

BOND

PORTABLE BINDING MACHINES PBL-1 and PBL-2



**OPERATING INSTRUCTIONS
MAINTENANCE MANUAL
PARTS & ASSEMBLIES LISTS**



Introducing
BOND'S PORTABLE CARPET BINDERS
PBL1 and PBL2

This instruction manual has been prepared and written to guide you in the current usage of your PORTABLE CARPET BINDER (PBL). 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 returned 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 completely, most especially the bottom.

Send or address all inquiries or returns to:

Service Manager
BOND PRODUCTS, INC.
4511 Wayne Avenue
Philadelphia, PA 19144 U.S.A.
Call Toll Free (888) 800-2663, or
Fax Free (800) 582-9643

When ordering replacement parts, identify the model number and the Serial Number which is located on the base and rear of the machine. We recommend shipping the machine for repairs via UPS or PARCEL POST. Be sure to insure it against damage during transit.

BOND MANAGEMENT

Limited 90 Day Warranty

Bond Products, Inc. makes every effort to assure that its products meet high quality and durability standards and warrants, to the original purchaser, that this product is free from defects in materials and workmanship for a period of 90 days from date of purchase. This warranty does not apply to damage due, directly or indirectly, to misuse, abuse, negligence, repairs or alterations outside our facilities, or lack of maintenance.

We shall in no event be liable for death or injuries to persons or property, or for incidental, contingent, special, or consequential damages arising from the use of our products. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation or exclusion may not apply to you.

To take advantage of this warranty, the product or part must be returned to us with transportation charges prepaid. Proof of purchase, and an explanation of the complaint must accompany the merchandise. If our inspection verifies the defect, we will either repair or replace the product at our election, or we may elect to refund the purchase price if we cannot readily and quickly provide you with a replacement. The repaired product will be returned to you via the most economical route, and you will be charged for the cost of transportation.

This warranty gives you specific legal rights. You may also have other rights which vary from state to state.

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SET-UP AND

As you remove the PBL from its carton, notice how it is packed. (Save the factory carton) Note that the binding bracket and disc are not in place, and that a piece of carpet has been attached to the machine indicating that the machine is in "ready to use" condition.

ALL REFERENCES TO THE OPERATION AND SET-UP OF THIS MACHINE ARE DESCRIBED AS THE OPERATOR WOULD LOOK AT THE FRONT OF THE MACHINE

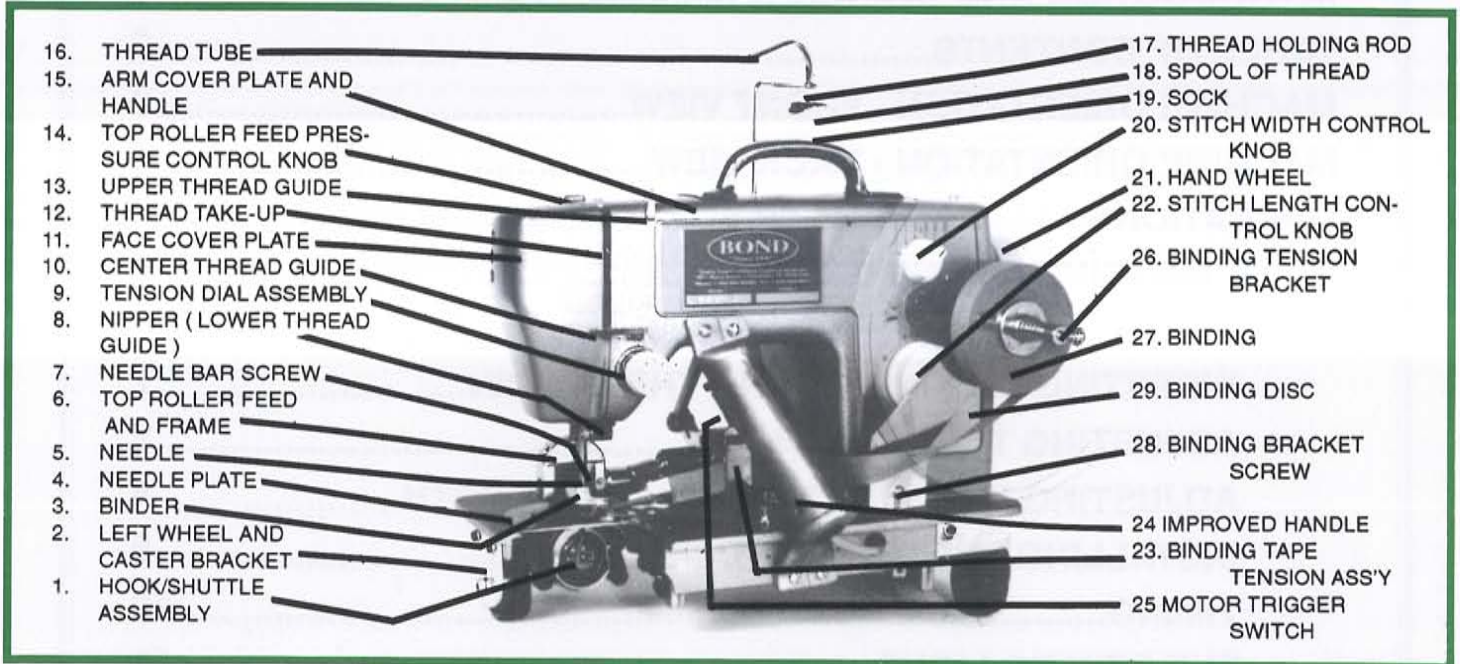


FIG.1 -FRONT VIEW

SET-UP OPERATIONS

Follow these steps in sequence to set up your new machine:

1. Study front and back of machine and compare with Figures 1 and 2 above.
2. Loosen binding bracket screw (Item 28, Figure 1) and attach the binding bracket.
3. Turn Hand Wheel toward the operator to lift the needle to top dead center. The wheel must always be turned in this direction.
4. Lift Top Roller Feed with lifting lever, (back of machine) (Item 45, Fig. 2. Page 4)
5. Remove carpet sample and cut binding that is trailing off the carpet
6. Refer to Page 6 for threading upper machine
7. Study machine and threading diagram before removing thread.
8. Refer to Page 9 for threading of binding
9. Remove binding tension bracket (Item 26, Fig. 1 above)
10. Place your roll of binding on the binding disc
11. Insert binding tension bracket (Item 26) and push down so that 1/4" (6.35mm) of the binding bracket shaft is protruding from the top of the tension bracket, Then tighten screw.
12. Cut the end of the tape in a sharp angle.
13. Thread binding tape through the tape tension assembly. Note: When the tape is being pulled through the tape tension assembly, the binding should unwind clockwise.
14. Thread tape through binder (Item 3, Fig. 1) Use tweezers to pull tape through.
15. Lift top roller feed with lifting lever and place tape under feed then lower lever.
16. Refer to Page 7 for instructions on how to remove bobbin case from shuttle.
17. Refer to page 7 on how to insert bobbin case back into shuttle.
18. Connect the machine. All wiring is factory finished. Plug the machine cord into any 110/120V wall outlet. (International models have been wired for 220/240V where applicable.)
19. The sewing light is located inside the face cover plate, as shown in Fig. 25, Page 11. It may be turned on or off by pushing the light switch (Item 35, Fig. 2 Page 4).
20. Place the corner of the carpet into the mouth of the binder. Be sure to keep the carpet snugly against the right side of the binder mouth.

OPERATION

IMPORTANT: Always turn top of the hand wheel toward you. When machine is not being used, place a piece of material (binding tape) over the feed dog and under the lowered top roller feed. Always have binding tape under the top roller feed when operating the machine. Operating the machine without binding will cause it to jam by not creating a stitch and forcing the thread into the shuttle. To avoid thread breaking, be sure thread tube is raised at least 1" above the thread holding rod when the machine is operating. For shipping the machine, however, be sure the rod is down.

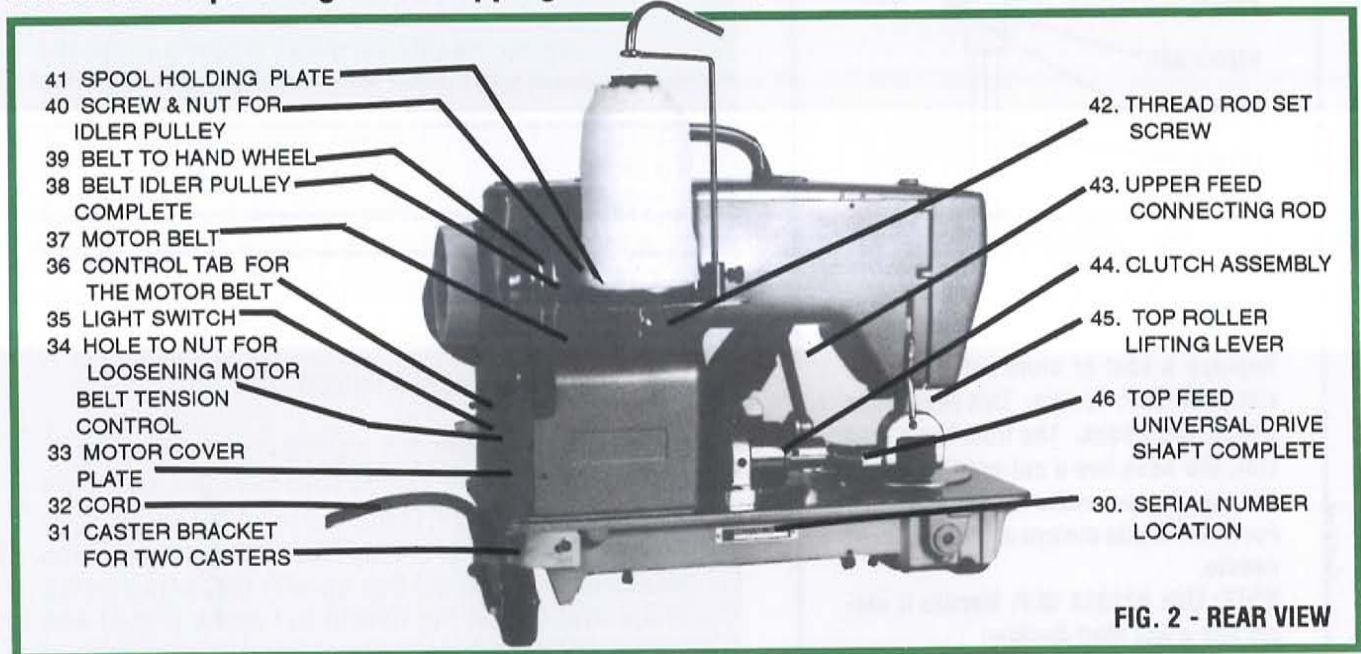


FIG. 2 - REAR VIEW

21. To begin binding, depress the trigger switch (Item 25, page 3) using the forefinger of your right hand. Pull the machine lightly, but firmly, into the carpet and toward your body. This machine binds at the rate of 8' (2.44 mm) per minute. If the machine is pulled faster than the carpet can be fed into the machine

naturally, a clattering sound will result that can cause serious damage.

22. Allow the machine to travel around the carpet on the floor, free from any obstructions. Be sure to keep the power cord well away from the machine.

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 1/4" (6.35 mm) past the corner.

Turn the carpet (or machine) and restart the same corner into the machine and allow that 1/4" tail to be covered with new binding tape. You will notice that a tail of binding about 1-1/4" (31.75 mm) long will appear at the corner. If longer, trim to 1" (25.4 mm)

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

A. Place a bead of HOT MELT GLUE on the back side of the binding tape, then fold the tape back at a 45° angle and press into the backing of the carpet, spreading out the adhesive. The glue will be very hot, so PROTECT YOUR FINGERS!

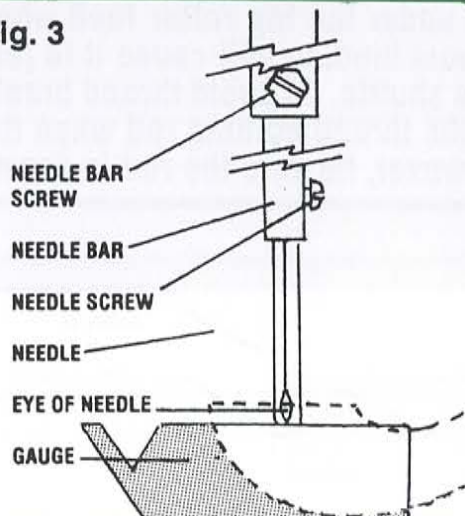
B. Using the Hand Binding Stapler with the depth-stop removed, staple the tail back. (When binding cut-pile carpets, pluck up any nap drawn down by the staple.)

2. One piece corner

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

CHANGING THE NEEDLE

Fig. 3



Replace a bent or blunt needle with a sharp #22 D.P. Needle. This needle has a front and a back. The front has a long slot, the back has a cut-out just above the eye of the needle called a "scarf". For best results always use a fresh new needle.

NOTE: Use #21023 W.P. Needle if carpet has a Hot Melt Backing

Raise the needle bar (Shown in Fig. 3) to its highest position by turning the hand wheel in your direction. Hold the needle with the scarf away from you and the long slot facing forward.

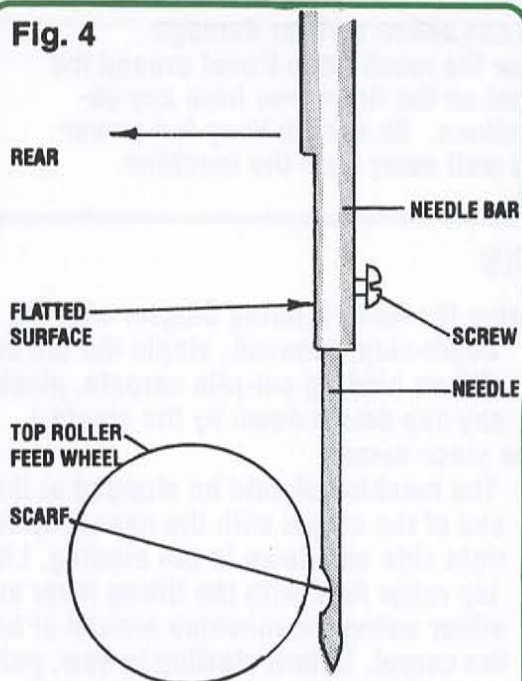
Slip the needle as far as it will go into the needle clamp and tighten the needle clamp screw (Use screwdriver provided)

NOTE: If the needle is put in backwards with the long slot facing to the back of the machine, serious damage to the lower hook assembly may result. Always be sure the slot is facing toward you with the needle scarf to the back of the machine.

HOW TO CHECK NEEDLE HEIGHT

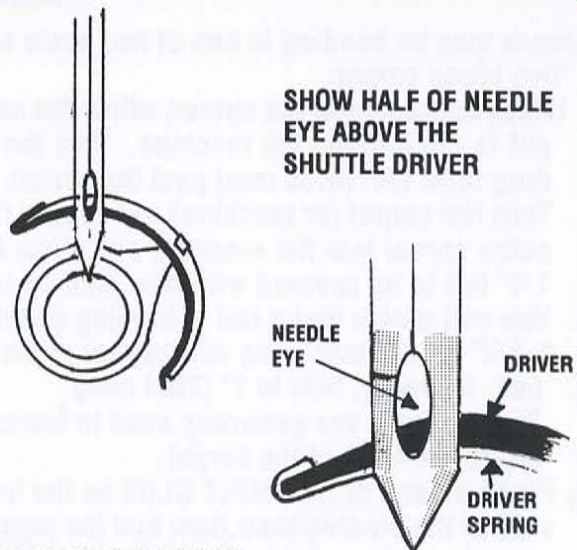
WITH THE NEEDLE BAR IN ITS HIGHEST POSITION, MEASURE 3/4" (19.05 MM) from the feed plate (with needle inserted) to the bottom of the needle eye, or use the square end of the #PBL Timing gauge. If the measurement does not line up with the bottom of the eye, loosen the needle bar screw (Fig.3) and move the shaft up or down as necessary to obtain proper height. If no gauge is available, measure with the needle bar on the right side in its lowest position. The point of the hook should be 1/16" (1.59 mm) above the eye of the needle, or when the needle is on the right side, lowest down stroke, the upper half of the needle eye should be slightly visible above the shuttle driver (Fig. 5).

Fig. 4



NOTE: Where needle inserts into the needle bar, the back of the needle bar is flat. This is for top roller feed clearance. BE SURE THE FLAT SIDE IS FACING THE TOP ROLLER FEED. If not, serious damage could result.

Fig. 5



DRIVER SPRING SHOULD SHOW IN BOTTOM EDGE OF NEEDLE EYE

THREADING UPPER MACHINE

1. Place a full spool of thread on the spool holding plate (Fig. 6) and tighten thread holding rod (Page 3, Fig 2, Item 41)
NOTE: Be sure the sock is placed on spool of thread. This prevents the thread from falling off or becoming entangled with the thread tube. When the spool of thread is half used, or when the sock becomes loose, tighten it by either soaking in water and allowing it to dry overnight, or folding the side of the sock over and tapping the excess material.
2. Center the thread tube over the thread holding rod at a distance of about 1" (25.4 mm) above the holding rod.
3. Insert thread through thread tube.
4. Insert thread through upper thread guide.
5. Insert thread between discs of the thread tension assembly (Fig. 7 & 8).
 - A. Hold the thread in both hands
This will prevent the thread from coming off the spool.
 - B. With thread between discs, pull straight up with both hands until a "CLICK" is heard.
 - C. With left hand, lift thread up.
This will pull the spring wire loop (check spring) up and past the top hook until the thread can be slipped into the hook. When hands are released, the spring wire loop will return to position as shown with the thread in its proper place.
6. Place thread through thread take-up from the right side. Be sure thread take-up is in an "up" position.
7. Place thread through center guide.
8. Thread the nipper:
 - A. Hold thread in both hands
 - B. Push thread into the nipper from the front. You should hear a "click".
9. Place thread through eye of needle from the front.
10. Lift the top roller feed with lifting lever and pull the thread under it to allow a minimum of 6" (15.2 cm) of excess thread to extend beyond the top roller feed. Lower lever.

Fig. 6

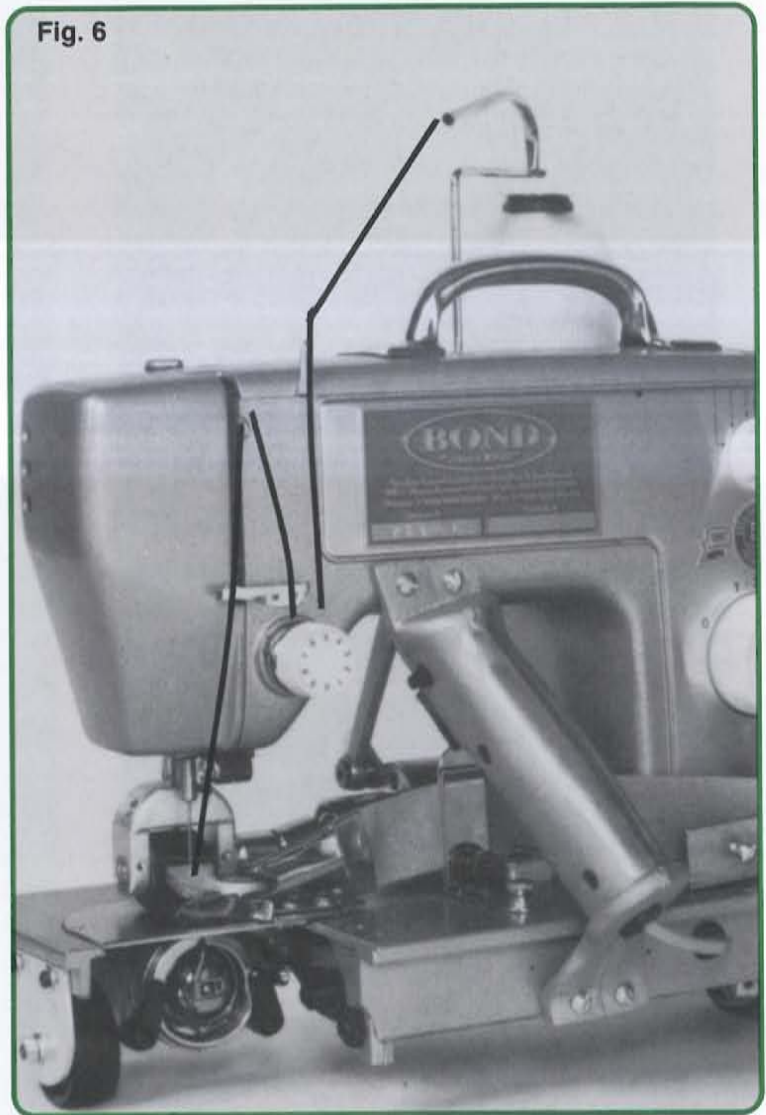


Fig. 7

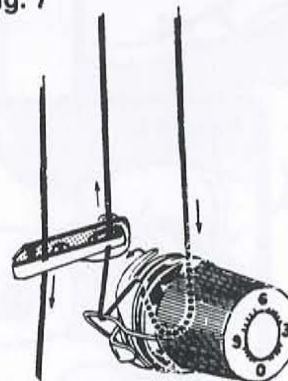
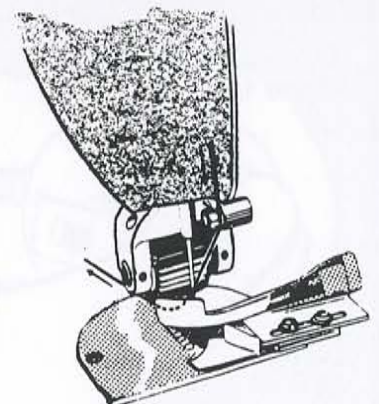


Fig. 8



INSERTING BOBBIN THREAD

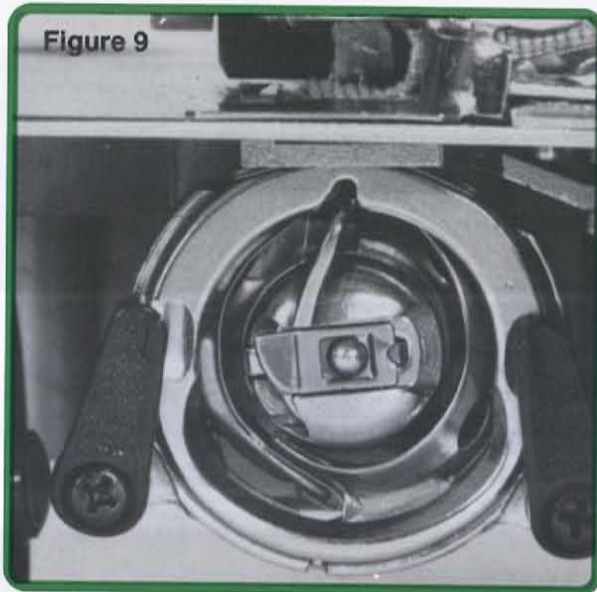


Figure 9

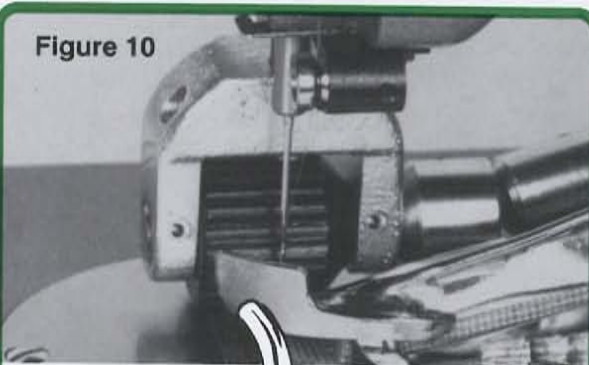


Figure 10

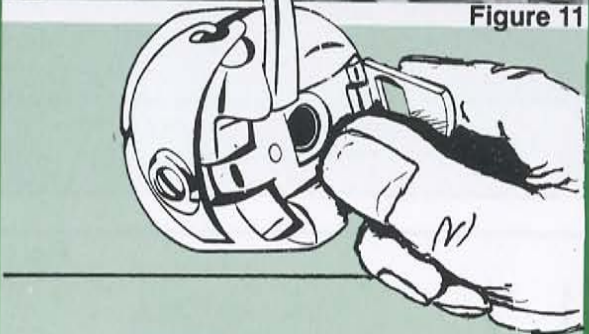


Figure 11

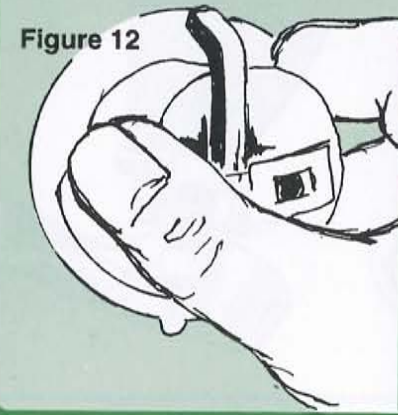


Figure 12

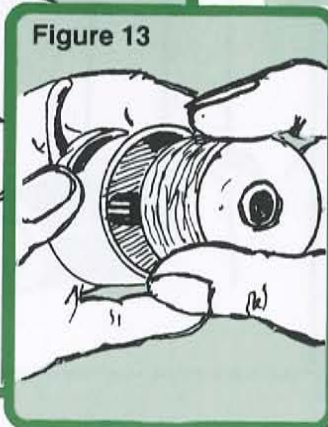


Figure 13

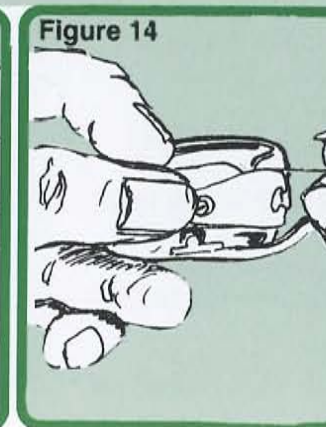


Figure 14

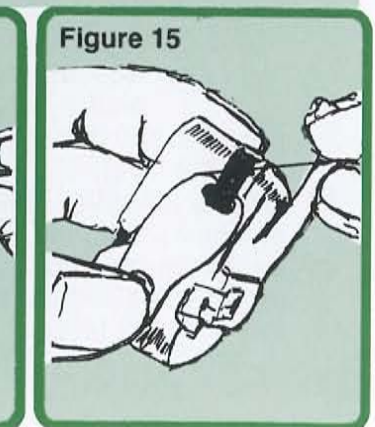


Figure 15

To remove bobbin case from hook/shuttle assembly, refer to Figure 9.

