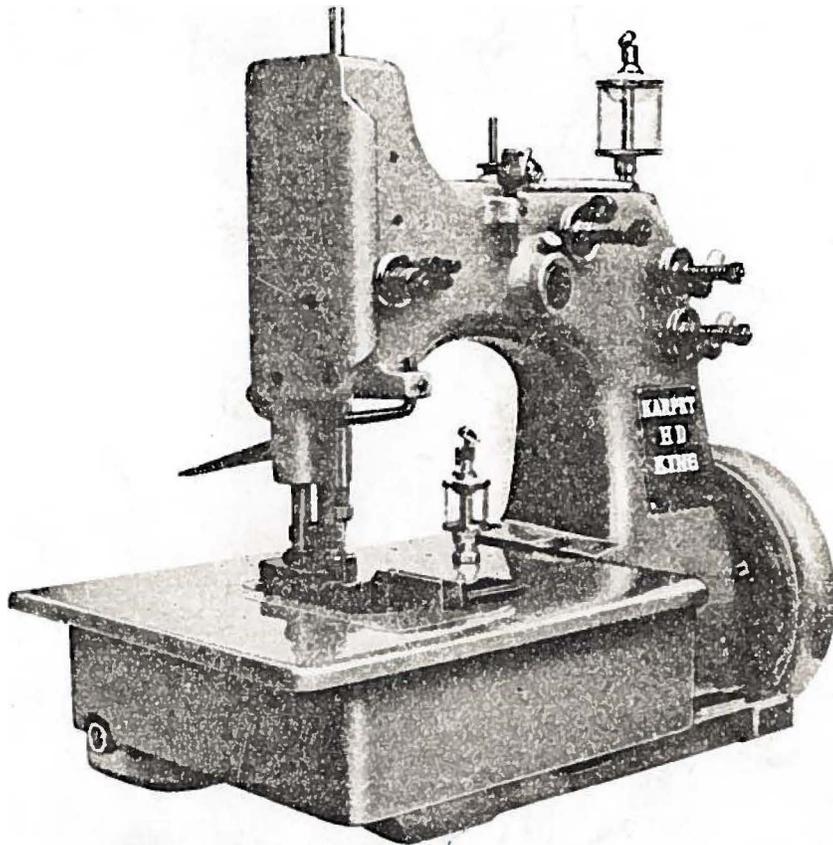


ILLUSTRATED PARTS LIST
FOR
HEAVY DUTY
KARPET KING MACHINE
Model 812K



National Distributors of Juki & Kingline Industrial Sewing Machines

OILING DIAGRAM

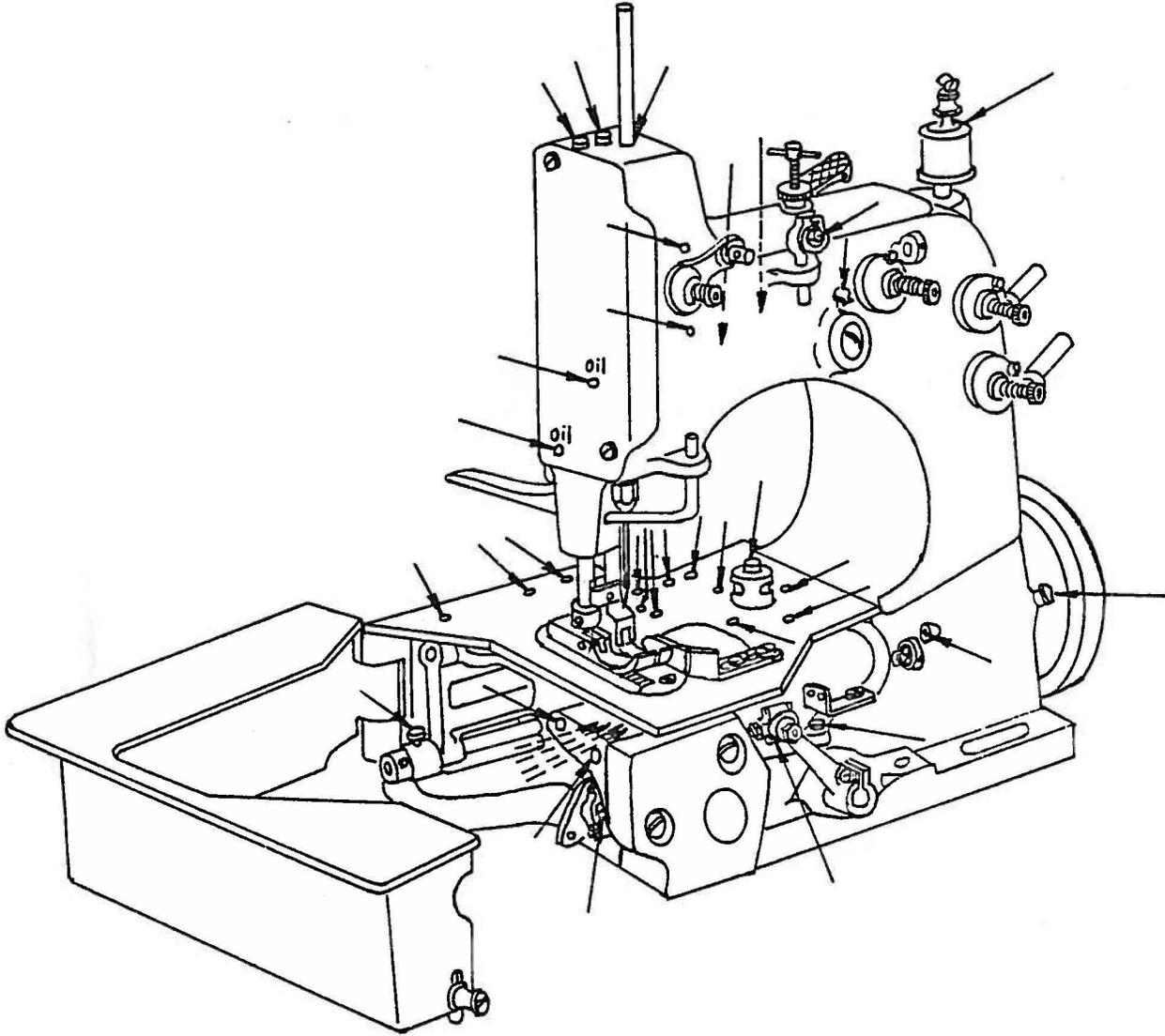


Fig. 1

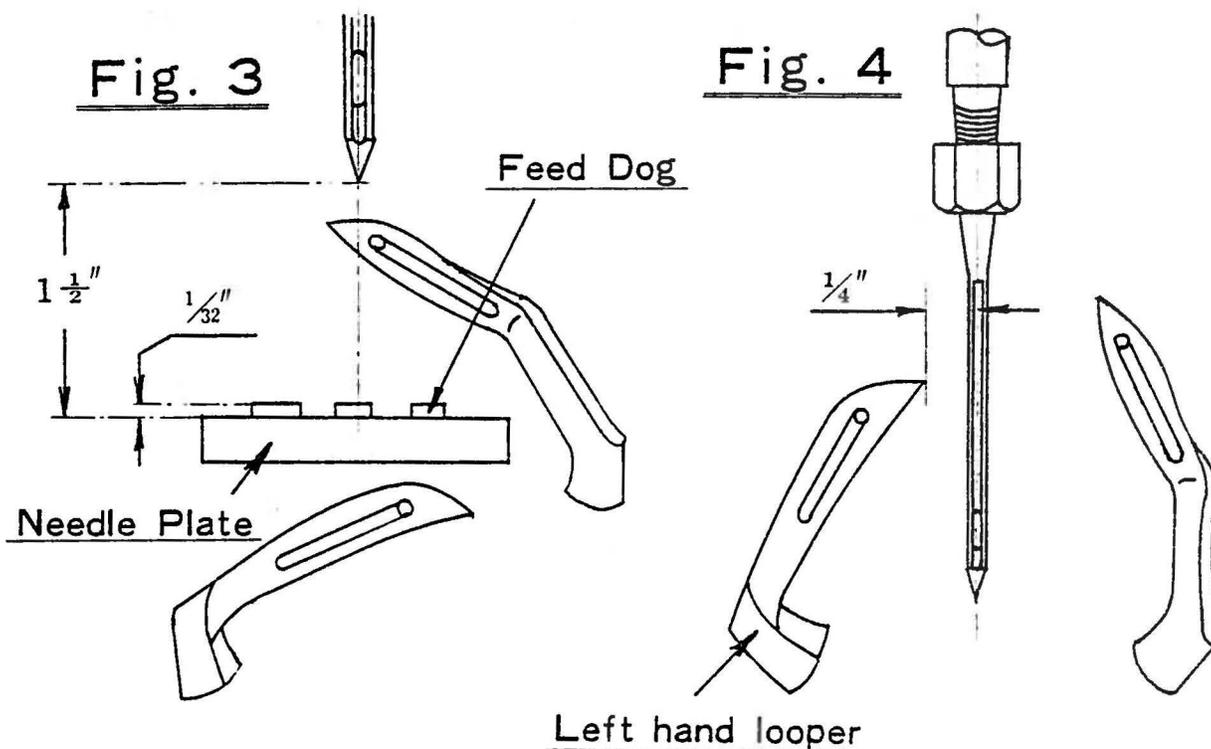
THREADING AND ADJUSTMENT INSTRUCTIONS
FOR
KINGLINE MODEL 812K HEAVY DUTY KARPET KING

812K One needle heavy duty flat bed machine for overseaming rugs and carpets.

