

Instruction Manual and Parts List

Ultra High Speed Overedge
and Safety Stitch Machine

321D 131M-04
131M-04 / KS
132M-015
134M-04
241M-24
241M-24 / KS
244M-24
251M-35
251M-35 / KH
251M-55
251M-55 / KH
251M-56
251H-56 / KH

321K 131M-04
131M-04 / KS
132M-015
134M-04
241M-24
241M-24 / KS
244M-24
251M-35
251M-35 / KH
251M-55
251M-55 / KH
251M-56
251H-56 / KH



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1.1

Important Safety Instructions

Important

When using the machine, basic safety procedures must be followed. Read with attention all instructions before using the machine.

When using it, understand that all basic safety instructions are not limited to the following items. Read all instructions, take care of this manual, and use it as reference when necessary.

- Before running the machine, make sure all relevant safety specifications are adequate to specifications and technical standards in your country.
 - The machine should not be run without its safety devices.
 - The machine should only be operated by properly trained personnel.
 - For your safety, goggles must be used while running the machine.
 - Turn off or unplug the machine when the following situations arise:
 - Passing the thread by the needle or replacing the bobbin or looper.
 - Replacing the needle, presser foot, throat plate, feed dog and sliding plate.
 - When the machine is in maintenance.
 - When the operator is not running the machine.
 - In case of lubricant oil contact with the eyes or skin, washed the surface with plenty of icy water with a generous amount of cold water. In case of ingestion, seek medical help immediately.
 - Repair, fitting or maintenance should only be performed by properly trained personnel.
 - Maintenance and repair on electric equipment should only be made by qualified personnel. If any electric device is damaged, the machine should be immediately stopped.
 - Before starting the machine in full running, a test must be conducted to assure that machine and operator are able to perform the task.
 - The machine should not be placed next to a sound source as an ultrasonic welding machine and other equipment.
 - The machine should only be run with the proper electric cable and connectors, and also the adequate grounding.
 - The machine should only be used to sew materials as indicated in its instructions manual, and indications of use should be followed.
- Singer will not be held responsible for any damage caused by unauthorized changes in the product.

1.2

For Safe Operation

- ⚠ • *To avoid the risk of electric shock, do not open the motor wiring box and do not touch the components assembled inside the wiring box.*
- *To avoid injuries do not run the machine without the belt cover or in case any other safety device is removed.*
- *To avoid possible injuries keep fingers, head and clothes far from wheel, belt and motor when the machine is running. Nothing should be placed near those parts.*
- *To avoid injuries never put your fingers next to the rotating hook and the thread take-up lever cover when the machine is running.*
- *To avoid possible injuries be careful when putting down or lifting the machine head.*
- *To avoid accident in case of a sudden start of the machine always turn it off when laying it down, or remove the belt cover and the belt.*
- *If you machine is equipped with a servomotor, it does not make noises while being driven. To avoid a possible accident caused by an unexpected start, be sure the machine is turned off.*
- *To avoid electrical shock, do not run the machine without proper grounding.*
- ⚠ • *To minimize the risk of accidents or damage in electric components caused by electric discharge turn the machine off before unplugging it.*
- *Clean the machine periodically.*

2

Product Description and Machine Specification

2.1 Product Description

Ultra high speed overedge and safety stitch machines



2.2

Machine Specification

Table 1 – Machine Specification

Singer Model	Needles	Threads	Needle Gauge [mm]	Overedge Bight [mm]	Stitch Length [mm]	Differential Rate	Presser Foot Lift [mm]	Singer Needle Cat	Speed [spm]	Application
321D-131M-04				4				6120-06 75/11	8500	Three-thread overlock machine
321D-131M-04 / KS	1	3	-	4				6120-06 75/11	8500	Three-thread overlock machine with vertical chain cutter and AFL device
321D-132M-015				1.5				6120-06 65/9	8500	Three-thread handkerchief edging (rolled hem) overlock machine
321D-134M-04				4				6120-06 75/11	7500	Three-thread back latch overlock machine
321D-241M-24				4				6120-06 75/11	7500	Four-thread overlock machine
321D-241M-24 / KS	2	4	2	4		0.7 ~ 2.0	5	6120-06 75/11	7500	Four-thread overlock machine with vertical chain cutter and AFL device
321D-244M-24				4	3.8			6120-06 75/11	7500	Four-thread back latch overlock machine
321D-251M-35				5				6120-06 90/14	7500	Five-thread overlock machine
321D-251M-35 / KH			3	5				6120-06 90/14	7500	Five-thread overlock machine with vertical chain cutter and AFL device
321D-251M-55	2	5	5	5				6120-06 90/14	7500	Five-thread overlock machine
321D-251M-55 / KH			5	5				6120-06 90/14	7500	Five-thread heavy duty overlock machine with horizontal chain cutter and AFL device
321D-251H-56				6				6120-06 130/21	6500	Five-thread heavy duty overlock machine
321D-251H-56 / KH				6		0.8~1.5	7	6120-06 130/21	6500	Five-thread heavy duty overlock machine with horizontal chain cutter and AFL device
321K-131M-04				4				6120-06 75/11	8500	Three-thread overlock machine
321K-131M-04 / KS	1	3	-	4				6120-06 75/11	8500	Three-thread overlock machine with vertical chain cutter and AFL device
321K-132M-015				1.5				6120-06 65/9	8500	Three-thread handkerchief edging (rolled hem) overlock machine
321K-134M-04				4				6120-06 75/11	7500	Three-thread back latch overlock machine
321K-241M-24				4				6120-06 75/11	7500	Four-thread overlock machine
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321K-244M-24				4	3.8			6120-06 75/11	7500	Four-thread back latch overlock machine
321K-251M-35				5				6120-06 90/14	7500	Five-thread overlock machine
321K-251M-35 / KH			3	5				6120-06 90/14	7500	Five-thread overlock machine with vertical chain cutter and AFL device
321K-251M-55	2	5	5	5				6120-06 90/14	7500	Five-thread overlock machine
321K-251M-55 / KH			5	5				6120-06 90/14	7500	Five-thread overlock machine with horizontal chain cutter and AFL device
321K-251H-56				6				6120-06 130/21	6500	Five-thread heavy duty overlock machine
321K-251H-56 / KH				6		0.8~1.5	7	6120-06 130/21	6500	Five-thread heavy duty overlock machine with horizontal chain cutter and AFL device

With Clutch Motor

With Direct Drive Servo Motor

2.3

**Motor,
Motor Pulley
and V-Belt
Specifications**

2.3.1 For 321D series

*½ HP 2-pole clutch motor
Motor pulley diameter
M type v-belt*

Table 2

Machine Speed [spm]	Motor Pulley Diameter [mm]	
	50 Hz	60 Hz
5,500	110	90
6,000	115	95
6,500	130	105
7,000	140	115
7,500	150	125

2.3.2 For 321K series

Direct drive servo motor and control system.

3

Setup and Adjustment Instructions

3.1

Table Cut-Out Diagram

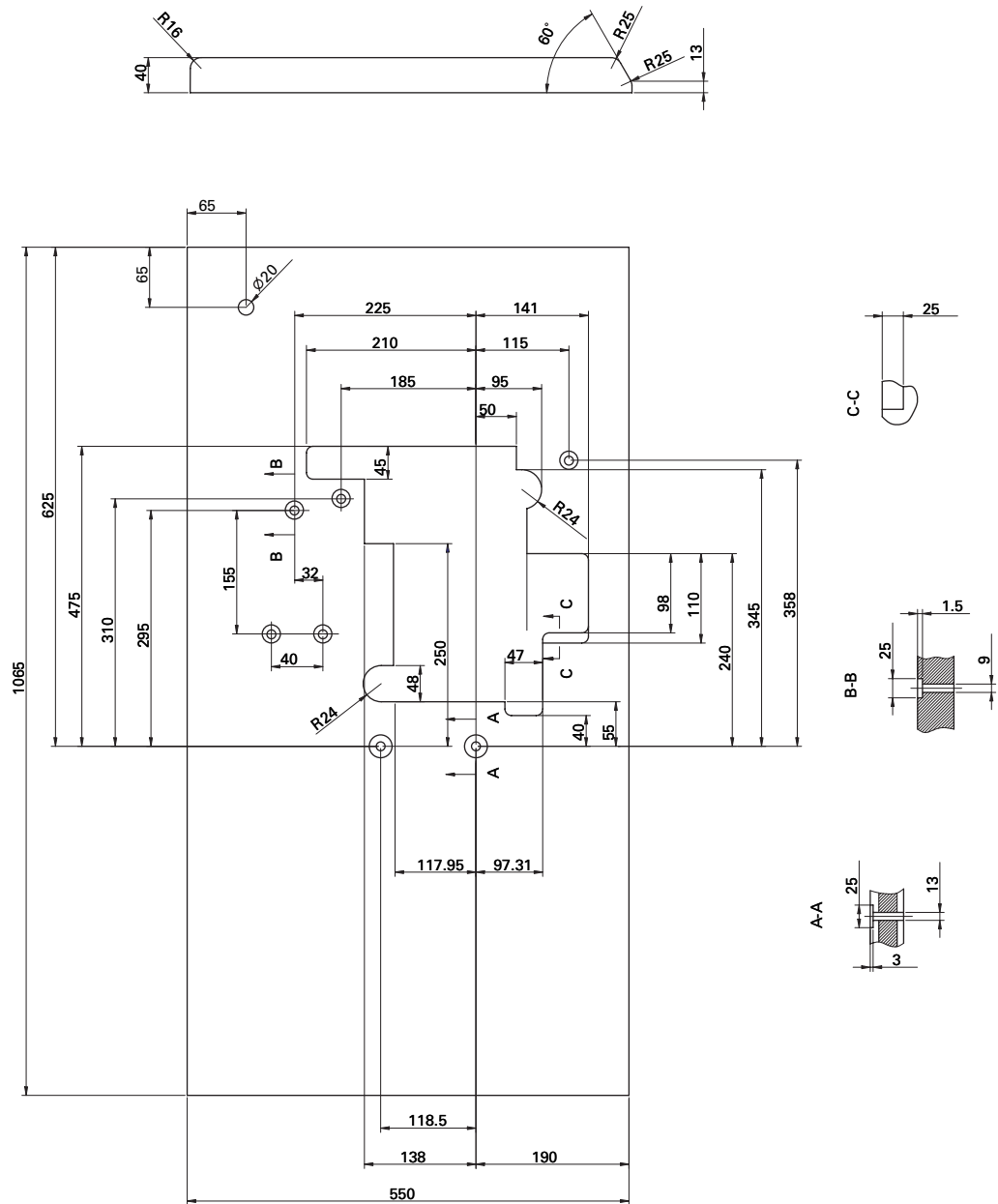


Figure 1

3.2

Machine Installation

Install the machine support components and the cloth waste chute as indicated in Figure 2. In case of semi-submerged assembly, the distance between the needle plate

top surface and the table top is around 100 mm. For fully-submerged assembly, the distance is around 5.0 mm.

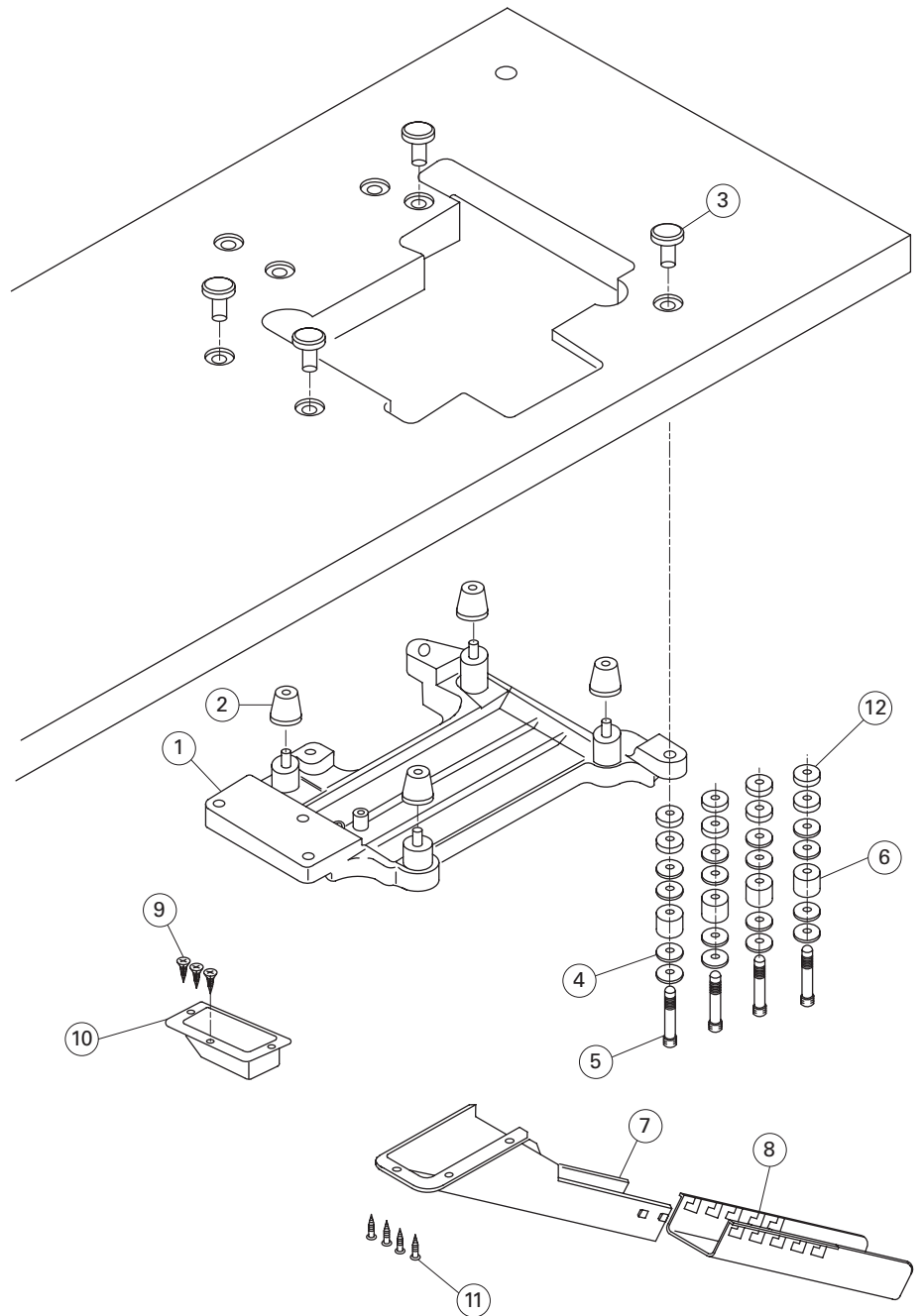


Figure 2

3.2

Machine Installation

Mount the machine head over the machine support plate.

Connect the machine handwheel to the clutch motor with the v-belt (for 321D only)

Adjust the tension of the v-belt so that it can be about 20 mm bent inward when you press the middle of it and make sure the motor turning direction is clockwise, referred to the Figure 3.(for 321D only)

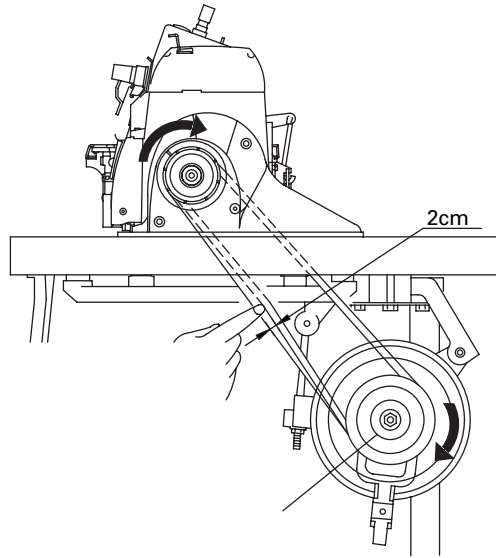


Figure 3

Set the pedal of the clutch motor to the left side and the pedal of the presser foot lift at right side.

Install the thread stand referred to the parts list.

Install the belt cover according to Figure 4.(for 321D only)

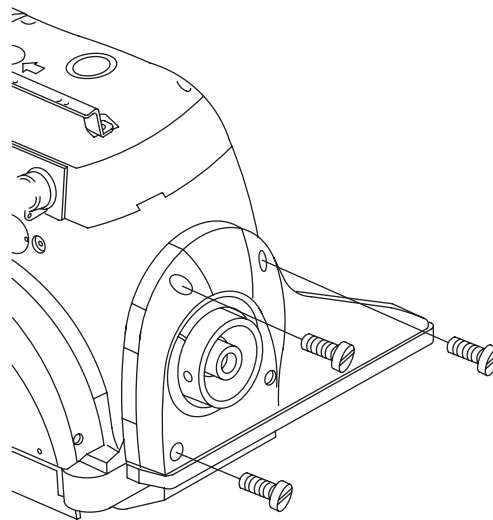


Figure 4

3.3

Lubrication and Oil Drainage

Important

As this is a ultra high speed machine, DO NOT run the machine before oiling and assuming the direction of the motor rotation.

Remove the rubber plug and fill the lubricant oil (Singer Oil) until the indicator of the oil level between 'L' and 'H' lines of the oil level sight window. After that put back the rubber plug.

When using the machine for the first time, or a machine that has not been used for some time, oil the needle bar top, the guides and looper before running it.

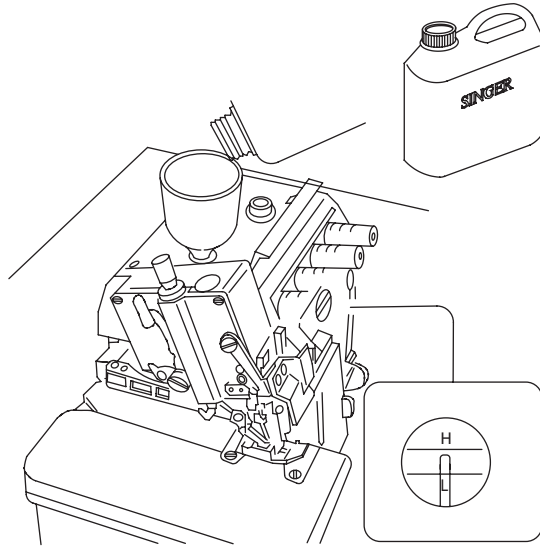


Figure 5a

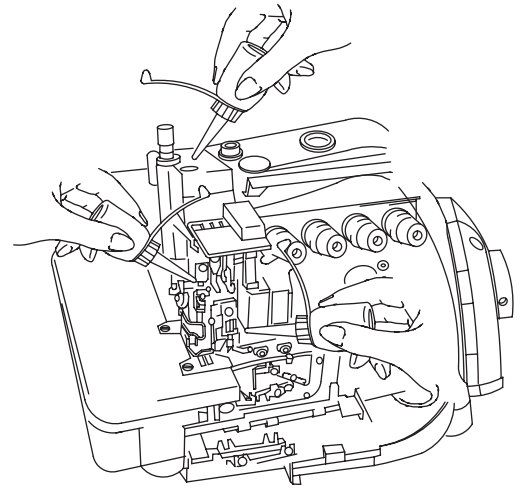


Figure 5b

To preserve the machine, change the oil after the four weeks of use. After that, the oil must be changed every six months. To change the oil, simply remove screw indicated on Figure 6. After draining the oil, replace the screw and fill the machine with new oil.

This machine has an oil filter that must be cleaned every month or changed as needed. To replace the oil filter, simply remove four screws and remove the top cover indicate on Figure 7. Then remove three screws and remove oil filter cap.

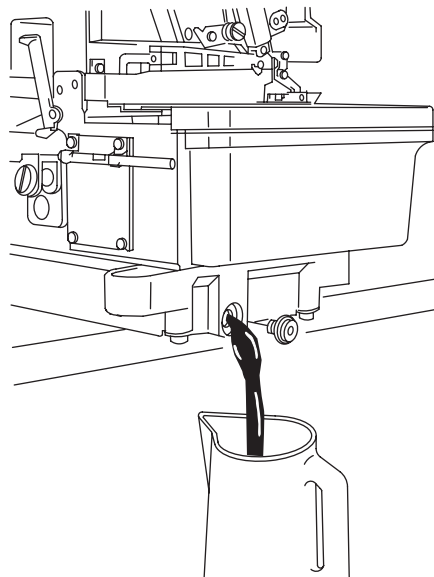


Figure 6

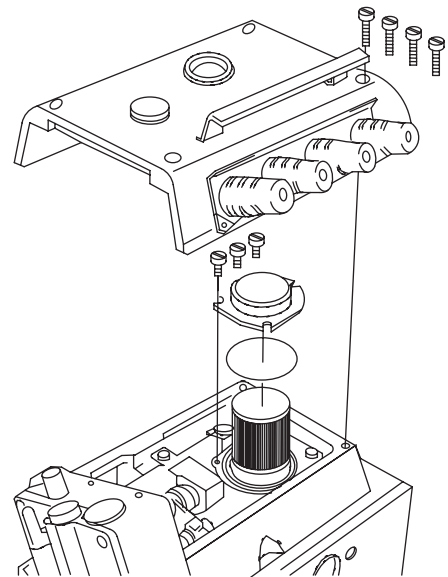


Figure 7

3.4

Fill Silicon Oil to Reservoir

When sewing in ultra high speed, fill the device with silicon oil in order to prevent needle thread

breakage and fabric damage. As show on Figure 8.

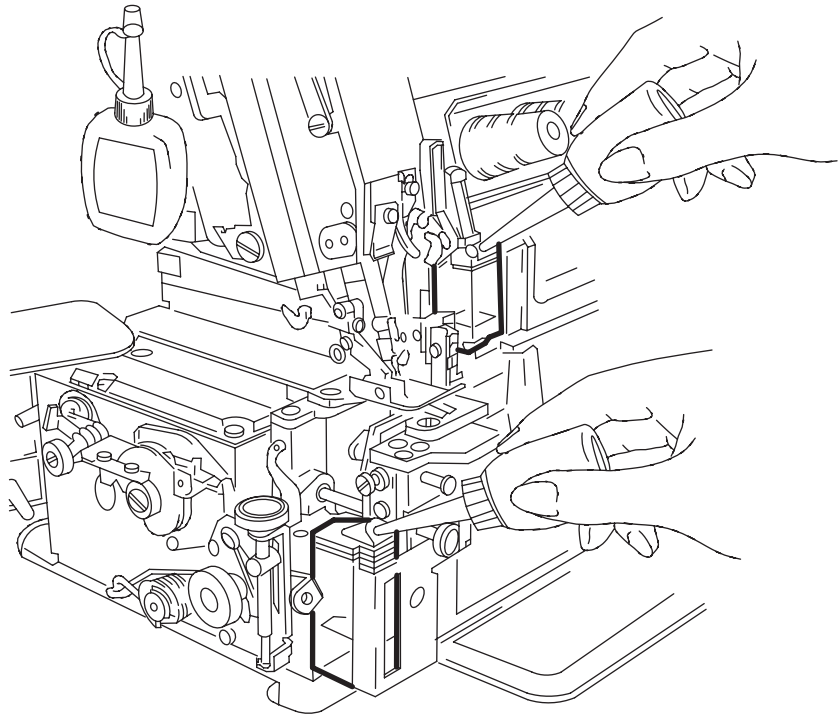


Figure 8

3.5

Needle Attachment (or Replacement)

Use only Singer's Cat. 6120 needles
Loosen screw '1' as indicated on Figure 9 & 10 with the Allen key wrench in the accessory box and insert the needle (or remove the old

needle).

Insert the needle with its long groove facing towards you and push it up until the bar end.. Tighten screw '1'.

For 1 needle For 2 needle

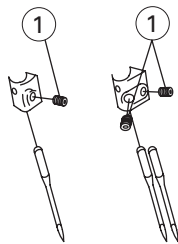
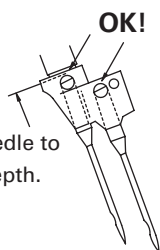


Figure 9 (a)



Insert the needle to the proper depth.

Figure 9 (b)

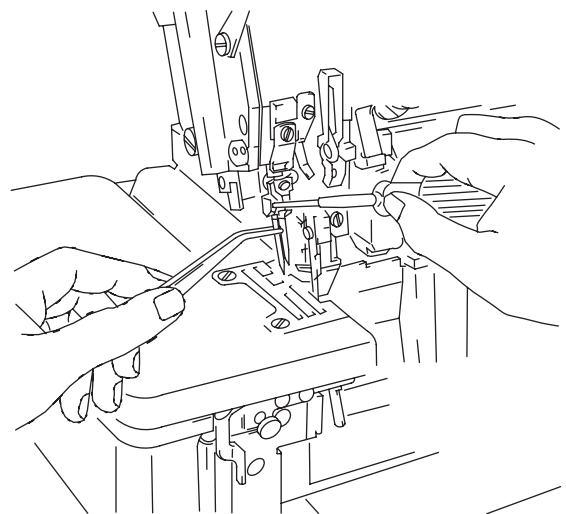


Figure 10

3.6

Replacing Upper and Lower Knife

Replacing the upper knife

1. Loosen screw '1'. Move lower knife holder '2' to the extreme left position. Tighten screw '1' temporarily.

2. Remove screw '3' and then upper knife '4'.

● To install a new upper knife, turn the handwheel until the upper knife holder reaches the lowest position of its stroke. Overlap the cutting edges of the upper and lower knives by 0.5~1.0 mm according to the over-edge width (Figure 11).

3. Overlap the cutting edges of the upper and lower knives so that midpoint 'A' on upper knife '4' and the midpoint of lower knife '6' are crossed (Figure 12). Loosen screw

'1'. Make sure the upper and lower knives mate positively. Then tighten screw '1'.

4. Place a thread between the upper and lower knives. Check the cutting by turning the handwheel.

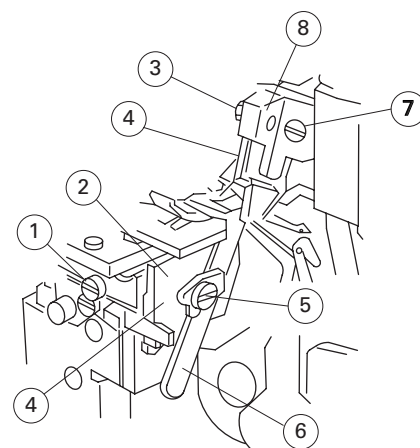


Figure 11

Replacing the lower knife

1. Loosen screw '1'. Move lower knife holder '2' to the extreme left position. Tighten screw '1' temporarily.

2. Loosen screw '5' and remove lower knife '6'. Install a new knife by referring to "Replacing the upper knife" procedures 3 and 4.

