



# PARTS AND INSTRUCTION MANUAL FOR 81200S AND 81200SM

80800 RFC



858 Summer Avenue Newark, NJ 07104

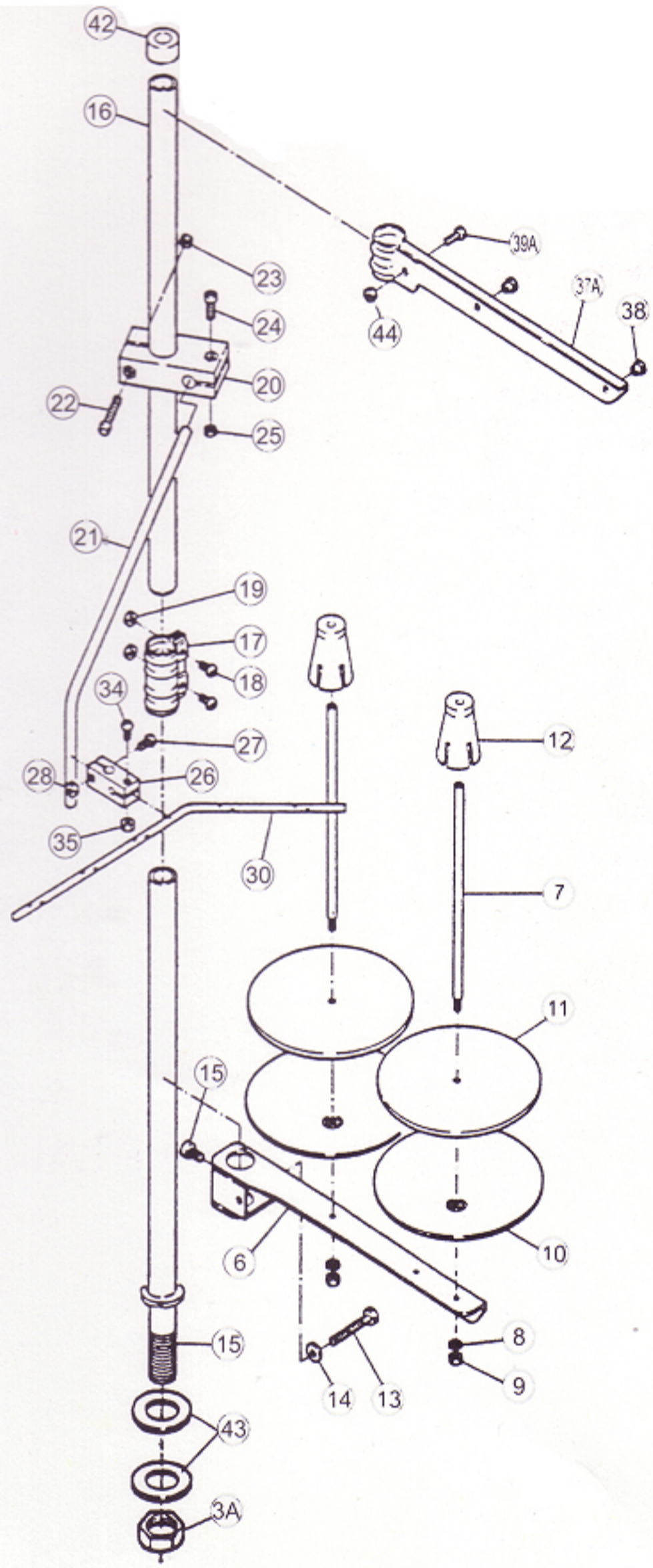
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# THREAD STAND FOR 81200S/SM





Refer to the illustration and assemble parts.

**Note:-**

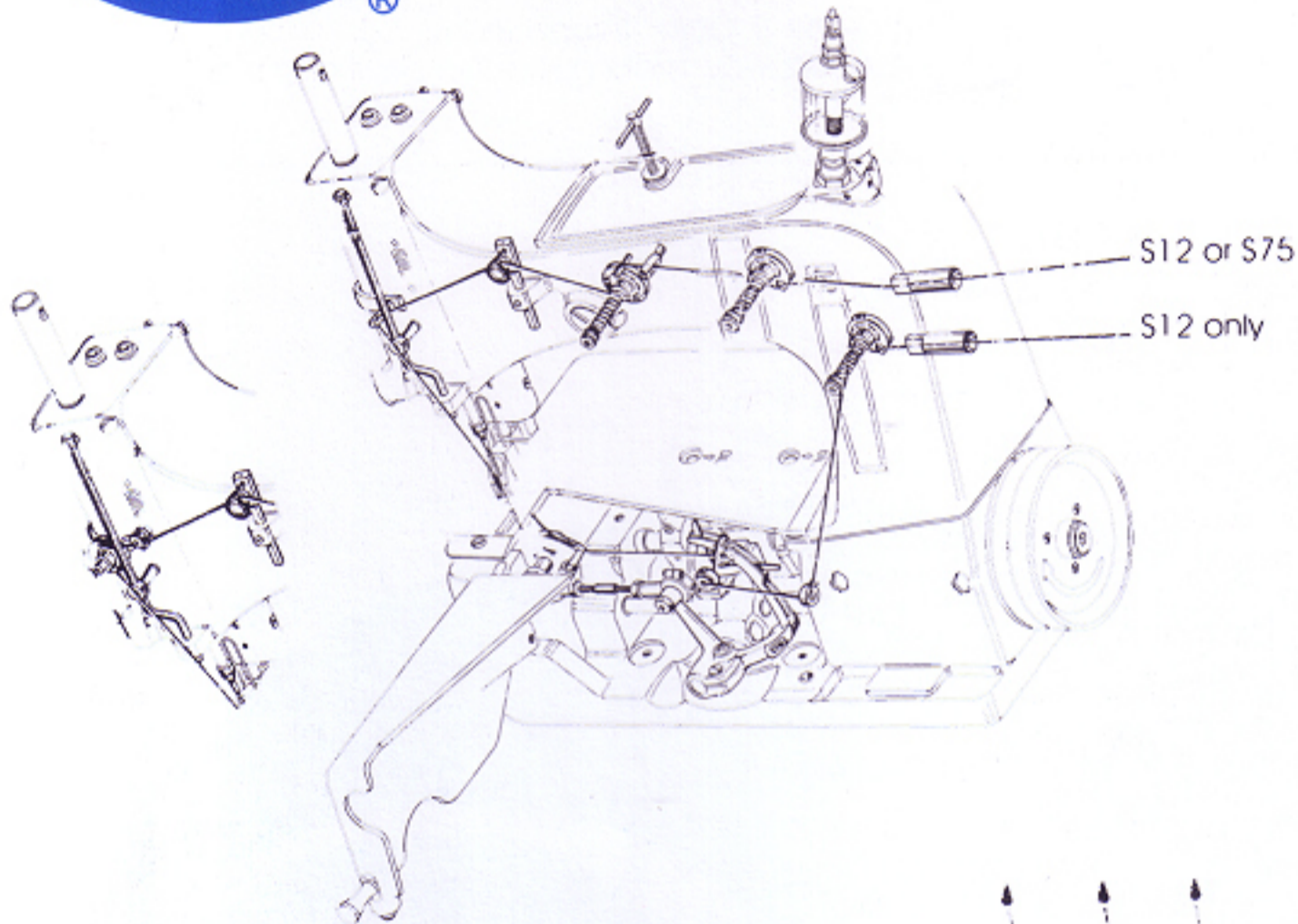
The illustration shows the 2 Cone Thread Stand. So, please assemble other stands in the similar way, making sure the parts and their quantity shown on the parts list

REF. NO.	NAME	2 Cone
	Thread Stand Assembly	1
	"	"
	"	"
	"	"
	"	"
(4B)	Thread Stand rod (lower)	1
(43)	Washer	2
(3A)	Nut	1
(5)	Bracket	
(6)	Bracket	1
(7)	Spool pin	2
(8)	Spring washer	2
(9)	Nut	2
(10)	Spool tray	2
(11)	Seat	2
(12)	Spool retaining fig	2
(13)	Screw	1
(14)	Washer	1
(15)	Screw	1
(16)	Thread stand rod (upper)	1
(17)	Joint	1
(18)	Screw	2
(19)	Nut	2
(20)	Holder (large)	1
(21)	Thread guide bar	1
(22)	Screw	1
(23)	Nut	1
(24)	Screw	1
(25)	Nut	1
(26)	Holder (small)	1
(27)	Screw	1
(28)	Nut	1
(29)	Thread guide bar	
(30)	Thread guide bar	
(31)	Thread guide bar	
(32)	Thread guide bar	1
(33)	Thread guide bar	
(34)	Screw	1
(35)	Nut	1
(36A)	Bracket	
(37A)	Bracket	1
(38)	Thread eyelet	2
(39A)	Screw	1
(44)	Nut	1
(42)	Cap	1





