



**PEGASUS®**

# W2600 Series

Thank you very much for purchasing Pegasus W2600 Series machine.

This instruction manual describes daily routine maintenance and safety precautions to keep the machine in the best possible conditions.

Please study this manual very carefully before operating the machine.

2 or 3-needle cylinder bed interlock  
stitch machine

**INSTRUCTIONS**



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# CONTENTS

<b>Copyright</b> .....	1	Oil replacement .....	17
<b>Directives</b> .....	1	To drain the oil .....	17
<b>1.Introduction</b> .....	2	Adjusting the needle thread guard .....	18
<b>2.Indications of dangers, warnings &amp; cautions</b> ·	2-3	Adjusting the needle thread guides .....	18
<b>3.Safety precautions</b> .....	3-4	Removing and reinstalling the looper thread take-up .....	19
<b>4.Notes for each procedure</b> .....	4-6	Adjusting the looper thread take-up .....	19
<b>5.Location of warning labels and safety devices</b> ···	7	Adjusting the looper thread guides .....	20
<b>6.Protectors for safety</b> .....	8	Adjusting the spreader .....	21
Assembling the machine rest board .....	9	Adjusting the top cover thread guide .....	22
Sewing machine installation .....	9	Adjusting the feed dog height .....	23
Installing the belt cover .....	9	Adjusting the presser foot lift .....	23
Operating direction of the machine pulley .....	9	Adjusting the needle height .....	24
Lubrication .....	10	Adjusting the looper .....	25
Silicone oil for H.R. device .....	11	Adjusting the needle guard (rear) .....	26
Threading .....	12-13	Adjusting the needle guard (front) .....	26
Adjusting presser foot pressure .....	14	Adjusting the differential feed ratio .....	27-28
Adjusting the differential feed ratio .....	14	Changing the needle bar stroke .....	29
Adjusting stitch length .....	14	Adjusting the supply of oil for the needle bar chamber ···	29
Adjusting the thread tension .....	15	Adjustment dimensions	
Cleaning the machine .....	15	Comparison table of equivalent sizes	
Replacing the needle .....	16	Standard needle .....	30
Replacing the oil filter .....	16	Subclass specifications .....	31

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Be sure to study very carefully **for safety.**

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## Copyright

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- **Disclaimer**  
The contents described in this instruction manual are intended for giving information and subject to change without notice. We assume no responsibility for these information, and any errors and/or incorrect descriptions that may appear in this instruction manual.
- Pegasus Sewing Machine Mfg. Co., Ltd. has a policy that we always modify the performance and/or specifications of this product introducing the state-of-the-art technology. Accordingly we reserve the right to change the specifications and/or design without notice.
- This instruction manual is valid for all the models and subclasses listed in the chapter "Specifications."

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## Directives

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This machine is constructed in accordance with the European regulations contained in the conformity and manufacturer's declarations. In addition to this instruction manual, strictly observe all the generally accepted, statutory regulations, legal requirements and all the environmental protection regulations.

Also rigidly adhere to the regionally valid regulations of the social insurance society for occupational accidents or other supervisory organizations.

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## 1.Introduction

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- This is the instruction manual that describes how to use this product safely.
- Read this instruction manual and learn very carefully how to operate, adjust and service this sewing machine before beginning any of the procedures.
- You should realize first that there is always the risk of contacting moving parts, such as needles because you have to work at point-blank range to them when you are operating industrial sewing machines.  
For safety it is essential that we supply safe products and you use them correctly and safely.  
There may be some safety measures that you yourself must take.  
Therefore, you should read and understand very carefully this instruction manual together with that of the driving equipment and take necessary safety measures in order to use this machine efficiently and effectively.

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## 2.Indications of dangers, warnings and cautions

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To prevent accidents and ensure safety, warning indications which show the degree of danger are used on our products and in this manual.




Study the contents of these indications carefully and follow all warnings and instructions.

Indication labels should be found easily.

Attach new labels when they are stained or removed.

Contact our sales office when new labels are needed.

### **Symbols, signs and/or signal words which attract users' attention**

 <b>DANGER</b>	Indicates an immediate hazard to life or limb.
 <b>WARNING</b>	Indicates a potential hazard to life or limb.
 <b>CAUTION</b>	Indicates a possible mistake that could result in injury or damage.

## Symbols and messages

	Be sure to follow the instructions when you operate the machine and/or labor saving device.
	If you use the machine and/or labor saving device incorrectly, you may get an electrical shock.
	If you use the machine and/or labor saving device incorrectly, your hands and/or fingers may be injured.
	Indicates a danger of burn injury due to high temperature.
	Never do this.
	Unplug the machine or shut off the power when checking, adjusting and/or repairing the machine and/or labor saving device, or when lightning may strike.
	Be sure to ground the machine and labor saving device securely.
	Denotes the normal rotating direction of the machine pulley.

### 3.Safety precautions

#### ①Applications, purpose

Our industrial sewing machines have been developed in order to increase quality and/or production in the sewing industry. Accordingly never use our products for other than intended use described above.

#### ②Circumstances

The environment in which our industrial sewing machines are used may seriously affect their lives, functions, performance and/or safety.



For safety, do not use the machine under the circumstances below.

- 1.Do not use the machine near objects which make noise such as a high-frequency welder, etc.
- 2.Do not use or store the machine in the air which has vapor from chemicals, or do not expose the device to chemicals.
- 3.Do not leave the machine outside, in high temperatures or the direct sun.
- 4.Do not use the machine in the places of high ambient temperature and humidity that seriously affects sewing machines.

5.Do not use the machine on the condition that the voltage fluctuation range is more than  $\pm 10\%$  of the rated voltage.

6.Do not use the machine in the place where the supply voltage specified for the control motor cannot be properly obtained.

#### ③Safety measures



(1)Safety precautions when you perform maintenance on the machine.

- Always turn off the power, unplug the machine and then make sure that the machine does not run by pressing the treadle before performing any maintenance, such as checking, repairing, cleaning, etc. However, if you need to perform these procedures with the power on, to prevent accidents due to the unexpected start of the machine and users' misoperation, establish your own procedures for safety and follow them.



●Always turn off the power and unplug the machine before performing the procedures shown below.

- Lubrication
- Threading
- Cleaning
- Replacing the needle
- Checking/replacing the oil element
- Replacing the oil

- Always turn off the power before performing the procedures shown below.
  - Adjusting the stitch length
  - Adjusting the differential feed ratio
  - Adjusting the front-to-back movement amount of the top feed dog

- Only well-trained people should perform routine daily maintenance and/or repair the machine.



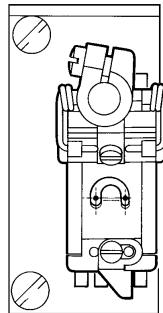
- Do not modify the machine yourself.

※ Consult your local Pegasus' sales office or representative for modification.

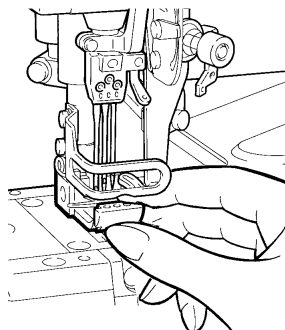


#### (2) Before operating the machine

- Check the machine head and unit for any damage and/or faulty function at the start of each day.  
If there should be something wrong with the machine, immediately perform repairs and/or other necessary procedures.
- Check by hand to see if the needle holder is secured.  
※ Be careful of the needle point.
- Before starting the machine, make sure that the presser foot is positioned correctly (turn the machine pulley slowly by hand to see if the needle point is centered in the needle drop hole on the presser foot).



- Check to see if the presser foot is set by the foot lifter and press it by hand front to back and left to right).



#### (3) Training

- To prevent accidents, operators and service/maintenance personnel should have proper knowledge and skills for safe operation.  
To ensure so, managers must design and conduct training for these people.

## 4. Notes for each procedure

### ⚠ CAUTION

#### ① Unpacking

1. The machine is packaged in a cardboard box before shipping.  
Unpack your machine in orderly sequence while checking them right-side up by referring to the indications, such as logo, etc. printed on the boxes.
2. Never hold the area near the needle and/or thread guide related parts when taking out the machine from the cushion.  
Otherwise it may cause injury and/or damage to the machine.
3. Take out the machine very carefully while checking the position of the center of the gravity.
4. Keep the cardboard box and packing carefully in case secondary transport is needed in the future.

#### Disposal of the packaging

- The packaging material of the machine consists of wood, paper, cardboard and VCE fiber. The proper disposal of the packaging is the responsibility of the customer.

#### Disposal of machine waste

1. The proper disposal of machine waste is the responsibility of the customer.
  2. The materials used on the machines are steel, aluminum, brass and various plastics.
  3. The machine waste is to be disposed of in accordance with the locally valid environmental protection regulations. A specialist should be commissioned if necessary.
- ※ The parts contaminated with lubricants should be disposed off separately according to the locally valid environmental protection regulations.

#### Transport within the customer's premises

- The manufacturer assumes no liability for transport within the customer's premises. Care should be taken to transport the machine in an upright position avoiding it from dropping or falling down to the ground when it is moved.

Be sure to study very carefully for safety.

## ! WARNING

### ② Transportation

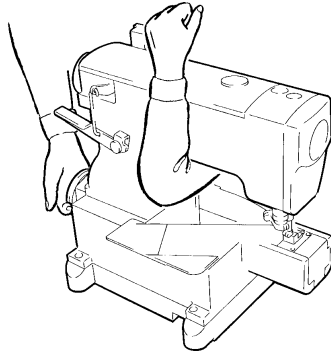
1. The machine should be carried by at least more than two people when it is mounted on the table and/or a hand truck.

Be sure to use a hand truck for other transportation.

2. To carry the machine, hold the machine pulley tightly with your right hand and the machine arm with your left upper arm.

If the machine and/or your hands are stained with oil, the machine may be easy to slip out of your hands and fall to the floor.

Therefore, wipe off the oil carefully.



3. Care should be taken to avoid excessive shock and shake when the machine is mounted on the table and/or transferred using a hand truck. Otherwise the machine may fall down.
4. Wipe off the oil from the machine before packaging it again for secondary transport. Otherwise the machine may easily slip out of your hands or the bottom of the box may come off while in transit.

## ! CAUTION

### ③ Installation, preparation

#### Machine table

1. Use the machine table (table board, metal legs) that completely carries the machine and is fully resistant to warping while the machine is running.
2. Arrange the working environment for easy operation by considering where to place the machine and the brightness around the working area. If the illumination is insufficient, control or change lighting as required.
3. Attach a non-slip pad to the treadle (foot switch).  
Otherwise the operator may slip off the treadle while running the machine, causing trouble.
4. Adjust the height of the table according to a working posture of the operator.

## ! WARNING

#### Cables

1. When connecting the cables between the machine and the motor, be sure to turn off the power and connect each cable connectors securely.
2. Do not strain the cables in use.
3. Do not bend the cables excessively.
4. When connecting the cables that are close to the moving parts, such as pulley or V belt, keep a distance of 25mm at least between them.
5. Protect each cable using a cover or adjusting its position if necessary.
6. Never use staples to fasten the cables.  
Otherwise it causes a short circuit and/or a fire.

## ! CAUTION

#### Motor

1. Install the machine motor correctly by referring to the instruction manual supplied by the manufacturer.
2. Select the machine motor equipped with the pulley cover so that any part of your body etc. is not caught in the belt.

## ! CAUTION

#### Ground


1. Connect each of the ground wires in the sewing machine system to the ground terminal. Do not connect to another devices'.
2. Connect the ground wires securely to the indicated ground points on the machine head.

## ! WARNING

### ④ Handling machine oil

1. Never start the machine with no oil in the reservoir.  
Use HIGHSPEED SEWING MACHINE OIL specified by Pegasus (Equivalent of ISO requirements: Viscosity Index of VG22).
  2. If machine oil gets in your eyes, it may cause eye irritation.  
To prevent the machine oil from getting in your eyes, wear a pair of protective glasses.
- ※ Should machine oil gets in your eyes, wash them with fresh water for 15 minutes and then go to see a doctor.

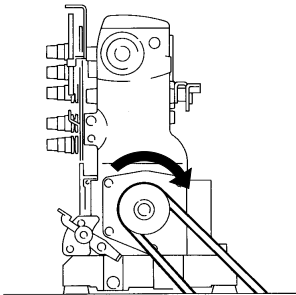


3. Avoid skin contact. Immediately wash contacted areas completely with water and soap.
4.  Never swallow machine oil.
5. Keep machine oil out of the reach of children.  
※ If swallowed, do not induce vomiting.  
Immediately go to see a doctor.
6. Dispose of the waste oil and/or containers properly as demanded by law. If you have further questions on its disposal, consult the store or shop at which you purchased it.
7. After opening the oil container, be sure to seal it to prevent dust and water from getting into the oil and keep it in the dark to avoid direct sunlight.

## WARNING



### ⑤ Before starting the machine





#### Machine table

1. Before turning the power on, visually check the cables and connectors for defective conditions, such as damage, disconnection and/or loosening.
  2. Never bring your hands close to the needle and/or pulley when turning on the power.
  3. When the machine is used for the first time, turn on the power and then check the rotating direction of the machine pulley.  
The machine pulley should turn clockwise as seen from the machine pulley.
- 
4. Well trained operators should use the machine after studying these precautions and the instruction manual carefully.
  5. Regarding symbols that indicate a danger or a warning, read and study "2. Warning indications" carefully and give training on safety to the operators as required.
  6. Run the machine at the speed less than 3/4 of its maximum for the first one month.

