

NC 252

TITAN 2500 SERIES



NC Binding & Equipment Corp. 973-481-3500

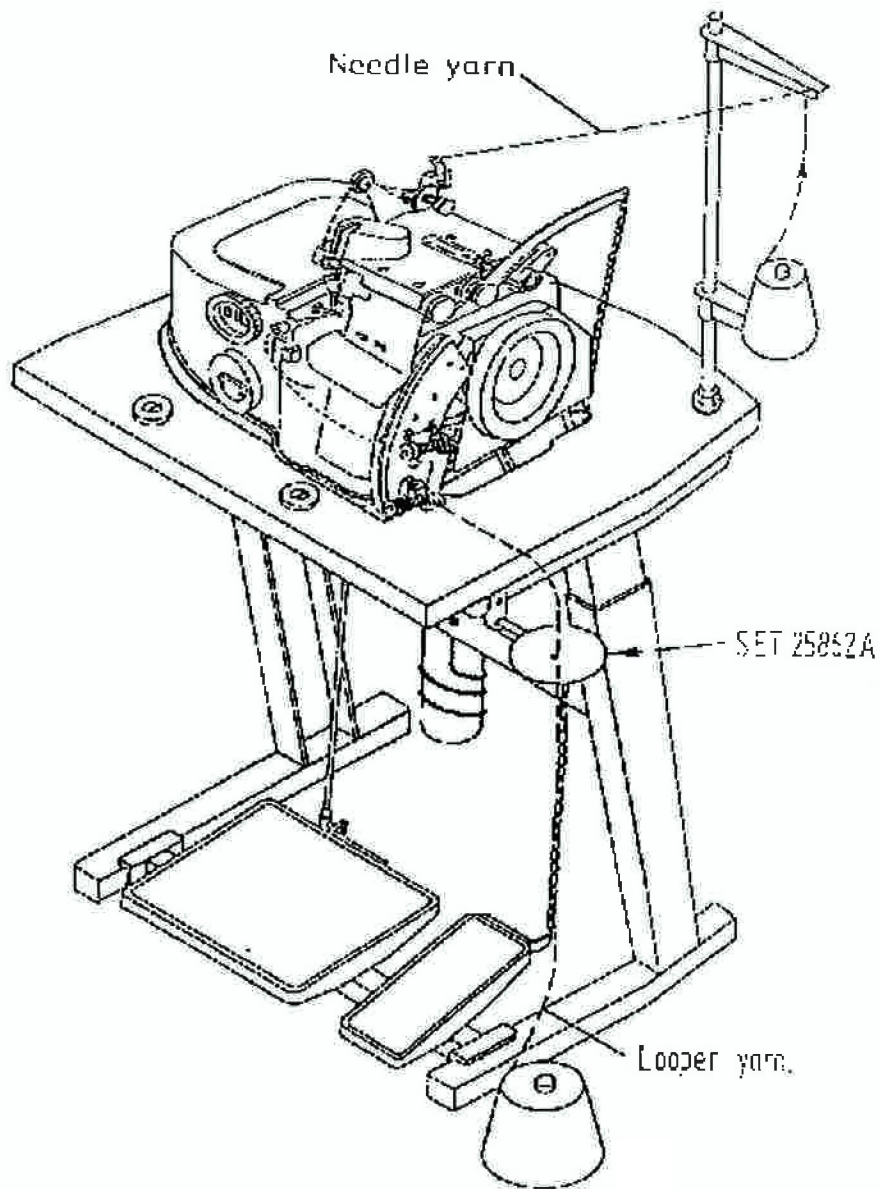
## INDEX

Setting up of the machine and lubrication .....	5
Threading of lower looper .....	7
Obtaining correct stitch .....	9
Cutting device .....	11
Carpet guide .....	12
Adjustment of loopers .....	13
Setting of number of stitches .....	14
Adjustment of needle bar .....	15
Adjustment after replacement of hooks .....	16
List of chain guides .....	18
Yarns & Feeddog .....	22
Presser foot .....	23
Knives .....	24
Noodles .....	25
Presser foot mechanism .....	27
Needlebar movement .....	29
Feeddog movement .....	31
Lower looper mechanism .....	33
Upper looper mechanism .....	35
Cutting device mechanism .....	37
Crank shaft .....	39
Fitting a puller (option) .....	41
Setting of length of stitch device (option) .....	48

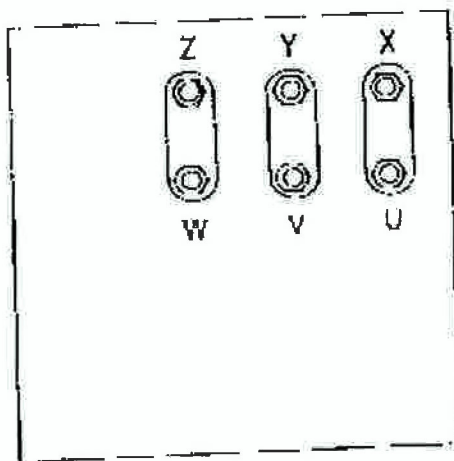
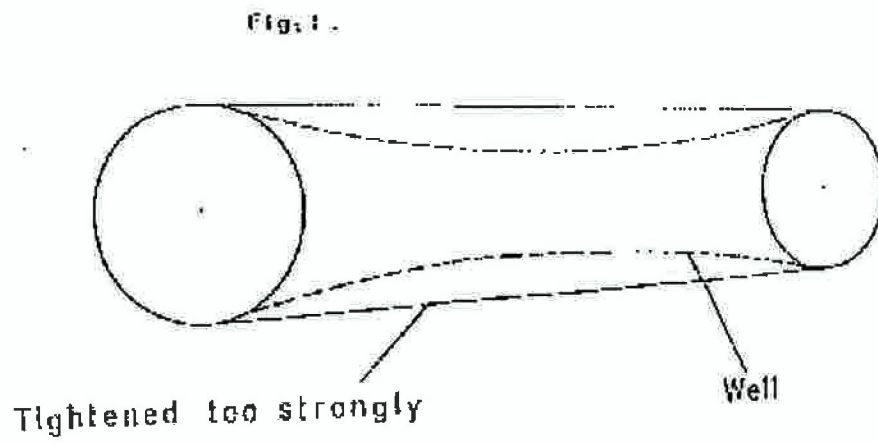
**WHEN ORDERING SPARE PARTS  
FOR LEFTHAND OVEREDGING  
MACHINE IDL-2501L, IDL-2502L, IDL-2503L  
PLEASE MENTION "L"  
AFTER THE REFERENCE NUMBER**

**IDL-2501 ,IDL-2502 ,IDL-2503**

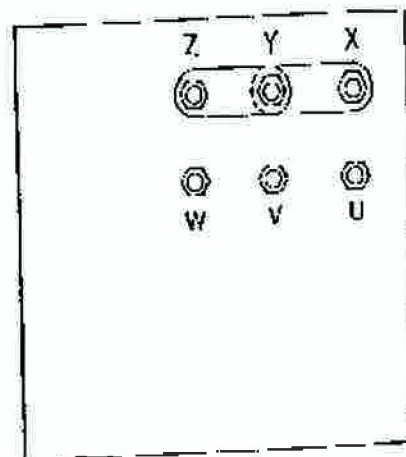
**FITTING INSTRUCTION FOR YARN STAND**







220 VOLT



380 VOLT

Fig. 2.

**IDL-2501 ,IDL-2502 ,IDL-2503**

### **SETTING UP OF THE MACHINE**

If the machine is supplied complete, assemble stand, table, motor, pedals and bobbin-holder with the help of the drawing of the manual. All bolts and screws are supplied so that there is no difficulty about it. When the machine has been erected, following controls should be carried out:

Voltage : motor is always supplied fitted for 380 V. If voltage of network is 220 V, change connections as shown fig.2.

Driving belt must be tightened too strong shafts could be deformed. For a correct belt tension look at fig. 1.

Before starting the machine, check oil level. The gauge must be full. Use only oil having a viscosity of 15W30 either SHELL Telus 37, BP Energol HLP46 or any other brand having the same viscosity.

When the machine has been supplied without stand, table or motor, a drawing in the manual will show how to cut out and drill the table top.

The motor must have a power of 1 HP or at least 3/4 HP at 3000 RPM and fitted with a V. belt pulley of 80 mm in diameter.

Afterwards check again a.m. points 1,2and 3.

### **LUBRICATION**

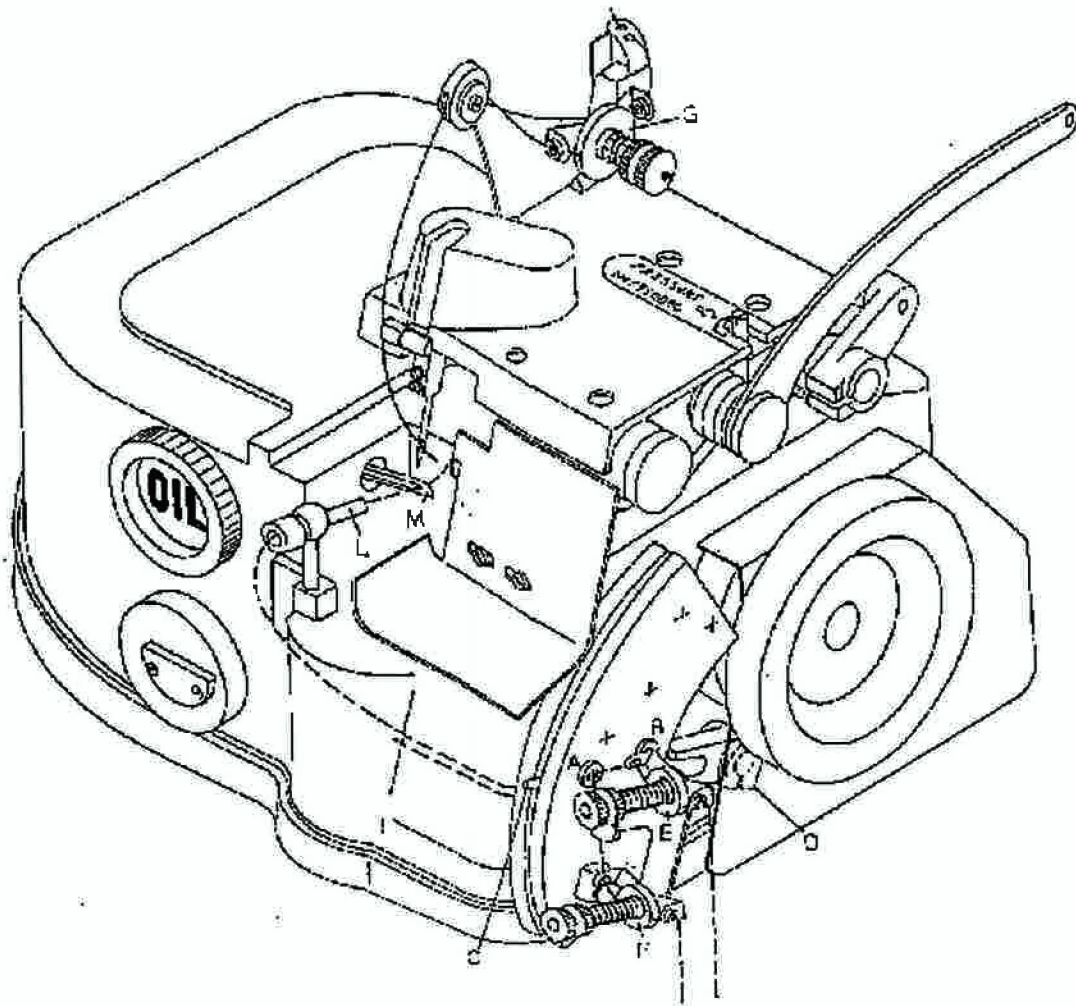
IDL-2501, IDL2502, IDL2503 are high precision machines. Although many parts move on ball bearings or needle-bearings, high speed makes an abundant lubrication necessary. For this reason the machine has been designed with a splash lubrication. Owing to a very special construction, all parts without exception are abundantly supplied with oil. Of course a little oil will disappear each day from the machine when working. As to enable the operator to check this steady and normal loss of oil, an level gauge has been fitted.

The perfect oil level is situated between both arrows printed on the oil level glass.

If there is too much oil leak. maybe one of the pipes for oil drainage is obstructed. In this case compressed air should be blown into the hole of the oil plug. To avoid the stopping up of the pipes. Then you will have enough pressure inside the machine to unstop the oil drainage pipes.

