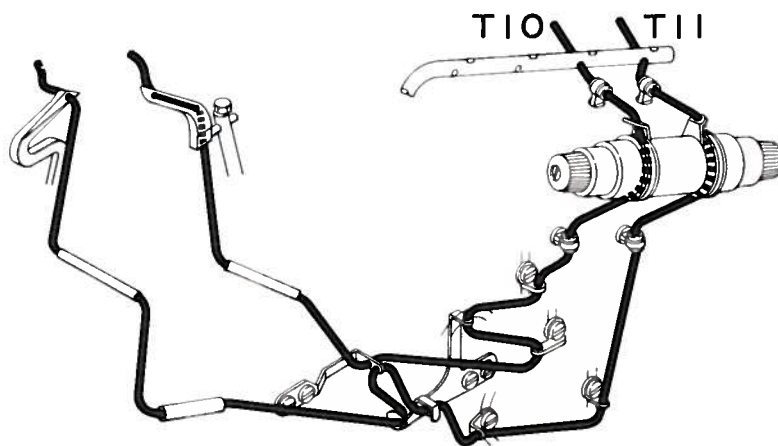


Fig. 10



PRESSURE OF PRESSER FOOT

Fig. 11

Pressure of presser foot is regulated by means of thumb screw ①. Pressure on presser foot should be just enough to feed material and obtain proper stitch formation. Too much pressure may spoil material and give it more stretch than it needs. Too little pressure may cause uneven feedings or stitches.

NEEDLES

Fig. 11, 12

Needles for 500/I & II series are specified in organization charts as shown in pages 60 to 68. Generally the size of needle should be determined by the size of thread or weight of material to be sewn.

Changing needles

1. Turn handwheel until needle drive arm ② is at its highest position.
2. Lift up lever ③ and swing presser arm ④ to the left.
3. Loosen nut ⑤ using socket wrench furnished with the machine and remove old needle.
4. Insert new needle in the groove ⑥ of clamp until needle rests against pin ⑦.
5. Tighten nut ⑤ securely.
6. Return arm ④ to the sewing position.
7. Make sure needle descends in the center of the needle hole in needle plate.
8. On two needle machine, be sure to keep shim ⑧ at the right position or between two needles.

REGULATING SEAM WIDTH

Fig. 11, 13

1. Lift up lever ③ and swing arm ④ to the left.
2. Turn handwheel until upper knife is at its lowest position.
3. Loosen screw ⑨. Pull thumb nut ⑩ to the left as far as it will go and lightly tighten screw ⑨.
4. Loosen screw ⑪ and move holder ⑫ to the right or left until the desired width is obtained, then tighten screw ⑪.
5. Loosen screw ⑨, then holder ⑬ will return to position by spring action.
6. Tighten screw ⑨.
7. Return arm ④ to the sewing position.

CAUTION: When seam width is changed to extremely wide or narrow, to replace needle plate for larger or narrower seam width is recommended.

See organization charts as shown in pages 60 to 68.

REPLACING THE UPPER AND LOWER KNIVES

Fig. 11, 13, 14, 15

UPPER KNIFE

1. Lift up lever ③ and swing arm ④ to the left.
2. Loosen screw ⑨. Pull nut ⑩ to the left as far as it will go and lightly tighten screw ⑨.
3. Remove screw ⑭ with socket wrench or screwdriver furnished with the machine.
4. Withdraw knife ⑮ downward.
5. Replace with new knife but do not tighten screw ⑭ completely.
6. Turn handwheel until upper knife is at its lowest position. Set upper knife so that its cutting edge overlaps lower knife by 0.5-1.0mm (.020-.039") as shown in Fig. 14.
7. Retighten screw ⑭ securely.
8. Loosen screw ⑨, then holder ⑬ will return to position by spring action.
9. Tighten screw ⑨.
10. Return arm ④ to the sewing position.

LOWER KNIFE

1. Lift up lever ③ and swing arm ④ to the left.
2. Loosen screw ⑨ and pull nut ⑩ to the left as far as it will go and lightly tighten screw ⑨.
3. Loosen nut ⑩ and withdraw knife downward.
4. Insert new knife into the groove of clamp stud, setting the blade so that the cutting edge is level with the top of needle plate as shown in Fig. 14.
5. Tighten nut ⑩ securely.
6. Loosen screw ⑨, then holder ⑬ will return to position by spring action.
7. Tighten screw ⑨.
8. Return arm ④ to the sewing position.

Knives must be kept sharp. Lower knife may be sharpened by use of a grinder while making sure that the correct angle is maintained as shown in Fig. 15. Upper knife may be sent to our distributors or return to us for resharpening since it is made from a special tungsten carbide alloy material, and must be sharpened by a diamond grinder.

Fig. 11

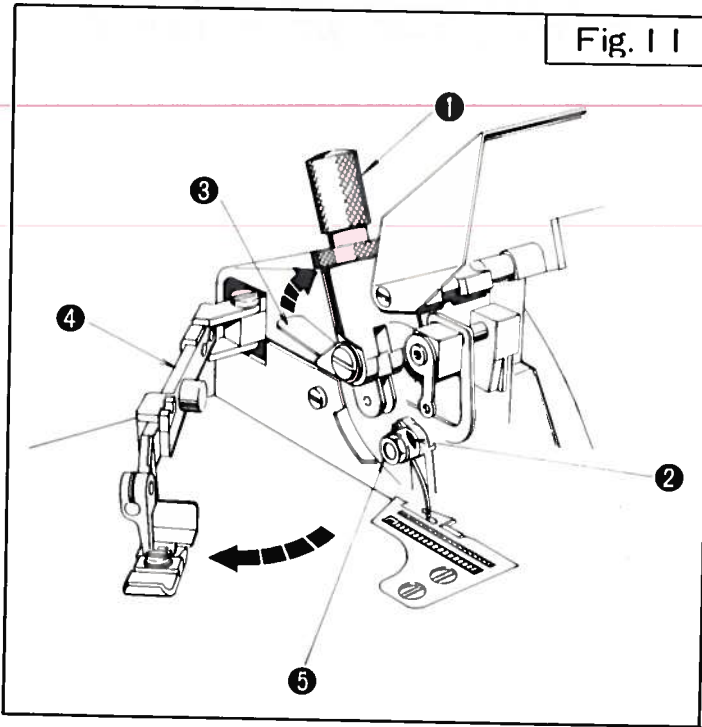


Fig. 14

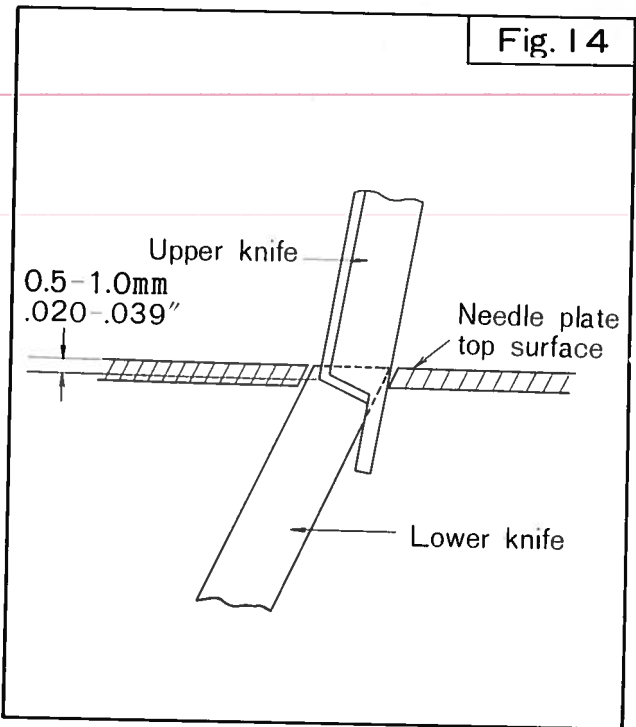


Fig. 12

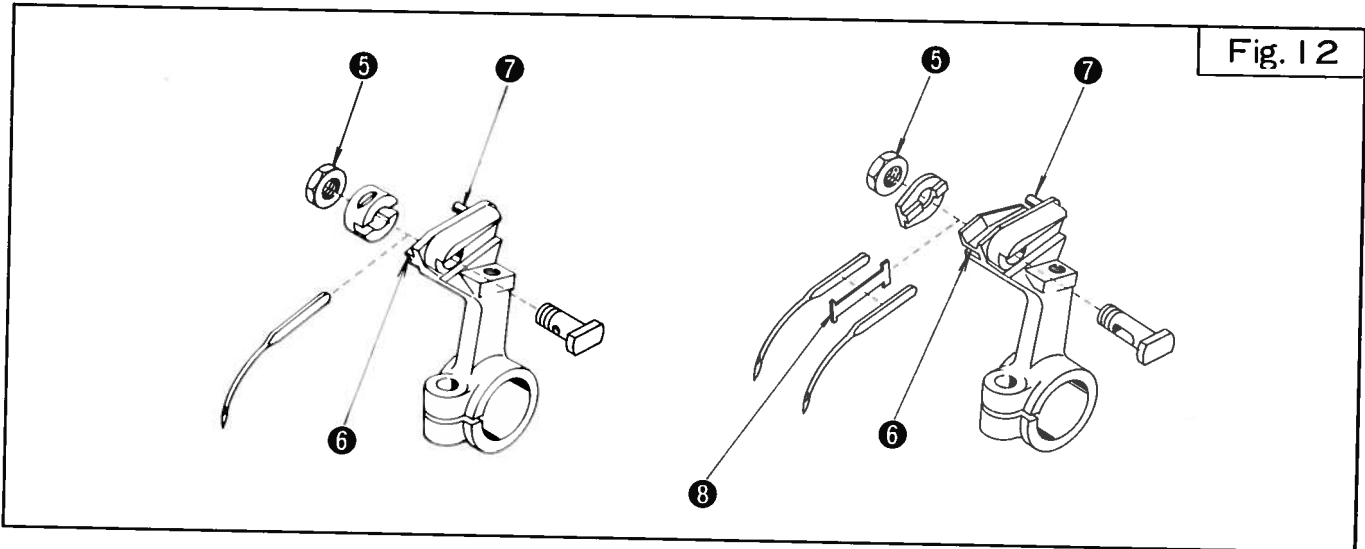


Fig. 13

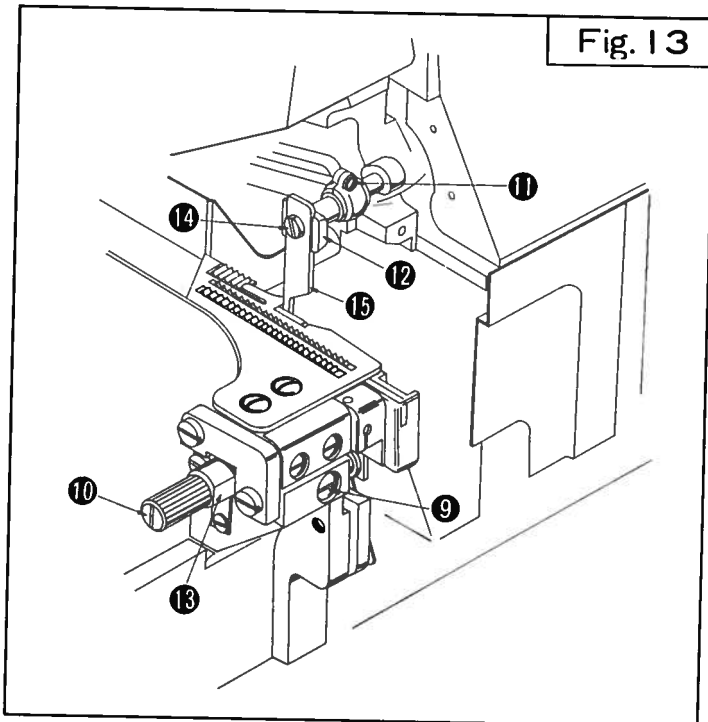
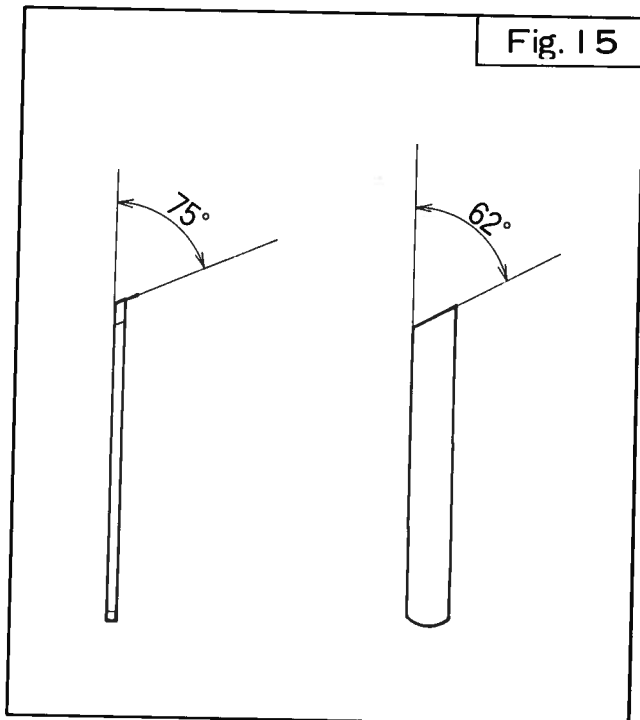


Fig. 15



REGULATING STITCH LENGTH

Fig. 16

Stitch length is determined by the combination of main and differential feed eccentrics to be used.

Outer eccentric ⑤ actuates main feed.
Inner eccentric ⑥ actuates differential feed.

The number stamped on feed eccentric indicates the number of stitches per inch.
However, the stitches made may vary more or less depending upon the material.

Selecting eccentric

When the stamped number of differential feed eccentric (e.g. #8) is smaller than that of main feed eccentric (e.g. #12), material will tend to shrink in stitching.

When the stamped number of differential feed eccentric (e.g. #16) is larger than that of main feed eccentric (e.g. #12), material will tend to stretch in stitching.

Changing eccentric

1. Swing presser arm, cloth plate and feed mechanism cover to the left.
2. Remove nut ① and washer ② from crankshaft ③.
3. Screw extractor, furnished with the machine, into screw hole ④ of main feed eccentric ⑤ and take it out.
4. Screw extractor into screw hole of differential feed eccentric ⑥ and take it out.
5. Be sure to eccentrics and mating parts are clean. Clean eccentrics in oil to remove all dirt and dust deposits before placing in the machine.
6. Face the extruded portion outward (leftward) and insert differential feed eccentric ⑥ on the crankshaft ③ mating the eccentric groove with the crankshaft key. Use extractor.
7. Face the extruded portion inward (rightward) and insert main feed eccentric ⑤ in the crankshaft ③ mating the groove with the key. Use extractor.
8. Replace washer ② and nut ①.
9. Tighten nut ① securely.
10. Replace covers and return arm to the sewing position.

Feed eccentrics supplied in the machine and in the accessories are listed in the organization charts. Additional eccentrics may be ordered separately.

SETTING THE WELT GUIDE

Fig. 17

Welt guide, equipped with models 503/I-25 and 503/II-25, is designed for blindstitch welting or hemming.

1. Set base ⑦ on the machine with screw ⑧.
2. Loosen screw ⑨.
3. Move guide ⑩ by turning screw ⑪ until guide ⑩ is correctly positioned.
4. Tighten screw ⑨ securely.

SETTING THE EDGE GUIDE

Fig. 18

Edge guide, equipped with models 503/I-4, 503/I-8, 503/II-4 and 503/II-8, is designed for regulating the width of material to be trimmed or for edge guide when the machine is operated without trimmer.

1. Set holder ⑫ on the machine with screws ⑬.
2. Loosen screw ⑭.
3. Move guide ⑮ to the right or left until proper position is obtained.
4. Tighten screw ⑭ securely.

Fig. 16

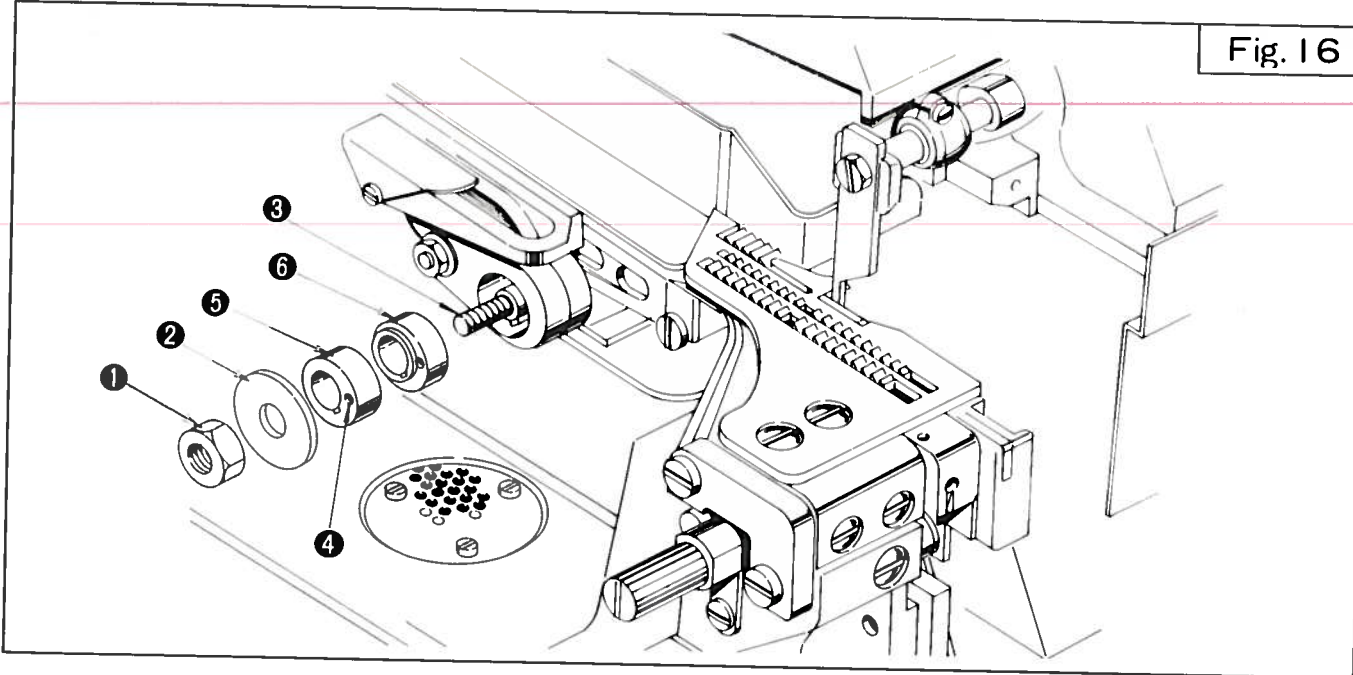


Fig. 17

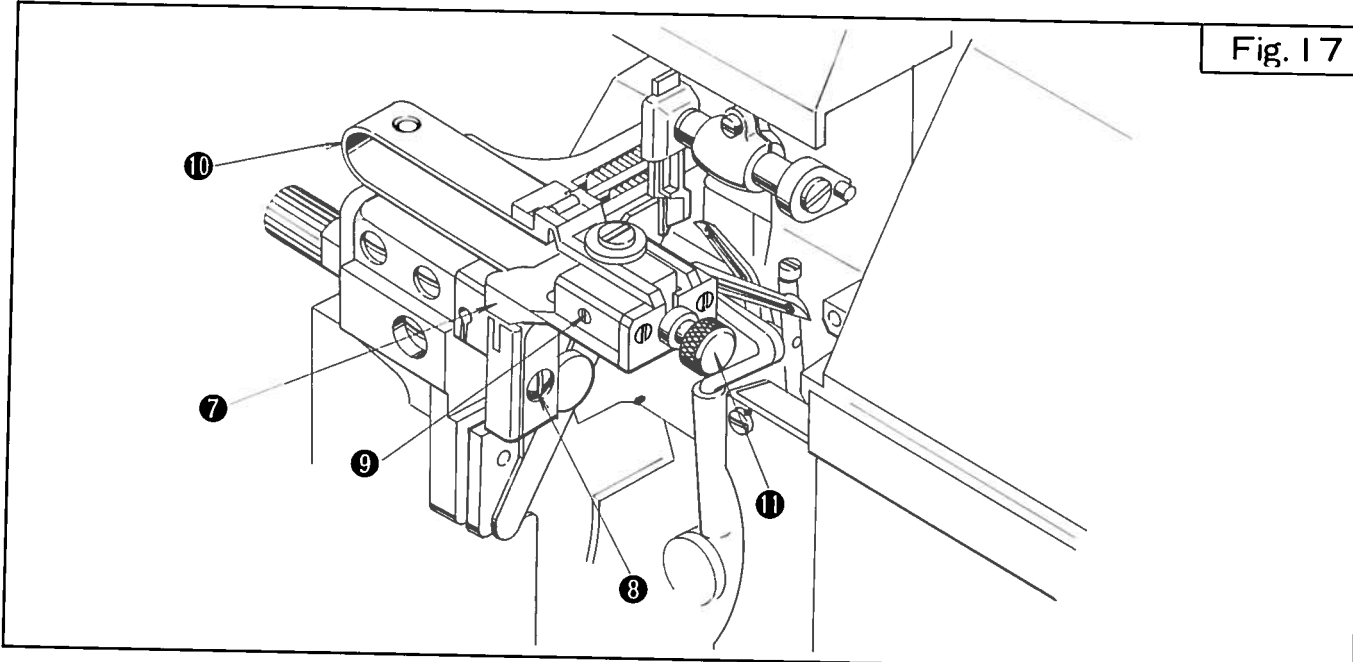
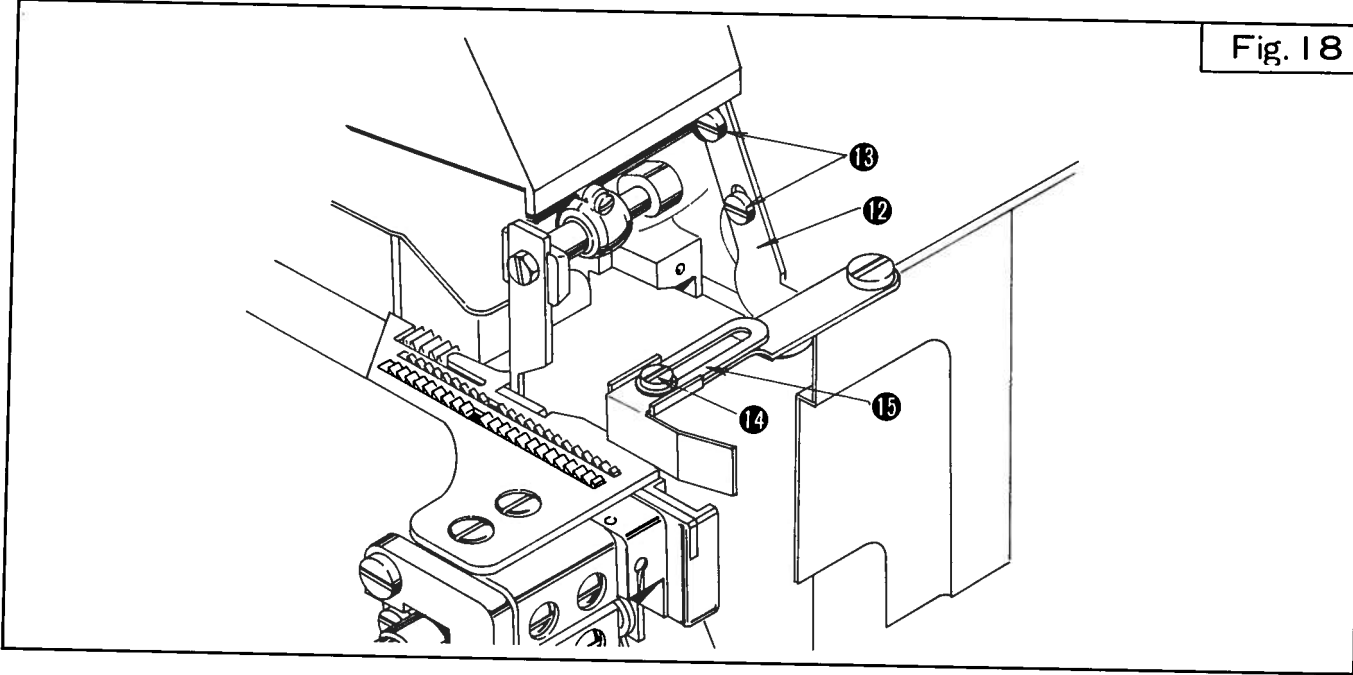


Fig. 18



MECHANICS' INSTRUCTION

ALIGNMENT OF NEEDLE PLATE TO FEED Fig. 19, 20, 21

Generally feeds should be in position as shown in Fig. 19. Each row of main and differential feeds rests in the center of each slot of needle plate. In case of models 503/I-25 and 503/II-25, differential feed evenly and slightly touches needle plate at its right side ①. If this setting is incorrect, reset as follows.

1. Release pressure on foot and swing out foot to the left.
2. Loosen screw ② and move upper knife to the right.
3. Loosen screw ③ and move lower knife to the right.
4. Loosen screws ④ and ⑤.
5. Check the groove of needle plate is on needle plate key and move plate to touch evenly at point ①.
6. Tighten screws ⑤ and ④.
7. Replace both knives into position.
8. Make sure needle descends in the center of the needle hole in needle plate.

FEED ADJUSTMENT Fig. 22, 23, 24

Standard height of main feed is 0.8-1.2mm (1/32-3/64") above the surface of needle plate at its rearend tooth when feeds are at their highest position as shown in Fig. 22.

A straight edge can be placed across the top of the main and differential feeds.

Standard height of auxiliary feed is 0.5mm (.020") above needle plate.

Replacing feeds

1. Turn handwheel until feeds are at their highest position.
2. Release pressure on foot and swing out foot to the left.
3. Swing out cloth plate to the left.
4. Loosen screw ⑥ and remove tube ⑦.
5. Remove screws ⑧ and feeds ⑨.
6. Replace with new feeds and set feeds by raising or lowering feeds until proper height is obtained, then tighten screws ⑧.
7. Replace tube ⑦ and tighten screw ⑥.
8. Return cloth plate and foot to the sewing position.

Feed dogs have generally been preset at the factory with a front to back tilt when feeds are at their highest position as shown in Fig. 22.

Tilting feeds

1. Turn handwheel until feeds are at their highest position.
2. Release pressure on foot and swing out foot to the left.
3. Swing out cloth plate to the left.
4. Loosen screw ⑩ and turn screw ⑪ with a screwdriver until proper tilt is obtained.
5. Tighten screw ⑩.
6. Return cloth plate and foot to the sewing position.

Woven material — Set feeds level.

Knit material — Tilt feeds higher in the front than the rear.

ADJUSTING NEEDLE ARM HEIGHT Table 5 Fig. 21, 25, 26, 27

Turn handwheel until needle is at its highest position. Use timing gauge, check the clearance between the point of needle and the top of needle plate as specified in Table 5.