## WARNING



### ⑥ Precautions while you are running the machine

1.  Do not run the machine with the safety devices removed, such as eye guard, finger guard, pulley cover, etc.
2.  Never bring your hands under the needle while running the machine.

3. A clutch motor keeps on running for a while after the power is turned off. Therefore, be careful even after the power is turned off as the machine could start running by pressing the machine treadle.
4.  To prevent accidents, never bring any part of your fingers, hair and clothes near the machine pulley, V belt, motor pulley, thread take-up and needle bar. Also never leave scissors, tweezers, tools, etc. around these areas.
5. If you use the machine with the HG device, be careful that any part of your fingers is not caught in the guide when the guide is opened/closed.
6.  If you use the machine with the RP device, be careful that any part of your fingers and hair are not caught in the roller during sewing. Also be extremely careful that any part of your hands and fingers are not caught in the roller when the roller is raised and then lowered again.
7.  If you use the machine with the FT device, do not bring any part of your hands and fingers too close to the FT during sewing. Otherwise it may cause accidents and physical injury.
8. Always turn off the power while the machine is not used or before leaving the machine table.
9. In the event of a power failure, be sure to turn off the power.
10. While operating the machine, wear clothes that cannot be caught in the machine.
11.  Do not put any tools or other unnecessary objects on the machine table while running the machine.

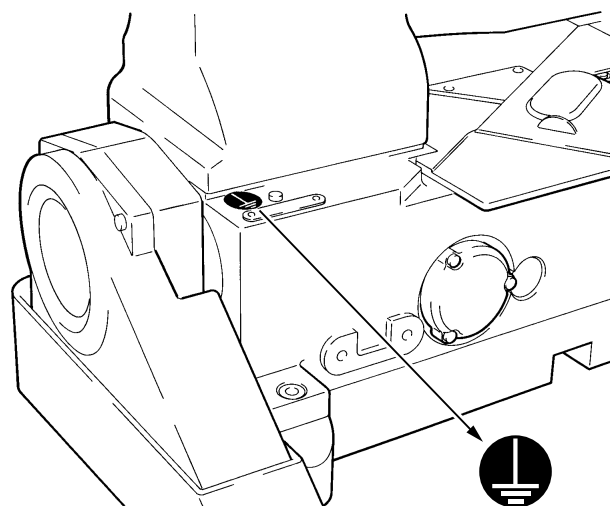
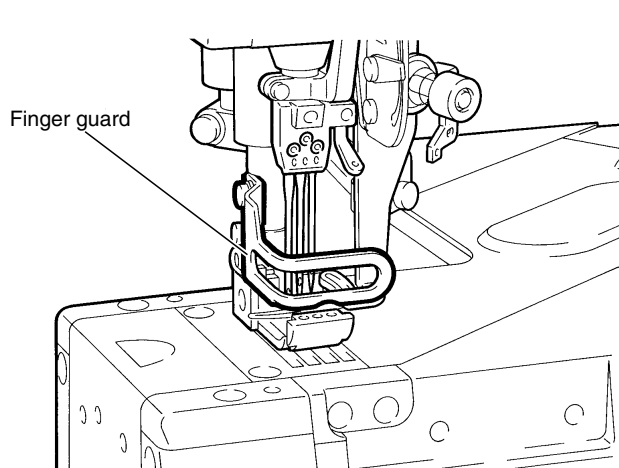
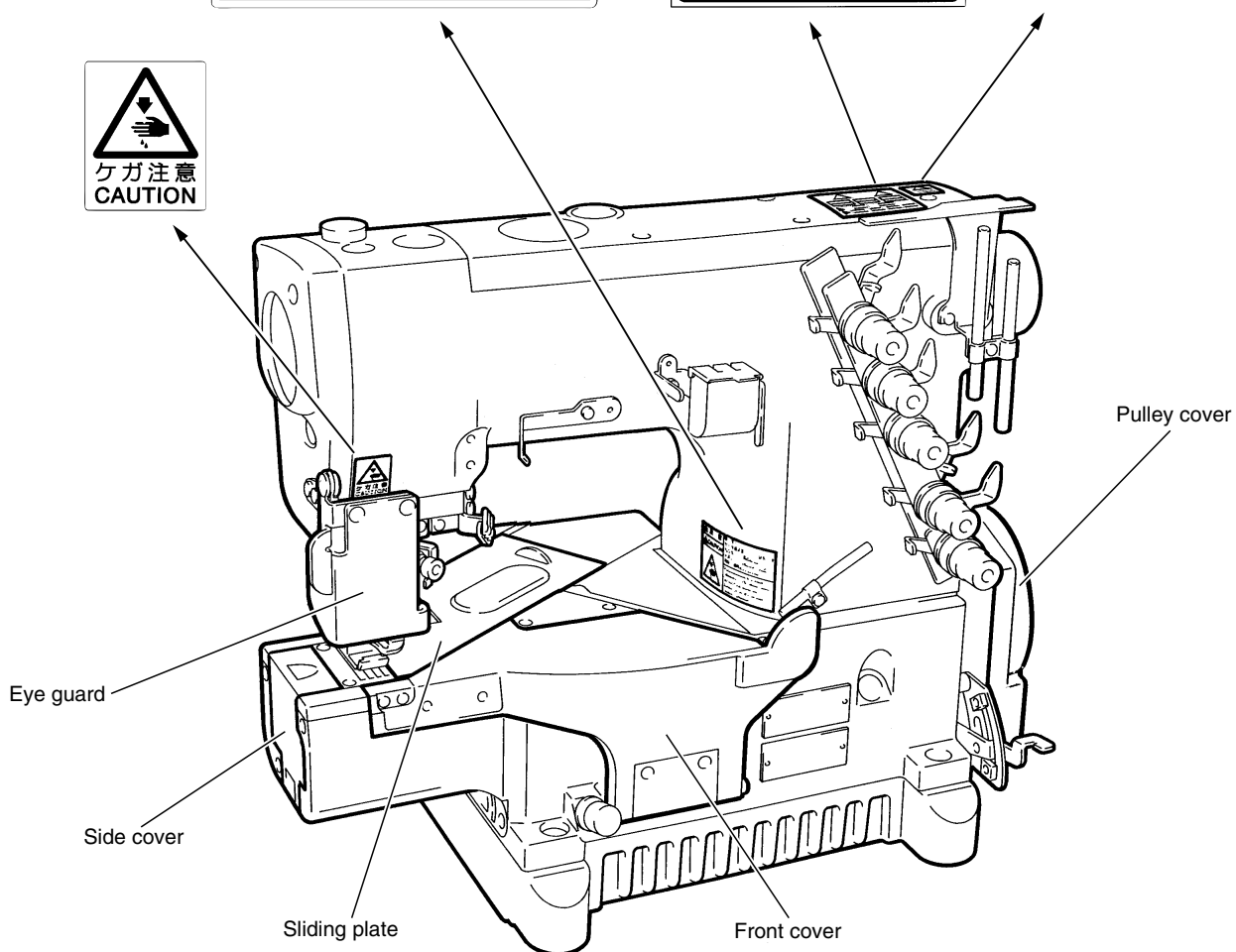
## CAUTION

### ⑦ Maintenance, Check, Repair

1. Well trained people should perform maintenance, check and repair of the machine after studying these precautions and the instruction manual carefully.
2.  If it is necessary to lay the machine backward for maintenance, check and repair, always turn off the power, unplug the machine and press the treadle to make sure that the machine does not operate before beginning any of the procedures.
3.  Before installing/removing the V belt, always turn off the power, unplug the machine and press the treadle to make sure the machine does not operate.
4. Carry out daily maintenance work and periodical inspections properly by following these precautions and the instruction manual.
5. Employ Pegasus' genuine parts when repairing the machine and/or replacing the parts. We are not responsible for accidents caused by any improper repair/adjustment and substituting other parts for those manufactured by Pegasus.
6. Do not attempt to modify the machine at your own discretion. We are not responsible for accidents caused by the modification.
7. Be sure to replace the safety devices and/or safety covers that are temporarily removed for maintenance and/or adjustment.
8. After performing maintenance, check and repair, make sure that turning on the power does not pose any danger to you.

//////// Be sure to study very carefully **for safety.** //////////

## 5. Location of warning labels and safety devices



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## 6.Protectors for safety

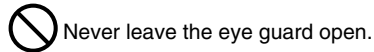
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This chapter describes each protector for safety. Therefore, read and study the following carefully.



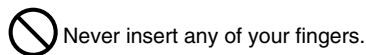
### Protectors for safety

#### (1) Eye guard



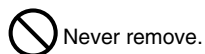
For the safety of eyes, do not operate the machine with the eye guard open. The eye guard will prevent any pieces of the broken needle from getting into your eyes if the needle should break during sewing.

#### (2) Finger guard



To prevent the needle that moves up and down from contacting any of your body, the finger guard is installed close to the needle. However, there is clearance above the finger guard for easy threading. Be careful that the needle may penetrate any of your fingers if you insert it into this clearance.

#### (3) Pulley cover

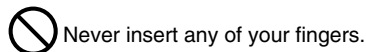


The machine pulley and V belt are covered with the pulley cover. The machine pulley and the V belt rotate at high speed during sewing. To prevent accidents, operate the machine with the pulley cover installed in place.

#### (4) Pulley

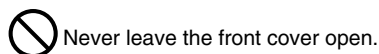
Check the direction in which the machine pulley rotates. It should rotate clockwise as seen from the pulley.

#### (5) Presser foot



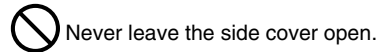
There is a clearance of more than 5mm between the top surface of the needle plate and the presser foot. Be careful that none of your fingers are caught in this clearance. Never insert any of your fingers under the presser foot when raising the presser foot with the knee switch or automatically raising it with the treadle.

#### (6)Front cover



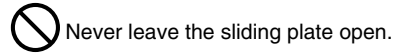
The looper travels left to right while drawing an arc as seen from the front of the machine. To prevent the looper from contacting any part of your body, be sure to operate the machine with the front cover closed securely.

#### (7) Side cover



The looper travels left to right while drawing an arc as seen from the front of the machine. To prevent the looper from contacting any of your body, be sure to operate the machine with the side cover closed securely.

#### (8) Sliding plate

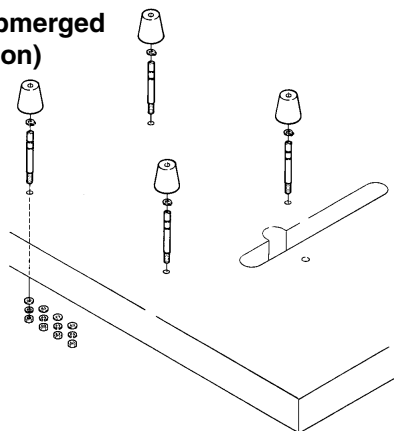


The looper thread take-up rotates in order to supply the required amount of looper thread during sewing. To prevent the looper thread take-up from contacting any of your body, be sure to operate the machine with the sliding plate closed securely.

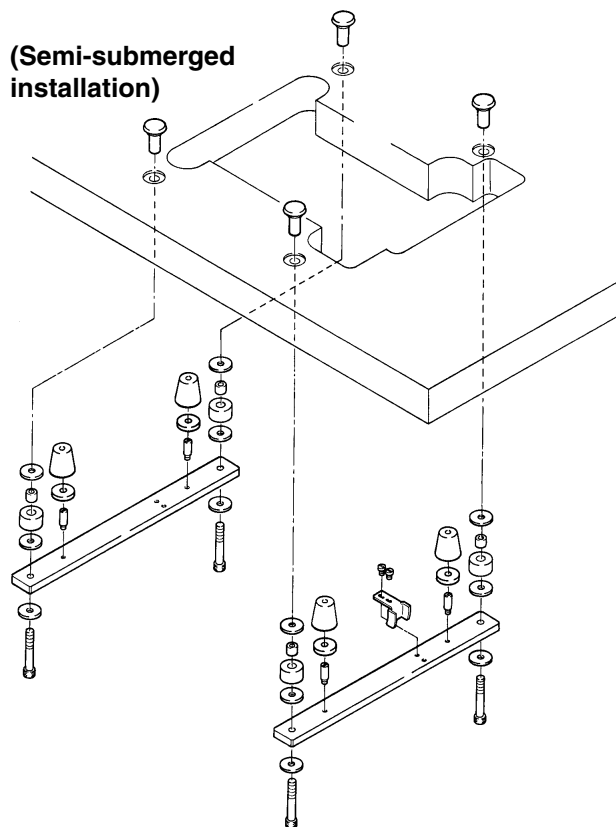
## Assembling the machine rest board

Assemble the components comprising the machine rest board by referring to the illustration below. Be sure to secure all rods, nuts and bolts firmly with no shake.

### (Non-submerged installation)



### (Semi-submerged installation)



## Sewing machine installation

### CAUTION



Always turn off the power, unplug the machine and then well-qualified technicians should install the machine.

Mount the machine on the machine rest board first. Put the V belt in place. Position the machine motor so that an approx. 2cm deflection can be obtained by pressing the center of the belt (see the illustration).