IDL-2501, IDL-2502, IDL-2503

THREADING DIAGRAM



### **THREADING DRAWING FOR THE LOWER LOOPER**

**In order to thread the yarn of the lower looper (M-fig:3.) one proceeds as follows : the motor is stopped, as soon as it has run out completely, the flywheel is rotated by hand until the take up (C-fig:3.) is very exactly in its lowest neutral position, so that the eye of the lower looper stands exactly opposite the leading tube (L-fig:3.). Yarn remainders, if any are removed from the leading tube, the threading needle is taken and the yarn is put in the fork, which is situated in front of the needle, and the yarn is glided through the tube (KL-fig:3.) exactly to the eye of the lower hook (M-fig:3.).**

**The threading needle is taken back and some yarn is still pressed in the threading tube so that there is a small clew of yarn behind the eye of the lower looper (M-fig:3.).**

**Never forget to remove the threading needle.**

**Rotate several times by hand until the yarn appears above the throat plate and the sitch has taken its normal shape.**

**It is possible to thread the lower looper with one or several yarns.**

FIG: 4



FIG: 5

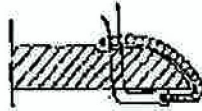


FIG: 6

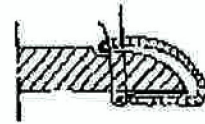


FIG: 7

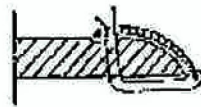


FIG: 8

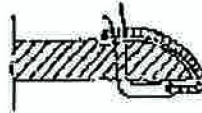


FIG: 9

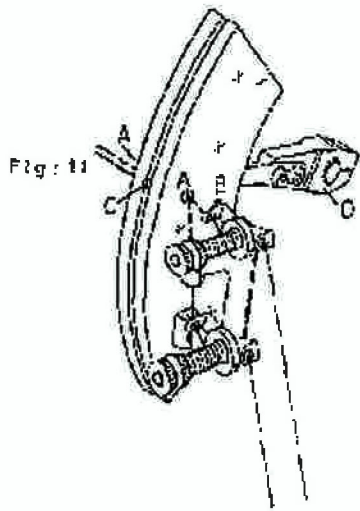


FIG: 11

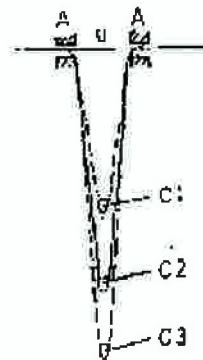


FIG: 10

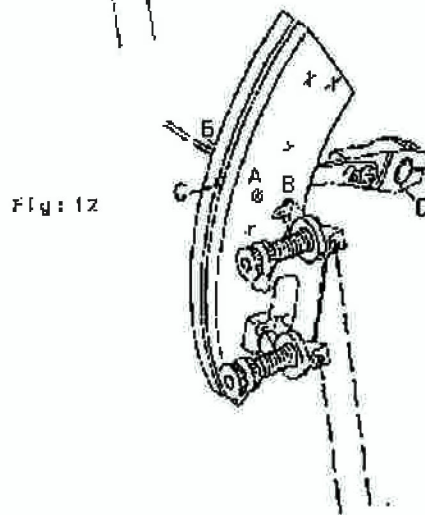


FIG: 12

IDL-2501, IDL-2502, IDL-2503

OVEREADGING MACHINE

## **OBTAINING CORRECT STITCH**

To obtain a correct stitch (fig. 4) tension regulating discs G,E and F (fig:3) are not very important.

They only restrain lightly the yarns so that the yarn drawing lever C (fig. 11.) will draw a well defined length of yarn.

Therefore it is advisable to tighten the tension regulating discs as slightly as possible.

The yarn drawing lever (fig:11) has an alternating movement. While moving down it draws along the yarn, which slips freely through the threading holes A. So a defined length of yarn is placed at the disposal of the upperlooper. If the lever is well adjusted, the length of yarn drawn will exactly be sufficient to surround the carpet edge, according to the width of stitch (fig.4 and C2 fig:10.)

If length of yarn draw is not sufficient (fig.5 and C1 fig:10), the tension of the needle thread and the tension of the looper thread will not be balanced. Consequently the needle thread will be drawn too far out of the carpet backside.

If the yarn drawing lever draws too much yarn (fig.6 and C3 fig:10.), then the looper thread surrounding the carpet edge will be slack, instead of keeping close to it.

To carry out this adjustment, loosen slightly screw D fig:11. of the lever, then put lever in the right position and tighten screw again.

To obtain a stitchdesign as shown on fig.7, it is generally sufficient to drive the thread along the thread along the threading holes (B-fig.12).

According to the nature of yarn and material which are used, an additional adjustment of the tension discs might have to be carried out.

**Fig. 7 :** The stitch is correct and there is a good balance between the needle yarn and looper yarn.

**Fig. 8 :** The tension on the looper yarn is too low, or that on the needle yarn too high.

**Fig. 9 :** The tension on the looper yarn is too high, or that on the needle yarn too low.

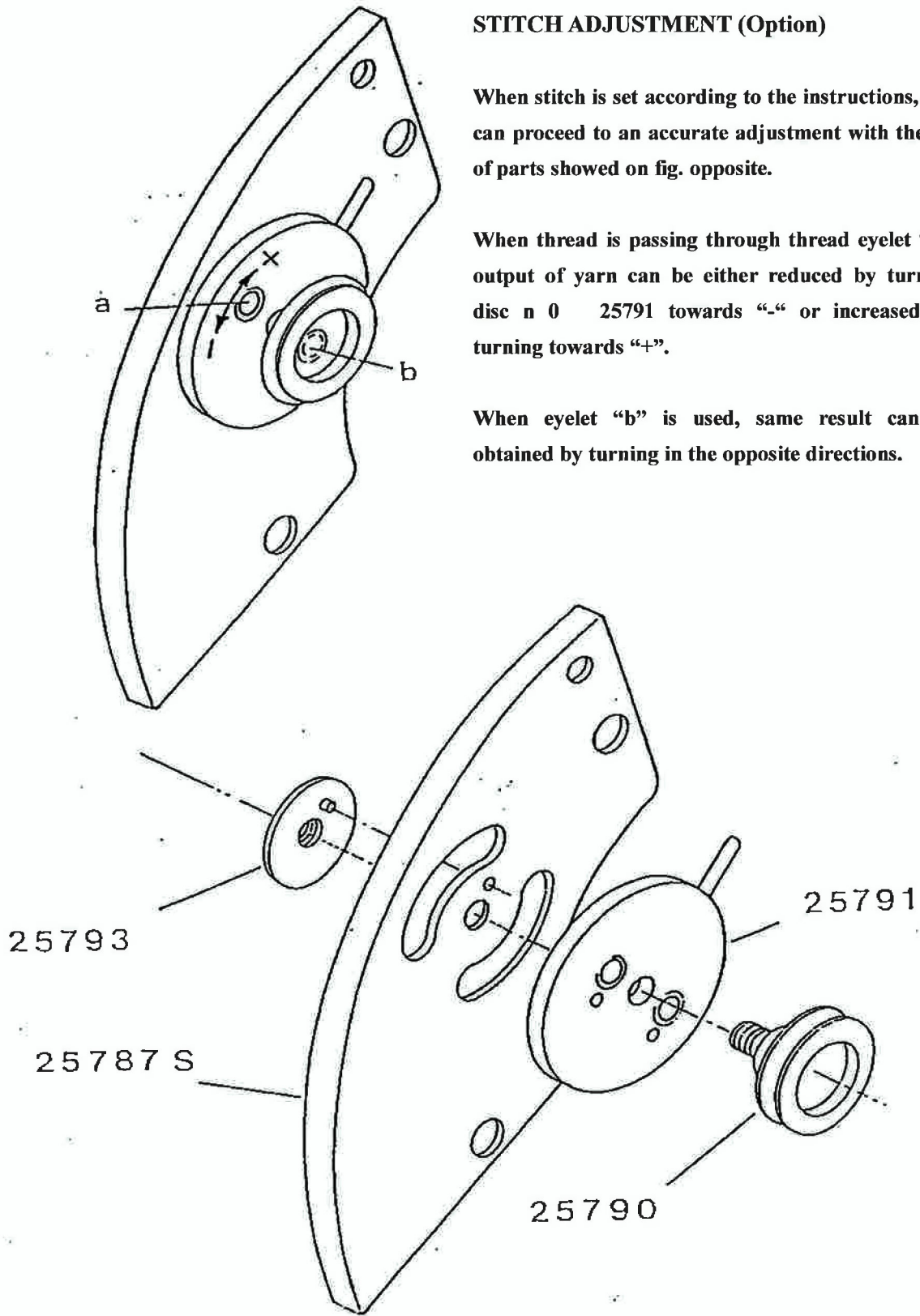


### STITCH ADJUSTMENT (Option)

When stitch is set according to the instructions, one can proceed to an accurate adjustment with the set of parts showed on fig. opposite.

When thread is passing through thread eyelet "a", output of yarn can be either reduced by turning disc n 0 25791 towards "-" or increased by turning towards "+".

When eyelet "b" is used, same result can be obtained by turning in the opposite directions.

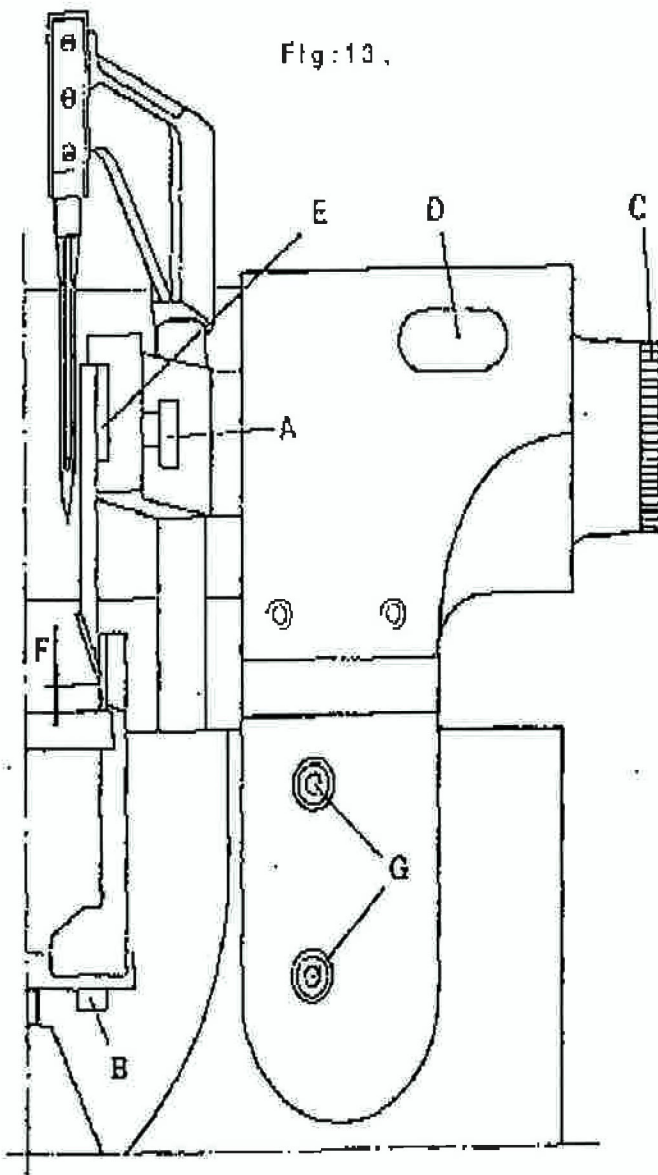


## CUTTING DEVICE

Both knives of the IDL-2501, IDL-2502, IDL-2503 overedging machine are lined with tungsten carbide. They can work for 3 months without being sharpened, if following directions are strictly observed:

When knives must be replaced, take good care that there will be no dirt or plush between fastening surfaces of knives and knives holders. A few pluses only may cause the knives to be irremediably destroyed within a short time.

When replacing knives, firstly loosen slightly handscrew C. (fig:13). Then untghten completely screw A of the upper knife without taking it out of its housing.



Screw B of the lower knife must be removed completely. Put the new knife exactly at the place of the old one and fasten it with screw B.

Afterwards the upper knife can be put on its place.

When turning handscrew C clockwise, the upper knife comes closer to the lower knife.

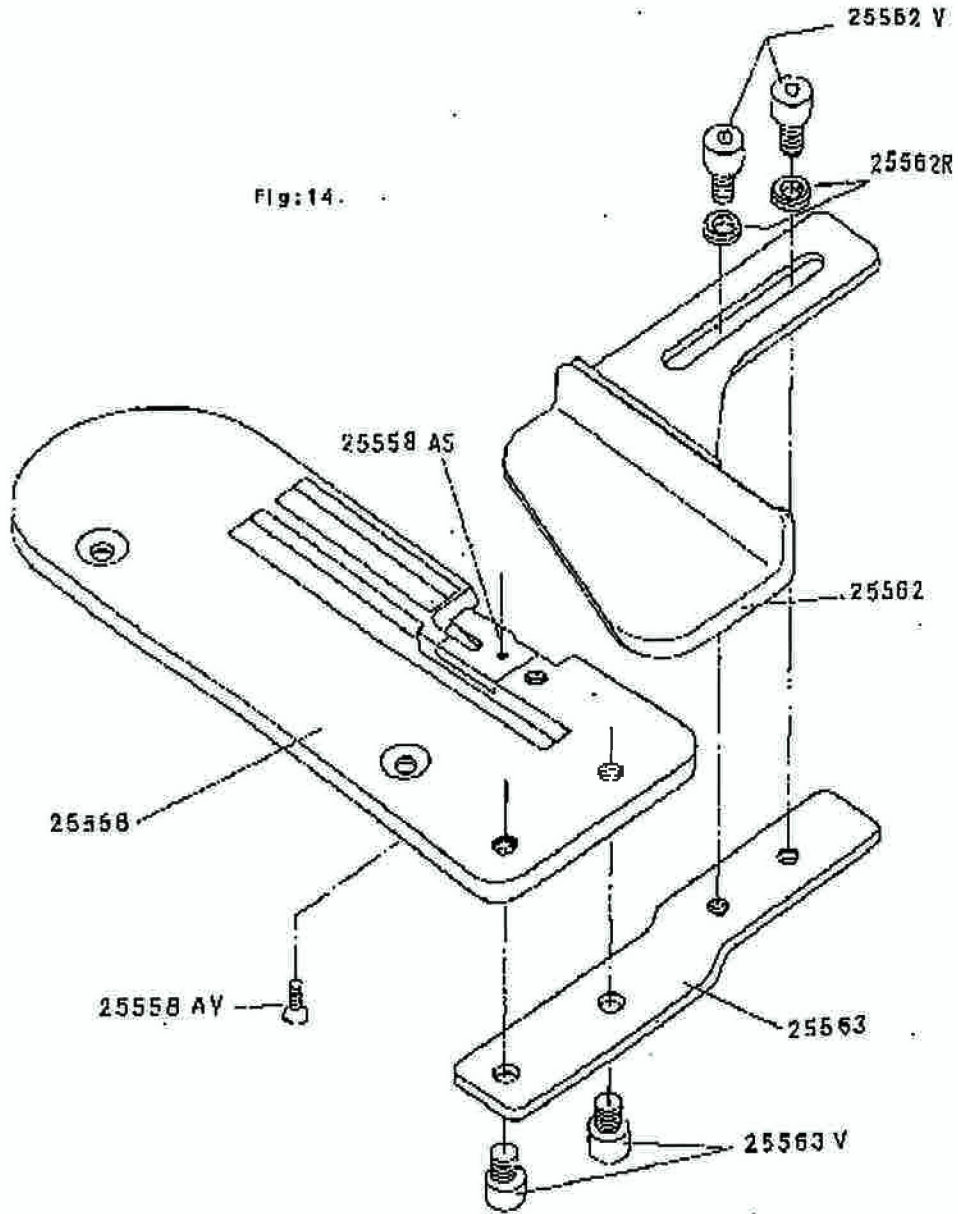
Both knives must touch, without exerting any pressure on each other.