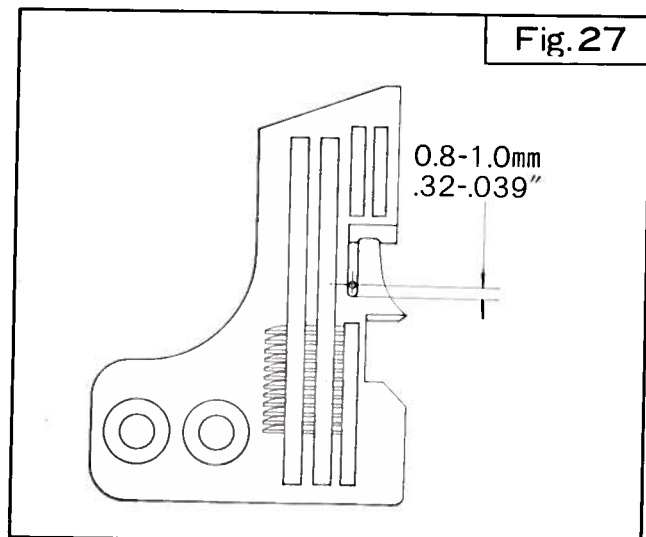
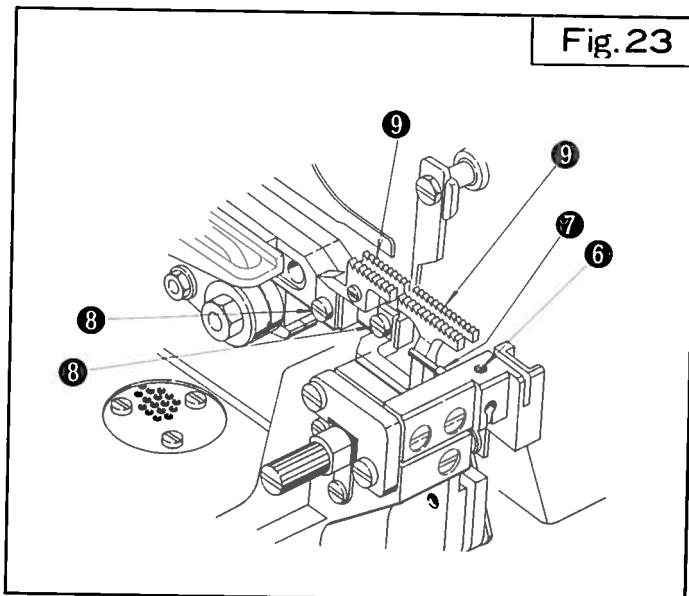
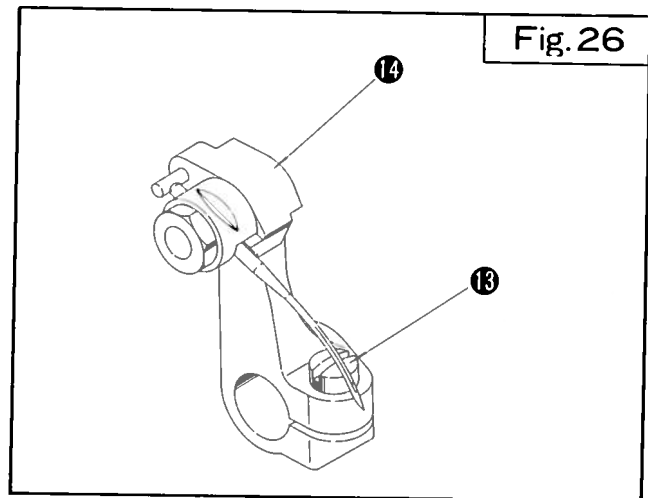
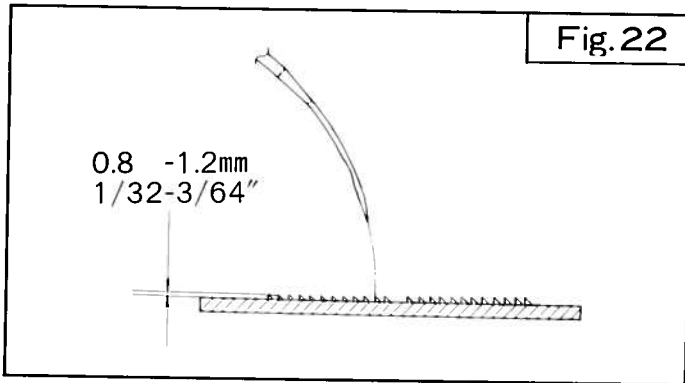
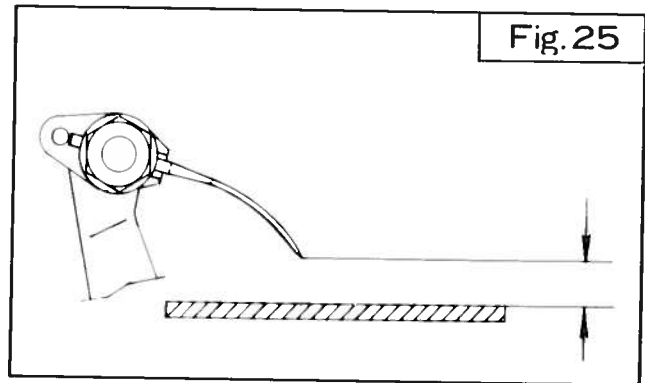
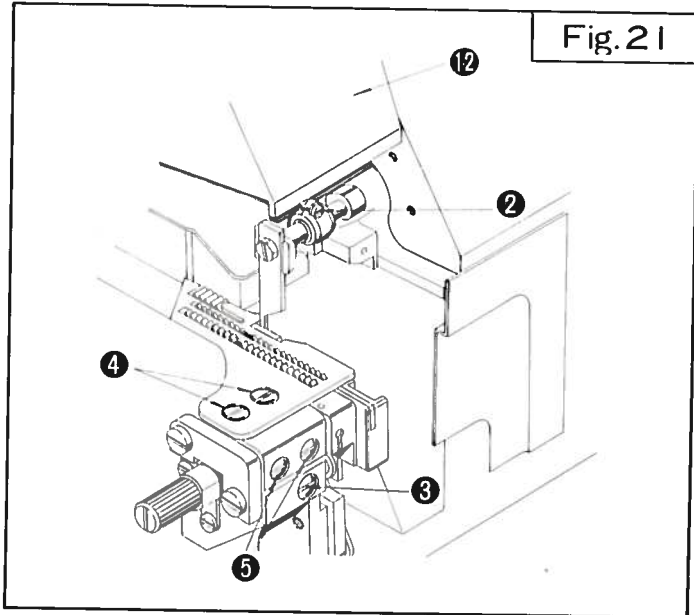
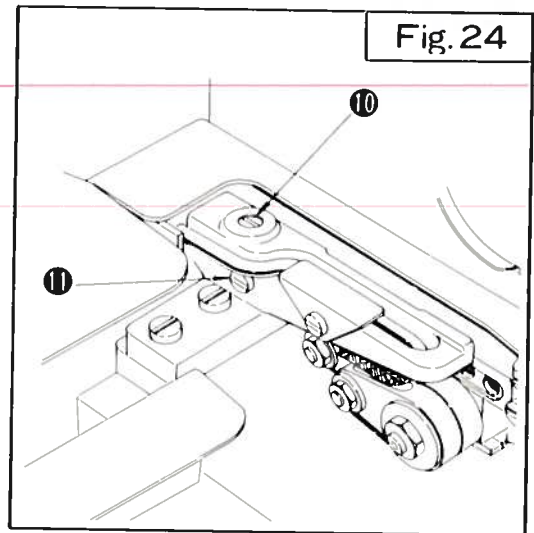
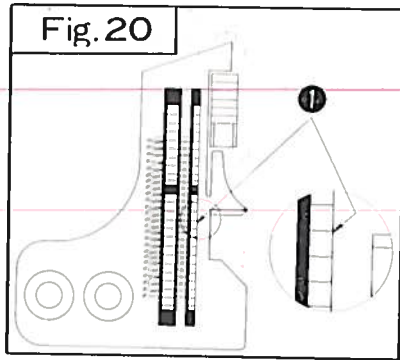
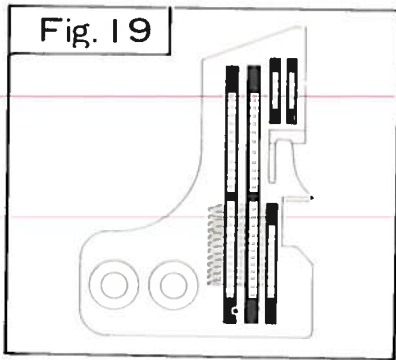
1. Release pressure on foot and swing out foot to the left.
2. Push up cover ⑫.
3. Slightly loosen screw ⑬.
4. Move arm ⑭ to right or left until needle descends in the center of the needle hole in needle plate.
5. Reset arm ⑭ to correct clearance as listed below at its highest position.
6. Tighten screw ⑬ securely.
7. Return cover ⑫ and foot to the sewing position.

At this time, with arm ⑭ down, check to see that there is clearance between the front edge of the needle hole in needle plate and needle as shown in Fig. 27.

If clearance is insufficient, loosen screws ④ and move needle plate back and forth until correct clearance is obtained.

MODEL	CLEARANCE	
	MM	INCH
500/I	9.8	.386
500/II	10.3	.406

Table 5



LEFT LOOPER ADJUSTMENT

Table 6 Fig. 28, 29, 30, 31

1. Release pressure on foot and swing out foot to the left.
2. Swing out cloth plate to the left and open front cover.
3. Remove needle plate.
4. Remove needle guards as instructed on this page.
5. Remove feeds as instructed on page 12.
6. Turn handwheel until looper lever ❶ is in the extremely left position.
7. Loosen screw ❷ and remove looper.
8. Insert new looper into lever ❶ and push down until base of looper shank reaches shaft ❸ and tighten screw ❷.
9. Loosen screw ❹ with wrench and adjust point of looper from centerline of needle to correct clearance as listed below and lightly tighten screw ❹.

On the two needle machine, set point of looper from centerline of left needle to correct clearance as shown in Fig. 29.

10. Turn handwheel until looper point is in the centerline of needle.
11. Move lever ❶ back and forth along its shaft ❸ so that the looper point just touches needle, then tighten screw ❹.
12. The point of looper should be in the scarf of needle as shown in Fig. 30.
13. Recheck clearance and tighten screw ❹ securely.
14. Replace feeds as instructed on page 12.
15. Replace needle guards as instructed on this page.
16. Replace needle plate.
17. Return cloth plate, front cover and foot to the sewing position.

Note: Left looper has a 2.3mm (3/32") offset when viewed from above looper lever in the machine.

Looper is self setting as shown in Fig. 31.

FEDERAL STITCH	MODEL	GAUGE	CLEARANCE	
			MM	INCH
503	503/I, II		5.3	.209
504	504/I, II		5.3	.209
512	514/I, II	2.0	5.3	.209
		3.0	4.3	.169
514	514/I, II	2.0	5.3	.209

Table 6

ADJUSTING NEEDLE GUARDS

Fig. 32

Machines are fitted with front and rear needle guards. Set rear guard ❶ first.

1. Release pressure on foot and swing out foot to the left.
2. Swing out cloth plate to the left.
3. Remove needle plate.
4. Remove feeds as instructed on page 12.
5. Loosen screw ❷ and remove guard ❸.

REAR NEEDLE GUARD

6. Loosen screw ❸ and remove rear guard ❶.
7. Replace with new guard ❶ and lightly tighten screw ❸.
8. Turn handwheel until the point of left looper is opposite to the centerline of needle.
9. Adjust guard ❶ back and forth until it just touches needle without deflecting needle point.
10. Tighten screw ❸ securely.

FRONT NEEDLE GUARD

11. Replace with new guard ❷.
12. Adjust guard ❷ until there is a space of 0.1-0.2mm (.004-.008") between needle and guard ❷.
13. Tighten screw ❹ securely.
14. Recheck setting after tightening screws ❹ and ❸.
15. Replace feeds as instructed on page 12.
16. Replace needle plate.
17. Return cloth plate and foot to the sewing position.

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

Fig.28

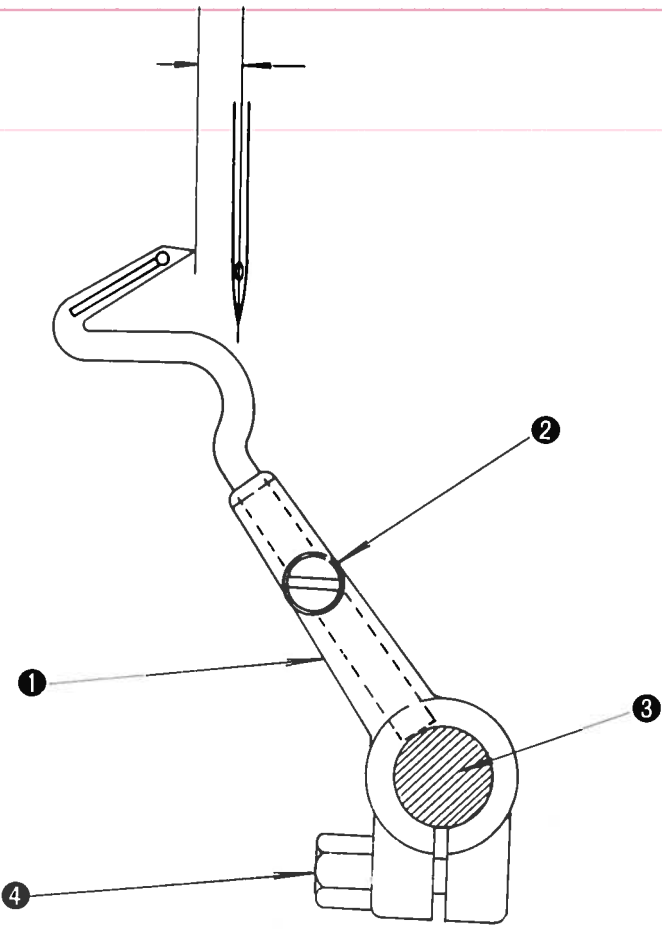


Fig.30



Fig.31

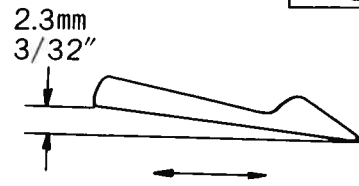


Fig.29

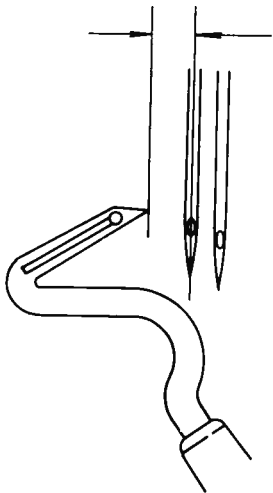
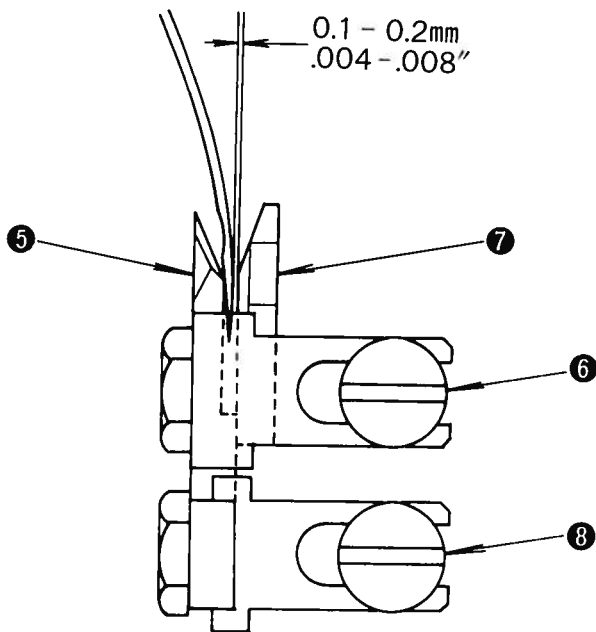


Fig.32



RIGHT LOOPER ADJUSTMENT

Table 7, 8 Fig. 33 – 43

500/I

1. Release pressure on foot and swing out foot to the left.
2. Swing out cloth plate to the left.
3. Open front cover and remove looper thread plate.
4. Remove needle plate.
5. Remove feeds as instructed on page 12.
6. Turn handwheel until connection ① is at its lowest position.
7. Loosen screw ② and adjust the clearance from the back edge of looper to the face of looper lever ③ to 3mm (1/8").
8. Tighten screw ② lightly.
9. Turn handwheel until looper is at its extremely left position.
10. Loosen screws ④ and ⑤.
11. Slightly loosen screw ⑥ and adjust looper eye or spreader (bottom of V groove) from centerline of needle to correct clearance as listed below by moving connection ① downward or upward.
12. Make sure it is correct, then tighten screw ⑥ lightly.
13. Turn handwheel slowly and observe that when both loopers pass they should be as close as possible without touching as shown in Fig. 35 and 36.
14. If right looper strikes left looper, move connection ① downward. Move right looper to the left until correct clearance is obtained as listed below. Turn handwheel and observe that both loopers pass as shown in Fig. 35.
15. If clearance is too much, move connection ① upward. Move right looper to the right until correct clearance is obtained as listed below. Turn handwheel and observe that both loopers pass as shown in Fig. 35.
16. Tighten screw ⑥, and tighten screws ④ and ⑤ alternately.
17. Rotate looper in its lever ③ and adjust right looper so that both loopers pass as shown in Fig. 36.
18. Retighten screw ② securely.
19. Looper should not strike needle when passing as shown in Fig. 37.
On the two needle machine, adjust looper so that upper portion of the back of looper just touches the right needle in its movement to the right as shown in Fig. 38.
20. Replace feeds as instructed on page 12.
21. Replace needle plate.
22. Replace looper thread plate and close front cover.
23. Return cloth plate and foot to the sewing position.

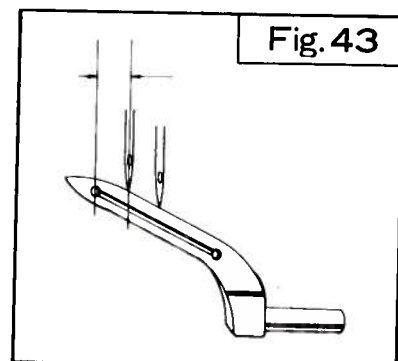
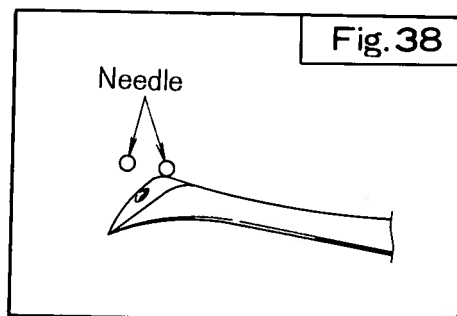
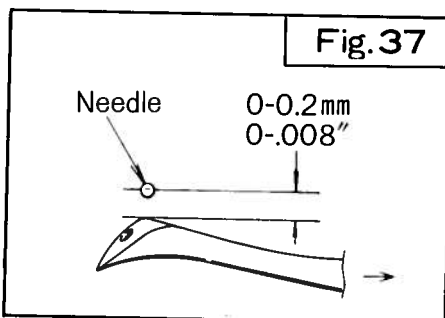
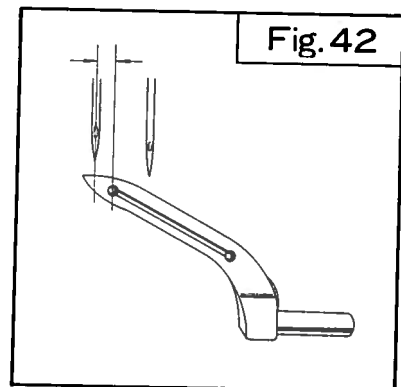
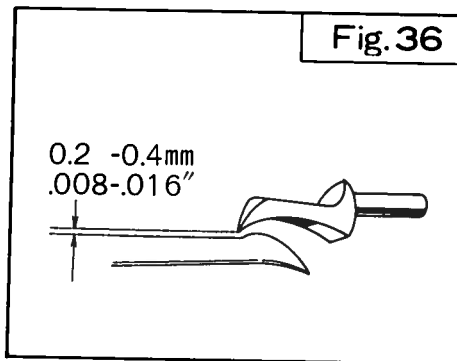
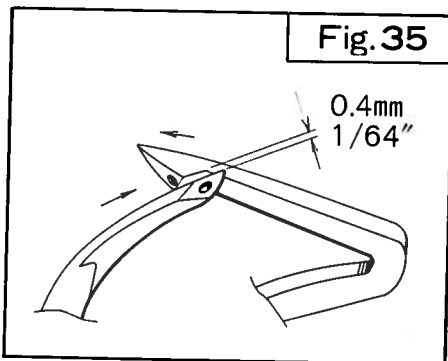
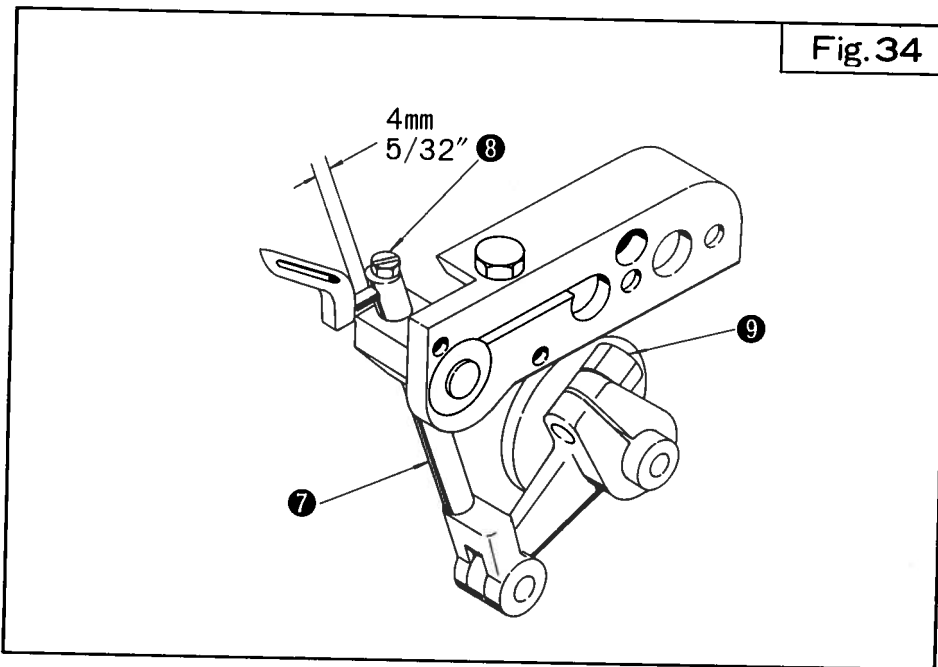
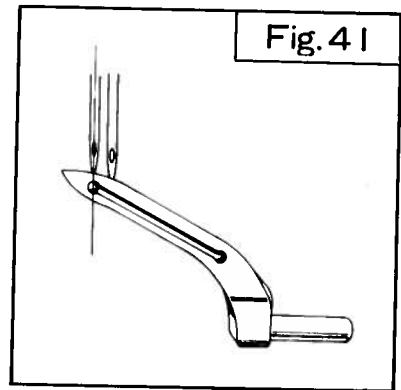
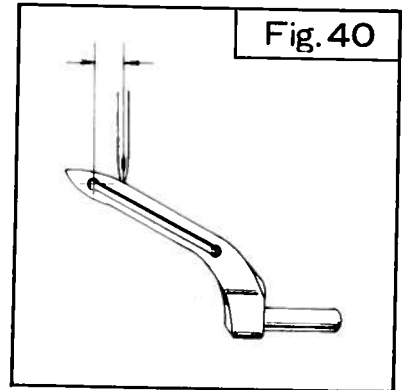
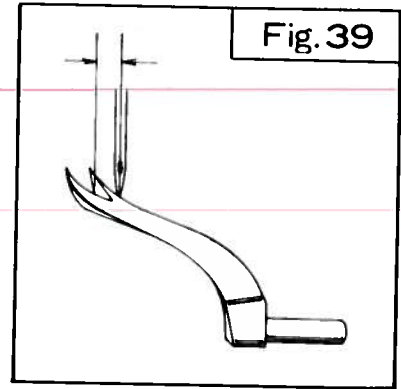
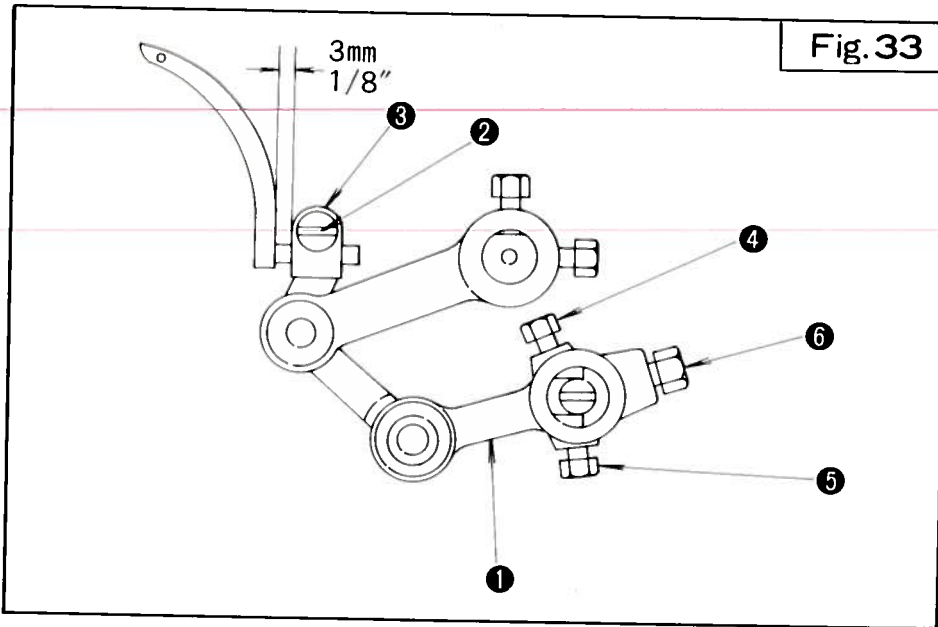
FEDERAL STITCH	MODEL	GAUGE	CLEARANCE		FIG.
			MM	INCH	
503	503/I, II		3.0	.118	39
504	504/I, II		3.0	.118	40
512	514/I, II	2.0	0	0	41
		3.0	-1.0	-.039	42
514	514/I, II		3.0	.118	43

Table 7

500/II

1. Release pressure on foot and swing out foot to the left.
2. Swing out cloth plate to the left.
3. Open front cover and remove looper thread plate.
4. Remove needle plate.
5. Remove feeds as instructed on page 12.
6. Turn handwheel until looper lever ⑦ is at its lowest position.
7. Loosen screw ⑧ and adjust the clearance from the back edge of looper to the left side of lever ⑦ to 4mm (5/32").
8. Tighten screw ⑧ lightly.
9. Turn handwheel until looper is at its extremely left position.
10. Slightly loosen screw ⑨.
11. Adjust looper eye or spreader (bottom of V groove) from centerline of needle to correct clearance as listed below by moving lever ⑦ downward or upward.
12. Make sure it is correct, then tighten screw ⑨ lightly.
13. Turn handwheel slowly and observe that when both loopers pass they should be as close as possible without touching as shown in Fig. 35 and 36.
14. If right looper strikes left looper, move lever ⑦ downward. Move right looper to the left until correct clearance is obtained as listed below. Turn handwheel and observe that both loopers pass as shown in Fig. 35.
15. If clearance is too much, move lever ⑦ upward. Move right looper to the right until correct clearance is obtained as listed below. Turn handwheel and observe that both loopers pass as shown in Fig. 35.
16. Tighten screw ⑨ securely.
17. Rotate looper in its holder and adjust right looper so that both loopers pass as shown in Fig. 36.
18. Retighten screw ⑧ securely.
19. Looper should not strike needle when passing as shown in Fig. 37.
On the two needle machine, adjust looper so that upper portion of the back of looper just touches the right needle in its movement to the right as shown in Fig. 38.
20. Replace feeds as instructed on page 12.
21. Replace needle plate.
22. Replace looper thread plate and close front cover.
23. Return cloth plate and foot to the sewing position.

Note: Various right loopers are provided as listed on page 18 for use with various size needles. For ease of identification some loopers have been marked with a looper marking.



PRESSER ARM ALIGNMENT

Fig. 44, 45, 46

Presser arm must be aligned correctly front to back and right to left to insure lifting without a bind and alignment of the needle hole in foot with the needle hole in needle plate.

Front to back alignment

1. With foot attached to arm, loosen screws ① and ②.
2. Adjust arm back and forth while lifting to insure there is no bind in bar ③.
3. Tighten screw ②.
4. Position regulator ④ against connection ⑤.
5. Tighten screw ①.

Once set do not loosen screw ②.

Right to left alignment

1. Loosen screws ⑥ and ⑦.
2. Shift bracket ⑧ and guide ⑨ to the right or left until the needle hole in foot and the needle hole in needle plate are aligned.
3. Check bar ③ is on guide ⑨ properly and presser arm is straight.
4. Tighten screws ⑥ and ⑦.

PRESSER FOOT ADJUSTMENT

Fig. 45, 46

Setting foot square and flat

1. Remove pressure from foot by turning screw ⑩ anti-clockwise.

2. Turn handwheel until feeds are at its lowest position.
3. Loosen screw ⑪ and position foot flat on needle plate.
4. Tighten screw ⑪ and reset pressure by turning screw ⑩ clockwise.
5. Pressure should be just enough to feed material evenly so that proper stitch is formed.

Adjusting foot tilt

1. Loosen screw ⑫.
2. Raise or lower regulator ⑬ to give the desired tilt for the weight of material being sewn.
3. Retighten screw ⑫.

PRESSER FOOT LIFT ADJUSTMENT

Fig. 45, 46, 47

1. Loosen nut ⑭ and turn screw ⑮ until its lowest position.
2. Loosen nut ⑯.
3. Turn screw ⑰ until a lift is obtained of 6.0mm (15/64") when presser foot is lifted. (4.5mm for 500/I)
4. Tighten nut ⑯.
5. While lifting presser foot of 6.0mm (4.5mm for 500/I), turn screw ⑮ until the clearance between screw ⑮ and stopper ⑱ is obtained of 0.5mm (.020").
6. Tighten nut ⑭.
7. When presser foot is on needle plate, loosen nut ⑱ and adjust the play clearance from the bottom of screw ⑲ to top of lever ⑳ to 2 - 3mm (5/64 - 1/8") by turning screw ⑲.
8. Tighten nut ⑱.