● To install a new lower knife, the cutting edge of the lower knife should be flush with the top surface of the needle plate.

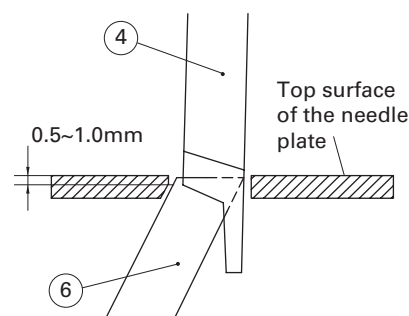


Figure 12 (a)

Adjusting overedge width

1. Loosen screw '1', move lower knife holder '2' all the way to the left and then tighten the screw '1' temporarily.

2. Loosen screw '7', move upper knife clamp '8' left or right as required. Install upper and lower knives by referring to "Replacing the upper knife" procedures 3 and 4.

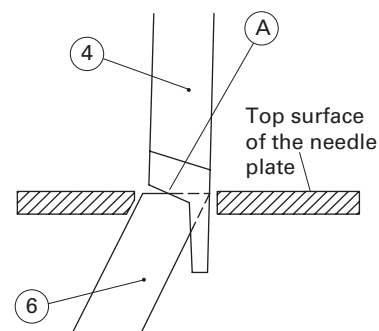


Figure 12 (b)

3.7

Machine Threading

Important

Refer to the sewing type you need for correct threading. Any incorrect threading may cause thread brake, uneven stitches or skip stitches.

3.7.1

Easy Threading Method

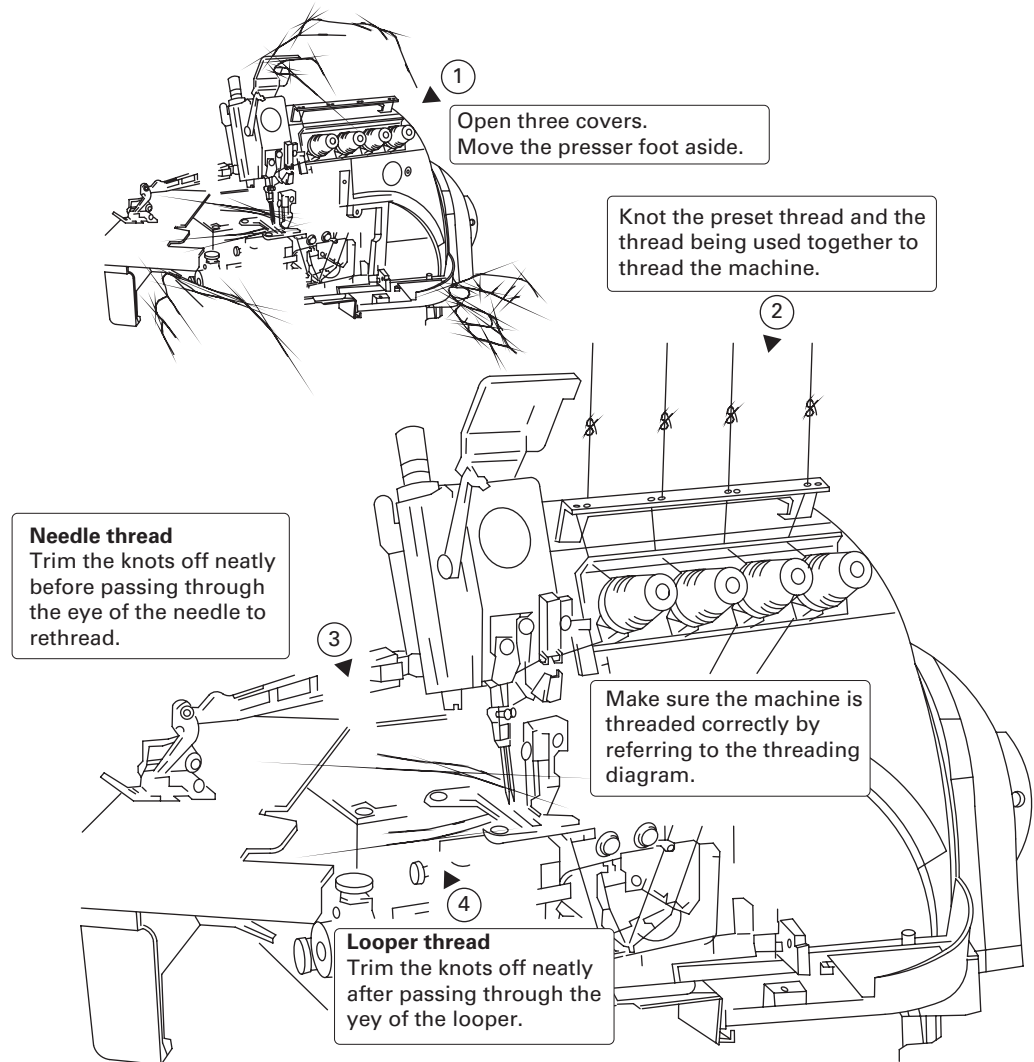


Figure 13

3.7.2

Threading Diagram

For three / four thread machine

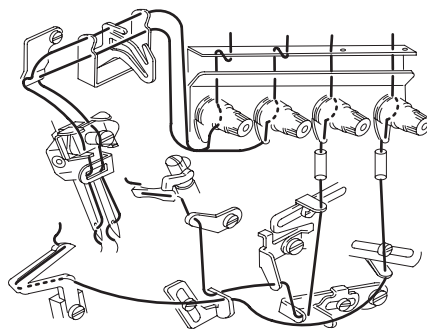


Figure 14

For five thread machine

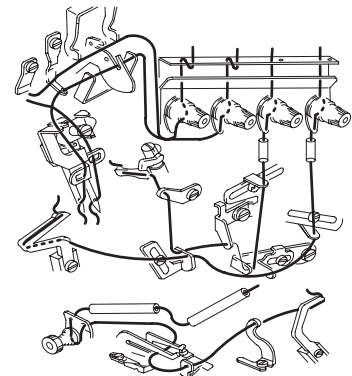


Figure 15

3.8

Thread Tension Adjustment

Important

The thread tension should be adjusted according to the type and thickness of the cloth, sewing thread, sewing width, stitch length and others. Therefore the pressure of the tension nuts or thread guides should be individually adjusted for each case.

The following adjustments are related to Figure 16 & 17.
Tension Nut 1: controls the needle thread or the left thread in case of two needles.
Tension Nut 2: controls the thread in the right needle.
Tension Nut 3: controls the thread in the lower looper.
Tension Nut 4: controls the thread in the lower looper.
Tension Nut 5: controls the thread of the safety stitch.

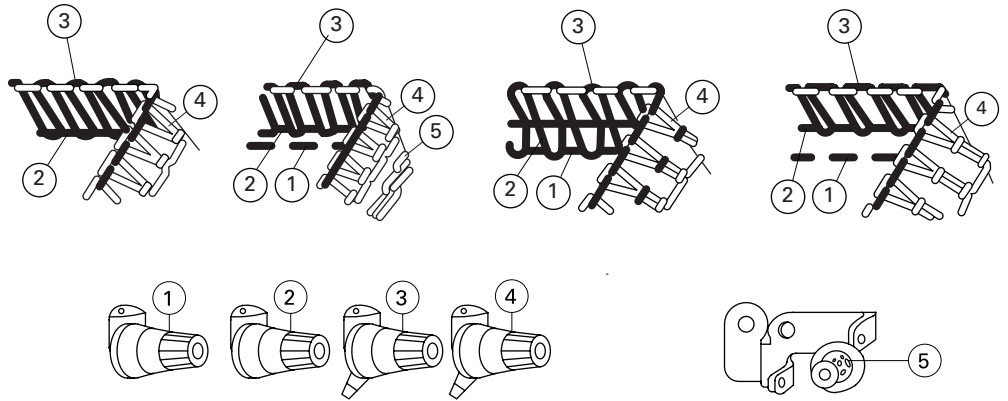


Figure 16

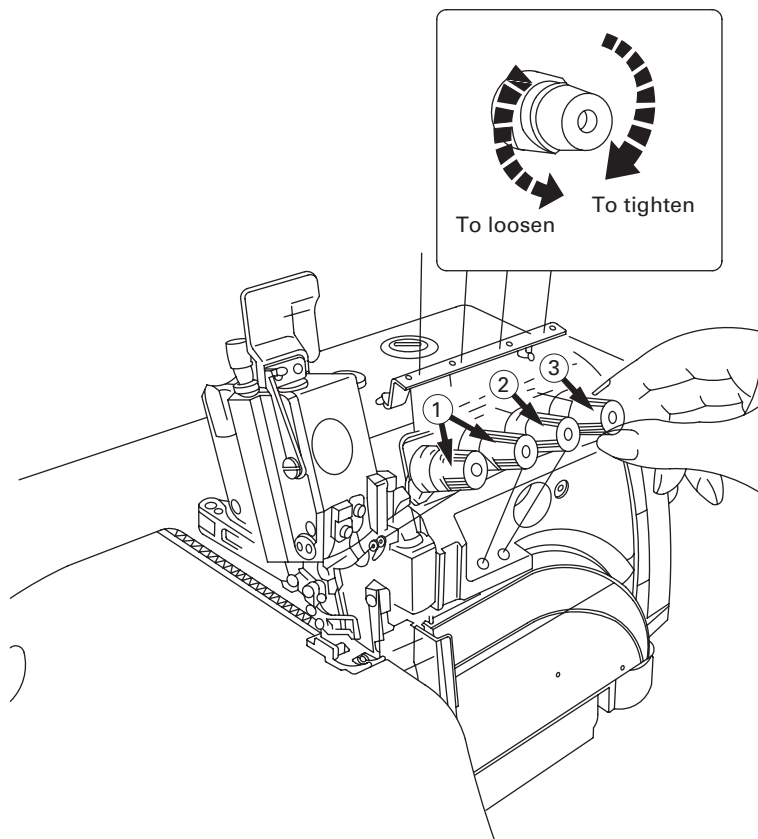


Figure 17

3.9

Presser foot pressure

Loosen adjusting nut '1' of Figure 18 and turn adjusting bar '2' to adjust the presser foot pressure. It

should be as light as possible to be sufficient to obtain the proper stitch formation.

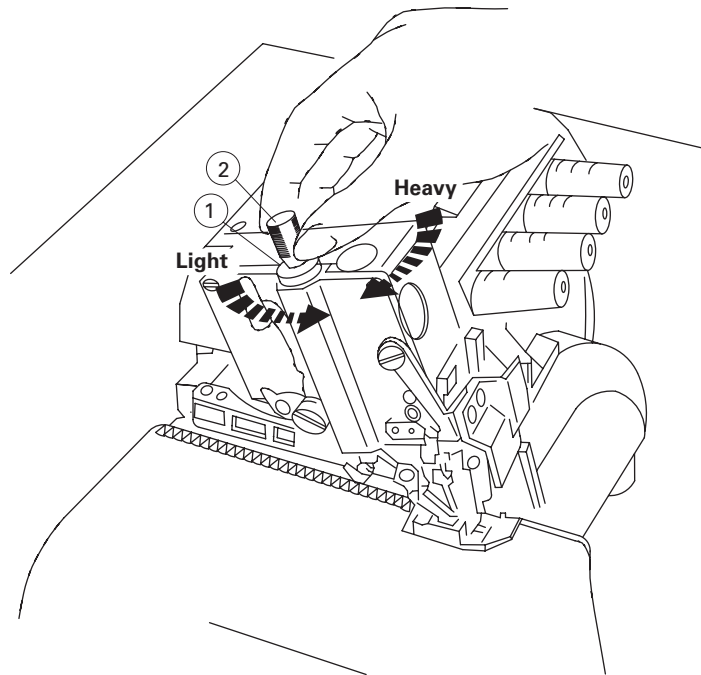


Figure 18

3.10

Adjusting the Differential Feed Rate

The differential feed ratio is the ratio of movements between the main feed dog and differential feed dog. When the movement of main feed dog is bigger than the differential feed dog, the fabric is stretched

at sewing. Otherwise the fabric will be shrunk.

Loosen the adjusting nut 1 and turn the adjusting nut 2 to adjust the differential feed ratio. As shown on Figure 19.

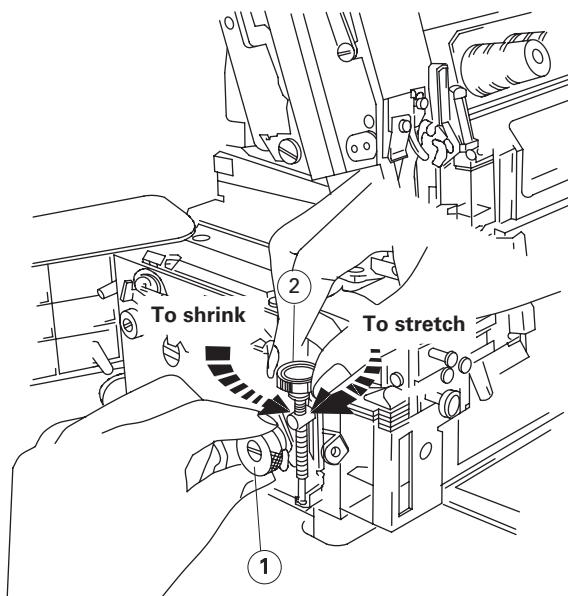


Figure 19

3.11

Stitch Length Adjustment

Important

The stitch length adjustment is made according to the sewing fabric, differential feed ration and other factors.

Press button to the end and keep it pressed as shown on Figure 20.

Turn the handwheel until we have the desired stitch length. It is shown on the handwheel scale.

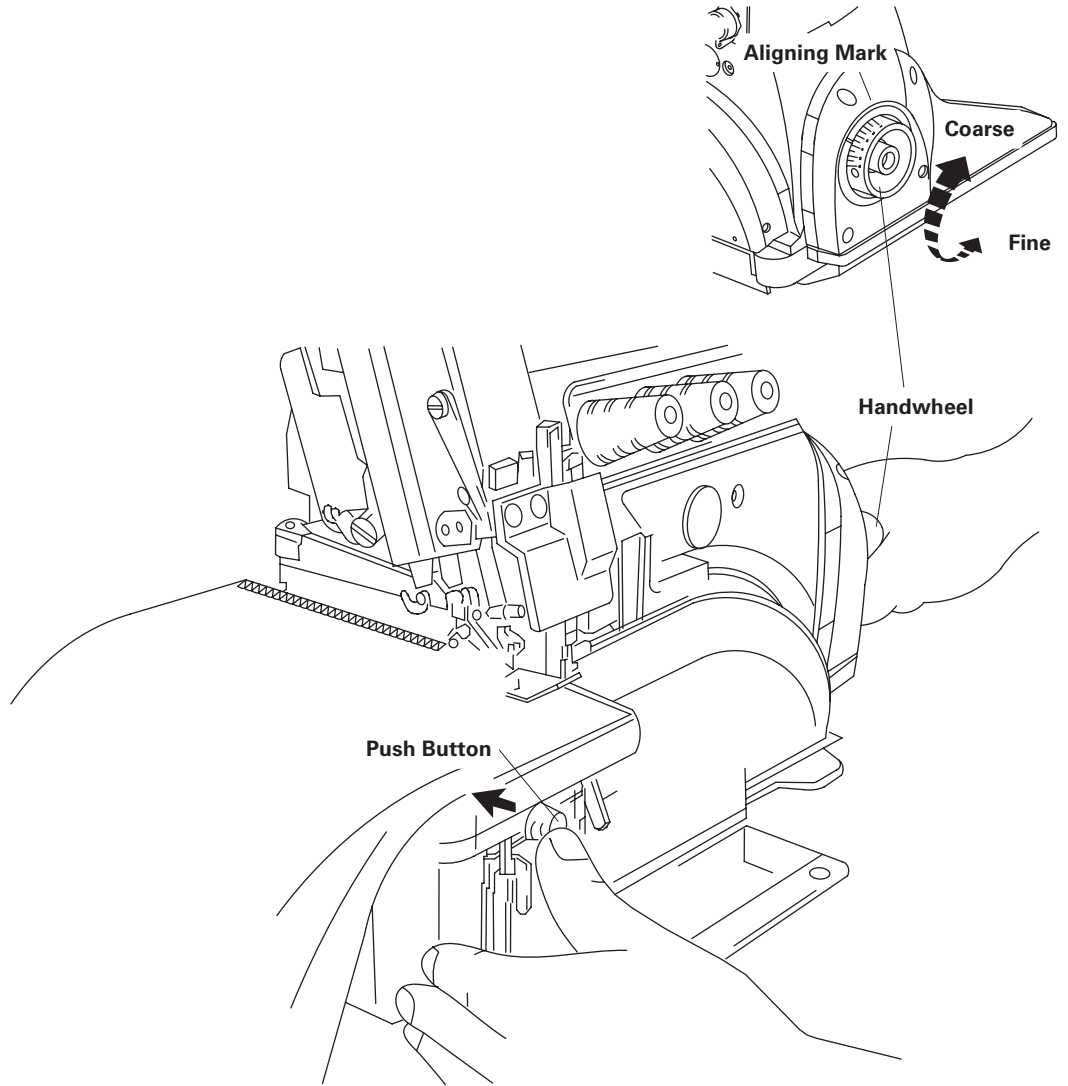


Figure 20

3.12

Parts Relation and Timing

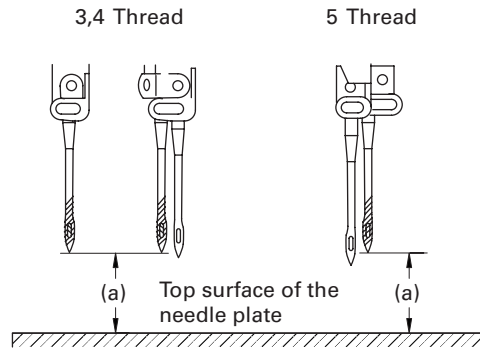


Figure 21

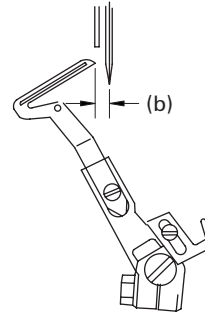


Figure 22

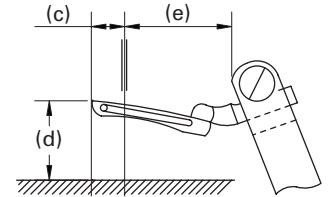


Figure 23

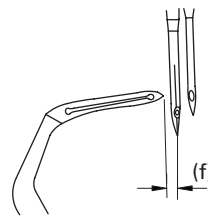


Figure 24

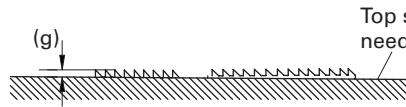


Figure 25

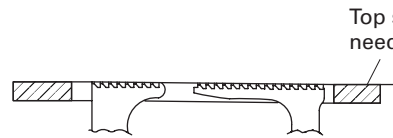


Figure 26

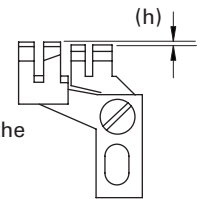


Figure 27

Model 321D & 321K	Height of needle (Figure 21)	Lower looper left limit position (Figure 22)	Upper looper				Chain looper left limit position (f) (Figure 24)	Feed dog		
			Upper looper left limit position (c) (Figure 23)	Height of upper looper (c) (Figure 23)	Upper looper holder left limit position (e) (Figure 23)	Upper looper holder install direction		Height of feed dog (g) (Figure 25)	Height of auxiliary feed dog (h) (Figure 27)	Feed eccentric
-131M-04	10.5	3.8	4.4-4.7	10.8	14.5	Left	-	0.8	0.5	0.35-2.0
-131M-04 / KS	10.5	3.8	4.4-4.7	10.8	14.5	Left	-	0.8	0.5	0.35-2.0
-132M-015	10.5	3.8	4.4-4.7	10.8	14.5	Left	-	0.6-0.7	0.3	0.35-1.7
-134M-04	10.5	3.8	5.4-5.7	10.5	13.5	Right	-	0.8	0.5	0.35-1.7
-241M-24	10.5	3.8	5.4-5.7	10.5	13.5	Right	-	0.8	0.5	0.35-2.0
-241M-24 / KS	10.5	3.8	5.4-5.7	10.5	13.5	Right	-	0.8	0.5	0.35-2.0
-244M-24	10.5	3.8	5.4-5.7	10.5	13.5	Right	-	0.8	0.5	0.35-2.0
-251M-35	10.5	3.8	4.4-4.7	10.8	14.5	Left	1.5	0.8	0.5	0.35-2.0
-251M-35 / KH	10.5	3.8	4.4-4.7	10.8	14.5	Left	1.5	0.8	0.5	0.35-2.0
-251M-55	10.5	3.8	4.4-4.7	10.8	14.5	Left	1.5	0.8	0.5	0.35-2.0
-251H-55 / KH	10.5	3.8	4.4-4.7	10.8	14.5	Left	1.5	0.8	0.5	0.35-2.0
-251H-56	11.9	4.2	5.0-5.3	12	14.5	Left	1.7	0.8	0.5	0.35-2.0
-251H-56 / KH	11.9	4.2	5.0-5.3	12	14.5	Left	1.7	0.8	0.5	0.35-2.0

4

Maintenance

4.1

Machine Head Cleaning

Clean the machine periodically with a soft and dry cloth to remove the excess of dust on the machine head. Do not use any kind of lacquer thinner to wipe the surface.

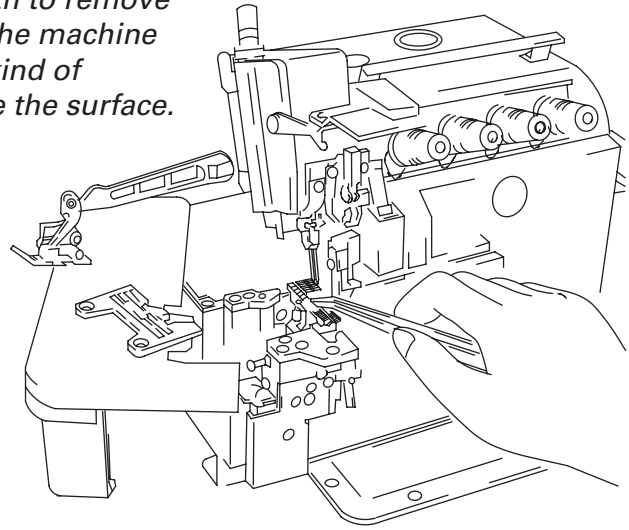


Figure 28

4.2

Oil Change and Filter Cleaning

When Machine is running, oil will be sprayed into the oil window. If no oil sprayed, please check oil level (see topic 3.3)

If the machine was idle for a long time, oil the top of the needle holder, guides and looper guides before resuming the operation.

The oil should be changed every four months. To replace the oil, follow the instructions of topic 3.3.

The oil filter should be cleaned every month or replaced by a new one as necessary. To clean or replace the oil filter, follow the instructions of topic 3.3.

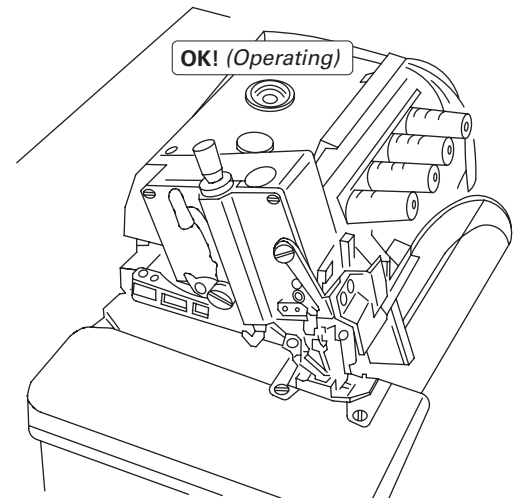


Figure 29

4.3

Safety Inspection

Frequently check if all safety devices are properly installed and adjusted.

Check all screws that fix and hold the machine head that should be properly tight.

Check and be sure the V-belt is not excessively worn out and see that it has the proper tension (Except 321K)

Check and be sure there is no motor overheating and be sure that the cable and electric connector are not damaged.

Problems	Possible Causes	Possible Solutions
Broken needle	1. Needle installed the wrong way.	1. Install the needle correctly.
	2. Wrong kind of needle.	2. Use needle adequate for cloth and thread.
	3. Damaged needle.	3. Replace for a new one.
	4. Wrong relation with needle guards.	4. Adjust needle guards.
	5. Wrong relation with looper.	5. Adjust the looper.
	6. Needle is not centralized with the hole at the needle plate or the presser foot.	6. Adjust the needle plate or the presser foot.
Broken thread	1. Low quality thread.	1. Use good quality thread.
	2. Thread is thicker than the eye of the needle.	2. Use adequate needle to cloth and thread.
	3. Wrong passage of thread.	3. Pass thread correctly.
	4. Thread tension too tight.	4. Adjust the thread tension unit.
	5. Needle wrongly set.	5. Set needle correctly.
	6. Thread stand wrongly set.	6. Set the thread stand correctly.
	7. Needle overheating.	7. Fill in silicon oil or adjust needle guards.
	8. Tension disk or guides with burrs .	8. Replace the parts.
	9. Wrong relation of needle with looper .	9. Adjust the synchronism of needle and looper.
	10. Needle, looper, needle plate and guides have burrs.	10. Replace the part.
Skip stitches	1. Wrong relation of needle with looper.	1. Adjust the relation of needle with looper.
	2. Wrong passage of thread.	2. Pass thread correctly.
	3. Needle installed the wrong way.	3. Install needle correctly.
	4. Inadequate tension of thread.	4. Adjust thread tension button.
	5. Point of looper damaged.	5. Replace the part.
	6. Needle damaged.	6. Replace for a new needle.
	7. Wrong installation of needle guards.	7. Adjust the needle cover.
Failure in stitches	1. Wrong threading.	1. Pass thread correctly.
	2. Thread is thicker than needle hole.	2. Use proper needle hole for cloth and thread.
	3. Wrong thread tension.	3. Adjust the thread tension units.
	4. Needle thread is not lubricated.	4. Fill in the silicon oil.
	5. Wrong relation of needle with looper.	5. Adjust the needle and looper.

