

■ 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

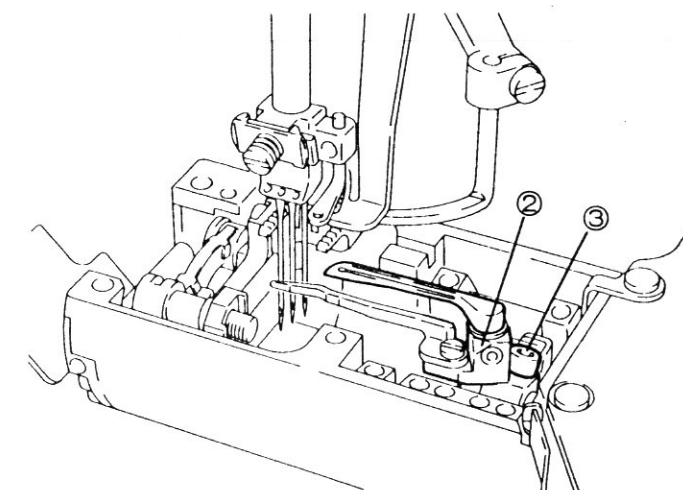
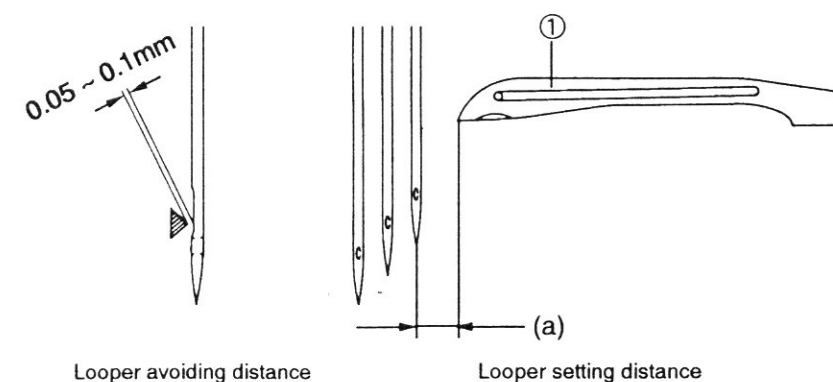
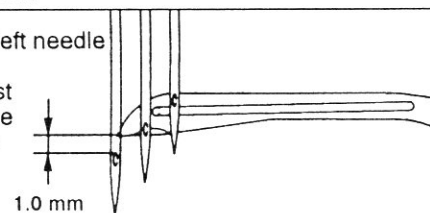
(2) Looper avoiding distance

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.

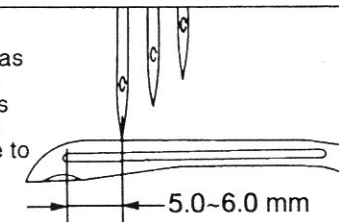
- For 3-needle machines, set the front-to-back clearance between the middle needle and the point of the looper at 0 - 0.05mm when the point of the looper has reached the center of the middle needle from its farthest position to the right.
- When the point of the looper passes the center of the right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



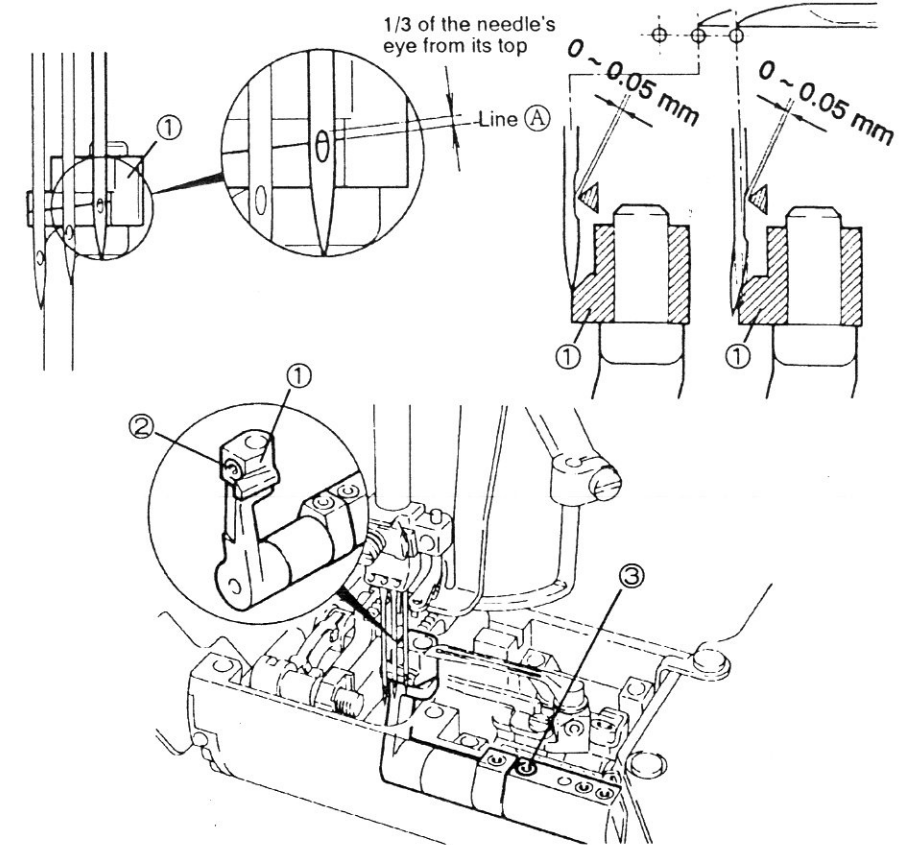
- When the point of the descending left needle has reached the top surface of the looper while the point of the looper is moving to the right from its farthest position to the left, check to make sure the distance from the center of the looper's eye to the center of the left needle is 5.0 - 6.0mm.



