

SINGER®

INSTRUCTION MANUAL ILLUSTRATED PARTS LIST

FOR HIGH-SPEED FLAT-BED INTERLOCK SEWING MACHINE

2754A 331

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IMPORTANT SAFETY INSTRUCTIONS

When using this machine, basic safety precautions should always be followed. Read all instruction before using the machine.

1. Whenever using the machine, understand the basic safety instructions which are not just limited to the following items.
2. Read all instructions and take care of the instruction book for your reference at any moment.
3. Before operating, confirm the relevant safety specifications and standards of this machine are fit for your country.
4. The machine should not be used without its relevant safety devices.
5. General operation must only be carried out by the appropriately trained person.
6. For your personal safety, it is recommended that suitable safety glasses should be worn when operating the machine
7. In the following situation, switch off the machine or unplug the machine from the electrical outlet.
 - 7.1 Threading the needle and replacing bobbin or looper.
 - 7.2 Replacing the needle, presser foot, throat plate, feed dog and sliding plate, etc..
 - 7.3 During service work.
 - 7.4 When the workplace is left unattended.
8. If lubricating oil comes into contact with the eyes or skin, they should immediately be washed with a generous amount of cold water.

If any lubricating oil is ingested, medical advice should be sought immediately.
9. Whether the machine is running or not, you never casually change or fiddle with the parts and the relevant device of the machine.
10. Repairs, conversion and special maintenance work must only be carried out by trained technicians.
11. Normal repairs and maintenance work must only be carried out by persons with special training.
12. Service work on the electrical equipment should always be carried out by qualified electricians or appropriately trained persons. Once an electric element is found to be damaged, the machine must be stopped immediately.
13. Clean the machine periodically.
14. Before commencing full operation of the machine, a trial run should be carried out to ensure that it is capable of performing the task required.

The machine should not be located next to a source of strong noise such as a high frequency welding machine, etc.
15. The machine should only be operated with the appropriate plug and cord with proper earthing.
16. Singer will not bear any responsibility for damage or injury caused by unauthorized modifications to the machine.
17. The machine should only be used for sewing the type of materials and in the manner indicated in the accompanying instructions for operation.

FOR SAFE OPERATION

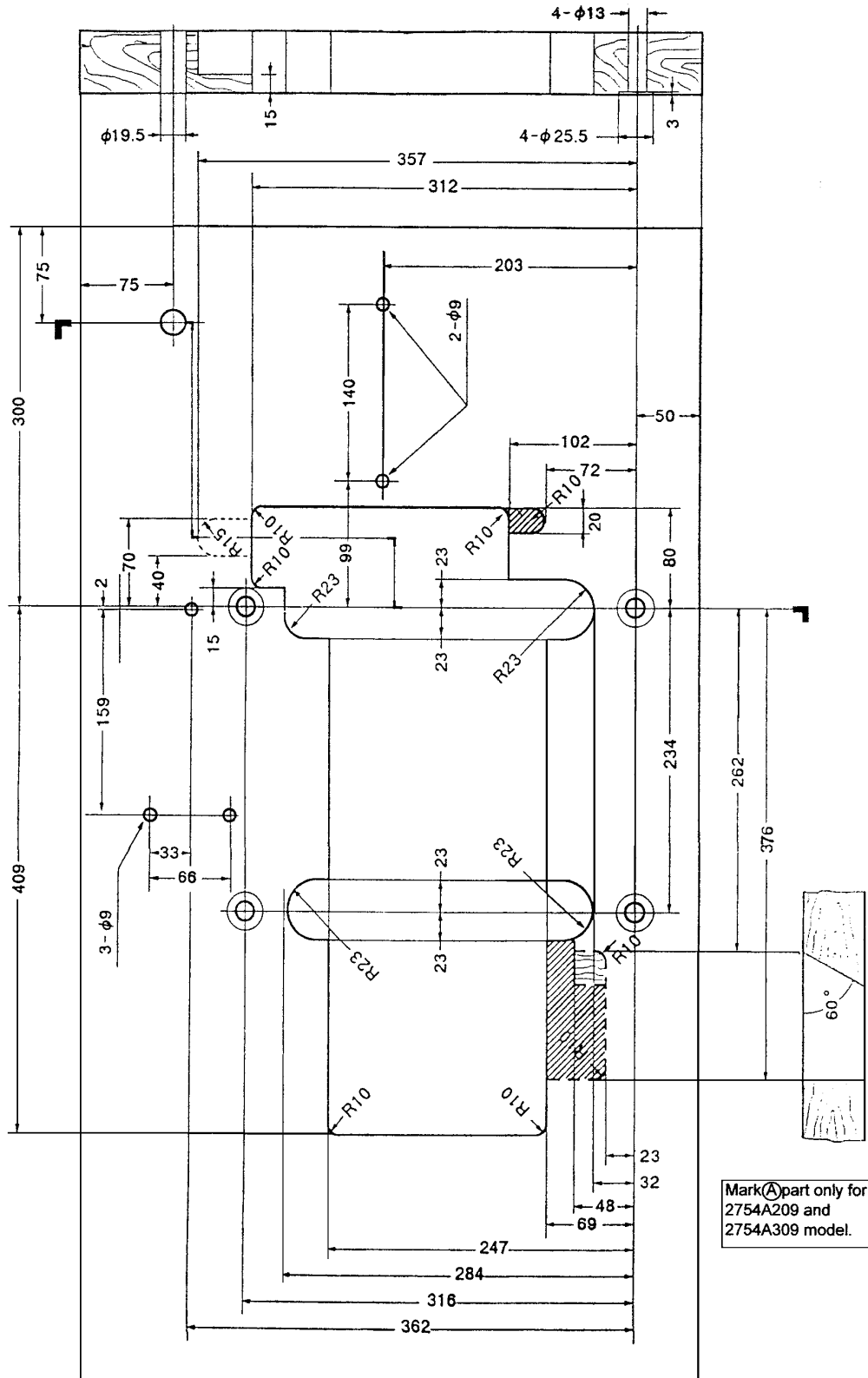
1. To avoid electrical shock hazards, neither open the cover of the electrical box for the motor nor touch the components mounted inside the electrical box.
2. To avoid personal injury, never operate the machine with any of the belt cover, finger guard or safety devices removed.
3. To prevent possible personal injuries caused by being caught in the machine, keep your fingers, head and clothes away from the Handwheel, V belt and the motor while the machine is in operation. In addition, place nothing around them.
4. To avoid personal injury, never put your hand under the needle when you turn "ON" the power switch or operate the machine.
5. To avoid personal injury, never put your fingers into the thread take-up cover while the machine is in operation.
6. The hook rotates at a high speed while the machine is in operation. To prevent possible injury to hands, be sure to keep your hands away from the vicinity of the hook during operation. In addition, be sure to turn OFF the power to the machine when replacing the bobbin.
7. To avoid possible personal injuries, be careful not to allow your fingers in the machine when tilting/raising the machine head.
8. To avoid possible accidents because of abrupt start of the machine, turn OFF the power to the machine when tilting the machine head or removing the belt cover and the V belt.
9. If your machine is equipped with a servo-motor, the motor does not produce noise while the machine is at rest. To avoid possible accidents due to abrupt starting of the machine, be sure to turn OFF the power to the machine.
10. To avoid electrical shock hazards, never operate the sewing machine with the ground wire for the power supply removed.
11. To prevent possible accidents because of electric shock or damaged electrical component(s), turn OFF the power switch in prior to the connection/disconnection of the power plug.

High Speed Flat-bed Interlock sewing machine Specification

| Model | Application | Singer Needle Cat. | needle | Thread | Needle guage (mm) | Stitch Length (mm) | differential Rate | Presser foot lift (mm) | Speed | Packing Size (mm) | NW/GW (Kg) | Device | | | | | | | | | | | | | | | |
|---------------|---|-----------------------|--------|--------|-------------------|--------------------|-------------------|------------------------|-------|-------------------|------------|---|-------------|-------|---|-------------|-------|-------------------------|-------------|-------|--|-------------|-------|-----------------------------------|-------------|-------|-----------------|
| 2754A331-0xxM | Be suitable for knitting material, and able to adorn two-sides. | Cat.3651-06 -75/11 | 2 | 4 | 4.0-4.8 | 4.4 | 0.5-1.3 | 6.3 | 6000 | 600*390*630 | 50/55 | 3 in 1 application device.(The device is included at the accessory) Plain seaming / Overlock seam covering / Bottom hemming. | | | | | | | | | | | | | | | |
| | | | 3 | 5 | 5.6-6.4 | 5 | | | | | | | | | | | | | | | | | | | | | |
| 2754A303-0xxM | Be suitable for sewing rolled-edge of and T-shirt. | Cat.3651-06 -75/11 | 2 | 4 | 4.0-4.8 | 4.4 | 0.5-1.3 | 6.3 | 6000 | | | | 600*390*630 | 50/55 | Tape binder. | | | | | | | | | | | | |
| | | | 3 | 5 | 5.6-6.4 | 5 | | | | | | | | | | | | | | | | | | | | | |
| 2754A313-0xxM | Be suitable for cover sewing rolled-edge of underwear and sports wear. | Cat.3651-06 -75/11 | 2 | 4 | 4.0-4.8 | 4.4 | 0.5-1.3 | 6.3 | 6000 | | | | | | | 600*390*630 | 50/55 | Overlock seam covering. | | | | | | | | | |
| | | | 3 | 5 | 5.6-6.4 | 5 | | | | | | | | | | | | | | | | | | | | | |
| 2754A309-0xxM | Be suitable for sewing elastic lace of short pants and coracty and be equipped with an atomatic edge cutter. (Right-hand knife) | Cat.3651-06 -75/11 | 2 | 4 | 4.0-4.8 | 4.4 | 0.5-1.3 | 5.3 | 5000 | | | | | | | | | | 600*390*630 | 50/55 | Elastic tape and lace attachment with right-hand fabric trimmer. | | | | | | |
| | | | 3 | 5 | 5.6-6.4 | 5 | | | | | | | | | | | | | | | | | | | | | |
| 2754A308-0xxM | Be suitable for sewing elastic lace of short pants and coracty. | Cat.3651-06 -75/11 | 2 | 4 | 4.0-4.8 | 4.4 | 0.5-1.3 | 6.3 | 5000 | | | | | | | | | | | | | 600*390*630 | 50/55 | Elastic tape and lace attachment. | | | |
| | | | 3 | 5 | 5.6-6.4 | 5 | | | | | | | | | | | | | | | | | | | | | |
| 2754A311-0xxM | Be suitable for folding sewing skirt and cuff of T-shirt and underwear. | Cat.3651-06 -75/11 | 2 | 4 | 4.0-4.8 | 4.4 | 0.5-1.3 | 6.3 | 6000 | | | | | | | | | | | | | | | | 600*390*630 | 50/55 | Bottom hemming. |
| | | | 3 | 5 | 5.6-6.4 | 5 | | | | | | | | | | | | | | | | | | | | | |
| 2754A300-0xxH | Be suitable for asirming of the heavy-duty material such as sweater, flannek clothes etc. | Cat.3651-06 -90/14 | 3 | 5 | 5.6-6.4 | 3.3 | 0.5-1.3 | 7 | 5000 | 600*390*630 | 50/55 | Plain seaming for heavy material. | | | | | | | | | | | | | | | |
| | | | 2 | 4 | 4.0-4.8 | 4.4 | | 6.3 | | | | | | | | | | | | | | | | | | | |
| 2754A341-0xxM | Be suitable for knitting material, and able to adorn two-sides. | Cat.3651-06 -75/11 | 2 | 4 | 4.0-4.8 | 4.4 | 0.5-1.3 | 6.3 | 6000 | | | | 600*390*630 | 50/55 | 4 in 1 application device.(The device is included at the accessory) Plain seaming / Tape binder / Overlock seam covering / Bottom hemming. | | | | | | | | | | | | |
| | | | 3 | 5 | 5.6-6.4 | 5 | | | | | | | | | | | | | | | | | | | | | |

**MACHINE TABLE
CUTTING**

Cutting Diagram Of The Machine Table



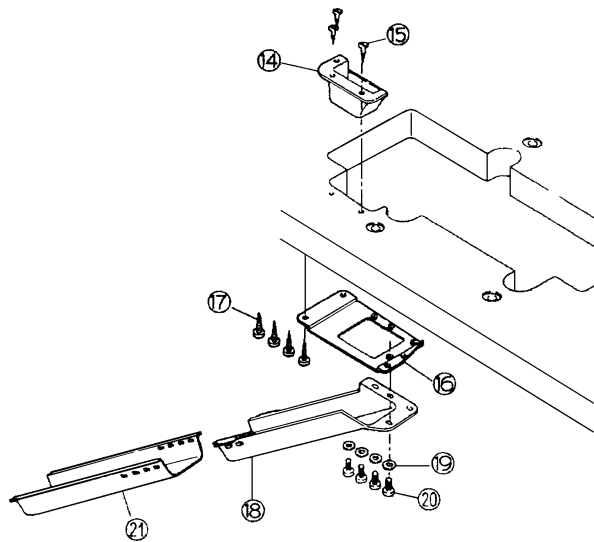
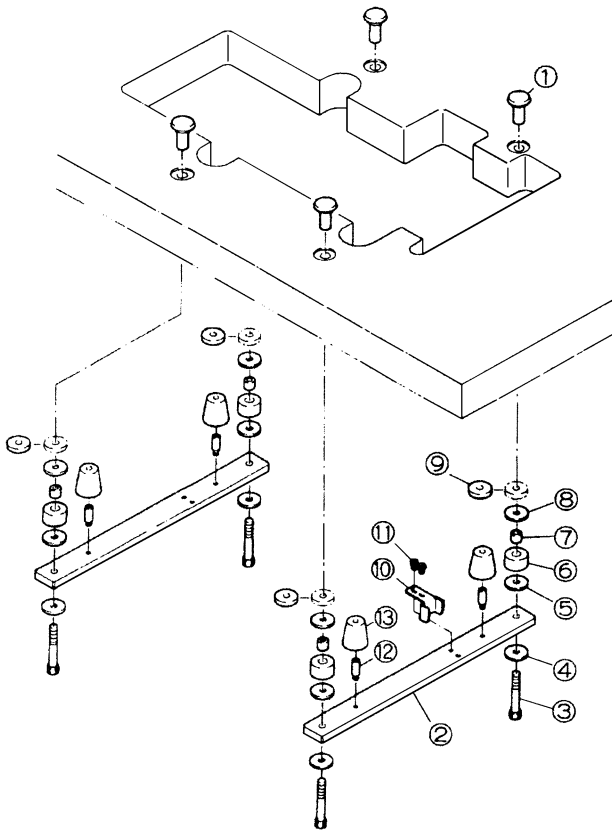
MACHINE HEAD INSTALLATION

Assembling The Machine Supporting Components

Following are the procedure for assembling the machine rest board.

Assembling the machine rest board by following step 1~13 in the below illustration.

Select the washer⑨ based on the thick of the table.



Waste chute necessary just for
2754A309 model.

Following are the specifications for the motor and V-belt

1. Motor:

2-pole(2800rpm), 1/2HP(400 or 370W) clutch motor.

2. V-belt:

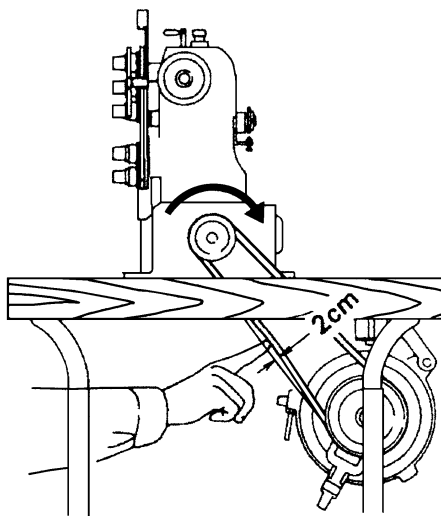
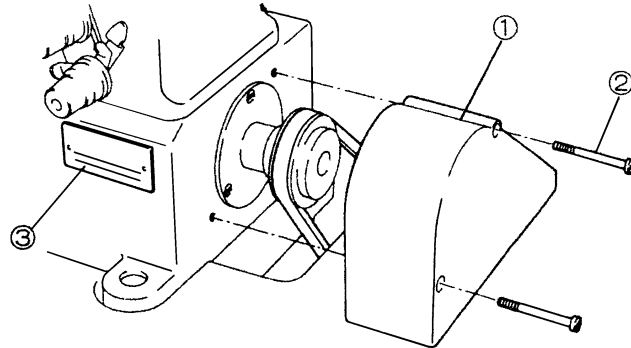
Type M

3. Motor pulley:

Select the proper motor pulley for the speed of machine to be used by referring to the table shown left.

| Machine speed (r.p.m) | Motor pulley diameter(mm) | |
|--------------------------|---------------------------|------|
| | 60Hz | 50Hz |
| 6,000 | 105 | 125 |
| 5,500 | 95 | 115 |
| 5,000 | 85 | 105 |
| 4,500 | 80 | 95 |
| 4,000 | 70 | 85 |

For safety reasons, make sure the Belt Guard ① is fixed on the machine ③ with supplied screws ②.



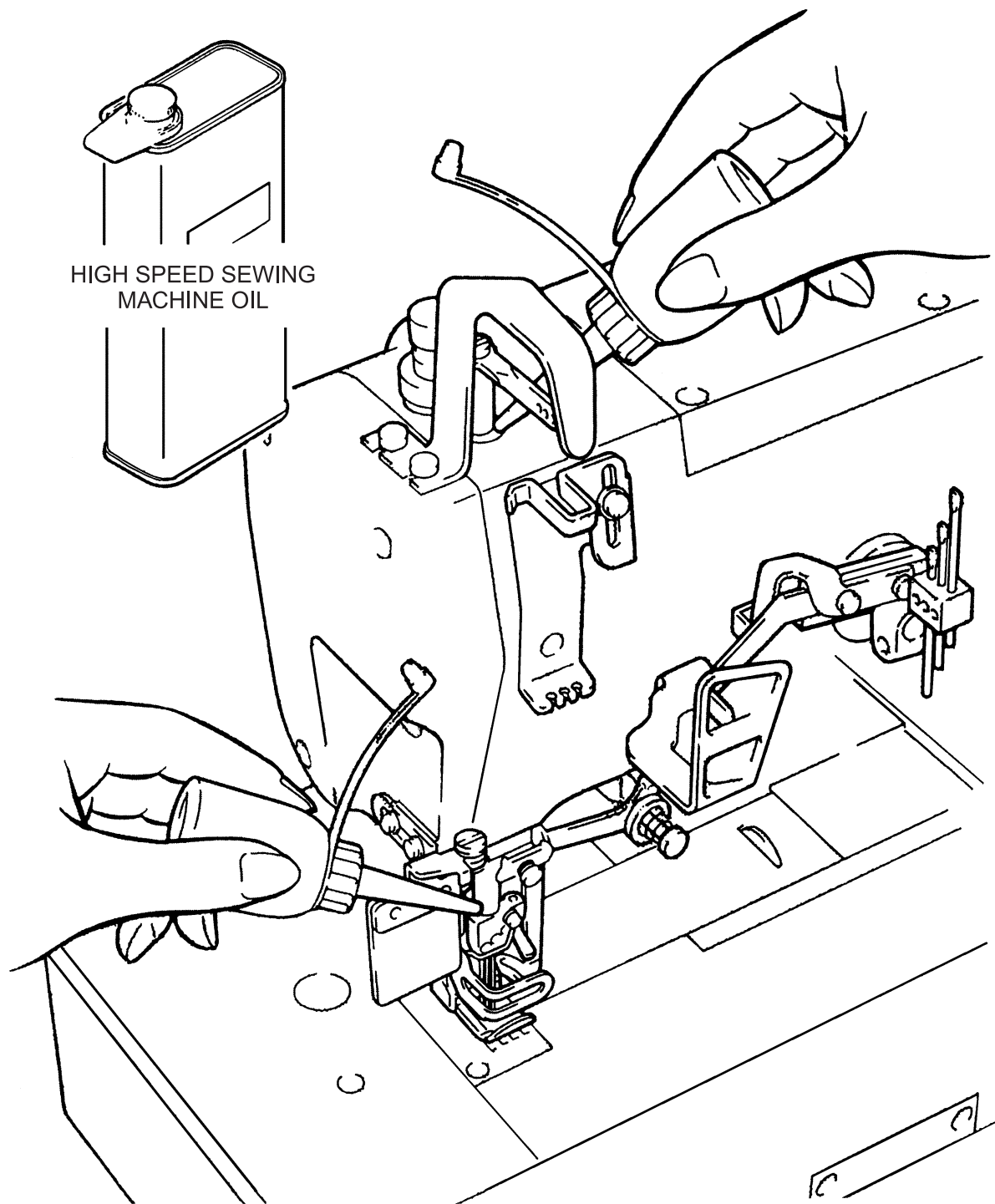
Adjust the tension of belt so that it can be 2 cm bent in ward when you press the middle of it.

Machine pulley must rotate clockwise (from right side view),as indicated in the figure.

**BEFORE
OPERATING**

Manual lubrication

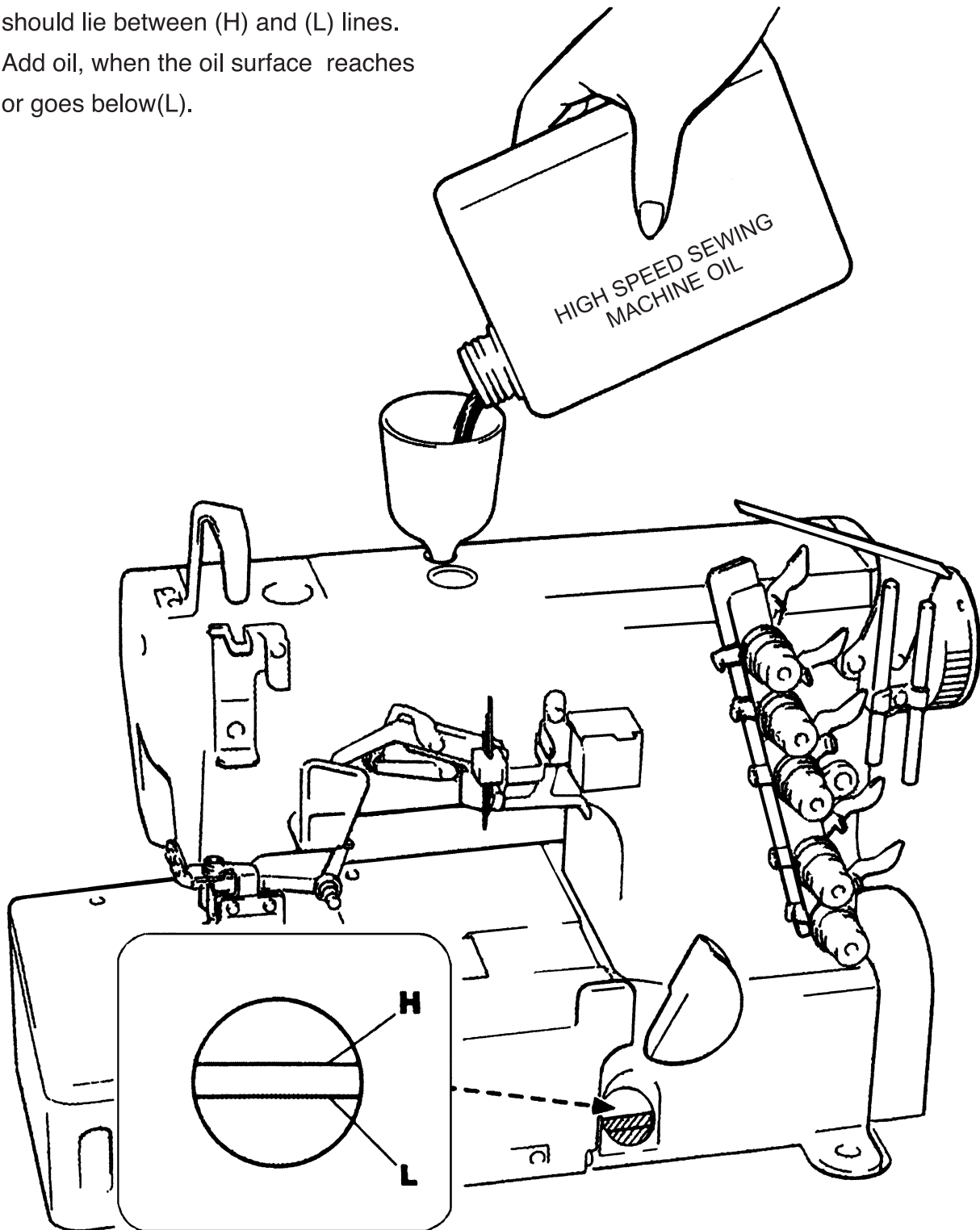
Apply 2 or 3 drops of oil by hand when the machine is used for the first time or has been left unused for some time.



**BEFORE
OPERATING**

Lubrication

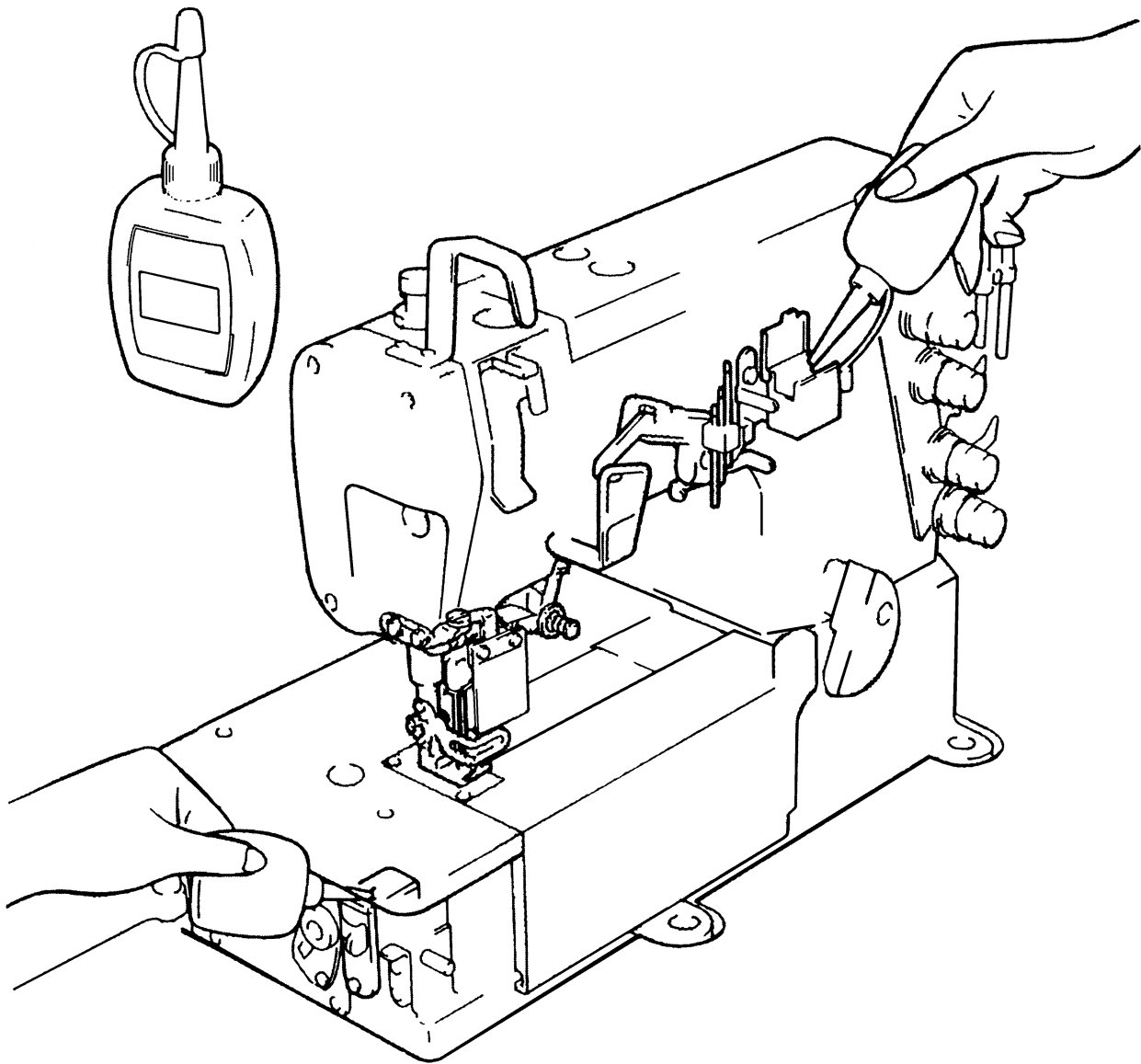
After filling the oil pan, the oil surface should lie between (H) and (L) lines. Add oil, when the oil surface reaches or goes below(L).



**BEFORE
OPERATING**

Filling the HR device with silicon oil

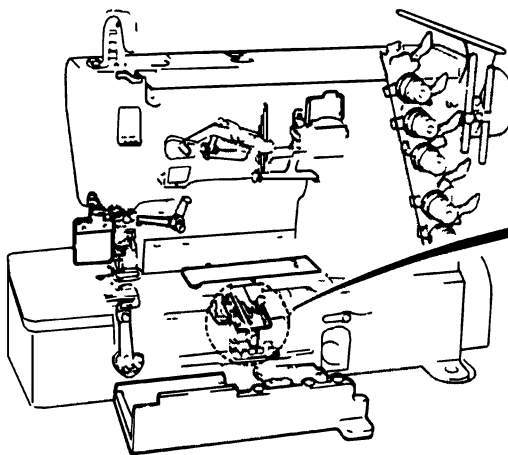
Fill the device with oil before it is too low in order to prevent needle thread breakage and fabric damage.



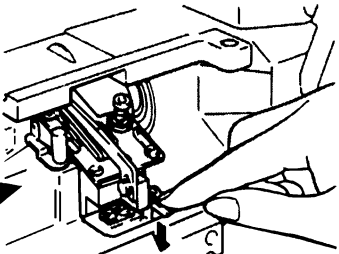
**BEFORE
OPERATING**

Threading (1)

① Open the eye guard and three covers.

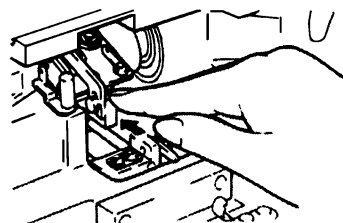


② Press down.



The looper thread take-up comes out.

④ Replace the looper thread take-up after threading.

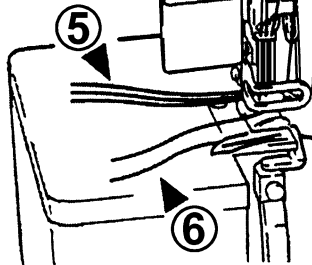


Knot the preset and the new thread together to thread the machine.

③

Needle thread

Trim the knots off neatly before passing through the eye of the needle to thread.

