Manual instruction

Mechatronic Post-Bed

Lockstitch Machine

with Built-in Energy Saving Motor,

control box and control panel

Post DD

HD texi®

Notes for using this operation manual and parts book

1. This book is applicable to sewing machine which have the same plate number as shown on the cover of this book.
2. This book was prepared based on information available in December 2014.
3. Parts are subject to change in design without prior notice.

CONTENTS

1. Safety

1.1. Safety symbols

Danger!
Points to be observed.

Danger of injury for operating and specialist personnel!

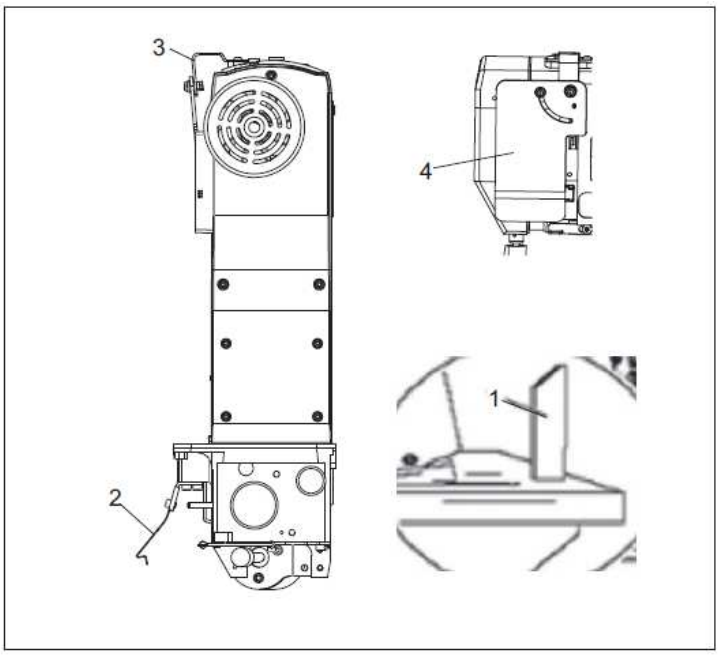
Caution
Do not operate without finger guard and safety devices.

Switch off machine before threading, changing bobbin and needle, etc.

1.2. Important points for the user

- This Manual Instruction is a component of the machine and must be available to the operating personnel at all times.
- The Manual Instruction must be read before operating the machine for the first time.
- The operating and specialist personnel must be instructed in the safeguards of the machine and safe work methods.
- It is the duty of the user to operate the machine in perfect running order.
- It is the obligation of the user to ensure that none of the safety mechanisms are removed or deactivated.
- It is obligation of the user to ensure that only authorized persons operate and work on the machine.

1.3. Danger



A working area of 1 meter is to be kept free both in front of and behind the machine in operation so that the machine is always accessible.

Never reach into the sewing area while sewing!
Alert of injured of the needle!

Never leave objects on the table while adjusting the machine's settings!
Object can be trapped or slung away!
Alert of accident!

Do not operate the machine without support 1!
Danger due to top-heavy sewing head!
Machine can tip over backwards when tilted!

Switched off the machine before tilting it backwards to prevent accident caused by abrupt start of the sewing machine.

Do not operate the machine without its take-up-lever guard 3 to prevent accident due to its motion.

On machines with thread lubricator, only operate the machine with eye guard 4 lowered as it will protect the eyes from oil particles of the thread lubrication.

Do not operate the machine without tilt lock 2 to prevent crashing between machine head and table top.

2. Proper use

Texi Post DD is a single needle, high speed post bed sewing machine (post to the right of the needle) with driven feed wheel and roller presser and synchronized needle.

The machine is used for sewing lockstitch seams in leather and upholstery industries.

Any use of the machine which is not approved by the manufacturer shall be considered as improper use!

Manufacturer shall not be liable for any damage caused by improper use.

Proper use shall also be considered to include compliance with the operation, adjustment, service and repair measures specified by the manufacturer.

3. Specifications

Stitch type……..	301/ lockstitch
Clearance under roller presser……..	7 mm
Clearance width…….	245 mm
Clearance height……..	115 mm
Post height……	180 mm
Sewing head dimensions	
Length…….	Approx. 615 mm
Width……..	Approx. 240 mm
Height (above table)…….	Approx. 500 mm
Bedplate dimensions……..	518 x 177 mm
Max speed (depends on the materials, work operation and stitch length)…….	3000 spm
Connection data	
Operating voltage……..	220V +/- 10%, 50/60 Hz
Max. power consumption……..	1.2 kVA
Fuse protection……..	1 x 16 A/ insert
Noise data	
Emission sound level at the work place at appropriate speed (DIN 45 635-48-A-1, ISO 11204, ISO 3744, ISO 4871)	
Noise measurement in accordance with DIN 45 635-48-A-1, ISO 11204, ISO 3744, ISO 4871	
At speed 2400 spm……	Lpa ≤ 79 dB (A)
At speed 1600 spm……	Lpa ≤ 73 dB (A)
KpA = 2,5 dB	
Net weight of sewing head……	Approx. 61 kgs
Gross weight of sewing head……	Approx. 71 kgs
Additional equipments: D3 – Automatic edge trimmer, automatic presser foot lifter, bartacking device.	

Needles and threads

This machine is dedicated for Medium-weight material (M).
However, by changing some parts, it can also be used to sew thick materials (H).

Model	Thread thickness (Nm) max. Synthetics	Needle thickness 1/100mm *	Needle system
M	40 / 3	90 / 14	134
H	15 / 3	120 / 14	134

* or similar strengths of other types of thread.

4. Explanation of symbols

In this Manual instruction, work to be carried out or important information is accentuated by symbols which have the following meanings:

Note, information

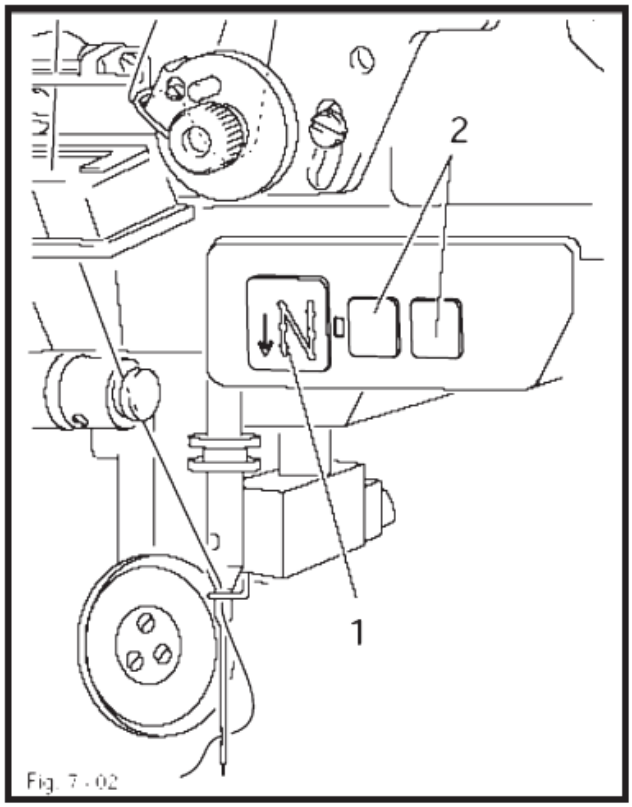
Cleaning, care

Lubrication

Maintenance, repairs, adjustment, service work (only to be carried out by technical staff)

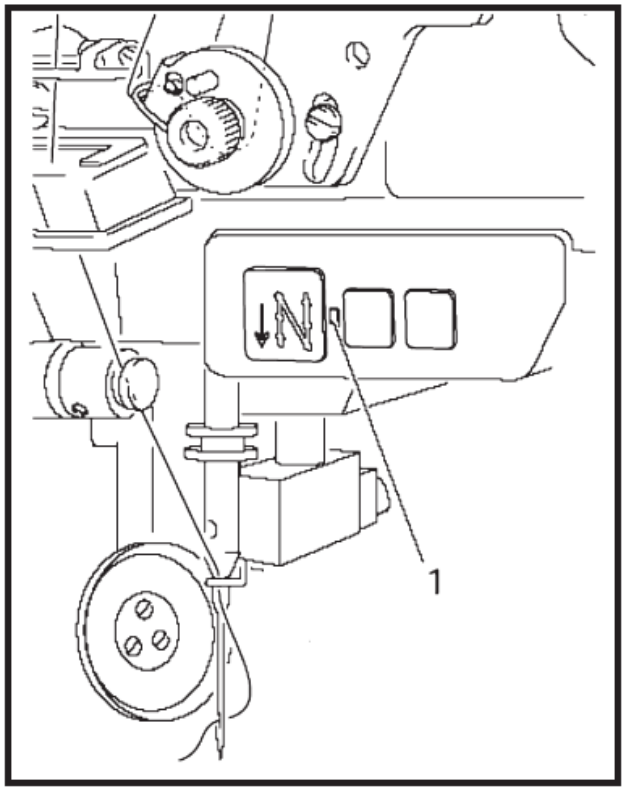
5. Controls

5.1. Keys on the machine head



- As long as key 1 is pressed during sewing, the machine sews in reverse direction.
- Keys 2 can be used for parameter settings, Manual instruction of Control box.

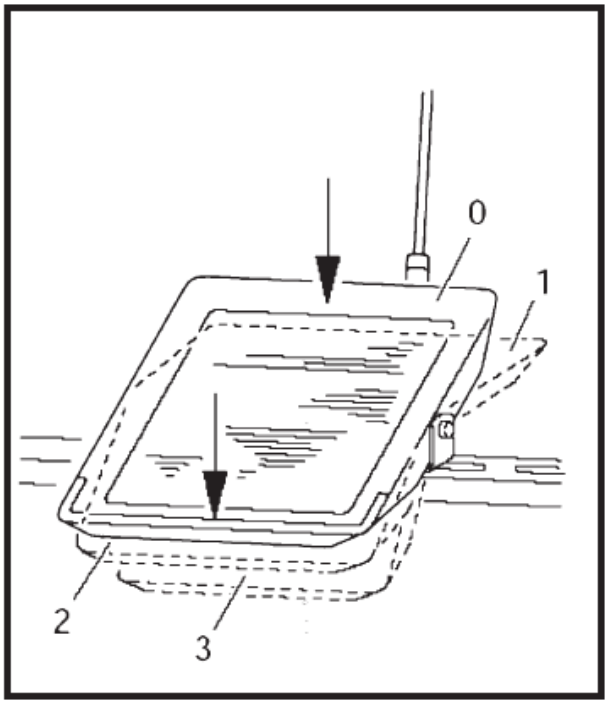
5.2. Bobbin thread monitoring with stitch counting



- About 100 stitches before reaching the preset number of stitches, LED 1 flashes.
- After the thread has been trimmed and the bobbin changed, the stitch counting restart from beginning.

Presetting the number of stitches, see **Instruction Manual of Electronic Control.**

5.3. Pedal



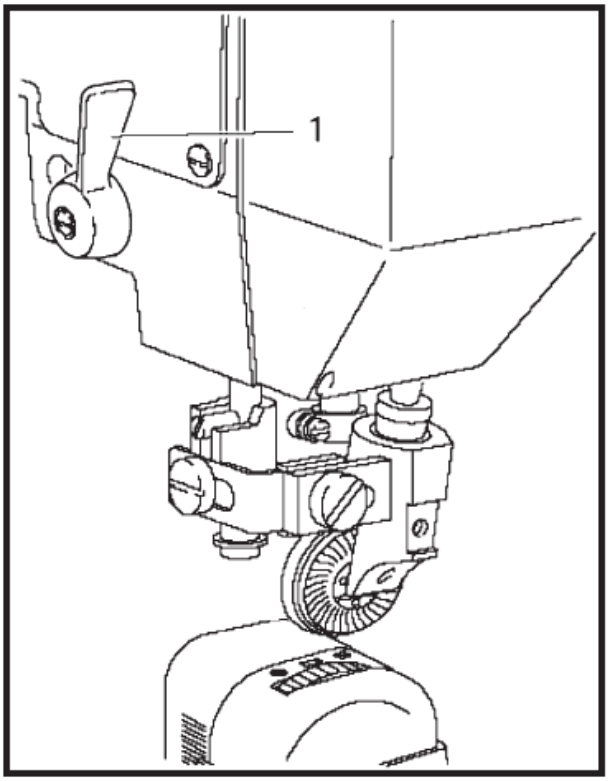
0 = Neutral position

1 = Sewing

2 = Raising roller presser

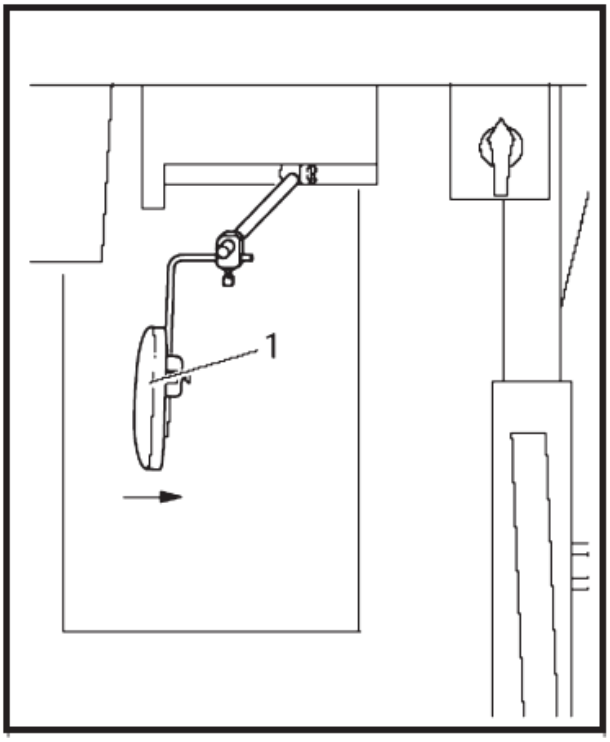
3 = Trim sewing threads

5.4. Lever for lifting roller presser



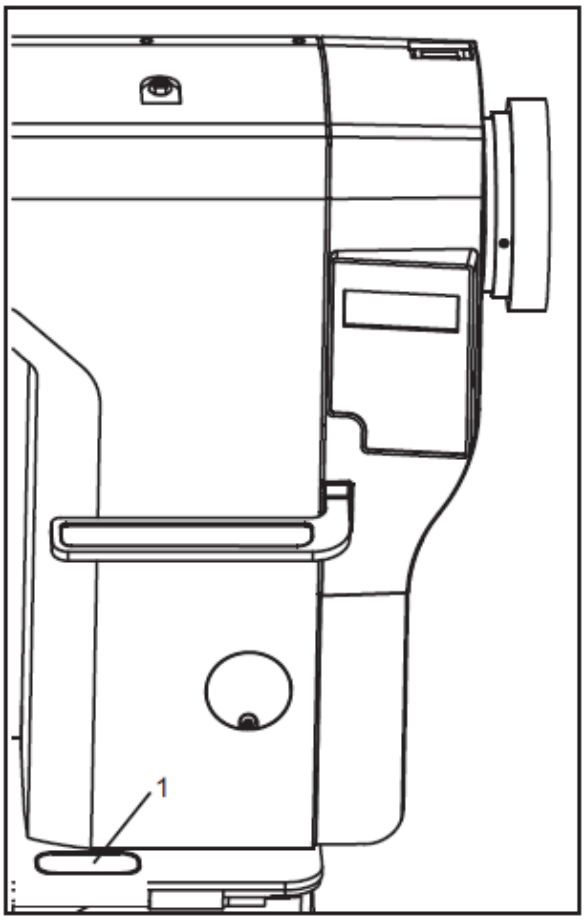
The roller presser can be raised by turning lever 1.

