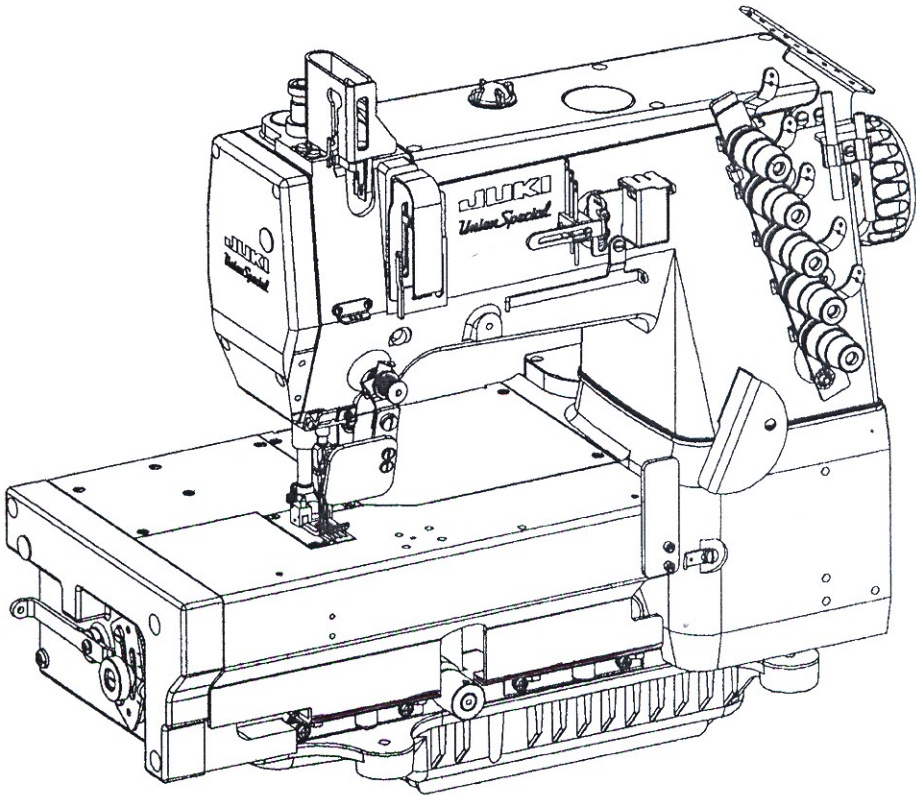




JUKI

Union Special

ILLUSTRATED PARTS MANUAL



FS300 SERIES, PLAIN AND DIFFERENTIAL FEED,
HIGH SPEED FLAT BED MACHINES

MANUAL NO. PT9800
FOR STYLES

FS322C01	FS335E42
FS332C01	FS322H01
FS322E12	FS332H01
FS332E12	FS322L01
FS335E41	FS332L21

USE IN CONJUNCTION WITH MACHINE SERIAL NUMBER PREFIX (BG) AND LATER

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IDENTIFICATION OF MACHINES

Each UNION SPECIAL machine is identified by a style number, which is stamped into the style plate affixed to the middle of the machine under the tension assembly. The serial number is stamped into the serial number plate affixed to the right rear base of the machine.

STYLE OF MACHINES

- FS322C01- COLLARETTE - Two or three needle, bottom coverstitch. Typical application - For attaching flat of ribbed knit split tube borders to knit garments. Seam specification for two needle 406BSb-1, three needle 407BSb-1. Standard gauges for two needle 32, (1/8", 3.2mm), 40, (5/32", 4.0mm), 48, (3/16", 4.8mm), for three needle 48, (3/16", 4.8mm), 56, (7/32", 5.6mm), 64, (1/4", 6.4mm). Maximum recommended speed, depending on application is up to 6500 R.P.M.
- FS332C01- COLLARETTE - Same as style FS322C01 except top and bottom coverstitch. Seam specification for two needle 602BSb-1, for three needle 605BSb-1.
- FS322E12- ELASTIC - Two or three needle, bottom coverstitch with fabric trimmer. Typical application - For attaching elastic to briefs or lace to lingerie. Seam specification for two needle 406LSa-1, for three needle 407LSa-1. Standard gauges for two needle 32, (1/8", 3.2mm), 40, (5/32", 4.0mm), 48, (3/16", 4.8mm), for three needle 48, (3/16", 4.8mm), 56, (7/32", 5.6mm), 64, (1/4", 6.4mm). Maximum recommended speed, depending on application is up to 6500 R.P.M.
- FS332E12- ELASTIC - Same as Style FS322E12 except top and bottom coverstitch with fabric trimmer. Seam specification for two needle 602LSa-1, for three needle 605LSa-1.
- FS335E41- ELASTIC - Three needle, top and bottom coverstitch, differential feed and rear puller with tooth roller. Typical application - for attaching tunnel elastic to briefs or lace to lingerie. Seam specification 605EFg-1. Standard gauges 56, (7/32", 5.6mm), 64, (1/4", 6.4mm). Maximum recommended speed, depending on application is up to 6000 R.P.M.
- FS335E42- ELASTIC - Same as style FS335E41 except puller with smooth roller.
- FS322H01- HEMMING - Two of three needle, bottom coverstitch. Typical application - for hemming on light to medium weight knit fabrics. Seam specifications for two needle 406EFa-1 (inv.), for three needle 407EFa-1 (inv.). Standard gauge for two needle 40, (5/32" 4.0mm), 48, (3/16", 4.8mm), for three needle 48, (3/16", 4.8mm), 56, (7/32", 5.6mm), 64, (1/4", 6.4mm). Maximum recommended speed, depending on application is up to 6500 R.P.M.
- FS332H01- HEMMING - Same as style FS322H01 except top and bottom coverstitch. Seam specification for two needle 602EFa-1 (inv.), for three needle 605EFa-1 (inv.).
- FS332L01- LAP SEAMING - Two or three needle, top and bottom coverstitch, tandem differential feed. Typical application - for general seaming on fleece and knit garments. Seam specification for two needle 602LSa-1, for three needle 605LSa-1. Standard gauges for two needle 32, (1/8", 3.2mm), 40, (5/32", 4.0mm), for three needle 48, (3/16" 4.8mm), 56, (7/32", 5.6mm), 64, (1/4", 6.4mm). Maximum recommended speed, depending on application is up to 6500 R.P.M.
- FS332L21- LAP SEAMING - Same as style FS332L01 except three needle, off set differential feeds. Standard gauges 56, (7/32", 5.6mm), 64, (1/4" 6.4mm).



ILLUSTRATIONS

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

Numbers in the first column are reference numbers only, and merely indicate the position of the part in the illustration. The reference number 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 descriptions under the description of the main sub-assembly. As an example refer to the following text.

5.	50366B	Needle Thread Strike-Off Assembly	1
6.	50358V	Needle Thread Strike-Off	1
7.	50370F	Thread Strike-Off Component	1
8.	SS7060310SP	Screw, for plate strike-off	1

When a part is common to all machines covered in this manual, no specific usage will be mentioned in the description. However, when the parts for the various machines are not the same, the specific usage will be mentioned in the description and, if necessary, the difference will be shown in the illustration.

*Ref. No. showing no Part No. is for location only. Part is not for sale separately.

A numerical index of all the parts shown in this manual is located at the back. This will facilitate locating the illustration and description when only a part number is known.

IDENTIFYING PARTS

Where construction permits, each part is stamped with its part number. On some of the smaller parts and on those where construction does not permit, an identification letter is stamped in to distinguish the part from similar ones.

PLEASE NOTE: Part numbers represent the same part, regardless of which manual they appear. On all orders

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 the largest diameter of the blade measured between the shank and the eye. Collectively, the type number and size number represent the complete symbol which is given on the label of all needles packed and sold by Union Special.

<u>TYPE</u>	<u>DESCRIPTION</u>
-------------	--------------------

128GBS	Short, double groove, struck groove, ball eye, spotted, ball point, chromium plated- Sizes available 065/025, 070/027, 075/029, 080/032, 090/036.
--------	--

When changing the needle, make sure it is fully inserted in the needle holder before the screw is tightened.

When ordering needles, please use the complete type and size numbers as printed on the package to ensure prompt and accurate processing of your order. A complete order should read as follows: "100 needles, type 128 GBS, size 075/029".



SAFETY RULES

1. Before putting the machines 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 machines described in this instruction manual are 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 EC Council Directives (89/392/EEC, Annex II B).

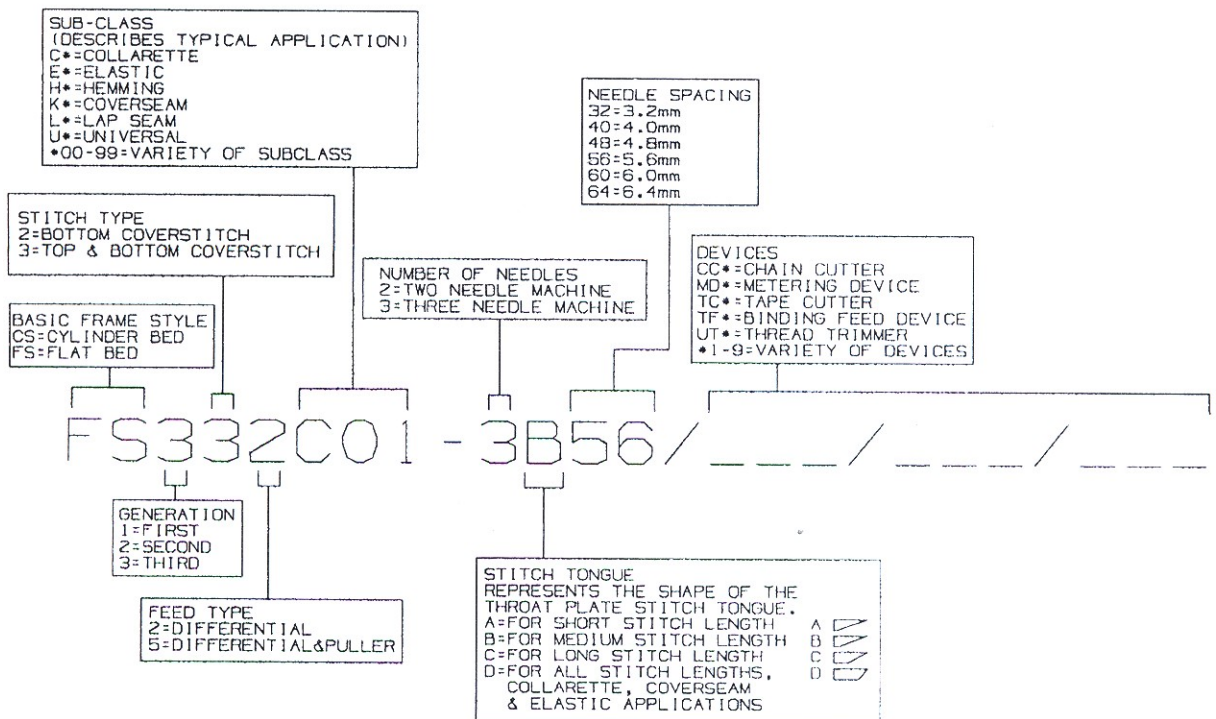
Each machine is only allowed to be used as foreseen. The foreseen use of the particular machine is described in paragraph "STYLES OF MACHINES" of this instruction manual. Another use, going beyond the description, is not as foreseen.

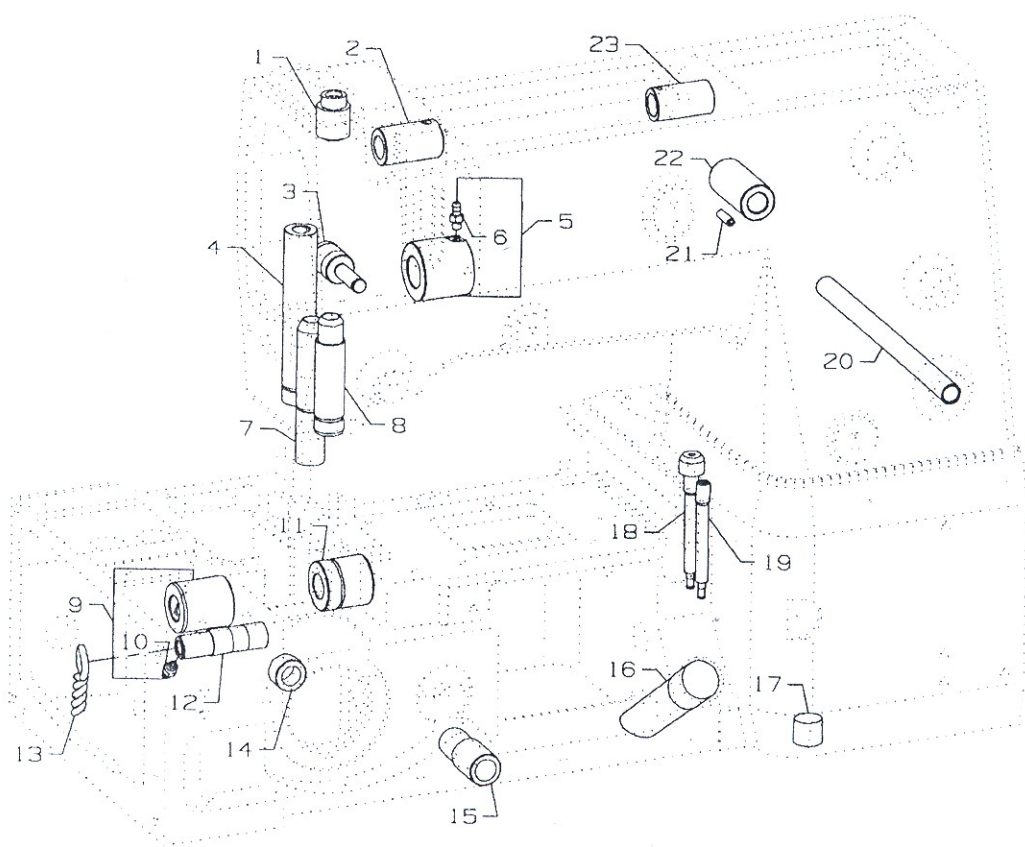
4. All safety devices must be in position when the machine is ready for work or in operation. Operation of the machine without the appertaining safety devices is prohibited.
5. Wear safety glasses.
6. In case of machine conversions and changes all valid safety rules must be considered. Conversions and changes are made at your own risk.
7. The warning hints in the instructions are marked with one of these two symbols:



8. When doing the following the machine has to be disconnected from the power supply by turning off the main switch or by pulling out the main plug:
 - 8.1 When threading needle(s), looper, spreader etc.
 - 8.2 When replacing any parts such as needle(s), presser foot, throat plate, looper, spreader, feed dog, needle guard, folder, fabric guide etc.
 - 8.3 When leaving the workplace and when the workplace is unattended.
 - 8.4 When doing maintenance work.
 - 8.5 When using clutch motors without actuation lock, wait until the motor is stopped totally.
9. Maintenance, repair and conversion work (see item 8) must be done only by trained technicians or special skilled personnel under consideration of the instructions.
10. Any work on the electrical equipment must be done by an electrician or under direction and supervision of special skilled personnel.
11. Work on parts and equipment under electrical power is not permitted. Permissible exceptions are described in the applicable sections of standard sheet DIN VDE 0105.
12. Before doing maintenance and repair work on the pneumatic equipment, the machine has to be disconnected from the compressed air supply. In case of existing residual air pressure, after disconnecting from compressed air supply (i.e. pneumatic equipment with air tank), the pressure has to be removed by bleeding.

FS300 SERIES BUILDING BLOCK STYLE DESIGNATION SYSTEM

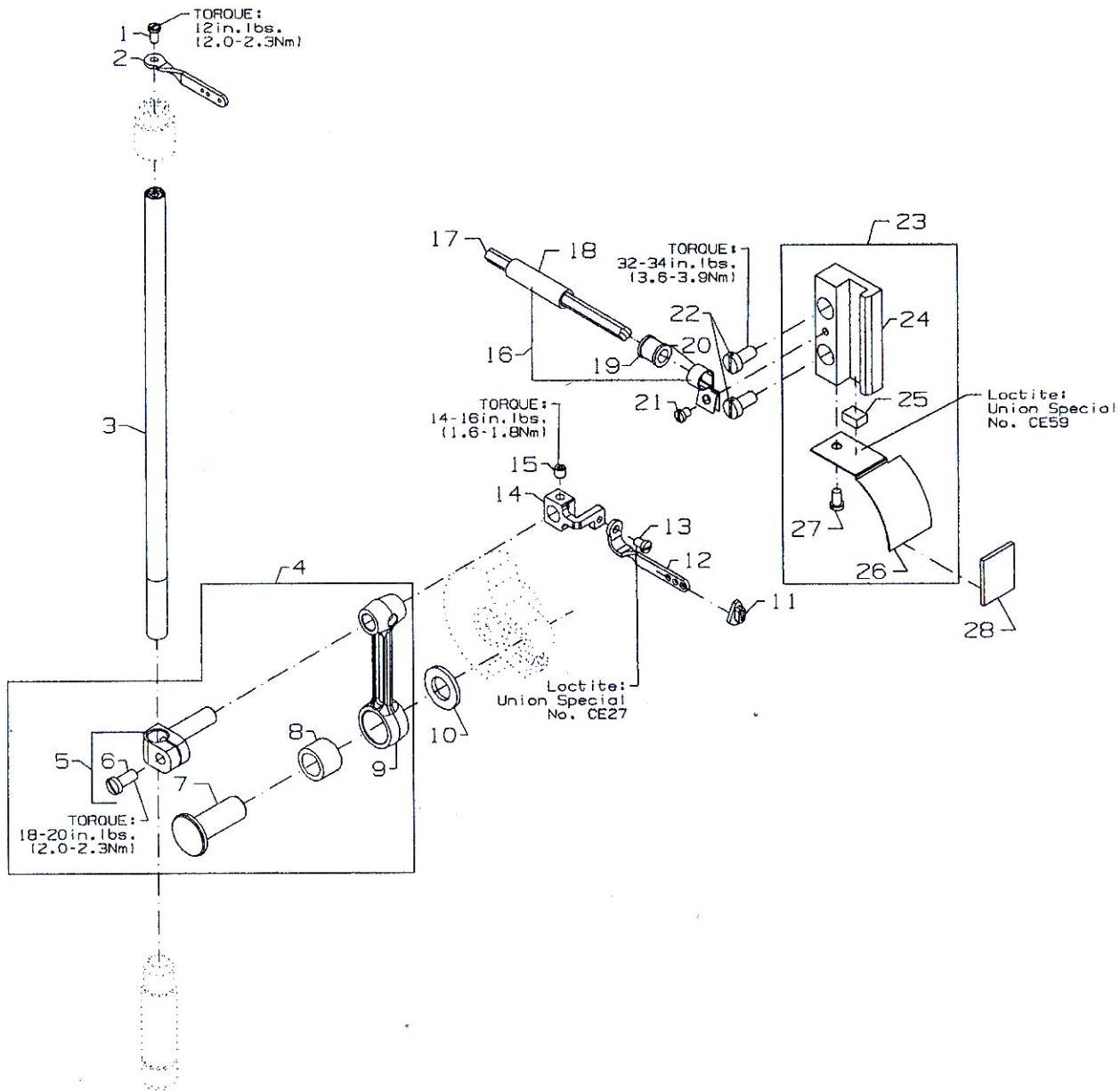




BUSHINGS

Ref. No.	Part No.	Description	Amt. Req.
1.	50354J	Bushing, for needle bar, upper	1
2.	50347F	Bushing, for spreader, front	1
3.	50332U	Pin, for front lifter lever	1
4.	50347L	Bushing, for spreader drive	1
5.	50344BU	Bushing, front	1
6.	SQ1110401MZ	Fitting	1
7.	50330CZ	Bushing, for presser bar	1
8.	50354H	Bushing, for needle bar, lower	1
9.	50344BE	Bushing, for lower mainshaft, left	1
10.	SQ1110401MZ	Fitting	1
11.	50344BF	Bushing, for lower mainshaft, right	1
12.	50344BC	Bushing, for needle lever	1
13.	CL21A	Oil Wick	1
14.	50344E	Bushing	1
15.	35036AB	Stitch Regulator Bushing	1
16.	50393GE	Oil Sight Gauge	1
17.	22571L	Screw, for drain plug	1
18.	50393EY	Fitting, filter	1
19.	50393FU	Fitting, oil tube	1
20.	50392AB	Bushing, for tension release	1
21.	PS0400142KH	Pin	1
22.	50381E	Bushing, for lifter lever, back	1
23.	50347E	Bushing, for spreader, rear	1

