

B-19 IIS

SINGLE NEEDLE, TWO THREAD HEAVY DUTY HEMMING & SEAMING SEWING MACHINES

B-19 IIW

SINGLE NEEDLE, SINGLE THREAD HEAVY DUTY
CHAIN STITCH SEWING MACHINES

R-19 IID

TWO NEEDLE, FOUR THREAD HEAVY DUTY HEMMING & SEAMING SEWING MACHINES

R-19 SERIES MACHINES

R-19HS

DESCRIPTION:

Single needle, two thread, double locked stitch sewing machine.

APPLICATION:

For seaming & hemming of light weight to heavy weight fabric such as woven PP, jute or burlap.

TECHNICAL TERMS:

Seam specification and stitch type

401

Stitch range

7-15 mm 9/32" -33/64

Standard setting of range

10mm = 25/64''

Maximum thickness of material

12 mm 7/12

Feed

Plain feed

Needle type

DRx4 Size 32 for using Jute Thread (Organ Make)

UY 1975 G 250/100 for using Cotton Thread (Groz Beckert)

Available sizes

080, 090, 100, 120, 140, 156, 172

Maximum speed

2100 Stitches / min.

Hand wheel diameter

152.4 mm = 6.00"

Pulley diameter

 $76.2 \, \text{mm} = 3.00''$

With motor speed

2800 R.P.M.

Phase

Single - 2 pole

Sewing yarn

Jute twine or cotton

Needle thread

18/6

Looper thread

14/3

Standard installation

non-submerged

R-19 HW

Same as R-19 HS, but single needle, single thread chain stitch sewing machine

Seam specification and stitch type: 101

MACHINES CLASS R-19 SERIES

R-19HD

DESCRIPTION:

Two needle, two independent row, four thread, double locked stitch bag sewing machine.

APPLICATION:

For seaming of heavy bags, exposed to constant and extreme pressure.

TECHNICAL TERMS:

Seam specification and stitch type : 401

Needle distance : $7.2 \,\mathrm{mm} = 9/32''$

Stitch range : 6-10 mm = 15/64'' - 25/64''

Standard setting of range : 8 mm = 5/16''

Feed : Plain feed

Teeth cut : 5 mm = 13/64''

Needle type : DRx4 Size 32 for using Jute Thread (Organ Make)

UY 1975 G 250/100 for using Cotton Thread (Groz Beckert)

Maximum speed : 2100 Stitches / min.

Hand wheel diameter : $152.4 \text{ mm} = 6.00^{\circ}$ Pulley diameter : $76.2 \text{ mm} = 3.00^{\circ}$

Standard installation : non-submerged

ADJUSTING INSTRUCTIONS

SETTING THE NEEDLE

Before adjusting the machine, insert new needle into the needle bar as far as possible. The long groove of the needle must be directed to the operator. Tighten the needle clamp nut securely.

ADJUSTING THE LOOPER

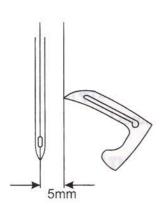
For convenient access remove the presser foot, throat plate and feed dog. Push the feed bar needle guard to the rear to avoid it contacting the needle. Insert the looper into the looper rocker. Set the looper so that the distance from the centre line of the needle to the point of the looper is 8 mm = 5/16" when the looper is at its farthest position to the right (looper gauge No. 21225-5/16). Therefore loosen the 2 nuts (269 and 18) on the looper connecting rod (80641) and turn the connecting rod forward or backward as required to obtain specified dimension, retighten nuts. When the looper is at its end position to the left, the distance from the centre line of the needle to the upper thread retaining must be 5 mm = 0.2". If it is not possible in the above mentioned way to realize the desired dimensions, then loosen the 2 clamping screws (22517) of the looper drive lever (80637), reposition as required and retighten them, assuring that all end play is taken out of the looper drive lever rocker shaft, but keep up some play in the 2 bearings (6039 K and 80657 A) at the end of the looper connecting rod.

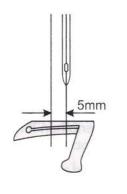
LOOPER AVOID MOTION

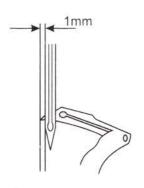
As the looper moves to the left, it should pass as close as possible to the back of the needle without contacting it. Adjustment can be made by loosening clamp screw (318) of the looper eccentric fork (80680) and turning the looper rocker shaft forward or backward as required retighten screw.

SETTING THE NEEDLE BAR

Set the needle bar so that the top of the needle eye is even with the underside of the looper, when the looper point in its travel to the left projects 1-1, $5 \, \text{mm} = 0.04 - 0.06''$ from the left side of the needle. If adjustment is necessary, loosen the clamping screw (BP 108) in the needle bar connection and move the needle bar up or down as required and retighten screw.







ADJUSTING THE FEED DOG

The height of the feed dog is correct, when at its highest point of travel, the rear teeth project above the throat plate their full depth. This can be accomplished by removing the feed dog holding screw and feed dog, then adjusting the stop screw in feed bar as required to maintain the prescribed setting. To adjust the feed dog within the throat plate, loosen the 2 bottom screws (88) of the feed rocker and after adjusting as required retighten them.

LOOPER THREAD TAKE UP

The cast off is correct adjusted when the free setting, means thread take up, happens at the moment as the needle descends into thread triangle, so that an early slip of the loop would be prevented. Too early or too late delivery of the looper thread causes skip stitches and thread breaking. This can be accomplished by higher or lower setting the thread take up in the long hole of the looper drive lever. Higher setting causes later and lower setting causes quick delivery of thread.

NEEDLE THREAD TAKE UP

The setting of the needle thread take-up is correct when the needle thread is raised about 2-3 mm = 5/64 - 1/8'' while the needle is descending.

ADJUSTING THE STITCH LENGTH

The length of the stitch can be adjusted by raising or lowering the stud 80696 in the segment slot of the feed rocker 80233. This can be accomplished by loosening nut HA 18 A, lowering stud 80696 will lengthen the stitch and raising the stud will shorten the stitch. When desired stitch length is obtained, retighten nut.

SETTING THE FEED BAR NEEDLE GUARD

Set the feed bar needle guard so that it barely contacts the needle at its most forward point of travel, screw secures it in place.

NOTE:

Any change in stitch length will necessitate a corresponding change in the feed bar needle guard setting.

