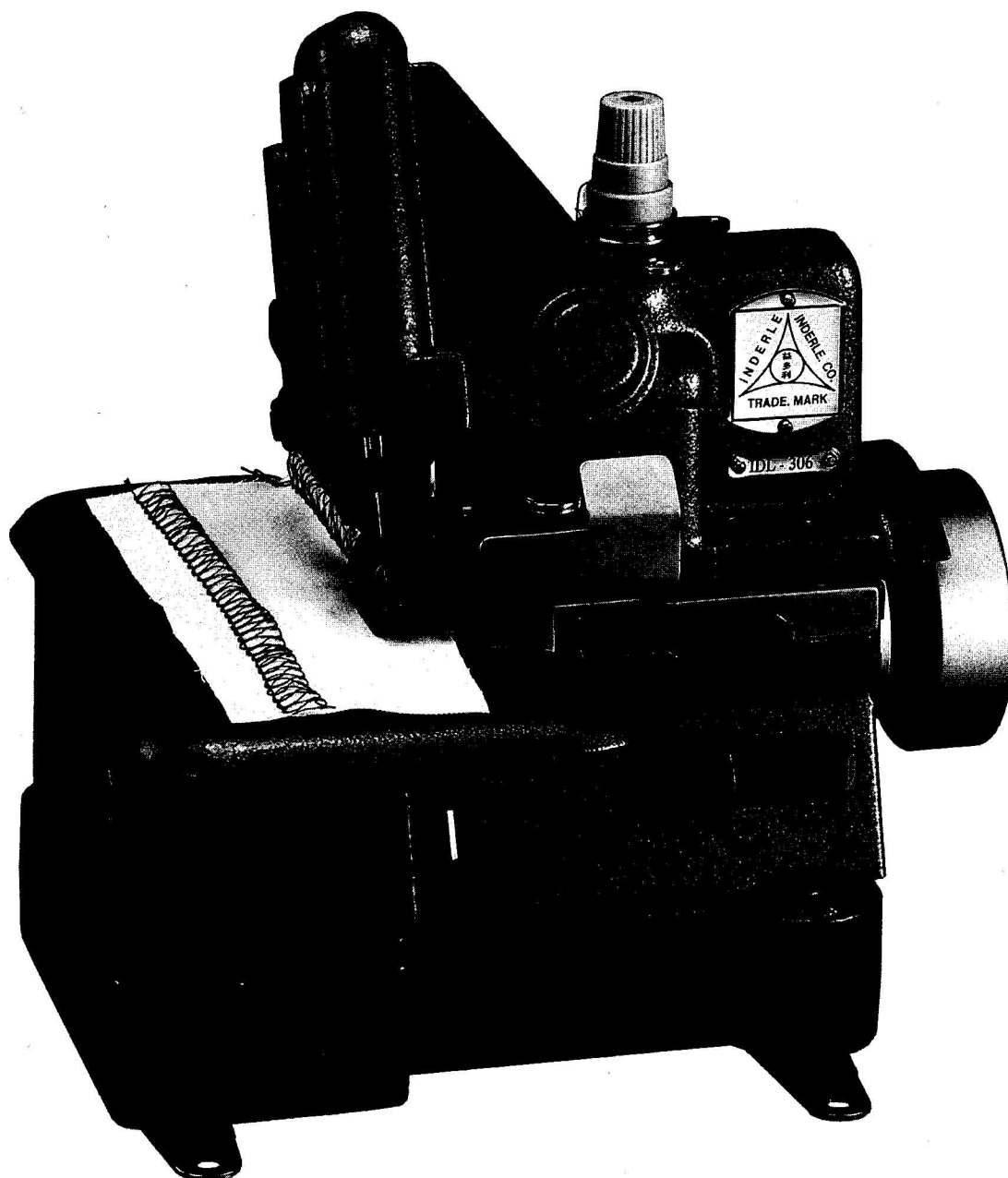


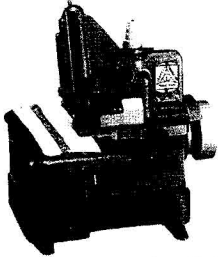
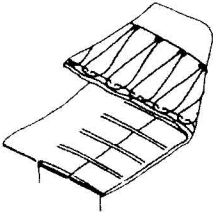
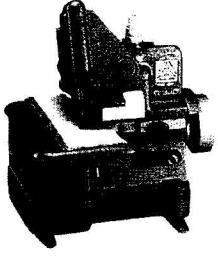
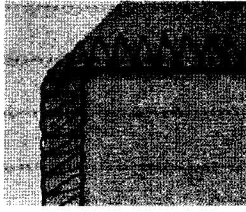
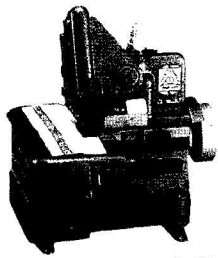
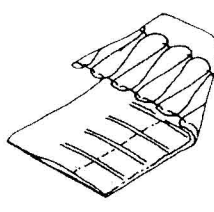
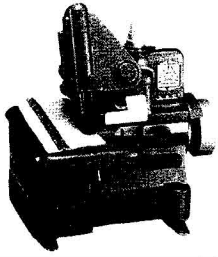
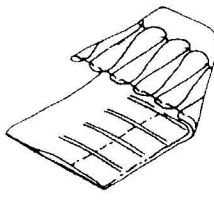
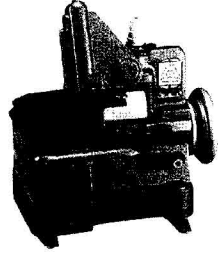
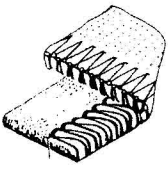

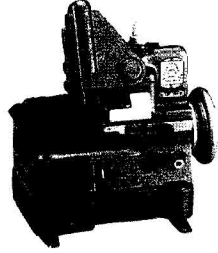
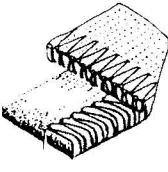

益多利縫機有限公司

INDERLE

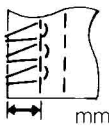
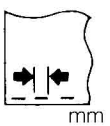
INSTRUCTIONS FOR IDL-300 SERIES



*HIGH SPEED OVERLOCK
SEWING MACHINE
2006 EDITION I (2006 年版)*

		MODEL-302 (1 THREAD) ABUTTED SEAM SEWING MACHINE 一般皮革、染整接布機專用 (1線) For joining temporarily the abutted edges of piece goods for processing in bleaching, dyeing and printing factories.	
		MODEL-303 (3 THREAD) OVERLOCK ABUTTED SEAM SEWING MACHINE 拷克車接布機專用 (3線) For joining temporarily the abutted edges of piece goods for processing in bleaching, dyeing and printing factories.	
		MODEL-306 (2 THREAD) ABUTTED SEAM SEWING MACHINE 一般染整接布機專用 (2線) For joining temporarily the abutted edges of piece goods for processing in bleaching, dyeing and printing factories.	
		MODEL-306A (2 THREAD) ABUTTED SEAM (MORE WIDTH) SEWING MACHINE 皮革、刷毛布厚類接布機專用 (特寬2線) For joining temporarily the abutted edges of piece goods for processing in bleaching, dyeing and printing factories.	
	 3 P	 2 P	MODEL-308 (2 THREAD、3 THREAD) CARPET OVEREDGING、NO TRIMMER SEWING MACHINE 地毯包邊機(厚類)無附切刀 (2線、3線) For overedging on carpet and similar goods of heavy materials.
	 3 P	 2 P	MODEL-309 (2 THREAD、3 THREAD) CARPET OVEREDGING、WITH TRIMMER SEWING MACHINE 地毯包邊機(中厚類)附切刀 (2線、3線) For overedging on carpet and similar goods of heavy materials.

SPECIFICATIONS

MODEL	NEEDLE	THREAD	 mm	ABUTTED WIDTH	 mm	CUFT	G.W.	N.W.
MODEL-302	DCx27 #16	1	----	10-13	1.8-6	1.4 CUFT	16 KG	13 KG
MODEL-303	DCx27 #16	3	----	8-10	1.8-6	1.4 CUFT	16 KG	13 KG
MODEL-306	DCx27 #16	2	----	10-13	1.8-6	1.4 CUFT	16 KG	13 KG
MODEL-306A	DCx27 #16	2	----	12-14	1.8-6	1.4 CUFT	16 KG	13 KG
MODEL-308	DMx5 #23 TTx81#23	3	10	----	1.8-4.5	1.4 CUFT	16 KG	13 KG
MODEL-309	DMx5 #23 TTx81#23	3	10	----	1.8-4.5	1.4 CUFT	16 KG	13 KG

CONTENTS

Page

1	Classification of Machines	1
2	Specification	1
3	Installation	2
4	Sewing Speed and Rotation of Pulley	2
5	Setting of Motor and Belt	2
6	Lubricant	3
6-1	Lubrication Oil	3
6-2	Oil Feeding	3
6-3	Oil Exchange	3
7	Proper Operation	4
7-1	Needle to Be Used	4
7-2	Setting of Needle	4
7-3	Threading	5
7-4	Thread Tension	5
7-5	Pressure of Presser Foot	6
7-6	Adjustment of Width of Overedge Seam	6
7-7	Adjustment of Stitch Length	7
8	Proper Adjustment	7
8-1	Adjustment of Feeding Mechanism	7
8-2	Adjustment of Presser Foot Mechanism	8
8-3	Adjustment of Needle Bar Stroke	10
8-4	Height of Needle Bar and Longitudinal Position of Lower Looper	10
8-5	Timing between Upper and Lower Loopers	11
8-6	Relation between Upper and Lower Loopers	11
8-7	Adjustment of Upper and Lower Knives	12
8-8	Adjustment of Auxiliary Stitch Tongue	13
8-9	Sharpening of Knives	13

1、 Classification of Machines

IDL-302 : For joining temporarily the abutted edges of piece goods for processing in bleadching , dyeing and printing factories . (1 Thread)

IDL-303 : For joining temporarily the abutted edges of piece goods for processing in bleadching , dyeing and printing factories . (3 Thread)

IDL-304 : For sewing Blanket and other materials of extra heavy duty , with knives for cutting fabric . (2 Threads)

IDL-306 : For joining temporarily the abutted edges of piece goods for processing in bleadching , dyeing and printing factories . (2 Threads)

IDL-306A : For joining temporarily the abutted edges of piece goods for processing in bleadching , dyeing and printing factories . (2 Threads & width)

IDL-308 : For sewing Carpet and other materials of extra heavy duty , without knives for cutting fabric . (3 Threads)

IDL-309 : For sewing Carpet and other materials of extra heavy duty , with knives for cutting fabric . (3 Threads)

IDL-309B : For sewing Carpet and other materials of extra heavy duty , with knives for cutting fabric . (2 Threads)

2、 Specification

	IDL-304、308、309、309B	IDL-302、303、306、306A
Dimensions	265(L) X 210(W) X 290(H)mm	
Weight	16kg	
Sewing Speed	Up to 3,000 s.p.m.	Up to 4,200 s.p.m.
Stitch Length	1.6~4.2mm 6~16 stitches per inch	
Width of Overedge Seam	9.0mm (standard)	7.0mm Abutted width 14mm
Needle to be used	DMX5 #23	DCX27 #16
Needle Bar Stroke	30mm	
Presser Foot Lifting	4.3mm	2.5mm
Lubricant	Automatic feeding by gear pump .	
Lubrication Oil	“SF OIL” or “TERESSO 46”	

3、 Installation

Standard Installation - the machine shall be installed on the top face of Table .

Put the machine at the fixed place on the Table and tighten Screws .

The machine is obtainable in a set with Table , if necessary , as we are ready to supply all parts concerned together with Table .

4 · Sewing Speed and Rotation of Pulley

The highest sewing speed is 3,000 s. p. m. for IDL-304 · IDL-308 · IDL-309 · IDL-309b and 4,200 s. p. m. For IDL-302 · IDL-303 · IDL-306 · IDL-306A . For the brand - new machines , it is recommended to rotate 15% ~ 20%

under max. speed for the initial 200 hours (one month approximately). This manner will bring the good result to the durability of machines .

Sa seen from the side of Pulley , the machine rotates to the right direction .

5 · Setting of Motor and Belt

Clutch Motor of 200 W (1/4 HP) shall be used and V-Belt of Type “M” also .

To position the Motor , as the sketch shows , align both center lines of Motor Pulley and Machine Pulley exactly .

External Diameter Of motor Pulley	Rotation of Machine			
	IDL-302 · 303 · 306 · 306A		IDL-304 · 308 · 309 · 309B	
	50HZ	60HZ	50HZ	60HZ
50mm	--	3,200	--	2,300
55mm	--	3,500	--	2,600
60mm	3,200	3,800	2,300	2,800
65mm	3,500	4,200	2,600	3,000
70mm	3,800	--	2,800	--
75mm	4,000	--	3,000	--
80mm	4,300	--	--	--

External Diameter of Machine Pulley specified on the Table here above are those nearest to calculated values , because Pulleys are being sold at the step of 5mm in the market .

6、Lubricant

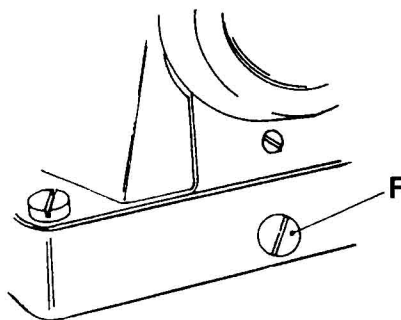
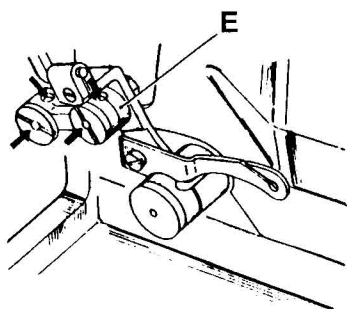
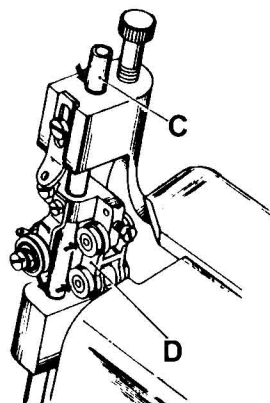
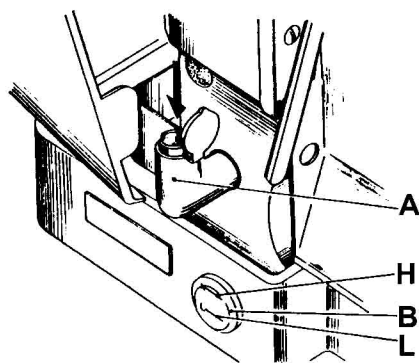
6-1、Lubrication Oil

Use "SF OIL" or "TERESSO 46" as the lubricant for this machine .

6-2、Oil Feeding

Oil in the machine will have been drained completely at the time of delivery , so it must be fed with new oil before operation .

Feeding shall be made quietly to Oil Cap(A) and the oil surface must be kept between two Lines(H) , (L) on Oil Sight Gauge(B) . And , at least once each in the morning and afternoon , feed oil manually to Needle Bar(C) , Needle Bar Connecting Link(D) and Lower Loper Connecting Link(E) . However , fabrics may be soiled when feeding oil around Needle Bar too much . Take care , please .



6-3、Oil Exchange

After the initial 200 hour's use of new machine , to keep it long life , remove Drain Screw (F) under the Pulley and drain used oil completely to change for new oil .

At this time remove Base from the machine and clean filter Screens and inside of the Base .

The cleaning must be made 2 or 3 times regularly in a year .

7、Proper Operation

7-1、Needle to Be Used

For IDL-302、303、306、306A : DCX27 #16

For IDL-304、308、309、309B : DMX5 #22 #23

As the standard size , #22 or # 23 is used .

But , # 16 can be used by changing Stitch Plate and Needle Guard .

