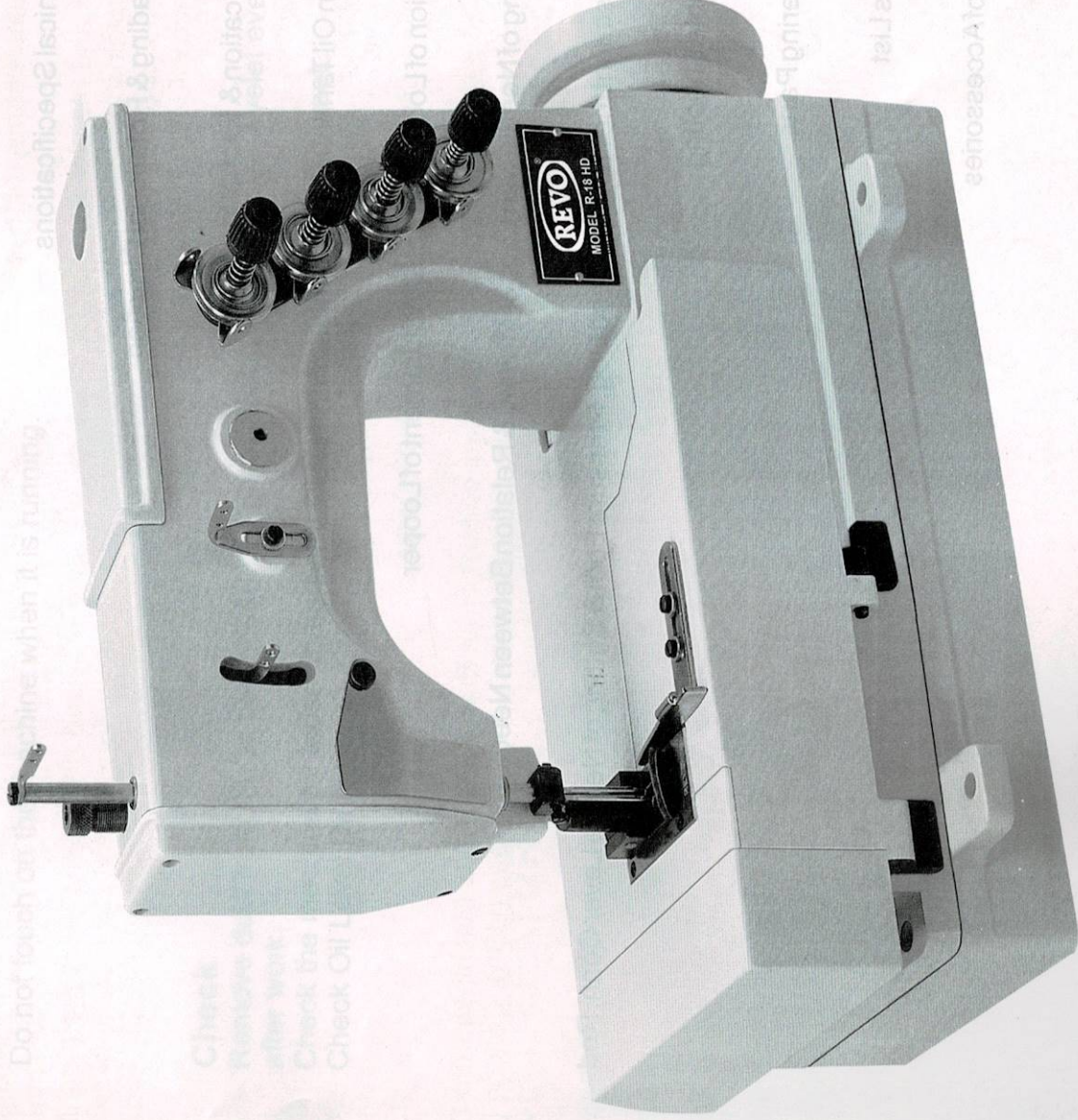


INSTRUCTION MANUAL



SINCE 1942



MODEL R-18HD & R-18HS

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SAFETY PRECAUTIONS AND CHECK

A. 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 running.

B. Check

1. Remove dust from throat plate, feed dog grooves and around looper eyelet everyday after work.
2. Check the machine for loose screws and tighten them, if any, once a week.
3. Check Oil Level Daily.

INTRODUCTION

We are pleased to introduce REVO Twin Needle 4 Threads Parallel Double Chain Sewing Machine Model R-18 HD for HDPE Woven Sacks, another addition to our wide range of Industrial Sewing Machines.

This machine is sturdy, high speed and self lubricated. All the frictional parts are made from High Grade Alloy Steel. Interchangeability of spares is ensured. To facilitate the operator and acquaint him with the operations and maintenance of the Machine, we have provided this manual with the machine. This manual explains about the operations, adjustments and maintenance. A thorough study of the Manual will enable the operator to get trouble free smooth service of this Machine. Right handling and day to day maintenance will increase the life of the Machine.

We have also Illustrated the detailed parts chart, which will enable the user to place order for the requisite spares and keep stock of wearable parts.

We are thankful to you for installing our Machine in your unit.

We assure you of our best and prompt service always.

Our State-of-the-art Manufacturing Facilities consist of 32 Brand New CNC Machines from Deckel-Maho (Germany), Chiron (Germany), Fanuc (Japan), Hamai (Japan), Haas (USA), Cellcon (USA), Favretto (Italy) and Studer (Switzerland)

All Revo® Bag Closers are CE Certified Revo® Corporation is ISO 9001:2008 TUV Certified

TECHNICAL SPECIFICATIONS

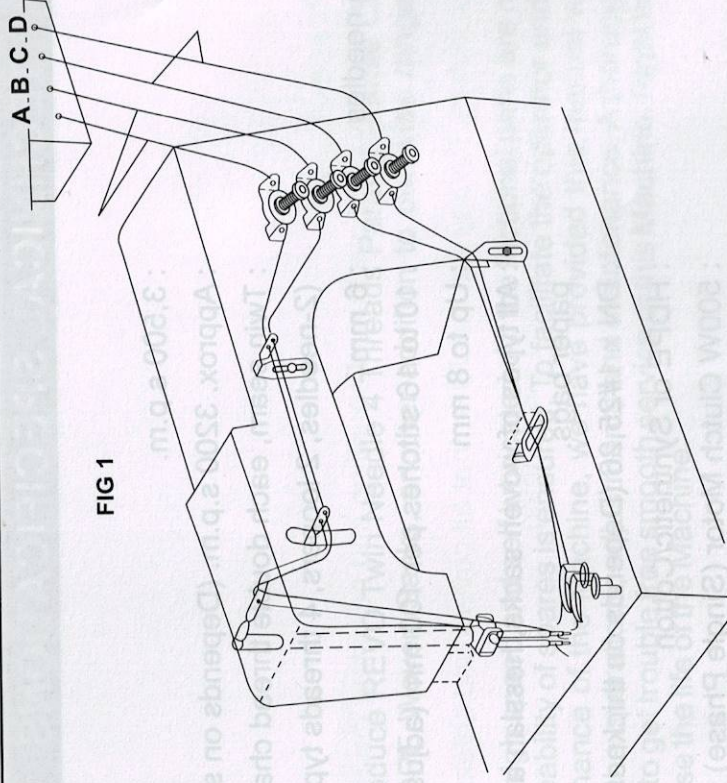
Max. Speed	: 3,500 s.p.m.
Working Speed	: Approx. 3200 s.p.m. (Depends on sewing material)
Seam	: Twin seam, each double thread chain stitch (2-needles, 2 loopers, 4 threads type)
Distance between two needles	: 6 mm
Stitch length	: 10 to 16 stitches per 100 mm (adjustable)
Material Thickness	: Up to 8 mm
Kind of material	: All types of woven sacks, hessian and multiwall paper bags.
Needle Size	: DN x 1#25,26 (Depends on thickness)
Thread	: HDPE or Synthetic/Cotton
Power required	: 500W Clutch Motor (Single Phase) 2850 r.p.m. Fully automatic
Net Weight	: 35 Kg.
Lubrication	: Fully Automatic

SPECIAL FEATURES :

1. Specially designed for heavy weight material such as HDPE, PP, Multiwall Paper and other type of woven sacks.
2. Bobbinless stitching system for high production.
3. Any type of cotton or synthetic yarn and plastic tape can be used.
4. Easily convertible to single needle machine.
5. Distance between two stitches can be adjusted by changing parts.
6. Fully automatic lubrication with oil recycling system which ensures long life of Machine.
7. Interchangeable Parts.
8. Parts are easily available.

THREADING

FIG 1



1.THREADING : (Figure No. 1)

Threading must be made correctly according to the illustration here under and take care to the fact that incorrect threading may cause some time skip-stitching, thread breakage and lack of uniformity in the sewing performance.

- A. B. Needle Thread.
- C. D. Looper Thread.

1.1 THREAD TENSION :

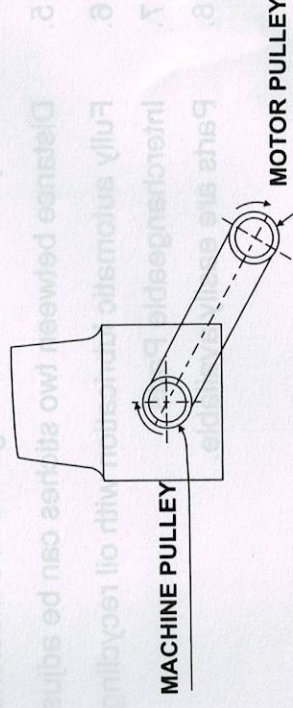
The thread tension must be adjusted according to sewing Fabric thickness, sewing and thread seam width, stitch length etc. Therefore the pressure of tension nuts of thread guides must be adjusted in each individual case.

2. ROTATIONAL DIRECTION :

Rotational Direction of the Pulley of motor & machine must be in clockwise direction.

NOTE : Use Suitable Number of F.H.P. V Belt. Do not run it before making sure the correct turning direction of motor.

FIG 2



1.THREADING : (Figure No. 1)

Threading must be made correctly according to the illustration here under and take care to the fact that incorrect threading may cause some time skip-stitching, thread breakage and lack of uniformity in the sewing performance.

- A. B. Needle Thread.
- C. D. Looper Thread.

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Rotational Direction of the Pulley of motor & machine must be in clockwise direction.

NOTE : Use Suitable Number of F.H.P. V Belt. Do not run it before making sure the correct turning direction of motor.

3. LUBRICATION :

3.1 LUBRICANT

Hindustan Petroleum 20 W-40 or 40 No. Indian Oil - SERVO OIL No. 40

3.2 FEEDING OF OIL :

At the time of shipment oil has been drained completely from the machine so it must be filled with new oil by opening the top cover. (502114A)

3.3 OIL LEVEL :

Pour The oil and maintain the level of oil in tank by checking oil gauge (by dropping gauge in tank and lifting immediately to see) maintain level as per fig. 3 between maximum and minimum line every day.

