

S-7200B

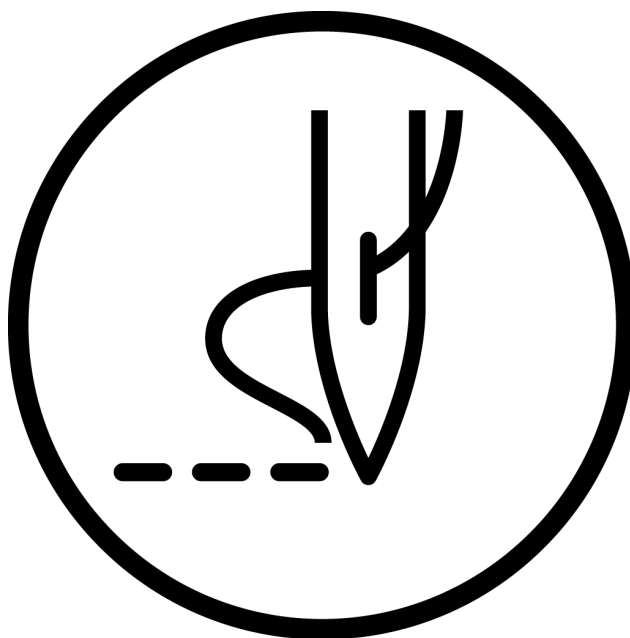
Basic Operation Manual

SINGLE NEEDLE DIRECT DRIVE STRAIGHT LOCK STITCHER WITH THREAD TRIMMER

Please read this manual before using the machine.

Please keep this manual within easy reach for quick reference.

This basic operation manual describes basic operations including sewing machine operations. For cleaning, standard adjustments and more details, please refer to the instruction manual contained in the Document CD.



brother®

Thank you very much for buying a BROTHER sewing machine. Before using your new machine, please read the safety instructions and the explanations given in the instruction manual.

With industrial sewing machines, it is normal to carry out work while positioned directly in front of moving parts such as the needle and thread take-up, and consequently there is always a danger of injury that can be caused by these parts. Follow the instructions from training personnel and instructors regarding safe and correct operation before operating the machine so that you will know how to use it correctly.



SAFETY INSTRUCTIONS

[1] Safety indications and their meanings

This instruction manual and the indications and symbols that are used on the machine itself are provided in order to ensure safe operation of this machine and to prevent accidents and injury to yourself or other people.

The meanings of these indications and symbols are given below.


Indications

 DANGER	The instructions which follow this term indicate situations where failure to follow the instructions may result in death or serious injury.
 CAUTION	The instructions which follow this term indicate situations where failure to follow the instructions could cause injury when using the machine or physical damage to equipment and surroundings.

Symbols




.....

This symbol () indicates something that you should be careful of. The picture inside the triangle indicates the nature of the caution that must be taken.
(For example, the symbol at left means “beware of injury”.)




.....

This symbol () indicates something that you must not do.



.....

This symbol () indicates something that you must do. The picture inside the circle indicates the nature of the thing that must be done.
(For example, the symbol at left means “you must make the ground connection”.)

[2] Notes on safety

DANGER



Wait at least 5 minutes after turning off the power switch and disconnecting the power cord from the wall outlet before opening the face plate of the control box. Touching areas where high voltages are present can result in severe injury.

CAUTION

Environmental requirements



Use the sewing machine in an area which is free from sources of strong electrical noise such as electrical line noise or static electric noise. Sources of strong electrical noise may cause problems with correct operation.



Any fluctuations in the power supply voltage should be within $\pm 10\%$ of the rated voltage for the machine. Voltage fluctuations which are greater than this may cause problems with correct operation.



The power supply capacity should be greater than the requirements for the sewing machine's power consumption. Insufficient power supply capacity may cause problems with correct operation.



The ambient temperature should be within the range of 5°C to 35°C during use. Temperatures which are lower or higher than this may cause problems with correct operation.



The relative humidity should be within the range of 45% to 85% during use, and no dew formation should occur in any devices. Excessively dry or humid environments and dew formation may cause problems with correct operation.



In the event of an electrical storm, turn off the power and disconnect the power cord from the wall outlet. Lightning may cause problems with correct operation.

Installation



Machine installation should only be carried out by a qualified technician.



Contact your Brother dealer or a qualified electrician for any electrical work that may need to be done.



The sewing machine weighs more than 44 kg. The installation should be carried out by two or more people.



Do not connect the power cord until installation is complete. The machine may operate if the treadle is depressed by mistake, which could result in injury.



Turn off the power switch before inserting or removing the plug, otherwise damage to the control box could result.



Be sure to connect the ground. If the ground connection is not secure, you run a high risk of receiving a serious electric shock, and problems with correct operation may also occur.



When securing the cords, do not bend the cords excessively or fasten them too hard with staples, otherwise there is the danger that fire or electric shocks could occur.



If using a work table which has casters, the casters should be secured in such a way so that they cannot move.



Use both hands to hold the machine head when tilting it back or returning it to its original position. If only one hand is used, the weight of the machine head may cause your hand to slip, and your hand may get caught.













Be sure to wear protective goggles and gloves when handling the lubricating oil and grease, so that they do not get into your eyes or onto your skin, otherwise inflammation can result.

Furthermore, do not drink the oil or eat the grease under any circumstances, as they can cause vomiting and diarrhea.





Keep the oil out of the reach of children.

CAUTION









Sewing

- | | |
|--|---|
| <p> This sewing machine should only be used by operators who have received the necessary training in safe use beforehand.</p> <p> The sewing machine should not be used for any applications other than sewing.</p> <p> Be sure to wear protective goggles when using the machine.
If goggles are not worn, there is the danger that if a needle breaks, parts of the broken needle may enter your eyes and injury may result.</p> <p> Turn off the power switch at the following times. The machine may operate if the treadle is depressed by mistake, which could result in injury.</p> <ul style="list-style-type: none"> • When threading the needle • When replacing the bobbin and needle • When not using the machine and when leaving the machine unattended <p> If using a work table which has casters, the casters should be secured in such a way so that they cannot move.</p> | <p> Attach all safety devices before using the sewing machine. If the machine is used without these devices attached, injury may result.</p> <p> Do not touch any of the moving parts or press any objects against the machine while sewing, as this may result in personal injury or damage to the machine.</p> <p> Use both hands to hold the machine head when tilting it back or returning it to its original position. If only one hand is used, the weight of the machine head may cause your hand to slip, and your hand may get caught.</p> <p> If an error occurs in machine, or if abnormal noises or smells are noticed, immediately turn off the power switch. Then contact your nearest Brother dealer or a qualified technician.</p> <p> If the machine develops a problem, contact your nearest Brother dealer or a qualified technician.</p> |
|--|---|

Cleaning

- | | |
|--|--|
| <p> Turn off the power switch before carrying out cleaning. The machine may operate if the treadle is depressed by mistake, which could result in injury.</p> <p> Use both hands to hold the machine head when tilting it back or returning it to its original position. If only one hand is used, the weight of the machine head may cause your hand to slip, and your hand may get caught.</p> | <p> Be sure to wear protective goggles and gloves when handling the lubricating oil and grease, so that they do not get into your eyes or onto your skin, otherwise inflammation can result.
Furthermore, do not drink the oil or eat the grease under any circumstances, as they can cause vomiting and diarrhea.
Keep the oil out of the reach of children.</p> <p> Use only the proper replacement parts as specified by Brother.</p> |
|--|--|

Maintenance and inspection

- | | |
|---|---|
| <p> Maintenance and inspection of the sewing machine should only be carried out by a qualified technician.</p> <p> Ask your Brother dealer or a qualified electrician to carry out any maintenance and inspection of the electrical system.</p> <p> Turn off the power switch and disconnect the power cord from the wall outlet at the following times, otherwise the machine may operate if the treadle is depressed by mistake, which could result in injury.</p> <ul style="list-style-type: none"> • When carrying out inspection, adjustment and maintenance • When replacing consumable parts such as the rotary hook <p> If the power switch needs to be left on when carrying out some adjustment, be extremely careful to observe all safety precautions.</p> | <p> Use both hands to hold the machine head when tilting it back or returning it to its original position. If only one hand is used, the weight of the machine head may cause your hand to slip, and your hand may get caught.</p> <p> Use only the proper replacement parts as specified by Brother.</p> <p> If any safety devices have been removed, be absolutely sure to re-install them to their original positions and check that they operate correctly before using the machine.</p> <p> Any problems in machine operation which result from unauthorized modifications to the machine will not be covered by the warranty.</p> |
|---|---|

[3] Warning labels

The following warning labels appear on the sewing machine.

Please follow the instructions on the labels at all times when using the machine. If the labels have been removed or are difficult to read, please contact your nearest Brother dealer.

1

	<p>⚠ 危険</p> <p>高電圧部分にふれて、大けがをすることがある。電源を切り、5分たってからカバーをはずすこと。</p>	<p>⚠ 危険</p> <p>触摸高压电部分，会导致受伤。在切断电源5分钟后，再开启盖罩。</p>
⚠ DANGER	⚠ GEFAHR	⚠ DANGER
Hazardous voltage will cause injury. Turn off main switch and wait 5 minutes before opening this cover.	Hochspannung verletzungsgefahr! Bitte schalten sie den hauptschalter aus und warten sie 5 minuten, bevor sie diese abdeckung öffnen.	Un voltage non adapte provoque des blessures. Eteindre l'interrupteur et attendre 5 minutes avant d'ouvrir le capot.
	⚠ PELIGRO	Un voltaje inadecuado puede provocar las heridas. Apagar el interruptor principal y esperar 5 minutos antes de abrir esta cubierta.

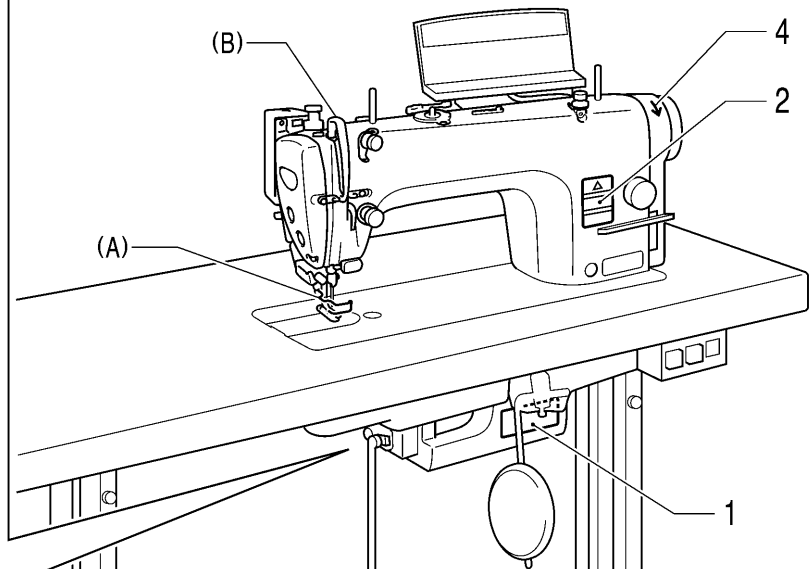
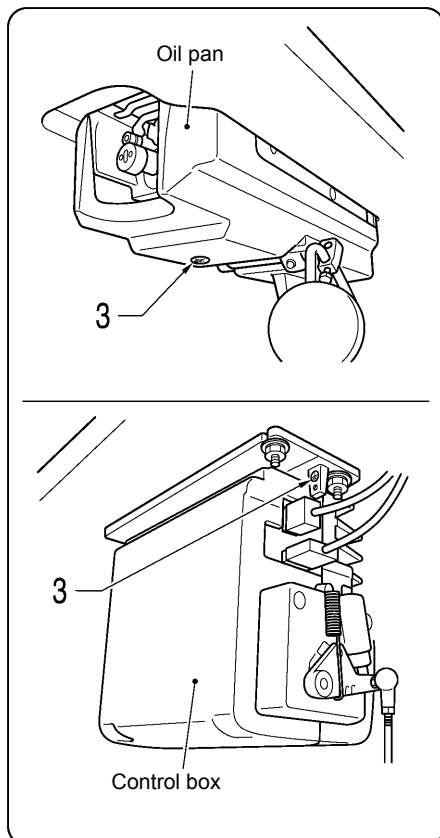
2

⚠ 注意
触摸运动部分，易造成受伤。所以在装上安全保护装置后，再进行缝纫操作。在切断电源后，进行穿线，更换梭芯，机针和做清扫，调整工作。
⚠ CAUTION
Moving parts may cause injury. Operate with safety devices. Turn off main switch before threading, changing bobbin and needle, cleaning etc.

