

COVER STITCH MACHINE:

- **RECEIVING INSTRUCTIONS**
- **SET-UP INSTRUCTIONS**

COVER STITCH MACHINE

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COVER STITCH MACHINE: RECEIVING INSTRUCTIONS

A palletted shipment from China FeiYue Inc./BCE Environment Corp, Chino, California will arrive on a pallet; the contents, weighing about 300 lbs., will be covered in cardboard & shrink wrapped.

It consists of 3 parts:

- Fully assembled sewing table and legs, including motor & thread stand, which will be attached with plastic cable/zip straps under the table
- Siruba box containing partially assembled sewing head & a box of accessories and spare parts & extra needles
- Boxed Husky Vacuum Cleaner



Remove the shrink wrap & protective cardboard covering.

Before signing the Bill of Lading it is imperative to:

1. **check for any damages,**
2. missing packages,
3. anything unusual, etc. that may have happened during shipping.

Otherwise, these will be treated as having occurred after delivery and shipping company will not be held accountable.

Written proof is required by the shipping company in order to claim damages that may have occurred during shipping.

Cover Stitch Machine: Receiving Instructions, cont'd

If machine arrives **with any damage, missing packages, anything unusual that may have happened, etc.:**

1. **Note in detail** all the damages, etc. **on** the Bill of Lading (BOL)
2. As proof of damage, etc. during shipping, the **Delivery Driver must** sign the BOL with description of damages, etc. A note without the driver's signature is insufficient to claim damages from the shipping company.
3. Take **photos** of all packages and damaged sections
4. Keep a **copy** of the signed Bill of Lading
5. **Email photos** and signed Bill of Lading to lululemon athletica at hemming@lululemon.com as soon as possible, within 5 days of receipt of shipment, at the LATEST.
6. **Accept** the package and sign BOL, BUT if you feel the degree of **damage is too extensive**, you can **choose to not accept** the shipment.

If shipment arrives without any damage, accept it, and sign Bill of Lading.

COVER STITCH MACHINE: SET-UP INSTRUCTIONS

The cover stitch machine will be partially assembled & pre-threaded.
The instructions in this manual will explain in detail how to complete the assembly.
Keep ALL original packaging material, e.g.

- boxes
- molded Styrofoam pieces
- 4 screws that attach sewing table to pallet

Due to the complexity and numerous parts on the machine head, mishandling can cause damage.

It is therefore imperative that you:

- **read and understand** the following instructions **AND**
- **read** the manufacturer's manual, including **safety instructions and warnings**, **before unpacking and setting up** the cover stitch machine.
Instruction manual is in the accessories box
- Keep the manufacturer's manual readily available for qualified cover stitch technician's reference

The Siruba cover stitch machine will come in 3 parts:

- Industrial sewing table, with attached clutch or electric motor, about 200 lbs
- Pre-threaded Cover Stitch machine head which weighs about 45kg/90 lbs
- 5 Spool Thread Stand, assembled, shrink wrapped, & taped under sewing table



Industrial Sewing Table



Pre-Threaded, 3 needle Cover Stitch Machine



5 Spool Thread Stand

Industrial Sewing Table:

A Clutch motor or an Electric motor will be attached to the table.
Remove bolts/screws that attach sewing table to the pallet.
Keep all original packaging.
Move table to its final location.
If still necessary, table height can be adjusted



Front Side view of table with clutch motor



Front side view of table with electric motor
Thread stand packed below table



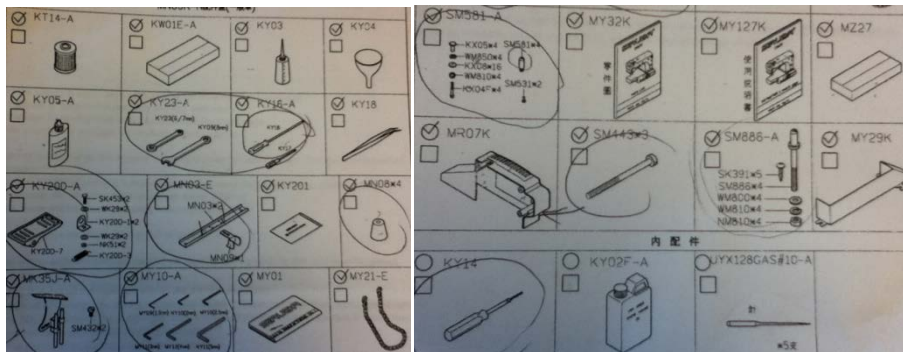
Remove screws that attach sewing table to pallet

Accessories:



Accessories Include:

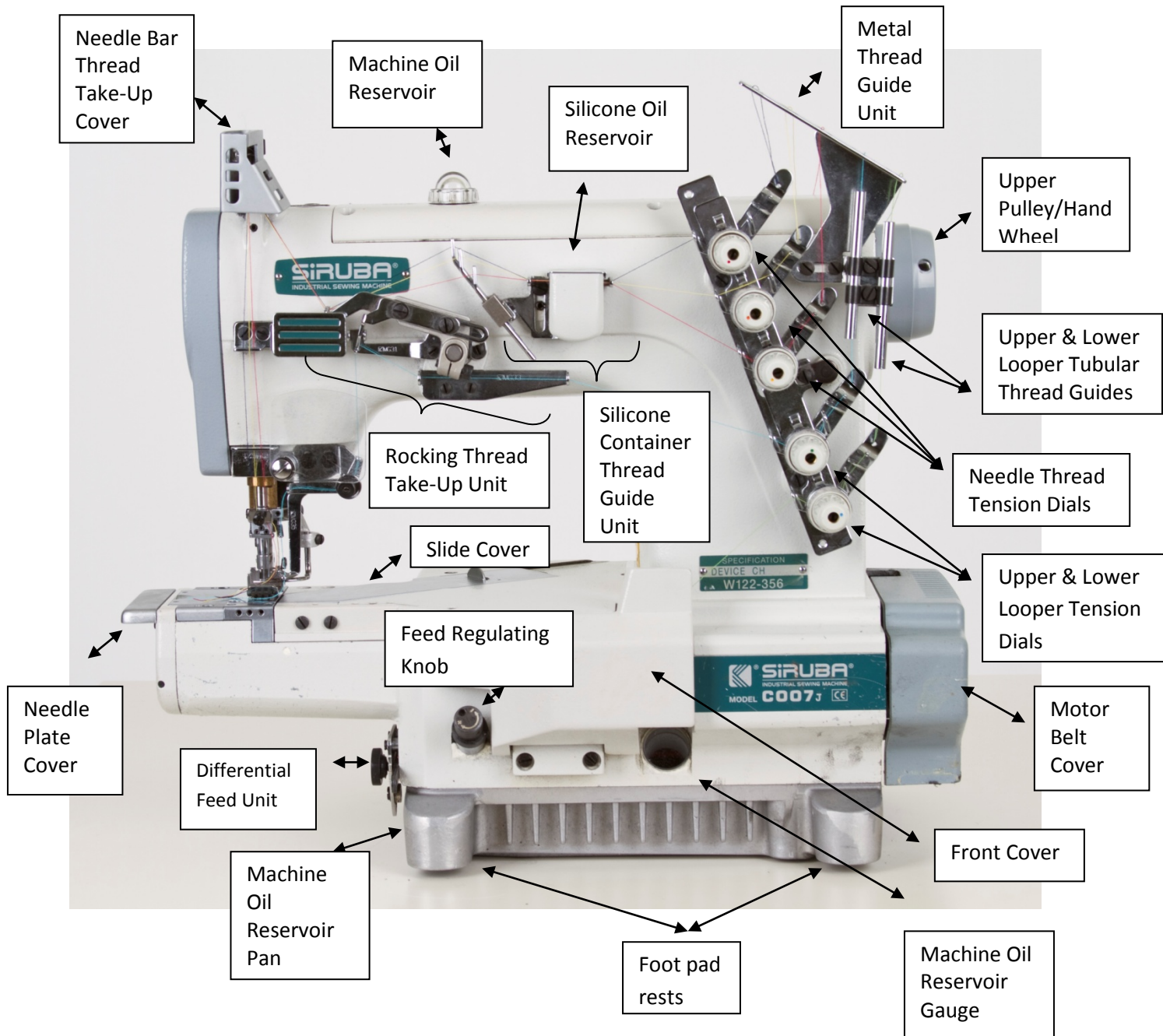
- Motor belt
- Metal chain & 2 “S” hooks
- Metal thread guides with 2 screws
- Hexagonal screw driver to insert/remove needles
- Needle Holding Screws
- 2 wrenches
- 6 Allen keys
- Assorted “Organ” needles
- Funnel, empty plastic dispenser with red cap,
- Silicone oil
- High speed sewing machine oil
- Tweezers
- Filter
- Siruba Manufacturer’s Instruction book & Siruba parts list
- Plastic machine cover



Copy of Accessories, packing list

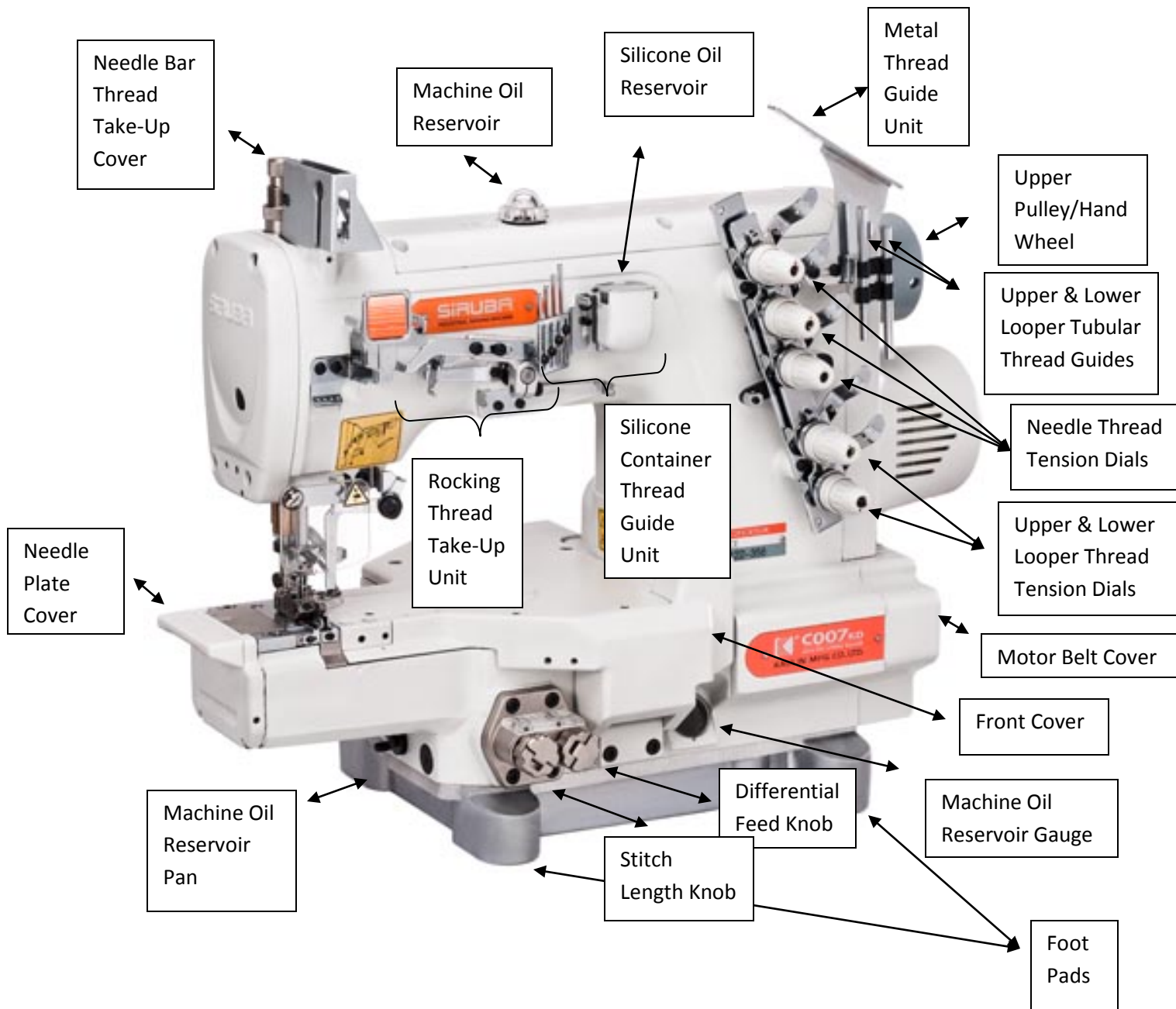
ANATOMY OF THE COVER STITCH MACHINE

Model C007J



ANATOMY OF THE COVER STITCH MACHINE

Model C007K



Unpacking & Assembling the Sewing Machine Head:

Machine head is packed in an industrial box; use the ropes at each end to move the box.

Caution: Box weighs about 90 lbs. Do not drop. Highly advisable that 2 people move this box. Move box in front of sewing table.

Open box, with a utility knife by cutting through packing tape only – Do Not Cut through Box

Remove the box of accessories, which includes a manufacturer's manual.

Please be sure to **read the Manufacturer's Manual before operating the machine.**

Machine head will be protected on all 4 sides, top, and bottom with molded styrofoam.



Boxed Sewing Machine Head



Accessories box inside Siruba box



Heavy duty box with
Styrofoam protection



Unpacking & Assembling the Sewing Machine Head Cont'd:

WARNING: To prevent damage, DO NOT grab/hold machine by any of the silver parts including: tension dials, upper looper section, needle bar area
See photos below:



WARNING: Do Not Hold or Grab Any of These Parts!!