1. The needle bar must be in its highest position (See Fig 10).
2. Pull out the holding latch (Figure 11).
3. Pull bobbin case straight out (Fig. 12.)
4. Guide bobbin onto center pin of bobbin case (Figure 13).

NOTE: Bobbin should unwind clockwise.

5. Pull thread through slot (Figure 14).
6. Pull thread under tension spring (Figure 15).
7. Drape about 1" (25.4 mm) of thread over the holding latch side of the bobbin case.
8. Position bobbin case into hook/shuttle assembly with stem facing up. (Figure 12)

Push bobbin case until you hear a "click".

NOTE: This bobbin does have a center core and is especially wound to provide more binding yardage - 100 yards.

9. To pick up the bobbin thread, hold the needle thread tightly in the left hand (Refer to step 10 of threading upper machine) and rotate hand wheel toward you for two complete turns. This will automatically pick up the bobbin thread and start to stitch in the binding tape.

DO NOT PULL NEEDLE THREAD OR BINDING TAPE. LET THEM FEED THROUGH THE MACHINE NATURALLY.

10. Push on the machine switch and run one foot of binding to check performance.

ADJUSTING THREAD TENSIONS

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

When stitching is unsatisfactory, as in Samples 1 and 2, adjust the upper thread tension.

The upper thread tension is set at the factory at #6. This setting should give you proper stitching. Check your machine dial and adjust, if necessary, to correct your stitch problem. (Figures 16 & 17)

Lower tension is made through adjustments on the bobbin case. Slight adjustments are made with a screw driver with 1/8 turn in either direction with a screw driver (Ref. Figure 18)

Figure 18

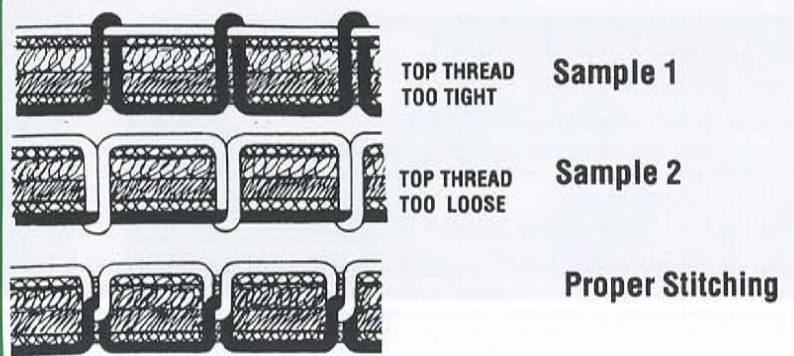


Figure 16

To decrease tension turn knob counterclockwise

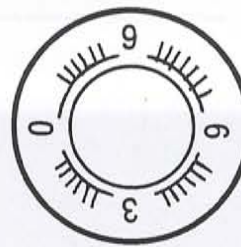
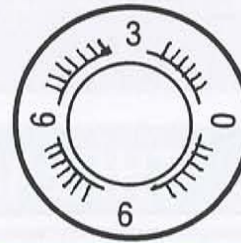


Figure 17

To increase tension, turn knob clockwise



SETTING STITCH LENGTH AND WIDTH

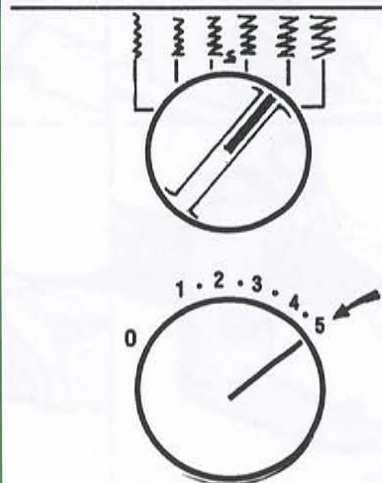
This has been performed at the factory. The stitch length is controlled by the large round knob (Figure 19), and it should be on setting #5. The width is controlled by the small knob above, and should be set on the second design from the right.

ADJUSTING YOUR PBL BINDER FOR GOOD STITCHES

When your PBL does not sew a properly locked stitch, check the following:

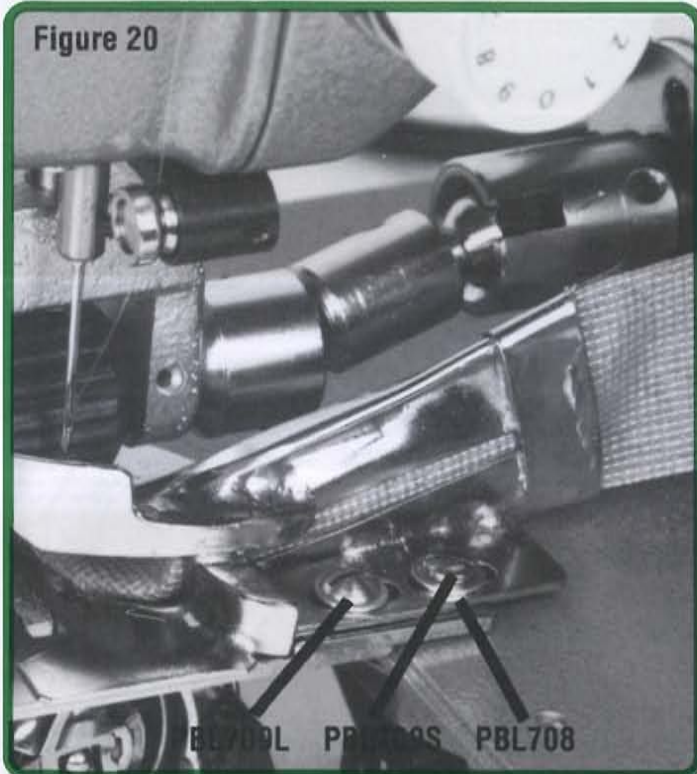
1. Insert a new #22 needle
2. Check threading carefully
3. Check the thread tension balance
4. Check needle height
5. Check timing

Figure 19



SELECTION AND PLACEMENT OF BINDER

Figure 20



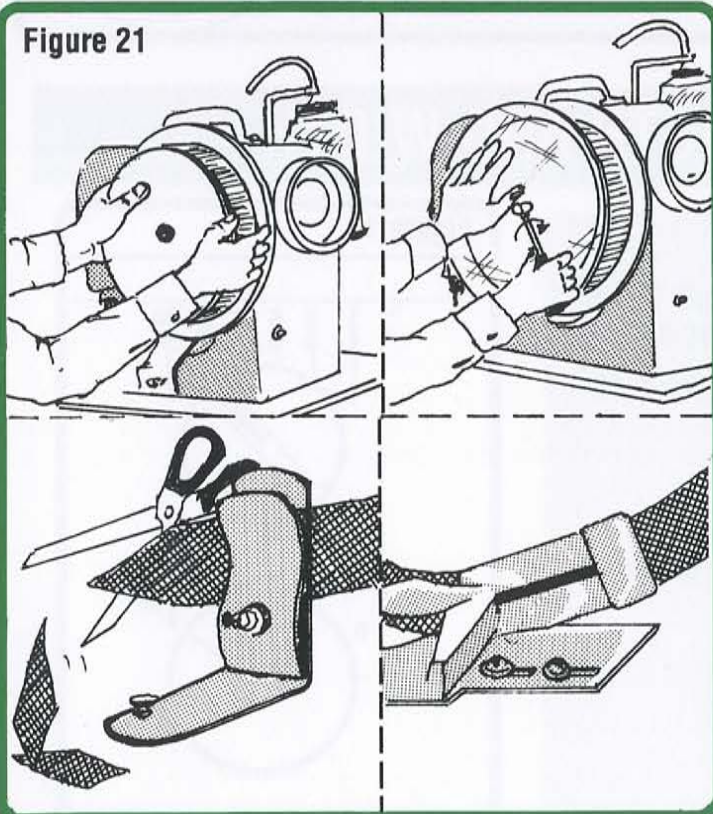
Removal, replacement and adjustment. The binder is held in place by two (2) screws (See Figure 20). The right one is shorter than the left one.

To adjust the binder, loosen the screws, slide the binder all the way to the left with the binder tape through and under the top roller feed. Tighten the binder screws and run about 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 the binder 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 binder. Use BOND's Edge Beveler, EW 610, before binding dense, high pile carpet.

THREADING OF BINDING

Figure 21



Refer to Figure 21

1. Place binding on binding disc.
2. Insert onto binding tension bracket and push down so that 1/4" (6.35 mm) of shaft is showing.
3. Tighten adjustment screw.
4. Thread binding tape through tape tension assembly. When tape is being pulled through the tape tension assembly, the binding should unwind clockwise.
5. Cut the end of the tape at a sharp angle.
6. Thread tape through binder (use tweezers to pull tape through).
7. Lift top roller feed with lifting lever, place tape under feed and lower lever.

TIMING

1. Turn hand wheel toward operator until the needle comes down on the left side of the throat plate (See Item 5, Fig. 22) through the slot and stops at bottom dead center.
2. Insert the PBL Feeler Gauge (PBL-782) between the hook and needle (See Fig. 23)
3. If feeler gauge cannot be inserted, or when inserted there is a space between the hook and the needle, the timing is off and must be adjusted.
4. The following procedure is used in timing adjustment:

A. Raise needle bar until both timing screws come into view. Loosen screw (B) first; then lower needle bar on the left side and on its lowest downstroke. (See Figure 24) Now, loosen timing screw (A).

B. Rotate lower shaft. Notice the hook/shuttle will move back and forth. The remainder of the machine will not rotate.

C. Rotate shaft until hook point is pressing against the PBL feeler gauge, and the feeler gauge is pressing against the needle. This space is $5/32$ " (3.97 mm) DO NOT MOVE THE NEEDLE AS IT WILL CAUSE IMPROPER TIMING.

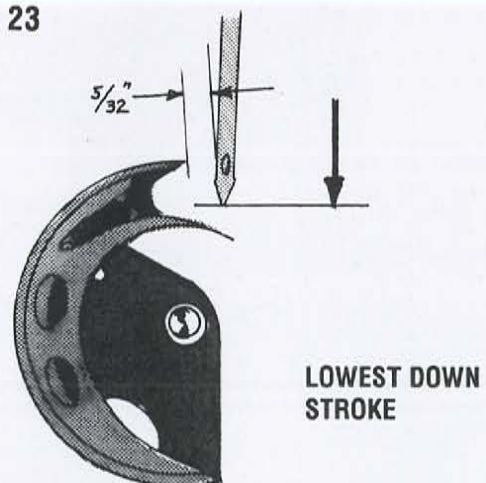
D. Tighten timing screws.

E. Rotate hand wheel until needle bar comes down the right side, then the left side, and finally dead bottom center. Re-check with the PBL feeler gauge.

Figure 22

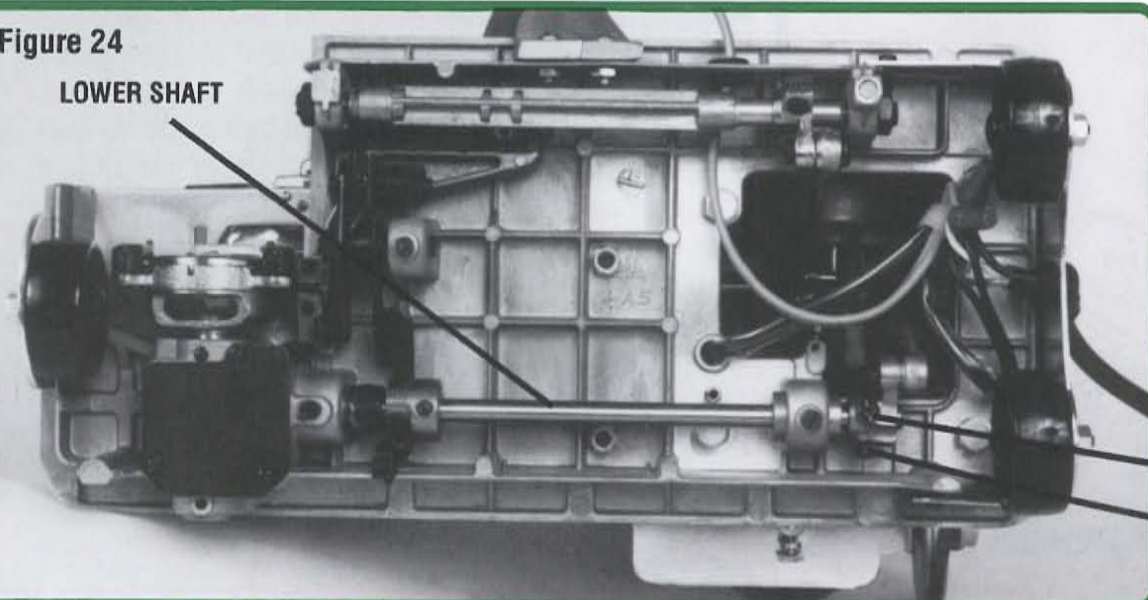


Figure 23



To time the hook, the needle must be on the left side and at the lowest point of its downstroke.

Figure 24

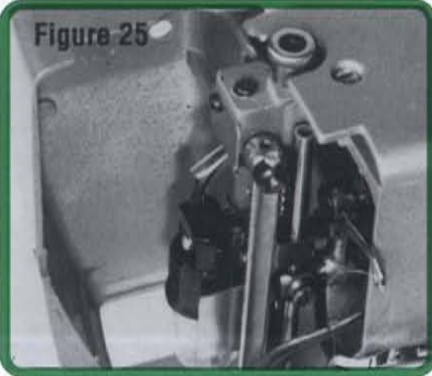


CAUTION:
Oil hook assembly after every half hour of operation. Use only Bond #21020 stainlessoil! NOT MOTOR OIL!

TIMING SCREW A
TIMING SCREW B

SEWING LIGHT

Figure 25

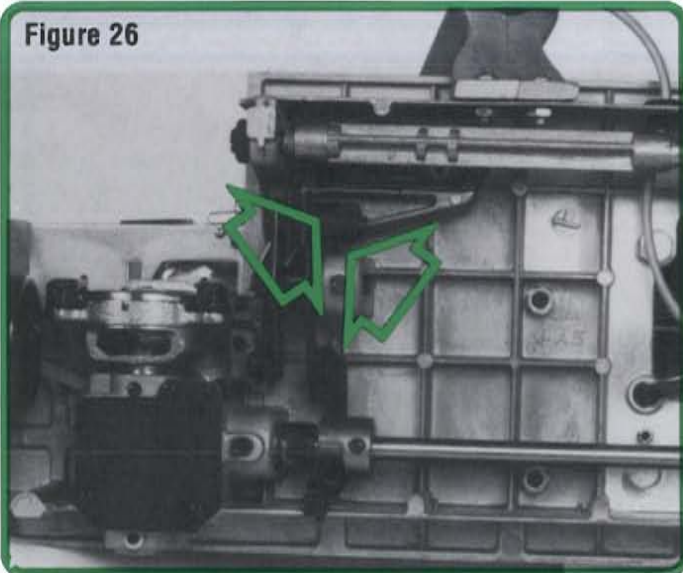


The sewing light is located inside the face cover plate as shown in Figure 25. It may be turned on or off by pushing the light switch button (Figure 2 Item 35, Page 4.)

To remove the bulb, turn light switch off, open the face cover plate by swinging it open, turn the bulb counterclockwise, and remove it from the socket. To replace, turn new bulb clockwise. Do not over tighten.

FEED DOG ADJUSTMENT

Figure 26

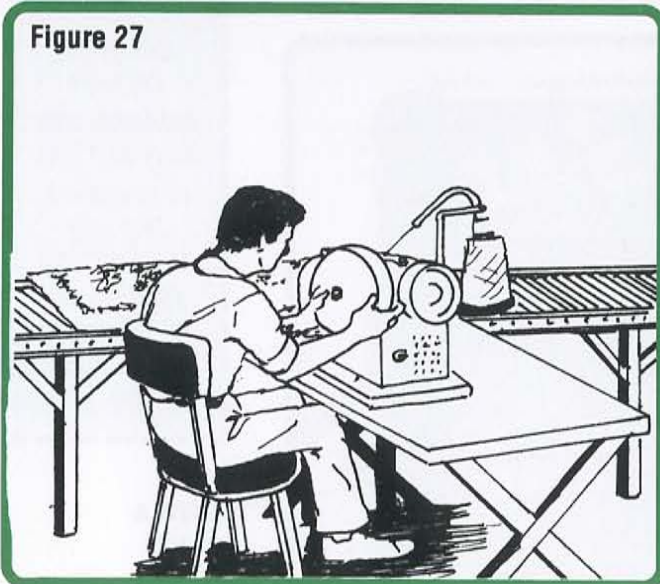


Although pre-set at the factory, should the feed dog move out of adjustment, reposition as follows:

1. Before attempting to adjust feed dog, take the needle plate off (Fig.1, Item 4, Page 3) and clean all lint from the feed dog area. Replace needle plate.
2. Refer to Figure 26 for set screws and adjustment eccentric locations. Turn hand wheel until feed dog is in an up position, loosen set screw and turn adjustment eccentric until feed dog is as far up as possible, and tighten set screw.

USING THE PBL AS A TABLE MODEL

Figure 27



When used as a table model, we recommend a roller conveyor system. Start carpet by placing the corner of the carpet into the mouth of the binder. Run the motor with the foot pedal and guide the carpet with both hands. Push the roll of carpet just enough so the carpet will feed through the machine at its own speed. Also, pull the carpet to the right so carpet will stay tight against the right side of the binder mouth.

Note: Serious damage will result if the carpet is forced.

We have submitted a typical conveyor/ table floor plan to the left. (See Figure 27)

TOP ROLLER FEED ADJUSTMENT

When top roller rotates faster than the bottom dog feed, the binding may not catch or cover the bottom side of the carpet. Loosen the 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.



Figure 28

REPLACING DRIVE BELTS & ADJUST TENSION

1. Remove sleeve screw holding light switch (Refer to Figure 29)
2. Remove screws from right side plate.
NOTE: THE BOTTOM LEFT SCREW IS SHORTER THAN THE OTHER THREE SCREWS.
3. Loosen belt control tab with either a screw driver or wrench.
4. Loosen center screw of belt idler pulley. Slide pulley forward.
5. Remove belts.
6. To replace belts, reverse this procedure.
7. Adjust belt tensions as follows:
NOTE: The following adjustments can be made with the side cover on.
 - A. Slide belt idler pulley away from the machine until belt leading the hand wheel is firm (not tight). Tighten screw.
 - B. Press down on belt control tab. The belt leading from the motor to the belt idler **MUST** have play. Halfway from the motor pulley to the idler pulley, the play in the belt should be approx. 1/4". (6.35 mm) Press belt inward with the finger to test. Without play, the motor bearings will burn out.
 - C. When adjusted, tighten belt control tab screw.

