

 **Kansai Special**
Industrial Sewing Machine

INSTRUCTION MANUAL

MODEL P-3001TP
P-3002VP

THE MAXIMUM SPEED OF THE SEWING MACHINE IS 1,800 RPM.

MORIMOTO MFG. CO., LTD.

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1. Specification

Stitch type: P3001TP Picot and decorative hemming stitch
 P3002VP Picot and fagoting stitch

Number of needles: P3001TP 1
 P3002VP 2

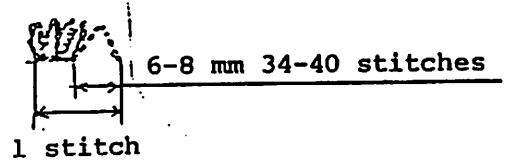
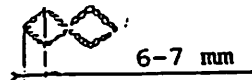
Number of threads: 2 or 4

Needle: UY 163 #65-90

Needle bar stroke: 31 mm

Feed: Differential feed

Standard feed: 1 stitch



Lubricating system: Fully automatic lubrication

Normal rotation speed: 1,800 rpm

2. Selection of Motor Pulley

The rotation direction of the machine pulley is counter-clockwise viewing the pulley.

The motor is 400 W, 4 P (3-phase).

Machine speed rpm	Motor pulley outside diameter	
	50 Hz	60 Hz
1,500	70 mm	55 mm
1,800	80 mm	60 mm

Table 1

3. Filling and Draining Method of Oil (Refer to Fig. 1.)

The optimum lubricating oil of the machine is Tellecco #33. Remove the siphon case A and fill oil up to the line B of the oil gage C.

To drain oil, remove the screw E.

Exchange oil after initial operation of one month and every six months after that by removing oil thoroughly from the oil pan and filling new oil.

Be sure that the oil level is between the marking lines B and D.

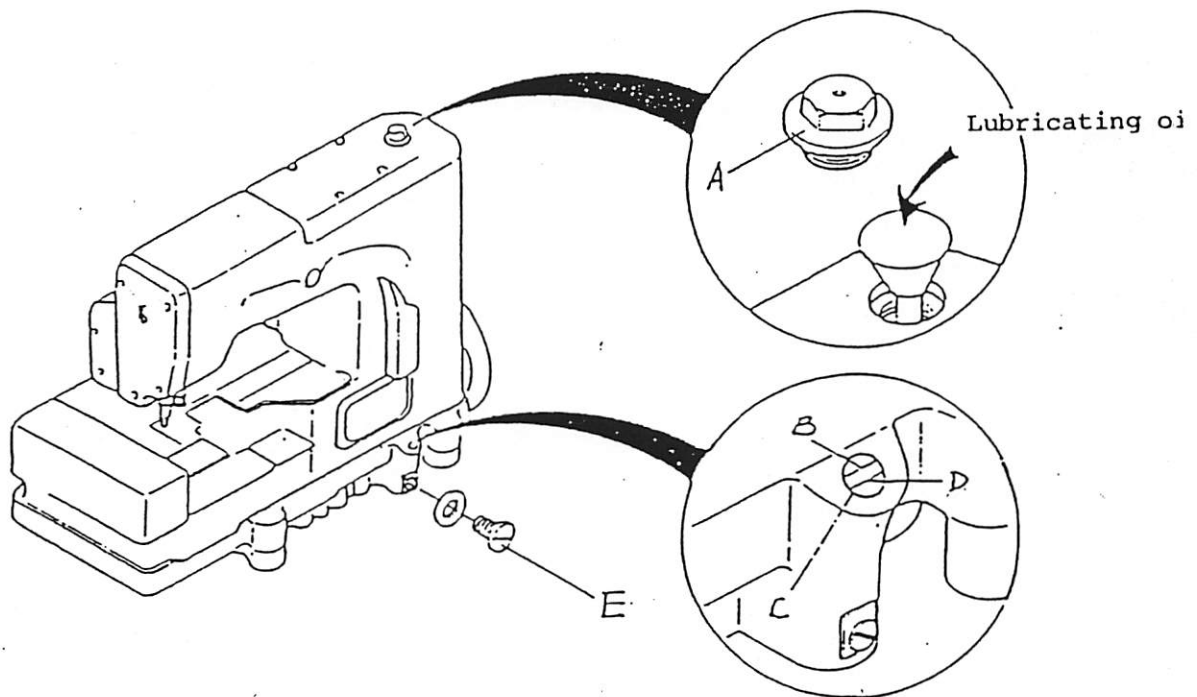


Fig. 1

4. Installation of Needle (Refer to Fig. 2.)

Loosen the screw A and install the needle correctly so that the groove in the needle is just behind the needle.

