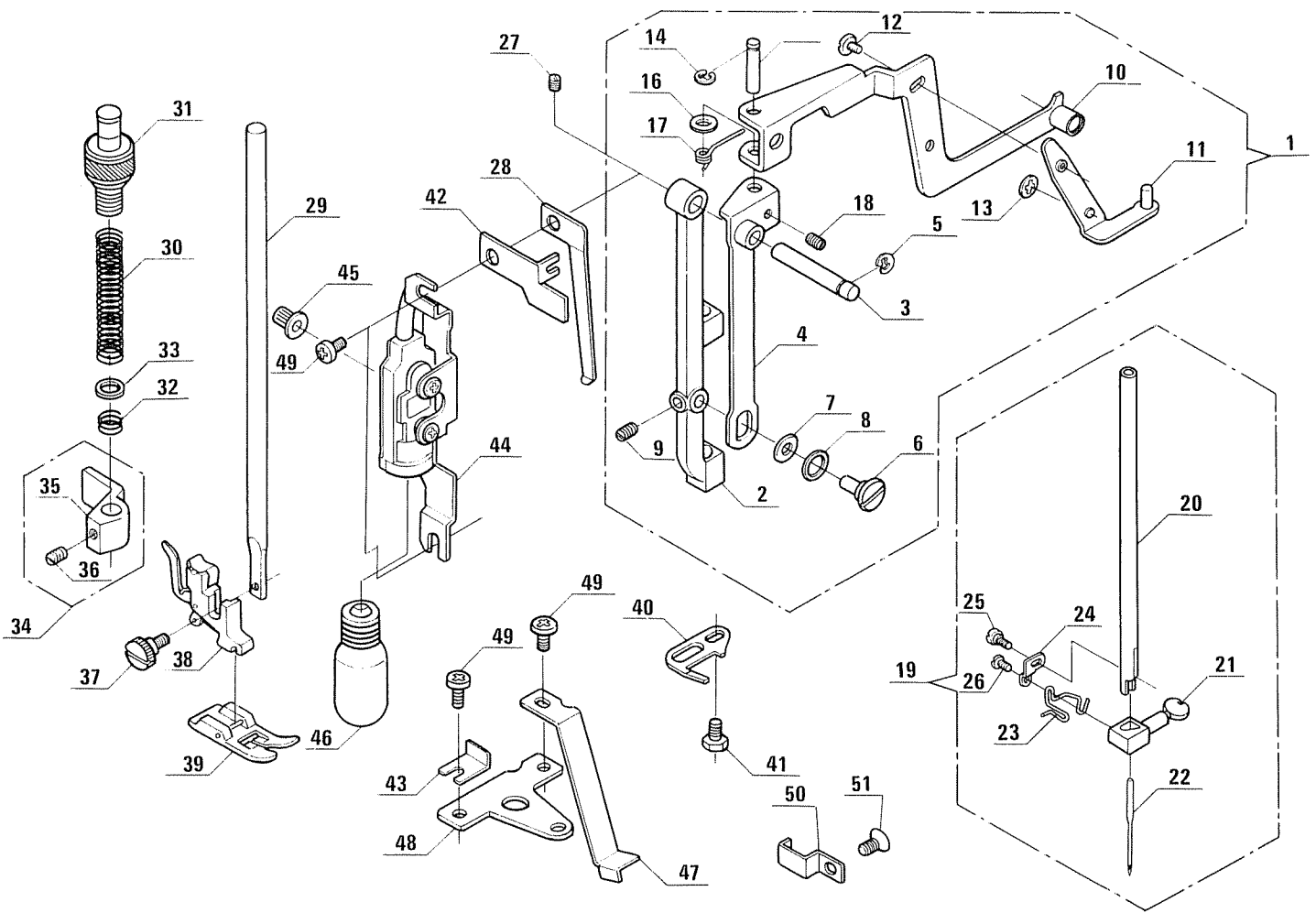


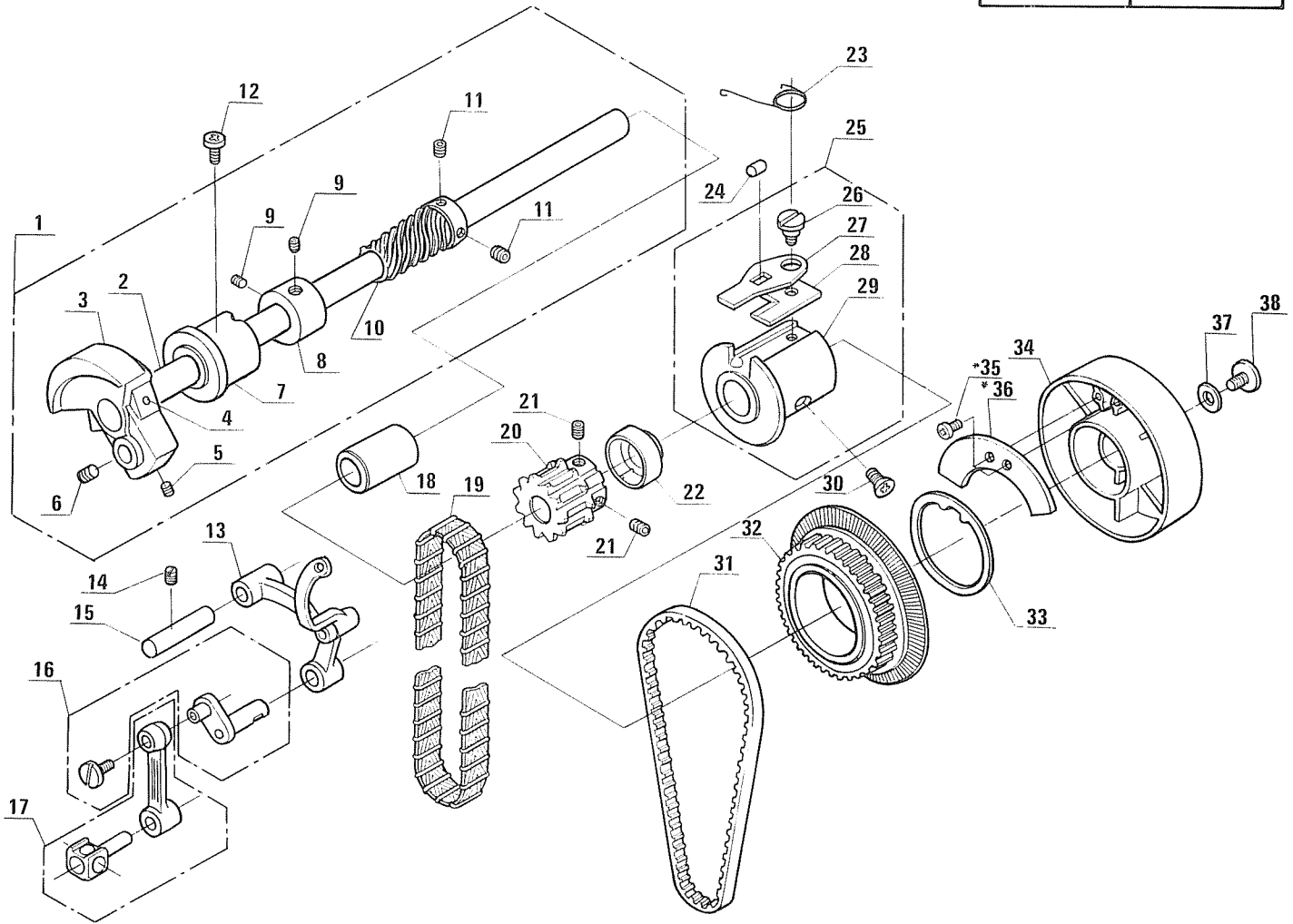
PARTS LIST

Models 618 & 681



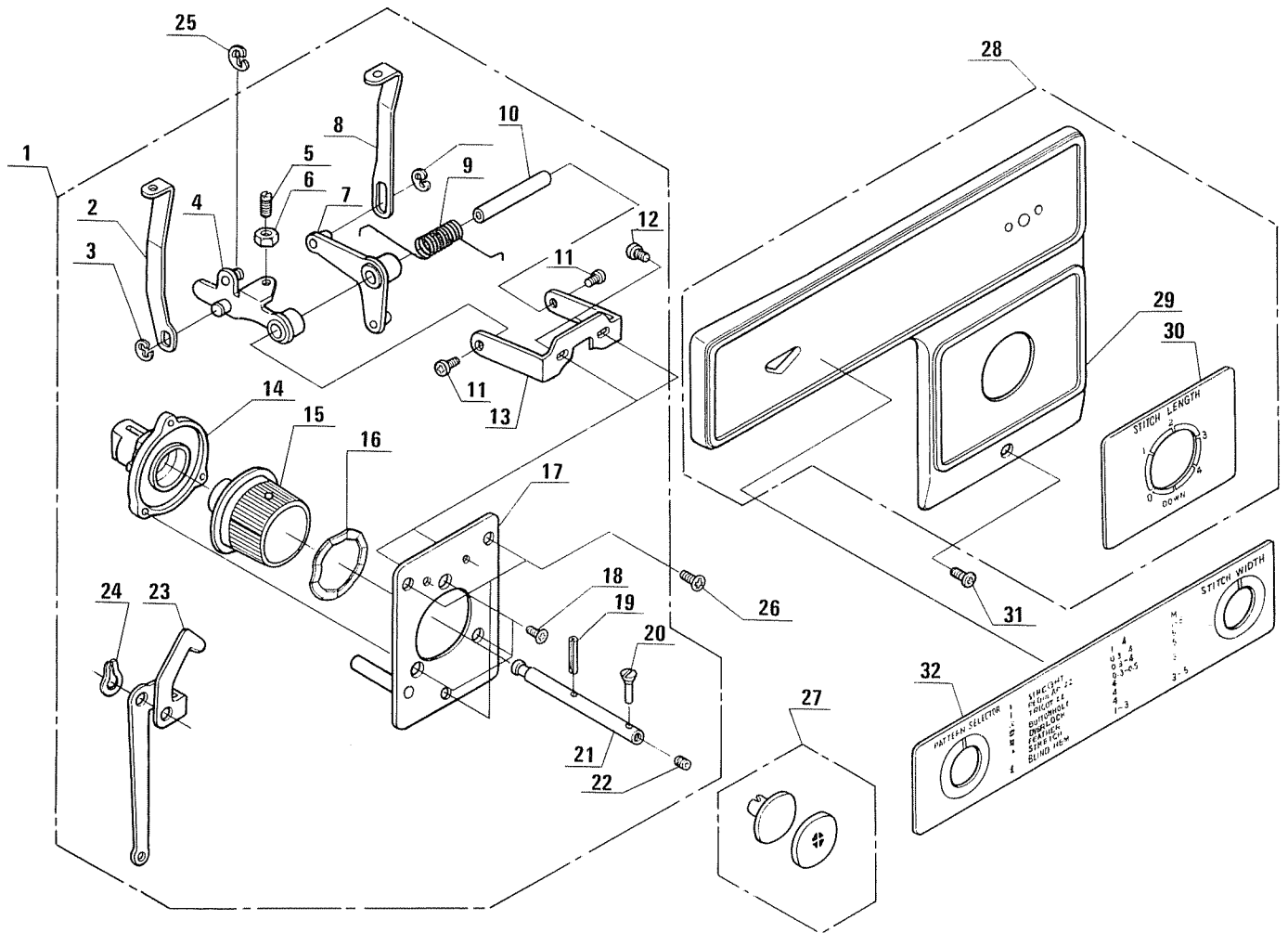
Ref. No.	Parts No.	Names of Parts	Ref. No.	Parts No.	Names of Parts
1	693604109	Needle bar supporter (unit)	27	000082202	Cup point set screw 5 x 5
2	670070006	Needle bar supporter	28	693089009	Needle bar supporter spring
3	693008004	Needle bar supporter pin	29	350804005	Presser bar
4	693009005	Needle bar supporter plate	30	532165008	Presser bar spring
5	000001506	Snap ring E-4 (D)	31	102517107	Pressure regulator (unit)
6	678084007	Eccentric pin	32	102222009	Pressure regulator spring
7	670258000	Plain washer	33	102061008	Plain washer
8	678044005	Plain washer	34	810518001	Presser bar guide bracket (unit)
9	553137006	Set screw	35	810442003	Presser bar guide bracket
10	693612100	Zigzag width rod (unit)	36	102063006	Set screw
11	693012001	Zigzag width regulating crank	37	102012004	Thumb screw
12	102021109	Set screw	38	611510000	Foot holder (unit)
13	000013903	Snap ring CS-5	39	611511001	Presser foot (unit)
14	000002105	Snap ring E-3	40	680036001	Needle bar supporter stopper
15	693044002	Zigzag width rod shaft	41	000066303	Hexagon head bolt 4 x 6
16	693045003	Plain washer	42	693007003	Face plate set plate
17	693013002	Zigzag width rod spring	43	693049007	Zigzag width rod stopper
18	672138009	Set screw	44		Lamp socket (unit)
19	801504006	Needle bar (unit)	*45	801803008	Switch knob
20	673027007	Needle bar	46		Lamp bulb
21	801506008	Needle clamp (unit)	47	693047005	Cord fixing metal
22	102408089	Needle HA-1x14	48	693005001	Top cover set plate
23	801020003	Needle bar thread guide	49	000103406	+ binding head small screw 4 x 8
24	670262007	Needle bar thread guide set plate	50	674819007	Lamp cord fixing metal
25	673030003	Hinge screw	51	102053007	Flat head set screw
26	670047004	Flat head set screw			

* This parts can be used only for rotary lamp switch.

