



Instruction Manual

Parts List

SUPER HIGH SPEED OVERLOCK MACHINE

AZ8003SD-70

AZ8020SD-70

This instruction manual only includes the different adjustment from AZ8000SD-8.

For properly using your AZ8003SD-70 or AZ8020SD-70, please read over this manual and the manual for AZ8000SD-8 together to fully understand their contents.

After reading the instruction manuals, please keep them in a location where they are easily accessible to the operator.




YAMATO SEWING MACHINE MFG. CO., LTD.

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*** ILLUSTRATED SPARE PARTS LIST ***

Attention

- ◇ This instruction manual is designed mainly for technicians, but it is advisable that also operators read the instructions with  mark to use the machine properly.
- ◇ The numbers in lower left corners of figures are figure numbers. We use them in texts as needed for your reference.

Attention

The parts used for this product are subject to change without notice. If such a change is made, any part of the contents and illustrations of this instruction manual may not conform to this product. In preparing the instruction manual, we have made our best efforts for making it free of any error or omission. If any error or omission should yet be found, it might not be rectified immediately.

1. Sewing speed and rotating direction of pulley

The maximum sewing speed is 8000 sti/min.

Run a new machine at 15 - 20% lower sewing speed of its maximum sewing speed during the first 200 hours (for about one month) so that the machine can offer a long service life in good condition.

The rotating direction of the motor pulley ① and the machine pulley ② is clockwise as shown in the figure.

⚠ CAUTION

If rotating in reverse direction, oil can not be supplied properly, and the machine can be damaged.

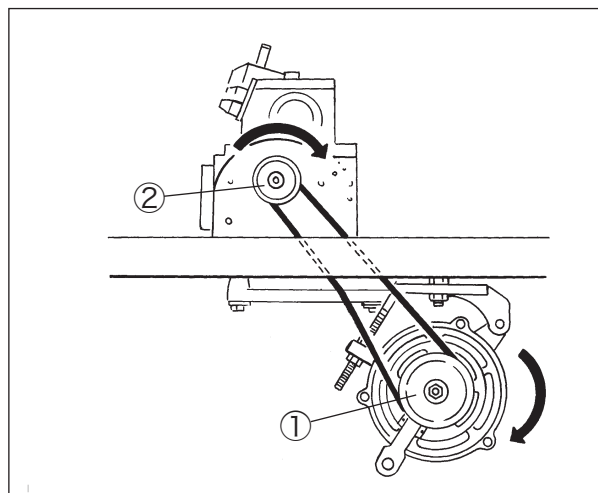


Fig. 1-1

2. Adjustment of sewing machine

⚠ CAUTION

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has stopped.

2.1 Height of needle

- (1) Loosen the screws ① to remove the logo plate ②.
- (2) Remove the screw ③.
- (3) Raise the needle bar at the highest point while rotating the machine pulley.
- (4) Loosen the screw ④ and adjust the needle bar while moving it up and down.

When the needle bar is at the highest point, make the height “N” from the top of the stitch plate to the needle tip in Table 1.

Model	Height of Needle “N” (mm)	Fig. No.
AZ8003SD-70 1-needle	9.6 - 9.9	2-2-1
AZ8020SD-70 2-needle	10.0 - 10.3	2-2-2

Table 1

! ATTENTION

1. Tighten the screw ④ with a tightening torque of 1.5 N·m.
2. Check the parallel setting of the needles for 2-needle machine.
3. Apply the liquid packing to the thread of the screw ③ when tightening it.