### Installing the belt cover

### CAUTION

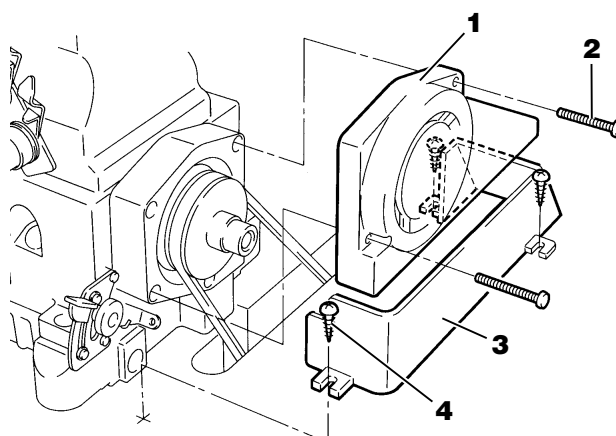
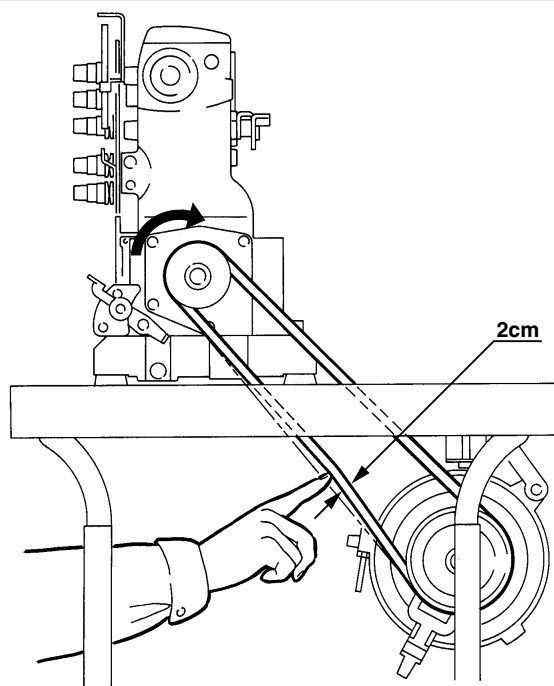


Always turn off the power, unplug the machine and then well-qualified technicians should install the belt cover.

Install belt cover **1** on the machine with screws **2**.  
For non-submerged installation, install belt guard **3** onto the machine table with wood screws **4**.

### Operating direction of the machine pulley

The machine pulley rotates clockwise as seen from the end of the machine pulley.



## Lubrication

### 1. Oil

Use the oil "HIGH SPEED SEWING MACHINE OIL" specified by Pegasus (ISO Viscosity Grade 22).

### 2. To fill the machine with oil

Remove cap **1**.

Add the oil until the oil level (see oil gauge **2**) reaches (H).

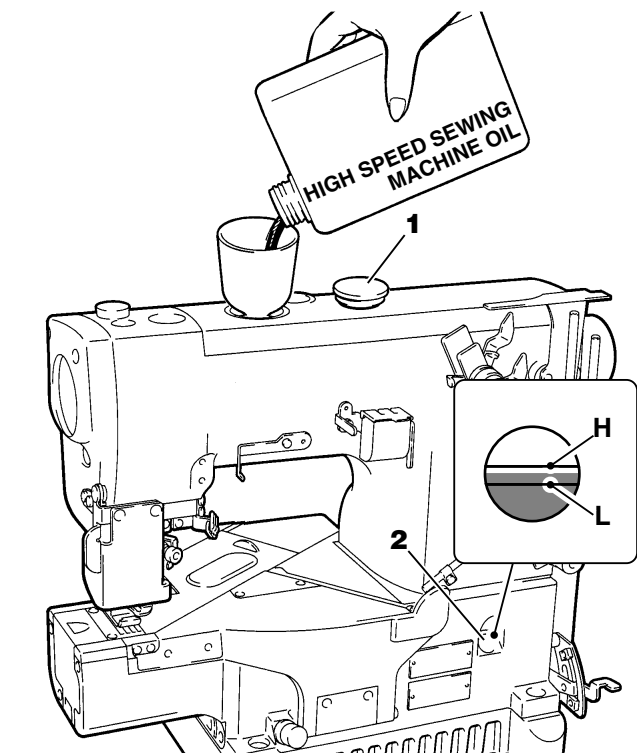
After filling the tank with oil, replace cap **1**.

### 3. Required amount of oil

(H) on oil gauge **2**: Upper limit

(L) on oil gauge **2**: Lower limit

The oil level should always lie between (H) and (L).

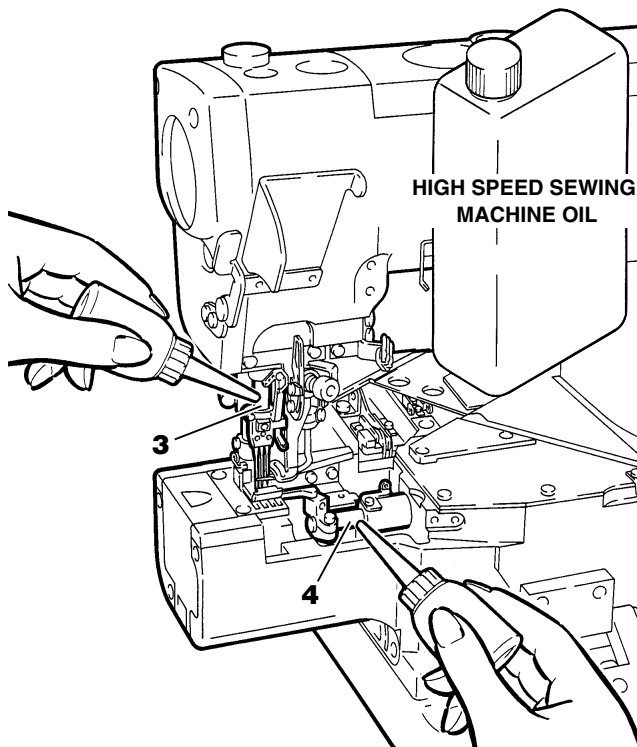


### 4. Manual lubrication



Always turn off the power and unplug the machine when you apply oil by hand.

Apply two or three drops of oil to needle bar **3** and looper shaft **4** by hand when the machine is used for the first time or left unused for some time.

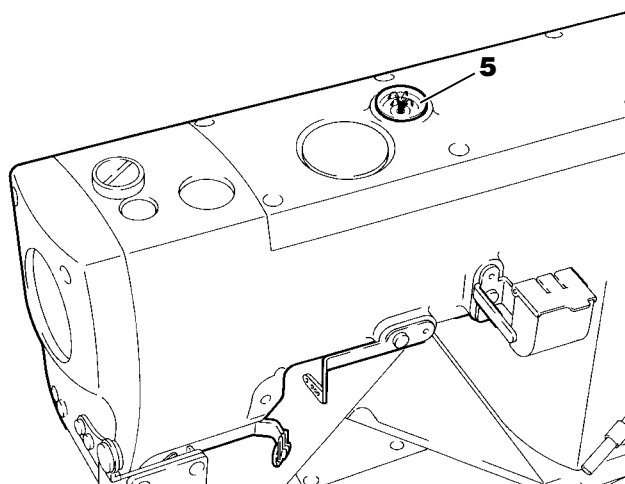


### 5. Checking oil circulation

Once the machine has been properly filled with oil, press the machine treadle to run the machine and check oil gauge window **5** to see if the oil is flowing.

#### Note

If oil is not splashing, check the oil filter by referring to "Replacing the oil filter" on page 16.



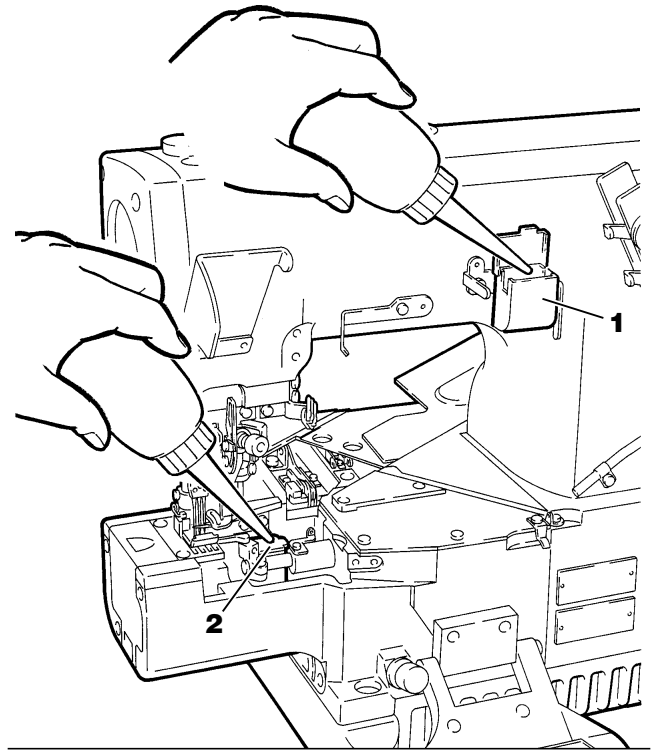
## Silicone oil for H.R. device



Always turn off the power and unplug the machine when you fill the HR device with silicone oil.

Fill silicone oil tanks **1**, **2** with silicone oil.

To prevent thread breakage or fabric damage, add the silicone oil before it is too low.

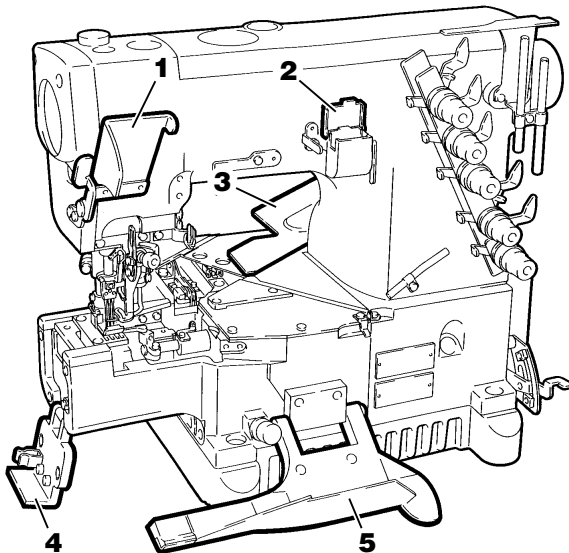


## Threading

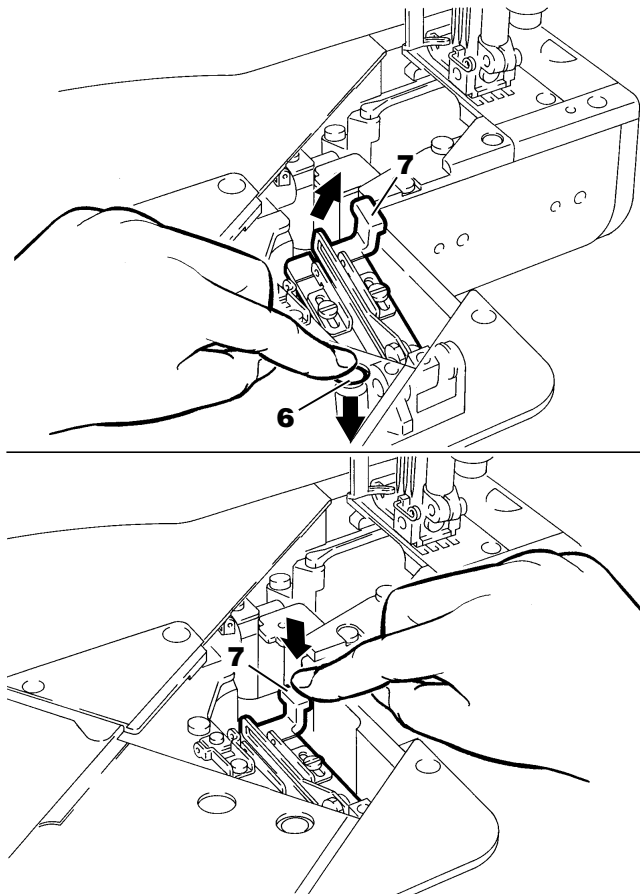


Always turn off the power and unplug the machine when you thread the machine.