Stitch type 505-EFD-1 (modified).

————— SETTING UP MACHINE —————

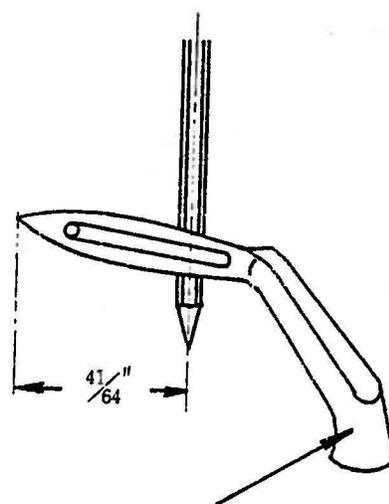
1. Clean machine thoroughly. Fill oiling system and oil all bearings, particularly the eccentrics on the main shaft. Run the machine slowly for a minute to allow the oil wicks to carry the oil to the bearings. See that the wicks are saturated by the flow from the oil reservoir and that they contact the oil holes in the straps. Repeat the oiling and run for five minutes at 2,000 R.P.M.. Oiling diagram (Figure 1) is available.
2. Put in a new needle, class 1970, size 100 (80E) and check location of needle in throat plate. The needle should center in the front end of the throat plate needle slot. The needle point in its highest position should be $1\frac{1}{2}$ inches above the top of the throat plate (Figure 3).
3. Remove the presser feet, cloth plates and feed dog for convenient access to the machine. Loosen the screw ($\approx 93A$) on the right side of the feed bar and push the rear needle guard ($\approx 81225K$) far enough to the rear to avoid its contacting the needle.
4. Place the left hand looper in the looper holder and set the looper gauge to $\frac{1}{4}$ inch. The looper gauge is set when the looper is at its farthest point of travel to the left (Figure 4). This adjustment is accomplished by rocker and raising or lowering the ball



joint (# 15442K) in the slot. Raising the ball joint decreases the looper gauge and lowering it acts the reverse. Looper gauge is available for setting the looper.

5. Set the left hand looper so that it is up to the back of the needle without deflecting it. This adjustment is readily made by loosening the two screws (# 95) in the looper rocker.
6. Set the rear needle guard so that it barely contacts the needle at its most forward point of travel.
7. Set the distance between centers (# 6038K & # 6039K) of the right hand looper drive connecting rod (# 81241) straps at $4 - \frac{1}{4}$ ". This is done by loosening the two nuts (# 269 & # 18) on the pitman rod and turning the rod until the desired measurement is obtained, then tighten the nuts and reassemble the connecting rod in the machine.
8. Set the right hand looper gauge so that the point of the right hand looper passes $\frac{1}{64}$ " to the left of the center of the needle when the looper is at its extreme left position (Figure 5). The looper gauge of the right hand looper is controlled by moving the looper drive lever (# 81238) on the cross shaft. To increase the looper gauge, move the lever clockwise and to decrease the looper gauge, move the lever the opposite. When tightening the screws on the looper drive lever, make sure that there is no end play in the cross shaft.

This may be done by pushing forward on the cross shaft and at the same time setting the looper drive lever tight up against the casting. Re-check the setting of the looper with respect to the needle each time the looper drive lever is shifted.



Right hand looper

Fig. 5

9. When right hand looper moves to the right, it must pass the needle as close as possible without deflecting it. It must also cross the left hand looper as close as possible. The adjustment for setting the right hand looper is made by loosening the two screw (# 318) at the front of the machine and moving the looper shaft bearing or sliding block (# 81255). Moving the block upward brings the looper closer to the needle and moving it downward brings the looper closer to the left hand looper. The loopers themselves can be turned slightly by loosening the holding screws and holding the loopers in the desired position while retightening the screws.

10. With right hand looper at its extreme left position, set the right hand looper thread take-up eyelet (\neq 81266KB) in a vertical position being careful that the left hand looper gauge is not changed when nut (\neq 9937) is loosened.
11. Put the feed dog, cloth plates with throat plate back on the machine and set the front needle guard close to the needle without deflecting it.
This guard is readily adjusted by loosening the screw (\neq 90) in top of the throat plate in front of the needle slot and moving the guard into position and retightening the screw. Place the presser feet on the machine and check the vertical movement of the presser bars with the pressure released as much as convenient. The bars must move freely. THIS FACTOR IS VITAL.
12. The height of the feed dog is correct when at its highest point of travel the tips of the rear teeth project $1/32$ " above the throat plate. A stop screw is provided to maintain the adjustment (Figure 3).
13. Screw the edge guide on to the cloth plate and adjust it so that the edge guide tongue (\neq 81203KA-1) is against the presser foot stitch tongue.
14. Draw the thread into the machine and start operating on a piece of rug material. Threading diagram (Figure 2) is available.
15. Adjust the stitch length to give the desired number of stitches per inch.

This adjustment is made by loosening the stitch regulator stud nut (\neq HA 18A) on the side of the feed rocker (\neq 80233) (Figure 6). Raising the feed driving arm (\neq 80651) shortens the stitch and lowering it lengthens the stitch. After the stitch length is set, reset the rear needle guard so that it barely contacts the needle when in its most forward position of travel.

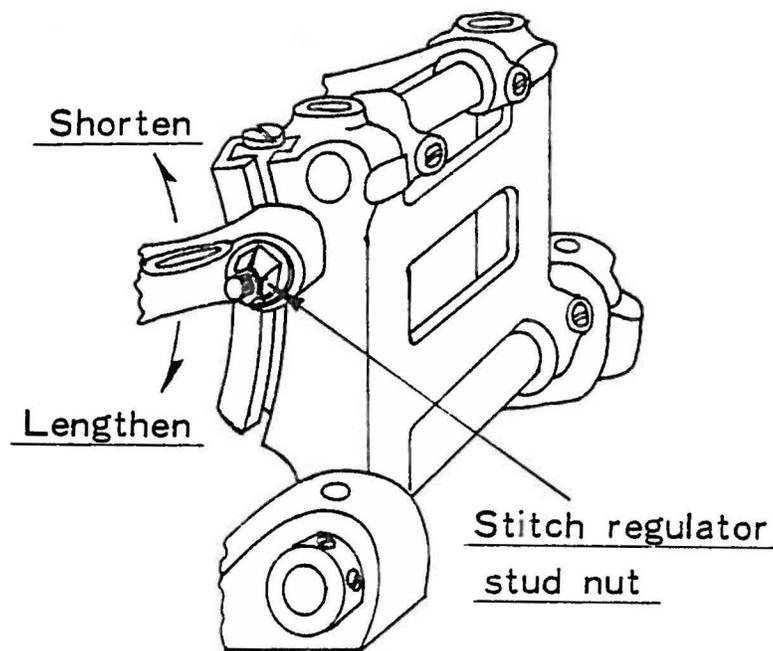


Fig. 6

16. Regulate the pressure on the presser feet so that the springs exert a pressure sufficient to feed properly. A comparatively heavy pressure is usually required.
17. Adjust the left hand looper thread take-up (# 81266K) outward or clockwise until the left hand looper thread just tightens as the left hand looper thread comes off the right hand looper. (CAUTION - NO LEFT HAND LOOPER THREAD SHOULD BE DRAWN FROM THE CONE AT THIS TIME). All the left hand looper thread should be drawn from the cone as the left hand looper moves to the end of its travel to the right.
18. The needle and right hand looper thread tension should be set as low as possible yet high enough to give positive and consistent control to the needle and right hand looper thread. The left hand looper thread tension should be just high enough to give a beaded appearance of the lower thread at the purl or edge.
19. Make sewing test on a single thickness of rug material. If satisfactory samples are not obtained, check the following thread controls.

20. NEEDLE THREAD CONTROL

To pull less needle thread into the stitch, or move purl down, increase needle thread tension, or raise needle frame eyelet. Most of the needle thread should be drawn from the cone on the upstroke of the needle.

21. RIGHT HAND LOOPER THREAD CONTROL

To pull more right hand looper thread into the stitch, or move purl down, reduce the right hand looper thread tension or move right hand looper thread take-up (eyelet) clockwise, being careful that the left hand looper gauge is not changed when nut (# 9937) is loosened.

22. LEFT HAND LOOPER THREAD CONTROL

The left hand looper thread control eyelet (take-up) should be adjusted outward or clockwise until the left hand looper thread just tightens as the left hand looper thread should be drawn from the cone as the left hand looper moves to the end of its travel to the right.

