

Operation manual

TEXI WALKER WF SERVO  
TEXI WALKER WF AUT

**HD** *texi*®



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CE Declaration of conformity

## SAFETY PRECAUTION

This instruction manual contains important guidelines regarding correct, safe and economical method of use of the machine. Following recommendations contained in this manual will decrease work down-time, increase machine reliability and durability, and will make work safer.

This instruction manual must always be available at the workplace. The machine can be serviced only by an employee trained in Industrial Safety, after reading this instruction manual.

The supplier is not responsible for damages caused by improper use or by usage of this product for functions other than those it has been designed for.

To minimize the risk of fire, electric shock, or injury, observe the following precautions:

- Keep the workplace clean.
- Pay attention to the machine's work environment; do not subject it to atmospheric conditions.
- Do not install the machine in rooms that are dusty, where aerosols are sprayed, or to which oxygen is supplied.
- Keep the workplace well lit.
- Be careful of danger of electric shock.
- Pay attention to clothing. Let-down hair or loose clothing can be caught by the machine's mobile elements.
- Take care not to damage the power supply cable.
- When the machine is not in use, disconnect it from the power grid.
- Take care not to turn-on the machine accidentally.
- In case of even the slightest damage, always check if the damaged part requires replacement.
- Never install on the machine attachments and accessories other than those recommended by the manufacturer and supplier.
- Do not perform machine modifications independently.
- Do not leave near the machine unattended bystanders or children.

### Electric installation

Check if the supply voltage in the electric socket corresponds to the data on the machine's rating plate 1-phase voltage 230V 50Hz.

Check the correctness of electric connections in the plug and electric socket, **observing electric shock safety countermeasures.**

Do not use extension power cords.

Apply the valid electrical and Industrial Safety norms.

**ATTENTION – all work related to the electrical installation must be carried out by a qualified electrician.**

### Before starting work

Using machine without any of the safeguarding parts (finger guard, eye guard, etc.) is dangerous to an operator.

During work, only the items necessary for sewing should be found on the machine's work table.

Before connecting the machine to the power grid, always release the pedal and the start button.

Do not use blunt or bent needles.

Do not touch any of the machine's mobile elements, such as the needle, needle bar, thread tensioner or take-up, or hook, during its operation.

### Turn machine off before: replacing needle, threading, installing attachments, changing the bobbin or bobbin case.

If you notice any abnormalities in the machine's function, turn it off immediately and inform a mechanic or your superior. After finishing work, turn the machine off and remove the plug from the electric socket. In case of power grid failure, disconnect the machine from the power grid.

### This machine is not a toy!

We hope that you will use this machine with pleasure for a long time.

## USER'S MANUAL

The lockstitch machine TEXI, model Walker WF Servo and Walker WF AUT are high speed sewing machines, designed for sewing upholstery and leather materials.

### Attention!

The machine is not to be used for other materials than those for which it has been designed. Non-observance of this rule places the user at risk and can cause irreversible damage to the machine.

Before use, the user should become acquainted with this instruction manual, general safety precautions and maintenance instructions.

### 1. Before starting work

1. After turning-on the machine and during its operation, do not touch the needle or put fingers into the thread take-up guard.
2. During sewing, do not put fingers into the needle guard.
3. Turn power off before tilting the machine head or uninstalling parts.
4. Turn machine off before leaving it unattended.
5. Do not allow hair, loose clothing, fingers or any objects to be in the vicinity of the pulley during machine run.
6. Do not clean the machine with paint thinner.

### Technical specifications

Model	WALKER WF SERVO
Application	Medium and thick materials
Power supply	AC 220 - 240V, 750W
Frequency	50 -60 HZ
Sewing speed (max)	2000 stitches/min
Maximum stitch length	8 mm
Presser foot raising height	5 mm (standard), 16 mm (max)
Needle	135x17 with tips, appropriate to the type of sewn material
Lubricating oil	Oil for lockstitch machine (recommended: SPIRIT 2)
Net weight	51 kg
Packaging dimensions	803 x 299 x 606 mm

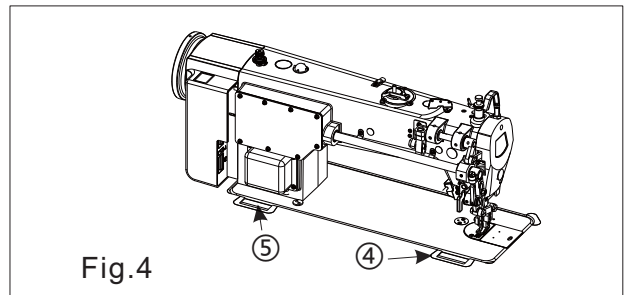
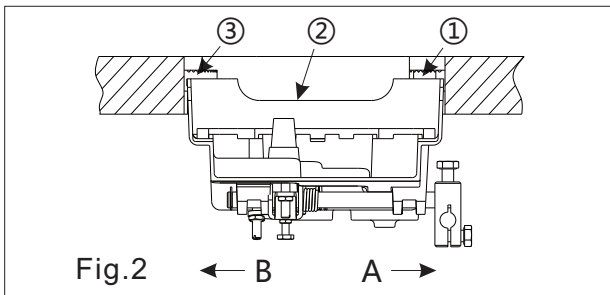
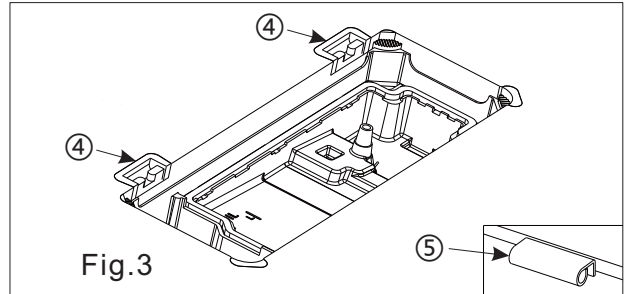
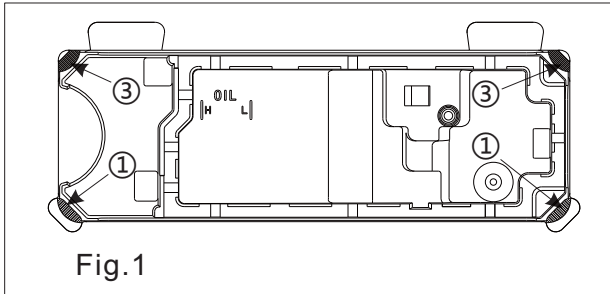
**Technical specifications**

Model	WALKER WF AUT
Application	Medium and thick materials
Power supply	AC 220 - 240V, 750W
Frequency	50 -60 HZ
Sewing speed (max)	2000 stitches/min
Maximum stitch length	8 mm
Presser foot raising height	5 mm (standard), 16 mm (max)
Needle	135x17 with tips, appropriate to the type of sewn material
Lubricating oil	Oil for lockstitch machine (recommended: SPIRIT 2)
Net weight	58 kg
Packaging dimensions	803 x 299 x 606 mm

