

SERVICING MANUAL & PARTS LIST

MODELS	JF 1022
	JF 1018S
	JF 1018
	JF 1014
	JF 1012 (BL1108)
	JF 1004

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WHAT TO DO WHEN

CONDITION	CAUSE	HOW TO FIX	REFERENCE
1. SKIPPING STITCHES	1. NEEDLE IS NOT INSERTED PROPERLY.	INSERT THE NEEDLE PROPERLY.	P.15 P.16 P.13,14
	2. NEEDLE IS BENT OR WORN.	CHANGE THE NEEDLE.	
	3. INCORRECTLY THREADED.	RETHREAD.	
	4. NEEDLE OR THREAD ARE INAPPROPRIATE FOR FABRIC BEING SEWN.	USE THE RECOMMENDED SEWING NEEDLE AND THREAD.	
	5. SEWING ON STRETCH FABRIC.	USE A #11 BLUE TIP NEEDLE.	
	6. INAPPROPRIATE NEEDLE BAR HEIGHT.	SEE MECHANICAL ADJUSTMENT "NEEDLE BAR HEIGHT".	
	7. INAPPROPRIATE NEEDLE TO HOOK TIMING.	SEE MECHANICAL ADJUSTMENT "HOOK TIMING".	
	8. INAPPROPRIATE NEEDLE TO HOOK CLEARANCE.	SEE MECHANICAL ADJUSTMENT "CLEARANCE BETWEEN NEEDLE AND HOOK".	
2. FABRIC NOT MOVING	1. INCORRECT F.D. HEIGHT.	SEE MECHANICAL ADJUSTMENT "HEIGHT OF FEED DOG".	P.12
	2. THREAD ON BOTTOM SIDE OF FABRIC IS JAMMED UP.	MAKE SURE TO BRING BOTH NEEDLE AND BOBBIN THREAD UNDER THE FOOT WHEN STARTING SEWING.	
	3. FEED DOG TEETH ARE WORN.	CHANGE THE FEED DOG.	

CONDITION	CAUSE	HOW TO FIX	REFERENCE
3. BREAKING UPPER THREAD	1. INITIAL SEWING SPEED IS TOO FAST. 2. THREAD PATH IS INCORRECT. 3. NEEDLE IS BENT OR DULL. 4. UPPER THREAD TENSION IS TOO STRONG. 5. NEEDLE SIZE IS INAPPROPRIATE FOR FABRIC. 6. NEEDLE EYE IS WORN. 7. NEEDLE HOLE IN NEEDLE PLATE IS WORN OR BURRED.	START WITH MEDIUM SPEED. USE THE PROPER THREAD PATH. REPLACE WITH A NEW NEEDLE. ADJUST UPPER THREAD TENSION CORRECTLY. USE APPROPRIATE NEEDLE FOR FABRIC AND THREAD IN USE. CHANGE THE NEEDLE. REPAIR THE HOLE OR REPLACE THE NEEDLE PLATE.	P.7
4. BREAKING BOBBIN THREAD	1. INCORRECTLY THREADED BOBBIN CASE. 2. TOO MUCH THREAD IS AROUND ON THE BOBBIN. 3. LINT IS STUCK INSIDE THE BOBBIN HOLDER. 4. THREAD QUALITY IS TOO LOW. 5. THREAD IS JAMMING AROUND THE BOBBIN. 6. BOBBIN THREAD TENSION IS TOO STRONG.	THREAD BOBBIN CASE CORRECTLY. ADJUST THE POSITION OF STOPPER. CLEAN THE HOOK RACE. CHANGE TO A HIGH QUALITY SEWING THREAD. CLEAR OUT THE JAMMING THREAD. ADJUST BOBBIN THREAD TENSION CORRECTLY.	P.8
5. NEEDLE BREAKS	1. NEEDLE IS HITTING THE NEEDLE PLATE. 2. NEEDLE IS BENT OR WORN. 3. NEEDLE IS HITTING THE HOOK RACE. 4. THE FABRIC MOVES WHILE THE NEEDLE IS PIERCING IT, OR THE NEEDLE ZIGZAGS WHILE IN FABRIC. 5. FABRIC IS BEING PULLED TOO STRONGLY WHILE SEWING.	SEE MECHANICAL ADJUSTMENT "NEEDLE DROP". CHANGE THE NEEDLE. SEE MECHANICAL ADJUSTMENT "CLEARANCE BETWEEN NEEDLE AND HOOK". SEE MECHANICAL ADJUSTMENT "NEEDLE SWING". GUIDE THE FABRIC GENTLY WHILE SEWING.	P.11 P.13,14 P.10

CONDITION	CAUSE	HOW TO FIX	REFERENCE
6. NOISY OPERATION	1. BACKLASH BETWEEN SHUTTLE HOOK GEAR AND LOWER SHAFT GEAR IS TOO GREAT.	SEE MECHANICAL ADJUSTMENT "CLEARANCE BETWEEN NEEDLE AND HOOK (NO.2)".	P.14
	2. LOWER SHAFT GEAR IS LOOSE.	ELIMINATE THE LOOSENESS.	
	3. INAPPROPRIATE BELT TENSION.	SEE MECHANICAL ADJUSTMENT "MOTOR BELT TENSION".	P.25
	4. UPPER SHAFT GEAR IS LOOSE.	ELIMINATE THE LOOSENESS.	
	5. NOT ENOUGH OIL.	OIL ALL MOVING PARTS.	
7. DEFORMATION PATTERN	1. INAPPROPRIATE ZIGZAG SYNCHRONIZATION.	SEE MECHANICAL ADJUSTMENT "NEEDLE SWING".	P.10
	2. INAPPROPRIATE DISENGAGEMENT OF CAM FOLLOWER.	SEE MECHANICAL ADJUSTMENT "DISENGAGEMENT OF CAM FOLLOWER".	P.20-23
	3. UPPER THREAD TENSION IS TOO STRONG.	ADJUST UPPER THREAD TENSION CORRECTLY.	P.7
	4. INAPPROPRIATE FEED BALANCE.	SEE MECHANICAL ADJUSTMENT "FEED BALANCE ON STRETCH STITCH".	P.17

SERVICE ACCESS

FACE PLATE

TO REMOVE

1. REMOVE THE FACE PLATE BY REMOVING THE CAP AND SET SCREW.

TO ATTACH

2. MOUNT THE FACE PLATE BY THE SET SCREW, AND THEN, MOUNT THE CAP.

BELT COVER

TO REMOVE

1. LOOSEN THE SET SCREW, AND REMOVE THE BELT COVER BY REMOVING THE BELT COVER RIB FROM THE FRONT COVER.

TO ATTACH

2. MOUNT THE BELT COVER RIB TO THE FRONT COVER, AND THEN, MOUNT THE BELT COVER BY THE SET SCREW.

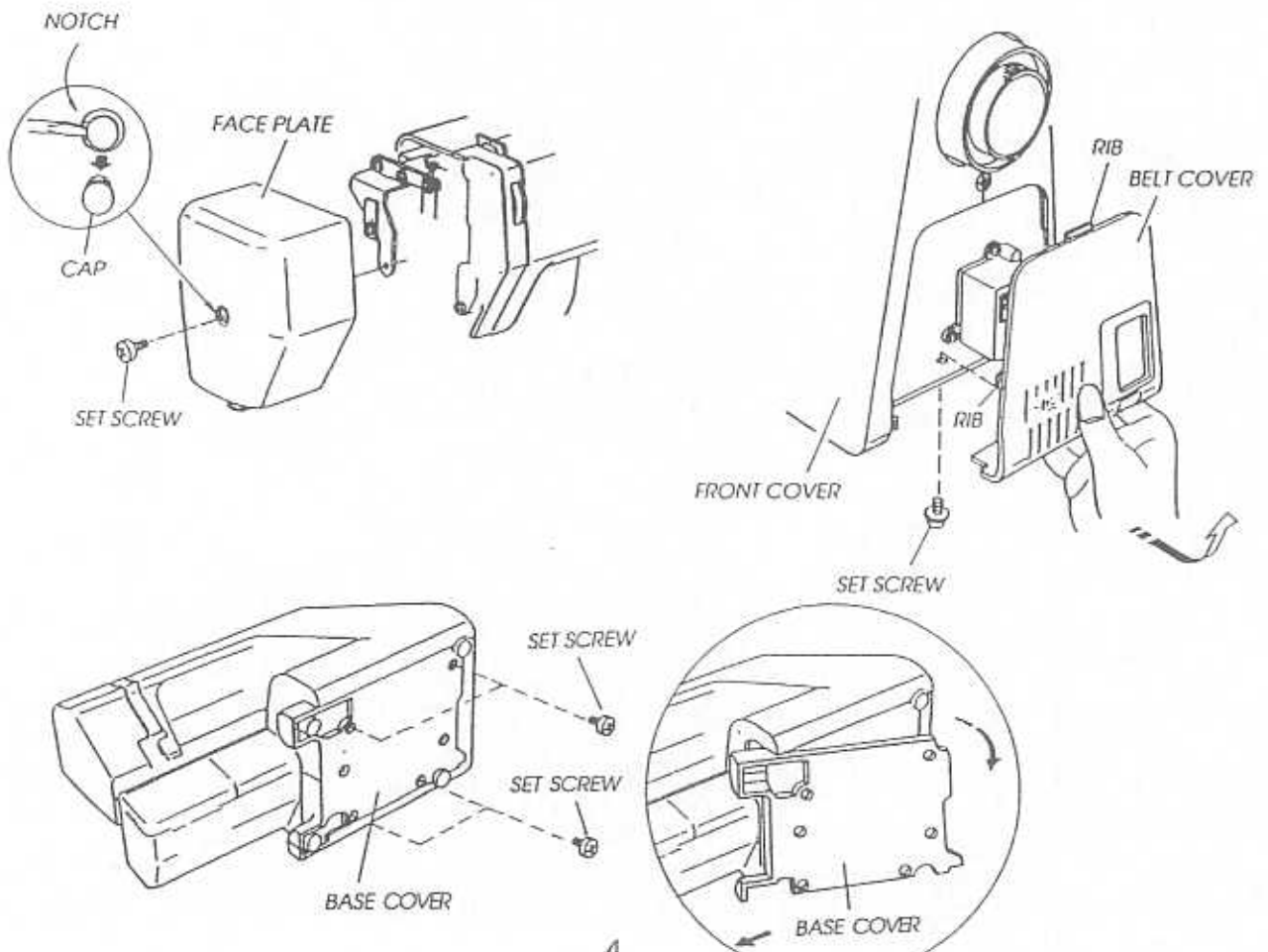
BASE COVER

TO REMOVE

1. REMOVE THE BASE COVER BY FOUR SET SCREWS.

TO ATTACH

2. MOUNT THE BASE COVER BY FOUR SET SCREWS.



SERVICE ACCESS

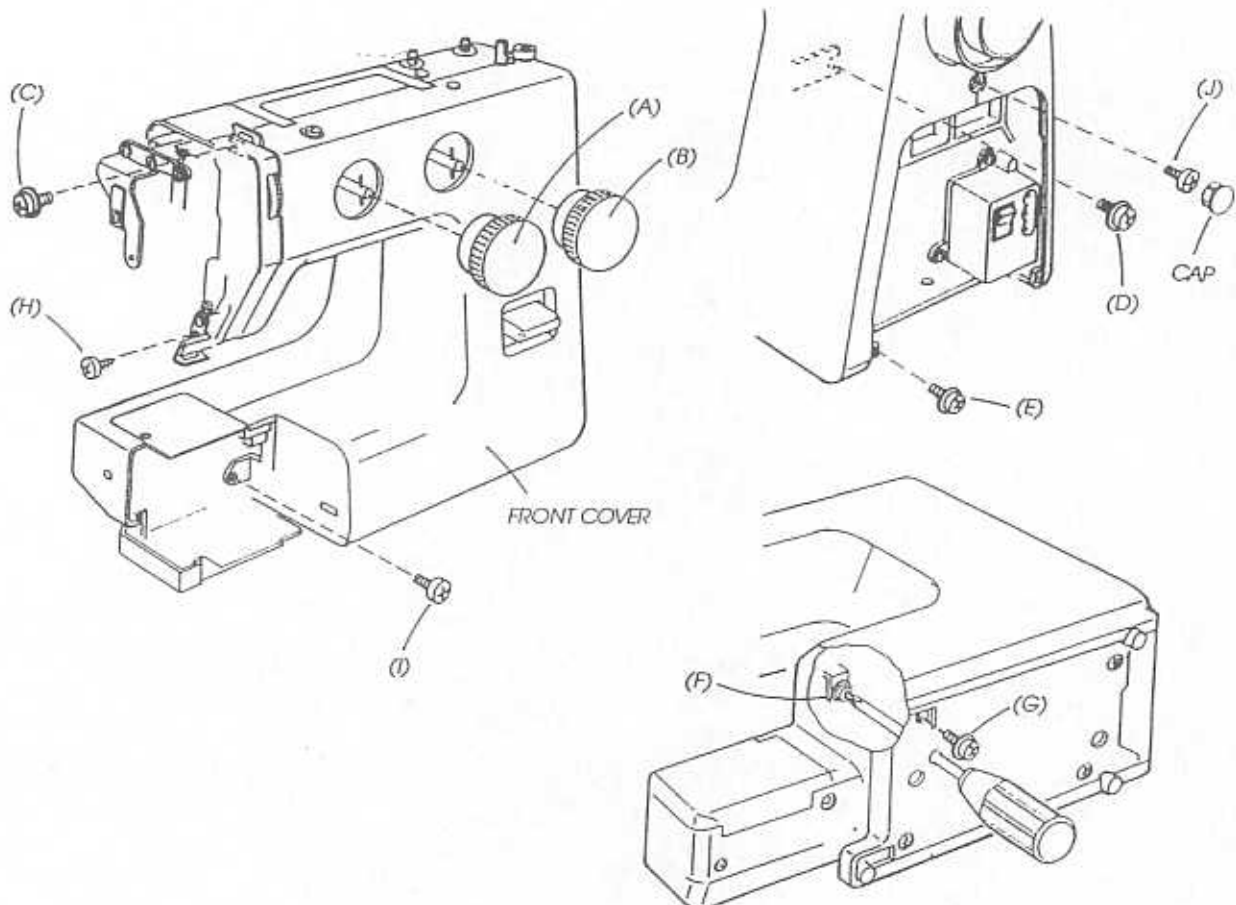
FRONT COVER

TO REMOVE

1. REMOVE THE FACE PLATE AND BELT COVER. (SEE PAGE 4.)
2. REMOVE SELECTOR DIALS (A) AND (B).
NOTE: NUMBER OF SELECTOR DIALS IS AS FOLLOWS:
MODEL JF 1022 } 3 DIALS
JF 1018 }
MODEL JF 1018S } 2 DIALS
JF 1014 }
JF 1012 }
MODEL JF 1004 1 DIAL
3. LOOSEN SET SCREWS (C), (D), (E), (F), (G), AND THEN, REMOVE THE FRONT COVER BY REMOVING SET SCREWS (H), (I), AND (J).

TO ATTACH

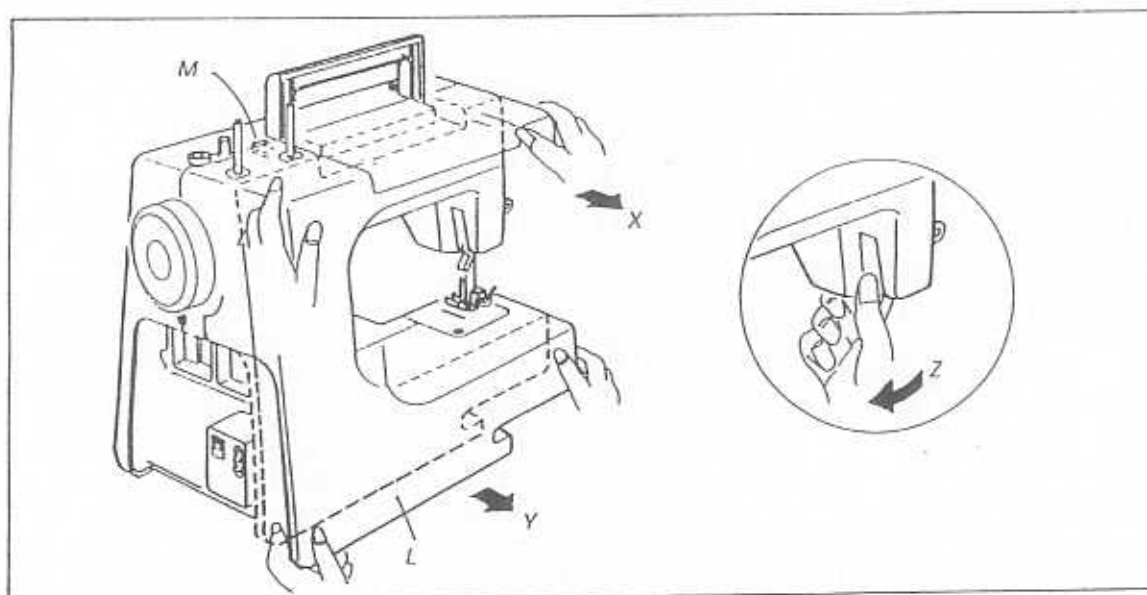
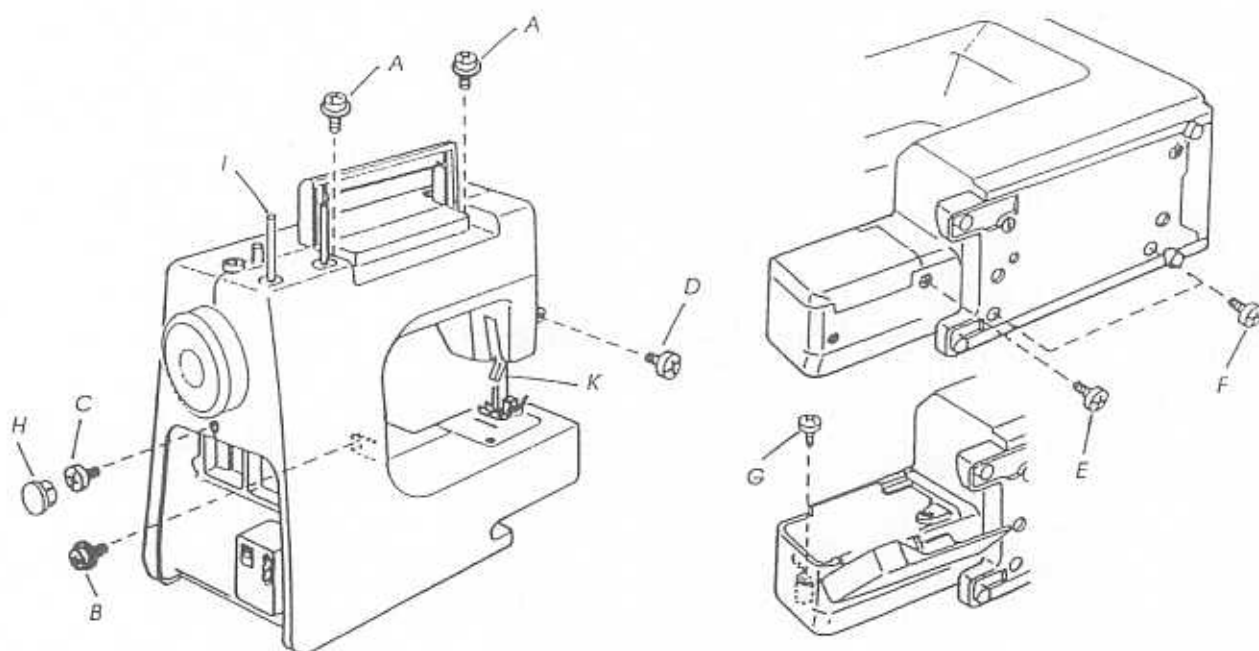
4. MOUNT THE FRONT COVER IN REVERSE PROCEDURE OF THE REMOVING.