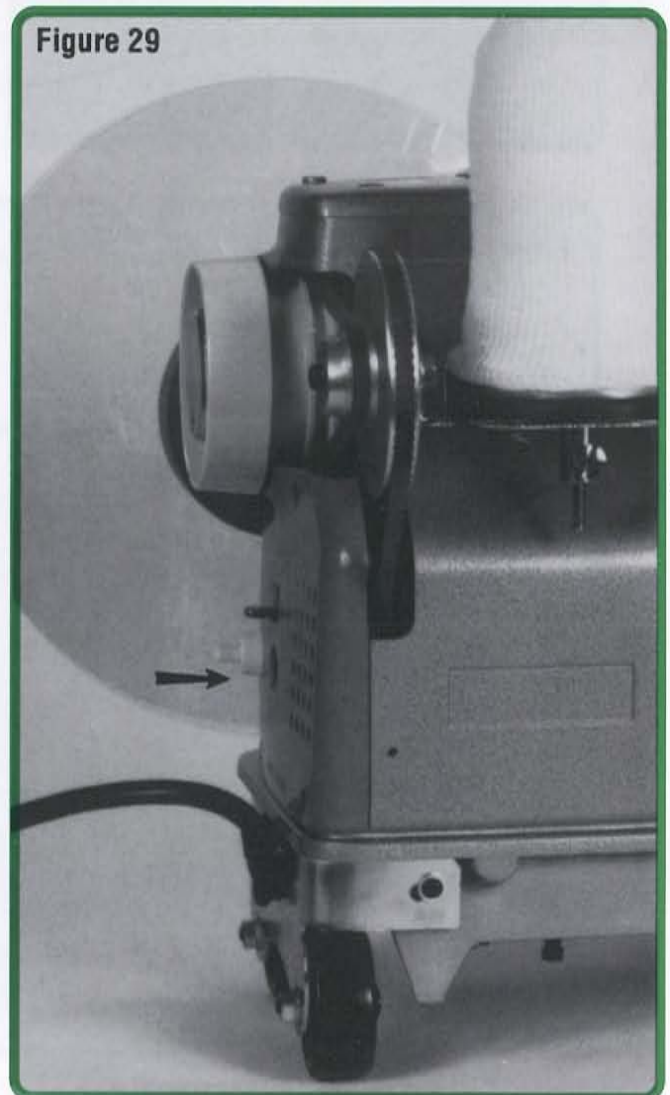
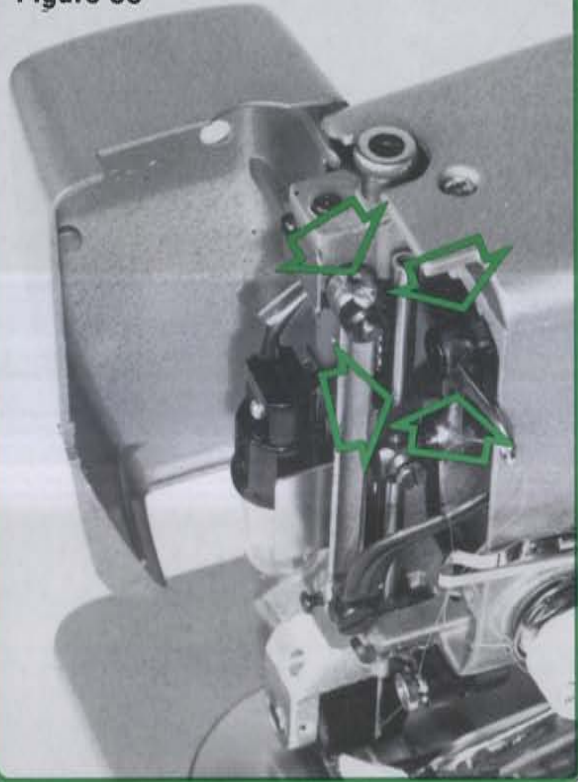


Figure 29

MAINTENANCE - CLEANING AND OILING

Figure 30

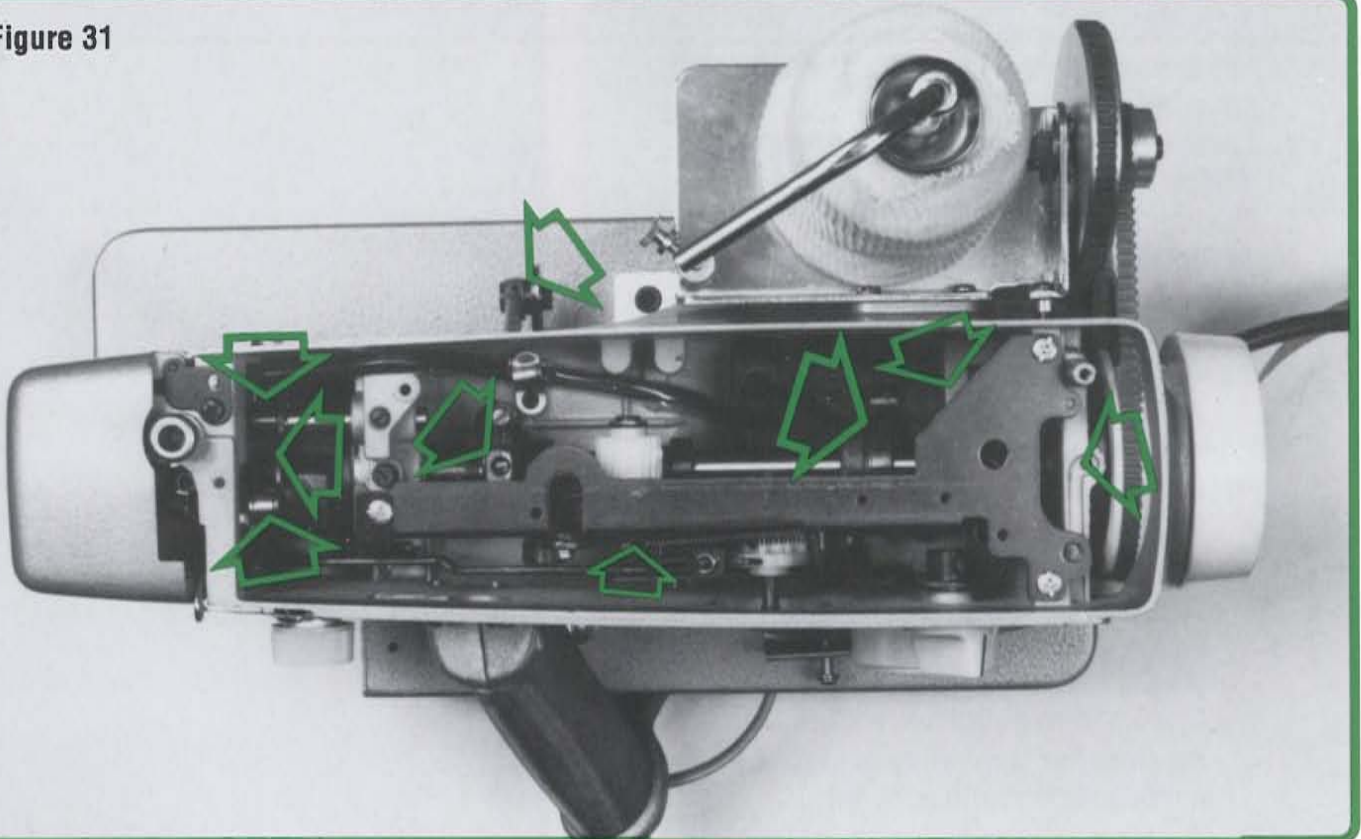


Keep the moving parts free from dust and excess thread for efficient operation. Cleaning should be done with a small brush.

The machine should be oiled every working day or after every eight hours of operation. Should the machine stand idle for a prolonged period, it should be oiled before you start using it again.

1. Swing open the hinged face cover plate to oil all the points indicated at the end of the machine head (Refer to Figure 30. Oil (4) locations.
2. Remove the handle/arm cover plate to oil all points indicated in the top of the machine. (Refer to Figure 31) To remove the handle/arm cover plate, remove the screws and lift plate from machine. Oil (9) locations.

Figure 31



MAINTENANCE - CLEANING & OILING (Cont'd)

3. It is necessary to periodically clean the hook/shuttle area. We recommend once after every eight hours of operation. (Figure 32).

- A. Turn hand wheel toward you to raise the needle to it highest point.
- B. Remove the bobbin case (See Pg.7).
- C. Push the latches sideways (Fig.33) from the hook/shuttle assembly, and lift out race cover (Figure 34). Then holding the center pin, remove the hook (Figure 35)
- D. Clean the shuttle of any lint or thread with a small brush, tweezers, or an oiled cotton swab.
- E. Oil all parts and reassemble.

NOTE: Be sure the shuttle race cleaner is in place (Figure 35). Should the shuttle race cleaner jump out of the race body, replace it as shown in Figure 36. Insert the cleaner in space (A) with the protrusion (B) fitting in the slot (C) forming a perfect circle with the driver (D). Notice cut-out on protrusion must face down.

Figure 33

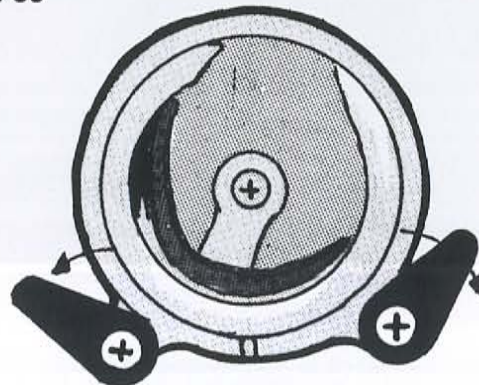


Figure 34



Figure 35

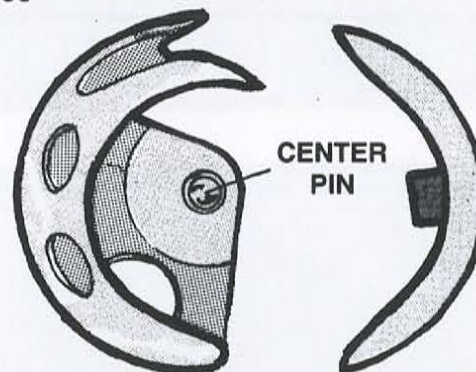


Figure 36

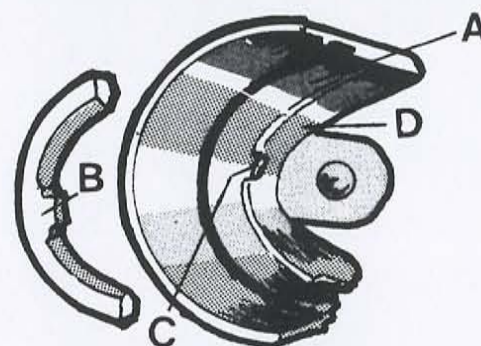
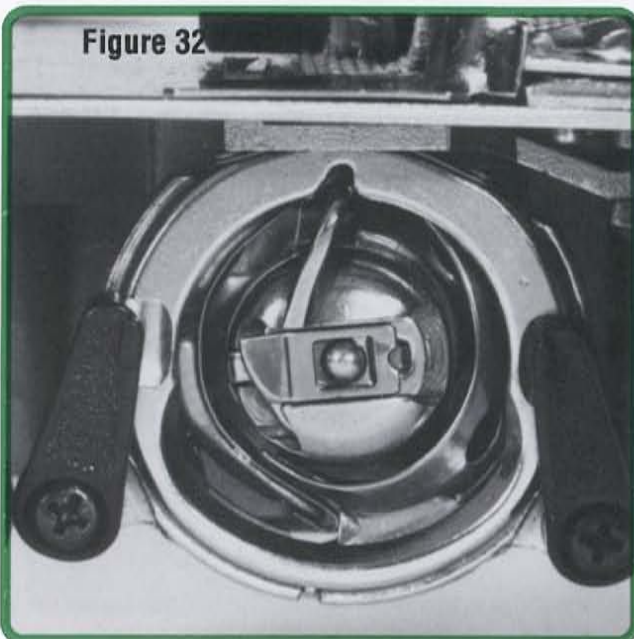
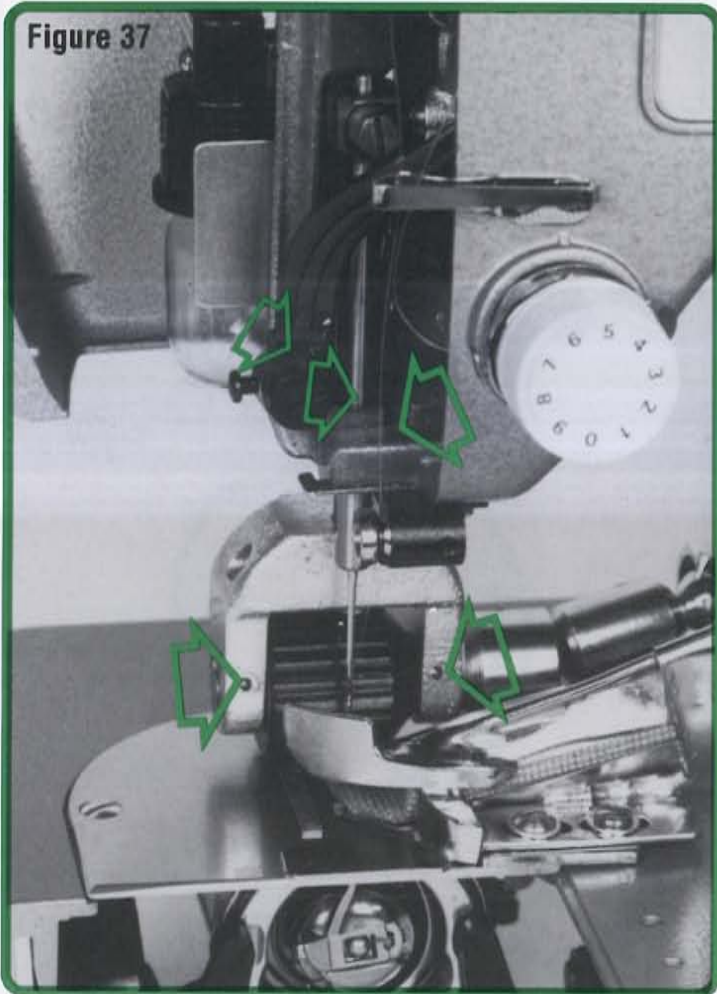


Figure 32



MAINTENANCE - CLEANING & OILING (Concluded)

Figure 37



4. Oil all parts of the needle bar area as shown in Figure 37. (5) points are identified.
5. Oil clutch drive arm as shown in Figure 38. (1) point.
6. Tilt machine back to oil points as indicated in Figure 39 (22 points) on underside of the machine head.

Figure 38

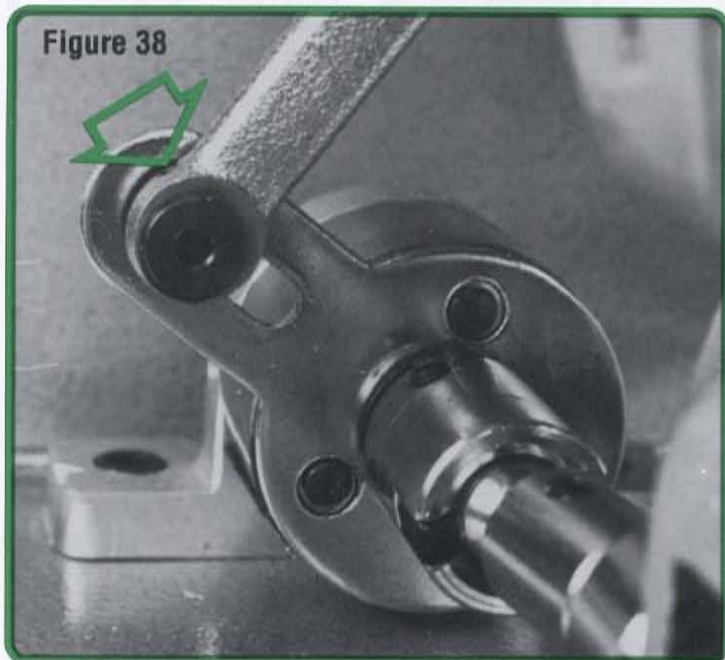
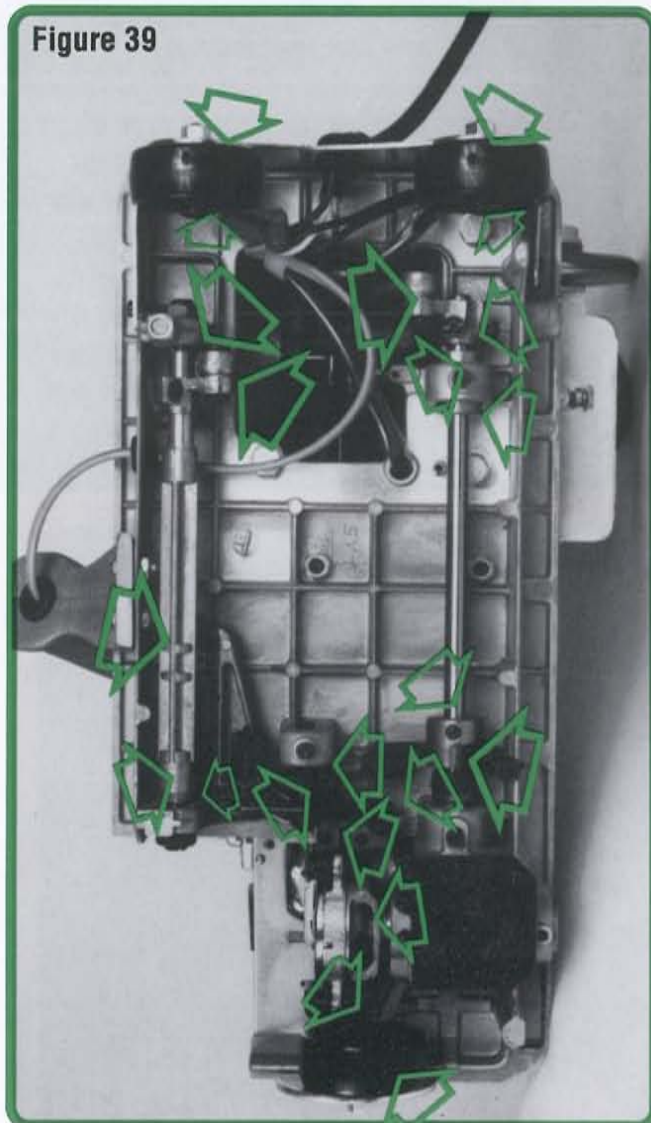


Figure 39



BOND'S INDEX OF DIAGRAMS

ON THE FOLLOWING 12 PAGES, YOU WILL FIND DIAGRAMS OF MAJOR PARTS AND ASSEMBLIES IN YOUR PBL MACHINE WITH THE PART NUMBERS CLEARLY IDENTIFIED. WE HAVE INCLUDED THIS PORTION OF THE MANUAL TO HELP YOU IDENTIFY PARTS AND ASSEMBLIES FOR ORDERING OR MAINTENANCE PURPOSES.

DIAGRAM 1 - Top Plate and Handle	PAGE 17	DIAGRAM 26- Motor and Thread Bracket	PAGE 23
DIAGRAM 2 - Front Plate	PAGE 17	DIAGRAM 27- Motor and Wheel Belts	PAGE 23
DIAGRAM 3 - Hinged Face Plate	PAGE 17	DIAGRAM 28- Thread and Tube Holder	PAGE 23
DIAGRAM 4 - Stitch Length Knob	PAGE 17	DIAGRAM 29- Thread Spool and Sock	PAGE 23
DIAGRAM 5 - Stitch Width Knob	PAGE 17	DIAGRAM 30- Zigzag Drive Crank	PAGE 24
DIAGRAM 6 - Binding Tension	PAGE 17	DIAGRAM 31- Unit Frame Assembly	PAGE 24
DIAGRAM 7 - Handle and Switch	PAGE 18	DIAGRAM 32- Hand Wheel and Shaft	PAGE 24
DIAGRAM 8 - Binding Bracket	PAGE 18	DIAGRAM 33- Motor	PAGE 25
DIAGRAM 9 - Face Plate Thread Guide	PAGE 18	DIAGRAM 34- Power Cord	PAGE 25
DIAGRAM 10- Tension Dial Assembly	PAGE 18	DIAGRAM 35- Light Switch	PAGE 25
DIAGRAM 11- Thread Nipper Assembly	PAGE 18	DIAGRAM 36- Belt Cover	PAGE 25
DIAGRAM 12- Needle Plate	PAGE 19	DIAGRAM 37- Front Caster Bracket	PAGE 25
DIAGRAM 13- Binder Mechanisms	PAGE 19	DIAGRAM 38- Rear Caster Bracket	PAGE 26
DIAGRAM 14- Take-up Lever Assembly	PAGE 20	DIAGRAM 39- Accessory Kit	PAGE 26
DIAGRAM 15- Needle Bar and Frame	PAGE 20	DIAGRAM 40- Shears	PAGE 26
DIAGRAM 16- Top Feed Presser Bar	PAGE 20	DIAGRAM 41- Bobbins, Gauge, Needles	PAGE 27
DIAGRAM 17- Light Assembly	PAGE 20	DIAGRAM 42- Foot Control	PAGE 27
DIAGRAM 18- Gear Box Cover	PAGE 21	DIAGRAM 43- Table	PAGE 27
DIAGRAM 19- Shuttle Race and Bobbin	PAGE 21	DIAGRAM 44- PBL2 Caster Assembly	PAGE 27
DIAGRAM 20- Lower Shaft Bevel Gear	PAGE 21	DIAGRAM 45- Crank/Connect. Rod Ass'y	PAGE 28
DIAGRAM 21- Feed Crank Assembly	PAGE 21	DIAGRAM 46- Universal Coupling	PAGE 28
DIAGRAM 22- Feed Rock Shaft Assembly	PAGE 22	DIAGRAM 47- Back Feed Roller Assembly	PAGE 28
DIAGRAM 23- Feed Dog	PAGE 22	DIAGRAM 48- Back Lift Lever Assembly	PAGE 28
DIAGRAM 24- Top Feed Clutch Drive	PAGE 22	DIAGRAM 49- Clutch Assembly	PAGE 28
DIAGRAM 25- Presser Lever	PAGE 22	DIAGRAM 50- Idler Roller Plate	PAGE 28

NOTE

Bond has also provided a listing of part numbers in numerical order. These can be found on pages 35 to 37 of this manual. It is hoped you will find these two listings helpful to you to identify any part(s) you may wish to order, or for which you may have any questions during the use of your Portable Carpet Binder, (PBL 1 or 2).

