

# W200 Series

# WT200 Series

## Seminar on

### W200 Series

Small diameter cylinder bed, interlock stitch machine with top cover thread

### WT200 Series

Variable top feed, small diameter cylinder bed, interlock stitch machine with top cover thread



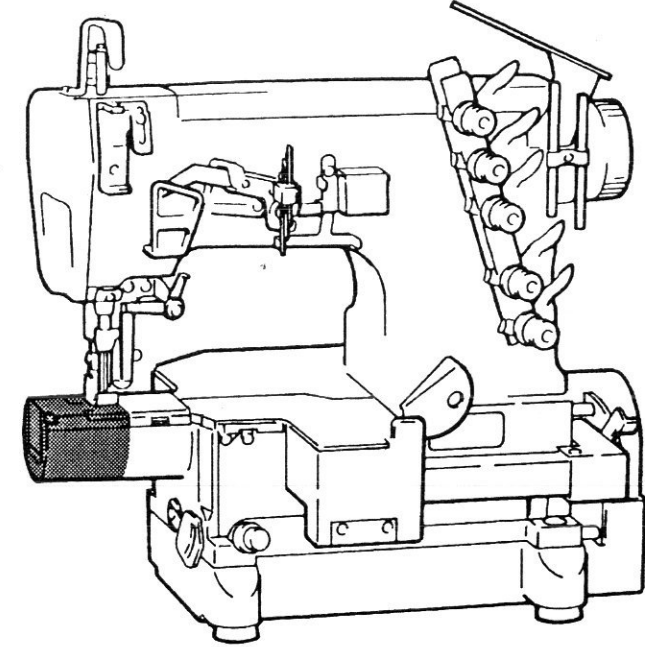
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## ■ W(T)200 Features

Features the smaller diameter cylinder bed which is packed with precision mechanism as well as the variable top feed with top cover thread. Pegasus has achieved these good results based on our experience as a leading manufacturer of industrial sewing machines. This is the new W200/WT200 Series with user-friendly design for ease of operation, and including the high quality functions of conventional machines.

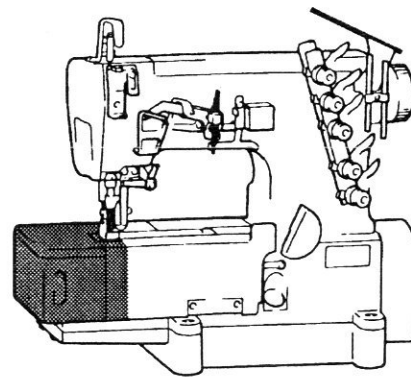
### Sales points

- Circumference of the cylinder bed: 177mm
- Independently driven top feed with top cover thread (WT200 Series)
- Equipped with the feeding mechanism available for intermittent differential feed ratio adjustment and condensed stitching

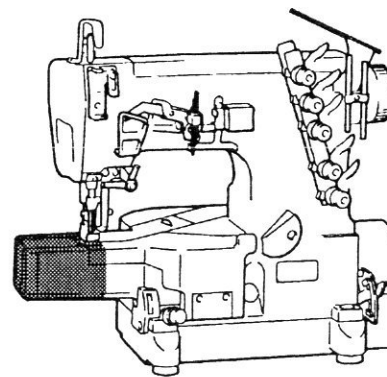


W200 Series: Small diameter cylinder bed

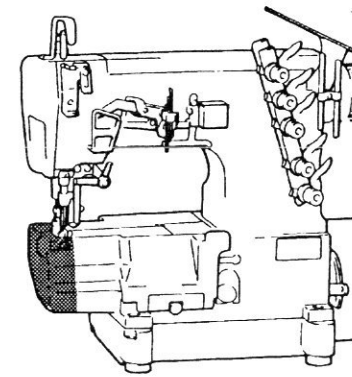
### Various types of beds of interlock stitch machines



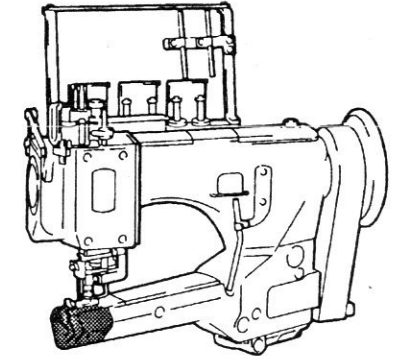
W500 Series: Flatbed



W600 Series: Cylinder bed



W700 Series: Short bed



FW Series: Feed-up-the-arm cylinder bed

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## ■ W(T)200 Features

### Subclasses

<b>W264-01</b>	Small diameter cylinder bed, interlock stitch machine with top cover thread for plain seaming
<b>W264-03F</b>	Small diameter cylinder bed, interlock stitch machine with top cover thread for covering (flattening out overlock seams)
<b>W264-03G</b>	Small diameter cylinder bed, interlock stitch machine with top cover thread for covering (folding over overlock seams)
<b>W264-08</b>	Small diameter cylinder bed, interlock stitch machine with top cover thread for hemming
<b>WT264-01</b>	Variable top feed, small diameter cylinder bed, interlock stitch machine with top cover thread for plain seaming
<b>WT264-03F</b>	Variable top feed, small diameter cylinder bed, interlock stitch machine with top cover thread for covering (flattening out overlock seams)
<b>WT264-03G</b>	Variable top feed, small diameter cylinder bed, interlock stitch machine with top cover thread for covering (folding over overlock seams)
<b>WT264-08</b>	Variable top feed, small diameter cylinder bed, interlock stitch machine with top cover thread for hemming

※ For the details, see the subclass table.

### Maximum speed

<b>W200 Series</b> 5,000 s.p.m.	(Differential feed ratio = More than 1:1.4 → Maximum speed = Less than 4,500 s.p.m.)
<b>WT200 Series</b> 5,000 s.p.m.	(Front-to-back movement amount of the top feed dog = 4.0mm to 6.0mm Up-and-down movement amount of the top feed dog = 4.0mm to 5.0mm Differential feed ratio = More than 1:1.4 → Maximum speed = Less than 4,500 s.p.m.)

### Specifications of the cylinder bed

Circumference = 177mm  
Distance from the needle drop hole to the right end of the cylinder bed = 65mm  
Distance from the needle drop hole to the left end of the cylinder bed = 37mm

### Feed method

- Stitch length adjustment : Micro-adjusting dial (with condensed stitch capability)  
Movement amount of the main feed dog = 0.9~4.2mm  
Feed dog pitch = 1.6mm  
If a stitch length is more than 3.2mm, the differential feed ratio should not be more than 1:1.4.
- Differential feed ratio adjustment : Lever (available for an intermittent adjustment)  
[Differential feed ratio]  
Movement amount of the main feed dog = More than 3.2mm ··· 1:0.8~1:1.4  
Movement amount of the main feed dog = 0.9~3.2mm ····· 1:0.8~1:1.8  
※ Factory-set differential feed ratio = 1:1.4  
※ Max. movement amount of the differential feed dog = 5.8mm  
If a differential feed ratio is 1:1.4, the stitch length should not be more than 3.2mm.
- Front-to-back movement amount of the top feed dog (WT200 Series) = 1.0~6.0mm
- Up-and-down movement amount of the top feed dog (WT200 Series) = 2.8~5.0mm

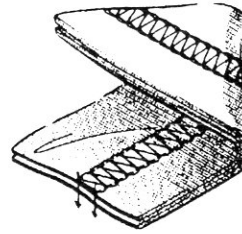
### Labor saving devices

UT, PL, MS

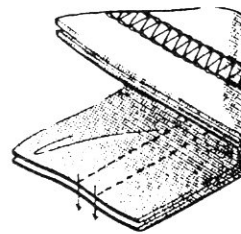
## ■ W(T)200 Features

### Stitch types

- 01  
2-needle  
plain seaming

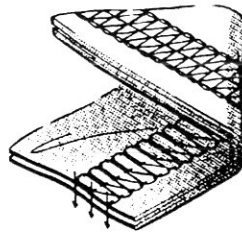


Stitch type 602

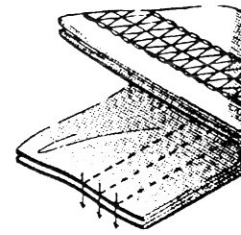


Stitch type 406

- 01  
3-needle  
plain seaming

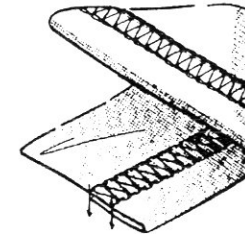


Stitch type 605

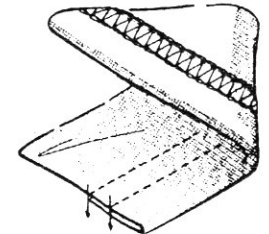


Stitch type 407

- 08  
2-needle  
hemming

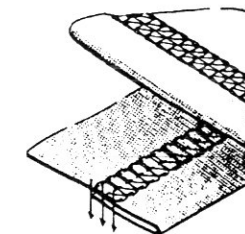


Stitch type 602

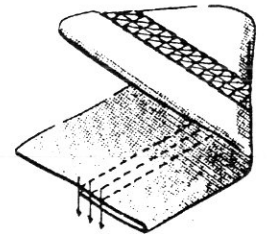


Stitch type 406

- 08  
3-needle  
hemming

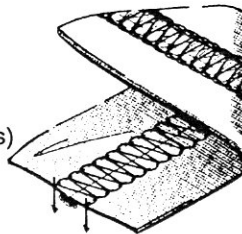


Stitch type 605

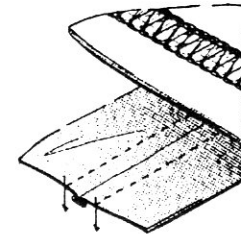


Stitch type 407

- 03F  
2-needle  
covering  
(flattening out  
overlock seams)

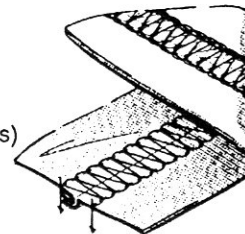


Stitch type 602

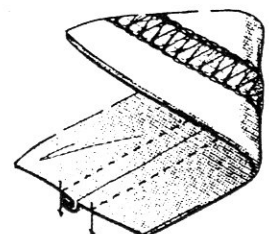


Stitch type 406

- 03G  
2-needle  
covering  
(folding over  
overlock seams)

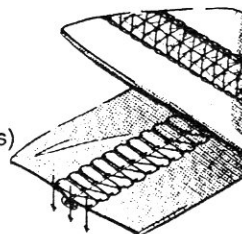


Stitch type 602

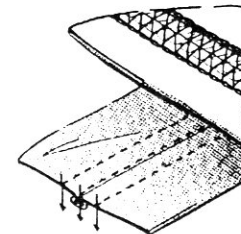


Stitch type 406

- 03F  
3-needle  
covering  
(flattening out  
overlock seams)

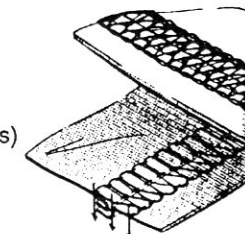


Stitch type 605

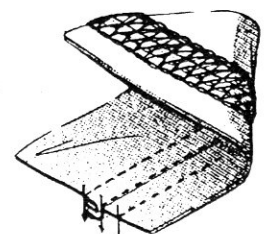


Stitch type 407

- 03G  
3-needle  
covering  
(folding over  
overlock seams)



Stitch type 605



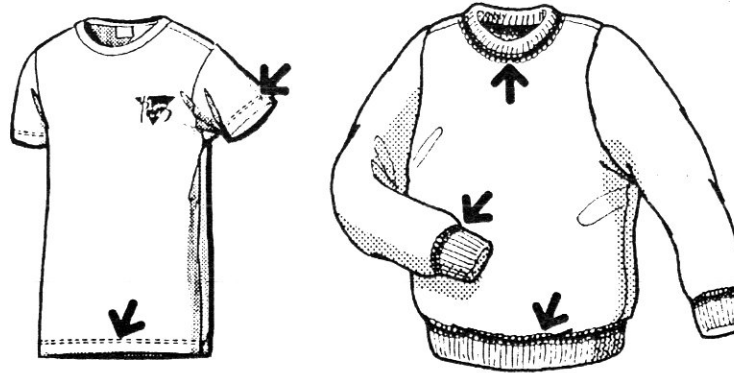
Stitch type 407

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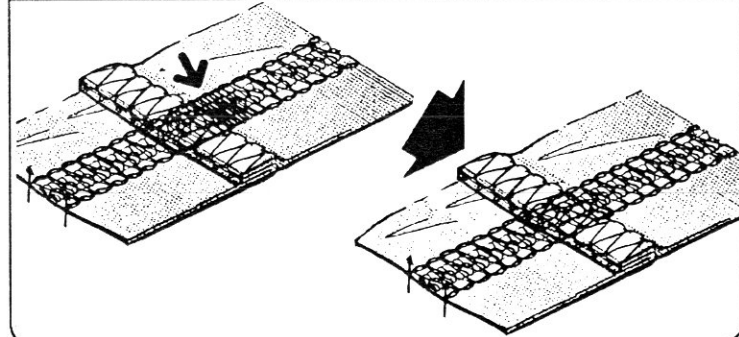


