

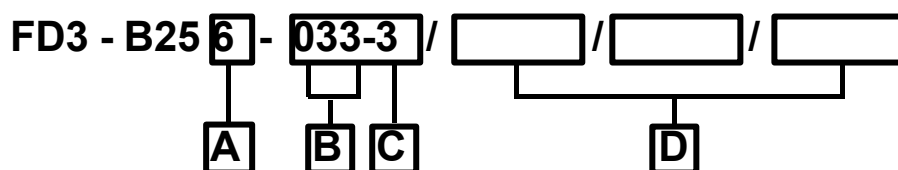
# FD3-B256 · B257

Cylinder Bed Bottom Covering Stitcher  
with Thread trimmer

Cylinder Bed Top and Bottom Covering  
Stitcher with Thread Trimmer



## Specifications



B	Specifications
011	Plain stitching
012*	Plain stitching (High stroke)
033	Covering
051	Hem stitching (The guide on the front cover)
053	Hem stitching (The guide on the needle plate)
056	Circular hemming (With puller) / Binder opener, Tension roller
061	Elastic hemming (With puller)
0V1	Spun knit elastic loop attaching (With puller) / Binder opener, Tension roller
0W1	Wide elastic loop attaching (With puller) / Tension roller, Right knife
0X1	Hem stitching / With left knife
0X3*	Hem stitching / With binder opener and left knife
0X6	Circular hemming (With puller) / Binder opener, Tension roller, Left knife

\* 012 and 0X3 specifications are available in limited area only.

A	Model
6	Bottom covering stitcher
7	Top and bottom covering stitcher

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

Device No.	Applicable model	D Device					
		Solenoid thread trimmer	Solenoid wiper	Solenoid top covering thread trimmer	Solenoid presser foot lifter	Pneumatic presser foot lifter	Pneumatic presser foot lifter
UT11	B256, B257	○	—	—	—	—	—
UT12	B256	○	○	—	—	—	—
UT13	B256, B257	○	—	—	○	—	—
UT14	B256	○	○	—	○	—	—
UT32	B257	○	—	○	—	—	—
UT34	B257	○	—	○	○	—	—
UT21	B256, B257	—	—	—	—	○	—
UT22	B256	—	○	—	—	○	—
UT23	B256, B257	—	—	—	—	○	○
UT24	B256	—	○	—	—	○	○
UT42	B257	—	—	○	—	○	—
UT44	B257	—	—	○	—	○	○
CS1	B256, B257	Condense stitch device					

## Specifications

Sub-class	Application	2-Needle				3-Needle		
		Gauge No.	Stitch pattern		Gauge No.	Stitch pattern		
			B256	B257		B256	B257	
-011	Plain stitching	-1 -2 -3 -4 -5			-6 -7 -8			
-012*2	Plain stitching (High stroke)	-	-	-	-	-		
-033	Covering	-3 -4 -5			-6 -7 -8			
-051 -053	Hem stitching -051: Guide front cover attaching type -053: Guide needle plate attaching type	-2 -3			-7 -8			
-056	Circular hemming w/puller Binder opener, Tension roller	-2 -3			-7 -8			
-061	Elastic hemming w/puller	-1 -2 -3			-	-	-	
-0V1*1	Spun knit elastic loop attaching w/puller Binder opener, Tension roller	-	-	-	-7 -8	-		
-0W1	Wide elastic loop attaching w/puller Tension roller, Right knife	-	-	-	-7 -8			
-0X1	Hem stitching w/left knife	-2 -3			-7 -8			
-0X3*2	Hem stitching w/left knife	-	-	-	-8	-		
-0X6	Circular hemming w/puller Binder opener, Tension roller Left knife	-2 -3			-7 -8			

\*1 The sub-class -0V1 is only for B257.

\*1 -012 and -0X3 specifications are available in limited area only.

Needle size	Stitch length (mm)	Needle bar stroke (mm)	Differential feed ratio (mm)	Height of presserfoot (mm)		Max. speed (rpm)
				B256	B257	
UYX128 #70 (#65-#90)	1.0-4.2	31.0	0.6-1.4	7.0	5.0	6,000
UYX128 #70 (#65-#90)	1.0-4.2	33.4	0.6-1.4	-	6.0	5,000
UYX128 #70 (#65-#90)	1.0-4.2	31.0	0.6-1.4	7.0	5.0	6,000
UYX128 #70 (#65-#90)	1.0-4.2	31.0	0.6-1.4	7.0	5.0	6,000
UYX128 #70 (#65-#90)	1.0-4.2	33.4	0.6-1.4	7.0	6.0	4,500
UYX128 #70 (#65-#90)	1.0-4.2	33.4	0.6-1.4	7.0	6.0	4,500
UYX128 #70 (#65-#90)	1.0-4.2	33.4	0.6-1.4	-	6.0	4,500
UYX128 #70 (#65-#90)	1.0-4.2	33.4	0.6-1.4	7.0	6.0	4,500
UYX128 #70 (#65-#90)	1.0-4.2	31.0	0.6-1.4	7.0	5.0	5,000
UYX128 #70 (#65-#90)	1.0-4.2	31.0	0.6-1.4	-	5.0	5,000
UYX128 #70 (#65-#90)	1.0-4.2	33.4	0.6-1.4	7.0	6.0	4,500

