

INSTRUCTION MANUAL

Tre 1F

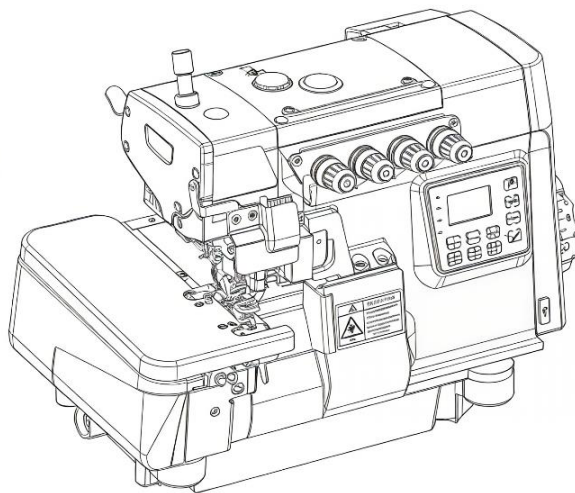
Orlo 1F

Quattro 1F

Cinque 1F

Quattro 3F

High speed industrial overlock sewing
machine



 ***texi***

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Technical Specification

Model	Orlo 1F	Tre 1F	Quattro 1F	Cinque 1F	Quattro 3F
Application	Light & medium materials	Light & medium materials	Light & medium materials	Light & medium materials	Light & medium materials
Power supply	230 V	230 V	230 V	230 V	230 V
Frequency	50 ~ 60 Hz	50 ~ 60 Hz	50 ~ 60 Hz	50 ~ 60	50 ~ 60 Hz
Number of Needles	1	1	2	2	2
Number of threads	3	3	4	5	4
Sewing speed (max)	7000 stitches per minute	7000 stitches per minute	7000 stitches per minute	7000 stitches per minute	7000 stitches per minute
Stitch Width	4 mm	4 mm	6 mm	8 mm	6 mm
Needle	B-27 with appropriate tips to the type of sewn materials	B-27 with appropriate tips to the type of sewn materials	B-27 with appropriate tips to the type of sewn materials	B-27 with appropriate tips to the type of sewn materials	B-27 with appropriate tips to the type of sewn materials
Lubricating oil	Oil for high speed machines	Oil for high speed machines	Oil for high speed machines	Oil for high speed machines	Oil for high speed machines
Nett weight	37 kgs	37 kgs	37 kgs	37 kgs	37 kgs
Packing dimension	515 × 360 × 466 mm	515 × 360 × 466 mm	515 × 360 × 466 mm	515 × 360 × 466 mm	515 × 360 × 466 mm

1. INTRODUCTION

- These Operating Instructions describe the safe operation of the machine.
- Read these instructions carefully and become familiar with operation, adjustment, inspection and maintenance procedures before using the machine.
- During operation of an industrial sewing machine, the operator works close to moving parts such as needles. Contact with moving machine parts is therefore possible. Safe products must be used correctly and all safety rules must be followed. Read these Operating Instructions and the instructions for the drive/motor and implement the necessary safety measures before operating the machine.

2. DANGER, WARNING AND CAUTION INDICATIONS

To prevent accidents, this product and this manual use symbols and signal words to indicate the degree of hazard. Read and understand them fully and always follow the instructions. Warning labels must be attached where they are clearly visible. Replace them immediately if they become dirty, damaged or detached. Contact the seller or nearest Texi distributor for replacement labels.

Signal word	Meaning
 DANGER	Immediate danger of death or serious bodily injury.
 WARNING	Potential danger of death or serious bodily injury.
 CAUTION	Possible incorrect operation that may cause injury or damage to the machine/device.

Symbols and messages

	Incorrect operation of the machine or device may cause electric shock.
	Incorrect operation may result in injury to the hands and/or fingers.
	Incorrect operation may cause the hands and/or fingers to be caught and injured.
	Danger of burns from high temperatures.
	Incorrect operation of the machine or device may cause fire.
	Strictly prohibited.
	Disconnect the power plug or switch off the power before inspection, maintenance or repair, and during thunderstorms.
	Make sure the machine and device are properly grounded.
	Motor rotation direction

3. SAFETY PRECAUTIONS

3.1 Application and intended use

Industrial sewing machines are developed to improve quality and productivity in the sewing industry. Use the machine only for its intended sewing applications.

3.2 Operating environment

The operating environment can have a decisive influence on service life, performance and safety. For safety, do not use the machine under the following conditions:

1. Near equipment that generates strong electrical interference, such as high-frequency welding equipment.
2. In places where chemicals are stored or used, or where the air contains chemical vapors or splashes.
3. Outdoors or in direct sunlight.
4. At ambient temperatures below 5 °C or above 35 °C.
5. At relative humidity below 35% or above 85%.
6. Where voltage fluctuation exceeds $\pm 10\%$ of the rated voltage.
7. Where the available power supply capacity does not meet the requirements of the drive motor.
8. Where the prescribed compressed-air supply for pneumatic devices cannot be provided.
9. Where the machine may be exposed to water.

3.3 Safety measures during maintenance

WARNING

Always switch off the machine and unplug the power cord before inspection, repair, cleaning or other maintenance. Confirm that the machine will not run when the pedal is pressed. If work must be carried out with the power on, establish and follow strict safety procedures to prevent unexpected start.

Always switch off and unplug the machine before the following operations:

- Installing the sewing machine
- Lubrication
- Threading
- Replacing the needle
- Opening or closing the presser foot bar
- Adjusting stitch length
- Replacing or adjusting the knives
- Cleaning the machine
- Changing the oil
- Checking or replacing the filter
- Adjusting the needle-thread take-up
- Adjusting the thread take-up
- Installing or adjusting the blind-hemming guide
- Installing or adjusting a gathering device
- Installing or adjusting a gathering/piping attachment
- Daily maintenance and repairs must be carried out only by qualified technical personnel.
- Do not modify the machine without authorization. Contact your supplier or nearest Texi distributor before making any modification.

3.4 Before starting the machine

- Before each day's operation, visually inspect the sewing head for damage or malfunction. If an abnormality is found, repair it immediately or take the required corrective action.
- Check that the needle clamp is securely tightened. Be careful of the needle point.
- Make sure the presser foot is correctly positioned. Turn the handwheel slowly by hand and confirm that the needle enters the center of the needle hole in the presser foot.
- Check that the presser foot is securely installed. Raise it with the lifter and check for looseness by moving it forward/backward and left/right.
- To prevent accidents, make sure all safety covers and guards are correctly installed and secured. Never remove them during operation.

3.5 Training

To prevent accidents, operators, service personnel and maintenance personnel must have the necessary knowledge and technical skills for safe operation. The user is responsible for providing appropriate training.

4. PRECAUTIONS FOR THE FOLLOWING OPERATIONS

4.1 Unpacking

1. The machine head is shipped in a carton. Confirm the correct top and bottom from the markings on the carton, then unpack it carefully from the top.
2. Do not lift the machine by the needle area or thread guides; doing so may cause injury or damage.
3. Lift the machine carefully, taking its center of gravity into account.
4. Keep the carton and packing materials in good condition for possible future transport.

Disposal of packing materials

The packing materials consist of wood, paper, cardboard, LDPE and polystyrene foam. The customer is responsible for disposing of these materials correctly in accordance with local regulations. LDPE = low-density polyethylene.

Disposal of the machine

1. The customer is responsible for proper disposal of the machine.
2. The machine contains steel, aluminum, brass/zinc and various plastics.
3. Dispose of the machine in accordance with local environmental regulations. Consult a specialist disposal company if necessary.
4. Parts contaminated with lubricant must be disposed of separately in accordance with local environmental regulations.

Moving the machine within the customer's premises

The manufacturer assumes no responsibility for transport within the customer's premises. Keep the machine upright during transport and do not drop it.

4.2 Transportation

WARNING

1. When mounting the machine on the table or moving it to a cart, the machine must be lifted by at least two people. Use a suitable cart for any other transport.
2. When carrying the machine, hold the handwheel/pulley area with the right hand and support the underside/free-arm area with the left hand. Remove oil from the machine and from your hands first to prevent slipping.
3. Avoid impacts and strong vibration when transporting the machine or placing it on the table; otherwise, the machine may fall.
4. Before repacking the machine for future transport, wipe off all oil. Otherwise, the machine may slip from the hands or oil may weaken the bottom of the carton.

4.3 Installation and preparation — Machine table

1. Use a table (tabletop and metal stand) that is strong enough for the machine and resistant to vibration during operation.
2. Place the table in a suitable, well-lit location. If illumination is insufficient, provide additional lighting.
3. Fit a non-slip surface to the pedal so that the operator's foot cannot slip during operation.
4. Set the table height to suit the operator's working posture.

Cables

1. Switch off the machine and motor before connecting cables, and make sure all connectors are fully engaged.
2. Do not subject cables to excessive tension during operation.
3. Do not bend cables excessively.
4. Maintain at least 25 mm clearance between cables and moving parts such as the handwheel/pulley or V-belt.
5. Protect cables with covers or reposition them when necessary.
6. Never use wire staples to secure cables; they may cause short circuits or fire.

Motor

1. Install the motor correctly in accordance with the motor manufacturer's instructions.
2. Use a motor with a belt guard so that body parts cannot become caught in the V-belt.

Compressed-air hoses (optional)

1. Switch off the power before connecting compressed-air hoses. Connect all hoses to their fittings before connecting the air supply.
2. Insert hoses fully into the fittings and secure them.
3. Do not subject hoses to excessive loads during operation.
4. Do not bend hoses excessively.
5. Route hoses in safe positions and protect them with covers where necessary.
6. Never secure hoses with staples, as this can damage them.

