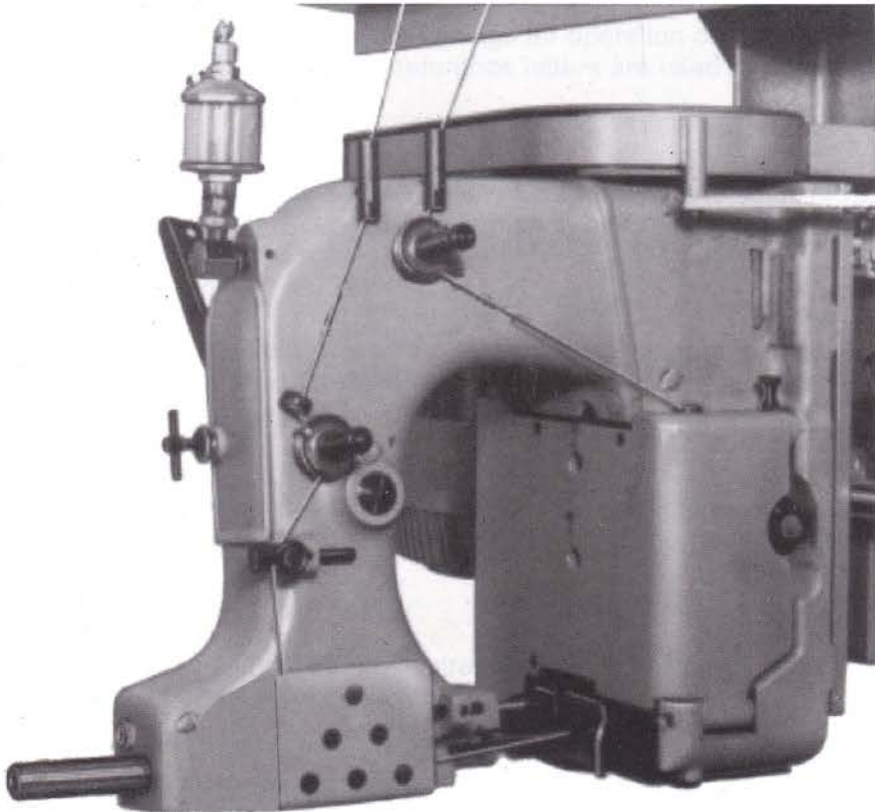




Pioneer in Bag Sewing Machines

**SEWING MACHINE FOR CLOSING FILLED BAGS  
MODEL - 80800**

**INSTRUCTION MANUAL / PARTS LIST**



**SWARUP MECHANICAL WORKS**

Overlock Buildings, Overlock Road, LUDHIANA-141 003.(India)  
Ph. : 2530774, 2546030, 5005940, 2672174 Fax : 91-161-2533751  
Web : [www.sewingnet.com](http://www.sewingnet.com), [www.sewingmaker.com](http://www.sewingmaker.com)  
[www.revoindia.com](http://www.revoindia.com) E- mail : [sales@revoindia.com](mailto:sales@revoindia.com)

# INSTRUCTIONS FOR 80800 SERIES MACHINES

## PREFACE

This manual has been prepared to guide you while operating 80800 series machines and arranged to simplify ordering wear and spare parts.

This manual explains in detail the proper settings for operation of the machines. Illustrations are used to show the adjustments and reference letters are used to point out specific items discussed.

Careful attention to the instructions and cautions for operating and adjusting these machines will enable you to maintain the superior performance and reliability designed and built into every Revo Bag Closing Machine.

Adjustments and cautions are presented in sequence so that a logical progression is accomplished. Some adjustments performed out of sequence may have an adverse effect on the function of the other related parts.

This manual has been comprised on the basis of available information. Changes in design and / or improvements may incorporate a slight modification of configuration in illustrations or cautions.

On the following pages will be found illustrations and terminology used in describing the instructions and the parts for your machine.

In addition to the instructions and to the mandatory rules and regulations for accident prevention and environmental protection in the country and place of use of the machine/unit, the generally recognized technical rules for safe and proper working must be observed.

The instructions are to be supplemented by the respective national rules and regulations for accident prevention and environmental protection.

# INDEX

CONTENTS	PAGE NO.
PREFACE.....	1
IDENTIFICATION AND STYLES OF MACHINES.....	3
SAFETY RULES.....	4
NOISE EMISSION AND OILING DIAGRAM.....	5
LUBRICATION AND OPERATION, NEEDLES, THREADING.....	6
THREADING THE MACHINE.....	7
ADJUSTING INSTRUCTIONS.....	8 - 11
ORDERING WEAR AND SPARE PARTS.....	12
EXPLODED VIEWS AND DESCRIPTION OF PARTS.....	13 - 29
BUSHING OILER AND COVER PARTS.....	14 - 15
CLOTH PLATES AND MISCELLANEOUS COVERS.....	16 - 17
THREAD TENSIONS, THREAD GUIDES AND NEEDLE BAR GUIDE.....	18 - 19
NEEDLE BAR, NEEDLE LEVER, CRANKSHAFT, PULLEY, LOOPER DRIVE AND LOOPER AVOID ECCENTRIC.....	20 - 21
NEEDLE LEVER ASSEMBLY FOR STYLE 80800.....	22 - 23
THREAD CHAIN CUTTER KNIVES AND CHAIN CUTTER KNIFE DRIVE FOR STYLE 80800.....	22 - 23
LOOPER AVOID ECCENTRIC FORK, LOOPER, LOOPER DRIVE LEVER AND ROCKER, LOOPER THREAD CAST-OFF.....	24 - 25
FEED MECHANISM.....	26 - 27
PRESSER FOOT LIFTER AND PRESSER FOOT PARTS.....	28 - 29
PRESSER FEET, THROAT PLATES AND FEED DOGS.....	3
NUMERICAL INDEX OF PARTS.....	31 - 3

## IDENTIFICATION OF MACHINE

Each **REVO** machine is identified by a Style number, which on this Class machine is stamped into the Style plate affixed to the right front of machine. Serial number is stamped into bed casting at the right front base of machine.

## STYLES OF MACHINE

High performance sewing machines with mechanically driven thread chain respectively tape cutters. For closing filled bags and sacks made of jute, cotton, paper, plastic or woven polypropylene tapes as well as bituminized or foil laminated materials.

Equipped with guides for application of filler cord sealing the needle punctures.

Foot switch controlled starting and stopping of the sewing machine. For cutting, the thread chain has to be guided to the thread chain cutter of the machine. On styles with tape cutter, thread chain with binding tape are cut automatically.

One Needle, High Throw, Manual Lubrication, Lateral Looper Travel, Plain Feed.

**80800** Sewing machine for closing filled bags and sacks of all kinds with a two thread double locked stitch. With mechanically driven thread chain cutter. Presser foot with spring loaded chaining section.

## SPECIFICATIONS

Seam specification and stitch type:	Chain stitch sewing machine
Stitch range:	6.5 to 11mm
Standard setting:	8mm
Capacity under presser foot:	11mm (Adjustable upto 16 mm)
Sewing capacity on paper bags:	Upto 32 piles of paper
Working dia. of handwheel:	108mm
Maximum speed:	1800 rpm (Depending on stitch length and speed of conveyor as well as on operation and material)

## TYPES OF BAG CLOSURES





## **SAFETY RULES**

1. Before putting the machine described in this manual into service, carefully read the instructions. The starting of each machine is only permitted after taking notice of the instructions and by qualified operators.

**IMPORTANT !** Before putting the machine into service, also read the safety rules and instructions from the motor supplier.

2. Observe the national safety rules valid for your country.
3. The sewing machine described in this instruction manual is prohibited from being put into service until it has been ascertained that the sewing units which these sewing machines will be built into, have conformed with the provisions of EC Machinery Directive 98/37/EC, Annex II B.

The machine is only allowed to be used as foreseen. The foreseen use of the particular machine is described in paragraph STYLE OF MACHINE of this instruction manual. Another use, going beyond the description, is not as foreseen.

4. All safety devices must be in position when the machine is ready for work or in operation. Operation of the machine without the appertaining safety devices is prohibited.
5. Wear safety glasses.
6. In case of machine conversions and all valid safety rules must be considered. Conversions and changes are made at your own risk.
7. When doing the following machine has to be disconnected from the power supply by turning off the main switch or by pulling out the main plug.
  - 7.1 When threading needle(s), looper, spreader etc.
  - 7.2 When replacing any parts such as needle(s), presser foot, throat plate, looper, spreader, feed dog, needle guard, folder, fabric guide etc.
  - 7.3 When leaving the workplace and when the work place is unattended.
  - 7.4 When doing maintenance work.
  - 7.5 When using clutch motors without actuation lock, wait until motor is stopped totally.
8. Maintenance, repair and conversion work (see item 7) must be done only by trained technicians or special skilled personnel under consideration of the instructions. Only genuine spare parts approved by Revo have to be used for repairs.
9. Any work on the electrical equipment must be done by an electrician or under direction and supervision of special skilled personnel.
10. Work on parts and equipment under electrical power is not permitted. Permissible exceptions are described in the applicable section of standard sheet EN 50110 / VDE 0105.

## NOISE EMISSION

Equivalent continuous A-weighted sound pressure Level ( $L_{pAd}$ ) at workstation dB(A) according to ISO 10821-C.6.3 at 1400 RPM and 50% of duty cycle.