When knives are resharpened some metal is lost and height of knives decreases. For that reason the upper knife must be lowered a little after each sharpening. Carry out this adjustment as follows : take off the protection plate. Loosen screw D and push the knife holder down.

**ATTENTION :** the cutting edge of the upper knife must be at 3 mm. Above needle-plate. (F:fig:13.). The lower knife (moving knife) may keep its position till many sharpenings have shortened it in such way that the replacement is required.

**CARPET GUIDE**

When no use is made of the cutting device, or if only a very small strip must be cut off from the carpet edge, then set the guide as shown hereunder.



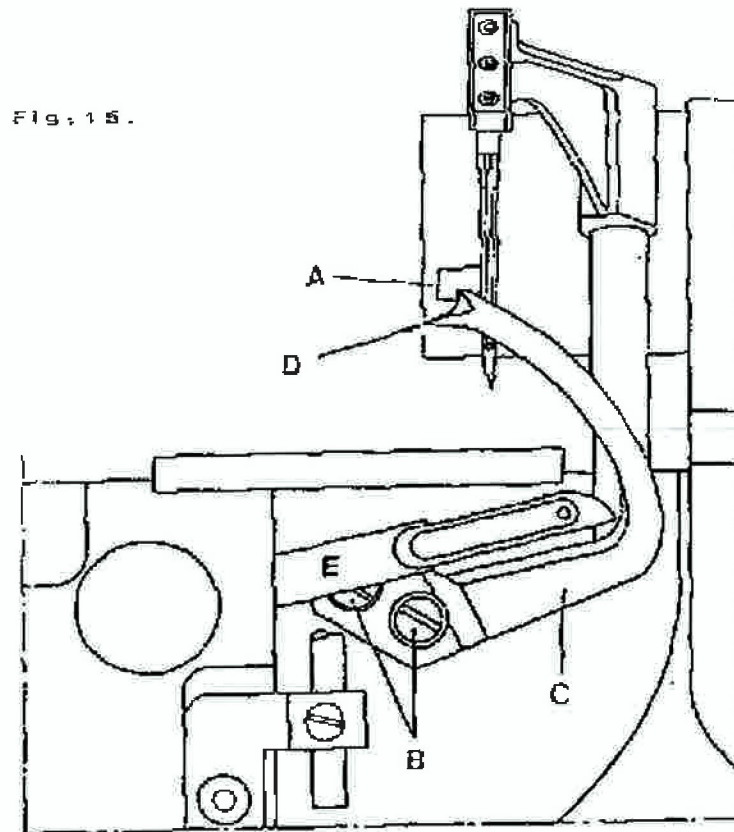
### ADJUSTMENT OF LOOPERS

When leaving the factory, the machine is adjusted for using yarns of medium quality and size. If yarns of lower quality are used, a little adjustment will perhaps be necessary. This adjustment will be performed by displacing upper looper C. (fig:15)

When upper looper is in its highest position, the take up of upper looper C will be situated at 4,5 mm of the needle (fig.15A).

When using certain types of yarns, this distance might have to be either increased or reduced by 1 mm.

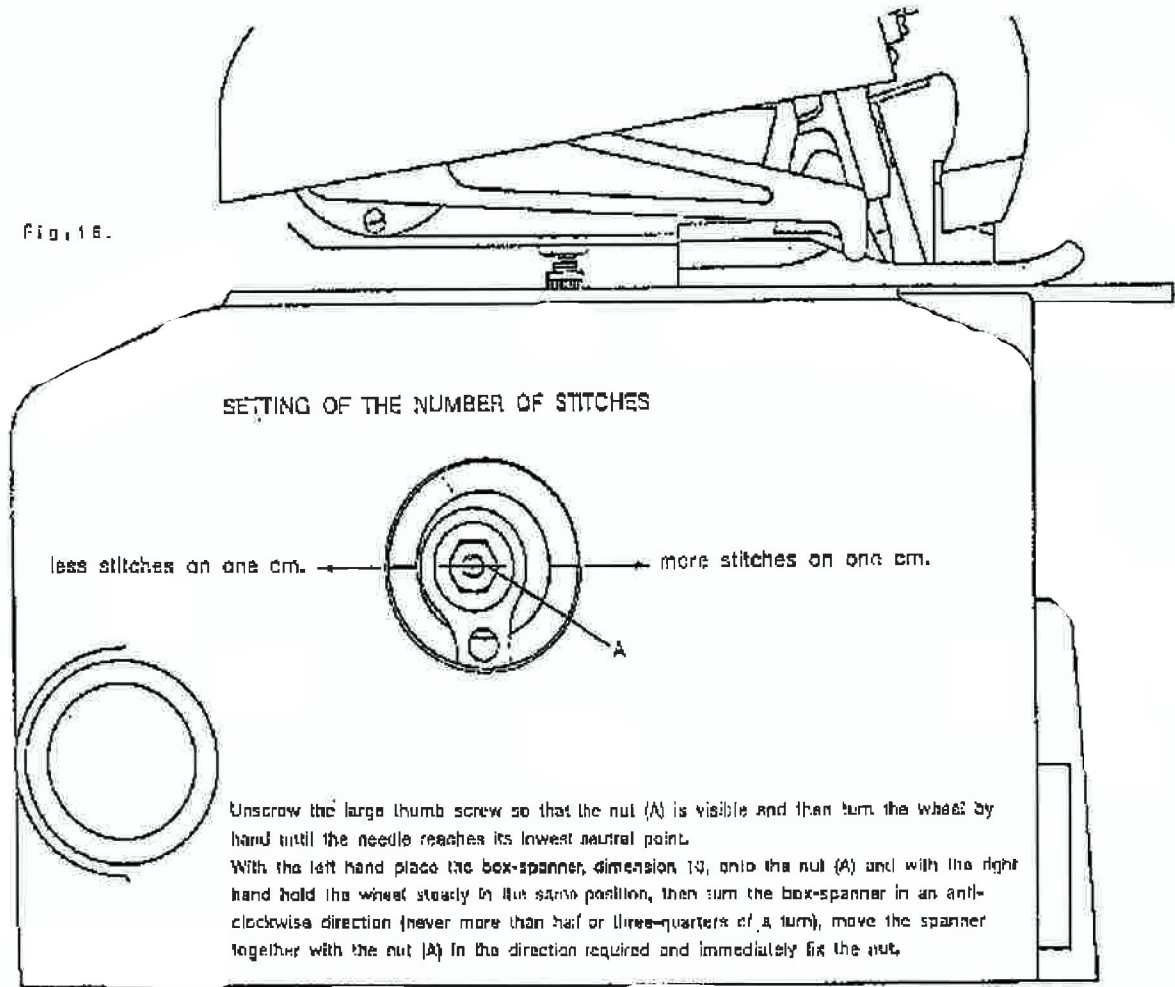
Carry out the adjustment as follows: loosen screws B a little (fig. 15) displace looper C, either to the right or to the left.



Looper C can only be displaced over a short distance i.e. 1 mm in each direction. When the looper moves towards the needle, it crosses underlooper E (fig. 15). At this moment point D of looper C moves in a groove milled in the underlooper E. Take care the E and C do not touch each other.

When this adjustment is performed, refer to §Obtaining correct stitch.

Fig. 16.



IDL-2501, IDL-2502, IDL-2503

OVERLOCKING MACHINE



### **ADJUSTMENT OF THE NEEDLE BAR**

**Untighten both screws A (fig. 18) so that the needle bar B moves with a certain restraint in the holder C.**

**Turn the machine wheel by hand until the needle D gets engaged in the slot E of the needle plate 1: the point of the needle must be exactly I the centre of the slot E.**

**During this adjustment, also adjust the height of the needle as follows:**

**Loosen slightly the screws G and set screw F in such position that it sticks out from its housing by 3 mm. (fig:23.)**

**Tighten the screw G, place a new needle and fix it with screw H fig. 18. By turning the machine by hand, the needle-bar reaches its highest neutral point, in this position the distance between the point of the needle and the surface of the needle plate (i) (fig. 23.) should be exactly 23 mm.**

**For this adjustment move the needle bar B with regard to the holder C (fig. 18), to the height which is required, making sure that the point of the needle is always exactly in the center of the slot E and tighten the screws A.**

**When the needle reaches its lowest neutral point, it is necessary for the correct formation of the loop of the needle's thread that the needle rises from 1,7 mm to 2 mm before the lower hook is in the position shown by figure 20.**



**ADJUSTMENT AFTER REPLACING THE LOWER  
OR UPPER LOOPER**

Loosen both screws G (fig.13) and remove the complete upper part of the machine, then the needle plate I and the base plate as well.

**REPLACEMENT OF THE LOWER HOOK**

Insert a new needle and unscrew the nut K (fig.18) half a turn.

By turning the machine wheel by hand, position both loopers as shown on fig. 21, unscrew the looper J from its slot N (fig. 18), in an anti-clockwise direction.

Introduce the new looper into the slot N and screw it on the threaded rod L up to the point where the nut is (fig. 18).

Place the surface S of the lower looper exactly parallel to the needle (fig.24) i.e. at 170

Between the countersink of the needle and the surface S of the lower looper, there must be a play of 2/10 to 3/10 mm, more would give rise to false stitches, while less play would give rise to contact between the parts concerned, which should be avoided at all costs.

On the surface S place a 6 mm fork spanner and fix the nut K (fig. 18) maintaining the 17 ° angle of the surface S. Figure 21 shows a measure of 80 mm which must be respected when the lever M fig. 18 has to be moved. For this adjustment, loosen screws R (fig. 18) so that the lever can turn on its axis with a slight restraint; adjust the point of the lower looper at the required measure of 80 mm and tighten the screws R.

### **REPLACEMENT OF THE UPPER LOOPER**

Completely remove the upper part of the machine, and the needle plate (fig. 18).

Turn the machine wheel by hand until the upper looper V reaches its lowest neutral point (fig. 19). In this position both screws T can be removed and the worn looper replaced by a new one (see \*). If after this replacement, there is contact made between the upper looper and the lower looper, carry out the following adjustment:

Loosen screws O (fig. 18) and move the bronze slot N in the direction which is required (see arrows-fig. 17).

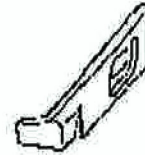
**ATTENTION:** The adjustment must be minimal and should never exceed 1/10 mm. Tighten both screws O.

A similar adjustment can be made by untightening the screw U (fig. 17) and by moving the shank of the swivel joint L in the required direction, with regard to the lever M (fig. 17).

\* §Adjustment of loopers.

### SELECTION OF A CHAIN GUIDE

Depending on the thickness of the carpet to be overedged. In order to obtain a proper stitch, one will fit a chain guide which is suitable to the material.



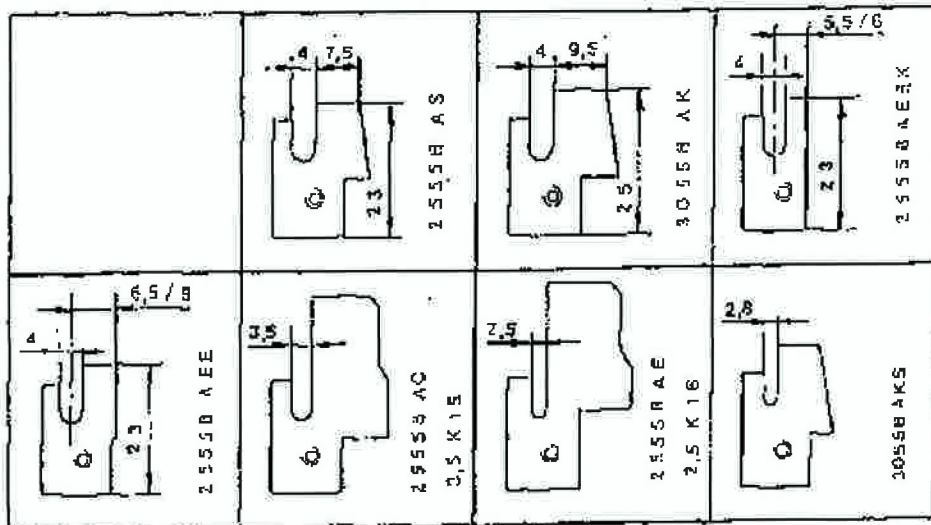
Hereunder the list of different available guides with their ref. numbers.

PART NUMBER	LEFT EXECUTION	RIGHT EXECUTION	DESCRIPTION
-25560	×	×	-Normal carpets.
-25560B	×	×	-High piles.
-25560C	×	×	-Blankets.
-25560EE	×	×	-Normal carpets with small overedging.
-30560GR	×	×	-Normal carpets with tape insertion.
-25560H	×	×	-Heavy carpets.
-25560K	×	×	-Butseamer.