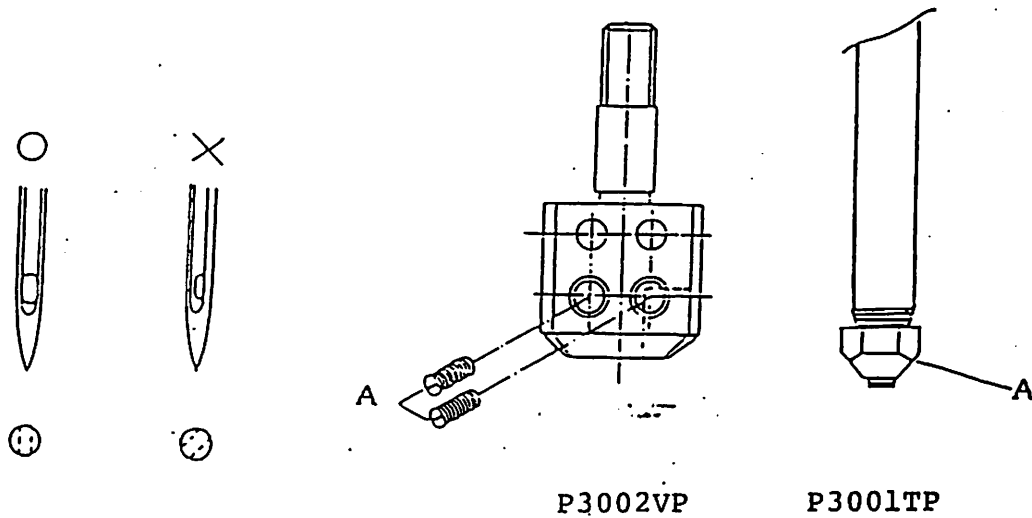


Fig. 2

5. Threading Method (Refer to Fig. 3.)

Pass through the thread correctly according to the following illustration.

The threads numbered 1 and 2 are needle threads and those numbered 3 and 4 are looper threads with the model P3002VP. The thread numbered 1 is needle thread and that numbered 4 is looper thread with the model P3001TP.