- 3** Be sure to connect the ground. If the ground connection is not secure, you run a high risk of receiving a serious electric shock, and problems with correct operation may also occur.

Safety devices:
(A) Finger guard
(B) Thread take-up cover

- 4** Direction of operation



3629M

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1. CONVENIENT FUNCTION FOR SMOOTH SEWING

Lower thread counter

➔ **INSTRUCTION MANUAL CD**
5-7. Using the lower thread counter

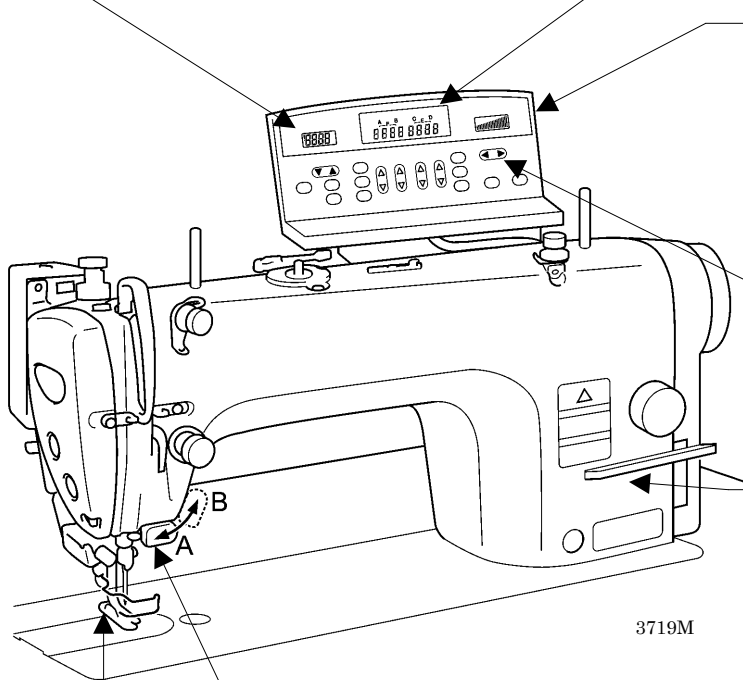
The graphic display lights and a buzzer sounds before the bobbin thread runs out, so that the operator can concentrate on the job with confidence.

Notification given when greasing is required

➔ **INSTRUCTION MANUAL CD**
11-2. Applying grease

GREASEUP

3163M



3719M

Selectable starting speed

The sewing speed at the sewing start can be selected in accordance with the treadle depression amount. You can set the speed according to the preferences of the operator. (Contact the place of purchase.)

Easy setting of sewing speed from operation panel

➔ **Page 17**

The sewing speed can be easily set by the sewing speed control keys.

Condensed stitching

➔ **INSTRUCTION MANUAL CD**
9-3. Sewing condensed stitches

This feature is ideal for use when sewing thin materials that can easily pucker when reverse stitches are sewn. Condensed stitches have a smaller sewing pitch and they help prevent fraying.

Sewing direction

Condensed stitches

3165M

Actuator

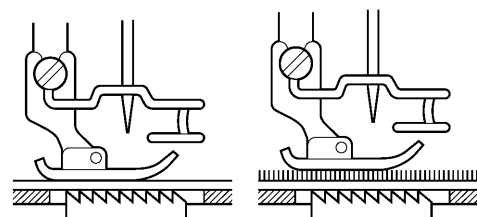
➔ **INSTRUCTION MANUAL CD**
13-1. Adjusting the actuator position

The installation position for the actuator can be adjusted to <A> or . Adjust so that it is in a position where it is easy to operate.

Floating presser foot for easy handling

➔ **INSTRUCTION MANUAL CD**
13-12. Adjusting the presser foot floating amount

A micro-adjustable type floating presser foot is equipped as standard. This device is ideal for controlling presser foot floating in materials that stretch easily and materials with long pile. It prevents seam slippage and also prevents damage to the material. In addition, three-dimensional articles with irregular curves can also be handled with ease.

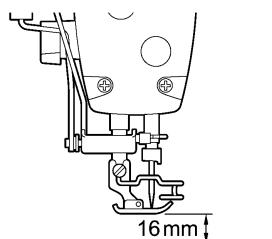


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Maximum presser foot lift amount 16 mm

The knee lifter and the needle up stop (reverse rotation) function together provide 16 mm of space underneath the presser foot. This makes it much easier to insert and remove heavy material without it getting caught on the needle.

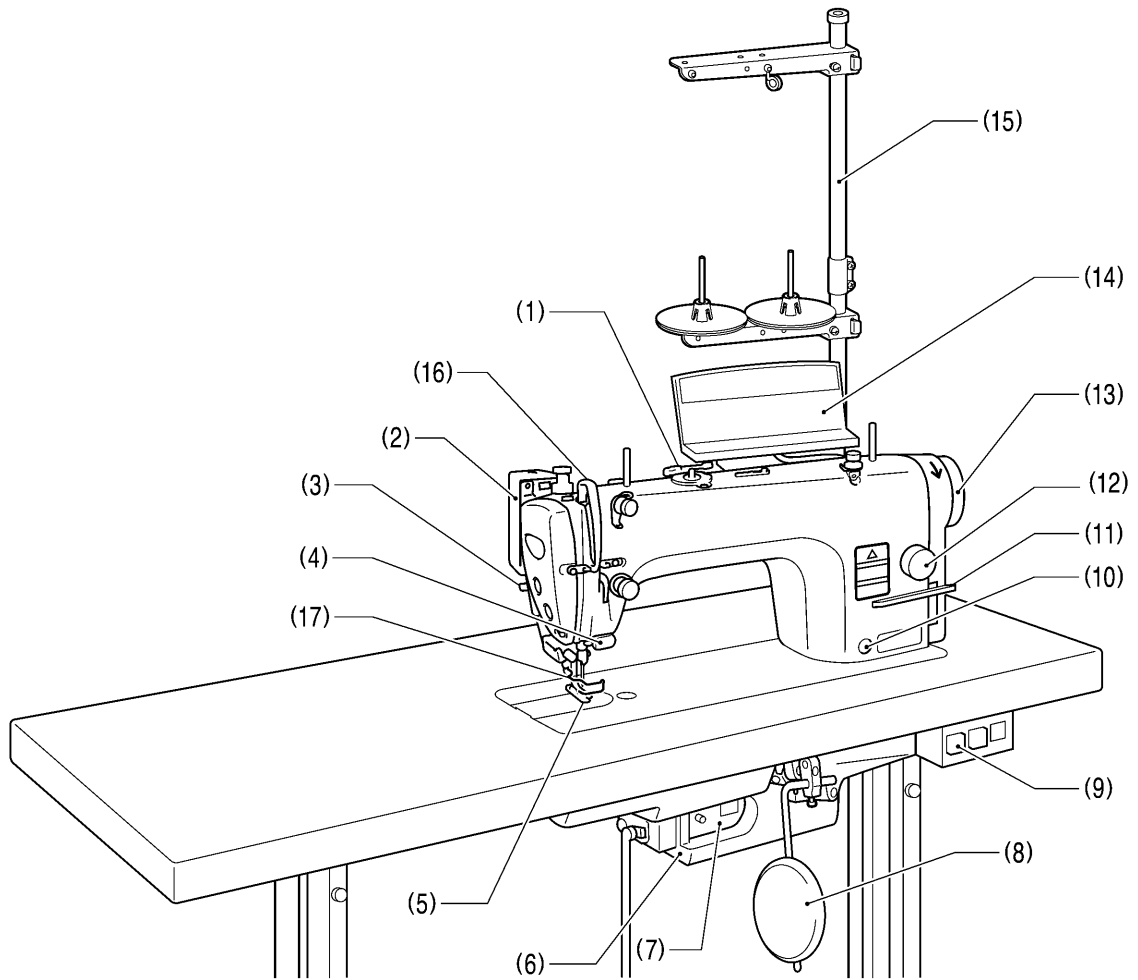
(Contact the place of purchase.)



16mm

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2. NAMES OF MAJOR PARTS



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- | | |
|-----------------------|--|
| (1) Bobbin winder | (2) Thread wiper (-4□□ specifications) |
| (3) Lifting lever | (4) Quick reverse (Actuator) |
| (5) Presser foot | (6) Control box |
| (7) Control box panel | (8) Knee lifter assembly |
| (9) Power switch | (10) Oil gauge window (-□0□, □3□ specifications) |
| (11) Reverse lever | (12) Stitch length dial |
| (13) Machine pulley | (14) Operation panel (Models with operation panel) |
| (15) Cotton stand | |

Safety devices

- | | |
|---------------------------|-------------------|
| (16) Thread take-up cover | (17) Finger guard |
|---------------------------|-------------------|

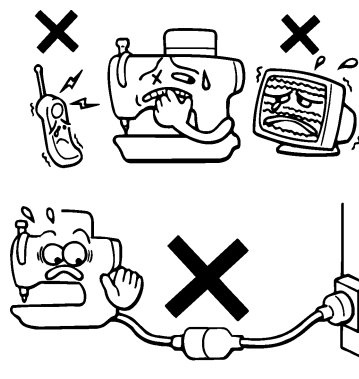
3. INSTALLATION

CAUTION

-  Machine installation should only be carried out by a qualified technician.
-  Contact your Brother dealer or a qualified electrician for any electrical work that may need to be done.
-  The sewing machine weighs more than 44 kg. The installation should be carried out by two or more people.
-  Do not connect the power cord until installation is complete. The machine may operate if the treadle is depressed by mistake, which could result in injury.
-  Use both hands to hold the machine head when tilting it back or returning it to its original position. If only one hand is used, the weight of the machine head may cause your hand to slip, and your hand may get caught.

About the machine set-up location

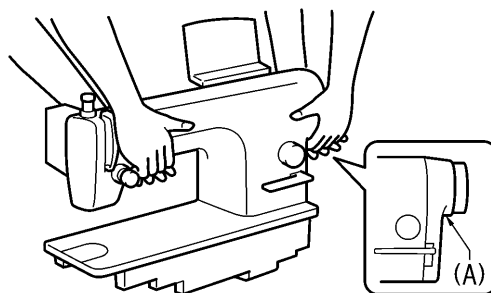
- Do not set up this sewing machine near other equipment such as televisions, radios or cordless telephones, otherwise such equipment may be affected by electronic interference from the sewing machine.
- The sewing machine should be plugged directly into an AC wall outlet. Operation problems may result if extension cords are used.



2086M

Carrying the machine

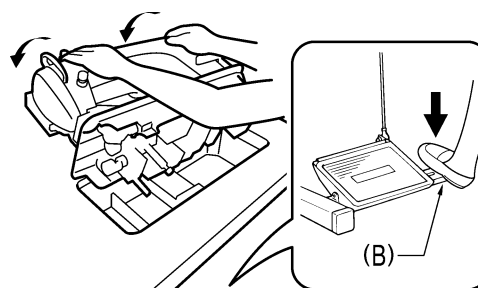
- The machine should be carried by the arm by two people as shown in the illustration.
 - * Hold the motor cover (A) by hand also so that the pulley does not rotate.