RIGHT LOOPERS FOR USE WITH VARIOUS SIZE NEEDLES

MODEL	THREADS	FEDERAL STITCH	LOOPER MARKING	NEEDLE SIZE IDENTIFICATION			PART NUMBER	
				SINGER	W & G	METRIC	NEW NO.	OLD NO.
500/I	2	503		9-12	25-32	65-80	323-810-003	201234A
				13-16	34-40	85-100	323-810-013	202475
	3	504		9-12	25-32	65-80	323-810-001	201067A
				13-16	34-40	85-100	323-810-004	201287A
500/II	4	512		11-14	30-36	75-90	323-810-001	201067A
	4	514		9-12	25-32	65-80	323-810-004	201287A
	2	503	2	9-12	25-32	65-80	323-810-213	202842
				9-12	25-32	65-80	323-810-211	202874
	3	504	4	13-16	34-40	85-100	323-810-224	202828
9-12				25-32	65-80	323-810-213	202842	
4	512	7	9-12	25-32	65-80	323-810-214	202872	
			13-16	34-40	85-100	323-810-007	202989	
4	514	1	9-14	25-36	65-90	323-810-211	202874	

Table 8

Fig. 44

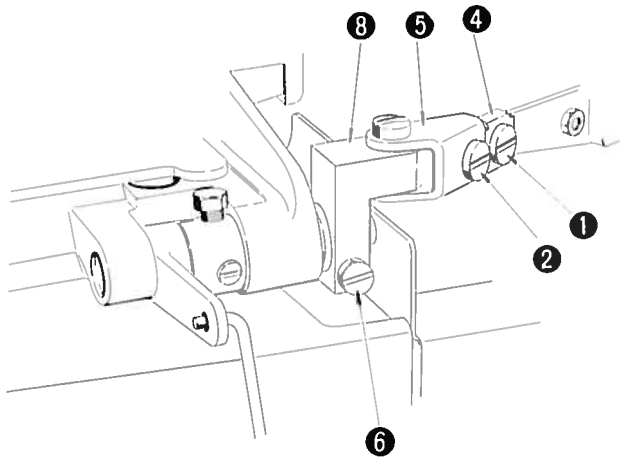


Fig. 46

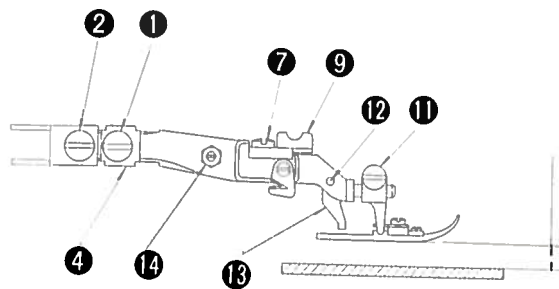


Fig. 45

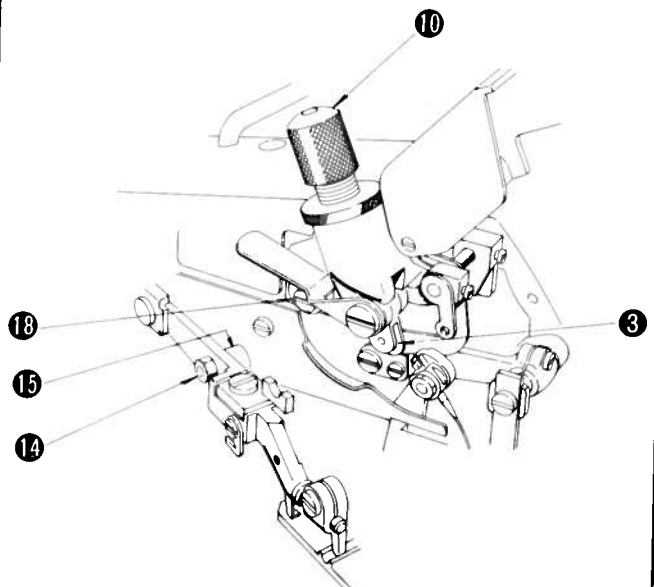
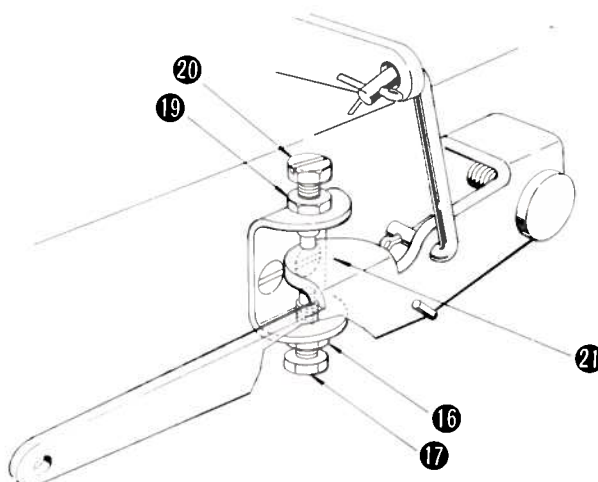
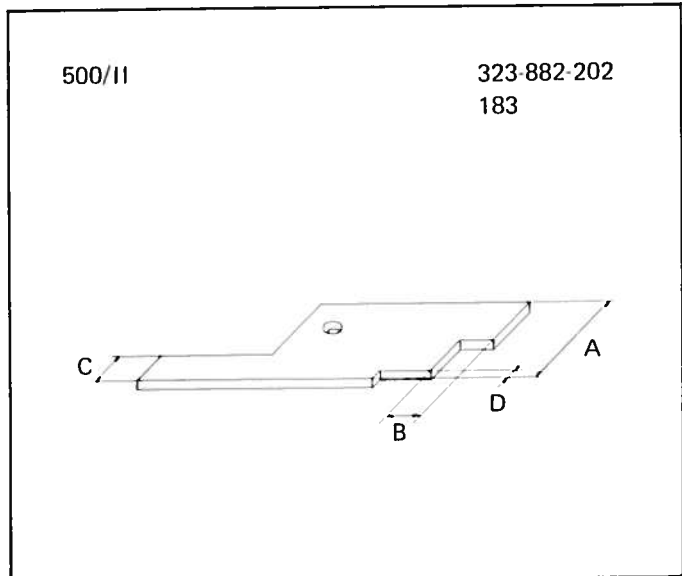
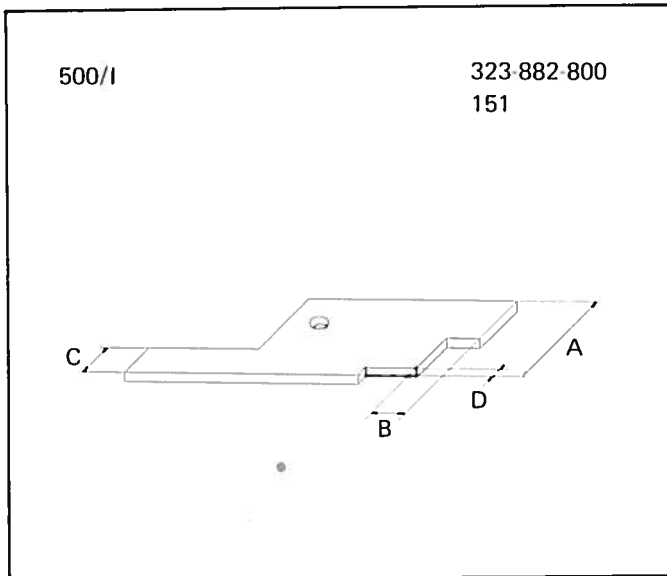


Fig. 47



500/I & 500/II TIMING GAUGES



RESPECTIVE POSITIONS REQUIRED AT MEASURING

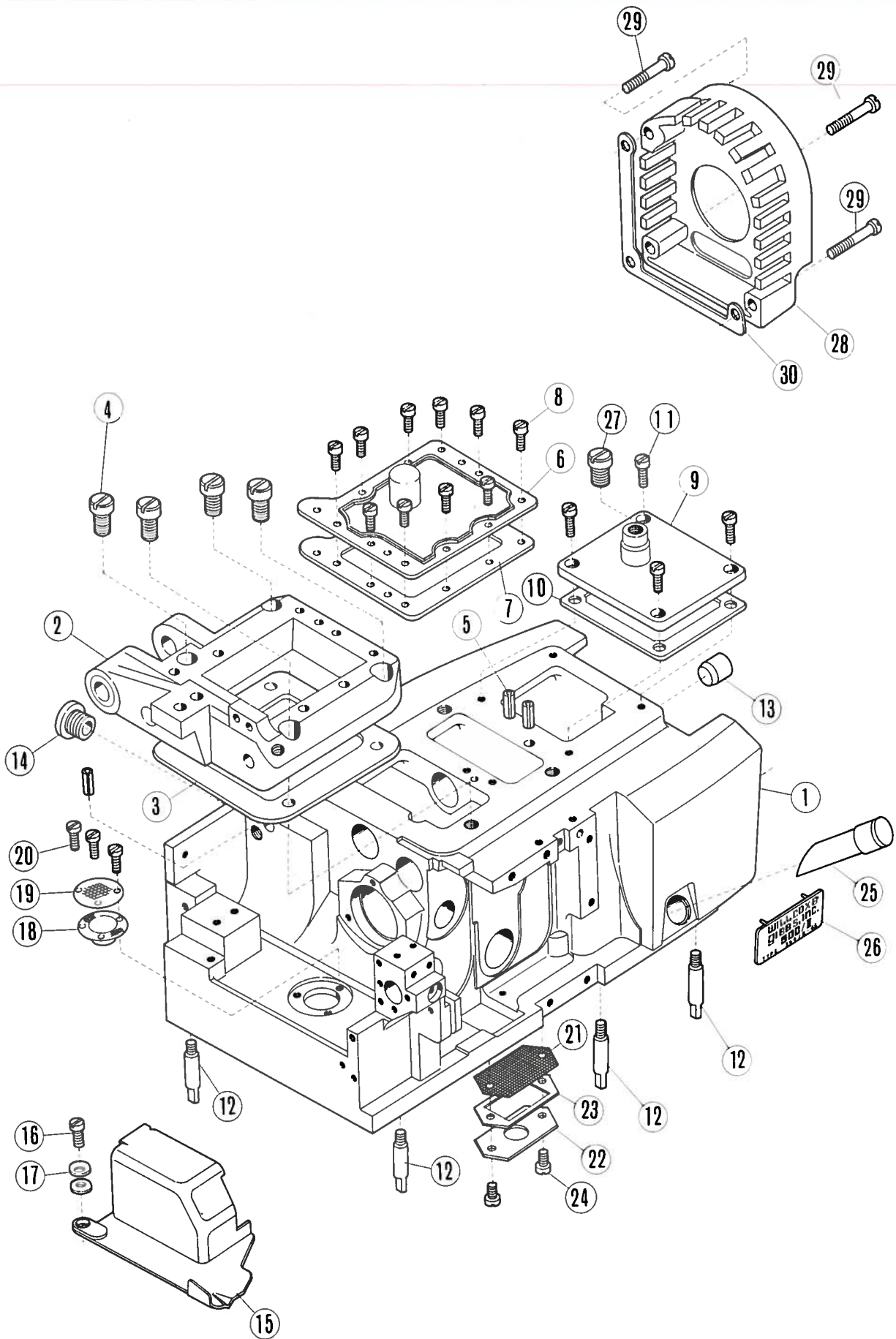
- A) Needle, at upper dead point
- B) Right looper, at left dead point
(Needle size 9)
- C) Left looper, at left dead point
(Needle size 9)
- D) Main feed dog, at upper dead point

BASIC POSITIONS ON MEASURING

- from needle plate top to needle point.
- from left side of needle to center of looper eye.
- from left side of needle to looper point.
- from needle plate top to top edge of feed teeth.

MILLIMETER-INCH FRACTION & DECIMAL CONVERSION CHART

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



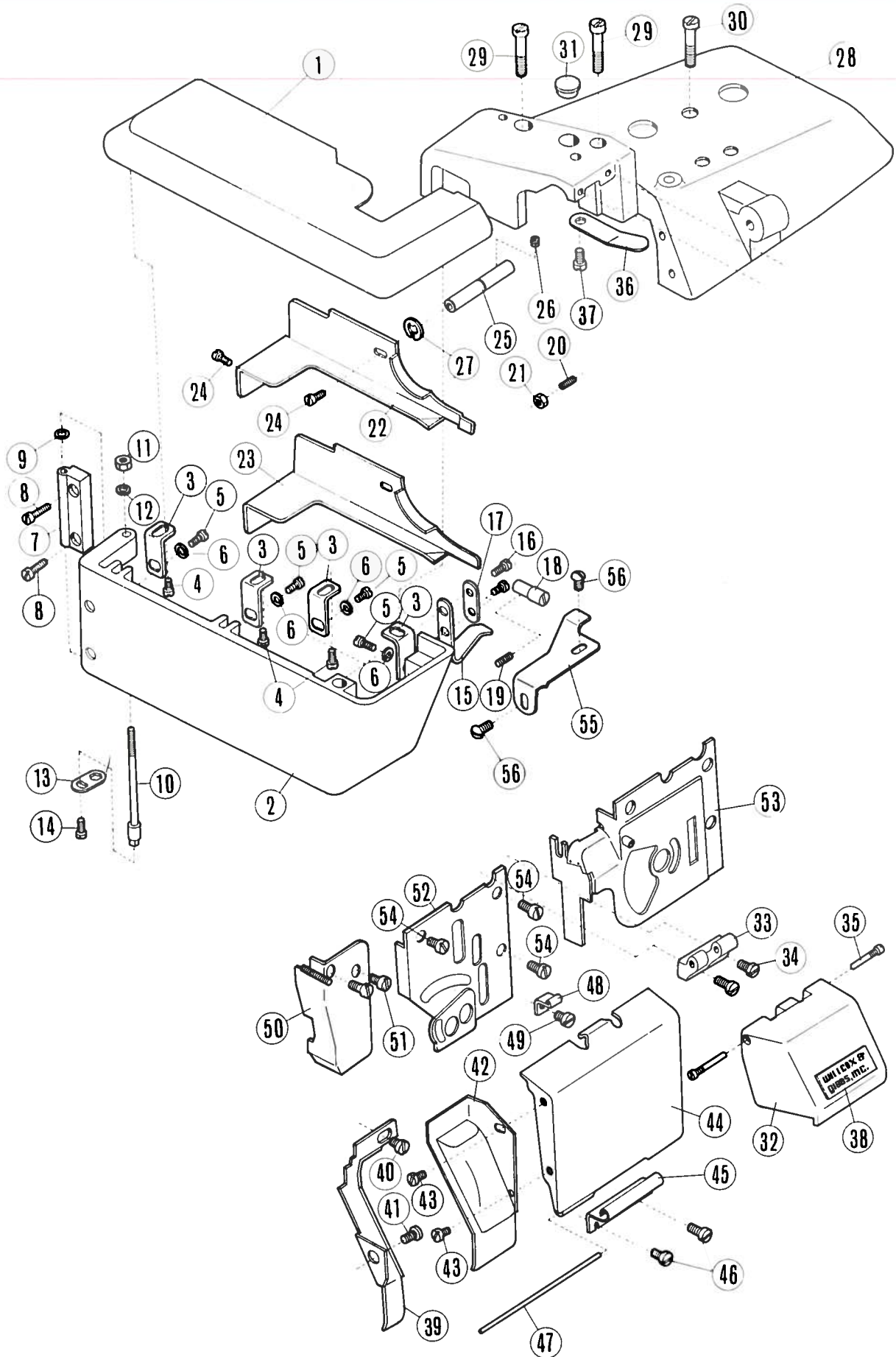
MACHINE BED FRAME

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	500/I	500/II
1	323-508-003	205208	Machine bed frame		x
2	323-500-002	202501A	" arm	x	x
3	323-663-200	202371	" " gasket	x	x
4	323-600-001	5078	" " screw (4)	x	x
5	323-620-001	201002	" " hinge pin (2)	x	x
6	323-510-016	201178B	" " cover plate	x	x
7	323-663-007	201179B	" " " " gasket	x	x
8	323-600-057	5117	" " " " screw (10)	x	x
9	323-510-018	202932	" bed cover plate	x	x
10	323-663-005	201177A	" " " " gasket	x	x
11	323-600-060	5118	" " " " screw (4)	x	x
12	323-620-202	202354	" " bottom pin (4)	x	x
13	323-627-003	202863B	Construction hole plug	x	x
14	323-510-231	202687	" " plug-screw	x	x
15	323-510-017	202934	Feed eccentric cover (except for 503/I, /II-4 & -8)		
16	323-600-325	5215A	" " " hinge screw	x	x
17	323-615-015	201191	" " " " " washer	x	x
18	323-655-001	201004	Oil filter screen (left)	x	x
19	323-800-002	201005	" " " " plate	x	x
20	323-600-002	1175-2	" " " " " screw (3)	x	x
21	323-655-204	202662	" " " (front)	x	x
22	323-800-217	202663D	" " " " plate		x
23	323-648-200	202720B	" " " " " gasket		x
24	323-600-002	1175-2	" " " " " screw (2)		x
25	323-882-001	201330	" sight gauge	x	x
26	** 323-692-009	205158	Type plate – for 504/II-45		
27	323-600-208	5198	Oil filler plug screw	x	x
28	323-510-234	201318B	" cooler cover	x	x
29	323-600-072	5094	" " " screw (3)	x	x
30	323-648-201	202748	" " " gasket	x	x

**See additional organization chart.

Not shown

323-508-200 201000C Machine bed frame for 500/I

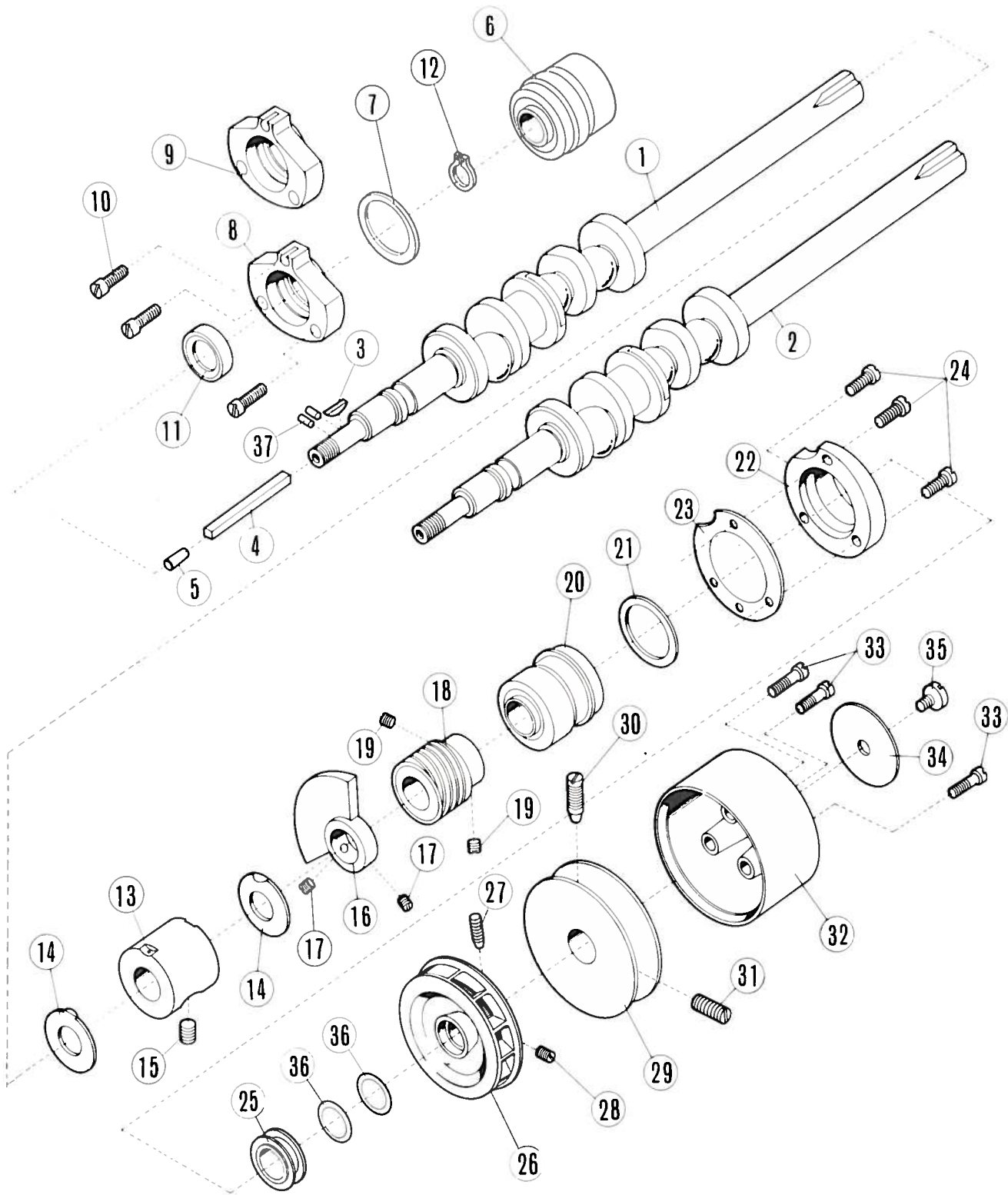


MAIN FRAME AND MISCELLANEOUS COVERS

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	500/I	500/II
	323-900-003	202466	Cloth plate, complete with 201181C, 202467, 201184x4, 1216x4, 201185x4 & 1202x4	x	x
1	323-802-001	201181C	Cloth plate	x	x
2	323-802-212	202467	" " frame	x	x
3	323-740-006	201184	" " joint (4)	x	x
4	323-600-068	1216	" " " screw (upper) (4)	x	x
5	323-600-032	1202	" " " " (lower) (4)	x	x
6	323-615-012	201185	" " " " " washer (4)	x	x
7	323-728-208	200159A	" " hinge	x	x
8	323-600-038	5095	" " " screw (2)	x	x
9	323-618-007	200183	" " " thrust washer	x	x
10	323-620-207	201221A	" " " pin	x	x
11	323-630-009	5099	" " " " nut	x	x
12	323-615-013	200821	" " " " " washer	x	x
13	323-625-200	202865	" " " " " retainer	x	x
14	323-600-357	5293	" " " " " screw	x	x
15	323-643-003	201186	" " lock spring	x	x
16	323-600-068	1216	" " " " " screw (2)	x	x
17	323-615-014	200162	" " " " " washer	x	x
18	323-734-206	200163A	" " " " " stud	x	x
19	323-600-069	1435	" " " " " screw	x	x
20	323-600-069	1435	" " stop screw	x	x
21	323-630-001	3044	" " " " " nut	x	x
22	* 323-560-024	202513B	" " fabric guard	x	x
23	* 323-560-025	202795A	" " " guard (for /I, II-41, -42, -43, -45 & -47)	x	x
24	323-600-068	1216	" " " " " screw (2)	x	x
25	323-620-203	202521	" " " " " pin	x	x
26	323-600-012	1457	" " " " " screw	x	x
27	323-634-200	202522	" " " " " stop ring	x	x
28	** 323-510-009	202514A	Machine top cover (for 503, 504/I & /II)	x	x
29	323-600-072	5094	" " " " " screw (long) (2)	x	x
30	323-600-038	5095	" " " " " (short)	x	x
31	323-627-011	201755	" " " " " plug	x	x
32	323-510-206	202515A	Upper knife cover (see page 49 for new cover with eye guard)	x	x
33	323-728-200	202516	" " " " " hinge	x	x
34	323-600-073	2918	" " " " " screw (2)	x	x
35	323-620-204	202579	" " " " " pin (2)	x	x
36	323-641-200	202517	" " " " " lock spring	x	x
37	323-600-057	5117	" " " " " screw	x	x
38	323-692-200	202524	" " " " " name plate	x	x
39	323-560-203	202843	Chip guard	x	x
40	323-600-068	1216	" " " screw (upper)	x	x
41	323-600-074	2905	" " " " (lower)	x	x
42	323-560-201	202660	Front cover extension	x	x
43	323-600-026	2921	" " " " " screw (2)	x	x
44	323-510-006	201200	" cover	x	x
45	323-728-003	201201	" " hinge	x	x
46	323-600-068	1216	" " " " " screw (2)	x	x
47	323-620-011	201202	" " " " " pin	x	x
48	323-643-005	201203	" " " " " lock spring	x	x
49	323-600-068	1216	" " " " " screw	x	x
50	323-510-020	202937	Right looper cover		x
51	323-600-068	1216	" " " " " screw (2)		x
52	323-800-025	202938	Looper thread plate		x
53	323-800-202	201204B	" " " " " plate	x	
54	323-600-068	1216	" " " " " screw (3)	x	x
55	323-734-002	202936	Feed eccentric cover latch	x	x
56	323-600-068	1216	" " " " " screw (2)	x	x

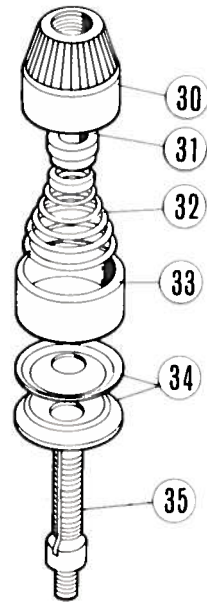
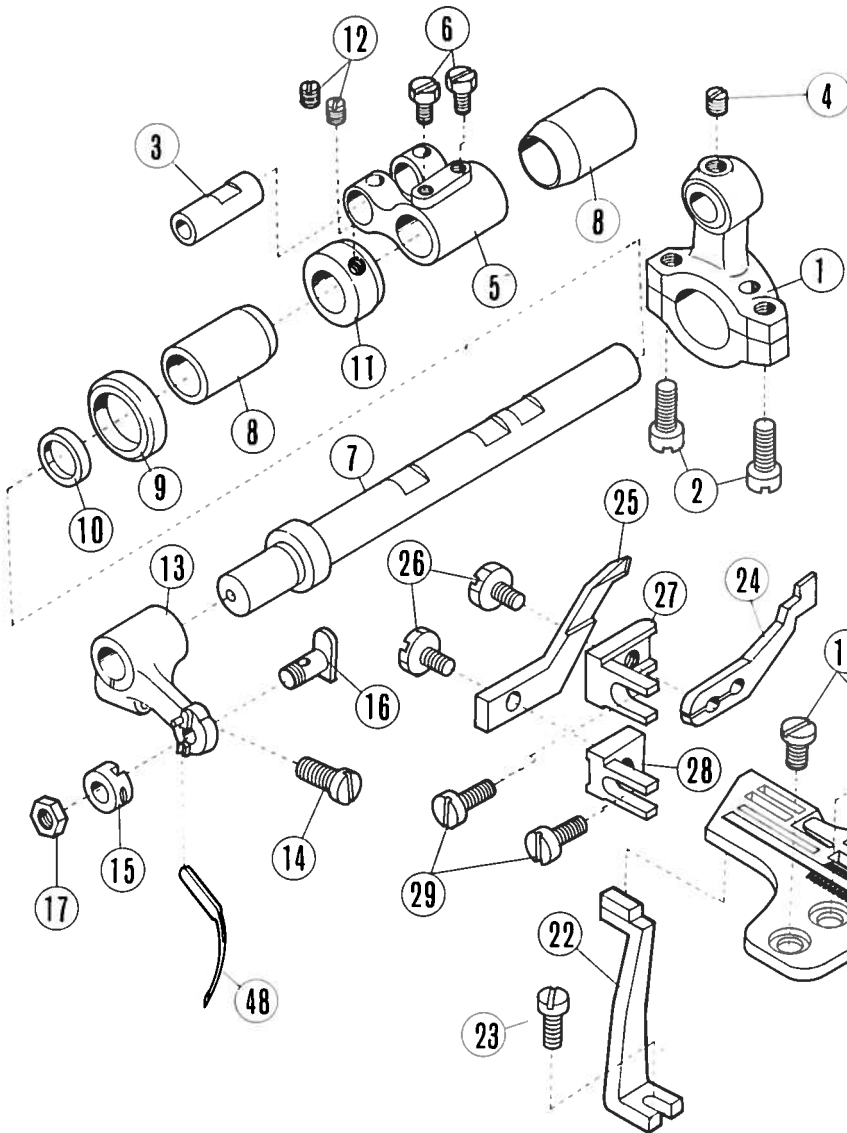
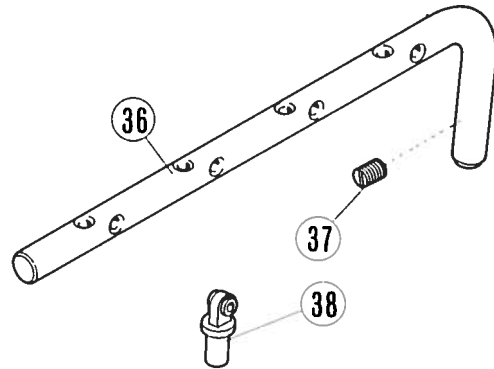
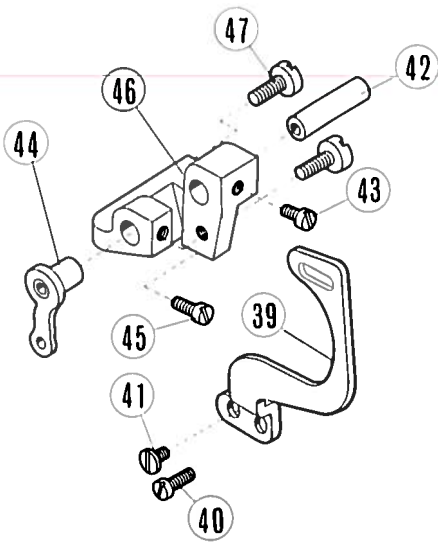
*See organization chart.

