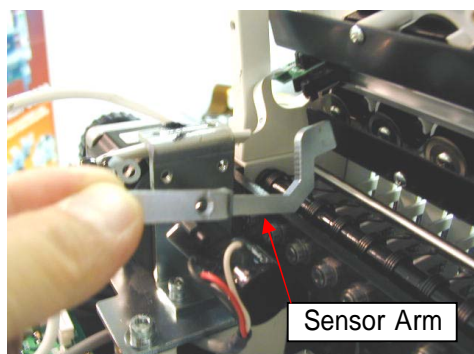
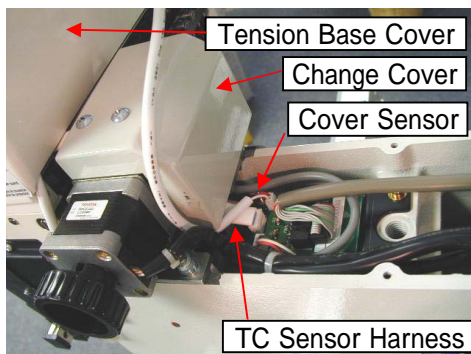


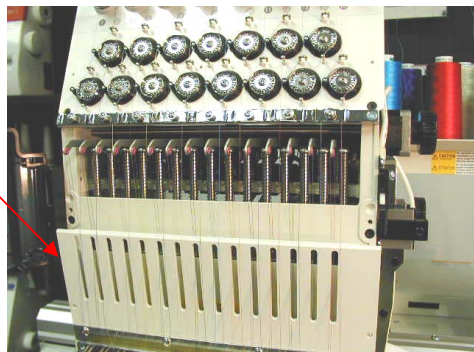
**Disassembly procedure**

- 1, Move Needle Case to needle # 15.
- 2, Remove Relay Card Cover, Change Cover and Tension Base Cover.
- 3, Disconnect Cover Sensor and TC Sensor Harness from Joint Card.
- 4, Disassemble Sensor Arm.



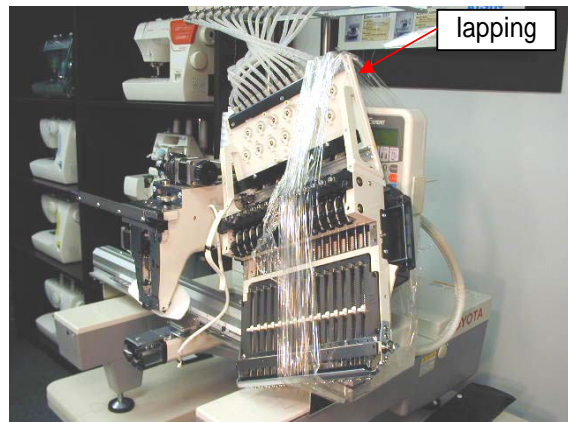
- 5, Remove two screw and hang Top Cover by threads. Loosen all 15 threads then hang Top Cover. Do not pull out any threads, it is takes a lot of time for re-threading later.

Hang Top Cover by thread



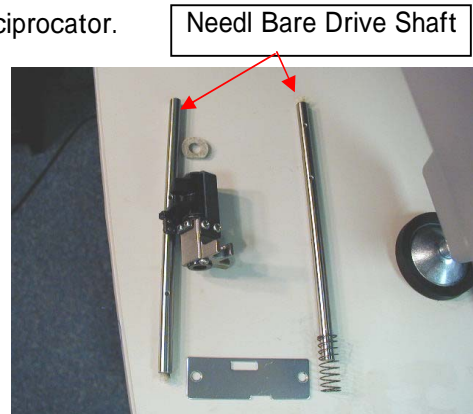
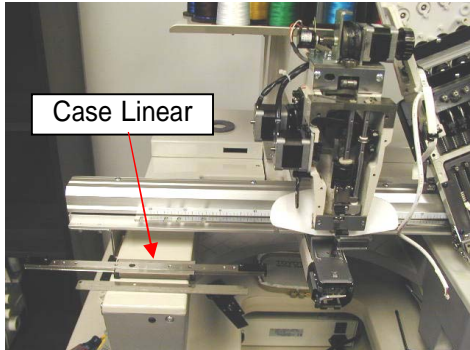
- 6, Turn Needle Case whole assembly and lapping Needle Case to Operation Panel and X Sash as shown. Use lapping tape is better for hold.

Turn Needle Case

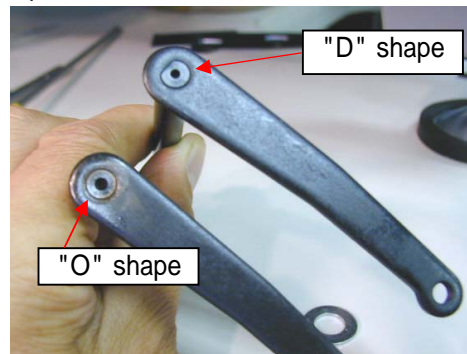
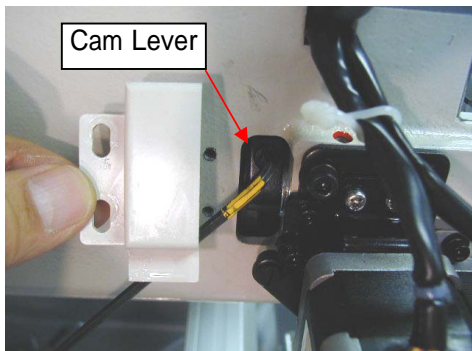


7, Remove Case Linear and Arm Front Cover L and R.

8, Remove two of Needle Bare Drive Shaft Sets and Reciprocator.

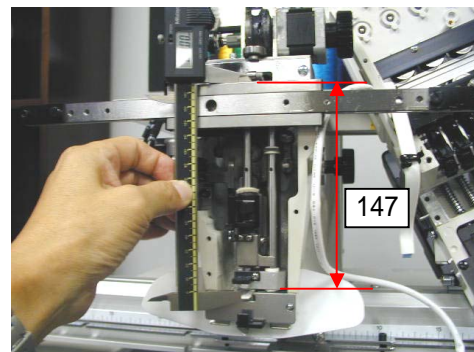
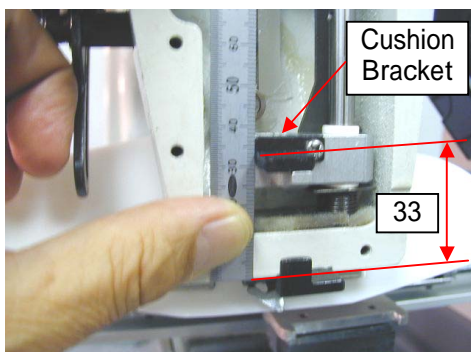


9, Loosen Cam Lever and remove Drive Lever assembly.  
Change defective "O" shape Drive Lever to new "D" shape Drive Lever.

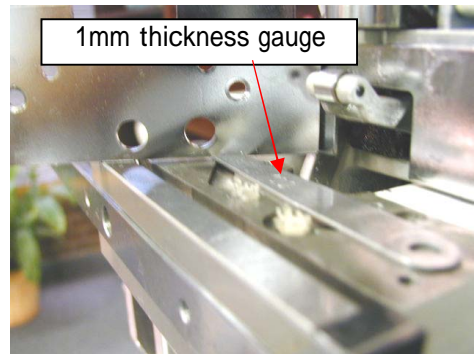
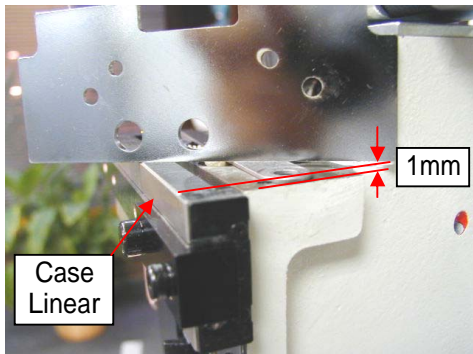


### Assembly procedure

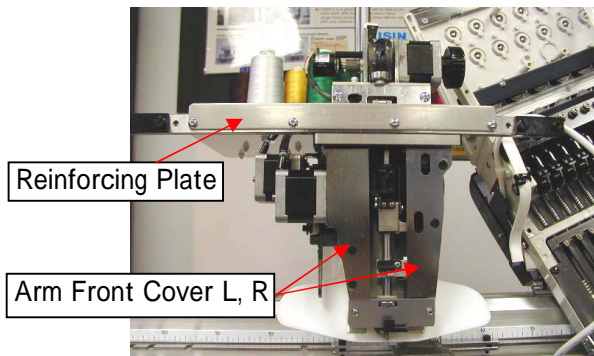
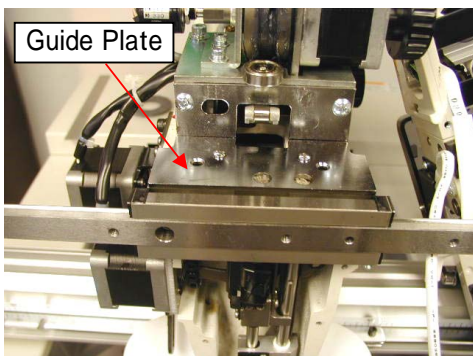
- 1, Assemble new "D" shape Drive Lever and Needle Bare Drive Shaft Set to the Arm.  
Be sure Drive Lever "no shake no bind of axle direction".
- 2, Assemble Needle Bare Drive Shaft.  
Both Needle Bare Drive Shaft bottom edge must be flush to the Arm bottom surface.
- 3, Set up Presser Foot Reciprocator height 33mm.  
When Presser Foot Reciprocator is lower dead point, from Cushion Bracket top surface to Arm bottom surface must be 33mm.  
( or from Presser Foot Reciprocator lower surface to Case Linear top surface is 147mm )



- 4, Assemble Case Linear to the Arm, height is 1mm.  
 From Case Linear top surface to Arm top surface must be set up 1 mm both side.  
 For easy to set up 1 mm, use 1mm thickness gauge to set up.

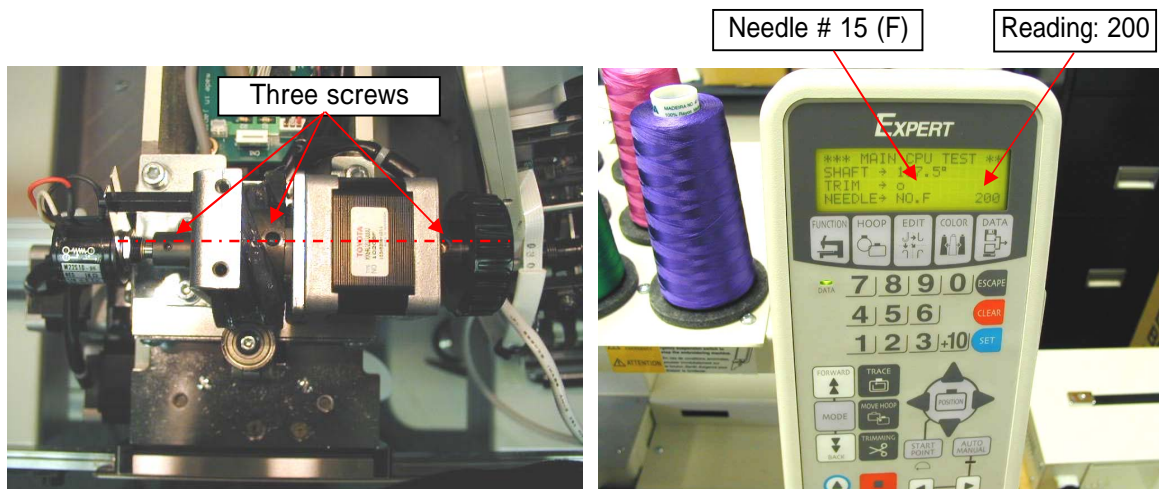


- 5, Assemble Guide Plate B, Reinforcing Plate, Arm Front Cover L,R and Arm Guide Plate.

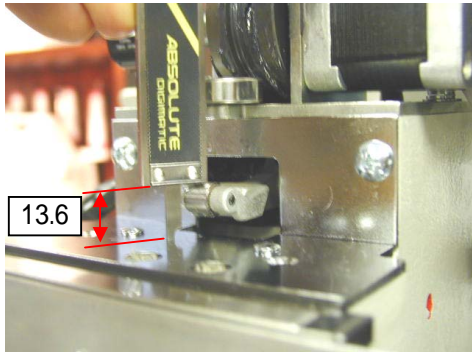


- 6, Confirm Potentiometer, Cam and Handle B screw location. (all three screws are 12 o'clock).  
 Three screws must be in line and 12 o'clock.

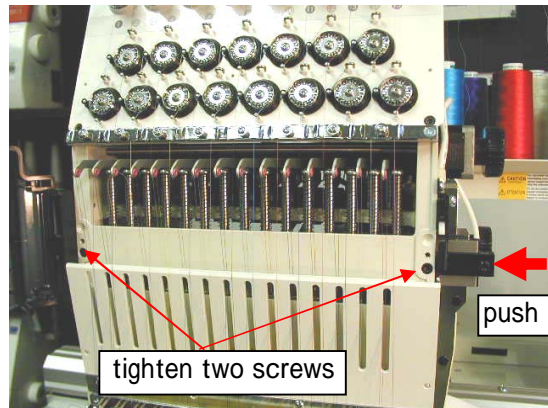
Confirm Potentiometer Reading 200 at Needle #15(F).



7, Confirm Roller height 13.6mm from Arm Guide Plate.



8, Assemble Needle Case  
Tighten two screws when Linear is most left side.



9, Assemble Top Cover and put in order 15 threads.

10, Assemble TC Sensor Bracket and connect Harness.

11, Assemble Tension Base Cover and connect Sensor Harness.

12, Assemble Relay Card Cover and Change Cover.