SETTING HEIGHT OF PRESSER BAR AND PRESSER FOOT PRESSURE

The presser bar unit move freely. After removing the front cover (80687 A), the pressure of the presser foot can be altered. This can be accomplished by shifting the collars (80666), where the in the front fork shaped laminated springs 80663 and 80664 are supported. Use the screw 64 Y at the top cover to obtain the precise adjustment, retighten the lock nut 35733 B.

IMPORTANT:

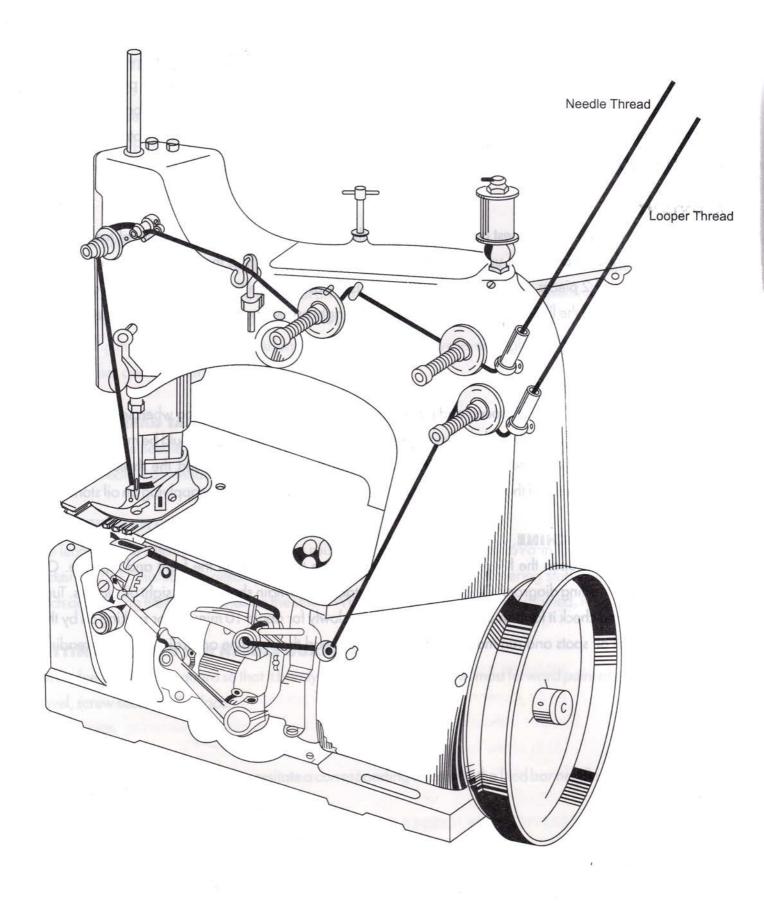
Between the presser foot at its highest point of travel and the needle clamp nut its lower point of travel, there must be a sufficient clearance. The upper travel limit is adjustable by shifting the upper collar on the right presser bar. In case of 2 pieces presser foot, the 2 parts must be at the same time actuated, raising as well as descending by means of the lifter lever. The lower collar of the right presser bar must support on the left presser bar guide.

SEWING OF THE MACHINE

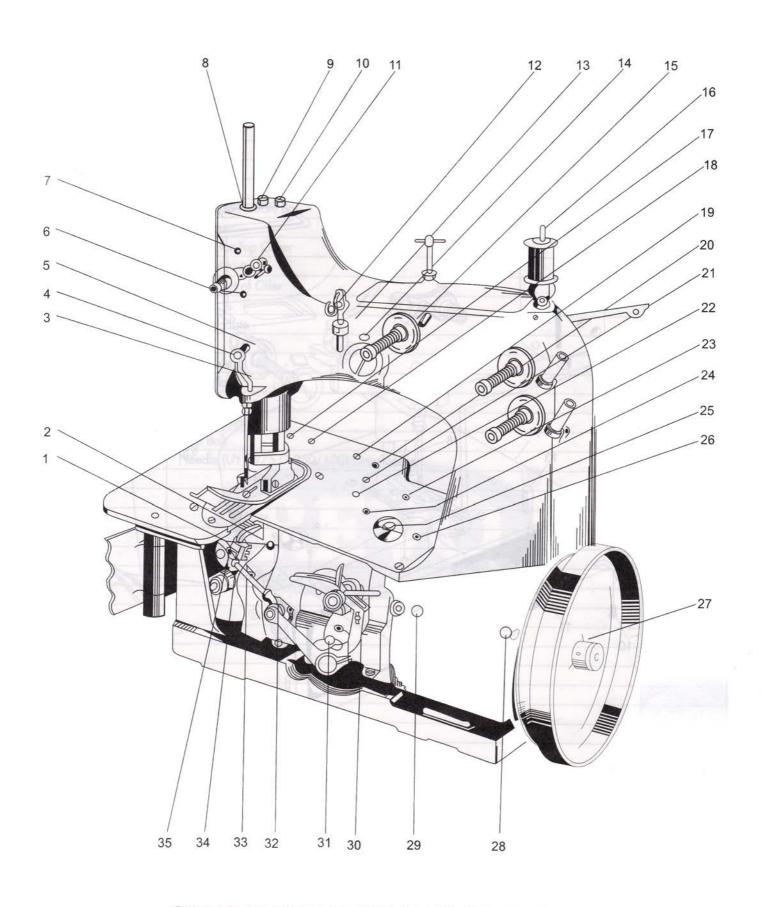
Start operating the machine at high speed and pay attention to an immaculate chaining when sewing on with fabric or without fabric. Regulate thread tension to get proper seams. As a rule, there should be more tension on the needle thread than on the looper thread tension. Should the sewing fabric and the thread chain be damaged (injured) by the teeth of the feed dog, then the teeth can be slightly dulled by applying an oil stone.