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PARTS DIAGRAMS - MAIN EXTERIOR

DIAGRAM 1

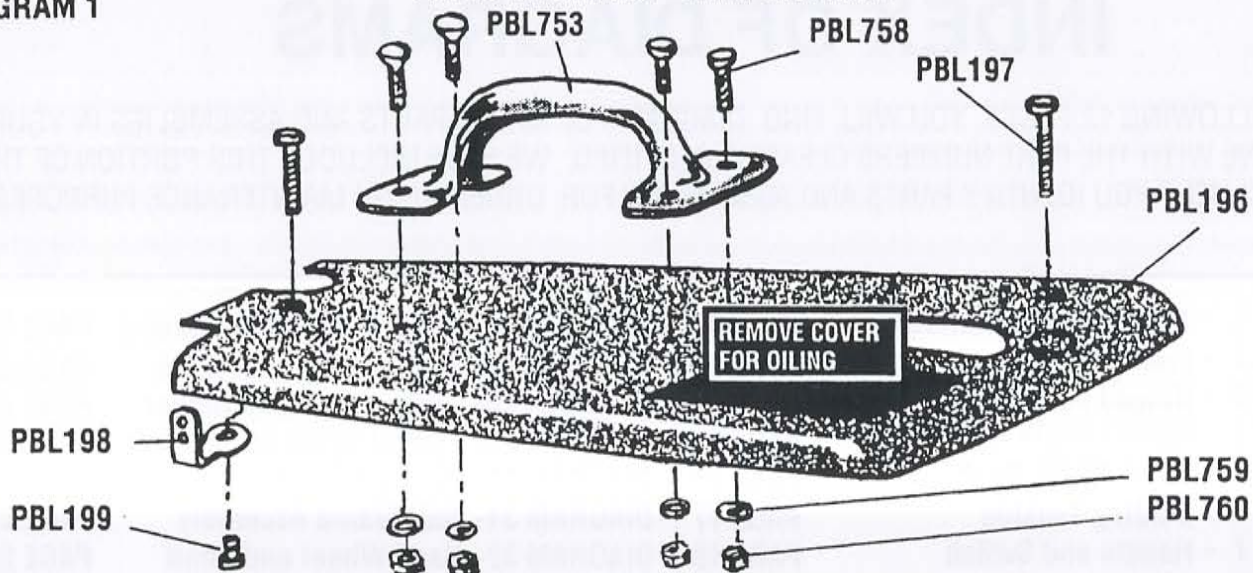


DIAGRAM 2

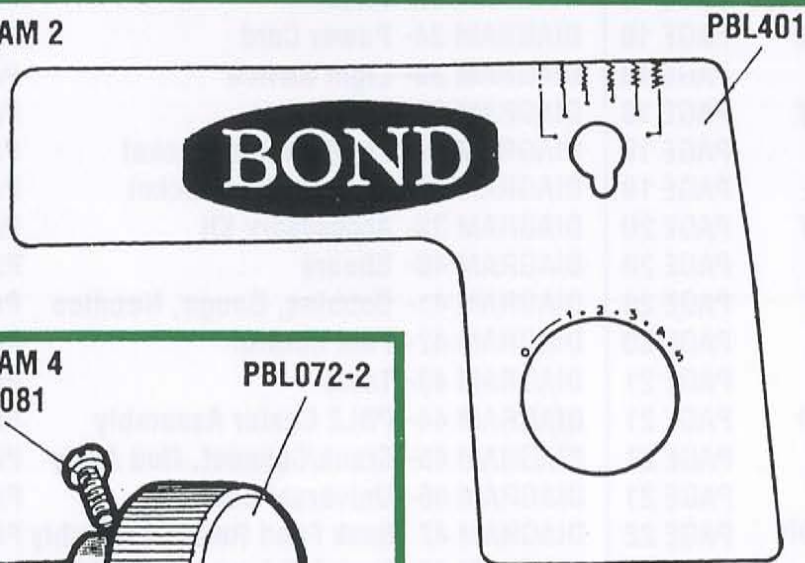


DIAGRAM 3

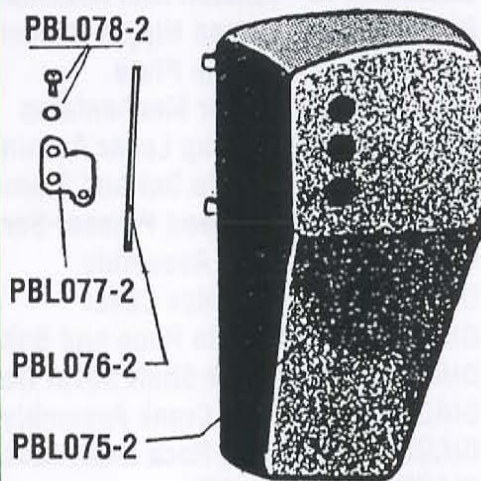


DIAGRAM 4

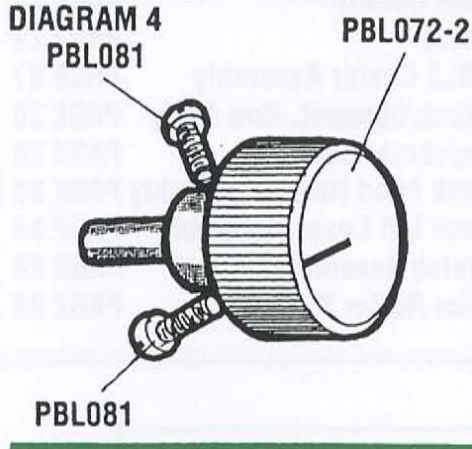


DIAGRAM 5

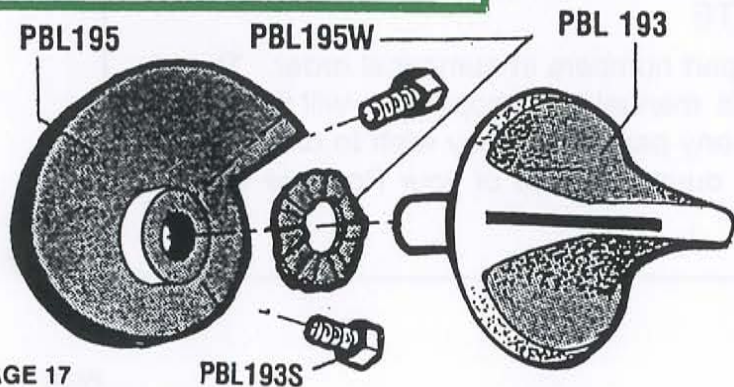
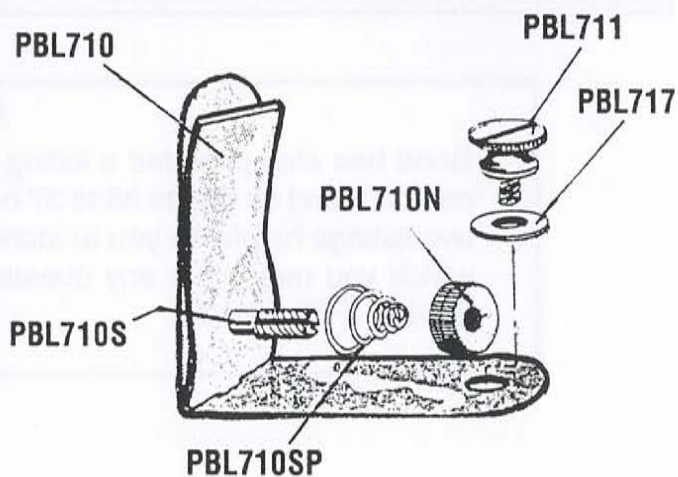


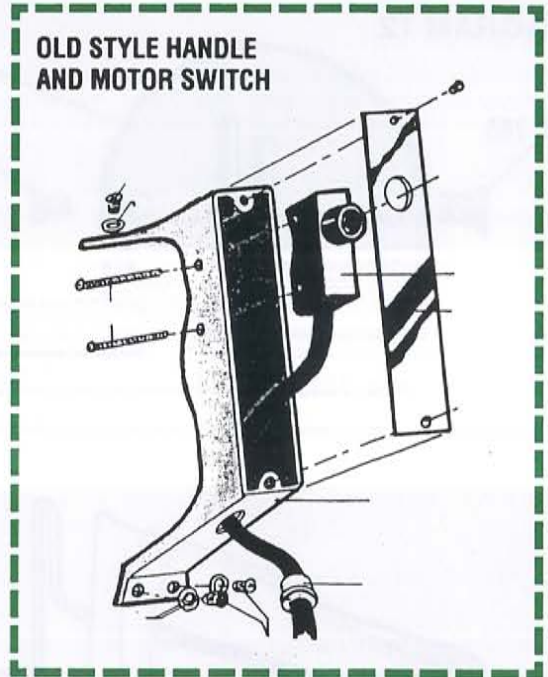
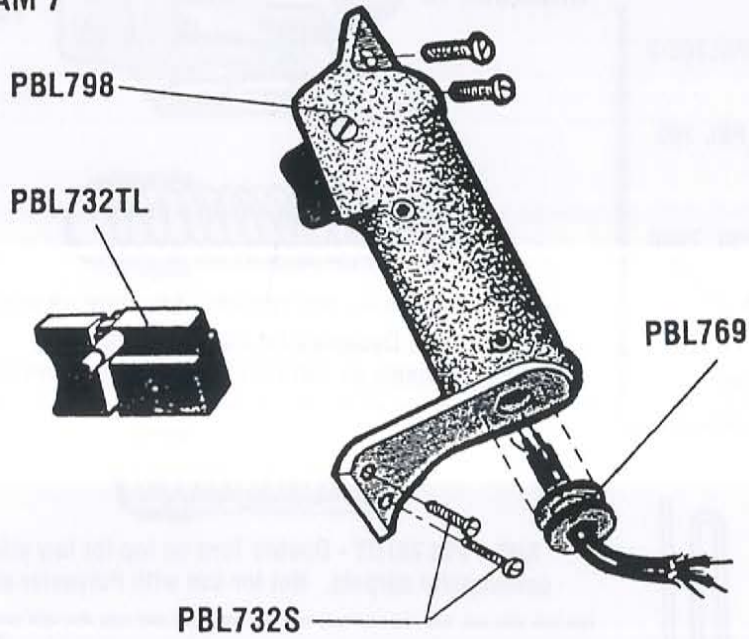
DIAGRAM 6



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PARTS DIAGRAMS - MAIN EXTERIOR

DIAGRAM 7



OLD STYLE HANDLE AND MOTOR SWITCH

DIAGRAM 8

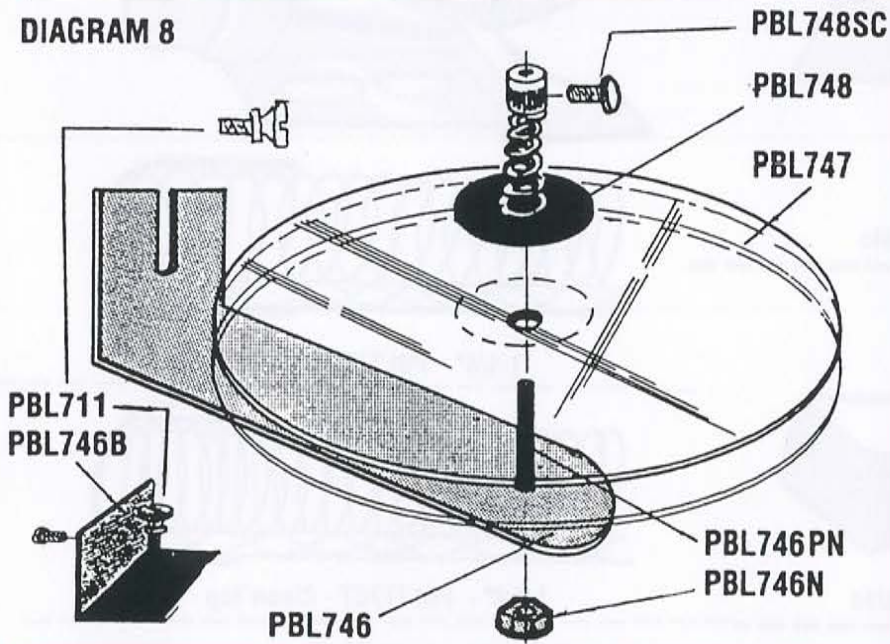


DIAGRAM 9

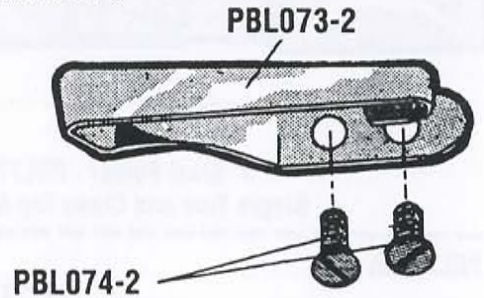


DIAGRAM 10

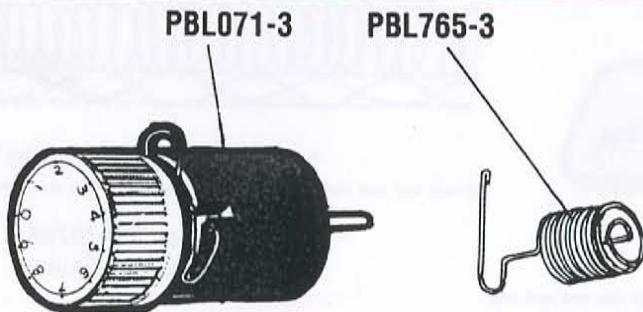
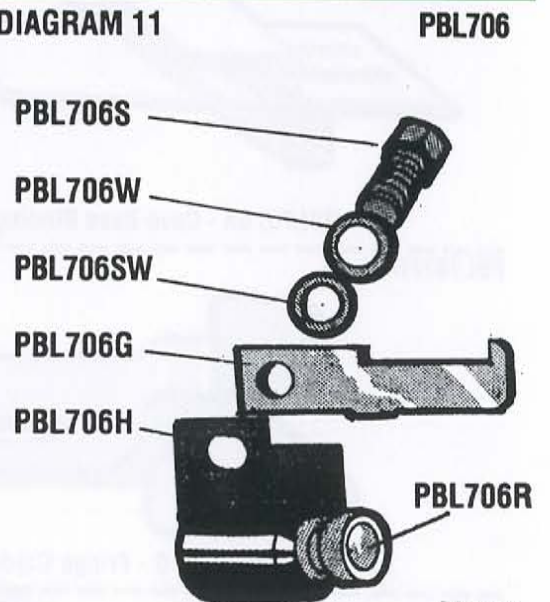


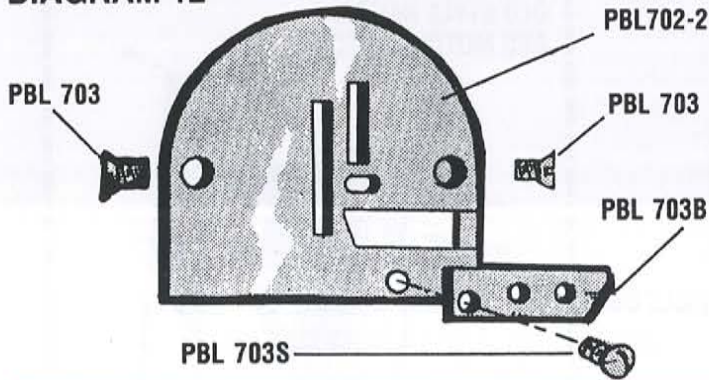
DIAGRAM 11



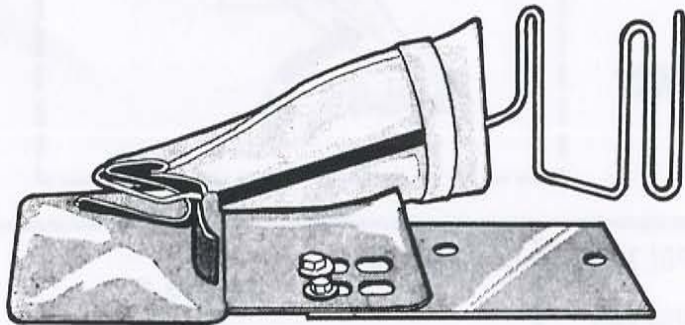
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PARTS DIAGRAMS - MAIN EXTERIOR

DIAGRAM 12

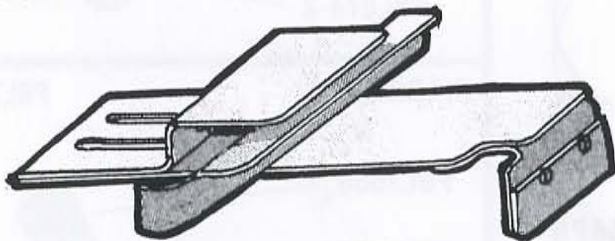


PBL778SF



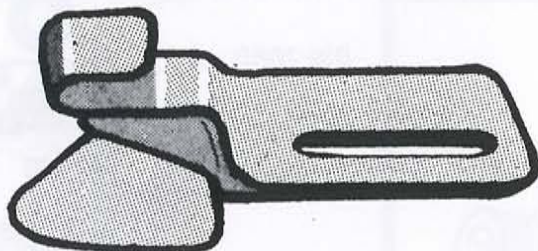
3" Sisal Folder - PBL778SF
Single Turn and Clean Top Available

PBL707BA



PBL707BA - Cove Base Binding Guide

PBL707FG

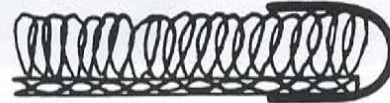


PBL707FG - Fringe Guide

DIAGRAM 13

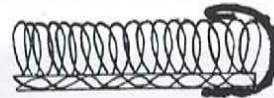


PBL707WM



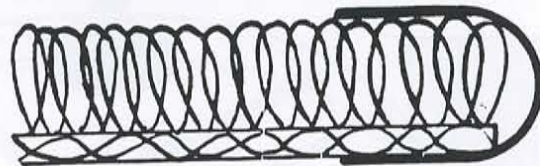
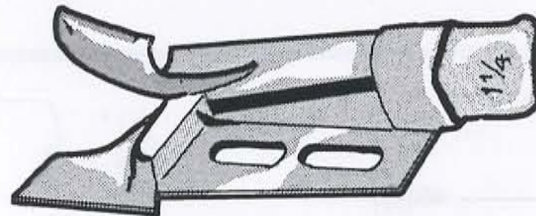
13/16" Single Turn - PBL707WM - Standard on your machine
Designed for Polyester binding
Also available as PBL707CT in 3/4" for cotton binding.

PBL707DT

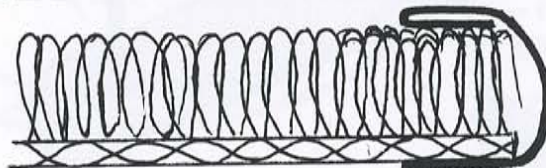


3/4" - PBL707DT - Double Turn on top for low pile and
commercial carpets. Not for use with Polyester binding

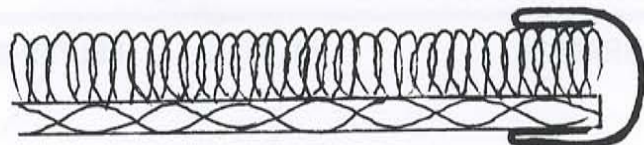
PBL777ST



1-1/4" - PBL777ST - Single Turn



1-1/4" - PBL777CT - Clean Top



1-1/4" - PBL777DT - Double Turn

Also Available: PBL707SB - 7/8"
Serging Tape Folder

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PARTS DIAGRAMS - LEFT SIDE HEAD INTERIOR

DIAGRAM 14

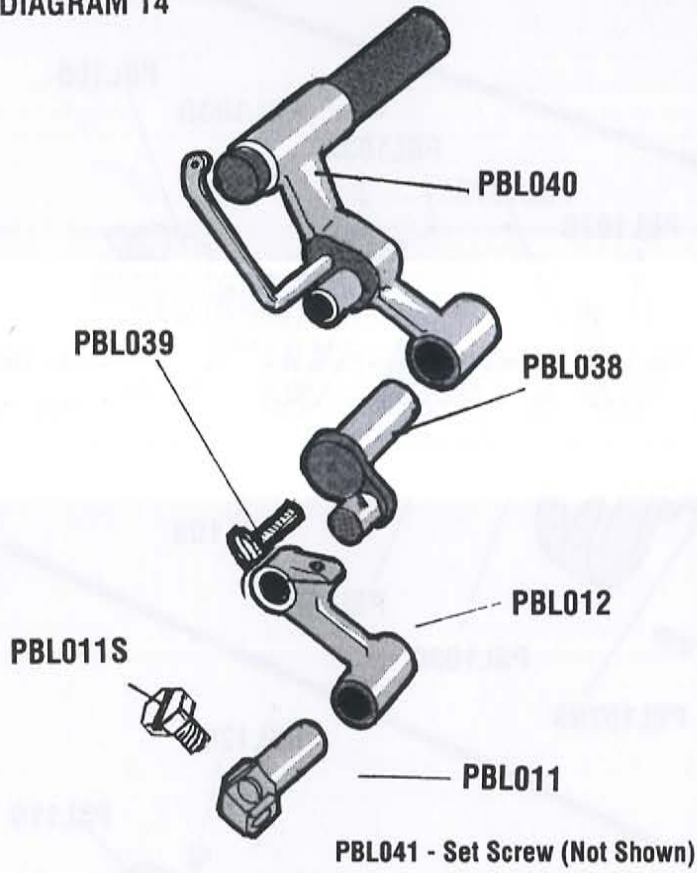


DIAGRAM 15

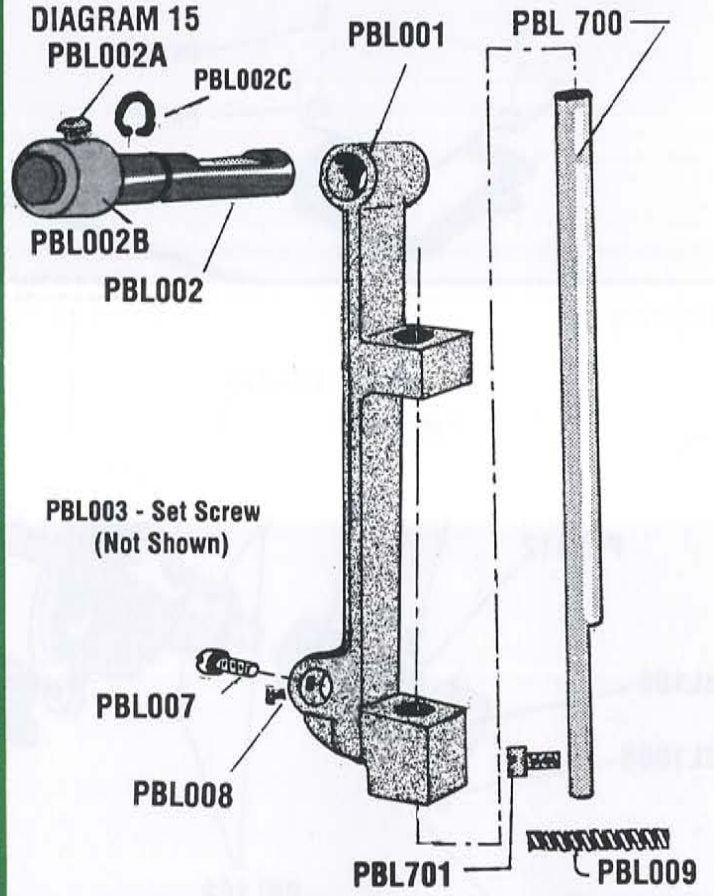


DIAGRAM 16

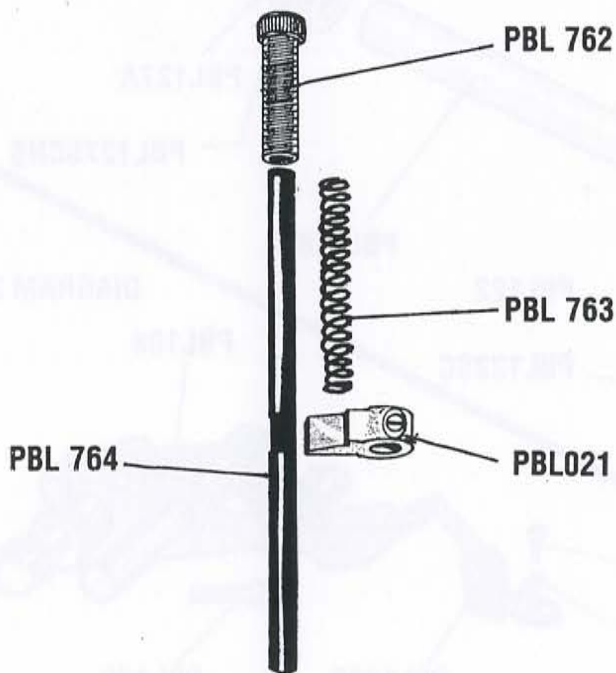
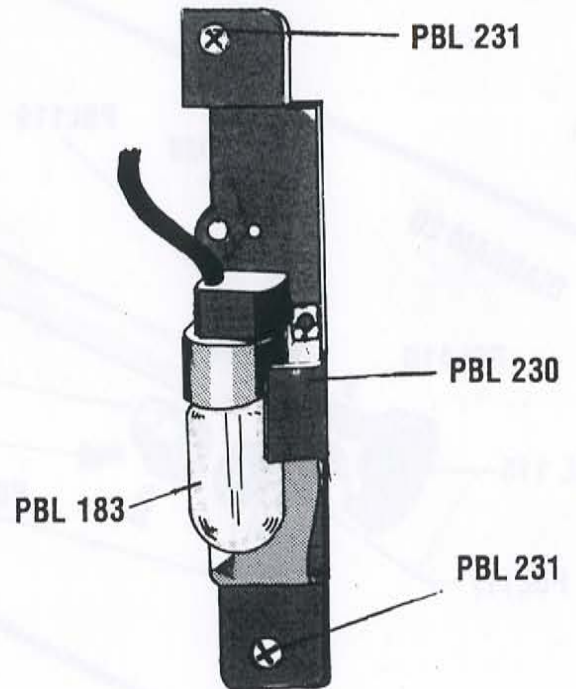


