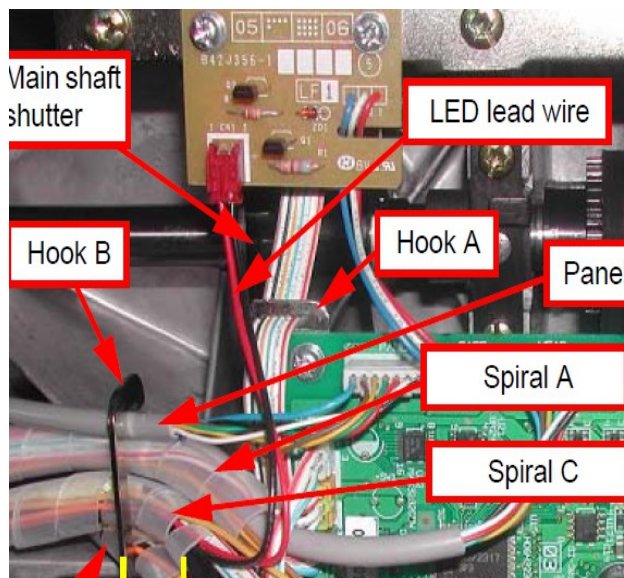
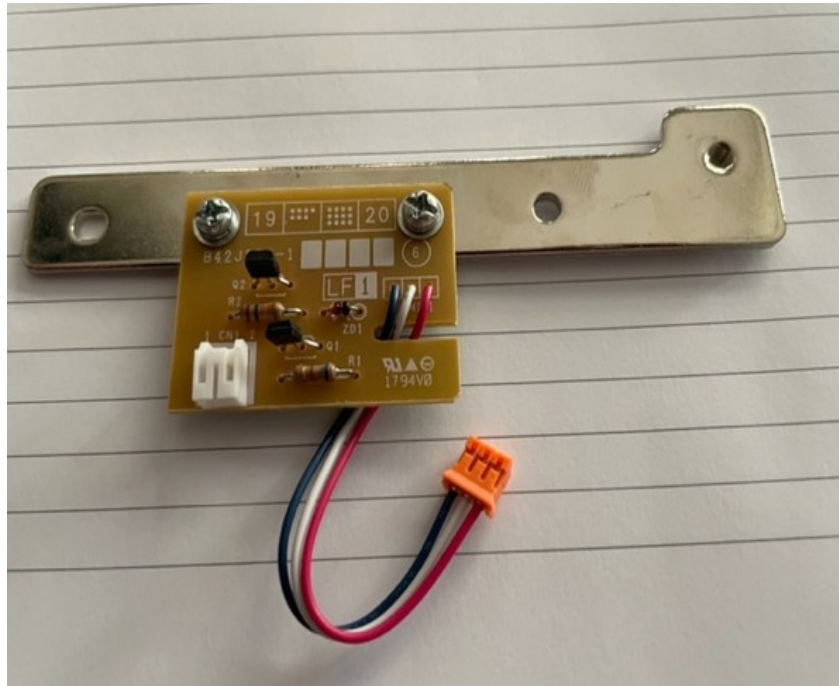


## KIT GRUPPO LED PR600/PR600II/PR620/PR650/PR650e

QUESTA PIASTRA/SCHEDA VA POSIZIONATA SOPRA LA SCHEDA PRINCIPALE :



PR600... non essendoci nulla è una scheda da aggiungere.