STARTING OF THE MACHINE

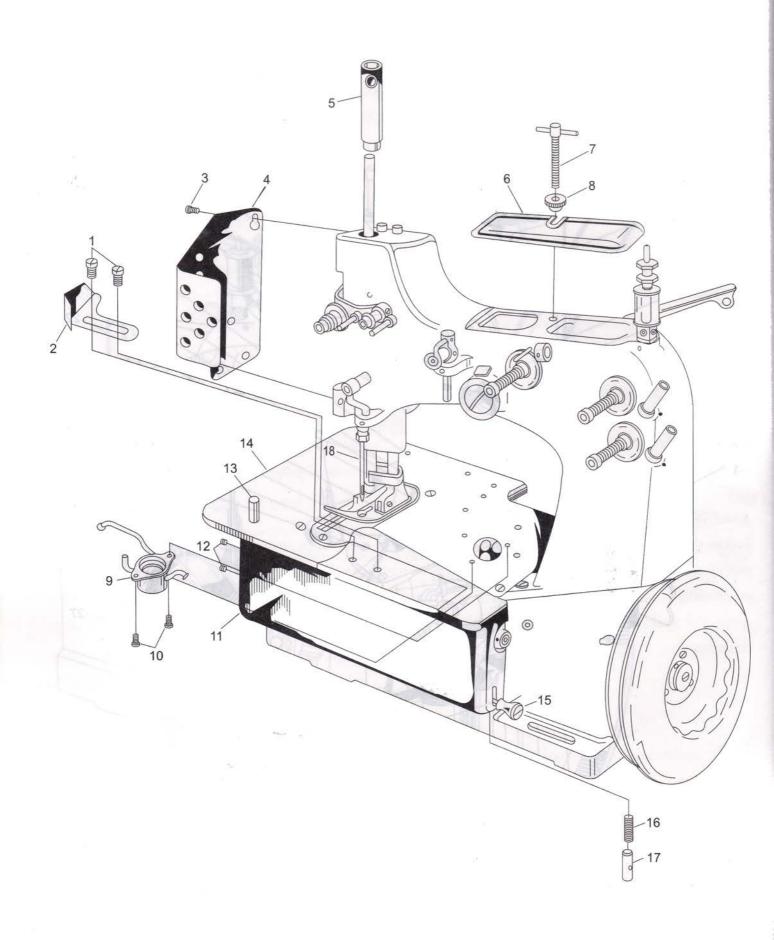
Before starting machine open the hinged front plate and remove the covers on the front and top side. Oil machine according to oiling diagram. Oil carefully all eccentrics on the main shaft. Fill the sight oil glasses. Turn machine by hand and check it for a smooth run. Run machine slowly for about 10 minutes for sucking oil by the wicks. Oil again all oil spots and run machine at full speed. Thread the machine according to the threading diagram.



THREADING DIAGRAM FOR MACHINE R-19HS



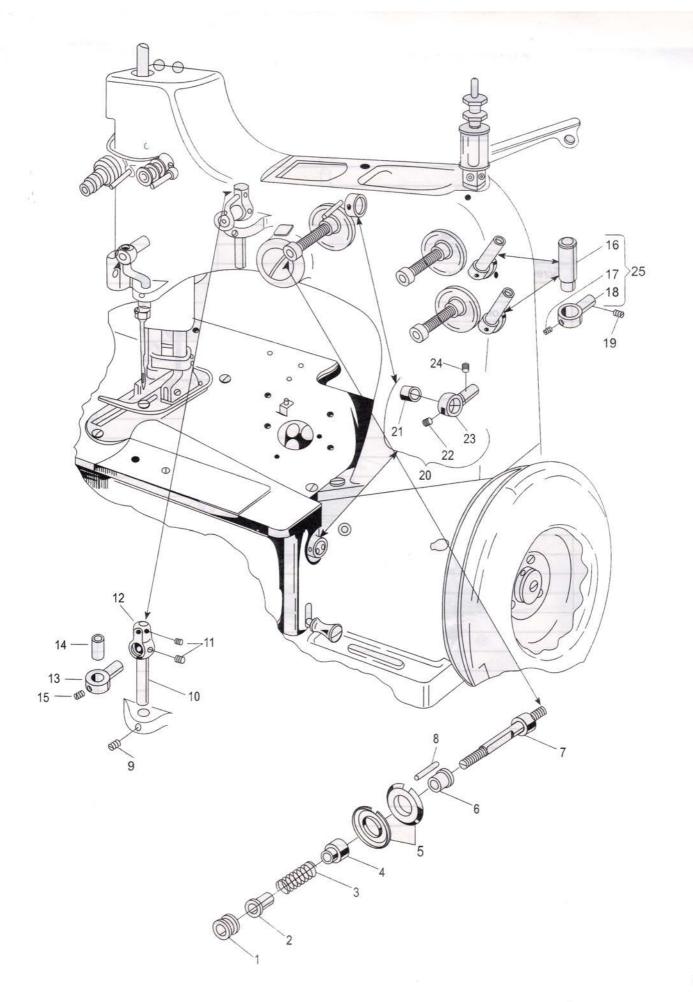
OILING DIAGRAM FOR MACHINE R-19HS





CLOTH PLATES, OILER, GUARDS AND MISCELLANEOUS COVERS

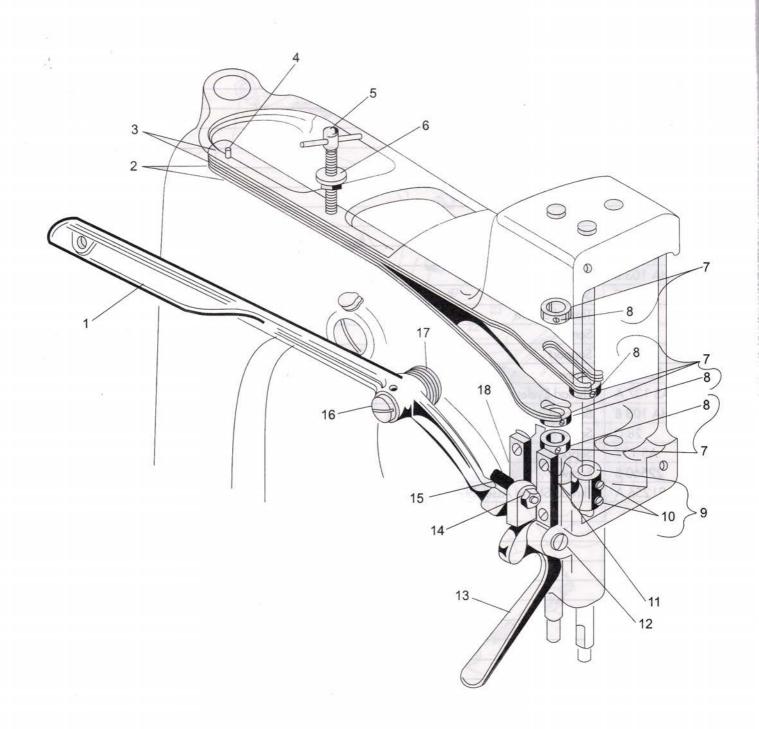
REF. No.	PART No.	DESCRIPTION	AMT. REQ.
1.	22514	Screw	2
2.	AS 24 A	Edge Guide	1
3.	93	Screw	1
4.	80887 A	Face Cover	1
5.	80673 C	Guard for Needle Bar	1
6.	80688	Top Cover	1
7.	64 Y	Screw, for Top Cover	1
8.	35733 B	Knurled Nut	1
9.	765021	Lower Part of Oiler	1
10.	22562	Screw	2
11.	80201 A	Hinged Plate	1
12.	89	Screw	2
13.	80437 A	Joint Axle	1
14.	80201 B	Cloth Plate	1
15.	80440	Guide Screw	1
16.	80438	Spiral Spring	1
17.	81239	Stop Bolt	1
18.	1975 G	Needle (UY 1975 G 250/100) Groz Beckert	1
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MISCELLANEOUS THREAD GUIDES AND THREAD TENSION