REAR COVER

NOTE: REAR COVER COULD BE REMOVED WITHOUT REMOVING FIRST FRONT COVER.
TO REMOVE

1. REMOVE THE BELT COVER (SEE PAGE 4).
2. LOOSEN THE SET SCREWS A AND B AND REMOVE THE CAP H.
3. REMOVE THE SET SCREWS C, D, E, F AND G.
4. PULL UP THE 2 SPOOL PINS I AND J AND LOWER THE PRESSER FOOT LIFTER K.
5. WHILE PUSHING THE REAR COVER L NEAR THE NOTCHES L AND M, PULL UPPER PART OF THE REAR COVER (SEE X BELOW).
6. PULL LOWER PART OF THE REAR COVER TOWARD YOU AND SLIDE IT TO THE LEFT (SEE Y AND Z BELOW).
WHILE SLIDING THE REAR COVER TO THE LEFT, REMOVE THE PRESSER BAR LIFTER K.



MECHANICAL ADJUSTMENT

UPPER THREAD TENSION DIAL

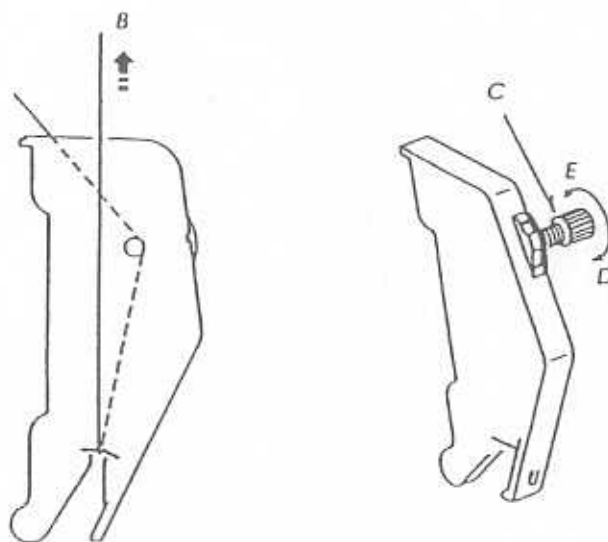
CORRECT SETTING

THE STANDARD UPPER THREAD TENSION SHOULD BE 65 - 95g WHEN PULLING THE THREAD (COTTON THREAD #50) IN THE DIRECTION OF B WITH SETTING THE TENSION DIAL AT "3". (MAKE SURE THE FOOT SHOULD BE LOWERED.)

IF THE TENSION IS OUT OF THE STANDARD RANGE, ADJUST IT AS FOLLOWS:

TO ADJUST

1. REMOVE THE FRONT PANEL COVER UNIT. (SEE PAGE 5.)
2. TURN THE ADJUSTING NUT C IN THE DIRECTION OF D WHEN THE UPPER THREAD TENSION IS TOO TIGHT.
TURN THE ADJUSTING NUT C IN THE DIRECTION OF E WHEN THE UPPER THREAD TENSION IS TOO LOOSE.
3. ATTACH THE FRONT PANEL COVER UNIT.



MECHANICAL ADJUSTMENT

BOBBIN THREAD TENSION

CORRECT SETTING

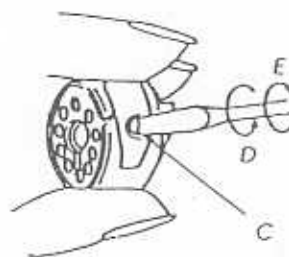
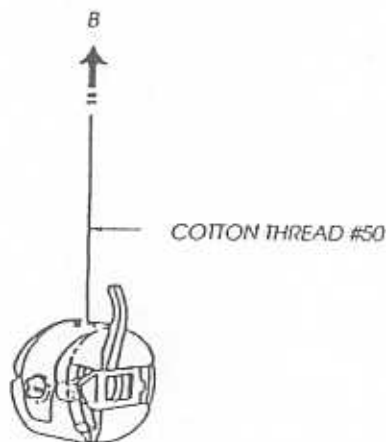
SET THE BOBBIN IN THE BOBBIN CASE AND PASS THE THREAD (COTTON #50) THROUGH THE TENSION SPRING.

THE BOBBIN THREAD TENSION SHOULD BE 45 - 55g WHEN PULLING THE THREAD IN THE DIRECTION OF B.

IF THE TENSION IS OUT OF THE RANGE, ADJUST IT AS FOLLOWS:

TO ADJUST

1. TURN THE ADJUSTING SCREW C IN THE DIRECTION OF D WHEN THE BOBBIN THREAD TENSION IS TOO TIGHT.
2. TURN THE ADJUSTING SCREW C IN THE DIRECTION OF E WHEN THE BOBBIN THREAD TENSION IS TOO LOOSE.



MECHANICAL ADJUSTMENT

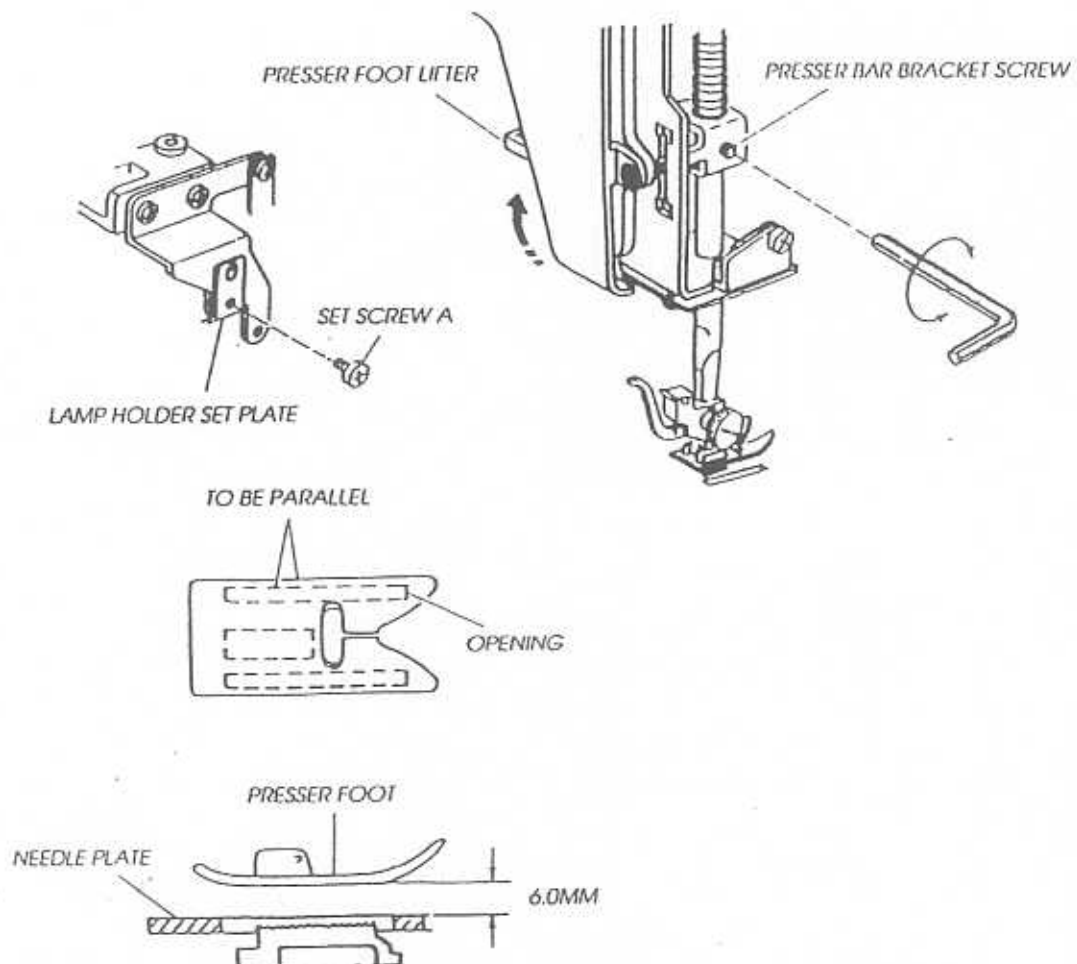
PRESSER BAR HEIGHT AND ALIGNMENT

CORRECT SETTING

THE STANDARD PRESSER BAR HEIGHT IS 6.0MM BETWEEN THE BOTTOM SURFACE OF THE FOOT AND NEEDLE PLATE WHEN PRESSER FOOT LIFTER IS UP POSITION.

TO ADJUST

1. REMOVE THE FACE PLATE. (SEE PAGE 4.)
2. REMOVE SET SCREW A AND REMOVE LAMP HOLDER SET PLATE.
3. RAISE THE PRESSER FOOT AND LOOSE THE PRESSER BAR BRACKET SCREW AND ADJUST THE HEIGHT (6.0MM).
4. CHECK IF THE PRESSER FOOT IS PARALLEL TO THE OPENINGS FOR THE FEED DOG ON THE NEEDLE PLATE. IF NOT , ADJUST IT.
5. TIGHTEN THE PRESSER BAR BRACKET SCREW WHILE HOLDING THE PRESSER BAR TO KEEP THE FOOT PARALLEL TO THE OPENINGS.
6. ATTACH THE LAMP HOLDER SET PLATE.
7. ATTACH THE FACE PLATE.



MECHANICAL ADJUSTMENT

NEEDLE SWING

CORRECT SETTING

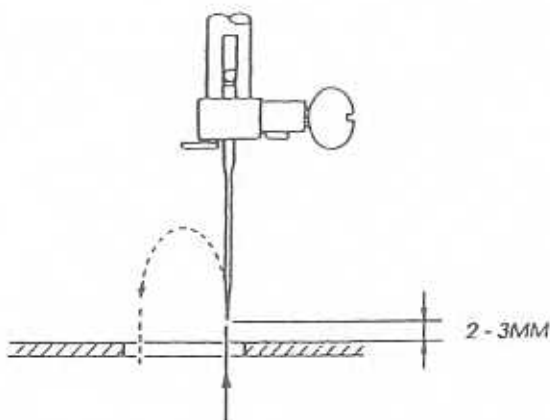
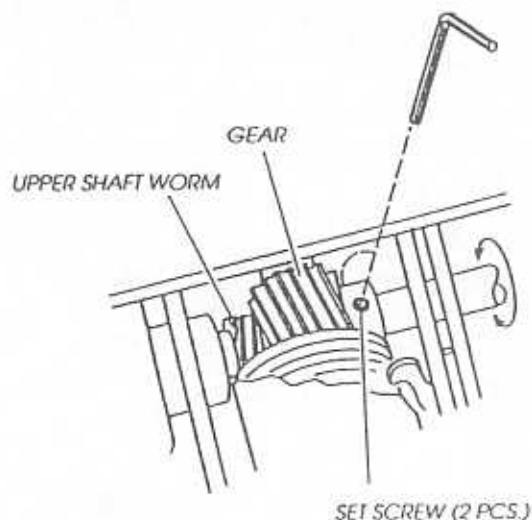
IF THE TIMING OF NEEDLE SWING IS NOT CORRECTLY ADJUSTED, THE NEEDLE WILL MOVE SIDEWISE WHILE IT IS IN THE FABRIC.

IDEALLY THE NEEDLE SHOULD START SWING FROM A POSITION 2 - 3 MM ABOVE THE NEEDLE PLATE IN ITS RIGHT OUTFLOW. (WITH MAXIMUM ZIGZAG WIDTH)

TO ADJUST

1. SET THE PATTERN SELECTOR DIAL WITH MAXIMUM ZIGZAG WIDTH, AND REMOVE THE FRONT COVER. (SEE PAGE 5.)
2. LOOSEN TWO SET SCREWS.
3. ADJUST THE NEEDLE SWING BY TURNING THE BALANCE WHEEL, WHILE PRESSING THE WORM SO AS NOT TO ROTATE IT, UNTIL THE NEEDLE SWING STARTS AT 2 - 3MM ON THE NEEDLE PLATE AFTER THE NEEDLE HAS COME OUT OF THE RIGHT SIDE OF THE NEEDLE HOLE.
4. TIGHTEN TWO SET SCREWS.
5. MOUNT THE FRONT COVER.

NOTE: AFTER ADJUSTING THE NEEDLE SWING, CHECK THAT THE UPPER SHAFT WORM AND GEAR ROTATE SMOOTHLY WITHOUT ANY BACKLASH BETWEEN THEM.



MECHANICAL ADJUSTMENT

NEEDLE DROP

CORRECT SETTING

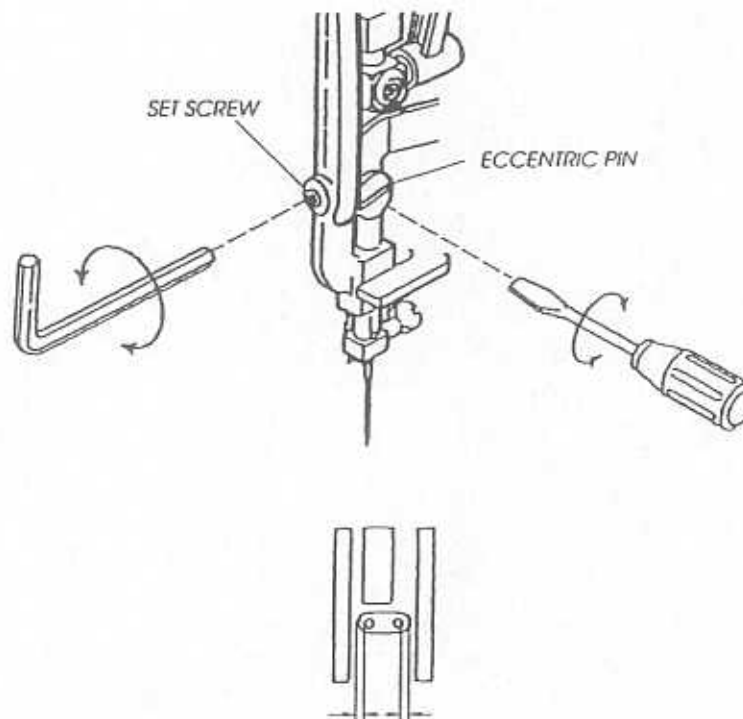
WHEN THE NEEDLE SWINGS IN MAXIMUM ZIGZAG WIDTH, THE DISTANCE BETWEEN THE BOTH ENDS OF NEEDLE HOLE ON THE NEEDLE PLATE AND THE NEEDLE DROP POSITIONS SHOULD BE EQUAL.

IF NOT, MAKE AN ADJUSTMENT AS FOLLOWS:

TO ADJUST

1. REMOVE THE FACE PLATE. (SEE PAGE 4.)
2. SET THE PATTERN SELECTOR DIAL AT MAXIMUM ZIGZAG WIDTH.
3. LOOSEN THE SET SCREW.
4. TURN THE ECCENTRIC PIN TO ADJUST THE NEEDLE DROP POSITION.
5. TIGHTEN THE SET SCREW.
6. ATTACH THE FACE PLATE.

NOTE: CHECK THE HOOK TIMING AFTER THIS ADJUSTMENT.



BOTH CLEARANCE SHOULD BE EQUAL.

MECHANICAL ADJUSTMENT

HEIGHT OF FEED DOG

CORRECT SETTING

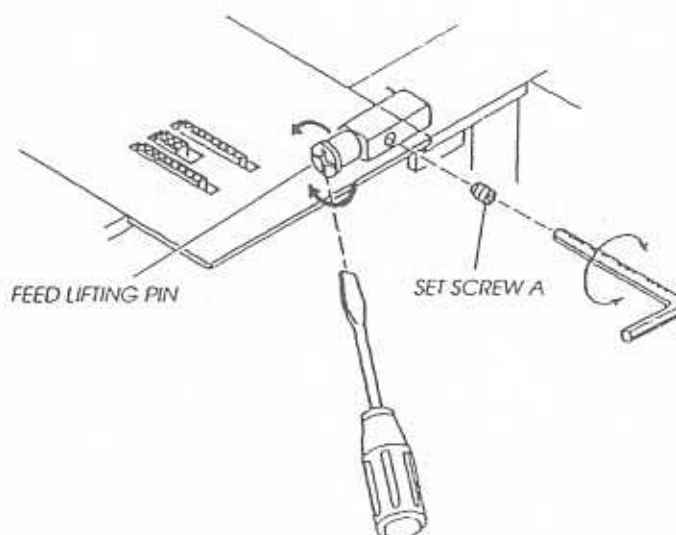
LOWER THE PRESSER FOOT AND TURN THE BALANCE WHEEL TOWARD YOU UNTIL THE NEEDLE BAR COMES TO THE HIGHEST POINT OF ITS TRAVEL.