### SELECTION OF NEEDLE PLATE FINGER

Depending of the fact the yarn of the lower hook is thick or thin it might appear necessary to adapt the needle plate.

For thin yarn and thin material one will use a needle plate with a small groove. For thick yarn and thick material the use of a needle plate with a larger groove will be more suitable.



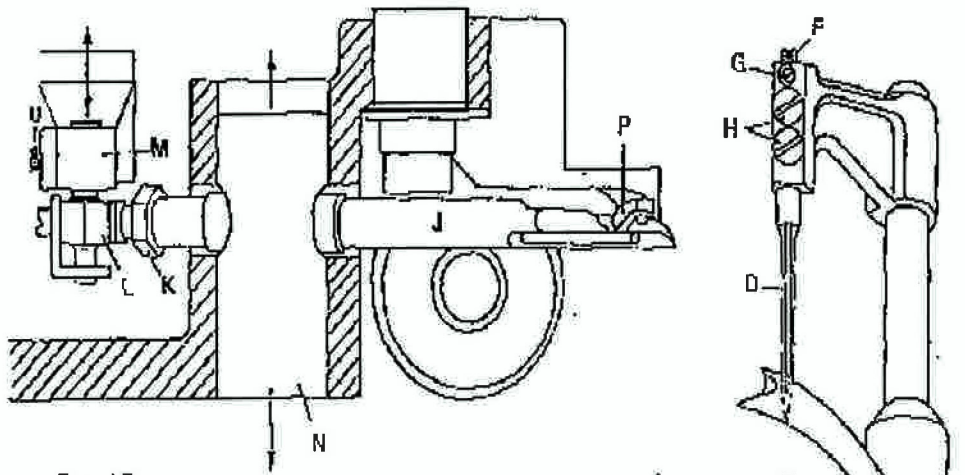


Fig. 17.

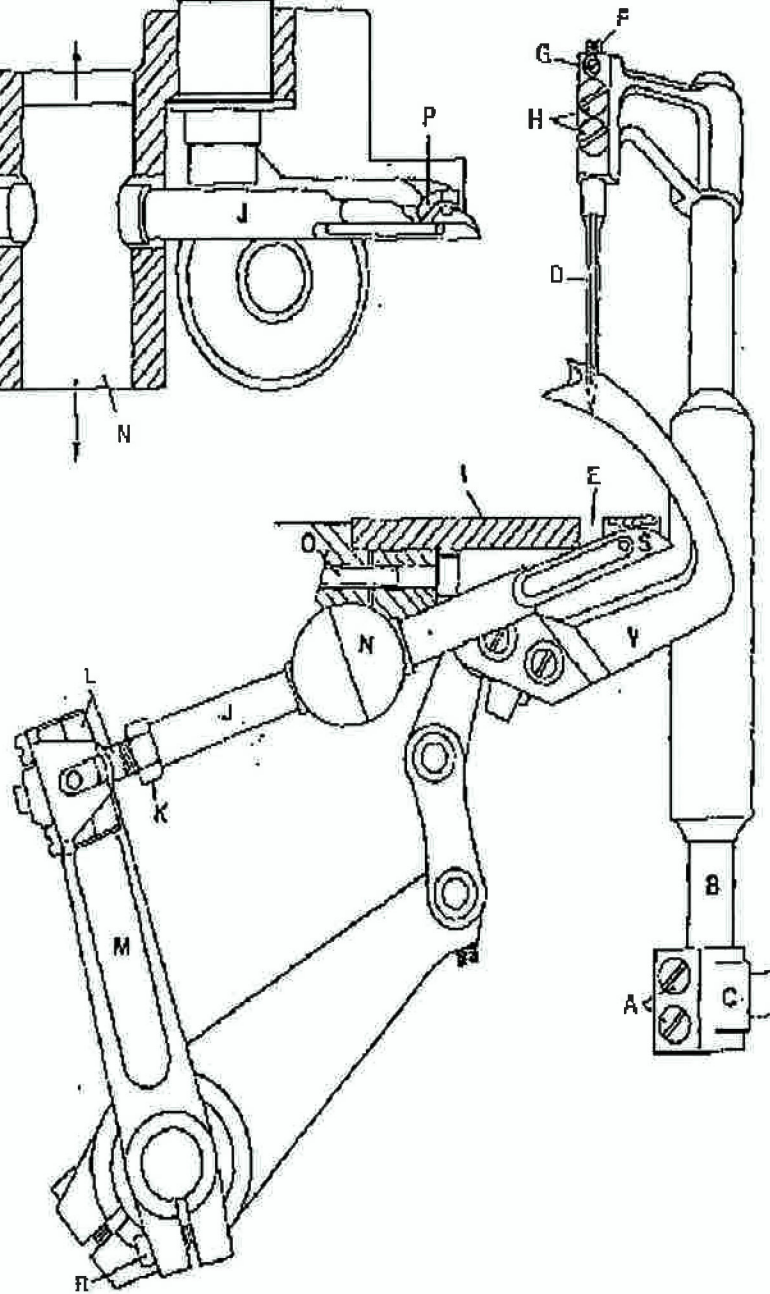
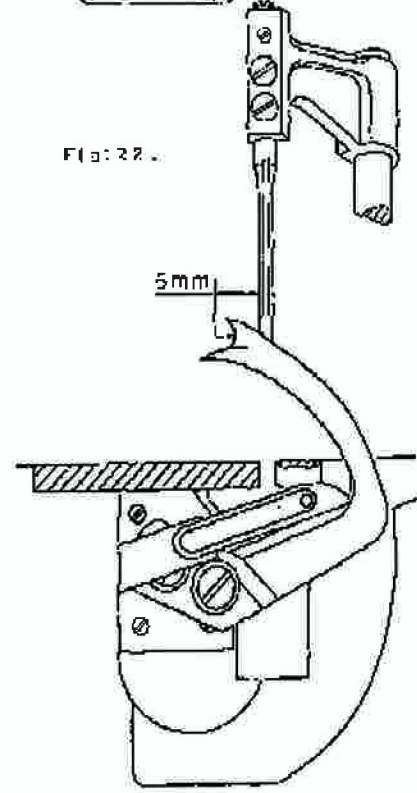
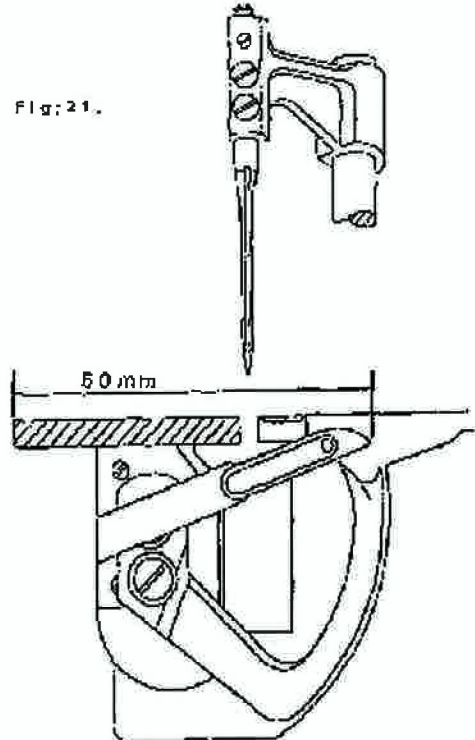
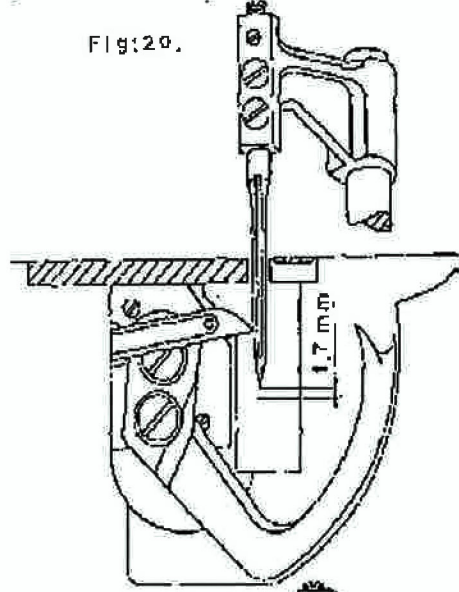
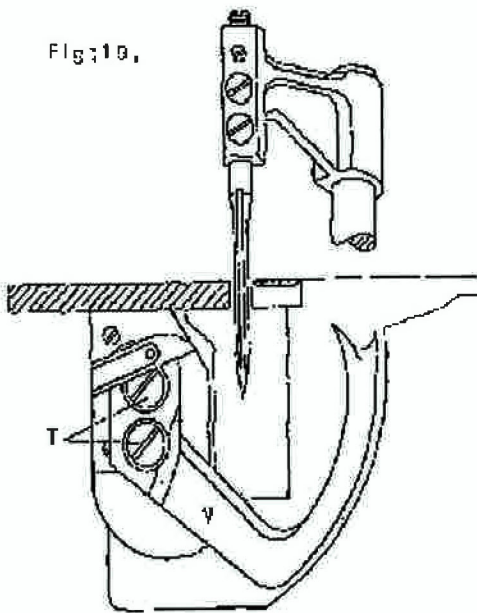


Fig. 18.

**IDL-2501, IDL-2502, IDL-2503  
OVEREDGING MACHINE**



**IDL-2501, IDL-2502, IDL-2503**

**OVEREDGING MACHINE**

Fig: 23 .

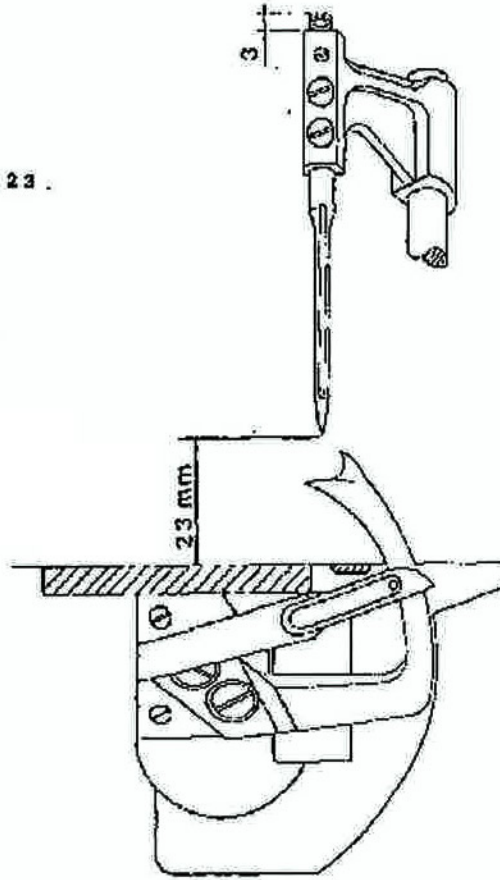
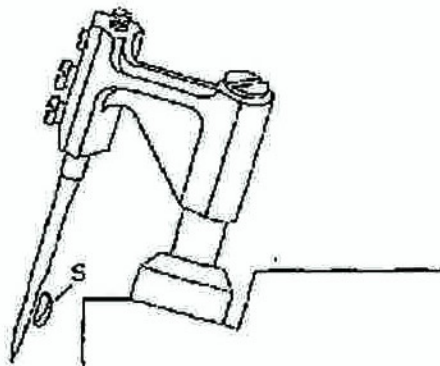


Fig:24



IDL-2501, IDL-2502, IDL-2503

OVEREDGING MACHINE



### **YARNS**

All types of yarn can be used on the IDL-2501, IDL-2502, IDL-2503. However, for the needle, we recommend using thinner yarns for example, a n 0 18-2500 m mercerized cotton from BST or any other brand.

Use preferably 2 or 3 thin yarns for the finishing yarn for tufted carpets. These should be loosely twined with about 10 twists per metre. This is because 2 or 3 and even 4 yarns spread out better and consequently the stitch can be markedly larger than with a single thick and overtwined yarn in the lower looper or hook.

### **THE FEEDDOG**

The sewing of tufted carpets with a needle creates a sort of dust composed of textile and rubber particles.

This dust accumulates every day the machine is used and it becomes more and more compressed by the movement of the feeddog itself finally breaks.

This also causes severe overloading of the other parts of the machine. If a powerful compressor is available which delivers air at 6 bar, it suffices to blow the uncompressed dust away every day. Even so the throat plate should be removed at least every two weeks the machine is in operation, in order to remove compressed dirt.

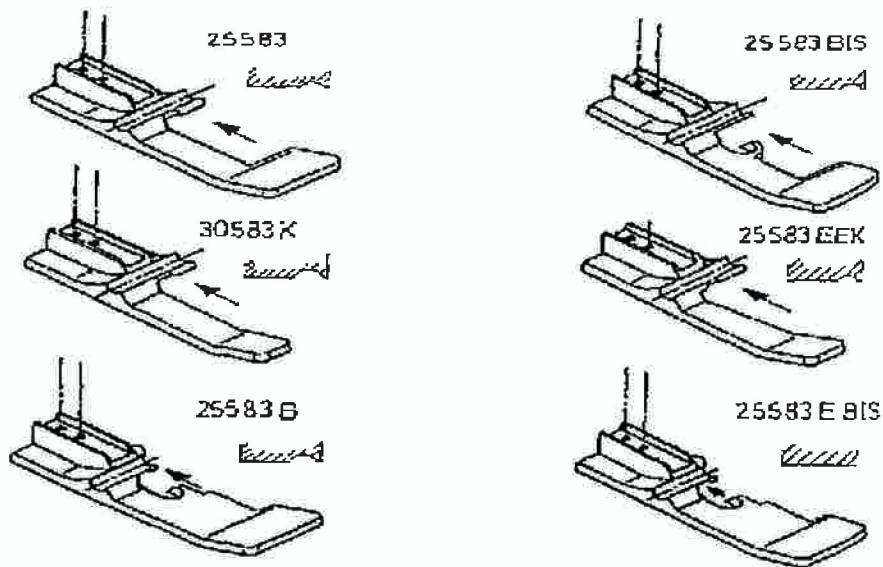
## PRESSER FOOT

It is very important to have the correct pressure on the presser foot if the overedging machine is to work well. If the pressure is too low, the feeddong will nevertheless carry the material forward, but this will be very irregular and the feeddong will slide too much on the rough backing of the carpet, causing undue wear on the feeddong. For the same reason the stitches will be irregular and may not be properly formed.