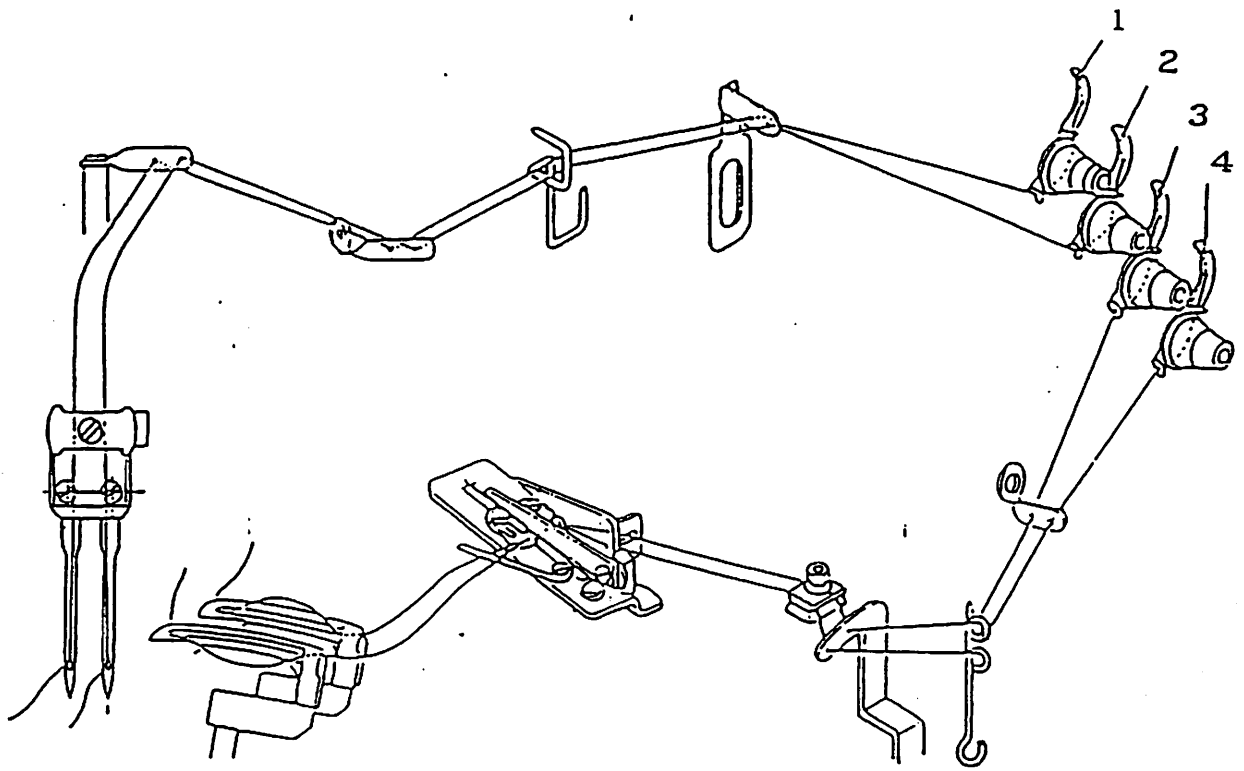


Fig. 3

6. Height of Feed Dog (Refer to Fig. 4.)

Adjust so that the tooth top of the feed dog is about 1 to 1.2 mm above the top surface of the needle plate when the needle bar is at the top dead center.

Make adjustment by loosening the set screws A and B.

(With the model P3001TP, the feed dog height is the height when feeding is motionless.)

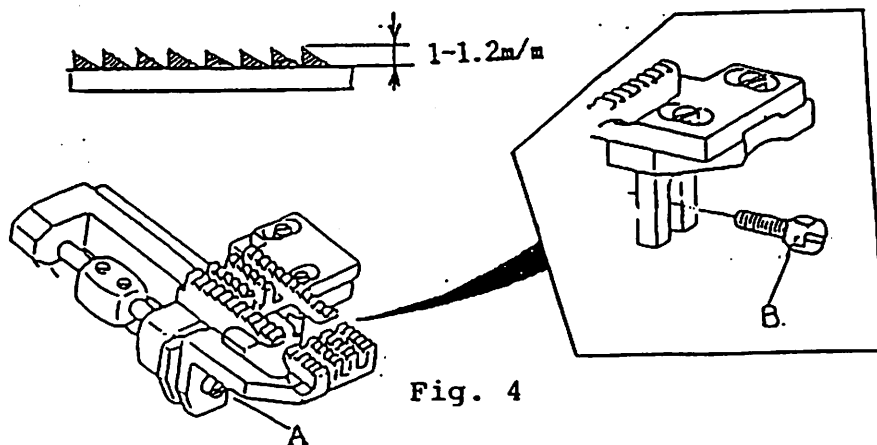


Fig. 4

7. Adjustment of Feed (Refer to Fig. 5.)

a) Adjustment of main feed

Loosen the nut B (left-hand thread) by turning it clockwise. Turn the adjusting screw C counterclockwise for increasing feed and clockwise for diminishing. Must adjust the needle guard when the feed is changed on the model P3002VP only.

b) Adjustment of differential ratio

Loosen the nut A. Shift the connecting crank D upwards in the slot for increasing the differential ratio and downwards for diminishing.

