

NP320 GEO

Instructions Manual



CE

**Single Needle, Double thread Chain stitch
Portable Sewing Machine for closing bags
and connecting GEO textile.**

FOR OPERATOR SAFETY

- The contents of this manual are subject to change without prior notice for improvement and safety purpose.

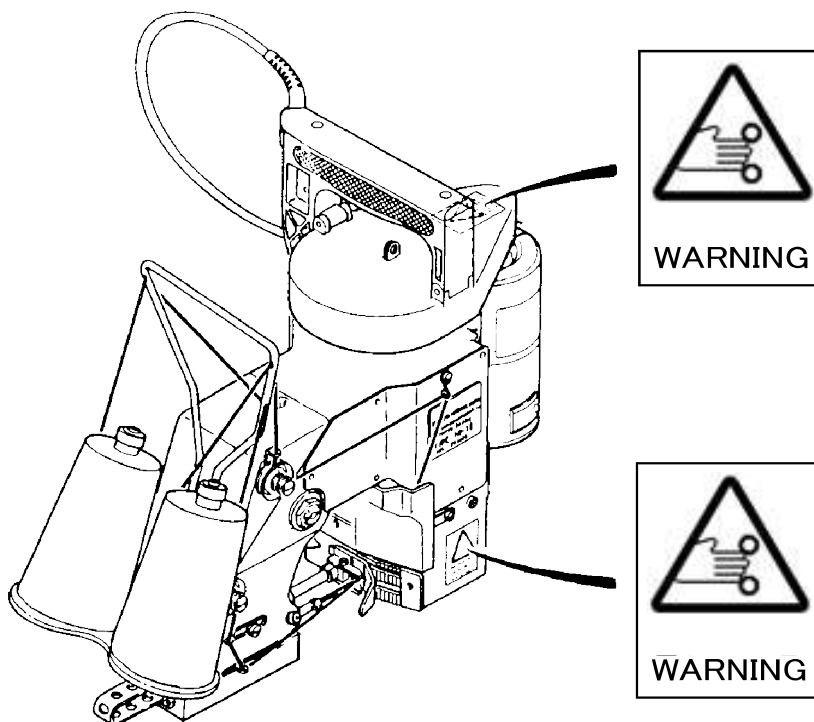


Instructions with this mark are especially important for operator safety. Be sure to observe these marked instructions.



Hazard of Being Caught in the Machine

- Be careful, when you insert a bag to be closed into the sewing machine, or your fingers may be caught in the machine between the presser foot and feed dog.
- A "Hazardous" mark is attached to the machine. When sewing, be sure to support the bag with the hand from beneath the sewing head and not to touch on the machine.
- When adjusting the machine or replacing parts, always disconnecting the Electric Cord from the power source.
This is important in view of safety to the operator and adjuster.



- The instruction manual and parts list is subject to change without prior notice.

WARNING

PERSONAL INJURY MAY RESULT IF THE FOLLOWING SAFETY PRECAUTIONS ARE NOT OBSERVED.

1. BE SURE THE AREA SURROUNDING MACHINE IS FREE OF ALL HAZARDS SUCH AS FIRE, WATER, OIL, RUBBISH OR ANYTHING THAT CAN CAUSE INJURY.
2. DO NOT OPERATE MACHINE IN AN EXPLOSIVE AREA OR UNDER WET CONDITIONS. THE MACHINE IS NOT AN EXPLOSION-PROOF TYPE NOR WATER-PROOF TYPE.
3. DO NOT OPERATE MACHINE BEFORE READING INSTRUCTION MANUAL.
4. DO NOT OPERATE MACHINE ON VOLTAGES OTHER THAN SPECIFIED FOR THE MACHINE.
5. BE SURE MACHINE IS CONNECTED TO BUILDING ELECTRICAL SAFETY GROUND (EARTH).
6. BE SURE POWER (AND AIR SUPPLY) IS OFF BEFORE PERFORMING MACHINE MAINTENANCE, PARTS REPLACEMENT, ADJUSTMENTS OR CLEANING.
7. DO NOT OPERATE MACHINE WITH GUARDS AND COVERS REMOVED.
8. DO NOT TOUCH KNIFE, NEEDLE, PULLEY, BELT AND MOVING PARTS WHEN MACHINE IS IN OPERATION.
9. BE SURE MACHINE IS PLACED ON A SMOOTH (LEVEL) SURFACE WHEN PERFORMING MAINTENANCE, PARTS REPLACEMENT, ADJUSTMENTS, CLEANING OR STORAGE.
10. BE SURE THE MATERIAL TO BE SEWN OR CLOSED COMPLIES WITH THE MACHINE SPECIFICATIONS.
11. DO NOT USE SPARE PARTS OTHER THAN " NLI " GENUINE PARTS.

Identifying and Ordering Parts

Where the construction permits, each part is stamped with its part number. On all orders, please include part number, part name and model name of machine.

Safety Rules

To prevent personal injury:

- All power sources to the machine must be turned off before threading, oiling, adjusting or replacing parts.
- All cover and guards must be in position before operating machine.
- Do not tamper with safety cover, guards, etc., while machine is in operation.

Cautions When Using the Machine

Safety Precautions

- 1) Always turn power off before threading, oiling, and adjusting the machine or replacing parts.
- 2) Wear safety glasses.
- 3) Make sure, before starting the machine, that all covers and shields are in place and closed.
- 4) Do not touch on the machine when it is run.
- 5) Turn power off and make sure the cutter does not operate before you put your fingers under the cutter blades and the needles to adjust.
- 6) Do not touch on the machine when it is run.

Maintenance

- Please keep in mind to handle the machine carefully and to maintain the machine in good condition.
- Thread fuzz or dust must be cleaned with air or brush on throat plate, in the groove of feed dog or around looper after the day's work.
- Wipe the area easy to rust with oil cloth.
- Check the machine for loose screws and tighten them, if any, once a month.
- Good maintenance will prolong the machine life.

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1. SPECIFICATIONS

Seam	Double Thread Chain stitch
Stitch Range (mm.)	8.5mm (fixed)
Speed (rpm.)	1,650rpm ± 100
Needle	DN × 1#25
Thread	20/6 (vinyon, synthetic or cotton)
Bag Material To Be Closed	Kraft Paper, PP/PE Woven Cloth, Cotton, Hessian, Jute
Drive Motor	AC90W 220V, 50/60Hz 1phase
Power Supply	110~120, 220 or 240V.A.C.
totally enclosed type for overseas type	12V, 24.,D.C. (specify one.) 50-60Hz, Single Phase

2. THE POINTS BEFORE OPERATION

- Oil the area through which thread passes, the tension disc, the thread guide, looper, etc.
(Note:An anticorrosive agent is applied to the machines at the factory, in order to prevent rusting. It is necessary to use oil to remove this agent. or it may prevent the thread from passing smoothly.)
- Confirm that the machine has been threaded as per the instructions 3. in the manual.
- Confirm that the machine has been lubricated as per the instructions 4. in the manual.