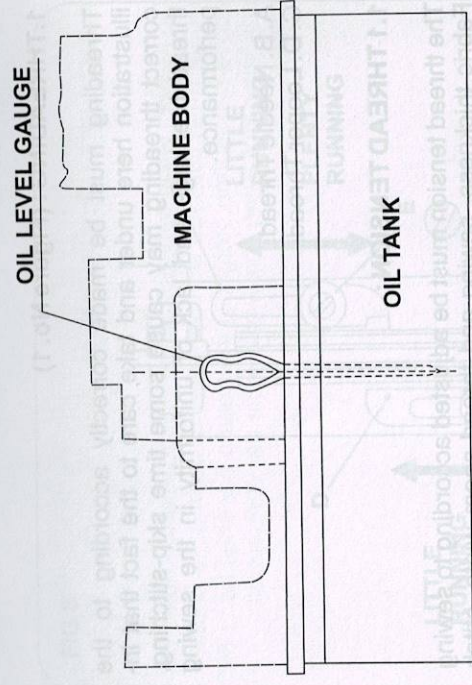
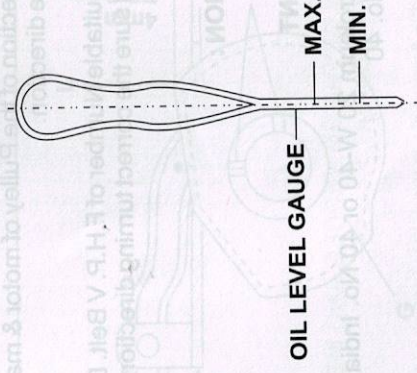


FIG 3



OIL LEVEL GAUGE

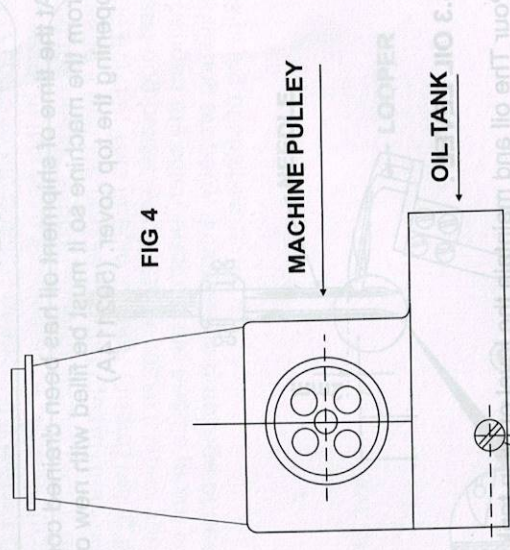


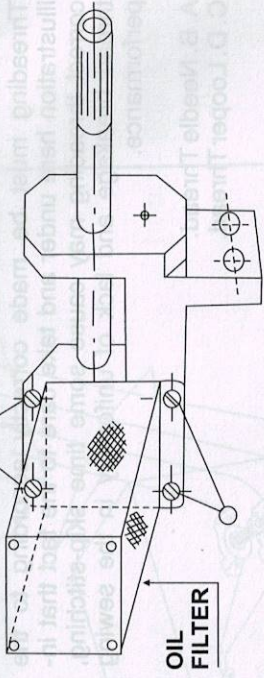
FIG 4

1.THREADING : (Figure No. 1)

Threading must be made correctly according to the illustration here under and take care to the fact that incorrect threading may cause some time skip-stitching, thread breakage and lack of uniformity in the sewing performance.

- A. B. Needle Thread.
- C. D. Looper Thread.

FIG 5



1.1 THREAD TENSION :

The thread tension must be adjusted according to sewing Fabric thickness, sewing and thread seam width, stitch length etc. Therefore the pressure of tension nuts of thread guides must be adjusted in each individual case.

2. ROTATIONAL DIRECTION :

Rotational Direction of the Pulley of motor & machine must be in clockwise direction.

NOTE : Use Suitable Number of F.H.P. V Belt. Do not run it before making sure the correct turning direction of motor.

3. LUBRICATION :

3.1 LUBRICANT

Hindustan Petroleum 20 W-40 or 40 No. Indian Oil - SERVO OIL No. 40

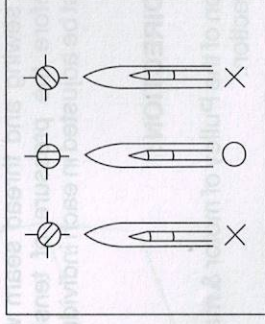
3.2 FEEDING OF OIL :

At the time of shipment oil has been drained completely from the machine so it must be filled with new oil by opening the top cover. (502114A)

3.3 OIL LEVEL :

Pour The oil and maintain the level of oil in tank by checking oil gauge (by dropping gauge in tank and lifting immediately to see) maintain level as per fig. 3 between maximum and minimum line every day.

FIG 6



3. LUBRICATION :

3.1 LUBRICANT

SERVO OIL No. 40
Hindustan Petroleum 20 W-40 or 40 No. Indian Oil -

3.2 FEEDING OF OIL :

At the time of shipment oil has been drained completely from the machine so it must be filled with new oil by opening the top cover. (502114A)

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ORGEN DR x 2 26NO

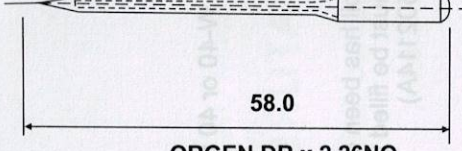
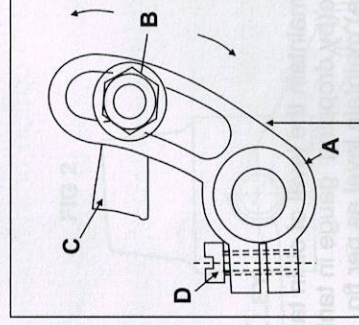


FIG 7



FEED BAR LEVER

8. TENSION OF LOOPER THREAD (FIGURE No : 8)

To get high quantity of thread move eyelet 'C' & 'D' towards operators' side by loosening 'E' & 'F' screw and move them to the rear side for smaller quantity of thread.

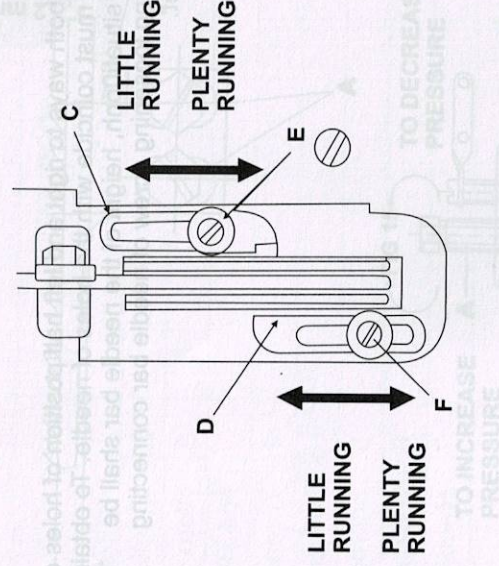


FIG 8

9. POSITIONING OF LOOPER THREAD TAKE UP (FIGURE No : 9)

1. The sketch shows looper thread take up (G) viewed from the side of Needle Bar.
2. The looper reaches the extreme left and of its movement then starts to return right direction just when looper thread take up will also start to take thread up.
3. At this time, the highest point (L) of the looper thread takes up (G) must positioned with the distance of 4mm to 5 mm above top face of thread eyelet plate (K)
4. To obtain richer quantity of thread in the taking positioning of the take-up (G) must be made earlier than the timing mentioned above. In this adjusting, the take-up must not be moved in right or left, to which please take care.

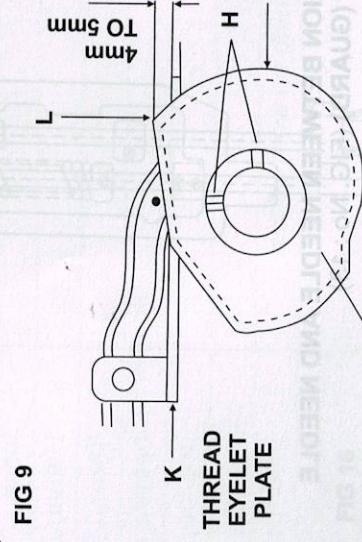


FIG 9

10. ADJUSTMENT OF LOOPER

As shown in the sketch here under movement scope (m) of looper means the distance between point of looper and center of rightmost needle. When the looper reaches extreme and of its movement to the right. When needle are at their lowest position & looper is at extreme right of the movement distance of looper point from center of needles shall be 4 mm & this adjustment is made by loosening screw (C).

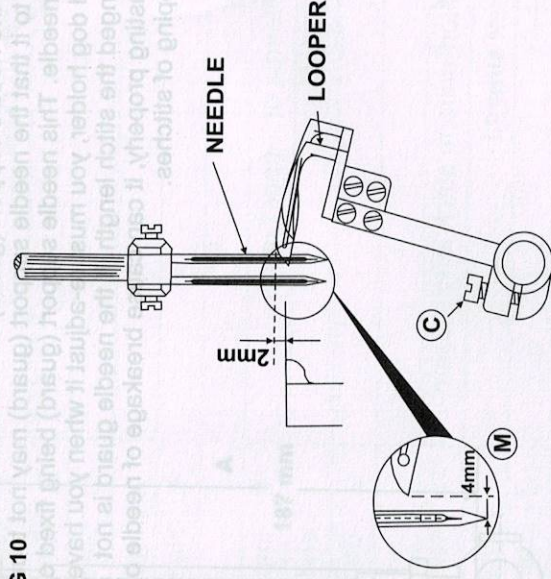
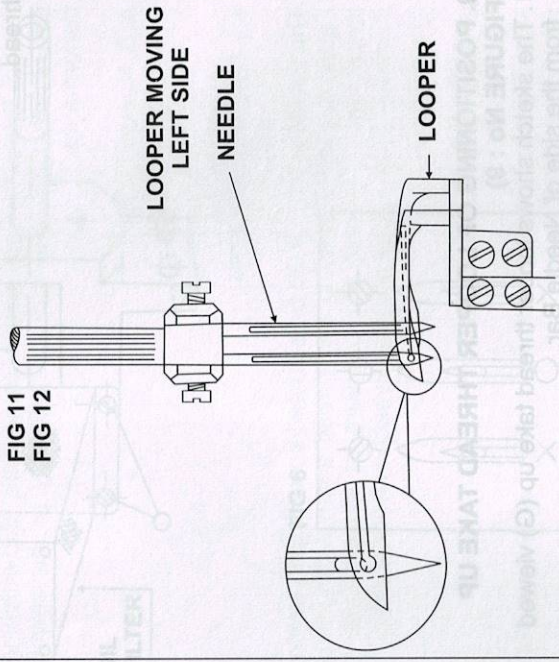


FIG 10

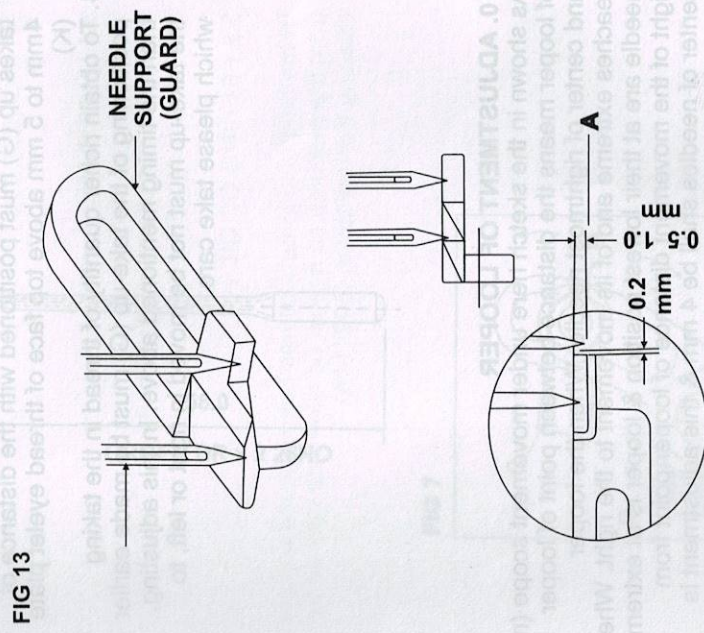
11/12 TIMING OF NEEDLE WITH LOOPER MOVING RIGHT/LEFT: (FIG. No : 11/12)

On its both ways to right and left half position of holes of looper must coincide with the holes of needle. To obtain above situation, height of the needle bar shall be adjusted loosening screw of needle bar connecting bracket.



