

INSTRUCTION MANUAL



Pioneer in Bag Sewing Machines

MODEL DAD & MODEL DAD-R



DIN EN ISO 9001 : 2000



Certificate Registration No.
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ET/LVD/2009/700

**REVO TWIN NEEDLE DOUBLE THREAD PARALLEL CHAIN
STITCH BAG CLOSER SEWING MACHINE WITH LUBRICATOR**

INTRODUCTION

Thank you very much for purchasing Revo[®] Bag Closer Sewing Machine from Style D-R Series.

This instruction manual describe daily routine maintenance and safety precautions to keep the machine in best possible condition.

Please study this manual carefully before operating the machine

YEAR OF MANUFACTURE

**NOTE : Difference between Model DAD and DAD-R Machine is in cutter mechanism.
(See Page No. 21, 25 & 27)**

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Technical Specifications

Speed (rpm.)	1,600±125
Seam	2 Parallel Chain Stitch
Stitch Range (mm.)	7 (fixed)
Needle	DB x 1 200 / 25 (Groz Beckert)
Thread (synthetic or cotton)	20/6
Driver Motor	75W Heavy Duty
Belt Size	Toothed Belt 170 XL Width 15 mm
Type of Stitch	Federal Stitch Type Parallel Stitch

POWER SUPPLY

Countries	Specified Volts	Frequency
Argentina, Australia, Austria, Belgium, Korea South, Malaysia, New Zealand, China, France Germany, Greece, South Africa, India, Italy United Arab Emirates, United Kingdom etc.	220 ± 10% Volts	50Hz
Belize, Brazil, Colombia, Canada, Mexico Dominican Republic, Honduras, Japan, Serbia & Montenegro, Taiwan, U.S.A. Etc.	110 ± 10% Volts	60Hz

Power Cable Size 23/76 Three Core PVC Flexible

Material Thickness 15mm max.

Machine Dimension (mm.) 508(L) x 305(W) x 381(H)

Net Weight (kg.) 7.5

Note : The machine is capable of sewing on materials with thickness upto 15 mm, making them ideal for use on heavy and thick materials.

Accessories Box Items

S. No.	Part No.	Description	Qty.
01	D02	Accessory Box	1 Pc.
02	T05	Needle DB x 1 200 / 25R (GROZ BECKERT) or equivalent	2 Pcs.
03	T300	Looper	2 Pcs.
04	D13	Allen Key 2.00mm	1 Pc.
05	D14	Allen Key 2.50mm	1 Pc.
06	D07	Allen Key 3.00mm	1 Pc.
07	D15	Allen Key 4.00mm	1 Pc.
08	D03	Allen Key 3 / 16	1 Pc.
09	D12	Screw Driver	1 Pc.
10	T501-3	Allen Key Screw for Needle Holder	2 Pcs.
11	D8C	Tweezer	1 Pc.
12	D16	Oil Can	1 Pc.
13	D810P	Thread Cone 1000 mtr.	1 Pc.

* The part list is subject to change without prior notice.

For Operator Safety

Thanks you for purchasing the REVO Model DAD-R Portable Bag Closer.

- ◆ This manual contains the instructions and precautions for using the Model DAD-R Portable Bag Closer. Be sure to read and understand this manual before use and use the machine correctly.
- ◆ Keep this manual near the sewing machine for easy reference. Be sure to attach this manual to the machine when lending or transferring it to another person or company.
- ◆ Please order this manual from the nearest REVO office if it is lost.
- ◆ The contents of this manual are subject to change without prior notice for improvement and safety purpose.



Instructions with this mark are especially important for operator safety. Be sure to observe these marked instructions.

Hazard of Being Caught in the Machine

Be careful, when you insert a bag to be closed into the sewing machine, or your fingers may be caught in the machine between the presser foot and feed dog.

A "Hazardous" mark is attached to the machine. When sewing, be sure to support the bag with the hand from beneath the sewing head and not to touch on the machine.

When adjusting the machine or replacing parts, always disconnect the Electric Cord from the power source.

This is important in view of safety to the operator and adjuster.

WARNING

PERSONAL INJURY MAY RESULT IF THE FOLLOWING SAFETY PRECAUTIONS ARE NOT OBSERVED.

- ◆ BE SURE THE AREA SURROUNDING MACHINE IS FREE OF ALL HAZARDS SUCH AS FIRE, WATER, OIL, RUBBISH OR ANYTHING THAT CAN CAUSE INJURY.
- ◆ DO NOT OPERATE MACHINE IN AN EXPLOSIVE AREA OR UNDER WET CONDITIONS. THE MACHINE IS NOT AN EXPLOSION-PROOF TYPE NOR WATER PROOF TYPE.
- ◆ DO NOT OPERATE MACHINE BEFORE READING INSTRUCTION MANUAL.
- ◆ DO NOT OPERATE MACHINE ON VOLTAGES OTHER THAN SPECIFIED FOR THE MACHINE.
- ◆ BE SURE MACHINE IS CONNECTED TO BUILD ELECTRICAL SAFETY GROUND (EARTH).
- ◆ BE SURE POWER SUPPLY IS OFF BEFORE PERFORMING MACHINE MAINTENANCE, PARTS REPLACEMENT, ADJUSTMENTS OR CLEANING.
- ◆ DO NOT OPERATE MACHINE WHEN GUARDS AND COVERS REMOVED.
- ◆ DO NOT TOUCH KNIFE, NEEDLE, PULLEY, BELT AND MOVING PARTS WHEN MACHINE IS IN OPERATION.
- ◆ BE SURE MACHINE IS PLACED ON A SMOOTH (LEVEL) SURFACE WHEN PERFORMING MAINTENANCE, PARTS REPLACEMENT, ADJUSTMENTS, CLEANING OR STORAGE.

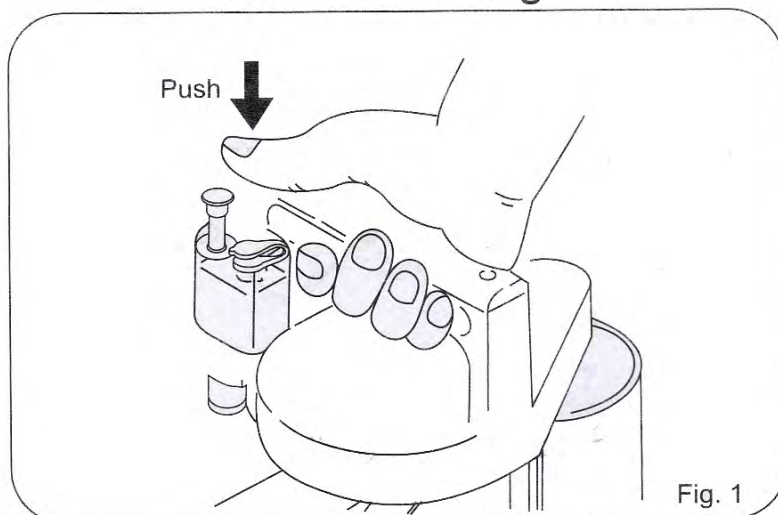
- ◆ BE SURE THE MATERIAL TO BE SEW OR CLOSED COMPLIES WITH THE MACHINE SPECIFICATION.
- ◆ DO NOT USE SPARE PARTS OTHER THAN "REVO" GENUINE PARTS.
- ◆ USE OF THE EAR PLUG DURING OPERATING MACHINE IS ESSENTIAL.



Special Instructions

1. This machine is not intended for use elsewhere bag closing application.
2. This machine can be used for all Kinds of multi - wall paper, jute, burlap, cotton, hessian, woven bags etc.
3. Do not use this machine on Rubber coated bags.
4. Do not use this machine in wet conditions.
5. The machine can be operated completely portable or it can be used with suspension unit with hanging hook during operating the machine. (Here picture can be used for better under standing).
6. Use this machine with a minimum 4 mtrs. Length of power card.
7. Do not use this machine where the material thickness is more than 15 mm.
8. Do not run on three phase connection.
9. Use machine under suitable lighting.
10. Use suspension unit with hanging hook to avoid fatigue of operator. (See Page 29)
11. Use of ear plugs is essential.
12. Do not use machine in wet conditions.
13. Do not use this machine without rubber shoes.

Before Starting



OILING

Oiling is imperative to keep the machine in excellent operating condition. Fill oil tank with oil up to the maximum level mark. To begin flow of oil to the machine, push the lubricator button four times continuously before starting machine (See Fig. 1). This should dispense enough oil for continuous machine use of around four hours.

Do not run machine without oil as this could cause machine failure or break down.

How to Close A Paper Bag

HOW TO CLOSE A BAG

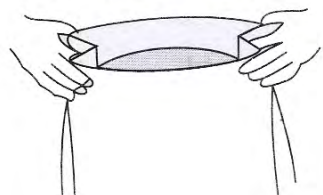


Figure No. 1

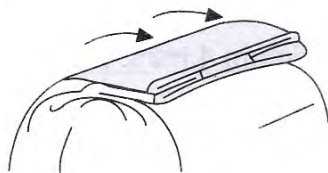


Figure No. 2

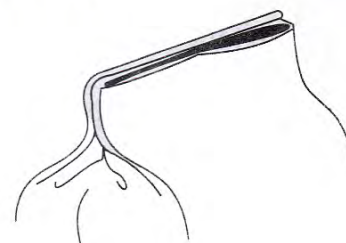


Figure No. 3

After bag is filled, weighed and ready for closing, the operator should first reform gussets. See Fig. No. 1

Then, fold or "break" top of bag sharply over contents. See Fig. 2

Bring top of bag upright closing position. The sides should be closed together, smooth and wrinkle-free. See Fig. No.3

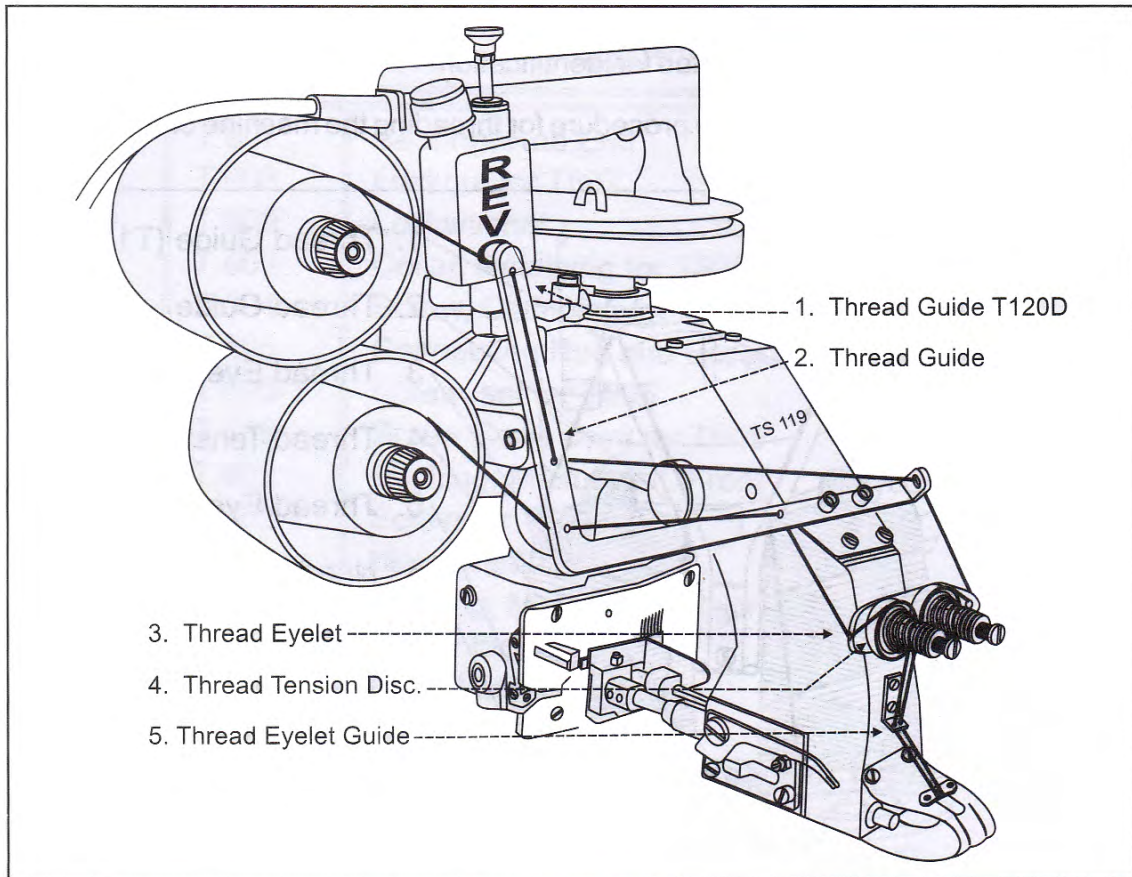
Proceed with sewing operation, **but sewing no more than two inches down from top of bag.**