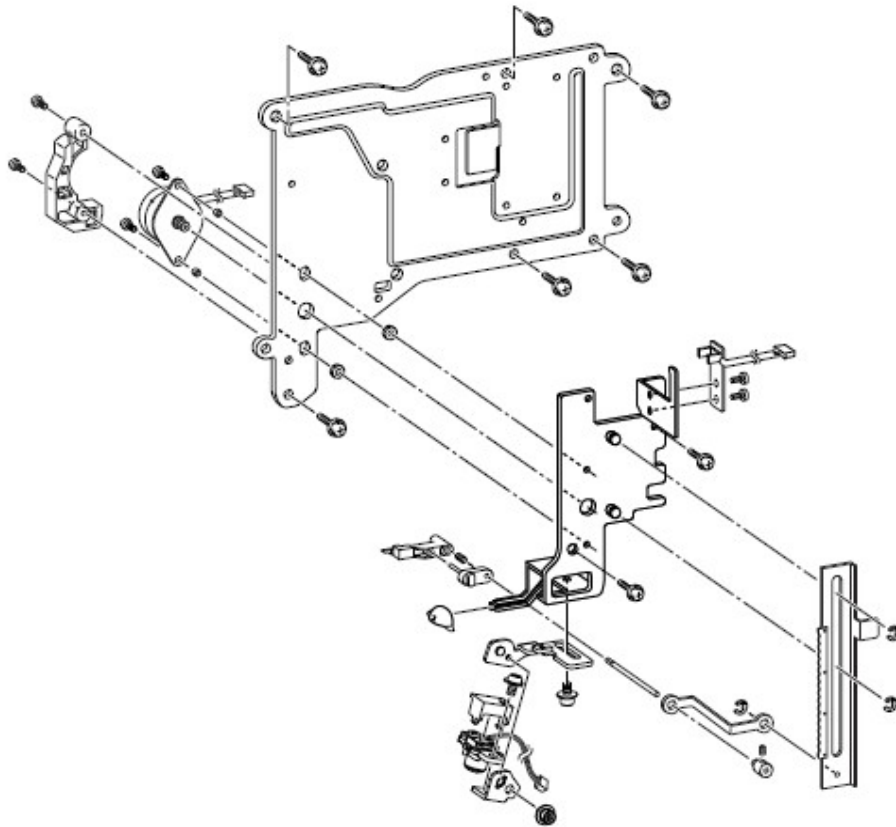
PR600II/PR620...sostituire la scheda presente con quella del kit ed eliminare il cavo/kit luce presente(sarà di conseguenza perchè sostituendo la piastra porta infilago non ci sarà spazio di montarli entrambi).

PR650/PR650e... sostituire la scheda presente con quella del kit ed lasciare libero il cavo delle luci (purtroppo , avendo solo un connettore , lo si utilizzerà per il puntatore LED).

## SOSTITUIRE LA PIASTRA PORTA INFILAGO

Main unit	Needle thread unit
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Needle thread unit



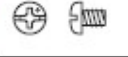


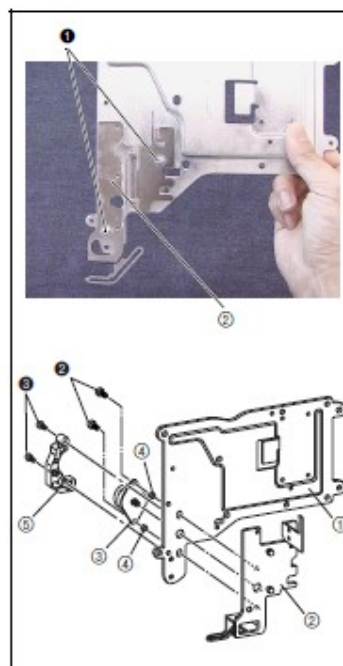
## 1 TH motor assembly attachment

1. Attach the base plate assembly ② to the thread guide base ① with the 2 screws ①.

### \*Key point

- Firmly tighten the 2 screws ① after completing 4 - 27 "Needle threader (up/down)."
2. Attach the TH motor assembly ③ and the 2 spacers ④ to the base plate assembly ② with the 2 screws ②.
  3. Paint the thread motor's connector red.
  4. Attach the lead wire guide ⑤ to the thread guide base ① with the 2 screws ③.