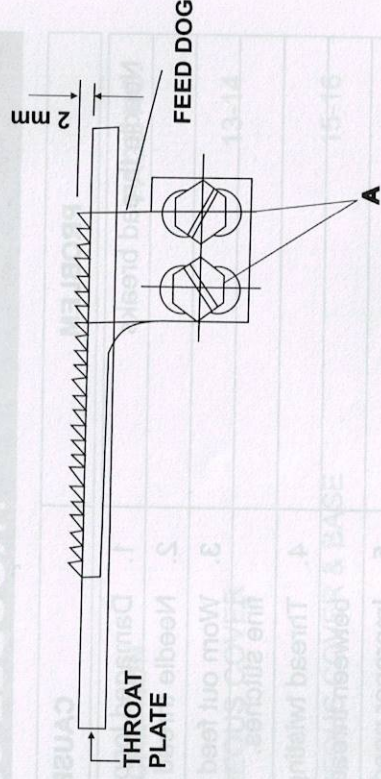
13. RELATION BETWEEN NEEDLE AND NEEDLE SUPPORT (GUARD) (FIG. No : 13)

Install the needle support (guard) so that the point 'A' may come to the position of about 0.5 mm to 1.0mm upward. In this case the clearance between the needle and the needle support (guard) should be 2.0 mm but see to it that the needle support (guard) may not touch the needle. This needle support (guard) being fixed on feed dog holder, you must re-adjust it when you have changed the stitch length. If the needle guard is not adjusting properly, it can cause breakage of needle or skipping of stitches.



14. ADJUSTMENT THE HEIGHT OF FEED DOG : FIG 16
(FIGURE No : 14)

Top faces of feed dog and throat plate shall be parallel when the feed dog is at its highest position. At this moment leveling top face the feed dog must be 2mm upper then throat plate. Height of the feed dog must be adjusted by screw 'A'.



15. ADJUSTING THE PRESSURE OF PRESSURE FOOT :

Pressure of pressure foot assembly is so adjusted that you material is fed at a constant and uniform speed. Pressure knob (A) turn clock wise to increase pressure and turn anti-clockwise to decrease it. Too heavy pressure will cause thread breaking etc. And too low pressure failure of thread chain, at end of material and also slips of bags.

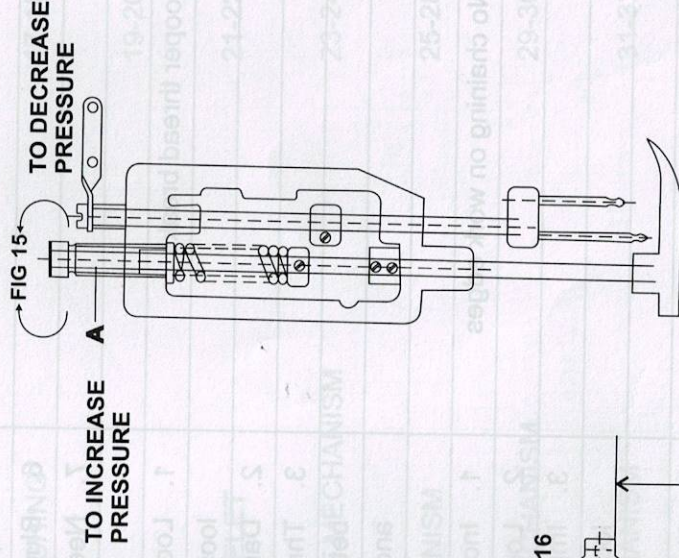


FIG 15

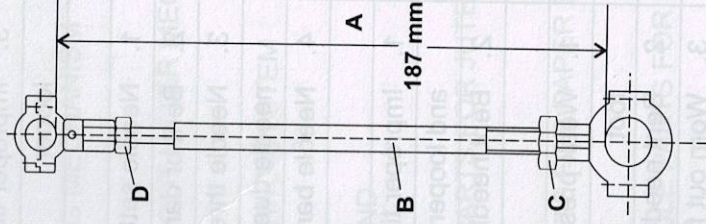


FIG 16

16. SETTING OF NEEDLE LEVER CONNECTING ROD ASSEMBLY :

Distance A must be kept 187 mm when adjusting Needle lever connecting Rod (B) with two nuts (C & D).

TROUBLE SHOOTING

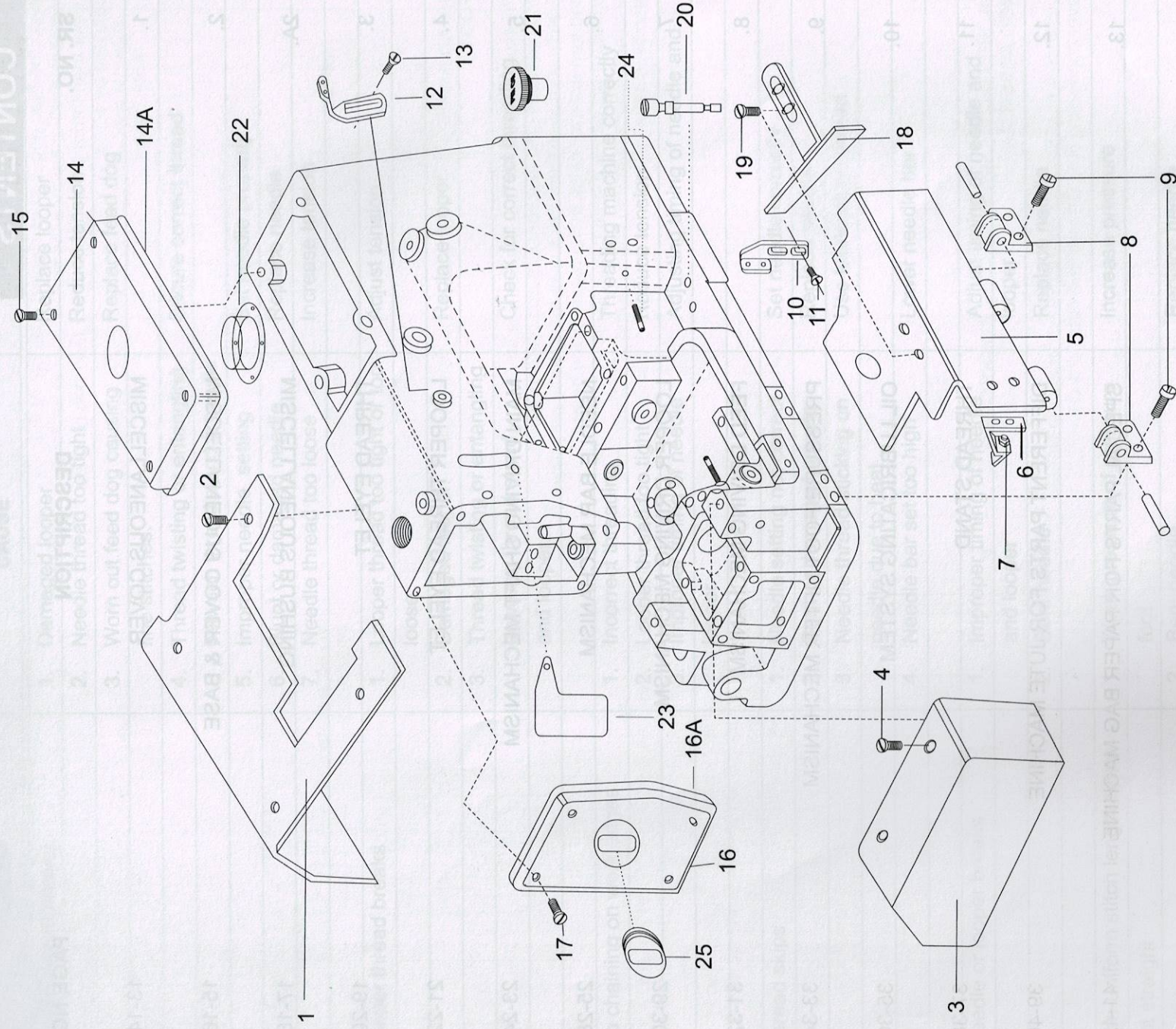
PROBLEM	CAUSE	SOLUTION
Needle thread breaks	1. Damaged loop	Replace loop
	2. Needle thread too tight	Reduce tension
	3. Worn out feed dog causing fine stitches.	Replace feed dog
	4. Thread twisting or entangling between thread stand & needle	Secure correct thread
	5. Improper needle setting	Set needle properly
	6. Blunt or damaged needle.	Replace needle
	7. Needle thread too loose	Increase tension
Looper thread breaks	1. Looper thread too tight or too loose.	Adjust tension
	2. Damaged looper.	Replace looper
	3. Thread twisting or entangling between thread stand and looper.	Check for correct threading
No chaining on work edges	1. Incorrect threading	Threading machine correctly
	2. Looper thread too tight	Reduce tension
	3. Improper timing of needle and looper	Adjusting timing of needle and
Thread skips	1. Needle setting not correct	Set needle correctly
	2. Bent or damaged needle	Replace needle
	3. Needle thread sticking on needle due to heat	Use lubricant on thread
	4. Needle bar set too high	Lower needle bar
Needle or looper breaks	1. Improper timing of needle and looper	Adjust timing of needle and looper
	2. Bent needle	Replace needle
Non-uniform stitch length seam not straight	1. Weak pressure of pressure foot	Increase pressure
	2. Bent needle	Replace needle
	3. Worn out feed dog.	Replace feed dog

ORDERING PARTS

CONTENTS

SR. NO.	DESCRIPTION	PAGE NO.
1.	MISCELLANEOUS COVER	13-14
2.	MISCELLANEOUS COVER & BASE	15-16
2A.	MISCELLANEOUS BUSHING	17-18
3.	THREAD EYELET	19-20
4.	LOOPER THREAD EYELET	21-22
5.	MAIN DRIVING SHAFT MECHANISM	23-24
6.	NEEDLE BAR MECHANISM	25-28
7.	LOOPER DRIVING MECHANISM	29-30
8.	FEED DRIVING MECHANISM	31-32
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13.	SPECIAL PARTS FOR PAPER BAG MACHINE	41-42
14.	SINGLE NEEDLE PARTS FOR R-18HS	43-44