3631M

Tilting back the machine head

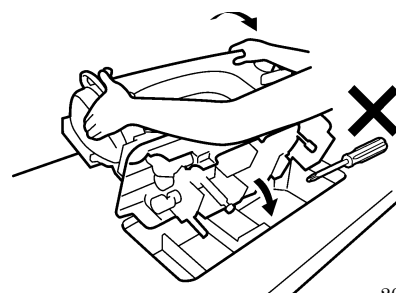
- Hold section (B) with your foot so that the table does not move, and then push the arm with both hands to tilt back the machine head.



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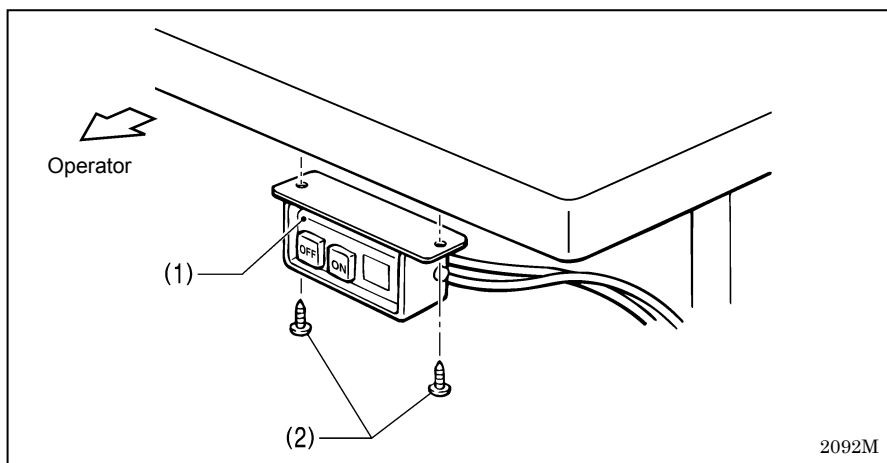
Returning the machine head to the upright position

1. Clear away any tools, etc. which may be near the table holes.
2. While holding the face plate with your left hand, gently return the machine head to the upright position with your right hand.



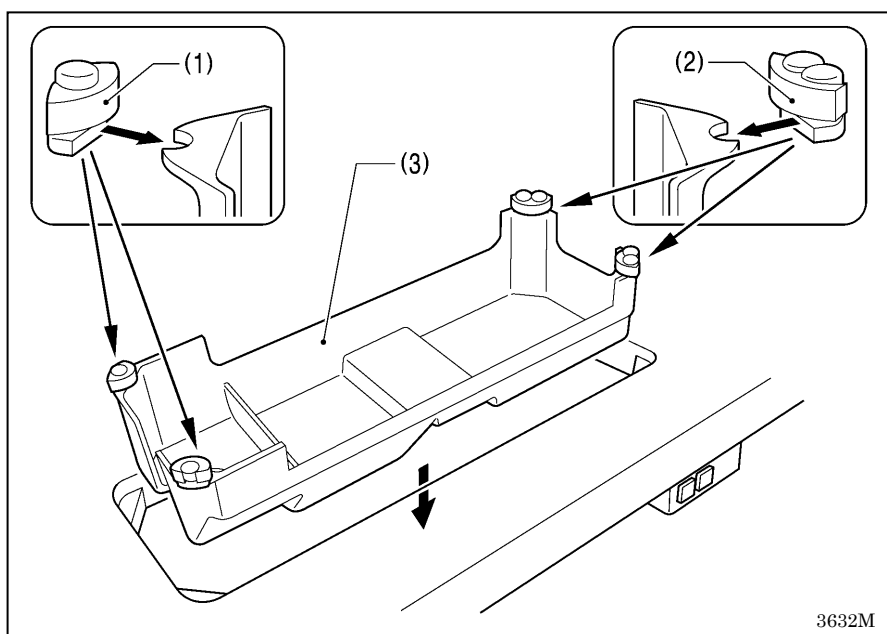
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3. INSTALLATION



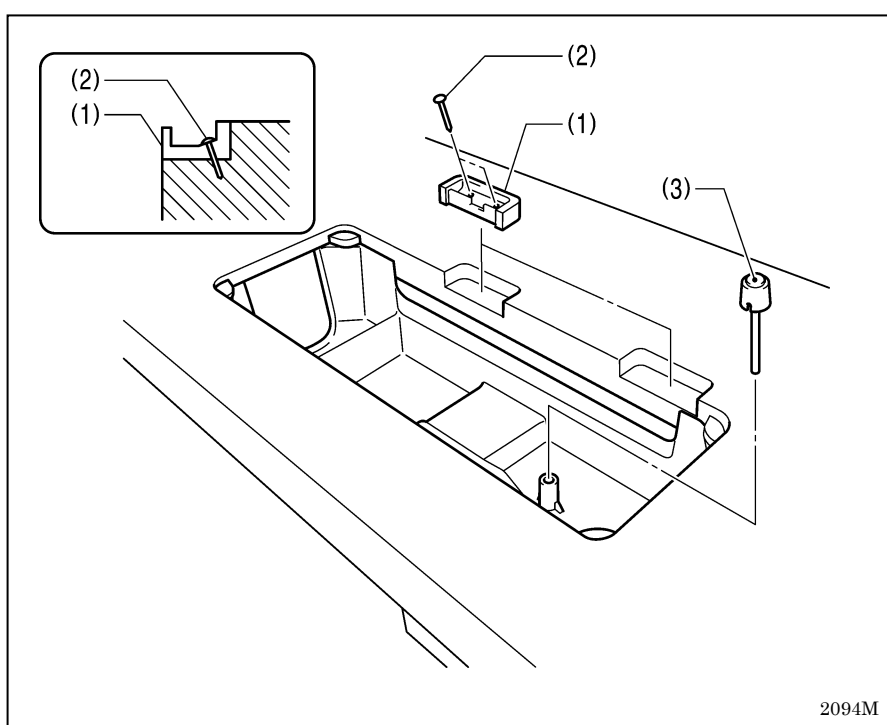
3. Power switch

- (1) Power switch
- (2) Screws [2 pcs]



4. Oil pan

- (1) Head cushions (left) [2 pcs]
- (2) Head cushions (right) [2 pcs]
- (3) Oil pan

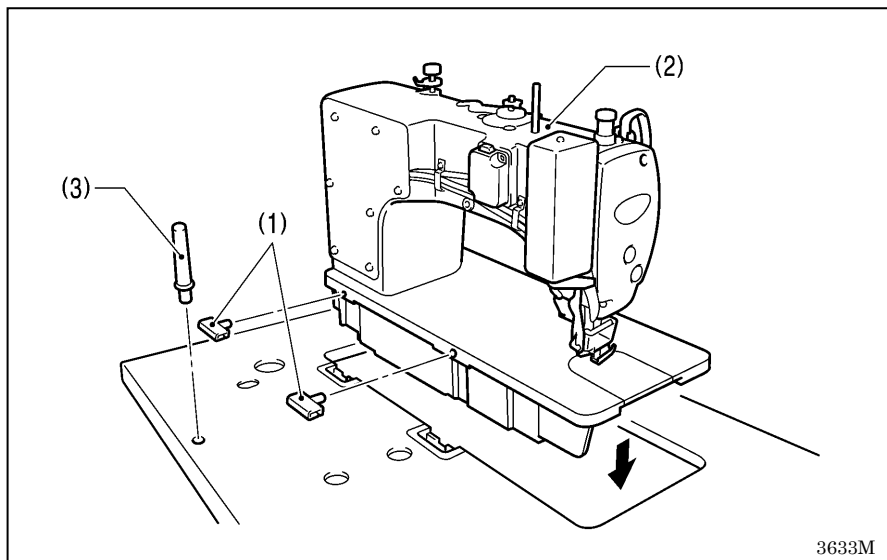


5. Rubber cushions

- (1) Rubber cushions [2 pcs]
- (2) Nails [4 pcs]

6. Knee lifter complying bar

- (3) Knee lifter complying bar

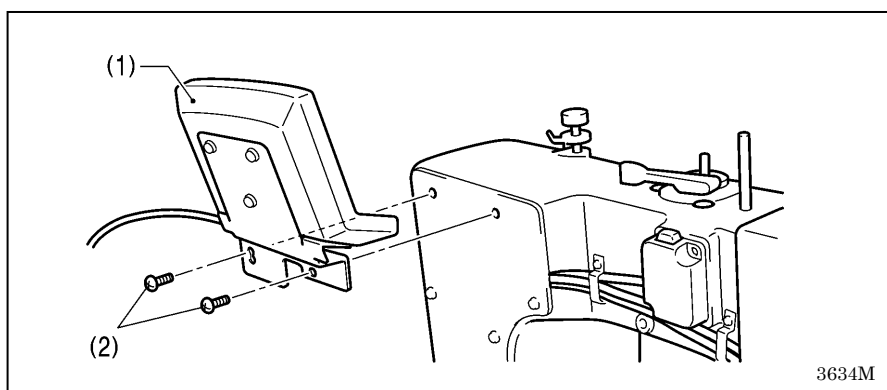


7. Machine head

- (1) Hinges [2 pcs]
- (2) Machine head
- (3) Head rest

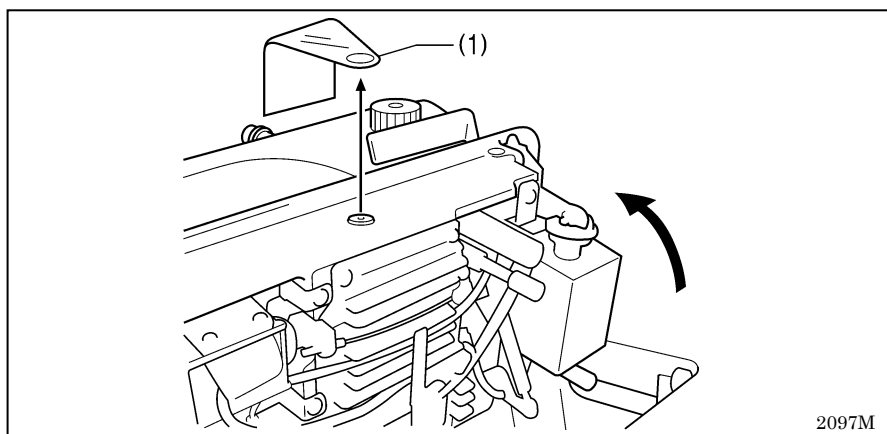
NOTE:

Tap the head rest (3) securely into the table hole. If the head rest (3) is not pushed in as far as it will go, the machine head will not be sufficiently stable when it is tilted back.



