



TABLE MODEL CARPET BINDER & FRINGER

OPERATING INSTRUCTIONS MAINTENANCE MANUAL PARTS & ASSEMBLIES LISTS



Model HDP Portable Double Puller



Model TMB-1 Double Puller

BOND PRODUCTS INC

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10 Reason\$ to Bind Carpet\$

10. "Gift" your customers with their own "scrap" rugs. Make a positive from a negative.
9. Laminate, hardwood & ceramic tile has been steadily eroding your carpet business.
8. Rugs don't require installation but do require profitable pad type products.
7. Every hard surface floor will end up with rugs on them. "Double Dip" your sale
6. Hardwood stairs are everywhere and are LOUD.
Quiet your customers' house and solve noise pollution in the home.
5. Fire places expel hot ashes. A rug is expendable – hardwood is not.
4. Designer rugs and runners sell well. Make these make you money.
3. Designer rugs create custom profits.
Design, fabricate & bind your own "one of a kind masterpiece".
2. Carpet base is practical and used extensively in commercial work.

AND THE NUMBER 1 REASON IS:

It's the most profitable thing your warehouse person, installer, etc.
can do for your business.

The return percentage can't be touched elsewhere
in the floor covering business!



Introducing
BOND'S PORTABLE HDP DOUBLE PULLER CARPET BINDER
and
TMB-1 DOUBLE PULLER CARPET BINDER

This instruction manual has been prepared and written to guide you in the usage of your Portable HDP DOUBLE PULLER CARPET BINDER or TMB-1 DOUBLE PULLER CARPET BINDER. In order to obtain maximum efficiency from this machine, we urge you to read this entire manual thoroughly before using the machine for the first time.

Although this machine has been carefully assembled, inspected and tested, should it ever need factory service, we recommend it be shipped in its original carton. If the original carton is no longer available, you may use a sturdy carton with ample room to allow packing material (i.e. foam, carpeting, etc.) to surround the entire machine, (especially the bottom) to prevent it from shifting inside while in transit.

Send or address all inquiries or returns to:

Service Manager
BOND PRODUCTS INC
4511 Wayne Avenue
Philadelphia PA 19144- 3639 USA
Call Toll Free (888-800-2663) or
Fax Toll Free (800-582-9643)

When ordering replacement parts or supplies identify the model and serial number of the machine. We recommend shipping the machine for repairs via UPS, FedEx, or Parcel Post. Be sure to insure its value in case of damage during transit.

BOND MANAGEMENT

Limited 90 Day Warranty

Bond Products, Inc. warrants the original purchaser of this product that it is free from defects in material and workmanship. Bond Products' sole obligation under this warranty is to replace any defective parts, to repair free of charge, for a period of 90 days from date of purchase. If service is required, please enclose a proof of purchase for validation of the warranty when returning your unit to Bond Products, Inc. All postage, insurance and shipping charges are the responsibility of the Purchaser and are not included in this warranty.

The provisions of this warranty shall not apply to any product which in Bond Products' judgment has been (1) subject to misuse or neglect, (2) damaged in an accident, (3) used for a purpose for which it was not designed, or (4) repaired or altered in any way that adversely affected its performance or reliability.

Bond Products, Inc. neither assumes nor authorizes any person to assume for it any other liability in connection with its products. There are no warranties which extend beyond the description on the face hereof. No responsibility is assumed for incidental or consequential damages that may result from the use of a Bond Products, Inc. product, for damages due to accident, abuse, lack of responsible care, the affixing of any unauthorized attachment, loss of parts, or use at a voltage other than specified.

Bond Products, Inc. disclaims all liabilities for defects or damages caused by use of replacement parts obtained from un-authorized source. This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.



WARNING

1. USE NEEDLE SIZE #23 DIAMOND AND WEDGE POINTS ONLY.
2. HOLD TOP THREAD WHEN STARTING OFF TO AVOID JAMMING THE HOOK.
3. OIL ALL POINTS, PAINTED IN RED, DAILY WITH A FEW DROPS OF STAINLESS MACHINE OIL, EXCEPT ON CLUTCH HOUSING SHAFTS, WHICH SHOULD BE OILED ONE DROP A WEEK.
4. MAKE SURE THAT THE TAKE-UP LEVER IS AT THE HIGHEST POINT WHEN REMOVING WORK.
5. IF MACHINE IS PLACED ON A TABLE OR WORK BENCH, BLOCK WHEELS TO PREVENT ACCIDENTAL ROLLING OFF THE TABLE SURFACE (HDPB ONLY).
6. KEEP SCISSORS AND OTHER TOOLS AWAY FROM THE MACHINE.
7. MAKE SURE BINDER HEAD (FOLDER) IS IN THE CORRECT POSITION.
8. CHECK TO INSURE MACHINE IS THREADED CORRECTLY.
9. DO NOT ALLOW ANYONE TO PLACE THEIR HANDS NEAR THE PULLERS WHEN MACHINE IS OPERATING.
10. BLOW OUT ROTARY HOOK AREA DAILY OR OFTEN, IF TOO MUCH LINT IS ACCUMULATING ON THE MACHINE.
11. PLACE A DROP OF OIL ON THE ROTARY HOOK AREA AFTER EVERY BOBBIN CHANGE.
12. ALWAYS HAVE BINDING TAPE UNDER THE PULLERS WHEN OPERATING THIS MACHINE.

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SPECIAL INSTRUCTIONS FOR MODEL HDP- HEAVY DUTY PORTABLE CARPET BINDER

SPEED CONTROL SETTINGS

The HDP Model is the most powerful portable carpet binder available, capable of binding all types of carpet. Due to the various types of carpet backing available, it is important to select the proper machine speed to match the carpet being bound.

Bond Products, Inc. recommends operating this machine between 5.5 minimum speed and 7.5 maximum speed marked in white on the speed dial. **Caution:** Do not select speed lower than 5.0 for it may cause the machine motor to overheat due to lack of speed of the motor cooling fan.

HDP HANDLING HINTS

Because of the extra weight of the HDP, extreme care should be taken whenever lifting this machine off the floor. If the HDP needs lifting up on a bench make sure that you place your hands securely on the machine and that the casters are blocked up to prevent the machine from rolling off the bench.

BOBBIN CASE RE-LOADING

To re-load the bobbin case, tilt the machine on its back until it is resting by its thread bracket. Then turn to Page 7 of the instruction manual for the proper way of threading the bobbin into the case.

PORTABLE TO TABLE MODEL CONVERSION

A table is available from Bond Products, Inc. for this purpose. You may order this table assembly from your dealer. If a dealer is not available, it can be ordered directly from Bond Products, Inc.

The table assembly consists of a 20" x 36" laminated top with a cut-out well for the binder to fit into. It has a utility light and a foot control switch. The height of the steel legs is adjustable.

DESCRIPTION

Models HDPB and TMB Single & Double puller carpet binders are especially intended for lockstitch, zigzag or straight stitching at high speed application of binding and fringe onto carpets. Because the stitching is locked, it prevents the rest of the stitching to come apart when one stitch is broken, unlike bobbinless/ chain stitch binders. The work is accomplished more rapidly and satisfactorily on this machine than is possible by any other sewing machine or method.

SPEED

The maximum speed recommended for the HDPB model is 25 feet per minute, while for the TMB model, its 30 feet per minute. For best results, both models should be operated at a moderate speed. Speed for the model HDPB is controlled by a speed control switch, while the TMB model is controlled by the amount of pressure exerted to the foot treadle. The machines should be run slower than the maximum speed at first until the parts which are in movable contact have become glazed by their action upon each other. When the machines are in operation, the balance wheel should always turn over toward the operator.

NEEDLES

Use only needles obtained through your authorized distributor as these were specifically selected for this application. Accept no substitutes.

No smaller than the recommended size 23 diamond point should be used, and straight sharp needles should be kept in the machine for best operation.

Stock# 21023: #23 Diamond Point Heavy Duty Needles

Stock# 21023WP: #23 Wedge Point Needles

For HDP binders – use needles:

Stock# 21023L: #23 Long Shank Diamond Point Needles

Stock# 21024: #24 Diamond Point Needles

For truly troublesome carpets, use sewing softener to soften the carpet backing.

THREAD & BOBBINS

Recommended thread is a high temperature, high tenacity Type C monofilament thread.

Stock# 08015 #52 Cleartone Canister,
approx. 1-1/2 lb spool

Stock# 08016 #63 Cleartone Canister,
approx. 1-1/2 lb spool

Use only style “F”, sizes 0, 23, 33 pre-wound nylon bobbins for these machines.

OIL

Use only clear stainless oil, #21020 for these machines. Other types might cause permanent staining on machine parts and carpets.

No Motor Oil!!

To ensure easy running and prevent unnecessary wear of the machine, the parts which are in movable contact require oiling, and when the machine is in continuous use, it should be oiled at least twice each day.

The large hole near the front on top of the arm is for screw driver use.

1. Oil the Needle Bar Frame Hinge Stud at the top of the arm head.
2. Oil the Take-up Lever Hinge Stud through the hole behind the screw driver hole.
3. Oil the Arm Shaft Bushing (front) and conduits through the oil packing (wick) thumb screw.
4. Oil the Arm Shaft Bushing (back) through the hole near the balance wheel.
5. Move the arm cap aside and oil the feed driving and lifting connections.
6. Oil the Needle Bar Frame Pitman Eccentric by passing the spout of the oil can down between the small gear (spiral) on the arm shaft and the arm.

7. Oil the front bearing of the Needle Vibrator Gear Shaft through the hole near the Needle Vibrator Regulating Spindle Head,

8. Oil the back bearing through the hole at the back of the arm.

9. Oil the Hook Driving Bevel Pinion Shaft Bearing (back) through the hole near the inside front corner at the base of the arm.

10. Oil the Needle Bar Frame Pitman Eccentric Stud connecting with the Needle bar Frame at the underside of the arm head.

11. Oil the Bobbin Case Bearing in the Hook Race each time a bobbin is replaced.

12. Remove the face plate and oil the Needle and Presser Bars, the Needle Bar Connecting Stud Swivel the lower and upper holes in the Needle Bar Connecting Link the groove that the link slides in and wherever there is friction.

13. Tip the machine back and oil the Feed Bar Slide Block and all of the oil holes (see Fig 3, Page 4).

14. Oil bearings at both ends of Treadle, Pitman, Shaft and all other movable parts of the transmitter, etc.

When a machine has been neglected or becomes gummed, it should be soaked well with benzine and run for a short time, keeping all parts flooded with oil until it runs freely, then wipe thoroughly to remove all old oil and dirt; oil as before instructed.

Never run the machine with the presser foot down except when sewing, as it will scratch the pressure foot and dull the feed dog.

CAUTION: Oil Hook Assembly every half hour of operation, other parts at least once daily.

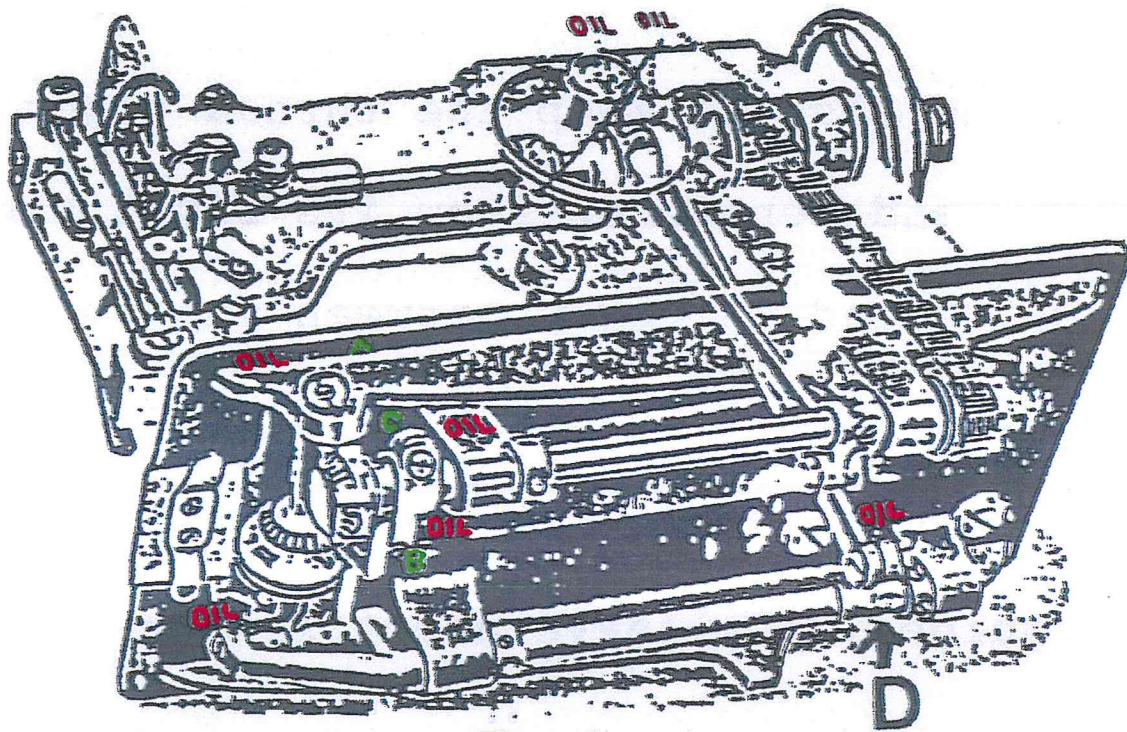


Figure 3

OIL CONDUITS

Fig. 4 shows that the shaft and studs are hollow and filled with oil wicking, as are also the conduits for conducting the oil from the shaft through the needle bar driving and the take-up driving studs.

Centrifugal force works the oil from the shaft to the bearing and through the conduits and studs.

There is a conduit from the top of the arm to the stationary take-up stud.

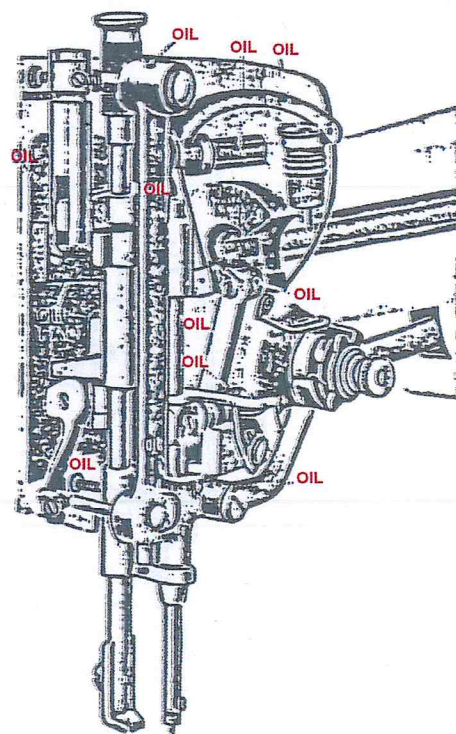


Figure 4

SET THE NEEDLE

Push the needle up in the needle bar as far as it will go, with the long groove to the front, and secure it firmly with the sew screw.

Note: Where the needle inserts into the needle bar, the back of the needle bar is flat. This is for the top roller feed clearance.

BE SURE THE FLAT SIDE IS FACING THE TOP ROLLER FEED.

If not, serious damage can result (see Fig. 5).

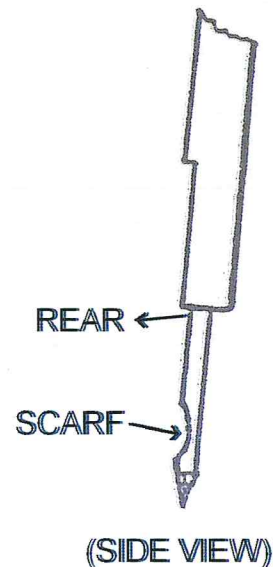
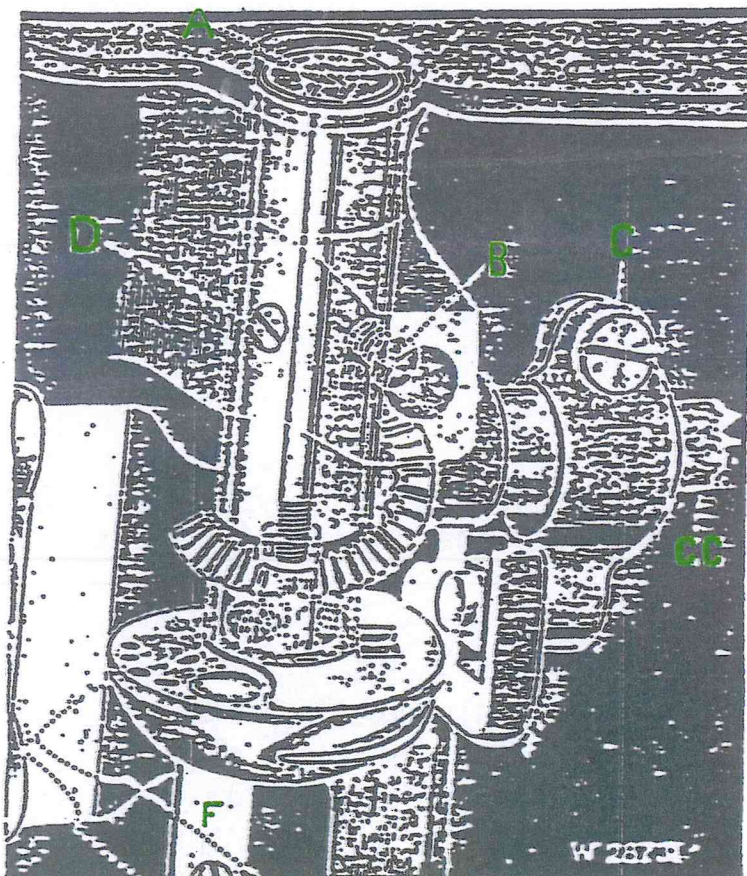


Figure 5



Transparent view showing how the Hook and its shaft (which runs in a bushing) are held together by screw (A); also showing the Feed Bar Slide Block and its crank with the Hook Driving Bevel Pinion Shaft extending out to the right at (CC).