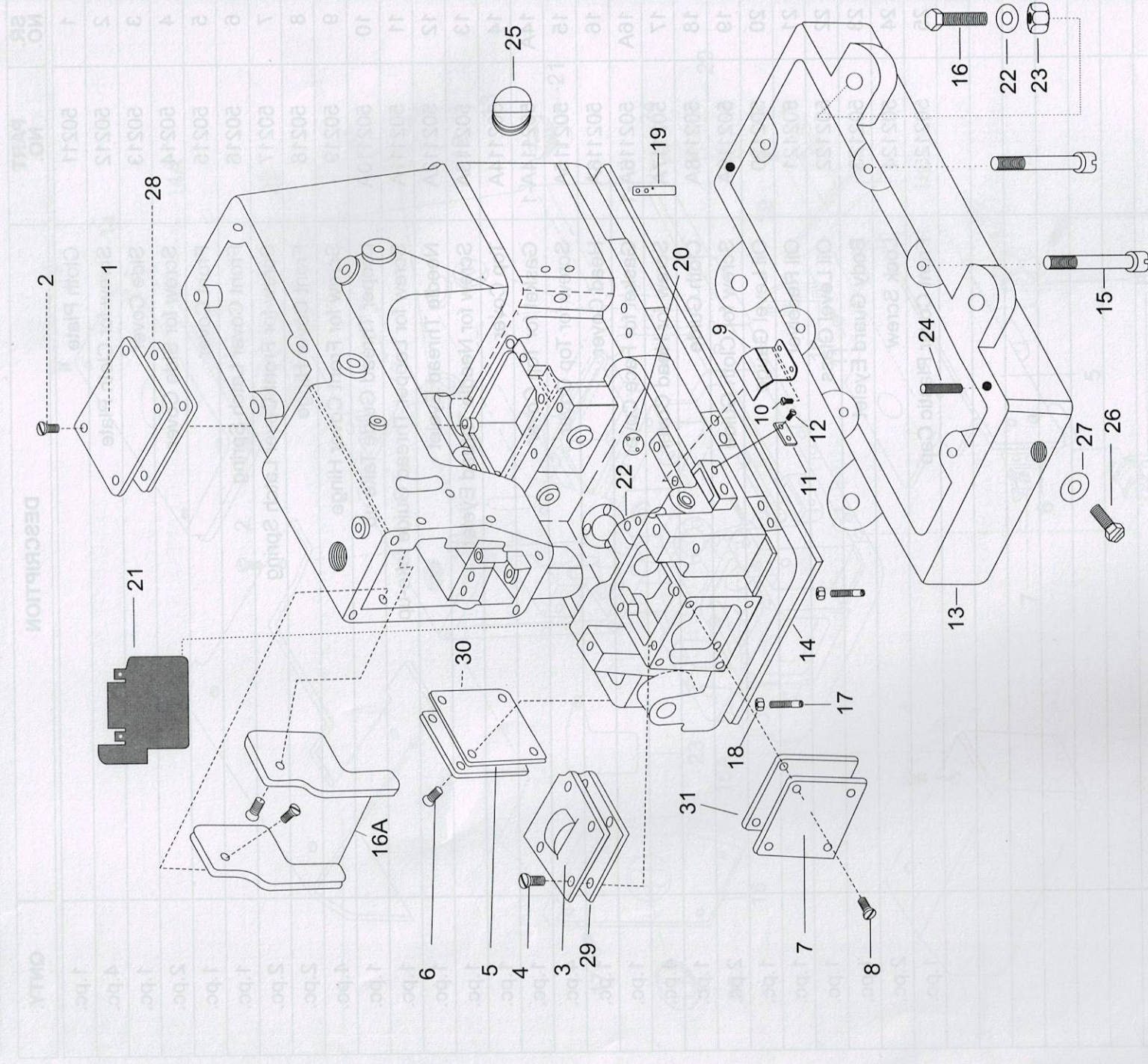
(1) MISCELLANEOUS COVER



(1) MISCELLANEOUS COVER

[illegible]

(2) MISCELLANEOUS COVER & BASE PARTS



(2)^o MISCELLANEOUS COVER & BASE PARTS

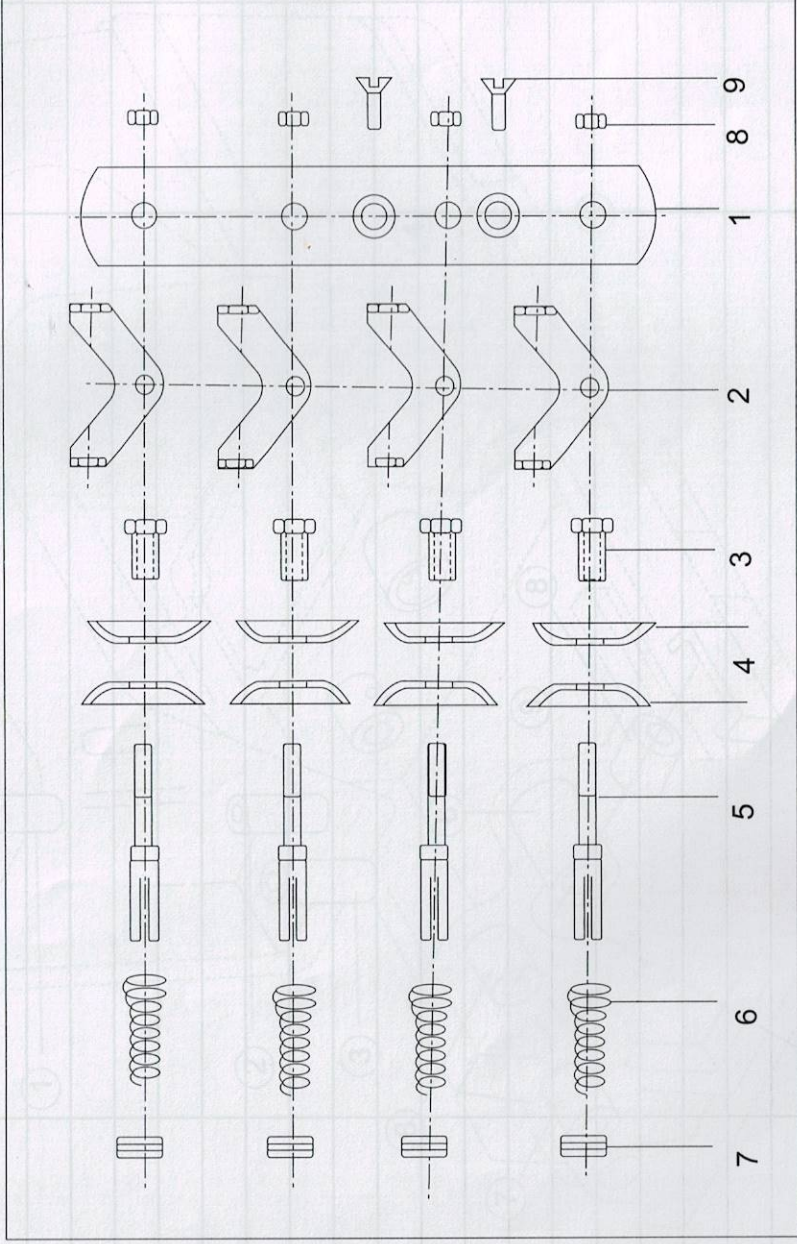
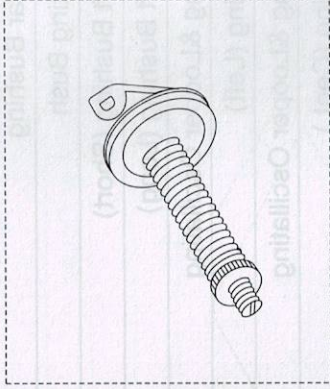
SR. NO.	PART NO.	DESCRIPTION	QNTY.
1	50221	Worm Chamber Cover	1.pc.
2	50222	Screw for Worm Chamber Cover	4.pc.
3	50223	Crank Chamber Cover	1.pc.
4	50224	Screw for Crank Chamber Cover	4.pc.
5	50225	Tail Cover	1.pc.
6	50226	Screw for Tail Cover	4.pc.
7	50227	Side Cover	1.pc.
8	50228	Screw for the Side Cover	4.pc.
9	50229	Feed Dog Driving Rod Front Cover	1.pc.
10	502210	Screw for Feed Dog Driving Rod front Cover	2.pc.
11	502211	Looper Holder Front Cover	1.pc.
12	502212	Screw for Looper Holder Front Cover	2.pc.
13	502213	Oil Tank	1.pc.
14	502214	Oil Tank Gasket	1.pc.
15	502215	Screw of Oil Tank	6.pc.
16	502216	Screw for Machine Foundation	4.pc.
16A	502216A	Gasket for Needle Bar	1.pc.
17	502217	Stud for Body Support	3.pc.
18	502218	Nut for Body Support Stud	3.pc.
19	502219	Eyelet for Body Support	1.pc.
20	502220	Oil Filter Screw	1.pc.
21	502221	Cover for Feed Dog Driving	1.pc.
22	502222	Washer for Machine Foundation	4.pc.
23	502223	Nut for Machine Foundation	4.pc.
24	502224	Pin for Oil Tank	2.pc.
25	502225	Stud Screw	1.pc.
26	502226	Oil Discharge Hex Bolt	1.pc.
27	502227	Washer for 502226	1.pc.
28	50221-1	Gasket for Worm Chamber Cover	1.pc.
29	50223-1	Gasket for Crank Chamber Cover	1.pc.
30	50225-1	Gasket for Tail Cover	1.pc.
31	50227-1	Gasket for Side Cover	1.pc.

(2A) MISCELLANEOUS BUSHING

NO. SR.	NO. PART	DESCRIPTION	QTY
1	805554	Worm Chamber Cover	1 pc.
5	805555	Screw for Worm Chamber Cover	4 pc.
3	805553	Worm Chamber Cover	1 pc.
4	805554	Worm Chamber Cover	4 pc.
6	805555	Screw for Tail Cover	4 pc.
7	805553	Worm Chamber Cover	1 pc.
8	805553	Worm Chamber Cover	4 pc.
9	805553	Worm Chamber Cover	1 pc.
10	805553	Worm Chamber Cover	3 pc.
11	805553	Worm Chamber Cover	1 pc.
12	805553	Worm Chamber Cover	3 pc.
13	805553	Worm Chamber Cover	1 pc.
14	805553	Worm Chamber Cover	1 pc.
15	805553	Worm Chamber Cover	3 pc.
16	805553	Worm Chamber Cover	1 pc.
17	805553	Worm Chamber Cover	3 pc.
18	805553	Worm Chamber Cover	1 pc.
19	805553	Worm Chamber Cover	3 pc.
20	805553	Worm Chamber Cover	1 pc.
21	805553	Worm Chamber Cover	1 pc.
22	805553	Worm Chamber Cover	1 pc.
23	805553	Worm Chamber Cover	1 pc.
24	805553	Worm Chamber Cover	1 pc.
25	805553	Worm Chamber Cover	1 pc.
26	805553	Worm Chamber Cover	1 pc.
27	805553	Worm Chamber Cover	1 pc.
28	805553	Worm Chamber Cover	1 pc.
29	805553	Worm Chamber Cover	1 pc.
30	805553	Worm Chamber Cover	1 pc.
31	805553	Worm Chamber Cover	1 pc.