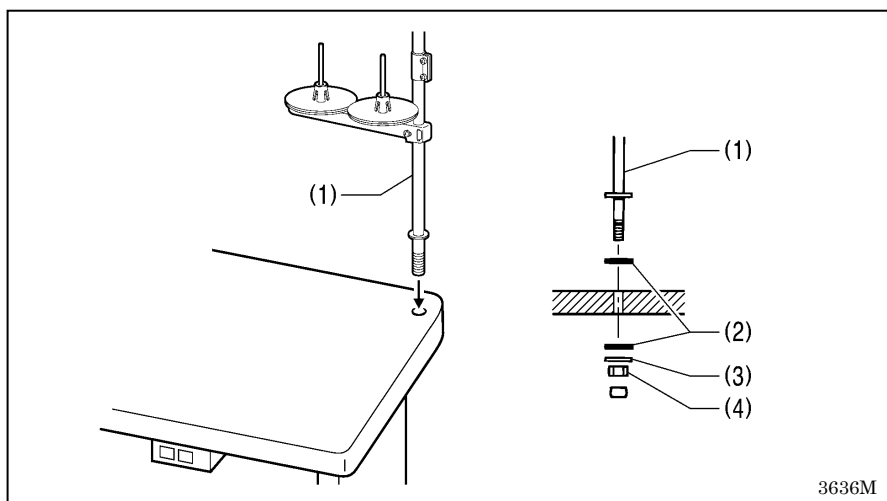
8. Operation panel (Models with operation panel)

- (1) Operation panel
- (2) Screws [2 pcs]
(Use for tightening rear cover)



9. Sticker (Remove)

- (1) Sticker

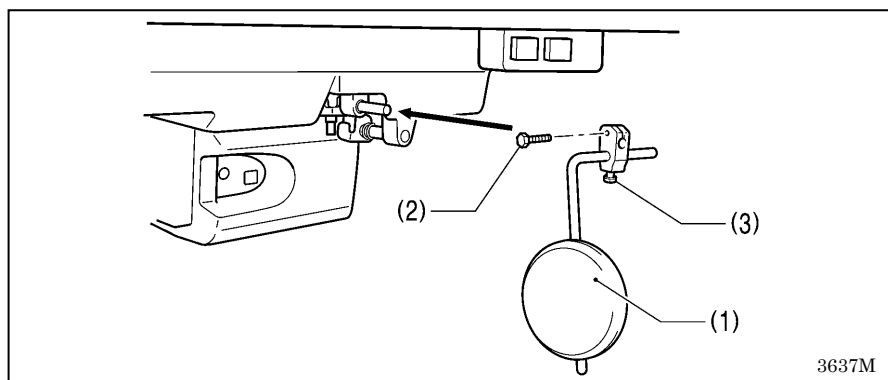


10. Cotton stand

- (1) Cotton stand

NOTE:

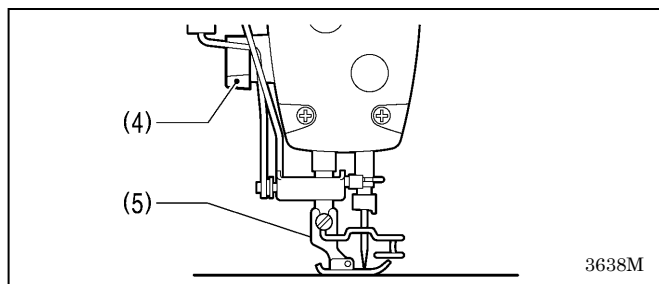
Securely tighten the nut (4) so that the two rubber cushions (2) and the washer (3) are securely clamped and so that the cotton stand (1) does not move.



11. Knee lifter plate

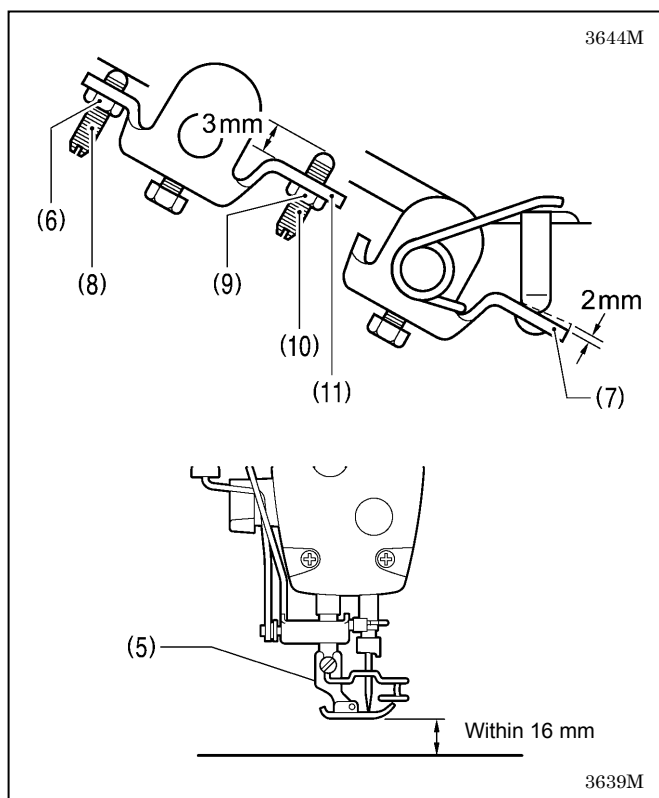
- (1) Knee lifter plate
- (2) Bolt

* Loosen the bolt (3) and move the knee lifter plate (1) to a position where it is easy to use.



<Knee lifter adjustment>

1. Turn the machine pulley so that the feed dog is below the top of the needle plate.
2. Lower the presser foot (5) by using the lifting lever (4).






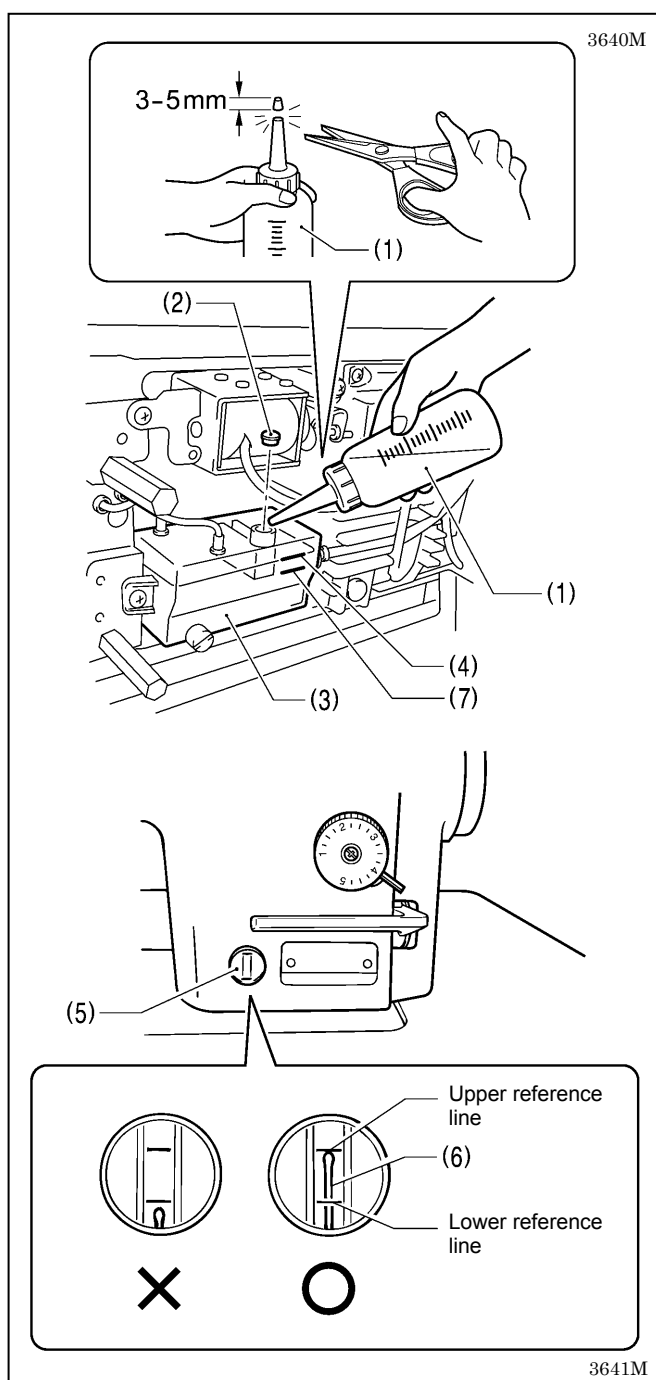
3. Loosen the nut (6).
4. Turn the screw (8) to adjust so that the amount of play in the knee lifter (7) is approximately 2 mm when the knee lifter plate (1) is gently pressed.
5. Securely tighten the nut (6).
6. Loosen the nut (9).
7. Turn the screw (10) until the distance between the end of the screw (10) and the knee lifter (11) is approximately 3 mm.
8. Turn the adjusting screw (10) to adjust so that the presser foot (5) is at the desired position within a distance of 16 mm of the needle plate when the knee lifter plate (1) is fully pressed.
9. After adjustment is completed, securely tighten the nut (9).

3-3. Lubrication (-[0], [3] specifications)

* If the sewing machine is -[5] specifications, it is a complete dry type machine, and so no lubrication is necessary.

CAUTION

-  Do not connect the power cord until lubrication has been completed, otherwise the machine may operate if the treadle is depressed by mistake, which could result in injury.
-  Be sure to wear protective goggles and gloves when handling the lubricating oil and grease, so that they do not get into your eyes or onto your skin, otherwise inflammation can result. Furthermore, do not drink the oil or eat the grease under any circumstances, as they can cause vomiting and diarrhea. Keep the oil out of the reach of children.
-  When cutting the nozzle of the oil tank, hold the base of the nozzle securely. If you hold the end of the nozzle, injury from the scissors may result.



• The sewing machine should always be lubricated and the oil supply replenished before it is used for the first time, and also after long periods of non-use.

• Use only the lubricating oil (Nisseki Mitsubishi Sewing Lube 10N; VG10) specified by Brother.

* If this type of lubricating oil is difficult to obtain, the recommended oil to use is <Exxon Mobil EssoTex SM10; VG10>.

1. Hold the base of the nozzle on the accessory oil tank (1), and then use scissors to cut 3 - 5 mm off the end of the nozzle.
2. Tilt back the machine head.
3. Remove the rubber cap (2), and pour 120ml of lubricating oil into the oil tank (3). (Use the upper reference line (4) as a guide when pouring.)
4. Replace the rubber cap (1).

5. Return the machine head to its original position.

6. Check that the oil gauge (6) comes to the upper reference line in the oil gauge window (5).

<Lubrication oil replenishment interval>

If the oil gauge (6) drops below the lower reference line (or if the oil level drops below the lower reference line (7) on the oil tank (3)), be sure to replenish the oil.

3. INSTALLATION

3-4. Connecting the cords

DANGER



Wait at least 5 minutes after turning off the power switch and disconnecting the power cord from the wall outlet before opening the face plate of the control box. Touching areas where high voltages are present can result in severe injury.

CAUTION



Contact your Brother dealer or a qualified electrician for any electrical work that may need to be done.

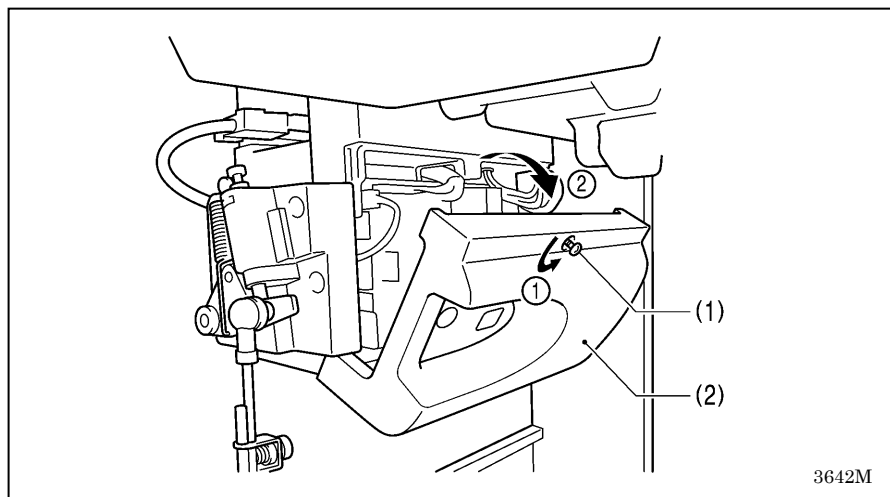


Do not connect the power cord until all cords have been connected.
The machine may operate if the treadle is depressed by mistake, which could result in injury.