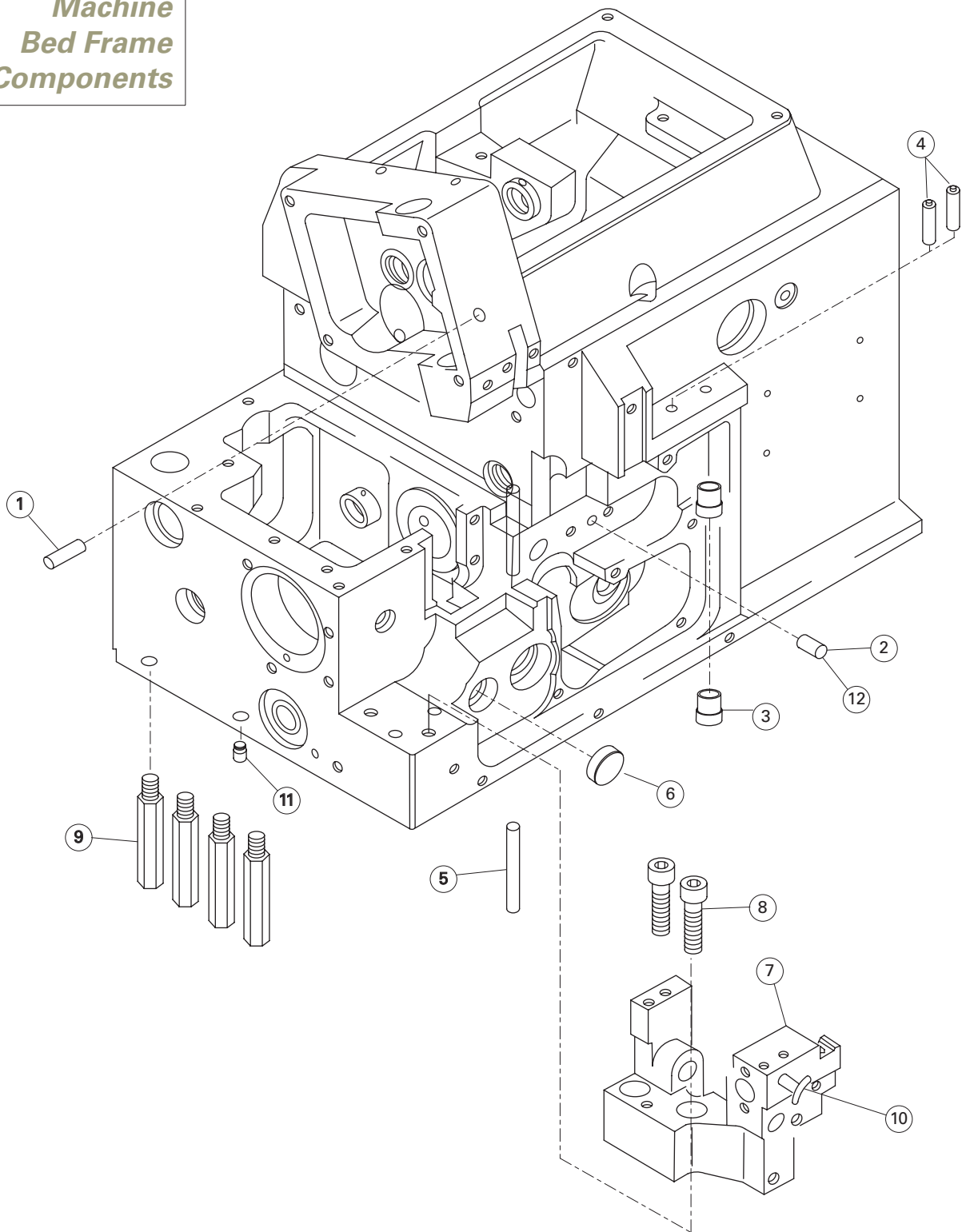
Problems	Possible Causes	Possible Solutions
Uneven Stitches	1. Wrong threading.	1. Threading correctly.
	2. Wrong installation of thread stand.	2. Install thread support correctly.
	3. Wrong setting of lower knife.	3. Adjust lower knife correctly.
	4. Knives does not cut perfectly.	4. Adjust or replace knives.
	5. Thread guide or tension disc with burrs.	5. Replace the part.
	6. Needle point damaged.	6. Replace the needle.
	7. Inadequate height of feed dog.	7. Adjust the height of feed dog.
	8. Inadequate thread tension.	8. Adjust thread tension.
Puckering	1. Thread tension is too strong.	1. Adjust thread tension.
	2. Inadequate pressure on presser foot.	2. Adjust pressure on presser foot.
	3. Inadequate height of feed dog.	3. Adjust the height of feed dog.
	4. Knives does not cut perfectly.	4. Adjust or replace knives.
	5. Differential feed is not correct.	5. Adjust differential feed ratio.
	6. Needle is too thick.	6. Use proper needle to cloth and thread.
Poor chain-off stitches	1. Incorrect presser foot.	1. Adjust presser foot correctly.
	2. Inadequate synchronism of looper cam.	2. Adjust looper cam.
	3. Chain stitch looper installed wrongly.	3. Adjust looper correctly.
	4. Wrong passage of thread.	4. Pass thread correctly.
	5. Thread tension inadequate.	5. Adjust thread tension.
	6. Wrong relation of needle with looper.	6. Adjust relation of needle with looper.
	7. Needle plate or presser foot with burr.	7. Replace the part.
	8. Rough thread tension disc.	8. Polish thread tension disc.

6

Parts list

6.1

Machine
Bed Frame
Components



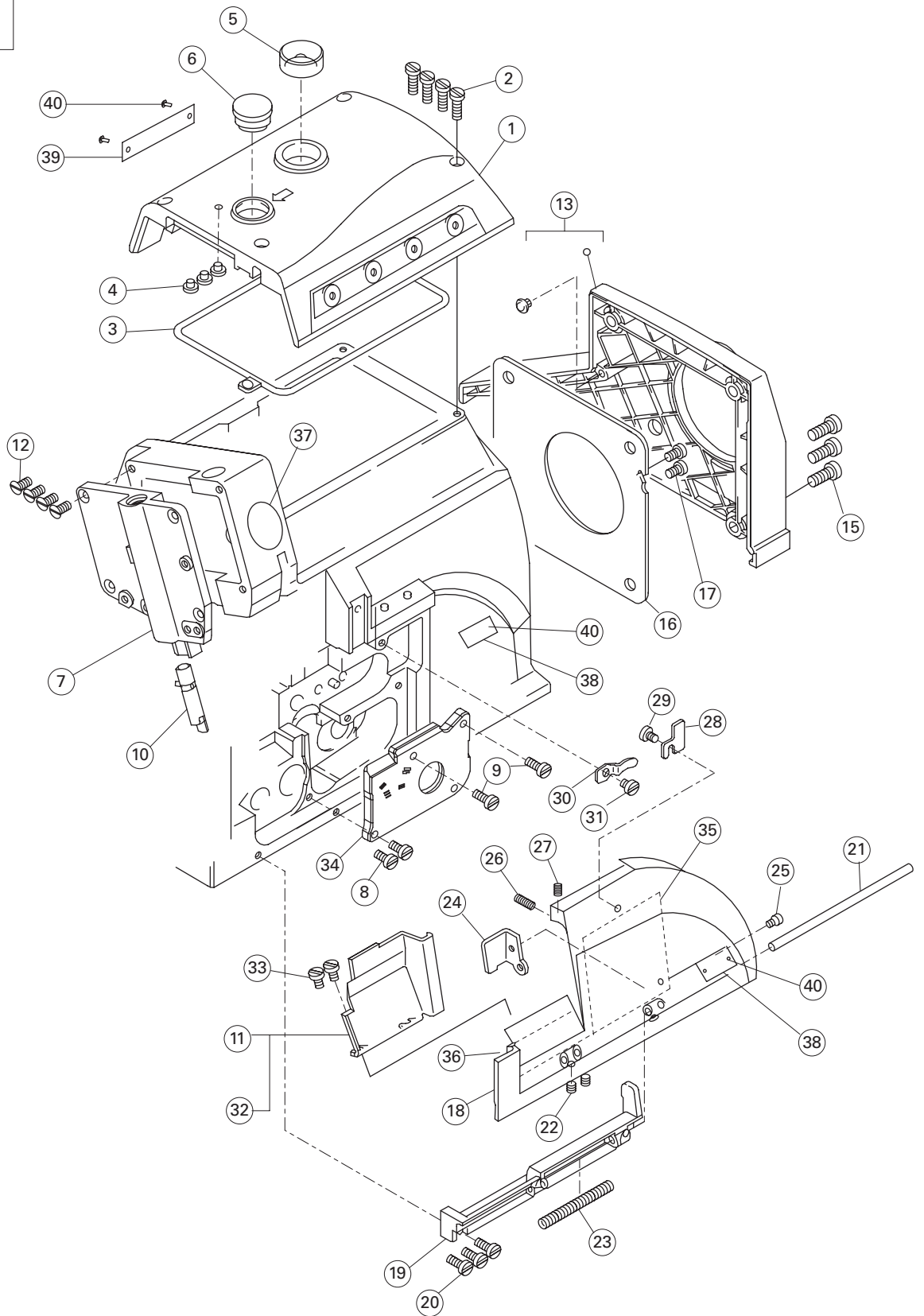
6.1

Machine Bed Frame Components

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	P03010	Pin	1	1	1
2	P03017	Pin	1	1	1
3	20711001	Indicator guide	2	2	2
4	20713027	Pipe	2	2	2
5	P03018	Pin	1	1	1
6	20628023	Plug	1	1	0
7	20701002	Bracket Assembly	1	1	1
8	207S13003	Screw	2	2	2
9	206S30001	Bed pin	4	4	4
10	P03019	Pin	1	1	1
11	20126001	Pin	1	1	1
12	20726009	Pin (for 321D-251H only)	0	0	1

6.2

Machine Cover Components (1)



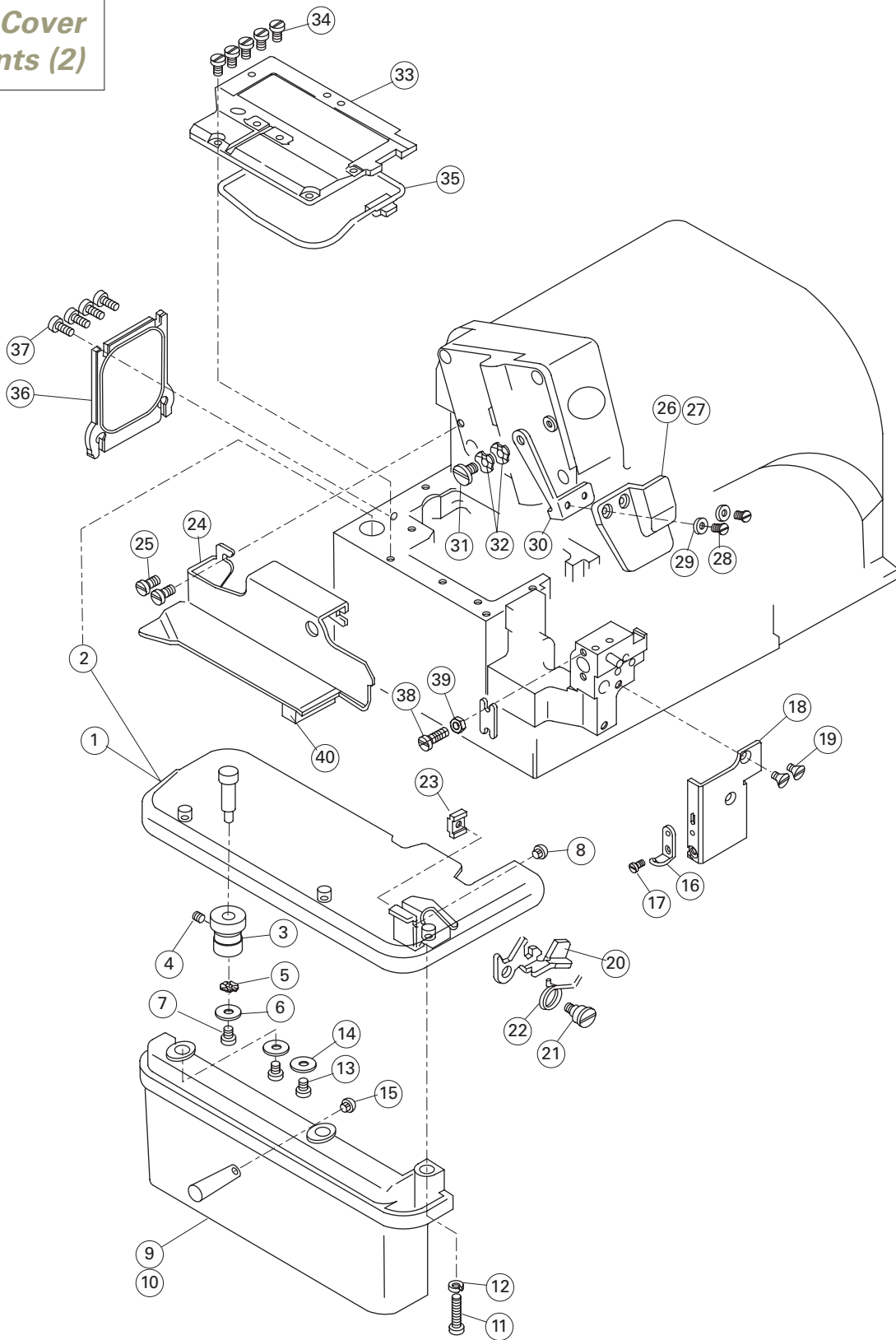
6.2

Machine Cover Components(1)

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20701003	Top cover	1	1	1
2	207S11012	Screw	4	4	4
3	20722001	Gasket	1	1	1
4	20622003	Cushion rubber	3	3	3
5	20711002	Oil sight window	1	1	1
6	20722002	Plug	1	1	1
7	20701004	Side cover	1	1	1
8	207S11012	Screw	2	2	2
9	207S11008	Screw	2	2	2
10	2070201100	Presser bar	1	1	1
11	20712043	Front cover (left)	0	0	1
12	207S17001	Screw	4	4	4
13	20711003	Belt cover assembly	1	1	1
15	S01013	Screw	3	3	3
16	20712001	Fan cover	1	1	1
17	207S11007	Screw	1	1	1
18	20701005	Front cover (right)	1	1	1
19	20701006	Hinge	1	1	1
20	207S11008	Screw	3	3	3
21	20626001	Pin	1	1	1
22	207S14001	Screw	2	2	2
23	20627001	Spring	1	1	1
24	20712002	Latch	1	1	1
25	207S11009	Screw	1	1	1
26	207S14002	Screw	1	1	1
27	207S14003	Screw	1	1	1
28	20712003	Latch	1	1	1
29	207S01031	Screw	1	1	1
30	20612004	Flat spring	1	1	1
31	S01031	Screw	1	1	1
32	20712004	Front cover (left)	1	1	0
33	207S11011	Screw	2	2	2
34	20712005	Side cover	1	1	1
35	20737006	Threading diagram	1	1	1
36	20737007	Threading diagram	0	0	1
37	J900112-001	Singer S cameo	1	1	1
38	J900321-0XX	Model plate	2	2	2
39	J900112-002	Singer resin plate	1	1	1
40	R03001	Revit	6	6	6

6.3

Machine Cover Components (2)



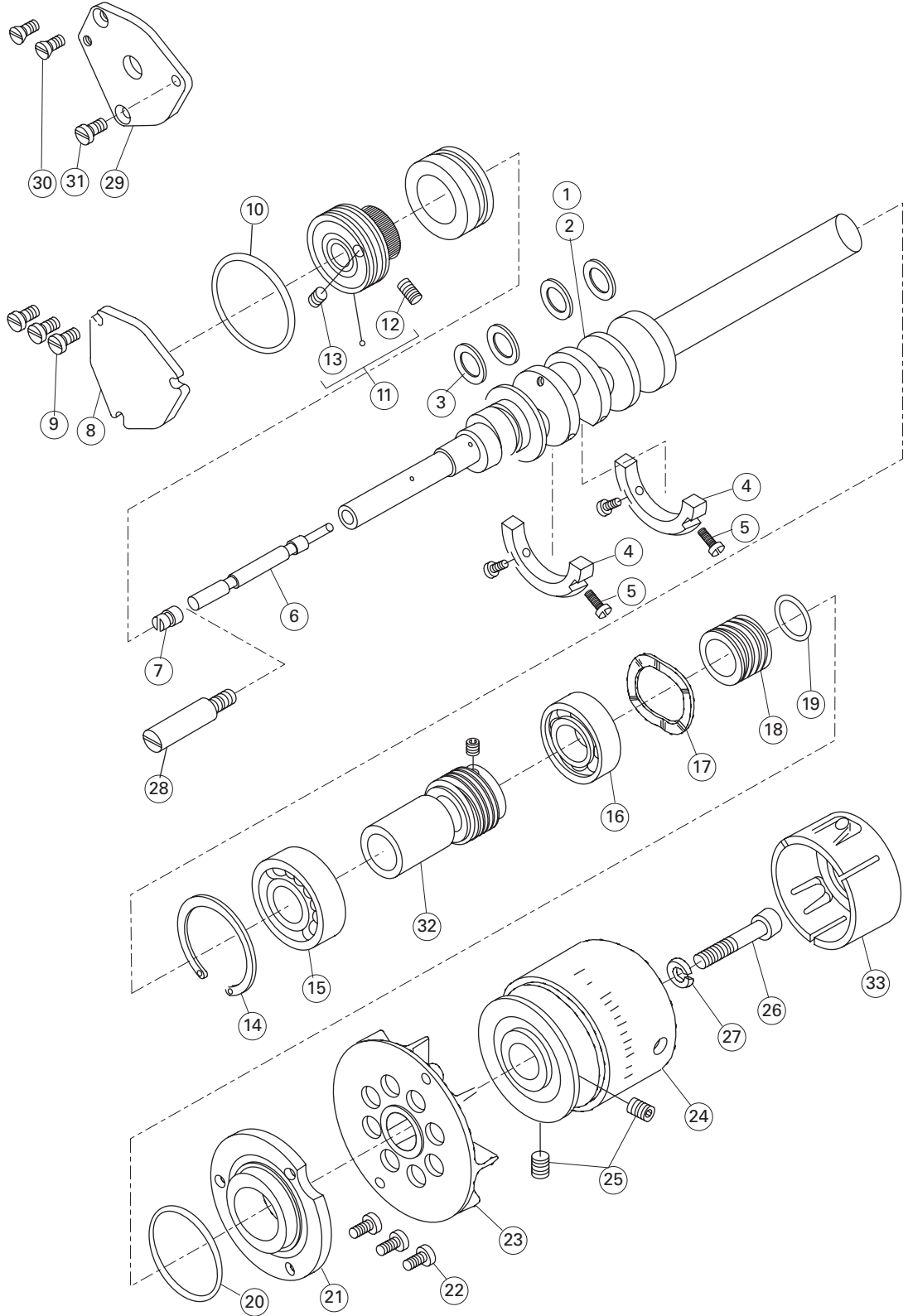
6.3

Machine Cover Components (2)

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	2071204400	Cloth plate	0	0	1
2	2071200600	Cloth plate	1	1	0
3	20703010	Bushing	1	1	1
4	207S14001	Screw	1	1	1
5	W02004	Washer	1	1	1
6	30228008	Washer	1	1	1
7	207S11011	Screw	1	1	1
8	20622003	Cushion rubber	1	1	1
9	20711018	Side cover (Wide)	0	0	1
10	20711004	Side cover (Narrow)	1	1	0
11	207S11013	Screw	1	1	1
12	W02002	Spring washer	1	1	1
13	207S11011	Screw	2	2	2
14	20528017	Washer	2	2	2
15	20622003	Cushion rubber	1	1	1
16	20612016	Latch	1	1	1
17	207S11014	Screw	1	1	1
18	20712008	Plate	1	1	1
19	207S17003	Screw	2	2	2
20	20712009	Lever	1	1	1
21	207S20001	Screw	1	1	1
22	20727001	Spring	1	1	1
23	20709001	Bracket	1	1	1
24	20712010	Fabric guide	1	1	1
25	207S11007	Screw	2	2	2
26	20711005	Eye guide	1	1	0
27	20711019	Eye guide	0	0	1
28	207S11015	Screw	2	2	2
29	W01011	Washer	2	2	2
30	20712011	Bracket	1	1	1
31	207S20002	Screw	1	1	1
32	20628022	Washer	2	2	2
33	20701007	Bed cover plate assembly	1	1	1
34	207S12001	Screw	5	5	5
35	20722003	Gasket	1	1	1
36	2071201200	Cover plate	1	1	1
37	207S11012	Screw	4	4	4
38	207S11016	Screw	1	1	1
39	N01001	Nut	1	1	1
40	10122020	Oil Reservoir Cushion	1	1	1

6.4

Crank Shaft Drive Components



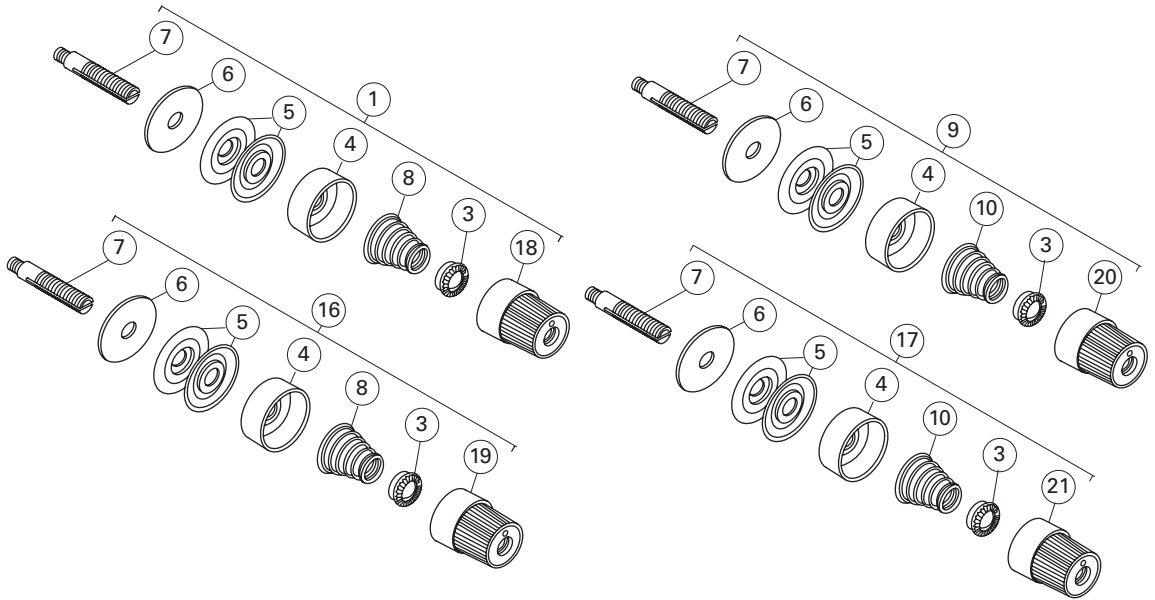
6.4

Crank Shaft Drive Components

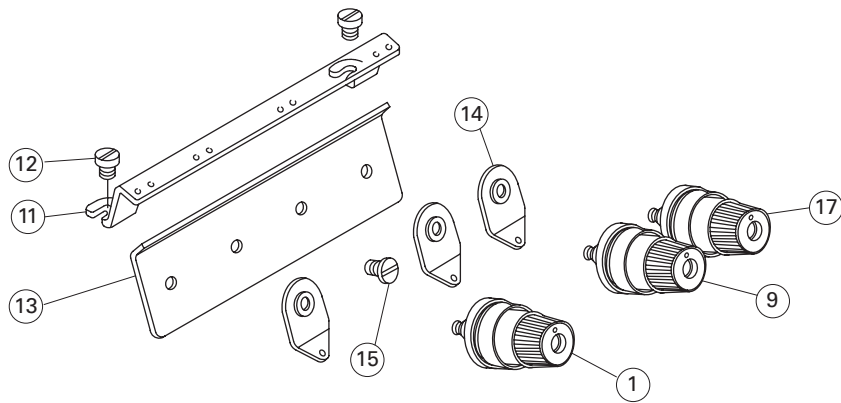
No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20702001	Crankshaft	1	1	1
2	20702050	Crankshaft (for 321D-251H / 321K-251H only)	0	0	1
3	20628007	Washer	4	4	4
4	20701008	Blance weight	2	2	2
5	207S11017	Screw	4	4	4
6	20726002	Pin	1	1	1
7	S10009	Screw	1	1	0
8	20712013	Cover	1	1	0
9	207S11007	Screw	3	3	0
10	001024	O Ring	1	1	1
11	B04004	Ball bearing assembly	1	1	1
12	207S11018	Screw	1	1	1
13	207S14006	Screw	1	1	1
14	20729001	Ring	1	1	1
15	B01012	Ball bearing	1	1	1
16	B04005	Ball bearing	1	1	1
17	W03003	Washer	4	4	4
18	20103002	Oil seal	1	1	1
19	001025	O ring	1	1	1
20	001028	O ring	1	1	1
21	20708002	Right cover	1	1	1
22	207S11012	Screw	3	3	3
23	20709001	Fan assembly	1	1	1
24	207350022	Machine pulley	1	1	1
25	S10009	Screw	2	2	2
26	207S13004	Screw	1	1	1
27	W02004	Spring washer	1	1	1
28	20602002	Pin	0	0	1
29	20712046	Cover	0	0	1
30	207S17001	Screw	0	0	2
31	207S11012	Screw	0	0	1
32	20708003	Spacer	1	1	1
33	20701009	Cover	1	1	1

