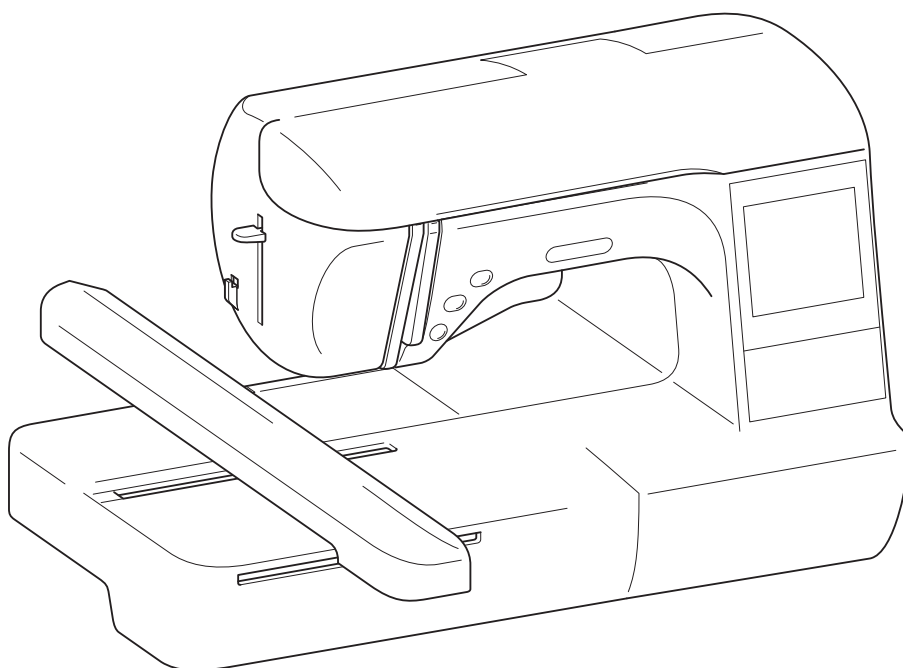


# brother

## *SERVICE MANUAL FOR COMPUTERIZED SEWING MACHINE*



***PE780D/PE770/NV750E  
DZ820E/SB7900E/NV770E***

**CONFIDENTIAL**

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7.2009.  
8.2014.

# GENERAL INFORMATION

This service manual has been compiled for explaining repair procedures of this MODEL.

This was produced based on up-to-date product specifications at the time of issue, but there may have been changes of specifications for the purpose of improvements.

Contact manufacturer or local sales company for information concerning such changes.

Brother Industries, Ltd.  
Nagoya, Japan

**CAUTION** <To do the adjustment and the repair safely and surely, follow the instructions below. >

1. Do the adjustment and the repair according to operation procedure of this service manual.
2. When you attach or remove parts, turn off a power switch and then pull out a power supply plug from outlet.
3. When you replace parts, use regular parts.
4. Do not remodel a sewing machine.
5. Always use earth band when handling printed circuit boards to exclude damage of printed circuit boards by static electricity.
6. Pack printed circuit boards in antistatic packaging and avoid subjecting them to any form of impact during storage or transportation.
7. Do not touch or damage the metal portion of a printed circuit board with a screwdriver or any other tool while making repairs or the like.
8. Insert removed connectors into the proper position according to special instructions of wiring for this service manual at the repair, the adjustment and replace printed circuit boards.
9. When you remove a connector from printed circuit boards, remove it while having a connector part.  
(When you pull out a connector while having a lead wire part, there is a risk that a lead wire get broken.)
10. Do not damage lead wires, when you cut a band that bind up lead wires.



<b>1. Outline of Mechanism .....</b>	<b>1 - 1</b>
Main Mechanisms .....	1 - 2
Driveline .....	1 - 3
Positions of electronic components .....	1 - 4
Control system block diagram .....	1 - 5
Operation of other electronic components .....	1 - 6
<b>2. Disassembly .....</b>	<b>2 - 1</b>
Main parts .....	2 - 2
Embroidery removal .....	2 - 3
Top cover removal .....	2 - 3
Face plate removal and disassembly .....	2 - 4
Front thread guard cover removal .....	2 - 4
Needle plate B removal and disassembly .....	2 - 5
Free arm cover removal .....	2 - 5
Front cover removal .....	2 - 6
Board plate A removal .....	2 - 7
Card cover removal .....	2 - 7
Main PCB assembly removal .....	2 - 7
Main PCB holder assembly removal .....	2 - 8
Touch panel assembly removal .....	2 - 8
Indication panel removal .....	2 - 8
Front cover disassembly (bobbin winder guide assembly removal) .....	2 - 9
Front cover disassembly (spool pin holder removal) .....	2 - 9
Front cover disassembly (SS-VR PCB assembly removal) .....	2 - 10
Front cover disassembly (SV cover removal) .....	2 - 10
Rear cover removal .....	2 - 11
Handle removal .....	2 - 11
Electrical parts and motors .....	2 - 12
Power supply unit F removal .....	2 - 13
PCB Unit LED lamp FL removal .....	2 - 13
Base plate sub assy. removal .....	2 - 13
Connector holder assembly removal and disassembly .....	2 - 14
Base plate cover and inlet assembly removal .....	2 - 14
Base rubber removal .....	2 - 14
Timing belt (motor belt) removal .....	2 - 15
Motor fan removal .....	2 - 15
Main motor assembly removal .....	2 - 15
Main motor assembly disassembly .....	2 - 16
Coating clip removal .....	2 - 16
Motor PCB assy. removal .....	2 - 16
NP PCB assy. removal .....	2 - 17
Belt guard removal .....	2 - 17
Thread tension mechanism .....	2 - 18
Thread tension assy removal .....	2 - 19
Upper thread PCB unit removal .....	2 - 19
Upper thread PCB unit disassembly .....	2 - 19
Thread guide removal .....	2 - 20
Thread guide cover removal .....	2 - 20
Tension plate removal .....	2 - 20

Thread release holder assy. F removal .....	2 - 21
PF-F SW assy. removal .....	2 - 21
Thread guide shutter removal .....	2 - 21
Tension releaser link removal .....	2 - 22
Plate assembly removal .....	2 - 22
Thread guide removal .....	2 - 22
Thread tension gear removal .....	2 - 22
AT pulse motor removal .....	2 - 23
Tension disk removal .....	2 - 23
Thread take up spring removal .....	2 - 23
Thread guide wire removal .....	2 - 24
<b>Bobbin winder mechanism .....</b>	<b>2 - 25</b>
Bobbin winder cover removal .....	2 - 26
Bobbin base disassembly .....	2 - 26
Bobbin presser removal .....	2 - 26
Bobbin winder assembly removal .....	2 - 26
BW holder supporter removal .....	2 - 27
BW-F SW assy. removal .....	2 - 27
BW shaft holder assembly removal .....	2 - 27
Bobbin winder shaft stopper removal .....	2 - 27
<b>Rotary hook drive mechanism / Feed and bobbin mechanism / Cutter assy. mechanism ...</b>	<b>2 - 28</b>
Coating clip removal .....	2 - 29
Thread cutter module removal .....	2 - 29
Feed module removal .....	2 - 29
Lower shaft A assy. removal .....	2 - 30
Joint removal .....	2 - 30
Timing pulley D removal .....	2 - 30
Lower shaft bushing removal .....	2 - 30
<b>Needle bar, presser mechanism / Upper shaft mechanism .....</b>	<b>2 - 31</b>
Upper shaft removal .....	2 - 32
Pulley removal .....	2 - 32
Upper shaft pulley removal .....	2 - 32
Tension pulley assembly removal .....	2 - 32
Needle-presser module removal .....	2 - 33
Plate spring removal .....	2 - 34
<b>Needle-presser module .....</b>	<b>2 - 35</b>
Quilting foot removal .....	2 - 36
Adjusting plate assy. removal .....	2 - 36
Adjusting plate ASSY disassembly .....	2 - 36
Guard plate removal .....	2 - 36
Spring removal .....	2 - 37
Lock nut removal .....	2 - 37
Needle bar assy. removal .....	2 - 37
Needle bar assy. disassembly .....	2 - 37
Needle holder guide assy. removal .....	2 - 38
Lever A spring removal .....	2 - 38
Needle bar supporter assy. removal .....	2 - 38
Lever AB assy. removal .....	2 - 39
Lever AB assy. disassembly .....	2 - 39
Shaft bushing A removal .....	2 - 39
Thread guide plate removal .....	2 - 40
Hook release plate removal .....	2 - 40
Threader hook assy. disassembly .....	2 - 40

Presser foot lifter removal .....	2 - 41
Thread take-up assy. removal .....	2 - 41
Thread take-up counter weight removal .....	2 - 42
Presser bar removal .....	2 - 42
Thread take-up lever link removal .....	2 - 43
Shaft bushing assembly removal .....	2 - 43
<b>Feed module .....</b>	<b>2 - 44</b>
Needle plate A removal .....	2 - 45
Needle plate A disassembly .....	2 - 45
Inner rotary hook bracket assy. removal .....	2 - 45
Cord supporter removal .....	2 - 45
Photo diode holder assembly removal .....	2 - 46
Photo diode assembly disassembly .....	2 - 46
Outer rotary hook assy. removal .....	2 - 46
Lower shaft B assy. removal .....	2 - 47
Lower shaft B assy. disassembly .....	2 - 47
Stopper plate block assy. removal .....	2 - 48
Bushing supporter B assy. removal .....	2 - 48
Bushing presser B removal .....	2 - 48
<b>Thread cutter module .....</b>	<b>2 - 49</b>
Thread cutter frame assembly removal .....	2 - 50
Photo transistor assembly removal .....	2 - 50
Presser plate removal .....	2 - 50
Cutter holder assembly removal .....	2 - 51
Thread hook assy. disassembly .....	2 - 51
Rubber removal .....	2 - 51
Thread cutter lever assy. removal .....	2 - 52
Thread cutter lever assy. disassembly .....	2 - 52
Idle gear A and idle gear B removal .....	2 - 52
Pulse motor C removal .....	2 - 52
<b>Embroidery parts .....</b>	<b>2 - 53</b>
YPM cover removal .....	2 - 54
X carriage cover removal .....	2 - 54
ES main cover assembly removal .....	2 - 55
Groove cover removal .....	2 - 55
Lead wire assembly (EMB unit FCOMB) removal .....	2 - 56
ES base cover unit removal .....	2 - 56
Lock release lever assembly removal .....	2 - 57
Lock release lever ASSY disassembly .....	2 - 57
Rubber cushion and rubber cushion cover removal .....	2 - 57
Groove cover removal .....	2 - 58
EMB relay PCB assembly removal .....	2 - 58
X belt presser removal .....	2 - 58
XY carriage unit removal .....	2 - 59
Oil guard plate removal .....	2 - 59
X pulse motor assembly removal .....	2 - 59
X tension pulley assembly removal .....	2 - 60
X tension pulley ASSY disassembly .....	2 - 60
X driving gear pulley removal .....	2 - 60
X initial shutter removal .....	2 - 61
X slider removal .....	2 - 61
Cord guide removal .....	2 - 61
Lead wire assembly YPM relay removal .....	2 - 61
Y slider removal .....	2 - 62

Y carriage unit removal .....	2 - 62
Y carriage ASSY disassembly .....	2 - 63
Y pulse motor assembly removal .....	2 - 63
Y tension pulley assembly removal .....	2 - 64
Y tension pulley ASSY disassembly .....	2 - 64
Y driving gear pulley assembly removal .....	2 - 65
Y sensor PCB assembly removal .....	2 - 65

### **3. Assembly .....3 - 1**

#### **Needle bar, presser mechanism / upper shaft mechanism .....3 - 2**

Plate spring attachment .....	3 - 3
Needle-presser module attachment .....	3 - 4
Upper shaft pulley attachment .....	3 - 4
Pulley attachment .....	3 - 5
Upper shaft assy. attachment .....	3 - 5
Connecting the needle-presser module and upper shaft .....	3 - 6
Tension pulley assembly attachment .....	3 - 6

#### **Rotary hook drive mechanism / Feed and bobbin mechanism /Cutter assy. mechanism .....3 - 7**

Assembling the Lower shaft A assembly .....	3 - 8
Timing pulley D attachment .....	3 - 8
Joint attachment .....	3 - 8
Lower shaft A attachment .....	3 - 9
feed module attachment .....	3 - 9
Thread cutter module attachment .....	3 - 10
Coating clip attachment .....	3 - 10

#### **Bobbin winder mechanism .....3 - 11**

Bobbin winder shaft stopper (bobbin winder assembly holder) assembly .....	3 - 12
BW shaft holder assembly attachment .....	3 - 12
BW-F SW assy. attachment .....	3 - 12
BW holder supporter attachment .....	3 - 13
Bobbin winder holder assembly attachment .....	3 - 13
Bobbin presser assembly .....	3 - 13
Bobbin winder cover attachment .....	3 - 14
Bobbin base assembly .....	3 - 14
Bobbin base attachment .....	3 - 14

#### **Thread tension mechanism .....3 - 15**

Spring tape attachment .....	3 - 16
Thread guide wire attachment .....	3 - 16
Thread take up spring attachment .....	3 - 17
Tension disk attachment .....	3 - 18
AT pulse motor attachment .....	3 - 18
Thread tension gear attachment .....	3 - 19
Thread guide attachment .....	3 - 19
Plate assembly attachment .....	3 - 19
Tension releaser link attachment .....	3 - 20
Thread guide shutter assembly .....	3 - 20
PF-F SW assy. assembly .....	3 - 20
Thread release holder assy. attachment .....	3 - 21
Upper thread PCB unit assembly .....	3 - 21
Upper thread PCB unit attachment .....	3 - 21
Tension plate attachment .....	3 - 22
Thread guide cover attachment .....	3 - 22
Thread guide cover assembly .....	3 - 23

Thread tension assy. attachment .....	3 - 23
<b>Electrical parts and motors .....</b>	<b>3 - 24</b>
Belt guard attachment .....	3 - 25
NP PCB assy. attachment .....	3 - 25
Motor PCB assy. attachment .....	3 - 25
Assembly of main motor assembly .....	3 - 25
Main motor assembly attachment .....	3 - 26
Motor fan attachment .....	3 - 26
Base plate rubber attachment .....	3 - 26
Inlet assy. and base plate cover attachment .....	3 - 26
Connector holder ASSY assembly and attachment .....	3 - 27
Base plate attachment .....	3 - 27
Power supply unit F attachment .....	3 - 27
PBC unit LED lamp-FL attachment .....	3 - 28
Wire clip attachment .....	3 - 28
Cord treatment .....	3 - 28
<b>Main parts .....</b>	<b>3 - 29</b>
Handle assembly and attachment .....	3 - 30
Rear cover attachment .....	3 - 30
Front cover assembly (SV cover attachment) .....	3 - 31
Front cover assembly (SS-VR F PCB assy. attachment) .....	3 - 31
Front cover assembly (spool pin attachment) .....	3 - 32
Front cover assembly (assembling bobbin winder guide assembly) .....	3 - 32
Indication panel attachment .....	3 - 32
Touch panel assembly attachment .....	3 - 33
Main PCB holder assembly attachment .....	3 - 33
Main PCB assembly attachment .....	3 - 34
Card cover attachment .....	3 - 34
Board plate A attachment .....	3 - 34
Front cover attachment .....	3 - 35
Free arm cover attachment .....	3 - 36
Front thread guide cover attachment .....	3 - 36
Assembling needle plate B assy .....	3 - 36
Needle plate B assy. attachment .....	3 - 36
Face plate assembly .....	3 - 37
Face plate assy. attachment .....	3 - 37
Top cover attachment .....	3 - 37
Embroidery attachment .....	3 - 38
<b>Needle-presser module .....</b>	<b>3 - 39</b>
Shaft bushing assembly attachment .....	3 - 40
Thread take-up lever link assembly .....	3 - 40
Presser bar attachment .....	3 - 41
Thread take-up counter weight attachment .....	3 - 42
Thread take-up lever assy. attachment .....	3 - 43
Presser foot lifter attachment .....	3 - 44
Threader hook assy. attachment .....	3 - 45
Hook release plate attachment .....	3 - 45
Thread guide plate attachment .....	3 - 46
Shaft bushing A attachment .....	3 - 46
Assembling the Lever AB assy .....	3 - 46
Lever AB assy. attachment .....	3 - 47
Needle bar supporter assy. attachment .....	3 - 47
Lever A spring attachment .....	3 - 48
Needle holder guide assy attachment .....	3 - 48



Needle bar assembly .....	3 - 48
Needle bar assembly attachment .....	3 - 49
Lock nut attachment .....	3 - 49
Spring (for needle bar supporter assy.) attachment .....	3 - 50
Gurd plate attachment .....	3 - 50
Adjusting plate ASSY assembly .....	3 - 50
Adjusting plate assy. attachment .....	3 - 50
Quilting foot attachment .....	3 - 51
<b>Feed module .....</b>	<b>3 - 52</b>
Bushing supporter assy. assembly .....	3 - 53
Bushing support assy. attachment .....	3 - 53
Stopper plate block assy. attachment .....	3 - 53
Assembling the lower shaft B assy .....	3 - 54
Lower shaft B assy. attachment .....	3 - 55
Outer rotary hook assy. attachment .....	3 - 56
Photo diode holder ASSY assembly .....	3 - 56
Photo diode holder assembly attachment .....	3 - 56
Cord holder attachment .....	3 - 57
Inner rotary hook bracket assy. attachment .....	3 - 57
Needle plate A ASSY assembly .....	3 - 57
Needle plate A assy. attachment .....	3 - 58
<b>Thread cutter module .....</b>	<b>3 - 59</b>
C pulse motor attachment .....	3 - 60
Idle gears A and B attachment .....	3 - 60
Assembling the thread cutter lever assy .....	3 - 61
Thread cutter lever assy. attachment .....	3 - 61
Rubber and spacer attachment .....	3 - 61
Assembling the thread hook assy .....	3 - 62
Cutter holder assembly attachment .....	3 - 62
Presser plate assy. attachment .....	3 - 62
Sensor holder attachment .....	3 - 63
Thread cutter check .....	3 - 63
Grease applications .....	3 - 63
Thread cutter frame assembly attachment .....	3 - 64
CPM lead processing .....	3 - 64
<b>Embroidery parts .....</b>	<b>3 - 65</b>
Y sensor PCB assembly attachment .....	3 - 66
Y driving gear pulley assembly attachment .....	3 - 66
Y tension pulley assembly attachment .....	3 - 67
Y tension pulley assembly attachment .....	3 - 67
Y pulse motor assembly attachment .....	3 - 68
Y carriage ASSY assembly .....	3 - 68
Y carriage unit attachment .....	3 - 69
Y slider attachment .....	3 - 69
Lead wire assembly YPM relay attachment .....	3 - 69
Cord guide attachment .....	3 - 70
X slider attachment .....	3 - 70
X initial shutter attachment .....	3 - 70
X driving gear pulley attachment .....	3 - 71
X tension pulley ASSY assembly .....	3 - 71
X tension pulley ASSY attachment .....	3 - 72
X pulse motor assembly attachment .....	3 - 72
Oil guard plate attachment .....	3 - 73
XY carriage unit removal .....	3 - 73

X belt presser removal .....	3 - 74
EMB relay PCB assembly attachment .....	3 - 74
Groove cover attachment .....	3 - 74
Rubber cushion and rubber cushion cover attachment .....	3 - 75
Lock release lever ASSY assembly .....	3 - 75
Lock release lever assembly attachment .....	3 - 75
ES base cover unit attachment .....	3 - 76
Lead wire assembly (EMB unit FCOMB) attachment .....	3 - 76
Groove cover attachment .....	3 - 77
ES main cover assembly attachment .....	3 - 77
X carriage cover attachment .....	3 - 78
YPM cover attachment .....	3 - 78

#### **4. Adjustment .....4 - 1**

Needle point damage .....	4 - 2
Starting test mode .....	4 - 3
List of the Test Mode .....	4 - 4
Touch panel .....	4 - 5
Timing belt tension .....	4 - 6
Motor belt tension .....	4 - 7
Fine tension .....	4 - 8
Upper thread tension .....	4 - 9
Needle left/right position .....	4 - 10
Needle bar rising .....	4 - 11
Needle bar height .....	4 - 12
Clearance between needle and rotary hook point .....	4 - 13
Needle threader .....	4 - 14
Presser bar height .....	4 - 15
Bobbin winder .....	4 - 16
Needle and presser foot front/back position .....	4 - 17
Inner rotary hook bracket position .....	4 - 18
Inner rotary hook assy. (lower thread) tension .....	4 - 19
Belt tension (embroidery unit) .....	4 - 20
Embroidery unit center position .....	4 - 21

<b>5. Failure Investigation for Electronic Parts .....</b>	<b>5 - 1</b>
Error message list .....	5 - 2
The power does not come on .....	5 - 3
Pulse motors do not return to starting position .....	5 - 5
The touch panel does not work .....	5 - 6
LCD backlight does not come on .....	5 - 7
Main motor does not turn .....	5 - 8
Main motor rotation abnormal .....	5 - 10
Cannot sew pattern correctly .....	5 - 11
Thread tensioning is not correct .....	5 - 12
Thread cutter does not work normally .....	5 - 13
Bobbin winding cannot be done .....	5 - 14
Lamp does not come on .....	5 - 15
Bobbin thread detection does not work normally .....	5 - 17
Upper thread sensor does not work normally .....	5 - 18
Card cannot be used normally .....	5 - 19
Embroidery unit does not operate normally .....	5 - 21
Error is displayed .....	5 - 24
Replacement of main PCB assy or motor PCB assy .....	5 - 27
Correspondence table of “Model” and “Printed-circuit board” .....	5 - 28
<b>6. Repair Manual .....</b>	<b>6 - 1</b>
<b>7. Special Instructions of Wiring .....</b>	<b>7 - 1</b>
Needle bar module wiring .....	7 - 2
Rotary hook module wiring .....	7 - 5
Motor PCB assembly wiring .....	7 - 6
Front cover assembly wiring .....	7 - 9
Embroidary unit assembly wiring .....	7 - 10

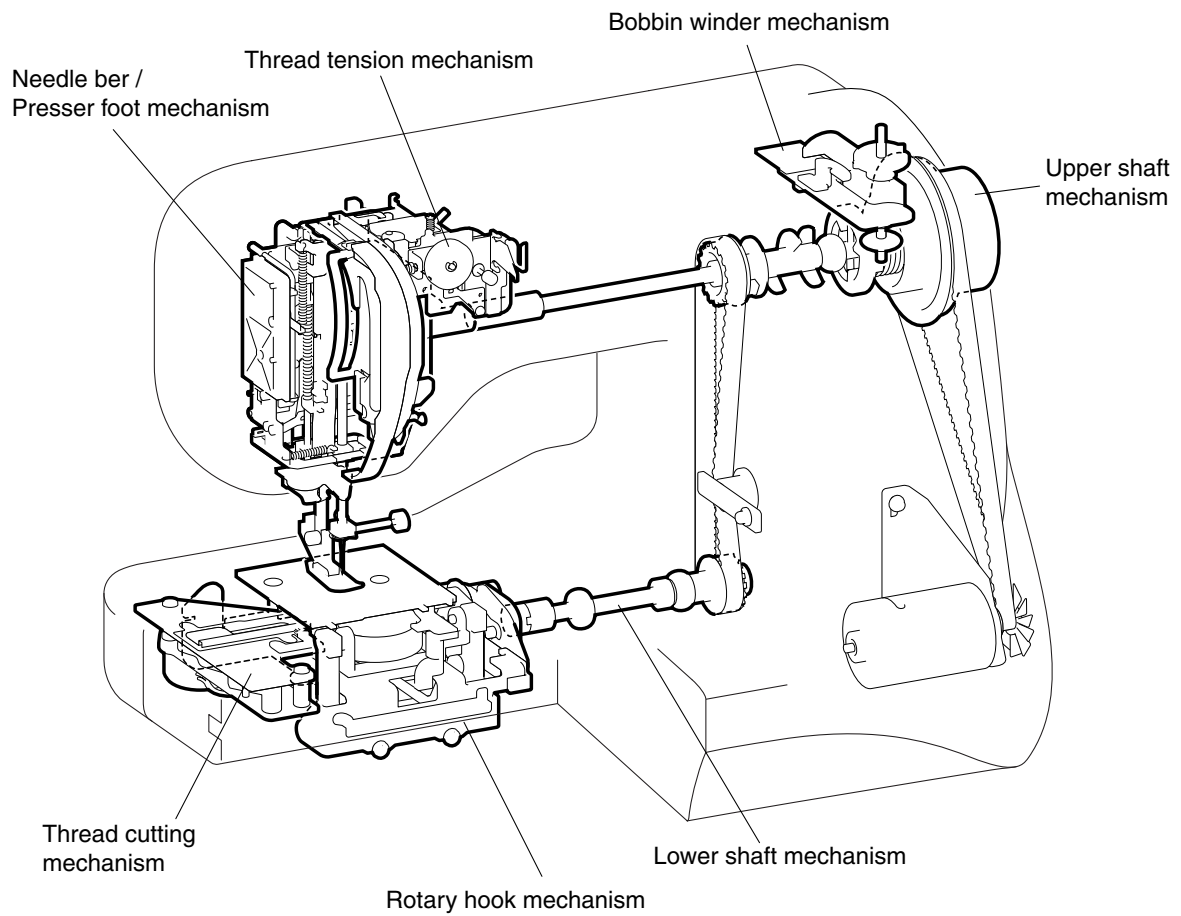
# 1 Outline of Mechanism

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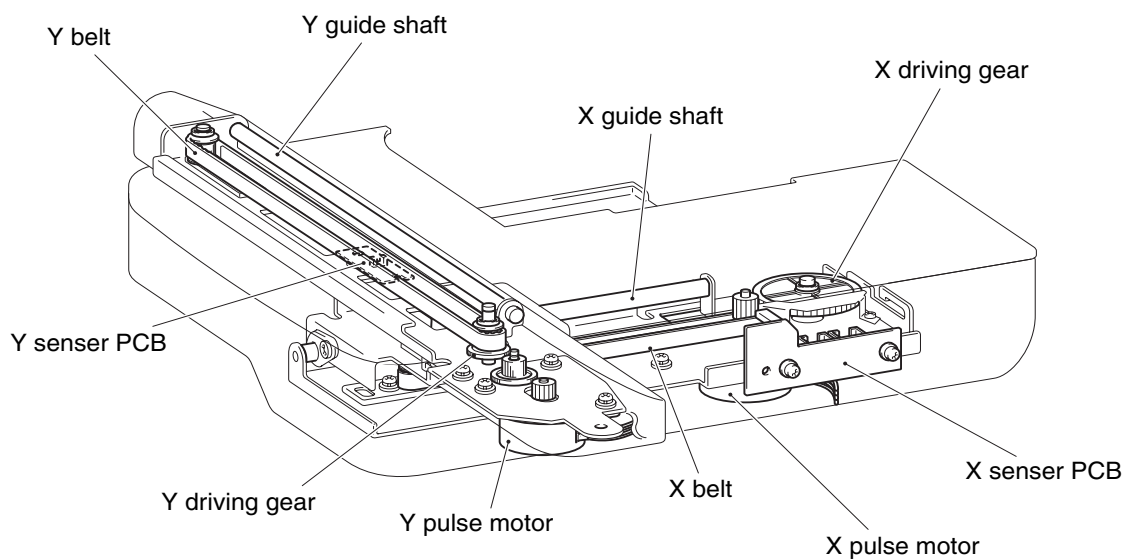
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Main Mechanisms .....	1 - 2
Driveline .....	1 - 3
Positions of electronic components.....	1 - 4
Control system block diagram.....	1 - 5
Operation of other electronic components .....	1 - 6

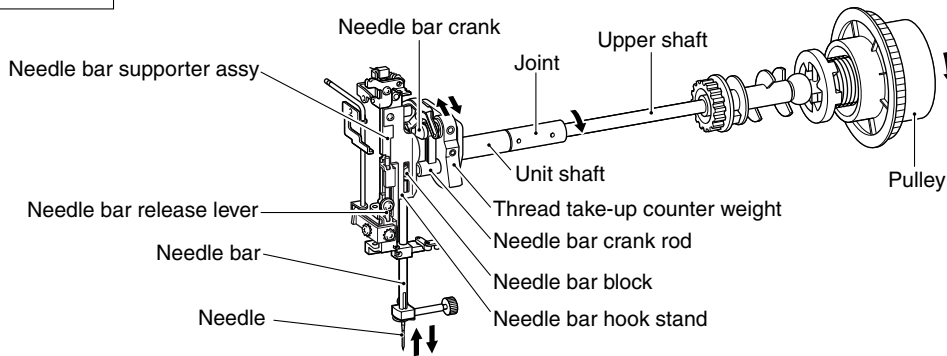
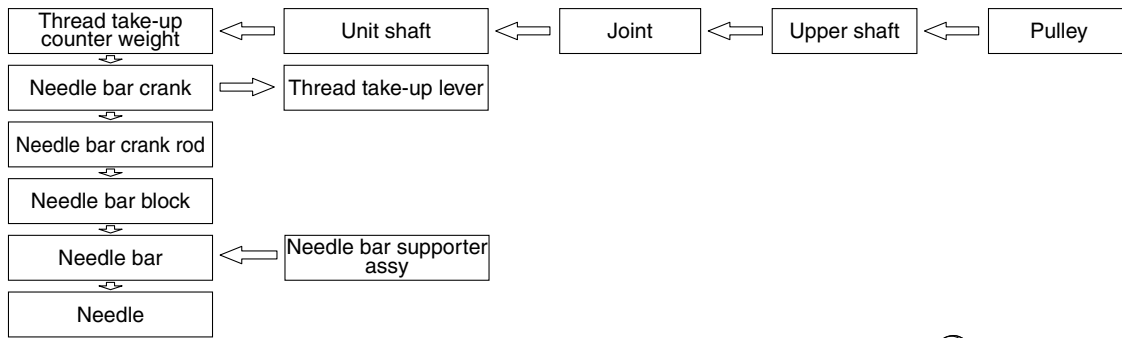
Sewing machine



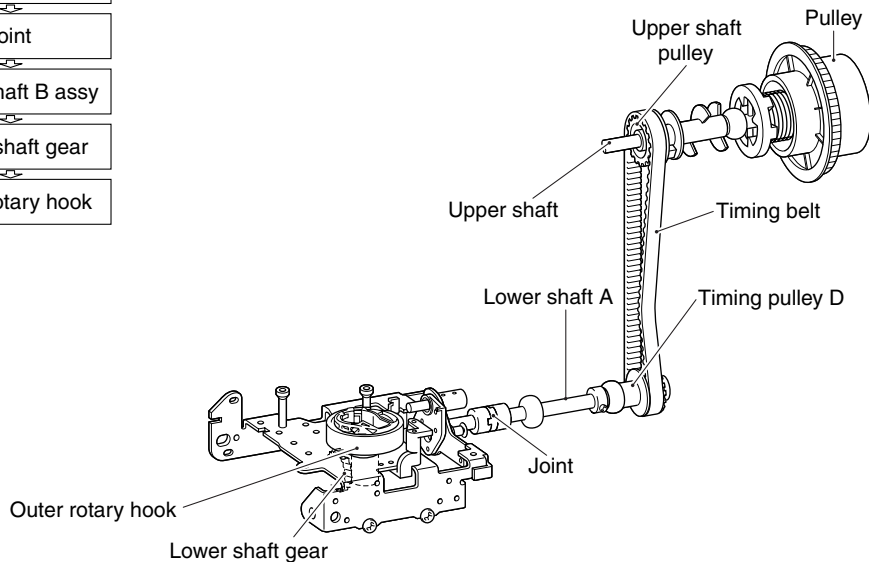
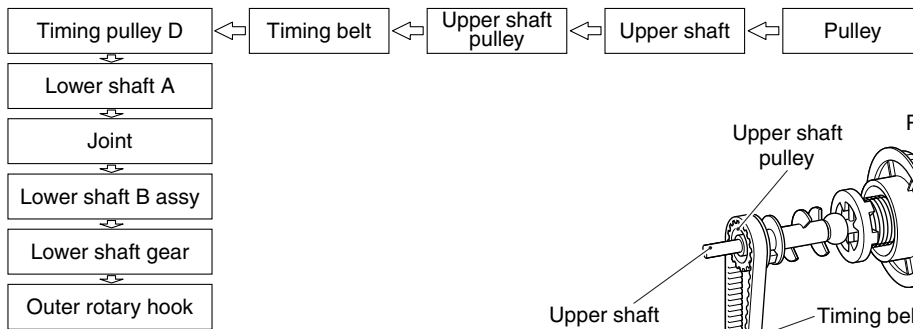
Embroidery unit

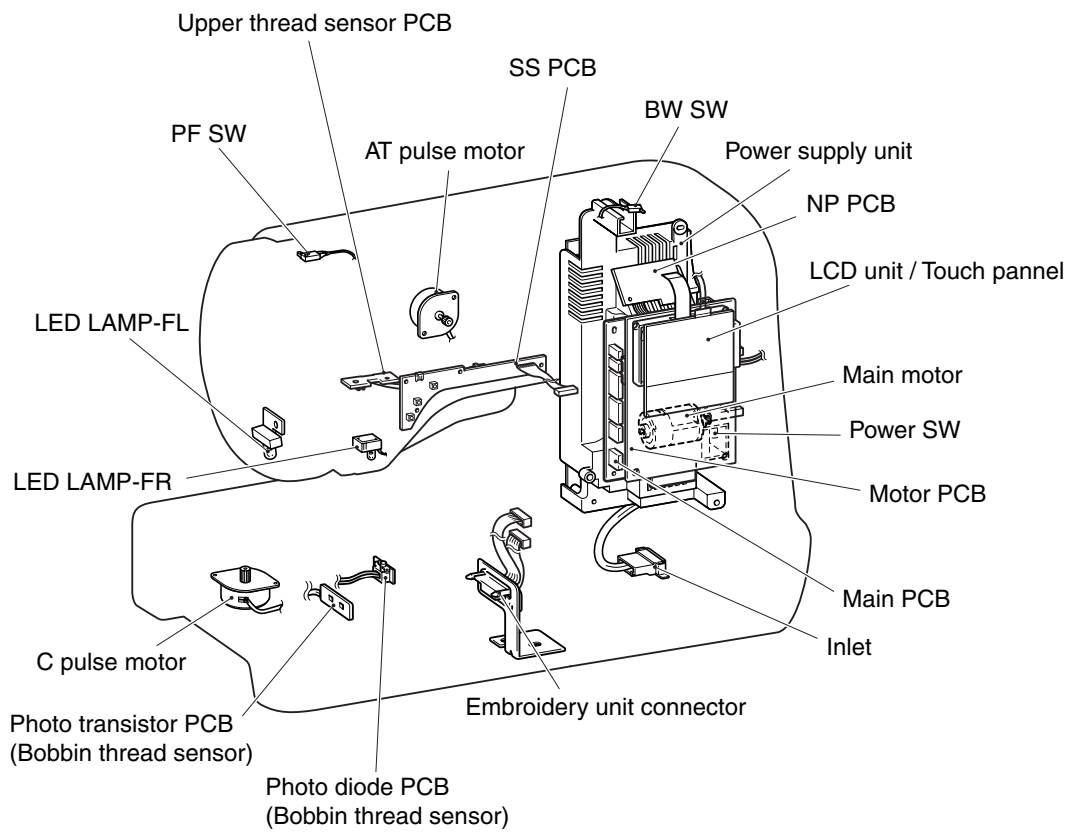


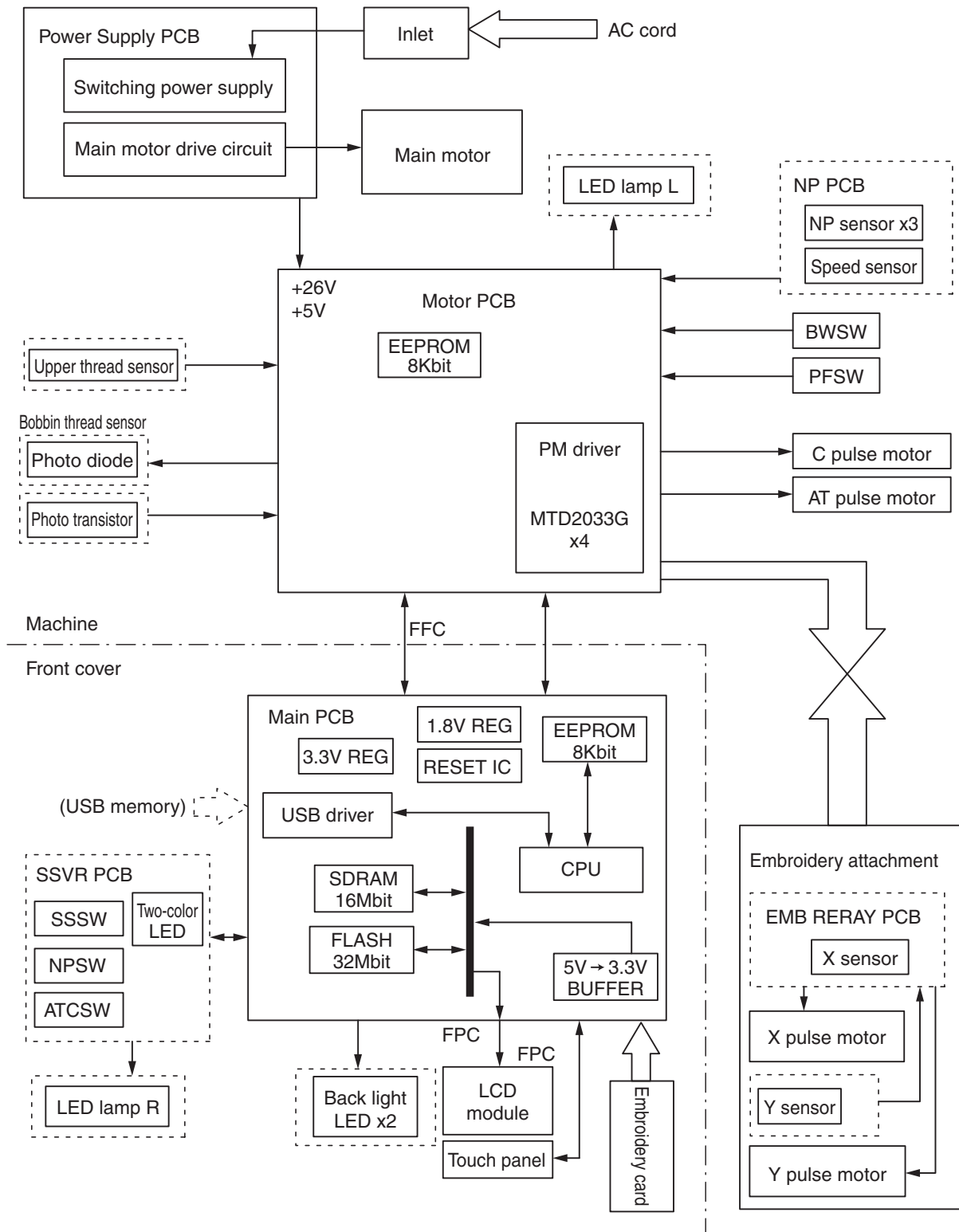
A) Up and down movement of needle bar, movement of thread take-up lever and zigzag mechanism



B) Rotation of outer rotary hook









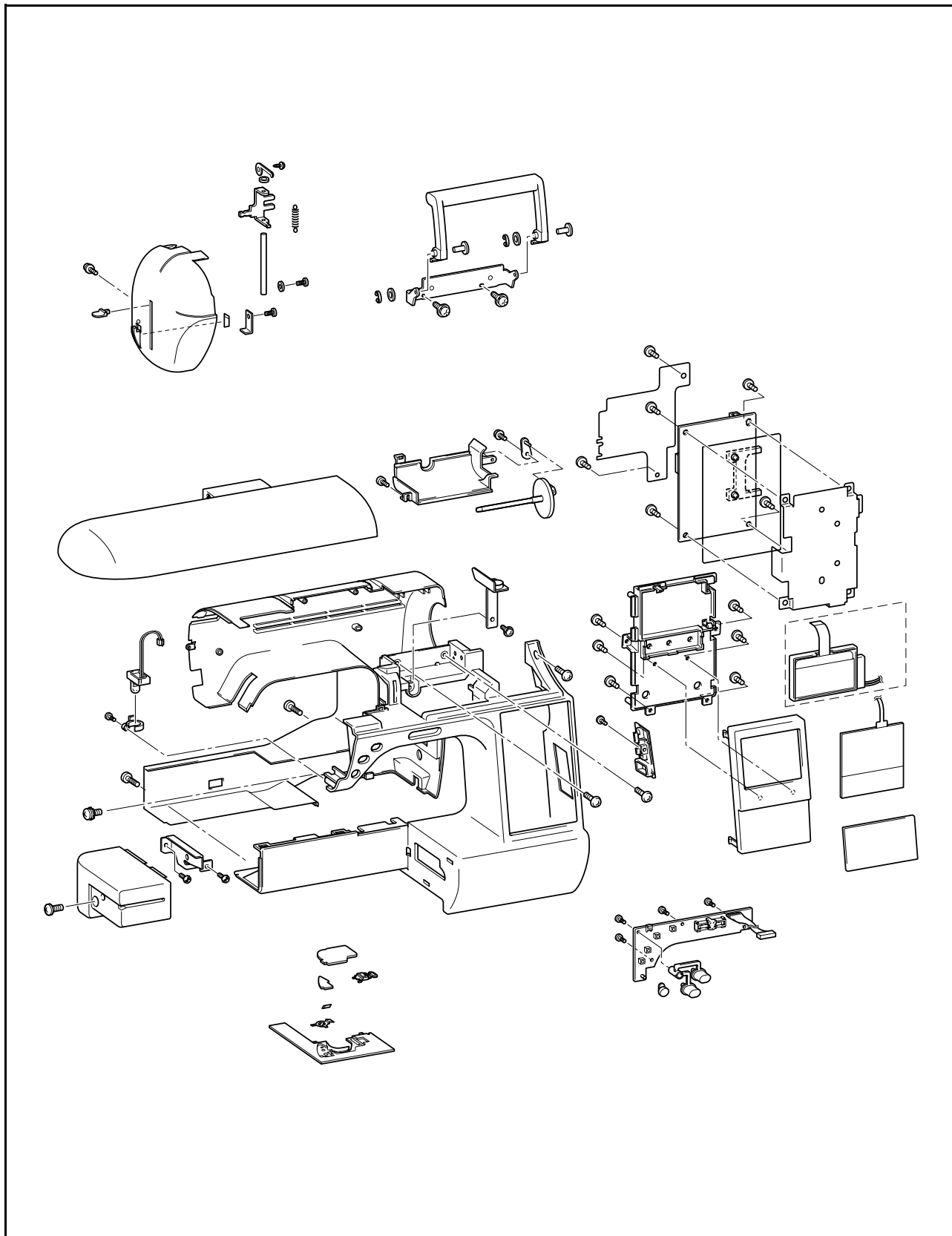
Start/Stop (SS) button . . . . .	Button for starting and stopping the sewing machine. The machine operates at a slow speed while the button is being held down.
Thread cutter button . . . . .	This button is for cutting the thread. In case the button is pressed, the thread is cut regardless of the needle position and stop with the needle up.
Touch Panel . . . . .	Used to select pattern and input test mode number required for sewing by simply touching the display on the panel. This simplifies the operation for selecting the desired pattern and number.
Needle position (NP) sensor . . . . .	This sensor detects the drive timing of each pulse motor and the vertical stop of the needle position. It detects the upper shaft angle of rotation by using a shutter attached to the upper shaft and an optical sensor.
Speed sensor . . . . .	This sensor detects the rotational speed of the main motor. It detects the upper shaft rotational speed by using a shutter attached to the upper shaft and an optical sensor.
PF (Presser foot) switch . . . . .	This switch detects the vertical position of the presser foot lever.
BW (bobbin winder) switch . . . . .	This switch detects whether the bobbin is set for winding or not, when the bobbin thread is wound.
LED lamp . . . . .	White LED lamps for illuminating the work space.
Up thread sensor . . . . .	Detects the presence or absence of the upper thread and whether it is cut or not.
Photo diode, photo transistor . . . . .	This assy detects the bobbin thread is low.
X sensor, Y sensor (Embroidery unit) . . . . .	This sensor detects the original position of X pulse motor and Y pulse motor.

# 2 Disassembly

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Main unit	Main parts .....	2 - 2
	Electrical parts and motors .....	2 - 12
	Thread tension mechanism .....	2 - 18
	Bobbin winder mechanism .....	2 - 25
	Rotary hook drive mechanism /	
	Feed and bobbin mechanism /	
	Cutter assy. location diagram .....	2 - 28
	Needle bar, presser mechanism /	
	Upper shaft mechanism.....	2 - 31
	Modules	Needle-presser module .....
	Feed module.....	2 - 44
	Thread cutter module .....	2 - 49
Embroidery	Embroidery parts .....	2 - 53

Main parts location diagram



## 1 Embroidery removal

1. Remove the embroidery ①.

**\*Key point**

- Move the lock lever ② of the back, and then remove the embroidery ①.

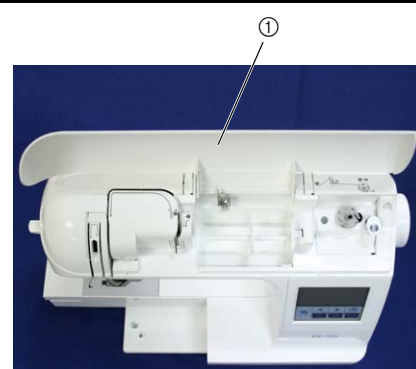


## 2 Top cover removal

1. Remove top cover ①.

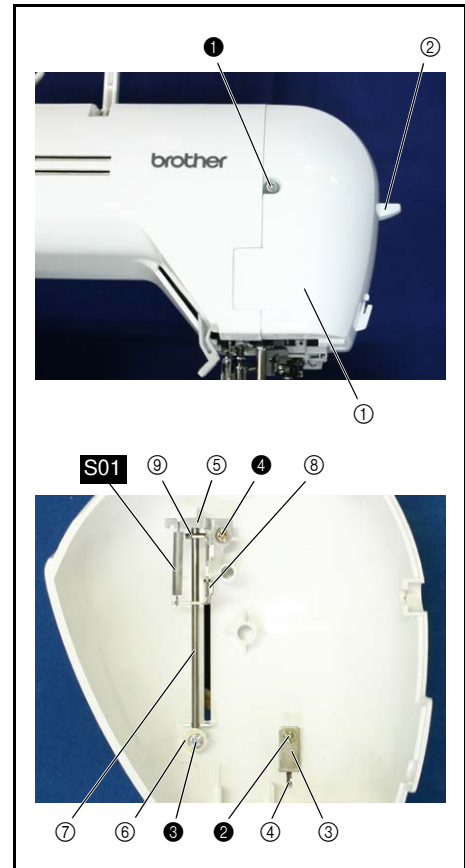
**\*Key point**

- Push the attached part toward the inside and remove.



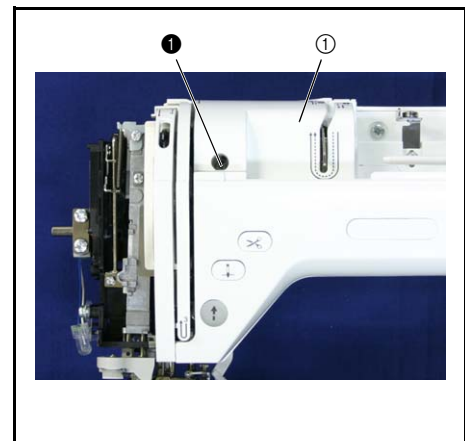
### 3 Face plate removal and disassembly

1. Remove the screw ①, and then remove the face plate assembly ①.
2. Remove the needle thread lever knob ②.
3. Remove the screw ②, and then remove the face plate cutter holder ③ and the NT lower thread cutter ④.
4. Remove the screws ③ and ④, and then remove the shaft presser plate ⑤ and the plain washer ⑥.
5. Remove the spring **S01**.
6. Remove the needle thread lever shaft ⑦.
7. Remove the needle thread lever ⑧ and the rubber washer ⑨ from the needle thread lever shaft ⑦.



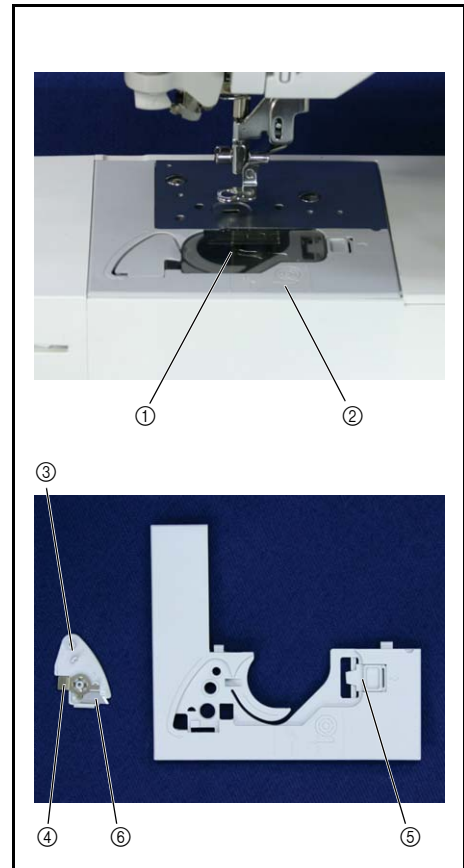
### 4 Front thread guard cover removal

1. Remove the screw ①, and remove the front thread guard cover ①.



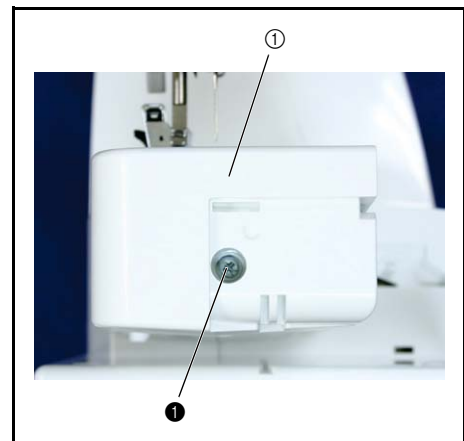
## 5 Needle plate B removal and disassembly

1. Remove the needle plate cover ①.
2. Remove the needle plate B ②.
3. Remove the cutter cover ③.
4. Remove the spring plate ④ from the cutter cover ③, and remove the NT lower thread cutter ⑥.
5. Undo the slide button hook (two locations), and remove the slide button ⑤.



## 6 Free arm cover removal

1. Remove the screw ①, and then remove the free arm cover ①.



## 7 Front cover removal

1. Remove the screw ❶ and the 3 screws ❷.
2. Remove the hook ❶ on the front cover, and then remove the hook ❷ by pushing the hook attachment section ❸ on the rear cover.

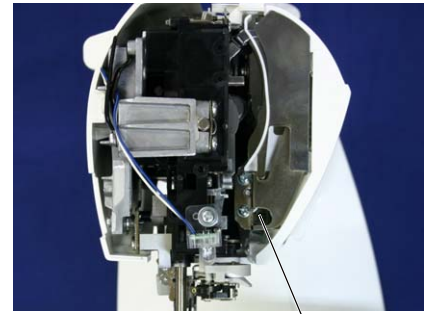
### \*Key point

- Be careful not to damage the hooks ❶ and ❷ on the front cover.

3. Remove the 2 bottom hooks ❸ from the base plate while sliding the front cover to the right.
4. Remove the flat cable ❹ and the connector ❺ from the main PCB assembly, and then remove the front cover.

### \*Key point

- Move the lock of the connector ❺ on the main PCB to the upright position to release it, and then pull out the flat cable ❹.



❶

❷

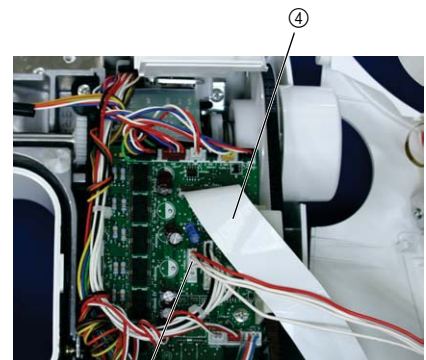


❶

❷



❸

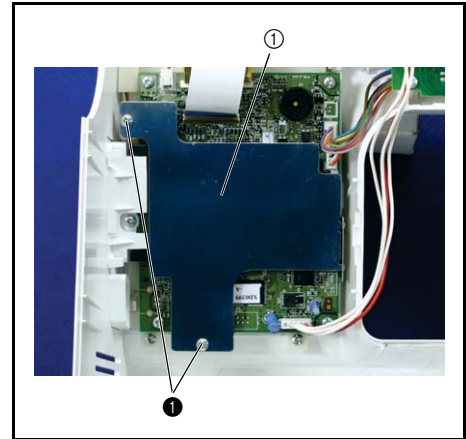


❹

❺

## 8 Board plate A removal

1. Remove the 2 screws ❶, and then remove the board plate A ❶.

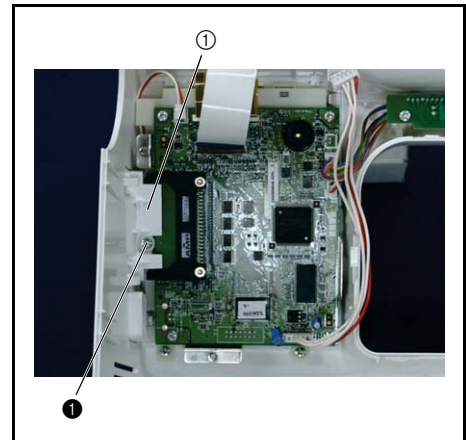


## 9 Card cover removal

1. Remove the screw ❶, and then remove the card cover ❶.

### \*Key point

- Press the 2 hooks on the card cover ❶ from the inside of the front cover.

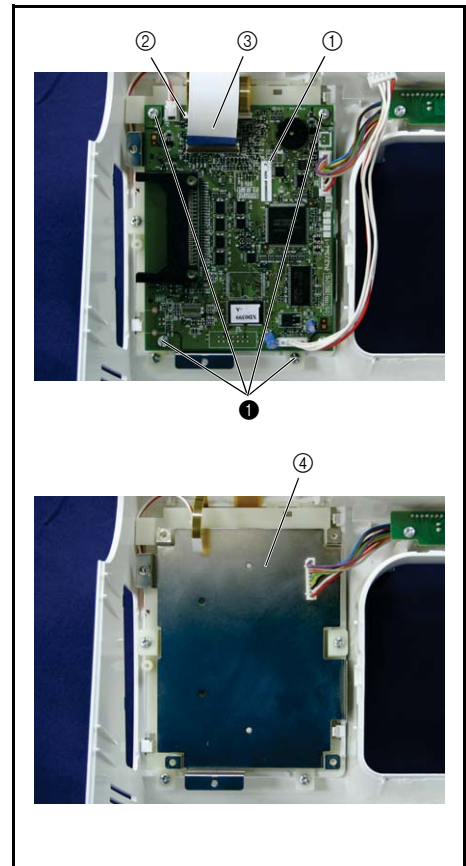


## 10 Main PCB assembly removal

1. Remove the 3 connectors from the main PCB ❶, and then disconnect the 3 FFC cords.

### \*Key point

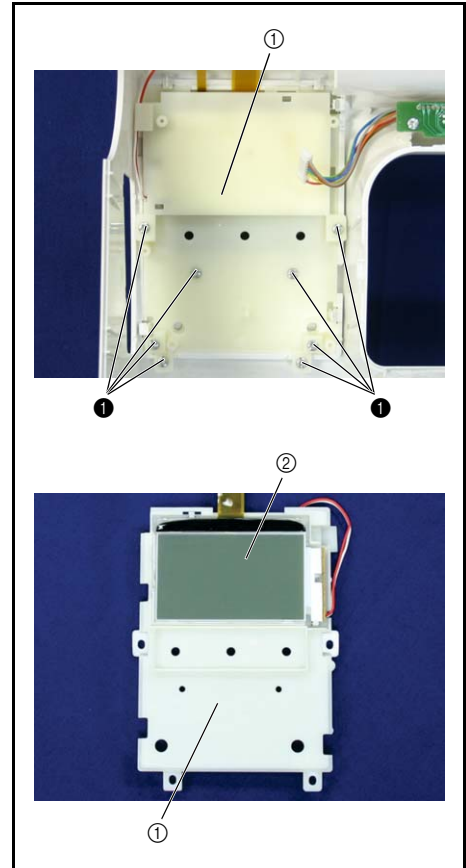
- Pull up the lock of the connector on the main PCB ❶ to release it, and then disconnect the FFC cord ❷.
  - Move the lock of the connector on the main PCB to the upright position to release it, and then disconnect the FFC cord ❸.
2. Remove the 4 screws ❶, and then remove the main PCB ❶ and the board plate B ❷.



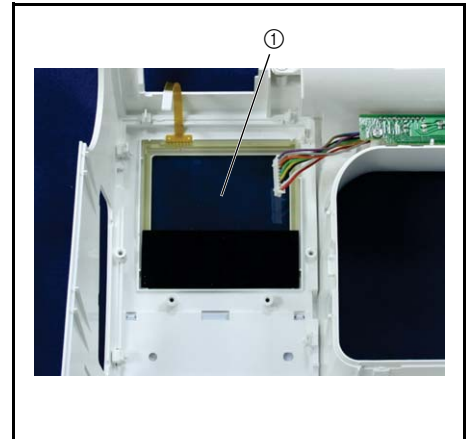


**11** Main PCB holder assembly removal

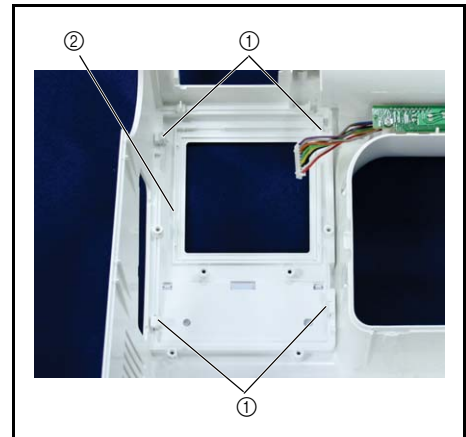
1. Remove the 8 screws ①, and then remove the main PCB holder assembly ①.
2. Remove the 2 hooks on the main PCB holder assembly ①, and then remove the light plate assembly ②.

**12** Touch panel assembly removal

1. Remove the touch panel assembly ① from the front cover.

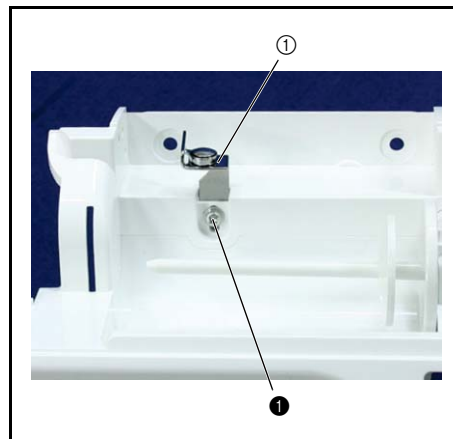
**13** Indication panel removal

1. Remove the 4 hooks ① from the backside of the front cover, and then remove the indication panel ②.

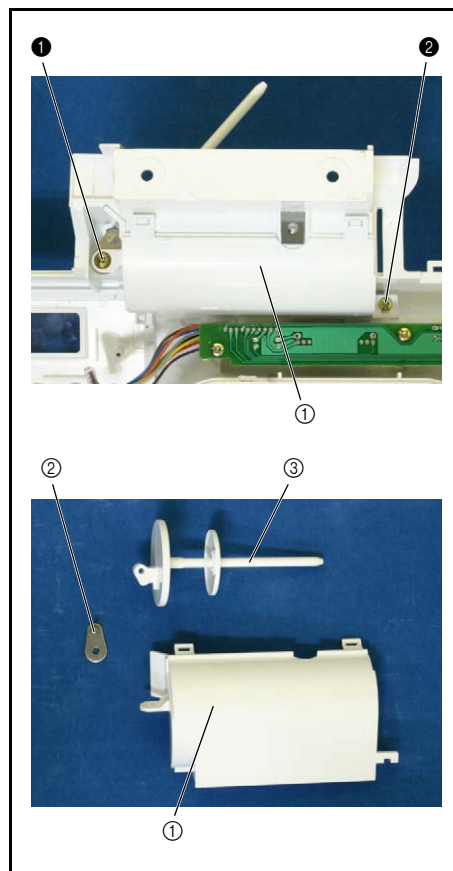


**14** Front cover disassembly  
(bobbin winder guide assembly removal)

1. Remove the screw ❶, and remove the bobbin winder guide assembly ❶.

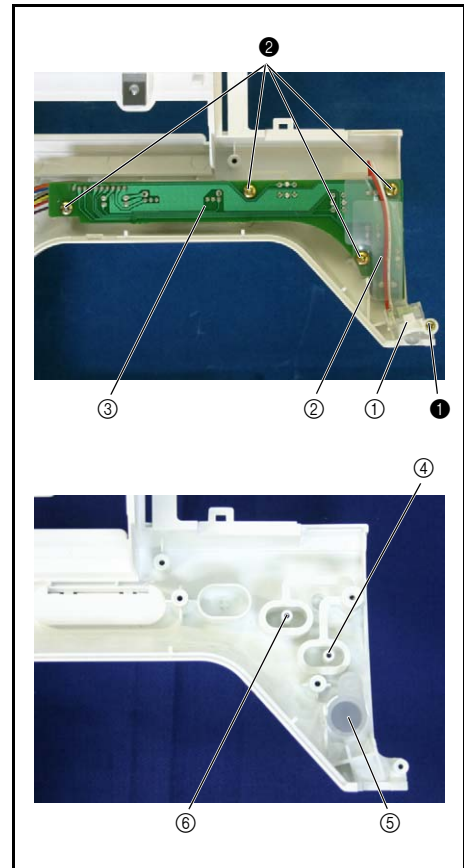
**15** Front cover disassembly (spool pin holder removal)

1. Remove the screws ❶ and ❷, and then remove the thread bobbin cover ❶, spool pin holder assembly ❷, and spool pin ❸.



**16** Front cover disassembly (SS-VR PCB assembly removal)

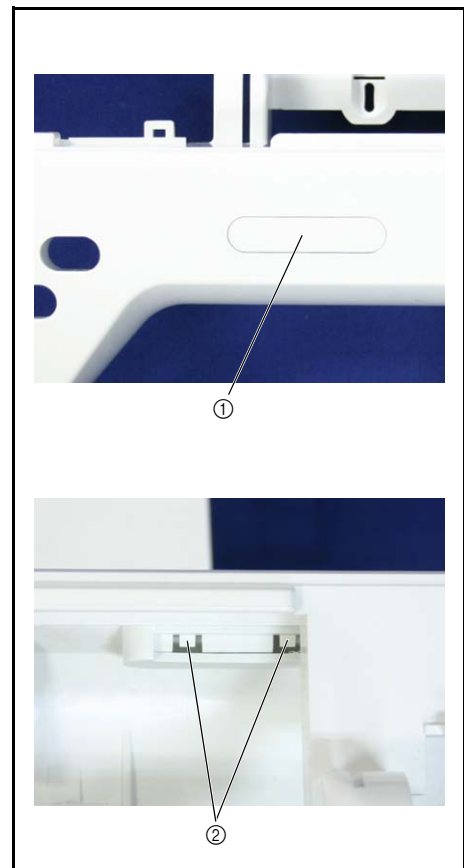
1. Remove the screw ①, and then remove the lamp holder supporter ①.
2. Remove the 4 screws ②, and then remove the insulation sheet ② and the SS-VR PCB assembly ③.
3. Remove the connector of the PCB unit LED lamp (FR).
4. Remove the reverse button ④, SS button ⑤, and thread cut button ⑥.

**17** Front cover disassembly (SV cover removal)

1. Remove the SV cover ①.

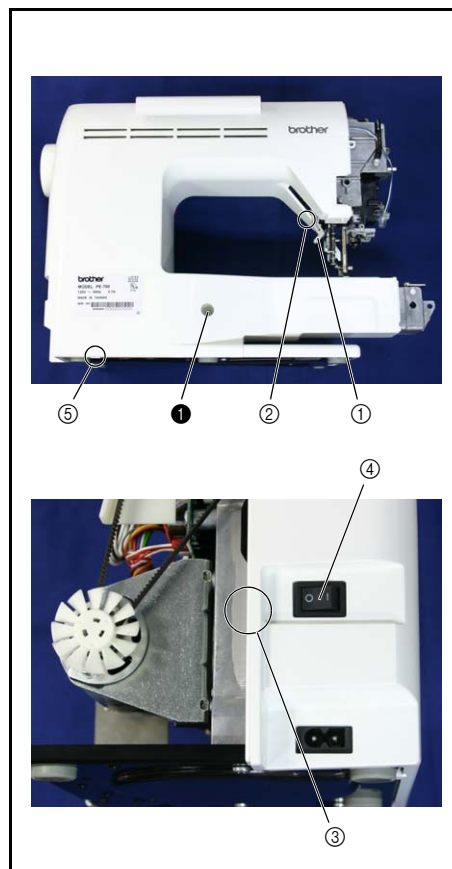
**\*Key point**

- Press the 2 hooks ② on the SV cover ① from the inside of the front cover.