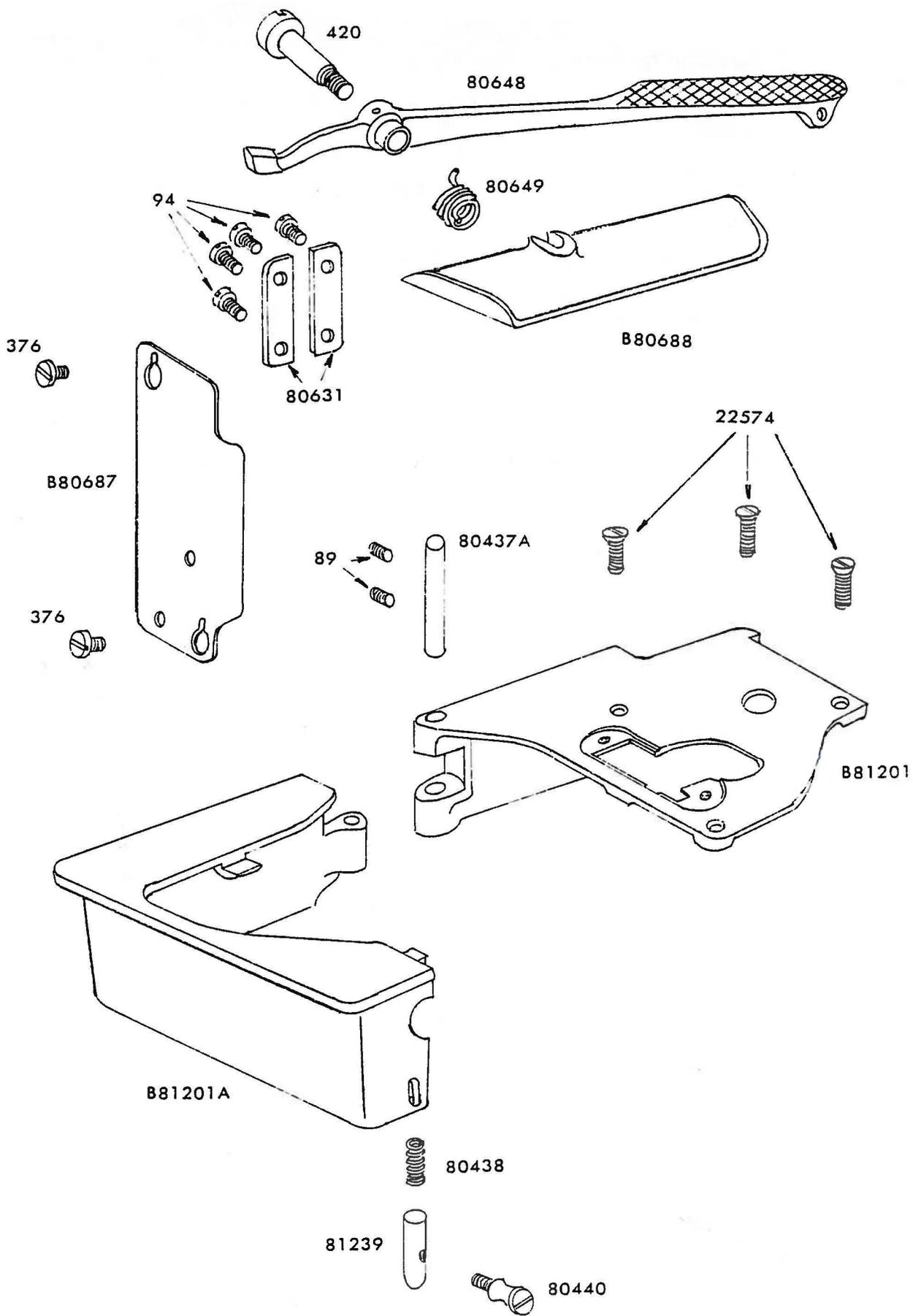


Plate No. 1

Plate No. 1

89	Set screw for Hinge pin.	2 pcs.
94	Set screw for Presser bar lifter guide plate and Looper thread guard.	4 pcs.
376	Screw for Face plate.	2 pcs.
420	Lifter lever stud.	1 pc.
22574	Screw for Cloth plate.	3 pcs.
80437A	Cloth plate swinging extension hinge pin.	1 pc.
80438	Spring for Locking bolt.	1 pc.
80440	Locking bolt knob.	1 pc.
80631	presser bar lifter guide plate.	2 pcs.
80648	Lifter lever.	1 pc.
80649	Lifter lever spring.	1 pc.
B80687	Face plate.	1 pc.
B80688	Top cover.	1 pc.
B81201	Cloth plate.	1 pc.
B81201A	Cloth plate swinging extension.	1 pc.
81239	Cloth plate swinging extension locking bolt.	1 pc.