### 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 Thread wiper set

Solenoid type

Part name	Part code	Q'ty
Thread wiper set, A	183821-201	1

Air type

Part name	Part code	Q'ty
Thread wiper set	S28896-001	1

## Presser foot lifter set

Solenoid type

Part name	Part code	Q'ty
Solenoid presser foot lifter set (A)	183795-401	1

\* With the knee switch

Solenoid type

Part name	Part code	Q'ty
Solenoid presser foot lifter set (B)	183796-401	1

\* Without the knee switch

Air type

Part name	Part code	Q'ty
Pneumatic presser foot lifter set	S28904-001	1

\* Without the knee switch

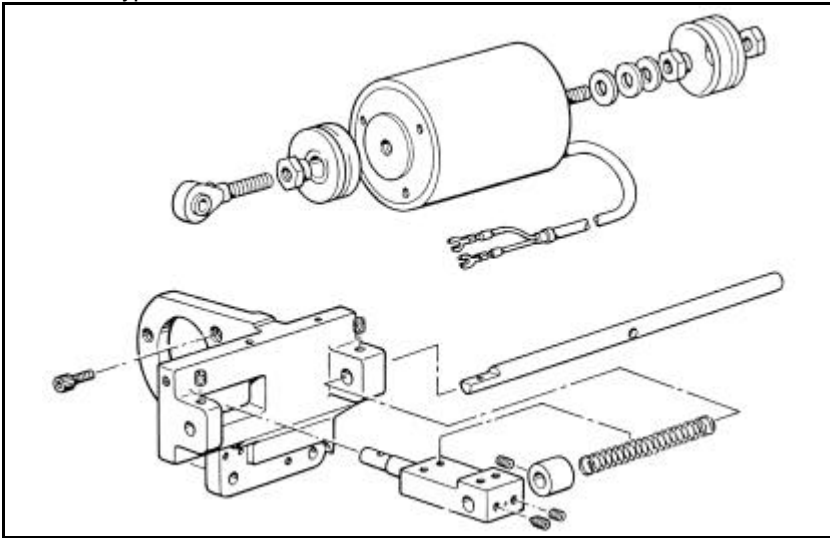
## Solenoid upper thread trimmer set

Part name	Part code	Q'ty
Upper thread trimmer set	S28915-001	1

\* With the face plate exclusively for this set.