1. Open eye guard 1 and covers 2, 3, 4 and 5.



2. Press button 6 once. Bracket 7 pops out. Press bracket 7 into place after threading the machine.



### 3. In case the machine is threaded previously

Be sure to thread the machine correctly by referring to the threading diagram. (See page 13)

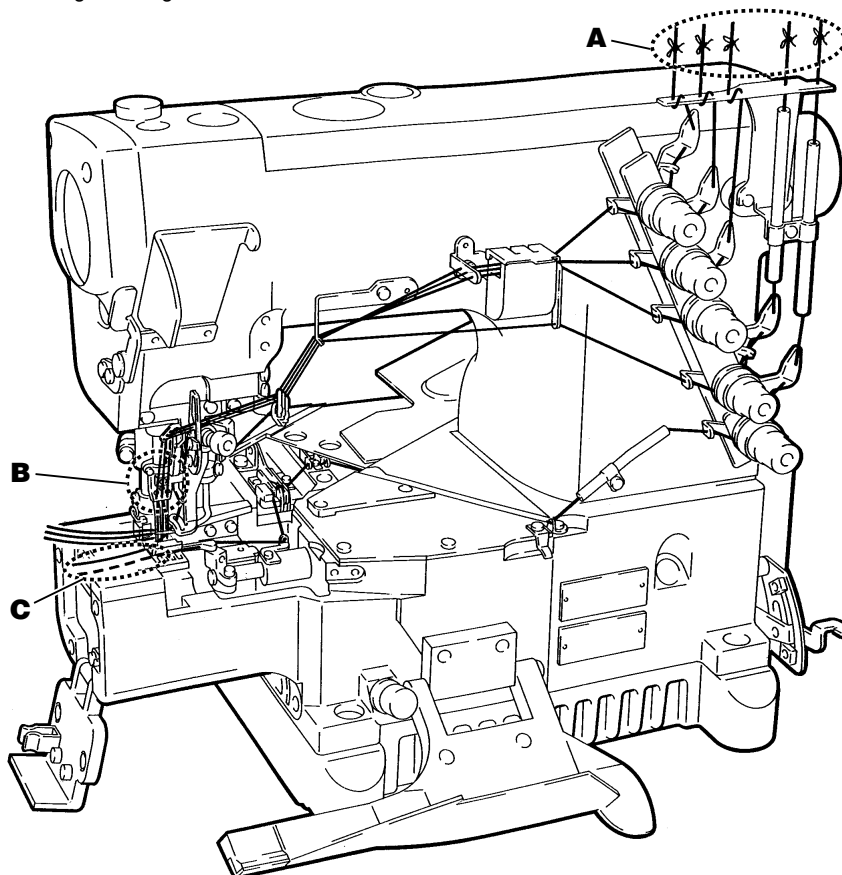
**A :** Knot the preset thread and the thread being used together to thread the machine.

#### **B : Needle thread**

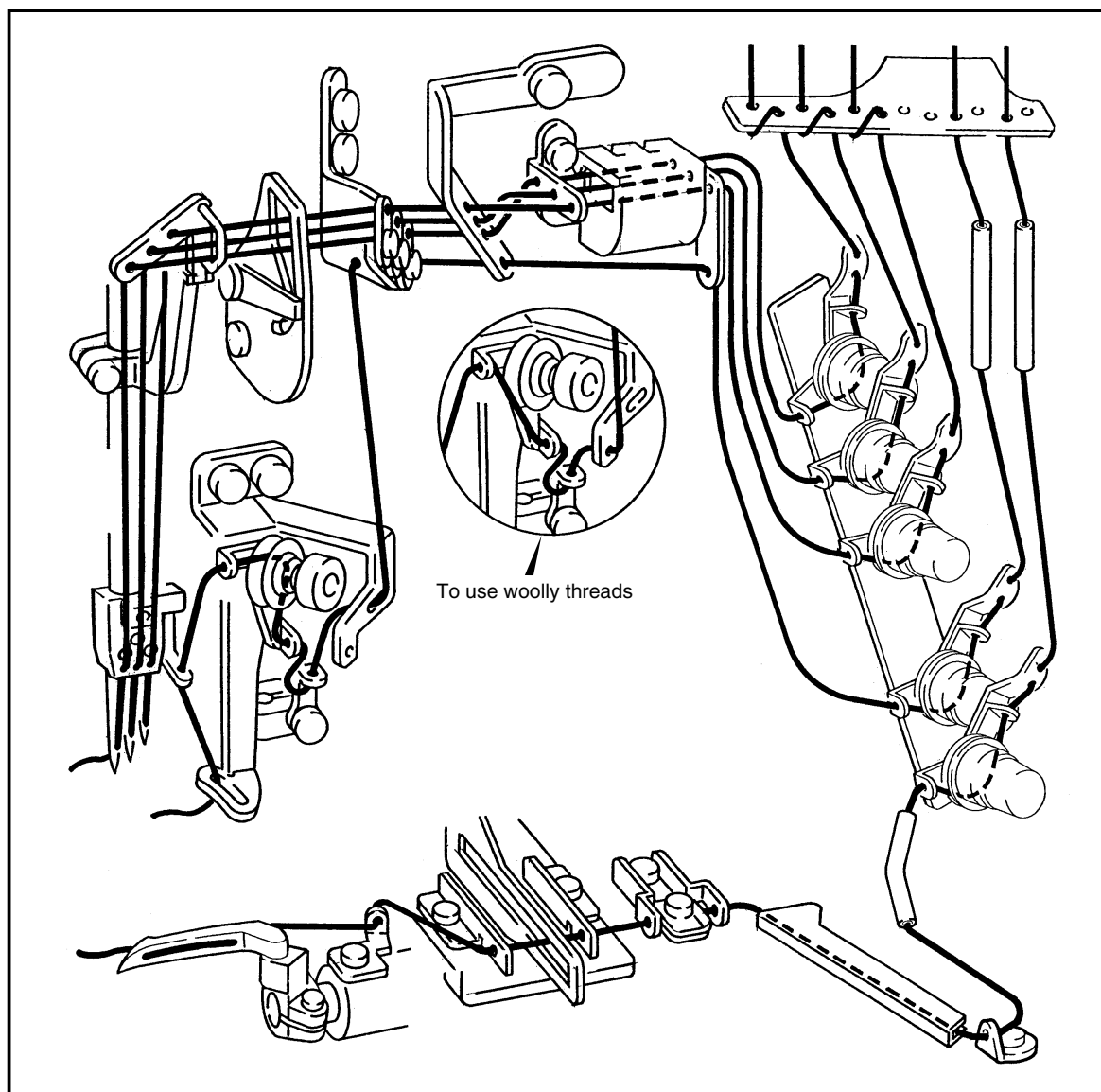
Trim the knots off neatly before passing through the eye of the needle to rethread.

#### **c : Looper thread, Top cover thread**

Trim the knots off neatly after passing through the eye of the looper.



#### 4. Threading diagram

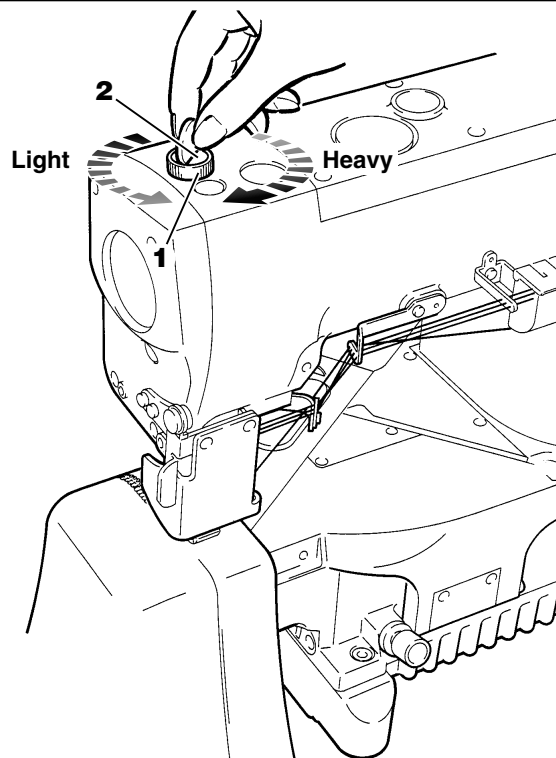




## Adjusting presser foot pressure

The presser foot pressure should be as light as possible, yet sufficient to feed the fabric correctly and provide the uniform stitch formation.

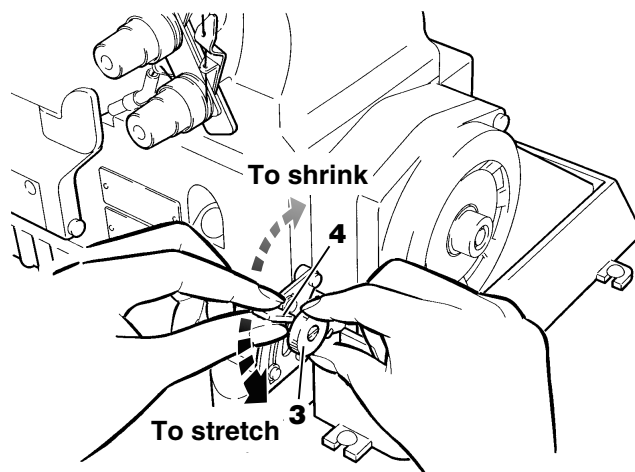
Loosen nut **1**. Adjust the presser foot pressure. Adjustment is made by turning screw **2** clockwise or counterclockwise using a coin. Tighten nut **1**.



## Adjusting the differential feed ratio

1. Loosen nut **3**. Adjust the differential feed ratio.  
To increase the differential feed ratio, raise lever **4**.  
The finished fabric is shrunk.  
To decrease the differential feed ratio, lower lever **4**.  
The finished fabric is stretched.

2. After this adjustment tighten nut **3**.



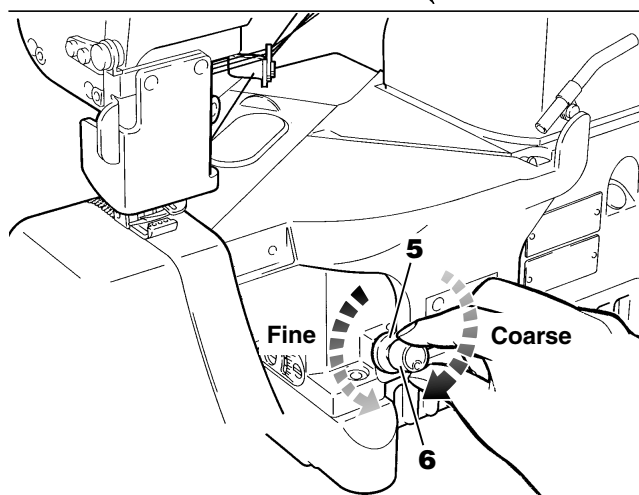
## Adjusting stitch length

Loosen nut **5**.

To make the stitch length coarse, turn knob **6** clockwise.

To make the stitch length fine, turn knob **6** counterclockwise.

After this adjustment tighten nut **5**.



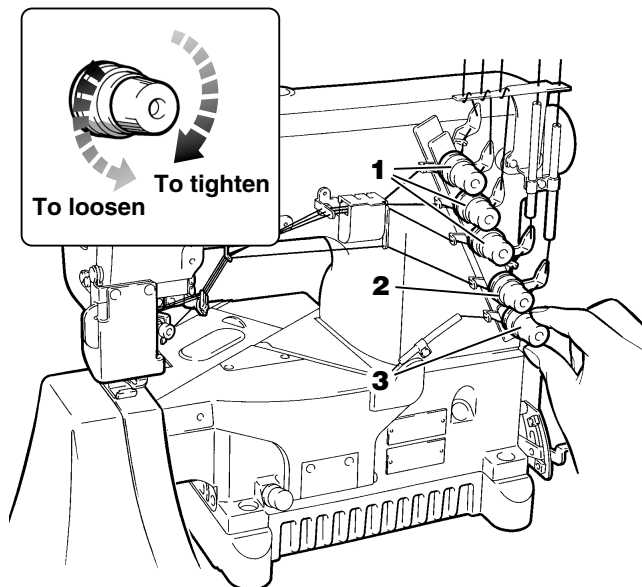
## Adjusting the thread tension

To obtain the proper thread tension, adjust needle thread tension knobs **1**, top cover thread tension knobs **2** and looper thread tension knob **3**.

To tighten the thread, turn each knob clockwise.

To loosen the thread, turn each knob counterclockwise.

Each thread tension should be as light as possible, yet be sufficient to produce balanced and beautiful stitches.

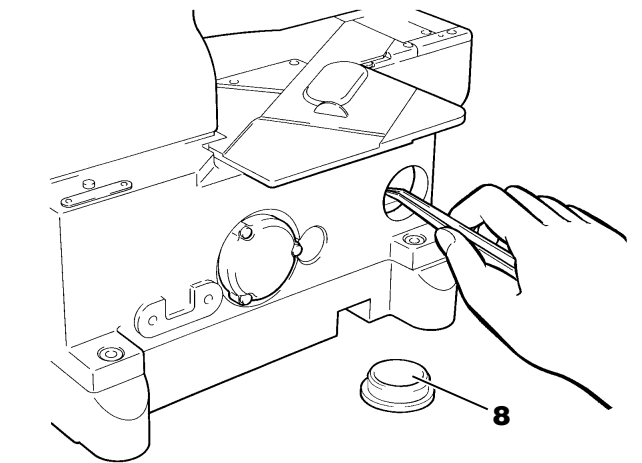
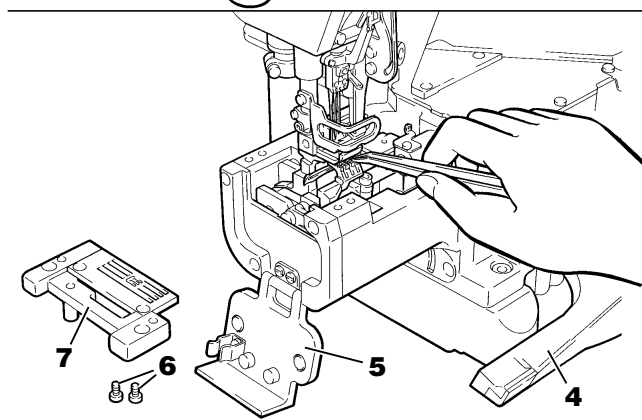


## Cleaning the machine



Always turn off the power and unplug the machine when you clean the machine.

1. Open covers **4** and **5**. Loosen screws **6**. Remove needle plate bracket **7**.
2. Clean the grooves of the needle plate and the area around the feed dogs.
3. Replace needle plate bracket **7** into place. Tighten screws **6**. Then close covers **4** and **5**.
4. Remove rubber plug **8**. Clean the inside. Replace rubber plug **8** into place.

