

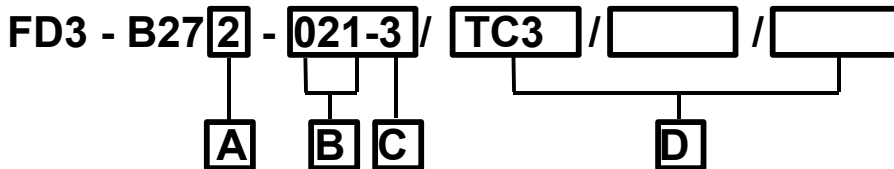
FD4-B271 B272

Flat bed bottom covering stitcher

Flat bed top and bottom covering stitcher



Specifications



A	Model
1	Bottom covering stitcher
2	Top and bottom covering stitcher

























B	Specifications
011	Plain stitching
021	Tape attaching
031	Covering
071	Elastic lace attaching (With top metering and edge trimming device)
075	Elastic lace attaching (With pulse motor drive top metering and edge trimming device)
OT1	Belt loop sewing (For thin and medium materials)
OT2	Belt loop sewing (For heavy materials)
OU1	Belt loop sewing with front cutter (For thin and medium materials)
OU2	Belt loop sewing with front cutter (For heavy materials)






C	No. of needles / Needle gauge
1	2 needles 3.2 mm
2	2 needles 4.0 mm
3	2 needles 4.8 mm
4	2 needles 5.6 mm
5	2 needles 6.4 mm
6	3 needles 4.8 mm
7	3 needles 5.6 mm
8	3 needles 6.4 mm

D	Device
	No accessories
TC1	Air-type tape cutter
TC3	Solenoid-type tape cutter
ATC1	Automatic tape cutter (Stitch number type)
CH1	Air-type chain cutter
CH2	Bacuum-type chain cutter
TFV	Automatic tape feeder (Vertical)
TFH	Automatic tape feeder (Horizontal)
PM1	Pulse motor drive top metering device

* Included in -075 specification. PM1 can not be

Specifications

Sub-class	Application	2-Needle			3-Needle		
		Gauge No.	Stitch pattern		Gauge No.	Stitch pattern	
			B271	B272		B271	B272
-011	Plain stitching	-1 -2 -3 -4 -5			-6 -7 -8		
-021	Tape attaching	-1 -2 -3 -4 -5			-6 -7 -8		
-031	Covering	-3 -4 -5			-6 -7 -8		
-071	Elastic lace attaching (w/top metering device & edge trimming device)	-1 -2 -3 -4 -5			-6 -7 -8		
-075	Elastic lace attaching (w/pulse motor driven top metering device & edge trimming device)	-1 -2 -3 -4 -5			-6 -7 -8		
-0T1	Belt loop sewing (Thin & Medium)	-3 -4 -5		-	-	-	-
-0T2	Belt loop sewing (Thick)	-3 -4 -5		-	-	-	-
-0U1	Belt loop sewing w/front cutter (Thin & Medium)	-3 -4 -5		-	-	-	-
-0U2	Belt loop sewing w/front cutter (Thick)	-3 -4 -5		-	-	-	-

Needle size 	Stitch length (mm) 	Differential feed ratio (mm) 	Height of presser foot (mm) 		Max. speed (rpm) 
			B271	B272	
UYX128 #70 (#65 - #90)	3.6	0.7 - 1.8	7.0	5.0	6,500 *1
UYX128 #70 (#65 - #90)	3.6	0.7 - 1.8	7.0	5.0	6,500 *1
UYX128 #70 (#65 - #90)	3.6	0.7 - 1.8	7.0	5.0	6,500 *1
UYX128 #70 (#65 - #90)	3.6	0.7 - 1.1	7.0	5.0	5,000
UYX128 #70 (#65 - #90)	3.6	0.7 - 1.1	7.0	5.0	5,000
UYX128 #90 (#75 - #90)	4.2	0.7 - 1.6	7.0	-	6,500
UYX128 #110 (#100 - #130)	4.2	0.7 - 1.6	7.0	-	6,500
UYX128 #90 (#75 - #90)	4.2	0.7 - 1.3	7.0	-	4,500
UYX128 #110 (#100 - #130)	4.2	0.7 - 1.3	7.0	-	4,500

*1 Max. speed for B272 is 6,000 rpm.

Gauge No.

Gauge No.	No. of needles	No. of threads	Gauge (mm)
-1	2	3 or 4	3.2
-2	2	3 or 4	4.0
-3	2	3 or 4	4.8
-4	2	3 or 4	5.6
-5	2	3 or 4	6.4
-6	3	4 or 5	4.8
-7	3	4 or 5	5.6
-8	3	4 or 5	6.4

Optional device

TC1 Air-type tape cutter

Parts	
Voltage	Tape cutter device set air
For export	S13074-002

TC3 Solenoid-type tape cutter

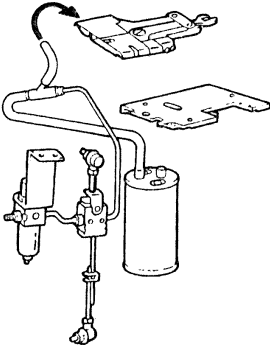
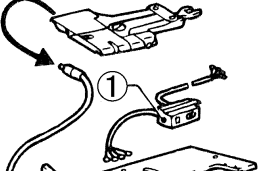
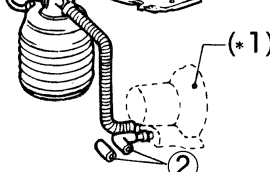
Parts	
Voltage	Tape cutter device set solenoid
For export 110 V	S11642-102
For export 220 V	S11642-104
For export 230 V	S11642-106
For export 240 V	S11642-107
For export 380 V	S11642-108
For export 415 V	S11642-109

ATC1 Automatic tape cutter

Parts	
Voltage	ATC device set solenoid
For export 110 V	S11643-102
For export 220 V	S11643-104
For export 230 V	S11643-105
For export 240 V	S11643-106
For export 380 V	S11643-107
For export 415 V	S11643-109

* When ATC1, TC1, or TC3 is used, a special needle plate is necessary. Refer to page 27 “ Needle plates for ATC1, TC1, and TC3” .

CH1, CH2 Chain cutter device

	Part name	Part code
	<p><CH1> Chain cutter device set. (Air)</p>	<p>For export S36510-102</p>
	<p><CH2> Chain cutter device set. (Vacuum) * With power supply switch ① for blower and silencer ②.</p>	<p>For export S13079-202</p>
	<p><CH2> Chain cutter device set. (Vacuum) * Without power supply switch ① for blower and silencer ②. (If using the optional blower assembly (*1), please order this chain cutter device set.)</p>	<p>For export S13080-102</p>

(*1) Blower assembly for CH2

Single	100 V	50/60 Hz	0.09/0.12 kW	147909-204
3-phase	200/220 V	50/60 Hz	0.09/0.12 kW	147909-301
3-phase	380 V	50 Hz	0.09 kW	147909-202
3-phase	220/380 V	50 Hz	0.09 kW	147909-203
Single	220 V	50 Hz	0.09 kW	147909-205
Single	115 V	60 Hz	0.12 kW	147909-206
Single	240 V	50 Hz	0.09 kW	147909-207
3-phase	400/440 V	50 Hz	0.09 kW	147909-214