3. THREADING

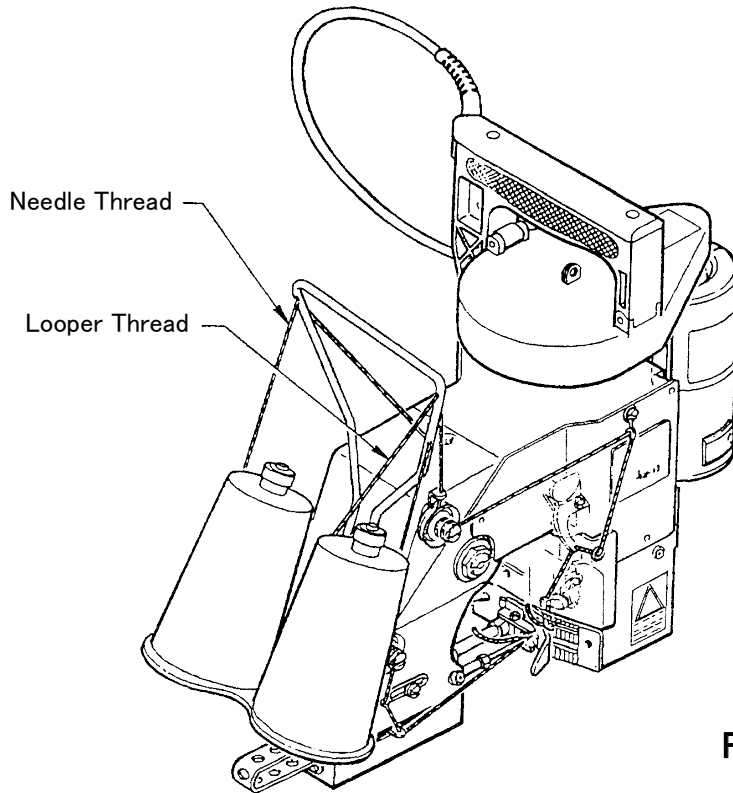


Fig.1

4. OILING

With adoption of hand lubricating system, the drip oiling before operation is imperative to keep the machine in good condition.

The oiling points are shown in red circle or are where the ball cups and the oil cups are provided.

The lubricant oil should be in conformity with the machine oil attached with the machine, the white spindle #60 (viscosity of 10 cSt) or the equivalent.

5. OPERATION

1. Hold the machine at the handle in your right hand.
2. Support the bag slightly by your left hand and insert the edge of a bag between presser foot and feed dog.
3. Push the switch button or the handle by your index finger to stitch the bag. Apart your index finger from the push button to stop the machine.
4. After stitching, the plain chain stitch with 1-2 inches in length shall be pressed down in the gutter of throat plate to be cut down by knives mounted on the machine.

Caution

Stitch the bag synchronously with the speed of feed dog. If the bag is pulled out faster than that of feed dog, it causes mis-stitch or needle break.

6. ADJUSTMENT

The machine has been properly adjusted before shipment from the factory. But if it needs re-adjustment for repair or replacement of parts, proceed as follows; When adjusting, make sure that the electric wiring plug is removed from the consent.

6-1 Needle and Loper (Fig.2)

Check the distance between needle center and looper edge. Turn the pulley by hand until the looper reaches its right furthest position, while keeping the clearance of 5mm between needle center and looper edge.

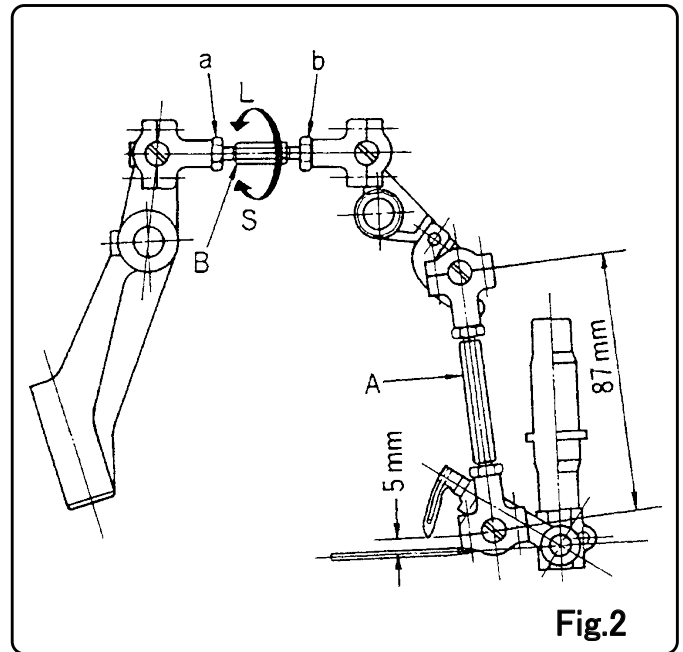
1) Confirm whether or not the distance between centers of ball joint (A) is being kept 87mm. Also pay special attention to the strict distance of 87mm, and if not, it is unable to adjust every parts at all.

2) Turn the pulley again by hand until looper reaches its left furthest position, while keeping the clearance of 5mm between needle center and looper edge to loose nuts (a) and (b) of joint rod (B).

In case the distance between centers is more than 5mm, turn joint rod (B) to "S" direction to decrease it.

In case the distance between centers is less than 5mm, turn joint rod (B) to "L" direction to increase it.

Make sure that the nut (b) has left-handed thread.



6. ADJUSTMENT

6-2 Needle Height (Fig.4)

When the looper moves left and right to turn pulley by hand, the looper and the needle shall be adjusted in such a way that the bottom of both holes will be entirely corresponded as shown in Fig.3.

- 1) Check if or not the needle is set in the needle bar as deep as it will go by loosening the needle bar clamping nut.
- 2) Make sure of setting a needle with its concave part facing correctly toward the looper when the needle is just going up from the lowest position.
- 3) Should it be necessary to change needle height, first remove the upper face plate.

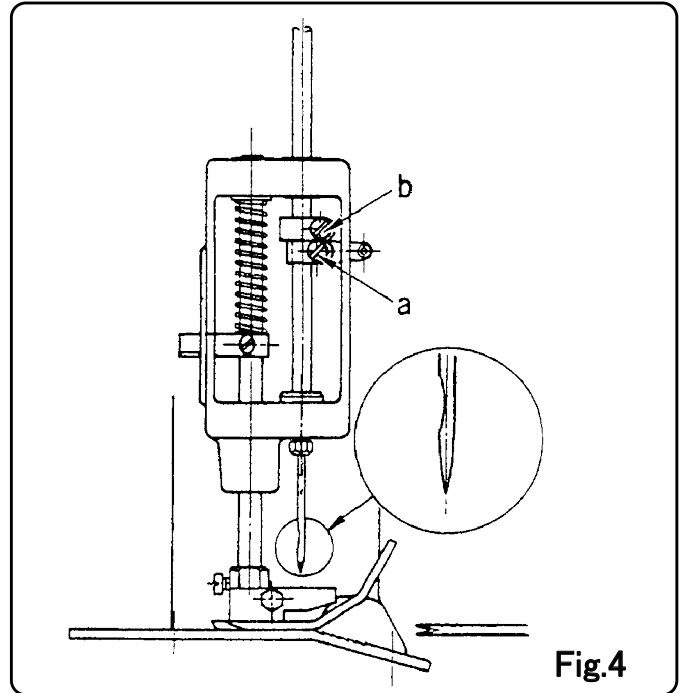
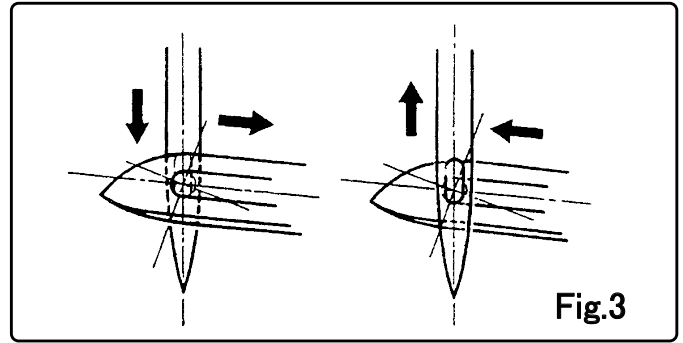
To go up the needle••••

Loosen the screw (a), lower the needle bar connection to obtain proper distance required and tighten it. Then, loosen the screw (b), risen the needle bar until the needle bar connection touches the needle bar connecting stud and tighten it.