Unpacking & Assembling the Sewing Machine Head Cont'd:

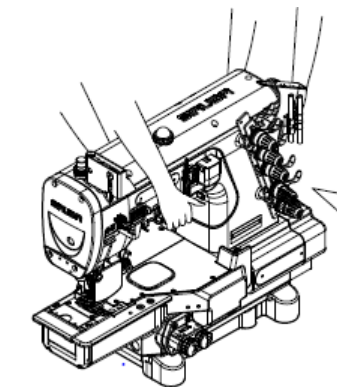
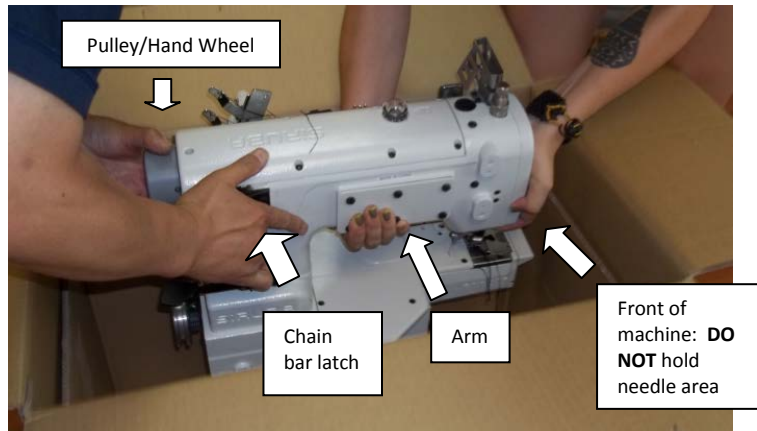
Remove machine head from box

2 people should move the head due to the weight of the machine:

- 1st person uses both hands to lift under the arm of the machine, intertwining fingers OR with one hand, lift under arm of machine and with other hand, lift the front of the machine, but without touching the needle area
- 2nd person holds the motor pulley, the chain bar located at back of machine, and/or the motor wheel

Place machine head onto the four pads on the sewing table

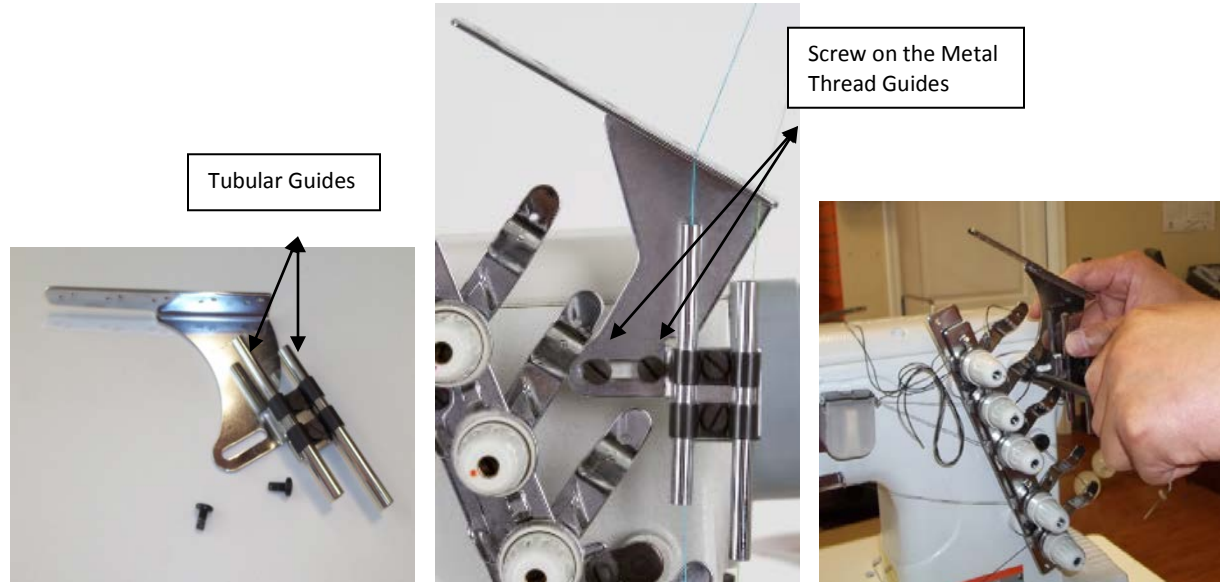
Due to the weight of the machine, additional bolts or screws are not needed



Metal Thread Guide:

Included in the accessories box is a small metal thread guide unit which consists of 2 tubular guides, 2 screws, & screwdrivers.

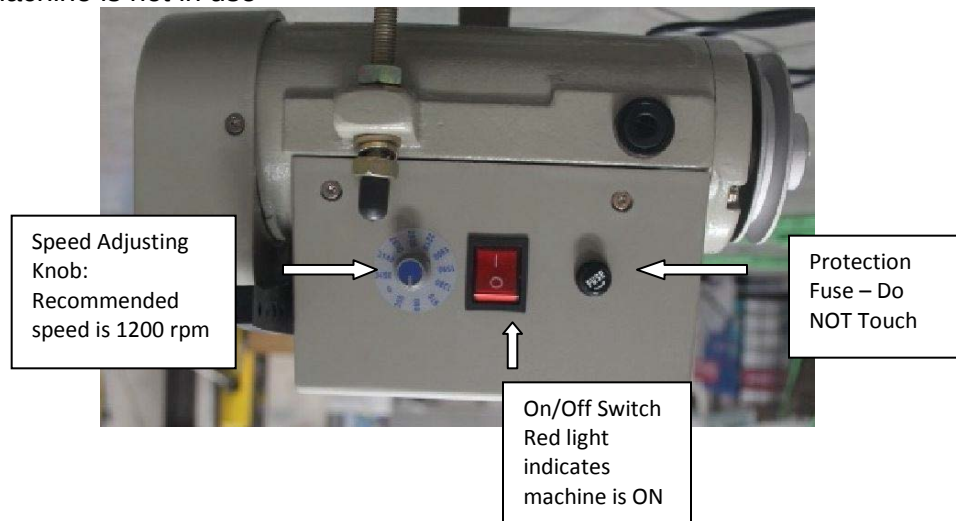
With the 2 enclosed screws, attach the unit so the tubular guides are positioned vertically, above the tension dials.



Electric Motor:

As of September 15, 2012, all sewing machine tables will be installed with an advanced silent servo-motor. Special features include:

- Motor is so quiet, that it does not make any sounds, even when the machine is operating
- Look at the On/Off Switch to make sure that the machine is on or off. Red light indicates that the machine is on.
- Sewing speed can be adjusted to low or high by turning Speed Adjusting knob.
- Avoid accidentally running the machine by ensuring that the motor is turned OFF when machine is not in use



Motor Belt:

Unscrew the belt cover.

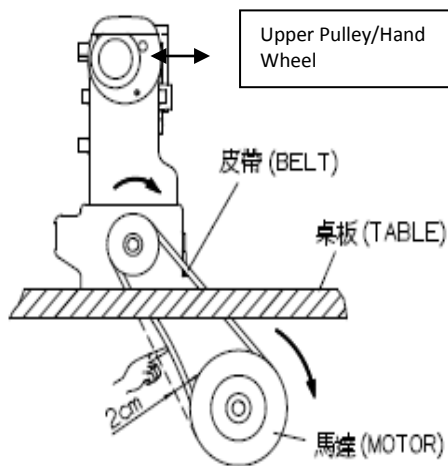
Motor belt, is in the accessories box.

Feed the belt up through the slit in the table.

Place belt onto the groove of the large metal wheel on the machine head and around the motor wheel, located under the table.

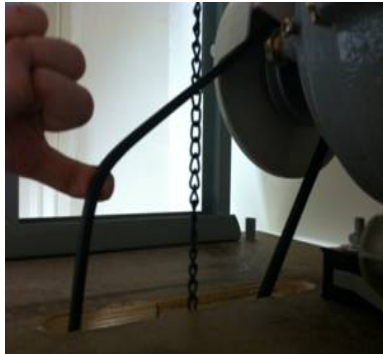
Turn the upper pulley or motor wheel clockwise to feed belt onto the wheel and into the groove. Belt has limited stretch & should be quite snug; it can be pressed inward with finger about 2 cm/1 inch.

Once the belt is in place, screw on the belt cover.



Adjust Motor Belt tension:

If needed, belt tension can be adjusted by adjusting the degree that motor tilts.
An L-shaped bolt is tightened by 2 nuts.
Loosen both nuts enough to allow the motor to hang by its own weight.
Tighten both nuts.



Loose Motor Belt Tension

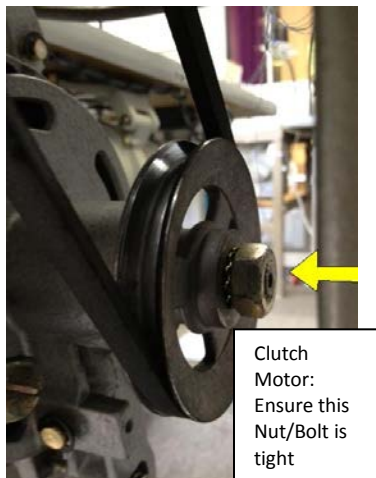


L-shaped Bolt on Clutch Motor

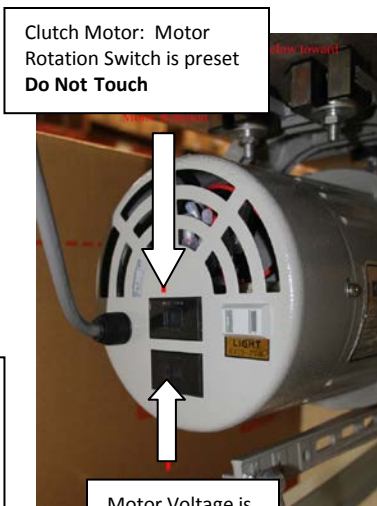


Bolt on Electric Motor

Warning: Ensure that the Nut/Bolt on the clutch motor's metal wheel is on tight.
Motor Rotation switch controls the direction that fabric will feed. This is already preset for the fabric to feed away from the operator.
Bottom Switch on the motor is at 110 volts
Electric Motors: Slide the belt cover, found in accessories box, over the motor wheel

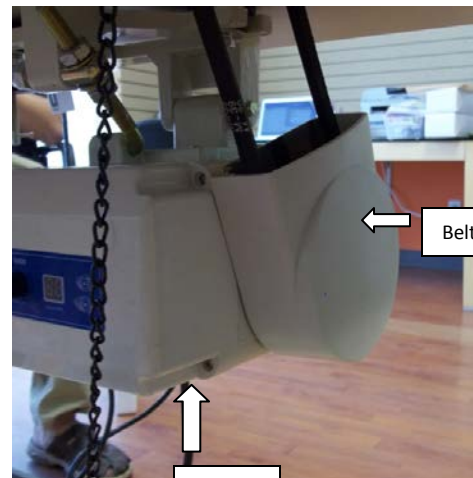


Clutch Motor:
Ensure this
Nut/Bolt is
tight



Clutch Motor: Motor
Rotation Switch is preset
Do Not Touch

Motor Voltage is
110V



Belt Cover

Electric
Motor

Metal Chain:

Chain and 2 “S” hooks are in the accessories box.

Attach “S” hook to the black latch on the right hand side of the machine, near the upper pulley.

Hook chain onto this “S” hook and feed chain through the hole in the table.

Make sure the chain does not wrap around motor belt.

Attach the 2nd “S” hook to the foot pedal and hook onto the chain.

Foot pedal must stay at its resting position after attaching chain.

If chain is too tight the presser foot will not fully rest on the needle plate.



Chain must not wrap around motor belt

5 Spool Thread Stand:

Thread stand will be assembled & packed under the sewing table
From the bottom up, thread stand consists of:

- Spool holder arms
- Set of tubular arms
- Set of thread guide arms

The arms that correspond with the 3 spools line up to the back of the table
Parts that thread 2 cones line up with right side of table

One nut and 2 washers attach thread stand to the table.

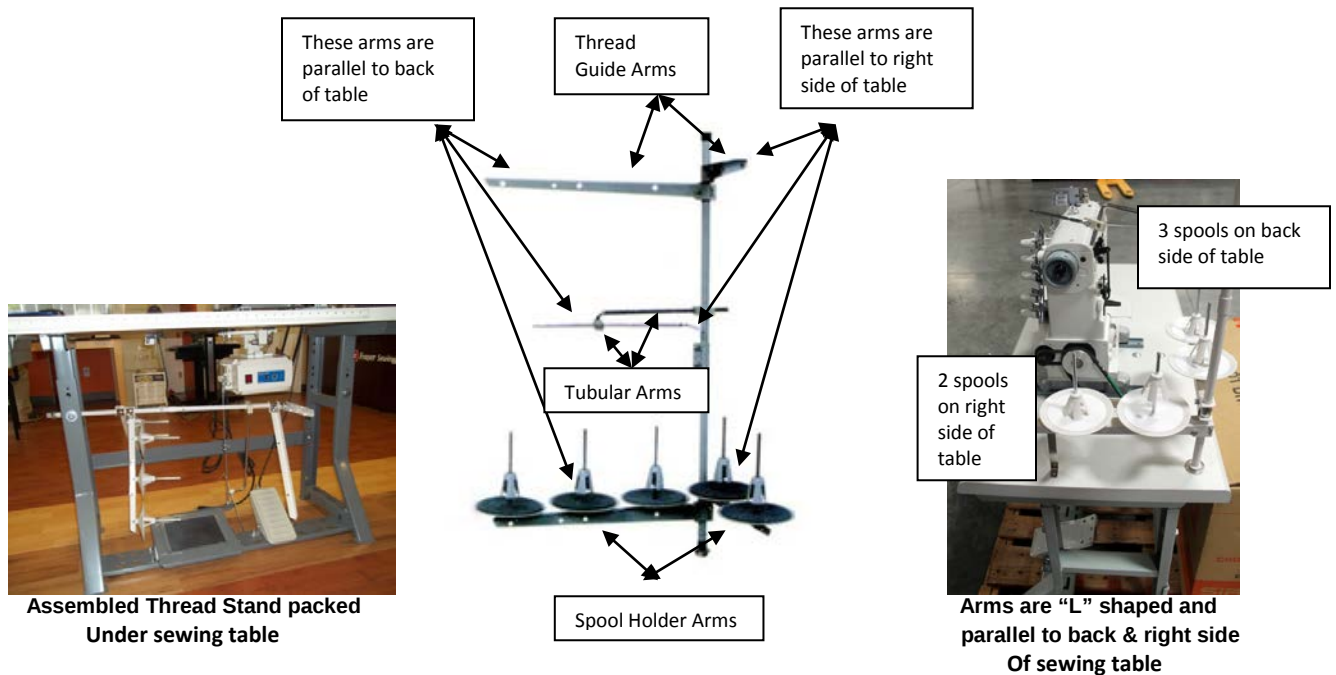
One washer goes on the top of the table, the other goes on the bottom

Insert thread stand into hole located on top, right hand side of the table

Tighten stand with the nut

Adjust spool holders, tubular arms, & guide arms to form an “L” shape.

WARNING: Thread stand area must always be clear of objects otherwise thread tension can be affected.