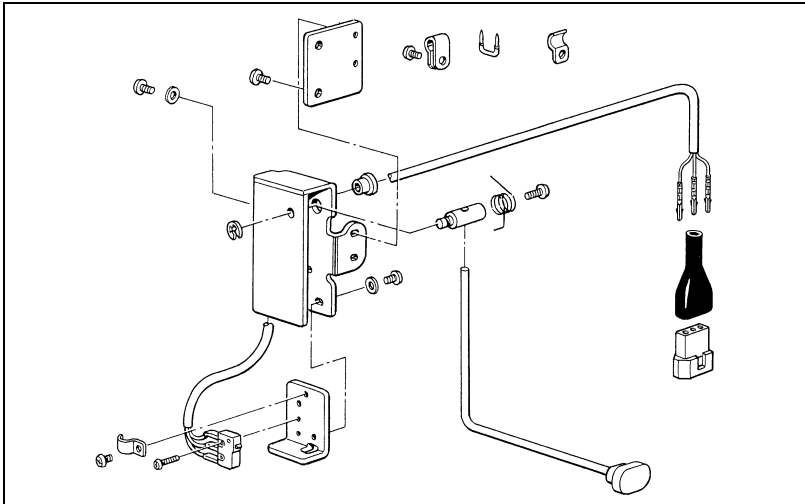
TFH Automatic tape feeder <Horizontal>

Voltage \ Parts	<021> Horizontal tape feed set
For export 110 V	S11259-202
For export 220 V	S11259-203
For export 230 V	S11259-204
For export 240 V	S11259-205
For export 380 V	S11259-206
For export 415 V	S11259-207

TFV Automatic tape feeder <Vertical>

Voltage \ Parts	<071, 075> Vertical tape feed set
For export 110 V	S11258-202
For export 220 V	S11258-203
For export 230 V	S11258-204
For export 240 V	S11258-205
For export 380 V	S11258-206
For export 415 V	S11258-207

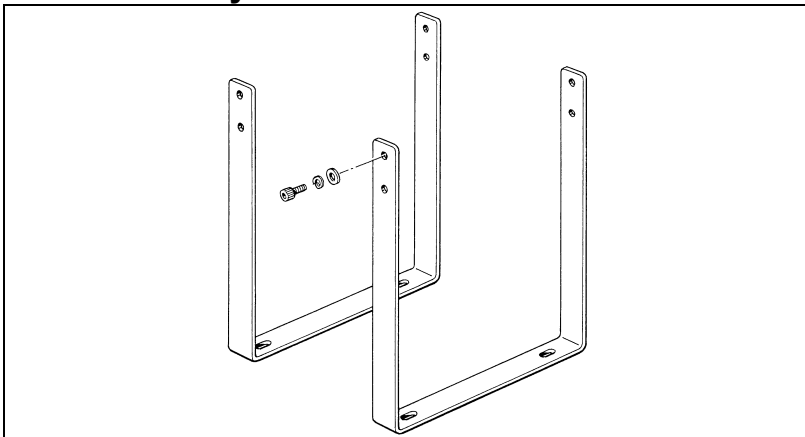
Push button switch set



Part name	Part code	Q' t y
Push button switch set	S18962-001	1

* When PM1 device is used, this set can be attached and used instead of the knee switch.

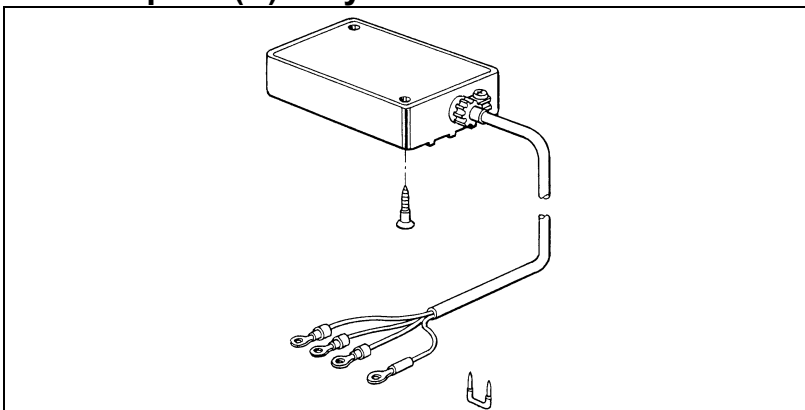
Joint box assy



Part name	Part code	Q' t y
Joint box assy	S18854-001	1

* Use this for wiring when using many devices together.

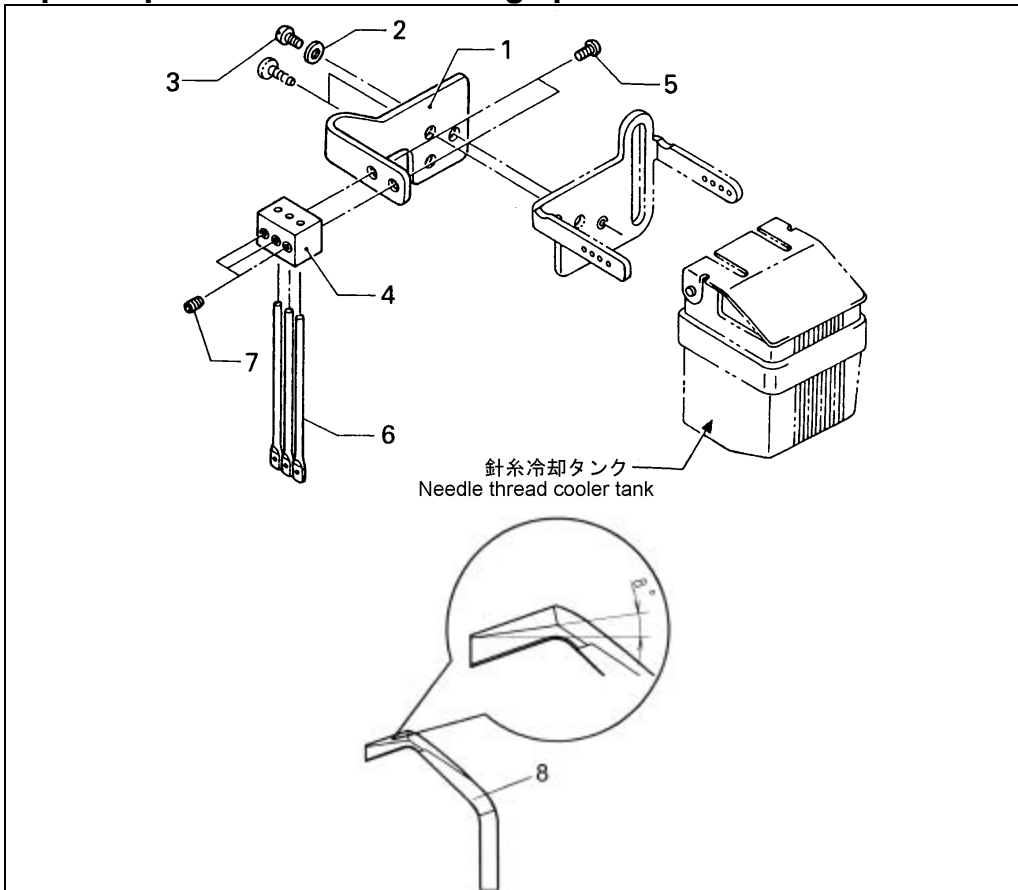
Box set plate (B) assy



Part name	Part code	Q' t y
Box set plate (B) assy	S18852-001	1

* Use this when hanging the boxes of ATC1 and PM1 under the table.