IN THIS CONDITION, THE HEIGHT OF THE FEED DOG ABOVE THE NEEDLE PLATE SHOULD BE 0.75 - 0.90MM.

IF IT IS NOT IN THE RANGE, MAKE AN ADJUSTMENT AS FOLLOWS:

TO ADJUST

1. SET THE STITCH LENGTH DIAL AT (4). (PATTERN SELECT DIAL AT ANY POSITION.)
2. LOWER THE PRESSER FOOT AND TURN THE BALANCE WHEEL UNTIL THE FEED DOG COMES TO ITS HIGHEST POINT.
3. LOOSEN THE SET SCREW A.
4. TURN THE FEED LIFTING PIN TO ADJUST THE HEIGHT OF FEED DOG (0.75 - 0.90MM).
5. TIGHTEN THE SET SCREW A.
6. TURN THE BALANCE WHEEL TO RECHECK THE HEIGHT OF FEED DOG.
 - * RAISE NEEDLE TO ITS HIGHEST POSITION.
 - * MODEL JD1804 IS NOT EQUIPPED WITH ANY STITCH LENGTH DIAL.



MECHANICAL ADJUSTMENT

CLEARANCE BETWEEN NEEDLE AND HOOK (NO.1)

CORRECT SETTING

THE CLEARANCE BETWEEN NEEDLE AND SHUTTLE RACE SHOULD BE 0 - 0.15MM.

IF NOT, MAKE AN ADJUSTMENT AS FOLLOWS:

TO ADJUST

1. REMOVE THE FACE PLATE. (SEE PAGE 4.)
2. SET THE PATTERN SELECTOR DIAL AT "B". (STITCH LENGTH DIAL AT ANY POSITION.)
NOTE: FOR MODEL JF1004...SET THE PATTERN SELECTOR DIAL AT "E".

FOR MODELS JF 1022 AND JF1018...SET THE PATTERN SELECTOR DIAL AT "A".
SET THE WIDTH SELECTOR DIAL AT "0".

3. LOOSEN SET SCREW A, AND MOVE THE NEEDLE BAR SUPPORTER TO ARROWS TO GET CLEARANCE BETWEEN 0 TO 0.15MM.

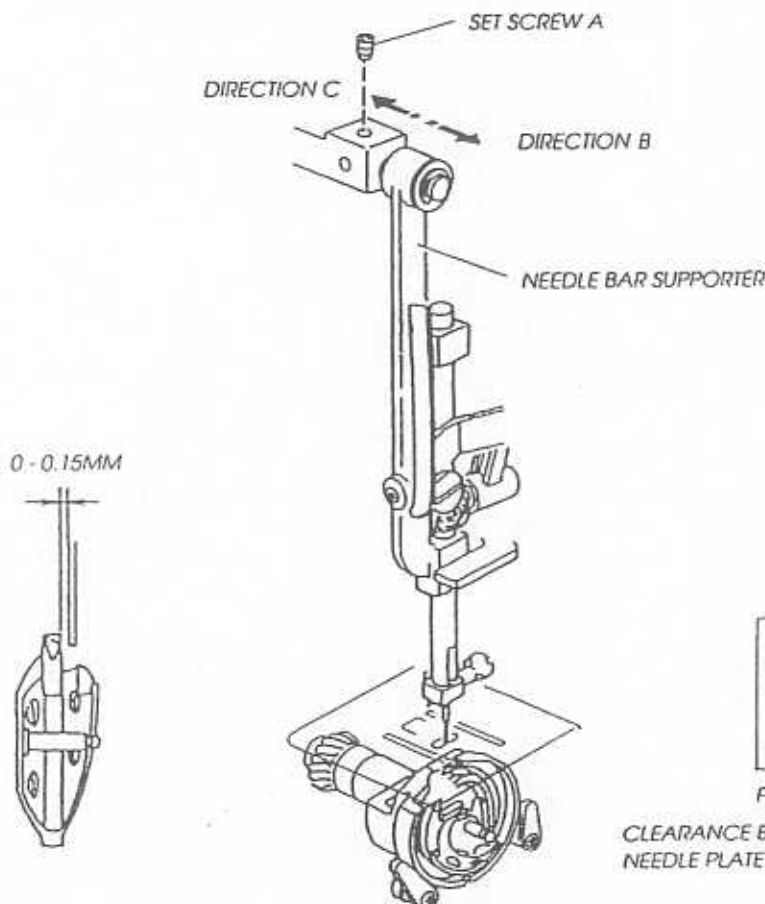
* WHEN CLEARANCE IS TOO WIDE, MOVE THE NEEDLE BAR SUPPORTER TO DIRECTION B.

* WHEN CLEARANCE IS TOO NARROW, MOVE THE NEEDLE BAR SUPPORTER TO DIRECTION C.

NOTE: AFTER THIS ADJUSTMENT, CHECK IF THE CLEARANCE BETWEEN NEEDLE AND NEEDLE PLATE IS MORE THAN 0.15MM AS SHOWN IN FIGURE D.

IF NOT, ADJUST THE CLEARANCE BETWEEN NEEDLE AND SHUTTLE RACE BY USING METHOD OF ADJUSTMENT NO.2 IN PAGE 13 AFTER READJUST THE CLEARANCE BETWEEN NEEDLE AND NEEDLE PLATE MORE THAN 0.15MM.

4. ATTACH THE FACE PLATE.



MECHANICAL ADJUSTMENT

CLEARANCE BETWEEN NEEDLE AND HOOK (NO.2)

CORRECT SETTING

USE THIS ADJUSTMENT NO.2 WHEN ADJUSTMENT NO.1 CAN NOT BE USED.

THE CLEARANCE BETWEEN NEEDLE AND SHUTTLE RACE SHOULD BE 0 - 0.15mm.

TO ADJUST

1. SET THE PATTERN SELECTOR DIAL AT "B". (STITCH LENGTH DIAL AT ANY POSITION.)
2. NOTE: FOR MODEL JF1004...SET THE PATTERN SELECTOR DIAL AT "E".

FOR MODELS JF 1022 AND JF1018...SET THE PATTERN SELECTOR DIAL AT "A".
SET THE WIDTH SELECTOR DIAL AT "0".

3. LOOSEN THE SCREW A ON LOWER SHAFT BUSHING AND SLIDE THE GEAR ABOUT 0.5MM TO THE RIGHT TO MAKE A SLACK BETWEEN GEARS.
4. LOWER THE NEEDLE AND LOOSEN THE TWO SHUTTLE RACE SET SCREWS B.
MOVE THE SHUTTLE RACE UNIT AXIALLY EITHER FORWARD OR BACKWARD TO ADJUST THE CLEARANCE BETWEEN THE NEEDLE AND THE SHUTTLE RACE IN THE RANGE OF 0 - 0.15MM.
5. SET THE PATTERN SELECT DIAL AT "C", TURN THE BALANCE WHEEL TO CHECK IF THE CLEARANCE BETWEEN THE NEEDLE AND INNER EDGES OF THE SHUTTLE RACE SPRING AT THE LEFT AND RIGHT NEEDLE DROPS ARE EQUAL.

IF NOT, MAKE AN ADJUSTMENT BY TURNING THE SHUTTLE RACE UNIT.

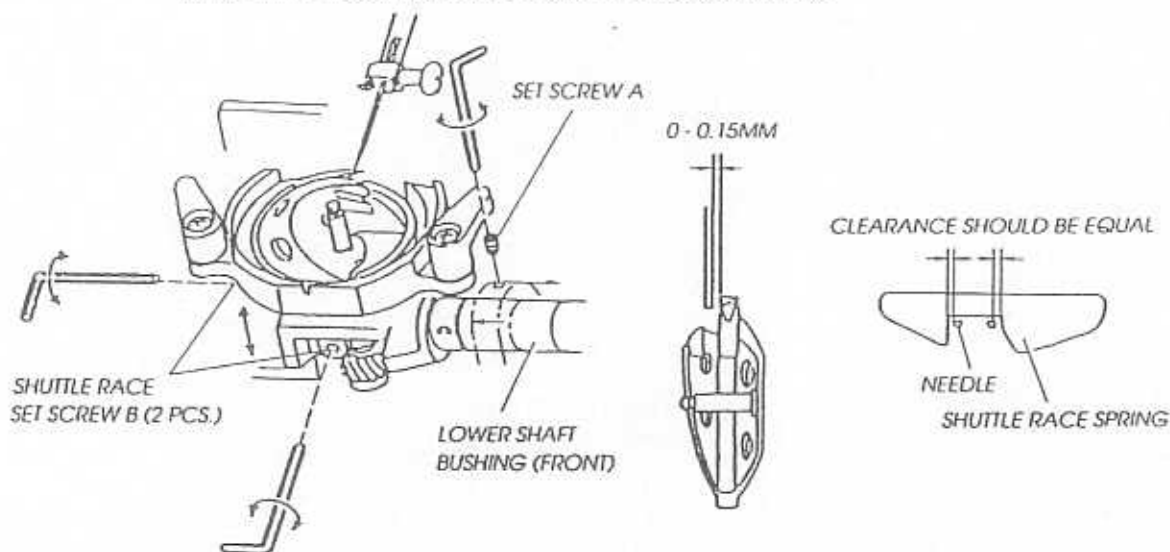
NOTE: FOR MODEL JF1004...SET THE PATTERN SELECTOR DIAL AT "H".

FOR MODELS JF 1022 AND JF1018...SET THE PATTERN SELECTOR DIAL AT "C".
SET THE WIDTH SELECTOR DIAL AT "5".

6. TIGHTEN THE TWO SHUTTLE RACE SET SCREWS B.
7. LOOSEN THE SET SCREW ON LOWER SHAFT BUSHING AND SLIDE THE GEAR BACK TO THE ORIGINAL POSITION WHILE ADJUSTING THE BACKLASH.
8. TIGHTEN THE SCREWS A FIRMLY.
9. ATTACH THE REAR COVER.

NOTE: THE BACKLASH PLAY SHOULD BE LESS THAN 0.3MM AND LOWER SHAFT TURNS SMOOTHLY.

AFTER THE ADJUSTMENT, CHECK THE HOOK TIMING.



MECHANICAL ADJUSTMENT

NEEDLE BAR HEIGHT

CORRECT SETTING

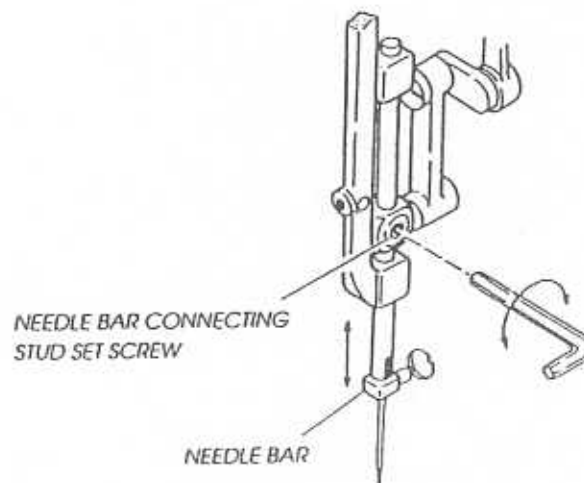
THE STANDARD DISTANCE BETWEEN THE UPPER EDGE OF NEEDLE EYE AND THE TIP OF SHUTTLE HOOK SHOULD BE IN THE RANGE OF 2.9 - 3.5MM WHEN THE TIP OF SHUTTLE HOOK MEETS THE LEFT SIDE OF THE NEEDLE IN ASCENDING TRAVEL OF NEEDLE FROM ITS LEFT AND LOWEST POSITION.

TO ADJUST

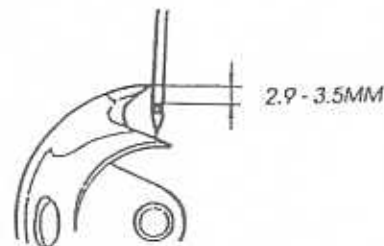
1. REMOVE THE FACE PLATE. (SEE PAGE 4.)
2. SET THE PATTERN SELECTOR DIAL AT "B". (STITCH LENGTH DIAL AT ANY POSITION.)
NOTE: FOR MODEL JF1004...SET THE PATTERN SELECTOR DIAL AT "E".

FOR MODELS JF 1022 AND JF1018...SET THE PATTERN SELECTOR DIAL AT "A".
SET THE WIDTH SELECTOR DIAL AT "0".

3. REMOVE THE SHUTTLE RACE RING.
4. TURN THE BALANCE WHEEL TOWARD YOU UNTIL TIP OF SHUTTLE HOOK MEETS THE LEFT SIDE OF THE NEEDLE.
5. LOOSEN THE NEEDLE BAR CONNECTING STUD SET SCREW.
6. ADJUST THE HEIGHT OF THE NEEDLE BAR BY MOVING THE NEEDLE BAR UPWARD OR DOWNWARD WITHOUT TURNING IT.
7. TIGHTEN THE SET SCREW.
8. ATTACH THE SHUTTLE RACE RING.
9. ATTACH THE FACE PLATE.



TIP OF SHUTTLE HOOK MEETS LEFT SIDE OF NEEDLE.



MECHANICAL ADJUSTMENT


HOOK TIMING

CORRECT SETTING

THE STANDARD HEIGHT OF NEEDLE POINT FROM ITS LOWEST POINT OF TRAVEL SHOULD BE IN THE RANGE OF 1.45 - 1.95MM WHEN THE TIP OF SHUTTLE HOOK MEETS EXACTLY THE LEFT SIDE OF NEEDLE AT LEFT NEEDLE POSITION.

TO ADJUST

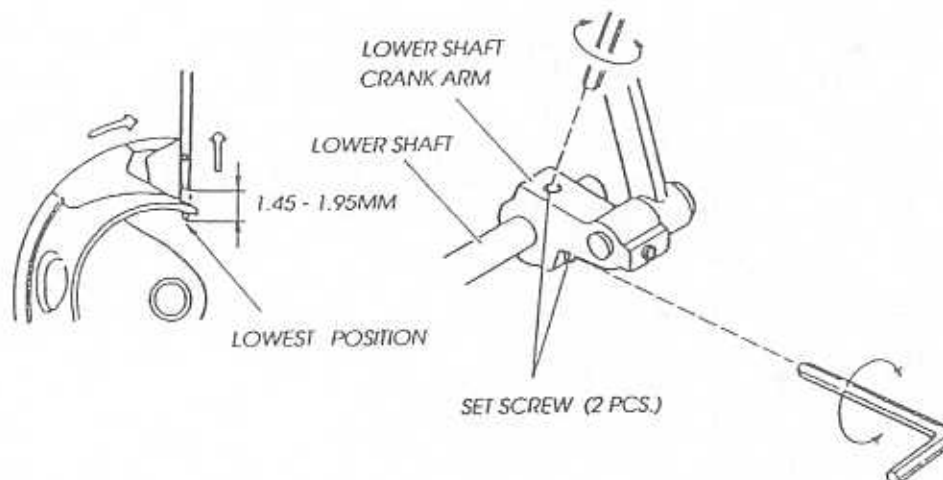
1. SET THE PATTERN SELECTOR DIAL AT " B ".

NOTE: FOR MODEL JF1004...SET THE PATTERN SELECTOR DIAL AT "  ".

FOR MODELS JF 1022 AND JF1018...SET THE PATTERN SELECTOR DIAL AT " A ".

SET THE WIDTH SELECTOR DIAL AT "  ".

2. REMOVE THE FRONT PANEL COVER UNIT.
3. REMOVE THE MOTOR.
4. REMOVE THE SHUTTLE RACE RING.
5. TURN THE BALANCE WHEEL TOWARD YOU UNTIL THE TIP OF SHUTTLE HOOK MEETS THE LEFT SIDE OF NEEDLE.
6. LOOSEN THE LOWER SHAFT CRANK ARM SET SCREWS (2 PCS.).
7. WHILE HOLDING THE SHUTTLE HOOK NOT TO TURN, TURN THE BALANCE WHEEL TOWARD YOU UNTIL THE NEEDLE COMES TO ITS LOWEST POSITION.
THEN, FURTHER TURN THE BALANCE WHEEL TO RAISE THE NEEDLE ABOUT 1.7MM FROM ITS LOWEST POSITION.
8. TIGHTEN THE SET SCREWS.
9. TURN THE BALANCE WHEEL TOWARD YOU TO CHECK IF THE HEIGHT IS THE RANGE OF 1.45 - 1.95MM.
IF IT IS NOT IN THE RANGE, REPEAT THE ABOVE PROCEDURE.
10. ATTACH THE SHUTTLE RACE RING.
11. ATTACH THE MOTOR AND ADJUST THE BELT TENSION.
12. ATTACH THE FRONT PANEL COVER UNIT.



MECHANICAL ADJUSTMENT

(FOR MODELS JF1022, JF1018S, JF1018, JF1014 AND JF1012)

FEED BALANCE ON STRETCH STITCH

CORRECT SETTING

IF THE STRETCH STITCH PATTERNS ARE DISTORTED WITH SETTING THE STITCH LENGTH DIAL AT "SS".