If sifting is a problem, merely tuck in the inner ply tightly over contents and proceed to sew remaining plies

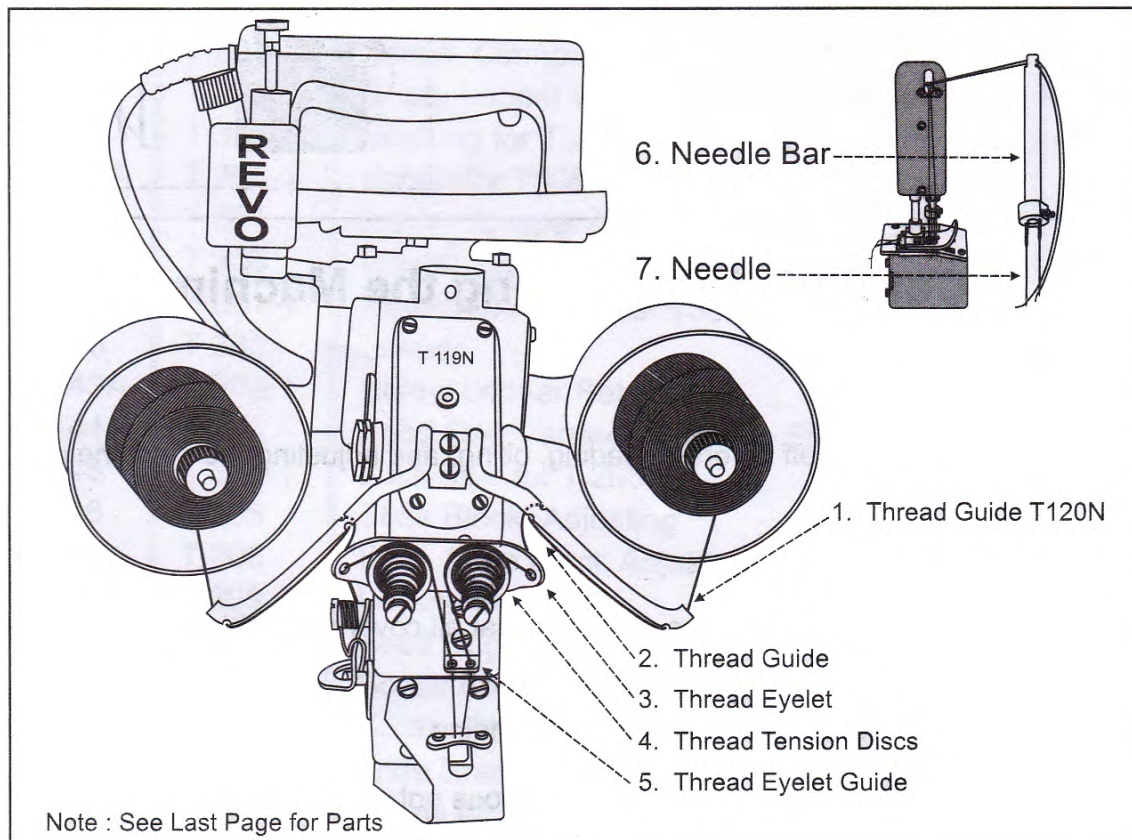
NOTE : Sufficient top is necessary to properly "break" bag

Important! Always sew well above contents of bag. Never interfere with the feeding of the machine as it sews across the bag, by either pulling it, holding it back, or pulling up.

Threading: One Side Two Thread Cone



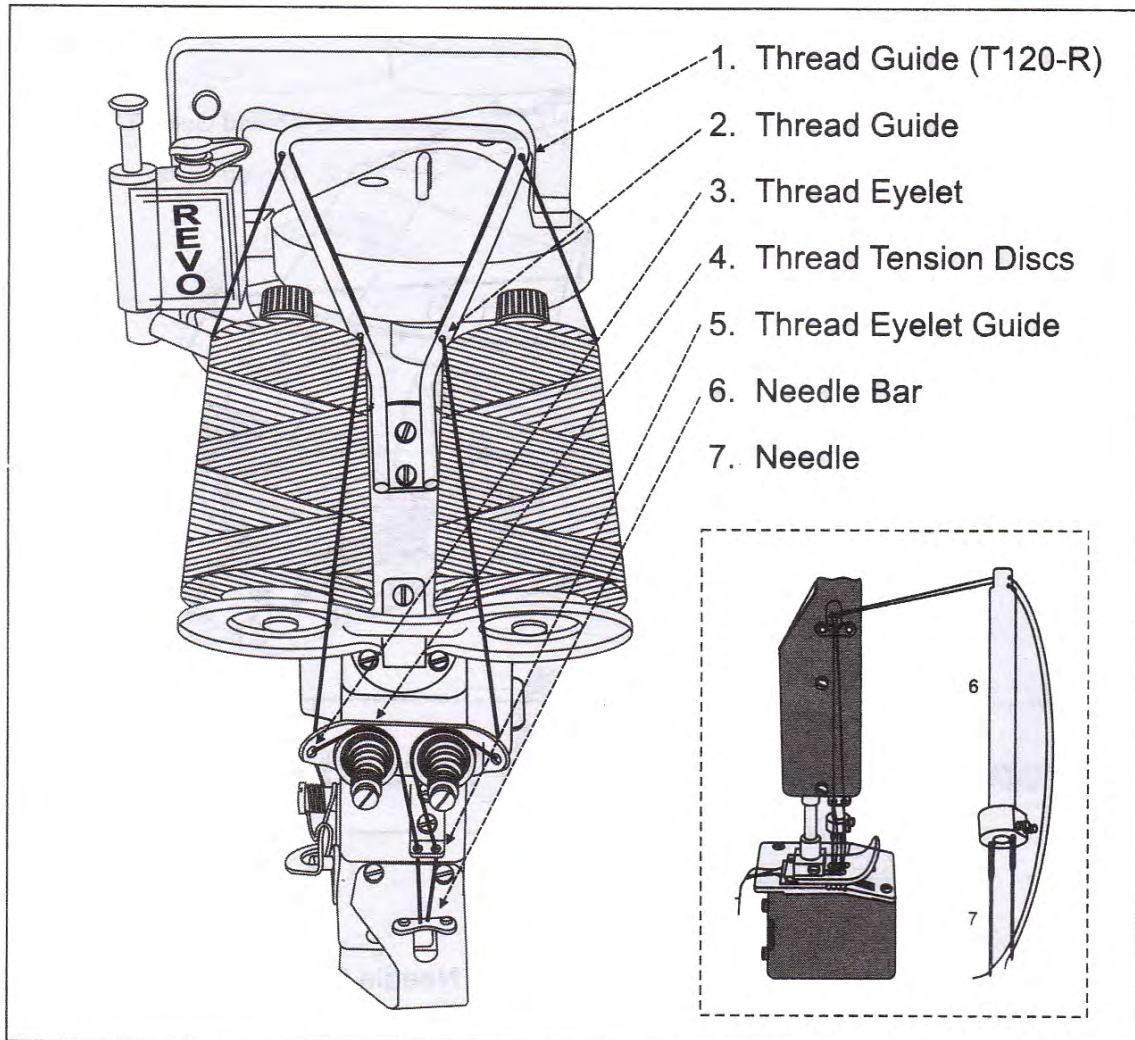
Threading: Each Side One Thread Cone



Threading

The machine is delivered threaded for identification.

The illustration below shows the procedure for threading the machine correctly.



Cautions When Using the Machine

Safety Precautions

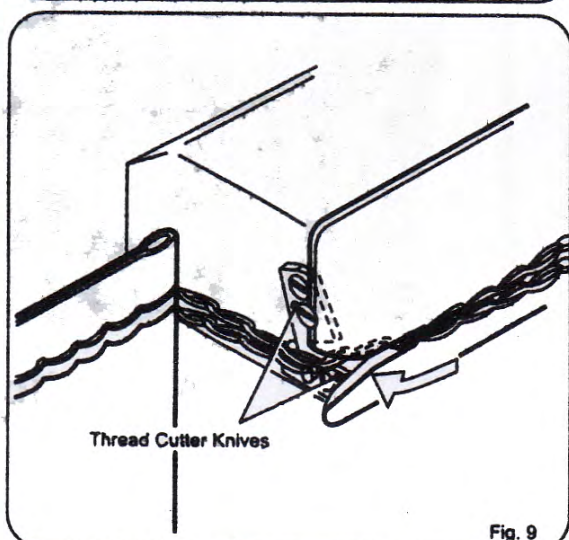
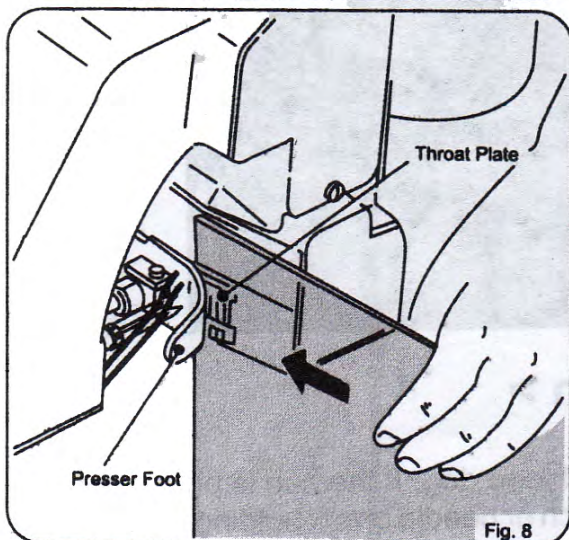
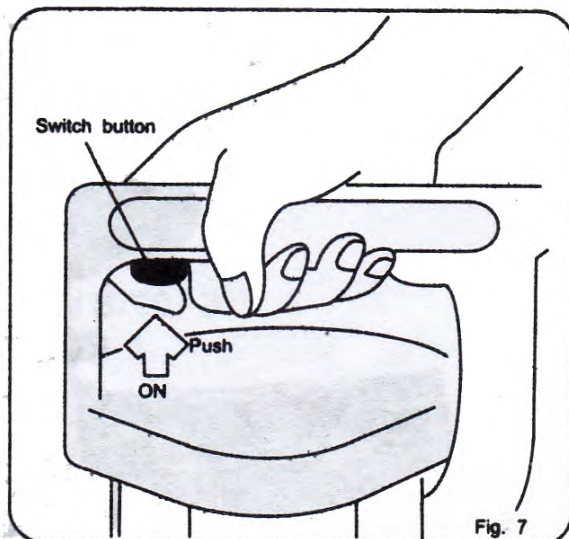
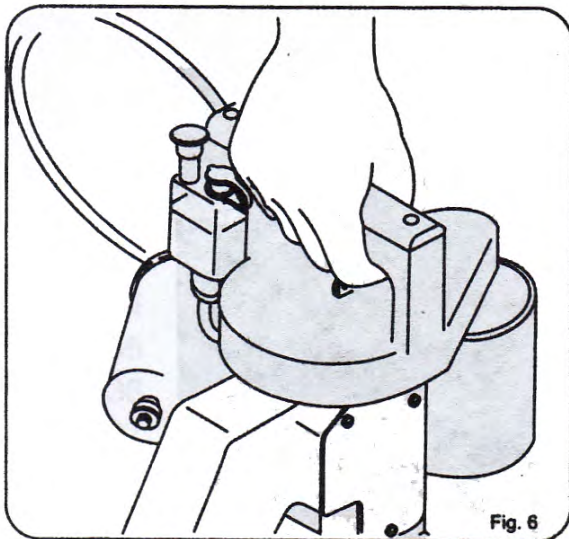
1. Always turn power off before threading, oiling, and adjusting the machine or replacing parts.
2. Wear safety glasses.
3. Make sure, before starting the machine, that all covers and shields are in place and closed.
4. Do not touch on the machine when it is running.
5. Turn power off and make sure the cutter does not operate before you put your fingers under the cutter blades and the needles to adjust.