## ■ WT200 Features

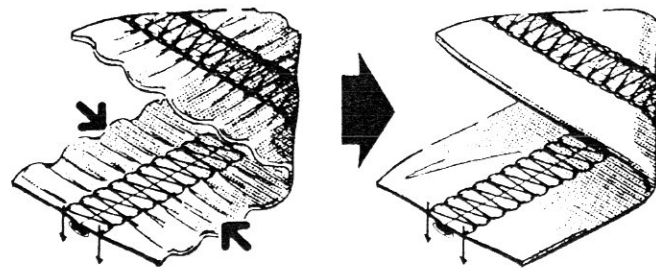
Feed efficiency by the variable top feed mechanism



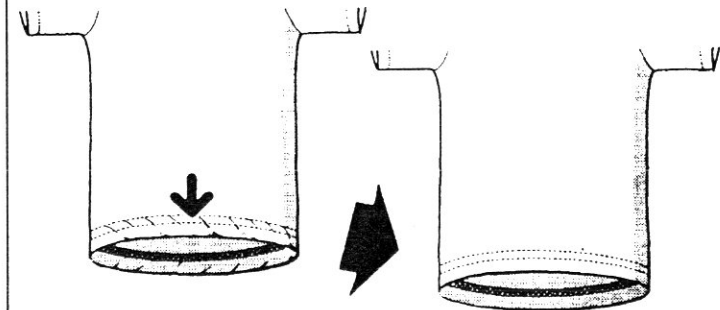
**1** This mechanism prevents the seam from jamming on cross seam sections and eliminates skip stitching.



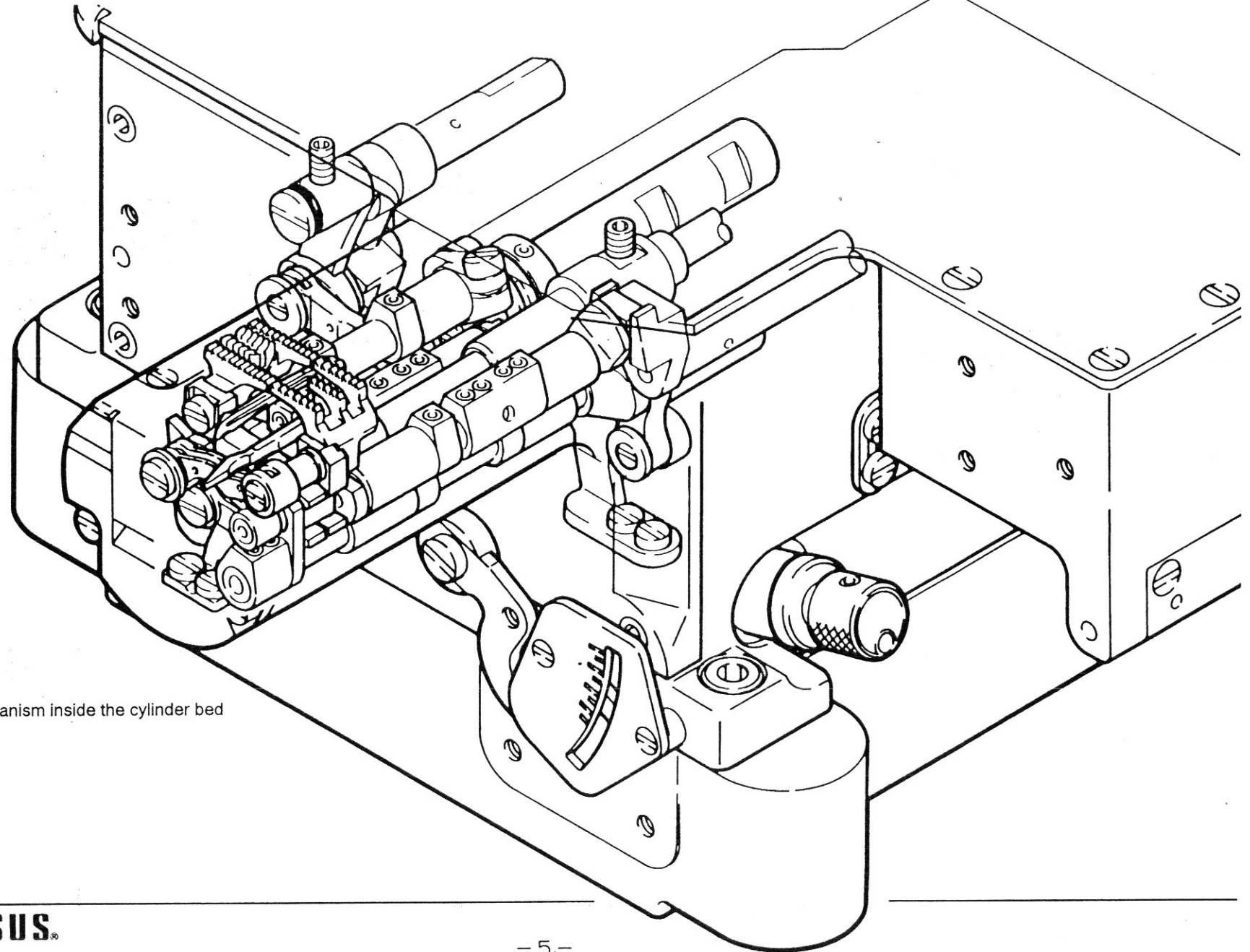
**2** Even covering is performed.



**3** No distortion occurs in a bottom hemming operation.



## ■ W200 Mechanism

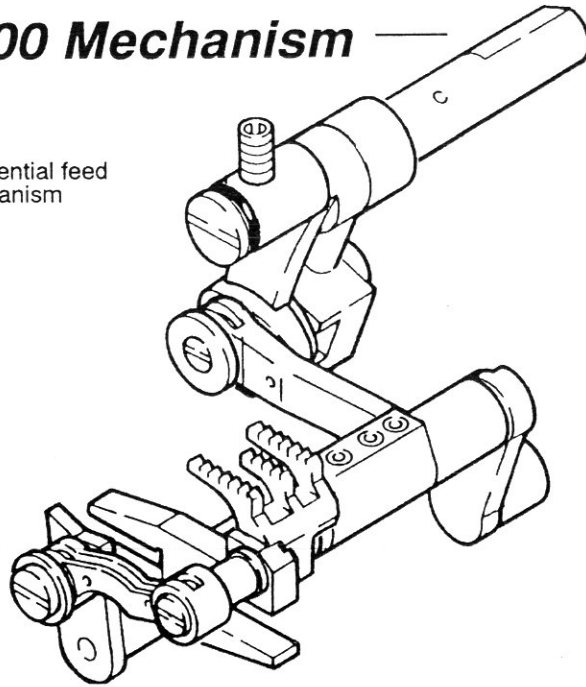


■ Mechanism inside the cylinder bed

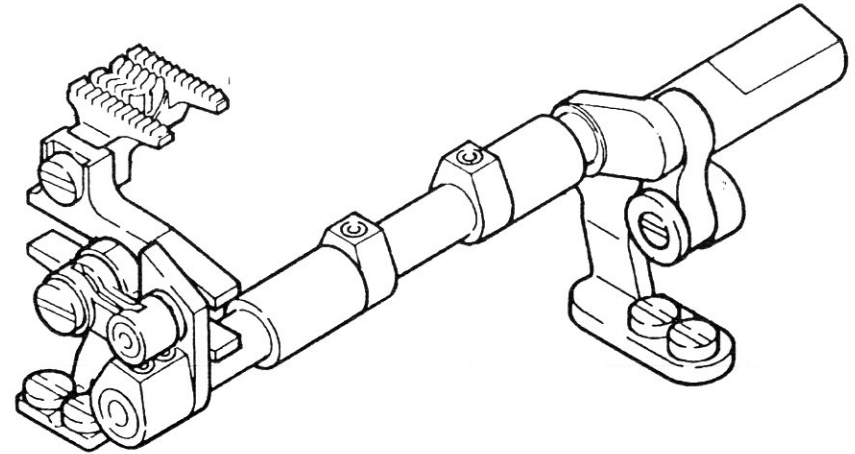
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## ■ W200 Mechanism