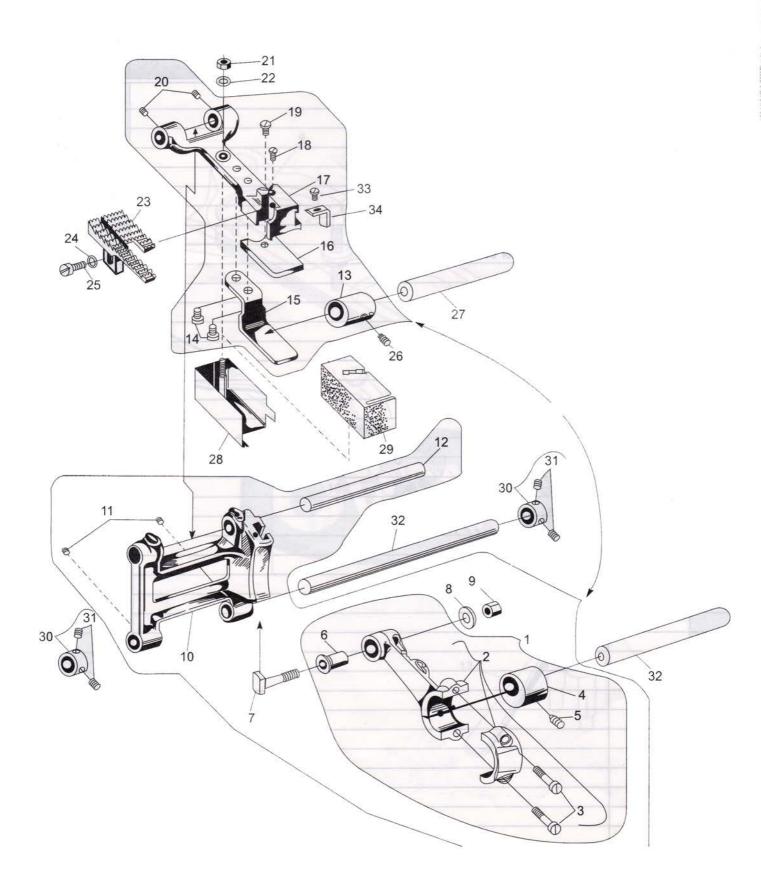
REF. No.	PART No.	DESCRIPTION	AMT. REQ.
1.	108	Tension Regulating Nut	2
2.	107	Tension Spring Ferrule	2
3.	110-4	Tension Spring	2
4.	HA 1349	Tension Sleeve	2
5.	80676 A	Tension Disc	4
6.	HA 1348	Tension Post Ferrule	2
7.	HS 106	Tension Post	2
8.	80667	Tension Disc Stop Pin	1
9.	95	Screw	1
10.	80665	Thread Roller Support	1
11.	95	Screw	1
12.	80250 A	Holder	1
13.	AS 137	Support	1
14.	HA 103 B	Support Bush	1
15.	28 C	Screw	1
16.	81256	Thread Sleeve	1
17.	28 C	Screw	1
18.	AS 137	Support	1
19.	22560 B	Screw (R)	2
20.	AS 137 A	Thread Eyelet with Support Assembly	2
21.	HA 103 B	Support Bush	1
22.	28 C	Screw	1
23.	AS 137	Support	1
24.	22560 B	Screw	1
25.	81256 A	Thread Sleeve Assembly	1
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PARTS FOR PRESSER FOOT LIFTER FOR 802000

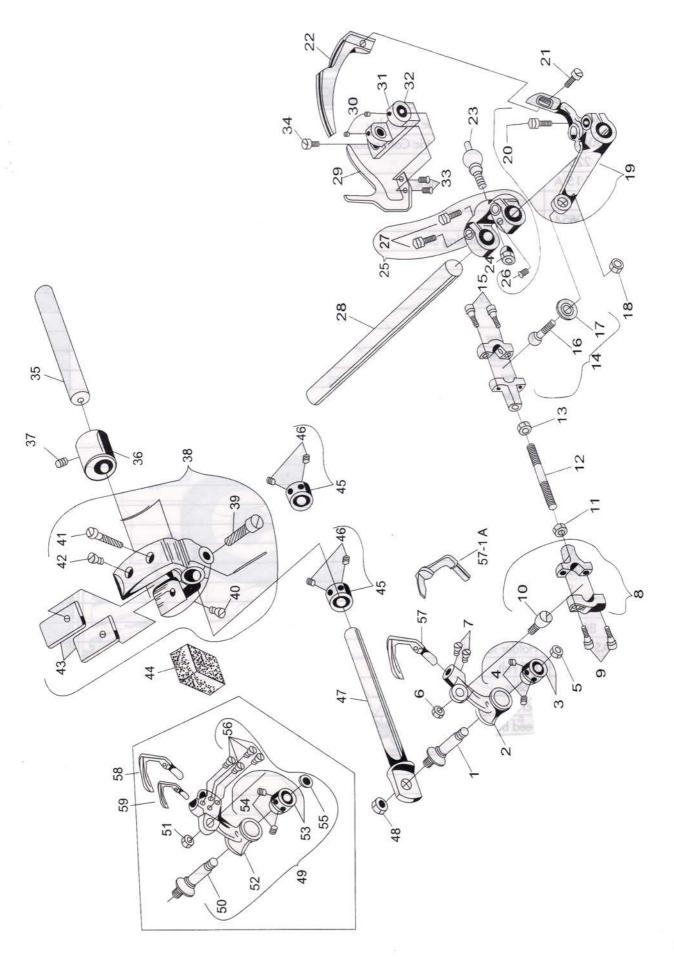
REF. No.	PART No.	DESCRIPTION	AMT. REQ.
1.	80648	Presser Foot Lifter Lever	1
2.	80664	Presser Foot Spring, Lower	2
3.	80663	Presser Foot Spring, upper	2
4.	80667	Pin a Roday Econtric	1
5.	64 Y	Screw	1
6.	35733 B	Lock Nut	1
7.	482 C	Collar	4
8.	98	Screw	2
9.	80632	Guide for Presser Bar	1
10.	95	Screw	2
11.	376	Screw (0)//	4
12.	11639 H	Screw	1
13.	80267	Presser Foot Lifter Hard Lever	1
14.	258	Nut	1
15.	22870	Screw	1
16.	420	Screw	1
17	80649	Spring	1
18.	80631	Guide Plate	2
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FEED LIFT AND FEED DRIVING PARTS