Start

Before starting, make sure that the supply voltage accords with the specification of the motor.

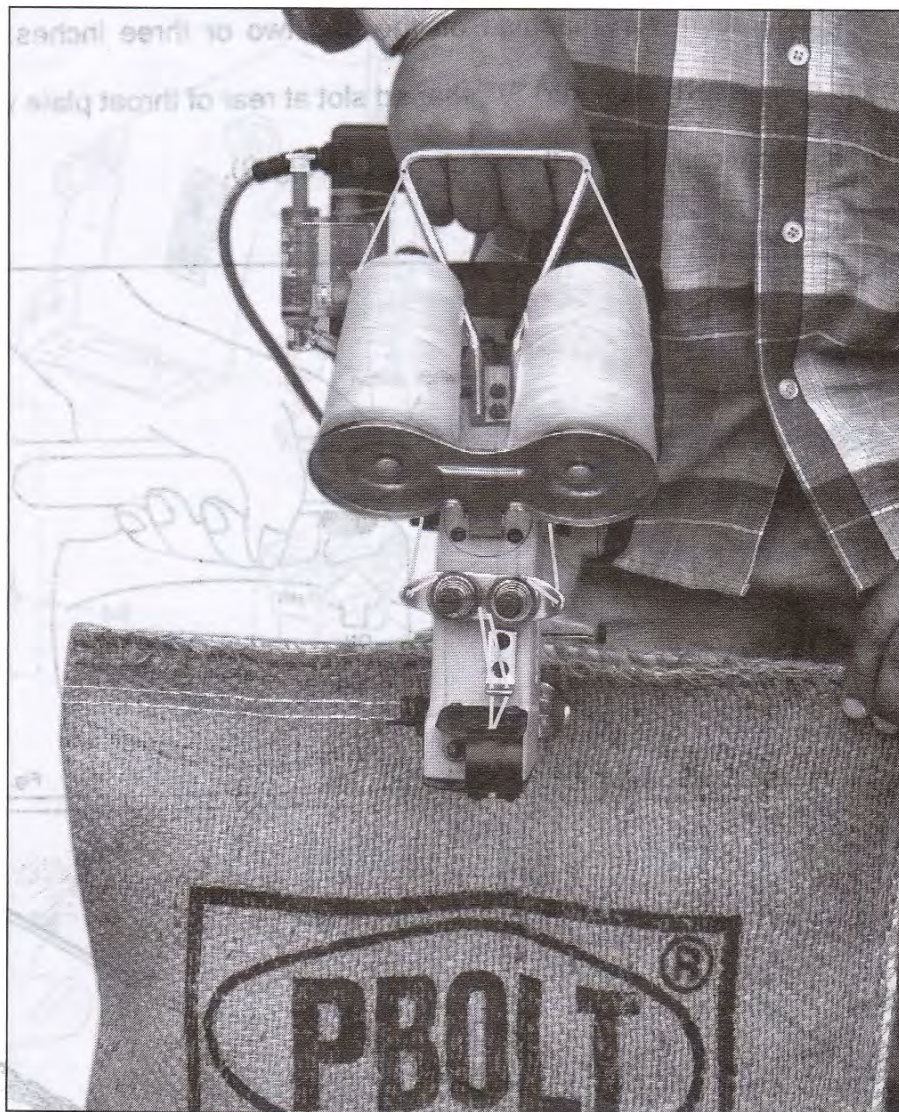
Hold the machine in your right hand (See Fig. 6) and place your index finger on the switch button on the handle (See Fig. 7). Hold the bag lightly in your left hand and insert bag mouth between Feed Dog and Presser Foot (See Fig. 8).

Run the machine while keeping the bag straight. Never pull or pull back the bag. To finish the closing operation, run machine off the bag two or three inches. With machine running, pull thread chain into "V" shaped slot at rear of throat plate where moving knife will automatically cut the thread chain (See Fig. 9).



Operation/Handling

1. Hold the machine at the handle in your right hand.
2. Support the bag slightly by your left hand and insert the edge of a bag between presser foot and feed dog.
3. Push the switch button or the handle by your index finger to stitch the bag. Apart your index finger from the push button stop to the machine.
4. After stitching, the plain chain stitch with 1-2 inches in length shall be pressed down in the groove of throat plate to be cut down by knives mounted on the machine.



< Caution >

Stitch the bag synchronize with the speed of feed dog. If the bag is pulled out faster than that of feed dog. It causes mis-stitch or needle break holding of bag.

Maintenance

- ◆ Please keep in mind to handle the machine carefully and to maintain the machine in good condition.
- ◆ Thread fuzz or dust must be cleaned with air or brush on throat plate, in the groove of feed dog or around looper after the day's work.
- ◆ Wipe the area easy to rust with oil cloth.
- ◆ Check the machine for loose screws and tighten them, if any, once a month.
- ◆ Good maintenance will prolong the machine life.

Troubleshooting

If machine skips stitches or fails to chain off, the cause could be any of the following:

1. Improper threading or tension (see THREADING section on page 9)
2. Bent or incorrectly installed needle
3. Damaged or misadjusted looper
4. Excessive wear, requiring rebuilding or servicing
5. Incorrect needle bar setting. To check these adjustments or replace these

Parts, carefully follow instruction listed below:

Do not disturb main bearing, part no. T605 or looper cam, part no. T310. They are timed and set at the factory.

Thread Tension Adjustment

Tension is the degree of resistance the thread experiences in passing between the tension discs, part No. T113 - 2 (Page No. 23). If tension is too loose, it will cause the thread to break or will leave loose loops of thread on the bag instead of firm stitches. If tension is too tight, it will also cause the thread to break or will cause bag to pucker. In either case, the machine may not chain off. To reduce the amount of tension, turn upper tension nut, part No. T113 - 4 (Page No. 23) anticlockwise. Then turn lower tension nut, part No. T113 - 4 (Page No. 23) anticlockwise. Turn both tension nuts clockwise to tighten tension, first the lower and then the upper nut. Test on material until desired stitch appearance is obtained. Be sure to re-lock upper tension nut in both cases, ie. when reducing or increasing thread tension.

Looper Installation

To install new or replace looper, loosen allen key screw T301-1 (page 25) from T301 (Page 25) Remove T301 (pg 25) and loosen T300-1 (page 25). This will allow the looper T300 (page 25) to become loose. Replace looper and tighten T301 (page 25) on to T300 (page 24) the allen key screw T301-1 (page 25).

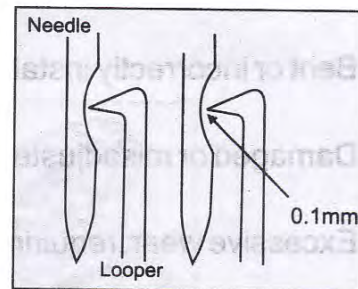


Figure No. 10

The point of the looper must pass through the center of the needle scarf with about 0.1mm clearance (See Fig. No. 10) between looper point and needle. The scarf is the hollowed out section just above eye of the needle. (See Fig. No. 10). Unless the looper holder and/or needle bar has moved or slipped, the looper will time up automatically. If necessary, adjust clearance between looper point and needle by loosening the looper holder clamp screw and sliding the looper holder in or out on looper shaft as required. Make sure the looper does not touch the needle in its path. See next section for needle bar adjustment.

Looper Timing Adjustment

Looper timing adjustment is not required after looper has been replaced. It is only required when the looper shaft, looper cam or cam follower is replaced. Looper timing is correct when distance between looper (when furthest away) from needle is approximately 1mm.

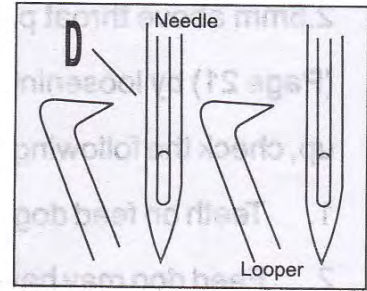


Figure No. 11

(See Fig No. 11). To adjust this distance loosen T307-1 (page 25) and T307-2 (Page 25). This will allow to turn T303 (Page 25) to adjust and set the distance of approx 0.8mm between looper (when furthest away) and needle. The point of looper must pass through centre of needle scarf with clearance of 0.1mm (See Fig. No.11)

Needle Bar Adjustment

This is required when replacing the needle bar (Part no. T500) or needle bar bushes part no. T503 & T504 (page 21) Remove needle bar guard, (Part no. D101) and loosen T405 (page 21) from T405-1 (page 21) Allen screws. Adjust the height of the needle bar so

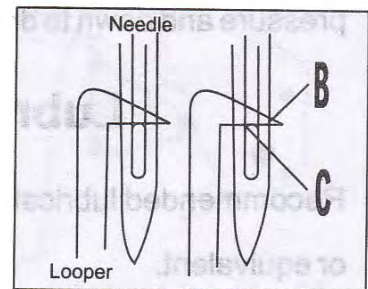


Figure No. 12

the bottom part of the looper tip is 1mm higher from the hole of the needle. Tighten T502-3 screw and fit the needle bar ground on the machine. Turn machine pulley in normal sewing direction until looper is in approximate position (as shown in Fig. No. 12) when the needle is on the up stroke. Slightly loosen clamping screw on needle bar clamp, part No. T502 - 2 (Page No. 21). Raise or lower needle bar and/or turn machine pulley to bring looper point flush with or not more than 0.5mm back from edge of the needle, (See B in Fig. No. 12), and to align bottom edge of looper flush with top of needle eye, (See C in Fig. No. 12).

Do not change looper setting. Securely lock needle bar clamp and replace needle bar guard. Check again for proper needle/looper clearance. (Fig. No. 10)

Position of Feed Dog

The Length of stitch is 7mm per stitch. The rear end of the feed dog should be 2.5mm above throat plate at its highest position. To adjust height, remove T210 (Page 21) by loosening T210-1 (Page 21) screw (3 in all). If the stitches shorten up, check the following :

1. Teeth on feed dog may have worn, Feed dog must then be replaced.
2. Feed dog may have slipped so that the teeth protrude less than 2mm.

