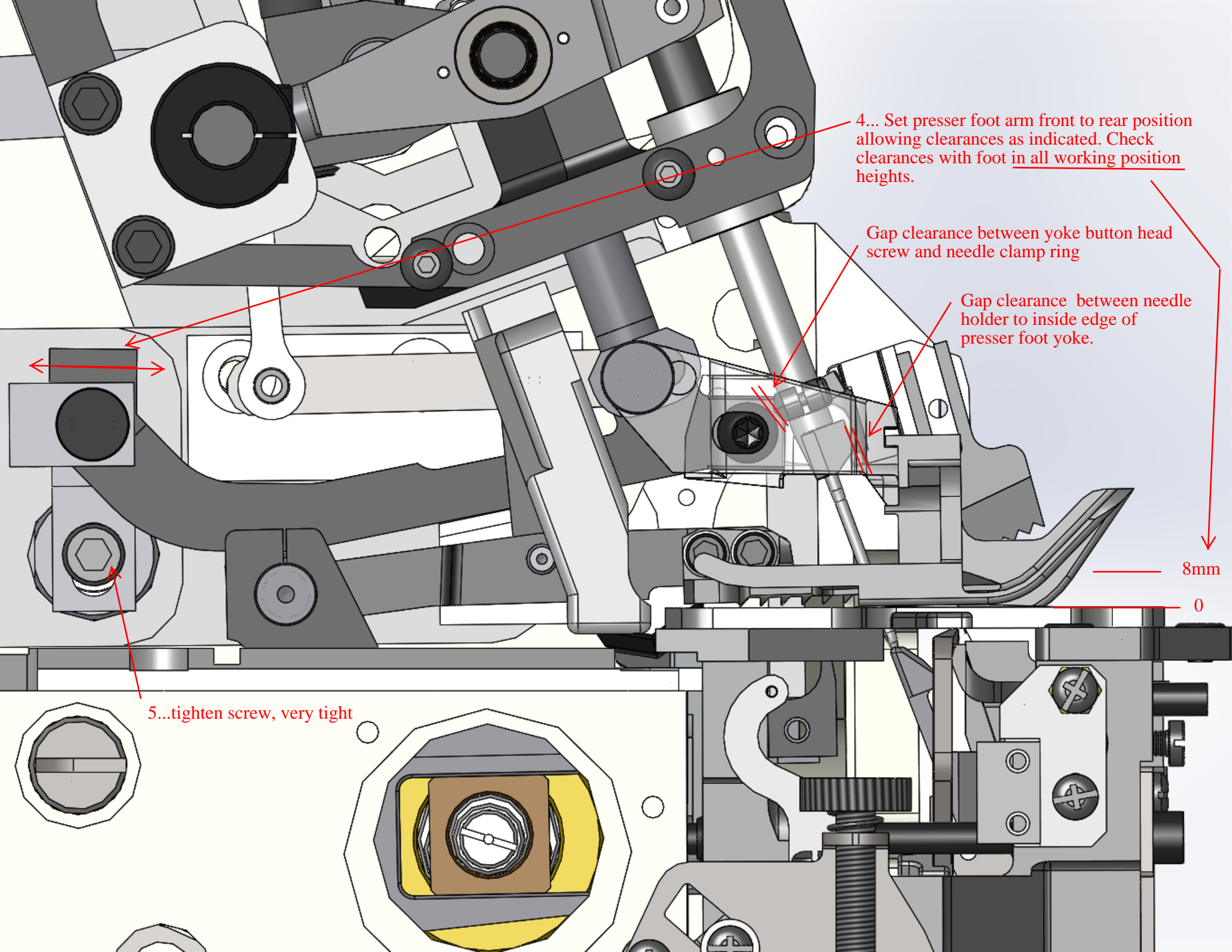


1... Disconnect main air supply

2...Rotate hand-wheel until the presser foot is in lowest position to needle plate

3mm

3... Loosen screw
Set a 3mm gap between the casting and presser foot arm pivot as shown. This will set the bottom of the presser foot parallel to the needle plate in its lowest position. Lightly tighten (#3) screw...go to next page.



4... Set presser foot arm front to rear position allowing clearances as indicated. Check clearances with foot in all working position heights.