DIAGRAM 17



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DIAGRAM 18

PARTS DIAGRAMS - UNDERSIDE OF MACHINE

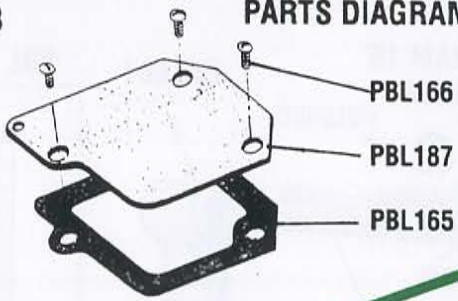


DIAGRAM 19

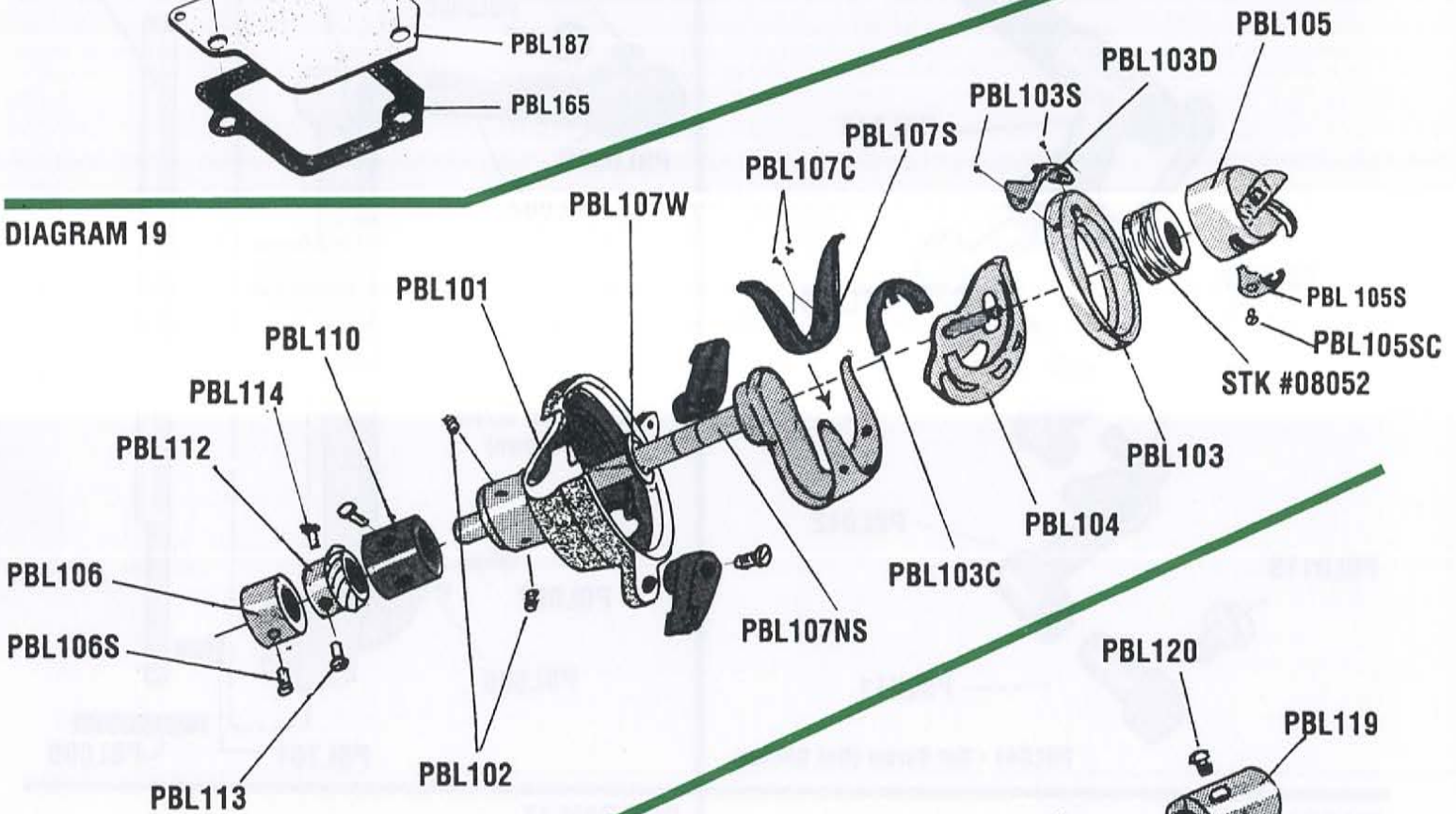


DIAGRAM 20

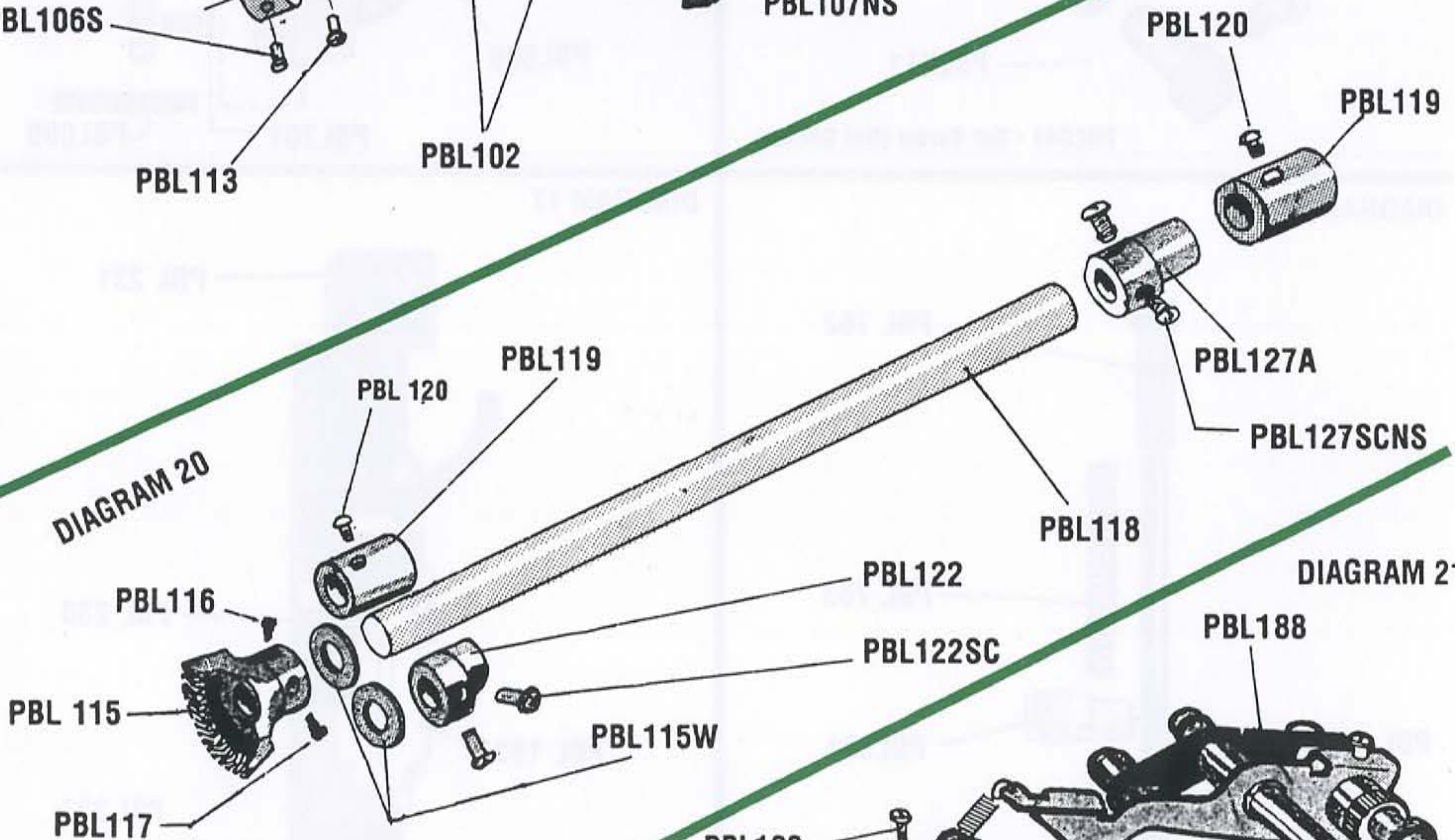
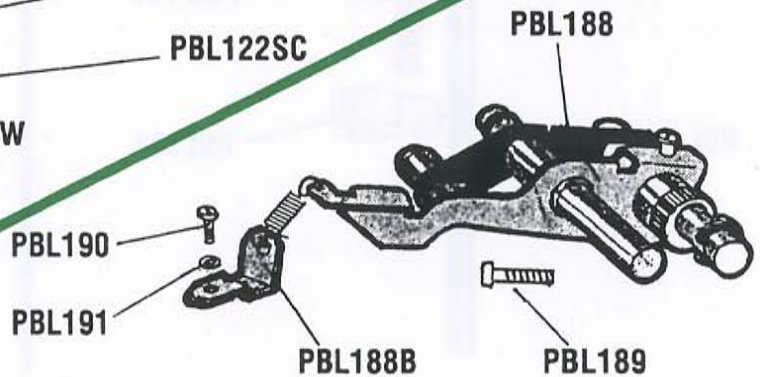


DIAGRAM 21



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PARTS DIAGRAMS - UNDERSIDE AND BACK OF MACHINE

DIAGRAM 22

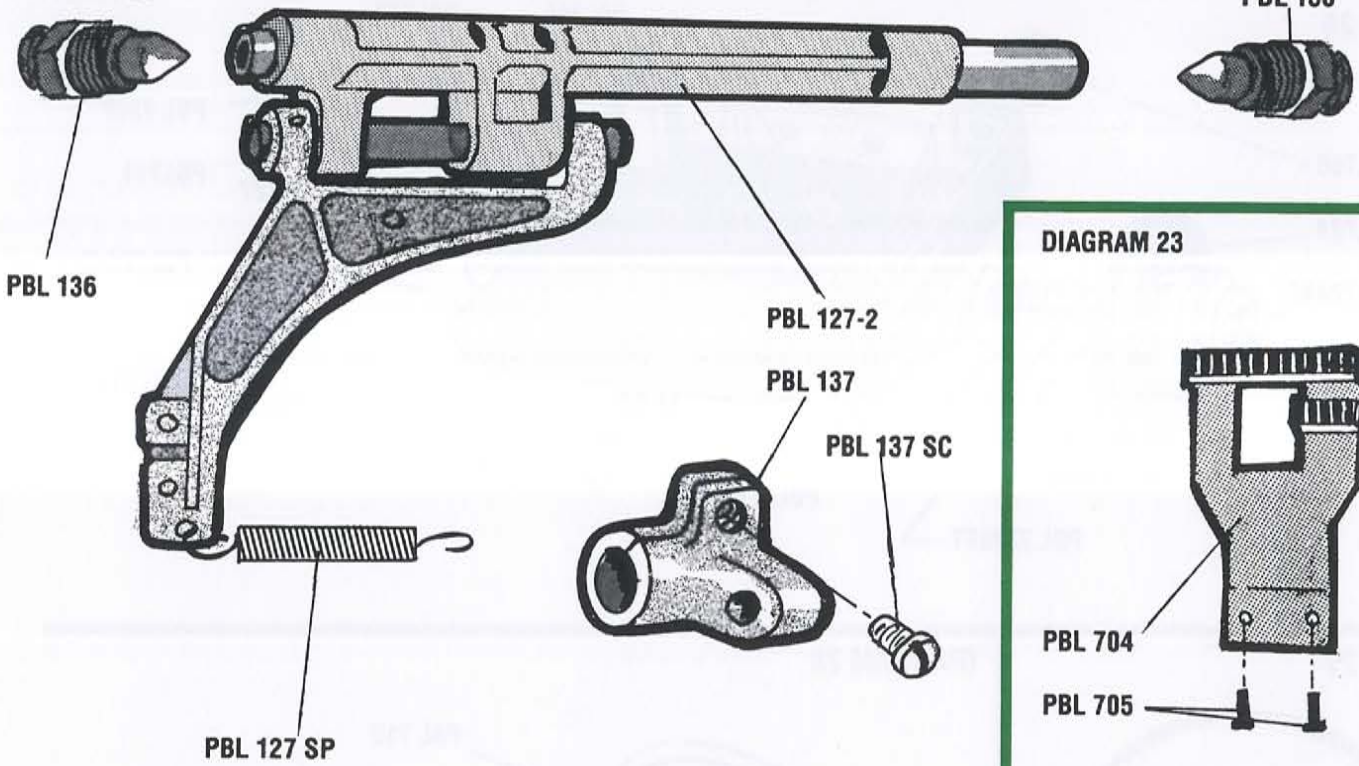


DIAGRAM 23

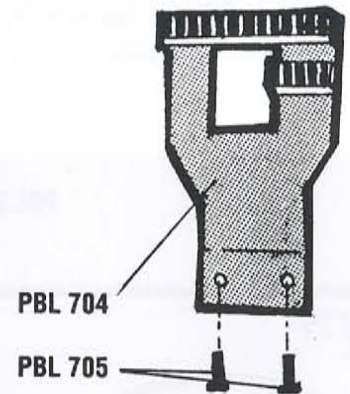


DIAGRAM 24

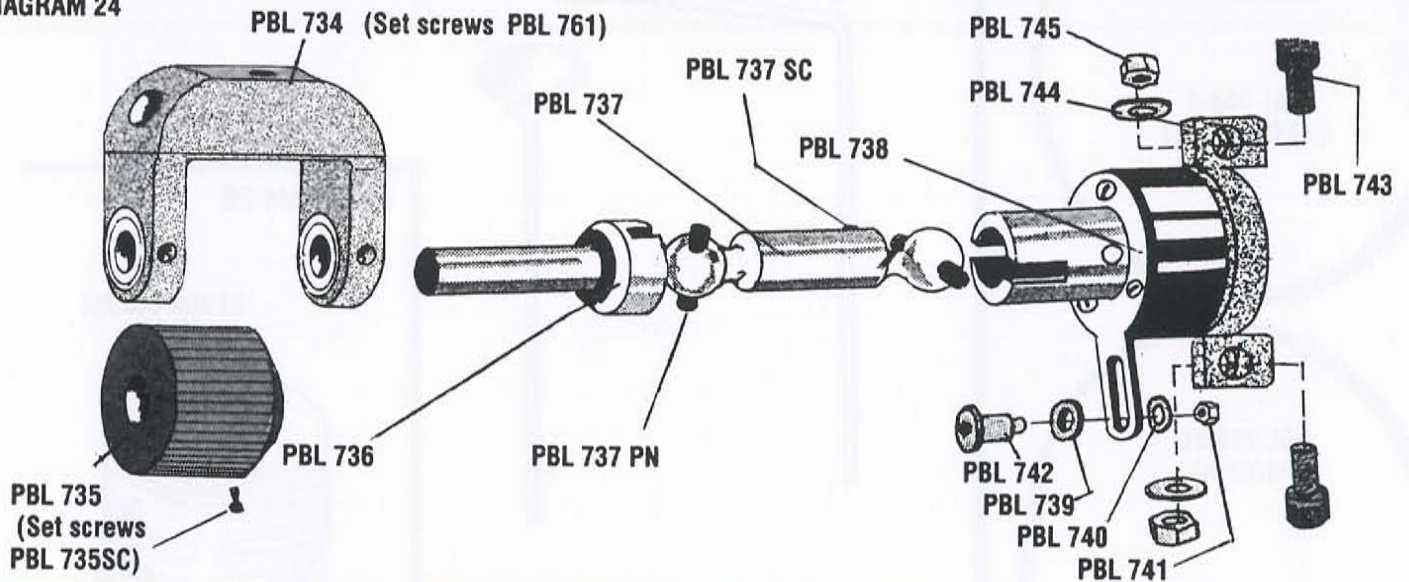
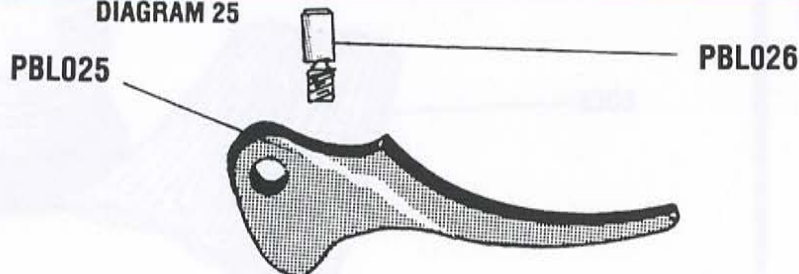


DIAGRAM 25



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PARTS DIAGRAMS - BACK OF MACHINE

DIAGRAM 26

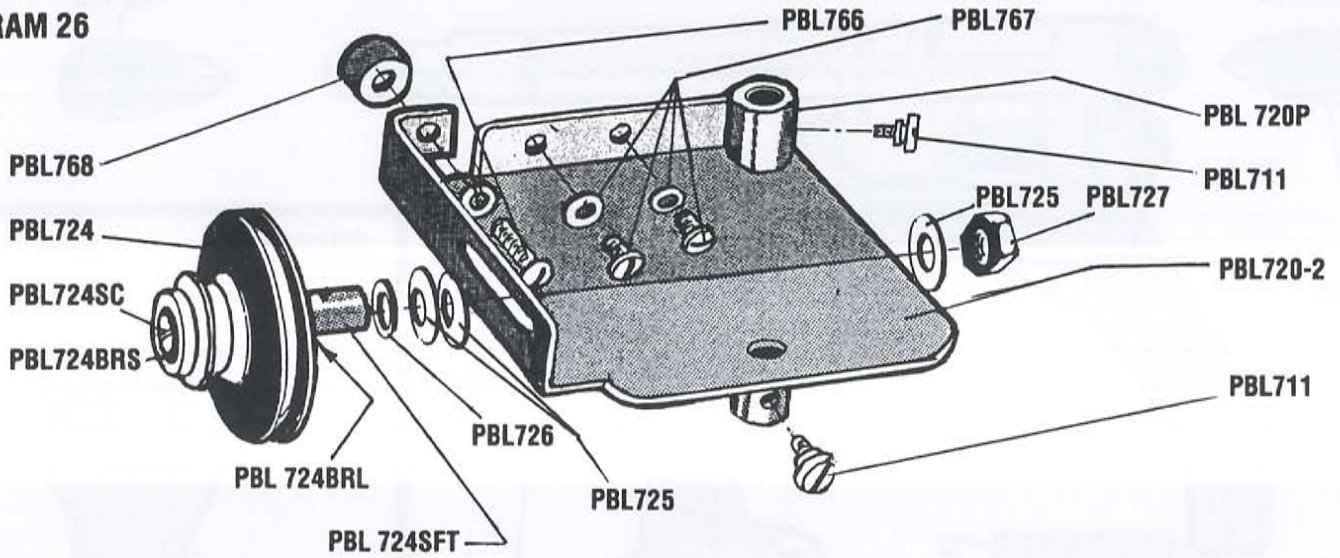


DIAGRAM 27

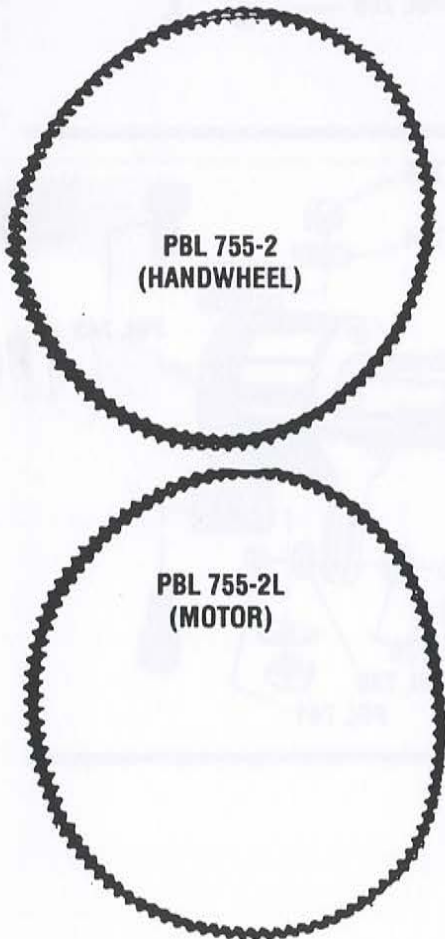
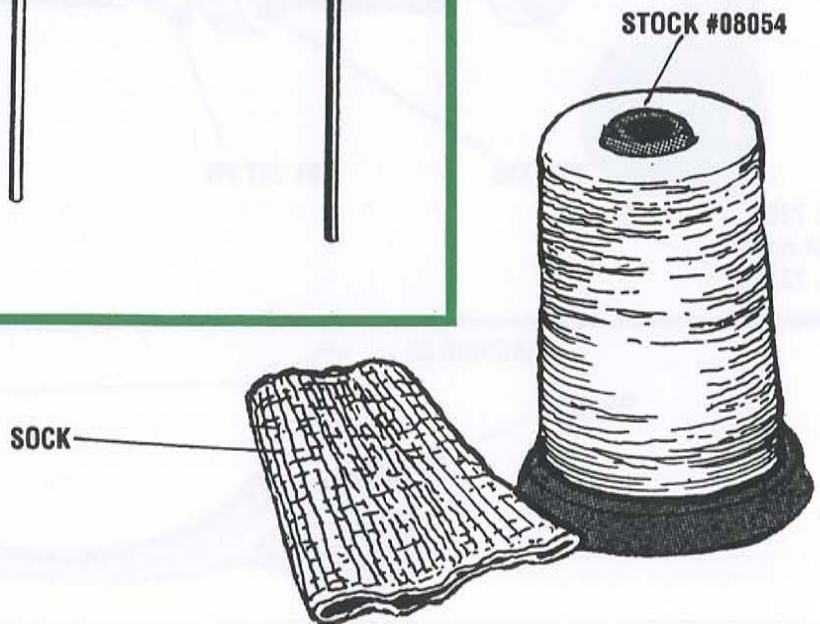


DIAGRAM 28



DIAGRAM 29



Our **BOND** is Your Guarantee!