5.5. Knee lever



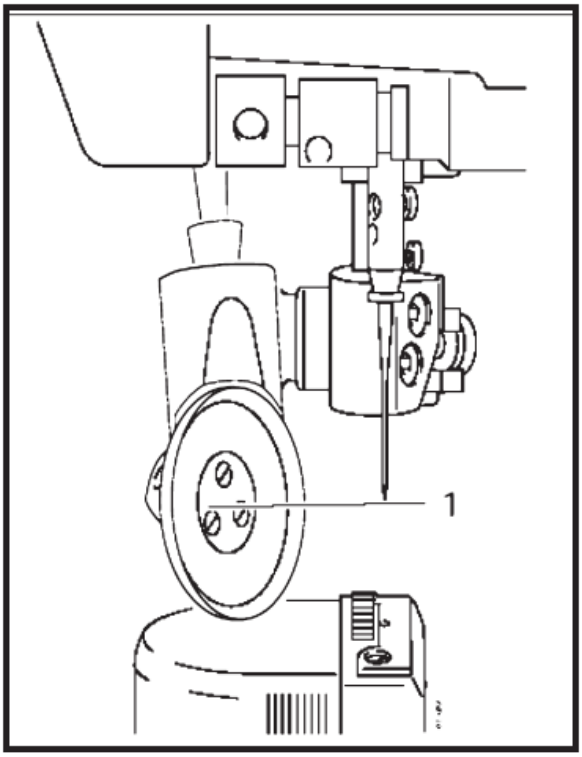
The roller presser can be raised pressing the knee lever 1 in the direction shown by the arrow.

5.6. Key for setting stitch length



The stitch length is set by pressing key 1 and turning the balance wheel (see **Chapter 7.6. Setting the stitch length**).

5.7. Swing out roller presser



When the roller presser is raised, it can be swung out by pulling it lightly downwards.

6. Installation and commissioning

The machine must only be installed and commissioned by qualified personnel.
All relevant safety regulations must be strictly adhered to.

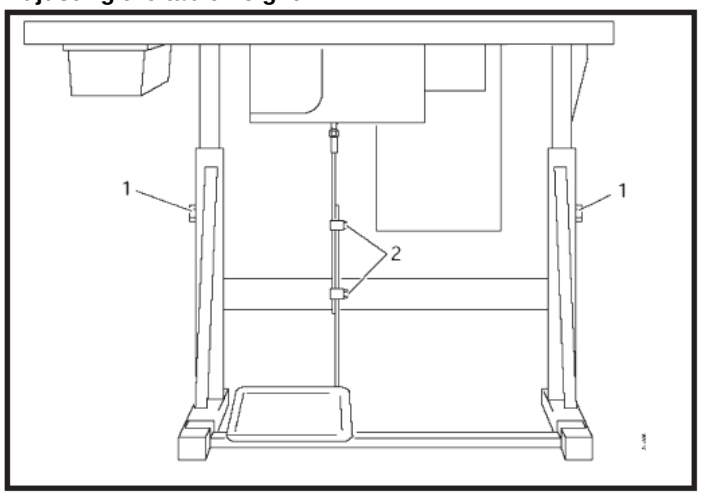
If the machine is delivered without a table top, be sure to use table stand and table top that can hold the weight of the machine with its motor.
It is very important to ensure that the stand of the machine is firm and steady, also during sewing.

6.1. Installation

The site where the machine is installed must be provided with suitable connections for electric current. It must be ensured that the standing surface of the machine site is firm and horizontal, and that sufficient lighting is provided for.

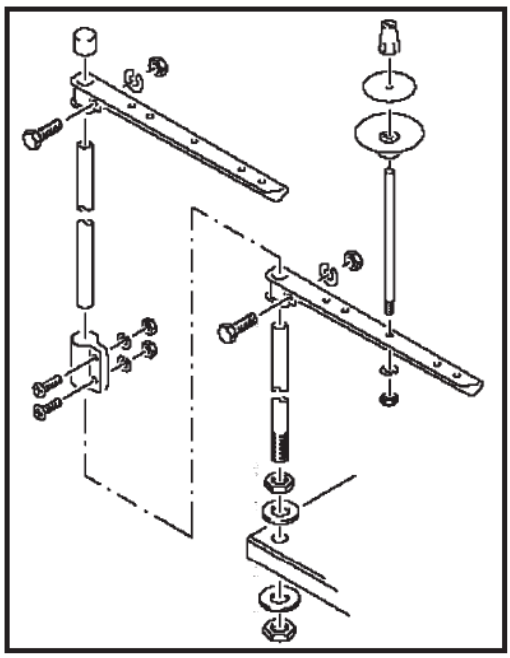
For packing and transportation reasons the table top is in the lowered position. The table height is adjusted as described below.

6.1.1. Adjusting the table height



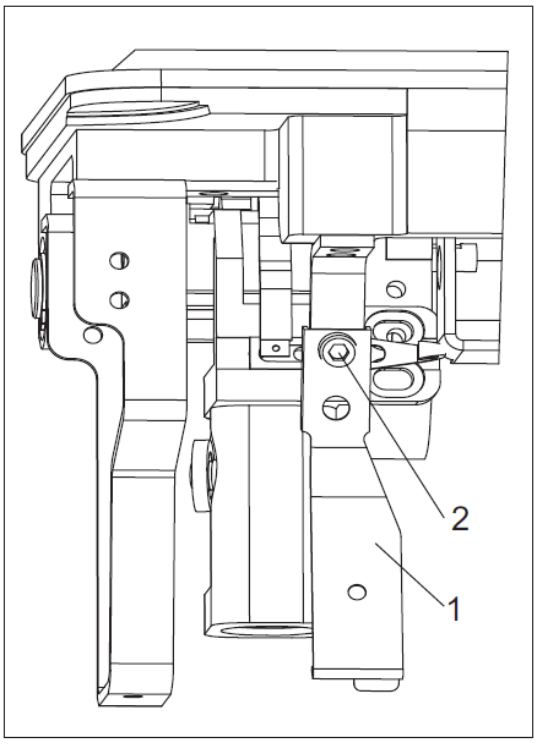
- Loosend screws 1 and 2 and set the table height as required.
- Firmly tighten screw 1.
- Set the required pedal position and tighten screw 2.

6.2. Fitting the reel stand



- Fit the reel stand as shown in Figure.
- Afterwards, insert the stand in the hole of the table top and secure it with nuts provided.

6.3. Install the safety plate for tilting the machine head



- Turn off the machine main power switch. There is a risk of injury if the machine accidentally start.
- Use screw no. 2 to fix the safety plate (using the screwdriver provided on accessories tools).
- Do not turn on the machine without safety plate! There is a risk of inquiry between machine head and table top.

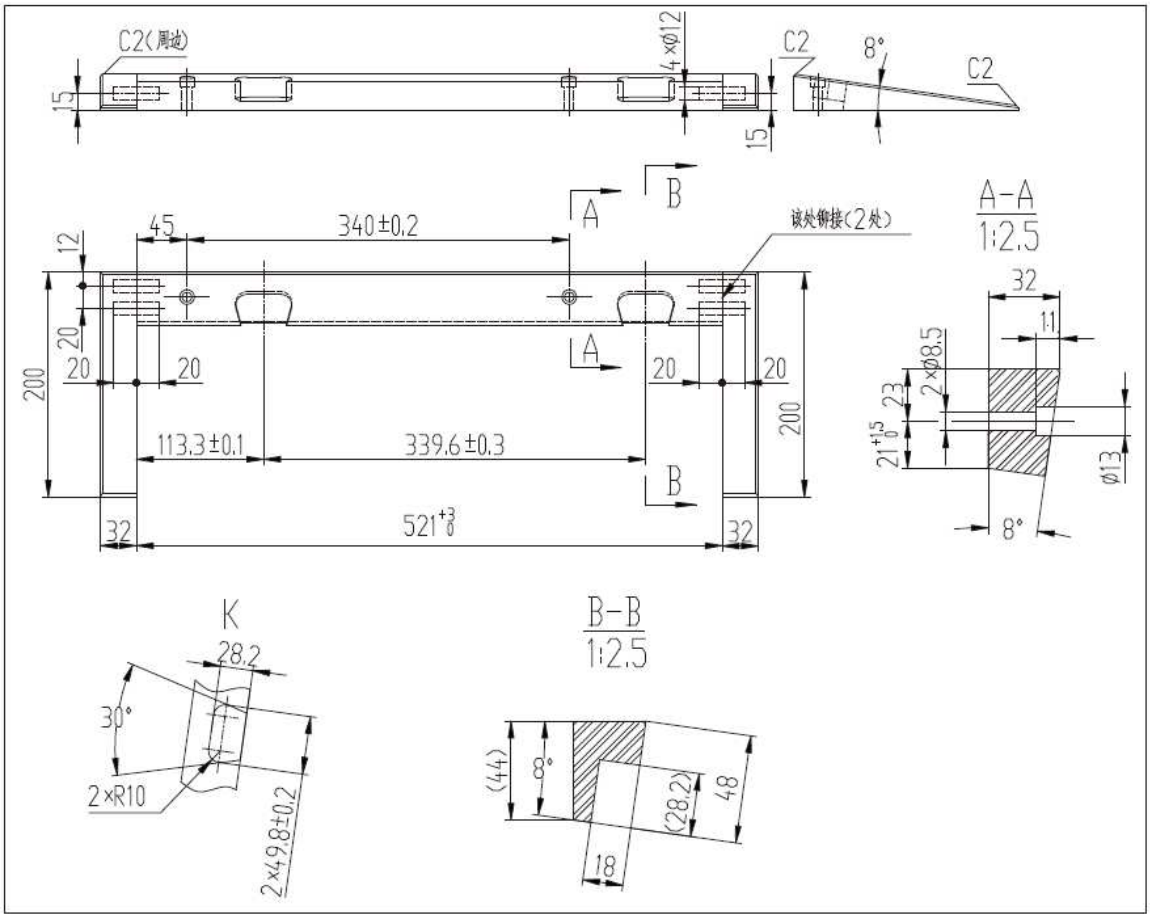
6.4. Commissioning

- Check the machine, particularly the electrical wiring for any damage.
- Clean the machine thoroughly and then oil it or fill oil in (see Chapter 11 – Care and maintenance).
- Have a mechanic check whether the motor of the machine can be operated with the available power supply, and that the motor is correctly connected in the junction box. If there are any discrepancies, the machine **must not be operated under any circumstances**.

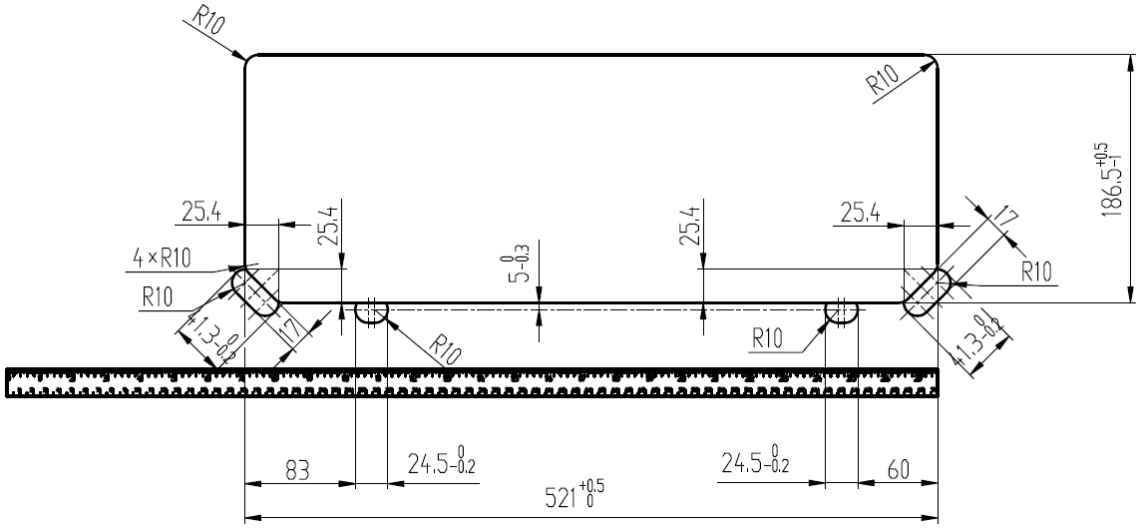
The machine only be connected to an earthed socket!

- When the machine is running, the balance wheel must turn towards the operator. If it does not, the motor connection must be changed by a mechanic.
- Machine with pneumatic equipment must be connected to the compressed air supply. The pressure gauge should indicate a pressure of 6 bar. If necessary, adjust to the correct setting (see **Chapter 8.1. Checking/adjusting the air pressure**).