Merely raise the feed dog by raising the adjusting screws No. T203-1 (page 25) located on the feed carrier block. Note the set of locking nut with screws No. T203-1 (page 25) on the under side of the feed dog carrier block.

Pressure of Presser Foot

When adjusting the pressure of Presser Foot, take out Needle Bar Guard and loosen Screw of Presser Bar Connection. Move up Presser Bar to increase the pressure and down to decrease. After the adjustment, tighten the Screw firmly.

Lubrication and Maintenance

Recommended lubrication are Shell X-100, Motor Oil 10W/30, Shell Vitria Oil 31 or equivalent.

Cleaning

Clean the machine at the end of the day's work and oil the bushings, shaft etc. that are not lubricated by the lubricator. Wipe dust and other foreign matter off the Feed Dog teeth, Looper and Throat Plate eyelet where they are easily gathered.

Care should be taken to keep the machine free from dust and dirt, especially when leaving it unused for some time.

Important !

When adjusting the machine or replacing parts, always disconnect the Electric Cord from the power source. This is for the safety of the operator.

CARE OF MOTOR

Brushes should be inspected at regular intervals so that wear can be detected and replaced before they are about 1/8" in length.

To remove brushes, take out two cap screws from each side of motor, when replacing brush, be sure it is replaced at the same axial position as removed. Spare brushes are provided with machine and can be purchased from us or our authorised distributors/dealers.

Motors do not operate properly unless the bearings are kept well lubricated. Ball bearings are sealed with grease sufficient for a period from one to two years, depending on the service given by the motor and temperature of the room in which it operates. To refill, remove the end caps covering the bearing and clean out the old grease before applying new grease.

Motor Protection Due to Overload/Overvoltage

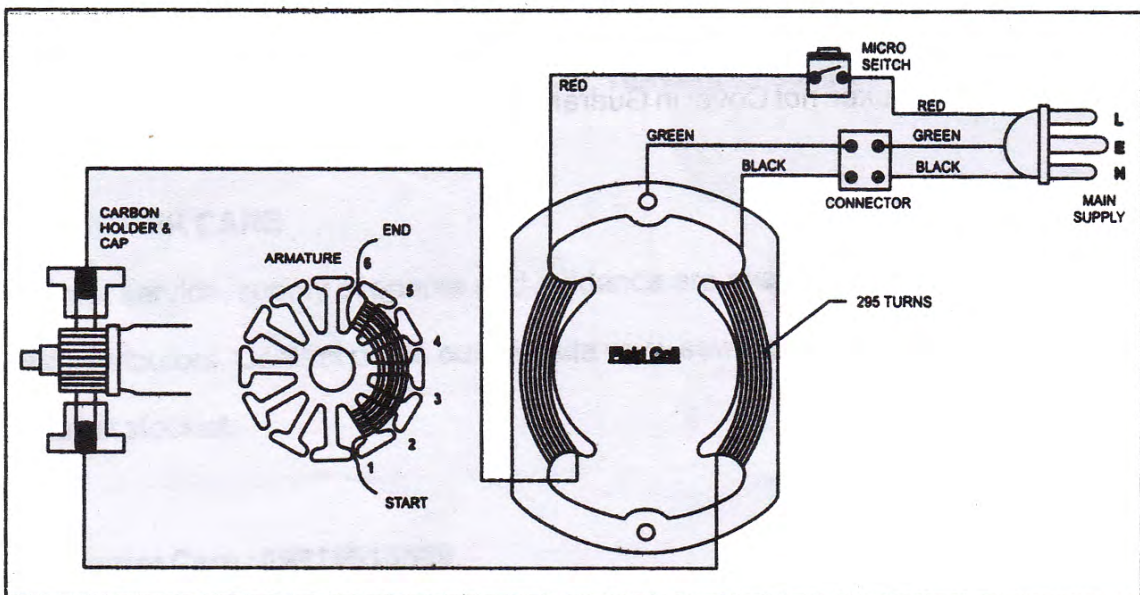
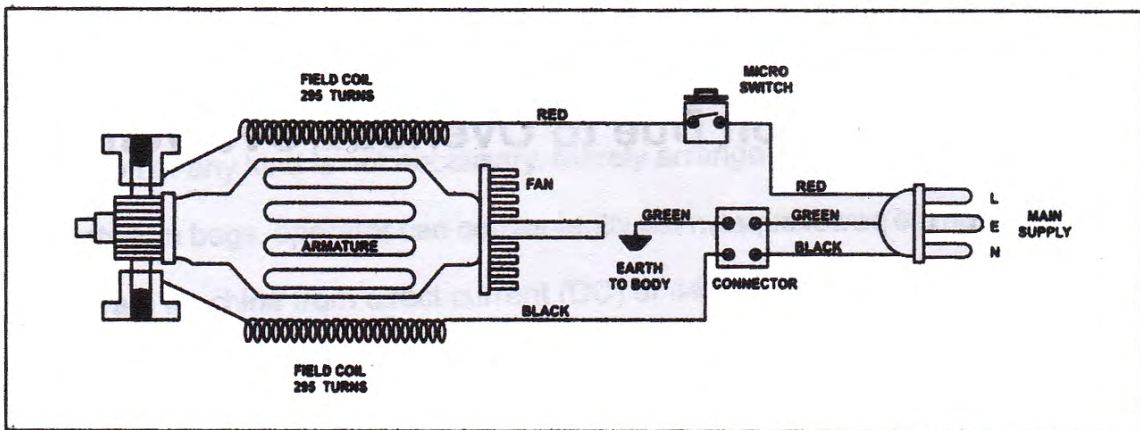
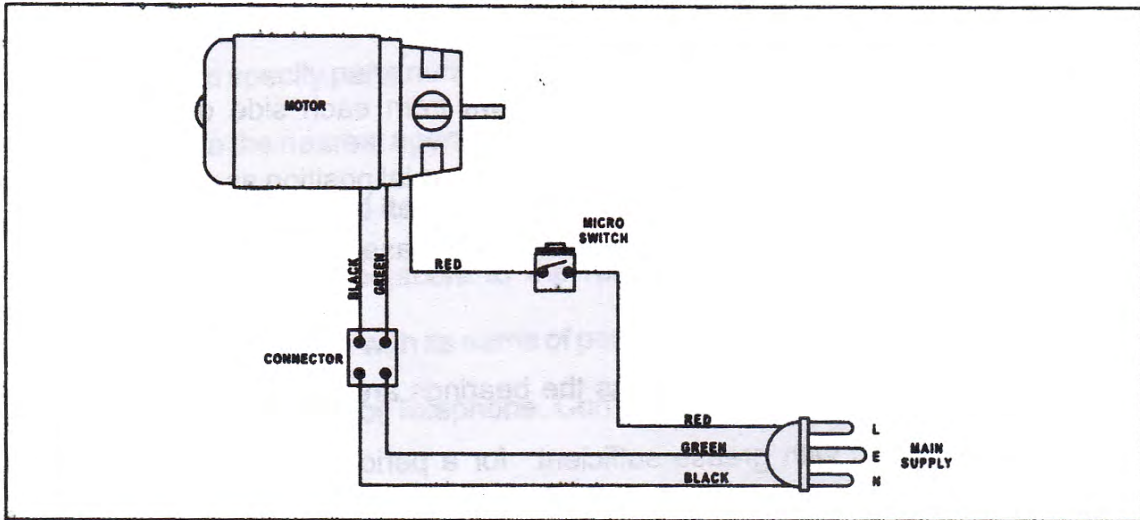
MCB install on the power supply.

Guarantee

All Revo[®] machines are warranted against manufacturing defects for 90 days from the date of purchase.

- ◆ No Guarantee against Rubber and electrical parts.
- ◆ Accident / Broken not Cover in Guarantee

Wiring Diagram



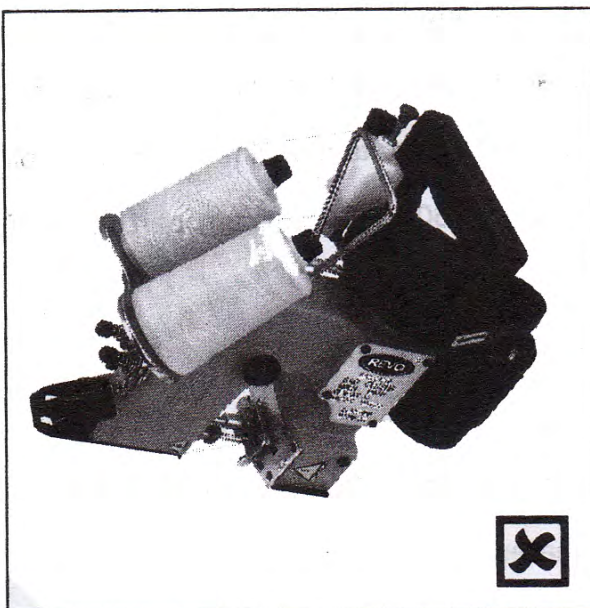
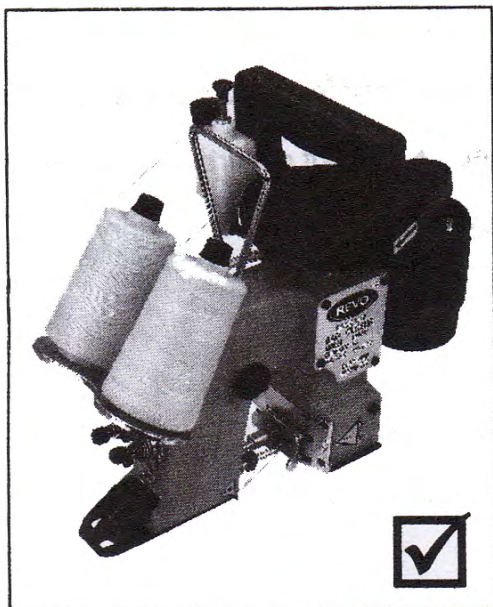
Transportation

Store the machine in dry area.
Ideal position to keep this machine is as under



Storage

Store the machine in dry area.
Ideal position to keep this machine is as under



Please study this manual before operating the machine

Identifying and Ordering Parts

The parts list showing all the parts used in the machine is included in this book.

Check the list, and specify parts numbers and quantities required clearly.

Send your order to the nearest agent, distributor of one of our branch offices.

Description of each part and its number is described in this parts list. Screws and nuts for parts are shown adjacent to the relevant parts. When ordering parts, describe clearly the number with its name of part.

Contact us via E-mail, Post or Telephone. Complete contact details are given at the back page of this manual.

GENERAL RECOMMENDATIONS

The machine uses 9-ply thread, wound on 1000 Mtrs. cones. Use correct thread, taking the advise of regional distributors.

Installation of any kind is not necessary. Merely arrange a box, shelf or bracket so that, between bags, operator can conveniently set machine down or hang it up. Do not operate machine from direct current (DC) or 440 volt line unless machine has been specifically ordered for same. Machines are available with 110 & 220Volts electric powered motor.