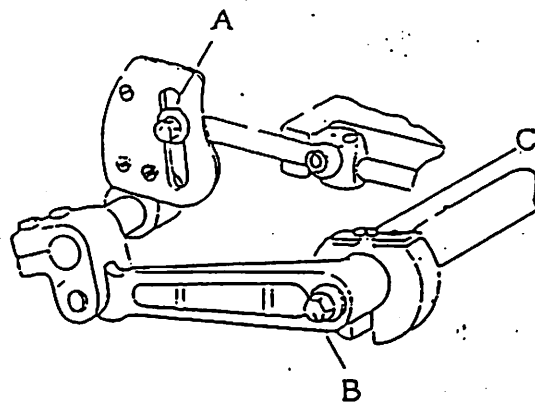


Fig. 5

8. Positional Adjustment of Needle Guard (Refer to Fig. 6.)

Adjust so that the top end B of the needle guard shown in Fig. 6 shall be 0.8 to 1.0 mm above the point of the

needle, and the needle and needle guard shall be in light contact at the time, when the looper moves leftwards and the looper tip is lined with the right side face of the needle.

The above position is acquired by loosening the thread A and moving the needle guard finely in the arrow directions shown in the illustration.

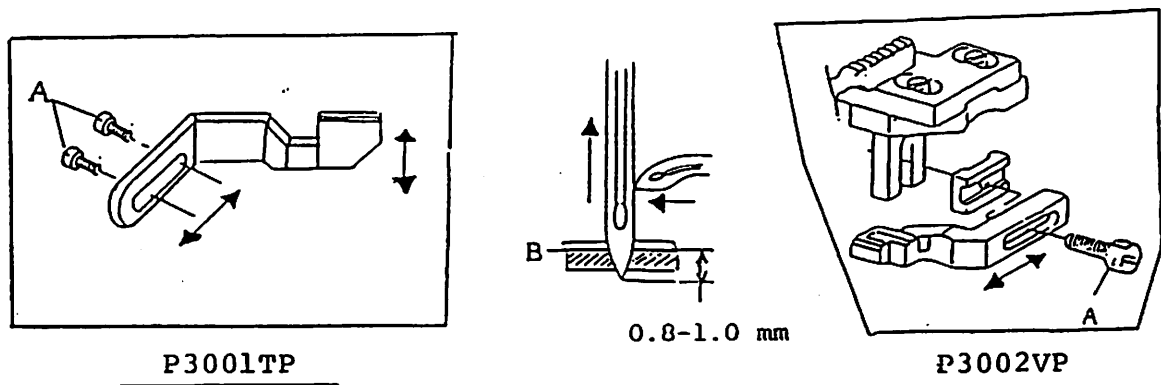


Fig. 6

9. Adjustment of Looper Thread Takeup (Refer to Fig. 7.)

a) Position of thread guide of looper thread takeup

Adjust so that the thread hole of the thread guide A shall be lined with the center line of the main shaft.

b) Position of looper thread takeup F

Loosen the screw G and adjust so that the distance between the underside of the looper thread takeup F

and the top surface of the looper thread guide bracket shall be 6 to 7 mm.

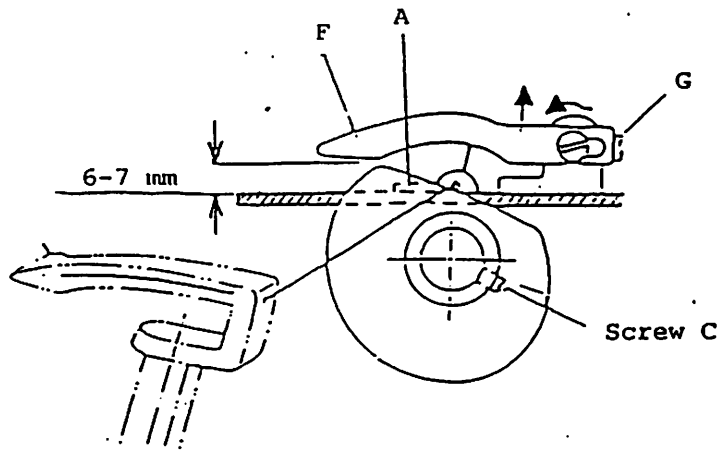


Fig. 7

c) Adjustment of thread tension cam (Refer to Fig. 8.)

Adjust so that the hauled up looper thread shall part from the back of the thread tension cam when the looper moves rightwards from the left dead center and the point of the needle is lined with the blade A of the looper.

Loosen the screw C (Fig. 7) for adjusting as above.