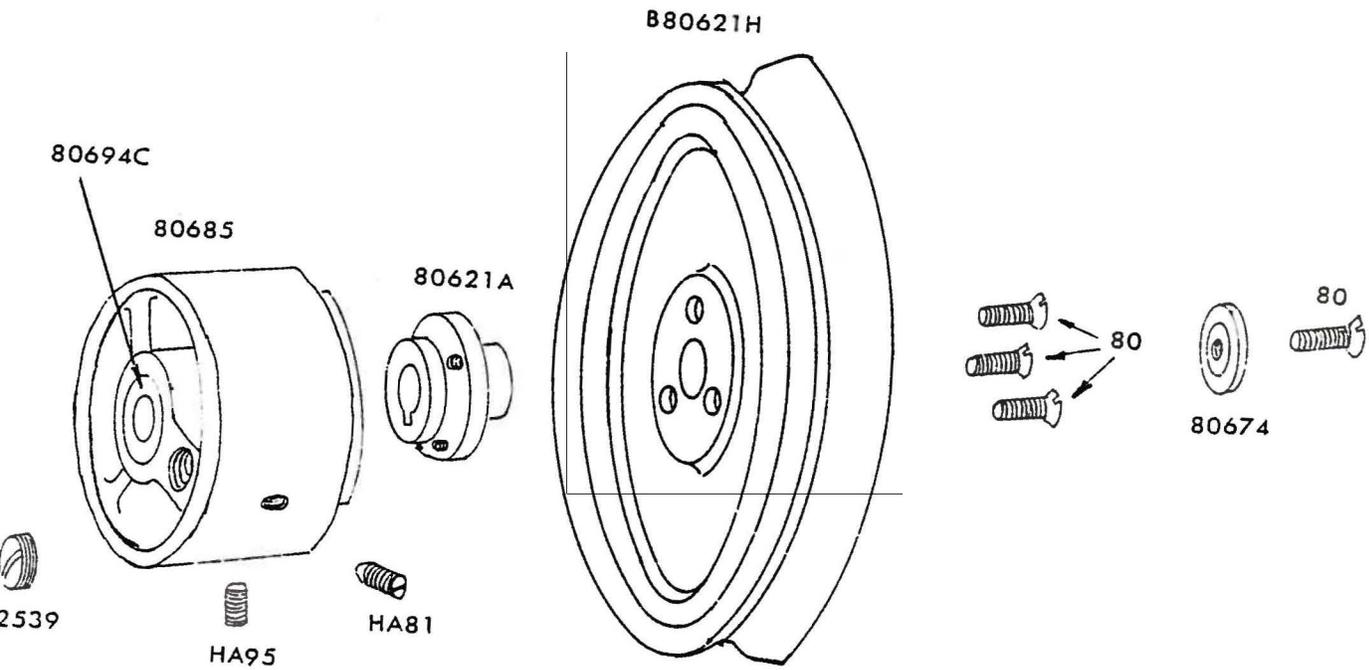
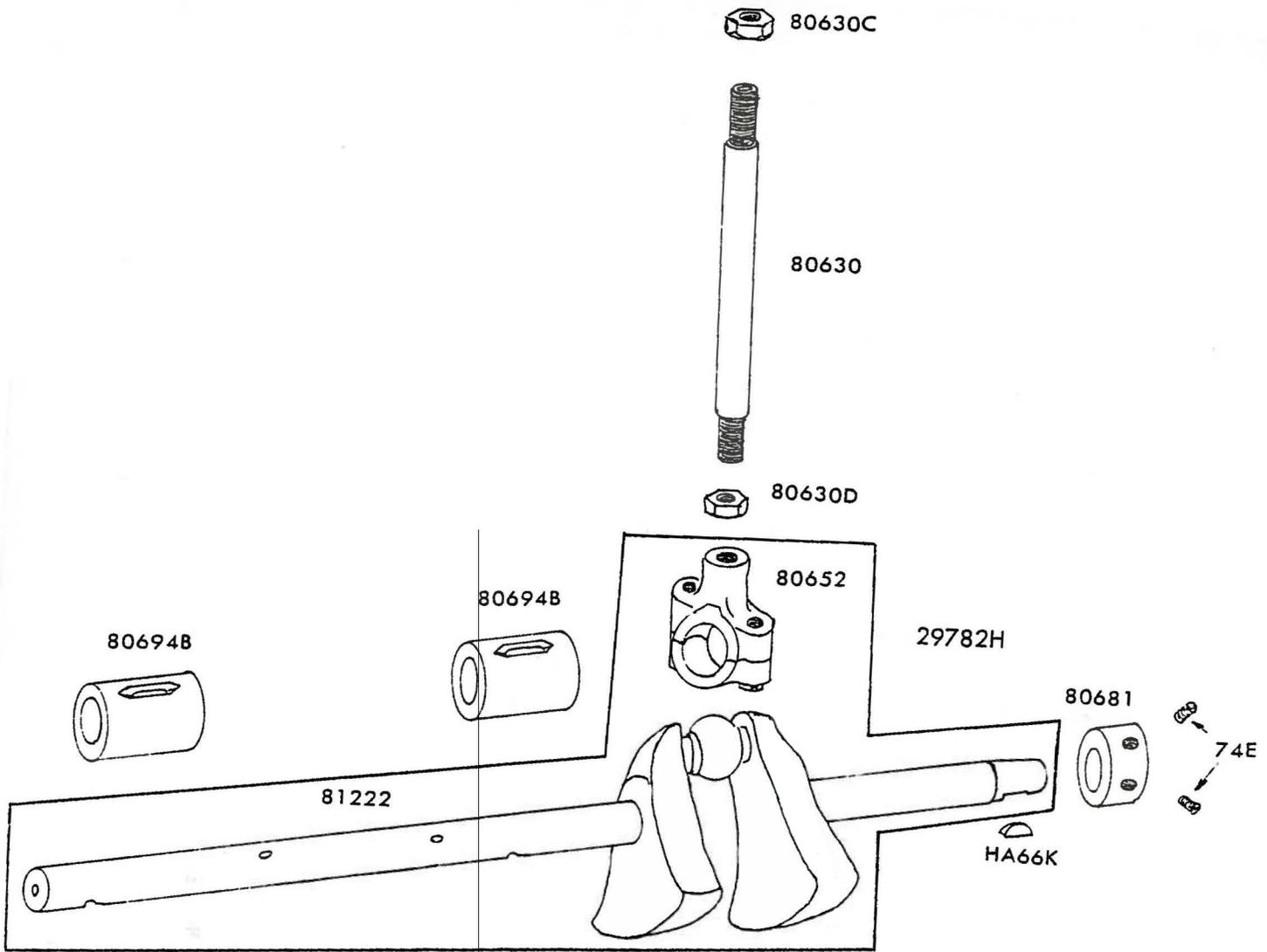
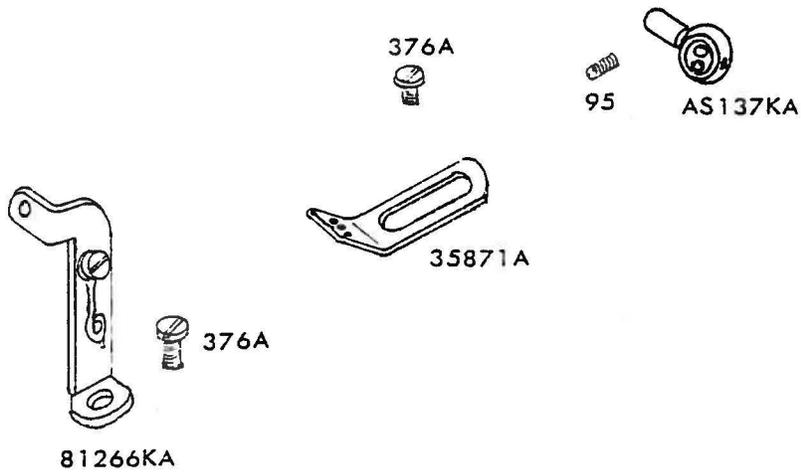
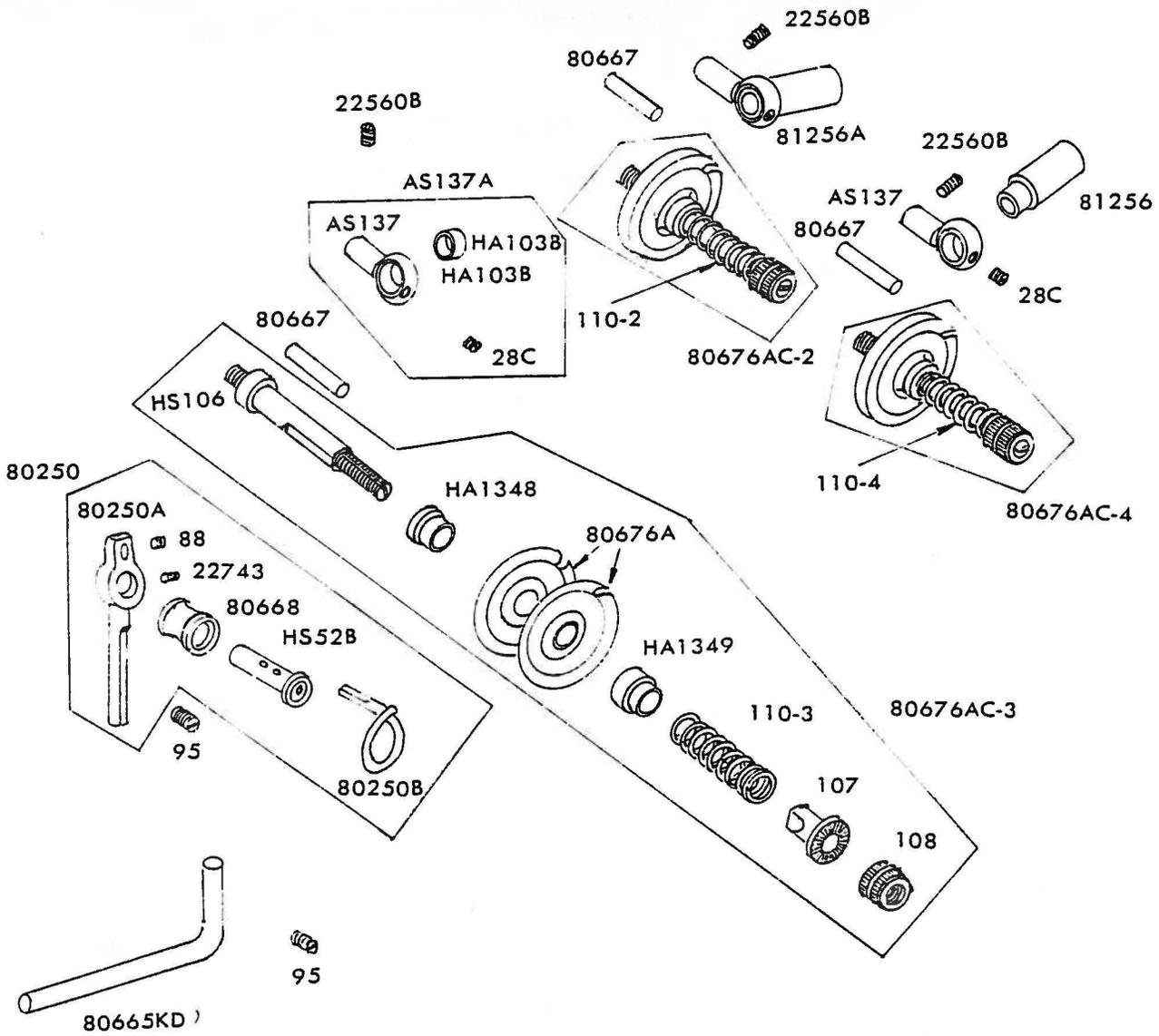


Plate No. 2

Plate No. 2

HA 66K	Key for Pulley hub.	1 pc.
74E	Screw for Main shaft collar.	2 pcs.
80	Screw for Wheel.	4 pcs.
HA 81	Spot screw for Main shaft bushing housing.	1 pc.
HA 95	Set screw for Main shaft bushing housing.	1 pc.
22539	Plung screw for Main shaft bearing sponge hole.	1 pc.
29782H	Main shaft assembly.	1 pc.
80621A	Wheel hub.	1 pc.
B80621H	Wheel rim.	1 pc.
80630	Needle lever connecting rod tube.	1 pc.
80630C	Needle lever connecting rod tube nut (left thread).	1 pc.
80630D	Needle lever connecting rod tube nut (right thread).	1 pc.
80652	Needle lever connection bearing (lower).	1 pc.
80674	Wheel hub lock washer.	1 pc.
80681	Main shaft collar.	1 pc.
80685	Main shaft bushing and housing.	1 pc.
80694B	Main shaft bushing, left and middle.	2 pcs.
80694C	Main shaft bushing, right.	1 pc.
81222	Main shaft.	1 pc.



28C	Set screw for Frame thread eyelet.	4 pcs.
HS 52B	Frame rolling thread guide axle assembly.	1 pc.
88	Set screw for Rolling thread guide.	1 pc.
95	Set screw.	3 pcs.
HA 103B	Frame thread eyelet.	1 pc.
HS 106	Tension post.	3 pcs.
107	Tension spring ferrule.	3 pcs.
108	Tension regulating nut.	3 pcs.
110-2	Tension spring for right hand looper thread.	1 pc.
110-3	Tension spring for left hand looper thread.	1 pc.
110-4	Tension spring for needle thread.	1 pc.
AS 137	Frame thread eyelet support.	4 pcs.
AS 137A	Frame thread eyelet assembly.	1 pc.
AS 137KA	Base thread eyelet assembly (two thread hole).	1 pc.
376A	Looper thread guide set screw.	2 pcs.
HA1348	Frame tension post ferrule, front.	3 pcs.
HA1349	Frame tension post ferrule, rear.	3 pcs.
22560B	Set screw for Frame thread guide.	3 pcs.
22743	Screw for Frame rolling thread guide axle.	1 pc.
35871A	Base thread guide.	1 pc.
80250	Frame needle thread rolling thread guide assembly.	1 pc.
80250A	Frame needle thread rolling thread guide support.	1 pc.
80250B	Frame needle thread rolling thread guide.	1 pc.
80665KD	Needle thread guide, (lower).	1 pc.
80667	Tension disc stop pin.	3 pcs.
80668	Needle thread take-up rolling thread guide roller.	1 pc.
80676A	Tension disc.	6 pcs.
80676AC-2	Thread tension assembly for Right hand looper thread.	1 pc.
80676AC-3	Thread tension assembly for Left hand looper thread.	1 pc.
80676AC-4	Thread tension assembly for Needle thread.	1 pc.
81256	Frame thread eyelet.	2 pcs.
81256A	Frame thread eyelet assembly.	2 pcs.
81266KA	Base thread guide assembly.	1 pc.

