



SAILRITE®

Est. 1969

FABRICATOR® ASSEMBLY INSTRUCTIONS



Video instructions available at
[Sailrite.com/fabricator-setup](https://www.sailrite.com/fabricator-setup)
or search part #300300XHT.

Quick Start Content Table

Standard Fabricator Assembly..... 1 Deluxe Fabricator Assembly..... 13



Fabricator Packaging

The Fabricator Sewing Machine head comes in a specially designed box with foam packaging to protect it from damage.

Save all original packaging to use if the machine ever needs to be sent in for service. Carriers will not pay insurance claims on improperly packaged machines even if they are insured.

Sew like a pro with Sailrite®

For step-by-step video instructions for your new Fabricator Sewing Machine, please refer to [Sailrite.com/fabricator-setup](https://www.sailrite.com/fabricator-setup) or search #300300XHT at Sailrite.com.



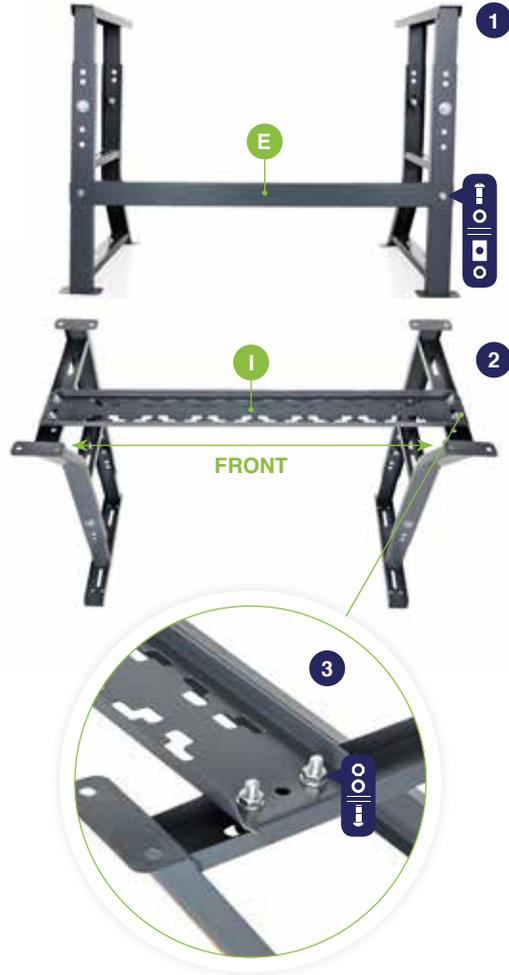
"I'm here to help! Give these videos a watch for seamless setup."
— Eric Grant

Leg Assembly

Find parts **A**, **B**, **C** and **D**. Stand both K-legs upright and bolt the back support bar (**E**) to the bottom hole at the back of the table legs (1). Do not tighten down.



Find parts **F**, **G** and **H**. Flip the legs upside down and place the treadle mount bar (**I**) at the back of the forward most slots (2). Bolt the treadle mount bar to the bottom surface of the K-legs (3). Do not tighten down.



Attaching Tabletop & Drawer

On a soft surface, place the tabletop “bottom” side up. Line up the table legs as shown (4). The back support bar (**E**) should be on the same side of the table as the three motor mount holes (**J**).

Line the slots (**K**) of the legs up with the pilot holes in the bottom of the tabletop. Use **L**, **M** and **N** to bolt the legs to the tabletop.

Tighten down all attachment points (1, 3).

Install the drawer with screws (**O**) by lining up the rails (**P**) with the pilot holes in the bottom of the tabletop. Overtightening the screws will prevent drawer from sliding smoothly.

Install rubber foot pads on each of the rectangular leg bases (5).

Table Height

Stand table upright and use bolts (**Q**) to adjust table height to the desired location.



Installing the Treadle

Find the treadle pedal (A) and use B, C, D and E to mount the L-bracket (B) as shown (6).

Flip the table on to its back side and use pivots (F) to install the treadle in the center of the treadle mount bar (7).

Ensure L-bracket (B) is pointing toward the back support bar (G). Tighten down.

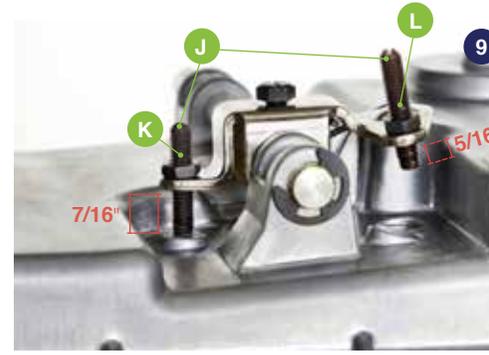
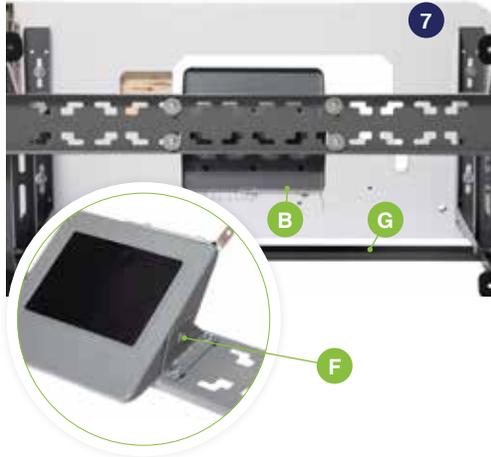
Important: Flip the table upright and check to make sure the treadle moves freely after the bolts are tightened. If not, loosen bolts and reposition one of the pivots.

Before Continuing: See “Attaching a Pulley” and “Installing the Workhorse® Servo Motor” in the Workhorse Servo Motor Instructions.

Installing the Linkage Bar

Bolt the linkage bar (H) to the outermost hole of the motor operation lever on the Workhorse (I) and the L-bracket (B) (10).

By increasing or decreasing the overlap of the linkage bar, different treadle pedal angles can be achieved.



Oil Pan Installation

Flip the oil tray upside down and locate the two stop screws (J). The stop screw that touches the oil tray (K) needs to be adjusted so the screw beneath the bracket equals 7/16 inch. The stop screw that doesn't touch the oil tray (L) needs to be adjusted to equal 5/16 inch.

Locate the two back corner cushions (M) and the two front corner cushions (N).

Slide the four corner cushions onto each respective corner flange and tilt the tray into the tabletop cutout so that all four corner cushions drop down into the ledges (10). The edge of the oil tray with the crescent cutout (O) should be facing the left side of the table, away from the belt slot (P).

Note: The black packaging discs at the corners of the oil pan should be removed and discarded.



Machine Installation

Push the machine Support Pin (A) into the hole in the tabletop nearest the carriage bolts holding the motor (11).

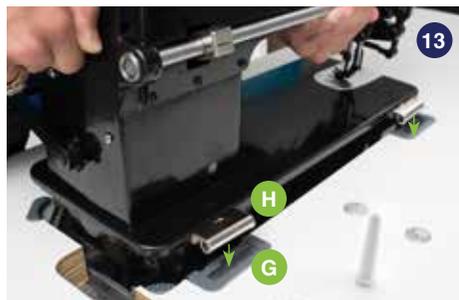
Insert the tapered end of the knee lift post connector (B) into the raised hole in the bottom of the oil tray (C) (12).

Find the magnet for the oil tray (D) and place it in the bottom of the oil tray (12).

Take the rubber pads (E) off of the chrome hinges (F) and place them into their respective tabletop cavities (G). Insert the two chrome hinges into the two holes located on the back side of the sewing machine (H).

With help, lift and lower the sewing machine into the tabletop so that the chrome hinges fit into the rubber pads (13).

Note: Do not cut away the string on the bottom of the machine; it is an oil wick.



Check Motor Rotation

The machine's motor shaft should rotate counterclockwise when viewed from the motor shaft end. Plug in the motor, switch the power on, and press down on the foot treadle to confirm operation now.

If motor rotation is not counterclockwise, please refer to "Changing Motor Rotation" in the Workhorse® Installation Instructions.



15

Securing the Stitch PRO Balance Wheel

Remove the three screws (A) for the belt cover installation. Position the C-shaped belt guard (B) and reinstall the screws, making sure washers are positioned as shims behind the guard to keep it from being bent out of shape.

Unscrew the reverse-threaded Posi-Pin® nut (C). Slide the Stitch PRO Balance Wheel (D) onto the bushing, making sure it does not interfere with the belt guard. If the wheel hits the guard, reposition the washers placed under the C-shaped belt guard or move the bushing out further by loosening the set screws in the bushing flange (E).

16



17



Push the Posi-Pin® (16) through the hole in the balance wheel (F). While maintaining pressure on the Posi-Pin, rotate the balance wheel (G) until the Posi-Pin locks into one of the balance wheel bushing holes (H). Rotation of the balance wheel will now cause the machine to function.

To disengage the machine (for bobbin winding), pull the Posi-Pin out of the balance wheel. The balance wheel will now rotate without operating the machine. Push the Posi-Pin into the hole at the center of the Posi-Pin nut (I) to store.

Belt Adjustment for the Workhorse® Servo Motor

Before installing the drive belt (J), loosen the screw (K) to allow the Workhorse Servo Motor to freely pivot.

With the machine tilted back, slip the drive belt over the balance wheel track (L) and guide it onto the motor pulley (M) then carefully lower the machine.

Pivot the motor back to tighten the belt. Proper adjustment of the belt results in 3/8 inch of slack when pressed by finger at its center. Retighten set screw (K). The Linkage Bar (N) may also need to be readjusted.

Once installed, the belt should not touch the table and should be centered on the track of both the balance wheel and motor pulley. Adjust the positioning of the motor left or right by loosening the bolts attaching the motor to the table.

Once the motor is in the correct position and all bolts are tightened, tilt the machine back and remove the belt so the pulley bracket can be installed.

Before Continuing: See "Installing the Pulley Cover" in the Workhorse instructions.



18

Attaching the Balance Wheel Belt Cover

Reinstall the belt and locate the remaining portion of the belt cover (19). It has a keyway (A) that locks onto post (B) of the C-shaped belt guard that was secured to the machine (20). Connect the covers and remove the remaining screw in the machine casting (C). Reinstall the screw through the slot (D) at the bottom of the belt cover (21). Position the screw in the slot to provide proper belt clearance above and below the balance wheel.



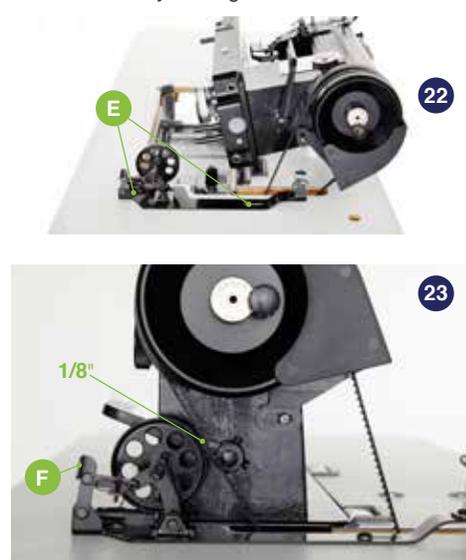
Attaching the Bobbin Winder

Position the bobbin winder so its slots (E) are over the pilot holes in the table. Tilt the machine head back and start to screw the bobbin winder down (22). Do not fully tighten the screws.

Tilt the machine back down into the table and position the bobbin winder so it's 1/8 inch forward of the belt when disengaged (23).

Once the proper location is found, fully tighten the bobbin winder down.

Note: Pressing the thumb pad (F) will engage the bobbin winder by moving the wheel into the belt.



Installing the Knee Lift Assembly

Assemble the knee lift (G) and attach it to the shaft sticking out from the oil tray (H). Adjust the knee lift to your desired location.

Attaching the Flex20 LED Light

To attach the Flex20 LED light (I), place the light in your desired location (25) on the machine and plug it into the back of the motor.

Note: 220 volt motors do not have an outlet so a wall outlet must be used.

Adhere the square plastic pads to the back of the sewing machine and use the zip ties to hold the cord to the machine casting.

To attach the light to a non-magnetic surface, use the round adhesive pad.

Mounting the Thread Stand

Assemble the thread stand as shown (26).

Secure it to the tabletop with included hardware.



Removing the Fabric Sample

Cut the thread from the top of the machine and ensure the needle is all the way up. If it is not, raise the needle by grabbing the top of the balance wheel and rotating toward the front of the machine (A). **Never** rotate the other direction. Use your knee or hand to push the knee lift (B) to the right, this will lift the feet. Remove the fabric sample while holding the knee lift to the right. Cut the thread coming from below the machine.

Note: If you want to lock the feet in the up position, push the knee lift to the right and pivot lever (C) into the up position. Release the knee lift and the feet will stay up. Actuate knee lift and lower lever (C) to drop the feet.



Auto Lubrication

Fill the oil tray with the oil found in the sewing machine box. Try to keep the oil level between the highest and lowest markings on the oil pan (28).

When it becomes necessary to change the oil, unscrew plug (D) to drain oil. Wipe the dirty oil and the dust from the oil drip pan, replace the plug and add fresh oil. Use any high-quality, clear sewing machine oil.

Please proceed to the Fabricator Guidebook.



Deluxe Leg Assembly

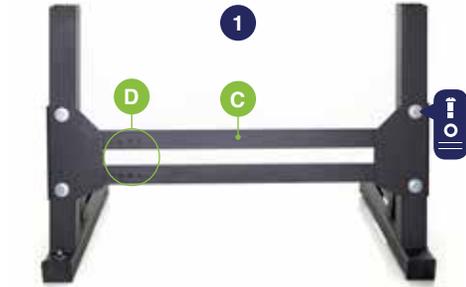
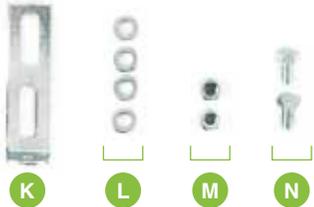
Find parts **A** and **B**. Stand both leg bottoms upright and bolt the back support bar (**C**) to the holes in the back of the legs so the support bar holes (**D**) are to the left (**1**). Do not tighten down.



Flip the legs on their back and place the treadle mount bar (**E**) over the slots in the legs (**F**). Use parts **G**, **H** and **I** to bolt the treadle mount bar to the leg bottoms (**2**). The chamfered side of the rectangle bolt (**I**) should face the slot in the leg (**3**). Do not tighten down.



Find the treadle pedal (**J**) and use **K**, **L**, **M** and **N** to mount the L-bracket (**K**) as shown (**4**).



Installing the Treadle

On the bottom of the treadle pedal (**J**) there are two bolts mounted to a pivoting bar. With the L-bracket (**K**) pointing toward the back support bar (**C**), place the bolts through the slots (**5**). The nub (**O**) should be to the far left of the right slot. Use **P** and **Q** to lock the pedal in place.

Flip the legs upright and install the arms (**R**) into the top of the leg bottoms so the measurement marks (**S**) are facing out (**6**). Sit in front of the table to determine your desired table height. Use **T** and **U** to lock the height in place. The measurement marks help determine an equal setting between the two arms.



Attaching Tabletop & Drawer

Place the tabletop on a soft surface so the bobbin case access (A) is facing up. Flip the legs upside down and position the holes (B) of the arms over the pilot holes in the tabletop (8). The back support bar (C) should be positioned above the three motor mount holes (D). Screw the legs in place with E and F.



Install the drawer with screws (G) by lining up the rails (H) with the pilot holes in the tabletop. Overtightening the screws prevents the drawer from sliding smoothly.



Flip the table upright and tighten down the back support bar (p. 13, 1). Position the treadle mount bar forward or back to your desired position and tighten down (p. 13, 2).

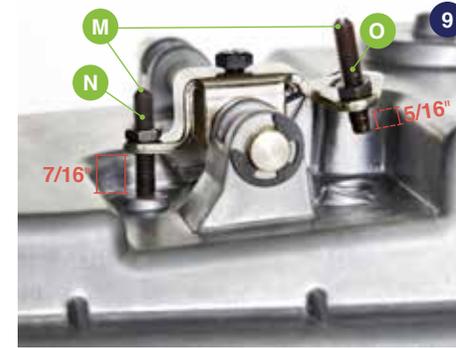
Before Continuing: See “Attaching a Pulley” and “Installing the Workhorse® Servo Motor” in the Workhorse Servo Motor Instructions.

Installing the Linkage Bar

Bolt the linkage bar (I) to the outermost hole of the motor operation lever (J) and the L-bracket (K) (7).

Increasing or decreasing the overlap of the linkage bar, changes the angle of the treadle pedal.

Note: You want at least a 1/2-inch clearance between the bottom of the treadle pedal and the floor (L).



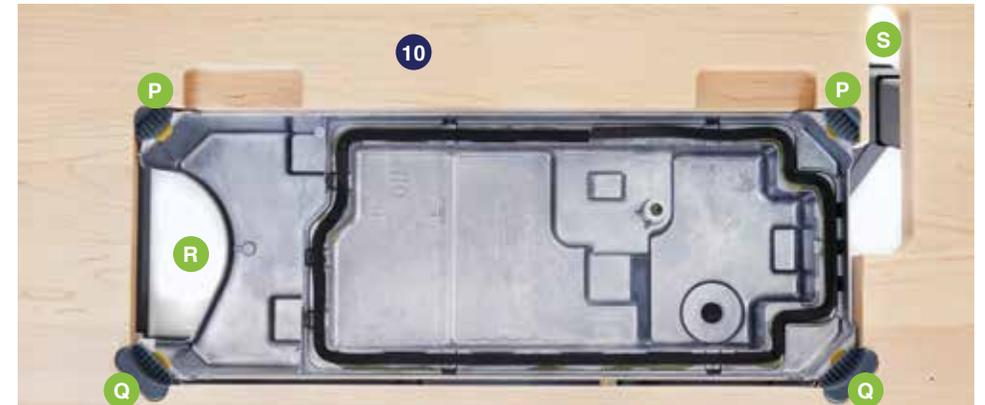
Oil Pan Installation

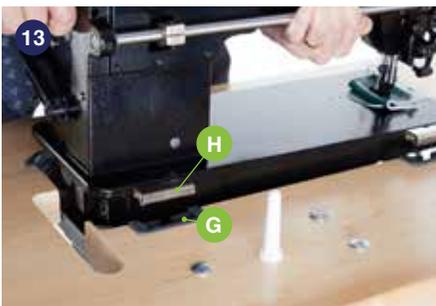
Flip the oil tray upside down and locate the two stop screws (M). The stop screw that touches the oil tray (N) needs to be adjusted so the screw beneath the bracket equals 7/16 inch. The stop screw that doesn't touch the oil tray (O) needs to be adjusted to equal 5/16 inch.

Locate the two back corner cushions (P) and the two front corner cushions (Q).

Slide the four corner cushions onto each respective corner flange and tilt the tray into the tabletop cutout so that all four corner cushions drop down into the ledges (10). The edge of the oil tray with the crescent cutout (R) should be facing the left side of the table, away from the belt slot (S).

Note: The black packaging discs at the corners of the oil pan should be removed and discarded.





Machine Installation

Push the machine Support Pin (A) into the hole in the tabletop nearest the carriage bolts holding the motor (11).

Insert the tapered end of the knee lift post connector (B) into the raised hole in the bottom of the oil tray (C) (12).

Find the magnet for the oil tray (D) and place it in the bottom of the oil tray (12).

Take the rubber pads (E) off of the chrome hinges (F) and place them into their respective tabletop cavities (G). Insert the chrome hinges into the holes located on the back of the sewing machine (H).



With help, lift and lower the sewing machine into the tabletop so that the chrome hinges fit into the rubber pads (13).

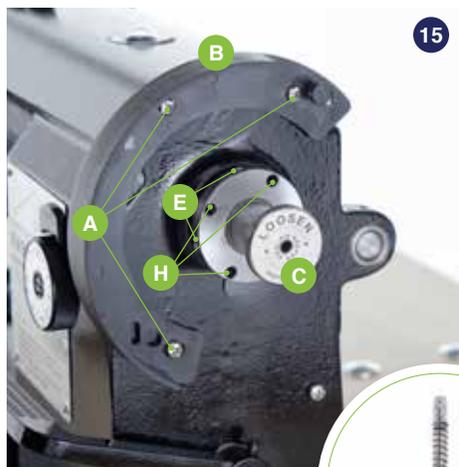
Note: Do not cut away the string on the bottom of the machine; it is an oil wick.



Check Motor Rotation

The machine's motor shaft should rotate counterclockwise when viewed from the motor shaft end. Plug in the motor, switch the power on and press down on the foot treadle to confirm operation now.

If motor rotation is not counterclockwise, please refer to "Changing Motor Rotation" in the Workhorse® Installation Instructions.



15

Securing the Stitch PRO Balance Wheel

Remove the three screws (A). Position the C-shaped belt guard (B) and reinstall the screws, making sure washers are positioned as shims behind the guard to keep it from being bent out of shape.

Unscrew the reverse-threaded Posi-Pin® nut (C). Slide the Stitch PRO Balance Wheel (D) onto the bushing, making sure it does not interfere with the belt guard. If the wheel hits the guard, reposition the washers placed under the C-shaped belt guard or move the bushing out further by loosening the set screws in the bushing flange (E).

Push the Posi-Pin® (16) through the hole in the balance wheel (F). While maintaining pressure on the Posi-Pin, rotate the balance wheel (G) until the Posi-Pin locks into one of the balance wheel bushing holes (H). Rotation of the balance wheel will now cause the machine to function.

To disengage the machine (for bobbin winding), pull the Posi-Pin out of the balance wheel. The balance wheel will now rotate without operating the machine. Push the Posi-Pin into the hole at the center of the Posi-Pin nut (I) to store.



16



17

Belt Adjustment for the Workhorse® Servo Motor

Before installing the drive belt (J), loosen the screw (K) to allow the Workhorse Servo Motor to freely pivot.

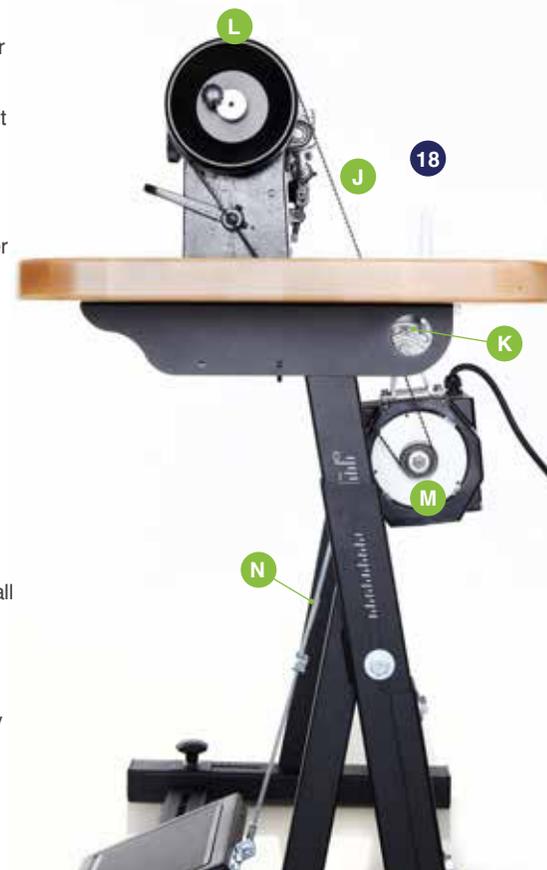
With the machine tilted back, slip the drive belt over the balance wheel track (L) and guide it onto the motor pulley (M) then carefully lower the machine.