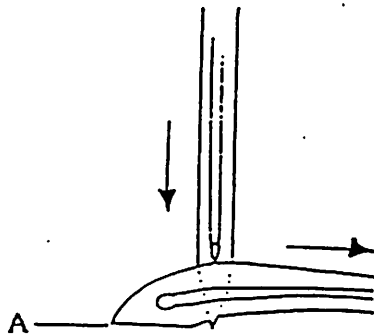


Fig. 8

10. Adjustment of Loper Back Spring (Refer to Fig. 9.)

Loosen the screw A and move the back spring base A up and down so that the entire surface of the back spring is in uniform contact with the back side of the looper and the tension of the thread shall be 30 to 40 g. Fasten the back spring base to the looper holder.

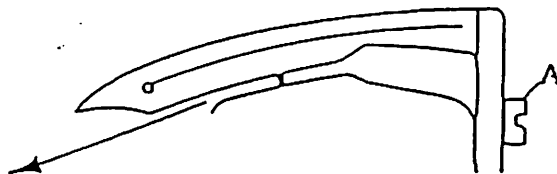


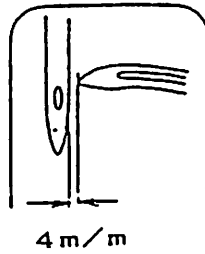
Fig. 9

11. Distance between Loper and Needle (Refer to Fig. 10.)

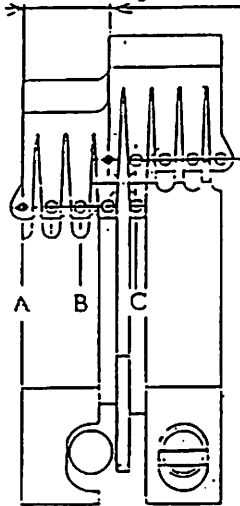
Set the distance between the looper tip and the needle to 4 mm when the needle bar is at the bottom dead center.

Confirm the distance 4mm at the needle drop points A and B (Fig. 11). Tighten the set screws A and B lightly and adjust the looper holder N finely side to side.

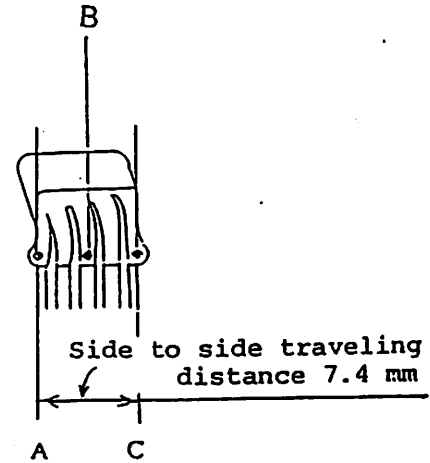
At the time, adjust so that the distance between the looper traveling behind the needle and the needle shall be 0 to 0.1 mm.



Side to side traveling distance 7.4 mm



P3002VP



P3001TP

Fig. 10

12. Timing of Needle and Loper (Refer to Fig. 11.)

a) Model P3002VP only

- Loosen the screw D and adjust the position of the eccentric so that the looper moves leftwards passing 0 to 0.5 mm above the top of the needle eye and rightwards passing 0 to 0.5 mm under the top of the needle eye.

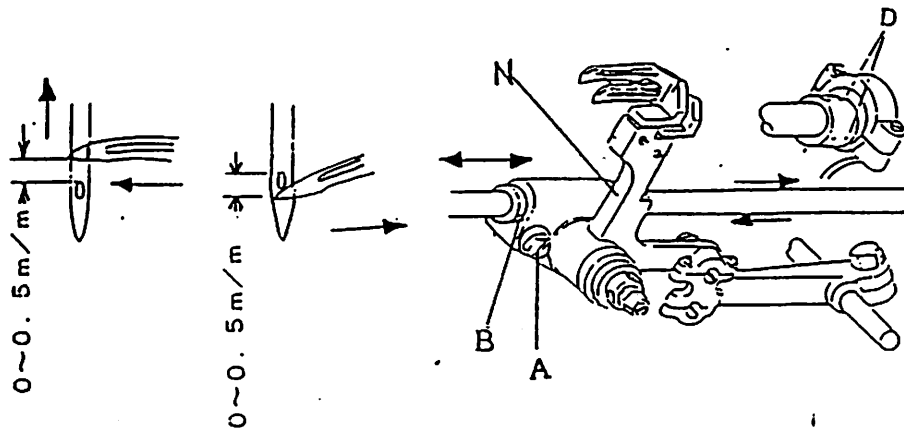


Fig. 11

b) Model P3001TP only

Loosen the screw D and adjust the position of the eccentric so that the looper moves leftwards passing 3 mm above the top of the needle eye and rightwards passing 2 mm above the top of the needle eye (Fig. 11).