80673B



80617



- 13 -

HA56



80673A

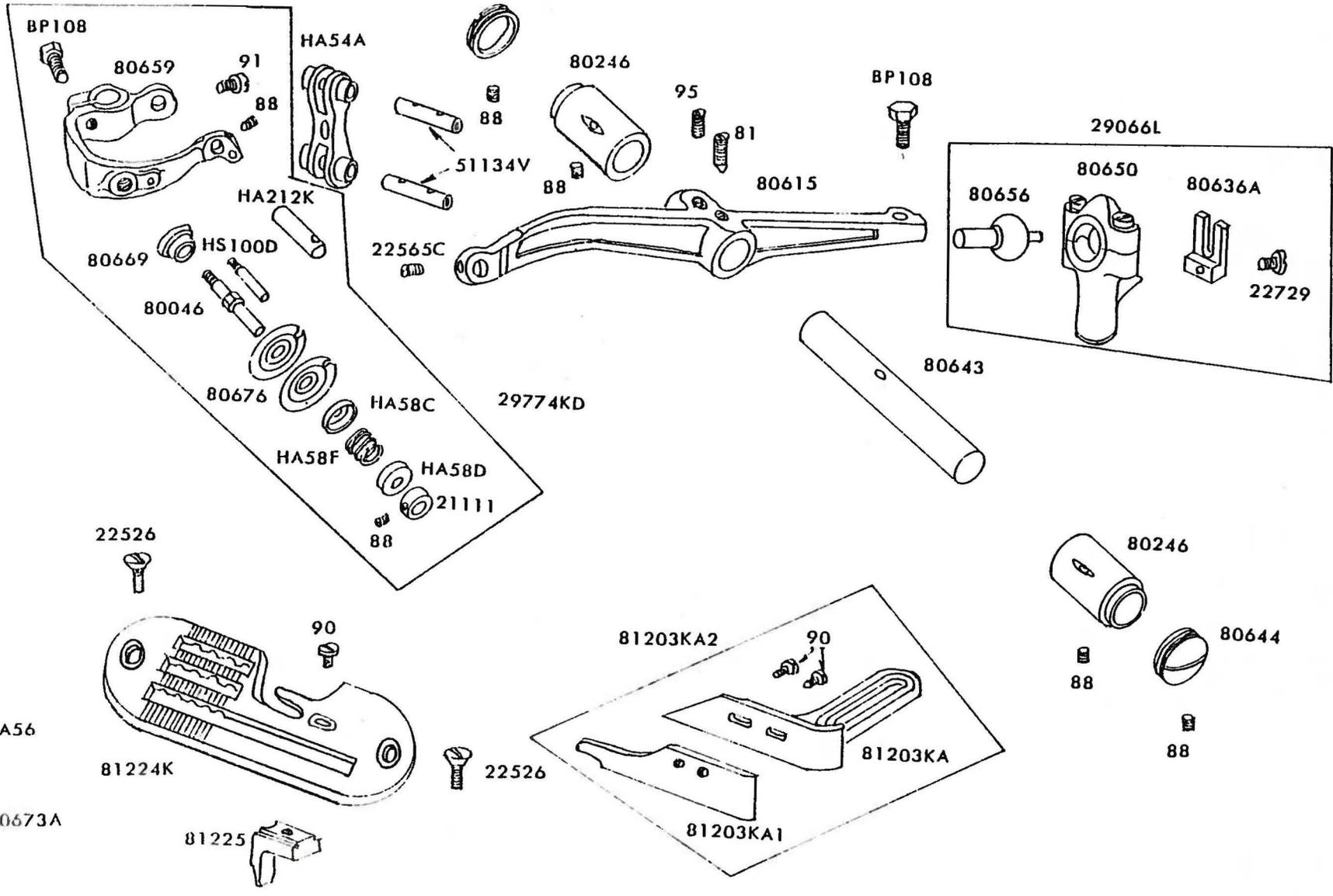
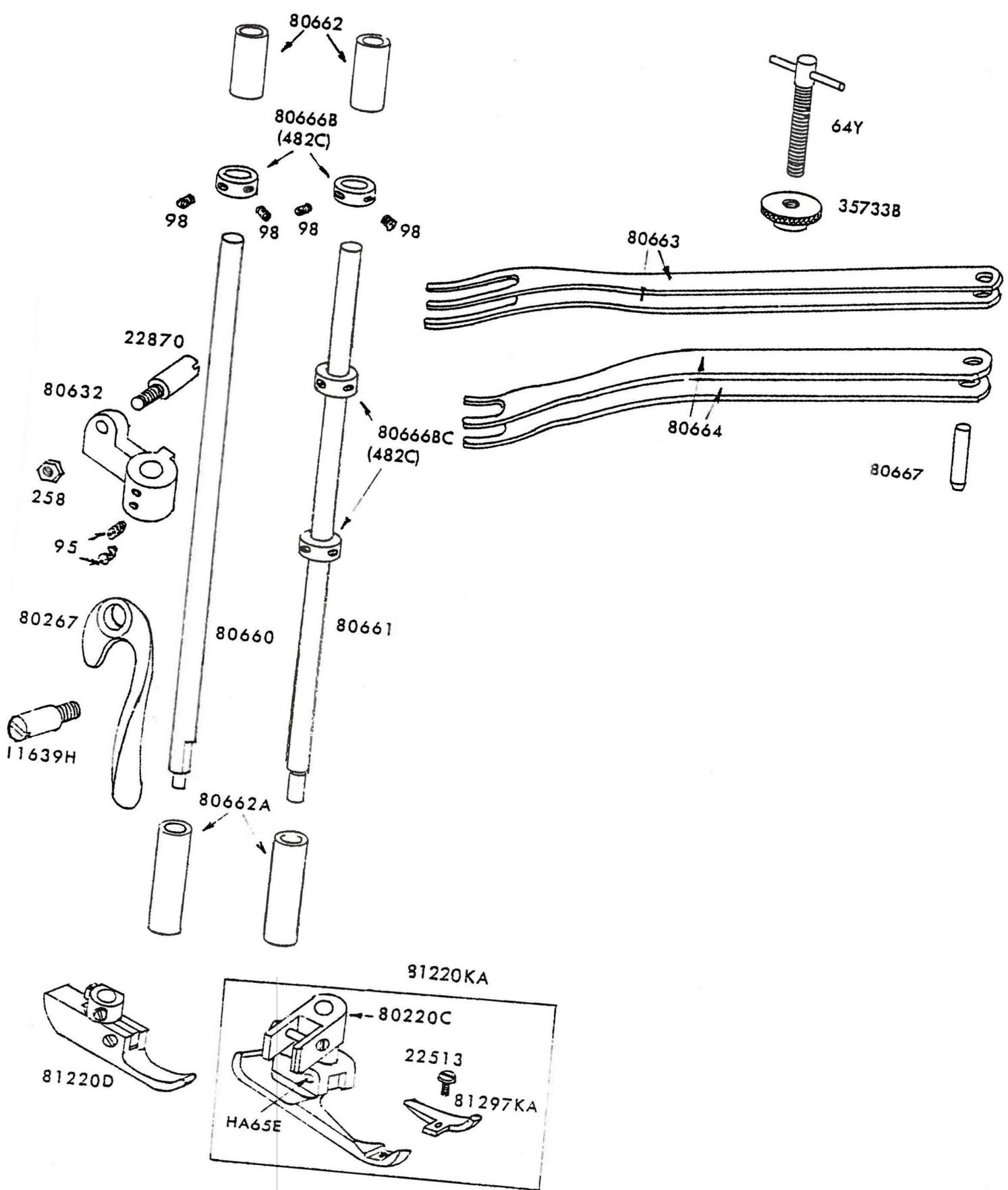