## 2. Installation of the oil reservoir

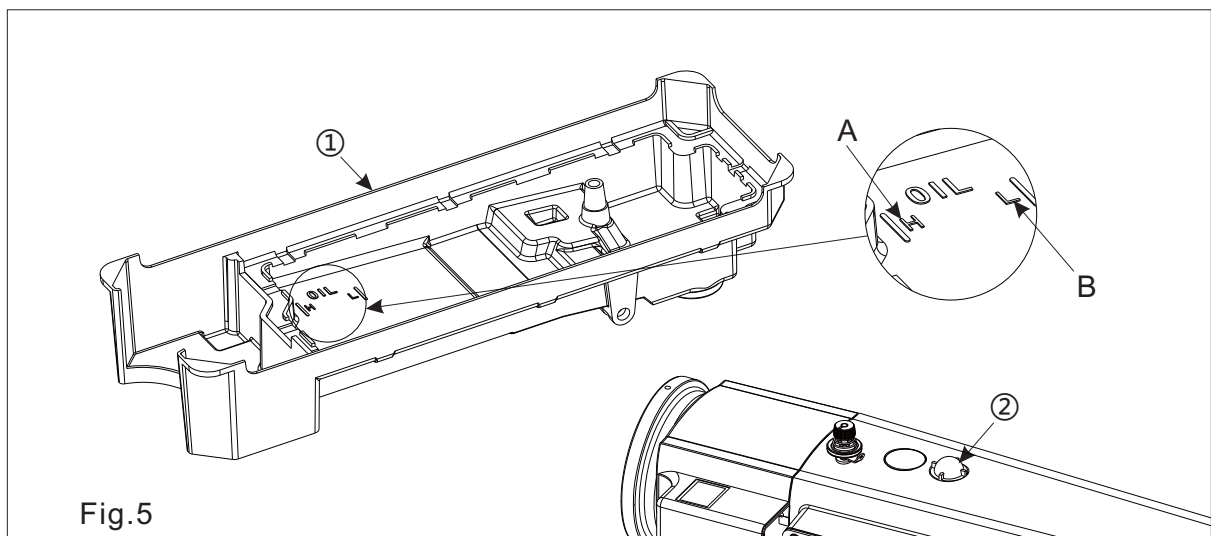
1. Fasten the two-armed washer (1) on side A of the oil reservoir (2), in the direction of the operator.  
Fasten the two-armed washer (3) on side B of the oil reservoir (2), in the direction of the hinges and fasten the reservoir (Fig. 1, Fig. 2).
2. The oil reservoir should rest upon four corners of the cut-out in the machine table-top.
3. Insert hinge (4) and (5) into the opening in the machine head, place machine head on table top with hinge into the recess and fasten it on the washers in the four corners of the reservoir (Fig. 3, Fig. 4).

**Attention:** In the packaging, the four rubber washers placed in the corners of the oil reservoir, only serve transportation purposes.



## 3. Lubrication

1. Fill the oil reservoir (1) with high-speed machine oil, up to the level of upper marker A.
2. When the oil level falls to the level of lower marker B, refill the reservoir.
3. During machine operation, oil spatter will be visible in the eye-hole (2).
4. Remember that the amount of oil spatter is not related to the amount of oil in the oil reservoir.



#### 4. Machine oil level

##### 1. Information about lubrication

- 1) During first machine start-up, or after long idle time, it should be started in idle mode for about 30 seconds.
- 2) During machine operation, insert a paper oil level indicator under the hook in order to check if the amount of oil dosed to it is correct. Oil level control should be carried out over the course of 5 seconds.
- 3) Before starting work, always check if the oil level in the oil reservoir is at the correct level.

##### 2. Regulation of the oil dosage to the hook

Regulate screw (1) to the right (A) to increase oil amount, turn to left (B) to decrease oil amount.

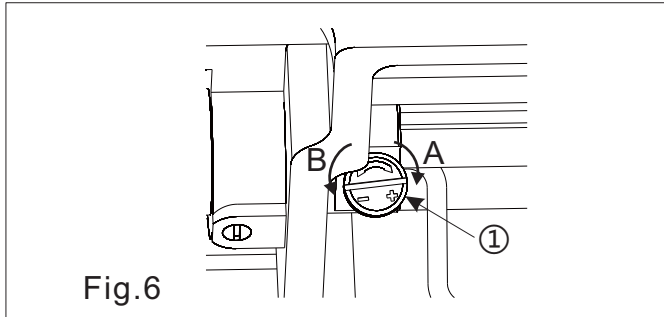


Fig.6

#### 5. Correct oil dosage to the hook

1. Checking oil dosage, shown below, should be carried out before start of sewing. Take care not to excessively increase/decrease amount of oil in the hook. If there is too little oil, the hook will be subject to excessive heating or seizing up. If there is too much oil, the sewn product can be stained by oil.
2. The amount of oil in the hook must be adjusted in such a way, that it does not change during three checks (on three separate pieces of paper).

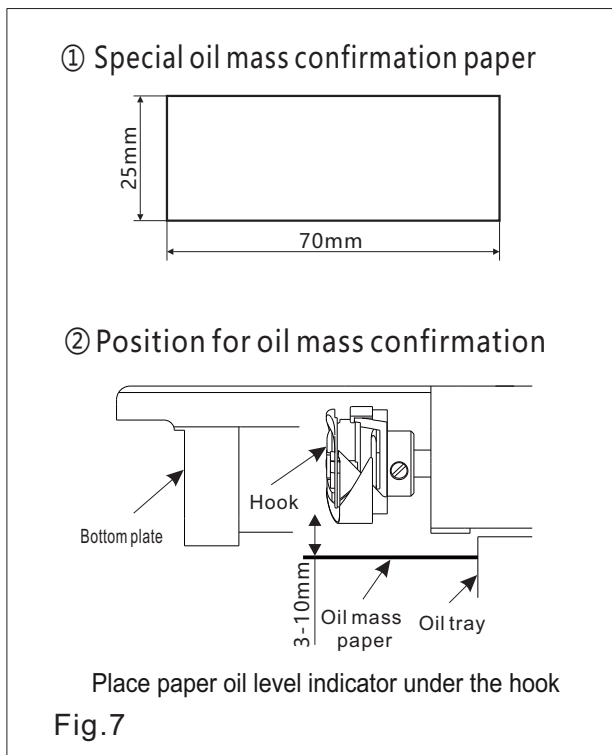


Fig.7

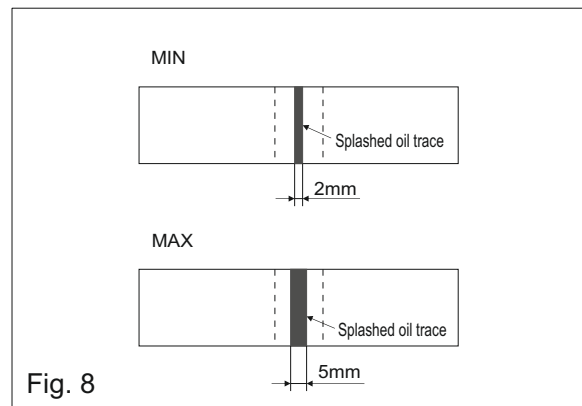


Fig. 8

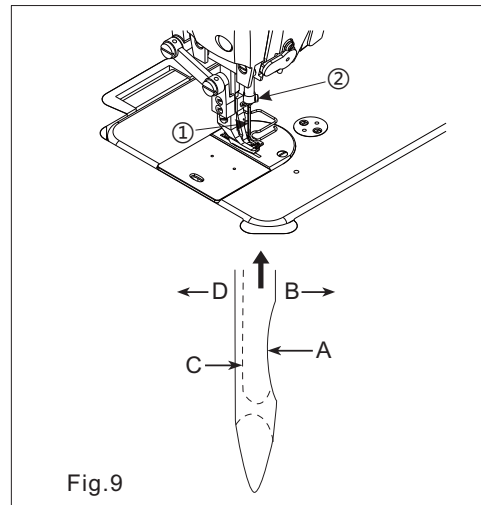


## 6. Fastening the needle

**ATTENTION: Turn machine off before carrying out the below operations.**

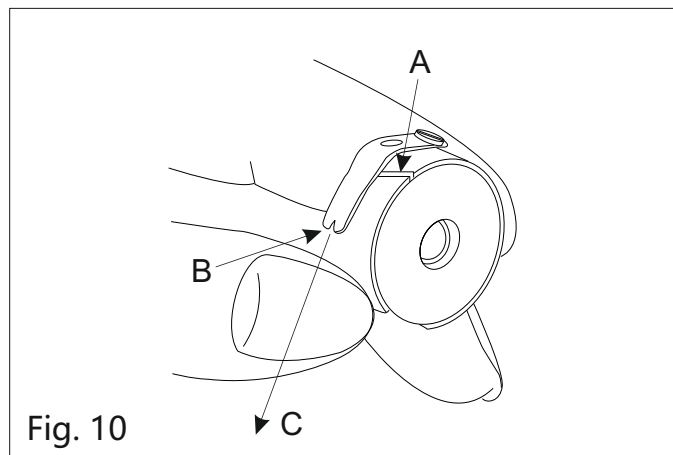
Select the needle appropriate to the sewn material.