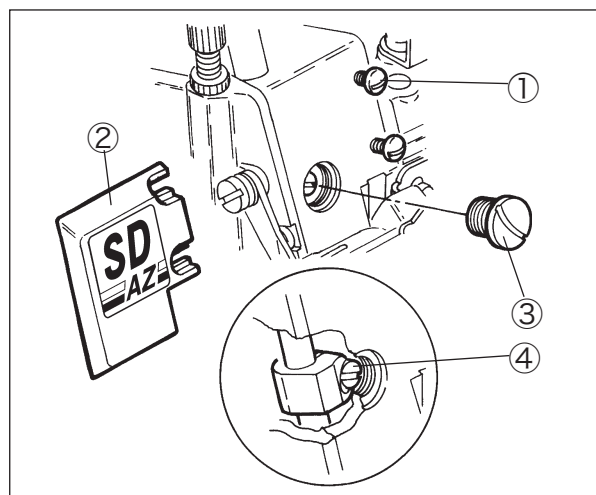


Fig. 2-1

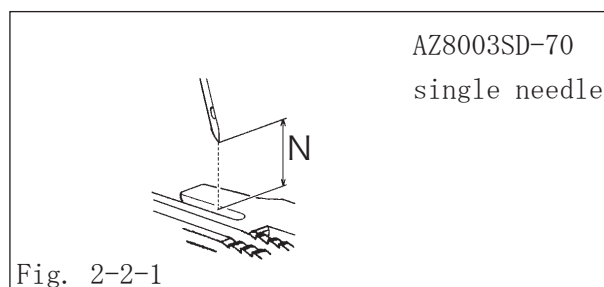


Fig. 2-2-1

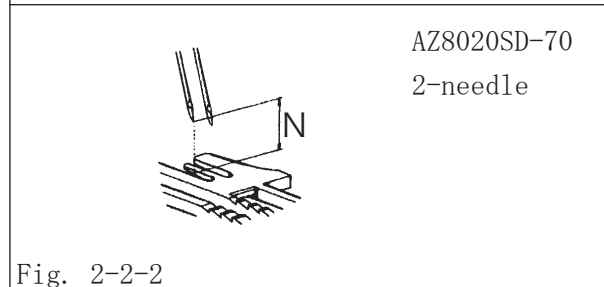


Fig. 2-2-2

⚠ CAUTION

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has stopped.

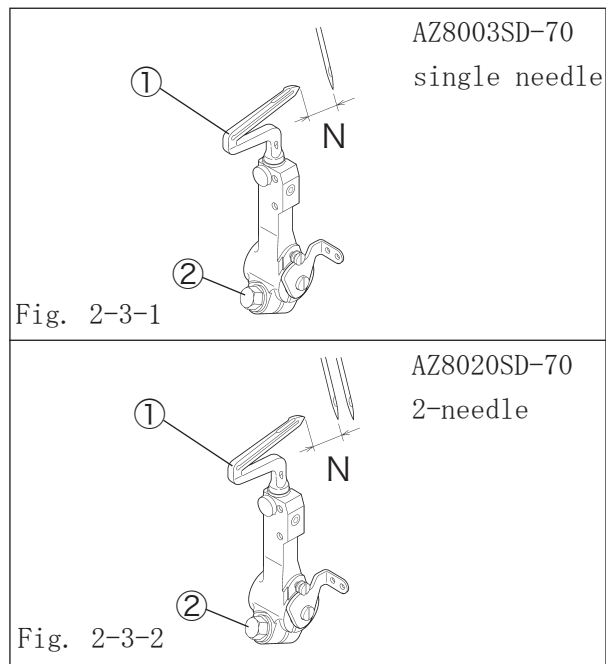
2.2 Distance between needle and lower looper

Rotate the machine pulley clockwise and move the lower looper ① to the extreme left. Make the distance between the lower looper tip and the center of the needle in Table 2.

Loosen the screw ② on the lower looper holder to adjust it.

Model	Distance between needle and lower looper “N” (mm)	Fig. No.
AZ8003SD-70 1-needle	3.5 - 4.0	2-3-1
AZ8020SD-70 2-needle	3.3 - 3.8	2-3-2