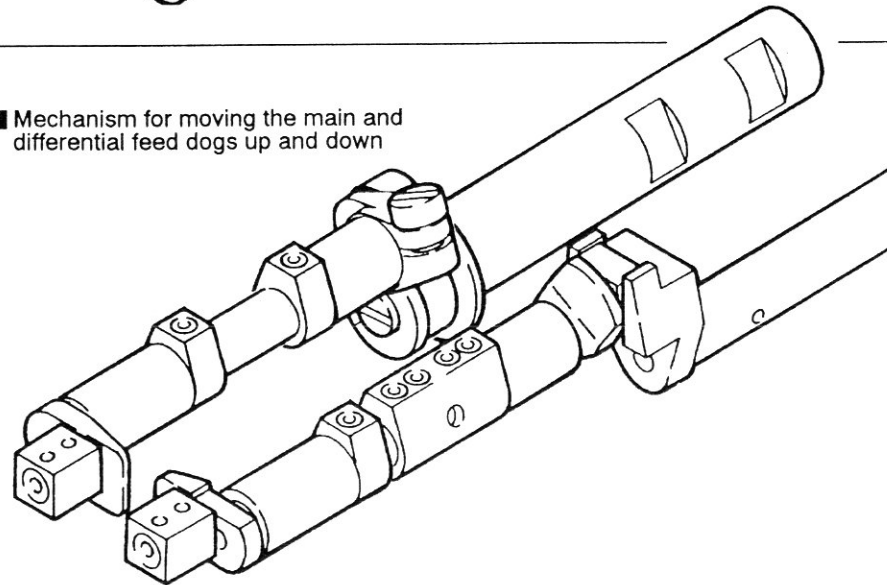
■ Differential feed mechanism



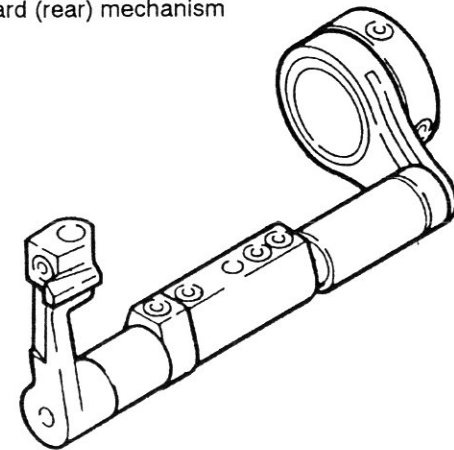
■ Main feed mechanism



■ Mechanism for moving the main and differential feed dogs up and down

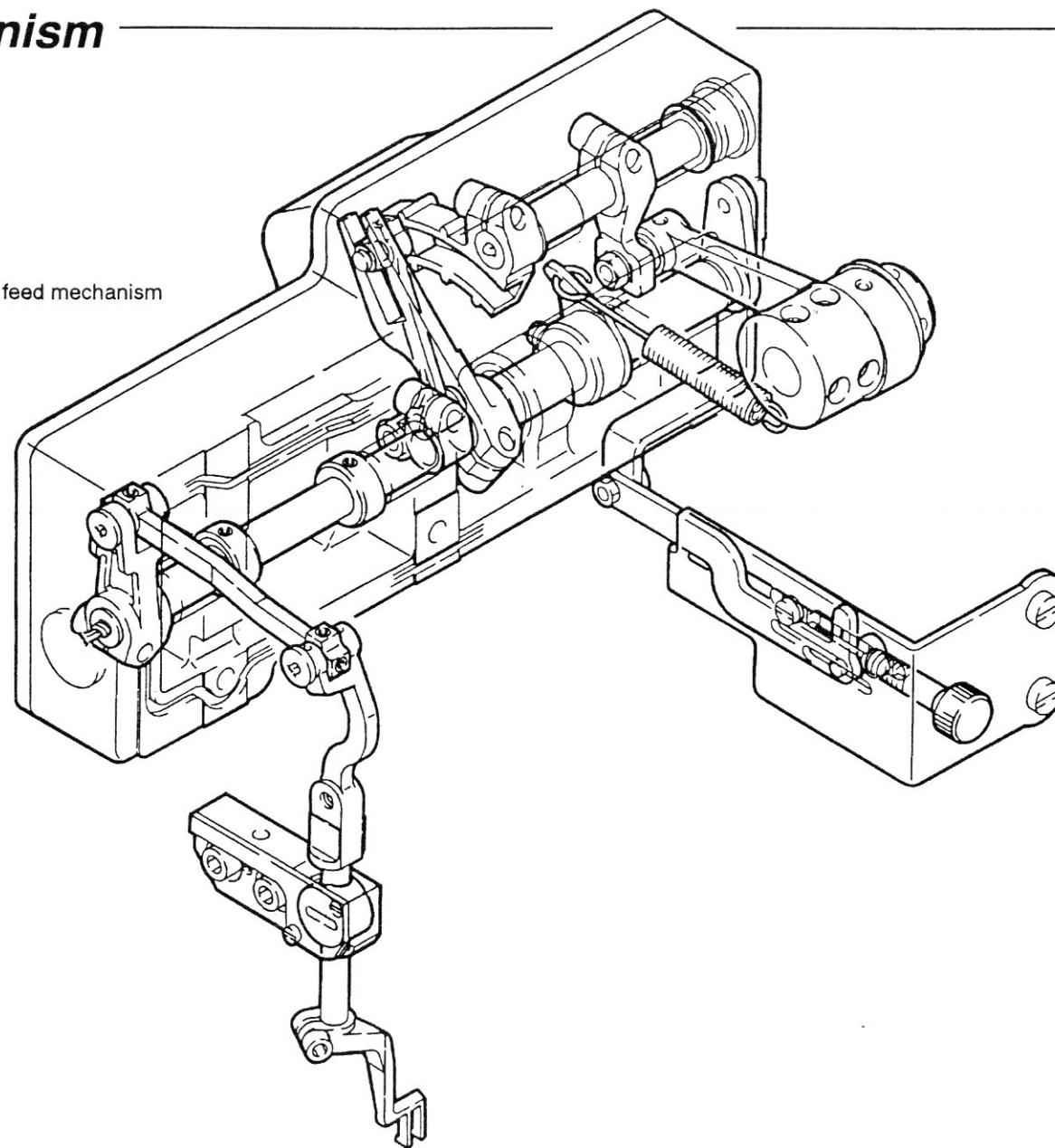


■ Needle guard (rear) mechanism



## ■ WT200 Mechanism

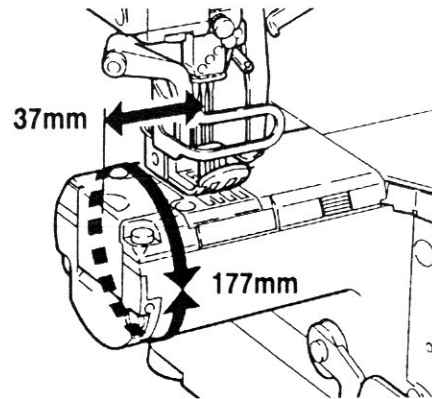
■ Top feed mechanism



## ■ W(T)200 Features of each part

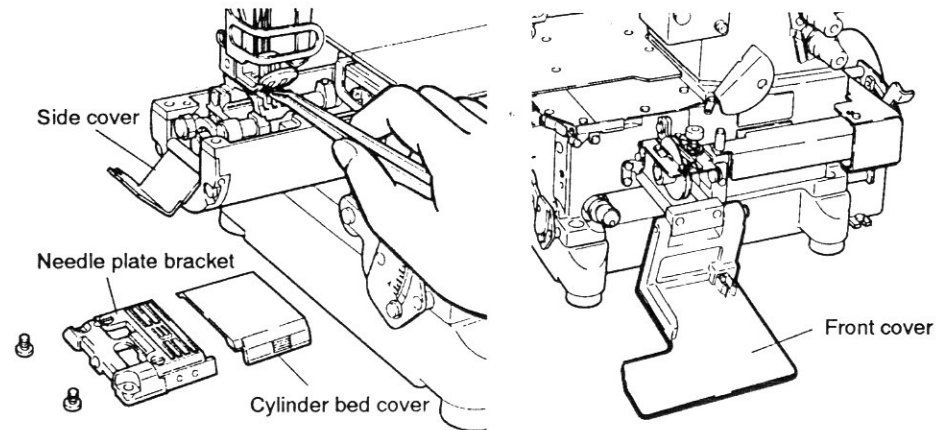
### The slim cylinder bed increases efficiency.

Since the circumference of the cylinder bed has decreased to 177mm, you can easily sew arm holes and neck openings of children's wear or small tubular goods which have previously been difficult. In addition, handling the fabric is effortless because of the shortened distance (37mm) from the cylinder bed end to the needle drop hole.



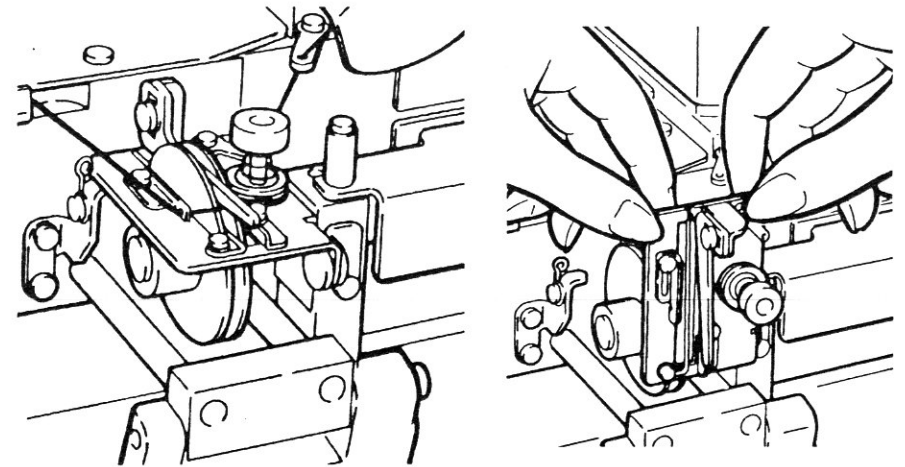
### User-friendly design into details

The front cover, side cover and cylinder bed cover open widely. Adjusting and cleaning each component are very easy.



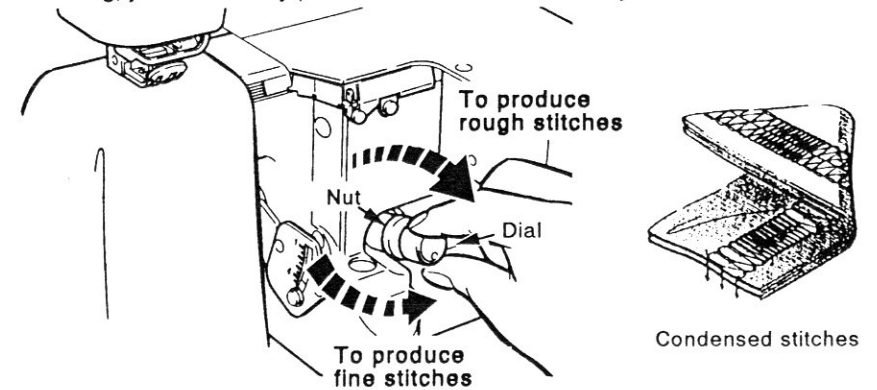
### Threading a looper thread is easy.

The looper thread take-up is located outside of the bed. In addition, the looper thread take-up guide holder can be easily raised by a finger, so threading the looper thread is easy.



### Stitch length adjustment by the dial (with condensed stitch capability)

To make a stitch length adjustment, all you have to do is loosen the nut and turn the dial. Thanks to the interlocking between the main feed dog and the differential feed dog, you can readily produce condensed stitches by the lever.



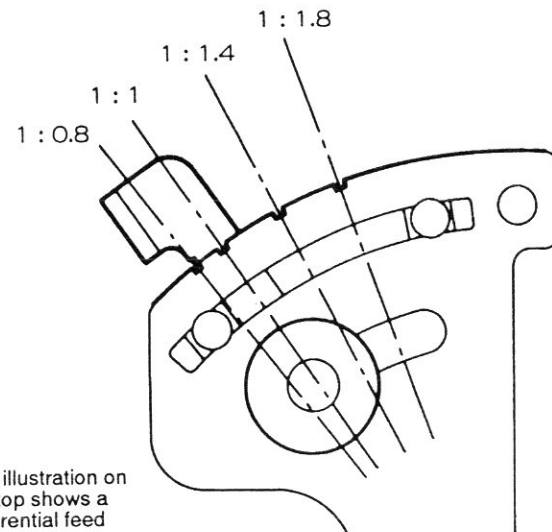
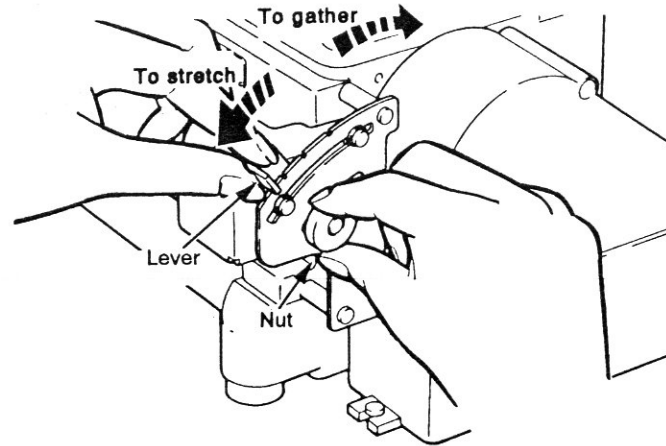
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## ■ W(T)200 Features of each part

### Easy-to-adjust differential feed ratio with the lever

(available for an intermittent adjustment)

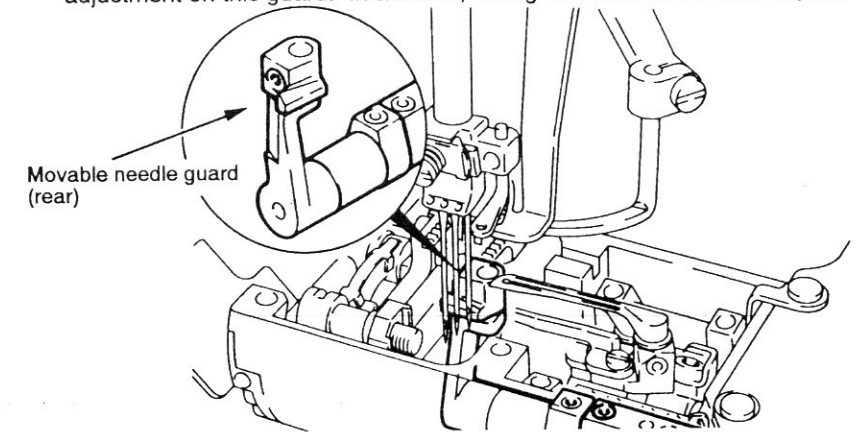
All you have to do is loosen the nut and move the differential feed adjusting lever up or down. By adopting the intermittent method on the differential feed ratio adjustment, partial ruffling is performed during sewing with the knee switch.



Note) The illustration on the top shows a differential feed ratio of 1:0.8.

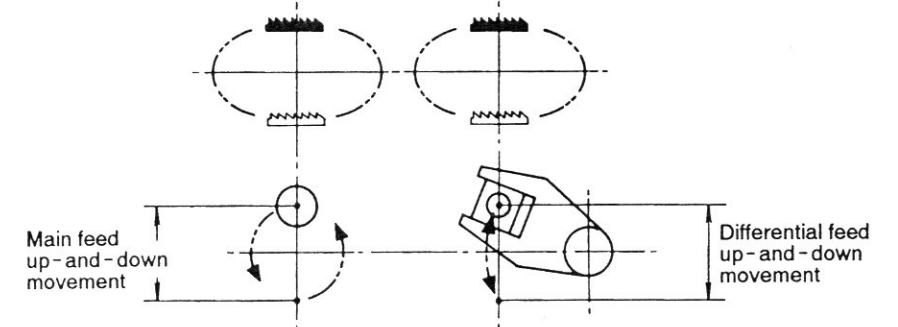
### Movable needle guard mechanism eliminates skip stitching.