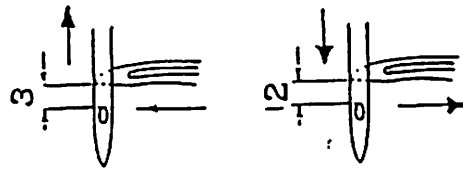


Fig. 12

c) Common to model P3001TP and P3002VP

Relative positions of needle bar and looper holder (Fig. 13)

Adjust the relative positions of needle bar and looper holder so that the distance between looper

and needle when the looper moves rightwards shall be equal to that when the looper moves leftwards, when the needle bar being at the point C (Fig. 10) of the needle plate is at the bottom dead center.

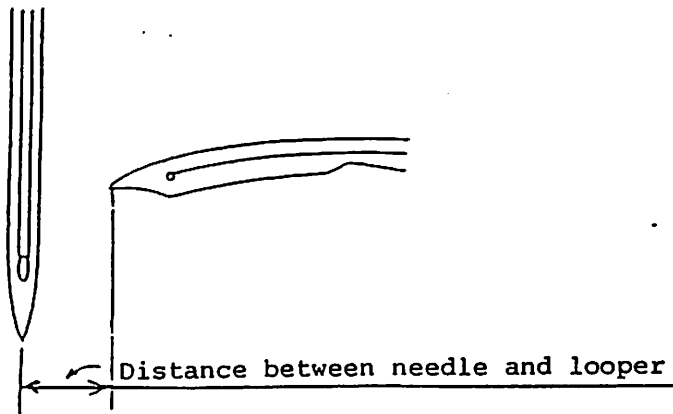


Fig. 13

13. Adjustment of Needle Bar Height (Refer to Fig. 14.)

Adjust the needle bar height A by loosening the screw B and shifting the needle bar up and down when the needle bar is at the top dead center.