(IN CASE OF BEING A DIFFERENCE BETWEEN FORWARD FEEDING AND BACKWARD FEEDING DURING STRETCH STITCH PATTERNS), MAKE AN ADJUSTMENT AS FOLLOWS:

TO ADJUST

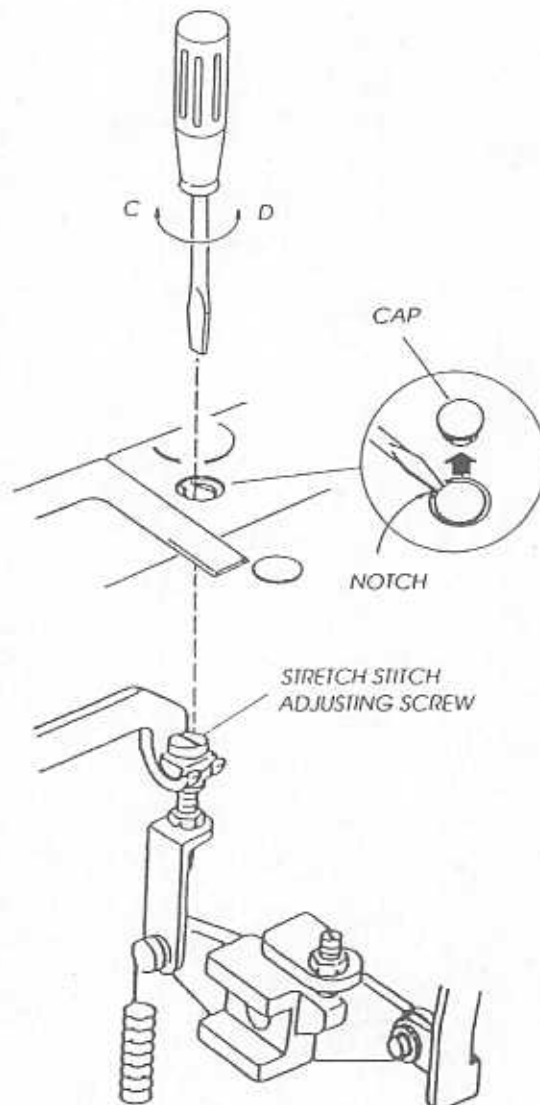
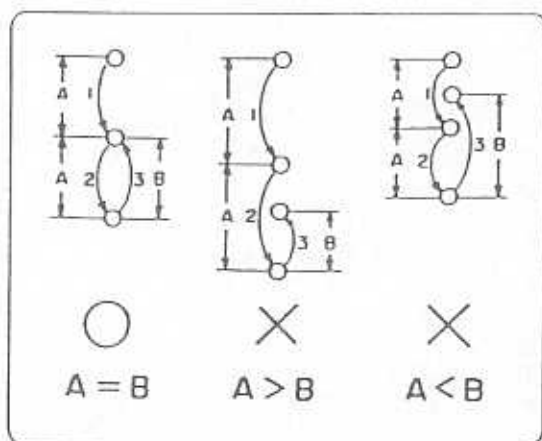
1. REMOVE THE CAP.
2. SET THE PATTERN SELECTOR DIAL AT "A", AND THE STITCH LENGTH DIAL AT "SS".

FOR MODELS JF1022 AND JF1018....SET THE PATTERN SELECTOR DIAL AT "A".

SET THE STITCH WIDTH SELECTOR DIAL AT "5".

SET THE STITCH LENGTH SELECTOR DIAL AT "SS".

3. TURN THE STRETCH STITCH ADJUSTING SCREW IN THE DIRECTION OF C WHEN $A > B$, OR IN THE DIRECTION OF D WHEN $A < B$.
4. MOUNT THE CAP.



MECHANICAL ADJUSTMENT

(FOR MODELS JF1022, JF1018S, JF1018 AND JF1014 – JF1004)

BUTTONHOLE FEED BALANCE

CORRECT SETTING

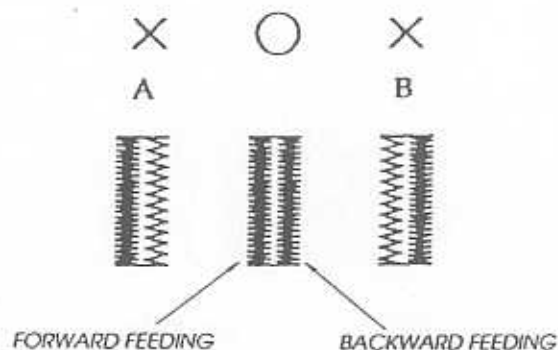
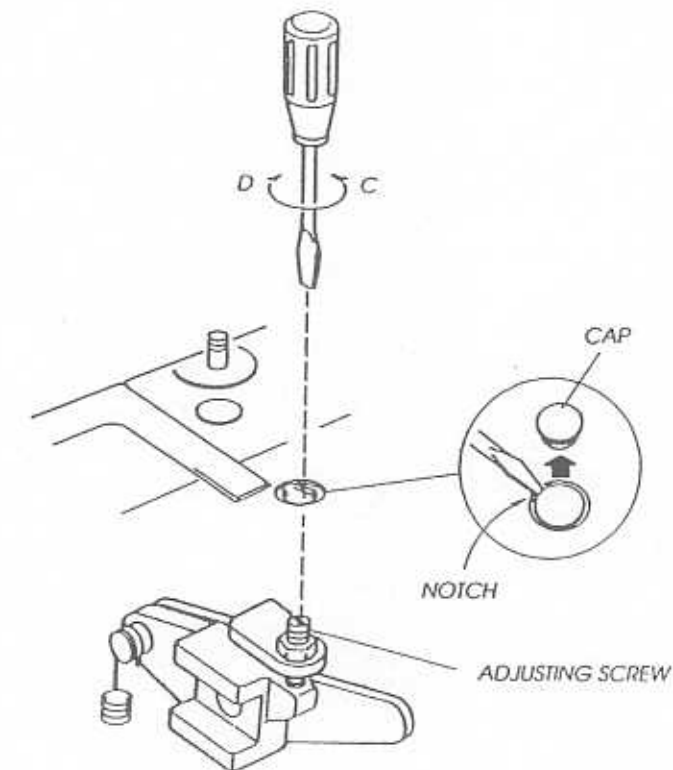
WHEN SEWING BUTTONHOLE, THE STITCHES ON EACH SIDE OF BUTTONHOLE SHOULD BE THE SAME STITCH DENSITY.

THE RANGE OF 9-11 STITCHES IN THE RIGHT SIDE ROW "BACKWARD FEEDING" AGAINST 10 STITCHES IN THE LEFT SIDE ROW "FORWARD FEEDING" IS CONSIDERED ACCEPTABLE.

TO ADJUST

1. CONFIRM THE STITCHES BY SEWING BUTTONHOLES, AND REMOVE THE CAP.
2. TURN THE ADJUSTING SCREW IN THE DIRECTION OF C IN CASE OF A (RIGHT STITCHES ARE ROUGH), OR IN THE DIRECTION OF D IN CASE OF B (LEFT STITCHES ARE ROUGH).
3. MOUNT THE CAP.

* IN CASE OF MODEL JD1818 HAVING ONE STEP BUTTONHOLE FUNCTION, THE "FORWARD FEEDING" AND "BACKWARD FEEDING" ARE REVERSED.



MECHANICAL ADJUSTMENT



(FOR MODELS JF1022, JF1018S, JF1018, AND JF1014 - JF1004)

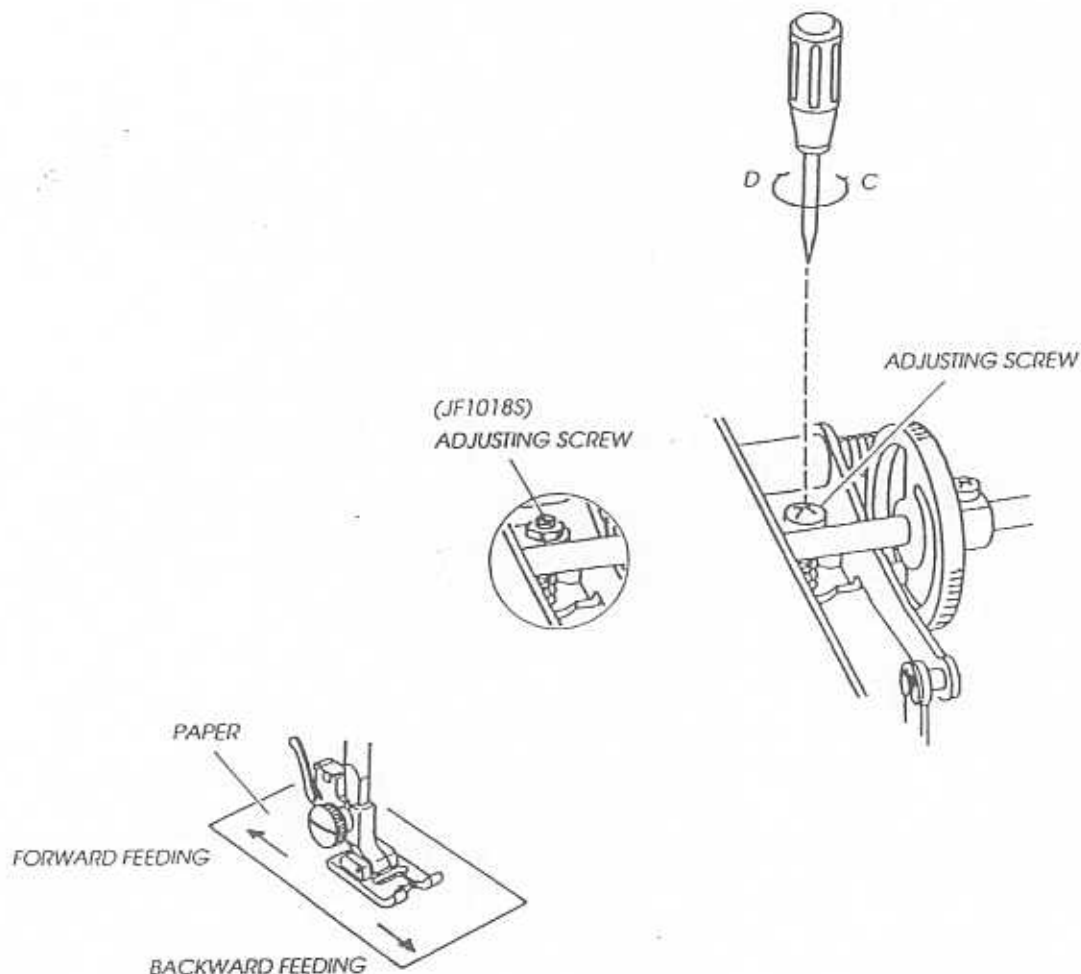
BARTACK FEED OF BUTTONHOLE

CORRECT SETTING

IF THE MATERIAL IS FED FORWARD OR BACKWARD WHEN SEWING BARTACK ON BUTTONHOLE, MAKE AN ADJUSTMENT AS FOLLOWS:

TO ADJUST

1. SET THE PATTERN SELECTOR DIAL AT " 2  4 " AND THE STITCH LENGTH DIAL AT " 4 ".
(SET THE PATTERN SELECTOR DIAL AT "  " IN CASE OF JF1018S)
 2. REMOVE THE FRONT COVER. (SEE PAGE 5.)
 3. PLACE A PIECE OF PAPER UNDER THE FOOT AND TURN THE BALANCE WHEEL.
IF THE PAPER IS FED FORWARD, TURN THE ADJUSTING SCREW IN THE DIRECTION OF C.
IF THE PAPER IS FED BACKWARD, TURN THE ADJUSTING SCREW IN THE DIRECTION OF D.
 4. MOUNT THE FRONT COVER.
- * IN CASE OF MODEL JF 1018S HAVING ONE STEP BUTTONHOLE FUNCTION, THE ADJUSTING SCREW AND PRESSER FOOT ARE DIFFERENT FROM THOSE DESCRIBED ABOVE.



MECHANICAL ADJUSTMENT

(FOR MODELS JF 1018 AND JF 1022)

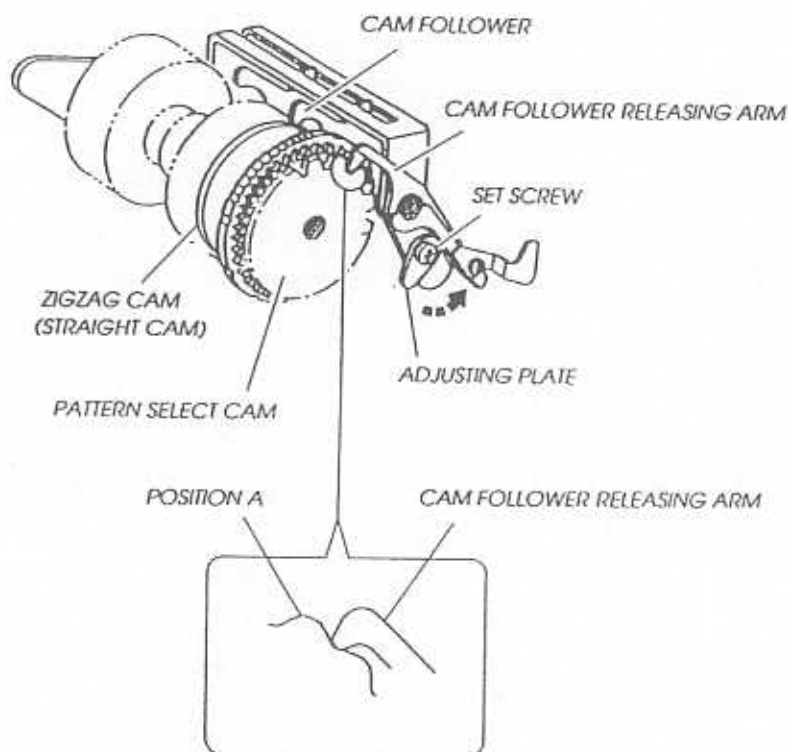
DISENGAGEMENT OF CAM FOLLOWER (NO.1)

CORRECT SETTING

TOO NARROW CLEARANCE BETWEEN THE CAM FOLLOWER AND THE TOP CONVEX OF ZIGZAG CAM MAY OFTEN CAUSE DIFFICULTY IN TURNING THE PATTERN SELECTOR DIAL OR CAN NOT SELECT CORRECT PATTERN.

TO ADJUST

1. SET THE PATTERN SELECTOR DIAL AT " A " AND THE STITCH WIDTH DIAL AT " 5 " (THE STITCH LENGTH DIAL AT ANY POSITION.)
2. REMOVE THE FRONT COVER. (SEE PAGE 5.)
3. PUT THE CAM FOLLOWER TO THE ZIGZAG CAM (STRAIGHT CAM), AND ALSO PUT THE CAM FOLLOWER RELEASING ARM TO THE PATTERN SELECT CAM.
4. LOOSEN THE SET SCREW.
5. MOVE ADJUSTING PLATE IN THE DIRECTION OF ARROW UNTIL TO TOUCH TO THE RELEASING ARM AND TIGHTEN SET SCREW.
 - * AFTER ADJUSTMENT, CHECK THAT THE CLEARANCE BETWEEN THE ZIGZAG CAM AND THE CAM FOLLOWER IS ABOUT 0.3MM WHEN PUTTING THE CAM FOLLOWER RELEASING ARM ONTO POSITION (A) OF PATTERN SELECT CAM.
6. MOUNT THE FRONT COVER.
 - * CHECK THE ADJUSTMENT OF THE NEEDLE MOVEMENT FOR STRAIGHT STITCH.



MECHANICAL ADJUSTMENT

(FOR MODELS JF 1018 AND JF 1022)

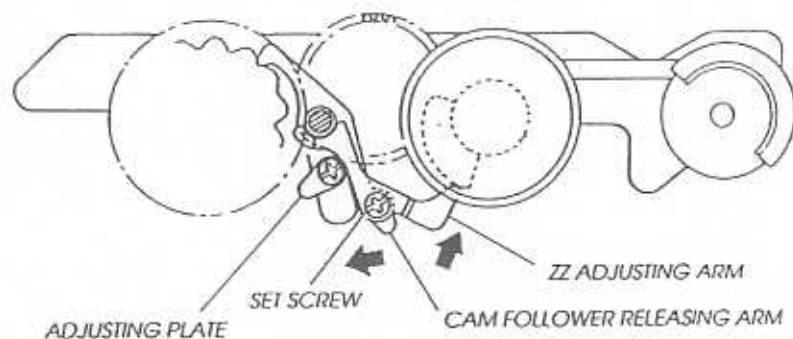
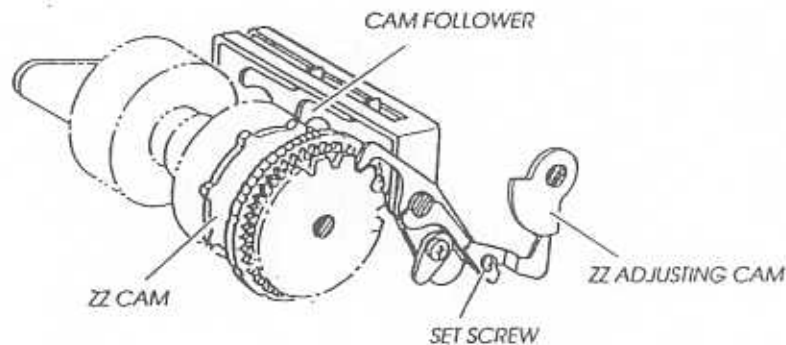
NEEDLE MOVEMENT FOR STRAIGHT STITCH

CORRECT SETTING

NEEDLE IS ZIGZAGING SLIGHTLY WHEN SELECT THE PATTERN SELECTOR DIAL AT " C " AND THE STITCH WIDTH DIAL AT " 0 ". ADJUSTMENT IS AS FOLLOWS:

TO ADJUST

1. SET THE PATTERN SELECTOR DIAL AT " C " AND THE STITCH WIDTH DIAL AT " 0 ".
2. REMOVE THE FRONT COVER. (SEE PAGE 5.)
3. LOOSEN THE SET SCREW.
4. TURN THE BALANCE WHEEL TO PUT THE CAM FOLLOWER ONTO THE TOP CONVEX OF THE ZIGZAG CAM (ZZ CAM) AND SET THE ZZ ADJUSTING ARM TO TOUCH THE ZZ ADJUSTING CAM. THEN, SET THE CAM FOLLOWER RELEASING ARM TO LIGHTLY TOUCH THE ADJUSTING PLATE, AND TIGHTEN THE SET SCREW.
* AFTER THIS ADJUSTMENT, CHECK IF NEEDLE IS NOT ZIGZAGING OR CLEARANCE BETWEEN NEEDLE AND NEEDLE PLATE HOLE IS MORE THAN 0.2MM AND NEEDLE POSITION IS CORRECT.
5. MOUNT THE FRONT COVER.