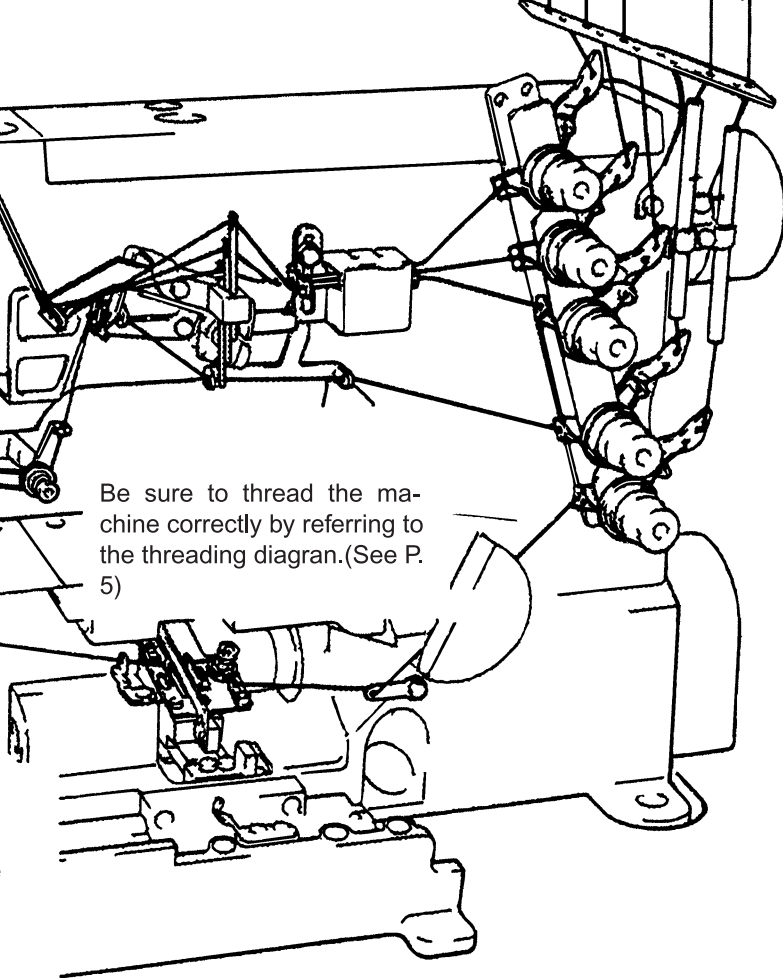


Looper thread and Top cover thread

Trim the knots off neatly after passing through the eye of the looper

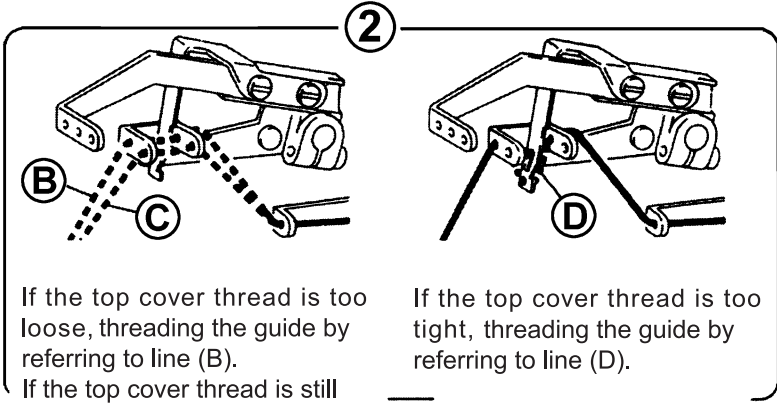
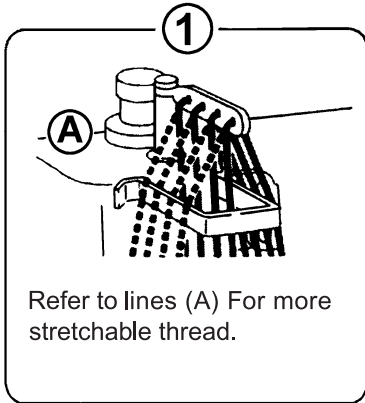
⑥

Be sure to thread the machine correctly by referring to the threading diagram. (See P. 5)

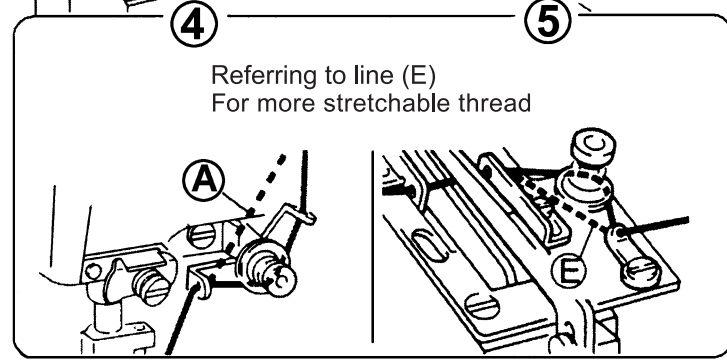
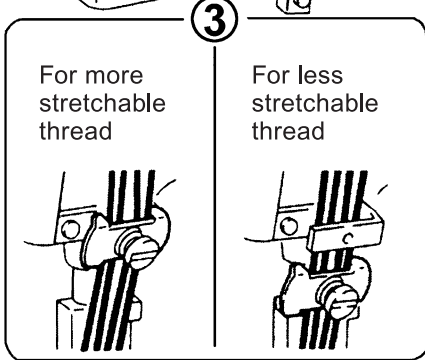
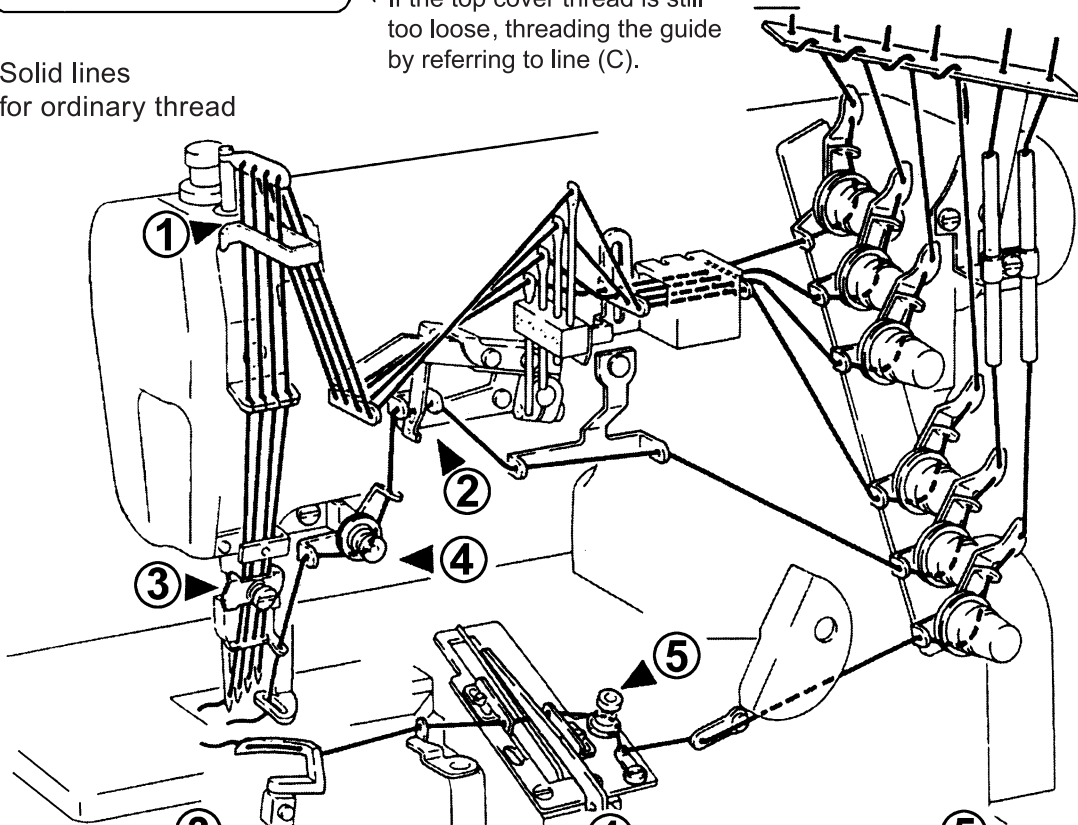


**BEFORE
OPERATING**

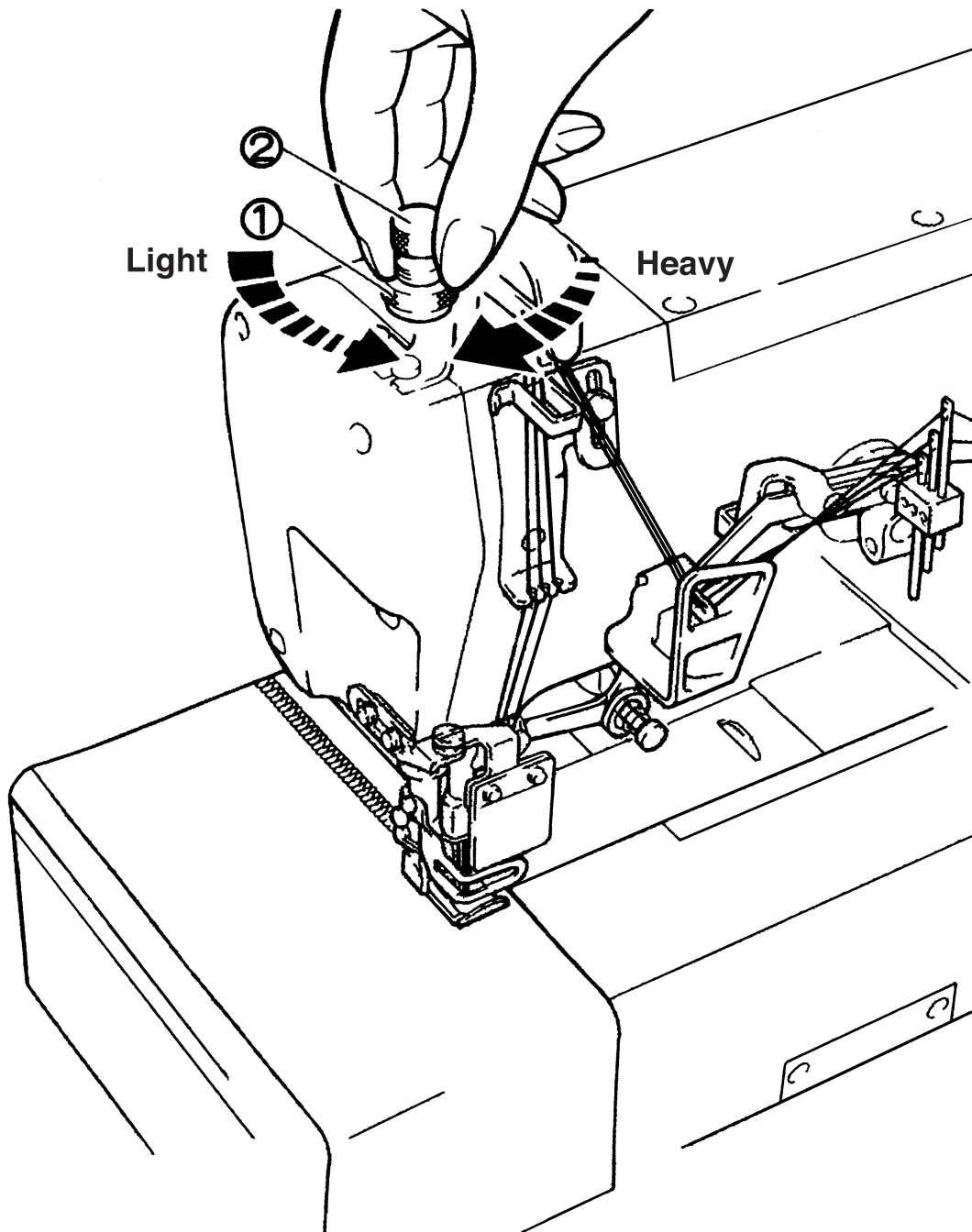
Threading (2)



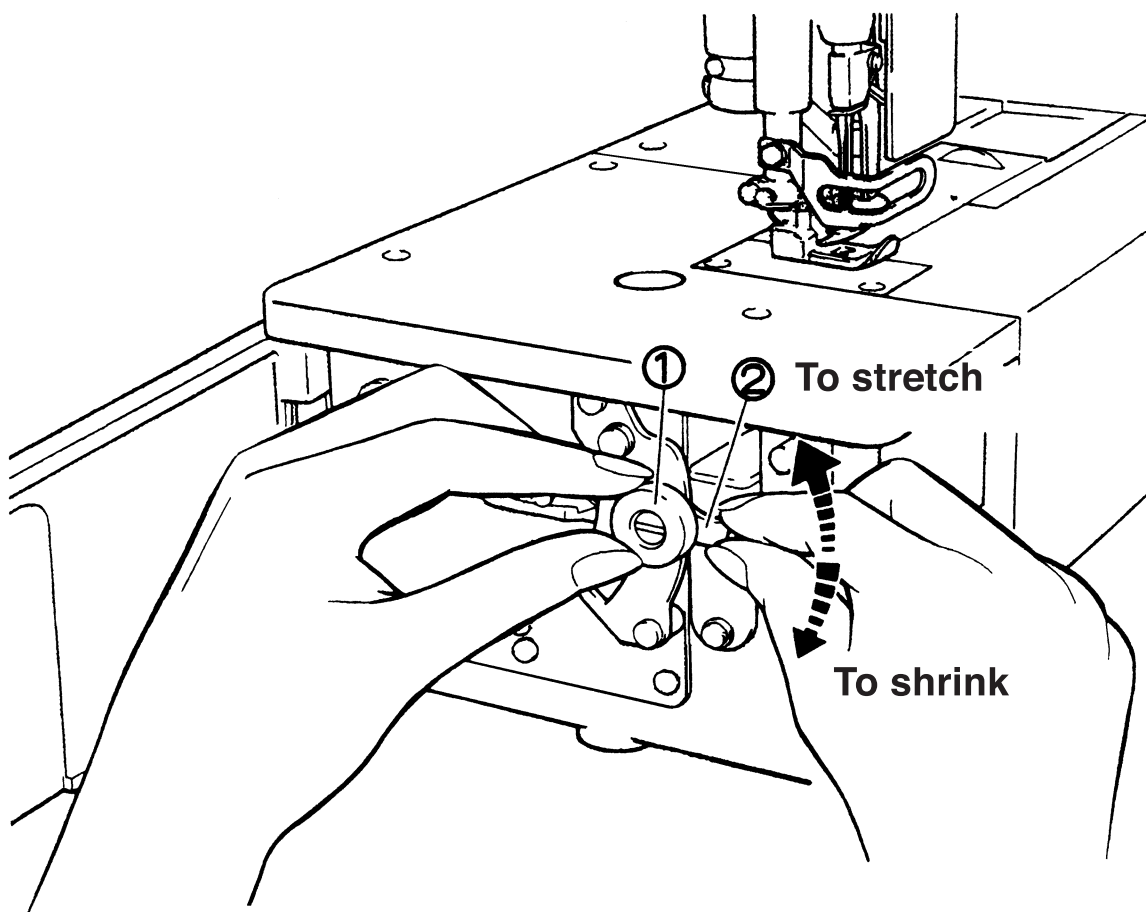
Solid lines
for ordinary thread



Loosen adjusting nut (1) and turn adjusting screw (2) to adjust the presser foot pressure. It should be as light as possible, yet be sufficient to obtain the proper stitch formation.



Loosen nut (1) and move the lever up (2) and down to obtain the correct differential feed ratio. then tighten nut (1).

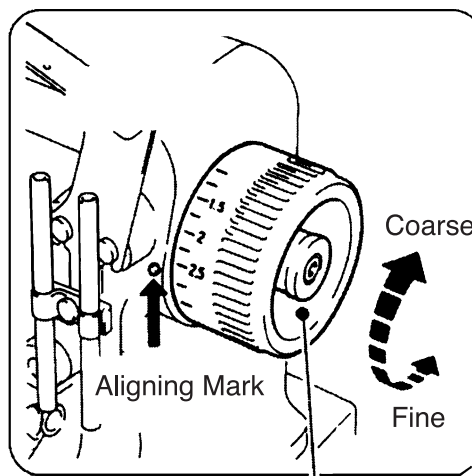


TEST SEWING

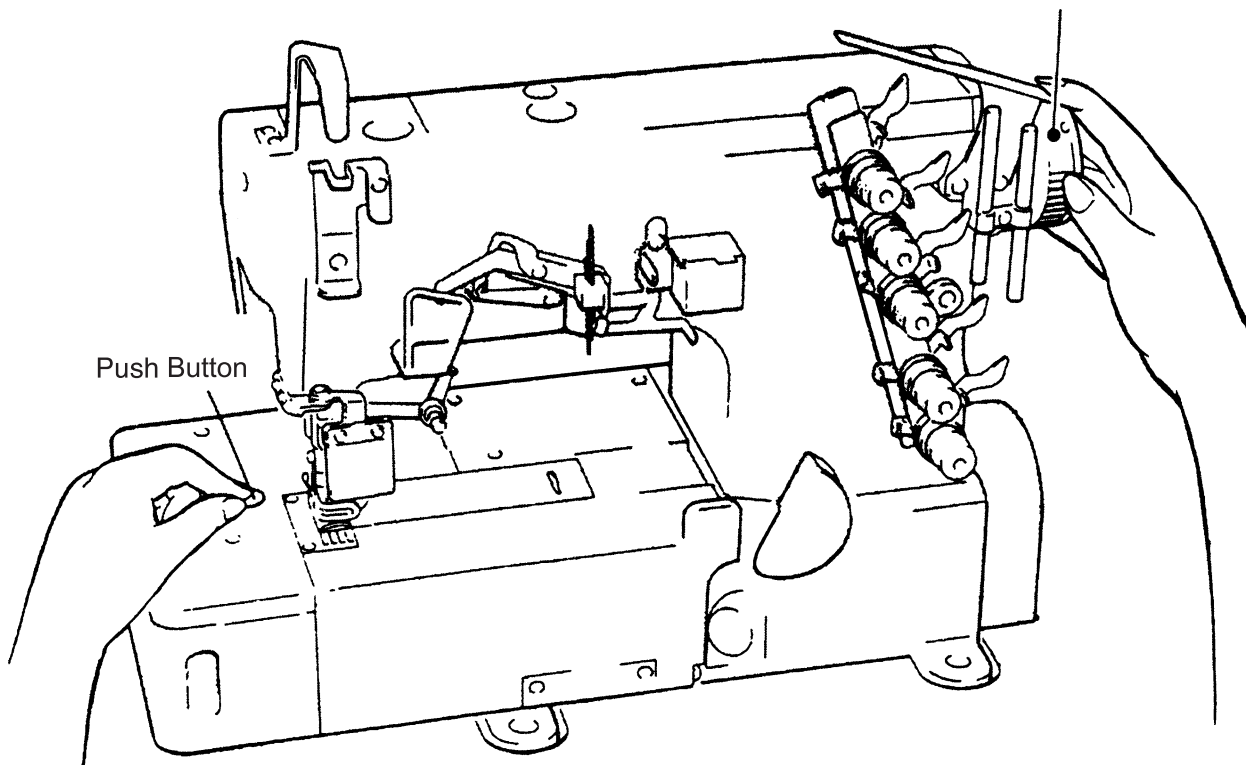
Stitch length adjustment

While pressing the push button, turn the handwheel to seek the position at which the push button goes further into the depth. Then, keeping the push button pressed, turn the handwheel and set the desired scale to the aligning mark.

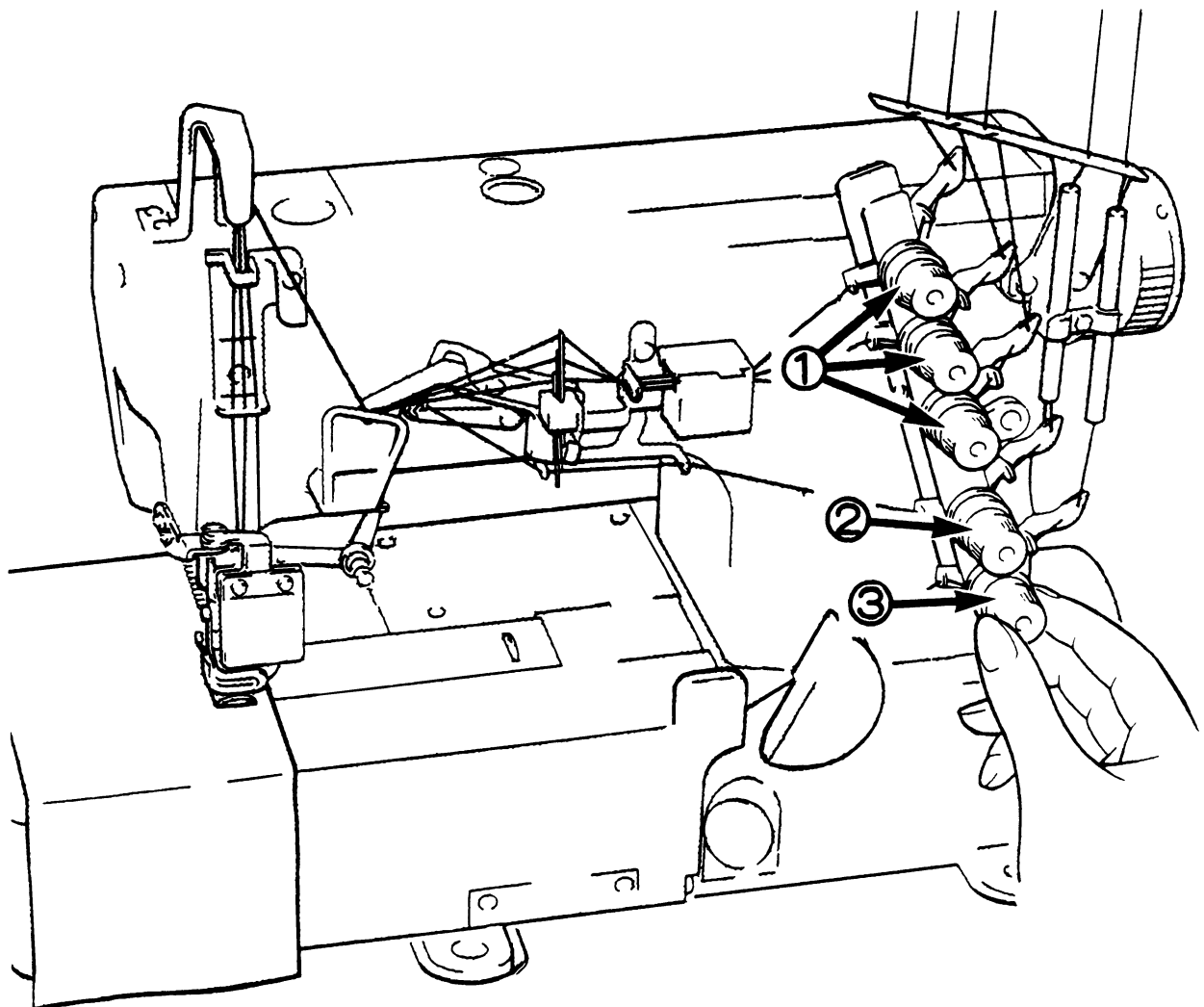
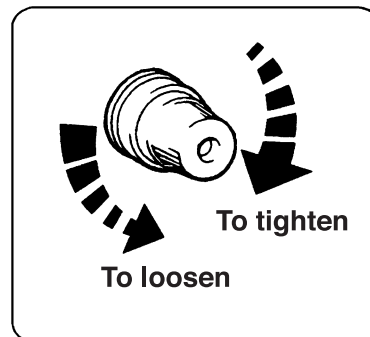
Important Note: Stitch length adjustment must only be made after the differential feed ratio has been changed.



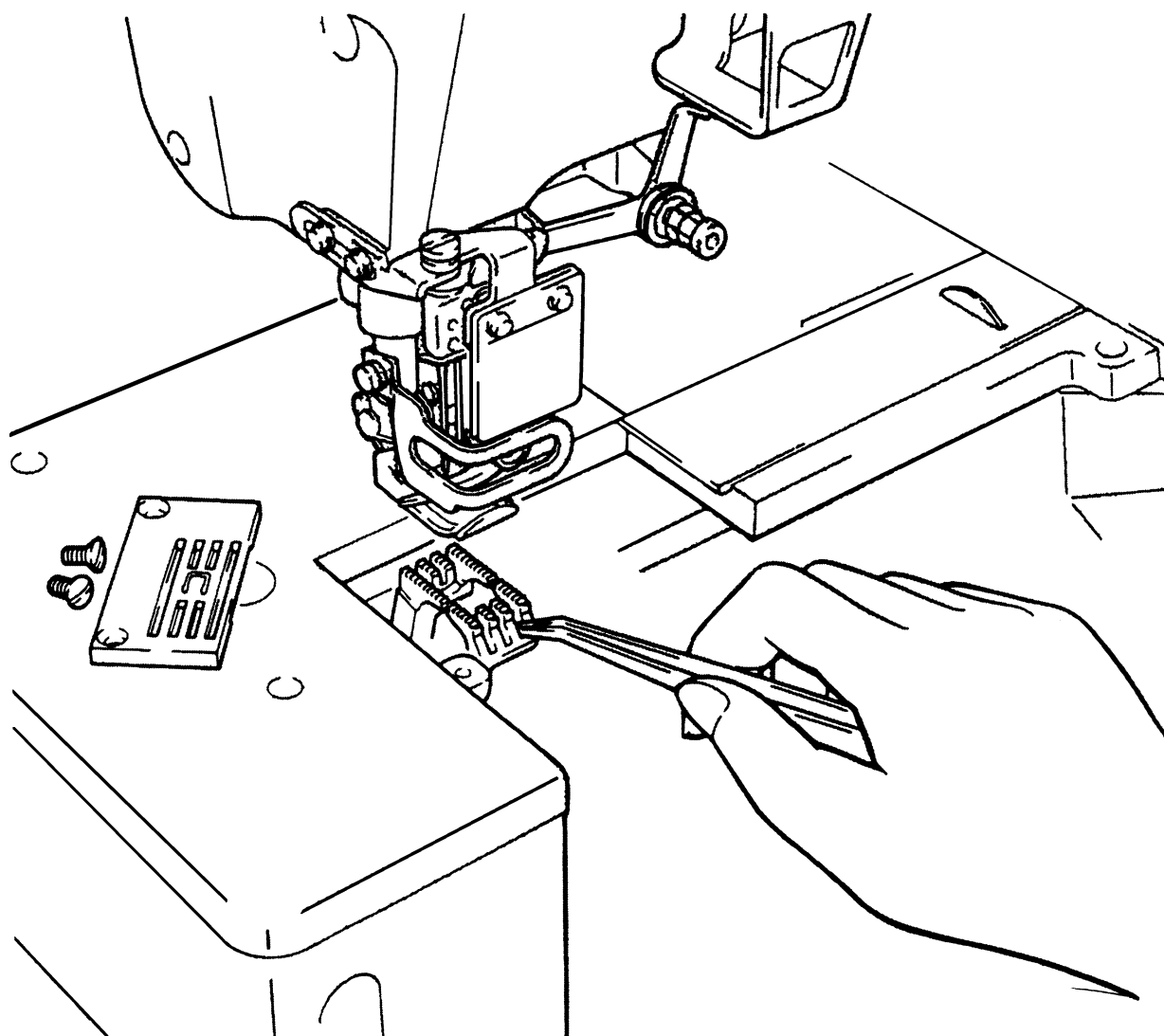
Handwheel

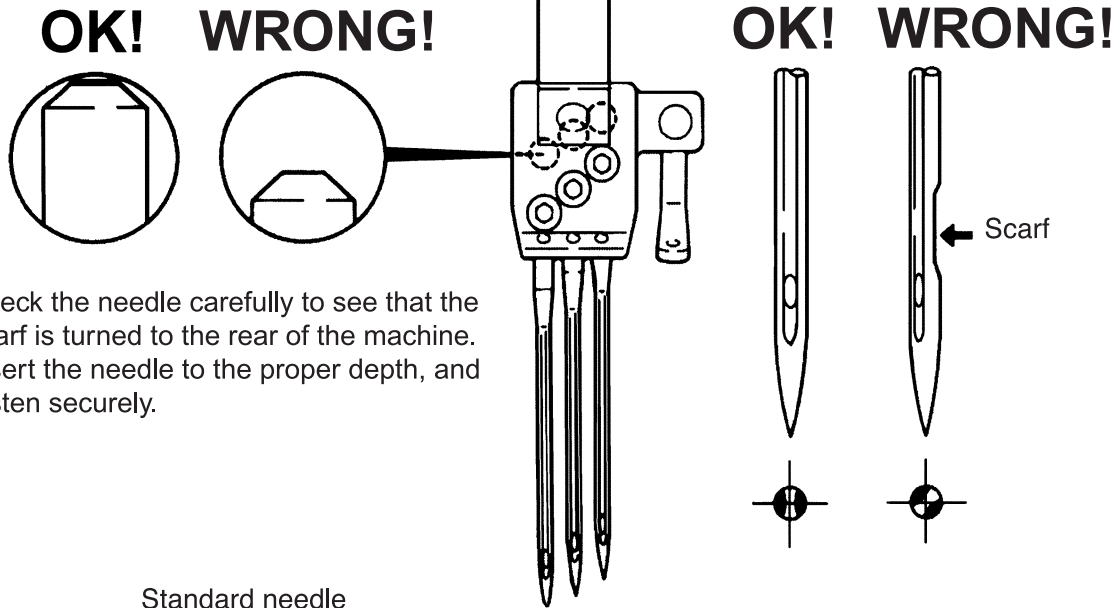


Make tension adjustments with the needle thread knob (1), top cover thread knob (2), and looper thread knob (3).



Mainly the slots of the needle plate and the feed rows should be cleaned.