6.5

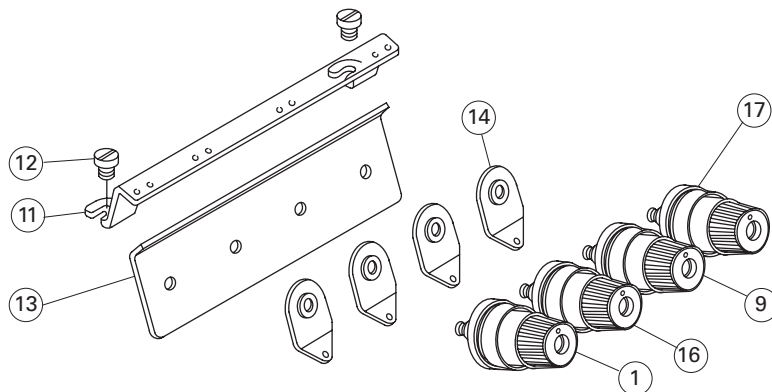
Thread Tension Components



For 1-needle



For 2-needle



6.5

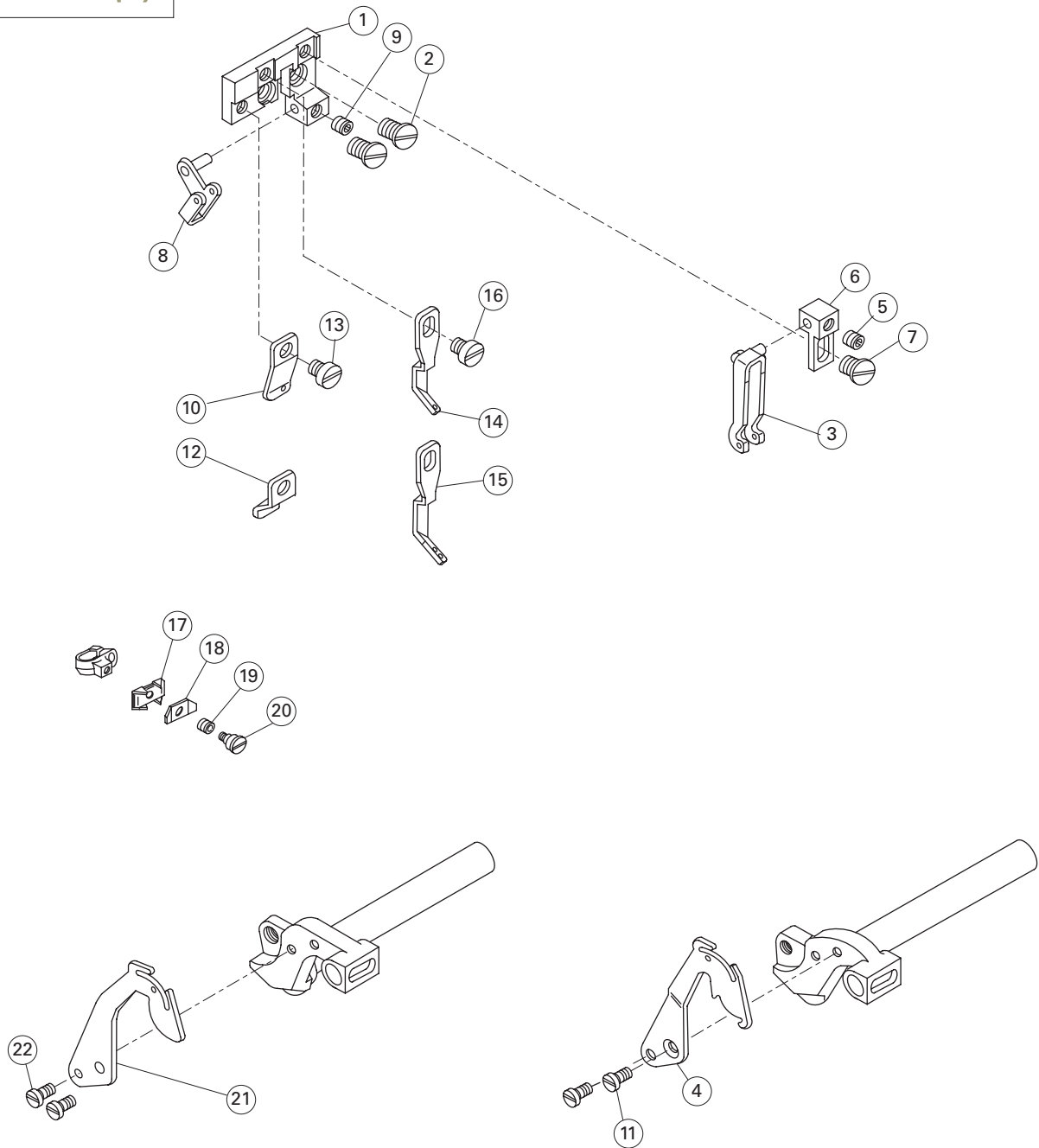
Thread Tension Components

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	2071100400	Tension spring assembly	1	1	1
3	30111006	Ratchet	3	4	4
4	301110052	Cup	3	4	4
5	30128016	Tension disc	6	8	8
6	20623008	Felt	3	4	4
7	201S30016	Screw stud	3	4	4
8	20727011	Spring	1	2	2
9	2071100500	Tension spring assembly	1	1	1
10	30127013	Spring	2	2	2
11	20713001	Thread guide	1	1	1
12	207S11007	Screw	2	2	2
13	20712015	Thread guide	1	1	1
14	20612052	Tension guide	3	4	4
15	207S110014	Screw	1	0	0
16	2071100300	Tension spring assembly	0	1	1
17	2071100700	Tension spring assembly	1	1	1
18	301S160062R	Knob (red dot)	1	1	1
19	301S160062Y	Knob (Yellow dot)	0	1	1
20	301S160062B	Knob (blue dot)	1	1	1
21	301S160062G	Knob (Green dot)	1	1	1

6.6

Thread Guide and Thread Take-up Components (1)

For 5-thread



6.6

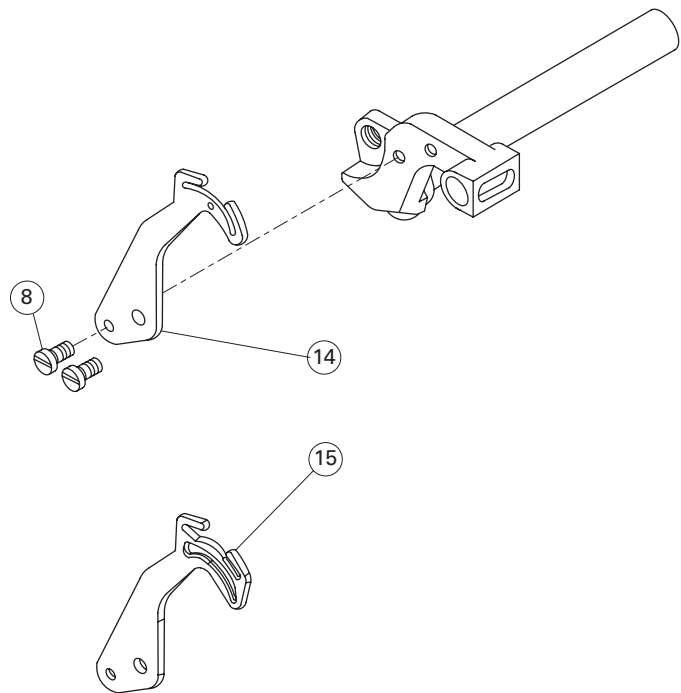
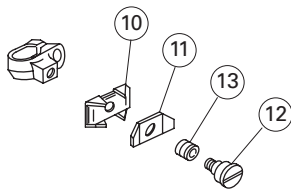
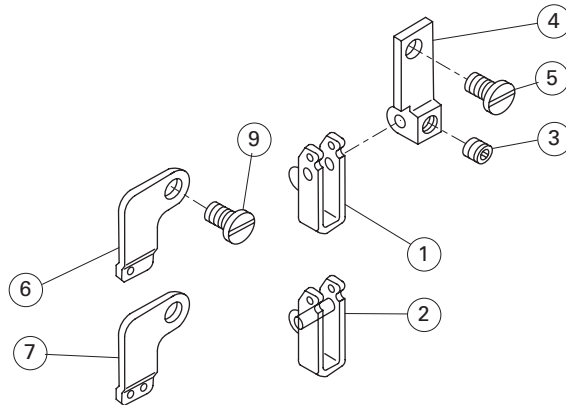
Thread Guide and Thread Take-up Components (1)

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20701029	Bracket	0	0	1
2	207S11019	Screw	0	0	2
3	20713020	Thread guide (for 321D-251H / 321K-251H only)	0	0	1
4	20713052	Thread take-up (for 321D-251H / 321K-251H only)	0	0	1
5	207S14001	Screw	0	0	1
6	20701030	Bracket	0	0	1
7	S01031	Screw	0	0	1
8	20713021	Thread guide	0	0	1
9	207S14001	Screw	0	0	1
10	20713022	Thread guide (except 321D-251H / 321K-251H)	0	0	1
11	207S11015	Screw (for 321D-251H / 321K-251H only)	0	0	2
12	20713050	Thread guide (for 321D-251H / 321K-251H only)	0	0	1
13	S01031	Screw	0	0	1
14	20713023	Thread guide (except 321D-251H / 321K-251H)	0	0	1
15	20713051	Thread guide (for 321D-251H / 321K-251H only)	0	0	1
16	S01031	Screw	0	0	1
17	20713006	Bracket	0	0	1
18	20713007	Thread retainer	0	0	1
19	207S20003	Screw	0	0	1
20	20727002	Spring	0	0	1
21	20713024	Thread take-up (except 321D-251H / 321K-251H)	0	0	1
22	207S11015	Screw (except 321D-251H / 321K-251H)	0	0	2

6.7

Thread Guide and Thread Take-up Components (2)

For 3-thread and 4-thread



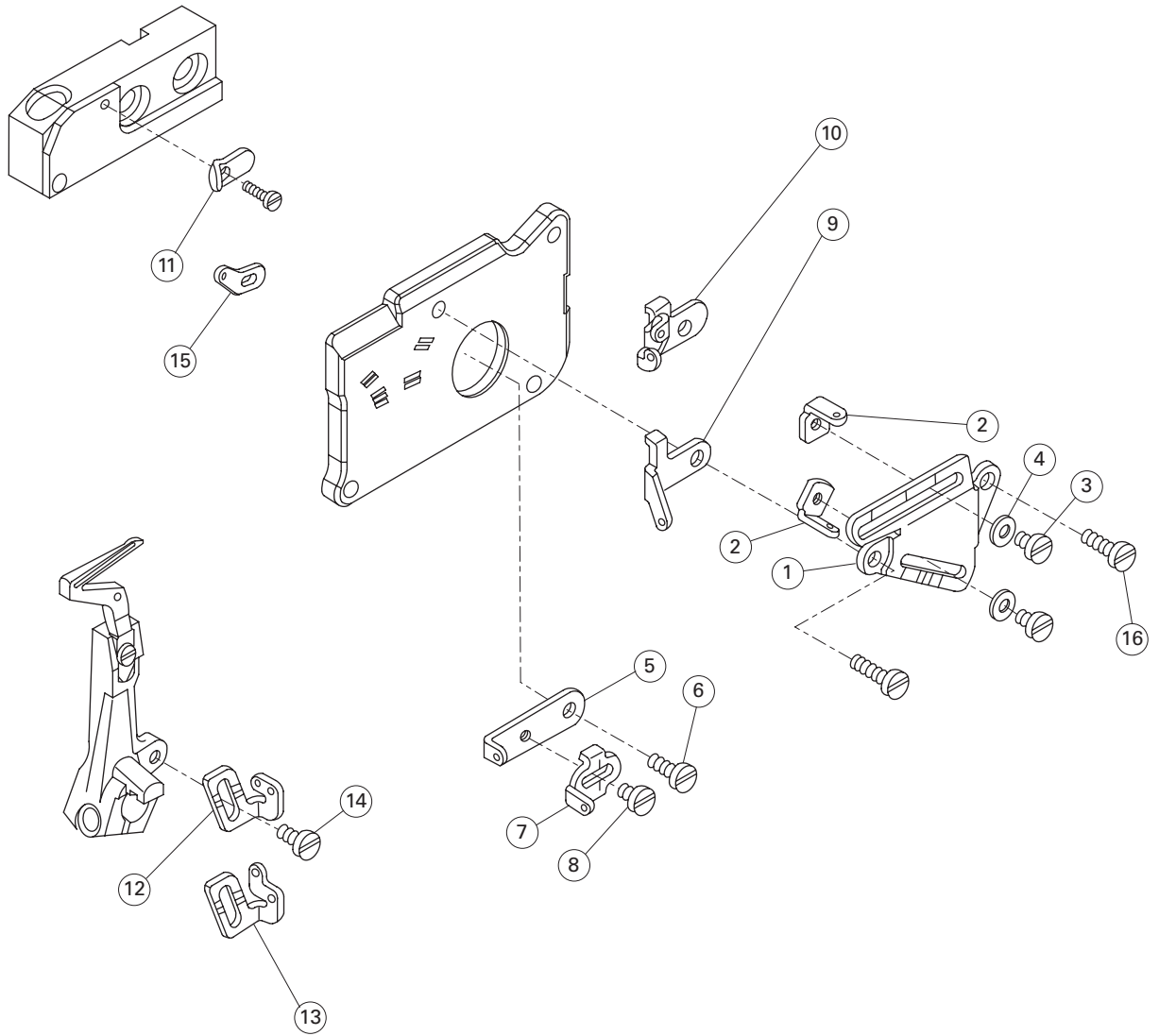
6.7

Thread Guide and Thread Take-up Components (2)

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20713002	Thread guide	1	0	0
2	20713003	Thread guide	0	1	0
3	207S14001	Screw	1	1	0
4	20701010	Bracket	1	1	0
5	207S11019	Screw	1	1	0
6	20713004	Thread eyelet	1	0	0
7	20713005	Thread eyelet	0	1	0
8	207S11015	Screw	2	2	0
9	207S11019	Screw	1	1	0
10	20713006	Bracket	1	1	0
11	20713007	Thread retainer	1	1	0
12	207S20003	Screw	1	1	0
13	20727002	Spring	1	1	0
14	20713008	Thread take-up	1	0	0
15	20713009	Thread take-up	0	1	0

6.8

Thread Guide and Thread Take-up Components (3)



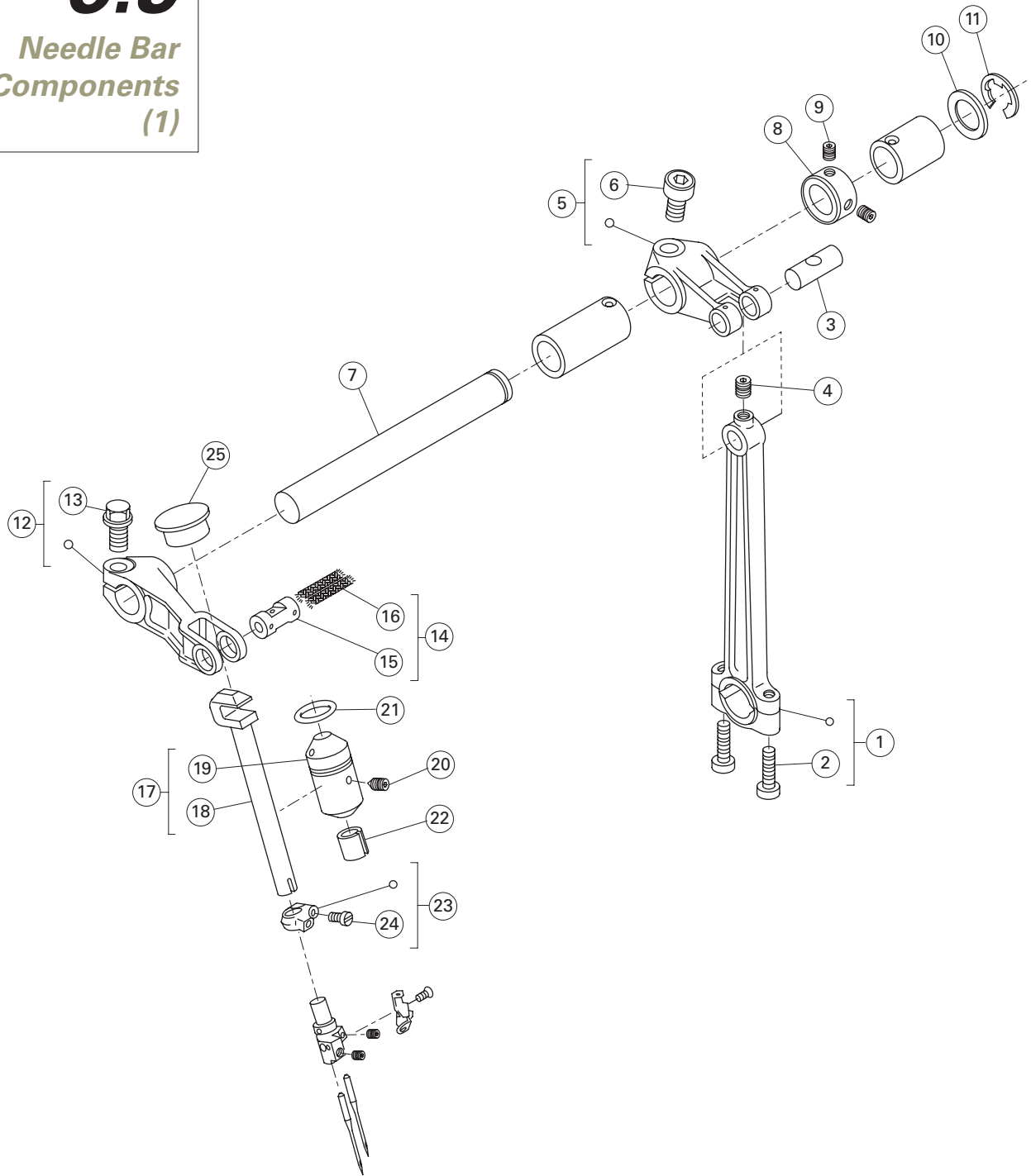
6.8

Thread Guide and Thread Take-up Components (3)

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20712016	Bracket	1	1	1
2	20113015	Thread guide	2	2	2
3	201S11006	Screw	2	2	2
4	W01011	Washer	2	2	2
5	20713010	Thread take-up	1	1	1
6	207S11007	Screw	1	1	1
7	20713011	Thread eyelet	1	1	1
8	207S11020	Screw	1	1	1
9	20713012	Thread guide	1	1	1
10	20713053	Thread guide (for 321D-251H / 321K-25H only)	0	0	1
11	20713054	Thread guide (for 321D-251H / 321K-25H only)	0	0	1
12	20713015	Thread take-up	1	1	1
13	20713055	Thread take-up (for 321D-251H / 321K-25H only)	0	0	1
14	207S11021	Screw	1	1	1
15	20713013	Thread guide	1	1	1

6.9

Needle Bar Components (1)



6.9

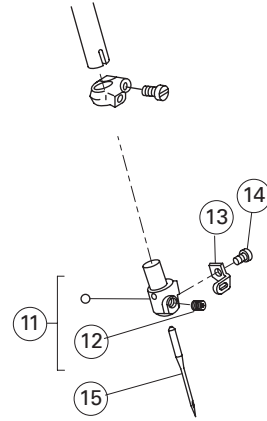
Needle Bar Components (1)

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20705001	Connection assembly	1	1	1
2	207811016	Screw	2	2	2
3	20626003	Pin	1	1	1
4	207814007	Screw	1	1	1
5	20704001	Crank assembly	1	1	1
6	S05018	Screw	1	1	1
7	20702002	Shaft	1	1	1
8	20708004	Collar	1	1	1
9	207814001	Screw	2	2	2
10	20628014	Washer	1	1	1
11	H05008	Ring	1	1	1
12	2070400200	Lever assembly	1	1	1
13	207812002	Screw	1	1	1
14	2072600300	Shaft assembly	1	1	1
15	20726003	Shaft	1	1	1
16	20523005	Oil wick	1	1	1
17	207200300	Needle bar bushing assembly	1	1	1
18	20702003	Needle Bar	1	1	1
19	20703012	Bushing	1	1	1
20	207814008	Screw	1	1	1
21	001026	O ring	1	1	1
22	20723003	Oil felt	1	1	1
23	20708005	Ring assembly	1	1	1
24	207811023	Screw	1	1	1
25	20722004	Plug	1	1	1

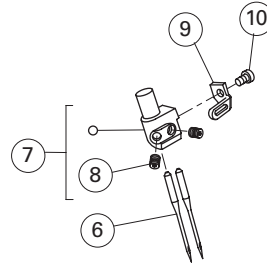
6.10

Needle Bar Components (2)

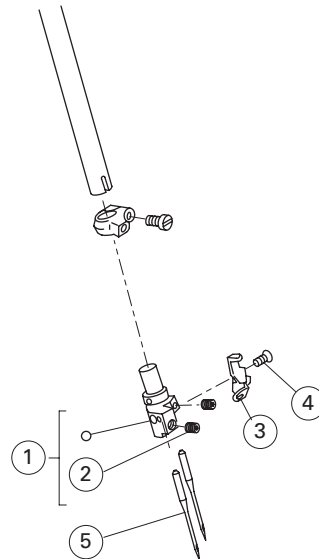
For 3 thread



For 4 thread



For 5 thread



6.10

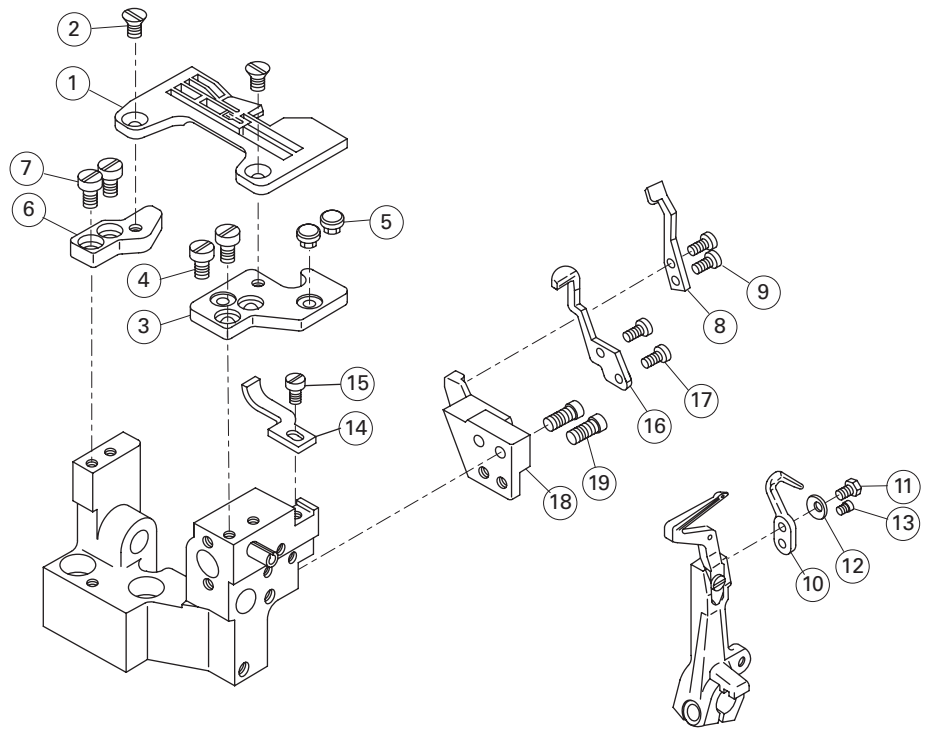
Needle Bar Components (2)

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	XXXXXXXXXX	Needle holder assembly	0	0	1
2	207S14009	Screw	0	0	2
3	20713017	Thread guide (except 321D-251H / 321K-251H)	0	0	1
4	207S11024	Screw	0	0	1
5	XXXXXXXXXX	Needle	0	0	2
6	XXXXXXXXXX	Needle	0	2	0
7	XXXXXXXXXX	Needle holder assembly	0	1	0
8	207S14009	Screw	0	2	0
9	20713018	Thread guide	0	1	0
10	207S11024	Screw	0	1	0
11	XXXXXXXXXX	Needle holder assembly	1	0	0
12	207S14009	Screw	1	0	0
13	20713038	Thread guide	1	0	0
14	207S11024	Screw	1	0	0
15	XXXXXXXXXX	Needle	1	0	0