MECHANICAL ADJUSTMENT

(FOR MODELS JF1018S, JF1014 AND JF1012)

DISENGAGEMENT OF CAM FOLLOWER

CORRECT SETTING

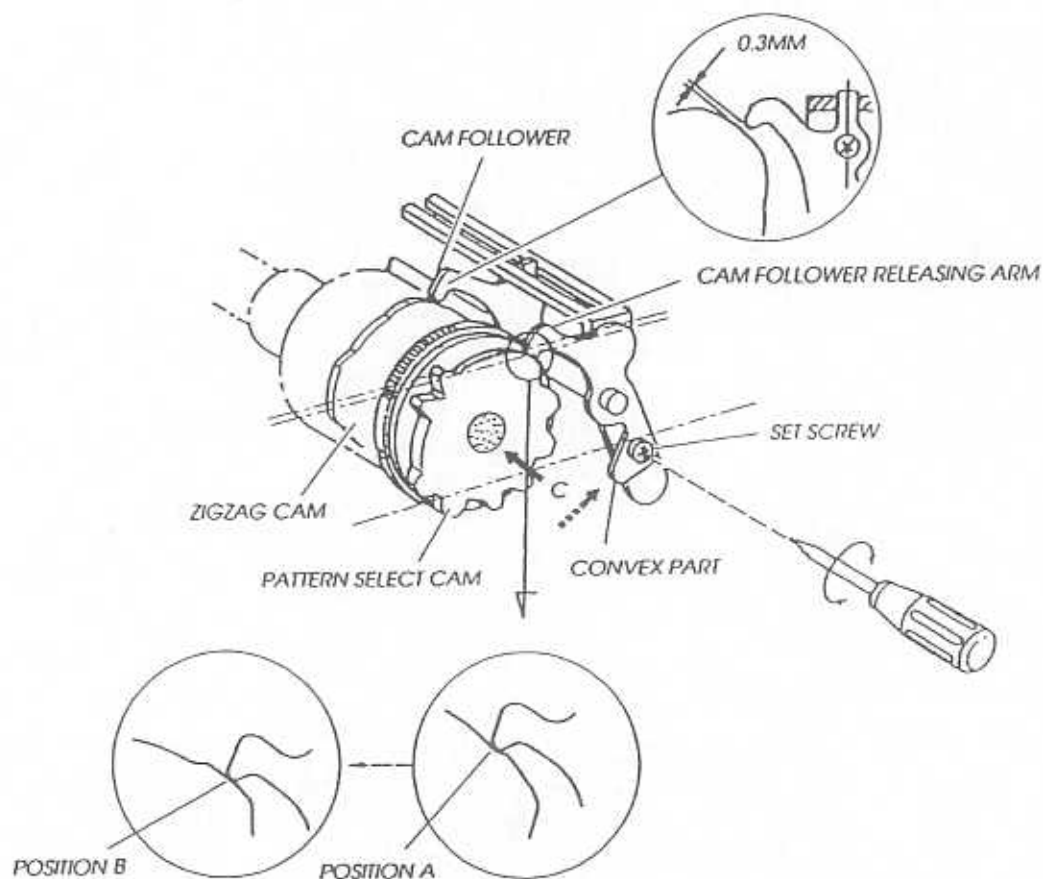
TOO NARROW CLEARANCE BETWEEN THE CAM FOLLOWER AND THE TOP CONVEX OF ZIGZAG CAM MAY OFTEN CAUSE DIFFICULTY IN TURNING OF THE PATTERN SELECTOR DIAL. CAN NOT SELECT CORRECT PATTERN OR ZIGZAGING IN STRAIGHT STITCH SETTING.

TO ADJUST

1. REMOVE THE FRONT COVER. (SEE PAGE 5.)
2. MOUNT THE PATTERN SELECTOR DIAL, AND SET IT AT PATTERN " B ". (5TH CAM AS VIEWED FROM C.)
3. TURN THE BALANCE WHEEL TO PUT THE CAM FOLLOWER ONTO THE TOP CONVEX OF THE ZIGZAG CAM.
4. LOOSEN THE SET SCREW.
5. PUSH THE CONVEX PART OF THE CAM FOLLOWER RELEASING ARM IN THE DIRECTION OF ARROW UNTIL THE CAM FOLLOWER RELEASING ARM TOUCHES TO POSITION (A) OF THE PATTERN SELECT CAM, AND THEN, TIGHTEN THE SET SCREW.

NOTE: AFTER THIS ADJUSTMENT, CHECK THAT THE CLEARANCE BETWEEN THE ZIGZAG CAM AND THE CAM FOLLOWER IS 0.3MM WHEN THE CAM FOLLOWER RELEASING ARM HAS REMOVED TO POSITION (B) BY TURNING THE PATTERN SELECTOR DIAL COUNTERCLOCKWISE, AND ALSO THE CLEARANCE BETWEEN THE CAM FOLLOWER AND THE ZIGZAG CAM SHOULD BE 0.3MM.

6. REMOVE THE PATTERN SELECTOR DIAL, AND MOUNT THE FRONT COVER.



MECHANICAL ADJUSTMENT

(FOR MODEL JF 1004)

DISENGAGEMENT OF CAM FOLLOWER

CORRECT SETTING

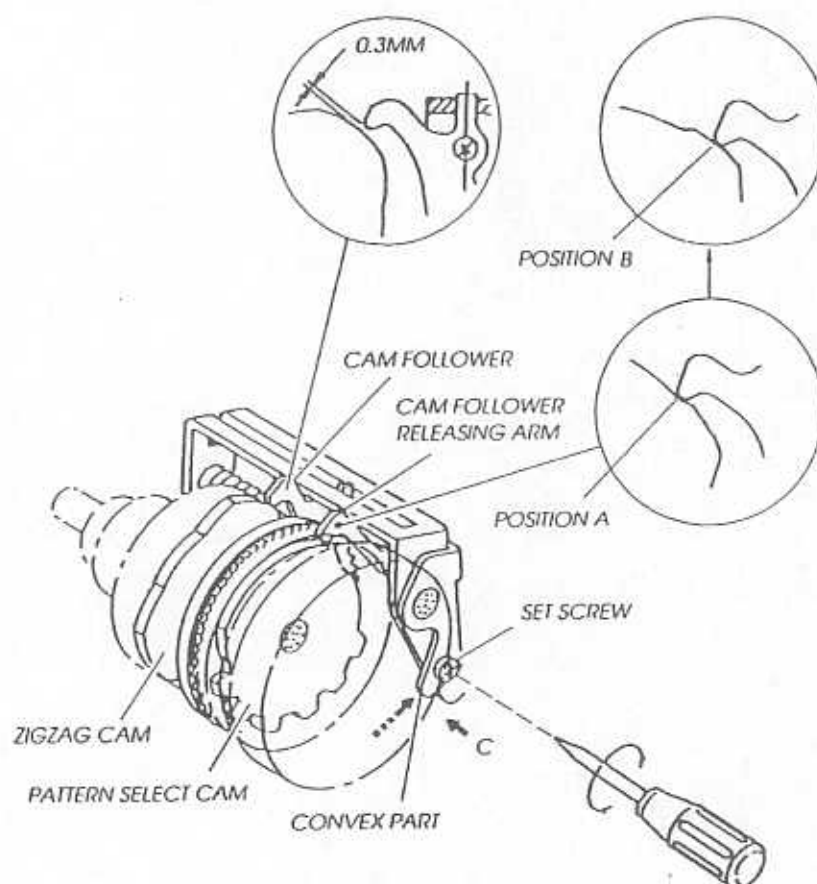
TOO NARROW CLEARANCE BETWEEN THE CAM FOLLOWER AND THE TOP CONVEX OF ZIGZAG CAM MAY OFTEN CAUSE DIFFICULTY IN TURNING OF THE PATTERN SELECTOR DIAL, CAN NOT SELECT CORRECT PATTERN OR ZIGZAGING IN STRAIGHT STITCH SETTING.

TO ADJUST

1. REMOVE THE FRONT COVER. (SEE PAGE 5.)
2. MOUNT THE PATTERN SELECTOR DIAL, AND SET IT AT PATTERN "E". (5TH CAM AS VIEWED FROM C.)
3. TURN THE BALANCE WHEEL TO PUT THE CAM FOLLOWER ONTO THE TOP CONVEX OF THE ZIGZAG CAM.
4. LOOSEN THE SET SCREW.
5. PUSH THE CONVEX PART OF THE CAM FOLLOWER RELEASING ARM IN THE DIRECTION OF ARROW UNTIL THE CAM FOLLOWER RELEASING ARM TOUCHES TO POSITION (A) OF THE PATTERN SELECT CAM, AND THEN, TIGHTEN THE SET SCREW.

NOTE: AFTER THIS ADJUSTMENT, CHECK THAT THE CLEARANCE BETWEEN THE ZIGZAG CAM AND THE CAM FOLLOWER IS 0.3MM WHEN THE CAM FOLLOWER RELEASING ARM HAS REMOVED TO POSITION (B) BY TURNING THE PATTERN SELECTOR DIAL COUNTERCLOCKWISE, AND ALSO THE CLEARANCE BETWEEN THE CAM FOLLOWER AND THE ZIGZAG CAM SHOULD BE 0.3MM.

6. REMOVE THE PATTERN SELECTOR DIAL, AND MOUNT THE FRONT COVER.



MECHANICAL ADJUSTMENT

(FOR MODEL JF1018S ONLY)

BUTTONHOLE FUNCTION

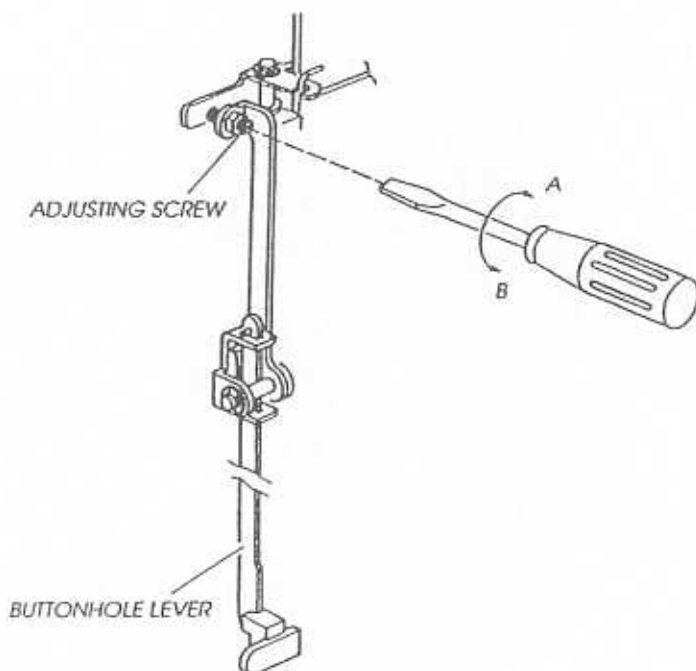
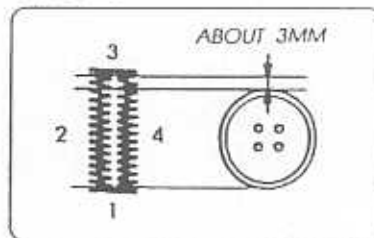
CORRECT SETTING

IN BH STITCHING, THE SEWED BUTTONHOLE SHOULD BE ABOUT 3MM LONGER THAN THE LENGTH SET BY THE R FOOT. IF THIS LENGTH CANNOT BE OBTAINED, THEN CHECK AND ADJUST IN THE FOLLOWING PROCEDURE:

TO ADJUST

1. REMOVE THE FACE PLATE. (SEE PAGE 4.)
2. TURN THE ADJUSTING SCREW IN THE DIRECTION OF (A) IF THE BUTTONHOLE STITCH LENGTH IS LONGER THAN THE STANDARD, OR IN THE DIRECTION OF (B) IF THE BUTTONHOLE STITCH LENGTH IS SHORTER THAN THE STANDARD.
3. MOUNT THE FACE PLATE.

STANDARD

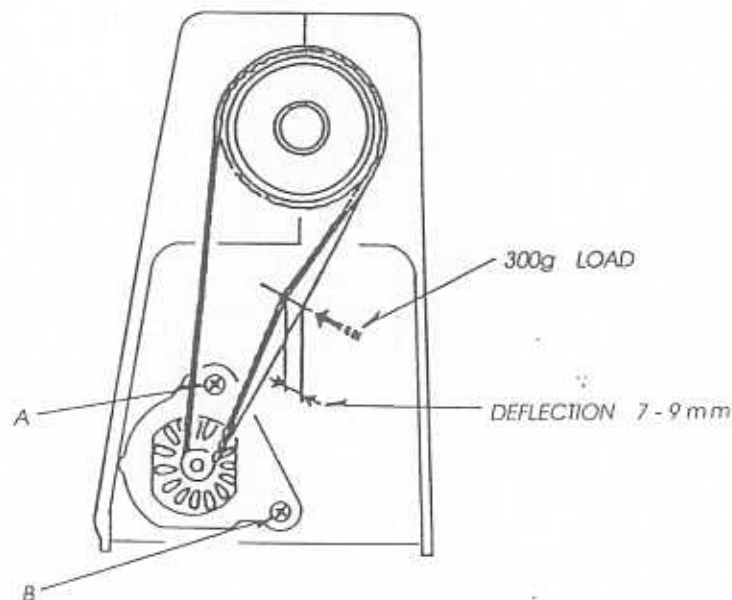


MECHANICAL ADJUSTMENT

MOTOR BELT TENSION

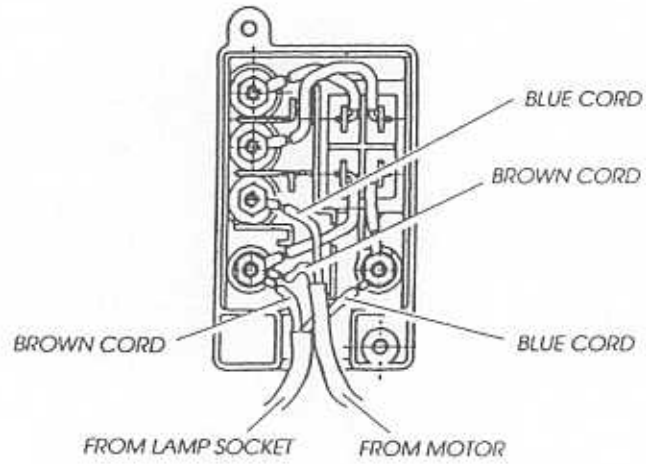
- CHECK:
1. TOO TIGHT OR TOO LOOSE MOTOR BELT TENSION MAY CREATE BELT NOISE AND ALSO TOO TIGHT MOTOR BELT TENSION CAN CAUSE THE MACHINE TO RUN SLOW AND WILL OVERLOAD THE MOTOR.
TOO LOOSE MOTOR BELT TENSION MAY CAUSE JUMPING OF THE BELT TEETH ON THE MOTOR PULLEY.
 2. THE CORRECT MOTOR BELT TENSION IS THAT THE DEFLECTION OF MOTOR BELT IS ABOUT 7 MM (0.28") - 9 MM (0.36") WHEN PUSHING THE MOTOR BELT BY FINGER AT ABOUT 300 GRAMS LOAD.

- ADJUSTMENT:
1. REMOVE THE BELT COVER.
 2. LOOSEN THE SCREWS (A) AND (B).
 3. MOVE THE MOTOR UP OR DOWN TO ADJUST THE DEFLECTION ABOUT 7 MM (0.28") - 9 MM (0.36").
 4. TIGHTEN THE SCREWS (A) AND (B).

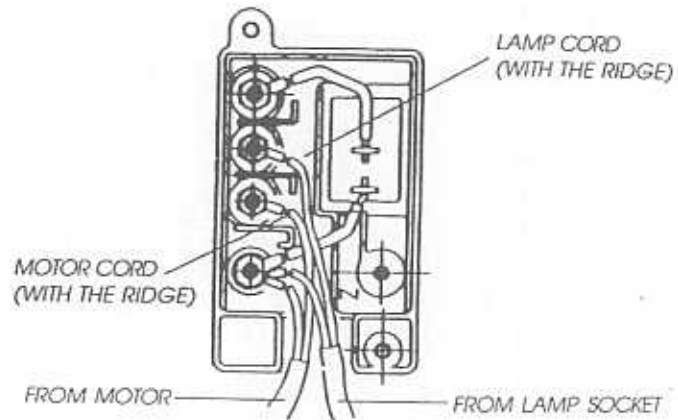


WIRING

(FOR 220-240V)

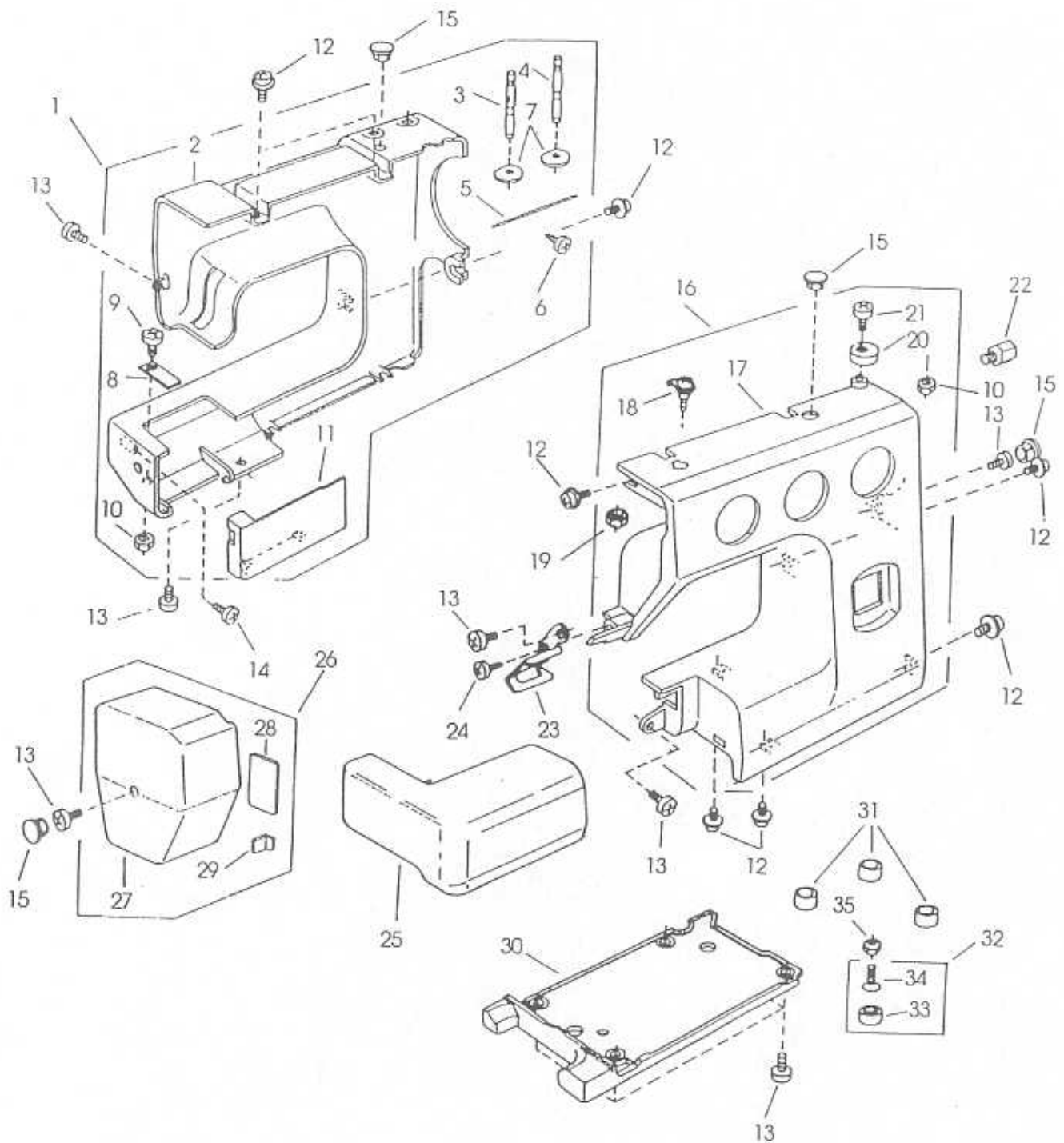


(FOR 110-120V)