Table 2



3. Specifications

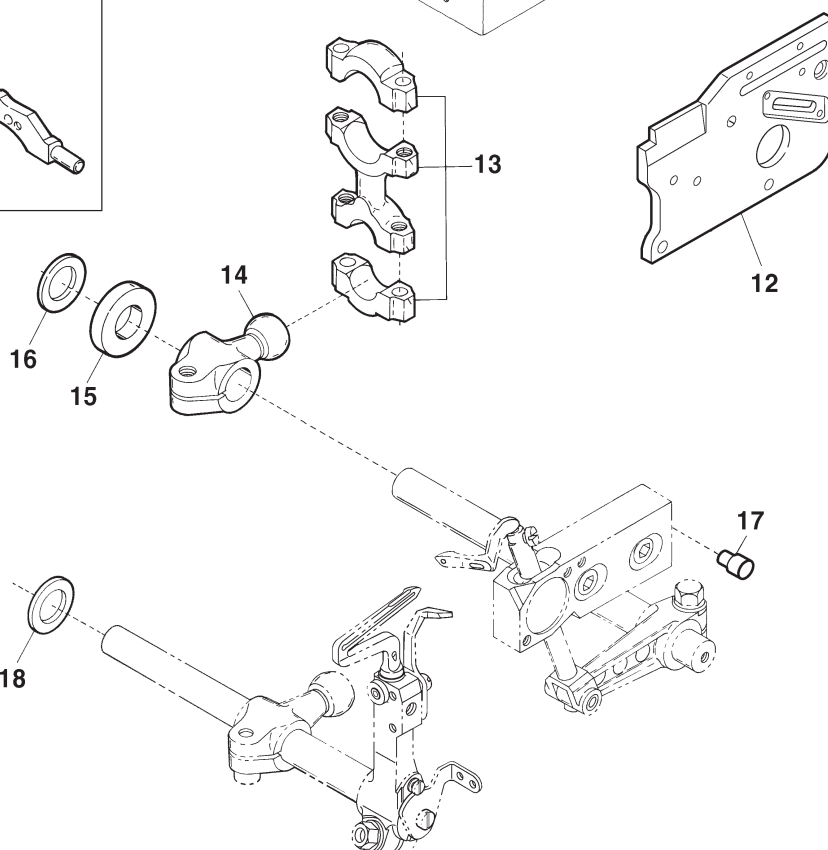
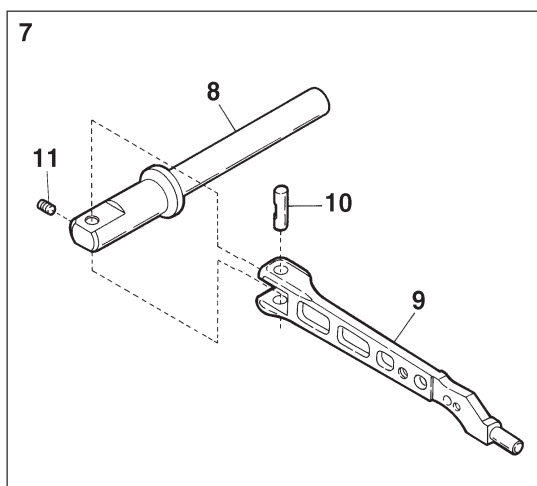
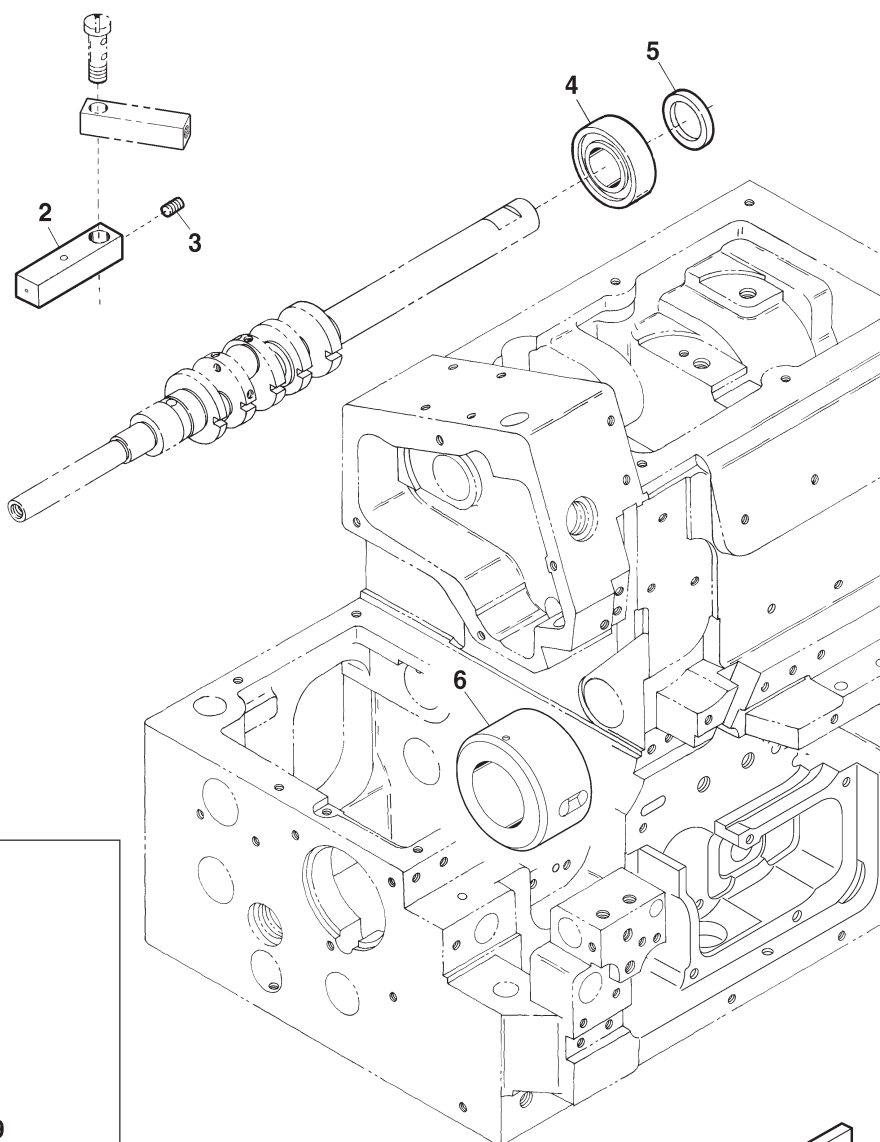
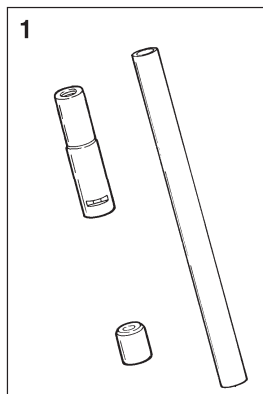
Model	AZ8003SD-70	AZ8020SD-70
Dimensions	380 (L) × 245 (W) × 310 (H) mm	
Weight	27.0 kg	
Construction	Dust-proof, Oil-tight and completely sealed	
Stitch Type	ISO: 504	ISO: 504, 514
Application	Overlock chain stitch for knitted or woven farics	
Sewing Speed	up to 8000sti/min	
Stitch length	1.0 – 4.0 mm Number of stitch per inch(24.5 mm) 6.5-25 stitches per 30mm 7.5-30 stitches	
Needle System	DC × 27 Size#8 ~ #14(60 ~ 90)	
Needle Stroke	23.7 mm	
Presser Foot Lift	5.0 mm	6.0mm
Feed Regulation	Push button system	
Differential Ratio	Max. Normal Differential (Gathering) 1:2.3 (Available up to 1:3 by adjusting the position of the lever pin.) Max. Reverse Differential (Stretching) 1:0.7 (Available up to 1:0.6 by adjusting the position of the lever pin.)	
Differential Feed Regulation	Adjustable by moving external lever during operation	
Knives for Fabric Cutting	Lower Knife : flat type, made of special steel Upper Knife : flat or angled type, made of super hard alloy	
Lubricating Oil	YAMATO SF OIL No.28	
Capacity of Oil Reservoir	900 ml	
Lubrication	Forcedly by trochoid shaped pump	
Installation	Semi-submerged type or fully-submerged type	
Compliance with Regulator	Comliant with the CE Marking and RoHS directive	
Noise declaration	Lp _A =85dB(8000 sti/min) according to ISO 10821-C6.2-ISO 11204 GR2	