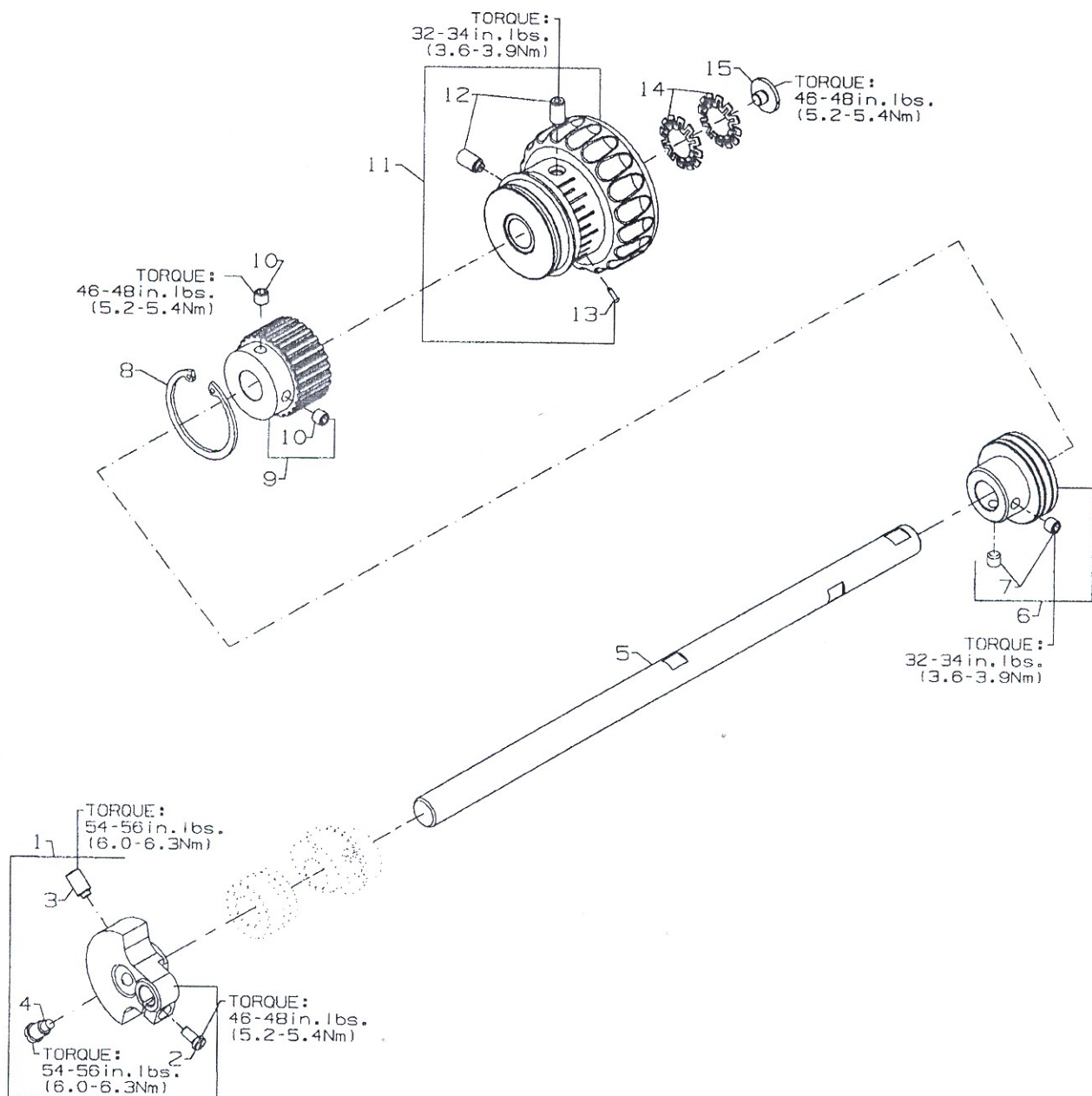




NEEDLE BAR

Ref. No.	Part No.	Description	Amt. Req.
1.	SS4080620TP	Screw	1
2.	50323P	Needle Bar Eyelet	1
3.	50317B	Needle Bar	1
4.	50345W	Connecting Rod Assembly	1
5.	50355AM	Needle Bar Clamp	1
6.	SS7111120TP	Screw	1
7.	50352	Pivot Pin	1
8.	661-259B	Needle Bearing Cage	1
9.	50355AN	Connecting Rod	1
10.	50351A	Washer	1
11.	50393JP	Eyelet Seal	1
12.	50358X	Needle Thread Eyelet	1
13.	SS7080520SP	Screw	1
-	CE27	Loctite Adhesive, (not shown), for screw	-
14.	50354F	Slide Block	1
-	CE63	Three Bond Adhesive, (not shown), for slide block	-
15.	SS8110422TP	Screw	1
16.	29476TC	Oil Tube Assembly	1
17.	CQ25220000	Cable	1
18.	50393JY	Oil Tube	1
19.	50393JZ	Oil Tube	1
20.	50393JW	Hose Clamp	1
21.	SS6090440SP	Screw, for support bracket	1
22.	SS6121010SP	Screw	2
23.	50354G	Slide Block Guide	1
24.	50393HS	Sponge	1
-	CE59	Loctite Adhesive, (not shown), for sponge	-
25.	50394AF	Slide Block Guide Cover	1
26.	SS6090620SP	Screw	1

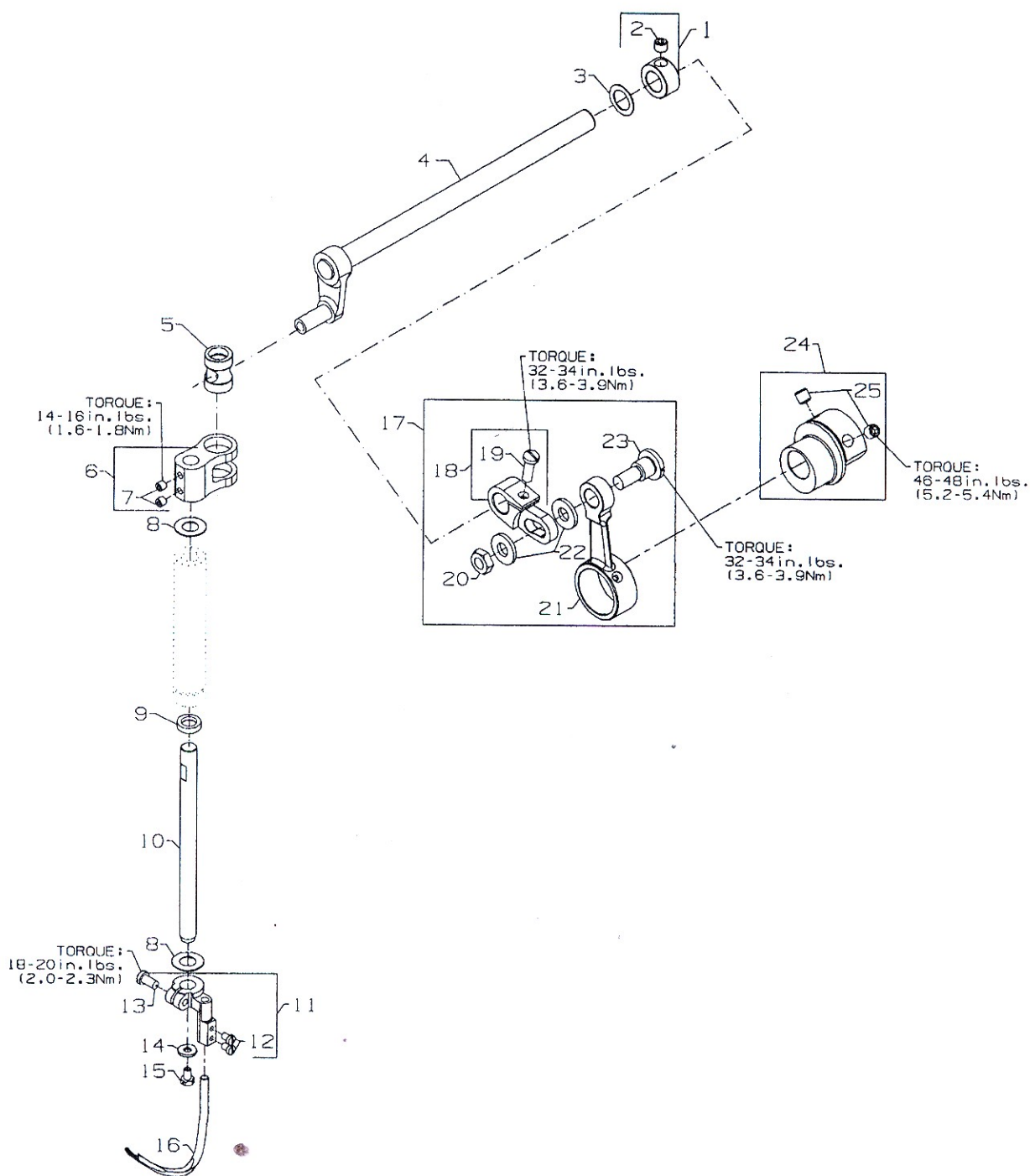




UPPER MAIN SHAFT

Ref. No.	Part No.	Description	Amt. Req.
1.	50391	Counter Weight	1
2.	SS7111120TP	Screw, for counter weight	1
3.	SS8681412TP	Screw, for counter weight	1
4.	SS7681410TP	Screw, for counter weight	1
5.	50322AF	Upper Main Shaft	1
6.	50335BD	Bearing Adapter Assembly	1
7.	SS8660612TP	Screw, for bearing adapter	2
8.	661-262	Retaining Ring	1
9.	50342BE	Sprocket, for upper main shaft	1
10.	SS8661012TP	Set Screw, for sprocket	2
11.	50321M	Handwheel	1
12.	SS8681412TP	Set Screw, for handwheel	2
13.	660-1043	Tack Pin, for handwheel	1
14.	661-261	Load Ring, for lower main shaft	2
15.	SS7660520SP	Screw, for handwheel preload	1

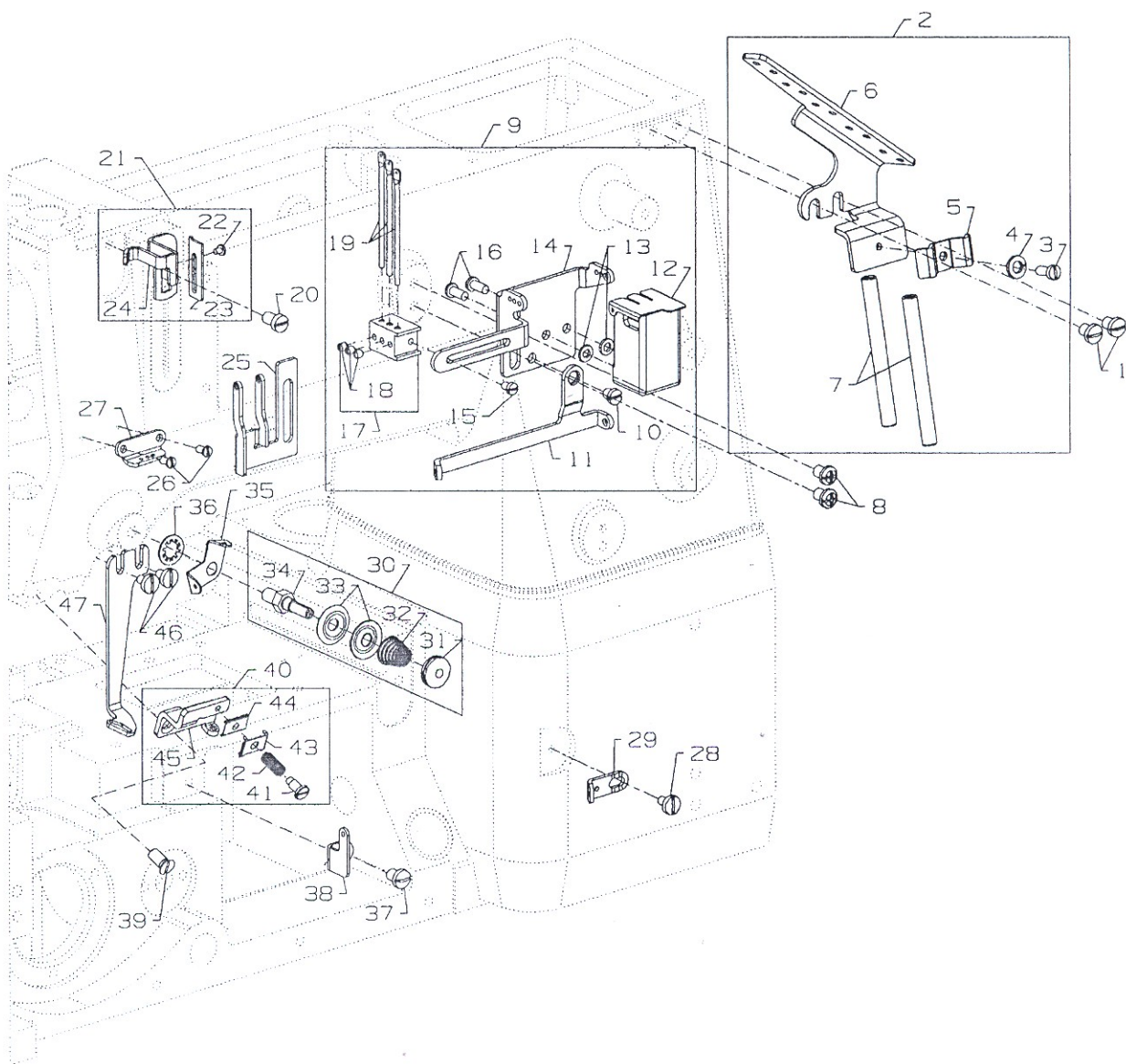




SPREADER

Ref. No.	Part No.	Description	Amt. Req.
1.	50335AW	Collar, for spreader shaft	1
2.	SS8660512TP	Set Screw	1
3.	96162B	Washer	1
4.	50360B	Crankshaft, for spreader assembly	1
5.	50347J	Pin, for spreader rocker	1
6.	50347C	Lever, for spreader holder shaft	1
7.	SS8110422TP	Screw	2
8.	61351C	Washer	2
9.	660-739	Oil Seal	1
10.	50347G	Shaft, for spreader, vertical	1
11.	50346A	Spreader Holder	1
12.	SS7080510TP	Screw	2
13.	SS7110910TP	Screw	1
14.	53678N	Washer	1
15.	SS9090640SP	Hex Screw, for vertical shaft	1
16.	50360H	Spreader	1
17.	29126FW	Spreader Crank Rod Assembly	1
18.	50360G	Spreader Shaft Driving Arm	1
19.	SS7121410TP	Screw	1
20.	NS6680410SP	Hex Nut, for spreader drive	1
21.	50360F	Connecting Rod, for spreader drive	1
22.	WP0742016SP	Collar, for spreader driving arm	2
23.	SD1000801SH	Stud	1
24.	50360	Eccentric, for spreader drive	1
25.	SS8660612TP	Screw	2

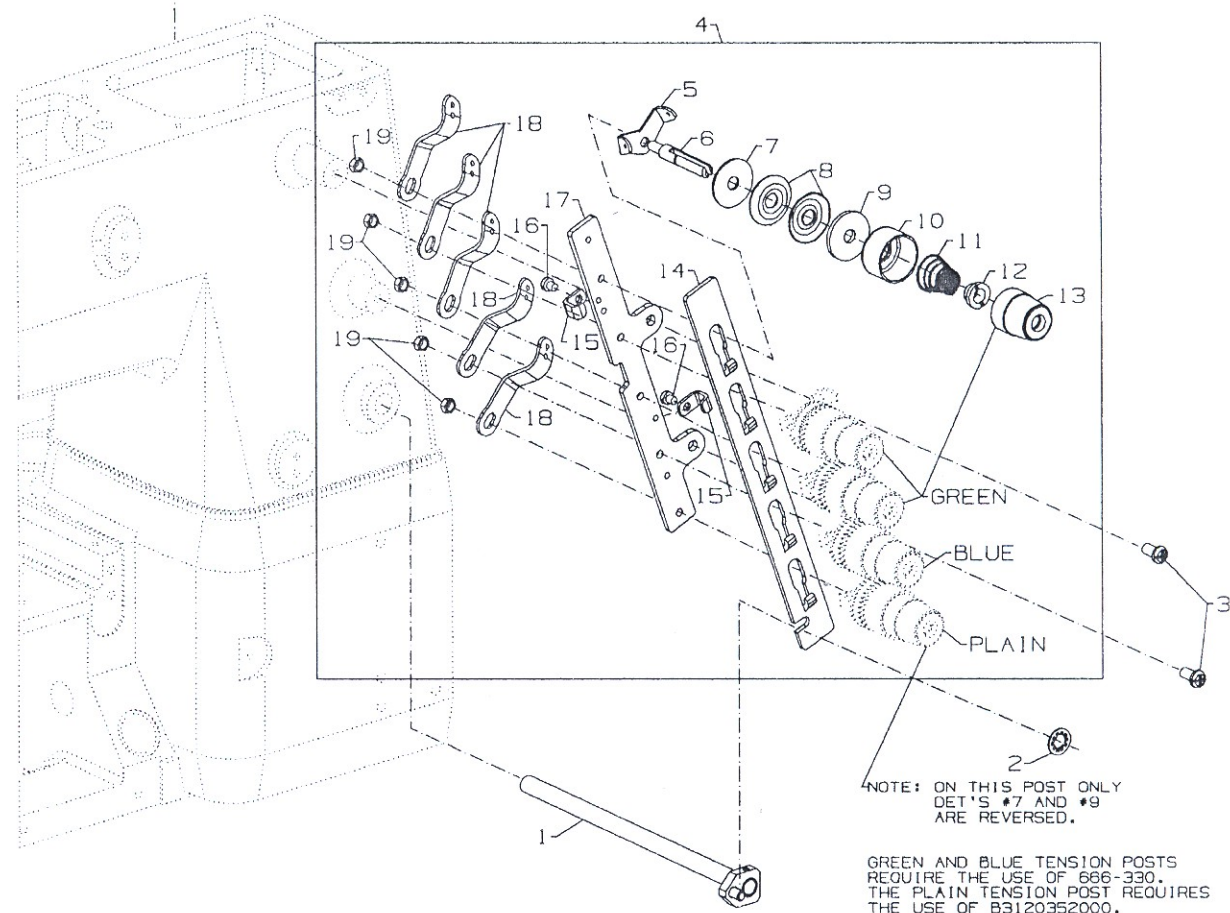
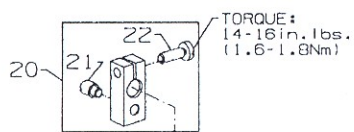




THREAD GUIDE

Ref. No.	Part No.	Description	Amt. Req.
1.	SS7120640SP	Screw, for lead-in eyelet	2
2.	50392AU	Thread Eyelet Assembly	1
3.	SS7090910TP	Screw	1
4.	WS0510002KP	Split Washer	1
5.	50366A	Thread Eyelet Tube Bracket	1
6.	50392S	Lead-In Tension Eyelet	1
7.	50366	Thread Eyelet Tube	2
8.	SS4120615SP	Screw, for needle thread guide	2
9.	50363CK	Needle Thread Guide and Lubricator Assembly	1
10.	SS7110410SP	Screw, for spreader thread guide	1
11.	50358U	Thread Guide, for spreader	1
12.	50393HH	Silicone Thread Lubricator	1
13.	WP0371026SD	Washer	2
14.	50366J	Needle Thread Guide	1
15.	SS7080510TP	Screw, for holder eyelet	1
16.	SS4090815SP	Screw, for silicone tank	2
17.	50358W	Holder, for needle thread eyelet	1
18.	SS8080410TP	Screw	3
19.	36271A	Adjusting Needle Thread Eyelet	3
20.	SS7120710SP	Screw, for strike-off	1
21.	50366B	Needle Thread Strike-Off Assembly	1
22.	SS7060310SP	Screw, for plate strike-off	1
23.	50370F	Thread Strike-Off Component	1
24.	50358V	Needle Thread Strike-Off	1
25.	50392T	Eyelet	1
26.	605A	Screw, for needle thread guide	2
27.	C50044E	Needle Thread Guide	1
28.	SS7090610SP	Screw	1
29.	12124202	Looper Frame Eyelet	1
30.	29475CG	Spreader Thread Tension Assembly	1
31.	50392AZ	Tension Nut	1
32.	50392AY	Tension Spring	1
33.	50392AX	Tension Disc	2
34.	50392AW	Tension Post	1
35.	57844	Eyelet	1
36.	652C16	Star Washer	1
37.	SS7120640SP	Screw	1
38.	50392AE	Looper Frame Eyelet	1
39.	SS1121010SP	Screw, for thread guide	1
40.	50357AR	Nipper Plate Assembly	1
41.	SD0380551SL	Screw	1
42.	50357AS	Nipper Spring	1
43.	50357Y	Nipper Spring Plate	1
44.	50357V	Nipper Plate	1
45.	50366G	Thread Guide	1
46.	SS7090610SP	Screw, for spreader thread guide	2
47.	50346	Thread Guide Spreader	1