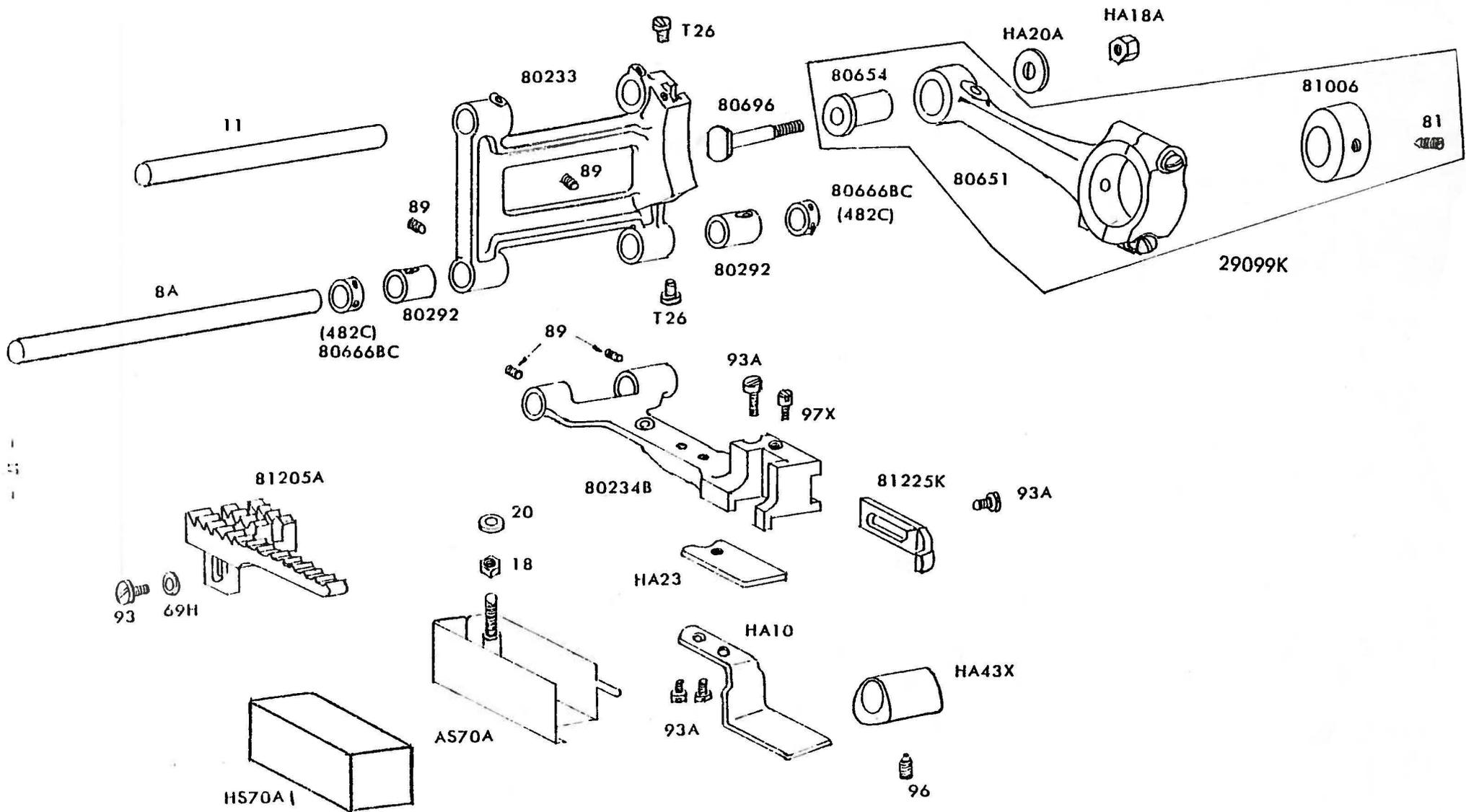
Plate No. 4

Plate No. 4

HA 54A	Needle bar link.	1 pc.
HA 56	Needle clamp nut.	1 pc.
HA 58C	Needle bar connection tension ferrule (front).	1 pc.
HA 58D	Needle bar connection tension ferrule (rear).	1 pc.
HA 58F	Needle bar connection spring.	1 pc.
81	Spot screw for Needle lever.	1 pc.
88	Set screw.	6 pcs.
90	Screw for Needle plate needle guard and Cloth plate edge guide tongue.	3 pcs.
91	Screw for Needle lever link upper pin.	1 pc.
95	Set screw for Needle lever.	1 pc.
HS 100D	Stop screw for Tension disc.	1 pc.
BP 108	Clamp screw for Needle bar connection and Needle lever ball.	2 pcs.
HA 212K	Thread guide for Needle bar connection.	1 pc.
21111	Needle bar connection post collar.	1 pc.
22526	Screw for Needle plate.	2 pcs.
22565C	Screw for Needle lever link lower pin.	1 pc.
22729	Screw for Needle lever ball stud fork.	1 pc.
29066L	Needle lever connecting rod upper bearing assembly.	1 pc.
29774KD	Needle bar connection assembly.	1 pc.
51134V	Needle lever link pin assembly.	2 pcs.
80046	Needle bar connection tension post.	1 pc.
80246	Needle lever shaft bushing.	2 pcs.
80615	Needle lever.	1 pc.
80617	Needle bar.	1 pc.
80636A	Needle lever ball stud fork.	1 pc.
80643	Needle lever shaft.	1 pc.
80644	Needle lever shaft hole plug screw.	2 pcs.
80650	Needle lever connection bearing, upper.	1 pc.
80656	Needle lever ball.	1 pc.
80659	Needle bar connection.	1 pc.
80669	Needle bar connection tension post ferrule (front).	1 pc.
80673A	Needle bar bushing (lower).	1 pc.
80673B	Needle bar bushing (upper).	1 pcs
80676	Tension disc.	2 pcs.
81203KA	Cloth plate edge guide.	1 pc.
81203KA-1	Cloth plate edge guide tongue.	1 pc.
81203KA-2	Cloth plate edge guide assembly.	1 pc.
81224K	Needle plate.	1 pc.
81225	Needle plate front needle guard.	1 pc.



64Y	Presser spring regulator screw.	1 pc.
HA 65E	Hinge screw for Right presser foot.	1 pc.
95	Set screw for Presser bar lifter.	2 pcs.
98	Screw for Presser bar collar.	8 pcs.
258	Nut for Lifter lever screw pin.	1 pc.
11639H	Hand lifter stud.	1 pc.
22513	Set screw for Presser foot tongue.	1 pc.
22870	Lifter lever screw pin.	1 pc.
35733B	Lock nut for Presser spring regulator screw.	1 pc.
80220C	Presser foot shank (right).	1 pc.
80267	Hand lifter.	1 pc.
80632	Presser bar lifter.	1 pc.
80660	Presser bar (left).	1 pc.
80661	Presser bar (right).	1 pc.
80662	Presser bar bushing (upper).	2 pcs.
80662A	Presser bar bushing (lower).	2 pcs.
80663	Presser spring (upper).	2 pcs.
80664	Presser spring (lower).	2 pcs.
80666B	Presser bar collar.	4 pcs.
80666BC	Presser bar collar with screw.	4 pcs.
80667	Presser spring pin.	1 pc.
81220D	Presser foot assembly (left).	1 pc.
81220KA	Presser foot assembly (right).	1 pc.
81297KA	Presser foot tongue.	1 pc.



8A	Feed rocker shaft.	1 pc.
HA 10	Feed bar prong.	1 pc.
11	Feed bar shaft.	1 pc.
18	Nut for Feed cam oiling felt holder.	1 pc.
HA 18A	Nut for Stitch regulating stud.	1 pc.
20	Washer for Feed cam oiling felt holder.	1 pc.
HA 20A	Washer for Stitch regulating stud.	1 pc.
HA 23	Feed bar shoe.	1 pc.
T 26	Stop screw for Stitch regulating stud.	2 pcs.
HA 43X	Feed lift cam.	1 pc.
69H	Washer for Feed dog screw.	1 pc.
AS 70A	Feed cam oiling felt holder.	1 pc.
HS 70A	Feed cam oiling felt.	1 pc.
81	Screw for Feed driving eccentric.	1 pc.
89	Set screw for Feed rocker and Feed bar.	4 pcs.
93	Set screw for Feed dog.	1 pc.
93A	Screw for Feed bar prong, Feed bar shoe and Feed bar needle guard.	4 pcs.
96	Spot screw for Feed lifter cam.	1 pc.
97X	Screw for Supporting feed dog.	1 pc.
98	Screw for Feed bar shaft collar.	4 pcs.
29099K	Feed driving eccentric assembly.	1 pc.
80233	Feed rocker.	1 pc.
80234B	Feed bar.	1 pc.
80292	Feed rocker shaft bushing.	2 pcs.
80651	Feed driving eccentric connection.	1 pc.
80654	Stitch regulating stud bushing.	1 pc.
80666B	Feed rocker shaft collar.	2 pcs.
80666BC	Feed rocker shaft collar with screw.	2 pcs.
80696	Stitch regulating stud.	1 pc.
81006	Feed driving eccentric.	1 pc.
81205A	Feed dog.	1 pc.
81225K	Feed bar rear needle guard.	1 pc.