Insufficient pressure on the presser foot when working with tufted carpets with foam backing will lead to the foam being stripped off. If in contrast the pressure is adequate, only light traces will be left by the feeddong o the backing. The most sultable pressure on the presser foot is 8 kg.

This can be checked by means of a standard dynamomerer.

Available presser foots.



Part number.	description
25583	-Standard foot.
25583BIS	-Fine materials.
30583K	-Blankets
25583EEK	-Used in combination with guides.
	-Stitch width 5,5 mm.
2583B	-Buttseamer.
25583E BIS	-Buttseamer (fine materials).

## **KNIVES**

**The knives are lined with plates in a hard metal allowing a service life of about two months. As these plates are extremely hard they are also very brittle, which means that overly sharp contact between the upper and lower knives can cause the cutting edges to shatter.**

**An adjusting screw is installed on the machine (see fig. 13) and this allows the best gap between the knives to be set without risking damage.**

**Staples are often used in weaving sheds; it should not be forgotten that if a staple ends up between the knives of IDL-2501, IDL-2502, IDL-2503 the knives will have to be resharpened.**

**We do not advise trying to sharpen the knives without specialized machinery.**

## **NEEDLES**

**Type : 7713/230,180 or 160**

**7713-99/230(square pointed)**

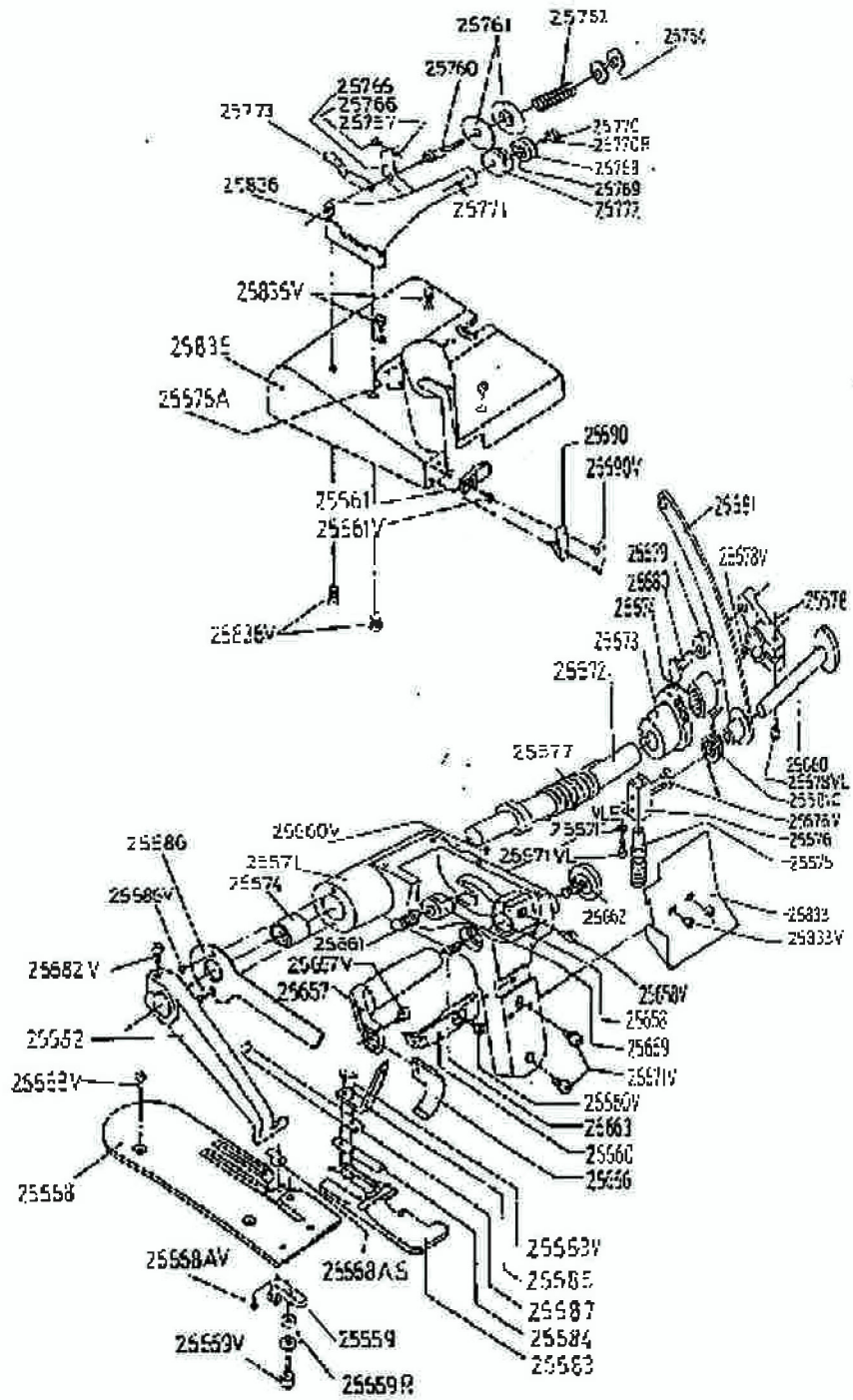
**Considering the fact that the needle of the IDL-2501, IDL-2502, IDL-2503 machine pierces the carpet 2800 times a minute, it is quite normal that the original shape of the needle is significantly altered after a few days. The recess in the needle which forms the loop in the yarn wears away and this causes false stitches.**

**If the MACHINE runs for 8 hours a day, the needle must be at the latest replaced after one week (36 hours) by a new one. The old needle will then have pierced and been withdrawn from the carpet 10 million times.**

**The needle in the machine may reach a temperature of 450 0C causing the foam at the back of tufted carpets to melt and to stick to the needle. This reduces the penetration power of the needle by about 50% and causes severe overloading of the needle drive mechanism and a premature wear of the internal parts of the machine. Therefore we advise to lubricate the needle when sewing rubber-backed carpets. This can be done by allowing the needle yarn bobbin to soak in a parafin oil bath for 24 hours, subsequently allow the bobbin to drip out for some days, after which the yarn can be used. The parafin laden yarns prevent the needle from sticking to the rubber. Parafin oil leaves no stains on the sewn work.**

**When changing needles you will notice that a ring of dust has been formed around the needle shaft. It is essential that this dust ring is carefully removed BEFORE the change of the needles. If this is not done properly, there is a danger that the dust is pushed into the needle holder, thus causing the original needle distance to be altered by the thickness of the dust layer, which could lead to the stitches not being properly made.**

**IDL-2501, IDL-2502, IDL-2503  
PRESSER FOOT ASSEMBLY**

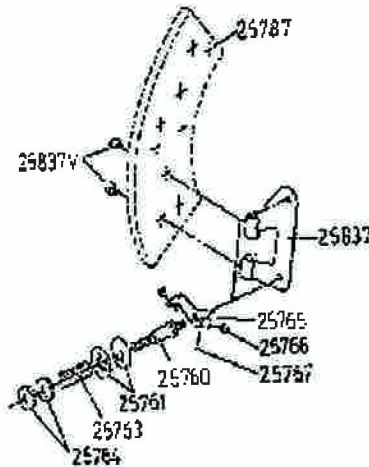
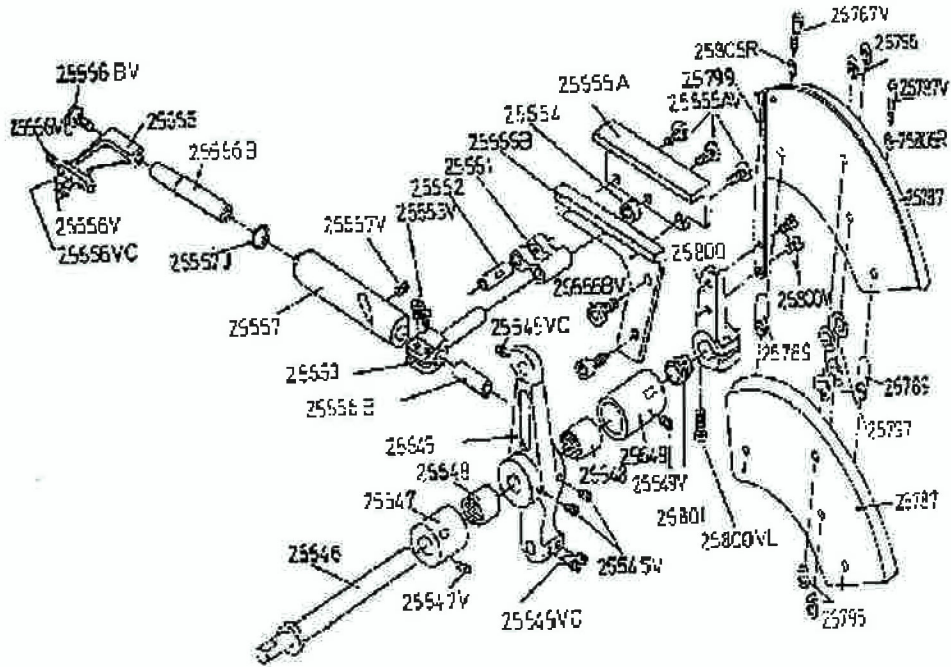




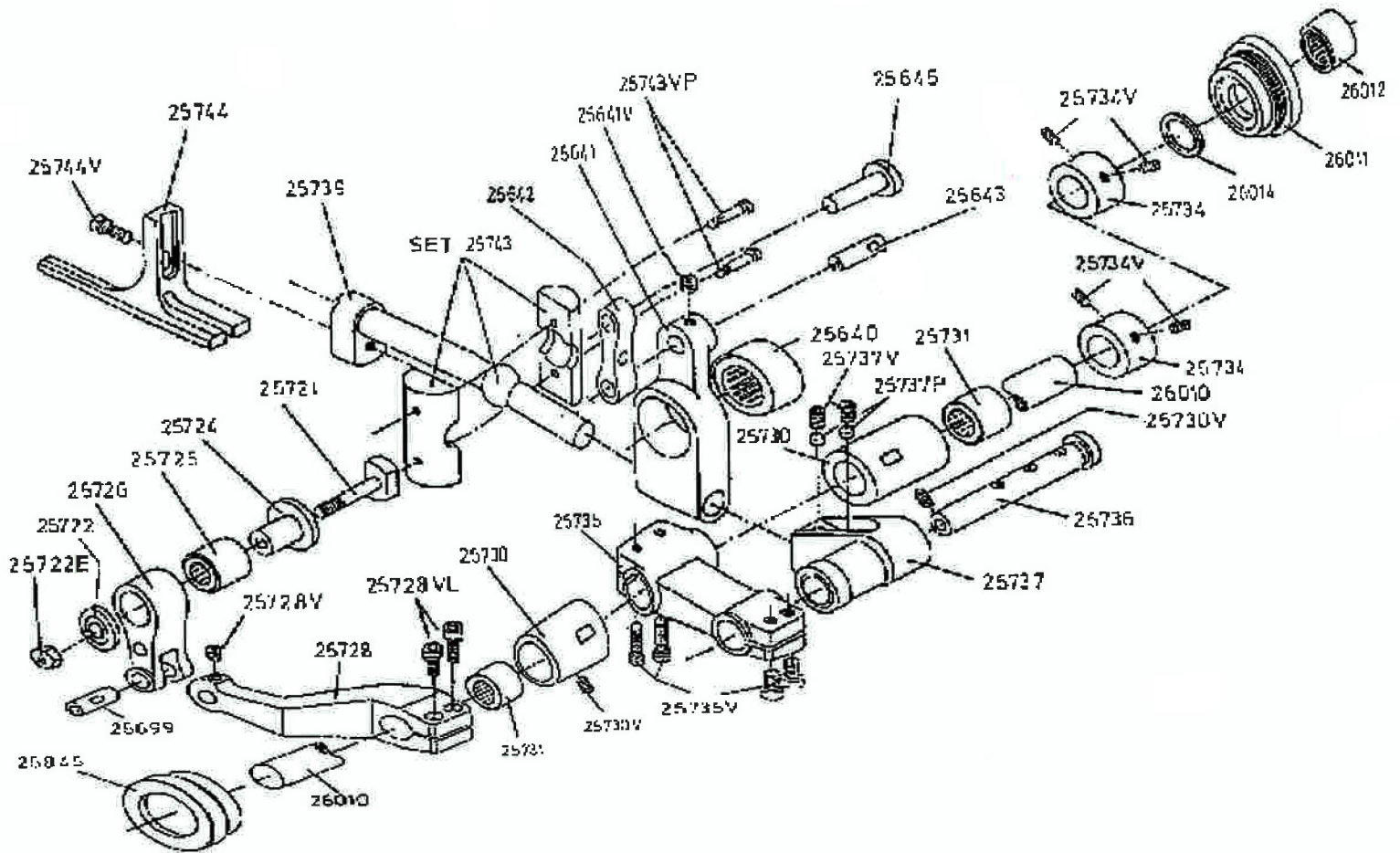
PRESSER FOOT MECHANISM					
REF NO.	PARTS NO.	DESCRIPTION	REF NO.	PARTS NO.	DESCRIPTION
1	25558	Needle plate	40	25587	Folium
2	25558AS	Finger	41	25590	Chain cutter
3	25558AV	Screw	42	25590V	Screw
4	25558V	Screw	43	25656	Upper knife
5	25559A	Needle guide complete	44	25657	Upper knife holder
6	25559	Needle guide	45	25657V	Screw
7	25559V	Screw	46	25658	Positioning lever
8	25559R	Washer	47	25658v	Screw
9	25560	Chain guide	48	25659	Slide block
10	25560V	Screw	49	25660	Shaft
11	25561	Thread tension releaser	50	25660V	Screw
142	25561V	Screw	51	25661	Feed spring
13	25571	Frame	52	25661	Screw
14	25571V	Screw	53	25663	Spring
15	25571VL	Screw	54	25760	Tension complete
16	25571VLE	Nut	55	25760	Tension post
17	25572	Lever shaft	56	25761	Tension disc
18	25573	Bushing	57	25762	Tensionspring (1,2mm)
19	25574	Bearing	58	25764	Nut
20	25575	Regulating screw	59	25765	Thread guide plate
21	25575A	Label	60	25766	Thread guiding ring
22	25576	Regulating screw holder	61	25767	Snap ring
23	25576V	Screw	62	25768	Roller
24	25577	Foot lifter spring	63	25769	Bearing
25	25578	Rise lever	64	25770	Precision screw
26	25578V	Screw	65	25770R	Washer
27	25578VL	Screw	66	25771	Nut
28	25579	Roller	67	25772	Roller holder
29	25580	Roller stud	68	25773	Thread guide
30	25581	Presser foot lifter lever	69	25833	Protective plate
31	25581C	Return spring	70	25833V	Screw
32	25582	Presser foot arm	71	25835	Cover
33	25582V	Screw	72	25835V	Screw
34	25583	Presser foot	73	25836	Tension holder
35	25583V	Screw	74	25836V	Screw
36	25584	Spring			
37	25585	Holder for parallelism			
38	25586	Connecting rod			
39	25586V	Screw			