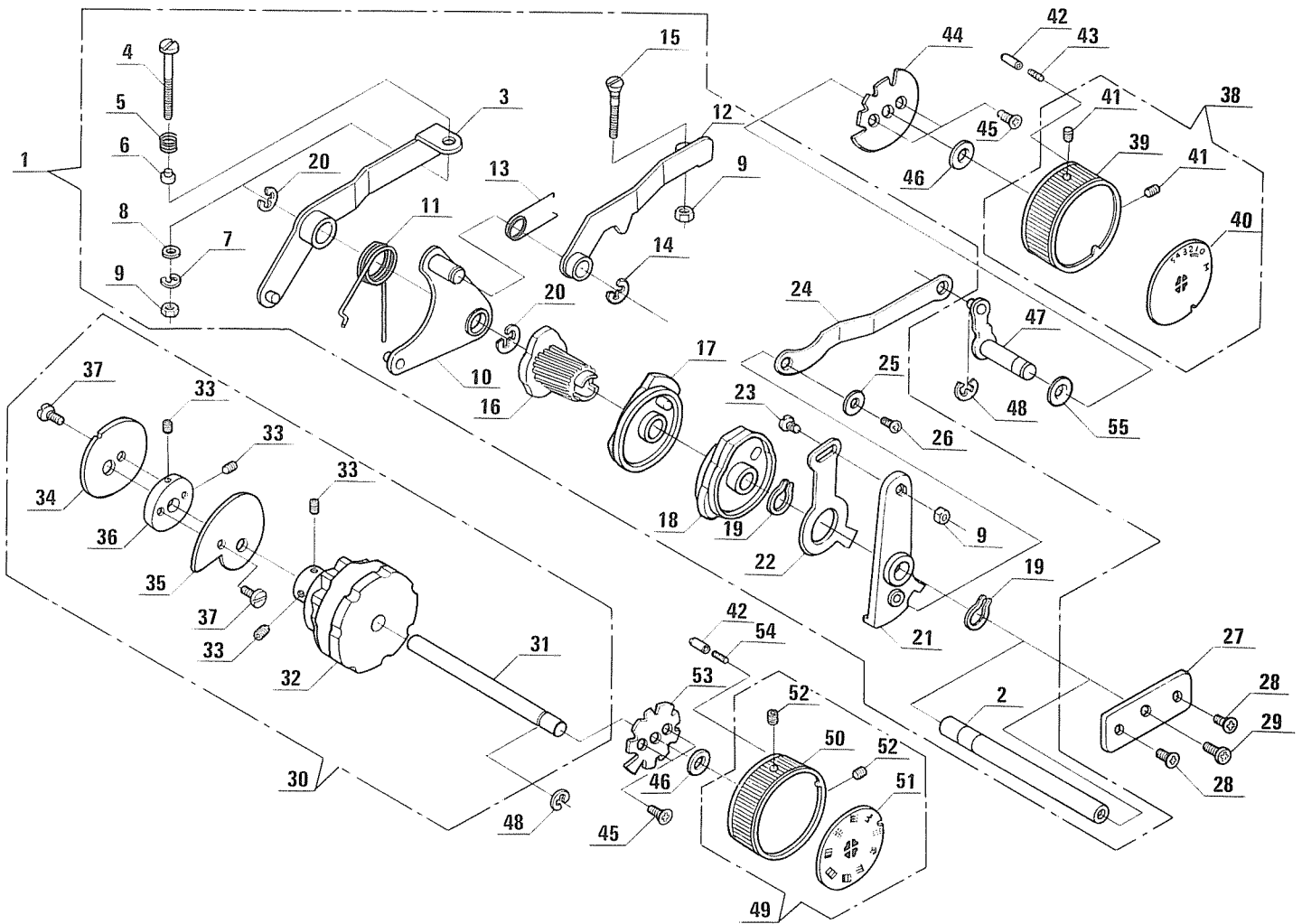


Ref. No.	Parts No.	Names of Parts	Ref. No.	Parts No.	Names of Parts
1	618613005	Upper shaft (unit)	21	673208004	Hexagon socket screw
2	618066007	Upper shaft	22	618067008	Timing gear collar
3	673068000	Thread take-up crank	23	804010009	Declutch lever spring
4	000004406	Spring pin 3 x 24	24	553015007	Declutch lever roller
5	102063000	Set screw	25	618614006	Balance wheel bushing (unit)
6	102073003	Set screw	26	366031003	Hinge screw
7	673061003	Upper shaft front bushing	27	801013003	Declutch lever
8	673063005	Ring	28	366030002	Declutch lever washer
9	673208004	Hexagon socket screw	29	618068009	Balance wheel bushing
10	618011007	Upper shaft worm gear	30	000069410	+ flat head small screw 4 x 10