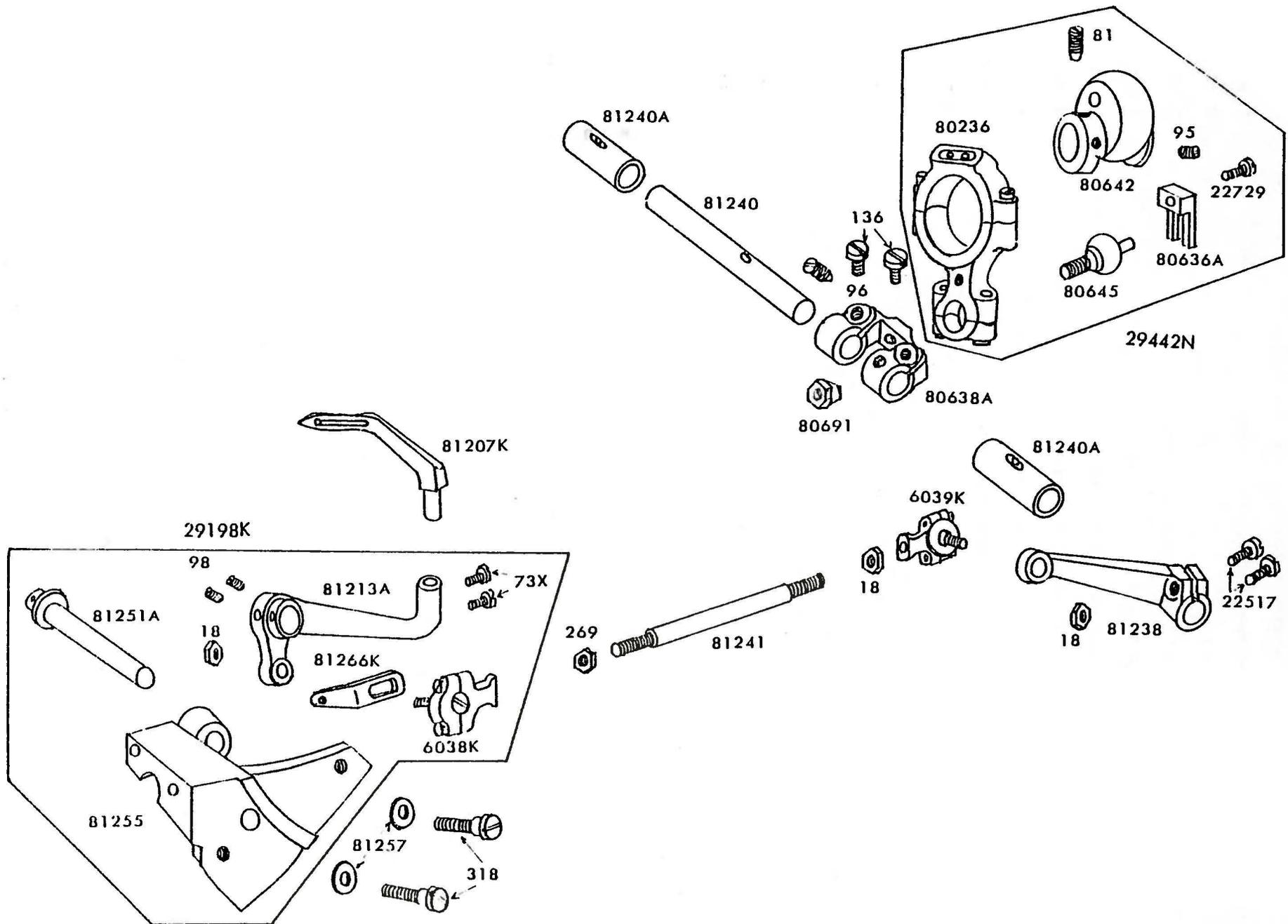


Plate No. 7

18	Nut for Looper drive connecting rod and Ball joint.	3 pcs.
HS 36K	Looper connecting rod ball joint washer.	1 pc.
73X	Set screw for Looper.	2 pcs.
81	Spot screw for Looper driving eccentric.	1 pc.
95	Set screw for Looper driving eccentric.	1 pc.
96	Spot screw for Looper drive lever shaft rocker.	1 pc.
98	Screw for Looper rocker (right hand).	2 pcs.
136	Clamp screw for Looper drive lever shaft rocker.	2 pcs.
269	Nut for Looper drive connecting rod (left thread).	1 pc.
318	Clamp screw for Right hand looper rocker shaft bearing.	2 pcs.
6038K	Looper rocker connecting rod ball joint (left).	1 pc.
6039K	Looper rocker connecting rod ball joint (right).	1 pc.
22517	Screw for Looper drive lever.	2 pcs.
22729	Screw for Looper lever ball stud fork.	1 pc.
29198K	Right hand looper rocker assembly.	1 pc.
29442N	Looper drive eccentric assembly.	1 pc.
80236	Looper drive eccentric connecting bearing.	1 pc.
80636A	Looper lever ball stud fork.	1 pc.
80638A	Looper drive lever shaft rocker.	1 pc.
80642	Looper drive eccentric.	1 pc.
80645	Looper drive eccentric connection ball stud.	1 pc.
80691	Looper drive eccentric connection ball stud nut.	1 pc.
81207K	Right hand looper.	1 pc.
81213A	Looper rocker (right hand).	1 pc.
81238	Looper drive lever.	1 pc.
81240	Looper drive lever shaft.	1 pc.
81240A	Looper drive lever shaft bushing.	2 pcs.
81241	Looper rocker connecting rod.	1 pc.
81251A	Right hand looper rocker shaft.	1 pc.
81255	Right hand looper rocker shaft bearing.	1 pc.
81257	Right hand looper rocker shaft bearing attaching screw washer.	2 pcs.
81266K	Left hand looper thread take-up.	1 pc.