### OILING DIAGRAM

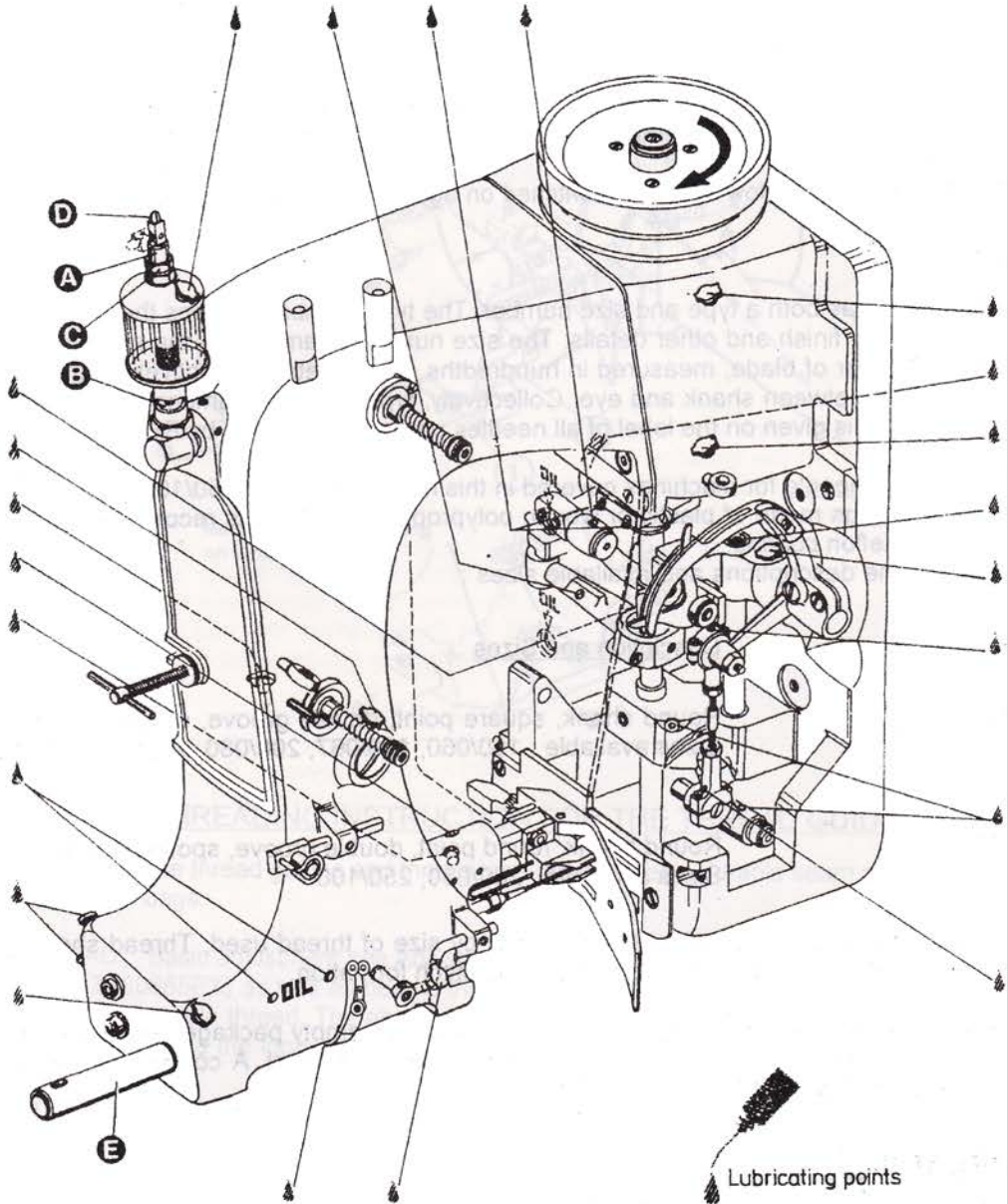


Fig.1

## **LUBRICATION AND OPERATION**

The machine of class 80800 have to be cleaned and lubricated twice a day before the morning and afternoon start on the lubricating points indicating on the oiling diagram (Fig. 1). The sight feed oiler has to be kept filled and should be adjusted so that it feeds two or three drops of oil per minute. The oiler has to be refilled latest, when 2/3 of the oil is used up.

For Lubrication we recommend "Mobil Oil DTE Medium" or equivalent, which can be purchased from Revo.

Before operating a new machine for the first time, the needle bar guard (E, Fig. 1) and the sight feed oiler, which come with the accessories of the machine, have to be screwed in. The sight feed oiler has to be adjusted. All lubricating points, indicated on the oiling diagram (Fig. 1) have to be oiled.

For adjusting fill the sight feed oiler half-way with oil and turn the metering pin (A, Fig. 1) a little bit out and then turn it in, until there will flow approx. two drops of oil per minute. This can be checked on the sight glass (B, Fig. 1). Secure the setting of the metering pin with lock nut (C, Fig. 1). Fill the oiler.

Repeat the oiling of a new machine after 10 minutes of operation!

When the machine is out of operation, the oil flow can be stopped by tilting the lever (D, Fig. 1) on the sight feed oiler.

**IMPORTANT!** The oil flow has to be switched on again before operating the machine.

## **NEEDLES**

Each needle has both a type and size number. The type number denotes the kind of shank, point, length, groove, finish and other details. The size number, stamped on the needle shank, denotes largest diameter of blade, measured in hundredths of millimeter respectively in thousandths of an inch, midway between shank and eye. Collectively, type and size number represent the complete symbol, which is given on the label of all needles packaged and sold by REVO.

The standard needle for machines covered in this manual is 9848G250/100.

For closing bags made of plastic or woven polypropylene tapes it is recommended to use needle 9856T with teflon coating.

Below are the descriptions and available sizes :

<u>Type No.</u>	<u>Description and Sizes</u>
9848G	Round shank, square point, double groove, spotted, chromium plated. Sizes available : 150/060, 170/067, 200/080, 250/100, 300/120,400/156
9856T	Round shank, round point, double groove, spotted, teflon-coated. Sizes available : 200/080, 250/100

Selection of proper needle size is determined by size of thread used. Thread should pass freely through needle eye in order to produce a good stitch formation.

To have needle orders promptly add accurately filled, an empty package, a sample needle or type and size number should be forwarded. Use description on label. A complete order would read : "100 needles, Type 9848G, Size 250/100".

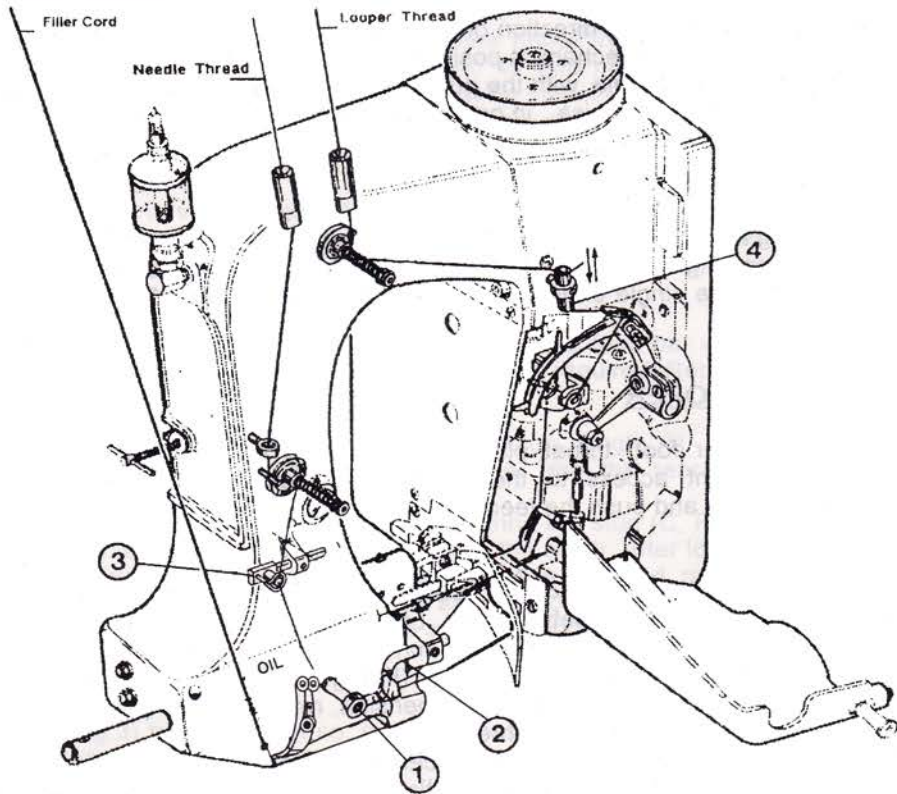
## **THREADING**

Thread machine as illustrated in Fig. 2.

When threading the looper, be sure the thread goes through the front eyelets, over the take-up and through the back eyelet before threading the looper.



## THREADING THE MACHINE



Needle Thread Threading  
on Styles 80800

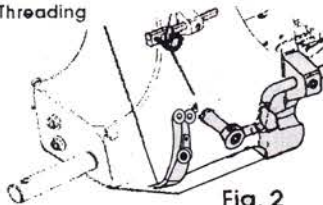


Fig. 2

## ADJUSTING AND THREADING INSTRUCTION FOR THE THREAD GUIDING PARTS

Proper adjustment of the thread guides and thread take-ups ensures a durable seam and consequently tight closure of the bags.

**NEEDLE THREAD :** Basic adjustment see Adjusting instructions. Shift needle thread take-up 1 (80865 MX) on support 2 (80865PX) as well as needle thread guide 3 (80858AX) on the machine housing for proper control of the needle thread. The above mentioned parts should be adjusted so that the needle thread, when slung around the looper blade, is controlled before the needle enters the thread triangle.

**LOOPER THREAD :** Shift looper thread guide 4 (80858BX2) so, that depending on the stitch length a sufficient amount of looper thread is available for setting the next stitch.

**IMPORTANT NOTE :** The above needle thread take-ups cannot be used on machines with long needle bar connection (e. g. 80659 or 29774D) which should be exchanged against the short needle bar connection 80659B together with thread guide G334. The threaded hole required for mounting bracket 80865QX of needle thread take up support 80865PX will already be provided in all future machines.



## ADJUSTING INSTRUCTIONS

**NOTE :** Instructions starting direction or location, such as right, left, front or rear of machine, are given relative to mechanic's position in front of the machine, when the machine is placed on an adjusting table, with the pull to the right and the needle bar in vertical position. The pulley rotates clockwise, in operating direction; when viewed from the right end of the machine.

### INSERTING THE NEEDLE

Before adjusting the machine, insert a new needle with the shank as far as possible into the needle bar. The long needle groove must point to the front (toward the operator). Tighten the needle clamp nut securely. Use the single ended open jaw wrench part No. 21388 from the accessories of the machine.

### SETTING THE LOOPER

Remove the presser foot, throat plate and feed dog and on styles 80800 also the needle guard for convenient access to the machine. On style 80800 loosen the screw (A, Fig. 3) in the feed bar (B) and push the feed bar needle guard (C) to the rear to avoid its contacting the needle (D).

For the two thread double locked stitch style 80800, set the looper connecting rod (E) so the distance (X, Fig. 4) between the center lines of the two ball joints is 69.8 mm (2 3/4"). The dimension (X, Fig. 4) should be 68.3 mm (2 11/16) on the single thread chain stitch style 80800. For adjustment loosen the two nuts (F, Fig. 3) and turn connecting rod (E) forward or backward as required to obtain specified dimension, retighten nuts (F).

**NOTE :** The left nut has a left hand thread.

Set the looper (G) so the distance from the center line of the needle (D) to the looper (G) is 8 mm (5/16") when the looper is at its farthest position to the right. Looper gauge No. 21225-5/16 can be used advantageously in making this adjustment. For adjustment loosen screws (H) in the looper drive lever (J), reposition as required to obtain specified dimension and retighten screws (H) assuring that all end play is taken out of the looper drive lever rocker shaft. Check to insure a clearance of approx. 1 mm (.040") between the point of the looper and the bed end cover when the looper is at its extreme position. Should the looper strike the bed end cover, recheck the distance between center lines of ball joints and the looper gauge distance as described above.