To go down the needle••••

Loosen the screw (b), lower the needle bar to obtain proper distance required and tighten it. Then, loosen the screw (a), fix the needle bar connection at the place where it touches the needle bar connecting stud and tighten it.

- 4) Check once again if the direction of concave part of needle is correct or not.



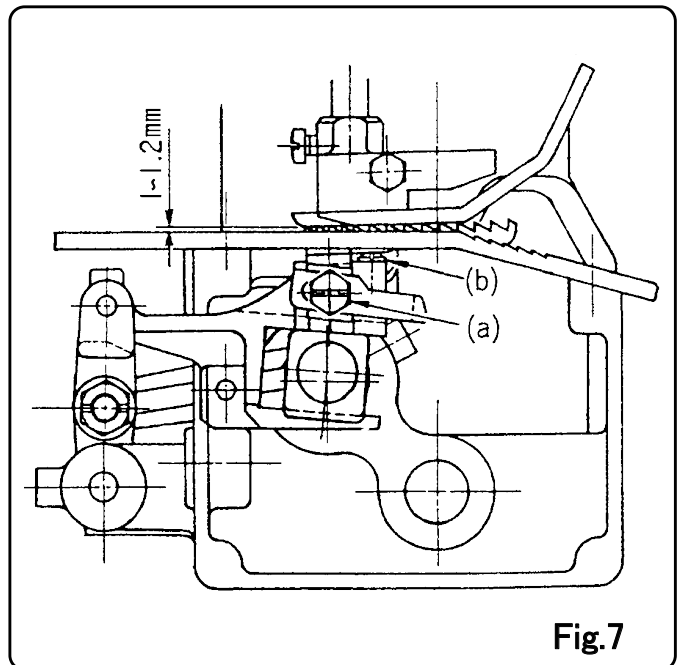
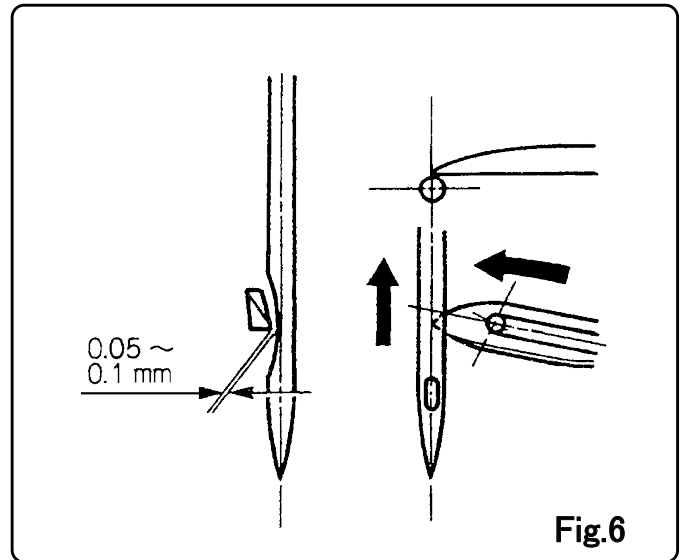
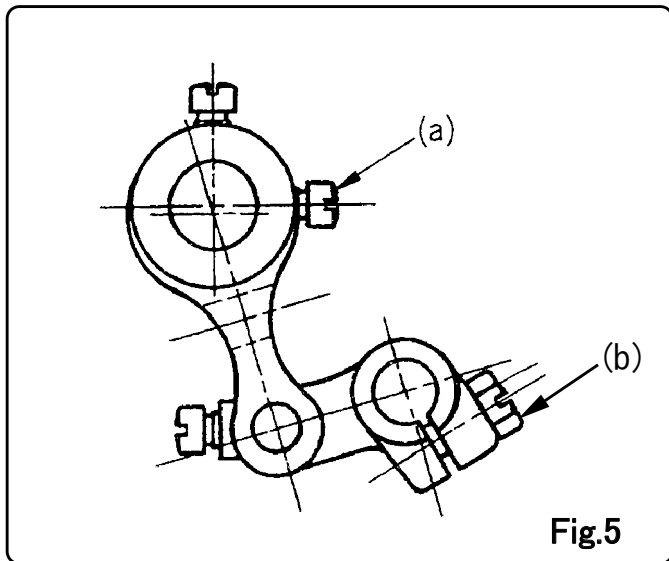
6. ADJUSTMENT

6-3 Gap between Loper and Needle

Turn pulley by hand and fix eccentric cam so that the screw (a) may be horizontal position as shown in Fig.5, while the looper is passing behind needle and the sharp point of looper is corresponded with needle center.

Afterwards, adjust the gap to be 0.05-0.1mm between looper and needle to confirm they are not clashed each other when the sharp point of looper is passing behind needle.

The adjustment of the gap shall be done by loosening screw (b) of looper oscillating arm.



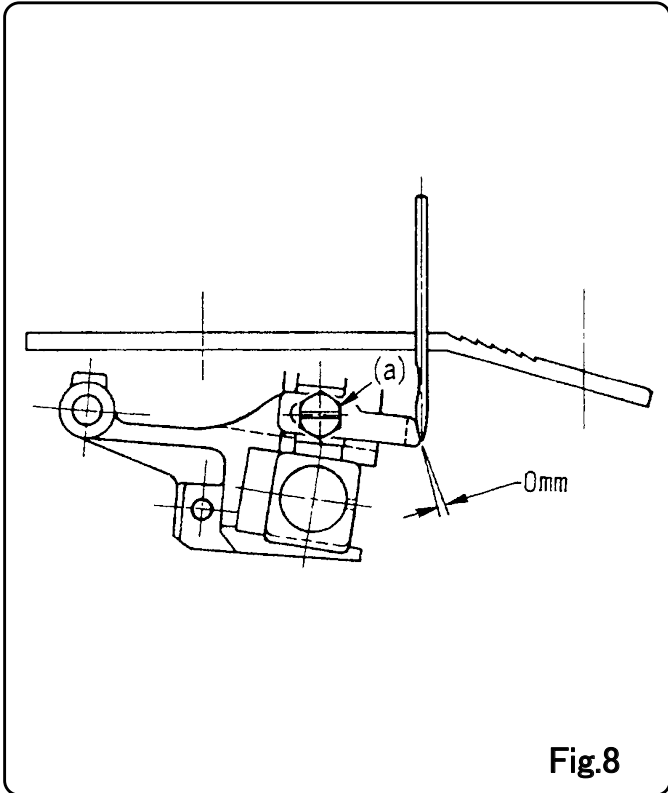
6-4 Feed Dog Height (Fig.7)

Adjust the height of feed dog to loosen screw (a) in order to obtain the most appropriate protrusion of 1.0-1.2mm above the upper surface of throat plate after regulating the screw (b).