Special parts to use when using spun thread or cotton thread



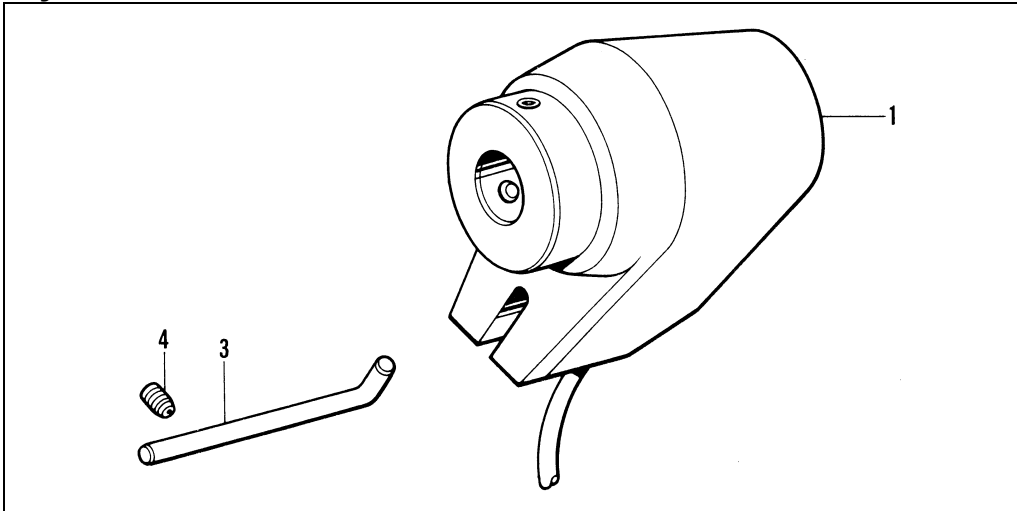
Ref. No.	Part name	Part code	Q'ty
1	Guide base	S28941-001	1
2	Washer	105161-004	1
3	Screw, pan SM3.57-40 × 6	062670-612	1
4	Thread guide (M) holder	S28942-001	1
5	Screw, pan SM3.18-40 × 5	062660-512	2
6	Thread guide (M)	S28943-001	3
7	Set screw, socket (CP) SM3.18	146427-001	3
8	Needle guard, BH	S28945-001	1
-----	Instruction manual	192271-032	1

* If there is a big difference among right, center, and left needle thread loop size, this thread guide (separate type) is effective in preventing stitch skipping.

* This needle guard, BH is effective in preventing stitch skipping caused by unwanted left needle backward movement.

* For attaching the parts listed above, refer to the instruction manual also listed above.

Synchronizer



Ref. No.	Part name	Part code	Q' t y
1	Synchronizer #17-2	J80347-001	1
3	Synchronizer guide	S28963-001	1
4	Set screw, socket (CP) SM4.37	014680-622	1

* When using the synchronizer, use the motor and V belt listed below.

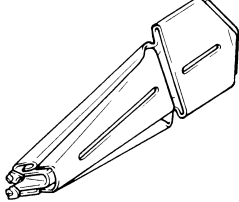
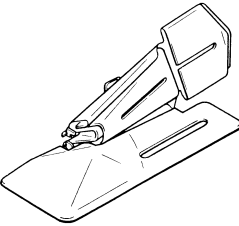
Motor

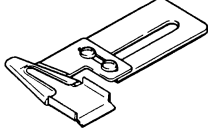
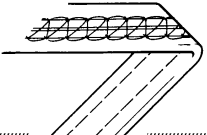
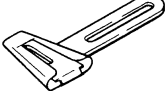

Single-phase	MD-601R
3-phase	MD-611R

V-belt

V-belt	M 36
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Optional binder

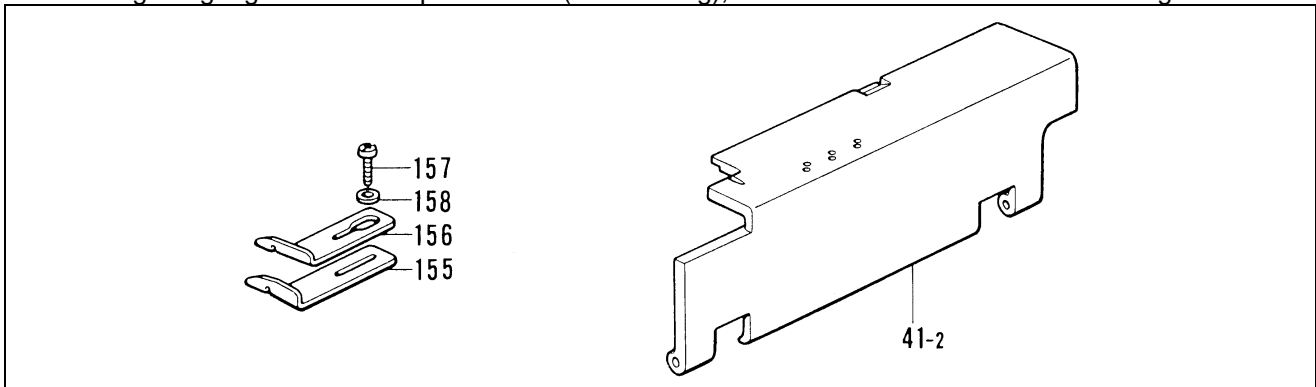
Binder for tape attachment in the bed side type <B271 · B272-021>	Single fold binding			Double fold binding			
	Finished size (mm)	Tape size (mm)	Parts No.	Finished size (mm)	Tape size (mm)	Parts No.	
	6	18	S09503-001	6	24	S09515-001	
	8	24	S09504-001	8	30	S09516-001	
	10	28	S09505-001	10	36	S09517-001	
	12	32	S09506-001	12	42	S09518-001	
	13	34	S09507-001	13	44	S09519-001	
	15	40	S09508-001	15	48	S09520-001	
	16	42	S09509-001	16	50	S09521-001	
	17	44	S09510-001	17	52	S09522-001	
	18	46	S09511-001	18	54	S09523-001	
	20	50	S09512-001	20	58	S09524-001	
	23	56	S09513-001	23	64	S09525-001	
	25	60	S09514-001	25	68	S09526-001	
	Binder for tape attachment in the bed on type <B271 · B272-011> 	6	18	S09527-001	6	24	S09539-001
		8	24	S09528-001	8	30	S09540-001
		10	28	S09529-001	10	36	S09541-001
12		32	S09530-001	12	42	S09542-001	
13		34	S09531-001	13	44	S09543-001	
15		40	S09532-001	15	48	S09544-001	
16		42	S09533-001	16	50	S09545-001	
17		44	S09534-001				
18		46	S09535-001	18	54	S09547-001	
20		50	S09536-001	20	58	S09548-001	
23		56	S09537-001	23	64	S09549-001	
25		60	S09538-001	25	68	S09550-001	

Belt loop holder without front cutter B271-0T1 · 0T2			Finished size (mm)	Tape size (mm)	Parts No.
			8	16	S09551-001
9	18	S09552-001			
10	20	S09553-001			
12	24	S09554-001			
15	30	S09555-001			
20	40	S09556-001			
Belt loop holder with front cutter B271-0U1 · 0U2			8	16	S09557-000
			9	18	S09558-000
			10	20	S09559-000
			12	24	S09560-000
			15	30	S09561-000
			20	40	S09562-000

Optional parts

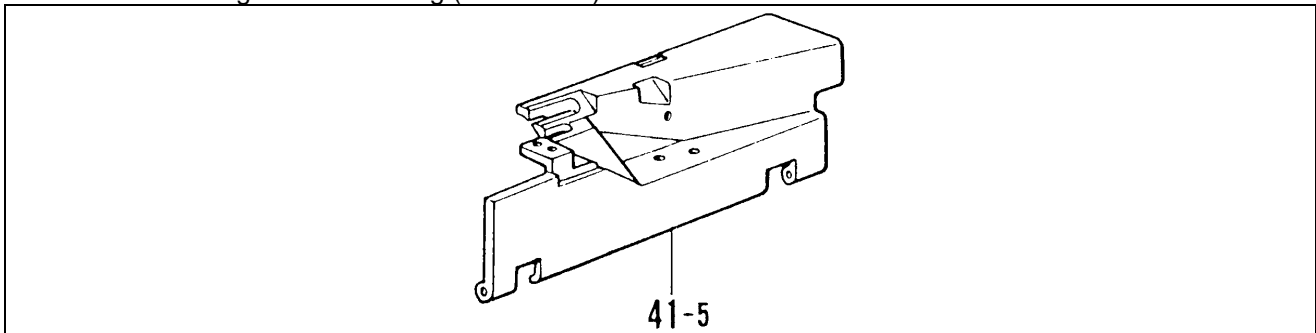
Front cover

* For using the gauges for – 033 specification (for covering), order the front cover listed below together.