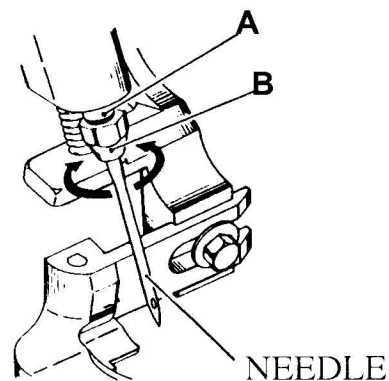
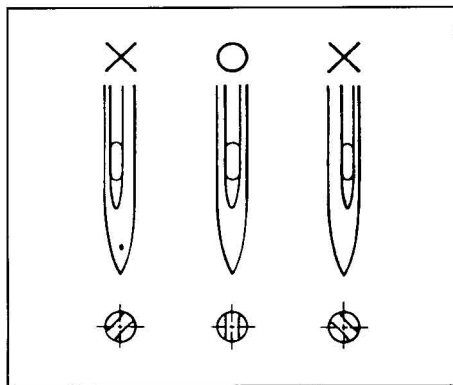
So , the needle of suitable size to the sewing condition must be selected .

7-2、Setting of Needle

Needle must be set correctly facing its scarf towards the back side of machine as shown in the sketch .

The setting order is :

- 1>、Turn Pulley until Needle Bar(A) reaches its highest position .
- 2>、Loosen Nut(B) of Needle Clamp by Wrench Spunner and pull off the needle downwards .
- 3>、Insert new needle to Needle bar to the facing is obtained as mentioned above .



7-3 · Threading

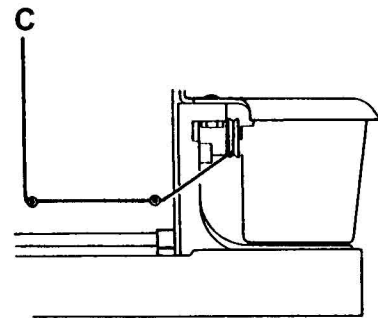
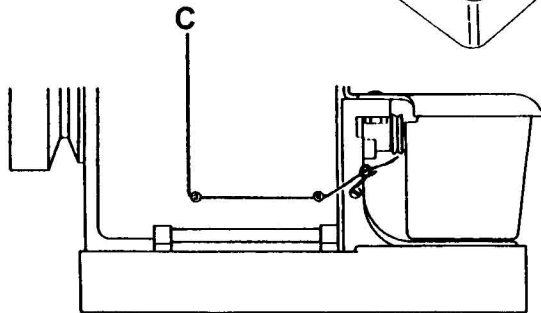
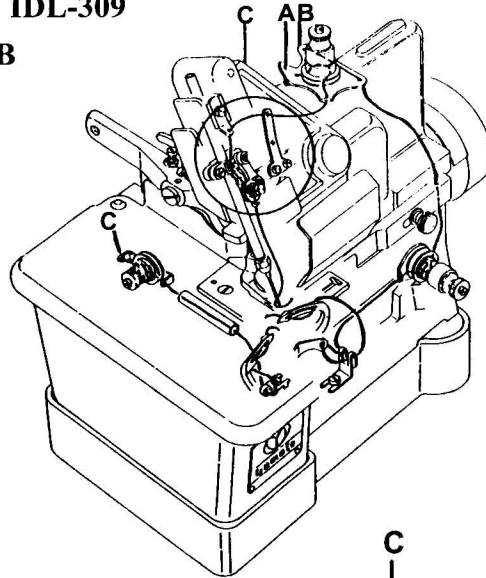
Threading must be made correctly according to the sketch .

A: Needle Thread B: Upper Looper Thread C: Lower Looper Thread

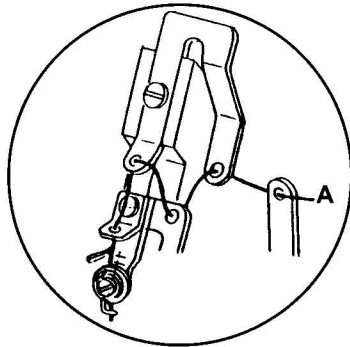
IDL-303 IDL-304

IDL-308 IDL-309

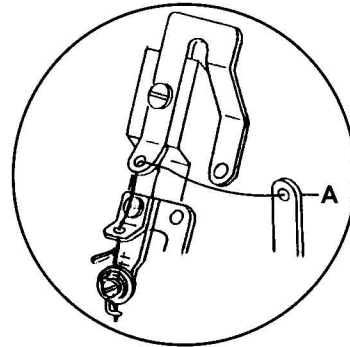
IDL-309B



IDL-302



IDL-306
IDL-306A



7-4 · Thread Tension

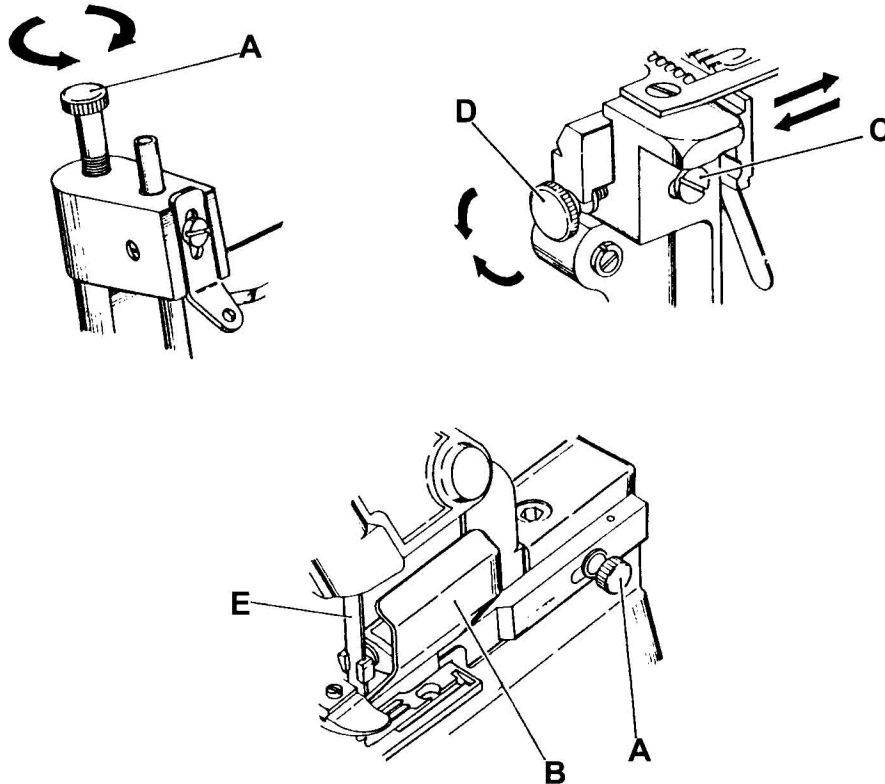
Thread tension shall be varied according to the kind of fabrics on threads , width of overedge seam , stitch length and other factors . So , adjust the thread tension mechanism for needle thread and upper , lower looper threads to obtain the suitable seam .

7-5 · Pressure of Presser Foot

The pressure of Presser Foot must be adjusted as weakly as possible .

If it is too weak , however , uniformity in the feeding and seaming may be lacked .

The pressure shall be strengthened when Adjusting Screw(A) is turned to right and weakened by turning(A) to left .



7-6 · Adjustment of width of Overedge Seam

The width of Overedge Seam can be adjusted by cutting margin of material by knife .

The adjustment is made in the following order :

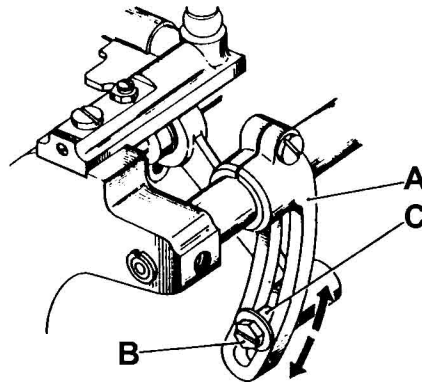
- 1> · Loosen Screw(A) of Chip Guard and move the Chip Guard(B) to the right .
- 2> · Loosen Screw(C) for Lower Knife Holder , and turn Screw(D) . Turning(D) to the right the width of Overedge Seam becomes wide and turning it to the left it becomes narrow .
- 3> · After adjustment , tighten Screw(C) .
- 4> · With Chip guard(B) contacting lightly to the Upper Knife(E) , tighten Screw(A) .

7-7 、 Adjustment of Stitch Length

Stitch length can be adjusted from 1.6mm to 6mm steplessly .

To obtain the stitch length as you desire , loosen Adjusting Screw(B) of Feed Regulator(A) and move Feed Dog Driving Connecting Rod(C) up and down along the groove of the Regulator(A) .

The stitch length becomes long when the Rod(C) is raised and short when the Rod(C) is lowered .

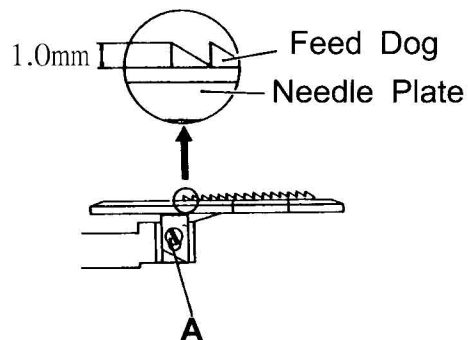


8 、 Proper Adjustment

8-1 、 Adjustment of Feeding Mechanism

1> 、 Height

When Feed Dog reaches the highest position , loosen Screw(A) and adjust the last teeth edge on the tail of Feed Dog to have 1.0mm for the height from top of Stitch Plate .

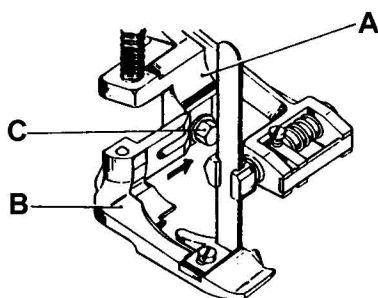
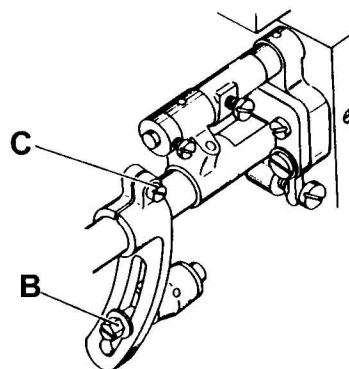
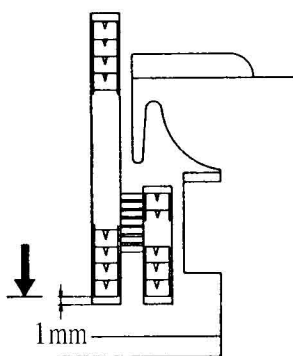


2> Longitudinal Position

Loosen Adjusting Screw(B) of Feed Regulator and tighten it at the highest position .

When Feed Dog comes to the foremost by turning Pulley , adjust the allowance between Front of groove in Stitch Plate and the point of Feed Dog to be 1mm . Then , tighten Screw(C) of Feed Regulator .

After the above adjustment , refer to 7-7 “Adjustment of Stitch Length” adjust to obtain the suitable stitch length by loosening Adjusting Screw(B) .



8-2 Adjustment of Presser Foot Mechanism

1> Fitting of Presser Foot

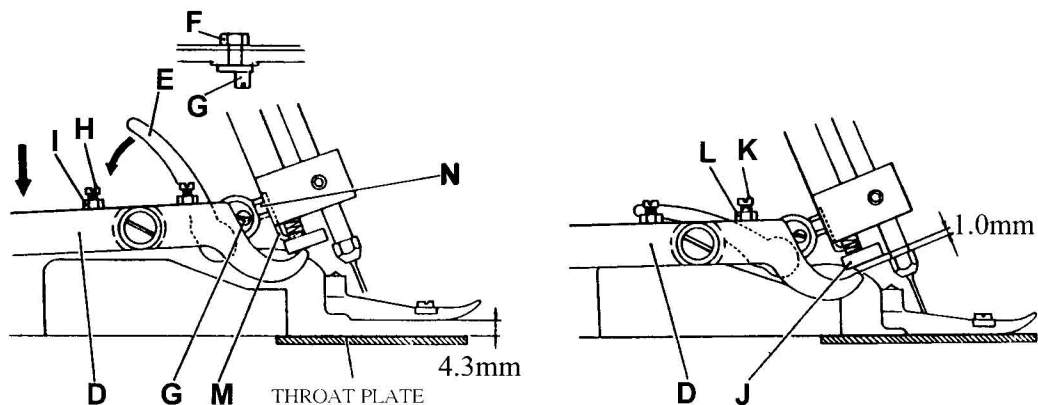
Turn Pulley until Needle Bar comes the highest position , then insert Presser Foot(B) to the groove of Presser Arm(A) .

And , turn Pulley again and adjust the needle to drop to the center of needle drop portion on Presser Foot . And tighten Screw(C) .

2> Height of Presser Foot

Adjust the height according to the following order :

- a> Remove Foot lifter Lever(D) .
- b> Raise foot Lifter Hand lever (E) .
- c> Loosen Nut(F) and turn Screw(G) of Presser Arm Eccentric to obtain 4.3mm (2.5mm for IDL-306) , the distance between the bottom of Foot and the top face of Stitch Plate . Re-tighten Nut(F) .
- d> Fit foot Lifter Lever(D) .
- e> Loosen Adjusting Screw(H) and push Foot Lifter Lever(D) downwards by hand until Foot Lifter Hand Lever(E) falls to the arrow direction . Tighten Nut(I) .
- f> When Presser Foot Lowers to the top face of stitch Plate , turn Adjusting screw(K) and adjust the allowance between foot Lifter Lever(D) and the bottom of Presser Arm(J) to be 1.0mm , then tighten Nut(L) .



During operation , when Presser Foot agrounds on the very thick part of fabric and lifts beyond 4.3mm , Loper may contact the Foot . As the result , Loper and other parts may be dam aged .

For those obstruction as mentioned above , keeping the Foot lifted in 4.3mm , apply Presser Arm Stopper(M) to Presser Arm(J) and tighten Screw(N) .

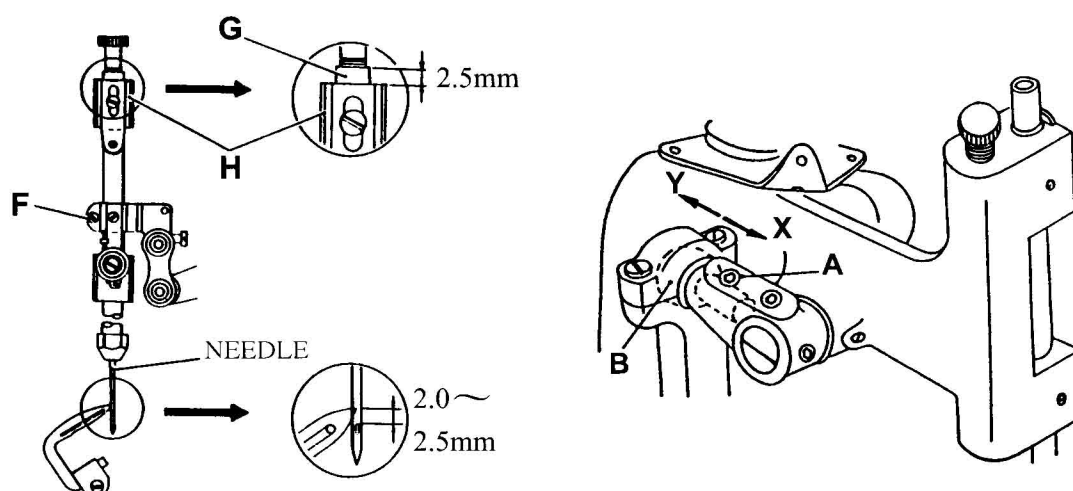
8-3 、 Adjustment of Needle Bar Stroke

The standard stroke of Needle Bar is 30mm .

After loosening Screw(A) , when Needle Bar Driving Crank Ball Stud(B) is put inside to the arrow direction(X) the stroke becomes big , and outside to the direction(Y) the stroke becomes small .