**IDL-2501, IDL-2502, IDL-2503  
NEEDLE BAR MECHANISM**



NEEDLE BAR MECHANISM		
REF NO.	PARTS NO.	DESCRIPTION
1	25545	Needle bar lever
2	25545V	Screw
3	25545VC	Screw
4	25546	Eccentric shaft
5	25547	Bushing
6	25547V	Screw
7	25548	Bearing
8	25549	Bushing
9	25549V	Screw
10	25551	Connection link
11	25552	Link shaft
12	25553	Connection stud
13	25553V	Screw
14	25554	Guide roller
15	25555A	Needle bar guide
16	25555B	Needle bar guide
17	25555AV	Screw
18	25555BV	Screw
19	25556	Needle clamp assembly
20	25556	Needle clamp
21	25556B	Needle bar
22	25556V	Screw
23	25556VL	Screw
24	25556BV	Screw
25	25556VC	Screw
26	25557	Needle bar bushing
27	25557J	O-ring
28	25557V	Screw
29	25760	Tension complete
30	25760	Tension post
31	25761	Tension disc
32	25763	Tension spring
33	25764	Nut
34	25765	Thread guide plate
35	25766	Thread guiding ring
36	25767	Snap ring
37	25787	Thread guide holder
38	25787V	Screw
39	25789	Bushing
40	25795	Thread guide
41	25797	Spring ring
42	25799	Thread take-up
43	25800	Thread take-up lever
44	25800V	Screw
45	25800VL	Screw
46	25801	Rubber V-ring
47	25805R	Washer
48	25837	Tension holder
49	25837V	Screw

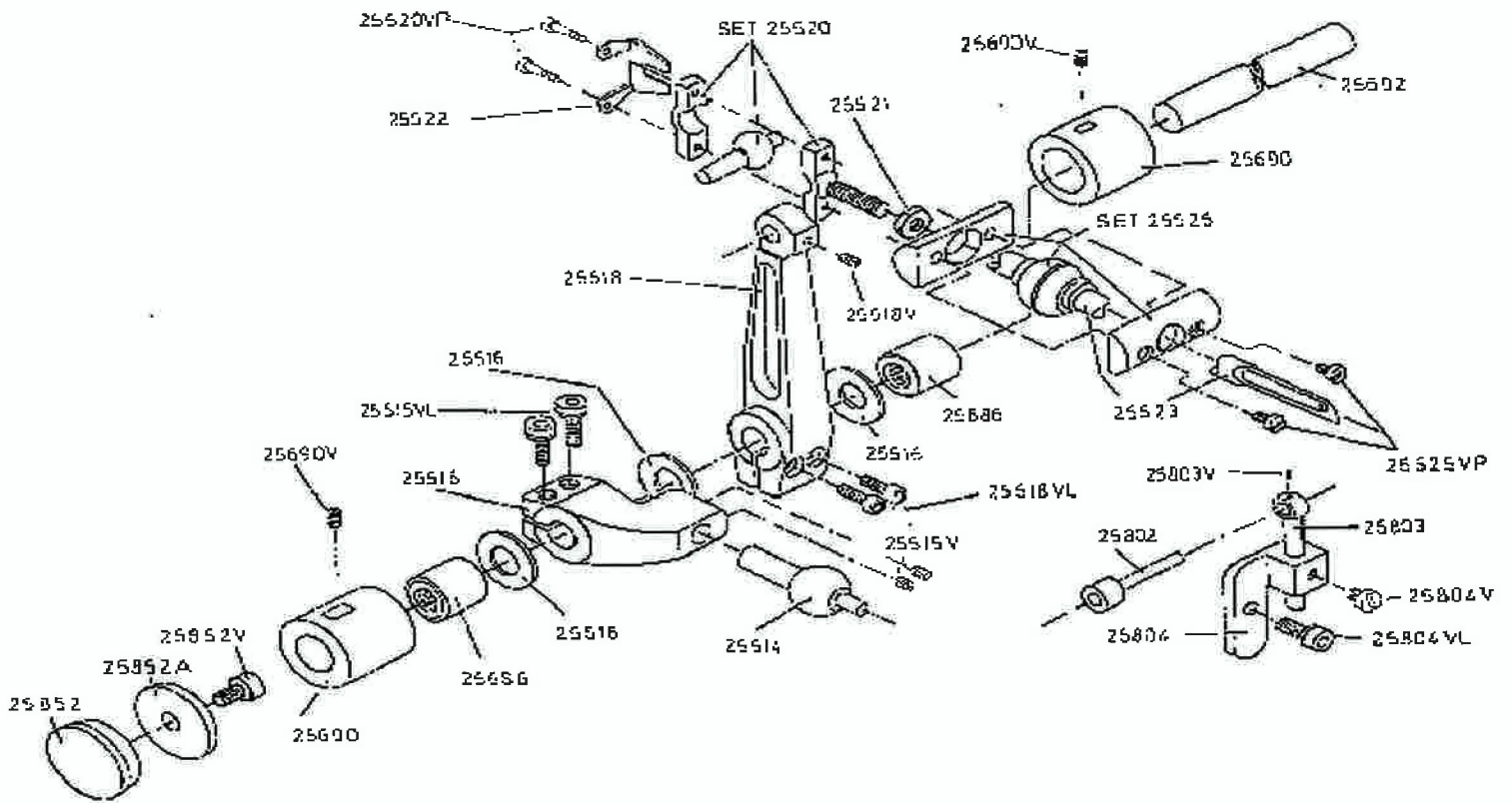


IDL-2501, IDL-2502, IDL-2503

FEEDDOG MECHANISM

<b>FEEDDOG MECHANISM</b>		
<b>REF NO.</b>	<b>PARTS NO.</b>	<b>DESCRIPTION</b>
1	25641	Lower knife driving link complete
2	25640	Bearing
3	*25641	Lower knife driving link
4	25641V	Screw
5	25642	Driving link
6	25643	Lower shaft
7	25645	Stud
8	25699	Pin
9	25721	Feed across regulator
10	25722	Washer
11	25722E	Nut
12	25724	Bearing bushing
13	25725	Bearing
14	25726	Feed driving rod
15	25728	Feed driving lever
16	25728V	Screw
17	25728VL	Screw
18	25730	Bushing
19	25730V	Screw
20	25731	Bearing
21	25734	Thrust collar
22	25734V	Screw
23	25735	Feed driving lever
24	25735V	Screw
25	25736	Stud
26	25737	Base
27	25737P	Protection
28	25737V	Screw
29	25739	Feeddog shaft
30	25743	Complete feeddog shaft guide
31	*25742	Shutter
32	*25743	Deeddog shaft guide
33	25743VP	Clamp screw
34	25744	Feeddog
35	25744V	Screw
36	25845	Plug
37	26010	Shaft
38	26011	Bushing
39	26012	Bearing
40	26014	O-ring

When ordering parts marked with a "\*" whole set will be delivered.



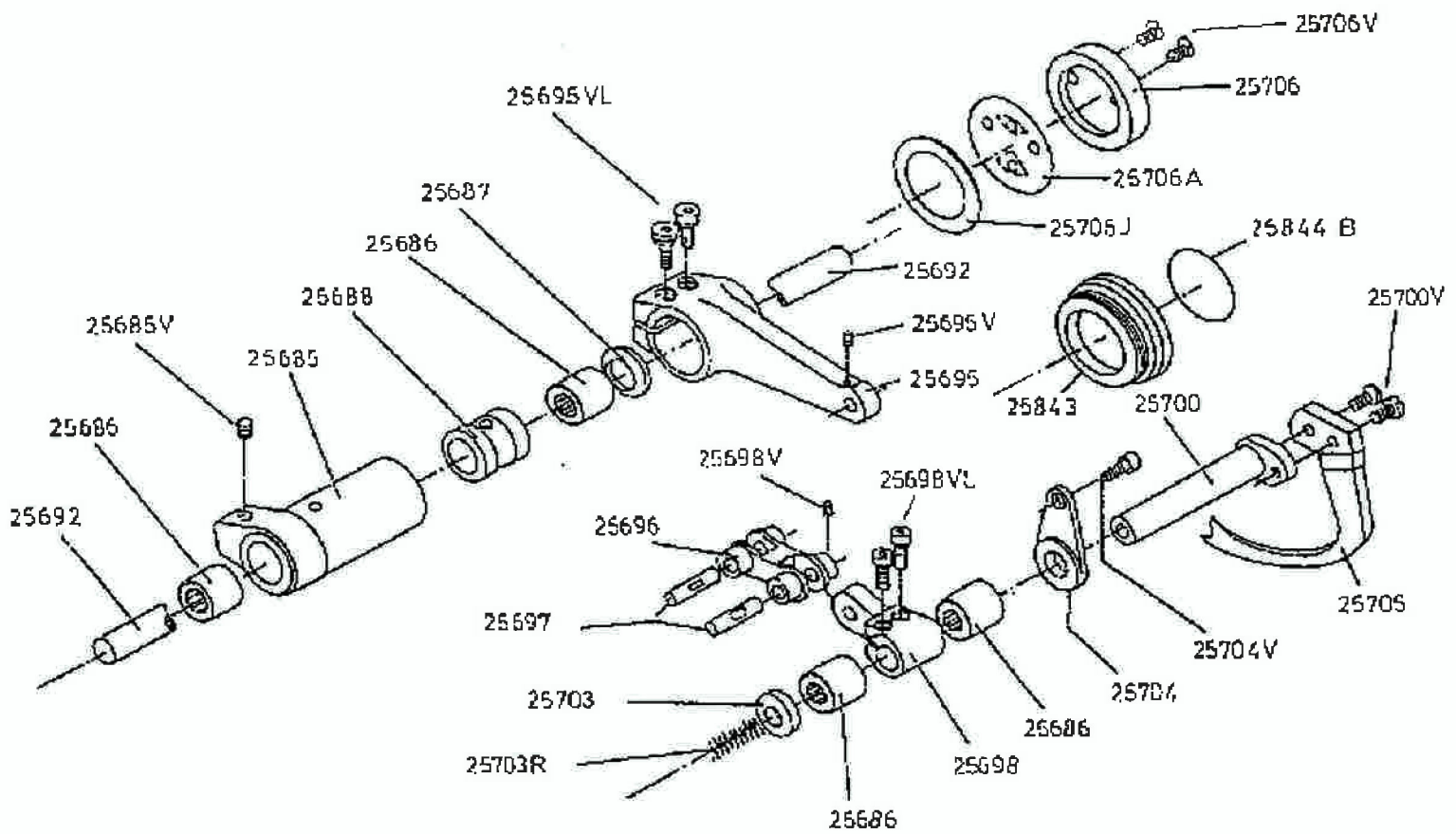
**Lower looper mechanism**



<b>LOWER LOOPER MECHANISM</b>		
<b>REF NO.</b>	<b>PARTS NO.</b>	<b>DESCRIPTION</b>
1	25511	Connecting rod complete
2	*25514	Ball
3	25515	Small driving lever
4	25515V	Screw
5	25515VL	Screw
6	25516	Washer
7	25518	Driving lever
8	25518V	Screw
9	25518VL	Screw
10	25520	Complete ball joint
11	*25519	Looper ball
12	*25520	Ball joint
13	25520VP	Precision screw
14	25521	Nut
15	25522	Ball joint guide fork
16	25523	Lower looper
17	25525	Under looper guide complete
18	*25524	Ball
19	*25525	Under looper ball joint
20	25525VP	Screw
21	25686	Needle bearing
22	25690	Bushing
23	25690V	Screw
24	25692	Shaft
25	25802	Thread guide
26	25803	Thread guide supporting shaft
27	25803V	Screw
28	25804	Thread guide holder
29	25804V	Screw
30	25804VL	Screw
31	25852	Plug
32	25852A	Washer
33	25852V	Screw