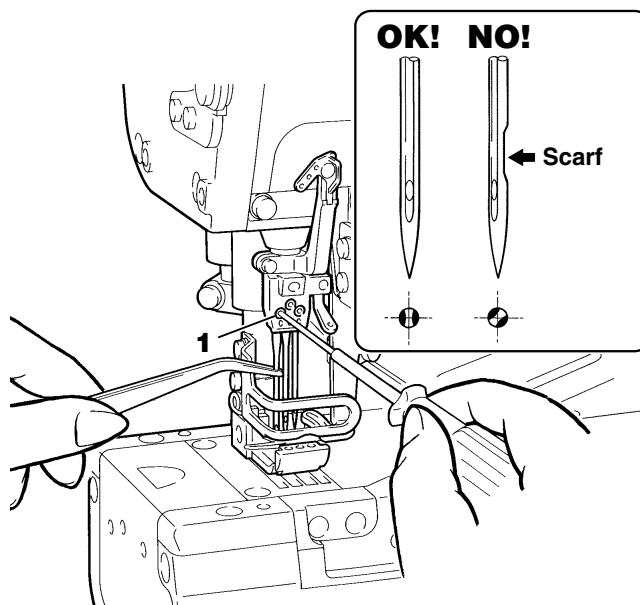
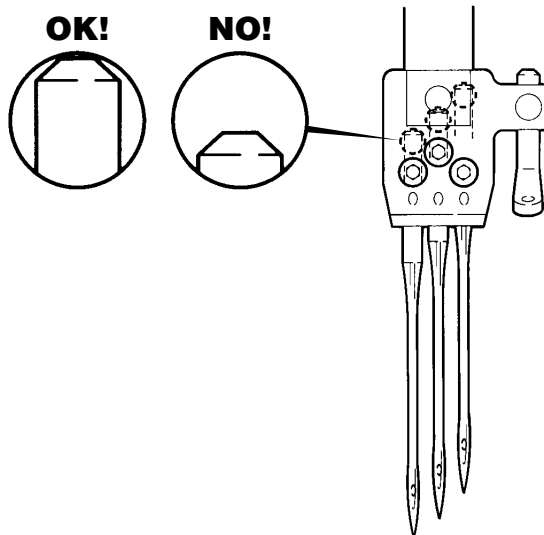


## Replacing the needle



Always turn off the power and unplug the machine when you replace the needle(s).

1. Loosen screw(s) **1** using a red-handled key wrench (1.5mm).
2. Remove the old needle(s) by using a pincette (provided as accessories).
3. Fix the needle so that its scarf faces the rear side of machine.
4. Insert a new needle into the needle hole as far it will go by using a pincette.
5. Tighten screw(s) **1** using a red-handled key wrench (1.5mm).



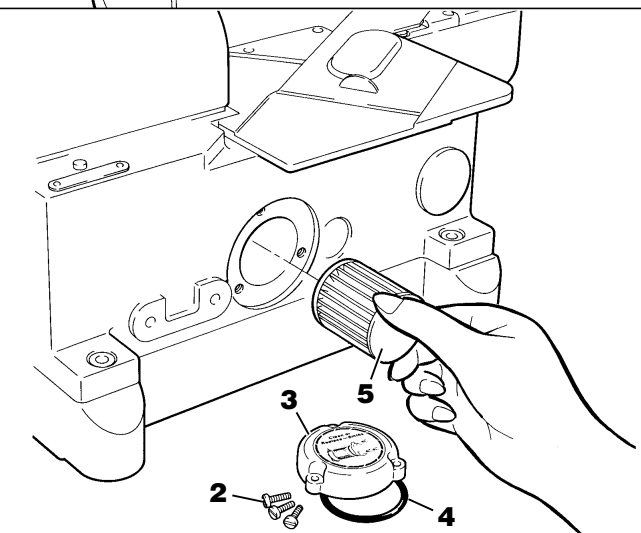
## Replacing the oil filter



Always turn off the power and unplug the machine when you check or replace the filter.

Remove screws **2**, cover **3**, O ring **4** and filter **5**. Check filter **5**. Replace the filter if necessary. After checking or replacing the filter, put filter **5**, O ring **4**, cover **3** and screws **2** back into place.

Contaminants on oil filter **5** may cause improper lubrication. Check and clean oil filter **5** every six months by removing **2** to **5**.

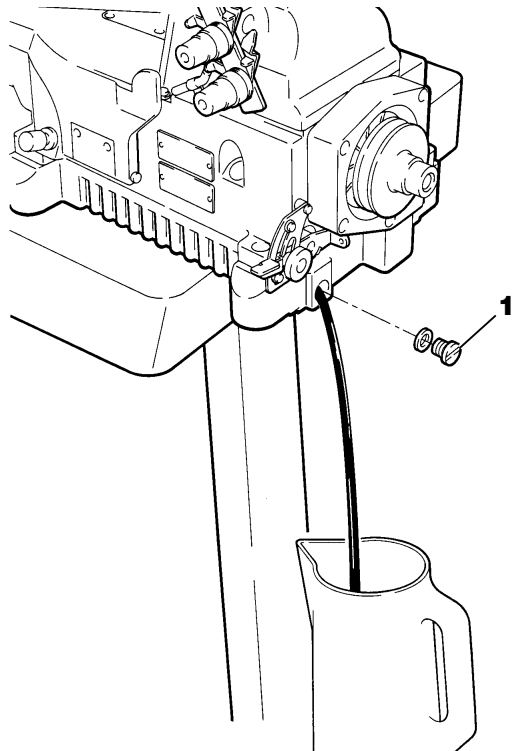


## Oil replacement

Replace the oil one month after the first use and thereafter every six months. If you keep using the old oil, it may cause the damage to the machine.

### To drain the oil

1. Drain the oil by removing screw **1** on the left side of the oil pan.
2. Tighten screw **1** after draining.



## Adjusting the needle thread guard



Always turn off the power, unplug the machine and then well-qualified technicians should adjust the needle thread guard.

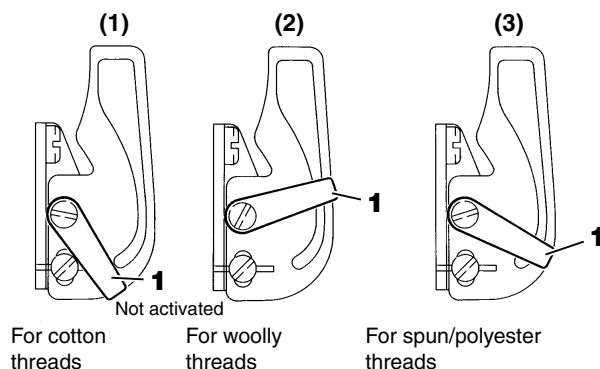
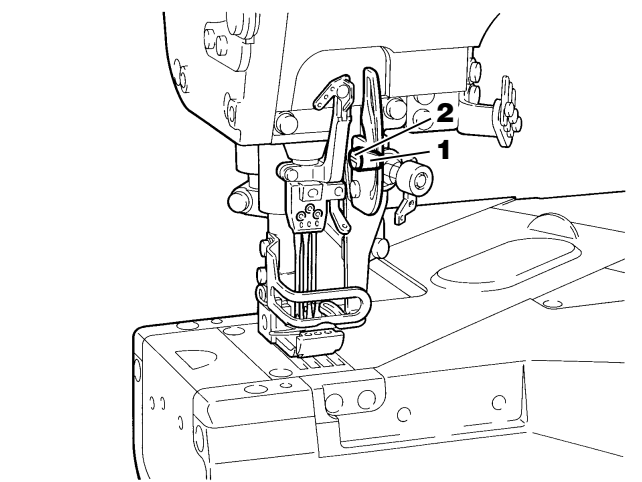
Loosen screw **2**. Adjust needle thread guard **1** to the appropriate position according to the type of thread being used (see the illustration right). Tighten screw **2** temporarily.

- To decrease the size of the needle thread loop, move needle thread guard **1** up.
- To increase the size of the needle thread loop, move needle thread guard **1** down.

Move guard **1** up and down so that the needle thread loop is formed properly.

Tighten screw **2** after this adjustment.

- (1) In the case of the threads that are not stretchable, such as cotton threads (The needle thread loop tends to be formed large and lie down.)
- (2) In the case of the stretchable threads, such as woolly threads (The needle thread loop tends to be formed small.)
- (3) In the case of the threads that are slightly stretchable, such as spun threads

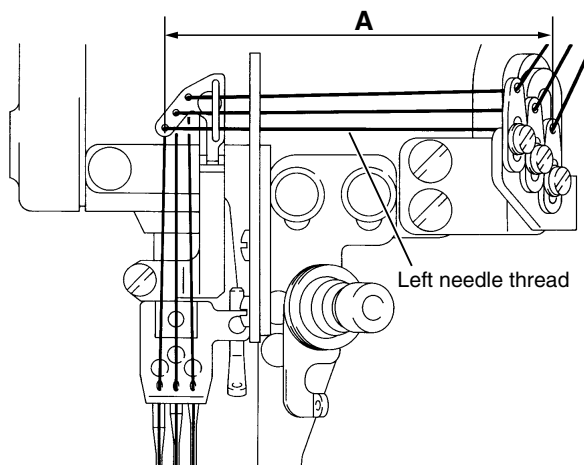
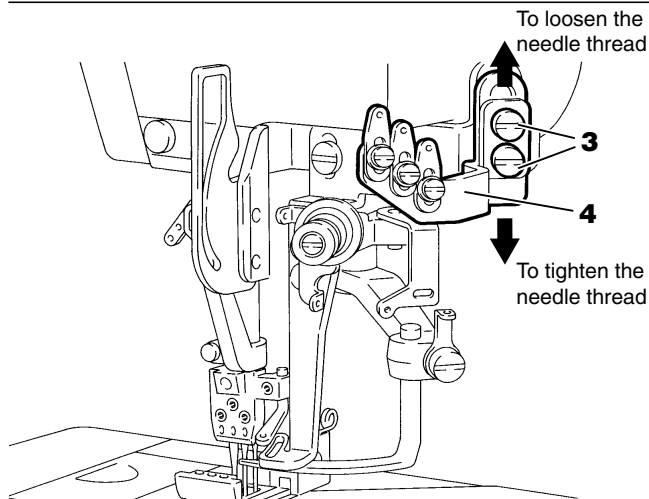


## Adjusting the needle thread guides

Loosen screws **3**. When the needles are at the top of their stroke, adjust the needle thread guide (see the illustration on the right) so that the left needle thread is horizontal within range **A** (standard position). After this adjustment is made, tighten screws **3** temporarily.

- To loosen the needle thread, move needle thread guide **4** up.
- To tighten the needle thread, move needle thread guide **4** down.

Tighten screws **3** after this adjustment.



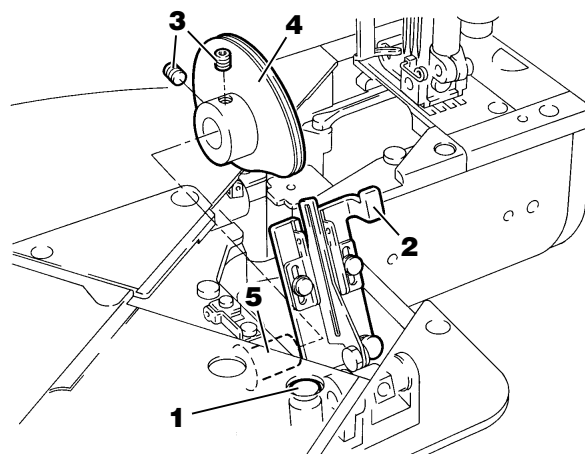
## Removing and reinstalling the looper thread take-up



Always turn off the power, unplug the machine and then well-qualified technicians should remove/reinstall the looper thread take-up.

### To remove the looper thread take-up

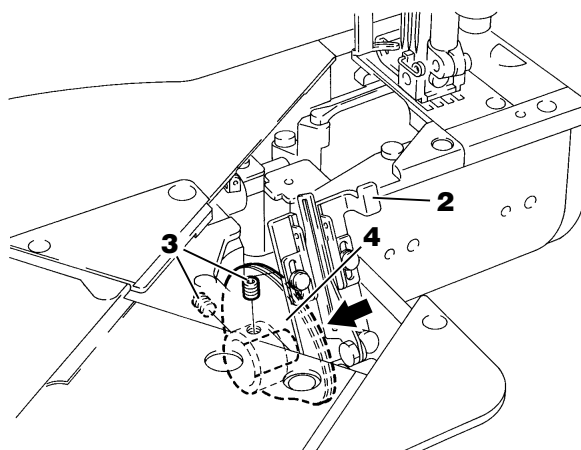
1. Raise looper thread take-up bracket **2** by pressing push button **1** twice.
2. Loosen screws **3**. Remove looper thread take-up **4**.



### To reinstall the looper thread take-up

1. Fit looper thread take-up **4** onto shaft **5**.
2. Tighten screws **3** while pressing looper thread take-up **4** in the direction of the arrow.
3. Put looper thread take-up bracket **2** back into place.

※After reinstalling the looper thread take-up, be sure to readjust it by referring to "Adjusting the looper thread take-up".