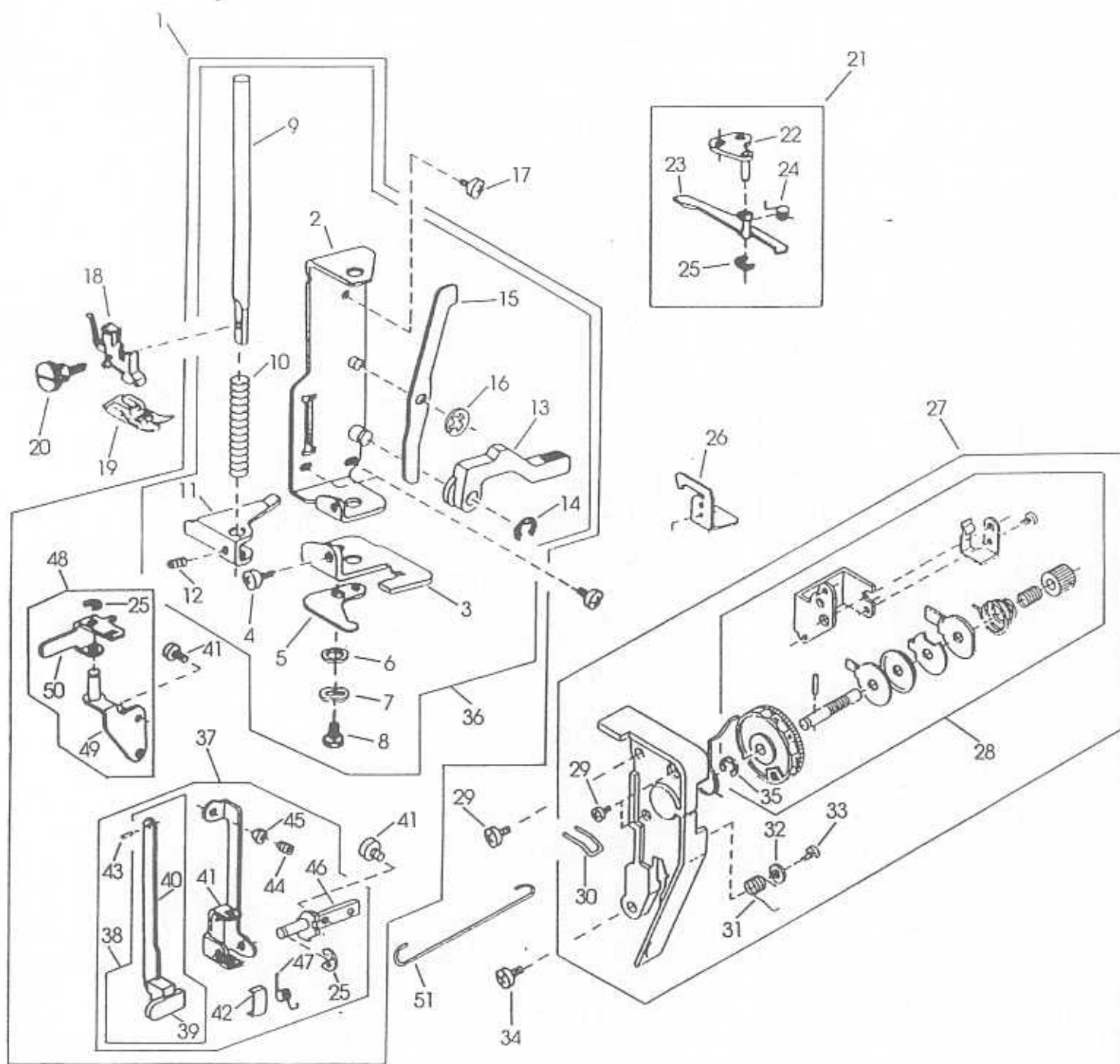
PARTS LIST

PARTS LIST

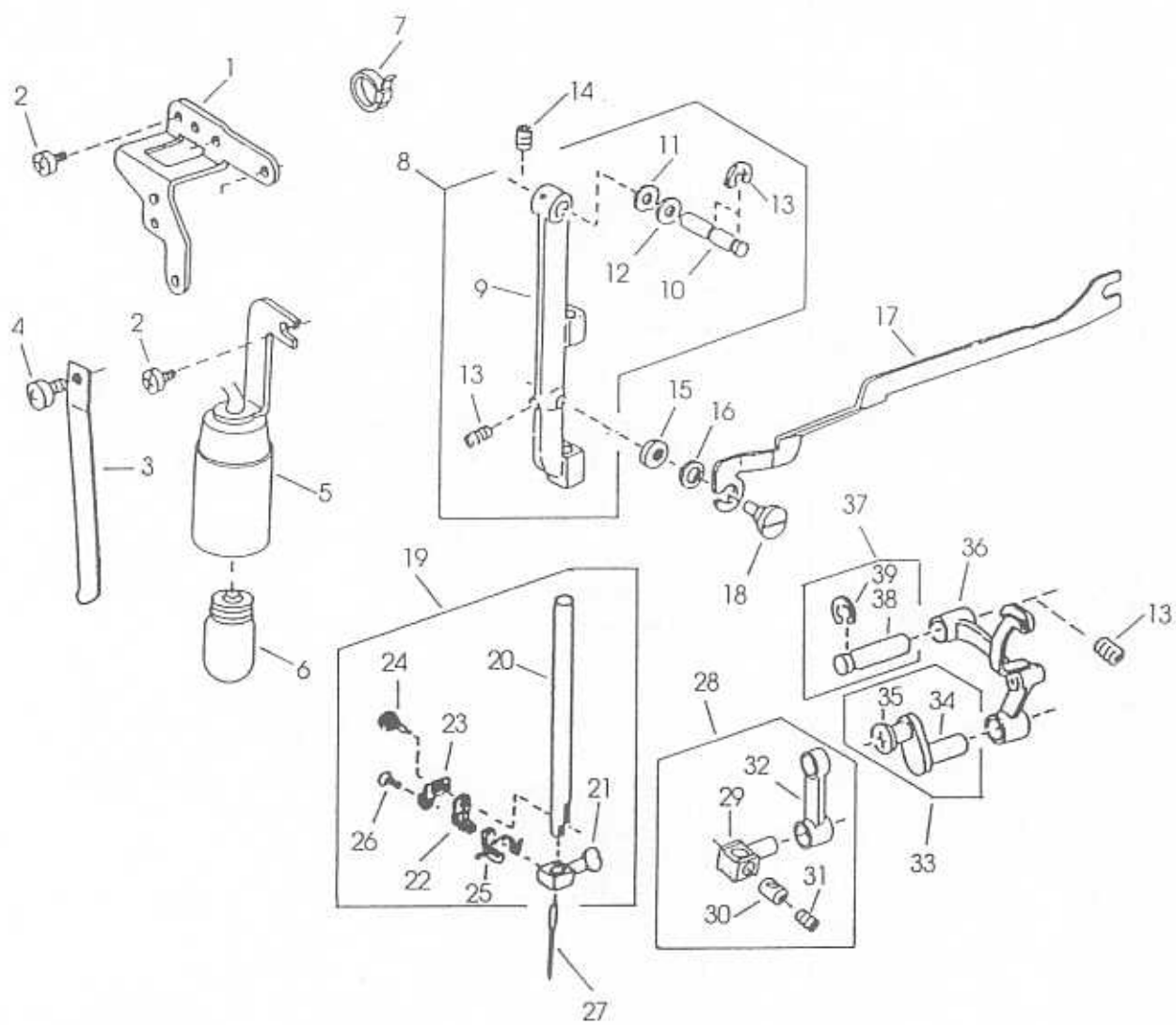


(NOTE: THE FRONT COVER SHOWN ABOVE IS THAT OF MODEL JF1022.)

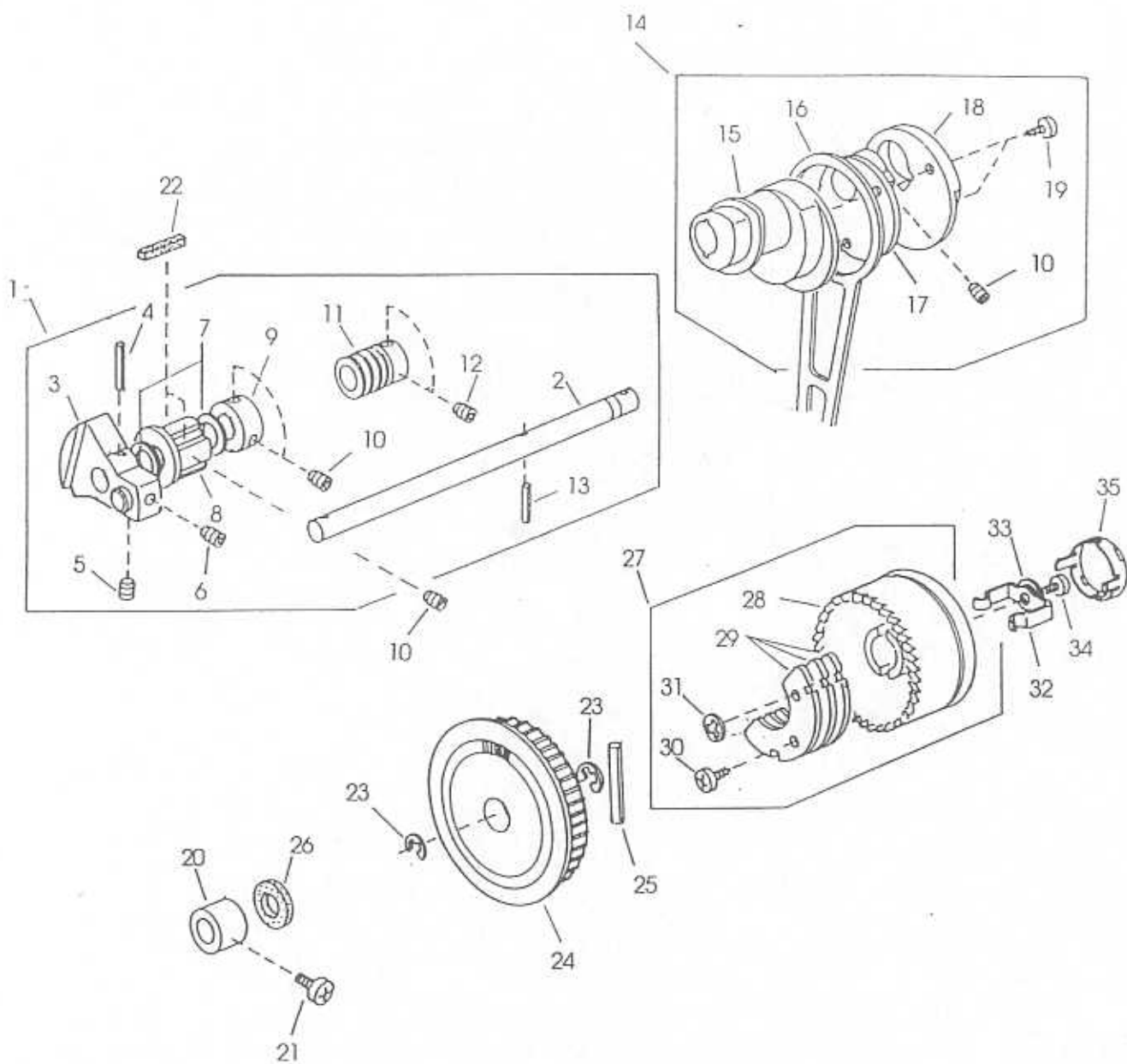
KEY NO.	PARTS NO.	DESCRIPTION	QUANTITY	
1	743601001	REAR COVER (UNIT) FOR ALL MODELS	1	
2	743003007	REAR COVER	1	
3	652302004	SPOOL PIN (LEFT)	1	
4	652205006	SPOOL PIN (RIGHT)	1	
5	736007009	SPOOL PIN SPRING	1	
6	000076317	T SET SCREW 3X10	1	
7	735013005	SPOOL PIN SPRING BASE	2	
8	730006000	SPRING	1	
9	000101404	SET SCREW 4X6	1	
10	000061205	NUT	2	
11	739004005	BED COVER PLATE	1	
12	000115205	TP SCREW 4X6	8	
13	000081005	SET SCREW 4X8	10	
14	000121905	TP SCREW 4X12B	1	
15	653006101	CAP	1	
16	743607007	FRONT COVER (UNIT) FOR JF1022	1	COMMON
	743605108	FRONT COVER (UNIT) FOR JF1018S	1	COMMON
	743607100	FRONT COVER (UNIT) FOR JF1018	1	COMMON
	743605407	FRONT COVER (UNIT) FOR JF1014	1	FOR JUK
	743605913	FRONT COVER (UNIT) FOR JF1012	1	COMMON
	743608008	FRONT COVER (UNIT) FOR JF1004	1	COMMON
17	743016117	FRONT COVER FOR JF1022	1	COMMON
	743016025	FRONT COVER FOR JF1018S	1	COMMON
	743016128	FRONT COVER FOR JF1018	1	COMMON
	743016058	FRONT COVER FOR JF1014	1	FOR JUK
	743016243	FRONT COVER FOR JF1012	1	COMMON
	743016210	FRONT COVER FOR JF1004	1	COMMON
18	730501011	THREAD GUIDE PLATE (UNIT)	1	
19	000160102	ADJUSTABLE LOCK NUT 4	1	
20	735016307	BOBBIN WINDER STOPPER	1	
21	000103107	SET SCREW 4X14	1	
22	741033000	COVER BASE SCREW	1	
23	740022003	THREAD GUIDE PLATE	1	
24	000107307	TP SCREW 3X8B	1	
25	743004008	EXTENSION TABLE	1	
26	743602301	FACE PLATE (UNIT) FOR ALL MODELS	1	COMMON
	743602208	FACE PLATE (UNIT) FOR JF1004	1	NH ONLY
27	743005009	FACE PLATE	1	
28	724025006	REFLEX STICKER	1	
29	822532008	THREAD CUTTER	1	
30	739005006	BASE PLATE	1	
31	739064003	RUBBER BASE	3	
32	735616107	RUBBER BASE (UNIT)	1	
33	735002001	RUBBER BASE	1	
34	000192000	SCREW	1	
35	000061319	NUT	1	



KEY NO.	PARTS NO.	DESCRIPTION	QUANTITY
1	740620007	PRESSER BAR BASE PLATE (UNIT) FOR JF1018S ONLY	1
2	735023008	PRESSER BAR BASE PLATE	1
3	735024009	NEEDLE DROP ADJUSTING PLATE	1
4	000101404	SET SCREW 4X6	1
5	735025000	NEEDLE BAR SUPPORTER STOPPER	1
6	000070506	PLAIN WASHER	1
7	000116103	WAVE WASHER 4	1
8	000138307	BOLT 4X8	1
9	735026001	PRESSER BAR	1
10	735027002	PRESSER BAR SPRING	1
11	735028003	PRESSER BAR BRACKET	1
12	000111500	HEXAGON SOCKET SCREW 4X8	1
13	735029004	PRESSER FOOT LIFTER	1
14	000001609	SNAP RING E-5	1
15	735030008	TENSION RELEASE LEVER	1
16	000013903	SNAP RING CS-5	1
17	000081005	SET SCREW 4X8	3
18	611510000	PRESSER FOOT HOLDER	1
19	611511001	PRESSER FOOT (UNIT)	1
20	647112009	THUMB SCREW	1
21	739605002	TENSION RELEASE ARM (UNIT)	1
22	739017001	TENSION RELEASE ARM BASE	1
23	739018002	TENSION RELEASE ARM	1
24	739019003	TENSION RELEASE SPRING	1
25	000002105	SNAP RING E-3	1
26	739016000	TOP COVER THREAD GUIDE	1
27	743501000	TENSION ASSEMBLY	1
28	735506217	TENSION DIAL (UNIT)	1
29	000103808	SET SCREW 3X5	4
30	735040001	THREAD GUIDE	1
31	735041002	CHECK SPRING	1
32	652039007	WASHER	1
33	000107307	TAPPING SCREW 3X8B	1
34	000101703	SET SCREW 4X12	1
35	000002507	SNAP RING E-4	1
36	735604009	PRESSER BAR PLATE (UNIT) FOR ALL MODELS, EXCEPT JF1018S	1
37	740617001	BH LEVER (UNIT) FOR JF1018S ONLY	1
38	753629109	BH LEVER (UNIT) FOR JF1018S ONLY	1
39	753160107	BH KNOB FOR JF1018S ONLY	1
40	753161108	BH LEVER FOR JF1018S ONLY	1
41	740047004	BH LEVER SUPPORTER FOR JF1018S ONLY	1
42	753027008	FRICTION SPRING FOR JF1018S ONLY	1
43	000023009	SPRING PIN 1.6X4 FOR JF1018S ONLY	1
44	000113306	SET SCREW 4X10 FOR JF1018S ONLY	1
45	000160102	ADJUSTABLE LOCK NUT 4 FOR JF1018S ONLY	1
46	740048005	BH LEVER BASE PLATE FOR JF1018S ONLY	1
47	740049006	BH LEVER SPRING FOR JF1018S ONLY	1
48	740613007	BH LEVER BASE (UNIT) FOR JF1018S ONLY	1
49	740050000	BH LEVER BASE FOR JF1018S ONLY	1
50	740051001	BH REGULATING LEVER FOR JF1018S ONLY	1
51	740052002	BH SHIFTING ROD FOR JF1018S ONLY	1