Power cable

WARNING

1. Before connecting the power cable, switch off the machine and disconnect the plug from the socket.
2. Confirm that the supply voltage matches the specified rated voltage. Using the wrong voltage may damage components and may cause fire.
3. Protect cables from external forces during operation.
4. Do not bend cables excessively.
5. Keep cables at least 25 mm away from moving parts of the machine or device.
6. If necessary, protect cables by safe routing or with covers.
7. Do not use cable staples or similar fasteners that could damage the cable, cause leakage current or fire.

Grounding

1. Connect the sewing machine grounding conductor to the grounding terminal.
2. Securely connect the grounding conductor to the designated grounding point on the machine head.

4.4 Handling sewing-machine oil

WARNING

1. Never operate the machine before filling the oil reservoir. Use TERRESTIC T32 high speed machine oil.
2. Machine oil can irritate the eyes. Wear protective glasses when handling it. If oil enters the eyes, rinse immediately with clean water for 15 minutes and consult a doctor.
3. Avoid skin contact. Wash affected skin thoroughly with soap and water.
4. Never swallow machine oil.
5. Keep machine oil out of the reach of children. If swallowed accidentally, do not induce vomiting; consult a doctor immediately.
6. Dispose of used oil and oil containers in accordance with applicable regulations. Contact your supplier if you need advice.
7. After opening, store the oil container tightly closed in a dark place away from direct sunlight, dust and moisture.

4.5 Before starting operation

1. Visually check cables and connectors before switching on the machine. Check for damage, disconnection or looseness.
2. Keep your hands away from the needle area and the handwheel/pulley when switching on the machine.
3. At first start-up, switch on the machine and verify the direction of pulley rotation. Viewed from the pulley side, the normal rotation is clockwise.
4. The machine may be operated only by trained personnel who have read and understood these safety instructions and the operating instructions.
5. Read and understand Section 2, 'Danger, Warning and Caution Indications', and train operating personnel accordingly where necessary.
6. During the first month of operation, run the machine at no more than approximately 3/4 of its maximum speed.

4.6 Safety precautions during operation

WARNING

1. Never operate the machine without safety devices such as the needle-breakage eye guard, finger guard and belt/handwheel cover.
2. Never place your hands under the needle while the machine is running.
3. With a clutch motor, the motor may continue to rotate for a short time after power is switched off. Even after switching off, pressing the pedal may move the machine; use extreme caution.
4. Keep fingers, hair and clothing away from the handwheel/pulley, V-belt, motor pulley, thread take-up and needle bar. Do not place scissors, tweezers, tools or other objects in these areas.
5. Switch off the machine when it is not in use or when the operator leaves the workstation.
6. Switch off the machine during a power failure.
7. Wear clothing that cannot be caught by the machine.
8. Do not leave tools or unrelated objects on the machine table while the machine is running.
9. Keep hands and fingers away from the cutting edges of the knives.
10. If the ambient noise level is between 75 dB and 80 dB, use suitable hearing protection as necessary. If the ambient noise level exceeds 80 dB, warn users by signs that hearing protection must be worn.

4.7 Maintenance, inspection and repair

CAUTION

1. Maintenance, inspection and repairs may be carried out only by qualified personnel who have read and understood these safety instructions and the operating instructions.
2. Before tilting the machine head for maintenance, inspection or repair, switch off the machine and disconnect the power plug. Confirm that pressing the pedal cannot start the machine.
3. Before installing or removing the handwheel/pulley or drive belt, switch off and unplug the machine and confirm that the machine cannot start when the pedal is pressed.
4. Carry out daily and periodic maintenance in accordance with this manual and the operating instructions.
5. Use only genuine Texi parts for replacement. The manufacturer assumes no responsibility for accidents resulting from improper repairs/adjustments or the use of non-approved parts.
6. Do not modify the machine on your own initiative. The manufacturer assumes no responsibility for accidents caused by unauthorized modification.
7. Reinstall all safety devices and guards removed temporarily for maintenance or adjustment.
8. After maintenance, inspection or repair, make sure there is no danger before switching the machine on again.
9. Prevent water, other liquids, metal pieces and other foreign material from entering the machine.
10. For pneumatic devices, drain and clean the air preparation unit periodically. Otherwise, condensate may enter the solenoid valve and/or pneumatic cylinder.
11. Remove lint, dust and foreign material before and after operation to prevent malfunctions and keep the machine clean.

5. POSITION OF WARNING LABELS AND SAFETY DEVICES

The following safety devices and warning labels are provided around the machine.

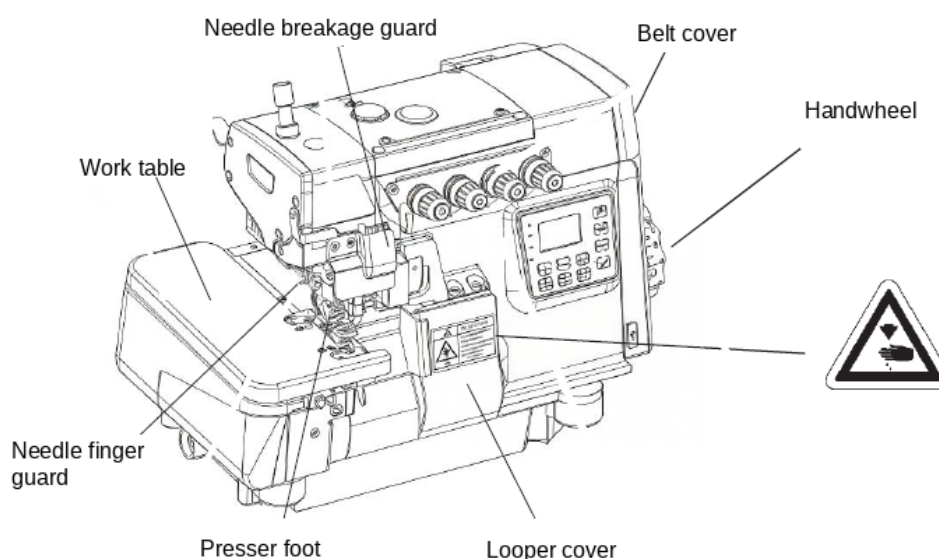


Fig. 1 - Original machine illustration — front side view

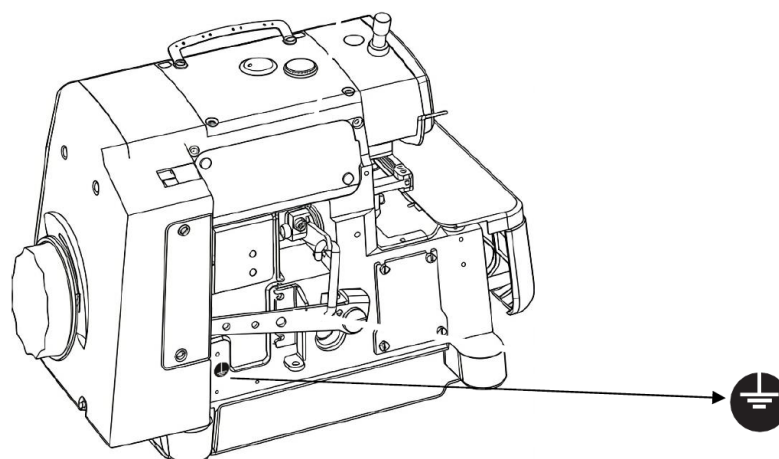


Fig. 2 - Original machine illustration — back side view

Needle-breakage eye guard	Protects the eyes from fragments if a needle breaks.
Knife caution label	Take special care during work to avoid cutting hands or fingers.
Drive pulley caution label	Keep hands, hair and clothing away from the drive pulley while the machine is running.
Finger guard	Helps prevent contact with the needle.
Handwheel / belt cover	Prevents contact with the rotating handwheel and drive belt.
Looper-area front cover	Prevents contact with moving loopers.
Work table / top cover	Prevents contact with moving thread take-up mechanisms.
Grounding label	Make sure the machine is correctly grounded to prevent electric shock and malfunction.
Presser foot	Keep fingers away from the gap under the presser foot during lifting.

(1) Needle-breakage eye guard

Never operate the machine with the eye guard open. The guard prevents needle fragments from striking the operator's eyes if a needle breaks. Wearing safety glasses during operation is also recommended.

(2) Finger guard

Never insert your fingers into the opening near the needle. The finger guard is installed to prevent contact with the moving needle. A small opening above the guard is provided to make threading easier; inserting fingers into this opening may result in needle injury.

(3) Handwheel / belt cover

Do not remove the cover. The handwheel/pulley and V-belt rotate at high speed during operation. Operate the machine only with the cover installed.

(4) Handwheel

Check the direction of handwheel rotation. Viewed from the handwheel/pulley side, normal rotation is clockwise.

(5) Presser foot

Never place your fingers in the gap. The presser foot rises more than 5 mm above the needle plate. Do not place fingers under the presser foot when it is raised automatically by the pedal or knee switch.