PARTS DIAGRAMS - INTERIOR OF MACHINE

DIAGRAM 30

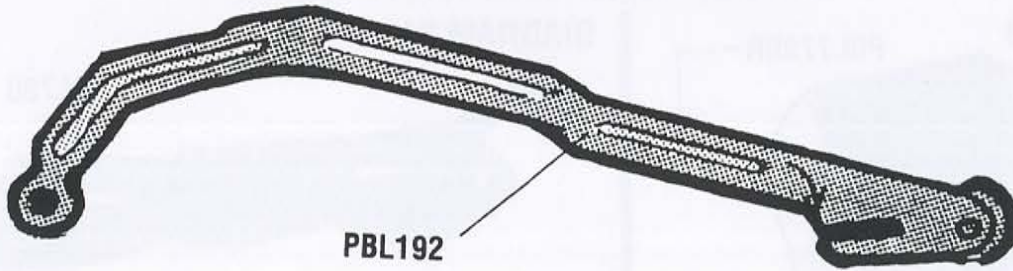


DIAGRAM 31

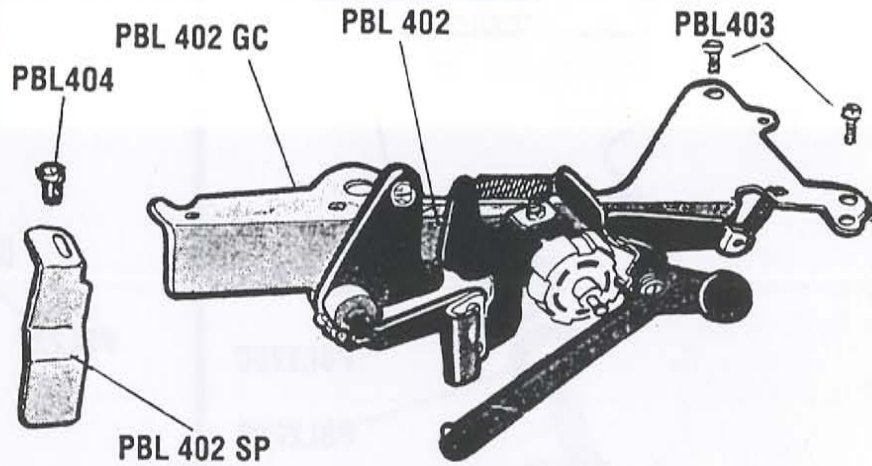
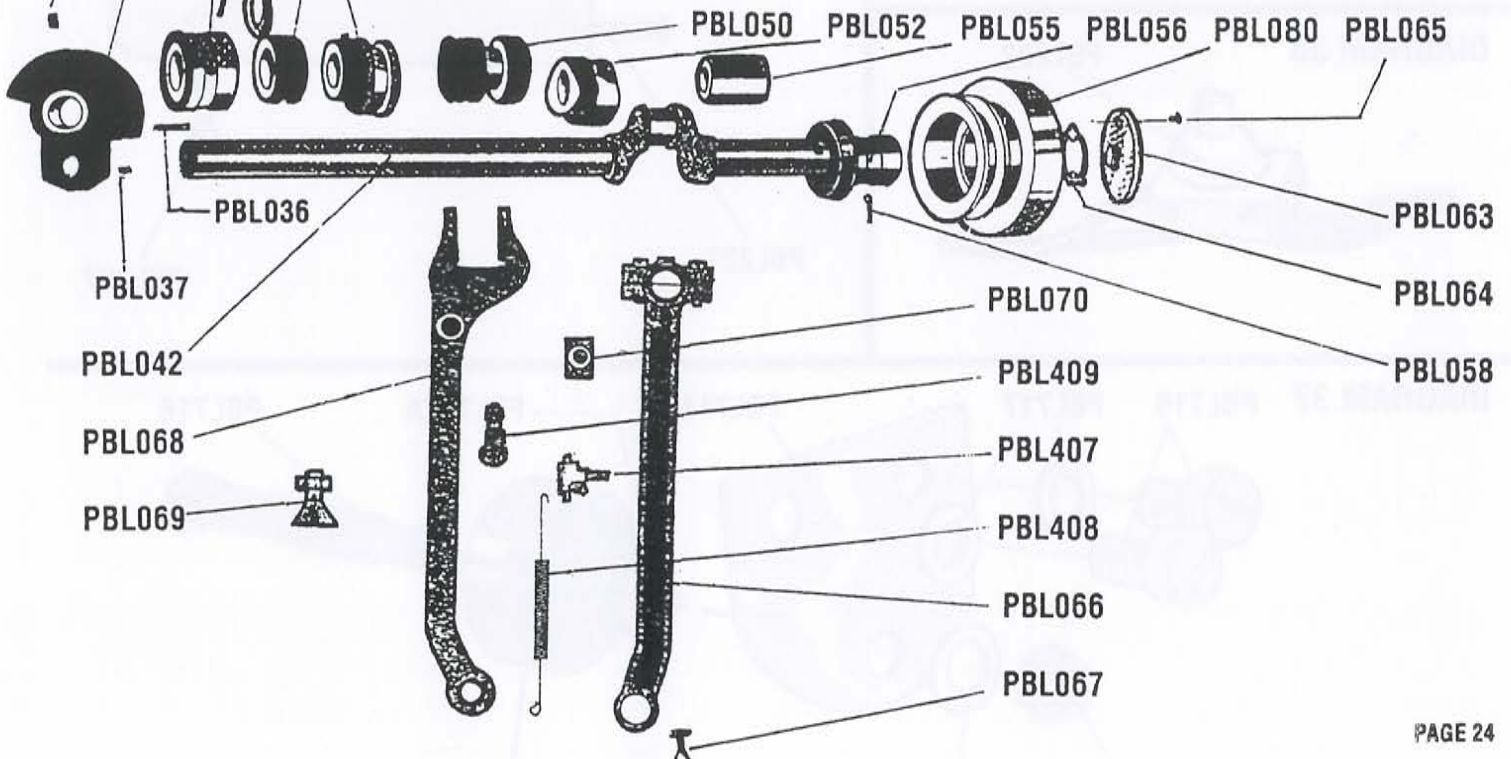


DIAGRAM 32



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PARTS DIAGRAMS - RIGHT SIDE OF MACHINE

DIAGRAM 33

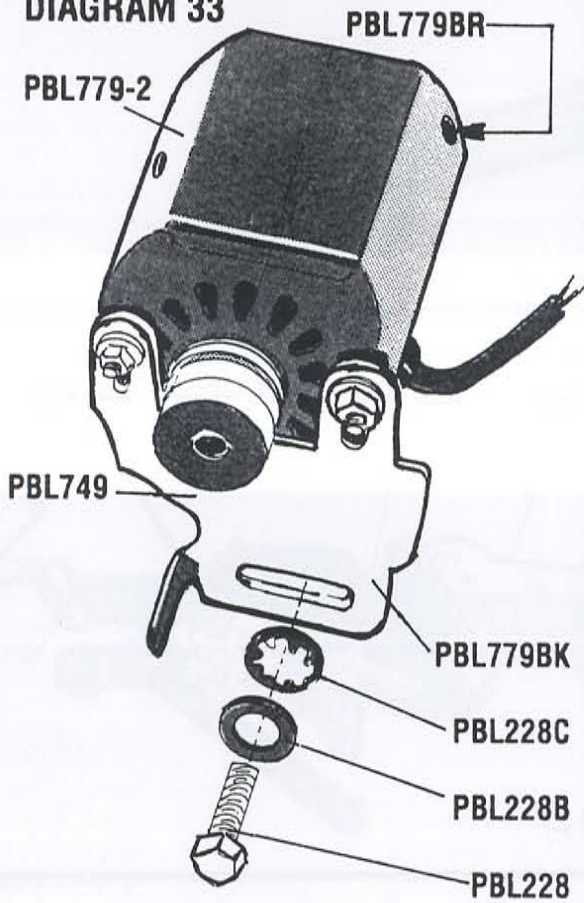


DIAGRAM 34

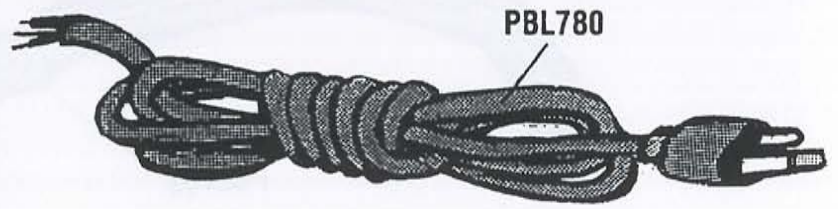


DIAGRAM 35

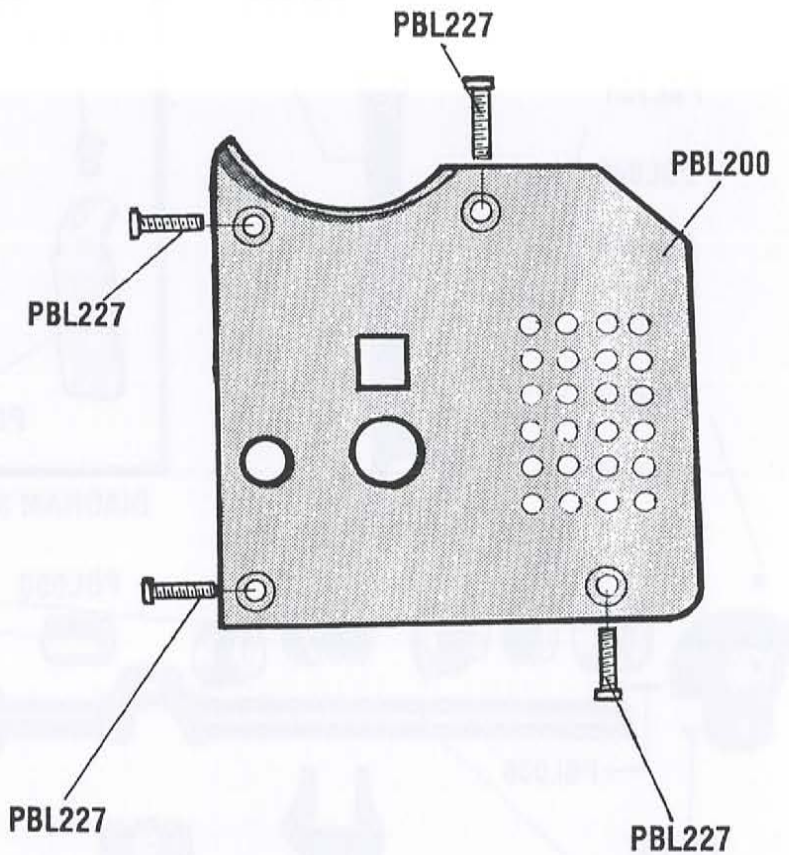


DIAGRAM 36

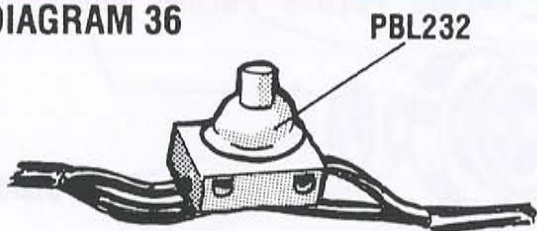
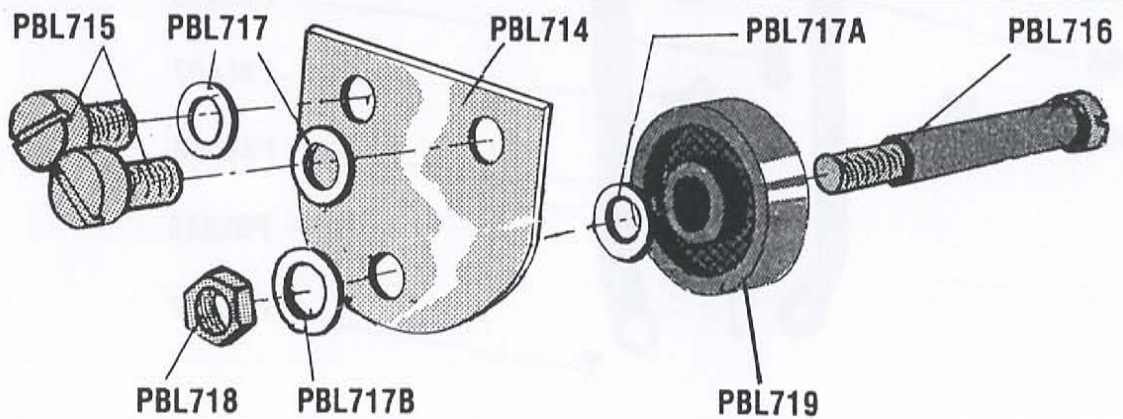


DIAGRAM 37



PARTS DIAGRAMS - CASTERS AND ACCESSORIES

DIAGRAM 38

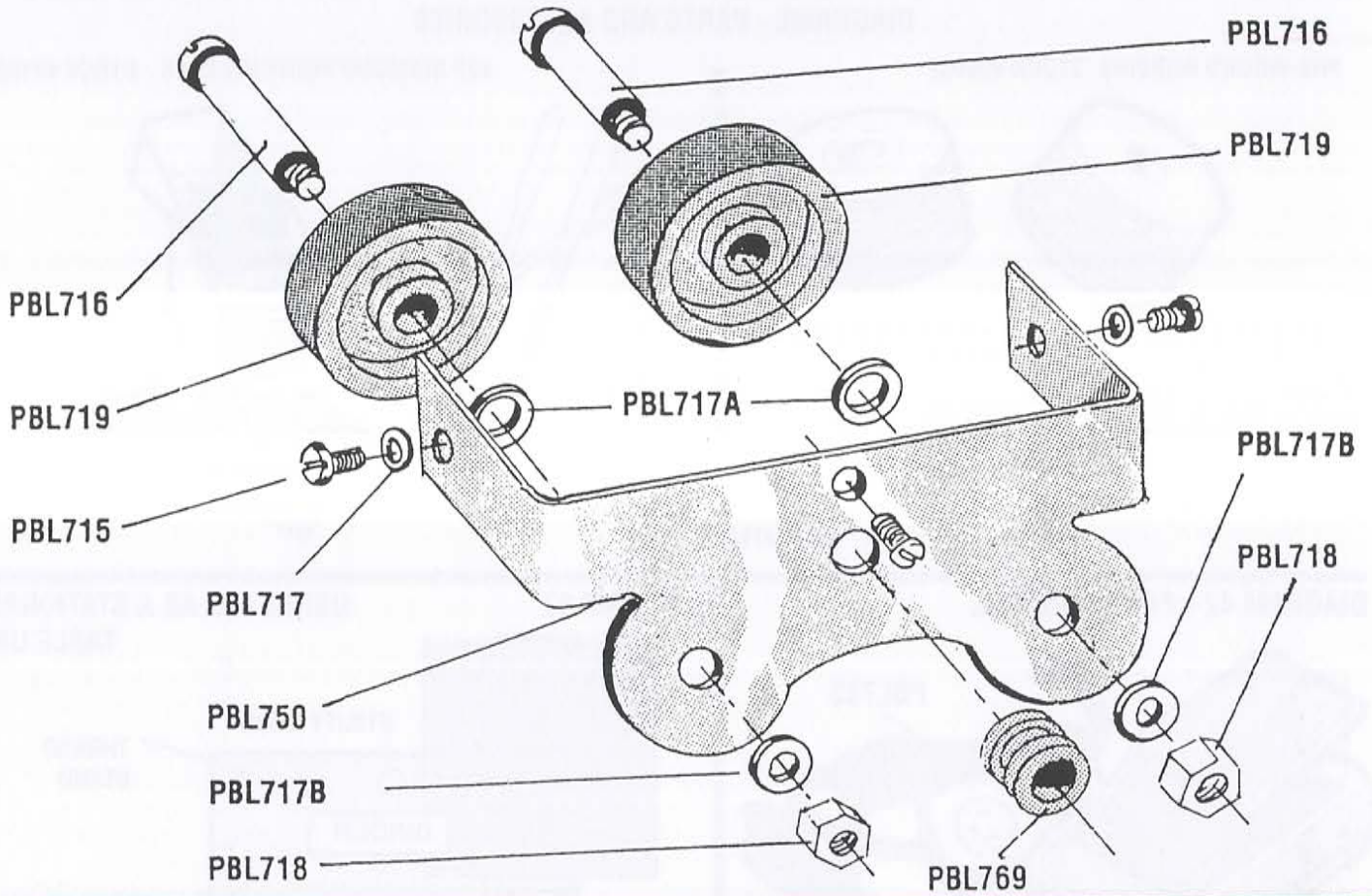


DIAGRAM 39

PBL781 - COMPLETE ACCESSORY SET

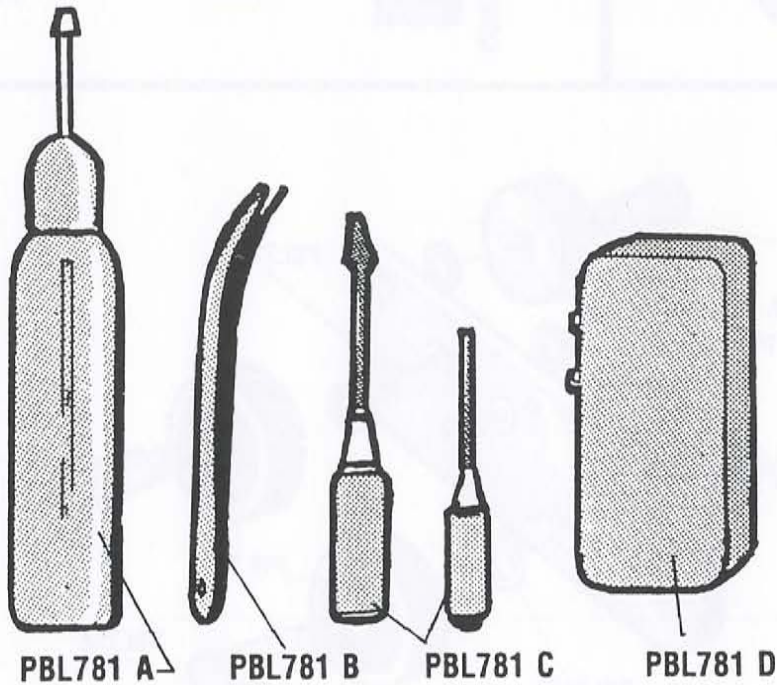
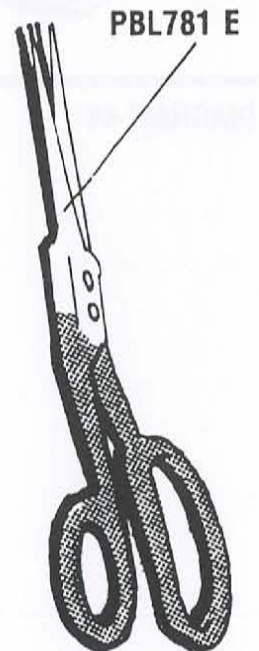


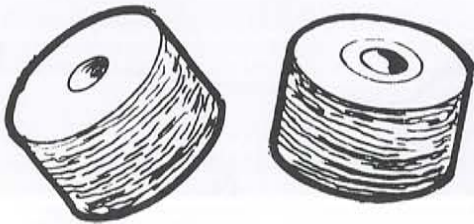
DIAGRAM 40



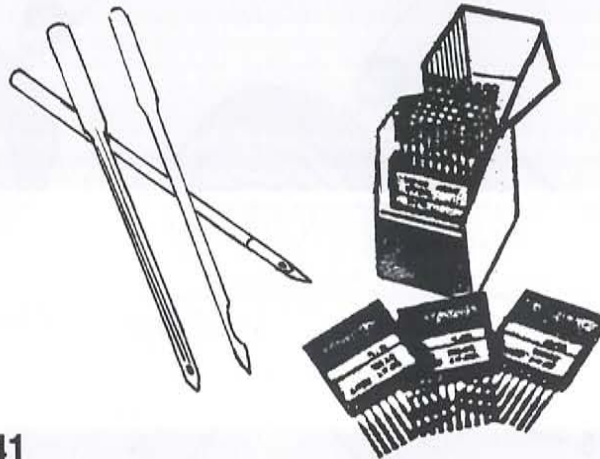
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DIAGRAMS - PARTS AND ACCESSORIES

PRE-WOUND BOBBINS STOCK #08052



#22 DIAMOND POINT NEEDLES - STOCK #21022



FEELER GAUGE

PBL782 (Optional)

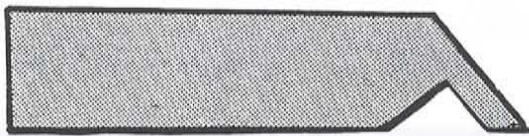


DIAGRAM 41

DIAGRAM 42 - FOOT CONTROL

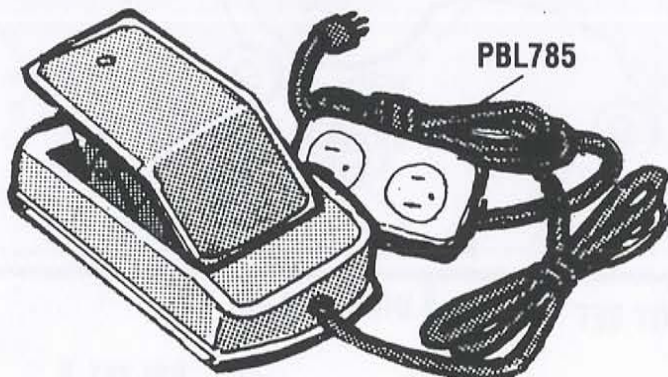


DIAGRAM 43

USING PBL AS A STATIONARY TABLE UNIT

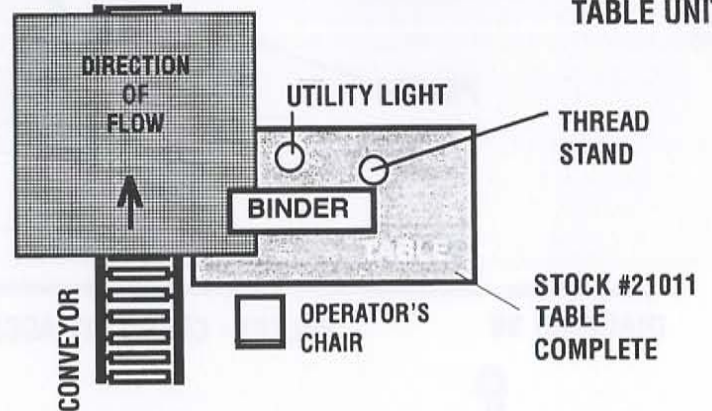
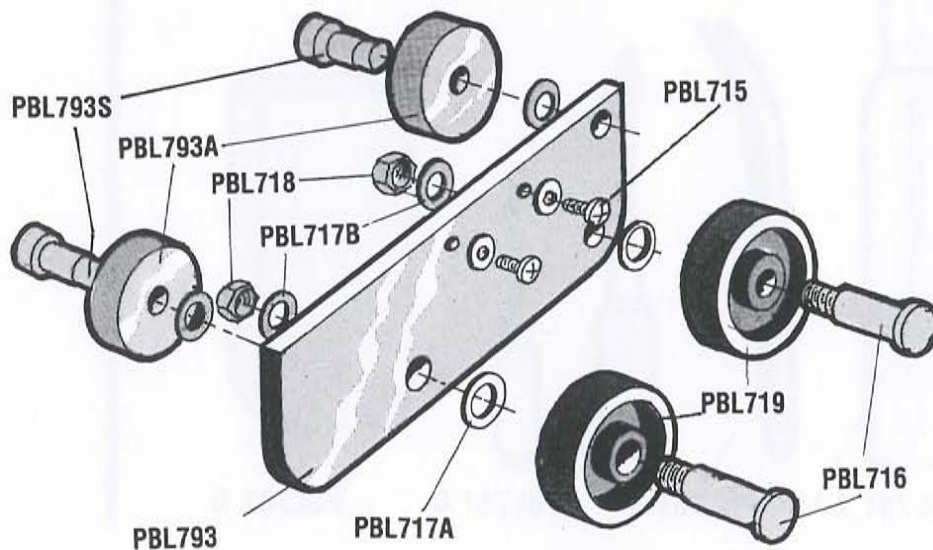