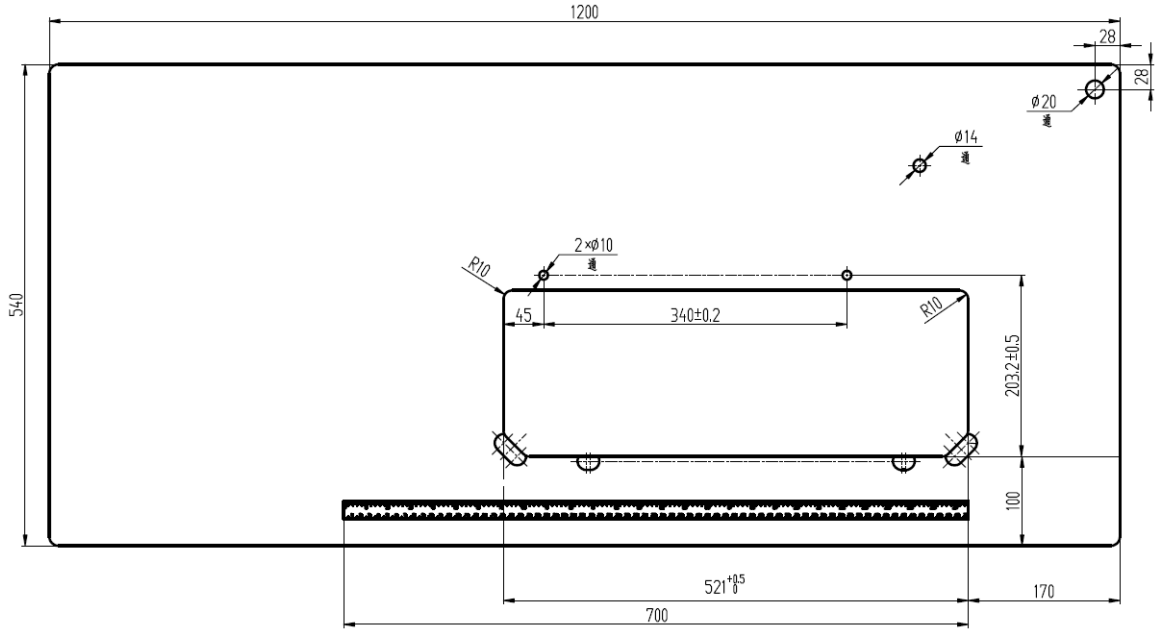
6.5. Tilted work base



6.6. Tilted work base



6.7. Mounting the table top



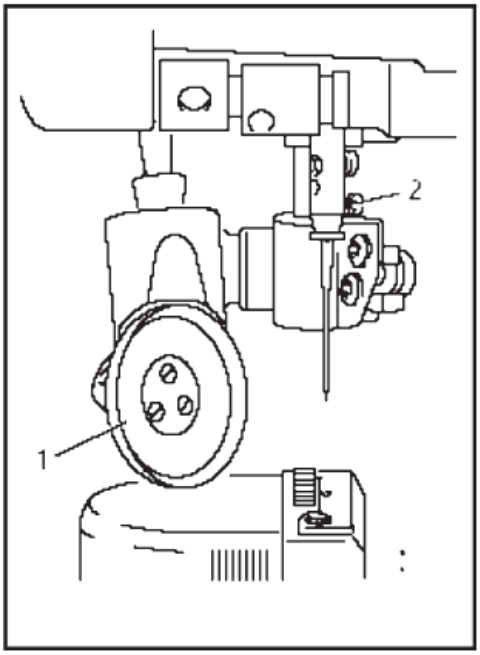
7. Preparation

All instructions and regulations in this Manual Instruction must be observed.
Special attention is required to all safety regulations.

All installation/setting-up the machine must only be carried out by personnel with appropriate training.
During installation/setting-up, the machine must be disconnected from power supply by turning of the on/off switch or removing the plug from electric power socket.

7.1. Inserting needle

Warning: Turn OFF the power before starting the work as to prevent accident caused by abrupt start of the sewing machine.

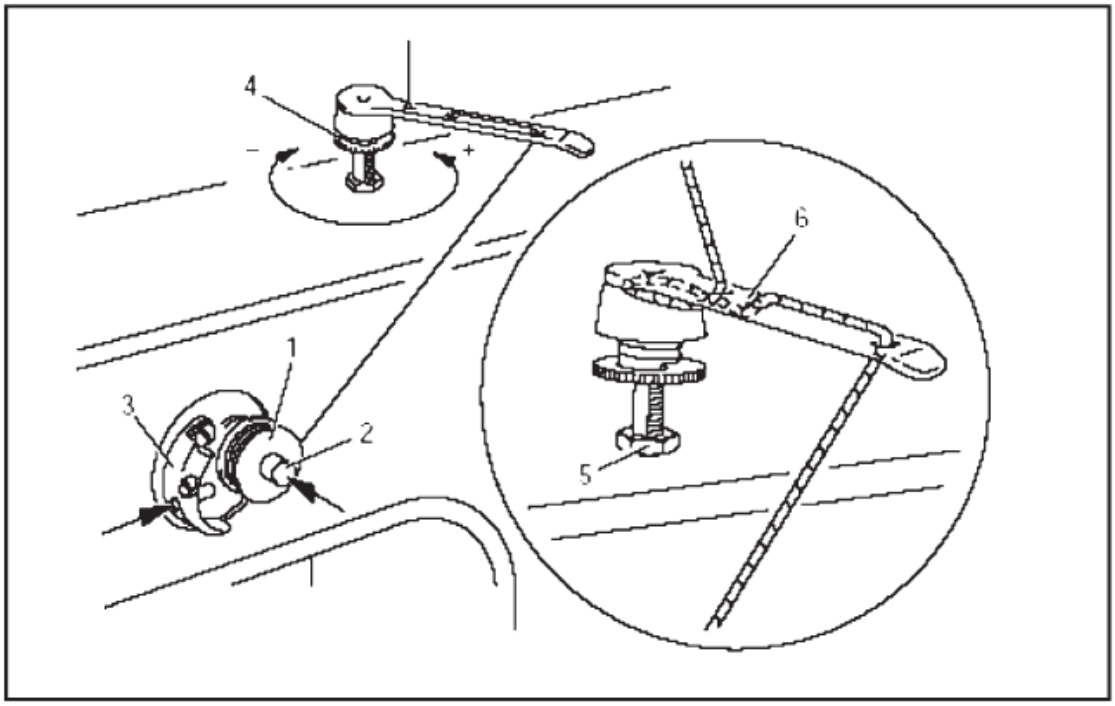


Only use needle system **134**

- Raise the roller presser 1 and swing it out.
- Loosen screw 2 and insert the needles as far as possible. The long groove must face to the left.
- Tighten screw 2 and swing roller presse 1 back to position.

NOTE:
The choice of needle depends on the model of machine, the thread and the material used.
See **Chapter 3. Specifications – Needles and threads.**

7.2. Winding the bobbin thread; adjusting the primary thread tension



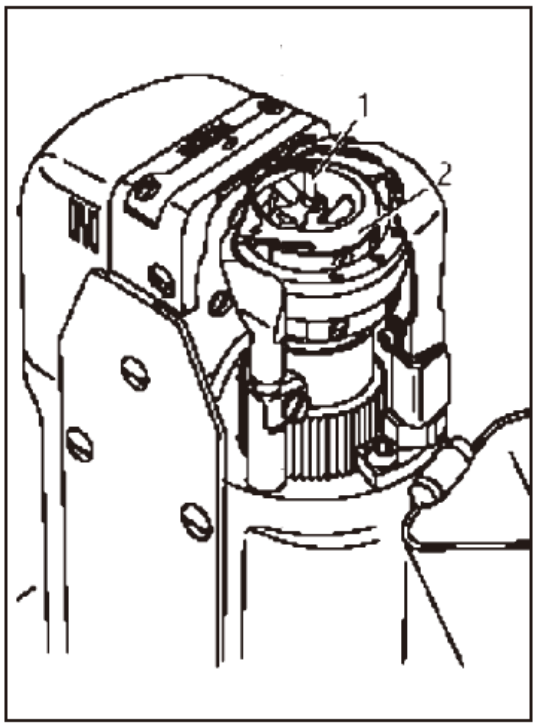
- Place an empty bobbin 1 into bobbin winder spindle 2.
- Thread the bobbin as shown in Fig. – and wind it clockwise around bobbin 1 a few times.
- Switch on the bobbin winder while pressing bobbin winder spindle 2 and lever 3.

The bobbin is filled up during sewing.

- The thread tension of bobbin 1 can be adjusted by knurled screw 4.
- The bobbin winder stops automatically when bobbin 1 is full.
- If the thread is wound unevenly:
  - Loosen nut 5.
  - Turn thread guide 6 accordingly
  - Tighten nut 5.

7.3. Removing/inserting the bobbin case

Warning: Turn OFF the power before starting the work as to prevent accident caused by abrupt start of the sewing machine.



Removing the bobbin case:
- Open the post cap.
- Raise latch 1 and remove bobbin case 2.

Inserting bobbin case:
- Insert bobbin case 2
- Close the latch and close the post.

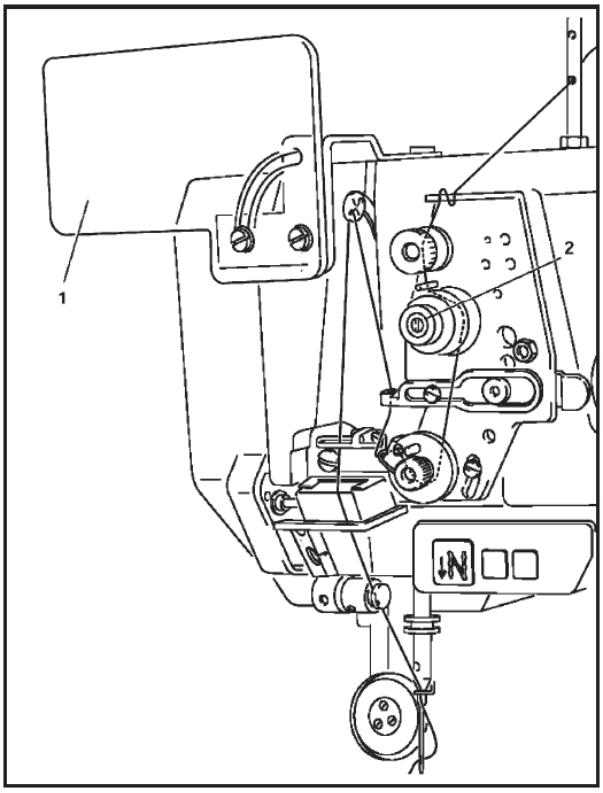
7.4. Threading the bobbin case/adjusting the bobbin thread tension

- Insert the bobbin into the bobbin case 1.
- Pass the thread through the slot under spring 2.
- Pass the thread through the notch.
- Adjust the thread tension by turning screw 3.

When the thread is pulled, the bobbin must rotate in the direction of the arrow.

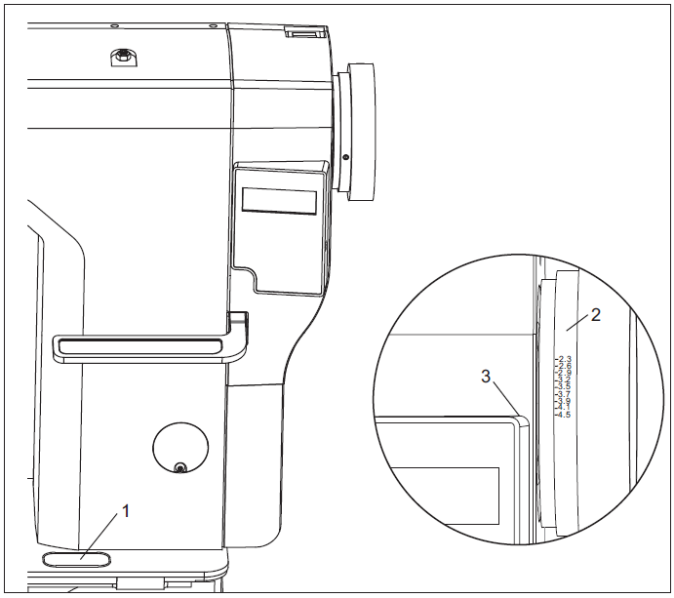
7.5. Threading the needle thread and regulating its tension

Warning: Turn OFF the power before starting the work as to prevent accident caused by abrupt start of the sewing machine.



- Tilt the eye guard 1.
- Thread the needle thread as shown in Fig.
- The needle is threaded from left to right.
- Adjust the needle thread tension by turning milled screw 2.

7.6. Setting the stitch length



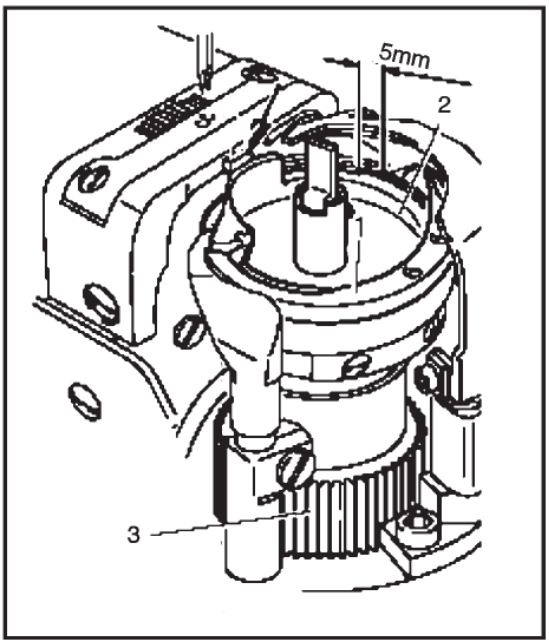
- Press key 1 and at the same time turn the balance wheel until the stitch setter clicks into position.
- Hold down key 1 and turn the balance wheel until the stitch length required is shown on the scale 2 opposite the bottom edge 3 of the belt guard recess.

8. Care and maintenance

Clean…….. Daily, more frequently if in continuous operation.
Oil level (thread lubrication/hook lubrication)….. Daily, before use.
Oil the hook…….. Daily, before use.
Lubricate the bevel gears…….. Once a year.