(3) THREAD EYELET PARTS

QTY	DESCRIPTION	PART NO.	SR. NO.
1 pc	Needle Bar Bushing (Upper)	6032SA-1	1
1 pc	Needle Bar Bushing (Lower)	6032SA-2	2
1 pc	Pressure Bar Bushing	6032SA-3	3
1 pc	Oil Lubricator Bush	6032SA-4	4
1 pc	Crank Shaft Bushing (Port)	6032SA-5	5
1 pc	Crank Shaft Bushing (Star)	6032SA-6	6
2 pc	Feed Driving Shaft Bushing (Left)	6032SA-7	7
2 pc	Feed Driving Shaft Bushing (Right)	6032SA-8	8
1 pc	Feed Driving Shaft Bushing (Right)	6032SA-9	9

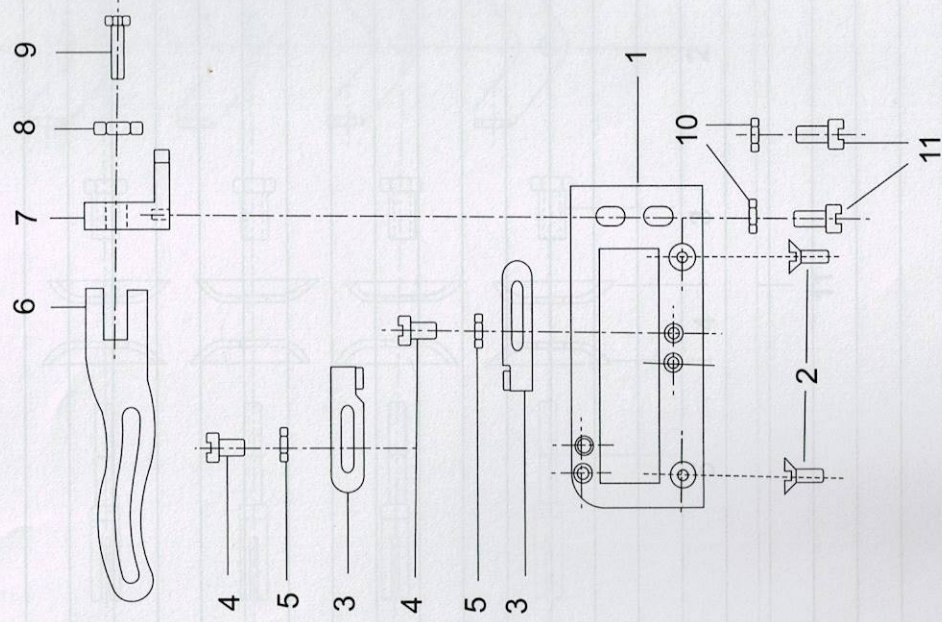
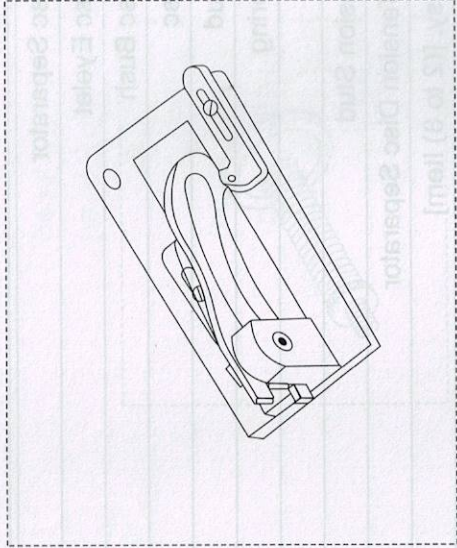


(3) THREAD EYELET PARTS

[illegible]

(4) LOOPER THREAD EYELET PARTS

QTY	DESCRIPTION	PART NO.	NO.
1 pc	Tension Disc Separator	202331	1
1 pc	Tension Disc Eyelid	202332	5
1 pc	Tension Disc Brush	202333	3
1 pc	Tension Disc	202334	4
1 pc	Tension Spring	202335	2
1 pc	Tension Spring	202336	6
1 pc	Nut for Tension Spring	202337	7
1 pc	Nut for Tension Spring	202338	8
1 pc	Screw for Tension Disc Separator	202339	9
1 pc	Tension Disc Separator (1 to 9) Item	202310	10
1 pc	Tension Unit Comp. Assy. (1 to 9)	202310AY	11



(4) LOOPER THREAD EYELET PARTS

[illegible]

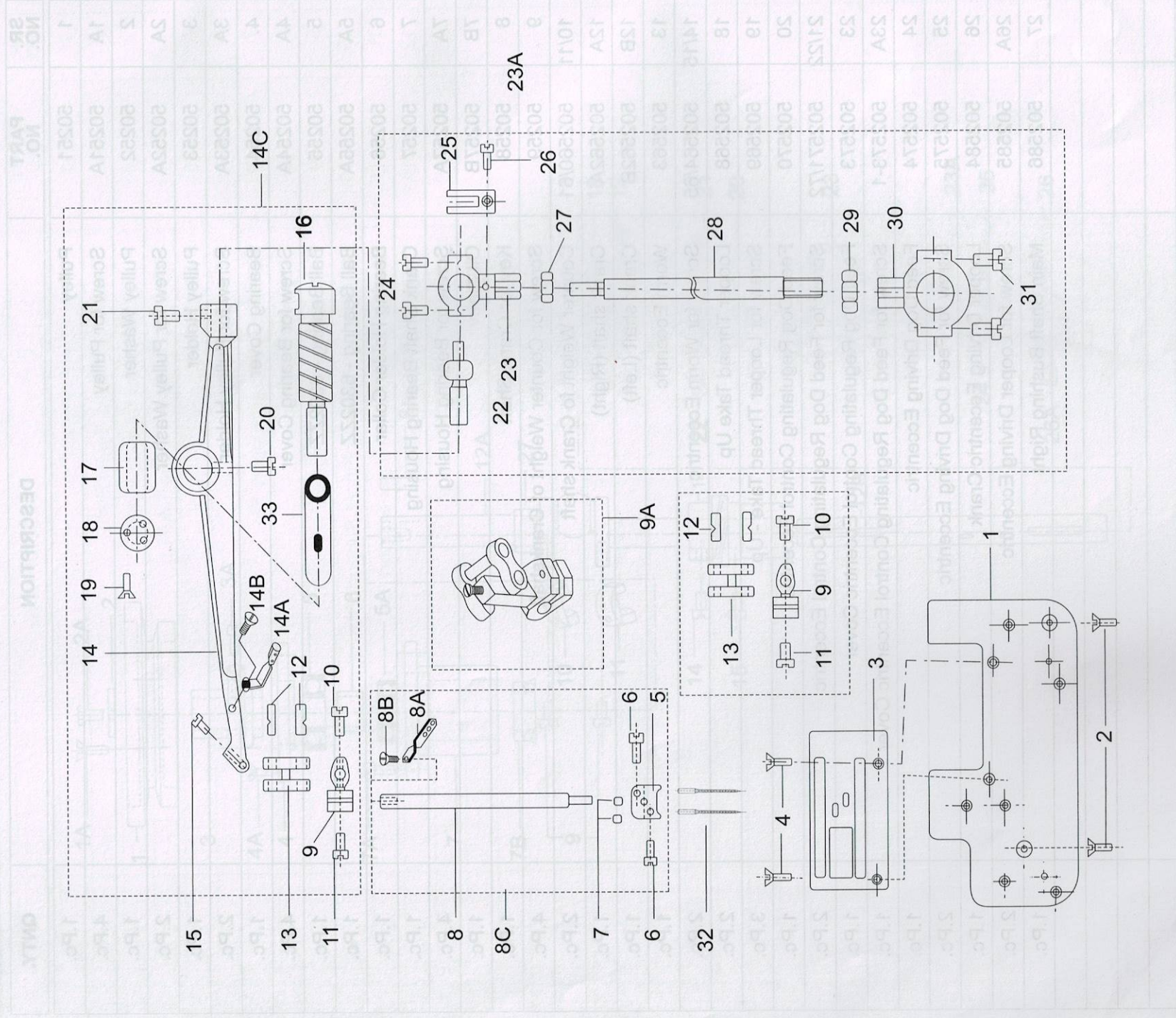
(5) MAIN DRIVING SHAFT MECHANISM

QTY	DESCRIPTION	NO. PART	NO. SR
1 pc	1A — 2A	202341	1
2 pc	1 — 2	202342	2
2 pc	1 — 3A	202343	3
2 pc	1 — 4	202344	4
2 pc	1 — 5	202345	5
1 pc	1 — 3A	202346	6
1 pc	1 — 4A	202347	7
1 pc	1 — 4	202348	8
1 pc	1 — 5	202349	9
2 pc	1 — 6	2023410	10
2 pc	1 — 5A	2023411	11
1 pc	1 — 8	2023412	12
	12A — 27		
	10 — 11		
	14 — 15		
	18 — 19		
	20 — 21		
	22 — 23		
	24 — 25		
	26A — 26		

(5) MAIN DRIVING SHAFT MECHANISM

SR. NO.	PART NO.	DESCRIPTION	QNTY.
1	50251	Pulley	1.Pc.
1A	50251A	Screw for Pulley	4.Pc.
2	50252	Pulley Washer	1.Pc.
2A	50252A	Screw for Pulley Washer	2.Pc.
3	50253	Pulley Holder	1.Pc.
3A	50253A	Screw for Pulley Holder	2.Pc.
4.	50254	Bearing Cover	1.Pc.
4A	50254A	Screw for Bearing Cover	4.Pc.
5	50255	Ball Bearing - 6302ZZ	1.Pc.
5A	50255A	Ball Bearing - 6302ZZ	1.Pc.
6	50256	Bearing Holder Collar	1.Pc.
7	50257	Crank Shaft Bearing Housing	1.Pc.
7A	50257A	Screw for Bearing Housing	4.Pc.
7B	50257B	Oil Sleeve	1.Pc.
8	50258	Key for Crank Shaft	1.Pc.
9	50259	Screw for Counter Weight of Crankshaft	4.Pc.
10/11	502560/61	Counter Weight fo Crank shaft	2.Pc.
12A	502562A	Crank shaft (Right)	1.Pc.
12B	502562B	Crank shaft (Left)	1.Pc.
13	502563	Worm Eccentric	1.Pc.
14/15	502564/65	Screw for Worm Eccentric	2.Pc.
18	502568	Looper Thread Take Up	2.Pc.
19	502569	Screw for Looper Thread Take - Up	3.Pc.
20	502570	Feed Dog Regulating Control Eccentric	1.Pc.
21/22	502571/72	Screw for Feed Dog Regulating Control Eccentric	2.Pc.
23	502573	Feed Dog Regulating Control Eccentric Cover	1.Pc.
23A	502573-1	Screw for Feed Dog Regulating Control Eccentric Cover	1.Pc.
24	502574	Feed Dog Driving Eccentric	1.Pc.
25	502575	Screw for Feed Dog Driving Eccentric	2.Pc.
26	502584	Looper Driving Eccentric Crank	1.Pc.
26A	502585	Screw for Looper Driving Eccentric	2.Pc.
27	502586	Main Shaft Bushing Right	1.Pc.