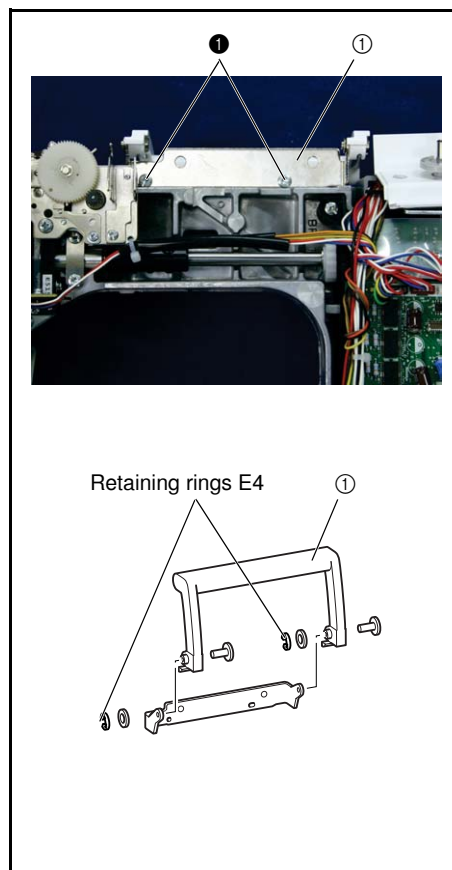
## 18 Rear cover removal

1. Remove the screw ❶.
2. Lower the presser lever ❷, and then remove section ❸, being careful to prevent the presser lever ❶ being caught in section ❸.
3. Remove section ❸, being careful to prevent the switch ❹ of the power supply unit being caught in section ❸.
4. Remove the hook ❺, and then remove the rear cover.

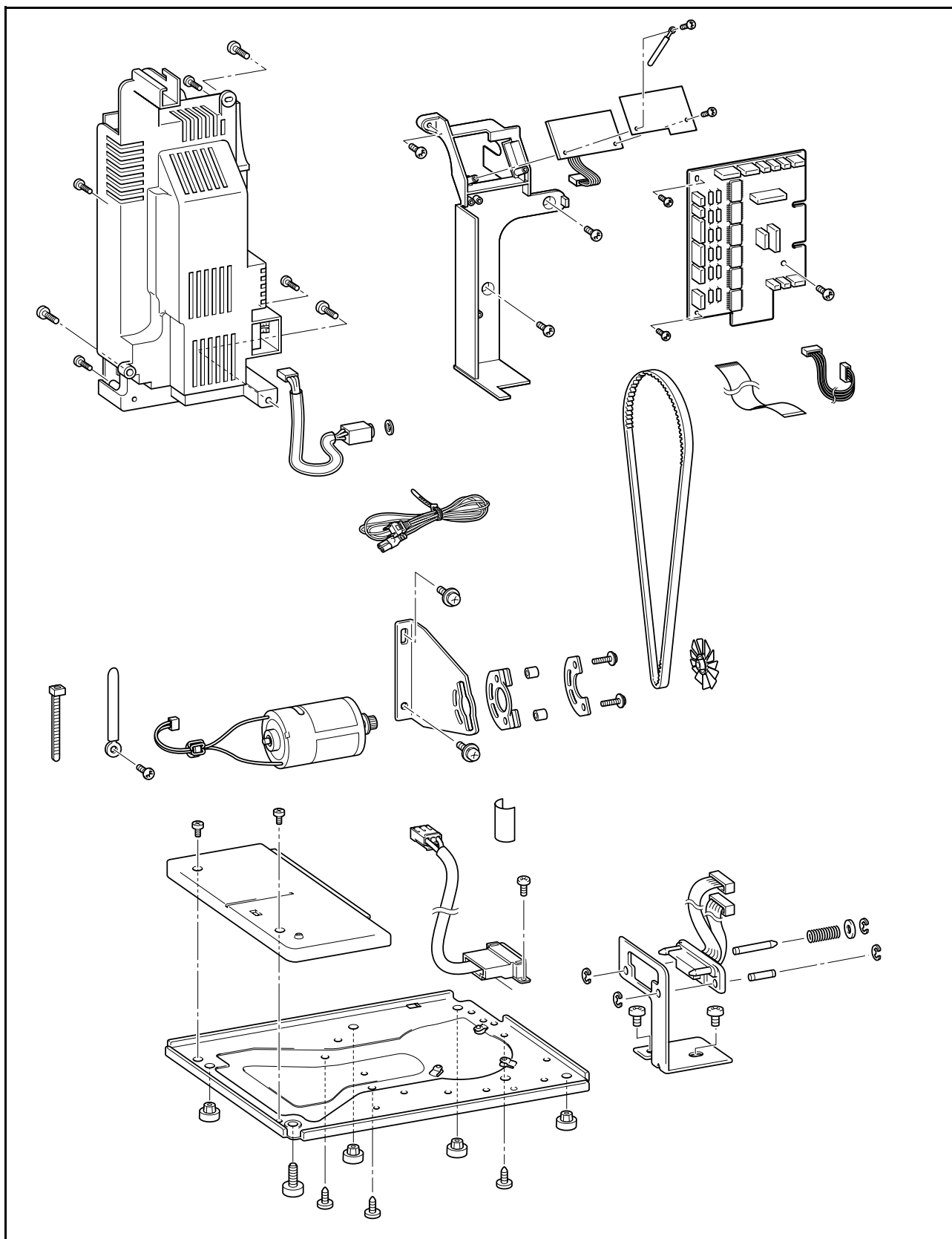


## 19 Handle removal

1. Remove the 2 screws ❶, and remove the handle ❶.
2. Remove the 2 retaining rings E4 from the handle shafts, and remove the handle ❶, the 2 handle shafts and the 2 polyester sliders from the handle holder.

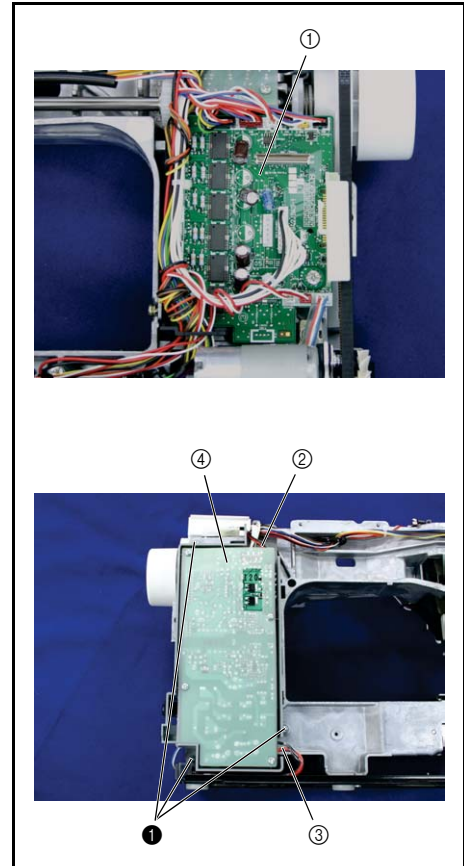


Electrical parts and motors location diagram



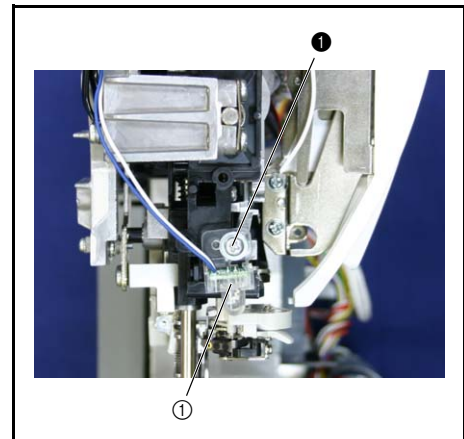
### 1 Power supply unit F removal

1. Unplug all of the connectors on the motor PCB Assy. ①.
2. Remove the main motor connector ②.
3. Disconnect the connector ③ of the inlet assembly lead wire.
4. Remove the 3 screws ①, and remove the power supply unit F ④.



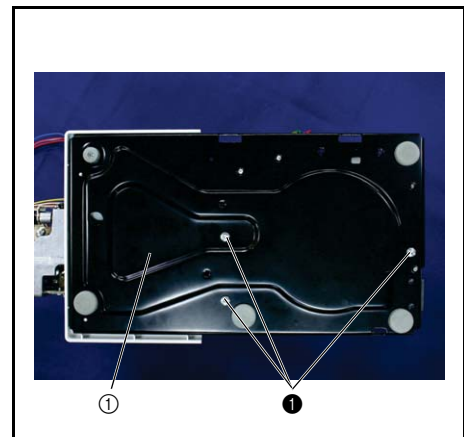
### 2 PCB Unit LED lamp FL removal

1. Disconnect the bands on the back of the arm bed.
2. Remove the screw ①, and remove the PCB unit LED lamp FL ①.



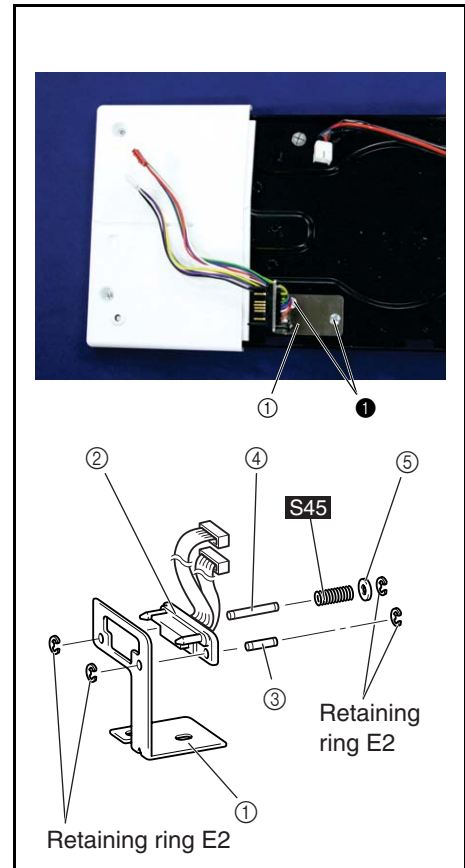
### 3 Base plate sub assy. removal

1. Remove the 3 screws ①, and remove the base plate sub assy. ①.



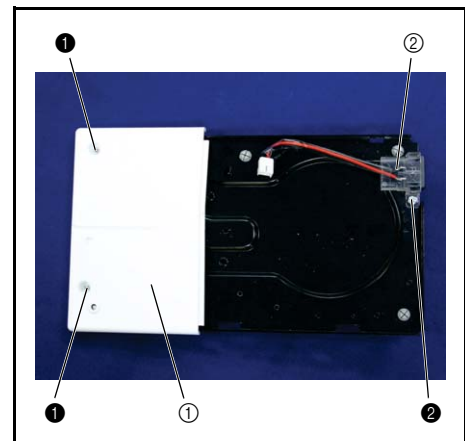
#### 4 Connector holder assembly removal and disassembly

1. Remove the 2 screws ①, and then remove the connector holder assembly ①.
2. Remove the 2 retaining rings (E2), and then remove the lead wire assembly (main body FCOMB) ②, ES pin F-A ③, and ES pin F-B ④ from the connector holder assembly ①.
3. Remove the retaining ring (E2) from ES pin F-A ③.
4. Remove the spring S45 and the feed bar spacer ⑤ from ES pin F-B ④, and then remove the retaining ring (E2).



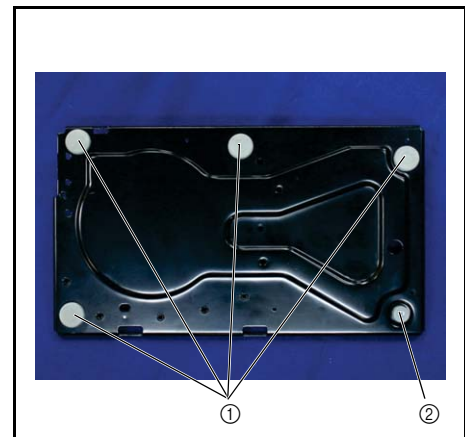
#### 5 Base plate cover and inlet assembly removal

1. Remove the 2 screws ①, and then remove the base plate cover ①.
2. Remove the screw ②, and then remove the inlet assembly ②.



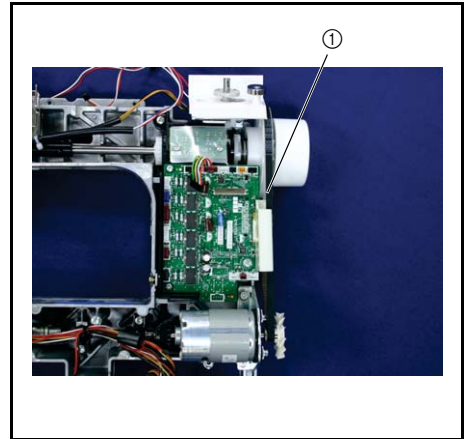
#### 6 Base rubber removal

1. Remove the 4 base rubbers A ①.
2. Remove the adjusting screw assembly ②.



## 7 Timing belt (motor belt) removal

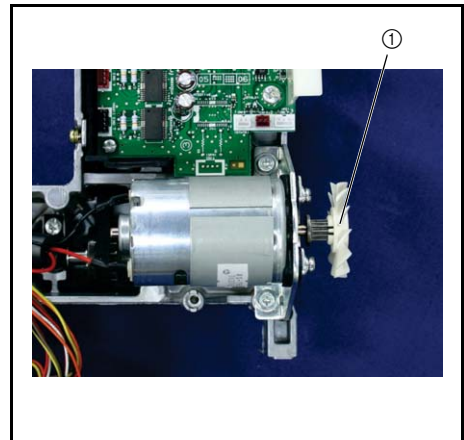
1. Remove the timing belt ①.



## 8 Motor fan removal

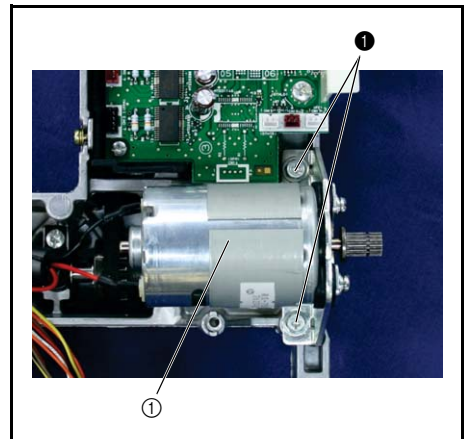
1. Remove the motor fan ①.

**NOTE** •Be careful not to bend the fins of the motor fan ①.



## 9 Main motor assembly removal

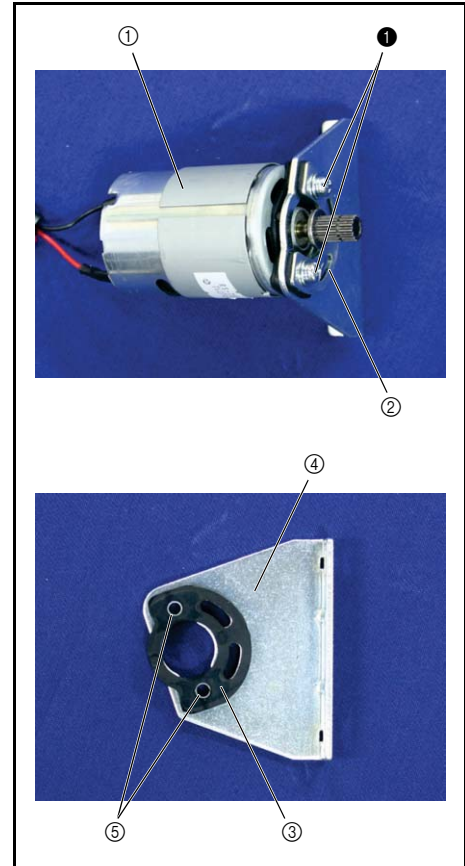
1. Remove the 2 screws ❶, and remove the main motor assembly ①.





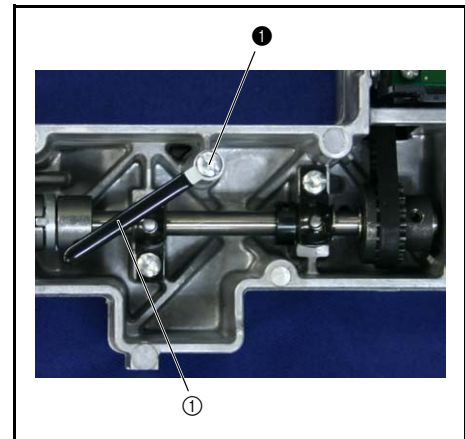
## 10 Main motor assembly disassembly

1. Remove the 2 screws ❶, and remove the main motor assembly ❶ and the motor spacer presser ❷.
2. Remove the fender rubber ❸ from the motor holder ❹.
3. Remove the 2 spacer 4x6 ❺ from the fender rubber ❸.



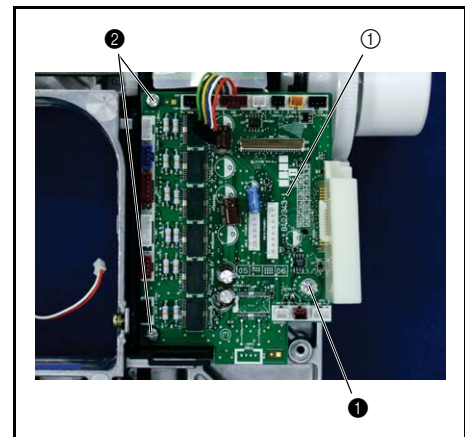
## 11 Coating clip removal

1. Remove the screw ❶ and the coating clip ❶.



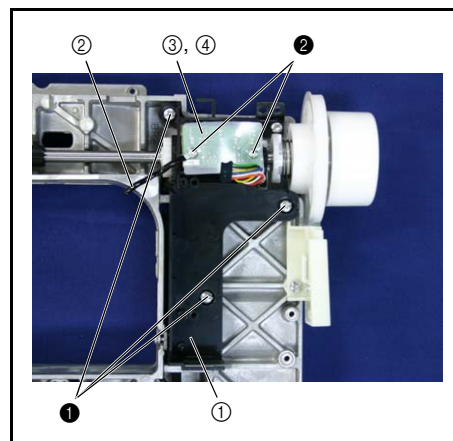
## 12 Motor PCB assy. removal

1. Remove the screw ❶ and the 2 screws ❷, and remove the motor PCB assy. ❶.

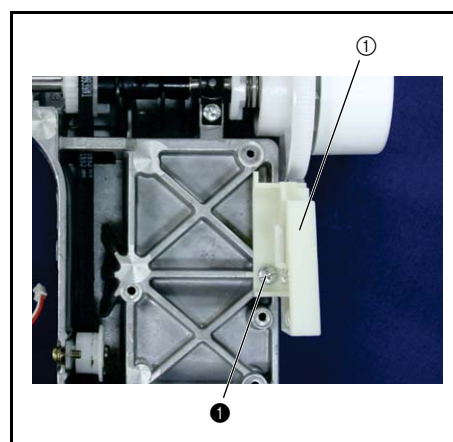


**13** NP PCB assy. removal

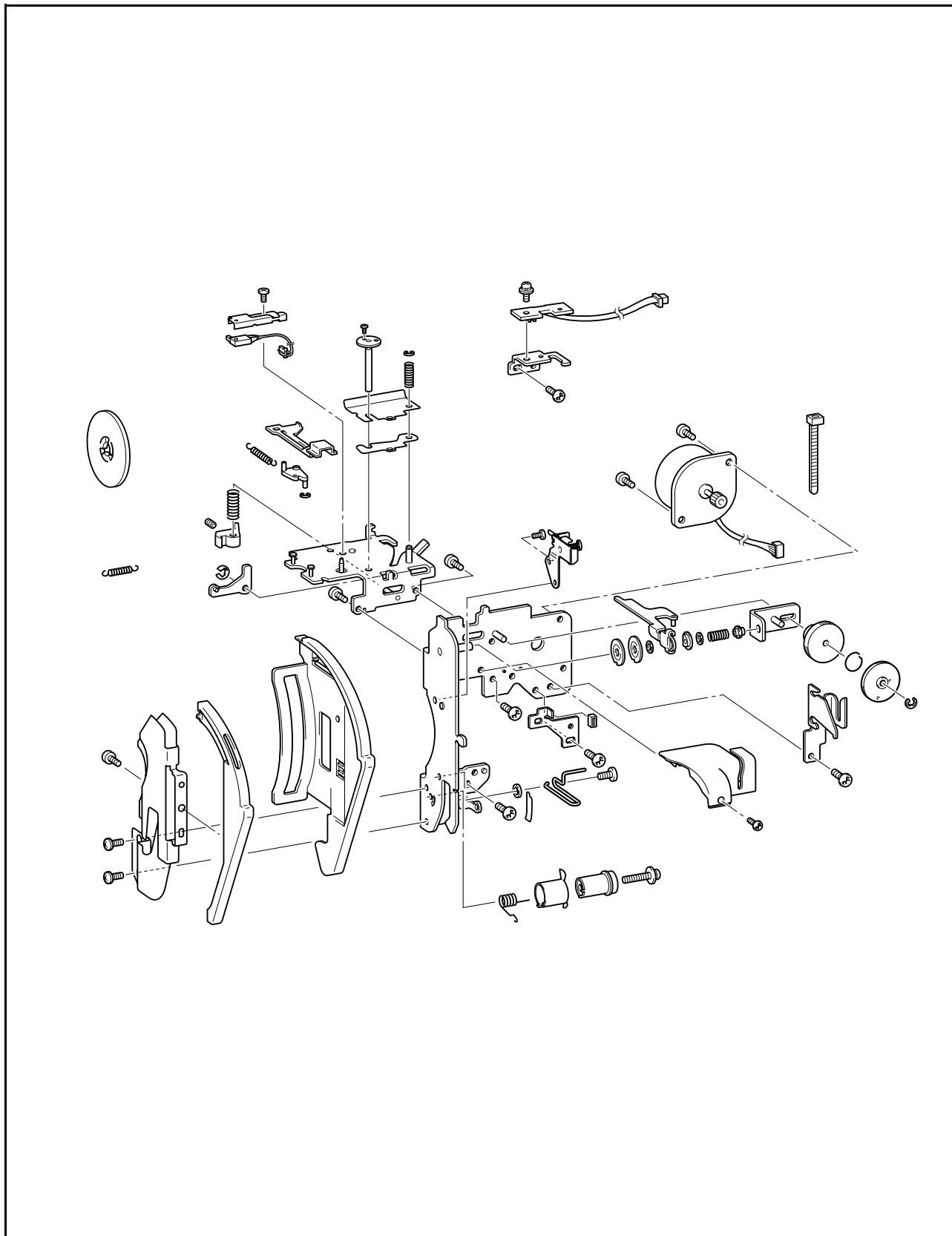
1. Remove the 3 screws ❶, and remove the PCB holder ❶.
2. Remove the 2 screws ❷, and remove the coating clip ❷, the insulation sheet ❸ and the NP PCB assy ❹ from the PCB holder ❶.

**14** Belt guard removal

1. Remove the screw ❶, and then remove the belt guard ❶.

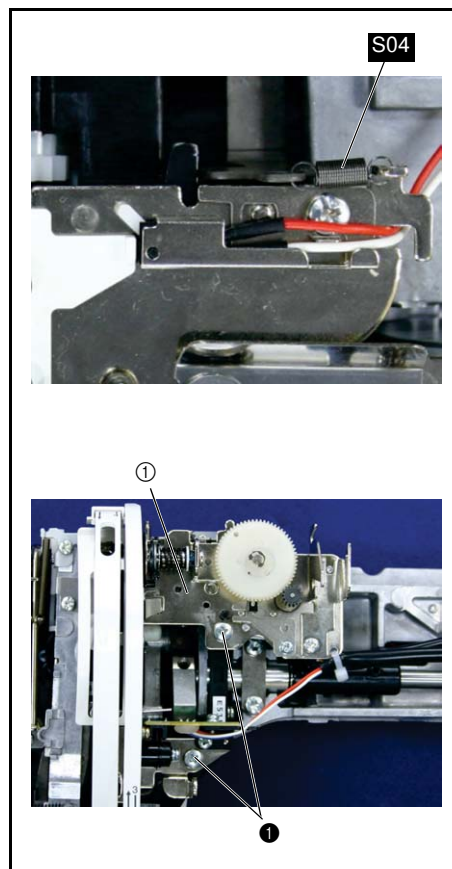


Thread tension mechanism location diagram



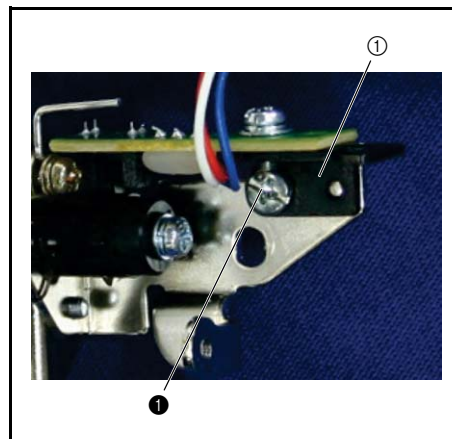
### 1 Thread tension assy removal

1. Remove the spring **S04**.
2. Remove the 2 screws **①**, and remove the thread tension assy **①**.



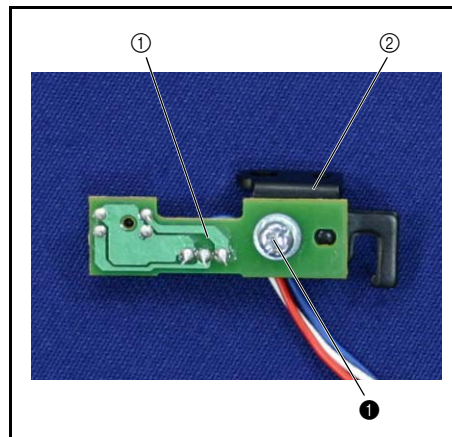
### 2 Upper thread PCB unit removal

1. Remove the screw **①**, and then remove the upper thread PCB unit **①**.



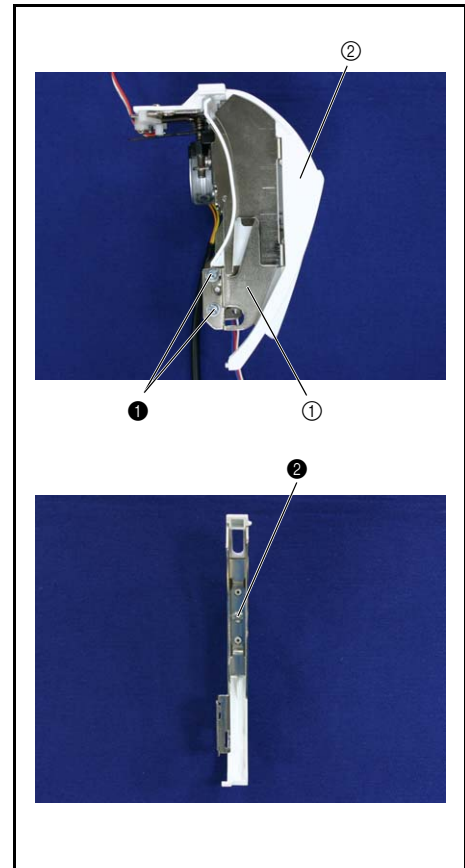
### 3 Upper thread PCB unit disassembly

1. Remove the screw **①**, and then remove the upper thread PCB assembly **①** from the thread sensor holder **②**.



#### 4 Thread guide removal

1. Remove the 2 screws ①, and remove the thread guide assy. ①.
2. Remove the screw ②, and remove the thread guide cover ②.

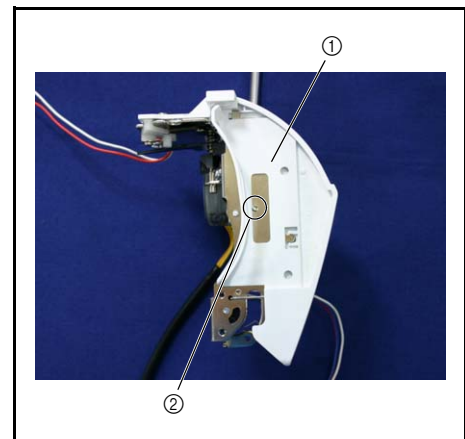


#### 5 Thread guide cover removal

1. Remove the thread guide cover ①.

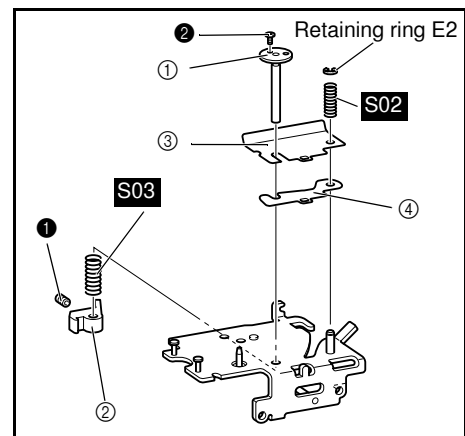
**\*Key point**

- Lift the protrusion ② and slide to the right.



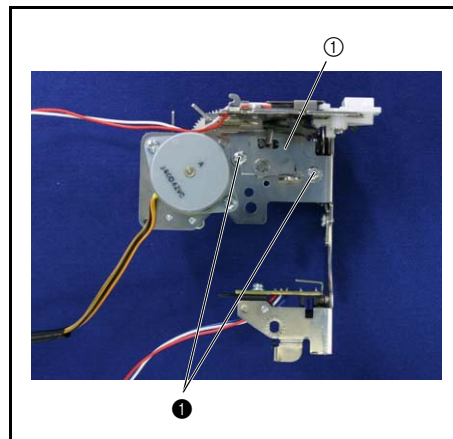
#### 6 Tension plate removal

1. Remove retaining ring E2, and remove the spring S02.
2. Remove the screw ①, and remove the tension pressure assy ① the spring S03 and the tension release cam ②.
3. Remove the tension plate ③ and the spacer ④.
4. Remove the screw the screw ②.

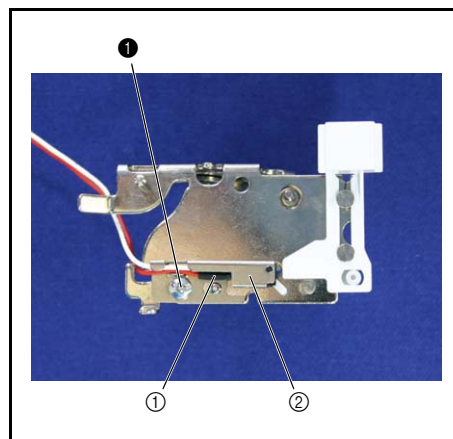


**7** Thread release holder assy. F removal

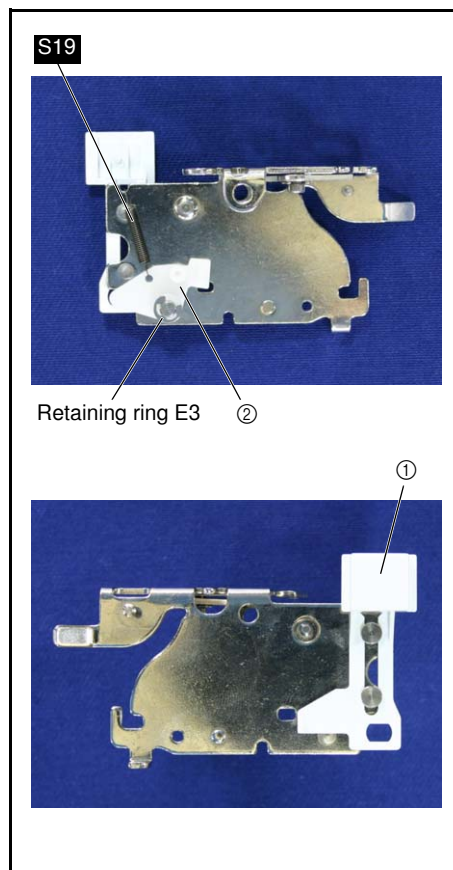
1. Remove the 2 screws ❶, and remove the thread release holder assy. ❶.

**8** PF-F SW assy. removal

1. Remove the screw ❶, and remove the PF-F SW assy ❶ and the presser switch holder ❷.

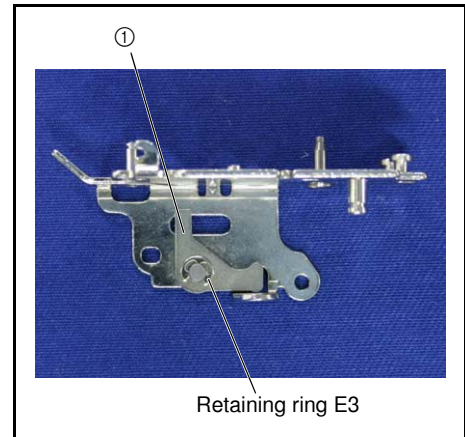
**9** Thread guide shutter removal

1. Remove the spring S19.
2. Remove retaining ring E3, and remove the thread guide shutter ❶ and the thread guide shutter link ❷.

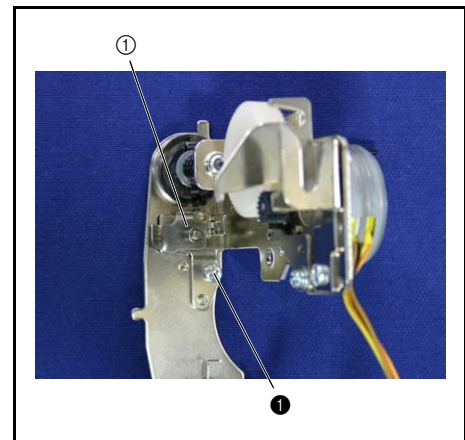


**10** Tension releaser link removal

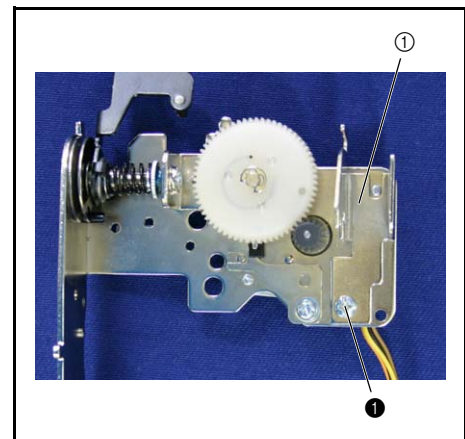
1. Remove the retaining ring E3 and remove the tension releaser link ①.

**11** Plate assembly removal

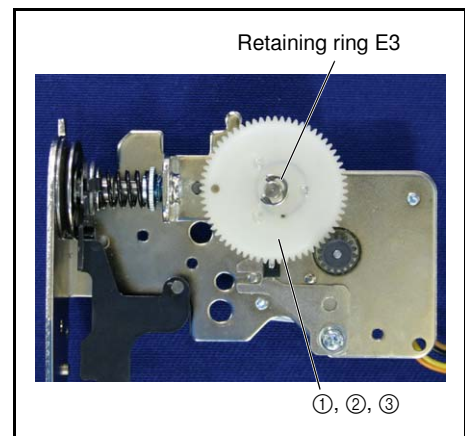
1. Remove the screw ❶, and remove the plate assembly ①.

**12** Thread guide removal

1. Remove the screw ❶, and remove the thread guide ①.

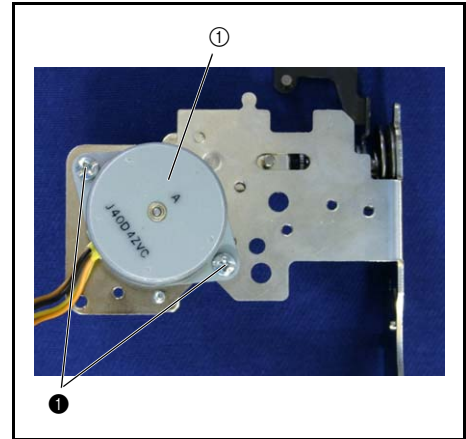
**13** Thread tension gear removal

1. Remove the retaining ring E3 and remove the thread tension gear ①, thread tension gear cover ② and the spring ③.

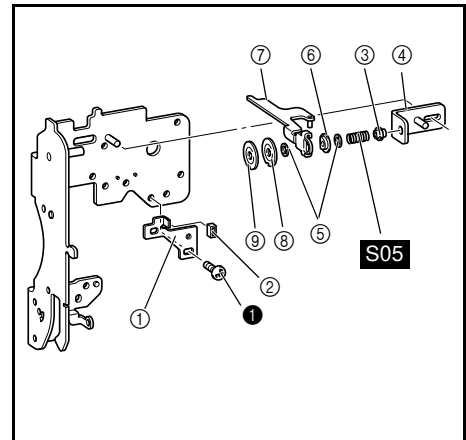


**14** AT pulse motor removal

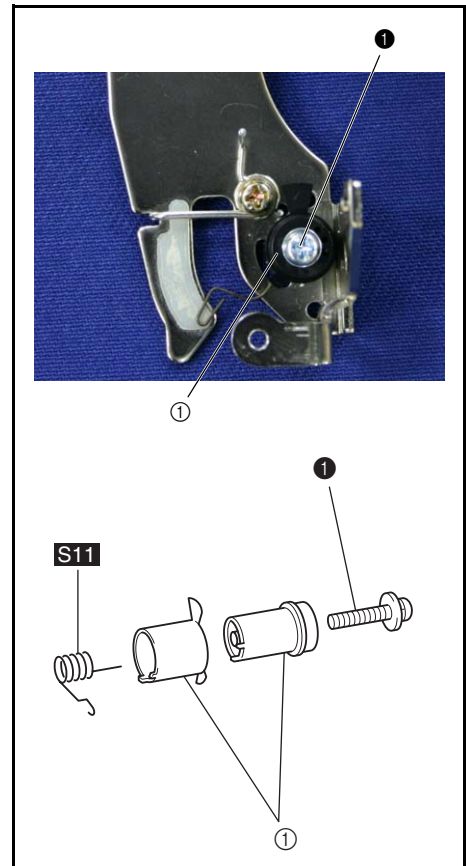
1. Remove the 2 screws ❶, and remove the AT pulse motor ❶.

**15** Tension disk removal

1. Remove the screw ❶, and remove the initial adjustment plate ❶.
2. Remove the rubber ❷ from the initial adjustment plate ❶.
3. Loosen the thread tension adjusting screw ❸, and remove the tension plate assy ❹.
4. Remove the thread tension adjusting screw ❸, the spring S05, washer ❺, tension disc washer ❻, tension release plate assy A ❼, washer ❺, tension disk B ❸ and tension disk A ❹.

**16** Thread take up spring removal

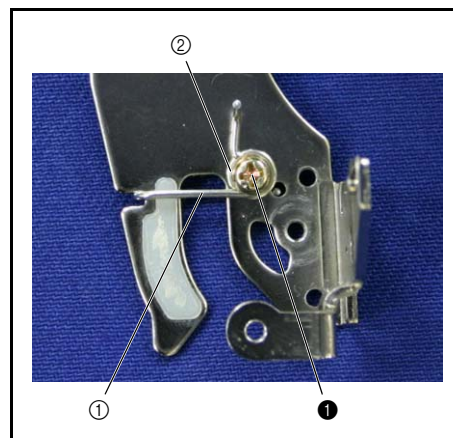
1. Remove the screw ❶, and remove the thread catching spring case ❶.
2. Remove the spring S11 from the thread catching spring case ❶.



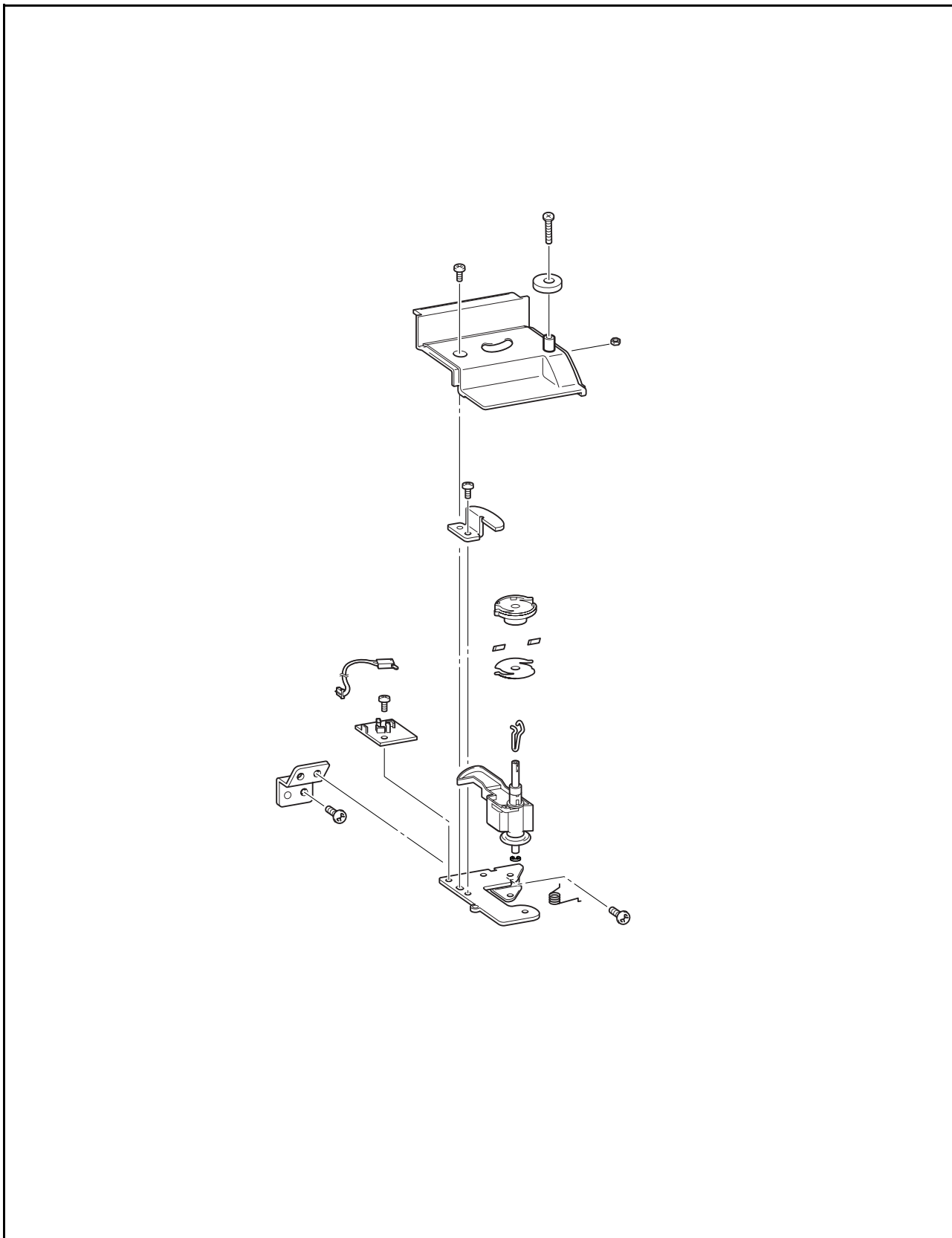


**17** Thread guide wire removal

1. Remove the screw ❶, and remove the thread guide wire ❶ and the washer ❷.

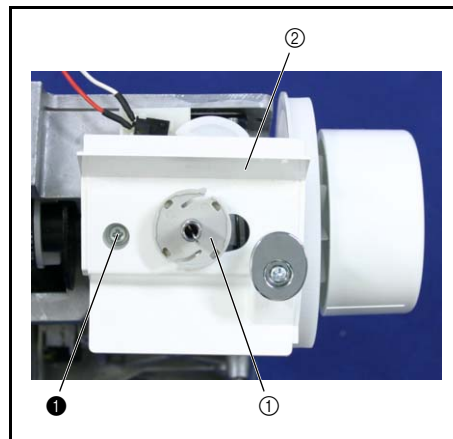


Bobbin winder mechanism location diagram

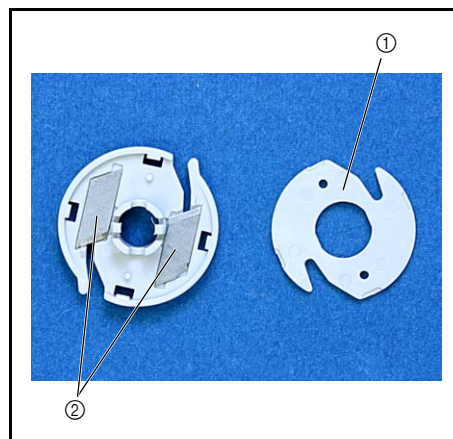


**1** Bobbin winder cover removal

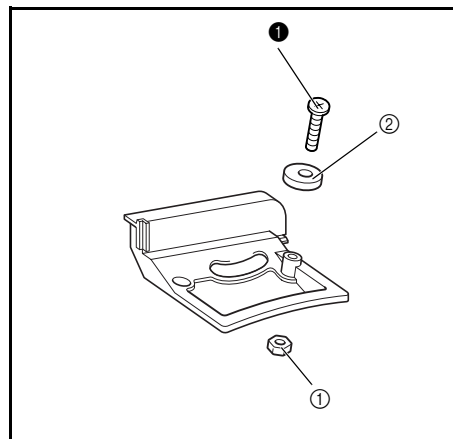
1. Remove the bobbin base ①.
2. Remove the screw ①, and remove the bobbin winder cover ②.

**2** Bobbin base disassembly

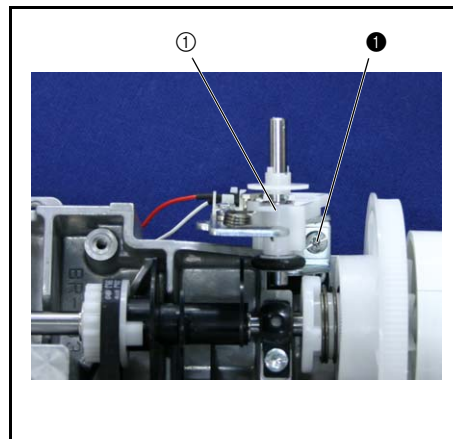
1. Remove the bobbin thread cutter holder ①.
2. Remove the 2 NT lower thread cutters ②.

**3** Bobbin presser removal

1. Remove the screw ① and the M3 nut ①, and remove the bobbin presser ②.

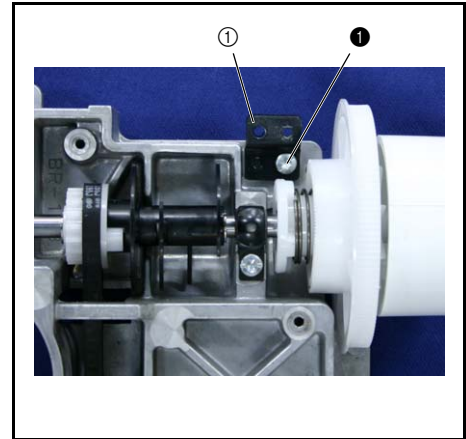
**4** Bobbin winder assembly removal

1. Remove the screw ①, and remove the bobbin winder assembly ①.



**5** BW holder supporter removal

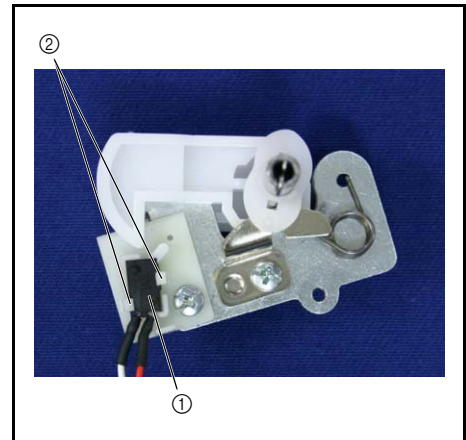
1. Remove the screw ❶, and remove the BW holder supporter ❶.

**6** BW-F SW Assy. removal

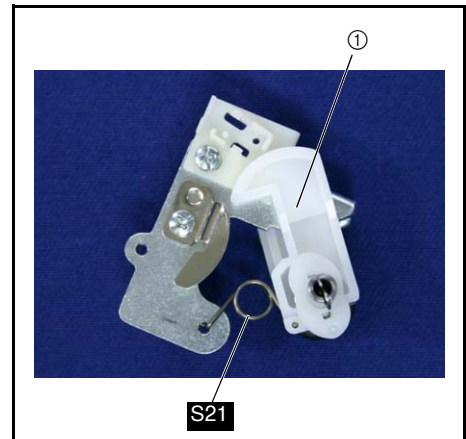
1. Remove the BW-F SW Assy ❶.

**\*Key point**

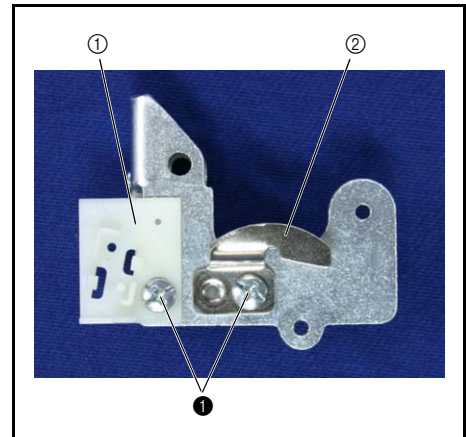
- Open the SW adjust plate ❷ clip and remove it.

**7** BW shaft holder assembly removal

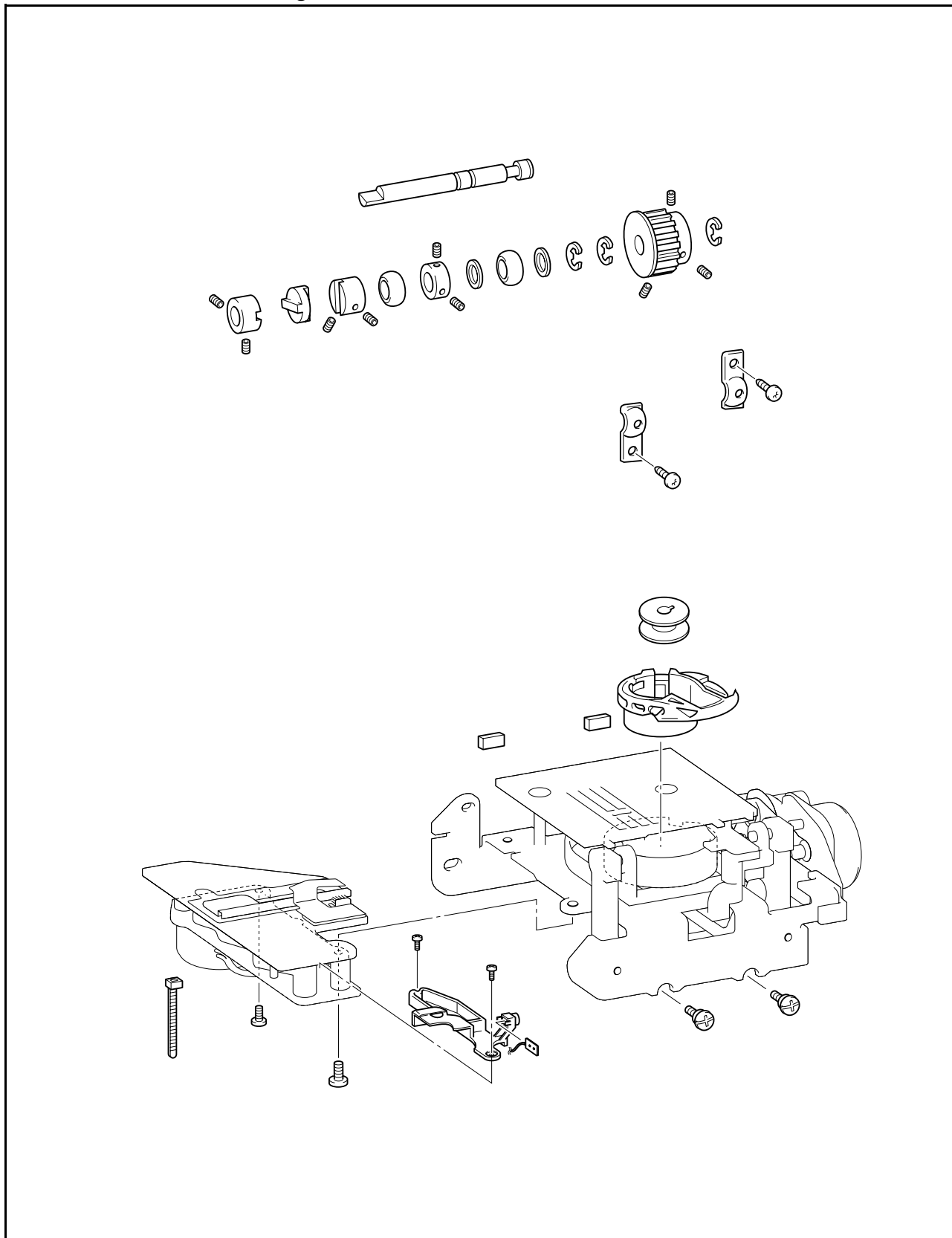
1. Move the BW shaft holder assembly ❶ to the right (bobbin winding ON).
2. Remove the spring S21.
3. Remove the BW shaft holder assembly ❶.

**8** Bobbin winder shaft stopper removal

1. Remove the 2 screws ❶, and remove the SW adjust plate ❶ and the bobbin winder shaft stopper ❷.

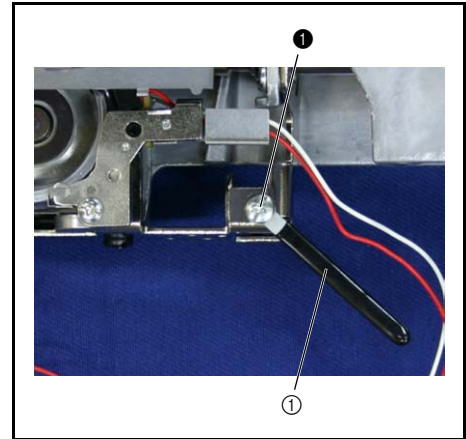


Rotary hook drive mechanism / Feed and bobbin mechanism / Cutter assy.  
mechanism location diagram

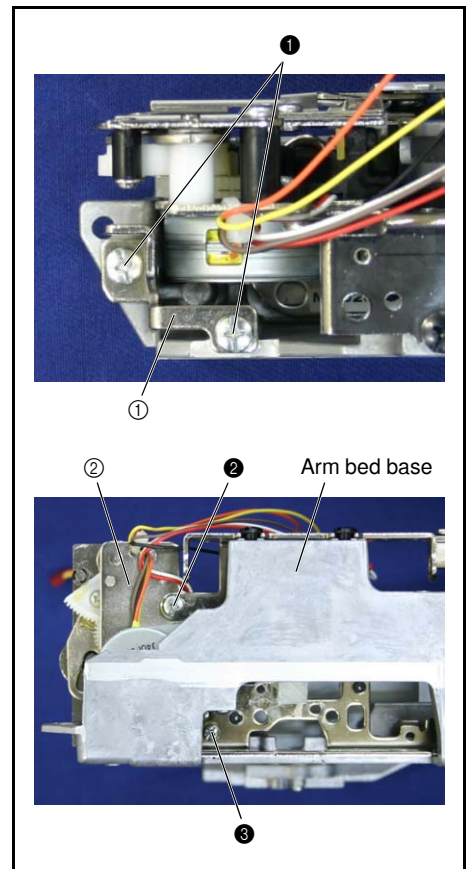


**1** Coating clip removal

1. Remove the screw ❶, and then remove the coating clip ❶.

**2** Thread cutter module removal

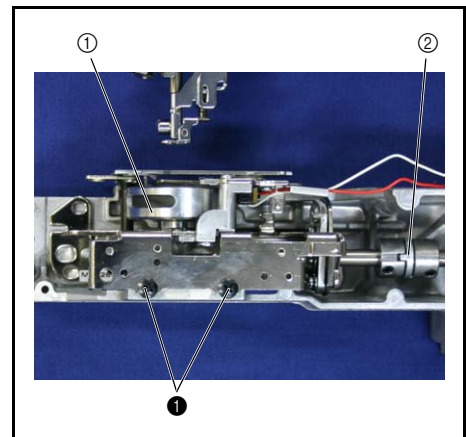
1. Remove the 2 screws ❶, and then remove the free arm plate ❶.
2. Remove the screws ❷ and ❸, and then remove the thread cutter module ❷.

**3** Feed module removal

1. Rotate the upper shaft, and bring the needle bar to its highest point
2. Remove the 2 screws ❶, and detach the feed module ❶ and the disk ❷.

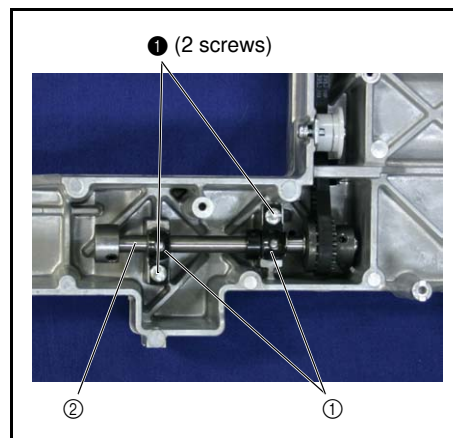
**\*Key point**

- Raise the needle bar to the top position.

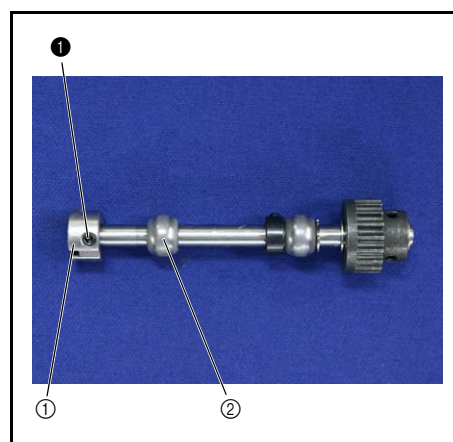


**4 Lower shaft A assy. removal**

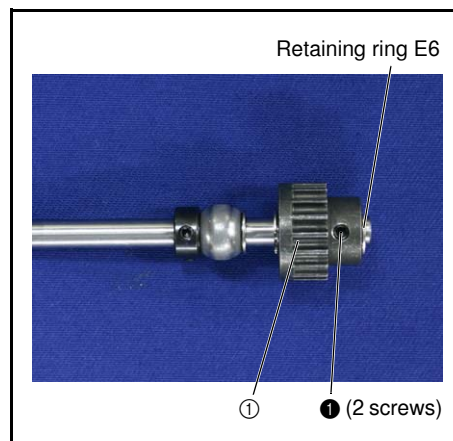
1. Remove the 2 screws ❶, and remove the 2 bushing pressers ❷.
2. Remove the lower shaft A assy ❸.

**5 Joint removal**

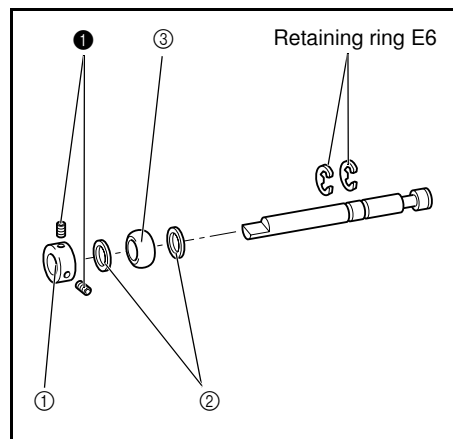
1. Remove the 2 screws ❶, and remove the joint ❷ and the lower shaft bushing ❸.

**6 Timing pulley D removal**

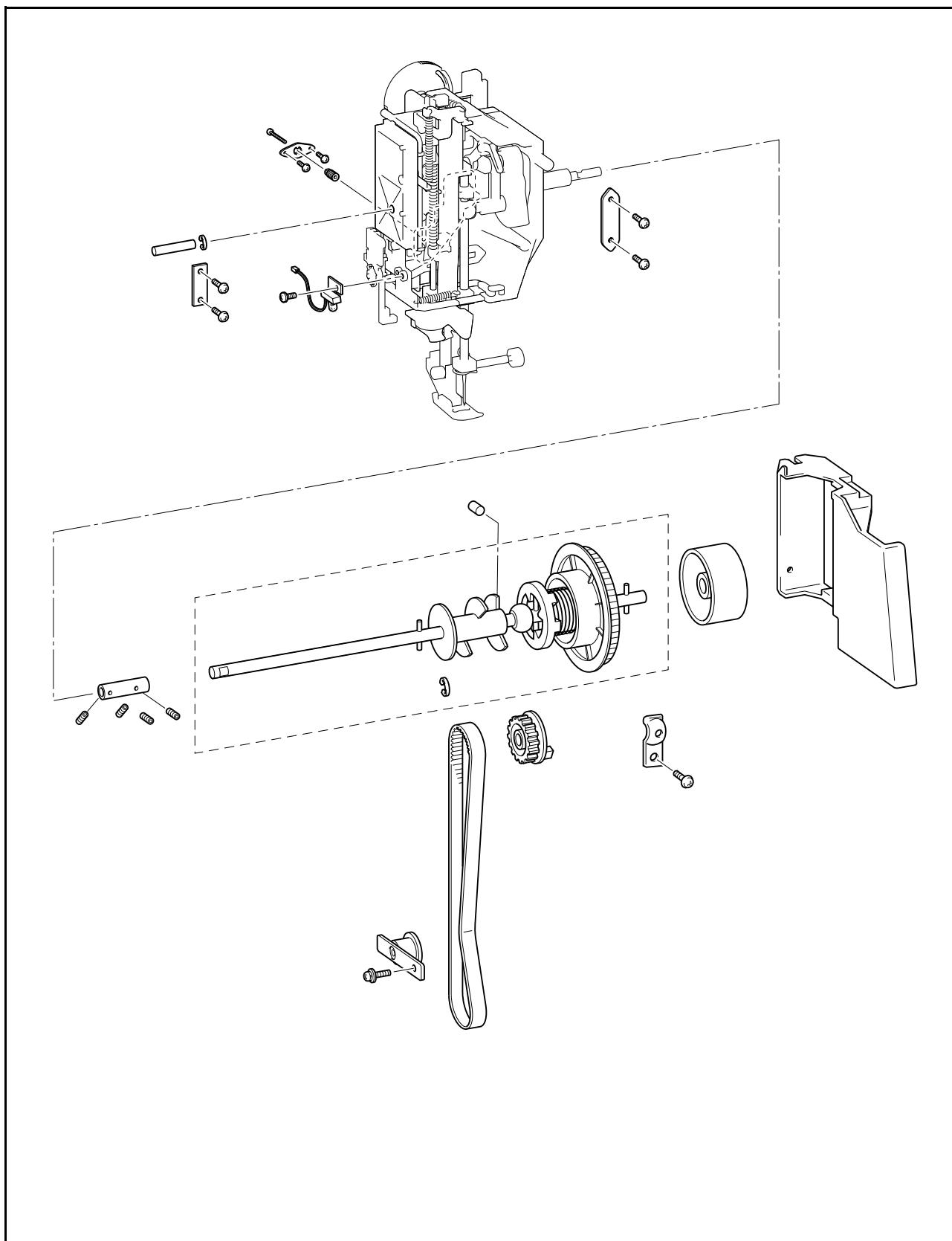
1. Remove the 2 screws ❶.
2. Remove retaining ring E6, and remove the timing pulley D ❷.

**7 Lower shaft bushing removal**

1. Remove the 2 screws ❶, and remove the set screw collar ❷, thrust washer ❸, lower shaft bushing ❹ and thrust washer ❺.
2. Remove the 2 retaining rings E6.



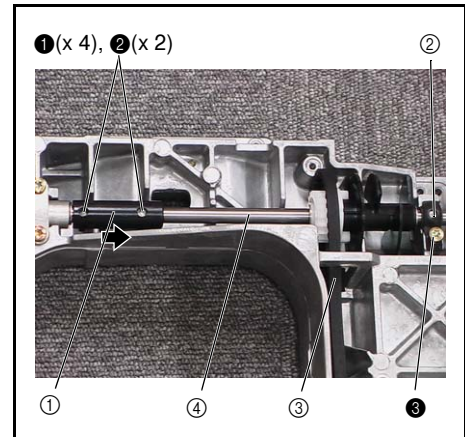
Needle bar, presser mechanism / Upper shaft mechanism location diagram





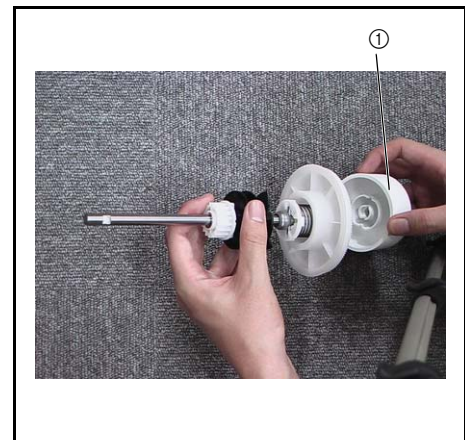
## 1 Upper shaft removal

1. Remove the 4 screws ① and the 2 screws ②, and slide the fixed joint ① to the right.
2. Remove the screw ③, and detach the bushing presser ②.
3. Remove the timing belt ③ and the upper shaft ④.
4. Remove the fixed joint ① from the upper shaft ④.