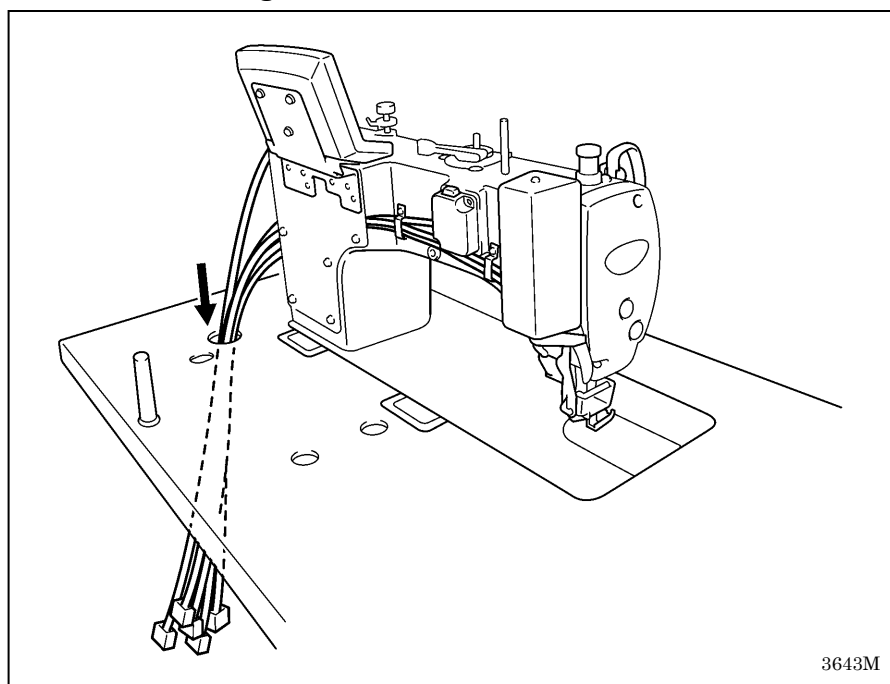
Be sure to connect the ground. If the ground connection is not secure, you run a high risk of receiving a serious electric shock, and problems with correct operation may also occur.

3-4-1. Opening the control box cover

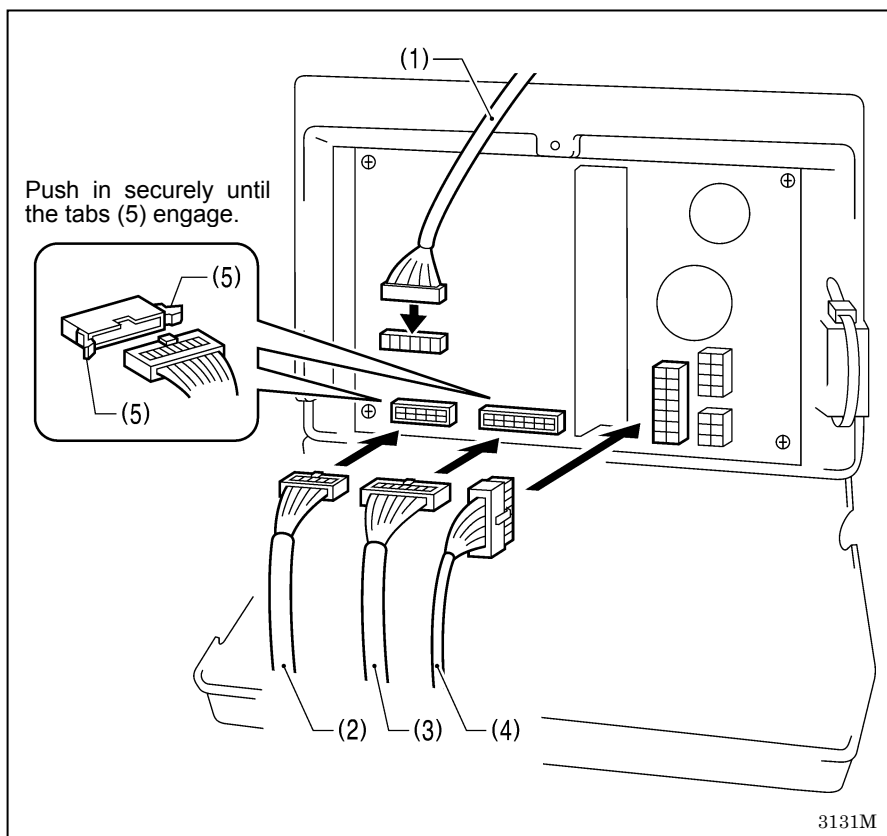


- (1) Screw
- (2) Cover

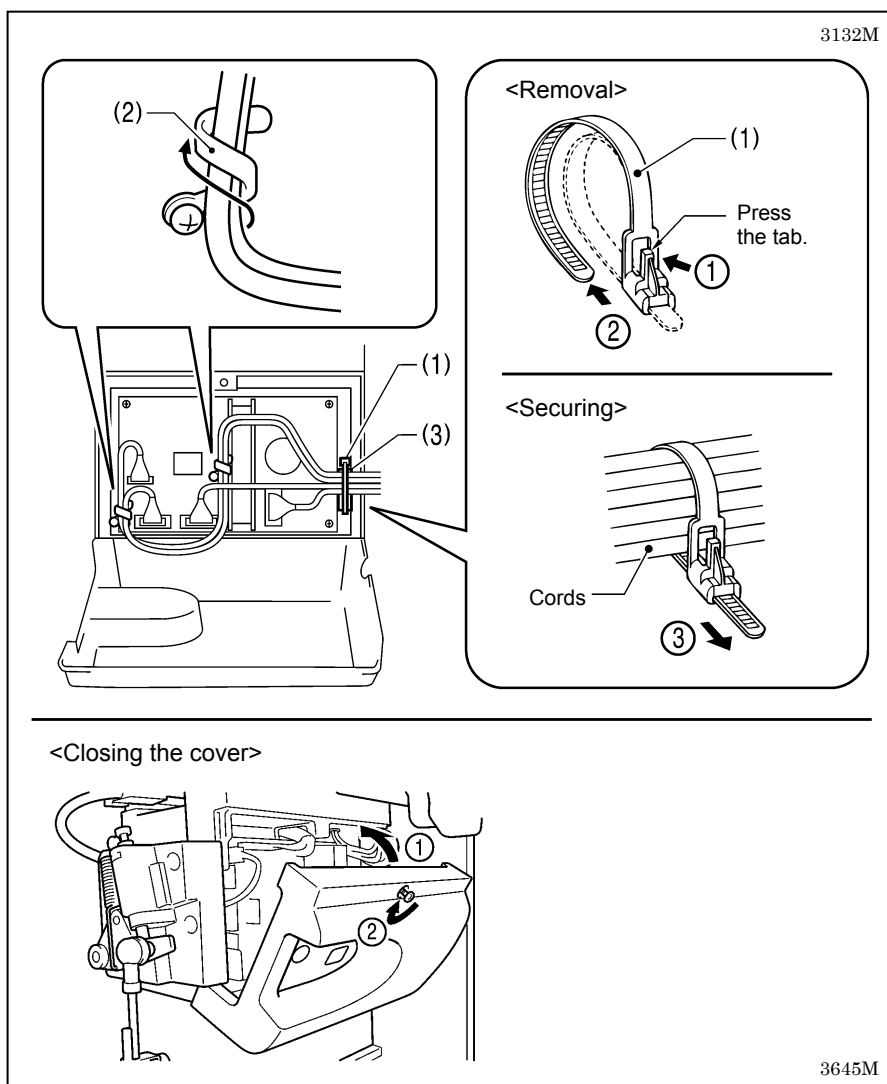
3-4-2. Connecting the cords



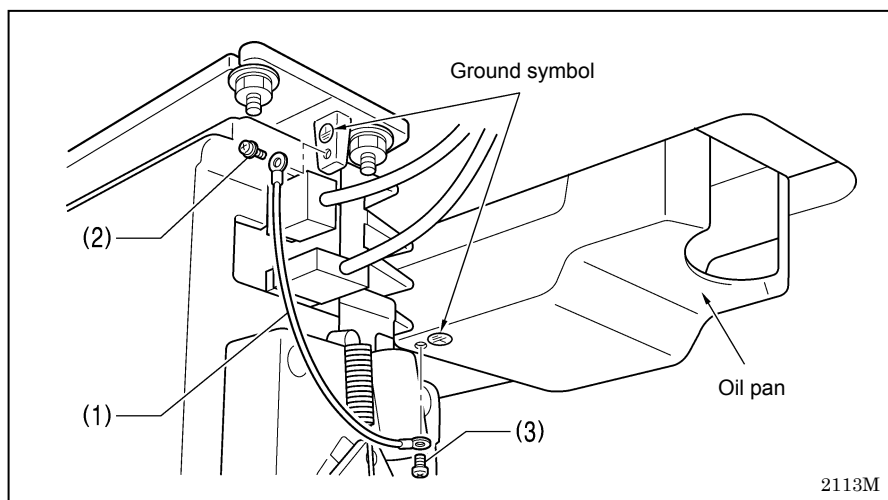
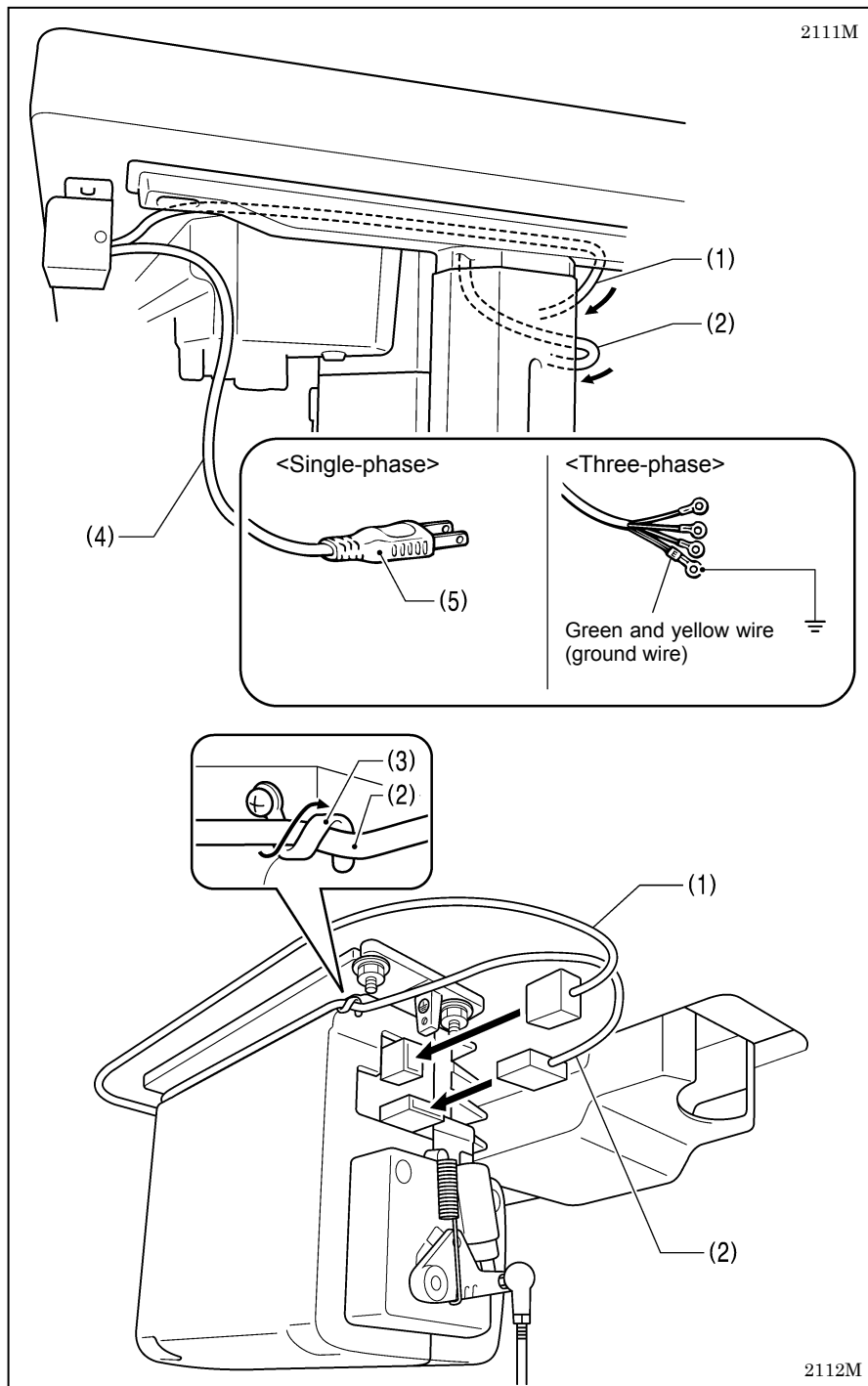
1. Sewing machine cords



Refer to the following page for the 4-pin motor connector.