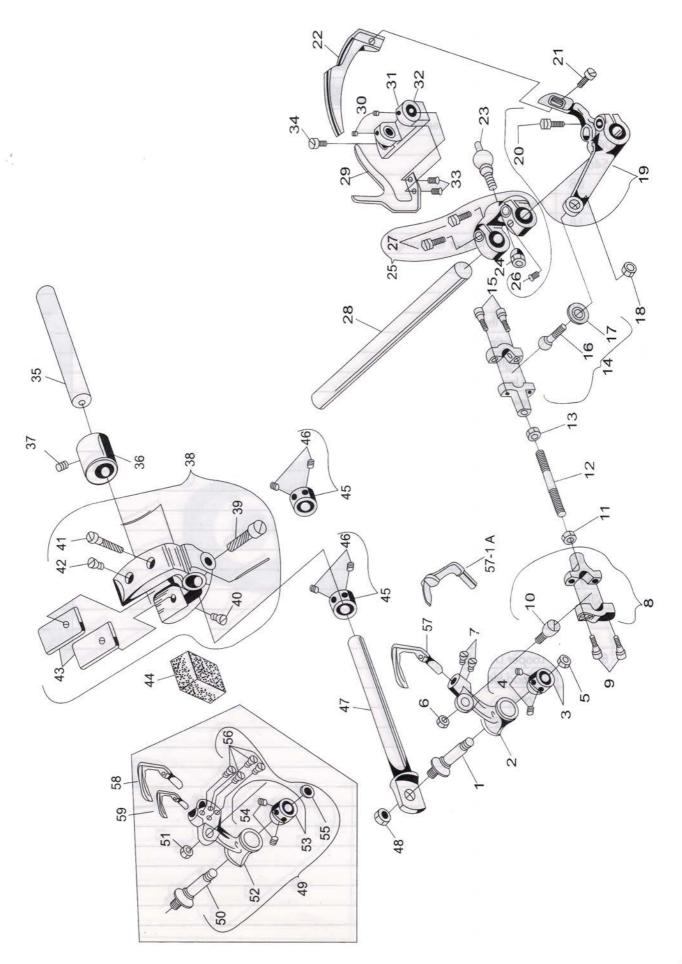
REF. No.	PART No.	DESCRIPTION	AMT. REQ
1.	29099 V	Feed Drive Eccentric Assembly	1
2.	80651 A	Feed Rocker Eccentric Connection	1
3.	22587	Screw	2
4.	HS 15 A	Feed Rocker Eccentric	1201
5.	81	Screw	1
6.	80654	Bushing	1
7.	80696	Stitch Regulating Stud	1
8.	HA 20 A	Washer	1
9.	HA 18 A	Nut	1
10.	80233	Feed Rocker	1
11.	89	Screw	2
12.	11	Feed Bar Shaft	1
13.	80206	Feed Lift Eccentric	1
14.	93 A	Screw	2
15.	HA 10	Guide for Eccentric	1
16.	HA 23	Base for Feed Bar	1
17.	80234 B	Feed Bar	1
18.	97 X	Screw	1
19.	93 A	Screw	1
20.	88	Screw	2
21.	18	Nut	1
22.	20	Washer IA A STATE OF THE STATE	1
23.	80205	Feed Dog	1
24.	80235	Serrated Washer	1
25.	93	Screw Division Investment of the Control of the Con	1
26.	96	Screw	1
27.	80222	Crank Shaft	1/1/
28.	AS 70 A	Holder for Felt	1
29.	HS 70 A	Oil Felt	1
30.	482 C	Collar	2
31.	98	Screw	2
32.	8 A	Feed Bar Shaft	1
33.	90	Screw	1
34.	81255	Needle Guard	1
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LOOPER DRIVE ASSEMBLY

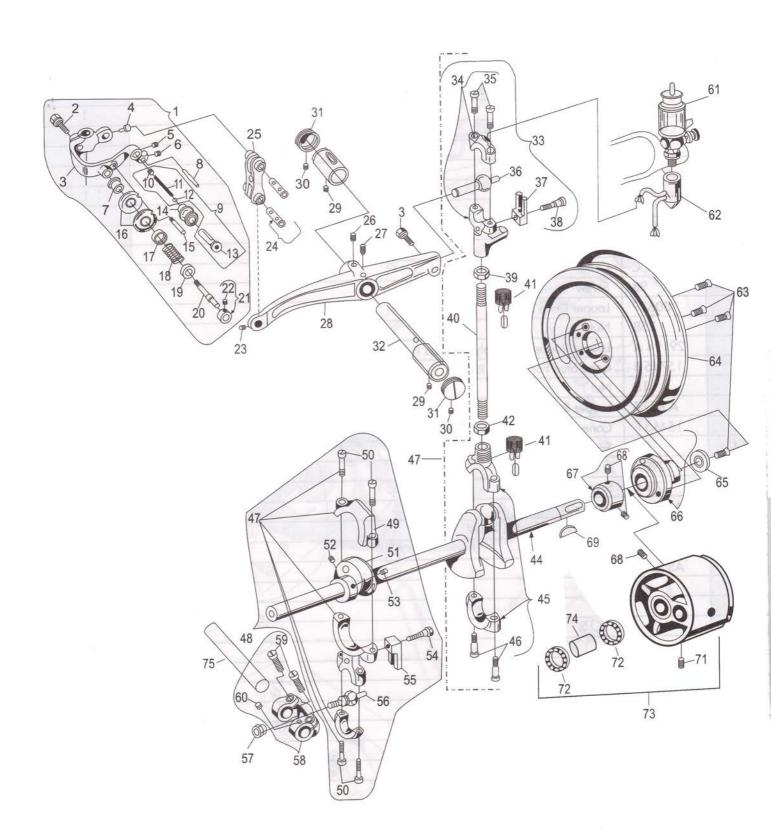
REF. No.	PART No.	DESCRIPTION	AMT. REG
1	15745 B	Cone Stud for looper Rocker	1
2	80613 A	Looper Rocker	1
3	15465 F	Rocker Cone	1
4	88	Screw Screw	2
5	12987 A	Nut	1
6	18	Nut	1
7	73-X	Screw, for looper fastening	2
8	6038 K	Ball Joint Assembly	1
9	97 A	Screw	2
10	10349	Ball Stud	1 1
11	269	Nut Left threaded	1
12	80641	Connecting Rod	1
13	18	Nut right threaded	1
14	6039 K	Ball Joint Assembly	1
15	97 A	Screw	2
16	10349	Ball Stud	1
17	HS 36 K	Washer	1
18	18	Nut	1
19	80637	Looper Drive Lever (R)	1
20	22517	Screw	2
21	J 79 J	Screw Screw	1
22	80623	Looper Thread Take up	1
23	80645	Looper Drive Ball Stud	1
24	80691	Nut	1
25	80638 A	Looper Drive Lever Shaft Rocker	1
26	96	Screw	1
27	136	Screw	2
28	80640	Looper Drive Lever Rocker Shaft	1
29	80604	Thread Hook	1
30	22743	Screw	1
31	80653	Holder for Thread Cast-off	2
32	HA 103 B	Thread Eyelet	1
33	5 BA	Screw	2
34	HA 61 D	Screw	2
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LOOPER DRIVE ASSEMBLY

