

ENGLISH

**AC-172N-1790
SETUP MANUAL**

1. VERIFICATION OF THE LOCATION OF PRESET BOARD AND SUB CLAMP CATCH PLATE

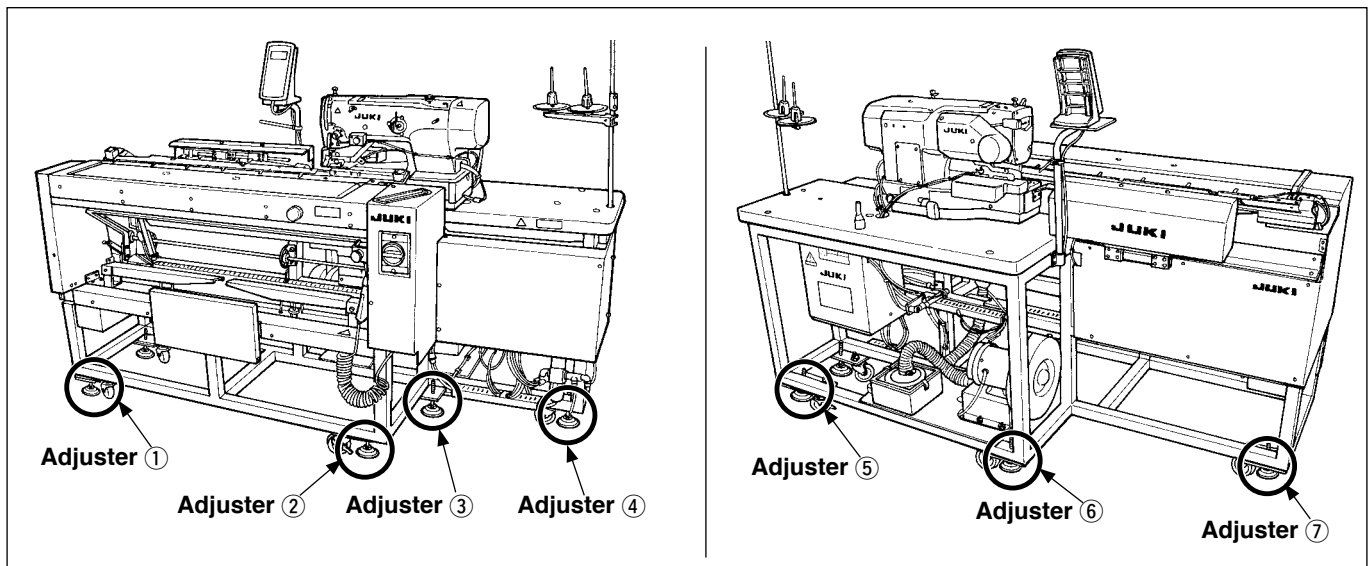
When you install the sewing machine in your plant, be sure to adjust the adjusters and check that the sewing machine is properly installed. Check the alignment between the preset board and the sub clamp catch plate following the steps of procedure described below.

1-1. Preparation of the power supply and the air supply

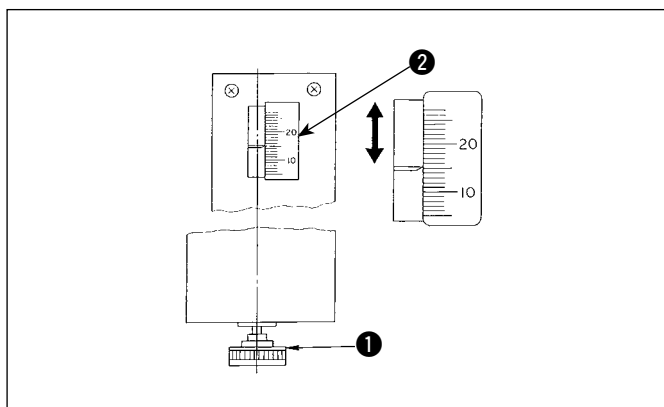
Refer to " I .3-2. Connecting the power supply" and " I .3-3. Installing the air hose" in the Instruction Manual.

