

4800 SEWING ISSUES PROPOSED SOLUTIONS

AAC 7/19/13 PBD

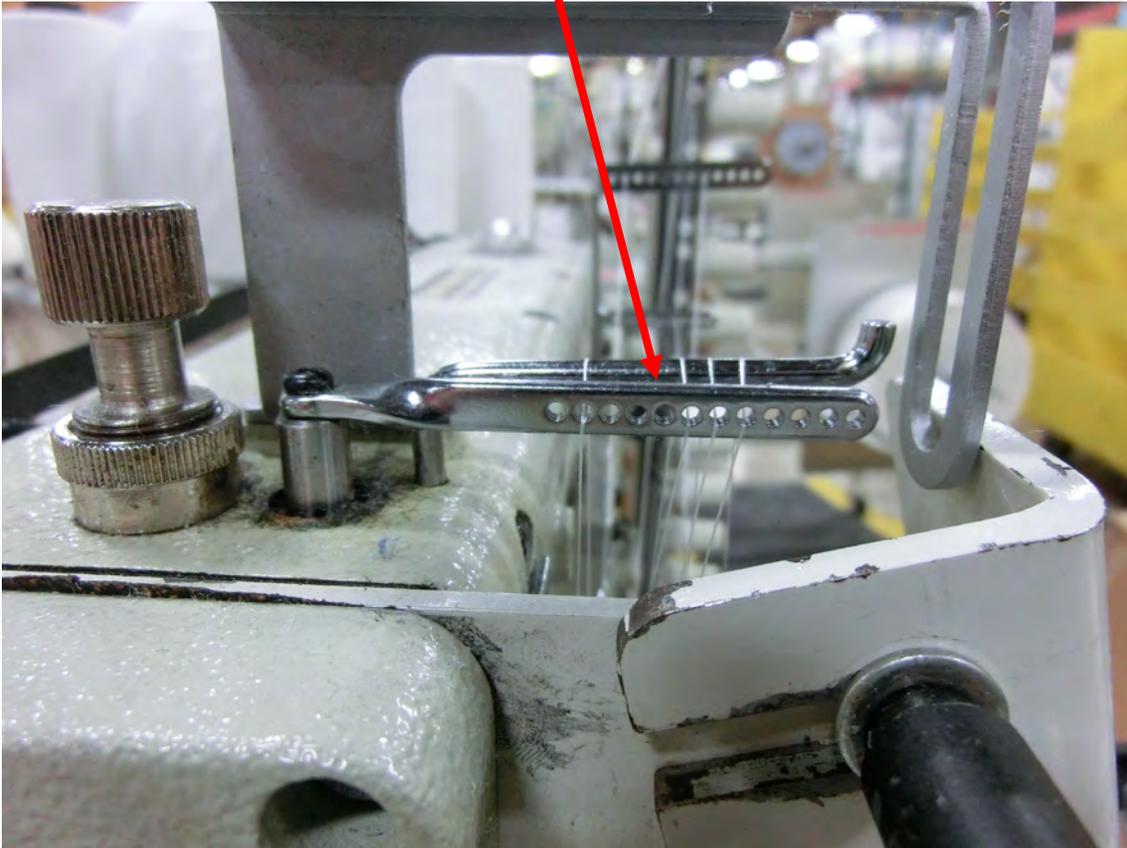
To compensate for the thickness of the cord with respect to thread pull-off we relocated the needle thread eyelets with the long eyelet mount on the left side and set at its highest position. Only the two threads for the cord go through this eyelet. The short eyelet was moved to the right side and only the two threads for the tape go through it. It is set at its lowest position.



Cord threads

Tape threads

The needle thread guard is position so at needle bottom dead center the center of the guard is even with the top of the needle thread eyelet. This setting controls needle loop formation.



Needle and looper timing are set at normal manufacture recommended sewing settings.

Replace standard needle clamp with modified clamp 1975C40001M. Back is cut out to clear presser foot shank when splices pass through.