**See additional organization chart.



CRANKSHAFT MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	500/I	500/II
1	323-540-014	205259	Crankshaft	x	
2	323-540-010	205260	Crankshaft		x
3	323-649-001	201009	" key	x	x
4	323-653-010	202990	" oil wick	x	x
5	323-627-208	202903	" " stopper	x	x
6	323-672-001	202902	" bearing (left)	x	x
7	323-634-003	202907	" " " oil seal ring	x	x
8	323-686-005	202906	" " " retainer	x	x
9	323-686-008	202943	" " " retainer – 503/I, /II-4 & -8		
10	323-600-002	1175-2	" " " " screw (3)	x	x
11	323-634-002	202908	" " " oil seal ring	x	x
12	323-686-004	202901	" " " retaining ring	x	x
13	323-676-037	201212C	" bushing (center)	x	x
14	323-618-201	202722A	" " " thrust washer (2)	x	x
15	323-600-007	2022-3	" " " screw	x	x
16	323-579-001	201010A	" counterweight	x	x
17	323-600-004	5060	" " screw (2)	x	x
18	323-765-001	201298	" worm	x	x
19	323-600-004	5060	" " screw (2)	x	x
20	323-672-001	202902	" bearing (right)	x	x
21	323-634-003	202907	" " " oil seal ring	x	x
22	323-800-021	202904	" " " retaining bracket	x	x
23	323-663-008	202905	" " " " " gasket	x	x
24	323-600-002	1175-2	" " " " " screw (3)	x	x
25	323-680-005	202909	" " " oil seal collar	x	x
26	323-568-003	205149	Oil cooling fan	x	x
27	323-600-066	5149A	" " " position screw	x	x
28	323-600-037	1458	" " " screw	x	x
29	323-546-001	201017A	Pulley	x	x
30	323-600-008	5080	" position screw	x	x
31	323-600-009	5081	" screw	x	x
32	323-780-201	201018B	" cap	x	x
33	323-600-010	5010	" " screw (3)	x	x
34	323-800-200	202523	" " name plate	x	x
35	323-600-209	5214	" " " " screw	x	x
36	323-632-001	201022	" 'o' ring (2)	x	x
37	323-653-003	202081	Feed eccentric oil wick (2)	x	x

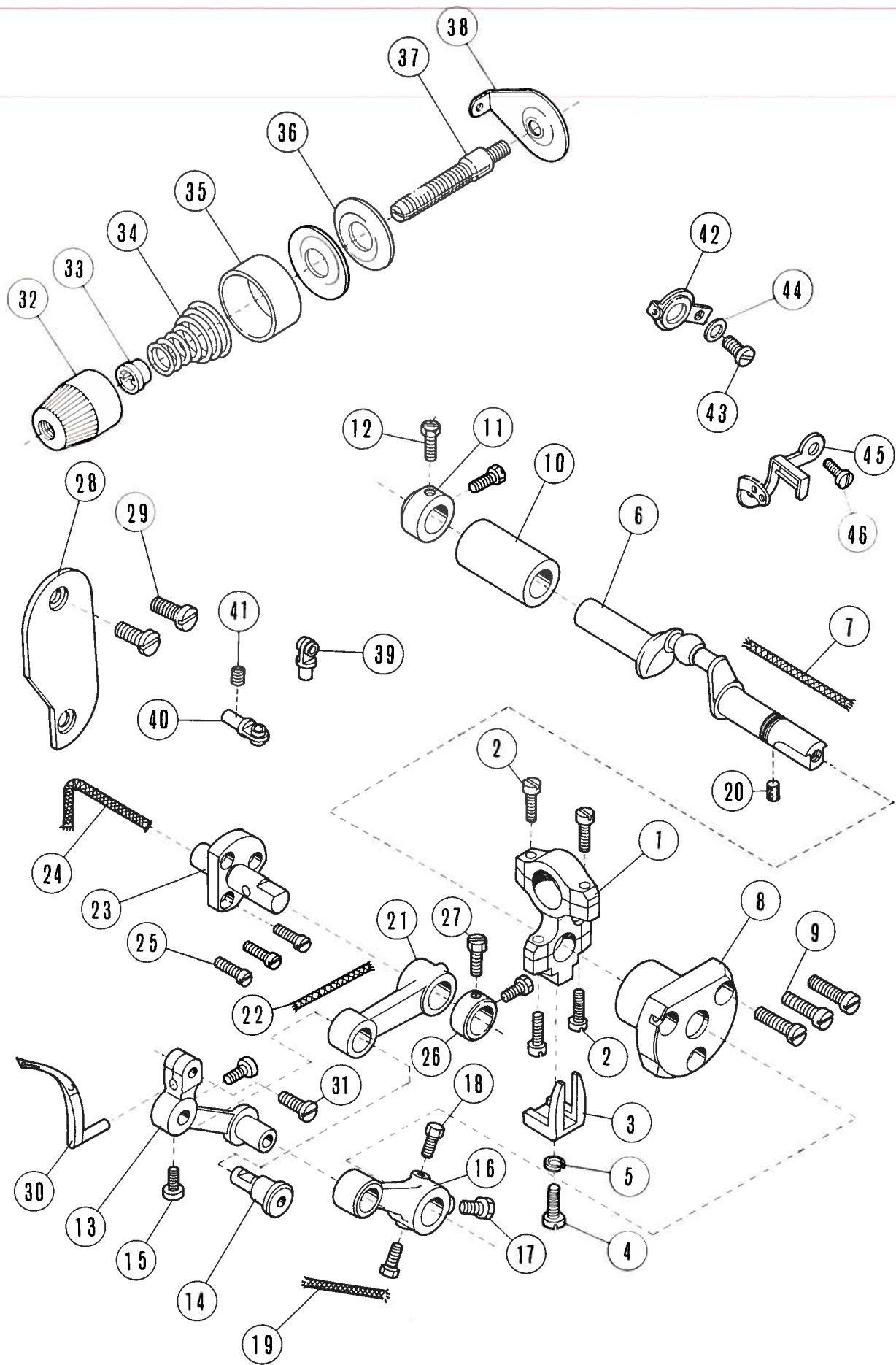


NEEDLE DRIVE MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	500/I	500/II
1	323-525-001	201023	Needle drive connection		
2	323-600-056	2213-1	" " " cap screw (2)	x	x
3	323-620-237	202711A	" " " hinge pin	x	x
4	323-600-012	1457	" " " " " screw	x	x
5	323-576-001	201025	" " crank	x	x
6	323-600-013	5084	" " " screw (2)	x	x
7	323-540-011	202825A	" " shaft	x	x
8	323-676-020	201027A	" " " bushing (2)	x	x
9	323-618-008	202910	" " " " thrust washer	x	x
10	323-626-001	202911	" " " oil seal	x	x
11	323-618-002	201029	" " " thrust collar	x	x
12	323-600-013	5084	" " " " " screw (2)	x	x
13	* 323-502-xxx		" " arm		
14	* 323-600-011	5002	" " " clamp screw		
15	* 323-683-xxx		" clamp		
16	* 323-604-001	201032	" " screw stud		
17	* 323-630-001	3044	" " " " nut		
18	* 323-801-xxx		" plate	x	x
19	323-600-014	4009-1	" " screw (2)	x	x
20	323-649-002	201034A	" " key	x	x
21	323-600-015	5053	" " " screw	x	x
22	323-800-022	202912	" " supporter	x	x
23	323-600-019	1175-3	" " " " screw	x	x
24	323-561-xxx		" guard (front)	x	x
25	323-561-xxx		" " (rear)	x	x
26	323-600-105	5364	" " screw (2)	x	x
27	323-685-226	202491	" " (front) holder	x	x
28	323-685-227	202492	" " (rear) holder	x	x
29	323-600-019	1175-3	" " " " screw (2)	x	x
	323-900-200	202478	" thread tension, complete with parts of Ref. Nos. 30-35 (except for 503/I, /II-4 & -8)		
30	323-630-200	201035A	Needle thread tension nut	x	x
31	323-676-202	202278	" " " spring bushing	x	x
32	** 323-642-001	201037	" " " spring (except for 503/I, /II-4 & -8)	x	x
33	323-780-002	201039	" " " " cup	x	x
34	323-613-001	201482	" " " disc (2)	x	x
35	323-604-201	5082A	" " " post	x	x
36	323-851-003	202999	Top cover thread guide bar	x	x
37	323-600-303	5185	" " " " " screw	x	x
38	323-860-200	201048A	Needle thread eyelet	x	x
39	323-866-009	202826A	" " " takeup	x	x
40	323-600-016	1229	" " " " screw (large)	x	x
41	323-600-074	2905	" " " " (small)	x	x
42	323-639-001	201042	" " tube	x	x
43	323-600-017	5109	" " " " screw	x	x
44	323-860-001	201044	" " " takeup eyelet	x	x
45	323-600-017	5109	" " " " " screw	x	x
46	323-740-215	201043B	" " tube bracket	x	x
47	323-600-002	1175-2	" " " " " screw (2)	x	x
48	423-xxx-xxx		Needle	x	x

*See organization chart.

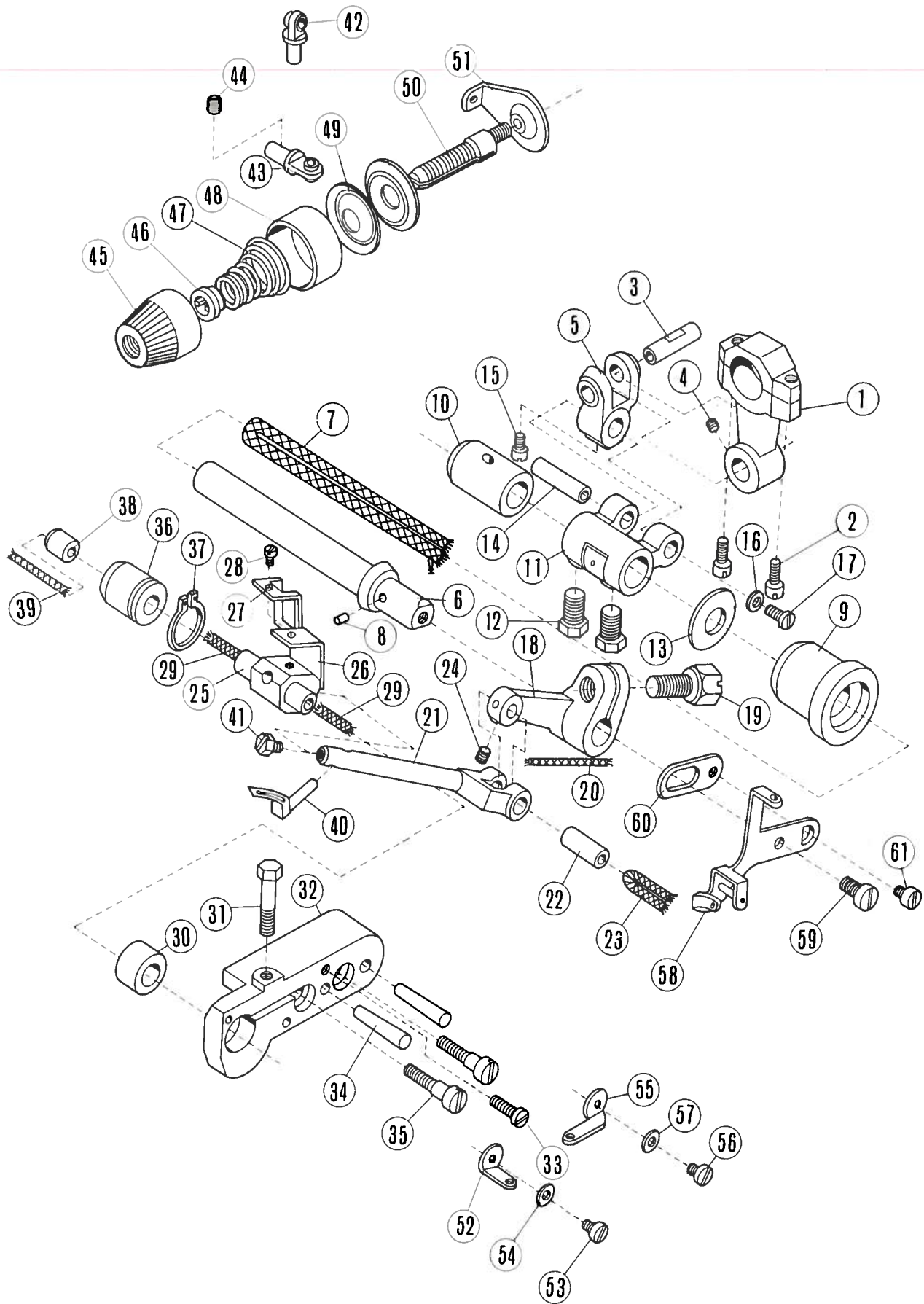
**See additional organization chart.



RIGHT LOOPER DRIVE MECHANISM FOR 500/I

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION
1	323-525-203	201373	Right looper drive connection
2	323-600-056	2213-1	" " " " cap screw (4)
3	323-850-002	201050	" " " " guide
4	323-600-019	1175-3	" " " " screw
5	323-615-003	201252	" " " " washer
6	323-540-018	201052B	" " " shaft
7	323-653-212	202177	" " " " oil wick
8	323-676-006	201053A	" " " " bushing (right)
9	323-600-019	1175-3	" " " " " " screw (3)
10	323-676-007	201055A	" " " " bushing (left)
11	323-618-003	201056	" " " " thrust collar
12	323-600-013	5084	" " " " " " screw (2)
13	323-530-221	201271A	" " lever
14	323-620-200	201058A	" " " pin
15	323-600-021	1206	" " " " screw (2)
16	323-525-003	201060B	" " " connection
17	323-600-022	2022-4	" " " " screw
18	323-600-023	5083	" " " " adjust screw
19	323-653-005	202176	" " " " oil wick
20	323-653-003	202081	" " " " felt
21	323-730-204	201061A	" " " link
22	323-653-005	202176	" " " " oil wick
23	323-604-003	201064	" " " " guide
24	323-653-005	202176	" " " " oil wick
25	323-600-024	1998-2	" " " " screw (3)
26	323-618-005	201065	" " " " thrust collar
27	323-600-013	5084	" " " " " " screw (2)
28	323-800-004	201066	" " " " guide plate
29	323-600-014	4009-1	" " " " " " screw (2)
30	* 323-810-xxx		" looper
31	323-600-032 323-900-201	1202 202479	" " clamp screw " " thread tension, complete with 201035A, 202278, 201068, 201039, 201482x2 & 5082A
32	323-630-200	201035A	Right looper thread tension nut
33	323-676-202	202278	" " " " spring bushing
34	323-642-002	201068	" " " " (light)
35	323-780-002	201039	" " " " cup
36	323-613-001	201482	" " " " disc (2)
37	323-604-201	5082A	" " " " post
38	323-800-215	202849	" " " " guide
39	323-860-200	201048A	" " " eyelet (upper)
40	323-860-200	201048A	" " " " (lower)
41	323-600-034	1459	" " " " screw
42	323-860-005	201071	" " " " guide
43	323-600-026	2921	" " " " screw
44	323-615-216	202875	" " " " washer
45	323-866-002	201070	" " " " takeup
46	323-600-025	5064	" " " " screw

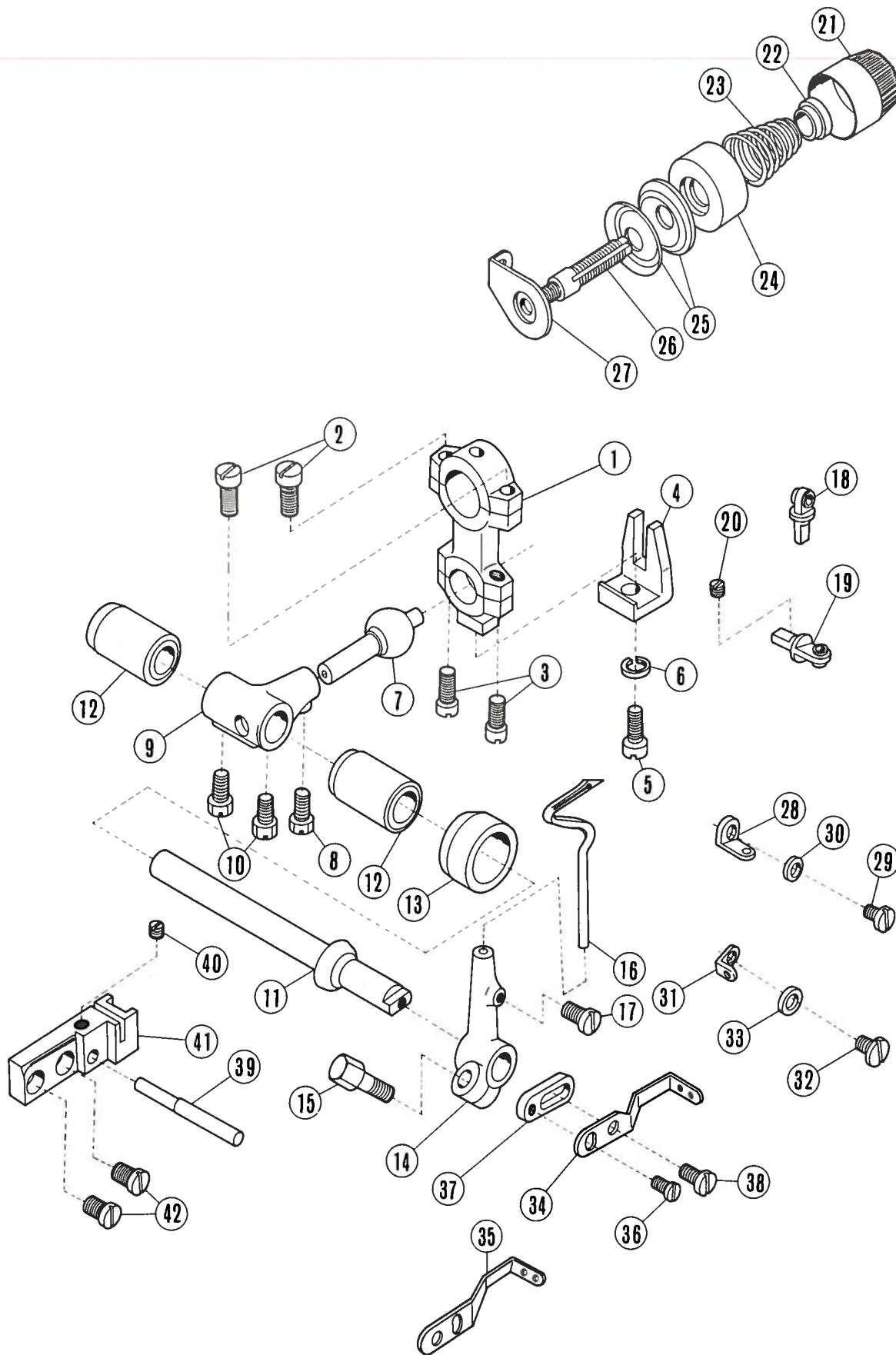
*See organization chart.



RIGHT LOOPER DRIVE MECHANISM FOR 500/II

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION
1	323-525-227	202619A	Right looper drive connection
2	323-600-011	5002	" " " " cap screw (2)
3	323-620-237	202711A	" " " " hinge pin
4	323-600-013	5084	" " " " " " screw
5	323-730-209	202709A	" " " " crank
6	323-540-223	202622B	" " " shaft
7	323-653-012	202178	" " " " oil wick
8	323-653-003	202081	" " " " felt
9	323-676-228	202623A	" " " " bushing (front)
10	323-676-007	201055A	" " " " (rear)
11	323-576-214	202710A	" " " " crank
12	323-600-022	2022-4	" " " " " screw (2)
13	323-618-009	202922	" " " " thrust washer
14	323-620-238	202712A	" " " " hinge pin
15	323-600-013	5084	" " " " " " screw
16	323-615-218	202757	" " " " " " thrust washer
17	323-600-068	1216	" " " " " " " " screw
18	323-540-227	202626A	" " lever connection
19	323-600-290	5219	" " " " clamp screw
20	323-653-204	202030	" " " " oil wick
21	323-530-223	202827	" " lever
22	323-620-234	202625	" " " " hinge pin
23	323-653-005	202176	" " " " " oil wick
24	323-600-264	5146	" " " " " screw
25	323-850-019	202914	" " " " guide
26	323-653-009	202915	" " " " oil felt
27	323-800-023	202916	" " " " " " retainer
28	323-600-051	1231	" " " " " " " screw
29	323-653-212	202177	" " " " " wick (2)
30	323-676-021	202917	" " " " bushing (front)
31	323-600-094	5305	" " " " " " clamp screw
32	323-740-015	202918	" " " " " " bracket
33	323-600-215	2133-1	" " " " " " removing screw
34	323-621-001	202926	" " " " " " cone pin (2)
35	323-600-038	5095	" " " " " " screw (2)
36	323-676-022	202919	" " " " " " bushing (rear)
37	323-633-001	202920	" " " " " " " " retainer
38	323-627-002	202921	" " " " " " " oil stopper
39	323-653-013	202174	" " " " " " " " oil wick
40	* 323-810-xxx		" " looper
41	323-600-291	5220	" " " " screw
42	323-860-200	201048A	" " " " thread eyelet (upper)
43	323-860-200	201048A	" " " " " (lower)
44	323-600-034	1459	" " " " " " screw
	323-900-201	202479	" " " " tension, complete with 201035A, 202278, 201068, 201039, 201482x2 & 5082A
45	323-630-200	201035A	Right looper thread tension nut
46	323-676-202	202278	" " " " " " spring bushing
47	323-642-002	201068	" " " " " " (light)
48	323-780-002	201039	" " " " " " cup
49	323-613-001	201482	" " " " " " disc (2)
50	323-604-201	5082A	" " " " " " post
51	323-800-215	202849	" " " " " " guide
52	323-860-006	201089	" " " " " " guide (left)
53	323-600-026	2921	" " " " " " screw
54	323-615-216	202875	" " " " " " " washer
55	323-850-244	202859	" " " " " " (right)
56	323-600-026	2921	" " " " " " screw
57	323-615-216	202875	" " " " " " " washer
58	323-866-007	202829A	" " " " " " takeup
59	323-600-025	5064	" " " " " " screw
60	323-685-228	202858	" " " " " " holder
61	323-600-026	2921	" " " " " " screw

*See organization chart.

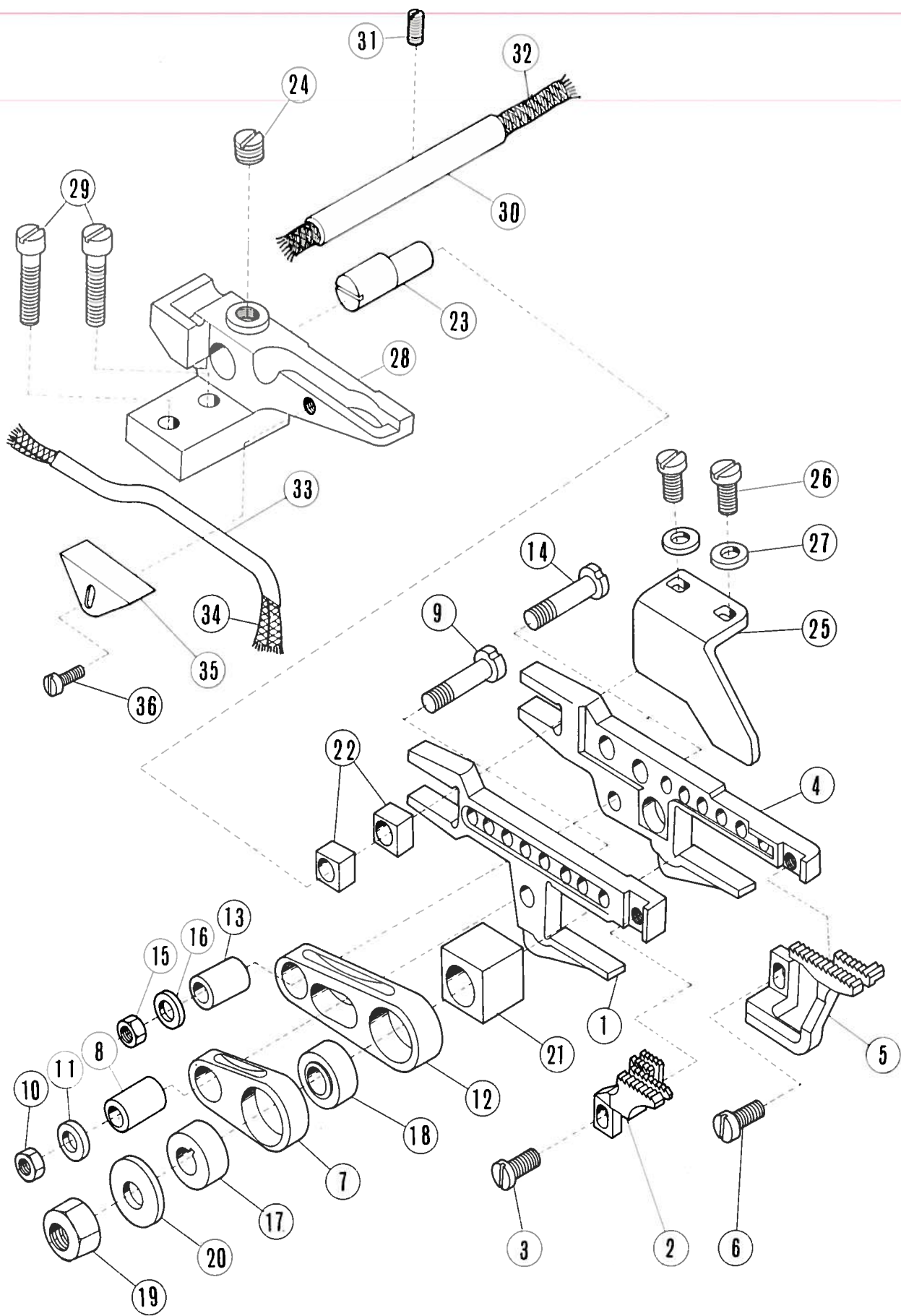


LEFT LOOPER DRIVE MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	500/I	500/II
1	323-525-200	201073B	Left looper drive connection	x	x
2	323-600-011	5002	" " " " cap screw (large) (2)	x	x
3	323-600-020	1170-1	" " " " " " (small) (2)	x	x
4	323-850-200	201074A	" " " " guide	x	x
5	323-600-200	1156	" " " " " screw	x	x
6	323-617-200	202286	" " " " " " washer	x	x
7	323-604-004	201075	" " " " ball stud	x	x
8	323-600-028	5048	" " " " " " screw	x	x
9	323-576-207	201079A	" " " " crank	x	x
10	323-600-028	5048	" " " " " screw (2)	x	x
11	323-540-004	201080	" " " " shaft	x	x
12	323-676-023	201081A	" " " " " bushing (2)	x	x
13	323-686-006	202923	" " " " " housing	x	x
14	323-530-206	201084A	" " " " lever	x	x
15	323-600-263	5274	" " " " clamp screw	x	x
16	* 323-810-xxx		" " " " looper	x	x
17	323-600-092	5328	" " " " screw	x	x
18	323-860-200	201048A	" " " " thread eyelet (upper)	x	x
19	323-860-200	201048A	" " " " " (lower)	x	x
20	323-600-034	1459	" " " " " screw	x	x
	** 323-900-xxx		" " " " tension, complete with parts of Ref. Nos. 21-26	x	x
21	323-630-200	201035A	Left looper thread tension nut	x	x
22	323-676-202	202278	" " " " " " spring bushing	x	x
23	** 323-642-xxx		" " " " " " spring	x	x
24	323-780-002	201039	" " " " " " cup	x	x
25	323-613-001	201482	" " " " " " disc (2)	x	x
26	323-604-201	5082A	" " " " " " post	x	x
27	323-800-215	202849	" " " " " " guide	x	x
28	323-860-006	201089	" " " " " " guide (right)	x	x
29	323-600-026	2921	" " " " " " " screw	x	x
30	323-615-216	202875	" " " " " " " " washer	x	x
31	323-850-243	202860	" " " " " " (left)	x	x
32	323-600-026	2921	" " " " " " " screw	x	x
33	323-615-216	202875	" " " " " " " " washer	x	x
34	323-866-210	202830	" " " " " " takeup		x
35	323-866-003	201087A	" " " " " " takeup	x	
36	323-600-026	2921	" " " " " " " screw	x	x
37	323-740-002	201088	" " " " " " bracket	x	x
38	323-600-032	1202	" " " " " " " screw	x	x
39	323-639-002	201091	" " " " " " tube	x	x
40	323-600-033	1892	" " " " " " screw	x	x
41	323-740-003	201092A	" " " " " " bracket	x	x
42	323-600-002	1175-2	" " " " " " " screw (2)	x	x

*See organization chart.

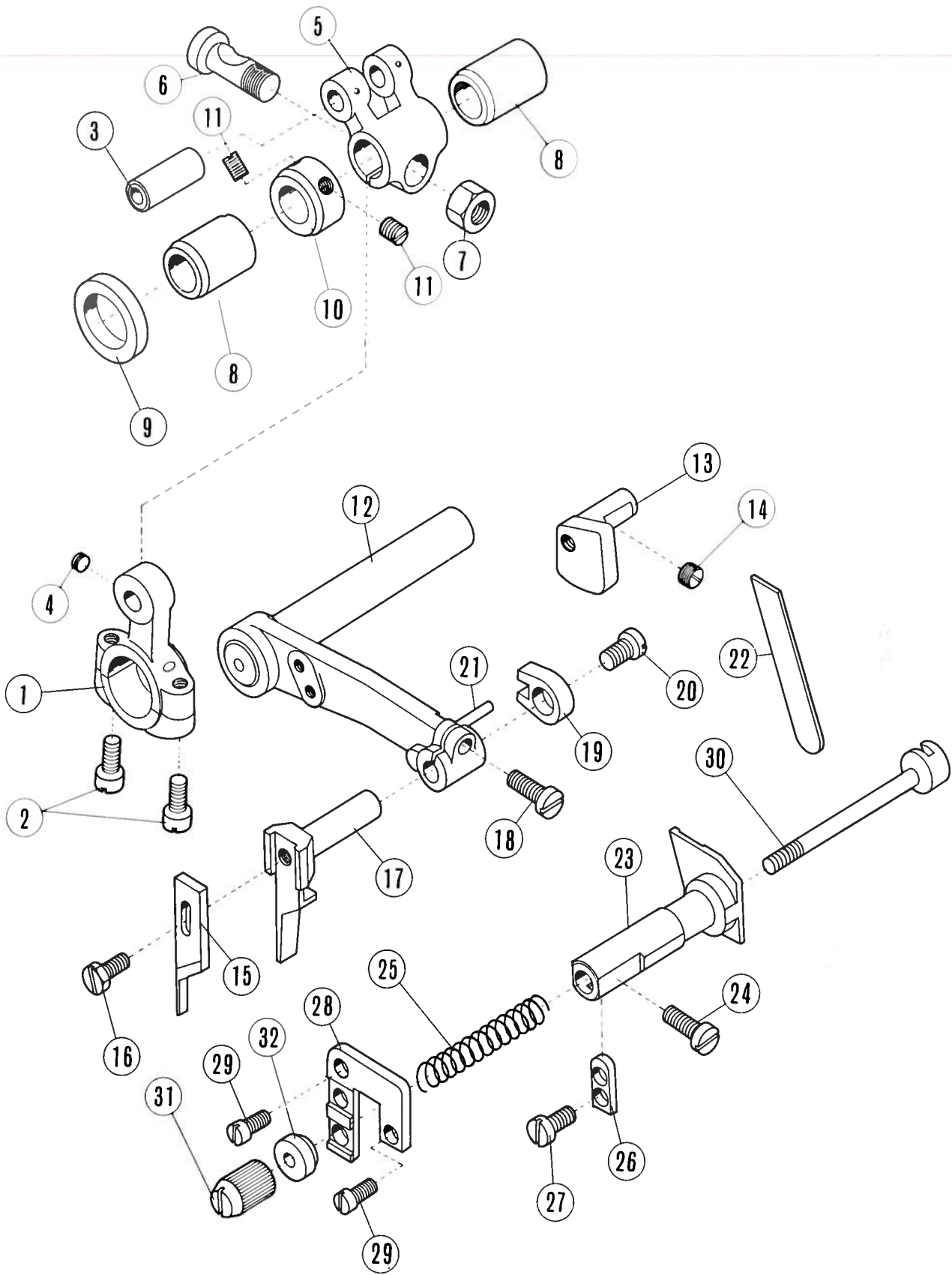
**See additional organization chart.