Since the needle guard (rear) moves front to back, it holds the needle correctly at the moment the lower looper enters the needle thread loop, eliminating skip stitching. You can make a front-to-back or up-and-down, and an angle adjustment on this guard. In addition, timing to the needle can be adjusted.



### The main feed dog and the differential feed dog have the same elliptical orbit.

The main feed dog and the differential feed dog rotate side by side in the same elliptical orbit with their up-and-down movement so that they can tightly catch the fabric. This orbit increases feed efficiency. A conventional feed bar has only one cam that moves a feed dog up and down. The front and back feed bars on the new W(T) 200 Series have a cam on their both ends.



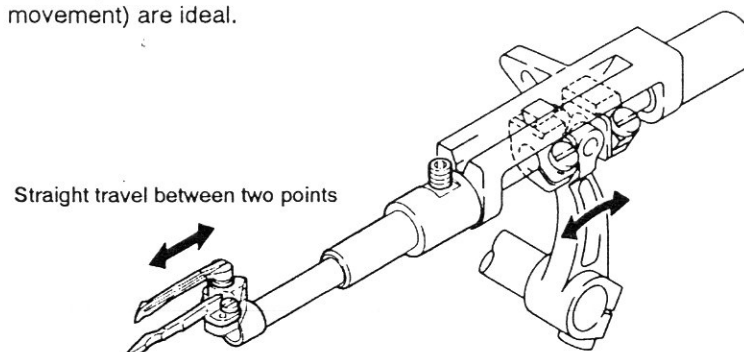
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## ■ W(T)200 Features

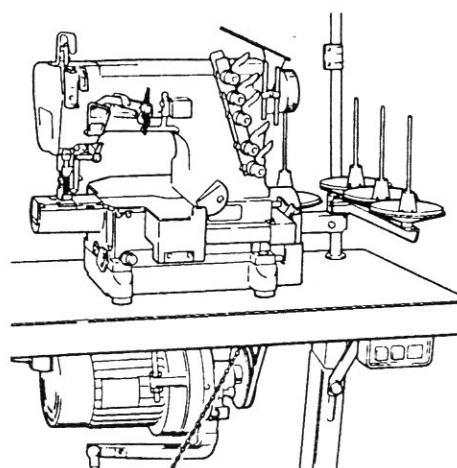
### **The looper left-to-right movement is straight.**

The diameter of the cylinder bed has decreased so that the looper can travel straight between two points. Since the angle at which the looper enters the needle thread loop is 90 degree, both the travel when the looper moves to the left (entering movement) and the travel when the looper moves to the right (returning movement) are ideal.

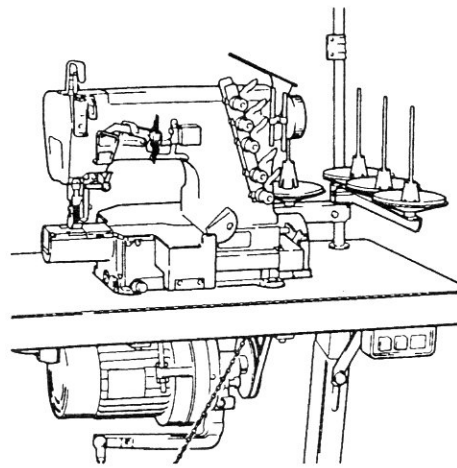


### **Installation**

Non-submerged or semi-submerged installation is selectable.



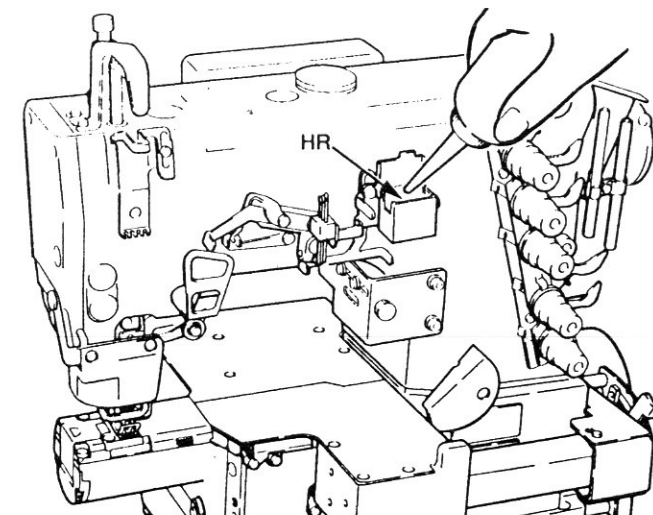
Non-submerged installation



Semi-submerged installation

### **Equipped with the HR (upper)**

This equipment prevents the needle points from overheating when chemical fiber threads or fabric is used. No skip stitching, thread breakage or fabric damage occurs.

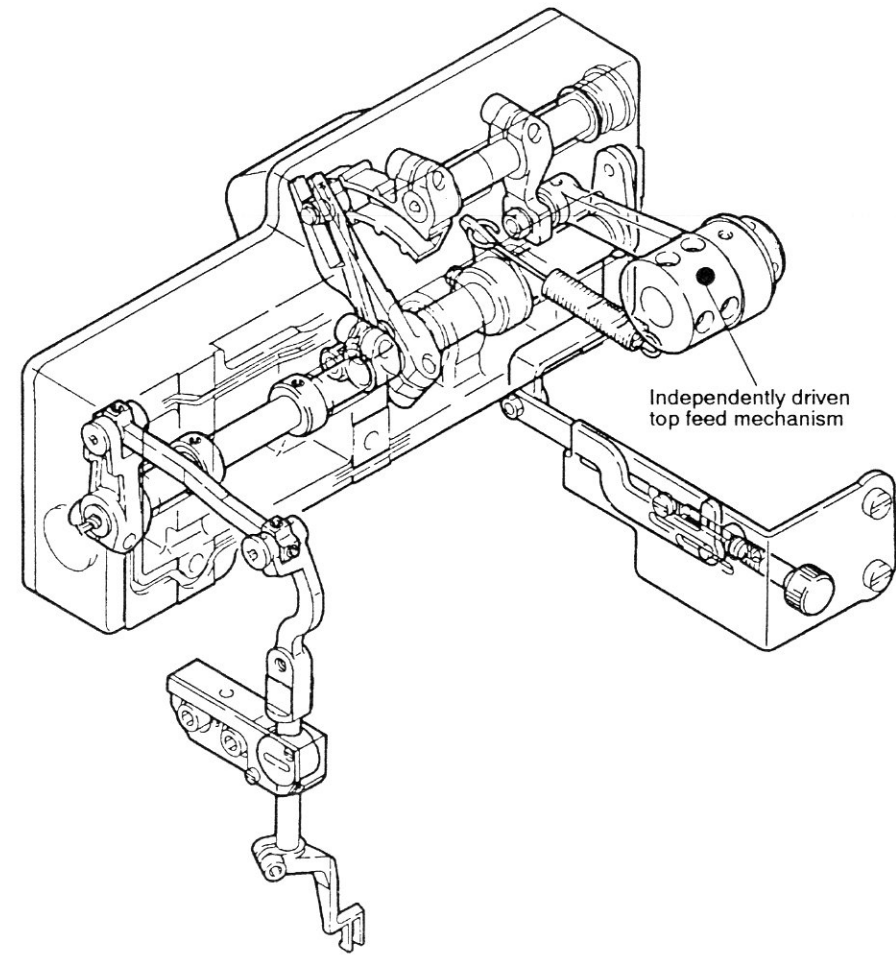
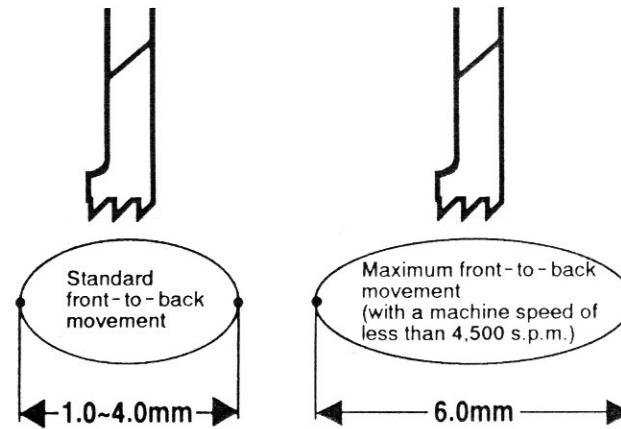


## ■ WT200 Features

### **Independently driven top feed**

■ Equipped with the independently driven top and bottom feed mechanism, larger differential feed ratios can be obtained.

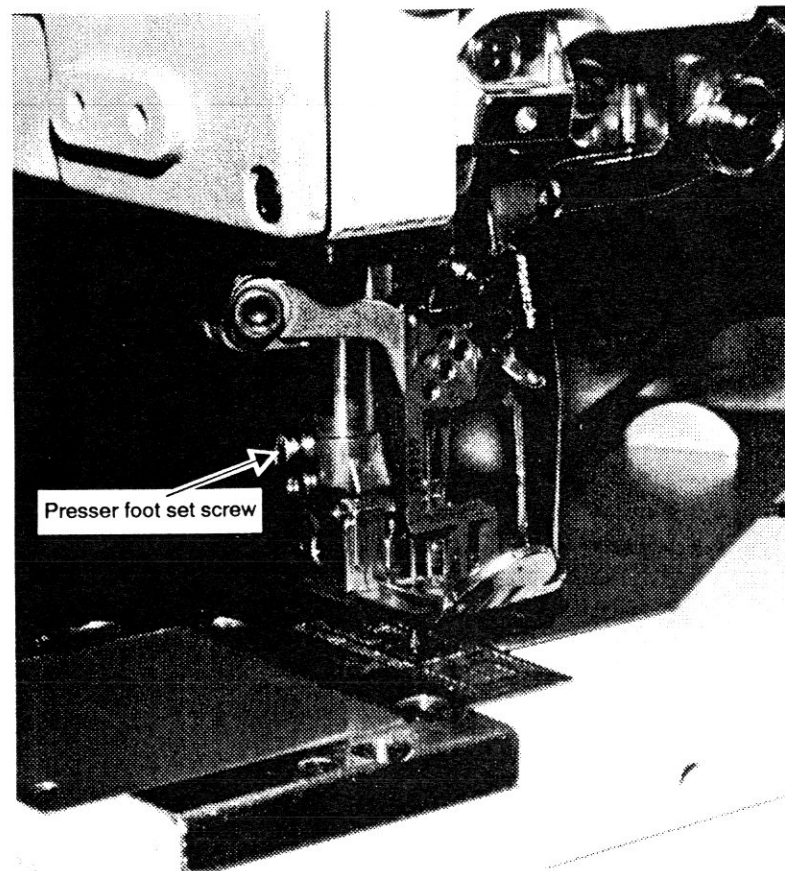
※ A ruffling operation can be performed on stretchable fabrics.



## ■ WT200 Features

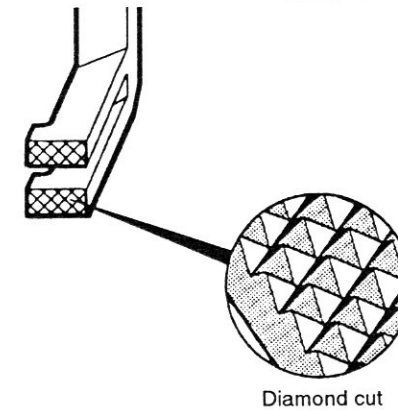
### Easy-to-remove presser foot

- Remove the presser foot by loosening the presser foot set screw and raising the presser foot (lowering the foot lift lever). The top feed dog is simultaneously raised, so removing the presser foot is easy.



### Top feed dog teeth with diamond cut

- Diamond cut (used on the EXT Series) that increases feed efficiency is adopted on the top feed dog of the WT200 Series. (The bottom feed dogs use conventional parallel feed dog teeth.)



## ■ W(T)200 Subclass specifications

WT 2 6 4 - 01 C B × 2 40

1 2 3 4

1 Subclass

3 No. of needles

2 Needle plate type

4 Needle space (mm)

A : The machine produces seams with tightened needle thread.  
Suitable for fine stitch length (less than 1.7mm).

B : Standard stitch (1.8 - 2.3mm)

C : The machine produces seams with affluent needle thread.  
Suitable for coarse stitch length (more than 2.5mm).