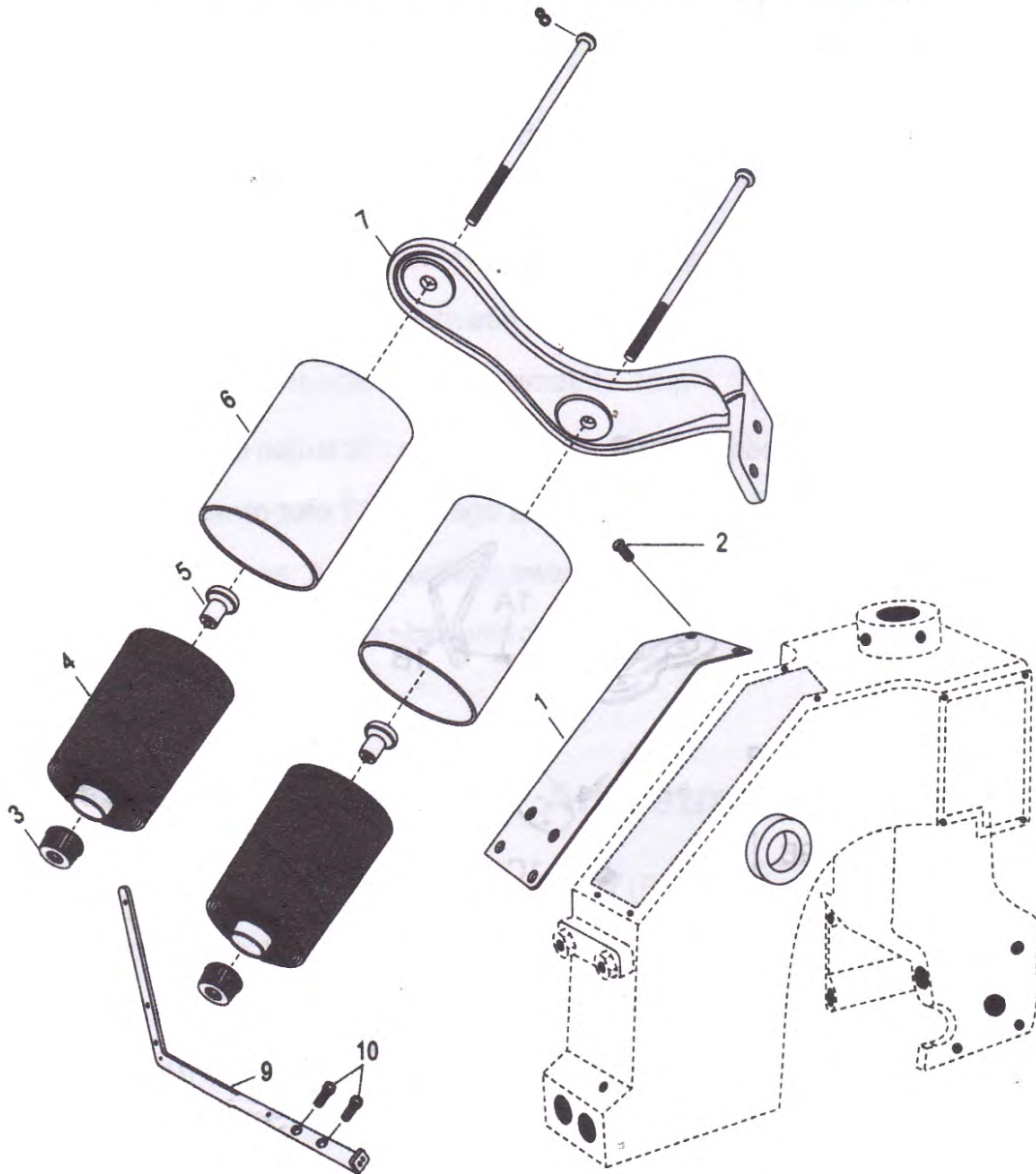
Machine feeds automatically. Don't pull or hold it back as it feeds across the bag. Do not try to operate machine with bent or blunt needle. Do not disturb main bearing, part No. T605, or looper cam, part No. T310. They are timed and set at factory.

CUSTOMER CARE

Prompt service, supply of spares and guidance are available from our factory and our distributors. Contact us via our website www.sewingnet.com for details on your nearest stockist.

Customer Care : 09915515589

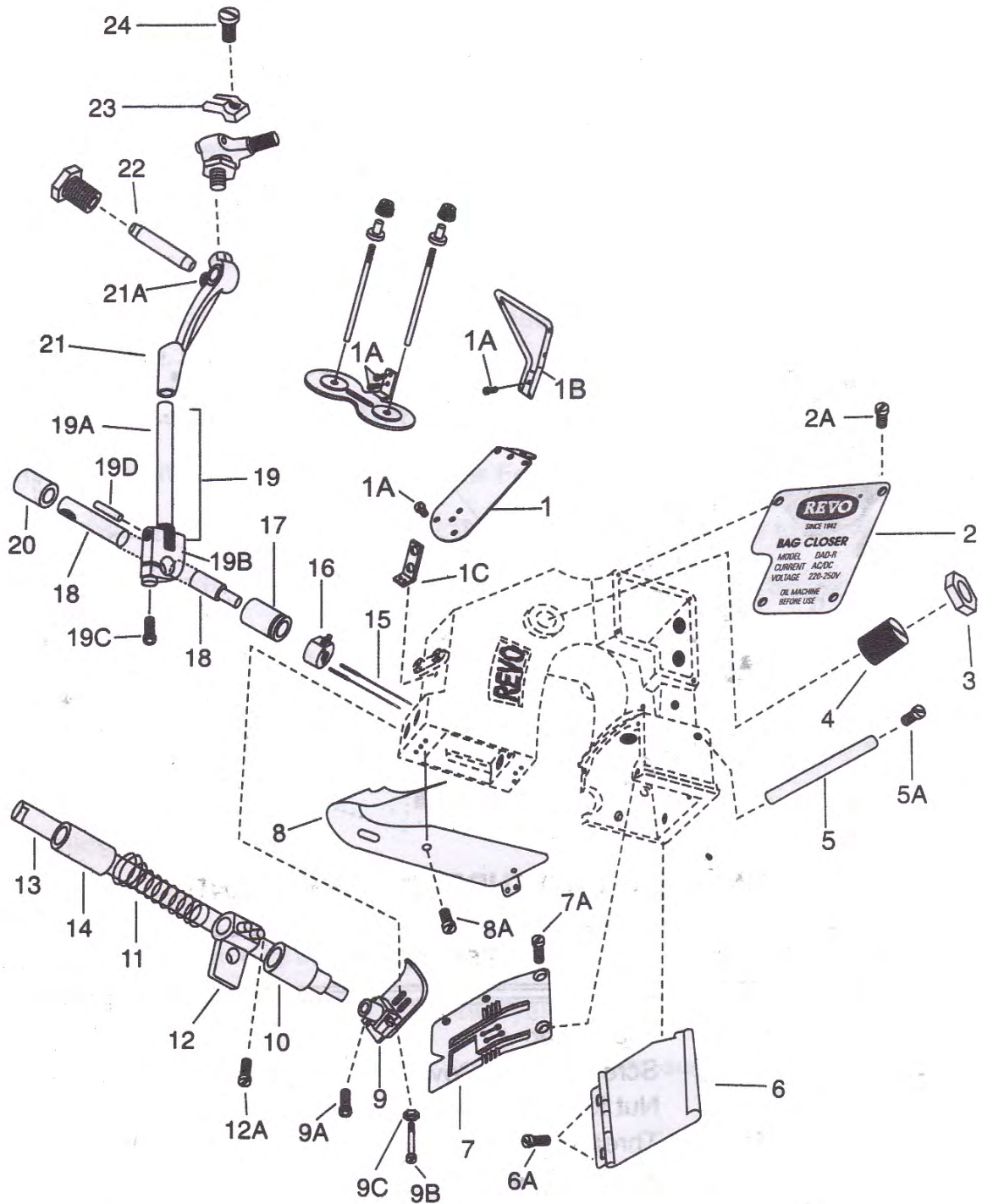
One Side Two Thread Cone Stand



ONE SIDE TWO THREAD CONE STAND

INDEX	PART NO.	DESCRIPTION	QNTY.
1	TS119	Top Cover	1
2	T119-1	Screw for Top Cover	4
3	T805	Nut for P-804	2
4	T810P	Thread Cone	2
5	T807-1	Rubber Clamp	2
6	T807	Thread Cone Cup	2
7	T815D	Thread Cone Stand	1
8	T804	Bolt Thread Clumping	2
9	T120D	Thread Guide	1
10	T120-1	Allen Bolt for Thread Guide	2