MAIN AND DIFFERENTIAL FEED MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	500/I	500/II
1	323-593-001	201093A	Main feed bar	x	x
2	* 323-830-xxx		" " dog	x	x
3	323-600-032	1202	" " " screw	x	x
4	323-593-002	201096A	Differential feed bar	x	x
5	* 323-830-xxx		" " dog	x	x
6	323-600-032	1202	" " " screw	x	x
7	323-730-002	201098	Main feed connecting link	x	x
8	323-676-013	201099	" " " " bushing	x	x
9	323-600-036	201100	" " " " " screw	x	x
10	323-630-001	3044	" " " " " nut	x	x
11	323-615-002	200098	" " " " " " washer	x	x
12	323-730-003	201101	Diff. feed connecting link	x	x
13	323-676-013	201099	" " " " bushing	x	x
14	323-600-036	201100	" " " " " screw	x	x
15	323-630-001	3044	" " " " " nut	x	x
16	323-615-002	200098	" " " " " " washer	x	x
17	* 323-580-xxx		Main feed eccentric	x	x
18	* 323-580-xxx		Differential feed eccentric	x	x
19	323-630-016	5213	Feed eccentric lock nut	x	x
20	323-615-023	202924	" " " " washer	x	x
21	323-750-001	201106	" bar lift block	x	x
22	323-750-002	201107	" " guide block (2)	x	x
23	323-620-201	202200	" " tilt adjust pin	x	x
24	323-600-043	2022	" " " " " screw	x	x
25	323-850-005	201109	" " guide (right)	x	x
26	323-600-019	1175-3	" " " " screw (2)	x	x
27	323-615-211	167066	" " " " washer (2)	x	x
28	323-850-251	202201A	" " " (left)	x	x
29	323-600-038	5095	" " " " screw (2)	x	x
30	323-639-003	201110	" " oil wick tube	x	x
31	323-600-069	1435	" " " " " screw	x	x
32	323-653-016	202181	" " " wick	x	x
33	323-639-201	202202	" eccentric oil wick tube	x	x
34	323-653-204	202033	" " " wick	x	x
35	323-685-200	202203	" " " " tube holder	x	x
36	323-600-029	1196	" " " " " " screw	x	x

*See organization chart.



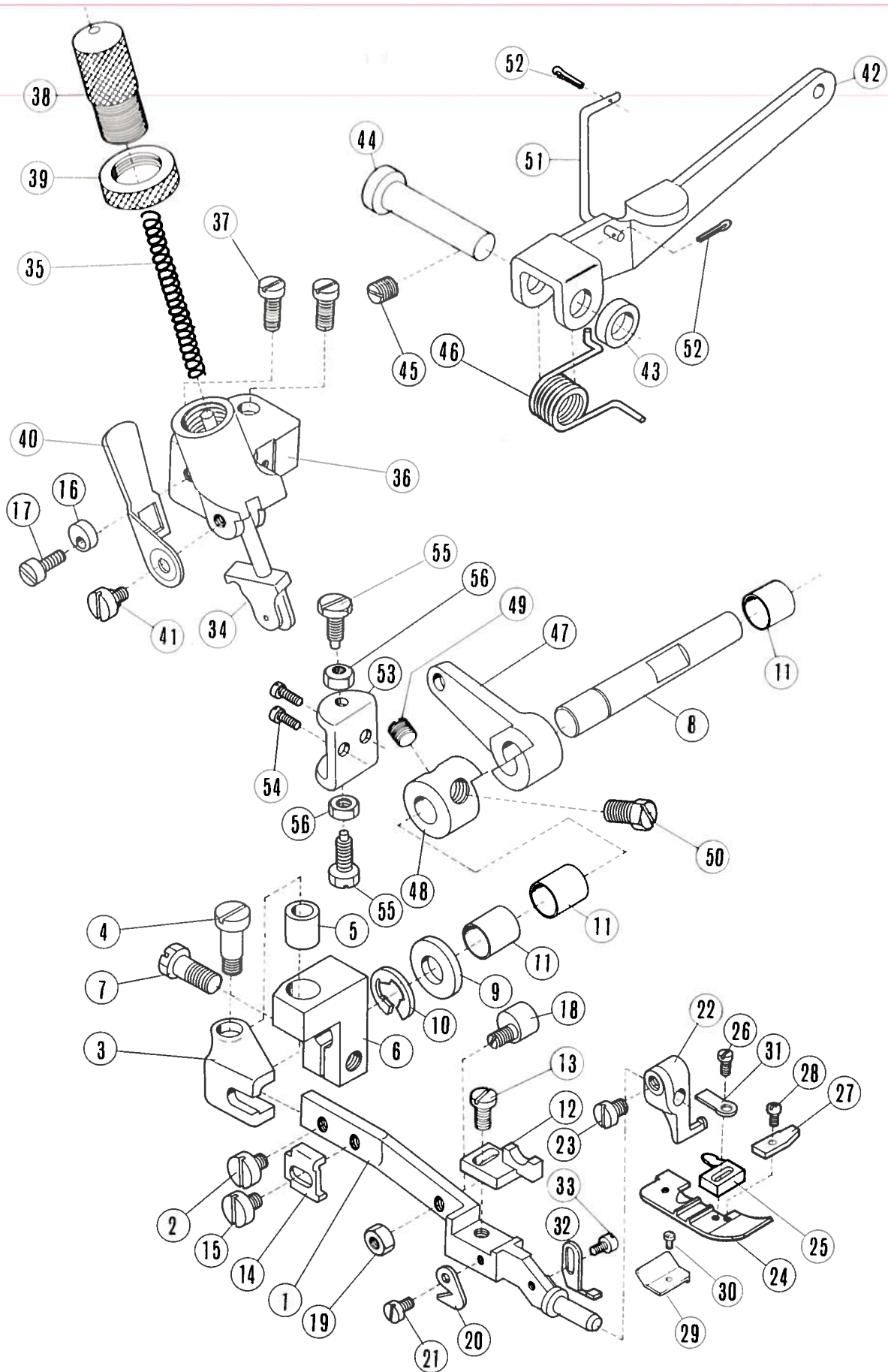
UPPER AND LOWER KNIFE MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	500/I	500/II
1	323-525-007	202925	Upper knife drive connection	x	x
2	323-600-095	5187	" " " " cap screw (2)	x	x
3	323-620-237	202711A	" " " " hinge pin	x	x
4	323-600-012	1457	" " " " " " screw	x	x
5	323-576-004	201360A	" " " crank	x	x
6	323-600-040	5087	" " " " clamp screw	x	x
7	323-630-005	5181	" " " " " " nut	x	x
8	323-676-230	201115A	" " lever bushing (2)	x	x
9	323-634-001	202927	" " " oil seal ring	x	x
10	323-618-006	201117	" " " thrust collar	x	x
11	323-600-013	5084	" " " " " screw (2)	x	x
12	323-530-019	205292	" " lever	x	x
13	323-850-205	202636	" " " guide	x	x
14	323-600-043	2022	" " " " screw	x	x
15	* 323-870-xxx		" knife (tungsten carbide tipped)	x	x
16	323-600-044	5088	" " screw	x	x
17	323-685-004	202637B	" " holder	x	x
18	323-600-002	1175-2	" " " clamp screw	x	x
19	323-850-018	202638B	" " " guide	x	x
20	323-600-301	1189	" " " " screw	x	x
21	323-620-006	201125	" " " " pin	x	x
22	* 323-870-xxx		Lower knife	x	x
23	323-685-234	202739	" " holder	x	x
24	323-600-014	4009-1	" " " screw	x	x
25	323-640-001	201129	" " " spring	x	x
26	323-686-001	201130A	" " " " retainer	x	x
27	323-600-019	1175-3	" " " " " screw	x	x
28	323-850-008	201131A	" " " guide	x	x
29	323-600-019	1175-3	" " " " screw (2)	x	x
30	323-604-211	201132B	" " clamp stud — except for 504/I-10	x	x
31	323-630-203	5260	" " " " nut	x	x
32	323-615-007	201134	" " " " " washer	x	x

*See organization chart.

Not shown

323-604-227 202590 Lower knife clamp stud — for 504/I-10 only

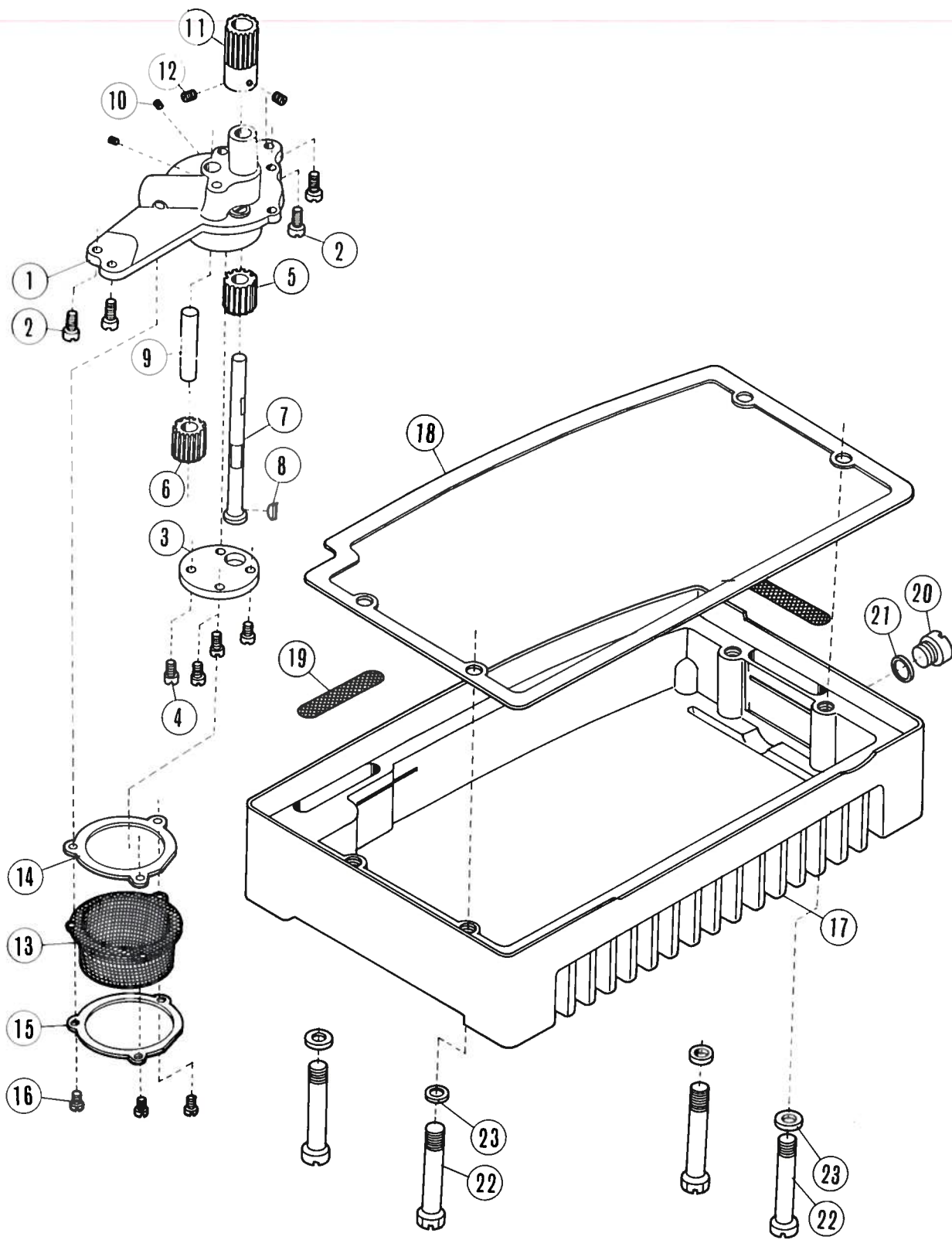


PRESSER FOOT AND LIFTING MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	500/I	500/II
1	323-502-212	202502B	Presser arm		
2	323-600-209	5214	" " screw	x	x
3	323-525-202	202505	" " swing-out connection	x	x
4	323-600-047	5164	" " " " hinge screw	x	x
5	323-680-002	201141	" " " " " " collar	x	x
6	323-740-026	202575A	" " " " " " bracket	x	x
7	323-600-265	5266	" " " " " " screw	x	x
8	323-540-203	202574	Foot lift lever shaft	x	x
9	323-615-201	202576	" " " " " " thrust washer	x	x
10	323-633-200	202577	" " " " " " retaining ring	x	x
11	323-676-207	202589	" " " " " " bushing (3)	x	x
12	323-850-242	202578	Presser arm guide	x	x
13	323-600-057	5117	" " " " " " screw	x	x
14	323-683-201	202503	" " " " " " regulator	x	x
15	323-600-209	5214	" " " " " " screw	x	x
16	323-716-209	202683	" " " " " " stopper	x	x
17	323-600-096	5345	" " " " " " screw	x	x
18	323-600-213	5258	" " " " " " regulating screw (eccentric)	x	x
19	323-630-202	5137	" " " " " " nut	x	x
20	323-873-200	202451	Chain cutter knife	x	x
21	323-600-026	2921	" " " " " " screw	x	x
22	* 323-685-232	202504A	Presser foot holder	x	x
23	323-600-014	4009-1	" " " " " " clamp screw	x	x
24	* 323-820-xxx		" " " " " " foot	x	x
25	* 323-863-xxx		" " " " " " chaining-off finger	x	x
26	323-600-050	5089	" " " " " " screw	x	x
27	* 323-854-xxx		" " " " " " fabric guard	x	x
28	323-600-051	1231	" " " " " " screw	x	x
29	* 323-560-xxx		" " " " " " uncurler	x	x
30	323-600-202	5030	" " " " " " screw	x	x
31	323-643-001	201156	" " " " " " hinge spring	x	x
32	323-716-211	202512A	" " " " " " regulator	x	x
33	323-600-016	1229	" " " " " " screw	x	x
34	323-850-202	202507	" " " " " " bar	x	x
35	323-640-002	201148A	" " " " " " spring	x	x
36	323-740-025	202518A	" " " " " " housing	x	x
37	323-600-216	2903	" " " " " " screw (2)	x	x
38	323-600-204	202510	Pressure regulating thumb screw	x	x
39	323-630-224	202871	" " " " " " lock nut	x	x
40	323-530-201	202511	Hand lift lever	x	x
41	323-600-211	5256	" " " " " " screw	x	x
42	323-530-222	201160B	Foot lift lever	x	x
43	323-618-209	202868	" " " " " " hinge pin washer	x	x
44	323-604-008	201161	" " " " " " pin	x	x
45	323-600-043	2022	" " " " " " screw	x	x
46	323-643-210	201162A	" " " " " " spring	x	x
47	323-530-007	201163	" " " " " " intermediate lever	x	x
48	323-680-003	201164A	" " " " " " collar	x	x
49	323-600-043	2022	" " " " " " screw	x	x
50	323-600-022	2022-4	" " " " " " " " (hex. head)	x	x
51	323-730-004	201165	" " " " " " lever connecting pin	x	x
52	323-622-001	201166	" " " " " " split-pin (2)	x	x
53	323-740-021	201167A	" " " " " " bracket	x	x
54	323-600-054	5142	" " " " " " screw (2)	x	x
55	323-600-055	5097	" " " " " " regulating screw (2)	x	x
56	323-630-001	3044	" " " " " " nut (2)	x	x

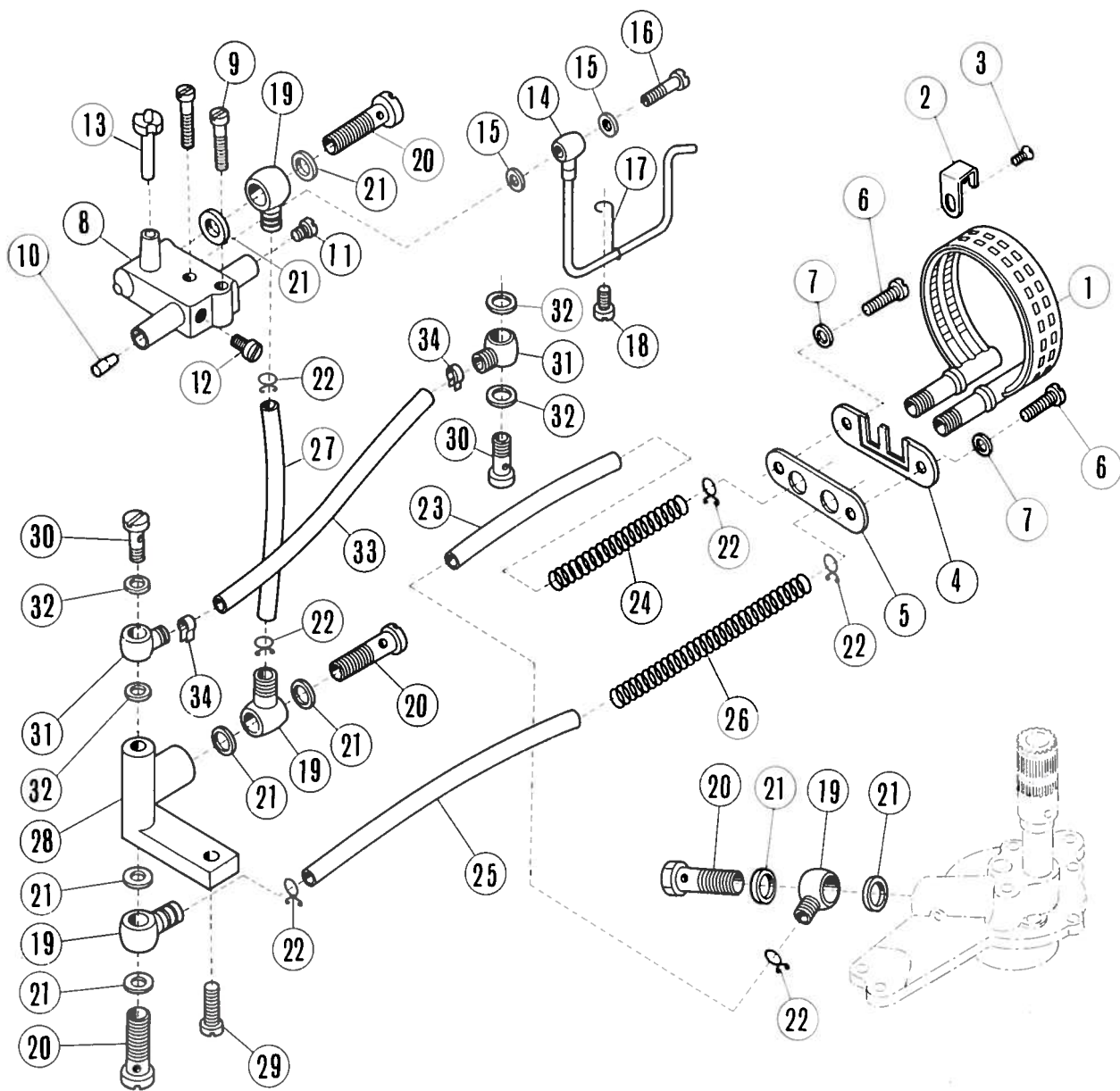
*See organization chart.

**See additional organization chart.



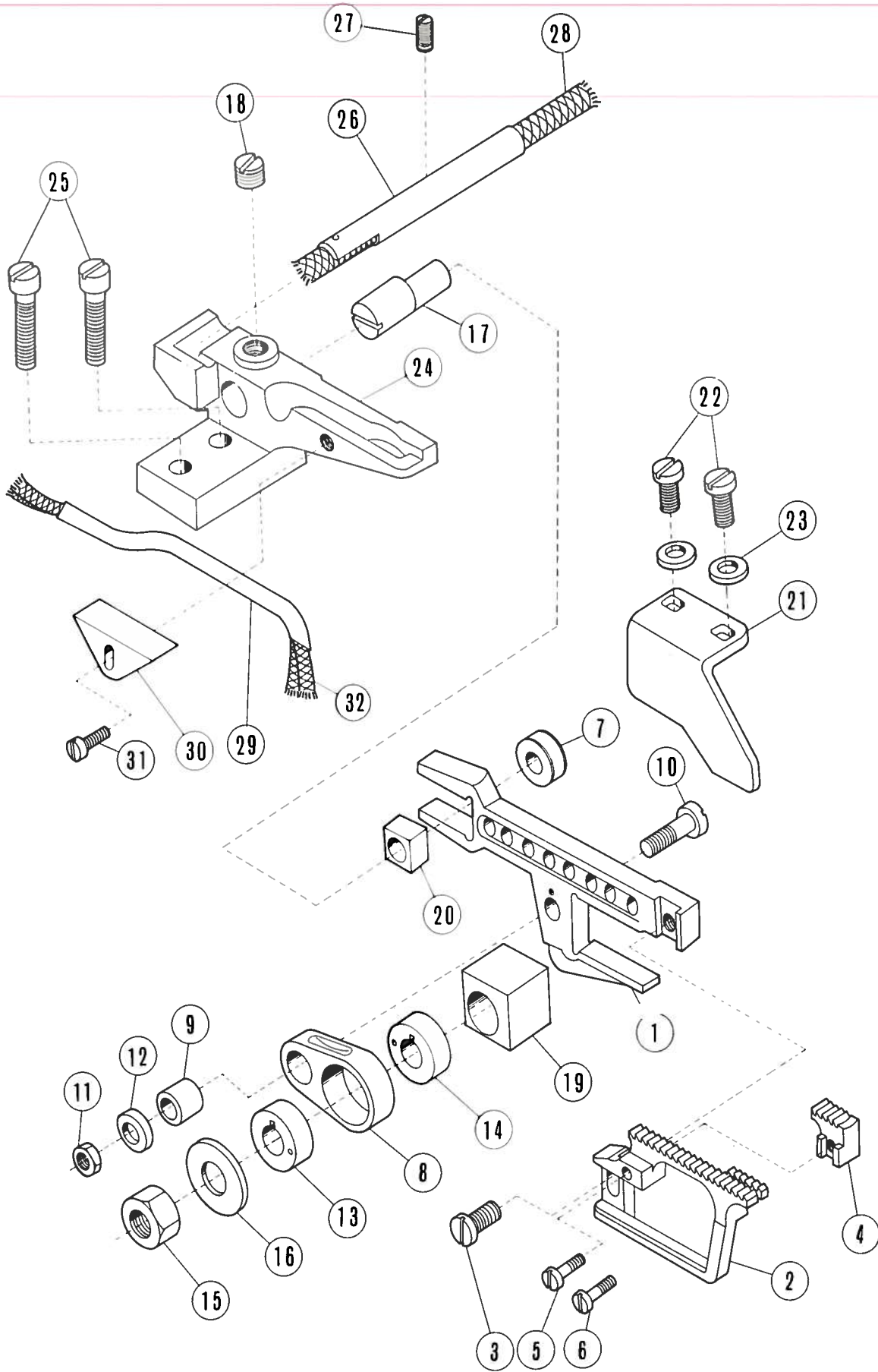
(1) PUMP LUBRICATING MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	500/I	500/II
1	323-900-001	201288A	Gear pump	x	x
2	323-600-056	2213-1	" " screw (4)	x	x
3	323-800-006	201293A	" " casing plate	x	x
4	323-600-057	5117	" " " " screw (4)	x	x
5	323-764-001	201294	Pump gear (right)	x	x
6	323-764-002	201295	" " (left)	x	x
7	323-540-007	201296	" " shaft (long)	x	x
8	323-649-001	201009	" " " " key	x	x
9	323-540-008	201297	" " " (short)	x	x
10	323-600-037	1458	" " " " screw (2)	x	x
11	323-570-001	201299	Worm wheel	x	x
12	323-600-004	5060	" " screw (2)	x	x
13	323-655-002	201338	Oil screen filter	x	x
14	323-663-001	201311	" " " gasket	x	x
15	323-508-002	201341	" " " frame	x	x
16	323-600-002	1175-2	" " " screw (3)	x	x
17	323-713-001	201334B	" pan	x	x
18	323-663-004	201335	" " gasket	x	x
19	323-800-009	201487	" filter plate (2)	x	x
20	323-600-354	5138B	" drain plug screw	x	x
21	323-615-229	202287A	" " " " washer	x	x
22	323-605-006	5150B	" pan bolt (4)	x	x
23	323-615-029	204806	" " " washer (4)	x	x



(2) PUMP LUBRICATING MECHANISM

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION	500/I	500/II
1	323-900-002	201342B	Oil cooler assembly	x	x
2	323-683-004	201345A	" " clamp	x	x
3	323-600-059	3001	" " " screw	x	x
4	323-800-008	201315	" " plate	x	x
5	323-663-002	201316	" " " gasket	x	x
6	323-600-061	5152	" " " screw (2)	x	x
7	323-615-009	200149	" " " " washer (2)	x	x
8	323-635-204	201321A	" distributor	x	x
9	323-600-038	5095	" " screw (2)	x	x
10	323-627-208	202903	" " oil plug	x	x
11	323-600-062	201323	" " " splash screw	x	x
12	323-600-063	201324	" " " " screw	x	x
13	323-891-204	202794	" splash indicator	x	x
14	323-639-006	201327	Worm wheel oil tube	x	x
15	323-615-010	201759	" " " " connector screw washer (2)	x	x
16	323-600-064	201758	" " " " " screw	x	x
17	323-685-201	202208	" " " " clamp	x	x
18	323-600-057	5117	" " " " " screw	x	x
19	323-636-001	201300	Oil distributing tube connector (4)	x	x
20	323-600-058	201301	" " " " screw (4)	x	x
21	323-615-008	201302	" " " " " washer (8)	x	x
22	323-683-002	201303	" " " " clamp (6)	x	x
23	323-639-009	201319	" pump tube	x	x
24	323-683-003	201304	" " " spring	x	x
25	323-639-014	202929	" distributing tube	x	x
26	323-640-004	202930	" " " spring	x	x
27	323-683-012	202931	" " tube	x	x
28	323-635-002	202928	" distributor	x	x
29	323-600-200	1156	" " screw	x	x
30	323-604-209	200152	" " oil splash screw (2)	x	x
31	323-636-200	200136	" " " tube connector (2)	x	x
32	323-615-209	200138	" " " " " washer (4)	x	x
33	323-639-016	200134A	" " " tube	x	x
34	323-685-003	202199	" " " " clamp (2)	x	x



PLAIN FEED MECHANISM

503/I-4. 503/I-8.

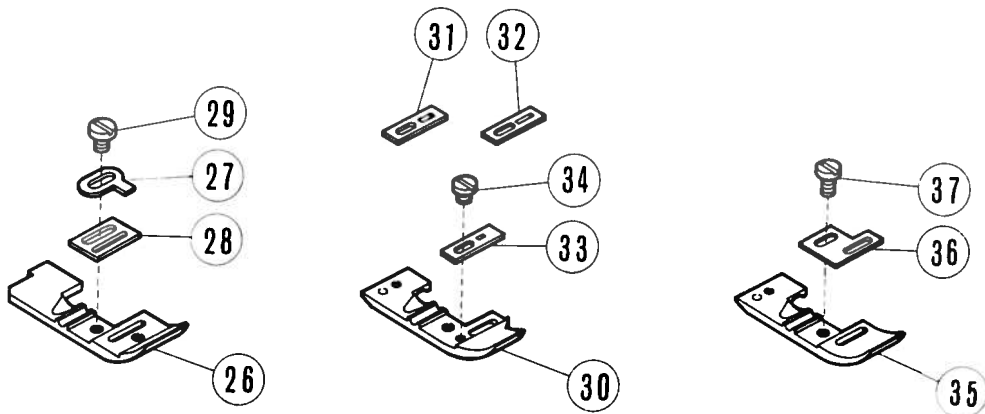
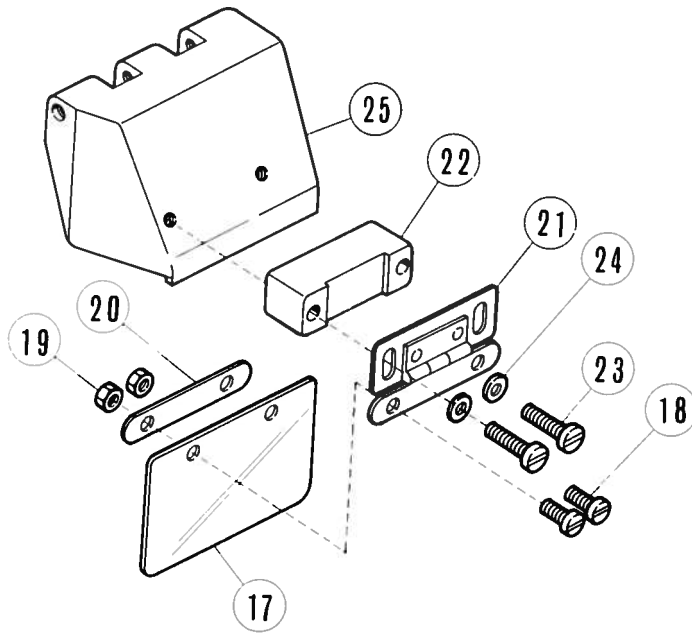
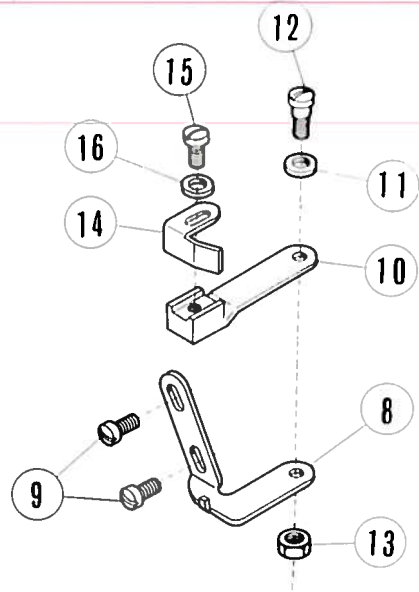
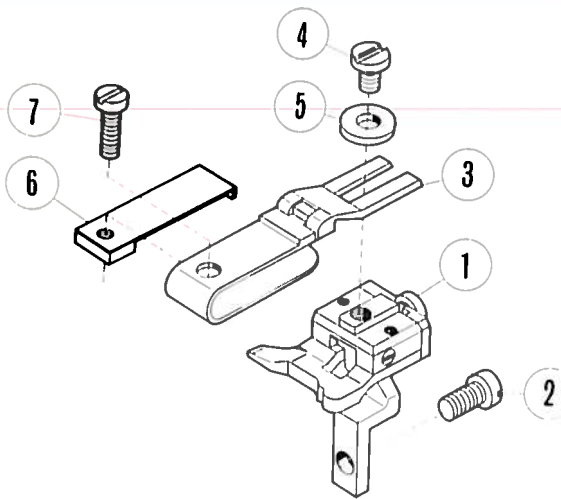
503/II-4. 503/II-8.