## Adjusting the looper thread take-up

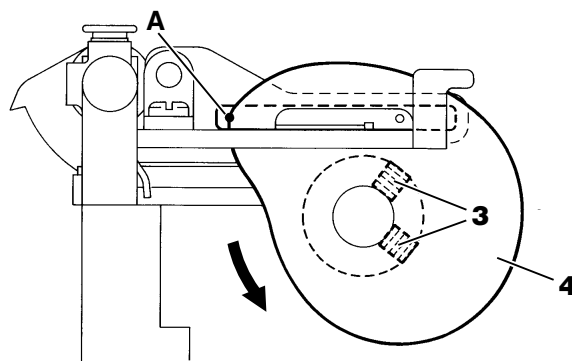


Always turn off the power, unplug the machine and then well-qualified technicians should adjust the looper thread take-up.

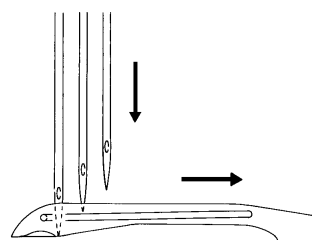
When the left needle has reached the point shown in the illustration while the looper is moving to the right from the extreme left end of its travel, the looper thread should be released from point **A** on the looper thread take-up.

To make this adjustment, loosen screws **3** and turn looper thread take-up **4** as required.

After the above adjustment, tighten screw **3**.



**Position of the point of the left needle when the looper thread is released from point A on looper thread take-up 4.**



The point of the left needle has reached the bottom end of the looper blade.

## Adjusting the looper thread guides



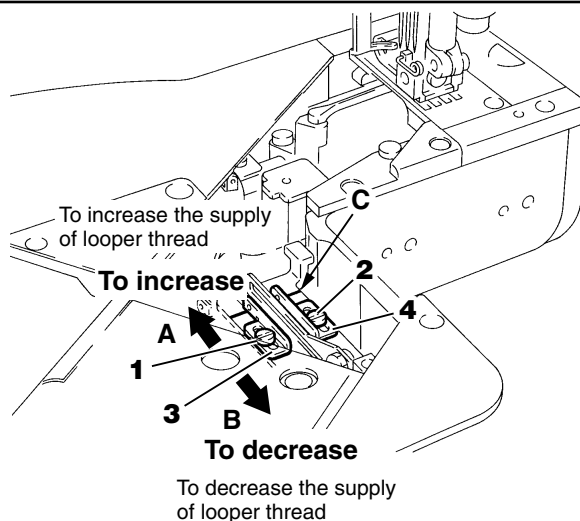
Always turn off the power, unplug the machine and then well-qualified technicians should adjust the looper thread guides.

Loosen screws **1** and **2** (see the illustration below). Align each eyelet on looper thread guides **3** and **4** with alignment mark **C** (standard position).

After this adjustment is made, tighten screws **1** and **2** temporarily.


- To increase the supply of looper thread, move looper thread guides **3** and **4** in the direction of **A**.
- To decrease the supply of looper thread, move looper thread guides **3** and **4** in the direction of **B**.

After this adjustment is made, tighten screws **1** and **2**.



## Adjusting the spreader

### CAUTION

 Always turn off the power, unplug the machine and then well-qualified technicians should adjust the spreader.

#### 1. To adjust the spreader

(1) To adjust the spreader height :

Adjust distance **A** from the top surface of the needle plate to the bottom surface of spreader **1**. Select the distance according to the machine being used by referring to the table of adjustment dimensions (see page 30). Adjustment is made by loosening screw **2** and moving spreader **1** up or down.

After the above adjustment is made, tighten screw **2** temporarily.

To adjust the spreader front to back :

When point **B** on the spreader has come close to the left needle while spreader **1** is moving to the left from the extreme right end of its travel, there should be a distance of 0.5mm from point **B** to the left needle. Adjustment is made by moving spreader **1** front to back.

After this adjustment is made, tighten screw **2**.

(2) Left-to-right adjustment

When spreader **1** is at the extreme left end of its travel, there should be a distance of 5.0mm from the center line of the left needle to point **B** on the spreader. Adjustment is made by loosening screw **3** and moving spreader **1** left to right.

After this adjustment is made, tighten screw **3**.

#### 2. Adjusting the spreader thread guide

(1) When spreader **1** is at the extreme right end of its travel, there should be a clearance of 0.5mm between the bottom surface of spreader thread guide **5** and spreader **1**. Adjustment is made by loosening screws **7**. After this adjustment is made, tighten screws **7** temporarily.

(2) Align the center of the slot of spreader thread guide **5** with point **B** on the spreader. Adjustment is made by moving spreader thread guide **5** left to right. After this adjustment is made, tighten screws **7**.

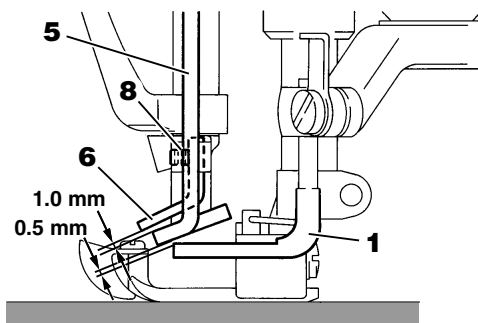
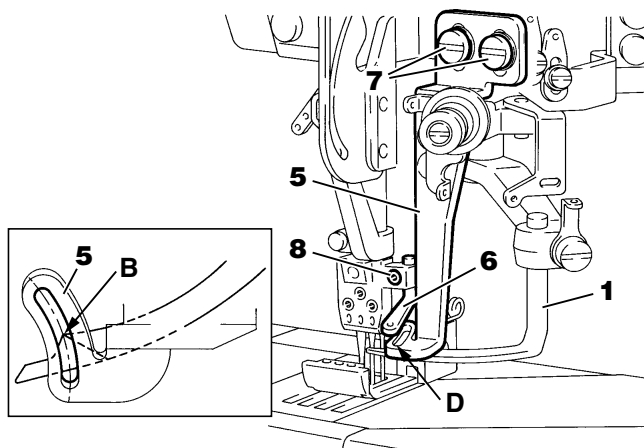
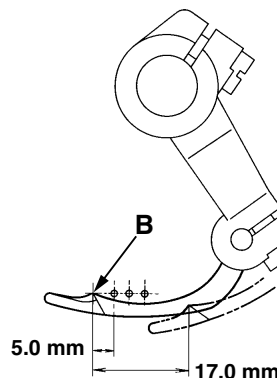
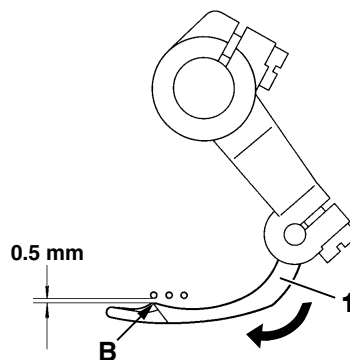
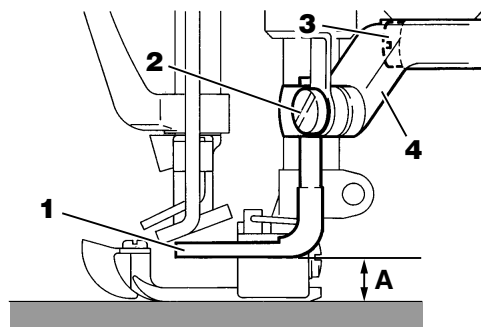
#### 3. Adjusting the thread guide

(1) When the needles are at the bottom of their stroke, position thread guide **6** just above front end **D** of the slot on thread guide **5**. Adjustment is made by loosening screw **8**.

After this adjustment is made, tighten screw **8** temporarily.

(2) There should be a clearance of 1.0mm between thread guide **6** and spreader thread guide **5**. Adjustment is made by moving thread guide **6** front to back.

After this adjustment is made, tighten screw **8**.





## Adjusting the top cover thread guide



Always turn off the power, unplug the machine and then well-qualified technicians should adjust the top cover thread guide.

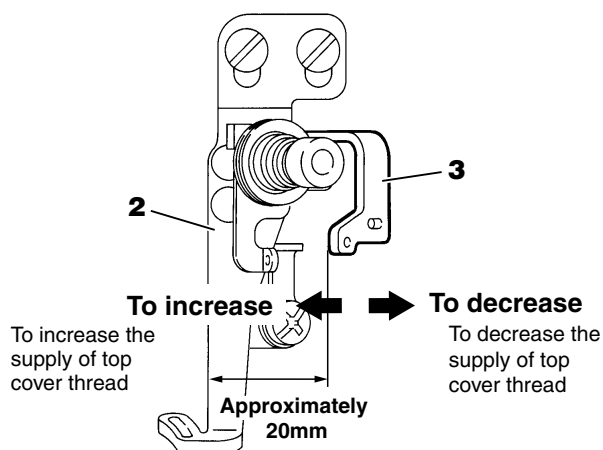
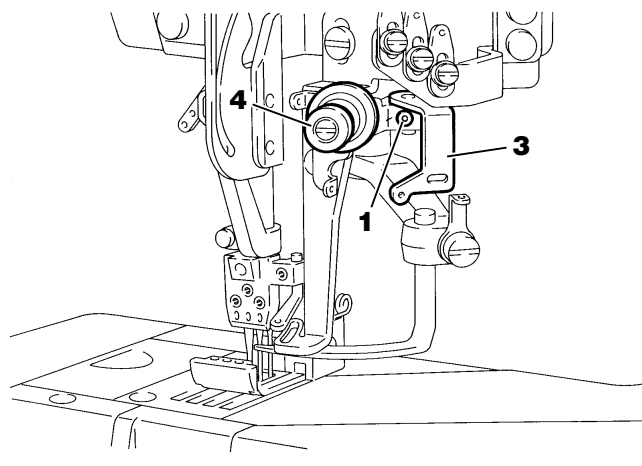
Loosen screw **1** so that there should be a distance of approximately 20mm (see the illustration) between the left end of spreader thread guide **2** and the left end of top cover thread guide **3** (standard position). Then, tighten screw **1** temporarily.

- To decrease the supply of top cover thread, move top cover thread guide **3** to the right.
- To increase the supply of top cover thread, move top cover thread guide **3** to the left.

Tighten screw **1** after this adjustment.


A fine adjustment can be made by knob **4**.

- To decrease the supply of top cover thread, turn knob **4** clockwise.
- To increase the supply of top cover thread, turn knob **4** counterclockwise.



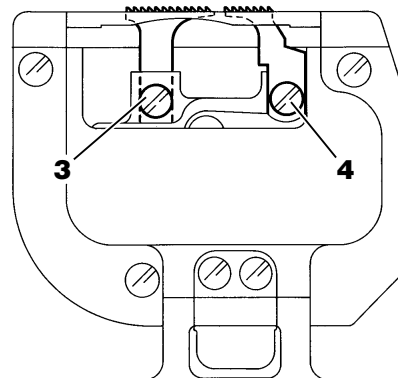
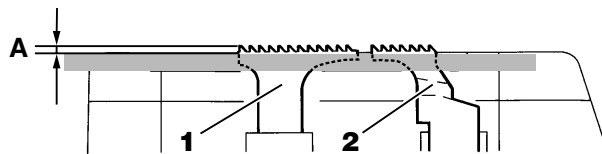
## Adjusting the feed dog height

### CAUTION

 Always turn off the power, unplug the machine and then well-qualified technicians should adjust the feed dog height.


When the feed dogs are at their highest point of travel, there should be a distance of 0.8~1.2mm from the top surface of the needle plate to extended line **A** from the tips of main **1** and differential **2** feed dogs. Adjustment is made by loosening screws **3** and **4**, and moving feed dogs **1** and **2** up or down.

After the above adjustment, tighten screws **3** and **4**.



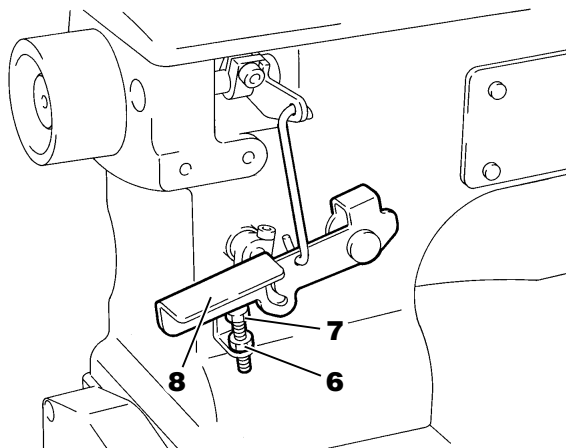
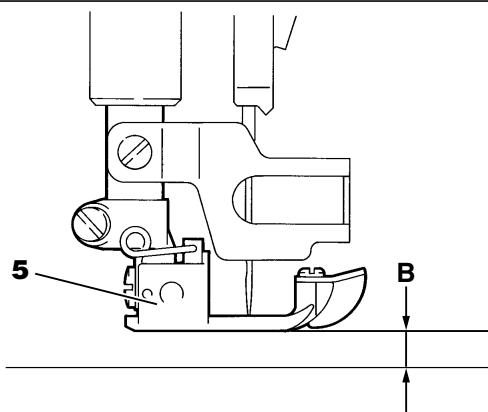
## Adjusting the presser foot lift

### CAUTION

 Always turn off the power, unplug the machine and then well-qualified technicians should adjust the presser foot lift.


When presser foot **5** is raised, adjust distance **B** from the top surface of the needle plate to the bottom surface of the presser foot. Select the distance according to the machine being used by referring to the specifications (see page 31).