# 81200S/SM THREADING CHART



## OILING DIAGRAM

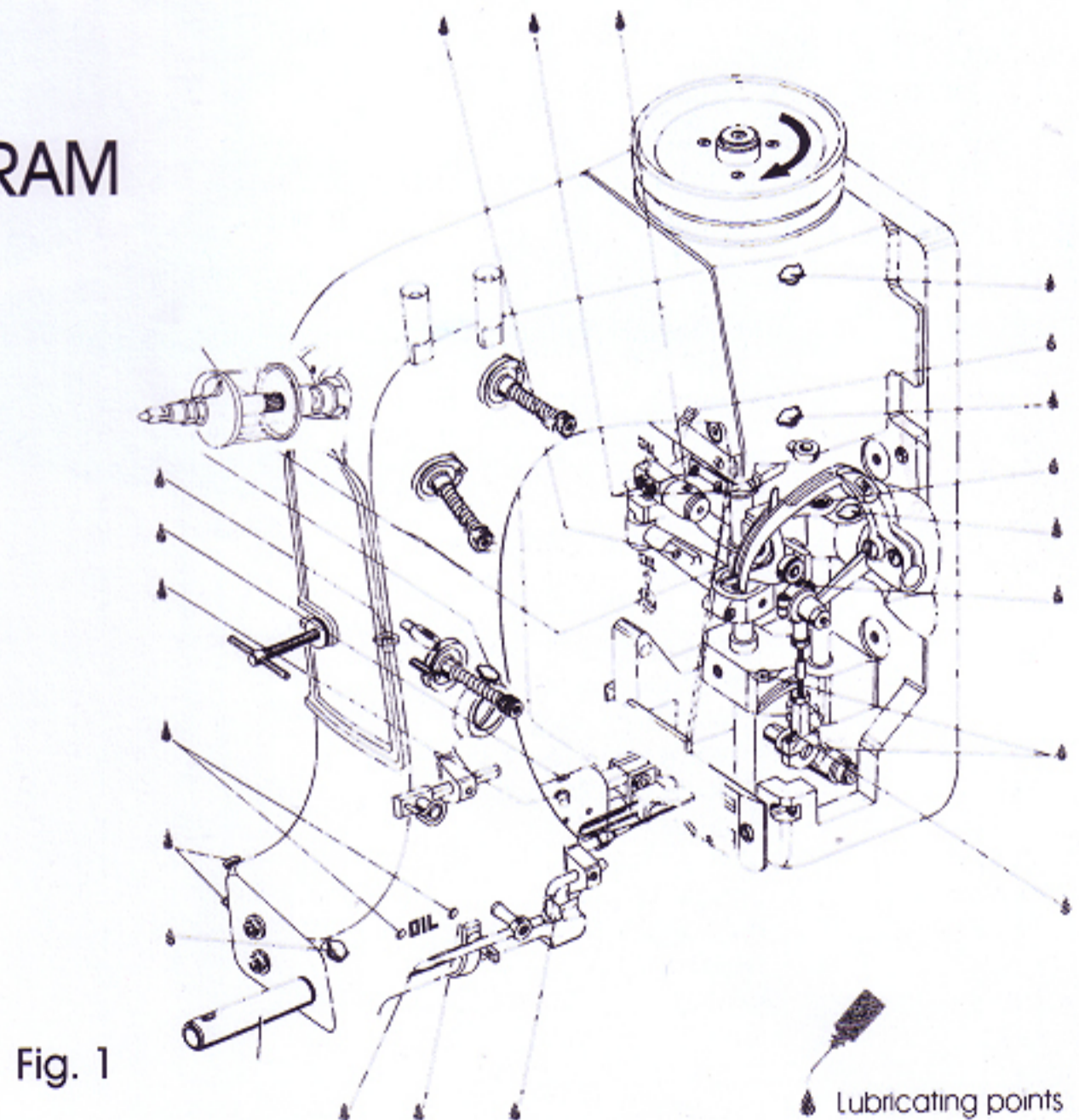


Fig. 1



## LUBRICATION AND OPERATION

NC machines of class 81200S and SM have to be cleaned and lubricated twice a day before the morning and afternoon start on the lubricating points indicated on the oiling diagram (Fig. 1). The sight feed oiler has to be kept filled and should be adjusted so that it feeds two to three drops of oil per hour.

## NEEDLES FOR 81200S AND 81200SM

The standard needles for machines covered in this manual are:

81200S-Style S23

SIZE 090

81200SM-Style S45

SIZE 080

Selection of proper needle size is determined by size of thread used. Thread should pass freely through needle eye in order to produce a good stitch formation.

## ADJUSTING INSTRUCTIONS

**NOTE** instructions stating direction or location, such as

right, left, front or rear of machine, are given relative to mechanic's position in front of the machine, when the machine is placed on an adjusting table, with the pulley to the right and the needle bar in vertical position. The pulley rotates clockwise, in operating direction, when viewed from the right end of the machine.

## INSERTING THE NEEDLE

Before adjusting the machine, insert a new needle with the shank as far as possible into the needle bar. The long needle groove must point to the front (toward the operator). Tighten the needle clamp nut securely. Use the single ended open jaw wrench part No.21388 from the accessories of the machine.

## SETTING THE LOOPER

Remove the feed roller, throat plate and feed dog and also the needle guard for convenient access to the machine. On styles 81200S and SM, loosen the screw (A, Fig. 2) in the feed bar (B) and push the feed bar needle guard (C) to the rear to avoid its contacting the needle (D).

For the styles 81200S/SM, set the looper connecting rod (E) so the distance (X, Fig. 3) between the center lines of the two ball joints is 69.8mm (2 3/4"). The

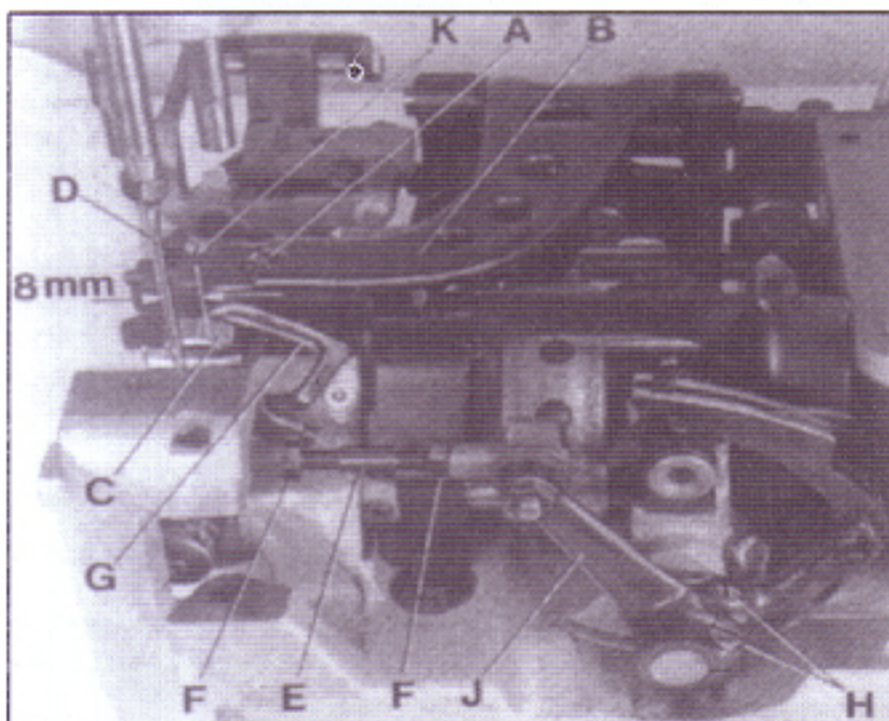


Fig. 2

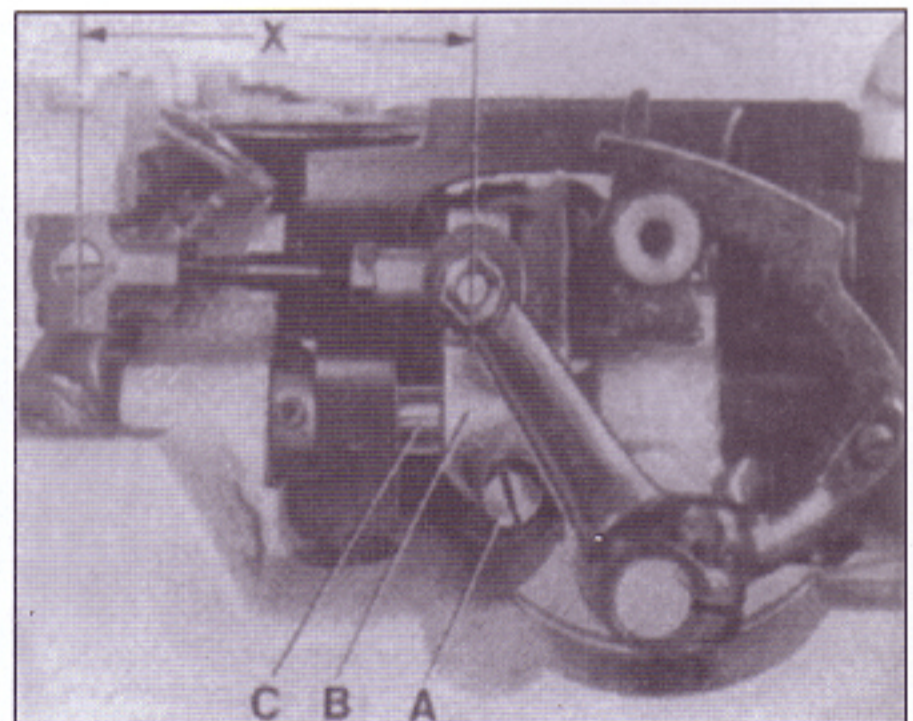


Fig. 3



dimension (X, Fig. 3) should be 68.3mm (2 11/16) on the single thread chain stitch style 80800D. For adjustment loosen the two nuts (F, Fig. 2) and turn connecting rod (E) forward or backward as required to obtain specified dimension, retighten nuts (F).

**NOTE** The left nut has a left hand thread. Set the looper (G) so the distance from the center line of the needle (D) to the looper (G) is 8mm (5/16") when the looper is at its farthest position to the right. Looper gauge No. 21225 5/16 can be used advantageously in making this adjustment. For adjustment, loosen screws (H) in the looper drive lever (J), reposition as required to obtain specified dimension and retighten screws (H) assuring that all end play is taken out of the looper drive lever rocker shaft. Check to insure a clearance of approx. 1 mm (.040") between the point of the looper and the bed end cover when the looper is at its extreme left position. Should the looper strike the bed end cover, recheck the distance between center lines of ball joints and the looper gauge distance as described above.

Rotate the machine pulley in operating direction so that the looper moves from right to left. The looper point should pass as close as possible to the back of the needle without contacting 0.08 to 0.13 mm (.003 to .005") clearance. For adjustment loosen screws (A, Fig. 3) in the looper eccentric fork (B) and turn looper rocker shaft (C) on the looper rocker forward or backward as required. Retighten screw (A).

#### SETTING HEIGHT OF NEEDLE BAR

Remove the face cover on machine arm. Rotate machine pulley in operating direction until the looper point, moving to the left, projects 1 to 1.5 mm (.040" to .060") left of the needle (see Fig. 4). Lower edge of looper and upper edge of needle eye must be flush in this position. If adjustment is necessary, loosen clamp screw (A, Fig. 5) in the needle bar connection and move the needle bar up or down, as required. Retighten screw (A) and remount face cover.

#### SETTING THE FEED DOG

At highest point of feed dog travel, the feed dog (B, Fig. 5) should be set so, that the rear teeth project their full depth above the throat plate surface. For setting remove the feed dog and adjust the supporting screw (K, Fig. 2) on the top of the feed bar to the required height. Remount the feed dog, and on styles 80800H and HA also the needle guard.

After loosening screws (A, Fig. 6) rear in the feed rocker (B), the feed bar with feed dog can be moved laterally to center the feed dog in the throat plate slots, if required. Retighten screws (A).