11	694050004	Hexagon socket screw	31	673189008	Synchro belt
12	000100506	+ pan head small screw 5 x 12	32	804011000	Upper shaft synchro belt gear
13	532503002	Thread take-up lever (unit)	33	673219008	Balance wheel washer
14	000082202	Cup point set screw 5 x 5	*34	618069000	Balance wheel
15	306024007	Thread take-up lever pin	*35	000075202	+ pan head T screw 3 x 10-2V (For Model 618)
16	609502002	Needle bar crank pin (unit)	36	804012001	Balance weight (For Model 618)
17	680504005	Needle bar connecting stud (unit)	37	556047007	Bent washer
18	673062004	Upper shaft rear bushing	38	618070004	Set screw
19	801605008	Clip belt (unit)			
20	801018008	Upper shaft timing gear			

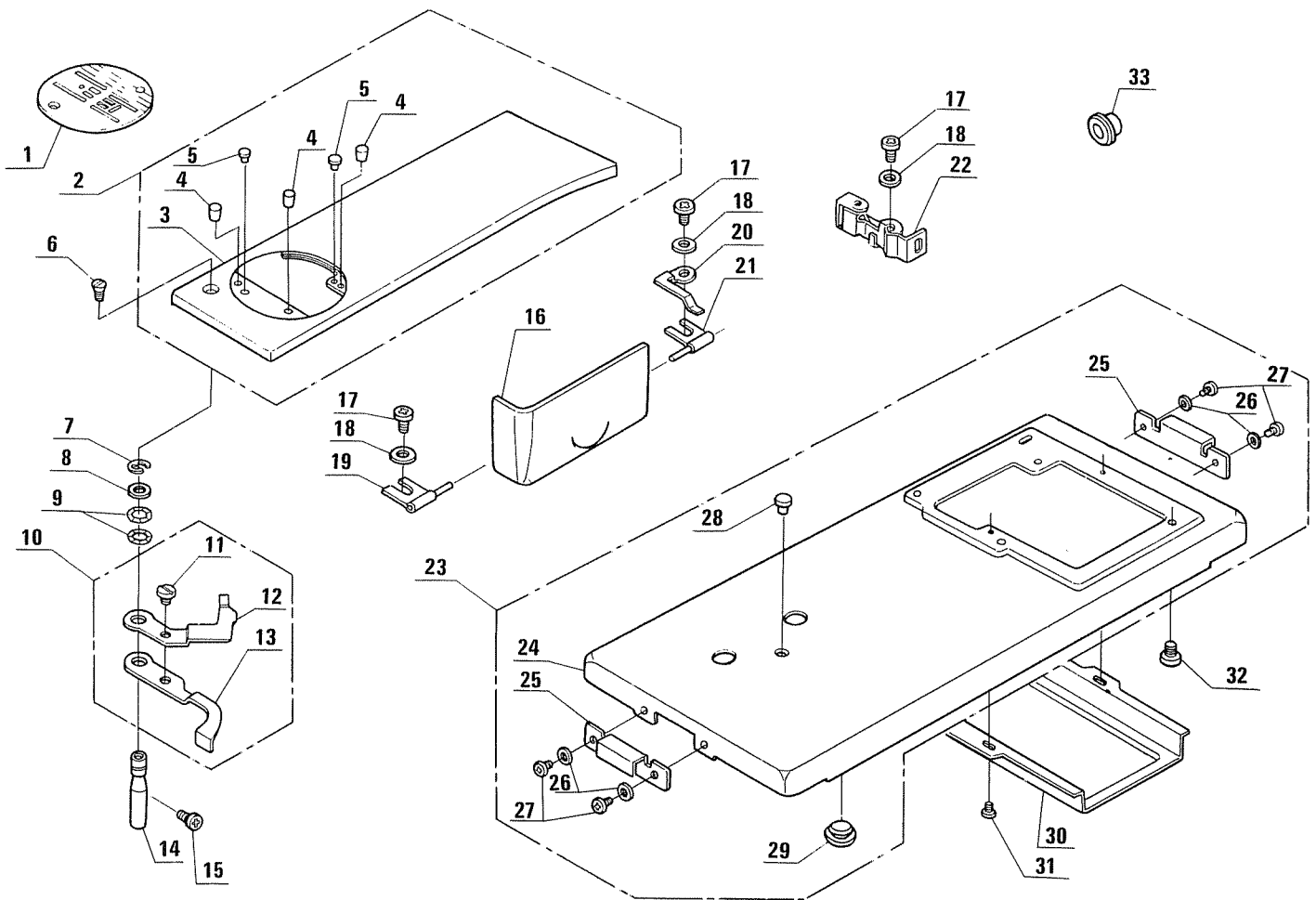
* These parts can be used only for MODEL 618.