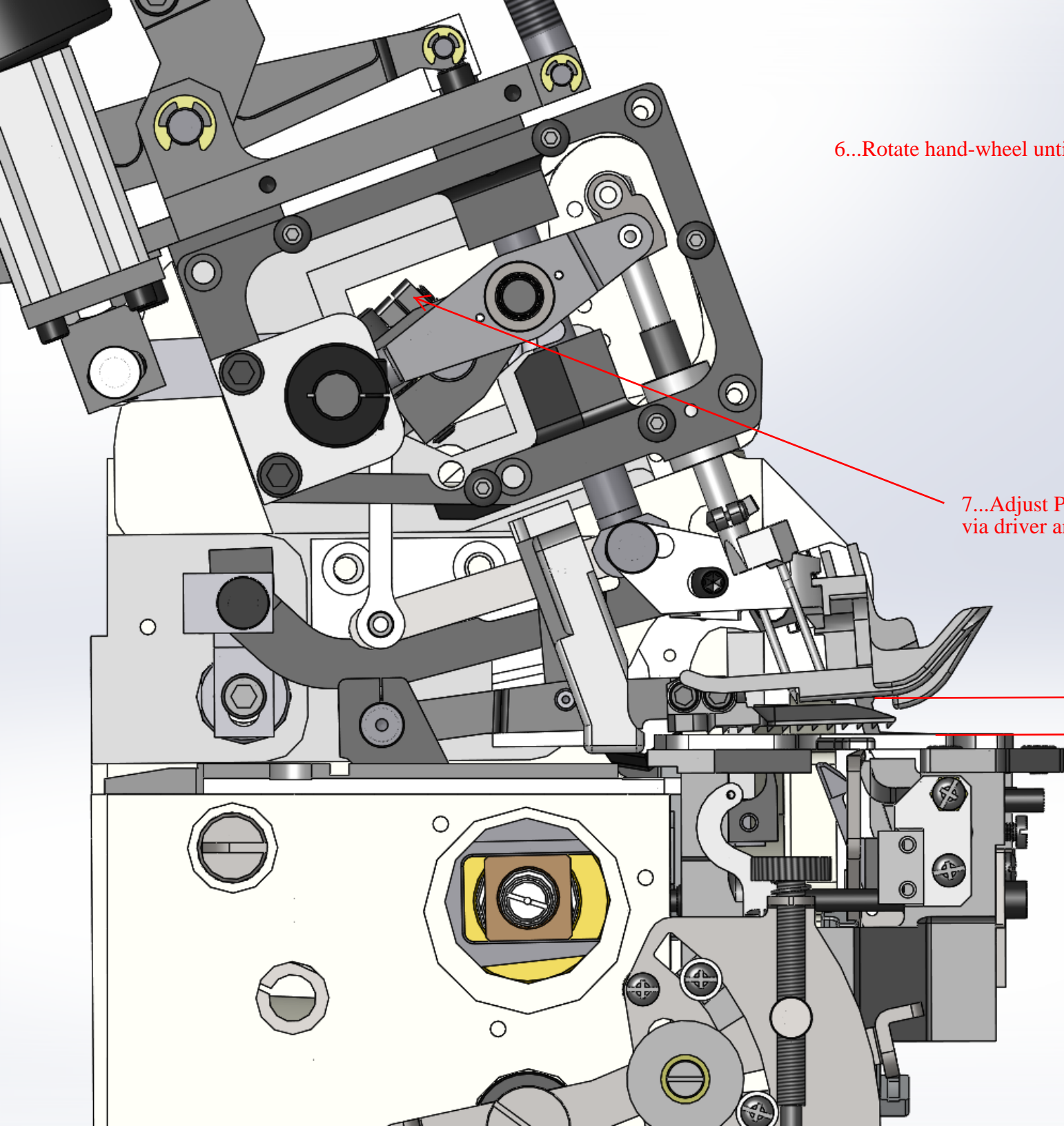
Gap clearance between yoke button head screw and needle clamp ring

Gap clearance between needle holder to inside edge of presser foot yoke.