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Needle guard (rear)

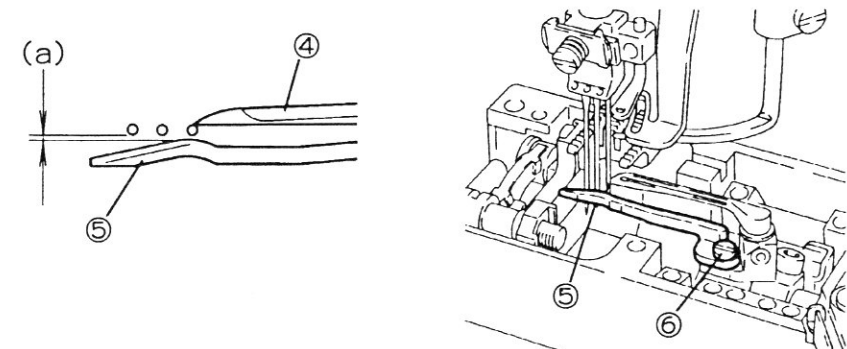
- (1) When the needle bar is at the bottom of the stroke, set line ① of needle guard (rear) ① at 1/3 of the right needle's eye from its top. To make this adjustment, loosen screw ② and move needle guard (rear) ① up or down.
- (2) When the point of the looper has reached the center of the right needle 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.

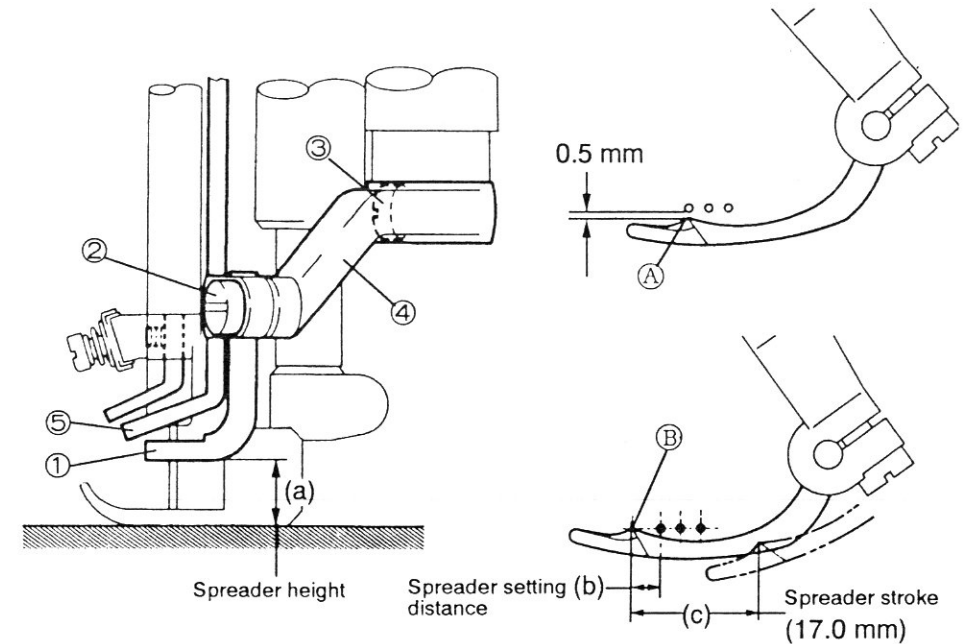
If the spreader still does not hook the spreader thread correctly, increase the spreader stroke within 18mm.