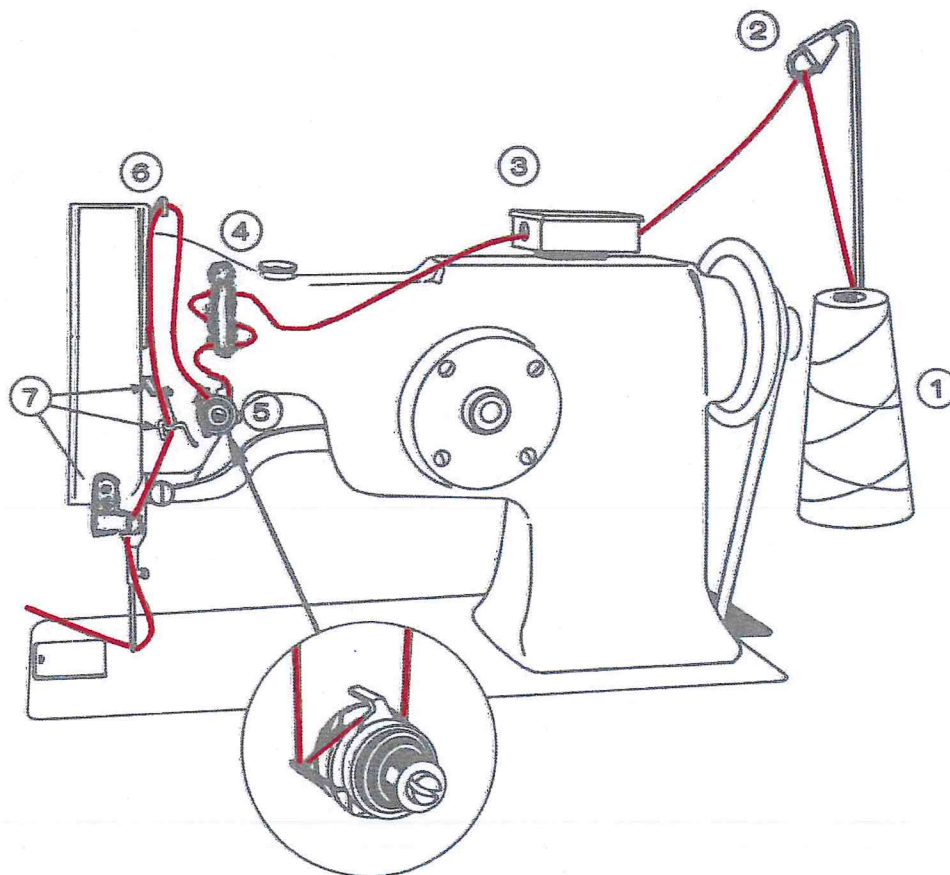
Figure 6

THREAD THE NEEDLE

Lead the thread from the spool through the various guides.

1. Follow steps #1 through #7 as shown below.
2. After going through step #4, pull back on the thread with your right hand while your left hand is pulling on the thread also to keep the thread tight while you are going around the thread tensioner from its right side, step #5.
3. Make sure that the thread is fully between the tension disc. Failure to do so will result in erratic stitching and will cause the thread to jam around the rotary hook, part #993.
4. After going through the last guides, #7, leave about six inches of thread for threading through the needle.

The thread must enter the needle eye from the front only!



THREADING DIAGRAM

THREAD THE BOBBIN CASE

Lift the bobbin case latch as shown on Fig. 11, and pull the case out from the rotary hook.

Insert a new spool of bobbin as follows.

1. Hold the bobbin spool (Fig. 8) so that it will go in to the case in a counter-clockwise position.
2. Pull off about five inches of thread from the spool.
3. Insert the spool into the case, press down on the spool with your left thumb to keep the spool from spinning while your right hand is holding the five inches of slack.
4. Continue the threading sequence by inserting the thread into the slit under the spring tensioner, Fig. 9 (see arrows). Follow steps 1, 2, & 3.
5. Prepare to attach the case back on the hook as shown on Fig. 10, with the thread slack out of the way of the bobbin case.

To remove the bobbin case, lift up on the case latch as shown in Fig. 10 & 11. When re-inserting the case, it is not necessary to lift the latch. Just push the case back on to the hook with the thread slack out of the way.

You should be able to hear a click indicating that the case is fully inserted. Failure to fully latch the case on to the hook will eject the case back out.

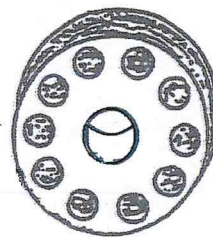


Figure 8

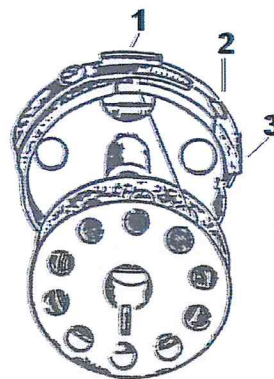


Figure 9

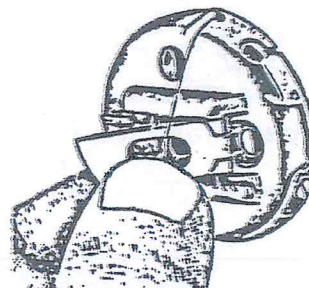


Figure 10

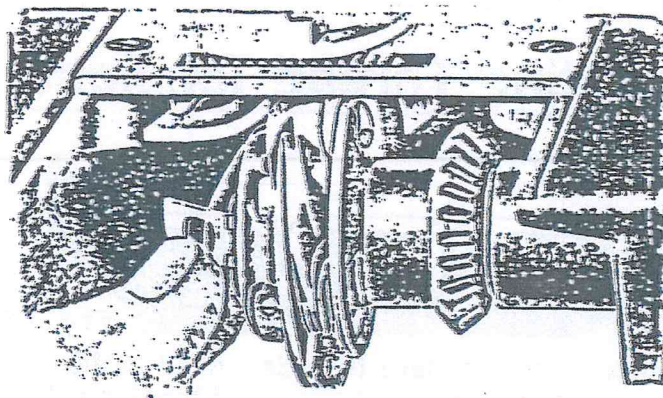


Figure 11

ADJUSTING BOBBIN CASE TENSION

A perfect stitch will have top and bottom threads locked in the carpet which is between the folds of the binding with no loops showing on top or bottom. Test for proper tensions by running the machine with the binding only. Run approximately ten inches and check the tension on the binding. A perfect stitch pattern should not show the top thread underneath the binding. Likewise, the bobbin thread should not show on the top of the binding. (see Fig. 12, 13 & 14)

To adjust the bobbin tension, use a very small screw driver, loosen or tighten the bobbin case tension spring screw, Fig. 15. The bobbin case should only have a slight tension. Test by pulling on the thread slack. Too much resistance will indicate tightness. Adjust by loosening the tension spring screw located on the outside wall of the bobbin case. A slight turn of the screw driver is usually all that is needed.

Too much tension on the bobbin case will require a tighter tension on the top thread, which could cause it to break often.

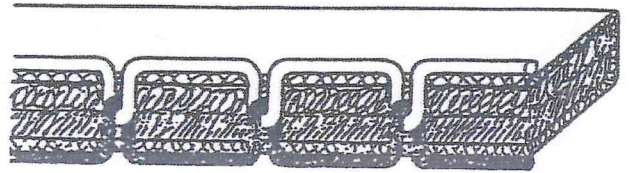


Figure 12

A perfect stitch will have threads locked in the carpet which is between the folds of binding with no loops on top or bottom

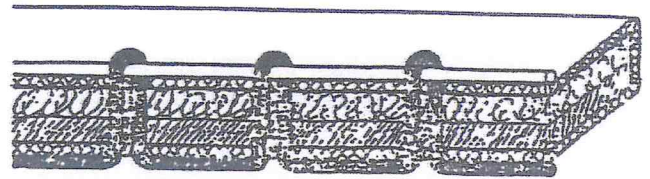


Figure 13

Upper thread too tight
(or bottom thread too loose)

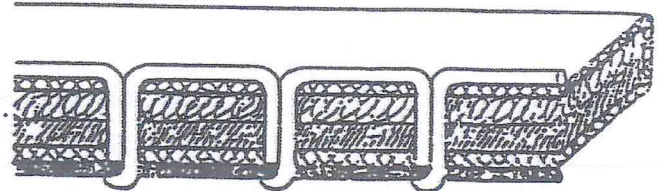


Figure 14

Upper thread too loose
(or bottom thread too tight)

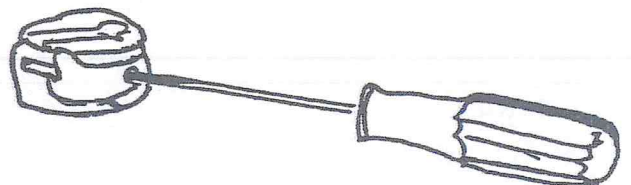


Figure 15

Adjusting Bobbin Case tension

FEED

To take up lost motion of the feed driving and lifting connections, adjust their hinge and pinch screws.

To prevent the feed dog from striking at either end of the slots in the throat plate,

Loosen screw (D, Fig. 3) and move the feed dog forward or backward until the longest stitch can be taken without the feed dog striking the throat plate and retighten the screw.

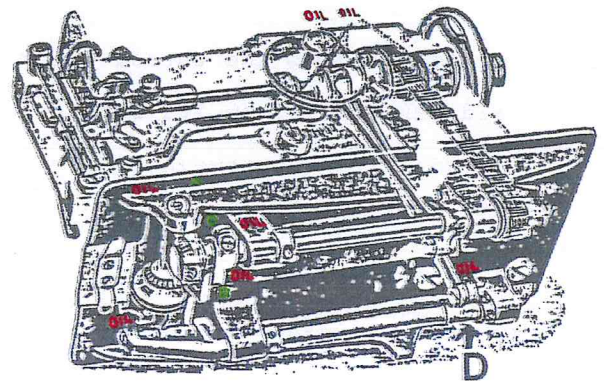
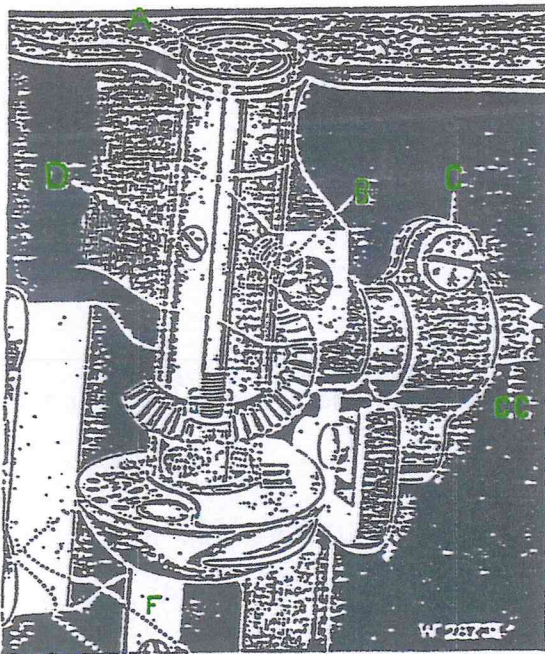


Figure 3

RAISE OR LOWER THE FEED DOG



Transparent view showing how the hook and its shaft (which runs in a bushing) are held together by screw (A); also showing the feed bar slide block and its crank with the hook driving bevel pinion shaft extending out to the right at (CC).

Figure 6

Usually when at its highest position, the feed dog should show a full tooth above the throat plate.

Remove the throat plate;
Clean the lint and dirt from between the feed points and replace the throat plate;

Tip the machine back and turn the balance wheel toward you until the feed dog is at its highest position;

Loosen screw (C, Fig. 6) and raise or lower the feed dog as desired and retighten the screw.

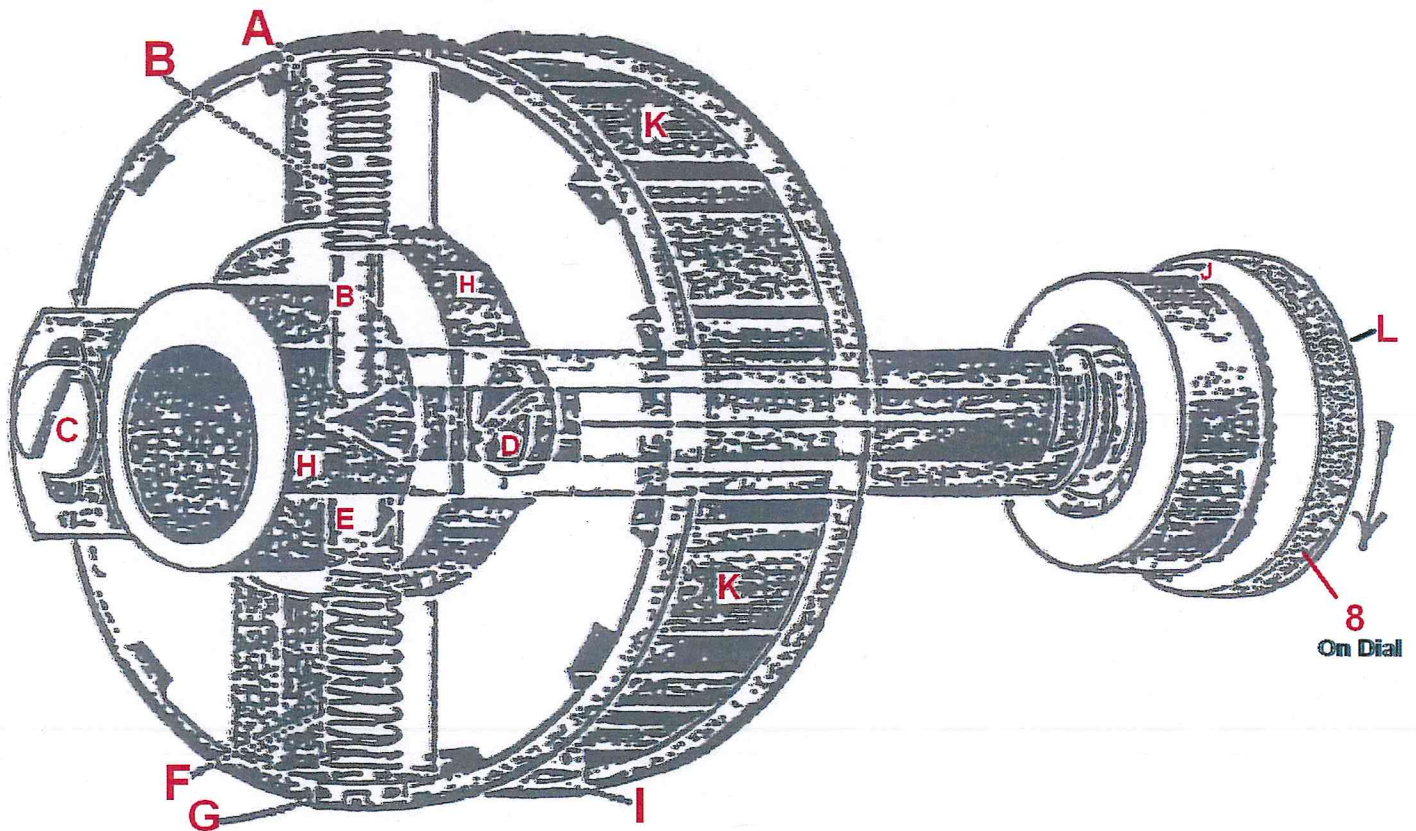
When raising or lowering the feed dog be careful that its underside does not drop low enough to strike the hook

NEEDLE AND NEEDLE BAR

Time adjustments can be tested or made only when the needle bar frame is held stationary for straightaway stitching.