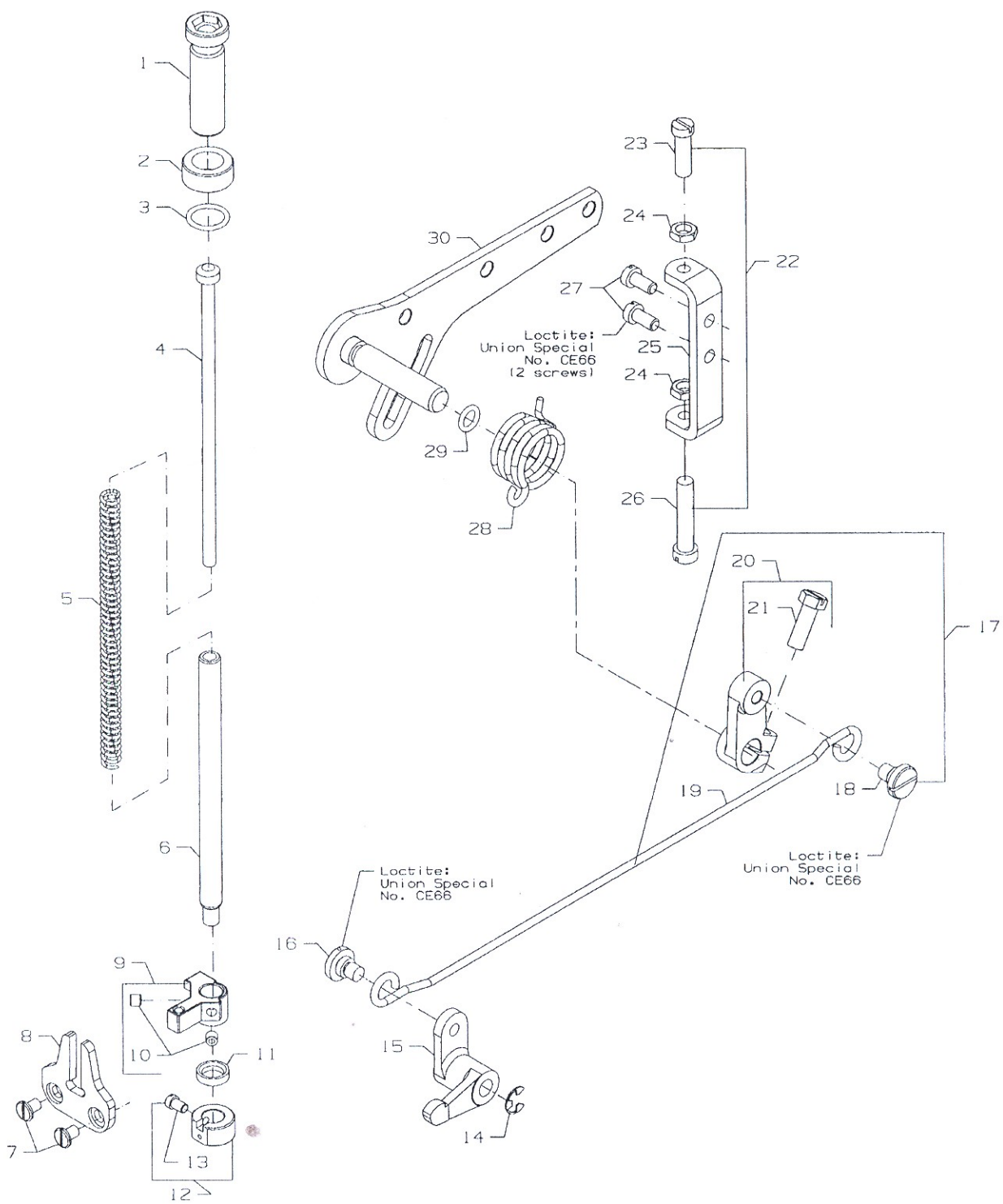




TENSION RELEASE & THREAD TENSION

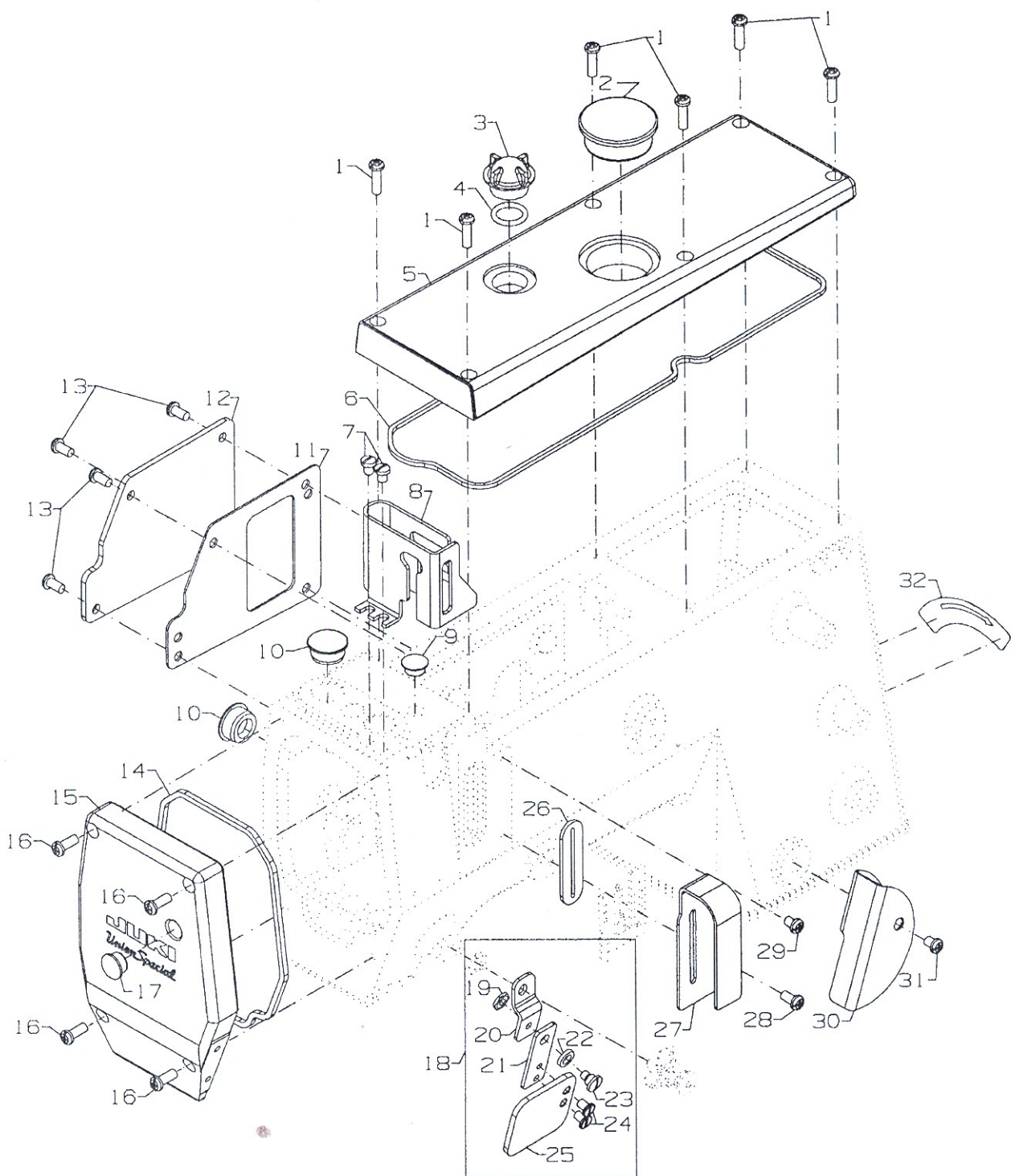
Ref. No.	Part No.	Description	Amt. Req.
1.	50392Z	Tension Needle Lever Assembly	1
2.	660-283A	Retainer Washer	1
3.	SS4120915SP	Screw, for tension assembly	2
4.	50392Y	5 Thread Tension Assembly	1
5.	57892K	Thread Tension Eyelet	5
6.	56392G	Tension Post	5
7.	B3120352000	Tension Disc Felt	1
-	666-330	Disc Felt	4
8.	B3126012000	Tension Disc	10
9.	B3120704000	Tension Disc Felt	5
10.	56392H	Spring Shield	5
11.	11550209	Spring, needle (green)	3
-	B3103804000	Spring, spreader (blue)	1
-	B3121804000	Spring, looper (plain)	1
12.	B3112704000	Ferrule, tension spring	5
13.	50692G	Knob, needle (green)	3
-	56392M	Knob, spreader (blue)	1
-	56392R	Knob, looper (plain)	1
14.	50392W	Tension Disc Separator	1
15.	50392AV	Guide, for tension disc separator	2
16.	SS7090520SP	Screw, for guide	2
17.	50392X	Tension Bracket	1
18.	57865	Lead-In Thread Guide	5
19.	NS6110420SP	Nut	5
20.	50392BC	Tension Release Lever Shaft Connection	1
21.	22875N	Base Spring Screw	1
22.	SS7121410TP	Binder Screw	1





PRESSERFOOTLIFT

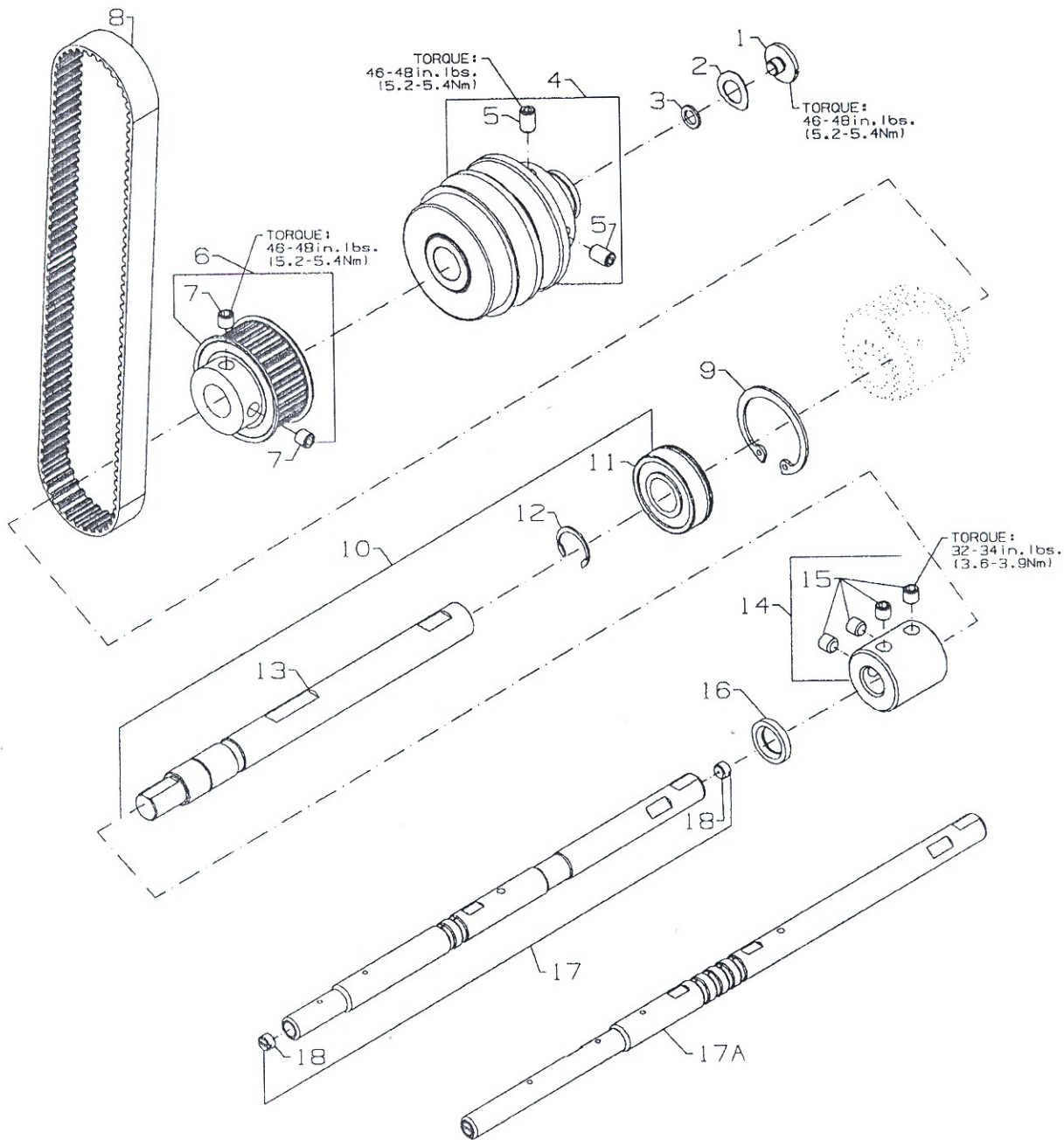
Ref. No.	Part No.	Description	Amt. Req.
1.	11071602	Adjusting Screw, for spring	1
2.	11071701	Locking Nut	1
3.	660-1014	"O" Ring	1
4.	C50056B	Spring Rod	1
5.	50357AP	Spring, for presser bar	1
6.	50335AF	Presser Bar	1
7.	SS6110610TP	Screw, for guide plate	2
8.	50335AG	Guide Plate, for presser bar	1
9.	50335AH	Presser Bar Guide	1
10.	SS8110422TP	Set Screw	2
11.	660-739	Oil Seal	1
12.	50333P	Collar	1
13.	22562	Screw	2
14.	RE0500000K0	E Ring, for pin	1
15.	50381F	Lever, for lifter, front	1
16.	SD0790303SP	Screw, for wire connector	1
-	CE66	Loctite Adhesive, (not shown), for screw	-
17.	29476TK	Rear Lifter Lever Assembly	1
18.	SD0790303SP	Screw	1
19.	50355AR	Wire Connector	1
20.	50381G	Lifter Lever, rear	1
21.	SS9151740CP	Hex Screw	1
22.	29476TT	Stop Assembly	1
23.	SS6121010SP	Screw, for stopper	1
24.	NS6150310SP	Hex Nut	2
25.	50332V	Stopper, for lifter lever	1
26.	SS6153040SP	Screw, for adjusting stopper	1
27.	SS6151920SP	Screw, for adjusting stopper	2
-	CE66	Loctite Adhesive, (not shown), for screw	-
28.	50381	Spring, for lifter lever	1
29.	RO068190100	"O" Ring	1
30.	50381B	Lifter Lever Assembly	1



COVERS, UPPER ARM

Ref. No.	Part No.	Description	Amt. Req.
1.	SS4121615SP	Screw, for top cover	6
2.	50393EU	Plug, for top cover	1
3.	B3530555000	Oil Sight Gauge, top	1
4.	660-212	"O" Ring, for oil sight gauge	1
5.	50382FW	Top Cover	1
6.	50382FZ	Quad Ring, for top cover	1
7.	SS7120640SP	Screw, for needle bar guard	2
8.	50317C	Needle Bar Guard	1
9.	TA1050504R0	Plug, for bed	1
10.	50393HB	Plug, for bed	2
11.	50384L	Gasket, for puller drive cover	1
12.	50382GB	Puller Drive Cover	1
13.	SS4120915SP	Screw, for puller drive cover	4
14.	50382FY	Quad Ring, for head cover	1
15.	50382FX	Head Cover	1
16.	SS4121215SP	Screw, for head cover	4
17.	TA1100604R0	Plug, for head cover	1
18.	99682XCB	Protection Shield Assembly, for all styles except FS322E12 & FS332E12	1
19.	NS6620320SP	Nut	1
20.	50383AE	Bracket Holder	1
21.	50383AD	Bracket	1
22.	WZ0641510KP	Spring Washer	1
23.	SD0640323TP	Shoulder Screw	1
24.	SS6110610SL	Counter Sunk Head Screw	2
25.	99682XC3	Protection Shield	1
26.	50393EW	Rubber Gasket, for needle lever	1
27.	50382GA	Cover, for thread take-up	1
28.	SS4120915SP	Screw, for thread take-up cover	1
29.	SS4120615SP	Screw, for thread cover	1
30.	50382GM	Thread Cover	1
31.	SS4120615SP	Screw, for thread take-up cover	1
32.	LA452	Label, direction of rotation	1

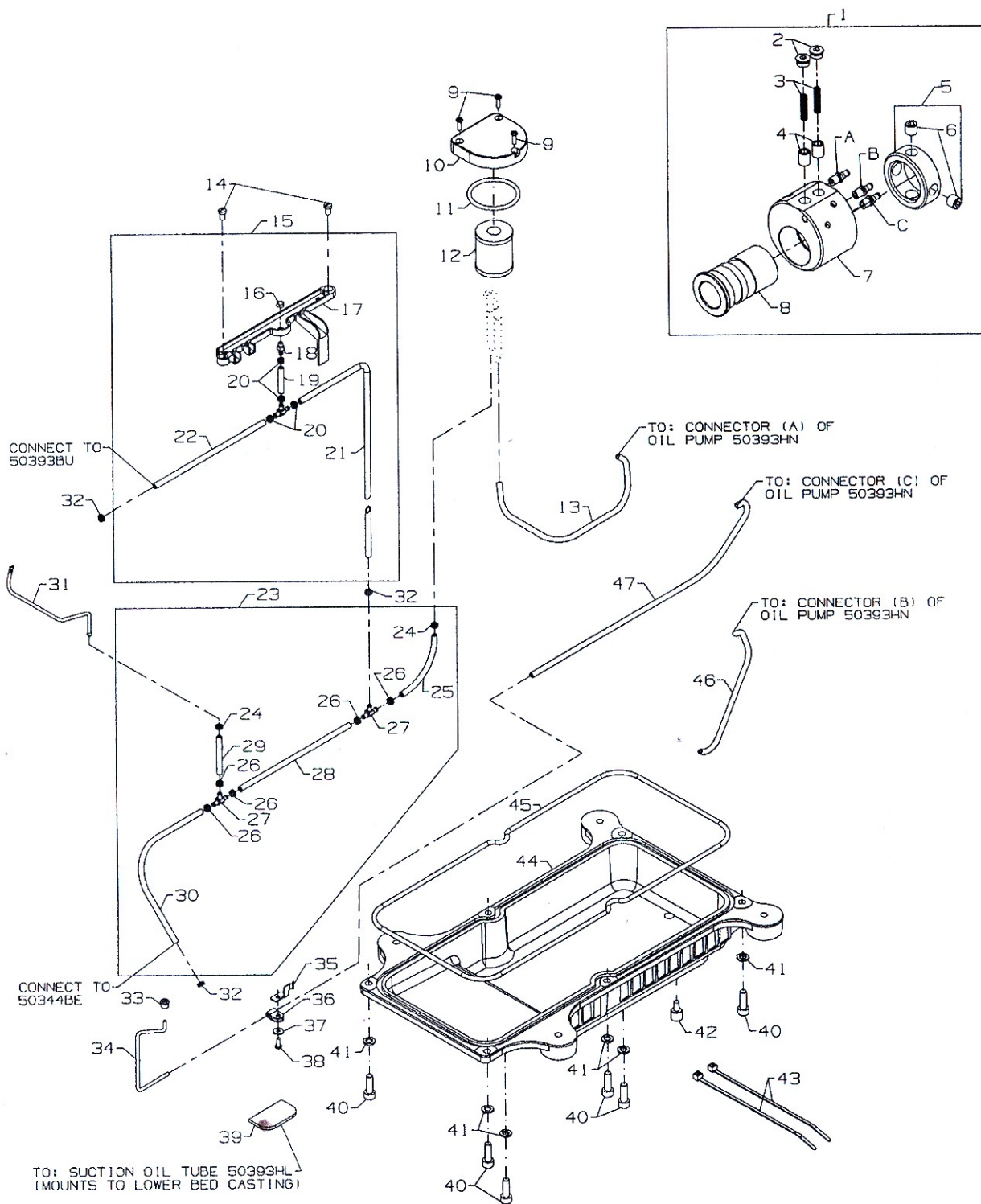




LOWER MAIN SHAFT

Ref. No.	Part No.	Description	Amt. Req.
1.	SS7660520SP	Shoulder Screw, for lower main shaft, right	1
2.	660-1062	Spring Washer	1
3.	50374	Spacer, for pulley assembly	1
4.	50321G	Pulley Assembly	1
5.	SS8661012TP	Set Screw	2
6.	50342AX	Sprocket, for lower main shaft	1
7.	SS8660612TP	Screw	2
8.	50342BS	Timing Belt	1
9.	50335AK	Retaining Ring, for ball bearing	1
10.	29476UH	Mainshaft Assembly, lower right	1
11.	50322AL	Ball Bearing, for lower main shaft	1
12.	50335BB	Retaining Ring	1
13.	50322AG	Lower Main Shaft, right	1
14.	50333A	Coupling, for lower main shafts	1
15.	SS8660612TP	Screw	4
16.	660-934	Oil Seal	1
17.	50322AU	Lower Main Shaft, left	1
17A.	50322AT	Lower Main Shaft, left, for FS322E12, FS332E12	1
18.	SS8660410SP	Screw	2