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION
1	323-593-001	201093A	Plain feed bar
2	* 323-830-xxx		" " dog
3	* 323-600-032	1202	" " " screw
4	323-830-xxx		Auxiliary feed dog
5	323-600-035	5086	" " " screw – 503/I, /II-8
6	323-600-093	5335	" " " screw – 503/I, /II-4
7	323-850-204	202566	Plain feed bar spacer
8	323-730-002	201098	" " " connecting link
9	323-676-200	202567	" " " " " bushing
10	323-600-205	202310	" " " " " " screw
11	323-630-001	3044	" " " " " " " nut
12	323-615-002	200098	" " " " " " " washer
13	323-680-200	202568	" " " " " collar
14	* 323-580-xxx		" " eccentric
15	323-630-016	5213	" " " lock nut
16	323-615-023	202924	" " " " " washer
17	323-620-201	202200	Feed bar tilt adjust pin
18	323-600-043	2022	" " " " " screw
19	323-750-001	201106	" " lift block
20	323-750-002	201107	" " guide block
21	323-850-005	201109	" " " (right)
22	323-600-019	1175-3	" " " " screw (2)
23	323-615-211	167066	" " " " " washer (2)
24	323-850-251	202201A	" " " (left)
25	323-600-038	5095	" " " " screw (2)
26	323-639-003	201110	" " " oil wick tube
27	323-600-037	1458	" " " " " " screw
28	323-653-016	202181	" " " " wick
29	323-639-201	202202	" eccentric oil wick tube
30	323-685-200	202203	" " " " " holder
31	323-600-029	1196	" " " " " " screw
32	323-653-204	202033	" " " wick

*See organization chart.

Not shown

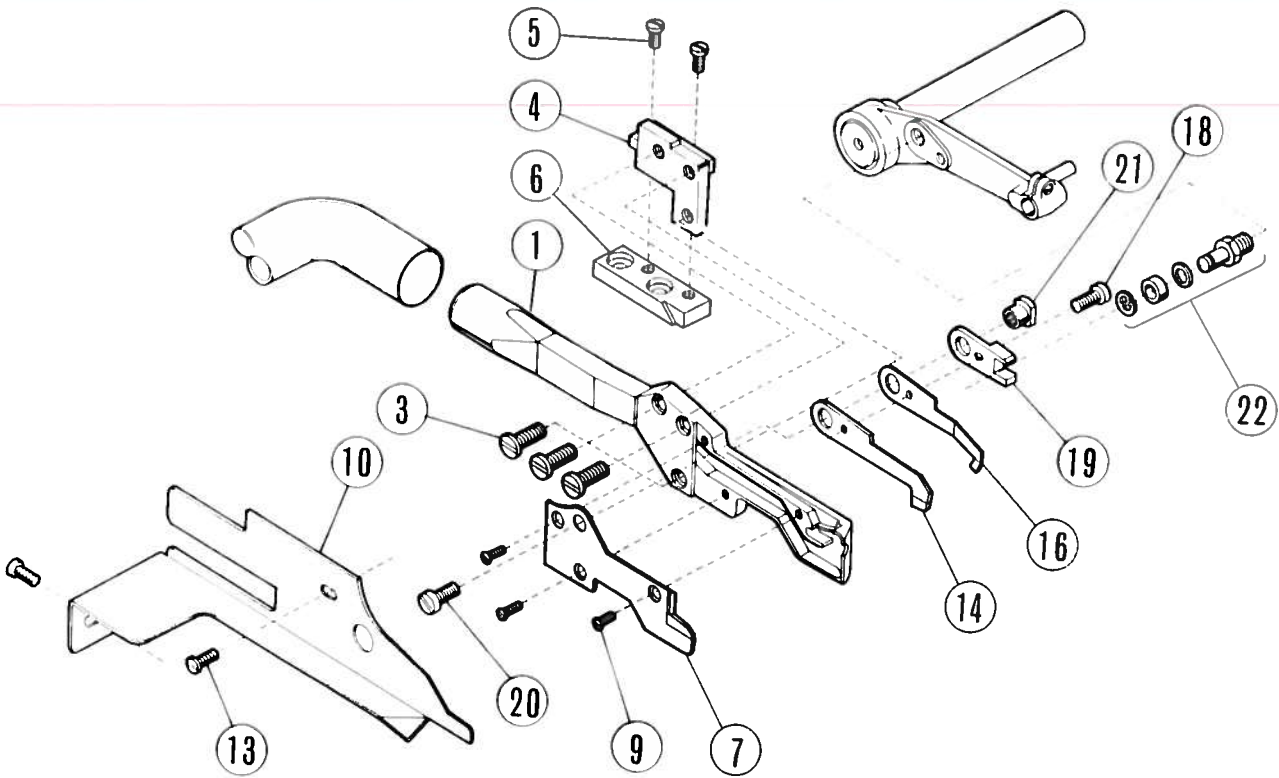
323-510-019	202944	Feed eccentric cover
323-686-008	202943	Crankshaft bearing (left) retainer



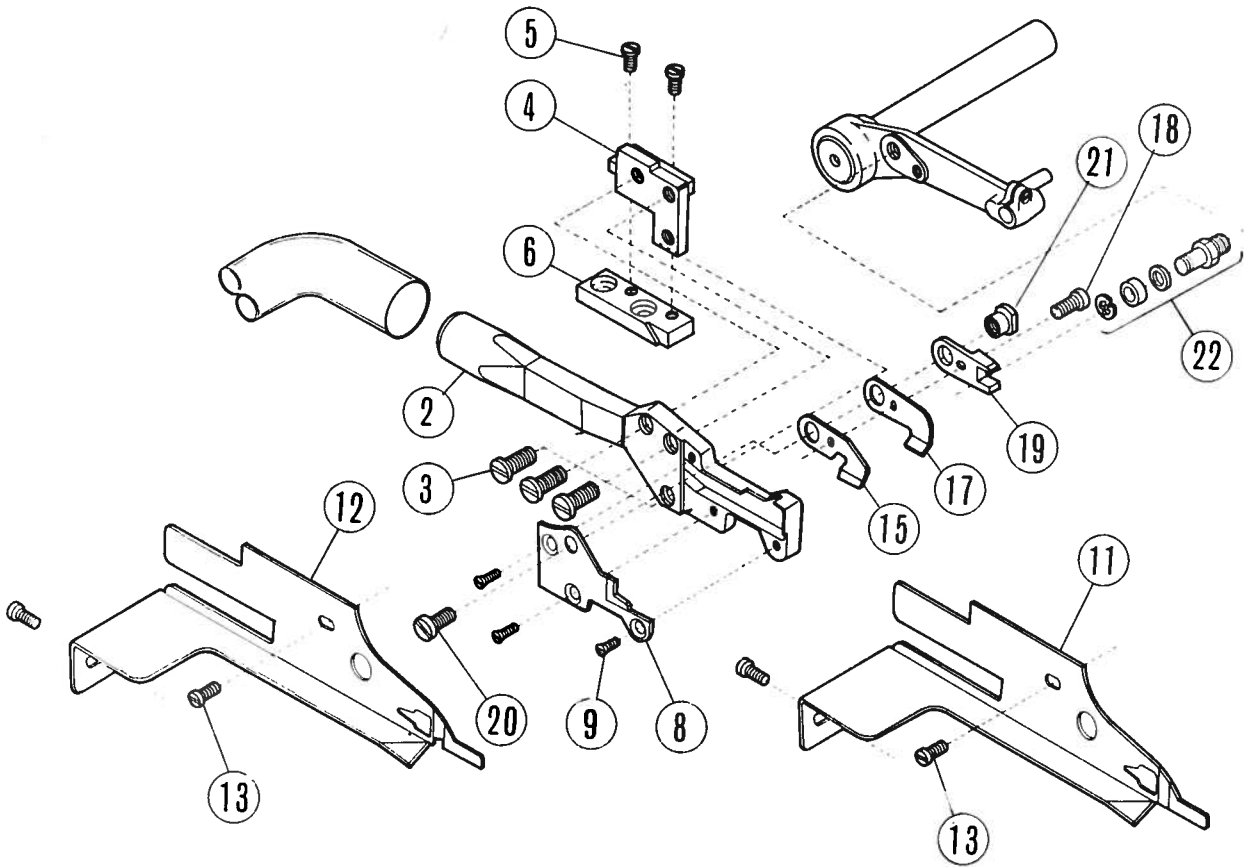
ATTACHMENTS

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION
Welt guide assembly – 503/I-25. 503/II-25.			
1	323-505-002	201206	Welt guide holder
2	323-600-002	1175.2	" " " screw
3	323-400-001	201211A	" guide
4	323-600-074	2905	" " screw
5	323-615-017	137142	" " " washer
6	323-758-004	202281	" " extension
7	323-600-074	2905	" " " screw
Edge guide assembly – 503/I-4 & -8. 503/II-4 & -8.			
	323-850-012	201500	Edge guide, complete with parts of Ref. Nos. 8-16
8	323-740-011	201232A	" guide arm holder
9	323-600-032	1202	" " " " screw
10	323-740-012	201485	" " arm
11	323-615-015	201191	" " " screw washer
12	323-600-079	5184	" " " screw
13	323-630-010	5074	" " " " nut
14	323-850-013	201233A	" guide
15	323-600-032	1202	" " screw
16	323-615-018	137906	" " " washer
Eye guard assembly – all 500/I & 500/II			
	323-561-020	205355	Eye guard, complete with parts of Ref. Nos. 17-24
17	323-561-019	204924	" guard
18	323-600-073	2918	" " screw (2)
19	323-630-009	5099	" " " nut (2)
20	323-615-032	204925	" " " " washer
21	323-728-013	205345	" " hinge
22	323-505-013	205344	" " " base
23	323-600-126	5405	" " " " screw (2)
24	323-615-013	200821	" " " " " washer (2)
25	323-510-071	205340	Upper knife cover
Presser foot assembly for tape and elastic braid.			
26	323-820-028	205314	Presser foot
27	323-850-033	205315	" " tape guide – 2.7 ~ 9mm tape width
28	323-740-039	205316	" " " " bracket
29	323-600-026	2921	" " " " " screw
30	323-820-029	205328	" foot
31	323-850-034	205330	" " tape guide – 2.7mm tape width
32	323-850-035	205331	" " " " – 4.4mm tape width
33	323-850-036	205332	" " " " – 5.0mm tape width
34	323-600-307	5077	" " " " screw
35	323-820-030	205329	" foot
36	323-850-037	205333	" " tape guide – 9.0mm tape width
37	323-600-124	5366	" " " " screw

KSR-570



KSR-571 AND KSR-572



CHAIN CUTTER MODELS KSR-570, KSR-571 AND KSR-572

REF. NO.	NEW PRODUCT		DESCRIPTION	K S R -		
	CODE NO.	OLD NO.		570	571	572
1	323-508-010	205280	Chain cutter frame	x		
2	323-508-011	300111	" " frame		x	x
3	323-600-301	1189	" " " screw (3)	x	x	x
4	323-740-048	300045	" " " bracket	x	x	x
5	323-600-353	5205	" " " " screw (2)	x	x	x
6	323-505-014	300046	" " " " base	x	x	x
7	323-873-007	300047	Stationary blade	x		
8	323-873-008	300112	" blade		x	x
9	323-600-251	5022	" " screw (3)	x	x	x
10	323-560-030	300056	" " fabric guard	x		
11	323-560-031	300115	" " " guard		x	
12	323-560-032	300116	" " " guard			x
13	323-600-068	1216	" " " " screw (2)	x	x	x
14	323-873-009	300048	Movable blade	x		
15	323-873-010	300113	" blade		x	x
16	323-643-009	300050	" " spring	x		
17	323-643-010	300114	" " spring		x	x
18	323-600-246	1186	" " screw	x	x	x
19	323-850-042	300051	" " guide	x	x	x
20	323-600-014	4009-1	" " " screw	x	x	x
21	323-630-026	300049	" " " " nut	x	x	x
22	323-620-031	300135	" " " pin	x	x	x

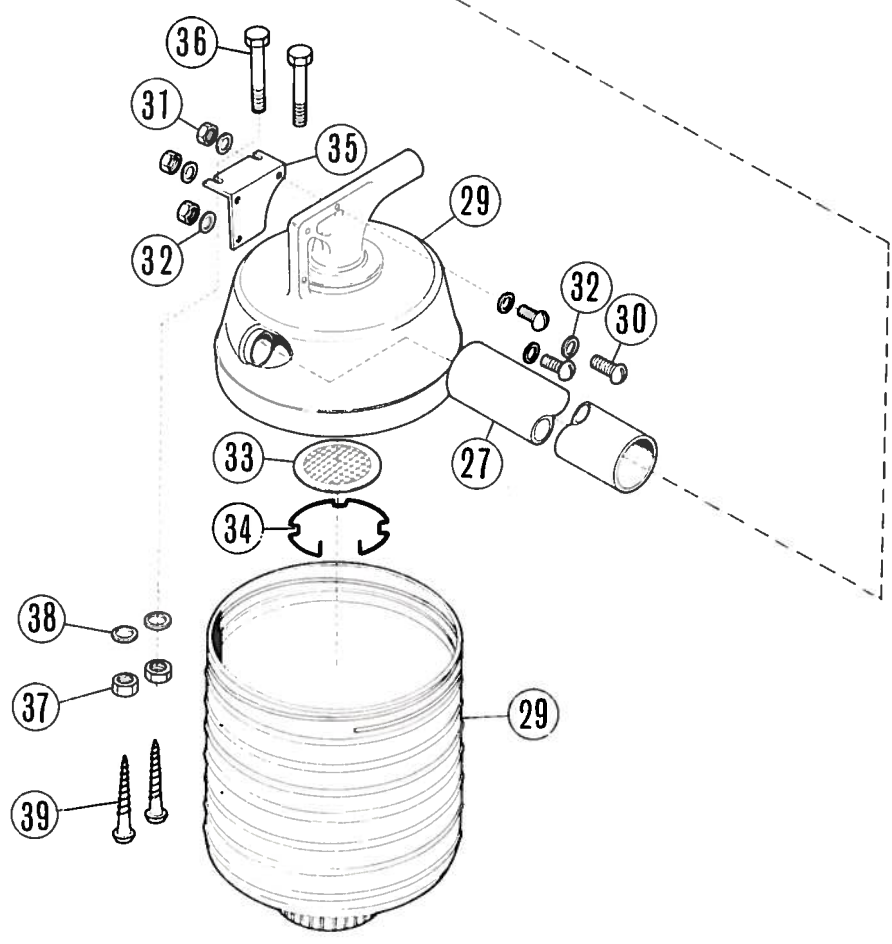
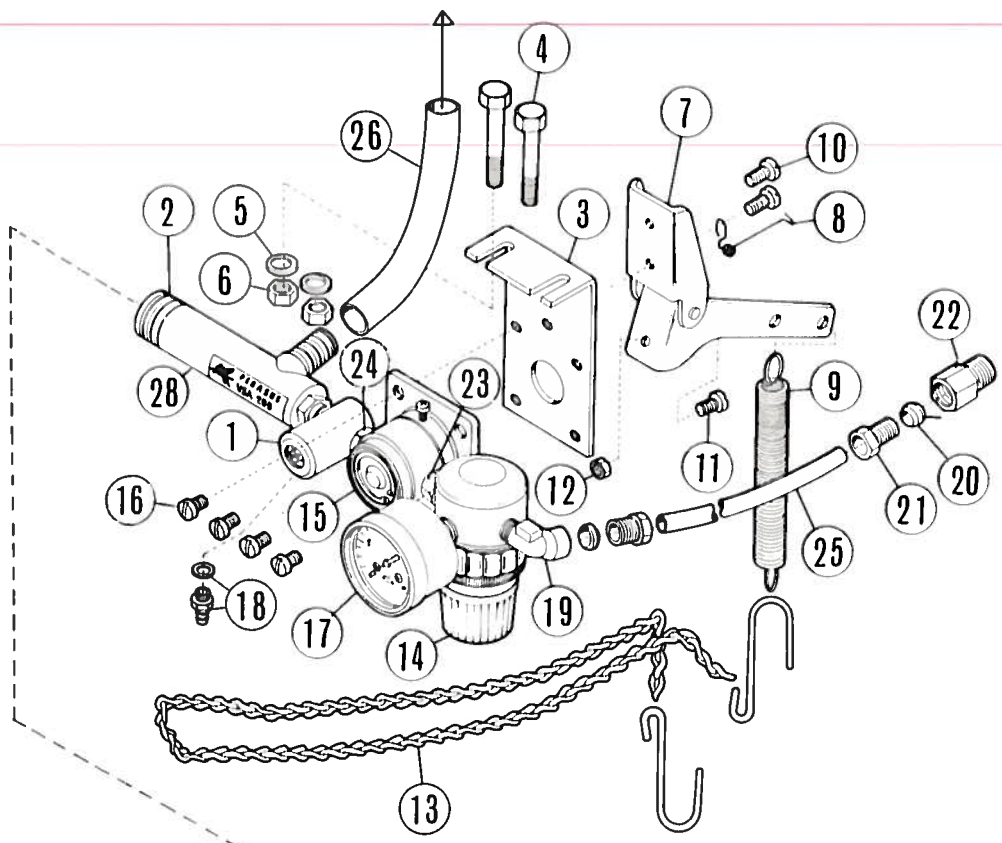
Replace machine parts with the followings before installing chain cutter on machine.

323-500-007	205274	Machine arm
323-510-067	300061	" top cover (right), for 1-needle machine
323-510-068	300062	" " " (right), for 2-needle machine
323-540-023	205273	Needle drive shaft
323-502-008	205266	" " arm, for 1-needle machine
323-502-009	205267	" " arm, for 2-needle machine 2.0mm needle gauge
323-502-010	205268	" " arm, for 2-needle machine 3.0mm needle gauge
323-866-010	205270	" thread takeup
323-851-015	205263	" " guide
323-851-016	205264	" " eyelet
323-850-043	205265	Left looper thread guide (rear)

CHAIN CUTTER CLASSIFICATION

	<u>KSR-570</u>	<u>KSR-571</u>	<u>KSR-572</u>		<u>KSR-570</u>	<u>KSR-571</u>	<u>KSR-572</u>
504/I-5	x			504/II-5	x		
504/I-45			x	504/II-45			x
504/I-43			x	504/II-43			x
504/I-47			x	504/II-47			x
514/I-41			x	514/II-41			x
514/I-42			x	514/II-42			x
503/I-4	x			503/II-4	x		
503/I-8		x		503/II-8		x	
503/I-25	x			503/II-25	x		
504/I-1	x						
504/I-9-27	x						
504/I-10	x						

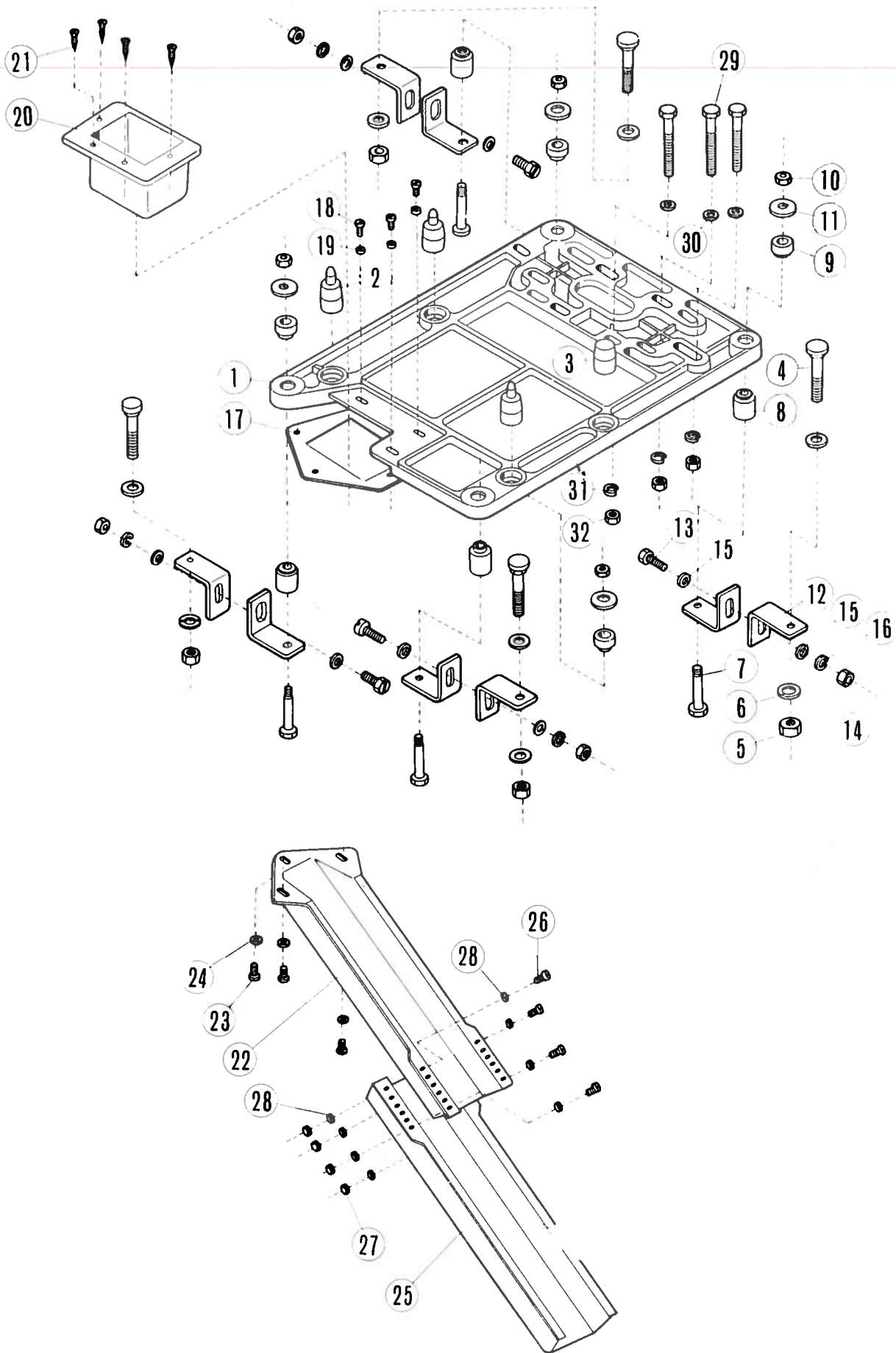
For more information on Chain Cutter, see its instruction book.



SUCTION DEVICE MODEL VSA-200 FOR CHAIN CUTTER

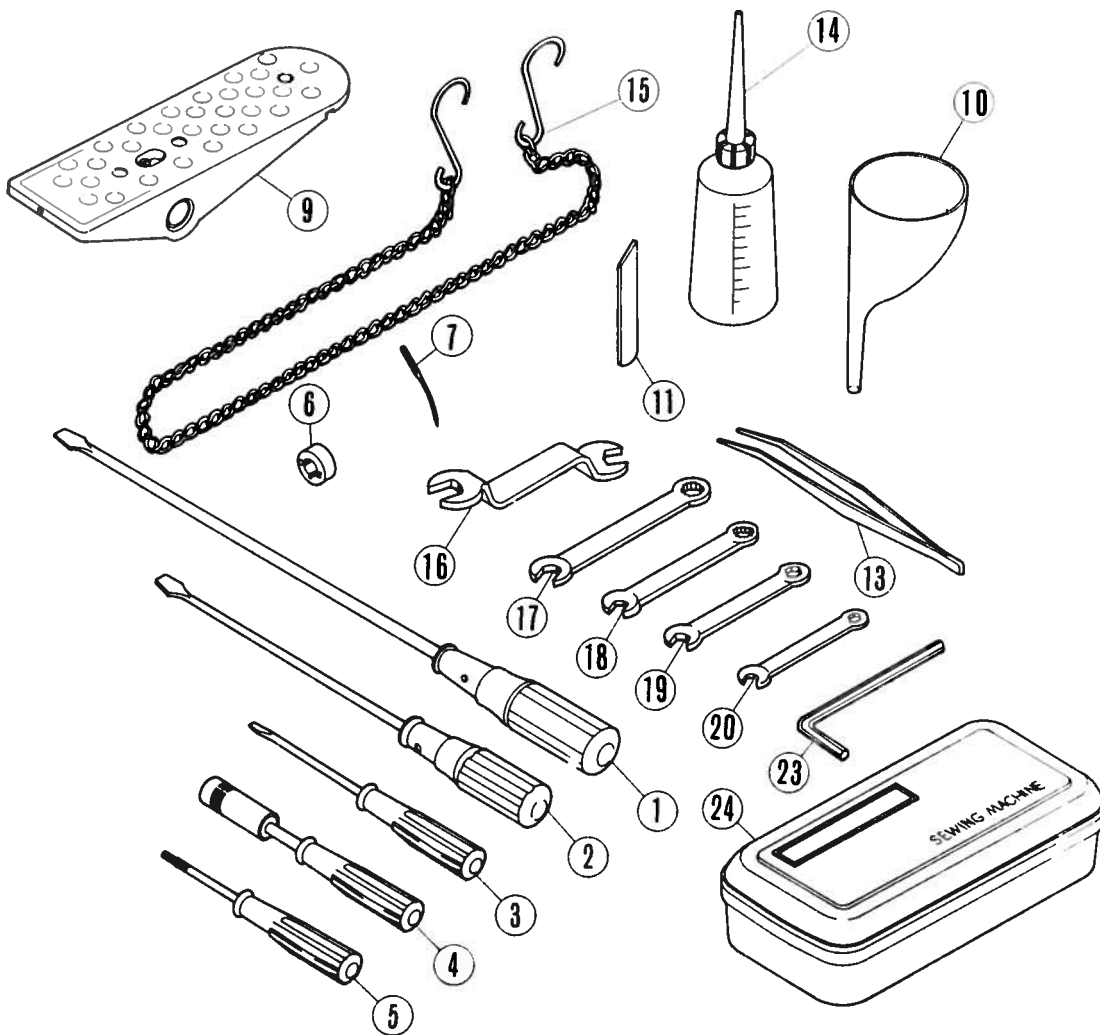
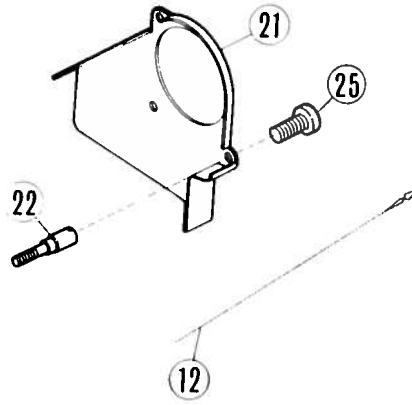
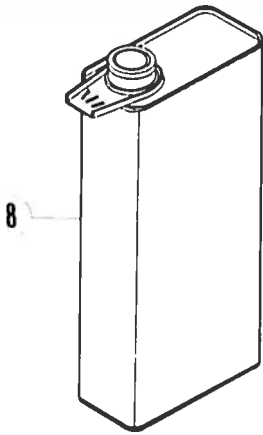
REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION
1	323-736-003	300027	Needle valve
2	323-651-001	300033	Venturi
3	323-740-044	300037	Air valve bracket
4	323-600-367	5344	" " " screw (2)
5	323-615-021	204585	" " " " washer (2)
6	323-630-013	5348	" " " " nut (2)
7	323-716-006	300038	Actuator
8	323-640-017	300042	" hinge spring
9	323-640-018	300043	" spring
10	323-600-014	4009-1	" screw (2)
11	323-600-027	1174	" stop screw
12	323-630-003	3091	" " " nut
13	323-732-001	126	" chain
14	323-716-007	522001	Air regulator
15	323-736-004	530001	" valve
16	323-600-039	5113	" " screw (4)
17	323-891-003	596002	" pressure gauge
18	323-636-006	601001	" valve joint
19	323-636-007	601011	Elbow
20	323-635-003	601012	Sleeve (2)
21	323-636-011	601013	Nipple joint, for 600005
22	323-636-008	601014	Nipple, for 600005
23	323-636-009	601015	Air valve nipple (right)
24	323-636-010	601016	" " " (left)
25	323-639-023	600005	Vinyl tube
26	323-639-024	600006	Suction tube
27	323-639-025	600007	Exhaust tube
28	323-692-028	300044	Model plate
29	323-900-027	300104	Waste receptacle complete
30	323-600-364	5354	" " screw (3)
31	323-630-022	5367	" " " nut (3)
32	323-615-012	201185	" " " " washer (6)
33	323-655-009	300107	Air filter
34	323-634-005	300108	" " stop ring
35	323-740-045	300109	Waste receptacle bracket
36	323-605-003	5347	" " " bolt (2)
37	323-630-013	5348	" " " " nut (2)
38	323-615-021	204585	" " " " " washer (2)
39	323-600-101	5341	" " " wooden screw (2)