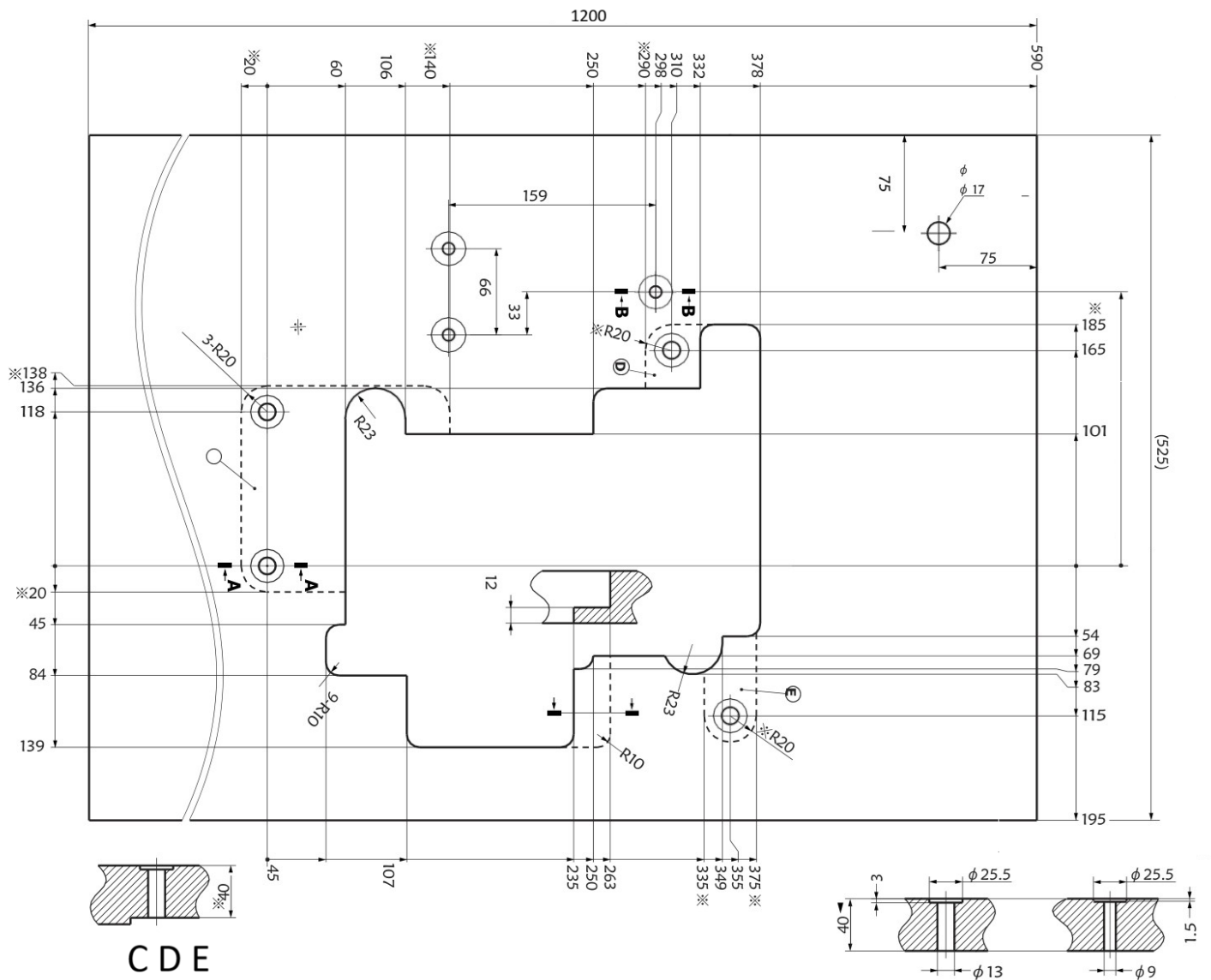
(6) Looper-area front cover

Never operate with the front cover open. Viewed from the front, the looper moves left and right in an arc. To prevent injury, operate the machine only with the cover correctly closed.

(7) Work table / top cover

Do not open during operation. Keep the work table/top cover closed so that the operator cannot contact the double-chainstitch looper thread take-up or looper mechanisms.

Semi-submerged installation



Original machine-table drawing with standard dimensions

Note: If the machine-table board thickness is 40 mm or more, machine the dimensions marked with ※ as indicated in the original drawing.

Machine pulley rotation direction

⚠ CAUTION

Viewed from the machine pulley/handwheel side, the machine pulley must rotate clockwise.

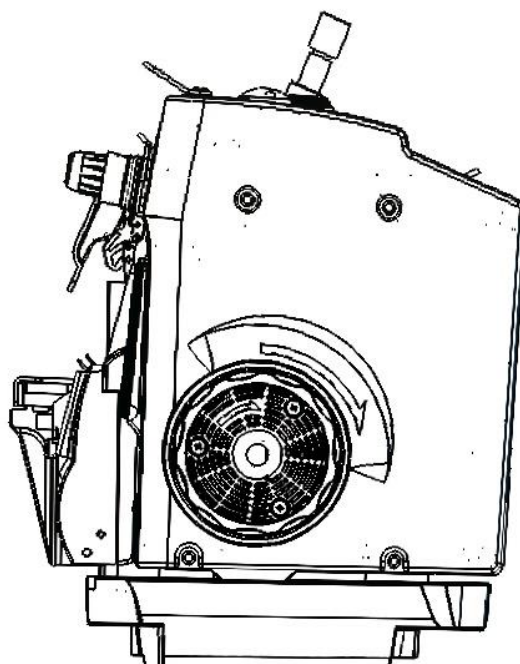


Fig. 3 - Machine pulley rotation direction

Installing the presser foot lifter chain

Install chain 5 between presser-foot-lifter lever 3 and pedal 4. Adjust the chain length so that the pedal can be operated easily.

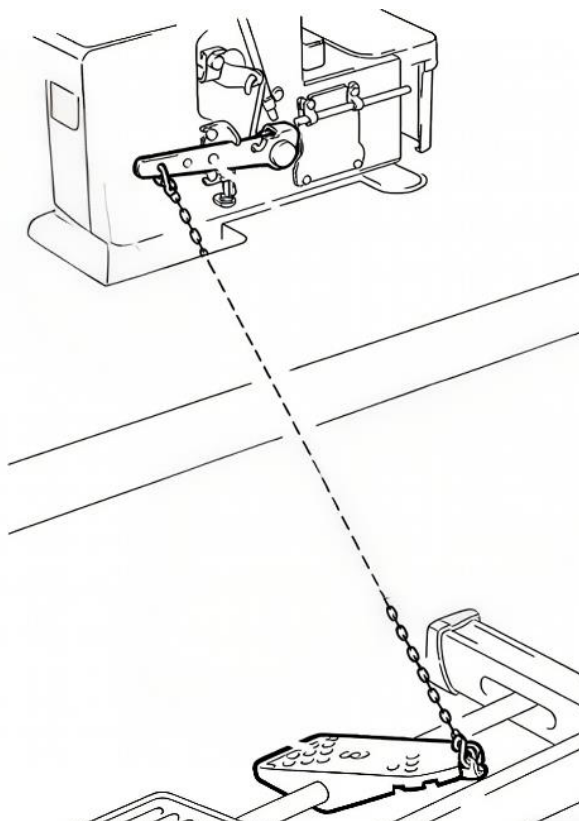


Fig. 4 — Presser foot lifter chain

LUBRICATION

⚠ CAUTION

Always switch off the power and unplug the machine before adding oil. Use only the oil recommended by manufacturer; other lubricants may damage the machine.

1. Oil

Use TERESSTIC T32 high speed sewing machine oil.

2. Filling the machine with oil

Remove cap 1. Add oil until the oil level is between the H and L marks on oil level gauge 2. After filling, reinstall cap 1.

3. Required oil level

H on gauge 2 = upper limit. L on gauge 2 = lower limit. Always keep the oil level between H and L and check it regularly.

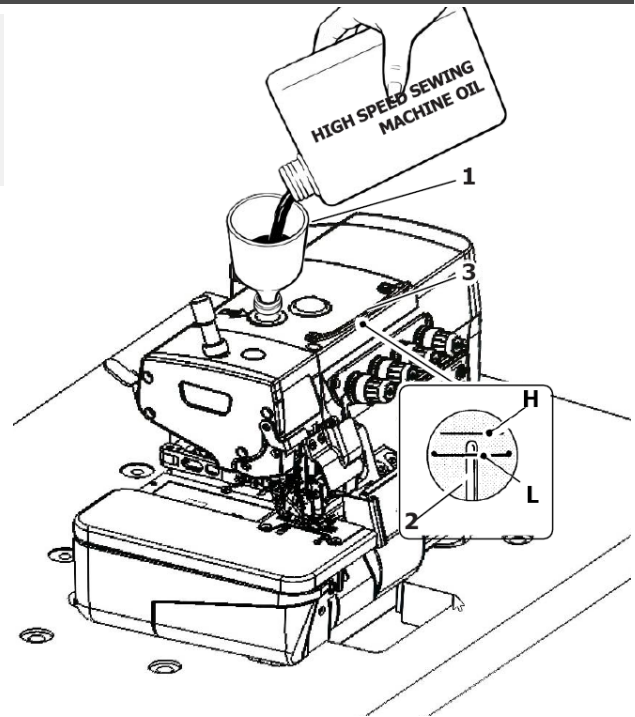


Fig. 5 — Filling and checking the oil level

4. Manual lubrication

⚠ CAUTION

Always switch off the power and unplug the machine before lubricating by hand.

When the machine is used for the first time, or after it has not been used for a long period, apply 2–3 drops of oil by hand to needle bar 4, upper-looper holder 5 and the indicated lubrication point 6.

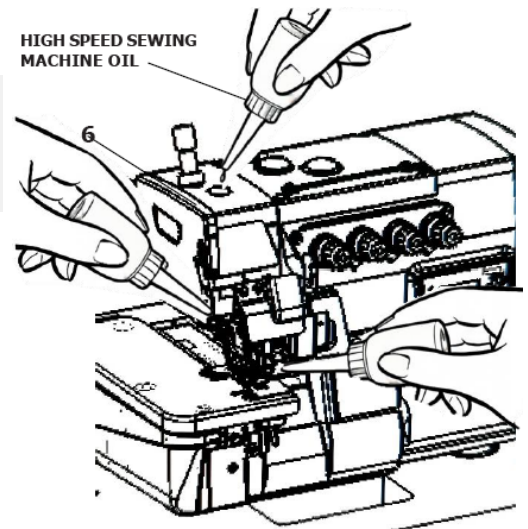


Fig. 6 — Manual lubrication points

5. Checking oil circulation

After the machine has been correctly filled with oil, operate the machine with the pedal and check oil sight window 1 to confirm that oil is circulating normally.