(6) NEEDLE BAR MECHANISM



(6) NEEDLE BAR MECHANISM

SR. NO.	PART NO.	DESCRIPTION	QNTY.
1	50261	Throat Plate Support	1.pc.
2	50262	Screw for Throat Plate Support	2.pc.
3	50263	Throat Plate	1.pc.
4	50264	Screw for Throat Plate	2.pc.
5	50265	Needle Holder	1.pc.
6	50266	Screw for Needle	2.pc.
7	50267	Screw for Needle Holder	2.pc.
8	50268	Needle Bar	1.pc.
8A	50268A	Needle Bar Thread Eyelet	1.pc.
8B	50268B	Screw for Needle Bar Thread Eyelet	1.pc.
8C	50268C-AY	Needle Bar with Needle Holder & Thread Eyelet (5-8)	1.Set.
9	50269	Needle Bar Connecting Bracket	1.pc.
9A	50269A-AY	Needle Bar Con. Bkt. With Link Set (9-13)	1.Set.
10	502670	Screw for Needle Bar Connecting Link	1.pc.
11	502671	Screw for Needle Bar Connecting Bkt.	1.pc.
12	502672	Needle Bar Connecting Link Pin	2.Pc.
13	502673	Needle Bar Connecting Link	1.Pc.
14	502674	Needle Bar Driving Crank Bkt.	1.Pc.
14A	502674A	Needle Thread Take Up	1.Pc.
14B	502674B	Screw for Needle Thread Take Up	1.Pc.
14C	502674C-AY	Needle Bar Driving Crank Bkt. Comp. Assy.	1.pc.
15	502675	Screw for Needle Bar Conn. Link Pin	1.Pc.
16	502676	Needle Bar Driving Bracket Shaft	1.Pc.
17	502677	Needle Bar Driving Bkt. Shaft Collar	1.Pc.
18	502678	Needle Bar Driving Bkt. Shaft Collar Washer	1.Pc.
19	502679	Screw for Needle Bar Driving Bkt. Shaft Collar	3.Pc.
20	502680	screw for Needle Bar Driving Bkt.	1.Pc.
21	502681	Screw for Ball Stud	1.Pc.
22	502682	Ball Stud (for N.B.B.)	1.Pc.
23	502683	Needle Lever Conn. Rod Bkt. Small	1.Pc.
23A	502683-AY	Needle Lever Conn. Rod Bkt. Assy. Comp (22-31)	1.Pc.
24	502684	Screw for Needle Lever Conn. Rod Bkt.	2.Pc.
25	502685	Ball Stud Guide (for N.B.B)	1.Pc.
26	502686	Screw for Ball Stud Guide	1.Pc.
27	502687	Nut for Needle Lever Connecting Rod (small)	1.Pc.

(6) NEEDLE BAR MECHANISM

QTY	DESCRIPTION	PART NO.	NO.
1 pc		203001	1
5 pc		203002	2
1 pc		203003	3
5 pc		203004	4
2 pc		203005	5
5 pc		203006	6
1 pc		203007	7
5 pc		203008	8
1 pc		203009	9
1 pc		203010	10
1 pc		203011	11
1 pc		203012	12
1 pc		203013	13
1 pc		203014	14
1 pc		203015	15
1 pc		203016	16
1 pc		203017	17
1 pc		203018	18
1 pc		203019	19
1 pc		203020	20
1 pc		203021	21
1 pc		203022	22
1 pc		203023	23
1 pc		203024	24
1 pc		203025	25
1 pc		203026	26
1 pc		203027	27
1 pc		203028	28
1 pc		203029	29
1 pc		203030	30
1 pc		203031	31
1 pc		203032	32
1 pc		203033	33
1 pc		203034	34
1 pc		203035	35
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1 pc		203038	38
1 pc		203039	39
1 pc		203040	40
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1 pc		203042	42
1 pc		203043	43
1 pc		203044	44
1 pc		203045	45
1 pc		203046	46
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1 pc		203062	62
1 pc		203063	63
1 pc		203064	64
1 pc		203065	65
1 pc		203066	66
1 pc		203067	67
1 pc		203068	68
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1 pc		203071	71
1 pc		203072	72
1 pc		203073	73
1 pc		203074	74
1 pc		203075	75
1 pc		203076	76
1 pc		203077	77
1 pc		203078	78
1 pc		203079	79
1 pc		203080	80
1 pc		203081	81
1 pc		203082	82
1 pc		203083	83
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1 pc		203086	86
1 pc		203087	87
1 pc		203088	88
1 pc		203089	89
1 pc		203090	90
1 pc		203091	91
1 pc		203092	92
1 pc		203093	93
1 pc		203094	94
1 pc		203095	95
1 pc		203096	96
1 pc		203097	97
1 pc		203098	98
1 pc		203099	99
1 pc		203100	100

(6) NEEDLE BAR MECHANISM

SR. NO.	PART NO.	DESCRIPTION	QNTY.
28	502688	Needle Lever Connecting (Long)	1.Pc.
29	502689	Nut for Needle Lever Conn. Rod (Big)	1.Pc.
30	502690	Needle Lever Conn. Rod Bkt. (Big)	1.Pc.
31	502691	Screw for Needle Lever Conn. Rod Bkt. (Big)	2.Pc.
32	502692	Needle DNX 1-25/26	2.Pc.
33	502693	Main Bush for H674	1.Pc.
1	502777	Screw for Looper Driving Lever	2 pc.
2	502778	Screw for Ball Stud	1 pc.
3	502779	Ball Stud for L.D.M.	1 pc.
4	502780	Looper Connecting Rod Complete	1 pc.
10A	502780A-AY	Looper Connecting Rod Comp. Set (9-16)	1 pc.
11	502781	Screw for Eccentric C.A.S. Rod Complete Set	4 pc.
12	502782	Ball Stud Guide L.D.M.	1 pc.
13	502783	Screw for Ball Stud SS Side	1 pc.
14	502784	Looper Driving Eccentric Crank	1.c.
15A	502785A-81	Screw for Looper Driving Ecc	2 pc.
17	502787	Looper Driving Shaft	1 pc.
17A	502787A-AY	Looper Driving Shaft Comp Assy (17-28)	1 Set
18	502788	Looper Link Holder	1 pc.
19A	502789A-51	Screw for Looper Link Holder	2 pc.
21	502791	Looper Driving Shaft Collar	1 pc.
22	502792	Screw for Looper Driving Shaft Collar	2 pc.
23	502793	Looper Link	1 pc.
24	502794	Looper Link Pin (short)	1 pc.
25	502795	Screw for Looper Link Pin (short)	2 pc.
26	502796	Screw for Looper Link Pin (short)	2 pc.
27	502797	Screw for Looper Link Pin (short)	2 pc.
28	502798	Screw for Looper Link Pin (short)	2 pc.
29	502799	Screw for Looper Link Pin (short)	2 pc.
30	502800	Screw for Looper Link Pin (short)	2 pc.
31	502801	Screw for Looper Link Pin (short)	2 pc.
32	502802	Screw for Looper Link Pin (short)	2 pc.
33	502803	Screw for Looper Link Pin (short)	2 pc.
34	502804	Screw for Looper Link Pin (short)	2 pc.
35	502805	Screw for Looper Link Pin (short)	2 pc.
36	502806	Screw for Looper Link Pin (short)	2 pc.
37	502807	Screw for Looper Link Pin (short)	2 pc.
38	502808	Screw for Looper Link Pin (short)	2 pc.
39	502809	Screw for Looper Link Pin (short)	2 pc.
40	502810	Screw for Looper Link Pin (short)	2 pc.
41	502811	Screw for Looper Link Pin (short)	2 pc.
42	502812	Screw for Looper Link Pin (short)	2 pc.
43	502813	Screw for Looper Link Pin (short)	2 pc.
44	502814	Screw for Looper Link Pin (short)	2 pc.
45	502815	Screw for Looper Link Pin (short)	2 pc.
46	502816	Screw for Looper Link Pin (short)	2 pc.
47	502817	Screw for Looper Link Pin (short)	2 pc.
48	502818	Screw for Looper Link Pin (short)	2 pc.
49	502819	Screw for Looper Link Pin (short)	2 pc.
50	502820	Screw for Looper Link Pin (short)	2 pc.
51	502821	Screw for Looper Link Pin (short)	2 pc.
52	502822	Screw for Looper Link Pin (short)	2 pc.
53	502823	Screw for Looper Link Pin (short)	2 pc.
54	502824	Screw for Looper Link Pin (short)	2 pc.
55	502825	Screw for Looper Link Pin (short)	2 pc.
56	502826	Screw for Looper Link Pin (short)	2 pc.
57	502827	Screw for Looper Link Pin (short)	2 pc.
58	502828	Screw for Looper Link Pin (short)	2 pc.
59	502829	Screw for Looper Link Pin (short)	2 pc.
60	502830	Screw for Looper Link Pin (short)	2 pc.
61	502831	Screw for Looper Link Pin (short)	2 pc.
62	502832	Screw for Looper Link Pin (short)	2 pc.
63	502833	Screw for Looper Link Pin (short)	2 pc.
64	502834	Screw for Looper Link Pin (short)	2 pc.
65	502835	Screw for Looper Link Pin (short)	2 pc.
66	502836	Screw for Looper Link Pin (short)	2 pc.
67	502837	Screw for Looper Link Pin (short)	2 pc.
68	502838	Screw for Looper Link Pin (short)	2 pc.
69	502839	Screw for Looper Link Pin (short)	2 pc.
70	502840	Screw for Looper Link Pin (short)	2 pc.
71	502841	Screw for Looper Link Pin (short)	2 pc.
72	502842	Screw for Looper Link Pin (short)	2 pc.
73	502843	Screw for Looper Link Pin (short)	2 pc.
74	502844	Screw for Looper Link Pin (short)	2 pc.
75	502845	Screw for Looper Link Pin (short)	2 pc.
76	502846	Screw for Looper Link Pin (short)	2 pc.
77	502847	Screw for Looper Link Pin (short)	2 pc.
78	502848	Screw for Looper Link Pin (short)	2 pc.
79	502849	Screw for Looper Link Pin (short)	2 pc.
80	502850	Screw for Looper Link Pin (short)	2 pc.
81	502851	Screw for Looper Link Pin (short)	2 pc.
82	502852	Screw for Looper Link Pin (short)	2 pc.
83	502853	Screw for Looper Link Pin (short)	2 pc.
84	502854	Screw for Looper Link Pin (short)	2 pc.
85	502855	Screw for Looper Link Pin (short)	2 pc.
86	502856	Screw for Looper Link Pin (short)	2 pc.
87	502857	Screw for Looper Link Pin (short)	2 pc.
88	502858	Screw for Looper Link Pin (short)	2 pc.
89	502859	Screw for Looper Link Pin (short)	2 pc.
90	502860	Screw for Looper Link Pin (short)	2 pc.
91	502861	Screw for Looper Link Pin (short)	2 pc.
92	502862	Screw for Looper Link Pin (short)	2 pc.
93	502863	Screw for Looper Link Pin (short)	2 pc.
94	502864	Screw for Looper Link Pin (short)	2 pc.
95	502865	Screw for Looper Link Pin (short)	2 pc.
96	502866	Screw for Looper Link Pin (short)	2 pc.
97	502867	Screw for Looper Link Pin (short)	2 pc.
98	502868	Screw for Looper Link Pin (short)	2 pc.
99	502869	Screw for Looper Link Pin (short)	2 pc.
100	502870	Screw for Looper Link Pin (short)	2 pc.