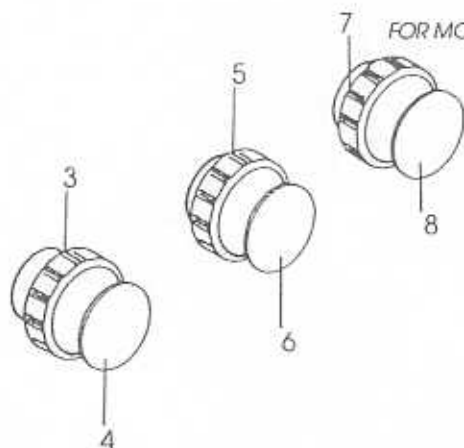
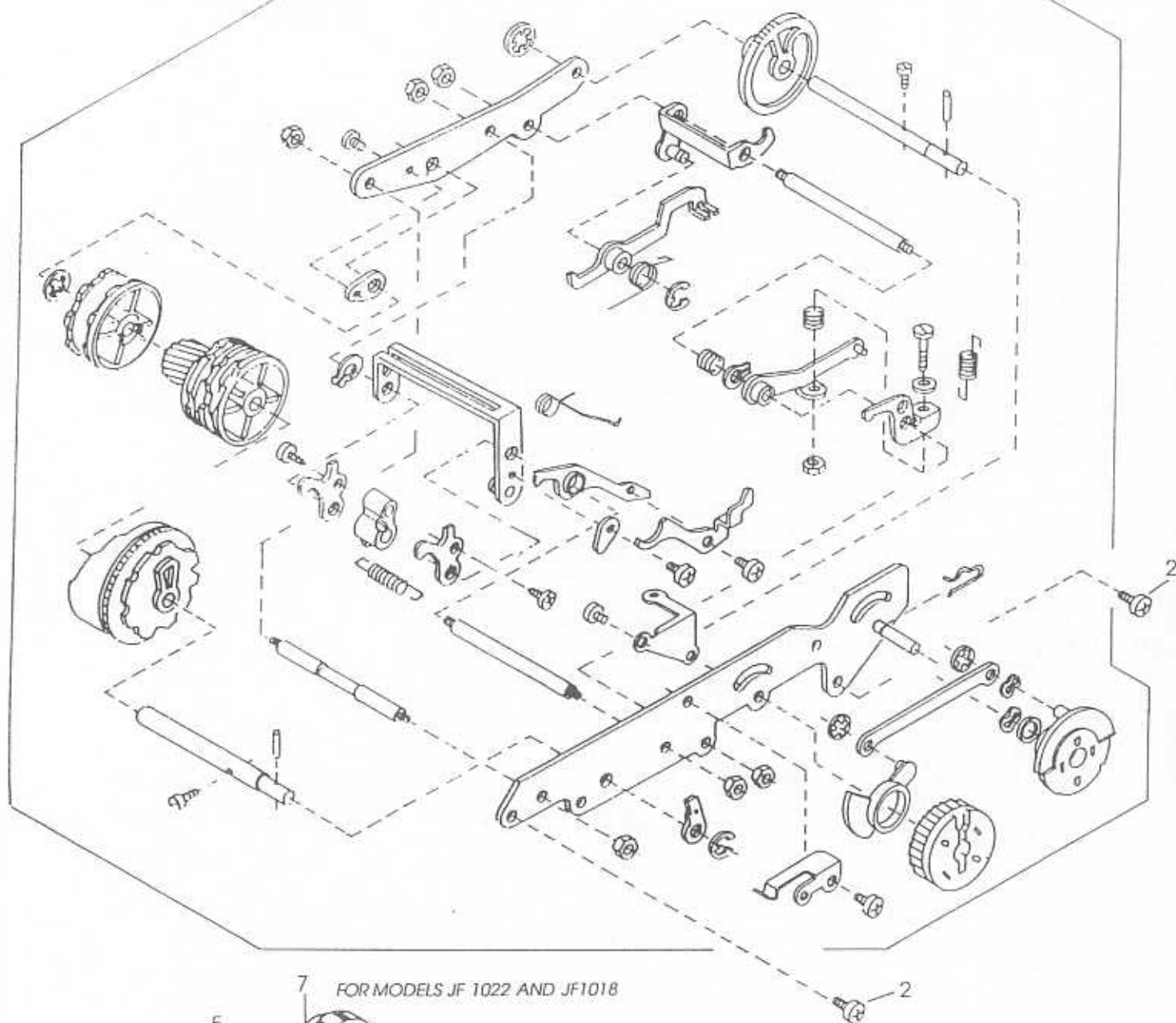


KEY NO.	PARTS NO.	DESCRIPTION	QUANTITY	
1	740007013	FACE PLATE BASE PLATE	1	
2	000081005	SET SCREW 4X8	2	
3	730024004	NEEDLE BAR SUPPORTER SPRING	1	
4	000101404	SET SCREW 4X6	1	
5	737512005	LAMP SOCKET (240V)	1	
	647510207	LAMP SOCKET (120V) <i>BL1108</i>	1	COMMON
6	000009102	LAMP (240V)	1	FOR NH
	000009803	LAMP (120V) <i>BL1108</i>	1	COMMON
7	000053008	CORD TIE BAND	1	FOR NH
8	735605103	NEEDLE BAR SUPPORTER (UNIT)	2	
9	735032000	NEEDLE BAR SUPPORTER	1	
10	730022002	NEEDLE BAR SUPPORTER PIN	1	
11	673022002	SPRING WASHER	1	
12	000070609	PLAIN WASHER	1	
13	000002507	SNAP RING E-4	1	
14	000111304	HEXAGON SOCKET SCREW 5X5	2	
15	670258000	PLAIN WASHER	3	
16	678044005	PLAIN WASHER	1	
17	735119002	ZIGZAG ROD	1	
18	678084007	ECCENTRIC PIN	1	
19	730503116	NEEDLE BAR (UNIT)	1	
20	553085019	NEEDLE BAR	1	
21	801506008	NEEDLE CLAMP (UNIT)	1	
22	730025005	NEEDLE GUIDE PLATE	1	
23	732105006	NEEDLE CLAMP PLATE	1	
24	802108009	HINGE SCREW	1	
25	680043012	NEEDLE BAR THREAD GUIDE	1	
26	670047004	FLAT HEAD SCREW	1	
27	102408089	NEEDLE HA1-14	1	
28	680504005	NEEDLE BAR CONNECTING STUD (UNIT)	1	
29	670052002	NEEDLE BAR CONNECTING STUD	1	
30	670272000	NEEDLE BAR CONNECTING STUD PIN	1	
31	000111201	HEXAGON SOCKET SCREW 4X4	1	
32	680032007	NEEDLE BAR CRANK ROD	1	
33	735504008	NEEDLE BAR CRANK PIN (UNIT)	1	
34	735174005	NEEDLE BAR CRANK PIN	1	
35	647139002	NEEDLE BAR CRANK CAP	1	
36	625506109	THREAD TAKE-UP LEVER (UNIT)	1	
37	731511006	THREAD TAKE-UP LEVER PIN (UNIT)	1	
38	647040005	THREAD TAKE-UP LEVER PIN	1	
39	000002806	SNAP RING E-6	1	

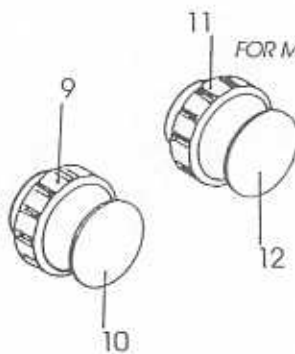


KEY NO.	PARTS NO.	DESCRIPTION	QUANTITY
1	743603106	UPPER SHAFT (UNIT)	1
2	743007001	UPPER SHAFT	1
3	743008002	TAKE-UP LEVER CRANK	1
4	000021708	SPRING PIN	1
5	102073003	SET SCREW	1
6	761052007	SET SCREW	1
7	000039307	THRUST WASHER FT-100	2
8	743009003	UPPER SHAFT FRONT BUSHING	1
9	639095000	RING	1
10	000111304	HEXAGON SOCKET SCREW 5X5	4
11	749011006	WORM GEAR	1
12	553245008	HEXAGON SOCKET SCREW 4X4	2
13	000003601	SPRING PIN	1
14	743604004	CRANK ROD (UNIT)	1
15	743010007	FEED CAM	1
16	743011008	CRANK ROD	1
17	639033000	CRANK CAM	1
18	639102012	CRANK CAM PLATE	1
19	000121400	TAPPING SCREW 3X14B	2
20	743002006	UPPER SHAFT REAR BUSHING	1
21	000172602	SET SCREW 5X8	1
22	731312005	FELT	2
23	000030205	SNAP RING E-8	2
24	743019006	BELT WHEEL	1
25	000023803	SPRING PIN	1
26	735143005	FELT	1
27	743606006	BALANCE WHEEL (UNIT)	1
28	639097024	BALANCE WHEEL	1
29	639116008	BALANCE WEIGHT	3
30	000160607	T SCREW 3X14B	1
31	000014306	SNAP RING CS-3	1
32	639113016	CLUTCH SPRING	1
33	000071013	PLAIN WASHER	1
34	810220003	SET SCREW	1
35	650070509	CLUTCH CAP	1

(NOTE: THIS DRAWING IS BASED THE ZIGZAG MECHANISM IN MODEL JF 1022.)