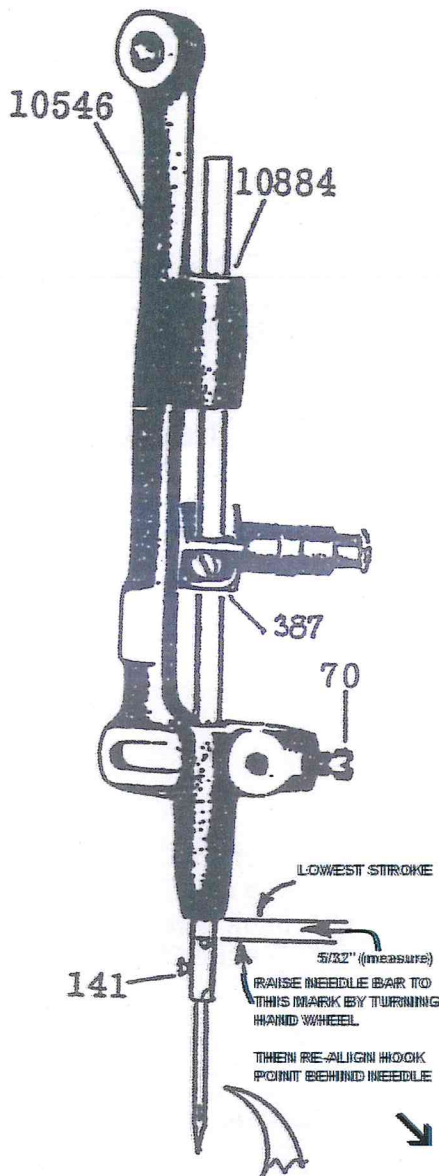
To set the needle bar (in correct time): Loosen the needle bar connecting stud pinch screw and place the needle bar in the proper position as directed above, then retighten the screw.

To set a needle bar (which has no mark): Set the needle bar so that when it rises $\frac{5}{32}$ " from its lowest position the point of the hook will be at the center of the needle and about $\frac{1}{16}$ " above the eye.



Transparent view through the arm shaft connection belt pulley and shaft showing the feed regulator spindle and feed driving eccentric regulating screw (B), which comes in contact with the cone of the spindle to gauge the length of the stitch.

Figure 16



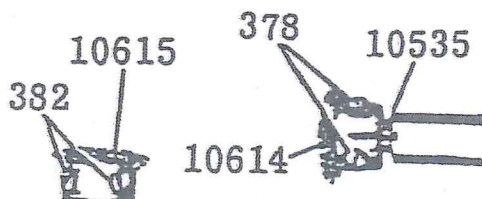
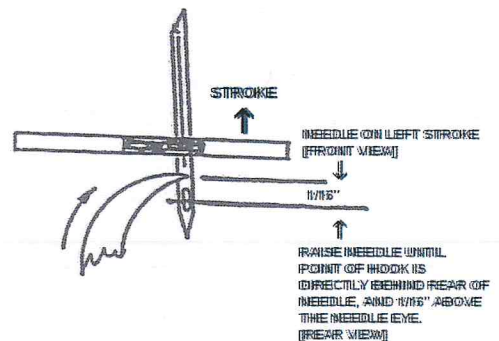
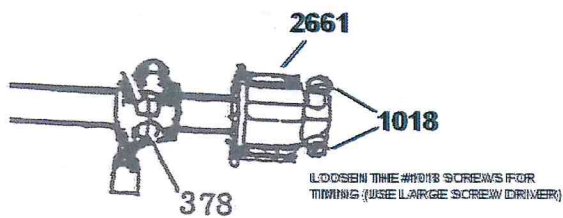
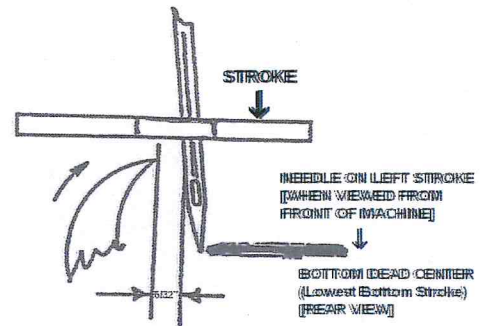
Time Hook First

Turn Hand Wheel toward you until Needle Bar goes down to lowest point on left side and comes up $5/32$ "; stop there.

Only After Timing Hook...

Adjust height of Needle Bar with screw #387 so eye (hole) of needle is $1/16$ " below point of Hook; retighten screw.

P.S. Don't move gears to time hook!



DO NOT USE THESE SCREWS FOR TIMING

HOOK REMOVAL, REPLACEMENT & ADJUSTMENT

To remove the hook, loosen long screw (Part #915, Fig. 6, A), while the feed dog is at its farthest stroke, pry off the hook by hand or with a screwdriver.

After removal, inspect for needle marks and nicks. Check point of hook for damage due to collision with the needle. If point is blunt or broken, replace hook and re-time.

The hook point should not hit the needle when they meet. To adjust, loosen screws "B & D", Fig. 6. Move hook bushing forward or backward until proper alignment is achieved.

When the needle is directly in front of the hook point, the hook point should not strike the needle. If it does, adjust the hook guard by prying it in or out from the needle. The guard should not rub against the needle except on the right stroke only.

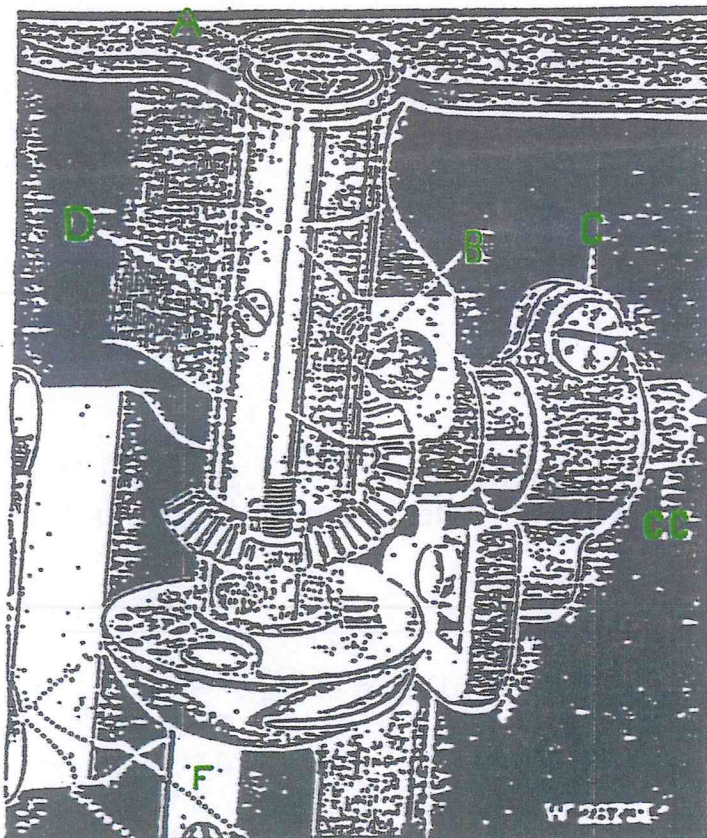


Figure 6

ZIGZAG WIDTH ADJUSTMENTS (STITCH WIDTH ADJUSTMENTS)

The width of bight or zigzag stitch is regulated by moving the upper end of the needle vibrating lever, indicated by the arrow in Fig. 17A (or 17B) to or from figure "0" on the graduated scale, each graduation representing a change of $\frac{1}{32}$ ". When the pointer is set at "0" the machine makes straightaway stitches only. The extreme width of zigzag stitch is $\frac{5}{16}$ ".

INSTRUCTIONS FOR MODEL TMB-1 WITH FRONT ZIGZAG WIDTH CONTROL KNOB

To increase zigzag width, turn knob counter clockwise (Fig 17).

To reduce zigzag width, turn knob clockwise.

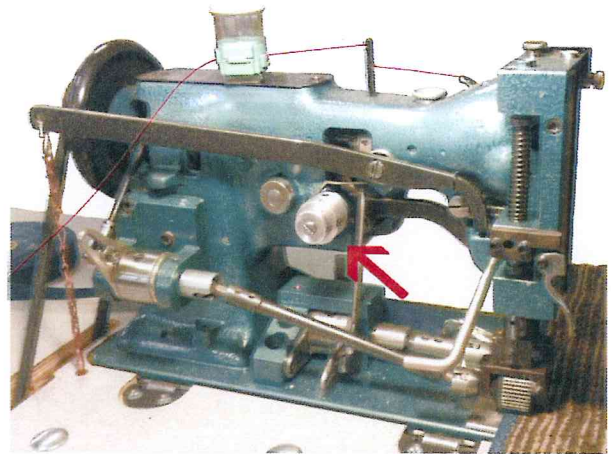
Important: When retiming hook and needle bar, always increase zigzag width to the maximum, then reduce to width you prefer.



Back view of Machine showing adjustment for
Changing width of Zigzag Stitches

Old Style

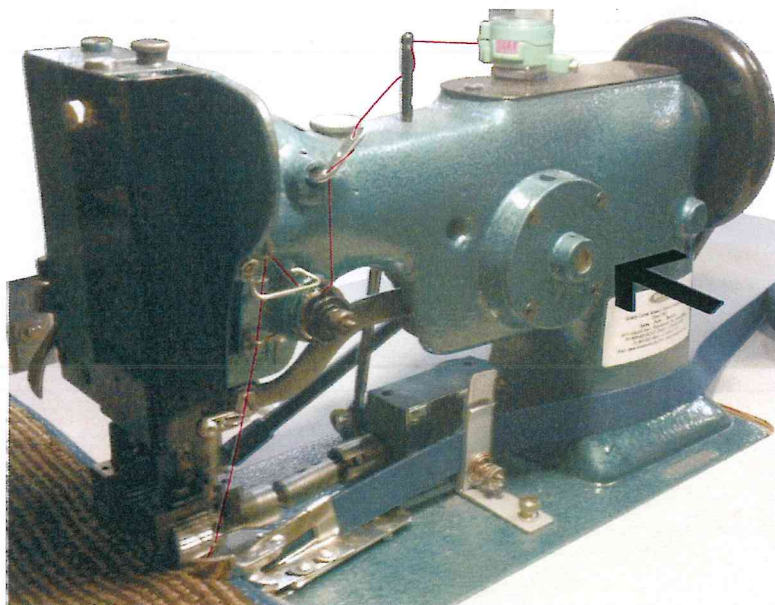
Figure 17A



Back view of Machine showing adjustment for
Changing width of Zigzag Stitches

New Style

Figure 17B



Front view of Machine showing adjustment
Changing width of Zigzag Stitches

Figure 17

THREAD CONTROLLER

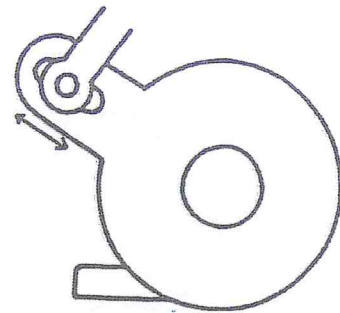
The function of the thread controller spring is to hold back the slack of the upper thread until the eye of the needle nearly reaches the carpet in its descent.

For more controller action on the thread, loosen the stop screw at the right of the tension and set the stop lower, and for less action set the stop higher.

To strengthen the action of the controller spring on the thread, loosen the tension stud screw at the right of the stop screw and turn the tension stud slightly to the left with a screw driver; or to lighten its action turn to the right and retighten the tension stud screw.

TOP ROLLER FEED ADJUSTMENT

When top roller feed rotates faster than the bottom dog feed- the binding may not catch or cover bottom side of the carpet. Loosen nut on clutch lever and move drive arm up (in the "less" direction). This will give less top roller feed. Moving the arm down will give the top roller more feed. Top roller and feed dog should move at the same time and speed.



ADJUSTING THREAD TENSIONS

A perfect stitch will have threads locked in the carpet which is between the folds of binding with no loops on top or bottom. (Illustration 1)

Lower thread tension requires adjustment less frequently than the upper thread tension. If a perfect stitch is not possible by readjusting the upper thread tension, then readjust the lower tension. Set the upper tension on #6 before attempting to adjust the lower tension.

When adjusting the tension on the bobbin case, make slight adjustments with a screwdriver- 1/8 turn in either direction is generally enough to correct adjustment (Fig. 10).

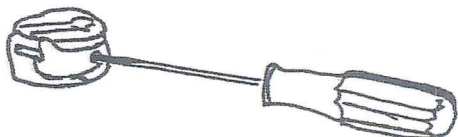


Figure 15

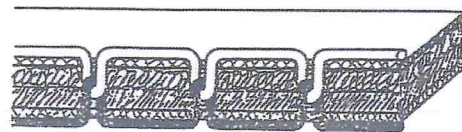


Illustration 1

A perfect stitch will have threads locked in the carpet which is between the folds of binding with no loops on top or bottom.

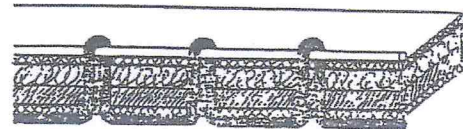


Illustration 2

Upper thread too tight.

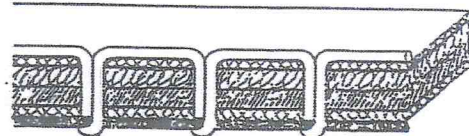


Illustration 3

Upper thread too loose.

COMMENCE BINDING OPERATION

With the left hand- take hold of the needle thread, leaving it slack between the hand and the needle, turn the balance wheel toward you until the needle moves down and the take-up lever rises to its highest point, thus catching the bobbin thread; draw up the needle thread and the bobbin thread will come up with it through the needle hole in the throat plate and lay both threads back across the feed dog.

Lift up the upper feed roller(s), guide the binding through all binding guides. Make a point on the binding end so it can go through the binding folder easily. After going through the folder, pull enough binding past the folder to go under the feed roller(s). While holding onto the binding and thread ends, slowly lower the feed roller(s). Turn the motor on and let the motor build up to normal speed. Do not step on the motor treadle until you're ready to start binding. Now slowly depress the treadle while still holding onto the thread and binding ends. As soon as the machine has stitched about two inches, let go of the thread and binding. Failure to follow this procedure will cause the machine to jam or go out of time.

Before binding a carpet, run some more of just the binding to test the thread tension balance. If not balanced, check manual for proper settings. Now test the machine on a small piece of carpet to be sure that the machine is ready to bind. Place the material beneath the needle, lower the presser foot, turn the balance wheel toward you and commence to sew.

Note: See that the presser foot and fabric hold the threads as shown in Fig. 18 before commencing to sew.

Do not pull or push the carpet. The machine moves it. If it does not, the stitch is too short, the feed is too low or too high, or the pressure on the presser foot is either too heavy or too light. The pressure on the presser foot is increased by turning down or decreased by turning up the presser bar thumb screw, which is above the presser bar.

Your machine is equipped with an upper roll feed to aid in pulling the carpet easily through.

Do not force the carpet to speed up while it is being fed through the machine. Let the machine bind the carpet at its own speed. Forcing the carpet to speed up binding will cause the machine to break a needle.

Large and or heavy carpets need an air table or conveyor system to support the weight of the carpet while it is being bound.

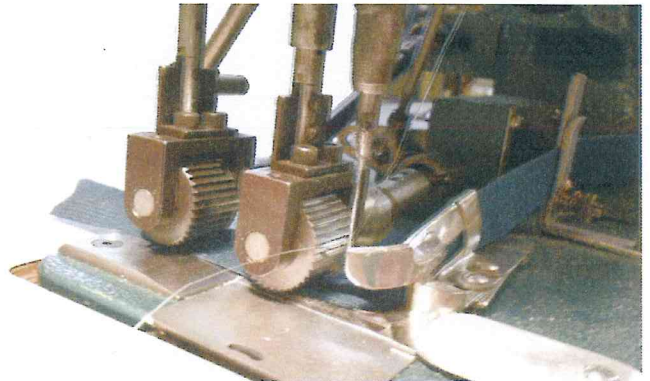


Figure 18

TO TURN A CORNER (FOR SMALL CARPETS ONLY)

Stop the machine while the needle is rising, but before it is out of the material, raise the presser foot and turn the work using the needle as a pivot.

BINDING CORNERS

Corners may be handled in one of two basic ways:

1. Two piece corner-

When approaching the corner, allow the carpet to run through the machine. Trim the binding tape $\frac{1}{4}$ " past the corner. Turn the carpet (or machine) and restart the same corner into the machine and allow that $\frac{1}{4}$ " tail to be covered with the new binding tape. You will notice that a tail of binding about 1- $\frac{1}{4}$ " long will appear at the corner. If longer, trim to 1".

Two methods are generally used to fasten the "tail" to the back of the carpet.

A. Place a bead of hot glue on the back side of the binding tape and then fold the tape back and press into the backing of the carpet, spreading out the hot glue.

B. Using a hand binding stapler with the depth-stop removed, staple the tail back. (When binding cut-pile carpets, pluck up any nap drawn down by the staple.)

2. One piece corner-

The machine should be stopped at the end of the carpet with the needle on the left side and down in the binding. Lift the top roller feed with lifting lever and either swing machine around or turn carpet. Before starting to sew, pull some binding tape through the binding tape tension. This will relieve the tension and help prevent the carpet corner from curling. Lower the lifting lever. Now you're ready to sew.