Installing the Thread Stand

The thread stand will be preassembled, with 3 basic sections:

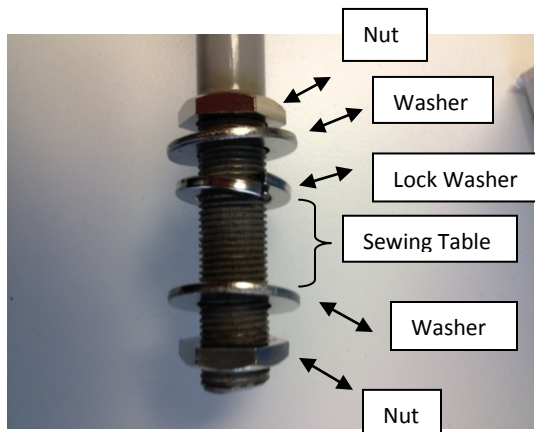
- The thread spool holders
- The tubular thread guide arms
- The larger thread guide arms



Bottom of thread stand
inserts into table – tightened
by nuts & washers



Lock Washer



Insert the assembled thread stand into the sewing table:

- Nut
- Washer
- Lock washer – looks like a broken washer
- Sewing table
- Washer
- Nut

Tighten the nut using a wrench

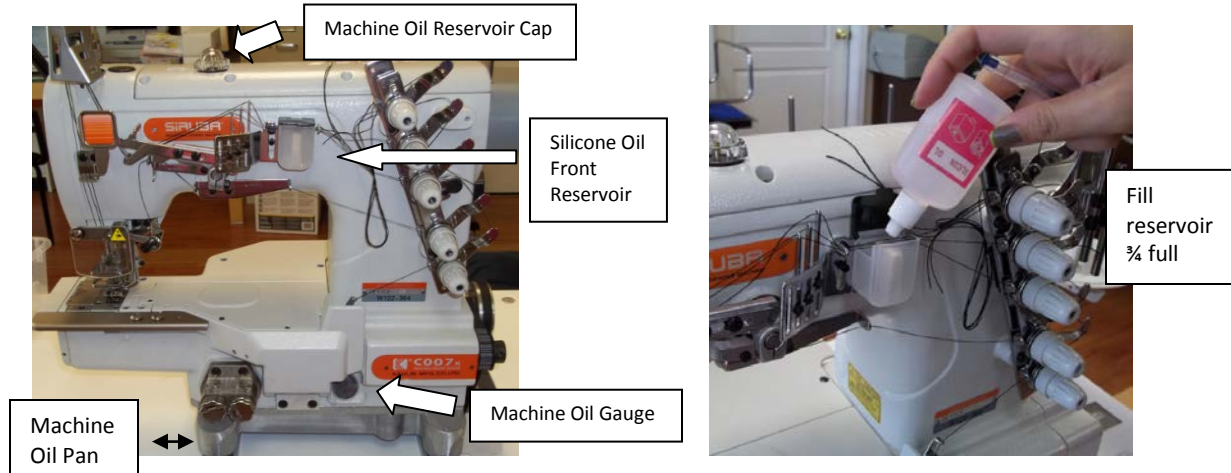
Once assembled, adjust the spool holders & the thread guides so that they are “L” shaped, parallel to the corners of the table

Silicone & Machine Oils:

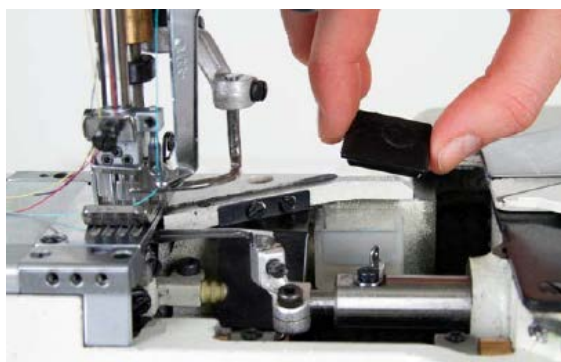
Warning: Machine Oils and Silicone Oils are **NOT** interchangeable.

Silicone Oil

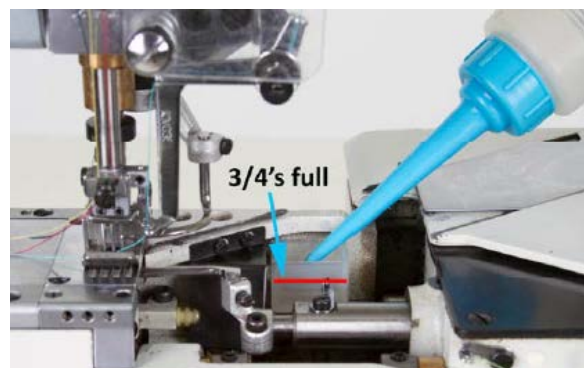
Silicone oil is thick and viscous, helping lubricate the needle threads. Add Silicone oil into small plastic reservoir located to the left of tension discs. And to the reservoir in the bottom of the machine, under the front cover.



A 2nd silicone oil reservoir is located on the bottom of the machine. Pull open the front cover. Some models also have a metal plate cover – slide it back to open



Remove the cap of the reservoir & fill $\frac{3}{4}$ full – see red line



Machine Oil

Industrial sewing machine oil is needed to prevent the machine parts from rusting. The machine holds about 600 ml of oil.

Unscrew clear plastic cap of the machine oil reservoir located on top of the sewing machine head.

Using supplied funnel, pour the sewing machine oil into the reservoir while watching the oil gauge located on the front of the machine.

The ideal oil level is between the 2 red lines on this window. A white line or bubble of air will represent where the oil level is.

The oil will take some time to go through the entire machine and settling in the oil pan before registering in the oil gauge.

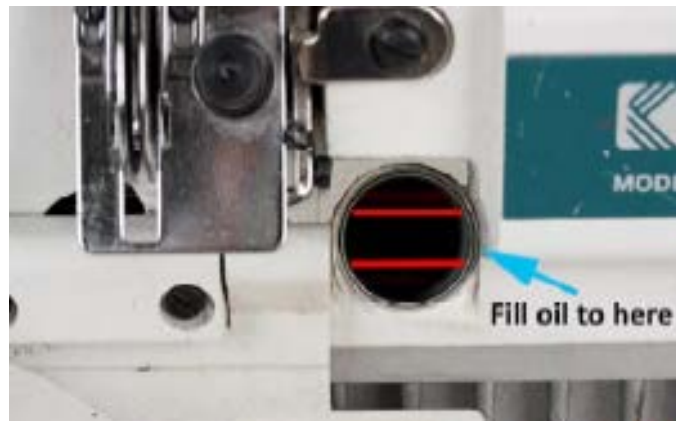
After adding half the oil, let it sit for a few minutes before adding the remaining oil.

You may find a bit of oil leakage on a brand new machine or a machine that has been idle for more than a couple of weeks. This is normal. Keep the machine clean and wipe up any oil residue. If leaking continues after about a week of usage, the machine should be inspected by a technician.

While sewing, you may notice oil splashing against the reservoir lid – this is normal. Check the oil level regularly.



Using funnel, add machine oil



Machine Oil Gauge – ensure oil level is between red lines

Threading the Machine

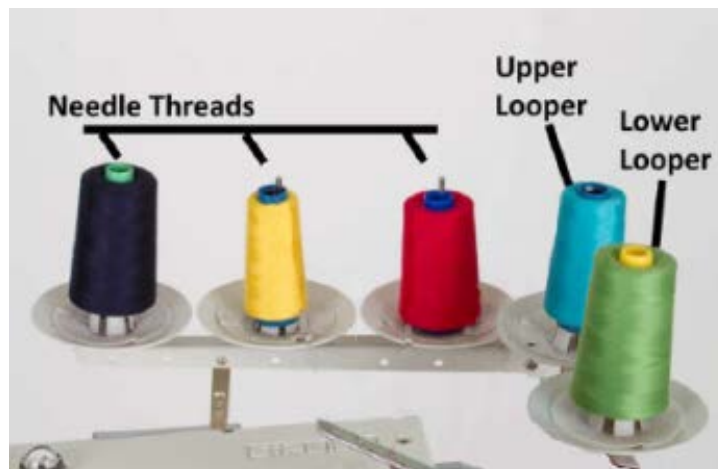
When threading the machine, always thread in the following order:

- Lower looper thread
- 3 needle threads
- Upper looper thread

100% polyester threads are used.

To perform a triple needle cover stitch, five cones of thread are used:

- Lower looper thread
 - o Has low tension
 - o Oscillates back and forth between the 3 needle threads on the wrong side of the fabric
 - o Must be used to create a stitch
 - o Placed on the spool closest to the front of the machine, on the thread stand
- 3 needle threads
 - o Have the highest amount of tension on them
 - o Can create a variety of stitches by removing certain needle threads: 2 needle cover stitch or single chain stitch
 - o Placed on the back 3 spools of the thread stand
- Upper looper thread
 - o Has low tension on it
 - o Oscillates between the three needle threads on the right side of the fabric
 - o Placed on the 2nd spool on the right side of thread stand
 - o Removing this thread will result in rows of double or triple needle straight stitch



Threading the Machine, cont'd

Note placement of thread stand and threads – the spool holder, the larger thread guide, and the smaller tubular thread guides are all “L” shaped & are parallel to edges of the sewing table. This placement is important as it can affect sewing tension.

It is also important that the threads are able to move freely since any obstructions can affect tension.

The 3 spools on the back side of the machine hold the needle threads

The 2 spools on the right hand side of the machine hold the upper and lower looper threads.



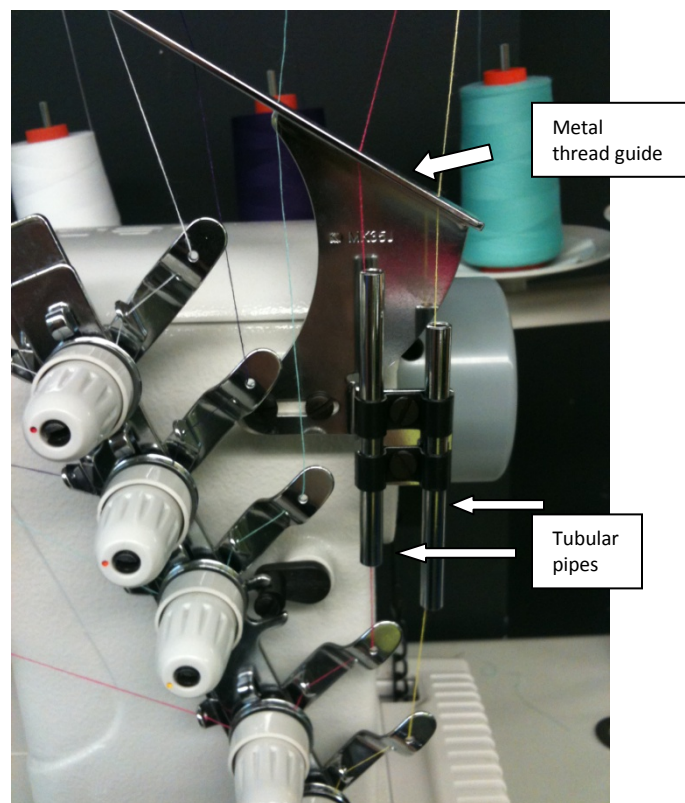
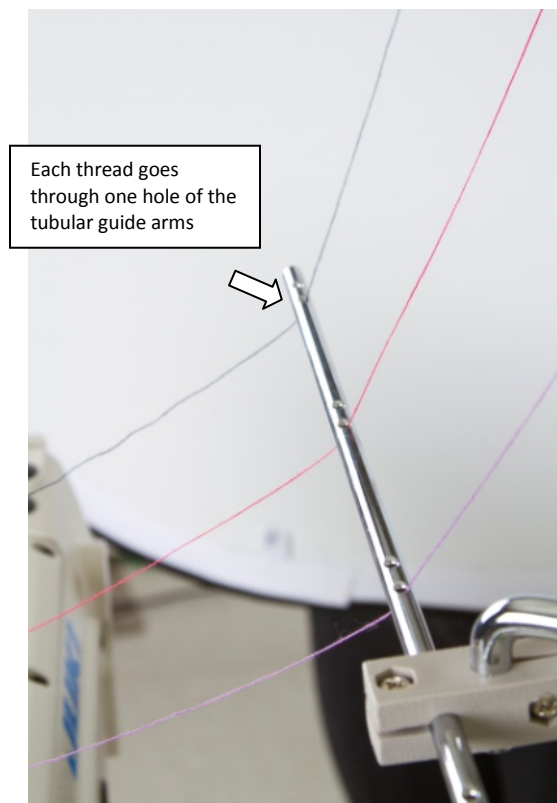
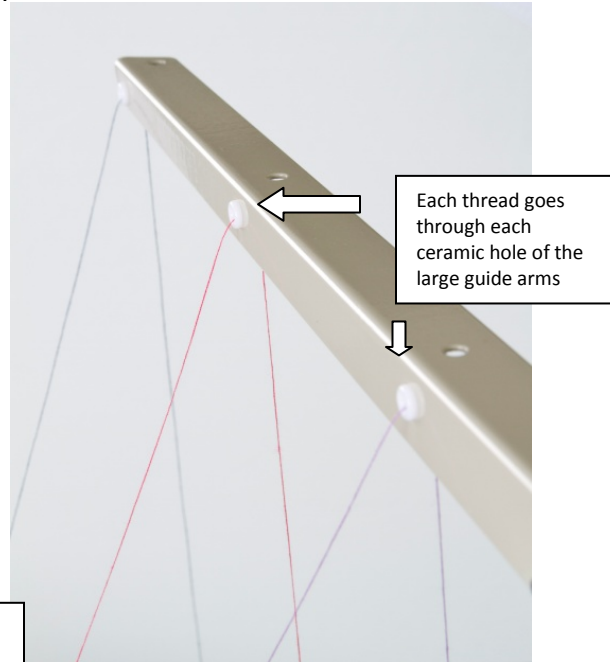
Threading the Thread Stand & Metal Thread Guide

Thread the ceramic holes of the large guide arms of the thread stand.

Thread the tubular guide arm.

Note: the tubular guides and the metal guide have 2 sets of holes for each thread. Since the non-stretchy, 100% polyester thread is being used, simply thread through one hole. Wrapping threads around both holes creates additional tension