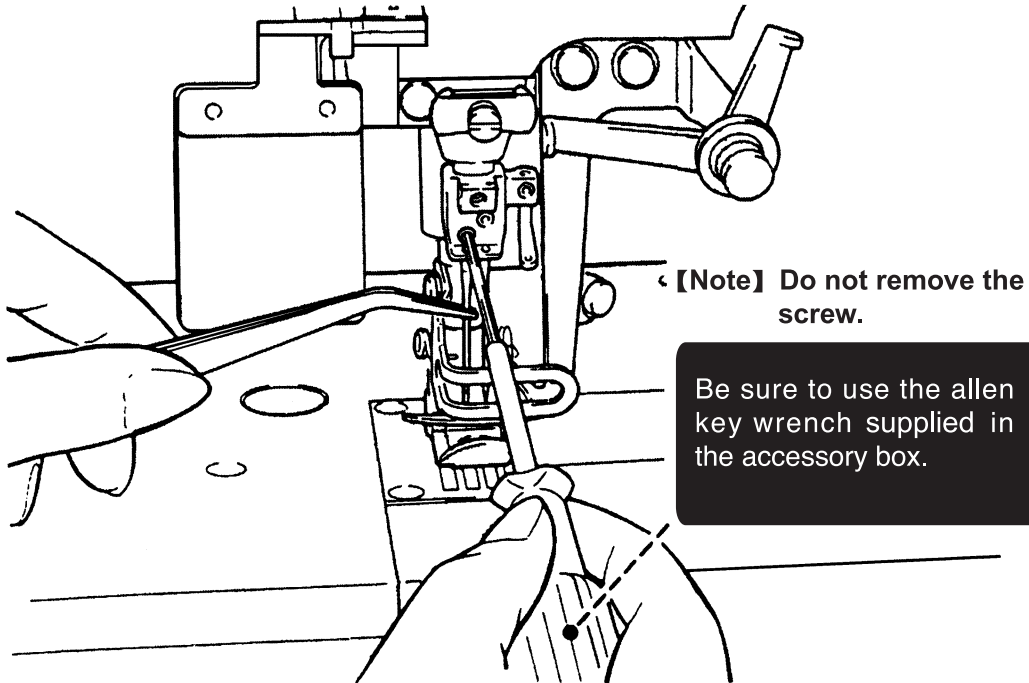


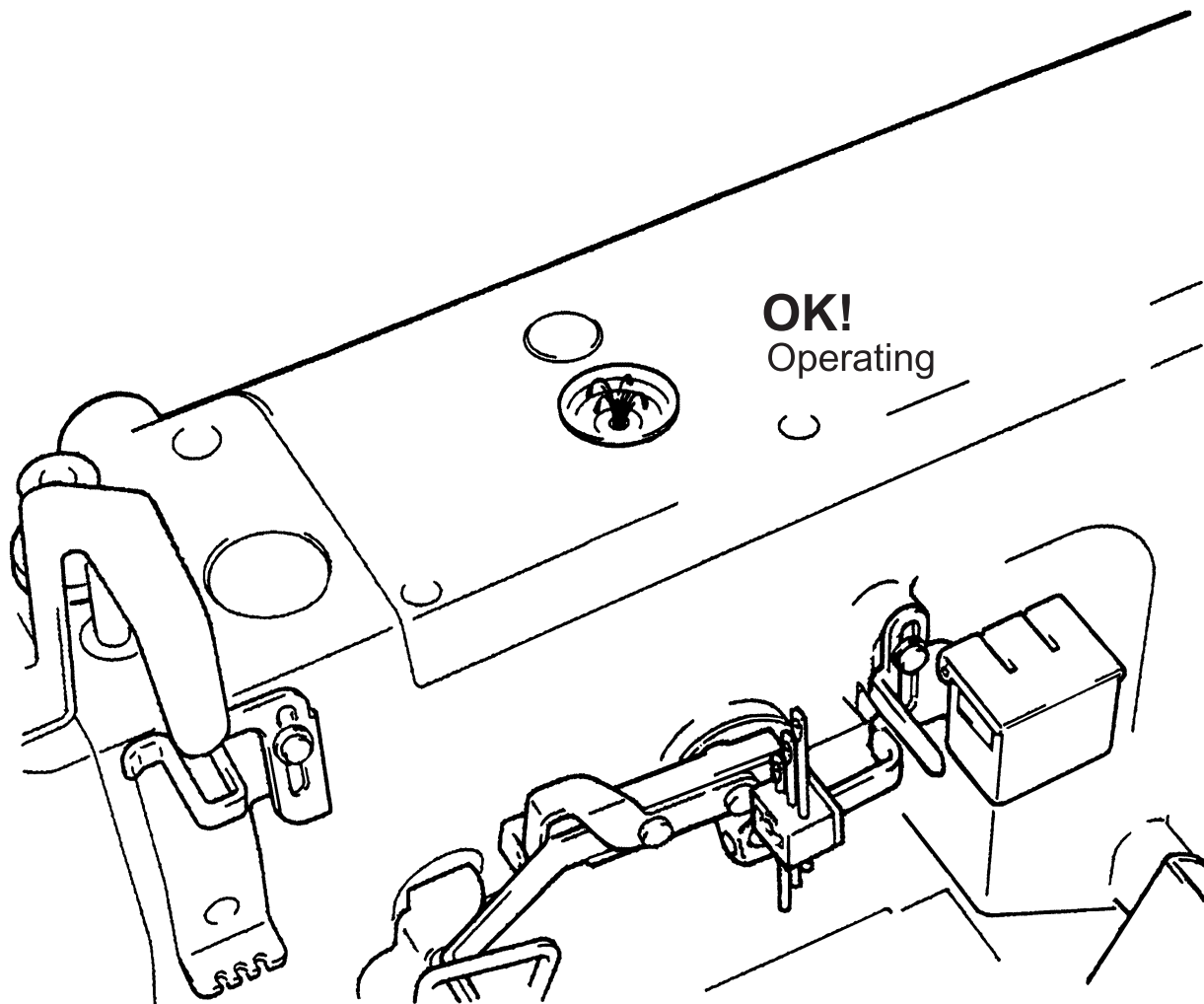


*Check the needle carefully to see that the scarf is turned to the rear of the machine.
*Insert the needle to the proper depth, and fasten securely.

Standard needle

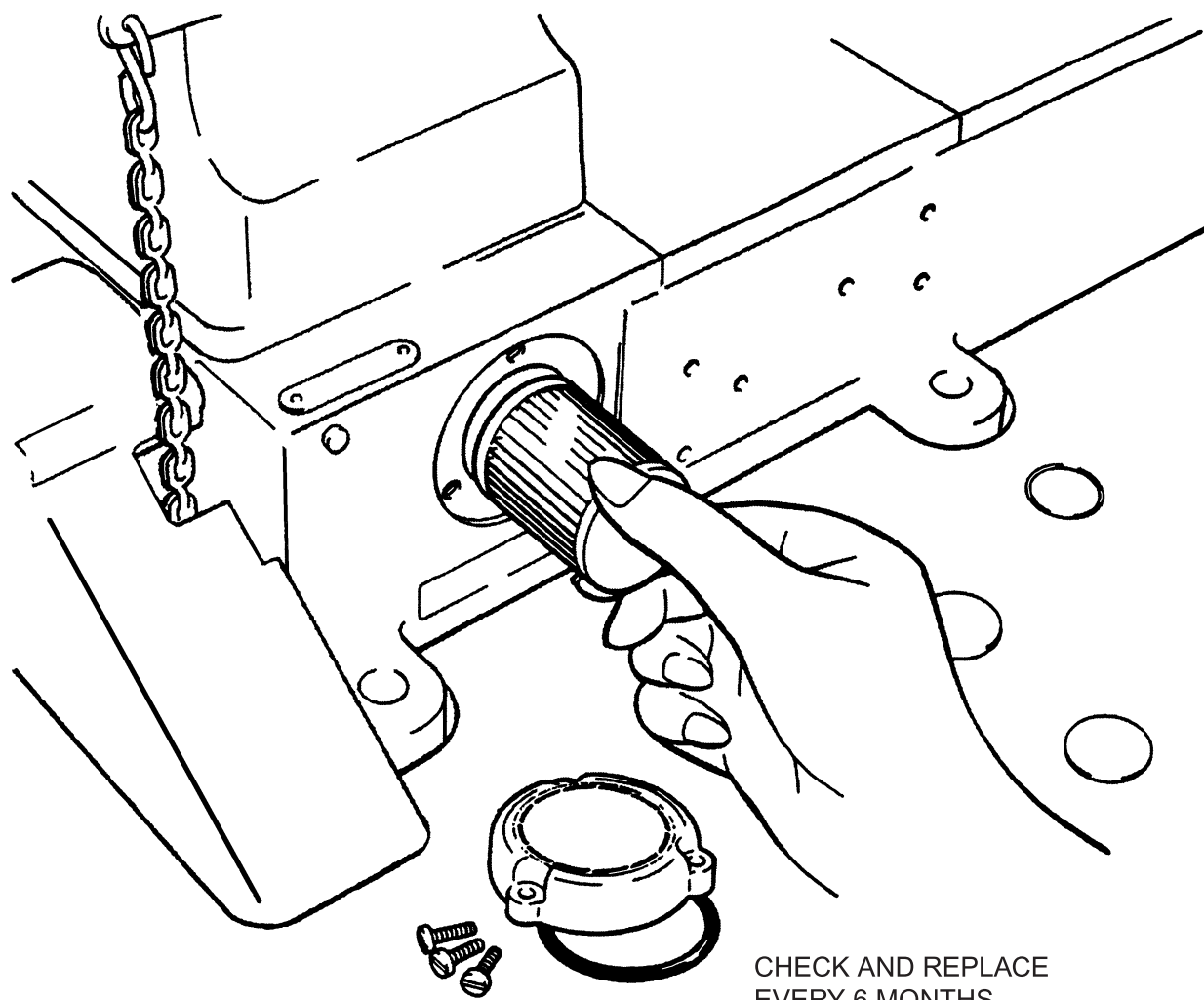
| | NEEDLE SIZE | |
|------------------------|-------------|----------|
| | 2-needle | 3-needle |
| Needle Cat No. 3651-06 | # 9 | # 10 |





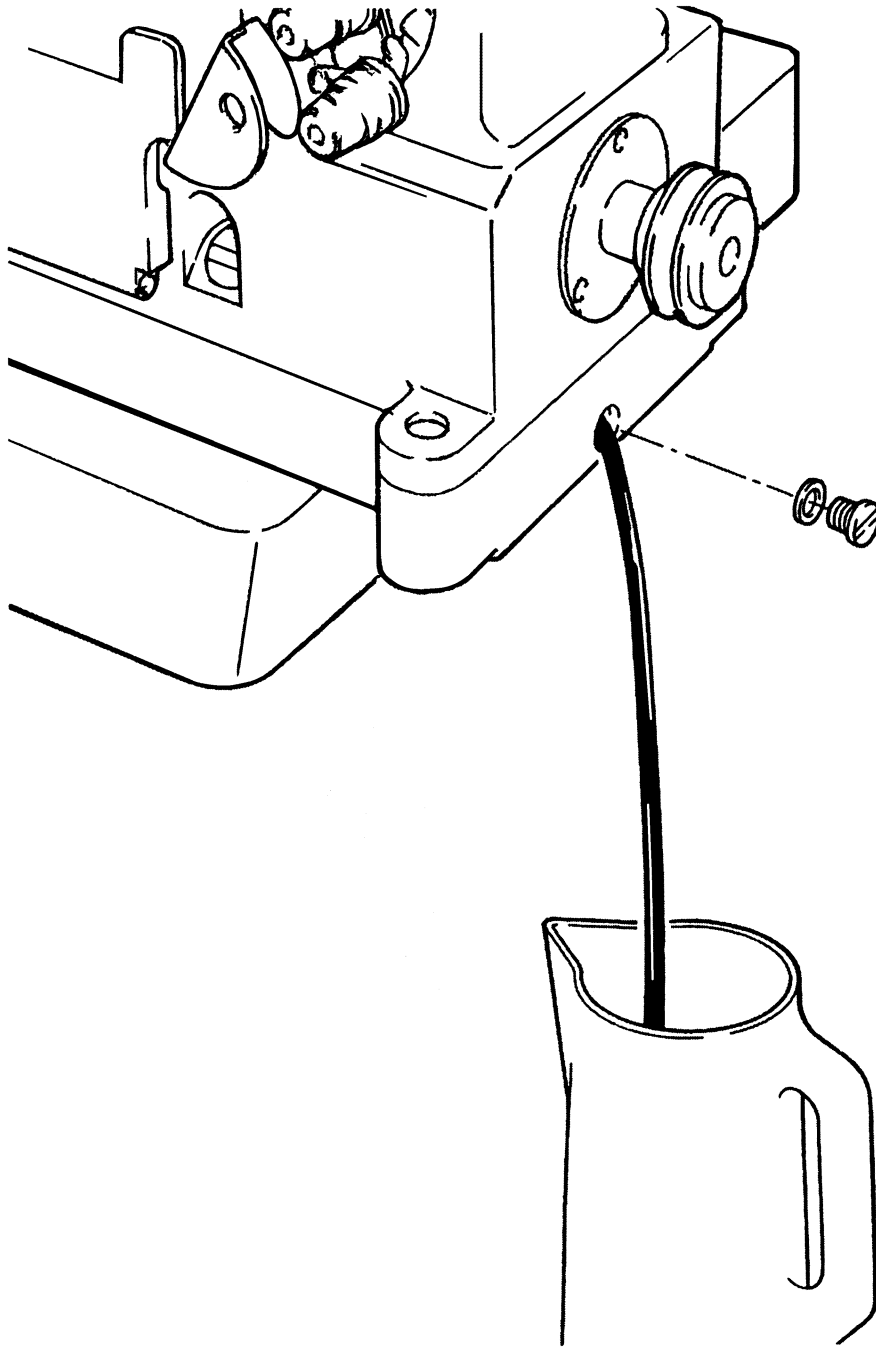
Checking and replacing the oil filter

Check and replace the oil filter every six months.



NOTE: On machines fit with a UT Device, remove the solenoid bracket.

Replace the oil one month after the first use and every six months thereafter.

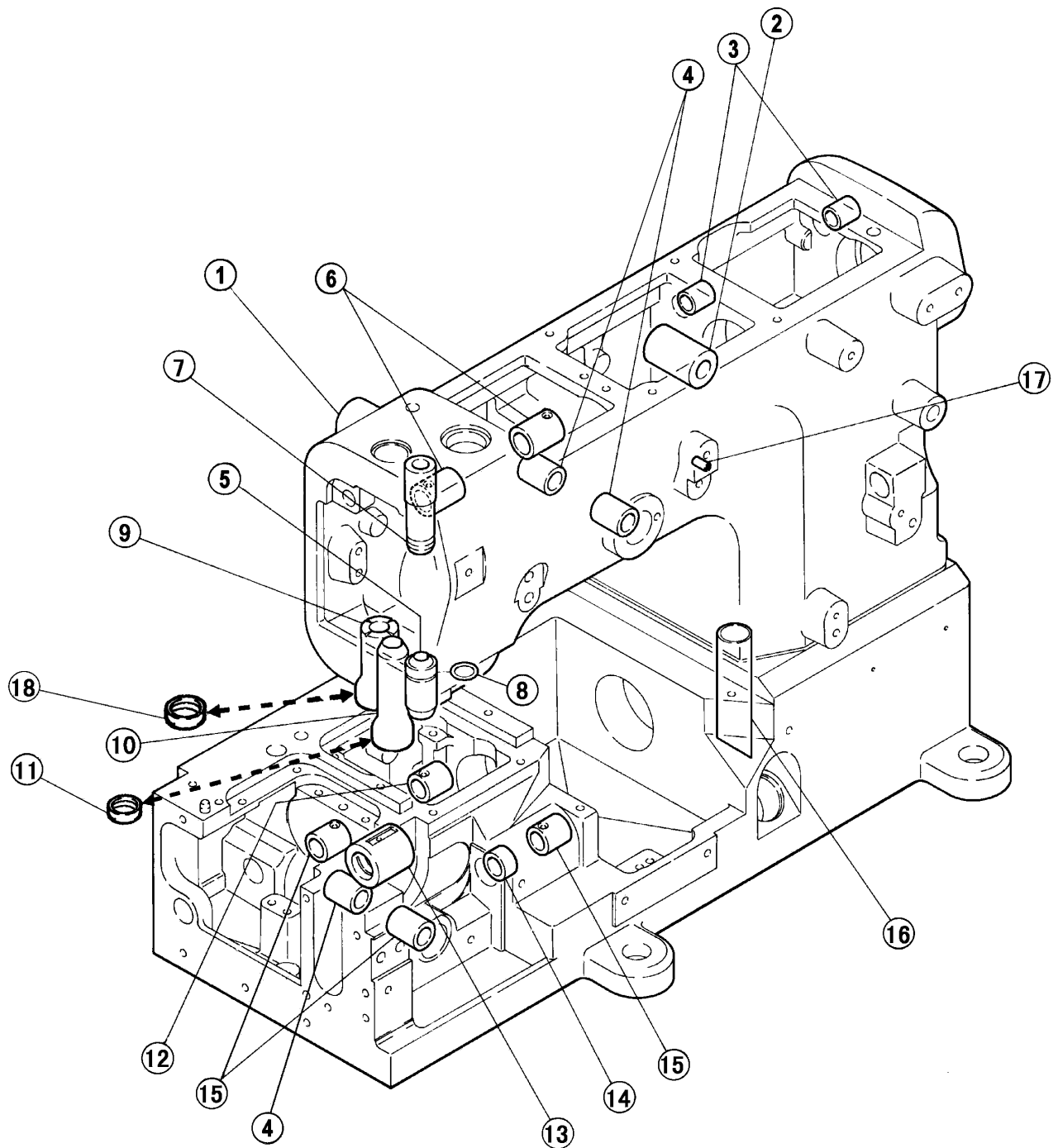


2754A Adjustment Dimensions (mm)

| Three-needle | 048M | 9.4 | 3.6~3.9 | 8.3~8.7 | 8.3~8.7 | 4.5~5.0 | 17.0 | 0.8~1.2 | |
|--------------|------|-----|---------|---------|---------|---------|------|---------|--|
| | 056M | 8.5 | 8.3~8.7 | 8.3~8.7 | 8.3~8.7 | 4.5~5.0 | 17.0 | 0.8~1.2 | |
| | 064M | 8.1 | 2.8~3.1 | 8.3~8.7 | 8.3~8.7 | 4.5~5.0 | 17.0 | 0.8~1.2 | |

ILLUSTRATED PARTS LIST

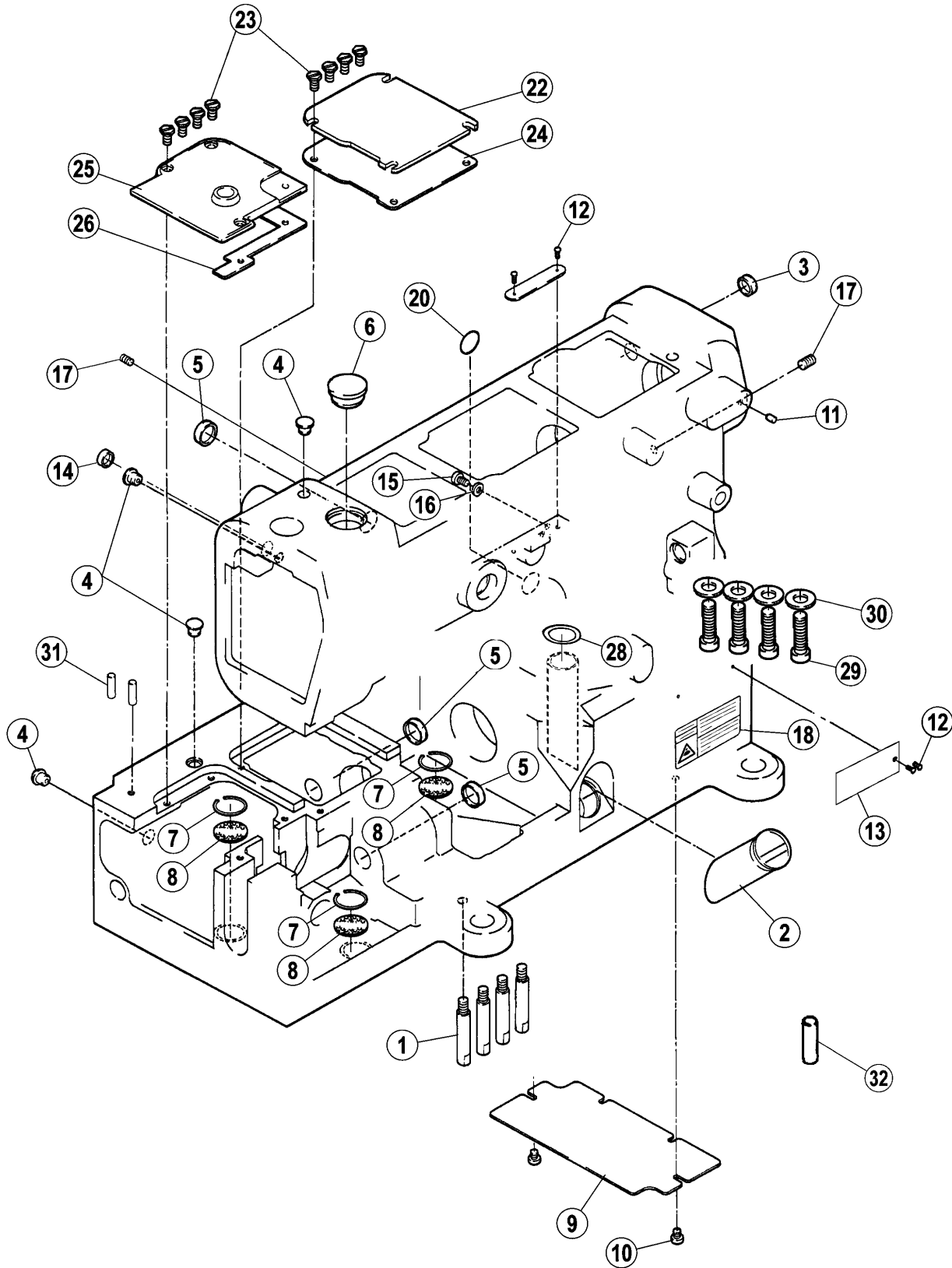
1. Bushing Components



1. Bushing Components

| No. | Parts No. | Description | QTY |
|-----|-----------|---------------|-----|
| 1 | 30101003 | machine frame | 1 |
| 2 | 30103036 | bushing | 1 |
| 3 | 30103037 | bushing | 2 |
| 4 | 30103042 | bushing | 3 |
| 5 | 30103018 | bushing | 1 |
| 6 | 30103039 | bushing | 2 |
| 7 | 30103017 | bushing | 1 |
| 8 | 001039 | o ring | 1 |
| 9 | 30103038 | bushing | 1 |
| 10 | 30103035 | bushing | 1 |
| 11 | 30122039 | plug | 1 |
| 12 | 30103021 | bushing | 1 |
| 13 | 30103010 | bushing | 1 |
| 14 | 30103019 | bushing | 1 |
| 15 | 20103014 | bushing | 3 |
| 16 | 30121001 | pipe | 1 |
| 17 | P03005 | pin | 1 |
| 18 | 20622019 | plug | 1 |

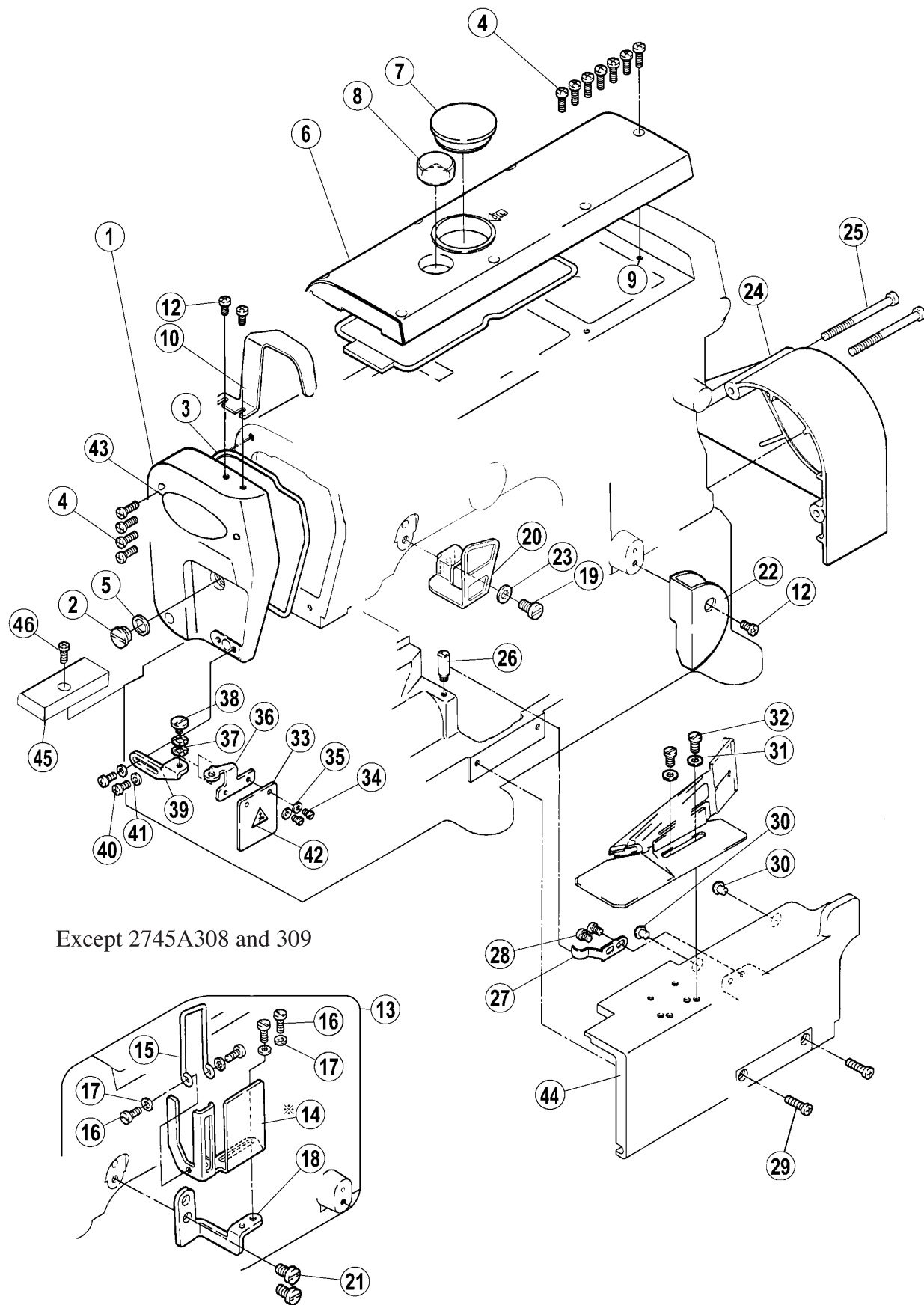
2. Frame Components



2. Frame Components

| No. | Parts No. | Description | QTY |
|-----|-------------|-------------------------|-----|
| 1 | 301S30001 | shoulder pin | 4 |
| 2 | 30111001 | oil level gauge | 1 |
| 3 | 30122004 | plug | 1 |
| 4 | 30122006 | plug | 4 |
| 5 | 30122008 | plug | 3 |
| 6 | 30122005 | plug | 1 |
| 7 | H01001 | ring 18 | 3 |
| 8 | 30112001 | filter | 3 |
| 9 | 30112002 | cover | 1 |
| 10 | S01002 | screw M4x6,5 | 2 |
| 11 | 30122010 | mark | 1 |
| 12 | R03001 | pin 2.5x4 | 4 |
| 13 | J900111-xxx | sticker | 1 |
| 14 | 30122007 | plug | 1 |
| 15 | S01004 | screw M4x7.8 | 1 |
| 16 | W01001 | washer4 | 1 |
| 17 | S12004 | screw M6x10 | 2 |
| 18 | 20131063 | sticker | 1 |
| 20 | 30122036 | sticker | 1 |
| 22 | 30101005 | top cover plate (right) | 1 |
| 23 | L02001 | screw M4x8 | 8 |
| 24 | 30122003 | gasket | 1 |
| 25 | 30101004 | top cover plate (left) | 1 |
| 26 | 30122002 | gasket | 1 |
| 28 | 1001 | o ring 15x2.65 | 1 |
| 29 | S05001 | screw M10x27.5 | 4 |
| 30 | W02003 | washer 10 | 4 |
| 31 | 3022600 | pin | 2 |
| 32 | P02001 | pin | 1 |

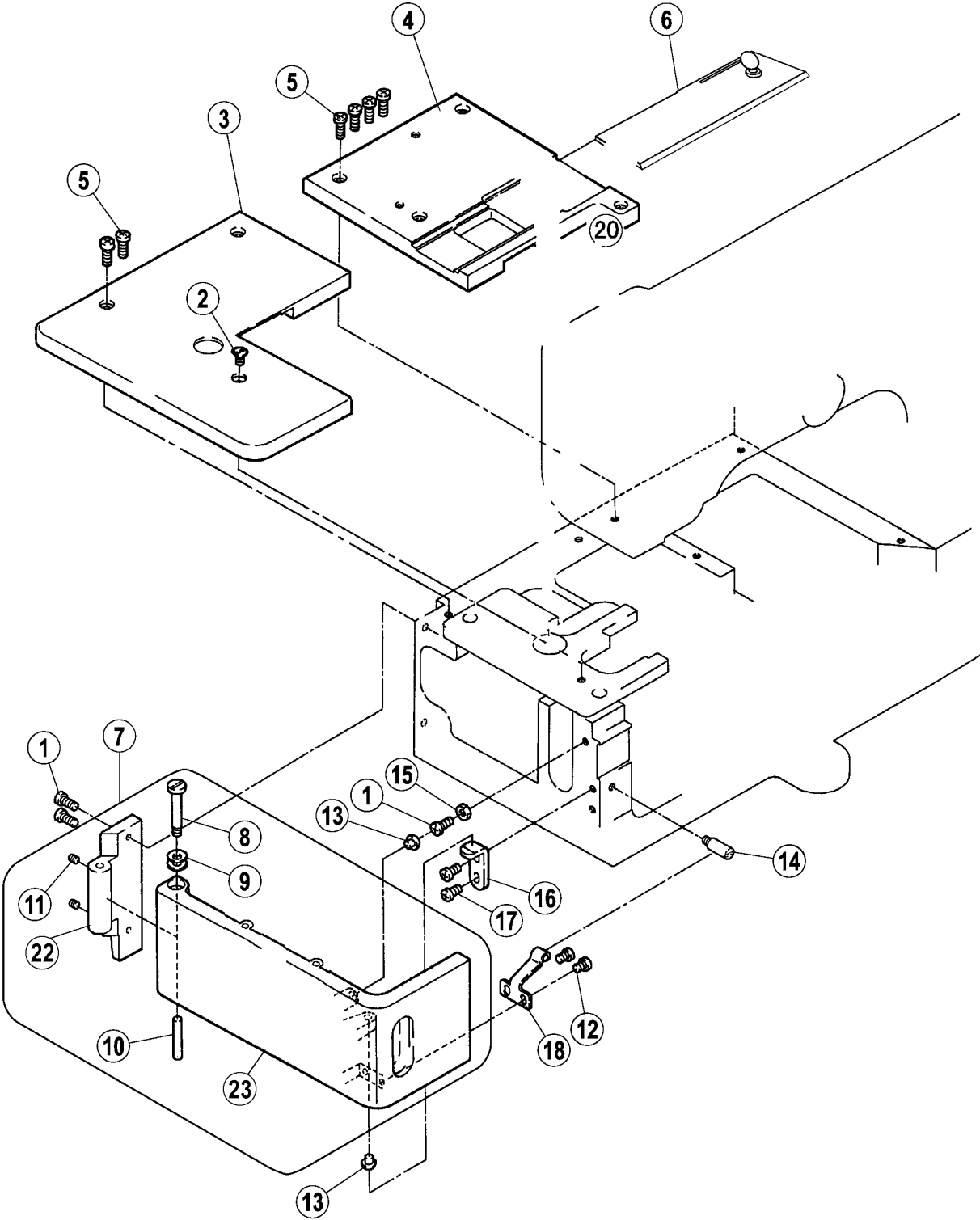
3. Cover Components



3. Cover Components

| No. | Parts No. | Description | QTY |
|-----|------------|-------------------------------|-----|
| 1 | 30101072 | arm cover (left) | 1 |
| 2 | 301S11001 | screw | 1 |
| 3 | 30122014 | o ring | 1 |
| 4 | S01003 | screw M4x12 | 1 |
| 5 | 3012801 | washer | 1 |
| 6 | 30101006 | arm cover(top) | 1 |
| 7 | 30122012 | plug | 1 |
| 8 | 20711002 | sight window | 1 |
| 9 | 30122013 | o ring | 1 |
| 10 | 30112003 | needle bar cover | 1 |
| 12 | S01004 | screw M4x78 | 3 |
| 13 | 3011208300 | thread take-up guard assembly | 1 |
| 14 | 30112083 | thread take-up guard | 1 |
| 15 | 30112084 | finger guard | 1 |
| 16 | S01001 | screw | 1 |
| 17 | W01001 | washer 4 | 3 |
| 18 | 30112085 | bracket | 1 |
| 20 | 30112006 | thread take-up cover | 1 |
| 21 | 301S11002 | screw | 2 |
| 22 | 300135 | looper thread guide cover | 1 |
| 23 | W01003 | washer 6 | 1 |
| 24 | 30111004 | pulley cover | 1 |
| 25 | 301S11003 | screw | 2 |
| 26 | 301S30002 | screw | 1 |
| 27 | 30127001 | flat spring | 1 |
| 28 | S01002 | screw M4x65 | 2 |
| 29 | S01007 | screw M4x13.5 | 2 |
| 30 | 30122015 | cushion | 2 |
| 31 | W01004 | washer 5 | 2 |
| 32 | S01011 | screw M5x10 | 2 |
| 33 | 30111003 | eye guard | 1 |
| 34 | S01006 | screw M3x45 | 2 |
| 35 | W01002 | washer 3 | 2 |
| 36 | 30112005 | bracket | 1 |
| 37 | W03001 | washer 6 | 2 |
| 38 | 301S20001 | screw | 1 |
| 39 | 30112004 | bracket | 1 |
| 40 | S01004 | screw M4x78 | 2 |
| 41 | W01001 | washer 4 | 2 |
| 42 | 30137005 | sticker | 1 |
| 43 | 30337001 | sticker | 1 |
| 44 | 300136 | arm cover (top) | 1 |
| 45 | 300657 | bracket | 1 |
| 46 | S01003 | screw M4x12 | 4 |