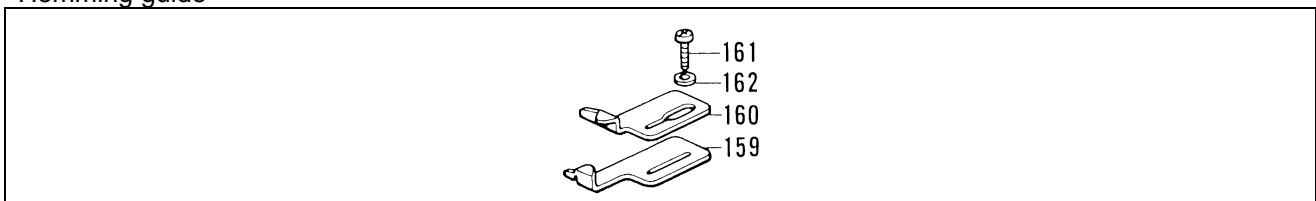
Ref. No.	Part name	Part code	Q' ty
41-2	Front cover	S21818-001	1
155	Guide (L)	S21862-001	1
156	Guide (R)	S21863-001	1
157	Screw, pan M4.76-32 × 8	062710-812	2
158	Washer	148847-001	2

Front cover for single needle linking (for – 026-S)



Ref. No.	Part name	Part code	Q' ty
41-5	Front cover	S17477-001	1

Hemming guide



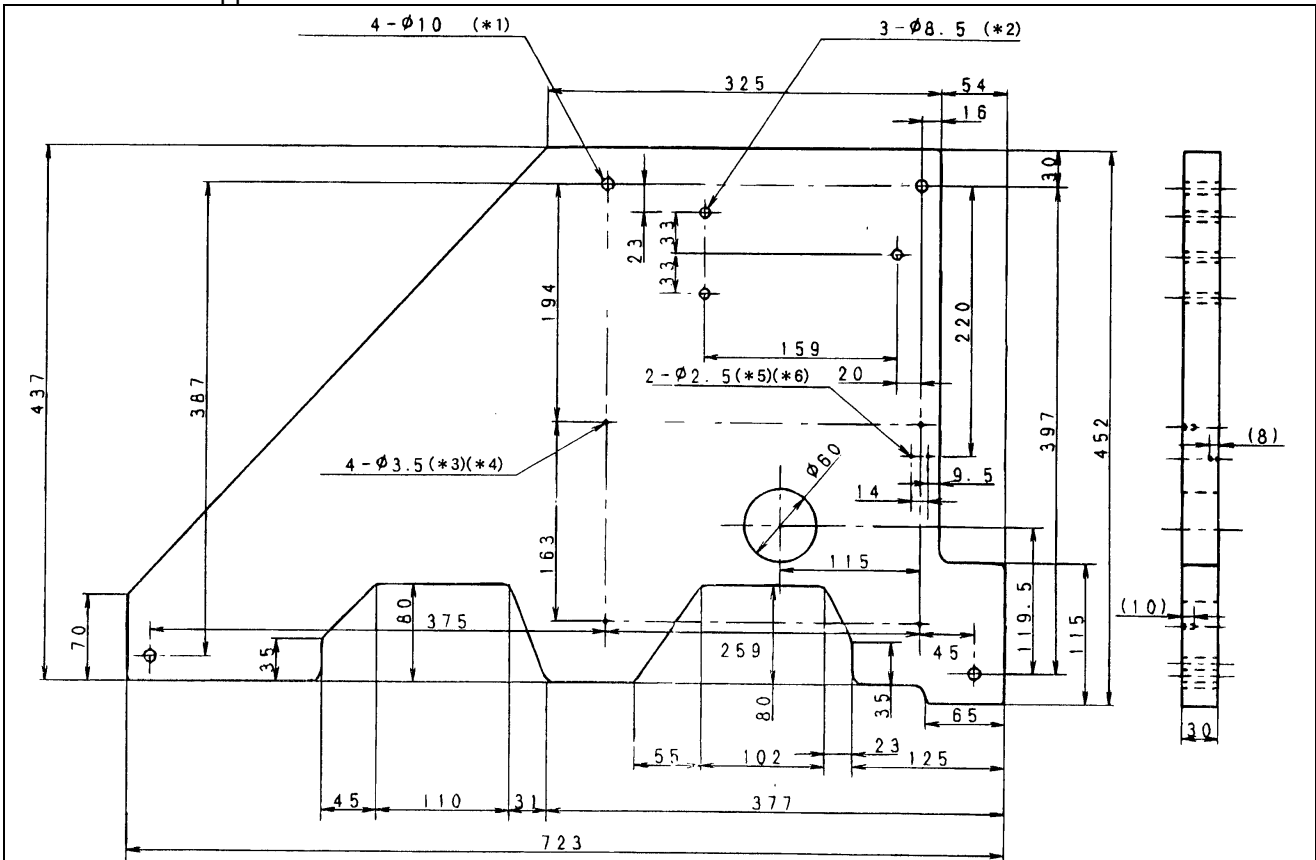
Ref. No.	Part name	Part code	Q' ty
159	Guide (L)	S21864-001	1
160	Guide (R)	S21865-001	1
161	Screw, pan M4.76-32 × 8	062710-812	2
162	Washer	148847-001	2

Processing the work table

* This sewing machine is a fully-submerged type. Refer to the diagram below to prepare the work table and the machine head support. Furthermore, if processing a folding-type work table, you will need parts which are sold separately. (Refer to page 13.)

* The top of the table should be 40 mm in thickness and should be strong enough to hold the weight and withstand the vibration of the sewing machine.