Note: Failure to put slack into the binding tape can curl the edge of soft-back carpets.

TO REMOVE THE WORK

Raise the presser lifter, turn the balance wheel until the take-up lever is at its highest point and draw the work from you. If the threads do not draw out easily, the take-up lever is not in the right position as directed. If the machine is stopped as directed, the needle will not be unthreaded in starting to sew, even if only a short end is left through the needle.

For convenience in taking out the work, the tension of the upper thread is released by raising the presser foot with the lifter; but is not released by thick goods or seams passing under the presser foot. Do not try to adjust the upper tension when the presser lifter is up as the tension is then loose.

Causes of the machine not working properly will usually be found in the tension not being correctly adjusted, or its discs may be clogged with lint or knots of thread. The thread may be too coarse or too fine for the needle, or the needle and thread too coarse or too fine for the throat plate.

Also the needle may be bent or blunt. See that a straight needle is pushed up in the needle bar as far as it should go; any particle of lint or dirt which prevents it from going up can be removed through the cross hole in the needle bar.

HOW TO FRINGE

For best results, **bind the carpet first**. Then remove the binding from the folder.

With the fringe end, rest the fringe over the folder top and under the front feed roller only. Make sure that the needle is up before inserting the fringe under the roller.

Lower the feed roller(s), and while holding the thread end to keep it from jamming the hook, slowly start sewing the fringe only.

After sewing about three inches of the fringe alone, insert the carpet corner into the folder mouth as if you are going to do binding. Slowly begin the fringing operation, sew only a small length of fringe at a time so you can control it before getting ready for the next pass.

When you get to the other end of the carpet, keep sewing fringe about three inches past the carpet end. These ends are for gluing under the carpet.



REMOVAL, REPLACEMENT AND ADJUSTMENT OF BINDING TAPE FOLDERS

The binding folder is held in place by two (2) screws (Fig. 19).

To adjust the binding folder, loosen screws, slide folder all the way to the left with the binding tape through and under the top roller feed. Tighten the folder screws and run about one (1) foot of tape through the machine. The stitch that goes into the binding should be approximately in the center of the binding. If not, move folder right or left to correct.

Note: Some cut pile, long pile shag and very thick carpets require special trimming before binding. Cut pile and long pile shags have to be beveled. Dense pile or thick backed carpets cannot feed into the standard folder.

Use Bond's Edge Beveler EW610 before binding dense, high pile carpets.

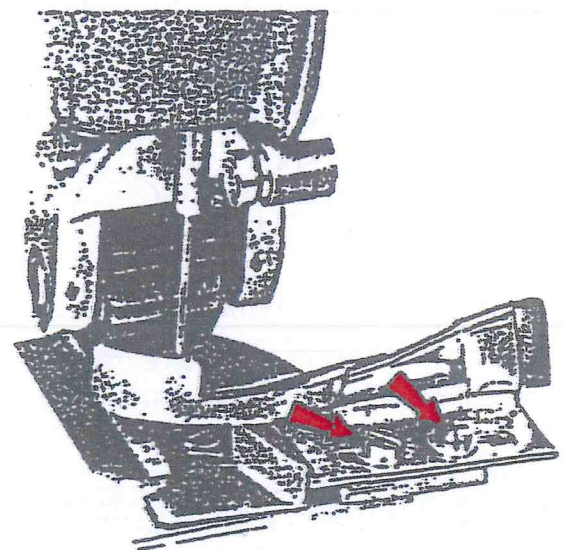
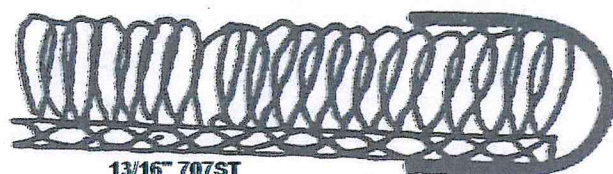
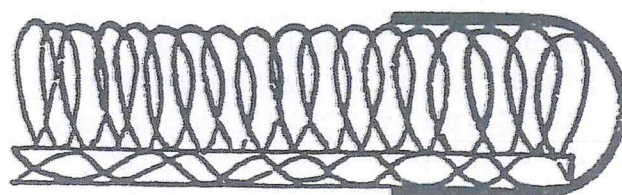


Figure 19

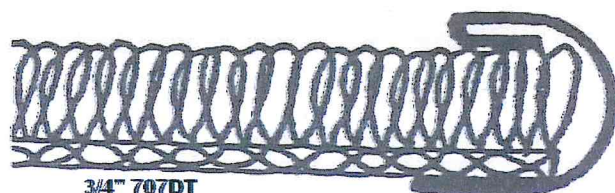
The following folders are available from Bond Products, Inc:



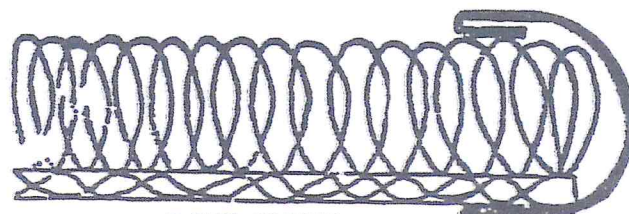
**13/16" 707ST
Single Turn Folder**



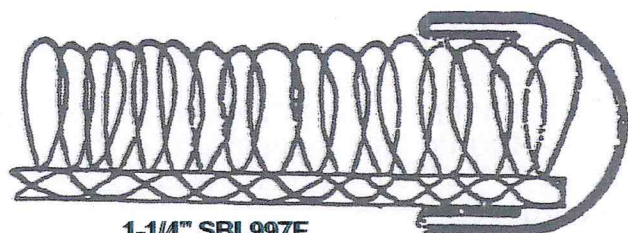
**1-1/4" ST SBL997G
Single Turn Folder**



**3/4" 707DT
Double Turn Folder**



**1-1/4" 777CT
Clean Top Folder**



**1-1/4" SBL997F
Double Turn Folder**

TROUBLESHOOTING

PROBLEM	PROBABLE CAUSE	CORRECTION
Irregular Stitching	Improper threading Loose thread tensions Timing is off Feed dog, clutch slips Holding back on carpet	Re-thread machine.....Page 6 - 7 Adjust upper & lower tensionsPage 14 Re-time.....Pages 11 Replace feed dog, rebuild or replace clutches Re-adjust conveyor system so that the rear is higher than the front.
Breaking Needles	Operator pulling or pushing carpet Incorrect size needle Hook/ Needle timing off Defective/ worn Hook	Do not push or pull carpet; let carpet feed naturally Use only recommended needles Re-time.....Pages 11 Replace Hook.....Page 12

PROBLEM	PROBABLE CAUSE	CORRECTION
Puckering	Incorrect thread, binding tensions Incorrect feeder adjustments Clutch(es) slipping Bent or blunt needle	Re-adjust tensions Re-adjust feeders.....Page 9 Clean, rebuild or replace Insert new needle.....Page 5
Skipping stitches	Bent or blunt needle Hook timing off Needle inserted cock-eyed Hook worn	Insert new needle.....Page 5 Re-time Hook/ Needle Adjust Needle Replace Hook
Upper thread breaking	Worn Needle Hook has nicks and burrs Tension too tight Thread old	Change needle Polish or replace Hook Adjust/ balance tensions Replace with new spool
Breaking bobbin thread	Defective lot Bobbin case worn Feed dog sharp Throat plate sharp or plate screw sharp	Test the rest of lot. Replace Replace bobbin case Buff with stone or emery cloth Buff with stone or emery cloth
Machine not feeding carpet	Feed dog worn or low Clutch(es) slipping Stitch length spindle slipped out Thread wrapped around Hook area	Raise or replace Clean, rebuild or replace Screw it back in the shaft Remove and clean Hook
Machine jamming, (Knocking Noise)	Thread caught in Shuttle/ Hook Incorrect timing Operator pulling carpet Oil parts if needed	Disassemble and clean Shuttle/ Hook. DO NOT RUN MACHINE WITHOUT BINDING See Page 11 to test and adjust. If the machine is being used on a table, the operator is pulling the carpet too fast. If the machine is being used on the floor, the operator is pulling the machine too fast. Let the carpet feed naturally.
Upper Thread Stitching but Breaking Under Carpet, Leaving A Rats Nest	Tension dial too loose Thread not in Tension Dial Look for burrs on Hook Assembly.	Adjust and balance Rethread machine Buff and oil Hook. Re-adjust Bobbincase Stop/Finger away from Hook

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1000-3	Idler Roller Ass'y Complete	36	10681	Face Plate Cover	34
1001	Blank Plate	36	10683	Thread Nipper Body	35
1002	Idler Shaft	36	10684	Thread Nipper Complete	35
1003	Idler Roller Only	36	10699	Needle Vibrator Gear	32
1004	Screw	36	10700	Vibrator Pinion Gear	25
1005	Short Rear Bolt (991)	36	10711	Vibrator Crank Shaft	32
1005L	Long Rear Bolt (991)	36	10712	Vibrator Cork with Screws (378, 917)	32
1005W	Spacer/ Washer	36	10718	Vibrator Cam Shaft	32
1006	Front Bolt (991)	36	10725	Needle Bar Crank	29
1007	Position Stud Screw	37	10735	Bobbin Case Latch	
1008	Screw (991)	37	10736	Bobbin Case Latch Spring	
1009	Set Screw	37	10754	Lift Bracket	
1010	Set Screw	37	10764	Bobbin Case Stop	28
1014	Screw (2300, 2635)	26	10768	Needle Bar Frame Pitman	32
1016	Screw (994)	31	10769	Needle Bar Frame Pitman Complete	
1018	Timing Screw (2661)	28	10770	Vibrator Regulator Gear	32
10512	Feed Bar	28	10772	Vibrator Regulator Slide Screw	32
10514	Slide Block Crank	28	10779	Needle Bar Vibrating Cam	32
10531	Feed Lift Rock Shaft	28	10780	Needle Bar Vibrating Clamp Complete	32
10535	Pinion Shaft	28	10781	Needle Vibrating Bracket	32
10536	Hook Gib (993)	31	10789	Presser Bar Lift Level Bracket	33
10539	Hook Holder Bushing	28	10844	Bed hinge Connection	26
10541	Hook Guard (993)	31	10882	Needle Bar Stud Swivel	28
10542	Needle Bar Frame Complete		10883	Needle Bar Crank Complete	
10543	Needle Bar Cam Link	29	10884	Needle Bar with Screw (141)	29
10544	Needle Bar Clamp	29	10954	Thread Guide	35
10546	Needle Bar Frame Housing	29	10957	Retainer Stud	35
10548	Needle Bar Hinge Stud	29	10958	Retainer Stud Collar	35
10551	Front Cover Bushing	32	10992	Spring	35
10557	Eccentric Stud	32	10993	Retainer Sleeve	35
10559	Cam Shaft Collar	32	132	Screw (2401, 41443)	29,33, 34
10585	Connect Stud Complete	29	1346	Screw (44074)	25
10589	Connecting Crank	28	141	Screw (10683, 10884)	29, 35
10591	Take- Up Auxiliary	29	145	Screw (993)	31
10592	Upper Thread Guide		1458	Threaded Bushing (37021)	37
10593	Thread Guide	35	1497	Thumb Screw (24478)	
106	Screw (998)	31			
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10615	Hook Shaft Bevel Gear	28			

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1525	Nut (992A, 992S, 1007)	26, 31	24400	Timing Belt	26
		36,37	24478	Presser Bar Bushing	37
1531	Nut (253, 326)	28, 32	24484	Lift Bracket	37
1556	Thumb Nut (10772)	32			
1572H	Thumb Nut (710, 44062)	26, 34	253	Screw (2276, 10514)	28
172	Screw (24387)	29	2554	Presser Bar Lift Lever	33
200592	Screw (994)		256	Screw (37023)	37
20239	Take-up Drive Connection	29	2595	Spring, Plunger	26
202412	Thread Post Guide		259658	Thread Stand Base Only, OS	
2135	Position Pin	34	260	Screw (10789)	33
2244	Oil Wick (7080, 40802)	25	262	Screw (996)	31
2248	Washer (278, 995)	25	2623	Feed Drive Rock Shaft	28
2249	Arm Shaft	25	2624	Connecting Crank	28
2253	Belt Stop Ring (2635)	26	2625	Stop Collar	28
2254	Oil Wick (2333)	29	2635	Pulley, Belt (2249)	26
2276	Slide Block	28	2661	Pulley, Belt (10531)	28
2277	Oil Wick (10544, 10768)	29, 32	27561	Lift Lever Spring	35
2297	Feed Drive Connection	26	278	Screw (995)	25
2300	Feed Regulator Eccentric	26	2894	Screw (990)	31
2301	Feed Regulator Plunger	26	3098	Pulley, Belt Complete	
2306	Feed Lift Connection	26	3172	Friction Washer	29, 32
2307	Feed Lift Eccentric	25	325	Screw (10539)	28
2310	Stitch Regulator	25	326	Screw (10781)	32
2324	Belt Stop Ring (2661)	28	327	Screw (2635)	26
2333	Connecting Link Stud	29	334	Screw (10548, 41349)	29
2335	Presser Bar with (2) Screws (74)	33	335	Screw (10725)	29
			338	Screw (7080, 23607, 40802)	25
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			350107	Small Hand Wheel Screw	25
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37037	Lift Lever	37	602	Screw (2635)	26
374	Screw (2333, 10725)	29	607	Screw (2300)	26
378	Screw (10589, 10614, 10712)	28, 32	61	Screw (44062)	34
38	Screw (2624)	28	62035	Table, Motor, Light Assembly	
382	Screw (10615, 2307, 10700)	25, 28, 32	62036	Table Top 36" x 20"	
			62037	Table Legs	
383	Screw (2333, 2400, 2625)	28, 29, 32	62037L	Large Table Legs	
3836	Screw (2300)	26	62038NS	New Style Servo Clutch Motor, wired	
387	Screw (10882, 10884)	29	62038OS	Old Style Clutch Motor, wired with Switch	
397	Screw (10683, 10957)	35	62038S	Replacement Switch for Clutch Motor	
40034	Thread Guide	35	62038WS	Replacement Wiring & Switch for Clutch Motor	
40802	Arm Shaft Bushing	25			
41342	Shims (10543)	29	62039	Pulley: 2, 2-1/2, or 3	
41349	Needle Bar Frame Stud	29	62040	Thread Stand	
41443	Check Spring Collar	34			
428	Screw (10725)	29	62040B	Thread Stand, Base Only	
429	Screw (2635)	26	62040P	Spool Pins for Thread Stand	
437	Screw (2307)	25	62040PN	Thread Stand Pin/ Post	
44033	Presser Bar	33	62040S	V Belt, size 40	
44048	Rear Tension Disc	34	62040T	Thread Stand	
44049	Front Tension Disc	34			
44059	Take-Up Lever	29	62040U/N	Thread Stand (for Union Special Binders, Sergers)	
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50107	Screw (44074)		62046	Sealed Beam 6.8 Volts	
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581	Screw (41342)	29	62052	Oiler with Capped Spout	
582	Screw (10593)	35	62053	Bobbin Winder	
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596	Screw (10596)	31			