8.1. Cleaning

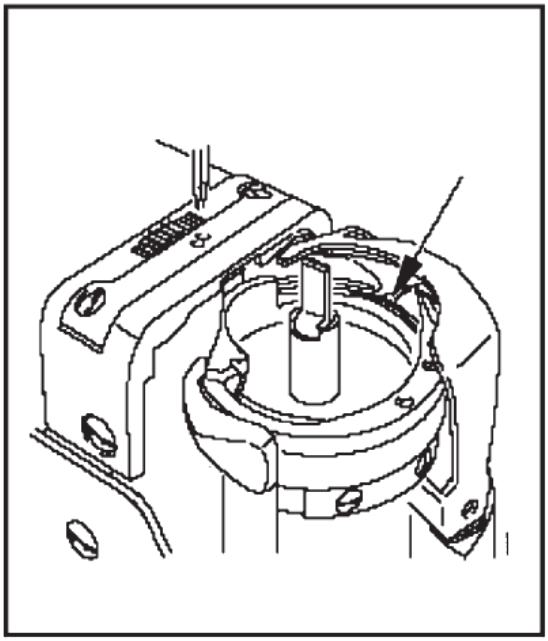
Warning: Turn OFF the power before starting the work as to prevent accident caused by abrupt start of the sewing machine.



- Bring the needle bar to its highest position.
- Open the post cap and remove the bobbin case cap and bobbin.
- Un-screw hook gib 1.
- Turn the hand wheel until the point of bobbin case 2 penetrates into the groove of the hook race approx. 5 mm.
- Remove bobbin case 2.
- Clean the hook race with parafin.
- When inserting the bobbin case 2, ensure that the horn of the bobbin case 2 engages in the groove of the needle plate.
- Screw hook gib 1 back on and close the post cap.

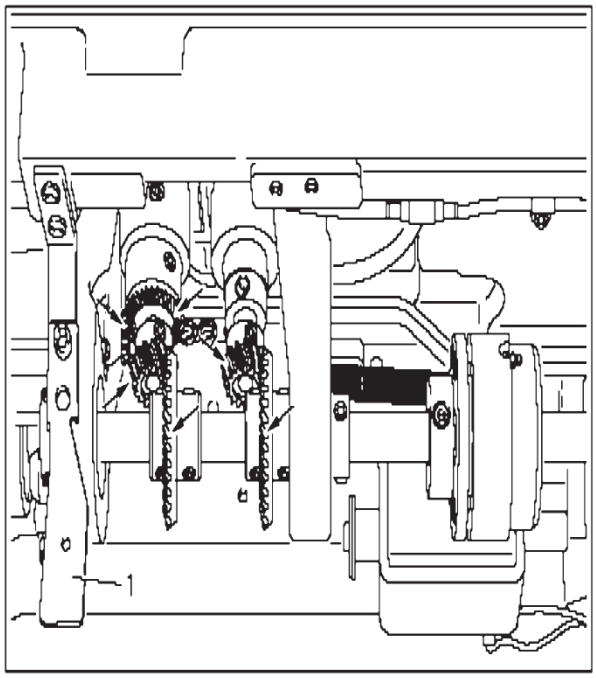
8.2. Oiling the hook

Warning: Turn OFF the power before starting the work as to prevent accident caused by abrupt start of the sewing machine.



- Pour 1-2 drops of oil into hole 1 of the gib daily.
- Before commissioning the machine and after long periods out of operation, pour a few drops of oil into the hook race (see arrow).

8.3. Oil bowl for hook lubrication

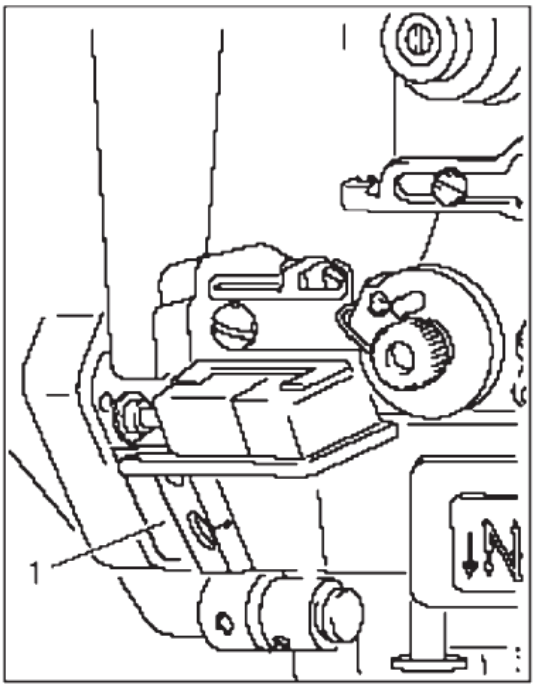


Check the oil level before each use.
There must always be oil in reservoir **1**.
If required refill oil through hole.

22.0 mm^2/s
0.865 g/cm3
Use only oil with a mean viscosity of 22.0mm^2/s at 40℃ and a density of 0.865g/cm3 at 15℃.

8.4. Filling the oil reservoir of the thread lubrication unit

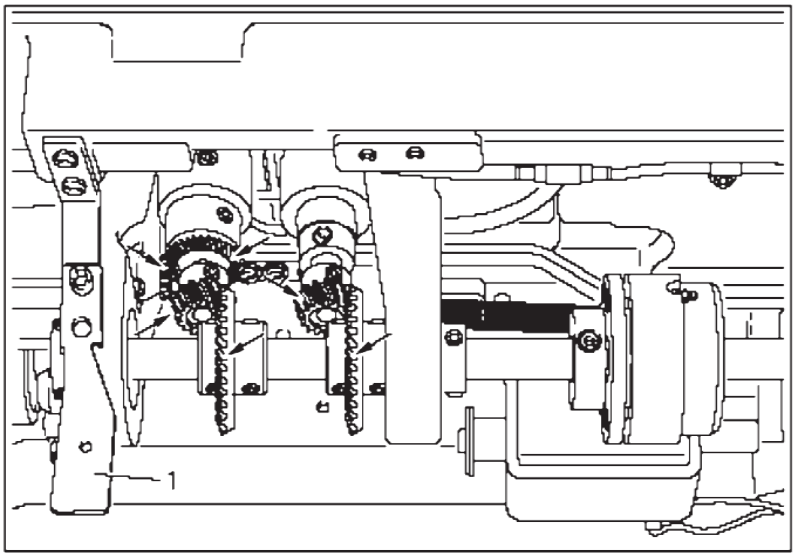
Control the oil level before each use.
There must always be oil in the reservoir **1.**



- If necessary, fill oil up to mark through hole.
  We recommend thread lubricating oil.

8.5. Lubricating the bevel gears

Warning: Turn OFF the power before starting the work as to prevent accident caused by abrupt start of the sewing machine.



- All bevel gears must be supplied with new grease once a year.
- Tilt the sewing head back onto the support.
- Apply grease to all the tooth flanks and the rack (see arrows).
- To set the sewing head upright, press tilt lock 1 backwards and set the sewing head upright using both hands.

Use both hands to set the sewing head upright!
Danger of crushing between the sewing head and the table top!

We recommend sodium grease with a dripping point of approx.150C.

9. Adjustment

Unless stated otherwise, during all adjustment work the machine must be disconnected from electric and pneumatic power supply!
Danger of injury if the machine is started accidentally!

9.1. Notes on adjustment

- All following adjustment are based on a fully assembled machine and may only be carried out by expert staff trained for this purpose.
- Machine covers, which have to be removed and replaced to carry out checks and adjustments, are not mentioned in the text.
- The order of the following chapters corresponds to the most logical work sequence for machines which have to be completely adjusted. If only specific individual work steps are carried out, both the preceding and following chapters must be observed.
- Screws, nuts indicated in bracket () are fastenings for machine parts, which must be loosened before adjustment and tightened again afterwards.

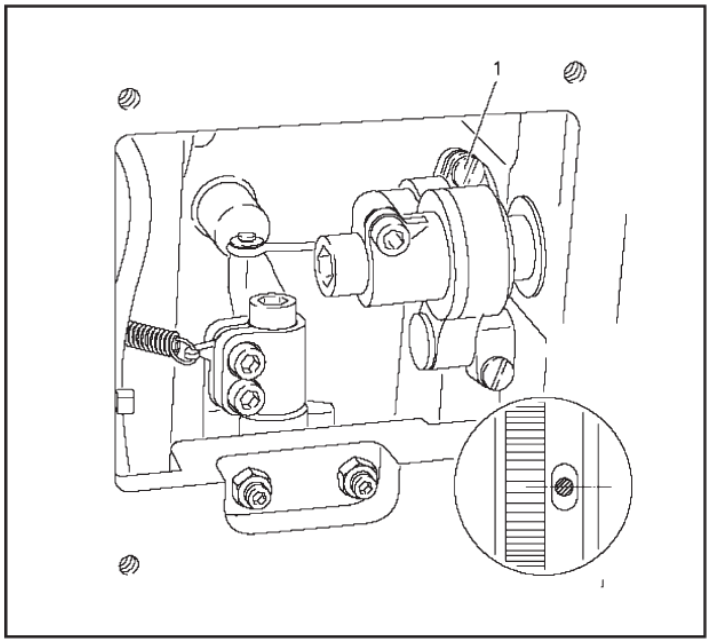
9.2. Tools, gauges and other accessories

- 1 set of screwdrivers with blade widths from 2 to 10 mm.
- 1 set of open ended wrenches with opening sizes from 7 to 13 mm.
- 1 set of allen keys from 1.5 to 6 mm.
- 1 clamp.
- 1 metal ruler.
- 1 gauge.
- Sewing thread and test material.

9.3. Adjusting the basic machine

9.3.1. Needle position in sewing direction

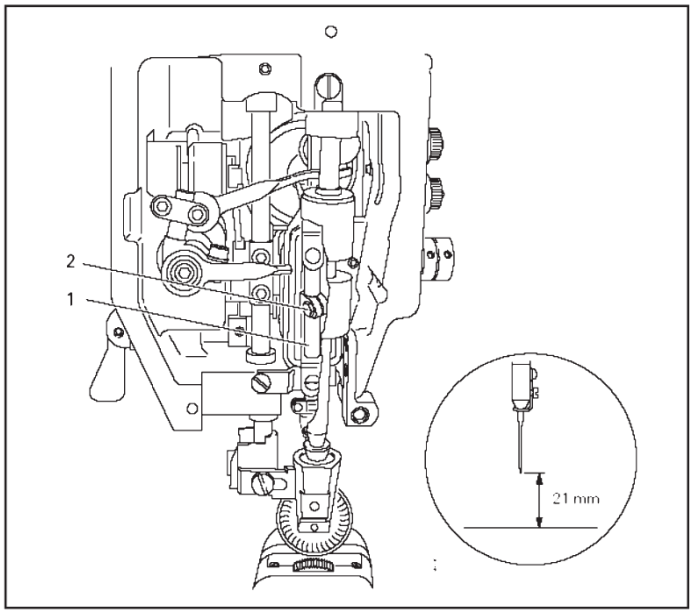
Requirement
With the stitch length set at its minimum, the needle should be positioned in the center of the needle hole, as seen in the direction of sewing.



- Set the minimum stitch length.
- Adjust needle bar (screw 1) according to the **Requirement.**

9.3.2. Preliminary adjustment of the needle height

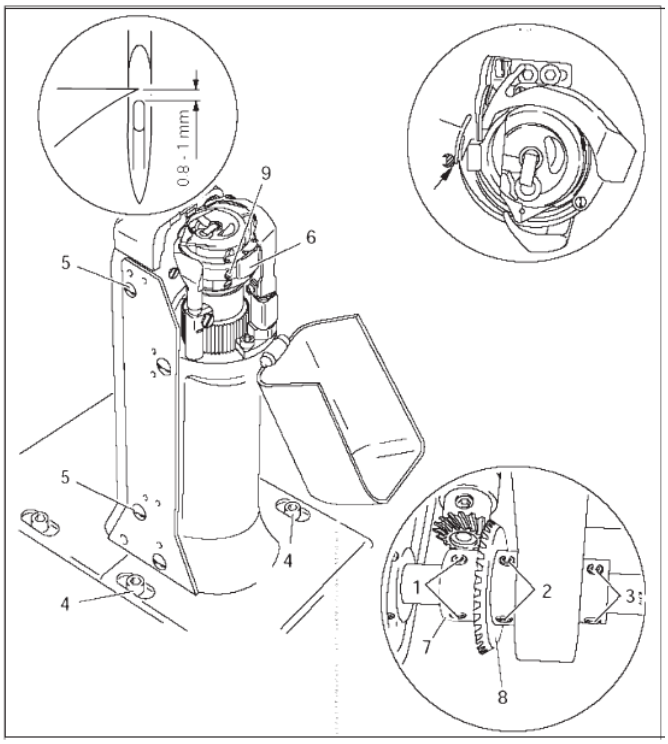
Requirement
When the needle bar is at top dead center, there must be a clearance of approx. 21 mm between the needle point and the needle plate.



- Adjust the needle bar 1 (screw 2) without turning it, according to the **Requirement.**

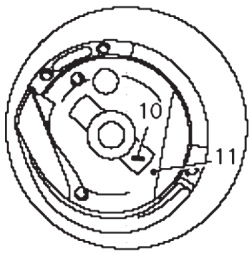
9.3.3. Needle rise, hook clearance, needle height and needle guard

Requirement
With the needle bar positioned 2.0 mm after bottom end center and the stitch length set at “0.8”:
- The hook point must be at needle center with a hook-to-needle clearance of 0.05 to 0.1 mm.
- The top of the needle eye must be 0.8 to 1.0 mm below the hook point.
- The needle guard 6 must touch the needle lightly.