DIAGRAM 44



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DIAGRAMS OF PARTS FOR THE DOUBLE PULLER PBL MACHINE ONLY

DIAGRAM 45

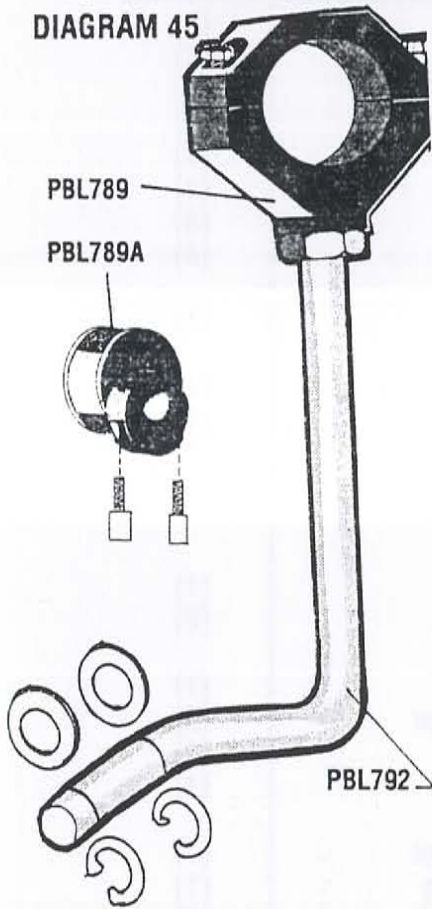


DIAGRAM 46

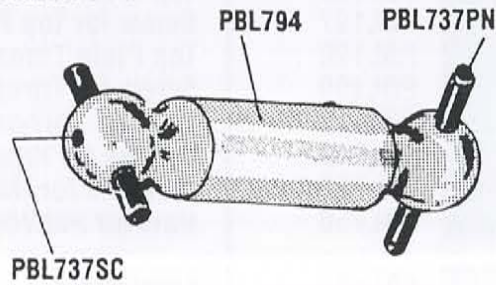


DIAGRAM 47

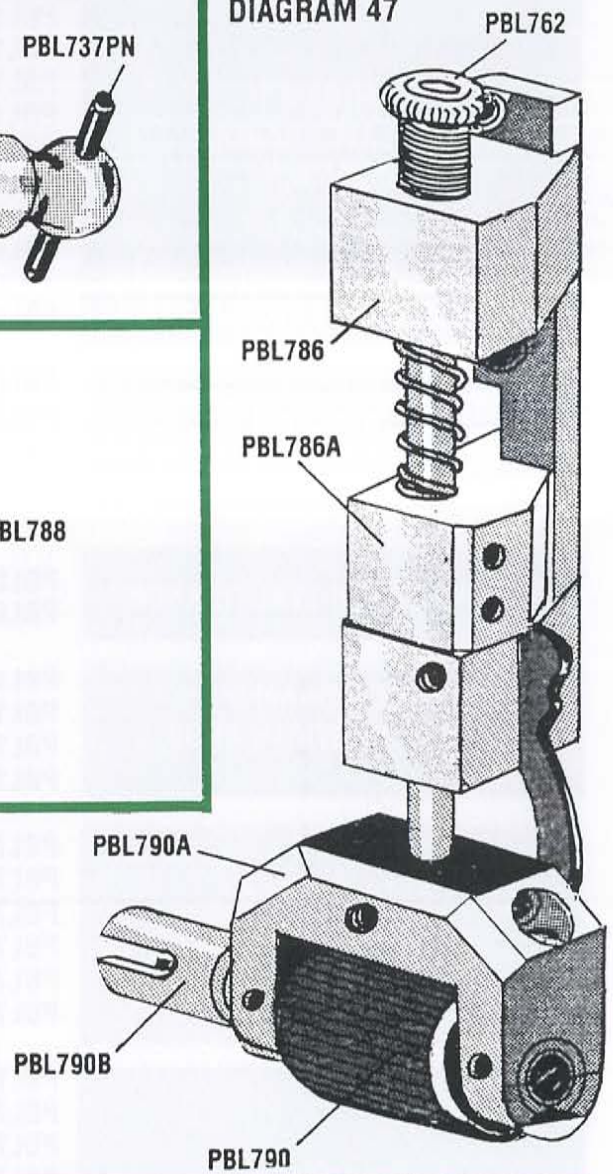


DIAGRAM 48

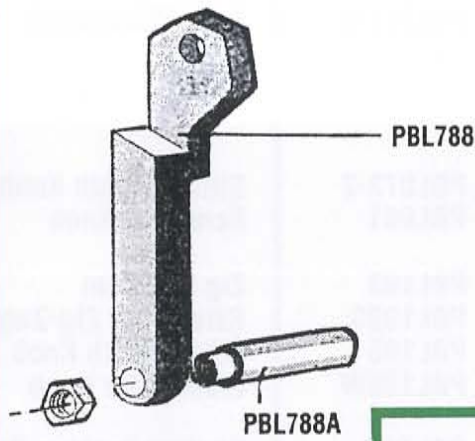


DIAGRAM 49

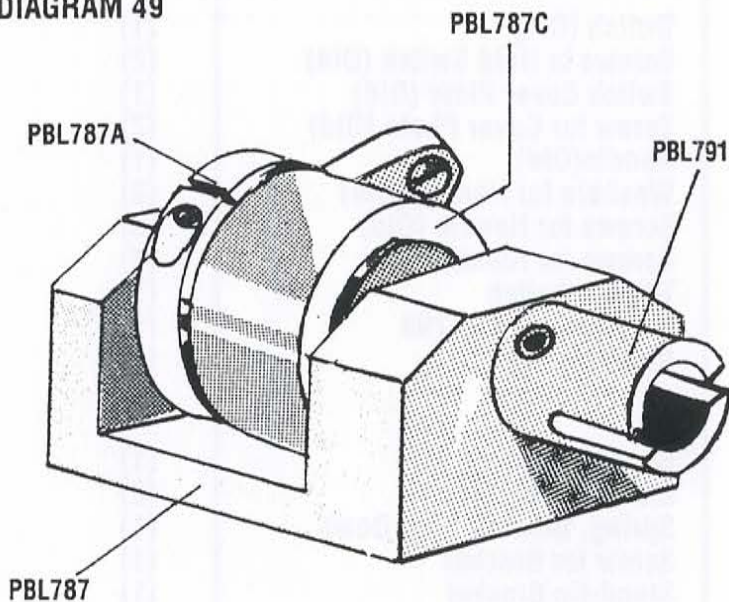
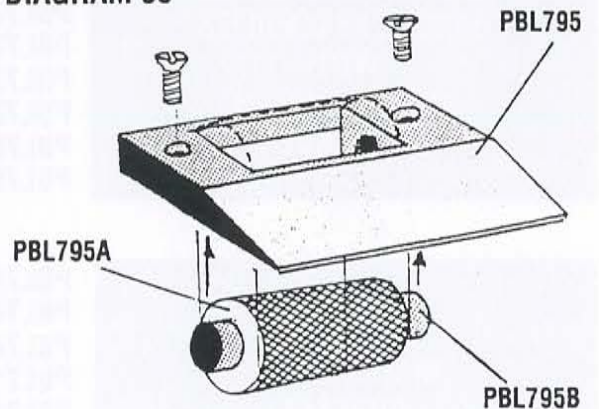


DIAGRAM 50



PBL787 - Clutch Drive Shaft (Not Shown)
 PBL787CS - Clutch Bearing (Small)(Not Shown)

PARTS LIST BY DIAGRAM NUMBERS

DIAGRAM NUMBER & ASS'Y	PART NO.	PART DESCRIPTION	QUAN.
DIAGRAM 1 TOP PLATE / HANDLE ASSEMBLY	PBL196	Top Plate	(1)
	PBL197	Screw for Top Plate	(2)
	PBL198	Top Plate Thread Guide	(1)
	PBL199	Screw for Thread Guide	(1)
	PBL753	Handle, Carrying	(1)
	PBL758	Screws for Handle	(4)
	PBL759	Washers for Handle	(4)
	PBL760	Nuts for PBL758	(4)
DIAGRAM 2 - FRONT PLATE	PBL401	Front Plate	(1)
DIAGRAM 3 FACE PLATE ASSEMBLY	PBL076-2	Face Plate Hinge Pin	(1)
	PBL077-2	Face Plate Hinge	(1)
	PBL078-2	Screw & Washer for Hinge	(1)
	PBL075-2	Face Plate	(1)
DIA. 4 - STITCH LENGTH KNOB	PBL072-2	Stitch Length Knob	(1)
	PBL081	Screw for Knob	(2)
DIAGRAM 5 STITCH WIDTH KNOB	PBL193	Zig Zag Cam	(1)
	PBL193S	Screws for Zig-Zag Cam	(2)
	PBL195	Stitch Width Knob	(1)
	PBL195W	Washer for Knob	(1)
DIAGRAM 6 BINDER TENSION ASSEMBLY	PBL710	Binding Tension Bracket	(1)
	PBL710SP	Binding Tension Spring	(1)
	PBL710N	Knurled Nut	(1)
	PBL710S	Screw, Shaft	(1)
	PBL711	Screw & Washer for PBL710	(1)
	PBL717	Washer for PBL710	(1)
DIAGRAM 7 OLD AND NEW STYLE HANDLE ASSEMBLIES WITH MOTOR SWITCH OR TRIGGER	PBL728	Switch (Old)	(1)
	PBL729	Screws to Hold Switch (Old)	(2)
	PBL730	Switch Cover Plate (Old)	(1)
	PBL731	Screw for Cover Plate (Old)	(2)
	PBL732	Handle (Old)	(1)
	PBL732W	Washers for Handle (Old)	(3)
	PBL732SC	Screws for Handle (Old)	(3)
	PBL732S	Screws for Handle-New	(4)
	PBL732TL	Trigger Switch	(1)
	PBL769	Grommet for PBL798	(1)
	PBL798	New Handle	(1)
DIAGRAM 8 BINDING TAPE BRACKET	PBL746	Binding Bracket	(1)
	PBL747	Binding Tape Disc	(2)
	PBL748	Spring, Binding Hold Down	(1)
	PBL711	Screw for Bracket	(1)
	PBL746B	Stand-Up Bracket	(1)
	PBL746N	Nut for PBL746	(1)
	PBL746PN	Pin for PBL746	(1)
PBL748SC	Screw for Spring	(1)	

PARTS LIST BY DIAGRAM NUMBERS

DIAGRAM NUMBER & ASS'Y	PART NO.	PART DESCRIPTION	QUAN.
DIA. 9 - THREAD GUIDE	PBL073-2	Thread Guide	(1)
	PBL074-2	Mounting Screws	(2)
DIA. 10 - TENSION DIAL ASS'Y	PBL071-3	Tension Dial Assembly	(1)
	PBL765-3	Check Spring - 3/8" Coil	(1)
DIAGRAM 11 NIPPER ASSEMBLY	PBL706	Nipper Assembly	(1)
	PBL706R	Thread Retainer Guide	(1)
	PBL706H	Nipper Housing	(1)
	PBL706G	Guide for PBL706	(1)
	PBL706S	Screw, Mounting	(1)
	PBL706SW	Spur Washer	(1)
	PBL706W	Washer	(1)
DIAGRAM 12 NEEDLE PLATE ASSEMBLY	PBL702-2	Needle Plate	(1)
	PBL703	Needle Plate Screws	(2)
	PBL703B	Binder Bracket Extension	(1)
	PBL703S	Screw for PBL703B	(1)
DIAGRAM 13 BINDER ASSEMBLY	PBL778SF	3" Sisal Folder - Single & Clean Top	(1)
	PBL707BA	Cove Base Binding Guide	(1)
	PBL707FG	Fringe Guide	(1)
	PBL707WM	13/16" Single Turn - for Polyester	(1)
	PBL707CT	3/4" Single Turn - for Cotton	(1)
	PBL707DT	3/4" Double Turn - for Cotton	(1)
	PBL777ST	1-1/4" Single Turn Folder	(1)
	PBL777CT	1-1/4" Clean Top Folder	(1)
	PBL777DT	1-1/4" Double Turn Folder	(1)
PBL707SB	7/8" Serging Tape Folder	(1)	
DIAGRAM 14 NEEDLE BAR & TAKE-UP LEVER	PBL011	Needle Bar Connecting Stud/Screw	(1)
	PBL011S	Needle Bar Screw	(1)
	PBL012	Needle Bar Connecting Link/Screw	(1)
	PBL038	Take-Up Lever Crank	(1)
	PBL039	Shoulder Screw	(1)
	PBL040	Take-Up Lever	(1)
	PBL041	Set Screw (Not Shown)	(1)
DIAGRAM 15 NEEDLE BAR DRIVE FRAME ASSEMBLY	PBL001	Presser Bar Spring Bracket	(1)
	PBL002	Top Feed Presser Bar Thumb Screw	(1)
	PBL002A	Screw for PBL002	(1)
	PBL002B	Bushing for PBL002	(1)
	PBL002C	Retaining Clip for PBL002A	(1)
	PBL003C	Set Screw (Not Shown)	(1)
	PBL007	Adjust. Eccentric Clip for PBL001	(1)
	PBL008	Set Screw for PBL007	(1)
	PBL009	Zigzag Drive Crank Spring	(1)
	PBL700	Needle Bar	(1)
PBL701	Needle Screw	(1)	
DIAGRAM 16 TOP FEED PRESSER BAR ASSEMBLY	PBL021	Presser Bar Spring Bracket/Screw	(1)
	PBL762	Top Feed Presser Bar Thumb Screw	(1)
	PBL763	Top Feed Presser Bar Spring	(1)
	PBL764	Top Feed Presser Bar	(1)
DIAGRAM 17 SEWING LIGHT ASSEMBLY	PBL183	Light Bulb	(1)
	PBL230	Sewing Light Assembly	(1)
	PBL231	Screws for Sewing Light	(2)

PARTS LIST BY DIAGRAM NUMBERS

DIAGRAM NUMBER & ASS'Y	PART NO.	DESCRIPTION	QUAN.
DIAGRAM 18 GEAR BOX COVER ASSEMBLY	PBL165	Gasket, Gear Box	(1)
	PBL166	Set Screws for PBL187	(3)
	PBL187	Gear Box Cover	(1)
DIAGRAM 19 SHUTTLE SHAFT DRIVE ASSEMBLY	PBL101	Shuttle Race (New Style)	(1)
	PBL102	Set Screw for PBL101	(1)
	PBL103C	Shuttle Race Cleaner	(1)
	PBL103D	Race Ring Cover	(1)
	PBL103	Retainer Ring with Screws	(1)
	PBL103S	Set Screw for PBL103	(2)
	PBL104	Shuttle Hook	(1)
	PBL105	Bobbin Case	(1)
	PBL105S	Bobbin Case Spring	(1)
	PBL105SC	Adjusting Screw for PBL105	(1)
	PBL106	Shuttle Driver Shaft Bushing	(1)
	PBL106S	Screw for PBL106	(1)
	PBL107C	Set Screw for PBL107	(2)
	PBL107NS	Shuttle Driver Assembly	(1)
	PBL107S	Driver Spring	(1)
	PBL107W	Thrust Washer for PBL107	(1)
PBL110	Shuttle Drive Shaft Collar	(1)	
PBL112	Shuttle Drive Bevel Gear	(1)	
PBL113	Set Screw - Pointed for PBL112	(1)	
PBL114	Set Screw - Flat for PBL112	(1)	
	08052	"A"Style Prewound Bobbin	(1)
DIAGRAM 20 LOWER SHAFT GEAR AND CRANK ASSEMBLY	PBL115	Lower Shaft Bevel Gear	(1)
	PBL115W	Nylon Washer	(2)
	PBL116	Set Screw Pointed for PBL115	(1)
	PBL117	Screw (Flat) for PBL115	(1)
	PBL118	Lower Shaft	(1)
	PBL119	Lower Shaft Bushing	(2)
	PBL120	Set Screw for PBL119	(2)
	PBL122	Lower Shaft Cam	(1)
	PBL122SC	Screws	(2)
	PBL127A	Lower Shaft Crank	(1)
PBL127SCNS	Screws	(2)	
DIAGRAM 21 FEED CRANK ASSEMBLY	PBL188	Feed Crank Assembly	(1)
	PBL188B	Spring Bracket	(1)
	PBL189	Set Screw (Long)	(1)
	PBL190	Set Screw (Short)	(1)
	PBL191	Star Washer for PBL190	(1)
DIAGRAM 22 FEED ROCK SHAFT ASSEMBLY	PBL127-2	Feed Rock Shaft Assembly	(1)
	PBL127SP	Spring for PBL127-2	(1)
	PBL136	Screw Center with Nut	(2)
	PBL137	Feed Bar Shaft Crank	(1)
	PBL137SC	Set Screw for PBL137	(1)
DIA. 23 - FEED DOG ASSEMBLY	PBL704	Feed Dog	(1)
	PBL705	Screws for Feed Dog	(2)

PARTS LIST BY DIAGRAM NUMBERS

DIAGRAM NUMBER & ASS'Y	PART NO.	DESCRIPTION	QUAN.
DIAGRAM 24 TOP ROLLER FRAME AND CLUTCH DRIVE	PBL734	Top Roller Feed Frame	(1)
	PBL735	Top Roller Feed	(1)
	PBL735SC	Screw for Top Roller Feed	(2)
	PBL736	Top Roller Feed Axle	(1)
	PBL737	Top Feed Universal Drive Complete	(1)
	PBL737PN	Pin for PBL737	(2)
	PBL737SC	Screw for PBL737	(1)
	PBL738	Top Feed Clutch Drive	(1)
	PBL739	Thrust Washer for PBL742	(1)
	PBL740	Washer for PBL742	(1)
	PBL741	Nut for PBL742	(1)
	PBL742	Hinge Stud Screw	(1)
	PBL743	Mounting Screw	(2)
	PBL744	Washer for PBL743	(2)
	PBL745	Nut for PBL743	(2)
	DIA. 25 - PRESSER LIFTER	PBL025	Presser Lifter
	PBL026	Presser Bar Lift Hinge Stud	(1)
DIAGRAM 26 MOTOR AND THREAD BRACKET ASSEMBLY	PBL711	Screw & Washer	(2)
	PBL720-2	Motor & Thread Bracket	(1)
	PBL720P	Retaining Post	(2)
	PBL724	Belt Idler Pulley	(1)
	PBL724SC	Screw for PBL724	(1)
	PBL724BRS	Bearing (Small)	(1)
	PBL724BRL	Bearing (Large)	(1)
	PBL724SFT	Shaft for PBL724	(1)
	PBL725	Thrust Washer for PBL724	(1)
	PBL726	Washer for PBL724	(1)
	PBL727	Nut for PBL724	(1)
	PBL766	Screw for PBL720-2	(1)
	PBL767	Screw for PBL720-2	(2)
PBL768	Spacer for PBL766 Screw	(1)	
DIA. 27-DRIVE BELTS	PBL755-2	Machine Belt	(1)
	PBL755-2L	Motor Belt	(1)
DIA. 28 - THREAD GUIDES	PBL712	Thread Tube	(1)
	PBL713	Thread Tube Holder	(1)
DIA. 29 - THREAD & SOCK	08054	Size 52 Clear Thread	(1)
	PBL000	Sock	(1)
DIA. 30 - ZIGZAG DRIVE CRANK	PBL192	Zigzag Drive Crank	(1)
DIAGRAM 31 UNIT FRAME ASSEMBLY	PBL402	Unit Frame Assembly	(1)
	PBL402GC	Cam Gear (Only)	(1)
	PBL402SP	Spring for Cam Gear (Only)	(1)
	PBL403	Set Screw for PBL402 (Short)	(2)
	PBL404	Set Screw for PBL402 (Long)	(1)

PARTS LIST BY DIAGRAM NUMBERS

DIAGRAM NUMBER & ASS'Y	PART NO.	DESCRIPTION	QUAN.
DIAGRAM 32 HAND WHEEL AND MAIN SHAFT ASSEMBLY	PBL034	Arm Shaft Crank	(1)
	PBL035	Set Screw for PBL34	(1)
	PBL036	Spring Pin for PBL34	(1)
	PBL037	Set Screw for PBL38	(1)
	PBL042	Arm Shaft	(1)
	PBL043	Arm Shaft Front Bushing	(1)
	PBL044	Set Screw for PBL43	(1)
	PBL045	Arm Shaft Collar w/Hardware	(1)
	PBL050	Worm Gear w/Screw	(1)
	PBL052	Feed Cam w/Screw	(1)
	PBL055	Arm Shaft Back Bushing	(1)
	PBL056	Hand Wheel Bushing w/Screw	(1)
	PBL058	Spring Pin for PBL56	(1)
	PBL063	Stop Motion Knob	(1)
	PBL064	Stop Motion Washer	(1)
	PBL065	Stop Motion Clamp Screw	(1)
	PBL066	Crank Connecting Rod	(1)
	PBL067	Crank Conn'ct'g.Rod HingeScrew	(1)
	PBL068	Forked Rod	(1)
	PBL069	Forked Rod Slide Block w/Stud	(1)
	PBL070	Feed Regulator Slide Block	(1)
	PBL080	Hand Wheel with Screw	(1)
	PBL407	Feed Regulator	(1)
	PBL408	Feed Regulator Spring	(1)
PBL409	Hold Screw for PBL408	(1)	
PBL721	Upper Feed Eccentric w/Screw	(1)	
PBL723	Upper Feed Connecting Rod	(1)	
DIAGRAM 33 MOTOR ASSEMBLY	PBL228	Motor Setting Screw	(1)
	PBL228B	Washer	(1)
	PBL228C	Washer, Star	(1)
	PBL749	Motor Pulley	(1)
	PBL779-2	Motor Assembly	(1)
	PBL779BK	Motor Bracket	(1)
PBL779BR	Motor Brushes (Not Shown)	(2)	
DIA. 34 - POWER CORD ASS'Y	PBL780	Power Cord 110 Volts	(1)
DIA. 35 - SEWING LIGHT ASS'Y	BPL232	Switch, Sew Light Assembly	(1)
DIA. 36 - BELT COVER ASS'Y	PBL200	Belt Cover	(1)
	PBL227	Screw for PBL200	(4)
DIAGRAM 37 FRONT CASTER ASSEMBLY	PBL714	Front Caster Bracket	(1)
	PBL715	Caster Bracket Screw	(2)
	PBL716	Caster Axle Screw	(1)
	PBL717	Washer for PBL716	(2)
	PBL717A	Washer (Small)	(1)
	PBL717B	Washer (Large)	(1)
	PBL718	Nut for PBL716	(1)
PBL719	Caster	(1)	