(7) LOOPER DRIVING MECHANISM

[illegible]

(7) LOOPER DRIVING MECHANISM

[illegible]

(8) FEED DRIVING MECHANISM

NO.	QTY	DESCRIPTION	NO.	QTY	DESCRIPTION
1	1	1	14	1	14
2	2	2	15	1	15
3	3	3	16	1	16
4	4	4	17	1	17
5	5	5	18	1	18
6	6	6	19	1	19
7	7	7	20	1	20
8	8	8	21	1	21
9	9	9	22	1	22
10	10	10	23	1	23
11	11	11	24	1	24
12	12	12	25	1	25
13	13	13	26	1	26
14	14	14	26A	1	26A
15	15	15	27	1	27
16	16	16	28	1	28
17	17	17	29	1	29
18	18	18	30	1	30
19	19	19	31	1	31
20	20	20	32	1	32
21	21	21			
22	22	22			
23	23	23			
24	24	24			
25	25	25			
26	26	26			
27	27	27			
28	28	28			
29	29	29			
30	30	30			
31	31	31			
32	32	32			

(8) FEED DRIVING MECHANISM

SR. NO.	PART NO.	DESCRIPTION	QNTY.
1	50281	Feed Bar Bracket	1.Pc.
1A	50281A-AY	Feed Bar Bracket	1.Set
2	50282	Feed Dog	1.Pc.
3	50283	Screw for Feed Dog	2.Pc.
4	50284	Needle Support (Guard)	1.Pc.
5	50285	Screw for Needle Support (Guard)	2.Pc.
6	50286	Feed Dog Driving Lever Link Pin	1.Pc.
7	50287	Screw for Feed Dog Driving Lever Link Pin	1.Pc.
8	50288	Feed Dog Driving Lever	1.Pc.
9	50289	Feed Bar	1.Pc.
9A	50289A-AY	Feed Bar Comp. (9 to 11)	1.Set
10	502810	Feed Bar Pin	1.Pc.
11	502811	Screw for Feed Bar Pin	2.Pc.
12	502812	Feed Bar Shaft Collar	2.Pc.
13	502813	Screw for Feed Bar Shaft Collar	2.Pc.
14	502814	Feed Bar Lever	1.Pc.
15	502815	Screw for Feed Bar Lever	2.Pc.
16	502816	Feed Dog Driving Conn. Rod Pin	1.Pc.
17	502817	Washer for Feed Dog Conn. Rod Pin	1.Pc.
18	502818	Nut for Feed Dog Conn. Rod Pin	1.Pc.
19	502819	Feed Bar Shaft	1.Pc.
20	502820	Looper Driving Lever	1.Pc.
21	502821	Screw for Looper Driving Lever	2.Pc.
22	502822	Looper Driving Lever Link Pin	1.Pc.
23	502823	Screw for Looper Driving Lever Link Pin	1.Pc.
24	502824	Looper Oscillating Rod	1.Pc.
25	502825	Ball Bearing	2.Pc.
26	502826	Feed Dog Driving Conn. Rod	1.Pc.
24A	502827AY	Looper Oscillating Rod Assy. (20-25)	1.Pc.
26A	502828AY	Feed Dog Driving Conn. Rod Assy	1.Pc.
27	502829	Bush for H81	1.Pc.
28	502830	Bush for H826	1.Pc.
29	502831	Feed Bar Coller Ring	1.Pc.
30	502832	Packing for Feed Dog	1.Pc.
31	502833	Coller Ring for H819	1.Pc.
32	502834	Gasket for Feed Bar Assy	1.Pc.

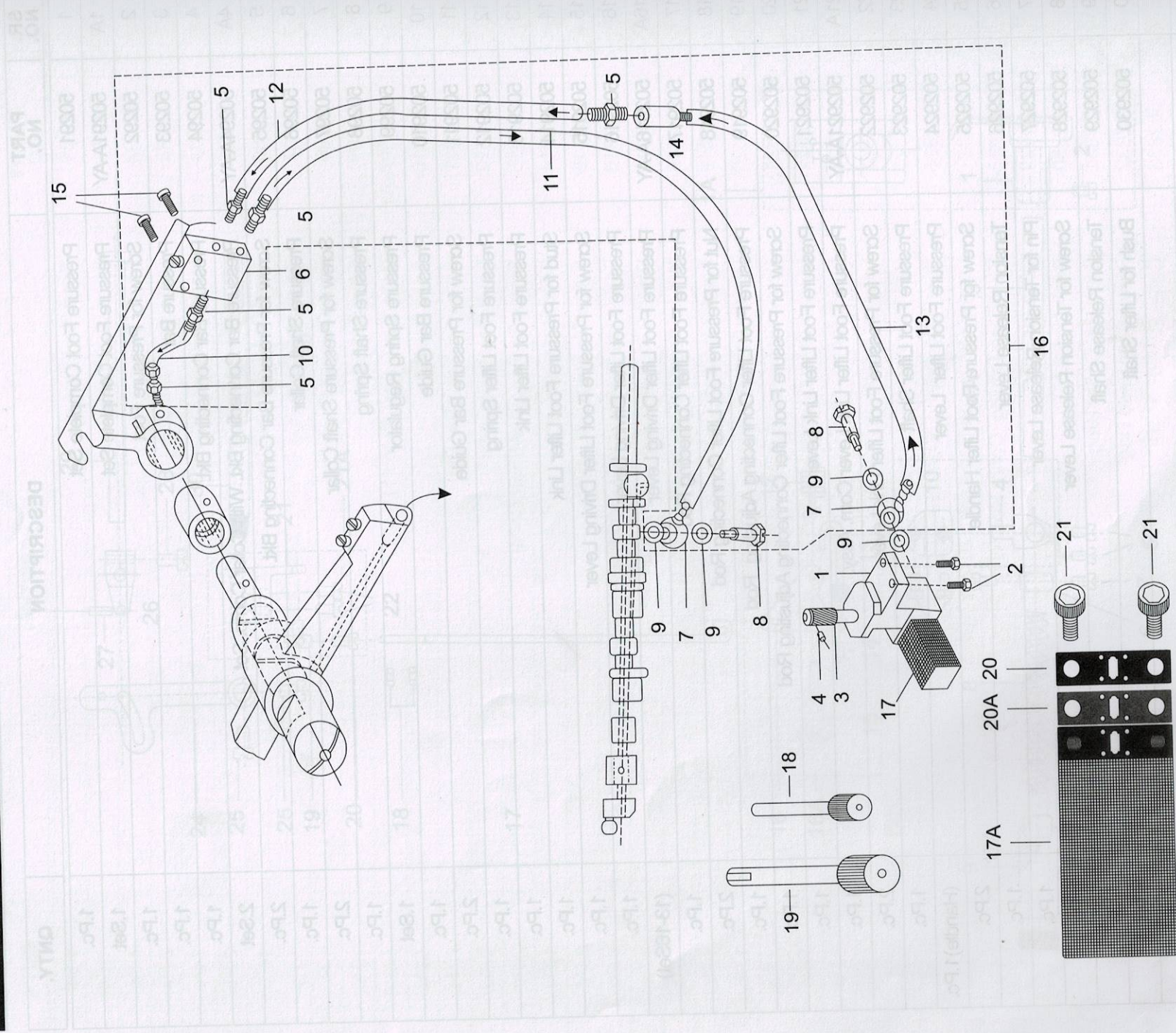
(9) PRESSURE FOOT LIFTER MECHANISM

NO.	DESCRIPTION	QTY
1	Feed Bar Blacket	1 pc
1A	Feed Bar Blacket	1 pc
2	Feed Bar Blacket	1 pc
3	Screw for Feed Dog	2 pc
4	Needle Subhody (Gun)	1 pc
5	Feed Dog Driving Lever Link Pin	1 pc
6	Feed Dog Driving Lever Link Pin	1 pc
7	Screw for Feed Dog Driving Lever Link Pin	1 pc
8	Feed Dog Driving Lever Link Pin	1 pc
9	Feed Dog Driving Lever Link Pin	1 pc
10	Feed Bar Comp. (9 to 11)	1 pc
11	Feed Bar Pin	1 pc
12	Screw for Feed Bar Pin	1 pc
13	Feed Bar Pin	1 pc
14	Screw for Feed Bar Pin	1 pc
15	Feed Bar Pin	1 pc
16	Feed Bar Pin	1 pc
17	Feed Bar Pin	1 pc
18	Feed Bar Pin	1 pc
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95	Feed Bar Pin	1 pc
96	Feed Bar Pin	1 pc
97	Feed Bar Pin	1 pc
98	Feed Bar Pin	1 pc
99	Feed Bar Pin	1 pc
100	Feed Bar Pin	1 pc

(9) PRESSURE FOOT LIFTER MECHANISM

SR. NO.	PART NO.	DESCRIPTION	QNTY.
1	50291	Pressure Foot Complete Set	1.Pc.
1A	50291A-AY	Pressure Foot Complete Set	1.Set
2	50292	Screw for Pressure Foot	1.Pc.
3	50293	Pressure Bar	1.Pc.
4	50294	Pressure Bar Connecting Bkt.	1.Pc.
4A	50294A-AY	Pressure Bar Connecting Bkt. With Collar Comp. Set	1.Pc.
5	50295	Screw for Pressure Bar Connecting Bkt.	2.Set
6	50296	Pressure Shaft Collar	2.Pc.
7	50297	Screw for Pressure Shaft Collar	1.Pc.
8	50298	Pressure Shaft Spring	2.Pc.
9	50299	Pressure Spring Regulator	1.Pc.
10	502910	Pressure Bar Guide	1.Set
11	502911	Screw for Pressure Bar Guide	1.Pc.
12	502912	Pressure Foot Lifter Spring	2.Pc.
13	502913	Pressure Foot Lifter Link	1.Pc.
14	502914	Stud for Pressure Foot Lifter Link	1.Pc.
15	502915	Screw for Pressure Foot Lifter Driving Lever	1.Pc.
16	502916	Pressure Foot Lifter Driving Lever	1.Pc.
16A	502916A-AY	Pressure Foot Lifter Driving Lever	1.Pc.
17	502917	Pressure Foot Lifter Connecting Rod	(13-16Set)
18	502918	Nut for Pressure Foot Lifter Connecting Rod	1.Pc.
19	502919	Pressure Foot Lifter Connecting Adjusting Rod	2.Pc.
20	502920	Screw for Pressure Foot Lifter Connecting Adjusting Rod	1.Pc.
21	502921	Pressure Foot Lifter Link Lever	1.Pc.
21A	502921A-AY	Pressure Foot Lifter Link Lever Com. Assy.	1.Pc.
22	502922	Screw for Pressure Foot Lifter Link Lever	1.Pc.
23	502923	Pressure Foot Lifter Shaft	2.Pc.
24	502924	Pressure Foot Lifter Lever	1.Pc.
25	502925	Screw for Pressure Foot Lifter Handle	(Handle) 1.Pc.
26	502926	Tension Release Lever	2.Pc.
27	502927	Pin for Tension Release Lever	1.Pc.
28	502928	Screw for Tension Release Lever	1.Pc.
29	502929	Tension Release Shaft	1.Pc.
30	502930	Bush for Lifter Shaft	1.Pc.