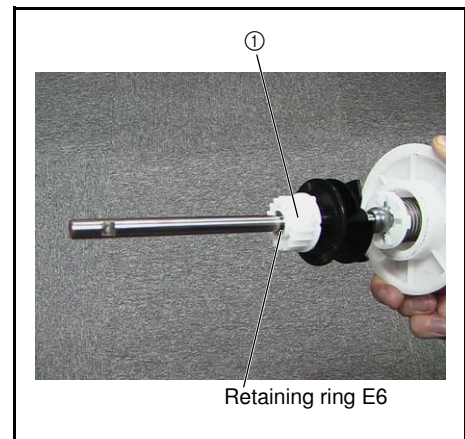
## 2 Pulley removal

1. Remove the pulley ①.



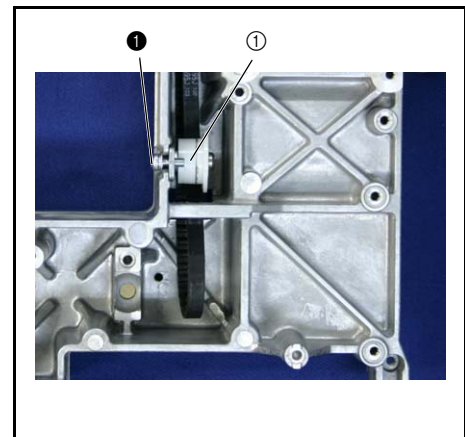
## 3 Upper shaft pulley removal

1. Remove retaining ring E6, and remove the upper shaft pulley ①.



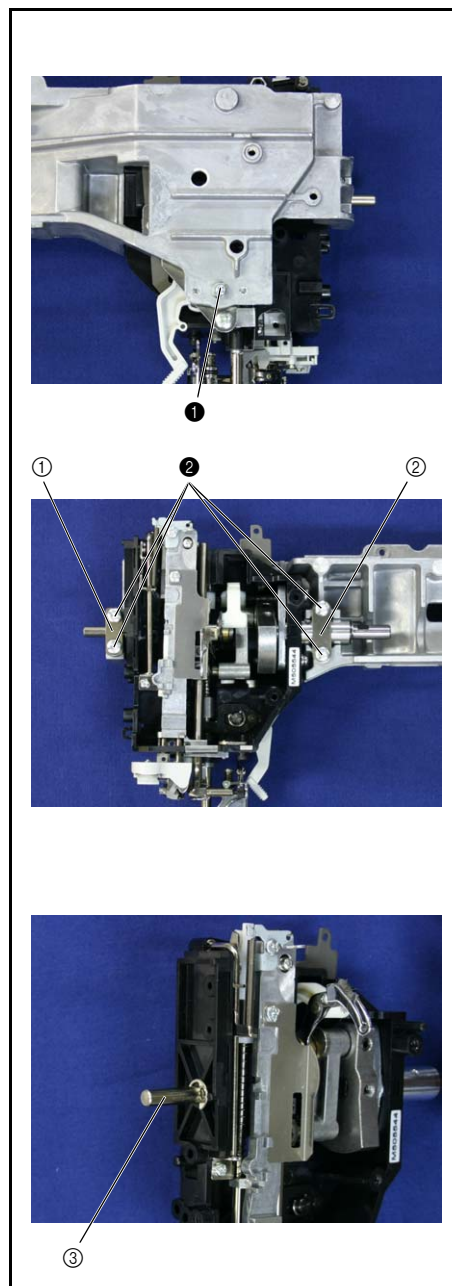
## 4 Tension pulley assembly removal

1. Remove the screw ①, and remove the tension pulley assembly ①.



## 5 Needle-presser module removal

1. Remove the screw ❶.
2. Remove the 4 screws ❷, and detach the presser plate A ❸ and the presser plate B ❹.
3. Remove the needle-presser module.
4. Detach the shaft ❺ from the needle-presser module.



**6** Plate spring removal

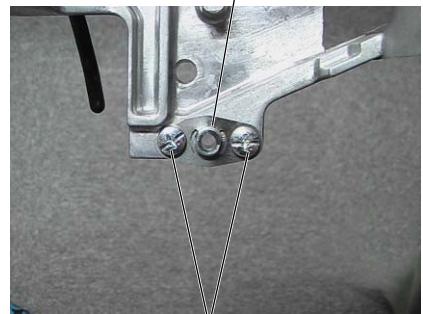
1. Remove the adjusting screw ①.
2. Remove the 2 screws ❶, and remove the plate spring ②.

\*Rear view



①

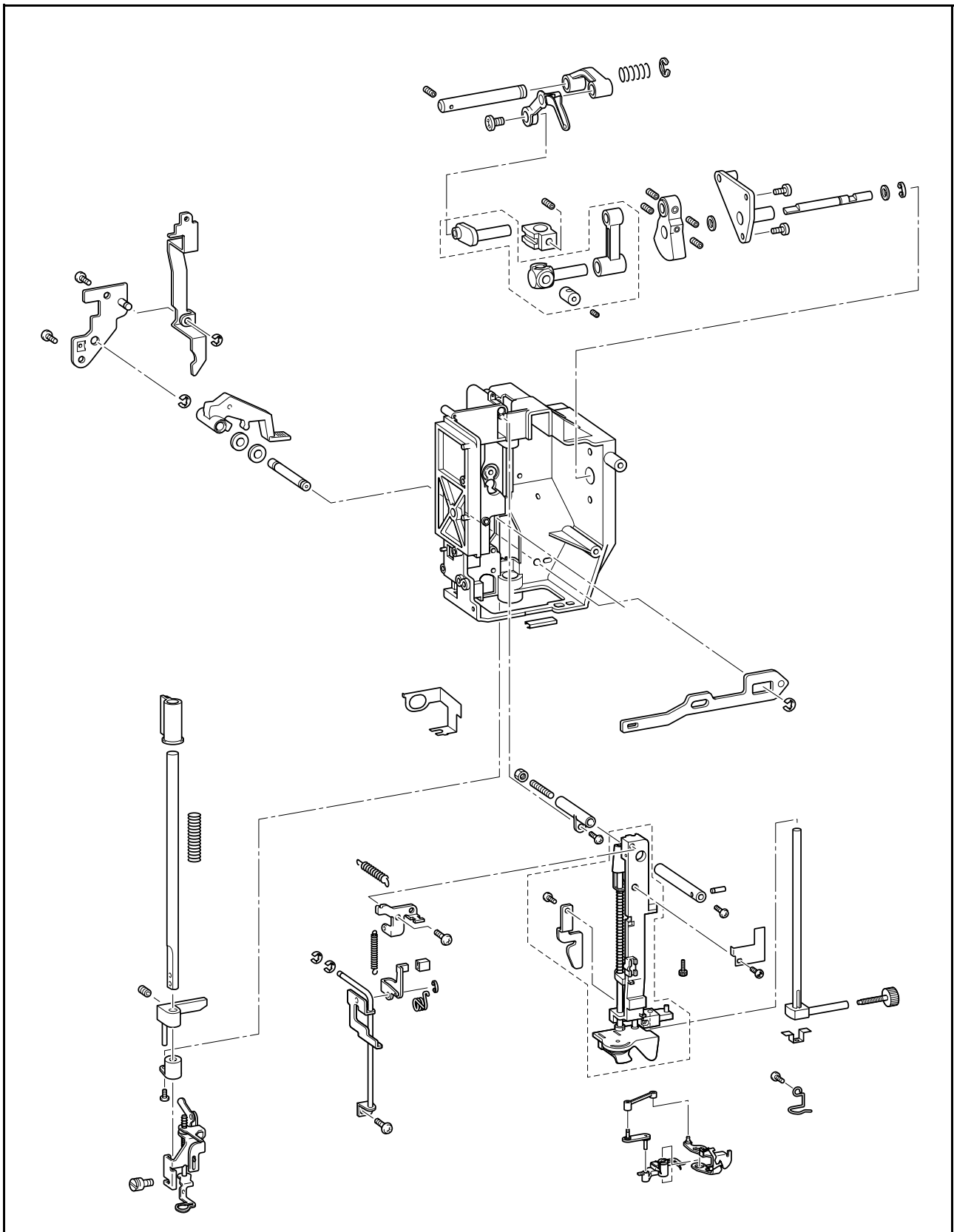
\*Front view



❶

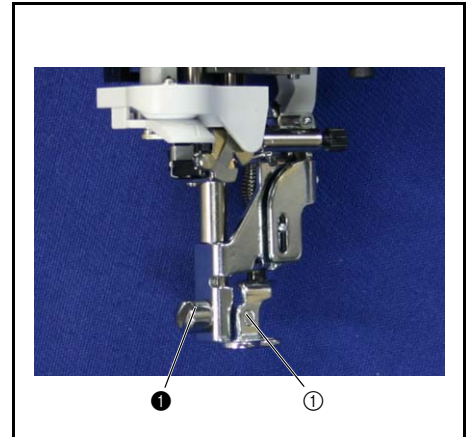
②

### Needle-presser module breakout diagram



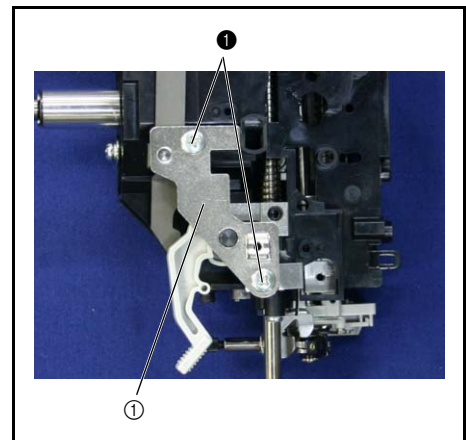
### 1 Quilting foot removal

1. Remove the screw ❶, and detach the quilting foot ❶.



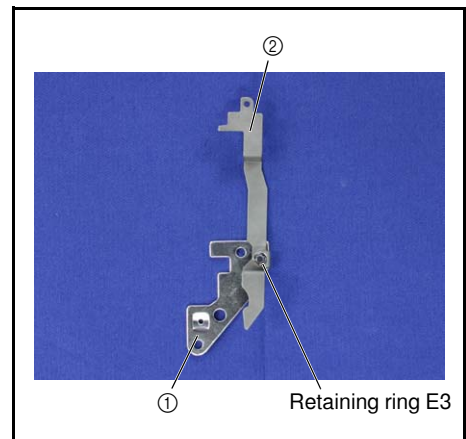
### 2 Adjusting plate assy. removal

1. Remove the 2 screws ❶, and remove the adjusting plate assy ❶.



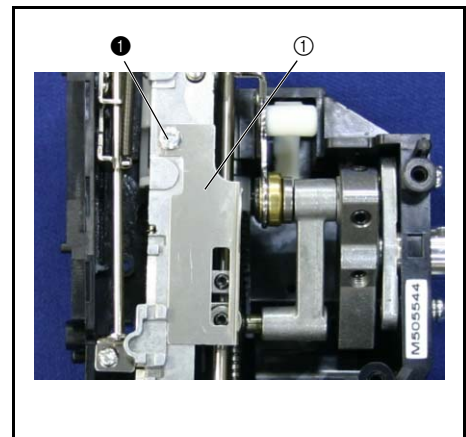
### 3 Adjusting plate ASSY disassembly

1. Remove the retaining ring E3, and then remove the tension releaser C ❷ from the adjusting plate assembly ❶.



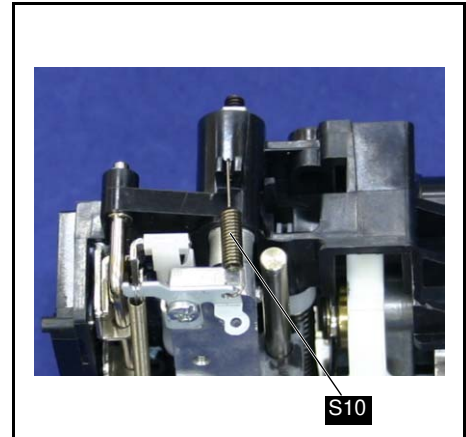
### 4 Guard plate removal

1. Remove the screw ❶, and then remove the guard plate ❶.

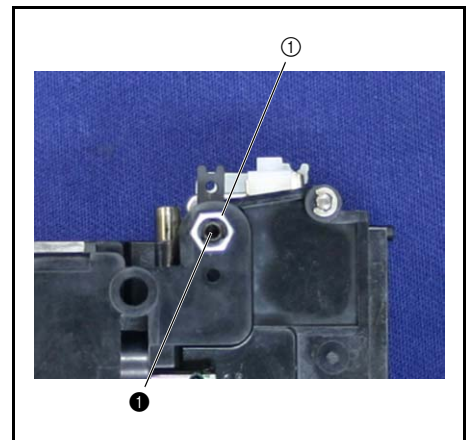


**5** Spring removal

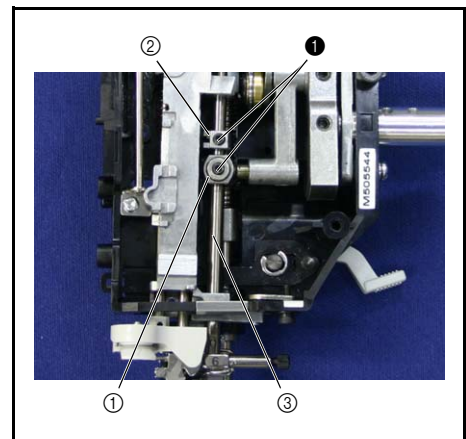
1. Remove the spring **S10**.

**6** Lock nut removal

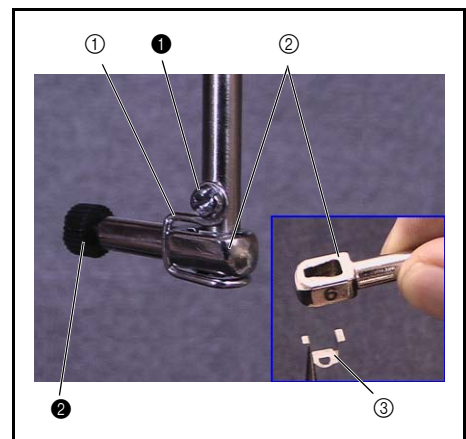
1. Remove the lock nut ① and the screw ①.

**7** Needle bar assy. removal

1. Remove the 2 screws ①.
2. Remove the needle bar ① and the needle thread block ②.

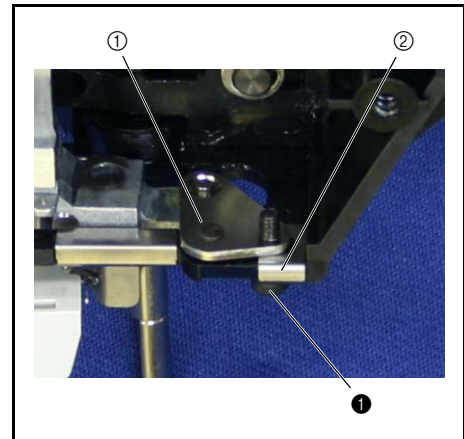
**8** Needle bar assy. disassembly

1. Remove the screw ①, and detach the needle bar thread guide ①.
2. Remove the screw ②, and remove the needle block ②.
3. Remove the needle thread plate ③ from the needle block ②.

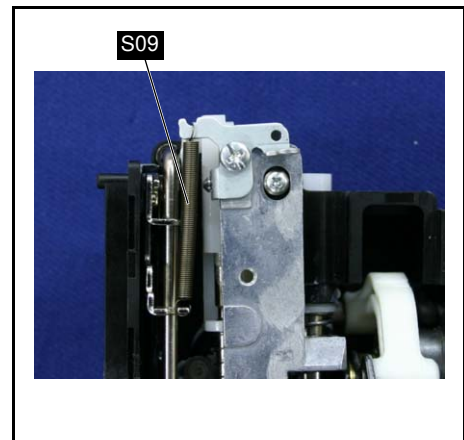


**9** Needle holder guide assy. removal

1. Remove the screw ❶, and remove the needle holder guide assy ❶ and the upper unit support plate ❷.

**10** Lever A spring removal

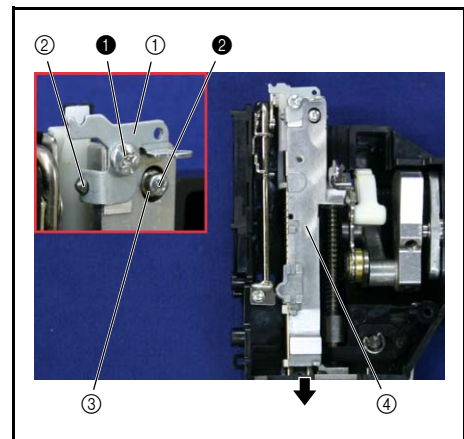
1. Remove the spring S09.

**11** Needle bar supporter assy. removal

1. Remove the screw ❶, and remove the plate ❶.
2. Remove the screw ❷, and remove the shaft ❷.
3. Remove the shaft ❸.
4. Remove the needle bar supporter assy ❹.

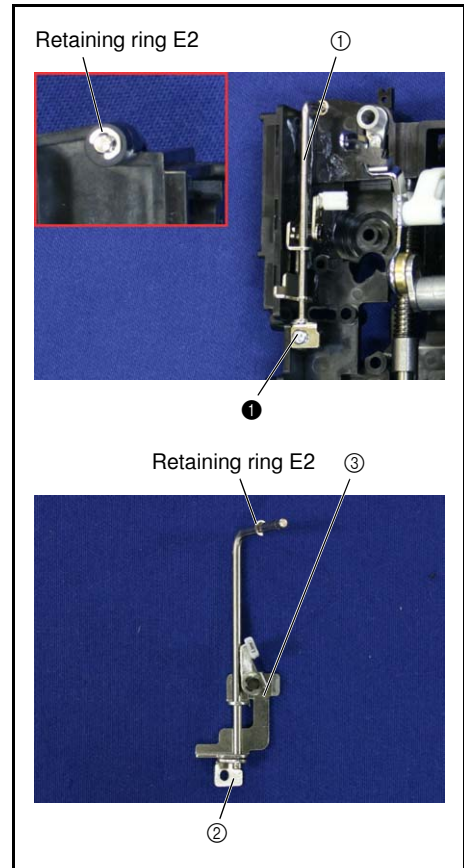
**\*Key point**

- Move the Z zigzag lever assy to the right.



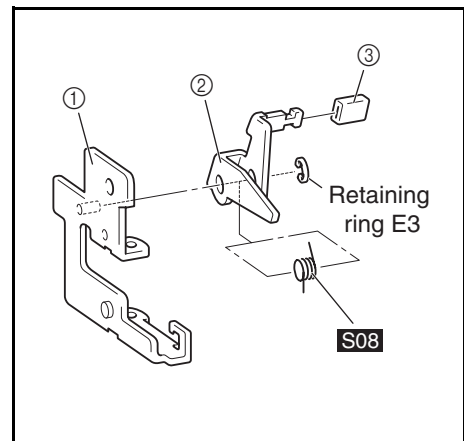
### 12 Lever AB assy. removal

1. Remove retaining ring E2.
2. Remove the screw ❶, and remove the lever guide shaft ❶.
3. Remove the lever presser plate ❷, lever AB assy ❸ and the retaining ring E2 from the lever guide shaft ❶.



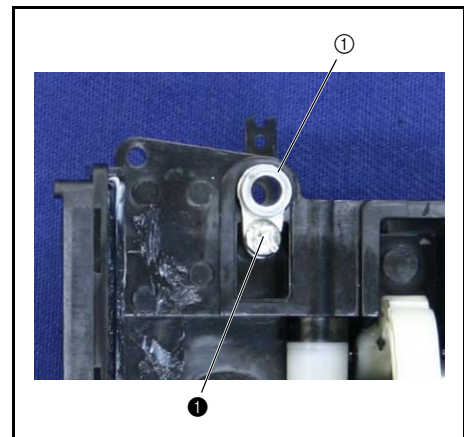
### 13 Lever AB assy. disassembly

1. Remove retaining ring E3, and remove the lever B ❷ and the spring S08 from the lever A assy. ❶.
2. Remove the cap ❸ from the lever B ❷.



### 14 Shaft bushing A removal

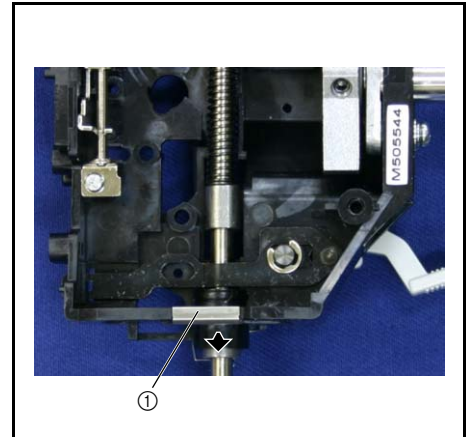
1. Remove the screw ❶, and detach the shaft bushing A ❶.



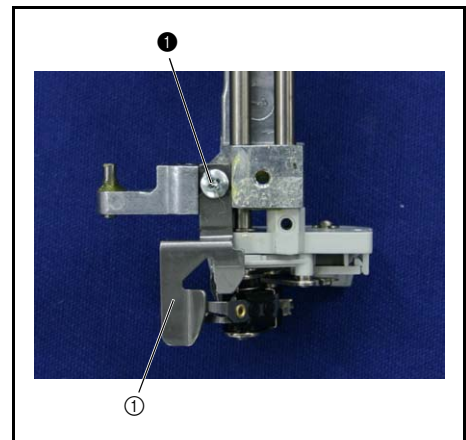


**15** Thread guide plate removal

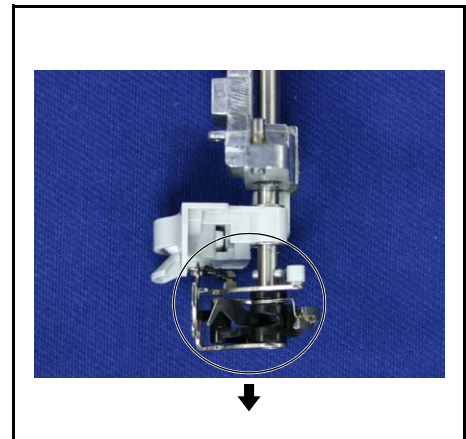
1. Remove the thread guide plate ①.

**16** Hook release plate removal

1. Remove the screw ❶, and detach the hook release plate ①.

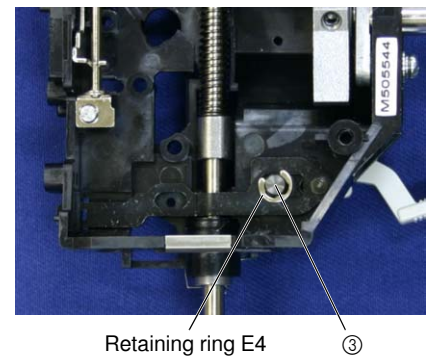
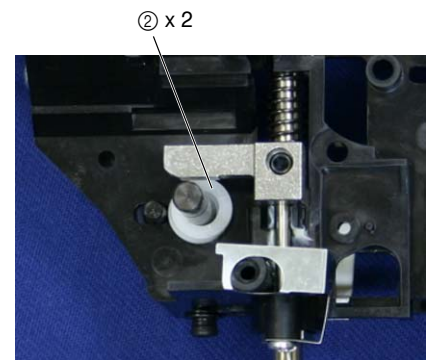
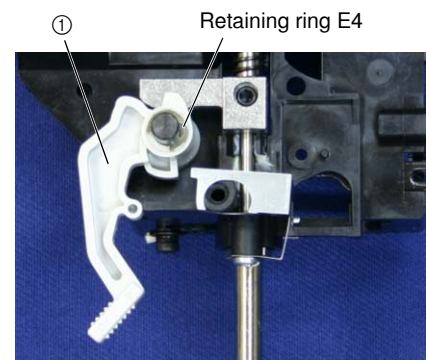
**17** Threader hook assy. disassembly

1. Remove the thread guide assy, threader hook assy, link A assy, and link B.



**18** Presser foot lifter removal

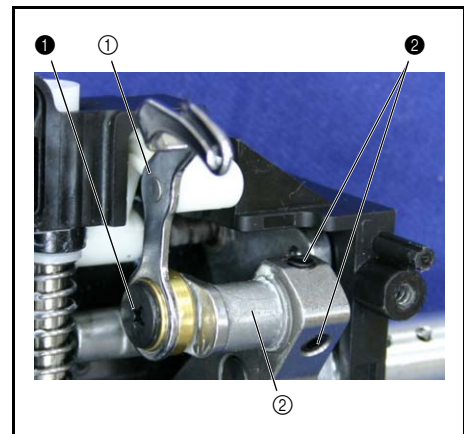
1. Remove the retaining ring E4.
2. Remove the presser foot lifter ① and the 2 washer ②.
3. Remove the presser lift shaft ③ and remove the retaining ring E4.
4. Remove the thread releaser assy ④.

**19** Thread take-up assy. removal

1. Remove the screw ①, and detach the thread take-up lever assy ①.

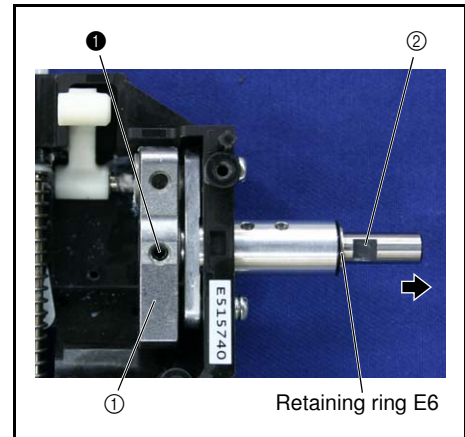
**NOTE** •The screw ① is reverse threaded.

2. Remove the 2 screws ②, and detach the needle bar crank rod assy ②.

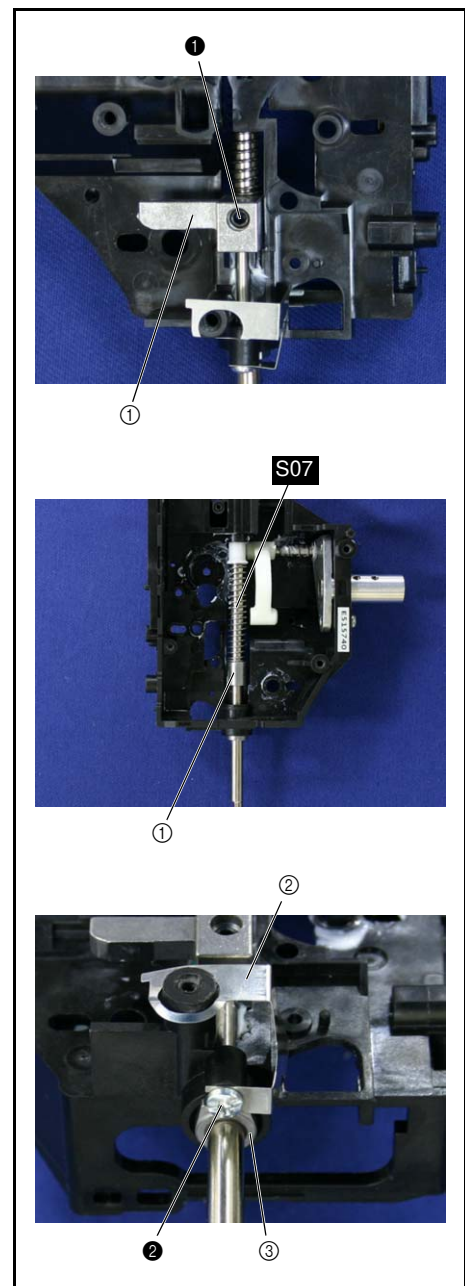


**20** Thread take-up counter weight removal

1. Remove the 2 screws ❶, and thread take-up counter weight ❶, thrust washer, unit shaft ❷ and thrust washer.
2. Remove the retaining ring E6 from the unit shaft ❷.

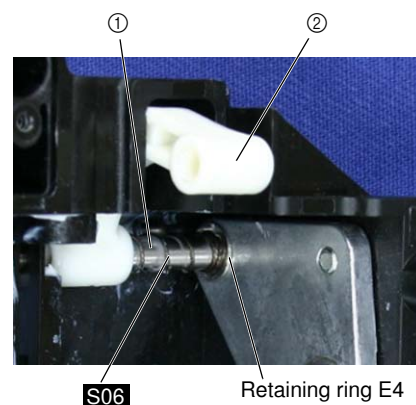
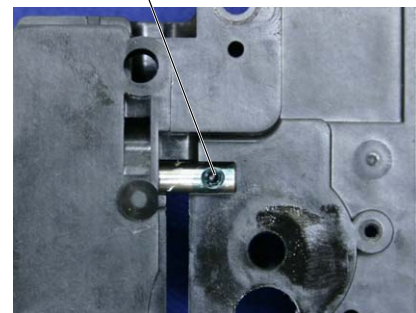
**21** Presser bar removal

1. Remove the screw ❶ from the presser bar clamp assembly ❶, and then pull the presser bar downward.
2. Remove the presser bar clamp assembly ❶ and spring S07.
3. Remove the screw ❷, and then remove the plate spring ❷ and the presser bar bushing ❸.



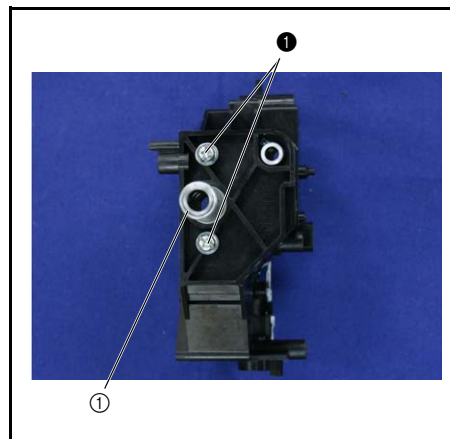
## 22 Thread take-up lever link removal

1. Remove the screw ①.
2. Remove the retaining ring E4, and remove the shaft ①, spring S06 and thread take-up lever link ②.

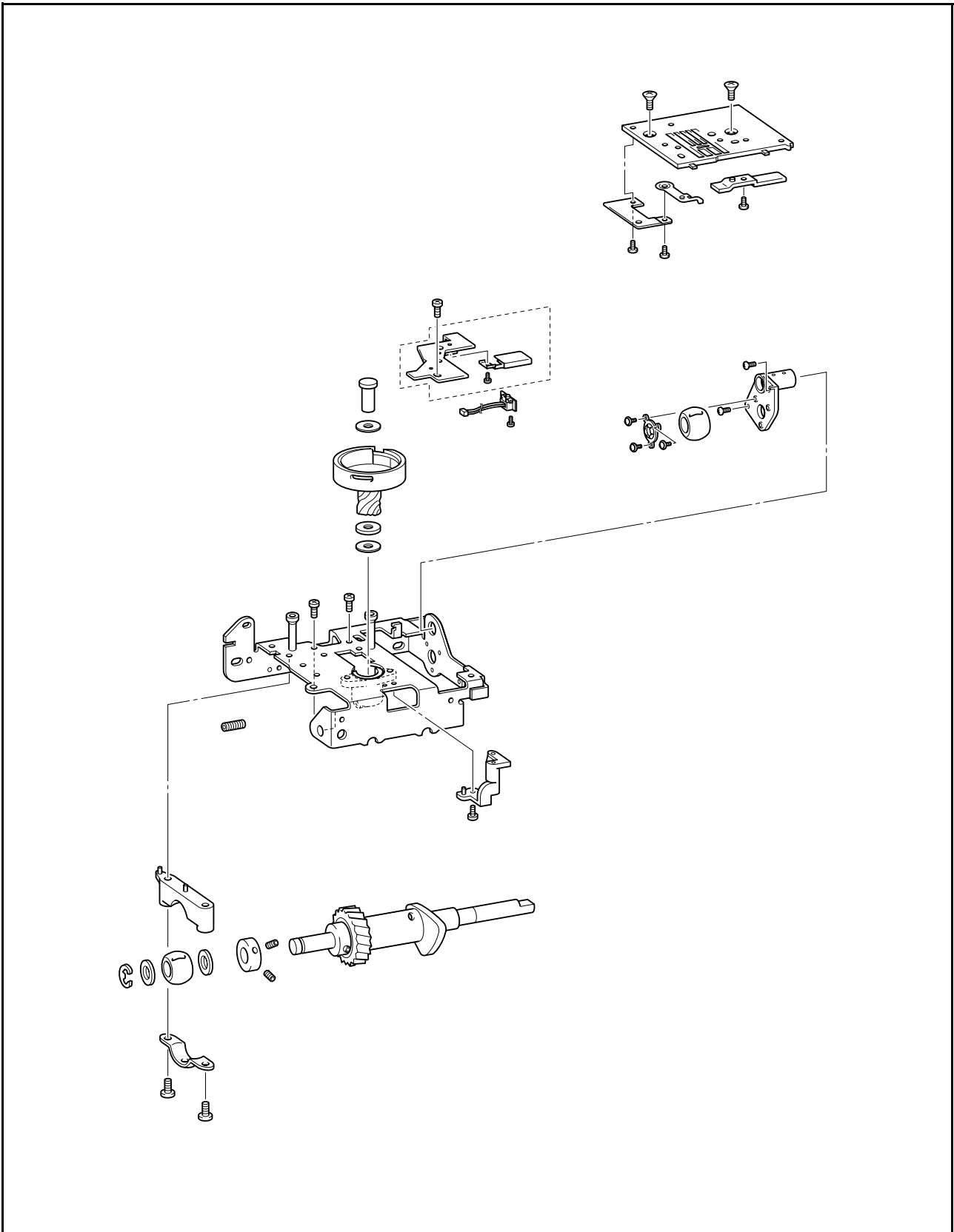


## 23 Shaft bushing assembly removal

1. Remove the 2 screws ①, and remove the shaft bushing assembly ①.

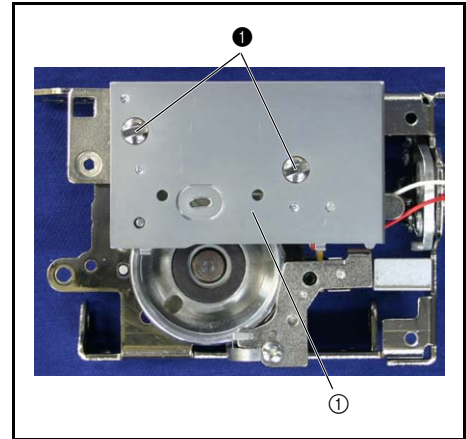


Feed module breakout diagram

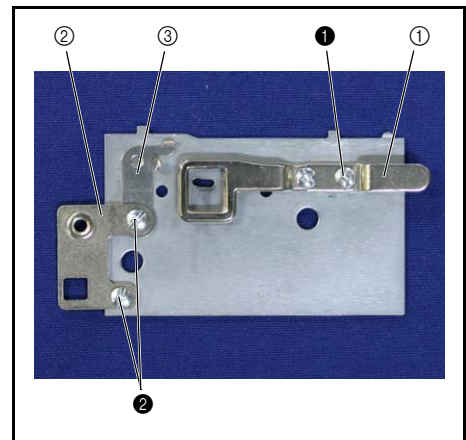


**1 Needle plate A removal**

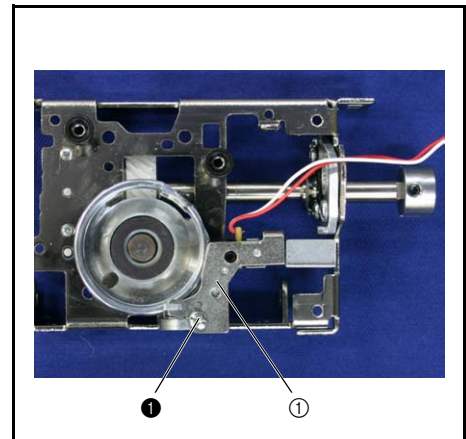
1. Remove the 2 screws ❶, and remove the needle plate A ❶.

**2 Needle plate A disassembly**

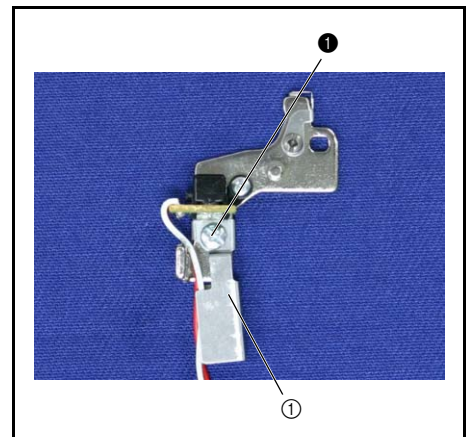
1. Remove the screw ❶, and then remove the F gear stopper plate ❶.
2. Remove the 2 screws ❷, and then remove the needle plate B support plate ❷ and the stopper plate ❸.

**3 Inner rotary hook bracket assy. removal**

1. Remove the screw ❶, and remove the inner rotary hook bracket assy ❶.

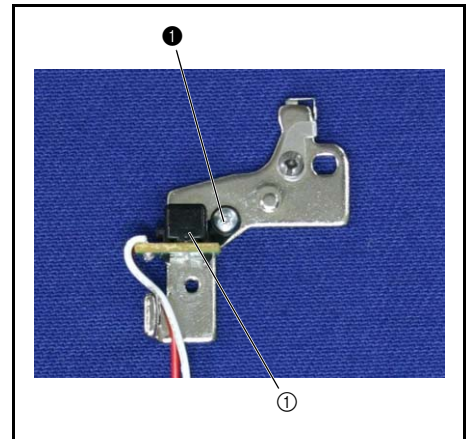
**4 Cord supporter removal**

1. Remove the screw ❶, and then remove the cord supporter ❶.



## 5 Photo diode holder assembly removal

1. Remove the screw ❶, and then remove the photo diode holder assembly ❶.

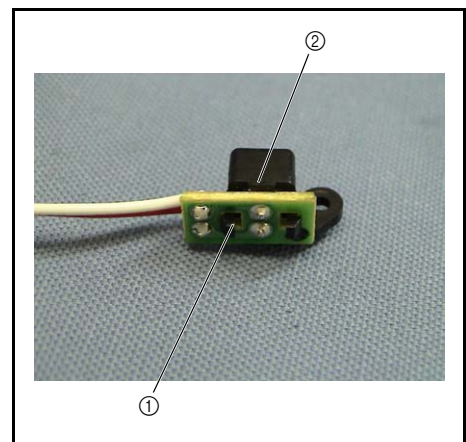


## 6 Photo diode assembly disassembly

1. Remove the photo diode assembly ❶ from the photo diode holder ❷.

### \*Key point

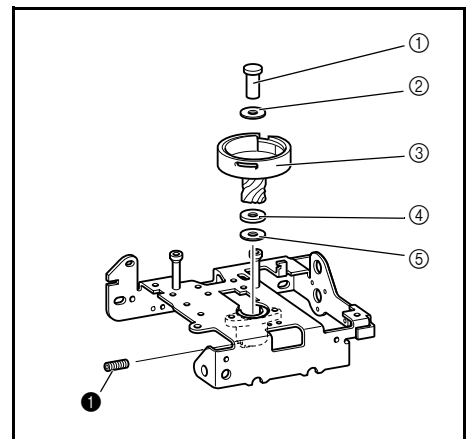
- Disengage the 2 hooks on the photo diode holder ❷.



## 7 Outer rotary hook assy. removal

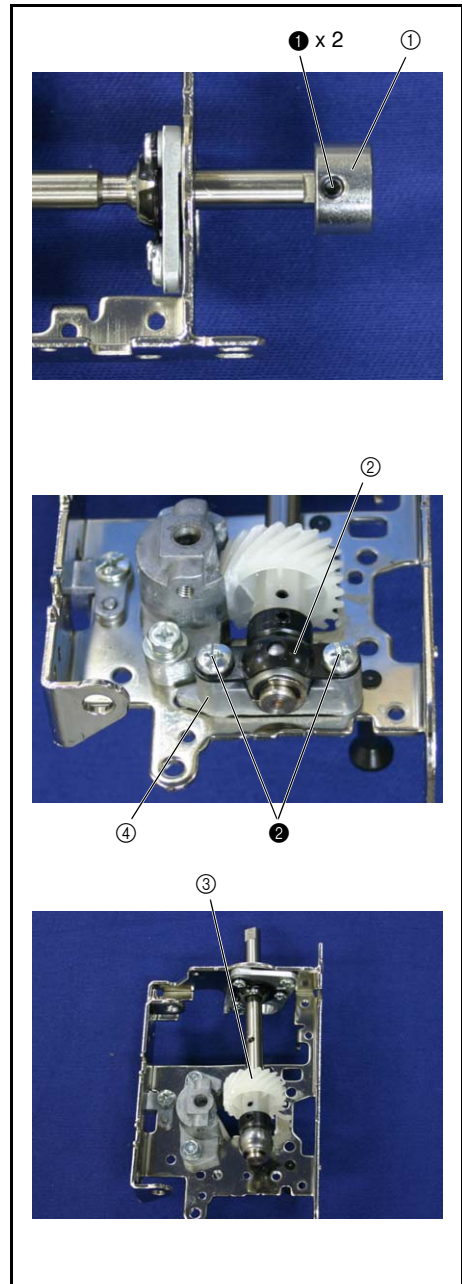
1. Remove the screw ❶, and remove the outer rotary hook shaft ❶, spacer ❷, outer rotary hook assy ❸, washer ❹ and the spacer ❺.

**NOTE** •Spacer and washer 6 attachment order  
 outer rotary hook shaft --> spacer (thin) --> outer rotary hook  
 assy. ❶ --> washer 6 (thick) --> spacer (thin)

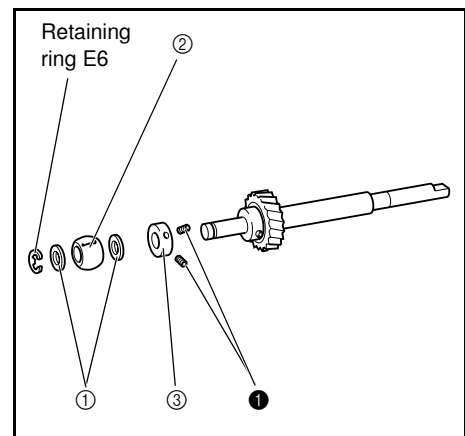


**8** Lower shaft B assy. removal

1. Remove the 2 screws ❶, and remove the joint ❶.
2. Remove the 2 screws ❷, and remove the bushing presser A ❷.
3. Remove the lower shaft B assy ❸.
4. Remove the bushing supporter A ❹ from the feed base.

**9** Lower shaft B assy. disassembly

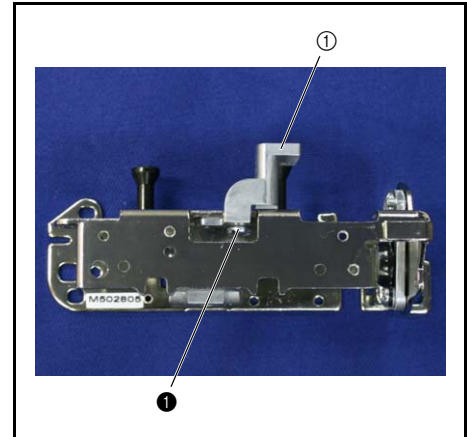
1. Remove the retaining ring E6, and remove the thrust washer ❶, lower shaft bushing ❷ and thrust washer ❶.
2. Remove the 2 screws ❶, and remove the set screw collar ❸.



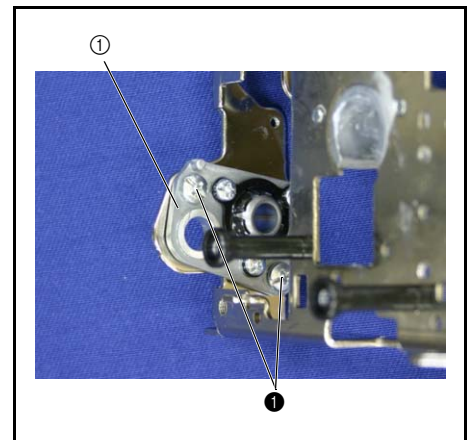


**10** Stopper plate block assy. removal

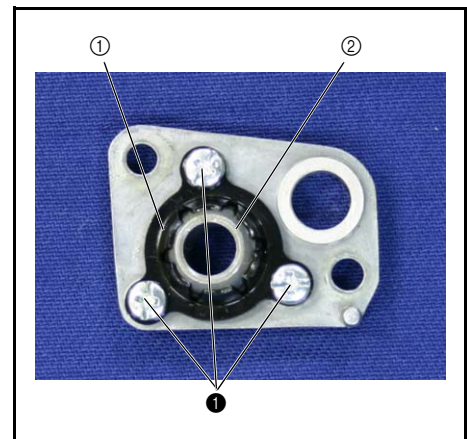
1. Remove the screw ❶, and remove the stopper plate block assy ❶.

**11** Bushing supporter B assy. removal

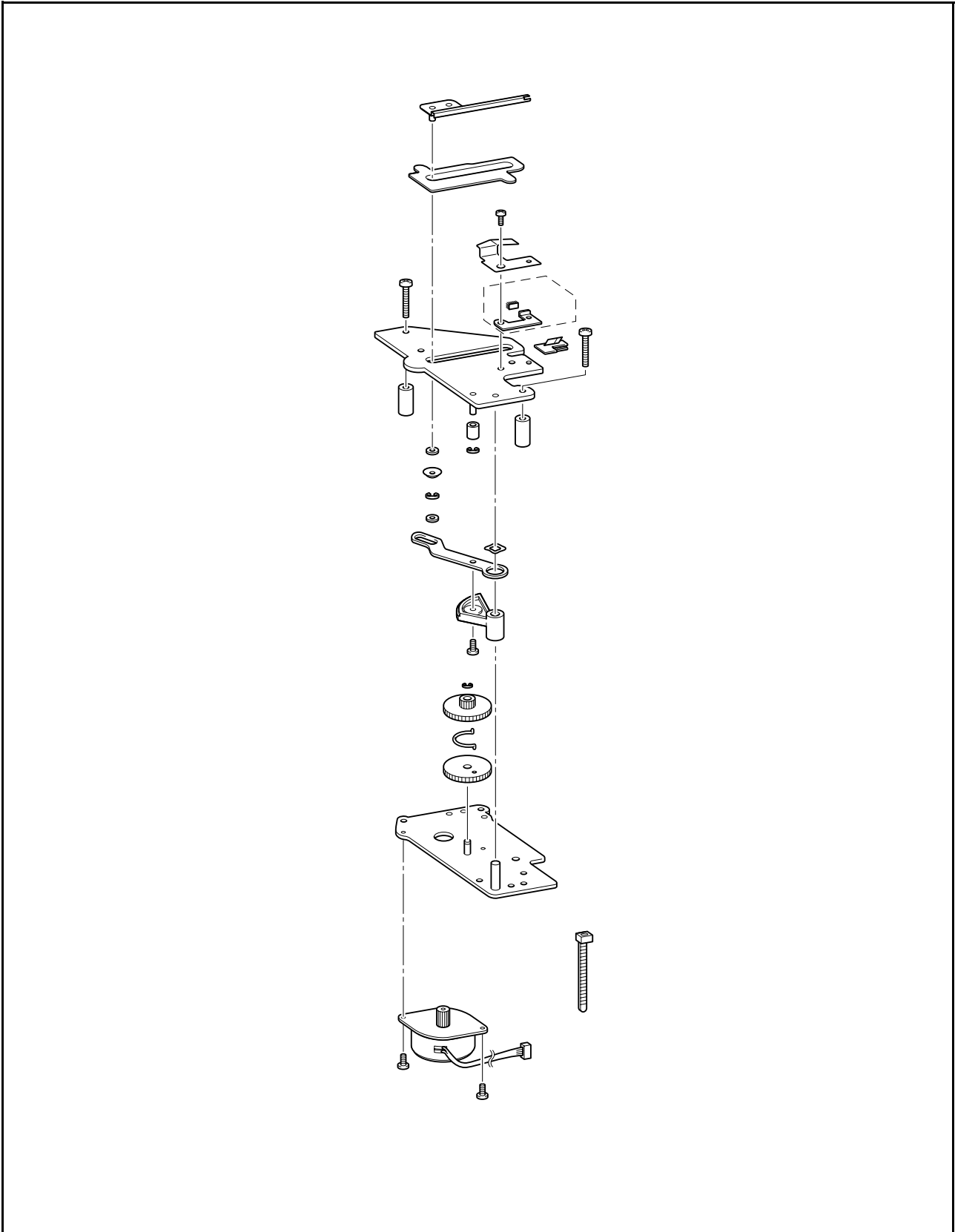
1. Remove the 2 screws ❶, and remove the bushing supporter B assy ❶.

**12** Bushing presser B removal

1. Remove the 3 screws ❶, and remove the bushing presser B ❶ and the lower shaft bushing ❷ from the bushing supporter B.



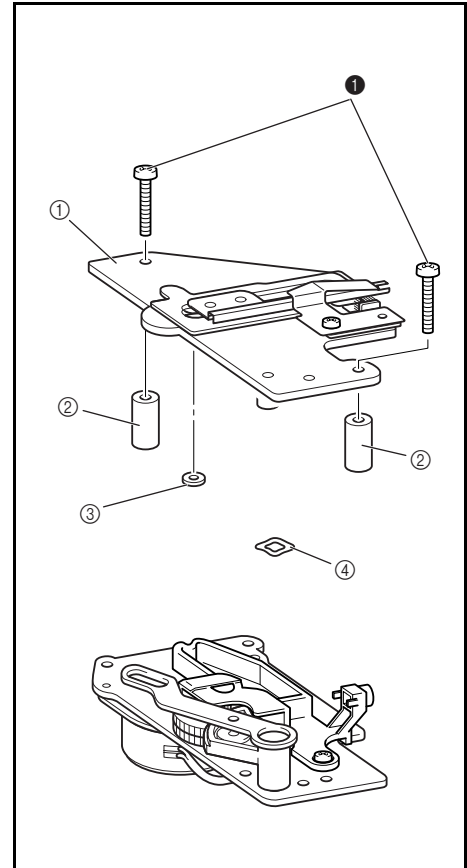
### Thread cutter module breakout diagram



Disassembly

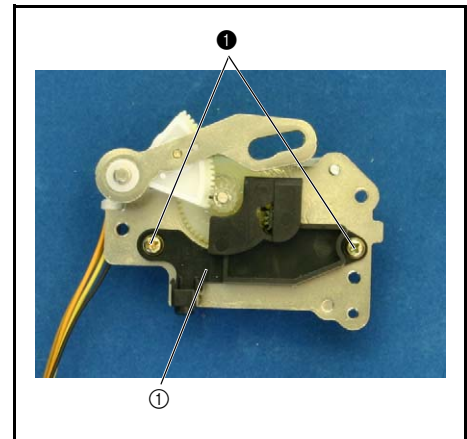
### 1 Thread cutter frame assembly removal

1. Remove the 2 screws ❶, and then remove the thread cutter frame assembly ❶, 2 collars ❷, and polyester slider ❸.
2. Remove the wave-shape spring washer ❹.



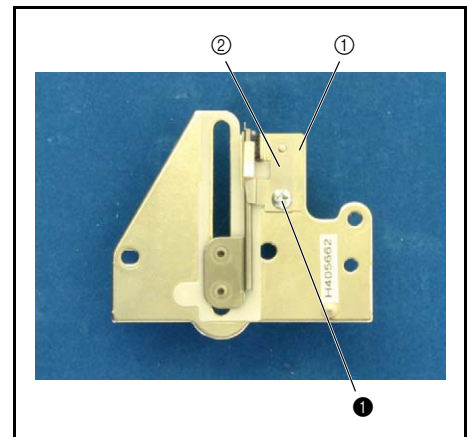
### 2 Photo transistor assembly removal

1. Remove the 2 screws ❶, and then remove the photo transistor assembly ❶.



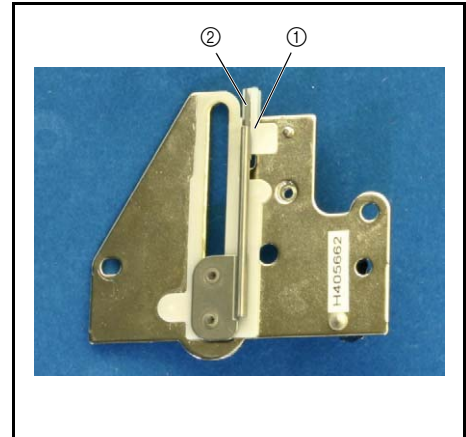
### 3 Presser plate removal

1. Remove the screw ❶, and then remove the presser plate ❶ and spring ❷.

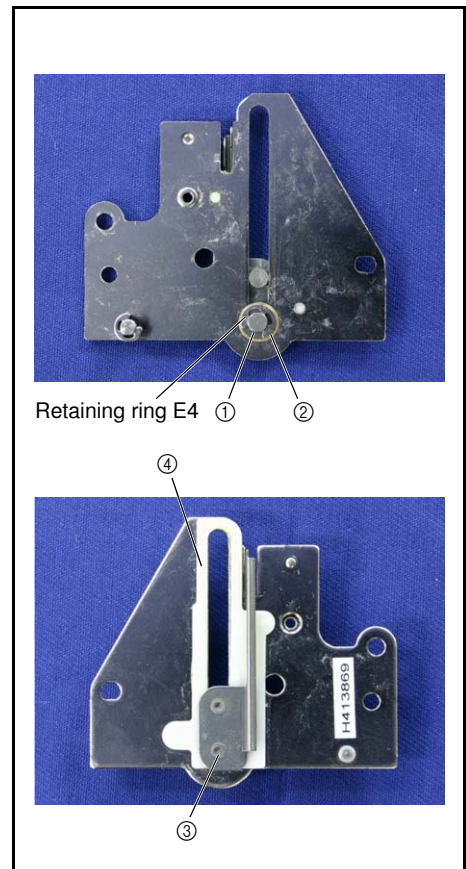


**4** Cutter holder assembly removal

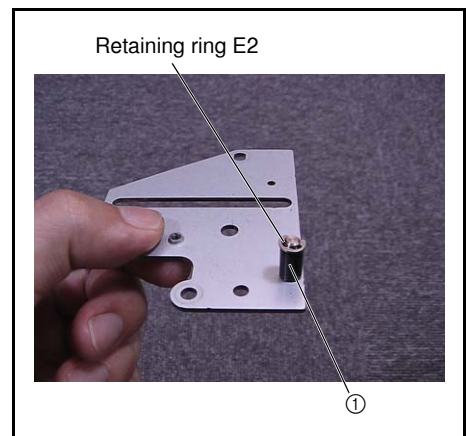
1. Remove the cutter holder assembly ①.
2. Remove the NT lower thread cutter ② from the cutter holder assembly ①.

**5** Thread hook assy. disassembly

1. Remove the retaining ring E4, and remove the polyester slider ①, polyester slider ② and the thread hook assy ③.
2. Detach the spacer ④.

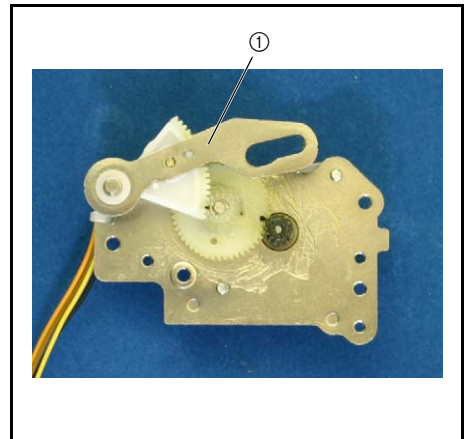
**6** Rubber removal

1. Remove the retaining ring E2, and remove the rubber ①.

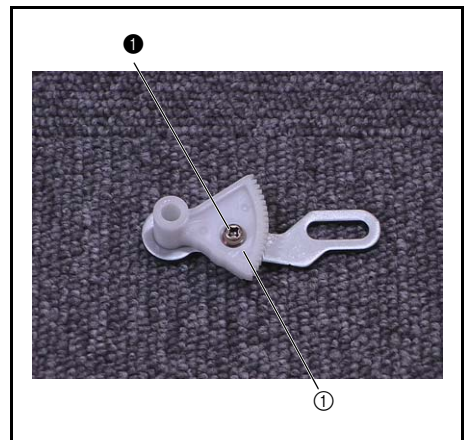


**7** Thread cutter lever assy. removal

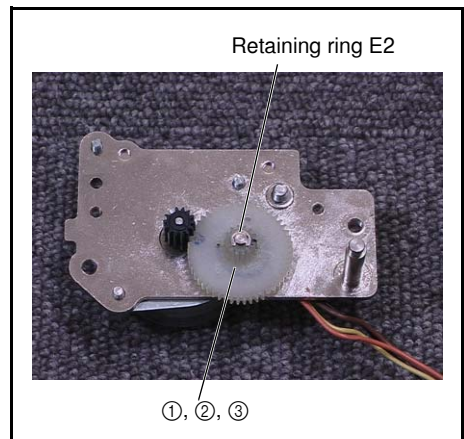
1. Remove the thread cutter lever assy ①.

**8** Thread cutter lever assy. disassembly

1. Remove the screw ①, and remove the thread cutter lever gear ①.

**9** Idle gear A and idle gear B removal

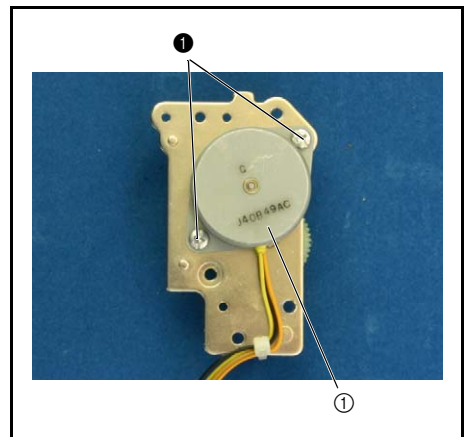
1. Remove the retaining ring E2, and remove the idle gear A ①, idle gear B ② and spring ③.

**10** Pulse motor C removal

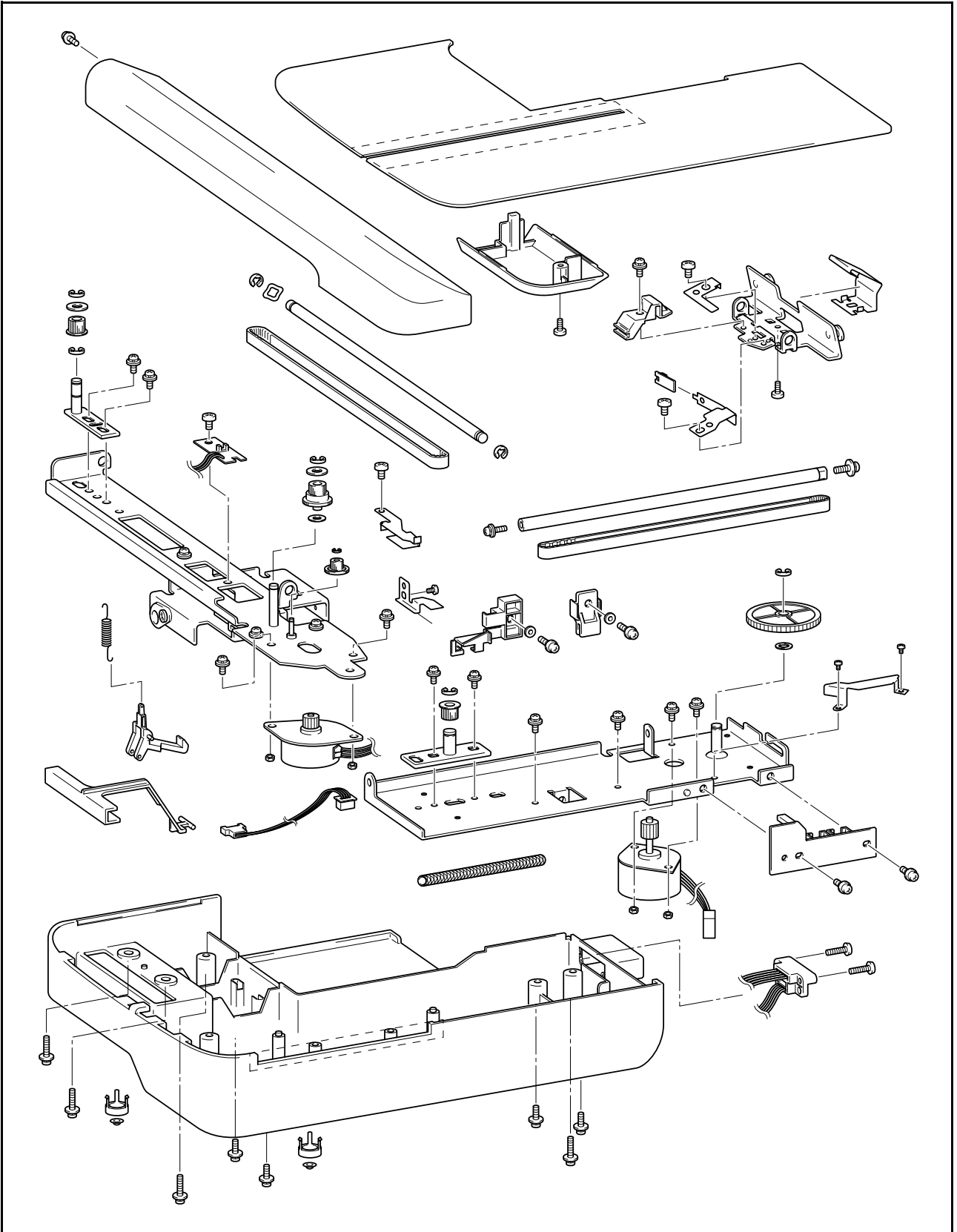
1. Remove the 2 screws ①, and then remove the pulse motor C (CPMSMJ35-4840-B) ①.

**\*Key point**

- Cut the band.

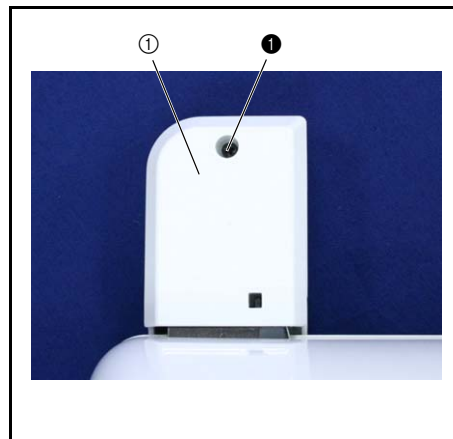


Embroidery parts location diagram

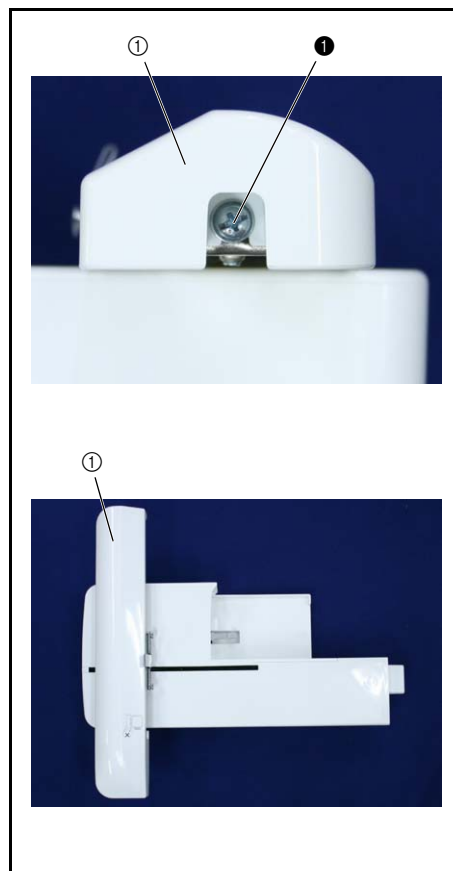


**1** YPM cover removal

1. Remove the screw ❶, and then remove the YPM cover ❶.

**2** X carriage cover removal

1. Remove the screw ❶, and then remove the X carriage cover ❶.

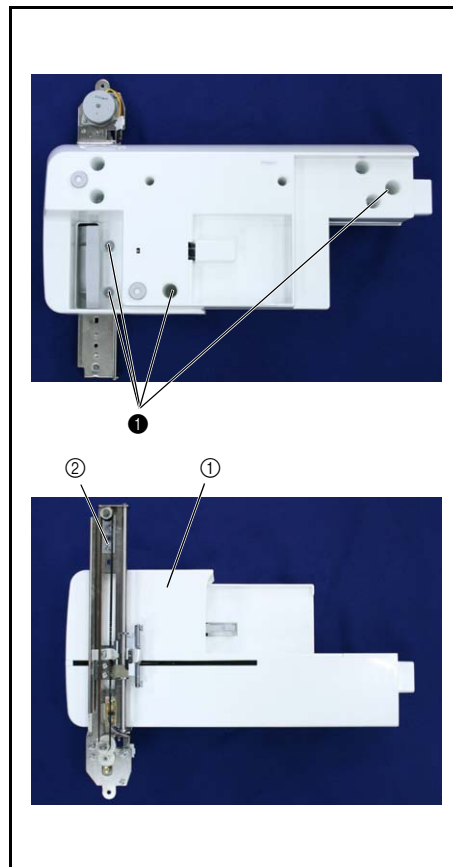


### 3 ES main cover assembly removal

1. Remove the 4 screws ❶, and then remove the ES main cover assembly ❶.

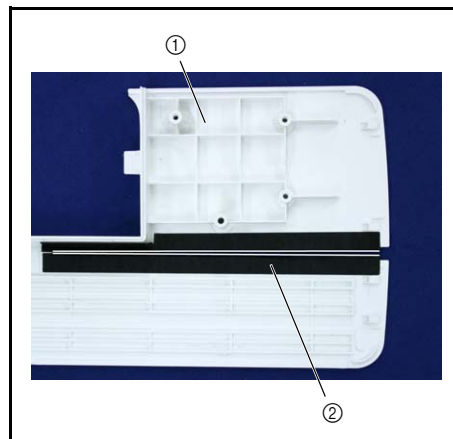
**\*Key point**

- Position the embroidery machine as shown in the photo on the right, and then slide the X carriage assembly ❷ to the left.
- Arrows are engraved on the outer surface of the base cover to indicate the locations of the 4 screws ❶.