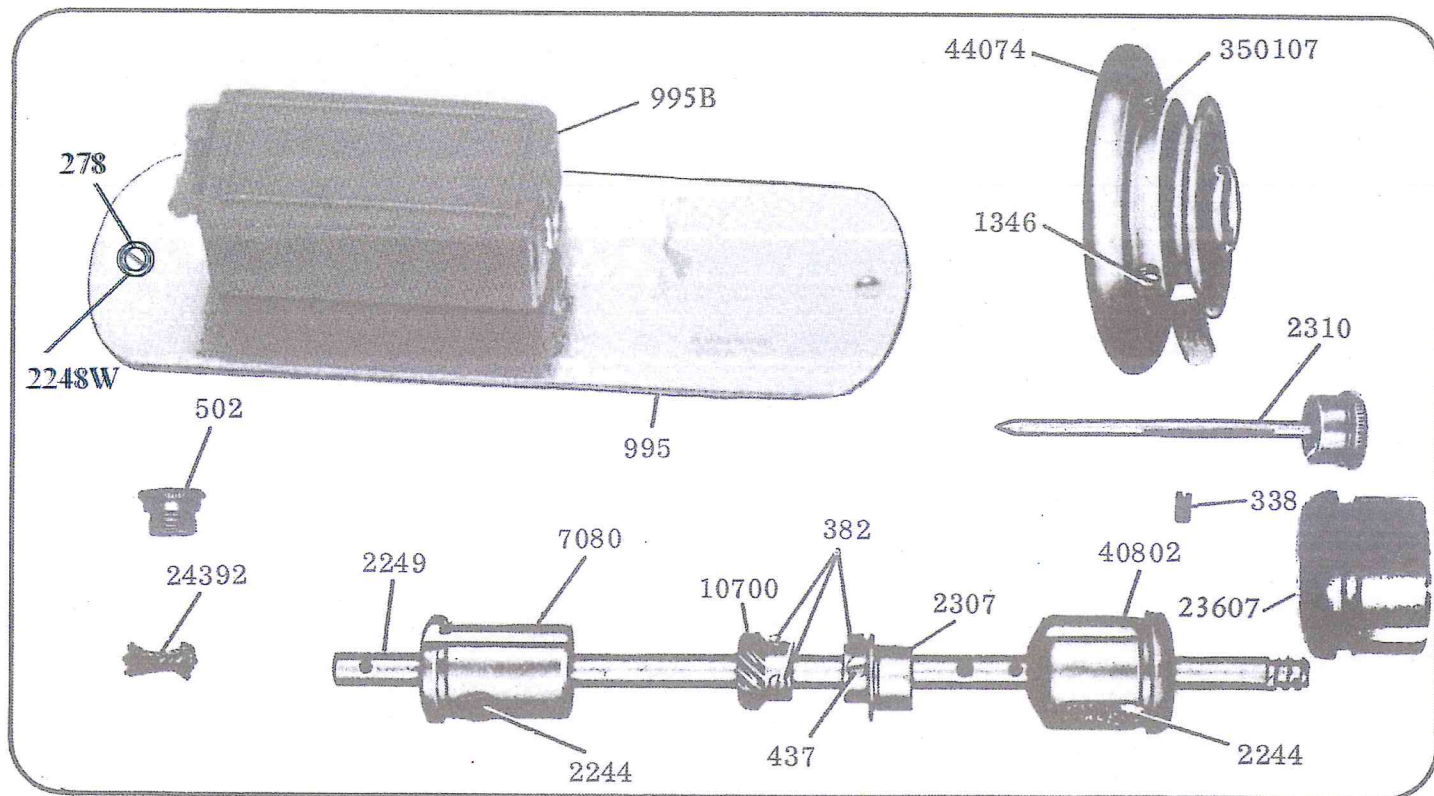
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62056	Bent Tweezers		991CP	Clutch Plates	
62057	Instruction/ Parts Manual		991CR	Clutch Rollers	
62058	Screw Driver Set		991CS	Clutch Springs	
625	Screw (44062)	34	991E	Clutch Plate/ Pad	
63106	Tension Spring Washer	34	991F/RCLB	Clutch Needle Bearings (NS Front/ Rear)	
63110	Bobbin Case Tension Spring	31	991FCNS	NS Front Main Clutch	36
641	Screw (2623, 37004)	28	991FR	OS Rebuild Clutch Front	
653	Screw (2554, 37004)	33	991FRNS	Replace Worn Front NS Clutch	
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7072	Presser Bar Bushing	33	991RCNS	NS Rear Main Clutch	36
708	Washer (997)		991RFNS	NS Front Clutch Replacement Only	
7080	Front Arm Shaft Bushing	25	991RR	OS Rear Clutch Rebuilt	
709	Screw (997)		991RRNS	NS Rear Clutch Replacement Only	
710	Binding Tension	26	991SC	Clutch Spring Caps	
711	Screw (710)	26	992	Complete Eccentric	31
74	Screw (44033)	33	992A	Front Eccentric Shaft	31
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778SF	3" Sisal Folder for TMB		992CW	Cut Washer	36
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989	Feed Roller Complete	31	993RB	Rebuild Customer Hook	
989B	Complete Bracket (989)	31	994	Bobbin Case	31
989BL	Bracket (989RL)	37	995	Top Cover	25
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989RL	Feed Roller Only	37	996	Lift Lever Bar	31
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989SL	Shaft (989RL)	37	997B	Folder Bracket Only	
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990PN	Pin (990)		997FG	Fringe Guide	
991	Front Clutch	31, 36	997G	1-1/4"ST Folder w Swing Arm	
991A	Clutch Crank Lever				

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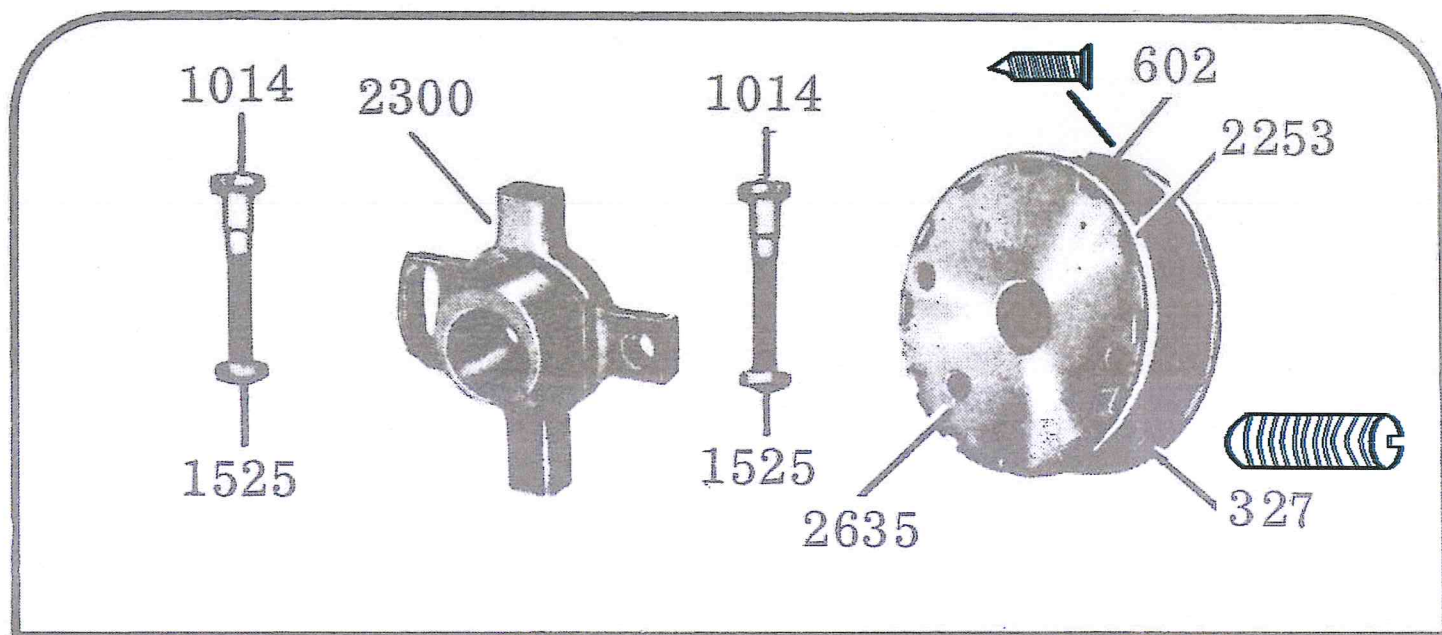
PART NO.	DESCRIPTION	PAGE	PART NO.	DESCRIPTION	PAGE
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997STS	1-1/4" Serging Tape Folder w Swing Arm		401	Electric Plug, Female	39
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314	Belt Guard				
315	Hand Wheel				

FRAME 1



SBL10700	Vibrator Pinion Gear
SBL1346	Screw for 44074
SBL2244	Oil Wick for 7080, 40802
SBL2248W	Washer for 278, 995
SBL2249	Arm Shaft
SBL2307	Feed Lift Eccentric
SBL2310	Stitch Regulator
SBL23607	Arm Shaft Short Bushing
SBL24392	Oil Wick
SBL278	Screw for 995
SBL338	Screw for 7080, 23607, 40802
SBL350107	Small Hand Wheel Screw
SBL382	Screw for 2307, 10700
SBL40802	Arm Shaft Bushing
SBL437	Screw for 2307
SBL44074	Hand Wheel
SBL502	Screw 7080
SBL7080	Front Bushing/ Arm Shaft
SBL995	Top Cover
SBL995B	Lube Box

FRAME 2



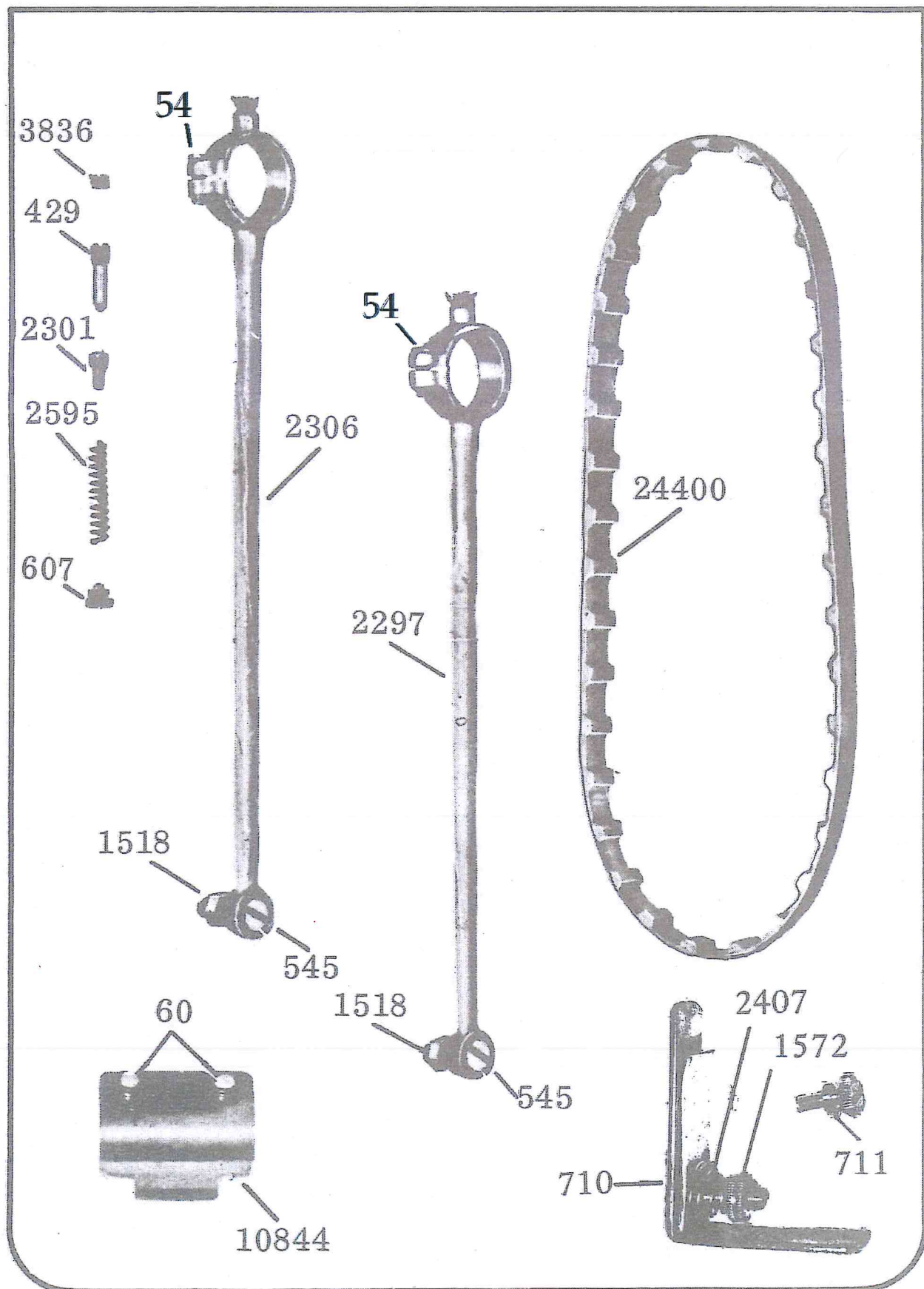
FRAME 2... parts list

SBL1014	Screw for 2300, 2635
SBL1525	Nut for 1014
SBL2253	Belt Stop Ring for 2635
SBL2300	Feed Regulator Eccentric
SBL2635	Pulley, Belt for 2249
SBL327	Screw for 2635
SBL602	Screw for 2635

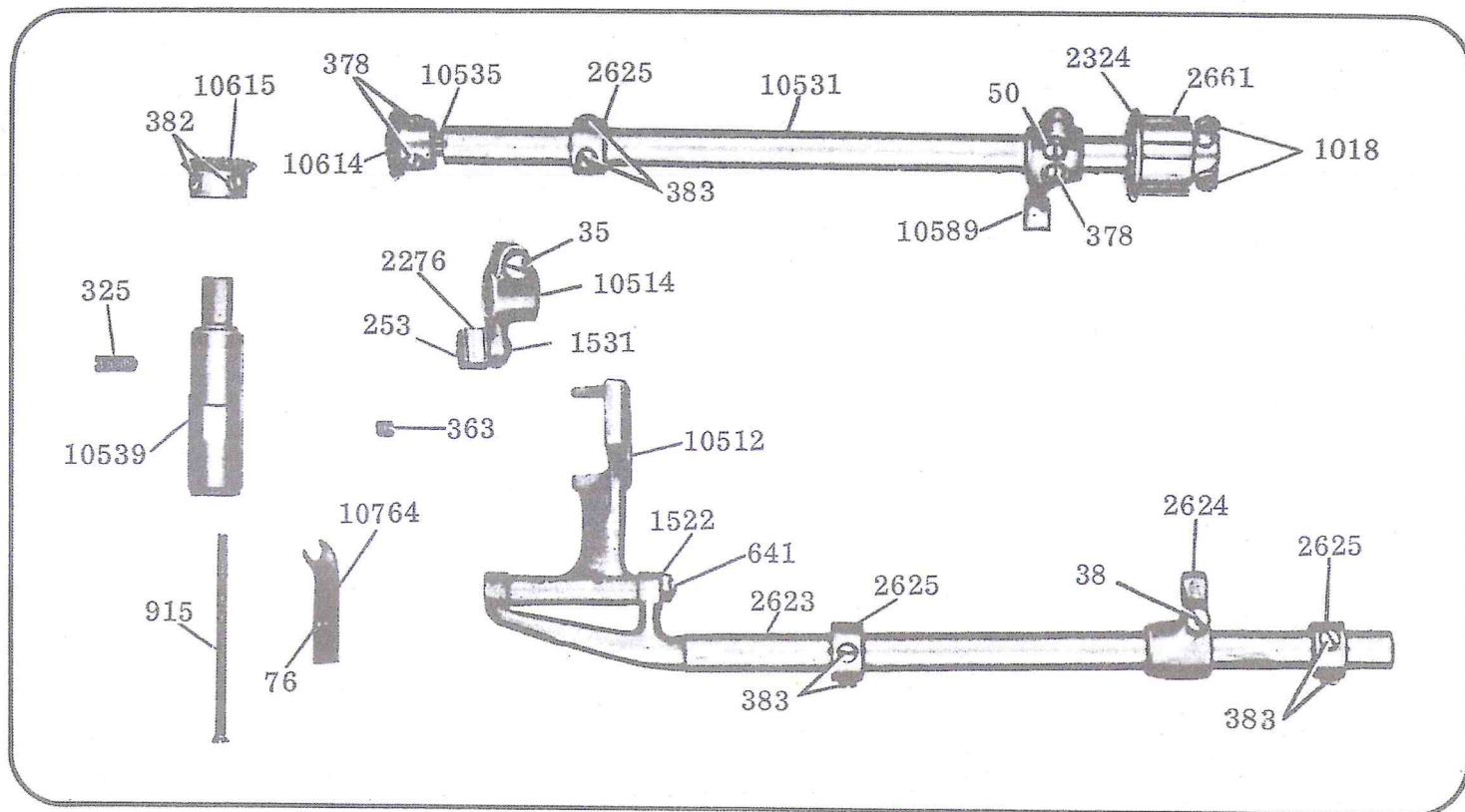
FRAME 3... parts list

SBL10844	Bed Hinge Connection
SBL1518	Nut for 545
SBL1572H	Thumb Nut for 710
SBL2297	Feed Drive Connection
SBL2301	Feed Regulator Plunger
SBL2306	Feed Lift Connection
SBL2407	Tension Spring
SBL24400	Timing Belt
SBL2595	Plunger Spring
SBL3836	Screw for 2300
SBL429	Screw for 2635
SBL54	Screw for 2297, 2306
SBL545	Screw for 2297, 2306
SBL60	Screw for 10844
SBL607	Screw for 2300
SBL710	Binding Tension
SBL711	Screw for 710