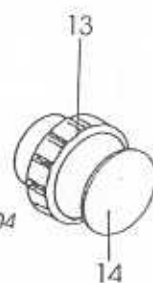


FOR MODELS JF 1022 AND JF1018

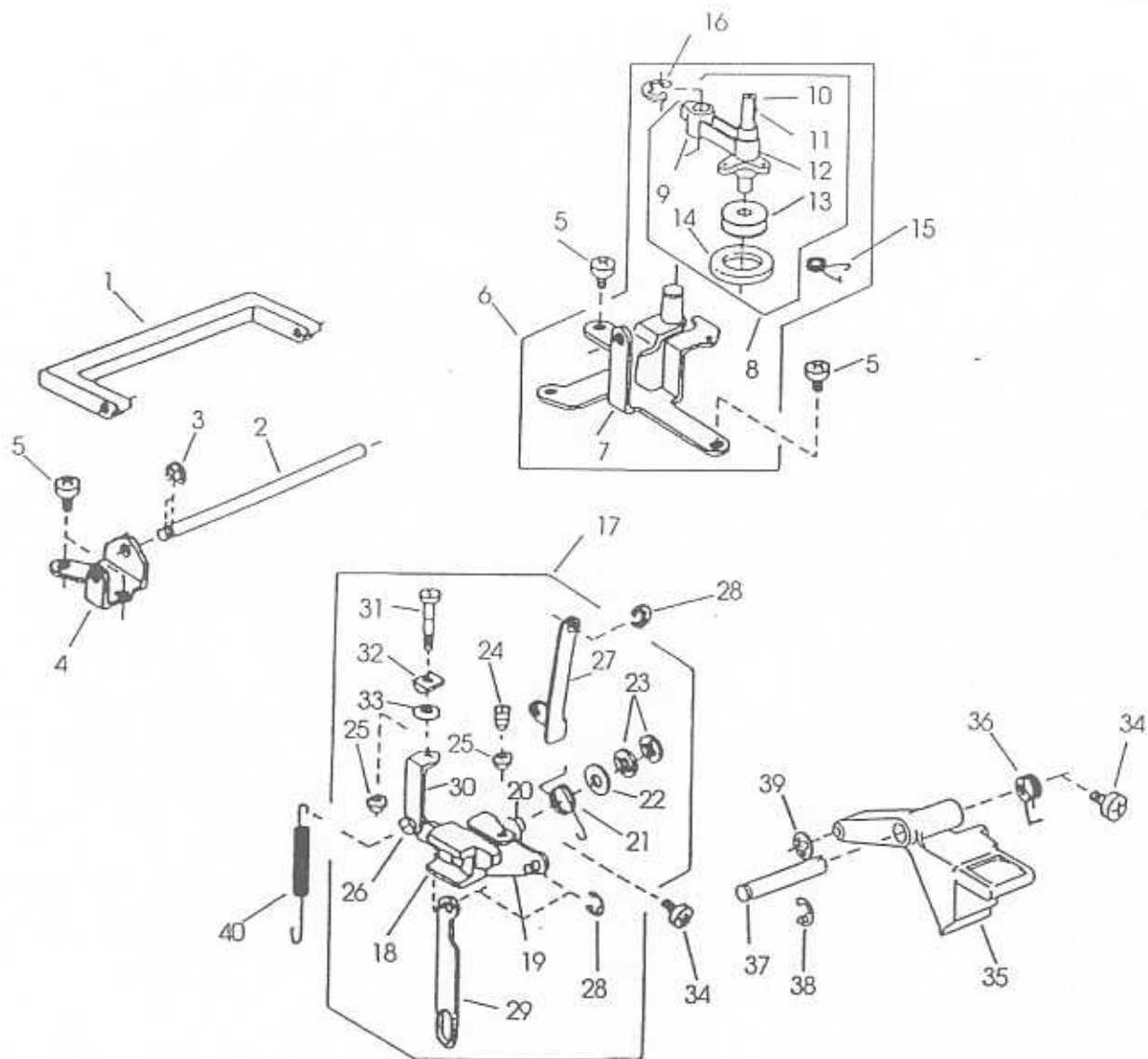


FOR MODELS JF1018S, JF1014 AND JF1012

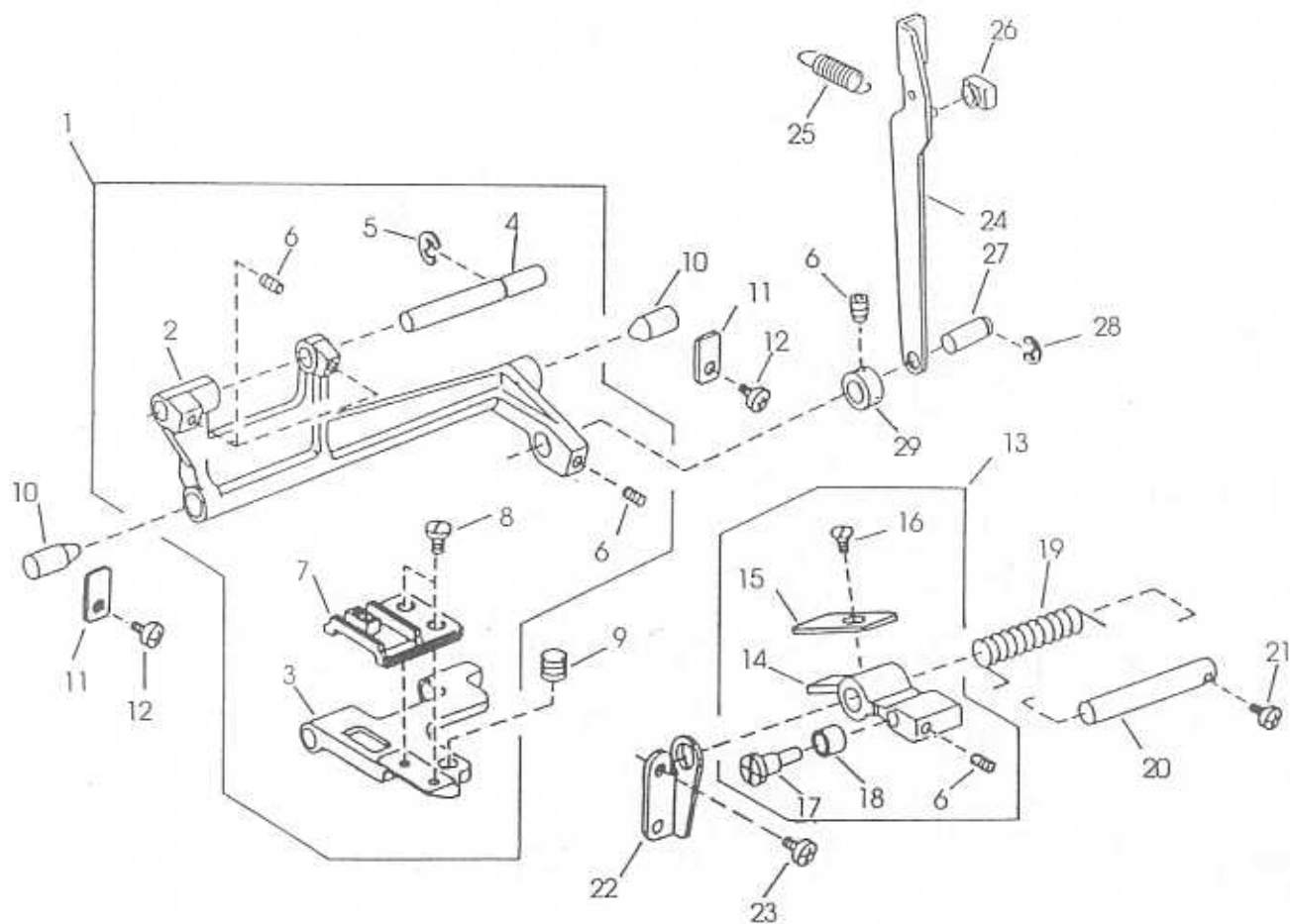
FOR MODEL JF1004



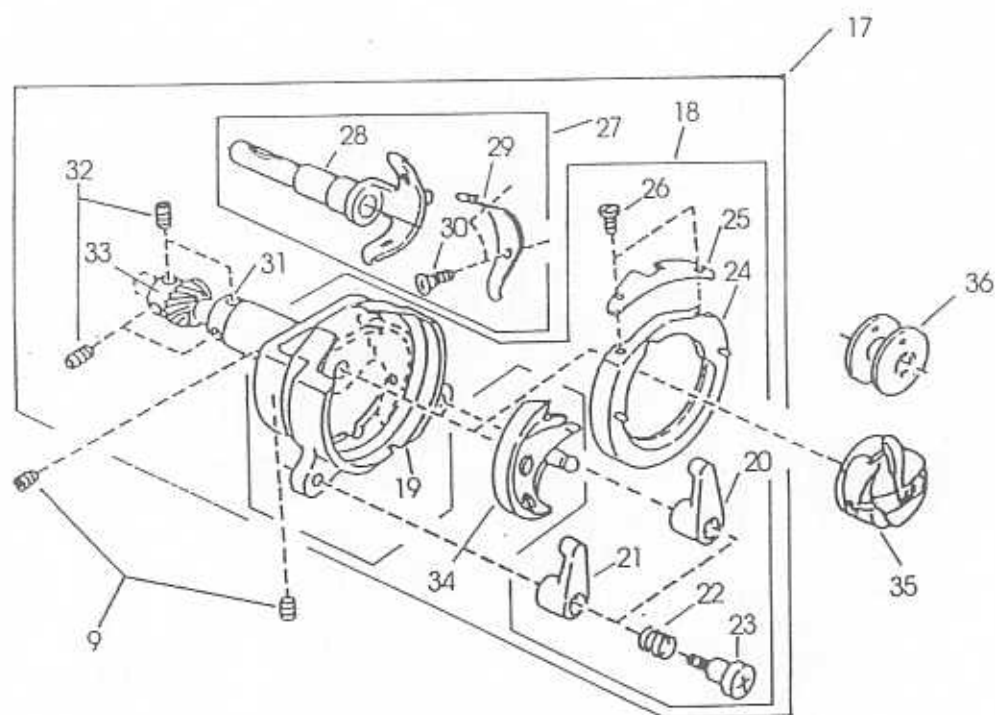
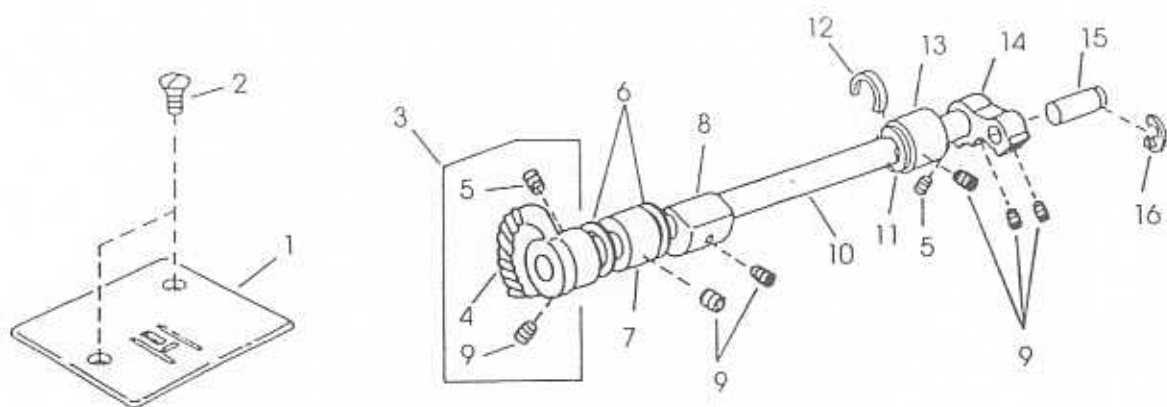
KEY NO.	PARTS NO.	DESCRIPTION	QUANTITY
1	743609009	ZIGZAG MECHANISM FOR JF1022	1 COMMON
	740614008	ZIGZAG MECHANISM FOR JF1018S	1 COMMON
	743609205	ZIGZAG MECHANISM FOR JF1018	1 COMMON
	740606007	ZIGZAG MECHANISM FOR JF1014	1 FOR JUK
	740606409	ZIGZAG MECHANISM FOR JF1012	1 FOR JA, DUBAI & OMAN
	740615009	ZIGZAG MECHANISM FOR JF1004	1 COMMON
2	000081005	SET SCREW	2 COMMON
3	743015002	SELECTOR DIAL (PATTERN) FOR JF1022 & JF1018	1 COMMON
4	740032305	PATTERN INDICATING PLATE FOR JF1022	1 COMMON
	743028101	PATTERN INDICATING PLATE FOR JF1022	1 FOR DUBAI & OMAN
	743026006	PATTERN INDICATING PLATE FOR JF1018	1 COMMON
5	743022002	SELECTOR DIAL (STITCH LENGTH) FOR JF1022 & JF1018	1 COMMON
6	740019801	STITCH LENGTH INDICATING PLATE FOR JF1022	1 COMMON
	740019708	STITCH LENGTH INDICATING PLATE FOR JF1018	1 COMMON
7	743022002	SELECTOR DIAL (WIDTH) FOR JF1022 & JF1018	1 COMMON
8	743021001	WIDTH INDICATING PLATE FOR JF1022 & JF1018	1 COMMON
	743021104	WIDTH INDICATING PLATE FOR JF1022	1 FOR DUBAI & OMAN
9	743015002	SELECTOR DIAL (PATTERN) FOR JF1018S, JF1014 & JF1012	1 COMMON
10	743027007	PATTERN INDICATING PLATE FOR JF1018S	1 COMMON
	740095306	PATTERN INDICATING PLATE FOR JF1018S	1 FOR JA, DUBAI & OMAN
	743031004	PATTERN INDICATING PLATE FOR JF1014	1 FOR JUK
		PATTERN INDICATING PLATE FOR JF1012	1 COMMON
	743037000	PATTERN INDICATING PLATE FOR JF1012	1 FOR JA, DUBAI & OMAN
11	743015002	SELECTOR DIAL (STITCH LENGTH) FOR JF1018S, JF1014 & JF1012	1 COMMON
12	740126307	STITCH LENGTH INDICATING PLATE FOR JF1018S	1 COMMON
	740126400	STITCH LENGTH INDICATING PLATE FOR JF1018S	1 FOR JA, DUBAI & OMAN
	740019801	STITCH LENGTH INDICATING PLATE FOR JF1014	1 FOR JUK
	740019801	STITCH LENGTH INDICATING PLATE FOR JF1012	1 COMMON
	740019801	STITCH LENGTH INDICATING PLATE FOR JF1012	1 FOR JA, DUBAI & OMAN
13	743015002	SELECTOR DIAL FOR JF1004	1 COMMON
14	743020000	PATTERN INDICATING PLATE FOR JF1004	1 COMMON



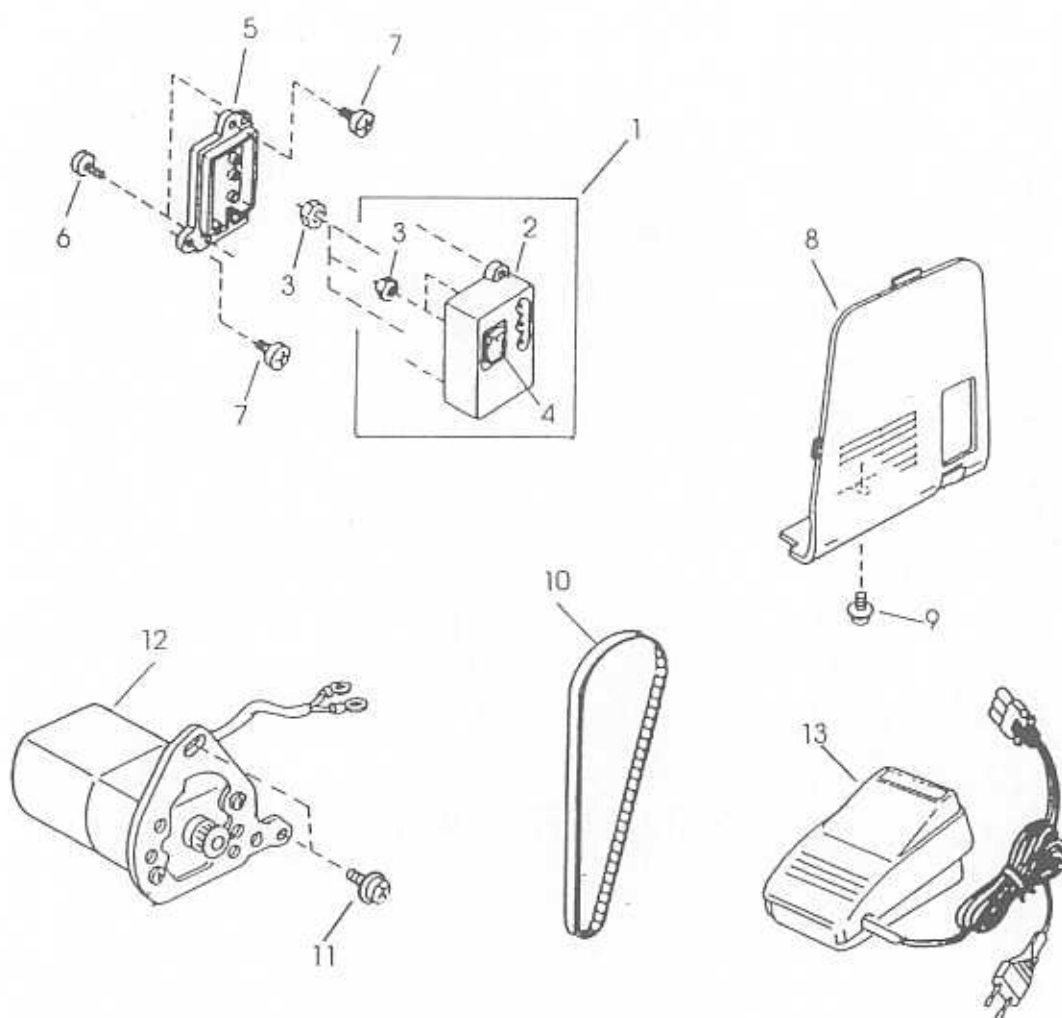
KEY NO.	PARTS NO.	DESCRIPTION	QUANTITY	
1	735017205	HANDLE	1	
2	740011009	HANDLE SHAFT	1	
3	000002105	SNAP RING E-3	2	
4	740010008	HANDLE HINGE SHAFT BASE	1	
5	000081005	SET SCREW 4X8	4	
6	740602209	BOBBIN WINDER BASE PLATE (UNIT)	1	
7	740003101	BOBBIN WINDER BASE PLATE	1	
8	735501005	BOBBIN WINDER ARM (UNIT)	1	
9	735014006	BOBBIN WINDER ARM	1	
10	735129005	BOBBIN WINDER SHAFT	1	
11	670026007	BOBBIN WINDER SHAFT SPRING	1	
12	652092008	BOBBIN WINDER SHAFT RING	1	
13	647017003	BOBBIN WINDER RING BASE	1	
14	647018004	BOBBIN WINDER RING	1	
15	740042009	BOBBIN WINDER ARM SPRING	1	
16	000002806	SNAP RING E-6	1	
17	736604105	FEED REGULATOR (UNIT)	1	
		FOR ALL MODELS, EXCEPT JF1004		
	736607016	FEED REGULATOR FOR JF1004	1	FOR NH
18	647049004	FEED REGULATOR FOR ALL MODELS	1	COMMON
19	736012007	FEED REGULATOR PLATE	1	
20	601024001	PIN	1	
21	735077007	FEED REGULATOR SPRING	1	
22	735073003	PLAIN WASHER	1	
23	000014605	SNAP RING CS-6	2	
24	648010009	SET SCREW	1	
25	000160102	ADJUSTABLE LOCK NUT 4	1	
26	648012001	SET SCREW	1	
27	739020007	FEED REGULATOR ROD	1	
28	000002105	SNAP RING E-3	3	
29	730045001	REVERSE LINK	1	
30	734039004	S. S ROD FOR ALL MODELS, EXCEPT JF1004	1	
31	735074004	S. S ADJUSTABLE SCREW	1	
		FOR ALL MODELS, EXCEPT JF1004		
32	735076006	S. S ROD BLOCK	1	
		FOR ALL MODELS, EXCEPT JF1004		
33	000071013	WASHER 4 FOR ALL MODELS, EXCEPT JF1004	1	
34	000172602	SET SCREW 5X8	2	
35	743014001	R BUTTON	1	
36	739063002	R BUTTON SPRING	1	
37	736015000	R BUTTON SHAFT	1	
38	000001609	SNAP RING E-5	1	
39	000014007	SNAP RING CS-4	1	
40	670100006	FEED REGULATOR SPRING	1	
		FOR ALL MODELS, EXCEPT JF1018S		
	740125007	FEED REGULATOR SPRING FOR JF1018S	1	



KEY NO.	PARTS NO.	DESCRIPTION	QUANTITY
1	735612000	FEED ROCK SHAFT (UNIT)	1
2	735078008	FEED ROCK SHAFT	1
3	735079009	FEED BAR	1
4	735080003	FEED BAR SHAFT	1
5	000002507	SNAP RING E-4	1
6	000111201	HEXAGON SOCKET SCREW	4
7	735081004	FEED DOG	1
8	735082005	SET SCREW	1
9	735083006	FEED BAR SPRING	1
10	735084007	FEED ROCK SHAFT CENTER	2
11	735085008	FEED ROCK SHAFT CENTER PLATE	1
12	000101404	SET SCREW 4X6	2
13	735613001	FEED LIFTING ARM (UNIT)	1
14	735086009	FEED LIFTING ARM	1
15	605030002	SLIDING PLATE	1
16	365032001	SET SCREW	1
17	735087000	FEED LIFTING PIN	1
18	735088001	FEED LIFTING ROLLER	1
19	735089002	FEED LIFTING SPRING	1
20	735090006	FEED LIFTING SHAFT	1
21	000097200	SET SCREW 4X12	1
22	739022009	FEED LIFTING SHAFT HOLDER	1
23	000081119	SET SCREW 4X6	1
24	743012009	FEED ROD	1
25	743013000	FEED ROD SPRING	1
26	102141003	FEED REGULATOR SLIDE BLOCK	1
27	735071001	FEED ROCK SHAFT CONNECTING PIN	1
28	000002806	SNAP RING E-6	1
29	735276008	RING	1



KEY NO.	PARTS NO.	DESCRIPTION	QUANTITY
1	739008009	NEEDLE PLATE	1
2	681009101	SET SCREW	2
3	735950003	LOWER SHAFT GEAR (UNIT)	1
4	735951004	LOWER SHAFT GEAR	1
5	000110107	HEXAGON SOCKET SCREW 5X5WP	2
6	000036201	THRUST WASHER FT-80	2
7	735233003	BUSHING	1
8	735061008	FEED LIFTING CAM	1
9	000111304	HEXAGON SOCKET SCREW 5X5	8
10	735236006	LOWER SHAFT	1
11	822070003	FELT	1
12	735239009	FELT HOLDER	1
13	735234004	BUSHING	1
14	639036003	LOWER SHAFT CRANK ARM	1
15	639037004	PIN	1
16	000002507	SNAP RING E-4	1
17	735610101	SHUTTLE BODY (UNIT)	1
18	735508002	SHUTTLE RACE BODY (UNIT)	1
19	735065002	SHUTTLE RACE BODY	1
20	605065006	SHUTTLE RACE RING CLASP (RIGHT)	1
21	605066007	SHUTTLE RACE RING CLASP (LEFT)	1
22	532184003	SHUTTLE RACE RING CLASP SPRING	1
23	673290003	HINGE SCREW	2
24	553168006	SHUTTLE RACE RING	1
25	601801000	SHUTTLE RACE SPRING	1
26	102100000	SET SCREW	2
27	735509003	DRIVER BODY (UNIT)	1
28	735066003	DRIVER BODY	1
29	670286007	DRIVER SPRING	1
30	102202003	SET SCREW	2
31	735067004	RING	1
32	553245008	HEXAGON SOCKET SCREW	4
33	735068108	SHUTTLE RACE BODY SHAFT GEAR	1
34	532096007	SHUTTLE HOOK	1
35	647515006	BOBBIN CASE	1
36	102261000	BOBBIN	1



KEY NO.	PARTS NO.	DESCRIPTION	QUANTITY	
1	739503009	MACHINE SOCKET (UNIT) FOR 240V	1	COMMON
	739505001	MACHINE SOCKET (UNIT) FOR 120V <i>BL1108</i>	1	NH ONLY
2	739036006	MACHINE SOCKET FOR 240V	1	COMMON
	739036006	MACHINE SOCKET FOR 120V <i>BL1108</i>	1	NH ONLY
3	000060802	NUT 3-1-5.5	5	
4	653528001	SWITCH FOR 240V	1	COMMON
	830334003	SWITCH FOR 120V <i>BL1108</i>	1	
5	739037007	MACHINE SOCKET COVER	1	
6	000107802	T SCREW 3X10	2	
7	000103509	SET SCREW 4X10	2	
8	743017004	BELT COVER	1	
9	000115205	TP SCREW 4X6	1	
10	650166008	TIMING BELT	1	
11	000115504	TP SCREW 5X10	2	
12	024070108	MOTOR (UNIT)	1	COMMON
	024070201	MOTOR (UNIT)	1	FOR JA & JUK
	024070304	MOTOR (UNIT)	1	FOR DUBAI & OMAN
	014170108	MOTOR (UNIT) <i>BL1108</i>	1	FOR NH
13	042870205	FOOT CONTROLLER (UNIT)	1	COMMON
	042870102	FOOT CONTROLLER (UNIT)	1	FOR JA
	042870401	FOOT CONTROLLER (UNIT)	1	FOR JUK
	033870104	FOOT CONTROLLER (UNIT) (TJC-150) <i>BL1108</i>	1	FOR NH