### 4 Groove cover removal

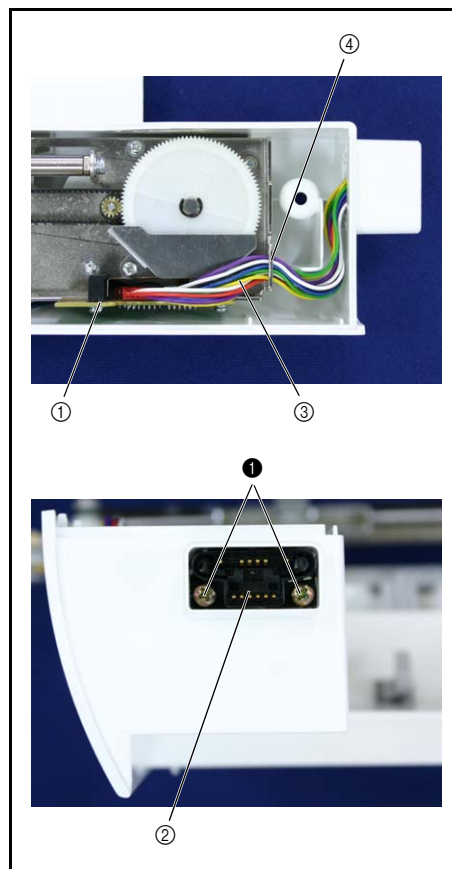
1. Remove the groove cover ❷ from the ES main cover assembly ❶.



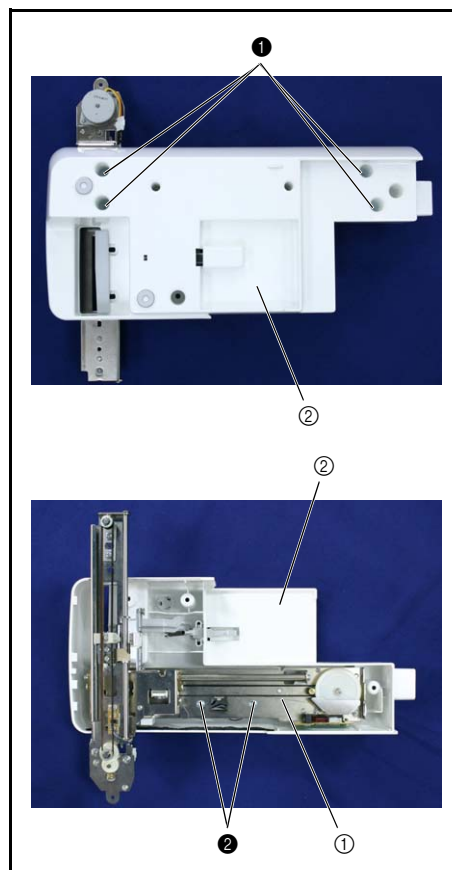


**5** Lead wire assembly (EMB unit FCOMB) removal

1. Remove the 2 connectors from the EMB relay PCB assembly ①.
2. Remove the lead wire ③ of the lead wire assembly (EMB unit FCOMB) ② from the guide ④ of the main frame subassembly.
3. Remove the 2 screws ①, and then remove the lead wire assembly ②.

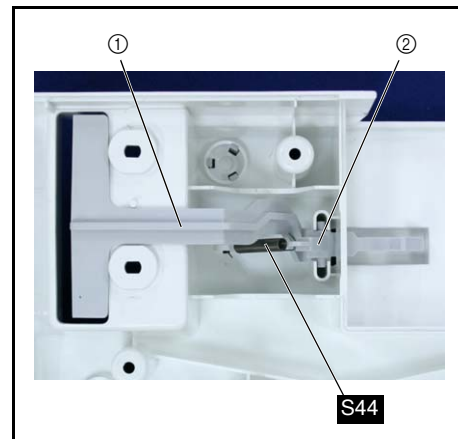
**6** ES base cover unit removal

1. Remove the 6 screws (①x4, ②x2), and then remove the EX base cover unit ② from the main frame ①.

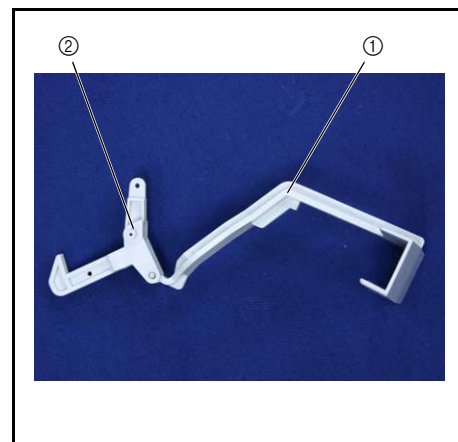


**7** Lock release lever assembly removal

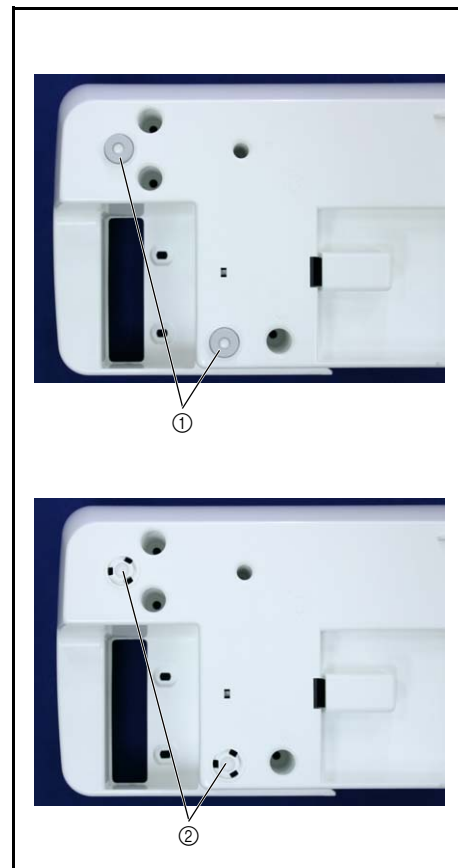
1. Remove the spring **S44** from the lock finger ② on the lock release lever assembly ①.
2. Remove the lock release lever assembly ①.
3. Remove the spring **S44** from the ES base cover.

**8** Lock release lever ASSY disassembly

1. Remove the lock finger ② from the lock release lever ①.

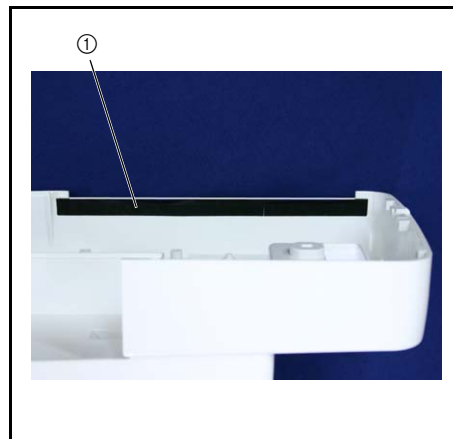
**9** Rubber cushion and rubber cushion cover removal

1. Disengage the 3 hooks from the outer surface of the ES base cover, and then remove the 2 rubber cushion covers ①.
2. Peel the 2 rubber cushions ② from the ES base cover.

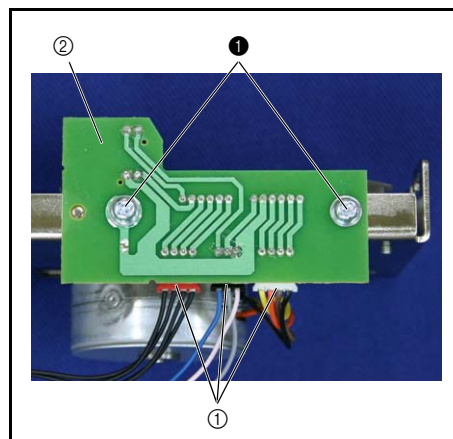


**10** Groove cover removal

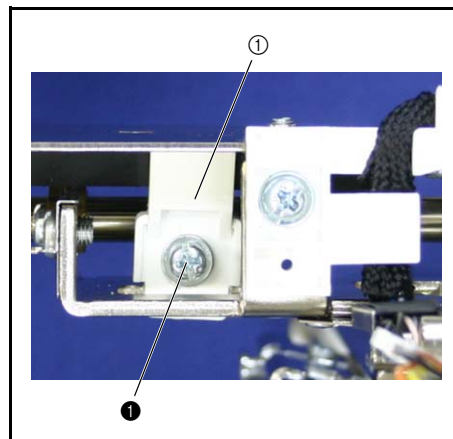
1. Remove the groove cover ① from the ES base cover.

**11** EMB relay PCB assembly removal

1. Remove the 3 connectors ① from the EMB relay PCB assembly ②.
2. Remove the 2 screws ①, and then remove the EMB relay PCB assembly ②.

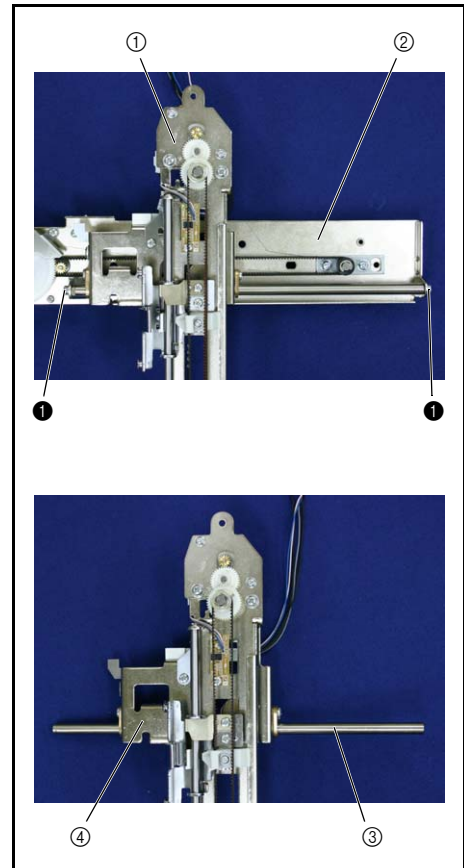
**12** X belt presser removal

1. Remove the screw ①, and then remove the X belt presser ①.

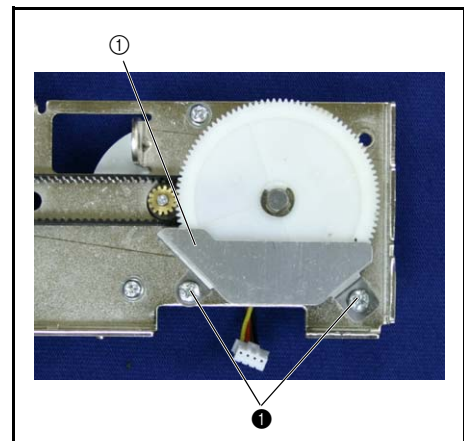


**13** XY carriage unit removal

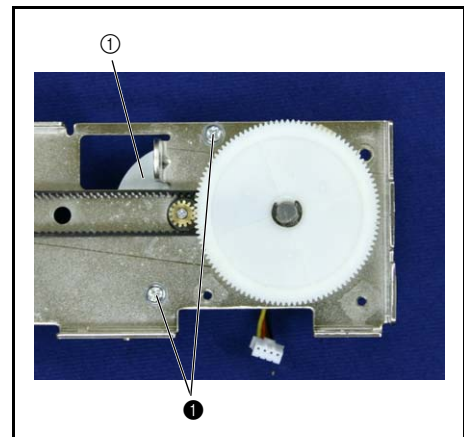
1. Remove the 2 screws ❶, and then remove the XY carriage unit ❶ from the main frame ❷.
2. Remove the X guide shaft ❸ from the Y carriage assembly ❹.

**14** Oil guard plate removal

1. Remove the 2 screws ❶, and then remove the oil guard plate ❶.

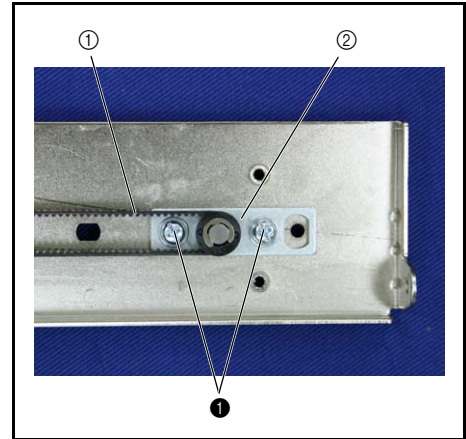
**15** X pulse motor assembly removal

1. Remove the 2 screws ❶, and then remove the X pulse motor assembly ❶.

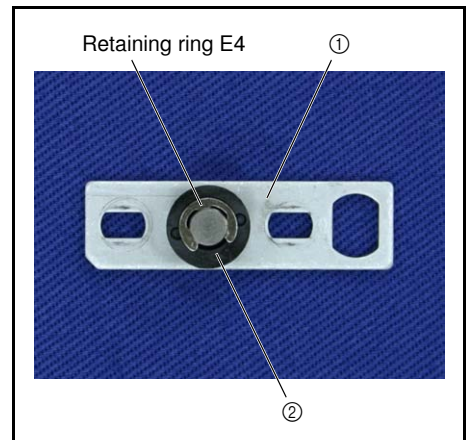


**16** X tension pulley assembly removal

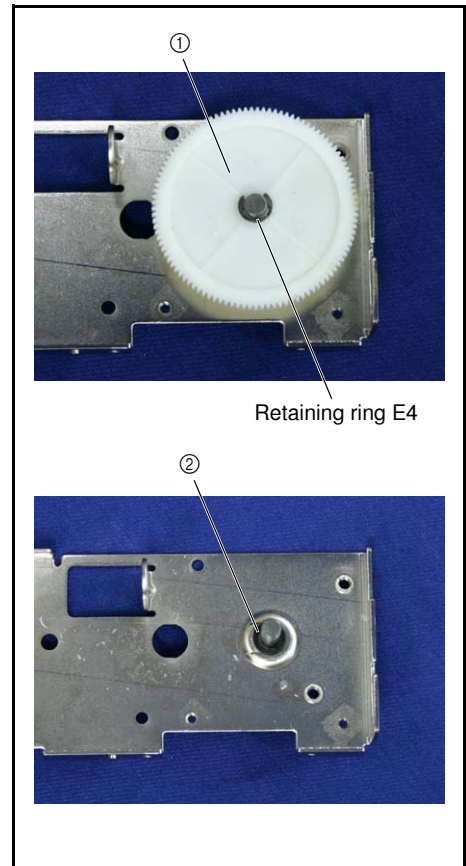
1. Remove the 2 screws ❶, and then remove the timing belt ❶ and the X tension pulley assembly ❷.

**17** X tension pulley ASSY disassembly

1. Remove the retaining ring (E4), and then remove the tension pulley ❷ from the X tension pulley assembly ❶.

**18** X driving gear pulley removal

1. Remove the retaining ring (E4), and then remove the X driving gear pulley ❶ and the washer ❷.

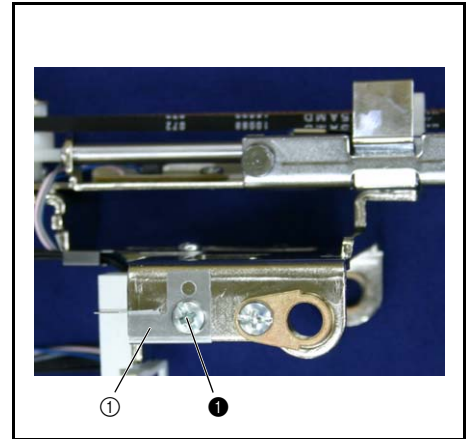


**19** X initial shutter removal

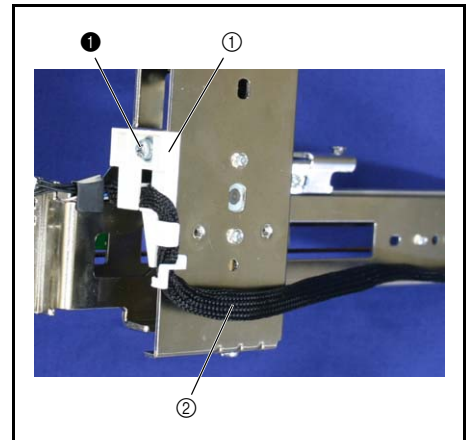
1. Remove the screw ❶, and then remove the X initial shutter ❶.

**\*Key point**

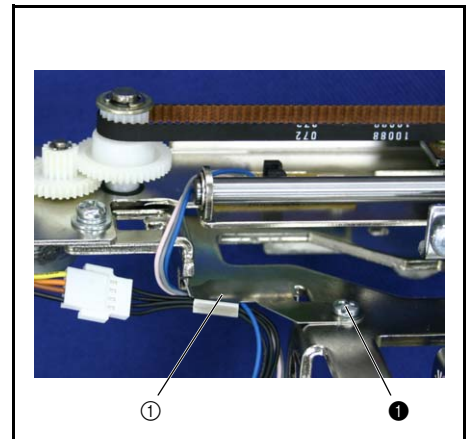
- The X initial shutter has sharp edges. Be careful when handling it.

**20** X slider removal

1. Remove the lead wire from the guide of the X slider ❶.
2. Remove the screw ❶, and then remove the X slider ❶.
3. Remove the nylon sleeve ❷ from the lead wire.

**21** Cord guide removal

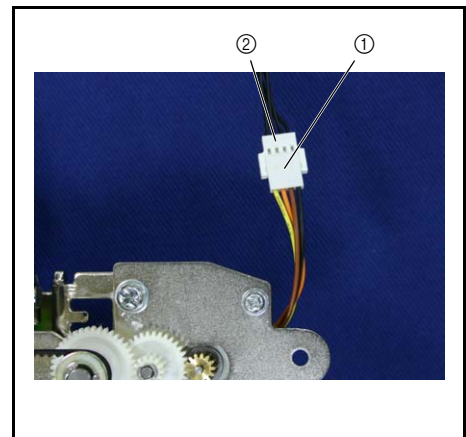
1. Remove the screw ❶, and then remove the cord guide ❶.

**22** Lead wire assembly YPM relay removal

1. Remove the lead wire assembly YPM relay ❷ from the lead wire connector on the Y pulse motor assembly ❶.

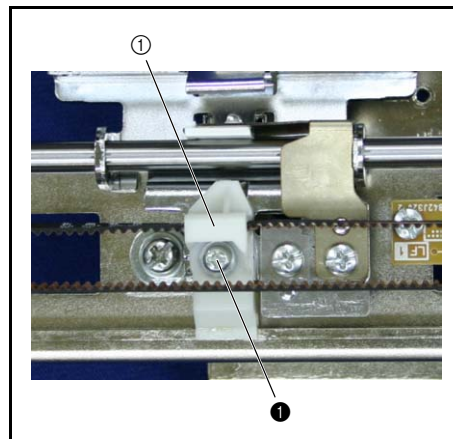
**\*Key point**

- Cut the band securing the Y sensor PCB assembly's lead wire and the lead wire assembly YPM relay ❷.

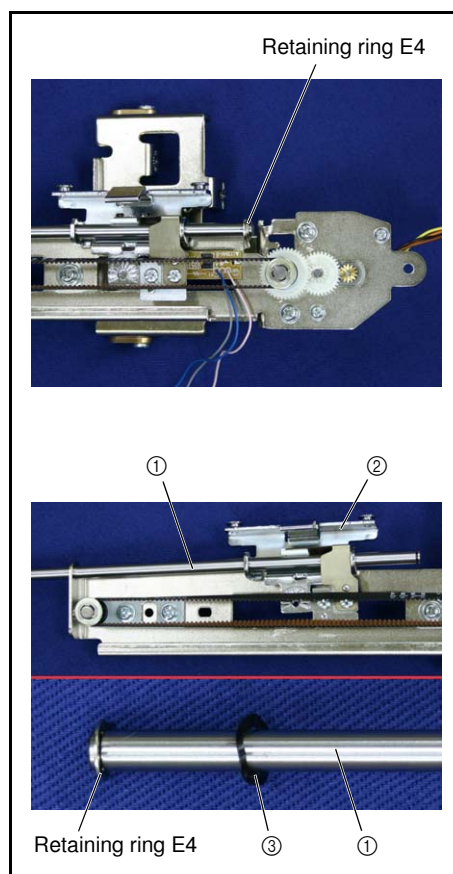


**23** Y slider removal

1. Remove the screw ❶, and then remove the Y slider ❶.

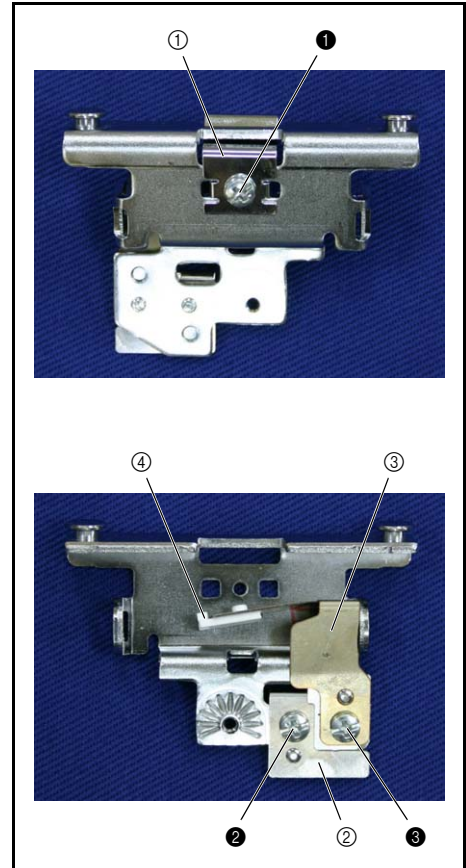
**24** Y carriage unit removal

1. Remove the retaining ring (E4).
2. Pull out the Y guide shaft ❶ from the Y carriage unit ❷.
3. Pull out the wave spring washer ❸ from the Y guide shaft ❶, and then remove the retaining ring (E4).

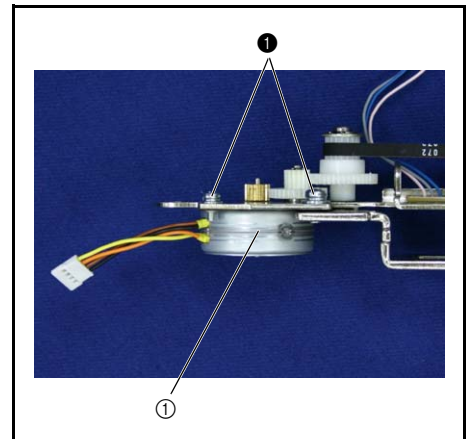


**25** Y carriage ASSY disassembly

1. Remove the screw ❶, and then remove the spring ❶.
2. Remove the screw ❷, and then remove the Y initial shutter ❷.
3. Remove the screw ❸, and then remove the Y guide shaft presser plate ❸.
4. Remove the Y guide shaft presser ❹ from the Y guide shaft presser plate ❸.

**26** Y pulse motor assembly removal

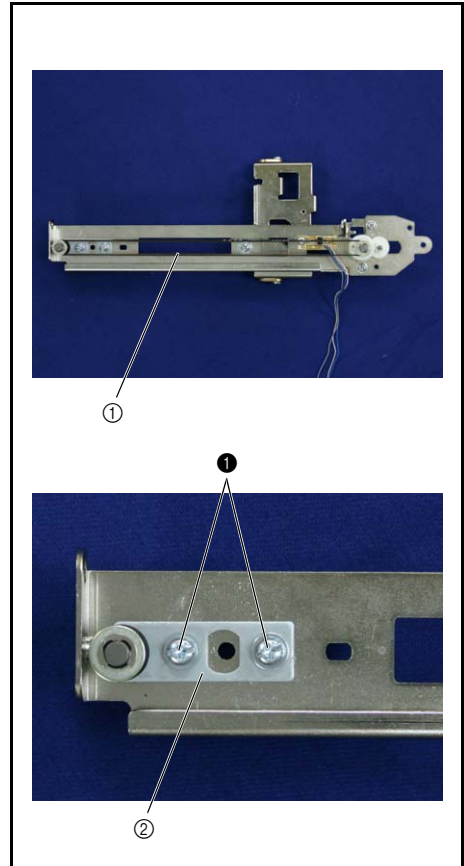
1. Remove the 2 screws ❶, and then remove the Y pulse motor assembly ❶.



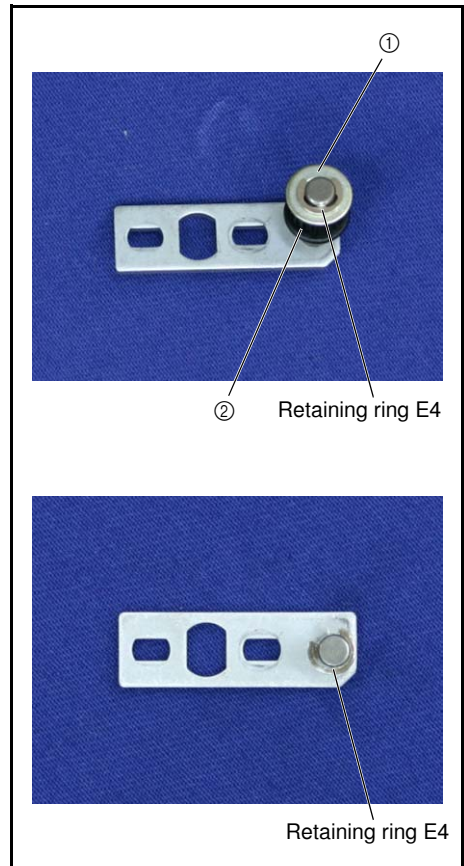


**27** Y tension pulley assembly removal

1. Remove the 2 screws ❶, and then remove the timing belt ❶ and the Y tension pulley assembly ❷.

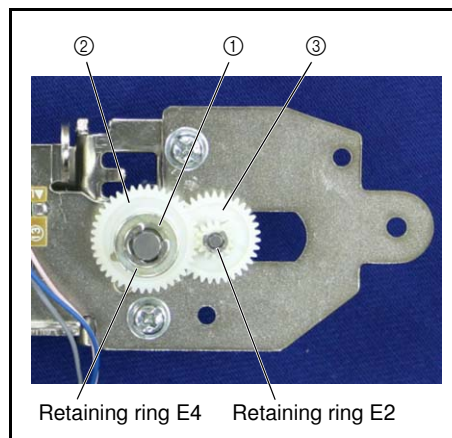
**28** Y tension pulley ASSY disassembly

1. Remove the retaining ring (E4), and then remove the plain washer (M6) ❶ and the tension pulley ❷.
2. Remove the retaining ring (E4).

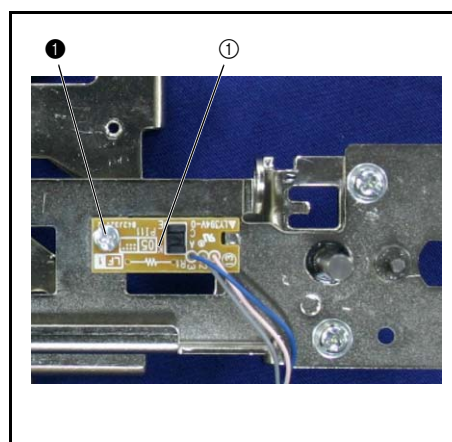


**29** Y driving gear pulley assembly removal

1. Remove the retaining ring (E4), and then remove the plain washer (M6) ① and the Y driving gear pulley ②.
2. Remove the retaining ring (E2), and then remove the gear ③.

**30** Y sensor PCB assembly removal

1. Remove the screw ①, and then remove the Y sensor PCB assembly ①.





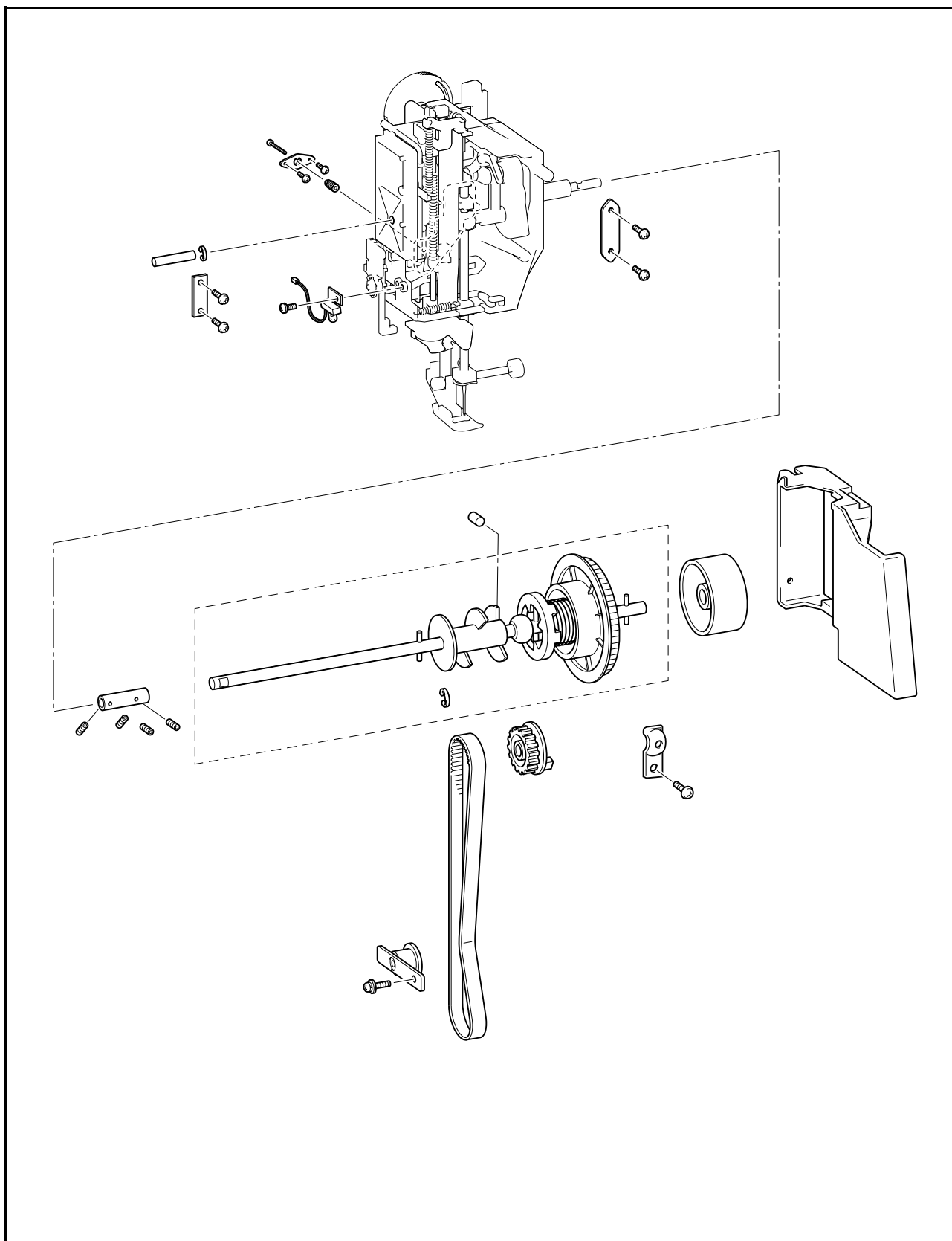
# 3 Assembly

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When disassembly and assembly are performed, make adjustments according to "4 Adjustments."

Main unit	Needle bar, presser mechanism /	
	upper shaft mechanism .....	3 - 2
	Rotary hook drive mechanism /	
	Feed and bobbin mechanism /	
	Cutter assy. ....	3 - 7
	Bobbin winder mechanism .....	3 - 11
	Thread tension mechanism .....	3 - 15
	Electrical parts and motors .....	3 - 24
	Main parts .....	3 - 29
Modules	Needle-presser module .....	3 - 39
	Feed module.....	3 - 52
	Thread cutter module .....	3 - 59
Embroidery	Embroidery parts .....	3 - 65

Needle bar, presser mechanism / upper shaft mechanism location diagram



## 1 Plate spring attachment

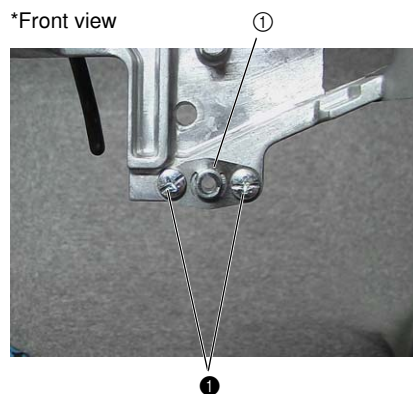
1. Attach the plate spring ① from the front of the arm bed using the 2 screws ①.
2. Attach the plate spring ① from the back of the arm bed using the adjusting screw ②.

### \*Key point

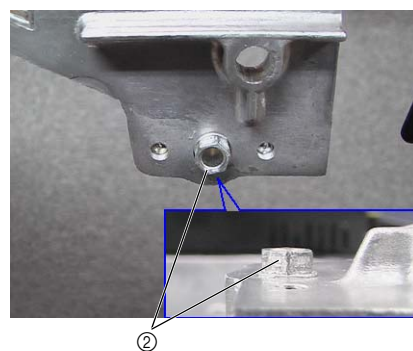
- Tighten adjusting screw ② so that the screw threads are completely hidden.

①		Screw, Blind M4X5	Torque 1.18 – 1.57 N*m
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\*Front view



\*Rear view

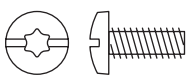
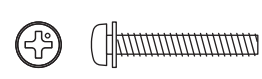


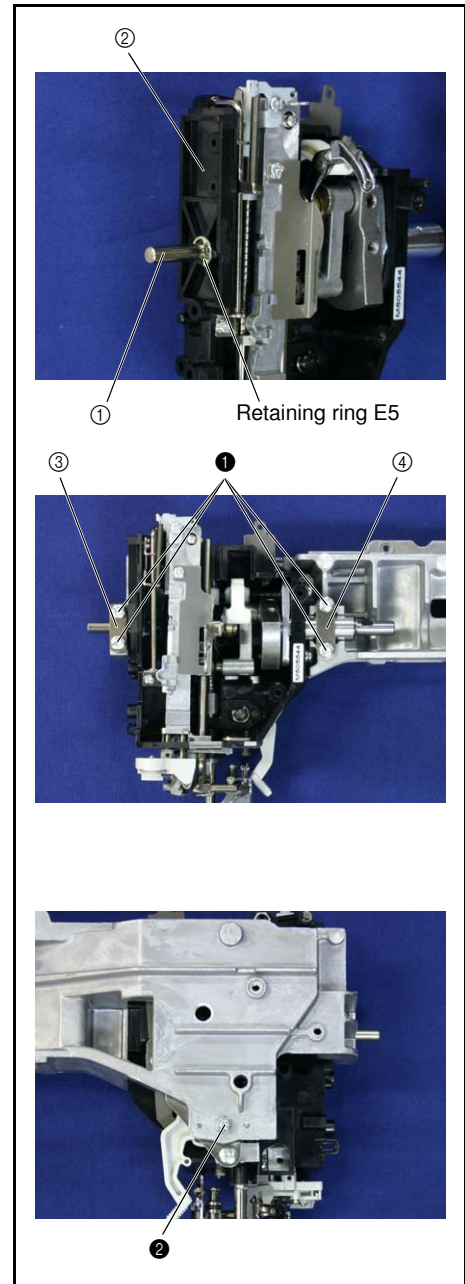
## 2 Needle-presser module attachment

1. Attach the retaining ring E5 to the shaft ①.
2. Insert the shaft ① into the shaft hole on the left side of the needle presser module ②.

### \*Key point

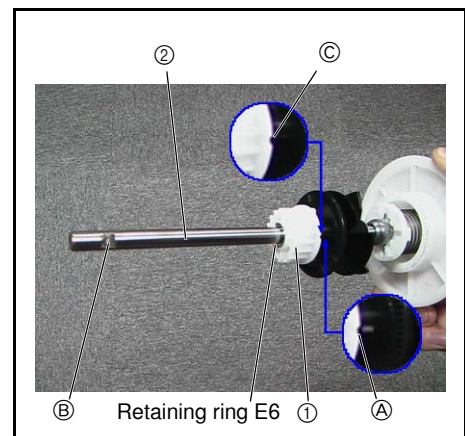
- Insert the shorter end of the shaft ① from the retaining ring (E5) into the shaft hole on the needle presser module ②.
3. Insert the shaft ① into the needle presser module ②, and then attach the presser plate A ③ with the 2 screws ①.
  4. Attach the presser plate B ④ with the 2 screws ①.
  5. Tighten the screw ② temporarily. (Fully tighten the screw after performing 4-11 Needle clearance adjustment.)

①		Taprite, Bind S M4X10	Torque 1.47 – 1.98 N·m
②		Screw, Pan (S/P washer) M3X20A	Torque 0.78 – 1.18 N·m



## 3 Upper shaft pulley attachment

1. Align the base line on the rotation shutter ① (on the same surface as the upper shaft ② D cut) and the base line on the upper shaft pulley ③, and attach the upper shaft pulley ① to the upper shaft assy. ②.
2. Attach retaining ring E6.

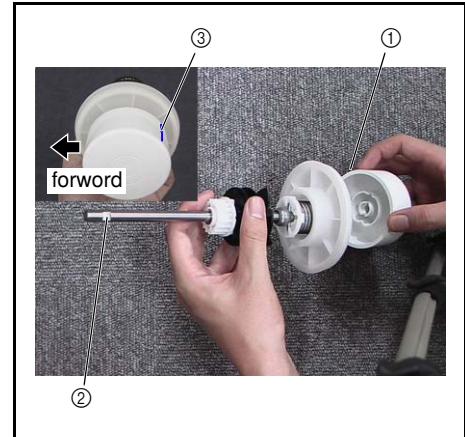


#### 4 Pulley attachment

1. Attach the pulley ① to the upper shaft assy.

**\*Key point**

- When the D cut ② on the upper shaft is facing forward, the pulley base line ③ is on the upper side.



#### 5 Upper shaft assy. attachment

1. Attach the fixed joint ① to the upper shaft.

**\*Key point**

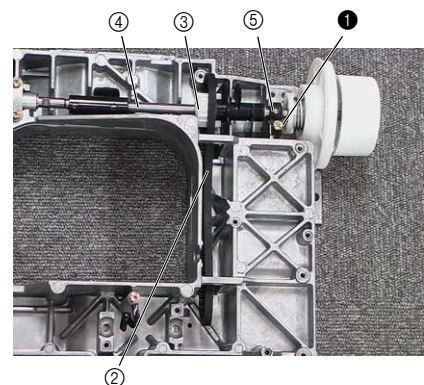
- Attach so that the fixed joint ① screw holes are toward the left side.

2. Place the timing belt ② around the upper shaft pulley ③, and insert the upper shaft assembly ④.
3. Attach the bushing presser ⑤ using the screw ①.

**\*Key point**

- Move the fixed joint ① to the left side of the upper shaft.

Screw holes toward the left side



①		Taprite, Bind S M4X10	Torque 1.47 – 1.98 N·m
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## 6 Connecting the needle-presser module and upper shaft

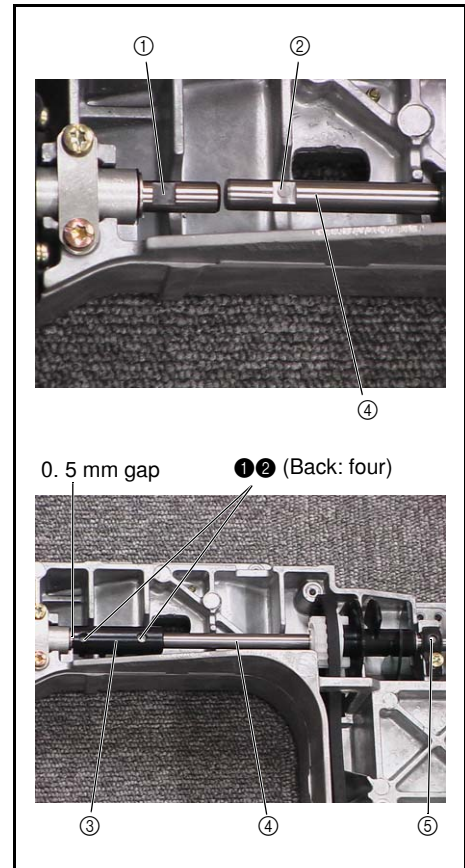
1. Face the unit shaft D cut ① and the upper shaft D cut ② forward.
2. Screw the 2 screws ① into the fixed joint ③.

### \*Key point

- Adjust the gap on the left side of the fixed joint ③ to 0.5 mm.
  - Align the screw holes for the screw ① with the D cuts ① and ②.
3. Rotate the upper shaft ④ 180 degrees, and screw the 4 screws ② into the fixed joint ③.
  4. Tap the lower shaft bushing ⑤ on lightly so that the upper shaft ④ turns easily.


Needle bar and presser unit Assy. and fixed joint gap	0.5 mm
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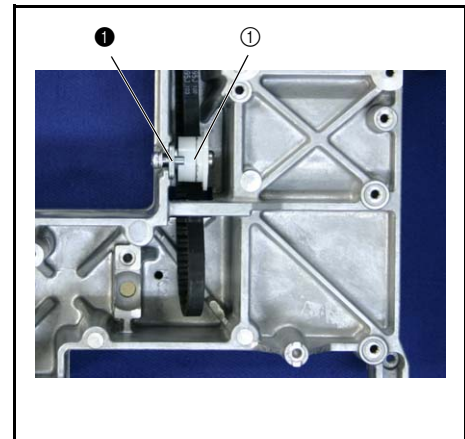
①		Set Screw, Socket (FT) M5X5	Torque 1.37 – 1.79 N·m
②		Set Screw, Socket (CP) M4X4	Torque 0.78 – 1.18 N·m



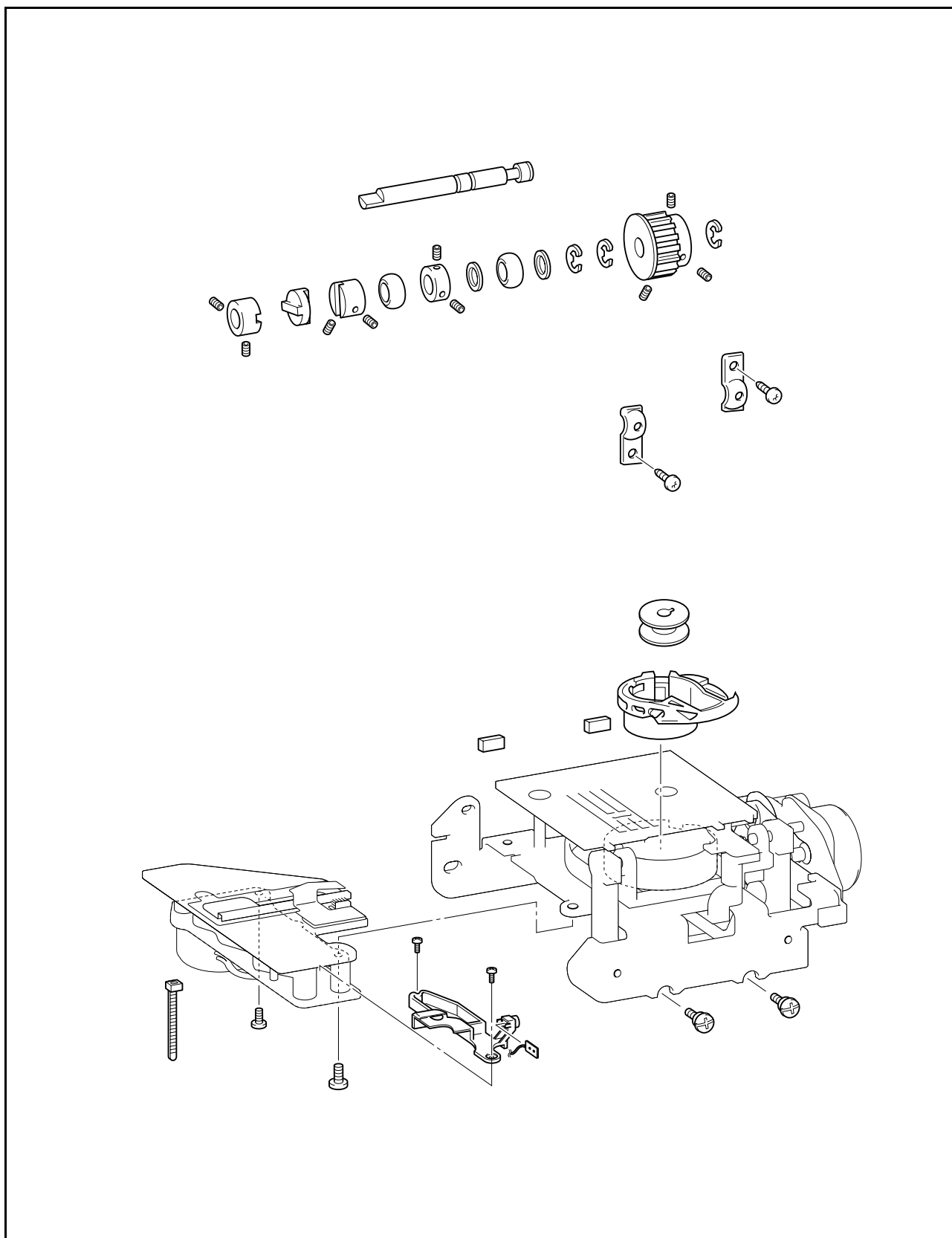
## 7 Tension pulley assembly attachment

1. Hand start the screw the screw ① in the tension pulley ① and attach to the arm bed (fully tighten after 4 - 6 "Timing belt tension.").

①		Screw, Pan (S/P washer) M4X10DA	Torque 1.18 – 1.57 N·m
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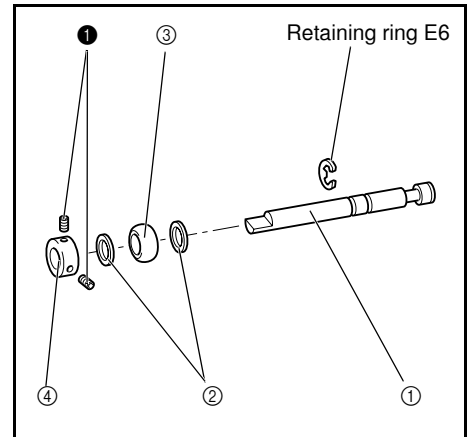
Rotary hook drive mechanism / Feed and bobbin mechanism /Cutter assy.  
mechanism location diagram



### 1 Assembling the Lower shaft A assembly

1. Attach the retaining ring E6 to the lower shaft A ①.
2. Attach the thrust washer ②, lower shaft bushing ③, thrust washer ② and set screw collar ④ (Face the ground surface toward the lower shaft bushing).
3. Move the set screw collar ④ to the right and secure it with the 2 screws ①.

①		Set Screw, Socket (CP) M4X4	Torque 1.47 – 1.98 N·m
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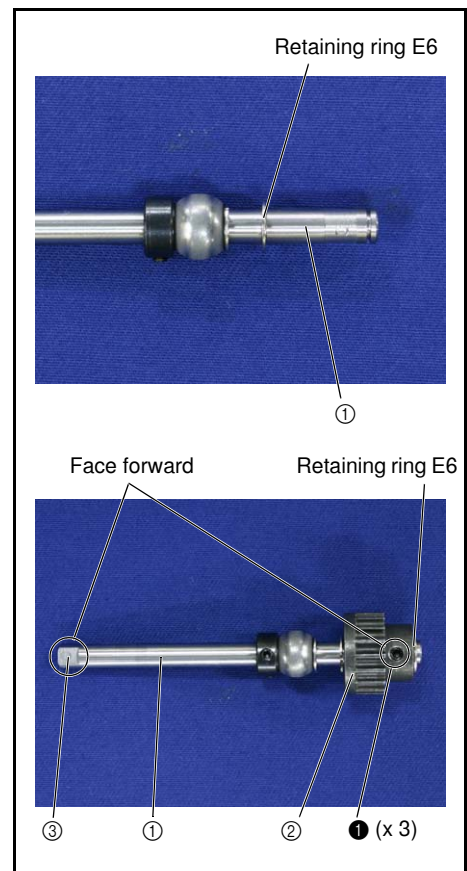
### 2 Timing pulley D attachment

1. Attach the retaining ring E6 to the lower shaft A ①.
2. Attach the timing pulley D ② to the lower shaft A ①, and attach the retaining ring E6.
3. Hand start the 3 screws ① in the timing pulley D ②.  
(Fully tighten after 4 - 11 "Needle bar rising".)

**\*Key point**

- With the lower shaft A D cut ③ facing forward, secure using one of the three screw holes in the timing pulley D ② in the forward facing position.

①		Set Screw, Socket (FT) M5X5	Torque 1.18 – 1.57 N·m
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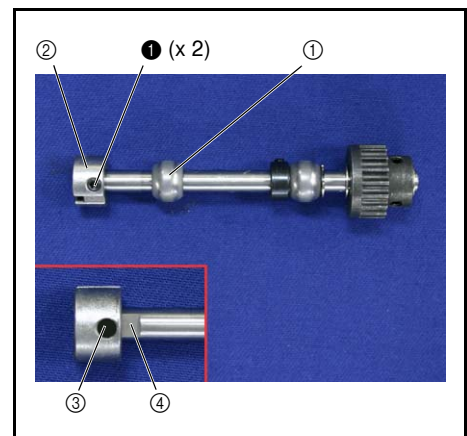
### 3 Joint attachment

1. Put the lower shaft bushing ① on the lower shaft A assy.
2. Put the joint ② on the lower shaft A assy., and hand start the 2 screws ① (fully tighten after 3 - 9 "6 feed module attachment.)

**\*Key point**

- Align the screw hole ③ in the joint with the D cut ④ in lower shaft A.

①		Set Screw, Socket (FT) M5X5	Torque 1.18 – 1.57 N·m
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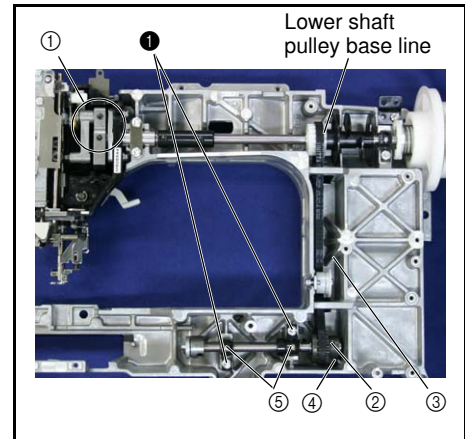
#### 4 Lower shaft A attachment

1. Rotate the lower shaft, and bring the needle bar to its highest point ① (lower shaft pulley base line forward).
2. Insert lower shaft A.

**\*Key point**

- Face the screw hole ② in the joint forward, and attach the timing belt ③ to timing pulley D ④.
3. Attach the 2 bushing pressers ⑤ using the 2 screws ①.

①		Taptite, Bind S M4X10	Torque 1.47 – 1.96 N·m
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#### 5 feed module attachment

1. Rotate the lower shaft, and bring the needle bar to its highest point (lower shaft pulley base line forward).
2. Apply EPNOC AP(N)0 to the disk ①, and attach it to the lower shaft joint.
3. Rotate feed module lower shaft B, and bring the solid dot on the outer rotary hook to the front, directly above the D cut in lower shaft B.
4. Attach the feed module attachment.



**\*Key point**

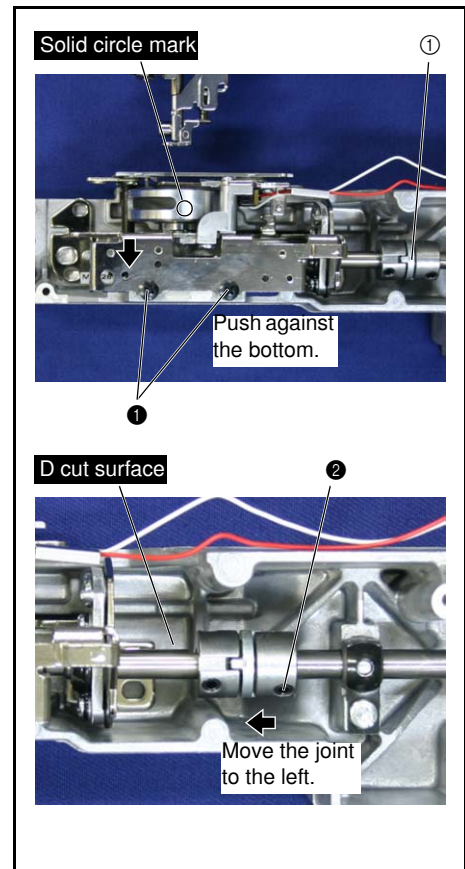
- The needle bar should be at the highest point.
  - The solid circle mark on the outer rotary hook should be forward.
  - (Feed module side) D cut in lower shaft B is directly above
5. Attach the 2 screws ①.

**\*Key point**

- While holding the feed module against the bottom, tighten the screw ① on the left.
6. Move the lower shaft A joint to the left, and fully tighten the 2 screws ②.

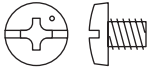
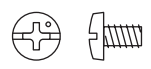
Application of EPNOC AP(N)0 to joint contact area	Small amount XC8387***
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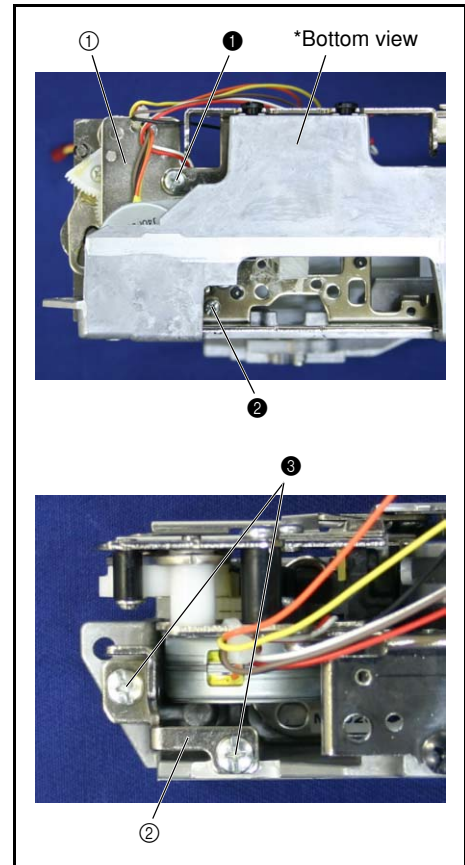
①		Screw M4	Torque 1.18 – 1.57 N·m
②		Set Screw, Socket (FT) M5X5	Torque 1.47 – 1.96 N·m




**6** Thread cutter module attachment

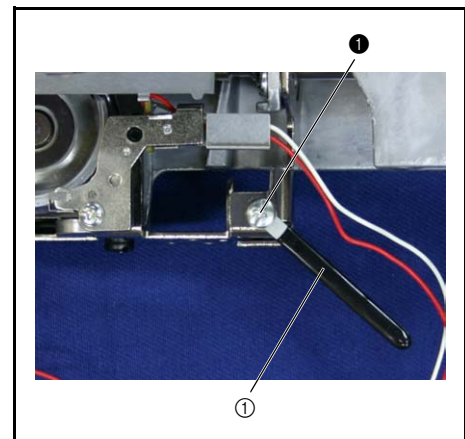
1. Attach the thread cutting module ① with the screws ① and ②.
2. Attach the free arm plate ② with the 2 screws ③.

① ③		Screw, Bind M4X5	Torque 1.18 – 1.57 N·m
②		Screw, Bind M3X5	Torque 0.78 – 1.18 N·m

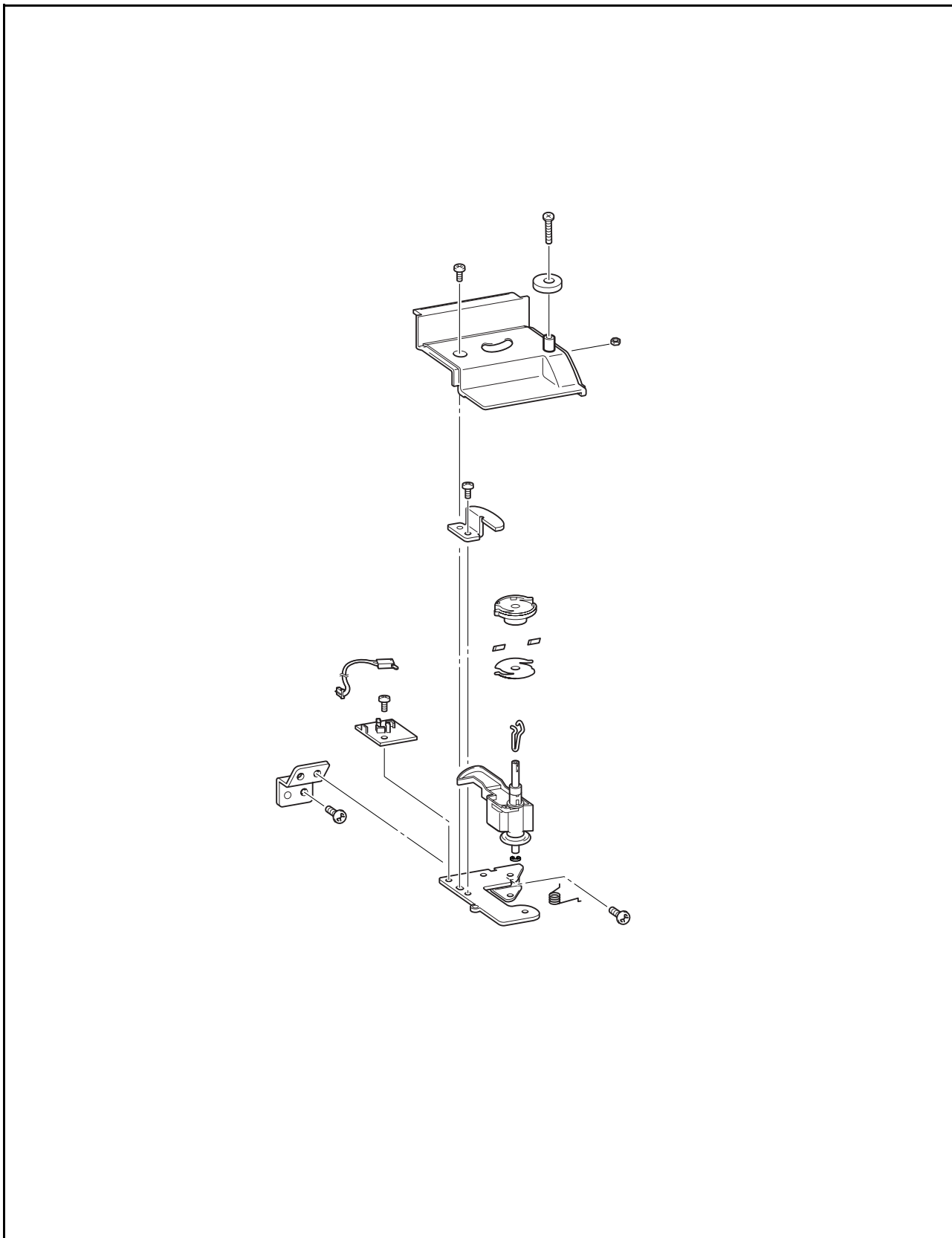
**7** Coating clip attachment

1. Attach the coating clip ① with the screw ①.

①		Screw, Bind M3X4	Torque 0.78 – 1.18 N·m
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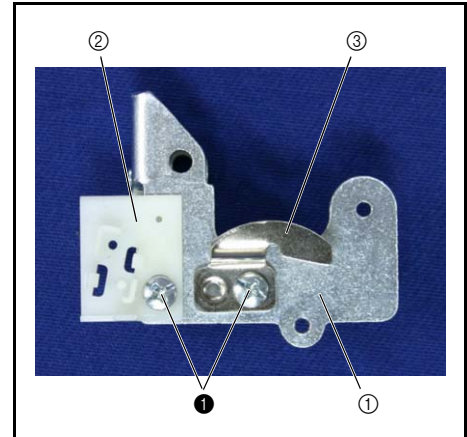
Bobbin winder mechanism location diagram



### 1 Bobbin winder shaft stopper (bobbin winder assembly holder) assembly

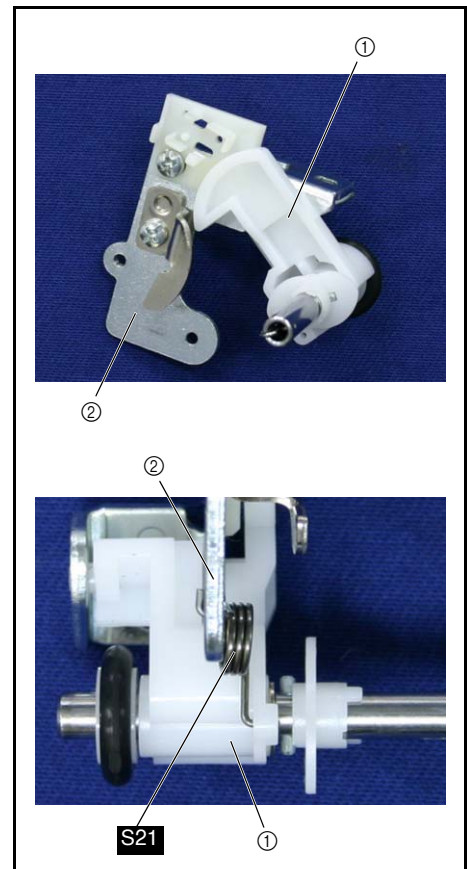
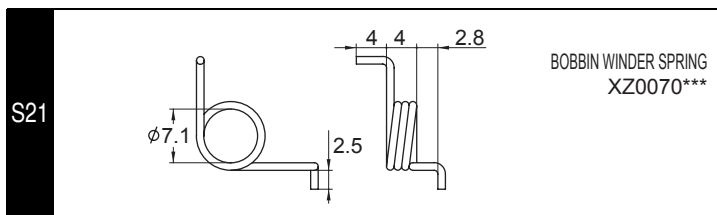
1. Attach the bobbin winder shaft stopper ① and SW adjust plate ② to the bobbin winder assembly holder ③, and hand start the 2 screws ①.  
(Fully tighten after 3 - 13 "5 Bobbin winder holder assembly attachment.")