①		Screw, Pan (SP washer) M4X8	Torque Hand start
②		Screw, Pan M3X6	Torque 0.78 — 1.18 N·m
③		Screw, Pan M3X4	Torque 0.78 — 1.18 N·m




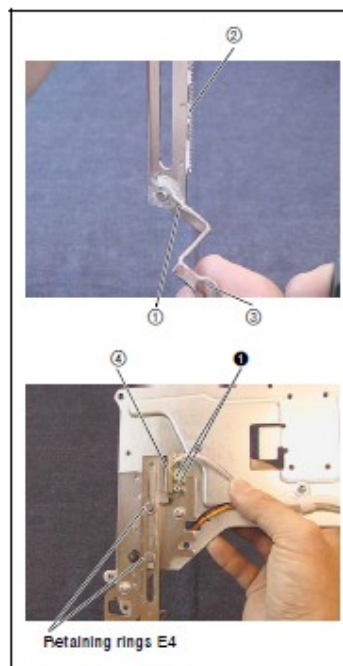
## 2 Rack assembly and hook holder link attachment

1. Attach the hook holder link ① to the rack assembly's shaft, and then attach the retaining ring E3.
2. Apply MOLYKOTE EM-30L to the gear face ② and the connecting face on the rack assembly, and the hook holder shaft attachment hole ③ on the hook holder link ①.
3. Attach the rack assembly to the base plate assembly's 2 shafts, and then attach the 2 retaining rings E4.
4. Attach the needle thread sensor assembly ④ to the base plate assembly with the 2 screws ①.

Apply MOLYKOTE EM-30L to the gear face and the connecting face on the rack assembly, and the hook holder shaft attachment hole on the hook holder link.

Size of a grain of rice

①		Screw, Pan (SP washer) M3X6	Torque 0.59 — 0.78 N·m
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### 3 Hook assembly

1. Attach the bush ② to the hook holder axis B ① with the screw ③.

#### \*Key point


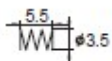
- Temporarily tighten the screw ③ first. Firmly tighten it after completing 4 - 29 "Needle threader (left/right)".

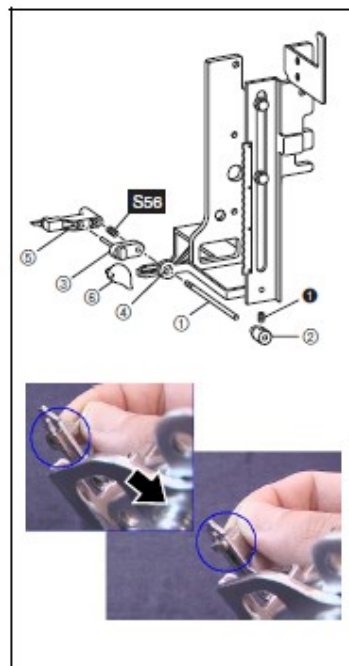
2. Attach the set collar assembly ④ to the base plate assembly.

#### \*Key point

- Thread the set collar assembly through the slot on the base plate, and turn it 90 degrees.




3. Thread the hook holder axis B assembly through the hole ④ on the hook holder link, the groove on the base plate assembly, the set collar assembly ④, and the spring S56, and then attach the hook holder assembly ⑤ to the hook holder axis B assembly and the set collar assembly's axis.
4. Attach the cap ⑥ to the tip of the slot on the base plate assembly.

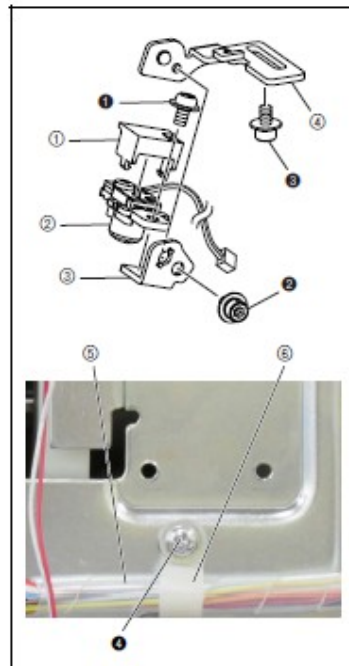
①		Set Screw, Socket (CP) M3X3	Torque Hand start
S56		5.5 3.5 HOOK HOLDER SPRING XC7375***	



### 4 LED pointer attachment

1. Attach the PT guard cover ① to the light source assy ②.
2. Attach the light source assy ② to the LED lens holder plate ③ with the screw ④.
3. Attach the LED lens holder plate ③ to the LED PT base plate ④ with the screw ⑤.
4. Attach the LED PT base plate ④ to the base plate assembly with the screw ⑥.
5. Attach the light source assy's lead wire to the lead wire guide.
6. Attach the spiral tube ⑦ to the lead wires.
7. Set the cord clamp ⑧ to the lead wires, and then attach the cord clamp ⑧ with the screw ④.