1. Turn the machine pulley until the feed dogs are at their lowest point of travel.
2. Adjust the presser foot lift by lowering lever **8**.  
Note that the presser foot should not be in contact with the spreader.
3. Loosen nut **6**. Adjust screw **7** so that it contacts lever **8**. Then tighten nut **6**.



## Adjusting the needle height

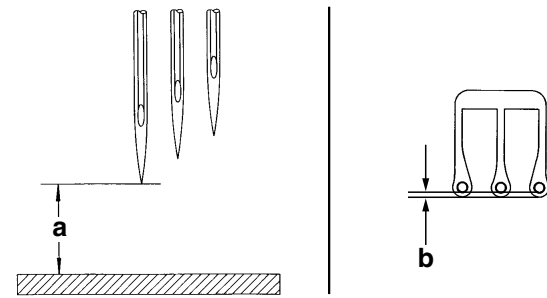
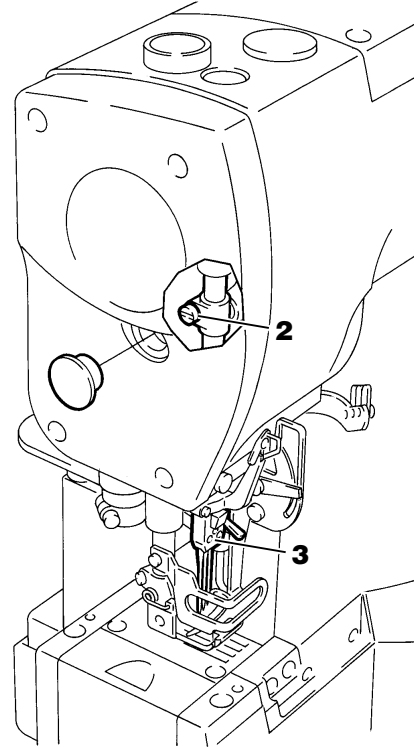
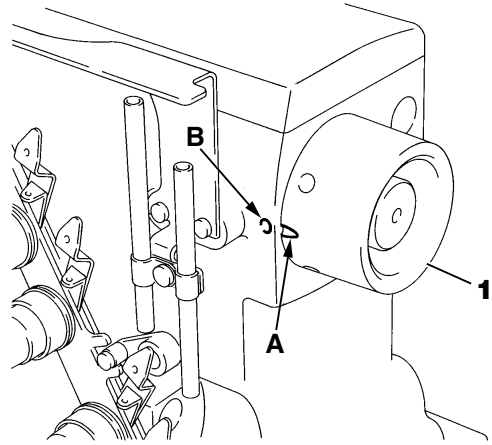
### CAUTION

 Always turn off the power, unplug the machine and then well-qualified technicians should adjust the needle height.

Adjust distance **a** from the point of the left needle to the top surface of the needle plate when the needle is at the top of its stroke.  
The distance varies according to the machine being used.  
Refer to the table of adjustment dimensions (see page 30).


1. Turn handwheel **1** and align mark **B** on the machine with mark **A** on the handwheel to bring the needle bar to the top of its stroke.
2. Loosen screw **2**. Adjust the needle height by moving needle holder **3** up or down.

● Adjust the relationship between each needle and needle drop hole so that clearance **b** is equal after the needle height adjustment (see the illustration). Then tighten screw **2**.



## Adjusting the looper

### CAUTION

 Always turn off the power, unplug the machine and then well-qualified technicians should adjust the looper.

#### 1. Adjusting the looper-needle setting distance

Adjust looper-needle setting distance **A** from the center of the right needle to the point of looper **1** when the looper is at its farthest position to the right. Select the distance according to the machine being used by referring to the table of adjustment dimensions (see page 30).

Adjustment is made by loosening screw **3** on looper holder **2** and moving looper holder **2** to the left or right. After the adjustment, tighten screw **3**.

#### 2. Adjusting the looper avoiding distance

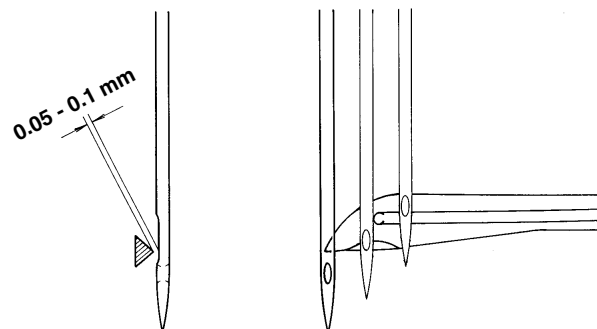
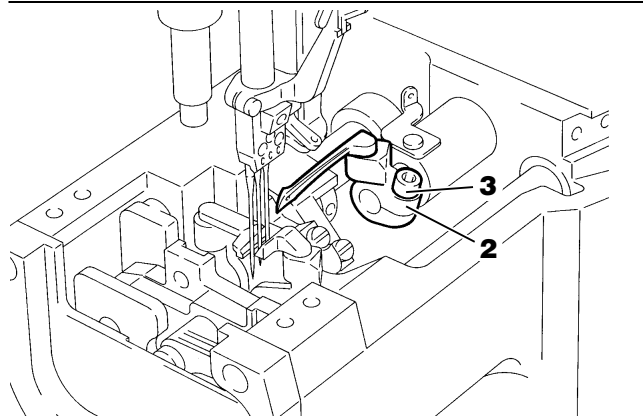
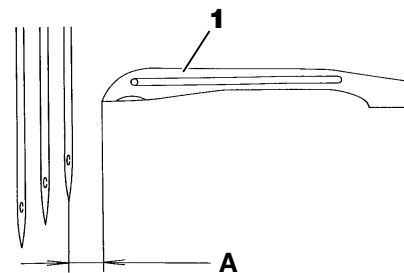
When the point of the looper has reached the center of the left needle from the extreme right end of its travel, there should be 0.05~0.1mm front-to-back clearance between the left needle and the point of the looper.

##### ● For 3-needle machines

When the point of the looper has reached the center of the middle needle from the extreme right end of its travel, there should be 0-0.5mm front-to-back clearance between the middle needle and the point of the looper.


Adjustment is made by loosening screw **3** on looper holder **2** and moving looper holder **2** forward or backward. After the adjustment, tighten screw **3**.

● When the point of the looper is passing the center of the right needle from the extreme right end of its travel (the rear needle guard is not effective), the right needle slightly contacts the point of the looper.

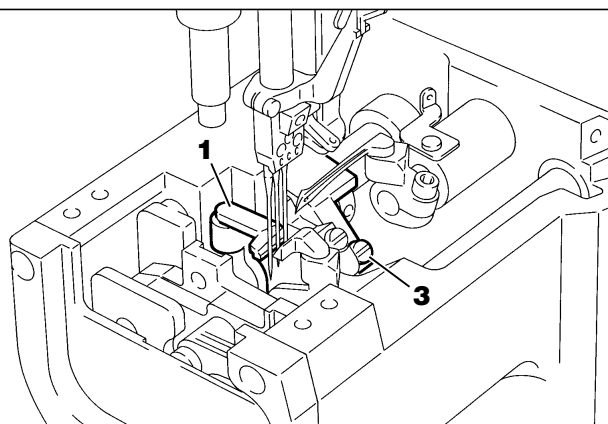
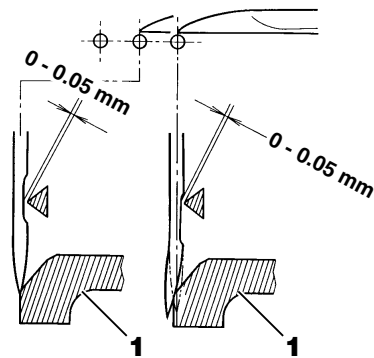
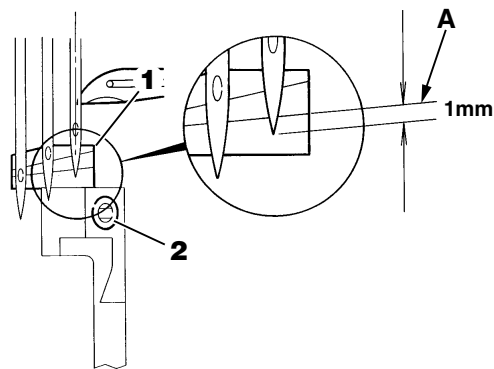


## Adjusting the needle guard (rear)

### CAUTION


 Always turn off the power, unplug the machine and then well-qualified technicians should adjust the needle guard (rear).

1. When the point of the looper has reached the center line of the right needle from the extreme right end of its travel, there should be a distance of 1mm from line **A** on needle guard (rear) **1** to the point of the right needle. Adjustment is made by loosening screw **2** and moving needle guard (rear) **1** up or down. After adjusting, tighten screw **2**.
2. When the point of the looper has reached the center of the right needle from the extreme right end of its travel, there should be 0~0.05mm front-to-back clearance between the right needle and the point of the looper. Adjustment is made by loosening screw **3** and moving needle guard (rear) **1** forward and backward. After adjusting, tighten screw **3**.
3. For 3-needle machines :  
When the point of the looper has reached the center of the middle needle, the middle needle must slightly contact needle guard (rear) **1** with 0~0.05mm front-to-back clearance between the middle needle and the point of the looper. Adjustment is made by loosening screw **2** and swing needle guard (rear) **1** to the left or right.

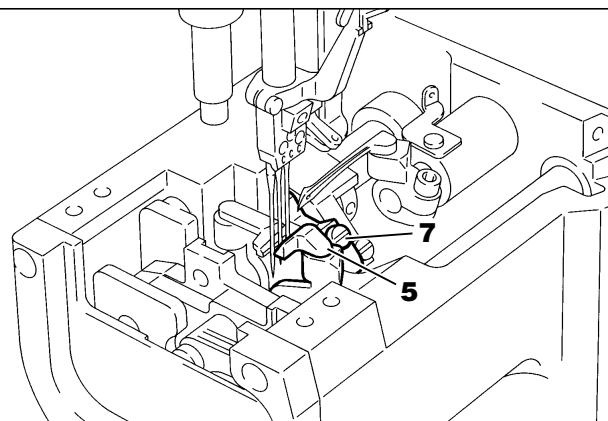
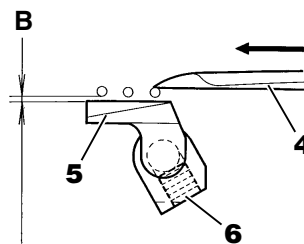


## Adjusting the needle guard (front)

### CAUTION

 Always turn off the power, unplug the machine and then well-qualified technicians should adjust the needle guard (front).

When looper **4** is moving to the left in the back side of the needles, there should be a clearance of 0.3~0.5mm **B** between the needles and needle guard (front) **5**. To make this adjustment, loosen screws **6** and **7**, and then adjust the angle of needle guard (front) **5** and its front-to-back position.  
After the adjustment, tighten screws **6** and **7**.



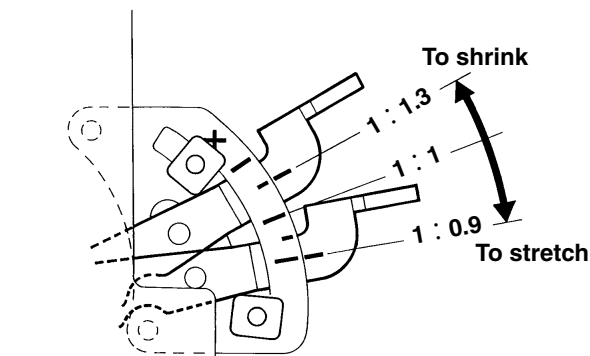
## Adjusting the differential feed ratio

The differential feed ratio is set to 1:0.9~1:1.3 at the factory.

(except -03G)



Always turn off the power, unplug the machine and then well-qualified technicians should adjust the differential feed ratio.



### In the case of a differential feed ratio of 1:1.3~1:1.8

## CAUTION



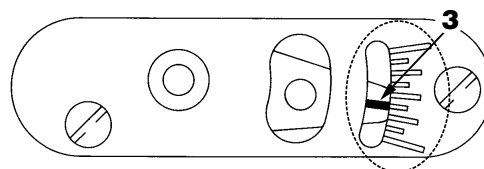
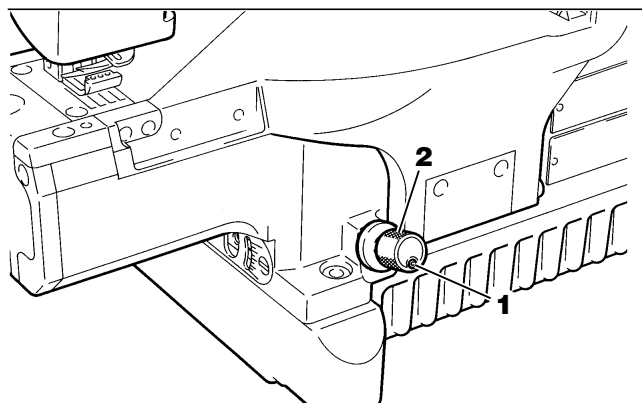
If you use the machine with a differential feed ratio of 1:1.3~1:1.8, the feed dogs may strike the needle plate and be damaged. Check to make sure the movement amount of the feed dogs is less than 2.5mm.