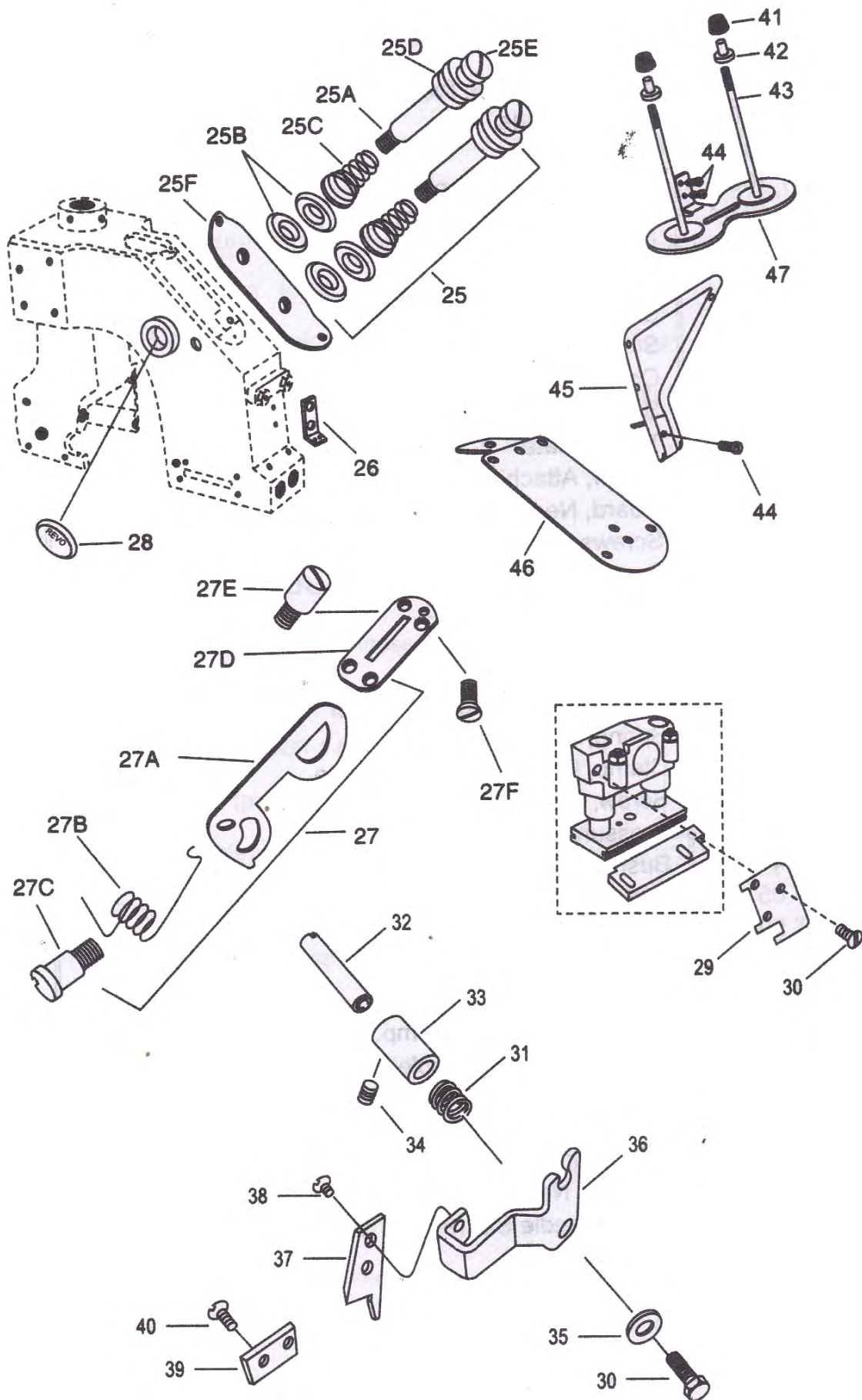
PLATE A



REFERENCE PLATE A - ORDER BY PART NUMBER

INDEX	PART NO.	DESCRIPTION	QNTY.
1	TR 119	Cover, Top	1
1A	T 119-1	Screw, Attaching for T119	4
1B	T 120-R	Thread Guide	1
1C	T 109	Thread Eyelet	1
2	T 103	Cover, Side Nameplate	1
2A	T 103-1	Screw, Attaching for T103	4
3	T 513	Lock Ring	2
4	T 512	Bearing, Cone	2
5	T 214	Stud, feed Dog Carrier Slide	1
5A	T 214-1	Screw, Attaching for T214	2
6	T 102-1	Cover, Looper Hing Type	1
6A	T 108	Screw, Attaching for T102	2
7	T 210N	Throat Plate	1
7A	T 210-1	Screw, Attaching for T210	3
8	T 101	Guard, Needle Bar	1
8A	T 101-1	Screws, Attaching for T101	4
9	T 400	Presser Foot Complete	1
9A	T 400-1	Hinging Bolt for T400	2
9B	T 400-2	Bolt for T400	1
9C	T 400-3	Nut for T400-2	1
10	T 413	Bushing, Pressure Bar, Lower	1
11	T 414	Spring, Pressure Bar	1
12	T 405	Clamp, Pressure Bar, complete	1
12A	T 405-1	Screw, Clamping for T405	2
13	T 404	Pressure Bar	1
14	T 412	Bushing, Pressure Bar Upper	1
15	T 05	Needle DB x 1 size 25/200 (Groz Beckett)	2
16	T 501	Needle Holder	1
17	T 504	Bushing, Needle Bar, Lower	1
18	T 500	Needle Bar	1
19	T 502	Clamp, Needle Bar Comp. Avl. 9.51, 7.93mm	1
19A	T 502-1	Pin For T 500 (Available. in 9.51, 7.93 mm)	1
19B	T 502-2	Clamp only, Needle Bar	1
19C	T 502-3	Screws, Clamping for T502	1
19D	T 502-4	Clamp Pin	1
20	T 503	Bushing, Needle bar Upper	1
21	T 505	Lever, Needle Bar (9.51, 7.93mm)	1
21A	T 505-1	Screw for T505	2
22	T 511	Stud, Needle Bar Lever	1
23	T 607-3	Guide	1
24	T 607-4	Screw for T607-3	1

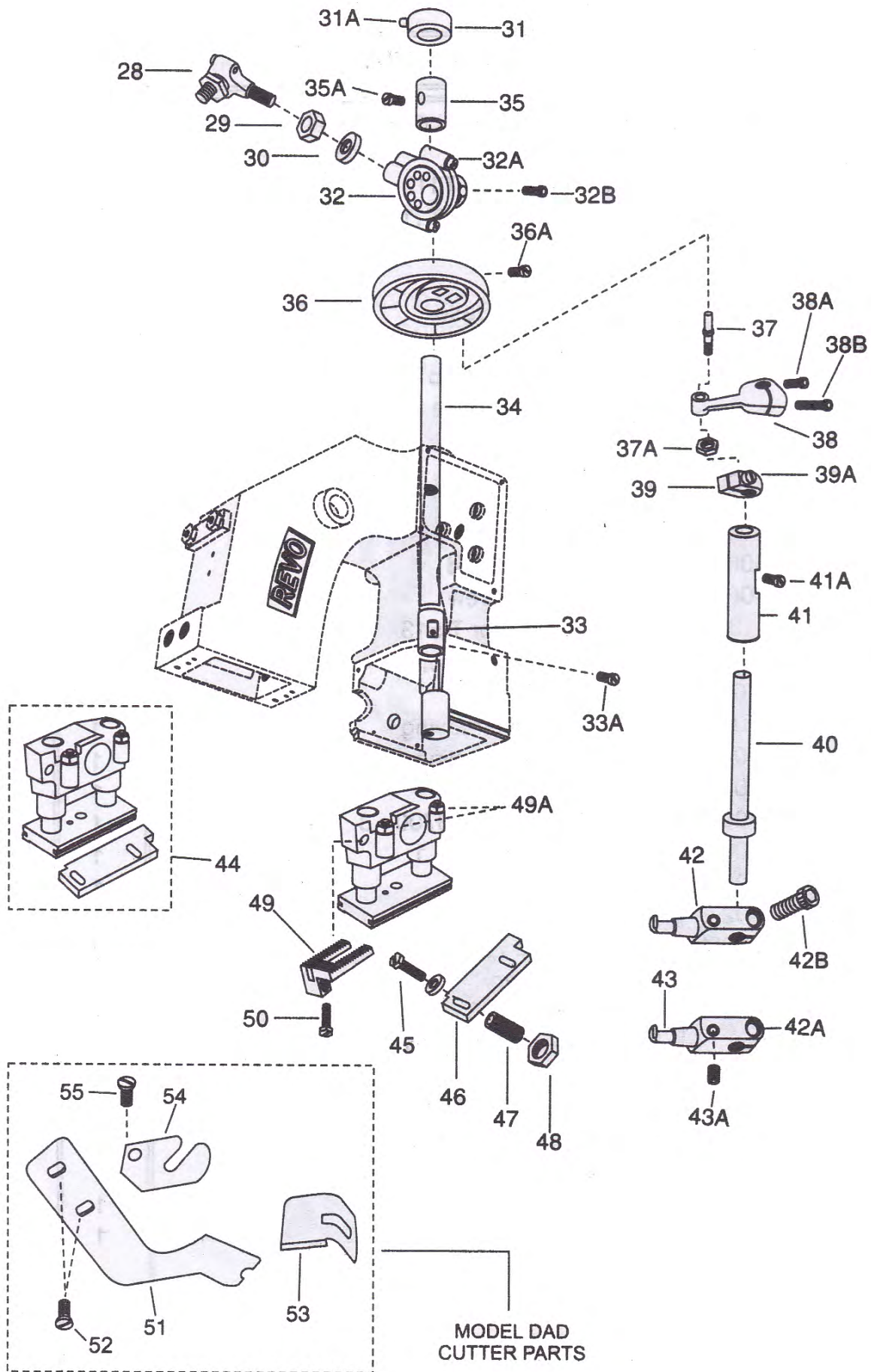
PLATE B



REFERENCE PLATE B - ORDER BY PART NUMBER

INDEX	PART NO.	DESCRIPTION	QNTY.
25	T 113	Tension Assembly complete	1
25A	T 113-1	Rod for T113	1
25B	T 113-2	Tension Plate for T113	2
25C	T 113-3	Tension Spring for T113	2
25D	T 113-4	Tension Nut	2
25E	T 113-5	Tension Screw	1
25F	T 114	Thread Guide Base	1
26	T 109	Eyelet	1
27	T 406	Pressure Bar Clamp Lifter Lever Assembly Complete	1
27A	T 406-1	Lifter Lever	1
27B	T 406-2	Lifter Spring	1
27C	T 406-3	Lifter Fixing Screw	1
27D	T 406-4	Lifter Eyelet	1
27E	T 406-5	Lifter Stopper Stud	1
27F	T 406-6	Lifter Eyelet Screw	3
28	T 513-1	Plastic Cover for T 513	2
29	TS700	Knife Bracket Support	1
30	TS700-1	Screw for TS 700	2
31	TS700-2	Spring for knife moving	1
32	TS700-3	Shaft for knife moving	1
33	TS700-4	Bush for TS700 - 3	1
34	TS700-5	Screw for Bush of S700 - 3	1
35	TS700-6	Washer for TS700 - 1	1
36	TS701	Knife Bracket	1
37	TS702	Knife Moving	1
38	TS702-1	Screw for TS 702	2
39	TS703	Knife Stationary	1
40	TS703-1	Screw for TS 703	2
41	T805	Thread Cone Clamp Nut	2
42	T807-1	Rubber Clamp	2
43	T804	Bolt Thread Clamping	2
44	T119-1	Screw for Thread Stand	2
45	T120-R	Thread Guide	1
46	TR119	Top Cover	1
47	TS815	Thread Cone Stand	1

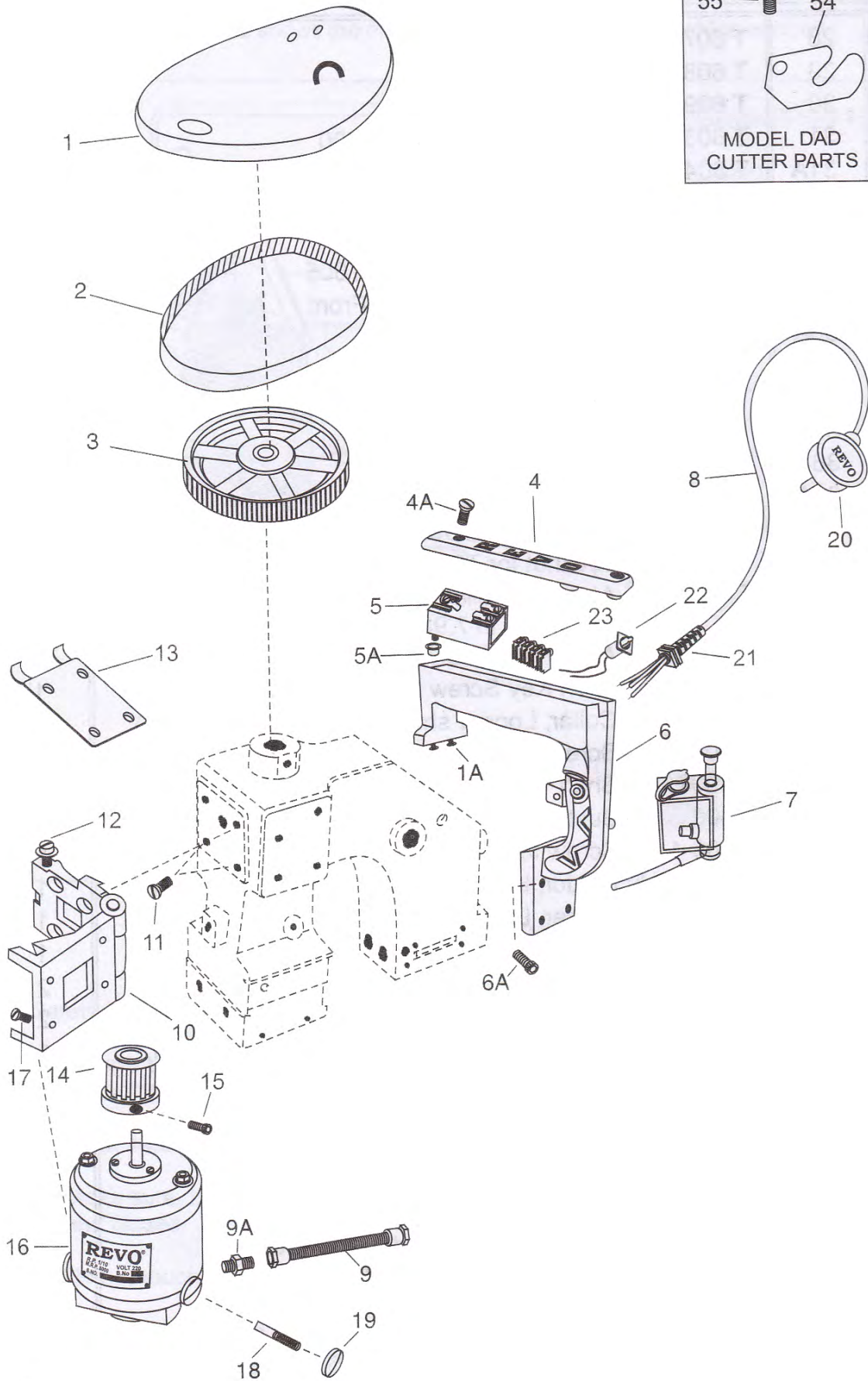
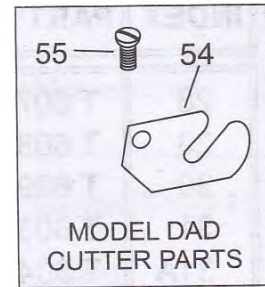
PLATE C