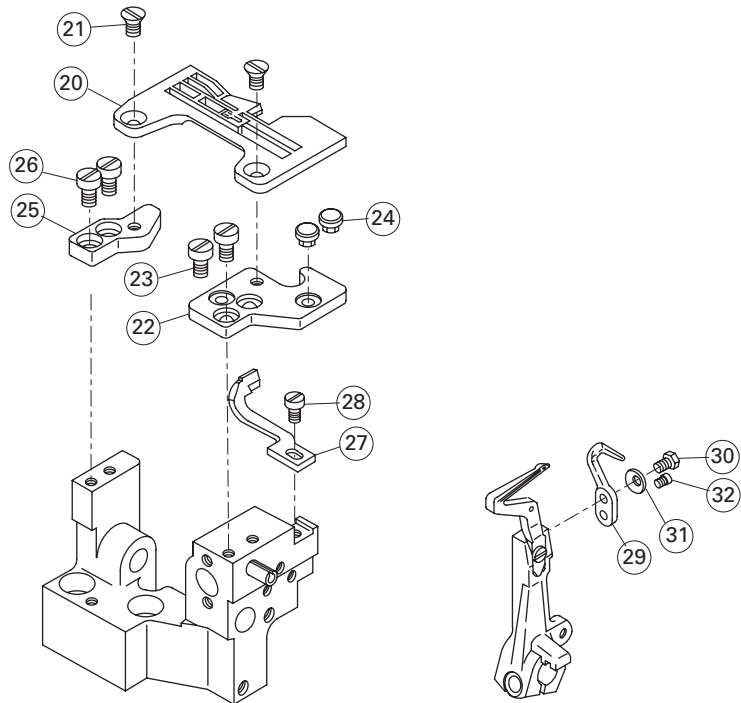
6.11

Needle Plate and Needle Guard Components

For 5-thread



For 3-thread / 4-thread



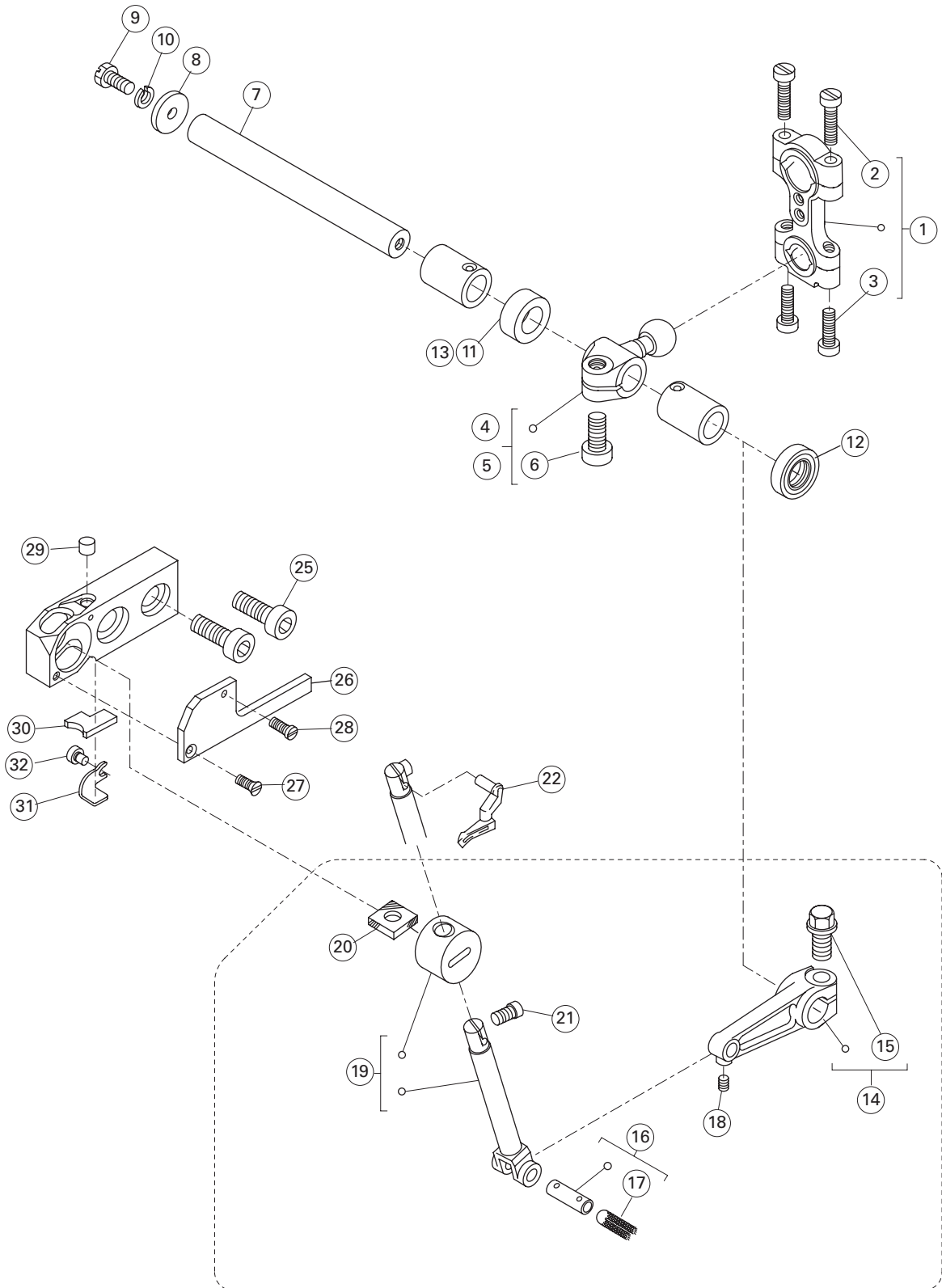
6.11

Needle Plate and Needle Guard Components

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	XXXXXXXXXX	Needle plate	0	0	1
2	207S17003	Screw	0	0	2
3	20709002	Bracket (Front)	0	0	1
4	207S11007	Screw	0	0	2
5	20622003	Cushion rubber	0	0	2
6	20709003	Bracket (Rear)	0	0	1
7	207S11007	Screw	0	0	2
8	XXXXXXXXXX	Needle guard (Front)	0	0	1
9	S01027	Screw	0	0	2
10	XXXXXXXXXX	Needle guard (Rear)	0	0	1
11	207S12005	Screw	0	0	1
12	W03004	spring	0	0	1
13	207S11002	Screw	0	0	1
14	XXXXXXXXXX	Needle guard (Front)	0	0	1
15	207S11007	Screw	0	0	1
16	XXXXXXXXXX	Needle guard (Rear)	0	0	1
17	S01027	Screw	0	0	2
18	20701033	Bracket	0	0	1
19	207S11003	Screw	0	0	2
20	XXXXXXXXXX	Needle plate	1	1	0
21	207S17003	Screw	2	2	0
22	20709002	Bracket (Front)	1	1	0
23	207S11007	Screw	2	2	0
24	20622003	Cushion rubber	2	2	0
25	20709003	Bracket (Rear)	1	1	0
26	207S11007	Screw	2	2	0
27	XXXXXXXXXX	Needle guard (Front)	1	1	0
28	207S11007	Screw	1	1	0
29	XXXXXXXXXX	Needle guard (Rear)	1	1	0
30	207S12005	Screw	1	1	0
31	W03004	spring	1	1	0
32	207S11002	Screw	1	1	0

6.12

Upper Looper Components



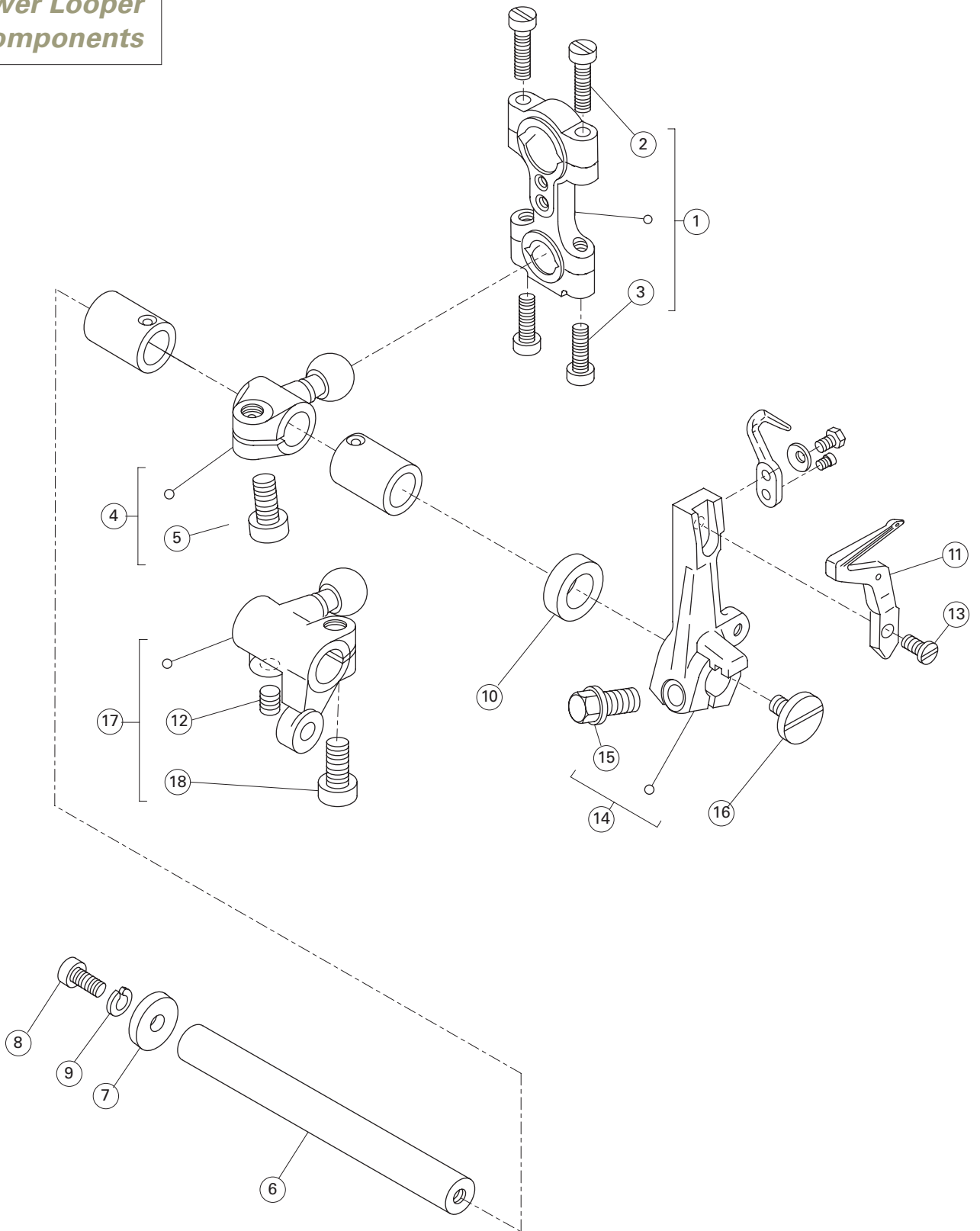
6.12

Upper Looper Components

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20705002	Connection assembly	1	1	1
2	207S11016	Screw	2	2	2
3	207S11005	Screw	2	2	2
4	20704003	Crank assembly	1	0	0
5	20704004	Crank assembly	0	1	1
6	S05018	Screw	1	1	1
7	20702004	Shaft	1	1	1
8	20628006	Washer	1	1	1
9	207S11004	Screw	1	1	1
10	20628005	Spring washer	1	1	1
11	20708006	Spacer	0	1	0
12	20622019	Oil Seal	1	1	1
13	20708007	Spacer	1	0	1
14	20705003	Lever assembly	1	1	1
15	207S12002	Screw	1	1	1
16	20726004	Pin assembly	1	1	1
17	20523005	Oil wick	1	1	1
18	207S14010	Screw	1	1	1
19	20704005	Upper looper holder assembly	1	1	1
20	20623005	Felt	1	1	1
21	207S11025	Screw	1	1	1
22	XXXXXXXX	Upper looper	1	1	1
25	207S11026	Screw	2	2	2
26	20715007	Cover	1	1	1
27	207S17004	Screw	1	1	1
28	207S11027	Screw	1	1	1
29	20123021	Oil wick	1	1	1
30	20723005	Felt	1	1	1
31	20712017	Bracket	1	1	1
32	207S11020	Screw	1	1	1

6.13

Lower Looper Components



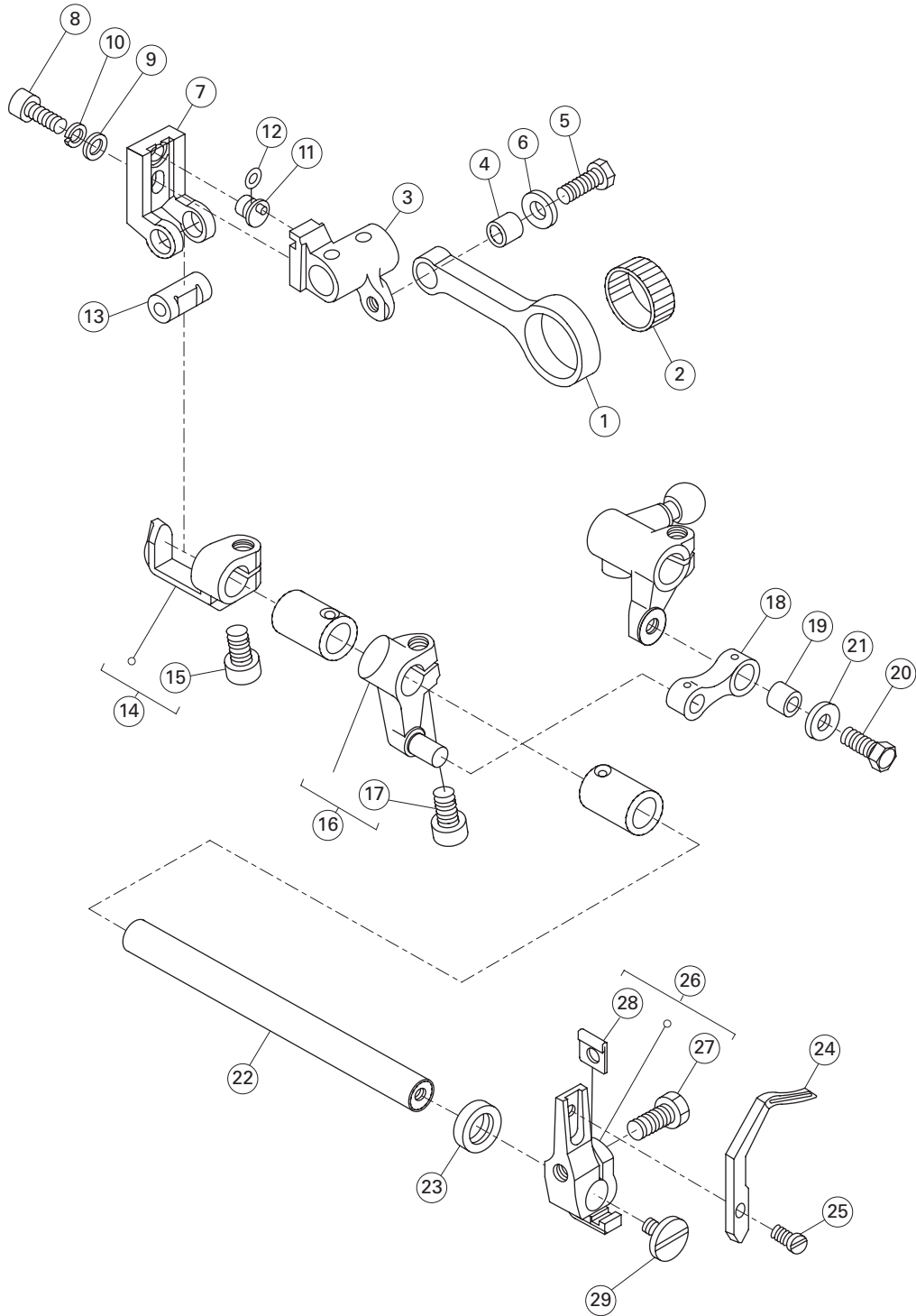
6.13

Lower Looper Components

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20705002	Connection assembly	1	1	1
2	207S11016	Screw	2	2	2
3	207S11005	Screw	2	2	2
4	20704006	Crank assembly	1	1	0
5	S05018	Screw	1	1	0
6	20702004	Shaft	1	1	1
7	20628006	Washer	1	1	1
8	207S11004	Screw	1	1	1
9	20628005	Spring washer	1	1	1
10	20622019	Oil seal	1	1	1
11	XXXXXXXX	Lower looper	1	1	1
12	207S14006	Screw	0	0	1
13	207S11028	Screw	1	1	1
14	20704007	Lower looper holder assembly	1	1	1
15	207S20004	Screw	1	1	1
16	207S15001	Screw	1	1	1
17	20704013	Crank assembly	0	0	1
18	S05018	Screw	0	0	1

6.14

Chain Stitch Looper Components (1)



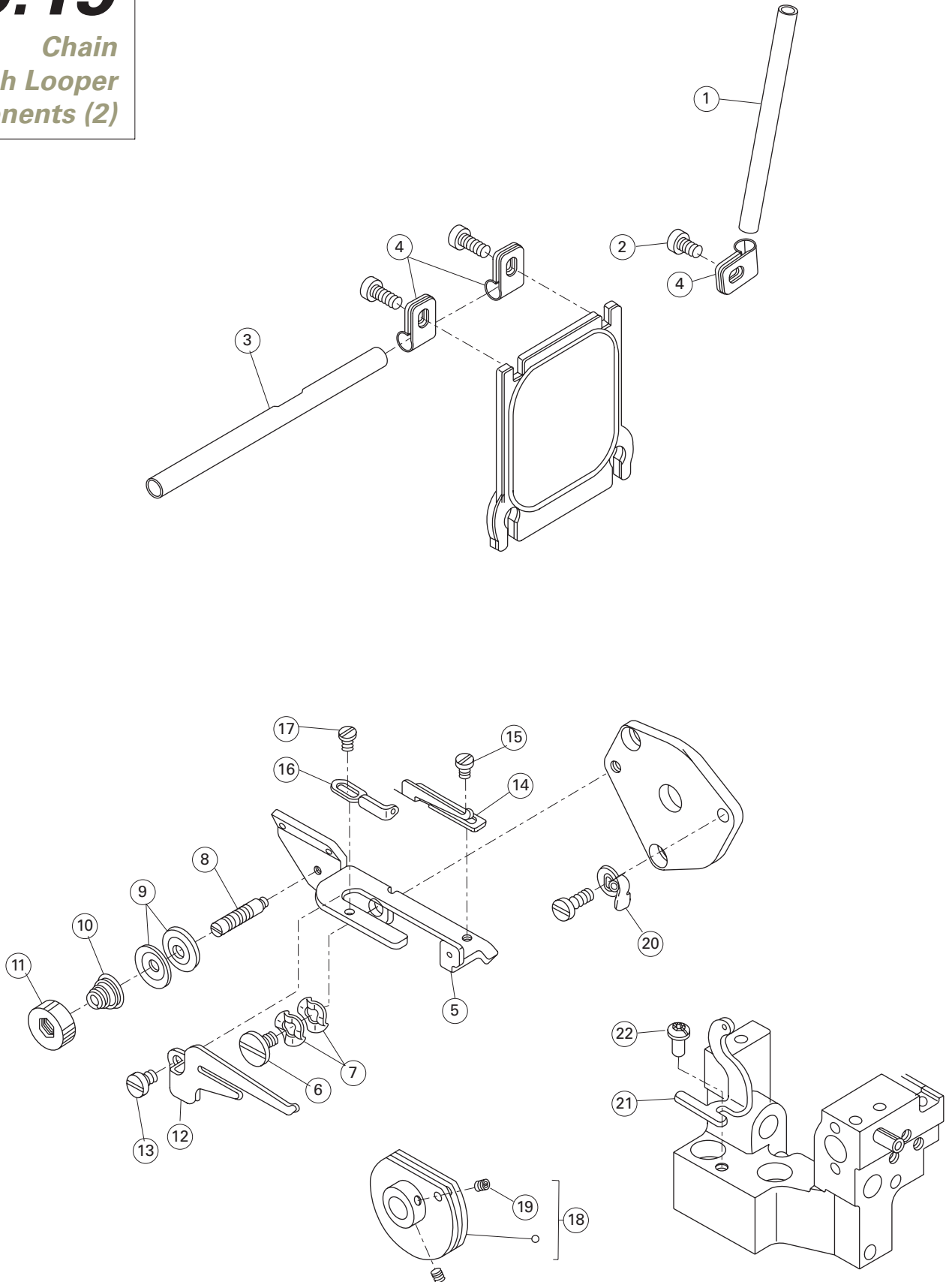
6.14

Chain Stitch Looper Components (1)

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20705006	Connection	0	0	1
2	B08002	Needle bearing	0	0	1
3	20704014	Crank	0	0	1
4	20703013	Bushing	0	0	1
5	207S12003	Screw	0	0	1
6	30228008	Washer	0	0	1
7	20709017	Slider	0	0	1
8	207S13009	Screw	0	0	1
9	20628010	Washer	0	0	1
10	20628005	Spring washer	0	0	1
11	20710008	Pin	0	0	1
12	001027	O ring	0	0	1
13	20626017	Shaft	0	0	1
14	20701034	Holder assembly	0	0	1
15	S05018	Screw	0	0	1
16	20704015	Crank assembly	0	0	1
17	S05018	Screw	0	0	1
18	20705008	Link	0	0	1
19	20703013	Bushing	0	0	1
20	207S12003	Screw	0	0	1
21	30228008	Washer	0	0	1
22	20702018	Shaft	0	0	1
23	3052201700	Oil seal	0	0	1
24	XXXXXXXX	Chain stitch looper	1	1	1
25	207S11028	Screw	0	0	1
26	20701035	Chain stitch looper holder assembly	0	0	1
27	207S20004	Screw	0	0	1
28	20728002	Spacer	0	0	1
29	207S15001	Screw	0	0	1

6.15

Chain Stitch Looper Components (2)



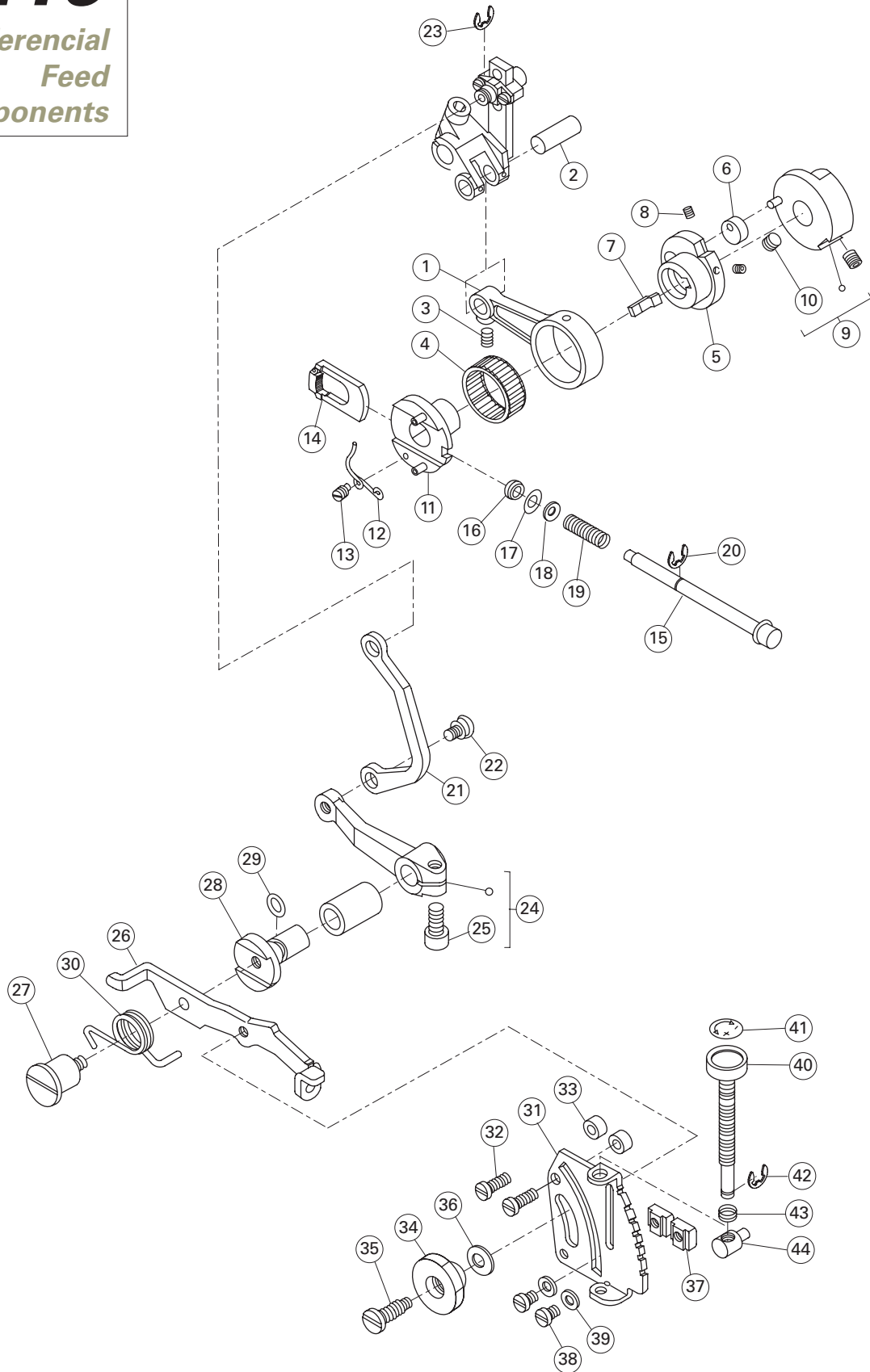
6.15

Chain Stitch Looper Components (2)

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20713039	Thread guide	0	0	1
2	207S11007	Screw	0	0	1
3	20713040	Thread guide	0	0	1
4	20629003	Holder	0	0	3
5	20612057	Bracket	0	0	1
6	207S20002	Screw	0	0	1
7	20628022	Washer	0	0	1
8	206S30015	Screw	0	0	1
9	20612055	Tension disc	0	0	2
10	3012016	Spring	0	0	1
11	206S16004	Knob	0	0	1
12	20612056	Thread guide	0	0	1
13	S01031	Screw	0	0	1
14	20629004	Thread guide	0	0	1
15	207S11020	Screw	0	0	1
16	20613017	Thread guide	0	0	1
17	207S11020	Screw	0	0	1
18	20612058	Looper thread take-up assembly	0	0	1
19	207S14009	Screw	0	0	2
20	20629005	Spring	0	0	1
21	20713026	Thread guide	0	0	1
22	207S11007	Screw	0	0	1