### W200 Series subclasses

Application	Subclass	No. of needles	No. of threads	Needle space (mm)	Stitch length (mm)	Differential feed ratio	Foot lift (mm)	Machine speed (s.p.m.)	Remarks
Plain seaming	W264-01CB	2	4	3.2•4•4.8•5.6•6.4	0.9~4.2	0.8~1.8	5.8	5,000	
	-01CC	3	5	5.6•6.4			5.1		
	W264-01EB	2	4	4.8	0.9~4.2	0.8~1.8	5.8	5,000	
Covering	W264-03FB	2	4	4•4.8•5.6•6.4	0.9~4.2	0.8~1.8	5.8	5,000	Flattening out overlock seams (for medium to heavy weight fabrics)
	-03FC	3	5	5.6•6.4			5.1		
	W264-03GB	2	4	4•4.8	0.9~4.2	0.8~1.8	5.8	5,000	Folding over overlock seams (for light weight fabrics)
Hemming	-03GC	3	5	5.6•6.4			5.1		
	W264-08AB	2	4	4•4.8	0.9~4.2	0.8~1.8	5.8	5,000	Hem width : narrow
	-08AC	3	5	5.6•6.4			5.1		
	W264-08BB	2	4	3.2•4•4.8	0.9~4.2	0.8~1.8	5.8	5,000	Hem width : wide
		3	5	5.6•6.4			5.1		
	W264-08BC	2	4	4•4.8	0.9~4.2	0.8~1.8	5.8	5,000	Hem width : wide
		3	5	5.6•6.4			5.1		

Note: Max. machine speed varies according to differential feed ratio.  
Max.differential feed ratio varies according to stitch length.

### WT200 Series subclasses

Application	Subclass	No. of needles	No. of threads	Needle space (mm)	Stitch length (mm)	Differential feed ratio	Top feed dog front-to-back movement amount (mm)	Foot lift (mm)	Machine speed (s.p.m.)	Remarks
Plain seaming	WT264-01CB	2	4	3.2•4•4.8•5.6•6.4	0.9~4.2	0.8~1.8	1~6	6	5,000	
	-01CC	3	5	5.6•6.4						
	WT264-01EB	2	4	4.8	0.9~4.2	0.8~1.8	1~6	6	5,000	
Covering	WT264-03FB	2	4	4•4.8•5.6•6.4	0.9~4.2	0.8~1.8	1~6	6	5,000	Flattening out overlock seams (for medium to heavy weight fabrics)
	-03FC	3	5	5.6•6.4						
	WT264-03GB	2	4	4•4.8	0.9~4.2	0.8~1.8	1~6	6	5,000	Folding over overlock seams (for light weight fabrics)
Hemming	-03GC	3	5	5.6•6.4						
	WT264-08AB	2	4	4•4.8	0.9~4.2	0.8~1.8	1~6	6	5,000	Hem width : narrow
	-08AC	3	5	5.6•6.4						
	WT264-08BB	2	4	3.2•4•4.8	0.9~4.2	0.8~1.8	1~6	6	5,000	Hem width : wide
		3	5	5.6•6.4						
	WT264-08BC	2	4	4•4.8	0.9~4.2	0.8~1.8	1~6	6	5,000	Hem width : wide
		3	5	5.6•6.4						

Note: Max. machine speed varies according to differential feed ratio and top feed dog movement amount.  
Max.differential feed ratio varies according to stitch length.

## ■ W(T)200/UT Application list

Electric UT specifications

Type	Operational method	Remarks		
		Top cover thread wiper	Presser foot lift	Top cover thread trimmer
UT117	Pressing the treadle with heel	Electric	Electric	—
UT118	"	Electric	—	—
UT119	"	—	Electric	—
UT120	"	—	—	—
UT216	"	—	Electric	Electric
UT217	"	—	—	Electric

Electric UT application

Type	Subclass					
	W264 — 01	W264 — 03	W264 — 08	WT264 — 01	WT264 — 03	WT264 — 08
UT117			○			○
UT118			○			○
UT119	○	○		○	○	
UT120	○	○		○	○	
UT216	○	○	○			
UT217	○	○	○			

Note) Electric UT is unavailable with MS device.

Pneumatic UT specifications

Type	Operational method	Remarks		
		Top cover thread wiper	Presser foot lift	Top cover thread trimmer
UT322	Pressing the treadle with heel	Electric	Pneumatic	—
UT323	"	Electric	—	—
UT324	"	—	Pneumatic	—
UT325	"	—	—	—
UT326	"	Pneumatic	Pneumatic	—
UT327	"	Pneumatic	Pneumatic	—
UT450	"	—	Pneumatic	Pneumatic
UT451	"	—	—	Pneumatic
UT452	"	—	Pneumatic	Pneumatic
UT453	"	—	—	Pneumatic

Pneumatic UT application

Type	Subclass					
	W264 — 01	W264 — 03	W264 — 08	WT264 — 01	WT264 — 03	WT264 — 08
UT322			○			○
UT323			○			○
UT324	○	○		○	○	
UT325	○	○		○	○	
UT326	○	○	○			
UT327				○	○	○
UT450				○	○	○
UT451				○	○	○
UT452	○	○	○			
UT453	○	○	○			

Note) Pneumatic UT are available with MS device.  
MS device cannot be installed on subclasses with C type of needle plate finger.

## ■ W(T)200 Basic adjustments

### Needle height

When the needle is at the top of its stroke, adjust distance (a) from the point of the left needle to the top surface of the needle plate (see Table 1). Follow the procedures below.

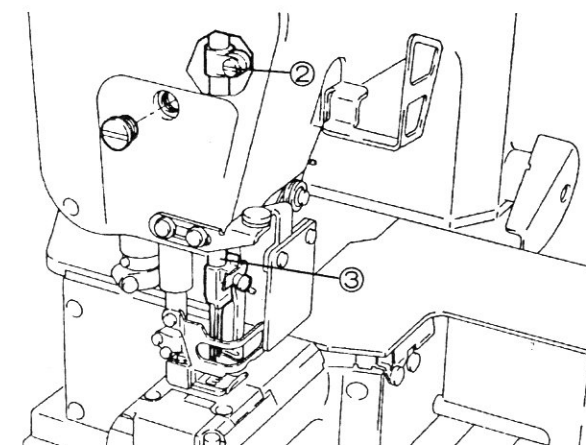
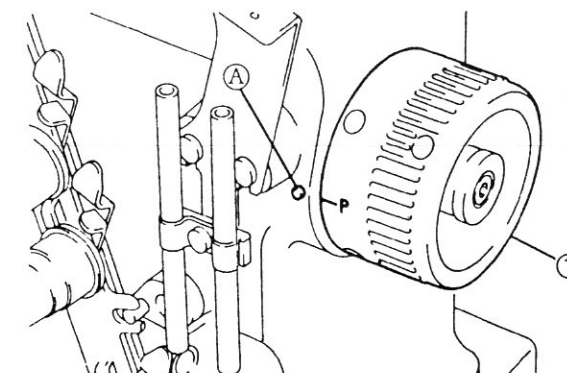
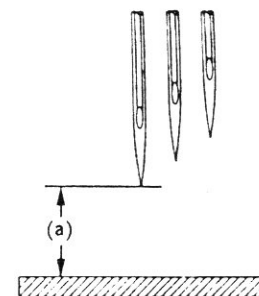
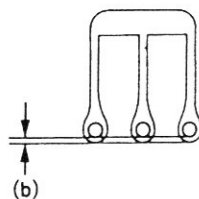
- (1) Turn handwheel ① until the needle bar is at the top of its stroke. Mark "P" on the handwheel should be aligned with alignment mark A.
- (2) Loosen screw ②. Adjust the needle height according to the needle space by moving needle bar ③ up or down.

Relationship between the needle space and the needle height

Table 1

W200 Series				WT200 Series			
2 - needle		3 - needle		2 - needle		3 - needle	
Needle space (mm)	Left needle height (a) (mm)	Needle space (mm)	Left needle height (a) (mm)	Needle space (mm)	Left needle height (a) (mm)	Needle space (mm)	Left needle height (a) (mm)
3.2	8.8	—	—	3.2	10.2	—	—
4.0	8.3	—	—	4.0	9.8	—	—
4.8	7.9	—	—	4.8	9.4	—	—
5.6	7.5	5.6	7.5	5.6	9.0	5.6	9.0
6.4	7.1	6.4	7.1	6.4	8.6	6.4	8.6

- After the above adjustment, check clearance (b) between needles and needle drop holes on the needle plate to make sure it is equal. Then tighten screw ②.





## ■ W(T)200 Basic adjustments

### Looper setting distance Looper avoiding distance

#### (1) Looper setting distance

When looper ① is at the extreme right end of its travel, adjust setting distance (a) from the center of the right needle to the point of the looper (see Table 2). To make this adjustment, loosen screw ③ on looper holder ② and move the looper holder to the left or right. Then tighten screw ③ temporarily.

Relationship between the needle space and the looper setting distance

Table 2

W200 Series				WT200 Series			
2-needle		3-needle		2-needle		3-needle	
Needle space (mm)	Setting distance (a) (mm)	Needle space (mm)	Setting distance (a) (mm)	Needle space (mm)	Setting distance (a) (mm)	Needle space (mm)	Setting distance (a) (mm)
3.2	4.7~5.0	—	—	3.2	4.3~4.5	—	—
4.0	4.3~4.6	—	—	4.0	3.9~4.1	—	—
4.8	3.9~4.2	—	—	4.8	3.5~3.7	—	—
5.6	3.5~3.8	5.6	3.5~3.8	5.6	3.1~3.3	5.6	3.1~3.3
6.4	3.1~3.4	6.4	3.1~3.4	6.4	2.7~2.9	6.4	2.7~2.9

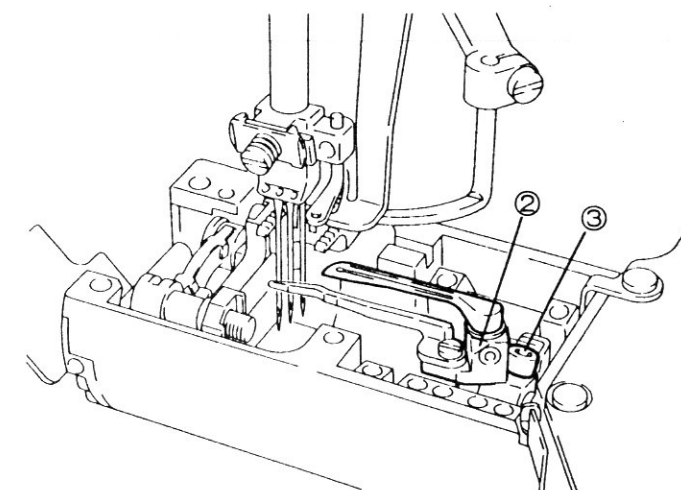
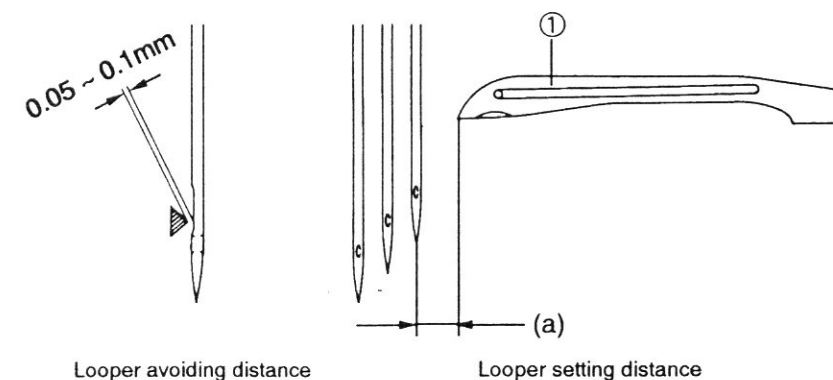
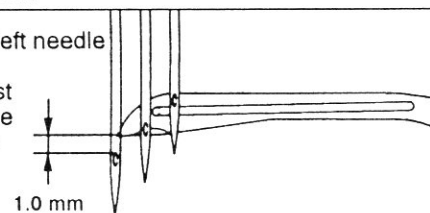
#### (2) Looper avoiding distance

When the point of the looper has reached the center of the left needle from its farthest position to the right, set front-to-back clearance between the left needle and the point of the looper at 0.05 - 0.1mm. To make this adjustment, loosen screw ③ on looper holder ② and move the looper holder front or back. Then tighten screw ③.