1-2. Preparation of the adjusters

Turn the adjusters (① - ⑦) until they come in contact with the floor. After they have come in contact with the floor, turn the adjusters clockwise by one revolution to lift them.



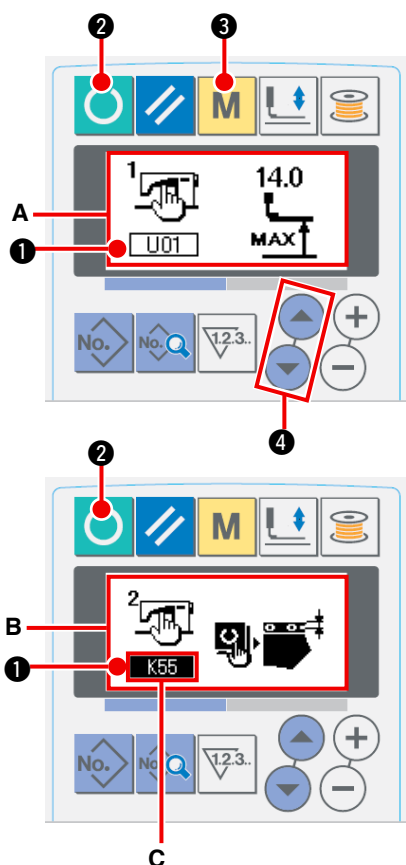
1-3. Preparation for the device



Check to be sure that the seam allowance is set to 21 mm. If not, adjust the seam allowance to 21 mm.

Insert preset adjusting knob ❶ which is supplied in the tool box into the hole, and turn the knob to set the seam allowance to the value indicated by scale (21mm) marker ❷. After the adjustment, return knob ❶ to the tool box to prevent it from being lost.

1-4. Preparation for the device



Turn the power ON.

❶ Set the mode to input mode.

When the back-light of LCD display ❶ shows the input mode in blue color, it is possible to change the memory switch data. When the back-light shows the sewing mode in green color, press READY key ❷ to change over to the input mode.

❷ Call memory switch data edit screen.

Press MODE key ❸, and memory switch data (level 1) edit screen A is displayed.

Further hold pressing the key for 3 seconds, and memory switch data (level 2) edit screen B is displayed.

❸ Select memory switch data to change.

Press ITEM SELECT key ❹ to select K55 (C).

❹ Activate the adjuster adjustment mode.

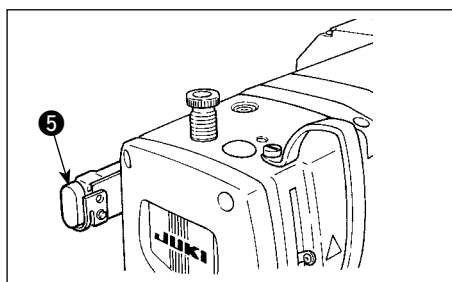
Press READY key ❷ to activate the adjustment mode.

Press STOP switch ❺ on the machine head, and the preset board travels forward and the cloth plate moves up.

Set up the adjustment gauge in place and adjust the adjuster.

After the completion of adjustment of the adjuster, remove the adjustment gauge. Press the switch on the machine head to return the cloth plate and the preset board to the home position.

Press the power switch to exit the adjuster adjustment mode.



Caution :Do not turn the power OFF when the preset board is traveling forward under the adjuster adjustment mode.