6.16

Differential Feed Components



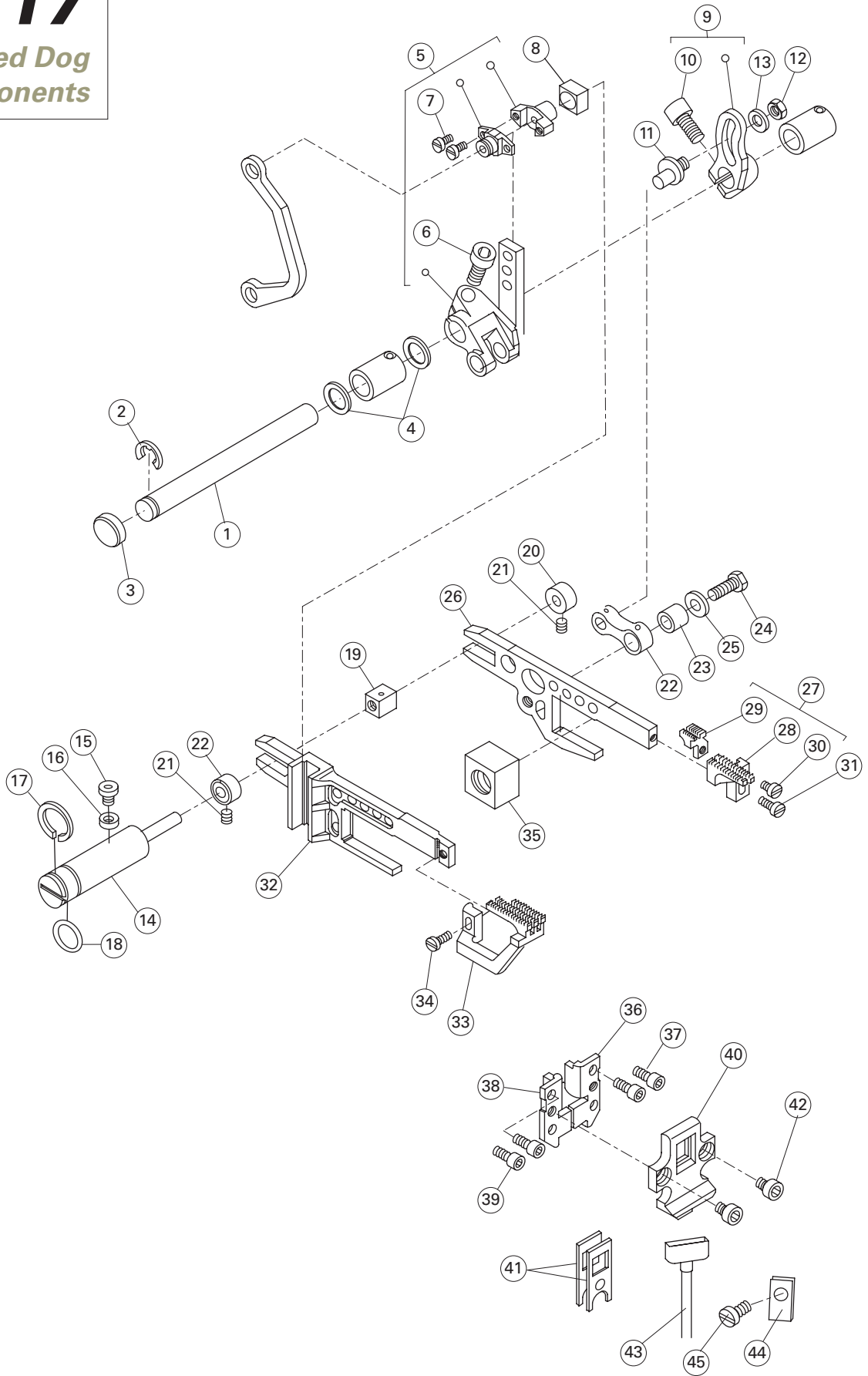
6.16

Differential Feed Components

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20705004	Connection	1	1	1
2	20626003	Pin	1	1	1
3	207S14007	Screw	1	1	1
4	BO8001	Needle bearing	1	1	1
5	20710001	Eccentric	1	1	1
6	20710002	Guide (Feed eccentric)	1	1	1
7	20712018	Flat spring	1	1	1
8	207S14003	Screw	2	2	2
9	20710003	Regulator assembly	1	1	1
10	207S14006	Screw	2	2	2
11	20710004	Eccentriv assembly	1	1	1
12	20727003	Spring	1	1	1
13	207S20005	Screw	1	1	1
14	20709006	Ratchet	1	1	1
15	20702005	Push button shaft	1	1	1
16	20722005	Gaket	1	1	1
17	001027	O ring	1	1	1
18	20728001	Washer	1	1	1
19	20727004	Spring	1	1	1
20	H05018	Ring	1	1	1
21	20705005	Link	1	1	1
22	207S20006	Screw	1	1	1
23	20629002	Ring	1	1	1
24	20704008	Lever assembly	1	1	1
25	S05018	Screw	1	1	1
26	20712019	Lever	1	1	1
27	207S20007	Screw	1	1	1
28	20702006	Shaft	1	1	1
29	20622010	O ring	1	1	1
30	20627006	Spring	1	1	1
31	20712020	Regulator plate	1	1	1
32	207S11008	Screw	2	2	2
33	20711007	Spacer	2	2	2
34	2071600100	Nut	1	1	1
35	207S300011	Screw	1	1	1
36	20728003	Spring washer	1	1	1
37	207S16002	Stopper	2	2	2
38	207S11011	Screw	2	2	2
39	30228009	Washer	2	2	2
40	20702007	Adjusting shaft	1	1	1
41	20737001	Label	1	1	1
42	H05018	Ring	1	1	1
43	20727005	Spring	1	1	1
44	20709007	Pin	1	1	1

6.17

Feed Dog Components



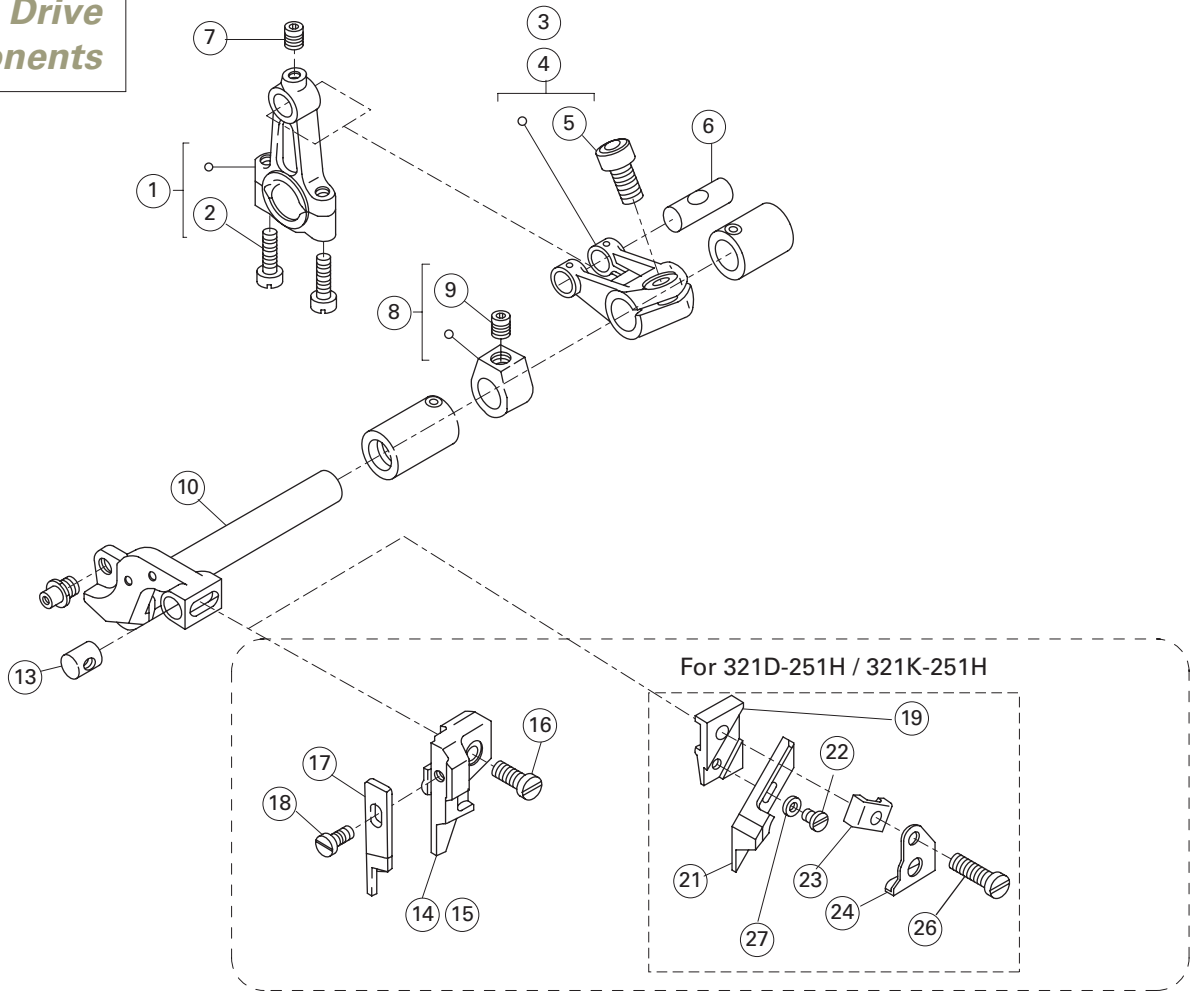
6.17

Feed Dog Components

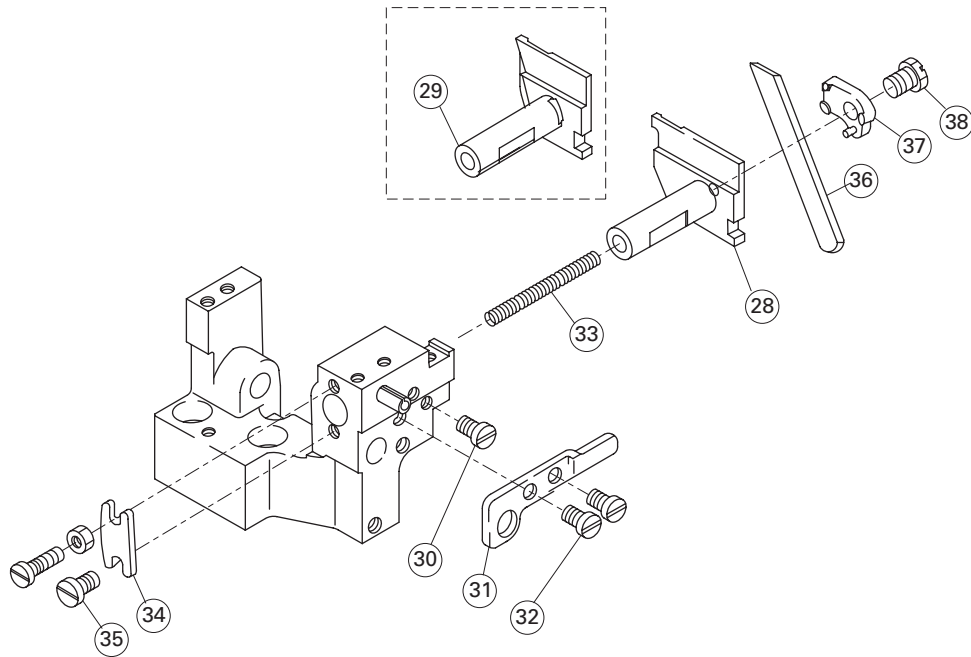
No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20702008	Shaft	1	1	1
2	H05009	Ring	1	1	1
3	20628023	Plug	1	1	1
4	20628011	Washer	2	2	2
5	2070400900	Crank assembly	1	1	1
6	207S13005	Screw	1	1	1
7	207811029	Screw	2	2	2
8	20709010	Block	1	1	1
9	20704011	Crank assembly	1	1	1
10	S05018	Screw	1	1	1
11	20710005	Pin	1	1	1
12	N01004	Nut	1	1	1
13	20628010	Wsher	1	1	1
14	20710006	Pin	1	1	1
15	207S13001	Screw	1	1	1
16	20722006	Gasket	1	1	1
17	20729002	Ring	1	1	1
18	1026	O ring	1	1	1
19	20709011	Block	1	1	1
20	20708008	Collar	2	2	2
21	207S14001	Screw	2	2	2
22	20705008	Link	1	1	1
23	20703013	Bushing	1	1	1
24	207S12003	Screw	1	1	1
25	30228008	Wsher	1	1	1
26	2070600100	Main feed dog bar	1	1	1
27	XXXXXXXXXX	Main feed dog assembly	1	1	1
28	XXXXXXXXXX	Main feed dog	1	1	1
29	XXXXXXXXXX	Auxiliary feed dog	1	1	1
30	207811029	Screw	1	1	1
31	801029	Screw	1	1	1
32	20706002	Differential feed dog bar	1	1	1
33	XXXXXXXXXX	Differential feed dog	1	1	1
34	207SI1030	Screw	1	1	1
35	20709012	Block	1	1	1
36	20701011	Feed bar guide (Right)	1	1	1
37	207S13006	Screw	2	2	2
38	20701012	Feed bar guide (Left)	1	1	1
39	207S13006	Screw	2	2	2
40	20701013	Feed bar guide oil seal	1	1	1
41	20722007	Oil seal	2	2	2
42	207S13007	Screw	2	2	2
43	20721003	Tube	1	1	1
44	20712055	Clamp	1	1	0
45	207SI1011	Screw	1	1	1

6.18

Knife Drive Components



For 321D-251H / 321K-251H



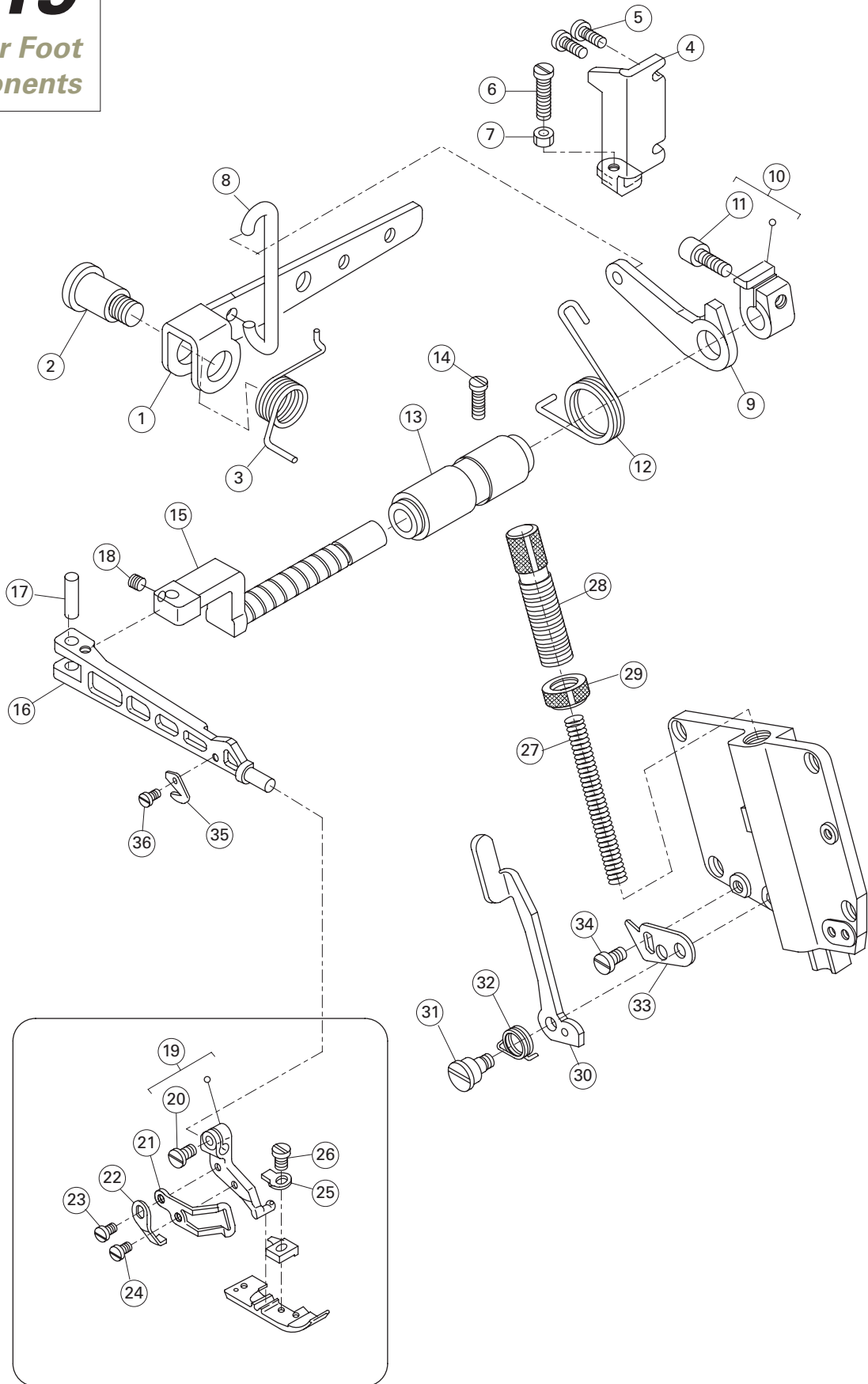
6.18

Knife Drive Components

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20705007	Connection assembly	1	1	1
2	207S11016	Screw	2	2	2
3	20704012	Crank assembly	1	1	0
4	20704030	Crank assembly	0	0	1
5	S05018	Screw	1	1	1
6	20626003	Pin	1	1	1
7	207S14007	Screw	1	1	1
8	30208001	Collar assembly	1	1	1
9	S10003	Screw	1	1	1
10	20702009	Upper knife lever	1	1	1
13	20726005	Pin	1	1	1
14	20701014	Upper knife holder	1	1	0
15	20701036	Upper knife holder	0	0	1
16	207S11012	Screw	1	1	1
17	XXXXXXXXXX	Upper knife	1	1	1
18	S01029	Screw	1	1	1
19	20701050	Angle upper knife holder	0	0	1
21	XXXXXXXXXX	Angle upper knife	0	0	1
22	207S11020	Screw	0	0	1
23	20712053	Angle upper knife gib	0	0	1
24	20712051	Waste guard	0	0	1
26	S11025	Screw	0	0	1
27	W01011	Washer	0	0	1
28	20701015	Lower knife holder	1	1	0
29	20701037	Lower knife holder	0	0	1
30	207S11007	Screw	1	1	1
31	20712021	Lower knife holder guide	1	1	1
32	207S11019	Screw	2	2	2
33	20727006	Spring	1	1	1
34	20712022	Plate	1	1	1
35	207S11007	Screw	1	1	1
36	XXXXXXXXXX	Lower knife	1	1	1
37	20709013	Lower knife clamp	1	1	1
38	207S12004	Screw	1	1	1

6.19

Presser Foot Components



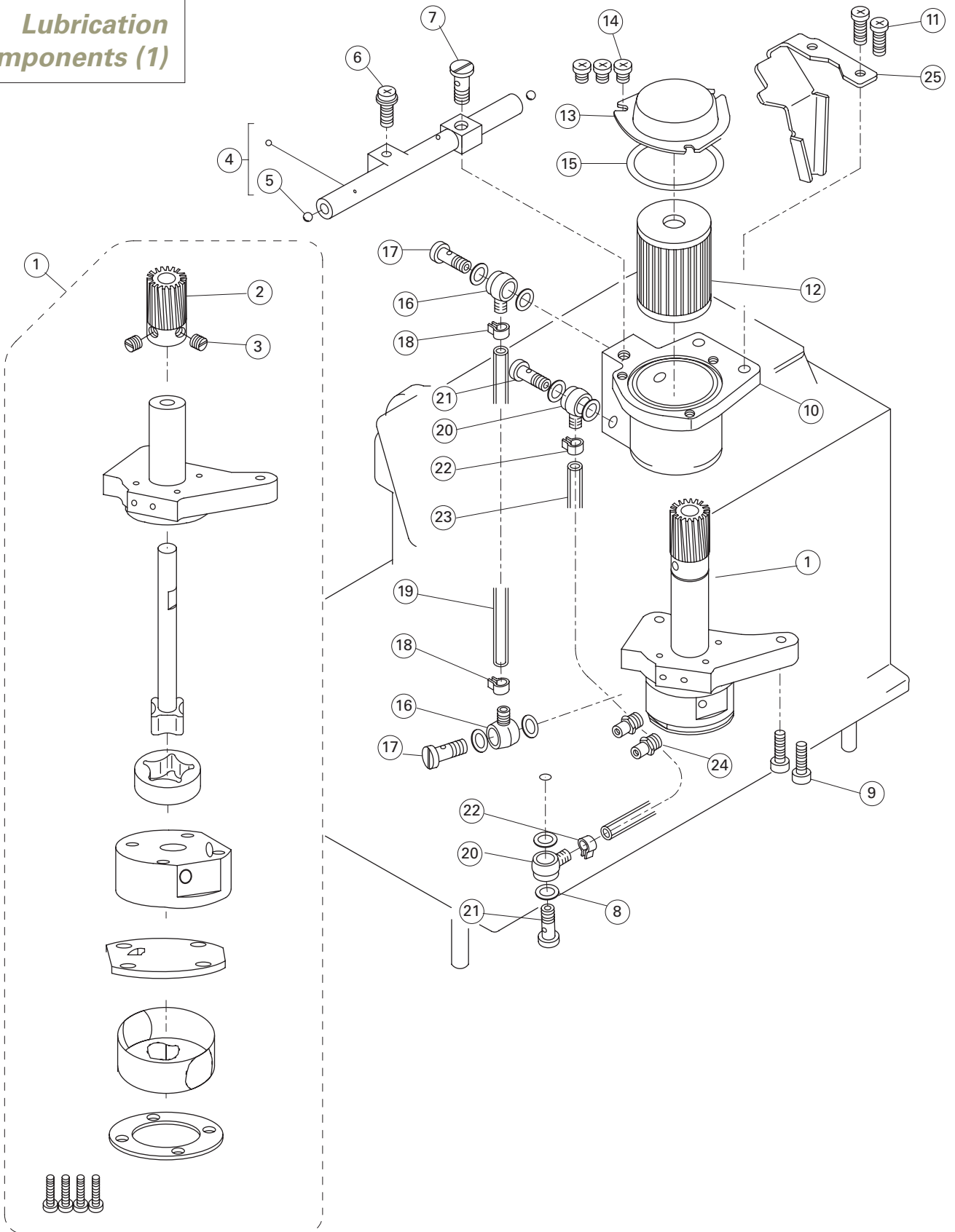
6.19

Presser Foot Components

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20712023	Lever	1	1	1
2	207S20008	Screw	1	1	1
3	20727007	Spring	1	1	1
4	20712024	Stopper	1	1	1
5	207S11012	Screw	2	2	2
6	207S11031	Screw	1	1	1
7	N01004	Nut	1	1	1
8	20712025	Link	1	1	1
9	20612030	Lever	1	1	1
10	20608004	Collar assembly	1	1	1
11	S05017	Screw	1	1	1
12	20627009	Spring	1	1	1
13	20703014	Bushing	1	1	1
14	207S11016	Screw	1	1	1
15	20702010	Shaft	1	1	1
16	20701016	Presser arm	1	1	1
17	20626016	Pin	1	1	1
18	S10011	Screw	1	1	1
19	XXXXXXXXX	Presser foot assembly	1	1	1
20	207S11030	Screw	1	1	1
21	20712026	Finge guard	1	1	1
22	20712048	Stopper	1	1	1
23	207S11009	Screw	1	1	1
24	207S11020	Screw	1	1	1
25	20712027	Flat Spring	1	1	1
26	207S11032	Screw	1	1	1
27	20712028	Spring (except 321D-251H / 321K-251H)	1	1	1
28	20702012	Adjusting screw	1	1	1
29	207S16003	Nut	1	1	1
30	20612034	Lever	1	1	1
31	207 S20009	Screw	1	1	1
32	20627010	Spring	1	1	1
33	20712030	Stopper	1	1	1
34	207S11007	Screw	1	1	1
35	20619005	Chain cutter	1	1	1
36	207S11020	Screw	1	1	1

6.20

Lubrication Components (1)



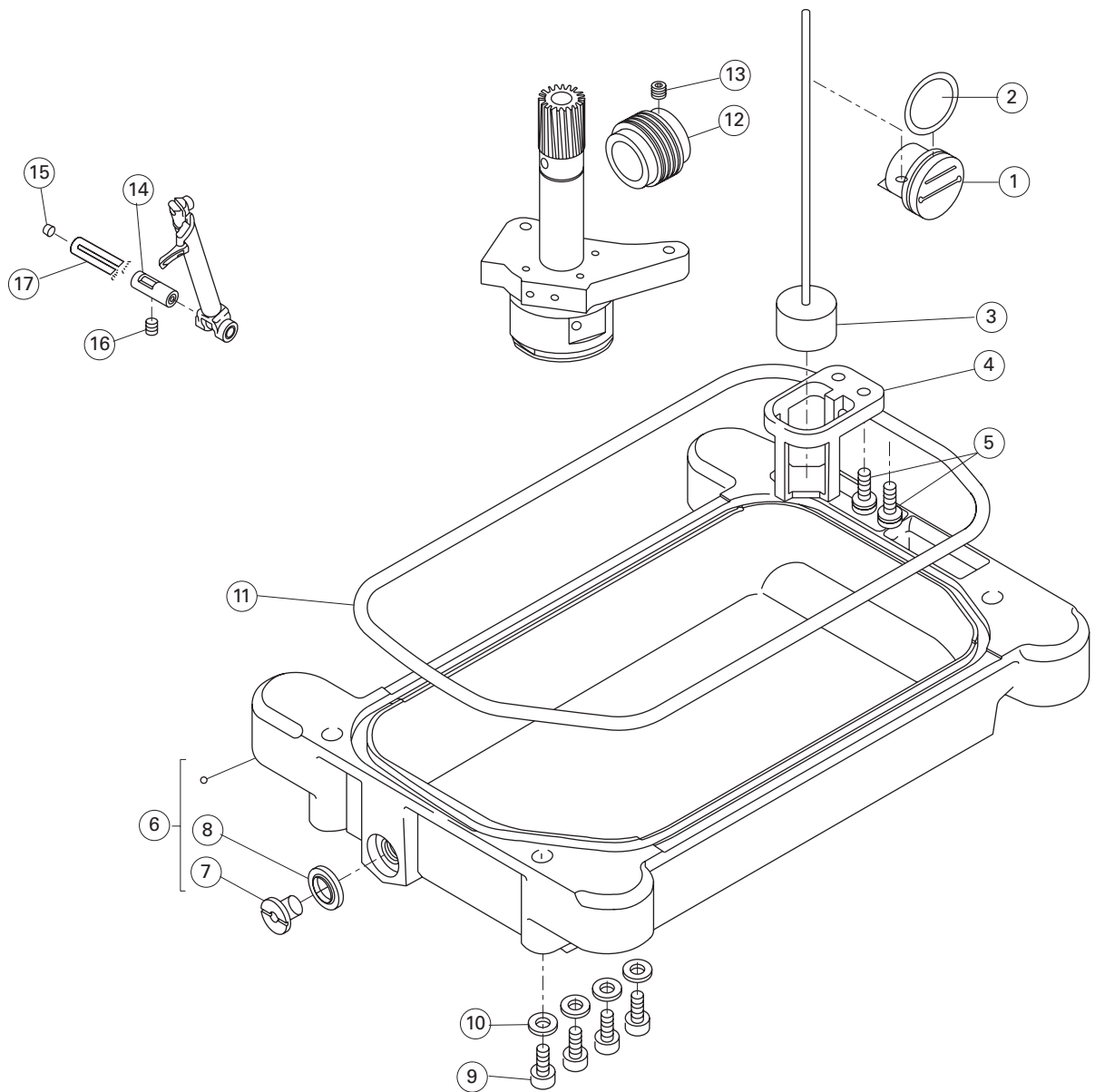
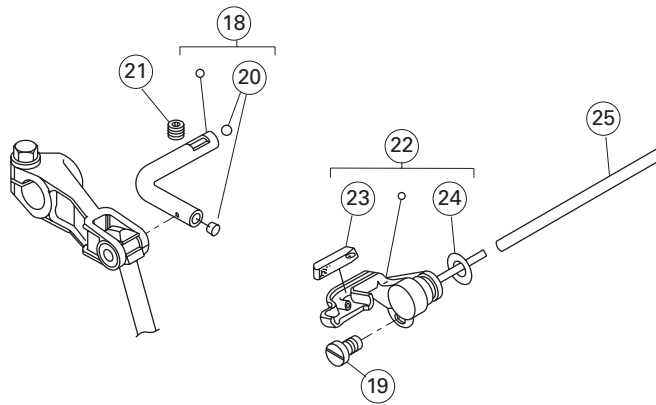
6.20

Lubrication Components (1)