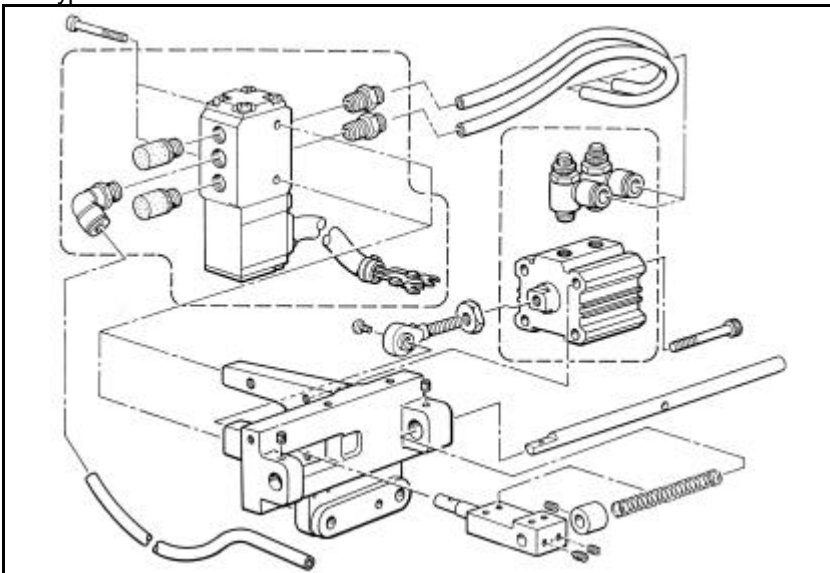
# Thread trimmer set

Solenoid type



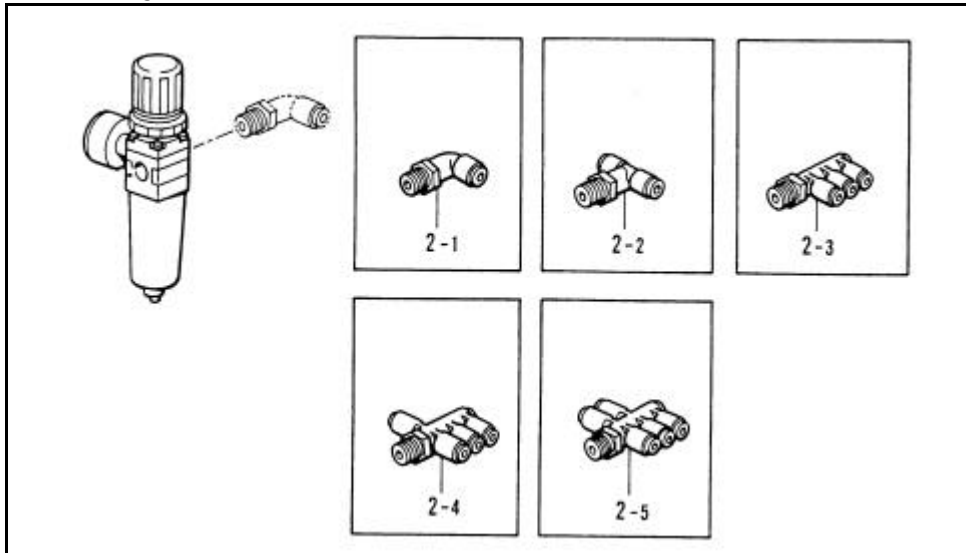
Part name	Part code	Q'ty
Solenoid thread trimmer set	S28906-001	1

Air type



Part name	Part code	Q'ty
Pneumatic thread trimmer set	S28908-001	1

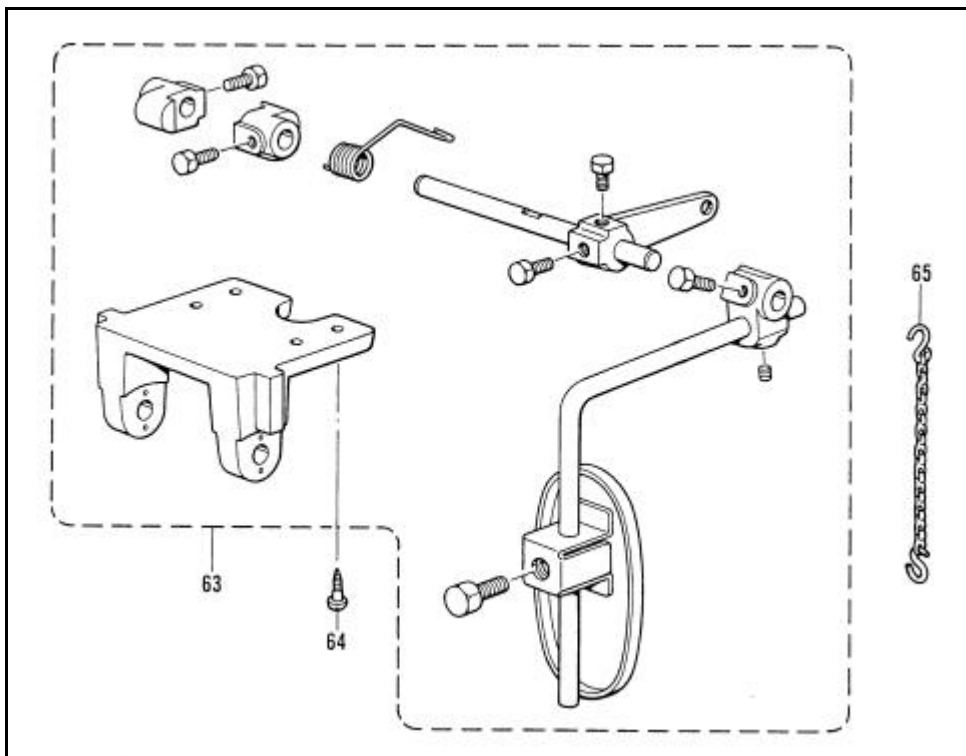
## Air tube joint



Ref. No.	Part name	Part code	Q'ty
2-1	Elbow union	S04896-000	1
2-2	T-union	S28469-000	1
2-3	Triple joint (3)	S28470-000	1
2-4	Triple joint (4)	S28471-000	1
2-5	Triple joint (5)	S28472-000	1

\* Use this when using more than one air-driven device together.