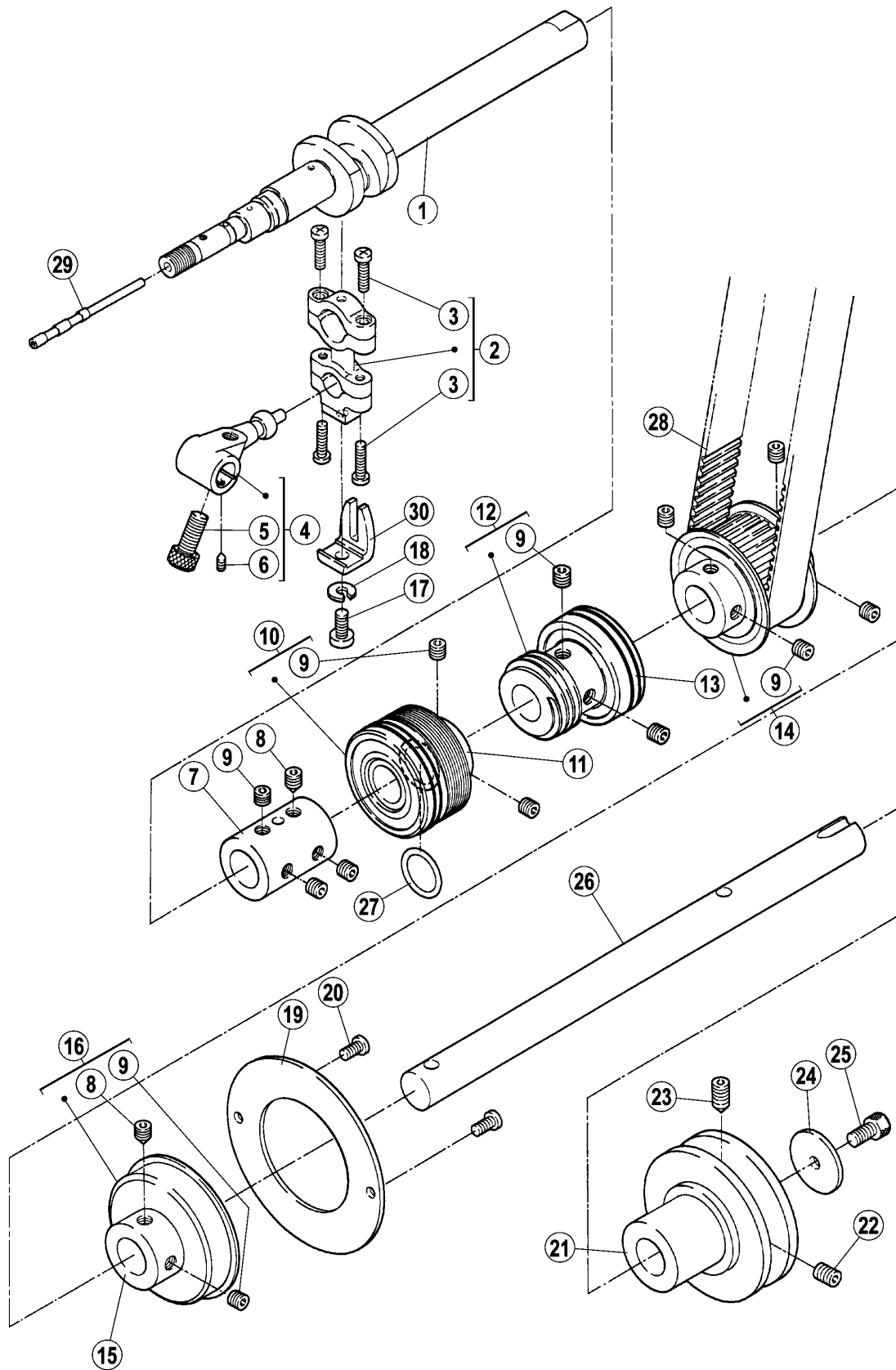
4. Cloth Plate Components



4. Cloth Plate Components

| No. | Parts No. | Description | QTY |
|-----|-----------|---------------------|-----|
| 1 | S01005 | screw M4x10 | 3 |
| 2 | S02001 | screw M4x6 | 1 |
| 3 | 300139 | bed cover(left) | 1 |
| 4 | 300137 | bed cover(right) | 1 |
| 5 | S01003 | screw M4x12 | 6 |
| 6 | 30115001 | cover | 1 |
| 7 | 300138 | side cover assembly | 1 |
| 8 | 301S20004 | screw | 1 |
| 9 | 30128036 | spring | 2 |
| 10 | 301S20005 | pin | 1 |
| 11 | S10001 | screw M3x4 | 2 |
| 12 | S01002 | screw M4x6.5 | 2 |
| 13 | 30122015 | cushion | 2 |
| 14 | 301S30002 | screw | 1 |
| 15 | N01001 | nut M4 | 1 |
| 16 | 30112008 | bracket | 1 |
| 17 | S01004 | screw M4x7.8 | 2 |
| 18 | 30127002 | flat spring | 1 |
| 22 | 30101013 | bracket | 1 |
| 23 | 30111020 | side cover | 1 |

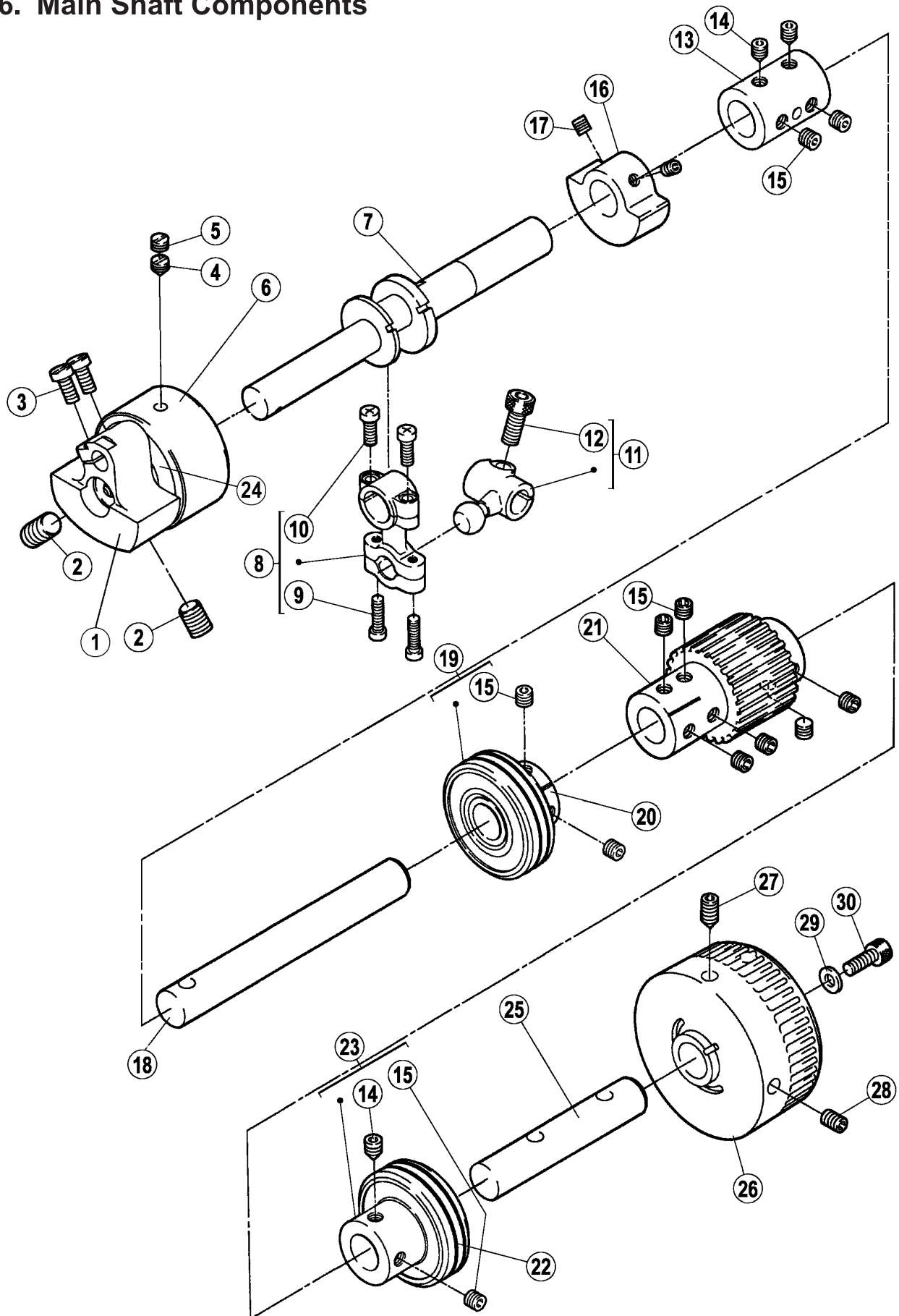
5. Crankshaft Components



5. Crankshaft Components

| No. | Parts No. | Description | QTY |
|-----|------------|--------------------|-----|
| 1 | 30102049 | crankshaft assy | 1 |
| 2 | 3010500100 | connection assy | 1 |
| 3 | S01008 | screw M3.5x13 | 4 |
| 4 | 30104002 | crank | 1 |
| 5 | S05002 | screw M6x0.75x15.2 | 1 |
| 6 | S12002 | screw M3x4 | 1 |
| 7 | 30103004 | joint | 1 |
| 8 | S12003 | screw M6x7 | 2 |
| 9 | S10003 | screw Mx0.75x5 | 12 |
| 10 | 3012400300 | beating | 1 |
| 11 | 30103006 | bushing | 1 |
| 12 | 30103008 | bushing | 1 |
| 13 | 3012400400 | bearing | 1 |
| 14 | 30125001 | gear (lower) | 1 |
| 15 | 30103009 | bushing | 1 |
| 16 | B01003 | bearing 6304z | 1 |
| 17 | 301S11004 | screw | 1 |
| 18 | W02001 | washer 5 | 1 |
| 19 | 30108001 | cover | 1 |
| 20 | S01004 | screw M4x7.8 | 2 |
| 21 | 30101015 | machine pulley | 1 |
| 22 | S10009 | screw M6x8 | 1 |
| 23 | S12001 | screw M6x8 | 1 |
| 24 | 30128005 | washer | 1 |
| 25 | S05003 | screw M5x10 | 1 |
| 26 | 30102003 | shaft | 1 |
| 27 | 001001 | o ring 15x2.65 | 1 |
| 28 | 30135002 | timing belt | 1 |
| 29 | 30126001 | adjusting bar | 1 |
| 30 | 30109001 | guide | 1 |

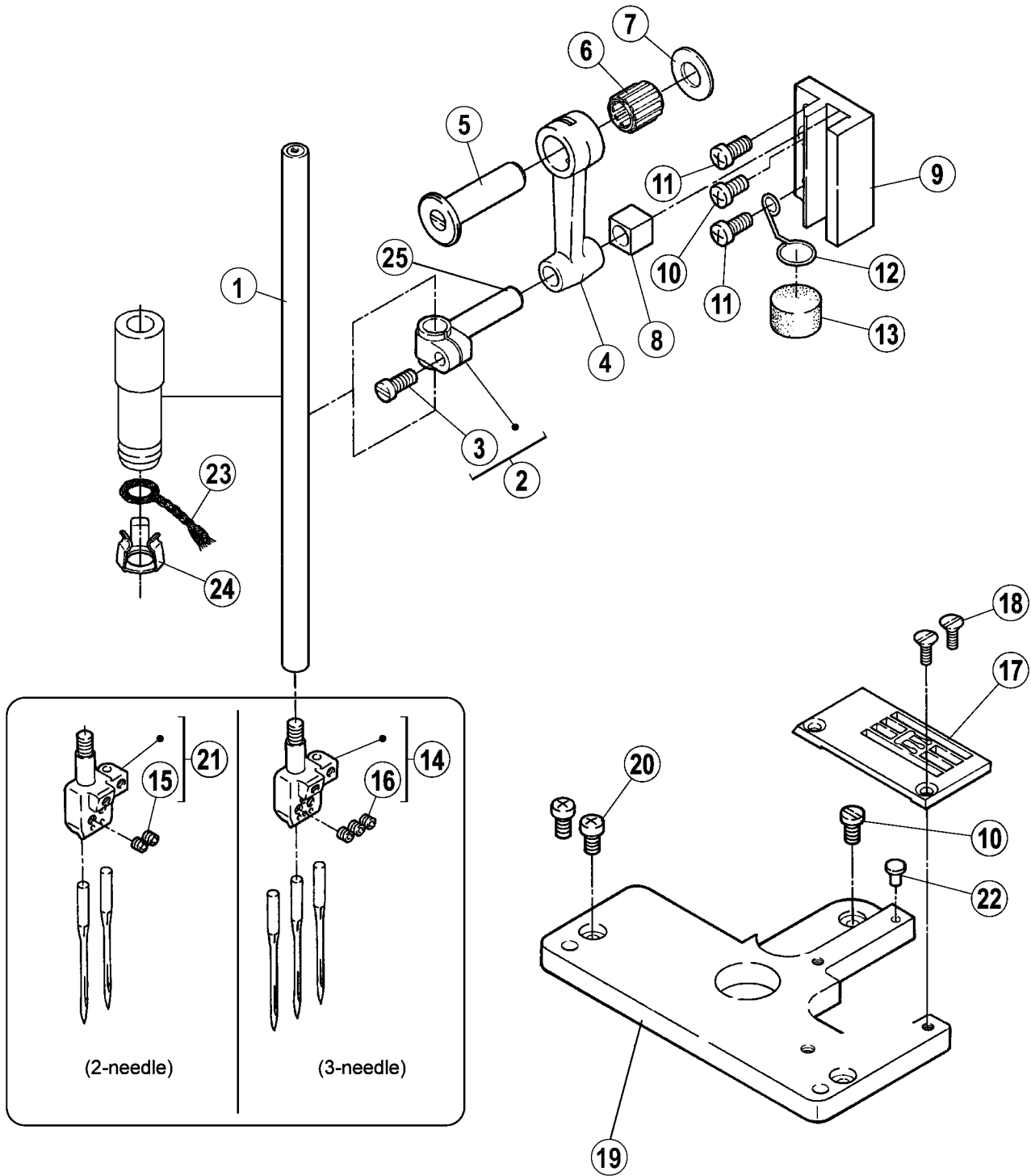
6. Main Shaft Components



6. Main Shaft Components

| No. | Parts No. | Description | QTY |
|-----|------------|--------------------|-----|
| 1 | 30104004 | motion assy | 1 |
| 2 | S1130114 | screw M8x1x2 | 2 |
| 3 | S01011 | screw M5x10 | 2 |
| 4 | S08001 | screw M6x0.75x3.5 | 1 |
| 5 | S11001 | screw M6x0.75x6 | 1 |
| 6 | 30103015 | bushing | 1 |
| 7 | 30102005 | crankshaft | 1 |
| 8 | 3010500300 | connection assy | 1 |
| 9 | S01003 | screw M4x12 | 2 |
| 10 | S01008 | screw M3.5x13 | 2 |
| 11 | 30104006 | crank assy | 1 |
| 12 | S05002 | screw M6x0.75x15.2 | 1 |
| 13 | 30103004 | joint | 1 |
| 14 | S12003 | screw M6x0.75x15.2 | 3 |
| 15 | S10003 | screw M6x0.75x5 | 11 |
| 16 | 30109003 | balance weight | 1 |
| 17 | S10002 | screw M5x5 | 2 |
| 18 | 30102006 | shaft | 1 |
| 19 | 3012400400 | bushing | 1 |
| 20 | 30103012 | bushing | 1 |
| 21 | 30125002 | gear (upper) | 1 |
| 22 | 3012400400 | bearing | 1 |
| 23 | 30103014 | bushing | 1 |
| 24 | B01005 | bearing | 2 |
| 25 | 30102007 | shaft | 1 |
| 26 | 30101016 | handwheel | 1 |
| 27 | S12001 | screw M6x8 | 1 |
| 28 | S10009 | screw M6x8 | 1 |
| 29 | W01004 | washer 5 | 1 |
| 30 | S05004 | screw M5X14 | 1 |

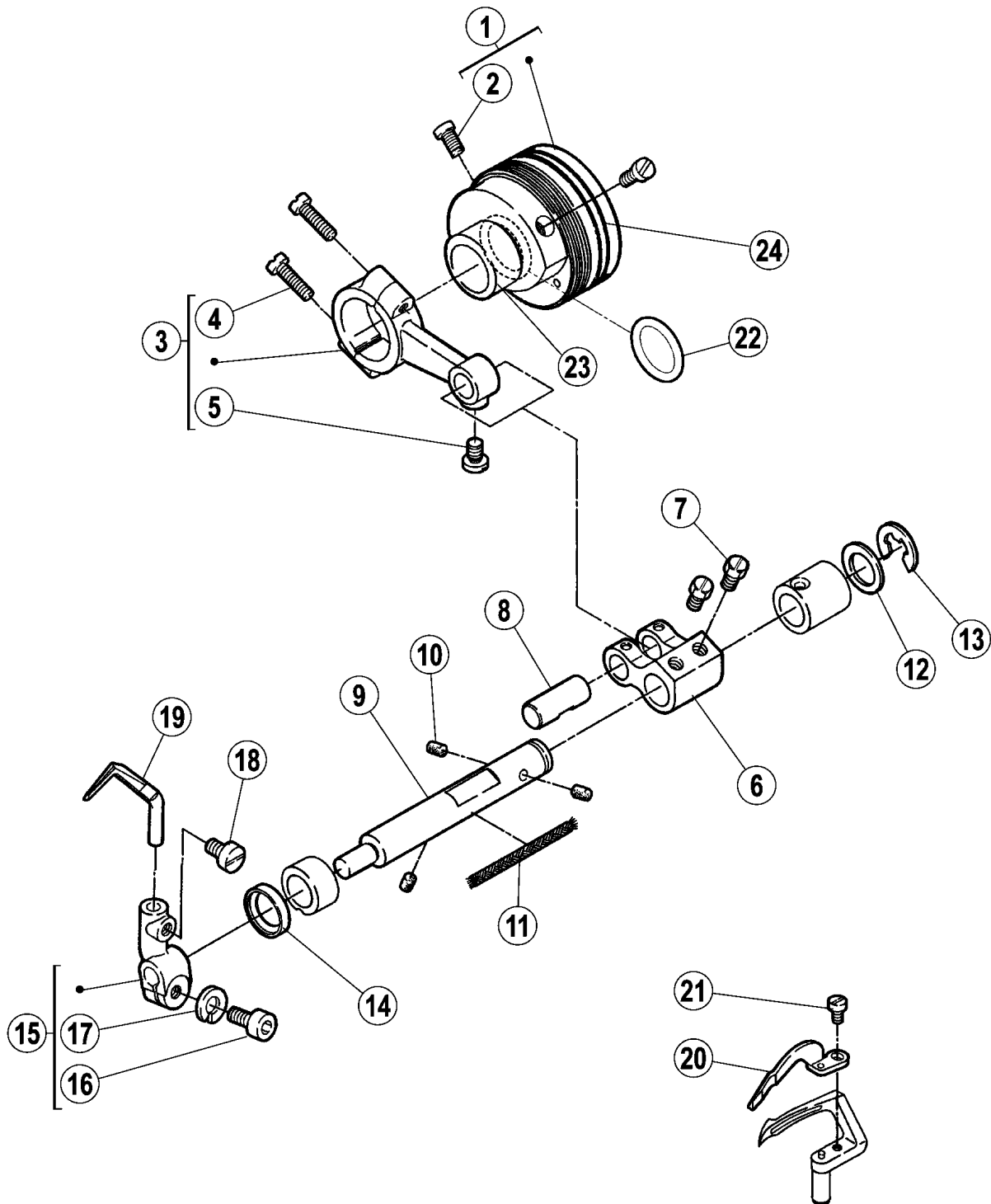
7. Needle Bar Components



7. Needle Bar Components

| No. | Parts No. | Description | QTY |
|-----|-----------|------------------------|-----|
| 1 | 30102008 | needle bar | 1 |
| 3 | 301S11005 | screw | 1 |
| 4 | 30105005 | needle bar drive link | 1 |
| 5 | 30102010 | pin | 1 |
| 6 | B07001 | needle bearing | 1 |
| 7 | 30128006 | washer | 1 |
| 8 | 80109004 | block | 1 |
| 9 | 30109005 | needle bar guide block | 1 |
| 10 | 301S11024 | screw | 2 |
| 11 | S01003 | screw M4x12 | 2 |
| 12 | 30127003 | latch | 1 |
| 13 | 30123002 | sponge | 1 |
| 14 | XXXXXXXXX | needle holder | 1 |
| 15 | S10005 | screw M3x3 | 2 |
| 16 | S10005 | screw M3x3 | 3 |
| 17 | XXXXXXXXX | needle plate | 1 |
| 18 | 301S17001 | screw | 2 |
| 19 | 30109006 | bracket | 1 |
| 20 | S01004 | screw M4x7.8 | 2 |
| 21 | XXXXXXXXX | needle holder | 1 |
| 22 | 30122018 | cushion rubber | 1 |
| 23 | 20523003 | oil wick | 1 |
| 24 | 30112009 | oil wick retainer | 1 |
| 25 | 30102009 | needle bar crank | 1 |

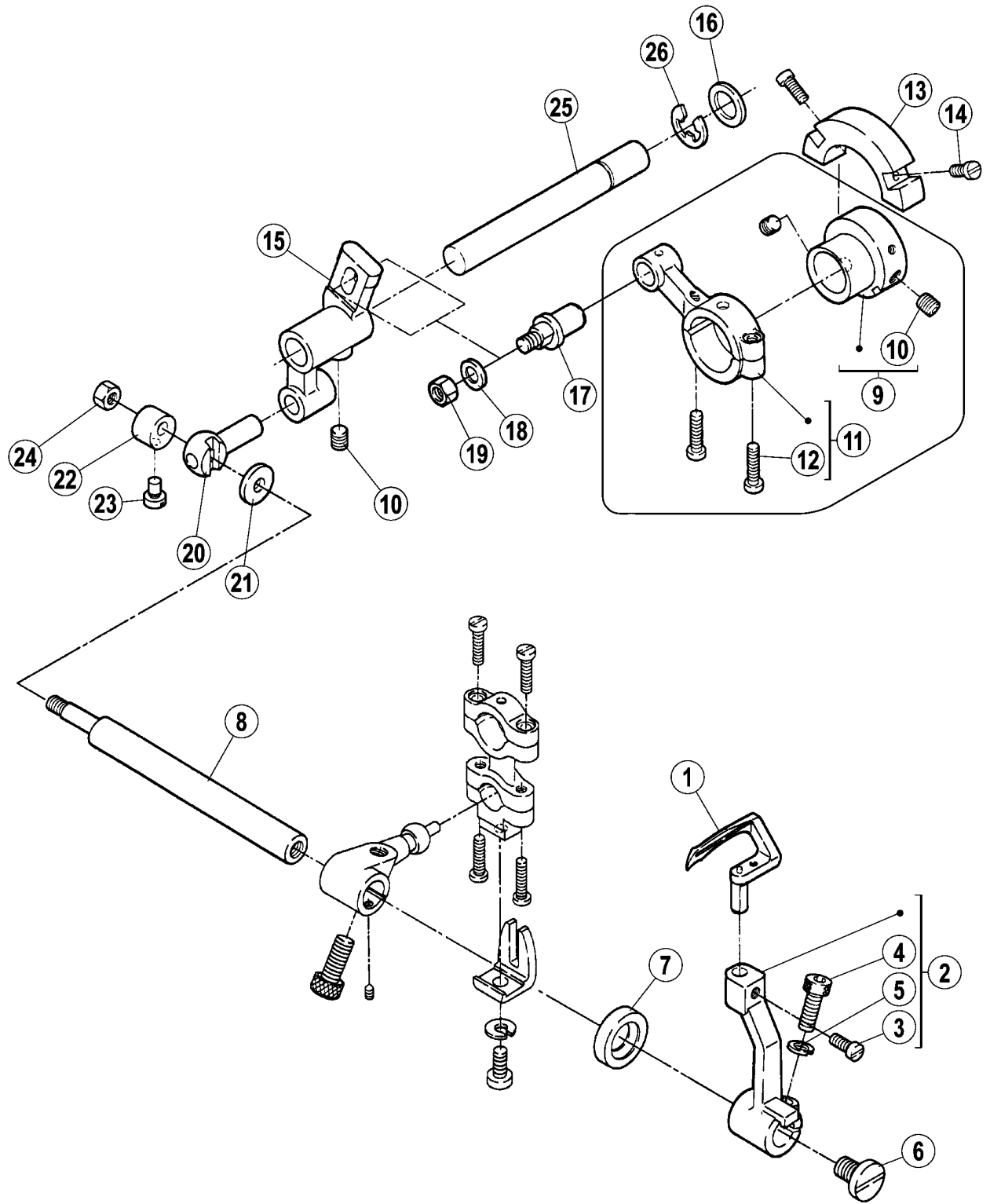
8. Needle Guard Components



8. Needle Guard Components

| No. | Parts No. | Description | QTY |
|-----|------------|----------------------|-----|
| 1 | B01001 | eccentric assy | 1 |
| 2 | S10006 | screw | 2 |
| 3 | 3010500600 | connection assy | 1 |
| 4 | S01008 | screw | 2 |
| 5 | 301811024 | screw | 1 |
| 6 | 30104007 | crank | 1 |
| 7 | 301S12001 | scrcew | 2 |
| 8 | 30126003 | pin | 1 |
| 9 | 30102011 | shaft | 1 |
| 10 | 30123001 | felt | 3 |
| 11 | 20523003 | oil wick | 1 |
| 12 | 30128008 | washer | 1 |
| 13 | H05001 | ring | 1 |
| 14 | 30122019 | oil seal | 1 |
| 15 | 30104009 | lever assy | 1 |
| 16 | S05003 | screw | 1 |
| 17 | W02001 | washer | 1 |
| 18 | S01002 | scow | 1 |
| 19 | 30117002 | needle guard (rear) | 1 |
| 20 | 30117003 | needle guard (front) | 1 |
| 21 | S01012 | screw | 1 |
| 22 | 001001 | o ring | 1 |
| 23 | 30110002 | eccentric | 1 |
| 24 | 30122017 | oil sel | 2 |

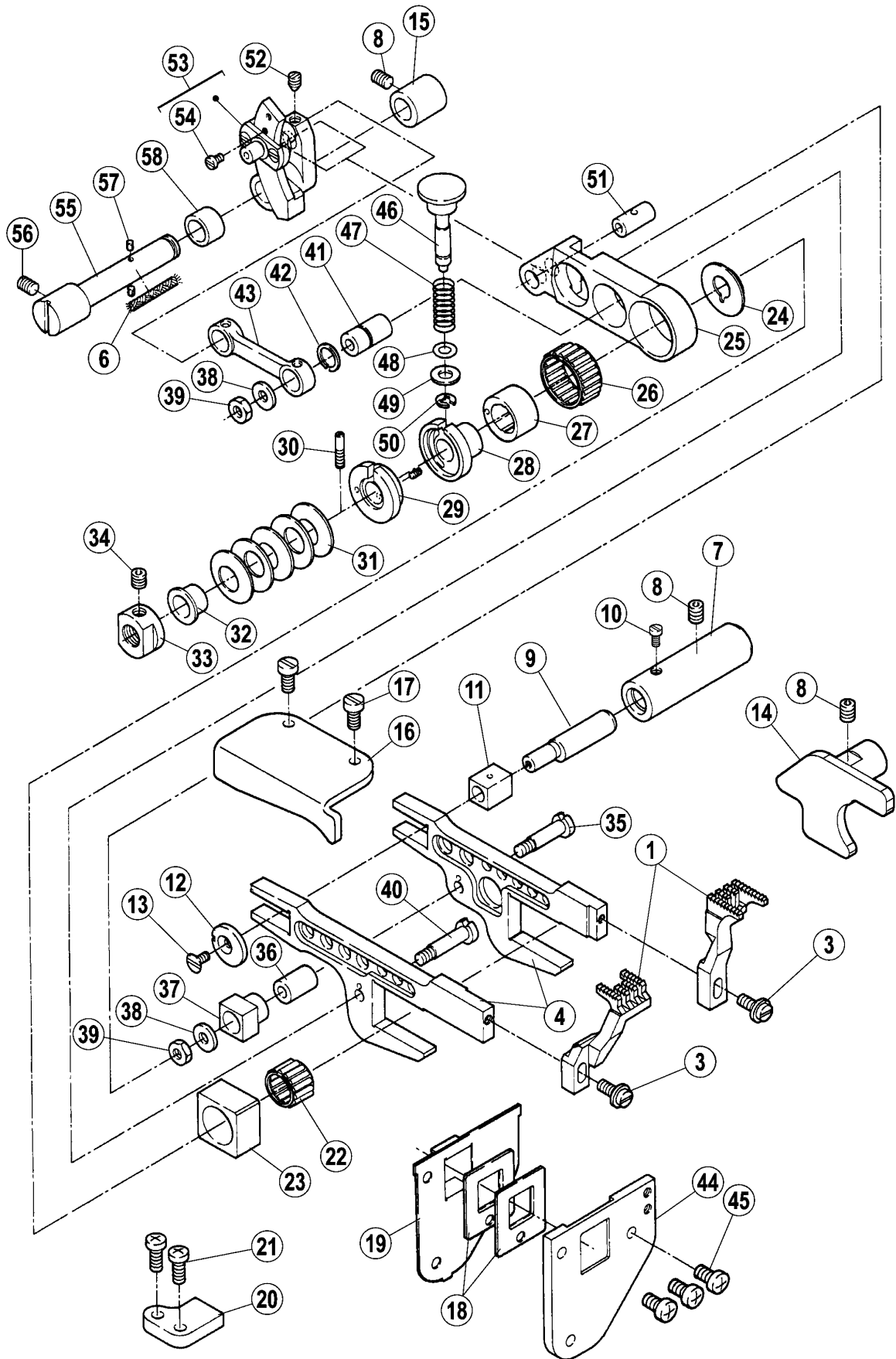
9. Looper Components



9. Looper Components

| No. | Parts No. | Description | QTY |
|-----|-------------|--------------------|-----|
| 1 | 3011700900 | looper | 1 |
| 2 | 30104012 | looper holder assy | 1 |
| 3 | S01004 | screw M4x7.8 | 1 |
| 4 | S05004 | screw M5x14 | 1 |
| 5 | W02001 | spring washer 5 | 1 |
| 6 | S01014 | screw M6x0.75x9.6 | 1 |
| 7 | 20622019 | oil seal | 1 |
| 8 | 30102014 | shaft | 1 |
| 9 | 30110005 | eccentric assy | 1 |
| 10 | S10006 | screw M5x6 | 3 |
| 11 | 31)10500800 | connection assy | 1 |
| 12 | S01008 | screw M3.5x13 | 2 |
| 13 | 30109007 | balance weight | 1 |
| 14 | S01009 | screw M3x7.5 | 2 |
| 15 | 30104010 | crank | 1 |
| 16 | 30128008 | washer | 1 |
| 17 | 30102013 | pin | 1 |
| 18 | 30128032 | washer | 1 |
| 19 | N01002 | nut M5 | 1 |
| 20 | 30102015 | block pin | 1 |
| 21 | 30128010 | washer | 1 |
| 22 | 30108002 | collar | 1 |
| 23 | 301812001 | screw | 1 |
| 24 | N01001 | nut M4 | 2 |
| 25 | 30102012 | shaft | 1 |
| 26 | H05001 | ring 10 | 1 |