Rotate the machine pulley in operating direction so that the looper moves from right to left. The looper point should pass as close as possible to the back of the needle without contacting 0.08 to 0.13 mm (.003 to .005") clearance. For adjustment loosen screws (A, Fig. 4) in the looper eccentric fork (B) and turn looper rocker shaft (C) on the looper rocker forward or backward as required. Retighten Screw (A).

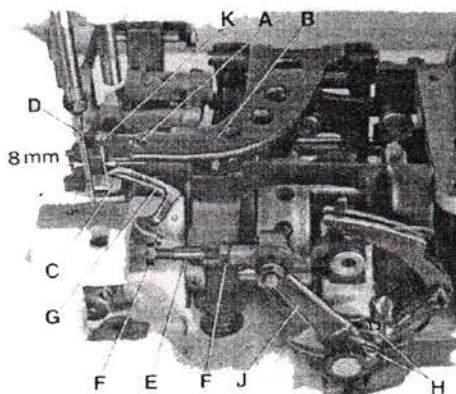


Fig. 3

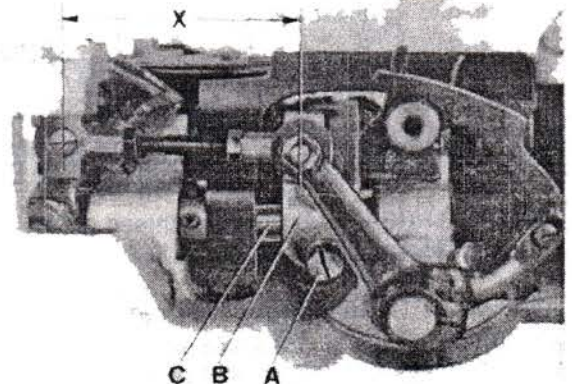


Fig. 4

### SETTING HEIGHT OF NEEDLE BAR

Remove the face cover on machine arm. Rotate machine pulley in operating direction until the looper point, moving to the left, projects 1 to 1.5 mm (.040" to .060") left to the needle (see Fig. 5). Lower edge of looper and upper edge of needle eye must be flush in this position. If adjustment is necessary, loosen clamp screw (A, Fig. 6) in the needle bar up or down, as required. Retighten screw (A) and remount face cover.

### SETTING THE FEED DOG

At highest point of feed dog travel, the feed dog (B, Fig. 6) should be set so, that the rear teeth project their full depth above the throat plate surface. For setting remove the feed dog and adjust the supporting screw (K, Fig. 3) on the top of the feed bar to the required height. Remount the feed dog, and on styles 80800 also the needle guard.

After loosening screws (A, Fig. 7) rear in the feed rocker (B), the feed bar with feed dog can be moved laterally to center the feed dog in the throat plate slots, if required. Retighten screws (A).

### CHANGING STITCH LENGTH

On Styles 80800 stud (C, Fig. 6) for changing the stitch length is accessible from the outside. On styles 80800 the housing for the tape cutter and the rear cloth plate have to be removed for changing the stitch length.

The length of the stitch can be adjusted by raising or lowering the stud (C, Fig. 6) in the segment slot of the feed rocker (D). Lowering stud (C) will lengthen the stitch. After loosening nut (E), stud (C) can be moved accordingly. When the desired stitch length is obtained, retighten nut (E).

Remount housing for cutter and rear cloth plate on style 80800.

**NOTE :** Any change in stitch length will necessitate a corresponding change in the needle guard setting!

### SETTING THE NEEDLE GUARD

The needle guard (C, Fig.3) has to be set so, that it just contacts the needle at its most forward point of travel, without deflecting it.

On style 80800 loosen screw (A, Fig. 3) in the feed bar (B) and adjust the needle guard (C) accordingly. Retighten screw (A).

On style 80800 loosen the feed dog fastening screw and move the needle guard accordingly. Retighten screw and make sure that the feed dog rests on the supporting screw in the feed bar.

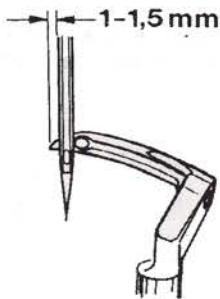


Fig.5

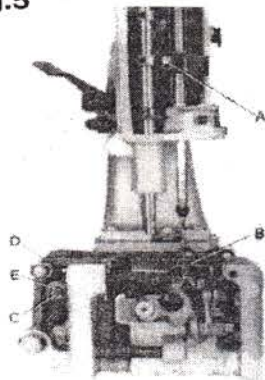


Fig.6

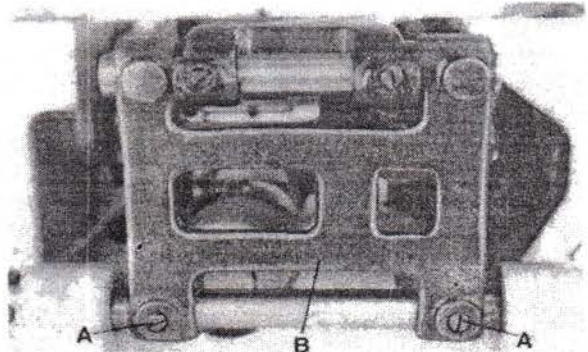


Fig.7

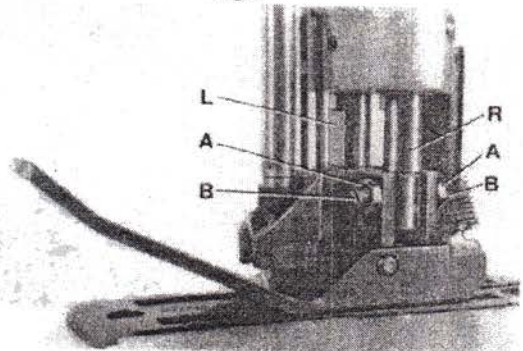


Fig.8



## MOUNTING AND SETTING THE PRESSER FOOT

Remove the needle and rotate the pulley until the feed dog is below the throat plate. Depress the presser foot lifter lever and insert the presser foot in the two presser bars (L and R, Fig. 8). The right presser bar (R) should only engage with its pivot in the groove of the presser foot shank.

Loosen the two lock nuts (A, Fig. 8) and align with the two set screws (B), the needle slot in the presser foot with the needle slot in the throat plate. Secure this setting with the two lock nuts (A). **Note :** The two set screws (A) should just contact the pivot of the right presser bar (R) but not be tightened. Now tighten the two set screws left in the presser foot shank on the left presser bar. Insert the needle.

## PRESSER FOOT PRESSURE

Rotate the pulley until the feed dog is below the throat plate. Remove the face cover left on machine arm and turn out the T-screw (H, Fig. 10) on the top of the machine arm, until it does not exert any pressure on the leaf springs. In this position, the pressure exerted on the presser foot, should be just strong enough to keep it flat on the throat plate. By relocating the collars (A, Fig. 9), which serve as a leaf spring rest, on the left and right presser bar, the pressure can be changed. Raising the collars increases the pressure, lowering the collars decreases the pressure.

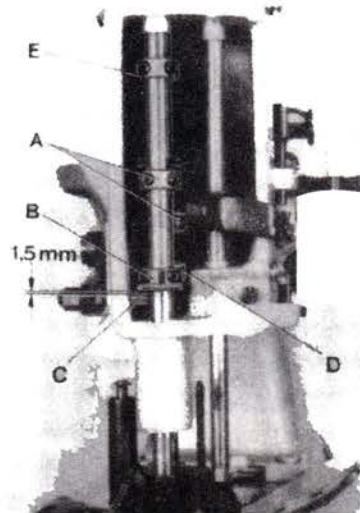
Set the presser bar lifter collar (B, Fig. 9) on the left presser bar so, that there is a difference of approx. 1.5 mm (1/16") between lifter lever stud (C) and lower surface of the lifter collar (B), when the presser foot rests on the throat plate (see Fig. 9). Set the collar (D) on the right presser bar close to the fork of the presser bar lifter collar (B) on the left presser bar.

The presser foot lift is limited with the upper stop collar (E, Fig. 9) on the left presser bar. When the needle is in its lowest position and the presser foot is lifted with presser foot bottom titled up, the needle bar respectively needle clamp should not contact the presser foot bottom. Set collar (E) accordingly.

Now turn in T-screw (H, Fig. 10) until the necessary presser foot pressure for proper feeding is exerted.(determine wir sewing tests). Secure this setting with the knurled nut (J), which simultaneously fastens the upper arm cover. Remount the face cover.

## THREAD TENSION

The tension (A, Fig. 10) on the needle thread should be fairly strong to produce uniform stitches. On two thread double locked stitch styles the tension (B) on the looper thread should be barely sufficient to steady it.





## LOOPER THREAD TAKE-UP

On the two thread double locked stitch styles, the height of the looper thread take-up (A, Fig. 11) is set so, that the cast-off hook (C) forces the looper thread over the corner (B) of the looper thread take-up (A) at the time the point of the descending needle is flush with the lower edge at looper or projects up to 1 mm (.040") below the lower edge of looper.

Draw the looper thread into the machine, rotate pulley in operating direction and note the position of the needle point to lower edge of looper at the time the cast-off (C) forces the looper thread over the corner (B).

For setting the looper thread take-up loosen screw (D, Fig. 11).

When the needle point is positioned above the lower edge of looper, the looper thread take-up (A) has to be raised accordingly. When the needle point is positioned more than 1 mm (.040") below the lower edge of looper, The looper thread take-up (A) has to be lower accordingly. Retighten screw (D).

## SETTING NEEDLE THREAD TAKE-UP ROLLER AND EYELET

On the two thread double locked stitch style 80800, the height of the needle thread take-up roller (C, Fig. 10) is set so that the needle thread on the downstroke of the needle just contacts the roll at the time the needle thread loop is released from the looper. Loosen screw (D) and set the needle thread take-up roller accordingly. Retighten screw (D).

On the single thread chain stitch style 80800 the needle thread take-up roller should be positioned so as not to contact the needle thread at any time.

On all styles the eyelet (E, Fig. 10) should be positioned so, that the needle thread runs nearly horizontal, parallel to cloth plate, between eyelet (G) on needle bar connection and eyelet (E) on machine arm, when the needle is in its upmost position. Eyelet (E) is secured by screw (F).