8mm

0

5...tighten screw, very tight

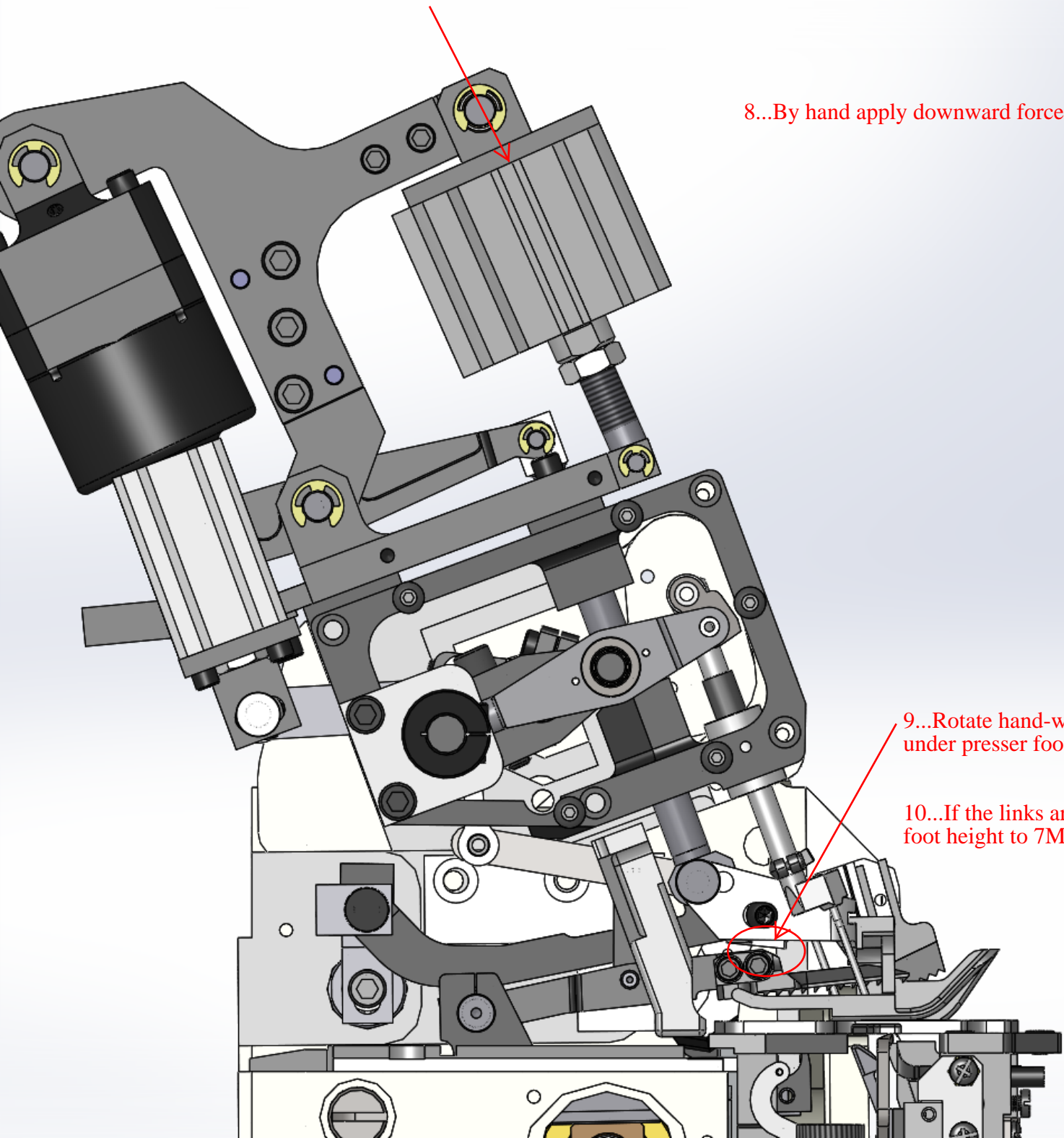


6...Rotate hand-wheel until presser foot lifts to highest position.

7...Adjust Presser Foot walking foot height to 8MM via driver arm.