3. INSTALLATION



3. Other cords

- (1) 6-pin power supply connector
- (2) 4-pin motor connector
- (3) Wire clip
- (4) Power cord

<For single-phase specifications>

Insert the power cord plug (5) into a wall outlet.

<For three-phase specifications>

1. Attach an appropriate plug to the power cord (4). (The green and yellow wire is the ground wire.)
2. Insert the plug into a properly-grounded AC power supply.

NOTE:

Do not use extension cords, otherwise machine operation problems may result.

4. Ground wire

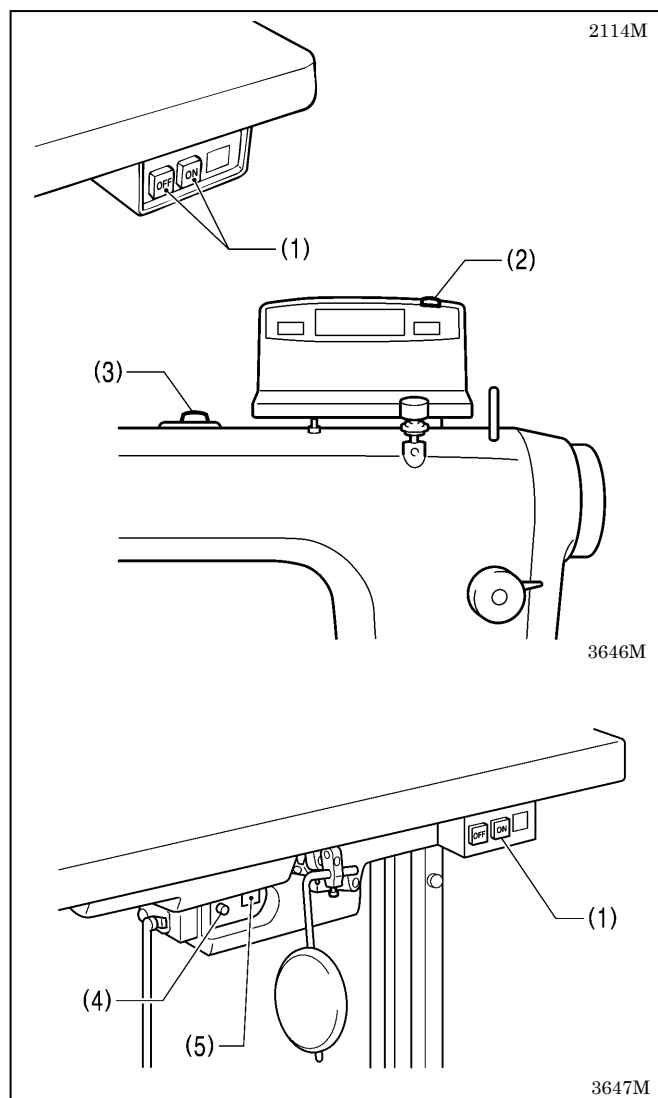
- (1) Ground wire
- (2) Screw [With washer]
- (3) Screw

3-5. Test operation (Operating the treadle)

! CAUTION



Do not touch any of the moving parts or press any objects against the machine while sewing, as this may result in personal injury or damage to the machine.



1. Turning on the power

<Models with operation panel>

Press the ON power switch (1).
The power indicators (2) and (3) will illuminate.

NOTE: When turning the power switch on for the first time

The treadle and the operation panel will not operate for approximately four seconds after the power switch is turned on.

After approximately 4 seconds, "iniT rPM" (speed initialization) or "iniT ALL" (full initialization) will be displayed on the operation panel. After "iniT rPM" or "iniT ALL" is displayed, the treadle can be operated. (The operation panel will change to the stitch number display.) This message will not appear the second and subsequent times that the power switch is turned on.

<Models without operation panel>

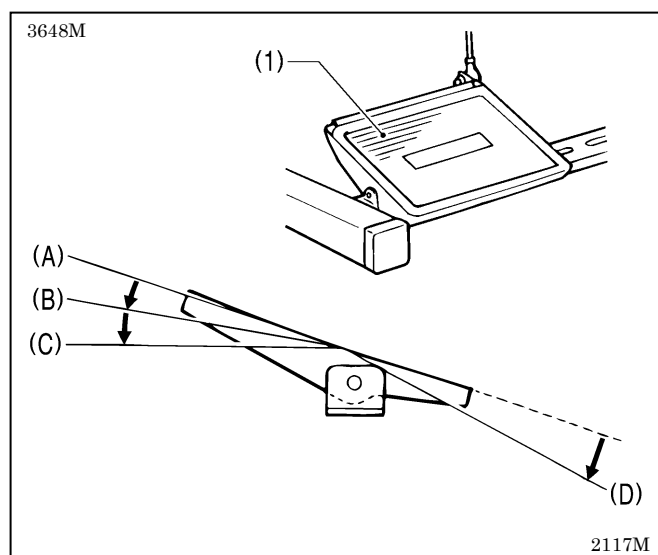
Press the ON power switch (1).
The power indicators (3) and (4) will illuminate.

NOTE: When turning the power switch on for the first time

The treadle and control box panel cannot be operated for approximately 4 seconds after the power switch has been turned on.

After approximately 4 seconds, "Ar (All reset)" may appear in the stitch number display (5).

If this happens, turn the power switch off and then back on again. After that, normal treadle operation will then be possible.



2. Test operation

1. Check that the machine sews at low speed when the treadle (1) is gently pressed to position (B).
2. Then check that it sews at high speed when the treadle (1) is gently pressed to position (C).
3. After pressing the treadle (1) forward, check that the needle is lowered to the top of the needle plate when the treadle (1) is returned to the neutral position (A). (when needle down stopping has been set.)
4. If the treadle (1) is pressed to position (D), thread trimming is carried out and the needle then rises above the needle plate and stops.

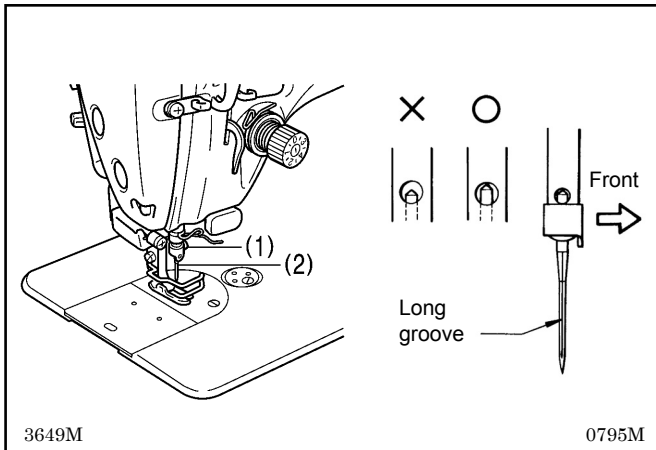
4. PREPARATION BEFORE SEWING

4-1. Installing the needle

! CAUTION



Turn off the power switch before installing the needle.
The machine may operate if the treadle is depressed by mistake, which could result in injury.



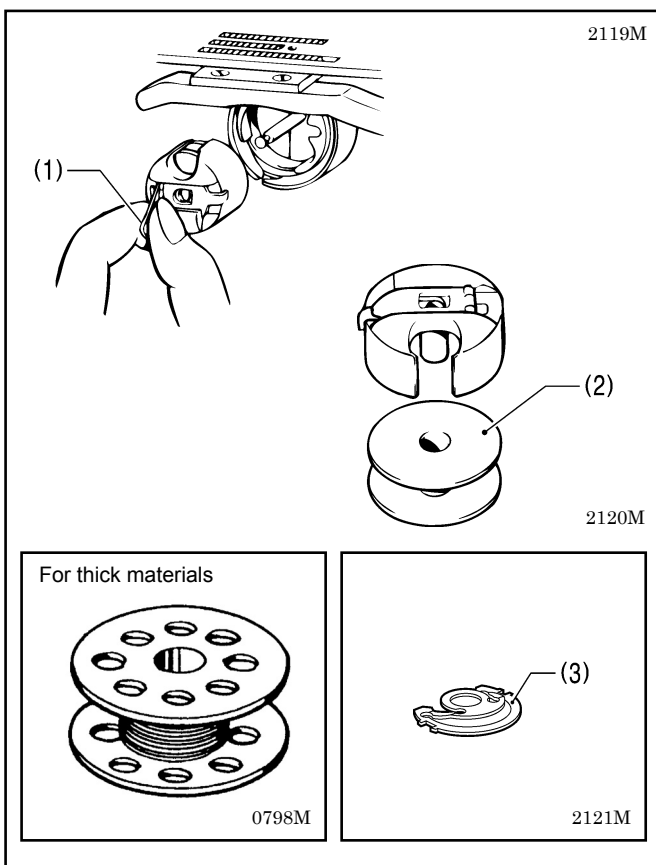
1. Turn the machine pulley to move the needle bar to its highest position.
2. Loosen the screw (1).
3. Insert the needle (2) in a straight line as far as it will go, making sure that the long groove on the needle is at the left, and then securely tighten the screw (1).

4-2. Removing the bobbin case

! CAUTION



Turn off the power switch before removing the bobbin case.
The machine may operate if the treadle is depressed by mistake, which could result in injury.



1. Turn the machine pulley to raise the needle until it is above the needle plate.
2. Pull the latch (1) of the bobbin case upward and then remove the bobbin case.
3. The bobbin (2) will come out when the latch (1) is released.

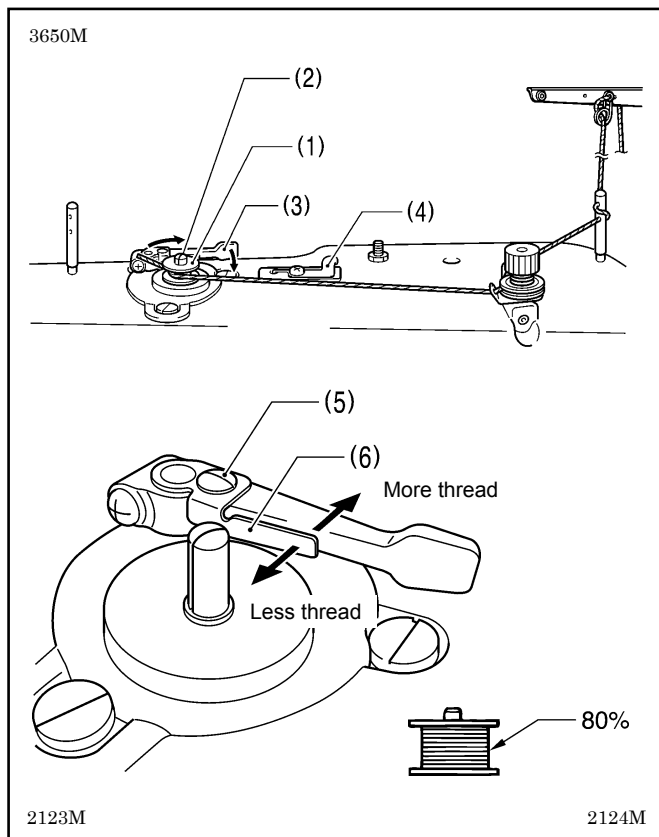
- * There is an anti-spin spring (3) inside the bobbin case. The anti-spin spring (3) prevents the bobbin from racing at times such as during thread trimming.
- * Use bobbins (2) made of light alloy as specified by BROTHER.