Tighten Screw(A) after adjustment .

When Ball stud is put inside to the direction(X) , be carefully that rod does not contact with crankshaft .



8-4 、 Height of Needle Bar and Longitudinal Position of Lower Loooper

When Lower Loooper(E) moves to right from left end and its point reaches the center of Needle , adjust the distance between the looper point and the upper edge of needle eye to be 2.0~2.5mm .

This adjustment is made by loosening Screw(F) of Needle Bar Connecting Bracket .

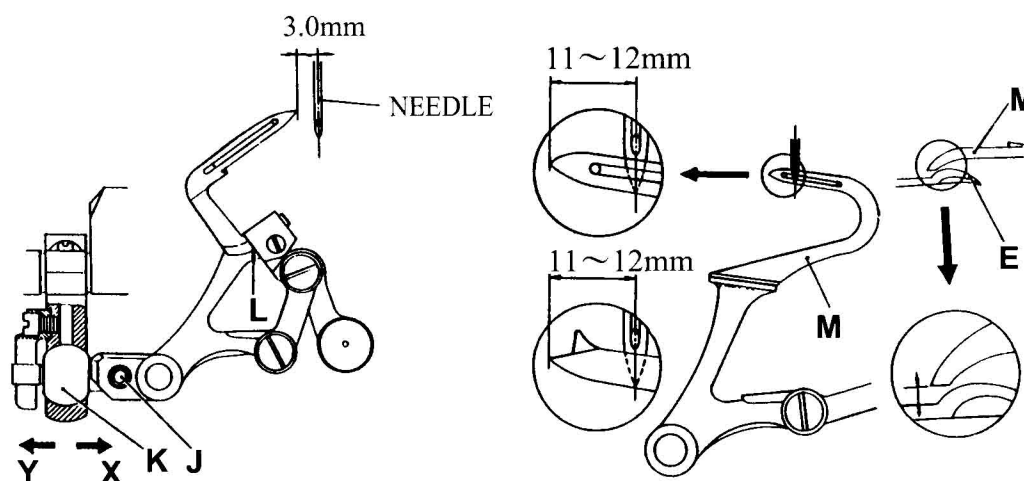
When Needle Bar lowers to its bottom , the distance between both upper edges of Needle Bar(G) and Arm(H) shall be 2.5mm . which is considered as the standard distance generally .

The point of Lower Loooper passes behind Needle and they must be closed as near as possible but without touch . This adjustment is made by loosening Screw(I) .

8-5 · Timing between Needle and Lower Loooper

When Lower Loooper swings to left end , the distance between its point and the center of Needle shall be 3.0mm . This adjustment is made by loosening Screw(J) and putting the Ball Stud(K) inside or outside . By putting the Ball Stud(K) inside to the direction(X) , the moving amount of the looper mechanism becomes big , and outside to the direction(Y) the amount becomes small .

Owing to the abovementioned , the position of Lower Loooper at its left end is changed inevitably . Furthermore , the portion(L) of Lower looper must always stick to Lower Loooper Holder Arm .



8-6 · Relation between Upper and Lower Loopers

When Upper Loooper(M) and Lower Loooper(E) meet together , the point of Upper Loooper passes the depression just under the swelling on the back of the point of Lower Loooper . at this moment , both Loopers must be closed as nearly as possible but without touch .

When Upper looper passes the front side of Needle and reaches the left end of its movement , the distance between the point of Upper Loooper and the center of Needle shall be 11~12mm approximately .

(In case of IDL-306 the distance the point of Spreader and the center of Needle should also be 11~12mm .)

8-7、Adjustment of Upper and Lower Knives

To fit Lower Knife(A) , push Upper Knife Holder(B) to right and insert the Lower Knife upwards along the groove on Lower Knife Holder .

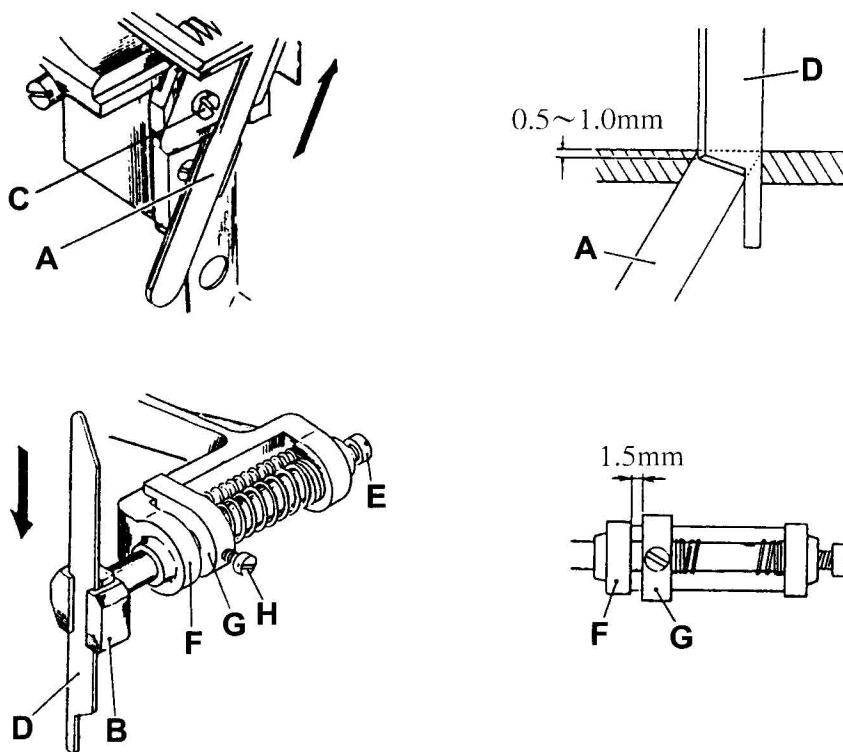
In the above fitting , make the Blade of Lower Knife even with the top face of Stitch Plate or a little lower (0~0.3mm) . This Adjustment is made by loosening Screw(C) .

When Upper Knife(D) lowers to the bottom , adjust the engagement with Lower Knife(A) to be 0.5~1.0mm . This adjustment is made by loosening Screw(E) of Upper Knife Clamp .

The pressure of engagement of both Knives shall be adjusted by loosening Screw(H) .

When Upper Knife Holder Guide(G) is moved to right the pressure becomes strong and to left the pressure becomes weak .

Under the standard condition of pressure , the allowance between Upper Knife Driving Arm Stud(F) and Holder Guide(G) shall be 1.5mm .



8-8 、 Adjustment of Auxiliary Stitch Tongue

When fixing Auxiliary Stitch Tongue , take care that it does not touch Upper and Lower Loper .

IDL-302

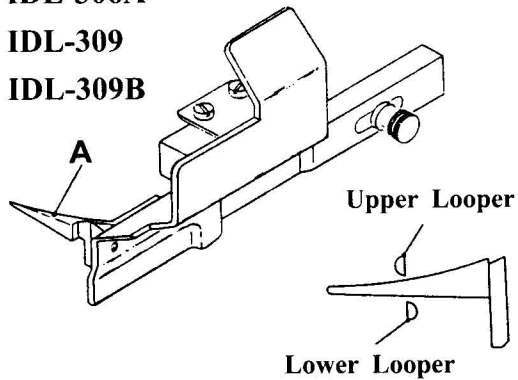
IDL-304

IDL-306

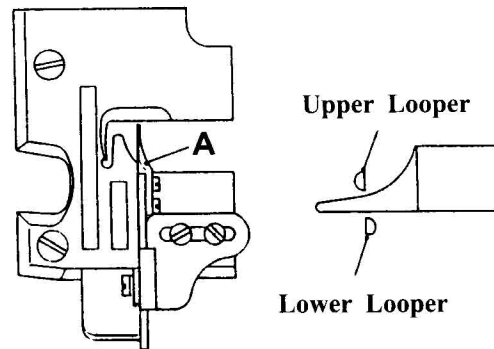
IDL-306A

IDL-309

IDL-309B

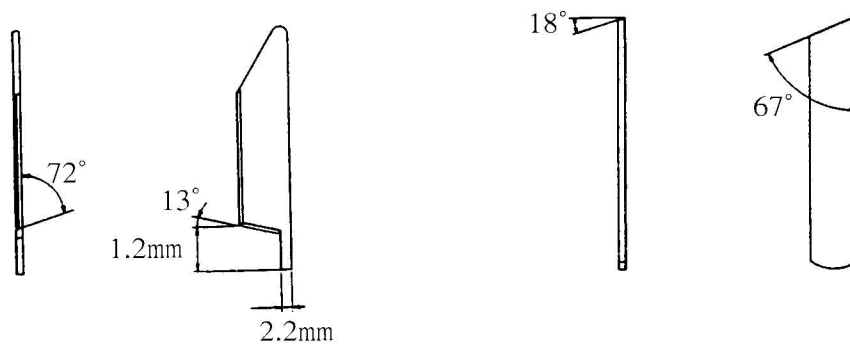


IDL-308

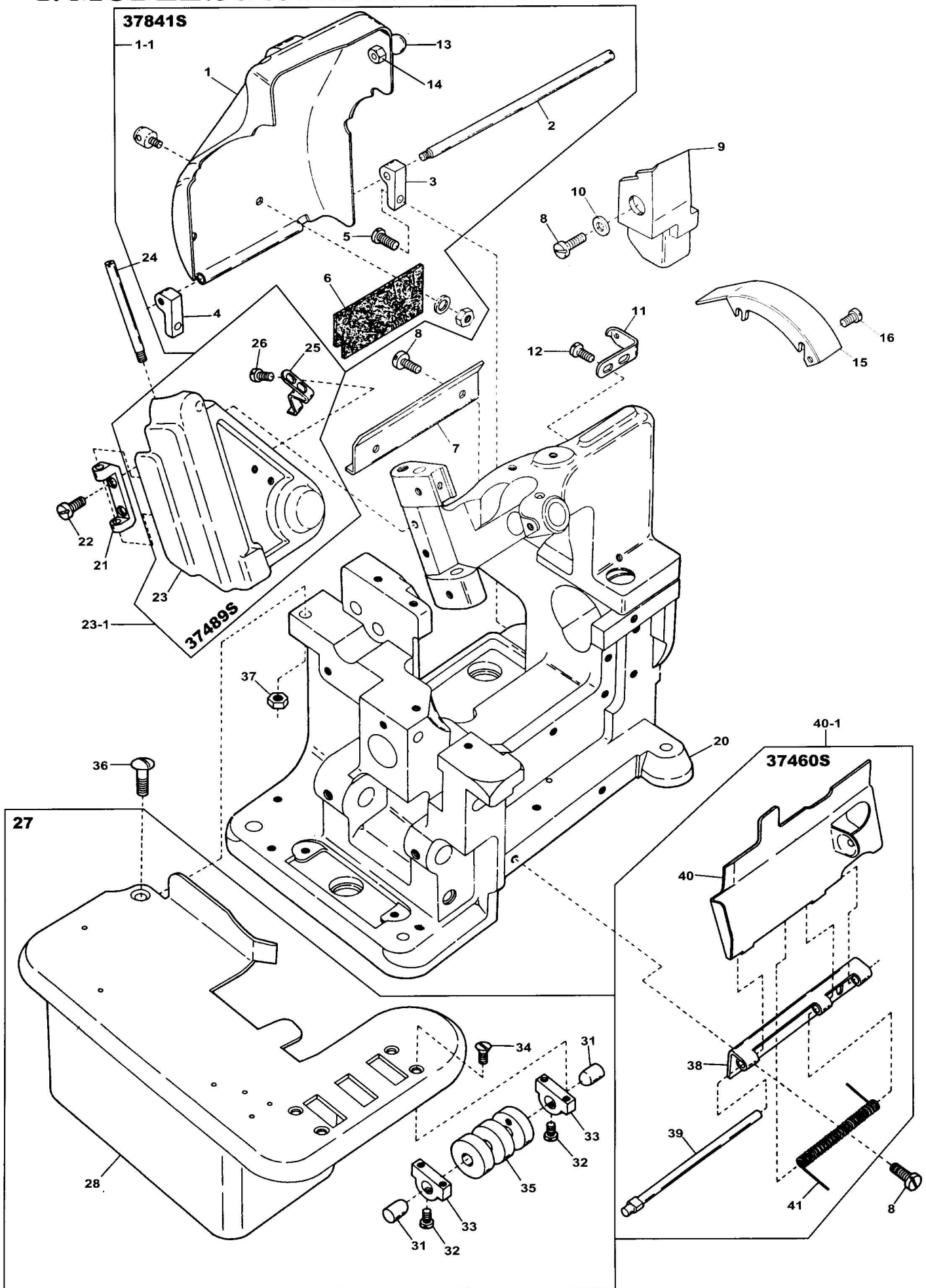


8-9 、 Sharpening of Knives

Knives must be re-sharpened when the sharpness become blunt . The sketches show angles of Blade on both knives . When Sharpening Upper Knife , the part(H) must be 12mm as the dimension indicated .



1. MODEL:302/303/304/306/306A

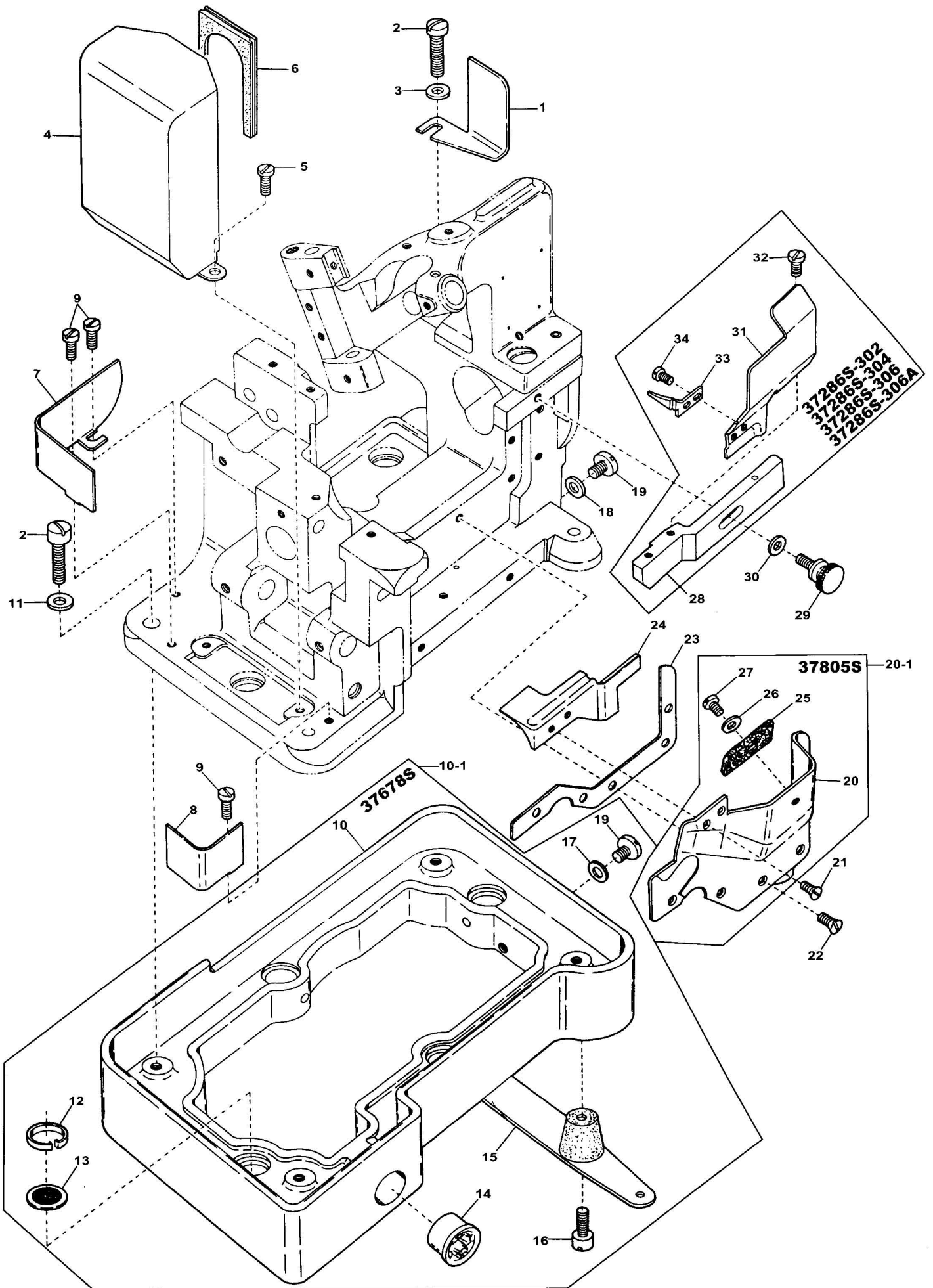


1 . MISCELLANEOUS COVERS (1)