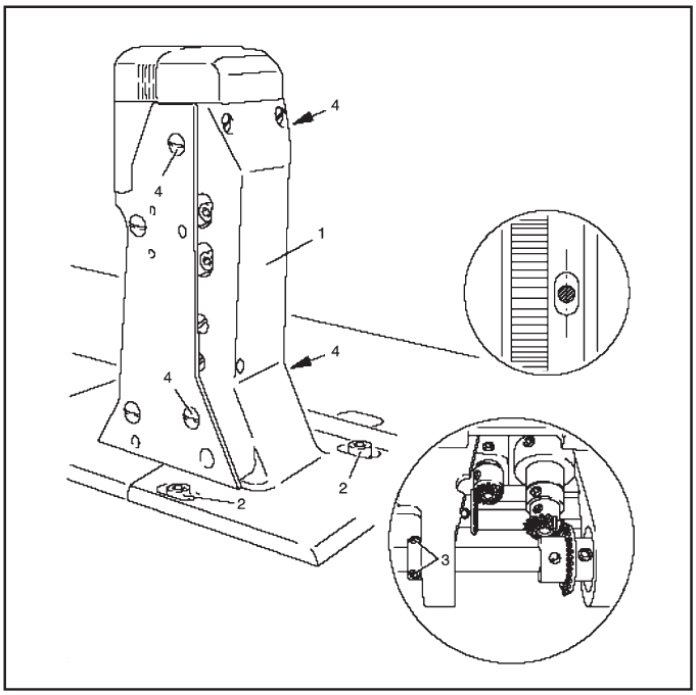
- Set stitch length at 0.8.
- Loosen screws 1, 2, 3, 4, and 5.
- Bring the needle bar to 2.0 mm past bottom dead center.
- Set hook point at needle center, making sure that the needle are not deflected by needle guard 6.
- Adjust needle height according to **Requirement 2**.
- Adjust hook post according to **Requirement 1** and tighten screw 4.
- Making sure that there is some play in the bevel gear, tighten screw 2.
- With retaining collar 7 touching bevel gear 8, tighten screw 1.
- Adjust needle guard 6 (screw 9) according to **Requirement 3**.

When the hook is changed, make sure that the markings **10** and **11** are both on one side.



9.3.4. Needle position crosswise to sewing direction

Requirement
As seen crosswise to the sewing direction, the needle must penetrate in the center of the needle hole.

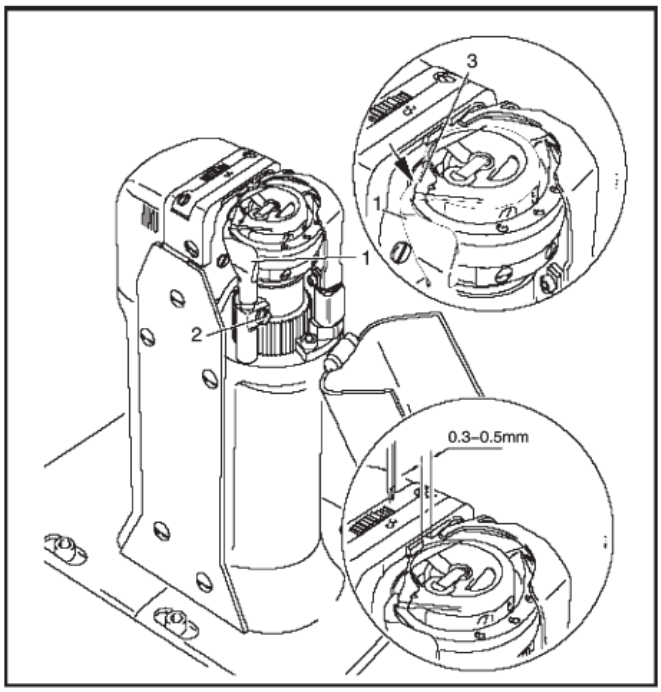


- Adjust feed wheel post 1 (screw 2, 3, 4) according to the **Requirement.**

9.3.5. Height and stroke of the bobbin case opener

Requirement

- The top edges of the bobbin case opener 1 and bobbin case 3 should be on one level.
- When the bobbin case opener 1 has deflected the bobbin case to its furthest point, the catch of the bobbin case should be from 0.3 to 0.5 mm from the back edge of the needle plate recess.

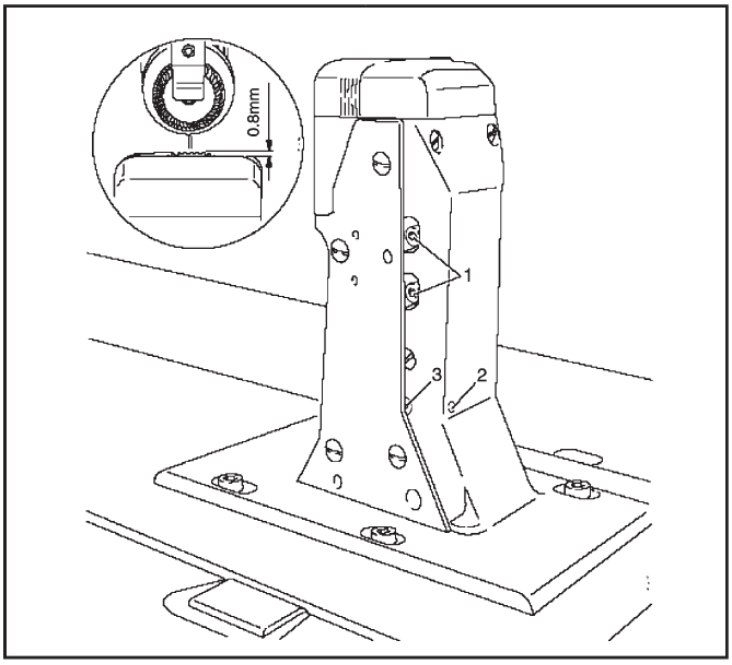


- Adjust the bobbin case opener 1 (screw 2) in accordance with **Requirement 1.**
- Turn the balance wheel until the bobbin case opener has deflected the bobbin case to its further point.
- Adjust bobbin case opener 1 (screw 2) in accordance with **Requirement 2.**

9.3.6. Height of the feed wheel

Requirement

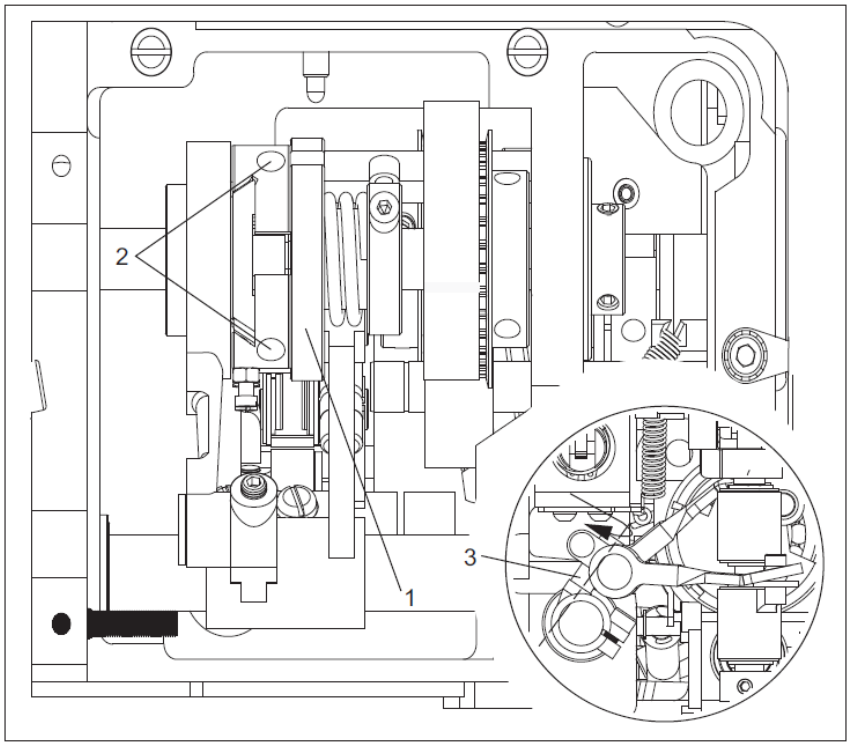
Feed wheel should protrude from the needle plate by tooth height (approx. 0.8 mm).



- Swing out the roller presser.
- Loosen screw 1.
- Adjust eccentric 3 (fastening screw accessible through hole 2).
- Tighten screw 1.

9.3.7. Stitch length control eccentric

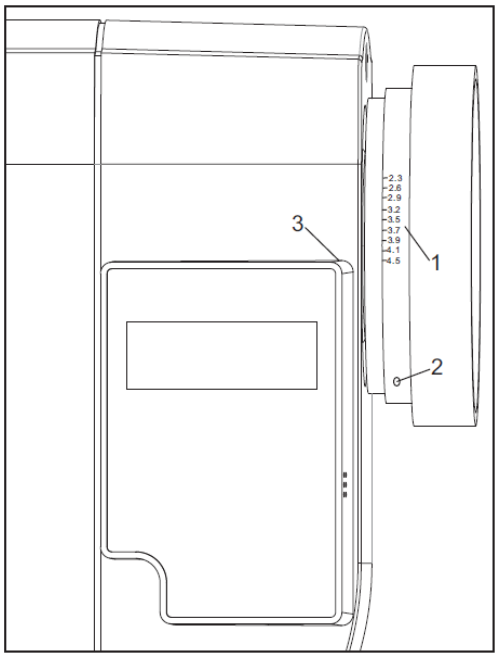
Requirement
When the needle (with maximum stitch length set), coming from top dead center, is 3 mm above the needle plate, the crank 3 must have reached its front point of reversal.



- Set the maximum stitch length.
- Turn stitch length control devise 1 (screw 2) according to **Requirement**.

9.3.8. Stitch length scale disk

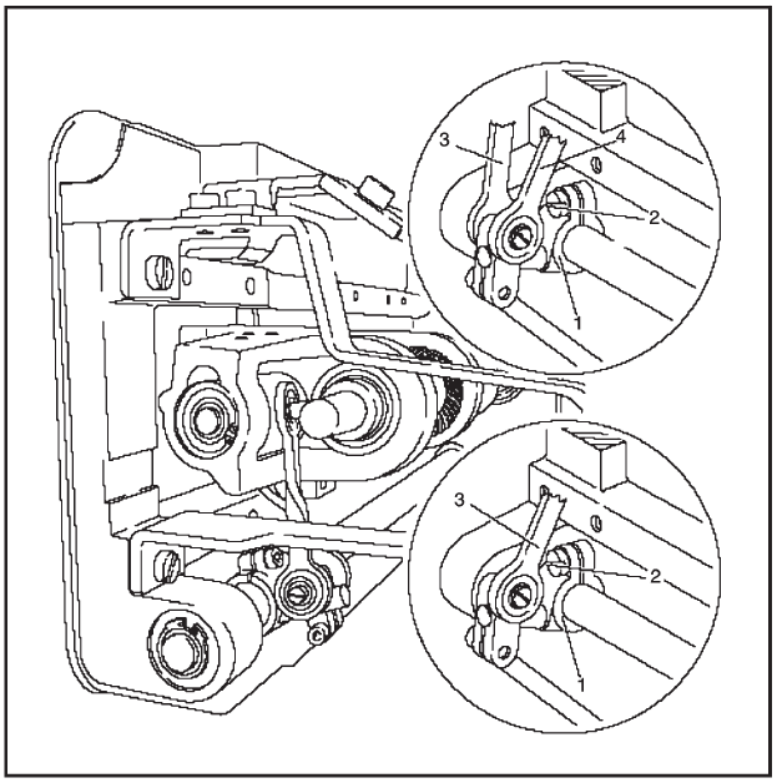
Requirement
When the stitch length control device is locked in position, and the maximum stitch length is set, the marking line of the highest number on the scale disk **1** must be opposite the lower edge **3** of the belt guard recess.



- Set the maximum stitch length.
- Turn the scale disk 1 (screw 2) according to the **Requirement.**

9.3.9. Shaft crank to feed wheel drive

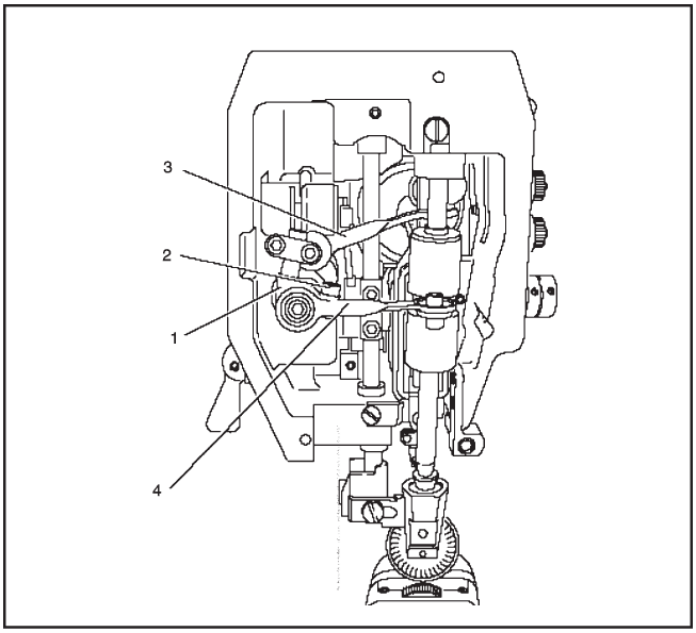
Requirement
When the maximum length is set, the linkage rod **3**, or linkage rods **3** and **4** must be able to move freely when the balance wheel is turned.



- Set the maximum stitch length.
- Twist of shift the shaft crank 1 (screw 2) according to the **Requirement.**

9.3.10. Shaft crank to roller presser drive

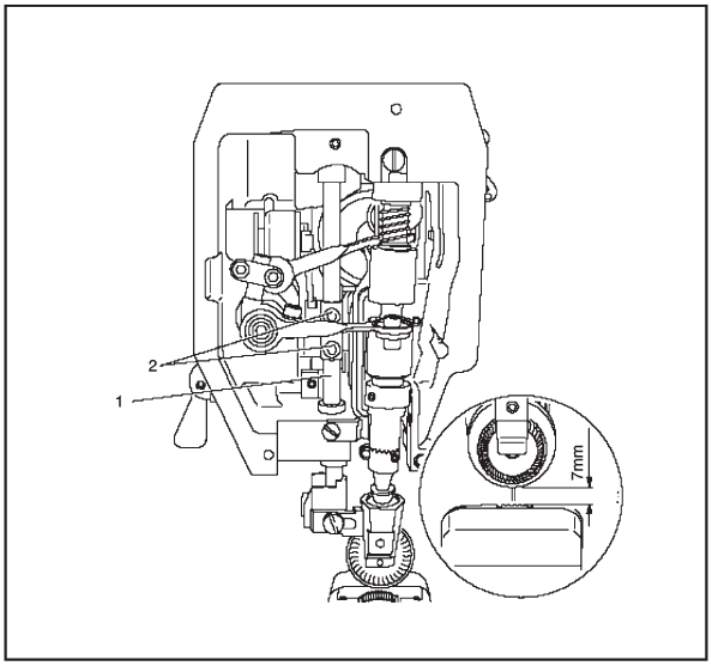
Requirement
When the maximum stitch length is set, the linkage rods 3 and 4 must be able to move freely at their left and right point of reversal when the balance wheel is turned.