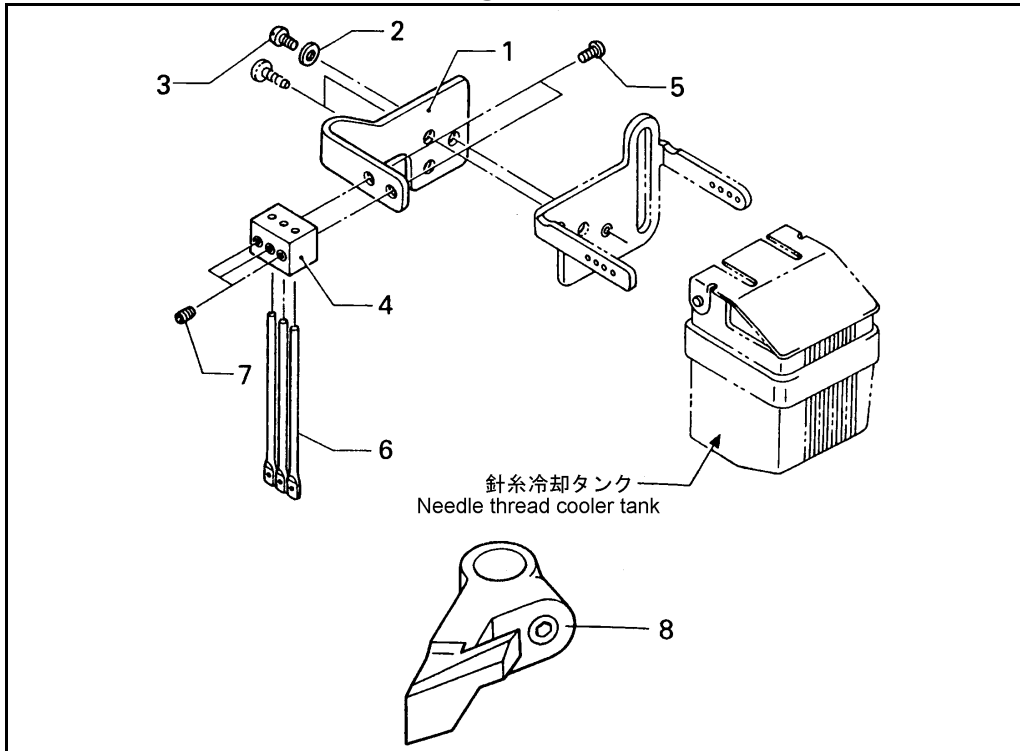
## Knee lifter device



Ref. No.	Part name	Part code	Q'ty
63	Knee lifter device assy	155196-409	1
64	Screw 4.1 × 25	032422-505	4
65	Chain assy	S28357-001	1

\* When used on the machine with the right knife specification (-071, -075), this enables you to stop and restart the operation of the cloth knife at any place during sewing.

## 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	S28483-101	1
—	Instruction manual	S91251-262	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.

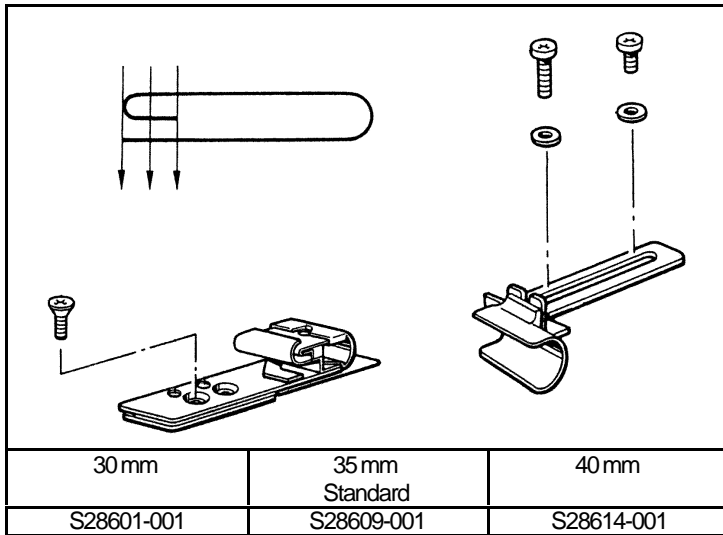
\* This needle guard, BH is effective in preventing stitch skipping caused by unwanted left needle backward movement.

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

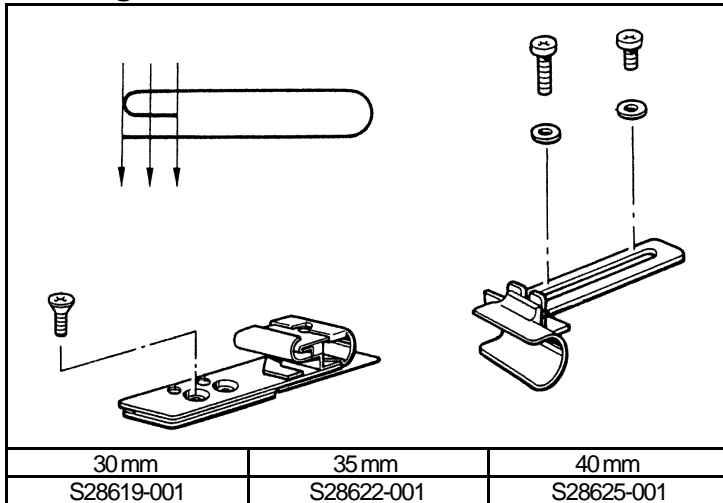
## Rubber binder assy (For -0V1)

\* The 35-mm threshold rubber binder is provided as a standard.

### Threshold seam



### Felting





## Conversion parts for installing the table

\* For table dimensions and installation, refer to the instruction manual supplied with the machine.

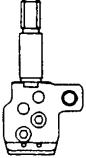
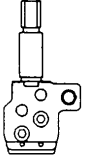
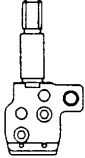
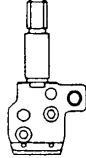
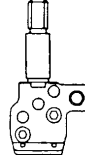
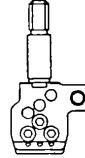
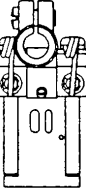
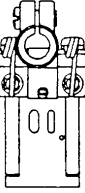

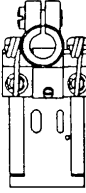
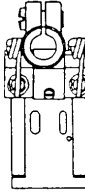
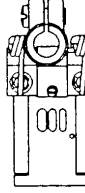
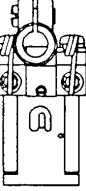
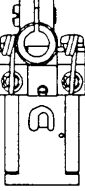
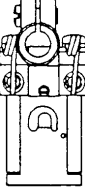
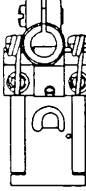
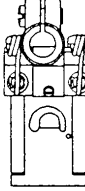
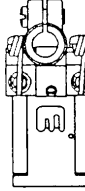
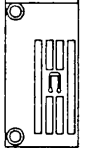
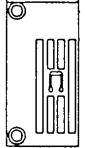
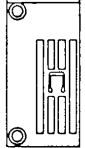
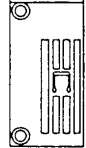
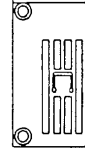
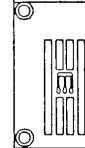
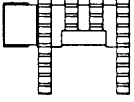
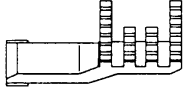
### Raised type → Semi-submerged type

Ref. No.	Part name	Part code	Q'ty
27	Head plate assy	S28830-001	2
28	Bolt, M8 x55	211964-001	4
29	Nut, 1 M8	021080-106	4
30	Washer, spring 2-8	028080-242	4
31	Washer, plain M8	025080-236	4



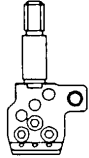
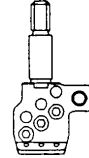
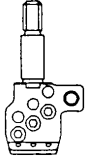
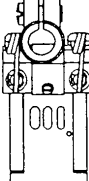
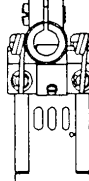
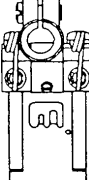
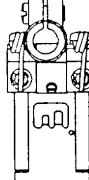
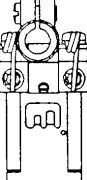
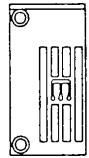

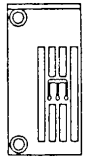
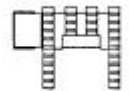
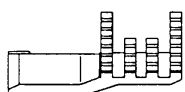
### Semi-submerged type → Raised type

Ref. No.	Part name	Part code	Q'ty
37	Rubber cushion pin	S28441-001	4
38	Retaining ring, U5	S28442-001	4
39	Washer, plain M6	025060-236	4
40	Washer, spring 2-6	028060-242	4
41	Nut, 1M6	021060-106	4
53	Sub belt cover	S28444-001	1
54	Screw, oval M5.5 x 20	100666-002	3
55	Washer, plain S 5.56	025750-132	3



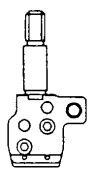
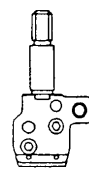


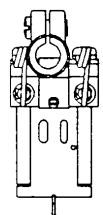
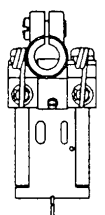
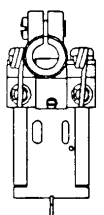
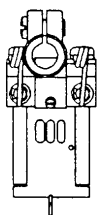
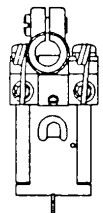
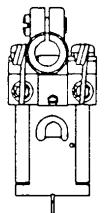
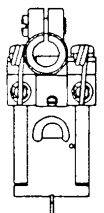
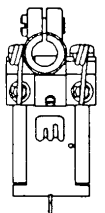
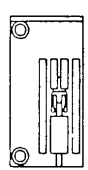

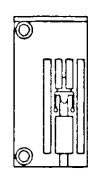

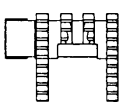
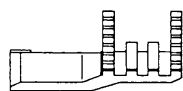
# Gauge parts list

Model	B256 B257	B256 B257	B256 B257	B256 B257	B256 B257	B256 B257
Specifications	011-1	011-2	011-3	011-4	011-5	011-6
Label	S08678-001	S08678-002	S08678-003	S08678-004	S08678-005	S08678-006
Application	Plain stitching		B256		B257	
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	S28770-001 	S28772-001 	S28774-001 	S28776-001 	S28778-001 	S28780-001 
Presser foot assy (B256)	S21832-001 	S21834-001 	S21836-001 	S21838-001 	S21840-001 	S21842-001 
Presser foot assy (B257)	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	S28237-001 					
Differential feed dog	S28242-001 					









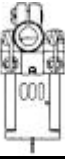
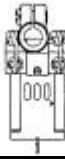
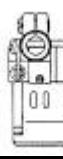



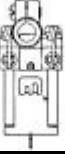
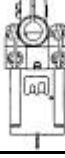
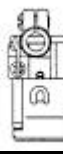

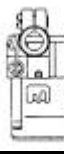
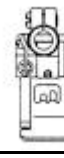
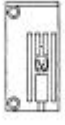







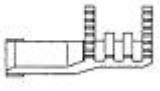
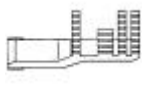
# Gauge parts list

Model	B256 B257	B256 B257	B257
Specifications	011-7	011-8	012
Label	S08678-007	S08678-008	S08678-097
Application	Plain stitching B256  B257 		
No. of needles	3	3	3
Needle gauge (mm)	5.6	6.4	6.4
Needle clamp assy	S28782-001 	S28784-101 	S28784-101 
Presser foot assy (B256)	S21844-001 	S21846-001 	- -
Presser foot assy (B257)	S08796-201 	S08798-201 	S08798-201 
Needle plate	S08723-001 	S08724-001 	S08724-001 
Main feed dog	S28237-001 		
Differential feed dog	S28242-001 		

# Gauge parts list

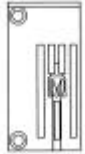
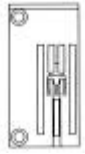
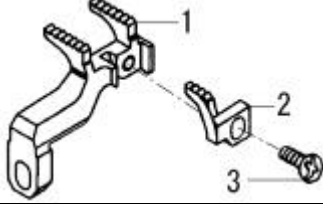
Model	B256 B257	B256 B257	B256 B257	B256 B257
Specifications	033-3	033-4	033-5	033-6
Label	S08678-064	S08678-065	S08678-066	S08678-067
Application	Covering <div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <p>B256</p>  </div> <div style="text-align: center;"> <p>B257</p>  </div> </div>			
No. of needles	2	2	2	3
Needle gauge (mm)	4.8	5.6	6.4	4.8
Needle clamp assy	S28774-001 	S28776-001 	S28778-001 	S28780-001 
Presser foot assy (B256)	S21848-001 	S21850-001 	S21852-001 	S21854-001 
Presser foot assy (B257)	S08828-201 	S08830-201 	S08832-201 	S08834-201 
Needle plate	S21823-001 	S21824-001 	S21825-001 	S21826-001 
Main feed dog	S28239-001 			
Differential feed dog	S28244-001 			

## Gauge parts list

Model	B256 B257	B256 B257	B256 B257	B256 B257	B256 B257	B256 B257
Specifications	033-7	033-8	051-2	051-3	051-7	051-8
Label	S08678-068	S08678-069	S08678-057	S08678-058	S08678-062	S08678-063
Application	Covering B256 		Hemstitching B256 			
No. of needles	3	3	2	2	3	3
Needle gauge (mm)	5.6	6.4	4.0	4.8	5.6	6.4
Needle clamp assy	S28782-001 	S28784-101 	S28772-001 	S28774-001 	S28782-001 	S28784-101 
Presser foot assy (B256)	S21856-001 	S21858-001 	S28140-101 	S28142-101 	S28144-101 	S28146-101 
Presser foot assy (B257)	S08836-201 	S08838-201 	S28121-101 	S28123-101 	S28125-101 	S28127-101 
Needle plate	S21827-001 	S21828-001 	S28079-001 	S28080-101 	S28081-001 	S28082-001 
Main feed dog	S28239-001 		S28240-001 			
Differential feed dog	S28244-001 		S28245-001 			






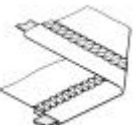






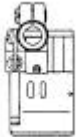
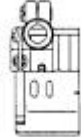
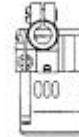
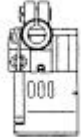
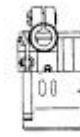
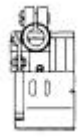
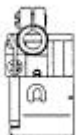




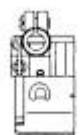






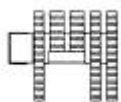

## Gauge parts list

\* With covering specification, the differential feed dog whose center portion height can be adjusted and the needle plate which is used with the feed dog are available as optional parts.


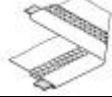


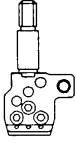
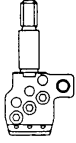
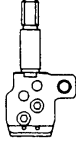
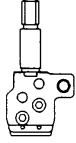
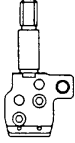
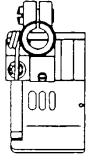
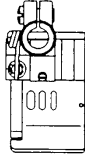
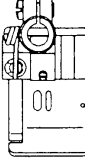
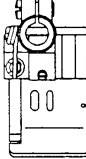
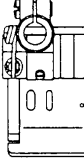
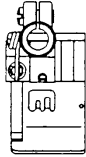
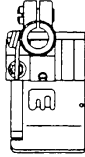
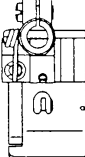
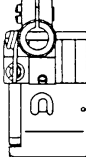
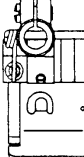

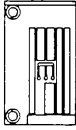
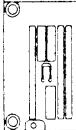
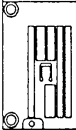
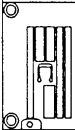
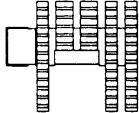
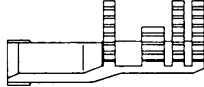
Needle plate	S28931-001 	S28932-001 	
Differential feed dog			
Ref. No.	Part name	Part code	Qty
1	Differential feed dog L	S28929-001	1
2	Differential feed dog S	S28930-001	1
3	Screw, pan SM3.18-40×6	062660-612	1

\* When you want to use the differential feed dog listed above or if you are using the old needle guard (F) (S28091-001), replace with the new needle guard (F) (S28091-101) **(Changed in 1995)**.

## Gauge parts list




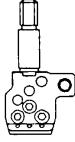

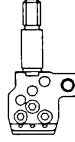
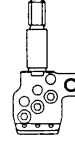
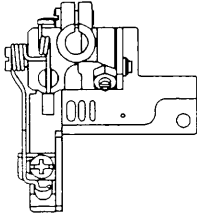
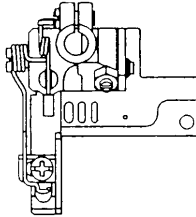
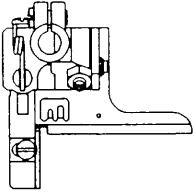
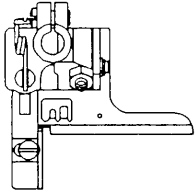
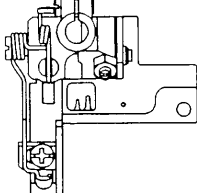
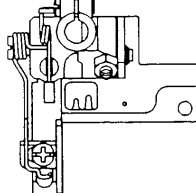
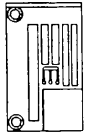
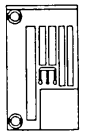
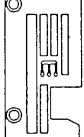
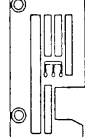
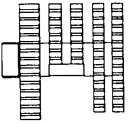
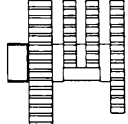
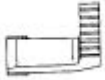
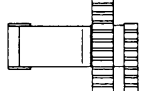
Model	B256 B257	B256 B257	B256 B257	B256 B257	B256 B257	B256 B257
Specifications	053-2	053-3	053-7	053-8	056-2	056-3
Label	S08678-090	S08678-091	S08678-095	S08678-096	S08678-070	S08678-071
Application	Hemstitching  B256  B257  B256  B257 				Circular hemming (With puller and binder opener) B256  B257 	
No. of needles	2	2	3	3	2	2
Needle gauge (mm)	4.0	4.8	5.6	6.4	4.0	4.8
Needle clamp assy	S28772-001 	S28774-001 	S28782-001 	S28784-001 	S28772-001 	S28774-001 
Presser foot assy (B256)	S28140-101 	S28142-101 	S28144-101 	S28146-101 	S28579-101 	S28581-101 
Presser foot assy (B257)	S28121-101 	S28123-101 	S28125-101 	S28127-101 	S28548-101 	S28550-101 
Needle plate	S28079-001 	S28080-001 	S28081-001 	S28082-001 	S28542-001 	S28543-001 
Main feed dog	S28240-001 					
Differential feed dog	S28245-001 					

# Gauge parts list






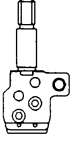
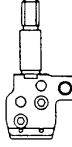
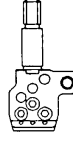
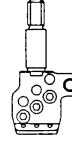

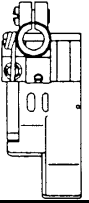
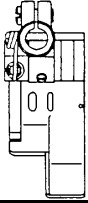
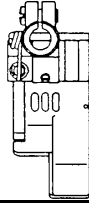
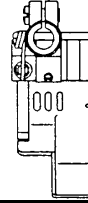
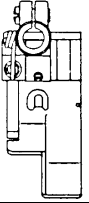
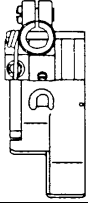
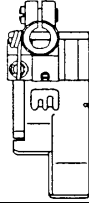
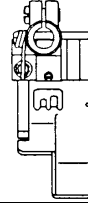
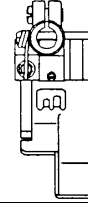