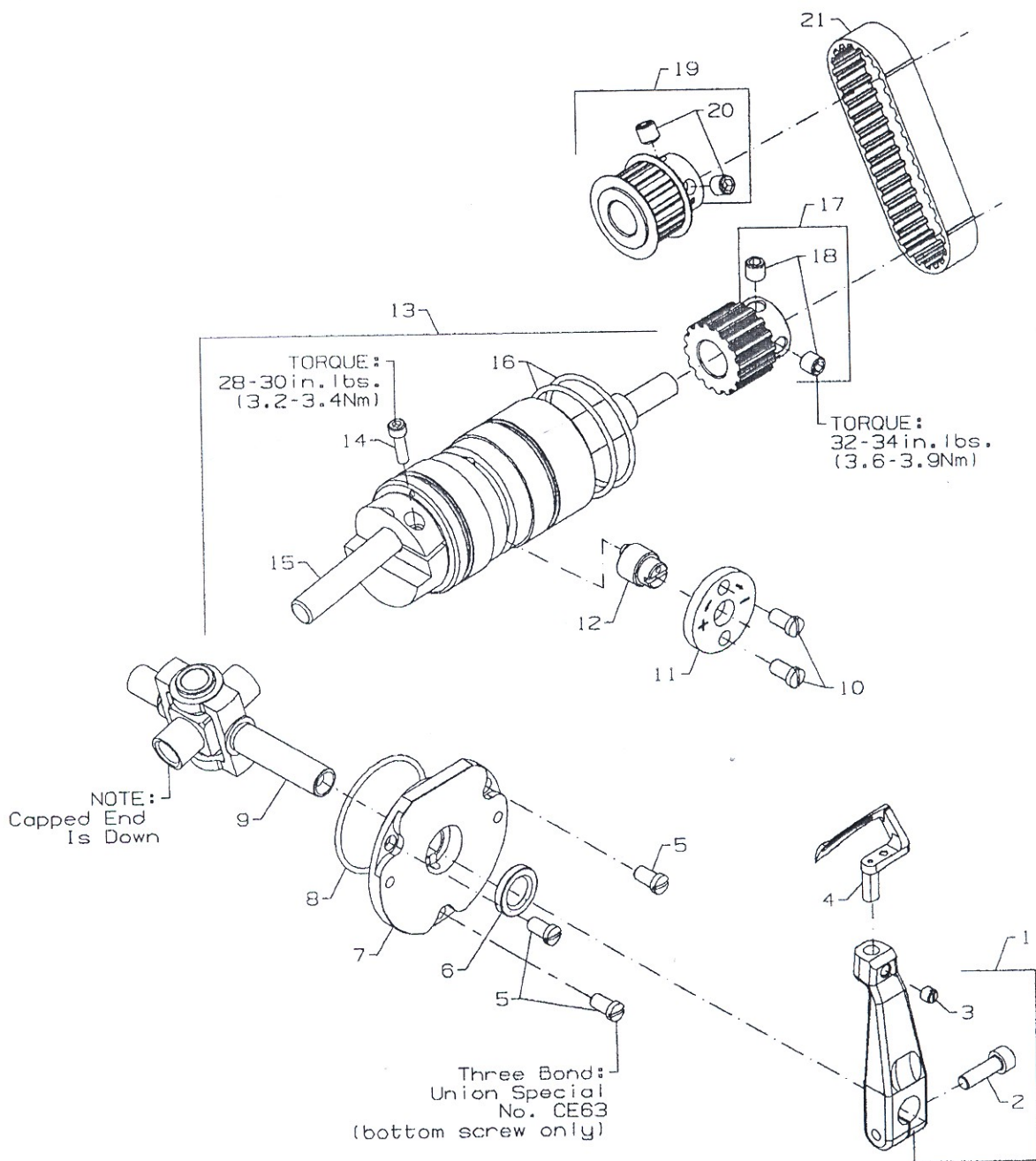




LUBRICATION, OIL TUBING & OIL PUMP

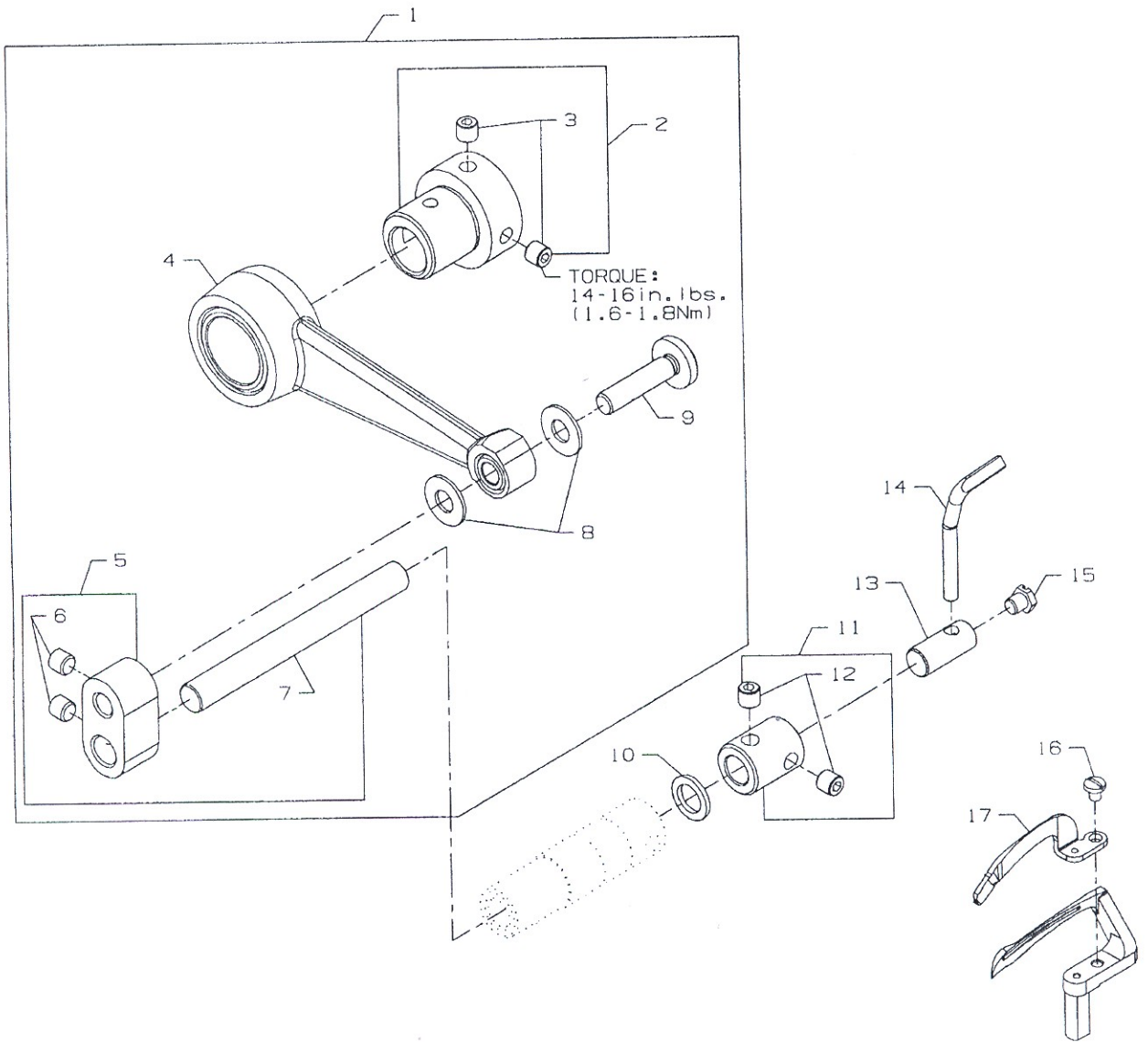
Ref. No.	Part No.	Description	Amt. Req.
1.	50393HN	Oil Pump Assembly, 2-stage	1
2.	18-1470	Screw	2
3.	50332S	Spring, for plunger.....	2
4.	34393D	Plunger	2
5.	50393EX	Collar, for oil pump	1
6.	SS8660612TP	Screw	2
7.	50393GB	Oil Pump Housing, 2 Stage.....	1
8.	50393GD	Oil Pump Housing, 2 Stage.....	1
9.	SS4091015SP	Screw, for oil filter cover.....	3
10.	50393FR	Cover, for oil filter.....	1
11.	50384	"O" Ring, for oil filter cover.....	1
12.	11843208	Oil Filter.....	1
13.	50393FV	Oil Tube, for supply (1)	1
14.	SS7120710SP	Screw	2
15.	29476US	Oil Supply Assembly, upper	1
16.	NS6110310SP	Nut	1
17.	50393KC	Oil Gutter	1
18.	SQ1110402MZ	Fitting	1
19.	50393-27	Oil Tube	1
20.	50393KM	Tube Retaining, spring	4
21.	50393-407	Oil Tube	1
22.	50393-140	Oil Tube	1
23.	29476UT	Oil Supply Assembly, lower	1
24.	50393KH	Tube Retaining, spring	2
25.	50393-70	Oil Tube	1
26.	50393KM	Tube Retaining, spring	5
27.	13765607	"T" Connector	2
28.	50393-140	Oil Tube	1
29.	50393-40	Oil Tube	1
30.	50393-170	Oil Tube	1
31.	50393KF	Oil Tube	1
32.	50393KM	Tube Retaining, spring	3
33.	50393HR	Plug, for feed chamber	1
34.	50393HL	Oil Tube, for suction	1
35.	50393FS	Oil Tube Holder	1
36.	998-358F	Plastic Clip	1
37.	53678N	Washer	1
38.	SS4090815SP	Screw, for oil tube holder	1
39.	50393HK	Felt	1
40.	SS6151812TP	Screw, for oil pan	6
41.	WS0631510KP	Spring Washer	6
42.	22571E	Screw, for oil drain plug	1
43.	RM2871B	Cable Tie	2
44.	50393EB	Oil Pan	1
45.	50384A	"O" Ring	1
46.	50393FT	Oil Tube, for suction	1
47.	50393HJ	Oil Tube, for suction	1





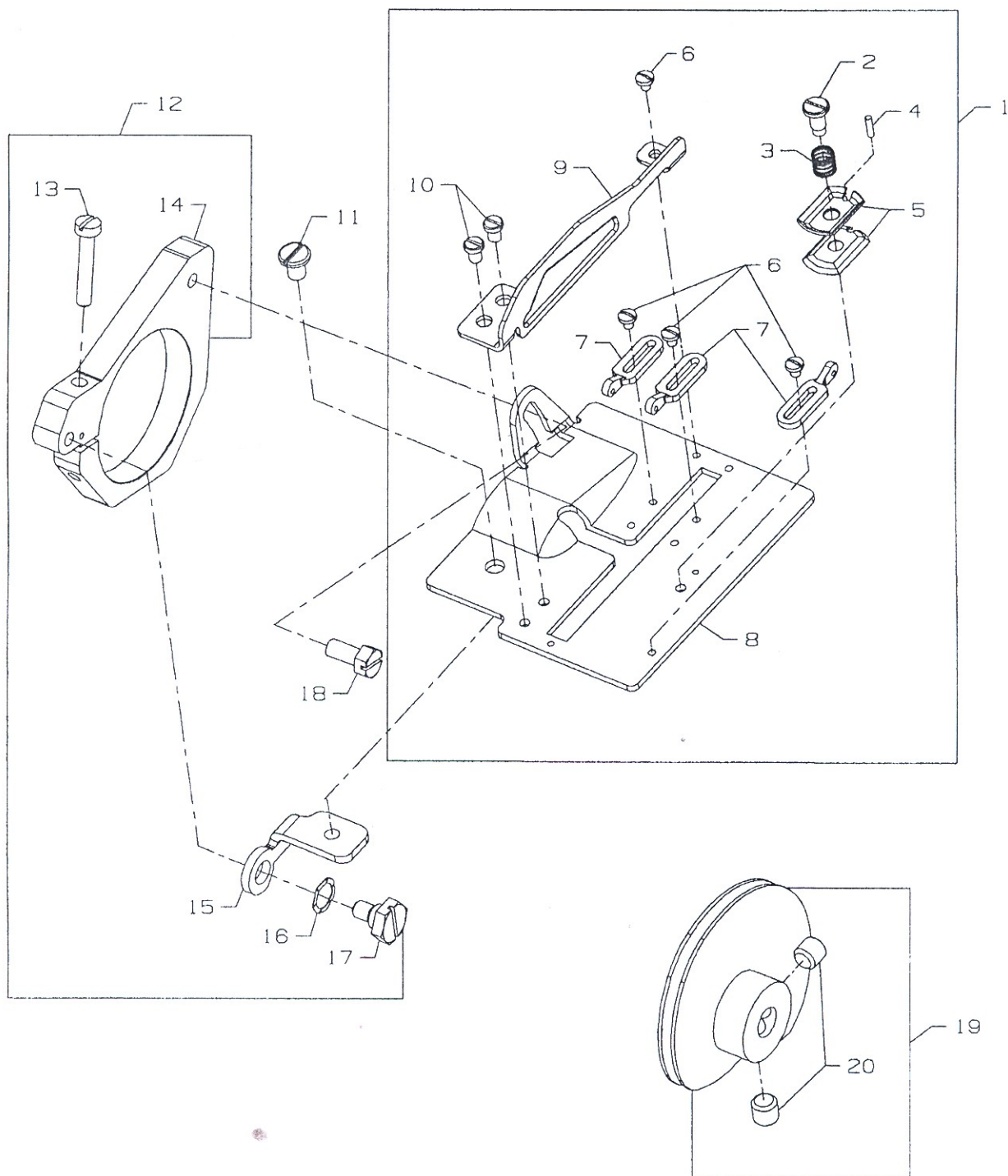
LOOPER DRIVE

Ref. No.	Part No.	Description	Amt. Req.
1.	50313P	Looper Holder	1
2.	22652B10	Screw, for looper holder	1
3.	22565	Screw, for looper holder	1
4.	50309K	Looper	1
5.	SS7120910SP	Screw, for bearing housing	3
-	CE63	Three Bond Adhesive, (not shown), for screw	-
6.	660-893	Oil Seal, looper	1
7.	50344AM	Bearing Housing Assembly, for looper drive	1
8.	660-455	"O" Ring, for bearing housing assembly	1
9.	50313J	Looper Rocker Assembly	1
10.	SS7120910SP	Screw, for retaining plate	2
11.	50314J	Eccentric Retaining Plate	1
12.	50314E	Looper Avoid Adjusting Eccentric.....	1
13.	50313M	Looper Drive Assembly	1
14.	22653J8	Screw	1
15.	667J33	Crank Pin	1
16.	660-979	"O" Ring	2
17.	50342BJ	Sprocket, for looper driven	1
18.	SS8660612TP	Screw	2
19.	50342BK	Sprocket, for looper drive	1
20.	SS8660612TP	Screw	2
21.	50342BP	Looper Drive Belt	1



NEEDLE GUARD

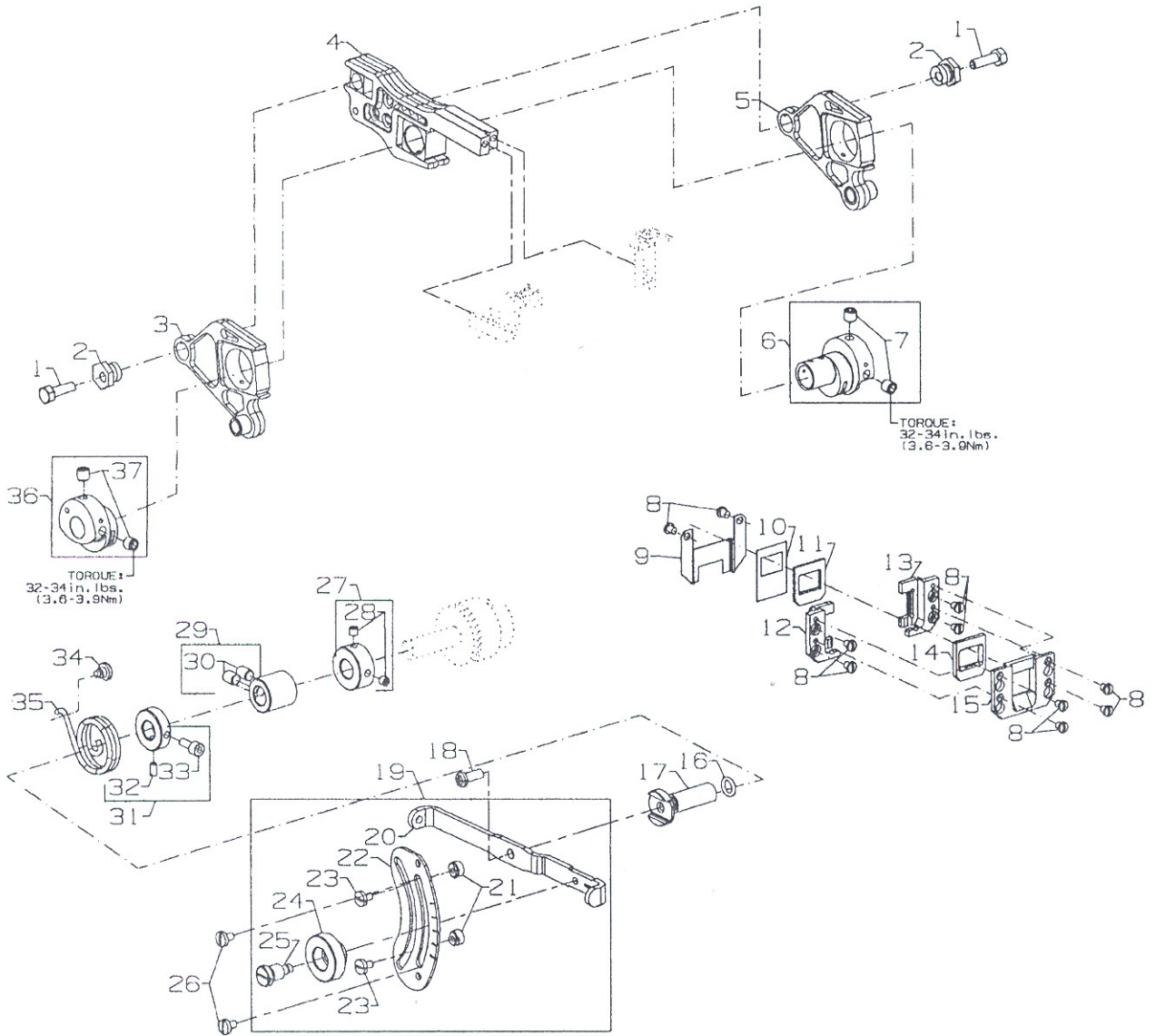
Ref. No.	Part No.	Description	Amt. Req.
1.	29476UJ	Rear Needle Guard Drive Assembly	1
2.	50373DA	Needle Guard Eccentric	1
3.	SS8110422TP	Screw, for needle guard eccentric	2
4.	50368W	Connecting Rod Assembly, for needle guard	1
5.	50368T	Pivot Link	1
6.	SS8110422TP	Screw	2
7.	50368V	Shaft, for needle guard	1
8.	50368E	Washer	2
9.	50368A	Pivot Pin	1
10.	50374	Washer	1
11.	50354L	Coupling, for needle guard	1
12.	SS8110422TP	Screw	2
13.	50325AF	Holder, for needle guard	1
14.	50325AE	Needle Guard, rear	1
15.	SS9090420TP	Screw, for rear needle guard	1
16.	SS7060310SP	Screw, for front needle guard	1
17.	50325AJ	Needle Guard, front	1



LOOPER THREAD TAKE-UP

Ref. No.	Part No.	Description	Amt. Req.
1.	50357AM	Cast-Off Plate Assembly	1
2.	SD0380551SL	Knurled Nut	1
3.	50332AC	Tension Spring	1
4.	50347R	Roll Pin	1
5.	51959B	Tension Disc	2
6.	SS7060310SP	Screw	4
7.	52958D	Take-up Eyelet	3
8.	50357AN	Cast-off Plate	1
9.	50304N	Retaining Finger	1
10.	SS6080410SP	Screw	2
11.	SS6110610TP	Screw, for cast-off holder	1
12.	29476UK	Cast-Off Plate Holder Assembly	1
13.	SS9111010SP	Screw, for collar bracket	1
14.	50383F	Take-up Collar Bracket	1
15.	50304K	Cast-Off Plate Holder	1
16.	50386J	Washer	1
17.	SD0630275SP	Shoulder Screw, for cast-off plate holder	1
18.	SS9111010SP	Screw, for collar bracket	1
19.	50323R	Take-up Assembly	1
20.	SS8660612TP	Set Screw	2

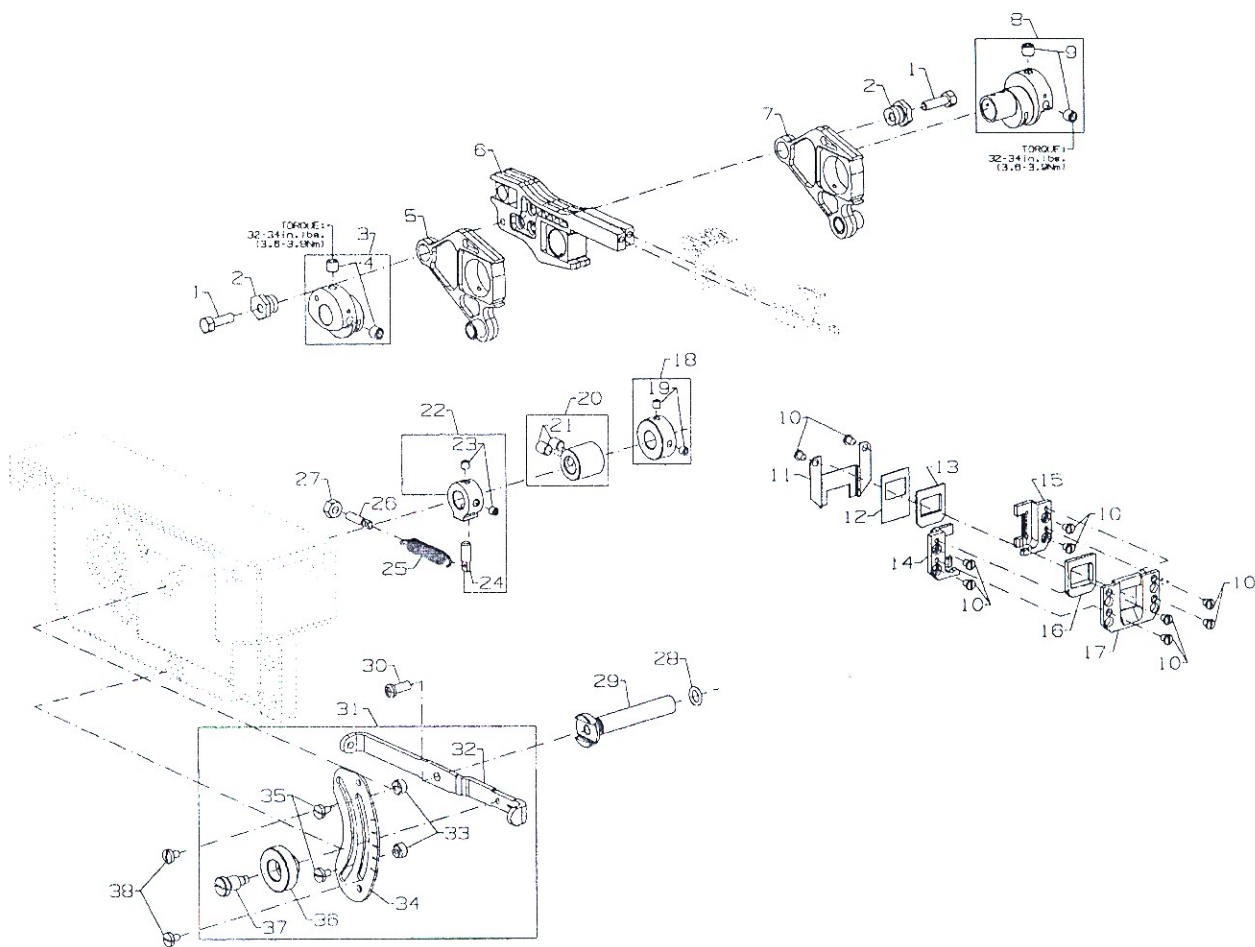




FEED DRIVE MECHANISM
FOR
FS322C01, FS332C01, FS335E41, FS335E42
FS322H01, FS332H01, FS332L01, FS332L21

Ref. No.	Part No.	Description	Amt. Req.
1.	18-1432	Screw	2
2.	50334BD	Hex Eccentric Stud	2
3.	50334AW	Drive Fork Assembly	1
4.	50334BE	Feed Bar Assembly	1
5.	50334AX	Drive Fork Assembly, right	1
6.	50340D	Feed Eccentric, main	1
7.	SS8660612TP	Screw	2
8.	SS7090530SP	Screw	10
9.	50334Y	Oil Shield	1
10.	50334V	Oil Scraper	1
11.	50334BH	Feed Bar Seal	1
12.	50335AM	Guide Plate, left, rear	1
13.	50335BA	Guide Plate, right, rear	1
14.	50334BJ	Feed Bar Seal	1
15.	50335AN	Guide Plate, front	1
16.	RO0681190100	"O" Ring	1
17.	50337J	Stem, for differential feed lever	1
18.	SS4121215SP	Screw, for stem	1
19.	29476YH	Differential Feed Lever Assembly	1
20.	50337H	Differential Feed Lever	1
21.	50337U	Stop	2
22.	50337BD	Plate, for differential feed lever	1
23.	SS7090610SP	Screw	2
24.	B1647704000A	Knob, for differential feed lever	1
25.	50387	Screw	1
26.	SS7090610SP	Screw	2
27.	50337S	Collar	1
28.	SS8110422TP	Screw	2
29.	50337L	Coupling, for differential feed lever	1
30.	SS6110650TP	Screw	2
31.	50337R	Collar, for differential feed lever	1
32.	SS8090710SP	Screw	1
33.	SS6091022TP	Screw	1
34.	SP0550271TP	Screw, for spring	1
35.	50337M	Spring, for differential feed lever	1
36.	50340F	Feed Eccentric, differential	1
37.	SS8660612TP	Screw	2

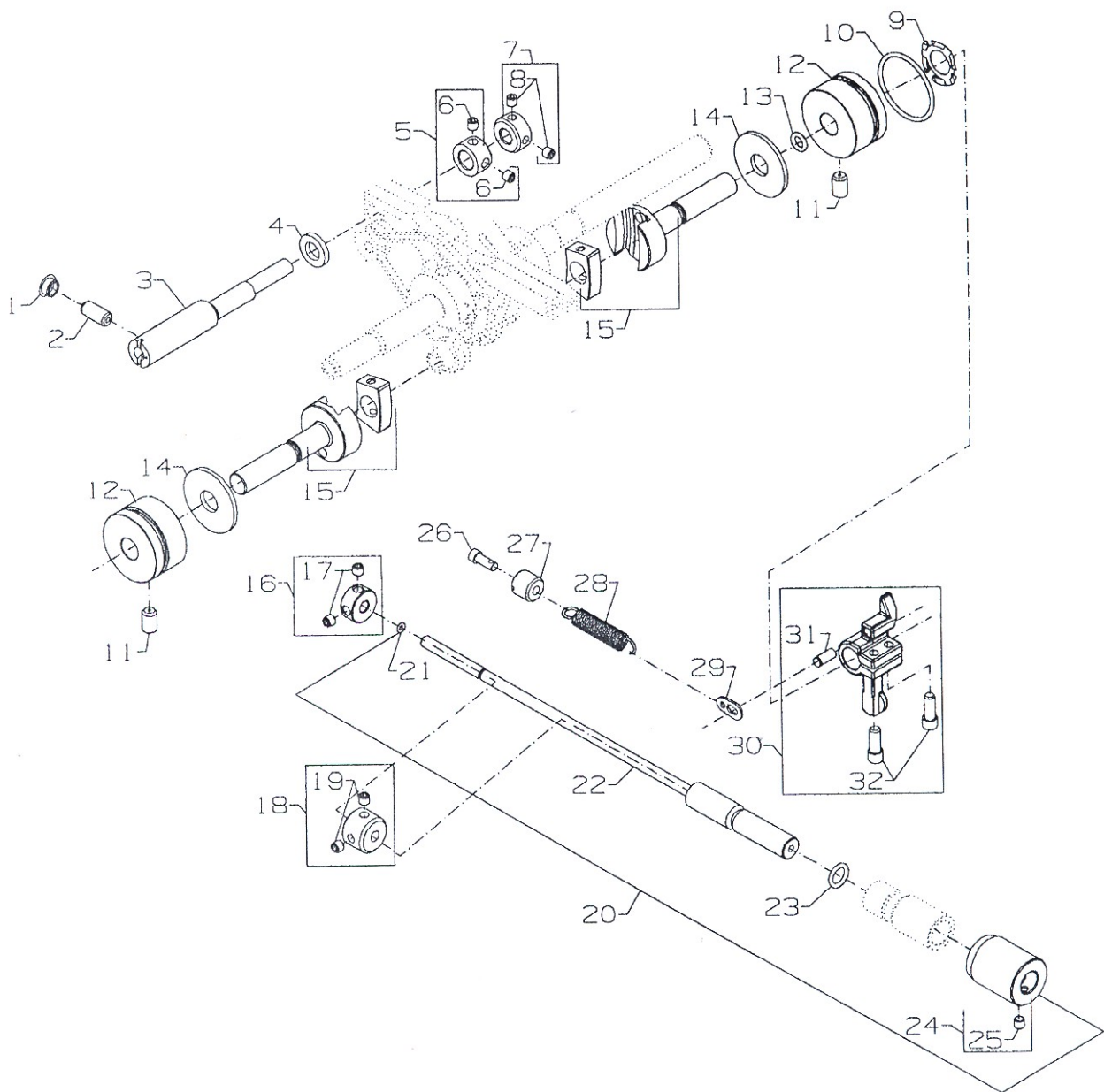




FEED DRIVE MECHANISM
FOR
FS322E12 & FS332E12

Ref. No.	Part No.	Description	Amt. Req.
1.	18-1432	Screw	2
2.	50334BD	Hex Eccentric Stud	2
3.	50340F	Feed Eccentric, differential	1
4.	SS8660612TP	Screw, for Feed Eccentric, differential.....	2
5.	50334AW	Drive Fork Assembly, left	1
6.	50334BE	Feed Bar Assembly	1
7.	50334AX	Drive Fork Assembly, right	1
8.	50340D	Feed Eccentric, main	1
9.	SS8660612TP	Screw	2
10.	SS7090530SP	Screw	10
11.	50334Y	Oil Shield	1
12.	50334V	Oil Scraper, front	1
13.	50334BH	Feed Bar Seal	1
14.	50335AM	Guide Plate, left, rear	1
15.	50335BA	Guide Plate, right, rear	1
16.	50334BJ	Feed Bar Seal	1
17.	50335AN	Guide Plate, front	1
18.	50337S	Collar	1
19.	SS8110422TP	Screw	2
20.	50337L	Coupling, for differential feed lever	1
21.	SS6110650TP	Screw	1
22.	50335AS	Collar, for differential feed lever	1
23.	SS8110422TP	Screw	2
24.	50336V	Pin, for differential feed lever	1
25.	50332W	Spring	1
26.	18-1445	Spring Latch Screw	1
27.	NS6110530SP	Nut	1
28.	RO068190100	"O" Ring	1
29.	50337Y	Stem, for differential feed lever	1
30.	SS4121215SP	Screw, for Stem	1
31.	29476YH	Differential Feed Lever Assembly	1
32.	50337H	Differential Feed Lever	1
33.	50337U	Stop	2
34.	50337BD	Plate, for differential feed lever	1
35.	SS7090610SP	Screw	2
36.	B1647704000A	Knob, for differential feed lever	1
37.	50387	Screw	1
38.	SS7090610SP	Screw	2