Machine head support

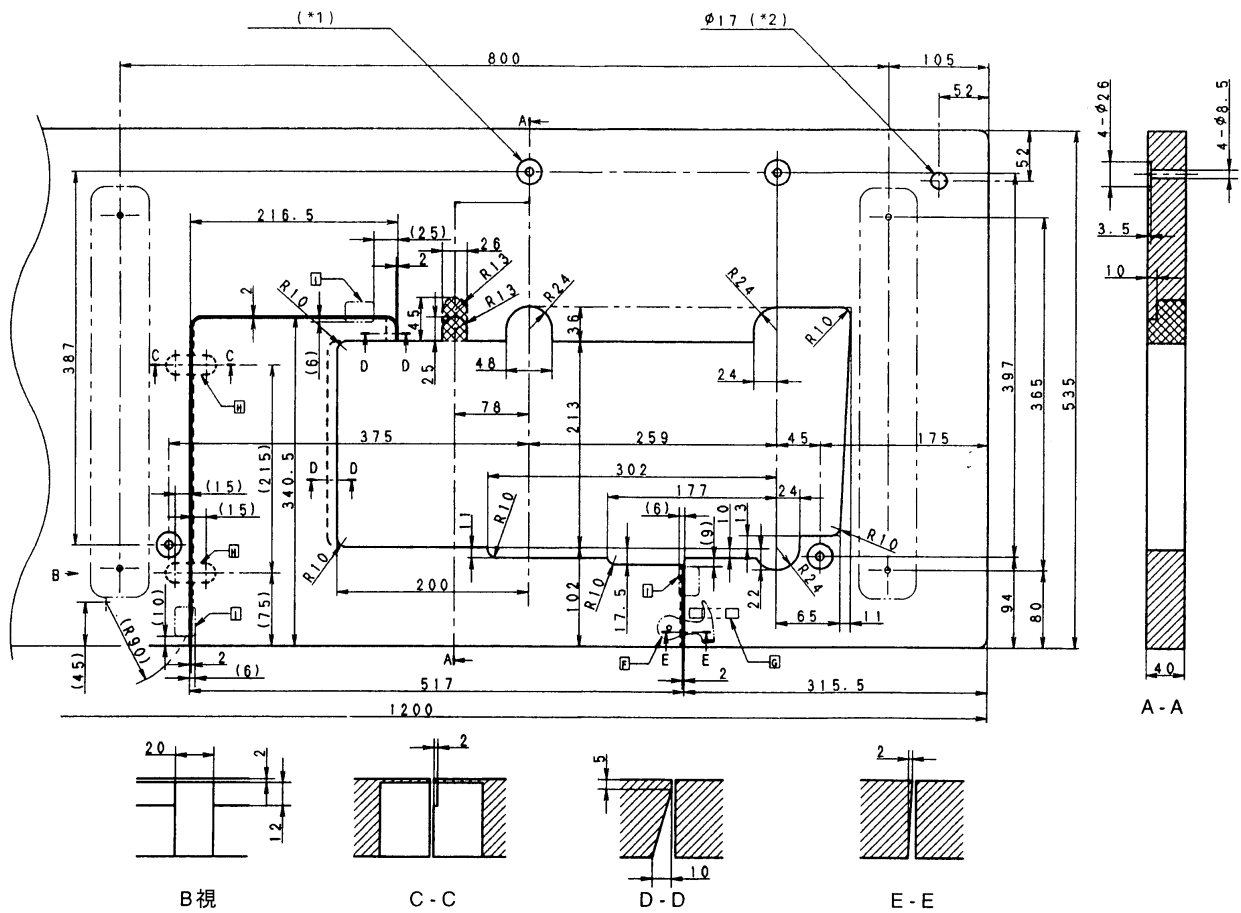



- *1 Machine head support connection positions
- *2 Motor mounting holes
- *3 Depth 10
- *4 Machine head support plate mounting holes
- *5 Depth 8
- *6 Chain guide mounting hole

Work table

*1 Machine head support connection positions (4 places)

*2 Cotton stand hole

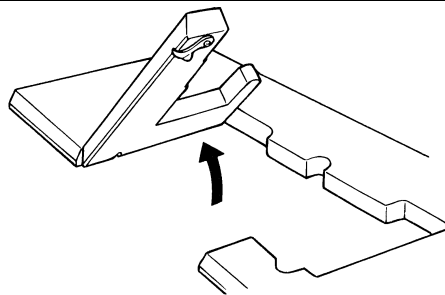


* When using the chain cutter device (CH1 or CH2), process the shaded area .

* Dimensions in brackets, diagram B and cross-sectional diagrams C-C, D-D and E-E indicate the dimensions for processing a folding-type work table with hinges.

Folding-type work table

* When processing a folding-type work table, please use the following parts which are available by separate purchase.

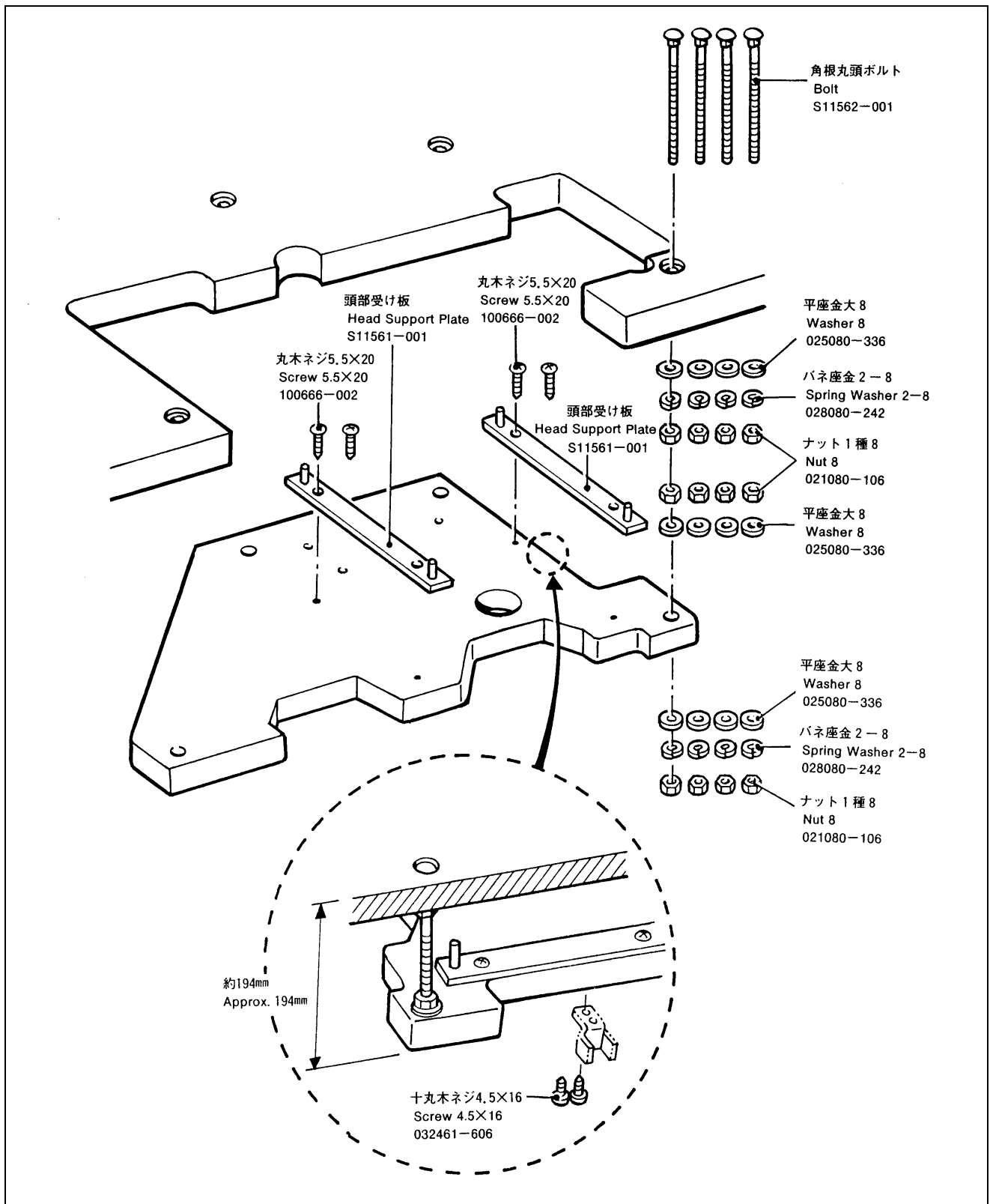


Part name	Part code	Q' t y
Stopper	101117-001	1
Wood screw, round M4.5 × 16	032461-606	1
Holder	119561-001	1
Wood screw, round M3.5 × 13	032361-306	2
Hinge	S42189-000	2
Wood screw, flat M2.7 × 16	034281-605	8
Guide plate	106292-001	3
Wood screw, flat M3.5 × 16	034361-606	6

Setting up the full-submerged table

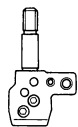
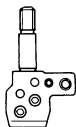
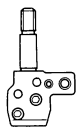
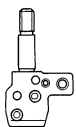
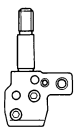





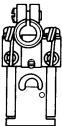




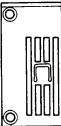


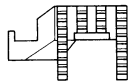
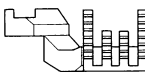
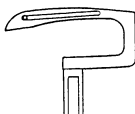
* Use the nuts to adjust the height of the machine head.