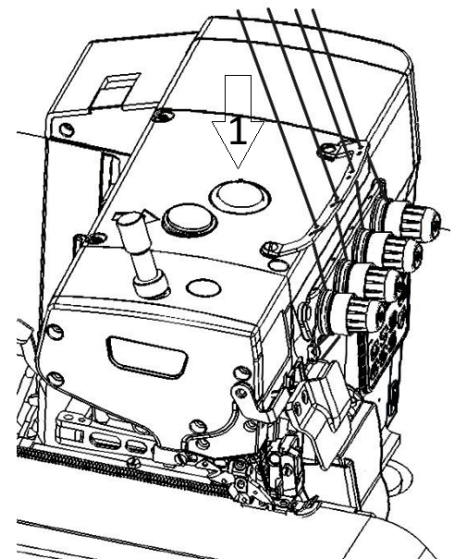


Fig. 7 — Oil circulation sight window

SILICONE OIL FOR THE H.R. DEVICE

⚠ CAUTION

Always switch off the power and unplug the machine before filling the H.R. device with silicone oil.

Fill silicone-oil reservoirs 2 and 3 with silicone oil. Check them frequently and refill in good time to help prevent thread breakage and damage to the sewing material.

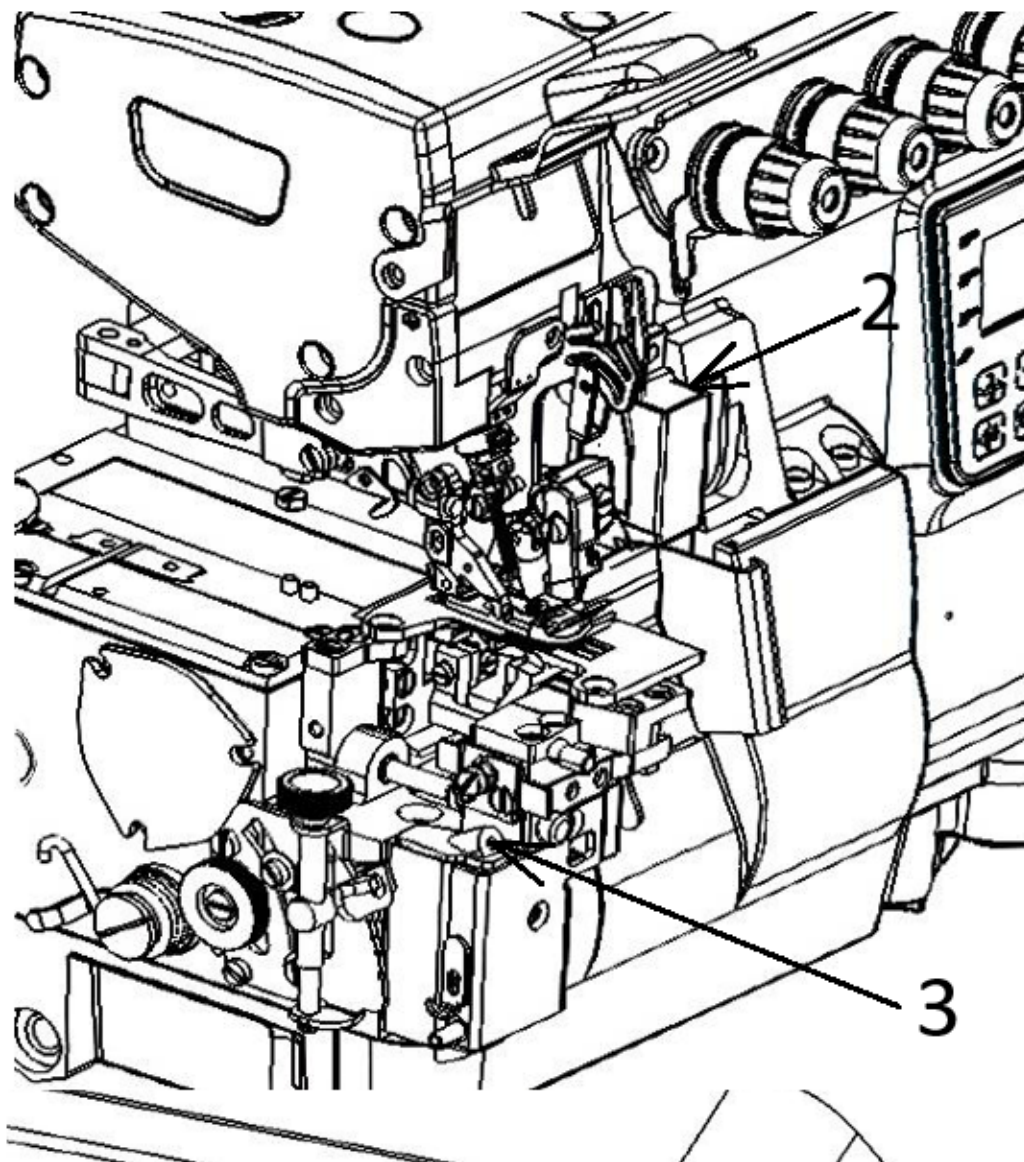


Fig. 8 — Silicone-oil reservoirs

⚠ CAUTION

Always switch off the power and unplug the machine before threading.

1. Open work table/top cover 1, needle-breakage eye guard 2, front cover 3 and presser foot bar 4. After threading, return all parts to their original positions.

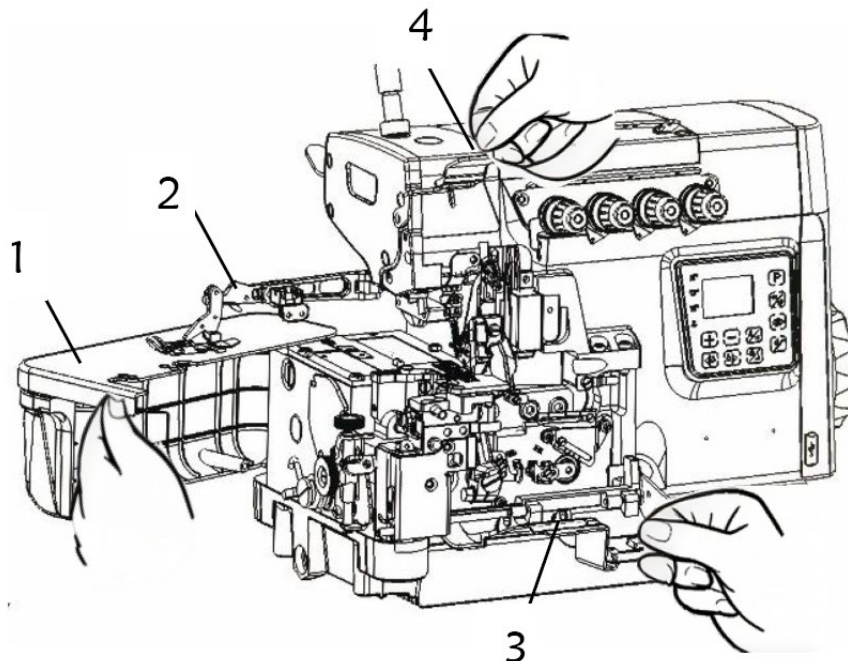


Fig. 9 — Opening the covers for threading

2. If the machine is already threaded:

- A — Tie the existing thread and the new sewing thread together.
- B — Needle thread: pull the knot up to just before the needle, cut off the knot, and then thread the needle.
- C — Looper thread: pull the knot through the looper eye, then trim the knot cleanly.

3. If the machine is not threaded, thread it according to the threading diagram attached to the machine.

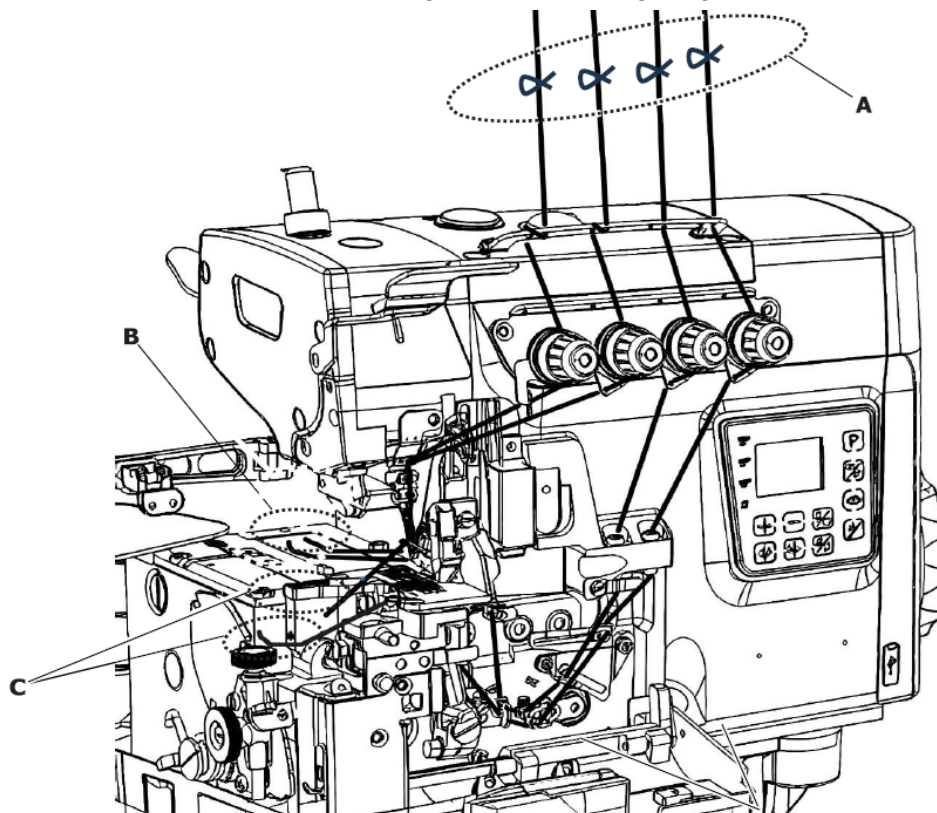


Fig. 10 — Threading diagram

⚠ CAUTION

Always switch off the power and unplug the machine before replacing the needle(s). Take care not to injure your hands or fingers on the needle point.