PARTS LIST BY DIAGRAM NUMBERS

DIAGRAM NUMBER & ASS'Y	PART NO.	DESCRIPTION	QUAN.
DIAGRAM 38 BACK CASTER ASSEMBLY	PBL715	Caster Bracket Screw	(3)
	PBL716	Caster Axle Screw	(2)
	PBL717A	Washer for PBL716 (Small)	(2)
	PBL717B	Washer for PBL716 (Large)	(2)
	PBL718	Nut for PBL716	(2)
	PBL719	Caster	(2)
	PBL750	Rear Caster Bracket	(1)
	PBL769	Grommet for PBL750	(1)
DIAGRAM 39 ACCESSORIES	PBL781A	Oiler	(1)
	PBL781B	Bent Tweezers	(1)
	PBL781C	Screw Driver Pair	(2)
	PBL781D	Plastic Box	(1)
DIA. 40 - RUG SHEARS	PBL781E	Rug Shears	(1)
DIAGRAM 41 BINDING SUPPLIES	#08052	"A" Type Prewound Bobbin	STOCK ITEMS
	PBL782	Timing Gauge (Optional)	
	#21022	#22 Diamond Point Needles	
DIA. 42 - FOOT CONTROL	PBL785	Foot Control Mechanism	(1)
DIAGRAM 43 STATIONARY TABLE UNIT	PBL000	Thread Stand	(1)
	PBL000	Utility Light	(1)
	#21011	PBL Table, Complete (Optional)	---
DIAGRAM 44 DOUBLE PULLER CASTER ASSEMBLY	PBL715	Caster Bracket Screw	(2)
	PBL716	Caster Axle Screw	(2)
	PBL717A	Washer for PBL716 (Small)	(2)
	PBL717B	Washer for PBL716 (Large)	(2)
	PBL718	Nut for PBL716	(2)
	PBL719	Caster	(2)
	PBL793S	Idler Wheel Axle	(2)
	PBL793	Caster Mounting Plate	(1)
	PBL793A	Idler Wheel	(2)
DIAGRAM 45 CAM/CRANK ASSEMBLY	PBL789	Cam Crank - Upper Part	(1)
	PBL789A	Feed Cam	(1)
	PBL792	Connecting Rod	(1)
DIAGRAM 46 UNIVERSAL BALL JOINT SHAFT	PBL794	Universal Ball Joint Ass'y	(1)
	PBL737PN	Pin for PBL794	(2)
	PBL737SC	Screw for PBL794	(3)
DIAGRAM 47 BACK FEED ROLLER ASSEMBLY	PBL762	Thumb Screw	(1)
	PBL786	Back Puller Frame	(1)
	PBL786A	Lifter Bracket	(1)
	PBL790	Feed Roller	(1)
	PBL790A	Feed Roller Yoke	(1)
	PBL790B	Feed Roller Sleeve	(1)
DIA. 48 - LIFTER LEVER ASS'Y	PBL788	Back/Front Lift Lever	(1)
	PBL788A	Lifter Handle	(1)
DIAGRAM 49 ROLLER CLUTCH ASS'Y	PBL787	Clutch Housing	(1)
	PBL787A	Clutch Crank	(1)
	PNL787B	Clutch Drive Shaft (Not Shown)	(1)
	PBL787C	Main Clutch w/ Large bearing	(1)
	PBL787CS	Small Clutch Bearing (Not Shown)	(1)
	PBL791	Coupling Collar	(1)
DIAGRAM 50 IDLER ROLLER PLATE ASS'Y	PBL795	Idler Roller Plate	(1)
	PBL795A	Knurled Idler Roller	(1)
	PBL795B	Idler Roller Plate	(1)

NUMERICAL LISTING OF PART NUMBERS

PART NO.	DESCRIPTION	DIA. NO.	PART NO.	DESCRIPTION	DIA. NO.
PBL001	Needle Bar Drive Frame	15	PBL078-2	Set Screw & Washer for PBL077-2	3
PBL002	Needle Bar Drive Frame Pin Ass'y	15	PBL080	Hand Wheel w/Screw	32
PBL002A	Screw for PBL002	15	PBL081	Screw for PBL072-2	4
PBL002B	Bushing for PBL002	15	PBL101NS	Shuttle Race (New Style)	19
PBL002C	Retaining Clip for PBL002	15	PBL102	Set Screw for PBL-101 (Pkg of 2)	19
PBL003	Set Screw for PBL002	15	PBL103	Shuttle Race Retainer Ring	19
PBL007	Adjustable Eccentric for PBL001	15	PBL103C	Shuttle Race Cleaner	19
PBL008	Set Screw for PBL007	15	PBL103S	Screw for PBL103D	19
PBL009	Zigzag Drive Crank Spring	15	PBL103D	Race Ring Cover	19
PBL011	Needle Bar Connecting Stud /Screw	14	PBL104	Shuttle Hook	19
PBL011S	Needle Bar Screw	14	PBL105	Bobbin Case	19
PBL012	Needle Bar Connecting Link /Screw	14	PBL105S	Bobbin Case Spring	19
PBL021	Presser Bar Spring Bracket	16	PBL105SC	Adjusting Screw for PBL105	19
PBL025	Presser Lifter	25	PBL106S	Screw for PBL106	19
PBL026	Presser Bar Lift Hinge Stud	25	PBL106	Shuttle Driver Shaft Bushing	19
PBL034	Arm Shaft Crank	32	PBL107NS*	Shuttle Driver Assembly (New)	19
PBL035	Set Screw for PBL034	32	PBL107C *	Set Screw for PBL107	19
PBL036	Spring Pin for PBL034	32	PBL107W *	Thrust Washer for PBL107	19
PBL037	Set Screw for PBL038	32	PBL110	Shuttle Drive Shaft Collar w/w&s	19
PBL038	Take-Up Lever Crank	14	PBL112	Shuttle Drive Shaft Bevel Gear	19
PBL039	Shoulder Screw for PBL038	14	PBL113	Set Screw, Pointed for PBL112	19
PBL040	Take-Up Lever	14	PBL114	Screw, Flat for PBL112	19
PBL041	Set Screw for PBL040 - (Not Shown)	14	PBL115	Lower Shaft Bevel Gear w/Screw	20
PBL042	Arm Shaft	32	PBL115W	Nylon Washer	20
PBL043	Arm Shaft Front Bushing	32	PBL116	Set Screw, Pointed for PBL115	20
PBL044	Set Screw for PBL043	32	PBL117	Screw, Flat for PBL115	20
PBL045	Arm Shaft Collar w/screw & washer	32	PBL118	Lower Shaft	20
PBL050	Worm Gear w/ Screws	32	PBL119	Lower Shaft Bushing	20
PBL052	Feed Cam w/ Screws	32	PBL120	Set Screw for PBL119	20
PBL055	Arm Shaft Back Bushing w/Felt	32	PBL122	Lower Shaft Cam w/Screw/Washer	20
PBL056	Hand Wheel Bushing w/ Screw	32	PBL127-2	Feed Rock Shaft Assembly	22
PBL058	Spring Pin for PBL056	32	PBL127A	Lower Shaft Crank w/Screw	20
PBL063	Stop Motion Knob	32	PBL127SC	Timing Screw, 1/2" Long	20
PBL064	Stop Motion Washer	32	PBL127SCNS	Timing Screw, 3/8" Long	20
PBL065	Stop Motion Clamp Screw	32	PBL136	Screw Center w/Nut for PBL127-2	22
PBL066	Crank Connecting Rod	32	PBL137	Feed Bar Shaft Crank w/Screw	22
PBL067	Crank Connecting Rod Hinge Screw	32	PBL165	Gear Box Gasket	18
PBL068	Forked Rod	32	PBL166	Set Screw for PBL187	18
PBL069	Forked Rod Hinge Screw w/ Nut	32	PBL183	Electric Bulb	17
PBL070	Feed Regulator Slide Block w/ Stud	32	PBL187	Gear Box Cover	18
PBL071-3	Tension Dial Assembly	10	PBL188B	Spring Bracket	21
PBL072-2	Stitch Length Knob	4	PBL188	Feed Crank Ass'y w/Spring	21
PBL073-2	Face Plate Thread Guide	9	PBL189	Set Screw for PBL188 (Long)	21
PBL074-2	Set Screw for PBL073-2	9	PBL190	Set Screw for PBL188 (Short)	21
PBL075-2	Face Plate	3			
PBL076-2	Face Plate Hinge Pin	3			
PBL077-2	Face Plate Hinge	3			

NUMERICAL LISTING OF PART NUMBERS

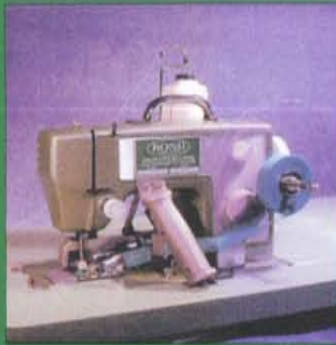
PART NO.	DESCRIPTION	DIA.	PART NO.	DESCRIPTION	DIA.
PBL191	Star Washer for PBL190	21	PBL707WM	Single Turn Folder - 13/16"	13
PBL192	Zigzag Drive Crank	30	PBL707SB	Serging Tape Folder - 7/8"	13
PBL193	Zigzag Cam w/ Screws	5	PBL707FG	Fringe Guide	13
PBL195	Stitch Width Knob	5	PBL707BA	Cove Base Binding Guide	13
PBL195W	Washer for Stitch Width Knob	5	PBL708	Binder, Screw & Washer	Refer to Page 9
PBL196	Top Plate	1	PBL709L	Binder Screw - Long	
PBL197	Screw for PBL196	1	PBL709	Binder Screw - Short	
PBL198	Top Plate Thread Guide	1	PBL710N	Knurled Nut for PBL710	6
PBL199	Screw for PBL198	1	PBL710SP	Spring for PBL710	6
PBL200	Belt Cover	36	PBL710S	Shaft/ Screw for PBL710	6
PBL227	Screw for PBL200	36	PBL710	Binding Tension	6
PBL228	Motor Setting Screw	33	PBL711	Screw & Washer	6,8, 26
PBL228B	Washers for Motor Setting	33	PBL712	Thread Tube	28
PBL228C	Washers for Motor Setting	33	PBL713	Thread Rod Holder	28
PBL230	Sew Light Assembly	17	PBL714	Front Caster Bracket	37
PBL231	Screw for PBL230	17	PBL715	Caster Bracket Screw	37 & 38
PBL232	Switch-Sew Light Assembly	35	PBL716	Caster Axle Screw	37, 38,44
PBL401	Front Plate	2	PBL717B	Washer for PBL716 (large)	37, 38 ,44
PBL402	Unit Frame Assembly	31	PBL717A	Washer for PBL716 (small)	37, 38, 44
PBL402GC	Cam/Gear Only	31	PBL717	Washer	37, 38, 44
PBL402SP	Spring for CamGear	31	PBL718	Nut for PBL716	37, 38, 44
PBL403	Set Screw for PBL402 Short	31	PBL719	Caster	37, 38, 44
PBL404	Set Screw for PB-402 Long	31	PBL720-2	Motor/Thread Bracket	26
PBL407	Feed Regulator	32	PBL720P	Retaining Post	26
PBL408	Feed Regulator Spring	32	PBL721	Upper Feed Eccentric w/screw	32
PBL409	Holding Screw for PBL408	32	PBL723	Upper Feed Connecting Rod	32
PBL700	Needle Bar	15	PBL724	Belt Idler Pulley	26
PBL701	Needle Screw	15	PBL724BRL	Large Bearing for PBL724	26
PBL702-2	Needle Plate	12	PBL724BRS	Small Bearing for PBL724	26
PBL703B	Binder Bracket Extension	12	PBL724SFT	Shaft for PBL724	26
PBL703S	Screw for PBL703B	12	PBL724SC	Screw for PBL724	26
PBL703	Needle Plate Screw	12	PBL725	Thrust Washer for PBL724	26
PBL704	Feed Dog	23	PBL726	Washer for PBL724	26
PBL705	Feed Dog Screw	23	PBL727	Nut for PBL724 (Not Shown)	26
PBL706	Thread Nipper Assembly	11	PBL728	Switch	Old Style Handle Parts
PBL706G	Guide for PBL706	11	PBL729	Switch Screw	
PBL706H	Nipper Housing	11	PBL730	Switch Cover Plate	
PBL706R	Thread Retainer Guides	11	PBL731	Screw for PBL730	
PBL706SW	Spur Washer	11	PBL732	Handle	
PBL706S	Screw for PBL706	11	PBL732W	Washer for PBL732W	
PBL706W	Washer	11	PBL732SC	Screw for PBL732	
PBL707DT	Double Turn Folder -Cotton - 3/4"	13	PBL733	Grommet for PBL732	
PBL707CT	Single Turn Folder - Cotton - 3/4"	13			

NUMERICAL LISTING OF PART NUMBERS

PART NO.	DESCRIPTION	DIA.	PART NO.	DESCRIPTION	DIA.
PBL 734	Top Roller Feed Frame	24	PBL779BR	Motor Brushes (Not Shown)	33
PBL735	Top Roller Feed	24	PBL779-2	Motor Assembly - 115 Volts	33
PBL735SC	Top Roller Feed Screw	24	PBL780	Power Cord - 110 V	34
PBL736	Top Roller Feed Axle	24	PBL781	Accessory Set	39
PBL737PN	Pin for PBL737	24 & 46	PBL781A	Oiler	39
PBL737SC	Screw for PBL737	24 & 46	PBL781B	Bent Tweezers	39
PBL737	Top Feed Univ. Drive Shaft	24	PBL781C	Screw Drivers (Set of 2)	39
PBL738	Top Feed Clutch Drive Complete	24	PBL781D	Accessory Box	39
PBL738A	Rebuilt Top Feed Clutch	---	PBL781E	Rug Shears-7-1/2" bent - Optional	40
PBL739	Thrust Washer for PBL742	24	PBL782	Timing Gauge	41
PBL740	Washer for PBL742	24	PBL783	Shipping Carton	---
PBL741	Nut for PBL742	24	PBL784	Parts & Instruction Manual	---
PBL742	Hinge Stud Screw PBL723	24	PBL785	Electric Foot Control (Optional)	42
PBL743	Mounting Screw PBL738	24	PBL786	Back Puller Frame	47
PBL744	Washer for PBL743	24	PBL786A	Lifter Bracket	47
PBL745	Nut for PBL743	24	PBL787	Clutch Housing	49
PBL746	Binding Bracket w/Scrw & Washer	8	PBL787A	Clutch Crank	49
PBL746N	Nut for PBL746	8	PBL787B	Clutch Drive Shaft (Not Shown)	49
PBL746PN	Pin/Shaft for PBL746	8	PBL787C	Main Clutch w/Large Bearing	49
PBL746B	Stand Up Bracket for PBL746	8	PBL787CS	Clutch Bearing (Small) Not Shown	49
PBL747	Binding Tape Disc	8	PBL788	Back Lifting Lever	48
PBL748	Binding Hold Down Spring Ass'y	8	PBL788A	Back Lifter Handle	48
PBL748SC	Screw for Spring	8	PBL789	Cam Crank - Upper Part	45
PBL749	Motor Pulley	33	PBL789 A	Feed Cam - Lower Part	45
PBL750	Rear Caster Bracket	38	PBL790	Feed Roller	47
PBL753	Carrying Handle	1	PBL790 A	Feed Roller Yoke	47
PBL755-2	Machine Belt	27	PBL790 B	Feed Roller Shaft	47
PBL755-2L	Motor Belt	27	PBL791	Coupling Collar	49
PBL758	Screw for PBL753	1	PBL792	Connecting Rod	45
PBL759	Washer for PBL758	1	PBL793	Caster Plate	44
PBL760	Nut for PBL758	1	PBL793 A	Idler Wheel	44
PBL761	Screw for PBL734 & PBL735	24	PBL793S	Idler Wheel Axle	44
PBL762	Top Feed Presser Bar Thumb Screw	16	PBL794	Universal Ball Joint Assembly	46
PBL763	Top Feed Presser Bar Spring	16	PBL795	Idler Roller Plate	50
PBL764	Top Feed Presser Bar	16	PBL795A	Knurled Idler Roller	50
PBL765-3	Check Spring, 3/8" Coil	10	PBL795B	Idler Roller Shaft	50
PBL766	Screw for PBL720-2	26	PBL798	New Handle	7
PBL767	Screw for PBL720-2 w/Washer	26	08052	"A" Style Prewound Bobbin	41
PBL768	Spacer for PBL766 Screw	26	08054	Size 52 Clear Thread	29
PBL769	Grommet for PBL750 and PBL798	7 & 38	21011	PBL Table Complete	43
PBL777DT	Double Turn Folder - 1-1/4"	13	21020	Oil Refill	---
PBL777ST	Single Turn Folder - 1-1/4"	13	21022	#22 Diamond Point Needle	41
PBL777CT	Clean Top Folder - 1-1/4"	13			
PBL778SF	Sisal Folder -3" ST & Clean Top	13			
PBL779BK	Motor Bracket	33			

TROUBLESHOOTING

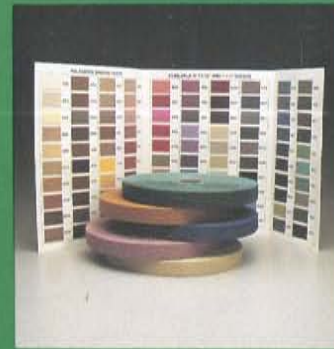
PROBLEM	PROBABLE CAUSE	CORRECTION
IRREGULAR STITCHES	IMPROPER THREADING LOOSEN UPPER THREAD TENSION TIMING OFF OPERATOR PULLING CARPET LIGHT PRESSURE ON TOP FEED ROLLER	RETHREAD MACHINE (PAGE 6) ADJUST UPPER THREAD TENSION DIAL (PAGE 8) RETIME DO NOT PULL CARPET / LET FEED NATURALLY ROTATE TOP ROLLER FEED PRESSURE CONTROL KNOB CLOCKWISE TO ADD MORE PRESSURE
BREAKING NEEDLE	OPERATOR PULLING CARPET INCORRECT NEEDLE SIZE INCORRECT SETTING OF NEEDLE WORN SHUTTLE RACE ASSEMBLY HOOK TIMING OUT	DO NOT PULL CARPET/ LET FEED NATURALLY USE ONLY #21022 NEEDLE (FOR HOT MELT #21023) CHECK AND RESET NEEDLE HEIGHT (PAGE 5) REPLACE CHECK AND RESET (PAGE 5)
BUNCHING OF THREAD	LOOSE TENSION(S) CLUTCH SLIPPING LENGTH OF STITCH TOO SHORT	TIGHTEN AND BALANCE TENSION(S) (PAGE 8) REBUILD/REPLACE CHECK LENGTH STITCH SETTING (8)
PUCKERING	INCORRECT THREAD TENSION(S) LIGHT PRESSURE ON TOP ROLLER FEED BINDING TENSION TIGHT BENT OR BLUNT NEEDLE	TIGHTEN AND BALANCE TENSION(S) ROTATE TOP ROLLER FEED PRESSURE CONTROL CLOCKWISE TO ADD PRESSURE LOOSEN BINDING TENSION (PAGE 9) INSERT NEW NEEDLE (PAGE 5)
SKIPPING STITCHES	BENT OR BLUNT NEEDLE INCORRECT SETTING OF NEEDLE AND NEEDLE LENGTH HOOK TIMING INCORRECT NEEDLE NOT IN STRAIGHT	INSERT NEW NEEDLE (PAGE 5) RESET NEEDLE (PAGE 5) CHECK AND RESET TIMING (PAGE 10) STRAIGHTEN NEEDLE (PAGE 5)
BREAKING NEEDLE THREAD	IMPROPER THREADING SHARP EYE IN NEEDLE OR BENT HOOK TOO CLOSE TO NEEDLE HOOK TIMING OFF	RETHREAD MACHINE (PAGE 6) INSERT NEW NEEDLE (PAGE 5) FACTORY REPAIR RETIME (PAGE 10)
BREAKING BOBBIN THREAD	IMPROPER BOBBIN CASE THREADING BOBBIN TANGLING TIGHT BOBBIN THREAD TENSION LINT IN BOBBIN CASE OR SHUTTLE	CHECK BOBBIN CASE THREADING (PAGE 7) REPLACE BOBBIN SPOOL LOOSEN BOBBIN THREAD TENSION AND RE-BALANCE (PAGE 8) CLEAN BOBBIN CASE AND SHUTTLE/HOOK (PAGE 14)
CARPET NOT MOVING	FEED DOG DOWN CLUTCH SLIPPING/ WORN STITCH LENGTH KNOB NOT SET FEED DOG DIRTY LIGHT PRESSURE ON TOP ROLLER FEED	RAISE FEED DOG (PAGE 11) RINSE WITH CLEANING FLUID OR REPLACE/REBUILD RESET LENGTH KNOB TO #5 SETTING REMOVE NEEDLE PLATE AND CLEAN FEED DOG ROTATE TOP ROLLER FEED PRESSURE CONTROL KNOB CLOCKWISE TO ADD PRESSURE
MACHINE JAMMING (KNOCKING NOISE)	THREAD CAUGHT IN HOOK/SHUTTLE CARPET TOO DENSE OR HIGH INCORRECT TIMING WORN SHUTTLE RACE ASSEMBLY OPERATOR PULLING CARPET	DISASSEMBLE AND CLEAN HOOK SHUTTLE. DO NOT RUN MACHINE WITHOUT BINDING BEVEL EDGES SEE PAGE 10 TO TEST AND ADJUST FACTORY REPAIR LET CARPET FEED NATURALLY
UPPER THREAD STITCHING BUT BREAKING UNDER CARPET LEAVING A RAT'S NEST	TENSION DIAL TOO LOOSE THREAD NOT IN TENSION DIAL SHUTTLE HOOK HAS BURR	ADJUST AND BALANCE (PAGE 8) RETHREAD MACHINE POLISH AND/OR REPLACE



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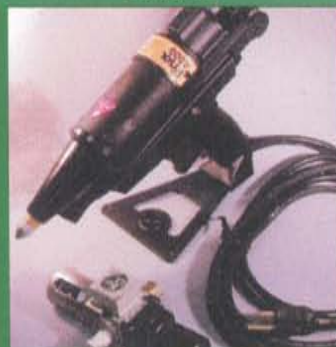
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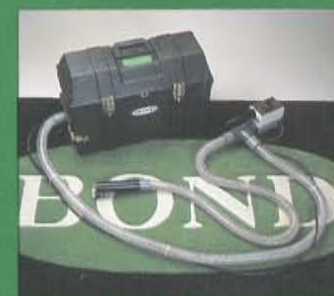
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