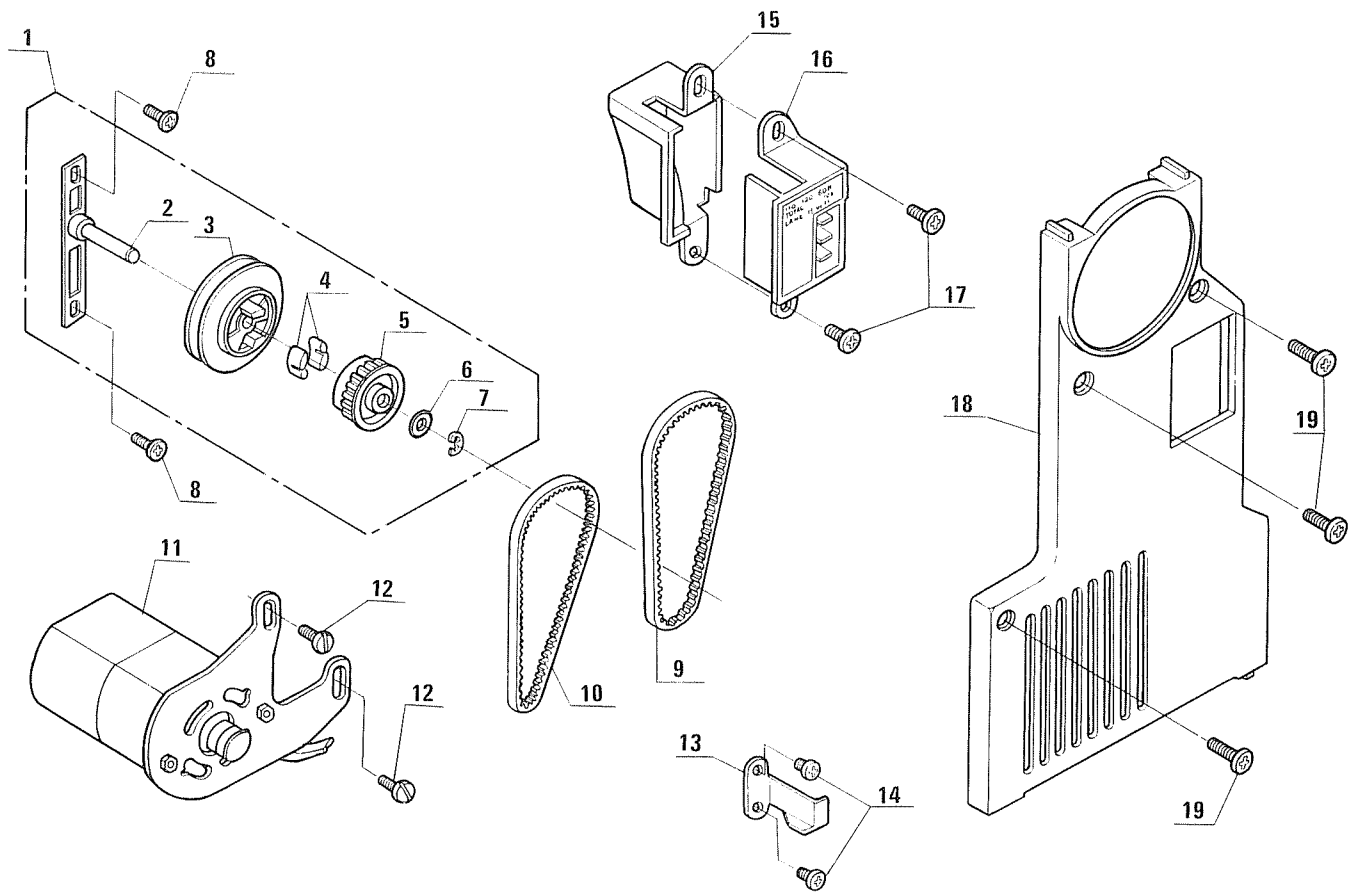
Ref. No.	Parts No.	Names of Parts	Ref. No.	Parts No.	Names of Parts
1	618604003	Stitch length regulator dial (unit)	17	618016002	Stitch length regulator dial holder plate
2	693088008	Stretch stitch feed regulating rod	18	000076801	+ flat head T screw 3 x 8-2V
3	000000309	Snap ring E-4	19	000019404	Spring pin 2.5 x 14
4	618027006	Feed regulating arm	20	618021000	Eccentric pin
5	618054002	Set screw	21	618020009	Stitch length regulator dial shaft
6	000067402	Hexagon nut 4-2-7	22	673209005	Hexagon socket screw
7	618026005	Feed regulating plate	23	618030002	Drop lever
8	801010000	Buttonhole feed regulating rod	24	000014605	Snap ring GTW-6
9	618028007	Feed regulating plate spring	25	000000309	Snap ring E-4
10	618025004	Feed regulating arm shaft	26	693091004	Flat head set screw
11	000067201	+ pan head small screw 3 x 6	27	618605004	Reverse button (unit)
12	000103602	+ binding head small screw 3.5 x 5	28	618617009	Control panel frame (unit)
13	618024003	Feed regulating arm base	29	618071005	Control panel
14	618017003	Stitch length regulator dial base	30	618072006	Stitch length indication plate
15	618018004	Stitch length regulator dial	31	630027004	Set screw
16	618019005	Corrugated washer	32	618073007	Control panel



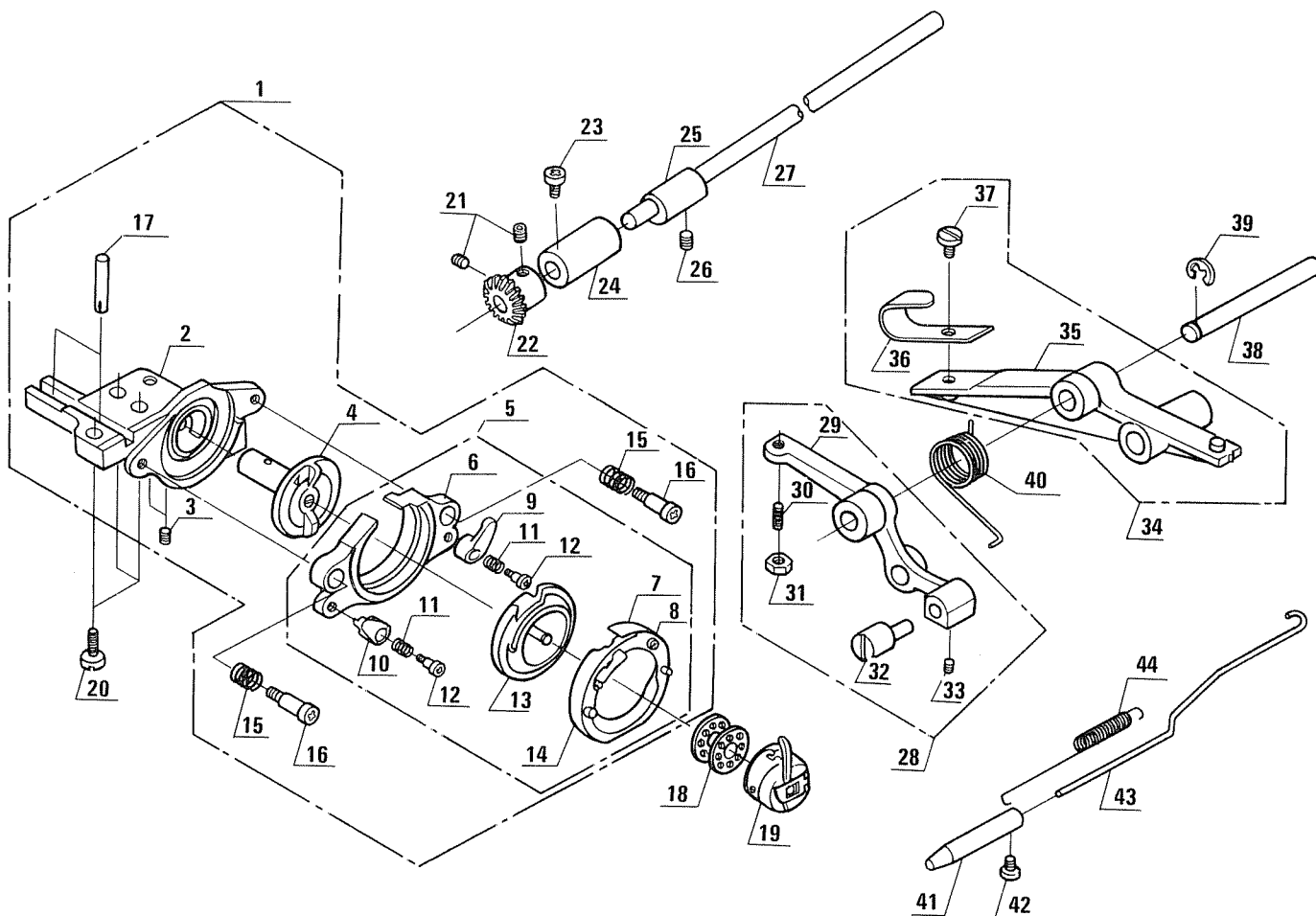
Ref. No.	Parts No.	Names of Parts	Ref. No.	Parts No.	Names of Parts
1	693635006	Cam shaft (unit)	29	601037007	Set screw
2	693060004	Cam shaft	30	611607005	Buttonhole dial shaft (unit)
3	611010005	Buttonhole feed crank	31	693037002	Buttonhole dial shaft
4	589039008	Buttonhole feed screw	32	693038003	Pattern selector cam
5	589040002	Buttonhole feed spring	33	673209005	Hexagon socket screw
6	560197006	Buttonhole feed spring holder	34	693039004	Buttonhole selector cam
7	000001207	Snap ring E-2.5	35	611006008	Stretch stitch selector cam
8	000071002	Plain washer	36	678066003	Cam follower release cam ring
9	532126007	Nut	37	102160008	Set screw
10	693085005	Stretch stitch selector crank	38	618618000	Stitch (zigzag) width regulator dial (unit)
11	693079006	Stretch stitch selector crank spring	39	607508116	Knob (unit)
12	693086006	Stretch stitch feed crank	40	618032004	Stitch (zigzag) width indicating plate
13	611008000	Stretch stitch feed crank spring	41	553245008	Hexagon socket screw