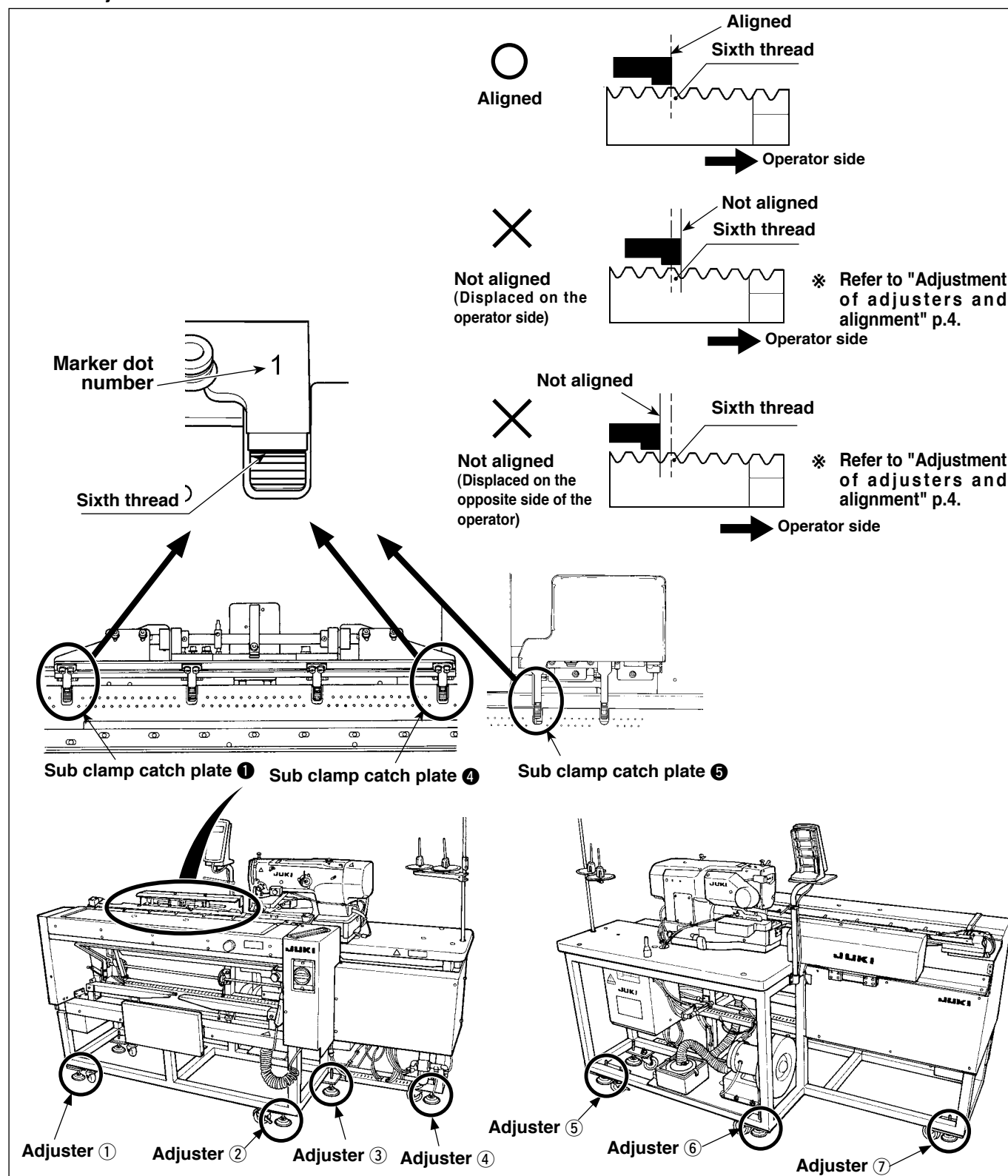
1-5. Verification of locations of the preset board and the sub clamp catch plate

Place the adjustment gauge, which has the same marker dot number with the sub-clamp catch plate number ①, ④ or ⑤, on the preset board. Check whether the 6th thread of the sub-clamp catch plate is aligned with the adjustment gauge. If not, adjust the location of the preset board and sub-clamp device taking the steps of procedure in " ■ Adjustment of adjusters and alignment" p.4.



Caution : Check the alignment between the gauge and the sub clamp locations observing from straight above the cloth plate and do not touch the devices.

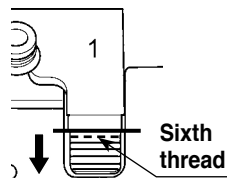
(Caution) Before the adjustment of position of the preset board and sub-clamp catch plates, check whether the 6th thread of the sub-clamp catch plates ①, ④ and ⑤ are displaced toward or away from the operator with respect to the gauge. If the sub-clamp catch plates are displaced in whole, it is necessary to adjust the seam allowance.