Use the red-handled screwdriver supplied with the machine.

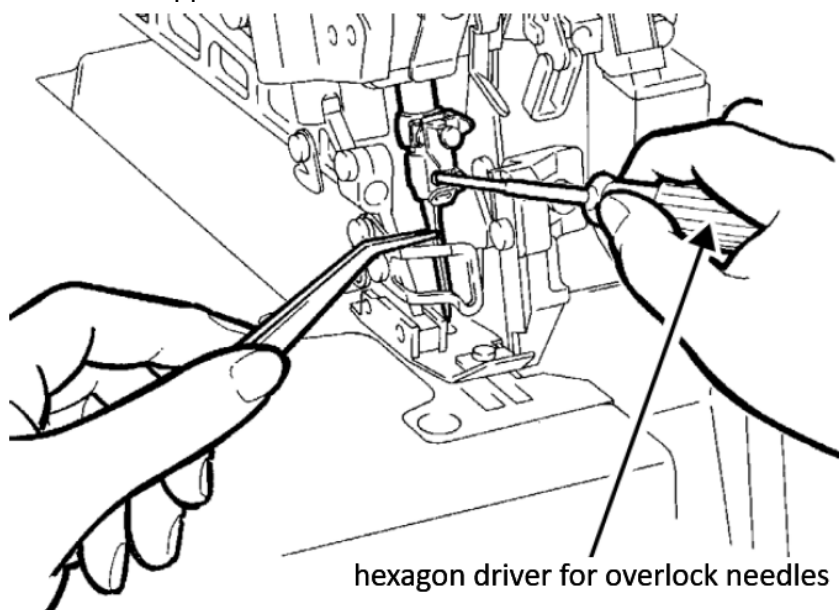


Fig. 11 — Loosening the needle-clamp screw

Loosen screw(s) 1 as shown; do not remove them completely. With the needle groove facing toward the rear of the machine, insert the needle fully into the needle clamp and securely tighten screw(s) 1.

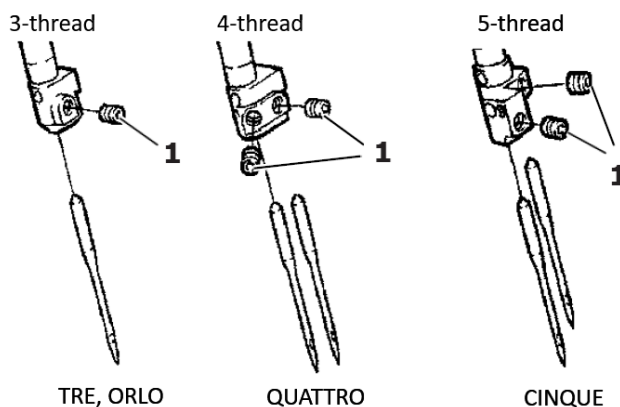


Fig. 12 — Needle arrangement for GT-U5 series

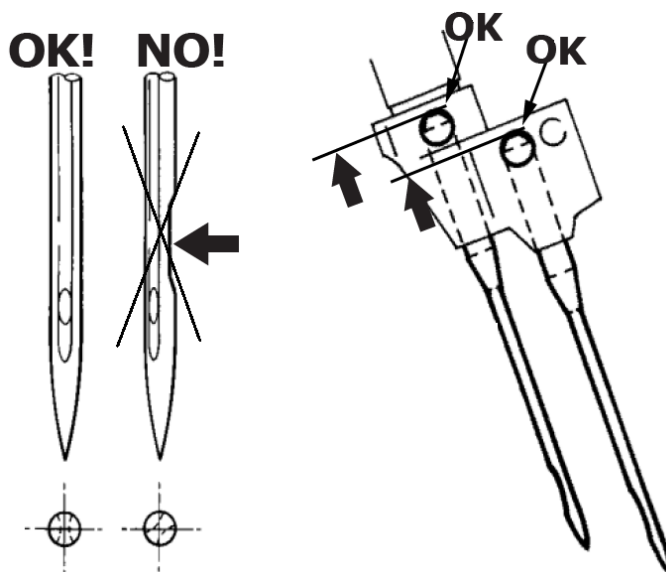


Fig. 13 — Correct needle orientation and insertion

ADJUSTING NEEDLE THREAD TENSION

Adjust thread tension with needle-thread tension knobs 2, upper-looper/thread tension knob 3, and lower-looper/thread tension knob 4 as applicable.

Turn a tension knob clockwise to increase tension and counterclockwise to decrease tension. Use the lightest possible tension that still produces balanced, attractive stitches.

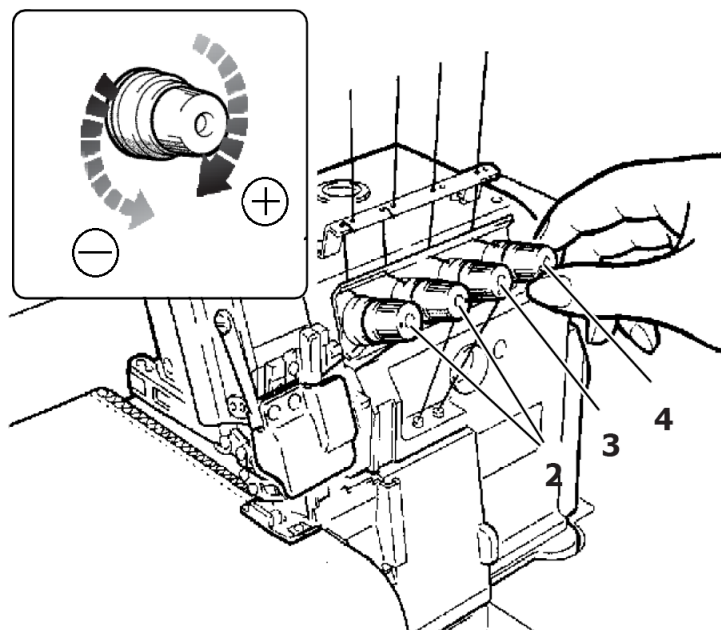


Fig. 14 — Thread-tension adjustment

OPENING AND CLOSING THE PRESSER FOOT BAR

⚠ CAUTION

Always switch off the power and unplug the machine before opening or closing the presser foot bar.

To open the presser foot bar

1. Turn the handwheel until the needle is at its highest position.
2. Move lever 1 downward and swing presser foot bar 2 outward.

To close the presser foot bar

1. Turn the handwheel until the needle is at its highest position.
2. Move lever 1 downward and return presser foot bar 2 to its original position.

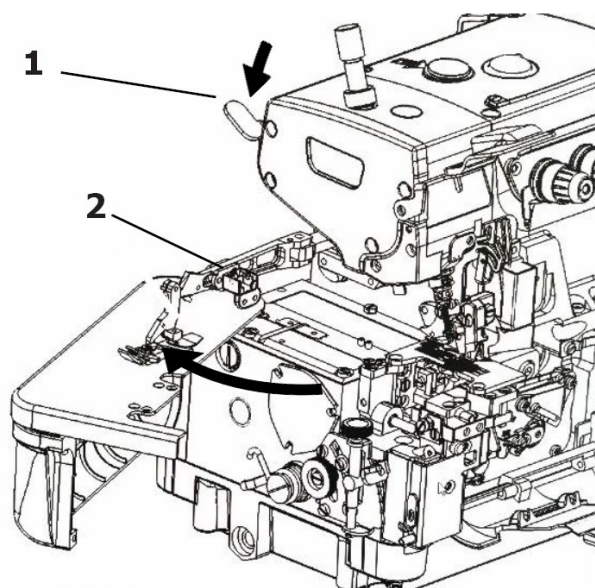


Fig. 15— Presser foot bar opening/closing

ADJUSTING PRESSER FOOT PRESSURE

Presser foot pressure should be as light as possible while still feeding the material correctly and producing uniform stitches.