- Set the maximum stitch length.
- Twist of shift the shaft crank 1 (screw 2) according to the **Requirement.**

9.3.11. Roller presser and feed wheel adjustment

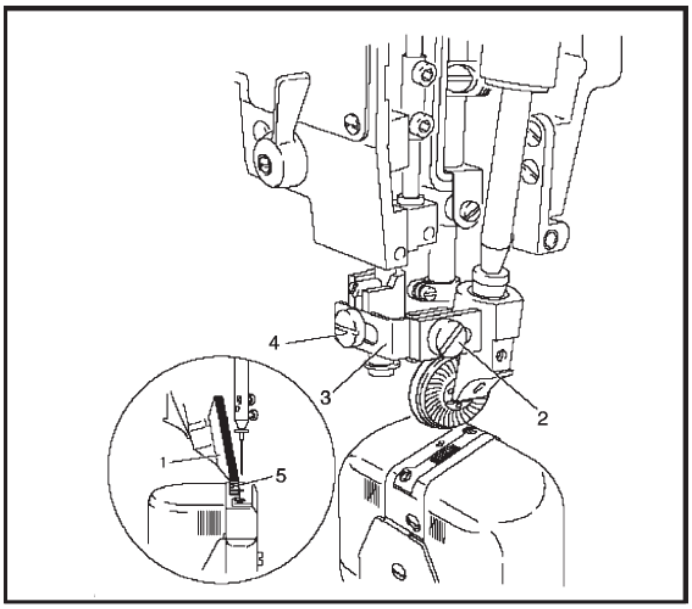
Requirement
When the presser bar lifter is raised, the clearance between the roller presser and the feed wheel must be 7 mm.



- Raise the presser bar lifter.
- Adjust the presser bar 1 (screw 2) according to the **Requirement**. Make sure that the roller presser is parallel to the feed wheel.

9.3.12. Roller presser

Requirement
When the roller presser 1 is touching the feed wheel 5, it must:
1. Be parallel to feed wheel 5, as seen in the direction of sewing.
2. Be in the center of needle, as seen in the direction of sewing.
3. Be as near as possible to the needle, as seen crosswise to the direction of sewing.

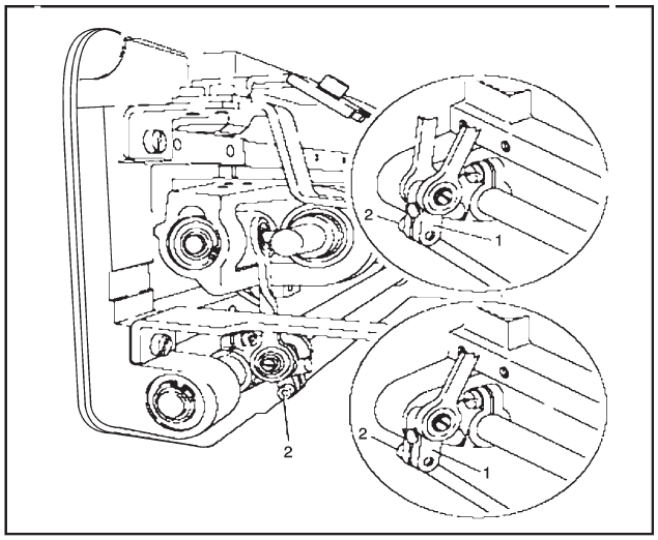


- Raise the roller presser foot.
- Always observe **Requirement 1** for subsequent adjustments.
- Adjust roller presser 1 (screw 2) according to **Requirement 2.**
- Lower roller presser 1 to rest on the feed wheel 5.
- Adjust roller presser bracket 3 (screw 4) according to **Requirement 3.**

When sewing very tight curves, the roller presser 1 must be moved a little towards the operator.

9.3.13. Stitch length on stitch length scale

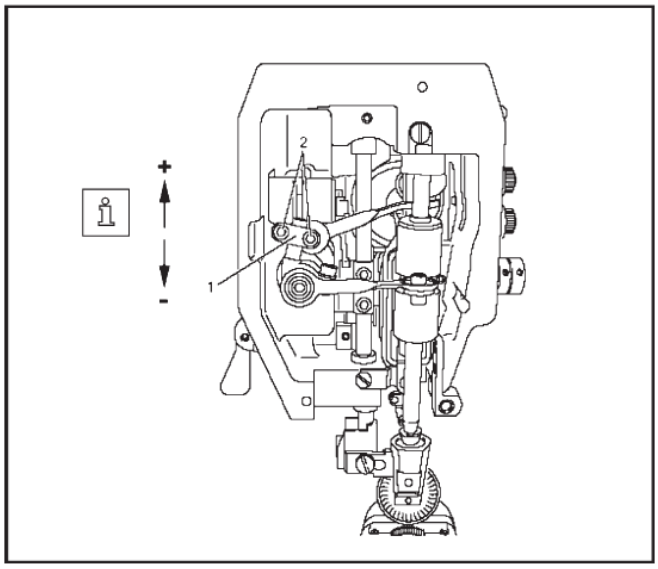
Requirement
When the stitch length is set at 3, and after the needle has entered a strip of leather 11 times, the total length from the first to last needle penetration must be 30 mm.



- Set stitch length “3”
- By turning the balance wheel, let the needle enter 11 times and measure the total length.
- Adjust clamp 1 (screw 2) according to the **Requirement**.
- Clamp 1 must not be positioned diagonally to the rock shaft!

9.3.14. Synchronization of roller presser and feed wheel

Requirement
After **30 needle penetrations** in a strip of leather the total length from the first-last penetration should be the same, both in the lower and the upper leather layer.

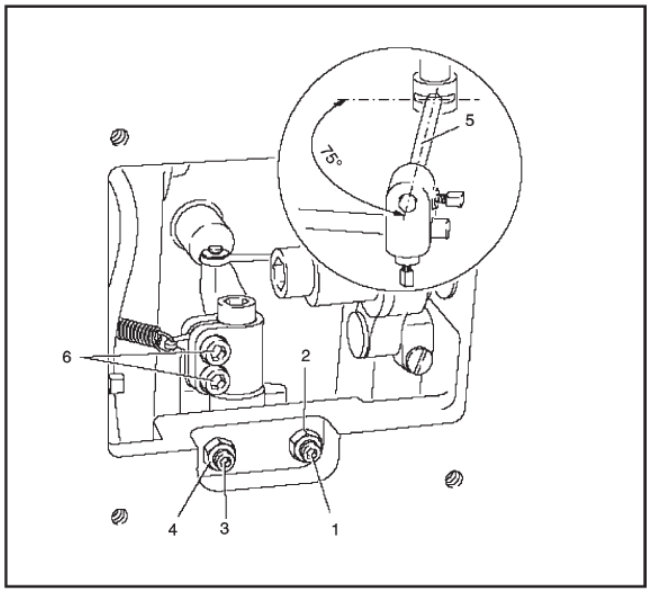


- Set stitch length “3”
- By turning the balance wheel, let the needle enter 30 times.
- Compare the total sewn length of the lower and upper leather layer.
- Adjust clamp 1 (screw 2) according to the **Requirement.**

9.3.15. Knee Lever

Requirement

1. Before the roller presser rises, the knee lever must still have slightly movement.
2. When the knee lever is raised as far as possible, the lever for the roller presser must drop automatically.
3. Knee lever bar 5 must be at an angle of approx. 75 to the bedplate.

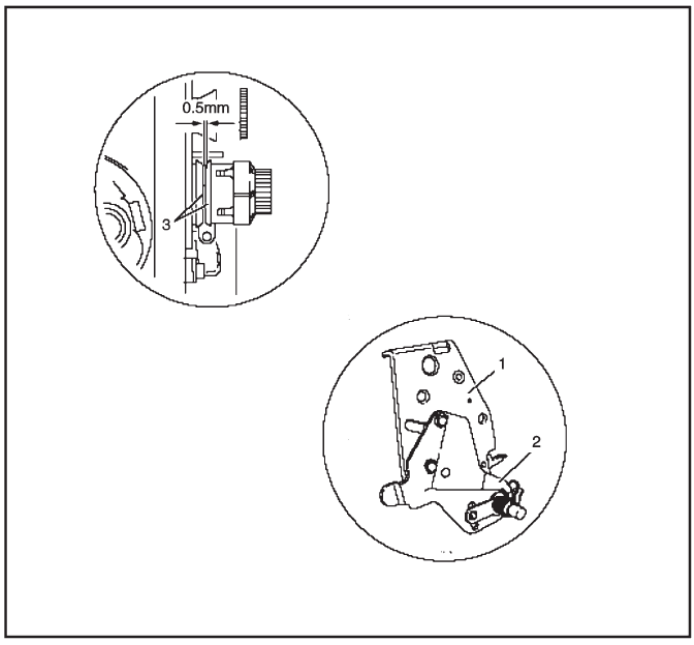


- Adjust screw 1 (nut 2) according to **Requirement 1**
- Adjust screw 3 (nut 4) according to **Requirement 2**
- Set bar 5 (screw 6) according to **Requirement 3**

9.3.16. Needle thread tension release

Requirement

1. When the presser bar lifter is raised, the tension discs 3 should be pressed at least 0.5 mm apart.
2. When the roller presser is lowered, the tension must be fully effective.

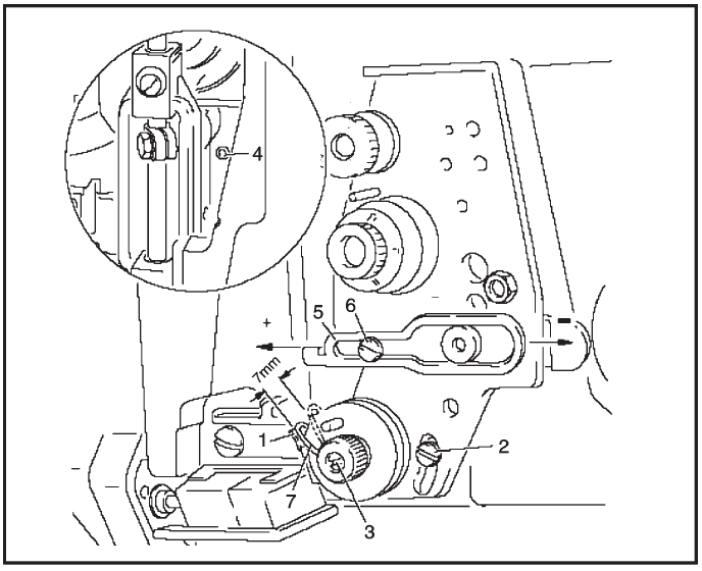


Align tension mounting plate 1 and presser plate 2 according to **Requirement**

9.3.17. Thread check spring

Requirement

1. The movement of thread check spring 7 should be completed when the needle point penetrate the fabric (spring stroke approx. 7 mm).
2. When the largest thread loop is formed while the thread is passed around the hook, the thread check spring 7 should raise slightly from its support.



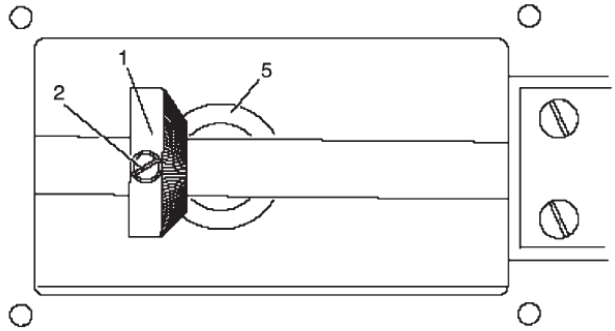
- Adjust support 1 (screw 2) according to **Requirement 1**
- Adjust the spring tension by turning screw 3 (screw 4)
- Adjust the thread regulator 5 (screw 6) according to **Requirement 2**

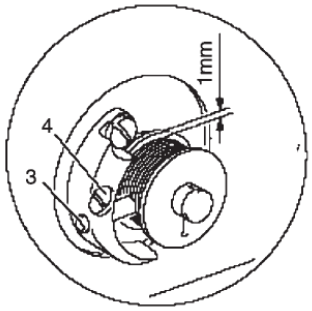
Note:
For technical reasons it may be necessary to deviate from the specified spring stroke or spring tension. Move the thread regulator 5 (screw 6) towards "+" (= more thread) or "-" (= less thread).

9.3.18. Bobbin winder

Requirement

1. When the bobbin winder is engaged, the winding spindle must be driven reliably. When the bobbin winder is dis-engaged, the friction wheel 5 must not be moved by drive wheel 1.
2. The bobbin winder must switch itself off when the filled thread is about 1 mm from the edge of the bobbin.

