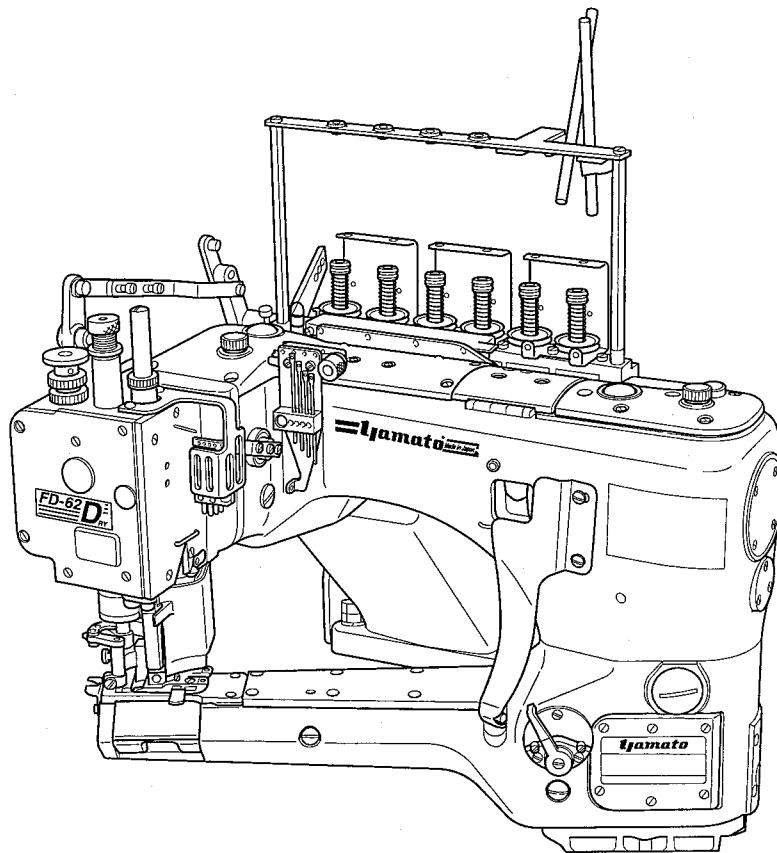


Yamato[®]

Instruction Manual

HIGH SPEED FEED-OFF-THE-ARM FLATSEAMER

FD-62DRY



Thank you for purchasing the Model FD-62DRY.

Before using your FD-62DRY, please read the instruction manual and understand the contents well.

After reading the instruction manual, please keep it in a location where it is easily accessible to the operator.














YAMATO SEWING MACHINE MFG. CO., LTD.

CONTENTS

Safety instructions


i – iv

1. Name of each part	1
2. Installation	2
2.1 Installation	2
2.1.1 Motor table top type	2
2.1.2 Motor hanging type	5
2.1.3 Compact type motor	6
2.1.4 Installing machine head	8
2.2 Installing presser foot connecting lever	9
2.3 Motor, belt and pulley	10
2.4 Hanging belt	11
2.5 Belt cover	11
2.5.1 Table top type	11
2.5.2 Hanging type	13
2.6 Other parts	14
3. Sewing speed and rotating direction of pulley	16
4. Lubrication	17
4.1 Lubricating oil	17
4.2 Lubricating	17
4.3 Priming oil	18
4.4 Changing oil	18
5. Proper operation	19
5.1 Needle system	19
 5.2 Installing needle	19
 5.3 Threading	20
 5.4 Thread tension	21
 5.5 Pressure of presser foot	21
 5.6 Up-and-down position of presser foot	22
 5.7 Adjusting differential feed dog	22
 5.8 Adjusting stitch length	23
 5.9 Adjusting lapped width of upper fabric	24
 5.10 SP device	25
 5.11 Use of lap former	26
 5.12 Setting tape (FD-62DRY-03)	27

CONTENTS

6. Adjustments	28
6.1 Needle thread tension	28
6.2 Looper thread tension	30
6.3 Top cover thread tension	31
6.4 Height of needle	32
6.5 Top cover thread carrier and hook	33
6.6 Looper	34
6.7 Needle guard(front)	35
6.8 Needle guard(rear)	35
6.9 Height of feed dog	36
6.10 Replacing presser foot	37
6.11 Replacing presser foot spring plate	40
6.12 Replacing and adjusting knives	41
6.13 Adjusting Presser lift	43
6.14 Tension release unit	45
7. Specifications	46

Attention

◇ This instruction manual is designed mainly for technicians, but it is advisable that also operators read the instructions with  mark to use the machine properly.

◇ The numbers in lower left corners of figures are figure numbers. We use them in texts as needed for your reference.

Attention

The parts used for this product are subject to change without notice. If such a change is made, any part of the contents and illustrations of this instruction manual may not conform to this product.

In preparing the instruction manual, we have made our best efforts for making it free of any error or omission. If any error or omission should yet be found, it might not be rectified immediately.



Safety instructions



1. To ensure safe use

Always observe the following instructions to ensure the safe use of the industrial sewing machines and devices.

1-1 Application and purpose

The sewing machine is designed to improve productivity in the sewing industry and must not be used for other applications and purposes. Do not use this sewing machine until it can be confirmed that safety measures for the drive units have been taken.

1-2 Before use

Read all instruction manuals thoroughly before starting the use of this machine and follow them.

Also, read the instruction manual for the installed drive unit.

1-3 Working environment

DO NOT WORK IN THE FOLLOWING ENVIRONMENTS:

- Place where atmosphere temperature and humidity give a bad influence the performance of sewing machines.
- Outdoors and place where the sewing machines are exposed to sunlight directly.
- Atmosphere containing dust, corrosive gases or flammable gases.
- Place where voltage fluctuation exceeds $\pm 10\%$ of the rated voltage.
- Place where power capacity necessary for the used motor specifications cannot be secured.
- Place where strong electric or magnetic fields are generated such as near large-output high frequency transmitters or high frequency welding machines.

1-4 Unpacking and transportation

- (1) Unpack from the top.
- (2) Never hold the parts near the needle or threading parts when removing the sewing machine head from the buffer of box.
- (3) When carrying the sewing machine head, have an assistant.
- (4) Pay attention not to get excessive impact or shock when moving the sewing machine head with a pushcart.

2. Installation and preparation

2-1 Instruction and training

Operators and workers, who supervise, repair or maintain the machine head and machine unit, are required to have the adequate knowledge and operation skills to do the job safely. In order to establish such necessary conditions, it needs for the employer to plan and enforce the safety education and training to those workers.

2-2 Sewing table and motor

- (1) Prepare a machine table that has enough strength to withstand the weight of the sewing head and any reaction while operating.
- (2) Maintain a comfortable working environment with considering the lighting and the arrangement of sewing machine so that the operators can work smoothly.
- (3) When installing the control box and the related parts on the sewing machine, take care about the posture of the worker.
- (4) Install the drive unit correctly according to the instruction manual.

2-3 Wiring

- (1) Never connect the plug for power supply until assembly is finished.
- (2) Fix the connectors securely to the sewing machine head, motor, and electric apparatus.
- (3) Do not apply excessive force to the connection cords.
- (4) Connect the cords away from the driving parts.
- (5) Place the ground wire securely to the designated position on the machine head.

2-4 Before operation

- (1) Take care not to attach lubricant, silicone oil, and grease on the eyes or skin.
Keep them away from children.



Safety instructions



- (2) Be sure to fill or drop lubrication oil before operating the sewing machine. Use the Yamato SF oil as specified.
- (3) Never put your hand under the needle or near the moving parts of the machine when turning on power supply switch.
- (4) When operating a new sewing machine, make sure the rotating direction of pulley agrees with the rotating-direction mark.

2-5 During operation

- (1) Be sure to operate the sewing machine with the safeguards such as belt cover, finger guard, and eye guard.
- (2) Never place the finger, hair or objects under the needle or close to the moving parts while operating the sewing machine.
- (3) Be sure to turn off the power supply switch when threading or replacing the needles.
- (4) Never place your hands close to the knives when operating the sewing machine with the trimming devices.
- (5) Be sure to turn off the power supply switch when terminating the sewing work or leaving the sewing machine.
- (6) If the sewing machine malfunctions, abnormal sound or smell something unusual while operating, be sure to turn off the power supply switch.

2-6 Removal

- (1) Turn off the power supply switch if removed or replaced any parts or during adjustment of sewing machine.
- (2) Do not pull the cord when removing the plug. Be sure to hold the plug itself.
- (3) A high voltage is applied inside the control box. Turn off the power supply switch and wait more than 5 minutes before opening the cover.

3. Maintenance, inspection, and repair

- (1) Follow the instruction manuals for maintenance, inspection, and repair.
- (2) Entrust the maintenance, inspection, and repair to specially trained personnel.
- (3) Be sure to turn off the power supply switch and make sure the sewing machine and motor completely stop before the maintenance, inspection, and repair. (If using a clutch motor, take care that the motor keeps turning for a while even after turning off the power supply switch.)
- (4) Be sure to remove the gasket too, when the cover removed at the maintenance, inspection, and repair. If not removed, may be injured at the edge of gasket.
- (5) Do not modify the sewing machine by the customer's judgment.
- (6) Be sure to use original replacement parts for repairs or maintenance.

4. Caution signs and alert pictorial markings

This instruction manual contains the following caution signs and alert pictorial markings to prevent you from injuring yourself or the sewing machine from being damaged.

Please follow the instructions.

4-1 Meanings of caution signs

WARNING

WARNING indicates potentially hazardous situations which, if not heeded, could result in death or serious injury to you and others.

CAUTION

Caution indicates hazardous situations which, if not heeded, may result in minor or moderate injury to you and others, or may result in machine damage.

NOTE is used to emphasize essential information.



Safety instructions



4-2 Alert pictorial markings



This mark indicates the warning which, if not heeded, could result in death or Serious injury.



This mark indicates the caution for high temperature.



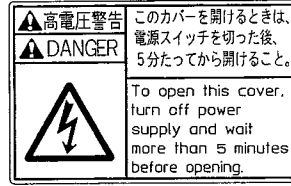
This mark indicates the warning which, if not heeded, could result in death or Serious injury.



High-voltage applies in the control box. This label indicates that electric shock may be caused.



This mark indicates the caution which, if not grounded, the machine or device could malfunction and could result in personal injury.



High-voltage applies in the control box. This label indicates that electric shock may be caused.



This label is affixed on the safeguards. Considering the operation, it is not affixed on the finger guard and eye guard. Be sure to operate with the finger guard and eye guard in position.

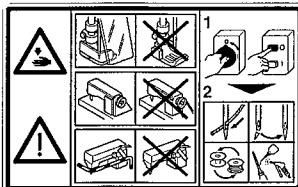


Stepping motor and solenoid may overheat if used continuously. To prevent a burn, take care not to touch.

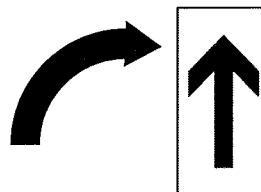


If not connected earth line, static electricity may be generated and inflict injury on person. In addition, the malfunction of electric system may cause injury to person.

5. Warning labels on sewing machines



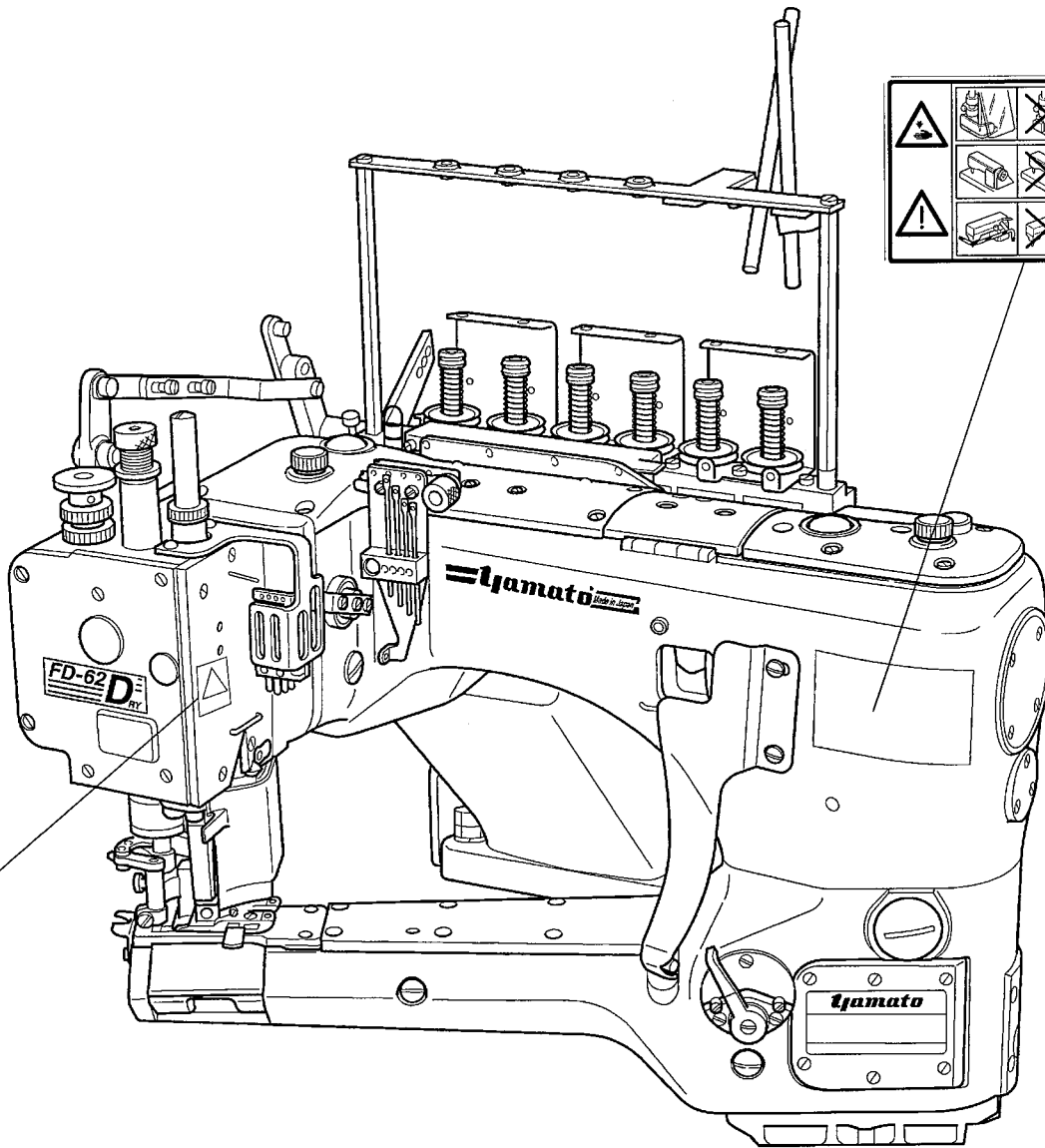
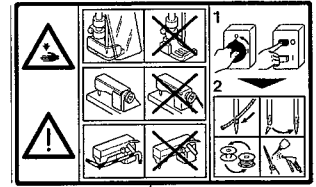
This label indicates that removal of the safeguards and works except for sewing performance while the power supply switch is on are prohibited. (For details, see the next page.)



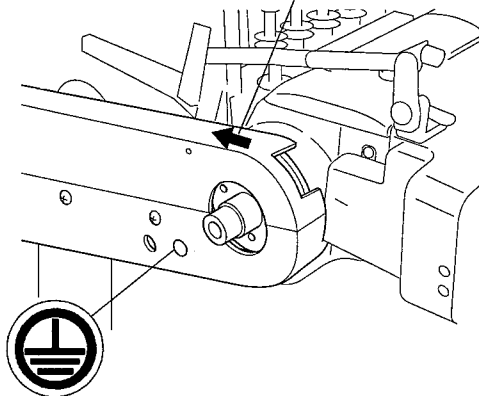
Check the rotating direction of machine pulley agrees with 'ROTATING-DIRECTION SYMBOL'.



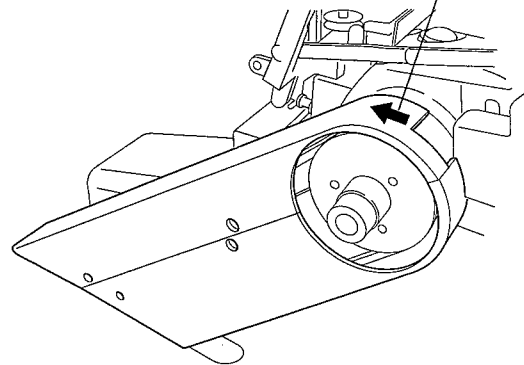
Safety instructions



Rotating direction



Rotating direction



1. Name of each part

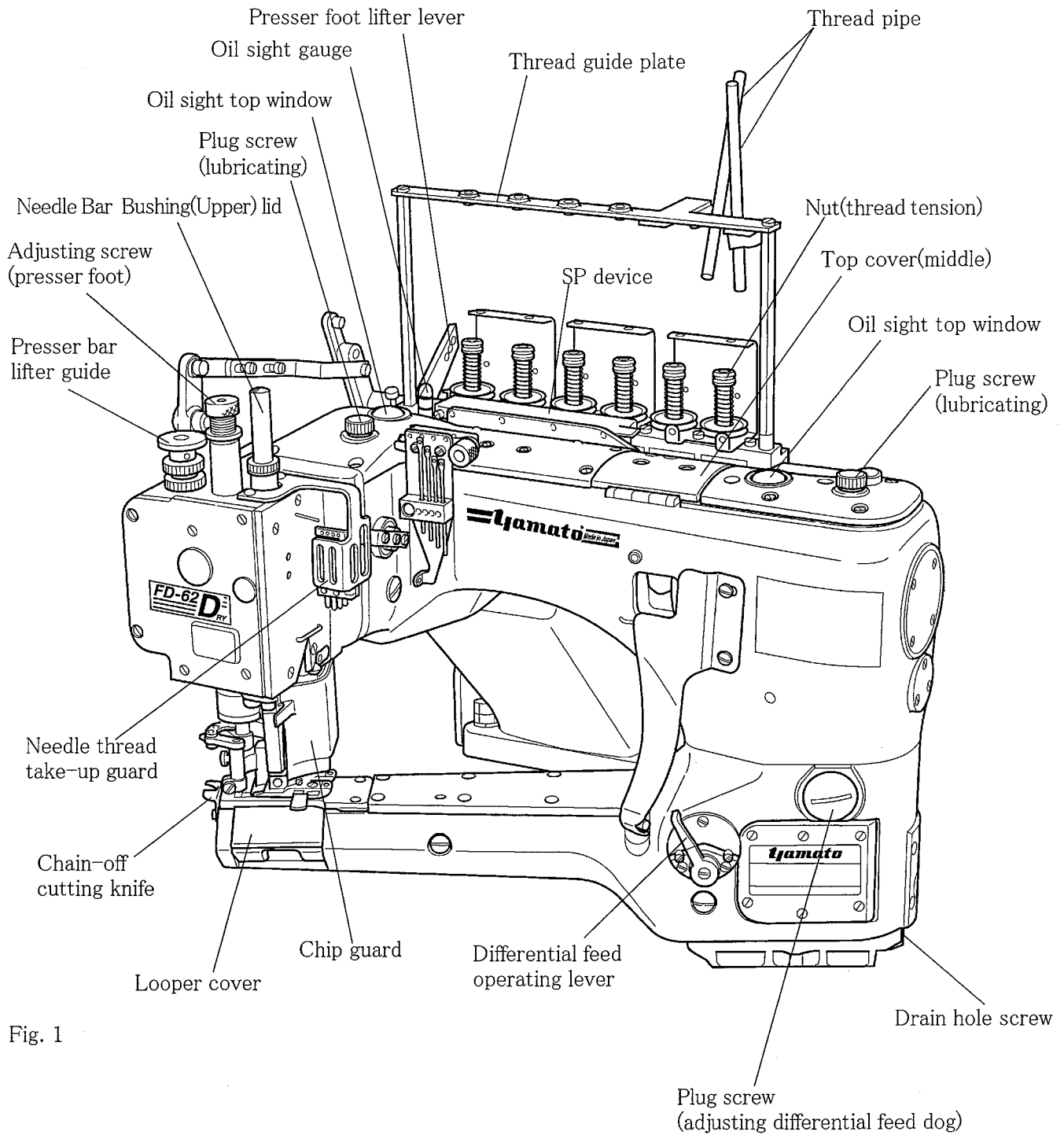


Fig. 1

2. Installation

2.1 Installation

2.1.1 Motor table top type

Table cutting diagram

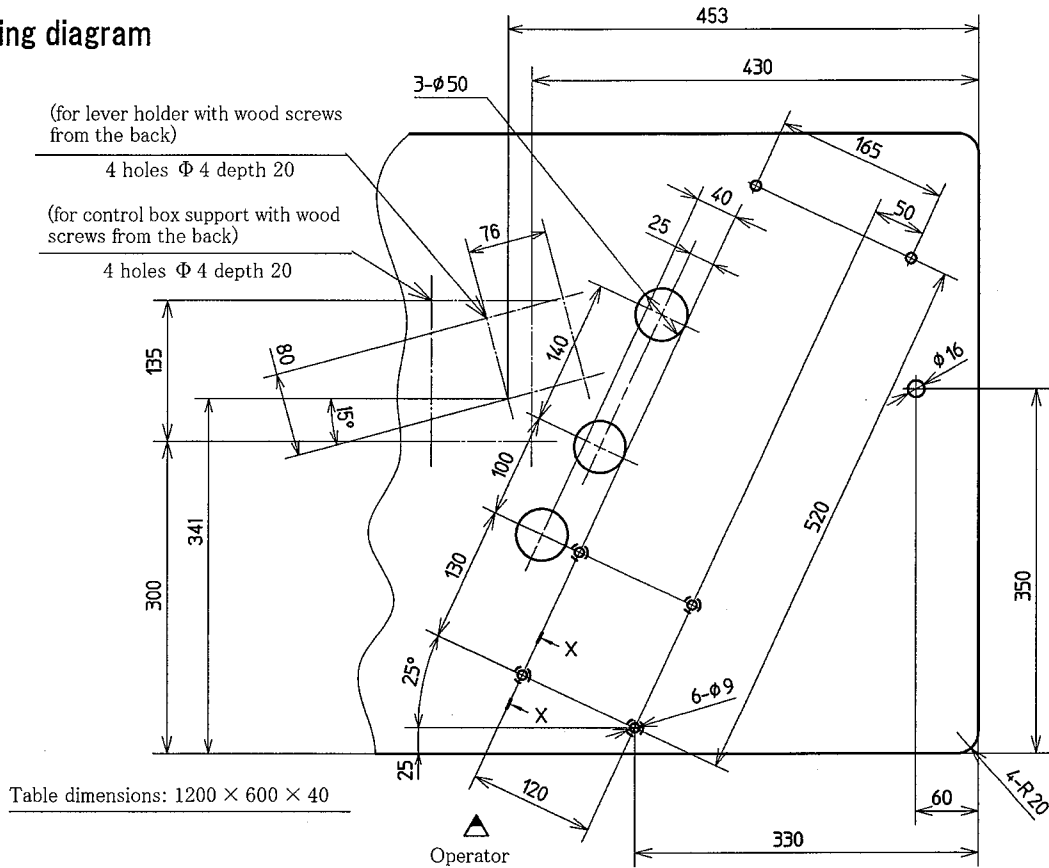
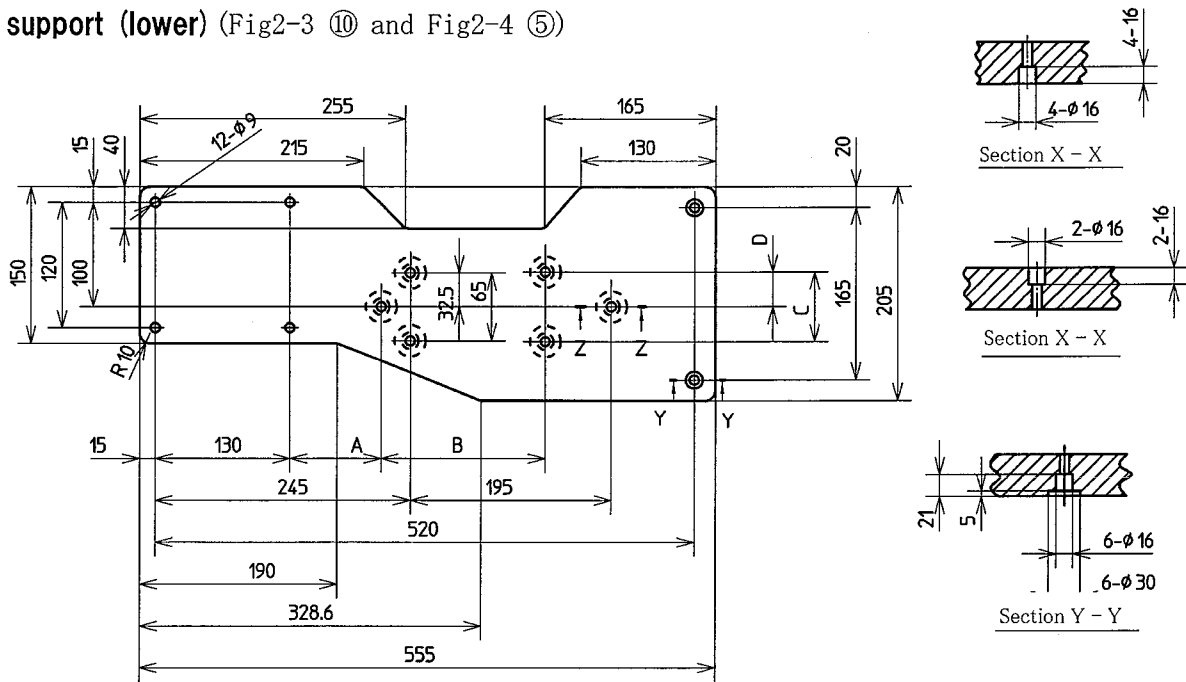


Fig. 2-1

Motor support (lower) (Fig2-3 ⑩ and Fig2-4 ⑤)



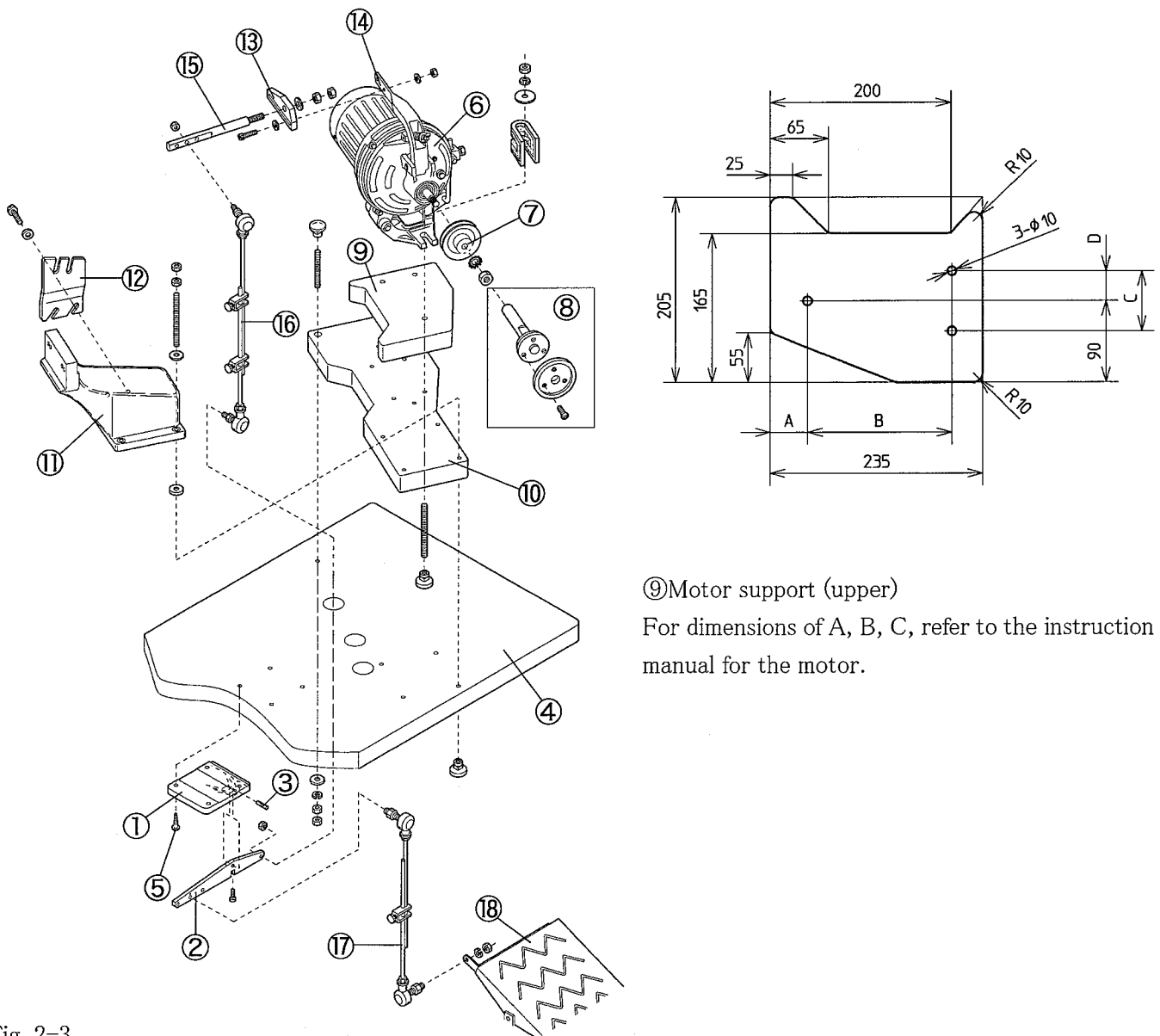
Thickness of board: 40 mm

Fig. 2-2

Installing SU-C-R(Clutch motor)

See Fig.2-3 to assemble the machine according to the following steps:

- 1.Install lever holder①, lever(lower)② and lever pin③, as shown in the fuigure.
- 2.Install assembled lever holder① on the underside of machine table④ with wood screws ⑤.
- 3.Install the pulley⑦ and handwheel⑧ onto the motor⑥.
- 4.Install the motor⑥ onto the motor support⑨⑩.
- 5.Put the motor⑥ and motor support ⑨⑩ on the machine table④, install them and sewing machine supporting block⑪ onto the machine table④.
- 6.Install the belt cover bracket⑫ onto the sewing machine supporting block⑪.
- 7.Install the lever plate⑬ onto the motor lever⑭.
- 8.Install the lever (upper)⑮ into the lever plate⑬.
- 9.Connect the lever (upper)⑮ and the lever (lower)② with the pitman (long)⑯. Then, adjust the length of pitman (long)⑯.
- 10.Connect the lever (lower)② and the presser foot pedal⑱ with the pitman(long)⑰. Then, adjust the length of pitman(long)⑰.



⑨Motor support (upper)

For dimensions of A, B, C, refer to the instruction manual for the motor.

Fig. 2-3

2.Installation

Installing SU-S(Servomotor)

See Fig.2-4 to assemble the machine according to the following steps:

1. Install the pulley① and handwheel② onto the motor③.
2. Install the motor③ onto the motor support④⑤.
3. Put the motor③ and motor support④⑤ on the machine table⑥, install them and sewing machine supporting block⑦ onto the machine table⑥.
4. Install the belt cover bracket⑧ onto the sewing machine supporting block⑦.
5. Install the control box support⑨ on the underside of the machine table⑥. Then, install the control box⑩ on the control box support⑨.
6. Install the synchroniser⑬ on the pulley of sewing machine.
7. Connect the motor③ and the control box⑩ with the extension cords⑪⑫.

Connect the cord of synchroniser⑬ onto the control box⑩.

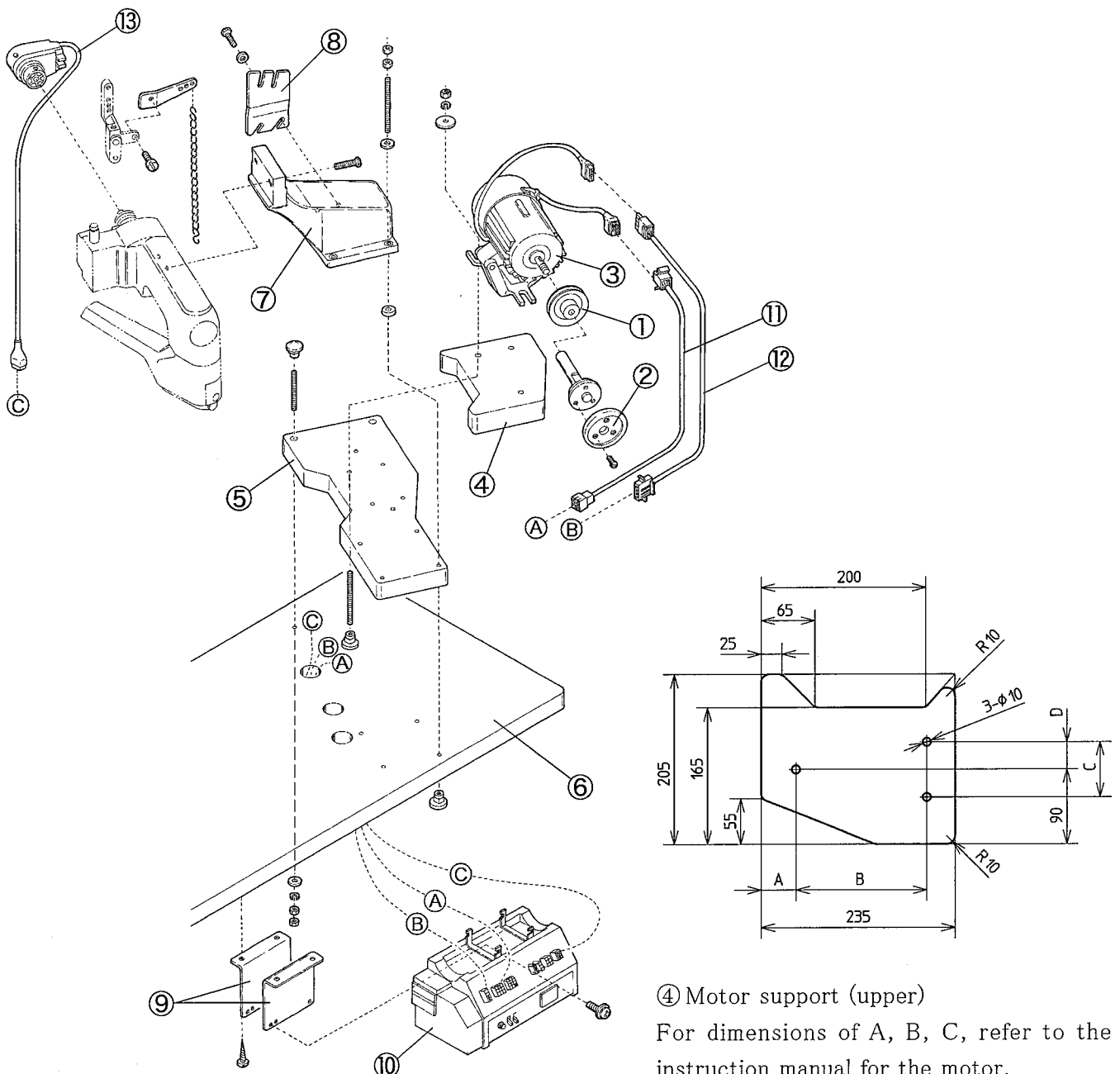


Fig. 2-4

2.1.2 Motor hanging type

Table cutting diagram

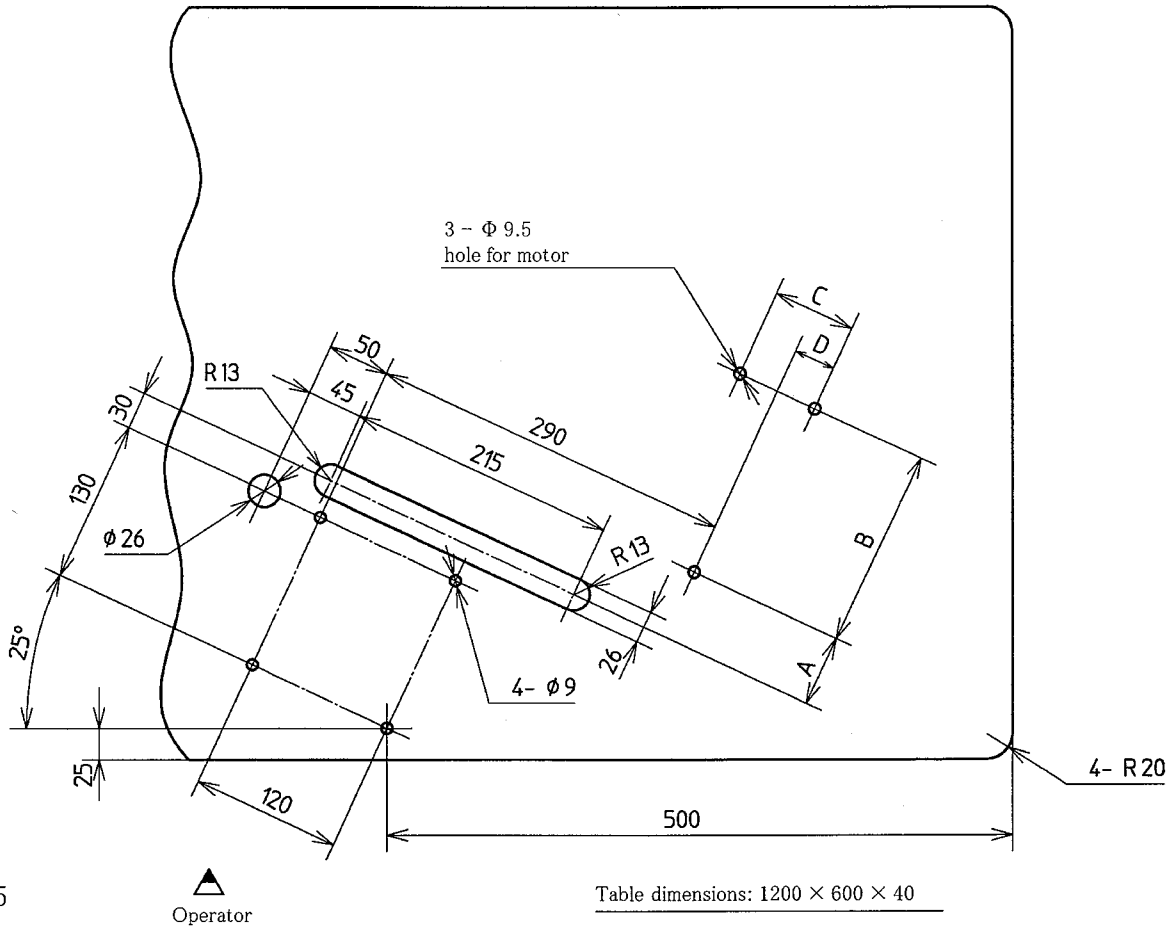


Fig. 2-5

Installing

Set the sewing machine supporting block①, referring to Fig. 2-6.

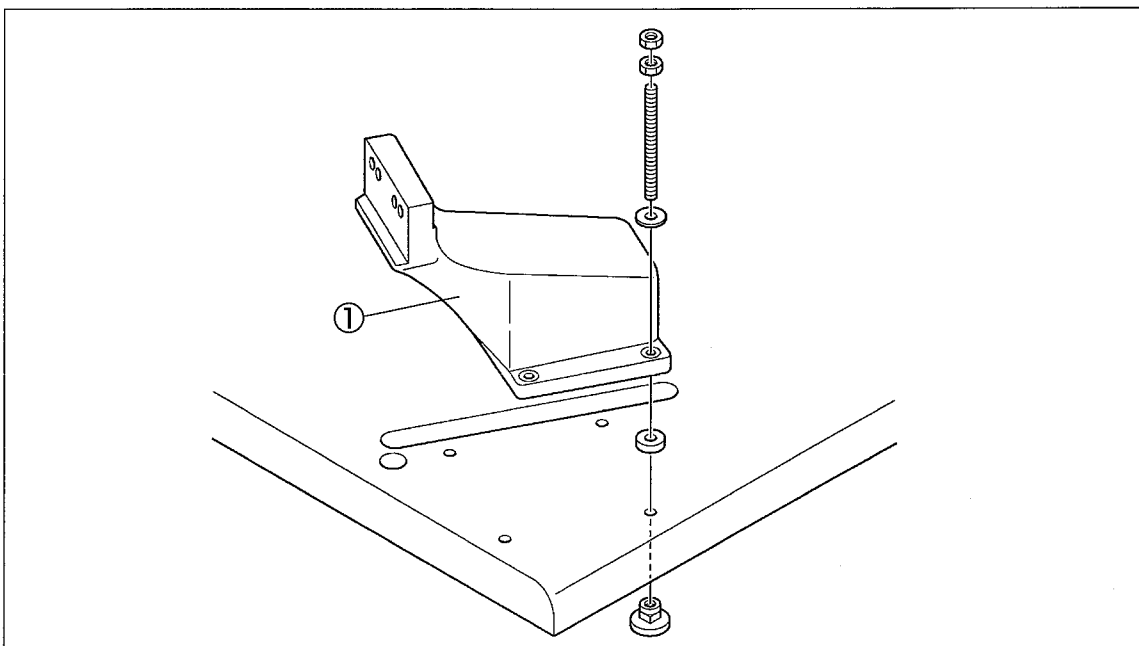


Fig. 2-6

2.1.3 Compact type motor

Table cutting diagram

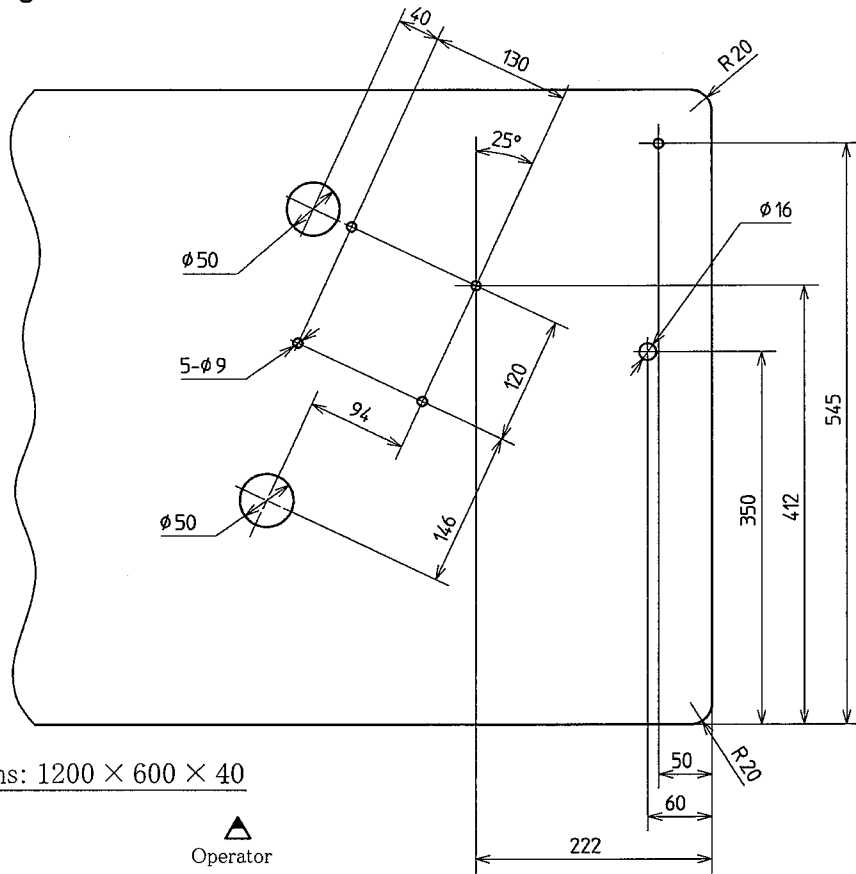


Fig. 2-7

Motor support(upper)

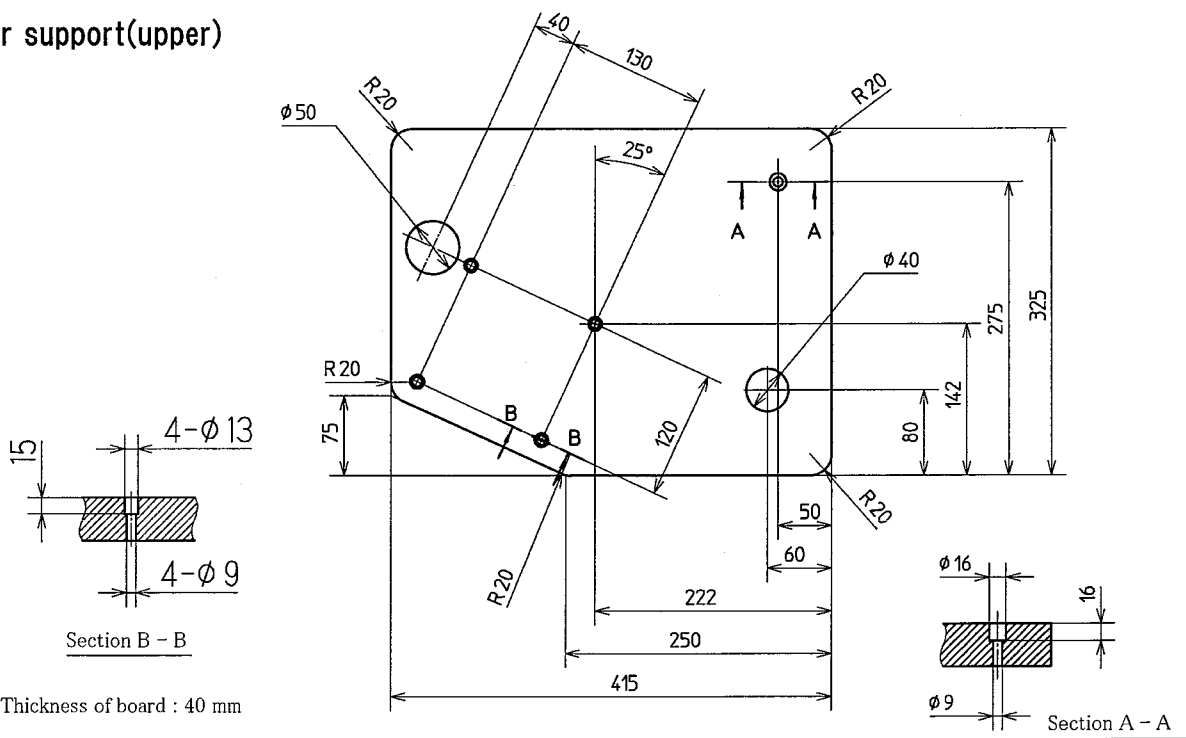


Fig. 2-8

Installing

Set the motor correctly, referring to Fig. 2-9.

Refer to 「SD-Y、FDL-6」 Insutraction about Installing of detail.

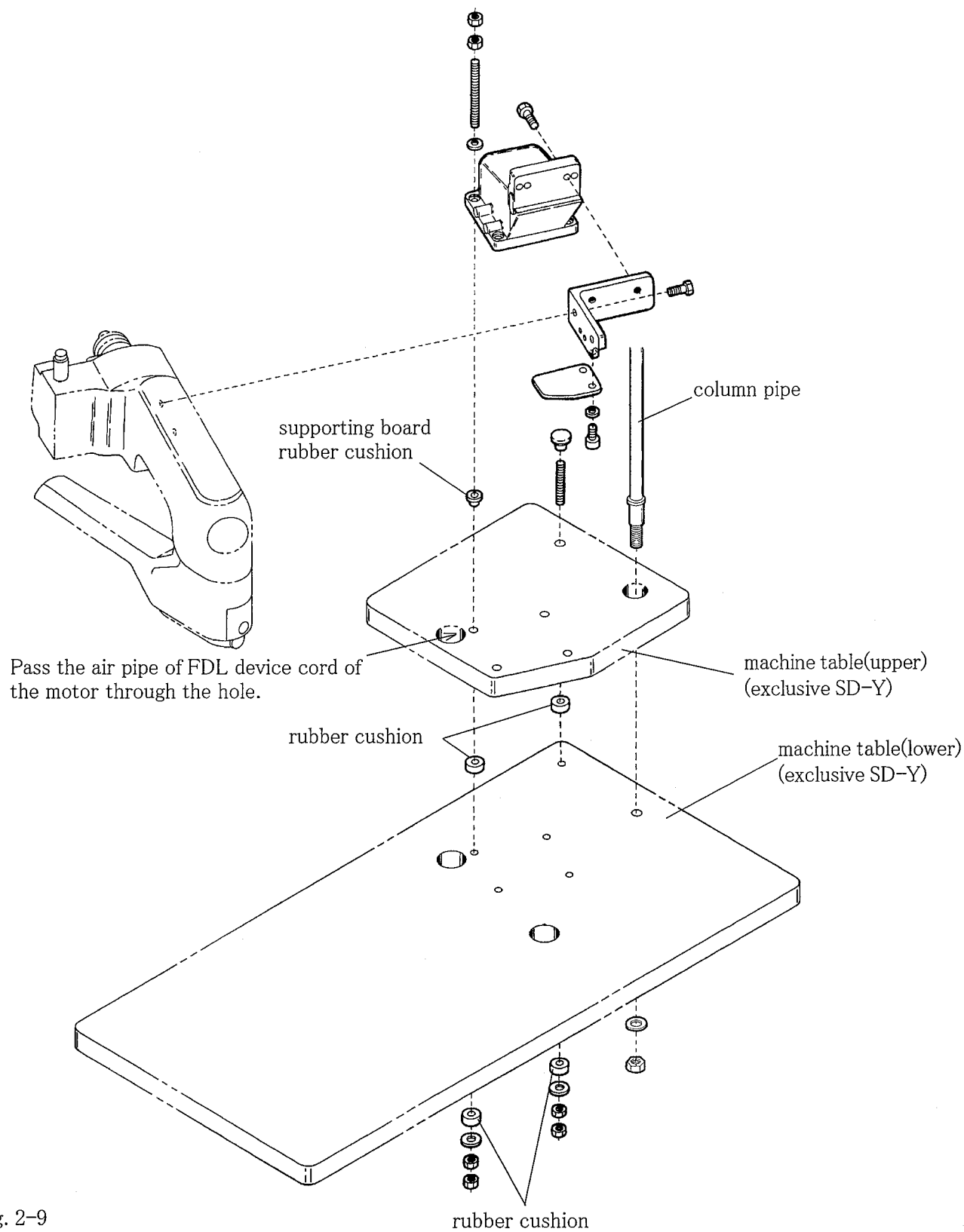


Fig. 2-9

2.1.4 Installing machine head

Install a sewing machine on the sewing machine supporting block with two screws.(Fig.2-10)

WARNING

If the machine is fell down, it can occur injury and machine damage.

Always install the machine with two persons.

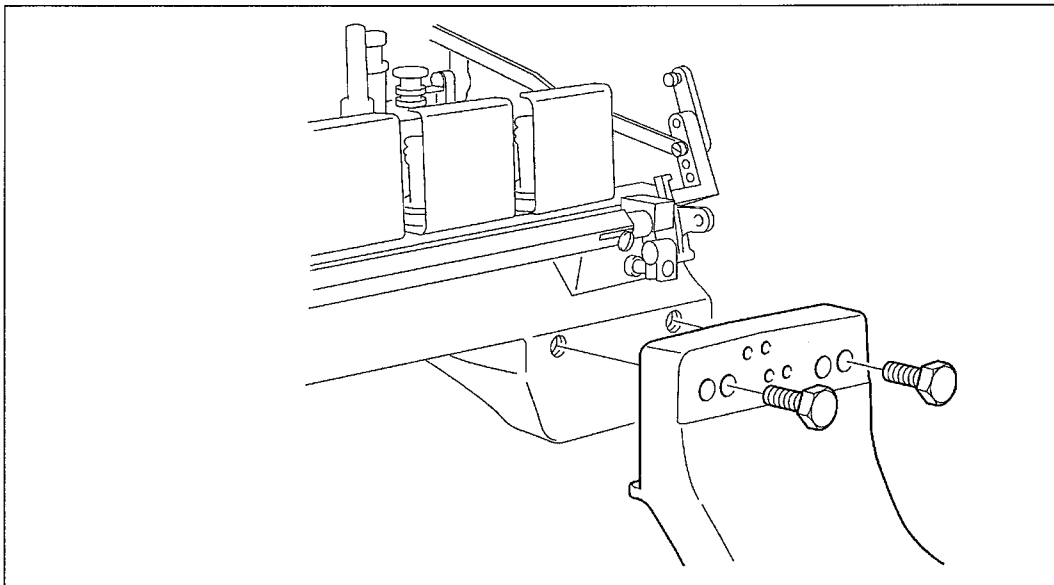


Fig. 2-10

When using the pedestal, install a sewing machine on the pedestal with two screws.(Fig. 2-11)

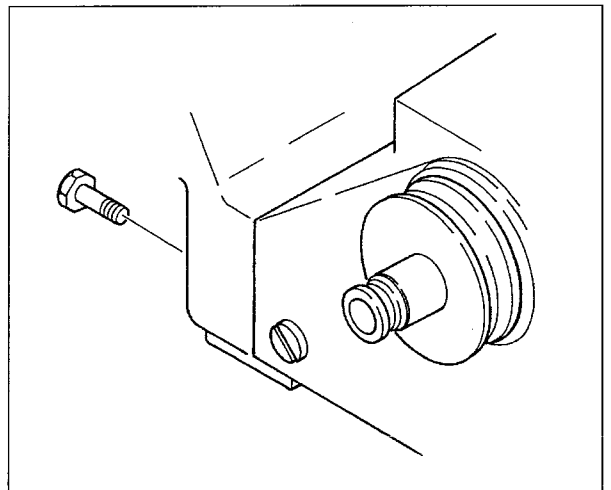


Fig. 2-11

⚠ WARNING

Before operation, unplug the motor's power cord from the outlet.

2.2 Installing presser foot connecting lever

Set the presser foot connecting lever① with the screw②. (Fig.2-12)

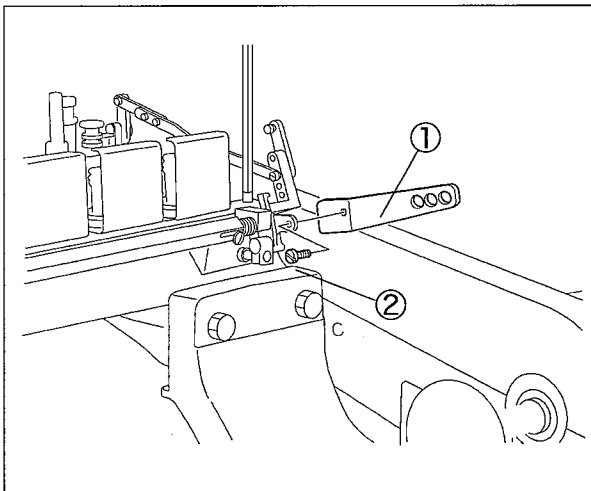


Fig. 2-12

When using the pedestal, link the presser foot lifting connector③ with the screw④.(Fig.2-13)

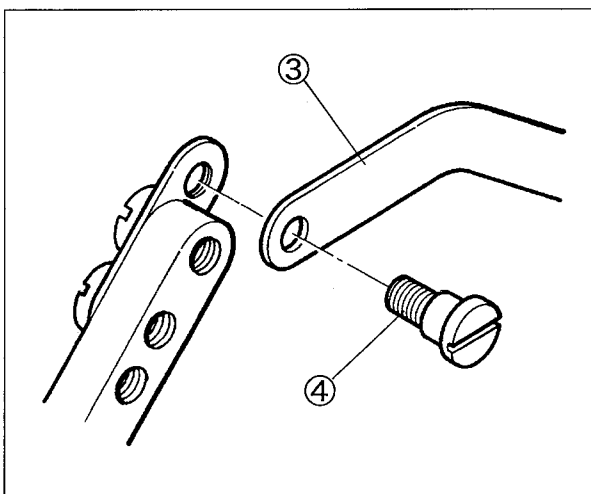


Fig. 2-13

2.3 Motor, belt and pulley

See the instruction manual for the motor to be used and install the motor properly.

To install the clutch motor, align the center of the machine pulley with that of the motor pulley when the motor pulley shifts to the left with toeing down the pedal.

NOTE: Table 1 shows the outside diameter of the motor pulley, rpm of the machine, and size of the belt when using the clutch motor of 3-phase, 2-pole, 400 W (1/2 HP).

The outside diameter on the table shows the nearest size to the calculated values based on the commercial pulleys at intervals of 5 mm.

⚠ CAUTION

Use only those motor pulleys applicable to the machine. If not, the sewing speed will be over maximum and it can cause the machine damage.

Servomotor

Calculate the outside diameter of a motor pulley from the following formula.

Or see Table 2 to select a proper motor pulley.

$$\text{Outside diameter of motor pulley} = \frac{\text{Usual sewing speed}}{\text{Servomotor speed}} \times 57 + 5 \text{ mm}$$

Belt

Use a V-belt of M type.

For belt size, refer to Table 1.

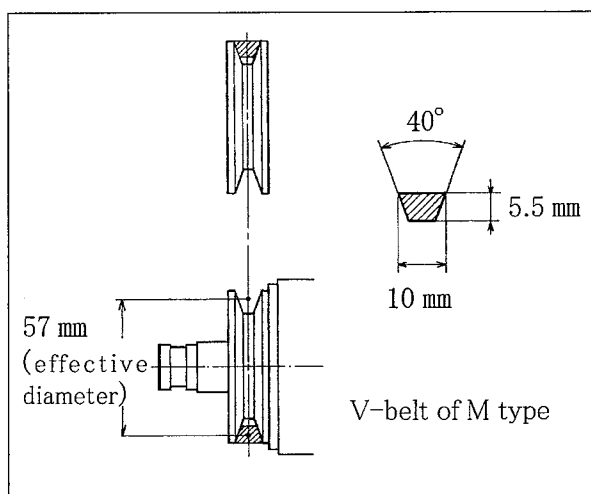


Fig.2-14

Outside diameter of pulley (mm)	rpm of machine		Size of belt	
	50Hz	60Hz	Table top type	Hanging type
45		2600	M31	M57
50		2900	M31	M57
55	2700	3200	M31	M57
60	2900	3500	M32	M57
65	3150	3800	M32	M58
70	3400	4100	M32	M58
75	3650		M33	M58
80	3900		M33	M59
85	7500		M33	M59

Table 1

rpm of machine (rpm)	Outside diameter of motor pulley (mm)	
	rpm of servomotor	
	3000rpm	3600rpm
2700	57	48
3000	62	53
3200	66	56
3500	72	61
3700	76	64
4000	81	69
4200	85	72

Table 2

2.4 Hanging belt

WARNING

Before hanging belt, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

Use the V-belt of M type.

- (1) Hang the belt ① on the machine pulley ②, and then on the motor pulley while rotating the machine pulley.
- (2) Adjust the belt tension so that the belt has 10 – 20 mm slack when its center is pushed with about 10 N.
- (3) Fix the motor with the adjusting bar.

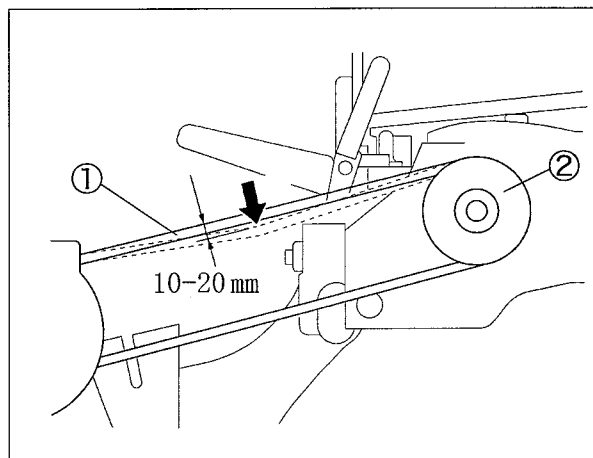


Fig.2-15

2.5 Belt cover

WARNING

Be sure to install belt cover to prevent you from injuring and a material from being caught by the belt.

To transfer the sewing machine from the FD-62G to the FD-62 DRY, also see “Compatibility of belt covers” on page 12.

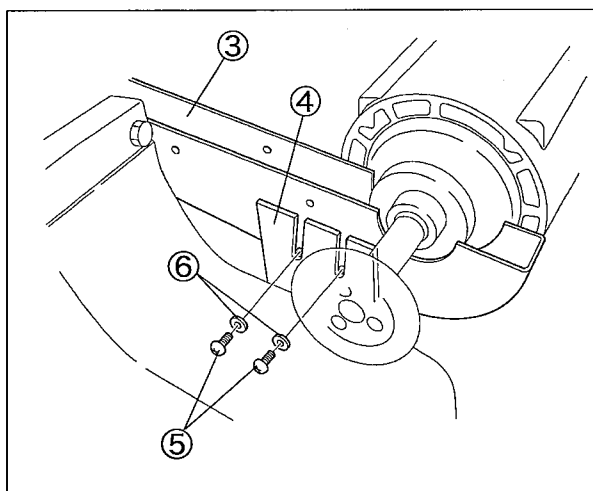


Fig. 2-16

2.5.1 Table top type

- (1) Set the belt cover(lower) ③ on the belt cover bracket ④ with two screws ⑤ and two washers ⑥.
- (2) Fix the belt cover(lower) ③ on the sewing machine supporting block with the screw ⑦ and the washer ⑧.
- (3) Set the belt cover(upper) ⑨ on the belt cover(lower) ③ with four screws ⑩ and four washers ⑪.

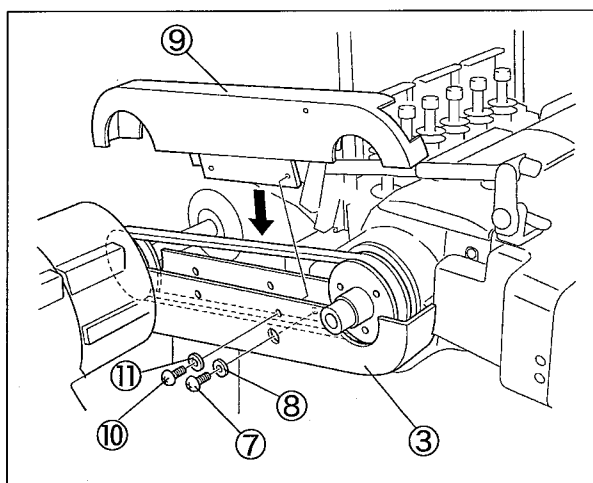


Fig. 2-17

2.Installation

Compatibility of belt covers(FD-62G→FD-62DRY)

The belt covers for the FD-62G can be used by reworking them as illustrated.

If you do not rework them, place an order for the belt covers (part numbers in the fig.2-18,2-19) for the FD-62DRY

SU-S、 SU-C-R、 SU-C

Belt cover(upper) Parts No.3021252

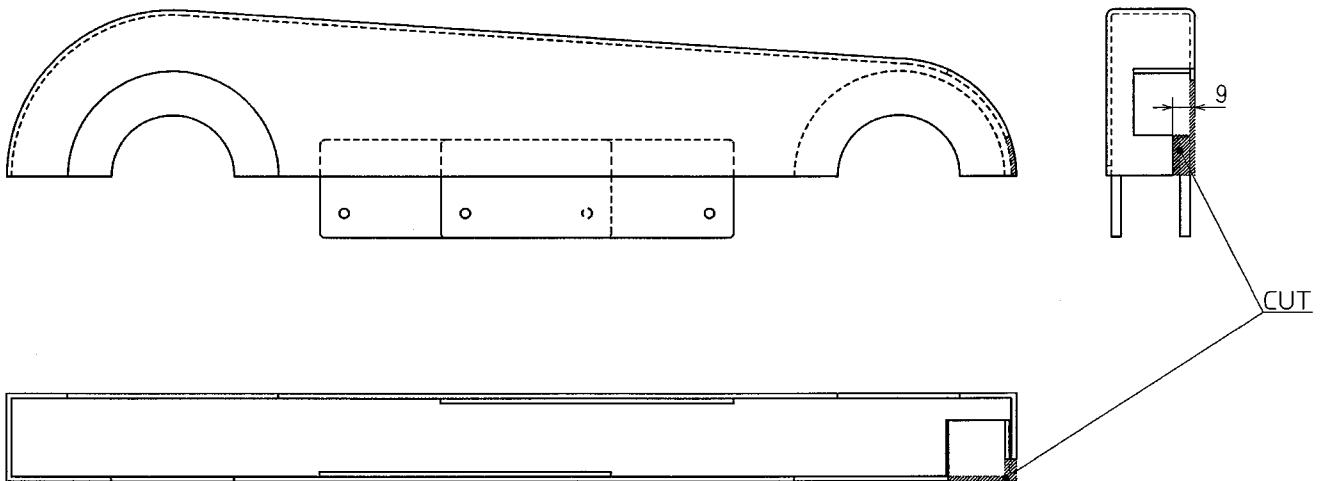


Fig. 2-18

Belt cover(lower) Parts No.3021254

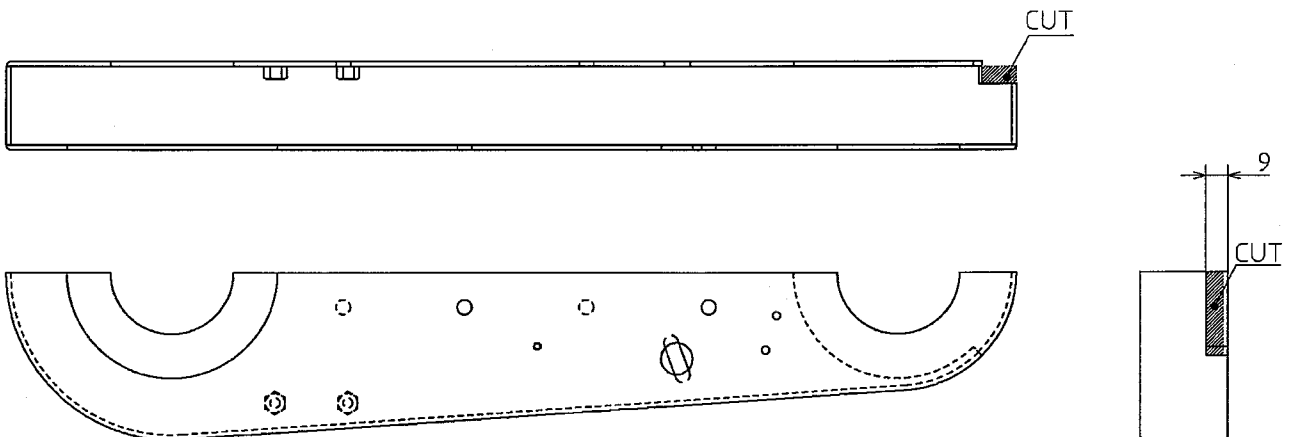


Fig. 2-19

2.5.2 Hanging type

- (1) Insert the screw ① and the washer ② slightly.
- (2) Set the belt cover(lower)④ on the sewing machine supporting block③ with the screw⑤ and the washer⑥. Fix the top of the belt cover(lower)④ with the screw① and the washer ②.
- (3) Insert the screws⑦ and ⑧ slightly.
- (4) Fix the belt cover(upper)⑨ on the belt cover(lower)④ with the screws ⑦ and ⑧.

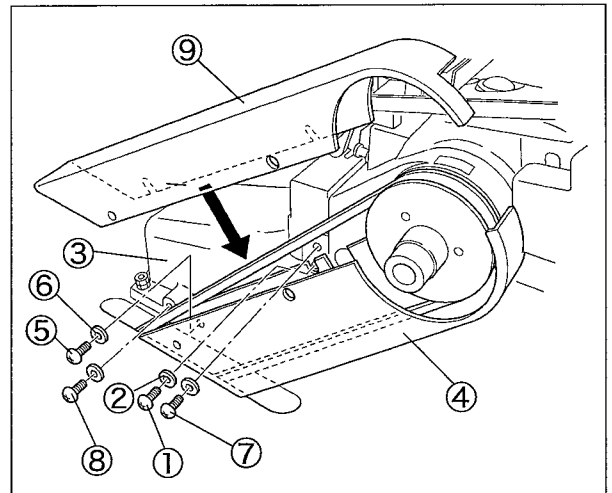


Fig. 2-20

Compatibility of belt covers(FD-62G→FD-62DRY)

The belt covers for the FD-62G can be used by reworking them as illustrated.

If you do not rework them, place an order for the belt covers (part numbers in the fig.2-21) for the FD-62DRY

SL-C

Belt cover(lower) Parts No.3021255

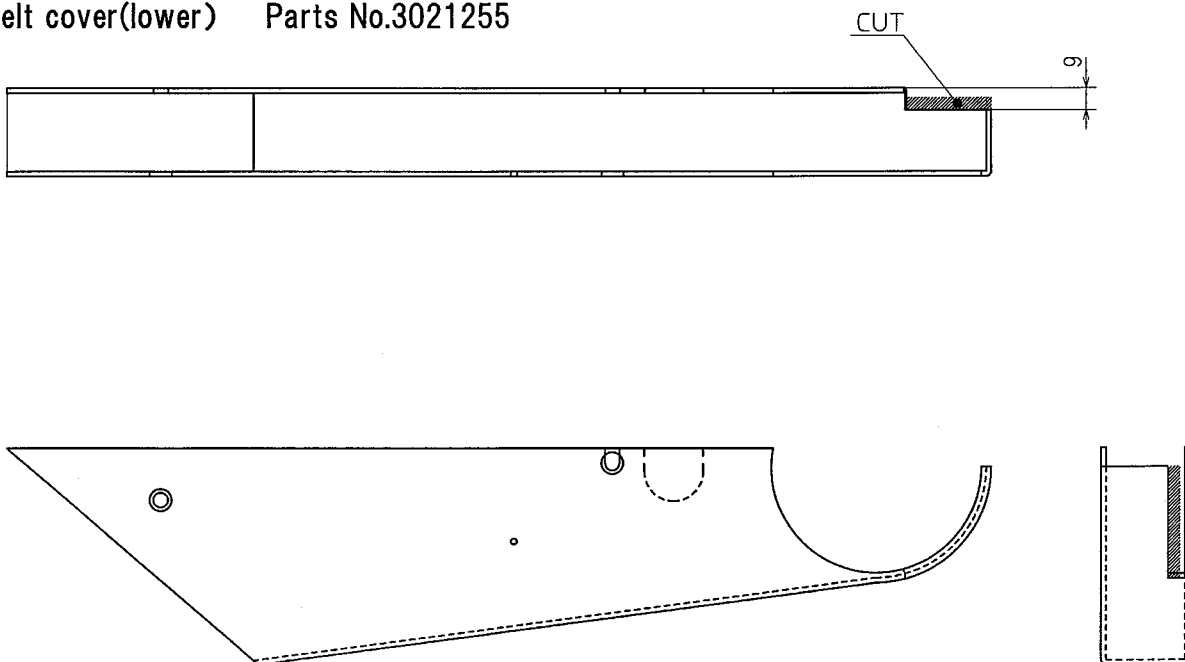


Fig. 2-21

2.6 Other parts

Setting thread eyelets:

Stand the thread guide plate supports① on the thread tension support② and fix the thread guide plate③ on the supports① with the screws④.

Adjust the thread pipes⑤ to thread smoothly without entangling.

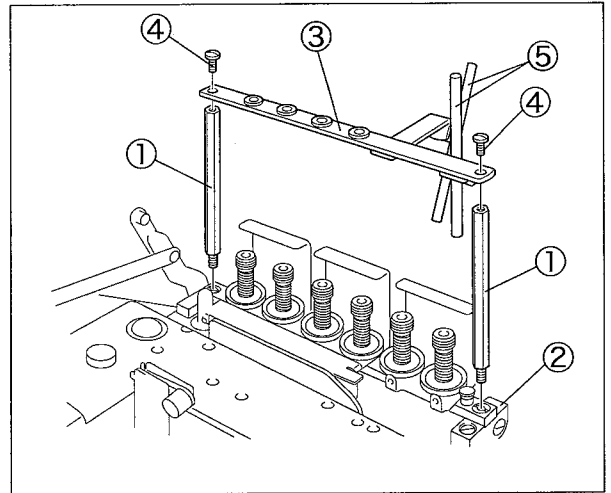


Fig. 2-22

Handwheel

Table top type:

Fix the motor pulley⑥ with the handwheel shaft⑦ .

Fix the handwheel⑧ to the handwheel shaft⑦ with the screws⑨ .

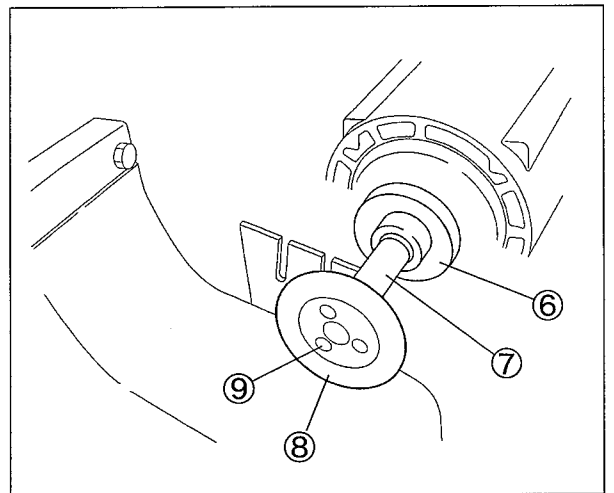


Fig. 2-23

Hanging type:

Set the handwheel⑩ on the pulley⑪ with the screws⑫.

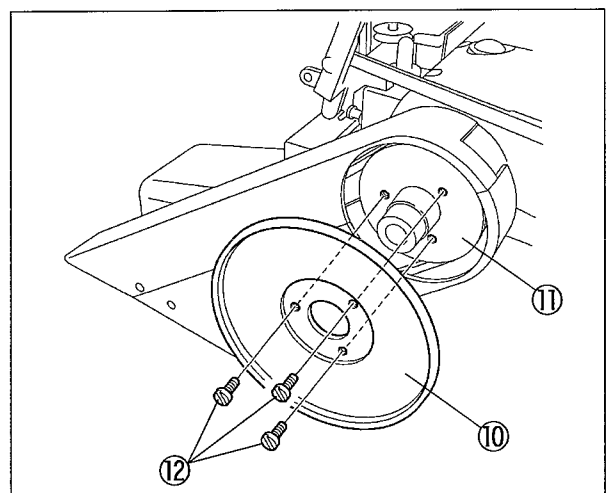


Fig. 2-24

Synchroniser

Set the synchroniser included a servomotor as follows.

Table top type:

Set the positioning plate^⑬ on the belt cover(upper). Set the synchroniser on the machine pulley and fix it with the positioning plate^⑬ (see Fig.2-25).

Hanging type:

Set the synchroniser on the machine pulley.

Fold the supporting plate included a motor on the machine table with the screw and fix the synchroniser on the supporting plate.

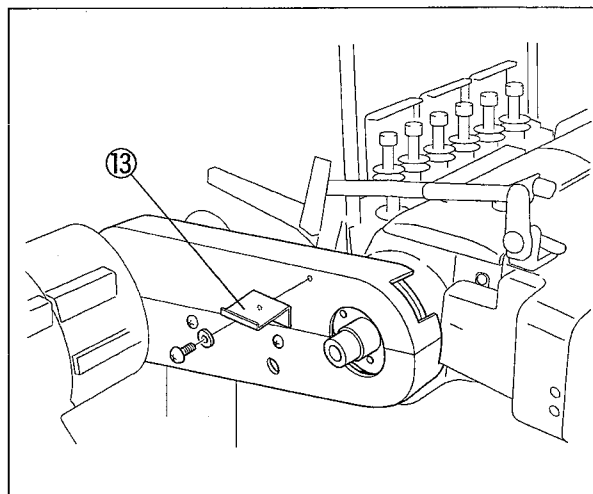


Fig. 2-25

3. Sewing speed and rotating direction of pulley

The sewing speed is 4200 rpm at the maximum and 3800 rpm in usual.

Run a new machine at a speed of 15 - 20% lower than maximum sewing speed during the first 200 hours (for about one month) so that the machine can offer a long service life in good condition.

The rotating direction of the motor pulley ① and the machine pulley ② is clockwise from the operator side.

⚠ CAUTION

If rotating in reverse direction, oil can not be supplied properly. It can cause the machine damage.

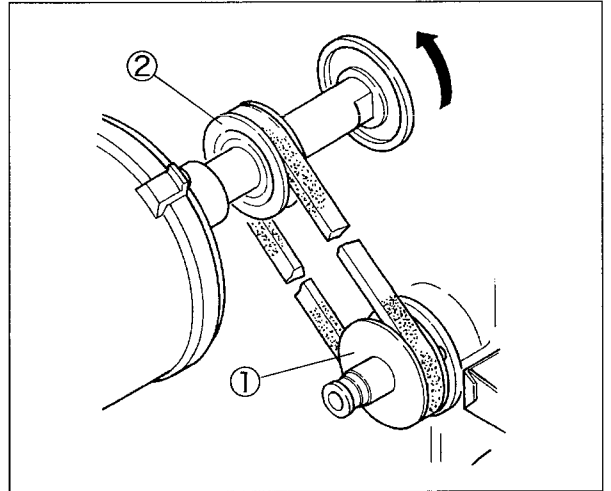


Fig. 3-1

4. Lubrication

4.1 Lubricating oil

Use YAMATO SF OIL No. 68.

⚠ CAUTION

NEVER add additives to the oil.
If added, it can cause the deterioration of the oil and the machine damage.

4.2 Lubricating

Remove the plug screws ① and ② indicated "OIL" and supply oil.

From the plug screw ①, supply oil until the oil level indicator top reaches the upper line in the oil sight gauge ③.
From the plug screw ②, supply oil to the upper line in the oil sight gauge ④.

Check the oil level between the lines in the oil sight gauges ③ and ④ before running a machine.

If it is under the lines, supply oil.

Check the oil splashes from the nozzle inside the oil sight top windows ⑤ and ⑥ when starting to run a machine.

⚠ CAUTION

Too much oil or not enough oil can cause oil leakage and machine trouble. Be sure to keep the oil level between the lines.

Fill the knife holder bracket bushing with YAMATO YS GREASE about once every 6 months.

- (1) Remove the screw ⑦ of the sewing head cover (left).
- (2) Press the tip of the YAMATO YS GREASE container ⑨ into the hole on the sewing head that can be seen from the screw hole ⑧.
- (3) Lightly press the container ⑨ to fill the bushing with a small amount of grease (about 1/8 to 1/10 of the container).
- (4) Attach the screw ⑦.

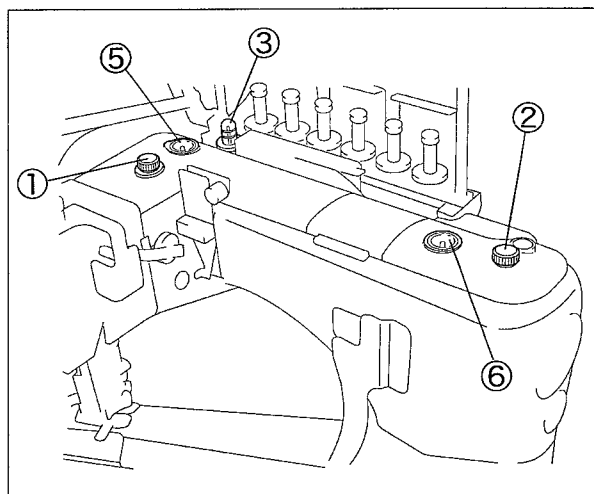


Fig. 4-1

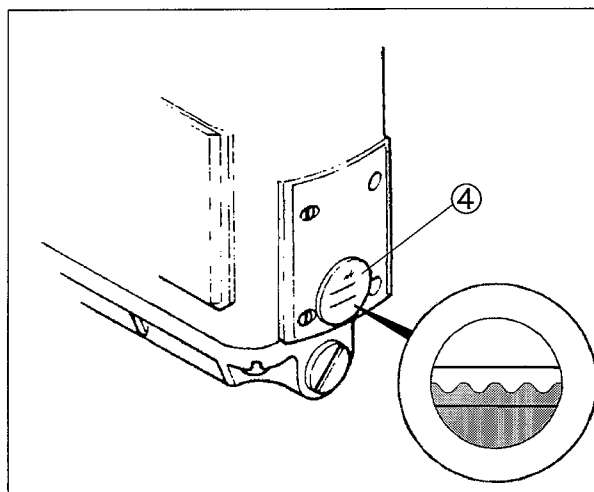


Fig. 4-2

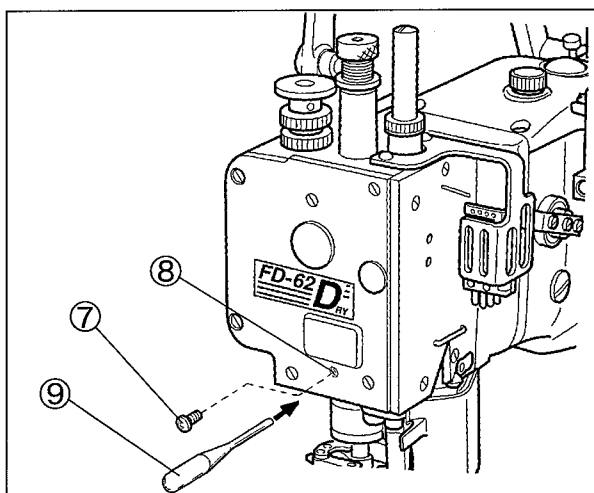


Fig. 4-3

⚠ CAUTION

YAMATO YS GREASE is a special grease for dry sewing machines. Do not use any other grease. If you use a different grease, it may cause a malfunction of the sewing machine.

4.3 Priming oil

Prime oil if oil does not circulate completely when installing a new machine or running a machine which has not been used for a while.

Remove the plug screws① of the pump driven gear to prime oil. Run a machine after resetting them①.

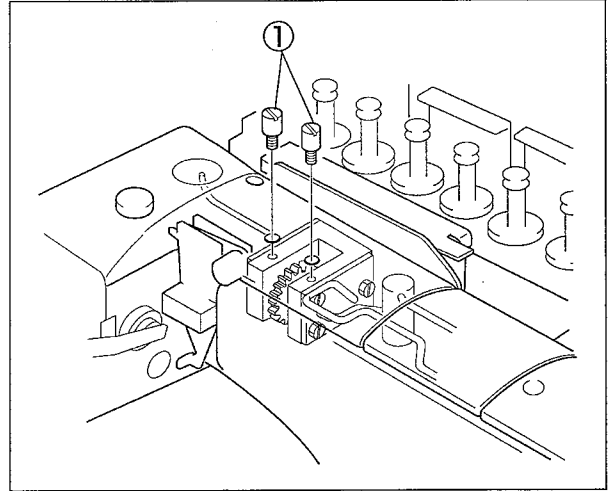


Fig. 4-4

4.4 Changing oil

Timing:

When using a new machine, change the lubricating oil after running for 200 hours (for about one month). After that, change the oil once or twice a year.

Procedure:

- (1) Remove the belt cover. (See page 11)
- (2) Set containers received the oil under the screws② and ③ respectively.
- (3) After removing screws② and ③, the oil is drained.

NOTE

Be careful not to soil the V-belt and the machine pulley with the oil.

- (4) Reset the screws② and ③.
- (5) Change the oil. (See “4.2 Lubrication” on page 17)
- (6) Reset the belt cover. (See page 11)

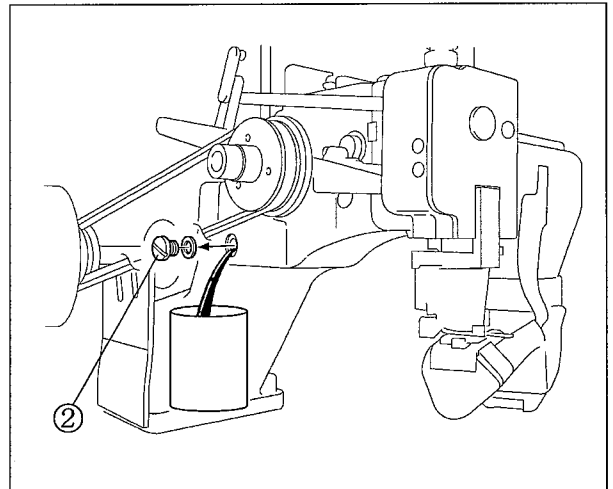


Fig. 4-5

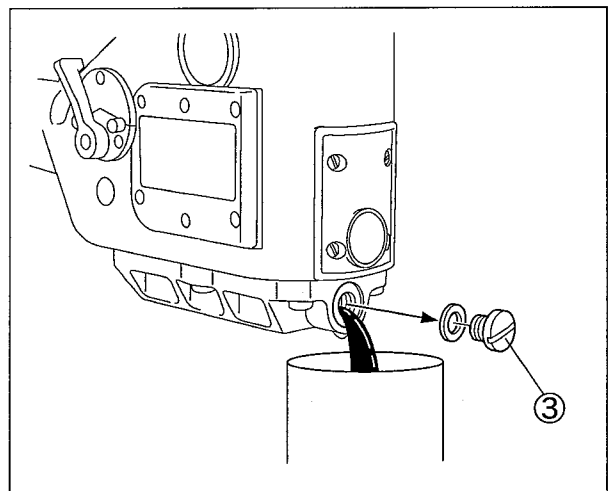


Fig. 4-6

5. Proper operation

5.1 Needle system

Sewing needle:

Groz-Beckert UY118GKS

Organ FL × 118GCS

Select the proper sewing needle in size according to the thickness and type of material.

Japanese standard	8	9	10	11	12	-	14
Metric standard	60	65	70	75	80	-	90

Table 3

Note: Some size of the needles are not available . Check the size in a manufacturer' s catalog.

Retainer needle:

One retainer needle is used with four sewing needles.

Groz-Beckert 36211, 36211A (with scarf)

Organ FLG-1, FLG-8 (with scarf)

Select the proper retainer needle in size according to the thickness and type of material.

Japanese standard	8	9	10	11	12
Metric standard	60	65	70	75	80

Table 4

Note: Some size of the needles are not available . Check the size in a manufacturer' s catalog.

5.2 Installing needle



WARNING

Before installing the needles, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

The shank of the needle includes the flat parts. Insert needles into the inmost point of the needle clamp ② , and tighten them with the screws ① .

Replacing needle:

- (1) Rotate the handwheel to raise the needles at the highest point.
- (2) Loosen the screws ① and pull the needles down.
- (3) Face the flat parts front, insert new needles into the needle clamp ② as far as they will go. Tighten them with the screws ① securely.

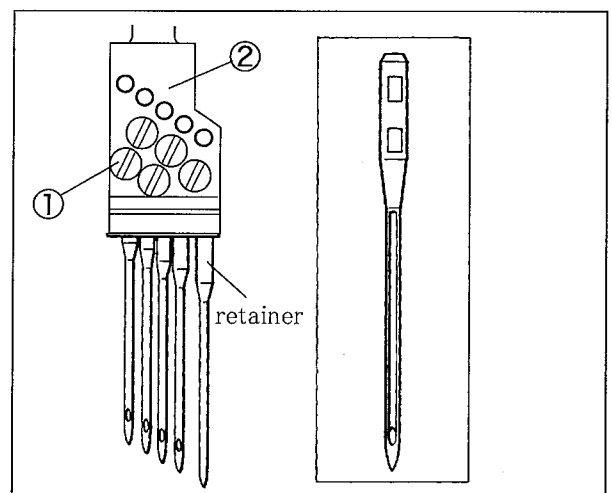


Fig. 5-1

WARNING

Before threading, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

5.3 Threading



Thread correctly, referring to Fig. 5-2.

- A, B, C, D : Needle thread ... When threaded, pull the thread out until it comes to the front of the needles. Then cut off the knots before rethreading them through the needle eyes.
- E : Top cover thread ... When threaded, pull the thread out until the knot is out.
- F : Lower looper thread ... Then cut off the knot.

i Easy to use

When raising presser foot, thread tension will be released to take up smoothly.

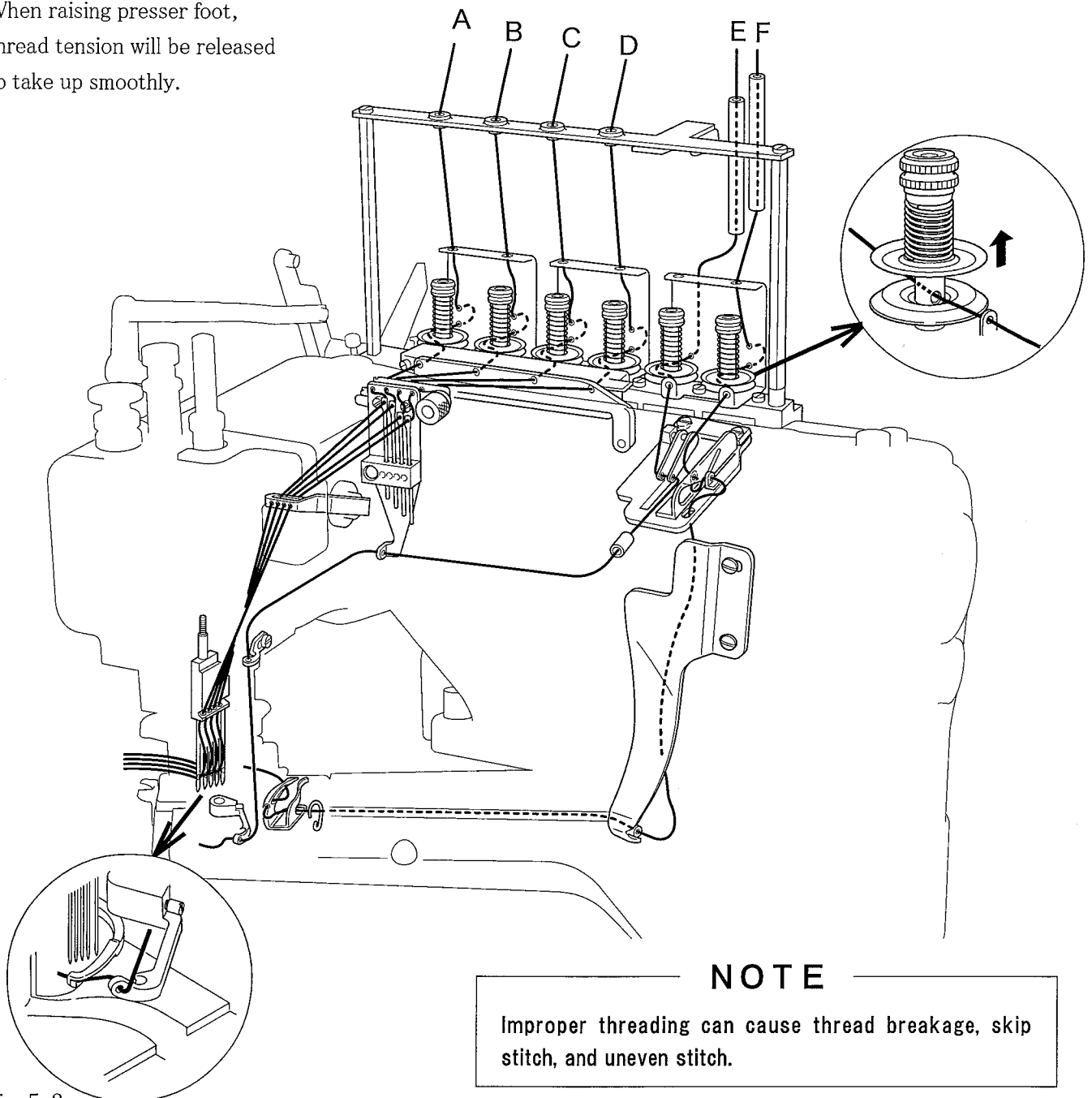


Fig. 5-2

5.4 Thread tension



Adjust the thread tension with the tension adjusting nuts ① - ⑥ depending on fabric type, thread type, seam width, stitch length, and other sewing conditions.

① - ④: needle threads

(①:right needle, ④:left needle)

⑤: top cover thread

⑥: looper thread

- To tighten the thread tension, turn the nuts clockwise.
- To loosen the thread tension, turn the nuts counterclockwise.

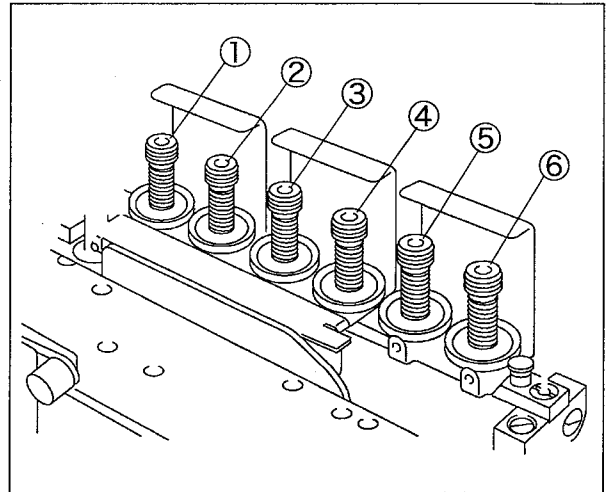


Fig. 5-3

5.5 Pressure of presser foot



Loosen the lock nut ⑦ and turn the adjusting screw ⑧ to adjust the pressure.

- To increase the pressure, turn the adjusting screw ⑧ clockwise.
- To decrease the pressure, turn the adjusting screw ⑧ counterclockwise.

Keep the pressure as low as possible for stable stitches.

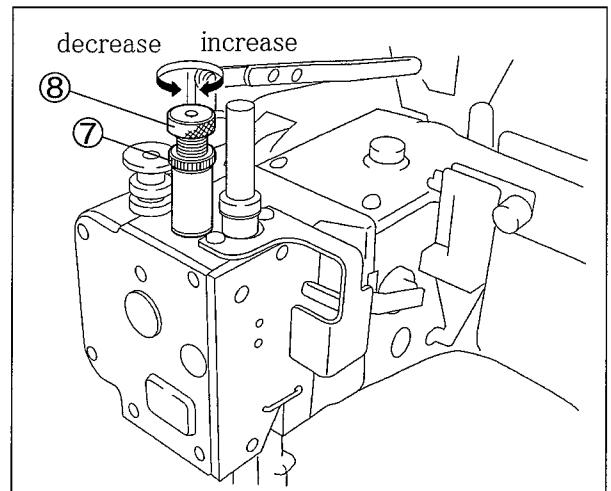


Fig. 5-4

5.6 Up-and-down position of presser foot



Following effective points will be obtained by slightly raising the presser foot.

- Prevention of fabric jam
- Prevention of feed scratch mark
- Improvement of durability of presser foot spring plate
- Reduction of vibration and noise
- Available for fine adjustment of lapped fabric width

To raise the presser foot.

- (1) Move the needle to the lowermost position.
- (2) Turn nut ① counterclockwise to raise the presser foot.
- (3) Adjust the position the presser foot so that the gap between presser foot spring plate ③ and the bottom of presser foot ④ falls in a range between 0.3mm - 0.5mm.
- (4) To prevent nut ① from loosening, turn nut ② counterclockwise until it touches nut ①.

To lower the presser foot.

- (1) Move the needle to the lowermost position.
- (2) Loosen the nut ② and turn the nut ① counterclockwise to low the presser foot.
- (3) Adjust the clearance between the bottom ④ of the presser foot and the presser foot spring plate ③ to 0.3 - 0.5 mm.
- (4) Tighten the nut ① securely.

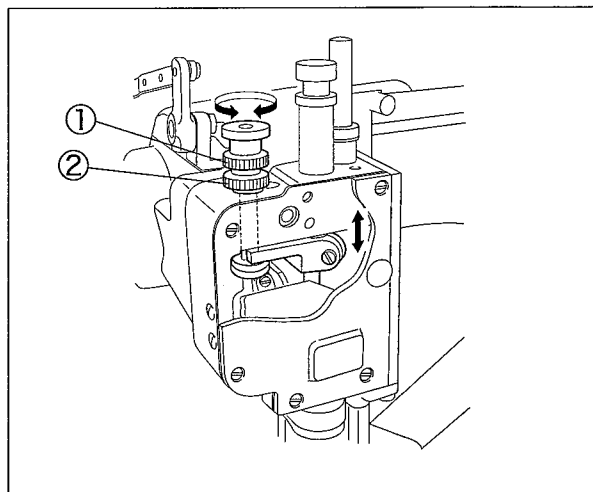


Fig.5-5

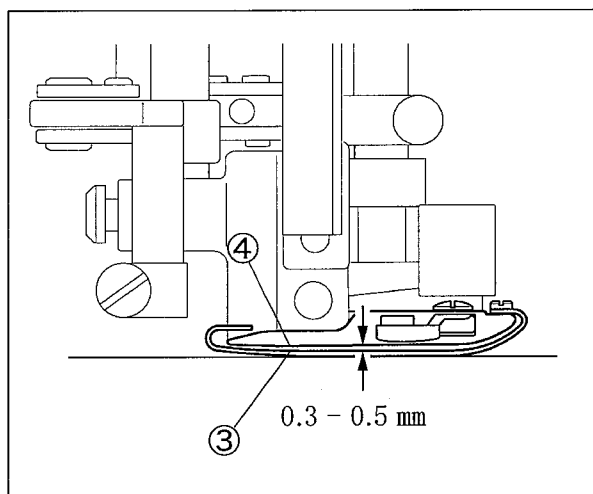


Fig. 5-6

5.7 Adjusting differential feed dog



Move the differential feed operating lever ⑤ right or left to adjust differential feed dog.

The lever ⑤ between the graduations “4” and “5” makes the equal movement of the main and the differential feed dogs.

- To make normal differential, move the lever ⑤ to “9” .
- To make reverse differential, move the lever ⑤ to “1” .

* The screw ⑥ is for fixing the lever ⑤ and keeping the differential movement adjusted.

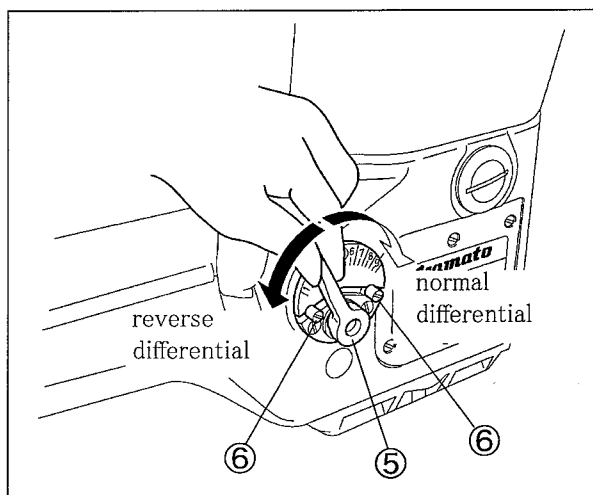


Fig. 5-7

⚠ WARNING

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

5.8 Adjusting stitch length



Stitch length ranges 1.6 – 2.5 mm as standard and can be adjustable infinitely.

Adjusting:

- (1) Loosen the screw ① and move the needle guard(rear) ② most rearward. Then tighten it slightly.
 - * This is skipped when decreased the stitch length.
- (2) Remove the plug screw ③.
- (3) Loosen the screw ④ to adjust the stitch length.
 - To increase stitch length, move the screw ④ upward.
 - To decrease stitch length, move the screw ④ downward.
- (4) Tighten the screw ④ securely and reset the plug screw ③.

⚠ CAUTION

Tighten the plug screw ③ securely to prevent oil leakage.

- (5) Adjust the position of the needle guard(rear) ② and tighten the screw ① securely. See “6.8 Needle guard(rear)” on page 35.

⚠ CAUTION

Be sure to adjust the needle guard(rear) after changing stitch length to prevent breakage of the parts.

ⓘ Advice on adjustment

Always adjust stitch length after changing differential feed dog.

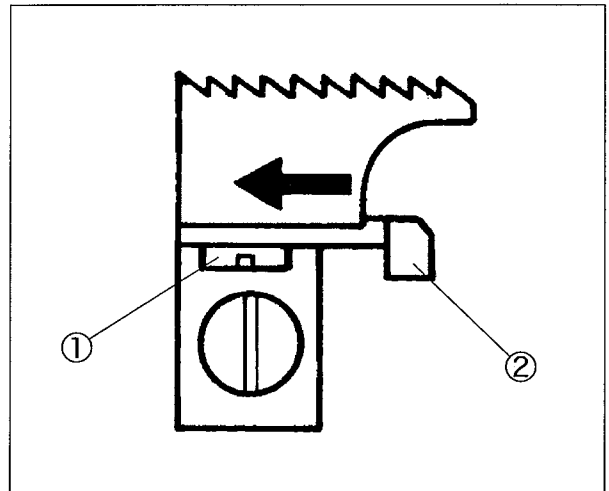


Fig. 5-8

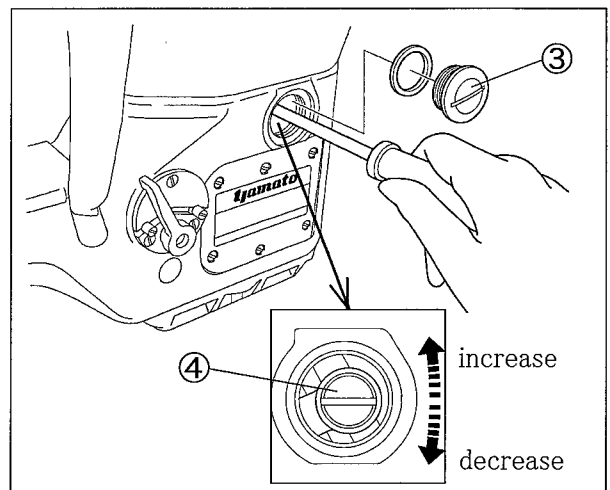


Fig. 5-9

Table 5 shows the number of stitches per inch (25.4 mm) and 30 mm converted stitch length.

Stitch length (mm)	Number of stitch (per 1 inch (25.4 mm))	Number of stitch (per 30 mm)
2.5	10	12
2.1	12	14
1.8	14	16.5
1.6	16	19
1.2	21	25
1	25	30

Table 5

⚠ WARNING

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

5.9 Adjusting lapped width of upper fabric



For the standard position of the lower knife ①, make the distance between the lower knife ① tip and the lower knife clamp ② to 0 - 0.5 mm.

For the standard position of the upper knife ③, engage between the upper knife ③ and lower knife ① to 0.5 mm when the upper knife ③ is at the extreme left.

To move the fabric edge right or left, position the lower knife ①, and then move the upper knife to engage between the knives to 0.5 mm.

Loosen the screws ④ and ⑤ to adjust the lower and upper knives respectively.

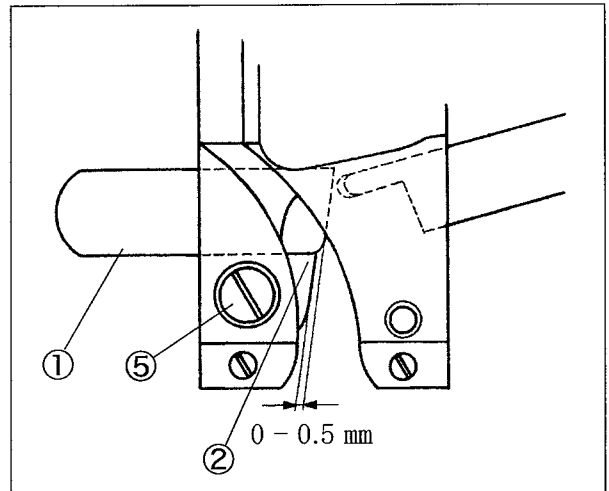


Fig. 5-10

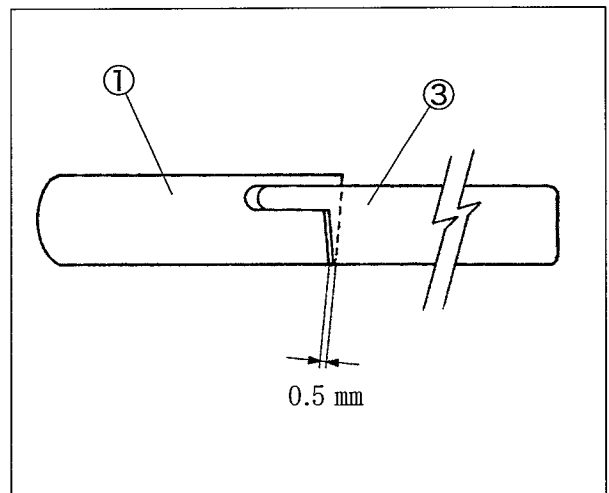


Fig. 5-11

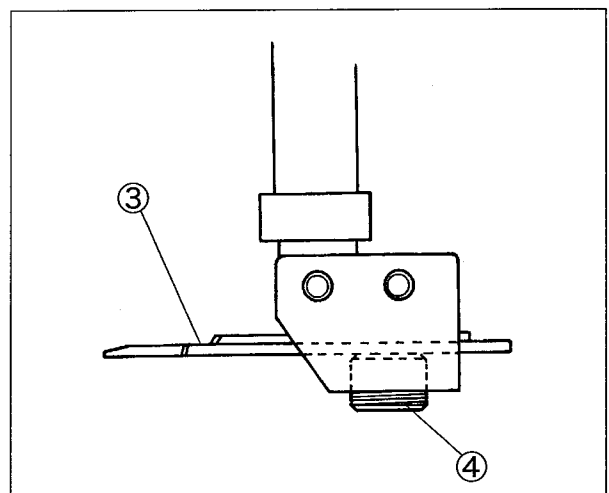


Fig. 5-12

5.10 SP device



SP device(needle thread oiling) is equipped as standard to prevent thread breakage and skip stitch when running a machine at high speed or using synthetic thread and/or synthetic fabric.

Fix the felts① included accessories into the SP tank② when using.

⚠ CAUTION

1. When not using SP device, remove the felts①. If not, it may occur irregular condition during sewing.
2. If the silicone oil is stuck onto the parts other than SP device, it can cause the machine damage. Be sure to wipe it away.

Use dimethyl silicone oil.

Open the oil cup lid③ and check the oil amount.

If not enough, supply oil into the SP tank②.

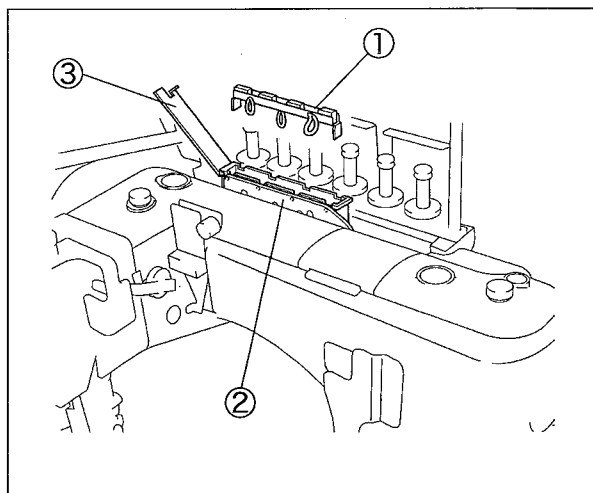


Fig. 5-13

5.11 Use of lap former



Standard left-and-right position:

Align the point A of the lap former ① with the center of four needles.

According to the lapped edges of the fabrics or fabric feeding, loosen the screws ④ and adjust the position.

Standard front-and-rear position:

Set the position where the lap former slide block ② touches and stops in the front of the stitch plate ③.

According to the fabric thickness, adjust the position slightly toward the operator.

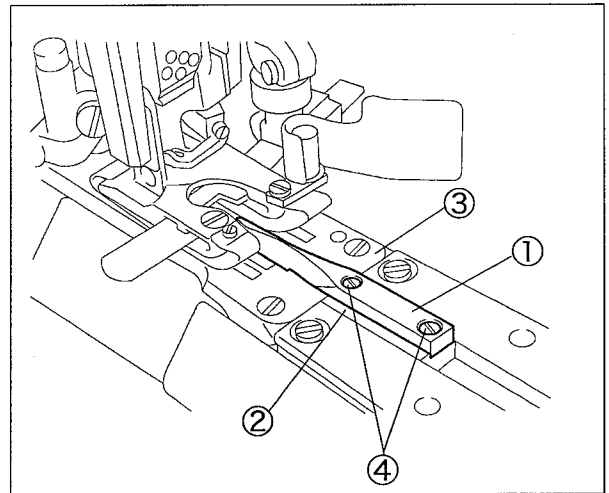


Fig. 5-14

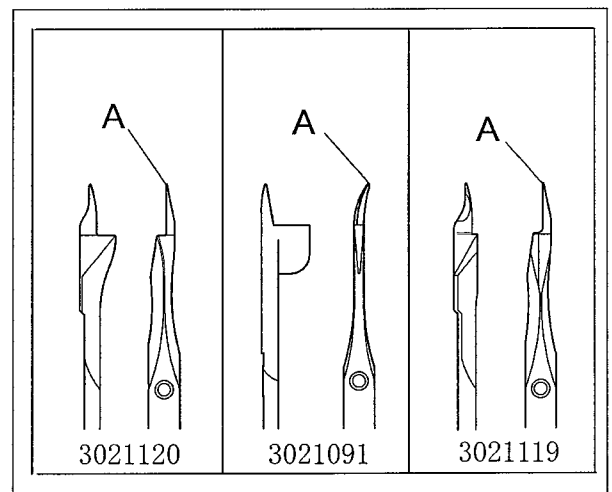


Fig. 5-15

Part No.	Applicable model
3021120	FD-62DRY-02, FD-62DRY-06
68469	FD-62DRY-02 (extra) FD-62DRY-06 (extra)
3021091	FD-62DRY-07
3021119	FD-62DRY-12HR

Table 6

5.12 Setting tape (FD-62DRY-03)



Set a tape correctly, referring to Fig. 5-16.

Pull the tape out after setting it under the presser foot through the folder①.

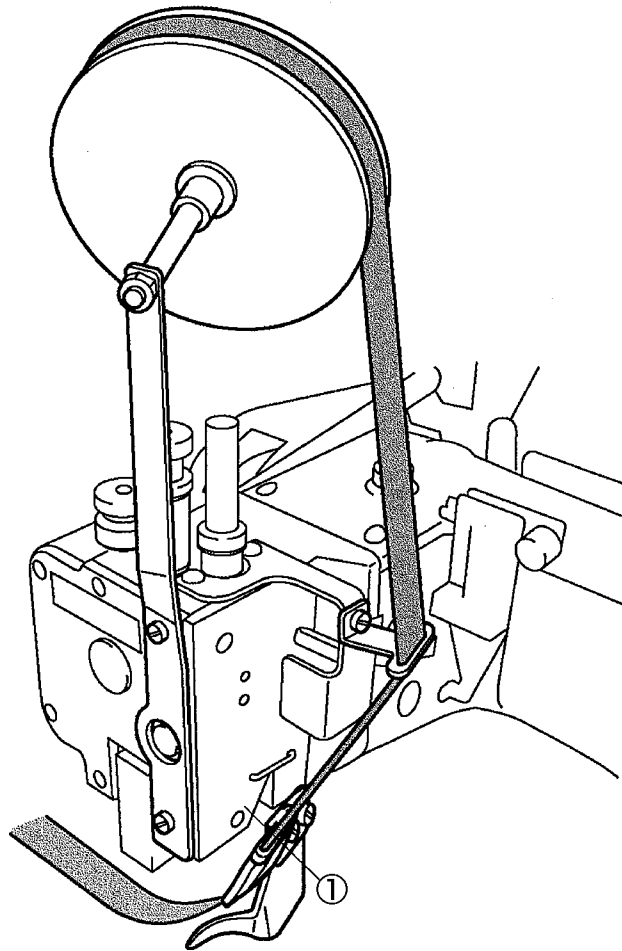


Fig. 5-16

6. Adjustments

⚠ WARNING

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

6.1 Needle thread tension

Needle thread strike-off pin:

Each of four needles has the needle thread strike-off pin which adjusts the thread tension respectively.

- (1) Position the needle thread take-up ① at the lowest point.
- (2) Set the top of pin ② even with the needle thread as the fourth right needle.
- (3) Set the pin ③ 3.2 mm higher than the pin ②.
- (4) Set the pin ④ 1.6 mm higher than the pin ②.
- (5) Set the pin ⑤ even with or 0.8 mm higher than the pin ②.
- (6) Tighten the screws ⑥ securely.

Note: Check the tops of the pins are horizontally.

Loosen the screws ⑥ and move the pins up or down to adjust the needle thread loop.

- To make the loop larger, move the pins in the direction "L".
- To make the loop smaller, move the pins in the direction "S".

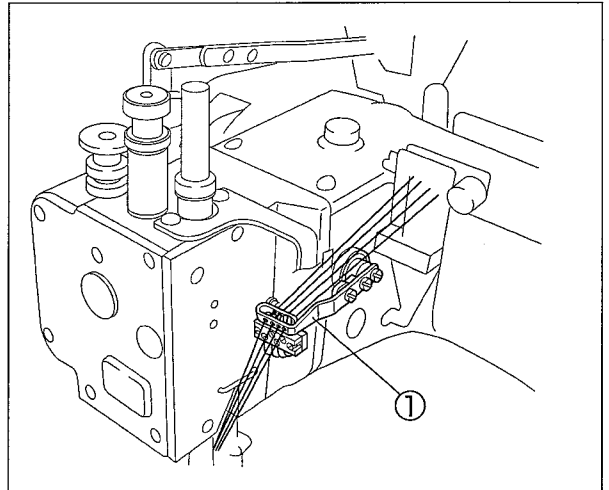


Fig. 6-1

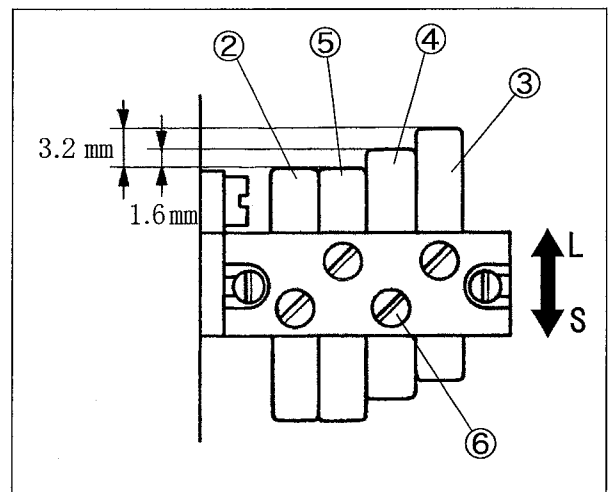


Fig. 6-2

⚠ WARNING

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

Needle thread eyelet:

- (1) Make the height of the right needle thread eyelets ① to align their eyes with the eyes ③ of the needle thread eyelet holder ②.
- (2) Set the eyelet ④ 5 mm lower than the eyelet ①.
- (3) Set the eyelet ⑤ 9 mm lower than the eyelet ①.
- (4) Set the eyelet ⑥ 15 mm lower than the eyelet ①.

Loosen the screws ⑦ to adjust the needle thread tension.

- To tighten needle thread, move the eyelets in the direction "T".
- To loosen needle thread, move the eyelets in the direction "L".

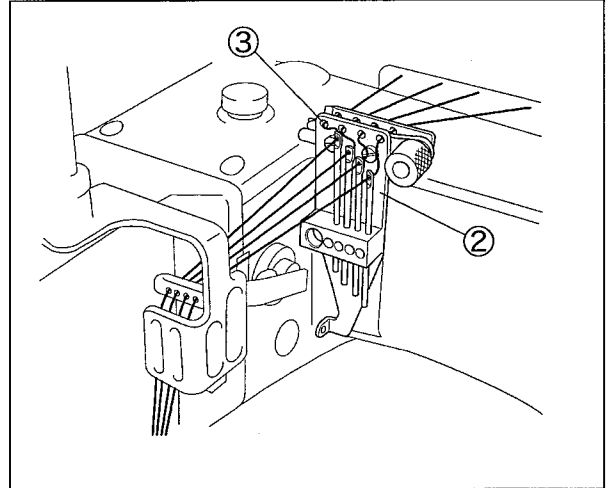


Fig.6-3

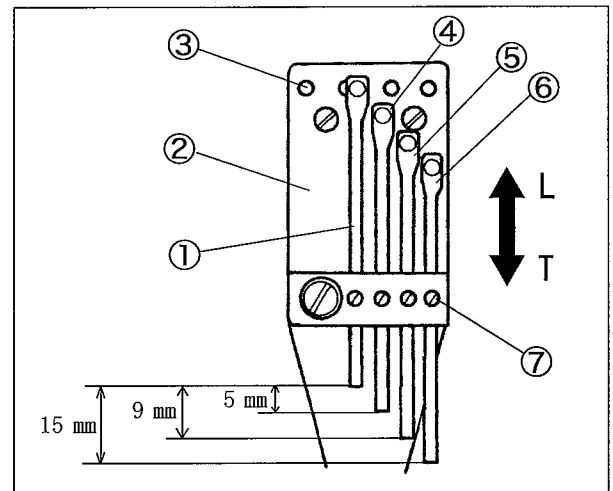


Fig.6-4

⚠ WARNING

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

6.2 Looper thread tension

The looper thread take-up is seen from the front in Fig. 6-5.

Position of looper thread take-up guide:

Align the right of the looper thread take-up guide ① with that of the eyelet supporting plate ②.

Timing of looper thread take-up:

Position the looper thread take-up ④ as standard so that looper thread passes at the point A when the needle bar ③ is lowered 2.8 mm from the highest point. Loosen the screws ⑤ to adjust it.

- To increase the looper thread take-up amount, hasten the timing.
- To decrease the looper thread take-up amount, delay the timing.

Note: When adjusting take-up ④, face both bosses of the take-up ④ and the top cover thread take-up without shifting the front-and-rear position.

⚠ CAUTION

If the timing of the looper thread take-up exceeds the adjustable range, it may occur skip stitch.

Position of looper thread take-up eyelet:

Set the looper thread take-up eyelets ⑥ and ⑦ at the extreme right as standard.

Loosen the screws ⑧ and ⑨, and move them right or left to adjust it.

- To increase the looper thread take-up amount, move them in the direction “L” .
- To decrease the looper thread take-up amount, move them in the direction “S” .

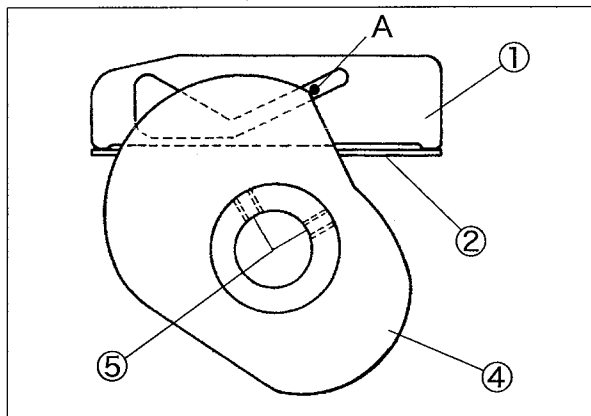


Fig. 6-5

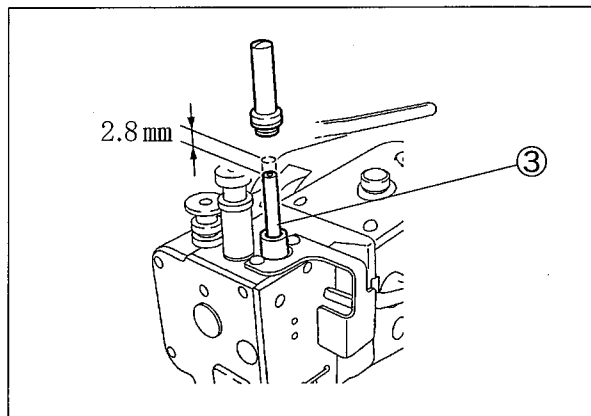


Fig. 6-6

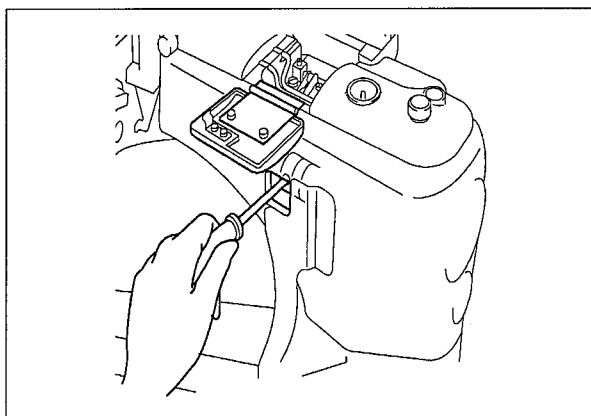


Fig. 6-7

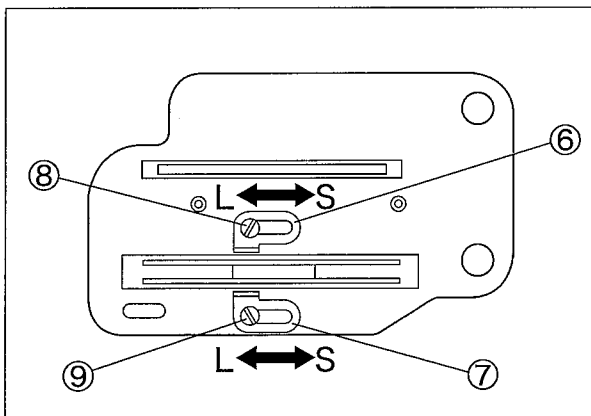


Fig. 6-8

⚠ WARNING

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

6.3 Top cover thread tension

The top cover thread take-up is seen from the front in Fig. 6-9.

Position of thread take-up eyelet:

Make the standard distance from the top of the eyelet supporting plate ② to the thread take-up eyelet ① eye to 4.4 mm.

Loosen the screw ③ and move the eyelet ① up or down to adjust it.

- To increase the top cover thread take-up amount, move the eyelet ① downward.
- To decrease the top cover thread take-up amount, move the eyelet ① upward.

Timing of top cover thread take-up:

The moment the top cover thread is hooked with the top cover thread hook ④ (Fig. 6-10), the thread is held at the point 0 - 1.0 mm apart from the top of the take-up ⑤.

Loosen the screws ⑥ to adjust it.

Note: When adjusting take-up ⑤, face both bosses of the take-up ⑤ and the looper thread take-up without shifting the front-and-rear position.

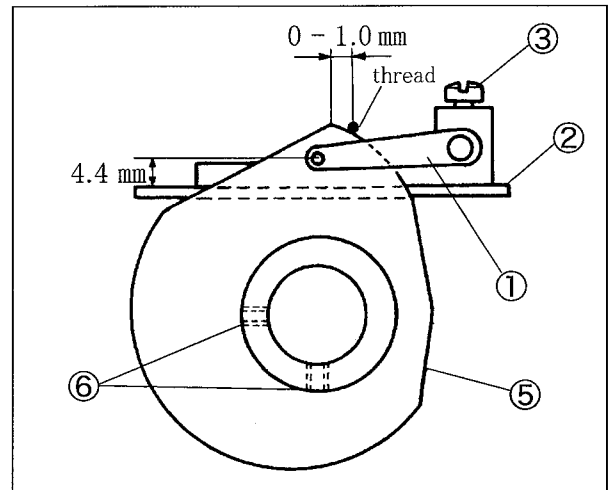


Fig. 6-9

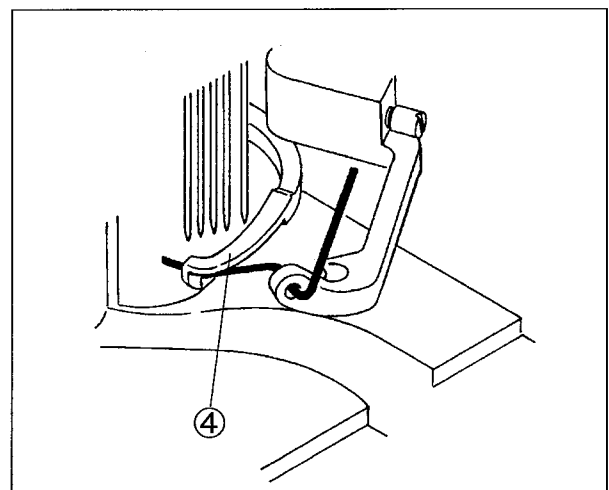


Fig. 6-10

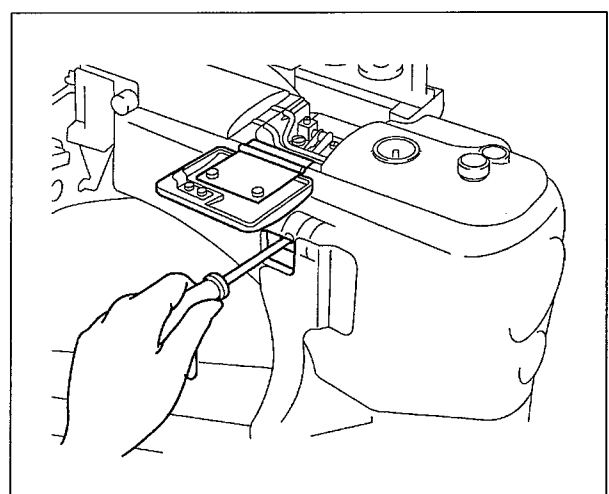


Fig. 6-11

6.Adjustments

WARNING

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

6.4 Height of needle

Make height “N” of the needle from the top of the stitch plate to the tip of the fourth needle from the left when the needle is at the highest point.

<u>Needle distance</u>	<u>Height(N)</u>
R: 5.2 mm	13.49 mm
S: 6.0 mm	12.7 mm

Adjusting height:

- (1) Remove the seal plug ①.
- (2) Loosen the screw ②.
- (3) Move the needle bar ③ up or down to adjust the height.

Check the alignment in Fig. 6-14.

- (4) Tighten the screw ② securely.
- (5) Reset the seal plug ①.

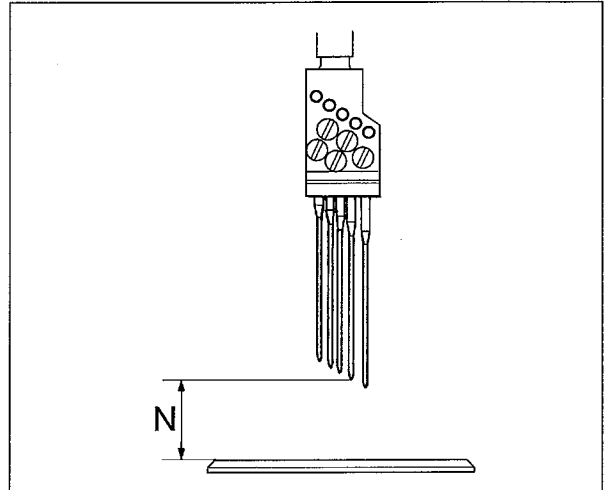


Fig. 6-12

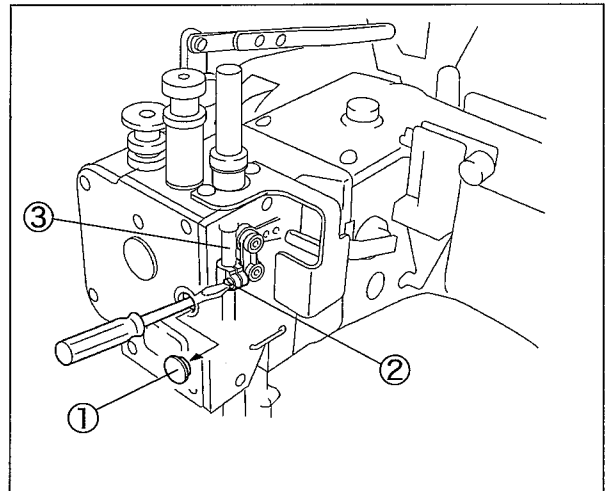


Fig. 6-13

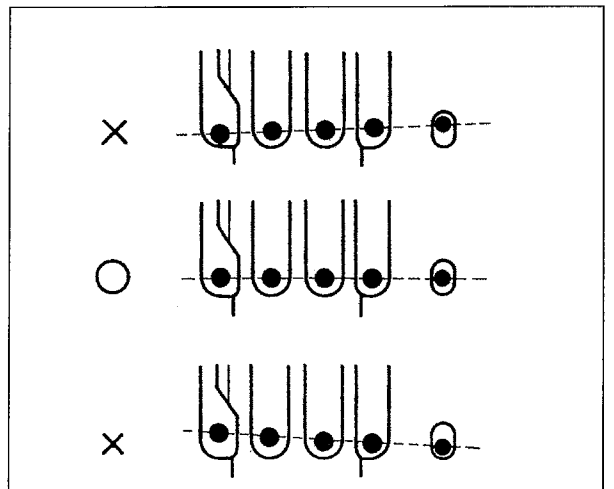


Fig. 6-14

⚠ WARNING

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

6.5 Top cover thread carrier and hook

Top cover thread carrier:

Position the top cover thread carrier ① so that the top cover thread loop formed with the hook passes behind the first and the second needles from the left when the carrier ① comes most nearly to the needle.

Loosen the screw ⑤ to adjust it.

Top cover thread hook:

When the top cover thread hook ② comes most nearly to the top cover thread carrier ③, make the clearance between them to 0.4 - 0.7 mm during one rotation.

When the hook ② moves at the extreme right, make the clearance between the hook ② and the retainer ③ to 0.5 mm.

Loosen the screw ⑥ to adjust them.

Note: Be sure to adjust them without play up and down.

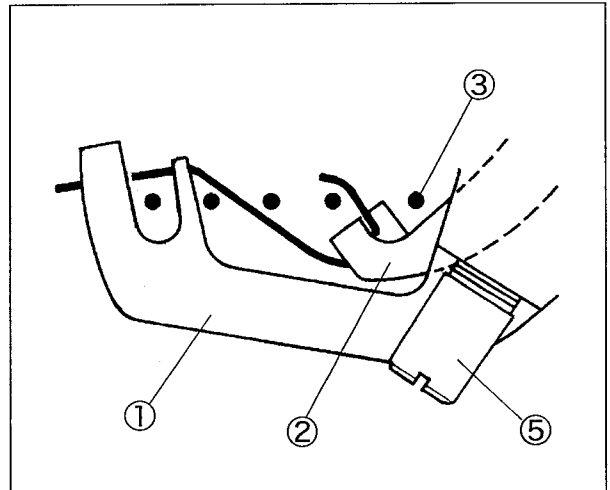


Fig. 6-15

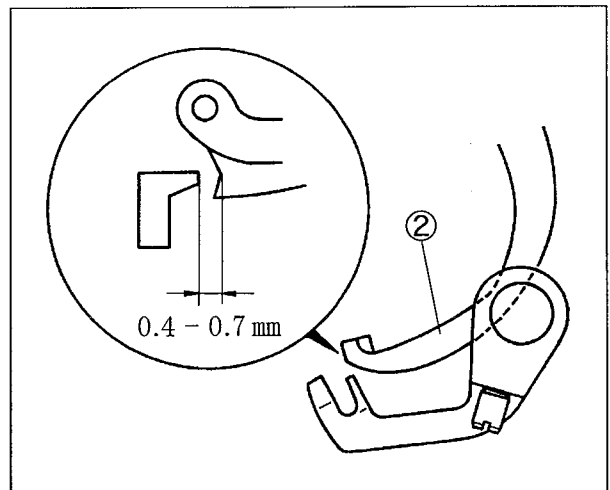


Fig. 6-16

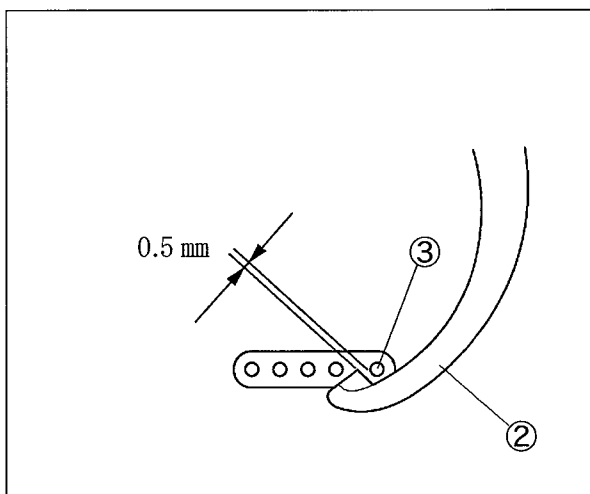


Fig. 6-17

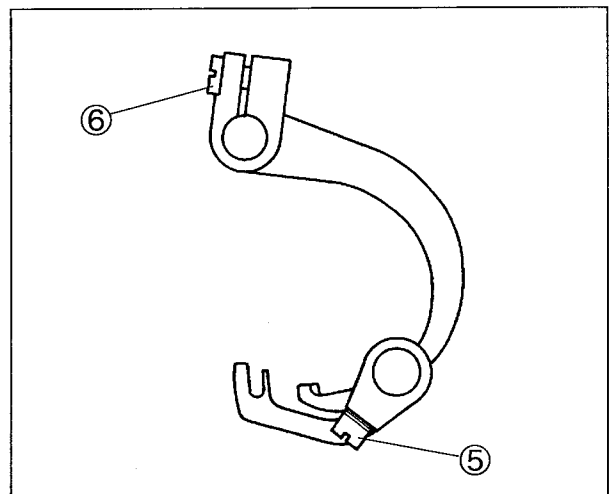


Fig. 6-18



WARNING

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

6.6 Loper

Height:

Insert the looper ① into the hole of the looper holder ⑥ in most position and tighten the screw ② securely.

Angle:

Fix the surface A of the looper at 90° to the looper rocker shaft ③.

Loosen the screw ② to adjust it.

Distance between looper and needle:

Make standard distance between the looper tip and the center of the left needle to 4.2 - 4.8 mm when the looper ① is at the extreme left.

Loosen the screw ④ to adjust it.

Front-and-rear position of looper and needle:

When the looper ① moves from the left to the right, it passes behind the needle.

Adjust the position so that the looper comes closely to the needle with the clearance of 0 - 0.05 mm but without touching them when the looper tip comes at the center of the left needle.

Loosen the screw ④ and turn the adjusting screw ⑤ to adjust it.

● To move forward, turn the screw ⑤ clockwise.

● To move backward, turn the screw ⑤ counterclockwise.

After adjusting, check the distance and tighten the screw ④ securely.

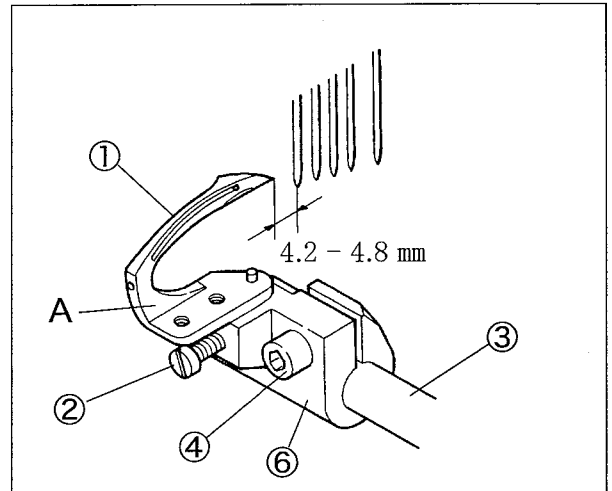


Fig. 6-19

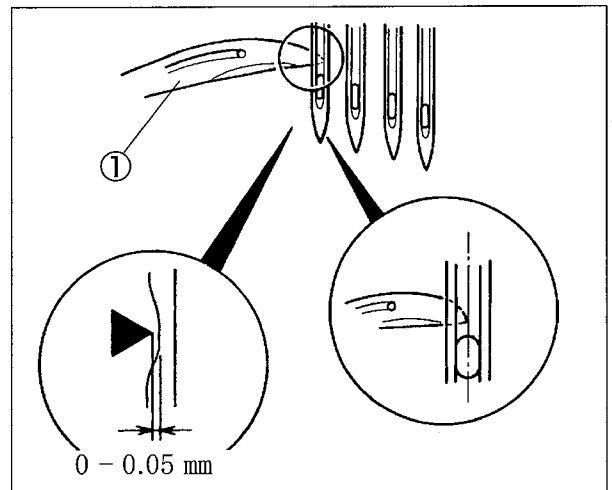


Fig. 6-20

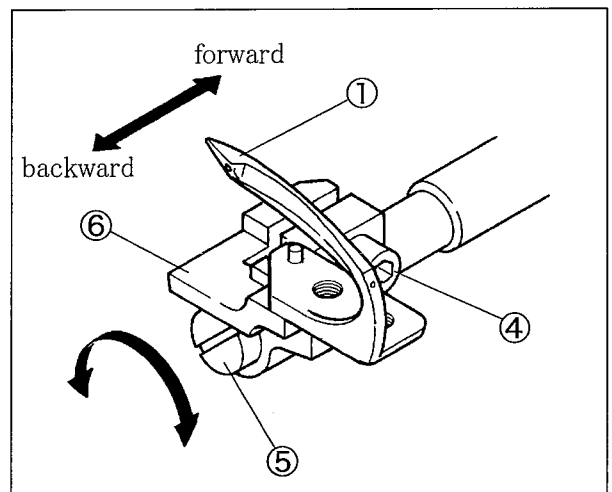


Fig. 6-21

⚠ WARNING

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

6.7 Needle guard (front)

Push the needle guard(front)① so that the clearance between the needle and the looper is 0 mm when the looper tip comes at the center of the left needle.

Loosen the screw ② to adjust it.

Check the looper tip touches the back of the needle and the needle does not swing to the right when the looper③ moves from the left to the right while rotating the handwheel.

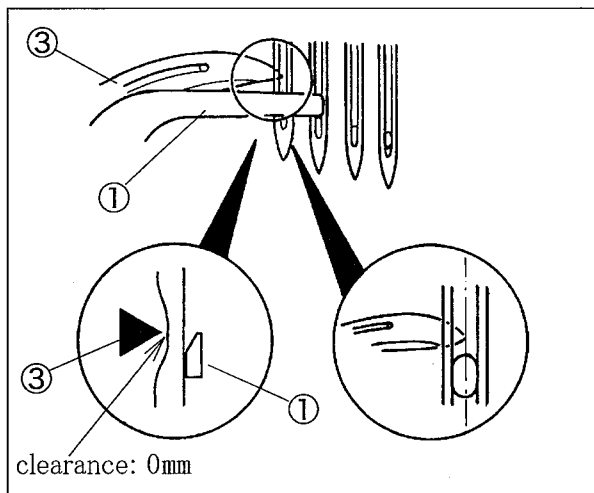


Fig. 6-22

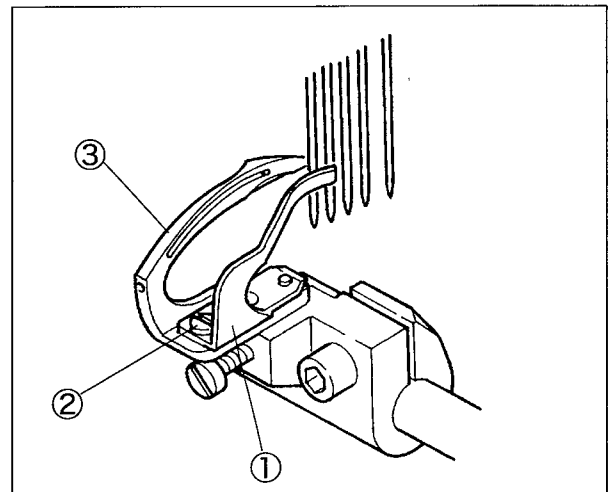


Fig. 6-23

6.8 Needle guard (rear)

Make the standard clearance between the needle guard(rear) ④ and the left needle to 0.05 – 0.1 mm when they meet most closely.

Open the looper cover and loosen the screw ⑤ to adjust it.

Check the needle does not swing to the right when the looper moves from the left to the right while rotating the handwheel.

⚠ CAUTION

After changing stitch length, the clearance changes between the needle guard(rear)④ set on the main feed dog and the needle.

Readjust the position of the needle guard(rear)④ after changing stitch length.

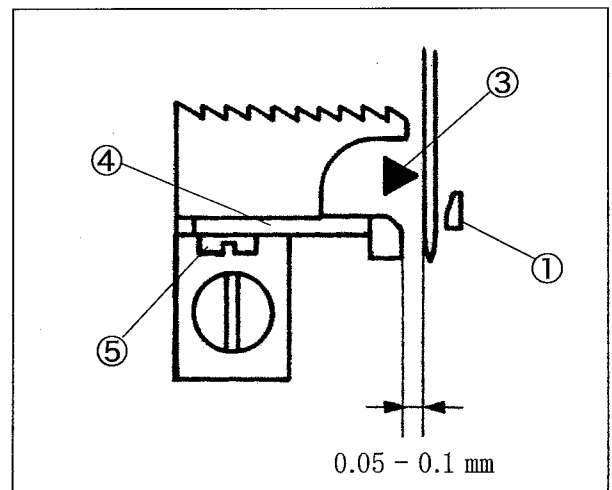


Fig. 6-24

WARNING

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

6.9 Height of feed dog

Fixing:

Fix the differential feed dog① and main feed dog③ with the screws ② and ④ respectively.

Fix the needle guard(rear)⑤ on the main feed dog and tighten it at the most rear position with the screw ⑥ slightly.

Note: See “6.8 Needle guard(rear)” to adjust it.

Height:

Adjust the height from the top of the stitch plate to the part A of the main feed dog③ to 1.2 - 1.5 mm when the feed dog is at the highest point.

Align the differential feed dog even with the main feed dog.

Fine adjustment of height:

Make fine adjustment of height of the main and differential feed dogs with the feed bar eccentric pin⑧ near the center of the cylinder.

Loosen the screw ⑦ and move the pin ⑧ to adjust it.

- To raise the feed dog, turn the pin ⑧ clockwise.
- To lower the feed dog, turn the pin ⑧ counterclockwise.

Advice on adjustment

Set the groove of the feed bar eccentric pin ⑧ horizontally with the screw ⑦ before fixing the main and differential feed dogs.

This is to adjust the equal movement of them.

Easy to use

When only removing the stitch plate, turn the feed bar eccentric pin ⑧ to the left to lower the feed dogs.

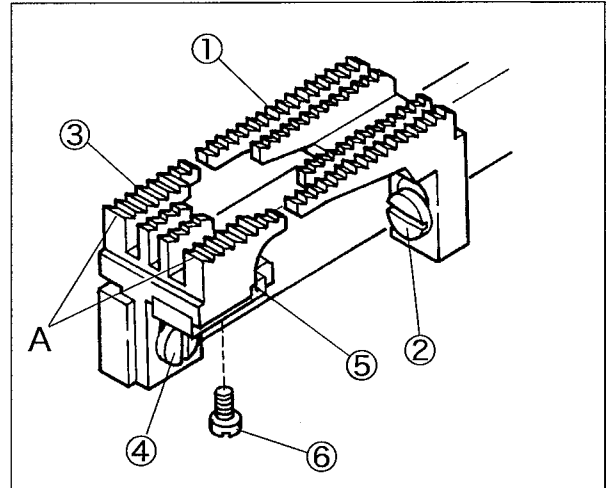


Fig. 6-25

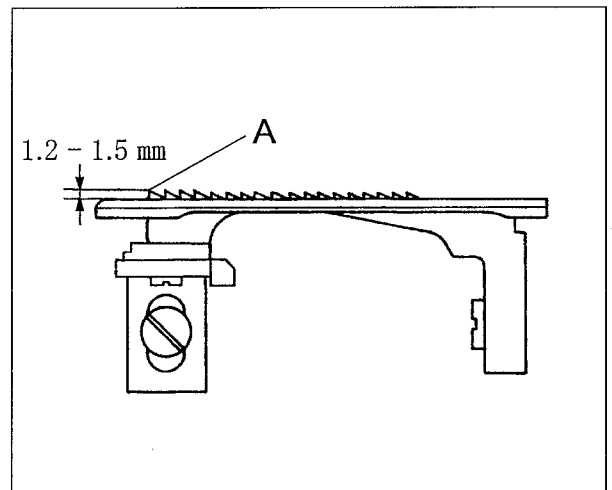


Fig. 6-26

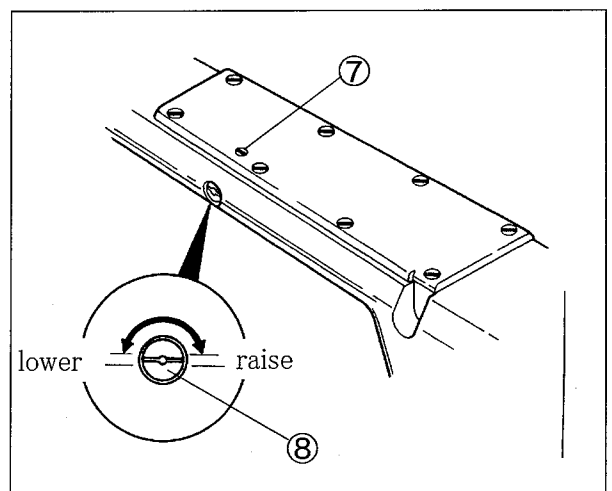


Fig. 6-27

⚠ WARNING

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

6.10 Replacing presser foot

Removing:

- (1) Remove all needles and the seal plug ①.
- (2) Remove the adjusting screw ② and then the screw ③ of the presser bar connecting bracket.
- (3) Loosen the screw ④ of the knife holder guide collar to be free the complete set including the upper knife, the knife holder, and the knife holder shank.
- (4) Loosen two screws ⑦ of the knife holder bracket ⑥ to remove the knife holder guide collar, c. set ⑤ and the upper knife.
- (5) Loosen the screw ⑧ on the back of the presser foot. (on the left side on “-07” and “-12” models: Fig. 6-31)

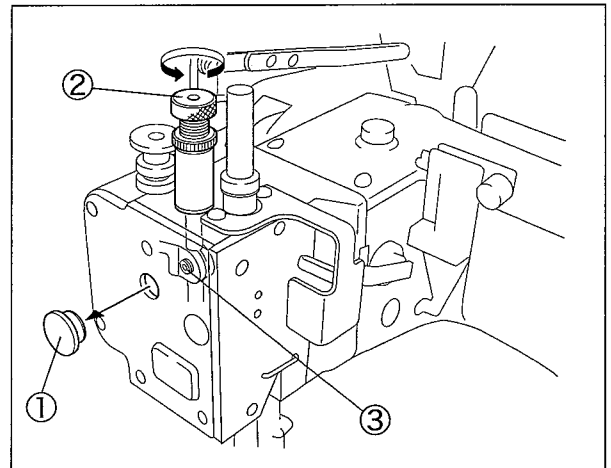


Fig. 6-28

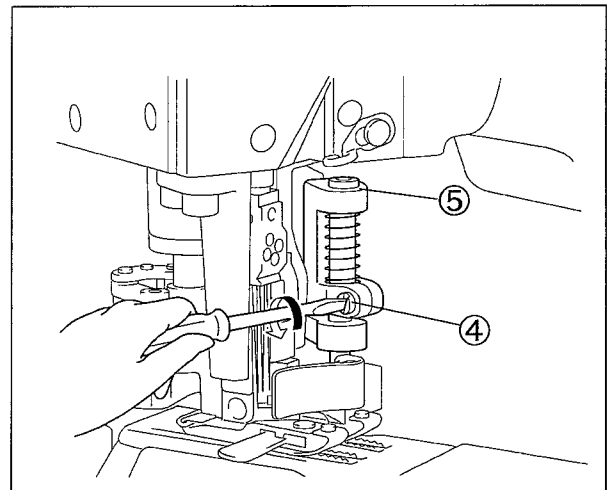


Fig. 6-29

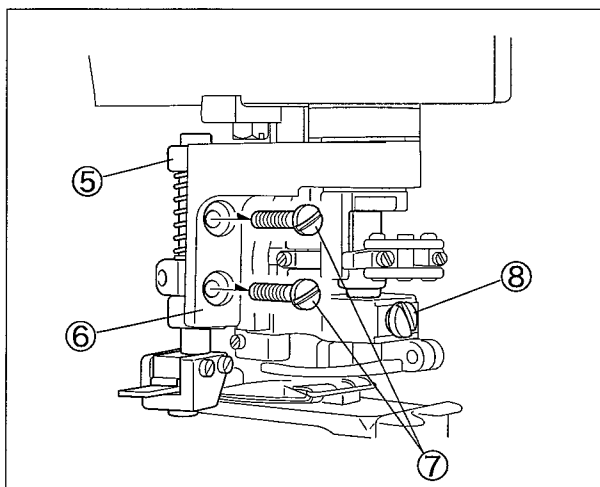


Fig. 6-30

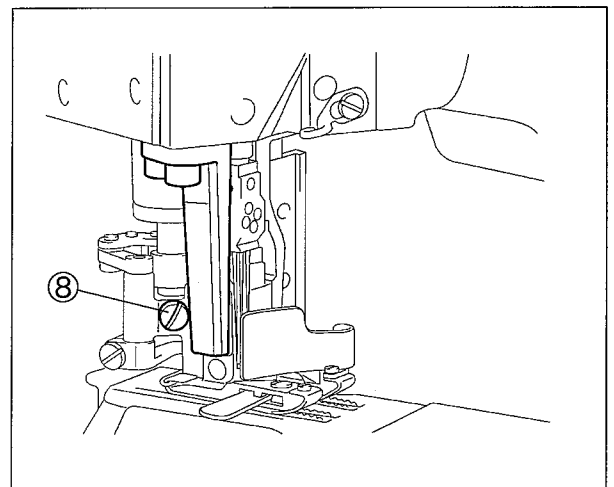


Fig. 6-31

WARNING

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

- (6) Rotate the handwheel to raise the needle at the highest point. Keep the presser bar ⑨ and the presser spring ⑩ upward as they come off from the presser foot.

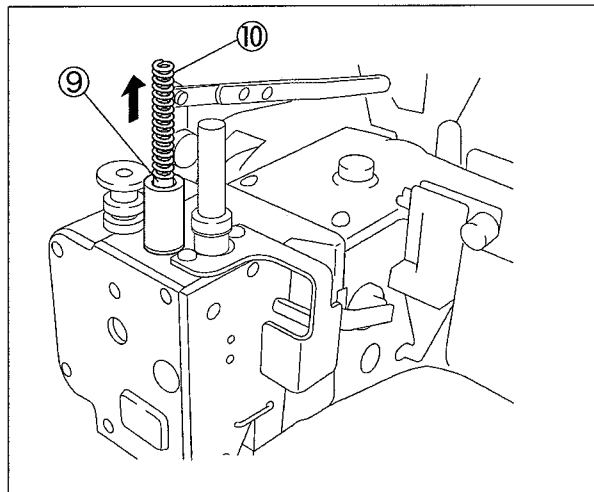


Fig. 6-32

- (7) Remove the carrier/hook driving segment ⑪ from the lever ⑫ on the carrier/hook driving sleeve.

- (8) Turn the presser foot, c. set to the left and remove it through the presser foot guides(left) and (right) backward.

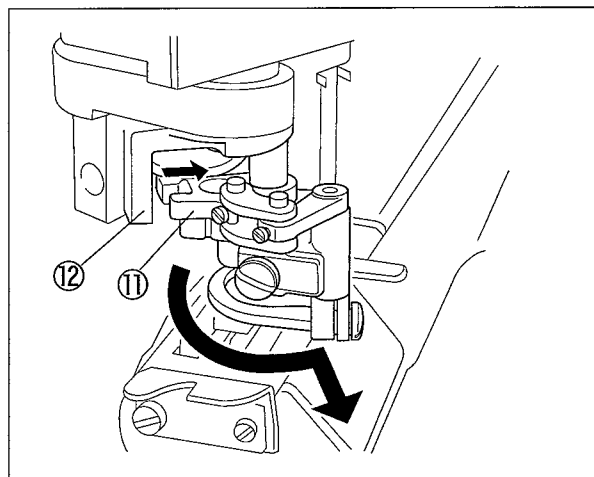


Fig. 6-33

⚠ WARNING

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

Resetting:

Refer to from figs. 6-28 to 6-35 for resetting.

- (1) Remove all needles. Reset the presser foot, c. set between the presser foot guides(left) and (right) while turning it to the right diagonally from the back.
- (2) Reset the carrier/hook driving segment ⑪ on the lever ⑫ on the carrier/hook driving sleeve.
- (3) Insert the presser bar into the carrier/hook driving segment ⑪ and tighten the screw on the back of the presser foot. (on the left side on “-07” and “-12” models)
- (4) Check the presser foot moves smoothly without play right and left. If not, loosen the screw ⑭ of the presser foot guide(left) ⑬ to adjust it.
- (5) Reset the knife holder guide collar, c. set ⑤ and the upper knife on the knife holder bracket ⑥ with two screws.
- (6) Adjust the positions of the knife holder guide collar and the upper knife when the needle is at the lowest point. (See “6.12 Replacing and adjusting knives” .)
- (7) Reset the adjusting screw ② when the needle is at the lowest point and the presser foot touches closely on the stitch plate. Then tighten the screw ③ of the presser bar connecting bracket while pushing slightly down.
- (8) Reset the seal plug ① .
- (9) Reset all needles.

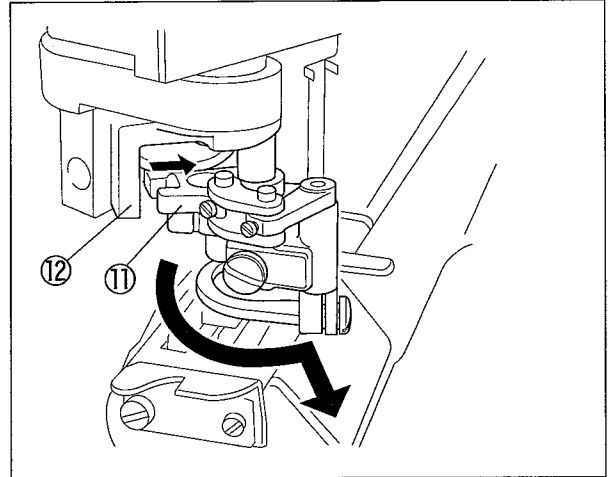


Fig. 6-34

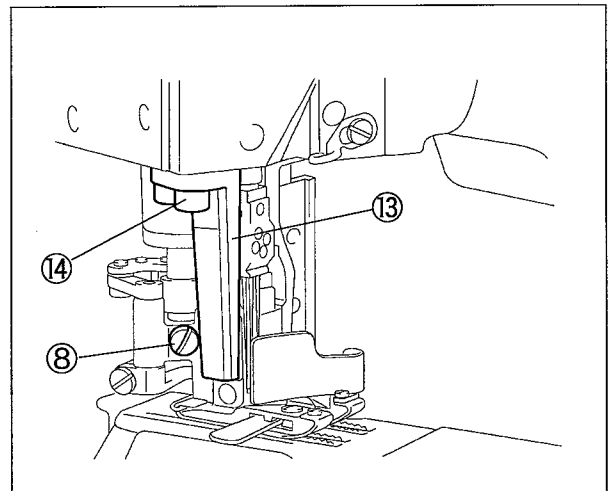


Fig. 6-35

WARNING

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

6.11 Replacing presser foot spring plate

Removing:

- (1) Remove the screws ①.
- (2) Remove the presser foot spring plates ② from the presser foot.
- (3) Remove each plate ② from the spring plate holder ③.

Resetting:

- (1) Reset each presser foot spring plate ② with the spring plate holder ③.
- (2) Reset the plates ② parallel each other on the presser foot.
- (3) Tighten the screws ① securely.

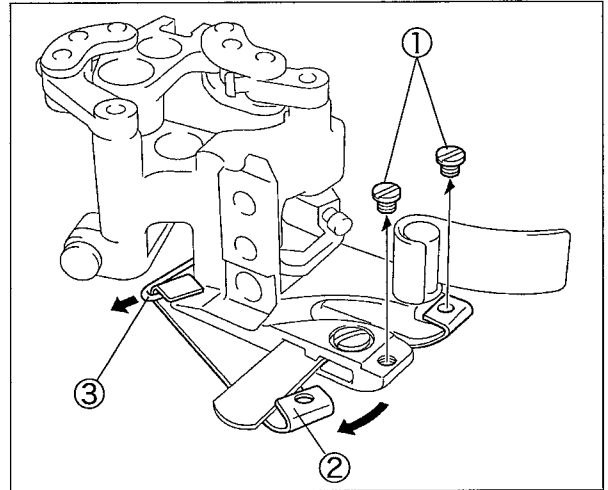


Fig. 6-36

⚠ WARNING

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

6.12 Replacing and adjusting knives

Pressure of upper knife:

When the needle is at the highest point and the upper knife ① is at the extreme left, the presser foot touches the stitch plate, and the upper knife ① touches the lower knife ② closely.

The standard clearance between the bearing of the knife holder shank support ③ and the knife holder guide collar ④ is 1.0 mm.

Loosen the screw ⑤ and move the knife holder guide collar ④ to adjust the pressure.

- To increase the pressure, move the collar ④ upward.
- To decrease the pressure, move the collar ④ downward.

Note: Align the front sides of the upper ① and lower ② knives without touching the upper knife to the presser foot.

After check them, fix the knife holder guide collar ④ with the screw.

Removing:

- (1) Loosen the screws ⑤ and ⑥ to remove the upper knife ①.
- (2) Loosen the screw ⑦ to remove the lower knife ②.

Resetting:

- (1) Reset the lower knife ② with the screw ⑦.
- (2) Reset the upper knife ① with the screw ⑥.
- See "5.9 Adjusting lapped width of upper fabric" for engagement of the knives.
- (3) Adjust the knife holder guide collar ④, referring to above "Pressure of upper knife".

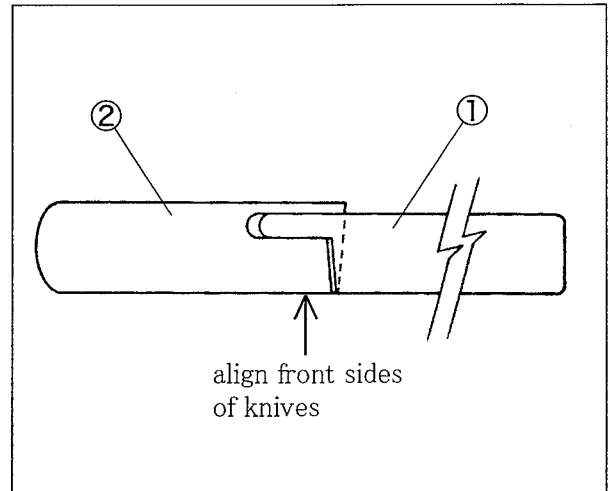


Fig. 6-37

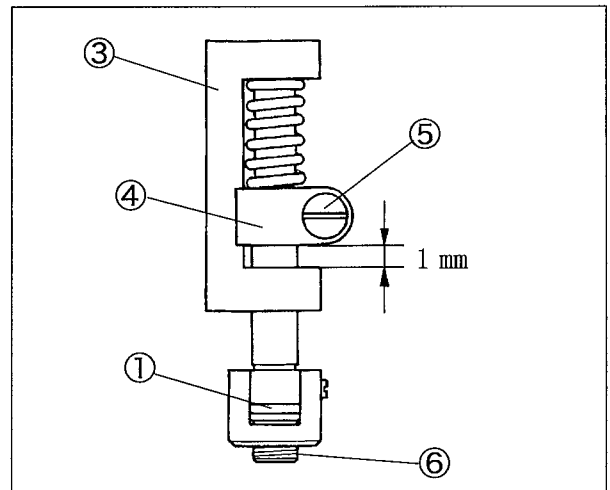


Fig. 6-38

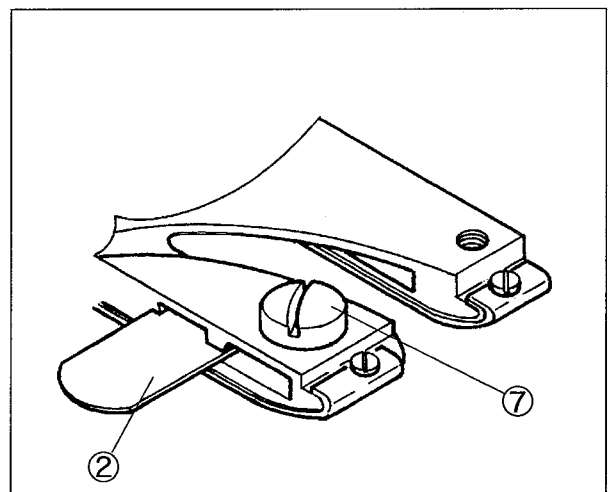


Fig. 6-39

WARNING

Before adjusting, ALWAYS turn the motor switch OFF and check that the motor has already stopped.

Engaging angle of upper knife to lower knife

Remove the parts ① - ⑤ in order and turn the screw ⑥ to adjust it.

When resetting, check the screw ⑦ is not out from the bottom of the knife support ⑤. Then insert it into the bracket hole ⑧ to tighten.

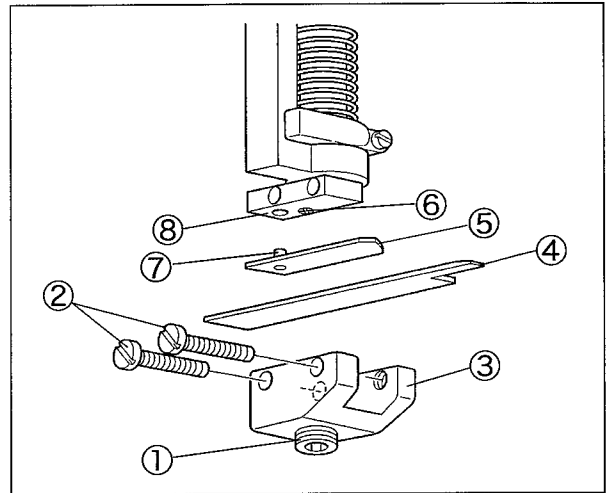


Fig. 6-40

6.13 Presser foot lift

- As standard, make the clearance between the presser bar lifter lever ④ and the fringe of presser bar lifter guide ③ to 1 mm when the presser foot touches the stitch plate closely and the presser bar connecting bracket ⑤ touches the connecting bracket cushion ② closely.

Note: The clearance between the body of the presser foot and the presser foot spring plate has 0.3 mm.

Adjusting:

- Remove the seal plug ⑦, and check the presser bar connecting bracket ⑥ to touch the connecting bracket cushion ② closely.
If not, loosen the screw ⑨ and touch the presser bar connecting bracket ⑤ to the connecting bracket cushion ② closely.
- Loosen the screws ⑩ of the presser foot lifter lever link (long) ⑧.
- Move the presser foot lifter lever link (short) ⑩ right or left to adjust the clearance.

⚠ CAUTION

After adjusting the clearance of the presser bar lifter lever ①, adjust the presser foot lift at the lowest point of the presser bar. (See page 44)

If not adjusted, it can cause damage to the top cover thread hook.

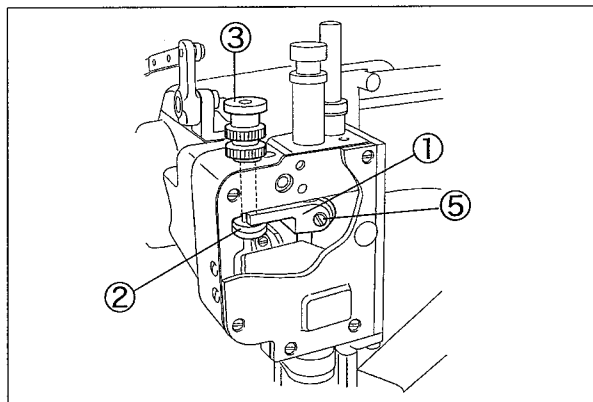


Fig.6-41

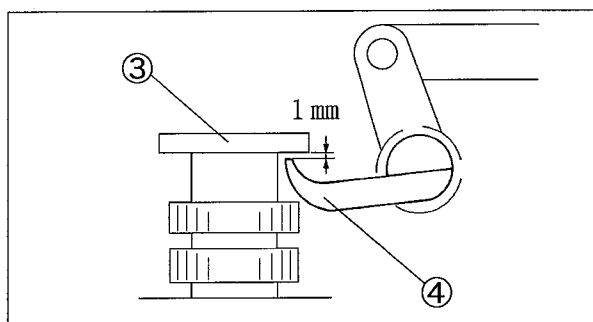


Fig.6-42

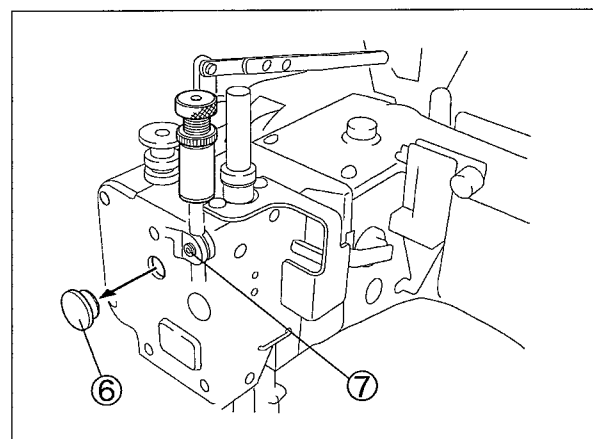


Fig.6-43

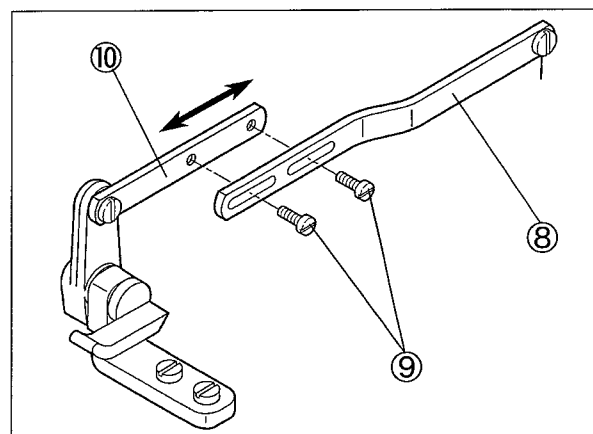


Fig.6-44

6.Adjustments

2. As standard, make the clearance between the notch of the needle clamp ① and the top cover thread hook ② to 0.3 mm when the needle bar is at the lowest point and the presser foot is raised by pressing the presser foot pedal fully.

Adjusting:

- (1) Loosen the lock nut ③.
- (2) Move the presser foot lifter stop plunger ④ in or out to adjust the clearance.

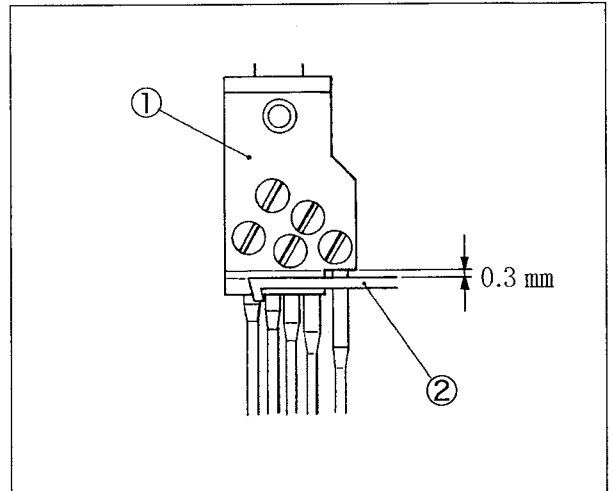


Fig. 6-45

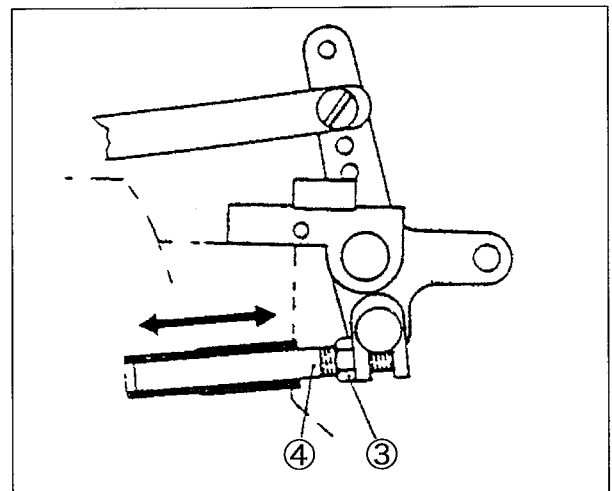


Fig. 6-46

6.14 Tension release unit

As standard, make the clearance between the tension release pins ① and the tension release shaft ③ to 0.5 mm when six tension release pins ① are pushed up slightly and the upper thread tension disc ② starts leaving from the lower thread tension disc without pressing the presser foot pedal.

Adjusting:

- (1) Loosen the screw ④ of the presser bar lifter lever (large).
- (2) Turn the tension release shaft ③ with a screwdriver.
 - To decrease the clearance, turn it clockwise.
 - To increase the clearance, turn it counterclockwise.

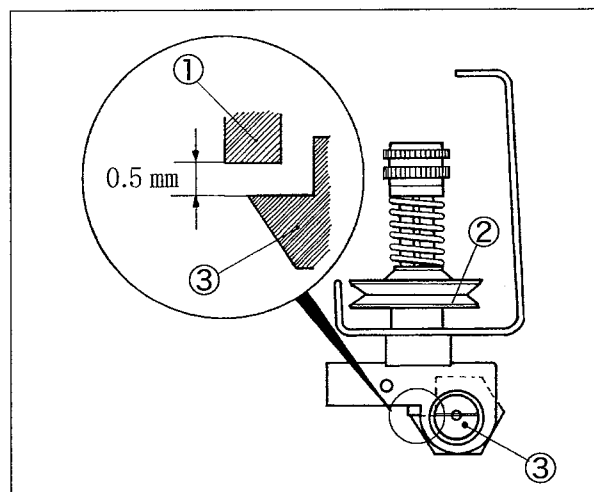


Fig.6-47

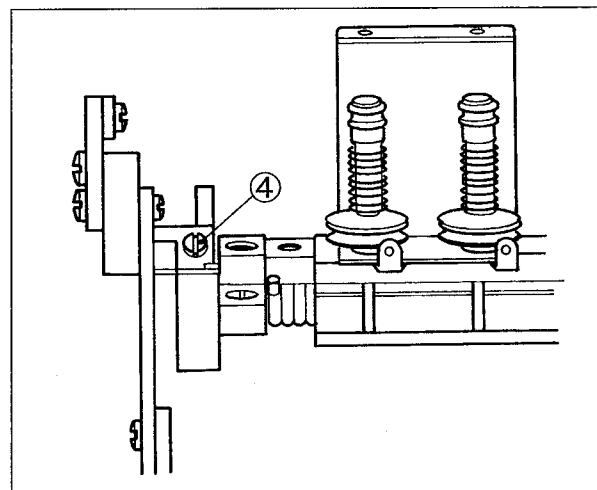


Fig.6-48

7. Specifications

Model	FD-62DRY
Description	High speed feed-off-the-arm flatseamer (semi-dry)
Dimensions	420 mm (L) × 300 mm (W) × 410 mm (H)
Circumference of Cylinder	148 mm at needle drop
Working Space	Cylindrical shape of 210 mm in front of needle drop
Weight	23 kg (machine head only)
Stitch Type	ISO 410, 605, 607
Application	Refer to below table
Sewing Speed	Up to 4200 rpm, 3800 rpm in usual
Stitch Length	1.6 - 2.5 mm The number of stitches 10 - 16 stitches per inch(25.4 mm) 12 - 19 stitches per 30 mm
Needle System	Sewing needle: Organ FL×118GCS, Groz-Beckert UY118GKS Retainer needle: Organ FLG-1, FLF-8 (with scarf) Groz-Beckert 36211, 36211A (with scarf)
Needle Distance	R: 5.2 mm (13/64 inches) S: 6.0 mm (15/64 inches)
Presser Foot Lift	01, 03, 15: Max. 8 mm, 06, 07, 12: Max. 6 mm at the highest point of needle clamp
Feed Regulation	By lever
Differential Ratio	Max.normal differential: 1.0:1.5 Max.reverse differential: 1.0:0.7
Differential Feed Regulation	By dial
Knives of Fabric Cutting	Both upper and lower knives made of special steel
Lubrication	Automatically by gear pump
Lubricating Oil	YAMATO SF OIL No.68
Capacity of Oil Reservoir	Frame: about 100 cc Cylinder: about 100 cc
Compliance with Regulation	Compliant with the PL Law and the CE Marking

Model	Application
-01	4-needle 6-thread flat seaming for knitted or woven fabric on light to medium weight, cutting one side fabric edge
-03	4-needle 5-thread lapping sewing for attaching tape on front placket of brief, cutting one side fabric edge, without spreader
-06	4-needle 6-thread flat seaming on crotch of brief (with stepped gauge on knife apart), cutting both sides fabric edges
-07	4-needle 6-thread flat seaming for light weight, cutting both sides fabric edges
-12M	4-needle 6-thread flat seaming for knitted or woven fabric on light weight, cutting both sides fabric edges
-12H	4-needle 6-thread flat seaming for knitted or woven fabric on medium to heavy weight (with wide knife), cutting both sides fabric edges
-15	Flat seaming for small stitch length on swimwear, and flat seaming for knitted or woven fabric on light to medium weight, cutting one side fabric edge



4-4-12,NISHITENMA, KITA-KU, OSAKA,JAPAN
TEL : 81-6-6364-5621 FAX : 81-6-6364-7185

〒530-0047 大阪市北区西天満4丁目4番12号
TEL(06)6364-5621(代) FAX(06)6364-7185