Replace throat plate with revised plate 4600040A with longer needle slots.

Reset the sewing parameters to AAC defaults:

110 = 390

111 = 3000

Reset the puller parameters to AAC defaults:

110 = 70

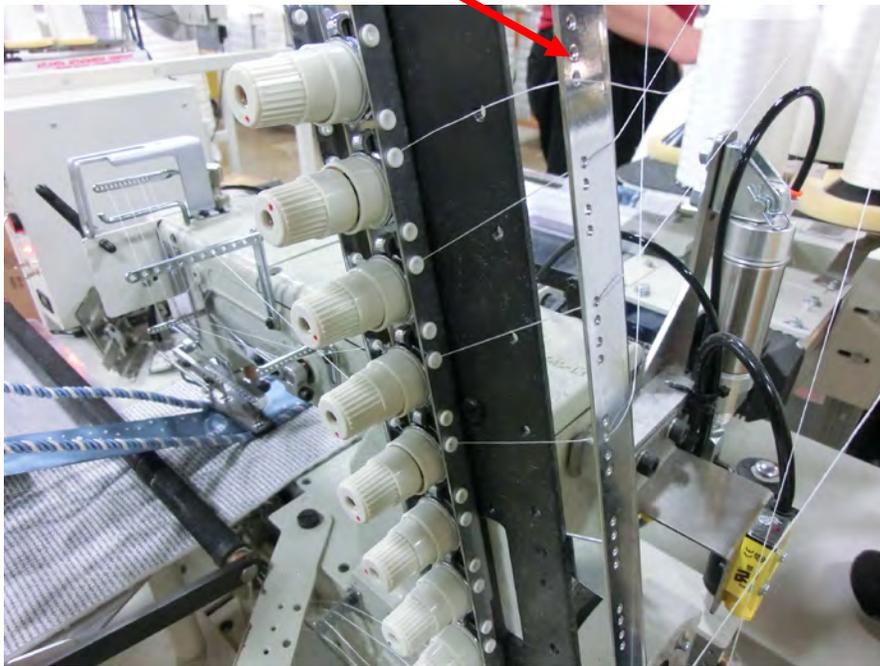
111 = 800

CAUTION:

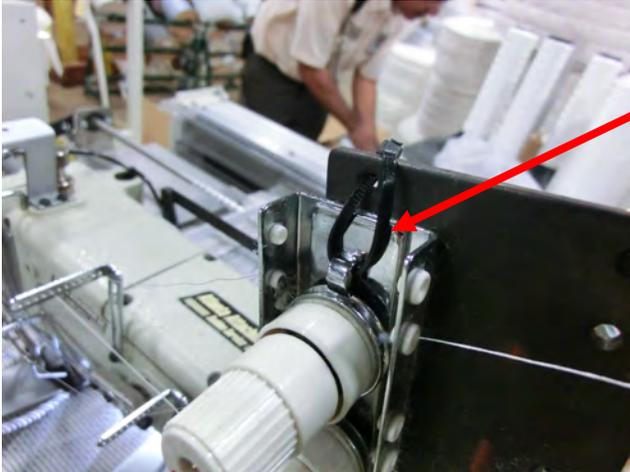
When the machine is **first run after a power on** it is very important to first quickly tap the manual sew pedal to make one manual stitch. The sewing motor needs this to calibrate itself after a power off. Failure to do this can cause the needles to jam in a down position because the puller is running normal but the first stitch after a power on is always at positioning speed. If the needles jam, **ALWAYS** turn off power, manually turn the handwheel to raise the needles, then re-apply power and use the above technique to restore proper sewing operation.

If the above starting technique is followed, you can change the puller acceleration parameter 220 from 1 to 5 and get a quicker puller response time when starting.