REF NO.	PARTS NO.	DESCRIPTION
1	37841	Rear Cover Unit
1-1	37841S	Complete Set
2	37612	Rear Cover Hinge Pin
3	37609	Rear Cover Hinge (Right)
4	37610	Rear Cover Hinge (Left)
5	7609	Screw
6	37569	Rear Cover Felt
7	38229	Plate
8	1175	Screw
9	37622	Front Cover (Fixed)
10	541	Washer
11	37613	Rear Cover Spring
12	1196	Screw
13	37481S	Ball Screw
14	37481N	Nut
15	37544	Belt Cover
16	1208	Screw
17	----	----
18	----	----
19	----	----
20	----	Machine Frame Unit
21	37616	Needle Bar Cover Bracket
22	7616	Screw
23	37489	Needle Bar Cover
23-1	37489S	Complete Set
24	37617	Needle Bar Cover Pin
25	37618	Needle Bar Cover Latch Spring
26	1227	Screw
27	----	Cloth Plate Complete Set
28	37495	Cloth Plate
29	----	----
30	----	----
31	37453	Roller Holder
32	3433	Screw
33	37809	Roller Holder Bracket
34	5345	Screw
35	37452	Roller
36	2419	Screw
37	144	Nut
38	37605	Front Cover Hinge
39	37606	Front Cover Hinge Pin
40	37460	Front Cover
40-1	37460S	Complete Set
41	37607	Front Cover Restoring Spring

REF NO.	MODEL	PARTS NO.	DESCRIPTION
20	IDL-302	37482	Machine Frame Unit
	IDL-303	37801	Machine Frame Unit
	IDL-304	37801	Machine Frame Unit
	IDL-306	37482	Machine Frame Unit
	IDL-306A	37801	Machine Frame Unit
27	IDL-302	37495S	Cloth Plate Complete Set
	IDL-303	37834S	Cloth Plate Complete Set
	IDL-304	37834S	Cloth Plate Complete Set
	IDL-306	37495S	Cloth Plate Complete Set
	IDL-306A	37834S	Cloth Plate Complete Set

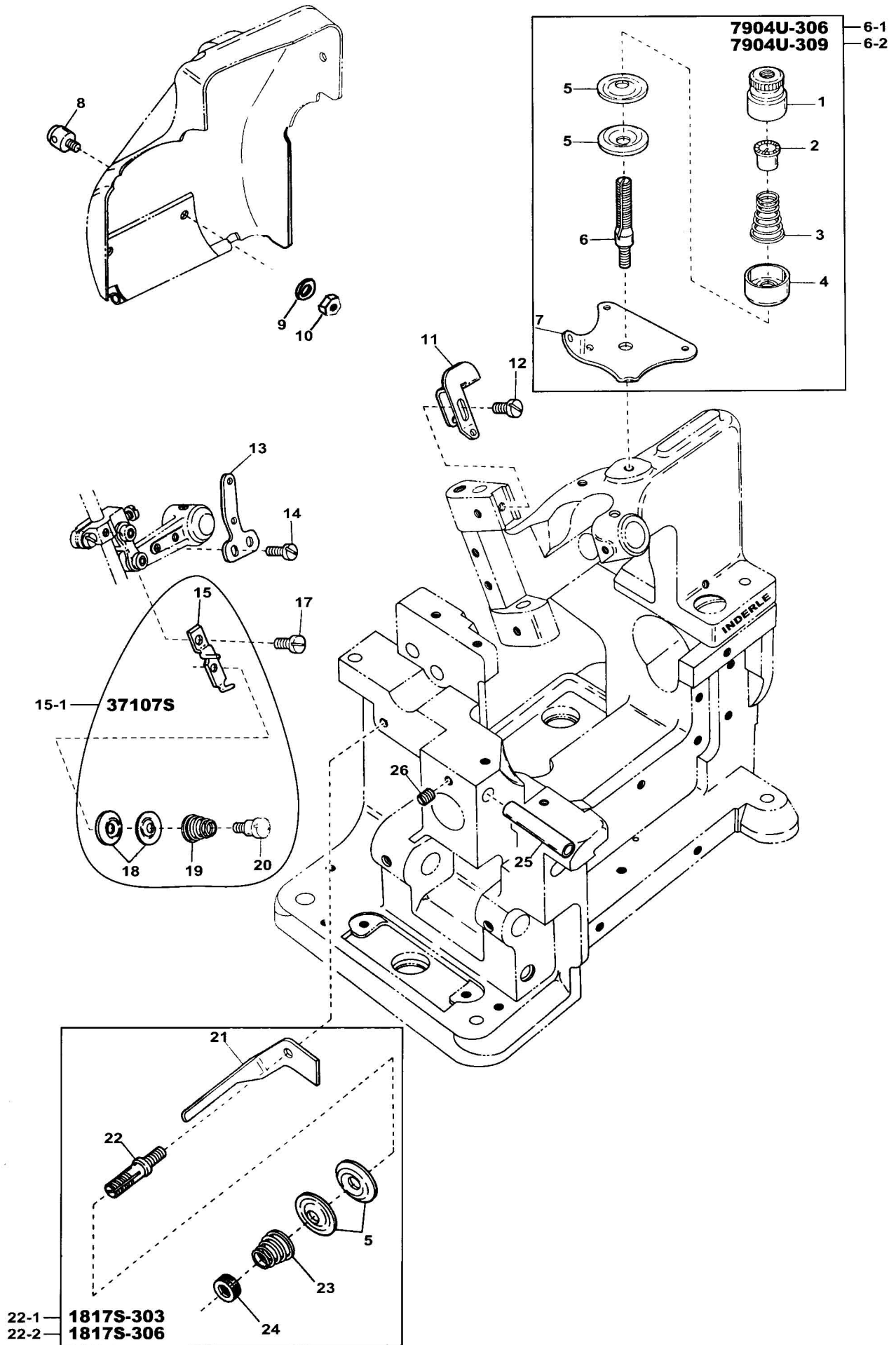
2. MODEL:302/303/304/306/306A



2. MISCELLANEOUS COVERS (2)

REF NO.	PARTS NO.	DESCRIPTION	
1	37709	Dust Plate	
2	7763	Screw	
3	562	Washer	
4	37624	Looper Connecting Rod Cover	
5	9604	Screw	
6	37699	Looper Connecting Rod Cover Gasket	
7	37626	Angled Cover (Large)	
8	37627	Angled Cover (Small)	
9	1208	Screw	
10	37678	Base	
10-1	37678S	Complete Set	
11	500	Washer	
12	37681	Oil Filter Screen Camp	
13	37680	Oil Filter Screen	
14	37679	Oil Sight Gauge	
15	37540	Base Rubber Cushion Unit	
16	5083	Screw	
17	568	Gasket	
18	567	Gasket	
19	5062	Screw	
20	37805	Front Oil Shield	
20-1	37805S	Complete Set	
21	1613	Screw	
22	7619	Screw	
23	37620	Front Oil Shield Gasket	
24	37842	Front Oil Shield (Upper)	
25	37692	Felt	
26	531	Washer	
27	7616	Screw	
28	----	Chip guard Holder	
29	1218	Screw	
30	554	Washer	
31	----	Chip Guard (Upper)	
32	1175	Screw	
33	----	Auxiliary Stitch Tongue	
34	4237	Screw	
REF NO.	MODEL	PARTS NO.	DESCRIPTION
28	IDL-302	37466	Chip Guard Holder
	IDL-303	37637	Chip Guard Holder
	IDL-304	37637	Chip Guard Holder
	IDL-306	37466	Chip Guard Holder
	IDL-306A	37466	Chip Guard Holder
31	IDL-302	37461	Chip Guard
	IDL-303	37461	Chip Guard
	IDL-304	37461	Chip Guard
	IDL-306	37487	Chip Guard
	IDL-306A	37461	Chip Guard
33	IDL-302	37286-306A	Auxiliary Stitch Tongue
	IDL-304	37286-304	Auxiliary Stitch Tongue
	IDL-306	37286	Auxiliary Stitch Tongue
	IDL-306A	37286-306A	Auxiliary Stitch Tongue

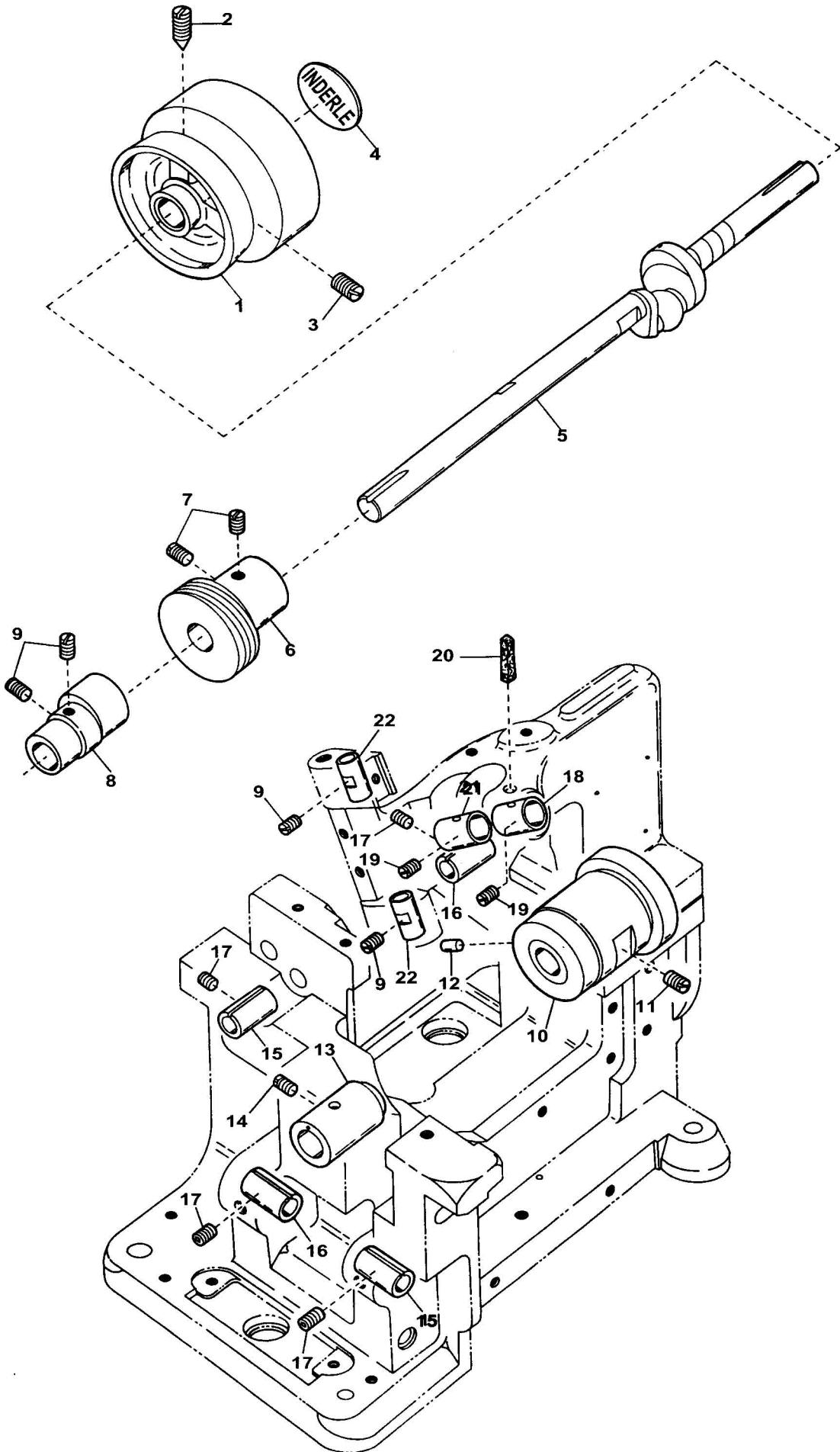
3. MODEL:302/303/304/306/306A



3. MISCELLANEOUS THREAD EYELETS

REF NO.	PARTS NO.	DESCRIPTION	
1	37634	Thread Tension Spring Cap	
2	37170	Tension Spring Bushing	
3	-----	Needle Thread Tension Spring	
4	37635	Thread Tension Spring Retainer	
5	31111	Tension Disc	
6	7904	Tension Post	
6-1	7904U-306	Complete Set	
6-2	7904U-309	Complete Set	
7	37812	Tension Disc Eyelet	
8	38364	Rear Cover Thread Eyelet	
9	531	Washer	
10	12	Nut	
11	37262	Needle Thread Eyelet	
12	4358	Screw	
13	37060	Needle Thread Sewing Eyelet	
14	1196	Screw	
15	37107	Needle bar Thread Retainer Bracket	
15-1	37107S	Complete set	
16	-----	-----	
17	1222	Screw	
18	37108	Thread Retainer Disc	
19	37109	Thread Retainer Spring	
20	1093	Screw	
21	-----	Side Thread Latch	
22	1817	Tension Post	
22-1	1817S-303	Complete set	
22-2	1817S-306	Complete set	
23	-----	Looper Thread Tension Spring	
24	56	Adjusting Nut	
25	37112	Lower Looper Thread Pipe	
26	1457	Screw	
REF NO.	MODEL	PARTS NO.	DESCRIPTION
21	IDL-303	37016	Side Thread Latch
	IDL-304	38074	Side Thread Latch
	IDL-306	37016	Side Thread Latch
	IDL-306A	37016	Side Thread Latch
23	IDL-303	37632	Looper Thread Tension Spring
	IDL-304	37115	Looper Thread Tension Spring
	IDL-306	37115	Looper Thread Tension Spring
	IDL-306A	37115	Looper Thread Tension Spring
3	IDL-302	37115	Needle Thread Tension Spring
	IDL-303	37113	Needle Thread Tension Spring
	IDL-304	37115	Needle Thread Tension Spring
	IDL-306	37115	Needle Thread Tension Spring
	IDL-306A	37115	Needle Thread Tension Spring
	IDL-308	37632	Needle Thread Tension Spring
	IDL-309	37632	Needle Thread Tension Spring