6. ADJUSTMENT

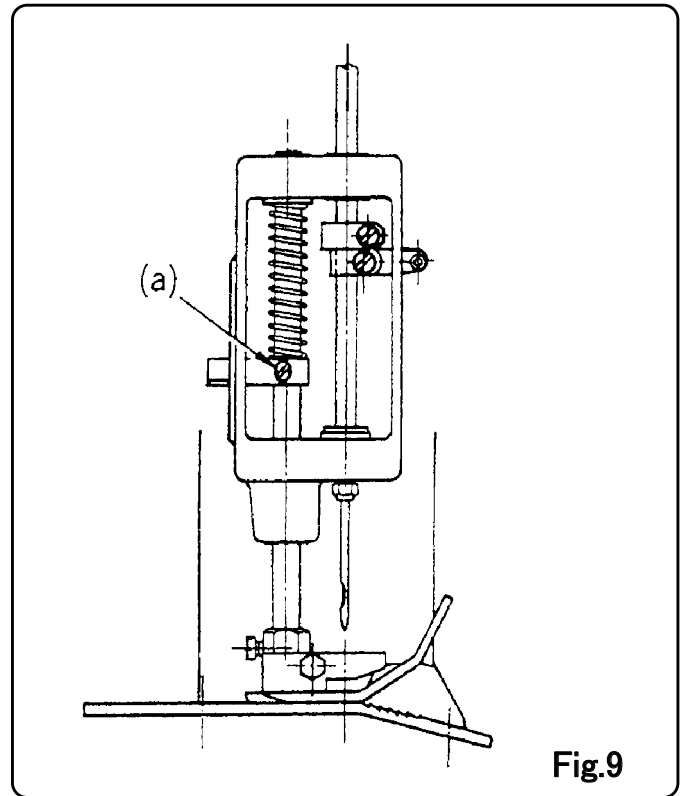
6-5 Needle Guard Adjustment

Adjust the clearance between needle guard and needle to zero when the needle is just coming up from its lowest position as shown in Fig.8 and tighten the screw (a)



[NOTES ON CARRYING AND STORAGE]

1. Carry the machine in a storage box.
2. After the use of the machine, remove the plug, clean the dirt, take the thread from the machine and then put it into a storage box. We suggest you to use a soft brush to clean the rear of the machine.
3. Never store the machine under the sunlight dried or wet condition.



6-6 Pressure of Presser Foot (Fig.9)

The pressure of presser foot shall be adjusted in such a manner that the upper face plate will be taken out first and then the presser bar connecting stud will be moved up-and-down by loosening its screw (a).

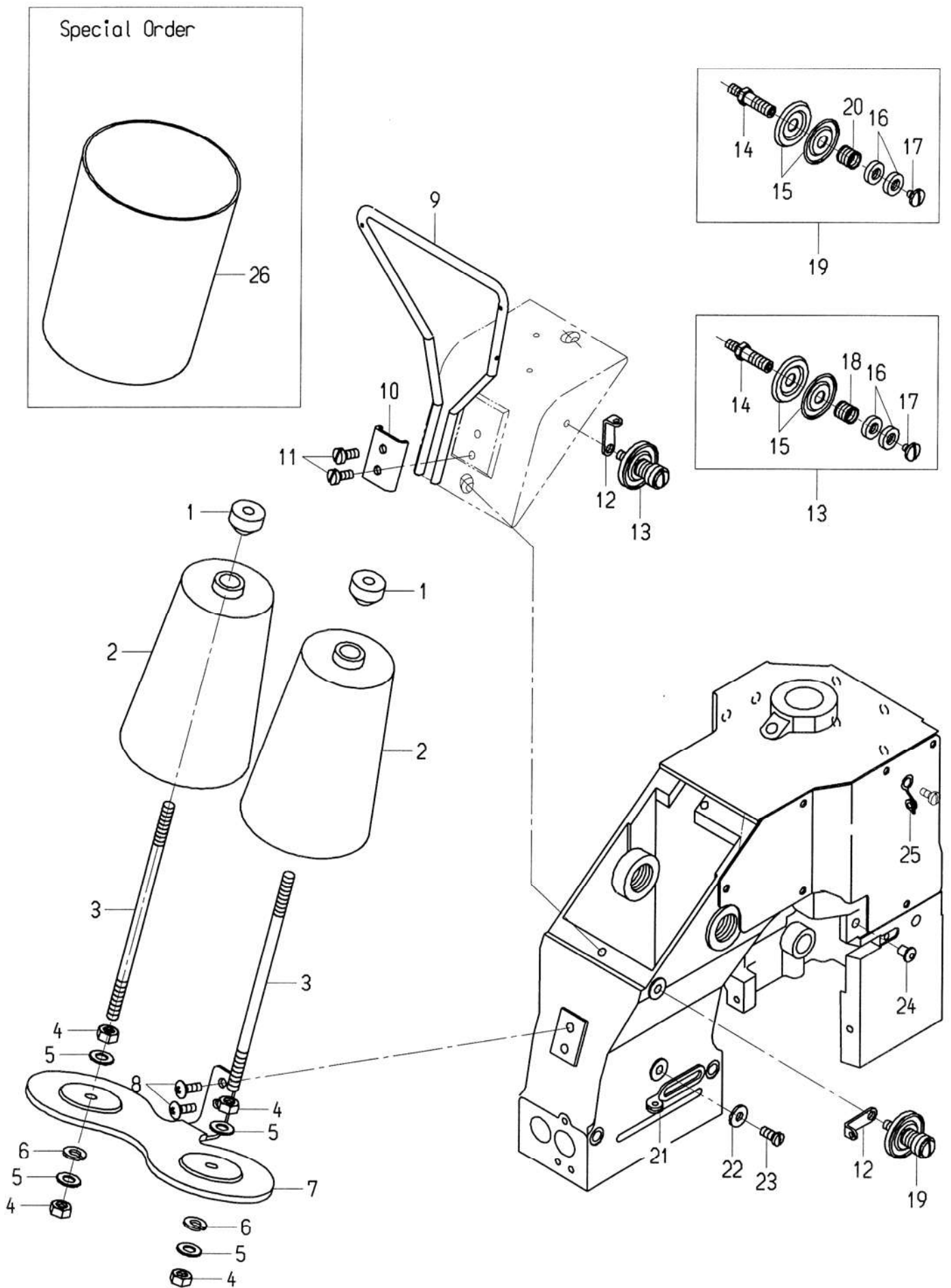
When stitching thinner material (ex. p.p. woven cloth bag), increase pressure.

On the other hand when stitching thicker material (ex. jute bag), decrease pressure.