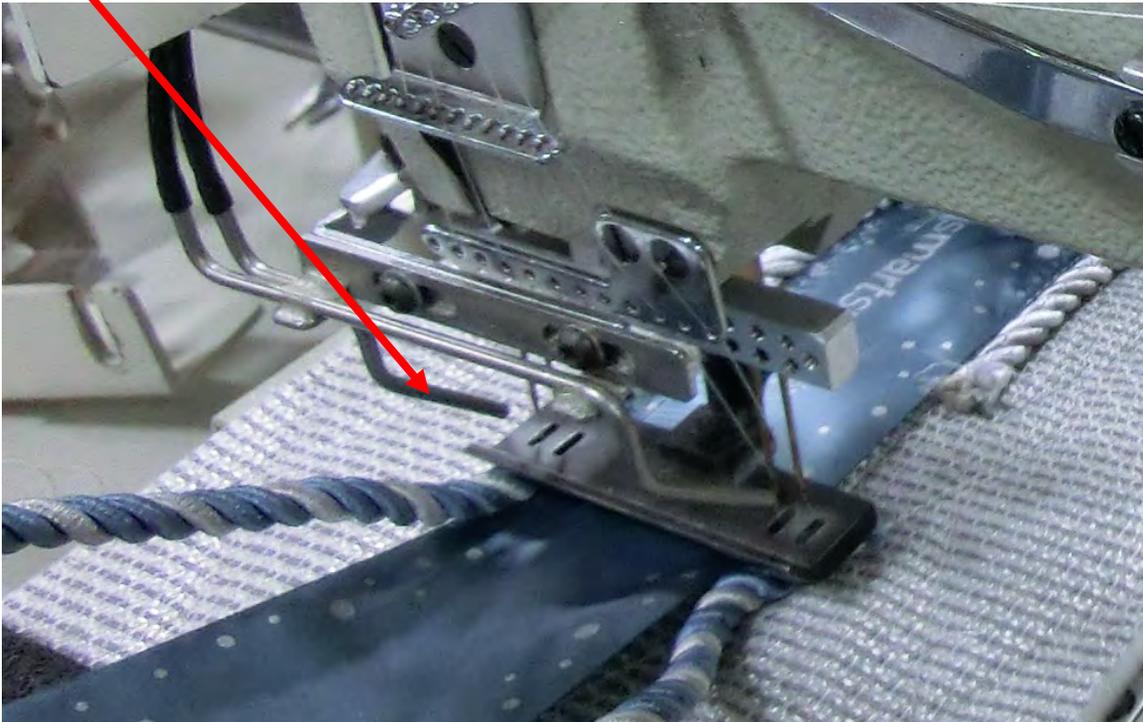
All threads at the tensions should not be wrapped around eyelet edge, but pass straight through a single eyelet hole.



The tension opener for the thread tensions is not connected to its operating lever because the tensions were moved to make room for the zig-zag capabilities of the machine. As a result, the tension opener is resting against the tension disc and may be preventing the tension springs from operating properly. You need to tie the tension opener up with a heavy wire or cable tie as shown and readjust any tensions that have excessive tension settings.



Check the needle cooler tubes and be sure they are blowing directly on the two cord needles.



Cut a disc out of panel fiber material and sandwiched it between the outer aluminum disc and the outer roll of cord to provide some tension friction that will be a little more repeatable than just pressing the disc tight against the cord spool.



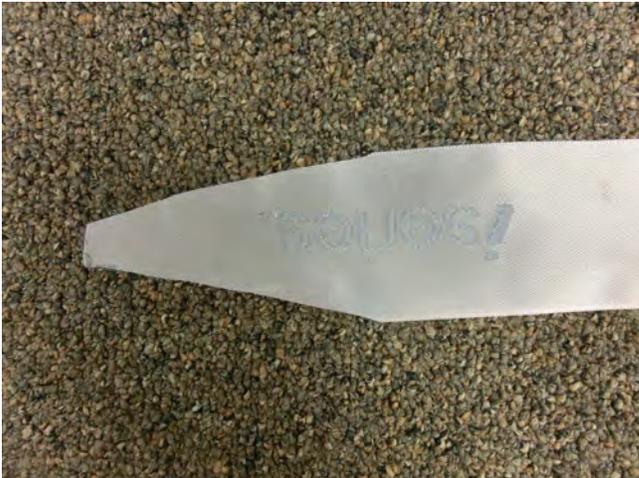
When you get down to the last few layers of the cord it starts to really knot up. We recommend stopping the machine at this time and unroll the rest of the cord from the spools. This will help eliminate the excessive knotting.