REF. No.	PART No.	DESCRIPTION	AMT. REQ.
35	80222	Crankshaft Crankshaft	1
36	AS 38 B	Looper avoid Eccentric	1
37	81	Screw	1
38	80680	Looper Fork Assembly	1
39	318	Screw	1/
40	93	Screw Acceptable Control of the Cont	100
41	88 F	Screw	1
42	93	Screw Screw	2
43	80680 B	Guide Plate	01/201
44	80680 C	Oil Felt	1
45	482 C	Collar	1
46	98	Screw	2
47	80639	Looper Drive Shaft	1
48	258	Nut	1
49	29194 A	Looper Rocker Assembly for class R-19 HD	1
50	15745 B	Cone Stud For Looper Rocker	1
51	18	Nut September 1999	1
52	A 8377	Looper Rocker	1
53	15465 F	Cone	1
54	88	Screw Screw	2
55	12987	A Nut	1
56	73 X	Screw	4
57	AS 26 X	Looper	1
57-1A	AS 26 X1A	Blind Looper for R-19 HW	1
58	AS 27 XL	Looper	1
59	AS 27 X	Looper	1
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P. 3. 6.	29045 L	Needle Lever Bearing Assembly	
1-3/	80850	Bearing #0// VGV 590	
	22587	Screw	
	80656	Boll Stud	
	80636 A	Guide fork 08	
	22729	Screw	
1288	80630 C	Not, Left Thread	
	80630	Needle Lever Connecting Rod	
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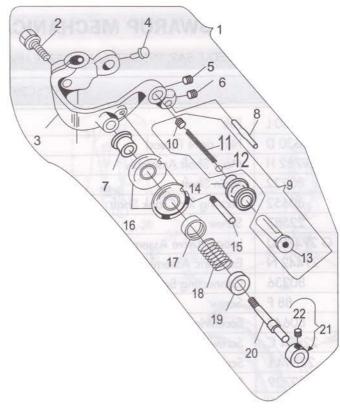
NEEDLE BAR, PRESSER BAR, NEEDLE LEVER, PULLEY AND CRANKSHAFT

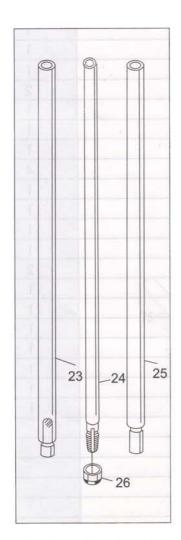
REF. No.	PART No.	DESCRIPTION	AMT. REQ.
1	29774 D	Needle Bar Connection Assembly	1
2	BP 108	Screw Screw	2
3	80659	Needle Bar Connection	1
4	91	Screw 39 / 20 / 20 / 20 / 20 / 20 / 20 / 20 / 2	6 1
5	88	Screw	1
6	22743	Screw	1
7	80669	Tension Post Ferrule	1
8	80655	Thread Guide Pin	1
9	HS 52 B	Rolling Thread Guide Axle Assembly	1
10	22560	Screw	1
11	HA 1286 B	Spring	1
12	12964 C	Ball O Part of the	1
13	81086 C	Rolling Thread Guide Axle	1
14	81093	Guide Roller	1
15	HS 100 D	Pin Screw	1
16	80676	Tension Disc	2
17	HA 58 C	Thread Tension Ferrule	1
18	HA 58 F	Spring	1
19	HA 58 D	Thread Tension Ferrule	1
20	80046	Tension Post	1
21	21111	Collar	1
22	88	Screw	1
23	22565 C	Screw	1
24	51134 V	Pin Assembly	2
25	HA 54 A	Needle Bar Connecting Link	1
26	95	Screw	1
27	81	Screw	1
28	80615	Needle Lever	1
29	89	Screw Screw	2
30	89	Screw Screw	2
31	80644	Plug Screw	2
32	80643	Needle Lever Shaft	1
33	29066 L	Needle Lever Bearing Assembly	1
34	80650	Bearing	1
35	22587	Screw	2
36	80656	Ball Stud	1
37	80636 A	Guide fork	1
38	22729	Screw	1
39	80630 C	Nut, Left Thread	1
40	80630	Needle Lever Connecting Rod	1
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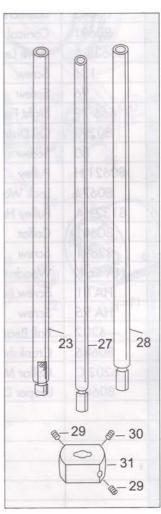
NEEDLE BAR, PRESSER BAR, NEEDLE LEVER, PULLEY AND CRANKSHAFT