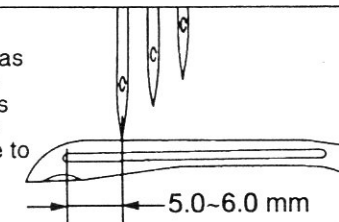
- For 3-needle machines, set the front-to-back clearance between the middle needle and the point of the looper at 0 - 0.05mm when the point of the looper has reached the center of the middle needle from its farthest position to the right.
- When the point of the looper passes the center of the right needle from its farthest position to the right (with the needle guard (rear) ineffective), the right needle slightly touches the point of the looper.

#### (3) Relationship between the looper and the left needle

- When the point of the looper has reached the center of the left needle from its farthest position to the right, check to make sure the point of the looper is 1.0mm above the top of the left needle's eye.



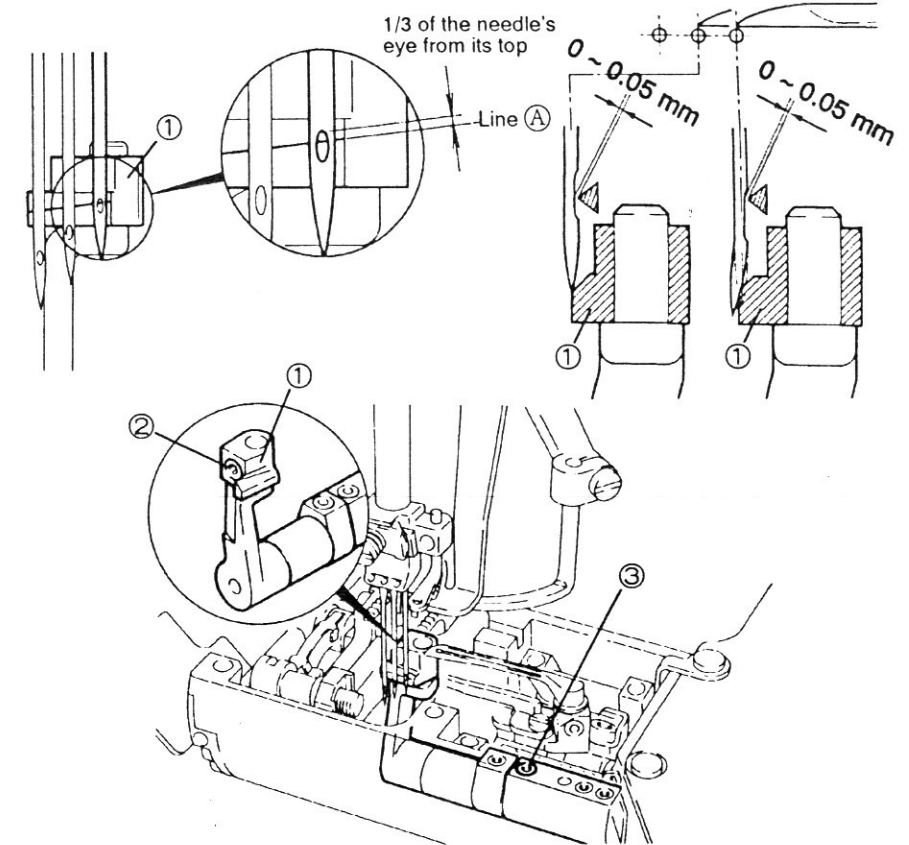
- When the point of the descending left needle has reached the top surface of the looper while the point of the looper is moving to the right from its farthest position to the left, check to make sure the distance from the center of the looper's eye to the center of the left needle is 5.0 - 6.0mm.



## ■ W(T)200 Basic adjustments

### Needle guard (rear)

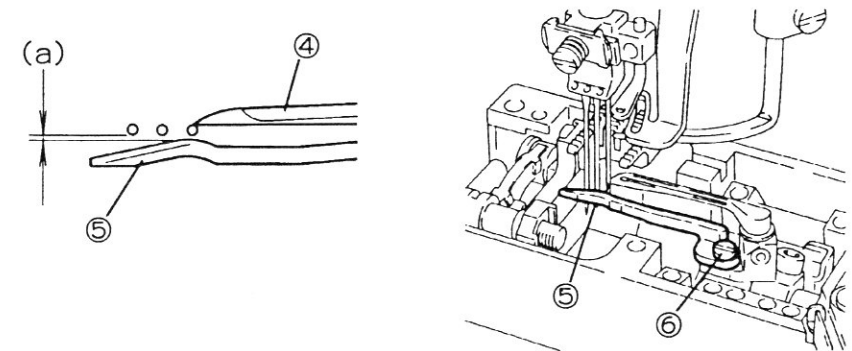
- (1) When the needle bar is at the bottom of the stroke, set line (A) of needle guard (rear) ① at 1/3 of the right needle's eye from its top. To make this adjustment, loosen screw ② and move needle guard (rear) ① up or down.
- (2) When the point of the looper has reached the center of the right needle from its farthest position to the right, set the front-to-back clearance between the right needle and the point of the looper at 0 - 0.05mm. To make this adjustment, loosen screw ③ and move needle guard (rear) ① front or back.
- (3) When the point of the looper has reached the center of the middle needle, the middle needle should slightly touch needle guard (rear) ① with the front-to-back clearance between the middle needle and the point of the looper maintained at 0 - 0.05mm. To make this adjustment, loosen screw ② and move the needle guard (rear) to the left or right.



### Needle guard (front)

When looper ④ moves to the left on the back side of the needles, install the needle guard (front) ⑤ as close to the needles as possible. To do so, adjust clearance (a) between the needle and needle guard (front) ⑤ according to the type or size of the thread so that the needle thread can go through (a) easily. Follow the procedures below.

- (1) Loosen screw ⑥. Turn needle guard (front) ⑤ clockwise or counterclockwise until clearance (a) is equal.



## ■ W(T)200 Basic adjustments

### Spreader

#### (1) Spreader height

Adjust the distance from the top surface of the needle plate to the bottom surface of the spreader (see Table 3). To make this adjustment, loosen screw ② and move spreader ① up or down.

#### (2) Front-to-back and left-to-right position

When spreader ① is moving from the extreme right end of its travel to the left, it should pass point A (at 0.5mm from the left needle). Then when the spreader has reached its farthest position to the left, adjust setting distance (b) (from the center of the left needle to point B of the spreader) by referring to Table 3. To make this adjustment, tighten screws ② and ③ temporarily. Then move spreader ① front or back while moving lever ④ to the left or right.

● Adjust while checking to see if the spreader moves as shown above by turning the machine pulley.

● If the spreader does not hook the spreader thread correctly due to the number of spreader threads or fabric weight, shift point B within 6mm to the left and install spreader thread guide ⑤ as close to the needle holder as possible.

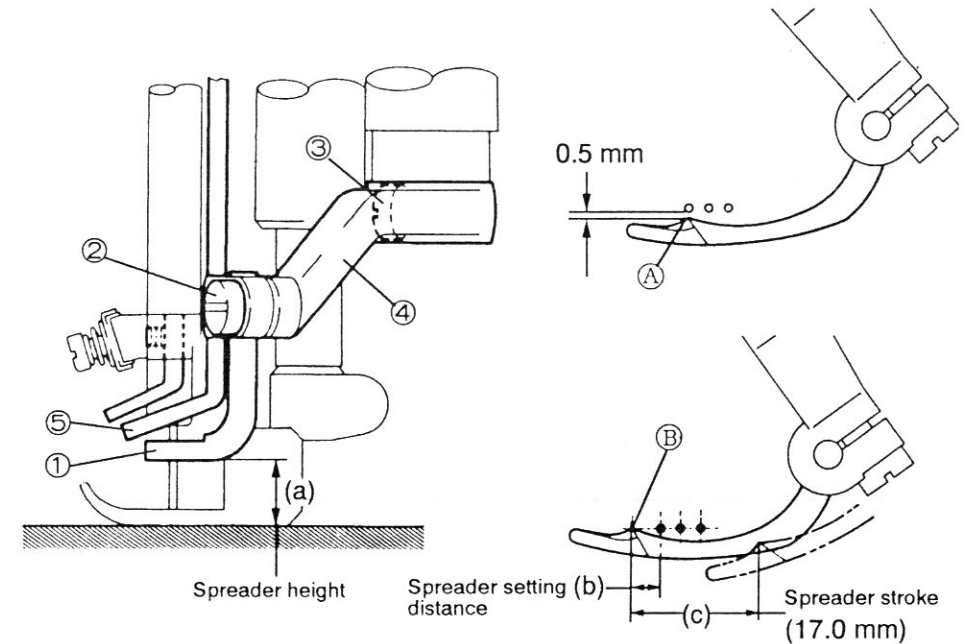
If the spreader still does not hook the spreader thread correctly, increase the spreader stroke within 18mm.

Relationship between the needle space and the position of the spreader

Table 3

W200 Series				WT200 Series			
2-needle				2-needle			
Needle space (mm)	Spreader height (mm)(a)	Setting distance (mm)(b)	Stroke (mm) (c)	Needle space (mm)	Spreader height (mm)(a)	Setting distance (mm)(b)	Stroke (mm) (c)
3.2	7.7	4.5~5.0	17.0	3.2	8.6	5.0~5.3	17.0
4.0	"	"	"	4.0	"	"	"
4.8	"	"	"	4.8	"	"	"
5.6	"	"	"	5.6	"	"	"
6.4	"	"	"	6.4	8.2	"	"
3-needle				3-needle			
5.6	7.7	4.5~5.0	17.0	5.6	8.6	"	"
6.4	"	"	"	6.4	8.2	"	"

(Note that the stroke on WT264-08B is 19.5mm.)



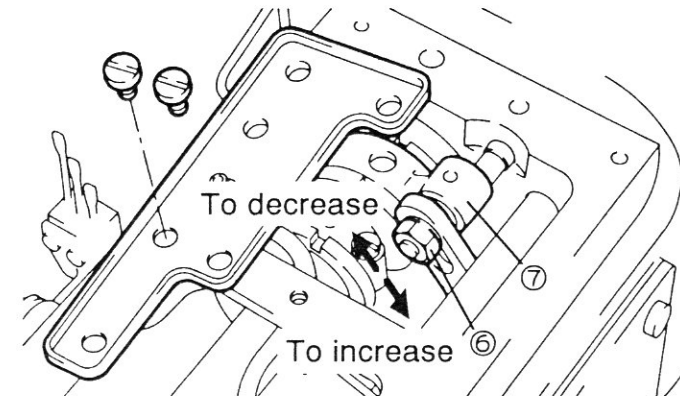
#### (3) Spreader stroke

The standard stroke of the spreader is 17.0mm.

Loosen nut ⑥ first.

● To decrease the stroke, move up rod ⑦.

● To increase the stroke, move down rod ⑦.



## ■ W(T)200 Basic adjustments

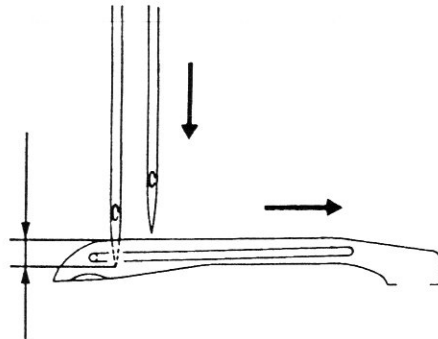
### Looper thread take-up

When the point of the left needle which descends to the back of the looper has reached the point (see the illustration below) while the looper is moving from the extreme left end of its stroke to the right, the looper thread which is held by looper thread take-up ① should be released from point (a) on the looper thread take-up.

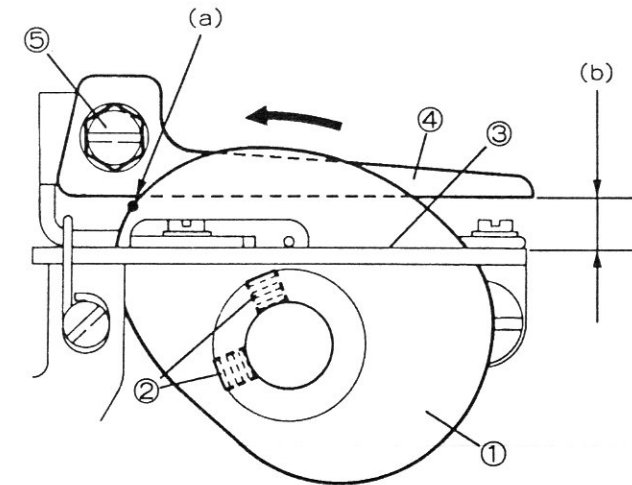
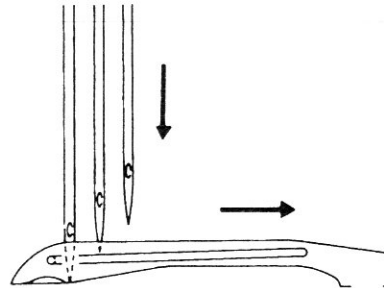
To make this adjustment, loosen screw ② and turn looper thread take-up ①.