1. Turn pulley until the needle bar reaches its highest point.
2. Loosen screw (2) and hold the needle with part A directed in direction B.
3. Insert needle into the needle holder, in the direction of the arrow.
4. Check if the needle's long groove C is directed in direction D.
5. Tighten screw securely (2).



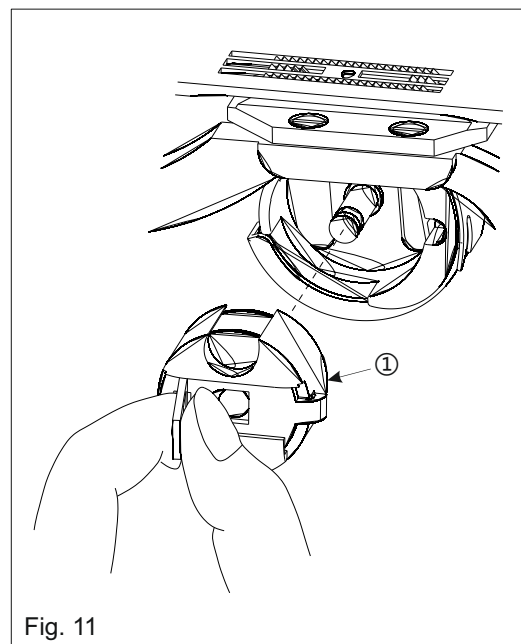
## 7. Inserting bobbin into bobbin case

1. Insert the bobbin into the bobbin case so that the thread winds to the left.
2. Lead the thread through the gap and pull it in direction C. This way, the thread will pass under the flat bobbin case spring B.
3. Check that the bobbin rotates in the direction of the arrow, after it is pulled.



## Installing bobbin case

- Set the needle to up position (above needle plate).
- Hold bobbin and bobbin case (1), and insert it to the hook.



## 8. Threading the machine

Before threading, set the needle bar in its highest point. Hold the end of the thread and thread the machine in the following manner:

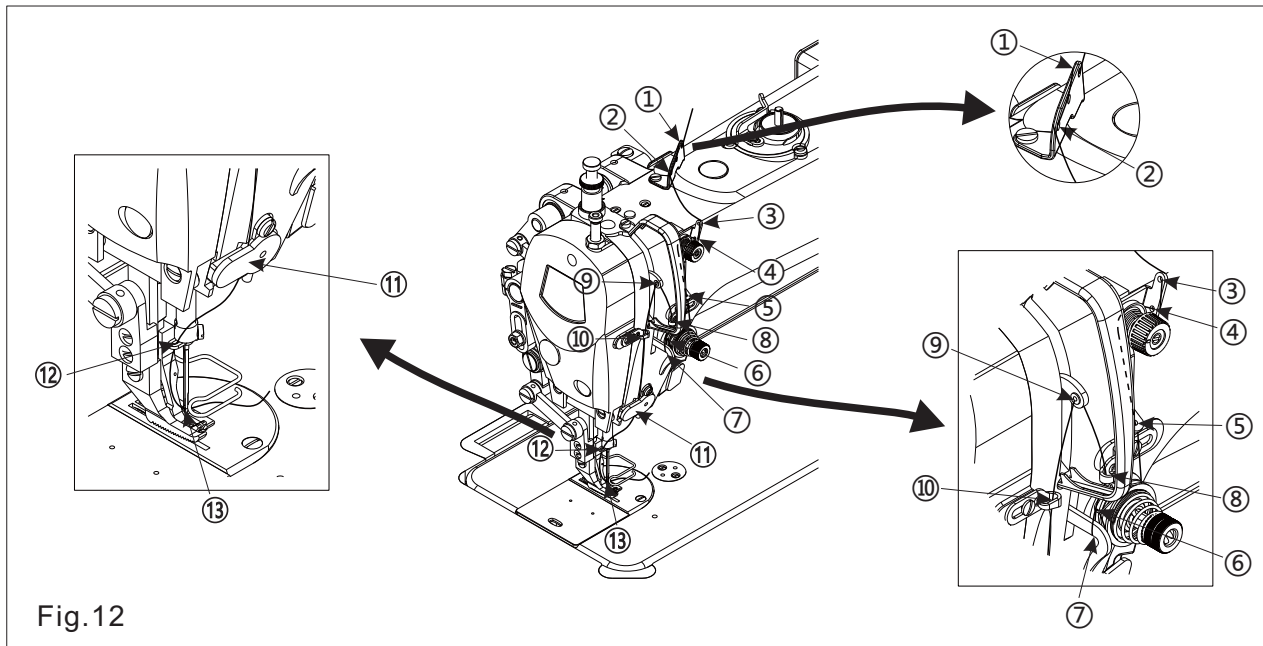


Fig.12

## 9. Winding the bobbin

Set the bobbin on to the bobbin winder and wind the thread onto it as shown on the figure

Losen screw (5) to move lever (3) to adjust how much thread will be on the bobbin.

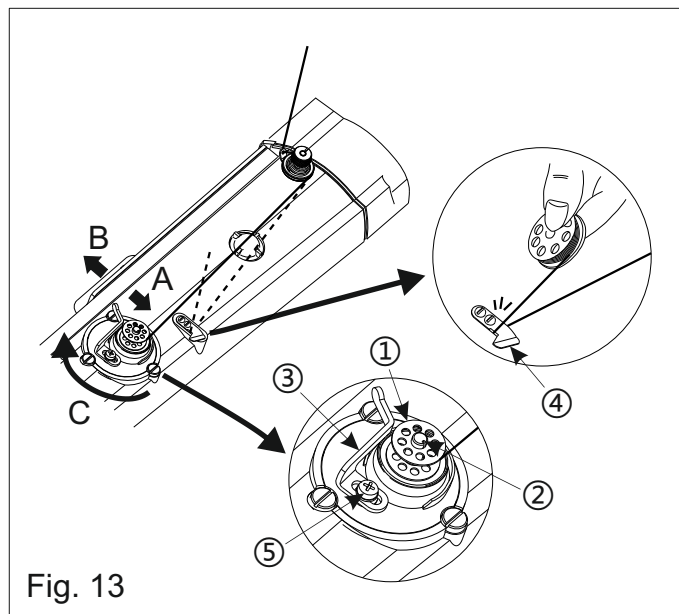


Fig. 13

## 10. Stitch length regulation

1. Push and turn the stitch length regulation dial (1) in the direction of the arrow and set the desired value at indicator A on the machine arm.
2. The wheel has millimeter gradation.
3. In order to decrease stitch length, turn the dial (1) while pressing the reverse sewing lever (B) in the direction of the arrow.

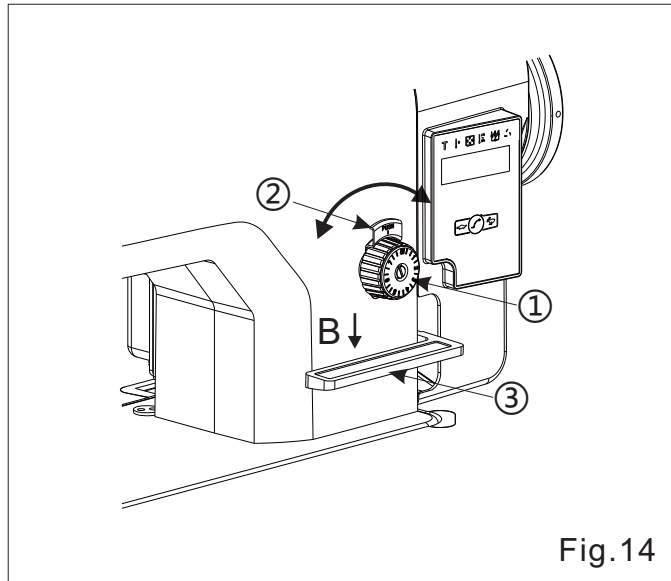


Fig. 14

## 11. Installing the thread stand

1. Assemble the thread stand and insert it into the opening in the machine table top.
2. Fasten the fixing nut (1) in order to secure the stand.