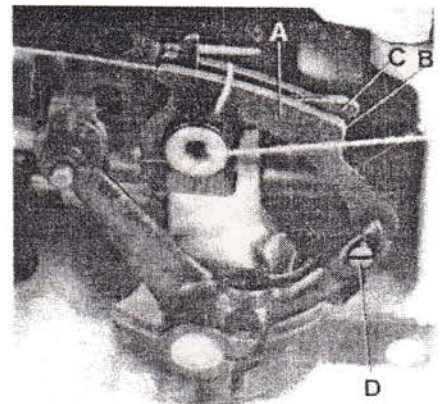
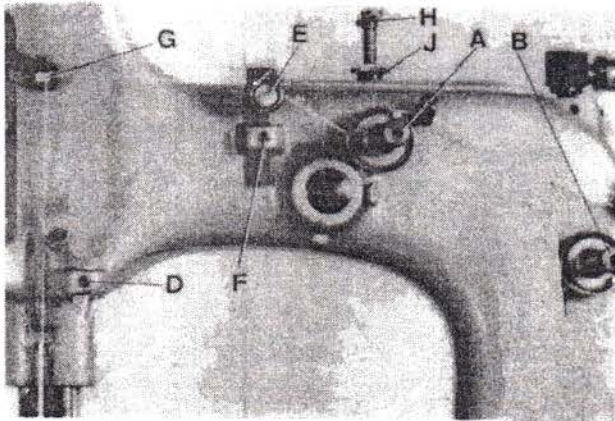


Fig.11

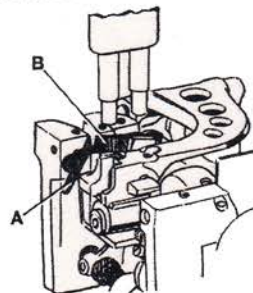


Fig.12

## ORDERING WEAR AND SPARE PARTS

### ILLUSTRATIONS

This manual has been arranged to simplify ordering wear and spare parts. Exploded views of various sections of the mechanism are shown so that the parts may be seen in their actual position in the sewing machine. On the page opposite the illustration will be found a listing of the parts with their part numbers, descriptions and the number of pieces required in the particular view being seen.

Numbers in the first column are reference numbers only and merely indicate the position of that part in the illustration. Reference numbers should never be used in ordering parts. Always use the part number listed in the second column.

Component parts of sub-assemblies which can be furnished for repairs are indicated by indenting their description under the description of the main sub-assembly.

At the back of the catalog will be found a numerical index of all parts shown in this catalog. This will facilitate locating the illustration and description when only the part number is known.

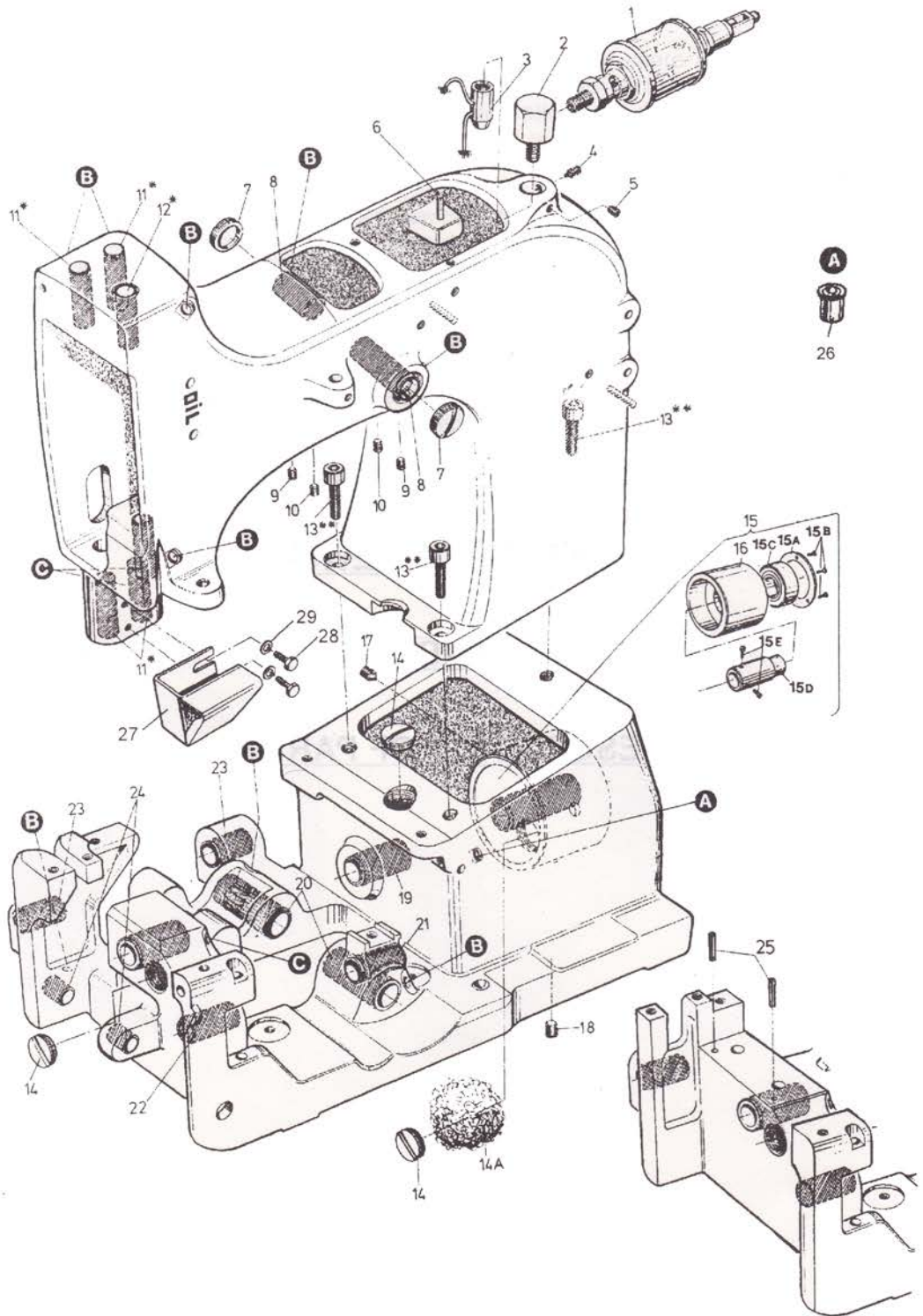
**IMPORTANT! ON ALL ORDERS, PLEASE INCLUDE PART NUMBER, PART NAME AND STYLE OF MACHINE FOR WHICH PART IS ORDERED.**