We removed the stainless steel eyelet plate from the top of the tape guide to make it a little easier to insert new cord. It also gives the cord more wiggle room without trapping knots and causing jams. It is necessary to add washers so the screws will tighten properly.

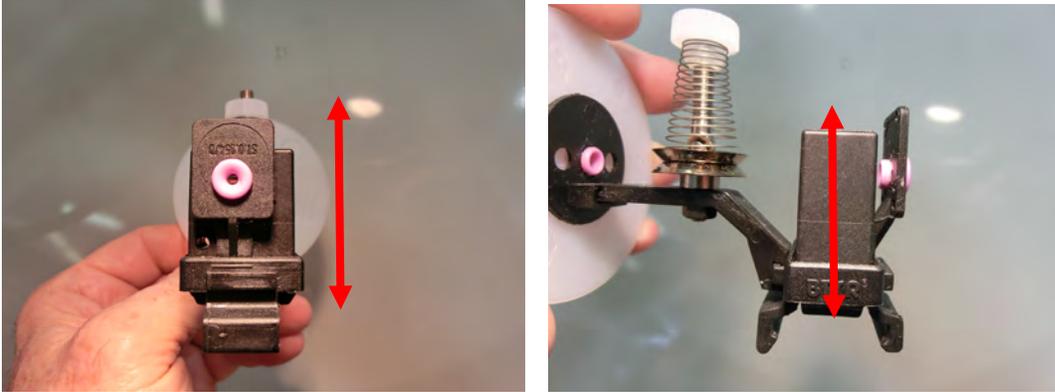


When inserting new tape, cut the tape end to a long point and insert into tube under the old tape end. With a little feeding help, it should sew through with the manual pedal.

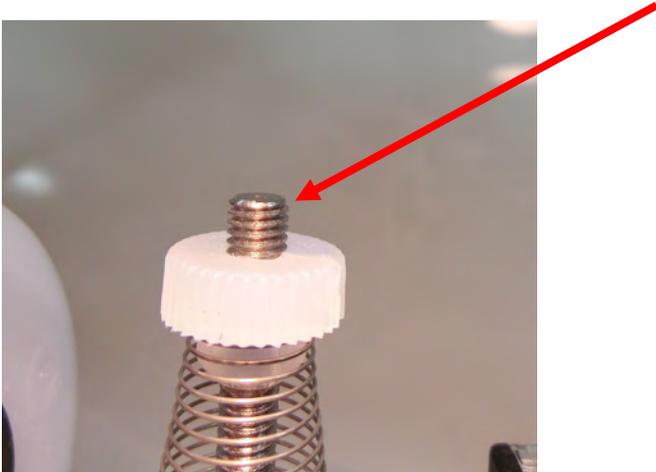


Check thread break sensors for proper adjustment and assembly condition.

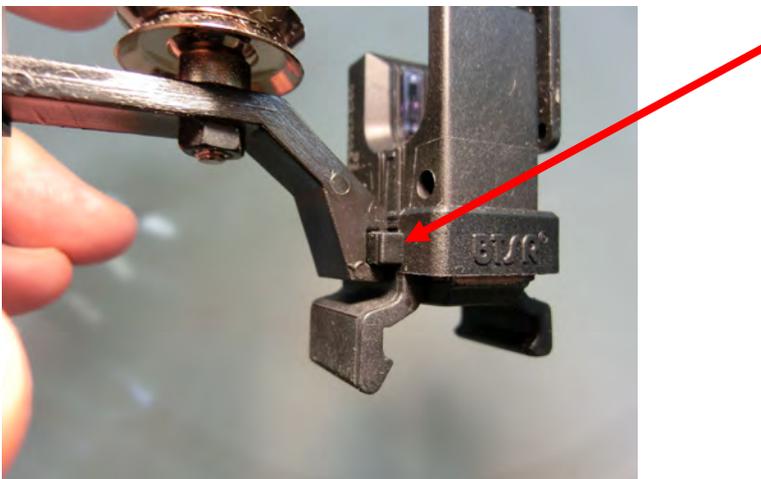
Sensor must be mounted straight in its holder. This is critical!!