REF. No.	PART No.	DESCRIPTION	AMT. REQ.
41	15430 L	Felt	1
42	80630 D	Nut, right Thread	1
43	29782 H	Main Shaft Assembly	1
44	80222	Main Shaft	1
45	80652	Bearing for Crank Shaft	1
46	22587	Screw	2
47	G 29479 U	Looper Drive Assembly	1
48	29442 N	Eccentric Assembly	1
49	80236	Connecting Bearing	1
50	88 F	Screw	4
51	80642	Eccentric	1
52	22894 C	Screw	1
53	22894 L	Screw	1
54	22729	Screw	1
55	80636 A	Guide Fork	1
56	80645	Ball Screw	1
57	80691	Conical Nut	1
58	80638 A	Drive Lever	1
59	136	Screw	2
60	96	Screw Screw	1
61	666-79	Sight Feed Oiler	1
62	80293	Oil Distributing Member	1
63	80	Screw	4
64	80621 H	Pulley	1
65	80674	Lock Washer	1
66	81321 A	Pulley Hub	1
67	80681	Collar	1
68	22891	Screw	2
69	HA 66 K	Woodruff Key	1
70	HA 81	Screw in Bed Lower Section	1
71	HA 95	Screw	1
72	6202	Ball Bearing	1
73	80685	Crankshaft bearing Housing	1
74	6202 C	Collar Main Shaft	1
75	80640	Looper Drive Liver Rocker Shaft	1
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R-19 HS, R-19 HW

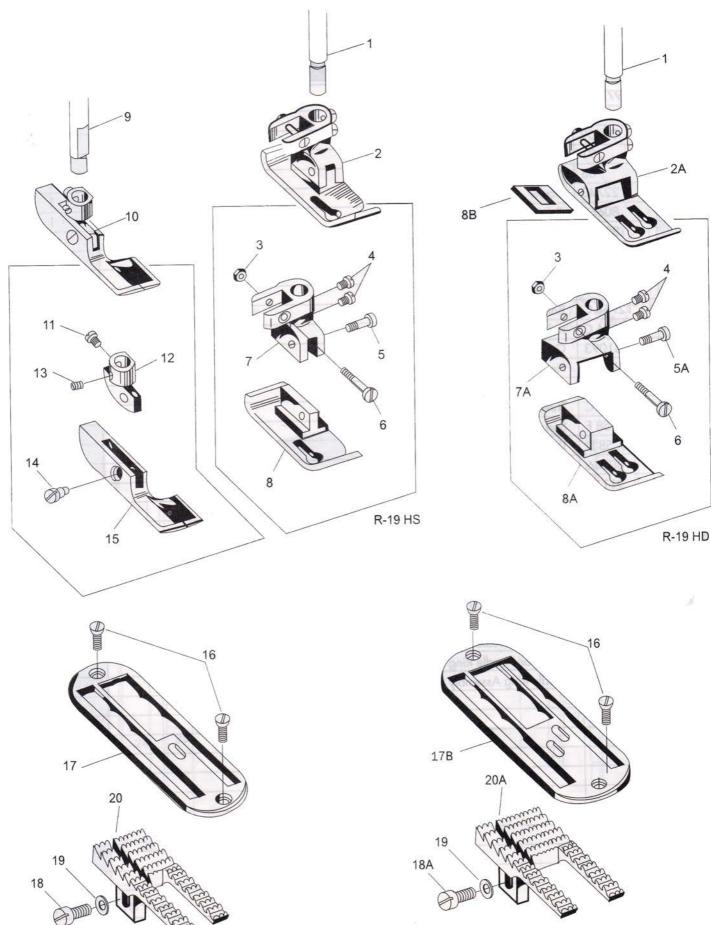


R-19 HD



NEEDLE BAR CONNECTION ASSEMBLY MISCELLANEOUS NEEDLE BARS AND PRESSER BARS

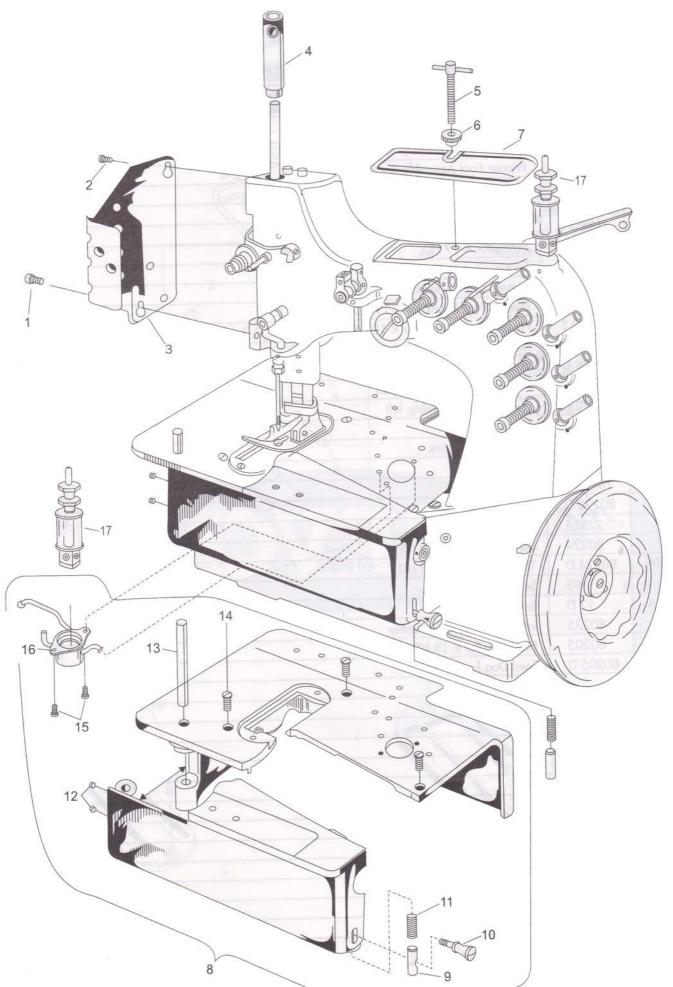
REF. No.	PART No.	DESCRIPTION	AMT. REG
1	29774 D	Needle Bar Connection Assembly	1
2	BP 108	Screw	2
3	80659	Needle Bar Connection	1
4	91	Screw	1
5	88	Screw	1
6	22743	Screw	1
7	80669	Tension Post Ferrule	1
8	80655	Thread Guide Pin	1
9	HS 52 B	Rolling Thread Guide Axle Assembly	1
10	22560	Screw	1
11	HA 1286 B	Spring	1
12	12964 C	Ball	1
13	81086 C	Rolling Thread Guide Axle	1
14	81093	Guide Roller	1
15	HS 100 D	Pin Screw	1
16	80676	Tension Disc	2
17	HA 58 C	Thread Tension Ferrule	1
18	HA 58 F	Spring	1
19	HA 58 D	Thread Tension Ferrule	1
20	80046	Tension Post	1
21	21111	Collar	1
22	88	Screw	1
23	80660	Presser Bar Left	1
24	80617	Needle Bar for R-19 HS, R-19 HW	1
25	80661	Presser Bar right for all R-19 HS	1
26	HA 56	Nut for needle Clamping	71
27	A 7894	Needle Bar for R-19 HD	1
28	80661	Presser Bar right for R-19 HD	1
29	89	Screw for Needle Fastening Allen Key 5mm	2
30	35	Screw for Needle Ring Fastening Allen Key 5mm	1
31	A 7895	Needle Ring Assembly for R-19 HD	1
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PARTS FOR PRESSER FOOT LIFTER FOR ALL R-19 SERIES