EXPLODED VIEWS

AND

DESCRIPTION OF PARTS

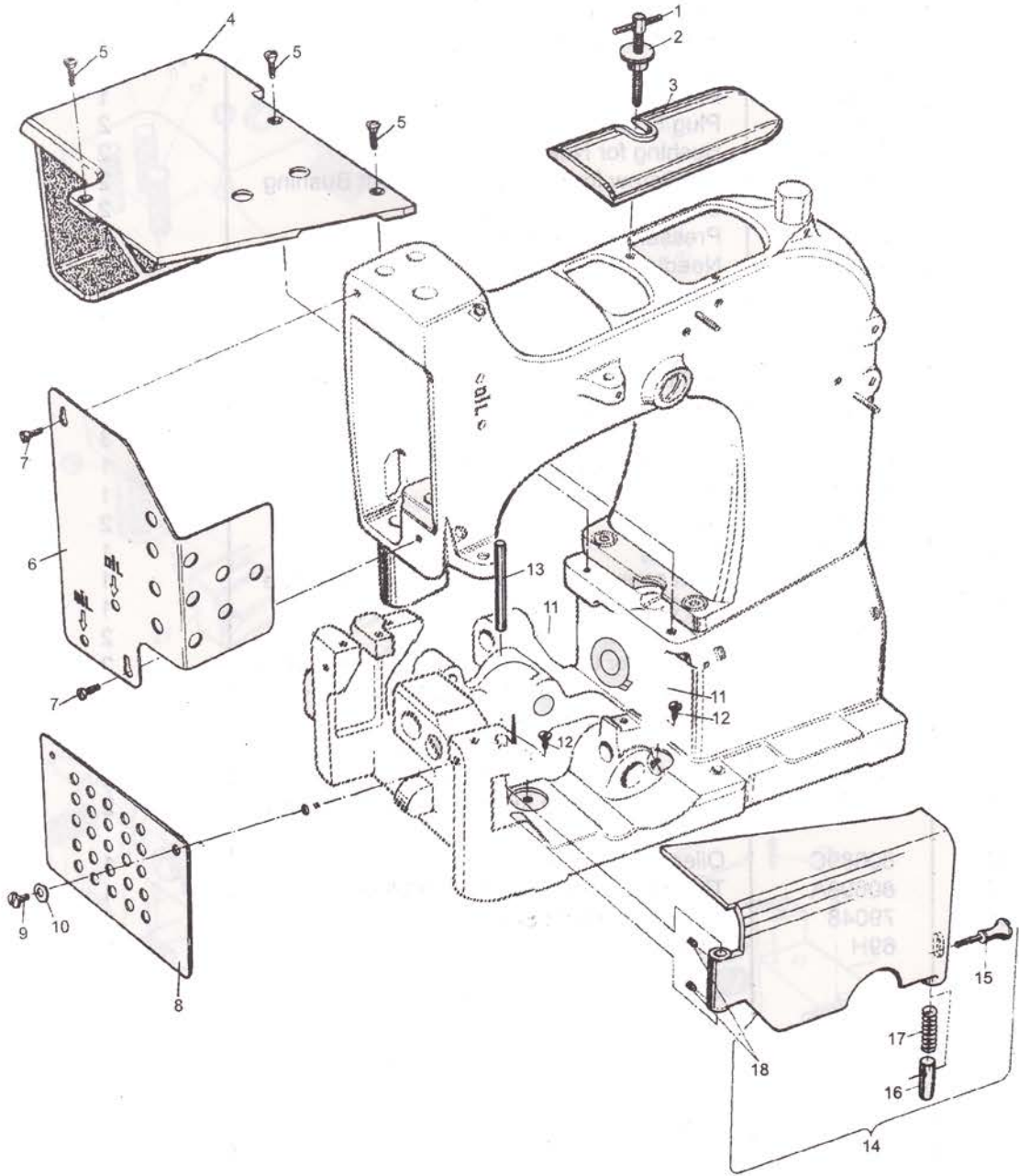




SPARE PARTS LIST FOR SEWING MACHINES FOR CLOSING FILLED BAGS  
MODEL-80800

**01 BUSHING OILER AND COVER PARTS**

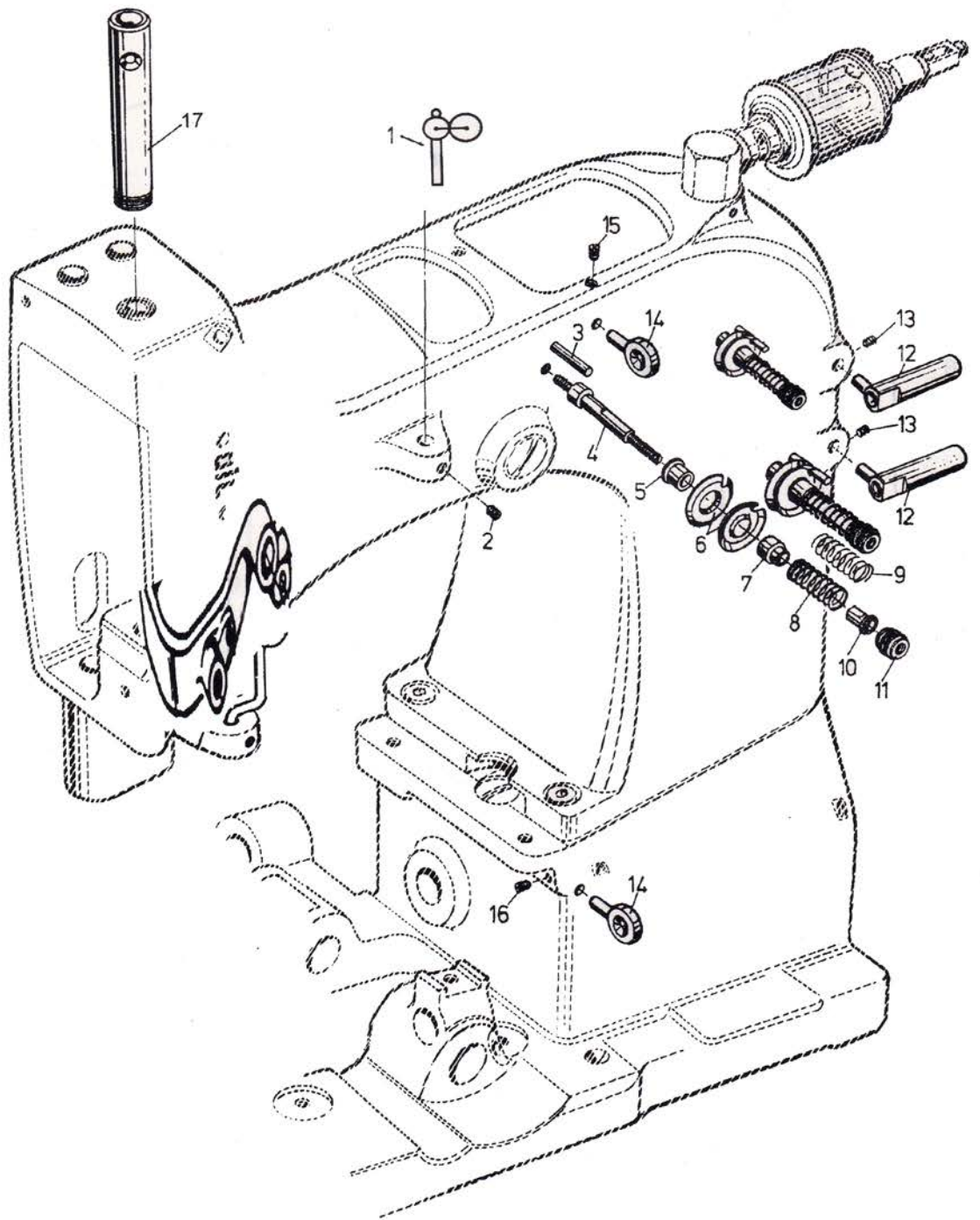
Ref. No.	Part No.	Description	Quantity
1-1	666-79	Sight Feed Oiler	1
2	80898A	Union Elbow	1
3	80293A	Oil Distributor	1
4	22894K	Spot Screw, Headless	1
5	22894J	Set Screw	1
6	80667	Pin	1
7	80644	Plug Screw	2
8	80846	Bushing for Needle Lever Shaft	2
9	89	Set Screw for Needle Lever Shaft Bushing	2
10	88	Set Screw for Plug Screw	2
11	80862	Presser Bar Bushing	4
12	80637B	Needle Bar Bushing	2
13	95861	Screw	3
14	22539	Plug Screw	3
14A	WO3	Wick Yarn, Length 50 mm (2")	1
15	80885	Ball Bearing Assembly for Crank Shaft	1
15A	80885C	Retaining Ring	1
15B	22596D	Screw	3
15C	999-106D	Deep Groove Ball Bearing	1
15D	80885B	Hub	1
15E	22891	Screw	2
16	80885A	Bearing	1
17	HA81	Spot screw for Crank Shaft Bearing House	1
18	HA95	Set Screw for Crank Shaft Bearing House	1
19	80694DA	Bushing for Crank Shaft	2
20	80640EA	Bushing for Looper Driver Lever Rocker Shaft	2
21	80639EA	Looper Shaft Bushing, Right	1
22	80639FA	Looper Shaft Bushing, Left	1
23	80692EA	Feed Rocker Shaft Bushing	2
24	80692DA	Knife Lever Shaft Bushing	2
25	96657	Clamping Sleeve for Tape Cutter for Styles 80800	2
26	80689C	Oiler, Shank Dia 7 mm	1
27	80698A	Thread Lubricator for Style 80800	1
28	79048	Hexagonal Head Screw	2
29	69H	Washer	2





**02 CLOTH PLATES AND MISCELLANEOUS COVERS**

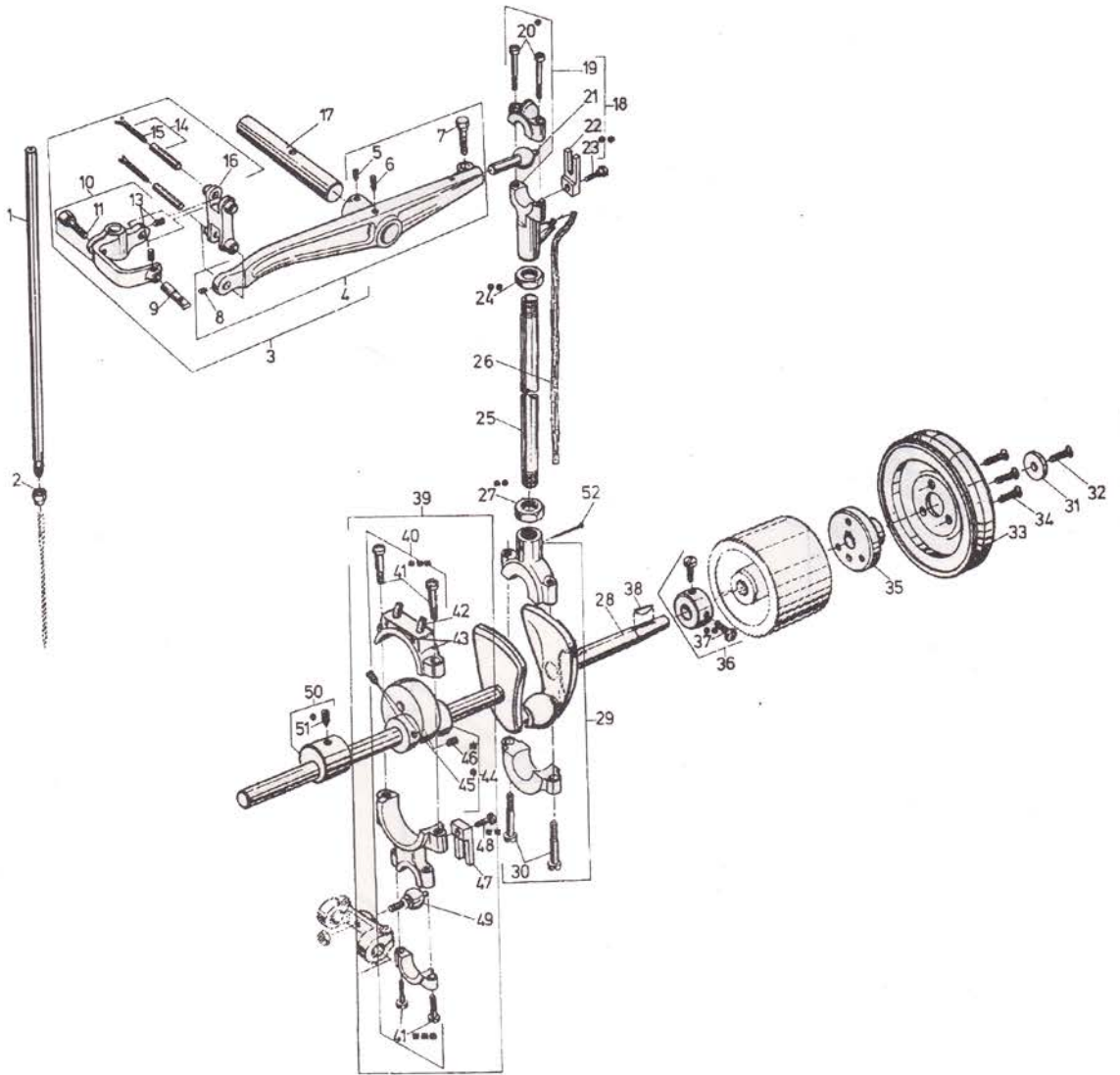
Ref. No.	Part No.	Description	Quantity
2-1	64Y	T-Screw	1
2	35733B	Knurled Nut	1
3	80888	Arm Cover	1
4	80601E	Cloth Plate for Style 80800	1
5	22574	Countersunk Screw	3
6	80887A	Face Cover	1
7	22528	Screw	2
8	80683	End Cover for Style 80800	1
9	92121	Shoulder Screw	1
10	J1614	Spring Washer	1
11	80284H	Guard	2
12	94	Screw	2
13	8564	Hinge Pin	1
14	80601D	Hinge Cover Assembly for Style 80800	1
15	80440	Locking Bolt Knob	1
16	81239	Locking Bolt	1
17	80438	Spring	1
18	89	Set Screw	2