	Part name	Part code	Q' ty
Full submerged set		S11560-001	1




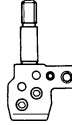
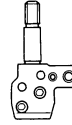

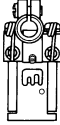

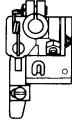
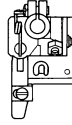
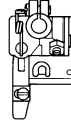
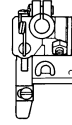


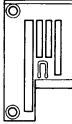
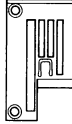
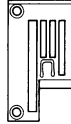
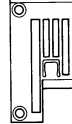
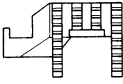
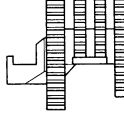
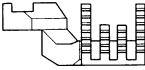
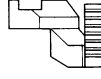
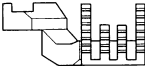
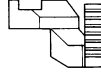
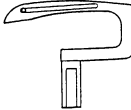


* The above parts can be supplied individually.

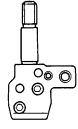
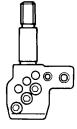



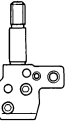
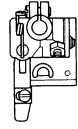
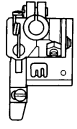
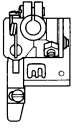
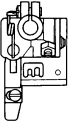
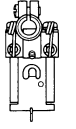
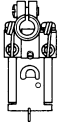
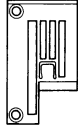
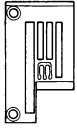
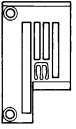
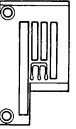


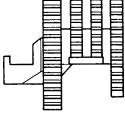
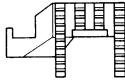
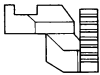
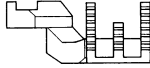
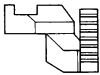
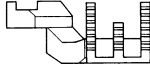
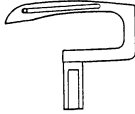
Gauge parts list

Model	B271 B272	B271 B272	B271 B272	B271 B272	B271 B272	B271 B272
Specifications	011-1	011-2	011-3	011-4	011-5	011-6
Label	S19854-001	S19854-002	S19854-003	S19854-004	S19854-005	S19854-006
Application	Plain stitching					
No. of needles	2	2	2	2	2	3
Needle gauge (mm)	3.2	4.0	4.8	5.6	6.4	4.8
Needle clamp assy	S08699-001 	S08701-001 	S08703-001 	S08705-001 	S08707-001 	S08709-001 
Presser foot assy	S08779-201 	S08786-201 	S08788-201 	S08790-201 	S08792-201 	S08794-201 
Needle plate	S08717-001 	S08718-001 	S08719-001 	S08720-001 	S08721-001 	S08722-001 
Main feed dog	S08882-001 					
Differential feed dog	S08885-001 					
Looper	S08913-001 					





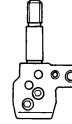
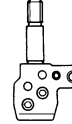
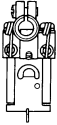

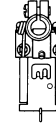

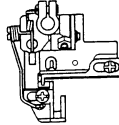
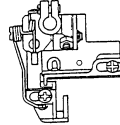

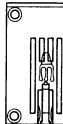
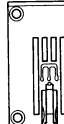
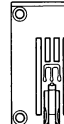


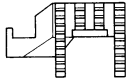
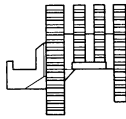
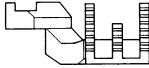
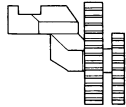
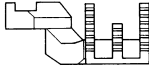
Gauge parts list

Model	B271 B272	B271 B272	B271 B272	B271 B272	B271 B272	B271 B272
Specifications	011-7	011-8	021-1	021-2	021-3	021-4
Label	S19854-007	S19854-008	S19854-009	S19854-010	S19854-011	S19854-012
Application	Plain stitching			Tape stitching		
No. of needles	3	3	2	2	2	2
Needle gauge (mm)	5.6	6.4	3.2	4.0	4.8	5.6
Needle clamp assy	S08711-001 	S08713-001 	S08699-001 	S08701-001 	S08703-001 	S08705-001 
Presser foot assy	S08796-201 	S08798-201 	S08800-201 	S08813-201 	S08815-201 	S08818-201 
Needle plate	S08723-001 	S08724-001 	S08725-101 	S08726-001 	S08727-001 	S08728-001 
Main feed dog	S08882-001 			S08883-001 		
	S08885-001 			S08886-001 		
Differential feed dog	S08885-001 			S08886-001 		
Looper	S08913-001 					

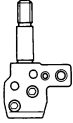
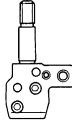
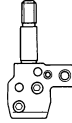



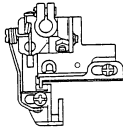
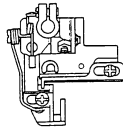
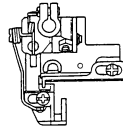
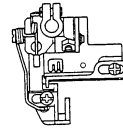
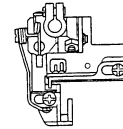
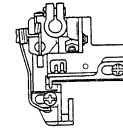
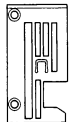
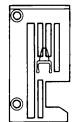
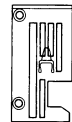
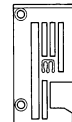
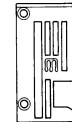
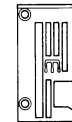
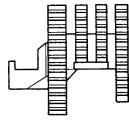
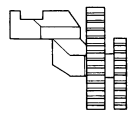
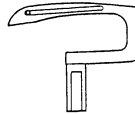
Gauge parts list

Model	B271 B272	B271 B272	B271 B272	B271 B272	B271 B272	B271 B272
Specifications	021-5	021-6	021-7	021-8	031-3	021-4
Label	S19854-013	S19854-014	S19854-015	S19854-016	S19854-017	S19854-018
Application	Tape stitching				Covering	
No. of needles	2	3	3	3	2	2
Needle gauge (mm)	6.4	4.8	5.6	6.4	4.8	5.6
Needle clamp assy	S08707-001 	S08709-001 	S08711-001 	S08713-001 	S08703-001 	S08705-001 
Presser foot assy	S08820-201 	S08822-201 	S08824-201 	S08826-201 	S08828-201 	S08830-201 
Needle plate	S08729-001 	S08730-001 	S08731-001 	S08732-001 	S08733-001 	S08734-001 
Main feed dog	S08883-001 				S08882-001 	
	S08886-001 				S08887-001 	
Differential feed dog	S08886-001 				S08887-001 	
Looper	S08913-001 					


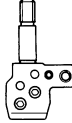
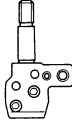



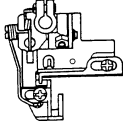
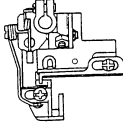
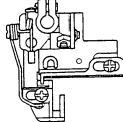
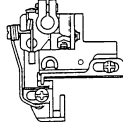
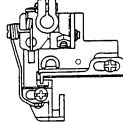
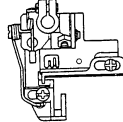
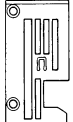
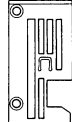
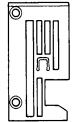
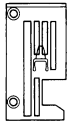
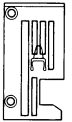
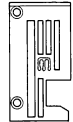
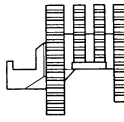
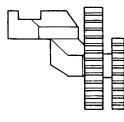
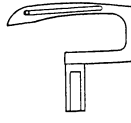
Gauge parts list