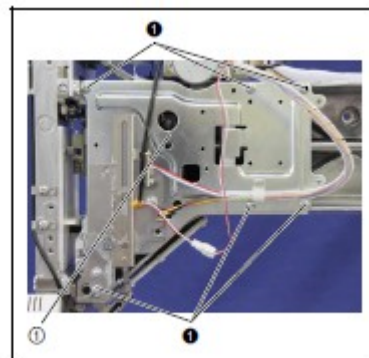
①		Socket, Pan (SP washer) M3X5	Torque 0.59 - 0.78 N-m
②		Set screw (SP washer) 3X5	Torque Hand start
④		Socket, Pan (SP washer) M4X10	Torque 1.18 - 1.67 N-m



### 5 Needle thread assembly attachment

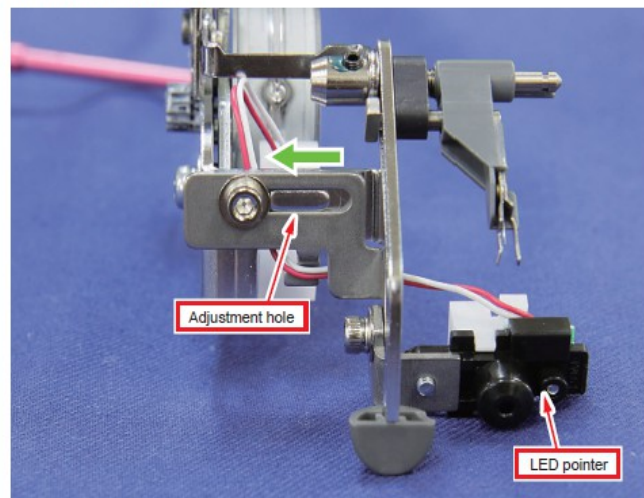
1. Attach the needle thread assembly ① with the 6 screws ②.

①		Tapite, Blind S M4X10	Torque 1.47 - 1.96 N-m
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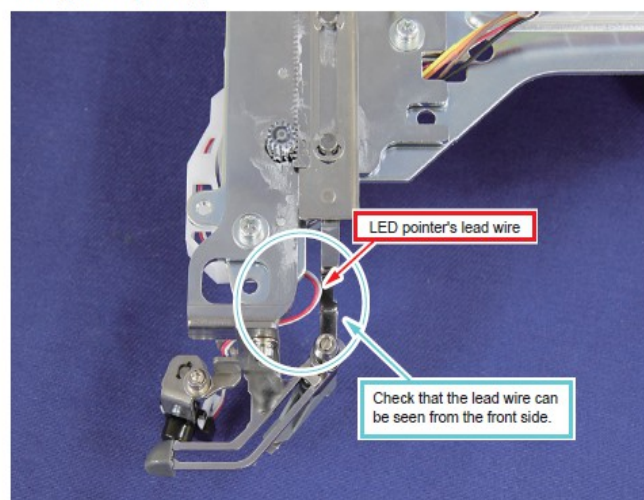




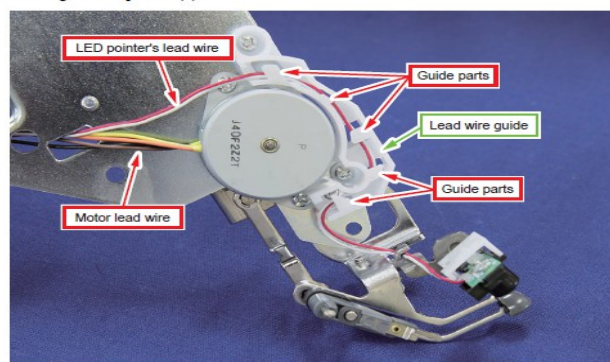
1. Wiring of LED pointer (1)



2. Wiring of LED pointer (2)



3. Wiring of LED pointer (3)



COME REGOLARE LA POSIZIONE DEL PUNTATORE LED

## [Standard]

The needle drop point is within a radius of the LED pointer beam.