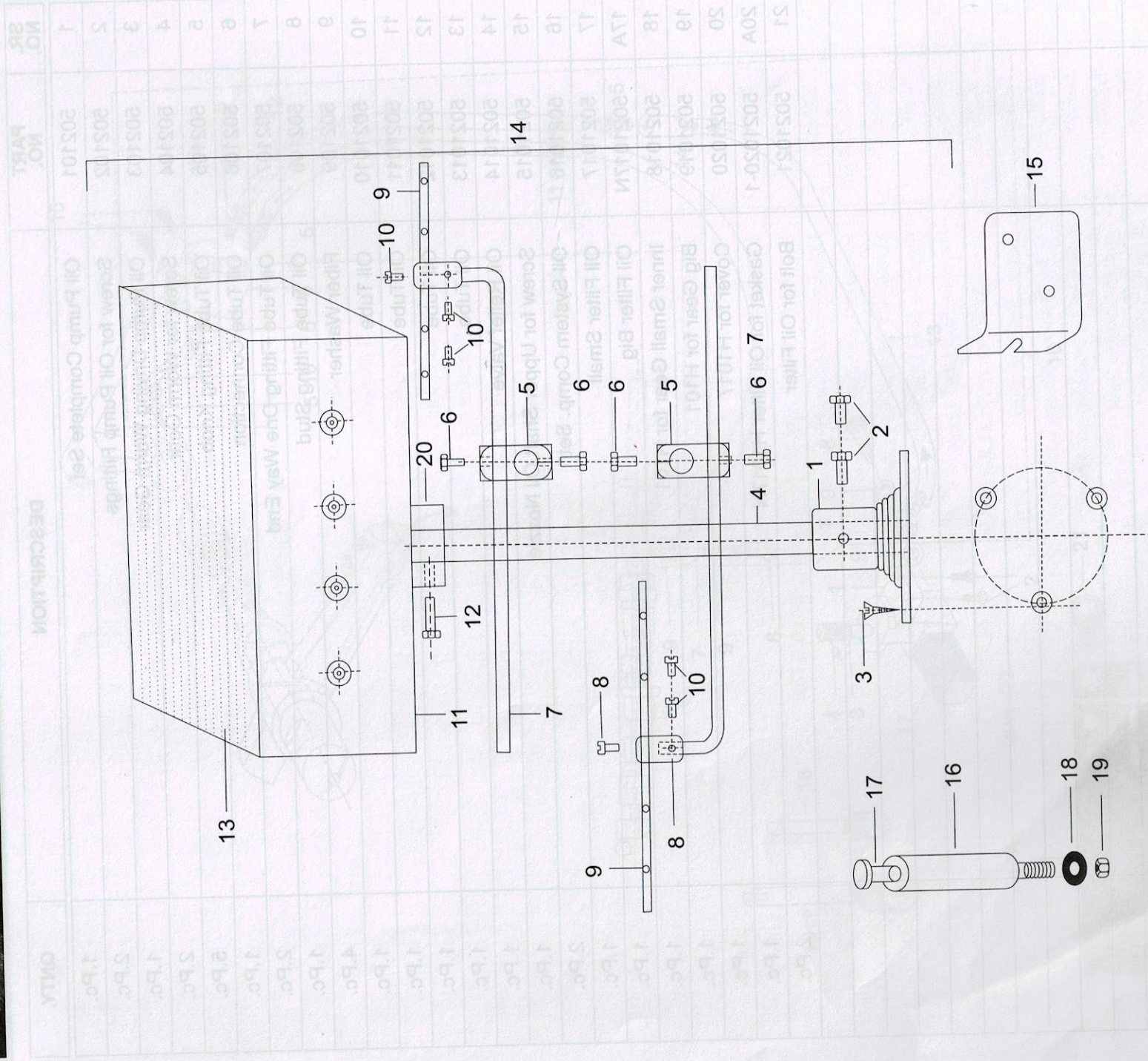
(10) OIL LUBRICATING SYSTEM



(10) OIL LUBRICATING SYSTEM

[illegible]

(11) THREAD STAND

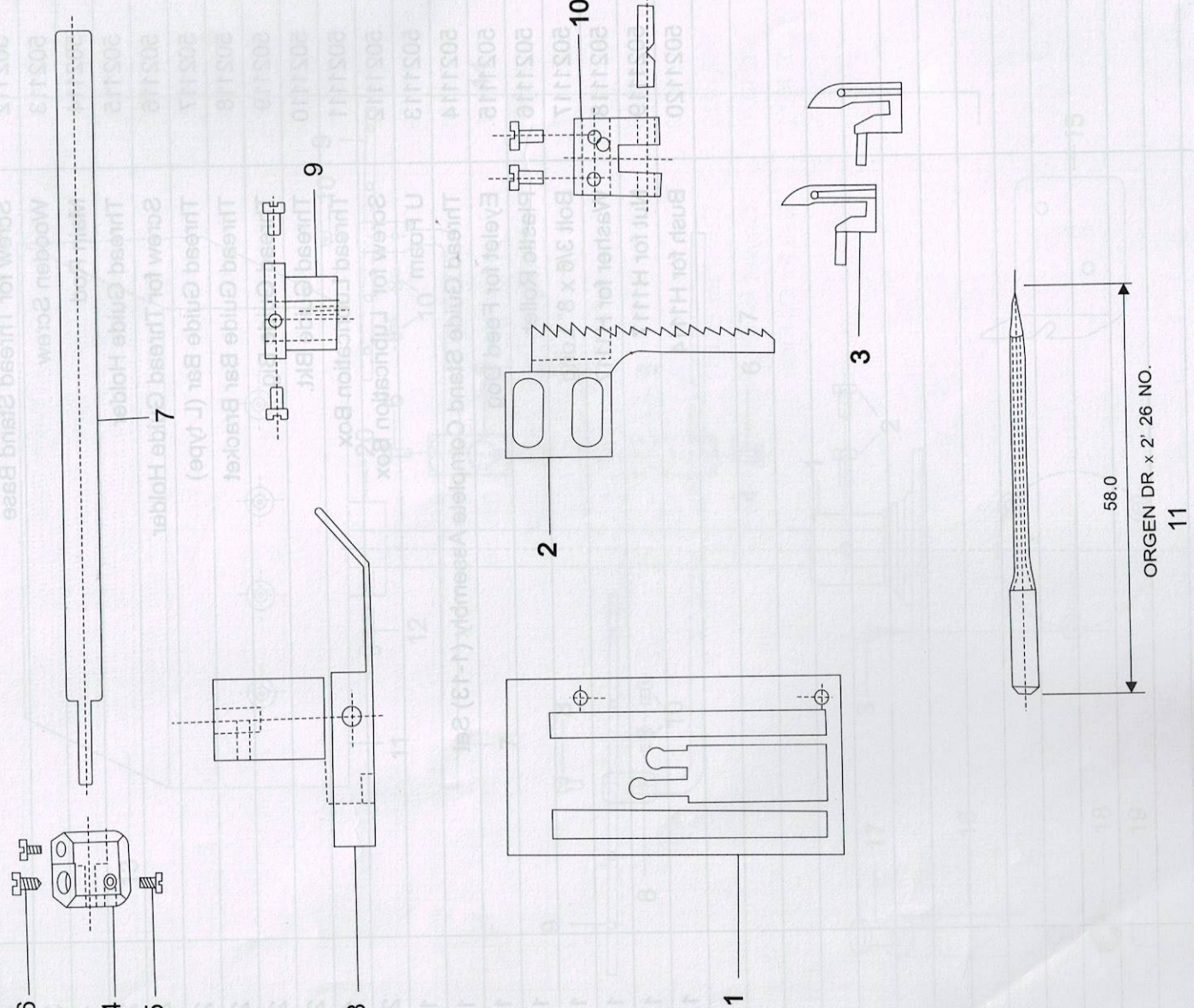


(11) THREAD STAND

[illegible]

(12) DIFFERENT PARTS FOR JUTE MACHINE

SER. NO.	PART NO.	DESCRIPTION	QTY.
1	502111	Thread Stand Base	1 pc
2	502112	Screw for Thread Stand Base	3 pc
3	502113	Wooden Screw	1 pc
4	502114	Thread Guide Holder	1 pc
5	502115	Screw for Thread Guide Holder	1 pc
6	502116	Thread Guide Bar (L type)	5 pc
7	502117	Thread Guide Bar Bracket	5 pc
8	502118	Thread Guide Bar (L type)	5 pc
9	502119	Thread Guide Bar Bracket	5 pc
10	502120	Thread Guide Bar (L type)	5 pc
11	502121	Thread Guide Bar Bracket	5 pc
12	502122	Thread Guide Bar (L type)	5 pc
13	502123	Thread Guide Bar Bracket	5 pc
14	502124	Thread Guide Bar (L type)	5 pc
15	502125	Thread Guide Bar Bracket	5 pc
16	502126	Thread Guide Bar (L type)	5 pc
17	502127	Thread Guide Bar Bracket	5 pc
18	502128	Thread Guide Bar (L type)	5 pc
19	502129	Thread Guide Bar Bracket	5 pc
20	502130	Thread Guide Bar (L type)	5 pc
21	502131	Thread Guide Bar Bracket	5 pc
22	502132	Thread Guide Bar (L type)	5 pc
23	502133	Thread Guide Bar Bracket	5 pc
24	502134	Thread Guide Bar (L type)	5 pc
25	502135	Thread Guide Bar Bracket	5 pc
26	502136	Thread Guide Bar (L type)	5 pc
27	502137	Thread Guide Bar Bracket	5 pc
28	502138	Thread Guide Bar (L type)	5 pc
29	502139	Thread Guide Bar Bracket	5 pc
30	502140	Thread Guide Bar (L type)	5 pc
31	502141	Thread Guide Bar Bracket	5 pc
32	502142	Thread Guide Bar (L type)	5 pc
33	502143	Thread Guide Bar Bracket	5 pc
34	502144	Thread Guide Bar (L type)	5 pc
35	502145	Thread Guide Bar Bracket	5 pc
36	502146	Thread Guide Bar (L type)	5 pc
37	502147	Thread Guide Bar Bracket	5 pc
38	502148	Thread Guide Bar (L type)	5 pc
39	502149	Thread Guide Bar Bracket	5 pc
40	502150	Thread Guide Bar (L type)	5 pc
41	502151	Thread Guide Bar Bracket	5 pc
42	502152	Thread Guide Bar (L type)	5 pc
43	502153	Thread Guide Bar Bracket	5 pc
44	502154	Thread Guide Bar (L type)	5 pc
45	502155	Thread Guide Bar Bracket	5 pc
46	502156	Thread Guide Bar (L type)	5 pc
47	502157	Thread Guide Bar Bracket	5 pc
48	502158	Thread Guide Bar (L type)	5 pc
49	502159	Thread Guide Bar Bracket	5 pc
50	502160	Thread Guide Bar (L type)	5 pc



(13) SPECIAL PARTS FOR PAPER BAG MACHINE

NO. SR.	PART NO.	DESCRIPTION	QTY
1	20321121	Throat Flange	1 No
2	20321122	Feed Dog	1 No
3	20321123	Looper	2 Pcs
4	20321124	Needle Holder	1 No
5	20321125	Screw for Needle Holder	1 No
6	20321126	Screw for Needle Holder	2 Pcs
7	20321127	Needle	2 Pcs
8	20321128	Pressure Foot	1 No
9	20321129	Feed Dog Pressure Control Ecc	1 No
10	20321130	Looper Drive Ecc	1 No
11	20321131	Needle	2 Pcs
12	20321132	Needle Holder	1 No
13	20321133	Pressure Foot	1 No
14	20321134	Feed Dog Pressure Control Ecc	1 No

(13) SPECIAL PARTS FOR PAPER BAG MACHINE

[illegible]

(14) SINGLE NEEDLE PARTS FOR R-18HS

QTY.	DESCRIPTION	NO. PART	NO. SR.
1 No.		1	1
1 No.		2	2
2 Pcs.		3	3
1 No.		4	4
1 No.		5	5
2 Pcs.		6	6
1 No.		7	7
1 No.		8	8
1 No.		9	9
1 No.		10	10
2 Pcs.		11	11
1 No.		12	12
1 No.		13	13
1 No.		14	14

(14) SINGLE NEEDLE PARTS FOR R-18HS

[illegible]

LIST OF ACCESSORIES FOR REVO BAG SEWING MACHINE **MODEL R-18HD**

1. Thread Guide Stand With oil Tank Complete Set 1 (with 4 Rubber Base)
2. Feed Dog 1 Pc.
3. Looper 1Set
4. Needle 4 Pc.
5. Scissor 1Pc.
6. Screw Driver 2 Pc. (Small / Large)
7. Spanner 8x9 Number 1Pc.
8. Spanner 10x11 Number 1 Pc.
9. Booklet 1Pc.
10. Oil Cane 1 Pc.
11. Brush 1 Pc.