Model	B271 B272	B271 B272	B271 B272	B271 B272	B271 B272	B271 B272
Specifications	031-5	031-6	031-7	031-8	071-1	071-2
Label	S19854-019	S19854-020	S19854-021	S19854-022	S19854-023	S19854-024
Application	Covering				Elastic lace attaching (w / top metering device & edge trimming device)	
No. of needles	2	3	3	3	2	2
Needle gauge (mm)	6.4	4.8	5.6	6.4	3.2	4.0
Needle clamp assy	S08707-001 	S08709-001 	S08711-001 	S08713-001 	S08699-001 	S08701-001 
Presser foot assy	S08832-201 	S08834-201 	S08836-201 	S08838-201 	S08840-201 	S08848-201 
Needle plate	S08735-001 	S08736-001 	S08737-001 	S08738-001 	S08739-001 	S08740-001 
Main feed dog	S08882-001 				S08883-001 	
	Differential feed dog	S08887-001 				S08888-101 
Looper		S08913-001 				



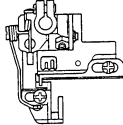
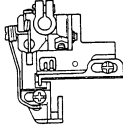

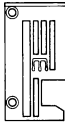
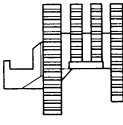
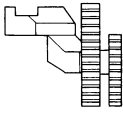
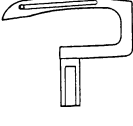
Gauge parts list

Model	B271 B272	B271 B272	B271 B272	B271 B272	B271 B272	B271 B272
Specifications	071-3	071-4	071-5	071-6	071-7	071-8
Label	S19854-025	S19854-026	S19854-027	S19854-028	S19854-029	S19854-030
Application	Elastic lace attaching (w / top metering device & edge trimming device)					
No. of needles	2	2	2	3	3	3
Needle gauge (mm)	4.8	5.6	6.4	4.8	5.6	6.4
Needle clamp assy	S08703-001 	S08705-001 	S08707-001 	S08709-001 	S08711-001 	S08713-001 
Presser foot assy	S08850-201 	S08852-201 	S08854-201 	S08856-201 	S08858-201 	S08860-201 
Needle plate	S08741-001 	S08742-001 	S08743-001 	S08744-001 	S08745-001 	S08746-001 
Main feed dog	S08883-001 					
Differential feed dog	S08888-101 					
Looper	S08913-001 					

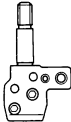
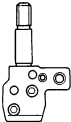

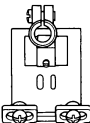
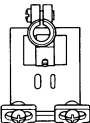
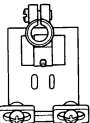



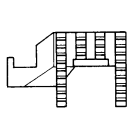
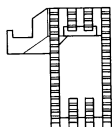
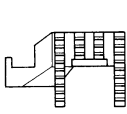
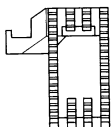
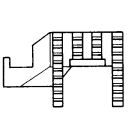
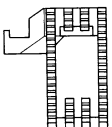
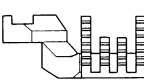
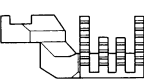
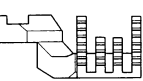
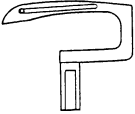
Gauge parts list

Model	B271 B272	B271 B272	B271 B272	B271 B272	B271 B272	B271 B272
Specifications	075-1	075-2	075-3	075-4	075-5	075-6
Label	S19854-048	S19854-049	S19854-050	S19854-051	S19854-052	S19854-053
Application	Elastic lace attaching (Pulse motor drive top metering device & edge trimming device)					
No. of needles	2	2	2	2	2	3
Needle gauge (mm)	3.2	4.0	4.8	5.6	6.4	4.8
Needle clamp assy	S08699-001 	S08701-001 	S08703-001 	S08705-001 	S08707-001 	S08709-001 
Presser foot assy	S08840-201 	S08848-201 	S08850-201 	S08852-201 	S08854-201 	S08856-201 
Needle plate	S08739-001 	S08740-001 	S08741-001 	S08742-001 	S08743-001 	S08744-001 
Main feed dog	S08883-001 					
Differential feed dog	S08888-101 					
Looper	S08913-001 					

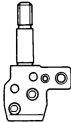
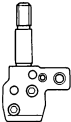

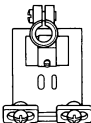
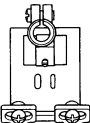
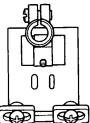



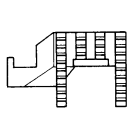
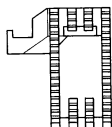
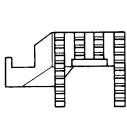
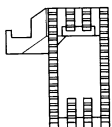
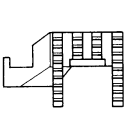
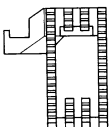
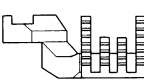
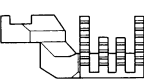
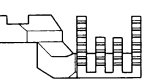
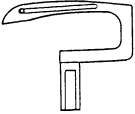
Gauge parts list

Model	B271 B272	B271 B272				
Specifications	075-7	075-8				
Label	S19854-054	S19854-055				
Application	Elastic lace attaching (Pulse motor drive top metering device & edge trimming device)					
No. of needles	3	3				
Needle gauge (mm)	5.6	6.4				
Needle clamp assy	S08711-001 	S08713-001 				
Presser foot assy	S08858-201 	S08860-201 				
Needle plate	S08745-001 	S08746-001 				
Main feed dog	S08883-001 					
Differential feed dog	S08888-101 					
Looper	S08913-001 					



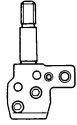




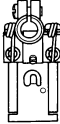


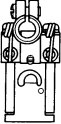
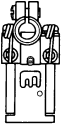






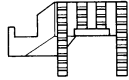
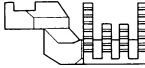
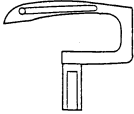
Gauge parts list

Model	B271	B271	B271	B271	B271	B271
Specifications	0T1-3	0U1-3	0T1-4	0U1-4	0T1-5	0U1-5
Label	S19854-031	S19854-037	S19854-032	S19854-038	S19854-033	S19854-039
Application	Belt loop sewing Thin / Medium	Belt loop sewing Thin / Medium (w / front cutter)	Belt loop sewing Thin / Medium	Belt loop sewing Thin / Medium (w / front cutter)	Belt loop sewing Thin / Medium	Belt loop sewing Thin / Medium (w / front cutter)
No. of needles	2		2		2	
Needle gauge (mm)	4.8		5.6		6.4	
Needle clamp assy	S08703-001 		S08705-001 		S08707-001 	
Presser foot assy	S08862-101 		S08866-101 		S08868-101 	
Needle plate	S08719-001 		S08720-001 		S08721-001 	
Main feed dog	S08882-001 	S28453-001 	S08882-001 	S28453-001 	S08882-001 	S28453-001 
Differential feed dog	S08885-001 		S08885-001 		S08885-001 	
Looper	S08913-001 					




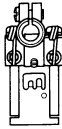
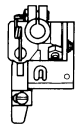
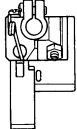
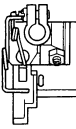

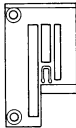
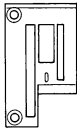
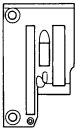
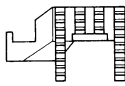
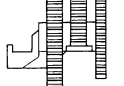
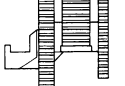