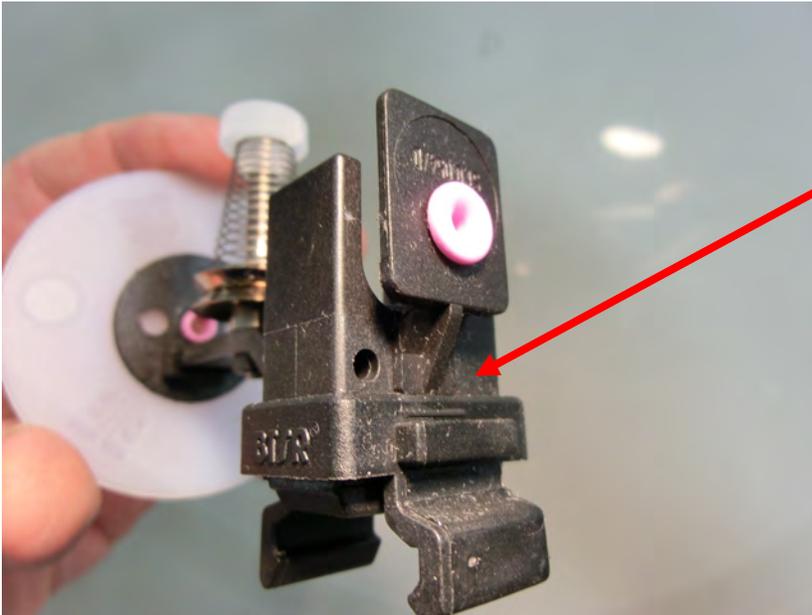
Tension knob has about 1/8" thread above.



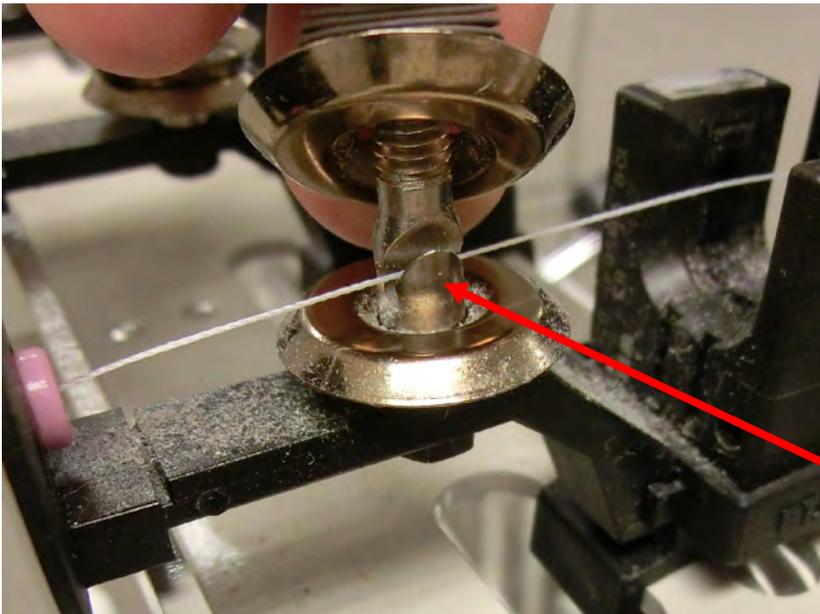
Tension arm seated all the way to the right in its slot.



Exit eyelet seated all the way down in its mounting slot.



Thread must pass through groove in tension post.



Blow off sensors and clean lint out daily!