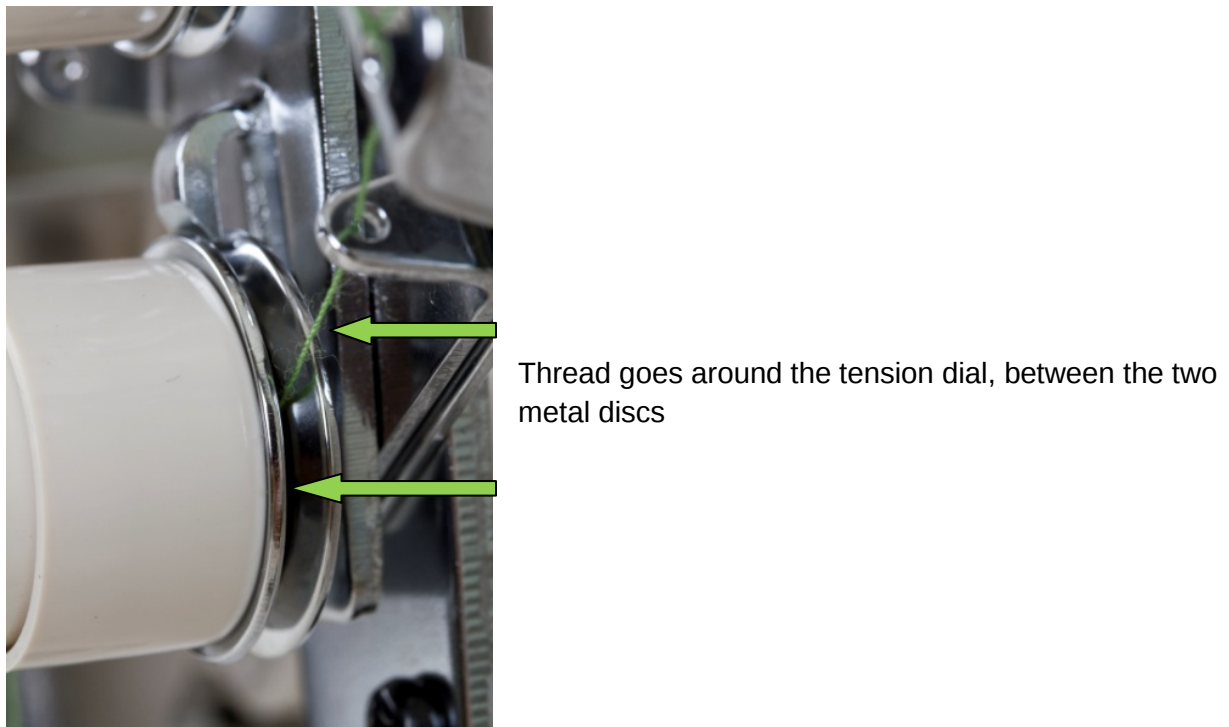
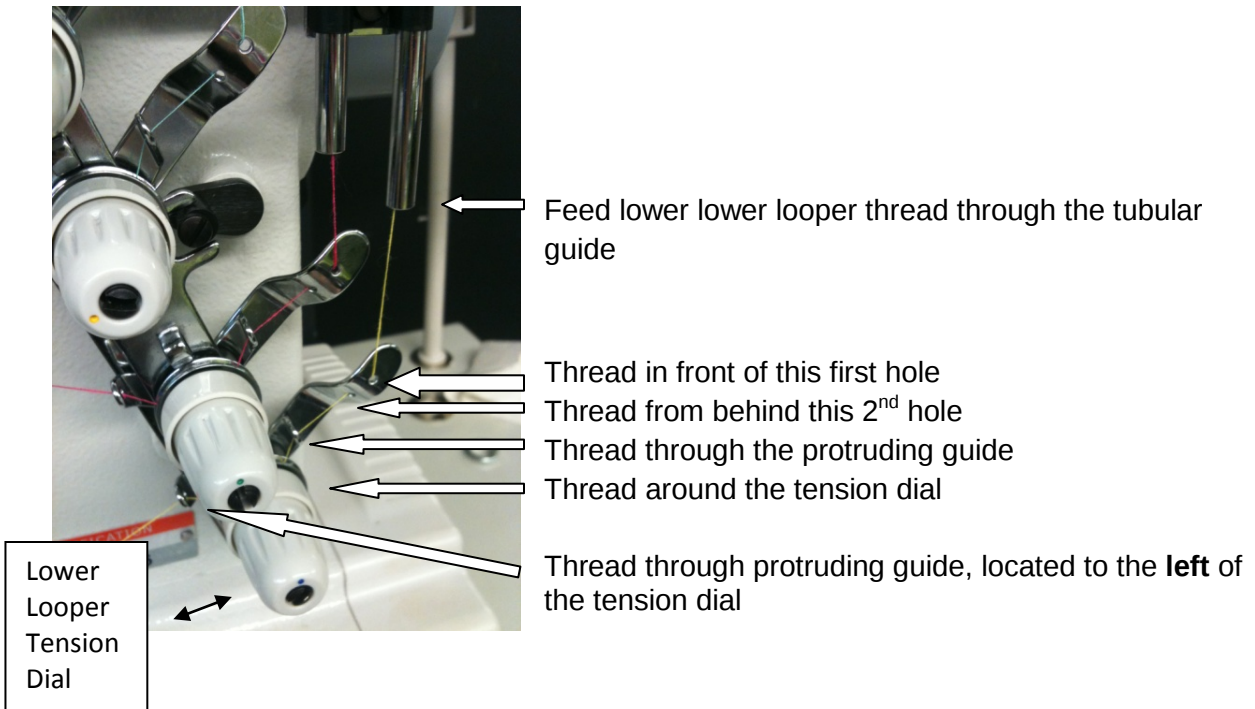
Feed thread down the length of the tubular pipe.



Threading the Lower Looper at the Tension Dial

Thread through the 3 holes to the right of the Tension Dial, entering from the **front** of the first hole.

Pass the thread between the 2 metal tensions discs on the Tension Dial.
Ensure the thread is not wrapped around the knob or felt padding.
Continue threading to left side of the Tension Dial.

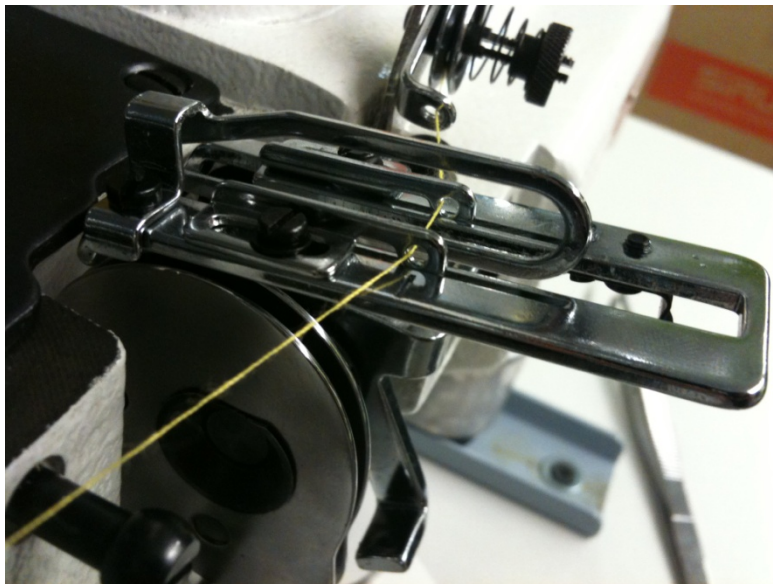
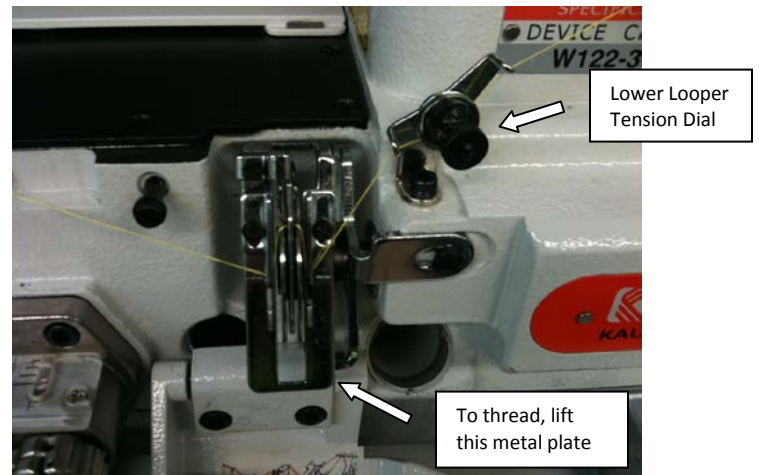
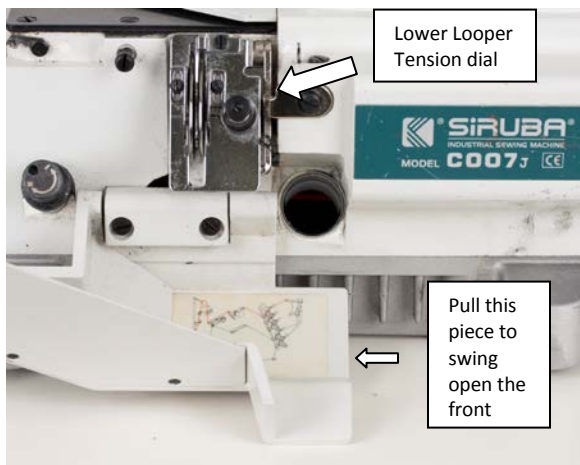


Threading the Lower Looper Thread, inside the Front Cover

Pull open the front cover.

Location of the Tension dial varies, depending on the model of the machine.

Pass the thread through the small guides to the right of the tension dial, around the Tension Dial and to the left of the tension dial.



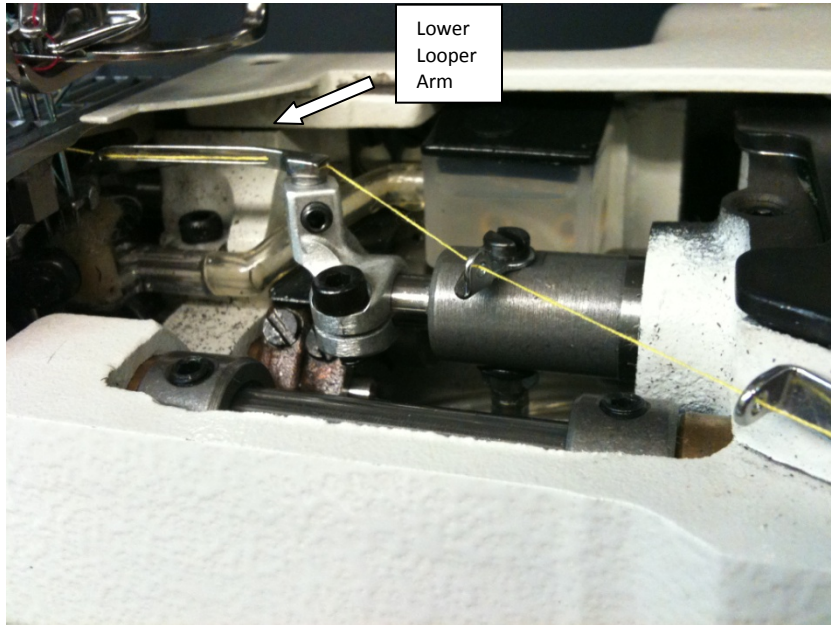
This metal plate can be lifted; swing it up to continue threading

Feed thread through:

- small hole
- long oval hole
- another small hole

Close the plate. Make sure it "clicks."

Threading the Lower Looper Thread, Lower Looper Arm

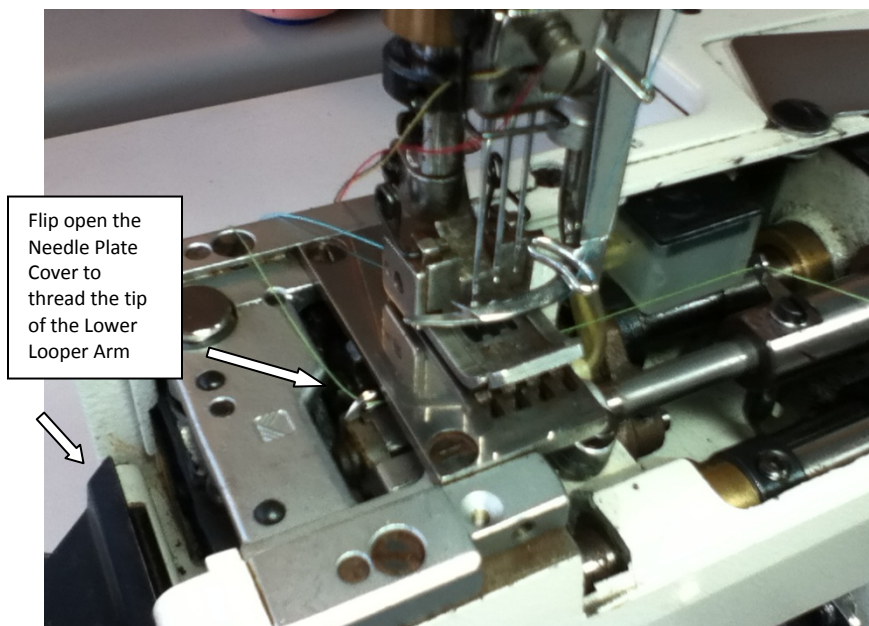


Thread the next small guide.

When in motion, the lower looper arm moves from side to side

Feed the thread through the 1st hole of the lower looper arm.

The length of the arm is grooved, cradling the thread



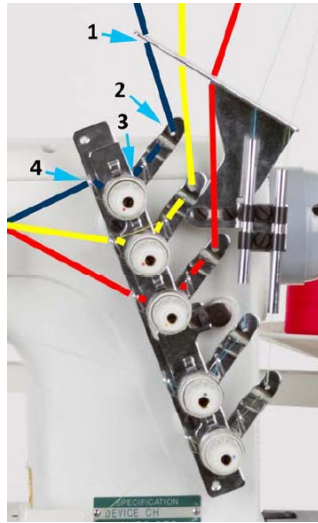
Flip open the needle plate cover, located at the far left.

The point of the lower looper arm is more easily threaded when it is positioned to the far left.

Turn the pulley/hand wheel clockwise to move the lower looper arm.

Place thread towards the back of the machine.

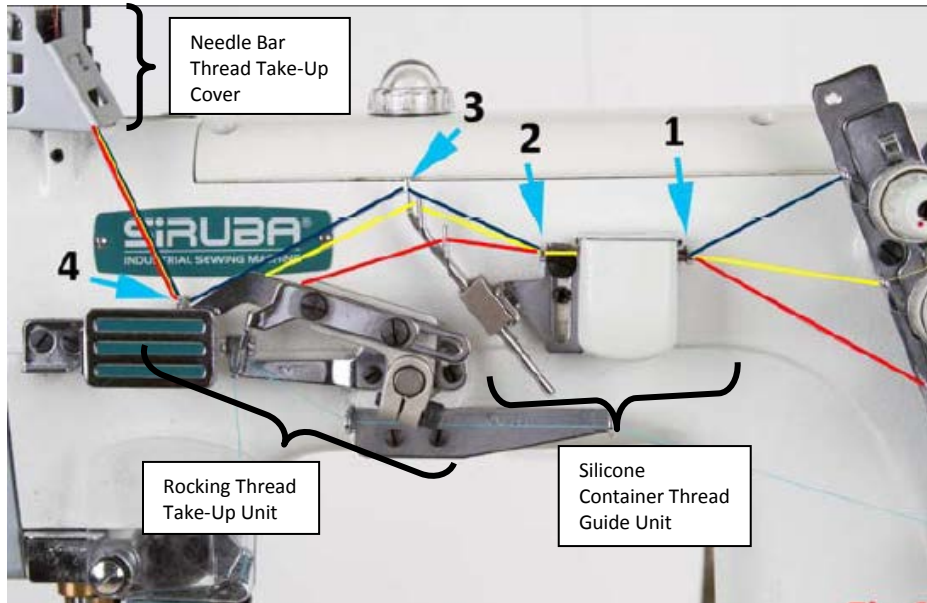
Threading the Needle Threads



Threading one needle thread at a time, follow the same procedure as for the lower looper thread. Ensure the threads go through the holes in the order that they are on the thread stand.

From the spools, thread:

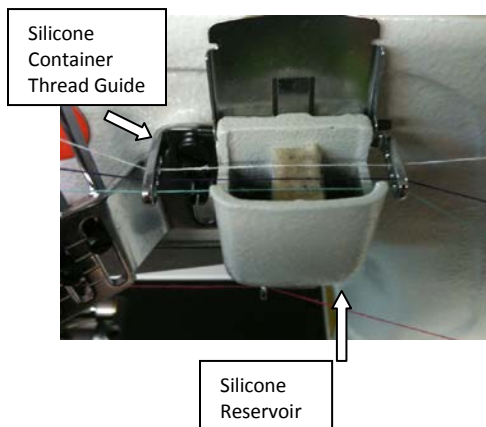
- large thread stand guide arm
- tubular guide arm
- metal thread guide
- tension dial area



Threading continues towards the left of the machine:

- * Silicone Container Thread Guide Unit, and
- * Rocking Thread Take-Up Unit

It is important that the needle threads remain parallel & do not overlap.



Flip open the silicone oil reservoir lid

Thread the right side of the silicone reservoir, over the sponge, and through the left side of Silicone Reservoir.

Depending on the model, the silicone container thread guides vary slightly.