**03    THREAD TENSIONS, THREAD GUIDES AND NEEDLE BAR GUIDE**

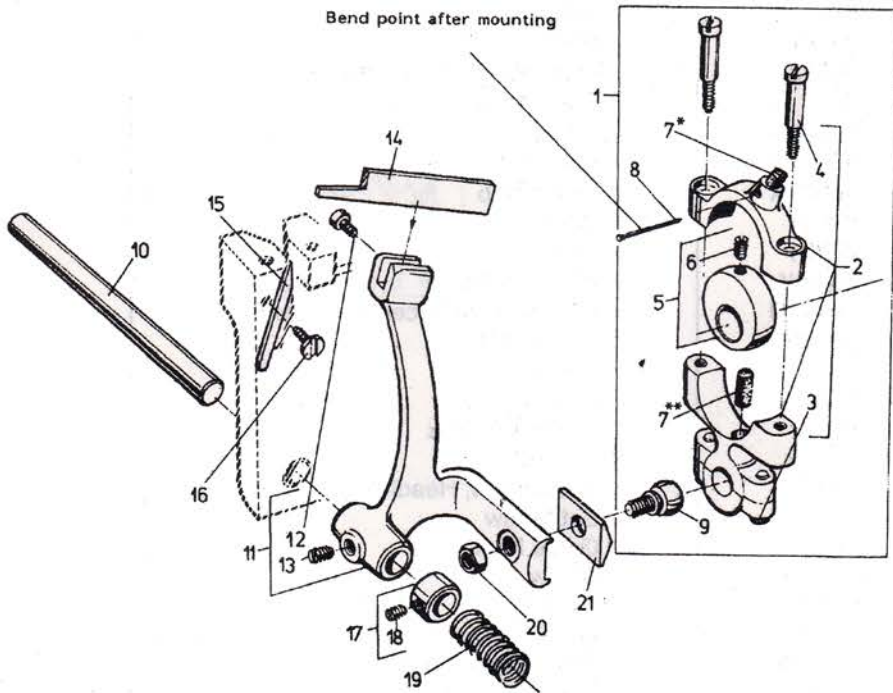
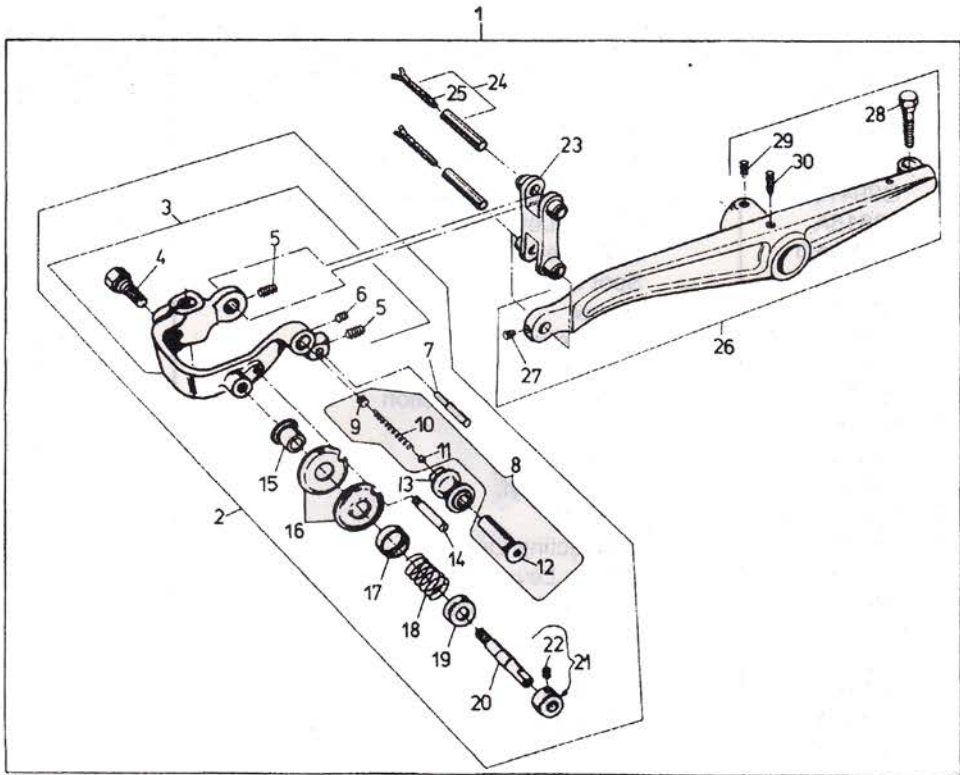
Ref. No.	Part No.	Description	Quantity
3-1	80858AX	Needle Thread Guide	1
2	22894AD	Set Screw	1
3	80667	Pin for Tension Discs	2
4	HS106	Tension Post	2
5	HA1348	Tension Post Ferrule	2
6	80676A	Tension Disc	4
7	HA1349	Tension Sleeve	2
8	110-4	Spring for Needle Thread Tension	1
9	110-3	Spring for Loper Thread Tension	1
10	107	Tension Spring Ferrule	2
11	108	Tension Nut	2
12	81256A	Thread Sleeve	2
13	22560B	Set Screw	2
14	AS137A	Thread Eyelet	2
15	22560B	Set Screw	1
16	22892AD	Set Screw	1
17	80673CB	Needle Bar Guard	1





04 NEEDLE BAR, NEEDLE LEVER, CRANK SHAFT, PULLEY, LOOPER DRIVE AND LOOPER AVOID ECCENTRIC

Ref. No.	Part No.	Description	Quantity
4-1	80617	Needle Bar	1
2	HA56	Needle Clamp Nut	1
3	G29479PA	Needle Lever Assembly	1
4	80615A	Needle Lever	1
5	22894AD	Set Screw	1
6	22894K	Spot Screw	1
7	22811	Screw	1
8	22894Y	Set Screw	1
9	G334	Thread Eyelet	1
10	80659B	Needle Bar Connection	1
11	BP108	Screw	1
13	22894Y	Set Screw	2
14	51134Y	Link Pin, Cyl.	2
15	666-260	Oil Wick	1
16	HA54B	Connecting Link	1
17	80643	Needle Lever Shaft	1
18	29066LA	Needle Lever Ball Link	1
19	80650LA	Shell	1
20	22587	Screw	2
21	80656	Ball Stud	1
22	80636A	Guide Fork	1
23	G22515A	Screw	1
24	80630C	Nut, Left Hand Thread	1
25	80630	Needle Lever Connecting Rod	1
26	80630G	Oil Felt	1
27	80630D	Nut, Right Hand Thread	1
28	80822	Crank Shaft	1
29	80652	Shell	1
30	22587	Screw	2
31	80674	Lock Washer for Pulley Hub	1
32	80	Countersunk Screw	1
33	80621B	Pulley	1
34	80	Countersunk Screw	3
35	80621A	Pulley Hub	1
36	80681	Collar	1
37	22891	Screw	2
38	HA66K	Woodruff Key	1
39	29442N	Looper Drive Eccentric Assembly	1
40	80236	Connection	1
41	88F	Screw	4
42	666-19	Oil Wick	2
43	PI18	Pin for Oil Wick	2
44	80642	Eccentric	1
45	22894L	Spot Screw, Headless	1
46	22894C	Set Screw	1
47	80636A	Guide Fork	1
48	G22515A	Screw	1
49	80645	Ball Stud	1
50	AS38B	Looper Avoid Eccentric	1
51	22894K	Spot Screw, Headless	1
52	PI18	Pin for Oil Wick	1



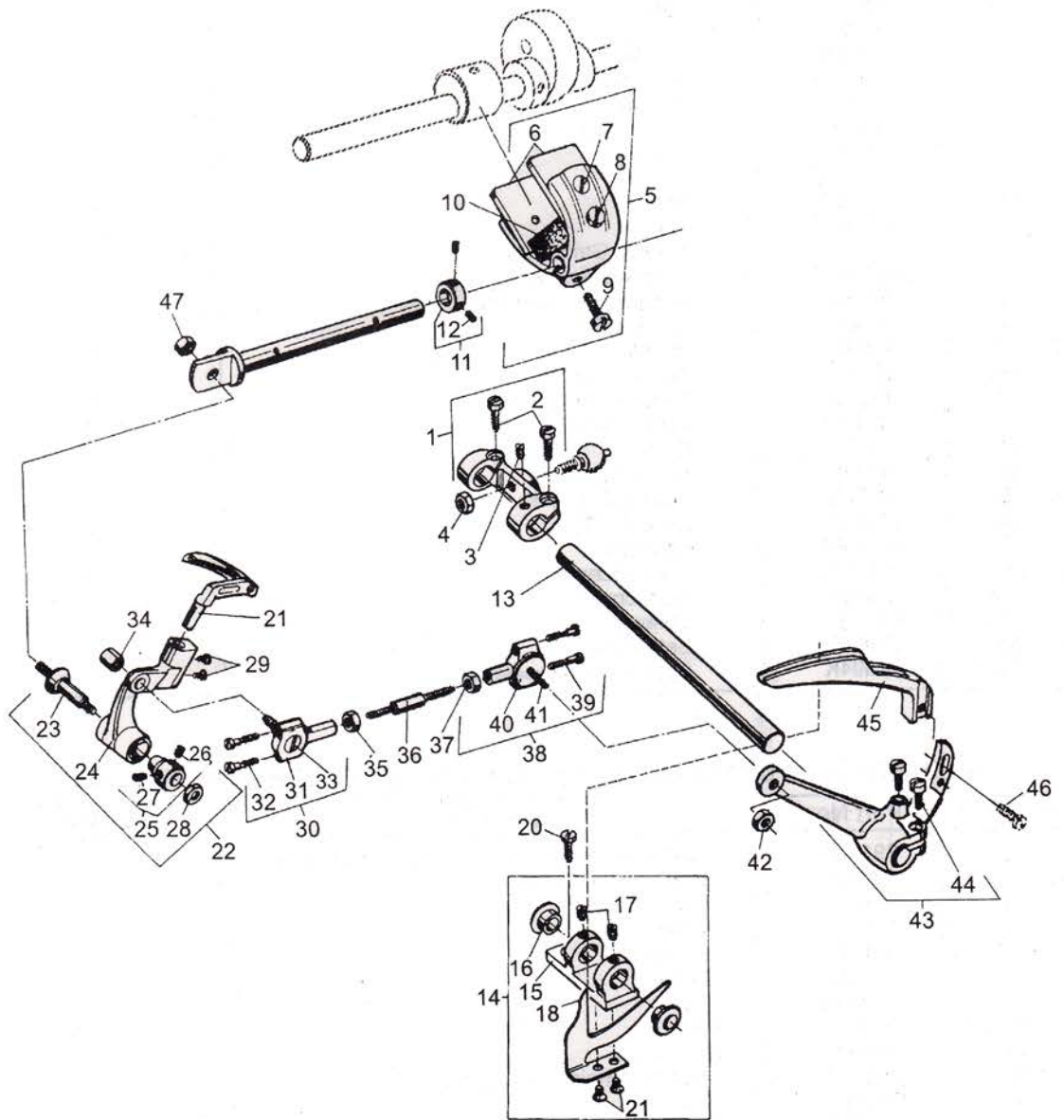


**05 NEEDLE LEVER ASSEMBLY FOR STYLE 80800**

Ref. No.	Part No.	Description	Quantity
5-1	G29479P	Needle Lever Assembly for Style 80800	1
2	29774E	Needle Bar Connection Assembly	1
3	80659C	Needle Bar Connection	1
4	BP108	Screw	1
5	22894Y	Set Screw	2
6	22894W	Set Screw	1
7	80655	Thread Guide Pin	1
8	HS52B	Axle Assembly for Rolling Thread Guide	1
9	22560	Set Screw	1
10	HA1286B	Spring	1
11	12964C	Ball	1
12	81086C	Axle	1
13	81093	Thread Guide Roller	1
14	HS100D	Locating Screw	1
15	80669	Tension Post Ferrule	1
16	80676	Tension Disc	2
17	HA58C	Ferrule	1
18	HA58F	Tension Spring	1
19	HA58D	Tension Spring Ferrule	1
20	80046	Tension Post	1
21	21111	Collar	1
22	22743	Set Screw	1
23	HA54B	Connecting Link	1
24	51134Y	Link Pin, Cyl.	2
25	666-260	Oil Wick	1
26	80615A	Needle Lever	1
27	22894Y	Set Screw	1
28	BP108	Screw	1
29	22894	Set Screw	1
30	22894K	Spot Screw, Headless	1