14	000001506	Snap ring E-4 (D)	42	366043008	Dial pin
15	368013005	Stretch stitch regulating screw	43	322027000	Dial pin spring
16	693084004	Stretch stitch cam	44	693021003	Stitch (zigzag) width regulator index plate
17	693074001	Stitch pattern cam (1)	45	618080007	Flat head set screw
18	693032007	Stitch pattern cam (2)	46	672158005	Plain washer
19	000014502	Snap ring G-8	47	693034102	Stitch (zigzag) width regulator shaft
20	000001702	Snap ring E-6 (D)	48	000001506	Snap ring E-4 (D)
21	693051002	Stitch (zigzag) width regulator cam	49	618619001	Stitch pattern selector knob (unit)
22	693050001	M needle position cam	50	607508116	Selector knob (unit)
23	102021109	Set screw	51	618033005	Pattern indicating plate
24	693035000	Stitch (zigzag) width regulating rod	52	553245008	Hexagon socket screw
25	678085008	Plain washer	53	693023005	Pattern selector index plate
26	000075903	+ pan head T screw 2.3 x 5-2V	54	693046004	Selector knob pin spring
27	693061005	Cam shaft supporter	55	589028004	Plain washer
28	365032001	Flat head set screw			



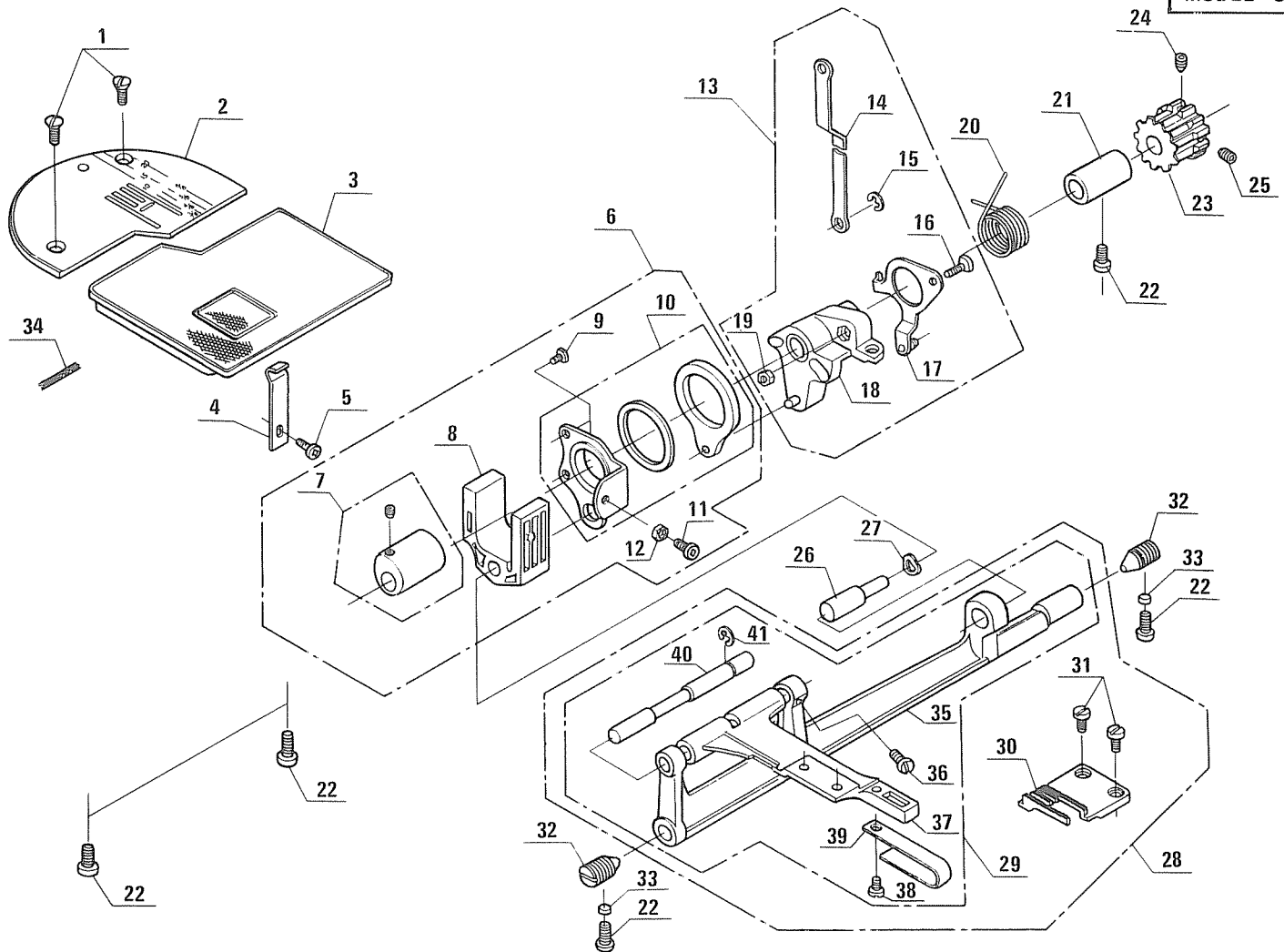
Ref. No.	Parts No.	Names of Parts	Ref. No.	Parts No.	Names of Parts
1	618510001	Needle plate (unit)	18	000070506	Polished plain washer
2	618609008	Free arm cover (unit)	19	812014008	Hook cover hinge (L)
3	618059100	Free arm cover	20	812057003	Hook cover spring
4	670236002	Needle plate cushion	21	812015009	Hook cover hinge (R)
5	605063004	Needle plate positioning pin	22	812510009	Hook cover opener (unit)
6	605071005	Flat head set screw	23	618620005	Base (unit)
7	000001702	Snap ring E-6 (D)	24	618077001	Base
8	572062008	Plain washer	25	618078002	Base lock
9	556168005	Corrugated washer	26	220405579	Plain washer
10	618610002	Needle plate releasing lever (unit)	27	000066727	+ binding head small screw 3 x 8
11	366066007	Set screw	28	701179005	Base rubber cap
12	618061002	Needle plate releasing lever spring	29	618039001	Rubber cushion
13	605010006	Needle plate releasing lever	30	618040005	Base lid
14	605011007	Lever pin	31	000078205	+ binding head small screw 3 x 4
15	000077628	+ pan head small screw 4 x 10	32	000100609	+ pan head small screw 5 x 10
16	812013100	Hook cover	33	605049004	Extension table bushing
17	000103901	+ binding head small screw 4 x 6			