#### CHANGING STITCH LENGTH

On styles 81200S and SM stud (C, Fig. 5) for changing

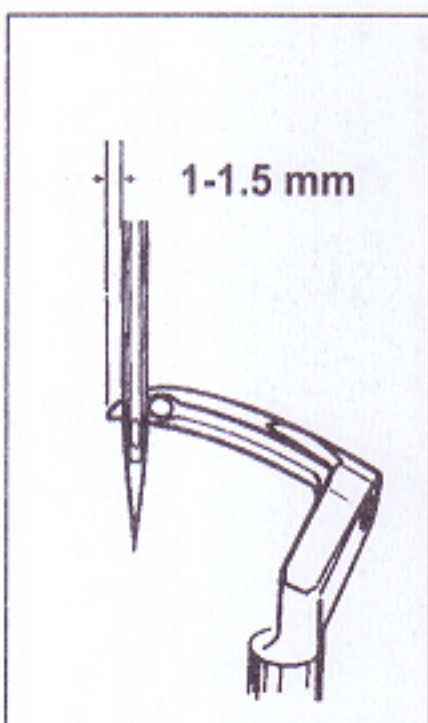


Fig. 4



Fig. 5

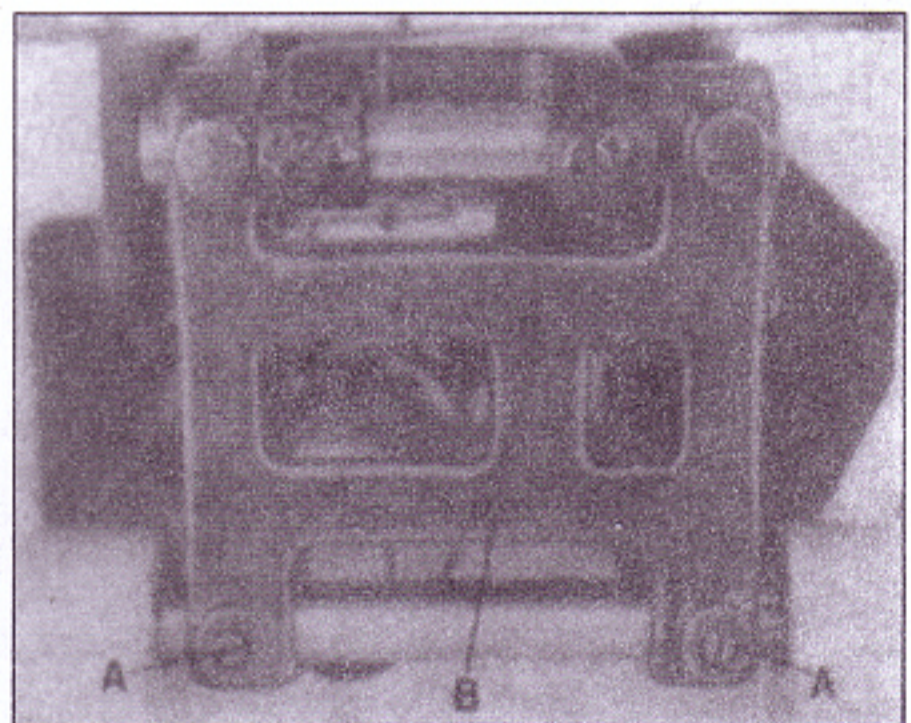


Fig. 6



the stitch length is accessible from the outside

The length of the stitch can be adjusted by raising or lowering the stud (C, Fig. 5) in the segment slot of the feed rocker (D). Lowering stud (C) will lengthen the stitch. After loosening nut (E) stud (C) can be moved accordingly. When the desired stitch length is obtained, retighten nut (E). Remount housing for cutter and rear cloth plate on styles 80800H and HA.

**NOTE:** Any change in stitch length will necessitate a corresponding change in the needle guard setting!

#### SETTING THE NEEDLE GUARD

The needle guard (C, Fig. 2) has to be set so, that it just contacts the needle at its most forward point of travel, without deflecting it.

On styles 81200S/SM loosen screw (A, Fig. 2) in the feed bar (B) and adjust the needle guard (C) accordingly. Retighten screw (A).

On styles 81200SM loosen the feed dog fastening screw and move the needle guard accordingly. Retighten screw and make sure that the feed dog rests on the supporting screw in the feed bar.

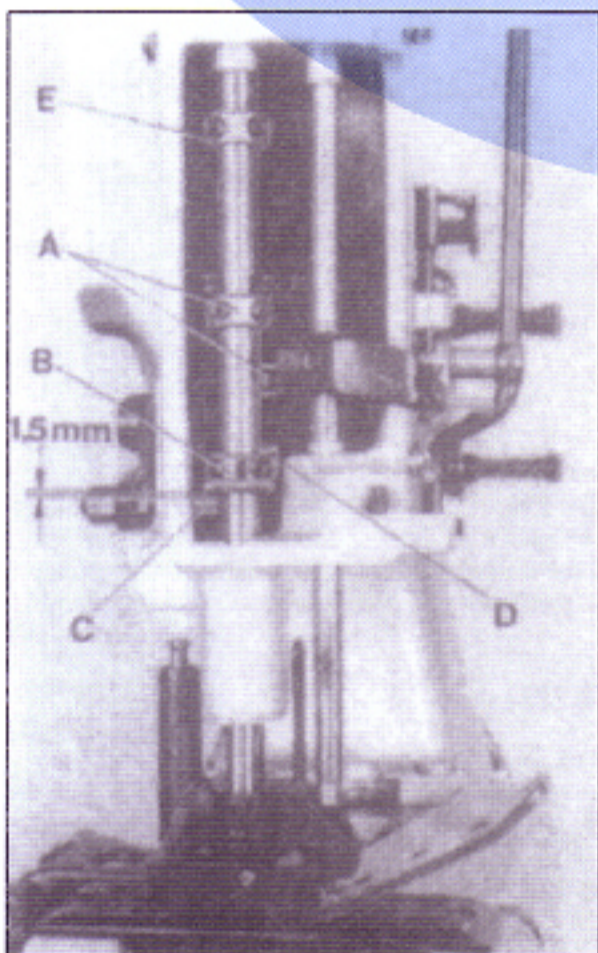


Fig. 7

#### ROLLER FEED PRESSURE

Rotate the pulley until the feed dog is below the throat plate. Remove the face cover left on machine arm and turn out the T-screw (H, Fig. 8) on the top of the machine arm, until it does not exert any pressure on the leaf springs. In this position, the pressure exerted on the presser foot, should be just strong enough to keep it flat on the throat plate. By relocating the collars (A, Fig. 7), which serve as a leaf spring rest, on the left and right presser bar, the pressure can be changed. Raising the collars increases the pressure, lowering the collars decreases the pressure.

Set the presser bar lifter collar (B, Fig. 7) on the left presser bar so, that there is a distance of approx. 1.5 mm (1/16 in.) between lifter lever stud (C) and lower surface of the lifter collar (B), when the presser foot rests on the throat plate (see Fig. 7). Set the collar (D) on the right presser bar close to the fork of the presser bar lifter collar (B) on the left presser bar. The presser foot lift is limited with the upper stop collar (E, Fig. 7) on the left presser bar. When the needle is in its lowest position and the presser foot is lifted with presser foot bottom tilted up, the needle bar respectively needle clamp nut should not contact the presser foot bottom. Set collar (E) accordingly.

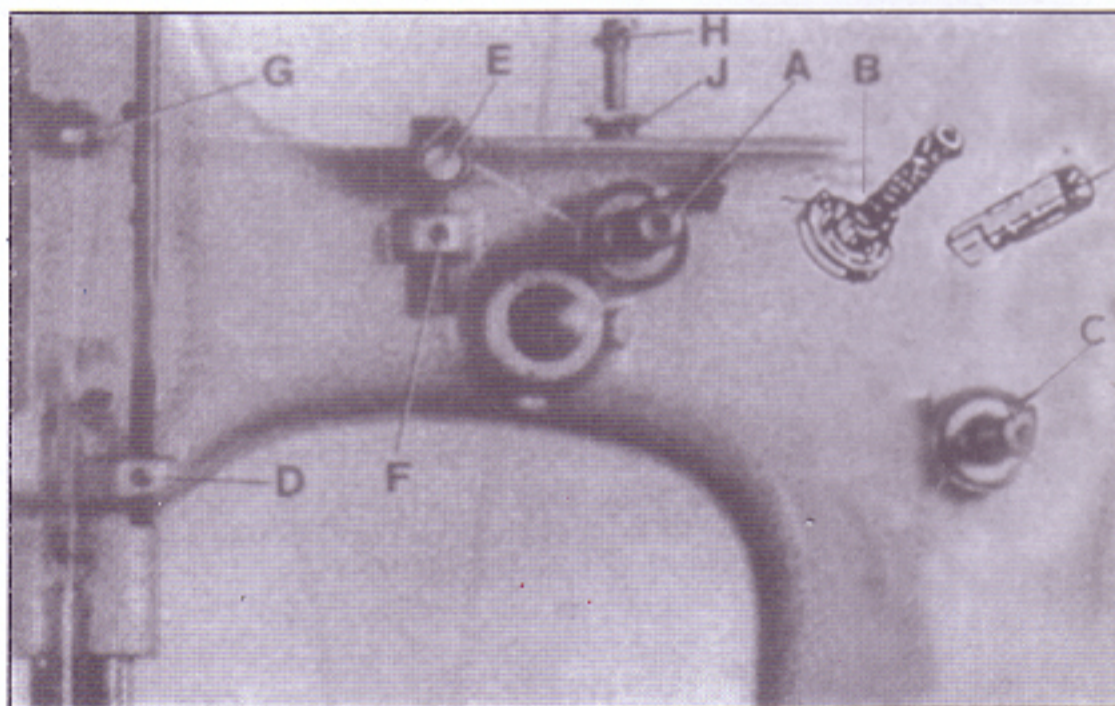


Fig. 8



Now turn in T-screw (H, Fig. 8) until the necessary presser foot pressure for proper feeding is exerted (determine via sewing tests). Secure this setting with the knurled nut (J), which simultaneously fastens the upper arm cover. Remount the face cover.

#### THREAD TENSION

The tensions (A&B, Fig. 8) on the needle thread should be fairly strong to produce uniform stitches. The tension (C) on the looper thread should be barely sufficient to steady it.

#### LOOPER THREAD TAKE-UP

On the two thread double locked stitch styles, the height of the looper thread take-up (A, Fig. 9) is set so, that the cast-off hook (C) forces the looper thread over the corner (B) of the looper thread take-up (A) at the time the point of the descending needle is flush with the lower edge of looper or projects up to 1 mm (0.040") below the lower edge of looper.

Draw the looper thread into the machine, rotate pulley in operating direction and note the position of the needle point to lower edge of looper at the time the cast-off (C) forces the looper thread over the corner (B).

For setting the looper thread take-up loosen screw (D, Fig. 9). When needle point is positioned above the lower edge of looper, the looper thread take-up (A) has to be raised accordingly. When the needle point is positioned more than 1 mm (0.040") below the lower edge of looper, the looper thread take-up (A) has to be lowered accordingly. Retighten screw (D).

#### SETTING NEEDLE THREAD TAKE-UP ROLLER AND EYELET

On the two thread double locked stitch styles 80800C, E, H and HA, the height of the needle thread take-up roller (C, Fig. 8) is set so that the needle thread on the downstroke of the needle just contacts the roll at the time the needle thread loop is released from the looper. Loosen screw (D) and set the needle thread take-up roller accordingly. Retighten screw (D).

On the single thread chain stitch style 80800D the needle thread take-up roller (C) should be positioned so as not to contact the needle thread at any time.