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



MOUNTING ACCESSORIES

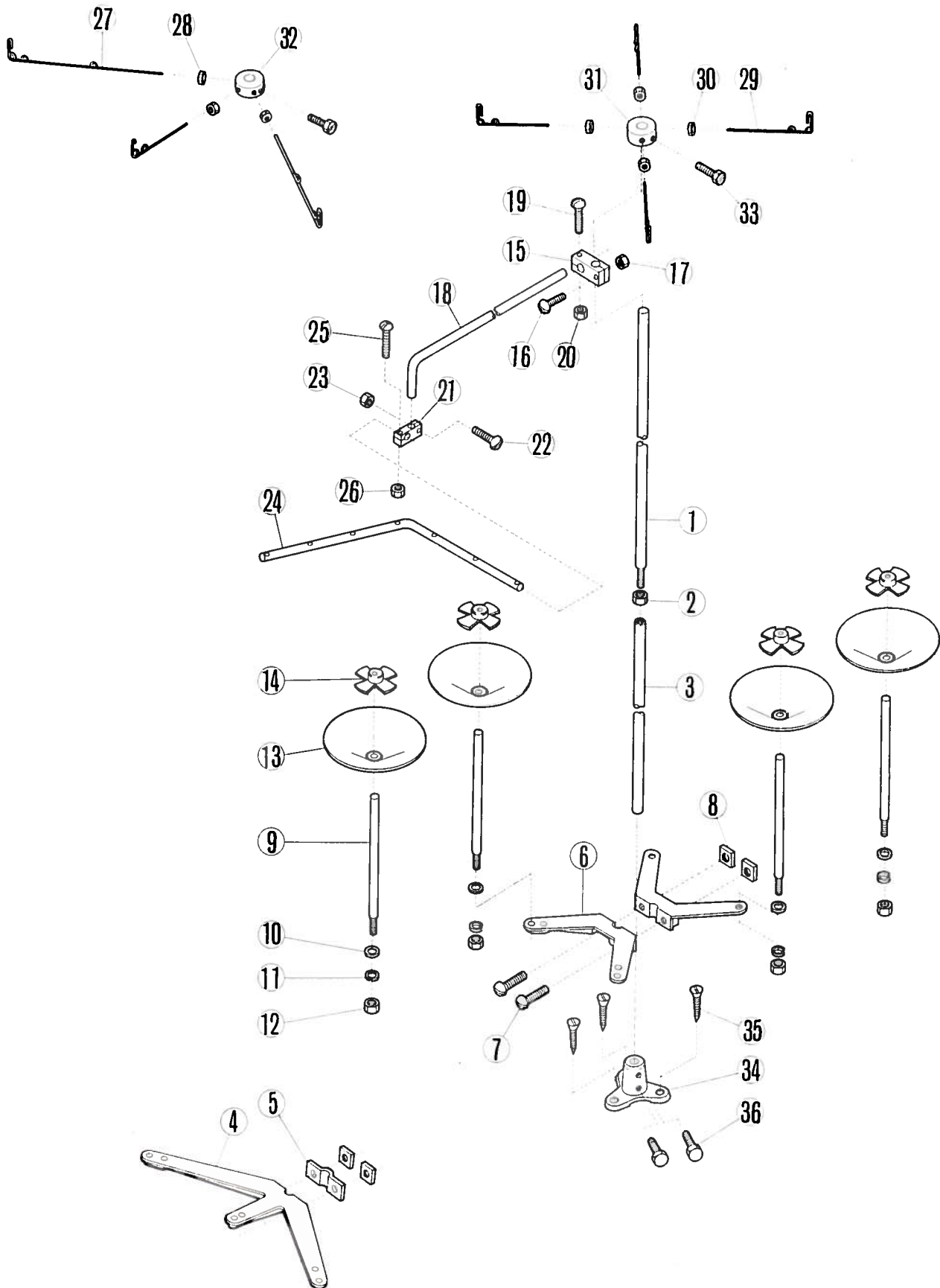
REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION
1	323-945-210	202697C	Machine rest board
2	323-945-202	202691	" cushion rubber (3)
3	323-945-209	202761	" " rubber
4	323-605-202	204303	" rest board hanger bolt (4)
5	323-630-204	5221	" " " " " nut (4)
6	323-615-203	202700	" " " " " washer (4)
7	323-605-203	202766	" " " set bolt (4)
8	323-945-208	202693A	" " " cushion rubber (lower) (4)
9	323-627-204	202765	" " " " " (upper) (4)
10	323-630-229	5298	" " " set bolt nut (4)
11	323-615-220	202767	" " " " " washer (4)
12	323-740-223	202768	" " " hanger bracket (8)
13	323-600-324	5296	" " " " " screw (4)
14	323-630-228	5297	" " " " " nut (4)
15	323-615-219	202769	" " " " " washer (8)
16	323-616-001	201477	" " " " " washer (4)
17	323-800-219	202715A	Waste chute bracket
18	323-600-057	5117	" " " screw (3)
19	323-615-002	200098	" " " " washer (3)
20	323-740-013	201346A	" " top
21	323-600-321	175	" " " screw (4)
22	323-774-001	201348B	" chute
23	323-600-057	5117	" " screw (3)
24	323-615-002	200098	" " " washer (3)
25	323-774-200	201349B	" " extension
26	323-600-060	5118	" " " screw (4)
27	323-630-001	3044	" " " nut (4)
28	323-615-002	200098	" " " washer (8)
29	323-605-204	5302	Motor hanger bolt (3)
30	323-615-219	202769	" " " washer (6)
31	323-616-001	201477	" " " washer (3)
32	323-630-228	5297	" " " nut (3)



ACCESSORIES

REF. NO.	NEW PRODUCT CODE NO.	OLD NO.	DESCRIPTION
1	323-885-001	127	Screwdriver (large)
2	323-885-002	128	" (medium)
3	323-885-003	129	" (small)
4	323-880-212	152	Socket wrench
5	323-945-001	154	Feed eccentric extractor
6	* 323-580-xxx		" eccentric
7	* 423-xxx-xxx		Needle
8	323-945-002	133	Oil container – 750cc
9	323-533-001	121	Treadle
10	323-945-003	135A	Oil funnel
11	* 323-870-xxx		Lower knife
12	323-660-200	153	Threading wire
13	323-886-001	131	Tweezers
14	323-659-200	132	Oiler
15	323-732-001	126	Treadle chain
16	323-880-006	130A-12-14	Wrench (12.0mm & 14.0mm)
17	323-880-211	130A-9.5	" (9.5mm)
18	323-880-209	130A-7	" (7.0mm)
19	323-880-208	130A-6	" (6.0mm)
20	323-880-200	130A-5	" (5.0mm)
21	323-945-005	205216	Belt guard
22	323-600-117	205217	" " fixing screw
23	323-880-005	200	Allen key
24	323-945-006	201	Accessory box
25	323-600-057	5117	Belt guard screw

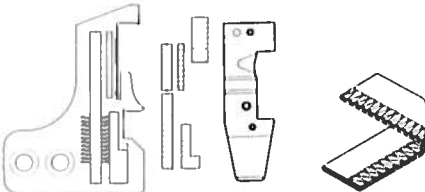
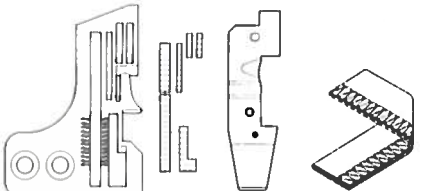
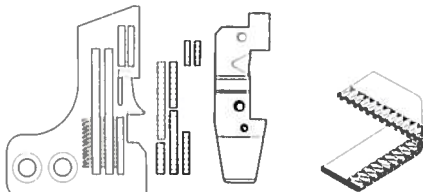
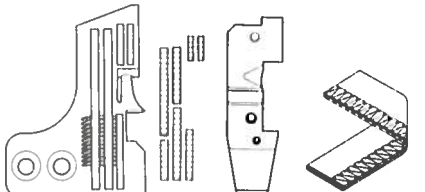
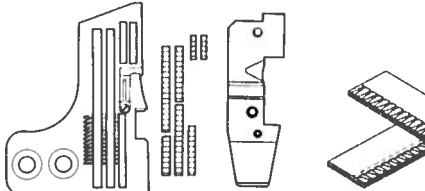
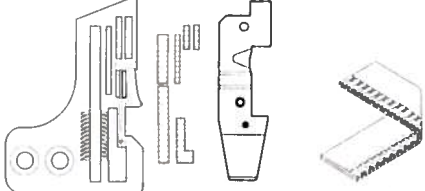
*See organization chart.



THREAD STAND

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

ORGANIZATION CHART

Machine model (operation)	Gauge (millimeter) (inch)	Needle plate	Main feed	Auxiliary feed	Differential feed	Right looper	Cloth plate fabric guard
504/I-5							
Seaming and closing on knits.							
	3mm 1/8"	202684 801-018	201094B 830-001	202634A 830-252	202854A 830-333	201067A 810-001	202513B 560-024
	4mm	202685	"	"	"	"	"
	5/32"	801-019	"	"	"	"	"
504/I-45							
Seaming and closing knit and woven fabrics. For stretching action, use accessory eccentrics.							
	3mm 1/8"	205231 801-344	202798 830-332	---	"	"	202795A 560-025
	4mm	205232	"	---	"	"	"
	5/32"	801-345	"	---	"	"	"
504/I-43							
Seaming and closing knit goods.							
	3mm 1/8"	205235 801-340	205249 830-330	---	202535C 830-331	"	"
	4mm	205236	"	---	"	"	"
	5/32"	801-341	"	---	"	"	"
504/I-47							
Edging and seaming medium weight woven and knit fabrics.							
	3mm 1/8"	205239 801-360	205250 830-255	---	202544D 830-256	201287A 810-004	"
	4mm	205240	"	---	"	"	"
	5/32"	801-361	"	---	"	"	"
514/I-41							
2-needle seaming on stretch fabrics.							
	2x4mm 5/64x5/32"	205243 801-364	"	---	"	201067A 810-001	"
514/I-42							
2-needle seaming on stretch fabrics.							
	1.5x3mm 1/16x1/8"	202981 801-354	202798 830-332	---	202854A 830-333	"	"
	2x3mm 5/64x1/8"	202982 801-355	"	---	"	"	"
	2x4mm 5/64x5/32"	202983 801-356	"	---	"	"	"

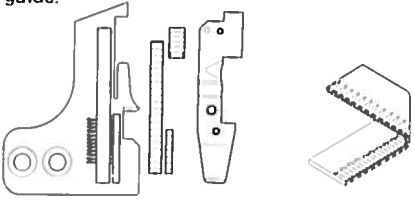
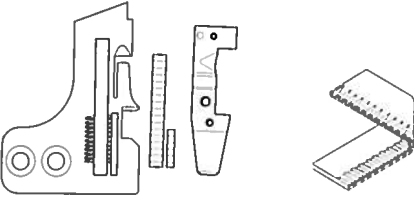
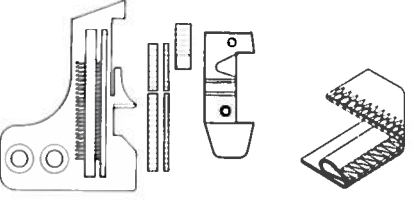
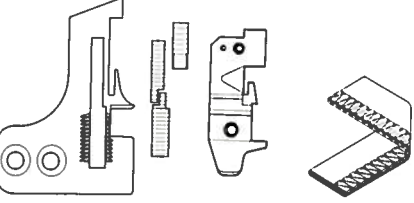
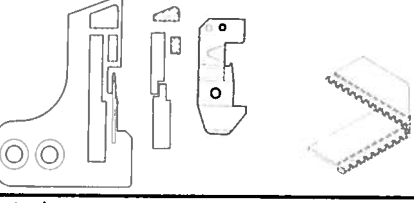
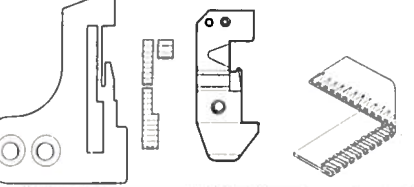
Note: All product code numbers begin with prefix 323-

COMMON PARTS: Left looper 201085B 323-810-002

Presser foot body	chaining off finger	uncurler	fabric guard	Needle guard (front)	Needle guard (rear)	Upper knife	Lower knife	Feed eccentric in machine main diff.	Feed eccentric in accessory main diff.	Needle (factory setting) Singer Willcox & Gibbs Metric	Attachment on machine (optional item)		
201230C 820-019	201224B 863-007	205342 560-021	201265B 854-200	201248B 561-205	201249B 561-206	201121A 870-214	201127 870-211	10	10	8	12	UOx154 #11 423203231	Chain cutter
"	"	"	"	"	"	"	202295 870-210						
202799 820-286	"	"	"	"	"	"	201127 870-211	10	10	8	12	UOx154 #11 423203231	Chain cutter
"	"	"	"	"	"	"	202295 870-210						
205252 820-285	"	"	"	"	"	"	201127 870-211	10	10	8	12	UOx154 #11 423203231	Chain cutter
"	"	"	"	"	"	"	202295 870-210						
205253 820-287	"	"	"	"	"	"	201127 870-211	10	10	8	12	UOx154 #16 423204031	Chain cutter
"	"	"	"	"	"	"	202295 870-210						
"	201310A 863-201	"	"	201250B 561-200	201251B 561-201	"	"	10	10	8	12	UNx154 #14 423213631	Chain cutter
202799 820-286	201396B 863-215	"	"	"	"	"	"	10	10	8	12	UNx154 #14 423213631	Chain cutter
"	"	"	"	"	"	"	"						
"	201310A 863-201	"	"	"	"	"	"						

503/I-4. 503/I-8. 503/I-25. 504/I-1. 504/I-9-Z7. 504/I-10.

ORGANIZATION CHART

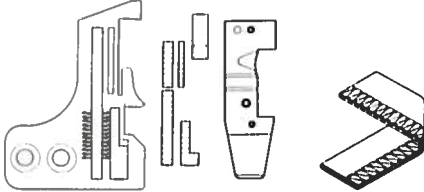
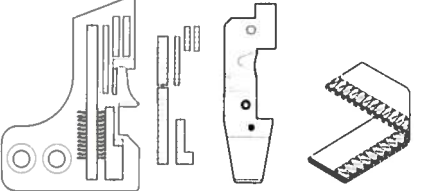
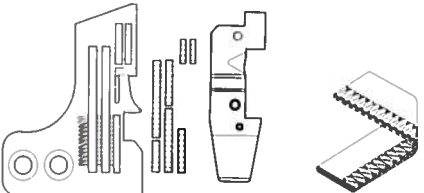
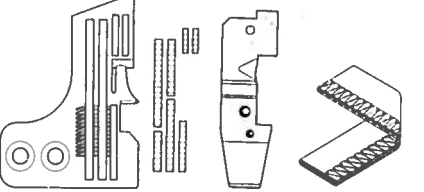
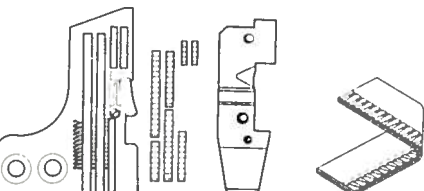
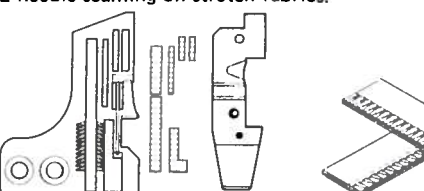
Machine model (operation)	Gauge (millimeter) (inch)	Needle plate	Main feed	Auxiliary feed	Differential feed	Right looper	Cloth plate fabric guard
503/I-4							
Serging woven fabrics with adjustable edge guide.							
	3mm	205357	205356	202671	---	202475	202513B
	1/8"	801-075	830-084	830-018	---	810-013	560-024
	4mm	205358	"	"	---	"	"
	5/32"	801-076	"	"	---	"	"
503/I-8							
Serging woven fabrics with adjustable edge guide.							
	3mm	205365	205364	---	---	"	"
	1/8"	801-079	830-085	---	---	"	"
	4mm	205366	"	---	---	"	"
	5/32"	801-080	"	---	---	"	"
503/I-25							
Blindstitch hemming on light to medium heavy knits.							
	4mm	202618	201094B	202634A	201097C	201234A	"
	5/32"	801-222	830-001	830-252	830-233	810-003	"
504/I-1							
Seaming light weight fabrics.							
	1.6mm	202528A	202529A	"	202530B	201067A	"
	1/16"	801-036	830-200	"	830-039	810-001	"
	2.4mm	202531A	"	"	"	"	"
	3/32"	801-037	"	"	"	"	"
504/I-9-Z7							
Curtain industry. Combined hemming and edging with single down turn.							
	1.6mm	202782	202783	202784	202845A	"	202795A
	1/16"	801-072	830-095	830-066	830-065	"	560-025
504/I-10							
Towel industry. Combined hemming and edging with single up turn.							
	3mm	202582	202584	---	202585A	201287A	202513B
	1/8"	801-213	830-202	---	830-203	810-004	560-024
	4mm	202583	"	---	"	"	"
	5/32"	801-214	"	---	"	"	"

Note: All product code numbers begin with prefix 323-

COMMON PARTS: Left looper 201085B 323-810-002

Presser foot body	chaining- off finger	uncurler	fabric guard	Needle guard (front)	Needle guard (rear)	Upper knife	Lower knife	Feed eccentric in machine main diff.	eccentric in accessory main diff.	Needle (factory setting) Singer Willcox & Gibbs Metric	Attachment on machine (optional item)		
202540B 820-251	201224B 863-007	205342 560-021	201265B 854-200	201248B 561-205	201249B 561-206	201121A 870-214	201127 870-211	6	-	5.5	-	UOx154 #14 423203631	Edge guide Chain cutter
"	"	"	"	"	"	"	202295 870-210						
202549B 820-254	"	"	"	"	"	"	201127 870-211	6	-	5.5	-	UOx154 #14 423203631	Edge guide Chain cutter
"	"	"	"	"	"	"	202295 870-210						
201152E 820-021	201155C 863-212	"	---	"	"	"	"	10	10	8	12	UOx154 #9 423202731	Welt guide Chain cutter
202580 820-200	---	---	---	"	"	202527 870-207	201127 870-211	12	12	10	14	UOx154 #9 423202731	Chain cutter
"	---	---	---	"	"	"	"						
202786 820-031	202787 863-013	---	201265B 854-200	"	"	"	202295 870-210	12	14	16	20	UOx154 #9 423202731	Chain cutter
202586 820-201	202587 420-200	205342 560-021	202588 615-206	"	"	"	"	8	8	10	12	UOx154 #16 423204031	Chain cutter
"	"	"	"	"	"	"	"						

ORGANIZATION CHART

Machine model (operation)	Gauge (millimeter) (inch)	Needle plate	Main feed	Auxiliary feed	Differential feed	Right looper	Cloth plate fabric guard
504/II-5 Seaming and closing on knits.							
	5mm 3/16"	202669 801-234	201094B 830-001	202634A 830-252	202854A 830-333	202874 810-211	202513B 560-024
	6mm 1/4"	202595 801-235	"	"	"	"	"
504/II-45 Seaming and closing knit and woven fabrics. For stretching action, use accessory eccentrics.							
	3mm 1/8"	205231 801-344	202798 830-332	---	"	"	202795A 560-025
	4mm 5/32"	205232 801-345	"	---	"	"	"
	5mm 3/16"	205233 801-346	"	---	"	"	"
	6mm 1/4"	205234 801-347	"	---	"	"	"
504/II-43 Seaming knit goods.							
	3mm 1/8"	205235 801-340	205249 830-330	---	202535C 830-331	"	"
	4mm 5/32"	205236 801-341	"	---	"	"	"
	5mm 3/16"	205237 801-342	"	---	"	"	"
	6mm 1/4"	205238 801-343	"	---	"	"	"
504/II-47 Edging and seaming medium weight woven and knit fabrics.							
	3mm 1/8"	205239 801-360	205250 830-255	---	202544D 830-256	"	"
	4mm 5/32"	205240 801-361	"	---	"	"	"
	5mm 3/16"	205241 801-362	"	---	"	"	"
	6mm 1/4"	205242 801-363	"	---	"	"	"
514/II-41 2-needle seaming on stretch fabrics.							
	2x4mm 5/64x5/32"	205243 801-364	"	---	"	202872 810-214	"
	2x5mm 5/64x3/16"	205244 801-365	"	---	"	"	"
514/II-42 2-needle seaming on stretch fabrics.							
	2x3mm 5/64x1/8"	202982 801-355	202798 830-332	---	202854A 830-333	"	"
	2x4mm 5/64x5/32"	202983 801-356	"	---	"	"	"

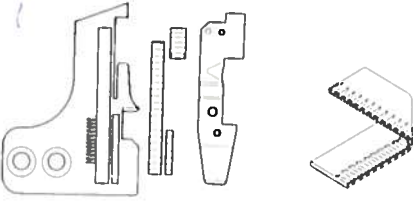
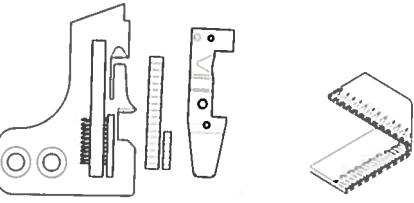
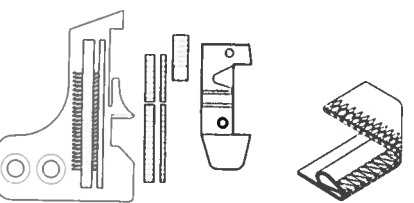
*3x5mm (1/8x3/16") organization – withdrawn from production

Note: All product code numbers begin with prefix 323-

COMMON PARTS: Upper knife 201121A 323-870-214
Left looper 202861 323-810-212

Presser foot body	chaining off finger	uncurler	fabric guard	Needle guard (front)	Needle guard (rear)	Lower knife	Feed eccentric in machine main diff.	Feed eccentric in accessory main diff.	Needle (factory setting) Singer Willcox & Gibbs Metric	Attachment on machine (optional item)	
201230C 820-019	201224B 863-007	205342 560-021	201265B 854-200	201248B 561-205	201249B 561-206	202295 870-210	10	10	8 12	UOx154 #14 423203631	Chain cutter
"	"	"	"	"	"	"					
202799 820-286	"	"	"	"	"	201127 870-211					
"	"	"	"	"	"	"	10	10	8 12	UOx154 #14 423203631	Chain cutter
"	"	"	"	"	"	202295 870-210					
"	"	"	"	"	"	"					
205252 820-285	"	"	"	"	"	201127 870-211					
"	"	"	"	"	"	"	10	10	8 12	UOx154 #14 423203631	Chain cutter
"	"	"	"	"	"	202295 870-210					
"	"	"	"	"	"	"					
205253 820-287	"	"	"	"	"	201127 870-211					
"	"	"	"	"	"	"	10	10	8 12	UOx154 #16 423204031	Chain cutter
"	"	"	"	"	"	202295 870-210					
"	"	"	"	"	"	"					
"	201310A 863-201	"	"	201250B 561-200	201251B 561-201	"	10	10	8 12	UNx154 #14 423213631	Chain cutter
"	"	"	"	"	"	"					
202799 820-286	201396B 863-215	"	"	"	"	"	10	10	8 12	UNx154 #14 423213631	Chain cutter
"	201310A 863-201	"	"	"	"	"					

ORGANIZATION CHART

Machine model (operation)	Gauge (millimeter) (inch)	Needle plate	Main feed	Auxiliary feed	Differential feed	Right looper	Cloth plate fabric guard
503/II-4 Serging woven fabrics with adjustable edge guide. 	3mm 1/8"	205357 801-075	205356 830-084	202671 830-018	---	202842 810-213	202513B 560-024
	4mm 5/32"	205358 801-076	"	"	---	"	"
	5mm 3/16"	205359 801-077	"	"	---	"	"
	6mm 1/4"	205360 801-078	"	"	---	"	"
503/II-8 Serging woven fabrics with adjustable edge guide. 	3mm 1/8"	205365 801-079	205364 830-085	---	---	"	"
	4mm 5/32"	205366 801-080	"	---	---	"	"
	5mm 3/16"	205367 801-081	"	---	---	"	"
	6mm 1/4"	205368 801-082	"	---	---	"	"
503/II-25 Blindstitch hemming on light to medium weight knit. 	2mm 5/64"	202616 801-038	201094B 830-001	202634A 830-252	201097C 830-233	"	"
	3mm 1/8"	202617 801-039	"	"	"	"	"
	4mm 5/32"	202618 801-222	"	"	"	"	"

Note: All product code numbers begin with prefix 323-

COMMON PARTS: Upper knife 201121A 323-870-214
Left looper 202861 323-810-212

Presser foot body	chaining- off finger	uncurler	fabric guard	Needle guard (front)	Needle guard (rear)	Lower knife	Feed eccentric in machine main diff.	Feed eccentric in accessory main diff.	Needle (factory setting) Singer Willcox & Gibbs Metric	Attachment on machine (optional item)		
202540B 820-251	201224B 863-007	205342 560-021	201265B 854-200	201248B 561-205	201249B 561-206	202295 870-210						
"	"	"	"	"	"	"	6	-	5.5	-	UOx154 #14 423203631	Edge guide Chain cutter
"	"	"	"	"	"	"						
"	"	"	"	"	"	"						
202549B 820-254	"	"	"	"	"	201127 870-211						
"	"	"	"	"	"	"	6	-	5.5	-	UOx154 #14 423203631	Edge guide Chain cutter
"	"	"	"	"	"	202295 870-210						
"	"	"	"	"	"	"						
201152E 820-021	201155C 863-212	"	---	"	"	"						
"	"	"	---	"	"	"	10	10	8	12	UOx154 #9 423202731	Welt guide Chain cutter
"	"	"	---	"	"	"						

ADDITIONAL ORGANIZATION CHART

Machine model	Type plate	Machine top cover	drive arm		Needle		clamp stud	shim	Presser foot holder	Left looper thread tension spring	Needle thread tension spring	Lower knife clamp stud
			205266 323-502-008	201031A 323-683-001	202273 323-683-200	201031A 323-683-001						
504/I-5	202558 323-692-206	202514A 323-510-009	205266 323-502-008	201031A 323-683-001	201239A 323-600-201			202504A 323-685-232	201086 323-642-003	201037 323-642-001	201132B 323-604-211	
504/I-45	205153 323-692-004	"	"	"	"			"	"	"	"	
504/I-43	205152 323-692-003	"	"	"	"			"	"	"	"	
504/I-47	205154 323-692-005	"	"	"	"			"	"	"	"	
514/I-41	205150 323-692-001	202520A 323-510-010	205267 323-502-009	202273 323-683-200	"	202274 323-615-200		"	"	"	"	
514/I-42	205151 323-692-002	"	"	"	"			"	"	"	"	
503/I-4	202557 323-692-205	202514A 323-510-009	205266 323-502-008	201031A 323-683-001	"			205317 323-685-015	"	201068 323-642-002	"	
503/I-8	202561 323-692-209	"	"	"	"			"	"	"	"	
503/I-25	202496 323-692-213	"	"	"	"			202504A 323-685-232	"	201037 323-642-001	"	
504/I-1	202525 323-692-202	"	"	"	"			"	"	"	"	
504/I-9-27	205146 323-692-029	"	"	"	"			205317 323-685-015	"	"	"	
504/I-10	202563 323-692-211	"	"	"	"			"	201037 323-642-001	"	202590 323-604-227	
504/I-15	202885 323-692-216	"	"	"	"			202504A 323-685-232	201086 323-642-003	"	201132B 323-604-211	
504/I-145	205158 323-692-009	"	"	"	"			"	"	"	"	
504/I-43	205157 323-692-008	"	"	"	"			"	"	"	"	
504/I-47	205159 323-692-010	"	"	"	"			"	"	"	"	
514/I-41	205155 323-692-006	202520A 323-510-010	205267 323-502-009	202273 323-683-200	"	202274 323-615-200		"	"	"	"	
514/I-42	205156 323-692-007	"	"	"	"			"	"	"	"	
503/I-4	202884 323-692-215	202514A 323-510-009	205266 323-502-008	201031A 323-683-001	"			205317 323-685-015	"	201068 323-642-002	"	
503/I-8	202888 323-692-219	"	"	"	"			"	"	"	"	
503/I-25	205141 323-692-030	"	"	"	"			202504A 323-685-232	"	201037 323-642-001	"	