## [Adjustment]

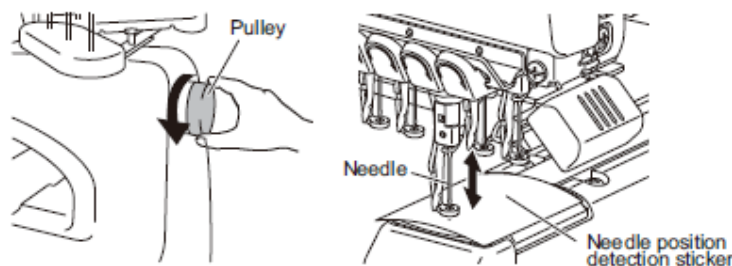
1. Turn OFF the power switch.
2. Attach the needle position detection sticker so that the needle hole on the needle plate will be completely covered.

**\*Note**

- Needle position detection sticker is an optional accessory.

XE7916001	Needle position detection sticker
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3. Turn the pulley by hand to pierce the needle position detection sticker by the needle point.



4. Start the test mode and select [#39 LED Pointer Check] under [PANEL BOARD TEST MODE].
5. Press [ON] on the screen to turn ON the light of the LED pointer.
6. Check the position of the LED pointer.

**\*Key point**

- Make sure that the center of the pointer is positioned 0.2mm forward from the center of the needle drop position. (Fig.1)
- Positions of LED pointer and needle point must be matched on the cloth surface (1mm above from the needle plate).

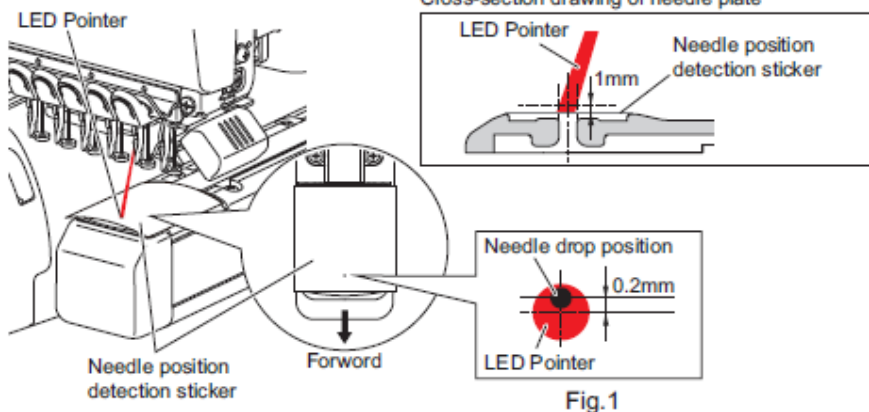
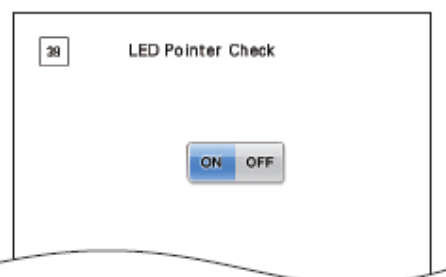


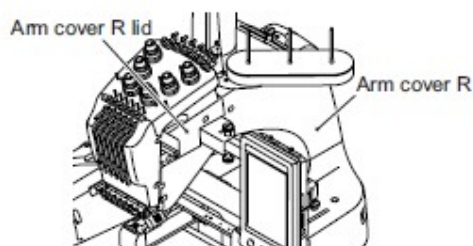
Fig.1

To next page

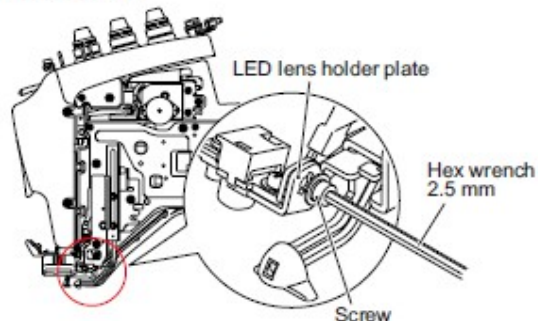
- When the needle drop point is not matched with the pointer beam, adjust the LED pointer position by following procedures below.