①		Taprite, Bind B M3X6	Torque Hand tighten
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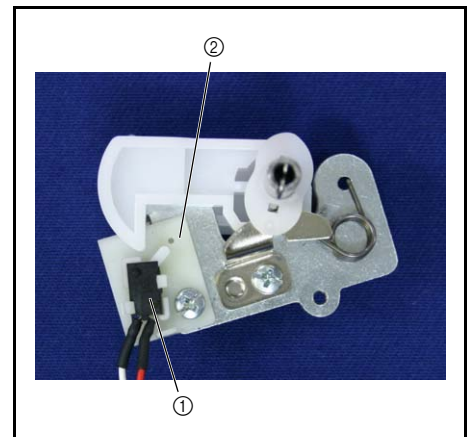
### 2 BW shaft holder assembly attachment

1. Attach the BW shaft holder assembly ① to the bobbin winder assembly holder ②.
2. Attach the spring S21 to the BW shaft holder assembly ① and bobbin winder assembly holder ②.



### 3 BW-F SW assy. attachment

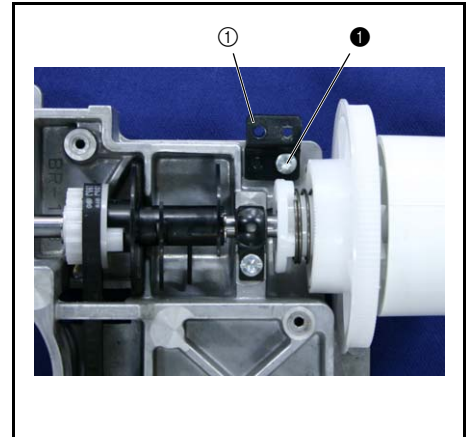
1. Attach the BW-F SW assy ① to the SW adjust plate ②.



#### 4 BW holder supporter attachment


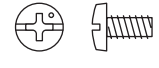
1. Attach the BW holder supporter ① using the screw ❶.

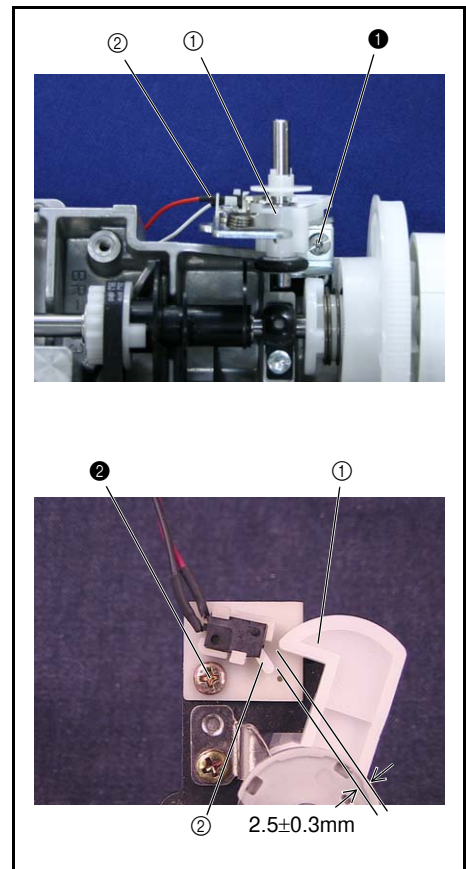
❶		Tapite, Bind S M4X10	Torque 1.18 – 1.57 N·m
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#### 5 Bobbin winder holder assembly attachment

1. Attach the bobbin winder assembly ① using the screw ❶.
2. With the bobbin winder OFF, adjust the SW adjust plate left or right so that the gap between the BW shaft holder assembly ① and the BW-F SW assy ② is  $2.5 \pm 0.3$  mm, and fully tighten the screw ❷.

❶		Screw, Bind M4X8	Torque 1.18 – 1.57 N·m
❷		Screw, Bind M3X6	Torque 0.78 – 1.18 N·m

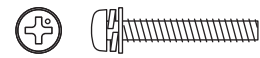


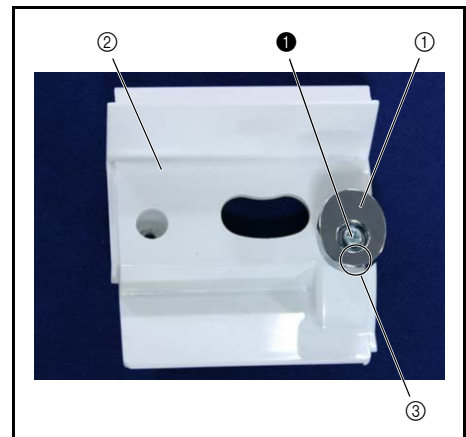
#### 6 Bobbin presser assembly

1. Attach the bobbin presser ① to the bobbin winder cover ② using the screw ❶ and a M3 nut.

##### \*Key point

- Set the side of the bobbin presser ① with the least eccentricity to the near side ③ (see figure to the right).


❶		Screw, Pan (S/P washer) M3X20DA	Torque 1.18 – 1.57 N·m
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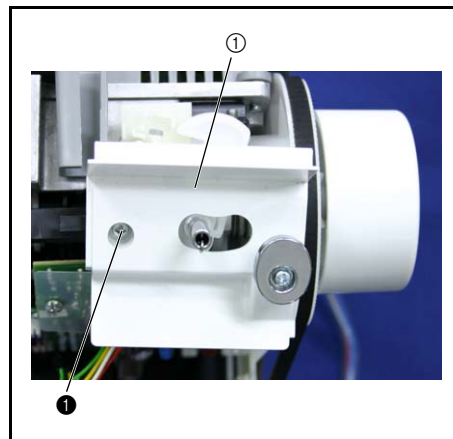




## 7 Bobbin winder cover attachment

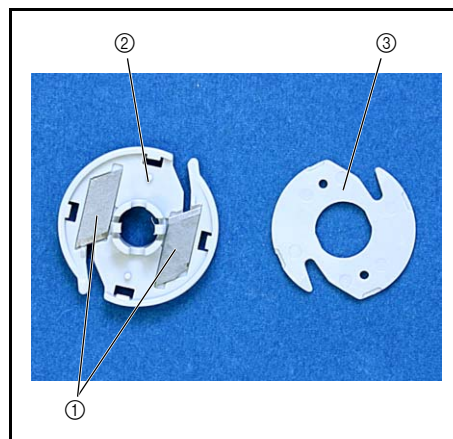
1. Attach the bobbin winder cover ① using the screw ②.

①		Screw, Bind M3X6	Torque 0.78 – 1.18 N·m
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## 8 Bobbin base assembly

1. Attach the 2 NT lower thread cutters ① and the bobbin thread cutter holder ② to the bobbin base ③.

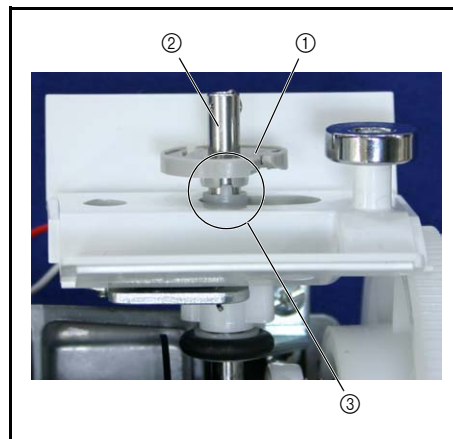


## 9 Bobbin base attachment

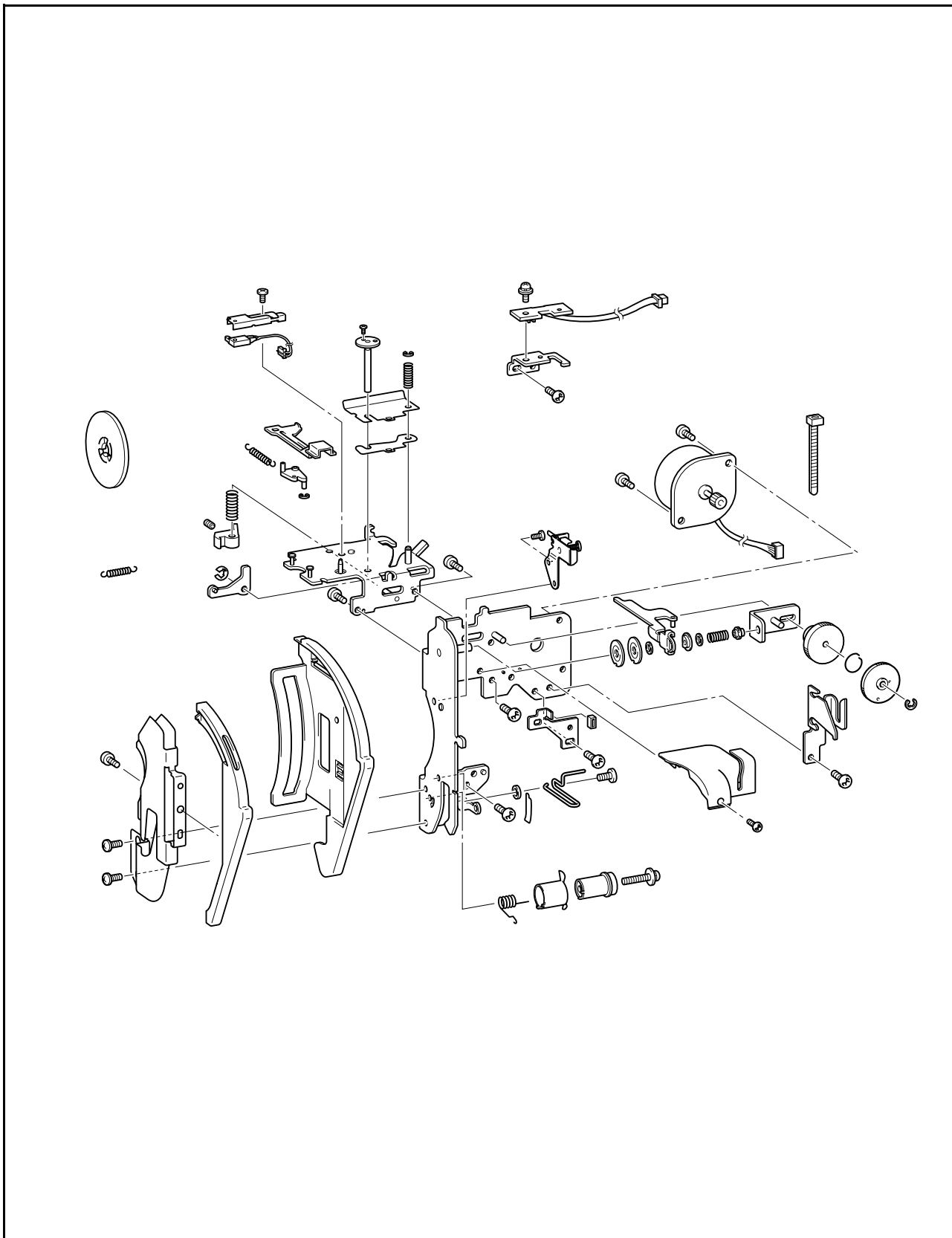
1. Attach the bobbin base ① to the bobbin winder shaft ②.

**\*Key point**

- Attach the bobbin base ① to position ③.



### Thread tension mechanism location diagram

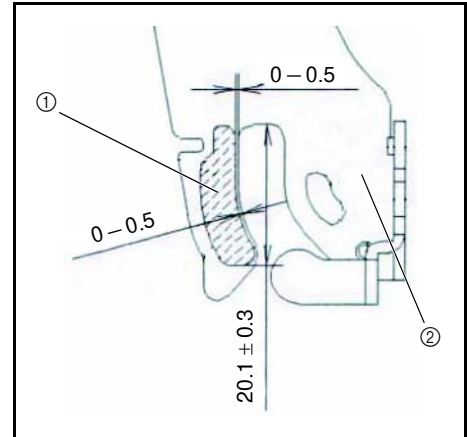


## 1 Spring tape attachment

1. Attach the spring tape ① to the thread guard assembly ②.

**\*Key point**

- See the figure to the right for positioning.



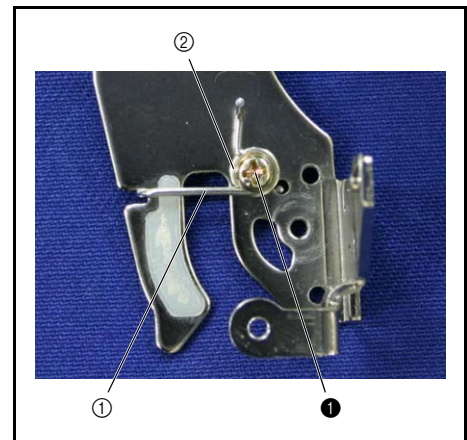
## 2 Thread guide wire attachment

1. Attach the thread guide wire ① and the washer ② using the screw ①.

**\*Key point**

- While holding the thread guide wire ① up, tighten the screw ①.

①		Screw, Pan (S/P washer) M3X6	Torque 0.78 – 1.18 N·m
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### 3 Thread take up spring attachment

1. Attach the spring **S11** to the thread catching spring case ①.

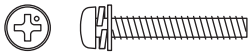

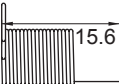
**\*Key point**

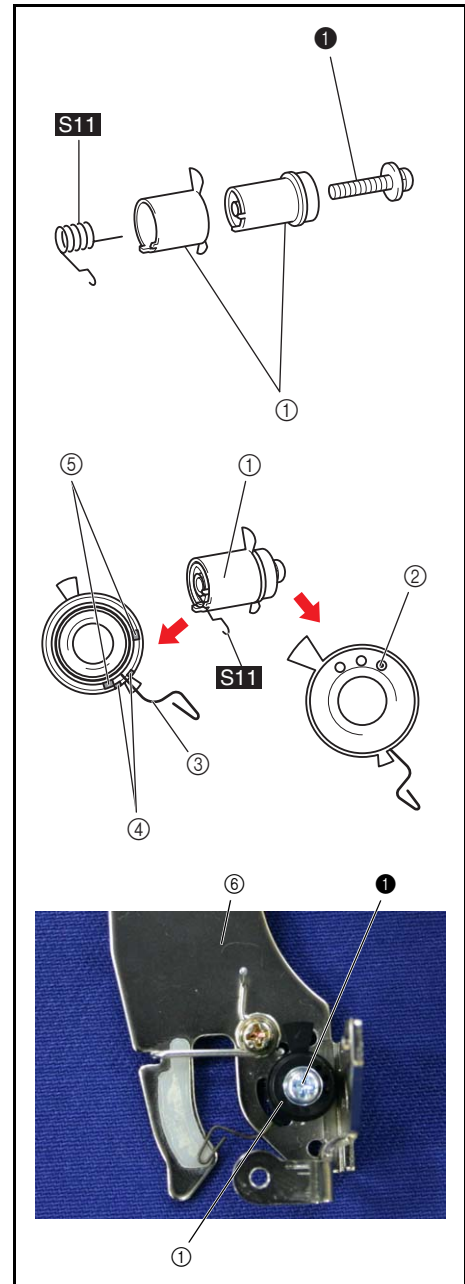
- Insert the tip ② of the spring **S11** into the right-most hole of the three spring tension positioning holes.
- Insert the bent end ③ of the spring **S11** between the two tabs ④ of the thread catching spring case, and then engage it with the spring groove ⑤.

2. Attach the thread catching spring case ① to the thread guard assembly ⑥ using the screw ①.

**\*Key point**

- Align the protrusions ⑤ (two) on the bottom of the thread catching spring case ① with the oval hole in the thread guard assembly ④, and turn clockwise to the end of the hole to attach.

①		Screw, Pan (SIP washer) M3X18DA	Torque 0.78 – 1.18 N·m
S11			THREAD TAKE UP SPRING XZ0145***

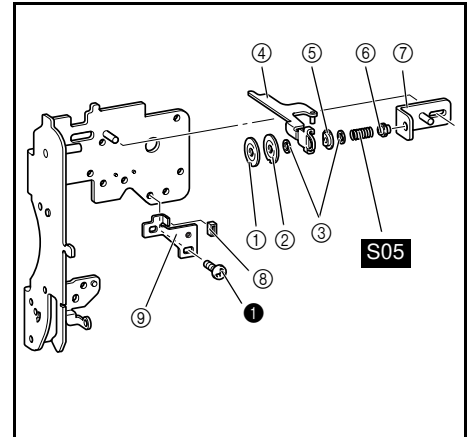



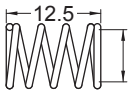
#### 4 Tension disk attachment

1. Attach the tension disc A ①, tension disc B ②, washer ③, thread tension plate A ④, the tension disc washer ⑤, washer ③, spring **S05** and tension adjusting screw ⑥ to the thread tension disk shaft.
2. Attach the tension plate assy ⑦ to the thread tension gear shaft, and screw the tension adjusting screw ⑥ into the tension plate assy.

**\*Key point**

- The tension adjusting screw ⑥ should be screwed in so that the tip protrudes approximately 0.5 mm from the right of the tension plate assy. ⑦.
3. Attach the rubber ⑧ to the initial adjusting plate ⑨.
  4. Install the screw ① into the initial adjusting plate ⑨.

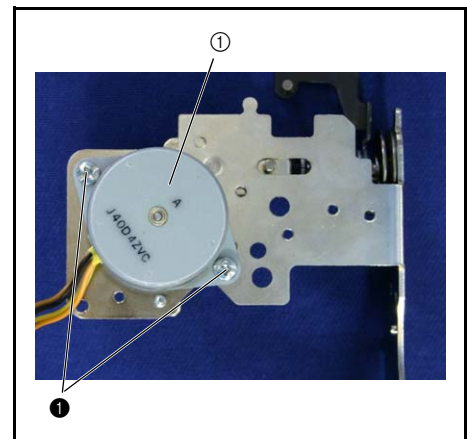


①		Screw, Bind M3X4	Torque 0.78 – 1.18 N·m
S05			THREAD TENSION SPRING XA9900***

#### 5 AT pulse motor attachment

1. Attach the AT pulse motor ① using the 2 screws ①.

①		Screw, Bind M3X4	Torque 0.78 – 1.18 N·m
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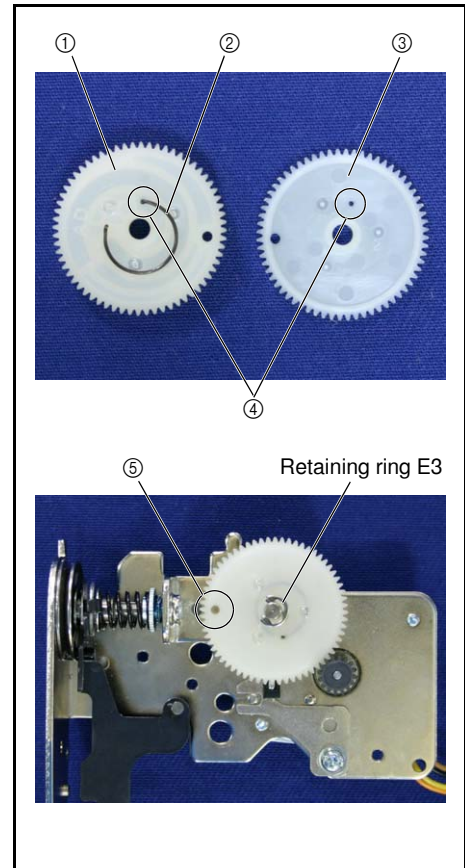


## 6 Thread tension gear attachment

1. Attach the thread tension gear ①, spring ② and thread tension gear cover ③ and attach the retaining washer E3.

### \*Key point

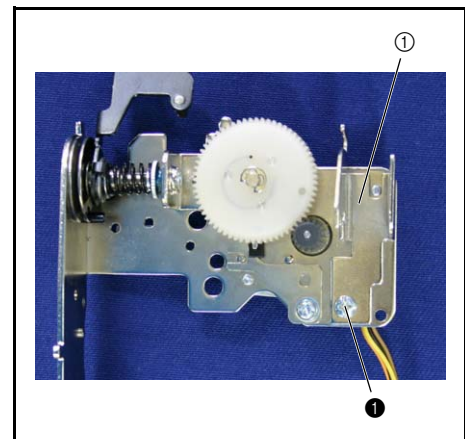
- Attach the spring ② to the small holes ④ in the thread tension gear ① and the thread tension gear cover ③.
- Turn the thread tension gear cover ③ clockwise until the large holes ⑤ in the thread tension gear ① and the thread tension gear cover ③ are on top of each other, and attach the thread tension gear assembly.



## 7 Thread guide attachment

1. Attach the thread guide ① using the screw ①.

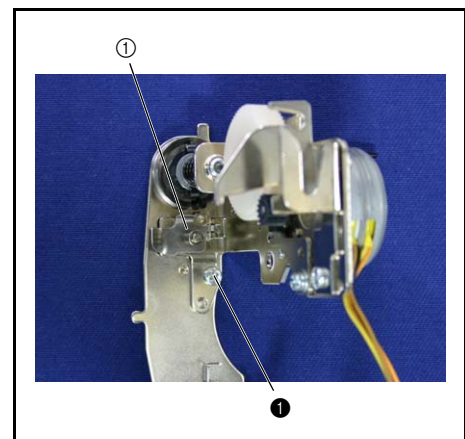
①		Screw, Bind M3X4	Torque 0.78 – 1.18 N·m
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## 8 Plate assembly attachment

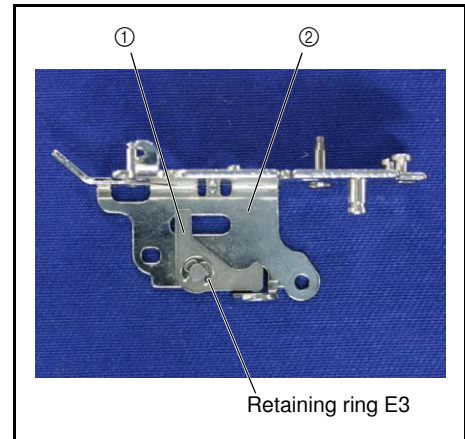
1. Attach the plate assembly ① using the screw ①.

①		Screw, Bind M3X4	Torque 0.78 – 1.18 N·m
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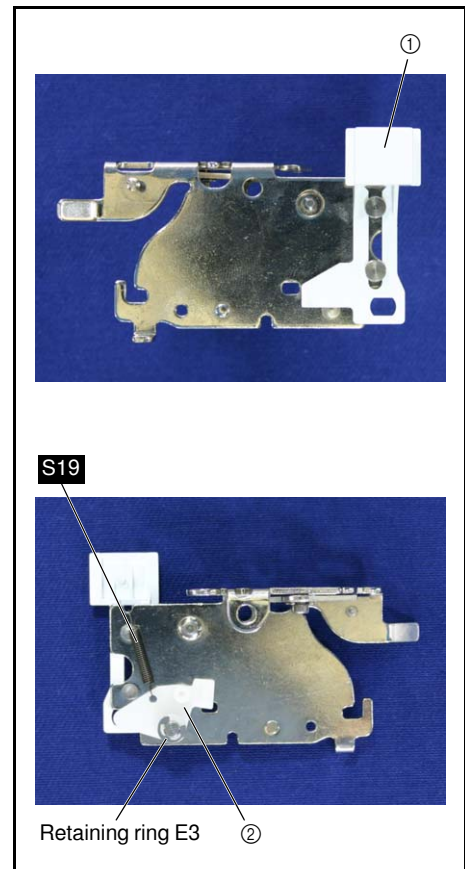
## 9 Tension releaser link attachment

1. Attach the tension releaser link ① to the thread release holder assy ②, and the attach retaining ring E3.

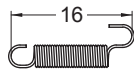


## 10 Thread guide shutter assembly

1. Attach the thread guide shutter ① to the tension release holder assy.
2. Attach the thread guide shutter link ② to the tension release holder assy, and the attach the retaining ring E3.
3. Attach the spring S19 to the thread guide shutter link ② and the tension release holder assy.



S19



SPRING  
XC2650\*\*\*

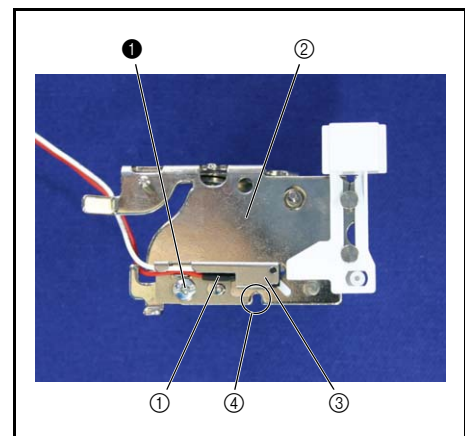
## 11 PF-F SW assy. assembly

1. Attach the PF-F SW assy ① and the presser switch holder ③ to the thread release holder assy ② using the screw ①.

### \*Key point

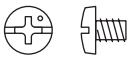
- Align the edge ④ of the thread release holder assy ② and the presser switch holder ③.

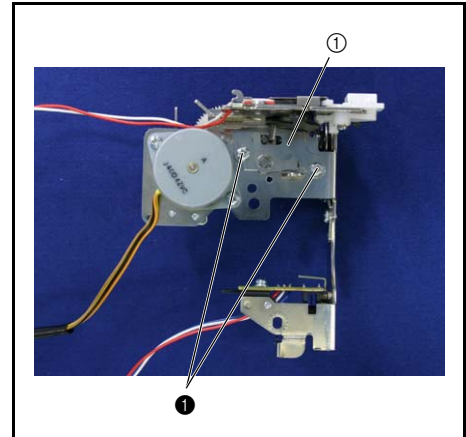
①		Screw, Bind M3X4	Torque 0.78 – 1.18 N·m
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## 12 Thread release holder assy. attachment

1. Attach the tension release holder assy ① to the thread guard assembly using the 2 screws ❶.

❶		Screw, Bind M3X4	Torque 0.78 – 1.18 N·m
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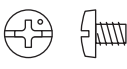


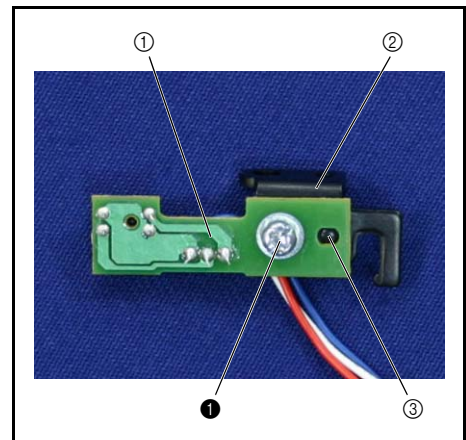
## 13 Upper thread PCB unit assembly

1. Attach the upper thread PCB assembly ① to the thread sensor holder ② with the screw ❶.

### \*Key point

- Align the positioning tab on the thread sensor holder ② with the center of the oval positioning hole ③ on the upper thread PCB assembly ①.

❶		Screw, Bind M3X4	Torque 0.78 – 1.18 N·m
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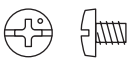


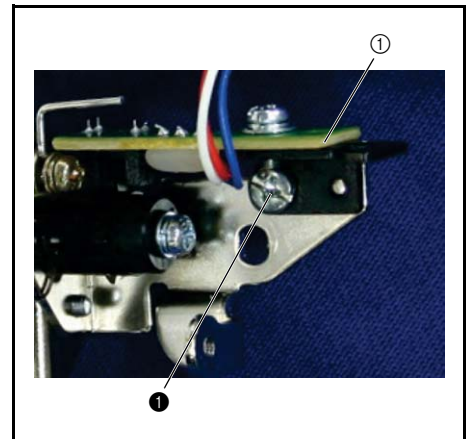
## 14 Upper thread PCB unit attachment

1. Attach the upper thread PCB unit ① to the thread guide assembly with the screw ❶.

### \*Key point

- Engage the positioning tab on the thread guide assembly with the positioning hole on the upper thread PCB unit ①.
- Check that the thread cutting shutter is positioned at the center relative to the sensor of the upper thread PCB unit ①.




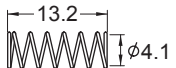
❶		Screw, Bind M3X4	Torque 0.78 – 1.18 N·m
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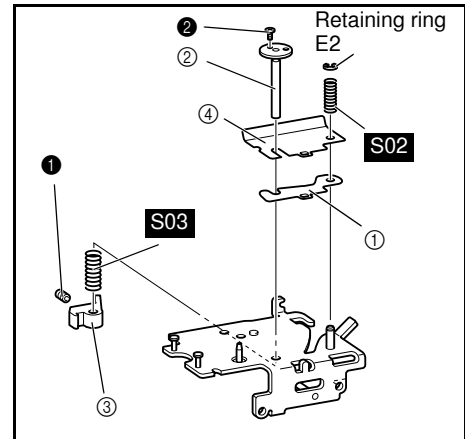




## 15 Tension plate attachment

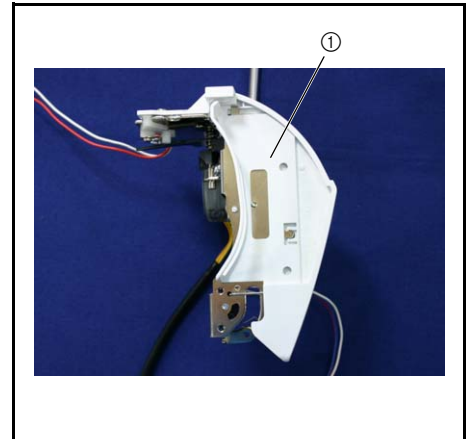
1. Attach the spacer ① to the tension release holder assy.
2. Attach the tension pressure assy ②, the spring **S02** and tension release cam ③.
3. Attach the tension plate ④.
4. Install the screw ① in the tension release cam ③.
5. Hand start the screw ② in the tension pressure assy. ② (after assembly, perform 4 - 8 "Fine tension").
6. Attach the spring **S03** to the tension release holder assy shaft, and attach the retaining washer E2.

①		Set Screw, Socket (FT) M3X4	Torque 0.78 – 1.18 N·m
②		Power Lock 2X3	Amount screw should be tightened Screw head should protrude 0.2 - 5.0 mm
S02			SPRING X57605***
S03			SPRING XA9577***



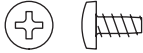

## 16 Thread guide cover attachment

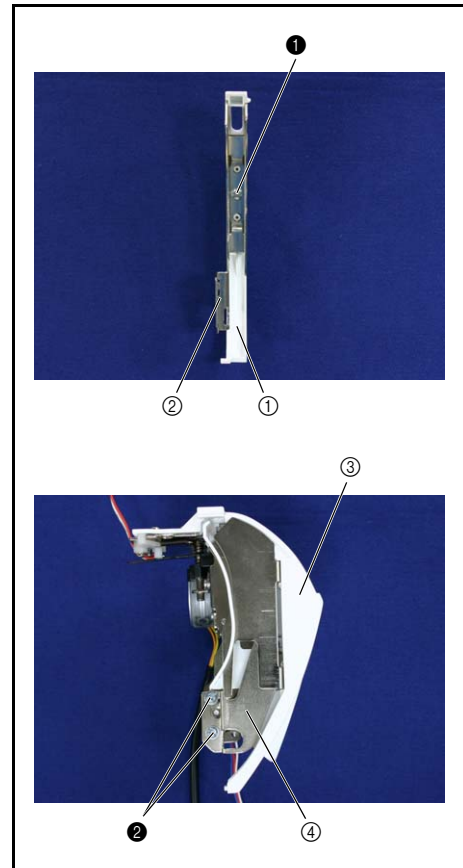
1. Attach the thread guide cover ① to the thread guard assembly.



## 17 Thread guide cover assembly

1. Attach the thread guide cover ① to the thread guide assy ② using the screw ①.
2. Attach the thread guide cover assembly ③ to the thread guard assembly ④ using the 2 screws ②.

①		Tapite, Bind B M3X6	Torque 0.78 – 1.18 N·m
②		Screw, Pan (S/P washer) M3X6	Torque 0.78 – 1.18 N·m





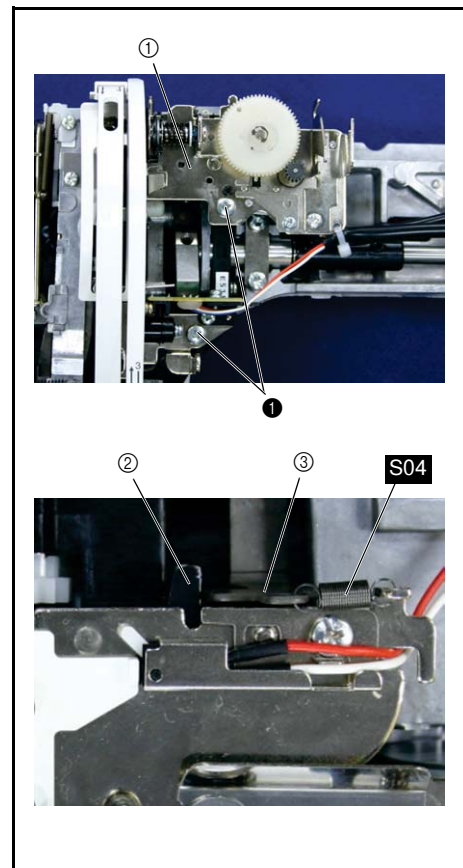
## 18 Thread tension assy. attachment

1. Attach the thread tension assy ① using the 2 screws ①.

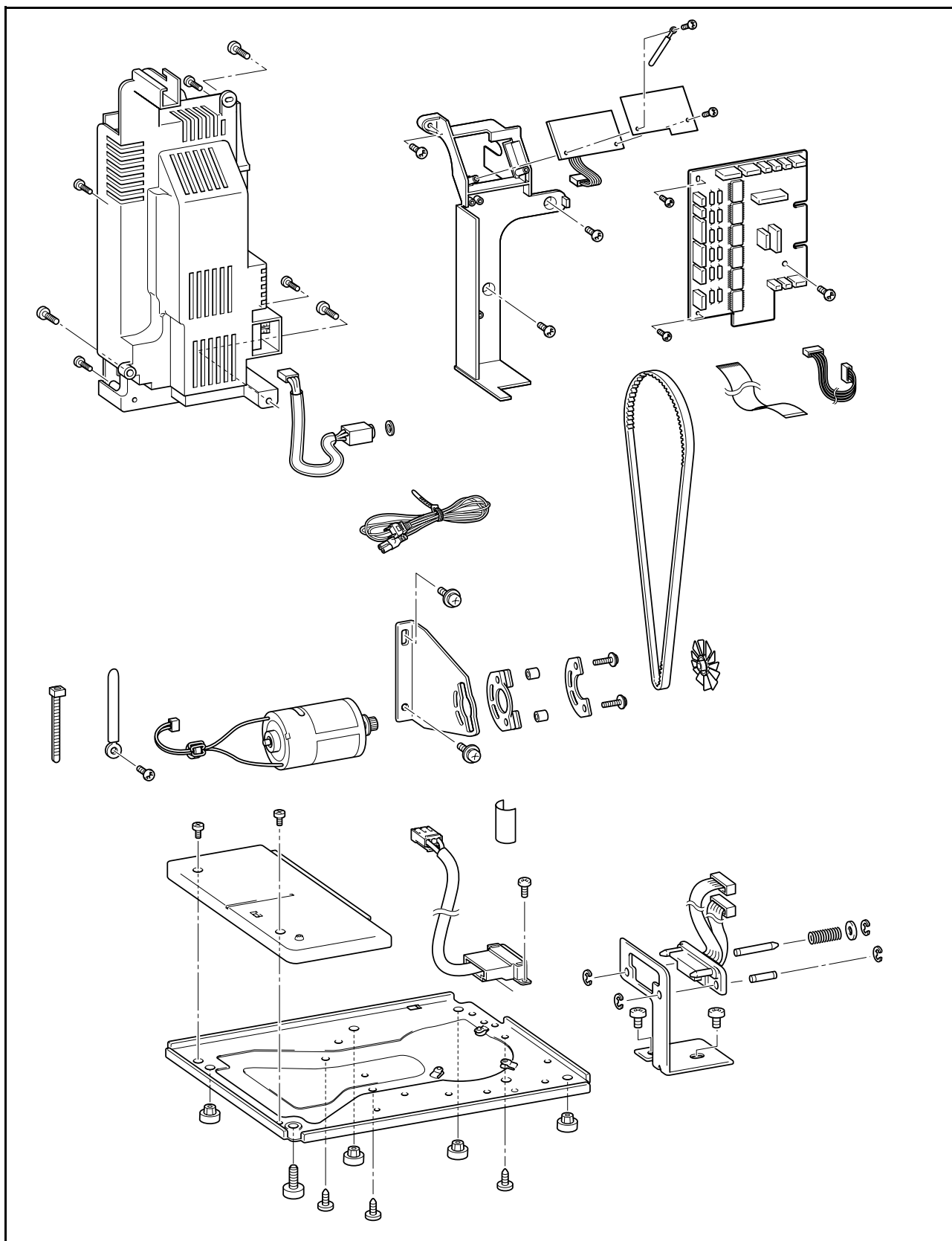
### \*Key point

- For the position of the thread release lever assy A ②, see the diagram to the right.
2. Attach the spring S04 to the tension release holder shaft and tension release plate C ③ on the needle-presser module.

①		Tapite, Bind B M4X10	Torque 1.18 – 1.57 N·m
S04			SPRING XA9787***

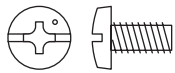


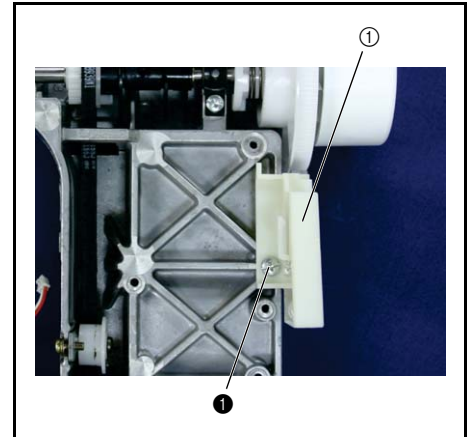
Electrical parts and motors location diagram



## 1 Belt guard attachment

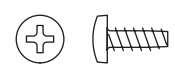

1. Attach the belt guard ① to the arm bed with the screw ①.

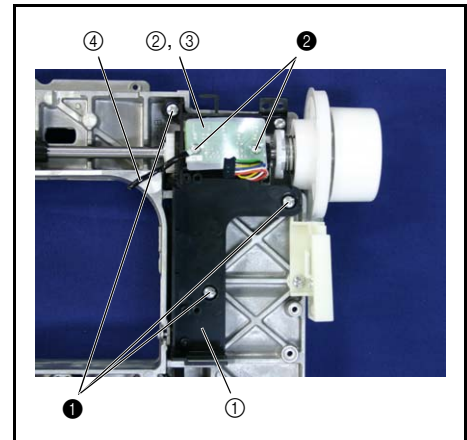
①		Screw, Bind M4X8	Torque 0.78 – 1.18 N·m
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## 2 NP PCB Assy. attachment


1. Attach the PCB holder ① to the arm bed using the 3 screws ①.
2. Attach NP PCB Assy ②, the insulation sheet ③ and the coating clip ④ to the PCB holder ① using the 2 screws ②.

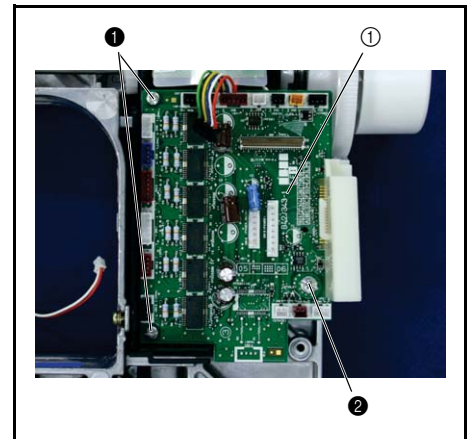
①		Tapite, Bind B M3X8	Torque 0.59 – 0.78 N·m
②		Screw, Bind M4X8	Torque 0.78 – 1.18 N·m



## 3 Motor PCB Assy. attachment


1. Attach the motor PCB Assy ① to the PCB holder and arm bed using the 2 screws ① and the screw ②.

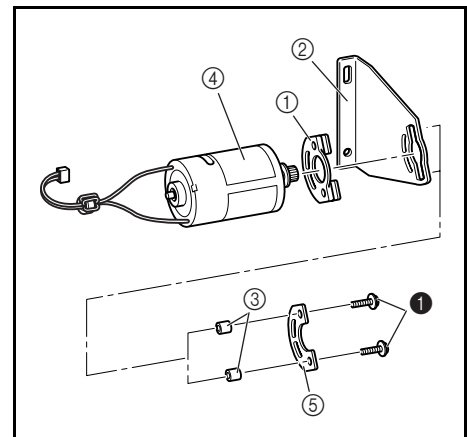
①		Tapite, Bind B M3X8	Torque 0.59 – 0.78 N·m
②		Screw, Bind M4X8	Torque 0.78 – 1.18 N·m



## 4 Assembly of main motor assembly

1. Attach the fender rubber ① to the motor holder ②.
2. Engage the 2 spacers (4 x 6) ③ with the 2 round holes on the fender rubber ①.
3. Attach the main motor ④ and the motor spacer presser ⑤ to the motor holder ② with the 2 screws ①.

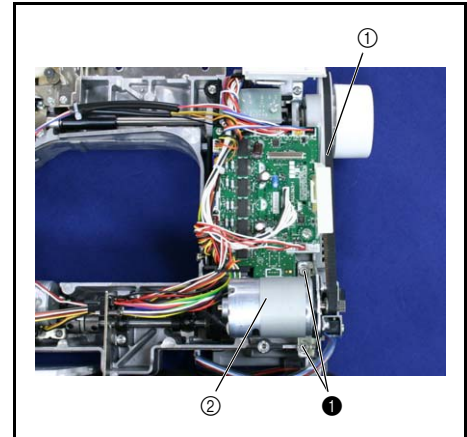
①		Screw, Pan (S/P washer) M4X14	Torque 1.18 – 1.57 N·m
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## 5 Main motor assembly attachment

1. Attach the timing belt ① to the upper shaft timing pulley and the motor pulley, align the main motor assembly ② with the arm bed and hand start the 2 screws ①.  
(Fully tighten after 4 - 7 "Motor belt tension").

①		Upset 4X12DB	Torque Hand tighten
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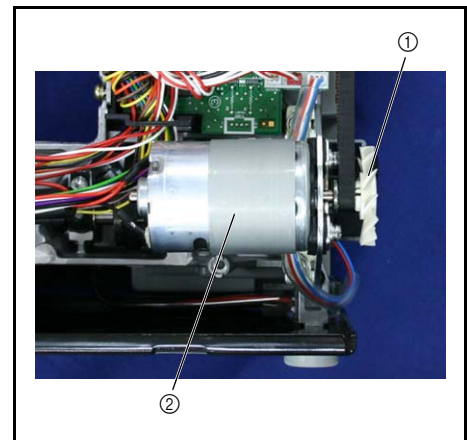


## 6 Motor fan attachment

1. Attach the motor fan ① to the main motor assembly ②.

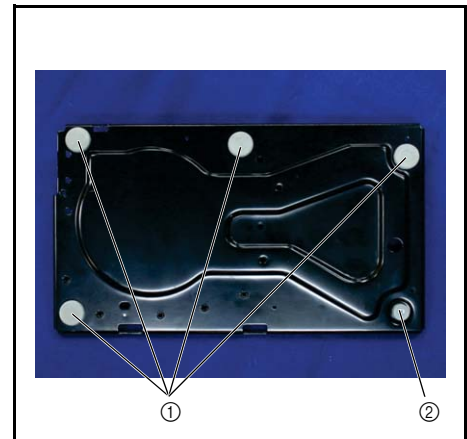
### \*Key point

- Be careful removing the motor fan ① because the wings of the fan are very fragile.



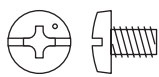

## 7 Base plate rubber attachment

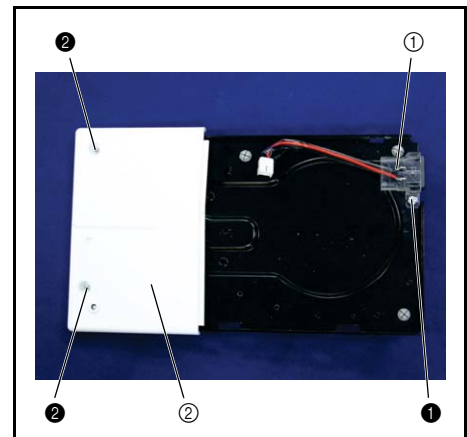
1. Attach the 4 base plate rubbers ① to the base plate.
2. Attach the adjusting screw assembly ②.



## 8 Inlet assy. and base plate cover attachment


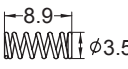
1. Attach the inlet assy ① to the base plate using the screws the screw ①.
2. Attach the base plate cover ② to the base plate with the 2 screws ②.

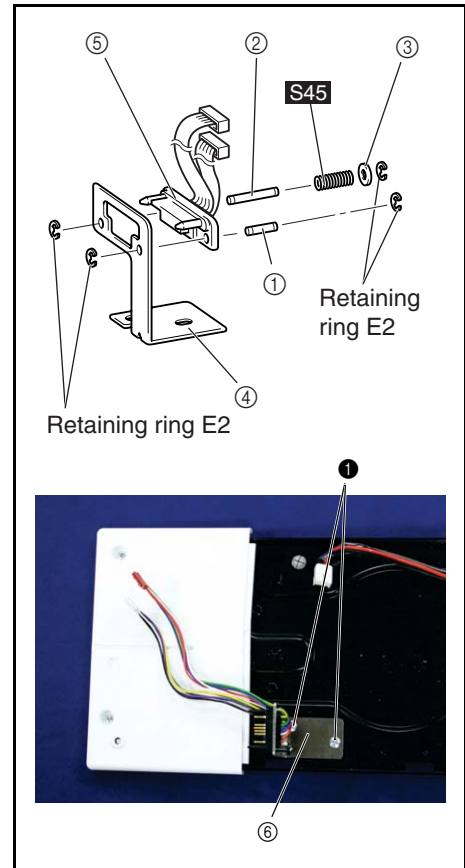
①		Screw, Bind M4X6	Torque 1.18 – 1.57 N·m
②		Screw, Bind M3X5	Torque 0.78 – 1.18 N·m



## 9 Connector holder ASSY assembly and attachment

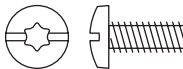
1. Attach the retaining ring (E2) to ES pin F-A ①.
2. Attach the retaining ring (E2) to the sharper end of ES pin F-B ②, and then insert the feed bar spacer ③ and the spring S45.
3. Attach the lead wire assembly ⑤ to the connector holder ④.
4. Insert ES pin F-A ① into the lead wire assembly ⑤, and then attach the retaining ring (E2).
5. Insert ES pin F-B ② into the lead wire assembly ⑤, and then attach the retaining ring (E2).
6. Attach the connector holder assembly ⑥ to the base plate with the 2 screws ①.

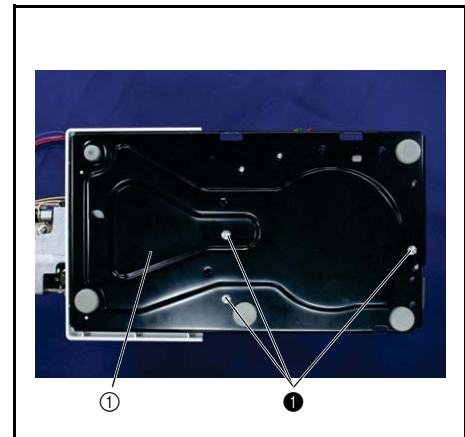
①		Screw, Bind M4X6	Torque 1.47 – 1.96 N·m
S45		SPRING XD0967***	



## 10 Base plate attachment


1. Attach the base plate assembly ① to the arm bed using the 3 screws ①.

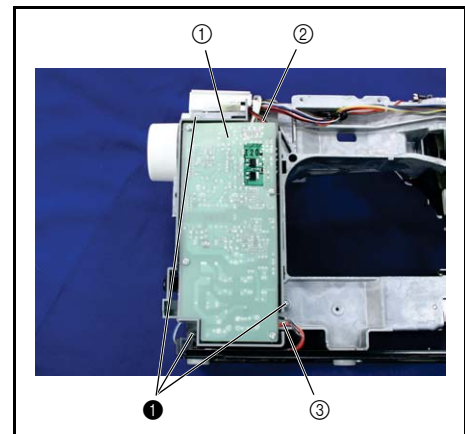
①		Taprite, Bind S M4X10	Torque 1.47 – 1.96 N·m
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## 11 Power supply unit F attachment

1. Attach the power supply unit ① to the arm bed with the 3 screws ①.
2. Connect the inlet assembly lead wirefs connector ② to the power supply unit.
3. Connect the main motor assemblyfs connector ③ to the power supply unit.

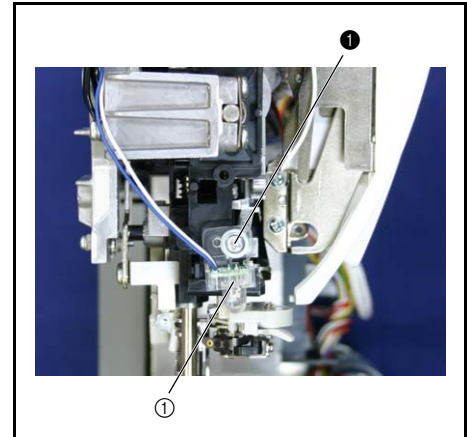
①		Screw, Pan (S/P washer) M4X14	Torque 0.78 – 1.18 N·m
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## 12 PBC unit LED lamp-FL attachment

1. Attach the PBC unit LED lamp-FL ① to the needle-presser module using the screw ❶.

❶		Tapite, Pan B M4X12	Torque 0.78 – 1.18 N·m
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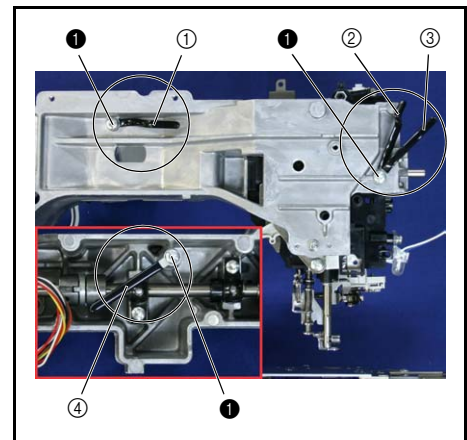
## 13 Wire clip attachment

1. Attach the 4 coating clips ① to ④ with the 3 screws ❶.

**\*Key point**

- Secure coating clips ② and ③ with one screw ❶.

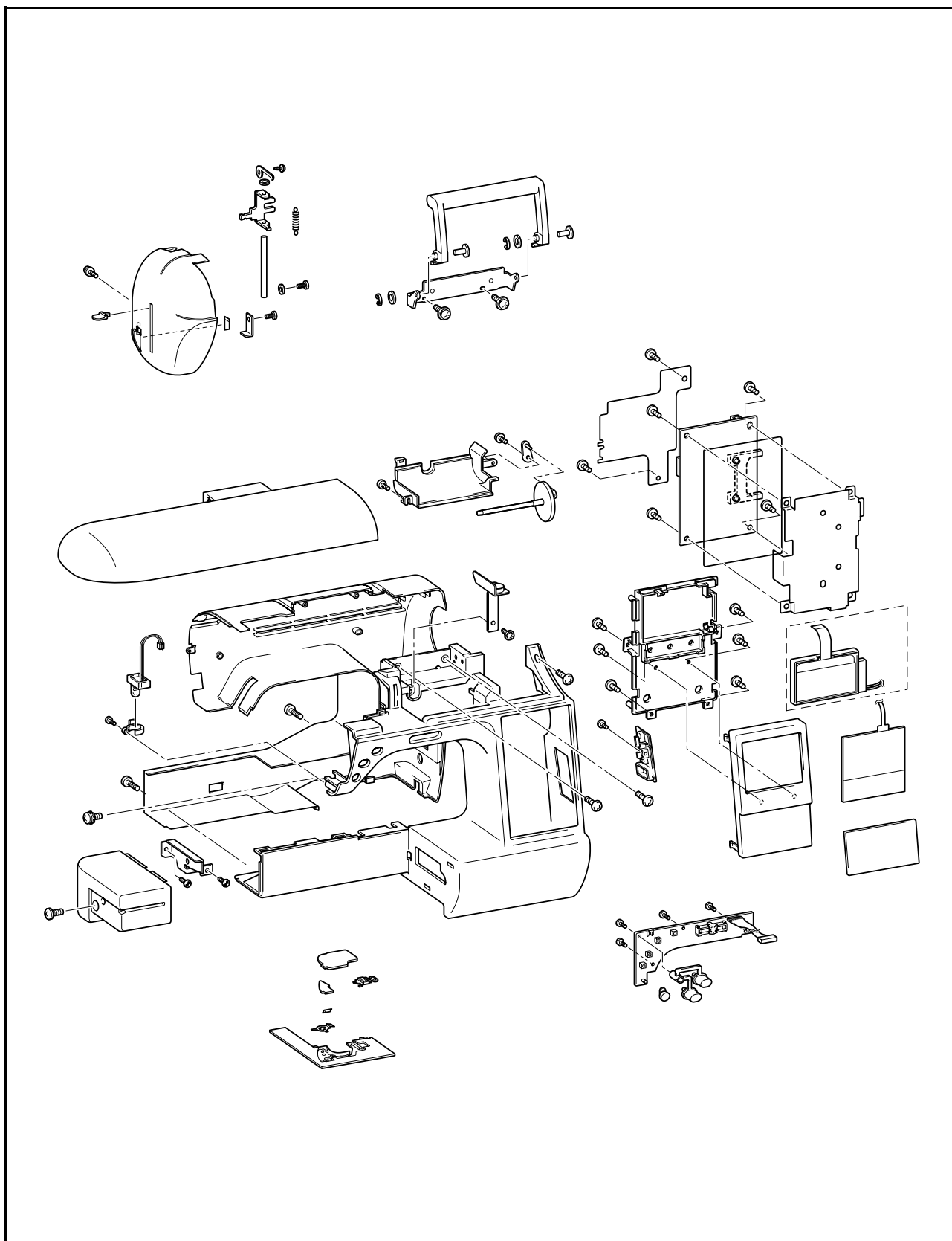
❶		Tapite, Bind S M4X10	Torque 1.47 – 1.98 N·m
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## 14 Cord treatment

1. Refer to Chapter 7 [Special Instructions of Wiring] for cord treatment of each section.


Main parts location diagram

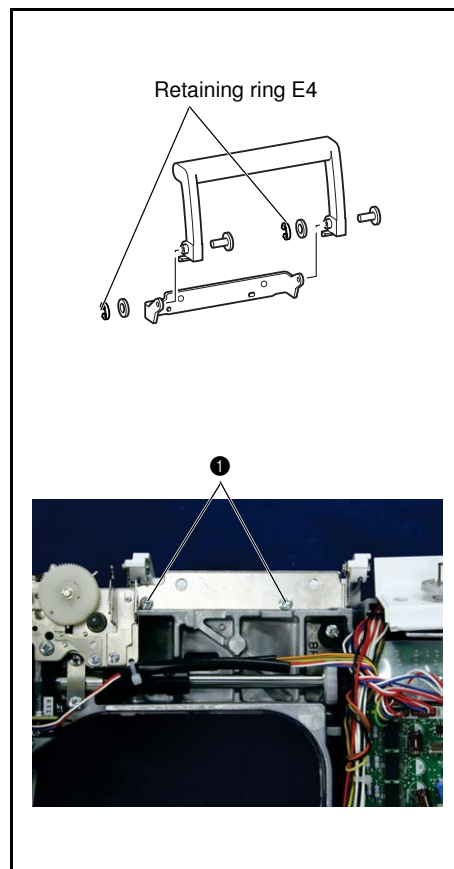




## 1 Handle assembly and attachment

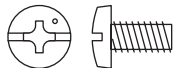
1. Attach the handle, handle holder and polyester slider to the handle shafts, and attach 2 retaining rings E4.
2. Attach the handle to the arm bed using the 2 screws ①.

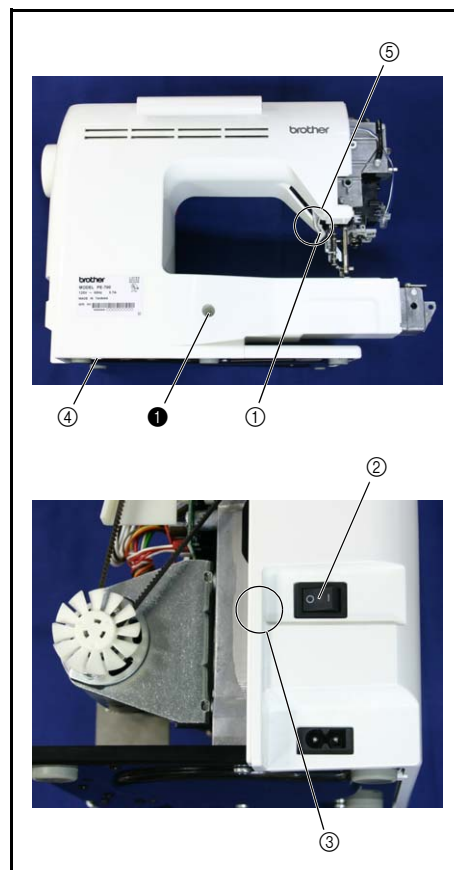
①		Taptite, Bind S M4X10	Torque 1.47 – 1.96 N·m
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## 2 Rear cover attachment

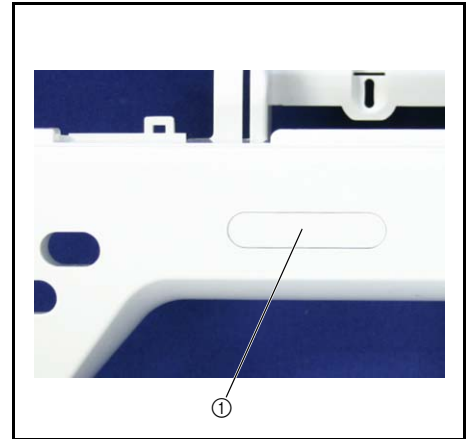
1. Lower the presser lever ①.
2. Attach the rear cover, being careful to avoid the switch ② being caught in section ③, and then attach the hook ④ to the base plate.
3. Attach the rear cover, being careful to avoid the presser lever ① being caught in section ⑤.
4. Secure the rear cover to the arm bed with the screw ①.

①		Screw, Bind M4X8	Torque 0.78 – 1.18 N·m
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### 3 Front cover assembly (SV cover attachment)

1. Attach the SV cover ①.



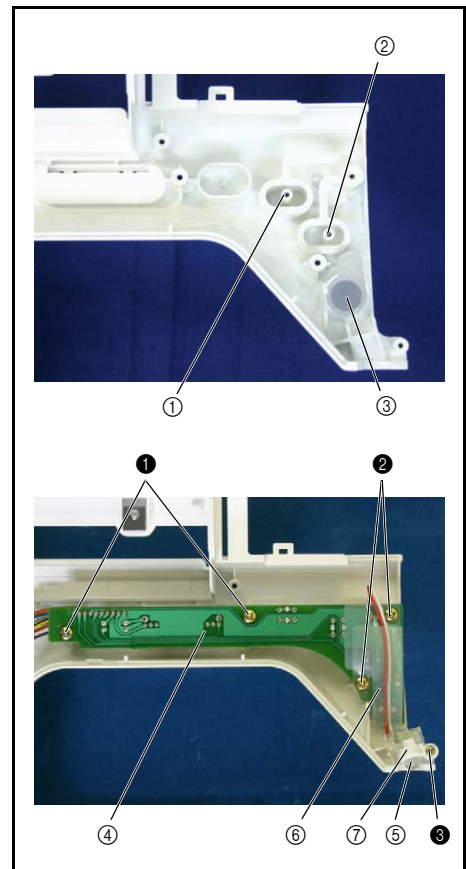
### 4 Front cover assembly (SS-VR F PCB assy. attachment)

1. Attach the thread cut button ①, reverse button ②, and SS button ③.
2. Attach the SS-VR PCB assembly ④ to the front cover with the 2 screws ①.

**\*Key point**

- Align VR1 on the SS-VR PCB assembly with the SV joint plate.

3. Connect the connector of the PCB unit LED lamp (FR) ⑤ to the SS-VR PCB assembly ④.
4. Cover the cord of the PCB unit LED lamp (FR) ⑤ with the insulation sheet ⑥. Secure the SS-VR PCB assembly ④ and the SS-VR insulation sheet ⑥ with the 2 screws ②, and then attach these to the front cover.
5. Pass the lamp of the PCB unit LED lamp (FR) ⑤ through the lamp holder support ⑦, and then attach the lamp holder support ⑦ to the front cover with the screw ③.





①		Tapite, Bind B M3X8	Torque 0.57 – 0.78 N·m
②		Tapite, Pan B M2.6X8	Torque 0.29 – 0.49 N·m

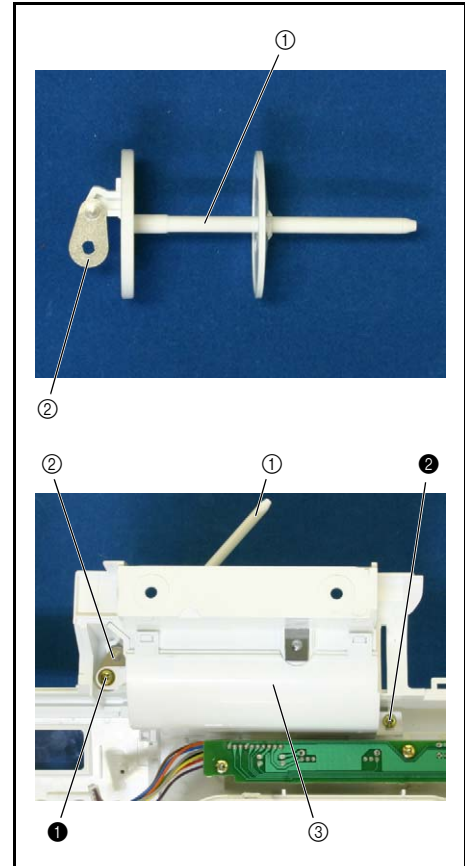
## 5 Front cover assembly (spool pin attachment)

1. Attach the spool pin ① to the spool pin holder assembly ②.
2. Attach the thread bobbin cover ③ and the spool pin holder assembly ② with the screws ① and ②.

### \*Key point


- Secure both the spool pin holder assembly ② and the thread bobbin cover ③ with the screw ①.

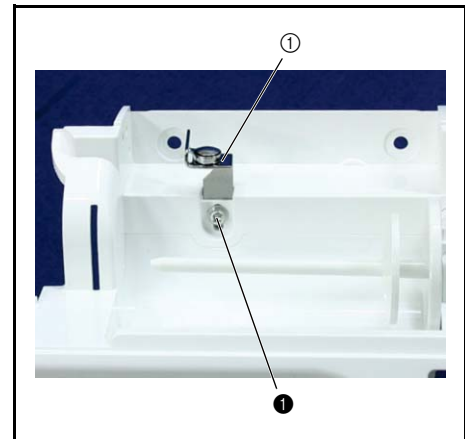
①		Taprite, Cup B M3X10	Torque 0.29 – 0.49 N·m
②		Taprite, Bind B M3X8	Torque 0.29 – 0.49 N·m



## 6 Front cover assembly (assembling bobbin winder guide assembly)

1. Attach the bobbin winder guide assembly ① to the front cover.
2. Hand start the screw ①.  
(Fully tighten after 4 - 16 "Bobbin winder.")

①		Screw, Pan (S/P washer) M3X8DA	Torque 0.57 – 0.78 N·m
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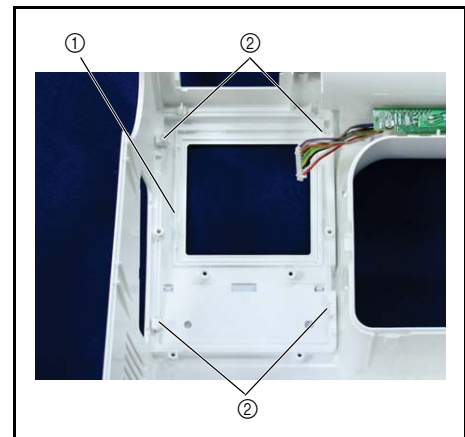


## 7 Indication panel attachment

1. Attach the indication panel ① to the front cover.

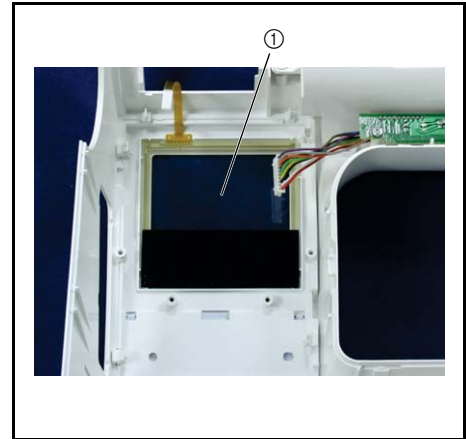
### \*Key point

- Insert the indication panel ① from the top of the front cover to set it on the front side of the front cover, and then attach the 4 hooks ② to the inside of the front cover.