Position of the point of the left needle when the looper thread is released from point (a) on looper thread take-up ①

[2 - needle]  
At 2/3 of the looper from its top



[3 - needle]  
At the bottom surface of the looper



### Looper thread guard

Adjust distance (b) from the top surface of bracket ③ to bottom surface of looper thread guard ④.

- To increase the amount of the looper thread (for 3 - needle machines etc.), increase distance (b).
- To decrease the amount of the looper thread (for 2 - needle machines etc.), decrease distance (b).

To make this adjustment, loosen screw ⑤ and then move looper thread guard ④.

## ■ W(T)200 Basic adjustments

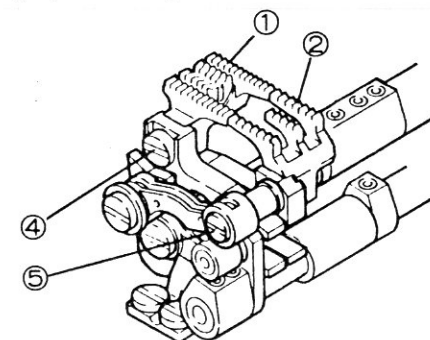
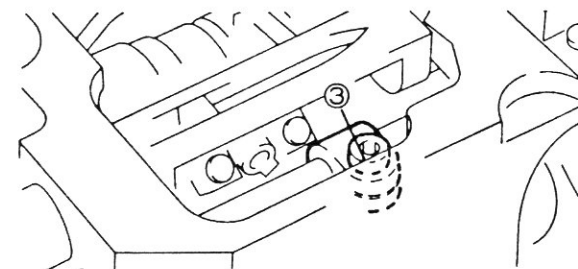
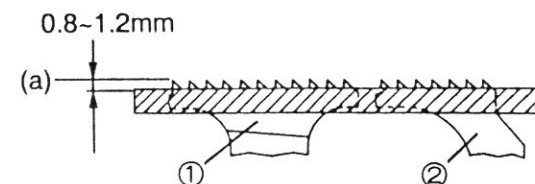
### Feed dog height

(1) When the feed dog is at the top of its stroke, line (a) formed by the teeth of main feed dog ① and those of differential feed dog ② should be parallel with the top surface of the needle plate.

To make this adjustment, loosen screw ③ first and then move the differential feed dog up or down while holding the front end of the differential feed dog.

(2) When the feed dog is at the top of its stroke, the distance from the top surface of the needle plate to line (a) formed by the teeth of main feed dog ① and those of differential feed dog ② should be 0.8 - 1.2mm.

To make this adjustment, loosen screws ④ and ⑤ first and then move feed dogs ① and ② up or down.



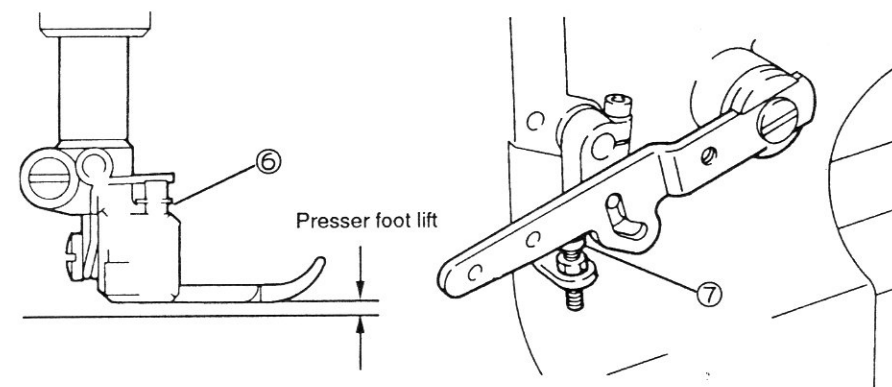
### Presser foot lift

When presser foot ⑥ is raised, adjust the distance from the top surface of the needle plate and the bottom surface of the presser foot (see Table 4). To make this adjustment, adjust stopper ⑦.

Presser foot lift (mm)

Table 4

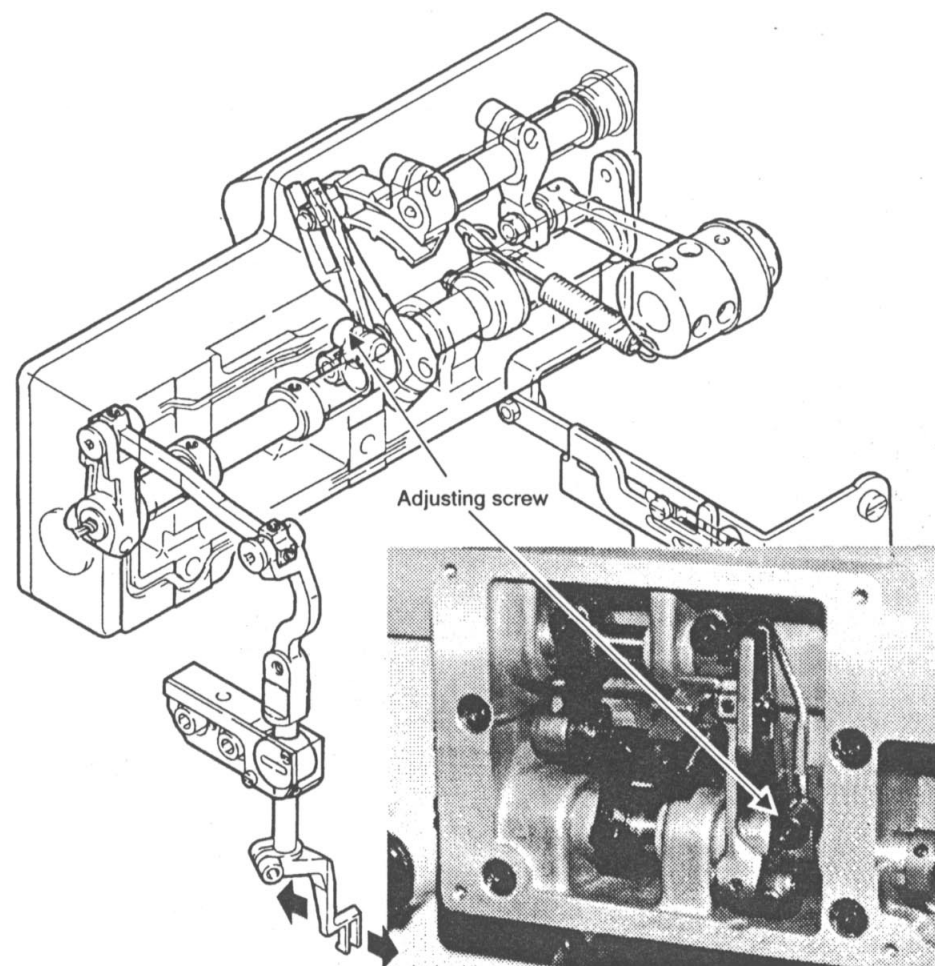
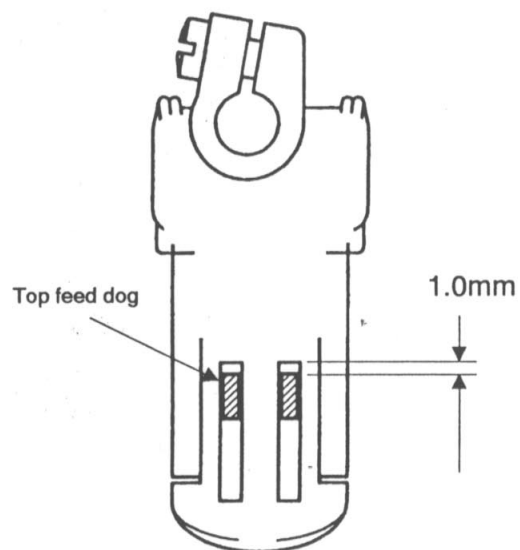
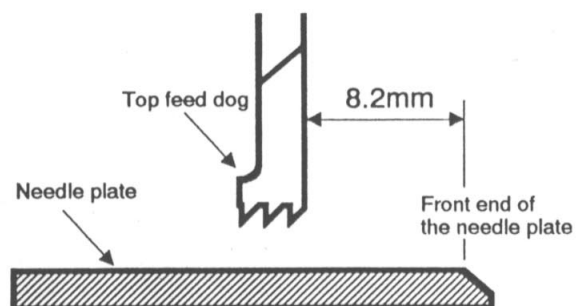
W200 Series		WT200 Series	
2 - needle	3 - needle	2 - needle	3 - needle
5.8	5.1	6.0	6.0



## ■ WT200 Basic adjustments

### Front-to-back position of the top feed dog

- To make this adjustment, remove the rear cover first and then loosen the adjusting screw with a 5mm key wrench.

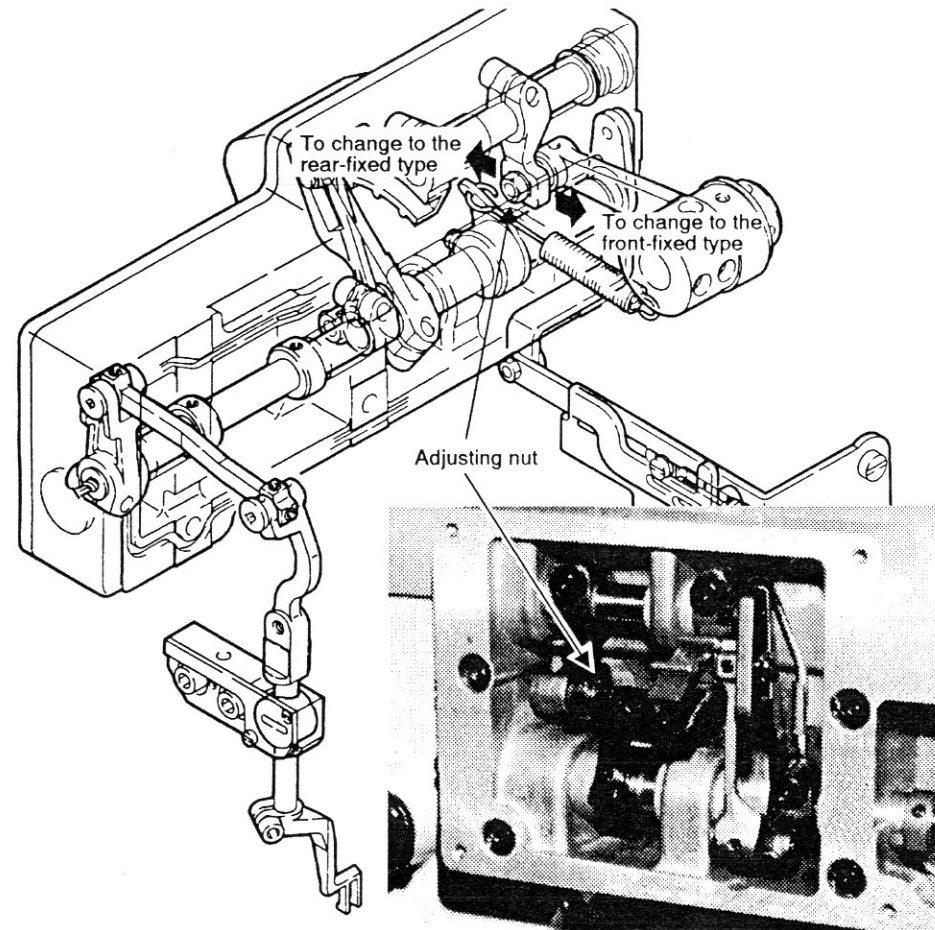




## ■ WT200 Basic adjustments

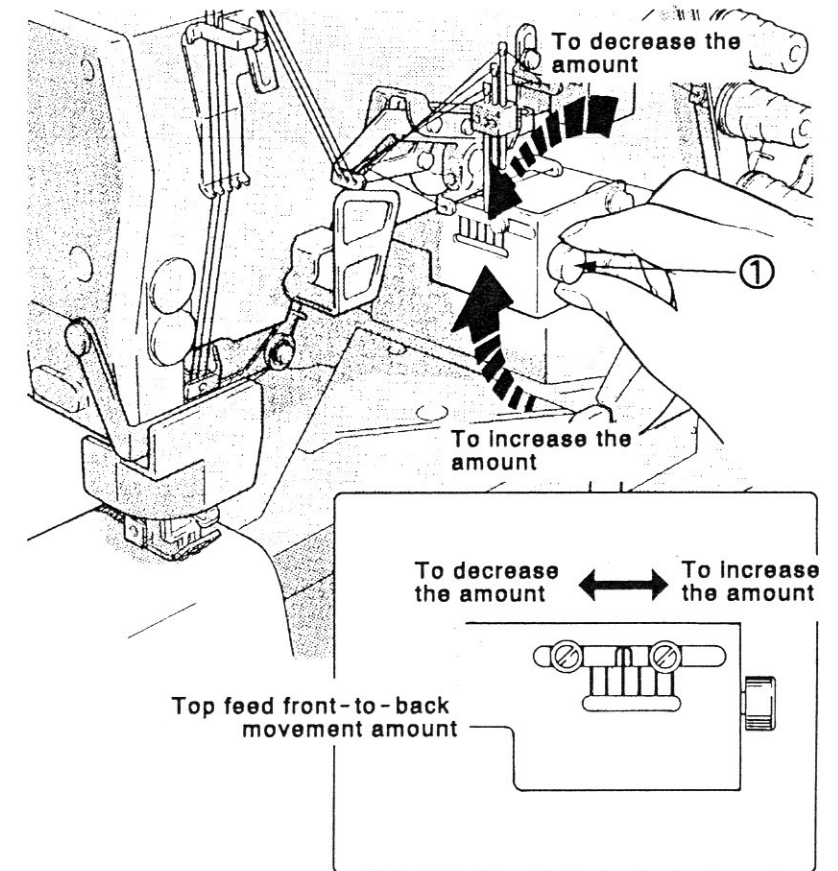
### Front-to-back movement of the top feed dog