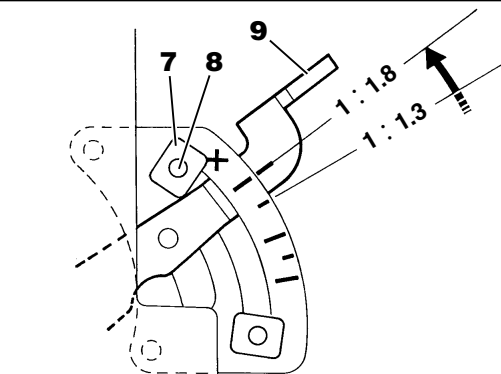
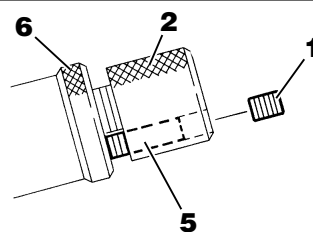
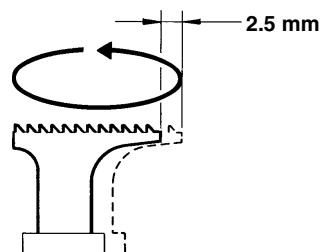
If you use the machine with a differential feed ratio of 1:1.3 ~ 1:1.8, run the machine at less than 6,000 rpm.

To use the machine with a differential feed ratio of 1:1.3~1:1.8, set the main feed dog movement amount at less than 2.5mm by following the steps below.

1. Loosen pin screw **1** and remove it.
2. Turn stitch length adjustment knob **2** until mark **3** on the lever points the reading as shown in the illustration (the main feed dog movement amount is approximately 2.5mm).
3. Turn the machine pulley (handwheel) by hand until the main feed dog movement amount is 2.5mm. To make a fine adjustment, turn stitch length adjustment knob **2**.
4. Turn pin screw **5** inside the stitch length adjustment knob **2** clockwise until pin screw **5** contacts nut **6**. Install pin screw **1** on stitch length adjustment knob **2**.
5. Loosen screw **8** of stopper **7**. Loosen the nut. Align the alignment mark on adjustment lever **9** with "1:1.8" reading. Then tighten the nut. Adjust stopper **7** so that it contacts adjustment lever **9**. Tighten screw **8**.




Feeding amount of main feed dog is set to approximately 2.5mm.



In the case of a differential feed ratio of 1:0.6~1:1.1

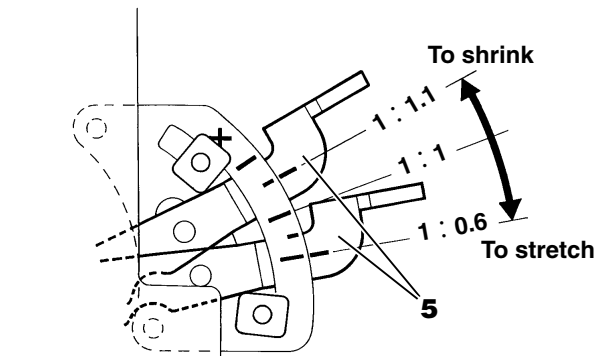
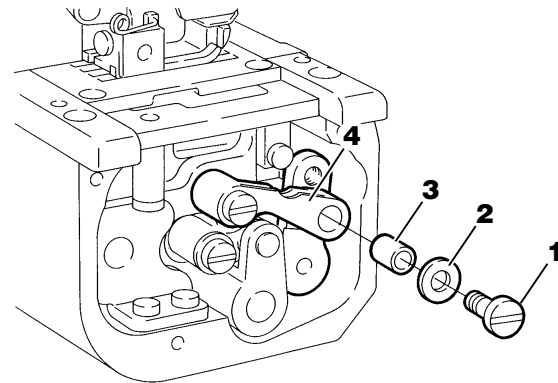
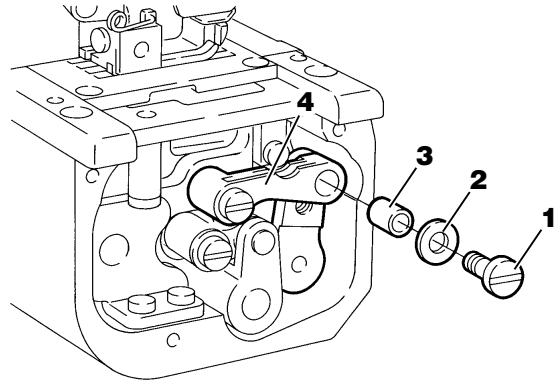
## CAUTION

 Always turn off the power, unplug the machine and then well-qualified technicians should adjust the differential feed ratio.

1. Remove screw **1**, washer **2** and bushing **3** in sequence.

2. Align the hole on link **4** with the lower screw hole.  
Then install bushing **3**, washer **2** and screw **1** in reverse sequence of step 1.

3. Altering the installation position of link **4** changes the differential feed ratio to 1:0.6~1:1.1 without changing the factory-set movable range of adjustment lever **5** (standard).



## Changing the needle bar stroke

### CAUTION

Always turn off the power, unplug the machine and then well-qualified technicians should change the needle bar stroke.

If you use the machine with high stroke, be sure to run the machine at a speed less than 6,000 rpm.

If you change the needle bar stroke, be sure to readjust the needle height (see page 24), the looper (see page 25) and the needle guard (see page 26).

1. Loosen screws **2** on motion **1**. Slightly move eccentric **3** in the direction of the arrow with a screwdriver until groove **B** comes out of pin **C**.
2. To change the needle bar stroke, bring flat surface **A** to the top or bottom position by turning screw **4** of eccentric **3**.

#### To position the needle bar stroke with standard stroke

Insert eccentric **3** into the motion with surface **A** at the bottom position until groove **B** fits into pin **C** of the motion.

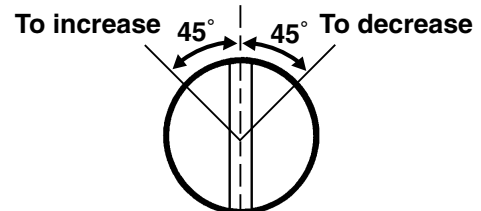
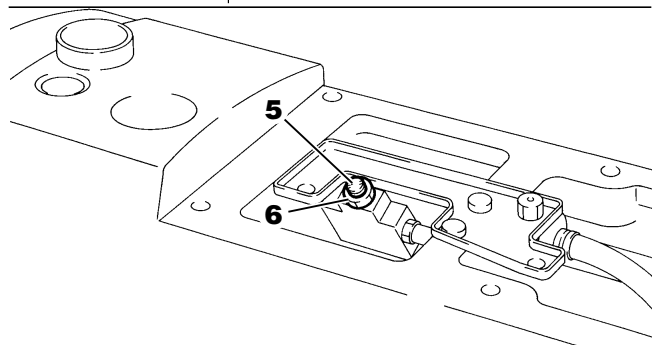
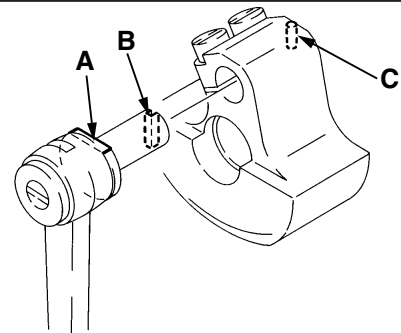
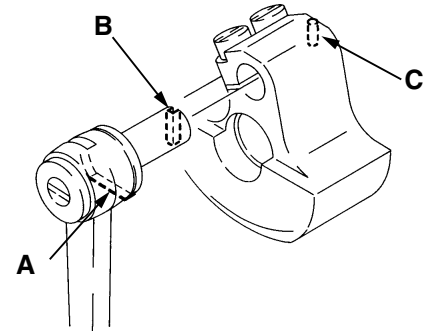
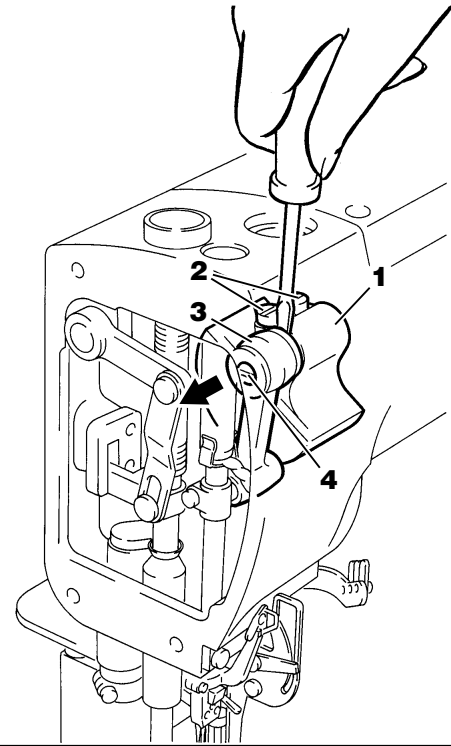
#### To position the needle bar stroke with high stroke

Insert eccentric **3** into the motion with surface **A** at the top position until groove **B** fits into pin **C** of the motion.

Tighten screws **2**

#### Note

The W2664S is designed for standard stroke. Do not use this machine with high stroke.



### CAUTION

The amount of oil to be supplied to the needle bar chamber is factory-set properly, so do not adjust it under normal conditions. However, if it should be necessary, follow the steps shown below.

### WARNING

Do not adjust the screw beyond the range shown below. Otherwise the machine may be damaged.

Loosen nut **6**. Adjust the amount of oil by turning screw **5**. The adjusting range is within 45° clockwise or counterclockwise, referred to the groove on screw **5** (see the illustration).

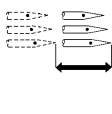

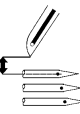




- To decrease the amount, turn screw **5** clockwise.
- To increase the amount, turn screw **5** counterclockwise.

After this adjustment is made, tighten nut **6**.



## Adjustment dimentions

(mm)

	× □□□								
W2664-01 -03 -08	232	Standard lift	8.3	4.7~5.0	7.8	5.0	17.0	0.8~1.2	
		High lift	9.8	4.3~4.5	9.0				
	240	Standard lift	7.8	4.3~4.6	7.8	5.0	17.0	0.8~1.2	
		High lift	9.3	3.9~4.1	9.0				
	248	Standard lift	7.4	3.9~4.2	8.2	5.0	17.0	0.8~1.2	
		High lift	8.9	3.5~3.7	9.2				
	356	Standard lift	7.0	3.5~3.8	8.2	5.0	17.0	0.8~1.2	
		High lift	8.5	3.1~3.3	9.2				
W2664S-01 -08	364	Standard lift	6.6	3.1~3.4	8.2	5.0	17.0	0.8~1.2	
		High lift	8.1	2.7~2.9	9.2				
	256	Standard lift	7.0	3.1~3.3	—	—	—	0.8~1.2	
	264	Standard lift	6.6	2.7~2.9	—	—	—	0.8~1.2	

## Comparison table of equivalent sizes

Japanese size (Organ)	#	9	10	11	14	16	18	21
Metric size (Schmetz)	Nm	65	70	75	90	100	110	130

## Standard needle

W2664-01 -03 -08	× □□□	Organ UY128GAS
W2664S-01 -08	232	9S
	240	9S
	248	9S
	256	9S
	264	9S
	356	10S
	364	10S

## W2600 Series subclass specifications

### W2600 Series



Application	Subclass	Number of needles	Number of threads	Needle space (mm)	Max. stitch length (mm)	Diff. feed ratio	Presser foot lift (mm)		Max. speed (rpm)		Remarks
							S	H	S	H	
Versatile	W2664-01G	2	4	3.2・4	4.5	0.9~1.3	5.6	6.8	6,500	6,000	
			4.8								
		3	5	5.6・6.4			6	7			
	W2664S-01G	2	3	5.6	4.5	0.9~1.3	7	—	7,000	—	
				6.4			6.5	—			
	W2664-01J	3	5	5.6	4.5	0.9~1.3	6	7	6,500	6,000	
Covering	W2664-03F	2	4	4.8	4.5	0.9~1.3	6	7	6,500	6,000	
		3	5	5.6・6.4							
	W2664-03G	2	4	4	4.5	0.6~1.1	5.6	6.8	6,500	6,000	
				4.8			6	7			
		3	5	5.6・6.4			6	7			
Hemming	W2664-08A	2	4	4	4.5	0.9~1.3	5.6	6.8	6,500	6,000	
			4.8	6			7				
		3	5	5.6・6.4			6	7			
	W2664S-08A	2	3	5.6	4.5	0.9~1.3	7	—	7,000	—	
				6.4			6.5	—			
	W2664-08B	2	4	4	4.5	0.9~1.3	5.6	6.8	6,500	6,000	
				4.8			6	7			
		3	5	5.6・6.4			6	7			

※If you use the machine with a differential feed ratio of more than 1:1.3, the main feed dog movement amount should be less than 2.5mm and the maximum machine speed less than 6,000 rpm.

※S and H in the columns of Presser foot lift and Max. machine speed denote as follows.

S: at a needle bar stroke of 31mm (Standard) H: at a needle bar stroke of 33.4mm (High lift)

Stitch type	602, 605
Needle size	UY128GAS #9S UY128GAS #10S
Machine size (WxDxH)	W : 460mm D : 270mm H : 392mm

Net weight (head only)	41.2Kg
Gross weight (with accessories)	47.2Kg
Working noise level	n=6,300rpm : LpA≤83.5dB Noise measurement according to DIN 45635 48A-1



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The description in this INSTRUCTIONS is subject to change without prior notice for improvement.