On all styles the eyelet (E, fig. 8) should be positioned so, that the needle thread runs nearly horizontal, parallel to cloth plate, between eyelet (G) on needle bar connection and eyelet (E) on machine arm, when the needle is in its upmost position. Eyelet (E) is secured by screw (F).

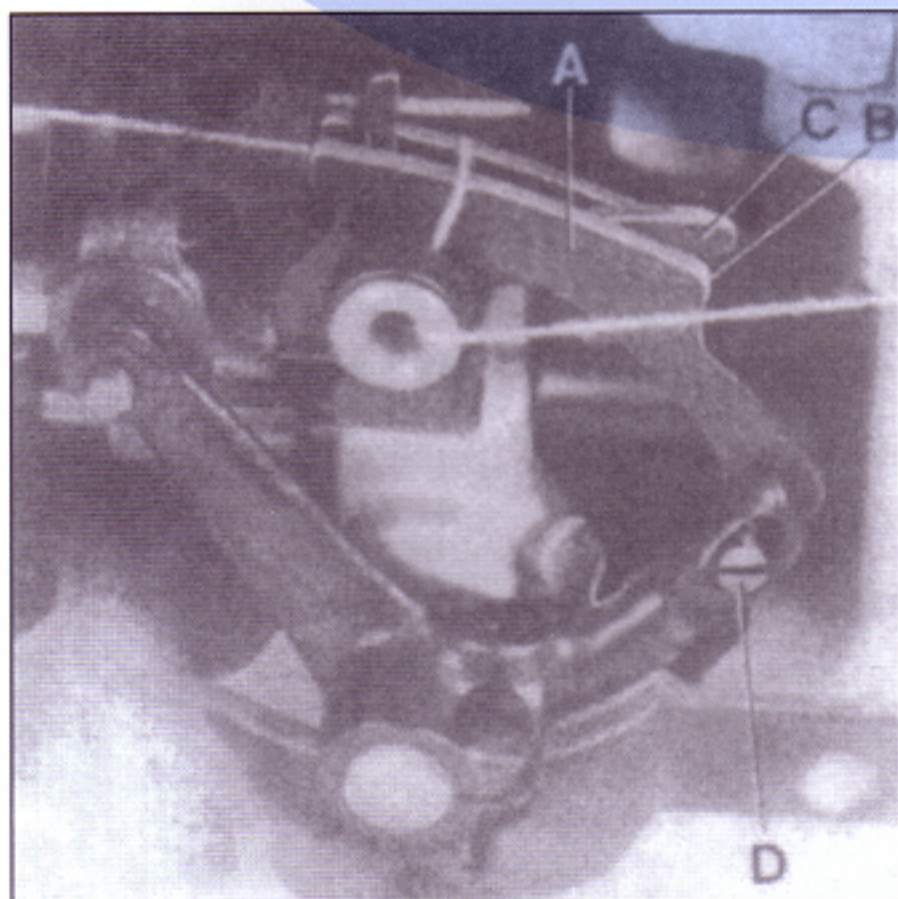
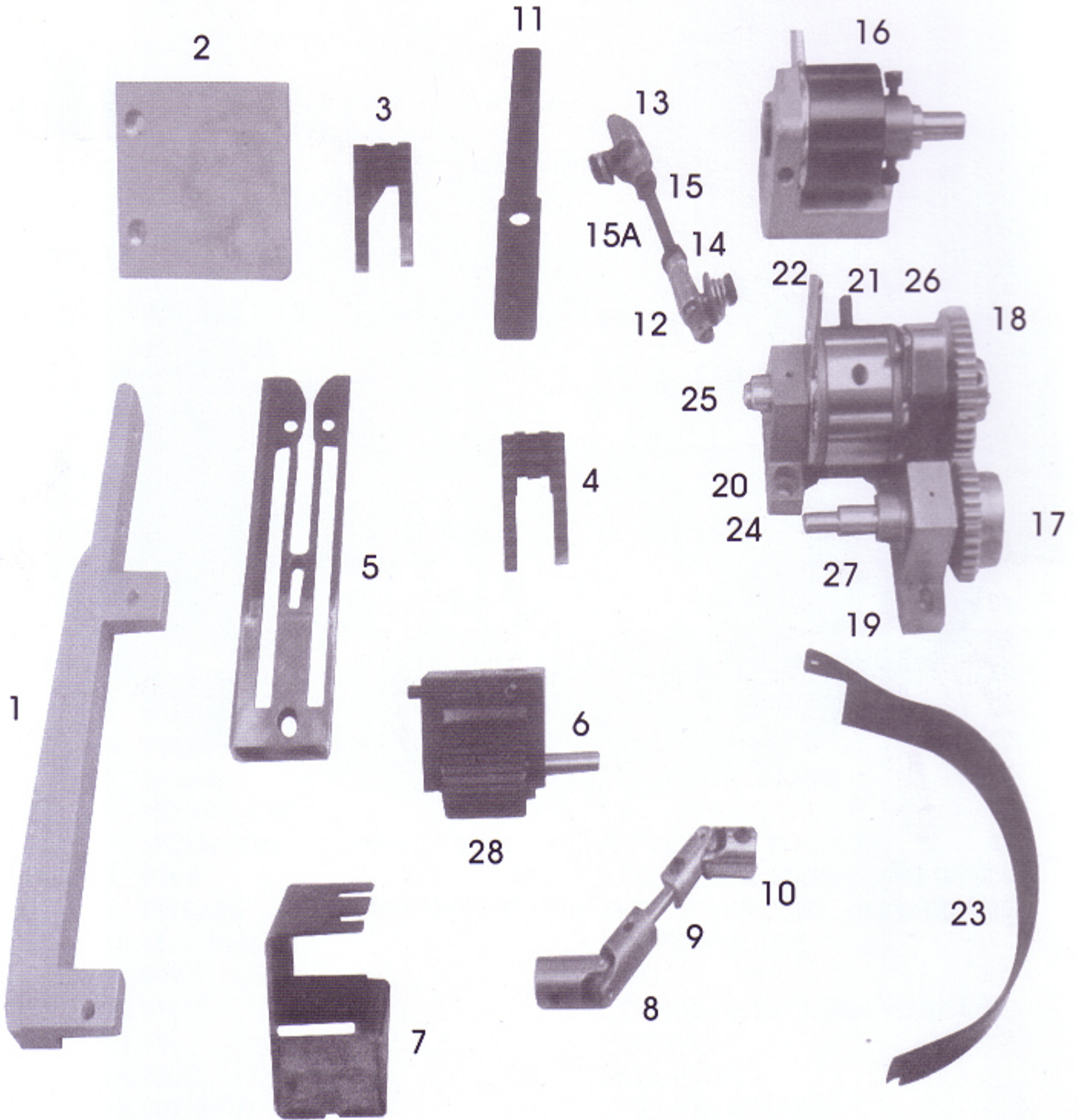


Fig. 9





# SPECIAL PARTS FOR 81200S/SM



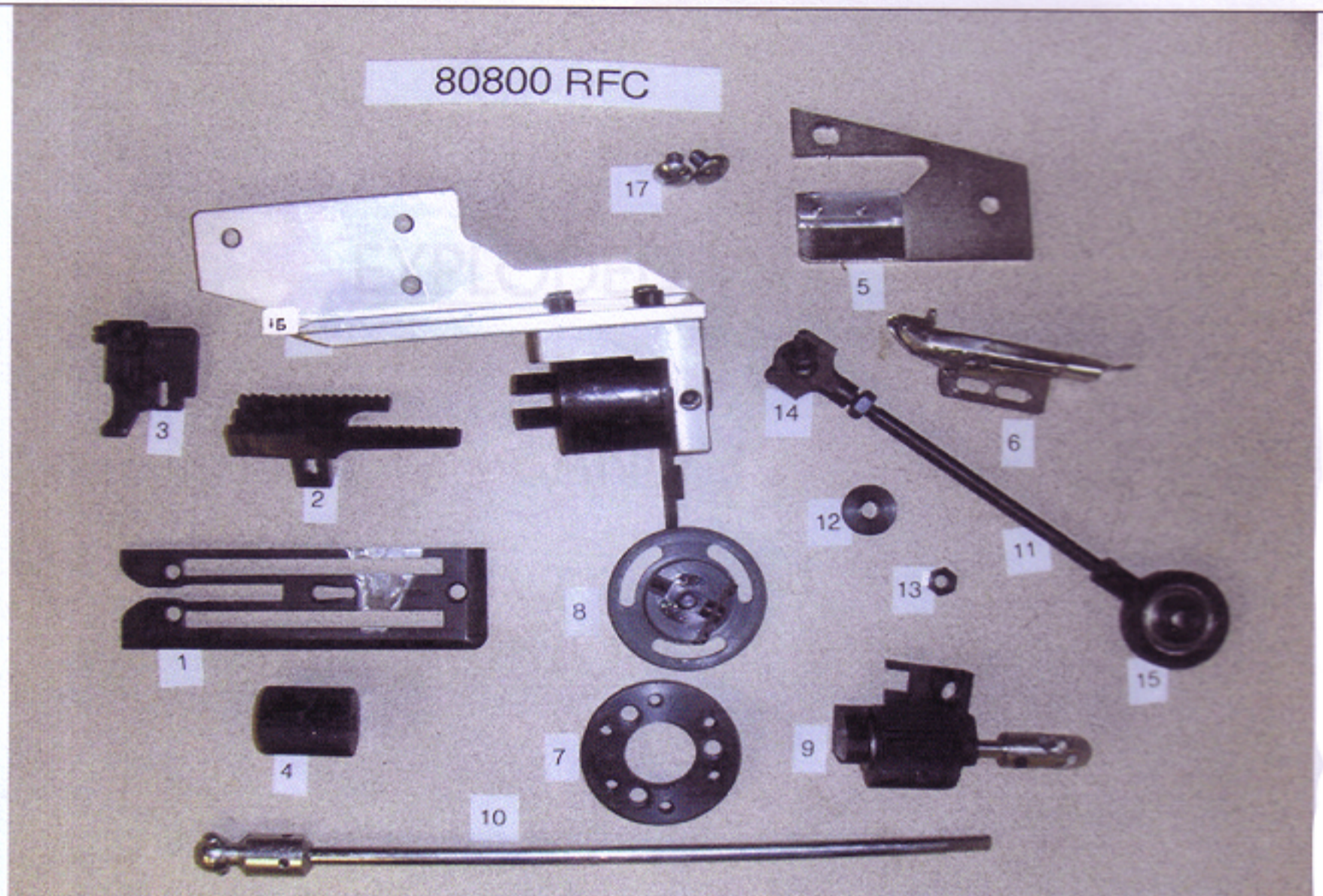


## SPECIAL PARTS LIST FOR 81200S/SM

Ref. No.	Part No.	Description
1	80S-7A	REAR PULLER BLOCK SUPPORT
2	80S-7	REAR PULLER BLOCK
3	80S-11M	FEED DOG FOR 81200SM
4	80S-11	FEED DOG FOR 81200S
5	80S-10	NEEDLE PLATE
6	80S-5	BRACKET F/81200S/SM
7	80698A	THREAD LUBRICATOR
8	51239G	UNIVERSAL
9	PS407	CONNECTING SHAFT
10	660-239	UNIVERSAL
11	80S-8	FOLDER BASE FOR S CLASS
12	6038K	BALL JOINT
13	6039K	BALL JOINT
14	81241	BALL JOINT ROD
15	18	NUT
15A	269	NUT
16	M145	N/S CLUTCH W/BASE
17	H2430	BOSTON GEAR
18	036	GEAR
19	80S-4	TOWER (LARGE)
20	003	TOWER (SMALL)
21	PS513	O/S CLUTCH
22	M150	CLUTCH PLATE
23	80S-9	GUARD
24	80S-2	SHAFT (SHORT)
25	80S-1	SHAFT (LONG)
26	80S-12	CLUTCH DRIVEN TOWER
27	80S-3	COLLAR
28	PS504	FEED ROLLER W/SHAFT