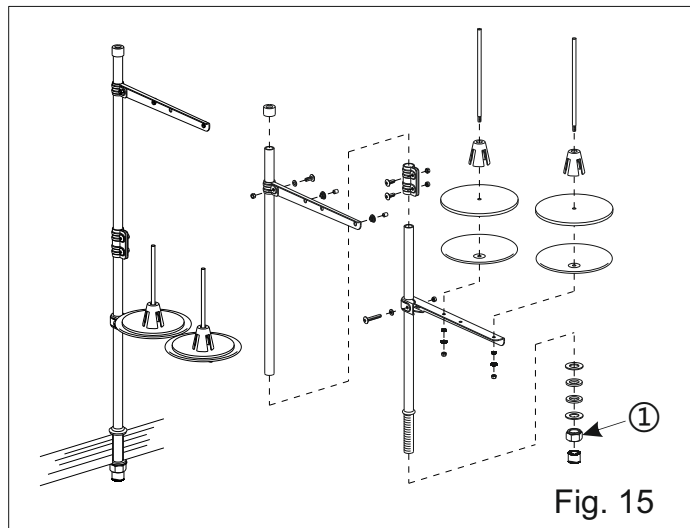
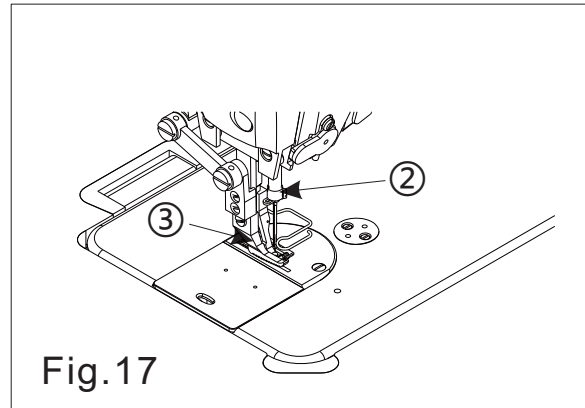
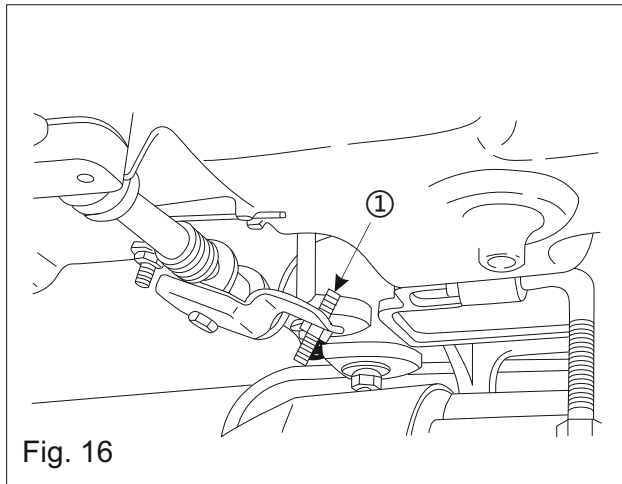


Fig. 15

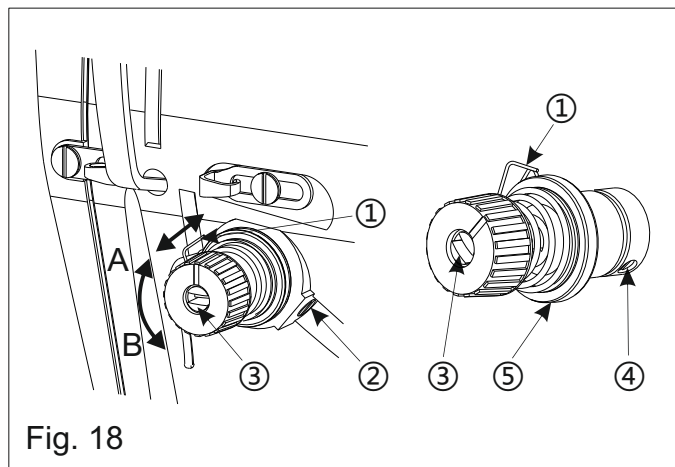
## 12. Setting presser foot lifting height using the knee lifter

1. Standard presser foot raising height is equal to 5 mm.
2. It can be increased to 13 mm by means of the regulation screw (1).
3. After setting the foot raising height to over 10 mm, check if the lower end of needle bar (2) does not come into contact with presser foot (3) at its lowest point.



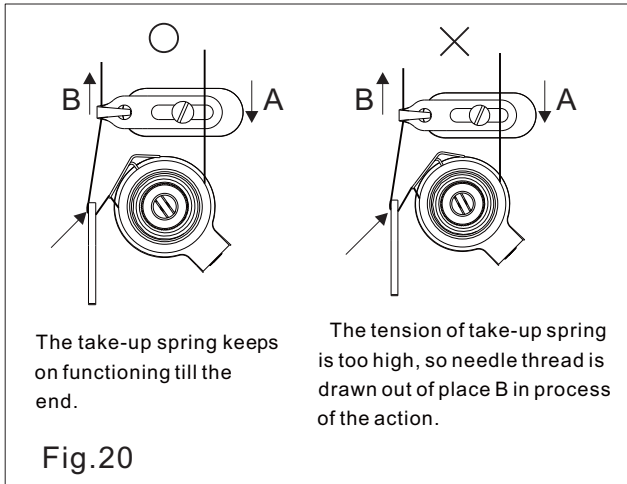
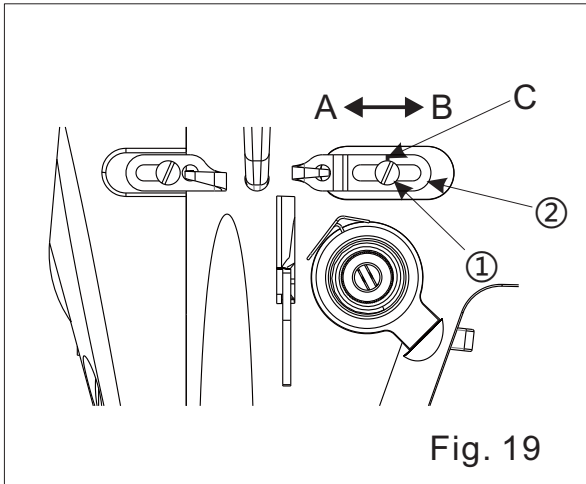
## 13. Compensating spring regulation

1. Changing compensating spring stroke (1):
  - 1) Loose screw (2).
  - 2) After turning the tension regulation screw (3) to the right (direction A) spring stroke will increase.
  - 3) After turning the screw to the left (direction B) the stroke will decrease.
2. Changing compensating spring tension (1):
  - 1) Loosen screw (2) and remove the tensioner from the machine head.
  - 2) Loose screw (4).
  - 3) After turning tensioner pin (3) to the right (direction A) thread tension will increase.
  - 4) After turning the pin to the left (direction B) tension will decrease.



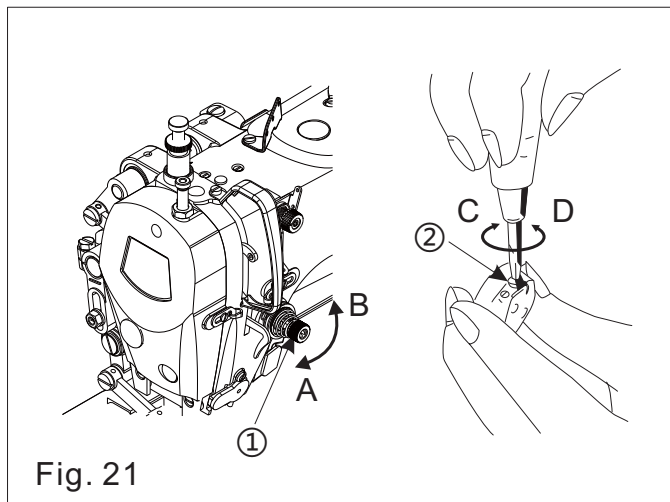
### 14. Thread guide regulation

1. During sewing medium materials, the thread guide (1) should be moved to the right (direction B) in order to increase the length of thread pulled by the thread take-up.
2. During sewing of thick materials, the thread guide (1) should be moved to the left (direction A) in order to decrease the length of thread pulled by the thread take-up.
3. Normally, the thread guide (1) is set so that the marker line (C) is leveled with the line on the screw.