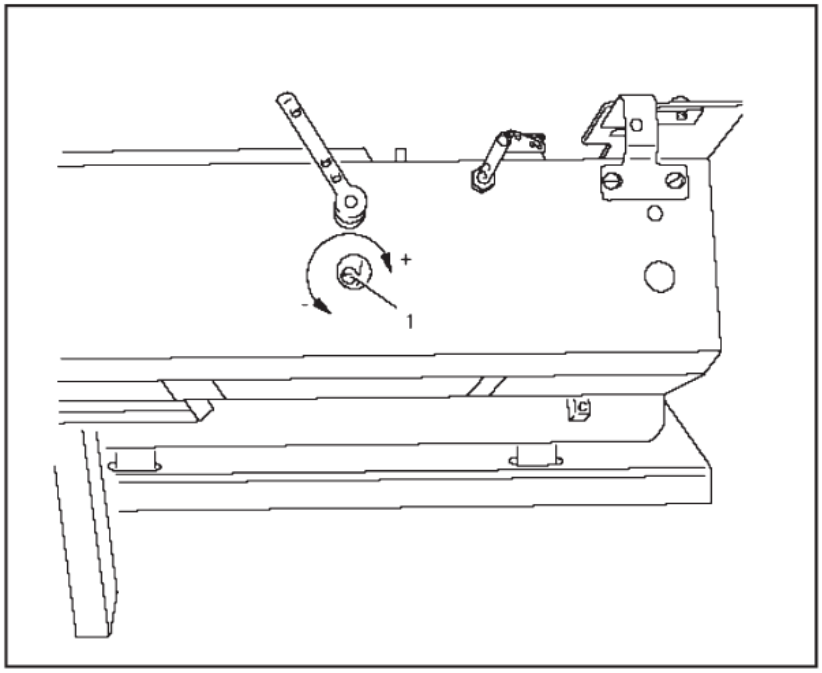




- Position drive wheel 1 (screw 2) according to **Requirement 1.**
- Position bolt 3 (screw 4) according to **Requirement 2**

9.3.19. Pressure of roller presser

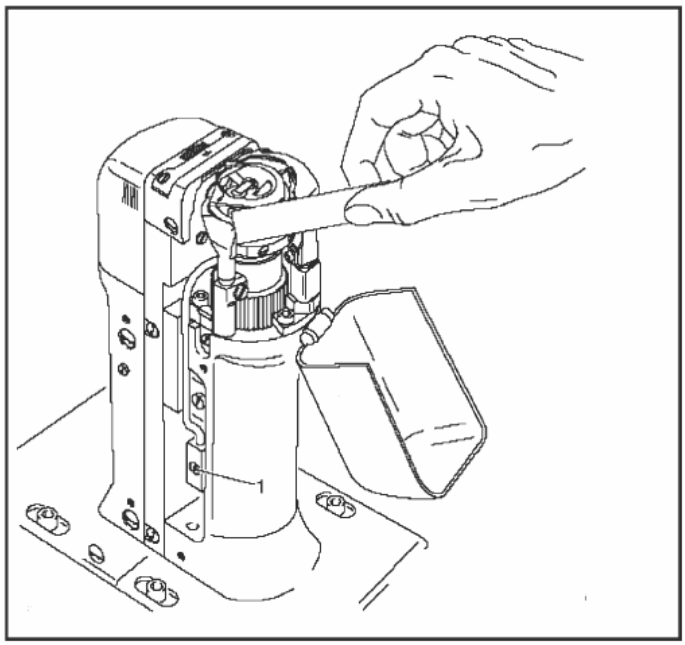
Requirement
The material must be fed smoothly. No pressure marks should be visible on the material.



Adjust roller pressure with screw 1 according to **Requirement.**

9.3.20. Lubrication

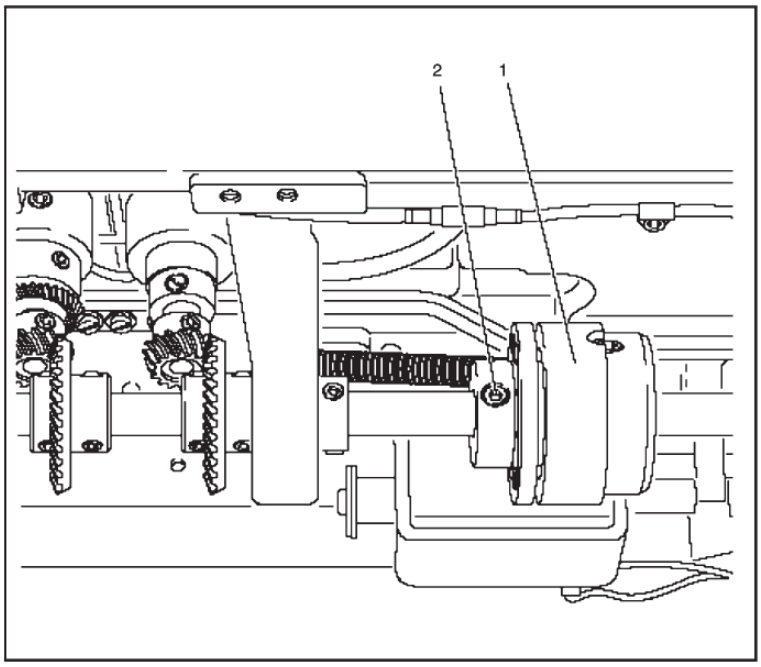
Requirement
After a running time 10 seconds, a fine line of oil should form on a strip of paper held next to the hook.



- Check whether oil has been filled in and that there is no air in the oil lines.
- Let the machine run for 2-3 min.

9.3.21. Re-engage safety coupling

The coupling **1** is set by the manufacturer. When the thread jams, the coupling **1** disengages in order to avoid damage to the hooks.
A description of how to engage the coupling follows.



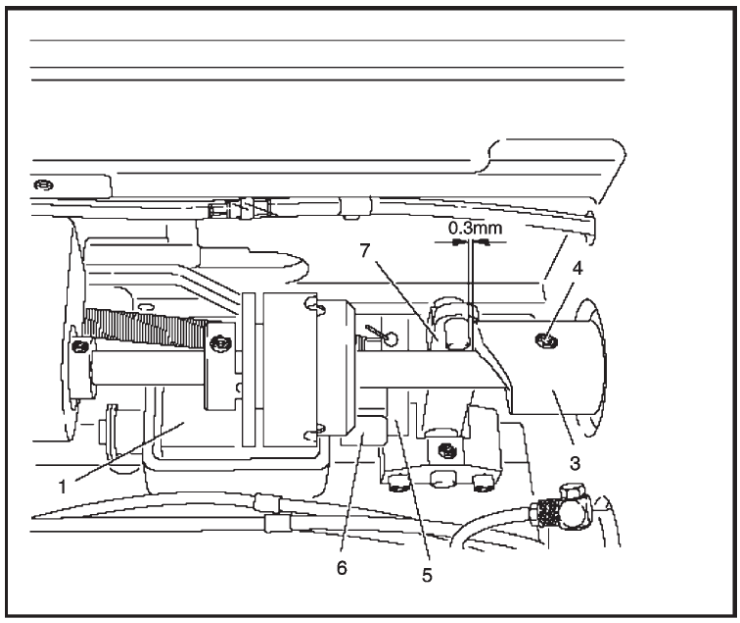
- Remove jammed thread
- Hold coupling 1 with screw 2 and turn the balance wheel until you feel coupling 1 snap back into place again.

9.4. Adjusting the thread trimmer

9.4.1. Resting position of the roller lever/radial position of the control cam

Requirement

1. When the thread trimmer is in resting position, lever 5 should be touching piston 6 and the roller of roller lever 7 should be 0.3 mm away from control cam 3.
2. When the take-up lever is at top dead center, control cam 3 should just have placed roller lever 7 in its resting position.

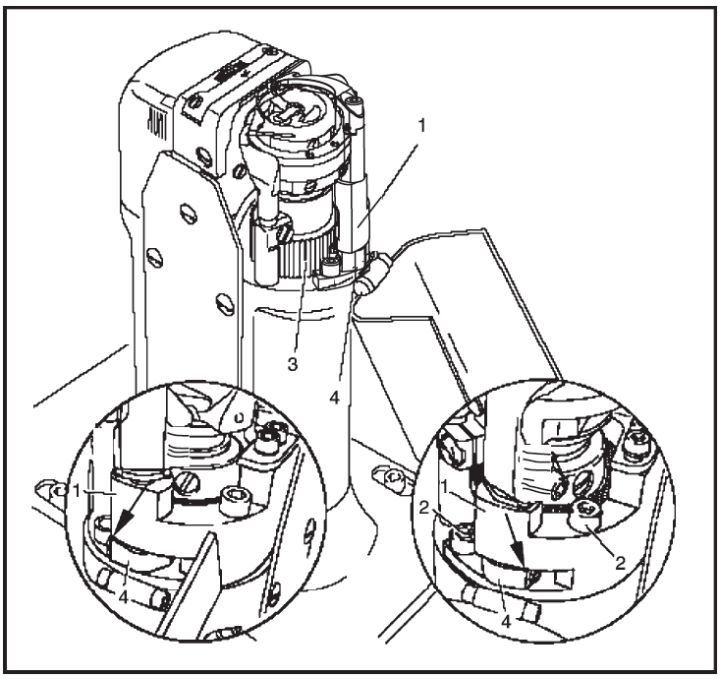


- Having made sure that piston 6 is positioned against the left stop, adjust magnet 1 (2 screws) in accordance with **Requirement 1**
- Adjust control cam 3 (screw 4) in accordance with **Requirement 2**.

9.4.2. Position of the thread catcher holder

Requirement

1. There should be a minimum amount of play between toothed wheel 3 and toothed segment 4.
2. Both in the neutral position and the foremost position of the catcher, the distance between the toothed segment 4 and the outer edge of the thread catcher holder 1 should be the same (see arrow).



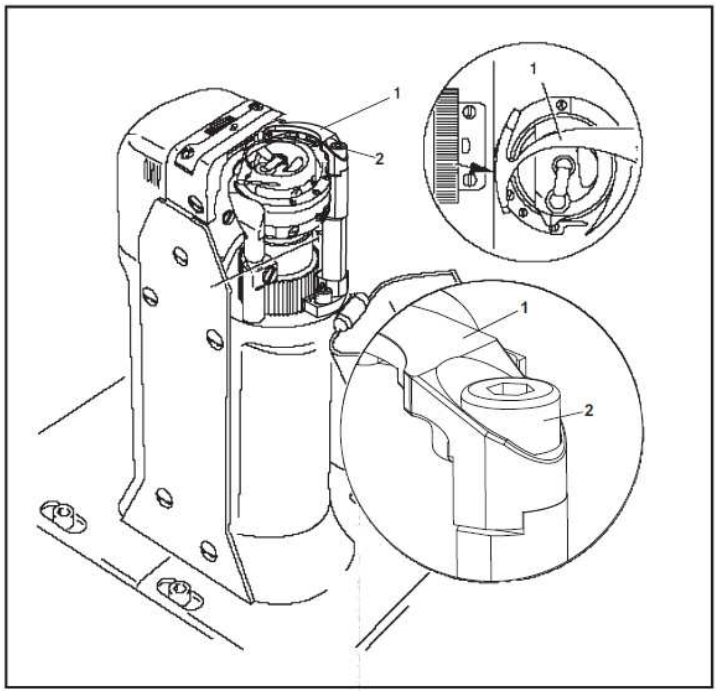
Adjust the thread catcher holder 1 (screw 2) according to **Requirements.**

Note:
If **Requirement 2** cannot be fulfilled, loosen screw 2 and move the toothed segment 4 by one tooth.

9.4.3. Distance between thread catcher and needle plate

Requirement

During its swivel movement thread catcher 1 should not pass the edge of the needle plate (see arrow).

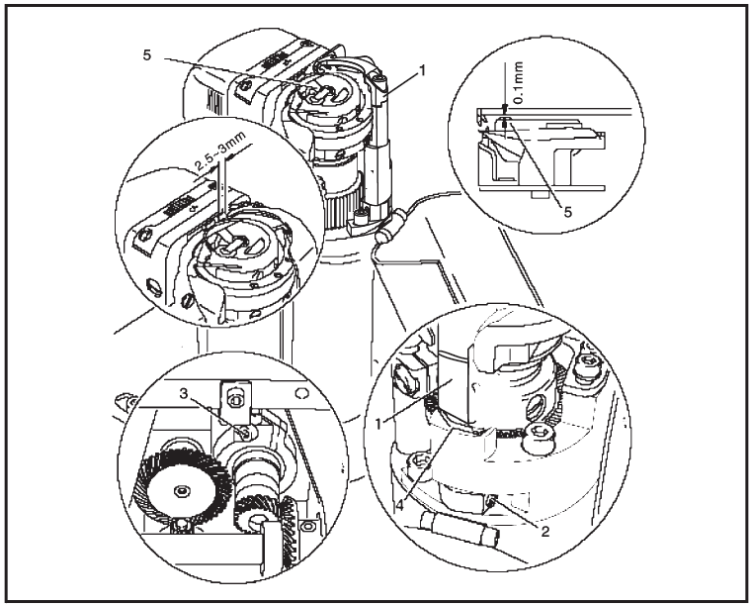


Move thread catcher 1 (screw 2, two screws) parallel to the thread catcher holder in accordance with the **Requirement.**

9.4.4. Position of the thread catcher

Requirement

1. The bottom edge of the thread catcher 1 should be at a distance of 0.1 mm from the positioning finger of the bobbin case 5.
2. When the thread trimmer is in its neutral position, the rear edge of catcher should be positioned approx. 2.5-3 mm behind the edge of the knife.



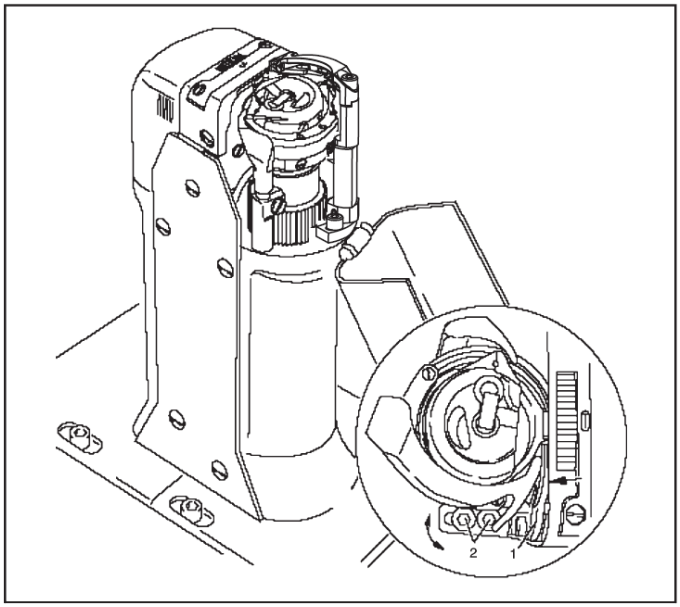
- Move thread catcher 1 (screw 2, two screws) in accordance with **Requirement 1**
- Turn thread catcher 1 (screw 3) in accordance with **Requirement 2**.

Note:
Thread catcher 1 must be parallel to the surface of the thread catcher holder 4.

9.4.5. Knife position and knife pressure

Requirement

1. The knife 1 should be touching the needle plate.
2. The knife pressure should be set as low as possible but the cutting operation should still be carried out reliably.