FRAME 3



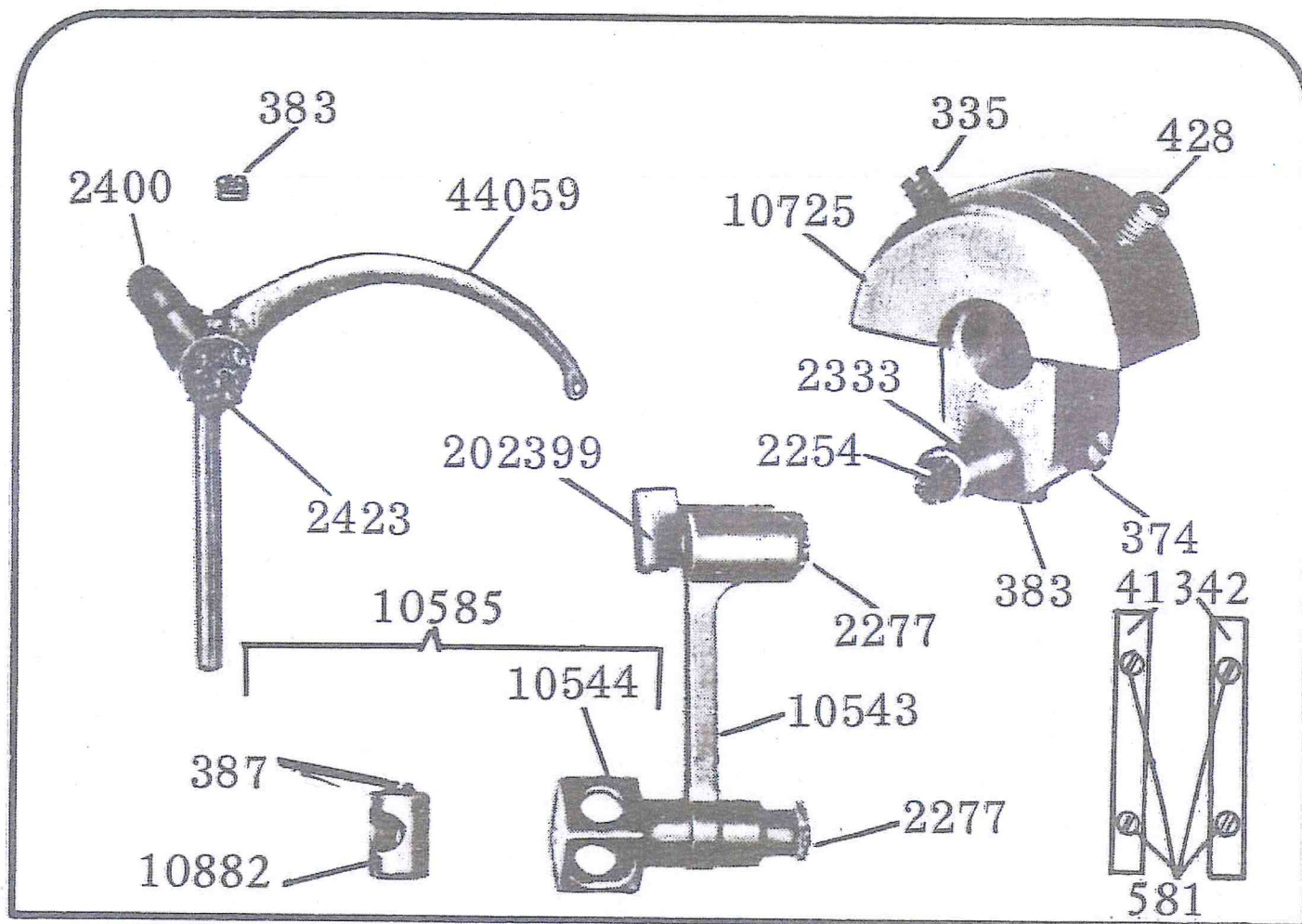
FRAME 4



SBL1018 Timing Screw for 2661
 SBL10512 Feed Bar
 SBL10514 Slide Block Crank
 SBL10531 Feed Lift Rock Shaft
 SBL10535 Pinion Shaft
 SBL10539 Hook Holder Bushing
 SBL10589 Connecting Crank
 SBL10614 Hook Pinion Gear
 SBL10615 Hook Shaft Bevel Gear
 SBL10764 Bobbin Case Stop
 SBL1522 Nut for 641
 SBL1531 Nut for 253
 SBL2276 Slide Block
 SBL2324 Belt Stop Ring for 2661
 SBL253 Screw for 2276, 10514

SBL2623 Feed Drive Rock Shaft
 SBL2624 Connecting Crank
 SBL2625 Stop Collar
 SBL2661 Pulley, Belt for 10531
 SBL325 Screw for 10539
 SBL35 Screw for 10514
 SBL363 Screw for 10539
 SBL378 Screw for 10589, 10614
 SBL38 Screw for 2624
 SBL382 Screw for 10615
 SBL383 Screw for 2625
 SBL50 Screw for 10589
 SBL641 Screw for 2623
 SBL76 Screw for 10764
 SBL915 Screw for 993

FRAME 5



FRAME 5... parts list

SBL10543	Needle Bar Cam Link
SBL10544	Needle Bar Clamp
SBL10585	Connection Stud Complete
SBL10725	Needle Bar Crank
SBL10882	Needle Bar Stud Swivel
SBL202399	Take Up Drive Connection
SBL2254	Oil Wick for 2333
SBL2277	Oil Wick for 10544
SBL2333	Connecting Link Stud
SBL2400	Take Up Lever Hinge Stud
SBL2423	Oil Wick for 2400
SBL335	Screw for 10725
SBL374	Screw for 2333, 10725
SBL383	Screw for 2333, 2400
SBL387	Screw for 10882, 10884
SBL41342	Shims for 10543
SBL428	Screw for 10725

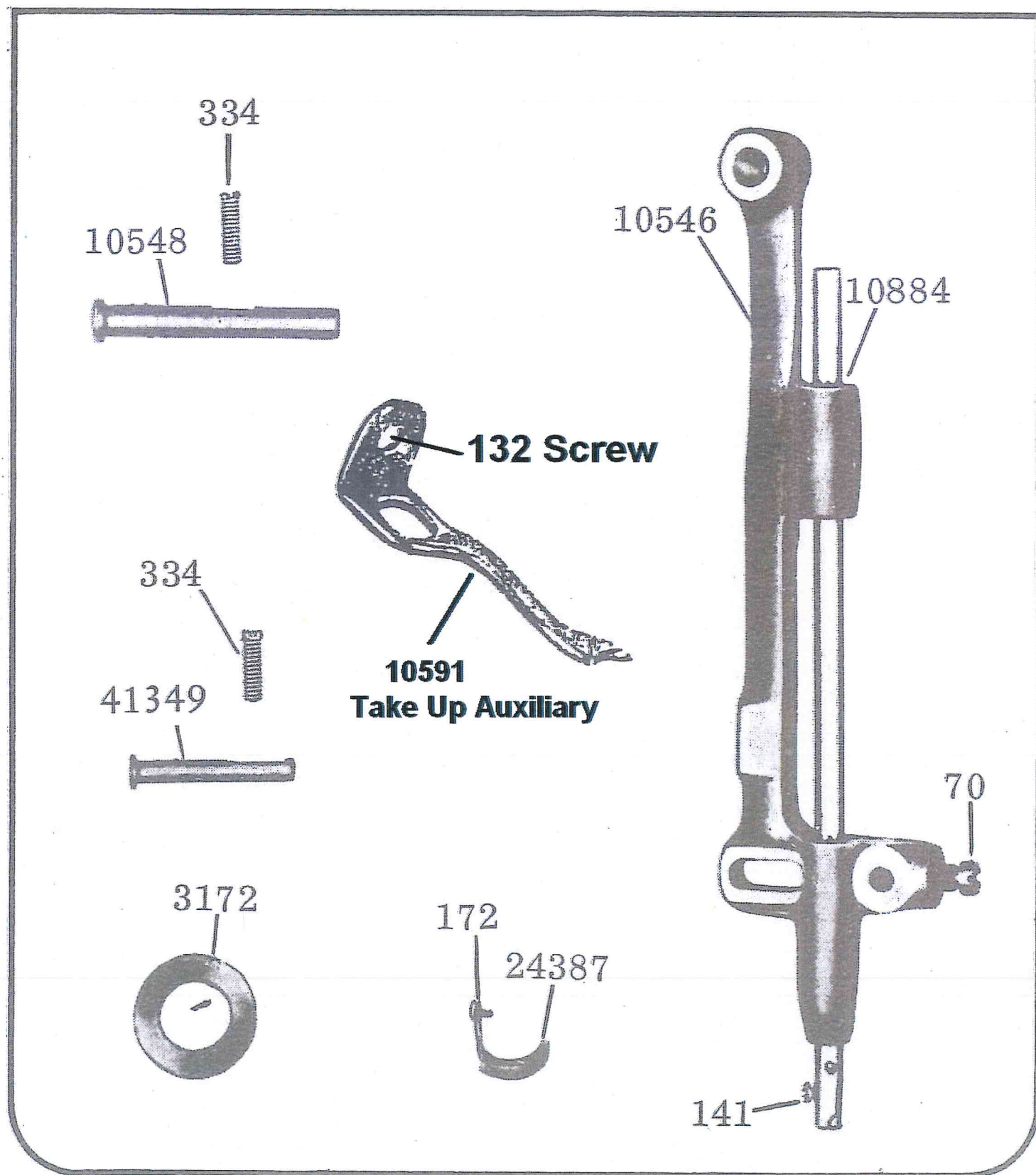
FRAME 5... parts list (continued)

SBL44059	Take Up Lever
SBL581	Screw for 41342

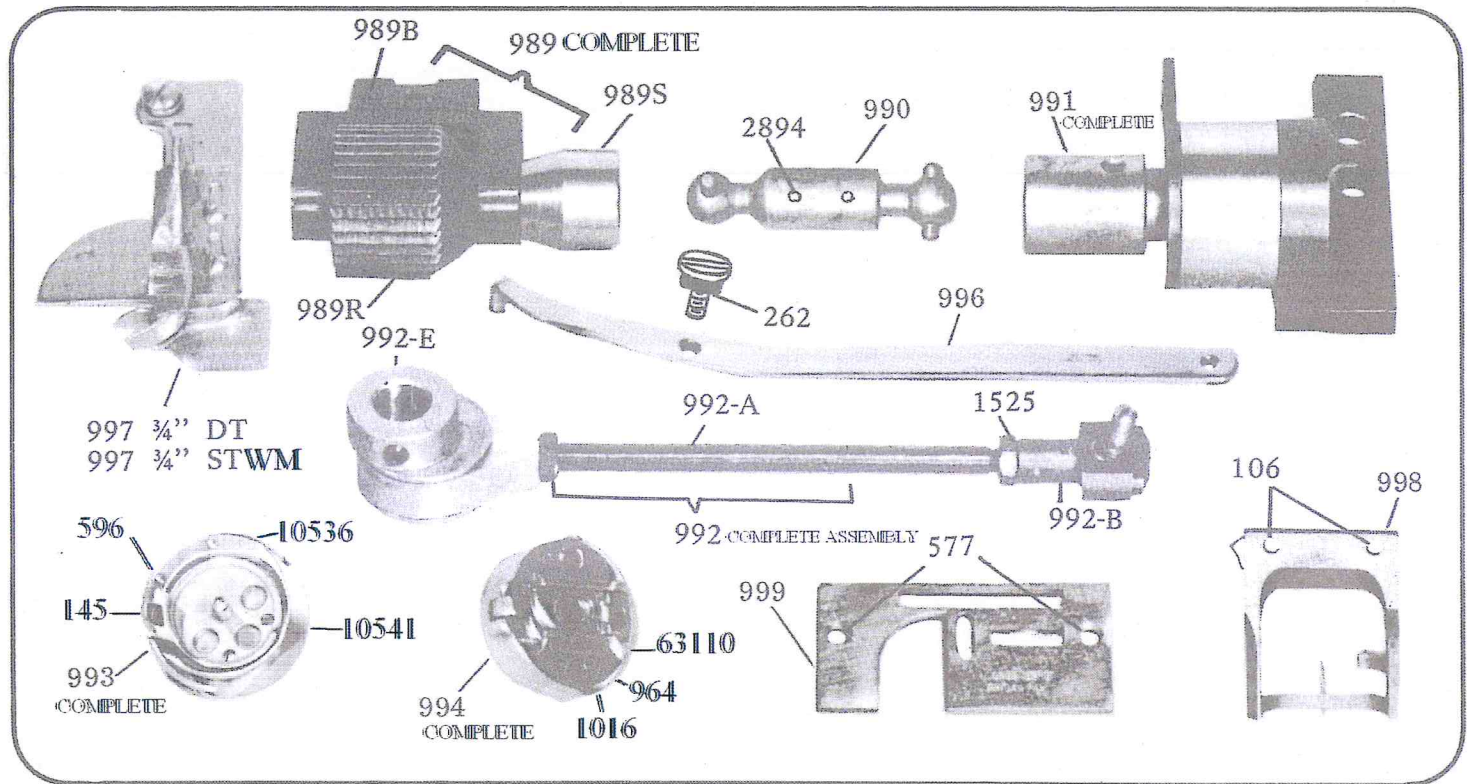
FRAME 6... parts list

SBL10546	Needle Bar Frame Housing
SBL10548	Needle Bar Hinge Stud
SBL10591	Take Up Auxiliary
SBL10884	Needle Bar with 141
SBL132	Screw for 41443
SBL141	Screw for 10884
SBL172	Screw for 24387
SBL24387	Thread Guide
SBL3172	Friction Washer
SBL334	Screw for 10548, 41349
SBL41349	Needle Bar Frame Stud
SBL70	Screw for 10546

FRAME 6



FRAME 7



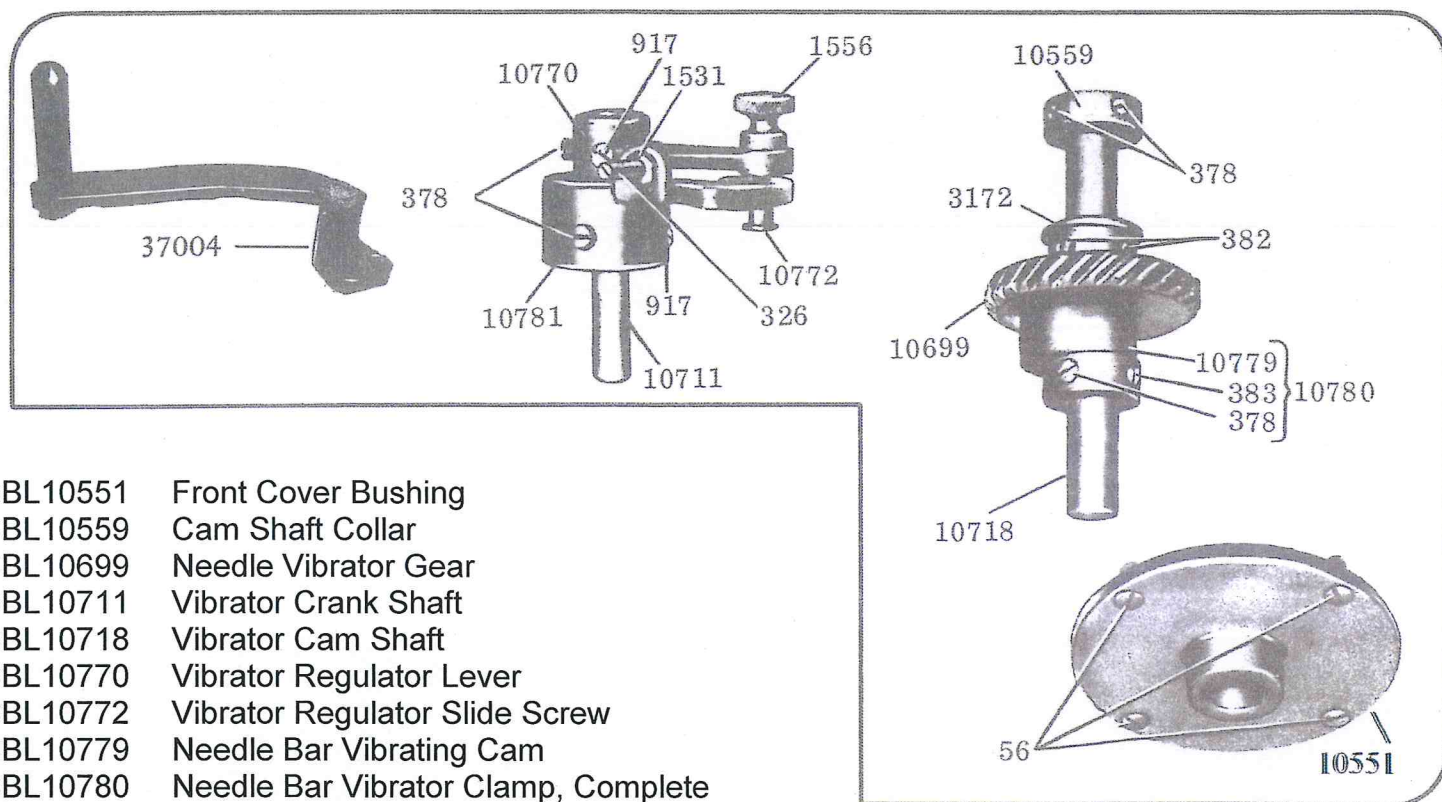
SBL1016	Screw for 994
SBL10536	Hook Gib for 993
SBL10541	Hook Guard for 993
SBL106	Screw for 998
SBL145	Screw for 993
SBL1525	Nut for 992A
SBL262	Screw for 996
SBL2894	Screw for 990
SBL577	Screw for 997, 999
SBL596	Screw for 10596
SBL63110	Bobbin Case Tension Spring
SBL964	Screw for 994
SBL989	Feed Roller Complete
SBL989B	Bracket Complete for 989
SBL989R	Feed Roller Only
SBL989S	Shaft for 989R