8MM

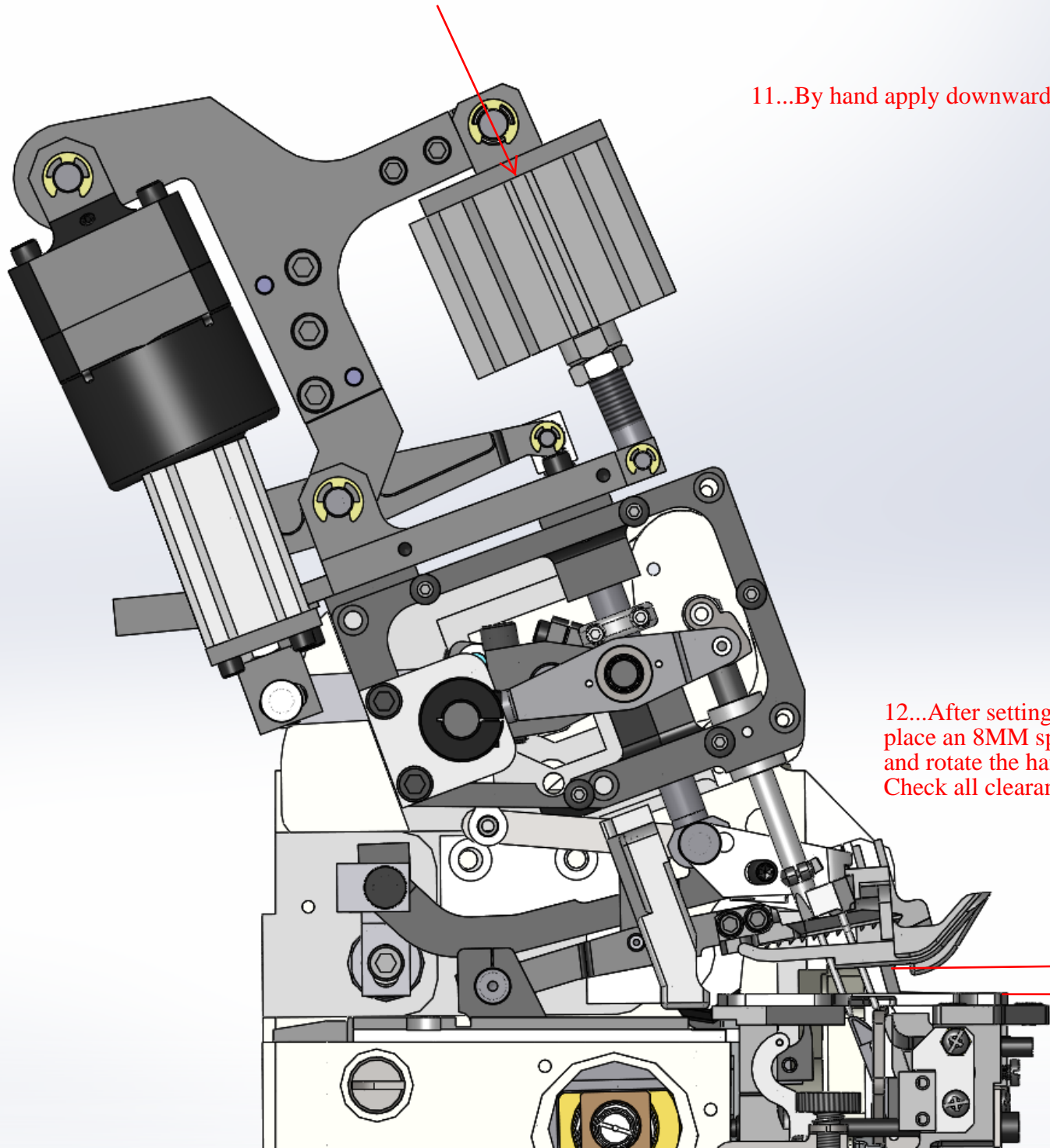
0



8...By hand apply downward force

9...Rotate hand-wheel and check for top feed clearance under presser foot yoke.

10...If the links are touching go back and lower the walking foot height to 7MM



11...By hand apply downward force

12...After setting a complementary walking foot height place an 8MM spacer (allen wrench) under the presser foot and rotate the hand-wheel to assure all linkages move freely. Check all clearance gaps noted while rotating @ 8MM height.

8MM

13...By hand apply downward force.

14...Rotate hand-wheel until the presser foot is in lowest position to needle plate.

15...Loosen jam nut and turn air cylinder shaft CCW until a small gaps appears between pressure block and shaft button.

16...Maintaining downward force turn air cylinder shaft CW until a "0" gap is made then 2 more full turns CW ...

The 2 added turns from "0" gap sets the spring system pre-load and prevents the spring from compressing to solid.