**06 THREAD CHAIN CUTTER KNIVES AND CHAIN CUTTER KNIFE DRIVE FOR STYLE 80800**

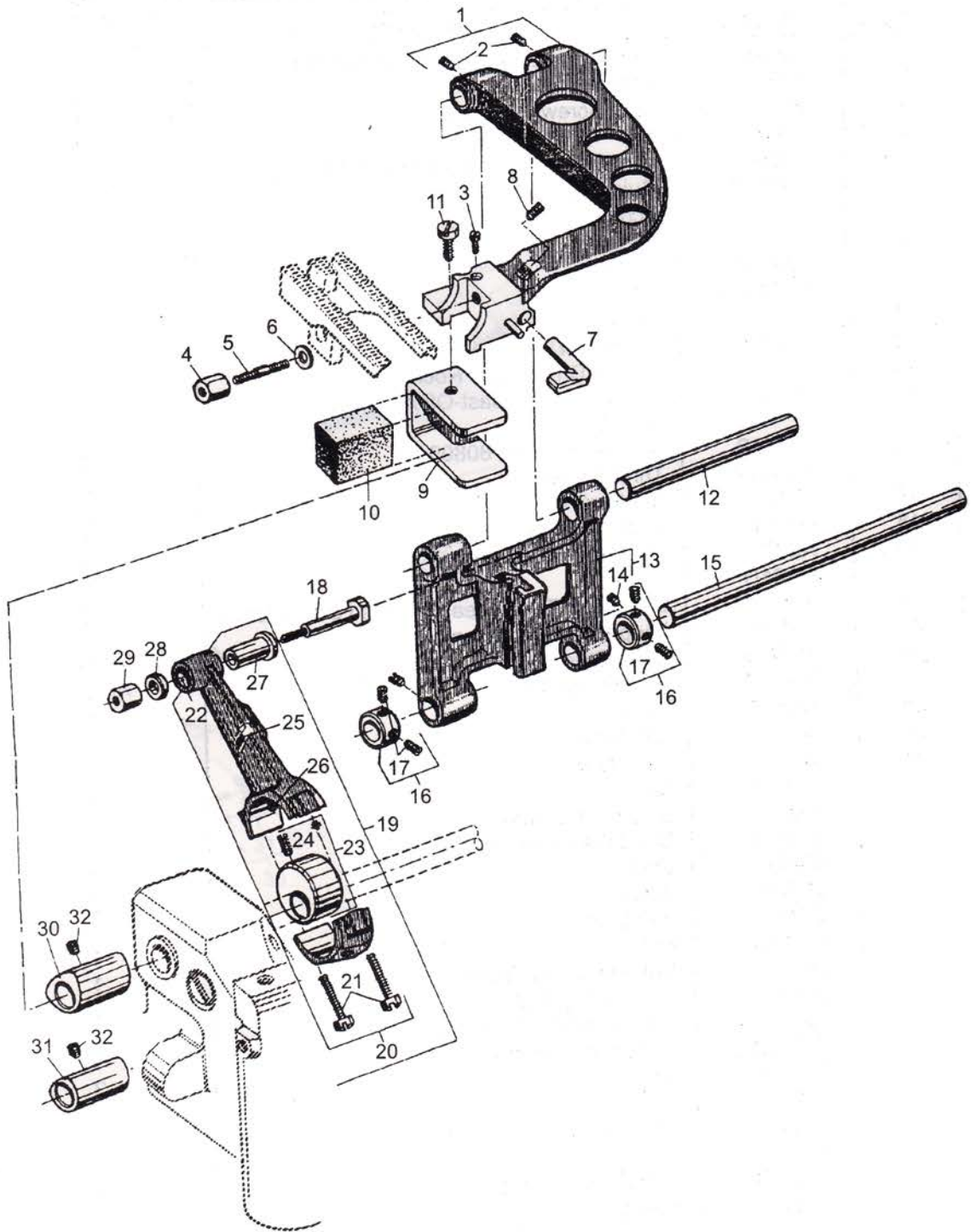
Ref. No.	Part No.	Description	Quantity
6-1	29132S	Connection Assembly for Chain Cutter Drive	1
2	15865	Connection Bearing	1
3	97A	Screw	2
4	75A	Screw	2
5	80672	Eccentric	1
6	22894L	Screw	1
7	666-149	Felt	1
8	PI18	Pin	1
9	G10349	Ball Stud	1
10	459	Shaft for Chain Cutter Knife	1
11	80671	Knife Bar	1
12	92127	Screw for Upper Knife	1
13	98	Screw	1
14	80677	Upper Knife	1
15	80675	Lower Knife	1
16	88D	Screw	1
17	4460	Collar	1
18	88	Screw	1
19	110-4	Spring	1
20	18	Nut	1
21	80670	Ball Stud Washer	1



## 07 LOOPER AVOID ECCENTRIC FORK, LOOPER, LOOPER DRIVE LEVER AND ROCKER, LOOPER THREAD CAST-OFF

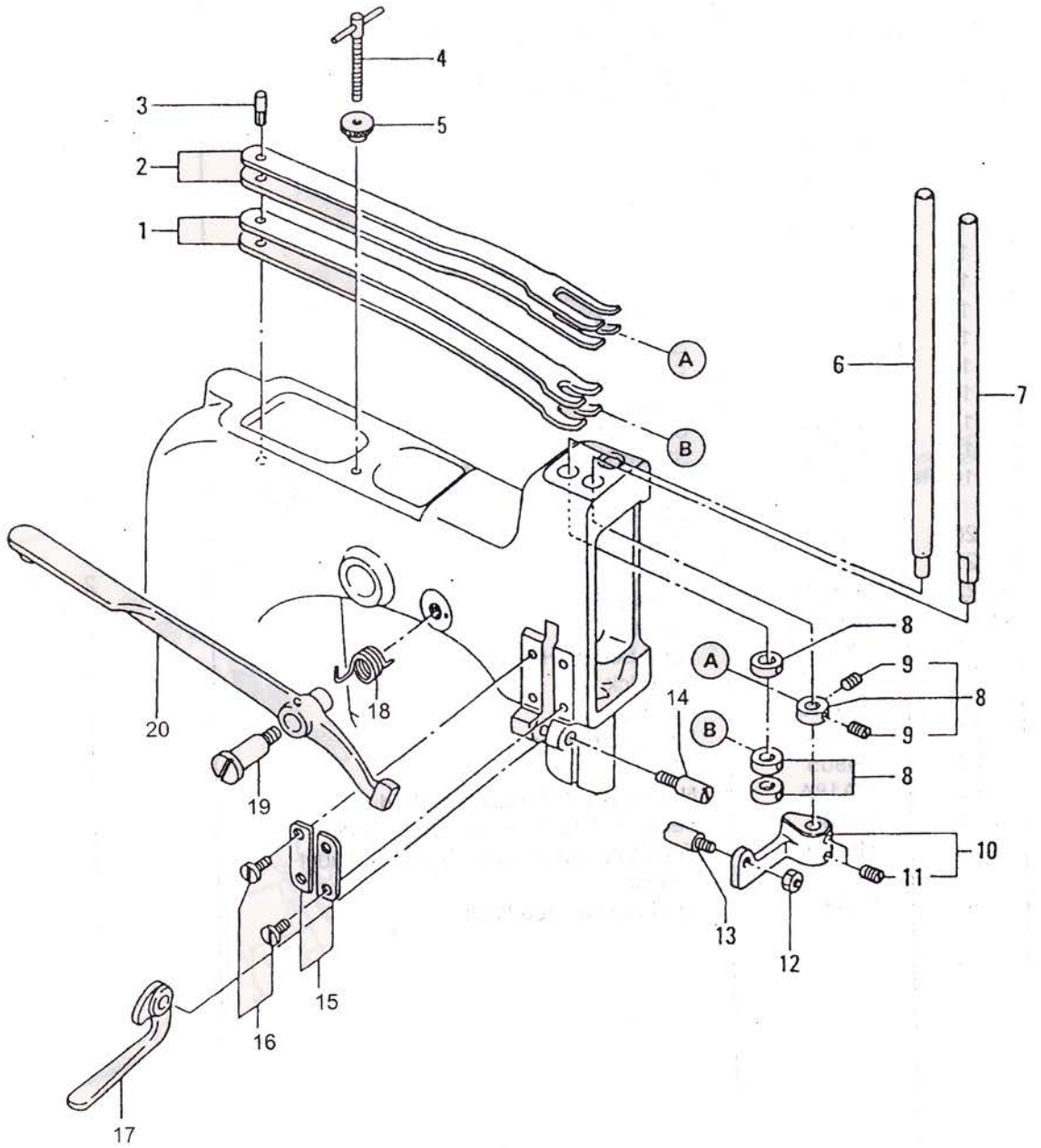
Ref. No.	Part No.	Description	Quantity
7-1	80638A	Rocker for Looper Drive Lever Shaft	1
2	136	Screw	2
3	96	Spot Screw, Headless	1
4	80691	Nut	1
5	80680	Looper Avoid Eccentric Fork Assembly	1
6	80680B	Guide Plate	2
7	94	Screw	2
8	85	Screw	1
9	22811B	Screw	1
10	80634EC	Oil Felt	1
11	482C	Collar	1
12	22894C	Set Screw	2
13	80640	Looper Drive Lever Rocker Shaft	1
14	80653A	Looper Thread Cast-Off Assembly For Style 80800	1
15	80653B	Bracket for Style 80800	1
16	HA102A	Thread Eyelet	2
17	22743	Set Screw	2
18	80604	Cast-Off Hook	1
19	AS22D	Countersunk Screw	2
20	HA61D	Screw	1
21	AS26XA	Looper for Two Thread Double Lock Stitched	1
22	29479	Looper Rocker Assembly	1
23	15745B	Cone Stud	1
24	80613A	Looper Rocker	1
25	15465F	Cone	1
26	88	Set Screw	1
27	88	Set Screw	1
28	12987A	Nut	1
29	73X	Screw for Looper	2
30	80657A	Ball Joint Assembly	1
31	6040A	Shell	1
32	22729	Screw	2
33	237A	Ball Stud	1
34	HA18A	Nut	1
35	269	Nut, Left Hand Thread	1
36	80641	Connecting Rod	1
37	18	Nut, Right Hand Thread	1
38	80658A	Ball Joint Assembly	1
39	22729D	Screw	2
40	HS36K	Washer	1
41	FP36E	Ball Stud	1
42	12538	Nut	1
43	80637X	Looper Drive Lever	1
44	22517	Screw	2
45	80623	Looper Thread Take-Up	1
46	22569	Screw	1
47	1280	Nut for Looper Rocker	1