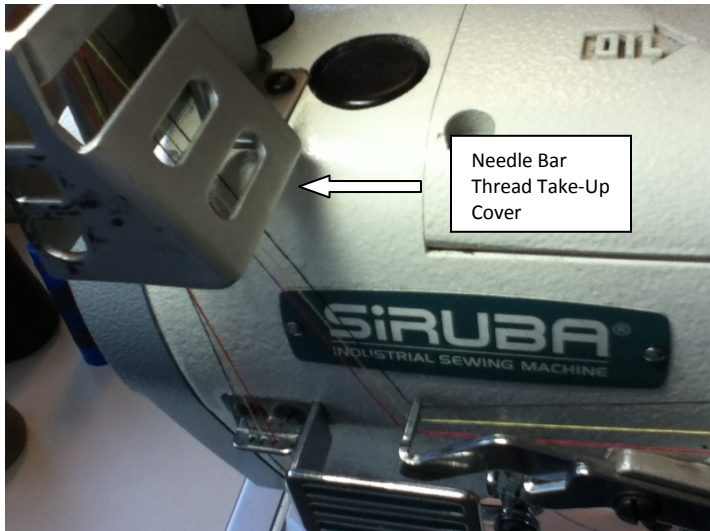
Threading the Needle Threads, cont'd



Bird's Eye View:

Pass the threads through the Rocking Thread Take Up Unit

Ensure that the needle threads are parallel



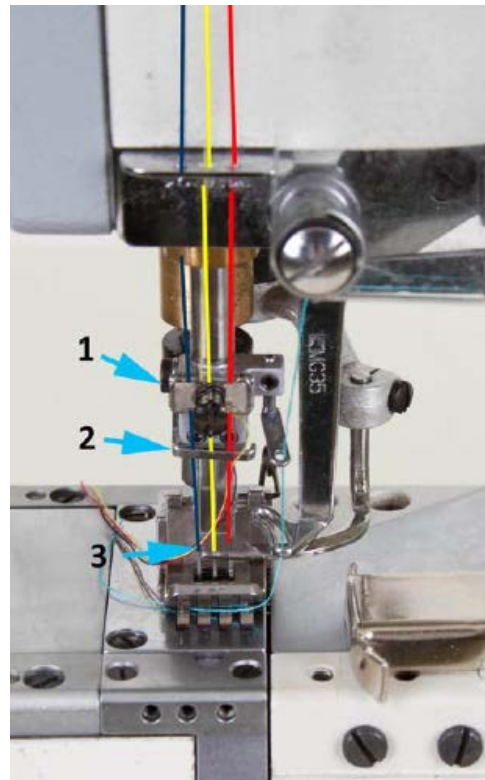
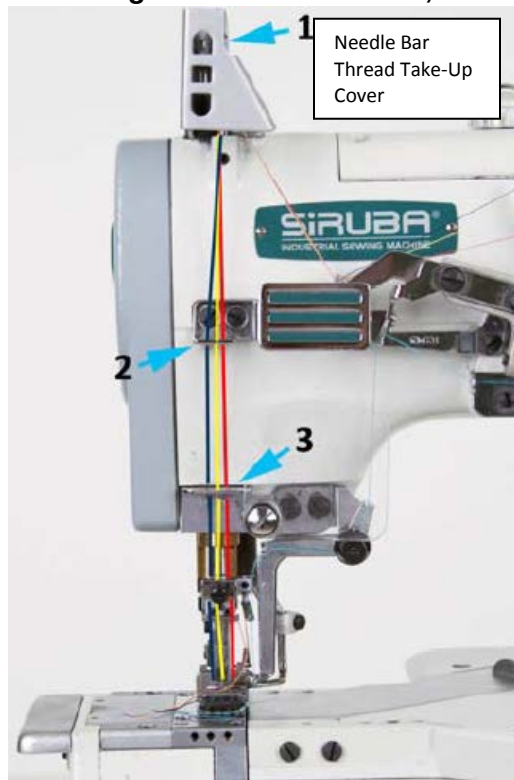
Located on the top, far left of the machine is The Needle Bar Thread Take-Up, which is protected by a cover.

Another set of thread guides is protected by this cover.

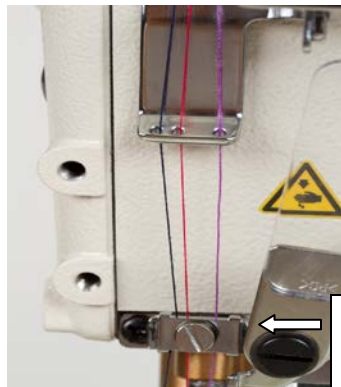


Continue threading, again, making sure that these needle threads remain parallel to each other.

Threading the Needle Threads, cont'd



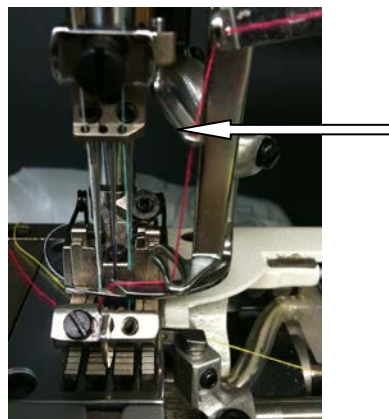
From the Needle Bar Thread Take-Up, continue feeding the threads into the next sets of guides.



Continue threading, sliding thread behind the little metal plate which is held in by a spring loaded screw.

Feed the left needle thread to the left of this screw.

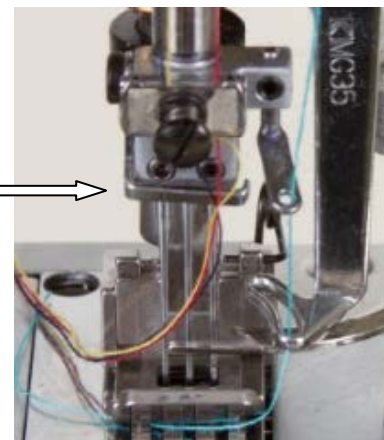
Feed the center and right needle threads to the right of this screw.



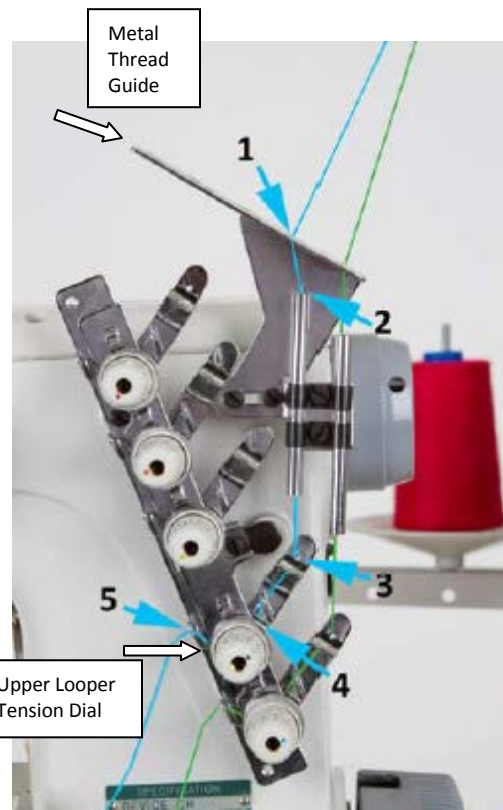
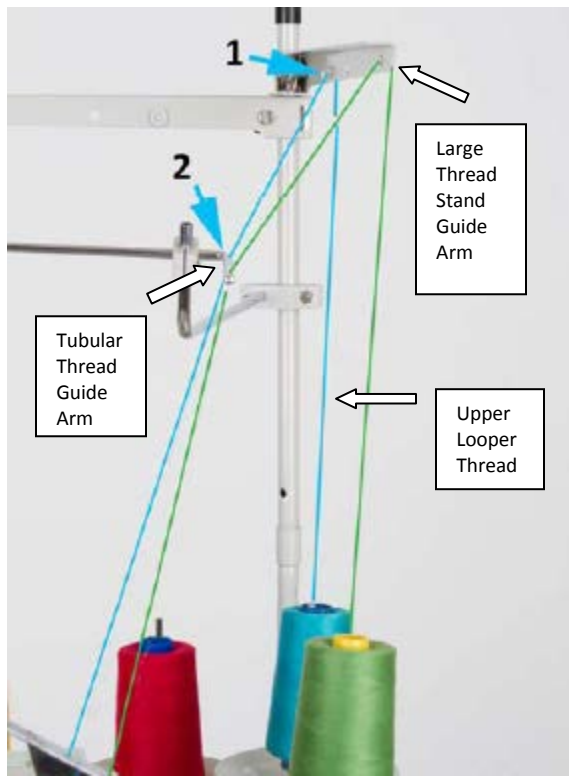
Continue threading down towards the needles

The thread guides below the metal plate vary with the different models

Finish by threading the eye of each needle

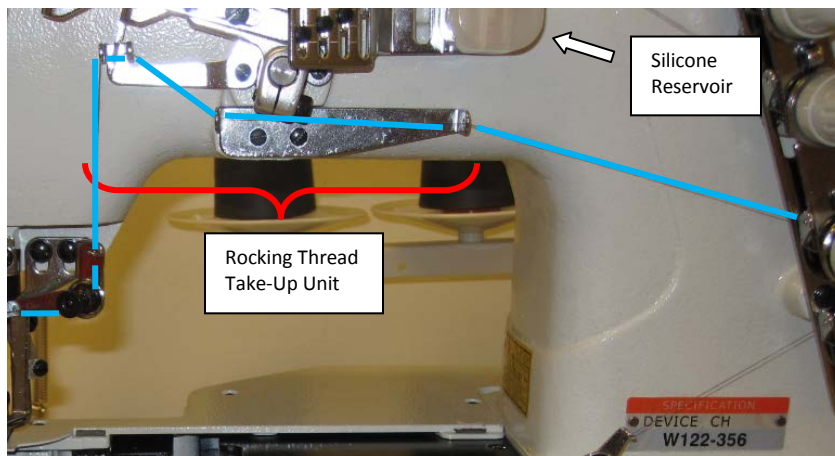


Threading the Upper Looper Thread



From the spools, thread the Blue Upper Looper thread through:

- large thread stand guide arm
- tubular guide arm
- metal thread guide
- tension dial area



From the tension dial area, feed the thread through 2 guides in the rocking thread take-up unit.

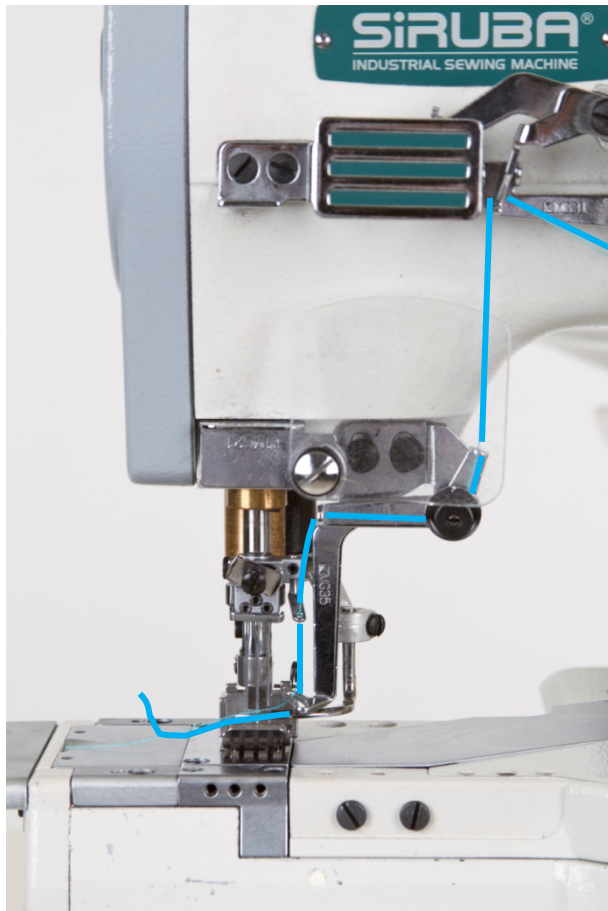
Threading the Upper Looper Thread, cont'd:



Towards the left of the rocking thread take-up unit is an "L" shaped hook.

Thread:

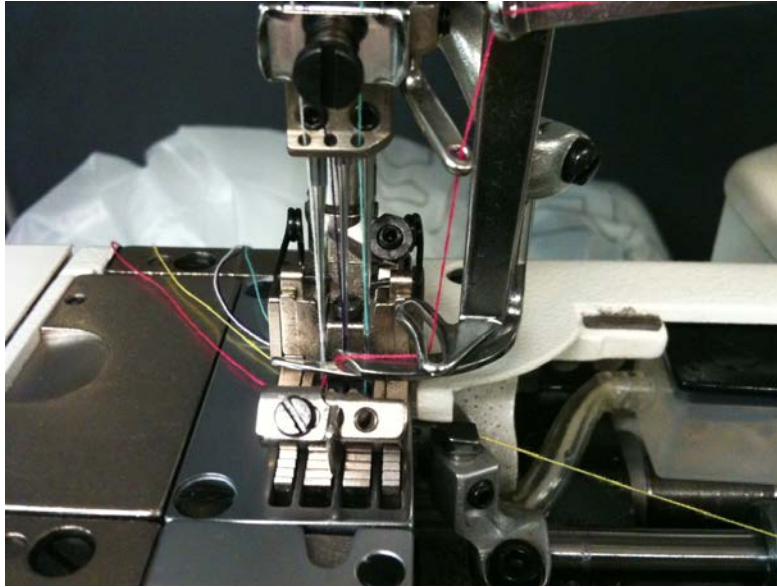
- the little guides to the right of "L" hook
- over the "L" hook
- the guide to the left of the "L" hook



From the "L" shaped rocking thread take-up piece:

- thread guide just above tension dial
- thread around tension dial
- thread guide to the left of tension dial
- thread down to kidney shaped looper

Threading the Upper Looper Thread, cont'd:



After threading into the kidney shaped opening, place thread in front of the “crab claw” shaped hook of the upper looper arm

The upper looper arm moves from side to side

Upper looper stitch forms when the thread is in front of the “crab claw” shaped hook

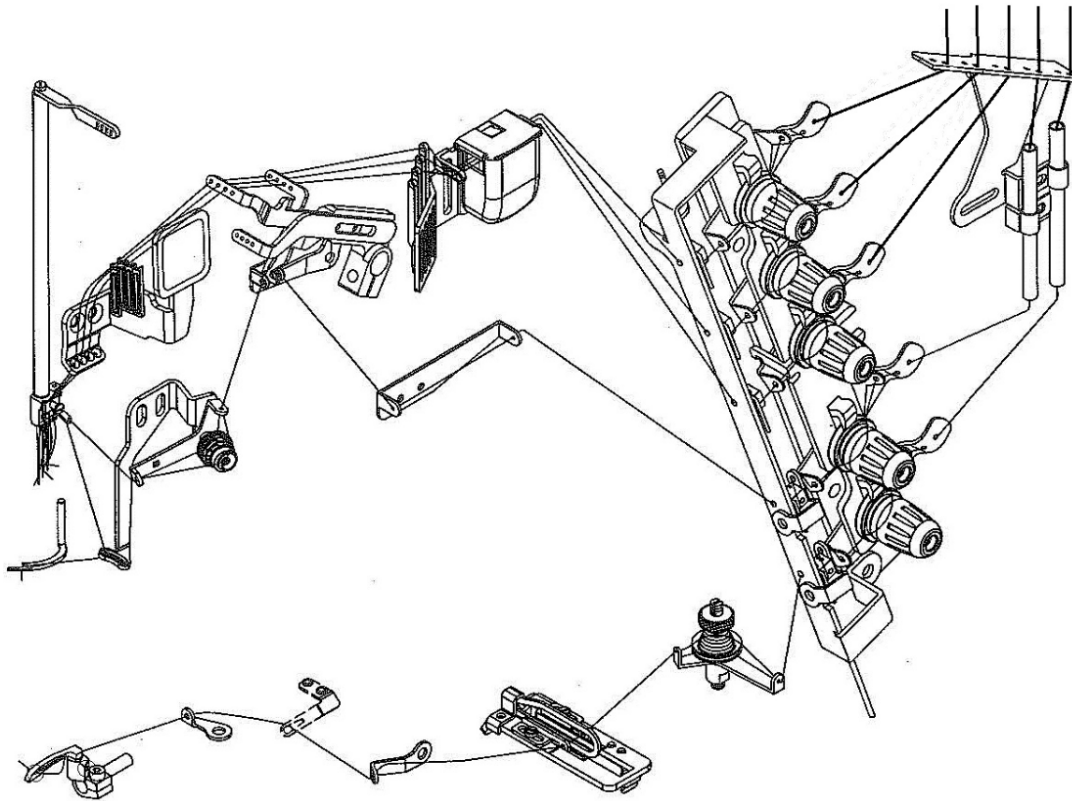


Once threading is complete, move all threads towards the back of machine

After a seam has been sewn:

- make sure needles are at the highest position,
- Press foot pedal to lift presser foot
- hold all threads
- in one continuous move, gently pull threads towards back of machine
- **once you stop pulling,** you cannot continue since the **threads will lock** – do not force

Overall Threading Diagram



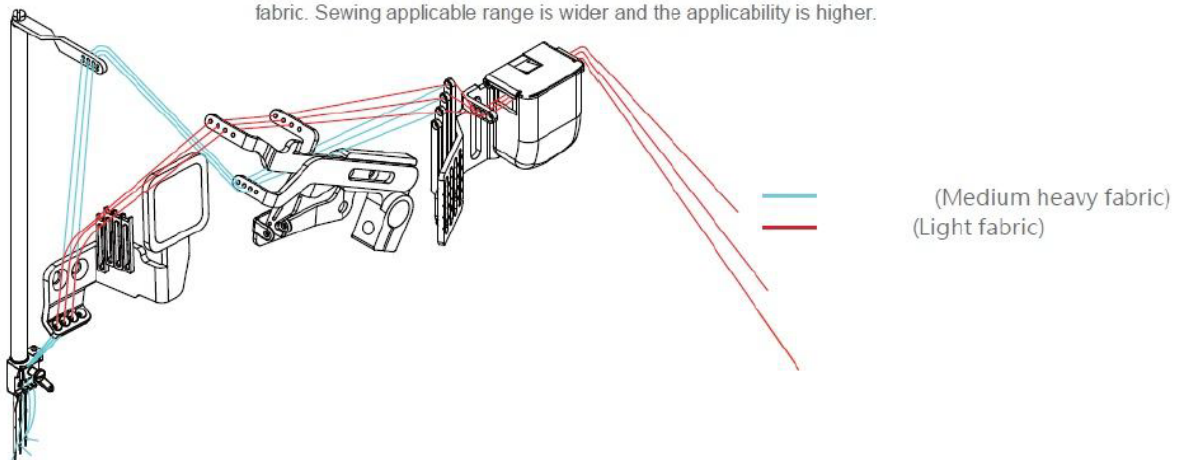
Threading the C007K models:

The Siruba Cover Stitch models C007K have a dual thread take-up mechanism. Follow the threading instructions below for the various weights of fabric.

- LIGHT fabric - follow red lines
 - MEDIUM HEAVY fabric – follow blue lines
- Follow the blue threading for luon pants e.g. groove pants

Dual Thread Take-up Mechanism

The brand new design of dual thread take-up lever thread tension combination is ideal for both heavy and light fabric. Sewing applicable range is wider and the applicability is higher.



Shortcut: Re-Threading Cover Stitch Machine

Re-threading or changing threads is most easily done by using the cut & tie method:



Cut the existing thread at the cone & replace with new cone of thread
Tie the 2 ends together
Repeat for all 5 cones of thread

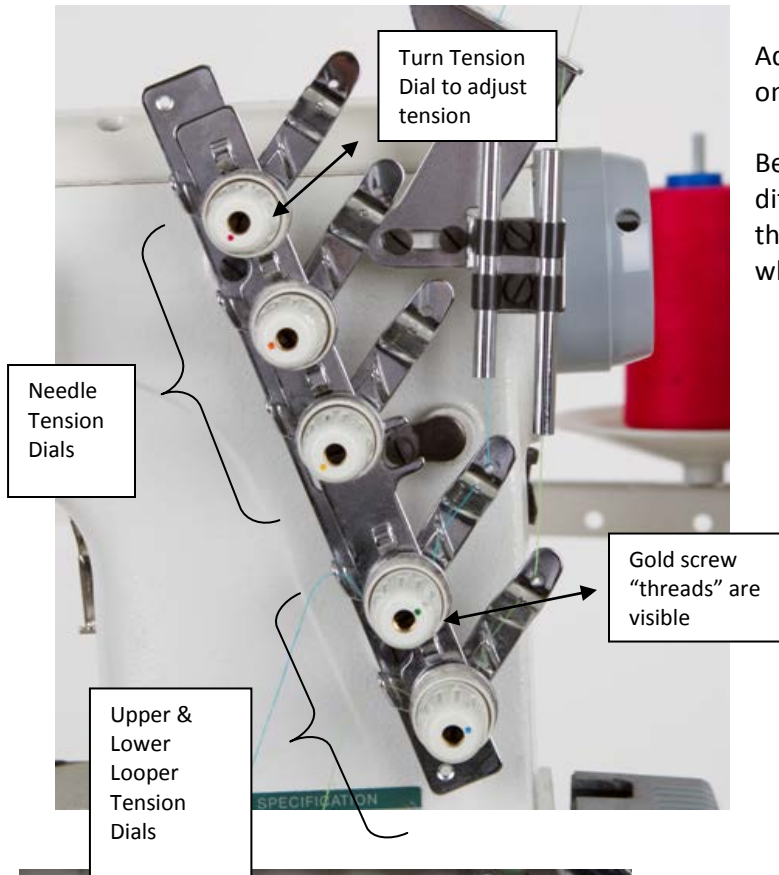
Remove the needle threads at the needle eye
Lift the presser foot
Gently pull the tails of the needle threads through the machine.
Trim threads at the knots & re-thread the needles
Place needle threads at back of machine.

Lift presser foot
Gently pull the tails of the upper & lower looper threads through the machine
Once all new threads are pulled through the machine, place at the back of the machine

Ensure all threads are properly threaded
Resume sewing

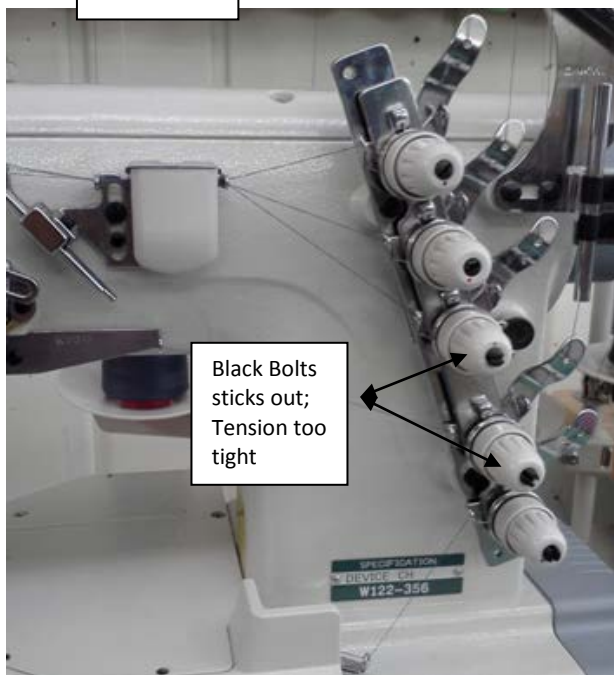
Adjusting Thread Tension

Thread tension should be altered when stitches are not lying flat and threads are bunching on either side of the fabric.



Adjust by turning one dial at a time since only one thread may need the adjustment.

Best practice: Thread the machine with different colored threads to test which thread needs to be altered and to determine when the tension has been fixed.



Notice how the black bolts are protruding. Thread tension is too high

The black bolts should be recessed about 1/8" to 1/4" from the dials & the gold threads visible (see above photo)

To loosen tension:

Turn the tension dial counter clockwise

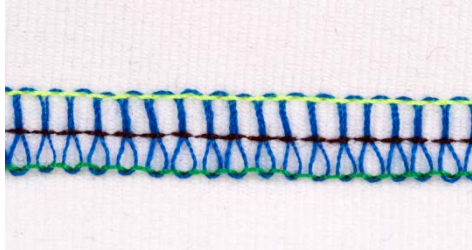
To increase tension:

Turn the tension dial clockwise

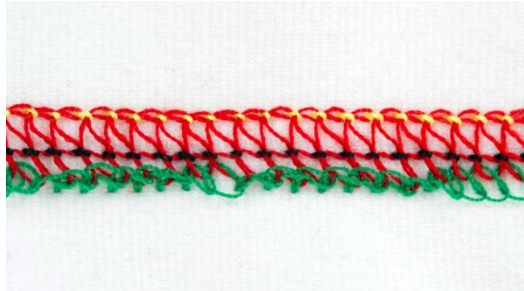
Needle Thread Tension Adjustments

Left Needle (Green Thread) is Loose

Front of Fabric



Back of Fabric

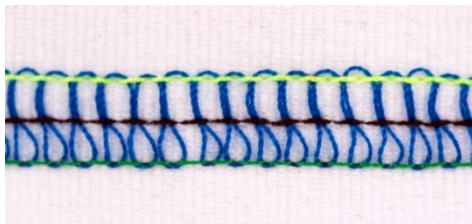


Green thread is too loose, causing it to gather at the back.

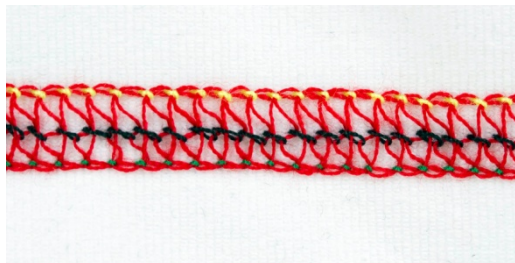
Turn the top Needle Thread Tension Dial clockwise to tighten the stitch

Middle Needle (Black Thread) is Loose

Front of Fabric



Back of Fabric

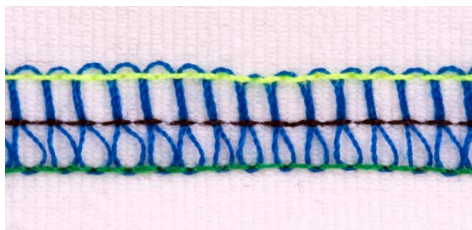


Black needle thread is too loose, causing the inconsistent spacing of the Upper Looper Thread.

Turn the second Needle Thread Tension Dial clockwise to tighten the stitch

Right Needle (Yellow Thread) is Loose

Front of Fabric



Back of Fabric



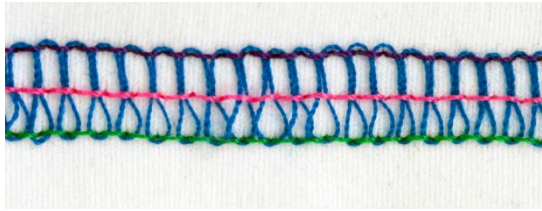
Yellow thread is too loose, causing it to gather in the back and make inconsistent stitches for the Upper & Lower Looper threads.

Turn the third Needle Thread Tension Dial clockwise to tighten the stitch

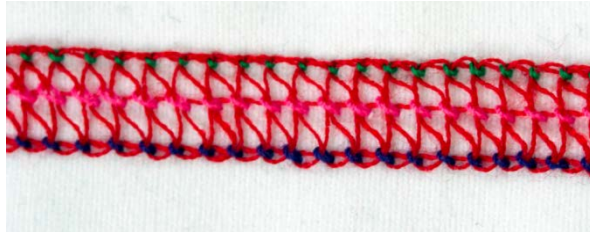
Stitch Length Adjustments

Stitches Too Close Together

Front of Fabric



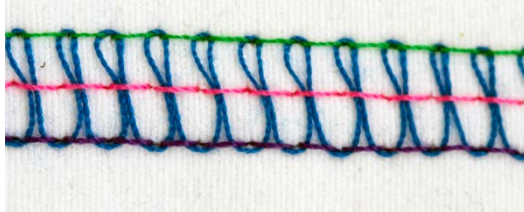
Back of Fabric



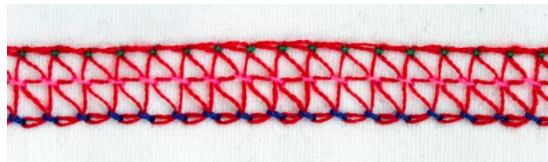
Stitches are too close together, creating a bunched hem.
Turn the Feed Regulating Knob clockwise to increase the stitch length.

Stitches Too Far Apart

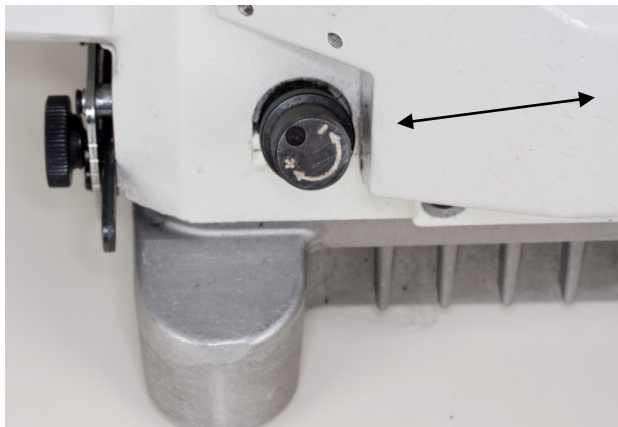
Front of Fabric



Back of Fabric



Stitches are too far apart, creating an uneven looking hem.
Turn the Feed Regulating Knob counter-clockwise to decrease the stitch length.