## 8 Touch panel assembly attachment

1. Attach the touch panel assembly ① to the front cover.

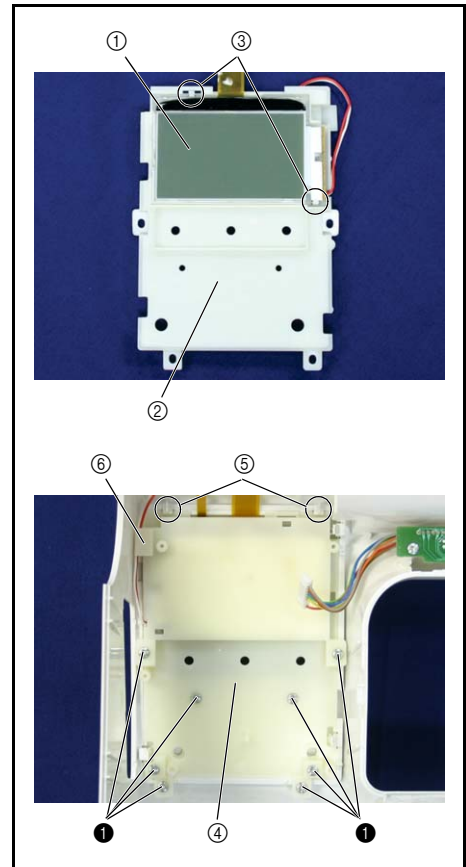



## 9 Main PCB holder assembly attachment

1. Attach the light plate assembly ① to the main PCB holder ② using the 2 hooks ③ on the main PCB holder ②.
2. Attach the main PCB holder assembly ④ to the front cover with the 8 screws ①.

### \*Key point

- Hang the main PCB holder assembly ④ over the 2 hooks ⑤ at the upper section of the front cover.
- Check that the lead wire of the light plate assembly ① passes under the left upper guide ⑥ of the main PCB holder assembly ④.




①		Taptite, Bind B M3X8	Torque 0.39 – 0.79 N·m
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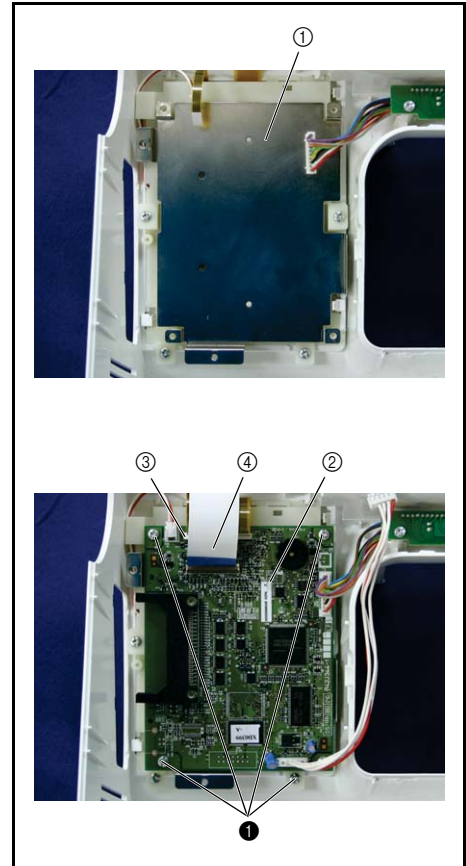
## 10 Main PCB assembly attachment

1. Position the PCB plate B ① and then the main PCB assembly ②, and then attach these to the front cover with the 4 screws ①.
2. Connect the lead wirefs connectors and FFC cords (3 each) to the main PCB assembly ②.

### \*Key point

- Pull up the lock of the connector on the main PCB to release it, insert the FFC cord ③, and then push down the lock to secure the cord.
- Move the lock of the connector on the main PCB to the upright position to release it, insert the FFC cord ④ with the blue surface facing down, and then press the lock down to secure the cord.
- After connection, check that the three FFC cords are connected to the connectors on the main PCB correctly.

①		Taptite, Bind B M3X8	Torque 0.39 – 0.79 N·m
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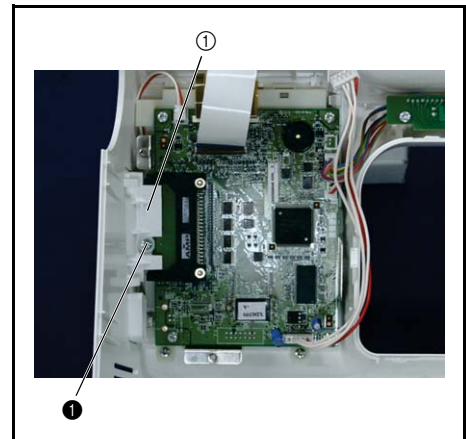
## 11 Card cover attachment

1. Attach the card cover ① to the front cover with the screw ①.

### \*Key point

- Check that the hook on the card cover ① is attached to the backside of the front cover.

①		Taptite, Bind B M3X8	Torque 0.39 – 0.79 N·m
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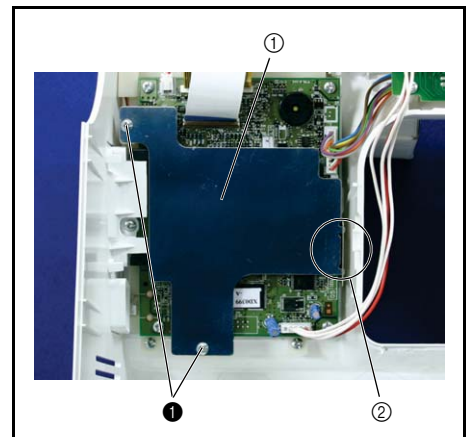
## 12 Board plate A attachment

1. Attach the board plate A ① to the front cover with the 2 screws ①.

### \*Key point

- Engage the 2 tabs on the right side of board plate A ① with the 2 slots on the right side of board plate B ②.

①		Screw, Bind M3X5	Torque 0.39 – 0.79 N·m
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### 13 Front cover attachment

1. Connect the FFC cord ① and the lead wires connector to the main PCB ②.

**\*Key point**

- Move the lock of the connector on the main PCB ② to the upright position to release it, insert the FFC cord ① with the blue surface facing up, and then press the lock down to secure the cord.

2. Engage the 2 hooks ③ with the bottom plate and 2 hooks ④ with the rear cover, and then secure the front cover with the 3 screws ①.

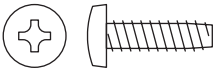

**\*Key point**

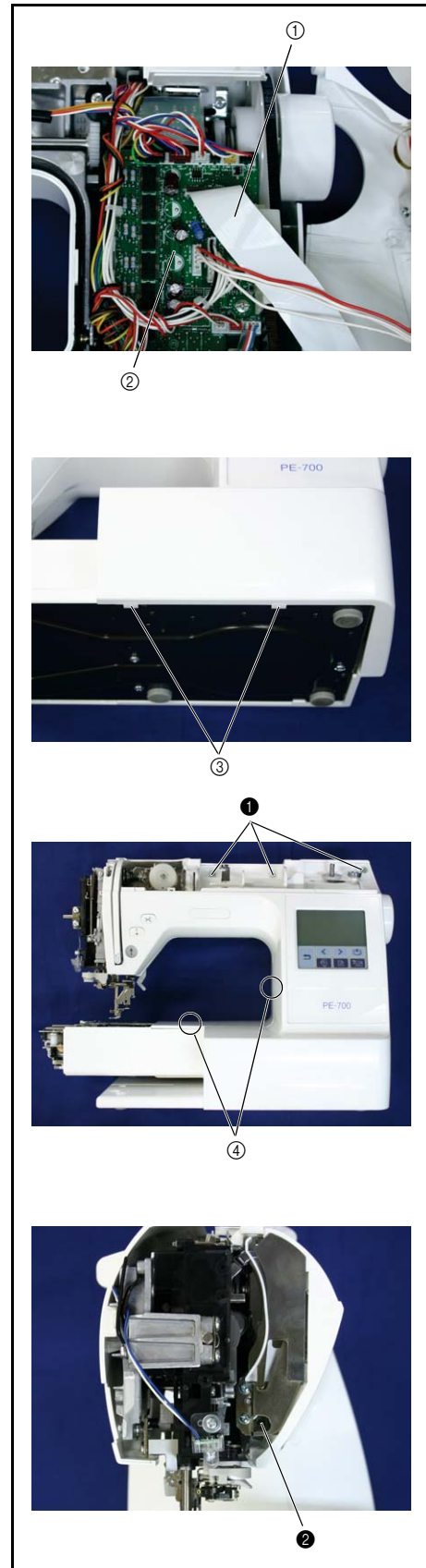
- Check that the bobbin winder cover is at the upper section of the front cover.

3. Tighten the screw ②.

**\*Key point**


- Secure both the thread guard assembly and the groove on the front cover with the screw ②.

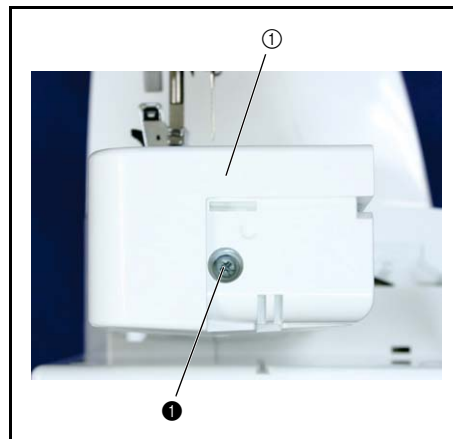
①		Tapite, Bind B M4X14	Torque 0.78 – 1.18 N·m
②		Screw, Pan (T washer) M3X6	Torque 0.57 – 0.78 N·m



## 14 Free arm cover attachment


1. Attach the free arm cover ① to the arm bed with the screw ❶.

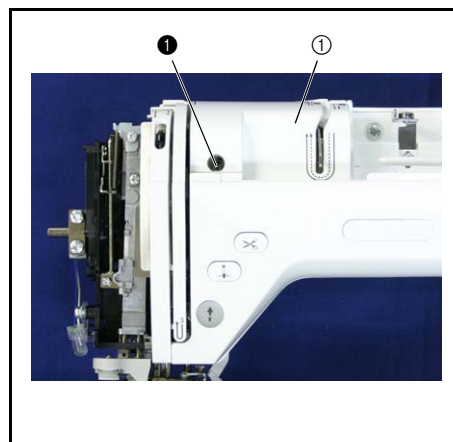
❶		Screw, Pan (SIP washer) M4X8	Torque 0.78 – 1.18 N·m
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## 15 Front thread guide cover attachment

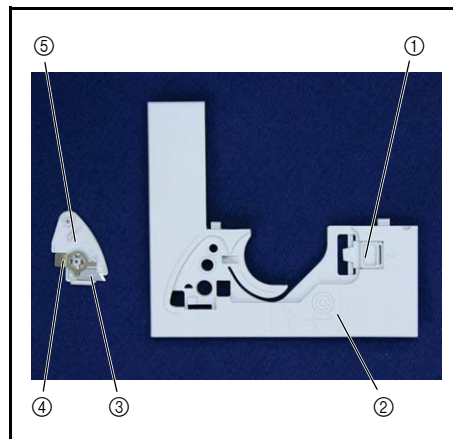
1. Attach the front thread guide cover ① using the screw ❶.

❶		Screw, Bind M3X4	Torque 0.78 – 1.18 N·m
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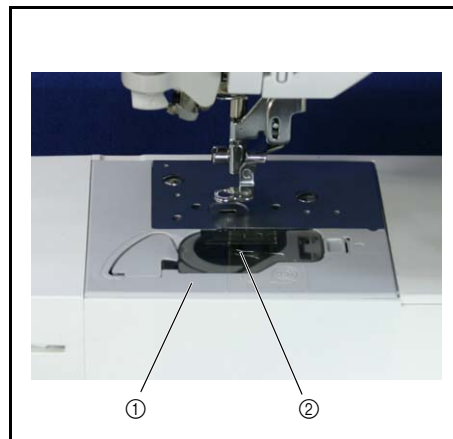
## 16 Assembling needle plate B assy

1. Attach the slide button ① to the needle plate B ②.
2. Attach the NT lower thread cutter ③ and the spring plate ④ to the cutter cover ⑤.
3. Attach the cutter cover ⑤ to the needle plate B ②.



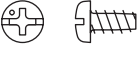


## 17 Needle plate B assy. attachment

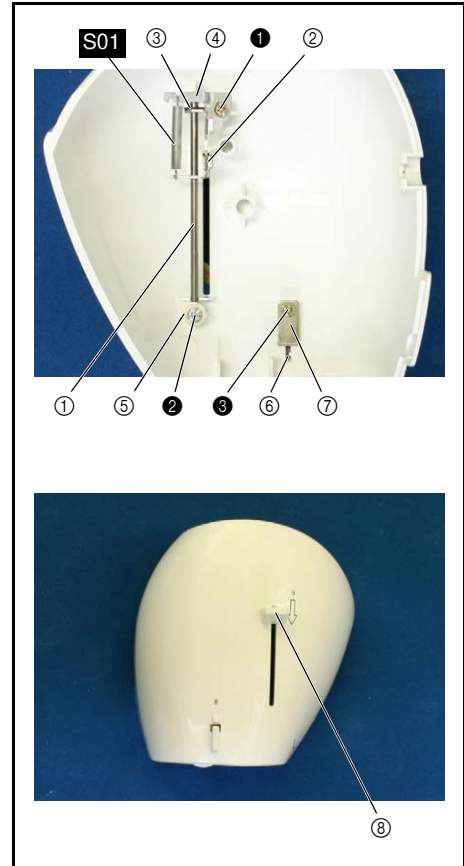
1. Attach the needle plate B assy ① to the main unit.
2. Attach the needle plate cover ② to the needle plate B assy ①.



## 18 Face plate assembly

1. Attach the needle thread lever shaft ①, needle thread lever ②, and rubber washer ③ to the face plate.
2. Attach the shaft presser plate ④ to the face plate with the screw ①.
3. Attach the screw ② and the washer ⑤.
4. Attach the spring S01 to the needle thread lever ② and the shaft presser plate ④.
5. Attach the NT lower thread cutter ⑥ to the face plate, and then attach the face plate cutter holder with the screw ③.
6. Attach the needle thread lever knob ⑧.

① ③		Tapite, Pan B M3X6	Torque 0.29 – 0.34 N·m
②		Tapite, Bind B M3X10	Torque 0.29 – 0.34 N·m
S01		THREAD THROUGH LEVER SPRING 138260***	




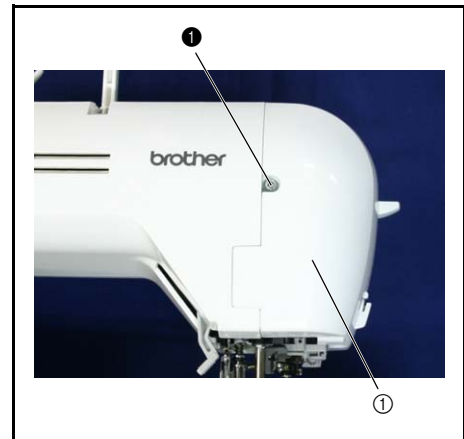
## 19 Face plate assy. attachment

1. Secure the face plate assy ① to the arm bed with the screw ①.

### \*Key point

- Align and attach the hole in the center on the inside of the face plate assy ① to the shaft on the needle-presser module.

①		Screw, Pan (S/P washer) M4X14	Torque 0.78 – 1.18 N·m
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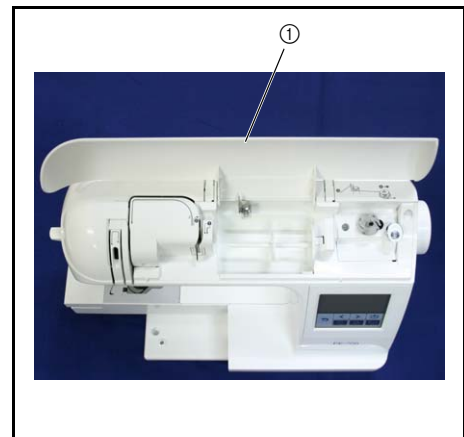


## 20 Top cover attachment

1. Attach the top cover ① to the front cover.

### \*Key point

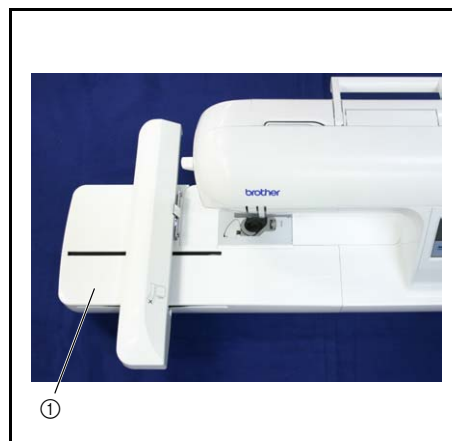
- The attachments (two, left and right) for the top cover ① fall to the inside.



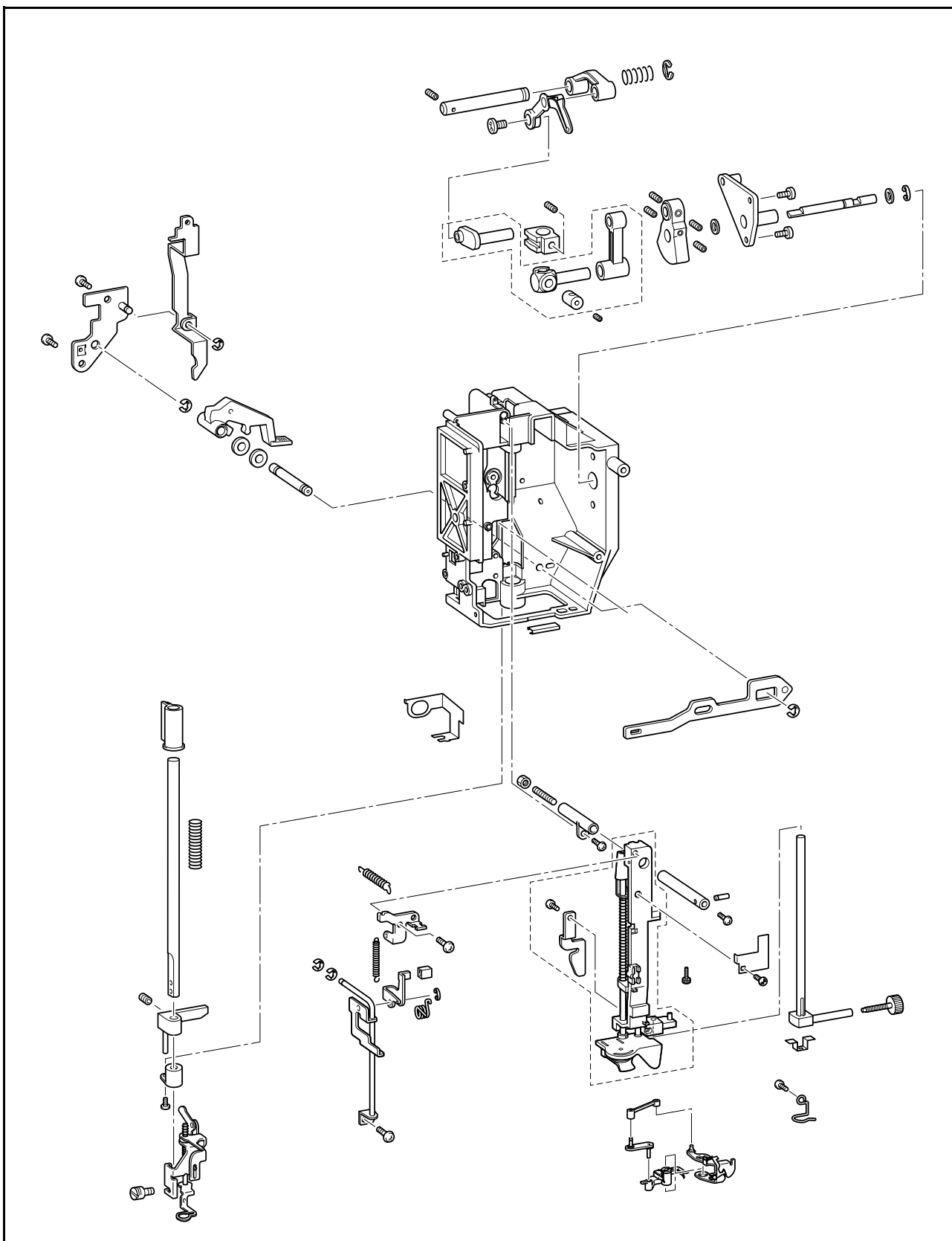


**21** Embroidery attachment

1. Embroidery ① to the main unit.




### Needle-presser module breakout diagram

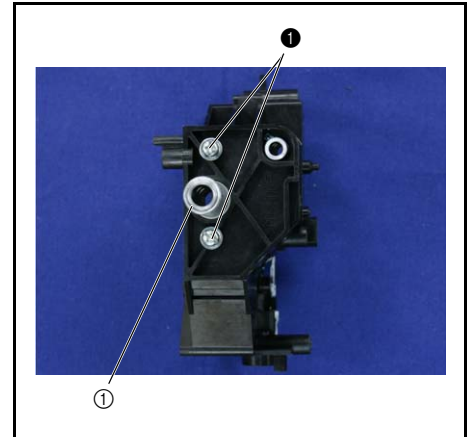


Assembly

### 1 Shaft bushing assembly attachment

- Using the 2 screws ❶, attach the shaft bushing assembly ① to the upper unit holder.


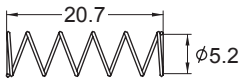
❶		Screw, Pan (SIP washer) M4X14DB	Torque 1.18 – 1.57 N·m
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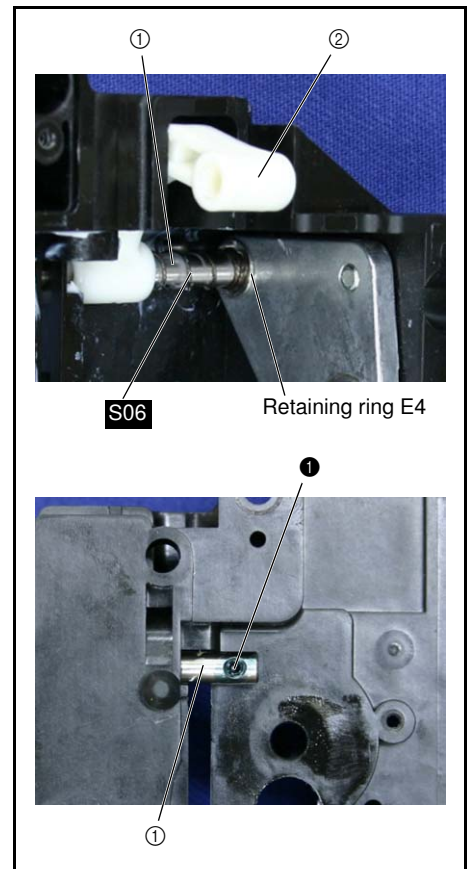


### 2 Thread take-up lever link assembly

- Apply a small amount of MOLYKOTE EM30L to the shaft hole in the thread take-up lever link.
- Attach the shaft ①, spring S06 and thread take-up lever link ② to the upper unit holder, and attach retaining ring E4.
- Install the screw ❶ in the shaft ①.

Apply MOLYKOTE EM30L all the way around the shaft hole in the thread take-up lever link.	small amount XC8385
--	------------------------

❶		Set Screw, Socket (CP) M3X5	Torque 0.49 N·m
S06			SPRING XC2441***



### 3 Presser bar attachment

1. Insert the presser bar bushing ① into the shaft hole on the bottom of the unit holder.
2. Attach the plate spring ② to the unit holder with the screw ①.

**\*Key point**

- Press the presser bar bushing with the plate spring.

3. Dip the tip of the presser bar ③ (opposite end from the retaining ring) in FBK OIL RO 100.
4. Insert the presser bar ③ into the presser foot rack ④.
5. Temporarily attach the screw ② to the presser bar clamp ⑤.
6. Adjust the presser bar height and parallel alignment, and then fully tighten the screw ②.

**\*Key point**

- Refer to "Presser bar height" on page 4 - 15 for the adjustment procedure.

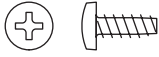

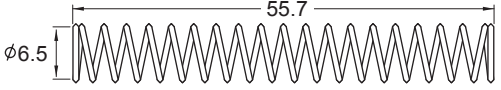
7. Apply a bead of MOLYKOTE EM30L to the groove on the stopper pin of the unit holder.
8. Insert spring S07 and the presser bar clamp ⑤ into the presser bar ③.

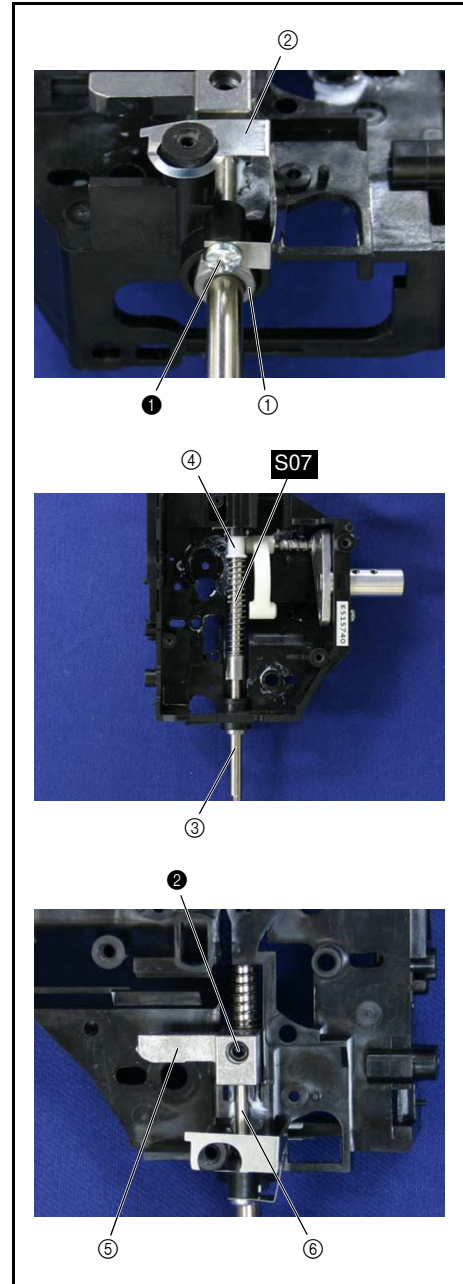
**\*Key point**

- Engage the stopper pin ⑥ of the presser bar clamp ⑤ with the groove on the stopper pin of the unit holder.

9. Pass the presser bar ③ through to the presser bar bushing ①.

Dip the tip of the presser bar (opposite end from the retaining ring) in FBK OIL RO 100.	Dipping XC8388***
Apply MOLYKOTE EM30L to the groove on the stopper pin of the unit holder.	Bead XC8385***

①		Taprite, Bind B M3X8	Torque 0.78 – 1.18 N·m
②		Set Screw, Socket (CP) M5X10	Torque Hand tighten
S07			SPRING XC4457***





#### 4 Thread take-up counter weight attachment

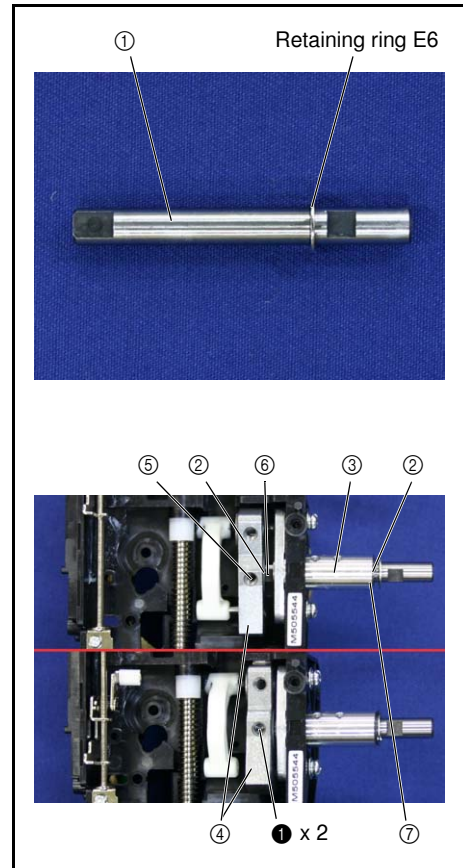
1. Attach the retaining ring E6 to the unit shaft ①.
2. Attach the thrust washer ②, unit shaft ①, thrust washer ② to the shaft bushing assembly ③.
3. Attach the thread take-up counter weight ④ using the 2 screws ①.

**\*Key point**

- Align the screw hole ⑤ in the thread take-up counter weight ④ and the unit shaft D cut surface ⑥.
4. Lubricate part ⑦ of the shaft bushing assembly ③ with one to two drops of OILER B ASSY.

Lubricate the unit shaft with OILER B ASSY.	1 – 2 drops XZ0206***
Lubricate the inside of the shaft bushing with OILER B ASSY	1 – 2 drops XZ0206***

  	Set Screw, Socket (FT) M5X5	<b>Torque</b> 1.37 – 1.77 N·m
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### 5 Thread take-up lever assy. attachment

1. Apply a bead of MOLYKOTE EM30L to the 2 calking shafts of the needle bar crank ①.
2. Apply a bead of MOLYKOTE EM30L to the calking shaft of the thread take-up lever assembly ②.
3. Insert the needle bar crank rod ③ (end with the larger diameter) into the calking shaft (longer) of the needle bar crank ①.
4. Apply a bead of MOLYKOTE EM30L to the screw attachment face of the needle bar crank ① (tip of the shorter calking shaft).
5. Insert the calking shaft (longer) of the needle bar crank rod ③ into the thread take-up counter weight ④.

**\*Key point**



- Align the D-cut face ⑤ of the needle bar crank calking shaft with the screw hole ⑥ on the thread take-up counter weight.

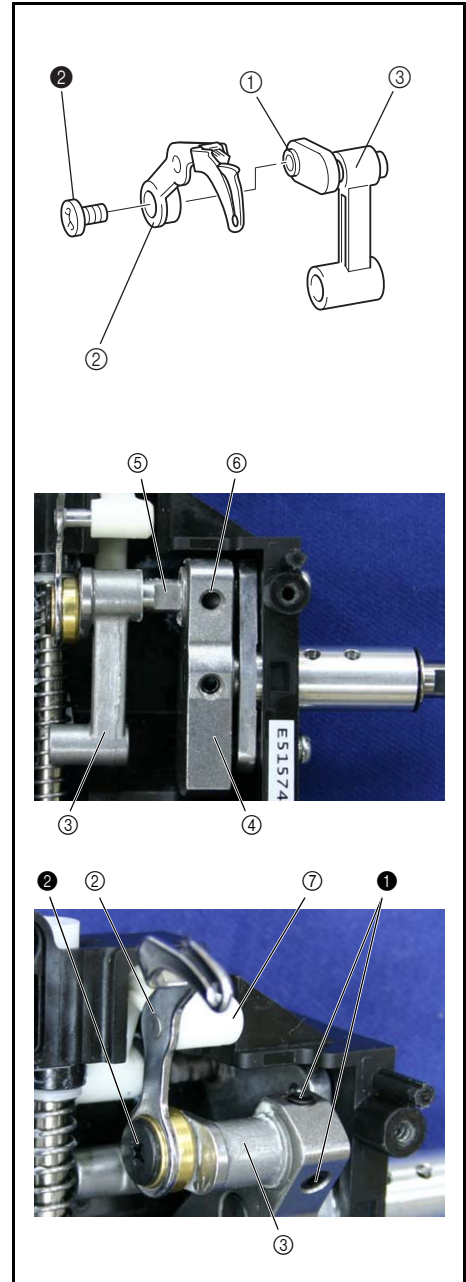
6. Fully tighten the 2 screws ① temporarily attached to the thread take-up counter weight ④.
7. Insert the calking shaft of the thread take-up lever assembly ② into the shaft hole on the thread take-up lever link ⑦.
8. Insert the calking shaft (shorter) of the needle bar crank ① into the shaft hole on the thread take-up lever assembly ②, and then tighten the screw ②.

**\*Key point**

- The screw ② has a reverse helical flute thread.

Apply MOLYKOTE EM30L to the 2 calking shafts of the needle bar crank.	Bead XC8385***
Apply MOLYKOTE EM30L to the calking shaft of the thread take-up lever assembly.	Bead XC8385***
Apply MOLYKOTE EM30L to the screw attachment face of the needle bar crank (tip of the shorter calking shaft).	Bead XC8385***

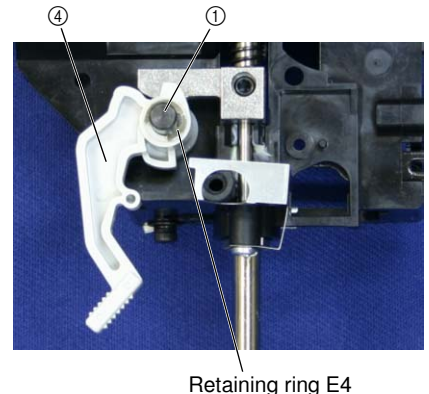
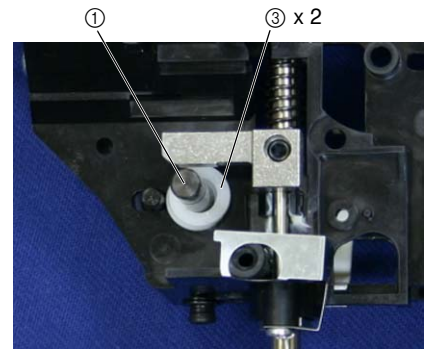
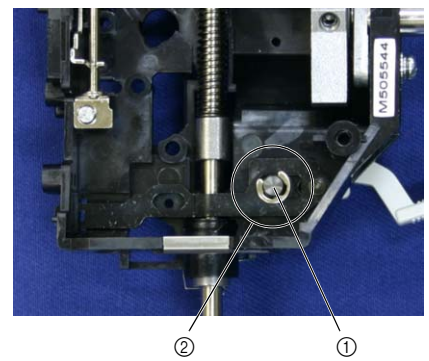
①		Set Screw, Socket (FT) M5X5	Torque 1.37 – 1.77 N·m
②		Screw, Flat SM3.57-40X7 L	Torque 1.18 – 1.57 N·m



**6** Presser foot lifter attachment

1. Attach the retaining ring E4 to the presser lift shaft ①.
2. Apply a small amount of MOLYKOTE EM30L to the presser lift shaft ①.
3. Insert the presser lift shaft ① into the hole ② in the thread releaser assy, and attach the 2 washer ③ and presser foot lifter ④.
4. Attach the retaining ring E4 to the presser lift shaft ①.

Apply MOLYKOTE EM30L to the operating surface of the presser lifter shaft presser foot lifter.	Small amount XC8385***
Apply MOLYKOTE EM30L to the operating surface of the presser foot lifter presser bar clamp	Small amount XC8385***

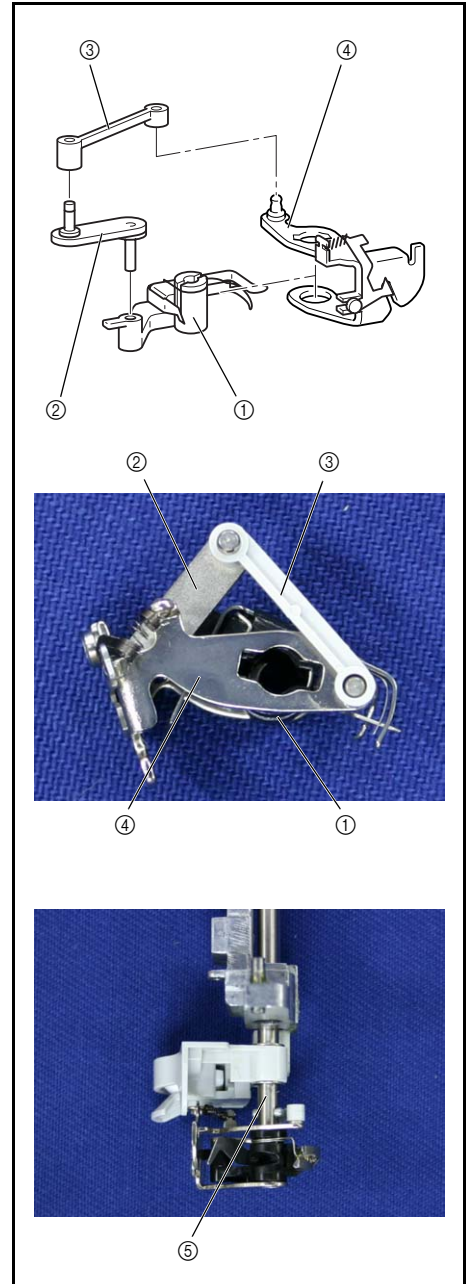


### 7 Threader hook assy. attachment

1. Assemble the threader hook assy ①, link A assy ②, link B ③ and thread guide assy ④.
2. Align the needle thread shaft A ⑤ to the shape of the threader hook assy ① shaft hole, and attach the threader hook assy ① to the needle thread shaft A ⑤.



**\*Key point**

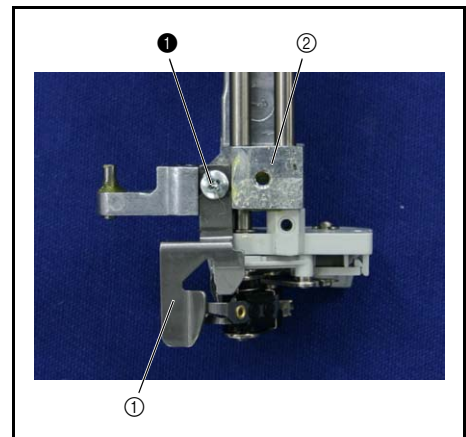
- Assemble the link A assembly ②, link B assembly ③, and thread guide assembly ④ so that a triangle is formed.



### 8 Hook release plate attachment

1. Attach the hook release plate ① to the needle bar supporter assy ② the screw ①.

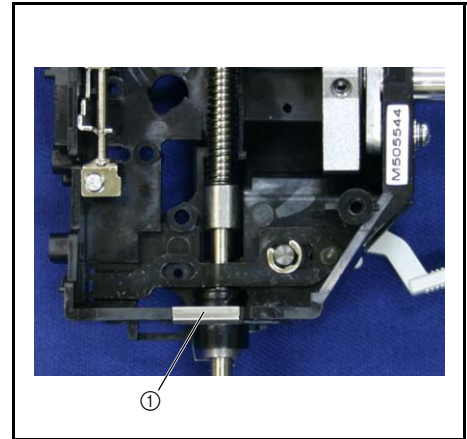
①	 	Screw, Bind M2.6X5	Torque 0.29 – 0.49 N·m
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### 9 Thread guide plate attachment

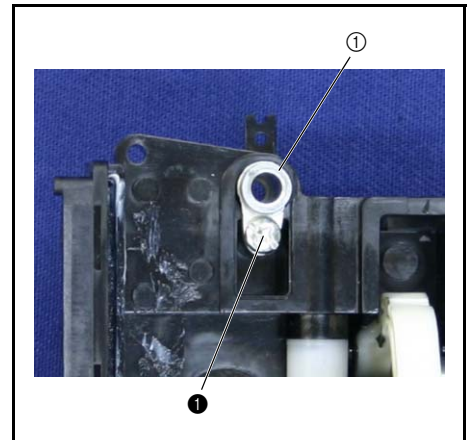
1. Attach the thread guide plate ① to the upper unit holder.



### 10 Shaft bushing A attachment

1. Attach the shaft bushing A ① to the upper unit holder using the screw ❶.

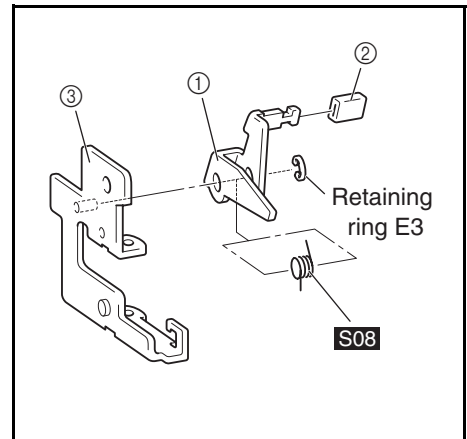
❶			Taplite, Bind B M3X8	Torque 0.78 – 1.18 N·m
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### 11 Assembling the Lever AB assy

1. Attach the cap ② to the lever B ①.
2. Attach the lever B ① and the spring S08 to the lever A assembly ③, and then attach the retaining ring (E3).


S08		TORSION SPRING XC2460***
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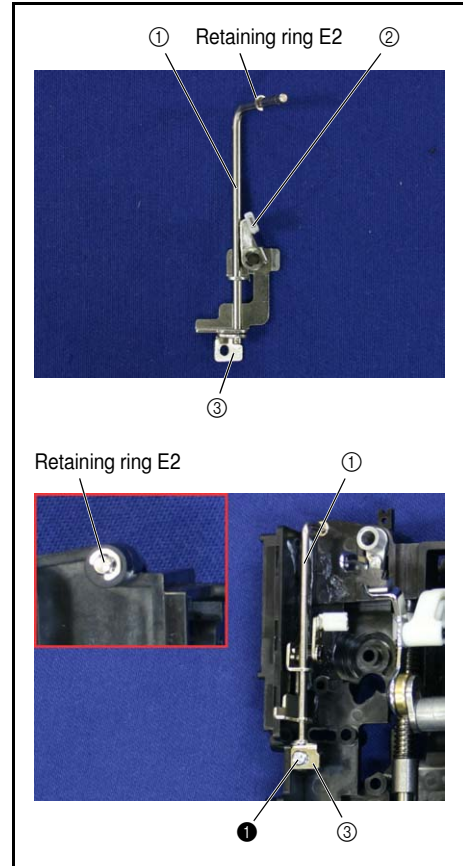


### 12 Lever AB assy. attachment

1. Attach the retaining ring E2 to the lever guide shaft ①.
2. Apply a small amount of EPNOC AP(N)0 to the lever guide shaft ①.
3. Apply a small amount of MOLYKOTE EM30L to the upper unit holder slide groove.
4. Attach the lever AB assy ② to the lever guide shaft ①.
5. Attach the lever guide shaft assy ① to the upper unit holder, and attach the lever presser plate ③ using the screw ❶.
6. Attach the retaining ring E2 to the lever guide shaft ①.

Apply EPNOC AP(N)0 to the lever guide shaft	Small amount XC8387***
Apply MOLYKOTE EM30L to the full width of the slide lever groove	Small amount XC8385***
Apply MOLYKOTE EM30L to the operating surfaces of the lever B cap and the thread guide slider.	Small amount XC8385***



❶		Taptite, Bind B M3X6	Torque 0.78 – 1.18 N·m
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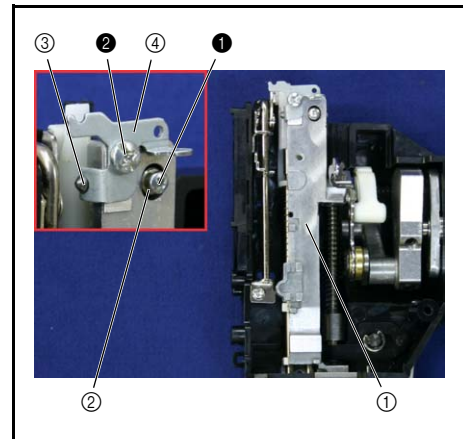


### 13 Needle bar supporter assy. attachment

1. Attach the needle bar supporter assy ① to the upper unit holder.
  - \*Key point**
    - Move the lever AB assy up.
    - Turn the T cam, and move the lower end of the Z zigzag lever to the left.
2. Attach the shaft A ②.
3. Attach the shaft C ③, and install the screw ❶.
4. Attach the plate ④ using the screw ❷.

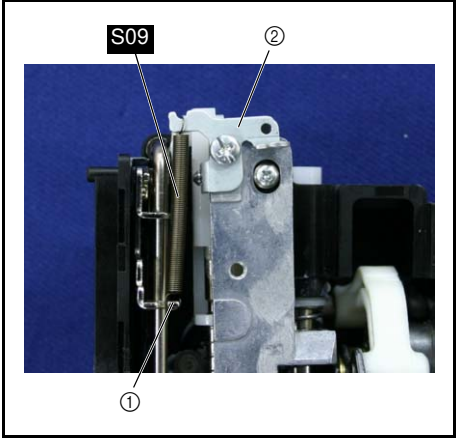
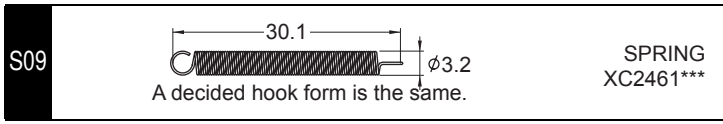
Lubricate the shaft with FBK OIL RO 100.	1 – 2 drops XC8388***
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❶		Set Screw, Socket (FT) M4X4	Torque 0.78 – 1.18 N·m
❷		Screw, Bind M3X5	Torque 0.78 – 1.18 N·m



### 14 Lever A spring attachment

1. Attach the spring **S09** to the lever AB assy ① and the plate ②.

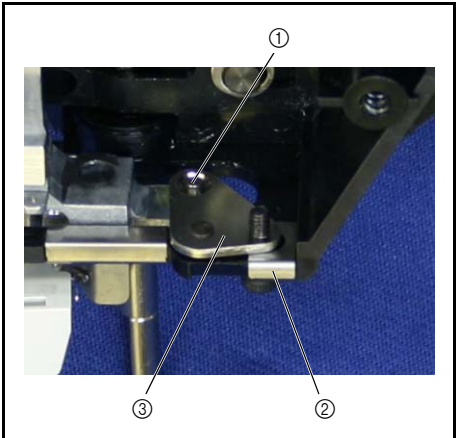


### 15 Needle holder guide assy attachment

1. Apply a small amount of EPNOC AP(N)0 to the needle bar supporter assy needle roller ①.
2. Attach the upper unit support plate ② and the needle holder guide assy ③ to the needle bar supporter assy needle roller ①.

Apply EPNOC AP(N)0 to the upper unit holder needle roller	Small amount XC8387***
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①		Screw 3X10	Torque 0.78 – 1.18 N·m
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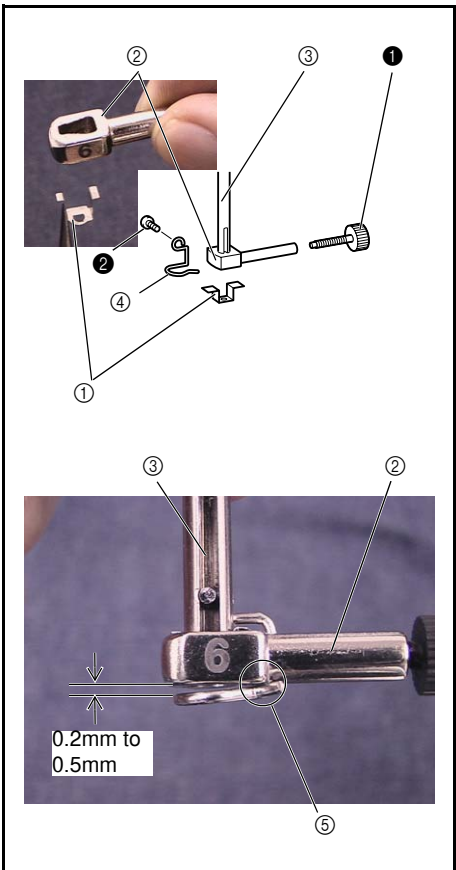
### 16 Needle bar assembly

1. Attach the needle thread plate ① to the needle block ②.
2. Attach the needle block ② to the needle bar ③ using the screw ①.
  - \*Key point**
    - With the needle bar groove facing forward, the screw ① is on the right side.
3. Attach the needle bar thread guide ④ to the needle bar ③ using the screw ②.

- \*Key point**
  - There should be no gap ⑤ on the right side of the needle bar thread guide ④ and needle block ②.
  - There should be a 0.2 mm – 0.5 mm gap on the left side of the needle bar thread guide ④ and needle block ②.

Gap on right side of needle bar thread guide and needle block	None
Gap on left side of needle bar thread guide and needle block	0.2 mm – 0.5 mm

①		Needle Clamp Screw	—
②		Screw SM2.38	Torque 0.39 – 1.78 N·m



### 17 Needle bar assembly attachment


1. Apply a small amount of EPNOC AP(N)0 to the needle thread block ①.
2. Hand tighten the needle bar ②, needle thread block ① and needle bar hook stand assy ③ using the 2 screws ❶.

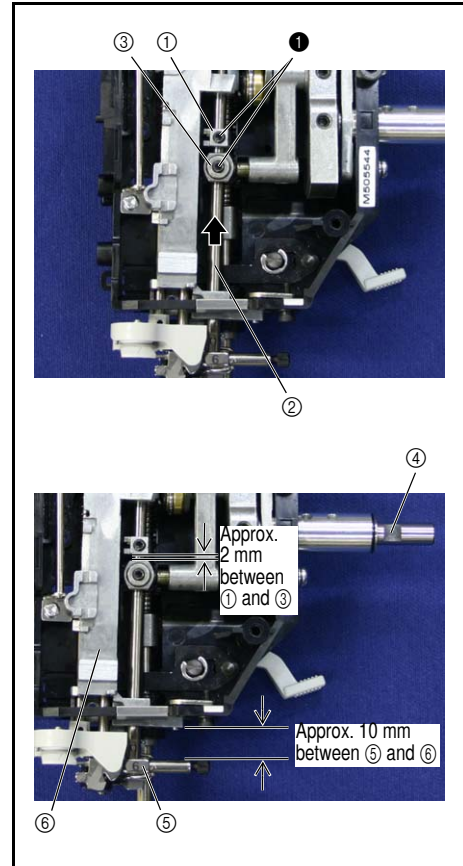
(Fully tighten after 4 - 15 "Presser bar height," and 4 - 14 "Needle threader.")

**\*Key point**

- With the unit shaft D cut ④ facing forward, the upper surface of the needle block ⑤ and the needle bar supporter assy ⑥ should be adjusted to approximately 10 mm separation.
- Adjust the space between the needle thread block ① and the needle bar hook stand assy ③ to approximately 2 mm.
- When the needle thread block ① is viewed from the front, it is secured in a position turned slightly counterclockwise (see 4 - 14 "Needle threader")

Lubricate the needle bar crank joint area with MOLYKOTE (OILER B ASSY 90% + MOLYKOTE DISPERSION).	1 – 2 drops XZ0206*** XC8385***
Apply EPNOC AP(N)0 to the sliding pin part of the needle thread block.	Small amount XC8387***
Lubricate the needle bar supporter assy. needle operating area with OILER B ASSY.	1 – 2 drops XZ0206***

❶		Set Screw, Socket (FT) M4X4	Torque Hand tighten
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### 18 Lock nut attachment

1. Attach the screw ❶ to the lock nut ①.

**\*Key point**


- The screw ❶ in approximately half its length.

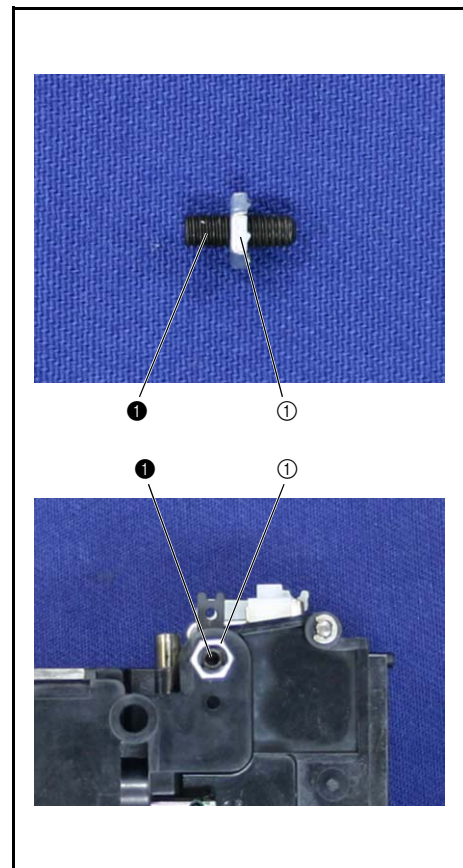
2. Install the screw ❶ in the upper unit holder.

**\*Key point**

- Tighten until the lock nut ① hits the upper unit holder.

3. Tighten the lock nut ①.

❶		Set Screw, Socket (CP) M4X12	Torque 0.39 – 0.49 N·m
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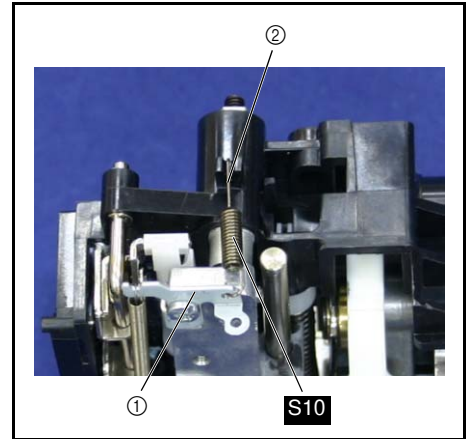
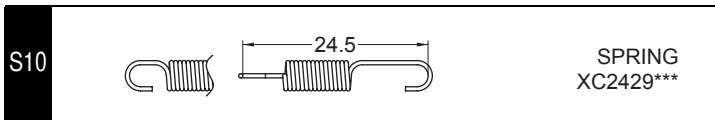


### 19 Spring (for needle bar supporter assy.) attachment

1. Attach the spring **S10** to the needle bar supporter assy plate ① and the upper unit holder ②.

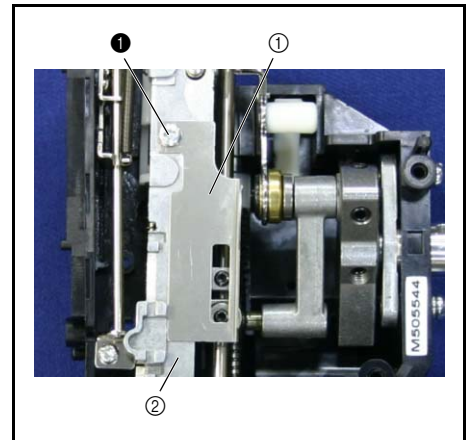
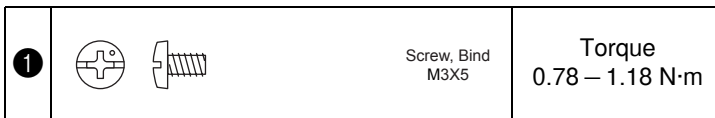
**\*Key point**

- Connect the side with the short hook to the needle bar supporter assy plate ① and the long side to the upper unit holder ②.



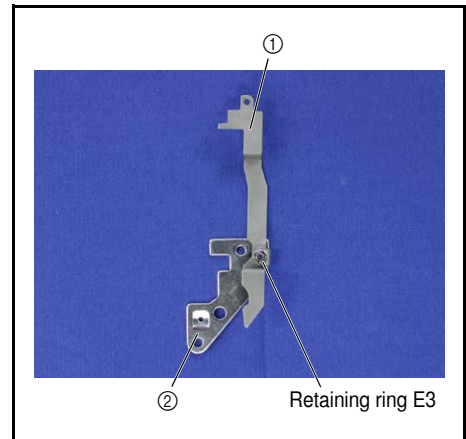
### 20 Gurd plate attachment

1. Attach the gurd plate ① to the needle bar supporter assembly ② with the screw ①.



### 21 Adjusting plate ASSY assembly

1. Attach the tension releaser C ① to the adjusting plate assembly ②, and then attach the retaining ring E3.

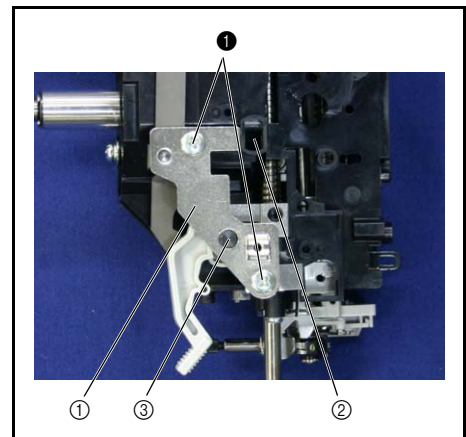
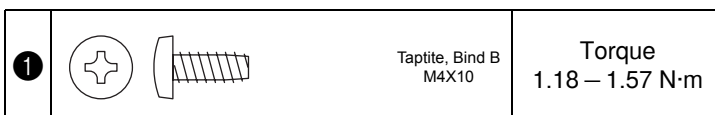


### 22 Adjusting plate assy. attachment

1. Attach the adjusting plate assy ① to the upper unit holder using the 2 screws ①.

**\*Key point**

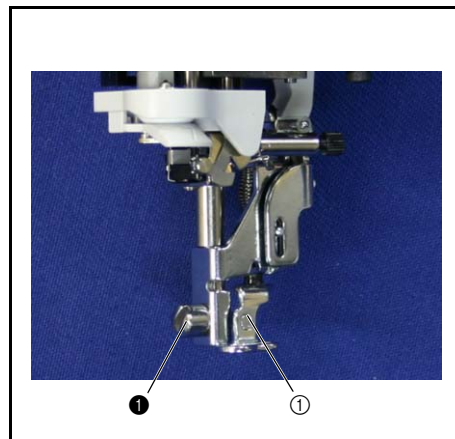
- Hold the adjusting plate assy ① against the right stopper ② and attach.
- Align the presser lifter shaft and the adjusting plate assy hole ③.



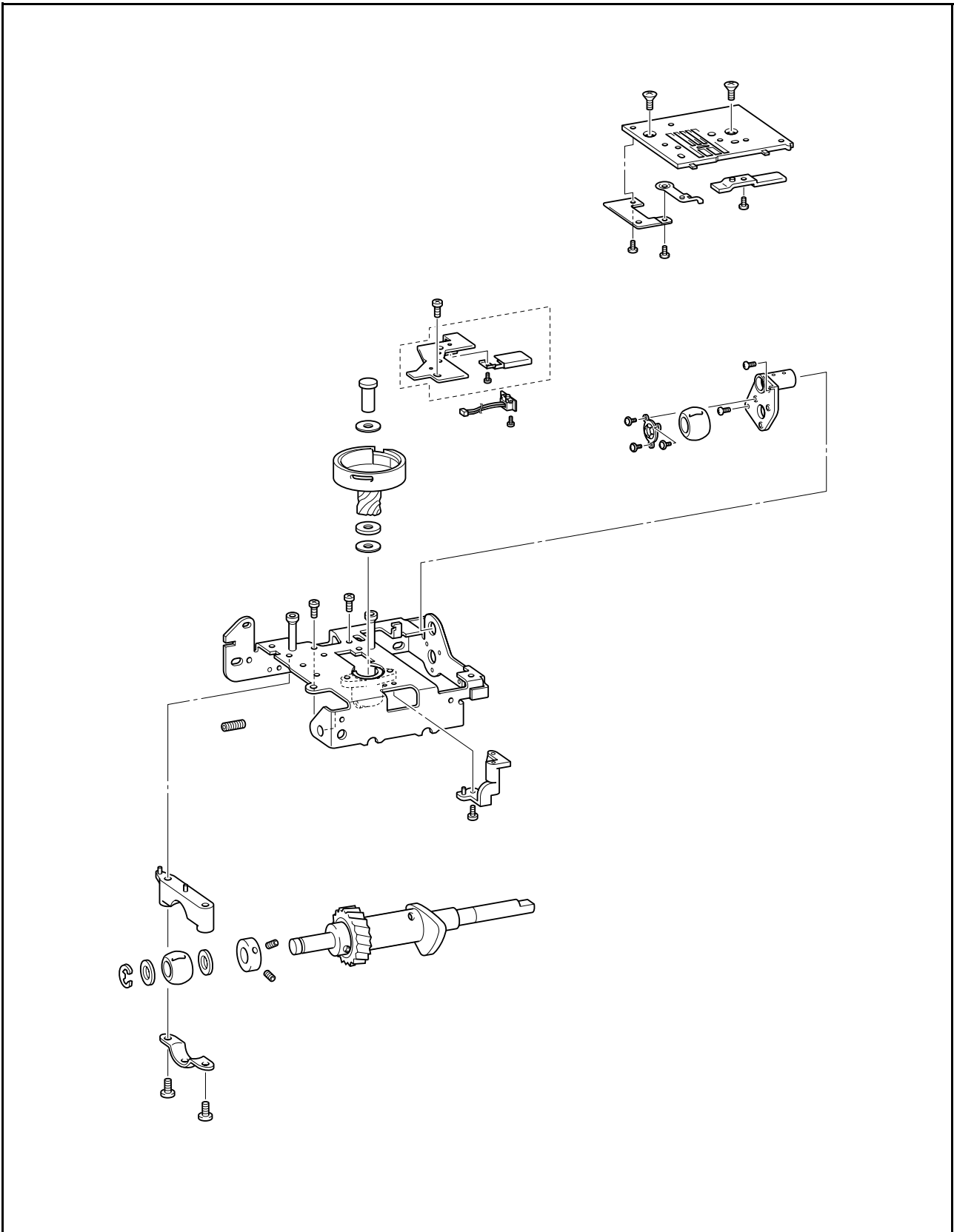
**23** Quilting foot attachment

1. Attach the quilting foot ① to the presser bar using the screw ❶.

❶		Screw 3.57  Torque 1.18 – 1.57 N·m
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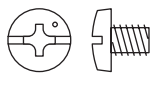
### Feed module breakout diagram

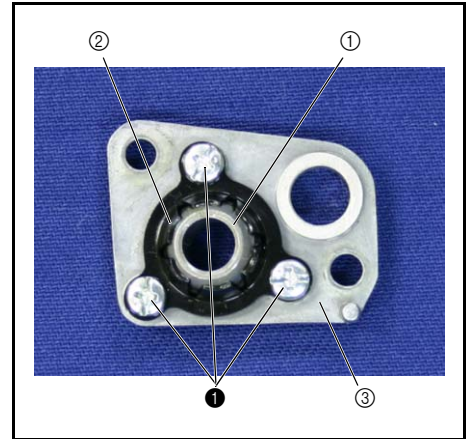


### 1 Bushing supporter assy. assembly

1. Attach the lower shaft bushing ① and the bushing presser B ② to the bushing supporter assy ③ using the 3 screws ❶.
2. Lubricate the lower shaft bushing ① with 1 – 2 drops of FBK OIL RO 100.

Lubricate the lower shaft bushing round surface with FBK OIL RO 100.	1 – 2 drops XC8388***
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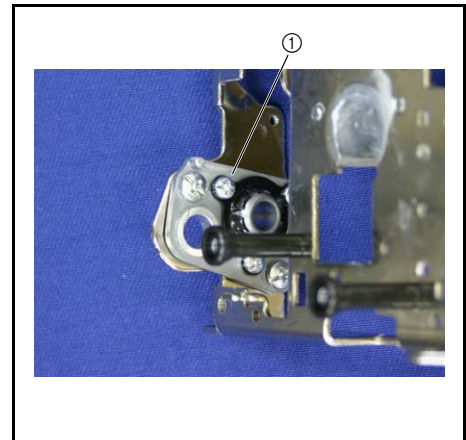
❶		Screw, Bind M4X5	Torque 0.78 – 1.18 N·m
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### 2 Bushing support assy. attachment

1. Attach the bushing supporter assy. ① to the feed base using the screws ❶ (two).

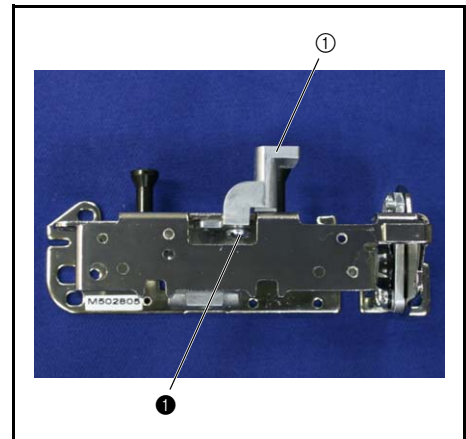
❶		Screw, Bind M4X6	Torque 1.18 – 1.57 N·m
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### 3 Stopper plate block assy. attachment

1. Attach the stopper plate block assy. ① using the screw ❶.

❶		Screw, Bind M4X5	Torque 1.18 – 1.57 N·m
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#### 4 Assembling the lower shaft B assy

1. Attach the set screw collar ①, thrust washer ②, lower shaft bushing ③ and thrust washer ② to the lower shaft B assy. ④, and attach retaining ring E6.

**\*Key point**

- Attach the set screw collar ① with the ground surface facing the lower shaft bushing ③.