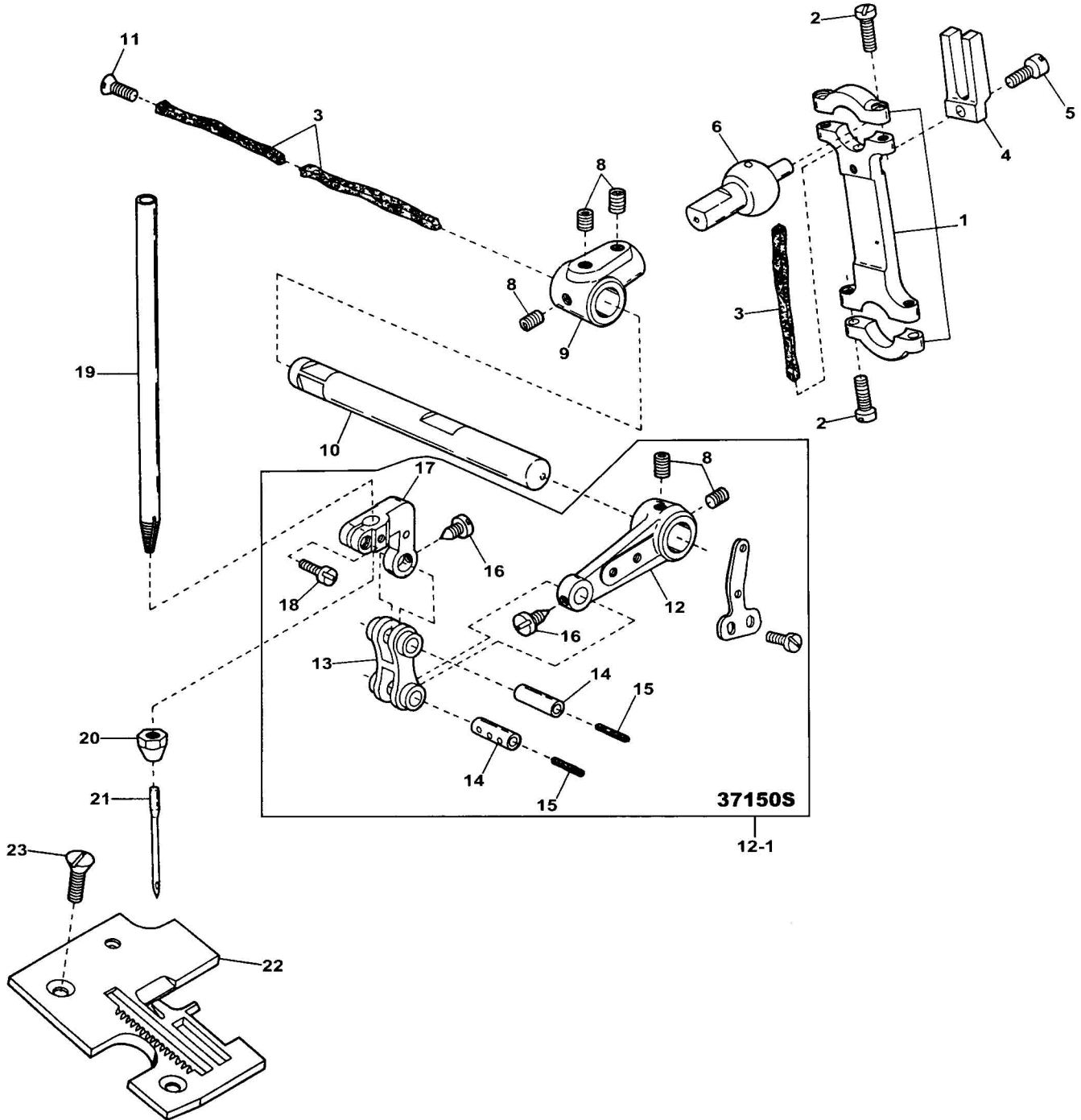
4. MODEL:302/303/304/306/306A



4. MISCELLANEOUS CRANKSHAFT & BUSHINGS

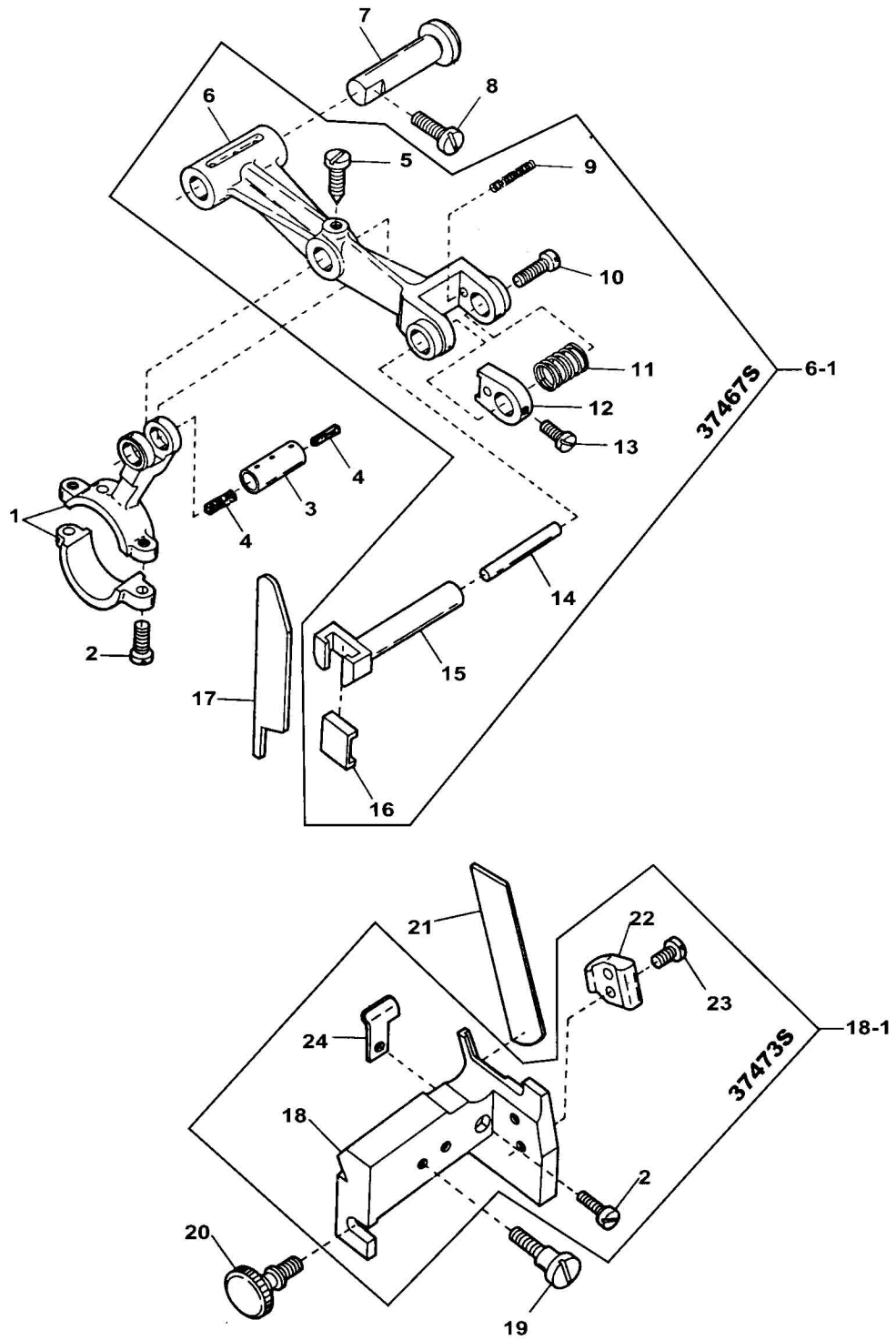
REF NO.	PARTS NO.	DESCRIPTION	
1	-----	Pulley	
2	3591	Screw	
3	3593	Screw	
4	989	Hand wheel Mark	
5	37799	Main Crankshaft	
6	37650	Feed Driving Eccentric	
7	7650	Screw	
8	37462	Feed and Upper Knife Eccentric	
9	1457	Screw	
10	37547	Crankshaft Bushing (Right)	
11	3639	Screw	
12	294	Oil Wick	
13	37645	Crankshaft Bushing (Middle)	
14	2022	Screw	
15	37409	Feed Bar and Upper Looper Bushing	
16	37654	Feed Bar and Upper Looper Bushing	
17	3635	Screw	
18	37133	Needle Bar Driving Crank Bushing (Front)	
19	3434	Screw	
20	290	Oil Wick	
21	37134	Needle Bar Driving Crank Bushing (Rear)	
22	37049	Needle Bar Bushing	
PREF NO.	MODEL	PARTS NO.	DESCRIPTION
1	IDL-302	37703	Pulley
	IDL-303	37703	Pulley
	IDL-304	37816	Pulley
	IDL-306	37703	Pulley
	IDL-306A	37703	Pulley

5. MODEL:302/303/304/306/306A



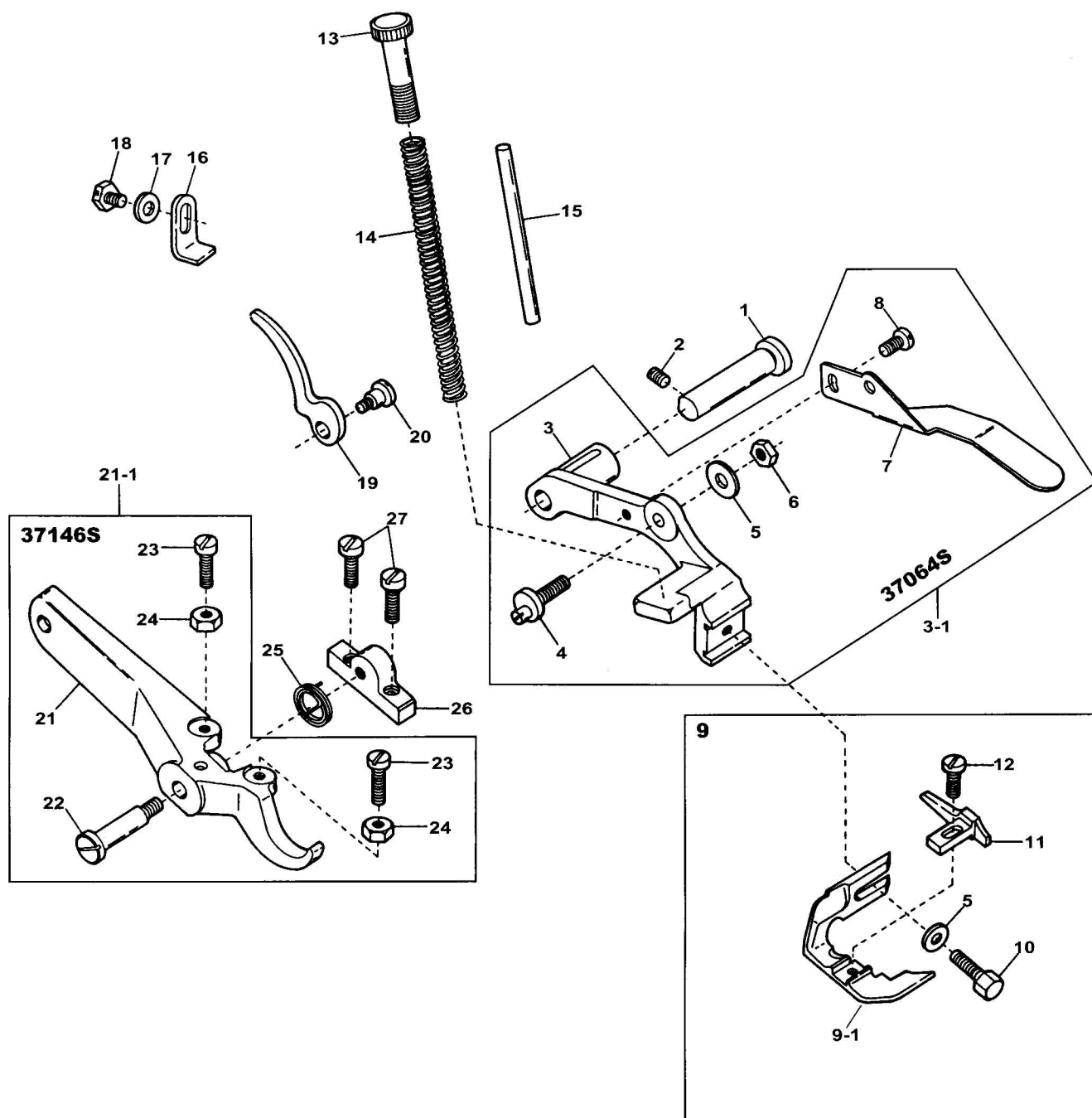
5. NEEDLE BAR DRIVING MECHANISM			
REF NO.	PARTS NO.	DESCRIPTION	
1	37057	Needle Bar Connecting Rod	
2	7311	Screw	
3	304	Oil Wick	
4	37130	Connecting Rod Guide Fork	
5	1170	Screw	
6	37132	Driving Crank Ball Stud	
7	----	-----	
8	3635	Screw	
9	37127	Driving Crank (Rear)	
10	37059	Driving Crankshaft	
11	9932	Screw	
12	37150	Driving Crank (Front)	
12-1	37150S	Complete Set	
13	90321	Connecting Link	
14	90320	Connecting Link Pin	
15	278	Oil Wick	
16	4313	Screw	
17	37818	Needle Bar Connecting Bracket	
18	4435	Screw	
19	37062	Needle Bar	
20	62	Nut	
21	----	Needle	
22	----	Stitch Plate	
23	1732	Screw	
REF NO.	MODEL	PARTS NO.	DESCRIPTION
21	IDL-302	DCx27#16	Needle
	IDL-303	DCx27#16	Needle
	IDL-304	DMx5#23	Needle
	IDL-306	DCx27#16	Needle
22	IDL-306A	DCx27#16	Needle
	IDL-302	37483-302	Stitch Plate
	IDL-303	37483-303	Stitch Plate
	IDL-304	37459B	Stitch Plate
	IDL-306	37483	Stitch Plate
	IDL-306A	37483-306A	Stitch Plate

6. MODEL:302/303/304/306/306A



6. KNIFE DRIVING MECHANISM			
REF NO.	PARTS NO.	DESCRIPTION	
1	37883	Upper Knife Connecting Rod	
2	1174	Screw	
3	37876	Connecting Rod Pin	
4	290	Oil Wick	
5	1176	Screw	
6	-----	Upper Knife Driving Arm Stud	
6-1	37467S	Complete Set	
7	37552	Driving Arm Stud Pin	
8	7311	Screw	
9	30414	Upper Knife Holder Spring (Small)	
10	1132	Screw	
11	30413	Upper Knife Holder Spring	
12	37478	Upper Knife Holder Guide	
13	1222	Screw	
14	37475	Upper Knife Clamp Pin	
15	37470	Upper Knife Holder	
16	37471	Upper Knife Clamp	
17	37469	Upper Knife	
	37468T	Upper Knife Tungsten	
18	37473	Lower Knife Holder	
18-1	37473S	Complete Set	
19	2086	Screw	
20	2369	Adjusting Screw	
21	37472	Lower Knife	
22	37474	Lower Knife Clamp	
23	7405	Screw	
24	37458	Needle Guard	
REF NO.	MODEL	PARTS NO.	DESCRIPTION
6	IDL-302	37467	Upper Knife Driving Arm Stud
	IDL-303	37467L	Upper Knife Driving Arm Stud
	IDL-304	37467L	Upper Knife Driving Arm Stud
	IDL-306	37467	Upper Knife Driving Arm Stud
	IDL-306A	37467L	Upper Knife Driving Arm Stud
	IDL-309	37467L	Upper Knife Driving Arm Stud
	IDL-309B	37467L	Upper Knife Driving Arm Stud