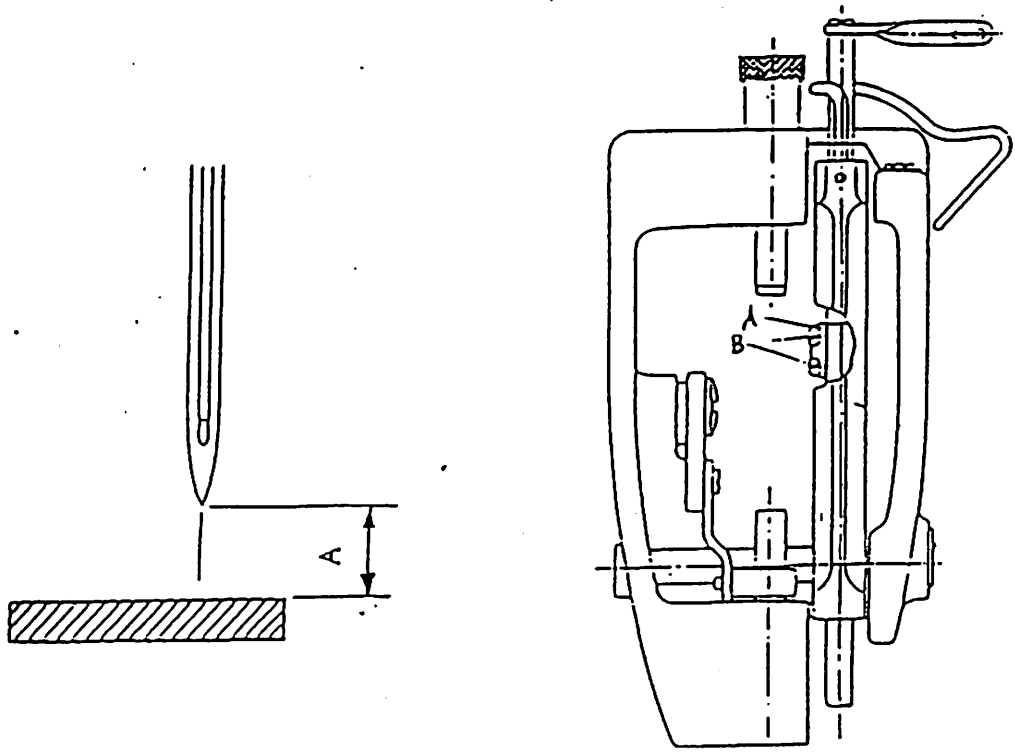
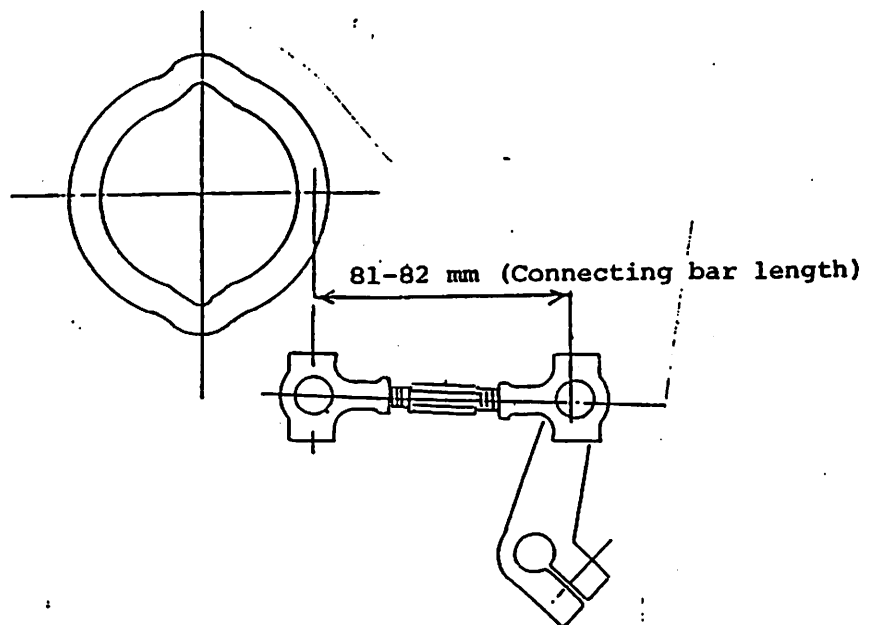
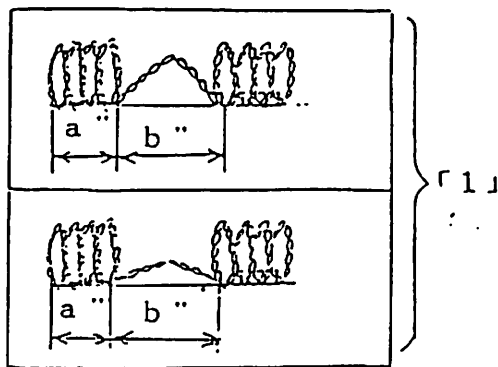


Fig. 14

14. Adjustment of Feed Cam (Model P3001TP only)

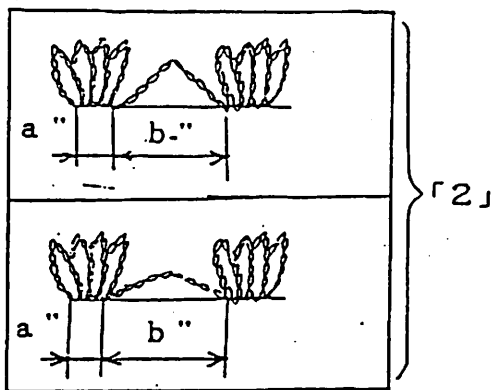
The connecting bar length of the basic stitch of this machine is 81 to 82 mm.





At the pattern [1]

- o Feed slightly at the pattern 'a'.
(Make the connecting bar long.)
- o Change the feed at the pattern 'b'.
(Refer to Para. 7 "Adjustment of feed" on Page 5.)