PARTS LIST CONTENTS

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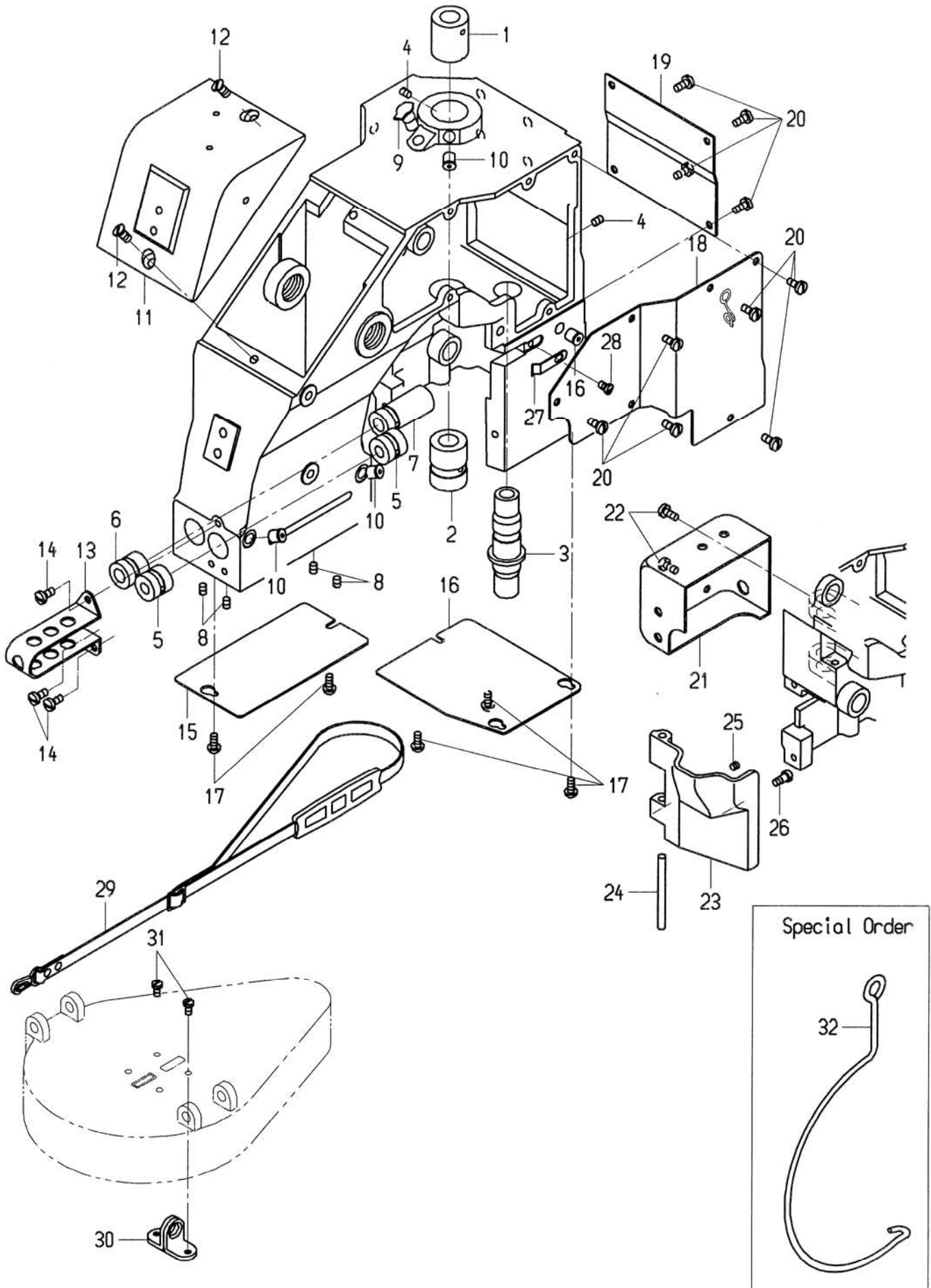
(1) THREAD STAND AND THREAD TENSION PARTS



(1) THREAD STAND AND THREAD TENSION PARTS

Ref.No.	Part No.	Description	Q' ty	Remarks
1	245201	Thread Cone Clamping Nut	2	
2	K01001	Thread	2	
3	245052	Thread Cone Clamping Rod	2	
4	1N6	Nut for 245052	4	
5	2W6	Washer for 245052	4	
6	3W6	Lock Washer for 245052	2	
7	205101	Thread Cone Stand	1	
8	10S4×12	Screw for 205101	2	
9	295041	Thread Guide	1	
10	295061	Thread Guide Holder	1	
11	11/64S40009	Screw for 295041	2	
12	245071	Thread Tension Eyelet	2	
13	245081B	Thread Tension Assembly for looper	1	(14-18)
14	245081	Tension Post	2	
15	065261	Tension Disc	4	
16	245091	Tension Nut	4	
17	9/64S40011	Screw for 245081	2	
18	205091	Tension Spring	1	
19	245081A	Thread Tension Assembly for needle	1	(14-17,20)
20	245101	Tension Spring	1	
21	P5011	Thread Countrollar for Needle	1	
22	11/64W15103	Washer for P5011	1	
23	3/16S28002	Screw for P5011	1	
24	P5161	Thread Guide Bushing for looper	1	
25	P5031	Thread Guide Wire for looper	1	
26	245181	Thread Coue Cover	(2)	

(2) COVERS, BUSHINGS AND OILING PARTS



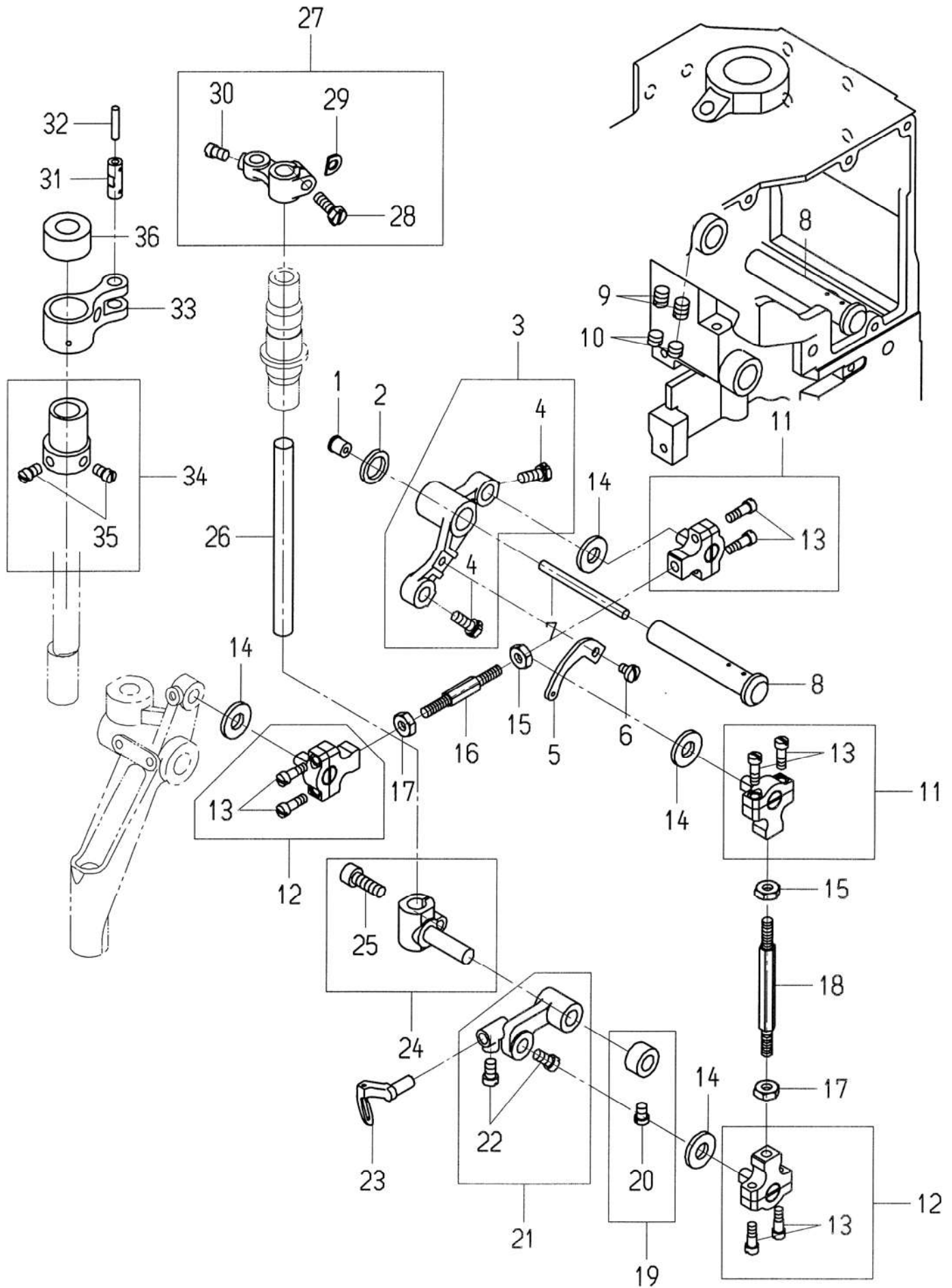
(2) COVERS, BUSHINGS AND OILING PARTS

Ref.No.	Part No.	Description	Q' ty	Remarks
1	241111	Main Shaft Bushing, front	1	
2	241122	Main Shaft Bushing, rear	1	
3	203031	Looper Rocker Shaft Bushing	1	
4	9/64S40502	Screw for 241122, 241111,243031	3	
5	202051	Needle Bar Bushing	2	
6	242211	Presser Bar Bushing, upper	1	
7	242221	Presser Bar Bushing, lower	1	
8	9/64S40502	Screw for 242211, 202051, 242221	4	
9	D01003	Oil Cup	1	
10	D01001	Push Oil Cup	5	
11	205191	Top Cover	1	
12	11/64S40007	Screw for 205191	2	
13	202091	Needle Bar Guard	1	
14	9/64S40005	Screw for 202091	3	
15	205021	Face Plate	1	
16	205032	End Cover	1	
17	9/64S40065	Screw for 205021,205032	5	
18	205042	Side Cover	1	
19	205201	Inside Cover	1	
20	9/64S40005	Screw for 205042, 205201	10	
21	205071	Feed Rocker Cover	1	
22	9/64S40005	Screw for 205071	2	
23	205002	Cover	1	
24	205011	Looper Cover Hinge Pin	1	
25	9/64S40501	Screw for 205011	1	
26	9/64S40058	Screw	1	
27	P1091	Looper Cover Extension Lock Spring	2	
28	9/64S40001	Screw for P1091	1	
29	245171	Shoulder Belt	1	
30	241151	Hook	1	
31	1/8S40006	Screw for 241151	2	
32	245271	Hanger	1	

(3) NEEDLE BAR, PRESSER BAR AND DRIVING PARTS

Ref.No.	Part No.	Description	Q' ty	Remarks
1	241091	Synchro Pulley	1	(2)
2	3/16S28009	Screw for 241091	2	
3	241131	Retaining Collar	1	(4)
4	11/64S40502	Screw for 241131	2	
5	241161	Spacer	1	
6	205131	Oil Felt	1	
7	202001A	Needle Lever Connecting Rod Assembly	1	(8,9)
8	11/64S40090	Screw for needle lever connecting rod cap	4	
9	11/64S40001	Screw for eccentric cam	2	
10	076062	Ball Stud Guide Fork	1	
11	9/64S40003	Screw for 076062	1	
12	201011	Main Shaft	1	
13	205131	Oil Felt	1	
14	D01001	Push Oil Cup	2	
15	245411	Oil Felt	2	
16	5/8N18101	Nut for 242081	2	
17	242081	Adjusting Stud	2	
18	245231	Oil Felt	2	
19	202041	Needle Lever Stud	1	
20	202033A	Needle Lever Assembly	1	(21,22)
21	11/64S40006	Screw for 013081B	1	
22	3/16S28005	Screw for 202033A	2	
23	245371	Oil Felt	1	
24	205171	Oil Felt	1	
25	202071A	Needle Bar Connection Assembly	1	(26)
26	11/64S40003	Screw for 202071A	1	
27	202081	Thread Take-Up for needle	1	(28)
28	11/64S40002	Screw for 202081	1	
29	202061A	Needle Bar With Nut	1	(30)
30	P2412	Needle Lock Nut	1	
31	B01002	Needle (DN × 1 #25)	1	
32	202131A	Presser Foot Assembly	1	(33-35)
33	11/64S40005	Screw for presser foot shank	1	
34	9/64S40055	Presser Foot Hinge Screw	1	
35	9/64N40101	Nut for presser foot hinge	1	
36	202101	Presser Bar	1	
37	242181	Presser Bar Connection	1	(38)
38	11/64S40003	Screw for 242181	1	
39	242191	Presser Foot Lifter	1	
40	242171	Presser Foot Lifter Base	1	
41	11/64S40007	Screw for 242171	2	
42	11/64S40002	Screw for 242171	1	
43	9/64S40001	Presser Foot Lifter Stopper Screw	1	
44	2W5	Washer	1	
45	242271	Collar	1	
46	242161	Presser Foot Lifter	1	
47	31LP6	"O" Ring	1	
48	11/64W15103	Washer for 242161	1	
49	11/64S40009	Screw for 242161	1	

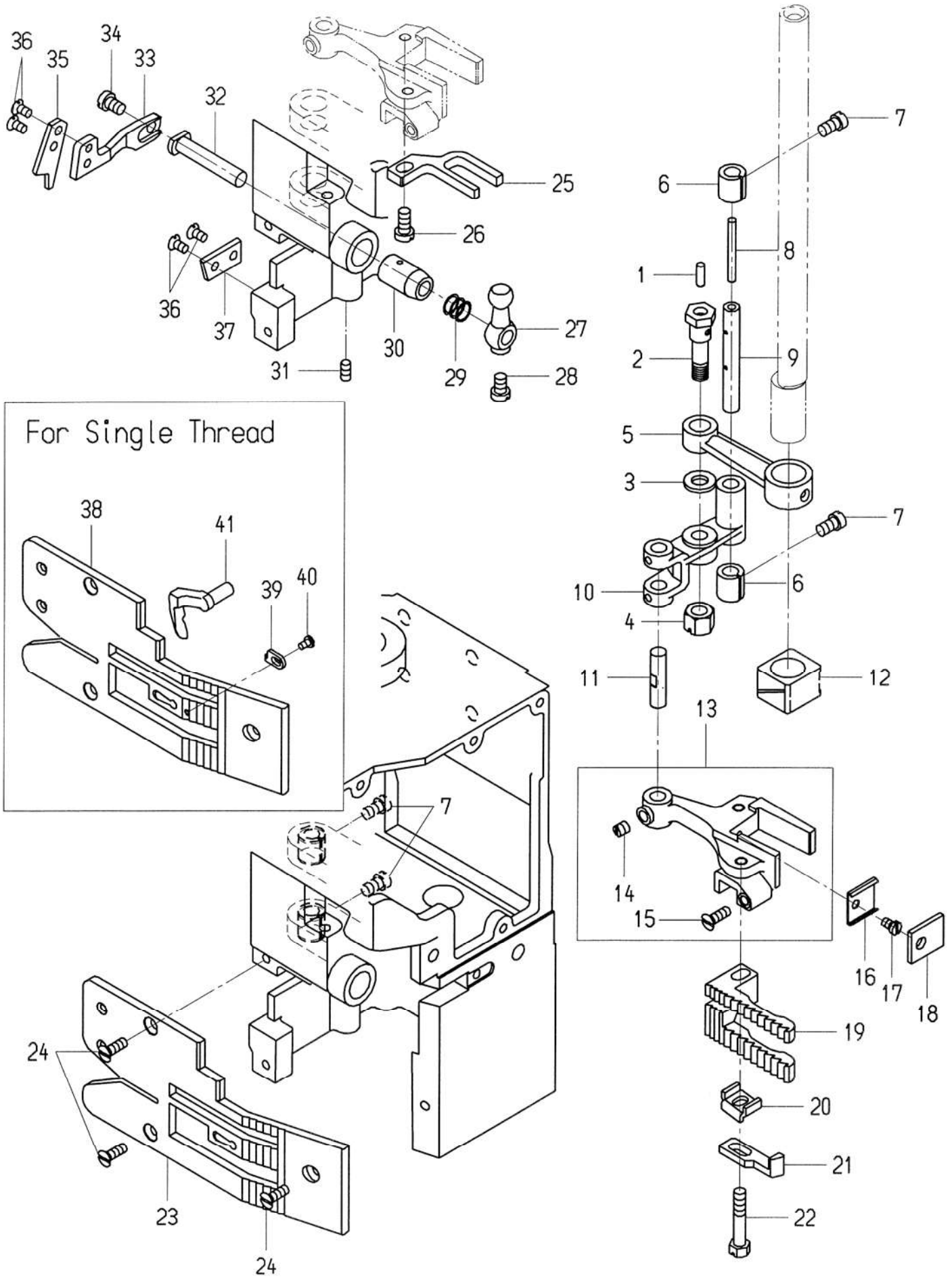
(4) LOOPER DRIVING PARTS



(4) LOOPER DRIVING PARTS

Ref.No.	Part No.	Description	Q' ty	Remarks
1	D01001	Push Oil Cup	1	
2	P3051	Spacer	1	
3	203091	Looper Bell Crank	1	(4)
4	11/64S40049	Screw for 013081B	2	
5	203111	Thread Take-Up for looper	1	
6	9/64S40004	Screw for 203111	1	
7	205211	Oil Felt	1	
8	203101	Looper Bell Crank Hinge Stud	1	
9	15/64S28513	Screw for 203101	2	
10	15/64S28511	Screw for 203101	2	
11	013042B	Ball Joint Assembly	2	(13)
12	013062A	Ball Joint Assembly	2	(13)
13	9/64S40061	Screw for ball joint	8	
14	9/32W20108	Fiber	4	
15	11/64N40203L	Nut for ball joint rod	2	
16	013081	Ball Joint Rod	1	
17	11/64N40203	Nut for ball joint rod	2	
18	203121	Ball Joint Rod	1	
19	203071	Looper Rocker Collar	1	(20)
20	11/64S40076	Screw for 203071	1	
21	203061	Looper Rocker	1	(22)
22	11/64S40002	Screw for 013062A, 203081	2	
23	203081	Looper	1	
24	203051	Looper Rocker Frame	1	(25)
25	4B5×12	Screw for 203051	1	
26	203041	Looper Rocker Shaft	1	
27	203021	Looper Rocker Shaft Arm	1	(28-29)
28	11/64S40089	Screw for P2071	1	
29	11/64W10104	Washer for 203021	1	
30	11/64S40001	Screw for P2071	1	
31	P2071	Link Pin	1	
32	205141	Oil Felt	1	
33	203011	Looper Avoid Link	1	
34	203001	Looper Avoid Eccentric	1	(35)
35	11/64S40001	Screw for 203001	2	
36	205181	Oil Felt	1	

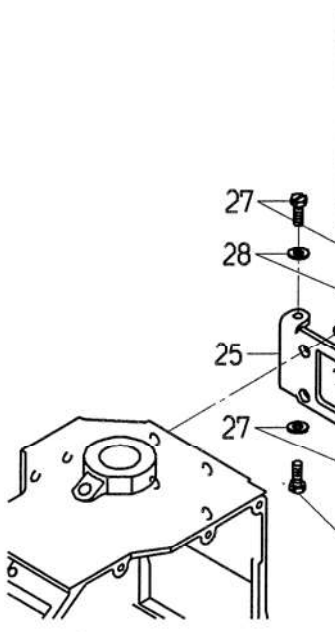
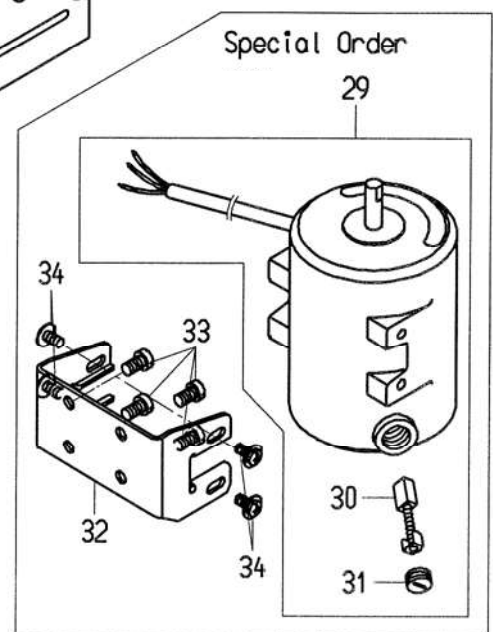
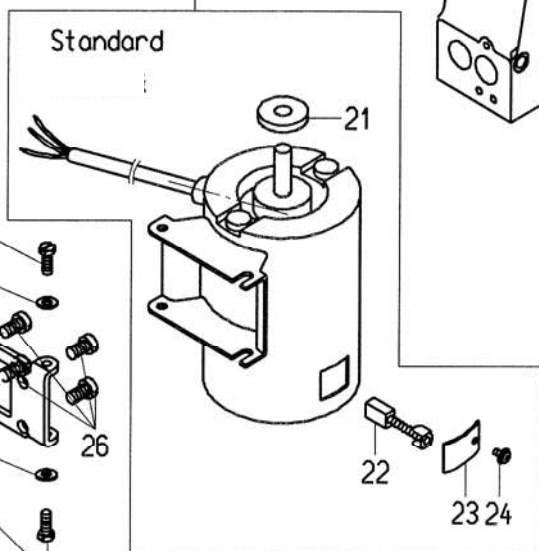
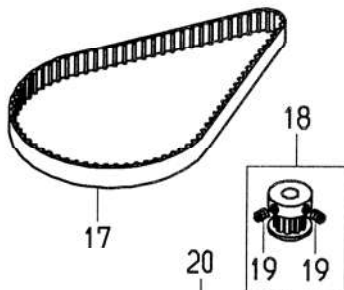
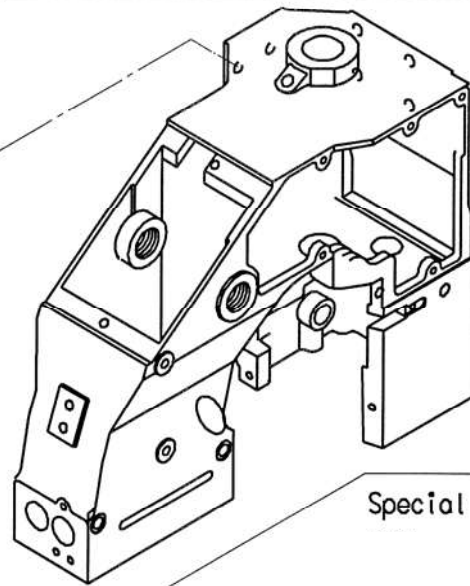
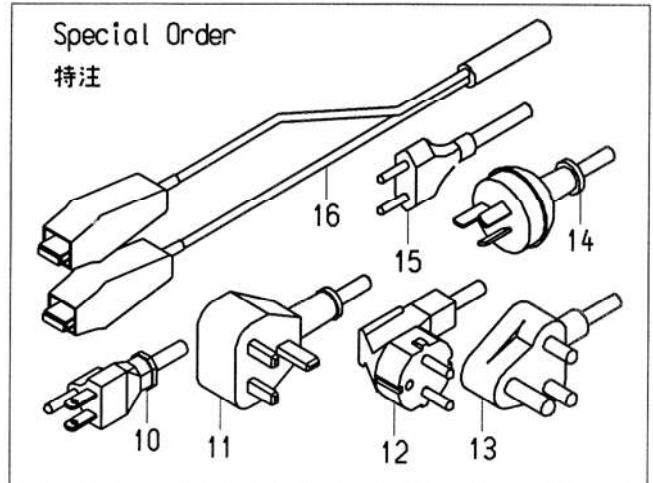
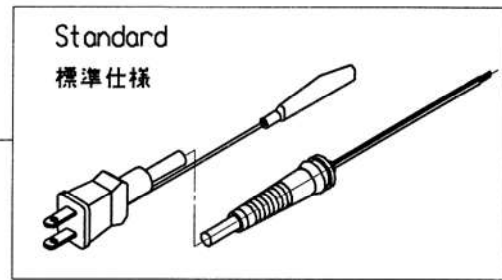
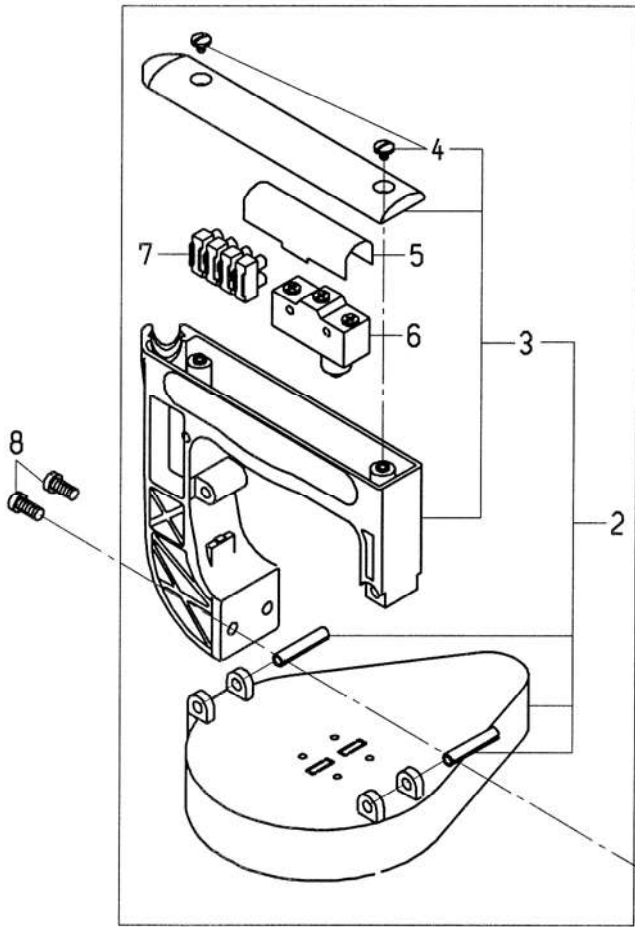
(5) FEED DRIVING AND THREAD CUTTER PARTS