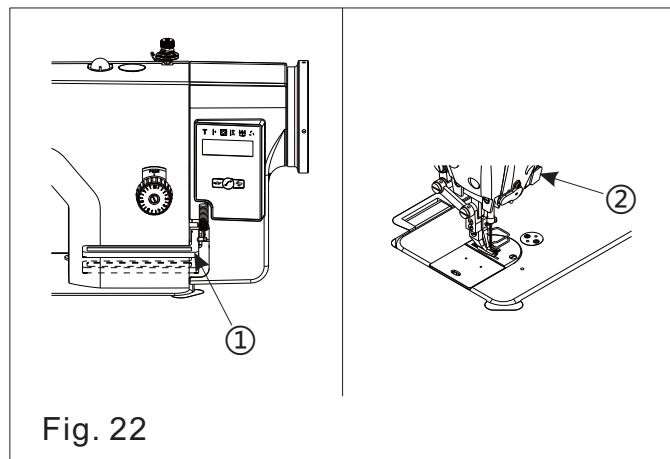
### 15. Thread tension regulator

1. Adjusting thread tension:
  - 1) After turning the pressure regulator knob to the right (direction A) pressure will increase.
  - 2) After turning the knob to the left (direction B) pressure will decrease.
2. Bobbin thread tension adjusting:
  - 1) After turning the bobbin spring screw (2) to the right (direction C) tension will increase.
  - 2) After turning the screw to the left (direction D) the tension will decrease.



### 16. Sewing and Bartacking

Switch on the machine and press the pedal to start sewing. when the reverse lever ① is pressed or the backtacing button ② is on during sewing, the feed will be reversed. After release, the feed will recover to normal sewing.



### 17. Presser foot regulation

1. Loosen the lock nut ①.
2. Turn the adjusting screw ② to adjust the pressure of presser foot, if it's not enough, please turn the screw ⑤ to increase the pressure. The pressure should be as weak as possible, but strong enough so that the material doesn't slip.
3. Tighten the nut ①.
4. Loosen the nut ③.
5. Turn the screw ④ clock wise to increase the pressure, on the contrary, turn the screw counterclockwise to decrease the pressure.
6. Tighten the nut ③.

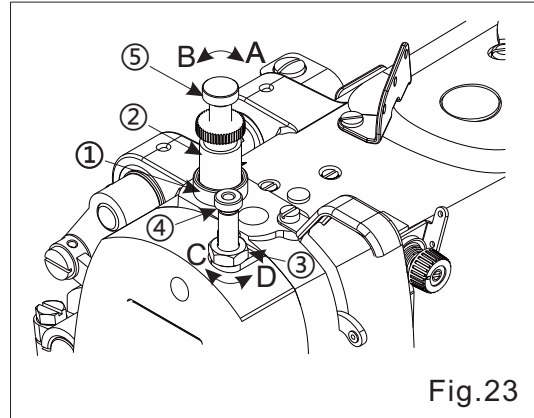


Fig.23

### 18. Foot bar height regulation

1. Loosen screw (1). Set the height and angle of the presser foot.
2. After setting, tighten screw (1).

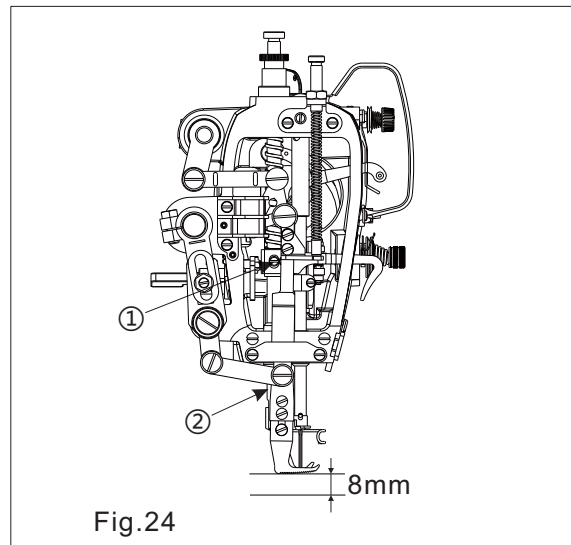


Fig.24

### 19. Feed dog height

1. The feed dog is factory-adjusted so that it just out from the throat plate 1.2mm.
2. To adjust the height of the feed dog
  - 1) Loosen screw ② of crank ①.
  - 2) Move the feed bar up or down to make adjustment.
  - 3) Securely tighten screw ②.

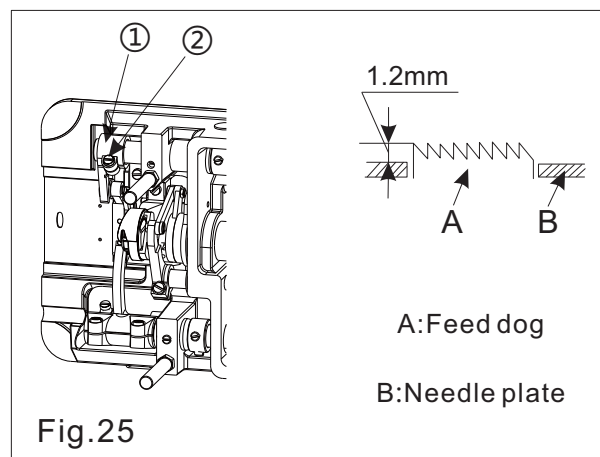


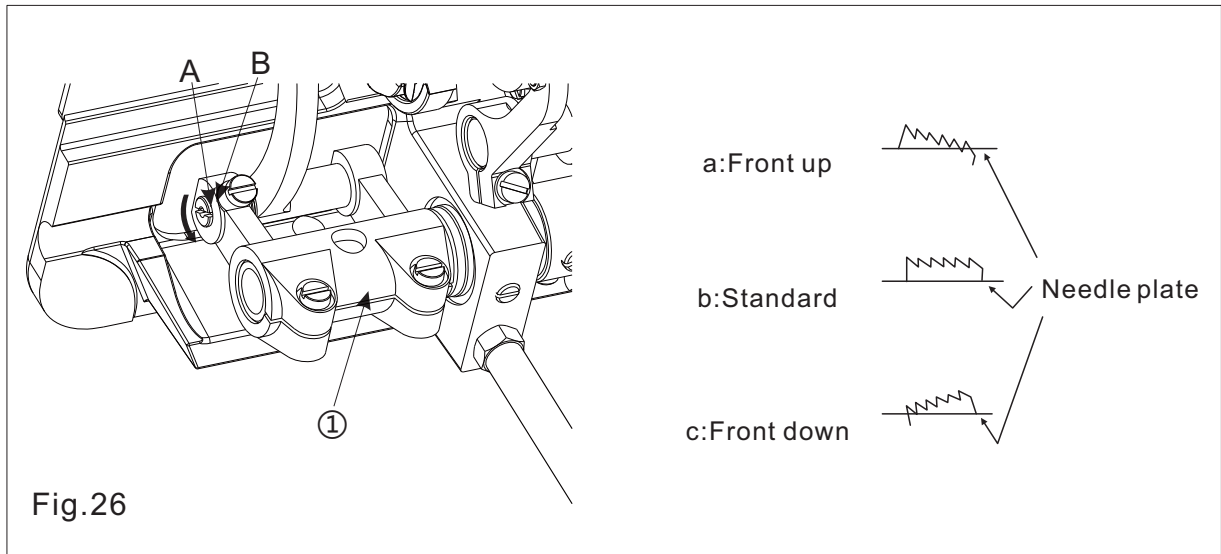
Fig.25

## 20. Feed dog tilting

To tilt the feed dog loosen screw (1) and turn screw (3) to A (lower front) and B (raised front) direction.