4-3. Winding the lower thread

! CAUTION



Do not touch any of the moving parts or press any objects against the machine while winding the lower thread, as this may result in personal injury or damage to the machine.



1. Turn on the power switch.
2. Place the bobbin (1) onto the bobbin winder shaft (2).
3. Wind the thread several times around the bobbin (1) in the direction indicated by the arrow.
4. Push the bobbin presser arm (3) toward the bobbin (1).
5. Raise the presser foot with the lifting lever.
6. Depress the treadle. Lower thread winding will then start.
7. Once winding of the lower thread is completed, the bobbin presser arm (3) will return automatically.
8. After the thread has been wound on, remove the bobbin and cut the thread with the knife (4).

- * Loosen the screw (5) and move the bobbin presser (6) to adjust the amount of thread wound onto the bobbin.

NOTE:

The amount of thread wound onto the bobbin should be a maximum of 80 % of the bobbin capacity.

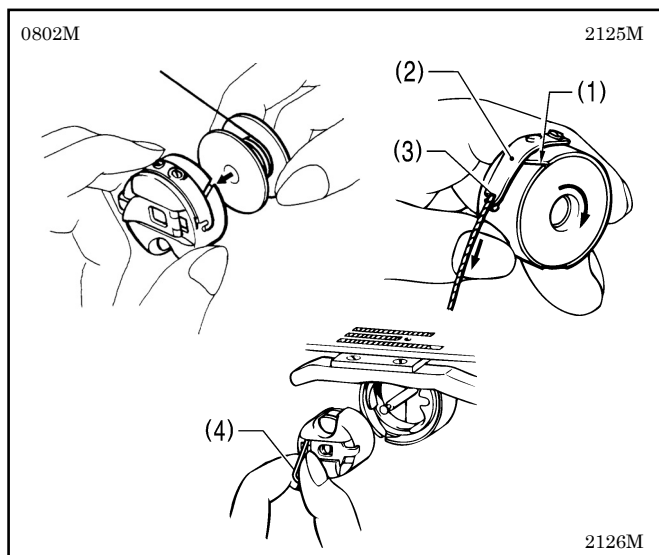
4-4. Installing the bobbin case

! CAUTION



Turn off the power switch before installing the bobbin case.

The machine may operate if the treadle is depressed by mistake, which could result in injury.



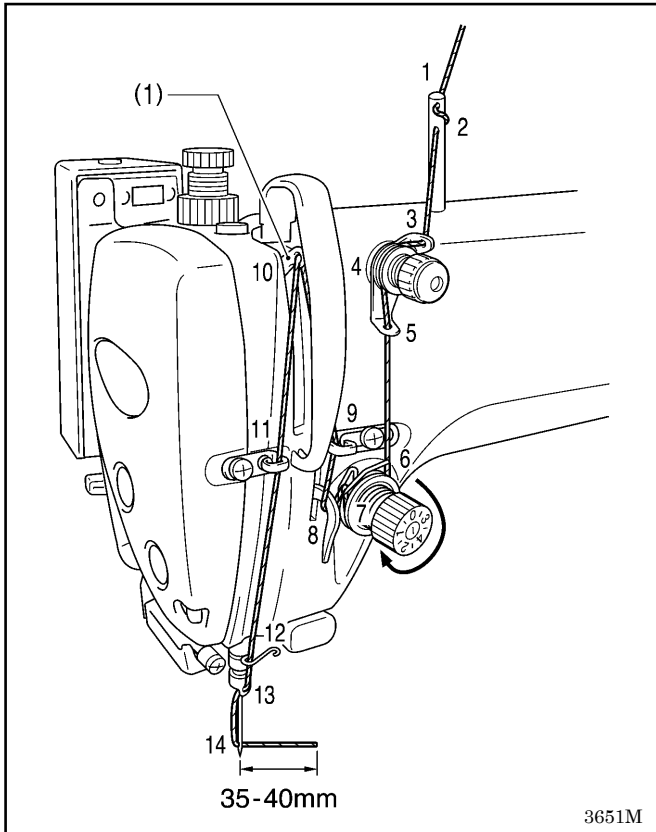
1. Turn the machine pulley to raise the needle until it is above the needle plate.
2. While holding the bobbin so that the thread winds to the right, insert the bobbin into the bobbin case.
3. Pass the thread through the slot (1) and under the tension spring (2), and then pull it out from the thread guide (3).
4. Check that the bobbin turns clockwise when the thread is pulled.
5. Hold the latch (4) on the bobbin case and insert the bobbin case into the rotary hook.

4-5. Threading the upper thread

! CAUTION

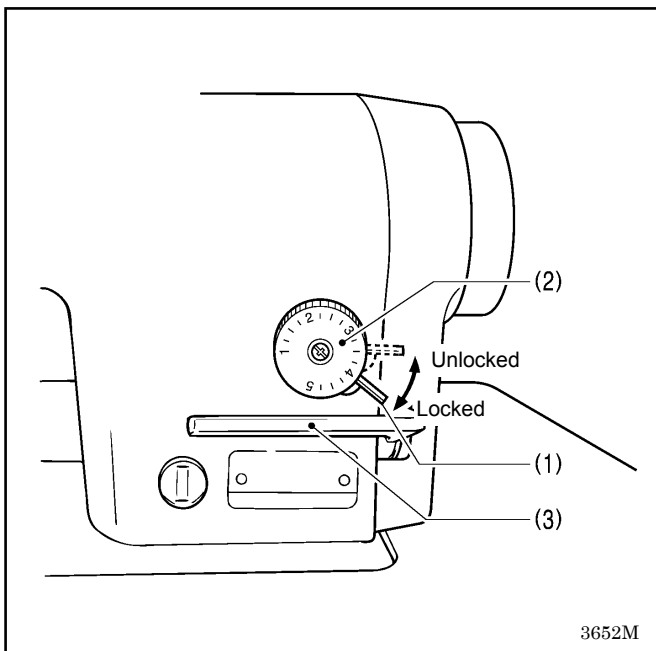


Turn off the power switch before threading the upper thread.
The machine may operate if the treadle is depressed by mistake, which could result in injury.



Turn the machine pulley and raise the thread take-up (1) before threading the upper thread. This will make threading easier and it will prevent the thread from coming out at the sewing start.

4-6. Adjusting the stitch length

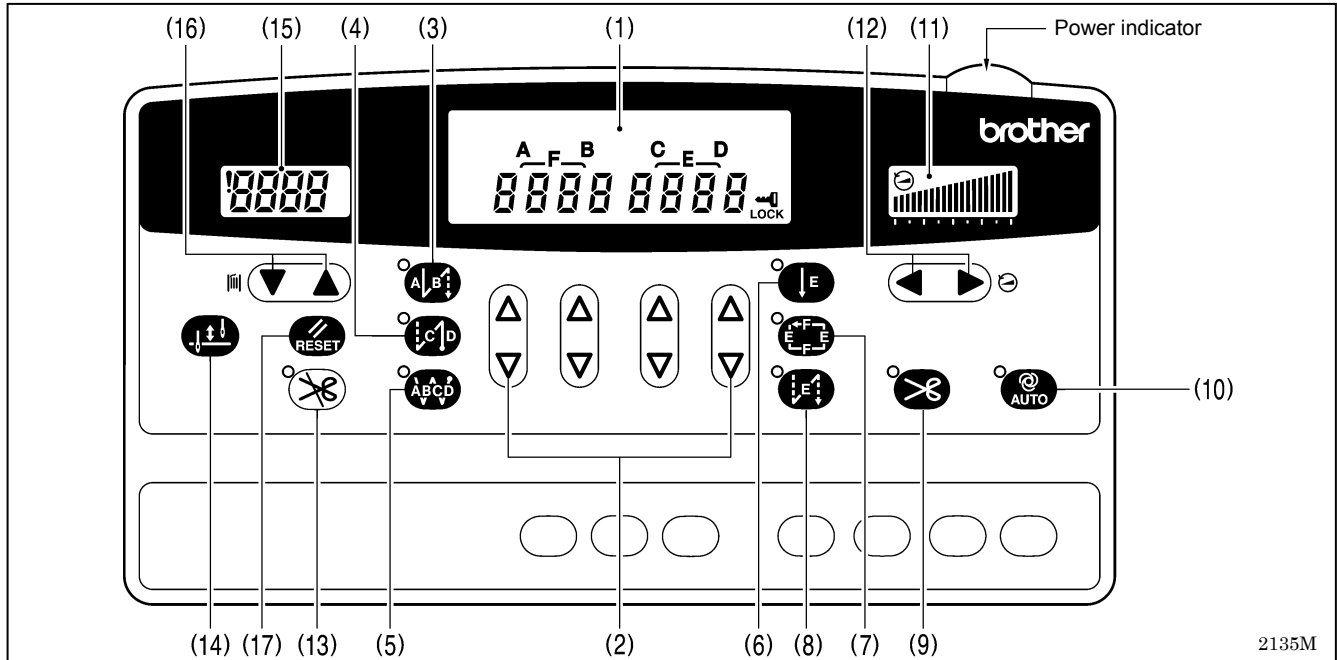


1. Push the dial lock lever (1) up until it clicks to release the lock.
 2. Turn the stitch length dial (2) clockwise or counter-clockwise so that the desired stitch length is at the uppermost position on the dial.
 - The larger the number, the longer the stitch length will be.
(The numbers on the dial are for use as a guide. The length of the finished stitches may vary depending on the type and thickness of material being sewn. Adjust while looking at the finished stitches.)
 - When turning the stitch length dial (2) from a larger setting to a smaller setting, it will be easier to turn the dial if the reverse lever (3) is pushed to the halfway-down position.
 3. Push the dial lock lever (1) down firmly to lock it.
- * Check that the stitch length dial (2) does not rotate.

5. USING THE OPERATION PANEL (BASIC OPERATIONS)

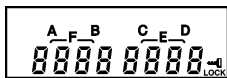
5-1. Names and functions

- The operation panel keys cannot be operated while sewing is in progress. Select the keys and set the number of stitches before starting sewing.
- In the case of keys with indicators, the indicator illuminates when that function is operating, and the indicator switches off when the key is pressed once more.



The power indicator illuminates when the power switch is turned on.

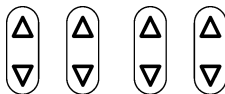
(1) Main display



- In start backtick display, AB illuminates and the number of stitches for A and B are displayed.
- In end backtick display, CD illuminates and the number of stitches for C and D are displayed.
- In continuous backtick display, ABCD illuminates and the number of stitches for A, B, C and D are displayed.
- In fixed stitch display, E or F illuminates and the number of stitches for E or F are displayed.

2136M

(2) Setting keys



These keys are used to set the number of backtick stitches for A, B, C and D and the number of fixed stitches for E and F.

- When the Δ key is pressed, the setting increases from 0 up to 99.
- When the ∇ key is pressed, the setting decreases from 99 down to 0.

2137M 2138M 2139M

(3) Start backtick key



When this key is pressed so that the indicator illuminates, the number of start backtick stitches (0–99) in the A and B stitch number displays is sewn.