ILLUSTRATED SPARE PARTS LIST

AZ8003SD-70, AZ8020SD-70

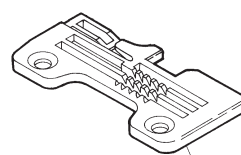
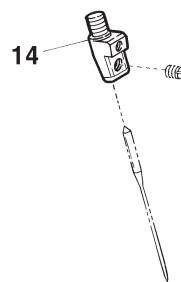
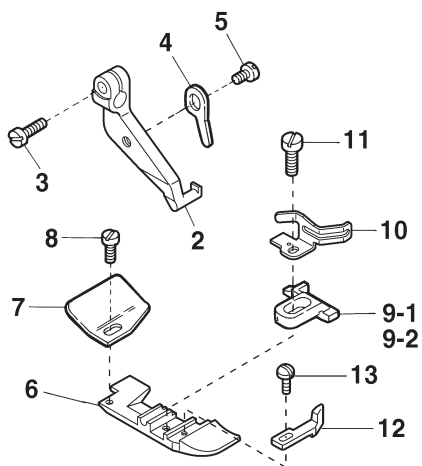
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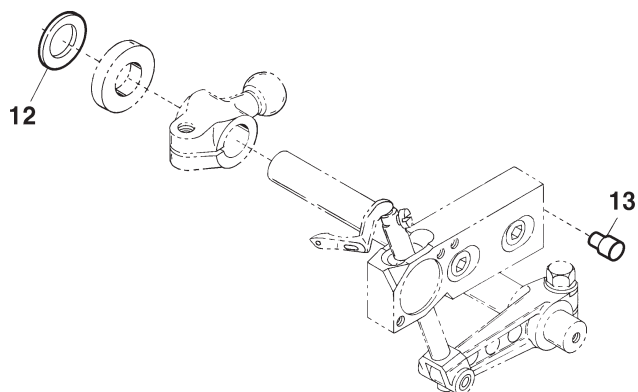
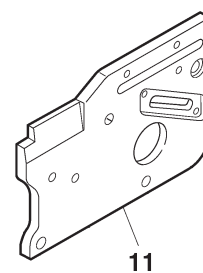
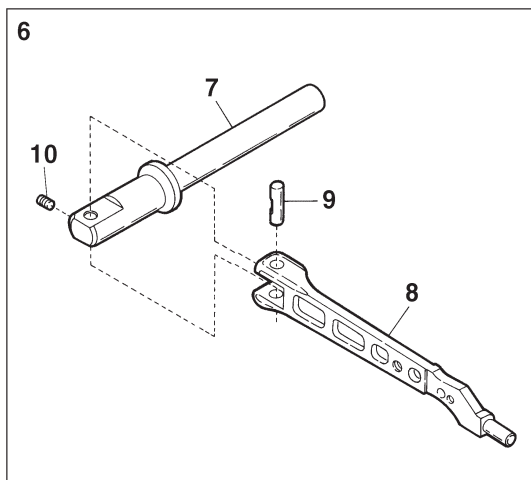
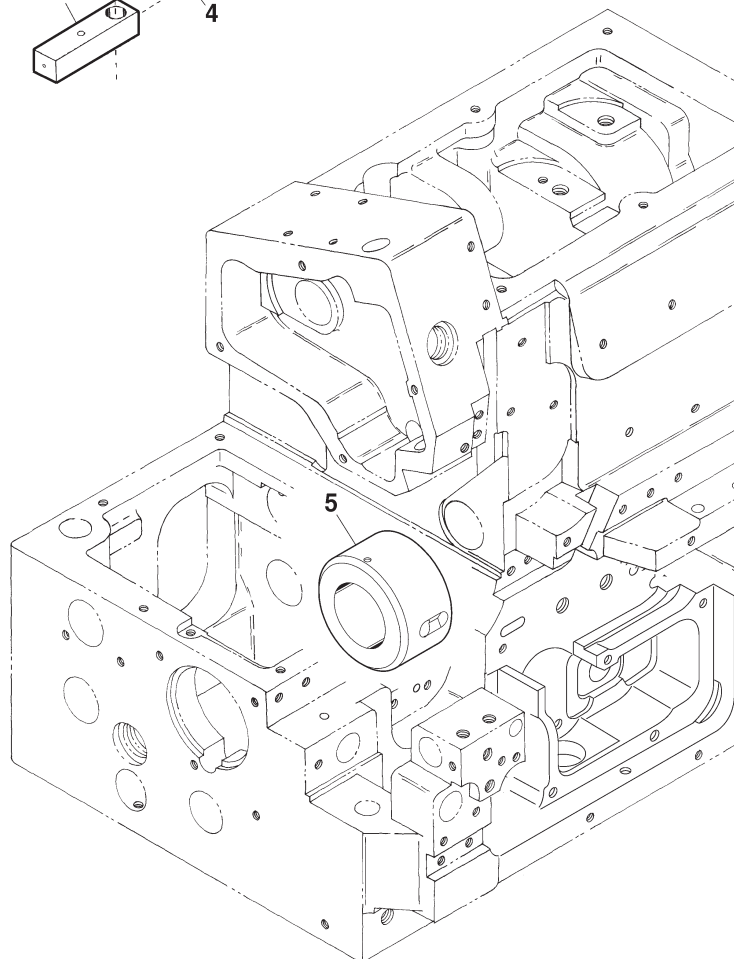
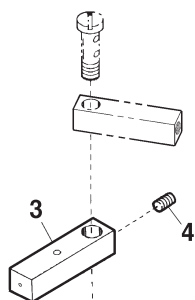
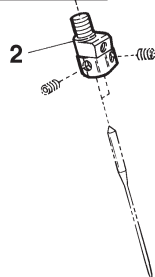
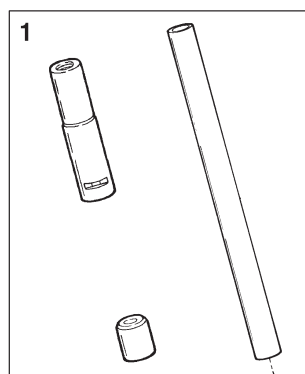