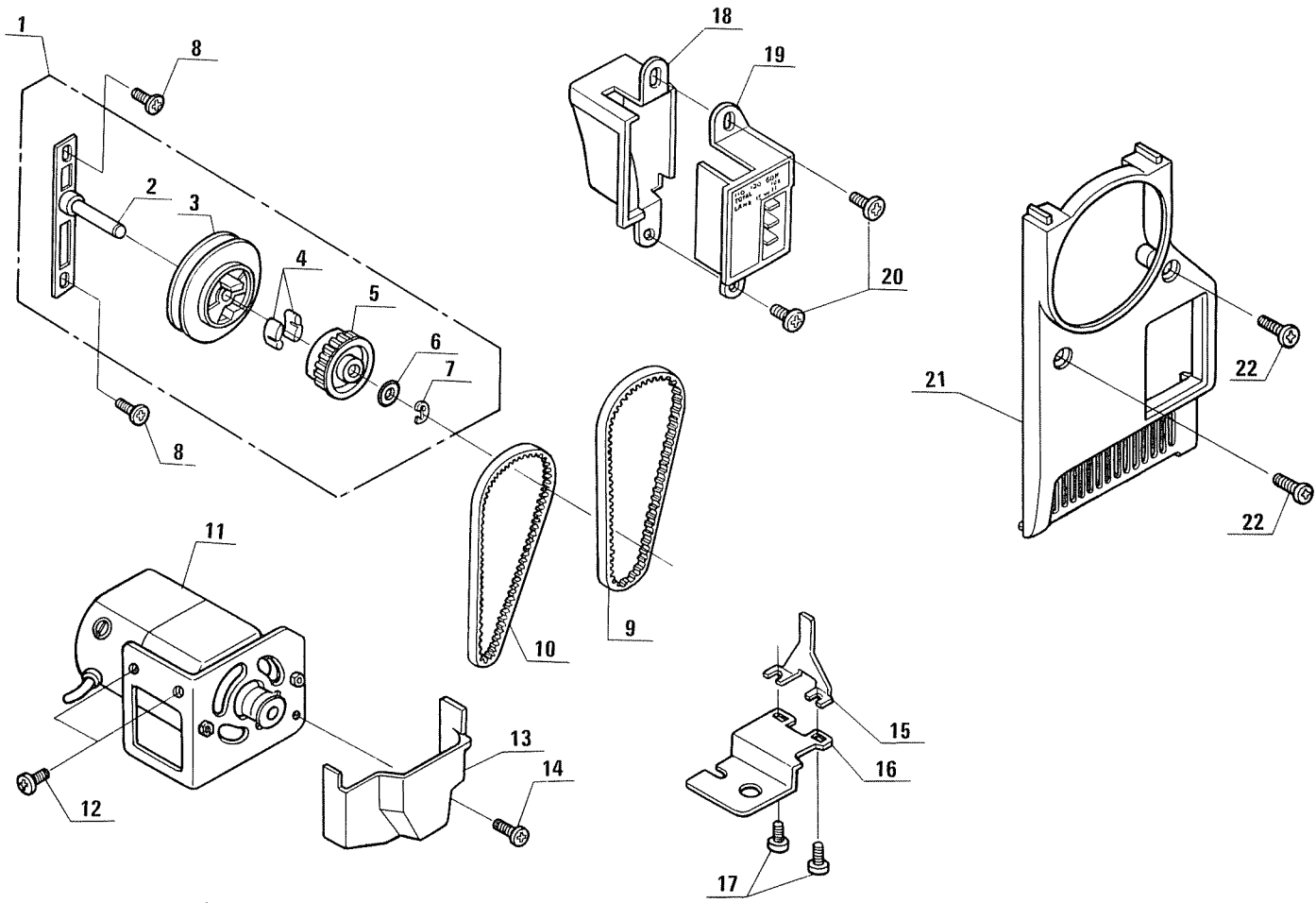
Ref. No.	Parts No.	Names of Parts	Ref. No.	Parts No.	Names of Parts
1	810653010	Pulley (unit)	11		Motor (unit)
2	810391017	Pulley supporter plate	12	000100609	+ pan head small screw 5 x 10
3	810392007	V-belt pulley	13	812038008	Cord guide plate
4	802061005	Pulley cushion	14	000077503	+ pan head small screw 4 x 6
5	810393008	Synchronized belt pulley	15		Cord connector cover
6	572062008	Plain washer	16		Cord connector (unit)
7	000001609	Snap ring E-5	17	000103509	+ binding head small screw 4 x 10
8	000103406	+ binding head small screw 4 x 8	18	618034006	Belt cover
9	673189008	Synchronized belt	19	000104119	+ binding head small screw 4 x 20
10	000090007	Belt			



Ref. No.	Parts No.	Names of Parts	Ref. No.	Parts No.	Names of Parts
1	673609009	Hook race (unit)	23	000100506	+ pan head small screw 5 x 12
2	673082000	Hook supporter base	24	673075000	Lower shaft front bushing
3	102205006	Set screw	25	673108003	Feed lifting cam
4	673521006	Lower shaft driver (unit)	26	102063000	Set screw
5	673505004	Hook race body (unit)	27	810115004	Lower shaft
6	673084002	Hook race body	28	673613006	Feed lifting adjusting crank (unit)
7	673086004	Hook supporter cap spring	29	673111009	Feed lifting adjusting crank
8	673087005	Set screw	30	680038003	Stopper screw
9	574046002	Hook race ring clasp (A)	31	553088001	Nut
10	574047003	Hook race ring clasp (B)	32	673113001	Feed lifting rock shaft crank roller stud
11	532184003	Hook race ring clasp spring	33	673208004	Hexagon socket screw
12	673290003	Hinge screw	34	673612005	Feed lifting rock shaft crank (unit)
13	673091002	Hook	35	673109004	Feed lifting rock shaft crank
14	673085003	Hook race ring	36	673300007	Feed lifting rock shaft crank spring
15	673205001	Coil spring	37	102021109	Set screw
16	673294007	Hinge screw	38	672050006	Feed lifting rock shaft
17	673083001	Hook supporter base pin	39	000001702	Snap ring E-6 (D)
18	102115008	Bobbin	40	673112000	Feed lifting adjusting crank spring
19	810520006	Bobbin case (unit)	41	810130005	Drop feed plunger
20	000100609	+ pan head small screw 5 x 10	42	000077112	+ pan head small screw 3 x 5
21	000110107	Hexagon socket WP set screw 5 x 5	43	810131006	Drop feed plunger connecting rod