**Attention:**

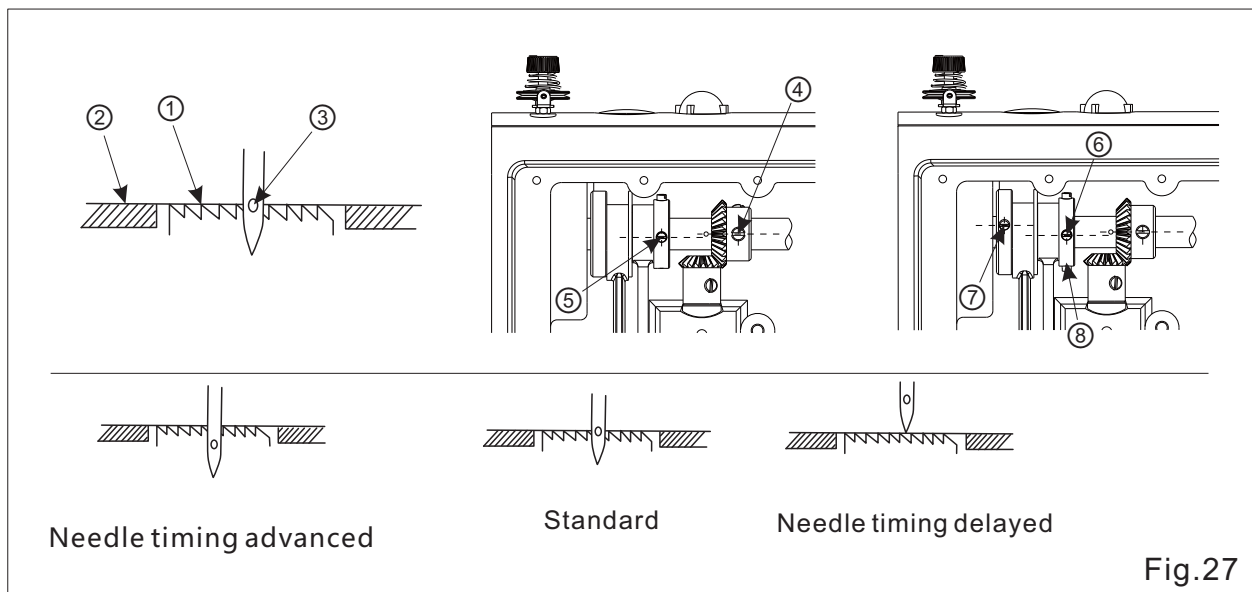
After this regulation feed dog height is changed, and should be re-checked.



## 21. Feed timing

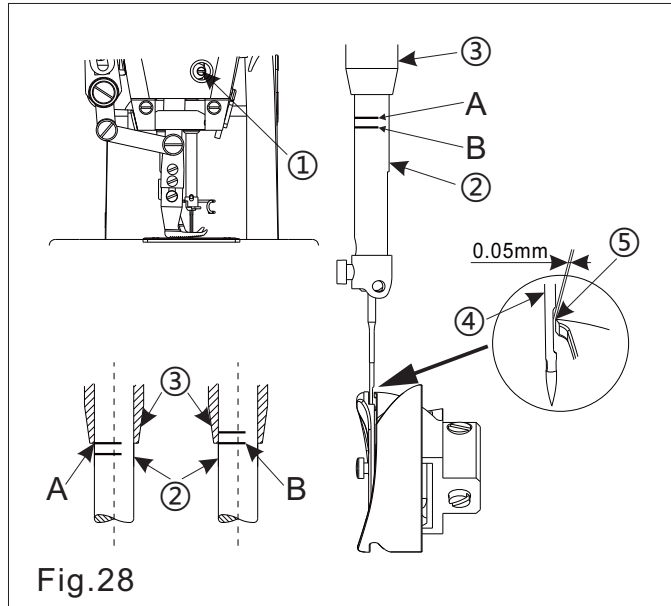
The standard timing is when the feed dog is lowered from its highest position until it is flush with the top of the needle plate (2), and the needle eye (3) is also aligned horizontally with the surface. Adjust by changing the phases of feed cam and eccentric wheel UD.

1. Remove the rear cover.
2. Turn the machine pulley in reverse direction. Set the second screw (4) on the gear of upper shaft as reference mark, make the third screw (5) of eccentric wheel UD slightly lower than the reference mark screw (4).
3. Continue to turn the machine pulley, set the second screw (6) of eccentric wheel UD as reference mark, make the third screw (7) of feed cam slightly higher than the reference mark screw (6).



## 22. Needle bar and hook regulation

1. Turn pulley until the needle bar is located in its lowest point and loosen screw (1).
2. Align marker line A on the needle bar with the lower end of the needle bar sleeve (3) and tighten screw (1).
3. Loosen the three hook screws, turn pulley and level lower marker line B on the needle bar (2) with the lower end of the needle bar sleeve.
4. After carrying out the above adjustment, level the hook tip (5) with the center of the needle. Set interval from 0.04 to 0.1 mm between the needle and the hook and tighten hook screws securely.

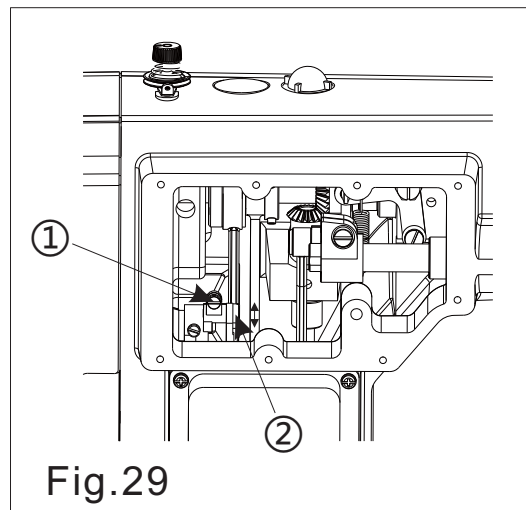


## 23. Adjusting the difference of stitch length between the forward and backtacking

1. Remove the rear cover.
2. Loosen the screw (1), and turn the connection stud (2)

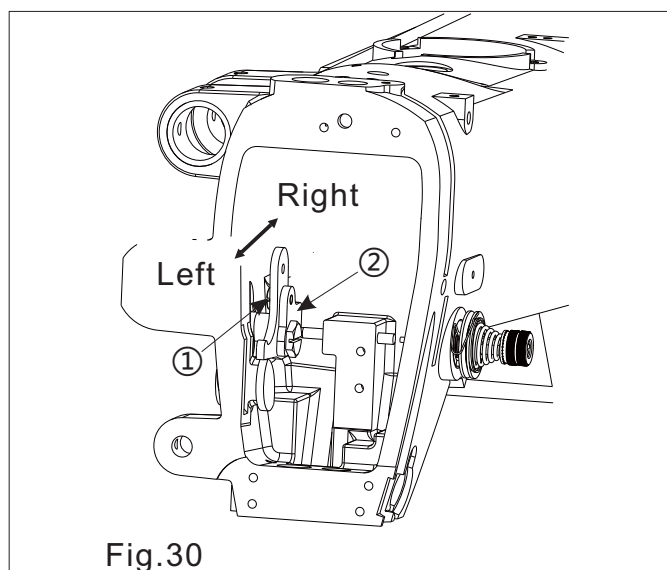
\* Turn the stud (2) clockwise, the forward stitch length will be longer and the back tacking stitch length will be shorter.

\* Turn the stud (2) counter clockwise, the forward stitch length will be shorter and the back tacking stitch length will be longer.



## 24. Adjusting the tension release

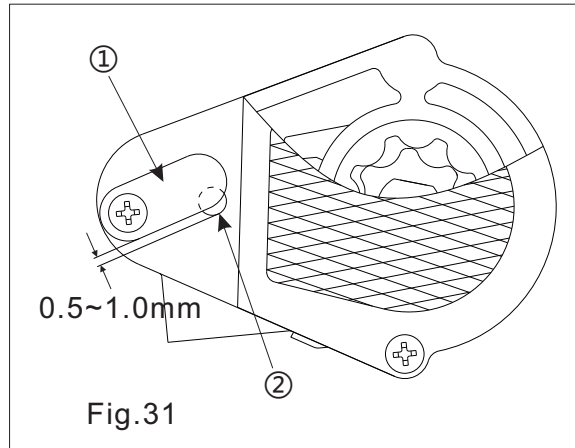
The opening time of the thread tension discs can be adjusted. Remove the rubber cap on the rear of arm, and turn the screw (1) then the thread release cam (2) can be moved left or right. Move the cam rightward, the release time will be slow. Move the cam leftward, the release time will be quick.