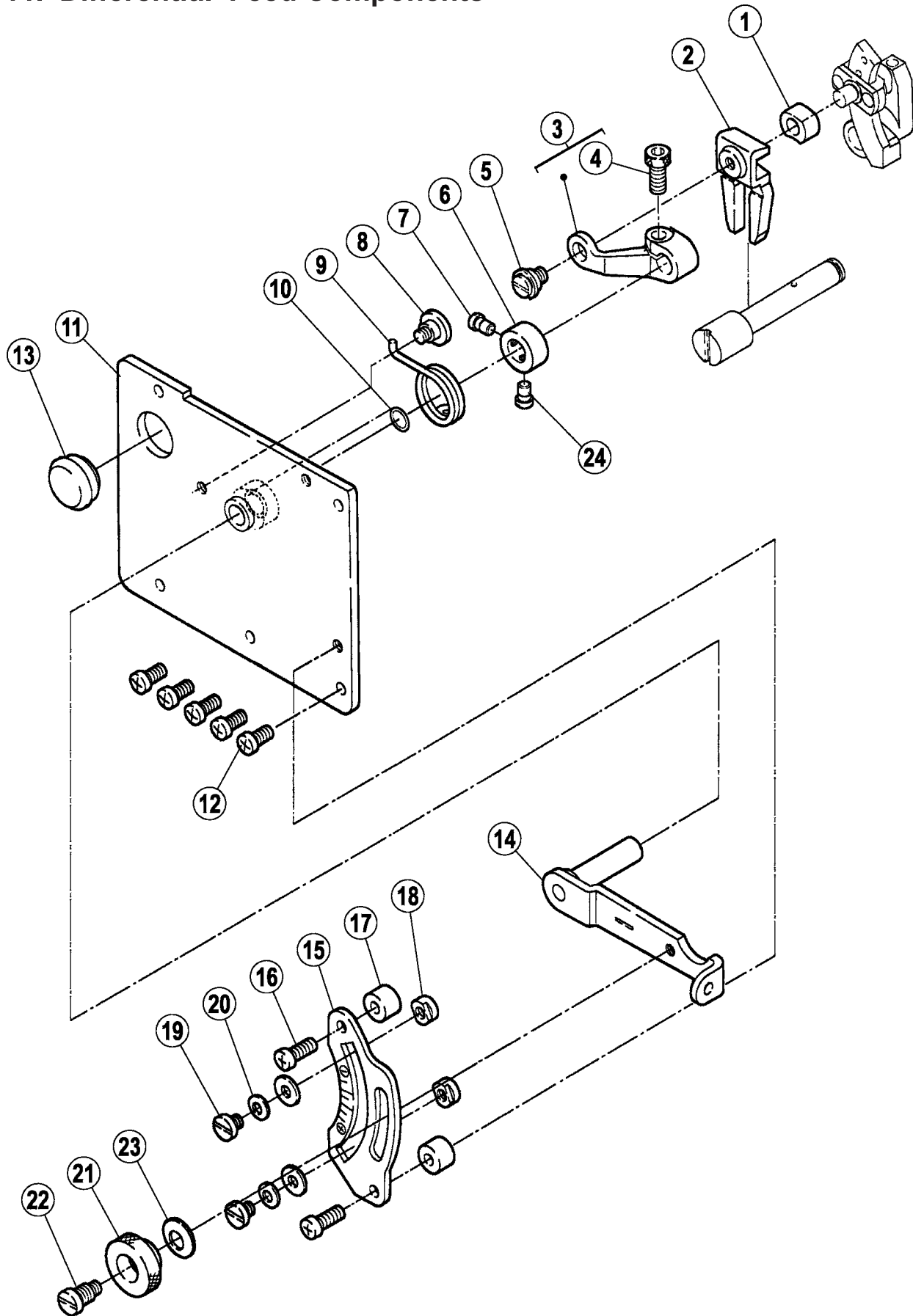
10. Feed Dog Holder Components



10. Feed Dog Holder Components

| No. | Parts No. | Description | QTY |
|-----|-------------|------------------------|-----|
| 1 | 3011400700 | main feed dog assy | 1 |
| 3 | 301S30003 | screw | 2 |
| 4 | 30110600400 | main feed bar assy | 1 |
| 6 | 20123019 | oil wick | 1 |
| 7 | 30103022 | bushing | 1 |
| 8 | S10006 | screw M5x6 | 4 |
| 9 | 30102016 | eccentric pin | 1 |
| 10 | 301S12001 | screw | 1 |
| 11 | 301109008 | block / feed bar guide | 1 |
| 12 | 30128011 | washer | 1 |
| 13 | 301S17002 | screw | 1 |
| 14 | 30109009 | guide (right) | 1 |
| 15 | 30103031 | bushing | 1 |
| 16 | 30100010 | guide (left) | 1 |
| 17 | L02003 | screw M4x7 | 2 |
| 18 | 30122020 | oil shield | 2 |
| 19 | 30109011 | cover | 1 |
| 20 | 30109012 | guide (lower) | 1 |
| 21 | S01005 | scww M4x10 | 2 |
| 22 | 807002 | needle bearing | 1 |
| 23 | 30109013 | block | 1 |
| 24 | 30108003 | washer | 1 |
| 25 | 30104013 | main feed link | 1 |
| 26 | B07003 | needle bearing | 1 |
| 27 | 30103023 | eccentric | 1 |
| 28 | 30103024 | regulator | 1 |
| 29 | 3010306500 | eccentric retainer | 1 |
| 30 | 301S30004 | screw | 1 |
| 31 | 30128012 | spring | 5 |
| 32 | 30103026 | spacer | 1 |
| 33 | 301S16001 | nut | 1 |
| 34 | S10002 | screw M5x5 | 1 |
| 35 | 301S30005 | screw | 1 |
| 36 | 30103027 | bushing | 1 |
| 37 | 30109014 | guide block | 1 |
| 38 | 30128013 | wsher | 2 |
| 39 | 301S10002 | nut | 2 |
| 40 | 301S30006 | screw | 1 |
| 41 | 30103028 | bushing | 1 |
| 42 | 30129001 | ring | 1 |
| 43 | 30105010 | differential feed link | 1 |
| 44 | 30109015 | bracket | 1 |
| 45 | S01004 | screw M4x7.8 | 3 |
| 46 | 30102017 | pin | 1 |
| 47 | 30127004 | spring | 1 |
| 48 | 1004 | o ring 4x1.8 | 1 |
| 49 | 30128032 | washer | 1 |
| 50 | 1105003 | ring 5 | 1 |
| 51 | 30103029 | pin | 1 |
| 52 | S12005 | screw M4x4 | 1 |
| 53 | 3010401500 | crank | 1 |
| 54 | S01012 | screw M2.5x4 | 1 |
| 55 | 30102018 | shaft | 1 |
| 56 | S10002 | serew MSx5 | 1 |
| 57 | 30123005 | felt | 2 |
| 58 | 30103030 | spacer | 1 |

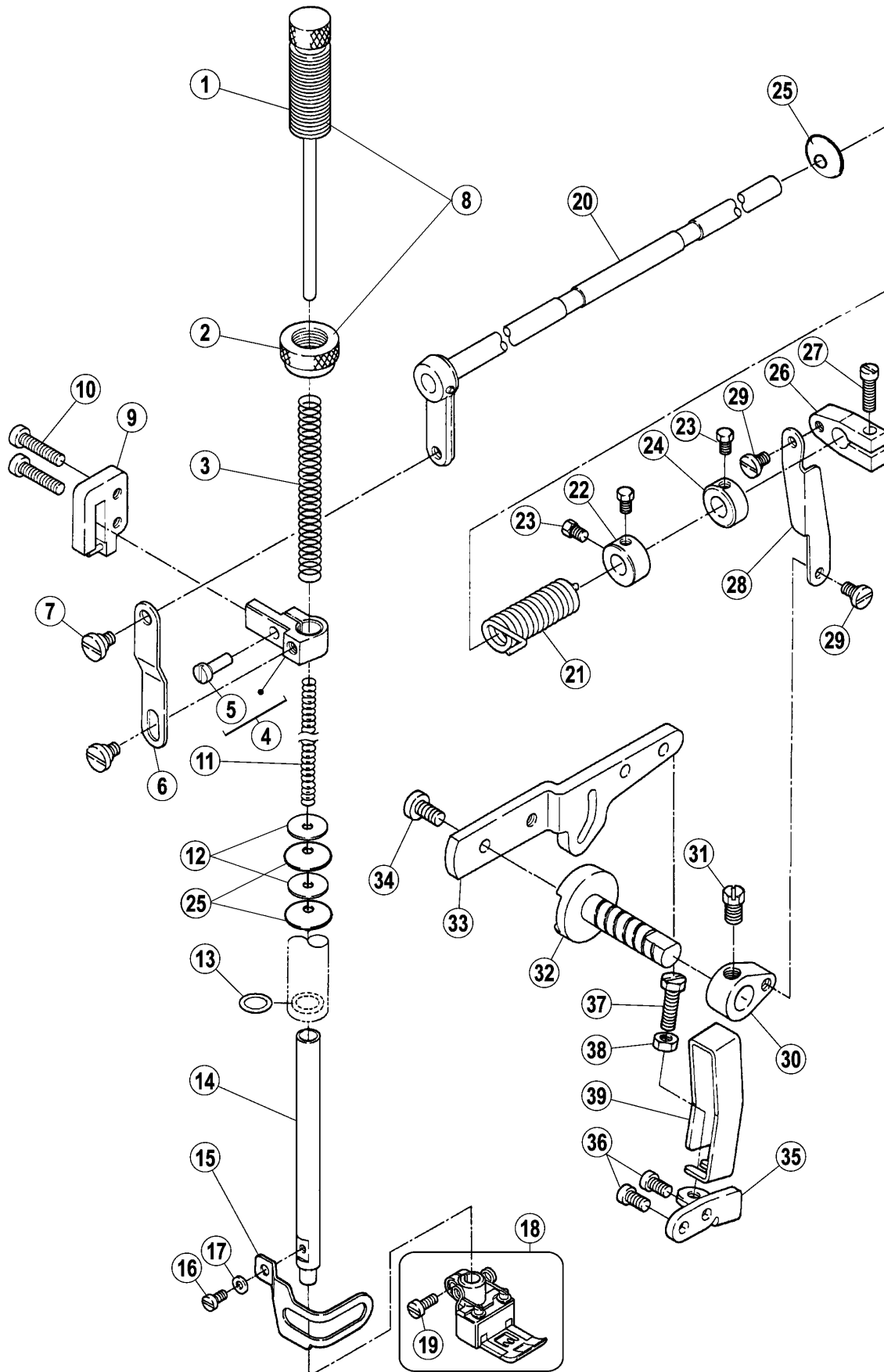
11. Differential Feed Components



11. Differential Feed Components

| No. | Parts No. | Description | QTY |
|-----|------------|----------------|-----|
| 1 | 30103032 | block | 1 |
| 2 | 30109016 | guide / block | 1 |
| 3 | 30105012 | lever assy | 1 |
| 4 | S05005 | screw M5x12 | 1 |
| 5 | 301S20006 | screw | 1 |
| 6 | 30108004 | ring | 1 |
| 7 | 301S11007 | scow | 1 |
| 8 | 301S20001 | screw | 1 |
| 9 | 30127005 | spring | 1 |
| 10 | 001005 | o ring 2.5x1.8 | 1 |
| 11 | 3011201100 | bracket | 1 |
| 12 | S01004 | screw M4x7.8 | 5 |
| 13 | 30122021 | plug | 1 |
| 14 | 3011201300 | lever | 1 |
| 15 | 30112015 | scale plate | 1 |
| 16 | S01003 | screw M4x12 | 2 |
| 17 | 30203019 | spacer | 2 |
| 18 | 20109005 | stopper | 2 |
| 19 | 301S11008 | screw | 2 |
| 20 | W01006 | washer 4 | 2 |
| 21 | 301S16004 | nut | 1 |
| 22 | 301S30007 | screw | 1 |
| 23 | 30128014 | washer | 1 |
| 24 | 301S11023 | screw | 1 |

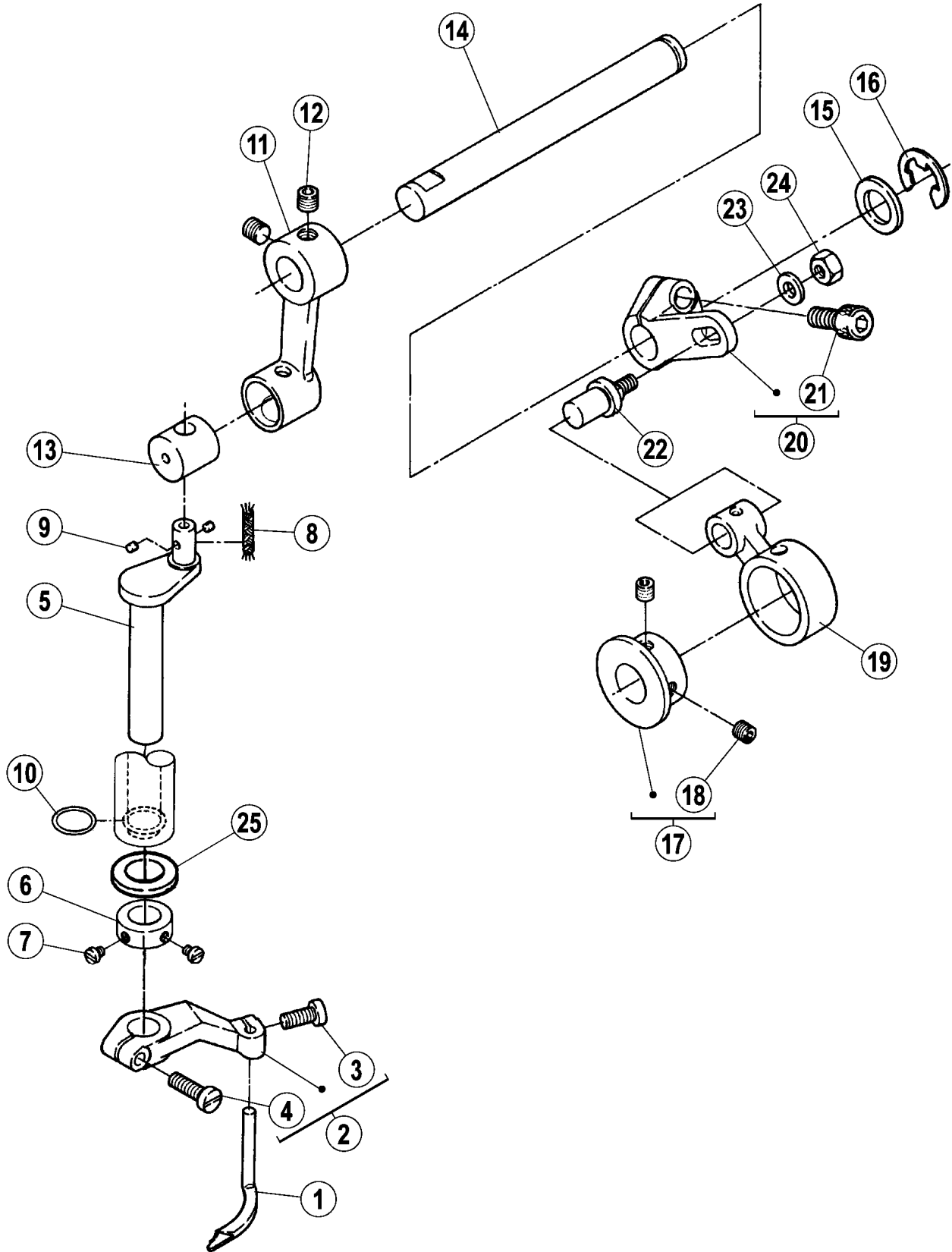
12. Presser Foot Components



12. Presser foot Components

| No. | Parts No. | Description | QTY |
|-----|------------|---------------------------------|-----|
| 1 | 301S30008 | adjusting bar | 1 |
| 2 | 301S16005 | nut | 1 |
| 3 | 30127006 | spring | 1 |
| 4 | 30104017 | presser bar clamp | 1 |
| 5 | S01003 | screw | 1 |
| 6 | 30112016 | link | 1 |
| 7 | 301S20007 | screw | 2 |
| 8 | 3013002400 | adjusting bar assy | 1 |
| 9 | 3010901700 | guide assy | 1 |
| 10 | S11025 | screw | 2 |
| 11 | 30127008 | spring | 1 |
| 12 | 30122022 | oil guard | 2 |
| 13 | 001006 | o ring | 1 |
| 14 | 30102020 | presser bar | 1 |
| 15 | 30112017 | finger guard | 1 |
| 16 | S01006 | screw | 1 |
| 17 | W01002 | washer | 1 |
| 18 | XXXXXXXXXX | presser foot assy | 1 |
| 19 | 301S11010 | screw | 1 |
| 20 | 30102021 | lever | 1 |
| 21 | 30127009 | spring | 1 |
| 22 | 30108005 | ring | 1 |
| 23 | 301S12001 | screw | 3 |
| 24 | 30108006 | ring | 1 |
| 25 | 30122023 | plug | 3 |
| 26 | 30104019 | bell crank (upper) | 1 |
| 27 | 301S11011 | screw | 1 |
| 28 | 30112018 | link | 1 |
| 29 | 301S20008 | screw | 2 |
| 30 | 30104020 | bell crank (lower) | 1 |
| 31 | 301S20013 | screw | 1 |
| 32 | 30102022 | shaft | 1 |
| 33 | 30112019 | lever | 1 |
| 34 | S01011 | screw | 1 |
| 35 | 30112020 | bracket | 1 |
| 36 | 9111004 | screw | 2 |
| 37 | S01016 | screw | 1 |
| 38 | N01002 | nut | 1 |
| 39 | 30211006 | guard / presser foot lift lever | 1 |

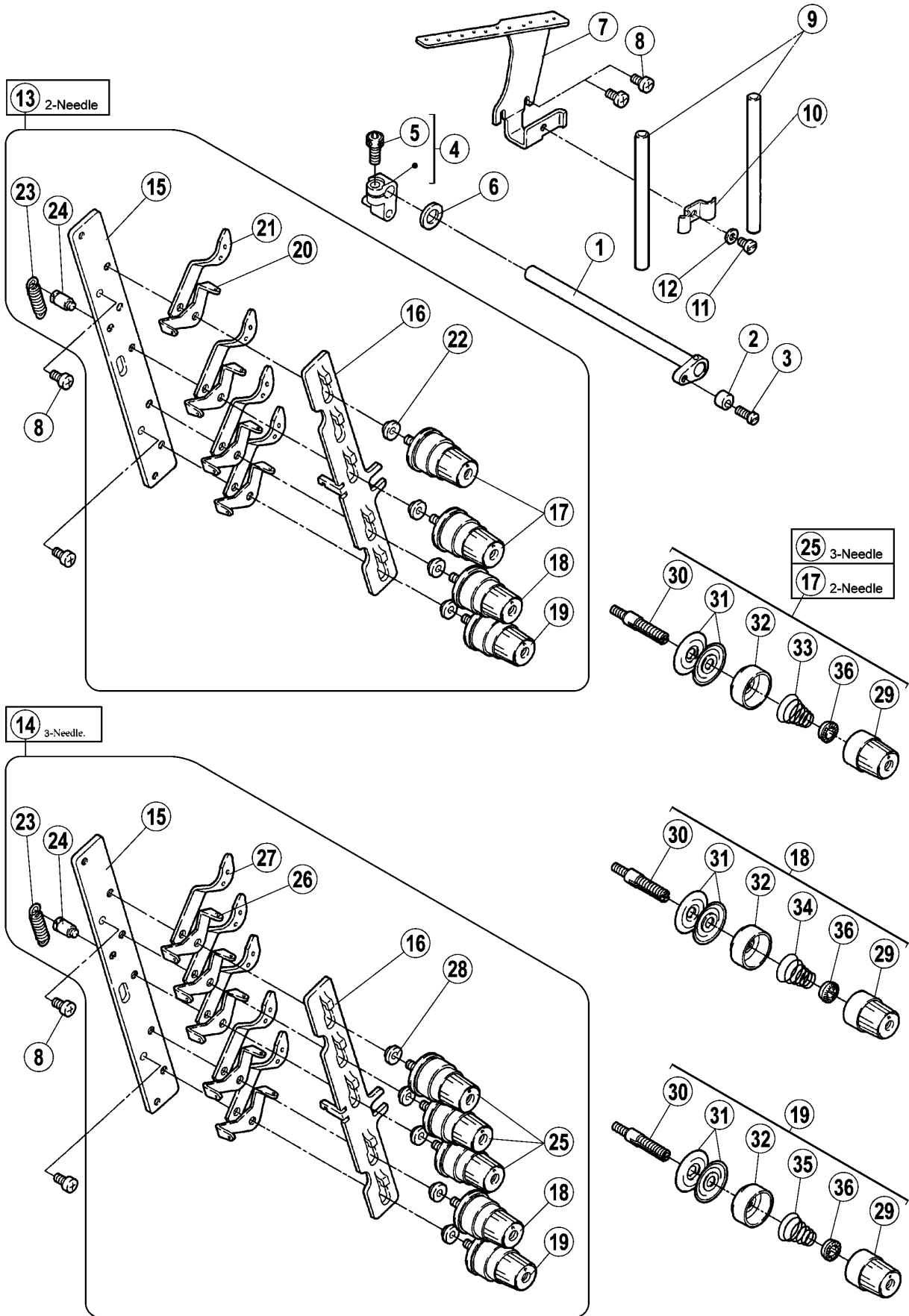
13. Spreader Components



13. Spreader Components

| No. | Parts No. | Description | QTY |
|-----|------------|----------------------|-----|
| 1 | 3011700900 | Spreader | 1 |
| 2 | 30104012 | Spreader holder assy | 1 |
| 3 | S01004 | screw M4x7.8 | 1 |
| 4 | S05004 | screw M5x14 | 1 |
| 5 | W02001 | scranksaft | 1 |
| 6 | S01014 | collar | 1 |
| 7 | 20622019 | screw | 1 |
| 8 | 30102014 | oil wick | 1 |
| 9 | 30110005 | felt | 1 |
| 10 | S10006 | o ring | 3 |
| 11 | 3010500800 | connection assy | 1 |
| 12 | S01008 | screw M3 5x13 | 2 |
| 13 | 30109007 | balance weight | 1 |
| 14 | S01009 | shaft | 2 |
| 15 | 30104010 | washer | 1 |
| 16 | 30128008 | ring | 1 |
| 17 | 30102013 | eccentric assembly | 1 |
| 18 | 30128032 | screw | 1 |
| 19 | N01002 | connection | 1 |
| 20 | 30102015 | crank | 1 |
| 21 | 30128010 | screw | 1 |
| 22 | 30108002 | screw | 1 |
| 23 | 301S12001 | washer | 1 |
| 24 | N01001 | nut M4 | 2 |
| 25 | 30102012 | shaft | 1 |
| 26 | H05001 | ring 10 | 1 |

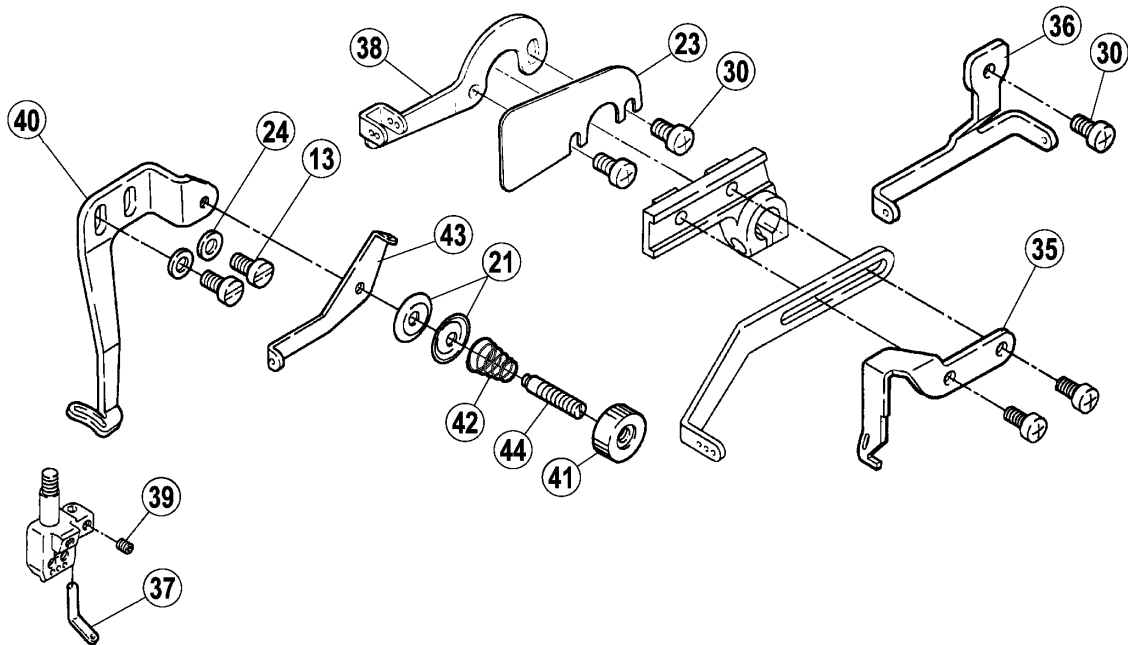
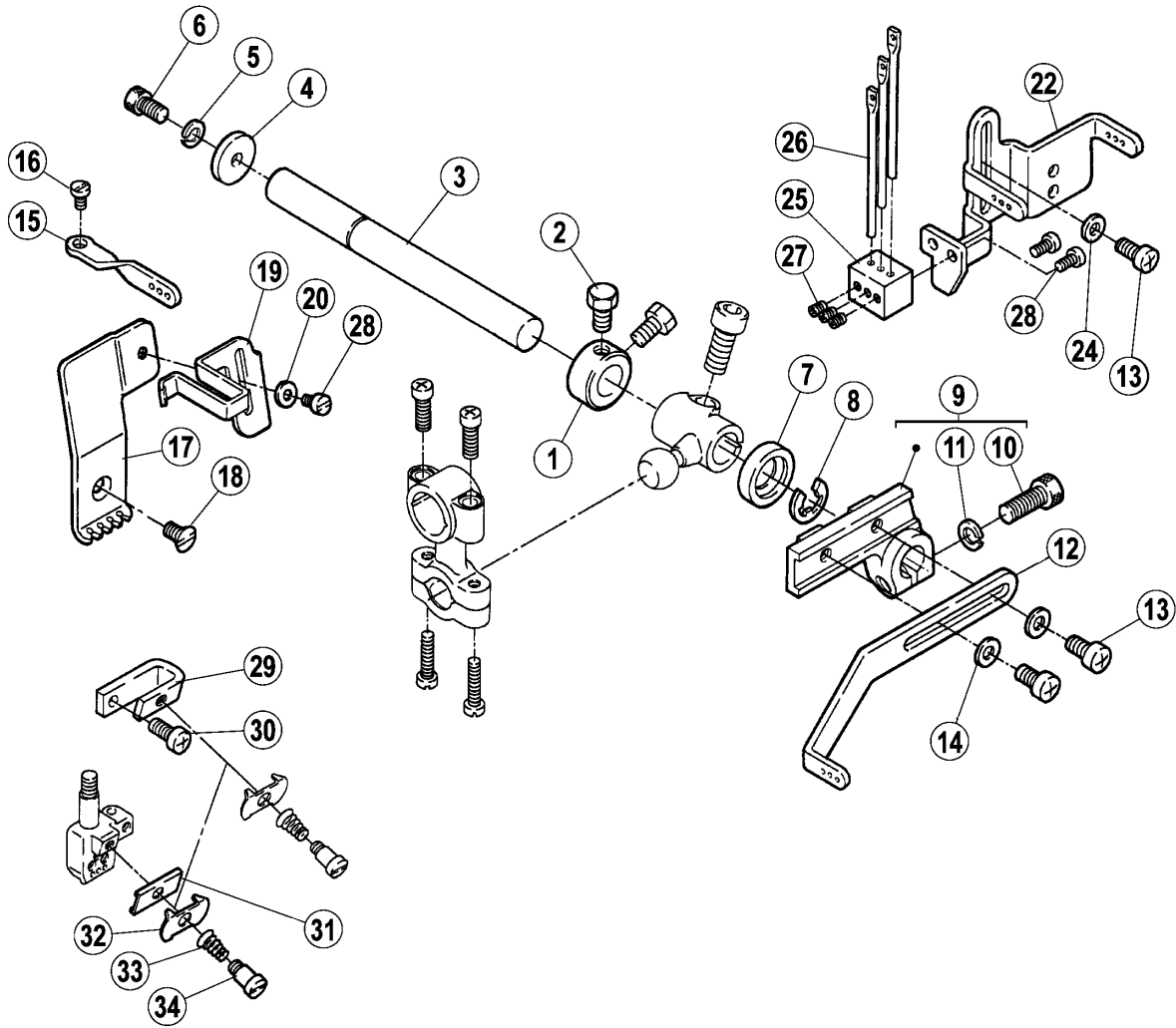
14. Thread Tension Components