At the pattern [2]

- o Set the feed to zero or minimal at the pattern 'a'.
(Make the connecting bar short.)
- o Change the feed at the pattern 'b'.
(Refer to Para 7 "Adjustment of feed" on Page 5.)

* To change the length of the connecting bar, loosen the nut A shown in Fig. 15.

15. Table Stand Setting

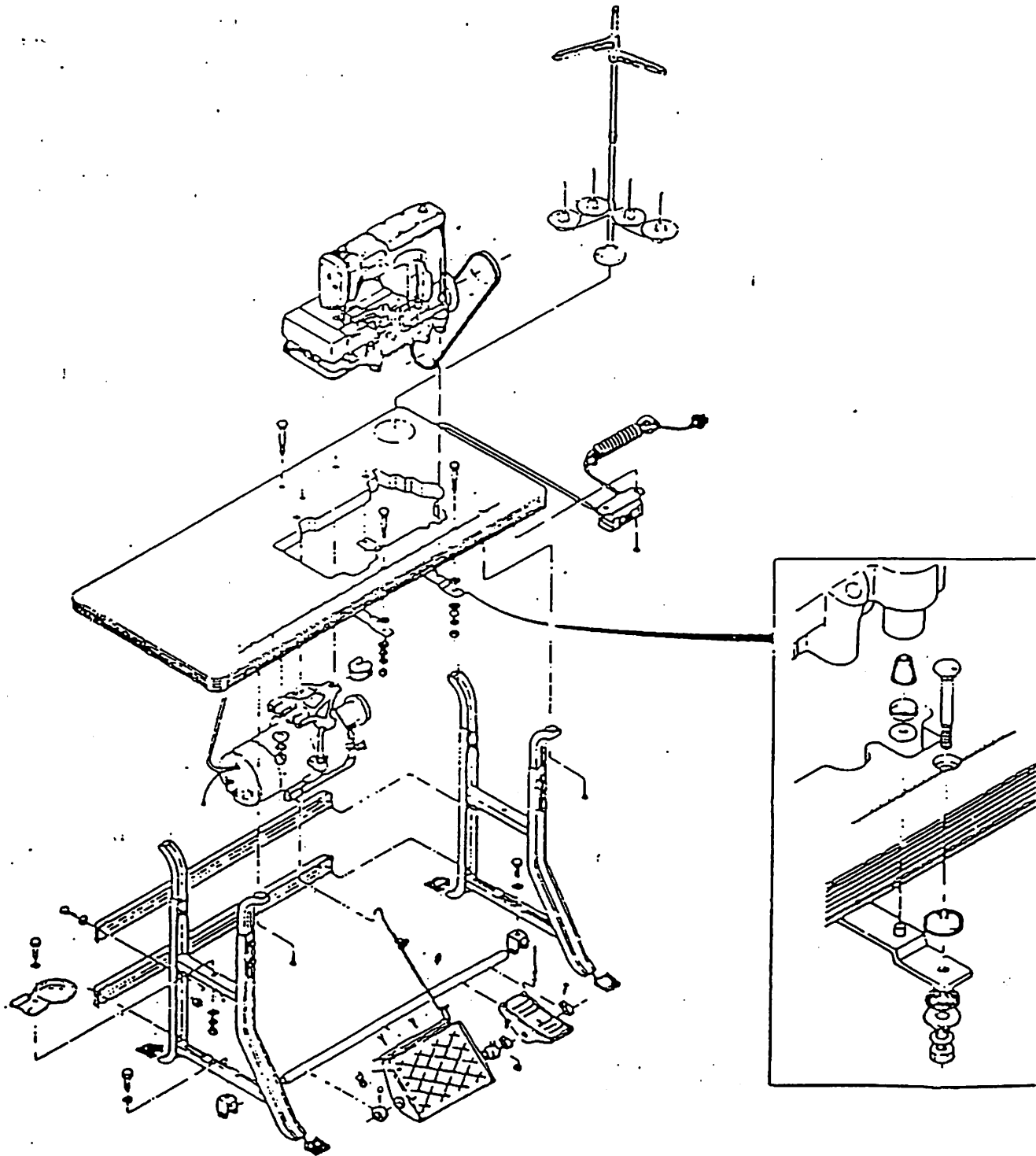


Fig. 16