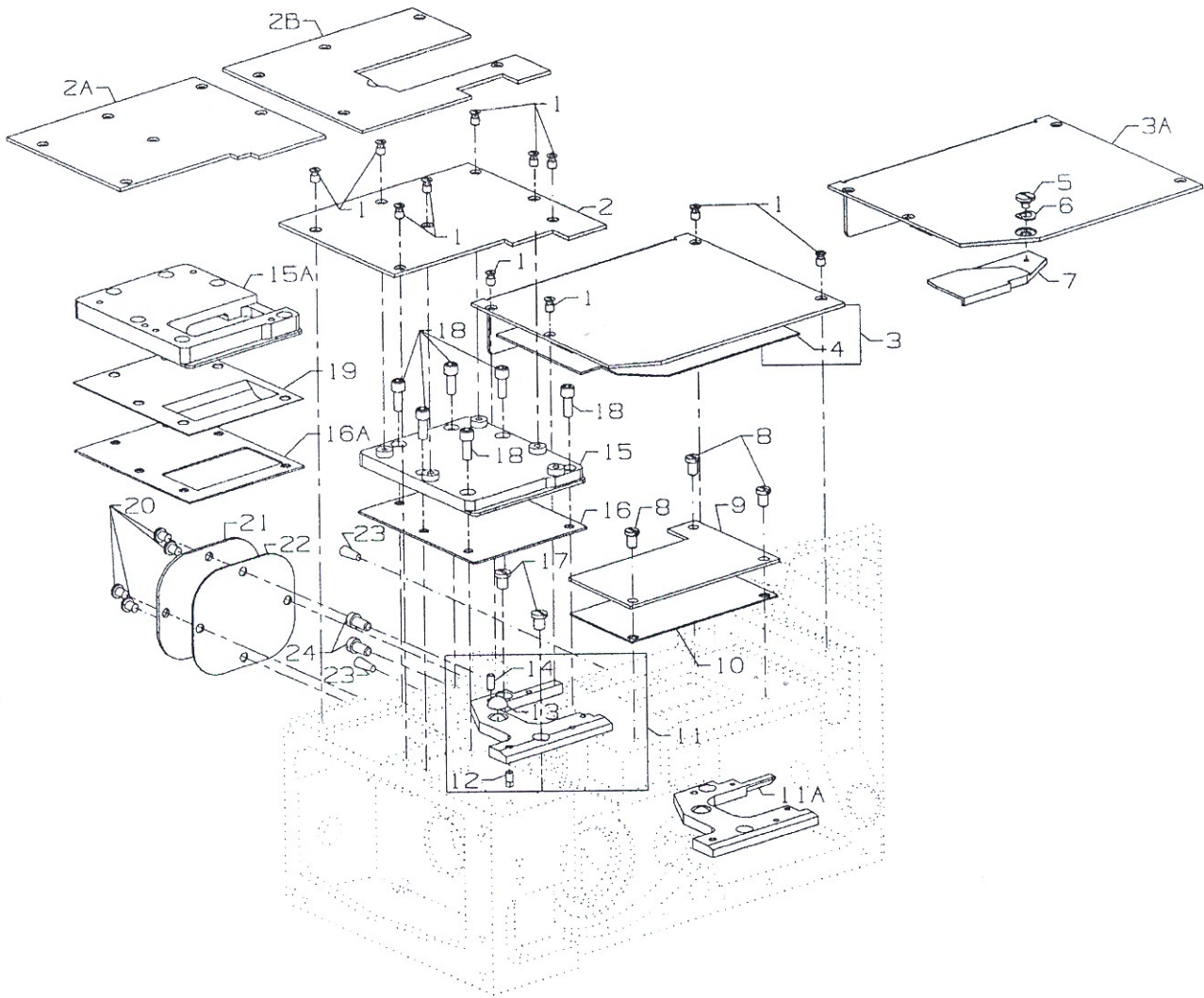




FEED DRIVE MECHANISM

Ref. No.	Part No.	Description	Amt. Req.
1.	TA0750404R0	Plug, for eccentric shaft	1
2.	22591A	Screw, for eccentric shaft	1
3.	50334BC	Eccentric Shaft	1
4.	50368AD	Washer, for eccentric shaft	1
5.	50334BB	Collar, for eccentric shaft	1
6.	SS8110422TP	Screw, for collar	2
7.	50337T	Collar, for eccentric shaft	1
8.	SS8110422TP	Screw, for collar	2
9.	661-96	Spring Washer	1
10.	660-695	"O" Ring, for bushing	1
11.	SS8661012TP	Screw, for bushing	1
12.	35036F	Bushing, for stitch adjusting shaft	1
13.	660-220	"O" Ring, for stitch adjusting shaft	1
14.	35036AZ	Brake Pad	1
15.	50634G	Stitch Adjusting Shaft Assembly	1
16.	50335D	Collar	1
17.	22894P	Screw	2
18.	50333T	Collar	1
19.	22894P	Screw	2
20.	29476UF	Stitch Length Adjusting Rod Assembly	1
21.	660-980	"O" Ring, stitch control shaft	1
22.	50322AR	Shaft, for stitch control	1
23.	660-206	"O" Ring, for stitch control shaft	1
24.	50336Y	Stitch Knob, indicator	1
25.	SS8110422TP	Screw	1
26.	50335	Spring Retainer	1
27.	22714C	Screw, for spring retainer	1
28.	50355	Spring	1
29.	50335A	Spring Holder	1
30.	50336S	Stitch Control Lever	1
31.	661-35	Pin	1
32.	22596H	Screw	2

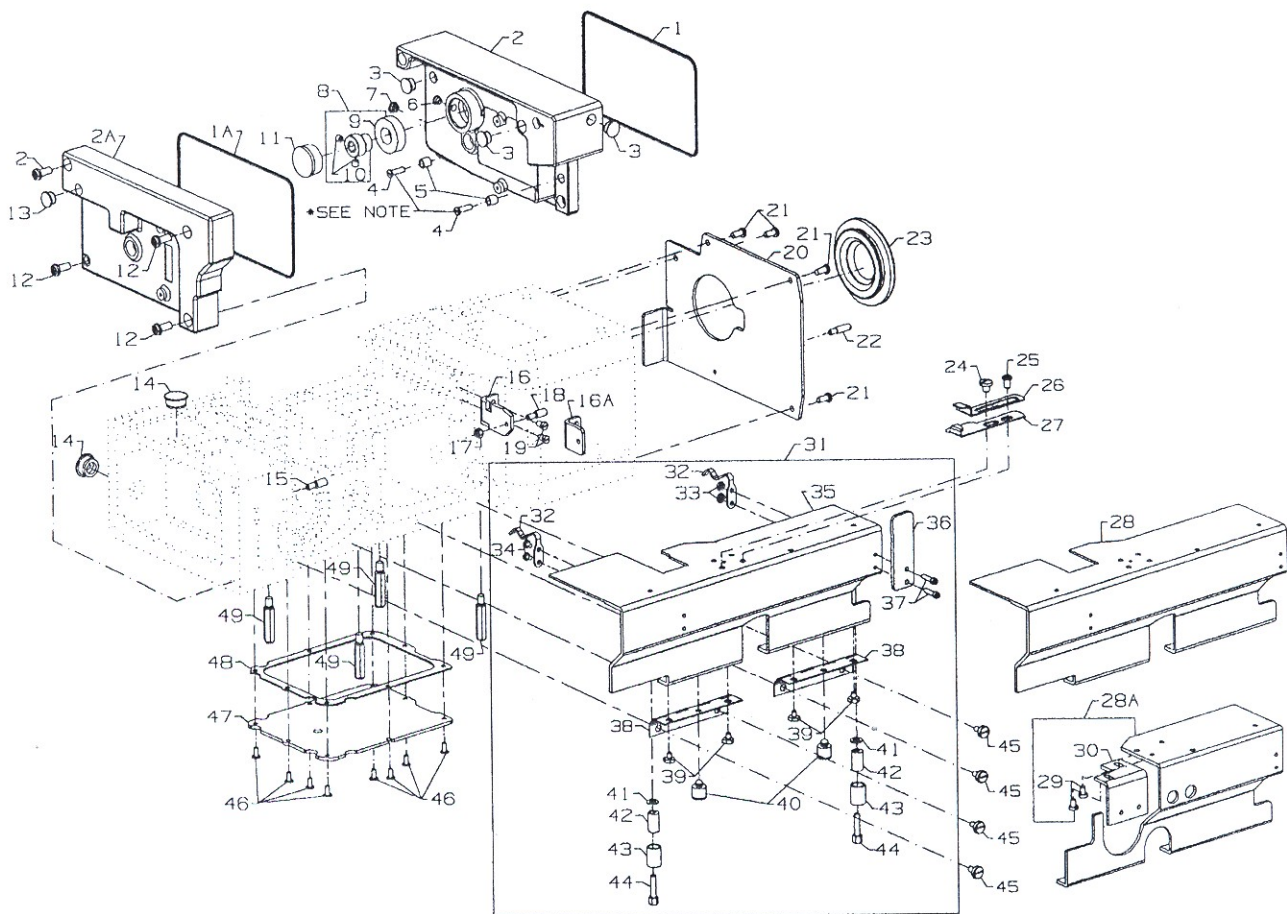




COVERS, LOWER BED

Ref. No.	Part No.	Description	Amt. Req.
1.	18-1448	Screw	9-11
2.	50301BH	Cloth Plate, left, for FS332L01, FS332L21, FS322H01, FS332H01	1
2A.	50301BA	Cloth Plate, left, for FS322C01, FS332C01, FS322E12, FS332E12	1
2B.	50301CH	Cloth Plate, left, for FS335E41, FS332E42	1
3.	50301BF	Cloth Plate, right, for FS322H01, FS332H01, FS332L01, FS332L21, FS335E41, FS335E42	1
3A.	50301AZ	Cloth Plate, right, for FS322C01, FS332C01, FS322E12, FS332E12	1
4.	50303B	Accoustic Pad	1
5.	22726	Screw for Swing Plate, for FS332C01, FS332C01, FS335E41, FS335E42	1
6.	95978	Spring Washer, for FS332C01, FS332C01, FS335E41, FS335E42	1
7.	50345U	Swing Plate, for FS332C01, FS332C01, FS335E41, FS335E42	1
8.	22839C	Screw, for FS322H01, FS332H01, FS332L01, FS332L21	3
9.	50382JR	Cover, for FS322H01, FS332H01, FS332L01, FS332L21	1
10.	50384K	Gasket, for FS322H01, FS332H01, FS332L01, FS332L21	1
11.	50380KA	Throat Plate Support Complete, for FS335E41, FS335E42, FS322H01, FS332H01, FS332L01, FS332L21,	1
11A.	50380LA	Throat Plate Support Complete, for FS322C01, FS332C01, FS322E12, FS332E12	1
12.	50328	Diamond Pin	1
13.	660-939	Rubber Bumper, for throat plate support	1
14.	50336W	Dowel Pin, for throat plate support	1
15.	50382CP	Cover for Feed Chamber, for FS322C01, FS332C01, FS322E12, FS332E12, FS322H01, FS332H01, FS332L01, FS332L21,	1
15A.	50382CT	Cover for Feed Chamber, for FS335E41, FS335E42	1
16.	50382CS	Gasket for FS322H01, FS332H01, FS332L01, FS332L21, FS322E12, FS332E12, FS322C01, FS332C01	1
16A.	50384E	Gasket, for FS335E41, FS335E42	1
17.	SS7150740SP	Screw	2
18.	SS6121212TP	Screw, for feed chamber cover	6
19.	37-70BLK	Cover Blank, for FS335E41, FS335E42	1
20.	SS4120615SP	Screw	4
21.	50382CL	Cover, rear, for feed chamber	1
22.	50382CR	Gasket	1
-	CE63	Three Bond Adhesive (not shown), for screw	-
23.	CO67D	Cork	2
24.	22517	Screw, for bed	2



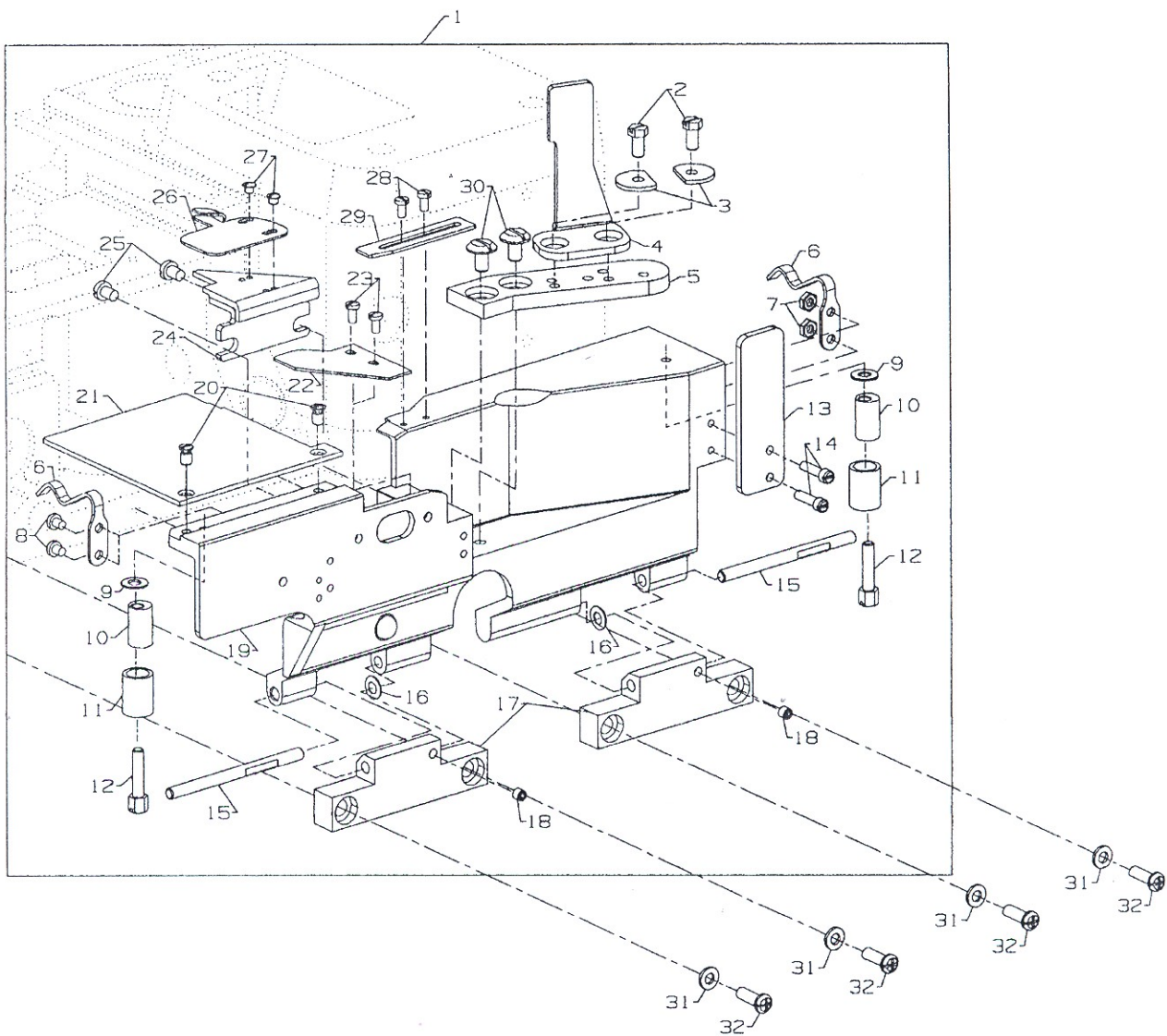


•THESE SCREWS SHOULD NOT BE LOOSENED WHEN TAKING APART.

COVERS, LOWER BED

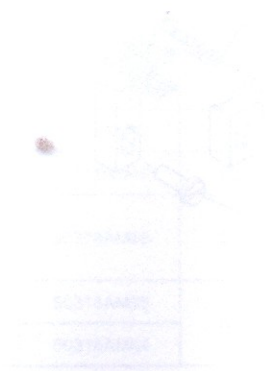
Ref. No.	Part No.	Description	Amt. Req.
1.	50382GK	Quad Ring for end cover, for FS322E12, FS332E12	1
1A.	50382CM	Quad Ring for end cover, for FS335E41, FS335E42, FS322H01, FS332H01, FS332L01, FS332L21	1
2.	50382KF	Left End Cover, for FS322E12, FS332E12	1
2A.	50382KE	Left End Cover, for FS335E41, FS335E42, FS322H01, FS332H01, FS332L01, FS332L21,	1
3.	TA1100604R0	Plug, for FS322C01, FS332C01, FS322E12, FS332E12,	1/3
4.	22541A	Screw, for FS322E12, FS332E12	2
5.	50336L	Ferrule, for FS322E12, FS332E12	2
6.	TA0620504R0	Plug for Left End Cover, for FS322E12, FS332E12	1
7.	TA0750404R0	Plug, for FS322E12, FS332E12	2
8.	50336	Bearing Thrust Collar, for FS322E12, FS332E12	1
9.	660-974	Bearing, FS322E12, FS332E12	1
10.	22894C	Screw	2
11.	999-216C	Plug, for FS322E12, FS332E12	1
12.	SS4151415SP	Screw	4
13.	TA1100604R0	Plug, for FS335E41, FS335E42, FS322H01, FS332H01, FS332L01, FS332L21.	1
14.	50393HB	Plug	1
15.	22799AH	Spring Latch Stud, for FS322C01, FS332C01, FS335E41, FS335E42, FS322H01, FS332H01, FS322L01, FS332L21,	2
16.	50332B	Support Block, for FS332L21, FS322E12, FS332E12, FS335E41, FS335E42, FS322H01, FS332H01, FS332L01, FS332L21	1
16A.	50357AC	Support Block, for FS322C01, FS332C01	1
17.	35569J	Nut	1
18.	22799AH	Spring Latch Stud	1
19.	SS7120710SP	Screw	2
20.	50382CJ	Cover, for drive belt	1
21.	SS4121015SP	Screw	4
22.	22799M	Stop Stud (used only with synchronizer)	1
23.	50393HU	Plug for right end non-synchronizer	1
24.	25S	Screw, for FS322H01, FS332H01	1
25.	22839C	Screw, for FS322H01, FS332H01	1
26.	34703F2	Holder, upper, for FS322H01, FS332H01	1
27.	34703E1	Hemmer, lower, for FS322H01, FS332H01	1
28.	50382JB	Swing Down Cover, for FS335E41, FS335E42	1
28A.	50382FS	Front Cover Assembly, for FS322E12, FS332E12	1
29.	94	Screw	2
30.	50332F	Bracket	1
31.	29476VX	Front Cover Assembly, for FS322H01, FS332H01, FS332L01, FS332L21	1
32.	50332A	Latch Spring	1/2
33.	41071G	Nut	2
34.	22513D	Screw	2
35.	50382CK	Swing Down Cover	1
36.	50363CH	Lever	1
37.	22729D	Screw	2
38.	50378S	Hinge	2
39.	SS9110543CP	Screw	4
40.	660-1020	Rubber Bumper	2
41.	20	Washer	2
42.	50382T	Stop, for front cover	2
43.	50393W	Rubber Bumper	2
44.	22519J	Screw	2
45.	SS6120930TP	Screw	4
46.	SS7090850SP	Screw	8
47.	50382CG	Dry Chamber Cover	1
48.	50383G	Gasket, for chamber cover	1
49.	22841U	Machine Support Stud	4