1. Loosen nut 3. Adjust presser foot pressure by turning adjusting screw 4.
2. After adjustment, securely tighten nut 3.

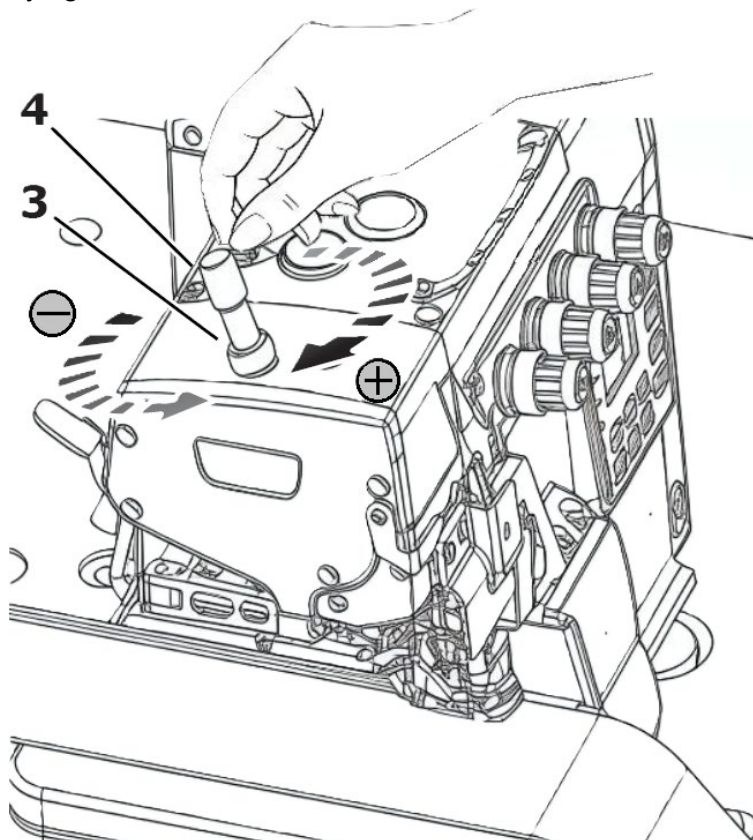


Fig. 16 — Presser foot pressure adjustment

ADJUSTING THE DIFFERENTIAL FEED RATIO

1. Loosen nut 1. To increase the differential feed ratio, move adjuster 2 in the (+) direction; the sewn material will be gathered. To decrease the ratio, move adjuster 2 in the (–) direction; the sewn material will be stretched.
2. After adjustment, retighten nut 1.

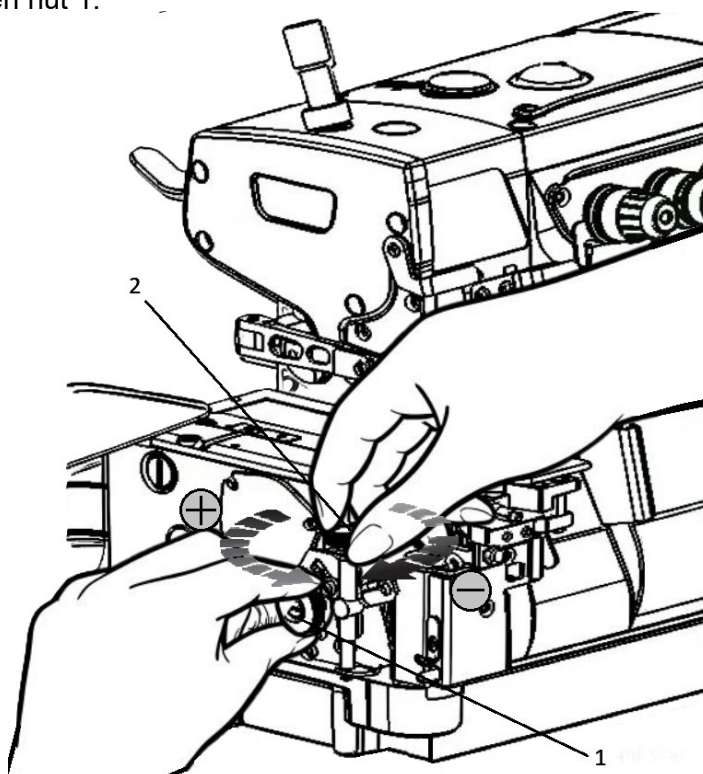


Fig. 17 — Differential feed adjustment

ADJUSTING STITCH LENGTH

⚠ CAUTION

Always switch off the power and unplug the machine before adjusting stitch length.

1. While pressing button 3, turn handwheel 4 until button 3 moves further inward.
2. With button 3 held in this position, turn handwheel 4 clockwise in the (+) direction for a longer stitch, or counterclockwise in the (–) direction for a shorter stitch.

Note: Adjust the differential feed ratio before making the final stitch-length adjustment.

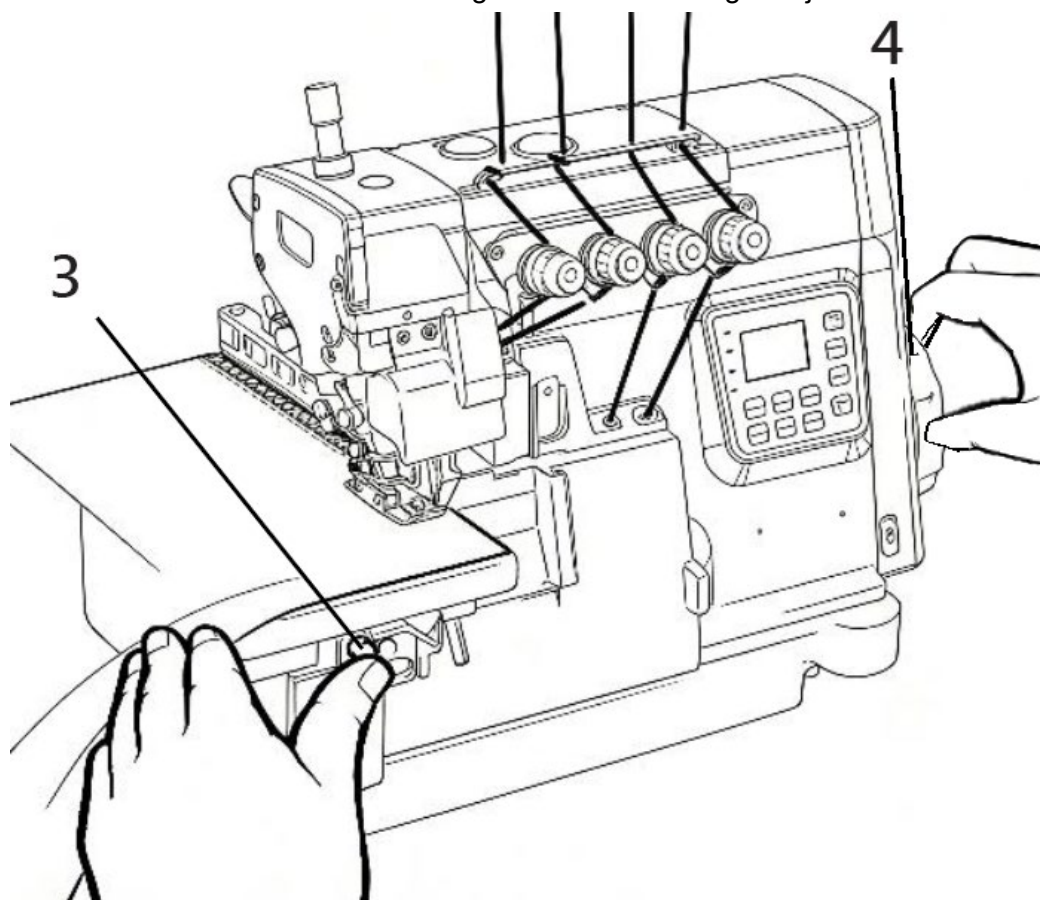


Fig. 18 — Stitch-length adjustment

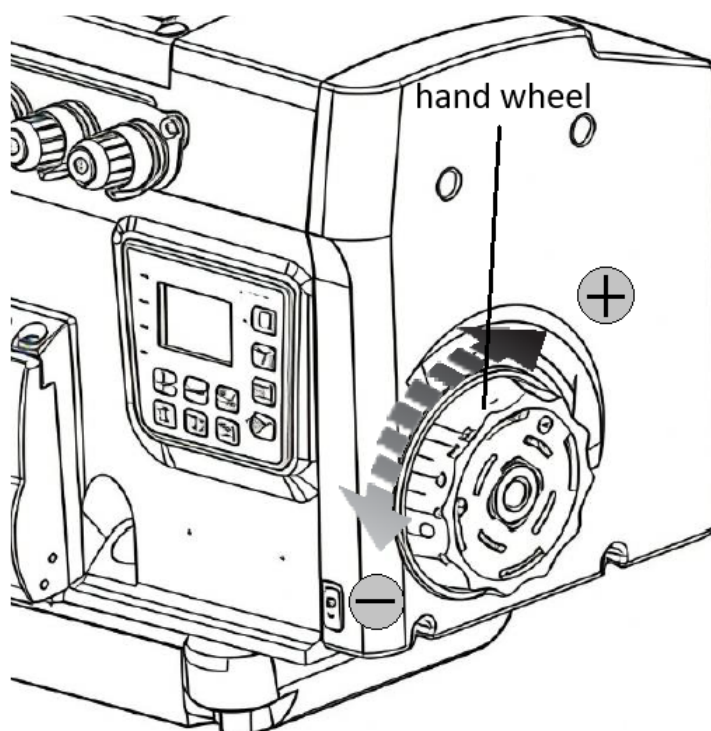


Fig. 19 — Stitch-length alignment mark

REPLACING THE UPPER KNIFE

⚠ WARNING

Always switch off the power and unplug the machine first. Knife replacement and adjustment must be performed by qualified mechanics. The cutting edges can injure hands and fingers.

1. Loosen screw 1. Move lower-knife holder 2 to its far-left position and temporarily tighten screw 1.

2. Remove screw 3 and upper knife 4. Install the new upper knife and temporarily tighten screw 3. Turn the handwheel until the upper-knife holder reaches its lowest position. Move the upper knife up or down so that the overlap between the upper and lower knives is 0.5–1.0 mm, then tighten screw 3.