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	2072000100	Oli pump assembly	1	1	1
2	20725002	Worm wheel	1	1	1
3	207S15002	Screw	2	2	2
4	2071100900	Oil distributor assembly	1	1	1
5	20709014	Plug	2	2	2
6	207S30002	Screw	1	1	1
7	206S30009	Joint screw	1	1	1
8	20122033	Washer	10	10	10
9	207S13008	Screw	2	2	2
10	20701025	Tank	1	1	1
11	207S11005	Screw	2	2	2
12	20136001	Oli filter	1	1	1
13	20712035	Cover	1	1	1
14	207S11007	Screw	3	3	3
15	001028	O ring	1	1	1
16	20636001	Joint	2	2	2
17	206S30009	Joint screw	2	2	2
18	20629002	Clamp	2	2	2
19	30121021	Tube	1	1	1
20	20636001	Joint	2	2	2
21	206S30009	Joint screw	2	2	2
22	20629002	Clamp	2	2	2
23	30121021	Tube	1	1	1
24	20521009	Joint	2	2	2
25	20712036	Oil guide	1	1	1

6.21

Lubrication Components (2)



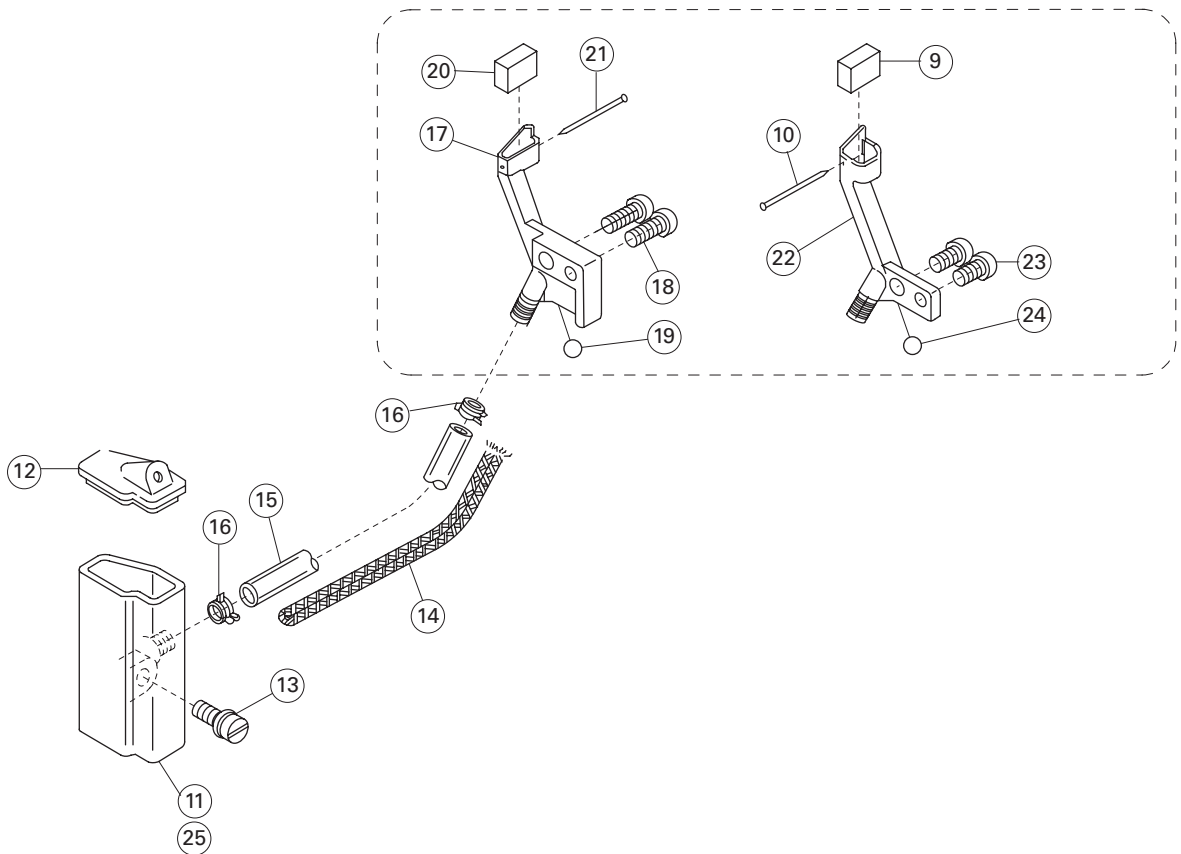
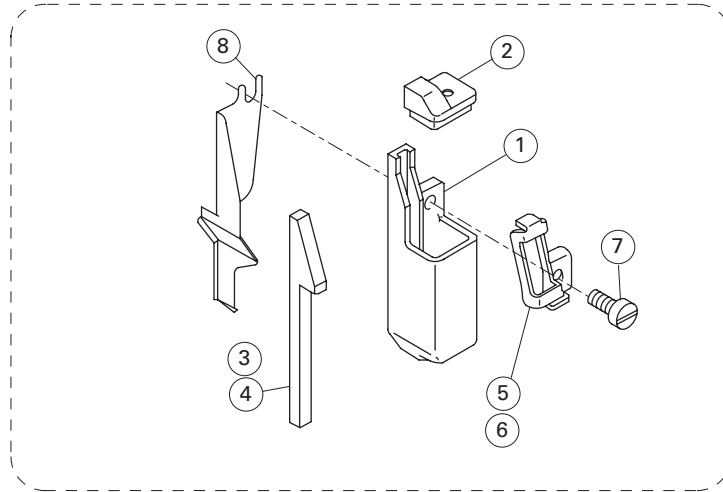
6.21

Lubrication Components (2)

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	2071101000	Oil sight gauge	1	1	1
2	001030	O Ring	1	1	1
3	2071101200	Indicator assembly	1	1	1
4	20711013	Indicator support	1	1	1
5	207S30002	Screw assembly	2	2	2
6	20701026	Oil reservoir assembly	1	1	1
7	207S13002	Screw	1	1	1
8	20622014	Washer	1	1	1
9	207S13009	Bolt	4	4	4
10	20628018	Washer	4	4	4
11	20722008	Gasket	1	1	1
12	20725003	Worm	1	1	1
13	207S14006	Screw	1	1	1
14	20626007	Pipe	1	1	1
15	20709015	Ball	1	1	1
16	207S14001	Screw	1	1	1
17	20123021	Oil wick	1	1	1
18	20721010	Pipe assembly	1	1	1
19	207S11011	Screw	1	1	1
20	20709016	Ball	2	2	2
21	207S14001	Screw	1	1	1
22	2071203800	Joint assembly	1	1	1
23	20723007	Felt	1	1	1
24	20622010	O ring	1	1	1
25	20721008	Tube	1	1	1

6.22

Silicon Oil Reservoir Components



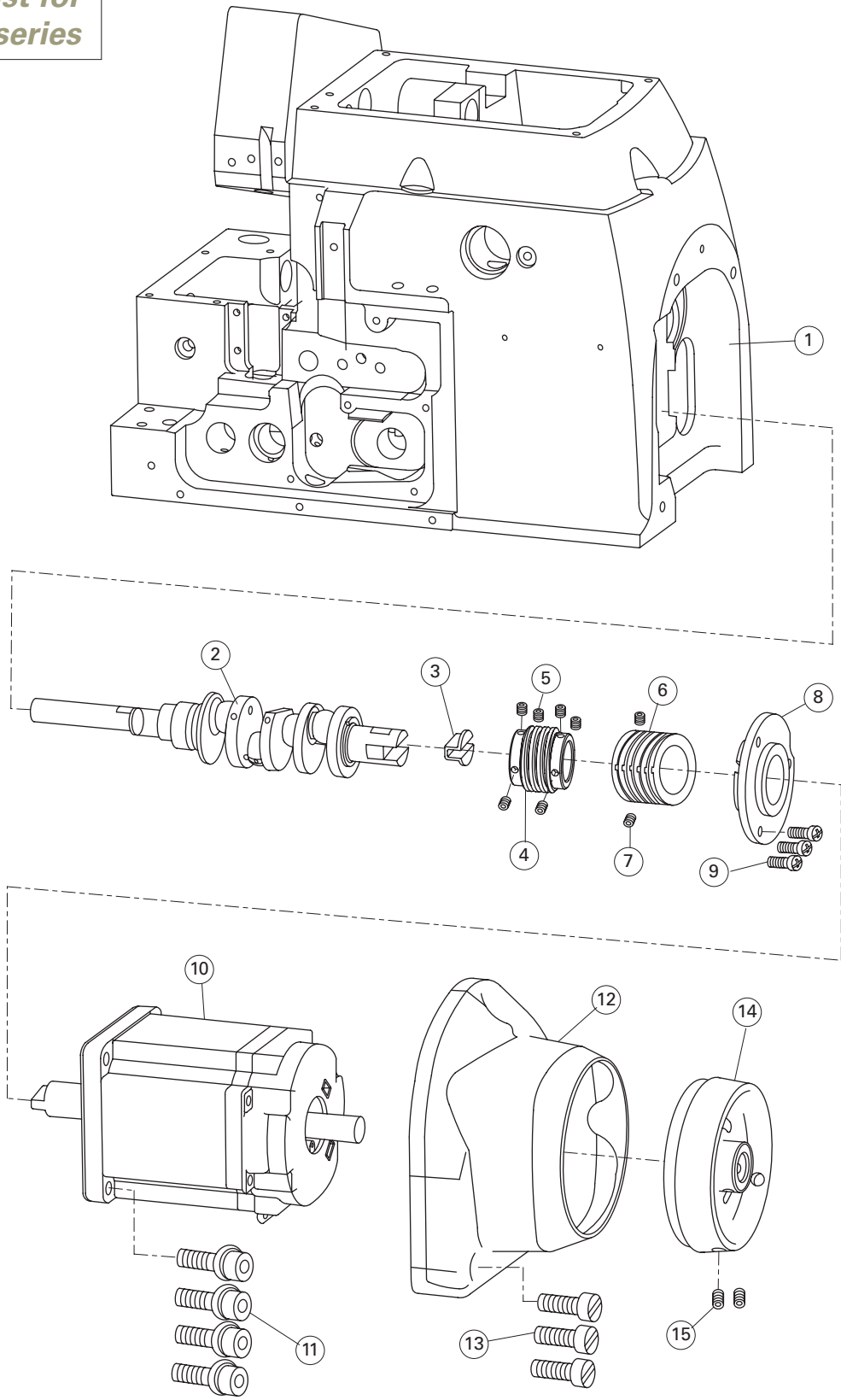
6.22

Silicon Oil Reservoir Components

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20711014	Silicone oil reservoir	1	1	1
2	20711015	Cover	1	1	1
3	20723008	Felt	1	1	0
4	20719051	Felt	0	0	1
5	20712040	Thread guide	1	1	0
6	20713019	Thread guide	0	0	1
7	207S11012	Screw	1	1	1
8	20712042	Cover	1	1	1
9	20723009	Oil felt	0	0	1
10	20726010	Pin	0	0	1
11	2071101600	Silicone oil reservoir	1	1	0
12	20711017	Cover	1	1	1
13	207S30003	Screw	1	1	1
14	40123013	Oil wick	1	1	1
15	40121002	Tube	1	1	1
16	20712041	Clamp	2	2	2
17	20701027	Needle thread lubricator	1	1	0
18	207S11008	Screw	2	2	0
19	20709014	Plug	1	1	0
20	20723009	Oil felt	1	1	0
21	20726010	Pin	1	1	0
22	20701038	Needle thread lubricator	0	0	1
23	207S11007	Screw	0	0	2
24	20709014	Plug	0	0	1
25	2070103000	Silicone oil reservoir	0	0	1

6.23

Exclusive
Parts List for
321K series



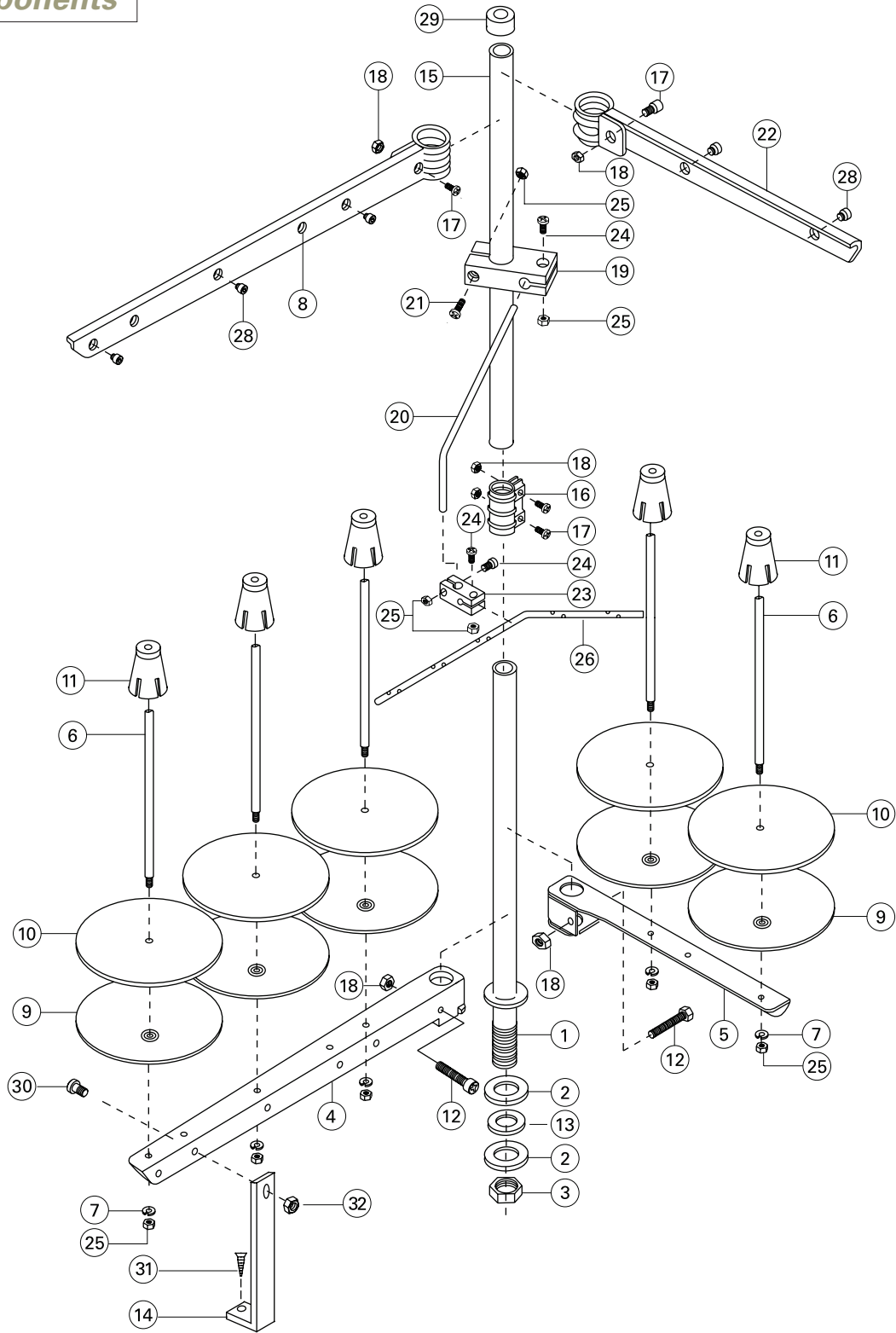
6.23

Exclusive Parts List for 321K series

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20701080	Machine Frame	1	1	1
2	20702023	Crank shaft	1	1	1
3	20723010	Washer	1	1	1
4	20725004	Worm	1	1	1
5	S10018	Screw	6	6	6
6	20708013	Helical casing	1	1	1
7	207S14006	Screw	2	2	2
8	20708014	Right cover	1	1	1
9	207S11012	Screw	3	3	3
10	2073300400	Direct drive servo motor	1	1	1
11	114S30001	Screw	4	4	4
12	20711026	Motor cover	1	1	1
13	S01013	Screw	3	3	3
14	20735015	Hand wheel	1	1	1
15	S10009	Screw	2	2	2

6.24

Thread Stand Components



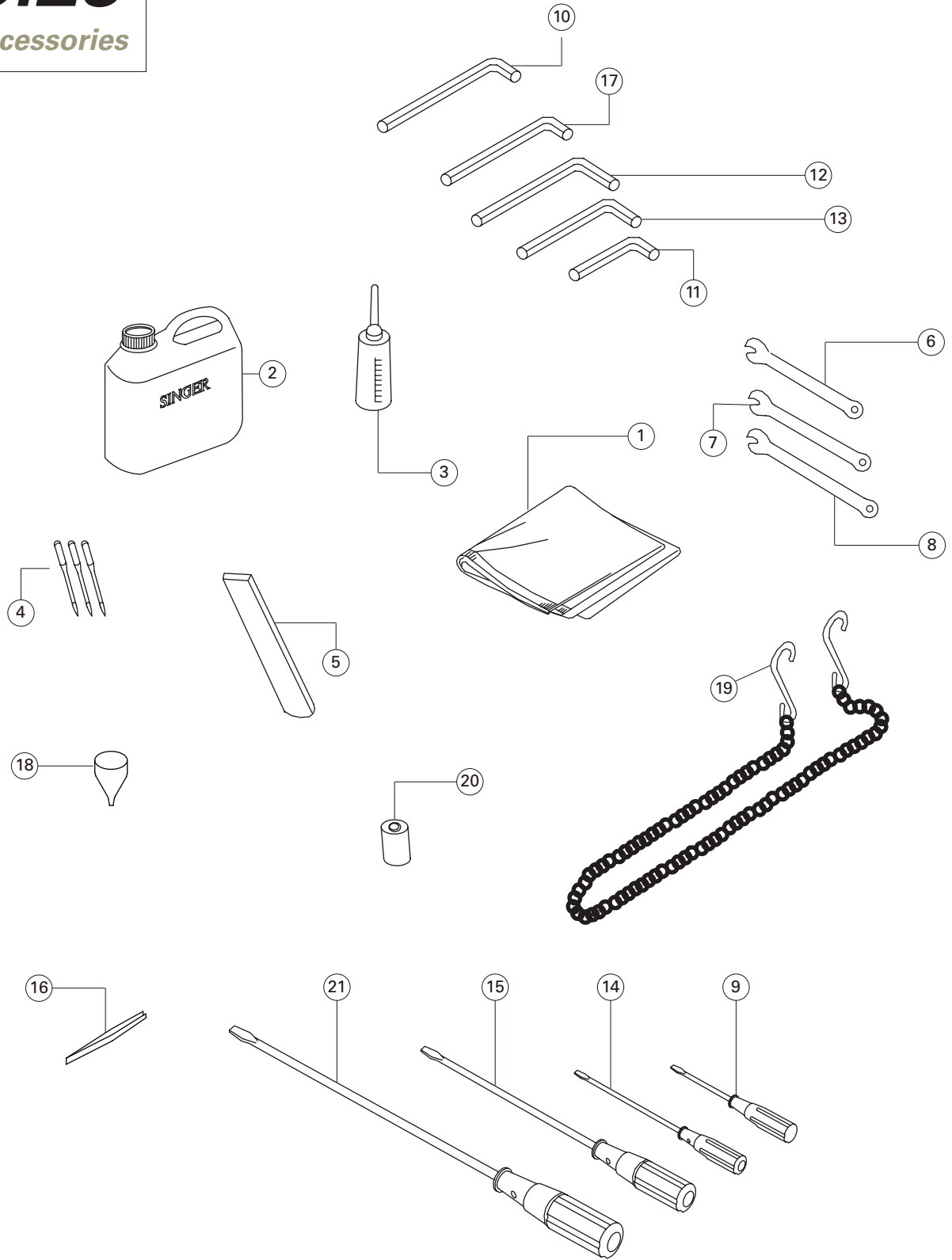
6.24

Thread Stand Components

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	30102032	Thread bar (lower)	1	1	1
2	30128024	Washer	2	2	2
3	N02001	Nut	1	1	1
4	30101028	Bracket (3 spools)	1	0	1
5	30101029	Bracket (2 spools)	0	2	1
6	30102033	Spool pin	3	4	5
7	W02002	Washer	3	4	5
8	30101030	Thread guide bar (3 spools)	1	0	1
9	30111007	Spool tray	3	4	5
10	30123014	Cushion	3	4	5
11	30103044	Spool holder	3	4	5
12	L02004	Screw	1	2	2
13	10128006	Rubber washer	1	1	1
14	20131014	Thread stand support	1	0	1
15	30102034	Thread bar (upper)	1	1	1
16	30129005	Joint	1	1	1
17	S04002	Screw	4	4	4
18	N01004	Nut	6	6	6
19	30111008	Bracket	1	1	1
20	30113018	Thread guide bar	1	1	1
21	S04003	Screw	1	1	1
22	30101031	Thread guide bar (2 spools)	0	2	1
23	30111009	Bracket	1	1	1
24	S04004	Screw	3	3	3
25	N01005	Nut	7	8	9
26	30113019	Thread guide bar (5 holes)	1	1	1
28	30103045	Thread guide hole	3	4	5
29	30122027	Rod cap	1	1	1
30	20131023	Screw	1	1	1
31	20131024	Screw	1	1	1
32	30122027	Nut	1	1	1

6.25

Accessories



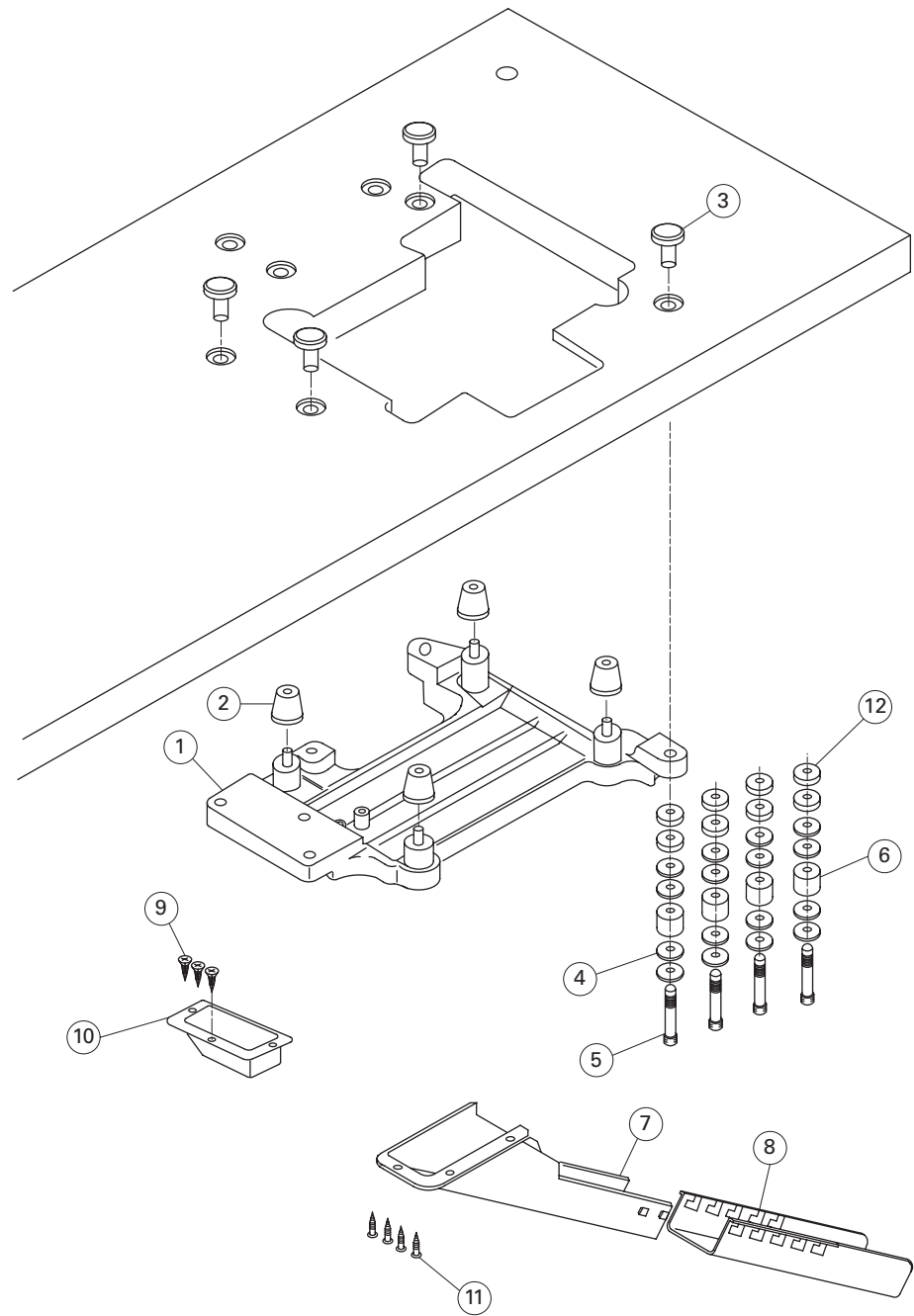
6.25

Accessories

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	10131005	Dust cover	1	1	1
2	20131037	Oil bottle	1	1	1
3	20131038	Small oil bottle	1	1	1
4	6120-06	Needle	3	3	3
5	20619003	Lower knife	1	1	1
6	20131041	Spanner (6mm)	1	1	1
7	20131042	Spanner (7mm)	1	1	1
8	20131043	Spanner (8mm)	1	1	1
9	20131044	Allen key driver (1.5mm)	1	1	1
10	30131026	Allen key (8mm)	1	1	1
11	20131046	Allen key (2mm)	1	1	1
12	20131047	Allen key (5mm)	1	1	1
13	30131012	Allen key (4mm)	1	1	1
14	10131004	Screw driver (small)	1	1	1
15	10131003	Screw driver (middle)	1	1	1
16	20131051	Tweezers	1	1	1
17	20131056	Allen key (6mm)	1	1	1
18	20131039	Funnel	1	1	1
19	20131054	Foot controller chain	1	1	1
20	20136001	Oil filter	1	1	1
21	10131002	Screw driver (big)	1	1	1