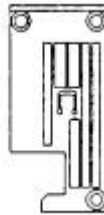



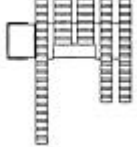
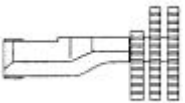
Model	B256 B257	B256 B257	B256 B257	B256 B257	B256 B257
Specifications	056-7	056-8	061-1	061-2	061-3
Label	S08678-072	S08678-073	S08678-074	S08678-075	S08678-076
Application	Circular hemming (With puller and binder opener) B256  B257 		Elastic hemming (With puller) B256  B257 		
No. of needles	3	3	2	2	2
Needle gauge (mm)	5.6	6.4	3.2	4.0	4.8
Needle clamp assy	S28782-001 	S28784-101 	S28770-001 	S28772-001 	S28774-001 
Presser foot assy (B256)	S28583-101 	S28585-101 	S28138-101 	S28140-101 	S28142-101 
Presser foot assy (B257)	S28552-101 	S28554-101 	S28118-101 	S28121-101 	S28123-101 
Needle plate	S28544-001 	S28545-001 	S28078-001 	S28079-001 	S28080-001 
Main feed dog	S28240-001 				
Differential feed dog	S28245-001 				







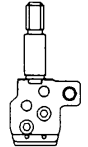
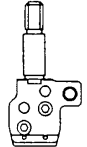
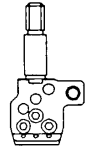
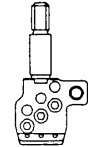
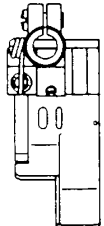
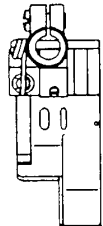
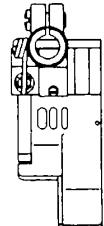
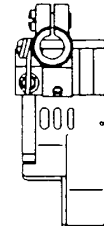
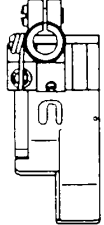
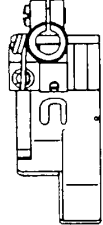
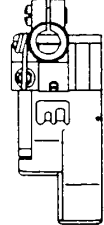
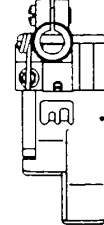
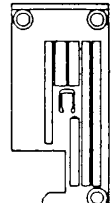
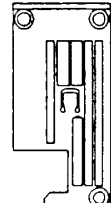
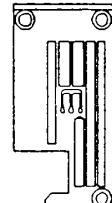
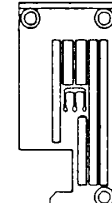
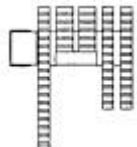
# Gauge parts list

Model	B257	B257	B256 B257	B256 B257
Specifications	OV1-7	OV1-8	OW1-7	OW1-8
Label	S08678-077	S08678-078	S08678-079	S08678-080
Application	Spun knit elastic loop attaching (With puller and binder opener) B257 		Wide elastic loop attaching (With puller and binder opener) B256  B257 	
No. of needles	3	3	3	3
Needle gauge (mm)	5.6	6.4	5.6	6.4
Needle clamp assy	S28782-001 	S28784-101 	S28782-001 	S28784-001 
Presser foot assy (B256)	/		S28587-001 	S28589-001 
Presser foot assy (B257)	S28556-001 	S28561-001 	S28563-001 	S28565-001 
Needle plate	S28546-001 	S28547-001 	S08745-001 	S08746-001 
Main feed dog	S28595-001 		S28238-001 	
Differential feed dog	S28243-001 		S28246-001 	

# Gauge parts list

Model	B256 B257	B256 B257	B256 B257	B256 B257	B257
Specifications	OX1-2	OX1-3	OX1-7	OX1-8	OX3
Label	S08678-081	S08678-082	S08678-083	S08678-084	S08678-098
Application	Hem stitching (With left knife)    				Hem stitching (With binder opener and left knife) 
No. of needles	2	2	3	3	3
Needle gauge (mm)	4.0	4.8	5.6	6.4	6.4
Needle clamp assy	S28772-001 	S28774-001 	S28782-001 	S28784-101 	S28784-101 
Presser foot assy (B256)	S28148-101 	S28150-101 	S28152-101 	S28154-101 	
Presser foot assy (B257)	S28129-101 	S28132-101 	S28134-101 	S28136-101 	S28136-101 
Needle plate	S28083-001 	S28084-001 	S28085-001 	S28086-001 	S28086-001 
Main feed dog	S28241-001 				
Differential feed dog	S28247-001 				

# Gauge parts list

Model	B256 B257	B256 B257	B256 B257	B256 B257
Specifications	OX6-2	OX6-3	OX6-7	OX6-8
Label	S08678-085	S08678-086	S08678-087	S08678-088
Application	Hem stitching (With left knife)			
	B256 	B257 	B256 	B257 
No. of needles	2	2	3	3
Needle gauge (mm)	4.0	4.8	5.6	6.4
Needle clamp assy	S28772-001 	S28774-001 	S28782-001 	S28784-101 
Presser foot assy (B256)	S28751-101 	S28753-101 	S28755-101 	S28757-101 
Presser foot assy (B257)	S28571-101 	S28573-101 	S28575-101 	S28577-101 
Needle plate	S28083-001 	S28084-001 	S28085-001 	S28086-001 
Main feed dog	S28241-001 			
Differential feed dog	S28247-001 