14. Thread Tension Components

| No. | Parts No. | Description | QTY |
|-----|------------|------------------------------|-----|
| 1 | 3010403200 | lever | 1 |
| 2 | 30103040 | spacer | 1 |
| 3 | 301S11013 | screw | 1 |
| 4 | 3010403100 | crank | 1 |
| 5 | S05005 | screw M5x12 | 1 |
| 6 | W01010 | washer 4 | 1 |
| 7 | 30113001 | thread guide | 1 |
| 8 | S01004 | screw M4x7.8 | 4 |
| 9 | 30102026 | pipe | 2 |
| 10 | 30112021 | bracket | 1 |
| 11 | S01002 | screw M4x6.5 | 1 |
| 12 | W01001 | washer 4 | 1 |
| 13 | 3011300300 | tension control mechanism | 1 |
| 14 | 3011300200 | tension control mechanism | 1 |
| 15 | 30113003 | bracket | 1 |
| 16 | 30112022 | thread releaser | 1 |
| 17 | 3011300400 | tension spring assy (heavy) | 2 |
| 18 | 3011300500 | tension spring assy (medium) | 1 |
| 19 | 3011300600 | tension spring assy (light) | 1 |
| 20 | 30113007 | thread guide | 4 |
| 21 | 30113008 | thread guide | 4 |
| 22 | 30103041 | spacer | 4 |
| 23 | 30127010 | spring | 1 |
| 24 | 301S30009 | screw | 1 |
| 25 | 3011300400 | tension spring assy (heavy) | 3 |
| 26 | 30113007 | thread guide | 5 |
| 27 | 30113008 | thread guide | 5 |
| 28 | 30103041 | spacer | 5 |
| 29 | 301S16006 | knob | 1 |
| 30 | 301S30010 | screw stud | 1 |
| 31 | 30128016 | tension disc | 2 |
| 32 | 30111005 | spring shield | 1 |
| 33 | 30127011 | spring (heavy) | 3 |
| 34 | 30127012 | spring (medium) | 1 |
| 35 | 30127013 | spring (light) | 1 |
| 36 | 30111006 | ratchet | 1 |

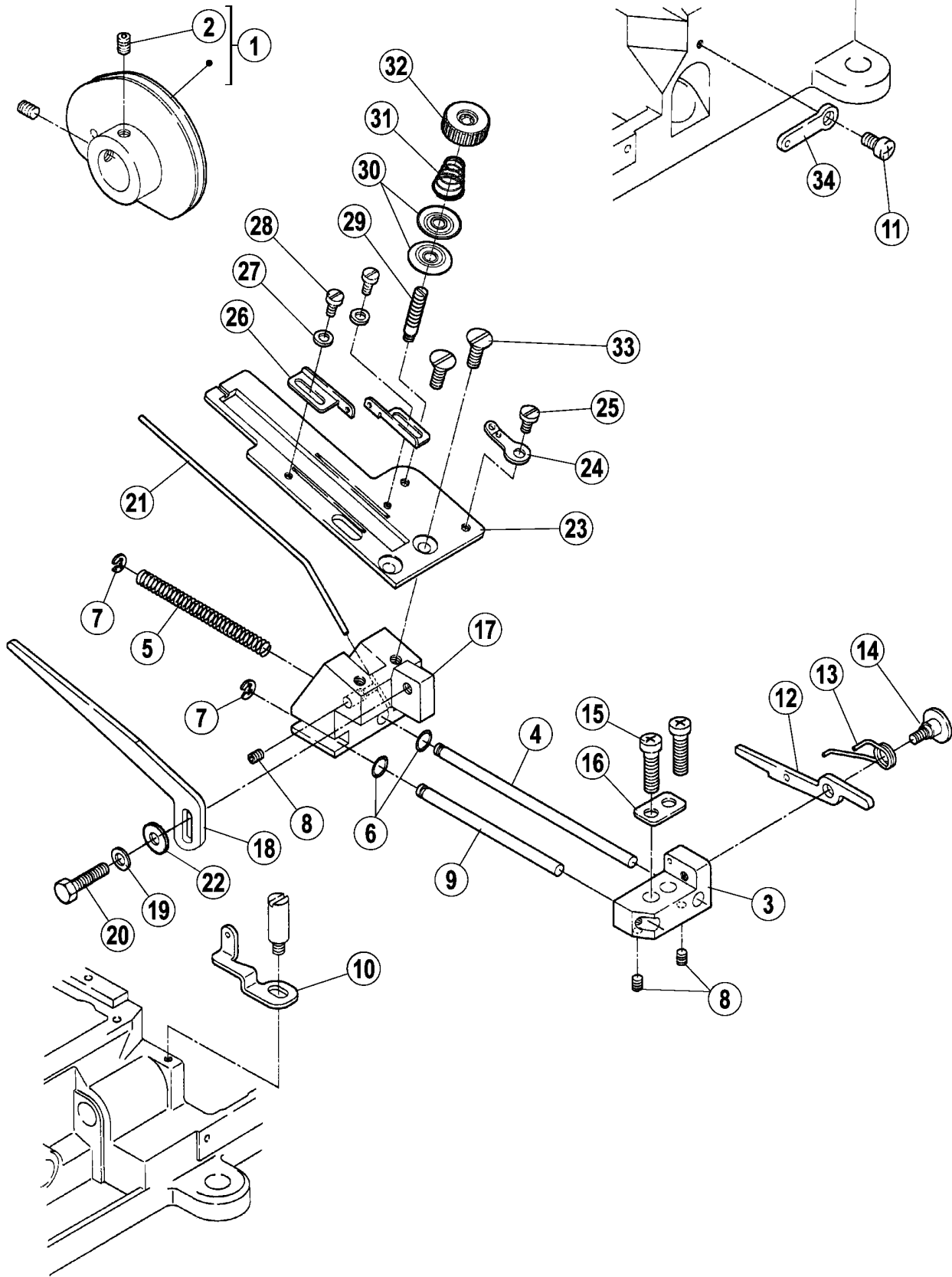
15. Needle, Spreader Thread Components



15. Needle, Spreader Thread Components

| No. | Parts No. | Description | QTY |
|-----|-----------|------------------------------|-----|
| 1 | 20608003 | collar | 1 |
| 2 | 301S12001 | screw | 2 |
| 3 | 30102028 | shaft | 1 |
| 4 | 30128019 | washer | 1 |
| 5 | W02002 | washer 4 | 1 |
| 6 | S05048 | screw M4x10 | 1 |
| 7 | 20622019 | plug | 1 |
| 8 | H05001 | ring 10 | 1 |
| 9 | 30101018 | lever assy | 1 |
| 10 | S05004 | screw M5x14 | 1 |
| 11 | W02001 | washer 4 | 1 |
| 12 | 30113009 | thread take-up | 1 |
| 13 | S01004 | screw M4x7.8 | 5 |
| 14 | W01001 | washer | 2 |
| 15 | 30113010 | thread guide | 1 |
| 16 | S01006 | screw M3x45 | 1 |
| 17 | 30113011 | thread guide | 1 |
| 18 | 206S30016 | screw | 1 |
| 19 | 30112023 | thread support | 1 |
| 20 | 30128034 | washer | 1 |
| 21 | 20112033 | tension disc | 2 |
| 22 | 30H2027 | thread guide | 1 |
| 23 | 30H2086 | guard / thread take-up lever | 1 |
| 24 | W01001 | washer | 3 |
| 25 | 30113012 | holder | 1 |
| 26 | 30113013 | thread guide | 3 |
| 27 | S10001 | screw M3x4 | 3 |
| 28 | S01006 | screw M3x45 | 2 |
| 29 | 30112024 | thread tension bracket | 1 |
| 30 | S01001 | screw M4x7 | 4 |
| 31 | 30112025 | thread guide | 1 |
| 32 | 30112026 | thread retainer | 1 |
| 33 | 30127014 | spring | 1 |
| 34 | 301S20009 | screw | 1 |
| 35 | 30112028 | thread take-up | 1 |
| 36 | 30112030 | thread guide | 1 |
| 37 | 30112033 | thread guide | 1 |
| 38 | 30112029 | thread guide | 1 |
| 39 | S10005 | screw M3x3 | 1 |
| 40 | 30112031 | thread guide | 1 |
| 41 | 301S16007 | knob | 1 |
| 42 | 30127016 | spring | 1 |
| 43 | 30112032 | thread guide | 1 |
| 44 | 301S30011 | screw | 1 |

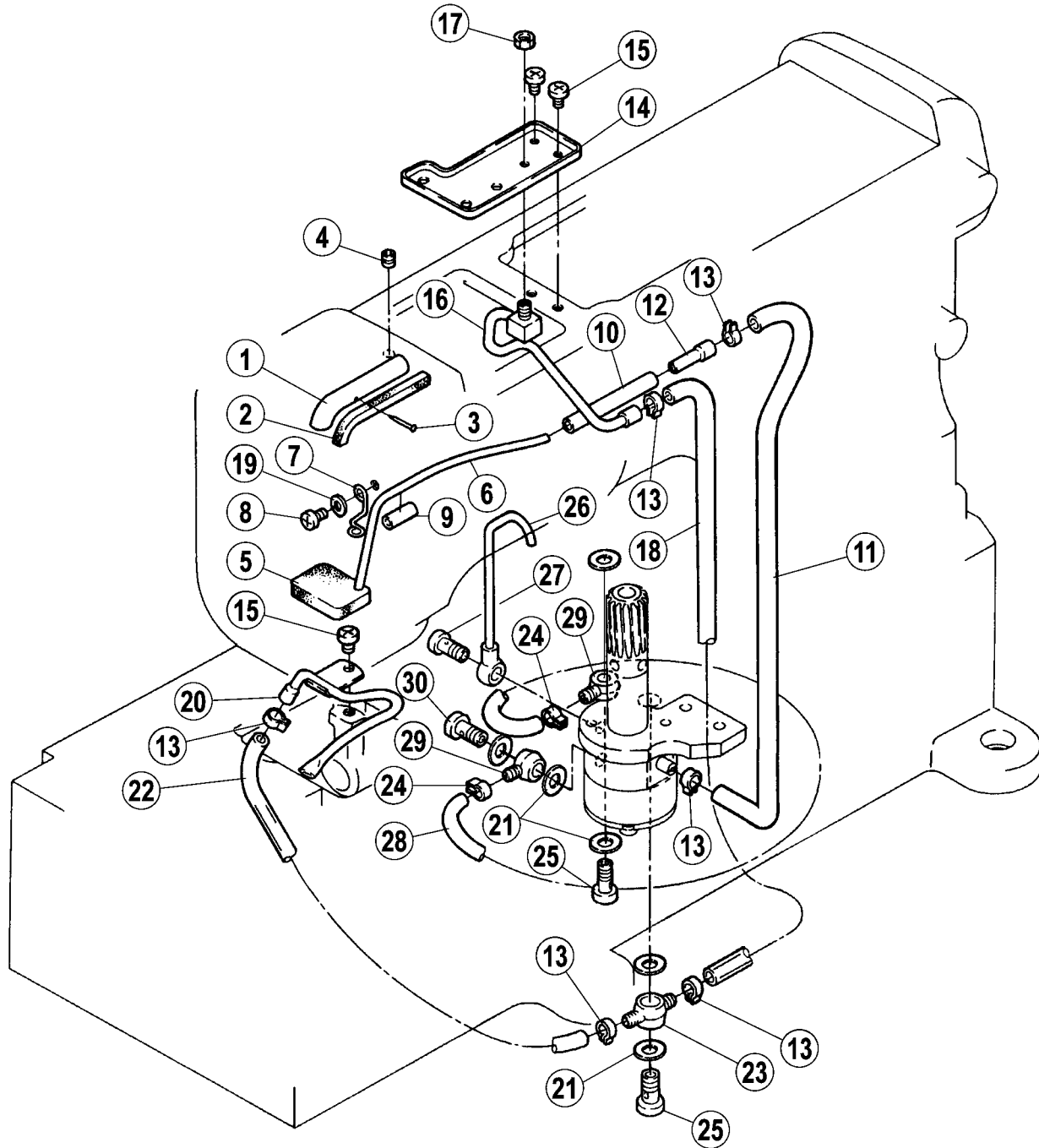
16. Looper Thread Cam Components



16. Looper Thread Cam Components

| No. | Parts No. | Description | QTY |
|-----|------------|-----------------|-----|
| 1 | 3011000800 | thread take-up | 1 |
| 2 | S10002 | screw M5x5 | 2 |
| 3 | 30101020 | bracket | 1 |
| 4 | 30102029 | shaft | 1 |
| 5 | 30127017 | spring | 1 |
| 6 | 001009 | o ring 4.5x1.8 | 2 |
| 7 | H05003 | ring | 2 |
| 8 | S10005 | screw M3x3 | 3 |
| 9 | 30102030 | shaft | 1 |
| 10 | 30113017 | thread guide | 1 |
| 11 | S01001 | screw M4x7 | 1 |
| 12 | 30112038 | stopper | 1 |
| 13 | 30127018 | spring | 1 |
| 14 | 301S20010 | screw | 1 |
| 15 | S01007 | screw M4x 13.5 | 2 |
| 16 | 30128023 | washer | 1 |
| 17 | 30101019 | bracket | 1 |
| 18 | 30112037 | thread guide | 1 |
| 19 | W02002 | washer | 1 |
| 20 | L02002 | screw M4x10 | 1 |
| 21 | 30112036 | thread support | 1 |
| 22 | 30128019 | washer | 1 |
| 23 | 30112035 | bracket | 1 |
| 24 | 20613008 | thread guide | 1 |
| 25 | 301S11014 | screw | 1 |
| 26 | 30113014 | thread guide | 2 |
| 27 | W01012 | washer 2.5 | 2 |
| 28 | S01012 | screw M2.5x4 | 2 |
| 29 | 301S30011 | screw | 1 |
| 30 | 20112033 | thread retainer | 2 |
| 31 | 30127016 | spring | 1 |
| 32 | 301S16007 | knob | 1 |
| 33 | S02001 | screw M4 | 2 |
| 34 | 30113016 | thread guide | 1 |

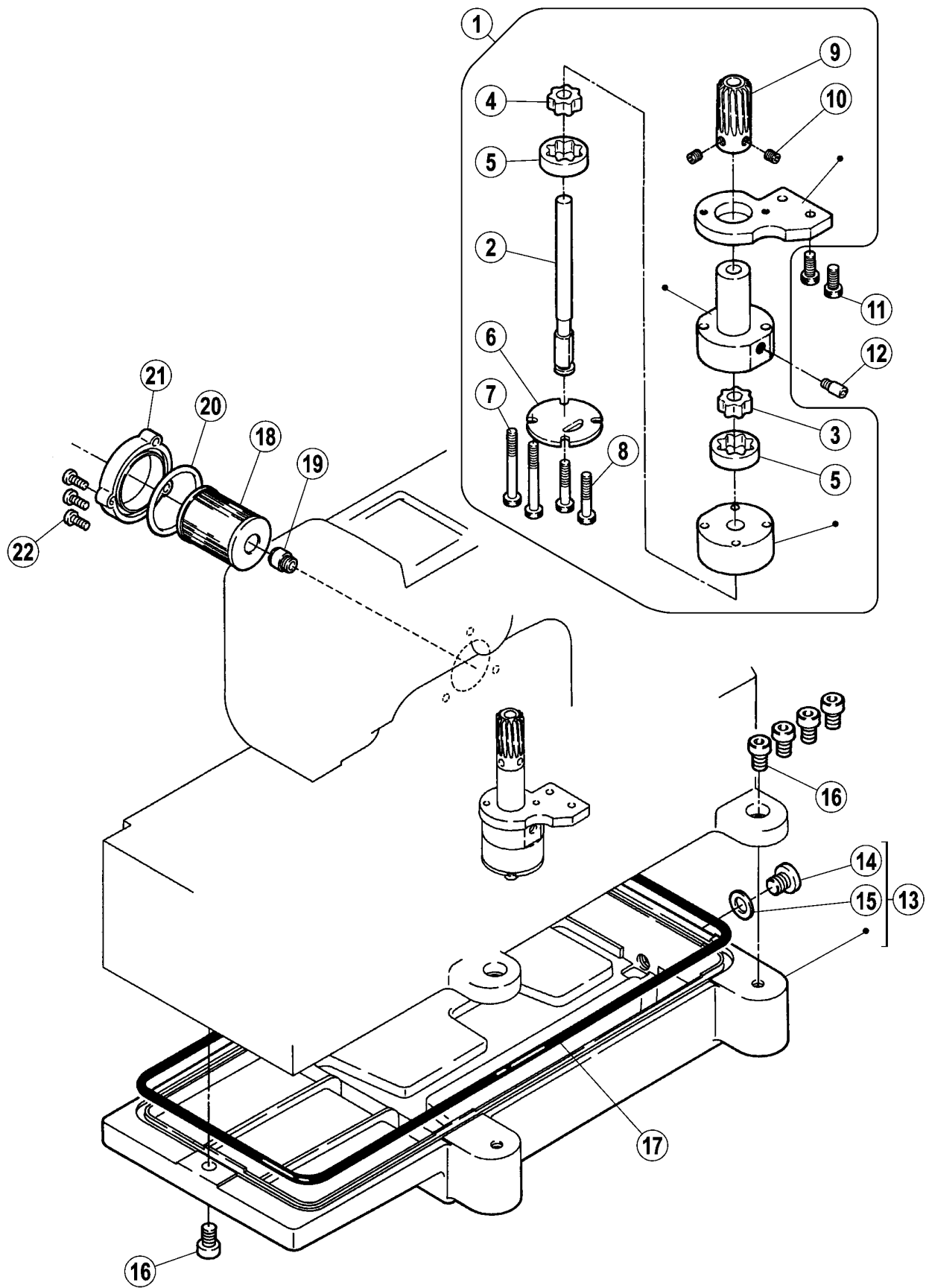
17. Lubrication Components



17. Lubrication Components

| No. | Parts No. | Description | QTY |
|-----|------------|-----------------------------|-----|
| 1 | 30121012 | oil pipe | 1 |
| 2 | 30123010 | felt | 1 |
| 3 | 30126008 | pin | 1 |
| 4 | S10002 | screw M5x5 | 1 |
| 5 | 30123009 | felt | 1 |
| 6 | 3012101400 | pipe | 1 |
| 7 | 30127019 | latch | 1 |
| 8 | S01004 | screw M4x7.8 | 1 |
| 9 | 30121007 | tube | 1 |
| 10 | 30121005 | tube | 1 |
| 11 | 30121018 | tube $\Phi 4 \times \Phi 6$ | 1 |
| 12 | 30136002 | joint | 1 |
| 13 | 20129002 | clamp | 6 |
| 14 | 30112039 | oil guard | 1 |
| 15 | S01002 | screw M4x6.5 | 3 |
| 16 | 3012101500 | oil distributor | 1 |
| 17 | N01001 | nut | 1 |
| 18 | 30121010 | tube $\Phi 4 \times \Phi 6$ | 1 |
| 19 | W01001 | ring | 1 |
| 20 | 30121009 | oil distributor | 1 |
| 21 | 20122033 | washer | 6 |
| 22 | 30121008 | tube $\Phi 4 \times \Phi 6$ | 1 |
| 23 | 30136004 | joint | 1 |
| 24 | 30129006 | clamp | 2 |
| 25 | 301S30013 | joint screw | 2 |
| 26 | 30136003 | pipe | 1 |
| 27 | 301S30012 | screw | 1 |
| 28 | 30121017 | tube $\Phi 5 \times \Phi 7$ | 1 |
| 29 | 30136001 | joint | 2 |
| 30 | 201S30004 | joint screw | 1 |

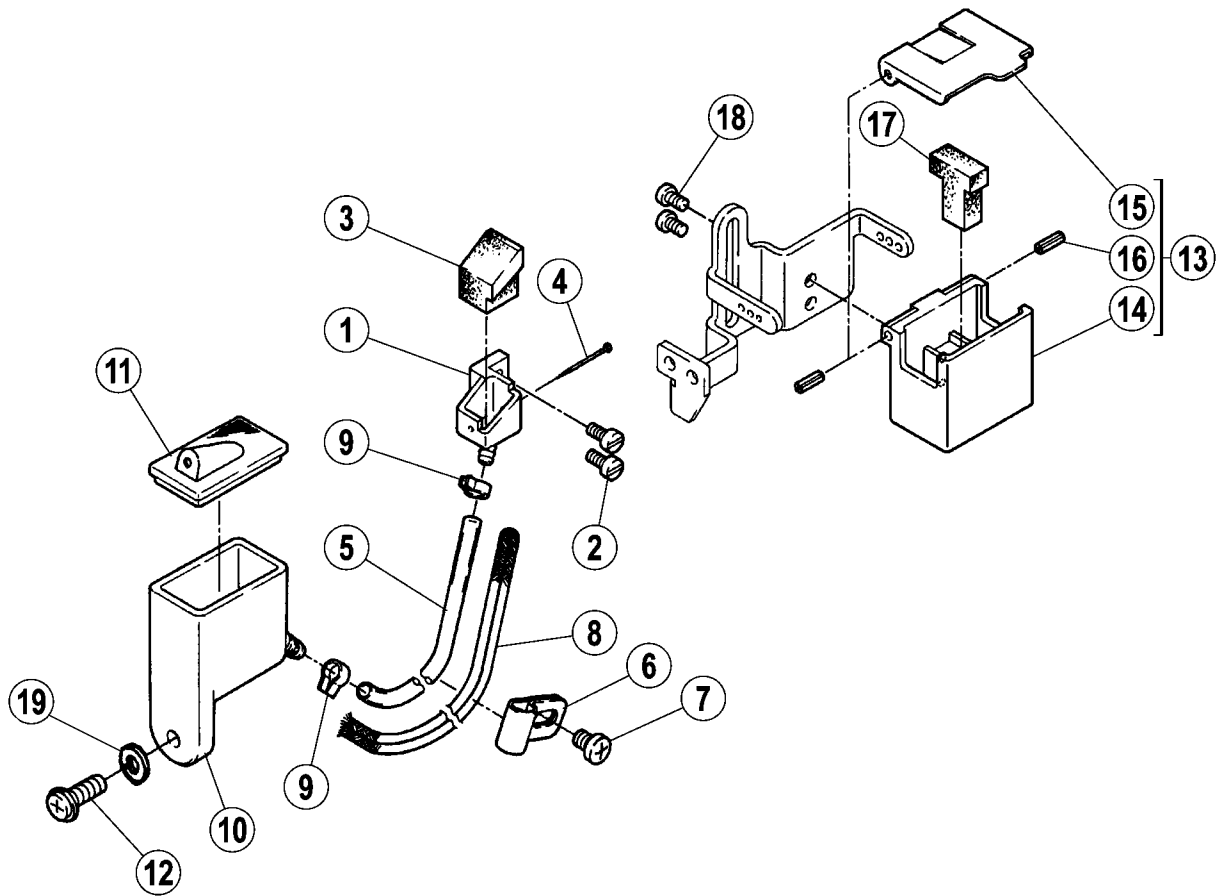
18. Oil Pump Components



18. Oil Pump Components

| No. | Parts No. | Description | QTY |
|-----|------------|--------------------------|-----|
| 1 | 3012000190 | oil pump assy | 1 |
| 2 | 30102031 | shaft | 1 |
| 3 | 30120004 | rotor | 1 |
| 4 | 30120007 | rotor | 1 |
| 5 | 30120005 | rotor | 2 |
| 6 | 30120008 | cover | 1 |
| 7 | 301s20011 | screw | 2 |
| 8 | S05006 | screw M4x25 | 2 |
| 9 | 30125003 | worm wheel | 1 |
| 10 | S10002 | screw M5x5 | 2 |
| 11 | S05004 | screw M5x14 | 2 |
| 12 | 301S30014 | joint screw | 1 |
| 13 | 30101023 | oil reservoir assy | 1 |
| 14 | 301S11015 | screw | 1 |
| 15 | 20528014 | washer | 1 |
| 16 | S05007 | screw M8x20 | 5 |
| 17 | 30122025 | o ring | 1 |
| 18 | 20136001 | filter element | 1 |
| 19 | 301S30016 | bracket / filter element | 1 |
| 20 | 1010 | o ring 38.7x3.55 | 1 |
| 21 | 300140 | cover | 1 |
| 22 | S01003 | screw M4x12 | 3 |

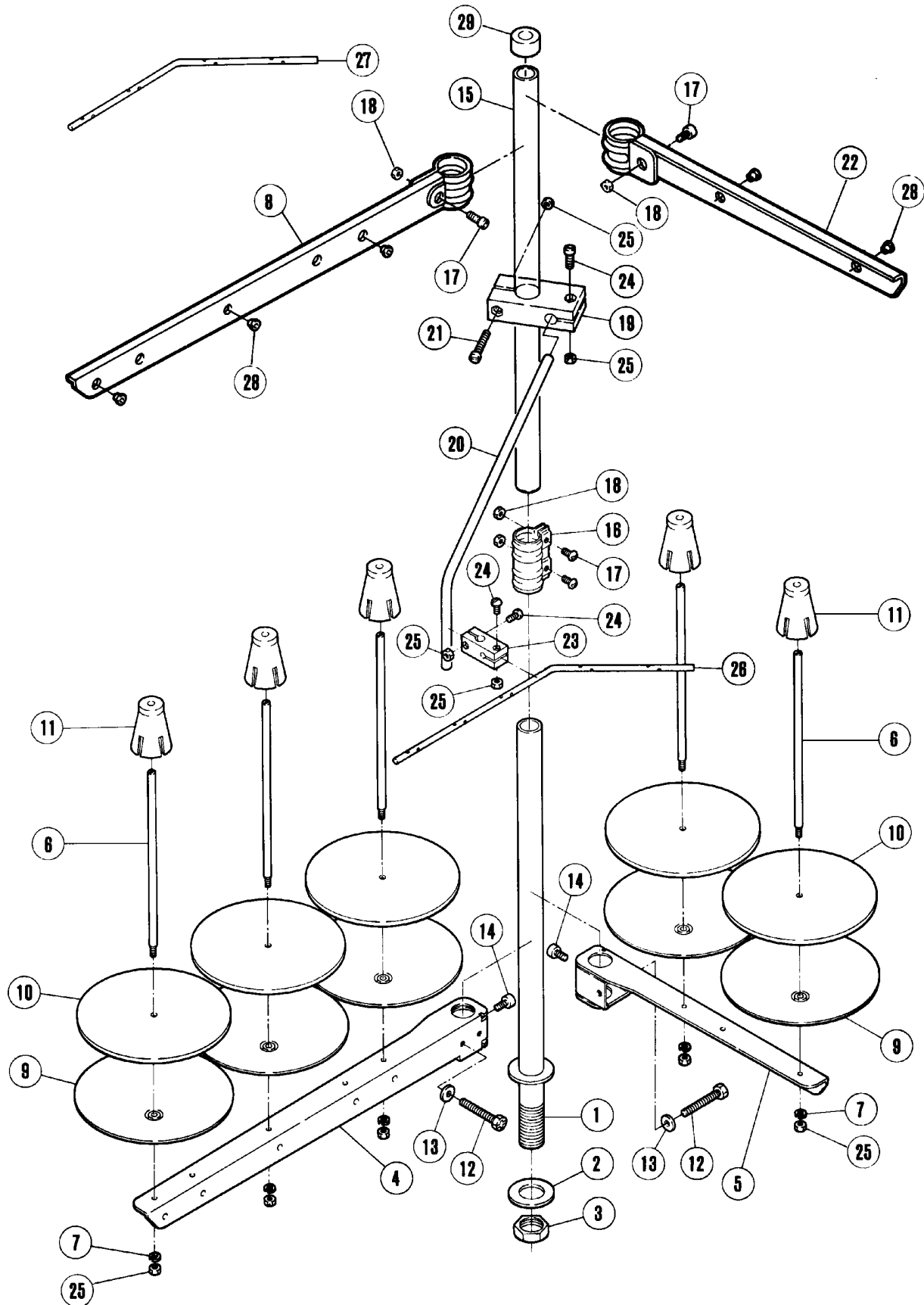
19. HR Device Components



19. HR Device Components

| No. | Parts No. | Description | QTY |
|-----|------------|-------------------------------------|-----|
| 1 | 30101027 | needle cooler (lower) | 1 |
| 2 | S01015 | screw M3x5 | 2 |
| 3 | 30123012 | felt | 1 |
| 4 | 30126009 | pin | 1 |
| 5 | 30121017 | tube $\Phi 5 \times \Phi 7$ | 1 |
| 6 | 30127020 | bracket | 1 |
| 7 | S01004 | screw M4x8 | 1 |
| 8 | 30123015 | oil wick | 1 |
| 9 | 30129006 | clamp | 2 |
| 10 | 30101026 | silicone oil reservoir (lower) | 1 |
| 11 | 30122026 | cap | 1 |
| 12 | S01005 | screw M4x10 | 1 |
| 13 | 3010102400 | silicone oil reservoir (upper) assy | 1 |
| 14 | 300141 | silicone oil reservoir (upper) | 1 |
| 15 | 30112040 | cap | 1 |
| 16 | P03008 | pin 2x6 | 2 |
| 17 | 30123011 | felt | 1 |
| 18 | S01006 | screw M3x4.5 | 2 |
| 19 | W01001 | washer | 1 |