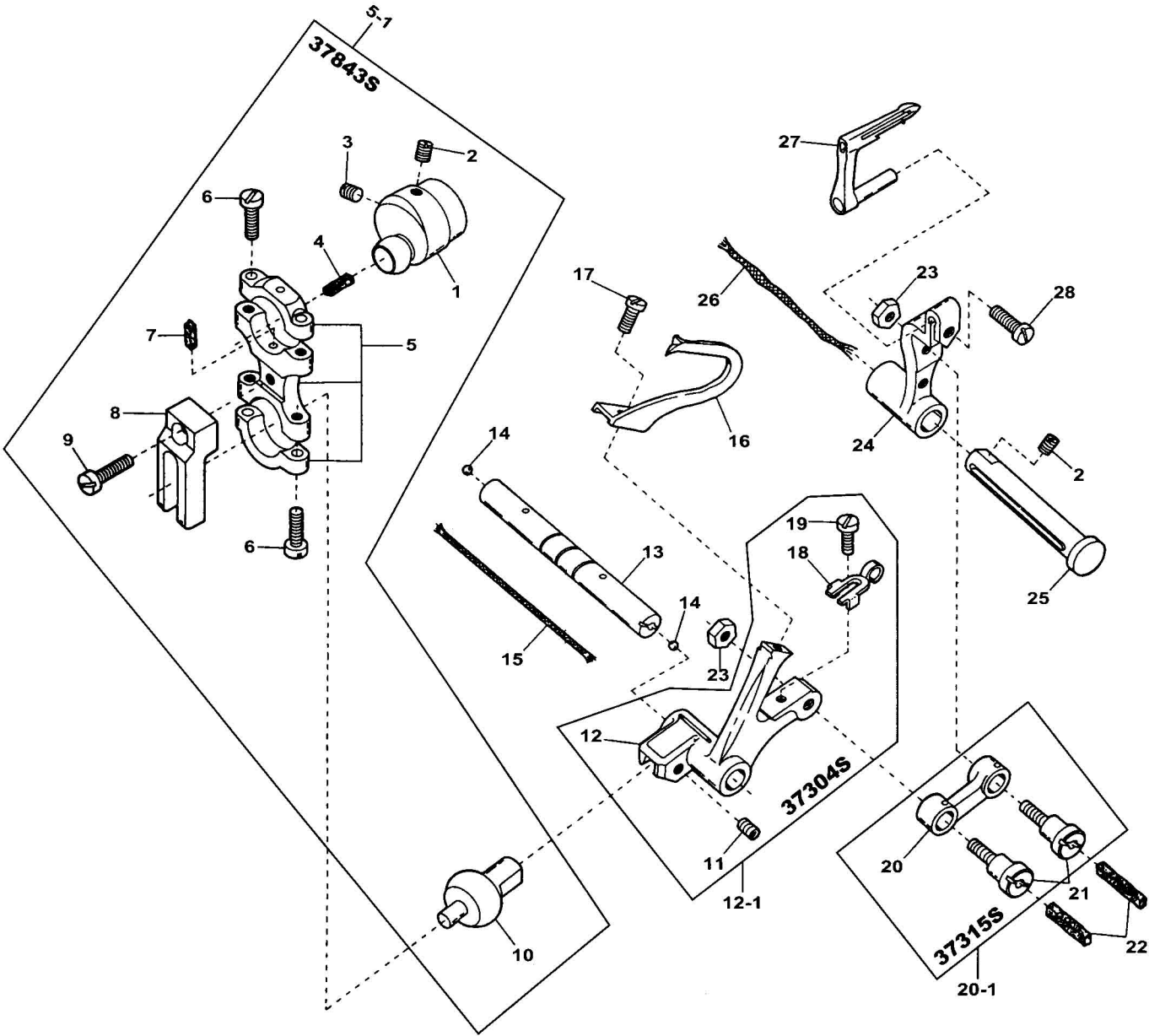
7. MODEL:302/303/304/306/306A



7. PRESSER FOOT MECHANISM

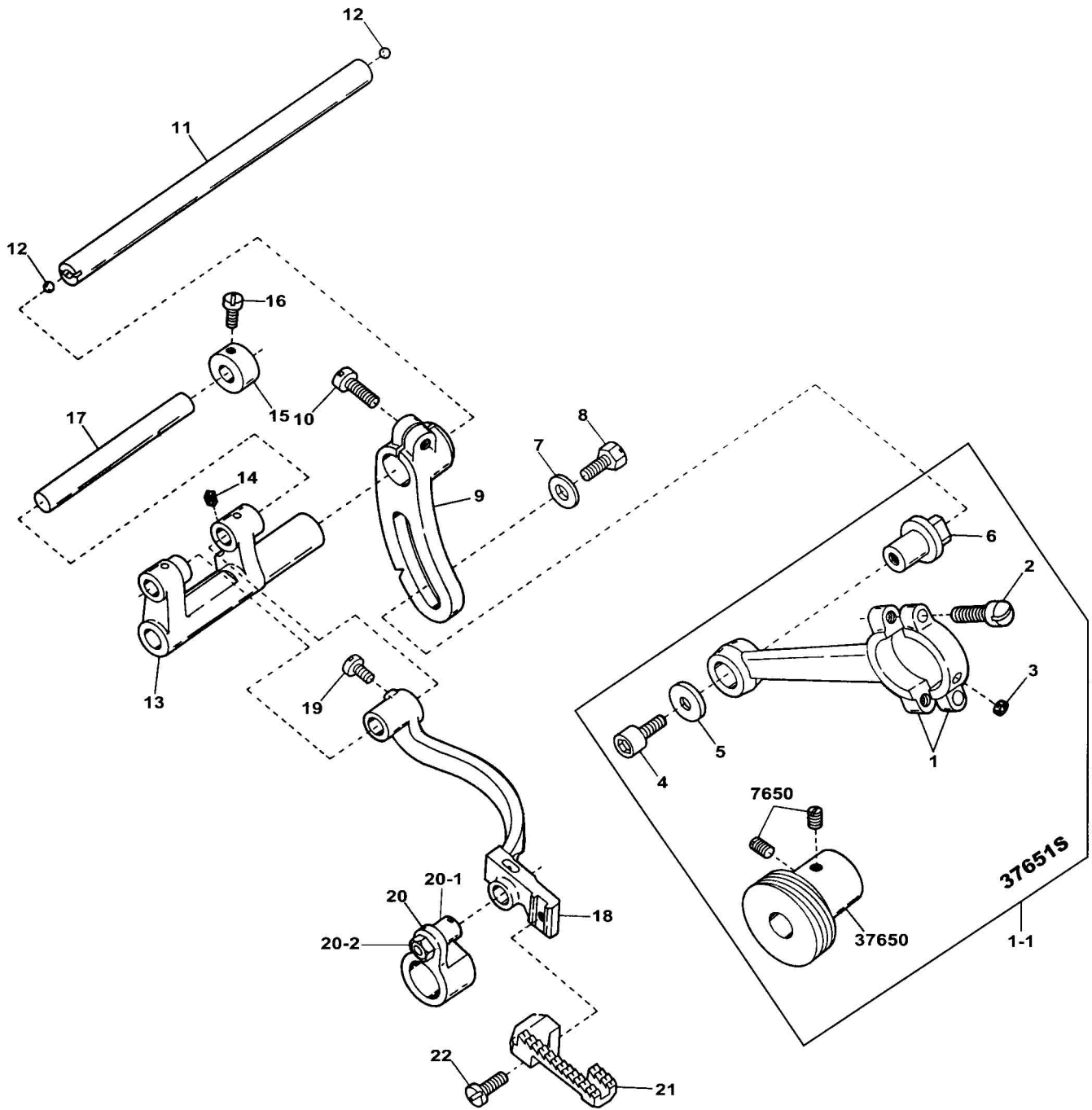
REF NO.	PARTS NO.	DESCRIPTION	
1	37552	Presser Arm Hinge Stud	
2	3434	Screw	
3	37064	Presser Arm	
3-1	37064S	Complete Set	
4	7143	Eccentric Screw	
5	554	Washer	
6	340	Nut	
7	37886	Auxiliary Foot Lifter Hand Lever	
8	1175	Screw	
9	----	Presser Foot, Complete Set	
9-1	----	Presser Foot Base	
10	2308	Screw	
11	----	Presser Foot Stitch Tongue	
12	4236	Screw	
13	2371	Adjusting Screw	
14	37065	Presser Spring	
15	37048	Presser Foot Positioning Pin	
16	37148	Presser Arm Stop	
17	531	Washer	
18	5541	Screw	
19	37144	Foot Lifter Hand Lever	
20	2214	Screw	
21	37146	Foot Lift Lever	
21-1	37146S	Complete Set	
22	2285	Screw	
23	2133	Screw	
24	334	Nut	
25	37147	Foot Lifter Lever Spring	
26	37145	Foot Lifter Lever Bracket	
27	7311	Screw	
REF NO.	MODEL	PARTS NO.	DESCRIPTION
9	IDL-302	37496-306A	Presser Foot Complete Set
	IDL-303	37496-303	Presser Foot Complete Set
	IDL-304	37848	Presser Foot Complete Set
9-1	IDL-306	37496	Presser Foot Complete Set
	IDL-306A	37496-306A	Presser Foot Complete Set
	IDL-303	37496B	Presser Foot Base
11	IDL-304	37848B	Presser Foot Base
	IDL-306	37496B	Presser Foot Base
	IDL-303	37268-303	Presser Foot Stitch Tongue
		37268-303W	Presser Foot Stitch Tongue (Width)
	IDL-304	37850	Presser Foot Stitch Tongue
IDL-306	37268	Presser Foot Stitch Tongue	

8. MODEL:302/303/304/306/306A



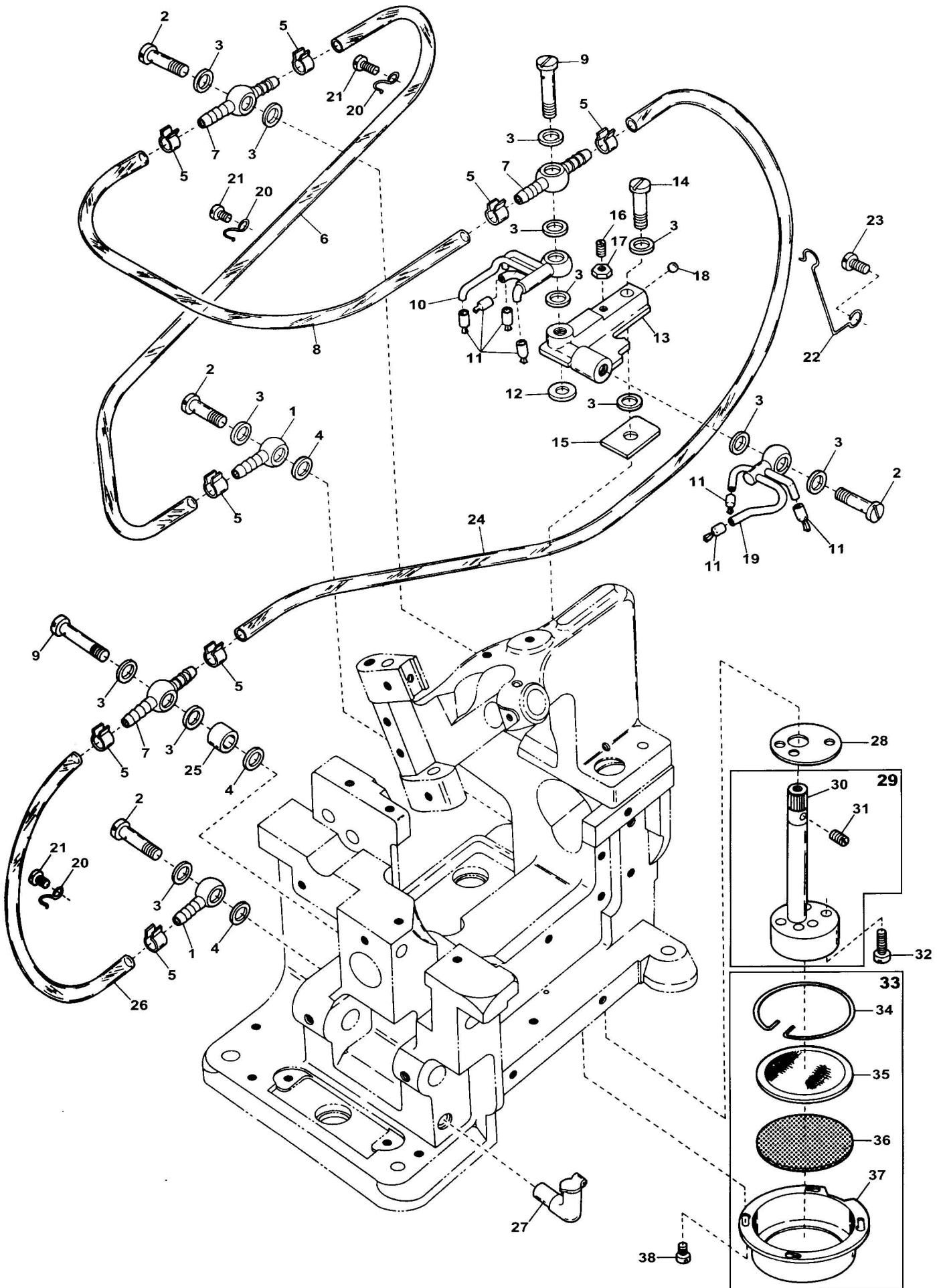
8. LOOPER DRIVING MECHINASM			
REF NO.	PARTS NO.	DESCRIPTION	
1	37831	Looper Driving Crank	
2	2022	Screw	
3	2368	Screw	
4	292	Oil Wick	
5	37843	Looper Connecting Rod	
5-1	37843S	Complete set	
6	7311	Screw	
7	294	Oil Wick	
8	37130	Connecting Rod Guide Fork	
9	1170	Screw	
10	37058	Holding Arm Ball Stud	
11	3635	Screw	
12	37304	Upper Looper Holding Arm	
12-1	37304S	Complete Set	
13	37647	Upper Looper Shaft	
14	9604	Screw	
15	----	Oil Wick	
16	----	Upper Looper (Spreader)	
17	1196	Screw	
18	37307	Upper Looper Thread Pull-off	
19	4236	Screw	
20	37315	Lower Looper Connecting Link	
20-1	37315S	Complete set	
21	1335	Screw	
22	290	Oil Wick	
23	18	Nut	
24	37648	Lower Looper Holder Arm	
25	37649	Lower Looper Shaft	
26	----	Oil Wick	
27	----	Lower Looper	
28	7302	Screw	
REF NO.	MODEL	PARTS NO.	DESCRIPTION
16	IDL-302	37271	Upper Looper
	IDL-303	37832-303	Upper Looper
	IDL-304	37271-304	Upper Looper
	IDL-306	37271	Upper Looper
27	IDL-306A	37271	Upper Looper
	IDL-302	37288	Lower Looper
	IDL-303	37272-303	Lower Looper
	IDL-304	37076-304	Lower Looper
	IDL-306	37272	Lower Looper
	IDL-306A	37272	Lower Looper
*16		37271B	Upper Looper (Strong Base)