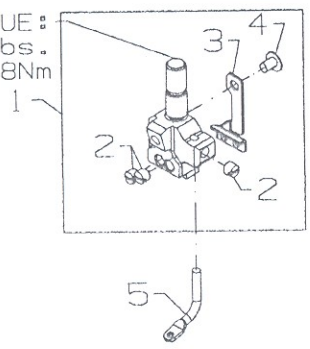


FRONT COVER ASSEMBLY
FOR
FS322C01, FS332C01

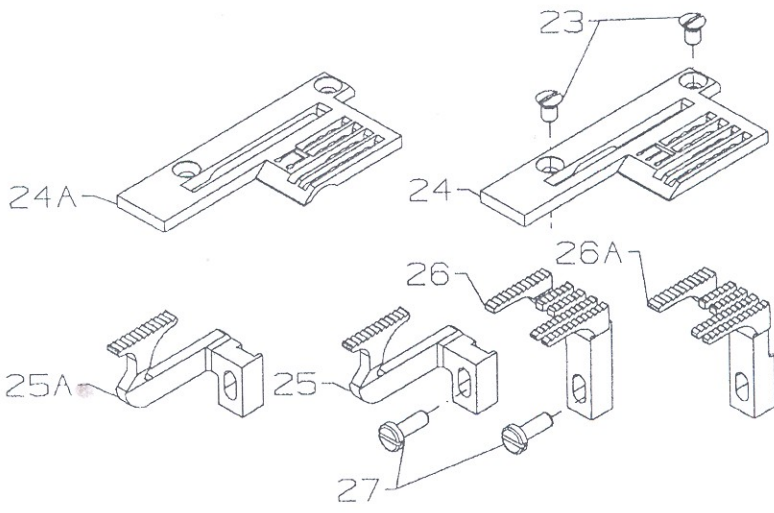
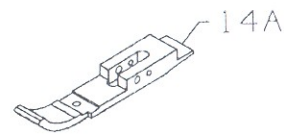
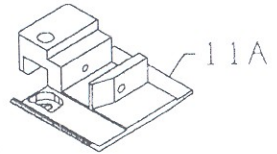
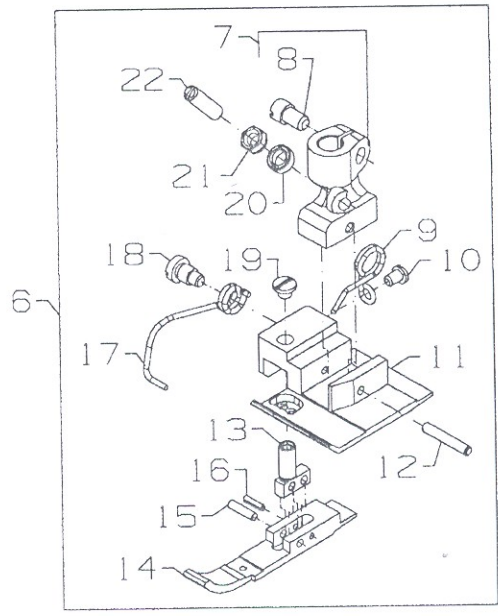
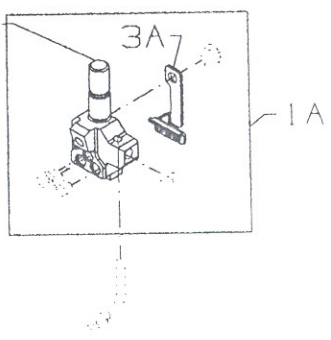
Ref. No.	Part No.	Description	Amt. Req.
1.	29476VY	Front Cover Assembly	1
2.	22882E	Hex Head Screw	2
3.	50368H	Washer	2
4.	52864W	Folder Support Bracket	1
5.	50364M	Mounting Bracket	1
6.	50332A	Latch Spring	2
7.	41071G	Nut	2
8.	22513D	Screw	2
9.	20	Washer	2
10.	50382T	Front Cover Stop	2
11.	50393W	Rubber Bumper	2
12.	22519J	Screw	2
13.	50363CH	Lever, front cover	1
14.	22729D	Screw	2
15.	50347P	Hinge Pin	2
16.	97127	Spring Washer	2
17.	50378T	Hinge	2
18.	22894W	Set Screw	1
19.	50382FT	Swing Down Cover	1
20.	22525A	Screw	2
21.	50301AY	Cloth Plate	1
22.	50382BB	Looper Shield	1
23.	77L	Screw	2
24.	50364P	Platform	1
25.	94	Screw	2
26.	50303C	Edge Guide	1
27.	77F	Screw	2
28.	77L	Screw	2
29.	50343A	Plate, for folder	1
30.	22517B	Screw	2
31.	8372A	Washer	4
32.	SS4121415SP	Screw	4



TORQUE:
14-16 in. lbs.
(1.6-1.8 Nm)



TORQUE:
14-16 in. lbs.
(1.6-1.8 Nm)



SEWING PARTS
FOR
FS322C01 & FS332C01

Ref. No.	Part No.	Description	Amt. Req.
1.	-----	Needle Head, for 2 needle sewing comb., (see chart)	1
1A.	-----	Needle Head, for 3 needle sewing comb., (see chart)	1
2.	SS8080310TP	Screw, for Needle Head	3/4
3.	50318AE40	Eyelet, per Needle Head, for 2 needle sewing comb.	1
3A.	50318AE56	Eyelet, per Needle Head, for 3 needle sewing comb.	1
4.	SS6060440TP	Screw, for Eyelet	1
5.	50392G	Needle Thread Eyelet	1
6.	-----	Presser Foot Assembly, for sewing comb., (see chart)	1
7.	34730H	Presser Foot Shank	1
8.	91	Screw	1
9.	97109	Torsion Spring	1
10.	605	Screw	1
11.	50330BN48	Presser Foot Bottom, for 50320V48	1
-	50330BN16	Presser Foot Bottom, for 50320V16	1
11A.	50330BN12	Presser Foot Bottom, for 50320U12	1
-	50330BN8	Presser Foot Bottom, for 50320U8	1
12.	22799B	Screw, for hinge	1
13.	G65-181	Plunger	1
14.	50330BP16	Presser Foot Yielding Section	1
15.	96532	Roll Pin	1
16.	96671	Roll Pin	1
17.	52830G	Spring	1
18.	57WD	Screw, for spring	1
19.	187A	Screw, for plunger	1
20.	51959E	Collar	1
21.	51430F	Nut	1
22.	22565E	Screw	1
23.	87	Screw, for throat plate	2
24.	-----	Throat Plate, for 3 needle sewing comb., (see chart)	1
24A.	-----	Throat Plate, for 2 needle sewing comb., (see chart)	1
25.	-----	Differential Feed Dog, for sewing comb., (see chart)	1
26.	-----	Main Feed Dog, for sewing comb., (see chart)	1
27.	SS7091110TP	Screw, for feed dogs	2

MODEL	NEEDLE HEAD	PRESSER FOOT ASSEMBLY	THROAT PLATE	FEED DOG MAIN	FEED DOG DIFFERENTIAL
FS322C01-2D32	50318AM32	50320U8	34724XX8	50305AZ	50326AZ
FS322C01-2D40	50318AM40	50320U12	34724XX10		
FS322C01-2D48	50318AM48	50320V48	50324XX48	50305AU	50326AG
FS322C01-3D48			34724XX48		
FS322C01-3D56	50318AM56	50320V16	34724XX56		
FS322C01-3D64	50318AM64		34724XX64		
FS332C01-2D32	50318AM32	50320U8	34724XX8	50305AZ	50326AZ
FS332C01-2D40	50318AM40	50320U12	34724XX10		
FS332C01-2D48	50318AM48	50320V48	50324XX48	50305AU	50326AG
FS332C01-3D48			34724XX48		
FS332C01-3D56	50318AM56	50320V16	34724XX56		
FS332C01-3D64	50318AM64		34724XX64		



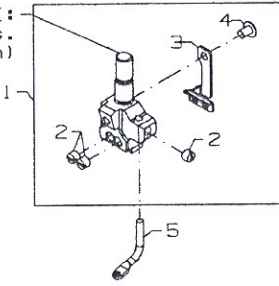
MODEL	NEEDLE HEAD	PRESSER FOOT ASSEMBLY	THROAT PLATE	FEED DOG MAIN	FEED DOG DIFFERENTIAL
FS322E12-2D32	50318AM32	50320W8	34824TD8	50305AZ	50326BA
FS322E12-2D40	50318AM40	50320W12	34824TD10		50326BB
FS322E12-2D48	50318AM48	50320X48	34824TD48	50305AU	50326AF
FS322E12-3D48					
FS322E12-3D56	50318AM56	50320X16	34824TD56		
FS322E12-3D64	50318AM64		34824TD64		



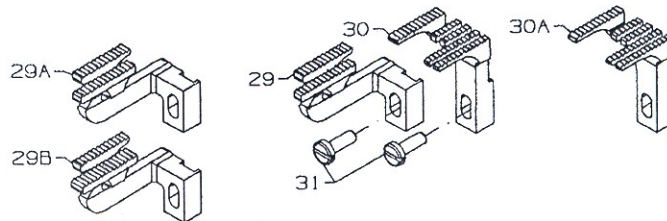
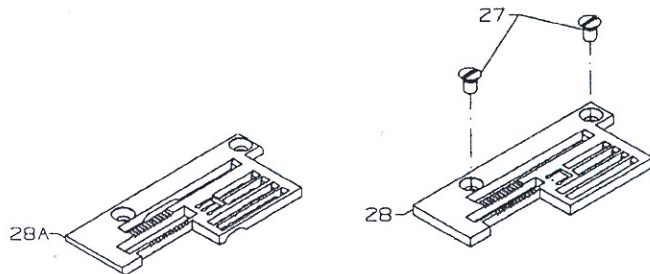
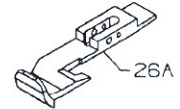
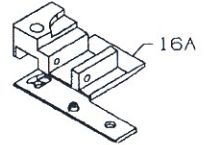
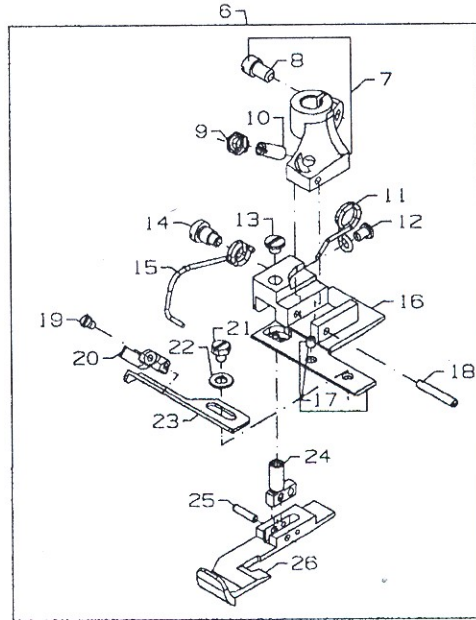
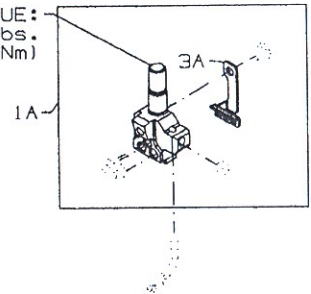
MODEL	NEEDLE HEAD	PRESSER FOOT ASSEMBLY	THROAT PLATE	FEED DOG MAIN	FEED DOG DIFFERENTIAL
FS332E12-2D32	50318AM32	50320W8	34824TD8	50305AZ	50326BA
FS332E12-2D40	50318AM40	50320W12	34824TD10		50326BB
FS332E12-2D48	50318AM48	50320X48	34824TD48	50305AU	50326AF
FS332E12-3D48					
FS332E12-3D56	50318AM56	50320X16	34824TD56		
FS332E12-3D64	50318AM64		34824TD64		



TORQUE:
14-16 in. lbs.
(1.6-1.8 Nm)



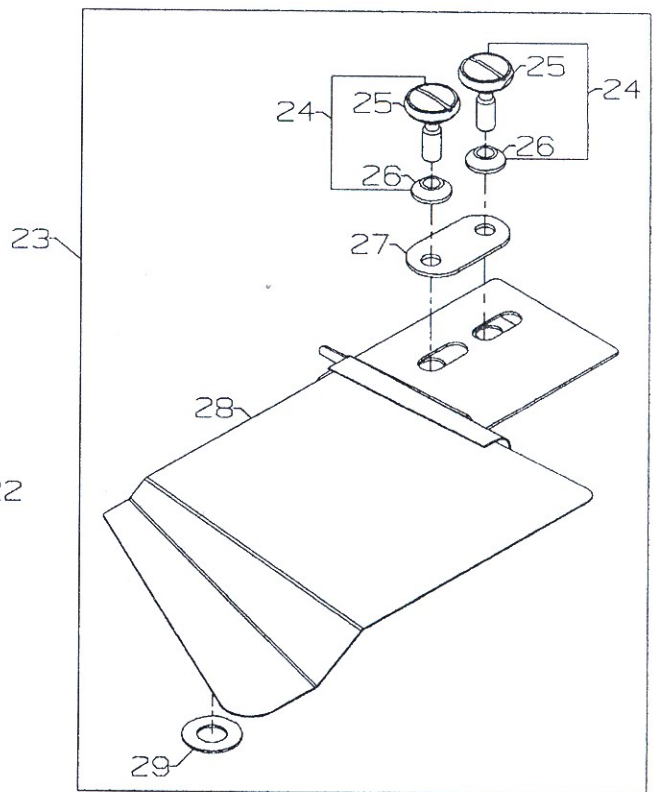
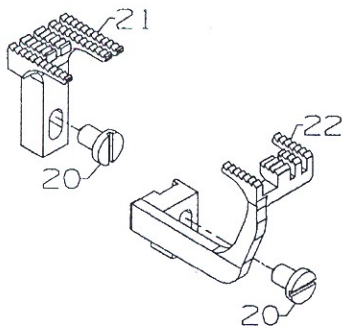
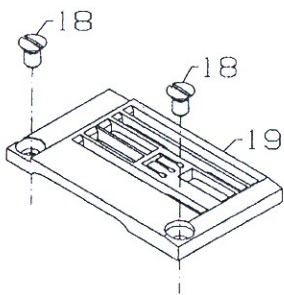
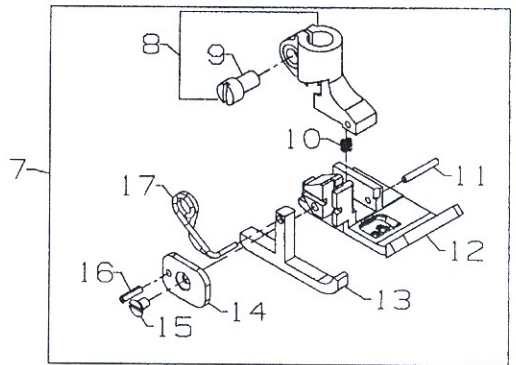
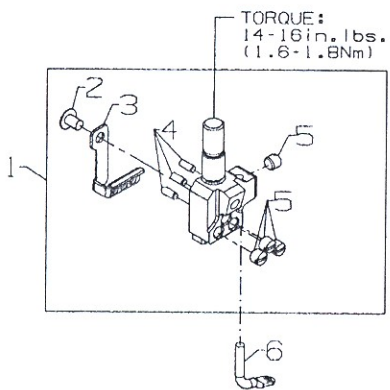
TORQUE:
14-16 in. lbs.
(1.6-1.8 Nm)



SEWING PARTS
FOR
FS322E12 & FS332E12

Ref. No.	Part No.	Description	Amt. Req.
1.	-----	Needle Head, for sewing comb., (see chart)	1
2.	SS5060410SP	Screw	4-6
3.	50318AE40	Eyelet, per needle head, for FE12-2D32, FE12-2D40	1
3a.	50318AE56	Eyelet, per needle head, for FE12-2D48, FE12-3D48, FE12-3D56, FE12-3D64	1
4.	SS6060440TP	Screw, for eyelet	1
5.	50392G	Needle Thread Eyelet	1
6.	-----	Presser Foot Assembly, for sewing comb., (see chart)	1
7.	52730T	Presser Foot Shank	1
8.	91	Screw	1
9.	51430F	Nut	1
10.	22840A	Screw	1
11.	97109	Spring	1
12.	605	Screw	1
13.	187A	Screw	1
14.	57WD	Screw	1
15.	52830G	Spring	1
16.	50330CE16	Presser Foot Bottom, per presser foot, for FE12-3D56, FE12-3D64	1
-	50330CE48	Presser Foot Bottom, per presser foot for, FE12-2D48, FE12-3D48	1
16A.	50330CC8	Presser Foot Bottom, per presser foot for, FE12-2D32	1
-	50330CC12	Presser Foot Bottom, per presser foot for, FE12-2D40	1
17.	73B	Screw	1
18.	22799B	Screw	1
19.	22738B	Screw	1
20.	34830MA	Tape Margin	1
21.	99373A	Screw	1
22.	95956	Washer	1
23.	34830LA	Tape Guide	1
24.	G65-181	Plunger	1
25.	96532	Roll Pin	1
26.	50330CF	Yielding Section, for sewing comb., FE12-2D48, FE12-3D48, FE12-3D56, FE12-3D60, FE12-3D64	1
26A.	50330CD	Yielding Section, for sewing comb., FE12-2D32, FE12-2D40	1
27.	87	Screw, for throat plate	2
28.	-----	Throat Plate, for sewing comb., (see chart).....	1
28A.	-----	Throat Plate, for sewing comb., (see chart)	1
29.	-----	Differential Feed Dog, for sewing comb., (see chart).....	1
29A.	-----	Differential Feed Dog, for sewing comb., (see chart).....	1
29B.	-----	Differential Feed Dog, for sewing comb., (see chart)	1
30.	-----	Main Feed Dog, for sewing comb., (see chart)	1
30A.	-----	Main Feed Dog, for sewing comb., (see chart)	1
31.	SS7091110TP	Screw, for feed dogs	2





SEWING PARTS
FOR
FS335E41 & FS335E42

Ref. No.	Part No.	Description	Amt. Req.
1.	50318AA56	Needle Head, for sewing comb., (see chart)	1
-	50318AA64	Needle Head, for sewing comb., (see chart)	1
2.	SS5060410SP	Round Head Screw	1
3.	50318AE56	Eyelet, needle head, for sewing comb. (see chart)	1
4.	660-1046	Pin	3
5.	SS8080310TP	Screw	4
6.	50392G	Eyelet	1
7.	50320BF64	Presser Foot Assembly	1
8.	G57730GB	Shank	1
9.	91	Screw	1
10.	G57730GD	Torsion Spring	1
11.	6-25-55	Pin (01.5 x 10.5)	1
12.	50330BH64	Presser Foot Bottom	1
13.	34730A	Yielding Section	1
14.	G57730GC	Plate	1
15.	22716	Screw	1
16.	96651	Roll Pin	1
17.	39568J	Pressure Spring	1
18.	87	Screw, for throat plate	2
19.	50324DB56	Throat Plate, for sewing comb., (see chart)	1
-	50324DC64	Throat Plate, for sewing comb., (see chart)	1
20.	SS7091110TP	Screw, for feed dogs	2
21.	50305BS	Main Feed Dog	1
22.	50326BL	Differential Feed Dog	1
23.	29480AWR	Folder Kit	1
24.	25	Gauge Screw Assembly	2
25.	201C	Gauge Screw	2
26.	25D	Washer	2
27.	57864B	Washer Plate	1
28.	50389B	Folder	1
-	21210	Looper Collar (not shown)	1
29.	51493AF	Isolator	1

MODEL	NEEDLE HEAD	PRESSER FOOT ASSEMBLY	THROAT PLATE	FEED DOG MAIN	FEED DOG DIFFERENTIAL
FS332E12-2D32	50318AM32	50320W8	34824TD8	50305AZ	50326BA
FS332E12-2D40	50318AM40	50320W12	34824TD10		50326BB
FS332E12-2D48	50318AM48	50320X48	34824TD48	50305AU	50326AF
FS332E12-3D48					
FS332E12-3D56	50318AM56	50320X16	34824TD56		
FS332E12-3D64	50318AM64		34824TD64		

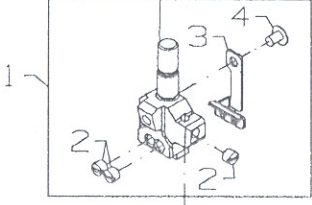


MODEL	NEEDLE HEAD	PRESSER FOOT ASSEMBLY	THROAT PLATE	FEED DOG MAIN	FEED DOG DIFFERENTIAL
FS322H01-2A32	50318AM32	50320AH	50324BL32	50305BM	50326AY
FS322H01-2C32			34724F8		
FS322H01-2A40	50318AM40		50324BL40		
FS322H01-2C40			34724F10		
FS322H01-2A48	50318AM48	50320T48	50324BL48		
FS322H01-2C48			34724F48		
FS322H01-3A48			50324BL48		
FS322H01-3B48			50324BS48		
FS322H01-3C48			34724F48		
FS322H01-3A56	50318AM56	50320T60	50324BL56		
FS322H01-3B56			50324BS56		
FS322H01-3C56			34724F56		
FS322H01-3A64	50318AM64		50324BL64		
FS322H01-3B64			50324BS64		
FS322H01-3C64			34724F64		
FS332H01-2A32	50318AM32	50320AH	50324BL32		
FS332H01-2C32			34724F8		
FS332H01-2A40	50318AM40		50324BL40		
FS332H01-2C40			34724F10		
FS332H01-2A48	50318AM48	50320T48	50324BL48		
FS332H01-2C48			34724F48		
FS332H01-3A48			50324BL48		
FS332H01-3B48			50324BS48		
FS332H01-3C48			34724F48		
FS332H01-3A56	50318AM56	50320T60	50324BL56		
FS332H01-3B56			50324BS56		
FS332H01-3C56			34724F56		
FS332H01-3A64	50318AM64		50324BL64		
FS332H01-3B64			50324BS64		
FS332H01-3C64			34724F64		

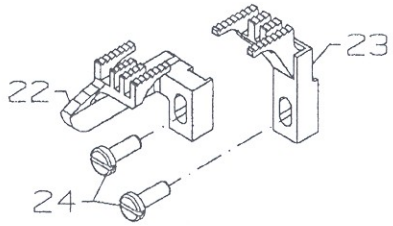
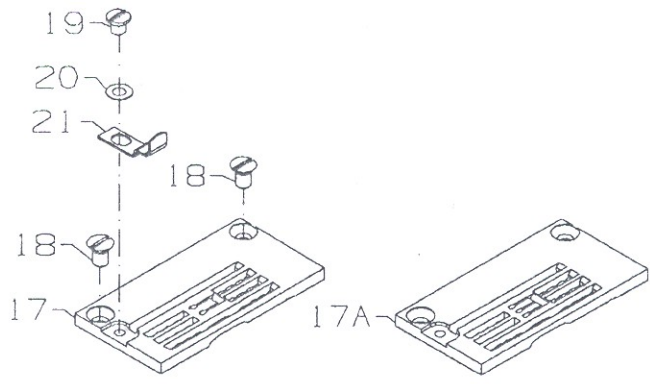
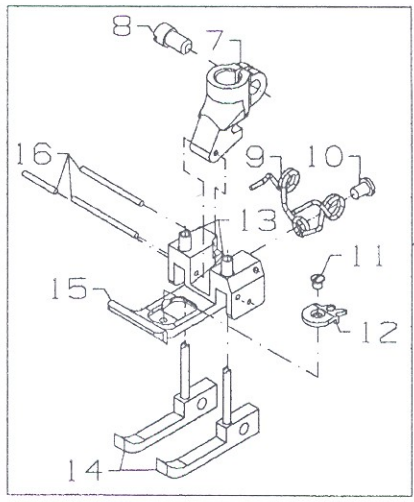
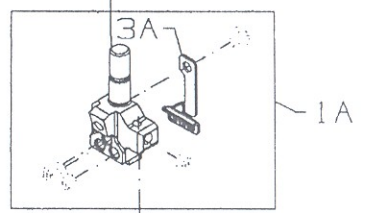
MODEL	NEEDLE HEAD	PRESSER FOOT ASSEMBLY	THROAT PLATE	FEED DOG MAIN	FEED DOG DIFFERENTIAL
FS332L01-2A32	50318AM32	50320AH	50324BN32	50305AN	50326AE
FS332L01-2C32			50324BM32		
FS332L01-2A40	50318AM40		50324BK40		
FS332L01-2C40			50324BJ40		
FS332L01-3A48	50318AM48	50320T48	50324BN48		
FS332L01-3B48			50324BR48		
FS332L01-3C48			50324BM48		
FS332L01-3A56	50318AM56	50320T60	50324BN56		
FS332L01-3B56			50324BR56		
FS332L01-3C56			50324BM56		
FS332L01-3A64	50318AM64		50324BN64		
FS332L01-3B64			50324BR64		
FS332L01-3C64			50324BM64		
FS332L21-3A56	50318AM56		50324BN56	50305AV	50326AX
FS332L21-3B56			50324BR56		
FS332L21-3C56			50324BM56		
FS332L21-3A64	50318AM64		50324BN64		
FS332L21-3B64			50324BR64		
FS332L21-3C64			50324BM64		