20. Thread Stand Components

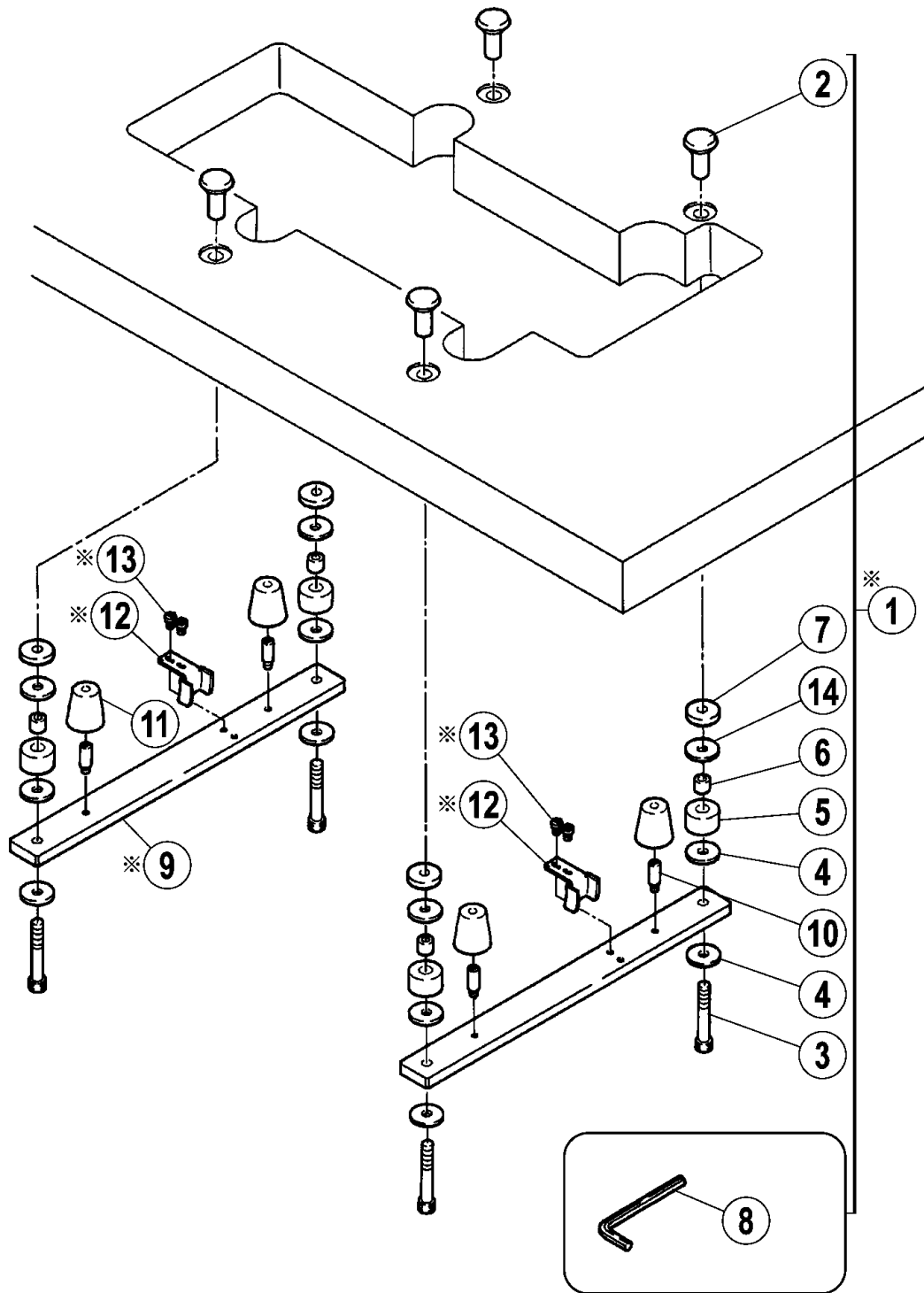


20. Thread Stand Components

| No. | Parts No. | Description | QTY |
|-----|-----------|----------------------------|-----|
| 1 | 30102032 | thread bar (lower) | 1 |
| 2 | 30128024 | washer | 2 |
| 3 | N02001 | nut | 1 |
| 4 | 30101028 | bracket (3 spool) | 1 |
| 5 | 30101029 | bracket (2-spool) | 1 |
| 6 | 30102033 | spool pin | 5 |
| 7 | W02002 | washer | 5 |
| 8 | 30101030 | bracket (3-spool) | 1 |
| 9 | 30111007 | spool tray | 5 |
| 10 | 30123014 | cushion | 5 |
| 11 | 30103044 | spool holder | 5 |
| 12 | L02004 | screw | 2 |
| 13 | W01003 | washer | 2 |
| 14 | S04001 | screw | 2 |
| 15 | 30102034 | thread bar (upper) | 1 |
| 16 | 30129005 | joint | 1 |
| 17 | S04002 | screw | 4 |
| 18 | N01004 | nut | 4 |
| 19 | 30111008 | bracket | 1 |
| 20 | 30113018 | thread guide bar | 1 |
| 21 | S04003 | screw | 1 |
| 22 | 30101031 | bracket (2-spool) | 1 |
| 23 | 30111009 | holder | 1 |
| 24 | S04004 | screw | 3 |
| 25 | N01005 | nut | 9 |
| 26 | 30113019 | thread guide bar(5 spool) | 1 |
| 27 | 30113034 | thread guide bar (6 spool) | 1 |
| 28 | 30103045 | thread guide | 5 |
| 29 | 30122027 | rod cap | 1 |

21. Machine Supporting Components

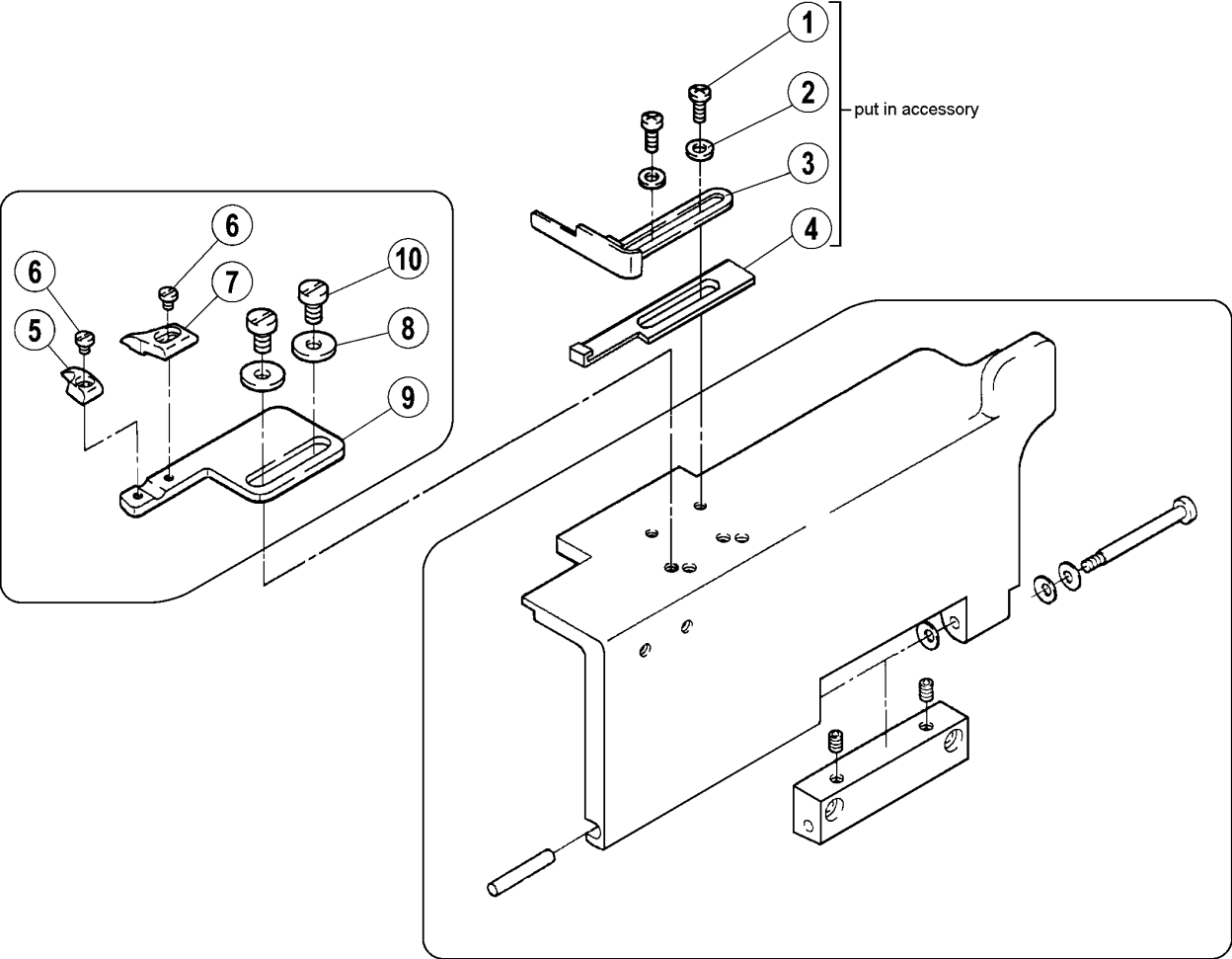
machine table mechanism (put in accessory)



21. Machine Supporting Components

| No. | Parts No. | Description | QTY |
|-----|------------|---------------------|-----|
| 1 | 3010103200 | screw (set) | 1 |
| 2 | 301S16008 | nut | 4 |
| 3 | 301S30017 | bolt | 4 |
| 4 | 20131029 | washer | 8 |
| 5 | 20131030 | rubber cushion | 4 |
| 6 | 30103080 | spacer | 4 |
| 7 | 30122031 | spacer | 4 |
| 8 | 20131056 | allen key / 6mm | 1 |
| 9 | 30101032 | supporting board | 2 |
| 10 | 301S30018 | screw | 4 |
| 11 | 30122029 | rubber cushion | 4 |
| 12 | 30112041 | treadle chain guide | 2 |
| 13 | S01011 | screw | 4 |
| 14 | 20131029 | washer | 8 |

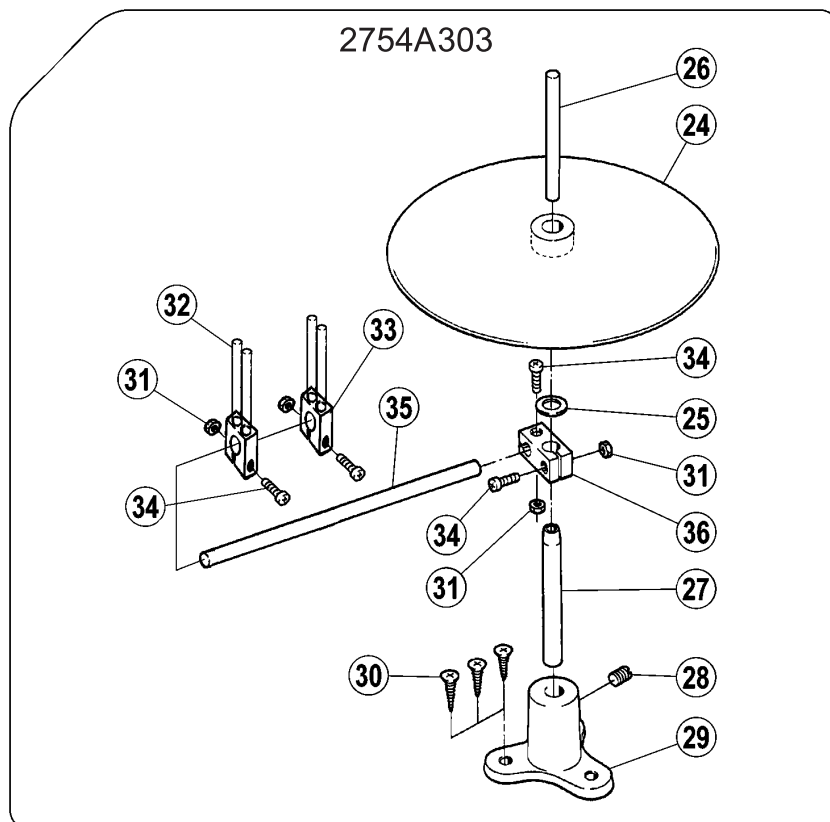
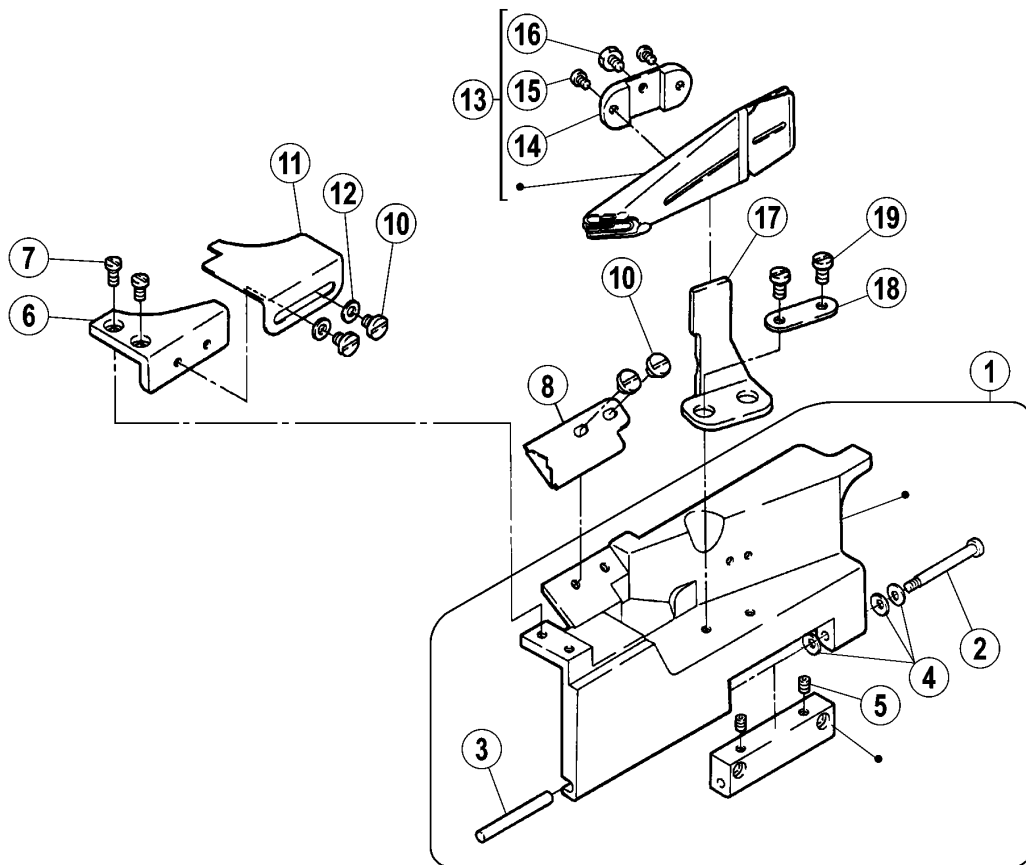
22. Parts For 2754A311/313



22. Parts For 2754A311/313

| No. | Parts No. | Description | QTY |
|-----|-----------|--------------|-----|
| 1 | 301S11024 | screw | 2 |
| 2 | W01001 | washer | 2 |
| 3 | 30112065 | fabric guide | 1 |
| 4 | 30112066 | fabric guide | 1 |
| 5 | 30109020 | fabric guide | 1 |
| 6 | S01036 | screw | 2 |
| 7 | 30109021 | fabric guide | 1 |
| 8 | W01009 | washer | 2 |
| 9 | 30112064 | bracket | 1 |
| 10 | S01011 | screw | 2 |

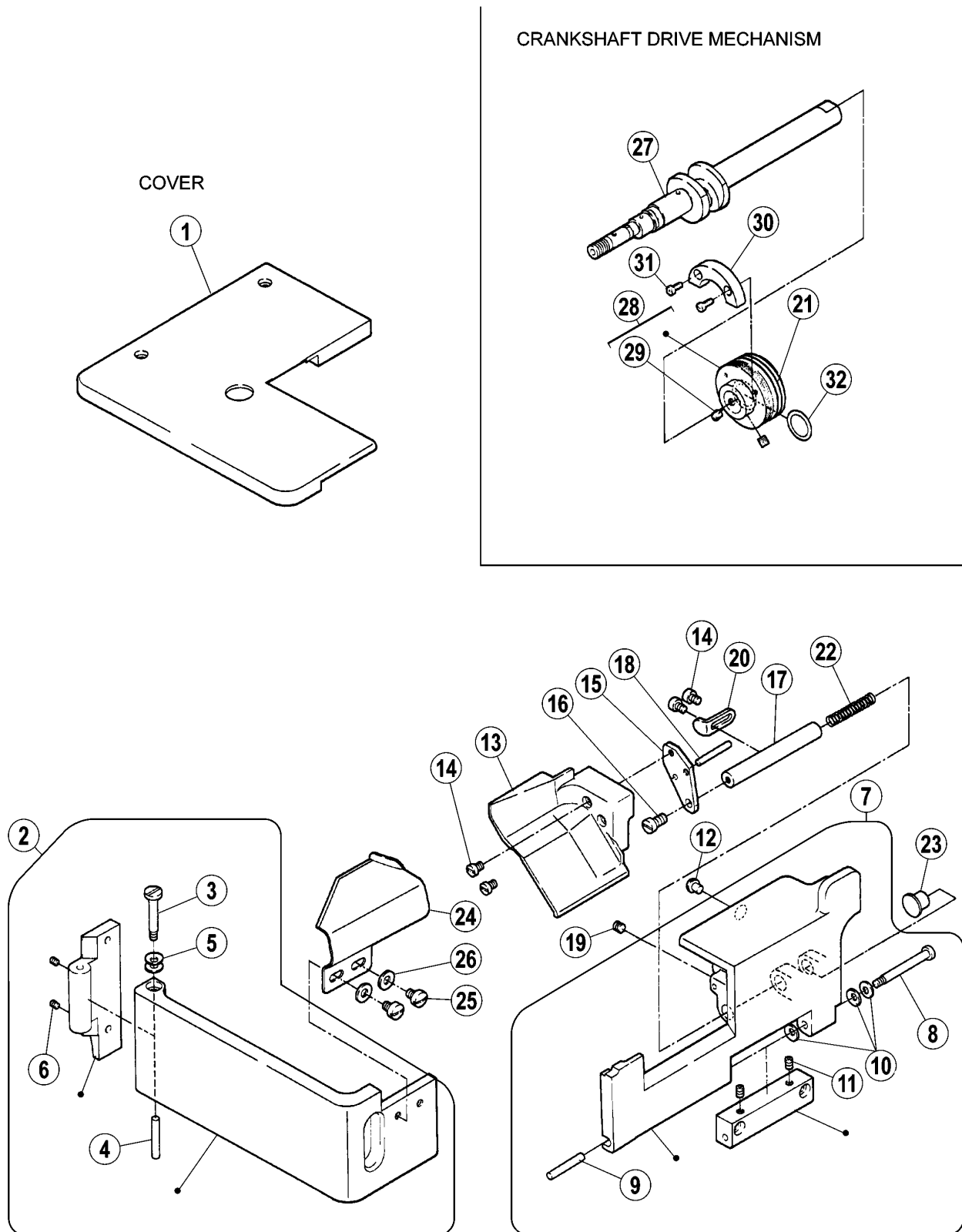
23. Parts For 2754A303



23. Parts For 2754A303

| No. | Parts No. | Description | QTY |
|-----|------------|-------------------------------|-----|
| 1 | 300202 | front cover assy | 1 |
| 2 | 301S20002 | screw | 1 |
| 3 | 301S20003 | pin | 1 |
| 4 | 30128002 | spring | 2 |
| 5 | S10002 | screw | 2 |
| 6 | 300130 | front cover (small) | 1 |
| 7 | S01011 | screw | 2 |
| 8 | 30112061 | fabric guard | 1 |
| 10 | S01065 | screw | 4 |
| 11 | 30112060 | auxiliary plate / front cover | 1 |
| 12 | W01004 | washer | 2 |
| 13 | 3011206800 | bracket assy | 1 |
| 14 | 30109019 | bracket | 1 |
| 15 | 301S11021 | screw | 2 |
| 16 | L02009 | bolt | 1 |
| 17 | 30112062 | bracket | 1 |
| 18 | 30112063 | washer | 1 |
| 19 | S01011 | screw | 2 |
| 24 | 30111019 | tape disc | 1 |
| 25 | 30128029 | washer | 1 |
| 26 | 30103060 | tape disc post | 1 |
| 27 | 30103061 | tape disc post | 1 |
| 28 | S09002 | scow | 1 |
| 29 | 30101049 | bracket | 1 |
| 30 | 301S30020 | screw | 3 |
| 31 | N01005 | nut | 4 |
| 32 | 30102048 | tape disc post | 4 |
| 33 | 30101050 | holder | 2 |
| 34 | S04004 | screw | 4 |
| 35 | 30113023 | guide post bar | 1 |
| 36 | 30111020 | bracket | 1 |

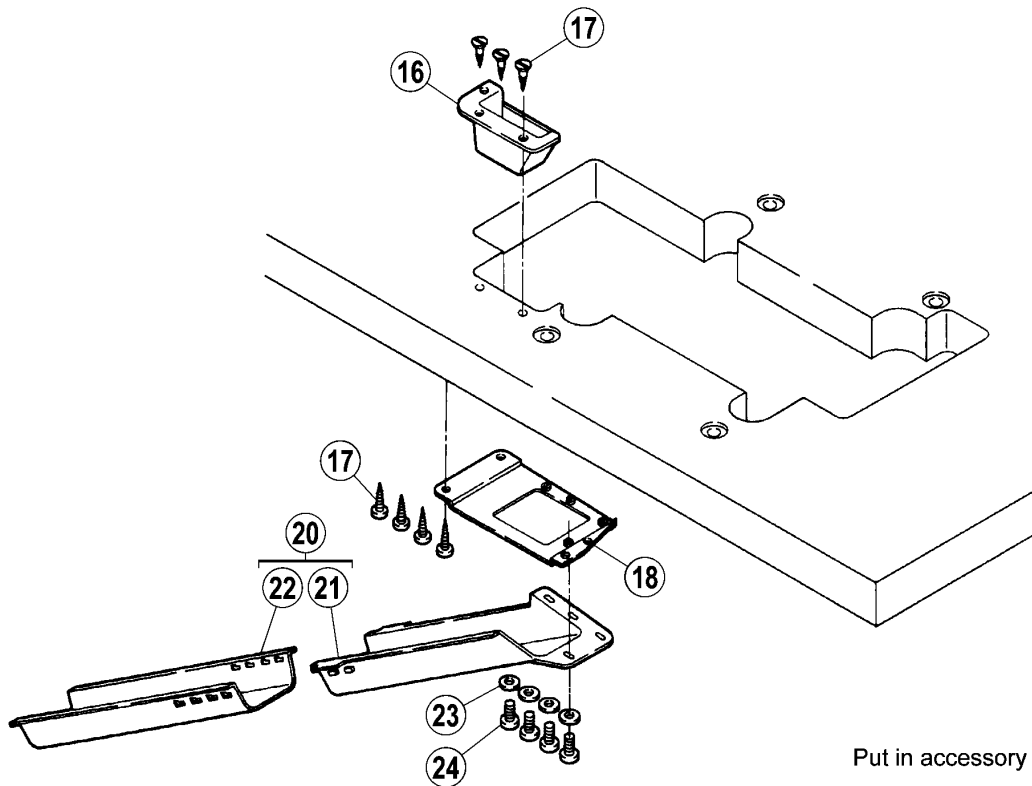
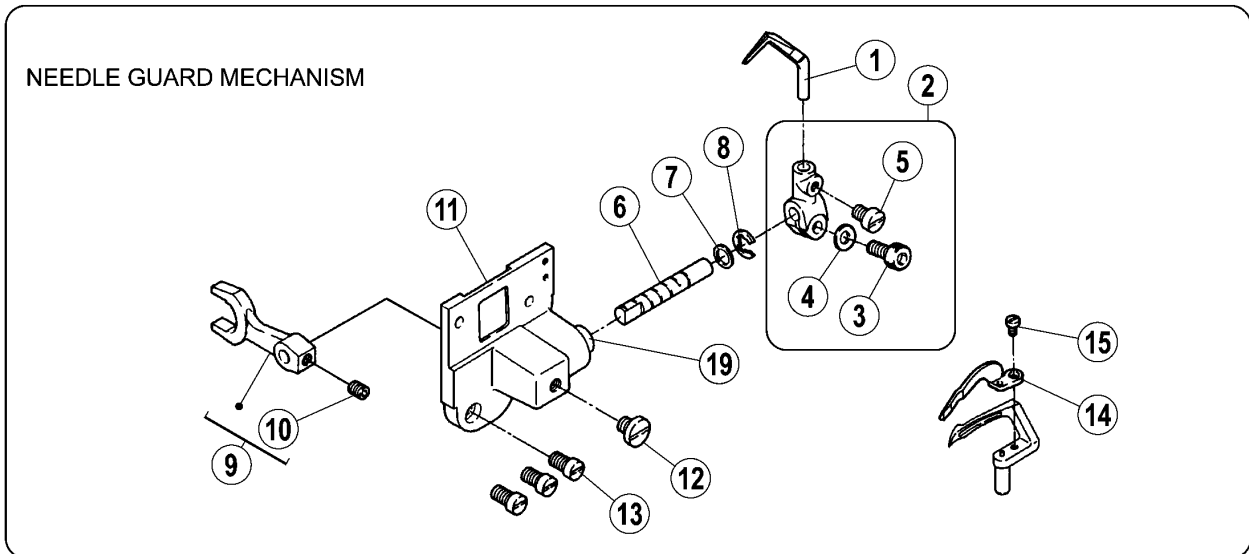
24. Parts For 2754A309 (1)



24. Parts For 2754A309 (1)

| No. | Parts No. | Description | QTY |
|-----|------------|---------------------|-----|
| 1 | 300471 | bed cover (left) | 1 |
| 2 | 300203 | side cover assy | 1 |
| 3 | 301S20004 | screw | 1 |
| 4 | 301S20005 | pin | 1 |
| 5 | 30128002 | spring | 2 |
| 6 | S10001 | screw M3x4 | 2 |
| 7 | 300142 | front cover assy | 1 |
| 8 | 301S20002 | screw | 1 |
| 9 | 301S20003 | pin | 1 |
| 10 | 30128002 | spring | 2 |
| 11 | S10006 | screw M5x6 | 2 |
| 12 | 30122015 | cushon | 1 |
| 13 | 30112045 | front cover (small) | 1 |
| 14 | S01001 | screw M4x7 | 4 |
| 15 | 30112046 | bracket | 1 |
| 16 | S01011 | screw M5x10 | 1 |
| 17 | 30102036 | shaft | 1 |
| 18 | 30126010 | pin | 1 |
| 19 | S10002 | screw M5x5 | 1 |
| 20 | 30112047 | stopper | 1 |
| 21 | 3012400300 | bushing | 1 |
| 22 | 30127024 | spring | 1 |
| 23 | 30122030 | plug | 1 |
| 24 | 30112044 | fabric guide | 1 |
| 26 | W01004 | washer | 2 |
| 27 | 30102049 | crankshaft assy | 1 |
| 28 | 30103003 | bushing | 1 |
| 29 | S10006 | screw M5x6 | 2 |
| 30 | 30109002 | balance weight | 1 |
| 31 | S01009 | screw M3x7.5 | 2 |
| 32 | 001001 | O ring 15x2.65 | 1 |

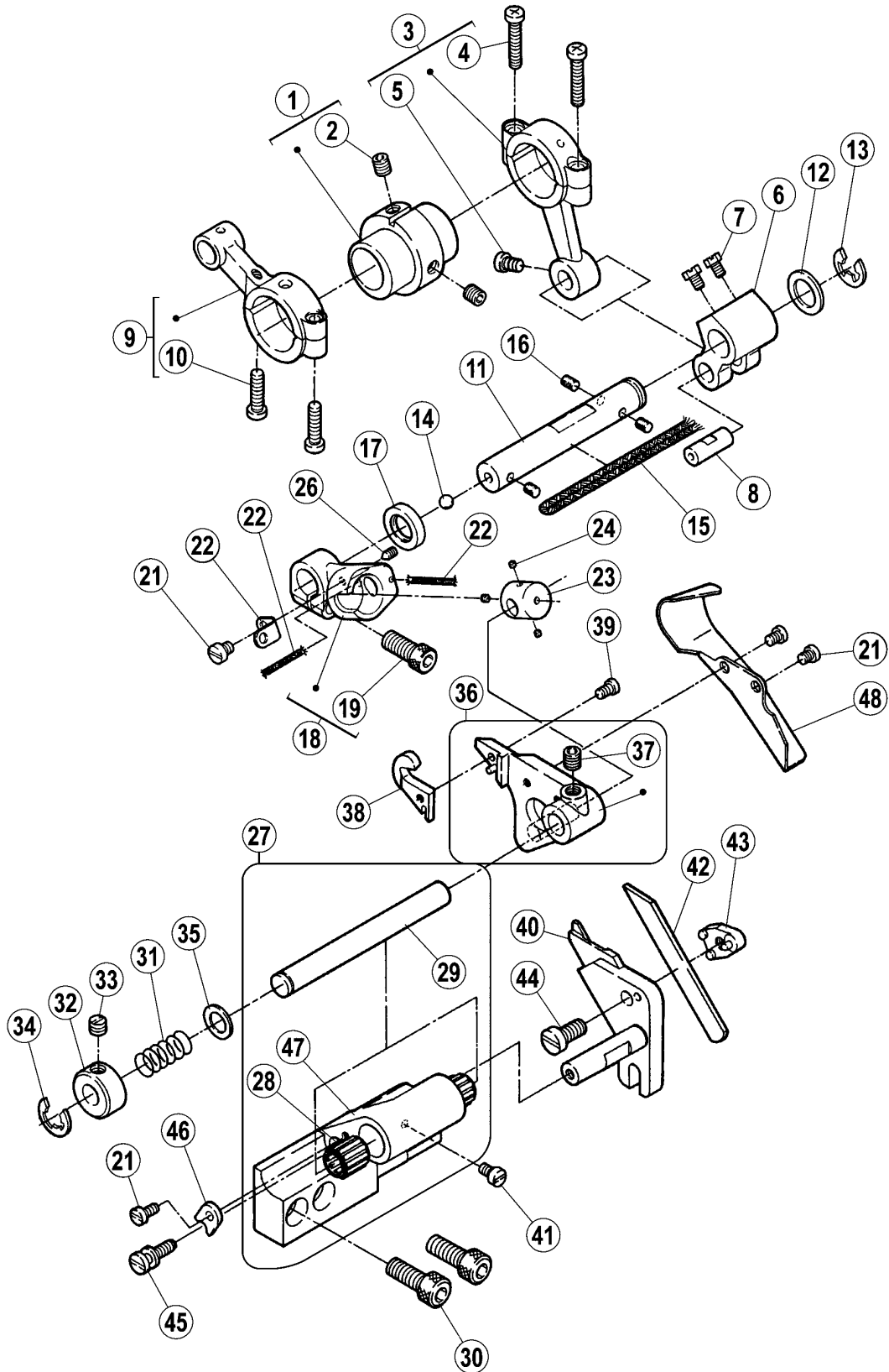
25. Parts For 2754A309 (2)



25. Parts For 2754A309 (2)

| No. | Parts No. | Description | QTY |
|-----|------------|----------------------|-----|
| 1 | 30117002 | needle guard (rear) | 1 |
| 2 | 3011700600 | lever assy | 1 |
| 3 | S05003 | bolt M5x10 | 1 |
| 4 | W02001 | wiasher 5 | 1 |
| 5 | S01002 | screw M4x6.5 | 1 |
| 6 | 30102037 | shaft | 1 |
| 7 | 30128035 | washer | 1 |
| 8 | H05013 | ring 6 | 1 |
| 9 | 30106003 | lever | 1 |
| 10 | S10002 | screw M5x5 | 1 |
| 11 | 30101036 | bracket | 1 |
| 12 | 301S11016 | screw | 1 |
| 13 | S01004 | screw M4x7.8 | 3 |
| 14 | 30117003 | needle guard (front) | 1 |
| 15 | S01012 | screw M2.5x4 | 1 |
| 16 | 30111013 | waste chute top (C) | 1 |
| 17 | 301S30019 | screw | 7 |
| 18 | 30112048 | bracket | 1 |
| 19 | 30103046 | bushing | 1 |
| 20 | 3011101400 | waste chute assy | 1 |
| 21 | 30111014 | waste chute top (A) | 1 |
| 22 | 30111015 | waste chute top (B) | 1 |
| 23 | 30128036 | washer | 4 |
| 24 | S01005 | screw M4x10 | 4 |