### 25. Adjust the oil pump

Observed from the oil gauge window at a lower sewing speed, turn the oil adjustment plate ① to cover the oil hole ②.



### 26. Adjusting the lifting amount of presser feet

1. Vertical movement of presser foot ② and walking foot ① :

\* The walking foot and presser foot move vertically one after another.

\* Usually the stroke of walking foot and presser foot is the same or the stroke of presser foot is slightly lower.

Place the thread take-up lever at the lowest position, and lower the presser bar lifter, loosen the screw ③ and move the upper feed lifting cam ④.

Move it rightward to make the stroke of two feet be equal.

Move it leftward to make the stroke of presser foot be smaller.

2. Adjusting the lifting amount of two feet to materials to be sewn:

Loosen the screw ⑤, and move the screw upward to increase the lifting amount or move the screw downward to decrease the lifting amount.

3. Adjusting the forward/backward clearance of the two feet.

To keep the front groove of walking foot not strike the rear of the presser foot, the clearance of C must be kept about 3mm. Loosen the screw ⑥ of feed arm R, and then turn the feed rock shaft ⑦ to adjust.

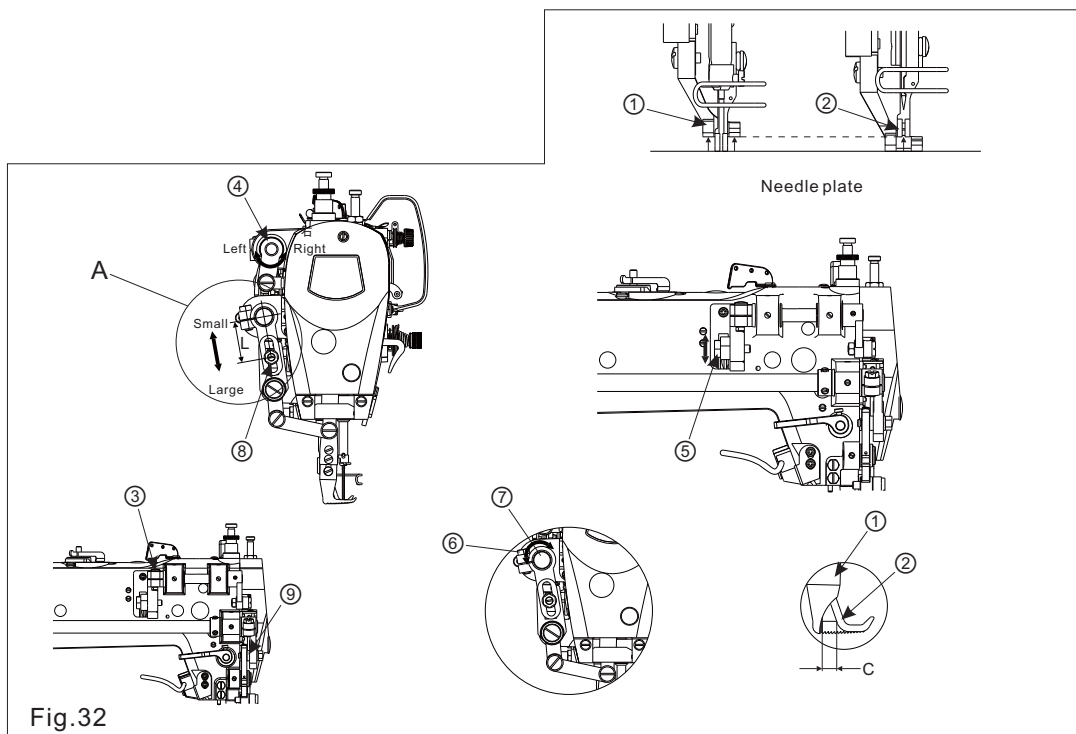
4. Adjusting the feed amount of walking foot (Fig. A)

\* The standard ration of feed amount between feed dog and walking foot is 1:1.

The feed amount of walking foot can be adjusted to suit for the materials to be sewn. Loosen the nut ⑧, and move the slide block ⑨ to adjust.

Upward: decrease the distance L to make the feed amount be smaller.

Downward: increase the distance L to make the feed amount be larger.



## 27. Adjustment of thread trimmer device

### 1. Trimmer mechanism

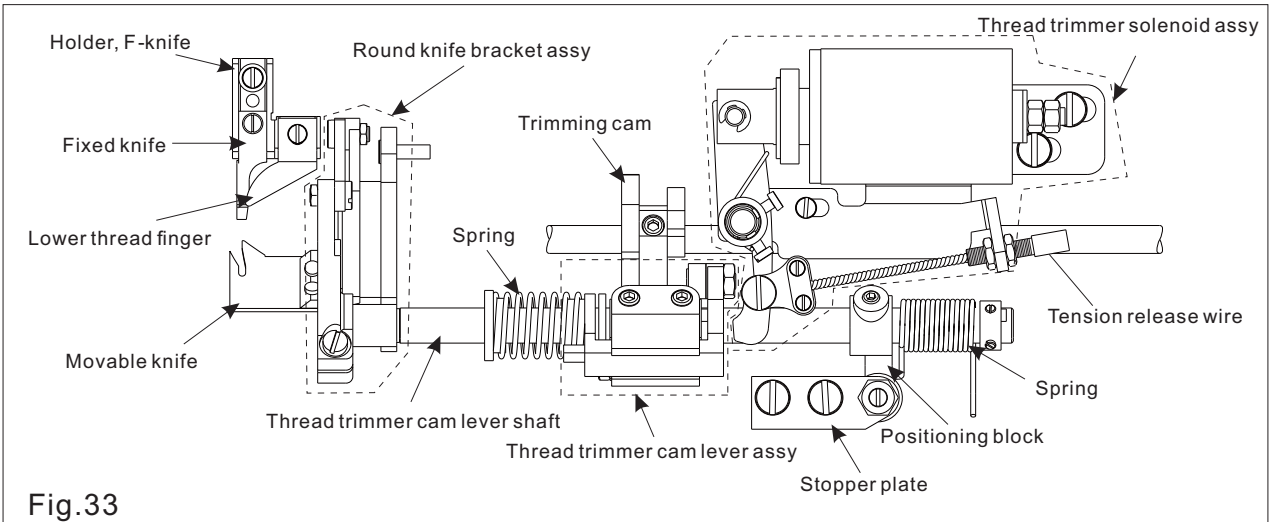


Fig.33

### 2. The relation between fixed knife and moving knife (Fig.34)

- 1) The clearance between fixed knife ① and moving knife ② should be 0.3mm
- 2) Adjust the position illustrated by the Fig.34.
- 3) Move the bobbin case opener and adjust the holder of fixed knife.

### 3. Thread trimmer cam lever shaft (Fig.35)

- 1) Install the shaft ① on the machine bed first.
- 2) Install the trimmer cam lever assy on the shaft ① as illustrated.
- 3) Slightly turn the shaft ①, and install the positioning block ② as illustrated.