3. Align the center point (A) of upper knife 4 with the center of lower knife 6 as shown. Loosen screw 1, make sure the upper knife lightly contacts the lower knife with no gap, then tighten screw

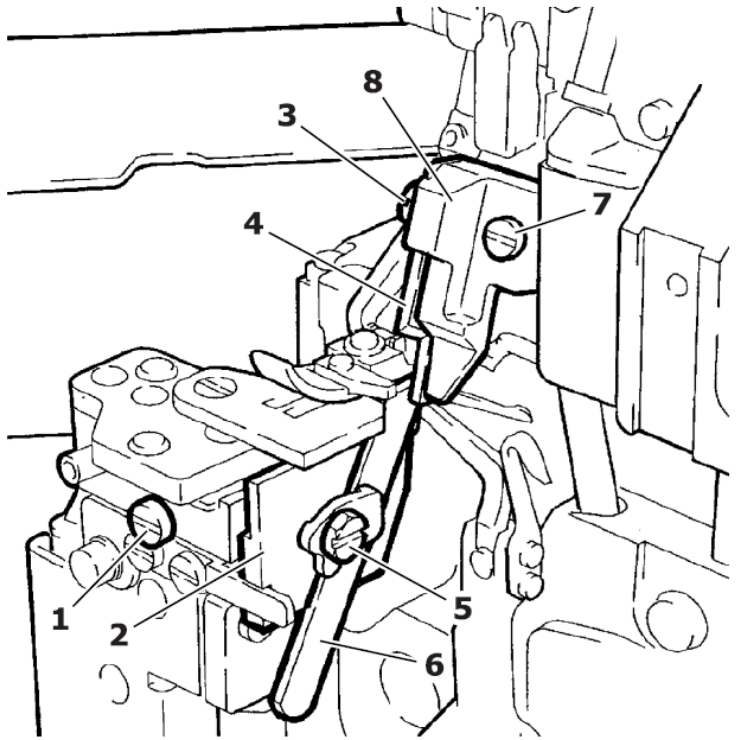


Fig. 20 — Upper/lower knife mechanism

4. Place a thread between the upper and lower knives and turn the handwheel to check that the thread is cut cleanly.

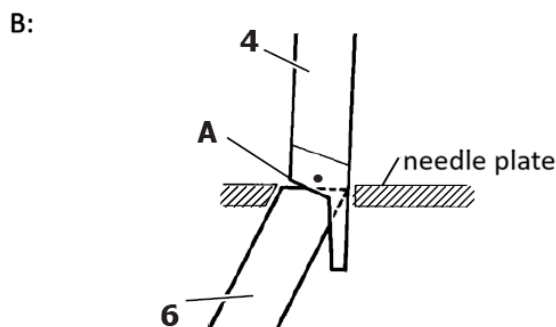
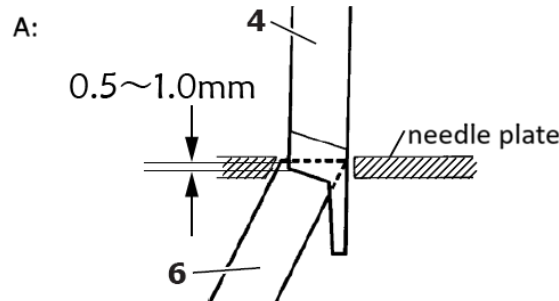


Fig. 21 — Upper/lower knife overlap

REPLACING THE LOWER KNIFE

1. Loosen screw 1. Move lower-knife holder 2 to its far-left position and temporarily tighten screw 1.
2. Loosen screw 5. Remove lower knife 6 and install a new lower knife. Set the cutting edge 0–0.3 mm below the top surface of the needle plate, then tighten screw 5.
3. Complete the adjustment as described in steps 3 and 4 of 'Replacing the Upper Knife'.

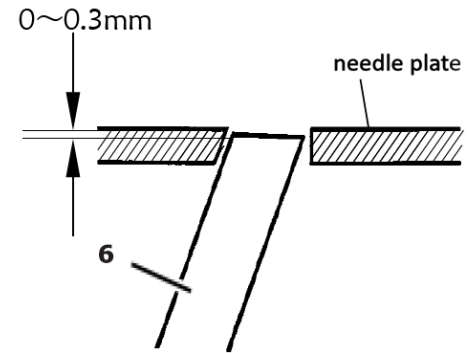


Fig. 22 — Lower knife

ADJUSTING SEAM WIDTH

1. Loosen screw 1. Move lower-knife holder 2 to its far-left position and temporarily tighten screw 1.
2. Loosen screw 3. Adjust seam width by moving upper-knife holder clamp 4 to the left or right.
3. Complete the adjustment as described in steps 3 and 4 of 'Replacing the Upper Knife'.

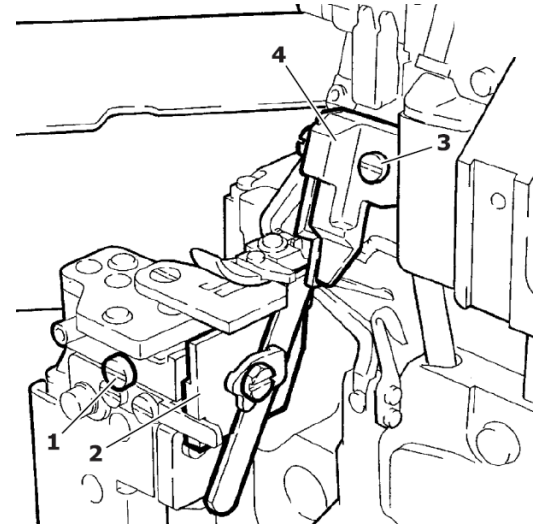


Fig. 23 — Seam-width

SHARPENING THE KNIVES

The upper knife is made of hard metal and normally requires sharpening only after long service. The lower knife must be sharpened more frequently to maintain a satisfactory cutting result.

Sharpening the lower knife

Sharpen the lower knife exactly as shown in Fig. 23. Incorrect sharpening may cause poor cutting performance or rapid loss of the cutting edge.

Upper knife

A special knife grinder is required to sharpen the upper knife. Contact distributor or an authorized Texi distributor. Keep a few spare sets of knives available to avoid production interruptions.

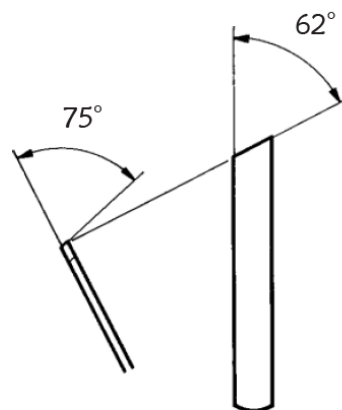


Fig. 24 — Knife sharpening angles

CLEANING THE MACHINE

⚠ CAUTION

Always switch off the power and unplug the machine before cleaning.

1. Move work table/top cover 1 and presser foot bar 2 outward. Loosen screws 3 and remove needle plate 4.
2. Clean the grooves in the needle plate and the area around the feed dogs.
3. After cleaning, reinstall needle plate 4 with screws 3, then return work table/top cover 1 and presser foot bar 2 to their original positions.

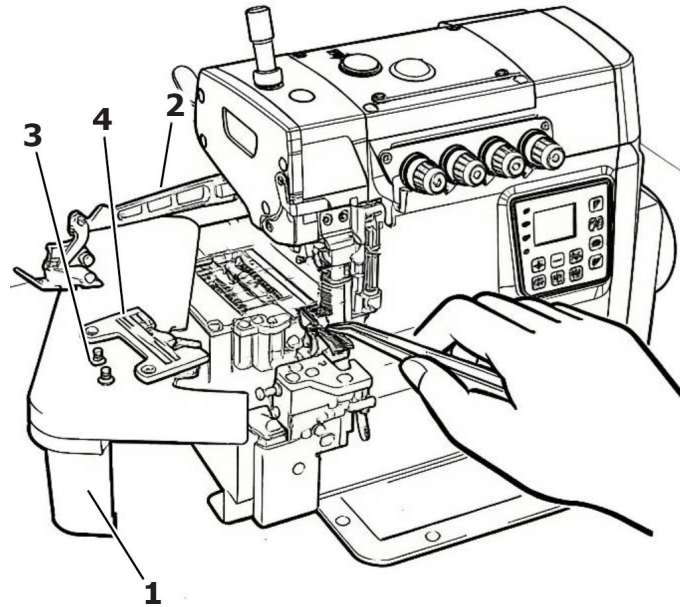


Fig. 25 — Cleaning around the needle plate and feed dogs

CHANGING THE OIL

⚠ CAUTION

Switch off the machine and disconnect the power plug before changing the oil. Oil changes should be carried out by authorized mechanics.

Change the oil one month after first use and every six months thereafter. Continued use of old oil may cause machine damage.

DRAINING THE OIL

1. Drain the oil by removing screw 5 from the left side of the oil pan/reservoir.
2. After draining, reinstall and tighten screw 5.

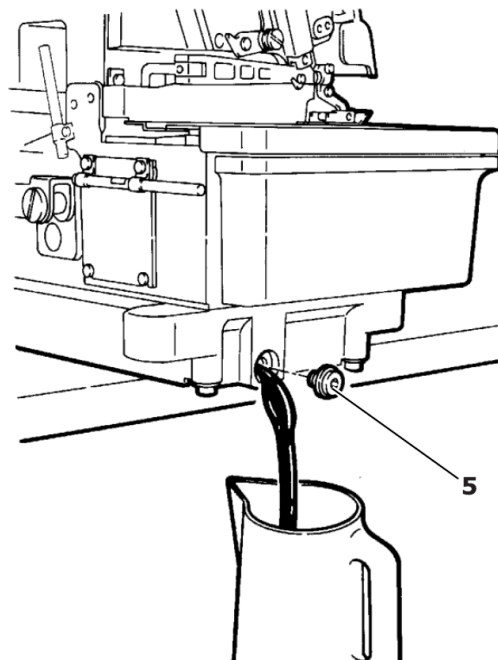


Fig. 26 — Oil drain screw

CHECKING AND REPLACING THE FILTER

⚠ CAUTION

Always switch off the power and unplug the machine before checking or replacing the filter. This work should be performed by qualified technical personnel.

If filter 5 is clogged with dust or dirt, the machine will not be lubricated correctly. Check filter 5 every six months and clean or replace it as necessary.

Removing the filter (Fig. 26)

Remove parts 1 through 5 in the order shown and inspect the filter. If filter 5 is damaged, replace it with a new one.

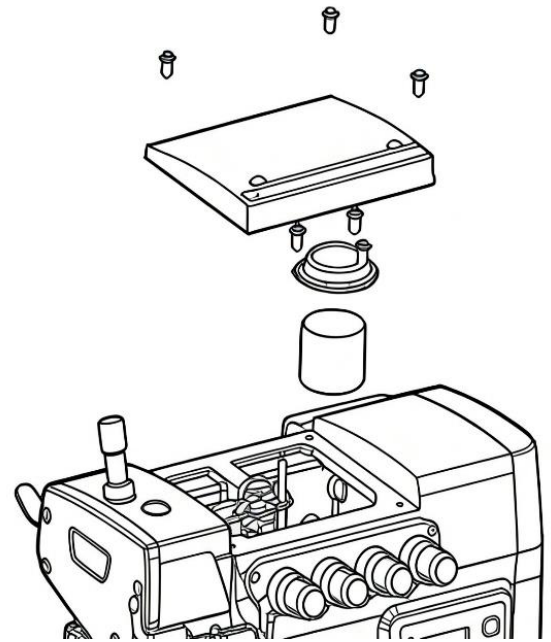


Fig. 27 — Filter removal and inspection

POSITIONING THE DOUBLE-CHAINSTITCH LOOPER THREAD TAKE-UP AND THREAD GUIDES

Adjusting the amount of thread taken up

⚠ CAUTION

Always switch off the power and unplug the machine first. The following adjustment must be performed by qualified mechanics.

1. Turn the handwheel until the needle is at its highest position.
2. Align point A of double-chainstitch looper thread take-up 1 with the upper edge of the holder. Loosen screws 2 and rotate thread take-up 1 to adjust.
3. Align point B of thread guide 3 with point B of thread take-up 1. Loosen screw 4 and move thread guide 3 up or down.
4. To adjust thread guides 5 and 6, loosen screws 7 and 8 and move guides 5 and 6 left or right as shown. For more thread, move the guides in the (+) direction. For less thread, move them in the (–) direction.

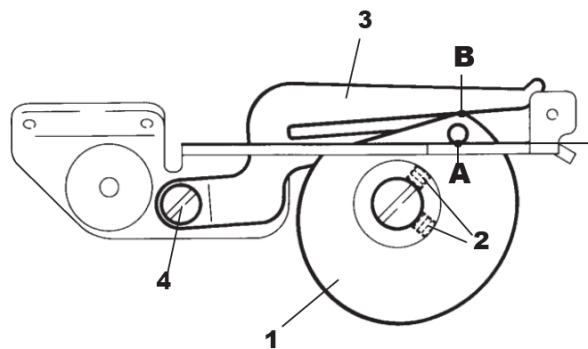


Fig. 28 — Double-chainstitch looper thread take-up position

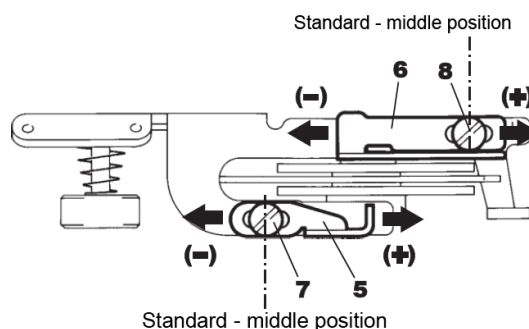


Fig. 29 — Thread-guide adjustment; standard setting is the middle position

Adjusting the looper thread take-up amount

⚠ CAUTION

Always switch off the power and unplug the machine first. The following adjustment must be performed by qualified mechanics.

1. Adjust lower-looper thread take-ups 1 and 2 with the lower looper at the far-right end of its travel. Use the standard positions shown in Fig. 36. Loosen screws 3 and 4 and move thread take-ups 1 and 2. Move them in the (+) direction to increase the amount of lower-looper thread supplied, or in the (–) direction to decrease it.
2. Adjust lower-thread take-up 5 according to the standard position shown. Loosen screw 6 and move take-up 5 as shown. Move it in the (+) direction to increase the amount of lower-looper thread supplied, or in the (–) direction to decrease it.
3. Adjust lower-thread guides 7 and 8 according to the standard positions shown. Loosen screws 9 and 10 and move guides 7 and 8. Move them in the (+) direction to increase the amount of lower-looper thread supplied, or in the (–) direction to decrease it.

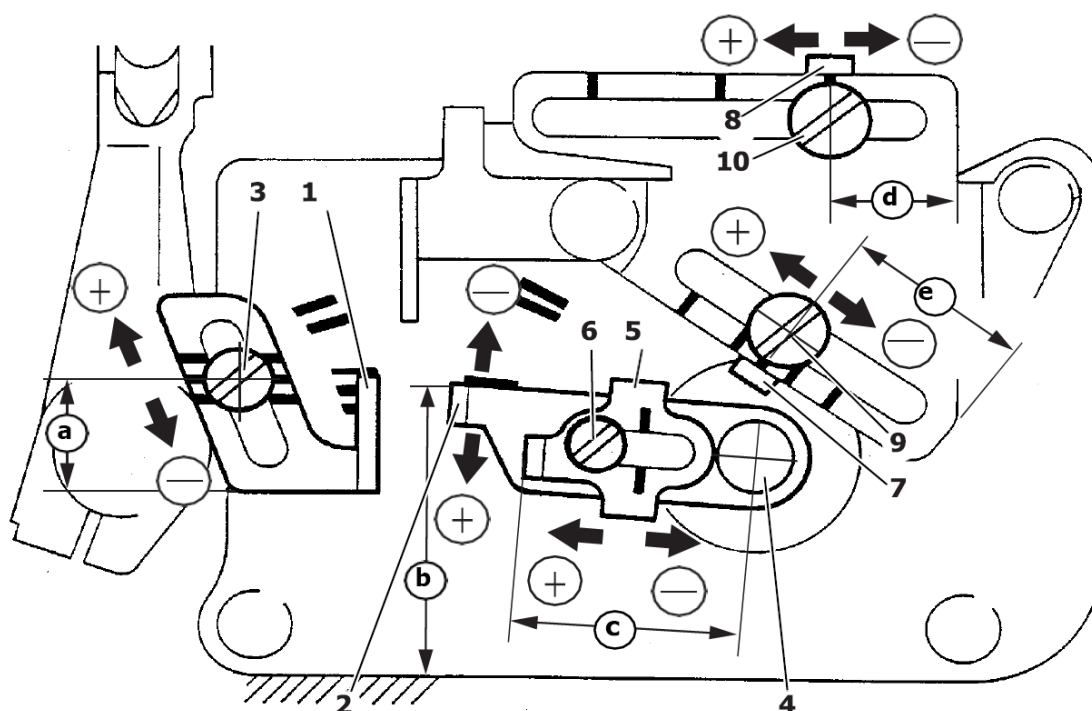


Fig. 30 — Looper thread take-up and thread-guide standard positions

Standard adjustments

Attention: Any adjustment can be performed only by qualified personnel. Guards of the machinery, to be removed to allow the control and regulation, should be re-installed before restarting the machine.

Settings

					
	Needle bar height (mm)	Lower loop to needle clearance (mm)	Upper loop to needle clearance (mm)	Bottom transporter height (mm)	Fabric clearance (mm)
Tre / Orlo	10.1	4.2	3.3	0.9 – 1.1	5.5
Quattro	10.6	4.2	3.3	0.9 – 1.1	5.5

						
	Needle bar height (mm)	Lower loop to needle clearance (mm)	Upper loop to needle clearance (mm)	Bottom transporter height (mm)	Fabric clearance (mm)	Chainstitch loop to needle clearance (mm)
Cinque	10.6	3.9	3.3	0.9 – 1.1	5.5	1.5

ASK YOUR SUPPLIER ABOUT:

	Machine needle with tip adjusted to sewed material: R - round, standard tip for most fabrics. SPI - very slim, acute tip, for a precise piercing of densely woven materials. SES - light ball point, especially suitable for jersey, tricot, elastic woven materials. SUK - medium ball point, best corsetry, jeans, coarse knitted fabrics and also elastic materials.
	TERESSTIC T32 High class oil for high-speed machines as overlock and coverstitch machines. Based on mineral oil. Used for central and point lubrication.
	SPIRIT 37 Silicon fluid modified especially for textile industry. Used for preparation of sewing thread and yarn, lubrication of knitting machine needles. Colourless and odourless. Applied with brushm sprinkle or through immersion.
	TWE6 Tweezers

CE DECLARATION OF CONFORMITY

Distributor:

Strima Sp. z o.o.

Swadzim, ul. Poznańska 54

62-080 Tarnowo Podgórne, Poland

We declare, that the following product:

High speed overlock sewing machine

Model: **Tre 1F, Orlo 1F, Quattro 1F, Cinque 1F, Quattro 3F**

was designed and manufactured in compliance with the following directives:

2014/35/EU Low Voltage Directive

2014/30/EU Electromagnetic Compatibility Directive

2006/42/EC Machinery Directive

Harmonized norms used:

EN ISO 12100:2010

EN ISO 10821:2005+A1:2009

EN 60204-1:2006+A1:2009+AC:2010

EN 60204-31:2013

Certificate of Conformity number: No.: 2T151222.ZBSQS33

Technical Construction File No.: RVT-BY20151211.003.007.009

Test Report No.: OViS202312065M, OViS202312065E

Notified body No: 2891

Strima Sp. z o.o.
Swadzim 15.07.2025

NOTES

This image shows a single sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

Dealer:

The Texi logo, featuring a stylized purple flower icon followed by the word "texi" in a lowercase, italicized, purple serif font.