2140M

(4) End backtick key



When this key is pressed so that the indicator illuminates, the number of end backtick stitches (0–99) in the C and D stitch number displays is sewn. When the treadle is depressed backward, the end backtick stitches are sewn and then the thread is trimmed automatically.

If the treadle has not yet been depressed backward, the end backtick function can be set to ON, the number of stitches can be changed and the function can be set back to OFF.

2141M

(5) Continuous backtick key



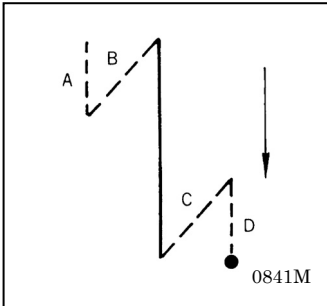
When this key is pressed so that the indicator illuminates, the number of backtick stitches (0–99) in the A, B, C and D stitch number displays is sewn continuously. After the sewing machine sews a full cycle of stitches set by A, B, C and D, the thread is trimmed automatically.

2142M

5. USING THE OPERATION PANEL (BASIC OPERATIONS)

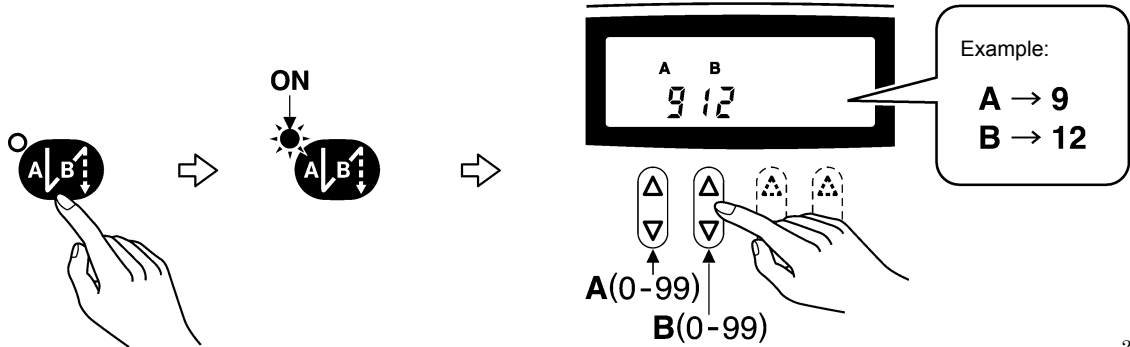
(6)	Fixed stitch key	When this key is pressed so that the indicator illuminates, the number of stitches (1-1999) in the E stitch number display is sewn, and then the sewing machine stops automatically.	2143M
(7)	Name label key	When this key is pressed so that the indicator illuminates, fixed stitch sewing of the number of stitches (1-1999) in the E and F stitch number displays is carried out repeatedly.	2144M
(8)	Pleat presser sewing key	When this key is pressed so that the indicator illuminates, the number of backtack stitches (1-1999) in the E stitch number display can be sewn by pressing the actuator.	2145M
(9)	Thread trimming key	<ul style="list-style-type: none"> This can only be set for use together with the fixed stitch key (6) or the name label key (7). When this key is pressed so that the indicator illuminates, the set number of stitches (start or end backtack stitches or fixed stitches) are sewn, and then the thread is trimmed automatically. 	2146M
(10)	AUTO key	<ul style="list-style-type: none"> This can only be set for use together with the continuous backtack key (5), the fixed stitch key (6) or the name label key (7). When this key is pressed so that the indicator illuminates, the set number of stitches (start or end backtack stitches, fixed stitches or thread trimming) are sewn automatically simply by depressing the treadle once. 	2147M
(11)	Sewing speed control display	<p>This shows the sewing speed when the treadle is depressed to the maximum amount.</p> <ul style="list-style-type: none"> If all bars are illuminated, it indicates that the maximum speed can be set. If all bars are switched off, it indicates the minimum speed (220 rpm). 	2148M
(12)	Sewing speed control keys	<p>These keys let you adjust the sewing speed that is used when the treadle is depressed to the maximum amount.</p> <p>The sewing speed can also be adjusted while sewing is in progress.</p> <ul style="list-style-type: none"> When the ► key is pressed, the sewing speed becomes faster. When the ◀ key is pressed, the sewing speed becomes slower. 	2149M 2150M 2151M
(13)	Thread trimming lock key	<ul style="list-style-type: none"> When this key is pressed so that the indicator illuminates, the sewing machine stops in the needle up position without thread trimming being carried out even if the treadle is depressed backward. If the indicator of the AUTO key (10) is illuminated, the sewing machine stops in the needle up position without thread trimming being carried out after the set number of stitches have been sewn. 	2152M
(14)	Half stitch key	When the sewing machine is stopped, the needle bar can be moved up and down by pressing this key.	2153M
(15)	Lower thread counter display	<p>This shows the lower thread counter value.</p> <p>The counter is reduced by "1" for every ten stitches sewn.</p>	2154M
(16)	Lower thread counter keys	These keys are used to set the initial value for the lower thread counter.	2155M
(17)	RESET key	This key is used to return the lower thread counter to its initial value and to cancel warning conditions.	2156M

5-2. Sewing start and end backtick stitches



1

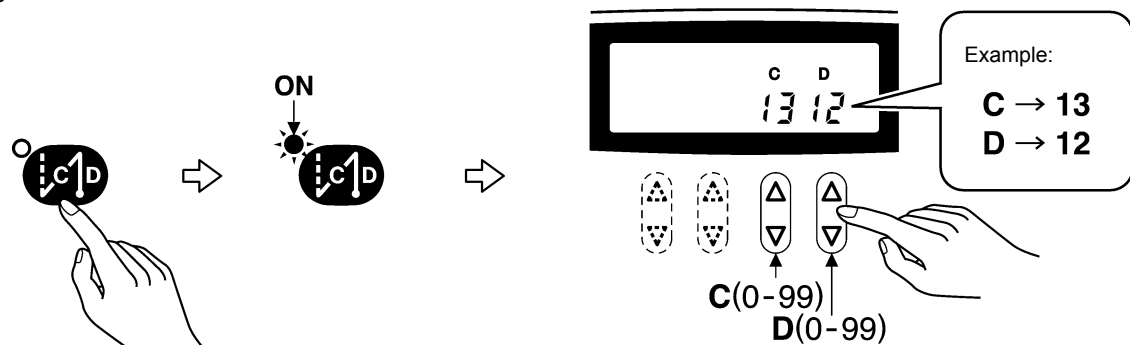
Setting start backtick stitches



2157M

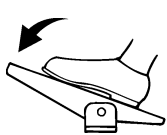
2

Setting end backtick stitches



2158M

3



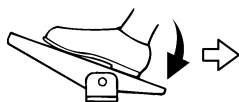
Start backtacking is carried out. After it has finished, normal sewing continues for as long as the treadle remains depressed.

NOTE:

If the treadle is returned to the neutral position, the sewing machine will continue operating until the set number of start backtick stitches has been sewn.

2159M

4



End backtacking is carried out. After it has finished, the thread is trimmed automatically and the sewing machine stops in the needle up position.

NOTE:

- If the treadle is depressed backward before sewing of the set number of start backtick stitches is complete, end backtacking will not be carried out.
- If the indicator of the thread trimming lock key is illuminated, the sewing machine will stop in the needle up position without thread trimming being carried out.

2160M

6. SEWING

! CAUTION



Attach all safety devices before using the sewing machine. If the machine is used without these devices attached, injury may result.



Turn off the power switch at the following times.

The machine may operate if the treadle is depressed by mistake, which could result in injury.

- When threading the needle
- When replacing the bobbin and needle
- When not using the machine and when leaving the machine unattended

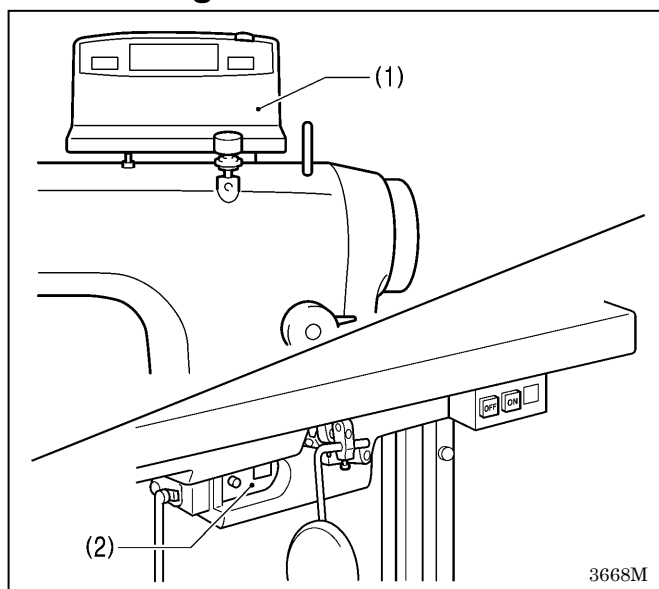


Do not touch any of the moving parts or press any objects against the machine while sewing, as this may result in personal injury or damage to the machine.



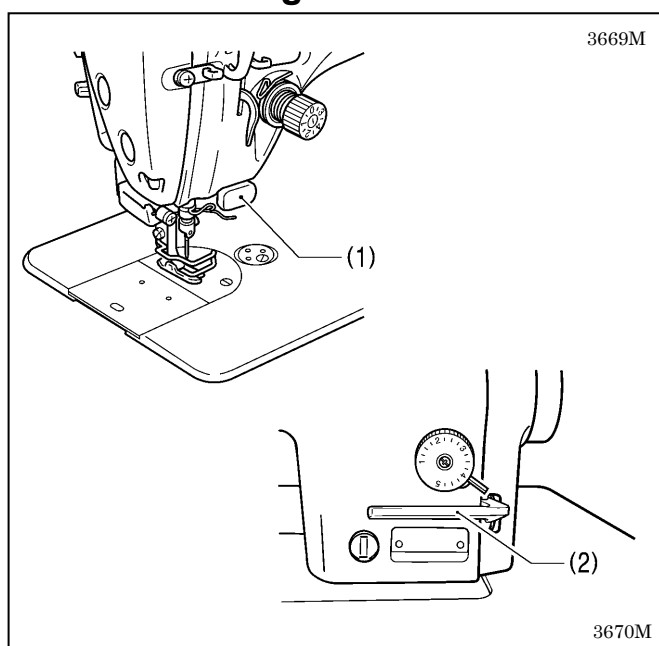
Use both hands to hold the machine head when tilting it back or returning it to its original position. If only one hand is used, the weight of the machine head may cause your hand to slip, and your hand may get caught.

6-1. Sewing



1. Carry out the programming which is necessary for sewing. (Refer to "Using the operation panel (1)" or "Using the control box panel (2)".)
2. Depress the treadle to start sewing.

6-2. Backtacking



When the actuator (1) or the reverse lever (2) is pressed during sewing, the feed direction will be reversed. When it is released, the feed direction will return to normal.

Document CD



For cleaning, standard adjustments and more details, please refer to the instruction manual contained in the Document CD.

3168M

Contents of the Document CD

The following documents are contained in PDF format.

- Basic Operation Manual
- Instruction Manual
- Parts Book

How to use the Document CD

Refer to "Using Document CD" which comes with the Document CD or the help function of the Document CD.

Recommended system configuration for using the Document CD

OS:	Microsoft® Windows® 98 Second Edition, Windows® 2000 Service Pack 4, Windows® XP Service Pack 2
Browser version:	Microsoft® Internet Explorer 6 Service Pack 1 or higher
Screen resolution:	1024 x 768 pixels or more
Plug in (required to access):	Adobe Reader 6.0 or higher

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Windows® and Microsoft® Internet Explorer are either registered trademarks of Microsoft Corporation in the United States and/ or other countries.

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