Pivot the motor back to tighten the belt. Proper adjustment of the belt results in 3/8 inch of slack when pressed by finger at its center. Retighten set screw (K). The Linkage Bar (N) may need to be readjusted.

Once installed, the belt should not touch the table and should be centered on the track of both the balance wheel and motor pulley. Adjust the positioning of the motor left or right by loosening the bolts attaching the motor to the table.

Once the motor is in the correct position and all bolts are tightened, tilt the machine back and remove the belt so the pulley bracket can be installed.

Before Continuing: See "Installing the Pulley Cover" in the Workhorse instructions.



18

Attaching the Balance Wheel Belt Cover

Locate the remaining portion of the belt cover (19). It has a keyway (A) that locks onto post (B) of the C-shaped belt guard that was secured to the machine (20). Connect the covers and remove the remaining screw in the machine casting (C). Reinstall the screw through the slot (D) at the bottom of the belt cover (21). Position the screw in the slot to provide proper belt clearance above and below the balance wheel.



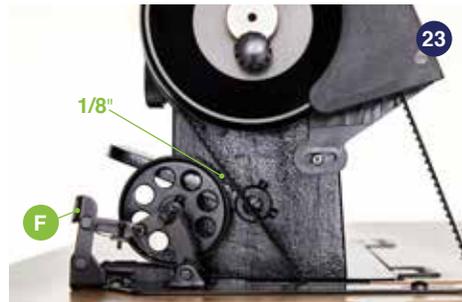
Attaching the Bobbin Winder

Position the bobbin winder so its slots (E) are over the pilot holes in the table. Tilt the machine head back and start to screw the bobbin winder down (22). Do not fully tighten the screws.

Tilt the machine back down into the table and position the bobbin winder so it's 1/8 inch forward of the belt when disengaged (23).

Once the proper location is found, fully tighten the bobbin winder down.

Note: Pressing the thumb pad (F) will engage the bobbin winder by moving the wheel into the belt.



Installing the Knee Lift Assembly

Assemble the knee lift (G) and attach it to the shaft sticking out from the oil tray (H). Adjust the knee lift to your desired location (24).



Mounting the Thread Stand

Assemble the thread stand as shown (25). Secure it to the tabletop with included hardware.



Attaching the Industrial Light

We find the best location for the light is at the front right corner of the table, but feel free to place it where you like (26). Plug it into the back of the motor.

Note: 220 volt motors do not have an outlet so a wall outlet must be used.



Removing the Fabric Sample

Cut the thread from the top of the machine and ensure the needle is all the way up. If it is not, raise the needle by grabbing the top of the balance wheel and rotating toward the front of the machine (A). **Never** rotate the other direction. Use your knee or hand to push the knee lift (B) to the right; this will lift the feet. Remove the fabric sample while holding the knee lift to the right. Cut the thread coming from below the machine.

Note: If you want to lock the feet in the up position, push the knee lift to the right and pivot lever (C) into the up position. Release the knee lift and the feet will stay up. Actuate knee lift and lower lever (C) to drop the feet.



Leveling the Table

If you find that your table is not level, use a wrench and loosen nut (D) then tighten or loosen the bolt (E) to level out the table. Once level, tighten the nut.



Auto Lubrication

Fill the oil tray with the oil found in the sewing machine box. Try to keep the oil level between the highest and lowest markings on the oil pan (29).

When it becomes necessary to change the oil, unscrew plug (F). Wipe the dirty oil and the dust from the oil drip pan, replace the plug and add fresh oil. Use any high-quality, clear sewing machine oil.

Please proceed to the Fabricator Guidebook.





Customer Service Questions or Concerns

To start a support case, go to [Sailrite.com/support](https://www.sailrite.com/support) and fill out the online form.
One of our support staff members will review your case and contact you.

[Sailrite.com](https://www.sailrite.com)

Equipping you to sew

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Version 6-20 Original manual in English

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Fabricator
Assembly Instructions

Qty: 1