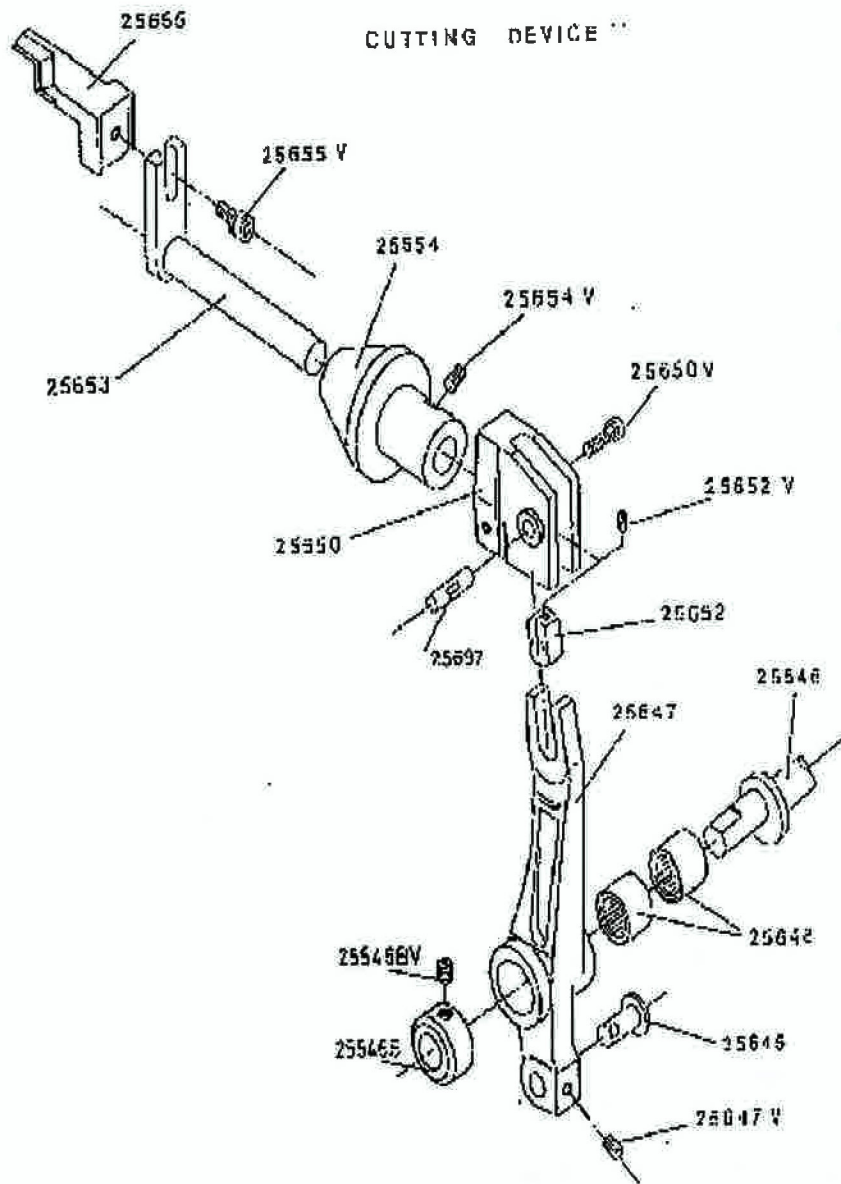
When ordering parts marked with a "\*" whole set will be delivered.

**IDL-2501, IDL-2502, IDL-2503**  
**UPPER LOOPER MECHANISM**



<b>UPPER LOOPER MECHANISM</b>		
<b>REF NO.</b>	<b>PARTS NO.</b>	<b>DESCRIPTION</b>
1	25685	Complete intermediary assenbly
2	*25685	Intermediate lever
3	25685V	Screw
4	25686	Bearing
5	25687	Washer
6	25688	Bushing
7	25692	Shaft
8	25695	Big lever
9	25695V	Screw
10	25695VL	Screw
11	25696	Connection link
12	25697	Link pin
13	25698	Small lever
14	25698V	Screw
15	25698VL	Screw
16	25700	Upper looper shaft
17	25700V	Screw
18	25703	Washer
19	25703R	Spring
20	25704	Thrust plate
21	25704V	Screw
22	25705	Upper looper
23	25706	Oil window
24	25706A	Sticker
25	25706J	Packing
26	25706V	Screw
27	25843	Plug
28	25844B	Sticker

When ordering parts marked with a "\*" whole set will be delivered.



**IDL-2501, IDL-2502, IDL-2503  
OREREDGINGMACHINE**

<b>CUTTING DEVICE MECHANISM</b>		
<b>REF NO.</b>	<b>PARTS NO.</b>	<b>DESCRIPTION</b>
1	25546	Eccentric shaft
2	25546B	Collar
3	25546BV	Screw
4	25645	Stud
5	25647	Lower knife lever complete
6	*25647	Lower knife lever
7	25648	Bearing
8	25647V	Screw
9	25650	Slide block guide
10	25650V	Screw
11	25652	Slide block
12	25652V	Screw
13	25653	Lower knife shaft
14	25654	Lower knife bushing
15	25654V	Screw
16	25655	Lower knife
17	25655V	Screw
18	25697	Link pin

When ordering parts marked with a "\*" whole set will be delivered.



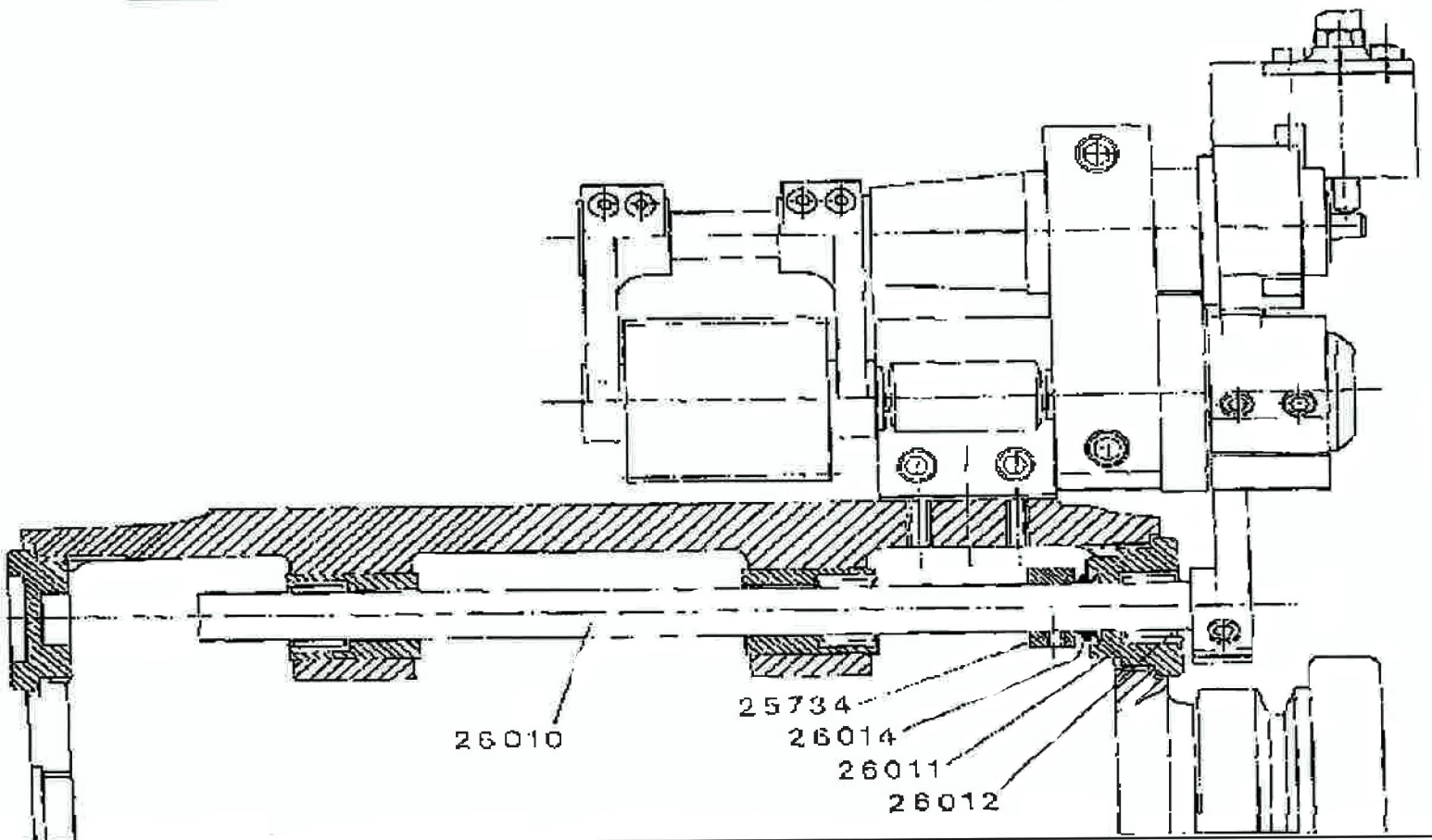


<b>CRANK SHAFT</b>		
<b>REF NO.</b>	<b>PARTS NO.</b>	<b>DESCRIPTION</b>
1	25511	Connecting rod complete
2	*25511	Connecting rod
3	25511V	Clamp screw
4	25511VL	Clamp screw
5	25512	Ball joint guide fork
6	*25513	Ball
7	*25514	Ball
8	25604	Bearing
9	25511A	Complete rod
10	25511A	Rod
11	25511B	Stud
12	25604	Bearing
13	25608	Pin
14	25601	Bearing
15	25601A	Bearing
16	25602	Crank
17	25602V	Screw
18	25603	Pin
19	25605	Crank
20	25605P	Protection
21	25605V	Screw
22	25605VL	Screw
23	25607	Crank
24	25607V	Screw
25	25608	Pin
26	25610	Crank
27	25610V	Screw
28	25612	Crank
29	25612V	Screw
30	25612VL	Screw
31	25615	Crank
32	25615V	Screw
33	25617	Ring
34	25620	Flange
35	25620J	O-ring
36	25620V	Screw
37	25621	Pulley
38	25621V	Screw
39	25640A	Washer
40	25641	Lower knife driving link complete
41	25640	Bearing
42	*25641	Lower knife driving link
43	25641V	Screw
44	25720	Eccentric
45	25720P	Projection
46	25720V	Screw
47	25721	Feed across regulator
48	25721V	Screw
49	25722	Washer
50	25722E	Nut
51	25844A	Plug

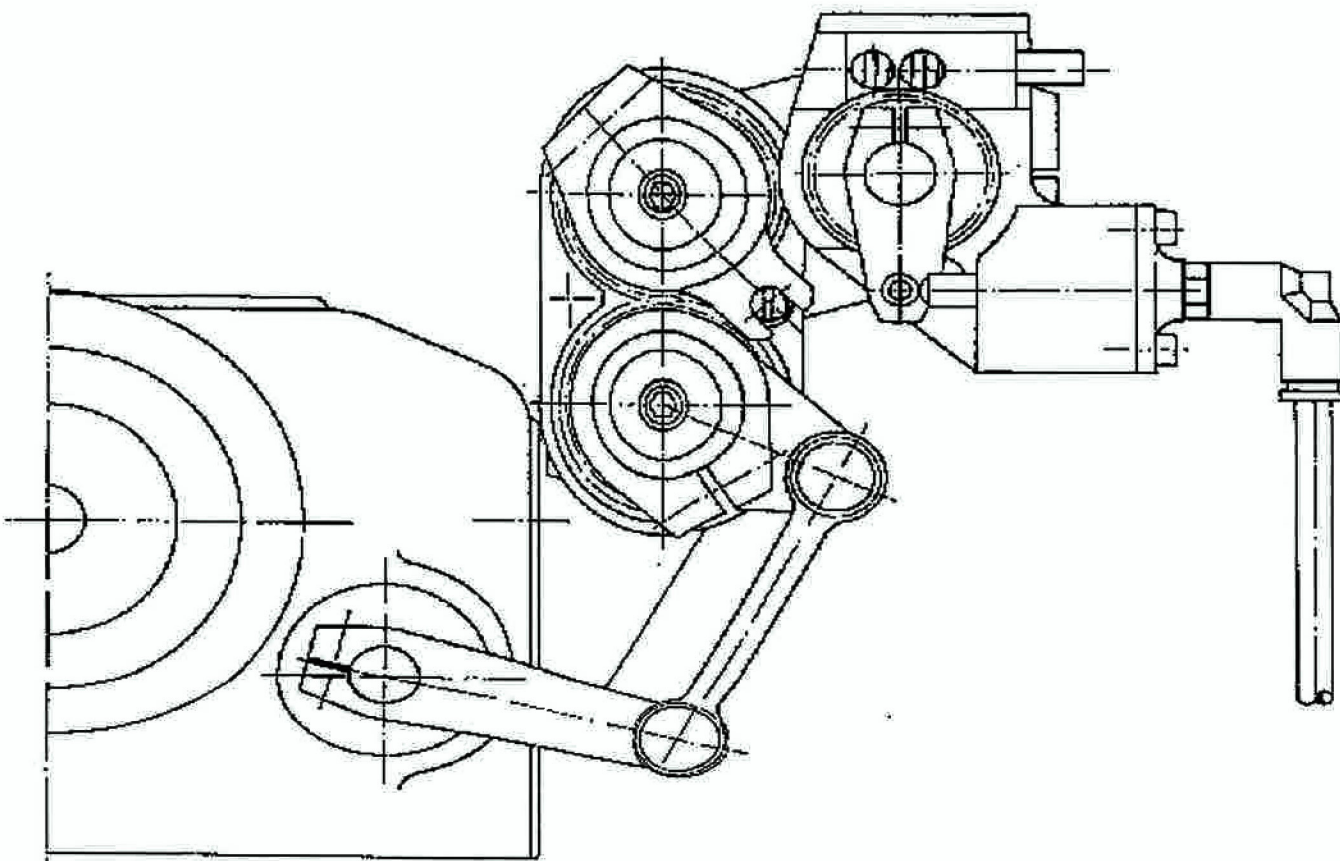
When ordering parts marked with an \* whole set will be delivered