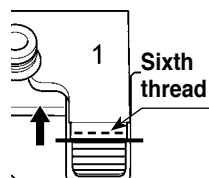
■ Adjustment of adjusters and alignment

Step 1

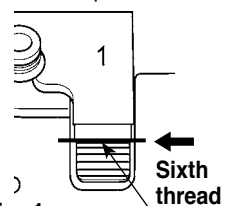
1A-1. In the case the 6th thread of sub-clamp catch plate ① is displaced toward the operator side with respect to the gauge.



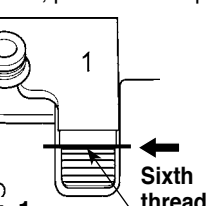
1B-1. In the case the 6th thread of sub-clamp catch plate ① is displaced away from the operator side with respect to the gauge.



1A-2. Lift adjuster ⑦, and adjust by turning it clockwise until the 6th thread of sub clamp catch plate is aligned with the gauge. Then, proceed to step 2.

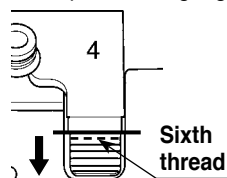


1B-2. Lift adjuster ①, and adjust by turning it clockwise until the 6th thread of sub clamp catch plate is aligned with the gauge. Then, proceed to step 2.

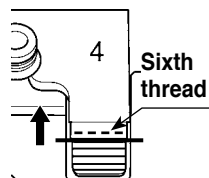


Step 2

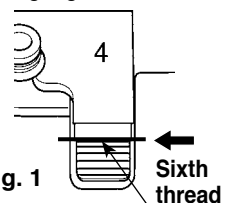
2A-1. In the case the 6th thread of sub-clamp catch plate ④ is displaced toward the operator side with respect to the gauge.



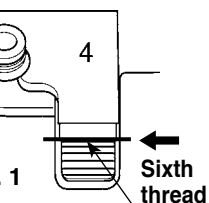
2B-1. In the case the 6th thread of sub-clamp catch plate ④ is displaced away from the operator side with respect to the gauge.



2A-2. Lift adjusters ③ and ④, and adjust by turning them clockwise until the 6th thread of sub clamp catch plate is aligned with the gauge.



2B-2. Lift adjuster ②, and adjust by turning it clockwise until the 6th thread of sub clamp catch plate is aligned with the gauge.



2-3.

Re-check: Are the 6th threads of sub clamp catch plates ① and ④ aligned with the gauge? (See Fig. 1.)

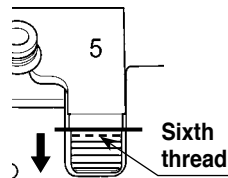
○ Aligned
A

× Not aligned

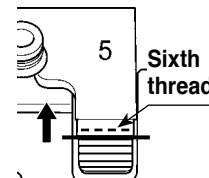
Carry out steps 1 and 2 again.

Step 3

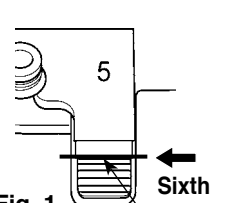
3A-1. In the case the 6th thread of sub-clamp catch plate ⑤ is displaced toward the operator side with respect to the gauge.



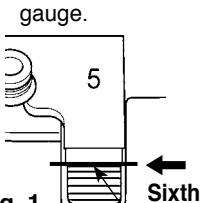
3B-1. In the case the 6th thread of sub-clamp catch plate ⑤ is displaced away from the operator side with respect to the gauge.



3A-2. Lower adjuster ⑤ by turning it counterclockwise to adjust so that they are aligned with the gauge.



3B-2. Lift adjuster ⑤, and adjust by turning it clockwise until the 6th thread of sub clamp catch plate is aligned with the gauge.



3-3.

Re-check: Are the 6th threads of sub clamp catch plates ①, ④ and ⑤ aligned with the gauge? (See Fig. 1.)

○ Aligned

Finish the adjustment.