SBL990	Universal Ball Joint
SBL991	Front Clutch
SBL992	Complete Eccentric
SBL992A	Front Eccentric Shaft
SBL992B	Ball Joint
SBL992E	Front Eccentric
SBL993	Hook
SBL994	Bobbin Case
SBL996	Lift Lever Bar
SBL997DT	3/4" Double Turn Folder

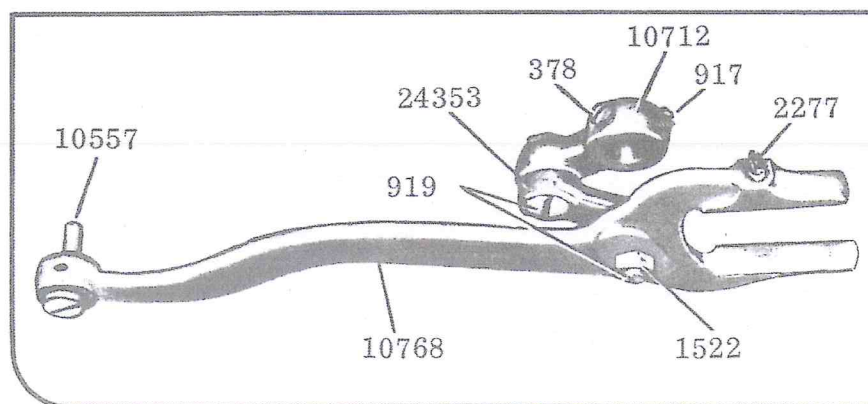
SBL997STWM
3/4" Single Turn Wide Mouth Folder

SBL998	Feed Dog
SBL999	Feed Throat Plate

FRAME 8

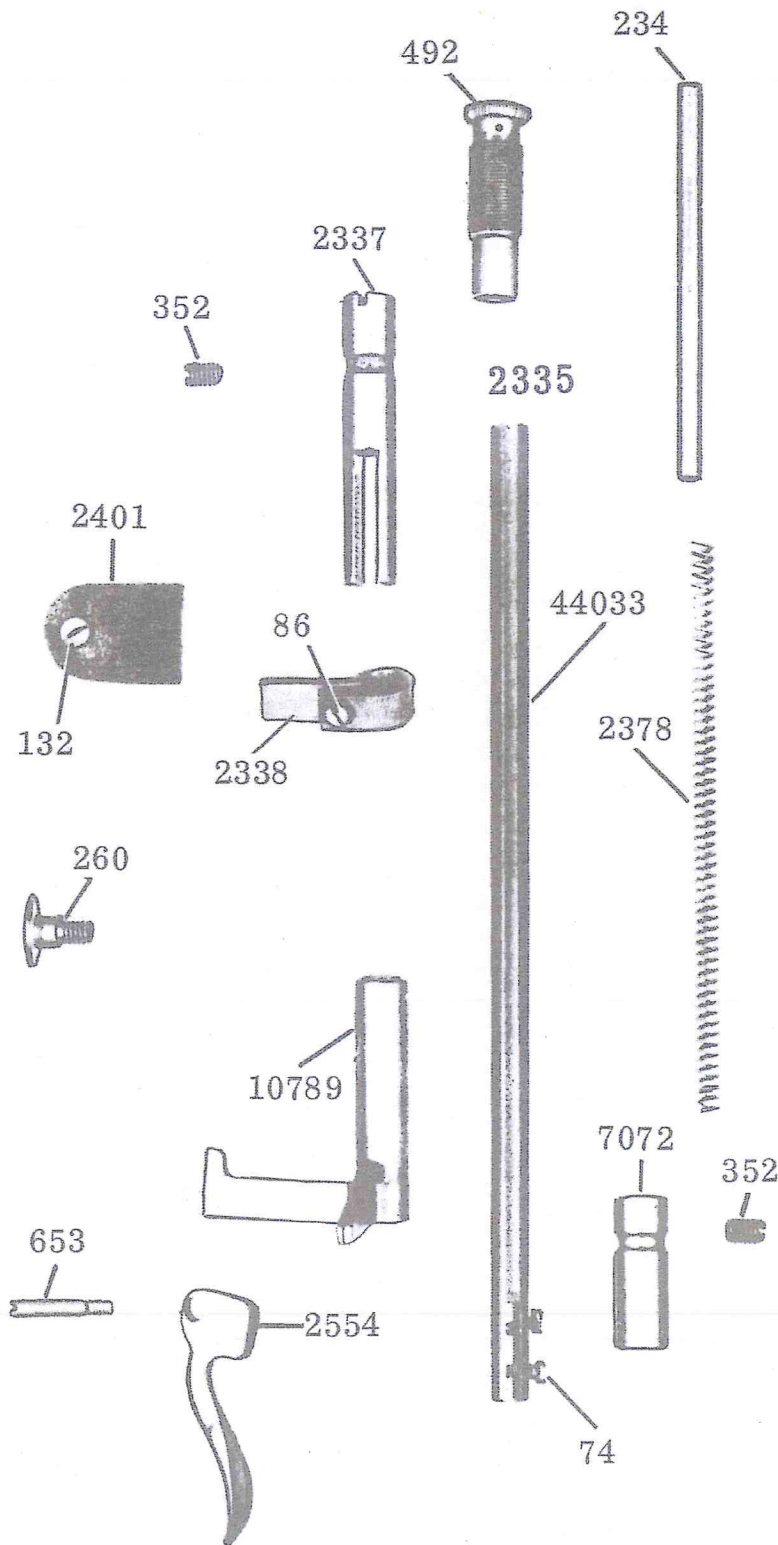


SBL10551	Front Cover Bushing
SBL10559	Cam Shaft Collar
SBL10699	Needle Vibrator Gear
SBL10711	Vibrator Crank Shaft
SBL10718	Vibrator Cam Shaft
SBL10770	Vibrator Regulator Lever
SBL10772	Vibrator Regulator Slide Screw
SBL10779	Needle Bar Vibrating Cam
SBL10780	Needle Bar Vibrator Clamp, Complete
SBL10781	Needle Vibrator Bracket
SBL1531	Nut for 326
SBL1556	Thumb Nut for 10772
SBL3172	Friction Washer
SBL326	Screw for 10781
SBL37004	Lift Lever
SBL378	Screw for 10712
SBL382	Screw for 10615, 2307, 10700
SBL383	Screw for 2625
SBL56	Screw for 10551, 200566
SBL917	Screw for 10712, 10770, 10781



SBL10557	Eccentric Stud
SBL10712	Vibrator Cork w 378, 917
SBL10768	Needle Bar Frame Pitman
SBL1522	Nut for 919
SBL2277	Oil Wick for 10768
SBL24353	Vibrator Crank Link
SBL378	Screw for 10712
SBL917	Screw for 10712, 10770, 10781
SBL919	Screw for 10712, 10768, 24353

FRAME 9



SBL10789
Presser Bar Lift Lever Bracket

SBL132 Screw for 2401

SBL2337
Presser Bar Positioning Guide

SBL2338
Presser Bar Positioning Lever

SBL234 Plunger for 44033
SBL2378 Presser Bar Spring
SBL2401 Felt Pad

SBL2554
Presser Bar Lift Lever

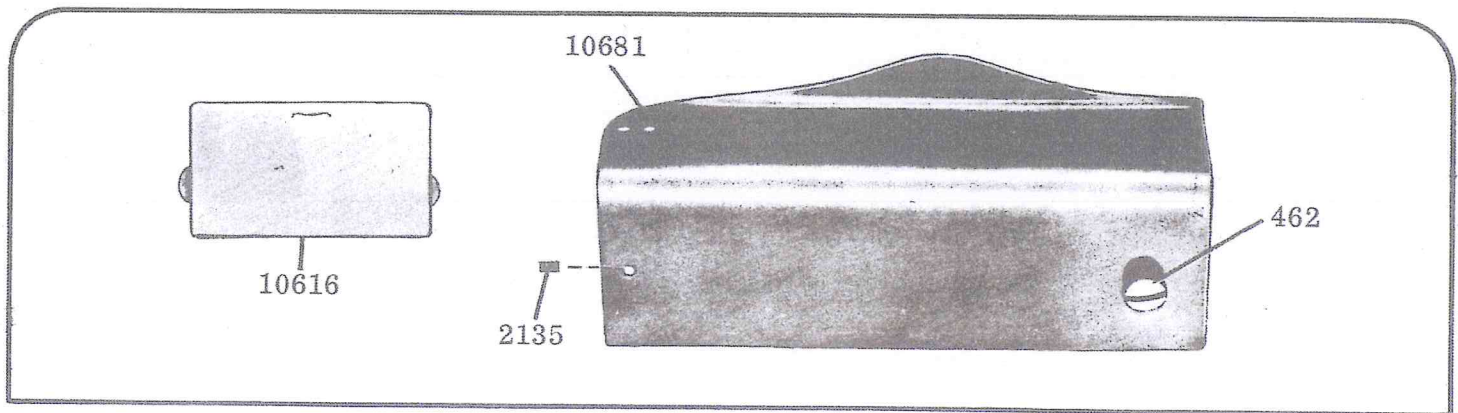
SBL260 Screw for 10789
SBL352 Screw for 2337
SBL492 Screw for 44033
SBL653 Screw for 2554
SBL7072
Presser Bar Bushing

SBL86 Screw for 2338

**SBL2335 – PRESSER BAR
w/ (2) 74sc**

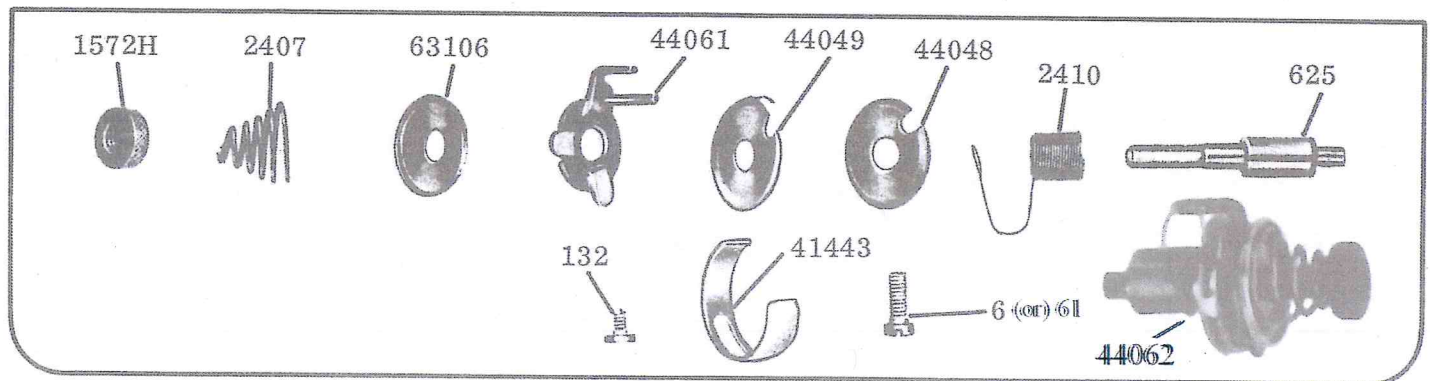
SBL44033 Presser Bar
SBL74 Screw for 44033

FRAME 10



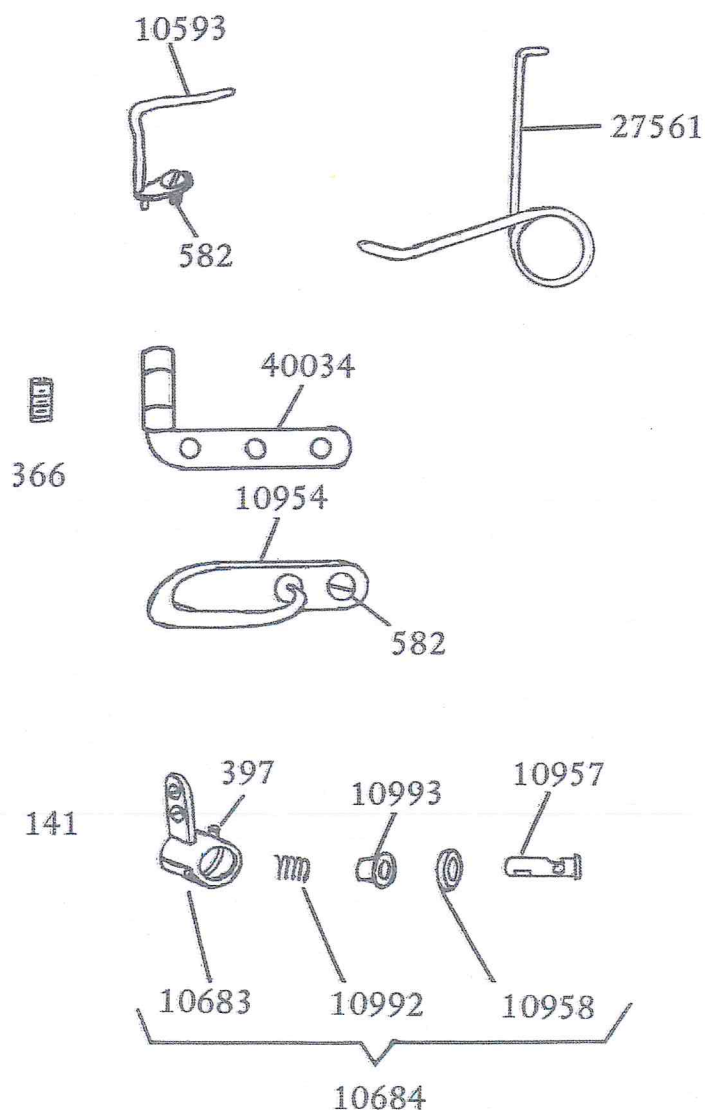
SBL10616	Bed Slide Plate
SBL10681	Face Plate Cover
SBL2135	Position Pin
SBL462	Screw for 10681

FRAME 11



SBL132	Screw for 41443
SBL1572H	Thumb Nut for 44062
SBL2407	Tension Spring
SBL2410	Check Spring for 44062
SBL41443	Check Spring Collar
SBL44048	Rear Tension Disc
SBL44049	Front Tension Disc
SBL44061	Tension Release Washer
SBL44062	Tension Complete
SBL6	Screw for 44062
SBL61	Screw for 44062
SBL625	Screw for 44062
SBL63106	Tension Spring Washer

FRAME 12



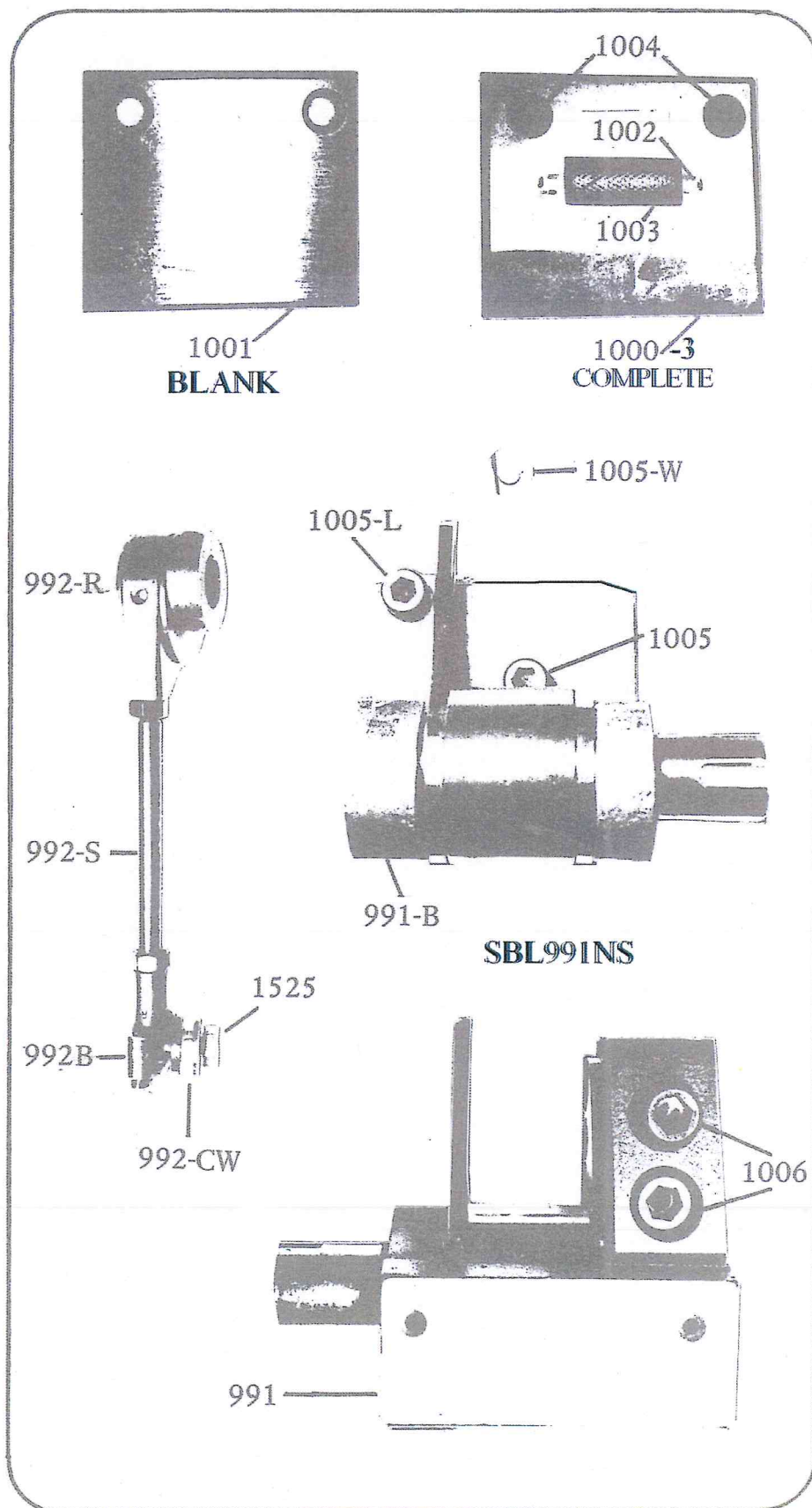
SBL10593 Thread Guide
 SBL10683 Thread Nipper Body
 SBL10684 Thread Nipper, Complete