REFERENCE PLATE C - ORDER BY PART NUMBER

INDEX	PART NO.	DESCRIPTION	QNTY.
28	T 607	Bearing, Rod End	1
29	T 608	Locknut for T607	1
30	T 609	Lockwasher	1
31	T 603	Collar, Retaining for T600	1
31A	T 604	Screw, Clamping for T603	3
32	T 605	Connecting Rod and Eccentric Complete	1
32A	T 605-1	Screw, set for T605	2
32B	T 606	Screw Cone point for T605	1
33	T 602	Bushing, Main Shaft, Front	1
33A	T 602-1	Screw for T602	1
34	T 600	Main Shaft	1
35	T 601	Bushing, Main Shaft, Rear	1
35A	T 601-1	Screw for T601	1
36	T 310	Cam, Looper complete	1
36A	T 310-1	Screw Set for T310	3
37	T 308	Stud, cam follower (Compl. with T307)	1
37A	T 309	Locknut for T308	1
38	T 307	Arm Cam follower (Compl. with T308) (Available in 7.93, 6.34mm)	1
38A	T 307-1	Allen Key Screw for T307 (Small)	1
38B	T 307-2	Allen Key Screw for T307 (Big)	1
39	T 304	Collar, Looper shaft (Avl. in 7.93, 6.34mm)	1
39B	T 304-1	Screw, Clamping for T304	1
40	T 303+5	Shaft, Looper with Coller (Avl. 7.93, 6.34mm)	1
41	T 306	Bushing for T303 (Avl. in 7.93, 6.34mm)	1
41A	T 306-1	Screw for T306	1
42	T 301	Holder, Looper (Right) (Avl. in 7.93, 6.34mm)	1
42A	T 302	Holder, Looper (Left) (Avl. in 7.93, 6.34mm)	1
42B	T 301-1	Screw, Clamping for T301	1
43	T 300	Looper	2
43A	T 300-1	Screw Looper Set	2
44	T 200	Feed Dog Carrier Block with Slide Compl.	1
45	T 205-1	Lock Bolt for T 205	2
46	T 205	Slide Block, Adjusting	1
47	T 206	Stud, Slide Block Adjusting Support	2
48	T 209	Locknut for T206	2
49	T 203	Feed Dog	1
49A	T 203-1	Screw Feed Dog Adjusting with Nut	2
50	T 204	Screw, Attaching for T203	1
51	T 701	Knife Bracket	1
52	T 701-1	Screw for T 703	2

PLATE D



REFERENCE PLATE D - ORDER BY PART NUMBER

INDEX	PART NO.	DESCRIPTION	QNTY.
53	T 702	Knife Moving	1
54	T 703	Knife Stationery	1
55	T 703-1	Screw for T 703	1
1	T 105	Guard for Belt	1
1A	T 105-1	Screw, Attaching for T105	3
2	T 910	Timming Belt	1
3	T 905	Pulley, Machine	1
3A	T 905-1	Screw for T905	2
4	T 802	Switch Cover	1
4A	T 802-1	Screw, Attaching for T802	2
5	T 806	Micro Switch	1
5A	T 806-1	Plastic Cover for T806	1
6	T 800	Handle complete with Belt Cover	1
6A	T 801	Screw, Attaching for T800	4
7	T 811	Oil Tank cum Pump	1
8	T 808-1	3 Core Cable 12 Feet Long	1
9	T 913	Motor Lead (Flexible Pipe)	1
9A	T 913-1	Locknut for T913	1
10	T 906	Hinged Motor Mount	1
11	T 906-1	Screw, Attaching for T906	4
12	T 908	Screw, set locking for T906	2
13	T 906-3	Packing for T906	1
14	T 903	Timming Pulley, Motor	1
15	T 903-1	Screw for T902	2
16	T 901	Motor (available in 110Volt or 220Volt)	1
17	T 906-1	Screw Attaching for T901	4
18	T 919	Carbon Brush with spring	2
19	T 900-4	Carbon Brush Cap	2
20	T 809	Plug	1
21	T808 - 2	Handle Wire Sleeve	1
22	T808 - 3	Indicator Bulb	1
23	T808 - 4	Wire Connector Stick	1

PLATE E

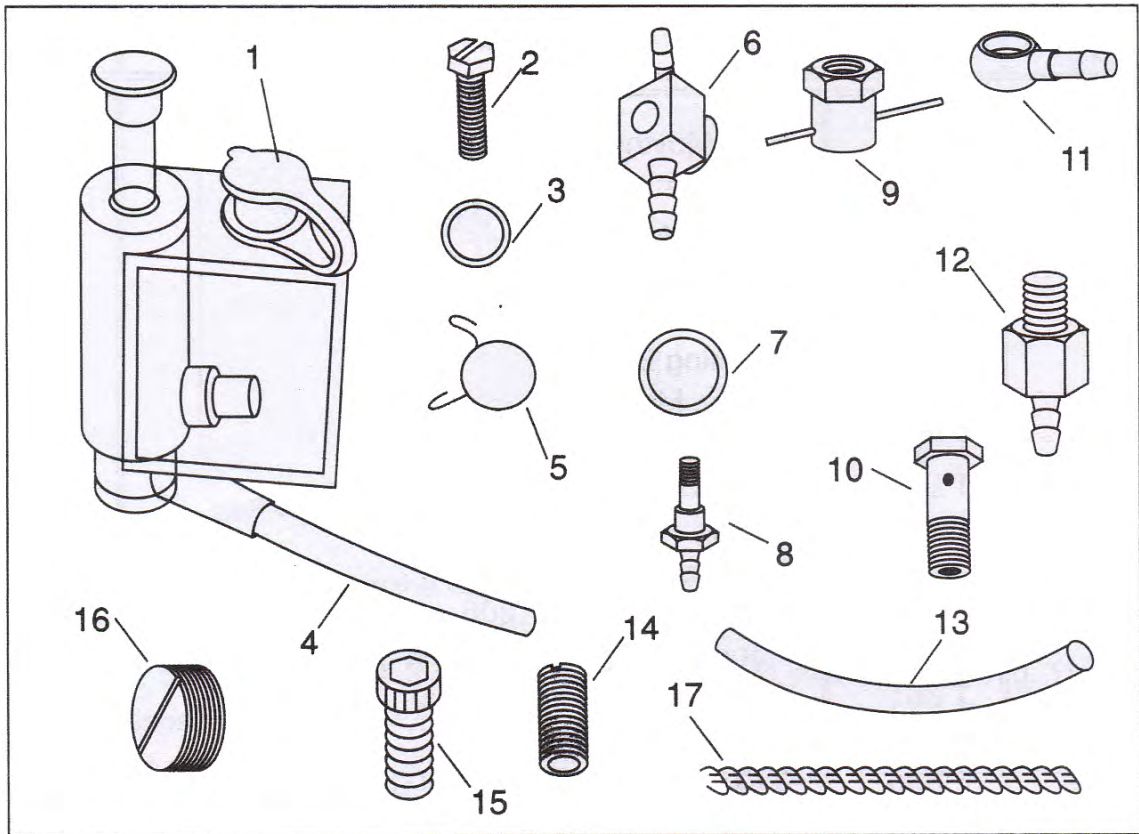


PLATE F

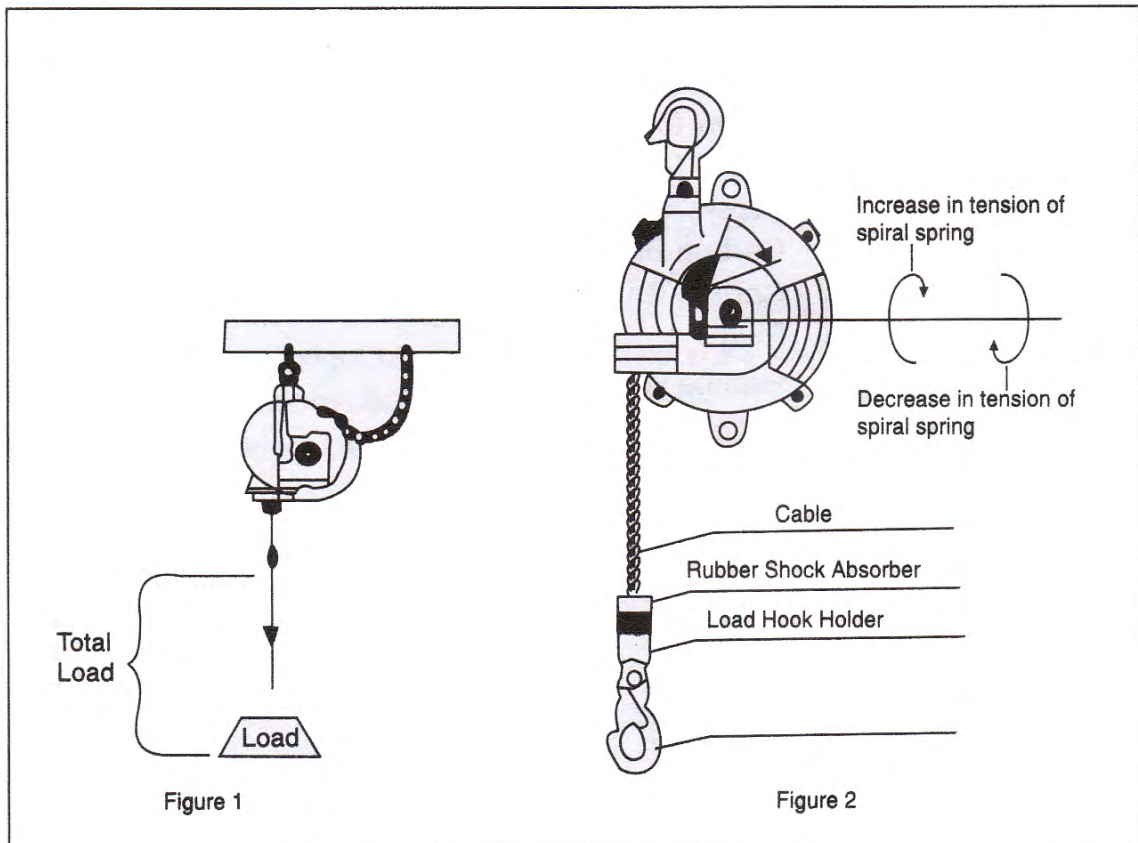


PLATE E - SPARE PARTS FOR OIL TANK CUM PUMP

INDEX	PART NO.	DESCRIPTION	QNTY.
1	T811	Oil Tank Cum Pump	1
2	T811-1	Screw Attaching Pump	1
3	T811-2	Washer for T811-1	1
4	T811-3	Plastic Pipe	1
5	T811-4	Clip for T811-3	1
6	T811-5	Oil Distributor	1
7	T811-6	Washer Small for T811-5	1
8	T811-7	Oil Distributor Screw for T811-5	1
9	T811-8	Oil Supplier	1
10	T811-9	Oil Supplier Bolt for T811-8	1
11	T811-10	Banjo T Nipple for T811-8	1
12	T811-11	Oil Nipple	1
13	T811-12	Pipe (Large)	1
14	T811-13	Oil Preventive Screw for T-600	1
15	T811-14	Oil Preventive Screw for Small Body	1
16	T811-15	Oil Preventive for Big Body	1
17	T811-16	Oil Wick	1

PLATE F - Guidance for Hanging Spring Balance

1. Make sure of the following points & guidance for hanging Spring Balancer as per Figure No. 1.
2. Be sure to fit a secondary support chain or wire rope sling. (Make sure there is enough slack in secondary support chain, so as to be able to turn the top hook freely).
3. It must be in a position to operate smoothly, even if, the spring balancer be used in slanting position.
4. Ensure that the balancer is fastened **securely**.
5. Always ensure that the top hook, holding the balancer, is free to rotate.
6. Adjust the tension of spring balancer according to its loading weight. Tension of spiral spring increases when turning the worm clockwise direction to decrease the tension of spiral spring for load in lesser weight turn worm counter clockwise direction as per Figure No. 2.