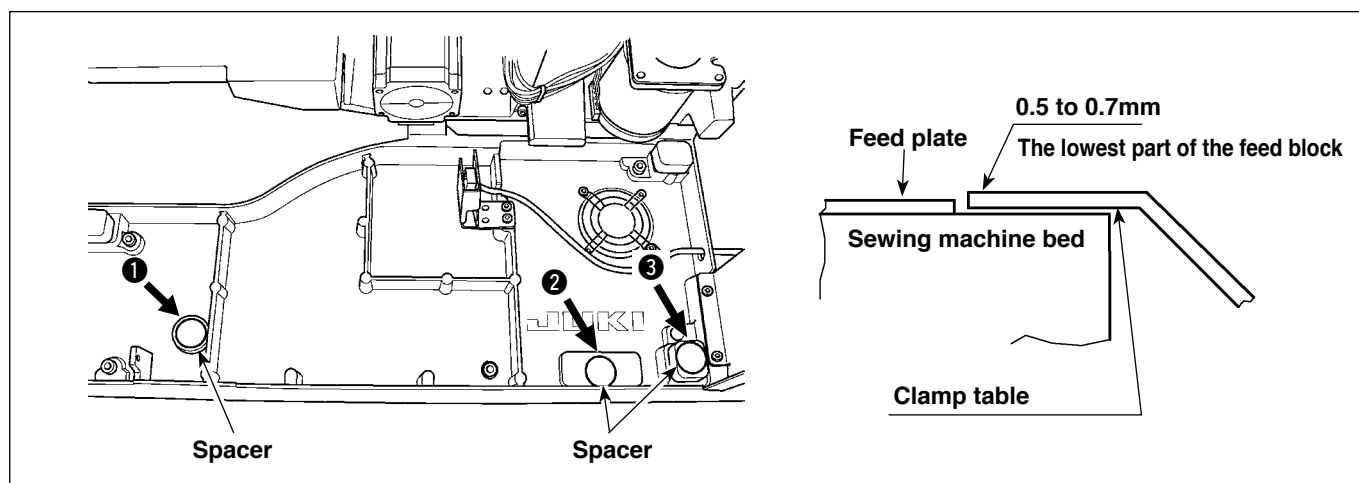
× Not aligned

Carry out steps 1 to 3 again.

Caution : Check to make sure that a clearance is provided with the sub-clamp catch plate and the preset board. After the completion of adjustment, be sure to remove the adjustment gauge.

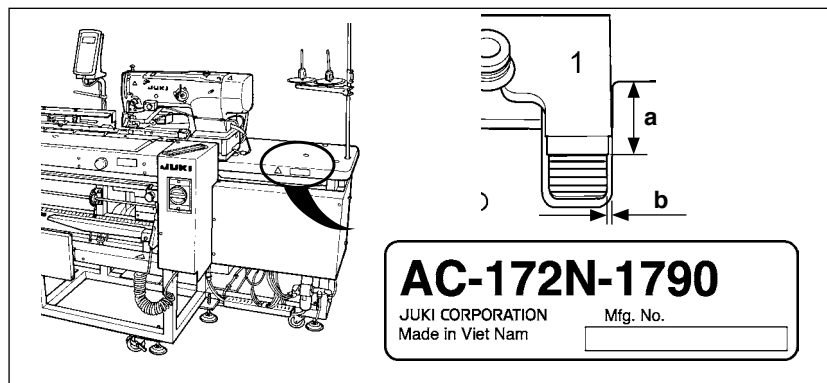


2. ADJUSTING THE MACHINE HEAD



If the machine head comes down from its normal position due to aged deterioration, the folded edge of the material and the seam (the edge) may not be properly aligned when placing the material position on the machine head. In the case the smallest clearance (the difference in height) between the machine head bed and the feed section is 0.7 mm or more, place spacers (0.5 mm and 1.0 mm) at locations ①, ② and ③ to decrease the clearance (the difference in height) to 0.7 mm or less

3. RECORDS OF ADJUSTED VALUES



When moving the device after you have installed it in your plant, ground the device referring to the dimensions given on the attached sheet

Mfg. No.		
	a	b
Sub clamp catch plate ①		
Sub clamp catch plate ④		
Sub clamp catch plate ⑤		