TORQUE:
14-16 in. lbs.
(1.6-1.8 Nm)

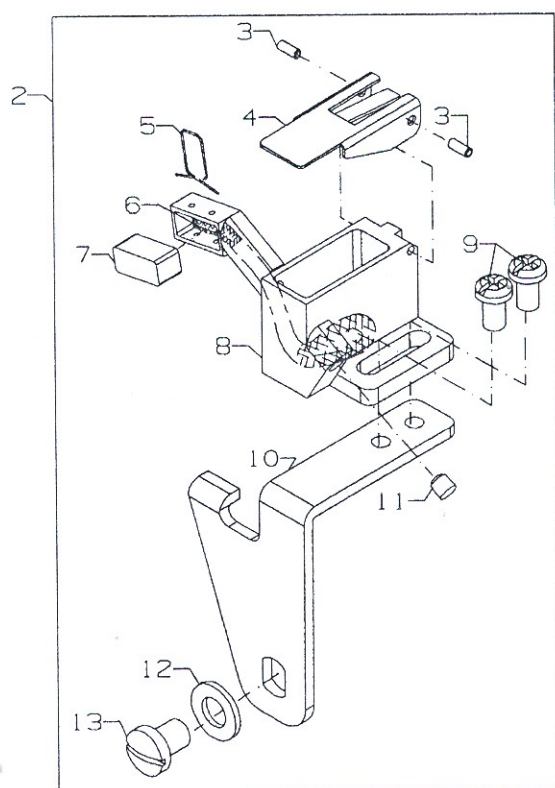
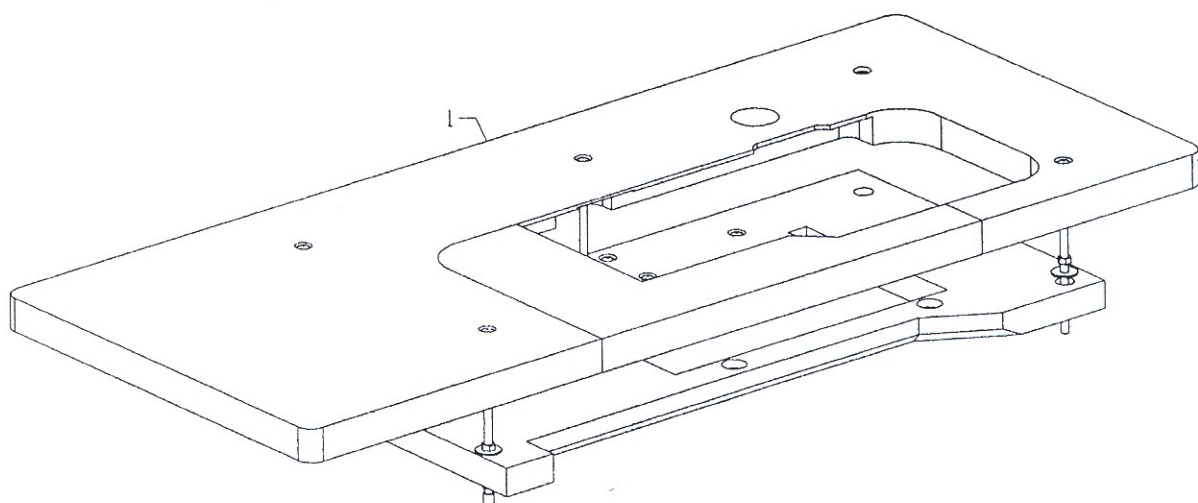


TORQUE:
14-16 in. lbs.
(1.6-1.8 Nm)



SEWING PARTS
FOR
FS322H01, FS332H01, FS332L01, FS332L21

Ref. No.	Part No.	Description	Amt. Req.
1.	-----	Needle Head, for two needle machines (see chart)	1
1A.	-----	Needle Head, for three needle machines (see chart)	1
2.	SS8080310TP	Screw	3/4
3.	50318AE40	Eyelet, per needle head, for sewing comb.,	1
3A.	50318AE56	Eyelet, per needle head, for sewing comb.,	1
4.	S5060410TP	Screw	1
5.	50392G	Needle Thread Eyelet	1
6.	-----	Presser Foot, for sewing comb., (see chart)	1
7.	G65-134	Presser Foot Shank	1
8.	91	Screw	1
9.	79633	Spring	1
10.	605	Screw	1
11.	22716A	Screw	1
12.	50397A16	Stitch Tongue, per presser foot, for gauges 5.6, 6.4	1
-	50397A48	Stitch Tongue, per presser foot, for gauge 4.8	1
12A.	50397C	Stitch Tongue, per presser foot, for gauges 3.2, 4.0	1
13.	G50-266	Bushing	2
14.	57830A	Yielding Section	1
15.	50330BL16	Presser Foot Bottom	2
16.	6-25-55	Drill Rod	3
17.	-----	Throat Plate, for sewing comb., (see chart)	1
17A.	-----	Throat Plate, for sewing comb., (see chart)	1
18.	87	Screw, for throat plate	2
19.	22561	Screw, for guide	1
20.	27-435BLK	Washer, for screw	2
21.	23195	Guide	1
22.	-----	Differential Feed Dog, for sewing comb., (see chart)	1
23.	-----	Main Feed Dog, for sewing comb., (see chart)	1
24.	SS7091110TP	Screw, for feed dogs	2

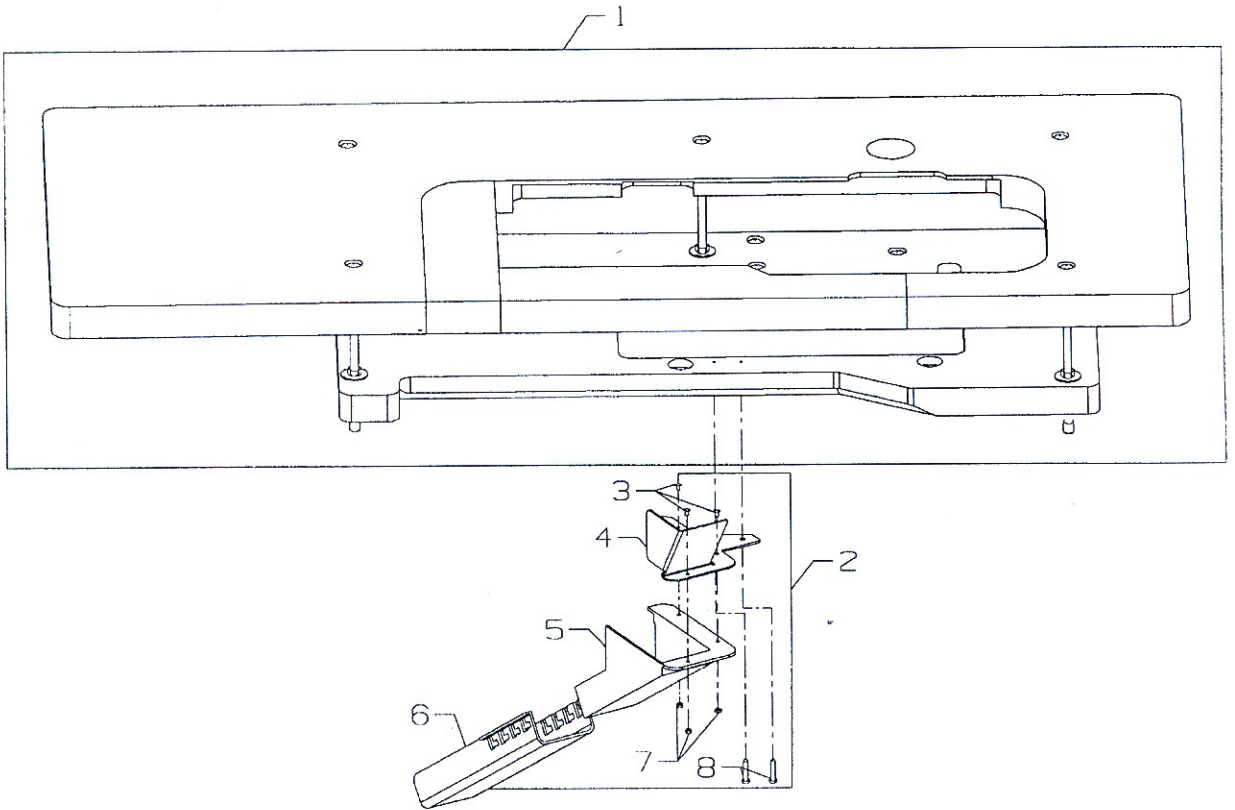


TABLING AND NEEDLE DIPPER ASSEMBLY
(EXTRA SEND CHARGE)
FOR

FS322C01, FS332C01, FS335E41, FS335E42
FS322H01, FS332H01, FS332L01, FS332L21

Ref. No.	Part No.	Description	Amt. Req.
1.	21371AAE48	Table Board	1
2.	29476RZ	Needle Dipper Assembly	1
3.	PS0160042KH	Roll Pin	2
4.	50393JD	Needle Dipper Cover	1
5.	50393GS	Wire, for needle dipper	1
6.	CQ202000000	Oil Wick, for needle dipper	1
7.	50393GK	Felt, for needle dipper	1
8.	50393JC	Needle Dipper	1
9.	SS4090615SP	Screw, for needle dipper	2
10.	50393GP	Silicone Oil Tank Holder	1
11.	50393GG	Plug	1
12.	WP0531000SD	Washer	1
13.	SS4120615SP	Screw, for needle dipper holder.....	1

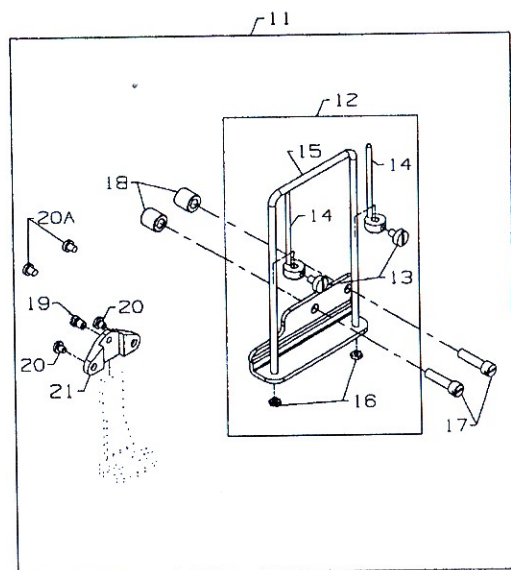
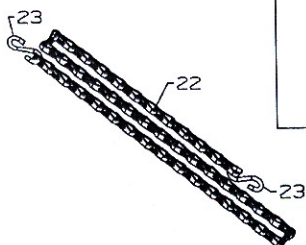
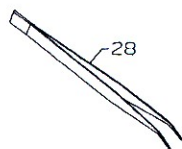
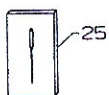
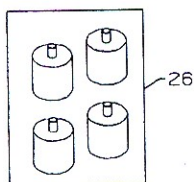
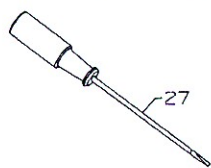
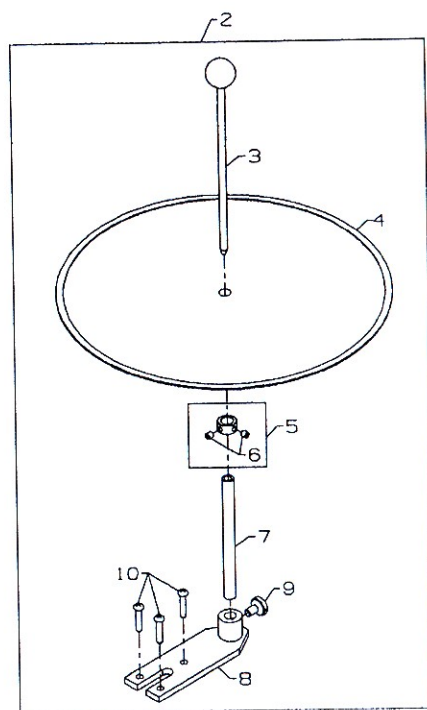
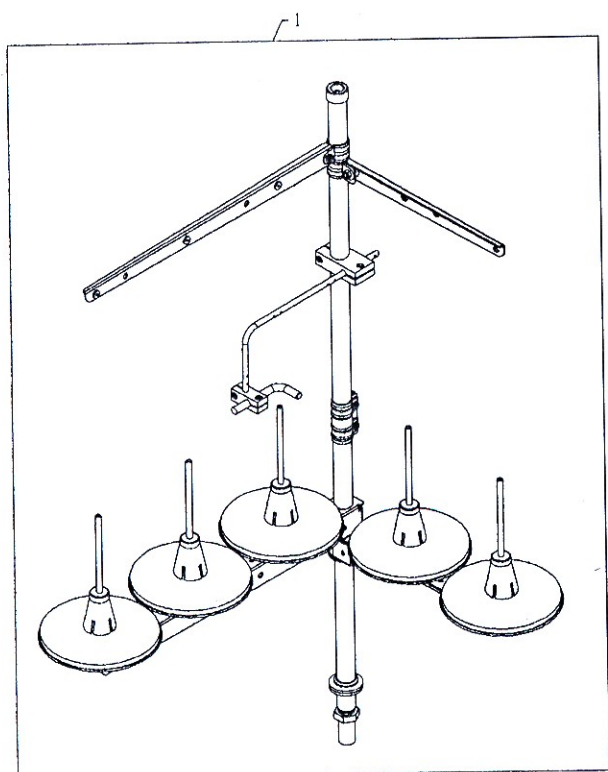




TABLING (EXTRA SEND CHARGE)
FOR
FS322E12 & FS332E12

Ref. No.	Part No.	Description	Amt. Req.
1.	21371AAG48	Table Board	1
2.	29480WR1	Waste Removal Kit	1
3.	SS5091020SP	Screw	3
4.	50383AC	Bracket	1
5.	11960101	Waste Chute	1
6.	11960002	Chute Extension	1
7.	NS6090310SP	Nut	3
8.	90561K	Wood Screw	2

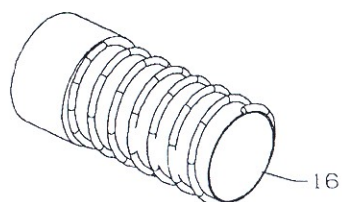
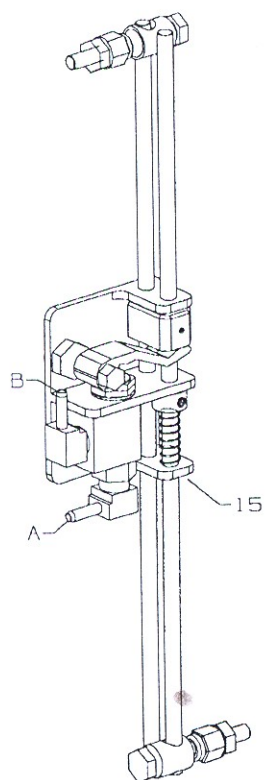
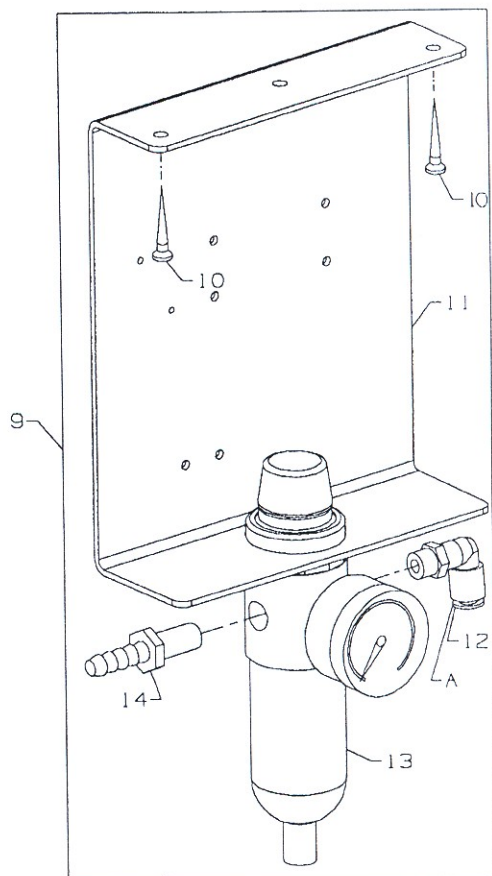




ACCESSORIES

Ref. No.	Part No.	Description	Amt. Req.
1.	11969557	Thread Stand	1
2.	29480AHU	Tape Reel Assembly, for FS322C01, FS332C01	1
3.	50322L	Support Shaft	1
4.	50392C	Tape Disc	1
5.	482C	Collar	1
6.	22894C	Screw	2
7.	50322H	Shaft	1
8.	50364A	Holder	1
9.	22728	Thumb Screw	1
10.	90561K	Wood Screw	3
11.	29480ASR	Strip Tension Kit, for FS322C01, FS332C01	1
12.	23439L	Tension Assembly	1
13.	188D	Screw	2
14.	23439F	Adjustable Pin	2
15.	51-651BLK	Guide	1
16.	907	Nut	2
17.	SS6151920SP	Screw	2
18.	50392D	Spacer	2
19.	22852G	Screw	1
20.	SS7110510SP	Screw	2
20A.	25CC	Screw	2
21.	23432B	Folder Clamp	1
22.	421D34	Chain	1
23.	660-264	S-Hook	2
24.	TT17	Wrench, for FS322E12, FS332E12, FS335E41, FS335E42	1
25.	128GBS075/029	Needles (package of 10)	1
26.	35095B	Isolator	4
27.	G21201	Screw Driver, for needle head	1
28.	660-240	Thread Tweezer	1
29.	28604R	Oil (1 pint)	2



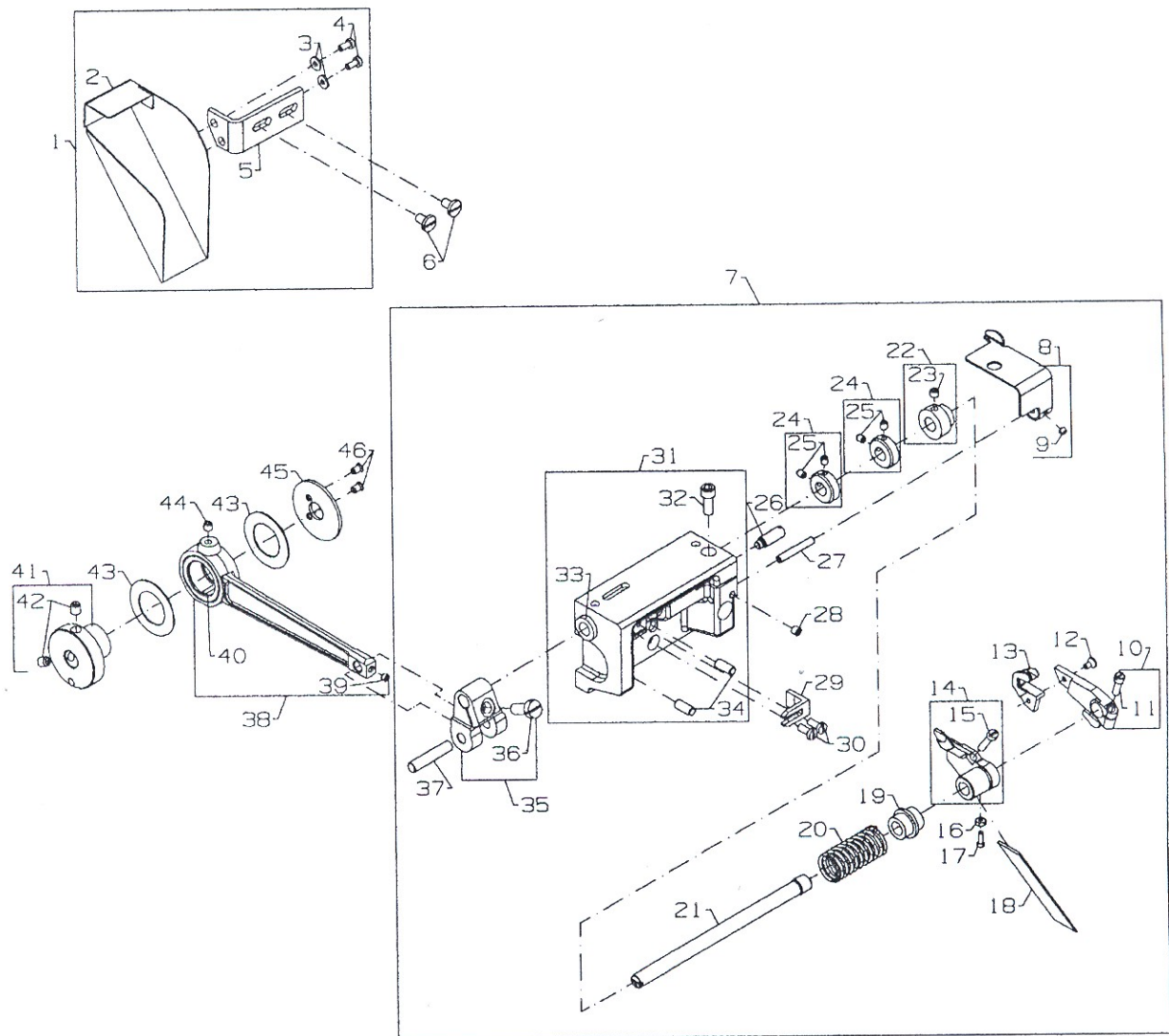


TUBE DIA.	TUBE
1/4 IN.	A
6 mm	B

VACUUM TUBE ASSEMBLY AND PNEUMATIC CONTROL (EXTRA SEND CHARGE)
FOR
FS322E12 & FS332E12

Ref. No.	Part No.	Description	Amt. Req.
1.	29480WR2	Pneumatic Waste Removal Kit	1
2.	50394AH	Vacuum Tube Assembly	1
3.	999-175DA	Fitting	1
4.	50373CR1	Bracket	1
5.	41358	Washer	2
6.	J87J	Screw	2
7.	50373DJ	Tube, for vacuum	1
8.	88D	Screw	2
9.	29480ASU	Pneumatic Control Kit	1
10.	90561K	Wood Screw	2
11.	99683CP	Mounting Bracket	1
12.	671F81A	Elbow Fitting - 6mm x 1/2" NPT	1
13.	671FD42	Filter/Regulator Assembly	1
14.	671F88	Barb Fitting	1
15.	29480ARN	Treadle Switch Assembly	1
16.	99675QB800	Spiral Plastic Hose	1