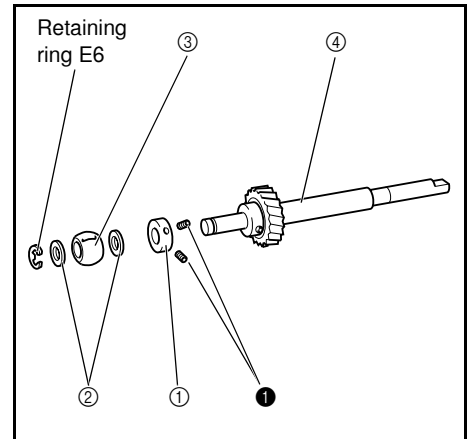
2. Install the 2 screws ❶ in the set screw collar ①.



**\*Key point**

- Attach the set screw collar ① in a position that allows the lower shaft bushing ③ to turn smoothly.

3. Lubricate the lower shaft bushing ③ with 1 – 2 drops of OILER B ASSY.

Lubricate the lower shaft bushing with OILER B ASSY	1 – 2 drops XZ0206***
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❶	 	Set Screw, Socket (CP) M4X4	Torque 0.78 – 1.18 N·m
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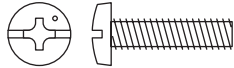

### 5 Lower shaft B assy. attachment

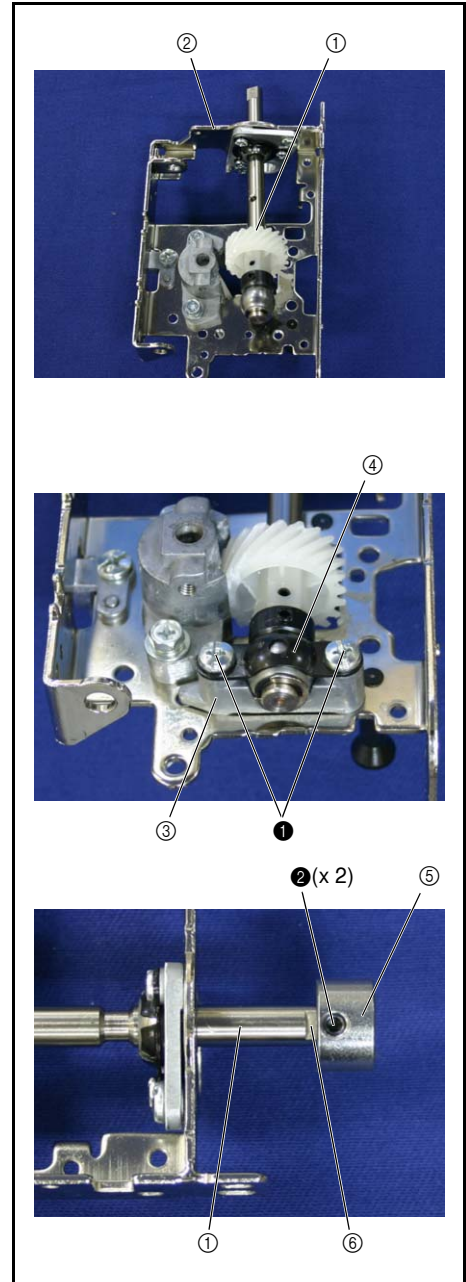
1. Attach the lower shaft B assy ① to the feed base ②.
2. Attach the bushing supporter A ③ to the feed base ②.
3. Attach the bushing presser A ④ using the 2 screws ①.
4. Attach the joint ⑤ using the 2 screws ②.

**\*Key point**

- Align the screw hole in the joint ⑤ and the D cut surface ⑥ in the lower shaft B assy ①.

Lubricate the lower shaft (inserted side of bushing supporter assy.) with OILER B ASSY.	1 – 2 drops XZ0206***
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<b>①</b>		Screw, Bind M4X16	Torque 1.18 – 1.57 N·m
<b>②</b>		Set Screw, Socket (FT) M5X5	Torque 1.18 – 1.57 N·m



### 6 Outer rotary hook assy. attachment


1. Apply a small amount of Molykote EM30L to the shaft supporter ①.
2. Install the outer rotary hook shaft ②, spacer (thin) ③, outer rotary hook assy ④, washer 6 (thick) ⑤ and the spacer (thin) ③.

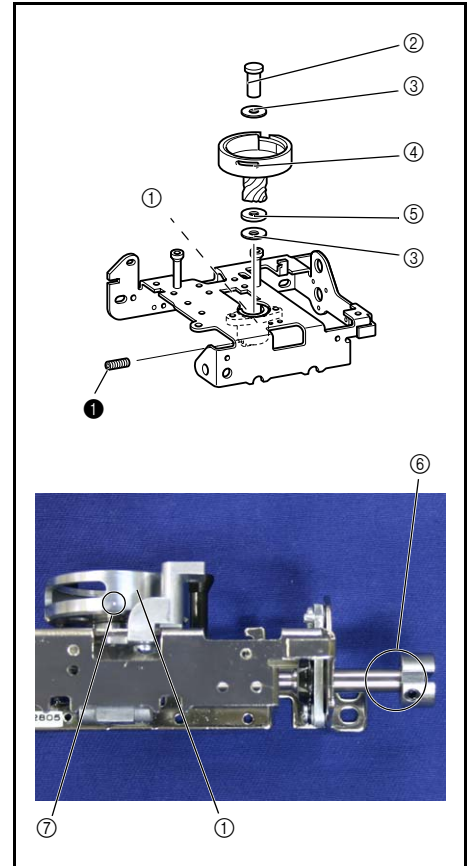
**\*Key point**

- With the D cut ⑥ in the lower shaft B facing upward, attach so that the solid dot ⑦ on the rotary hook assy faces forward.  
\*Attach from a position where ⑦ is 45 deg. to the right.

3. Install the screw ❶ in the shaft supporter.

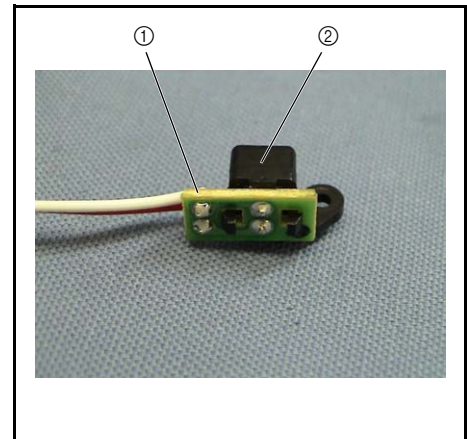
Apply MOLYKOTE EM30L to the shaft supporter surface	Small amount XC8385***
Lubricate the outer rotary hook shaft with OILER B ASSY	Apply liberally XZ0206***

❶		Set Screw, Socket (CP) M4X6	Torque 1.18 – 1.57 N·m
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### 7 Photo diode holder ASSY assembly

1. Engage the photo diode assembly ① with the 2 hooks on the photo diode holder ②.




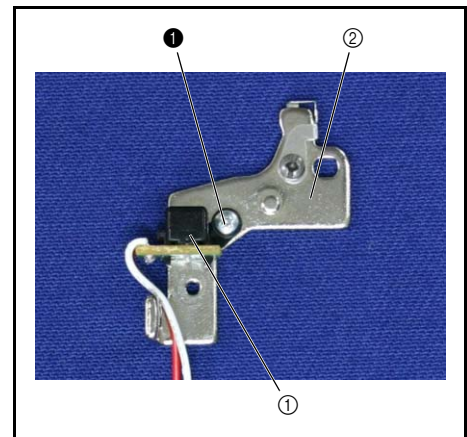
### 8 Photo diode holder assembly attachment

1. Attach the photo diode holder assembly ① to the inner rotary hook bracket ② with the screw ❶.

**\*Key point**


- Engage the positioning tab on the photo diode holder assembly ① with the positioning hole on the inner rotary hook bracket ②.

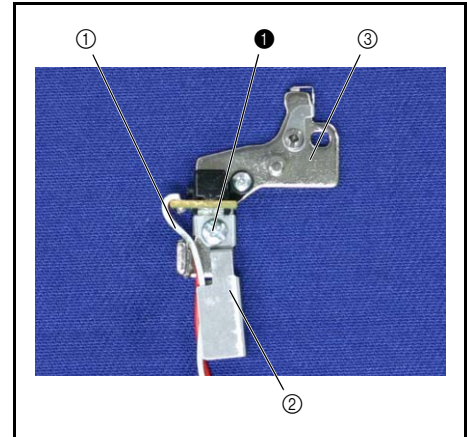
❶		Screw, Bind M2X4	Torque 0.29 – 0.49 N·m
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### 9 Cord holder attachment


1. Pass the photo diode lead wire ① through the cord holder ②.
2. Attach the cord holder ② to the inner rotary hook bracket ③ with the screw ①.

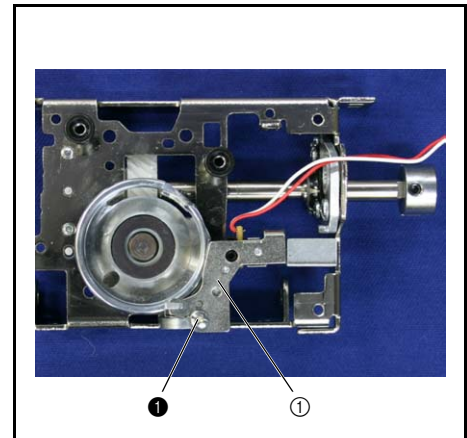
①		Screw, Bind M2X3	Torque 0.29 – 0.49 N·m
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### 10 Inner rotary hook bracket assy. attachment

1. Align the inner rotary hook bracket assy ① with the stopper plate block, and hand start the screw ①  
(Fully tighten after 4 - 18 "Inner rotary hook bracket position.")

①		Screw, Bind M2.6X3	Torque 0.78 – 1.18 N·m
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### 11 Needle plate A ASSY assembly

1. Attach the F gear stopper plate ① to the rear of the needle plate A ② with the screw ①.


**\*Key point**

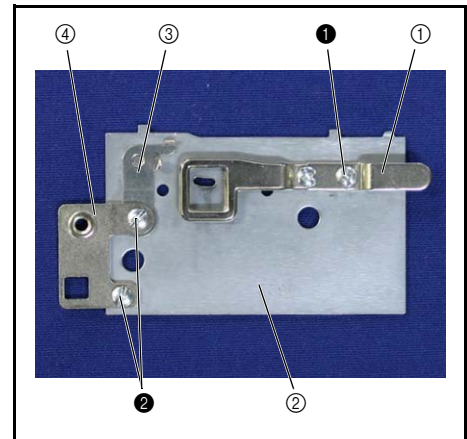
- Engage the positioning tab on the stopper plate with the positioning hole on the needle plate A ②.

2. Attach the stopper plate ③ and then the needle plate B support plate ④ to the rear of needle plate A ② with the 2 screws ②.

**\*Key point**

- Engage the positioning tab on the stopper plate with the positioning hole on needle plate A.

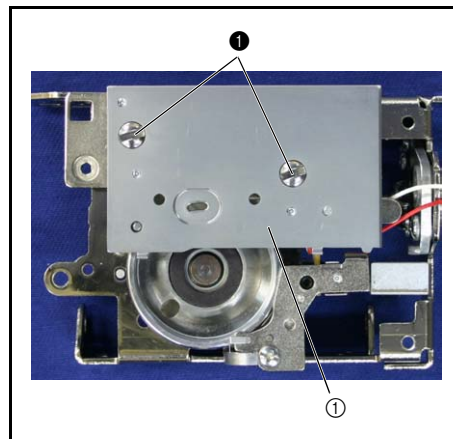
① ②		Screw, Bind M2.6X3	Torque 0.57 – 1.78 N·m
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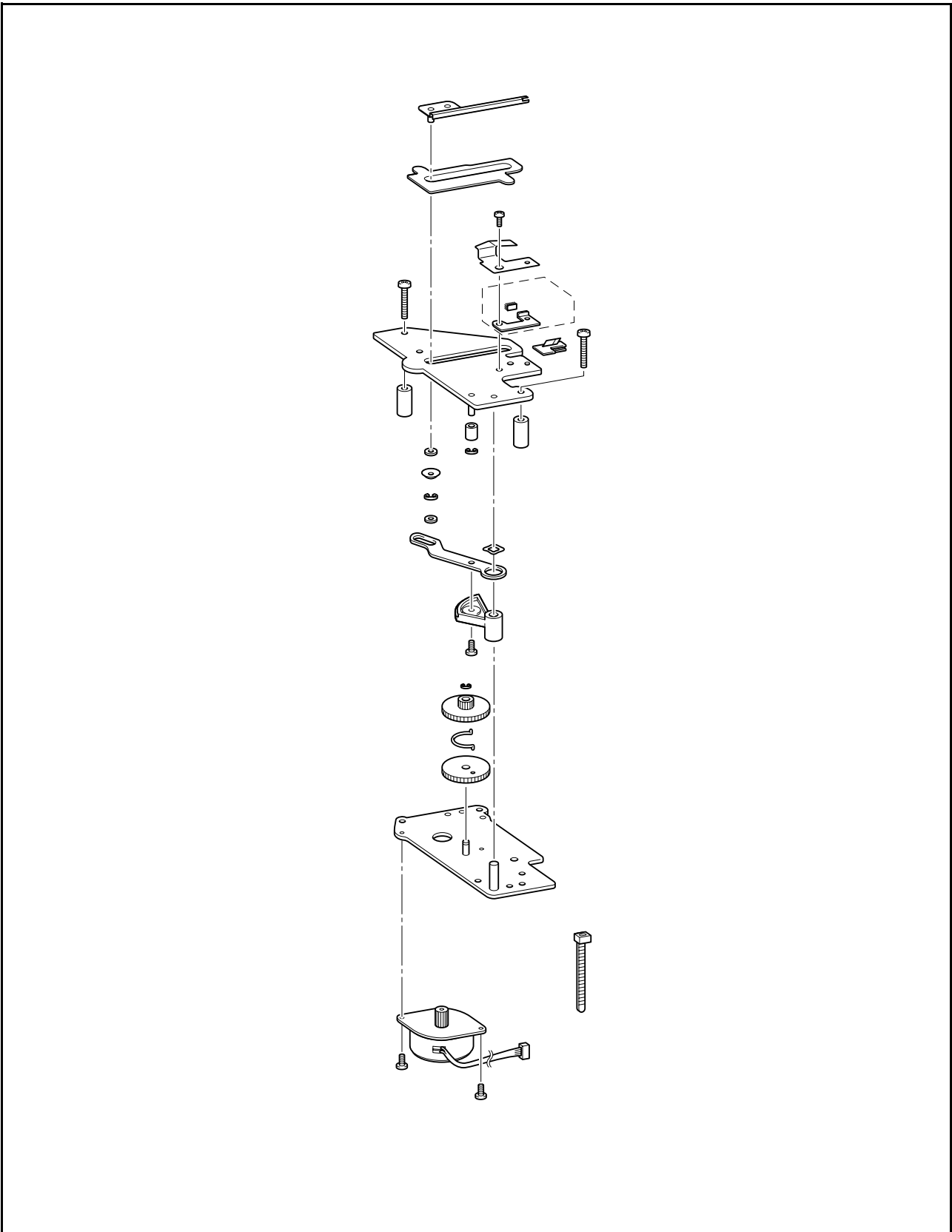
**12** Needle plate A assy. attachment

1. Attach the needle plate A ① using the 2 screws ❶.

❶		Screw M4	Torque 1.18 – 1.57 N·m
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Thread cutter module breakout diagram



### 1 C pulse motor attachment

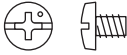
1. Attach the C pulse motor (ZPMM35SP-9N) ① to the motor holder assy ② using the 2 screws ①.

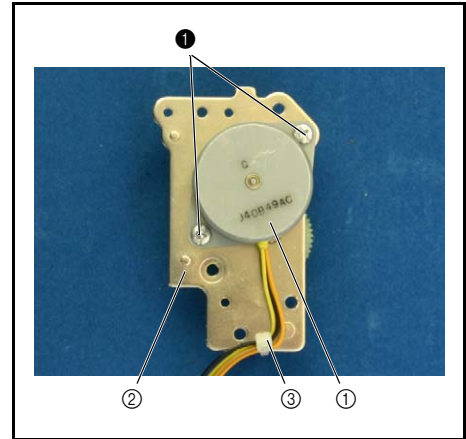
**\*Key point**

- Attach the band ③.

2. Lubricate the C pulse motor ① bearing with 1 – 2 drops of turbine oil # 100.

Lubricate the CPM bearing with FBK OIL RO 100.	1 – 2 drops XC8388***
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①		Screw, Band M3x4	Torque
			0.78 – 1.18 N·m



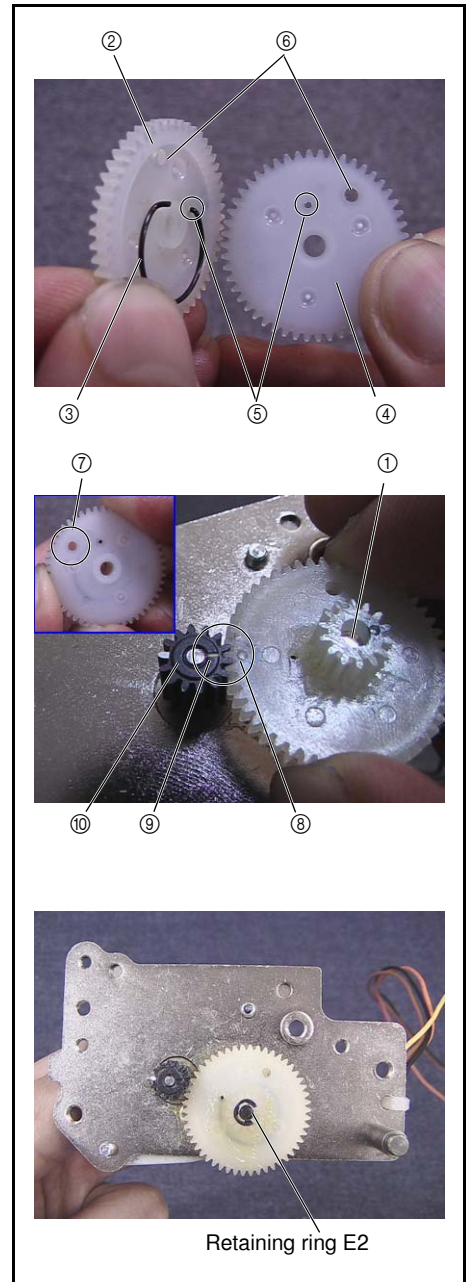
### 2 Idle gears A and B attachment

1. Apply a small amount of EPNOC AP(N)0 to the idle gear shaft ①.
2. Attach the idle gear A ②, spring ③ and idle gear B ④ to the idle gear shaft ①, and attach the retaining ring E2.

**\*Key point**


- Insert the spring ③ into the small holes ⑤ in the idle gear A ② and the idle gear B ④, and turn the idle gear A ② clockwise until the large holes ⑥ in the idle gear A ② and the idle gear B ④ overlap ⑦.
- With the large holes ⑥ aligned, align the match mark ⑧ on the idle gear assy and the match mark ⑨ on the C pulse motor gear ⑩, and attach the idle gear assy to the shaft ①.

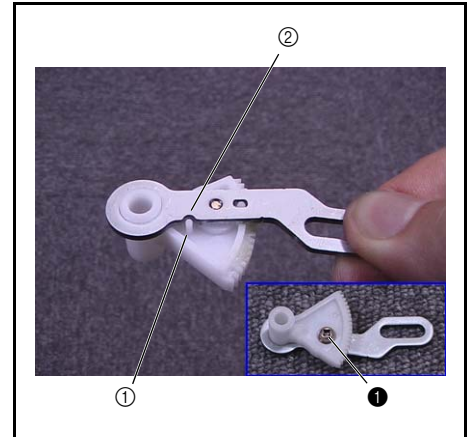
Apply EPNOC AP(N)0 to the lever guide shaft	Small amount XC8387***
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### 3 Assembling the thread cutter lever assy

1. Attach the thread cutter lever gear ① to the thread cutter lever ② using the screw ③.

<b>①</b>		Screw, Pan (SIP washer) M3X6DA	Torque 0.78 – 1.18 N·m
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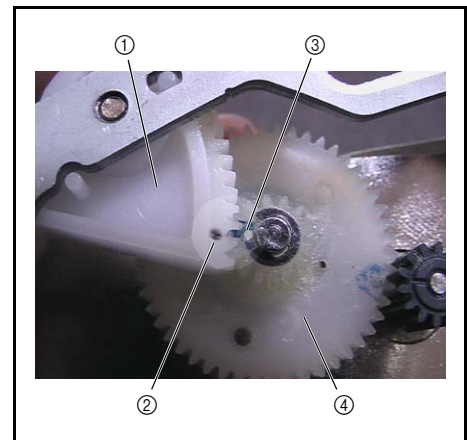
### 4 Thread cutter lever assy. attachment

1. Apply a small amount of EPNOC AP(N)0 to the thread cutter lever shaft.
2. Attach the thread cutter lever assy ① to the thread cutter lever shaft.

**\*Key point**

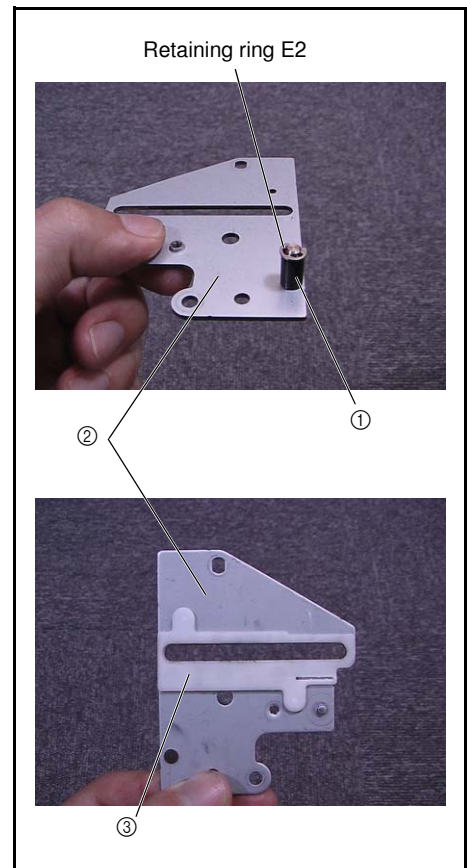
- Align the thread cutter lever assy ① match mark ② with the idle gear assy ④ match mark ③.

Apply a small amount of EPNOC AP(N)0 to the thread cutter lever shaft.	Small amount XC8387***
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### 5 Rubber and spacer attachment

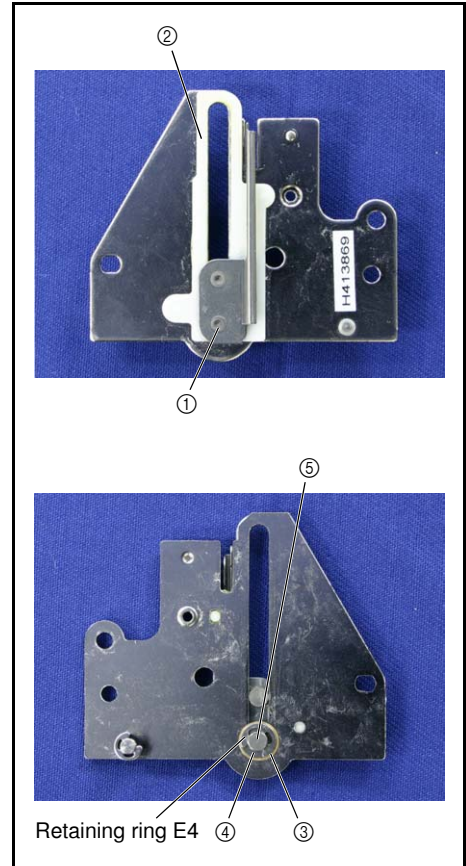
1. Attach the rubber ① to the thread cutter frame ② shaft, and attach retaining ring E2.
2. Attach the spacer ③ to the thread cutter frame ②.





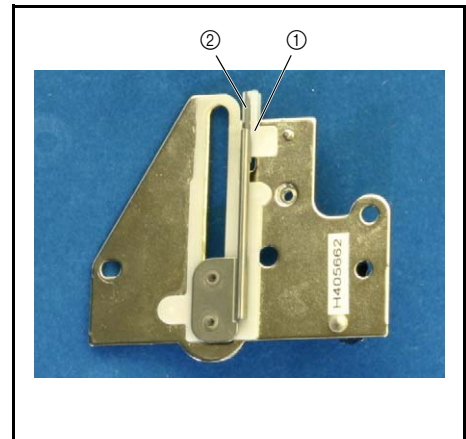
### 6 Assembling the thread hook assy

1. Attach the thread hook assembly ① to the spacer ②.
2. Attach the washer ③, polyester slider ④ to pin A ⑤, and then attach the retaining ring (E4).



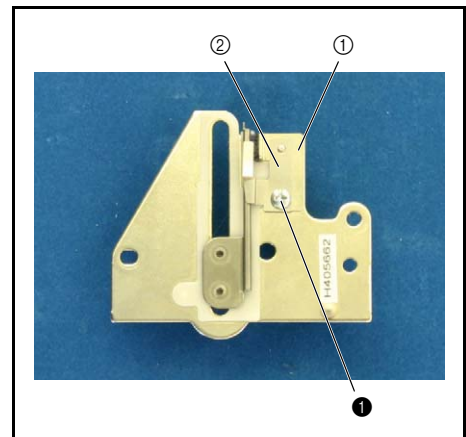
### 7 Cutter holder assembly attachment


1. Attach the NT lower thread cutter ② to the cutter holder assembly ①.
2. Engage the cutter holder assembly ① with the thread cutter frame.



### 8 Presser plate assy. attachment


1. Attach the spring ① and the presser plate assembly ② to the thread cutter frame with the screw ❶.

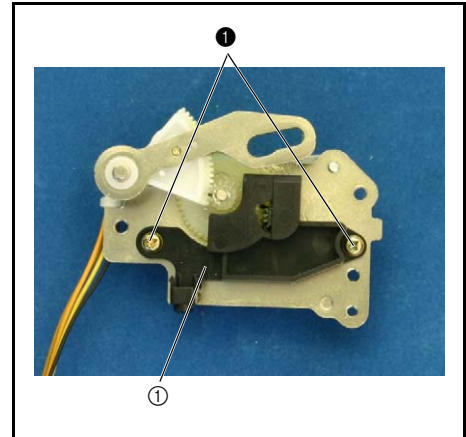


❶		Screw, Bind M3X4	Torque 0.78 – 1.18 N·m
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### 9 Sensor holder attachment

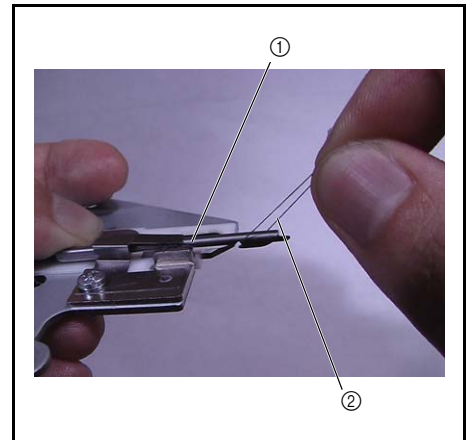
1. Attach the sensor holder ① with the 2 screws ❶.

❶		Screw, Pan (SIP washer) M3X6DA	Torque 0.78 – 1.18 N·m
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### 10 Thread cutter check

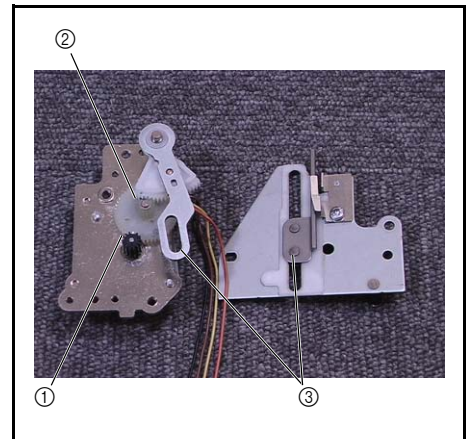
1. Pull the thread hook assy ① from the thread cutter frame assy.
2. Attach Schappe Spun Sewing Thread #30 ② to the end of the thread hook assy ①, and check that the thread is cut when the thread hook assy returns.



### 11 Grease applications

1. Apply a small amount of EPNOC AP(N)0 to the all of the operating surfaces ① of the idle gear assy. and C pulse motor gear.
2. Apply a small amount of EPNOC AP(N)0 to the all of the operating surfaces ② of the thread cutter lever gear and idle gear assy.
3. Apply a small amount of EPNOC AP(N)0 to the entire operating surface ③ of the thread cutter lever thread hook pin A.

Apply EPNOC AP(N)0 to the entire operating surfaces of idle gears A and B and the CPM gear.	Small amount XC8387***
Apply EPNOC AP(N)0 to the to the operating surfaces of the thread cutter lever gear and idle gears A and B	Small amount XC8387***
Apply EPNOC AP(N)0 to the operating surface of thread hook pin A	Small amount XC8387***


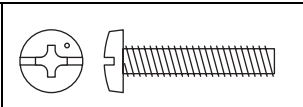


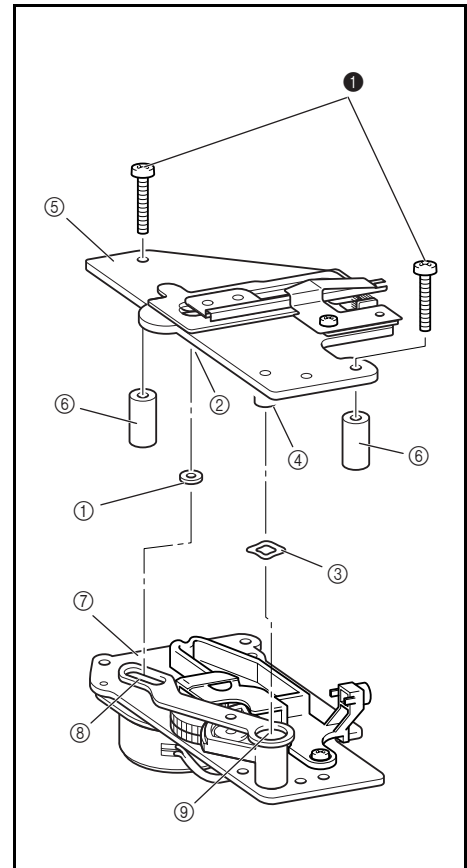
## 12 Thread cutter frame assembly attachment

1. Attach the polyester slider ① to thread hook pin A ②.
2. Attach the wave-shape spring washer ③ to the thread cutter lever shaft ④.
3. Attach the thread cutter frame assembly ⑤ and the 2 collars ⑥ to the motor holder assembly ⑦ with the 2 screws ①.

### \*Key point

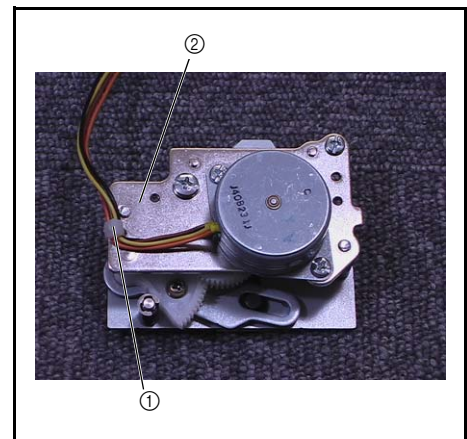
- Align the thread cutter lever shaft ⑧ with the reference hole ⑨ on thread cutter frame, and align thread hook pin A with the hole on the thread cutter lever.

		Screw, Bind M4X20	Torque 1.18 – 1.57 N·m
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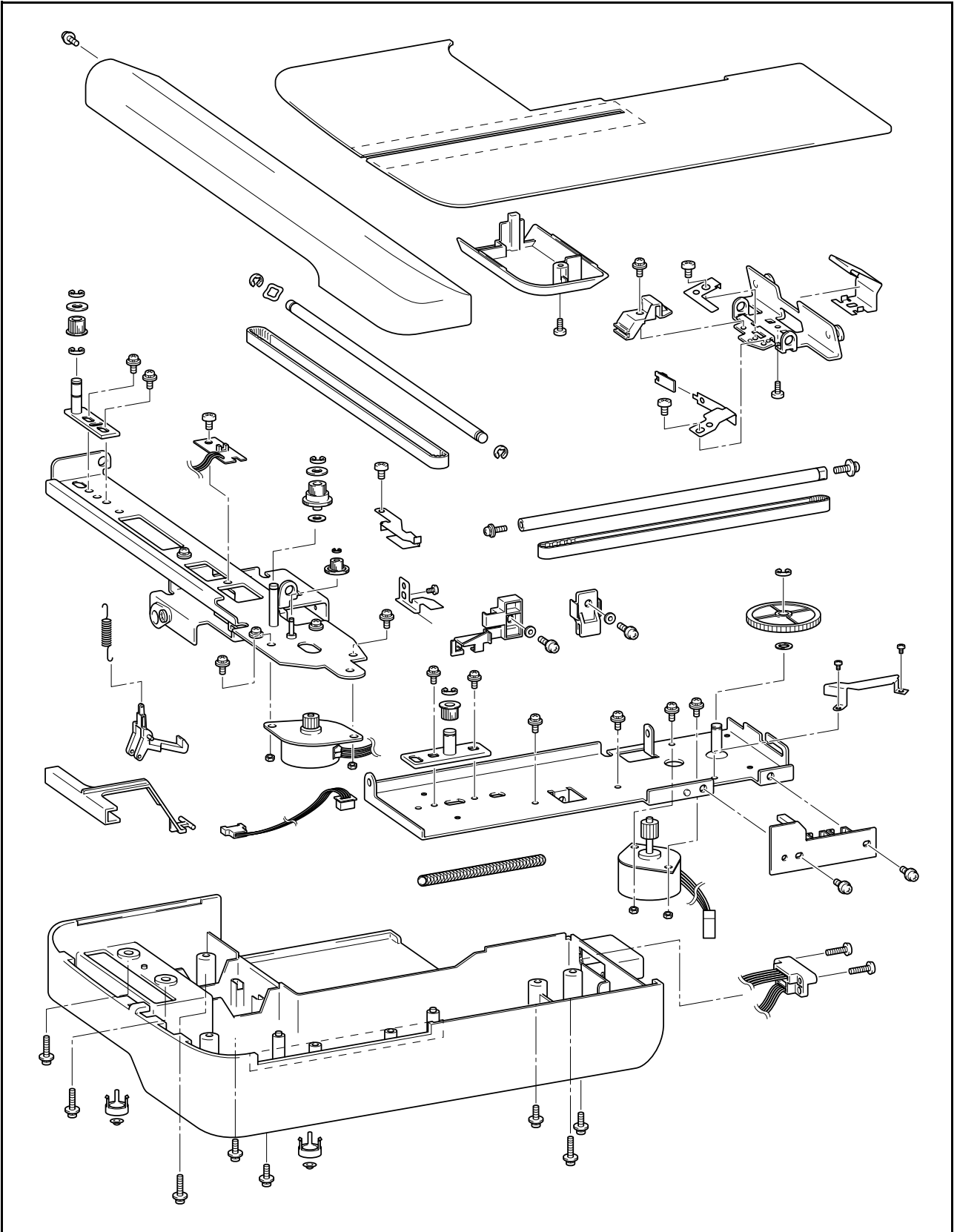


## 13 CPM lead processing

1. Attach the CPM leads to the motor holder ② using a band ①.



Embroidery parts location diagram




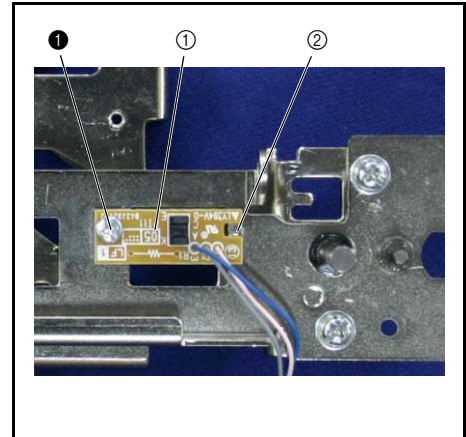
## 1 Y sensor PCB assembly attachment

1. Attach the Y sensor PCB assembly ① to the X carriage assembly with the screw ①.

### \*Key point

- Engage the tab ② on the X carriage assembly with the groove on the Y sensor PCB assembly ①.

①		Screw, Bind M3X4	Torque 0.59 – 0.79 N·m
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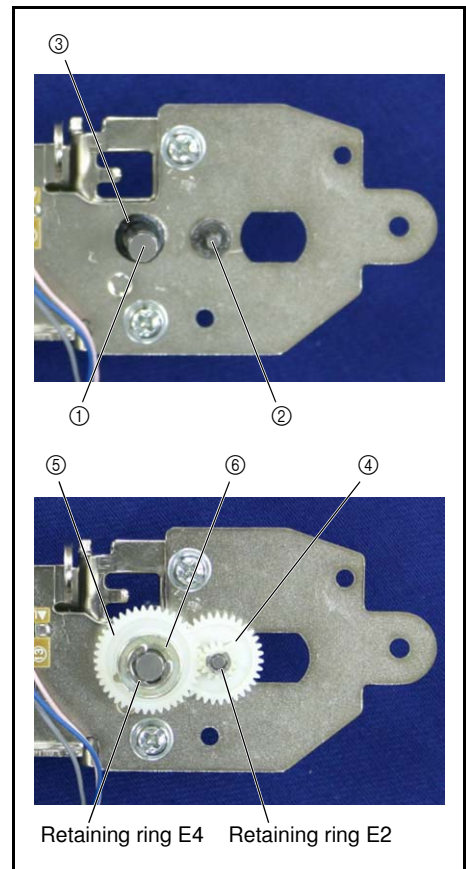


## 2 Y driving gear pulley assembly attachment

1. Apply a bead of EPNOC AP (N)0 to the 2 shafts ①② of the X carriage assembly.
2. Set the washer ③ onto the shaft ① of the X carriage assembly.
3. Set the gear ④ onto the shaft ② of the X carriage assembly, and then attach the retaining ring (E2).
4. Set the Y driving gear pulley ⑤ and then the plain washer (M6) ⑥ onto the shaft ① of the X carriage assembly, and then attach the retaining ring (E4).

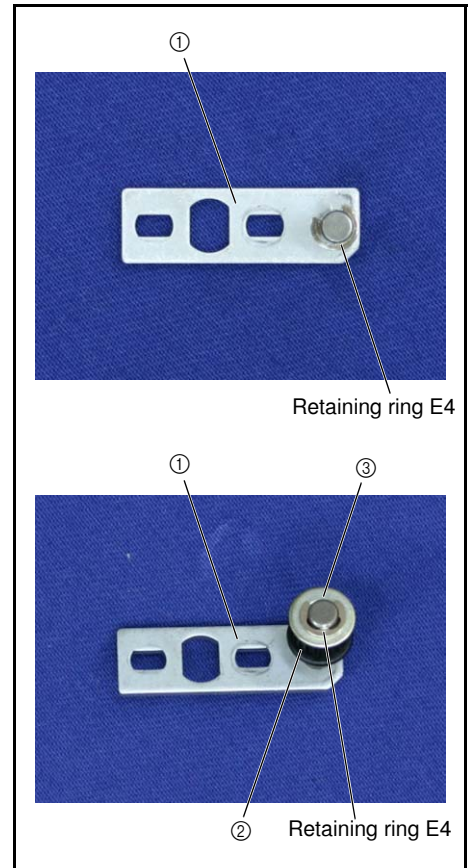
Apply EPNOC AP (N)0 to the 2 shafts of the X carriage assembly.

Bead  
XC8387\*\*\*



### 3 Y tension pulley assembly attachment

1. Attach the retaining ring (E4) to the shaft (lower groove) of the Y tension pulley assembly ①.
2. Set the tension pulley ② and the plain washer (M6) ③ onto the shaft of the Y tension pulley assembly ①, and then attach the retaining ring (E4).

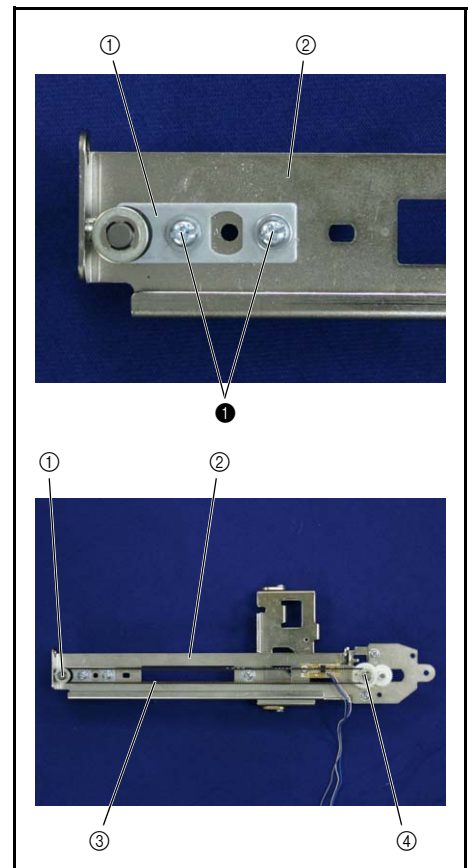



### 4 Y tension pulley assembly attachment

1. Temporarily attach the Y tension pulley assembly ① to the X carriage assembly ② with the 2 screws ①.
2. Hang one end of the timing belt ③ over the Y driving gear pulley ④, and the other end over the Y tension pulley assembly ①.

**\*Key point**

- Fully tighten the screws after adjustment.



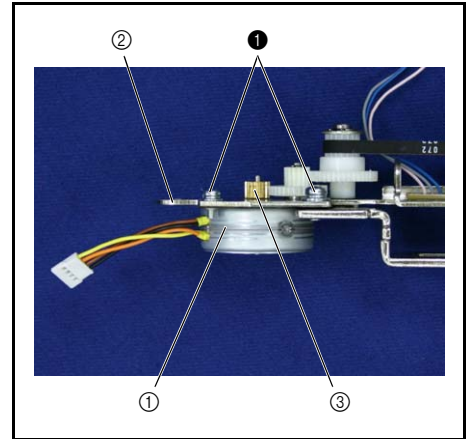
①		Screw, Pan (S/P washer) M4X8	Torque Hand tighten
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### 5 Y pulse motor assembly attachment



1. Apply 1 or 2 drops of FBK OIL RO 100 to the shaft of the Y pulse motor assembly ①.
2. Attach the Y pulse motor assembly ① to the X carriage assembly ② with the 2 screws ①.

**\*Key point**

- Position the X carriage assembly ② as shown in the photo on the right, and attach the Y pulse motor assembly ① with the gear ③ on the top.
- Check that the lead wire of the Y pulse motor assembly ① is on the left side.

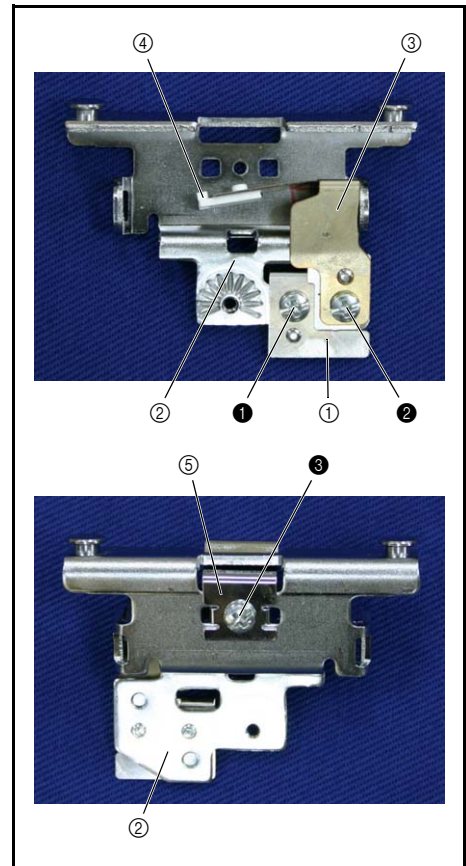




Apply FBK OIL RO 100 to the shaft of the Y pulse motor assembly.	1 - 2 drops XC8388***
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①			Screw, Pan (S/P washer) M3X7	Torque 0.79 – 1.18 N·m
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### 6 Y carriage ASSY assembly

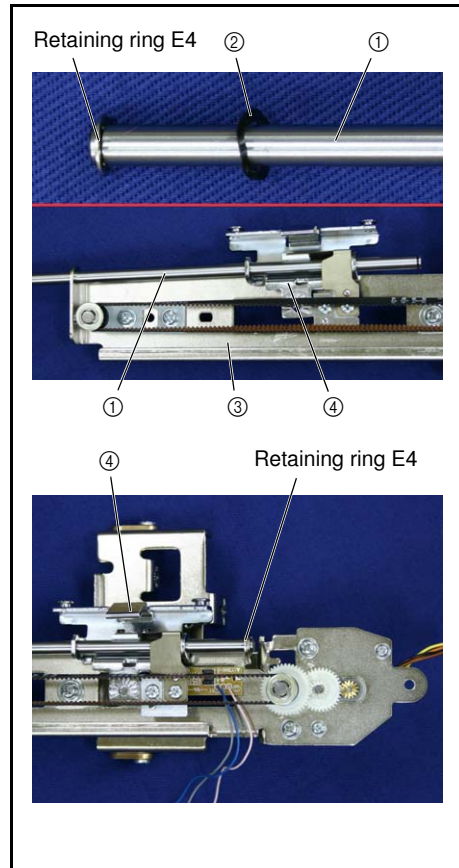
1. Attach the Y initial shutter ① to the Y carriage unit ② with the screw ①.
2. Attach the Y guide shaft presser ④ to the Y guide shaft presser plate ③, and then secure these to the Y carriage unit ② with the screw ②.
3. Attach the hoop fixed spring ⑤ to the Y carriage unit ② with the screw ③.



①			Screw, Bind M3X4	Torque 0.59 – 0.79 N·m
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## 7 Y carriage unit attachment

1. Attach the retaining ring (E4) to the Y guide shaft ①, and then attach the wave spring washer ② to the Y guide shaft ①.
2. Insert the Y guide shaft ① from the Y tension pulley assembly side of the X carriage assembly ③.
3. Set the Y carriage assembly ④ onto the Y guide shaft ①, and then push it to the YPM motor. Attach the retaining ring (E4).




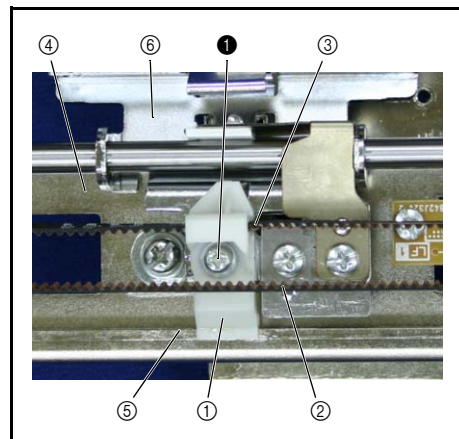
## 8 Y slider attachment

1. Insert the Y slider ① into the gear ③ of the timing belt ②.
2. Engage the groove on the Y slider ① with the rail ⑤ of the X carriage unit ④.
3. Slide the Y carriage unit ⑥ to align the Y slider ① with the screw hole on the Y carriage unit, and then secure these with the screw ①.

### \*Key point

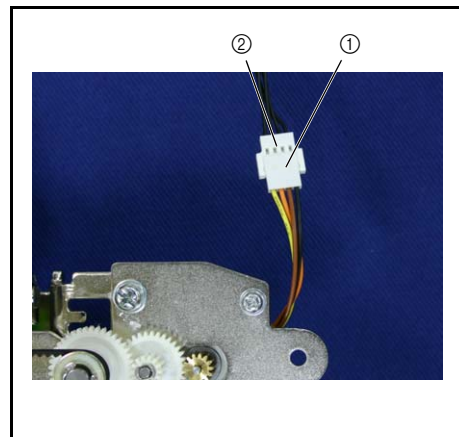
- Move the Y carriage unit ⑥ left and right to check that the timing belt ② moves accordingly.

①		Screw, Pan (S/P washer) M3X7	Torque 0.79 – 0.98 N·m
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## 9 Lead wire assembly YPM relay attachment

1. Connect the lead wire assembly YPM relay ② to the lead wire connector on the Y pulse motor assembly ①.



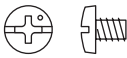


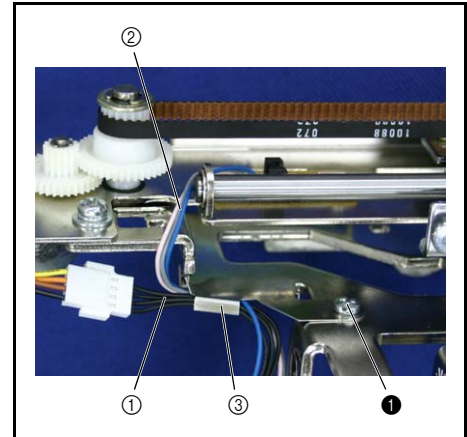
## 10 Cord guide attachment

1. Insert the lead wire assembly YPM relay ① and then the lead wire of the Y sensor PCB assembly ② into the groove on the cord guide ③, and then secure these with the screw ④.

### \*Key point

- Check that the lead wire assembly YPM relay ① and the lead wire of the Y sensor PCB assembly ② are routed as shown in the photo on the right.

④		Screw, Bind M3X4	Torque 0.79 – 1.18 N·m
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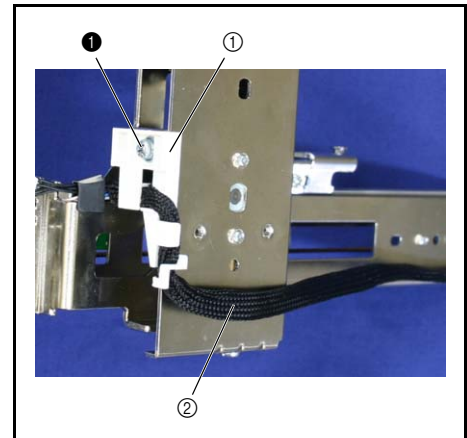
## 11 X slider attachment

1. Align the boss on the X slider ① with the oval hole on the bent section at the lower section of the X carriage assembly.
2. Temporarily tighten the screw ④.

### \*Key point

- Fully tighten the screw after the XY carriage unit has been attached.
3. Insert the lead wire into the nylon sleeve ②, and then attach the guide of the X slider ①.

④		Screw, Pan (S/P washer) M4X8	Torque Hand tighten
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## 12 X initial shutter attachment

1. Attach the X initial shutter ① with the screw ④.

### \*Key point

- The X initial shutter has sharp edges. Be careful when handling it.

④		Screw, Bind M4X6	Torque 1.18 – 1.57 N·m
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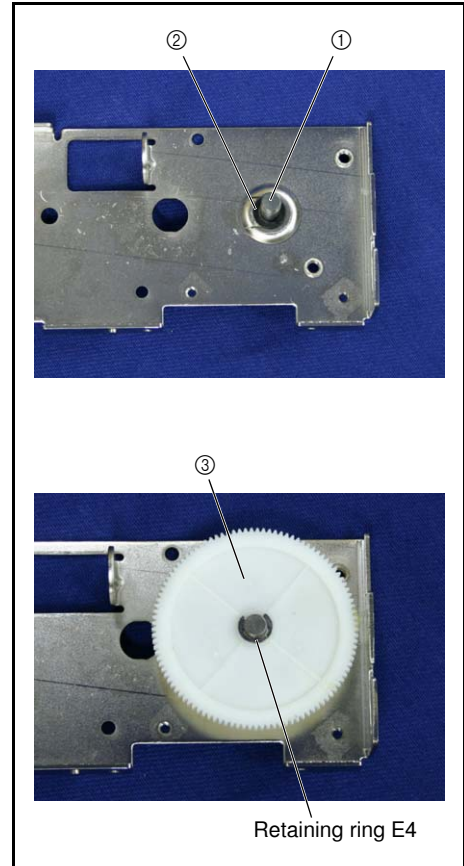


**13** X driving gear pulley attachment

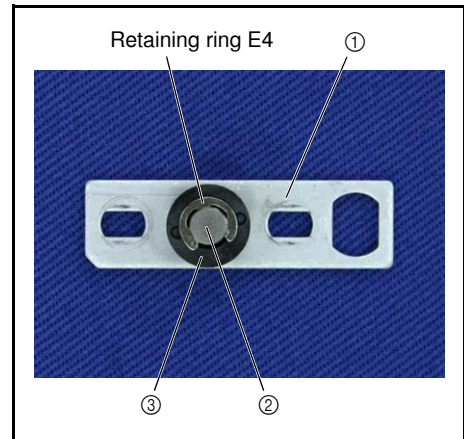
1. Apply a bead of EPNOC AP (N)0 to the shaft ① of the main frame subassembly.
2. Set the washer ② and the X driving gear pulley ③ onto the shaft ①, and then attach the retaining ring (E4).

Apply EPNOC AP (N)0 to the shaft of the main frame subassembly.
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bead XC8387***
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**14** X tension pulley ASSY assembly

1. Set the tension pulley ③ onto the shaft ② of the X tension pulley assembly ①, and then attach the retaining ring (E4).




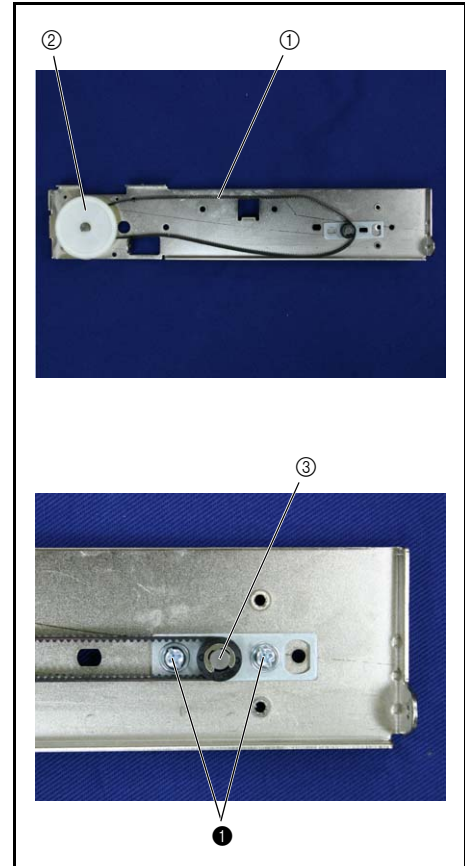
## 15 X tension pulley ASSY attachment

1. Hang one end of the timing belt ① over the X driving gear pulley ②, and the other end over the X tension pulley assembly ③.
2. Move the X tension pulley assembly ③ to the right, and then temporarily tighten the 2 screws ①.

### \*Key point

- Fully tighten the screws after adjustment.

①		Screw, Pan (SIP washer) M4X8	Torque Hand tighten
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## 16 X pulse motor assembly attachment

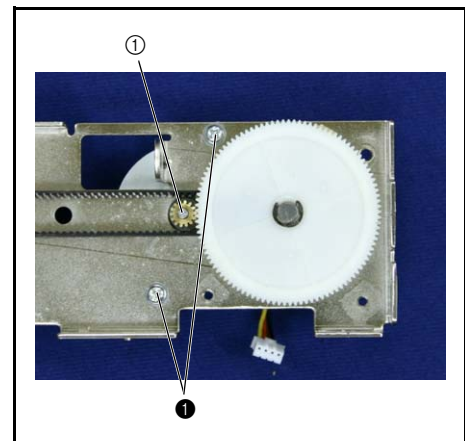
1. Apply 1 or 2 drops of FBK OIL RO 100 to the X pulse motor assembly.
2. Position the main frame unit as shown in the photo on the right, and then attach the X pulse motor assembly ① from the rear of the main frame unit with the gear on the top. Secure these with the 2 screws ①.

### \*Key point

- Check that the lead wire of the X pulse motor assembly ① is at the lower right .

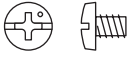
Apply FBK OIL RO 100 to the X pulse motor assembly.	1 - 2 drops XC8388***
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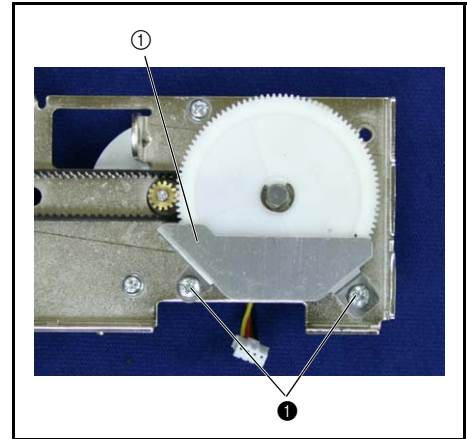
①		Screw, Pan (SIP washer) M3X7	Torque 0.79 – 1.18 N·m
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### 17 Oil guard plate attachment

1. Attach the oil guard plate ① to the main frame unit with the 2 screws ❶.

❶		Screw, Blind M3X4	Torque 0.79 – 1.18 N·m
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### 18 XY carriage unit removal

1. Position the XY carriage unit ① as shown in the photo on the right, and then insert the X guide shaft ②.

**\*Key point**

- Check that the cut face end ③ of the X guide shaft ② is on the left side.

2. Position the main frame unit ④ and the XY carriage unit ① as shown in the photo on the right.



**\*Key point**

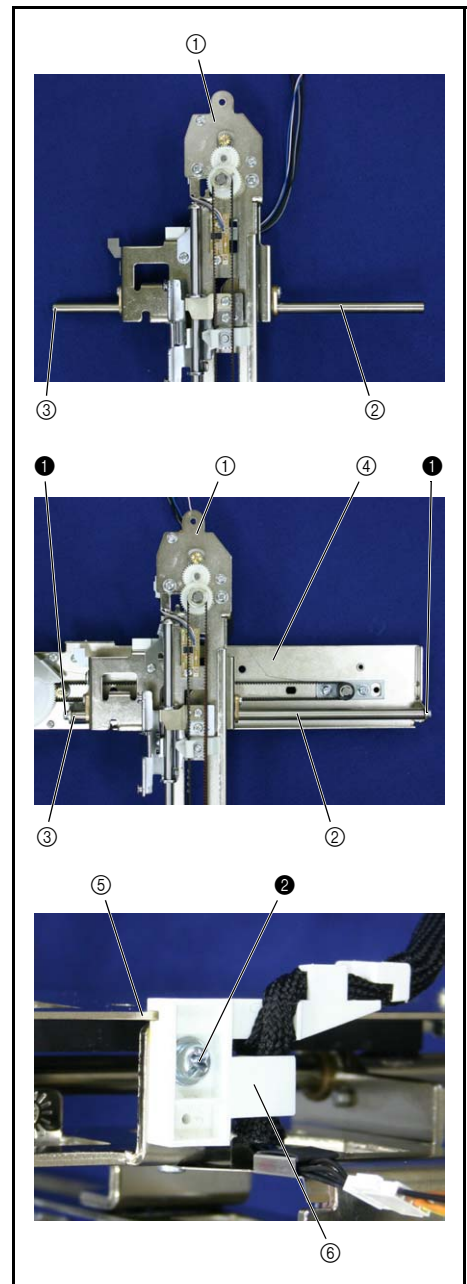
- Check that the cut face end ③ of the X guide shaft ② is on the left side.
- Check that the rail ⑤ of the main frame unit ④ is engaged with the groove on the X slider ⑥.

3. Attach the X guide shaft ② to the main frame unit ④ with the 2 screws ❶.

**\*Key point**

- Fully tighten the X slider securing screw ❷.

❶		Screw, Pan (S/P washer) M4X8	Torque 1.18 – 1.57 N·m
❷		Screw, Pan (S/P washer) M4X8	Torque 0.79 – 0.98 N·m




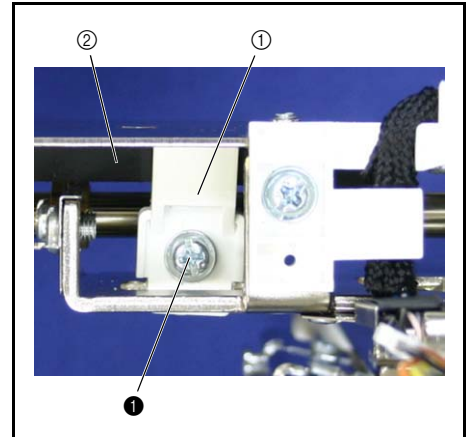
## 19 X belt presser removal

1. Insert the X belt presser ① into the gear of the timing belt ②.
2. Slide the XY carriage unit to align the round hole on the X belt presser ① with the screw hole on the XY carriage unit, and then secure these with the screw ③.

### \*Key point


- Move the XY carriage unit left and right to check that the timing belt ② moves accordingly.

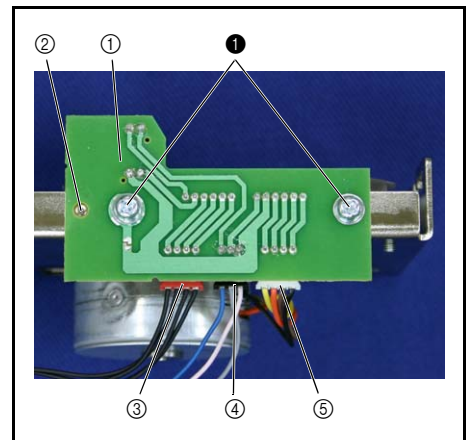
①		Screw, Pan (SIP washer) M4X8	Torque 0.79 – 0.98 N·m
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## 20 EMB relay PCB assembly attachment

1. Align the hole on the EMB relay PCB assembly ① with the boss ② on the main frame unit, and then secure these with the 2 screws ③.
2. Attach the lead wire assembly YPM relay ③, Y sensor PCB assembly lead wire ④, and XPM lead wire ⑤ to the EMB relay PCB assembly ①.

①		Screw, Pan (SIP washer) M3X7	Torque 0.79 – 0.98 N·m
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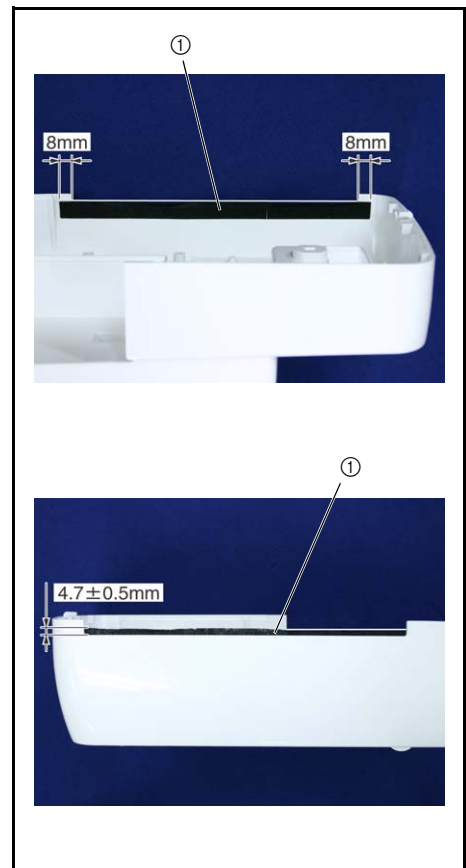


## 21 Groove cover attachment

1. Attach the groove cover ① to the ES base cover.

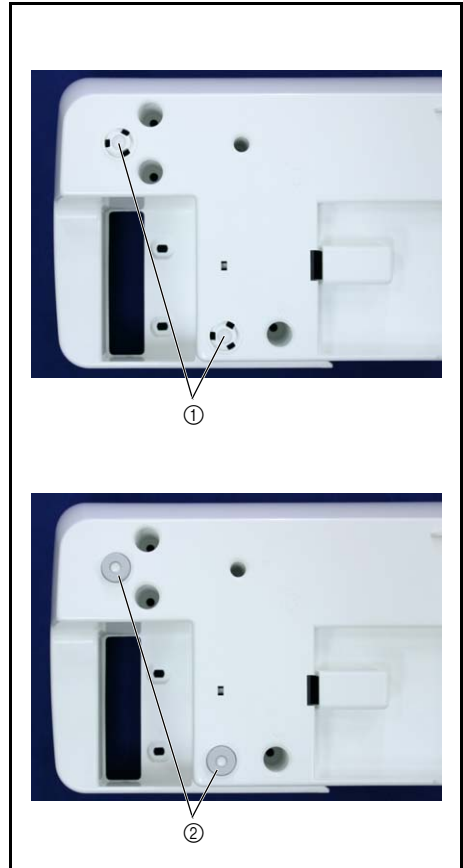
### \*Key point

- Refer to the two photos on the right for attachment of the groove cover ①.