22	673078003	Lower shaft gear	44	810132007	Drop feed plunger spring



Ref. No.	Part No.	Names of Parts	Ref. No.	Part No.	Names of Parts
1	102053007	Flat head set screw	22	000100506	+ pan head small screw 5 x 12
2	681005004	Needle plate	23	810019009	Lower shaft clip belt adjusting gear
3	810506006	Hook cover plate (unit)	24	673208004	Hexagon socket screw
4	810086005	Hook cover plate spring	25	000110107	Hexagon socket WP set screw 5 x 5
5	000103004	+ binding head small screw 3.5 x 6	26	810129001	Feed fork connecting pin
6	810612006	Feed fork (unit)	27	810436004	Spring washer
7	810509009	Feed cam (unit)	28	681602007	Feed rock shaft with feed dog (unit)
8	810117006	Feed fork	29	810511004	Feed rock shaft (unit)
9	000075707	+ flat head T screw 3 x 12-2V	30	681006005	Feed dog
10	810510003	Link supporter (unit)	31	761056104	Set screw
11	000077617	+ pan head small screw 4 x 10	32	532030003	Center screw
12	000061205	Hexagon nut 4-3-7	33	810449000	Cushion plate
13	681601006	Feed regulator arm (unit)	34	670235001	Oil string
14	618013009	Feed rod	35	810128000	Feed rock shaft
15	000002105	Snap ring E-3	36	532101006	Set screw
16	000103303	+ binding head small screw 3.5 x 12	37	673104009	Feed bar
17	681002001	Feed regulator arm plate	38	102021109	Set screw
18	810121014	Feed regulator arm	39	673106001	Feed bar spring
19	000062701	Hexagon nut 3.5-3-6	40	673107002	Feed bar shaft
20	810127009	Feed regulator arm spring	41	000001506	Snap ring E-4 (D)
21	673076001	Lower shaft rear bushing			



Ref. No.	Parts No.	Names of Parts	Ref. No.	Parts No.	Names of Parts
1	810653009	Pulley (unit)	14	000103004	+ binding head small screw 3.5 x 6
2	810391006	Pulley supporter plate	15	810417009	Cord guide plate (2)
3	810392007	V-belt pulley	16	810418000	Cord guide plate (3)
4	802061005	Pulley cushion	17	000103901	+ binding head small screw 4 x 6
5	810393008	Synchronized belt pulley	18		Cord connector cover
6	572062008	Plain washer	19		Cord connector (unit)
7	000001609	Snap ring E-5	20	000103509	+ pan head small screw 4 x 10
8	000103406	+ binding head small screw 4 x 8	21	681004003	Belt cover
9	673189008	Synchronized belet	22	000103107	+ binding head small screw 4 x 14
10	000090xxx	Belt			
11		Motor (unit)			
12	000100609	+ pan head small screw 5 x 10			
13	810420005	Exhaust air cover			