**08 FEED MECHANISM**

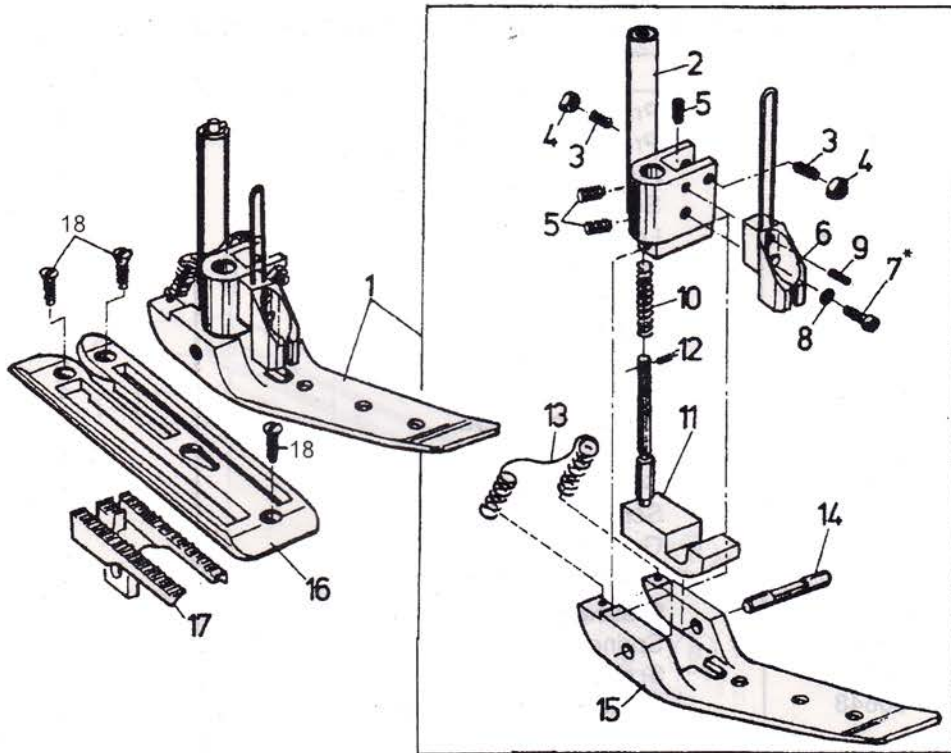
Ref. No.	Part No.	Description	Quantity
8-1	80634R	Feed Bar for Style 80800	1
2	89	Set Screw	2
3	97X	Feed Dog Supporting Screw	1
4	G5144	Nut for Feed Dog	1
5	80686C	Stud Bolt for Feed Dog	1
6	69H	Washer	1
7	80625	Needle Guard for Style 80800	1
8	HA95	Screw for Needle Guard	1
9	29476WM	Feed Lift Eccentric Fork	1
10	80634EB	Oil Felt	1
11	93A	Screw for Eccentric Fork	1
12	11	Feed Bar Shaft	1
13	80633	Feed Rocker	1
14	89	Set Screw	2
15	8A	Feed Rocker Shaft	1
16	482C	Collar	2
17	22894C	Set Screw	2
18	80696	Stitch Regulating Stud for Style 80800	1
19	29099S	Feed Drive Eccentric Assembly for Style 80800	1
20	80651A	Connection	1
21	22587	Screw	2
22	80651B	Bushing	1
23	80695A	Eccentric	1
24	22894L	Spot Screw, Headless	1
25	666-121	Oil Wick	1
26	666-19	Oil Wick	1
27	80654	Flange Bushing	1
28	96905	Washer	1
29	HA18A	Nut for Stitch Regulating Stud	1
30	80206	Feed Lift Eccentric for Style 80800	1
31	HA43X	Feed Lift Eccentric for Styles 80800H and HA	1
32	22894D	Spot Screw, Headless	2





09 PRESSER FOOT LIFTER AND PRESSER FOOT PARTS

Ref. No.	Part No.	Description	Quantity
9-1	80664	Presser Foot Spring, Upper	2
2	80663	Presser Foot Spring, Lower	2
3	80667	Pin	1
4	64Y	Screw	1
5	35733B	Lock Nut	1
6	80661	Presser Bar, Right	1
7	80660	Presser Bar, Left	1
8	482C	Collar	4
9	98	Screw For 482C	8
10	80632	Guide For Presser Bar	1
11	95	Screw For 80632	2
12	258	Nut	1
13	22870	Screw	1
14	11639H	Screw	1
15	80631	Guide Plate	2
16	376	Screw For 80631	4
17	80267	Presser Foot Lifter Hand Lever	1
18	80649	Spring	1
19	420	Screw	1
20	80648	Presser Foot Lifter Lever	1



### 10 PRESSER FEET, THROAT PLATES AND FEED DOGS

Ref. No.	Part No.	Description	Quantity
10-1	80820L	Presser Foot For Style 80800	1
2	80830	Presser Foot Shank	1
3	22560A	Set Screw To Align Presser Foot	2
4	12934A	Nut	2
5	22894C	Set Screw	3
6	99682VA	Finger Guard	1
7	95686	Screw	1
8	97165A	Lock Washer	1
9	96667	Clamping Sleeve	1
10	80620G	Spring	1
11	80620O	Chaining Section	1
12	80620H	Clamping Sleeve	1
13	80620P	Spring	1
14	96521	Pin	1
15	80830A	Presser Foot Bottom	1
16	80624C	Throat Plate For Style 80800	1
17	G80605E	Feed Dog For Style 80800	1
18	80	Screw For Throat Plate	3

## NUMERICAL INDEX OF PARTS

PART NO.	PAGE	PART NO.	PAGE	PART NO.	PAGE	PART NO.	PAGE
107	19	376	29	80639FA	15	80846	15
108	19	420	29	80640	25	80858AX	19
11	27	4460	23	80640EA	15	80862	15
110-3	19	459	23	80641	25	80885	15
110-4	19, 23	482C	25, 27, 29	80642	21	80885A	15
11639H	29	51134Y	21, 23	80643	21	80885B	15
12538	25	6040A	25	80644	15	80885C	15
1280	25	64Y	17, 29	80645	21	80887A	17
12934A	30	666-121	27	80648	29	80888	17
12964C	23	666-149	23	80649	29	80898A	15
12987A	25	666-19	21, 27	80650LA	21	81086C	23
136	25	666-260	21, 23	80651A	27	81093	23
15465F	25	666-79	15	80651B	27	81239	17
15745B	25	69H	15, 27	80652	21	81256A	19
15865	23	73X	25	80653A	25	85	25
18	23, 25	75A	23	80653B	25	8564	17
21111	23	79048	15	80654	27	88	15, 23, 25
22517	25	80	21, 30	80655	23	88D	23
22528	17	80046	23	80656	21	88F	21
22539	15	80206	27	80657A	25	89	15, 17, 27
22560	23	80236	21	80658A	25	8A	27
22560A	30	80267	29	80659B	21	92121	17
22560B	19	80284H	17	80659C	23	92127	23
22574	17	80293A	15	80660	29	93A	27
22587	21, 27	80438	17	80661	29	94	17, 25
22596D	15	80440	17	80663	29	95	29
22729	25	80601D	17	80664	29	95686	30
22729D	25	80601E	17	80667	15, 19, 29	95861	15
22743	23	80604	25	80669	23	96	25
22811	21	80613A	25	80670	23	96657	15
22811B	25	80615A	21, 23	80671	23	96667	30
22870	29	80617	21	80672	23	96905	27
22891	15, 21	80620G	30	80673B	15	97165A	30
22894	23	80620H	30	80673CB	19	97A	23
22894AD	19, 21	80620P	30	80674	21	97X	27
22894C	21, 25, 27, 30	80621A	21	80675	23	98	23, 29
22894D	27	80621B	21	80676	23	99682VA	30
22894J	15	80623	25	80676A	19	999-106D	15
22894K	15, 21, 23	80625	27	80677	23	AS137A	19
22894L	21, 23, 27	80630	21	80680	25	AS22D	25
22894W	23	80630C	21	80680B	25	AS26XA	25
22894Y	21, 23	80630D	21	80681	21	AS38B	21
237A	25	80630G	21	80686C	27	BP108	21, 23
258	29	80631	29	80689C	15	FP36E	25
269	25	80632	29	80691	25	G10349	23
29066LA	21	80633	27	80692DA	15	G22515A	21
29099S	27	80634EB	27	80692EA	15	G29479P	23
29132S	23	80634EC	25	80694DA	15	G29479PA	21
29442N	21	80634R	27	80695A	27	G334	21
29476WM	27	80636A	21	80696	27	G5144	27
29479	25	80637X	25	80698A	15	G80605E	30
29774E	23	80638A	25	80822	21	HA102A	25
35733B	17, 29	80639EA	15	80830	30	HA1286B	23



## NUMERICAL INDEX OF PARTS

PART NO.	PAGE	PART NO.	PAGE	PART NO.	PAGE	PART NO.	PAGE
HA1348	19						
HA1349	19						
HA18A	25, 27						
HA43X	27						
HA54B	21, 23						
HA56	21						
HA58C	23						
HA58D	23						
HA58F	23						
HA61D	25						
HA66K	21						
HA81	15						
HA95	15, 27						
HS100D	23						
HS106	19						
HS36K	25						
HS52B	23						
J1614	17						
PI18	21, 23						
WO3	15						