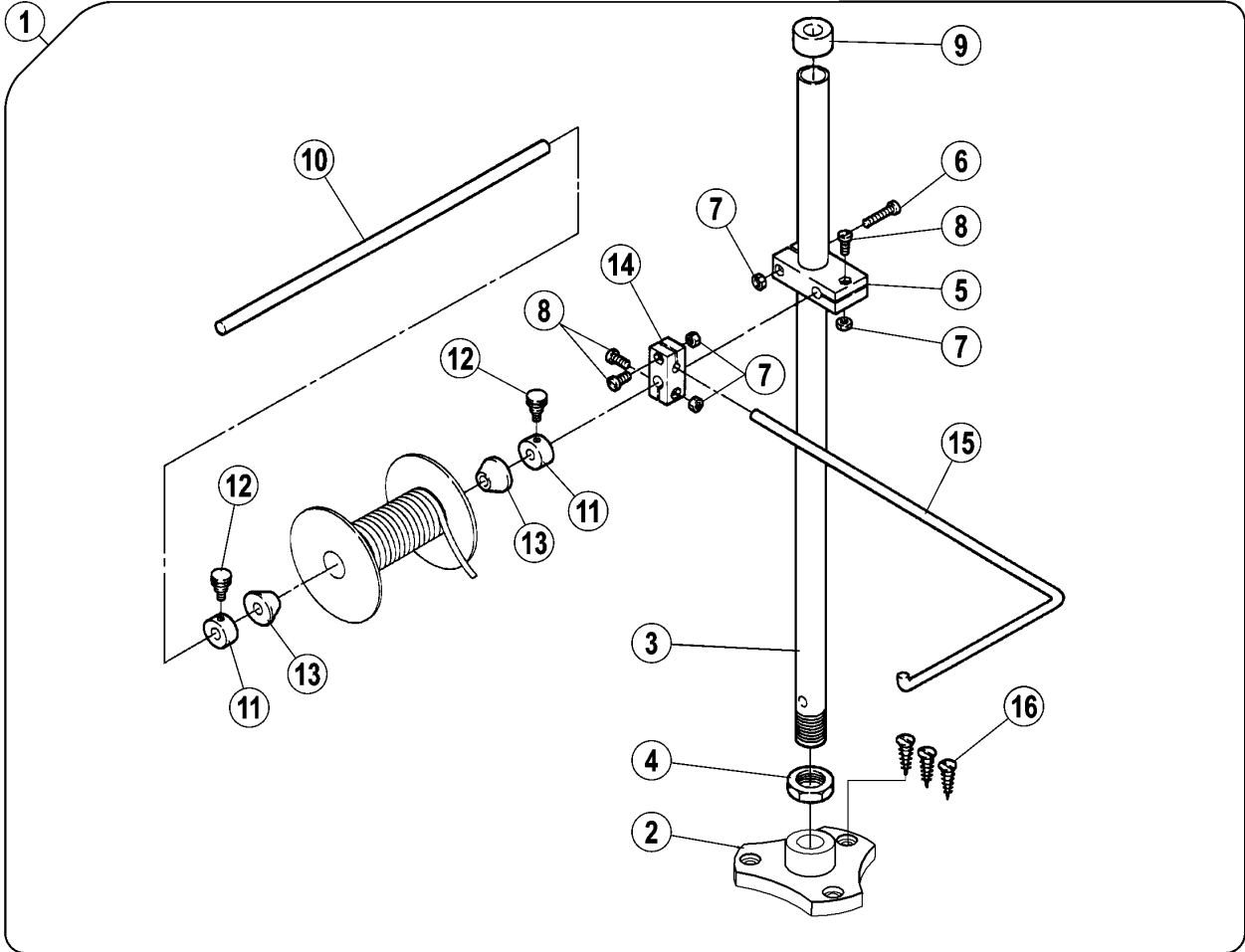
26. Parts For 2754A309 (3)



26. Parts For 2754A309 (3)

| No. | Parts No. | Description | QTY |
|-----|------------|------------------------|-----|
| 1 | 30110009 | eccentric assy | 1 |
| 2 | S10006 | screw M5x6 | 2 |
| 3 | 3010500600 | ccnnection assy | 1 |
| 4 | S01008 | screw M3.5x13 | 4 |
| 5 | S01010 | screw M4x8 | 1 |
| 6 | 30104007 | crank | 1 |
| 7 | 301S12001 | screw | 2 |
| 8 | 30126003 | pin | 1 |
| 9 | 30105009 | connection assy | 1 |
| 10 | S01008 | screw M3.5x13 | 2 |
| 11 | 30102038 | shaft | 1 |
| 12 | 30128008 | washer | 1 |
| 13 | H05001 | ring 10 | 1 |
| 14 | 30209009 | ball | 1 |
| 15 | 20523001 | oil wick | 1 |
| 16 | 30123001 | felt | 3 |
| 17 | 30122019 | oil seal | 1 |
| 18 | 30104028 | lever assy | 1 |
| 19 | S05004 | screw M5x14 | 1 |
| 21 | S01006 | screw M3x4.5 | 4 |
| 22 | 30123015 | oil wick | 2 |
| 23 | 30102039 | block | 1 |
| 24 | 30123008 | felt | 3 |
| 26 | S12002 | screw M3x4 | 1 |
| 27 | 3010104000 | bracket assy | 1 |
| 28 | 30103085 | needle bearing | 2 |
| 29 | 30102040 | shaft | 1 |
| 30 | S05019 | screw M6x16.3 | 2 |
| 31 | 30127022 | spring | 1 |
| 32 | 30108006 | collar | 1 |
| 33 | 209S14008 | screw | 1 |
| 34 | H05013 | ring | 1 |
| 35 | 30128026 | washer | 1 |
| 36 | 30101037 | upper knife lever assy | 1 |
| 37 | S10003 | screw M6x0.75x5 | 1 |
| 38 | 30119001 | upper knife | 1 |
| 39 | 301S11017 | screw | 1 |
| 40 | 30101039 | lower knife holder | 1 |
| 41 | 301S11025 | screw | 1 |
| 42 | 30119002 | lower knife | 1 |
| 43 | 30101038 | lower knife clamp | 1 |
| 44 | S01011 | screw M5x10 | 1 |
| 45 | 301S30021 | screw | 1 |
| 46 | 30112051 | guide | 1 |
| 47 | 30101040 | bracket assy | 1 |
| 48 | 30112050 | chip guard | 1 |

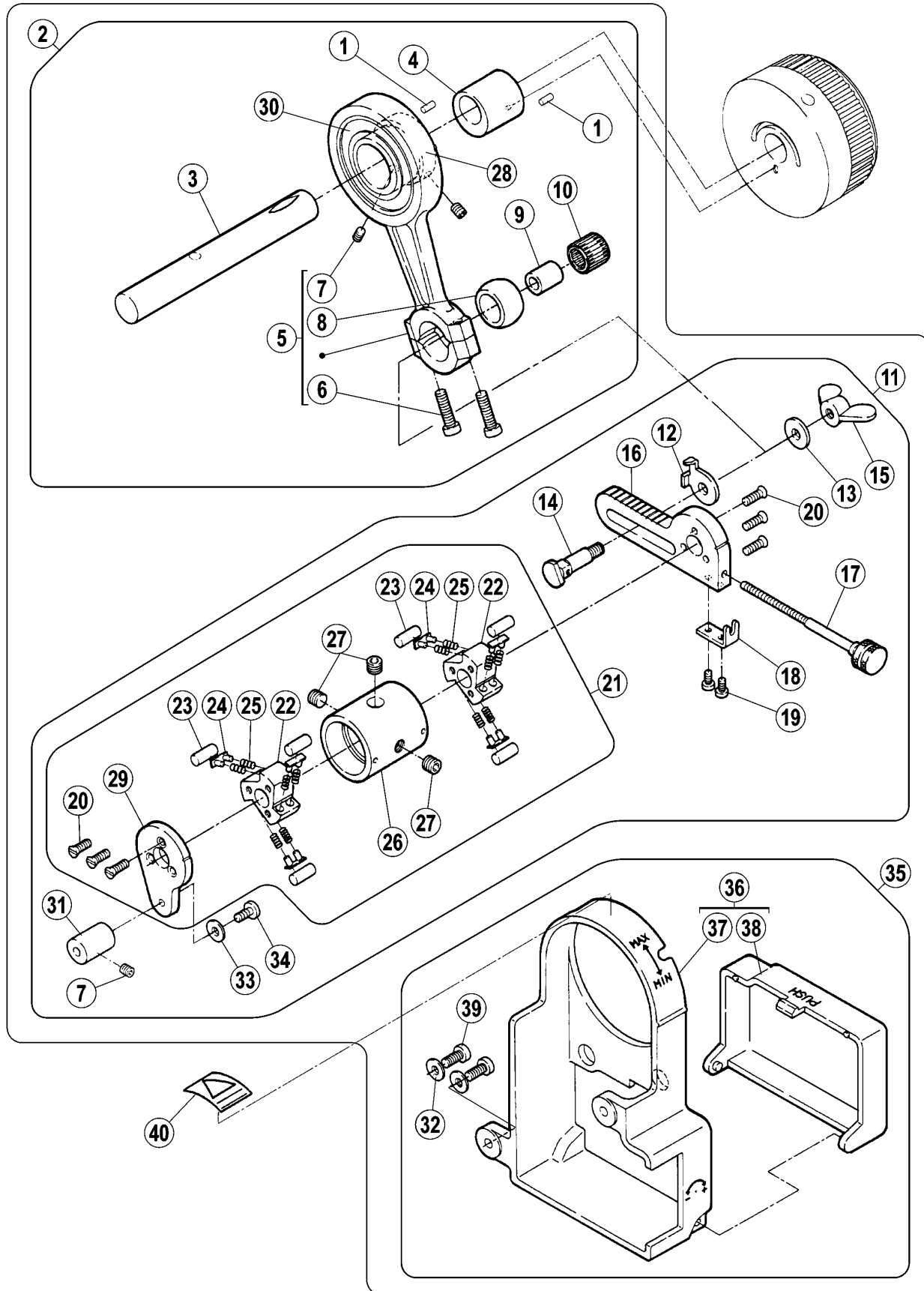
27. Parts For 2754A308/309 (1)



27. Parts For 2754A308/309 (1)

| No. | Parts No. | Description | QTY |
|-----|------------|-----------------|-----|
| 1 | 3010204100 | reel stand assy | 1 |
| 2 | 30103047 | bracket | 1 |
| 3 | 30102042 | rod | 1 |
| 4 | N02001 | nut M6x0.75 | 1 |
| 5 | 30111008 | bracket | 1 |
| 6 | S04003 | screw M4x25 | 1 |
| 7 | N01005 | nut M4 | 4 |
| 8 | S04004 | screw M4x15 | 3 |
| 9 | 30122027 | rod cap | 1 |
| 10 | 30102043 | shaft | 1 |
| 11 | 30103048 | collar | 2 |
| 12 | S01068 | screw M4x8 | 2 |
| 13 | 30103064 | reel guide | 2 |
| 14 | 30111009 | bracket | 1 |
| 15 | 30113020 | rod | 1 |
| 16 | 301S30022 | screw | 3 |

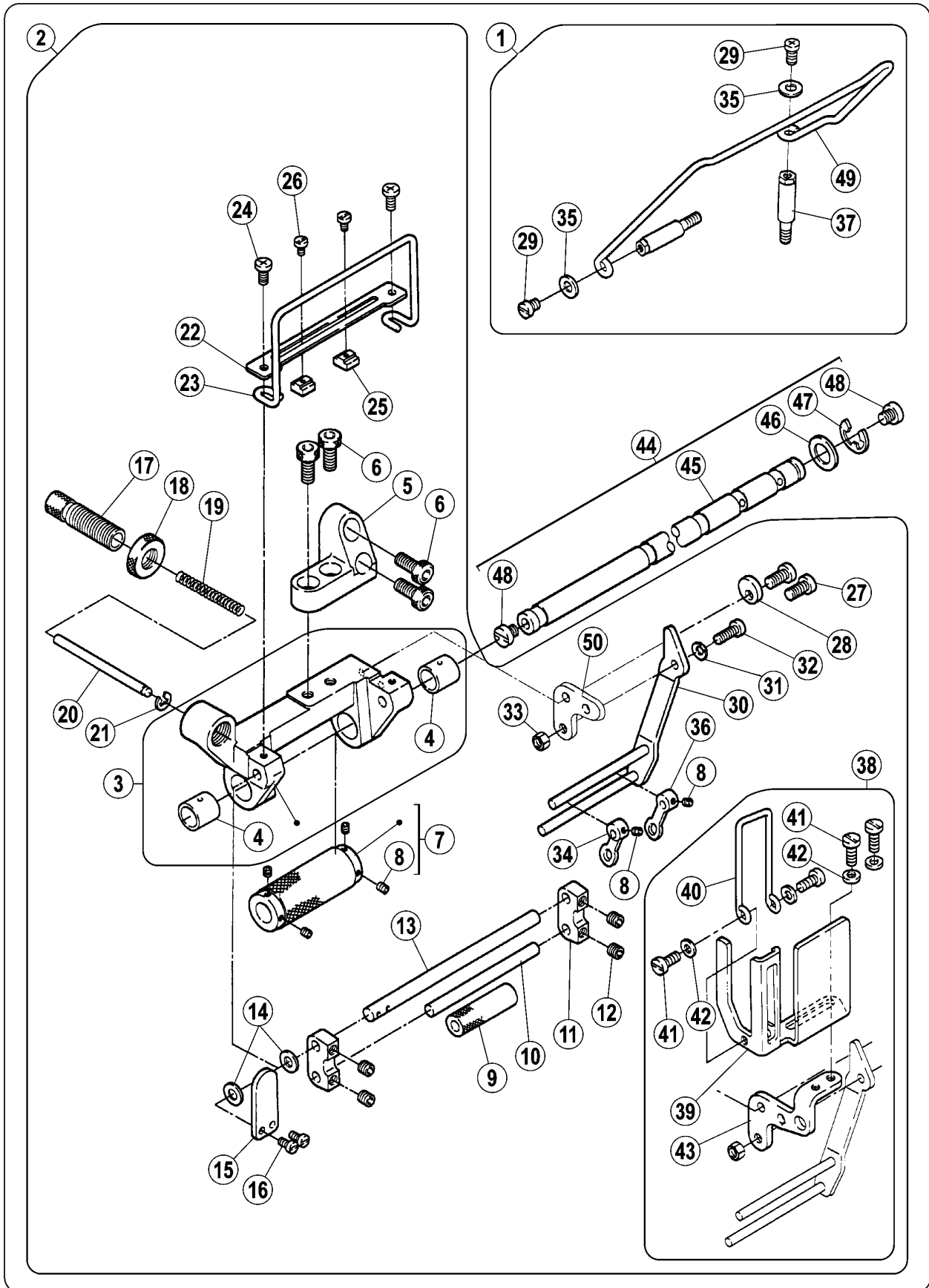
28. Parts For 2754A308/309 (2)



28. Parts For 2754A308/309 (2)

| No. | Parts No. | Description | QTY |
|-----|------------|---------------------------|-----|
| 1 | P03008 | pin 2x6 | 2 |
| 2 | 3010501500 | eccentric connection assy | 1 |
| 3 | 30103049 | shaft | 1 |
| 4 | 30103050 | eccentric assy | 1 |
| 5 | 3010501900 | connection assy | 1 |
| 6 | S04005 | screw M4x15.5 | 2 |
| 7 | S10002 | screw M5x5 | 3 |
| 8 | 30103051 | ball stud | 1 |
| 9 | 30103052 | bushing | 1 |
| 10 | B07014 | needle bearing 10x13x13 | 1 |
| 11 | 3010104100 | crank assy | 1 |
| 12 | 30112052 | indicator | 1 |
| 13 | 30128027 | washer | 1 |
| 14 | 301S20012 | pin | 1 |
| 15 | 301S16009 | butterfly nut | 1 |
| 16 | 30101041 | crank | 1 |
| 17 | 301 S30023 | screw | 1 |
| 18 | 30112053 | set plate | 1 |
| 19 | S01006 | screw M3x5 | 2 |
| 20 | 301S11019 | scrcw | 6 |
| 21 | 3010305300 | clutch assy | 1 |
| 22 | 30101042 | clutch | 2 |
| 23 | 30126011 | pin | 6 |
| 24 | 30112054 | guide assy | 6 |
| 25 | 30127023 | spring | 12 |
| 26 | 30103053 | sleeve | 1 |
| 27 | S10003 | screw M6x0.75x5 | 3 |
| 28 | 30103054 | bushing | 1 |
| 29 | 30101043 | stop plate | 1 |
| 30 | B04006 | beadng 6028z | 1 |
| 31 | 30126012 | pin | 1 |
| 32 | W01001 | washer 4 | 2 |
| 33 | W01001 | washer 4 | 1 |
| 34 | 201S11016 | screw | 1 |
| 35 | 3011101700 | cover assy | 1 |
| 36 | 3011101600 | md cover assy | 1 |
| 37 | 30111016 | md cover | 1 |
| 38 | 30111017 | cover | 1 |
| 39 | S01005 | screw M4x10 | 2 |
| 40 | 30137006 | sticker | 1 |

29. Parts For 2754A308/309 (3)

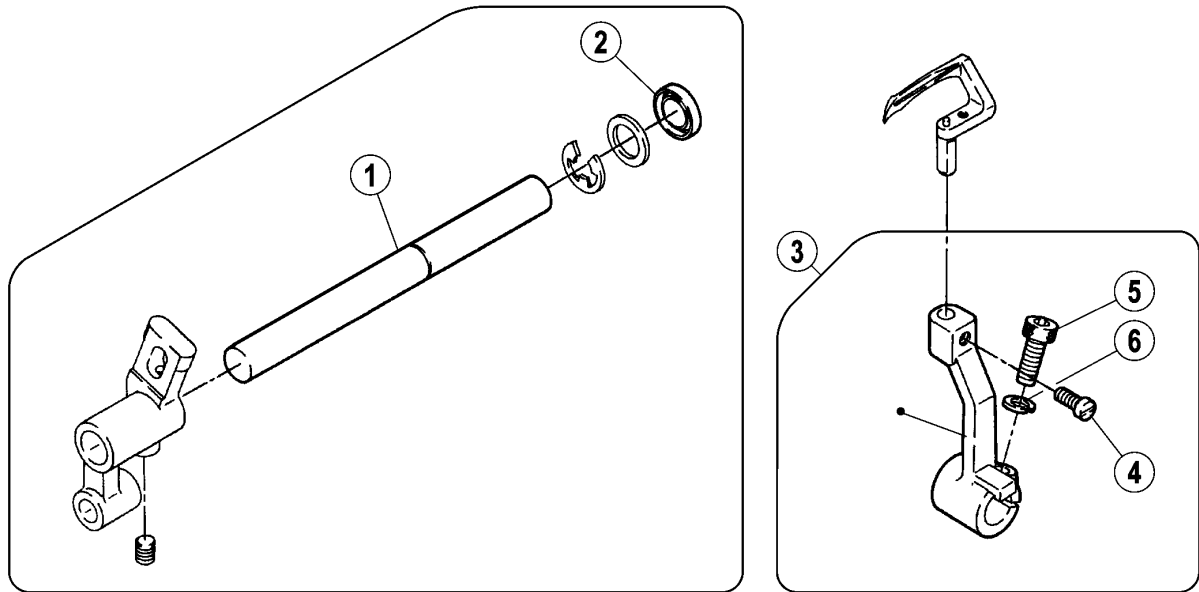


29. Parts For 2754A308/309 (3)

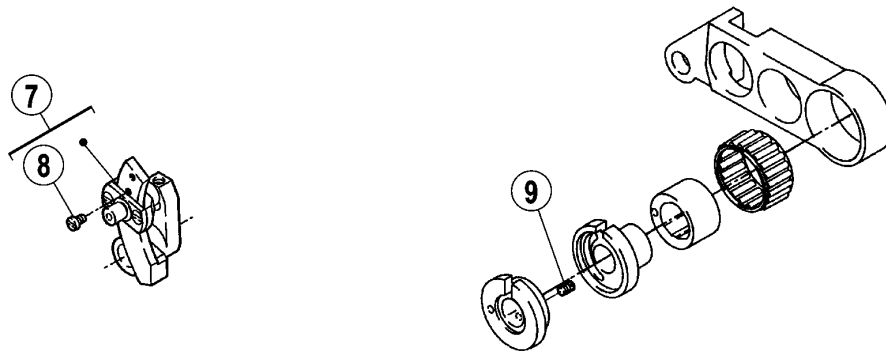
| No. | Parts No. | Description | QTY |
|-----|------------|---------------------------|-----|
| 1 | 3010304400 | lace guide assy | 1 |
| 2 | 3010104500 | elastic feed base assy | 1 |
| 3 | 300144 | bracket assy | 1 |
| 4 | 30103055 | bushing | 2 |
| 5 | 300143 | bracket | 1 |
| 6 | S05019 | bolt M6x16.3 | 4 |
| 7 | 3010305700 | roller assy | 1 |
| 8 | S10005 | screw M3x3 | 6 |
| 9 | 30103059 | roller | 1 |
| 10 | 30102045 | shaft | 1 |
| 11 | 30109018 | bracket | 2 |
| 12 | S10002 | screw M5x5 | 4 |
| 13 | 30102046 | shaft | 1 |
| 14 | W01003 | washer 6 | 2 |
| 15 | 30112059 | lever | 1 |
| 16 | S01015 | screw M3x5 | 2 |
| 17 | 301S30027 | screw | 1 |
| 18 | 301S16011 | nut | 1 |
| 19 | 30127024 | spring | 1 |
| 20 | 30126013 | shaft | 1 |
| 21 | H05003 | ring 5 | 1 |
| 22 | 30112055 | guide | 1 |
| 23 | 30113022 | lace guide | 1 |
| 24 | S01002 | screw M4x6.5 | 2 |
| 25 | 301S16010 | guide | 2 |
| 26 | 301S11018 | screw | 2 |
| 27 | S01004 | screw M4x7.8 | 2 |
| 28 | 30128028 | stopper | 1 |
| 29 | S01004 | screw M4x7.8 | 2 |
| 30 | 3011205600 | bracket | 1 |
| 31 | 30128020 | spring | 1 |
| 32 | S05049 | bolt M4x10 | 1 |
| 33 | N01001 | nut M4 | 1 |
| 34 | 30105017 | lace guide | 1 |
| 35 | W01004 | washer | 2 |
| 36 | 30105018 | lace guide | 1 |
| 37 | 301S30025 | screw | 2 |
| 38 | 3011208300 | thread take-up guard assy | 1 |
| 39 | 30112083 | thread take-up guard | 1 |
| 40 | 30112084 | finger guard | 1 |
| 41 | S01001 | screw M4x7 | 3 |
| 42 | W01001 | washer 4 | 3 |
| 43 | 30118087 | bracket | 1 |
| 44 | 3010304400 | shaft assy | 1 |
| 45 | 30103044 | shaft | 1 |
| 46 | 30128008 | washer | 1 |
| 47 | H05001 | ring 10 | 1 |
| 48 | 301S11020 | screw | 2 |
| 49 | 30113021 | lace guide | 1 |
| 50 | 30112058 | bracket | 1 |

30. Parts For 2754A300

LOOPER MECHANISM



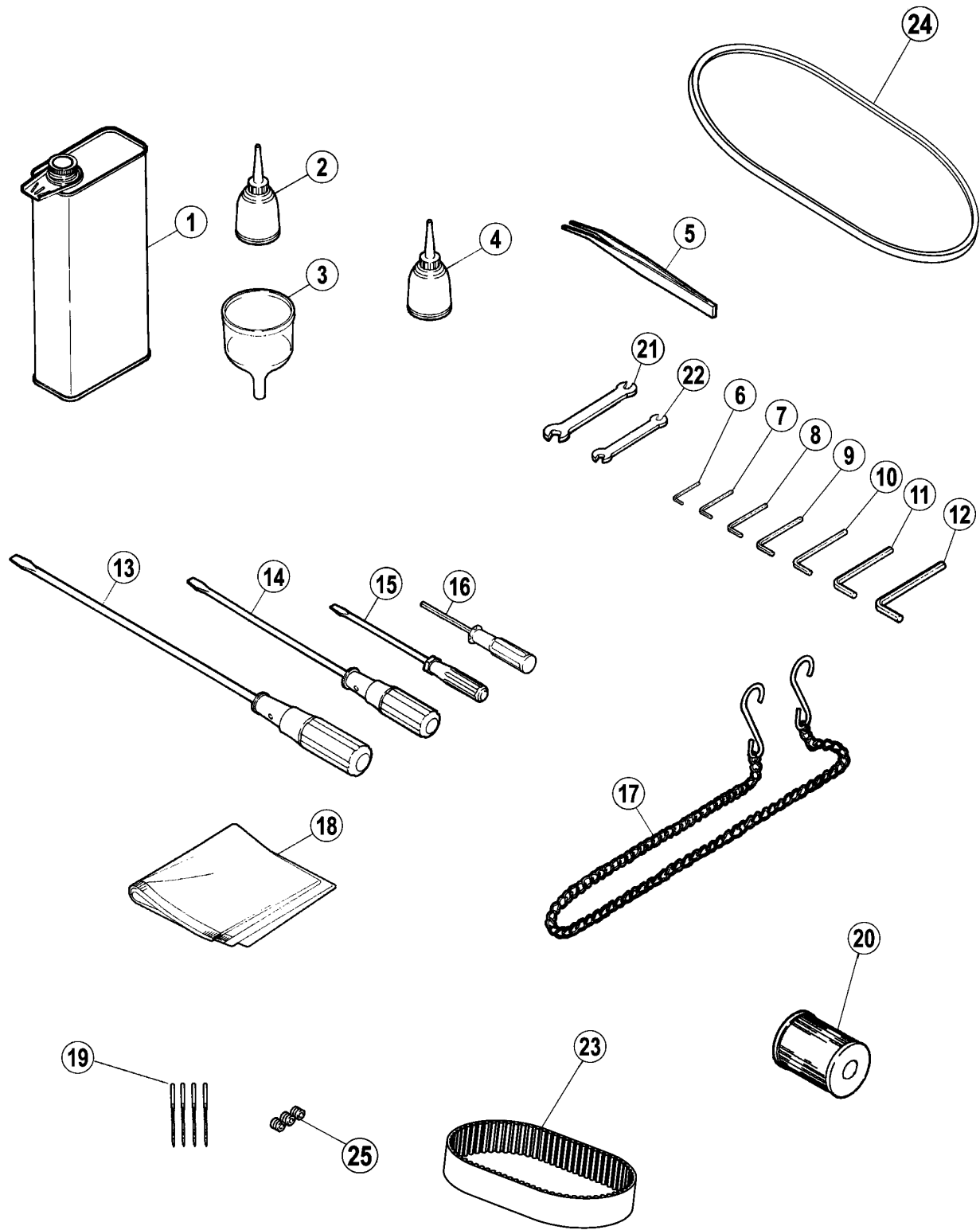
FEED MECHANISM



30. Parts For 2754A300

| No. | Parts No. | Description | QTY |
|-----|-----------|--------------------|-----|
| 1 | 30102051 | shaft | 1 |
| 2 | 30122008 | oil seal | 1 |
| 3 | 30104012 | looper holder assy | 1 |
| 4 | S01004 | screw | 1 |
| 5 | S05004 | screw | 1 |
| 6 | W02001 | washer | 1 |
| 7 | 30104014 | crank | 1 |
| 8 | S01012 | screw | 1 |
| 9 | 301S30029 | screw | 1 |

31. Accessories Components



31. Accessories Comonents

| No. | Paris No. | Description | QTY |
|-----|-----------|--------------------------|-----|
| 1 | 20131037 | oil container | 1 |
| 2 | 20131038 | oiler | 1 |
| 3 | 20131039 | oil funnel | 1 |
| 4 | 20131038 | silicone container | 1 |
| 5 | 20131051 | tweezers | 1 |
| 6 | 30131007 | allen key / 1.5mm | 1 |
| 7 | 20131046 | allen key / 2mm | 1 |
| 8 | 30131010 | allen key / 3mm | 1 |
| 9 | 30131012 | allen key / 4mm | 1 |
| 10 | 20131047 | allen key / 5mm | 1 |
| 11 | 20131056 | allen key / 6mm | 1 |
| 12 | 30131009 | allen koy / 8m | 1 |
| 13 | 10131002 | screwdriver (large) | 1 |
| 14 | 10131003 | screwdriver (medium) | 1 |
| 15 | 10131004 | screwdriver (small) | 1 |
| 16 | 20131044 | allen key driver (1.5mm) | 1 |
| 17 | 30131018 | chain | 1 |
| 18 | 10131005 | dust cover | 1 |
| 19 | 30117001 | needle | 3 |
| 20 | 20136001 | filter element | 1 |
| 21 | 30131005 | wrench / (7mm-9mm) | 1 |
| 22 | 30131006 | wrench / (8mm 10mm) | 1 |
| 23 | 30135005 | small timing belt | 1 |
| 24 | 30135004 | V-belt | 1 |
| 25 | S10005 | screw | 3 |

GAUGE PARTS LIST (1)

| MACHINE TYPE /SPEC. | GAUGE | NEEDLE HOLDER | NEEDLE PLATE | MAIN FEED DOG | DIFF. FEED DOG | PRESSER FOOT | LOOPER | NEEDLE GUARD | | SPREADER | NEEDLE |
|---------------------|-------|---------------|--------------|---------------|----------------|--------------|------------|--------------|----------|---------------|------------|
| | | | | | | | | FRONT | REAR | | |
| 2754A331 | 356 | 30134001 | 30115002 | 3011400700 | 3011601300 | 3011700900 | 3011700900 | 30117002 | 30117005 | 3561-06-75/11 | |
| | 364 | 30134002 | 30115003 | | | | | | | | 3011601400 |
| 2754A303 | 356 | 30134001 | 30115006 | 30114006 | 30114005 | 30116005 | 3011700900 | 30117002 | 30117005 | 3561-06-75/11 | |
| | 364 | 30134002 | 30115007 | | | | | | | | 30116006 |



GAUGE PARTS LIST (2)

| MACHINE TYPE /SPEC. | GAUGE | NEEDLE HOLDER | NEEDLE PLATE | MAIN FEED DOG | DIFF. FEED DOG | PRESSER FOOT | LOOPER | NEEDLE GUARD | | SPREADER | NEEDLE |
|---------------------|-------|---------------|--------------|---------------|----------------|--------------|------------|--------------|----------|---------------|--------|
| | | | | | | | | FRONT | REAR | | |
| 2754A313 | 356 | 30134001 | 30115002 | 3011400700 | 3011400700 | 3011601300 | 3011700900 | 30117002 | 30117005 | 3561-06-75/11 | |
| | 364 | 30134002 | 30115003 | | | 3011601400 | | | | | |
| 2754A309 | 356 | 30134001 | 30115004 | 30114004 | 30114003 | 30116003 | 3011700900 | 30117002 | 30117005 | 3561-06-75/11 | |
| | 364 | 30134002 | 30115005 | | | 30116004 | | | | | |
| 2754A308 | 356 | 30134001 | 30115002 | 3011400700 | 3011400700 | 30116003 | 3011700900 | 30117002 | 30117005 | 3561-06-75/11 | |
| | 364 | 30134002 | 30115003 | | | 30116004 | | | | | |
| 2754A311 | 356 | 30134001 | 30115004 | 3011400700 | 3011400700 | 3011601300 | 3011700900 | 30117002 | 30117005 | 3561-06-75/11 | |
| | 364 | 30134002 | 30115005 | | | 3011601300 | | | | | |
| 2754A300-0xxH | 356 | 30134003 | 30115008 | 3011400700 | 3011400700 | 30116007 | 3011700900 | 30117002 | 30117005 | 3561-06-75/11 | |
| | 364 | 30134005 | 30115011 | | | 30116017 | | | | | |