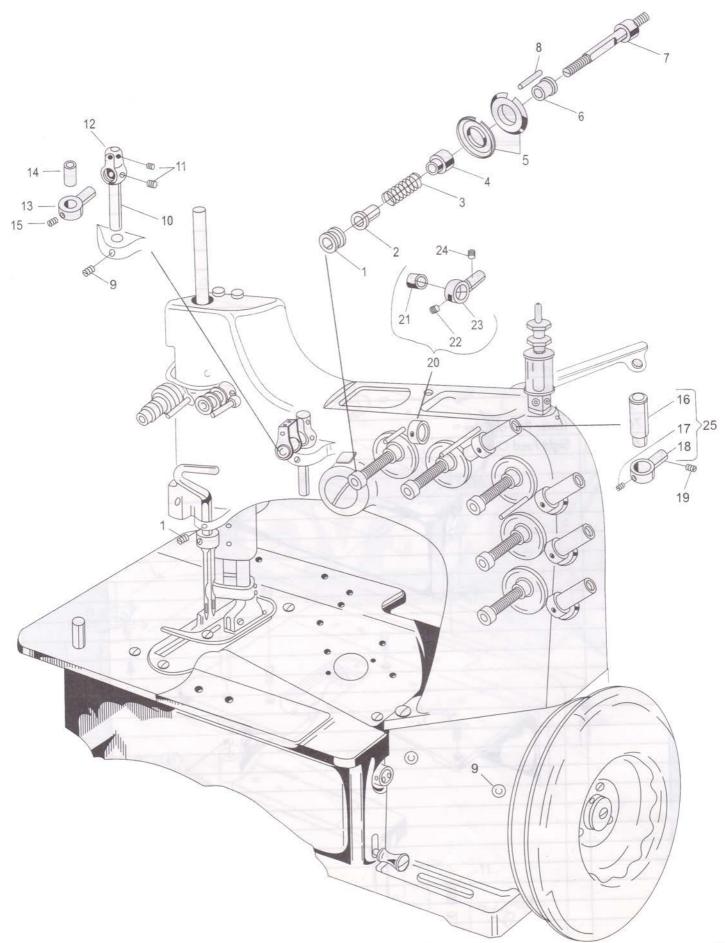
REF. No.	PART No.	DESCRIPTION	AMT, REQ.
1.	80661	Presser Bar, right for all Styles	1
2.	80220	Presser Foot Assembly, for R-19 HS	1
2A.	80220 D	Presser Foot Assembly, for R-19 HD	1
3.	907	Nut and the Class Religible	1
4.	88 A	Screw	2
5.	HA 65 E	Screw for R-19 HS	1
5A.	HA 65 ED	Screw for R-19 HD	1
6.	22525 C	Screw	1
7.	80220 C	Presser Foot Shank for R-19 HS	1
7A.	80220 CD	Presser Foot Shank for R-19 HD	- 1
8.	80228 B	Presser Foot Bottom for R-19 HS	1
8A.	80228 BD	Presser Foot Bottom for R-19 HD	
8B.	80228 G	Presser Foot Bottom Collar	1
9.	80668	Presser Bar, left for all Styles	1
10.	80220 A	Presser Foot Assembly, left	1
11.	88A	Screw	1
12.	80620 E	Presser Foot Shank	1
13.	88	Screw	1
14.	HA 65 L	Screw	1
15.	80220 D	Presser Foot Bottom	1
16.	22526	Screw	2
17.	80224	Throat Plate for R-19 HS	1
17A.	80224 D	Throat Plate for R-19 HD	-1
18.	93	Screw for R-19 HS	1
18A.	93 D	Screw for R-19 HD	1
19.	80235	Internal Tooth Lock Washer	1
20.	80205	Feed Dog for R-19 HS	9-81-1
20A.	80205 D	Feed Dog for R-19 HD	1
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CLOTH PLATES, OILER, GUARDS AND MISCELLANEOUS COVER

REF. No.	PART No.	DESCRIPTION	AMT, REG
1.	93	Screw	1
2.	93	Screw	1
3.	80687	Face Cover for Class R-19 HD	1
4.	80673 C	Guard for Needle Bar	301
5.	64 Y	Screw for Top Cover	1
6.	35733 B	Knurled Nut	1
7.	80688	Top Cover	1
8.	A 8378	Cloth plate Assembly for R-19 HD	1
9.	81239	Stop Bolt	1
10.	80440	Guide Screw	1
11.	80438	Spiral Spring	1
12.	89	Screw	2
13.	80437 A	Joint Axle	1
14.	22517	Screw	3
15.	22562	Screw	2
16.	765021	Lower Part of Oiler	1
17.	666-79	Sight Feed Oiler	2
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MISCELLANEOUS THREAD GUIDES AND THREAD TENSION

REF. No.	PART No.	DESCRIPTION	AMT. REQ.
1.	108	Tension Regulating Nut	2
2.	107	Tension Spring Ferrule	2
3.	110-4	Tension Spring	2
4.	HA 1349	Tension Sleeve	2
5.	80676 A	Tension Disc	4
6.	HA 1348	Tension Post Ferrule	2
7.	HS 106	Tension Post	2
8.	80667	Tension Disc Stop Pin	1
9.	95	Screw	1
10.	80665	Thread Roller Support	1
11.	95	Screw	1
12.	80250 A	Holder	1
13.	AS 137	Support	1
14.	HA 103 B	Support Bush	1
15.	28 C	Screw	1
16.	81256	Thread Sleeve	1
17.	28 C	Screw	1
18.	AS 137	Support	1
19.	22560 B	Screw	2
20.	AS 137 A	Thread Eyelet with Support Assembly	2
21.	HA 103 B	Support Bush	1
22.	28 C	Screw	1
23.	AS 137	Support	1
24.	22560 B	Screw	1
25.	81256 A	Thread Sleeve Assembly	1
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Manufacturers

SWARUP MECHANICAL WORKS