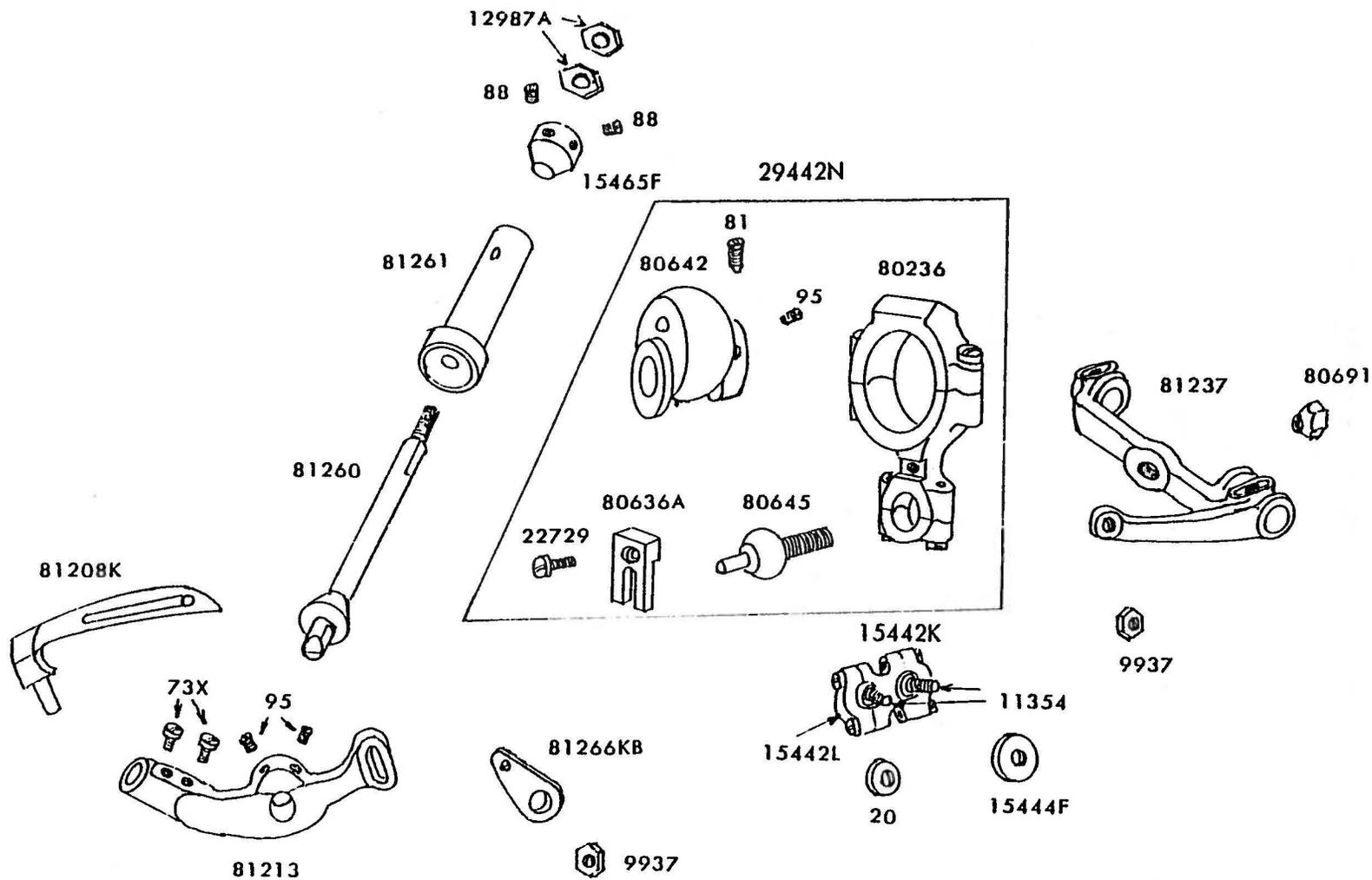


Plate No. 8

20	Washer for Looper rocker double ball joint right stud.	1 pc.
73X	Set screw for Looper.	2 pcs.
81	Spot screw for Looper driving eccentric.	1 pc.
88	Set screw for Looper rocker cone.	2 pcs.
95	Set screw for Looper driving eccentric and Looper rocker.	3 pcs.
9937	Nut for Looper rocker double ball joint stud.	2 pcs.
11354	Looper rocker double ball joint stud.	2 pcs.
12987A	Check nut for Looper rocker cone stud.	2 pcs.
15442K	Looper rocker double ball joint connection assembly.	1 pc.
15442L	Looper rocker double ball joint connection.	1 pc.
15444F	Washer for Looper rocker double ball joint left stud.	1 pc.
15465F	Looper rocker cone.	1 pc.
22729	Screw for Looper lever ball stud fork.	1 pc.
29442N	Looper driving eccentric assembly.	1 pc.
30236	Looper drive eccentric connecting bearing.	1 pc.
30636A	Looper lever ball stud fork.	1 pc.
30642	Looper drive eccentric.	1 pc.
30645	Looper drive eccentric connection ball stud.	1 pc.
30691	Looper drive eccentric connection ball stud nut.	1 pc.
31208K	Left hand looper.	1 pc.
31213	Looper rocker (left hand).	1 pc.
31237	Looper driving lever (left hand).	1 pc.
31260	Left hand looper rocker cone stud.	1 pc.
31261	Left hand looper rocker cone stud bushing.	1 pc.
31266KB	Right hand looper thread take-up.	1 pc.

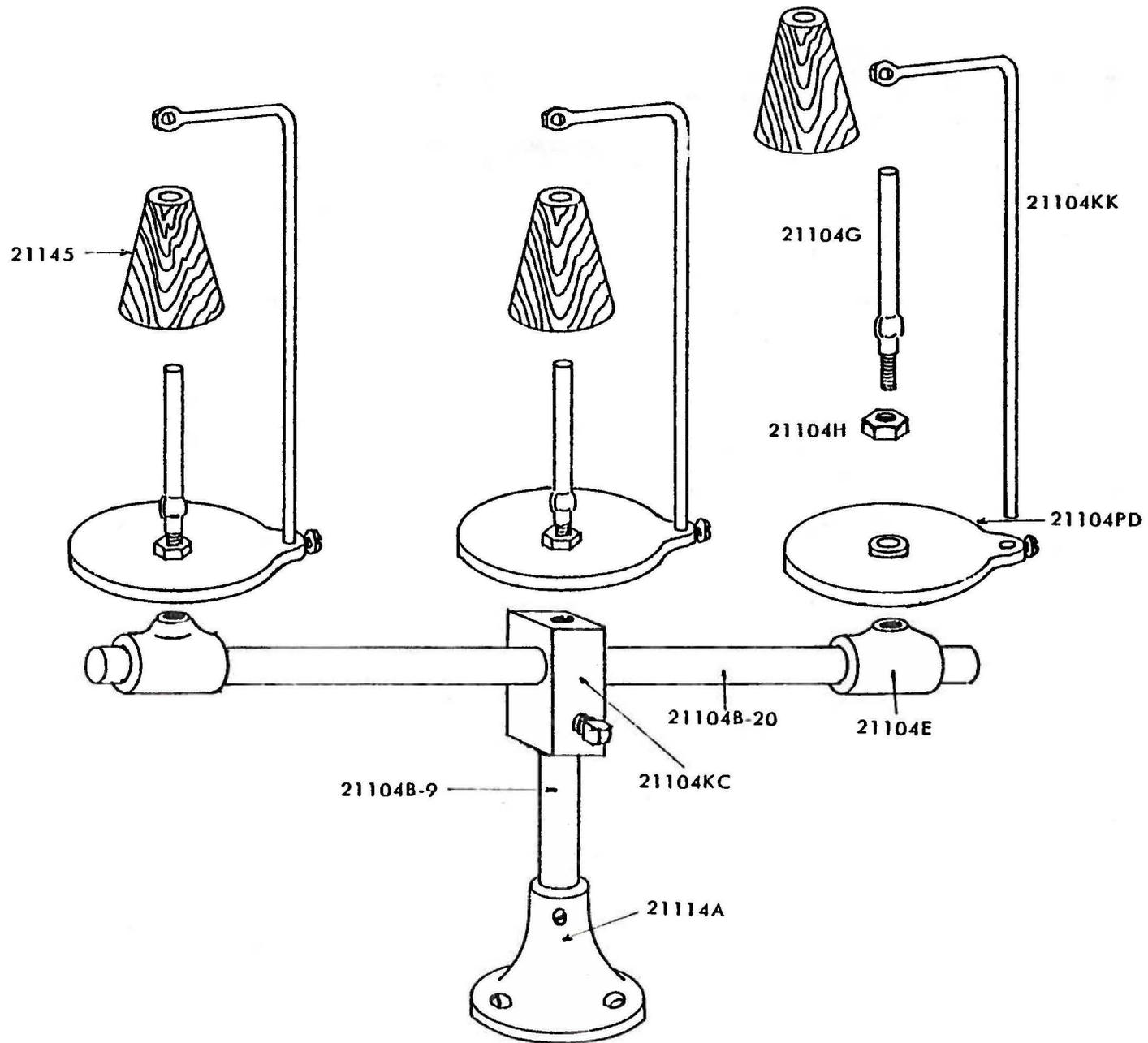


Plate No. 9

Plate No. 9

21104B-9	Thread stud support rod.	1 pc.
21104B-20	Thread stand seat support rod.	1 pc.
21104E	Thread seat connection.	2 pcs.
21104G	Thread stand seat pin.	3 pcs.
21104H	Thread stand seat pin nut.	3 pcs.
21104KC	Thread stand rod connection.	1 pc.
21104KK	Thread stand eyelet wire.	3 pcs.
21104PD	Thread stand seat.	3 pcs.
21114A	Thread stand base.	1 pc.
21145	Thread stand cone (wood).	3 pcs.

NUMERICAL LIST OF PARTS

Part No.	Plate No.	Part No.	Plate No.	Part No.	Plate No.
8A	6	97X	6	21104KC	9
HA 10	6	98	5,6,7	21104KK	9
11	6	HS 100D	4	21104PD	9
18	6,7	HA 103B	3	21111	4
HA18A	6	HS 106	3	21114A	9
20	6,8	107	3	21145	9
HA 20A	6	108	3	22513	5
HA 23	6	BP 108	4	22517	7
T 26	6	110-2	3	22526	4
28C	3	110-3	3	22539	2
HS 36K	7	110-4	3	22560B	3
HA 43X	6	136	7	22565C	4
HS 52B	3	AS 137	3	22574	1
HA 54A	4	AS 137A	3	22729	4,7,8
HA 56	4	AS 137KA	3	22743	3
HA 58C	4	HA 212K	4	22870	5
HA 58D	4	258	5	29066L	4
HA 58F	4	269	7	29099K	6
64Y	5	318	7	29198K	7
HA 65E	5	376	1	29442N	7,8
HA 66K	2	376A	3	29774KD	4
69H	6	420	1	29782H	2
AS 70A	6	HA1348	3	35733B	5
HS 70A	6	HA1349	3	35871A	3
73X	7,8	6038K	7	51134V	4
74E	2	6039K	7	80046	4
80	2	9937	8	80220C	5
81	4,6,7,8	11354	8	80233	6
HA 81	2	11639H	5	80234B	6
88	3,4,8	12987A	8	80236	7,8
89	1,6	15442K	8	80246	4
90	4	15442L	8	80250	3
91	4	15444F	8	80250A	3
93	6	15465F	8	80250B	3
93A	6	21104B-9	9	80267	5
94	1	21104B-20	9	80292	6
95	3,4,5,7,8	21104E	9	80437A	1
HA 95	2	21104G	9	80438	1
96	6,7	21104H	9	80440	1

Part No.	Plate No.	Part No.	Plate No.	Part No.	Plate No.
80615	4	80676AC-2	3	81261	8
80617	4	80676AC-3	3	81266K	7
80621A	2	80676AC-4	3	81266KA	3
B89621H	2	80681	2	81266KB	8
80630	2	80685	2	81297KA	5
80630C	2	B80687	1		
80630D	2	B80688	1		
80631	1	80691	7,8		
80632	5	80694B	2		
80636A	4,7,8	80694C	2		
80638A	7	80696	6		
80642	7,8	81006	6		
80643	4	B81201	1		
80644	4	B81201A	1		
80645	7,8	81203KA	4		
80648	1	81203KA-1	4		
80649	1	81203KA-2	4		
80650	4	81205A	6		
80651	6	81207K	7		
80652	2	81208K	8		
80654	6	81213	8		
80656	4	81213A	7		
80659	4	81220D	5		
80660	5	81220KA	5		
80661	5	81222	2		
80662	5	81224K	4		
80662A	5	81225	4		
80663	5	81225K	6		
80664	5	81237	8		
80665KD	3	81238	7		
80666B	5,6	81239	1		
80666BC	5,6	81240	7		
80667	3,5	81240A	7		
80668	3	81241	7		
80669	4	81251A	7		
80673A	4	81255	7		
80673B	4	81256	3		
80674	2	81256A	3		
80676	4	81257	7		
80676A	3	81260	8		