Ref.No	Parts No.	Description	品 名	Amt. Req
1	2150453	Needle Bar & Needle Bar Bushing, C. Set	針棒・針棒ブッシュ (組)	1
2	2152061	Oil Nozzle	給油ノズル	1
3	160000	Screw(M3-0.5×3)	止ネジ	1
4	2100120	Crankshaft Ball Bearing(Center)	ボールベアリング (中)	1
5	2150452	Bearing Spacer	ベアリングスペーサ	1
6	2150188	Crankshaft Bushing	小ブッシュ	1
7	2150140	Presser Arm, Complete Set	押エ腕 (組)	1
8	2100189	Presser Foot Shaft	押エ軸	1
9	2150141	Presser Arm	押エ腕	1
10	2100199	Presser Arm Hinge Pin	押エ腕ヒンジピン	1
11	160001	Screw(M4-0.7×4)	止ネジ	1
12	2150485	Looper Crank Cover	ループクランクカバー	1
13	2100215	Looper Driving Lever Connecting Rod	ループロッド	1
14	2150071	Upper Looper Driving Lever	上ループ軸腕	1
15	2160051	Driving Shaft Thrust Ring	スラストリング	1
16	2150075	Driving Shaft Thrust Ring	スラストリング	1
17	2150459	Standard Pin	基準ピン	1
18	2100218	Driving Shaft Thrast Ring	スラストリング	1
19	390608	Threading Chart	糸通シ図	1

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Ref.No	Parts No.	Description	品 名	Amt. Req
1-1	2157179	Presser Foot, C. Set(O3)	押エ (組)	1
1-2	2157228	Presser Foot, C. Set(O4)	押エ (組)	1
2	2157007	Presser Foot Hinge	押エヒンジ	1
3	110004	Screw(M3.5-0.6×8)	止ネジ	1
4	157040	Presser Foot Half-stay	半固定片	1
5	110050	Screw(M3.5-0.6×4.5)	止ネジ	1
6	2157023	Presser Foot (Lower)	押エ (下)	1
7	0034535	Thread Chain Guide	空環ガイド	1
8	004237	Screw(3/32-56×2.6)	止ネジ	1
9-1	2157189	Presser Foot Stitch Tongue(O3)	爪	1
9-2	2157229	Presser Foot Stitch Tongue(O4)	爪	1
10	2107032	Finger Guard	フィンガガード	1
11	110121	Screw(M3-0.5×5.5)	止ネジ	1
12	2157015	Presser Foot Chip	押エチップ	1
13	004236	Screw(3/32-56×4.2)	止ネジ	1
14	2159107	Needle Clamp	針止メ	1
15-1	2108002	Stitch Plate(O3)	針板	1
15-2	2158041	Stitch Plate(O4)	針板	1



Ref.No	Parts No.	Description	品 名	Amt. Req
1	2150465	Needle Bar & Needle Bar Bushing, C. Set	針棒・針棒ブッシュ (組)	1
2	2159108	Needle Clamp(Y)	針止メ	1
3	2152061	Oil Nozzle	給油ノズル	1
4	160000	Screw(M3-0.5×3)	止ネジ	1
5	2150188	Crankshaft Bushing	小ブッシュ	1
6	2150140	Presser Arm, Complete Set	押工腕 (組)	1
7	2100189	Presser Foot Shaft	押工軸	1
8	2150141	Presser Arm	押工腕	1
9	2100199	Presser Arm Hinge Pin	押工腕ヒンジピン	1
10	160001	Screw(M4-0.7×4)	止ネジ	1
11	2150485	Looper Crank Cover	ループクランクカバー	1
12	2150075	Driving Shaft Thrust Ring	スラストリング	1
13	2150430	Standard Pin	基準ピン	1



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