**""LIST OF PARTS FOR""  
80800 RFC**

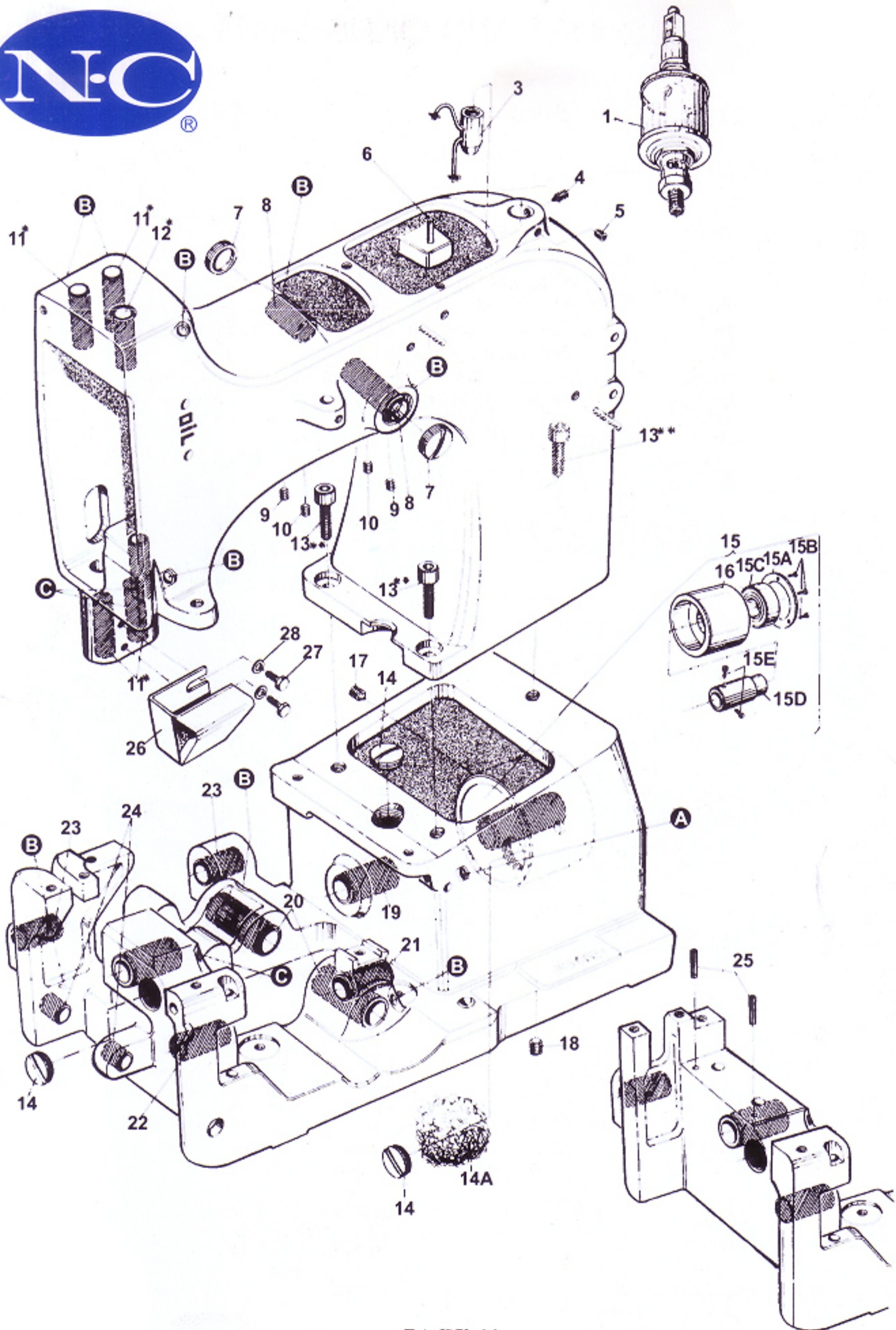


**PART #**

**DESCRIPTIONS**

1. 80624CRFC	NEEDLE PLATE
2. 80800FD	FEEDER
3. 80800FT	FOOT
4. PS506	FEED WHEEL
5. NC09S	MOUNTING PLATE
6. NC1011/4RFC	1 1/4" CF, RE, C
7. NC52921BS	HUB F/REAR PULLERS
8. P33S	FEED REGULATOR PLATE W/STUD
9. FWBASS	FEED WHEEL BKT. ASSEMBLY
10. M111R/M111	SHAFT W/JOINT
11. 049	ROD
12. 011	STEPPED SHOULDER WASHER
13. 18	NUT F/049
14. 050C	BALL JOINT
15. 007/007B	STRAP W/BEARING
16. M145	CLUTCH W/BASE COMPLETE
17. 25LS	1/4X20 SCREWS







# BUSHINGS AND OILING PARTS

Ref. No.	Part No.	Description
1	666-79	Sight Feed Oiler
3	80293A	Oil Distributor
4	22894K	Spot Screw, headless
5	22894J	Set Screw
6	80667	Pin
7	80644	Plug Screw
8	80846	Bushing for needle lever shaft
9	89	Set Screw for needle lever shaft bushing
10	88	Set screw for plug screw
11*	80862	Presser Bar Bushing (see note)
12*	80673B	Needle Bar Bushing (see note )
13**	95861	Screw (see note)
14	22539	Plug Screw
14A	WO3	Wick Yarn, length 50 mm (2") (please specify length when ordering)
15	80885	Ball Bearing Assembly for crankshaft
15A	80885C	Retaining Ring
15B	22596D	Screw
15C	999-106D	Deep Groove Ball Bearing
15D	80885B	Hub
15E	22891	Screw
16	80885A	Bearing
17	HA81	Spot Screw for crankshaft bearing housing
18	HA95	Set Screw for crankshaft bearing housing
19	80694DA	Bushing for crankshaft
20	80640EA	Bushing for looper driver lever rocker shaft
21	80639EA	Looper Shaft Bushing, right
22	80639FA	Looper Shaft Bushing, left
23	80692EA	Feed Ricker Shaft Bushing
24	80692DA	Knife Lever Shaft Bushing
25	96657	Clamping Sleeve for tape cutter for Styles 80800H and HA
26	80698A	Thread Lubricator for Style 81200S/SM
27	79048	Hexagonal Head Screw
28	69H	Washer

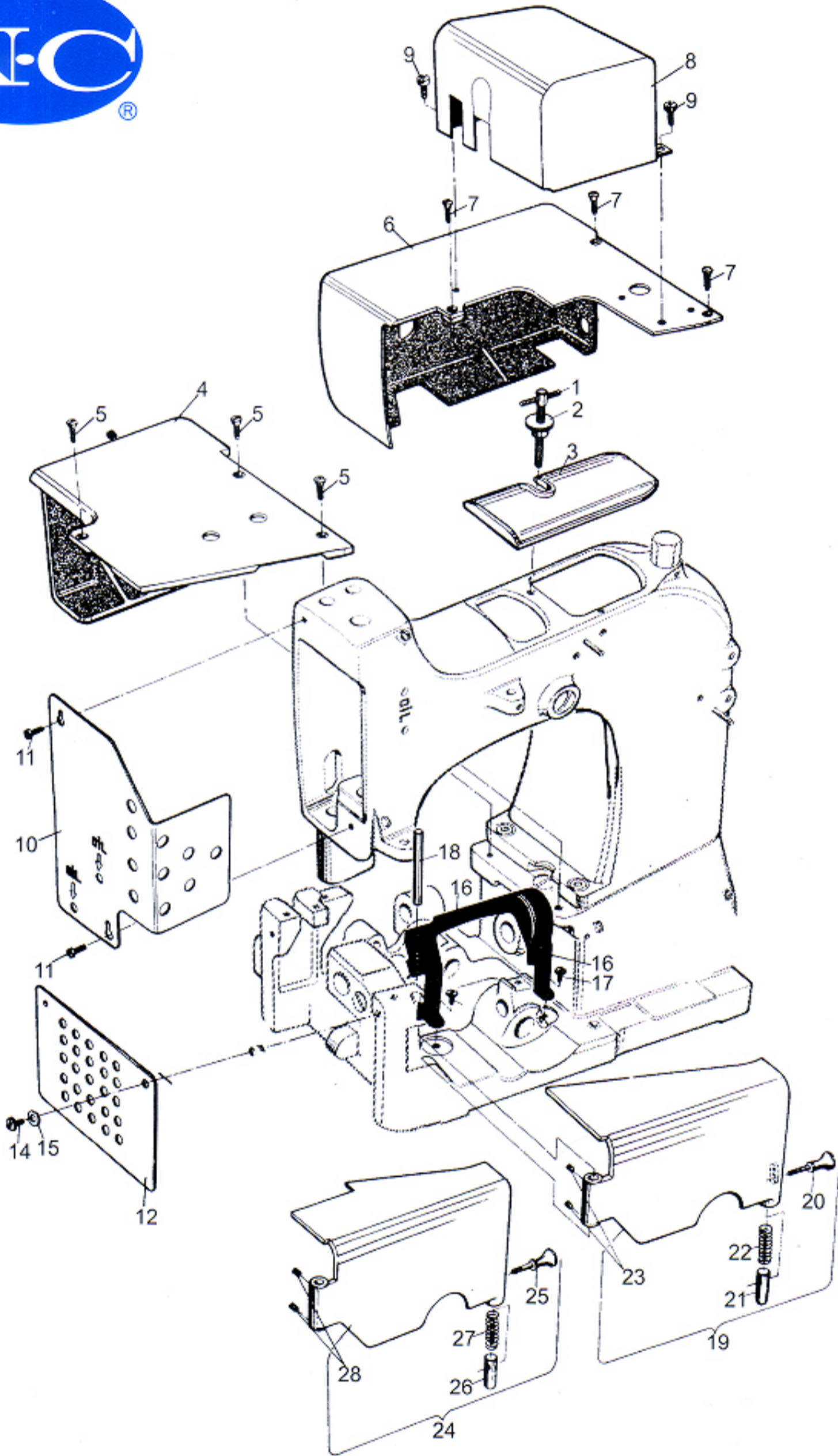
\* NOTE The presser bar bushings and the needle bar bushings are cemented in the bed casting therefore we recommend to order the following repair sets for renewing the bushings.

**29916REB Repair Set for renewing the Needle Bar Bushings, consists of**  
 80673B Needle Bar Bushing  
 80689C Oiler  
 999 114B Superfast Engineering Adhesive  
 D229185 Instruction  
 D229327 Instruction

**29916REE Repair Set for renewing the Presser Bar Bushings, consists of**  
 80862 Presser Bar Bushing  
 999 114B Superfast Engineering Adhesive  
 G41046G Oiler  
 80689D Oiler  
 D229818 Instruction  
 D229327 Instruction

\*\* Torque for screw No. 95861 (Ref. No.13) 25Nm (220 in lbs)The screw has to be secured with the superfast engineering adhesive part No 999 114B



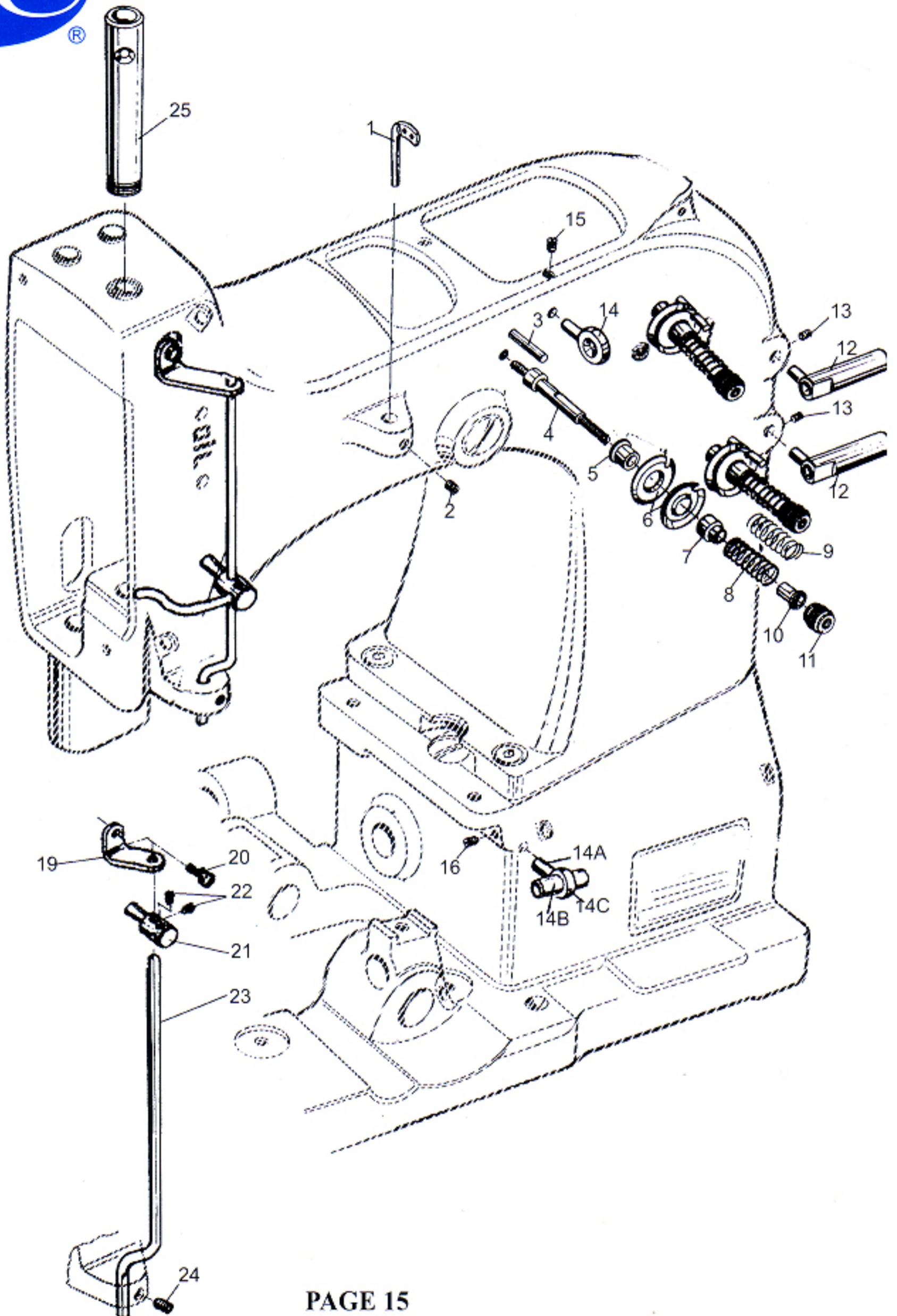




# CLOTH PLATES AND MISCELLANEOUS COVERS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>
1	64Y	T-Screw
2	35733B	Knurled Nut
3	80888	Arm Cover
4	80601E	Cloth Plate for Styles 80800C, D and E
5	22574	Countersunk Screw
6	80601G	Cloth Plate for Styles 80800H and HA
7	22574	Countersunk Screw
8	80897	Tape Cutter Housing for Styles 80800H and HA
9	93A	Screw
10	80887A	Face Cover
11	22528	Screw
12	80683	End Cover
14	92121	Shoulder Screw
15	J1614	Spring Washer
16	80284H	Guard
17	94	Screw
18	8564	Hinge Pin
19	80601D	Hinge Cover Assembly for Styles 80800C, D and E
20	80440	Locking Bolt Knob
21	81239	Locking Bolt
22	80438	Spring
23	89	Set Screw
24	806011	Hinge Cover Assembly for Styles 80800H and HA
25	80440	Locking Bolt Knob
26	81239	Locking Bolt
27	80438	Spring
28	89	Set Screw



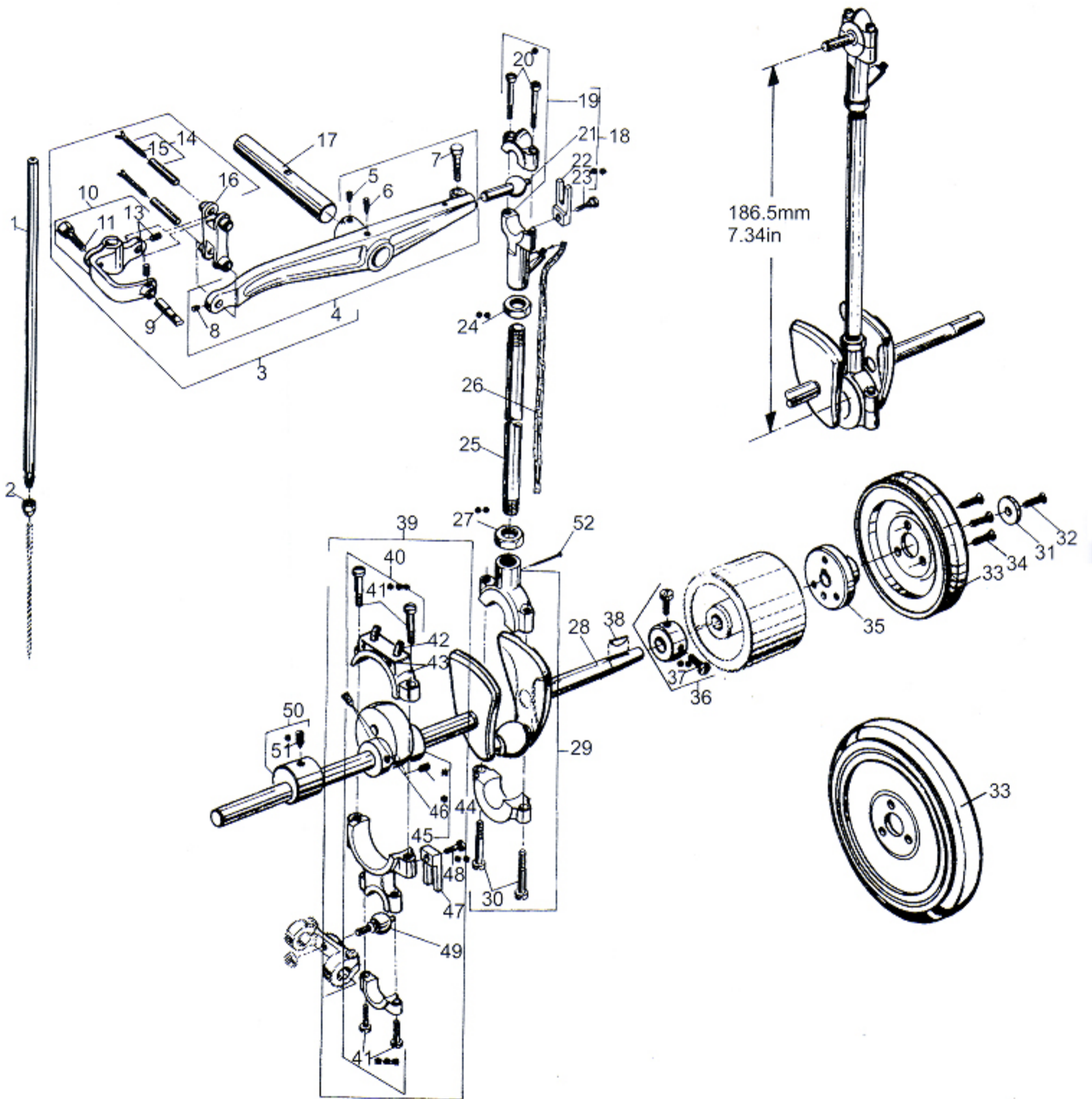




# THREAD TENSIONS, THREAD GUIDES AND NEEDLE BAR GUARD

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>
1	80858AX	Needle Thread Guide
2	22894AD	Set Screw
3	80667	Pin to Tension Discs
4	HS106	Tension Post
5	HA1348	Tension Post Ferrule
6	80676A	Tension Disc
7	HA1349	Tension Sleeve
8	110-4	Spring for needle thread tension
9	110-3	Spring for looper thread tension
10	107	Tension Spring Ferrule
11	108	Tension Nut
12	81256A	Thread Sleeve
13	22560B	Set Screw
14	AS137A	Thread Eyelet
14A	80858BX1	Holder
14B	80858BX2	Ferrule
14C	28C	Set Screw
15	22560B	Set Screw
16	22894AD	Set Screw
19	80865QX	Bracket
20	136A	Screw
21	80865MX	Needle Thread Take Up
22	88	Set Screw
23	80865PX	Support
24	22894AD	Set Screw
25	80673CB	Needle Bar Guard



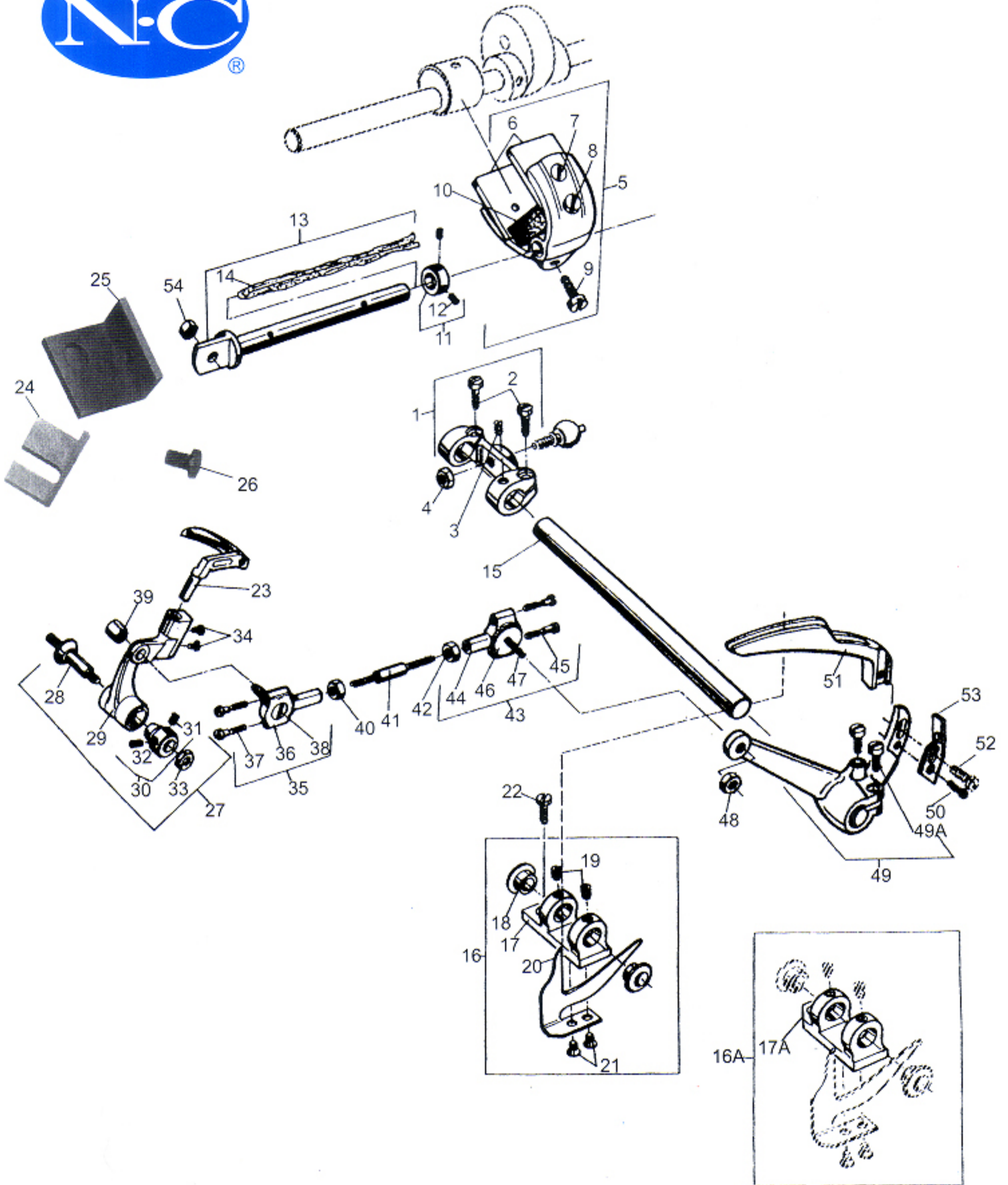




# NEEDLE BAR, NEEDLE LEVER, CRANK SHAFT, PULLEY LOOPER DRIVE AND LOOPER AVOID ECCENTRIC

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>
1	80617	Needle Bar
2	HA56	Needle Clamp Nut
3	G29479PA	Needle Lever Assembly
4	80615A	Needle Lever
5	22894AD	Set Screw
6	22894K	Spot Screw
7	22811	Screw
8	22894Y	Set Screw
9	G334	Thread Eyelet
10	80659B	Needle Bar Connection
11	BP108	Screw
13	22894Y	Set Screw
14	51134Y	Link Pin, Cyl.
15	666-260	Oil Wick
16	HA54B	Connecting Link
17	80643	Needle Lever Shaft
18	29066LA	Needle Lever Ball Link
19	80650LA	Shell
20+	22587	Screw
21	80656	Ball stud
22	80636A	Guide Fork
23**	G22515A	Screw
24++	80630C	Nut, left hand thread
25	80630	Needle Lever Connecting Rod
26	80630G	Oil Felt
27++	80630D	Nut, right hand thread
28	80822	Crank Shaft
29	80652	Shell
30	22587	Screw
31	80674	Lock Washer for pulley hub
32	80	Countersunk Screw
33	80621B	Pulley
33	B80621H	Pulley for Styles 81200S or SM
34	80	Countersunk Screw
35	80621A	Pulley Hub
36	80681	Collar
37++	22891	Screw
38	HA66K	Woodruff Key
39	29442N	Looper Drive Eccentric Assembly
40	80236	Connection
41***	88F	Screw
42	666-19	Oil Wick
43	P118	Pin for oil wick
44	80642	Eccentric
45*	22894L	Spot Screw, headless
46*	22894C	Set Screw
47	80636A	Guide Fork
48**	G22515A	Screw
49	80645	Ball Stud
50	AS38B	Looper Avoid Eccentric
51*	22894K	Spot Screw, headless
52	P118	Pin for oil wick



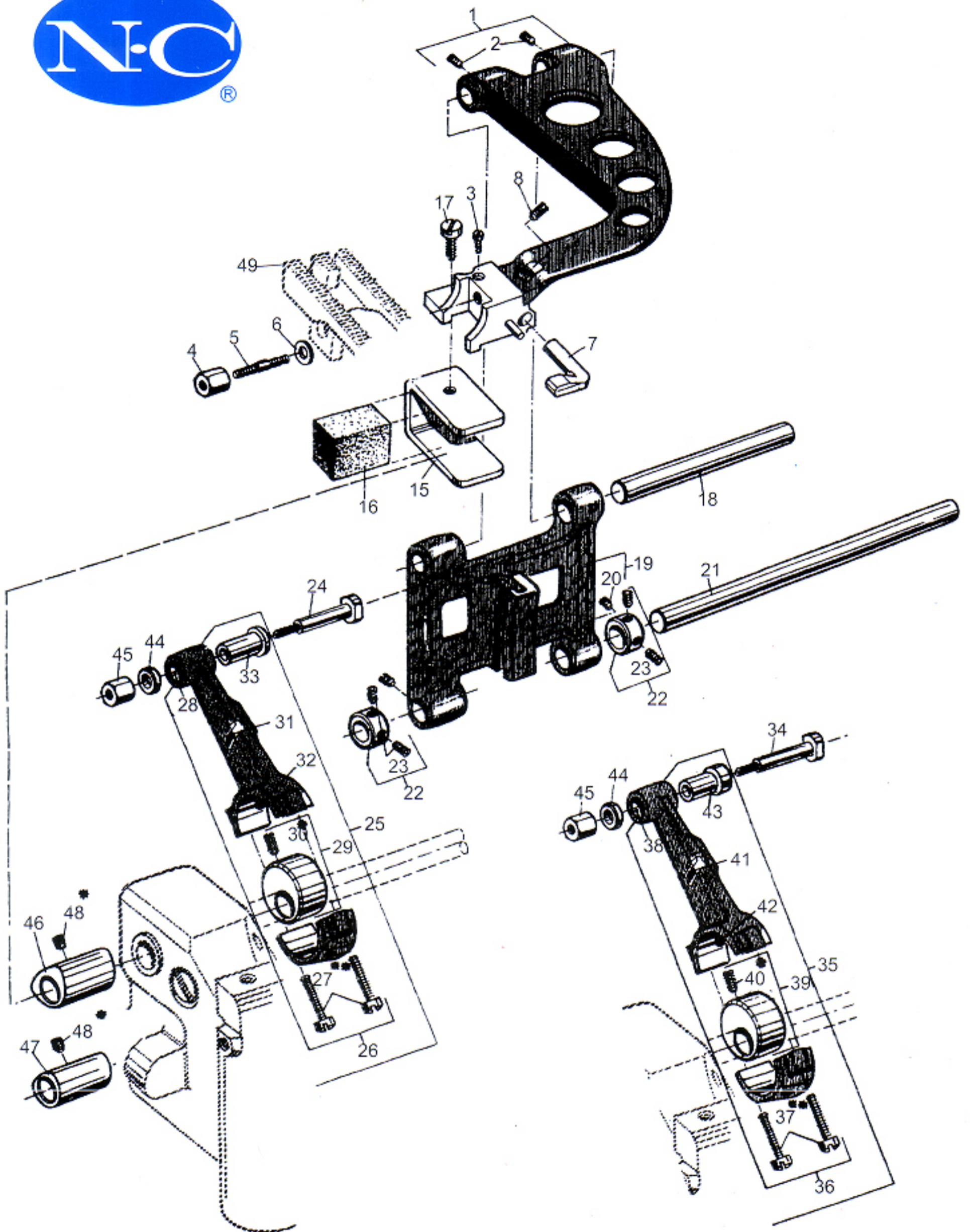




# LOOPER AVOID ECCENTRIC FORK, LOOPER, LOOPER DRIVE LEVER AND ROCKER, LOOPER THREAD CAST-OFF

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>
1	80638A	Rocker
2	136	Screw
3	96	Spot Screw, headless
4	80691	Nut
5	80680	Looper Avoid Eccentric Fork Assembly
6	80680B	Guide Plate
7	94	Screw
8	85	Screw
9	22811B	Screw
10	80634EC	Oil Felt
11	482C	Collar
12	22894C	Set Screw
13	80639	Looper Shaft
14	WO3	Wick Yarn, Length 0.6m(2") (please specify length when ordering)
15	80640	Looper Drive Lever Rocker Shaft
16	80653A	Looper Thread Cast-off Assembly for Styles 80800C and E
16A	806531	Looper Thread Cast-off Assembly for Styles 80800H and HA
17	80653B	Bracket for Styles 80800C and E
17A	80653H	Bracket for Styles 80800H and HA
18	HA102A	Thread Eyelet
19	22743	Set Screw
20	80604	Cast-off Hook
21	AS22D	Countersunk Screw
22	HA61D	Screw
23	AS26XA	Looper
24	8OS-13	Front Needle Guard
25	8OS-14	Front Needle Guard Base
26	90	Screw
27	29479	Looper Rocker Assembly
28	15745B	Cone Stud
29	80613A	Looper Rocker
30	15465F	Cone
31	88	Set Screw
32	88	Set Screw
33	12987A	Nut
34	73X	Screw for looper
35	80657A	Ball Joint Assembly
36	6040A	Shell
37	22729	Screw
38	237A	Ball Stud
39	HA18A	Nut
40	269	Nut, left hand thread
41	80641	Connecting Rod
42	18	Nut, right hand thread
43	80658A	Ball Joint Assembly
44	271E	Shell
45	22729D	Screw
46	HS36K	Washer
47	36E	Ball Stud
48	12538	Nut
49	80637X	Looper Drive Lever
49A	22517	Screw
50	22562B	Screw
51	80623	Looper Thread Take-up
52	22569	Screw
53	80858CX	Looper Thread Guide
54	1280	Nut for looper rocker



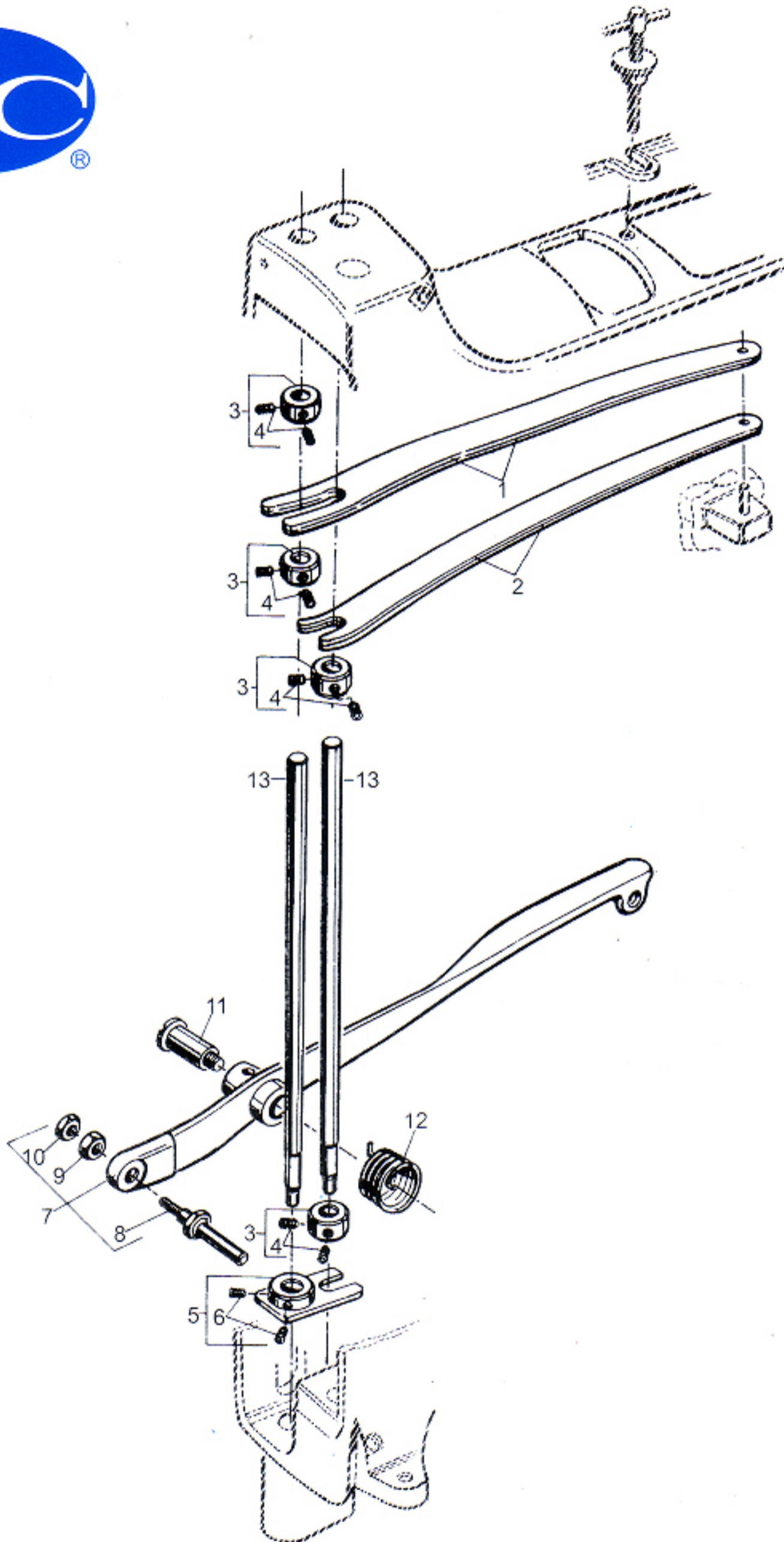




## FEED MECHANISM

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>
1	80634R	Feed Bar for Styles 80800c, D and E
2	89	Set Screw
3	97X	Feed Dog Supporting Screw
4	G5144	Nut for feed dog
5	80686C	Stud Bolt for feed dog
6	69H	Washer
7	80625	Needle Guard for Styles
8	HA95	Screw for needle guard
13	69H	Washer
14	80625H	Needle Guard for Styles
15	80634E	Feed Lift Eccentric Fork
16	80634EB	Oil Felt
17	93A	Screw for eccentric fork
18	11	Feed Bar Shaft
19	80633	Feed Rocker
20	89	Set Screw
21	8A	Feed Rocker Shaft
22	482C	Collar
23	22894C	Set Screw
24	80696	Stitch Regulating Stud for Styles 80800C, D and E
25	29099S	Feed Drive Eccentric Assembly for Styles 80800C, D and E
26	80651A	Connection
27**	22587	Screw
28	80651B	Bushing
29	80695A	Eccentric
30*	22894L	Spot Screw, headless
31	666-121	Oil Wick
32	666-19	Oil Wick
33	80654	Flange Bushing
34	HA20A	Washer
35	G29099M	Feed Drive Eccentric Assembly for Styles 80800H and HA
36	80651A	Connection
37**	22587	Screw
38	80651B	Bushing
39	80695A	Eccentric
40*	22894L	Spot Screw, headless
41	666-121	Oil Wick
42	666-19	Oil Wick
43	80654H	Flange Bushing
44	HA20A	Washer
45	HA18A	Nut for stitch regulating stud
46	80206	Feed Lift Eccentric for Styles 80800C, D and E
47	HA43X	Feed Lift Eccentric for Styles 80800H and HA
48*	22894D	Spot Screw, headless
49	NC80S-11	Feed Dog F/81200S
	NC80SM-11	Feed Dog F/81200SM

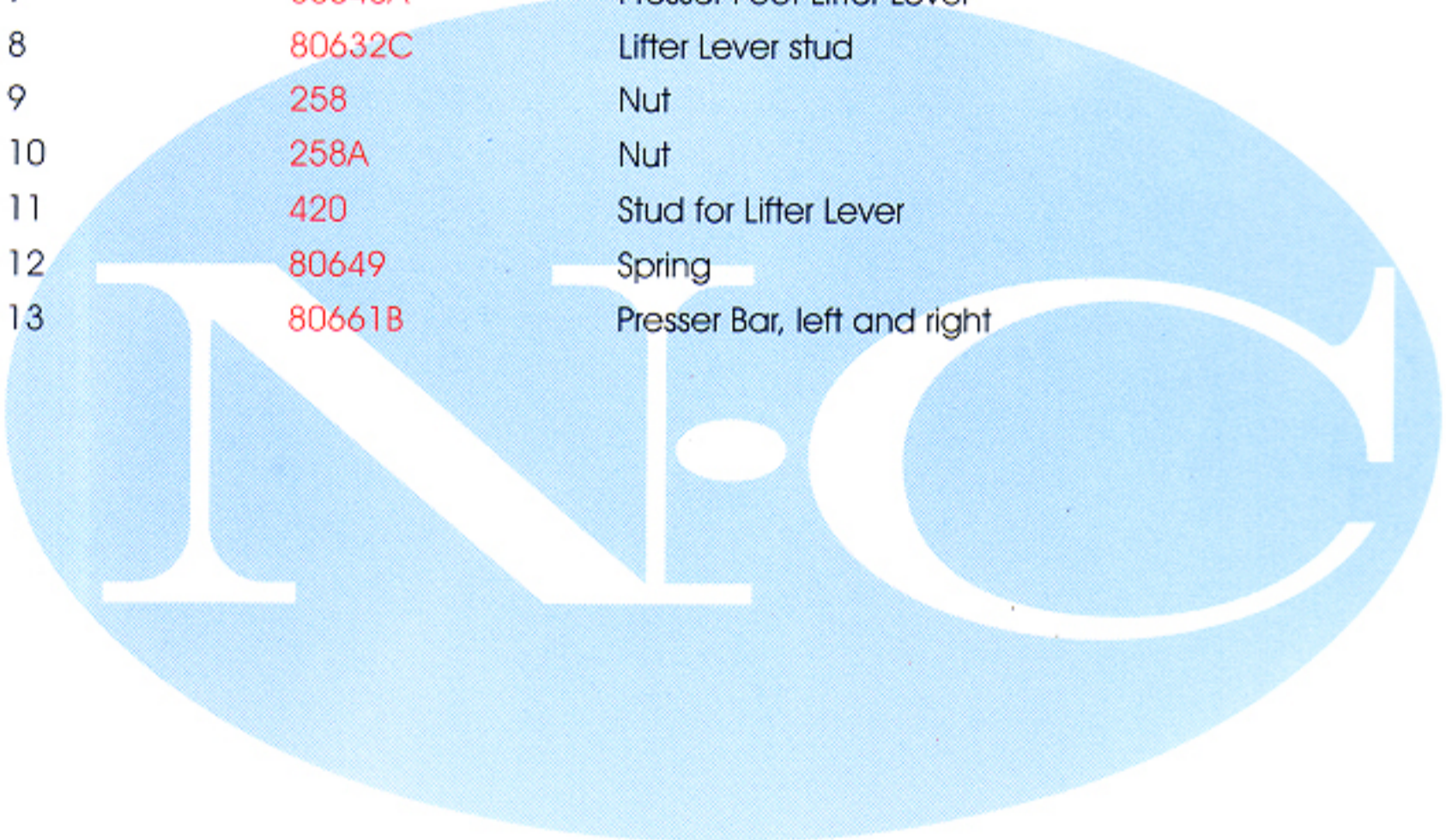






# PRESSER BAR, PRESSER BAR SPPINGS AND ROLLER FEED LIFTER PARTS

<u>Ref. No.</u>	<u>Part No.</u>	<u>Description</u>
1	80663	Leaf Spring, upper
2	80664	Leaf Spring, lower
3	482C	Collar
4	22894C	Set Screw
5	80666C	Presser Bar Lifter Collar
6	22894C	Set Screw
7	80648A	Presser Foot Lifter Lever
8	80632C	Lifter Lever stud
9	258	Nut
10	258A	Nut
11	420	Stud for Lifter Lever
12	80649	Spring
13	80661B	Presser Bar, left and right





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