PLATE G

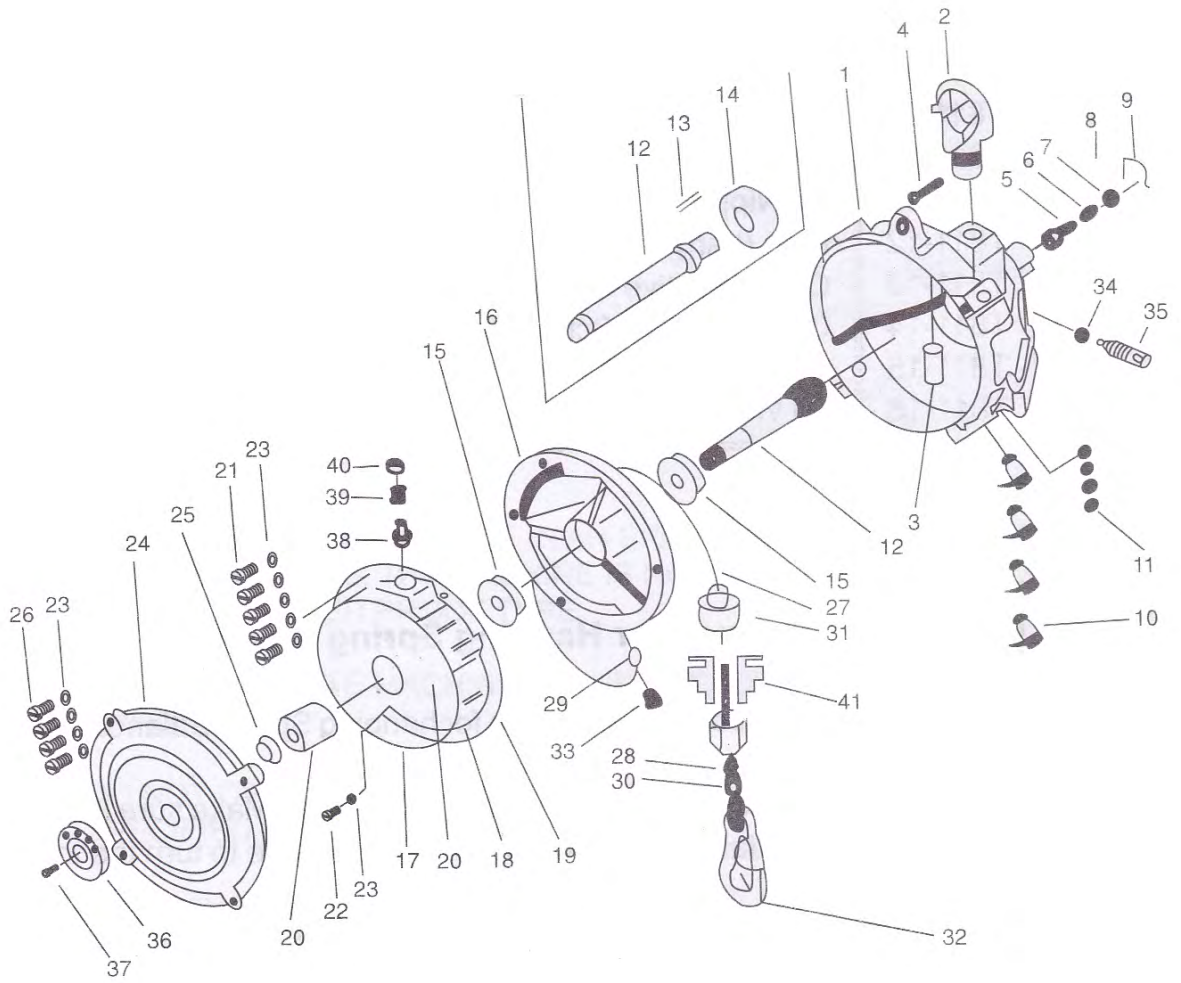


PLATE G - SPARE PARTS FOR SPRING BALANCER

INDEX	PART NO.	DESCRIPTION	QNTY.
1	SB 1	Case Suspension	1
2	SB 2	Suspension Hook	1
3	SB 3	Suspension Hook Shaft	1
4	SB 4	Suspension Hook Rivert	1
5	SB 5	Stopper Pin	1
6	SB 6	Stopper Spring	1
7	SB 7	Stopper Pin Holder	1
8	SB 8	Stop Ring Pin	1
9	SB 9	Stopper Lever	1
10	SB 10	Safety Stop Arm	1
11	SB 11	Hex Cap Screw	1
12	SB 12	Spindle	1
13	SB 13	Key	1
14	SB 14	Worm Wheel	1
15	SB 15	Ball Bearing	1
16	SB 16	Drum Self-Contained Spring Assly.	1
17	SB 17	Spiral Spring	1
18	SB 18	Spiral Case	1
19	SB 19	Spring Case Cover	1
20	SB 20	Bushing	1
21	SB 21	Hex Bolt	1
22	SB 22	Hex Bolt	1
23	SB 23	Spring Washer	10
24	SB 24	Casing Cover	1
25	SB 25	Casing Cover Bushing	1
26	SB 26	Hex Bolt Cable cplt.	1
27	SB 27	Cable	1
28	SB 28	Washer	1
29	SB 29	Lock (A)	1
30	SB 30	Lock (B)	1
31	SB 31	Rubber Shock Load Hook Latch	1
32	SB 32	Load Hook	1
33	SB 33	Cable Set-Bolt	1
34	SB 34	Thrust Washer	1
35	SB 35	Worm	1
36	SB 36	Gauge	1
37	SB 37	Gauge Screw	1
38	SB 38	Safety Device Pin	1
39	SB 39	Safety Device Spring	1
40	SB 40	Safety Device Spring Screw	1
41	SB 41	Adjustable Cable Stop Taper But	1

PLATE H

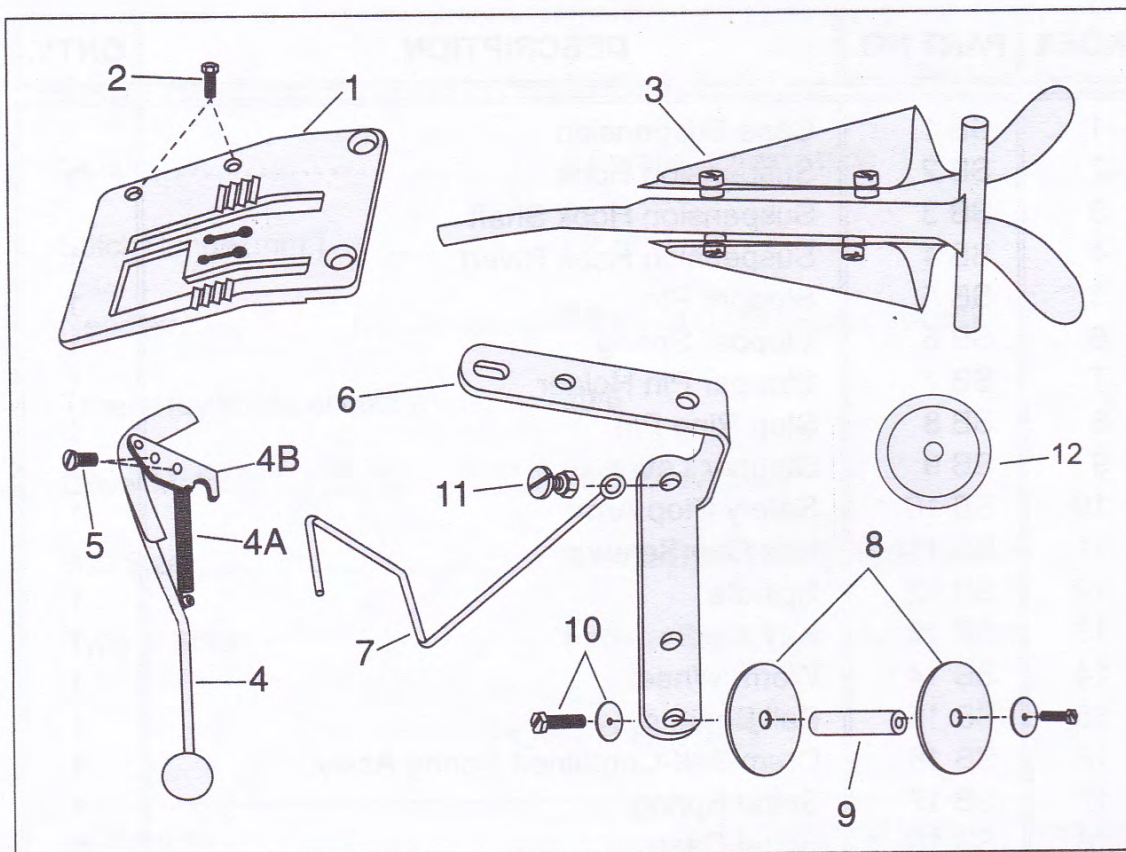


PLATE H - SPARE PARTS FOR TAPE BINDING ATTACHMENT

INDEX	PART NO.	DESCRIPTION	QNTY.
1	TC 01	Throat Plate	1
2	C 02	Bolt for C 01	2
3	C 03	Tape Folder (Avail. in 2inch & 2.5inch)	1
4	C 04	Cutter	1
4A	C 04-1	Cutter Spring	1
4B	C 04-2	Fix Cutter	1
5	C 05	Screw for C 04	2
6	C 06	Tape Handling Attachment	1
7	C 07	Tape Binding Hook (Avail. in 2inch & 2.5inch)	1
8	C 08	Tape Binder	2
9	C 09	Tape Binder Stud (Avail. in 2inch & 2.5inch)	1
10	C 10	Screw & Washer for C 09	2
11	C 11	Lock Nut & Bolt for C 07	1
12	C 23	Crepe Paper Tape Roll (Avail. in 2inch & 2.5inch width)	1

ONE SIDE TWO THREAD CONE

INDEX	PART NO.	DESCRIPTION	QNTY.
1	TS119	Top Cover	1
2	T815 D	Thread Stand	2
3	T120 D	Thread Guide	1
4	T103	Cover Side Name Plate	1
5	T 807	Thread Cone Cup	2
6	T 804	Thread Clamp Bolt	2
7	T 805	Nut for T804	2
8	T 810 P	Thread Cone	2

EACH SIDE ONE THREAD CONE

INDEX	PART NO.	DESCRIPTION	QNTY.
1	T119 N	Top Cover	1
2	T815	Thread Stand	2
3	T120 N	Thread Guide	1
4	T103 S	Cover Side Name Plate	1
5	T 807	Thread Cone Cup	2
6	T 804	Thread Clamp Bolt	2
7	T 805	Nut for T804	2
8	T 810 P	Thread Cone	2

General Notes

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