(5) FEED DRIVING AND THREAD CUTTER PARTS

Ref.No.	Part No.	Description	Q' ty	Remarks
1	205161	Oil Felt	1	
2	204041	Feed Rocker Connecting Rod Pin	1	
3	P4031	Washer for 204041	1	
4	15/64N28208	Nut for 204041	1	
5	204031	Feed Rocker Connecting Rod	1	
6	204001	Feed Rocker Shaft Bushing	2	
7	11/64S40002	Screw for 204001	2	
8	205151	Oil Felt	1	
9	204021	Feed Rocker Shaft	1	
10	204011	Feed Rocker	1	
11	P4101	Feed Bar Shaft	1	
12	204051	Feed Lifting Block	1	
13	204062	Feed Bar	1	(14,15)
14	11/64S40502	Screw for P4101	1	
15	9/64S40043	Feed Dog Height Adjusting Screw	1	
16	205111	Lubricating Felt Holder	1	
17	1/8S44009	Screw for 205111	1	
18	205121	Lubricating Felt	1	
19	204071	Feed Dog	1	
20	P4161	Needle Guard Holder	1	
21	204081	Needle Guard	1	
22	11/64S40012	Screw for 204071	1	
23	204091	Throat Plate	1	
24	9/64S40043	Screw for 204091	3	
25	206043	Knife Bracket Extension	1	
26	11/64S40006	Screw for 206043	1	
27	206061	Knife Bracket Extension Ball	1	
28	11/64S40005	Screw for 206051	1	
29	246051	Knife Tension Spring	1	
30	206002	Knife Bracket Pin Bushing	1	
31	9/64S40503	Screw for 206002	1	
32	206012	Knife Bracket Pin	1	
33	206022	Knife Bracket	1	
34	11/64S40005	Screw for 206022	1	
35	246061	Knife, moving	1	
36	1/8S40003	Screw for 246061, 246071	4	
37	246071	Knife, stationary	1	
38	204092	Throat Plate	(1)	
39	204101	Throat Plate Thread Retainer	(1)	
40	3/32S56004	Screw for 204101	(1)	
41	203131	Looper	(1)	

(6) MOTOR, SWITCH AND HANDLE PARTS



(6) MOTOR, SWITCH AND HANDLE PARTS

Ref.No.	Part No.	Description	Q' ty	Remarks
1	241024CS	Handle Assembly	1	(2,5-7)
2	241024C	Handle Assembly	1	(3,4)
3	241024	Handle	1	(4)
4	9/64S40011	Screw for 241024C	2	
5	245132	Micro Switch Cover	1	
6	C02001	Micro Switch (Z-15GK655-B)	1	
	C02006	Micro Switch (X-10GD-B) for DC Motor	1	
7	C05008	Flexible Terminal Block (ML-SK-1,4P)	1	
8	15/64S28021	Screw for 241024C	2	
9	C04001	Cabtyre Cord, with Plug (Standard Type)	1	
10	C04003	Cabtyre Cord, with Plug (American Type)	1	
11	C04004	Cabtyre Cord, with Plug (British Type)	1	
12	C04005	Cabtyre Cord, with Plug (German Type)	1	
13	C04013	Cabtyre Cord, with Plug (South Africa Type)	1	
14	C04007	Cabtyre Cord, with Plug (Australian Type)	1	
15	C04015	Cabtyre Cord, with Plug (Indonesia Type)	1	
16	C04009	Cabtyre Cord, with Plug (for DC Motor)	1	
17	F01002	Timing Belt 170XL	1	(15)
18	241082	Motor Pulley	1	(13)
19	11/64S40504	Screw for 241081	2	
20	C01028	Universal Motor (220V-90W)	1	(21-24)
	C01029	Universal Motor (240V-90W)	1	(21-24)
	C01030	Universal Motor (110V-90W)	1	(21-24)
	C01031	Universal Motor (100V-80W)	1	(21-24)
21	C07005	Rubber Ring	(1)	
22	C08004	Carbon Brush for AC Motor	(2)	
	C08005	Carbon Brush for DC Motor	(2)	
23	C07003	Cap	(2)	
24	4S3×6-W	Screw	2	
25	241072	Motor Base B	1	
26	15/64S28004	Screw for 241072	4	
27	11/64S40075	Screw for Motor	4	
28	11/64W10101	Washer for Motor	4	
29	C01046	Universal Motor (110V-120V)	1	(30,31)
	C01047	Universal Motor (220V)	1	(30,31)
	C01048	Universal Motor (230V~240V)	1	(30,31)
30	C08008	Carbon Brush	(2)	
31	C07001	Cap	(2)	
32	241075	Motor Base	1	
33	15/64S28004	Screw	4	
34	13S5×10	Screw for Motor	4	

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SCREW, NUT & WASHER