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323-420-200	202587	63		323-560-024	202513B	66		323-600-014	4009-1	53	10
323-500-002	202501A	23	2	323-560-025	202795A	25	23	323-600-015	5053	29	21
323-500-007	205274	51		323-560-025	202795A	60		323-600-016	1229	29	40
323-502-008	205266	51		323-560-025	202795A	62		323-600-016	1229	41	33
323-502-008	205266	68		323-560-025	202795A	64		323-600-017	5109	29	43
323-502-009	205267	51		323-560-030	300056	51	10	323-600-017	5109	29	45
323-502-009	205267	68		323-560-031	300115	51	11	323-600-019	1175-3	29	23
323-502-010	205268	51		323-560-032	300116	51	12	323-600-019	1175-3	29	29
323-502-212	202502B	41	1	323-560-201	202660	25	42	323-600-019	1175-3	31	4
323-505-002	201206	49	1	323-560-203	202843	25	39	323-600-019	1175-3	31	9
323-505-009	240	59	34	323-561-019	204924	49	17	323-600-019	1175-3	37	26
323-505-013	205344	49	22	323-561-020	205355	49		323-600-019	1175-3	39	27
323-505-014	300046	51	6	323-561-200	201250B	61		323-600-019	1175-3	39	29
323-508-002	201341	43	15	323-561-200	201250B	65		323-600-019	1175-3	47	22
323-508-003	205208	23	1	323-561-201	201251B	61		323-600-020	1170-1	35	3
323-508-010	205280	51	1	323-561-201	201251B	65		323-600-021	1206	31	15
323-508-011	300111	51	2	323-561-205	201248B	61		323-600-022	2022-4	31	17
323-508-200	201000C	23		323-561-205	201248B	63		323-600-022	2022-4	33	12
323-510-006	201200	25	44	323-561-205	201248B	65		323-600-022	2022-4	41	50
323-510-009	202514A	25	28	323-561-205	201248B	67		323-600-023	5083	31	18
323-510-009	202514A	68		323-561-206	201249B	61		323-600-024	1998-2	31	25
323-510-010	202520A	68		323-561-206	201249B	63		323-600-025	5064	31	46
323-510-016	201178B	23	6	323-561-206	201249B	65		323-600-025	5064	33	59
323-510-017	202934	23	15	323-561-206	201249B	67		323-600-026	2921	25	43
323-510-028	202932	23	9	323-568-003	205149	27	26	323-600-026	2921	31	43
323-510-060	202937	25	50	323-570-001	201299	43	11	323-600-026	2921	33	53
323-510-067	300061	51		323-576-001	201025	29	5	323-600-026	2921	33	56
323-510-068	300062	51		323-576-004	201360A	39	5	323-600-026	2921	33	61
323-510-071	205340	49	25	323-576-207	201079A	35	9	323-600-026	2921	35	29
323-510-206	202515A	25	32	323-576-214	202710A	33	11	323-600-026	2921	35	32
323-510-231	202687	23	14	323-579-001	201010A	27	16	323-600-026	2921	35	36
323-510-234	201318B	23	28	323-590-003	234	59	24	323-600-026	2921	41	21
323-525-001	201023	29	1	323-593-001	201093A	37	1	323-600-026	2921	49	29
323-525-003	201060B	31	16	323-593-001	201093A	47	1	323-600-027	1174	53	11
323-525-007	202925	39	1	323-593-002	201096A	37	4	323-600-028	5048	35	8
323-525-200	201073B	35	1	323-600-001	5078	23	4	323-600-028	5048	35	10
323-525-202	202505	41	3	323-600-002	1175-2	23	20	323-600-029	1196	37	36
323-525-203	201373	31	1	323-600-002	1175-2	23	24	323-600-029	1196	47	31
323-525-227	202619A	33	1	323-600-002	1175-2	27	10	323-600-032	1202	25	5
323-530-007	201163	41	47	323-600-002	1175-2	27	24	323-600-032	1202	31	31
323-530-019	205292	39	12	323-600-002	1175-2	29	47	323-600-032	1202	35	38
323-530-201	202511	41	40	323-600-002	1175-2	35	42	323-600-032	1202	37	3
323-530-206	201084A	35	14	323-600-002	1175-2	39	18	323-600-032	1202	37	6
323-530-221	201271A	31	13	323-600-002	1175-2	43	16	323-600-032	1202	47	3
323-530-222	201160B	41	42	323-600-002	1175-2	49	2	323-600-032	1202	49	9
323-530-223	202827	33	21	323-600-004	5060	27	17	323-600-032	1202	49	15
323-533-001	121	57	9	323-600-004	5060	27	19	323-600-033	1892	35	40
323-535-001	216	59	1	323-600-004	5060	43	12	323-600-034	1459	31	41
323-535-002	218	59	3	323-600-007	2022-3	27	15	323-600-034	1459	33	44
323-535-003	232	59	18	323-600-008	5080	27	30	323-600-034	1459	35	20
323-540-004	201080	35	11	323-600-009	5081	27	31	323-600-035	5086	47	5
323-540-007	201296	43	7	323-600-010	5010	27	33	323-600-036	201100	37	9
323-540-008	201297	43	9	323-600-011	5002	29	14	323-600-036	201100	37	14
323-540-010	205260	27	2	323-600-011	5002	33	2	323-600-037	1458	27	28
323-540-011	202825A	29	7	323-600-011	5002	35	2	323-600-037	1458	43	10
323-540-014	205259	27	1	323-600-012	1457	25	26	323-600-037	1458	47	27
323-540-018	201052B	31	6	323-600-012	1457	29	4	323-600-038	5095	25	8
323-540-023	205273	51		323-600-012	1457	39	4	323-600-038	5095	25	30
323-540-203	202574	41	8	323-600-013	5084	29	6	323-600-038	5095	33	35
323-540-223	202622B	33	6	323-600-013	5084	29	12	323-600-038	5095	37	29
323-540-227	202626A	33	18	323-600-013	5084	31	12	323-600-038	5095	45	9
323-546-001	201017A	27	29	323-600-013	5084	31	27	323-600-038	5095	47	25
323-560-021	205342	61		323-600-013	5084	33	4	323-600-039	5113	53	16
323-560-021	205342	63		323-600-013	5084	33	15	323-600-040	5087	39	6
323-560-021	205342	65		323-600-013	5084	39	11	323-600-043	2022	37	24
323-560-021	205342	67		323-600-014	4009-1	29	19	323-600-043	2022	39	14
323-560-024	202513B	25	22	323-600-014	4009-1	31	29	323-600-043	2022	41	45
323-560-024	202513B	60		323-600-014	4009-1	39	24	323-600-043	2022	41	49
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323-600-047	5164	41	4	323-600-202	5030	41	30	323-615-018	137906	49	16
323-600-050	5089	41	26	323-600-204	202510	41	38	323-615-021	204585	53	5
323-600-051	1231	33	28	323-600-205	202310	47	10	323-615-021	204585	53	38
323-600-051	1231	41	28	323-600-208	5198	23	27	323-615-023	202924	37	20
323-600-054	5142	41	54	323-600-209	5214	27	35	323-615-023	202924	47	16
323-600-055	5097	41	55	323-600-209	5214	41	2	323-615-028	224	59	10
323-600-056	2213-1	29	2	323-600-209	5214	41	15	323-615-029	204806	43	23
323-600-056	2213-1	31	2	323-600-211	5256	41	41	323-615-032	204925	49	20
323-600-056	2213-1	43	2	323-600-213	5258	41	18	323-615-200	202274	68	
323-600-057	5117	23	8	323-600-215	2133-1	33	33	323-615-201	202576	41	9
323-600-057	5117	25	37	323-600-216	2903	41	37	323-615-203	202700	55	6
323-600-057	5117	41	13	323-600-246	1186	51	18	323-615-206	202588	63	
323-600-057	5117	43	4	323-600-251	5022	51	9	323-615-209	200138	45	32
323-600-057	5117	45	18	323-600-263	5274	35	15	323-615-211	167066	37	27
323-600-057	5117	55	18	323-600-264	5146	33	24	323-615-211	167066	47	23
323-600-057	5117	55	23	323-600-265	5266	41	7	323-615-216	202875	31	44
323-600-058	201301	45	20	323-600-290	5219	33	19	323-615-216	202875	33	54
323-600-059	3001	45	3	323-600-291	5220	33	41	323-615-216	202875	33	57
323-600-060	5118	23	11	323-600-301	1189	39	20	323-615-216	202875	35	30
323-600-060	5118	55	26	323-600-301	1189	51	3	323-615-216	202875	35	33
323-600-061	5152	45	6	323-600-303	5185	29	37	323-615-218	202757	33	16
323-600-062	201323	45	11	323-600-307	5077	49	34	323-615-219	202769	55	15
323-600-063	201324	45	12	323-600-321	175	55	21	323-615-219	202769	55	30
323-600-064	201758	45	16	323-600-324	5296	55	13	323-615-220	202767	55	11
323-600-066	5149A	27	27	323-600-325	5215A	23	16	323-615-229	202287A	43	21
323-600-068	1216	25	4	323-600-353	5205	51	5	323-616-001	201477	55	16
323-600-068	1216	25	16	323-600-354	5138B	43	20	323-616-001	201477	55	31
323-600-068	1216	25	24	323-600-357	5293	25	14	323-617-001	225	59	11
323-600-068	1216	25	40	323-600-364	5354	53	30	323-617-200	202286	35	6
323-600-068	1216	25	46	323-600-367	5344	53	4	323-618-002	201029	29	11
323-600-068	1216	25	49	323-604-003	201064	31	23	323-618-003	201056	31	11
323-600-068	1216	25	51	323-604-004	201075	35	7	323-618-005	201065	31	26
323-600-068	1216	25	54	323-604-008	201161	41	44	323-618-006	201117	39	10
323-600-068	1216	25	56	323-604-201	5082A	29	35	323-618-007	200183	25	9
323-600-068	1216	33	17	323-604-201	5082A	31	37	323-618-008	202910	29	9
323-600-068	1216	51	13	323-604-201	5082A	33	50	323-618-009	202922	33	13
323-600-069	1435	25	19	323-604-201	5082A	35	26	323-618-201	202722A	27	14
323-600-069	1435	25	20	323-604-209	200152	45	30	323-618-209	202868	41	43
323-600-069	1435	37	31	323-604-211	201132B	39	30	323-620-001	201002	23	5
323-600-072	5094	23	29	323-604-211	201132B	68		323-620-006	201125	39	21
323-600-072	5094	25	29	323-604-227	202590	39		323-620-011	201202	25	47
323-600-073	2918	25	34	323-604-227	202590	68		323-620-024	223	59	9
323-600-073	2918	49	18	323-605-003	5347	53	36	323-620-031	300135	51	22
323-600-074	2905	25	41	323-605-006	5150B	43	22	323-620-200	201058A	31	14
323-600-074	2905	29	41	323-605-202	204303	55	4	323-620-201	202200	37	23
323-600-074	2905	49	4	323-605-203	202766	55	7	323-620-201	202200	47	17
323-600-074	2905	49	7	323-605-204	5302	55	29	323-620-202	202354	23	12
323-600-079	5184	49	12	323-613-001	201482	29	34	323-620-203	202521	25	25
323-600-092	5328	35	17	323-613-001	201482	31	36	323-620-204	202579	25	35
323-600-093	5335	47	6	323-613-001	201482	33	49	323-620-207	201221A	25	10
323-600-094	5305	33	31	323-613-001	201482	35	25	323-620-234	202625	33	22
323-600-095	5187	39	2	323-615-002	200098	37	11	323-620-237	202711A	29	3
323-600-096	5345	41	17	323-615-002	200098	37	16	323-620-237	202711A	33	3
323-600-101	5341	53	39	323-615-002	200098	47	12	323-620-237	202711A	39	3
323-600-105	5364	29	26	323-615-002	200098	55	19	323-620-238	202712A	33	14
323-600-117	205217	57	22	323-615-002	200098	55	24	323-621-001	202926	33	34
323-600-118	217	59	2	323-615-002	200098	55	28	323-622-001	201166	41	52
323-600-119	221	59	7	323-615-003	201252	31	5	323-625-200	202865	25	13
323-600-120	230	59	16	323-615-007	201134	39	32	323-626-001	202911	29	10
323-600-120	230	59	19	323-615-008	201302	45	21	323-627-002	202921	33	38
323-600-120	230	59	22	323-615-009	200149	45	7	323-627-003	202863B	23	13
323-600-120	230	59	25	323-615-010	201759	45	15	323-627-011	201755	25	31
323-600-121	239	59	33	323-615-012	201185	25	6	323-627-204	202765	55	9
323-600-122	241	59	35	323-615-012	201185	53	32	323-627-208	202903	27	5
323-600-123	242	59	36	323-615-013	200821	25	12	323-627-208	202903	45	10
323-600-124	5366	49	37	323-615-013	200821	49	24	323-630-001	3044	25	21
323-600-126	5405	49	23	323-615-014	200162	25	17	323-630-001	3044	37	10
323-600-200	1156	35	5	323-615-015	201191	23	17	323-630-001	3044	37	15
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323-630-001	3044	55	27	323-642-001	201037	68		323-680-005	202909	27	25
323-630-003	3091	53	12	323-642-002	201068	31	34	323-680-200	202568	47	13
323-630-005	5181	39	7	323-642-002	201068	33	47	323-683-001	201031A	68	
323-630-009	5099	25	11	323-642-002	201068	68		323-683-002	201303	45	22
323-630-009	5099	49	19	323-642-003	201086	68		323-683-003	201304	45	24
323-630-010	5074	49	13	323-643-001	201156	41	31	323-683-004	201345A	45	2
323-630-013	5348	53	6	323-643-003	201186	25	15	323-683-012	202931	45	27
323-630-013	5348	53	37	323-643-005	201203	25	48	323-683-200	202273	68	
323-630-016	5213	37	19	323-643-009	300050	51	16	323-683-201	202503	41	14
323-630-016	5213	47	15	323-643-010	300114	51	17	323-685-003	202199	45	34
323-630-018	222	59	8	323-643-210	201162A	41	46	323-685-004	202637B	39	17
323-630-019	226	59	12	323-648-200	202720B	23	23	323-685-013	227	59	13
323-630-020	231	59	17	323-648-201	202748	23	30	323-685-015	205317	68	
323-630-020	231	59	20	323-649-001	201009	27	3	323-685-016	260	59	31
323-630-020	231	59	23	323-649-001	201009	43	8	323-685-017	261	59	32
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230	323-600-120	59	19	1231	323-600-051	41	28	5060	323-600-004	43	12
230	323-600-120	59	22	1435	323-600-069	25	19	5064	323-600-025	31	46
230	323-600-120	59	25	1435	323-600-069	25	20	5064	323-600-025	33	59
231	323-630-020	59	17	1435	323-600-069	37	31	5074	323-630-010	49	13
231	323-630-020	59	20	1457	323-600-012	25	26	5077	323-600-307	49	34
231	323-630-020	59	23	1457	323-600-012	29	4	5078	323-600-001	23	4
231	323-630-020	59	26	1457	323-600-012	39	4	5080	323-600-008	27	30
232	323-535-003	59	18	1458	323-600-037	27	28	5081	323-600-009	27	31
233	323-750-006	59	21	1458	323-600-037	43	10	5082A	323-604-201	29	35
234	323-590-003	59	24	1458	323-600-037	47	27	5082A	323-604-201	31	37
235	323-851-021	59	27	1459	323-600-034	31	41	5082A	323-604-201	33	50
236	323-630-021	59	28	1459	323-600-034	33	44	5082A	323-604-201	35	26
236	323-630-021	59	30	1459	323-600-034	35	20	5083	323-600-023	31	18
237	323-851-020	59	29	1892	323-600-033	35	40	5084	323-600-013	29	6
239	323-600-121	59	33	1998-2	323-600-024	31	25	5084	323-600-013	29	12
240	323-505-009	59	34	2022	323-600-043	37	24	5084	323-600-013	31	12
241	323-600-122	59	35	2022	323-600-043	39	14	5084	323-600-013	31	27
242	323-600-123	59	36	2022	323-600-043	41	45	5084	323-600-013	33	4
243	323-800-041	59	5	2022	323-600-043	41	49	5084	323-600-013	33	15
260	323-685-016	59	31	2022	323-600-043	47	18	5084	323-600-013	39	11
261	323-685-017	59	32	2022-3	323-600-007	27	15	5086	323-600-035	47	5
1156	323-600-200	35	5	2022-4	323-600-022	31	17	5087	323-600-040	39	6
1156	323-600-200	45	29	2022-4	323-600-022	33	12	5088	323-600-044	39	16
1170-1	323-600-020	35	3	2022-4	323-600-022	41	50	5089	323-600-050	41	26
1174	323-600-027	53	11	2133-1	323-600-215	33	33	5094	323-600-072	23	29
1175-2	323-600-002	23	20	2213-1	323-600-056	29	2	5094	323-600-072	25	29
1175-2	323-600-002	23	24	2213-1	323-600-056	31	2	5095	323-600-038	25	8
1175-2	323-600-002	27	10	2213-1	323-600-056	43	2	5095	323-600-038	25	30
1175-2	323-600-002	27	24	2903	323-600-216	41	37	5095	323-600-038	33	35
1175-2	323-600-002	29	47	2905	323-600-074	25	41	5095	323-600-038	37	29
1175-2	323-600-002	35	42	2905	323-600-074	29	41	5095	323-600-038	45	9
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5099	323-630-009	25	11	200098	323-615-002	55	24	201079A	323-576-207	35	9
5099	323-630-009	49	19	200098	323-615-002	55	28	201080	323-540-004	35	11
5109	323-600-017	29	43	200134A	323-639-016	45	33	201081A	323-676-023	35	12
5109	323-600-017	29	45	200136	323-636-200	45	31	201084A	323-530-206	35	14
5113	323-600-039	53	16	200138	323-615-209	45	32	201085B	323-810-002	61	
5117	323-600-057	23	8	200149	323-615-009	45	7	201085B	323-810-002	63	
5117	323-600-057	25	37	200152	323-604-209	45	30	201086	323-642-003	68	
5117	323-600-057	41	13	200159A	323-728-208	25	7	201087A	323-866-003	35	35
5117	323-600-057	43	4	200162	323-615-014	25	17	201088	323-740-002	35	37
5117	323-600-057	45	18	200163A	323-734-206	25	18	201089	323-860-006	33	52
5117	323-600-057	55	18	200183	323-618-007	25	9	201089	323-860-006	35	28
5117	323-600-057	55	23	200821	323-615-013	25	12	201091	323-639-002	35	39
5118	323-600-060	23	11	200821	323-615-013	49	24	201092A	323-740-003	35	41
5118	323-600-060	55	26	201000C	323-508-200	23		201093A	323-593-001	37	1
5137	323-630-202	41	19	201002	323-620-001	23	5	201093A	323-593-001	47	1
5138B	323-600-354	43	20	201004	323-655-001	23	18	201094B	323-830-001	60	
5142	323-600-054	41	54	201005	323-800-002	23	19	201094B	323-830-001	62	
5146	323-600-264	33	24	201009	323-649-001	27	3	201094B	323-830-001	64	
5149A	323-600-066	27	27	201009	323-649-001	43	8	201094B	323-830-001	66	
5150B	323-605-006	43	22	201010A	323-579-001	27	16	201096A	323-593-002	37	4
5152	323-600-061	45	6	201017A	323-546-001	27	29	201097C	323-830-233	62	
5164	323-600-047	41	4	201018B	323-780-201	27	32	201097C	323-830-233	66	
5181	323-630-005	39	7	201022	323-632-001	27	36	201098	323-730-002	37	7
5184	323-600-079	49	12	201023	323-525-001	29	1	201098	323-730-002	47	8
5185	323-600-303	29	37	201025	323-576-001	29	5	201099	323-676-013	37	8
5187	323-600-095	39	2	201027A	323-676-020	29	8	201099	323-676-013	37	13
5198	323-600-208	23	27	201029	323-618-002	29	11	201100	323-600-036	37	9
5205	323-600-353	51	5	201031A	323-683-001	68		201100	323-600-036	37	14
5213	323-630-016	37	19	201034A	323-649-002	29	20	201101	323-730-003	37	12
5213	323-630-016	47	15	201035A	323-630-200	29	30	201106	323-750-001	37	21
5214	323-600-209	27	35	201035A	323-630-200	31	32	201106	323-750-001	47	19
5214	323-600-209	41	2	201035A	323-630-200	33	45	201107	323-750-002	37	22
5214	323-600-209	41	15	201035A	323-630-200	35	21	201107	323-750-002	47	20
5215A	323-600-325	23	16	201037	323-642-001	68		201109	323-850-005	37	25
5219	323-600-290	33	19	201039	323-780-002	29	33	201109	323-850-005	47	21
5220	323-600-291	33	41	201039	323-780-002	31	35	201110	323-639-003	37	30
5221	323-630-204	55	5	201039	323-780-002	33	48	201110	323-639-003	47	26
5256	323-600-211	41	41	201039	323-780-002	35	24	201115A	323-676-230	39	8
5258	323-600-213	41	18	201042	323-639-001	29	42	201117	323-618-006	39	10
5260	323-630-203	39	31	201043B	323-740-215	29	46	201121A	323-870-214	61	
5266	323-600-265	41	7	201044	323-860-001	29	44	201121A	323-870-214	63	
5274	323-600-263	35	15	201048A	323-860-200	29	38	201121A	323-870-214	65	
5293	323-600-357	25	14	201048A	323-860-200	31	39	201121A	323-870-214	67	
5296	323-600-324	55	13	201048A	323-860-200	31	40	201125	323-620-006	39	21
5297	323-630-228	55	14	201048A	323-860-200	33	42	201127	323-870-211	61	
5297	323-630-228	55	32	201048A	323-860-200	33	43	201127	323-870-211	63	
5298	323-630-229	55	10	201048A	323-860-200	35	18	201127	323-870-211	65	
5302	323-605-204	55	29	201048A	323-860-200	35	19	201127	323-870-211	67	
5305	323-600-094	33	31	201050	323-850-002	31	3	201129	323-640-001	39	25
5328	323-600-092	35	17	201052B	323-540-018	31	6	201130A	323-686-001	39	26
5335	323-600-093	47	6	201053A	323-676-006	31	8	201131A	323-850-008	39	28
5341	323-600-101	53	39	201055A	323-676-007	31	10	201132B	323-604-211	39	30
5344	323-600-367	53	4	201055A	323-676-007	33	10	201132B	323-604-211	68	
5345	323-600-096	41	17	201056	323-618-003	31	11	201134	323-615-007	39	32
5347	323-605-003	53	36	201058A	323-620-200	31	14	201141	323-680-002	41	5
5348	323-630-013	53	6	201060B	323-525-003	31	16	201148A	323-640-002	41	35
5348	323-630-013	53	37	201061A	323-730-204	31	21	201152E	323-820-021	63	
5354	323-600-364	53	30	201064	323-604-003	31	23	201152E	323-820-021	67	
5364	323-600-105	29	26	201065	323-618-005	31	26	201155C	323-863-212	63	
5366	323-600-124	49	37	201066	323-800-004	31	28	201155C	323-863-212	67	
5367	323-630-022	53	31	201067A	323-810-001	60		201156	323-643-001	41	31
5405	323-600-126	49	23	201067A	323-810-001	62		201160B	323-530-222	41	42
137142	323-615-017	49	5	201068	323-642-002	31	34	201161	323-604-008	41	44
137906	323-615-018	49	16	201068	323-642-002	33	47	201162A	323-643-210	41	46
167066	323-615-211	37	27	201068	323-642-002	68		201163	323-530-007	41	47
167066	323-615-211	47	23	201070	323-866-002	31	45	201164A	323-680-003	41	48
200098	323-615-002	37	11	201071	323-860-005	31	42	201165	323-730-004	41	51
200098	323-615-002	37	16	201073B	323-525-200	35	1	201166	323-622-001	41	52
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201178B	323-510-016	23	6	201327	323-639-006	45	14	202467	323-802-212	25	2
201179B	323-663-007	23	7	201330	323-882-001	23	25	202475	323-810-013	62	
201181C	323-802-001	25	1	201334B	323-713-001	43	17	202478	323-900-200	29	
201184	323-740-006	25	3	201335	323-663-004	43	18	202479	323-900-201	31	
201185	323-615-012	25	6	201338	323-655-002	43	13	202479	323-900-201	33	
201185	323-615-012	53	32	201341	323-508-002	43	15	202491	323-685-226	29	27
201186	323-643-003	25	15	201342B	323-900-002	45	1	202492	323-685-227	29	28
201191	323-615-015	23	17	201345A	323-683-004	45	2	202496	323-692-213	68	
201191	323-615-015	49	11	201346A	323-740-013	55	20	202501A	323-500-002	23	2
201200	323-510-006	25	44	201348B	323-774-001	55	22	202502B	323-502-212	41	1
201201	323-728-003	25	45	201349B	323-774-200	55	25	202503	323-683-201	41	14
201202	323-620-011	25	47	201360A	323-576-004	39	5	202504A	323-685-232	41	22
201203	323-643-005	25	48	201373	323-525-203	31	1	202504A	323-685-232	68	
201204B	323-800-202	25	53	201396B	323-863-215	61		202505	323-525-202	41	3
201206	323-505-002	49	1	201396B	323-863-215	65		202507	323-850-202	41	34
201211A	323-400-001	49	3	201477	323-616-001	55	16	202510	323-600-204	41	38
201212C	323-676-037	27	13	201477	323-616-001	55	31	202511	323-530-201	41	40
201221A	323-620-207	25	10	201482	323-613-001	29	34	202512A	323-716-211	41	32
201224B	323-863-007	61		201482	323-613-001	31	36	202513B	323-560-024	25	22
201224B	323-863-007	63		201482	323-613-001	33	49	202513B	323-560-024	60	
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201224B	323-863-007	67		201485	323-740-012	49	10	202513B	323-560-024	64	
201230C	323-820-019	61		201487	323-800-009	43	19	202513B	323-560-024	66	
201230C	323-820-019	65		201500	323-850-012	49		202514A	323-510-009	25	28
201233A	323-850-013	49	14	201755	323-627-011	25	31	202514A	323-510-009	68	
201234A	323-810-003	62		201758	323-600-064	45	16	202515A	323-510-206	25	32
201239A	323-600-201	68		201759	323-615-010	45	15	202516	323-728-200	25	33
201248B	323-561-205	61		202033	323-653-204	33	20	202517	323-641-200	25	36
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201249B	323-561-206	61		202081	323-653-003	31	20	202522	323-634-200	25	27
201249B	323-561-206	63		202081	323-653-003	33	8	202523	323-800-200	27	34
201249B	323-561-206	65		202174	323-653-013	33	39	202524	323-692-200	25	38
201249B	323-561-206	67		202176	323-653-005	31	19	202525	323-692-202	68	
201250B	323-561-200	61		202176	323-653-005	31	22	202525	323-692-202	68	
201250B	323-561-200	65		202176	323-653-005	31	24	202527	323-870-207	63	
201251B	323-561-201	61		202176	323-653-005	33	23	202528A	323-801-036	62	
201251B	323-561-201	65		202177	323-653-212	31	7	202529A	323-830-200	62	
201252	323-615-003	31	5	202177	323-653-212	33	29	202530B	323-830-039	62	
201265B	323-854-200	61		202178	323-653-012	33	7	202531A	323-801-037	62	
201265B	323-854-200	63		202181	323-653-016	37	32	202535C	323-830-331	60	
201265B	323-854-200	65		202181	323-653-016	47	28	202535C	323-830-331	64	
201265B	323-854-200	67		202199	323-685-003	45	34	202540B	323-820-251	63	
201271A	323-530-221	31	13	202200	323-620-201	37	23	202540B	323-820-251	67	
201287A	323-810-004	60		202200	323-620-201	47	17	202544D	323-830-256	60	
201287A	323-810-004	62		202201A	323-850-251	37	28	202544D	323-830-256	64	
201288A	323-900-001	43	1	202201A	323-850-251	47	24	202549B	323-820-254	63	
201293A	323-800-006	43	3	202202	323-639-201	37	33	202549B	323-820-254	67	
201294	323-764-001	43	5	202202	323-639-201	47	29	202557	323-692-205	68	
201295	323-764-002	43	6	202203	323-685-200	37	35	202558	323-692-206	68	
201296	323-540-007	43	7	202203	323-685-200	47	30	202561	323-692-209	68	
201297	323-540-008	43	9	202208	323-685-201	45	17	202563	323-692-211	68	
201298	323-765-001	27	18	202273	323-683-200	68		202566	323-850-204	47	7
201299	323-570-001	43	11	202274	323-615-200	68		202567	323-676-200	47	9
201300	323-636-001	45	19	202278	323-676-202	29	31	202568	323-680-200	47	13
201301	323-600-058	45	20	202278	323-676-202	31	33	202574	323-540-203	41	8
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201304	323-683-003	45	24	202286	323-617-200	35	6	202577	323-633-200	41	10
201310A	323-863-201	61		202287A	323-615-229	43	21	202578	323-850-242	41	12
201310A	323-863-201	65		202295	323-870-210	61		202579	323-620-204	25	35
201311	323-663-001	43	14	202295	323-870-210	63		202580	323-820-200	63	
201315	323-800-008	45	4	202295	323-870-210	65		202582	323-801-213	62	
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202590	323-604-227	39		202830	323-866-210	35	34	202982	323-801-355	64	
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202595	323-801-235	64		202843	323-560-203	25	39	202983	323-801-356	64	
202616	323-801-038	66		202845A	323-830-065	62		202990	323-653-010	27	4
202617	323-801-039	66		202849	323-800-215	31	38	202999	323-851-003	29	36
202618	323-801-222	62		202849	323-800-215	33	51	204303	323-605-202	55	4
202618	323-801-222	66		202849	323-800-215	35	27	204585	323-615-021	53	5
202619A	323-525-227	33	1	202854A	323-830-333	60		204585	323-615-021	53	38
202622B	323-540-223	33	6	202854A	323-830-333	64		204806	323-615-029	43	23
202623A	323-676-228	33	9	202858	323-685-228	33	60	204924	323-561-019	49	17
202625	323-620-234	33	22	202859	323-850-244	33	55	204925	323-615-032	49	20
202626A	323-540-227	33	18	202860	323-850-243	35	31	205149	323-568-003	27	26
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