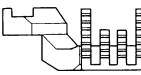



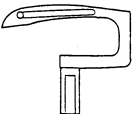
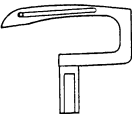
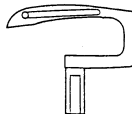
Gauge parts list

Model	B271	B271	B271	B271	B271	B271
Specifications	0T2-3	0U2-3	0T2-4	0U2-4	0T2-5	0U2-5
Label	S19854-034	S19854-040	S19854-035	S19854-041	S19854-036	S19854-042
Application	Belt loop sewing Thick	Belt loop sewing Thick (w / front cutter)	Belt loop sewing Thick	Belt loop sewing Thick (w / front cutter)	Belt loop sewing Thick	Belt loop sewing Thick (w / front cutter)
No. of needles	2		2		2	
Needle gauge (mm)	4.8		5.6		6.4	
Needle clamp assy	S08703-001 		S08705-001 		S08707-001 	
Presser foot assy	S08862-101 		S08866-101 		S08868-101 	
Needle plate	S08747-001 		S08748-001 		S08749-001 	
Main feed dog	S08882-001 	S28453-001 	S08882-001 	S28453-001 	S08882-001 	S28453-001 
Differential feed dog	S08885-001 		S08885-001 		S08885-001 	
Looper	S08913-001 					

Gauge parts list

Model	B271 B272	B271 B272	B271 B272	B271 B272	B271 B272	B271 B272
Specifications	for 011-1	for 011-2	for 011-3	for 011-4	for 011-5	for 011-7
Label	Option	Option	Option	Option	Option	Option
Application	Plain stitching (Heavy)					
No. of needles	2	2	2	2	2	3
Needle gauge (mm)	3.2	4.0	4.8	5.6	6.4	5.6
Needle clamp assy	S08699-001 	S08701-001 	S08703-001 	S08705-001 	S08707-001 	S08711-001 
Presser foot assy	S08779-201 	S08786-201 	S08788-201 	S08790-201 	S08792-201 	S08796-201 
Needle plate	S14074-001 	S14075-001 	S08747-001 	S08748-001 	S08749-001 	S14077-001 
Main feed dog	S08882-001 					
Differential feed dog	S08885-001 					
Looper	S12683-001 					

Gauge parts list

Model	B271 B272	B271 B272	B271	B271		
Specifications	for 011-8	for 021-1	025-S	026-S		
Label	Option	Option	S19854-046	S19854-047		
Application	Plain stitching (Heavy)	Tape stitching		Linking		
No. of needles	3	2	1	1		
Needle gauge (mm)	6.4	3.2	-	-		
Needle clamp assy	S08713-001 	S08699-001 	S17480-201 			
Presser foot assy	S08798-201 	S08800-201 	S17484-001 	S17489-001 		
Needle plate	S14078-001 	S18047-001 	S17482-001 	S17483-001 		
Main feed dog	S08882-001 	S18049-001 	S17494-001 	S17495-001 		
Differential feed dog	S08885-001 	S18050-001 	S08886-001 	S17496-001 		
Looper	S12683-001 	S08913-001 		S12683-001 		

* -025-S and -026-S are special order.




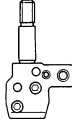




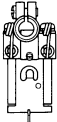
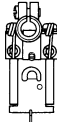



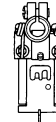
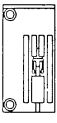
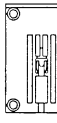
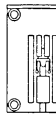


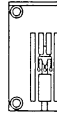
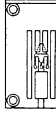
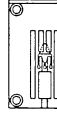
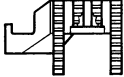
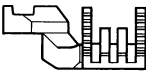
* Changing from -021 to -026-S requires the gauges and also the front cover listed in page 11.

* The binder for -026-S is not prepared. Please prepare separately.

Gauge parts list

* -033 specification is special order.

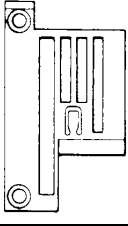
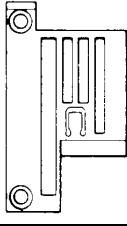
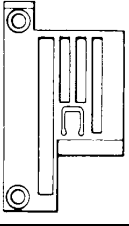
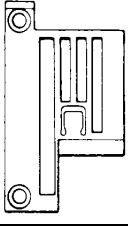
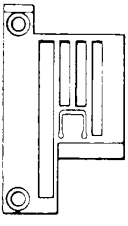
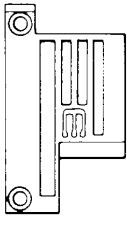
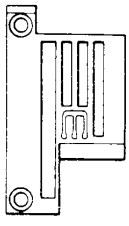
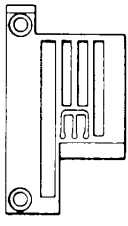
* Changing from –031 to –033 specification requires the gauge parts listed below and also the front cover listed in page 11.

Model	B271 B272	B271 B272	B271 B272	B271 B272	B271 B272	B271 B272
Specifications	033-3	033-4	033-5	033-6	033-7	033-8
Label	S08678-064	S08678-065	S08678-066	S08678-067	S08678-068	S08678-069
Application	Covering					
No. of needles	2	2	2	3	3	3
Needle gauge (mm)	4.8	5.6	6.4	4.8	5.6	6.4
Needle clamp assy	S08703-001 	S08705-001 	S08707-001 	S08709-001 	S08711-001 	S08713-001 
Presser foot assy	S08828-201 	S08830-201 	S08832-201 	S08834-201 	S08836-201 	S08838-201 
Needle plate	S21823-001 	S21824-001 	S21825-001 	S21826-001 	S21827-001 	S21828-001 
					S28910-001 *1 	S28911-001 *1 
Main feed dog	S21860-001 					
Differential feed dog	S21861-001 					

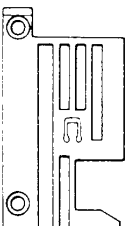
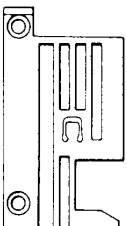
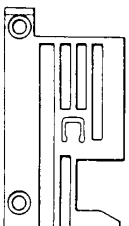
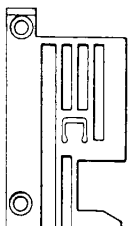
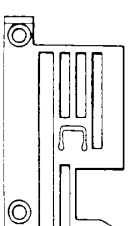
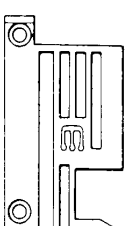
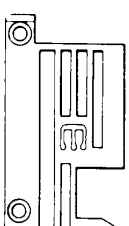
*1: This is the needle plate which has been increased in its strength by eliminating the groove in the center claw.

Needle plates for ATC1, TC1, TC3

Tape attaching <021>

No. of needles	2	2	2	2
Needle gauge (mm)	3.2	4.0	4.8	5.6
Needle plate	S11570-101 	S11571-001 	S11572-001 	S11573-001 
No. of needles	2	3	3	3
Needle gauge (mm)	6.4	4.8	5.6	6.4
Needle plate	S11574-001 	S11575-001 	S11576-001 	S11577-001 

Elastic lace attaching (w / top metering device and edge trimming device) <071, 075>

No. of needles	2	2	2	2
Needle gauge (mm)	3.2	4.0	4.8	5.6
Needle plate	S11578-001 	S11579-001 	S11580-001 	S11581-001 
No. of needles	2	3	3	3
Needle gauge (mm)	6.4	4.8	5.6	6.4
Needle plate	S11582-001 	S11583-001 	S11584-001 	S11585-001 