**FITTING A PULLER ISL-2600**

**ON MACHINE IDL-2501, IDL-2502, IDL-2503 OR IDL-2501L, IDL-2502L, IDL-2503L**

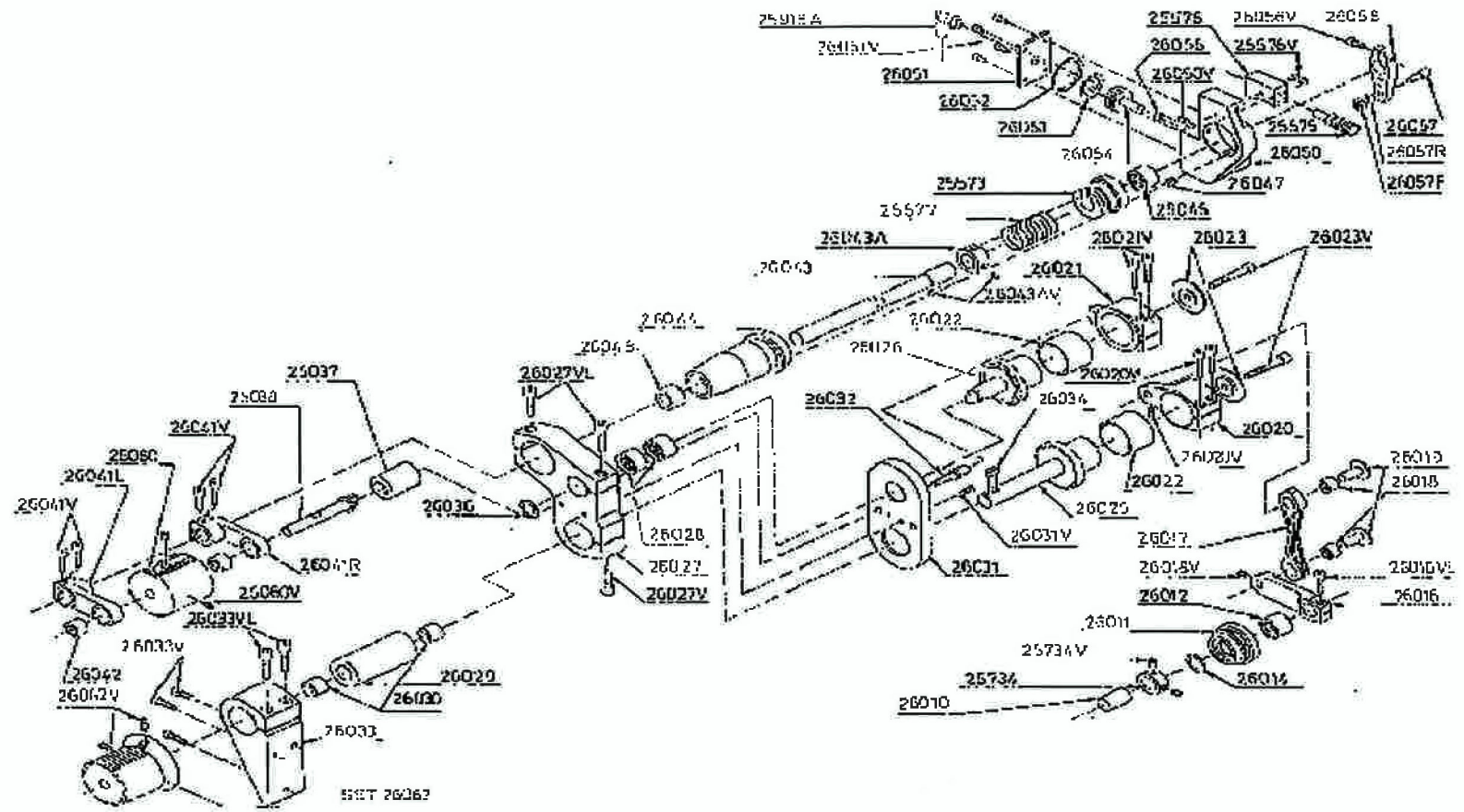


**FITTING A PULLER ISL-2600**  
**ON MACHINE IDL-2501, IDL-2502, IDL-2503 OR IDL-2501L, IDL-2502L, IDL-2503L**





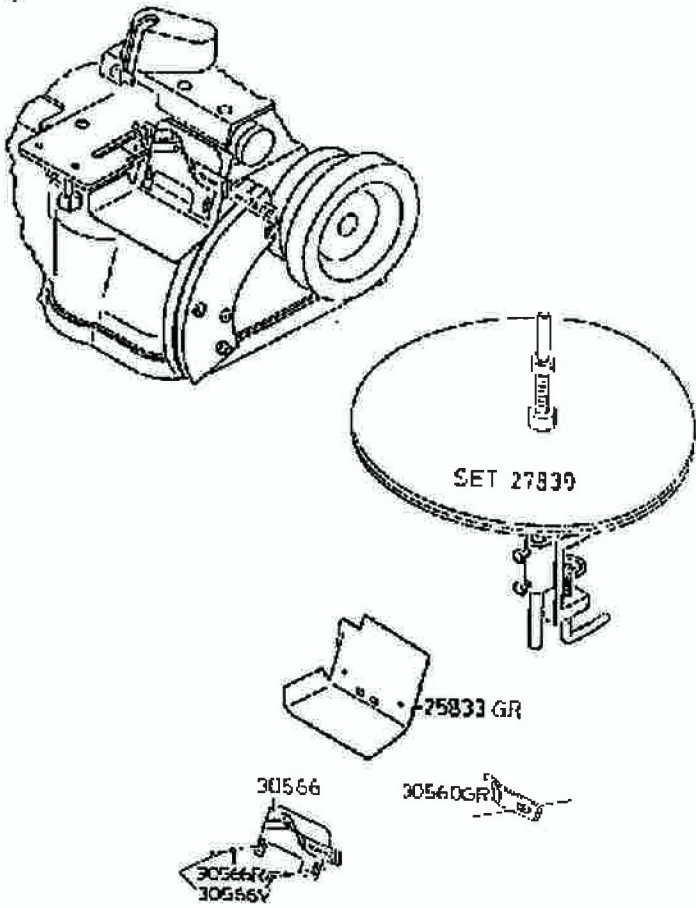
**IDL-2600**  
**PULLER**



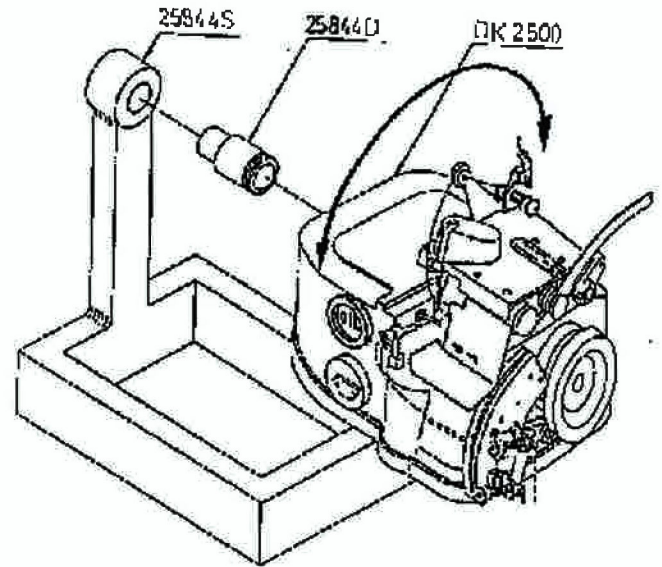
**PULLER IDL-2600**

REF NO.	PARTS NO.	DESCRIPTION	REF NO.	PARTS NO.	DESCRIPTION
1	25573	Bushing	37	26033	Fixation support
2	25575	Regulating screw	38	26033V	Screw
3	25576 25576L	Regulating screw holder	39	26033VL	Screw
4	25576V	Screw	40	26034	Block
5	25577 25577L	Foot lifter spring	41	26036	Snap ring
6	25734	Thrust collar	42	26037	Bushing
7	25734V	Screw	43	26038	Cardan
8	26010	Big axle	44	26041R	Lever
9	26011	Bushing	45	26041V	Screw
10	26012	Bearing	46	26041L	Lever
11	26014	Seal-Ring	47	26042	Bearing
12	26016	Lever	48	26043	Shaft for levers
13	26016V	Screw	49	26043A	Thrust collar
14	26016VL	Screw	50	26043AV	Screw
15	26017	Lever	51	26044	Bushing
16	26018	Bushing	52	26045	Bearing
17	26019	Pin	53	26047	Block
18	26020	Lever	54	26050 2560L	Piston frame
19	26020V	Screw	55	26050V	Screw
20	26020VL	Screw	56	26051	Cover
21	26021	Lever	57	26051V	Screw
22	26021V	Screw	58	26060	Upper feed wheel
23	26022	Wheel	59	26060V	Screw
24	26023	Washer	60	26062	Lower feed wheel
25	26023V	Screw	61	26062V	Screw
26	26025	Lower shaft	62	26054	Pneumatic cylinder(option)
27	26026	Upper shaft	63	25916A	Elbow
28	26027	Frame	64	26052	O-Ring
29	26027V	Screw	65	26053	O-Ring
30	26027VL	Screw	66	26054	Piston
31	26028	Bearing	67	26055	O-Ring
32	26029	Bushing	68	26056	Lever
33	26030	Bearing	69	26056V	Screw
34	26031	Gear cover	70	26057	Pin
35	26031V	Screw	71	26057E	Nut
36	26032	Pin	72	26057R	Washer



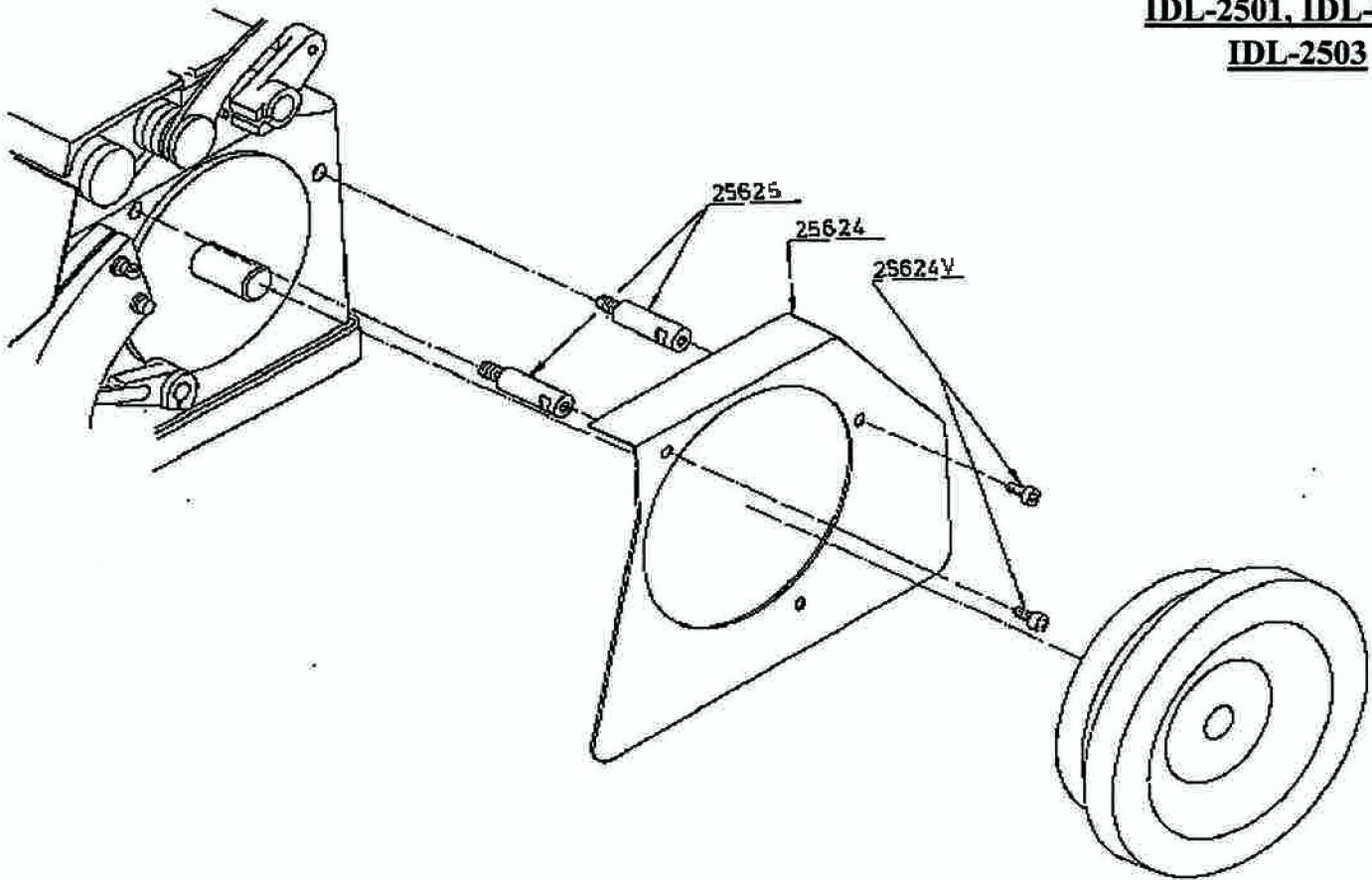


**TAPE INSERTION FOR IDL-2600  
WITH OR WITHOUT KNIVES**



**SERVICE WORKSTAND**

**BELT GUARD**  
**FOR**  
**IDL-2501, IDL-2502,**  
**IDL-2503**



**Setting of length of  
stitch device.  
(option).**