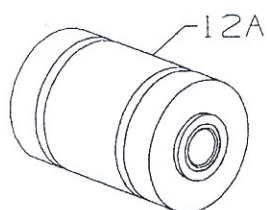
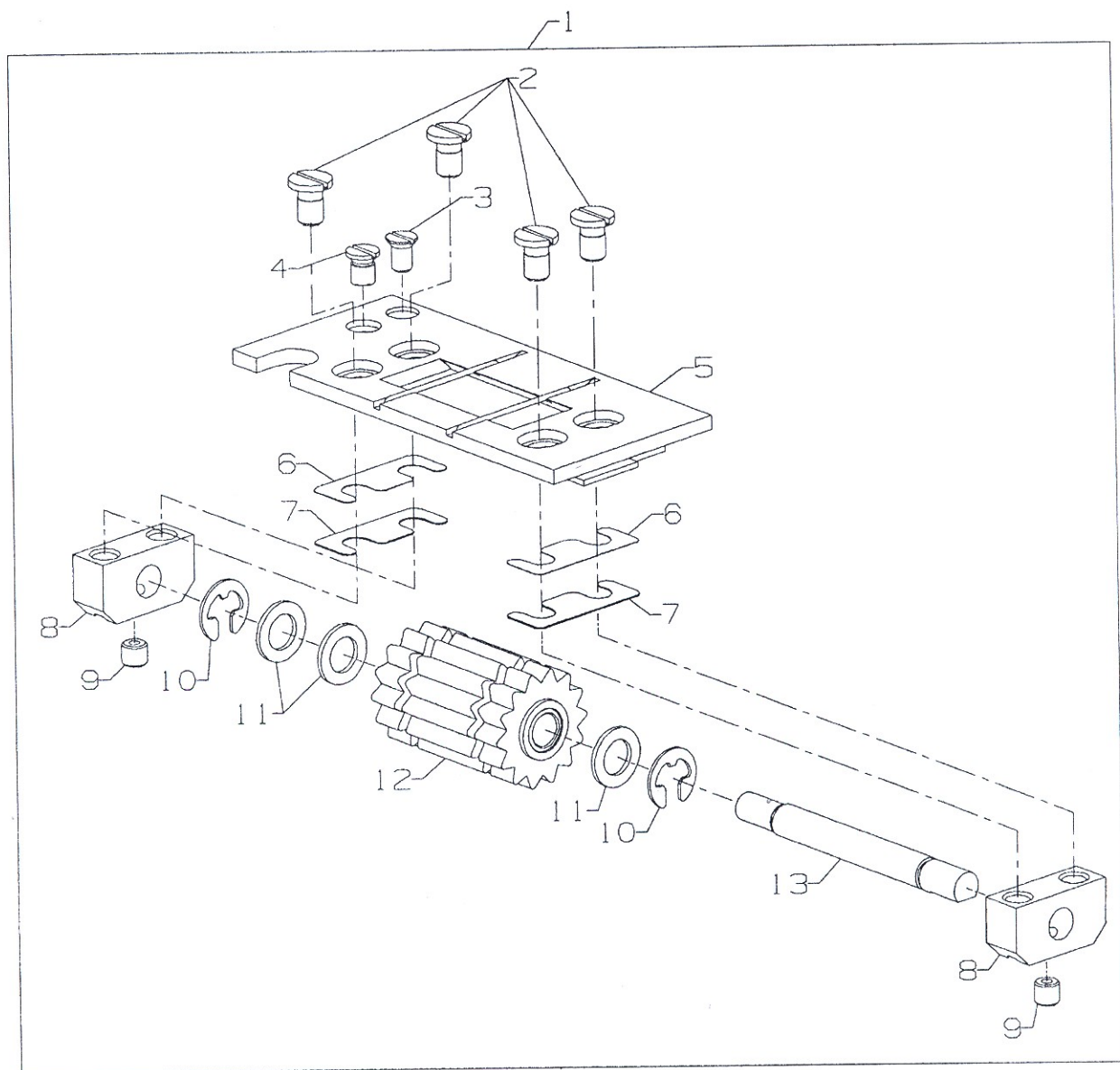




UNDERBED THREAD TRIMMER
FOR
FS322E12 & FS332E12

Ref. No.	Part No.	Description	Amt. Req.
1.	50394AK	Chip Chute Assembly	1
2.	50378U	Chip Chute	1
3.	41358	Washer	2
4.	J87J	Screw	2
5.	50373CR1	Bracket	1
6.	88D	Screw	2
7.	50349B	Undertrimmer Assembly	1
8.	50373DF	Edge Guide	1
9.	22743	Screw	1
10.	34771PA	Upper Knife Holder	1
11.	22729	Screw	1
12.	99316G	Screw	1
13.	34770AH	Upper Knife	1
14.	34750CA	Lower Knife Holder	1
15.	22729E	Screw	1
16.	51250C	Nut	1
17.	22797	Screw	1
18.	34749A	Lower Knife	1
19.	50373D	Collar	1
20.	97010D	Spring	1
21.	50373B	Shaft	1
22.	50373E	Collar	1
23.	22894W	Screw	1
24.	34334D	Thrust Collar	2
25.	22565C	Screw	4
26.	99364	Screw	1
27.	50373DE	Undertrimmer Housing	1
28.	96531	Pin	2
29.	99371G	Screw	1
30.	50373A	Bushing, left	1
31.	50373G	Bracket	2
32.	22585	Screw	1
33.	136	Screw	1
34.	50373DH	Lever Clamp	1
35.	50373K	Link Pin	1
36.	999-313N	Needle Bearing	2
37.	22894E	Screw	1
38.	22894Y	Screw	1
39.	99371G	Screw	1
40.	50373CB	Eccentric, for knife drive	1
41.	22894AD	Screw	2
42.	50373CD	Washer	2
43.	50368AA	Connecting Arm, for knife drive	1
44.	999-313F	Needle Bearing	1
45.	22894W	Screw	1
46.	50373CC	Retaining Plate	1
47.	22766	Screw	2

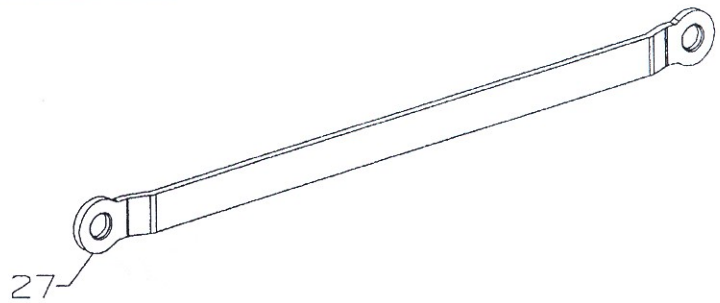
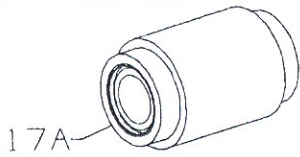
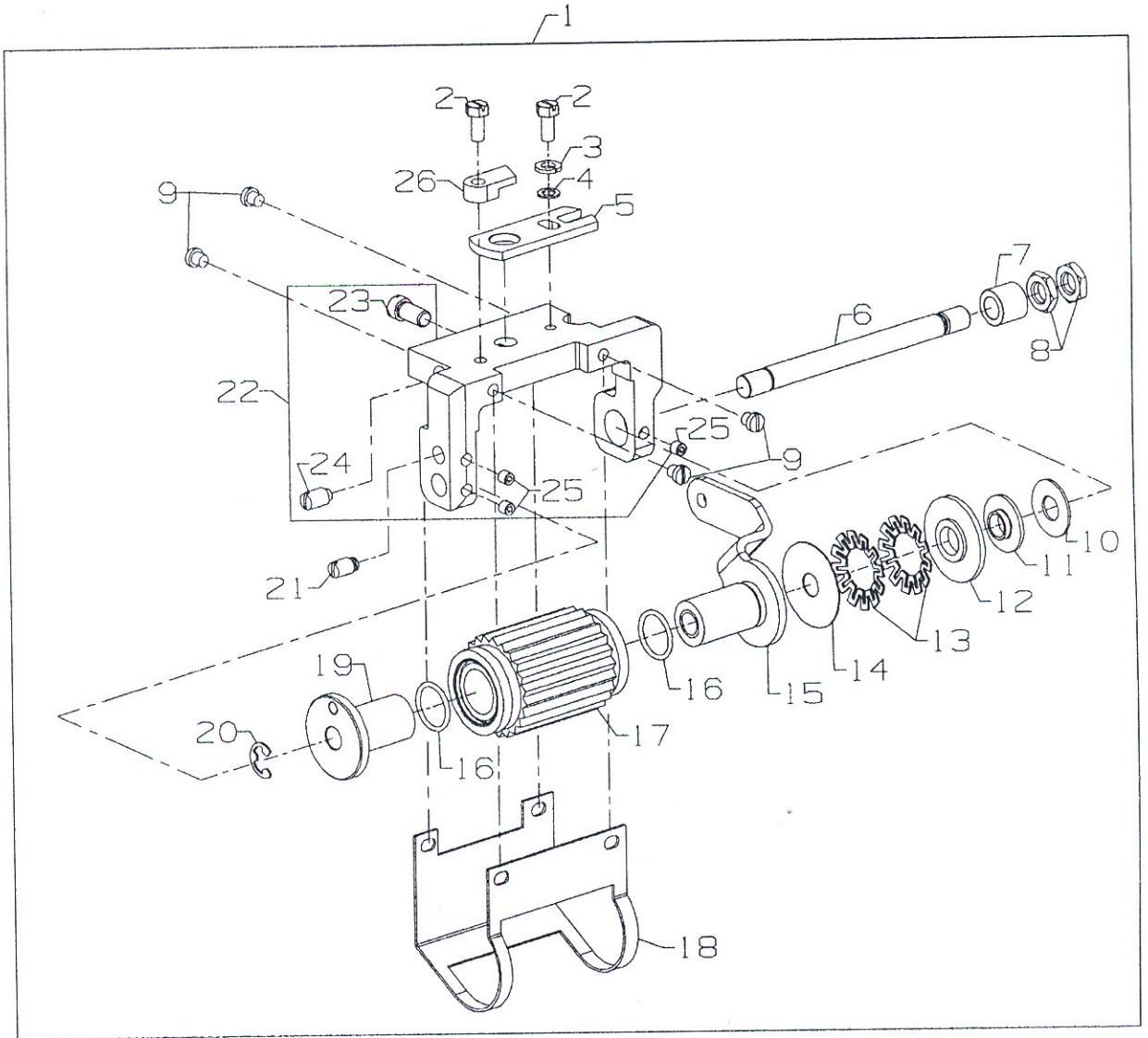




LOWER ROLLER ASSEMBLY
FOR
FS335E41 & FS335E42

Ref. No.	Part No.	Description	Amt. Req.
1.	29476PV	Lower Roller Assembly, for styles FS335E41	1
-	29476PJ	Lower Roller Assembly, for styles FS335E42	1
2.	376	Screw	4
3.	AS22D	Screw	1
4.	SS1110710SP	Screw	1
5.	50378E	Feed Plate	1
6.	C50078AF5	Shim	2
7.	C50078AF10	Shim	2
8.	C50078U	Bearing Block	2
9.	22894W	Set Screw	2
10.	660-330	Retaining Ring	2
11.	6042A	Washer	3
12.	50375D	Puller Roller, for styles FS335E41	1
12A.	C50076	Lower Roller (smooth), for styles FS335E42.....	1
13.	C50074	Pin	1

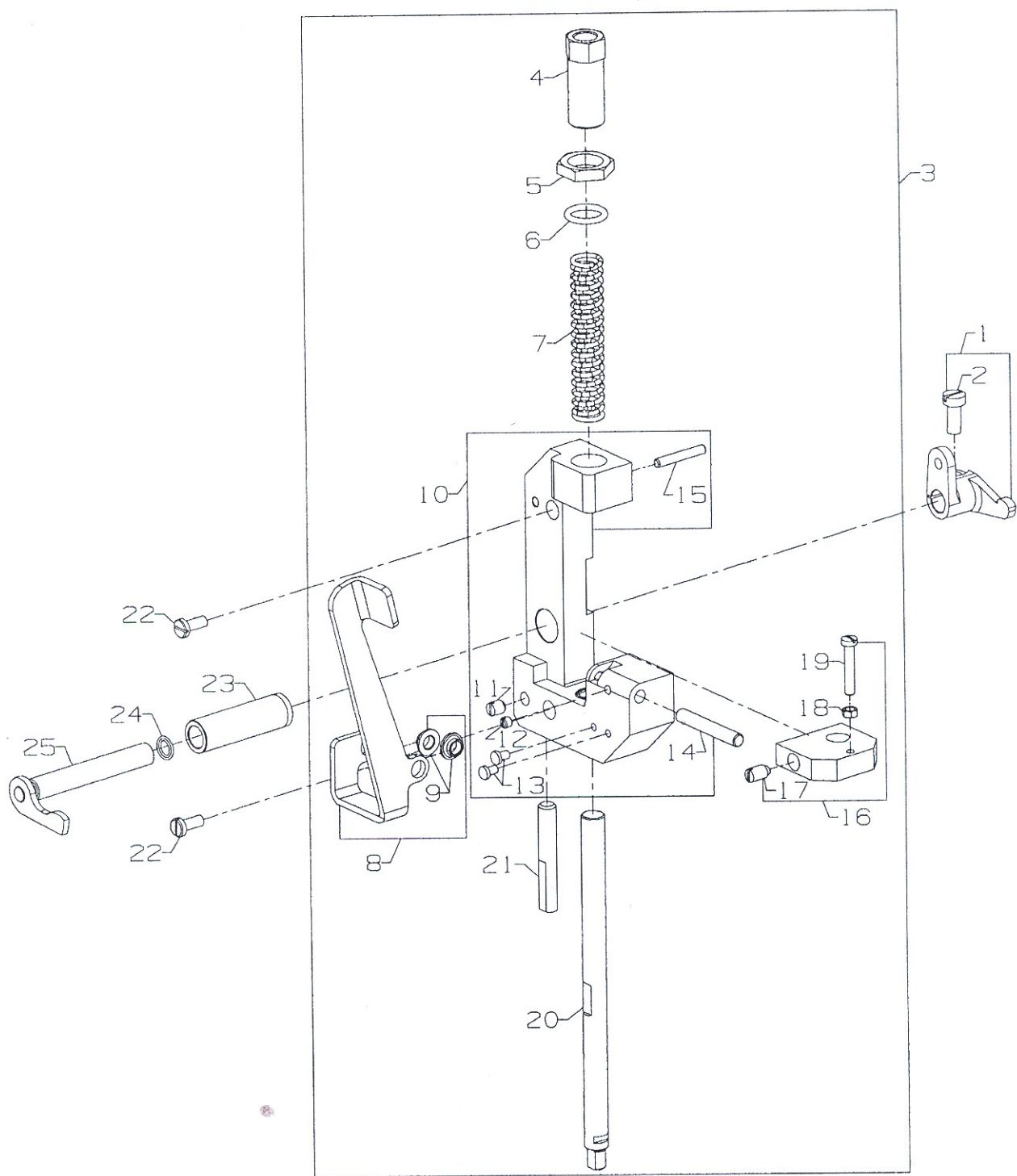




UPPER ROLLER ASSEMBLY
FOR
FS335E41 & FS335E42

Ref. No.	Part No.	Description	Amt. Req.
1.	29476UW	Upper Roller Assembly, for styles FS335E41	1
-	29476ST	Upper Roller Assembly, for styles FS335E42	1
2.	SS9111010SP	Hex Screw	2
3.	WS0510002KP	Lock Washer	1
4.	53634C	Washer	1
5.	34778D	Guide Plate	1
6.	34774	Shaft	1
7.	34778A	Bushing	1
8.	11638M	Stud Nut	2
9.	SS7110410SP	Screw	4
10.	C50077K	Washer	1
11.	34778C	Bushing	1
12.	50377AE	Disc	1
13.	661-261	Cup Spring	2
14.	50386B	Washer	1
15.	50377H	Lever Assembly	1
16.	661-149	"O" Ring	2
17.	50375Y	Roller Assembly, for styles FS335E41	1
17A.	50375V	Roller Assembly (smooth), for styles FS335E42	1
18.	50377AC	Roller Guard	1
19.	50377AD	Bushing	1
20.	96278	"E" Ring	1
21.	22892C	Shoulder Screw	1
22.	50377AJ	Feed Roller Yolk Assembly	1
23.	SS6151220SP	Screw	1
24.	SS8151150SP	Screw	1
25.	SS8110422TP	Set Screw	3
26.	50377AL	Stop Lever	1
27.	50355AS	Connector, for Presser Foot Lift	1

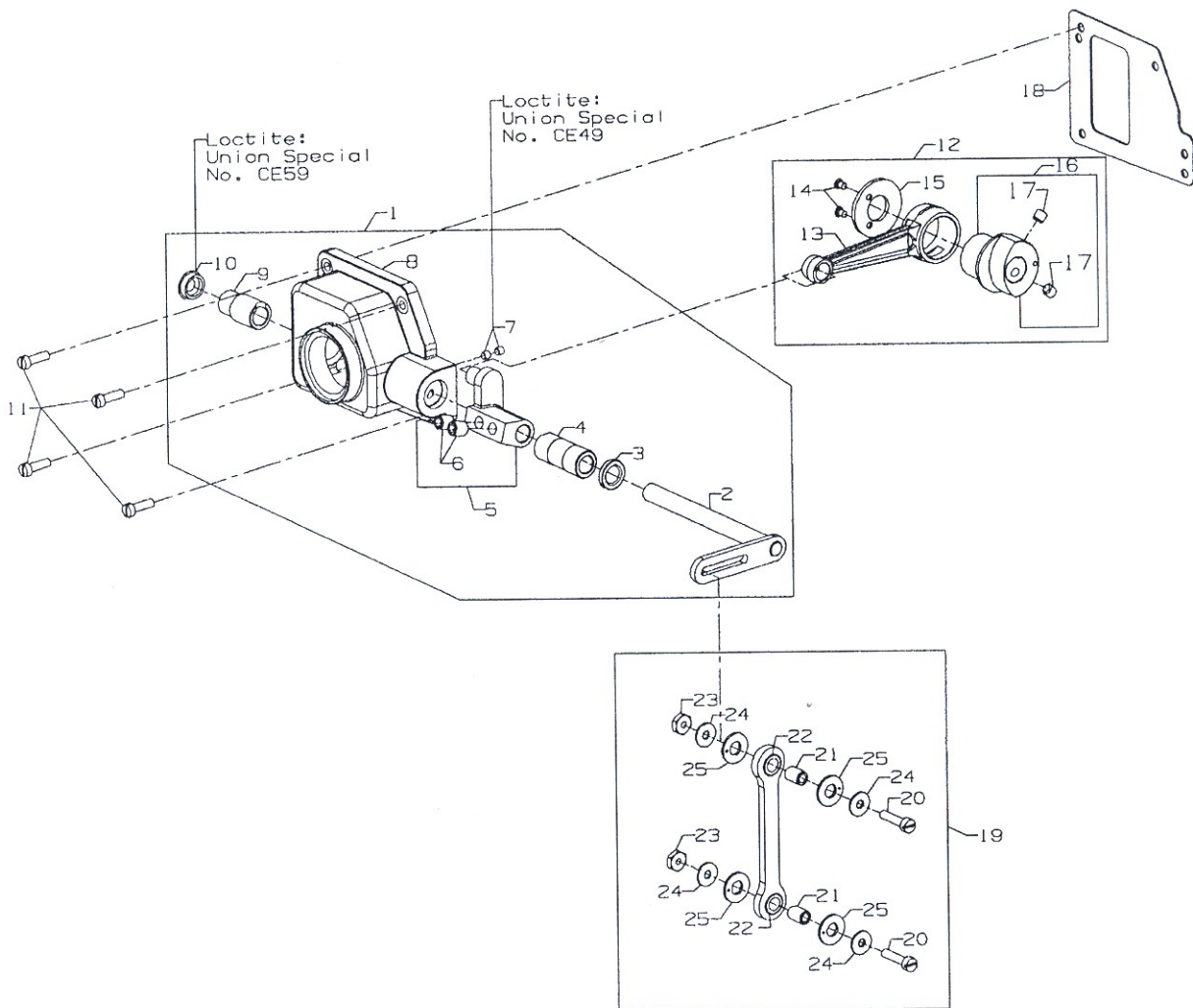




PULLERLIFTERASSEMBLY
FOR
FS335E41 & FS335E42

Ref. No.	Part No.	Description	Amt. Req.
1.	50377VA	Lever, lifter front	1
2.	SS6151440SP	Screw	1
3.	29476UX	Puller Lifter Assembly	1
4.	59477	Regulator	1
5.	35733G	Nut	1
6.	660-212	"O" Ring	1
7.	50377L	Spring	1
8.	50377C	Lever, lifter	1
9.	50344AT	Bushing	2
10.	50377D	Bracket, for roller lifter	1
11.	SS8150710SP	Set Screw	1
12.	SS8120410SP	Set Screw	1
13.	50337AM	Bumper	2
14.	50377AF	Pin	1
15.	96529	Pin	1
16.	50377M	Lifter	1
17.	SS8151150SP	Screw	1
18.	NS6110310SP	Nut	1
19.	SS7112420SP	Screw	1
20.	50377AM	Bar, roller presser	1
21.	50377Y	Guide Pin	1
22.	SS6121220TP	Screw	2
23.	50377T	Bushing, lifter link	1
24.	RO068190100	"O" Ring	1
25.	50377G	Lever, Puller Lifter	1





PULLER DRIVE ASSEMBLY
FOR
FS335E41 & FS335E42

Ref. No.	Part No.	Description	Amt. Req.
1.	29476SP	Puller Drive Assembly	1
2.	50377F	Roller Driving Arm	1
3.	660-893	Seal	1
4.	50377S	Bushing	1
5.	50377E	Lever, puller drive	1
6.	SS8110510SP	Set Screw	1
7.	50377U	Housing, puller drive	1
8.	50377P	Bushing	1
9.	TA1450404R0	Rubber Plug	1
10.	SS7121610SP	Screw	4
11.	50377Z	Connecting Rod Eccentric Assembly	1
12.	50377AA	Connecting Rod	1
13.	SS2090620SP	Screw	2
14.	50386	Washer	1
15.	50377AB	Eccentric	1
16.	SS8660612TP	Screw	2
17.	660-1090	Quad Ring	1
18.	50377J	Roller Drive Link Assembly	1
19.	SS6122030SP	Screw	2
20.	50344AP	Bushing, link	2
21.	660-303	Bearing	2
22.	NS6120480SP	Nut	2
23.	WP0501046SC	Washer	4
24.	660-1089	Thrust Washer	4



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