9. MODEL:302/303/304/306/306A



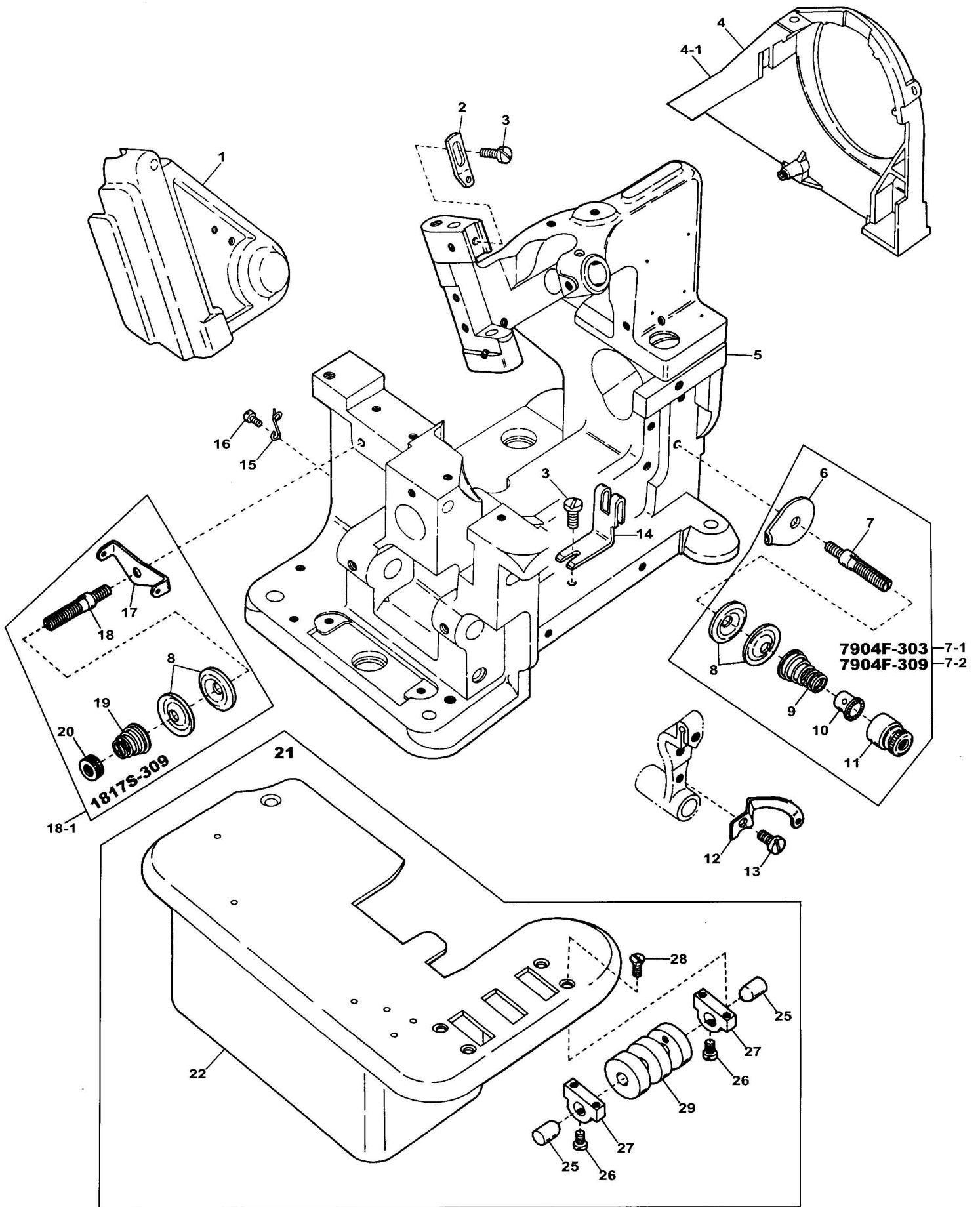
9. FEED DRIVING MECHANISM			
REF NO.	PARTS NO.	DESCRIPTION	
1	37651	Feed Dog Driving Connecting Rod	
1-1	37651S	Complete set	
	7650	Screw	
	37650	Feed Driving Eccentric	
2	2043	Screw	
3	281	Oil Wick	
4	5028	Screw	
5	555	Washer	
6	38064	Connecting Rod Pin	
7	551	Washer	
8	5540	Screw	
9	37652	Feed Regulator	
10	1156	Screw	
11	37653	Feed Bar Shaft	
12	9604	Screw	
13	37256	Differential Feed Rocker	
14	287	Oil Wick	
15	37443	Collar	
16	7616	Screw	
17	37442	Feed Holder Pin	
18	37279	Feed Dog Holder	
19	9604	Screw	
20	37410	Feed Dog Driving Lever	
20-1	37410S	PIN SCREW	
20-2	37410N	NUT	
21	----	Plain Feed Dog	
22	1175	Screw	
REF NO.	MODEL	PARTS NO.	DESCRIPTION
21	IDL-302	37273-302	Plain Feed Dog
	IDL-303	37273-303	Plain Feed Dog
	IDL-304	37439	Plain Feed Dog
	IDL-306	37273	Plain Feed Dog
	IDL-306A	37273-306A	Plain Feed Dog

10. MODEL:302/303/304/306/306A



10. LUBRICATING MECHANISM		
REF NO.	PARTS NO.	DESCRIPTION
1	37669	Oil Tube Fitting One Way End
2	7668	Oil Tube Fitting Stud
3	567	Seal
4	566	Seal
5	37675	Oil Tube Clamp
6	37433	Oil Tube
7	37668	Oil Tube Fitting Two Way
8	93619	Oil Tube
9	7667	Oil Tube Fitting Stud
10	37670	Oil Focal Point
11	37697	Oil Cap
12	569	Seal
13	37666	Oil Tube Joint Holder
14	7666	Oil Tube Fitting Stud
15	37667	Oil Tube Joint Holder Gasket
16	9209	Screw
17	340	Nut
18	637	Seal Plug
19	37479	Oil Focal Point
20	37677	Oil Tube Holder (Small)
21	1196	Screw
22	37676	Oil Tube Holder (Large)
23	4358	Screw
24	37432	Oil Tube
	37432S	Oil Tube Complete Set
25	37691	Oil Tube Joint Ring
26	37431	Oil Tube
27	37685	Oil Cup
28	37659	Oil Pump Gasket
29	37684	Oil Pump, Complete Set
30	37660	Worm Gear
31	3410	Screw
32	7658	Screw
33	38172	Pump Filter Screen, C. Set
34	38176	Pump Filter Screen Clamp
35	38175	Pump Filter Screen (Fine Mesh)
36	38174	Pump Filter Screen (Coarse Mesh)
37	38173	Pump Filter Case
38	1208	Screw

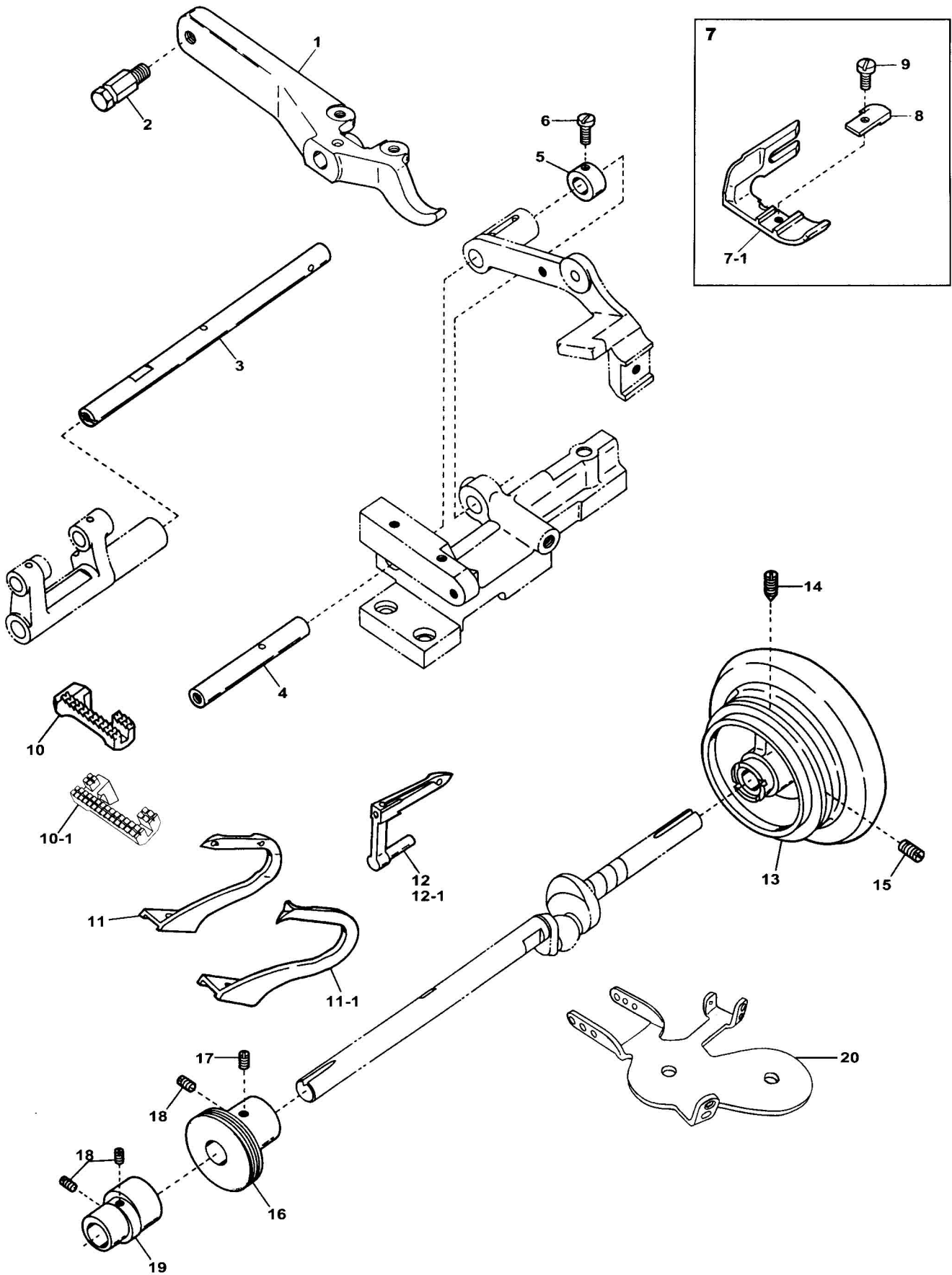
11. MODEL:308/309/309B



11. EXCLUSIVE PARTS (1)

REF NO.	PARTS NO.	DESCRIPTION	
1	37804	Needle Bar Cover	
2	37101	Needle Thread Eyelet	
3	4358	Screw	
4	2000002-306	Belt Cover	
4-1	2000002-309	Belt Cover	
5	37801	Machine Frame Unit	
6	37813	Tension Disc Eyelet	
7	7817	Tension Post	
7-1	7904F-303	Complete set	
7-2	7904F-309	Complete set	
8	31111	Tension Disc	
9	----	Upper Looper Thread Tension Spring	
10	37170	Tension Spring Bushing	
11	56	Adjusting Nut	
12	37833	Upper Looper Thread Pull-Off	
13	1196	Screw	
14	37814	Thread Take-Up Eyelet	
15	90185	Thread Eyelet	
16	1202	Screw	
17	38074	Tension Disc Eyelet	
18	1817	Tension Post	
18-1	1817S-309	Complete set	
19	37113	Lower Looper Thread Tension Spring	
20	56	Adjusting Nut	
21	37834S	Cloth Plate, Complete Set	
22	37834	Cloth Plate	
23	----	-----	
24	----	-----	
25	37453	Roller Holder	
26	3433	Screw	
27	37809	Roller Holder Bracket	
28	5345	Screw	
29	37452	Roller	
REF NO.	MODEL	PARTS NO.	DESCRIPTION
9	IDL-303	37632	Upper Looper Thread Tension Spring
	IDL-308	37113	Upper Looper Thread Tension Spring
	IDL-309	37115	Upper Looper Thread Tension Spring

12.MODEL:308/309/309B

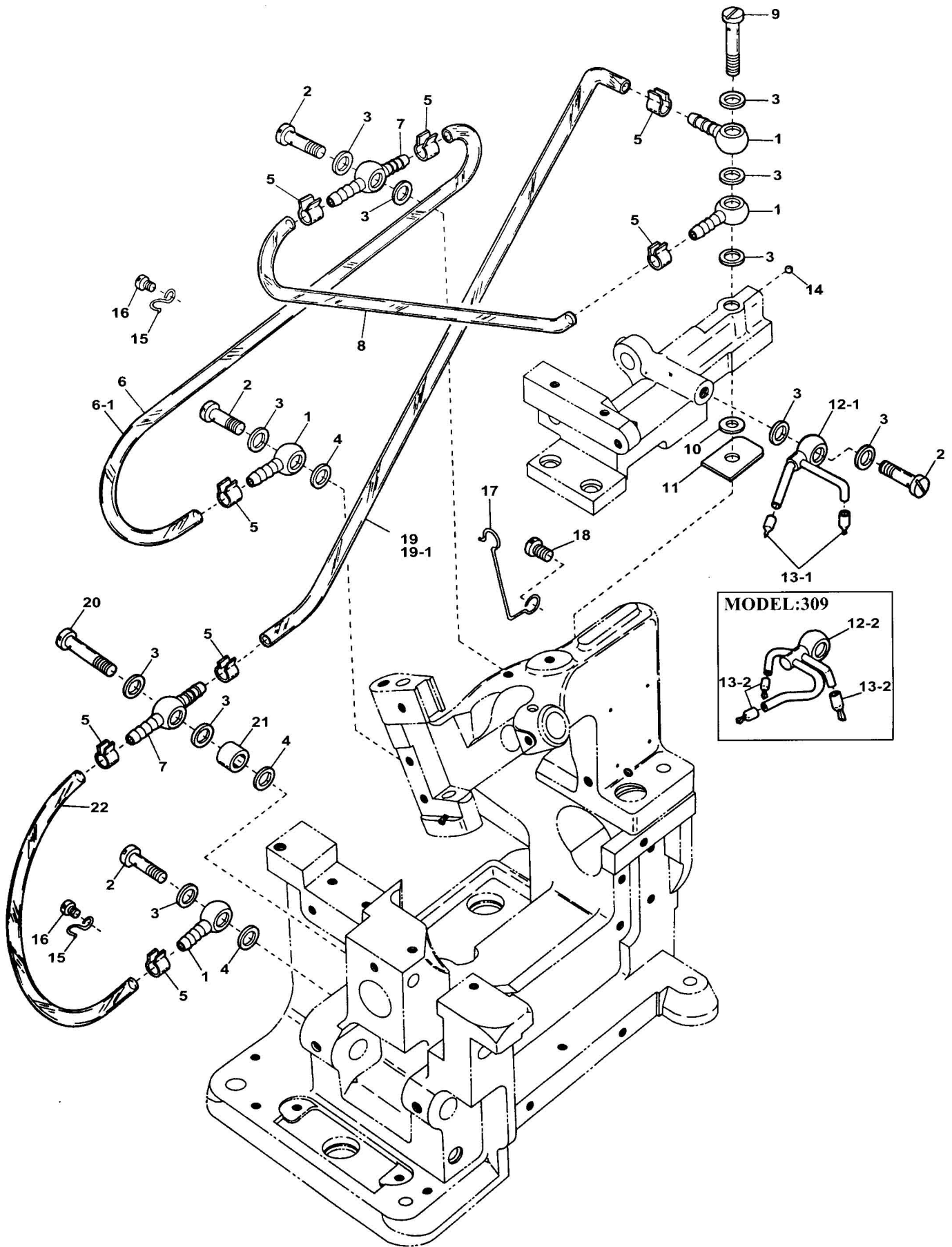


12. EXCLUSIVE PARTS (2)

REF NO.	PARTS NO.	DESCRIPTION
1	37755	Foot Lifter Lever
2	37757	Chain Latch Bolt
3	37835	Feed Bar Shaft
4	37826	Presser Arm Hinge Pin
5	37827	Collar
6	1208	Screw
7	37848	Presser Foot, Complete Set
7-1	37848B	Presser Foot Base
8	37850	Presser Foot Stitch Tongue
9	1228	Screw
10	37439	Plain Feed Dog
10-1	37439-309B	Plain Feed Dog
11	37832	Upper Looper
11-1	37271-309B	Upper Looper
12	37076	Lower Looper
12-1	37076-309B	Lower Looper
13	37816	Pulley
14	2347	Screw
15	1419	Screw
16	37438	Feed Driving Eccentric
17	7650	Screw
18	1457	Screw
19	37437	Feed Lift & Upper Knife Eccentric
20	37812-L309B	Tension Disc Eyelet

*11 37832B Upper Looper (Strong Base)