- Rear-fixed type (with feeding motion at the front of the top feed dog: standard)  
Divided-in-half type
- Front-fixed type (with feeding motion at the back of the top feed dog)
- To make this adjustment, remove the rear cover first and then loosen the adjusting nut with a 8mm wrench. Adjust the position of the nut within the slot of the top feed crank.



### Front-to-back movement amount of the top feed dog

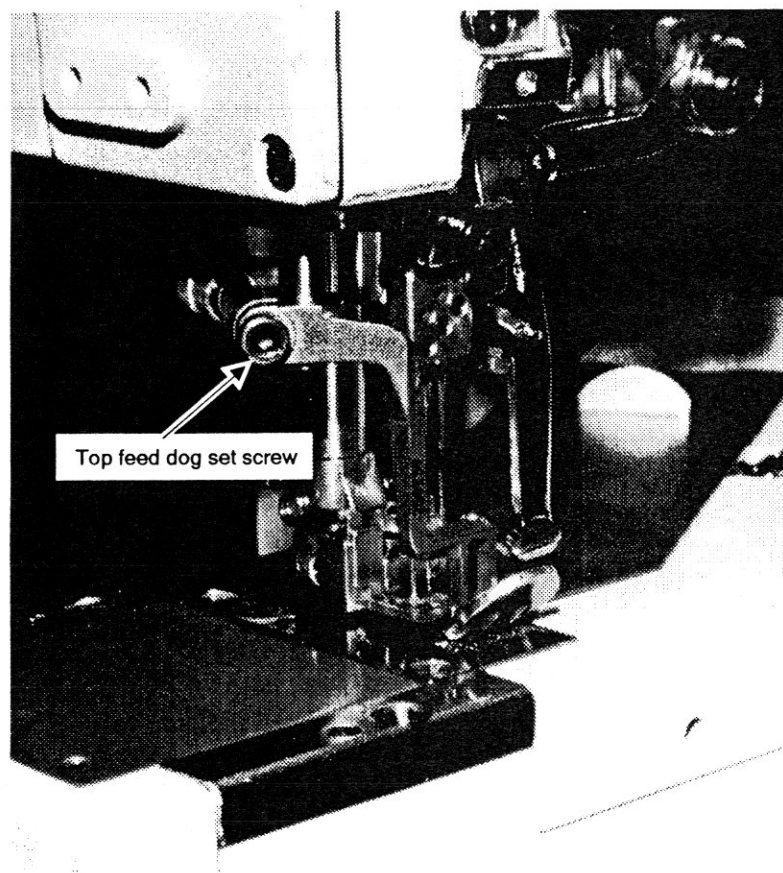
- To make this adjustment, turn adjusting nut ① as required.



## ■ WT200 Basic adjustments

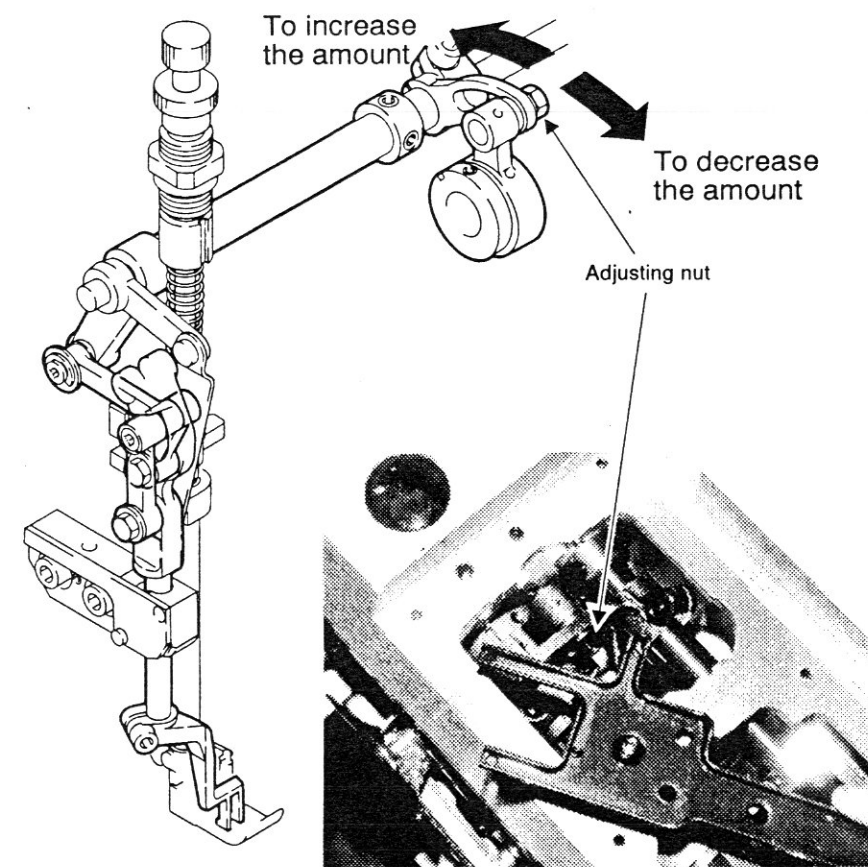
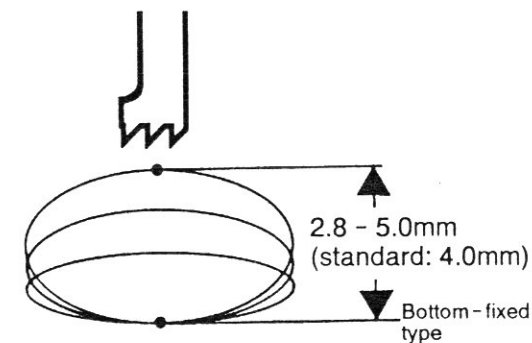
### Up - and - down position of the top feed dog

■ This adjustment can be made by the top feed dog set screw.



### Up - and - down movement amount of the top feed dog

■ A large amount of the top feed dog up - and - down movement can be obtained.  
Maximum 5.0mm  
(with a machine speed of less than 4,500 s.p.m.)



## ■ WT200 Basic adjustments

### Top feed dog orbit

- To make this adjustment, remove the top cover first and then loosen the two eccentric set screws with a 2.5mm key wrench.

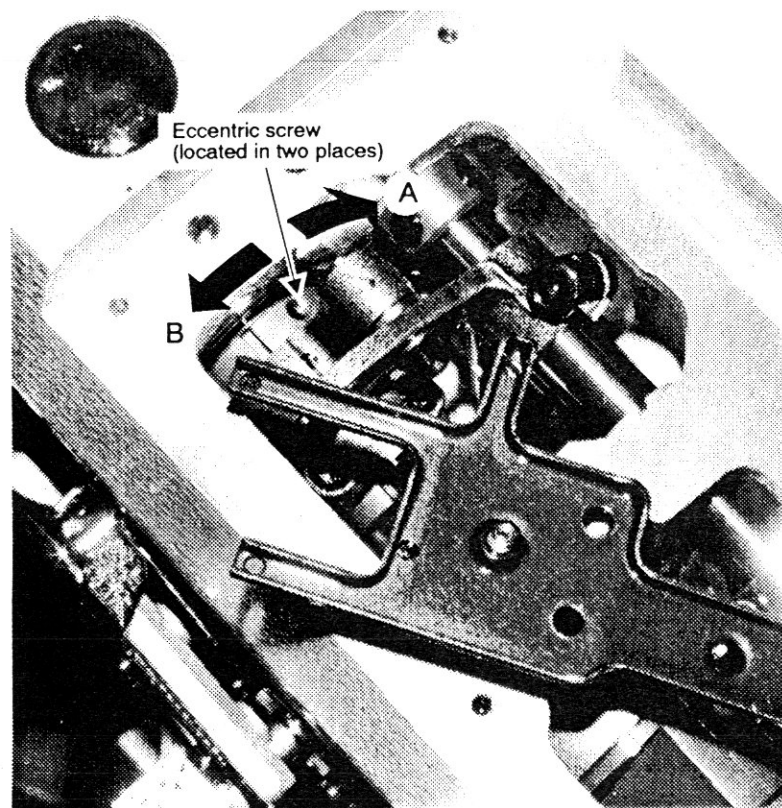


A: To increases the timing



B: To decreases the timing

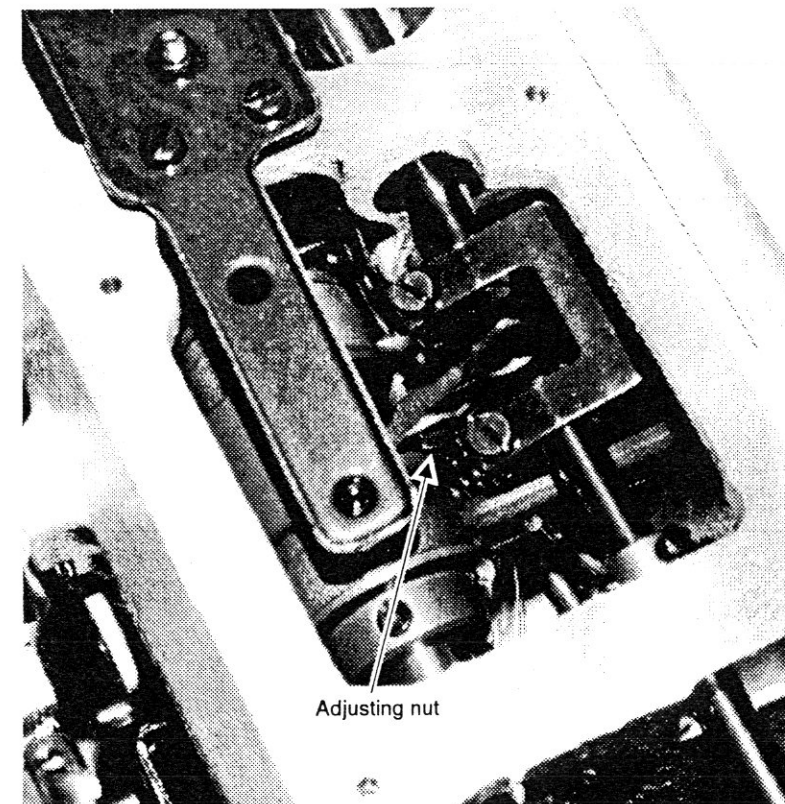
Top feed dog orbit



### Spreader movement amount

- Standard: 17mm  
-08B: 19.5mm

- To make this adjustment, remove the top cover first and then loosen the adjusting nut with a 8mm wrench. Adjust the nut within the slot.



## ■ WT200 Basic adjustments

### **Presser foot pressure**

- To make this adjustment, loosen nut ① first and then turn screw ② as required.  
The presser foot pressure should be as light as possible, yet be sufficient to produce uniform stitches.