SBL10954 Thread Guide
 SBL10957 Retainer Stud
 SBL10958 Retainer Stud Collar

SBL10992 Spring
 SBL10993 Retainer Sleeve
 SBL141 Screw for 10683
 SBL27561 Lift Lever Spring
 SBL366 Screw for 40034
 SBL397 Screw for 10683, 10957

SBL40034 Thread Guide
 SBL582 Screw for 10593

FRAME 13



SBL1000-3 Idle Roller Assy, Complete

SBL1001 Blank Plate

SBL1002 Idler Shaft

SBL1003 Idler Roller Only

SBL1004 Screw

SBL1005 Short Rear Bolt for 991

SBL1005L Long Rear Bolt for 991

SBL1005W Spacer/ Washer

SBL1006 Front Bolt for 991

SBL1525 Nut for 992A, 992S, 1007

SBL991 Front Clutch

SBL991B Large Clutch

SBL991FCNS New Style Front Clutch

SBL991RCNS New Style Rear Clutch

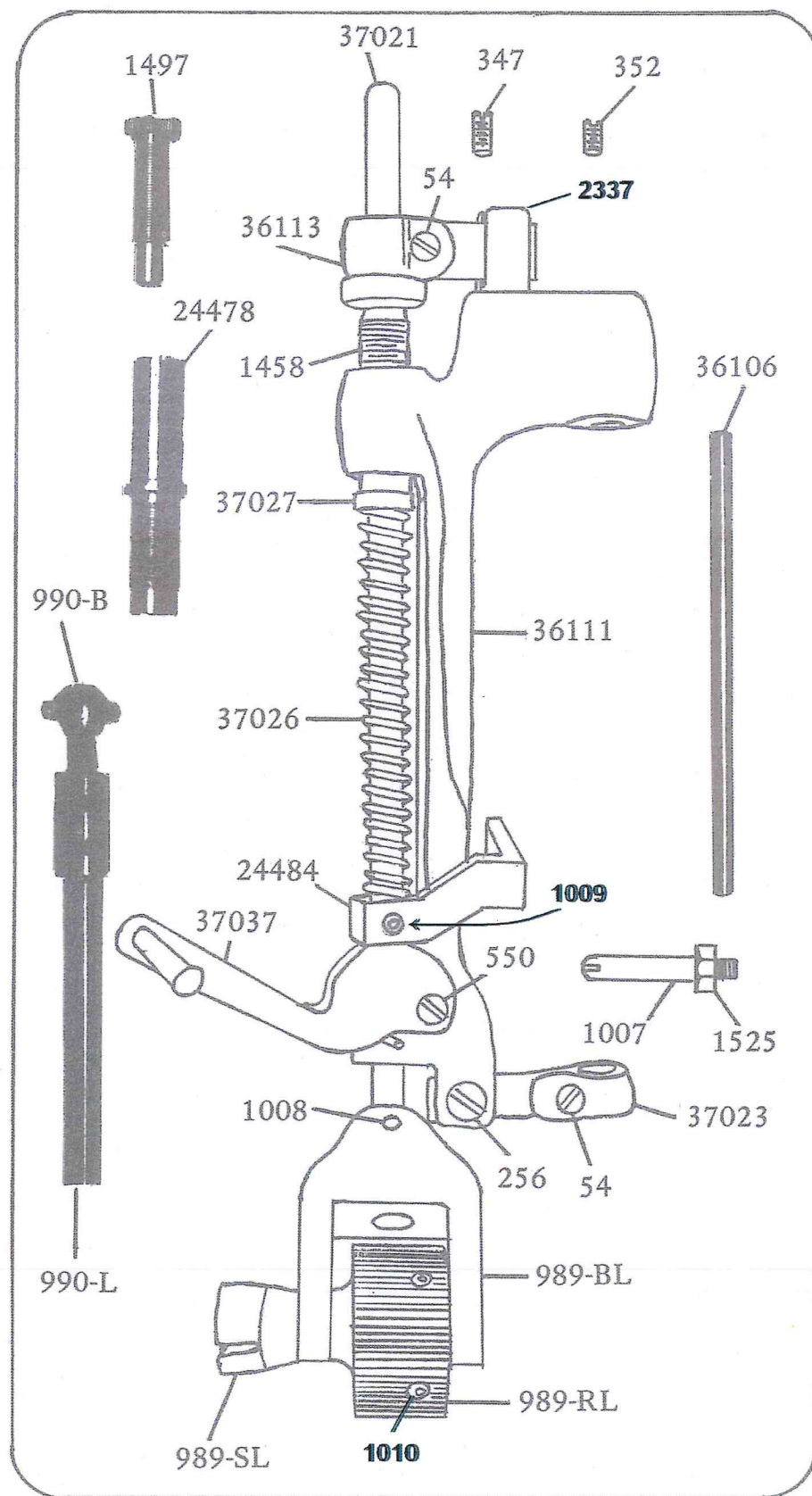
SBL992B Ball Joint

SBL992CW Cut Washer

SBL992R Rear Eccentric

SBL992S Rear Eccentric Shaft

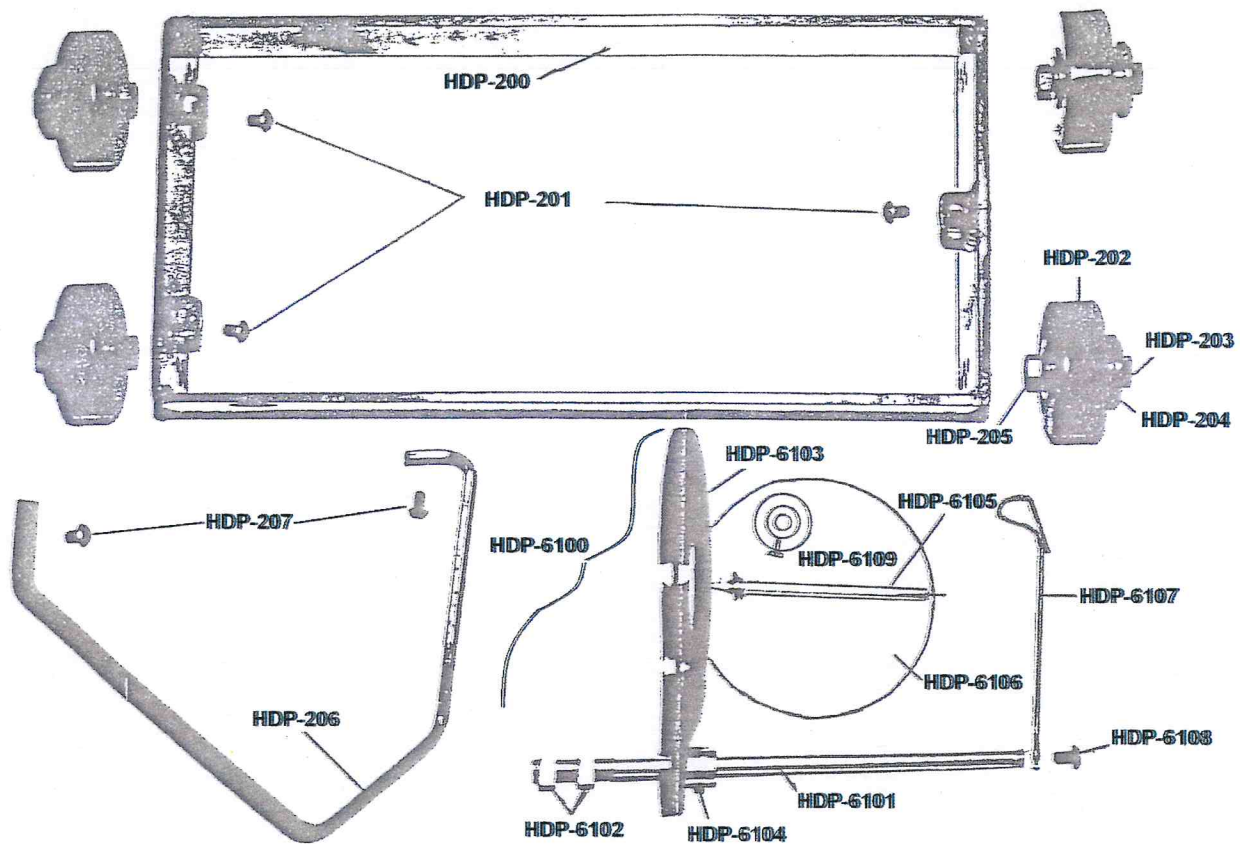
FRAME 14



- SBL1007 Position Stud Screw
- SBL1008 Screw for 991BL
- SBL1009 Set Screw
- SBL1010 Set Screw
- SBL1458 Threaded Bushing for 37021
- SBL1497 Thumb Screw for 24478
- SBL1525 Nut for 1007
- SBL2337 Presser Bar Positioning Guide
- SBL24478 Presser Bar Bushing
- SBL24484 Lift Bracket
- SBL256 Screw for 37023
- SBL347 Screw for 36111
- SBL352 Screw for 2337, 24478
- SBL36106 Presser Bar Spring Rod
- SBL36111 Presser Bar Frame
- SBL36113 Presser Bar Clamp Bracket
- SBL37021 Presser Bar
- SBL37023 Clamp Bracket
- SBL37026 Presser Bar Spring
- SBL37027 Presser Bar Spring Collar
- SBL37037 Lift Lever
- SBL54 Screw for 37023
- SBL550 Screw for 37037
- SBL989BL Bracket for 989RL
- SBL989RL Feed Roller Only
- SBL989SL Shaft for 989RL
- SBL990B Universal Ball Joint for 990L
- SBL990L Shaft for 990B

FOR HDP MACHINE

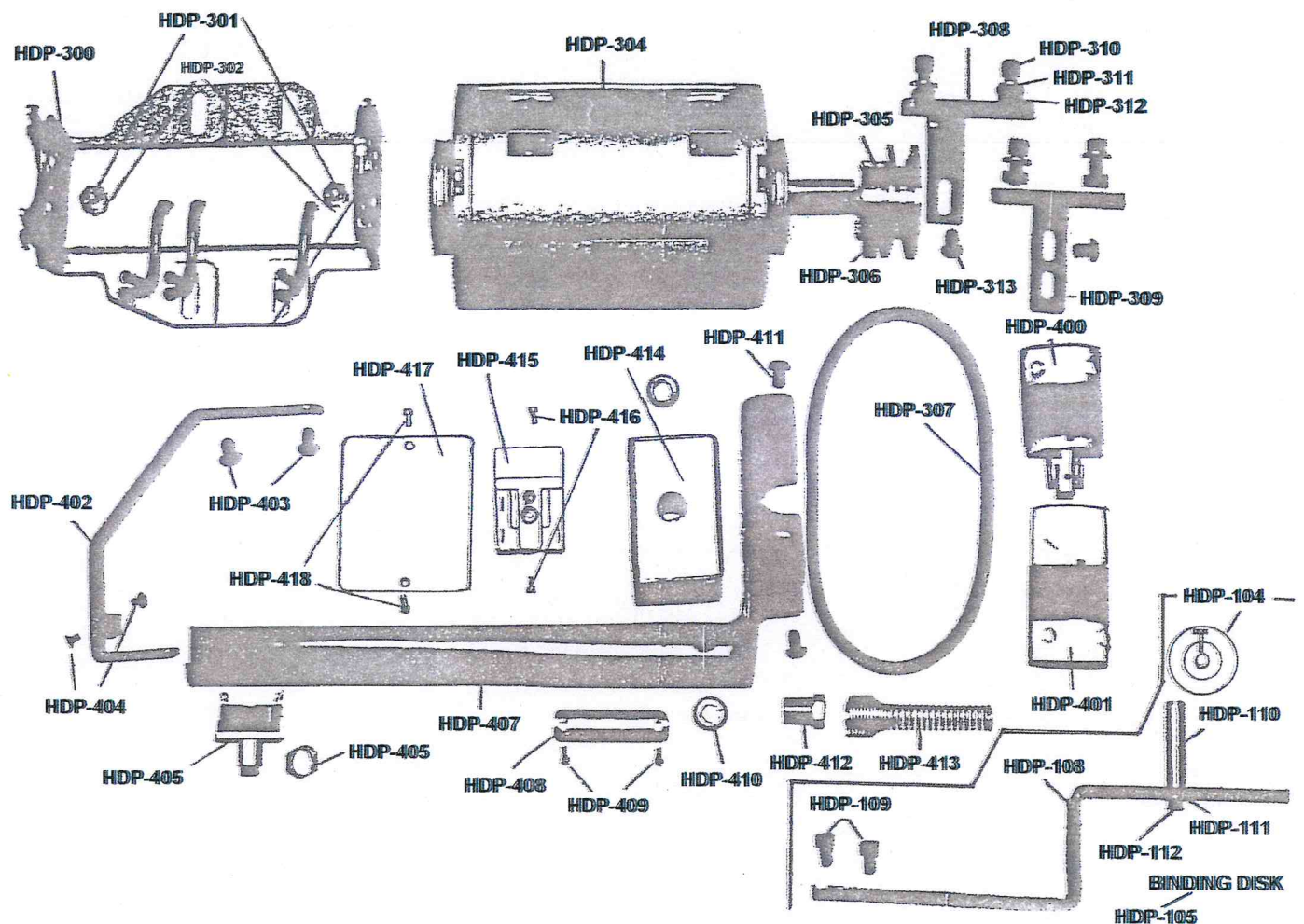
FRAME 15



HDP200 Caster Bracket/ Skirt
 HDP201 Mounting Screw (3)
 HDP202 Caster (4)
 HDP203 Shaft Bolt (4)
 HDP204 Washer (4)
 HDP205 Shaft Nut (4)
 HDP206 Rear Thread Bracket
 HDP207 Mounting Screw (2)

HDP6100 Complete Thread
 Bracket Assembly
 HDP6101 Thread Guide Post
 HDP6102 Post Nut (2)
 HDP6103 Thread Holder Base
 HDP6104 Thread Holder Base Screw
 HDP6105 Spool Post
 HDP6106 Felt Disc
 HDP6107 Thread Guide
 HDP6108 Thread Guide Screw
 HDP6109 Thread Spool Retainer

FRAME 16



HDP104 Binding Hold Down Clamp
 HDP105 Binding Disc
 HDP108 Binding Disc Bracket
 HDP109 Binding Disc Bracket Screw
 HDP110 Binding Bracket Post
 HDP111 Washer
 HDP112 Nut
 HDP300 Motor Base
 HDP301 Adjusting Screw
 HDP302 Top Plate/ Cover (not shown)
 HDP304 Motor 115 Volts
 HDP305 Shaft Pulley Screw
 HDP306 Shaft Pulley
 HDP307 V- Belt
 HDP308 Rear Motor Base Bracket
 HDP309 Front Motor Base Bracket
 HDP310 Screw (4)
 HDP311 Washer (4)
 HDP312 Nut (4)

HDP313 Screw (2)
 HDP400 Male Electric Plug
 HDP401 Female Electric Plug
 HDP402 Switch Handle Bracket
 HDP403 Switch Handle Bracket Screw (2)
 HDP404 Screw (2)
 HDP405 Push Button Switch/ Nut
 HDP407 Switch Handle
 HDP408 Handle Access Cover
 HDP409 Speed Controller
 HDP410 Washer
 HDP411 Handle Bracket Screw (2)
 HDP412 Cord Bushing
 HDP413 Cord Flex Spring
 HDP414 Speed Control Box
 HDP415 Speed Control Switch
 HDP416 Speed Control Switch Screw
 HDP417 Speed Control Box Cover
 HDP418 Speed Control Box Cover Screw (2)