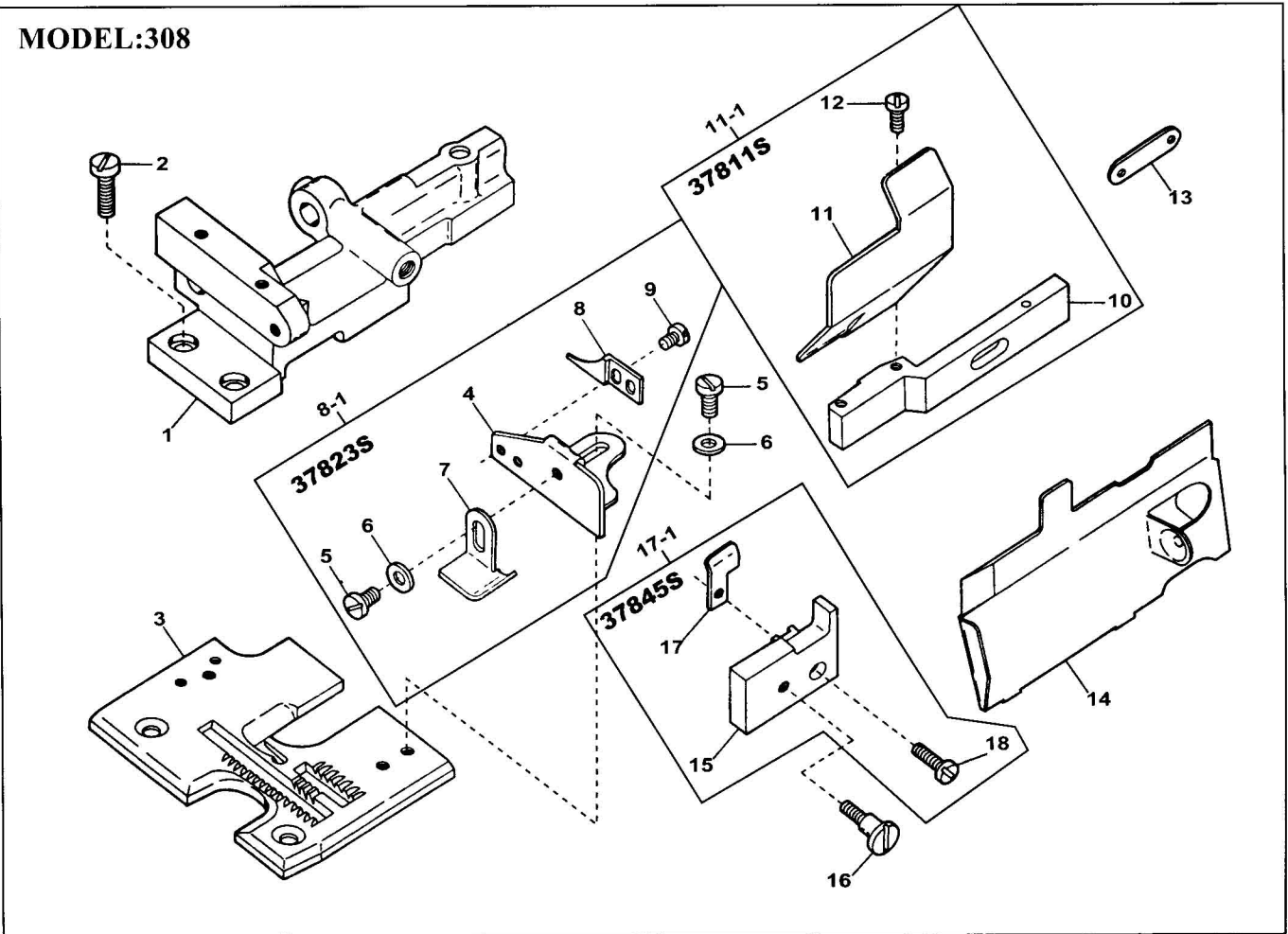
13.MODEL:308/309/309B



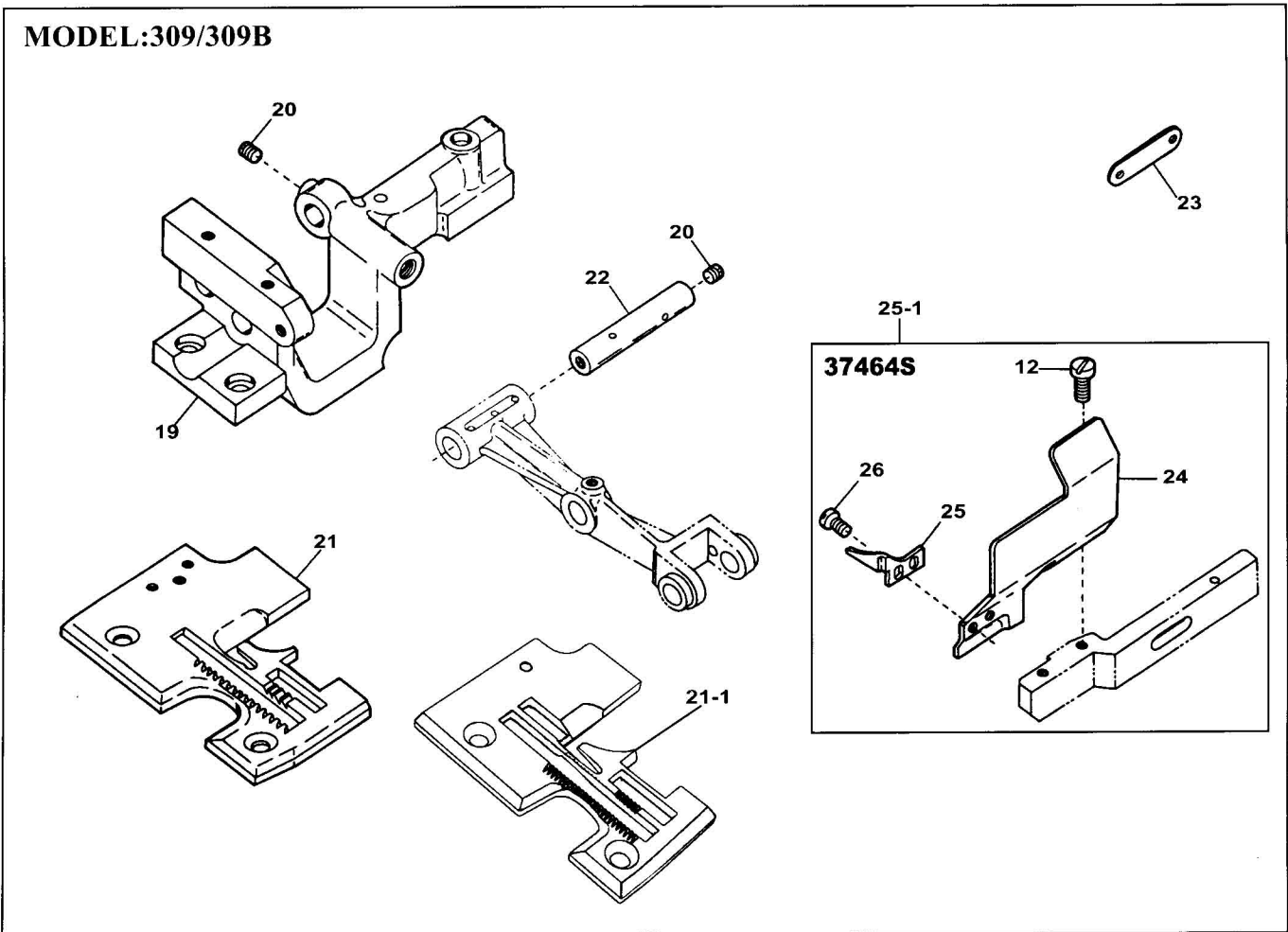
13. EXCLUSIVE PARTS (3)

REF NO.	PARTS NO.	DESCRIPTION
1	37669	Oil Tube Fitting One Way End
2	7668	Oil Tube Fitting Stud
3	567	Seal
4	566	Seal
5	37675	Oil Tube Clamp
6	37433	Oil Tube
6-1	37433S	Oil Tube Complete Set
7	37668	Oil Tube Fitting Two Way
8	37435	Oil Tube
9	6762	Oil Tube Fitting Stud
10	569	Seal
11	37667	Oil Tube Joint Holder Gasket
12-1	37715	Oil Focal Foint Model : 308
12-2	37479	Oil Focal Foint Model : 309
13-1	37697	Oil Cap Model : 308
13-2	37697	Oil Cap Model : 309
14	3433	Screw
15	37677	Oil Tube Holder (Small)
16	1196	Screw
17	37880	Oil Tube Holder (Large)
18	4358	Screw
19	37481	Oil Tube
19-1	37481S	Oil Tube Complete Set
20	7667	Oil Tube Fitting Stud
21	37691	Oil Tube Joint Ring
22	37431	Oil Tube

MODEL:308



MODEL:309/309B



14. EXCLUSIVE PARTS (4)

REF NO.	PARTS NO.	DESCRIPTION
1	37825	Foot Lifter Device Bracket
2	1156	Screw
3	37800	Stitch Plate
4	37821	Edge Guide
5	1202	Screw
6	532	Washer
7	37822	Fabric Guide
8	37823	Auxiliary Stitch Tongue
8-1	37823S	Complete Set
9	1228	Screw
10	37466	Chip Guard Holder
11	37811	Chip Guard
11-1	37811S	Complete set
12	1175	Screw
13	37839	Model Plate
14	37604	Front Cover
15	37824	Needle Guard Bracket
16	2086	Screw
17	37845	Needle Guard
17-1	37845S	Complete set
18	1174	Screw
19	37465	Foot Lifter Device Bracket
20	1457	Screw
21	37459	Stitch Plate
21-1	37459-309B	Stitch Plate
22	37468	Upper Knife Driving Arm Stud Pin
23	37480	Model Plate
24	37461	Chip Guard
25	37464	Auxiliary Stitch Tongue
25-1	37464S	Complete set
26	4237	Screw

INDEX											
PARTS NO	PAGE NO	REF NO	PARTS NO	PAGE NO	REF NO	PARTS NO	PAGE NO	REF NO	PARTS NO	PAGE NO	REF NO
12	3	10	1170	8	9	3433	11	26	9209	10	16
18	8	23	2043	9	2	3434	4	19	9604	2	5
56	3	24	1174	14	18	3434	7	2	9604	9	19
56	11	20	1175	1	8	3591	4	2	9932	5	11
62	5	20	1175	2	32	3593	4	3	30413	6	11
144	1	37	1175	7	8	3653	4	17	30414	6	9
278	5	15	1175	9	22	3653	5	8	31111	3	5
281	9	3	1175	14	12	3653	8	11	31111	11	8
287	9	14	1176	6	5	3639	4	11	37016	3	21
290	4	20	1196	1	12	4169	1	14	37048	7	15
290	6	4	1196	3	14	4236	7	12	37049	4	22
290	8	22	1196	8	17	4236	8	19	37057	5	1
292	8	4	1196	10	21	4237	2	34	37058	8	10
294	4	12	1196	11	13	4237	14	26	37059	5	10
294	8	7	1196	13	16	4313	5	16	37060	3	13
304	5	3	1202	11	16	4358	3	12	37062	5	19
334	7	24	1202	14	5	4358	10	32	37064	7	3
340	7	6	1208	2	9	4358	11	3	37065	7	14
340	10	17	1208	10	38	4358	13	18	37076	12	12
500	2	11	1208	12	6	4435	5	18	37101	11	2
531	2	26	1218	2	29	5028	9	4	37107	3	15
531	3	9	1222	3	17	5362	2	19	37108	3	18
531	7	17	1222	6	13	5083	2	16	37109	3	19
532	14	6	1223	1	16	5345	1	34	37110	3	16
541	1	10	1227	1	26	4345	11	28	37112	3	25
551	9	7	1228	12	9	5540	9	8	37113	11	19
554	2	30	1228	14	9	5541	7	18	37115	3	23
554	7	5	1335	8	21	6762	13	9	37127	5	9
555	9	5	1419	12	15	7143	7	4	37130	5	4
562	2	3	1457	3	26	7302	8	28	37130	8	8
566	10	4	1457	4	9	7311	5	2	37132	5	6
566	13	4	1457	12	18	7311	6	8	37133	4	18
567	2	18	1457	14	20	7311	7	27	37134	4	21
567	10	3	1613	2	21	7311	8	6	37144	7	19
567	13	3	1732	5	23	7405	6	23	37145	7	26
568	2	17	1817	3	22	7609	1	5	37146	7	21
569	10	12	1817	11	18	7616	1	22	37147	7	25
569	13	10	2022	4	14	7616	2	27	37148	7	16
634	8	14	2022	8	2	7616	9	16	37150	5	12
637	9	12	2043	9	2	7619	2	22	37170	3	2
637	10	18	2086	6	19	7650	4	7	37170	11	10
638	13	14	2086	14	16	7650	12	17	37256	9	13
715	1	30	2133	7	23	7658	10	32	37262	3	11
715	11	24	2214	7	20	7666	10	14	37268	7	11
726	1	19	2285	7	22	7667	10	9	37271	8	16
901	1	17	2308	7	10	7667	13	20	37272	8	27
989	4	4	2347	12	14	7668	10	2	37273	9	21
1024	1	29	2368	8	3	7668	13	2	37279	9	18
1024	11	23	2369	6	20	7763	2	2	37286	2	33
1093	3	20	2371	7	13	7817	11	7	37304	8	12
1132	6	10	2419	1	36	7904	3	6	37307	8	18
1156	9	10	3410	10	31						
1156	14	2	3433	1	32						
1170	5	5									

INDEX											
PARTS NO	PAGE NO	REF NO	PARTS NO	PAGE NO	REF NO	PARTS NO	PAGE NO	REF NO	PARTS NO	PAGE NO	REF NO
37315	8	20	37607	1	41	37697	13	13-2	1817 S303	3	22-1
37409	4	15	37609	1	3	37703	4	1	1817 S306	3	22-2
37410	9	20	37610	1	4	37709	2	1	1817 S309	11	18-1
37431	10	26	37612	1	2	37715	13	12-1	7904 F303	11	7-1
37431	13	22	37613	1	11	37755	12	1	7904 F309	11	7-2
37432	10	24	37616	1	21	37757	12	2	7904 U306	3	6-1
37433	10	6	37617	1	24	37799	4	5	7904 U309	3	6-2
37433	13	6	37618	1	25	37800	14	3	37064S	7	3-1
37435	13	8	37620	2	23	37801	11	5	37076-309B	12	12-1
37437	12	19	37622	1	9	37804	11	1	37107S	3	15-1
37438	12	16	37624	2	4	37805	2	20	37146S	7	21-1
37439	12	10	37626	2	7	37806	1	33	37150S	5	12-1
37442	9	17	37627	2	8	37809	11	27	37271-309B	12	11-1
37443	9	15	37632	3	3	37811	14	11	37304S	8	12-1
37452	1	35	37632	11	9	37812	3	7	37315S	8	20-1
37452	11	29	37634	3	1	37812	11	6	37410S	9	20-1
37453	1	31	37635	3	4	37813	11	14	37410N	9	20-2
37453	11	25	56	11	11	37818	5	17	37439-309B	12	10-1
37458	6	24	37637	14	10	37821	14	4	37459-309B	14	21-1
37459	14	21	37645	4	13	37822	14	7	37460S	1	40-1
37460	1	40	37647	8	13	37823	14	8	37464S	14	25-1
37461	14	24	37648	8	24	37824	14	15	37467S	6	6-1
37462	4	8	37649	8	25	37825	14	1	37473S	6	18-1
37464	14	25	37650	4	6	37826	12	4	37481S	1	13
37465	14	19	37651	9	1	37827	12	5	37481N	1	14
37466	2	28	37652	9	9	37831	8	1	37489S	1	23-1
37467	6	6	37653	9	11	37832	12	11	37544	1	15
37468	14	22	37654	4	16	37883	6	1	37651S	9	1-1
37469	6	17	37659	10	28	37833	11	12	37811S	14	11-1
37470	6	15	37660	10	30	37834	11	22	37812-L309B	12	20
37471	6	16	37666	10	13	37835	12	3	37816	12	13
37472	6	21	37667	10	15	37839	14	13	37823S	14	8-1
37473	6	18	37667	13	11	37841	1	1	37834S	11	21
37474	6	22	37668	10	7	37842	2	24	37841	1	1
37475	6	14	37668	13	7	37843	8	5	37841	1	1-1
37478	6	12	37669	2	6	37845	14	17	37843S	8	5-1
37479	10	19	37669	10	1	37848	12	7	37845S	14	17-1
37479	13	12-2	37669	13	1	37850	12	8	90185	11	15
37480	14	23	37670	10	10	37876	6	3	90320	5	14
37481	13	19	37675	10	5	37880	13	17	90321	5	13
37482	1	20	37675	13	5	37886	7	7	93619	10	8
37483	5	22	37676	10	22	37950	15	4	200000-306	11	4
37484	1	18	37377	10	20	37981	15	1	200000-309	11	4-1
37487	2	31	37677	13	15	37982	15	2			
37489	1	23	37678	2	10	38064	9	6			
37495	1	28	37379	2	14	38074	11	17			
37496	7	9	37680	2	13	38172	10	33			
37540	2	15	37681	2	12	38173	10	37			
37547	4	10	37684	10	29	38174	10	36			
37552	6	7	37685	10	27	38175	10	35			
37552	7	1	37691	10	25	38176	10	34			
37569	1	6	37691	13	21	38229	1	7			
37604	14	14	37692	2	25	38364	3	8			
37605	1	38	37697	10	11						
37606	1	39	37697	13	13-1						