6.26

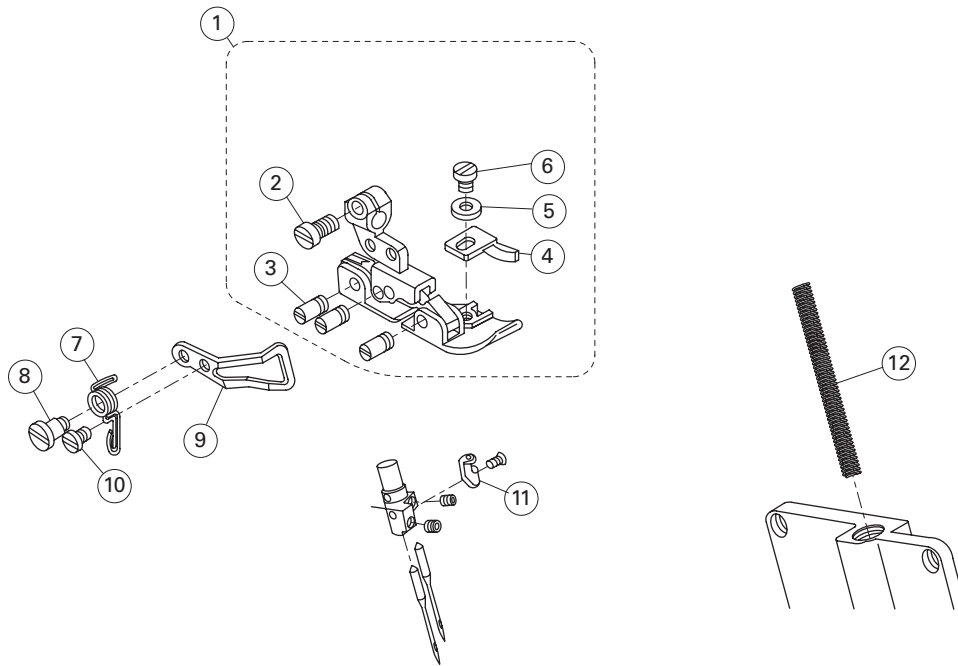
Machine Support Plate For Semi-Submerged Components



No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20701028	Machine support plate	1	1	1
2	20722009	Cushion rubber	4	4	4
3	301S16008	Nut	4	4	4
4	20131029	Washer	16	16	16
5	301S30017	Screw	4	4	4
6	20131030	Spacer	4	4	4
7	20131032	Waste chute (upper)	1	1	1
8	20131033	Waste chute (lower)	1	1	1
9	20131034	Screw	3	3	3
10	20131031	Waste chute inlet	1	1	1
11	20131035	Screw	4	4	4
12	30122031	Spacer	8	8	8

6.27

Specific Parts
for 321D-251H
and 321K-251H

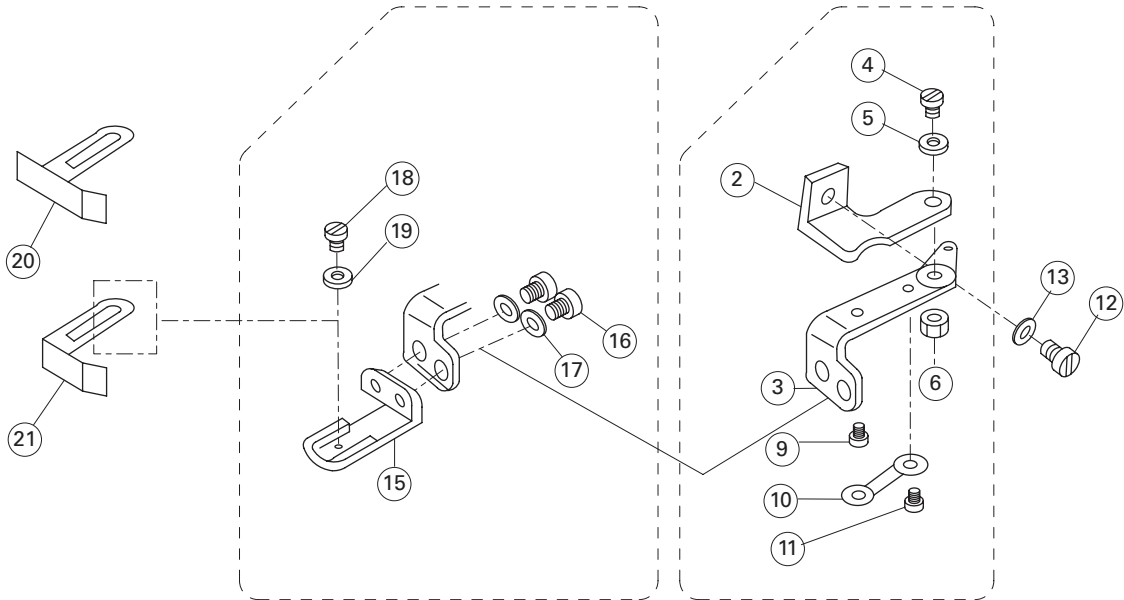


No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	XXXXXXXX	Presser foot assembly	0	0	1
2	207S11030	Screw	0	0	1
3	20726011	Pin	0	0	3
4	20714051	Fabric guard	0	0	1
5	W01002	Washer	0	0	1
6	206S11018	Screw	0	0	1
7	20719053	Spring	0	0	1
8	207S16050	Screw	0	0	1
9	20712052	Finger guard	0	0	1
10	207S11009	Screw	0	0	1
11	20713056	Thread eyelet	0	0	1
12	20719054	Spring	0	0	1

6.28

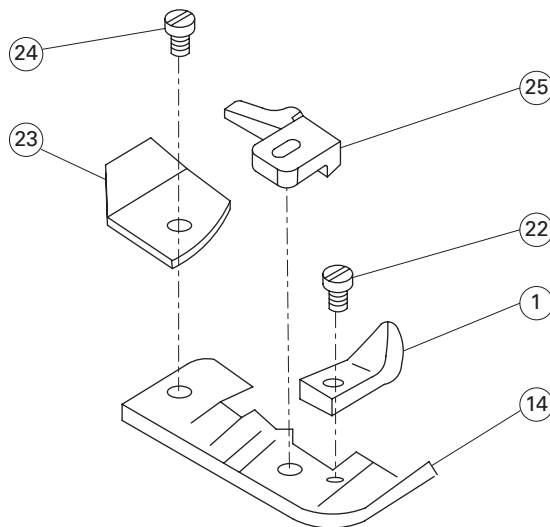
Optional Parts

For
321D-131M 321K-131M
321D-241M 321K-241M
321D-251M 321K-251M



For
321D-132M
321K-132M

Turn down hemming



6.28

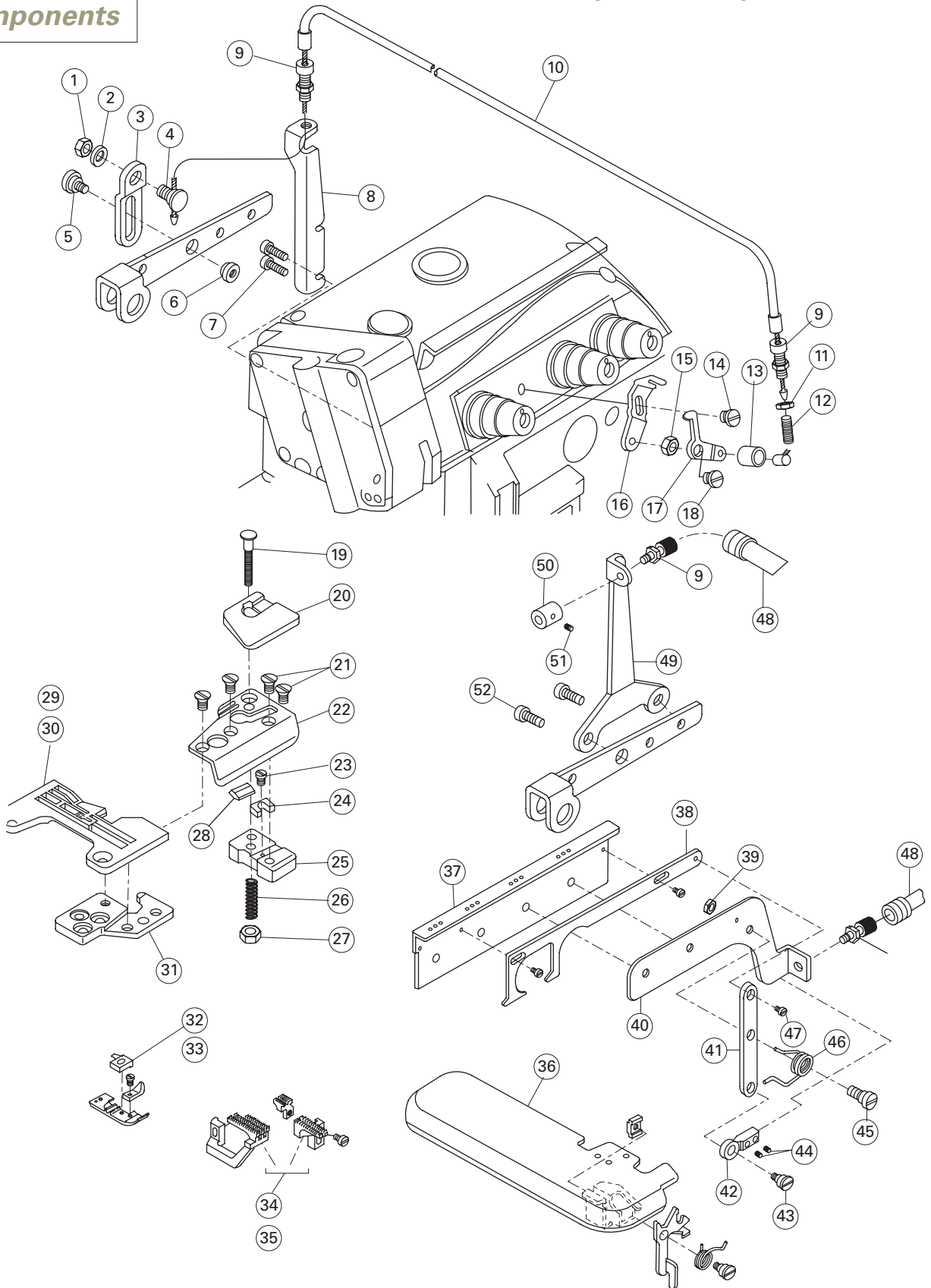
Optional Parts

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20701023	Fabric guard	1	0	0
2	20112051	Cloth plate bracket	1	1	1
3	20112052	Hinge guide bracket	1	1	1
4	201S20002	Screw	1	1	1
5	20128027	Spring washer	1	1	1
6	201S16003	Nut	1	1	1
9	20126020	Pin	1	1	1
10	20112053	Flat spring	1	1	1
11	201S11011	Screw	1	1	1
12	S01010	Screw	1	1	1
13	W02002	Spring washer	1	1	1
14	XXXXXXXXXX	Presser foot	1	0	0
15	20112056	Edge guide bracket	1	1	1
16	201S12001	Bolt	2	2	2
17	20128020	Washer	2	2	2
18	201S11010	Screw	1	1	1
19	20128020	Washer	1	1	1
20	20112054	Edge guide	1	1	0
21	20112055	Edge guide	0	0	1
22	207S11033	Screw	1	0	0
23	20712031	Uncurler	1	0	0
24	207S11034	Screw	1	0	0
25	XXXXXXXXXX	Presser foot finger	1	0	0

6.29

Back Latch Components

For
321D-134M 321K-134M
321D-244M 321K-244M



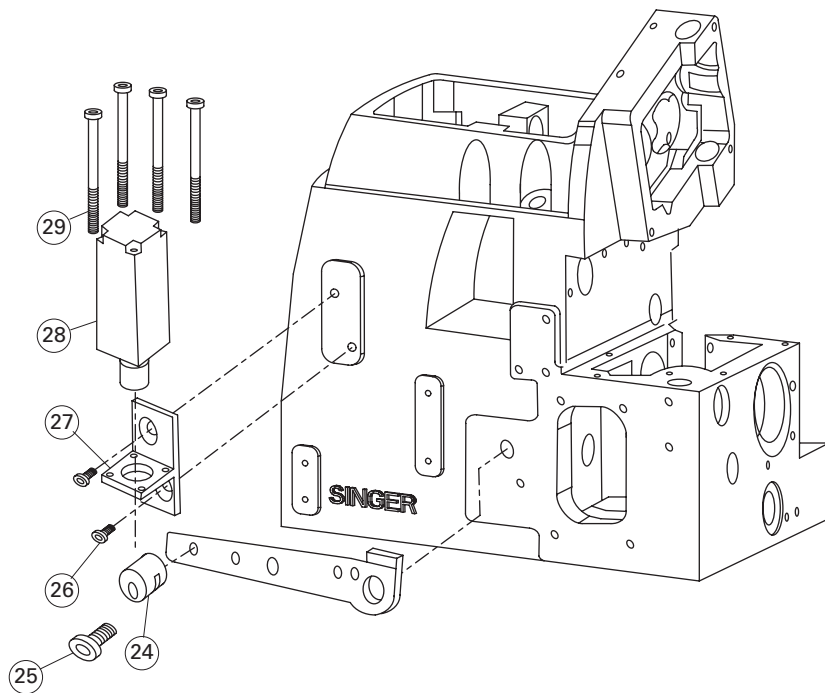
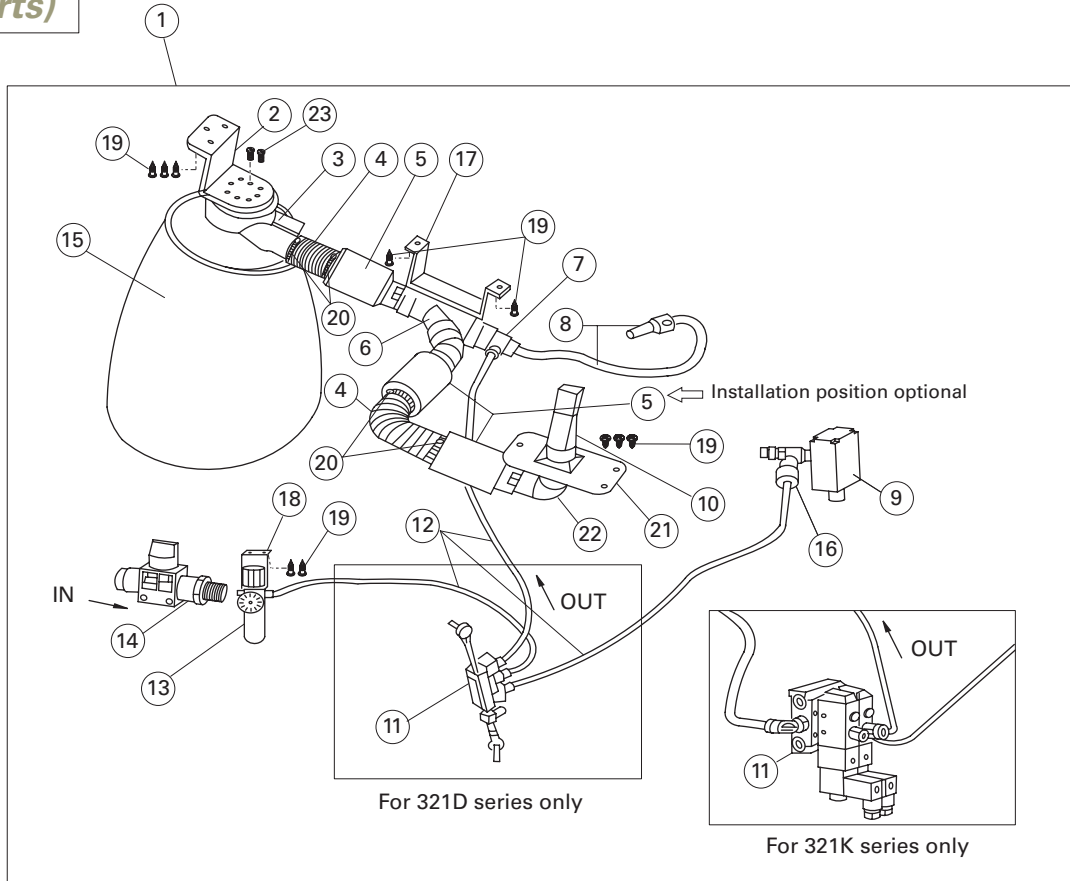
6.29

Back Latch Components

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	205S16002	Nut	1	1	0
2	20528008	Washer	1	1	0
3	20512008	Connecting plate	1	1	0
4	205S30011	Screw	1	1	0
5	205S30012	Screw	1	1	0
6	205S16003	Nut	1	1	0
7	207S11005	Screw	2	0	0
8	20713044	Bracket	1	0	0
9	205S30013	Connecting screw	2	2	0
10	2051200900	Thread tension releasing wire assemb	1	0	0
11	205S16005	Nut	4	2	0
12	20527006	Spring	1	0	0
13	205S30009	Screw	1	0	0
14	206S11005	Screw	1	0	0
15	205S16004	Nut	1	0	0
16	20512005	Tension support	1	0	0
17	20512006	Thread tension releasing plate	1	0	0
18	205S30014	Screw	1	0	0
19	205S30007	Screw	1	1	0
20	20512002	Thread press plate	1	1	0
21	S02007	Screw	4	4	0
22	20512004	Knife supporter	1	1	0
23	205S30008	Screw	1	1	0
24	20512003	Pressing block	1	1	0
25	20519001	Small knife support	1	1	0
26	20527003	Spring	1	1	0
27	301S16007	Thread tension nut	1	1	0
28	20519002	Knife	1	1	0
29	XXXXXXXXX	Needle plate	1	0	0
30	XXXXXXXXX	Needle plate	0	1	0
31	20709021	Needle plate supporter (front)	1	1	0
32	XXXXXXXXX	Presser foot finger	1	0	0
33	XXXXXXXXX	Presser foot finger	0	1	0
34	XXXXXXXXX	Feed dog assembly	1	0	0
35	XXXXXXXXX	Feed dog assembly	0	1	0
36	2071206500	Cloth plate	1	1	0
37	20112060	Thread guide plate	0	1	0
38	20112061	Thread tension plate	0	1	0
39	201S16003	Nut	0	1	0
40	20112062	Frong frame	0	1	0
41	20112063	Thread tension releasing lever	0	1	0
42	20101039	Connector	0	1	0
43	201S20014	Connector screw	0	1	0
44	201S14003	Screw	0	2	0
45	201S20013	Screw	0	1	0
46	20127021	Spring	0	1	0
47	201S20012	Screw	0	1	0
48	20112059	Sleeve	0	1	0
49	20112058	Bracket	0	1	0
50	20103029	Collar	0	1	0
51	201S14002	Screw	0	1	0
52	201S11016	Screw	0	2	0

6.30

Vacuum Suction & AFL Device (Option parts)



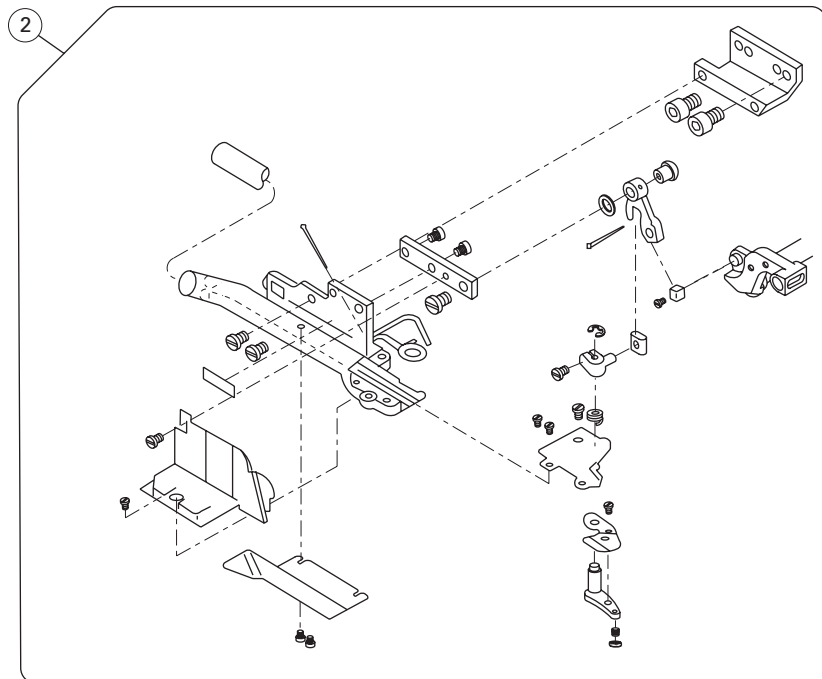
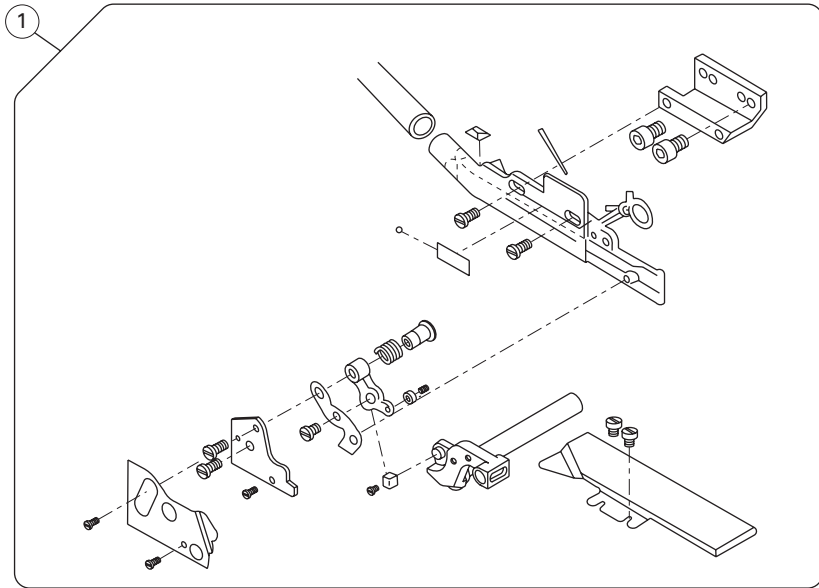
6.30

Vacuum Suction & AFL Device (Option parts)

No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	20731012	Vacuum suction assembly (For 321D only)	1	1	1
	20731009	Vacuum suction assembly (For 321K only)	(3)	(3)	(3)
2	20731012-1	Z basket	(1)	(1)	(1)
3	20731012-2	Bag connecting cover	(1)	(1)	(1)
4	20731012-3	Tube D38x0.7	(2)	(2)	(2)
5	20731012-4	Muffler	(1)	(1)	(1)
6	20731012-5	Tube	(1)	(1)	(1)
7	20731012-6	Dispenser assembly	(1)	(1)	(1)
8	20731012-7	Tube D13x0.7	(1)	(1)	(1)
9	20730002	Cylinder	(1)	(1)	(1)
10	20731012-8	Fabric clippings suction nozzle	(1)	(1)	(1)
11	20731012-9	Pneumatic switch (For 321D only)	(1)	(1)	(1)
	20731010	Pneumatic switch (For 321K only)	(1)	(1)	(1)
12	61911005	PU tube 3M (D6x4)	(1)	(1)	(1)
13	40730024	Pressure regulator with filter tap	(1)	(1)	(1)
14	40730046	Control switch	(1)	(1)	(1)
15	20731012-12	Fabric clippings bag	(1)	(1)	(1)
16	40736024	Adjustable tube connector	(1)	(1)	(1)
17	20731012-15	Dispenser bracket	(1)	(1)	(1)
18	20731012-16	Pressure regulator bracket Screw	(1)	(1)	(1)
19	20731012-19	Screw	(10)	(10)	(10)
20	20731012-20	Tube clamp	(4)	(4)	(4)
21	20731012-21	Nozzle plate	(1)	(1)	(1)
22	20731012-22	Elbow pipe	(1)	(1)	(1)
23	20731012-23	Scew	(2)	(2)	(2)
24	20701082	AFL connecting rod	1	1	1
25	207S13009	Screw M5x12	1	1	1
26	207S17007	Screw M6x8	2	2	2
27	20701081	AFL bracket	1	1	1
28	2073002	AFL Cylinder	1	1	1
29	207S11032	Screw M4x38	4	4	4

6.31

Chain Cutter Device Components



No.	Part No.	Description	Qty		
			3 thread	4 thread	5 thread
1	2071206000	Vertical chain cutter device assembly (KS)	1	1	0
2	2071206100	Horizontal chain cutter device assembly (KH)	0	0	1

Gauge Parts List

MACHINE MODEL 321D & 321K	GAUGE		NEEDLE PLATE	MAIN FEED DOG ASSM.	MAIN FEED DOG	AUX. FEED DOG	DIFF. FEED DOG	PRESSER FOOT ASSM	PRESSER FOOT FINGER	UPPER FINGER	LOWER LOOPER	CHAINSTITCH LOOPER
	NG	SW										
-131M-04 (KS)		4	20715005	2071400100	20714001	20714002	20714003	2071600700	20701022	20717004	20717006	—
-132M-015		1.5	20715010	2071400800	20714008	20714020	20714007	2071601000	20701043	20717004	20717006	—
-134M-04		4	20715019	2071402000	20714001	20714002	20714003	2071601700	—	20717004	20717006	—
-241M-24 (KS)	2	4	20715002	2071400100	20714001	20714002	20714003	2071600700	20701019	20717003	20717006	—
-244M-24	2	4	20715020	2071402200	20714001	20714002	20714003	2071601800	—	20717003	20717006	—
-251M-35 (KH)	3	5	20715008	2071400400	20714004	20714002	20714007	2071600600	—	20717006	20712047	20712047
-251M-55 (KH)	5	5	20715016	2071401700	20714004	20714002	20714017	2071601500	—	20717006	20712047	20712047
-251H-56 (KH)	5	6	20715050	2071405200	20714052	20714002	20714050	2070105400	—	20717006	20717051	20717051

MACHINE MODEL 321D & 321K	GAUGE		UPPER KNIFE		LOWER KNIFE	OVERLOCK NEEDLE GUARD		CHAIN STITCH NEEDLE GUARD		NEEDLE HOLDER	NEEDLE
	NG	SW	FLAT KNIFE	ANGLE KNIFE		FRONT	REAR	FRONT	REAR		
-131M-04 (KS)		4	20619002	—	20619003	20717001	20717002	—	—	20734001	6120-06 65/9
-132M-015		1.5	20619002	—	20619003	20717001	20717002	—	—	20734001	6120-06 75/11
-134M-04		4	20619002	—	20619003	20717001	20717002	—	—	20734001	6120-06 65/9
-241M-24 (KS)	2	4	20619002	—	20619003	20717001	20717002	—	—	20734002	6120-06 65/9
-244M-24	2	4	20619002	—	20619003	20717001	20717002	—	—	20734002	6120-06 75/11
-251M-35 (KH)	3	5	20619002	—	20619003	20717008	20717002	20712045	20701032	20734004	6120-06 90/14
-251M-55 (KH)	5	5	20719001	—	20619003	20717008	20717002	20712045	20701032	2734004	6120-06 75/11
-251H-56 (KH)	5	6	—	20719050	20701053	20717008	20717002	20712045	20701032	20719056	6120-06 132/21