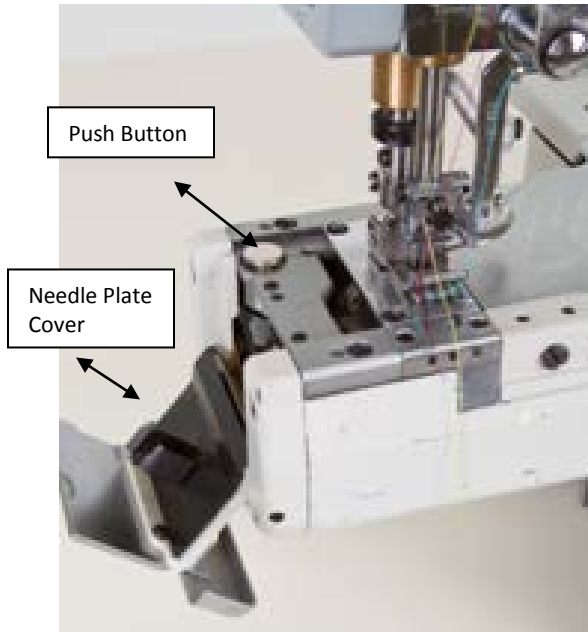


Feed Regulating Knob of Siruba C007J models – fine tunes the stitch length

Settings:

Adjusting the Stitch Length **(Warning: Avoid these Adjustments)**

The necessary stitch length varies depending on the type and thickness of the fabric being sewn. A shorter stitch length can be used for luon® or stretchy fabric and a longer stitch used for thicker fabrics such as cotton



Open the needle plate cover

Locate the push button on the top left corner



While pressing the push button, Turn the upper pulley/handwheel **clockwise** until you feel the push button click/ lock into place

To increase stitch length:

Rotate the upper pulley Counter-Clockwise

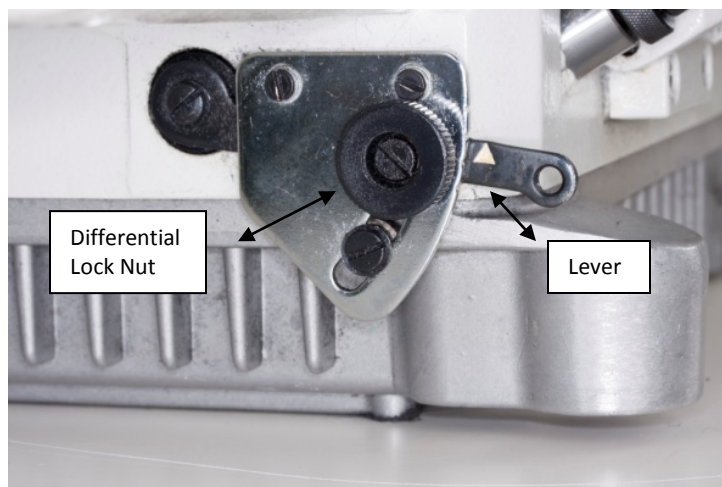
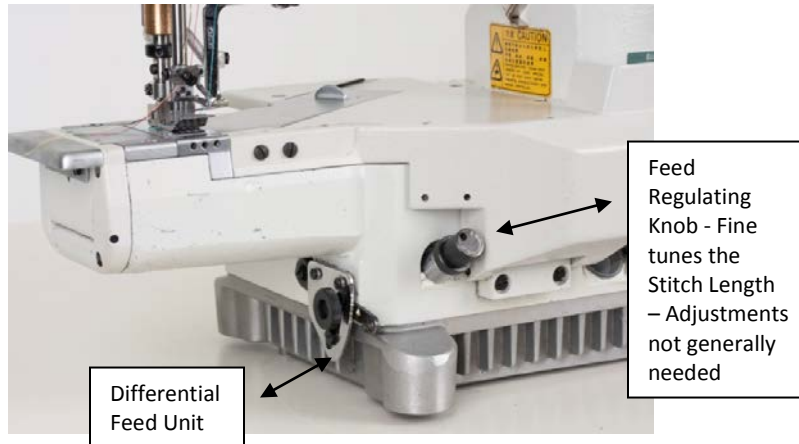
To decrease stitch length:

Rotate the upper pulley Clockwise

This Dial Fine Tunes the Stitch Length – Adjustments not Generally Needed

Adjusting the Differential Feed Ratio (**Warning: Avoid these Adjustments**)

After adjusting the stitch length, the Differential Feed Ratio **must also be changed** to ensure the fabric is fed into the machine at the correct rate. This will prevent the fabric from becoming gathered.



To Increase the Ratio:

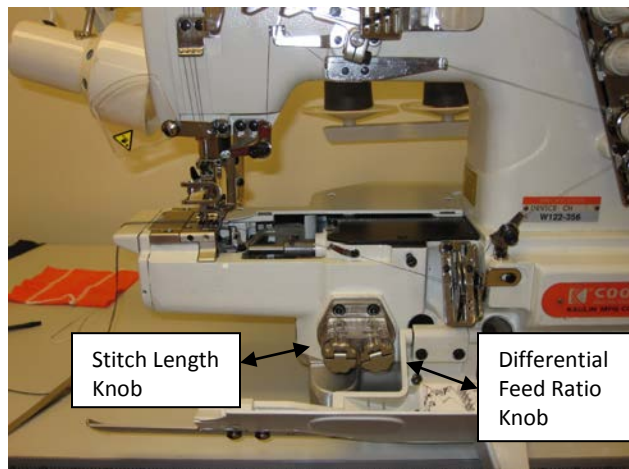
Loosen Differential Lock Nut and move lever **up**

Result: Sewn material is gathered

To Decrease the Ratio:

Loosen Differential Lock Nut and move the lever **down**

Result: Sewn material is stretched



The **Siruba C007K** model:

Stitch Length Knob & Differential Feed Ratio Knobs are located at the front of the machine

To increase stitch length:

Rotate the left knob Clockwise

To decrease stitch length:

Rotate the left knob Counter-Clockwise

After adjusting stitch length, the differential ratio should be changed

Turn Right knob Clockwise to gather fabric

Turn counter-clockwise to stretch the fabric

Adjusting the Presser Foot **(Warning: Avoid these Adjustments)**

The Presser Foot ensures that the fabric being sewn is smoothly moved between the feed dog and the sewing machine foot.

The level of pressure on the Presser foot must be adequate for the thickness of fabric being sewn to ensure the fabric is not gathered or pulled.



Loosen the Lock Nut and turn the Presser Spring Regulator

To increase pressure:

Turn Regulator clockwise

To decrease pressure:

Turn Regulator counter-clockwise

Tighten the Lock Nut after adjustment.

Note: To stabilize stitches, decrease the Presser foot pressure as low as possible so that fabric feeds and sews smoothl

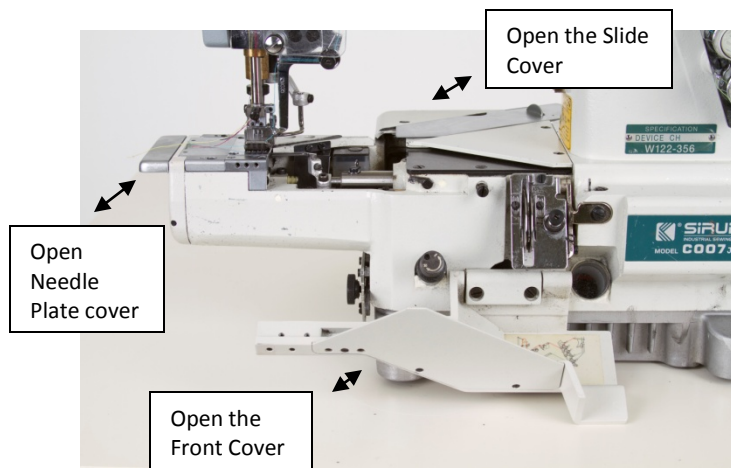
Machine Maintenance Schedule

TASK	FREQUENCY
Vacuum Entire Machine	Daily
Change Silicone Oil	Monthly or as needed
Add High Speed Machine Oil	Monthly or as needed
Complete Oil Change	1 Month after receiving machine & every 6 months
Clean Oil Filter	Monthly
Replace Oil Filter	6 months
Replace Needles	As needed, all 3 needles changed at once

Vacuum Entire Machine

Keep the cover stitch machine in excellent working condition; clean daily or after about 8 hours of use. For efficient & easy cleaning, use cotton swabs, wooden toothpicks & the tools that have been provided to you:

- Husky Vacuum cleaner (on loan to you)
- Small sewing machine cleaning brush



Vacuum Entire Machine, cont'd

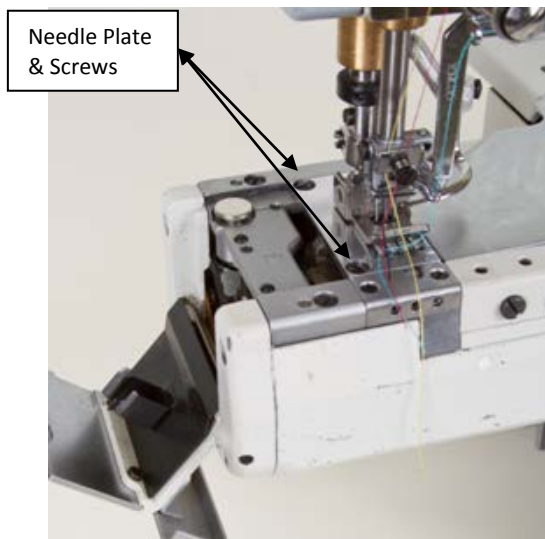


Open the Front Cover, Slide Cover & Needle Plate Covers to expose the inside of the machine

Attach the vacuum nozzle to the end of the vacuum hose

Use the "Suction" function of the vacuum to remove thread & fabric particles inside the machine.

For remaining particles, use "Blow" function. Ensure the nozzle faces upwards, towards an OPEN part of the machine so debris is removed away from the machine and not blown into another section.



To clean between the Feed dog, raise the presser foot
Unscrew 2 Needle Plate screws that hold the Needle Plate in place.

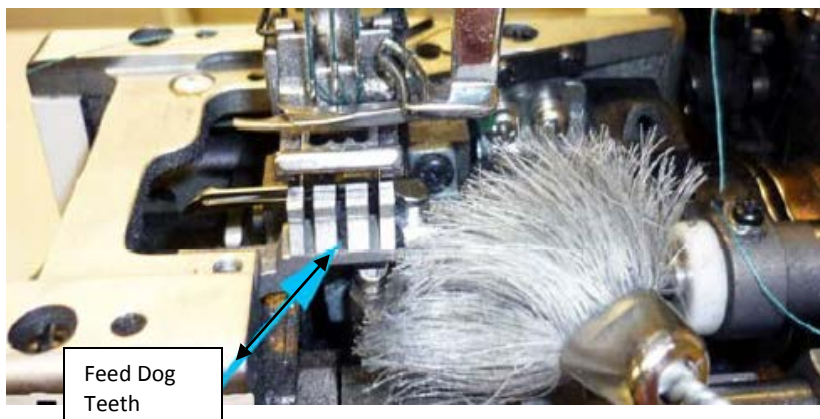
Screws are small, so be sure not to lose them

DO NOT Remove the Presser Foot

Build up of dust & debris in this area can result in:

- Needles breaking
- Machine jamming

It is important to keep this area clean



With the vacuum, "Suction" debris from Feed Dog area.

Use small brush/cotton swab/toothpick to help remove any remaining particles

Replace Needle Plate after cleaning

Changing Silicone Oil

Refer to page 17 for more additional instructions

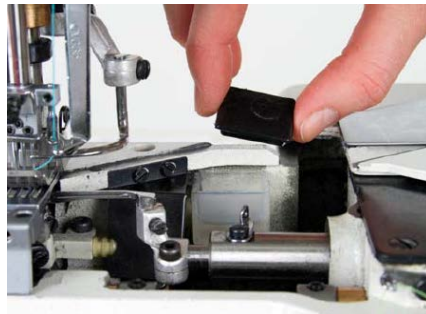
Silicone oil prevents threads from breaking or skipping during sewing.
Change silicone oil when reservoirs contain thread particles.

There are 2 silicone oil reservoirs that must stay clean of thread particles & filled at all times
Thread particles will stick to the thread and will block the machine:

- Front Silicone Reservoir at Top of the machine
- Bottom Silicone Reservoir Inside the Slide Cover



Using paper towel, wipe the inside of each Silicone Container



Add silicone to Front and Bottom Silicone Reservoir until $\frac{3}{4}$ full

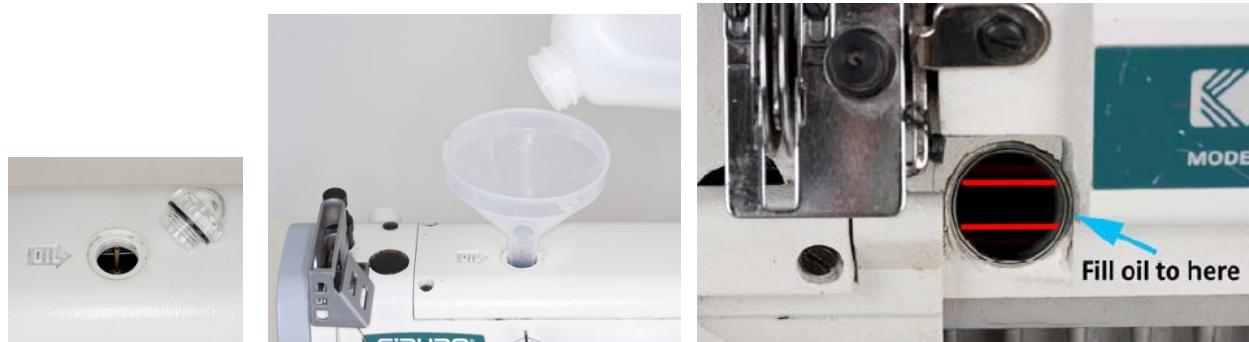
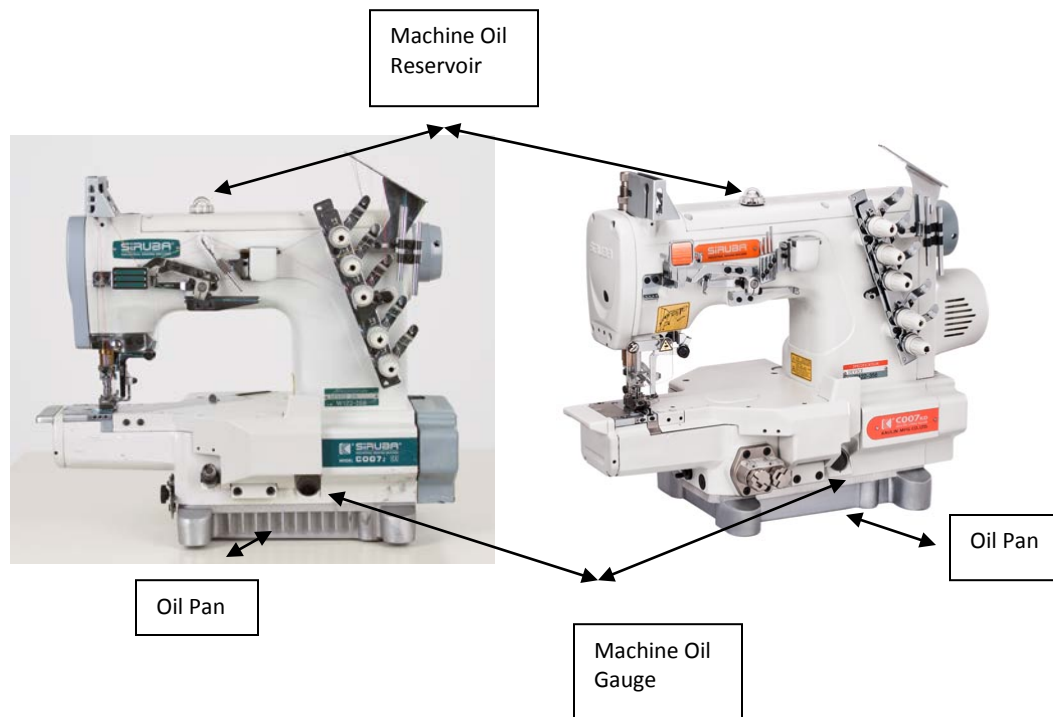
Adding more could cause an overflow.