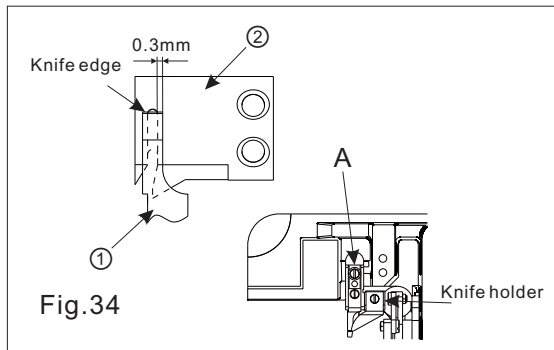


Fig.34

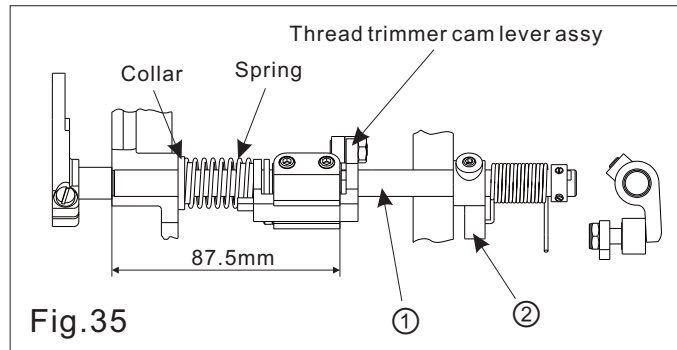


Fig.35

### 4. Installing the trimming solenoid (Fig.36)

- 1) The stroke of solenoid:
  - a. The standard stroke is 6.0mm.
  - b. Turn the nut A to adjust the stroke.
- 2) Install the solenoid
  - a. Fixed the solenoid by the screws B and C.
  - b. Be sure to keep the clearance between the driven plate ① and cam lever ② 1mm.
  - c. When the solenoid is active, there should be a 0.5mm clearance between the cam lever ③ and cam lever ②.

If need to adjust. Please move the solenoid base shown by the arrow.

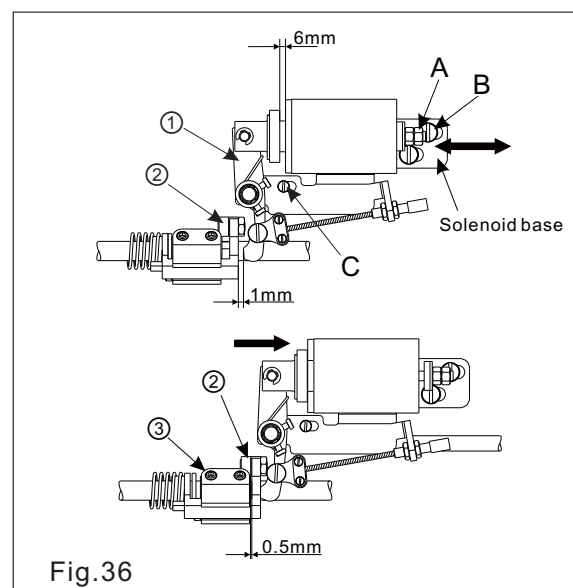


Fig.36

5. Installing the trimming cam (Fig.37)

- 1) Turn the wheel, make the thread take-up lever in the highest position.
- 2) Set the solenoid active, turn the trimming cam ① until the cam is touched with the roller of the cam lever ②, then fix the cam.
- 3) Set the solenoid inactive and make the lever ② restore to the original position, there should be a 0.5~1.0mm clearance between the cam ① and the roller of the cam lever ②.

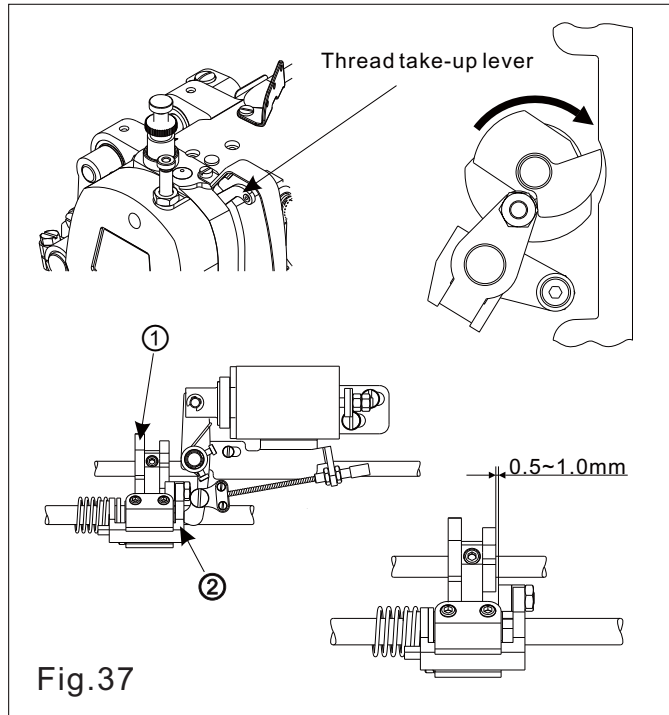


Fig.37

6. Adjusting the knives (Fig.38)

- 1) The relation between fixed knife and moving knife:  
The clearance between movable knife ① and needle center is 7.5mm, and the clearance between fixed knife ② and needle center 5mm.
- 2) Adjusting the knives: Set the function of trimming thread active, the moving knife ① will turn rightward by the trimming cam. When the moving knife ① moves to its furthest position, the clearance between two knives ① and ② should be 1.5-2.0mm.
- 3) Adjusting the trimming pressure: If the thread trimming not smoothly, especially the thick thread used, just need to increase the trimming pressure. The trimming pressure is adjusted as follows: loosen the nut B, adjust the screw A to get the reasonable pressure.

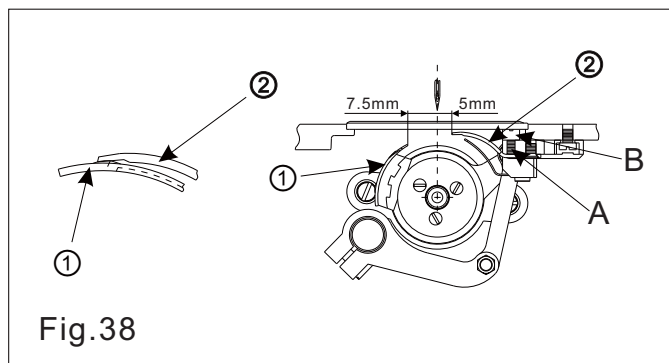


Fig.38

28. Adjusting the upper thread length after thread trimming

Turn the nut ① to adjust the upper thread length. At the time of thread trimming, the thread tension mechanism will release and the needle thread tension is only applied by the thread ①. The standard trailing length for the needle thread is 40-70mm. If increase the thread guide tension, the trailing length will be short; If decrease the thread guide tension, the trailing length will be longer.

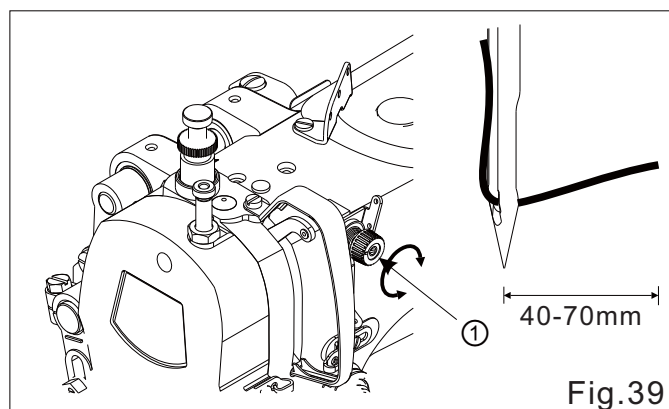






Fig.39

29. Ask your supplier about:

	<p>Machine needle with tip adjusted to sewed material:</p> <p>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</p>
	<p>SPIRIT 2</p> <p>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.</p>
	<p>SPIRIT 37</p> <p>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.</p>
	<p>TWE6</p> <p>Tweezers</p>

# CE DECLARATION OF CONFORMITY

Distributor:

Strima Sp. z o.o.

Swadzim, st. Poznańska 54

62-080 Tarnowo Podgórne, Polska

We declare, that the following product:

## **Lockstitch machine**

**Texi Walker WF Servo** (ZJ0303L-3-BD)

**Texi Walker WF AUT** (ZJ0303L-3-D4)

which this declaration relates, complies with the following directives:

Machinery directive 2006/42/EC

Low voltage directive 2014/35/EU

Harmonized norm used: EN 60204-31:2013





**HD** *texi*®

Dealer: