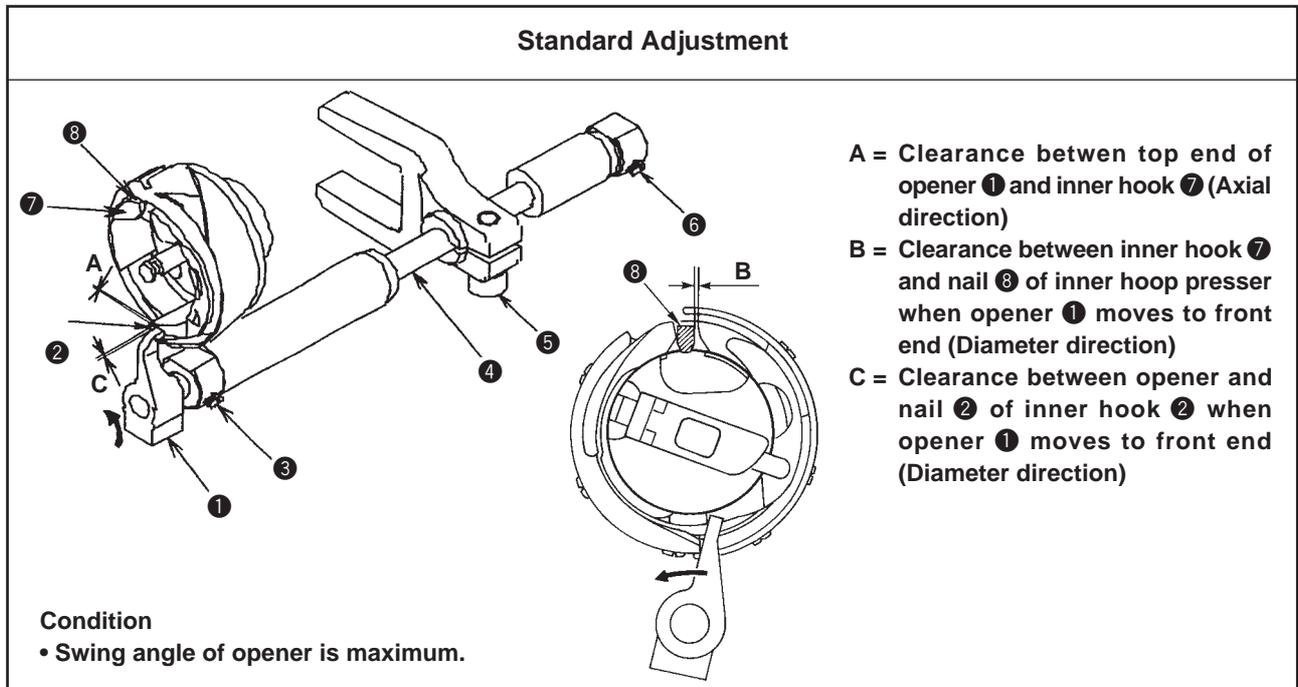
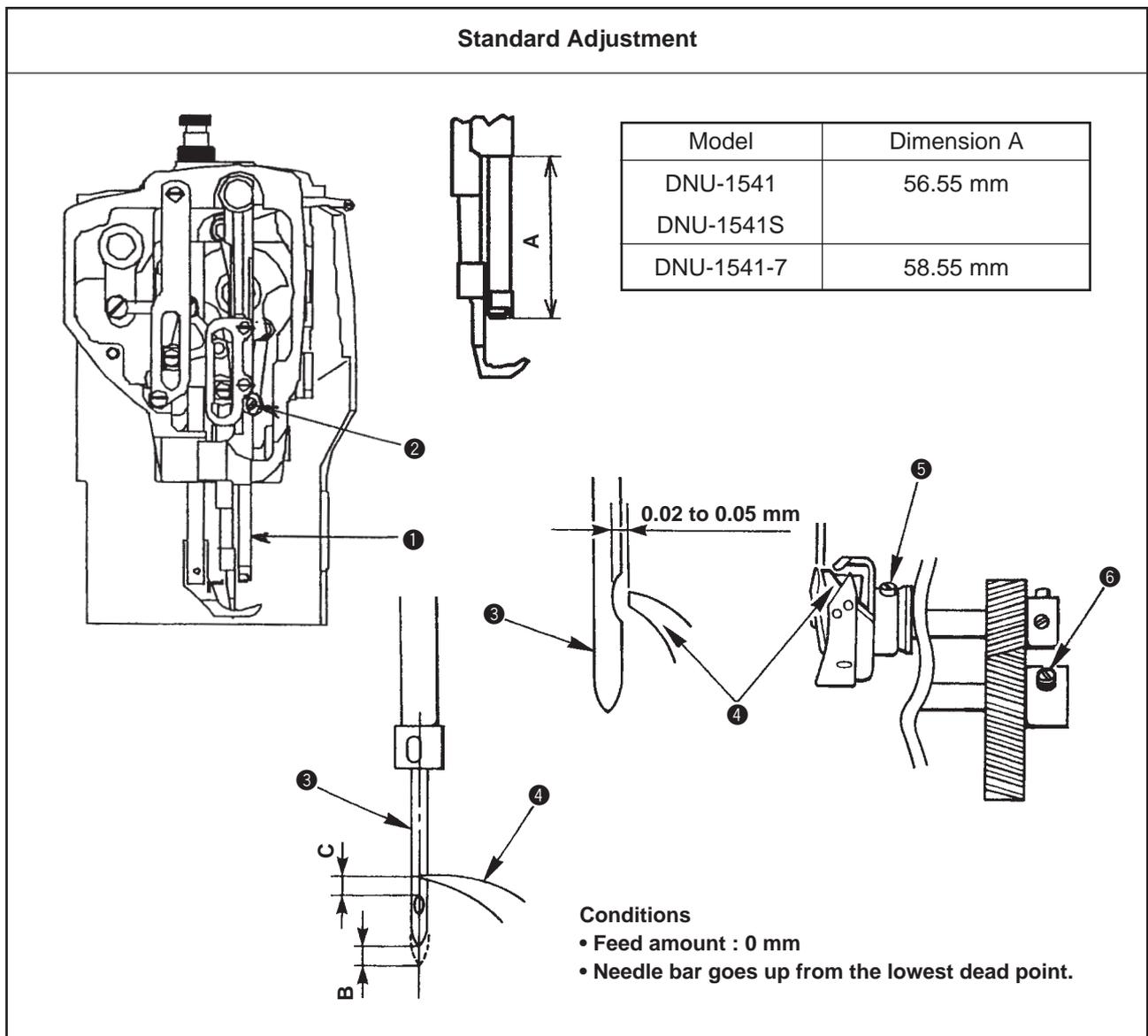


(5) Adjusting the opener (DNU-1541S)



(6) Needle-to-hook timing



Adjustment Procedures	Results of Improper Adjustment
<p>Timing of the opener</p> <ol style="list-style-type: none"> 1. Turn the handwheel to move the opener ❶ to the front end in the direction of the arrow mark. 2. Loosen clamping screw ❺ in the opener arm and turn opener shaft ❷ to adjust the clearance B to $B = 0.4^{0}_{-0.15}$ mm in the state that opener ❶ comes in contact with nail ❸ of inner hook. Then tighten the clamping screw. (Reference : C = 0.8 mm) <p>(Standard) Screw No. 2 of the opener cam faces almost directly below at the lowest dead point of the thread take-up.</p> <p>Adjusting the position of the opener</p> <ol style="list-style-type: none"> 1. Loosen setscrews ❸ and ❹ in the thrust collars of opener shaft. 2. Move the opener shaft and adjust the clearance A to $A = 0.8 \pm 0.15$ mm. Then tighten the setscrews. <p>(Caution) Tighten the screws so that the opener shaft ❷ has no thrust play.</p>	<ul style="list-style-type: none"> ○ Poorly tensed stitches will result.

Adjustment Procedures	Results of Improper Adjustment
<p>Standard of the lowest dead point of the needle bar</p> <ol style="list-style-type: none"> 1. Set the scale of stitch dial to "0". 2. Turn the handwheel to bring needle bar ❶ to the lowest dead point of its stroke. 3. Loosen the setscrew in the face plate to remove the face plate. 4. Loosen clamping screw ❷ in the needle bar bracket. At this time, if the screw is fully loosened, needle bar ❶ falls. Loosen the screw to such an extent that needle bar ❶ is moved up or down by hand. 5. Adjust the distance from the bottom end of the needle bar frame to the bottom end of the needle bar to the dimension A, and tighten the clamping screw. (For DNU-1541-7, there is a marker line engraved on needle bar ❶.) <p>Timing between the needle and the blade point of the hook</p> <ol style="list-style-type: none"> 1. Set the scale of stitch dial to "0". 2. Loosen clamping screw ❷ in the needle bar bracket, turn the handwheel, and adjust so that the distance from the top end of needle eye in needle ❸ to blade point ❹ of the hook to 2.0 ± 0.2 mm (C) when needle bar ❶ is raised by 2.15 ± 0.15 mm (B) from its lowest dead point. Then retighten the screw. (For DNU-1541-7, there is a marker line engraved on needle bar ❶.) 3. Turn the handwheel to raise the needle bar by 2.15 ± 0.15 mm (B) from its lowest dead point. Loosen hook setscrews ❺ and adjust so that blade point ❹ of the hook almost aligns with the center of the needle ❸. Then retighten the screws. For DNU-1541S, loosen setscrews ❻ in the lower shaft gear to perform the adjustment. Then retighten the screws. 4. Loosen hook setscrews ❺, move the hook to the left or the right and adjust so that a clearance of 0.02 to 0.05 mm is provide between blade point ❹ of the hook and needle ❸ at the position where blade point ❹ of the hook almost aligns with the center of needle ❸. Then securely tighten the screws. 	<ul style="list-style-type: none"> ○ Stitch skipping or thread breakage will result. ○ Poorly tensed stitches will result.