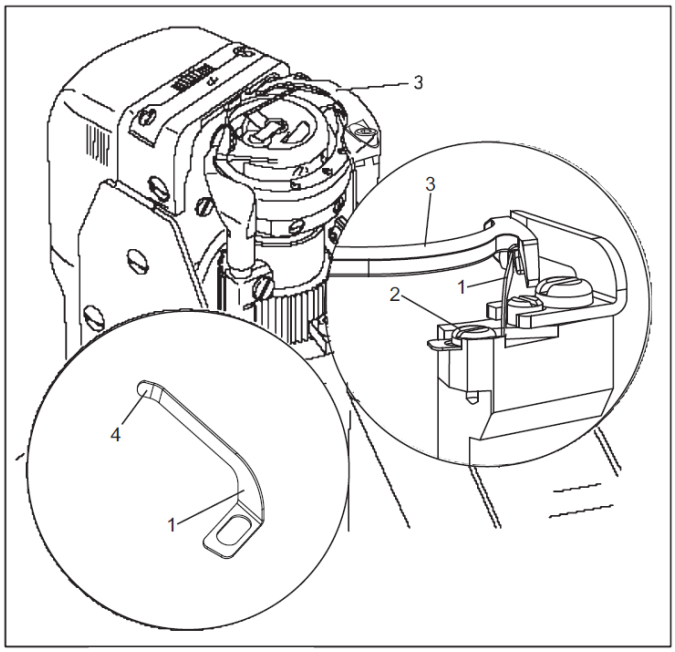


Move knife 1 (screw 2) in accordance with **Requirement 1** or swivel it in accordance with the **Requirement 2.**

9.4.6. Bobbin thread retaining spring

Requirement

1. The bobbin thread clamp spring should be guided reliably in the thread groove of the thread catcher 3.
2. The tension of the bobbin thread spring clamp should be as low as possible, but the bobbin thread should be reliably after the cutting operation.



- Adjust bobbin thread clamp spring 1 (screw 2) in accordance with **Requirement 1**
- Adjust the tension in accordance with **Requirement 2** by bending side 4 of the bobbin thread clamp spring 1.

Control Requirement 1:

- Switch off the machine and bring the take-up lever to its bottom dead center.
- Engage and disengage the thread catcher 3 by hand and check.

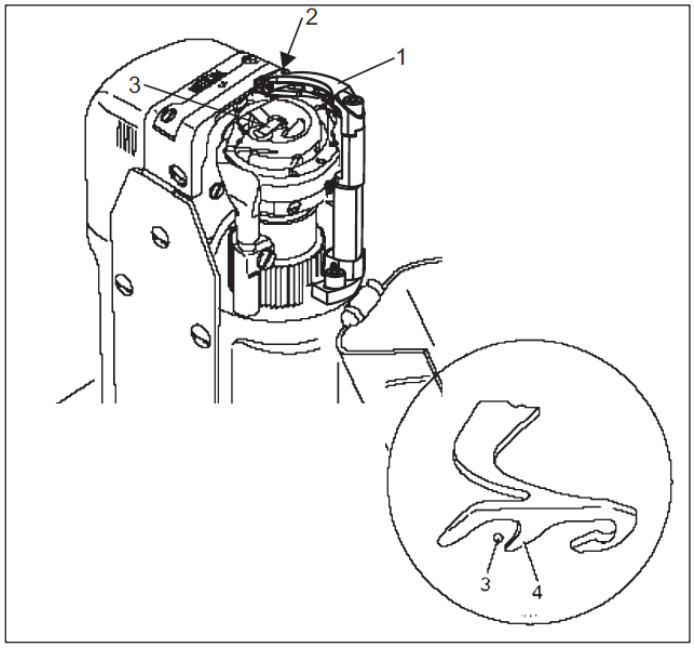
Control Requirement 2:

- After the thread cut has been cut, sew a few stitches by turning the balance wheel, checking whether the bobbin thread is drawn out of bobbin thread clamp spring between the 1st and 3rd stitched, if necessary, correct the tension.

9.4.7. Manual cutting test

Requirement

1. When thread catcher 1 is on its forward stroke, it must not carry bobbin thread 3 forward too.
2. When thread catcher 1 is in its front position, bobbin thread 3 must be held reliably by hook 4.
3. After the trimming action, both the needle thread and the bobbin thread must be perfectly cut and bobbin thread 3 retained.

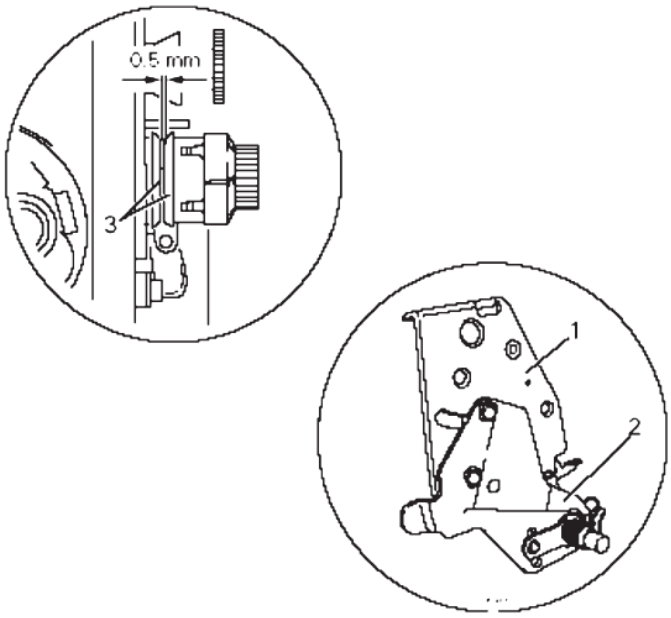


- Sew a few stitches.
- Turn off the on/off switch.
- Carry out the cutting operation manually.
- Check **Requirement 1** and **2**, and if necessary re-adjust thread catcher 1 in accordance with **Chapter 9.4.4. Position of the thread catcher.**
- Check **Requirement 3**, and if necessary re-adjust the bobbin thread retaining spring **2** in accordance with **Chapter 9.4.6. Bobbin thread retaining spring.**

9.4.8. Releasing the tension

Requirement

When the magnet is activated, tension discs 3 must be at least 0.5 mm apart.

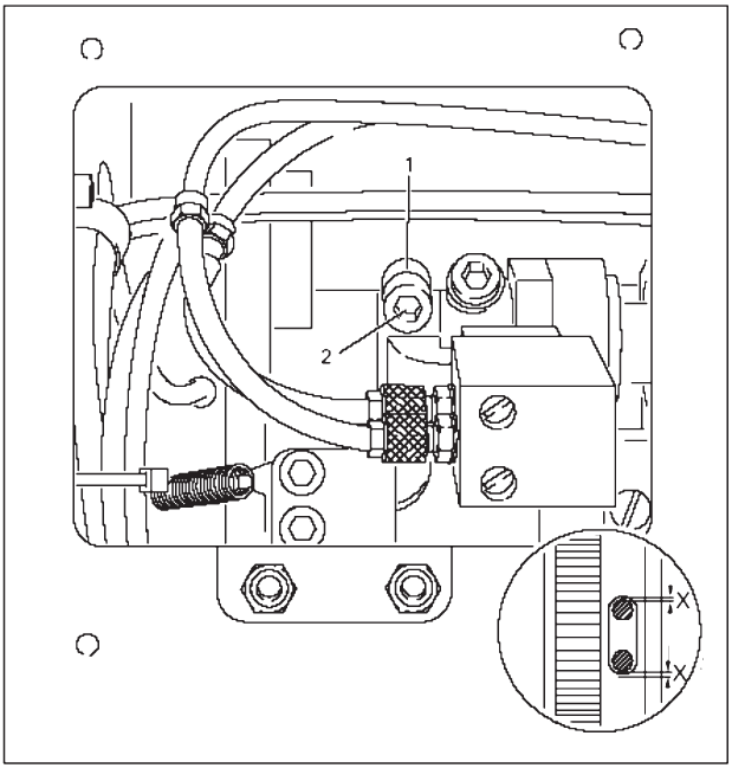


- Activate the magnet.
- Detach the tension bearing plate 1 and adjust presser plate 2.

9.5. Adjusting back-tacking mechanism

9.5.1. Needle in the hole

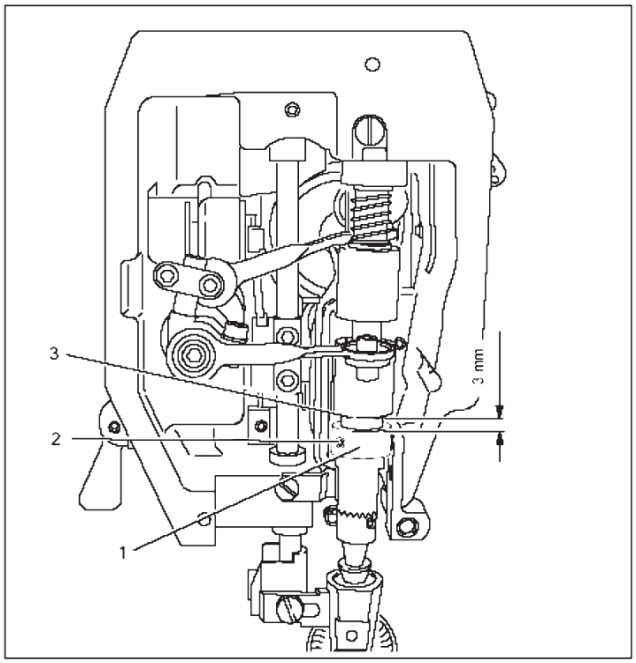
Requirement
When the maximum stitch length is set, the needle must be the same distance from the inside edge of the needle hole, both for forward and reverse stitch.



Turn crank 1 (screw 2) according to the **Requirement.**

9.5.2. Coupling for roller presser drive

Requirement
There must be a distance of 3 mm between coupling half 1 and locking disc 3 of the drive mechanism.

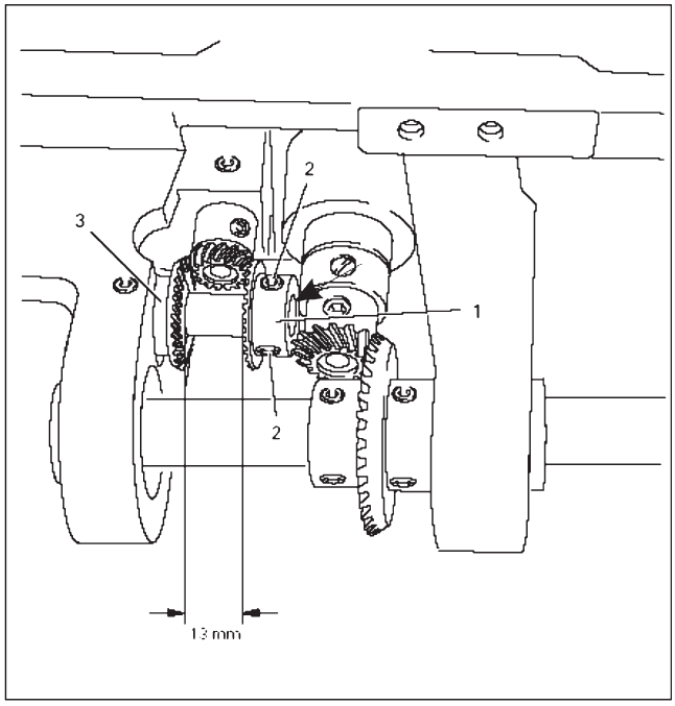


Adjust coupling half 1 (screw 2) according to the **Requirement.**

9.5.3. Bevel gears for feed wheel drive

Requirement

1. The right side of bevel gear 1 must be flush with its drive shaft (see arrow).
2. There must be a distance of 13 mm between bevel gear 3 and bevel gear 1.

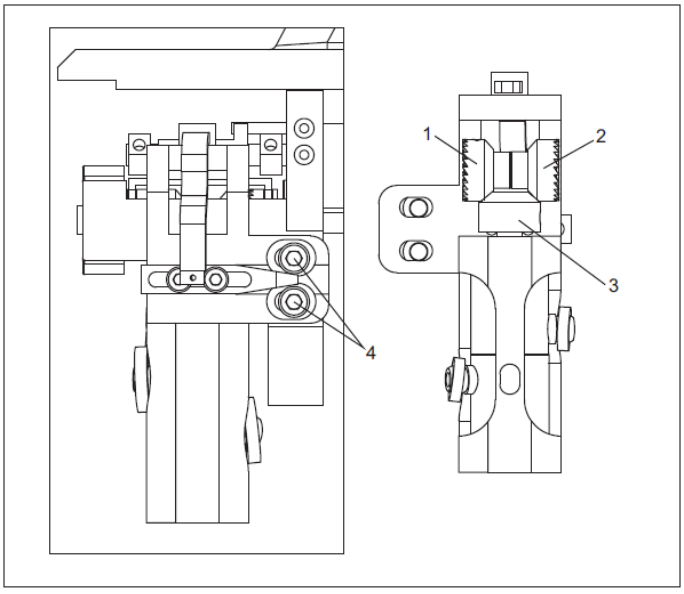


- Adjust bevel gear 1 (screw 2) according to **Requirement 1**.
- Adjust bevel gear 3 (screw 4) according to **Requirement 2.**

9.5.4. Bevel gear movement

Requirement

When sewing, there must be a slight movement between bevel gear 1 and 3.
At the same time, there must be a slight movement between bevel gear 2 and 3.



Adjust screw 4 according to **Requirement.**

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.
	**SPIRIT 2** Non-toxic, non-staining, odourless, colourless oil, neutral for plastics. Perfect for lubricating sewing machines (lockstitch, overlock, interlock, etc.), needles, knitting cams and other precise mechanism in the textile industry.
	**SPIRIT 37** Silicon fluid modified especially for textile industry. Used for preparation of sewing thread and yarn, lubrication of knitting machines needles. Colourless and odourless. Applied with brush, 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:

Mechatronic Post bed lockstitch sewing machine,

model Texi Post DD

(ZJ9610SA-D3-M-3)

With this declaration relates, complies with following directives:

Machine directive 2006/42/EC

Low voltage directive 2006/95/EC

Harmonized norm used: EN 60204-1

Notes

Notes

HD texi®

Dealer :