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.)



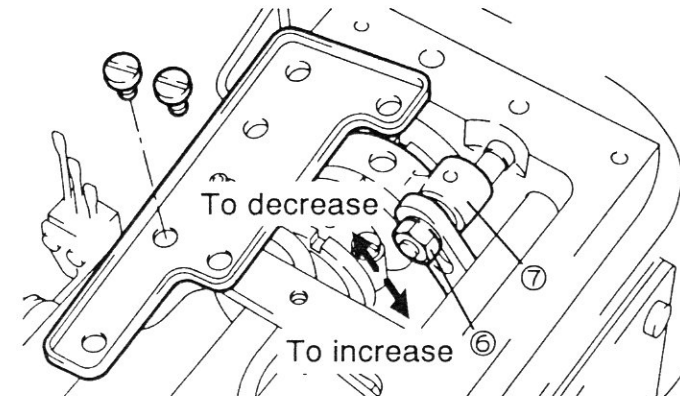
(3) Spreader stroke

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.



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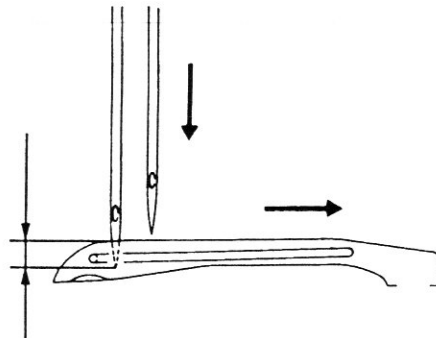
Looper thread take-up

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.

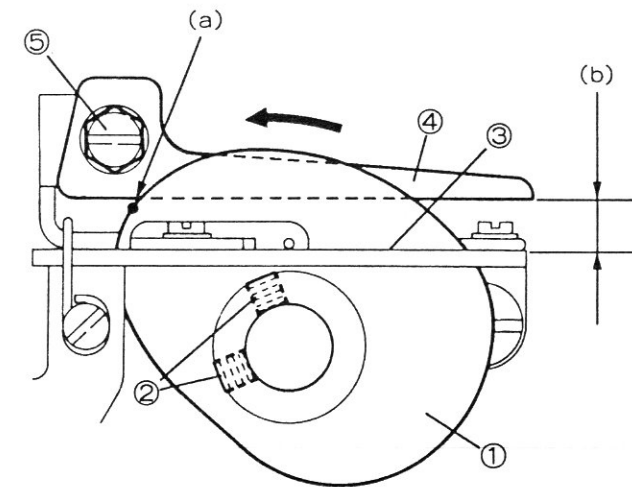
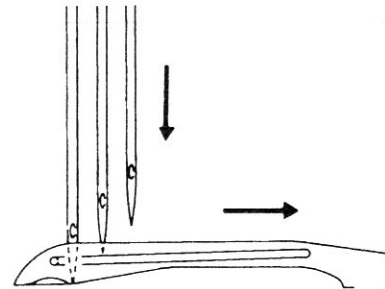
To make this adjustment, loosen screw ② and turn looper thread take-up ①.

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.

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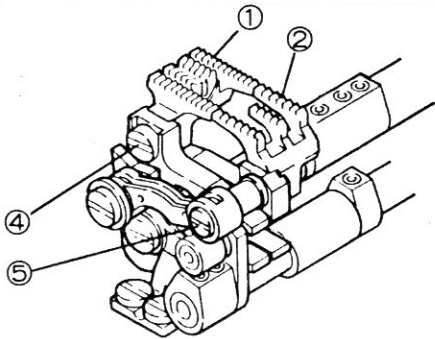
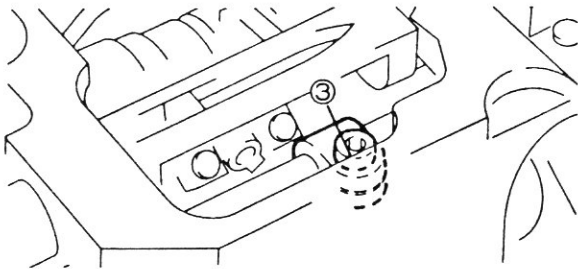
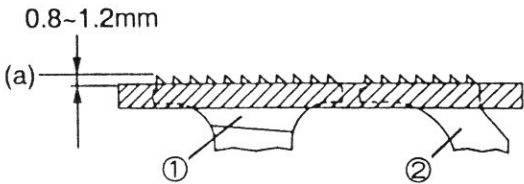
Feed dog height

(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