#### [Adjustment]

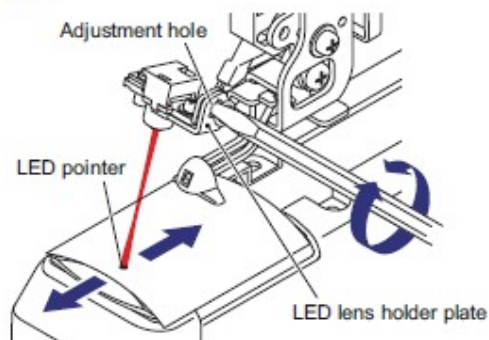
1. Remove the arm cover R lid and arm cover R.



2. Loosen the screw of the LED lens holder plate.



3. Insert the flat-blade screwdriver into the adjustment hole on the LED lens holder plate. Adjust the LED pointer position by turning the flat-blade screwdriver.



4. Tighten the screw of the LED lens holder plate.
5. After the adjustment, set the frame with a cloth attached and check if the needle drop point on the cloth is matched with the LED pointer position.

#### \*Note

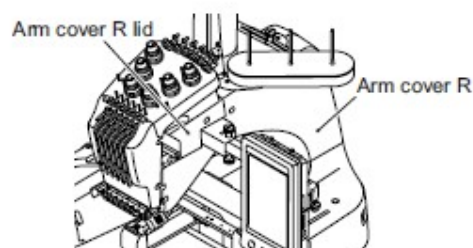
- Depends on the thickness of cloth, the LED pointer position could slightly deviate from the needle drop point.

To next page

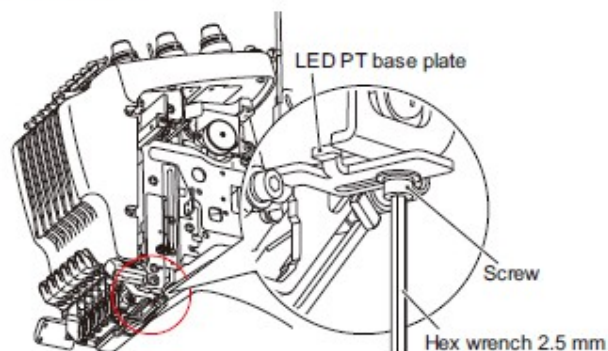
- When the LED pointer deviates to the left or right of the needle drop point

[Adjustment]

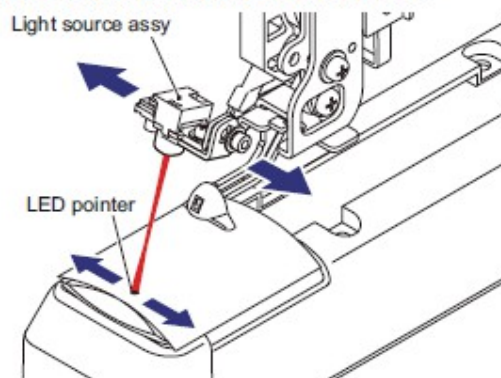
1. Remove the arm cover R lid and arm cover R.



2. Loosen the screw of the LED PT base plate.



3. Move the light source assy to the left and right to adjust the LED pointer position.



4. Tighten the screw of the LED PT base plate.  
5. After the adjustment, set the frame with a cloth attached and check if the needle drop point on the cloth is matched with the LED pointer position.

**\*Note**

- Depends on the thickness of cloth, the LED pointer position could slightly deviate from the needle drop point.