High Speed Machine Oil

Cover Stitch machines have a reservoir at the base of the machine.

High speed machine oil keeps the parts lubricated and prevents rusting.

It is important that oil level is checked regularly, on a monthly basis and never allowed to run low.



To add machine oil, remove plastic cap at the top of machine.

With a funnel, add about 300 ml of oil, while watching the Oil Gauge

The oil can take some time to go through the machine before registering in the oil gauge.

Let oil flow through for a few minutes

Add remaining machine oil, approx. 300 ml, until gauge shows oil level to reach between the 2 red lines.

Rescrew the plastic cap.

Note: While sewing you may notice oil splashing against the oil reservoir lid – this is normal.

Changing High Speed Machine Oil

Change High Speed Machine Oil after 1 month of use and then every 6 months.

It is highly recommended that 2 people help in changing the oil.

The cover stitch machine head weighs about 100 lbs. and needs to be moved to change the oil.



Cut threads

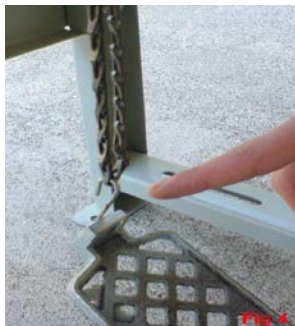
Remove Belt Cover:

Remove the screws on machine head that hold the Belt Cover over the two motor wheels



If present, remove belt cover from motor wheel, located under table

Lift motor belt from the groove in the large metal wheel using a screwdriver as a lever
Turn the Upper Pulley (hand wheel) in a clockwise direction, move the screwdriver to the outside of the wheel to remove the belt from the groove.



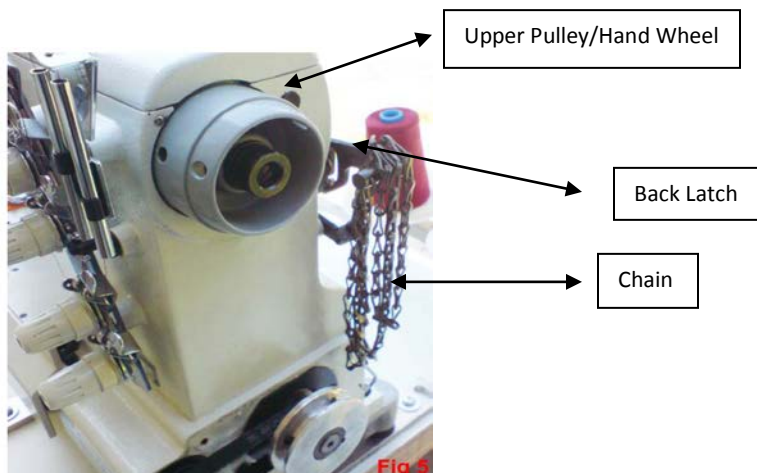
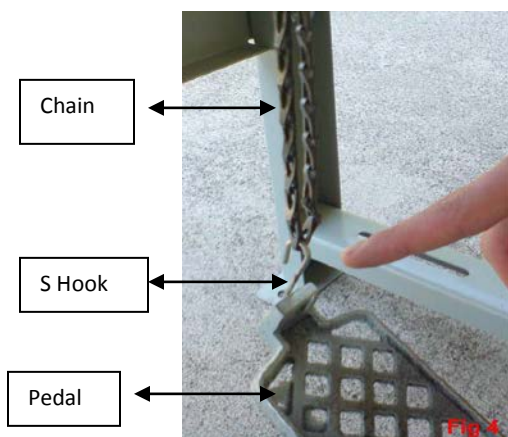
Under the sewing table, an "S" hook connects the pedal to the chain

Unhook chain, pull it up through the top right side of the machine.

Wrap the length of the chain around the back latch, near the upper pulley

Draining the Machine Oil

1. Under the sewing table, an "S" hook connects the pedal to the chain (Fig 4)
 - a. Unhook chain; pull it up through the top right side of the machine.
 - b. Store the "S" hook in accessories box.
 - c. Wrap the length of the chain around the back latch, near the upper pulley (Fig 5)



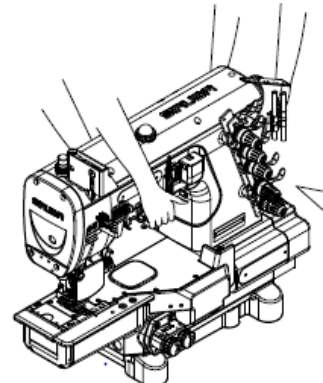
MOVE SEWING MACHINE HEAD

2 people should move the head due to the machine head weighing 90 lbs:

WARNING: To prevent damage, **DO NOT** grab/hold machine by any of the silver parts including: rocking thread take-up, tension dials, needle bar areas



1. **Note:** the machine rests on four small pads and is not screwed or bolted to the table.
2. 1st person uses both hands to lift under the arm of the machine, intertwining fingers OR with one hand, lift under arm of machine and with other hand, lift the front of the machine, but without touching the needle area
3. 2nd person holds upper pulley &/or chain bar located at back of machine &/or motor wheel
4. Move machine to edge of sewing table – **Do Not hold/grab any of the metal pieces**



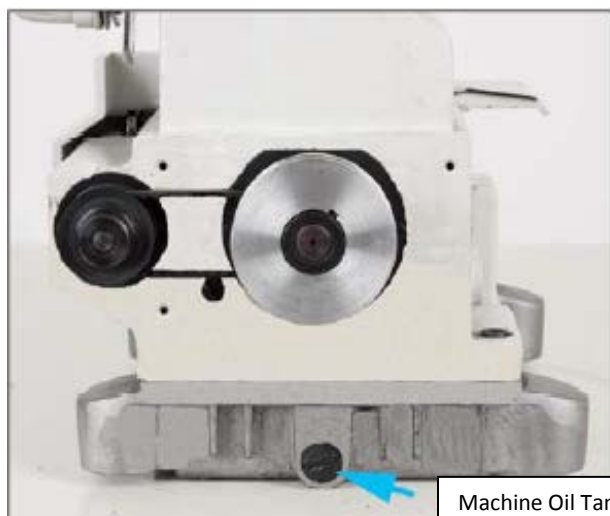
DRAIN THE MACHINE OIL:

The machine oil tank drain is located on the right hand side of the machine by the motor wheel.

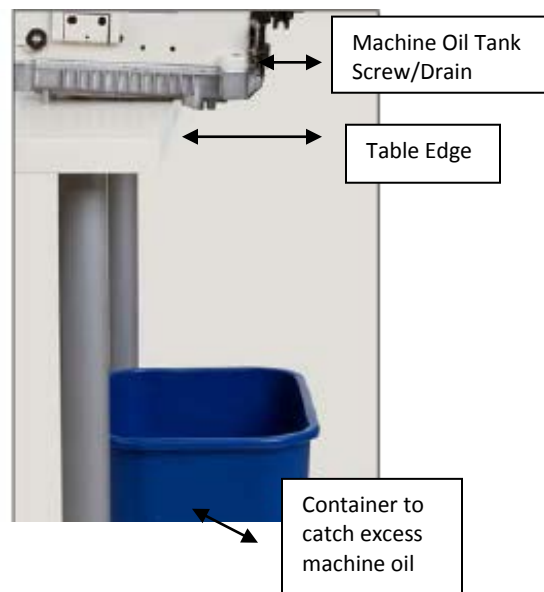
Slide the machine so the drain hangs over the edge of the table.

With a container in place to catch excess oil, loosen the screw and drain all oil from the machine's tank.

Re-fasten the screw.



Machine Oil Tank
Screw/Drain



Machine Oil Tank
Screw/Drain

Table Edge

Container to
catch excess
machine oil

Clean the Oil Filter

Oil Filter must be cleaned monthly and replaced every 6 months to ensure thread and fabric particles are removed from the oil and do not jam the machine.



Filter panel is located at the back, on the right hand side of the machine

Use a screwdriver to remove the screws that hold the panel in place



Remove the filter and tap out any particles that have collected.

Once clean, return the filter & reattach the filter panel.

Note: Some oil may drip out when the filter is removed.
Keep a cloth nearby to wipe any drips.



NEEDLES ON COVER STITCH MACHINE

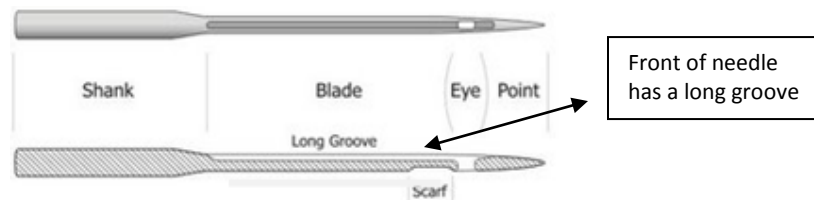
Needles:

Cover Stitch Machine needles are about 1 3/4" long with a long groove along the length of the blade. Groove must face the operator.

Needles must always be in good condition & should be changed after about 8 hours of sewing to prevent problems such as skipping stitches, fraying, etc.

When one needle needs replacing, it is best to change all three at that time.

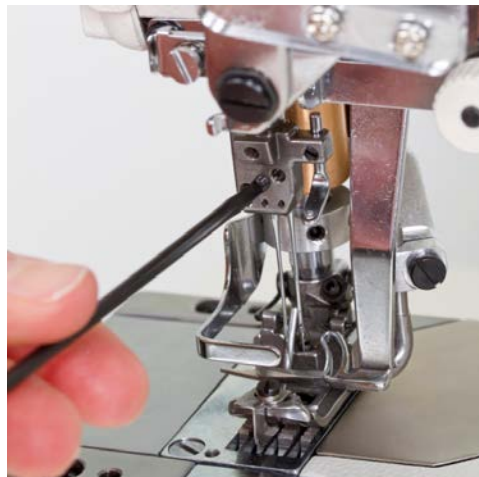
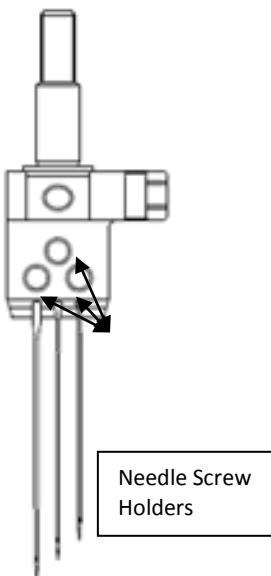
Do not use new needles with old.



Regular or Sharp Point needles are used to sew **woven** fabrics



Ball Point (BP) needles have a rounded tip allowing the tip to glide through the loops of **knit** fabrics



Each needle is held in place by very tiny screw holders

Remove & reinsert needles by loosening the screw right above needle socket

Screw does not need to be completely removed – avoid losing it

Needles, cont'd:



Hold needles with tweezers to make this job easier

When changing needles, all 3 needles should be replaced



Organ Needles, UYx128GAS, are recommended for the Cover Stitch machine

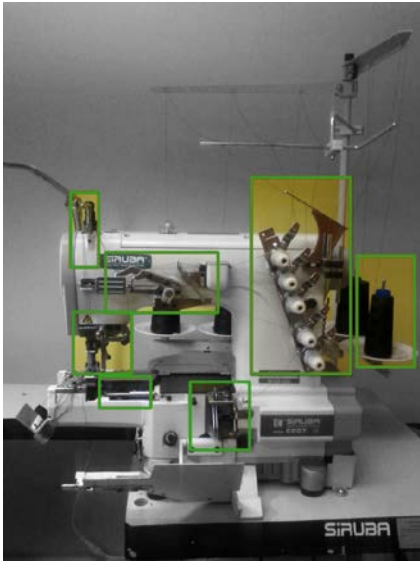
For regular knits e.g. Groove pants: #12 BP

For heavier knits e.g. French Terry: #14 BP

For woven fabrics: #12, #14 Regular needles

Troubleshooting

WARNING: The cover stitch machine is an extremely complex piece of equipment with multiple small parts working together in synchronicity. Seemingly minor adjustments to one part can affect a completely different part of the machine. If you do not understand the objective of the adjustment being made, do not make these adjustments. Other than the adjustments outlined in this manual, do not make any mechanical adjustments. Doing so can result in further misalignment of the machine.

Problem	Examine & Adjustment
Caution: When a problem occurs do not force the machine to move. To prevent potential injury, turn off the power switch & unplug the electrical cord.	Check that threads are able to move freely at the spools Check that thread stand pieces are aligned in an “L” shape Check that machine is correctly threaded Replace all 3 needles Check the thread tension Check silicone oil level Check machine oil level Check that the feed dog area is free of any dust or debris buildup Check that the motor belt is not damaged Clutch motor: 1. check that the voltage is set at 110 Volts & 2. check the Motor Rotation Switch Review the troubleshooting problems & adjustments outlined below If problem persists, take photos as shown below, including:  1. Overall machine 2. Close ups of all the threading points of the machine 3. Open front cover, take photos of lower looper area 4. Sewing Samples, front & back Email hemming@lululemon.com, describe problem & include your pictures as listed
Needle thread too tight/loose	Double check thread tension; adjust one tension dial at a time. It will help to determine which thread needs adjusting by using 5 different thread colors.
Needle thread stitches skip	Check that appropriate sized needle is being used If a needle is blunt, bent, damaged etc. replace all 3 needles Ensure needles are inserted all the way & that long groove faces operator Check & re-thread all threads Double check thread tension; adjust one tension dial at a time. It will help to determine which thread needs adjusting by using 5 different thread colors.

Unable to create stitch	Check the lower looper thread to ensure it is not broken Check that machine is correctly threaded
Upper looper stitch not being created	Ensure the upper looper thread is in front of the “crab claw” shaped hook Check that the upper looper thread tension is not too high – loosen if needed
Stitches are skipping and unraveling	Change all 3 needles, ensure they are properly inserted Ensure needle threads are properly threaded Check that the right sized needle is being used for the fabric being sewn Slow down sewing speed
Threads are breaking	Double check threading & re-thread according to instructions Check that needles are properly inserted with long groove facing operator Loosen the thread tension Check if thread is wider than the needle hole, if so, change needle or change the thread Poor quality thread being used
Needle breaking	Caution: To prevent the broken portion of the needle from getting stuck in the garment and potentially causing injury, please search for all the broken needle pieces If a needle is blunt, bent, damaged etc. replace all 3 needles Ensure needles are inserted properly & that long groove faces operator Check that the right sized needle is being used for the fabric being sewn Double check threading & re-thread according to instructions Double check thread tension; adjust one tension dial at a time. It will help to determine which thread needs adjusting by using 5 different thread colors.
Fabric is puckering or being stretched	Double check thread tension; adjust one tension dial at a time. It will help to determine which thread needs adjusting by using 5 different thread colors. Slow down sewing speed Make small adjustments to the differential feed ratio Make small adjustments to the presser foot pressure
Feed Dog isn't moving the fabric through the machine	Ensure fabric is not being pulled/pushed while sewing
Needle holes are created on the fabric	Check if the needle is blunt. If a needle is blunt, bent, damaged etc. replace all 3 needles Ensure needles are inserted properly & that long groove faces operator The needle is too large for the fabric; use a smaller sized needle