**22** Rubber cushion and rubber cushion cover attachment

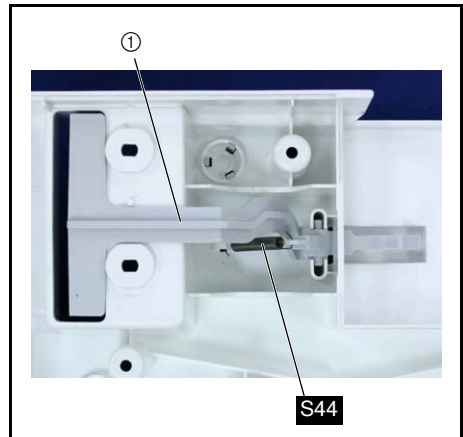
1. Attach the 2 rubber cushions ① to the ES base cover.
2. Insert the 2 rubber cushion covers ② into the attachment groove.

**23** Lock release lever ASSY assembly

1. Attach the lock finger ② to the lock release lever ①.

**24** Lock release lever assembly attachment

1. Attach the lock release lever assembly ① to the ES base cover unit.
2. Attach the spring **S44**.



S44

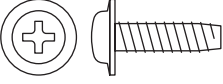


 SPRING  
 XC8096\*\*\*

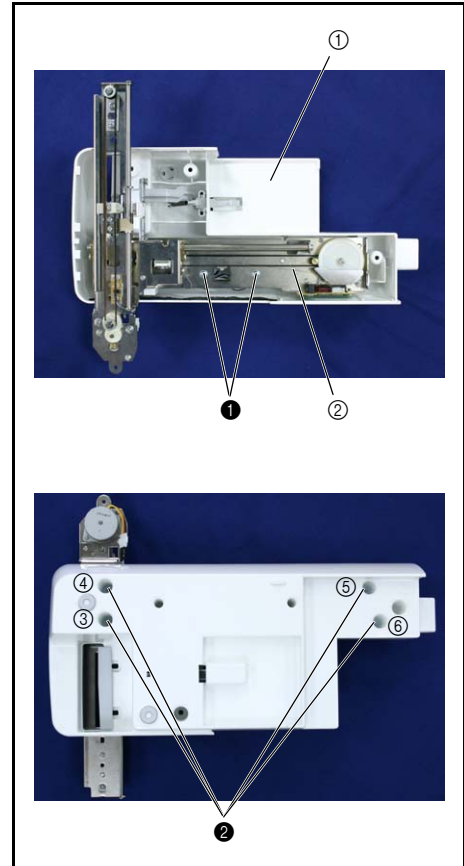
## 25 ES base cover unit attachment

1. Align the 2 positioning holes on the main frame unit ② with the 2 bosses at the center of the ES base cover unit ①.
2. Secure the ES base cover unit ① to the main frame unit ② with the 6 screws (①x2, ②x4).

### \*Key point

- Attach the 4 screws ② in the following sequence: ③ → ④ → ⑤ → ⑥.

①		Taprite, Cup B M4X14	Torque 0.79 – 1.18 N·m
②		Screw, Pan (S/P washer) M4X8	Torque 0.79 – 1.18 N·m

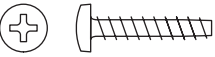


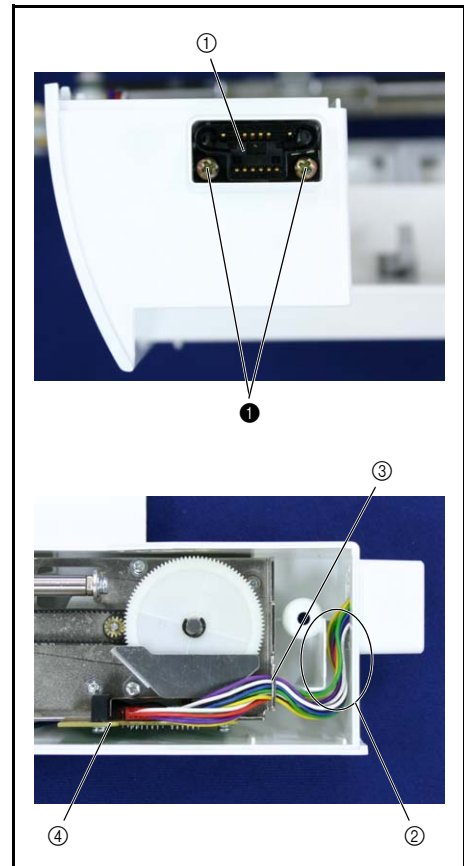
## 26 Lead wire assembly (EMB unit FCOMB) attachment

1. Pass the lead wires of the lead wire assembly EMB unit FCOMB ① through the hole on the ES base cover unit.
2. Attach the lead wire assembly ① to the ES base cover unit with the 2 screws ①.

### \*Key point

- Route the lead wires ① as shown in section ② in the photo, and then hang the lead wires onto the guide ③ of the main frame unit.
3. Attach the 2 connectors of the lead wire assembly ① to the EMB relay PCB assembly ④.

①		Taprite, Bind P M3X16	Torque 0.59 – 0.79 N·m
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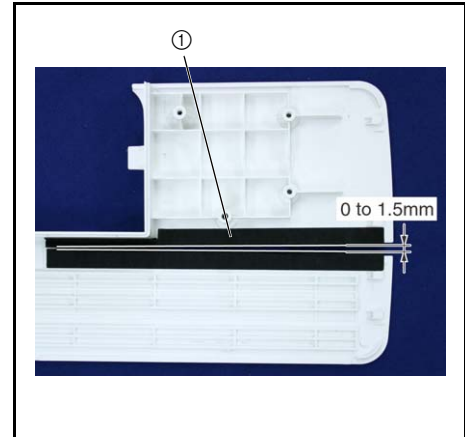


## 27 Groove cover attachment

1. Attach the groove cover ① to the ES main cover.

### \*Key point

- Refer to the photo on the right for attachment of the groove cover ①.

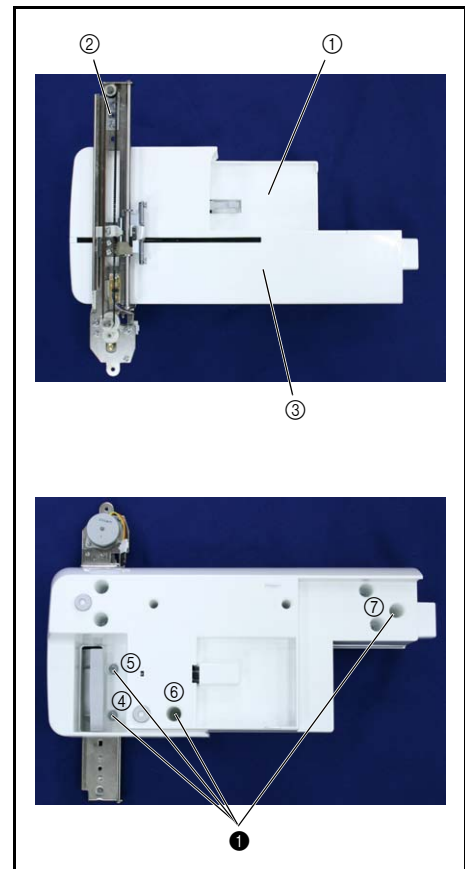


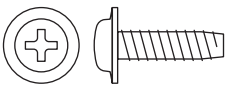
## 28 ES main cover assembly attachment

1. Position the ES base cover unit ① as shown in the photo on the right, and then slide the X carriage assembly ② to the left.
2. Slide the X carriage assembly ② along the slit on the ES main cover assembly ③ so that the X carriage assembly is fully engaged with the ES main cover assembly.
3. Secure the ES main cover assembly ③ with the 4 screws ①.

### \*Key point

- Attach the 4 screws ① in the following sequence: ④ → ⑤ → ⑥ → ⑦.
- Arrows are engraved on the outer surface of the base cover to indicate the locations of the 4 screws ①.



①		Taptite, Cup B M4X14	Torque 0.79 – 1.18 N·m
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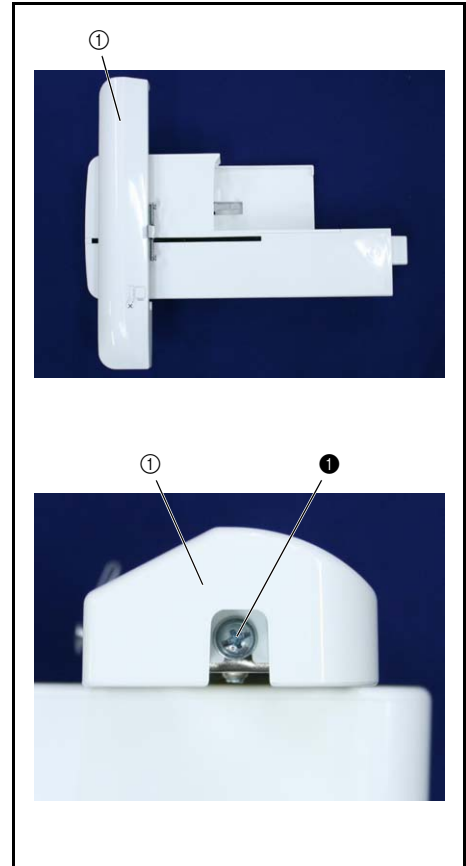
## 29 X carriage cover attachment

1. Position the X carriage cover ① so that it covers the X carriage assembly, and then temporarily tighten the screw ❶.

### \*Key point


- Fully tighten the screw after the YPM cover has been attached.

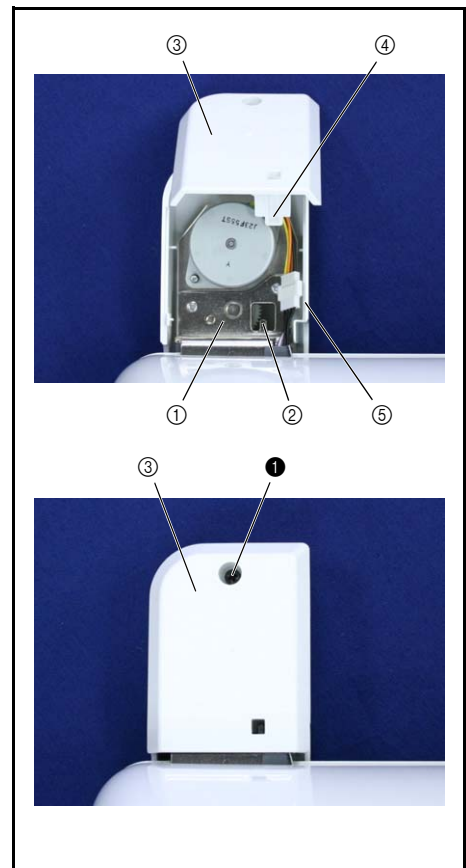
❶		Screw, Pan (SIP washer) M4X8	Torque 0.79 – 1.18 N·m
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## 30 YPM cover attachment

1. Align the tab ② on the X carriage assembly ① with the slot ④ on the YPM cover ③.
2. Secure the YPM cover ③ via the X carriage cover ⑤ to the X carriage assembly with the screw ❶.

❶		Taprite, Bind P M3X10	Torque 0.59 – 0.79 N·m
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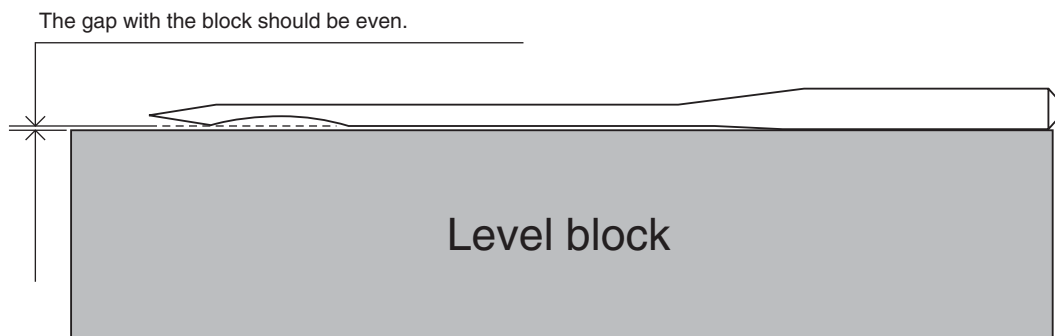


# 4 Adjustment

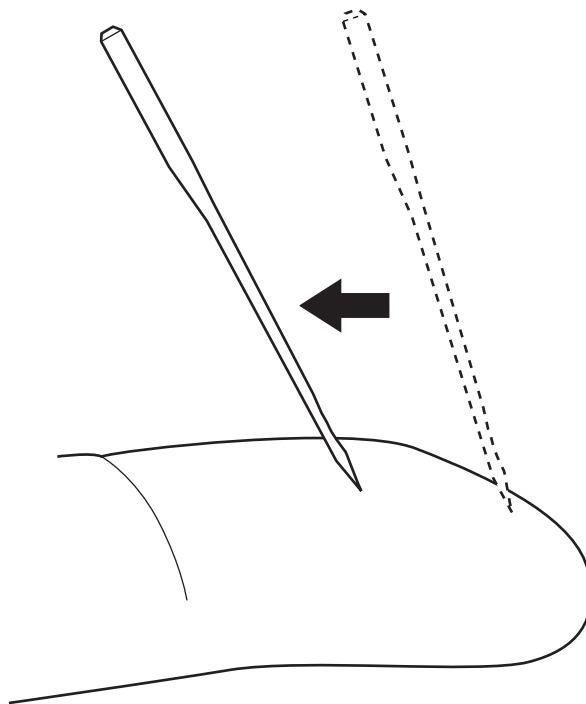
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Inspection	Needle point damage.....	4 - 2
Test Mode	Starting test mode.....	4 - 3
	List of the Test Mode .....	4 - 4
	Touch panel .....	4 - 5
Adjustment	Timing belt tension.....	4 - 6
	Motor belt tension .....	4 - 7
	Fine tension .....	4 - 8
	Upper thread tension .....	4 - 9
	Needle left/right position .....	4 - 10
	Needle bar rising.....	4 - 11
	Needle bar height.....	4 - 12
	Clearance between needle and rotary hook point....	4 - 13
	Needle threader .....	4 - 14
	Presser bar height.....	4 - 15
	Bobbin winder .....	4 - 16
	Needle and presser foot front/back position....	4 - 17
	Inner rotary hook bracket position.....	4 - 18
	Inner rotary hook assy. (lower thread) tension ....	4 - 19
	Belt tension (embroidery unit) .....	4 - 20
	Embroidery unit center position .....	4 - 21



1. Put needle on a level block, and check a needle is not bent.

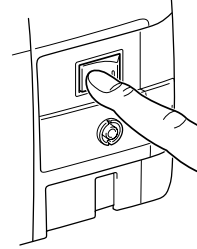
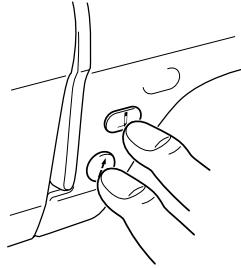


2. Slide a needle on your finger and check it moves smoothly (no damage on needle point).




1. Starting test mode


Turn on the power while pressing the  (Start/Stop button) and  (Needle position button), then test mode starts (test mode selection screen is displayed).



2. Starting and stopping operation

Press the  (Start/Stop button) on the front cover.

3. Return to test mode selection screen.

When the test mode stops, press the  (Back key) on the touch panel.

Test mode selection screen




1	2	3	4	5	6	7
8	9	10	11	12	13	14
15	16	17	18	19	20	21
22	23	24	25	26	27	28

Test Mode No.	Mode	Contents of test mode	Ref. page
1	Serial Numbers/Product ID	Serial number/Product ID and software version are displayed.	—
2	Embroidery position	Correct the initial position of embroidery by the 4 keys X direction (right and left) and Y direction (up and down). (-20 to +20)	4 - 21
3	Pattern adjustment	Not used	—
4	3-point needle drop	Not used	—
5	Needle clearance	Not used	—
6	Feed dog position	Not used	—
7	LCD contrast	Adjust the contrast of the LCD. (-10 to +10)	—
8	BH Forward/Backward count	Not used	—
10	Error display	Display the error message on the screen.	—
11	Sidfeed adjustment	Not used	—
12	Upper thread 1	Disable detection function of upper thread/lower thread. (Effective once when turning on at the next time.)	—
13	Forward and reverse feed	Not used	—
14	Speed	Running the machine with the maximum speed.	—
15	Power	Running the machine with the maximum electric power.	—
16	Switch monitoring	Check ON/OFF of each switch with buzzer. (BW-SW)	—
19	Creating memory/Clearing counter	When press the OK key of "CLEARING FLASH", the pattern that saved at sewing is deleted. When press the OK key of "CLEARING COUNTER", the service stitch counter is reset.	—
20	Stitch count	Display the total stitch count on the screen.	—
21	Input check	Display the each switch and sensor state on the screen. (+1: ON, 00: OFF)	—
22	NP sensor	Check upper shaft angle with buzzer ON/OFF	—
23	Embroidery max position	Trace the maximum size of embroidery.	—
24	LCD check	Check display state of LCD.	—
25	Tension adjustment	When the utility sewing, set up the correction value of the thread tension. (-8 to +8) When the embroidery sewing, set up the correction value of the thread tension. (-8 to +8)	—
26	XY wave table check	Not used	—
27	VR AD check	Display speed VR and foot controller AD value. Display target and actual rotation speed of upper shaft.	—
28	EEPROM USB HOST write	Not used	—

## [Adjustment standard]

Touch the 5 point in order from 1 to 5, and then "SUCCESS" is displayed.

## [Adjustment procedure]

1. Turn the power on while pressing the  (Start/Stop button),  (Needle position button), and  (Thread cutter button).
2. Touch the point "x" in order from 1 to 5.

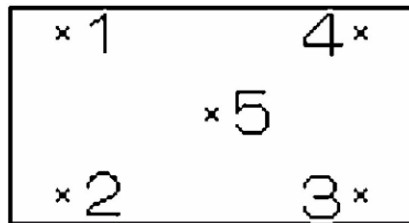
**\*Key point**

- Adjustment finishes when "SUCCESS" is displayed after pressing "5".
- Adjust again when "ERROR" is displayed after pressing "5".

**\*Note**

- Use included touch pen.  
Do not use acute hard tip one, otherwise touch panel will be damaged.
3. Turn the power off and on again. Check touch panel work correctly.

## Touch panel position adjustment screen



**[Adjustment standard]**

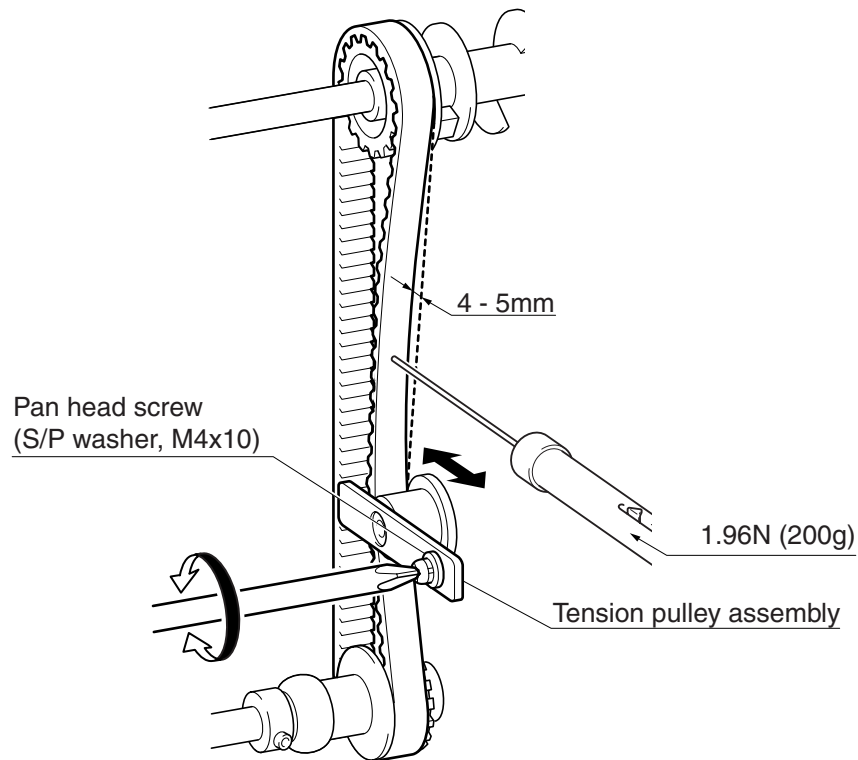
4 to 5mm slack by pushing the center of the belt with a force of 1.96N (200g).

**[Adjustment procedure]**

1. Remove the covers, the motor PCB and PCB holder.
2. Loosen the pan head screw (S/P washer, M4x10) of the tension pulley assembly.
3. Adjust the tension pulley assy. forward and back so that there should be 4 to 5mm slack in the timing belt when the center of the belt is pressed with a force of 1.96N (200g).
4. Tighten the pan head screw (S/P washer, M4x10) of the tension pulley assembly. (tightening torque: 1.18 to 1.57N·m)

XC2277001

Push-pull gauge (3N)



## [Adjustment standard]

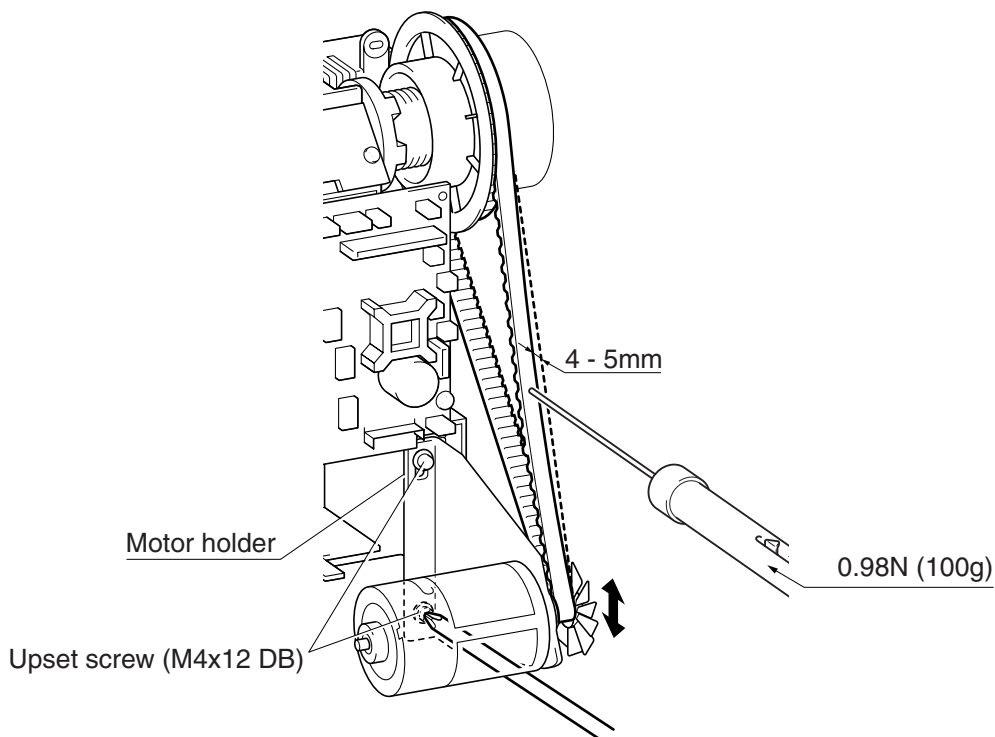
4 to 5mm slack by pushing the center of the belt with a force of 0.98N (100g).

## [Adjustment procedure]

1. Remove the front cover assy..
2. Loosen the 2 upset screws (M4x12 DB) of the motor holder.
3. Adjust the motor holder up and down so that there should be 4 to 5mm slack in the timing belt when the center of the belt is pressed with a force of 0.98N (100g).
4. Tighten the 2 upset screws (M4x12 DB) of the motor holder. (tightening torque: 1.18 to 1.57N·m)

XC2277001

Push-pull gauge (3N)





**[Adjustment standard]**

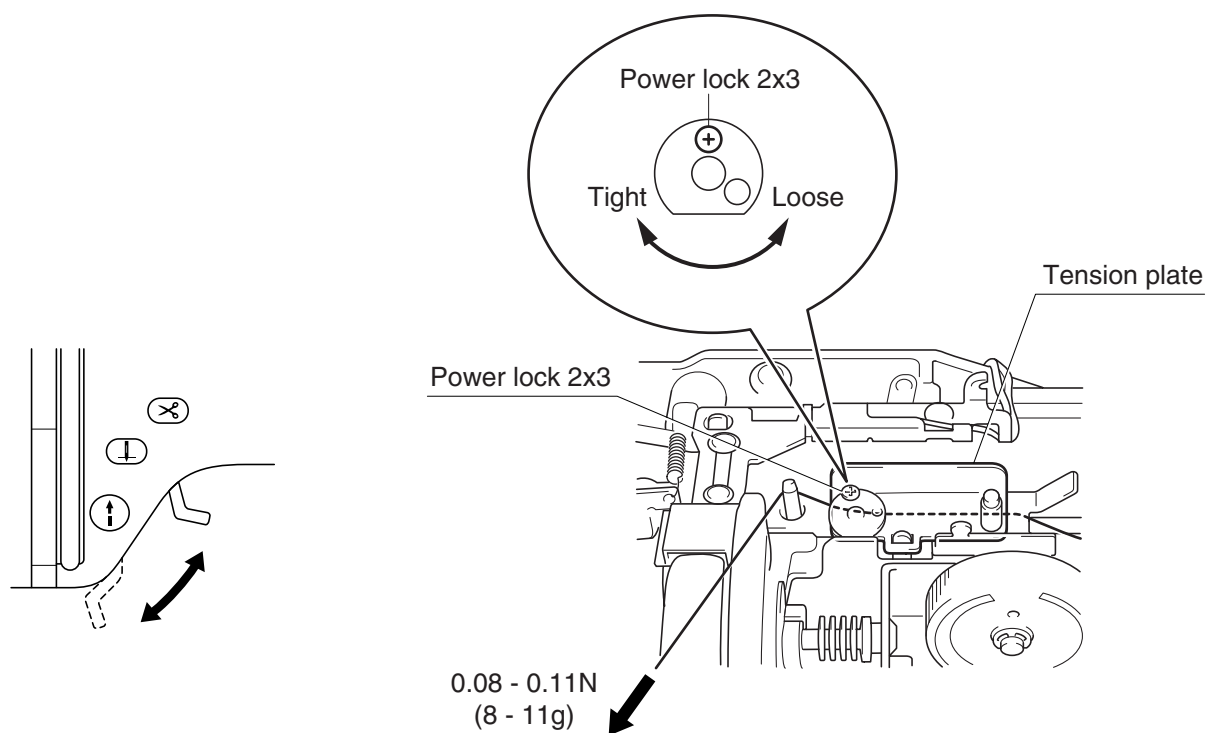
Pass the schappe spun thread #60 through tension plate and pull it by tension gauge, then adjust tension must be in 0.08 to 0.11N (8 to 11g).

**[Adjustment procedure]**

1. Remove the front thread guard cover.
2. Raise the presser foot lever.
3. Pass the schappe spun thread #60 through the thread guide and then tension plate.
4. Lower the presser foot lever.
5. Pull the thread by a tension gauge, and turn the power lock (2x3) and adjust the tension to 0.08 to 0.11N (8 to 11g).

XA9153001

Tension gauge 30 (0.3N)



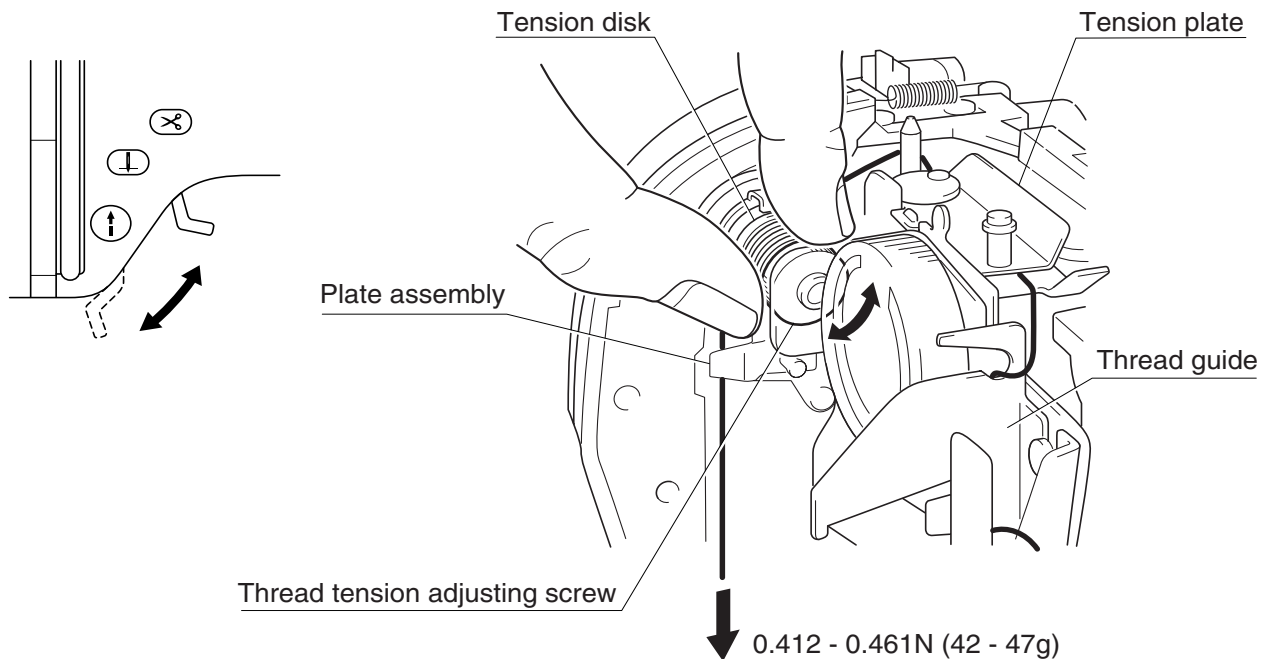
**[Adjustment standard]**

Start test mode, pass the schappe spun thread #60 through the thread guide, tension plate, tension disk and plate assembly, and pull it by tension gauge, then adjust tension must be in 0.412 to 0.461N (42 to 47g).

**[Adjustment procedure]**

1. Remove the embroidery unit from the machine.
2. Remove the front thread guard cover.
3. Start the test mode (AT pulse motor initializes).
4. Raise the presser foot lever.
5. Pass the schappe spun thread #60 through the thread guide, tension plate, tension disk and plate assembly in this order.
6. Lower the presser foot lever.
7. Pull the thread by a tension gauge, and turn the thread tension adjusting screw, and adjust the tension to 0.412 to 0.461N (42 to 47g).
8. Apply a small amount of thread locker to thread tension adjusting screw.

Thread locker for thread tension adjusting screw	Small amount
XA9154001	Tension gauge 50 (0.5 N)

**\*Key point**

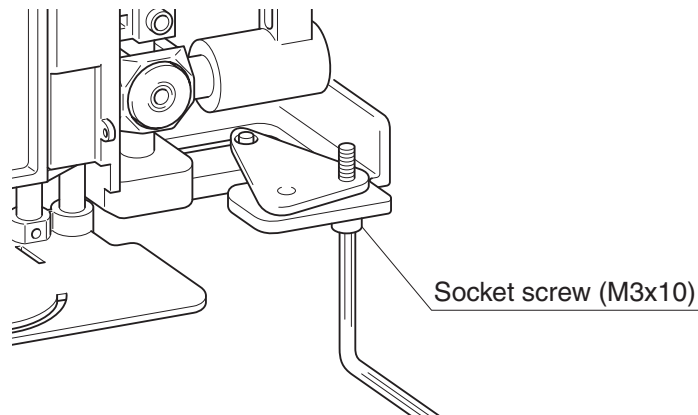
- Before adjusting, remove the embroidery unit.

**[Adjustment standard]**

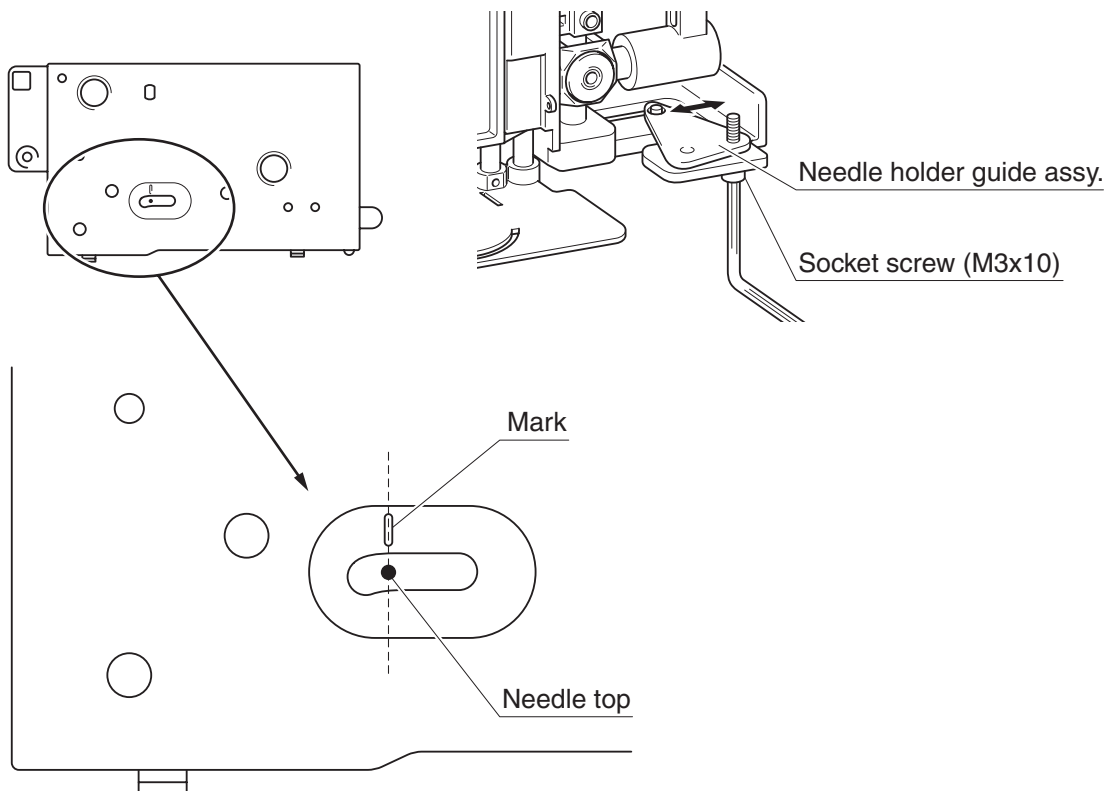
The needle top must drop in the mark area on the needle plate A.

**[Adjustment procedure]**

1. Remove the presser foot.
2. Attach the size 75/11 needle.
3. Turn the pulley by hand, and insert the needle top into the needle plate hole.
4. Loose the socket screw (M3x10).



5. Move the needle holder guide assy. left and right and adjust the needle top drops in the mark area on the needle plate A.



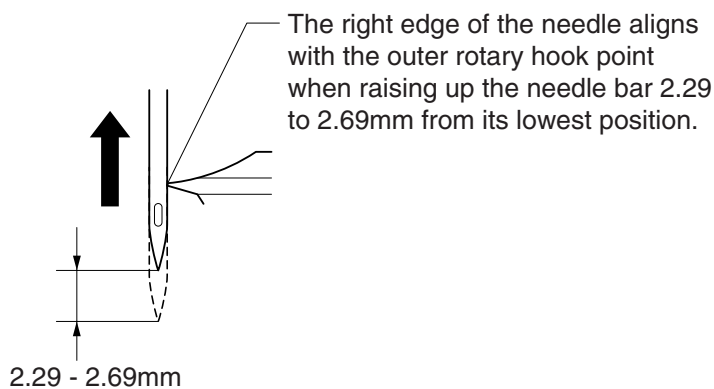
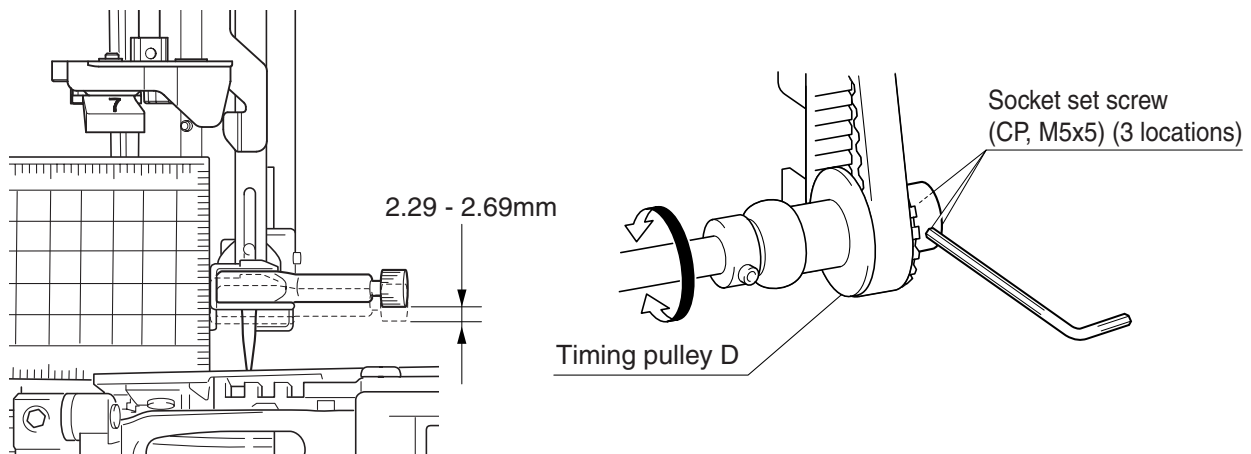
6. Tighten the socket screw (M3x10). (tightening torque: 0.78 to 1.18N·m)

**[Adjustment standard]**

The right edge of the needle aligns with the outer rotary hook point when raising up the needle bar 2.29 to 2.69mm from its lowest position.

**[Adjustment procedure]**

1. Start the test mode, and then select the "4" (3-point needle drop mode).
2. Press the [ ← ] button on the screen, then the needle moves to the left, and turn the power off.
3. Remove the front cover assy..
4. Remove the presser foot, the needle plate B and the needle plate A, and then remove the inner rotary hook assy..
5. Attach the size 75/11 needle.
6. Turn the pulley by hand and move the needle to its lowest position.
7. Loosen the 3 socket set screws (CP, M5x5) of the timing pulley D.
8. Turn the outer rotary hook by hand and adjust the right edge of the needle aligns with the outer rotary hook point when raising up the needle bar 2.29 to 2.69mm from its lowest position.
9. Tighten the 3 socket set screws (CP, M5x5) of the timing pulley D. (tightening torque: 1.37 to 1.79N·m)



**[Adjustment standard]**

When turn the pulley by hand until the right edge of the needle aligns with the outer rotary hook point, the clearance between the top of the needle eye and the outer rotary hook point is 1.6 to 2.0mm.

**[Adjustment procedure]**

1. Start the test mode, and then select the “4” (3-point needle drop mode).
2. Press the [ ← ] button on the screen, then the needle moves to the left, and turn the power off.
3. Remove the face plate assy. and the thread guide.
4. Remove the presser foot, the needle plate B and the needle plate A, and then remove the inner rotary hook assy..
5. Attach the size 75/11 needle.
6. Turn the pulley by hand until the right edge of the needle aligns with the outer rotary hook point.
7. Loosen the socket set screw (CP, M4x4) of the needle bar block.
8. Move the needle bar up and down, and adjust the clearance between the upper edge of the needle eye and the outer rotary hook point to 1.6 to 2.0mm.

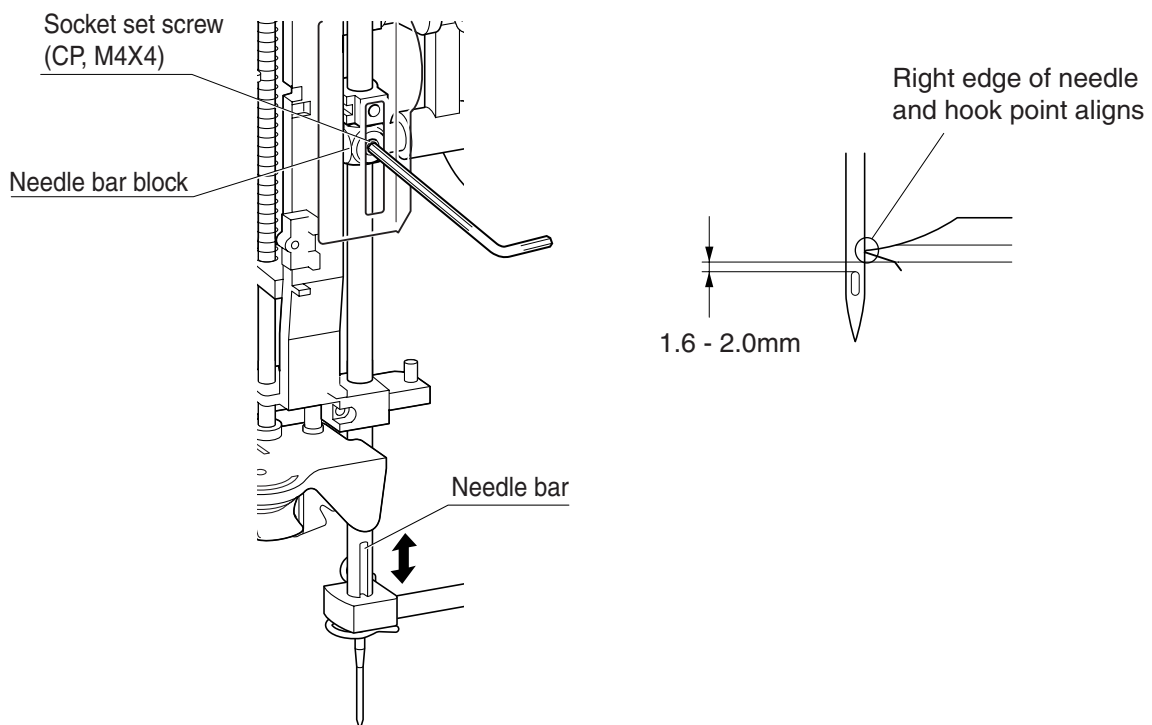
**\*Note**

- Check the socket set screw (CP, M4x4) faces front.

9. Tighten the socket set screw (CP, M4x4) of the needle bar block. (tightening torque: 0.78 to 1.18N· m)

**\*Key point**

- Need to adjust “4-14 Needle threader” after this adjustment.



## [Adjustment standard]

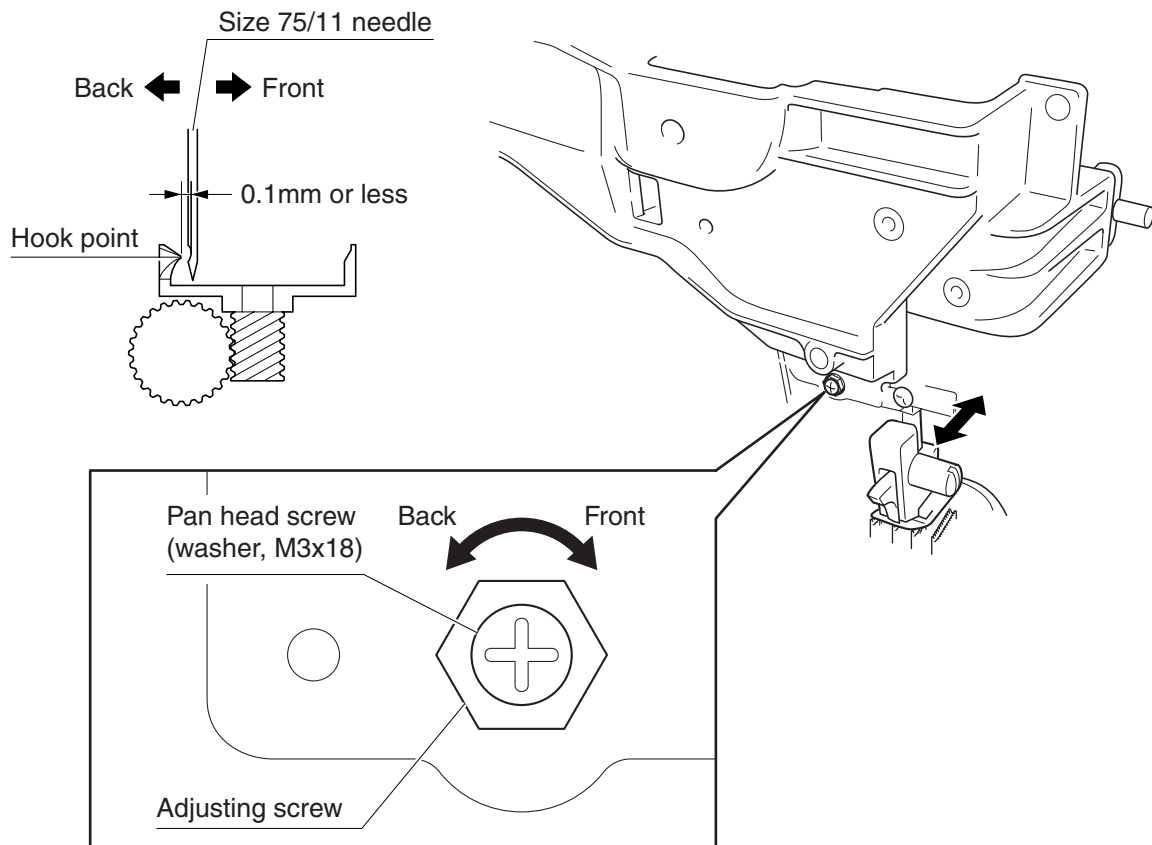
The clearance between the needle and the outer rotary hook point (front and back) is 0.1mm or less.

## [Adjustment procedure]

1. Remove the face plate assy..
2. Remove the presser foot, the needle plate B and the needle plate A, and then remove the inner rotary hook assy..
3. Attach the size 75/11 needle.
4. Loosen the pan head screw (washer, M3x18).
5. Turn the pulley by hand until the right edge of the needle aligns with the outer rotary hook point.
6. Turning the adjusting screw, adjust the clearance between the needle and the outer rotary hook point (front and back) to 0.1mm or less.
7. Tighten the pan head screw (washer, M3x18). (tightening torque: 0.78 to 1.18N· m)

XE2395001

Box driver 6



**[Adjustment standard]**

When passing the hook into the needle eye, the clearance between the upper edge of the hook and the upper edge of the needle eye is 0mm.

**[Adjustment procedure]**

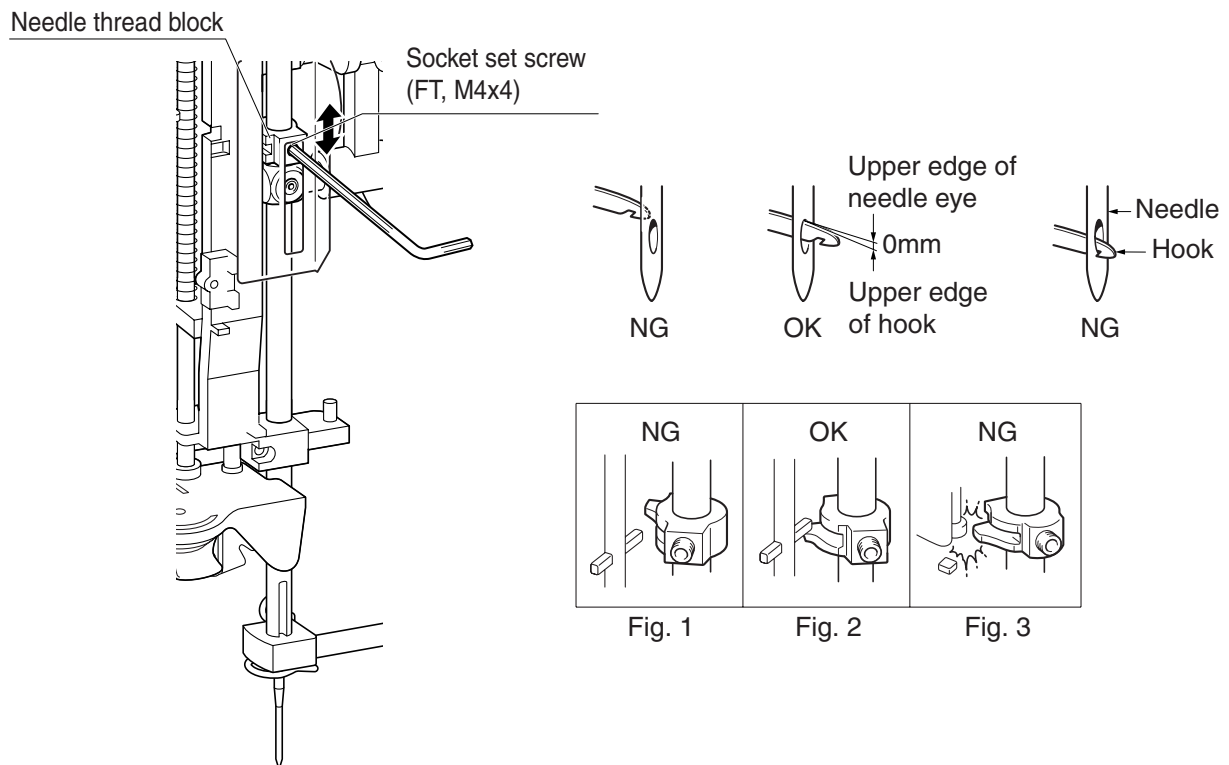
1. Remove the face plate assy..
2. Attach the size 75/11 needle.
3. Turn the pulley by hand to raise the needle bar to its highest position.
4. Loosen the socket screw (FT, M4x4), then move the needle thread block up and down and adjust the clearance between the upper edge of hook and the upper edge of the needle eye is 0mm. After that, tighten the socket set screw (FT, M4x4). (tightening torque: 0.78 to 1.18N·m)

**\*Key point**

- Tighten the socket set screw (FT, M4x4) at the position slightly to the left when viewed from the front of the machine. (Fig.2)

**\*Note**

- In case the position of the socket set screw (FT, M4x4) is too left, the hook doesn't turn. (Fig.1)
- In case the position of the socket set screw (FT, M4x4) is too right, the needle thread block contacts the needle bar supporter assy., and get damaged. (Fig.3)



## [Adjustment standard]

When the presser foot is lower, the clearance between the needle plate A and bottom surface of the presser foot is 1.5 to 2.5mm.

## [Adjustment procedure]

1. Remove the face plate assy..
2. Raise the presser foot lever.
3. Loose the stud screw (M5) of the presser bar clamp.
4. Lower the presser foot lever.
5. Turn the pulley by hand and insert the needle top into the presser foot hole.
6. Move the needle bar up and down, and adjust the clearance between the needle plate A and bottom surface of the presser foot is 1.5 to 2.5mm.
7. Raise the presser foot lever, and tighten the stud screw (M5) of the presser bar clamp.  
(tightening torque: 1.18 to 1.57N·m)

**\*Key point**

- Adjust the clearance (left/right) between the needle and the left edge of the presser foot hole to 2.4 to 2.8mm. (Fig. 1)

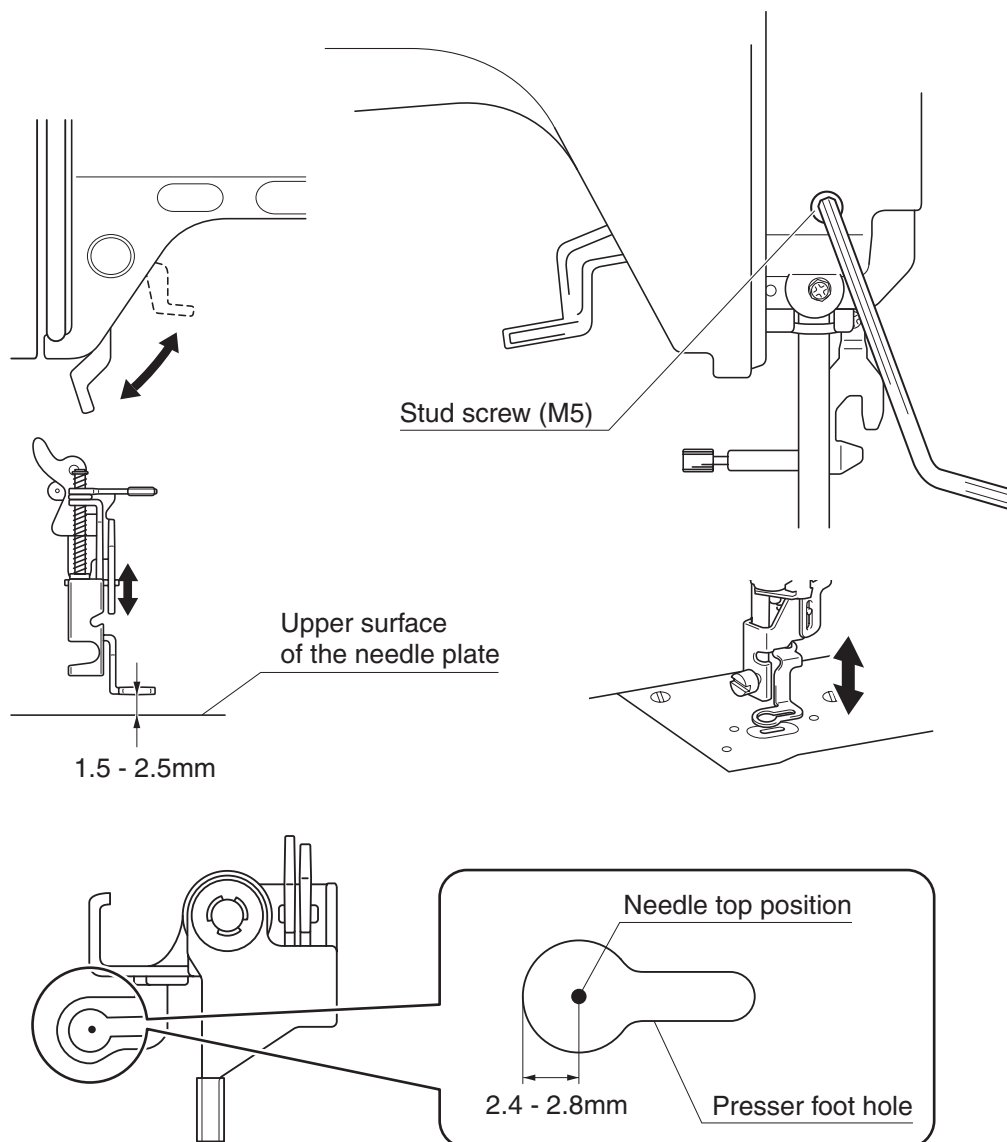


Fig. 1

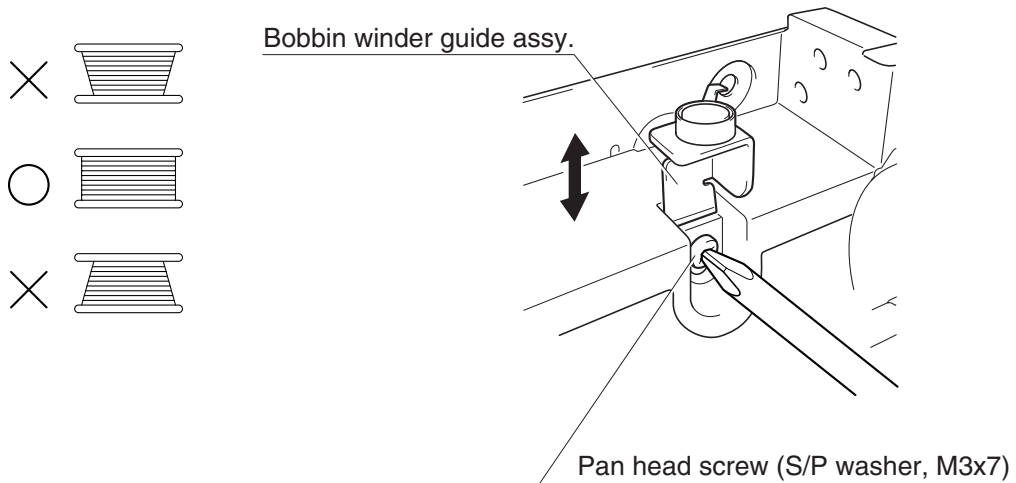


**[Adjustment standard]**

The bobbin should be wound evenly, and up to 80 - 90% of the outer diameter of the bobbin.

**[Adjustment procedure]**

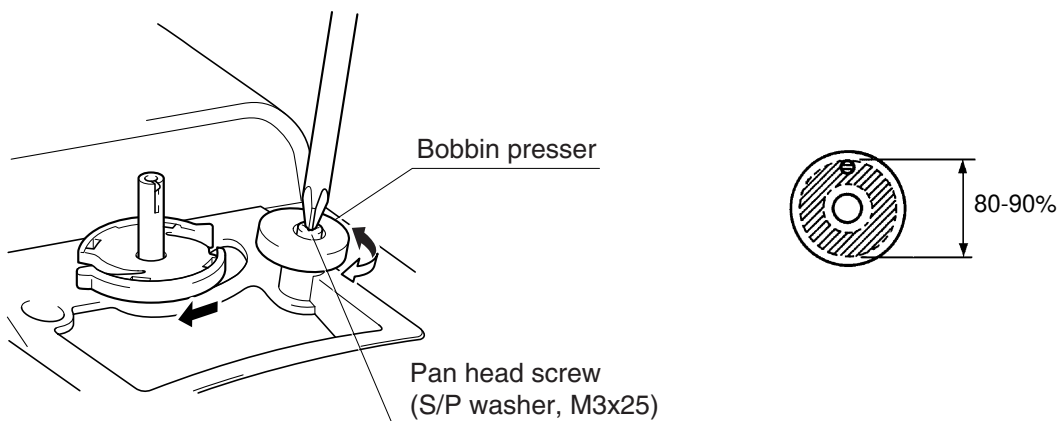
1. Loosen the pan head screw (S/P washer, M3x7) of the bobbin winder guide assy.
2. Move the bobbin winder guide assy. up and down, and adjust uneven bobbin winding.
3. Tighten the pan head screw (S/P washer, M3x7) of the bobbin winder guide assy.  
(tightening torque: 0.59 - 0.78N · m)



4. Loosen the pan head screw (S/P washer, M3x25).
5. Turn the bobbin presser left and right, and adjust the winding quantity.
6. Tighten the pan head screw (S/P washer, M3x25) of the bobbin winder guide assy.  
(tightening torque: 0.59 - 0.78N · m)

**\*Key point**

- The target for the bobbin winding quantity is filling 80 - 90% of the diameter.



## [Adjustment standard]

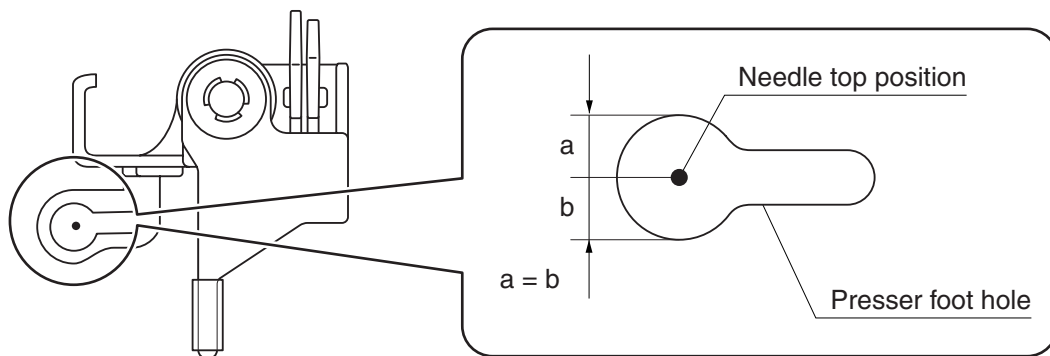
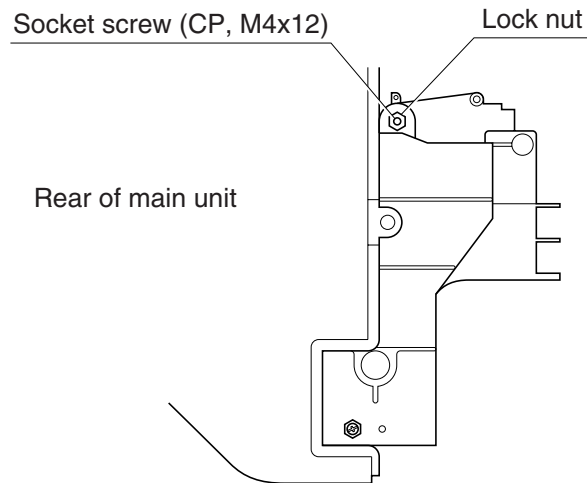
The needle top drops in the center position (front/back) of the presser foot hole.

## [Adjustment procedure]

1. Remove the face plate assy..
2. Attach the J presser foot, and then lower the presser foot lever.
3. Turn the pulley by hand, and drop the needle top into the presser foot hole.
4. Loosen the lock nut.
5. Adjust the needle top to the center position (front/back) of the presser foot hole using the socket screw (CP, M4x12).
6. Tighten the lock nut. (tightening torque: 0.39 to 0.49N·m)

**\*Key point**

- Need to adjust "4-13 Clearance between needle and rotary hook point" after this adjustment.

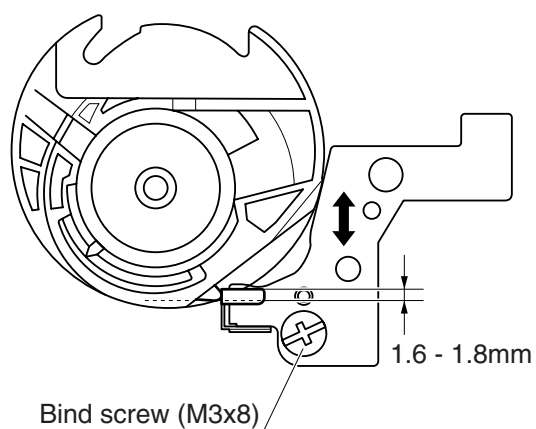


**[Adjustment standard]**

The clearance (overlap) between the inner rotary hook point and the bracket spring must be 1.6 to 1.8mm.

**[Adjustment procedure]**

1. Remove the needle plate B.
2. Set the inner rotary hook in the outer rotary hook assy..
3. Loosen the bind screw (M3x8) of the inner rotary hook bracket assy..
4. Move the position of the inner rotary hook bracket assy. (forward and back), and adjust the clearance is in standard ( 1.6 to 1.8mm).
5. Tighten the bind screw (M3x8) of the inner rotary hook bracket assy.. (Tightening torque: 0.78 to 1.18N· m)



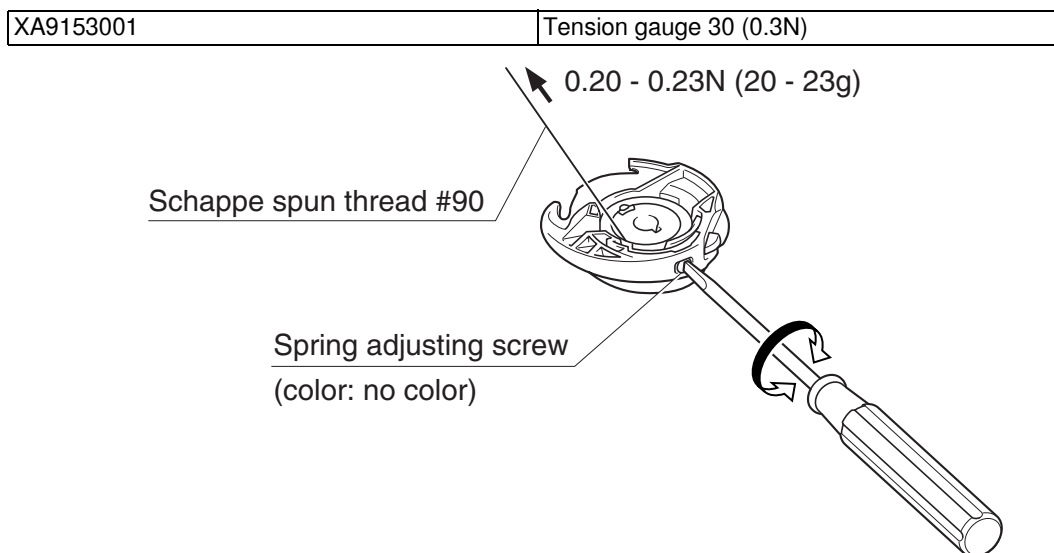
- Standard bobbin case (green marking on the screw)

[Adjustment standard]

Inner rotary hook assy. (lower thread) tension is 0.20 to 0.23N (20 to 23g).

[Adjustment procedure]

1. Set the bobbin (the schappe spun thread #90) in the inner rotary hook assy..
2. Pull the thread by a tension gauge, and turn the spring adjusting screw, adjust the tension to 0.20 to 0.23N (20 to 23g).



### ■ X timing belt

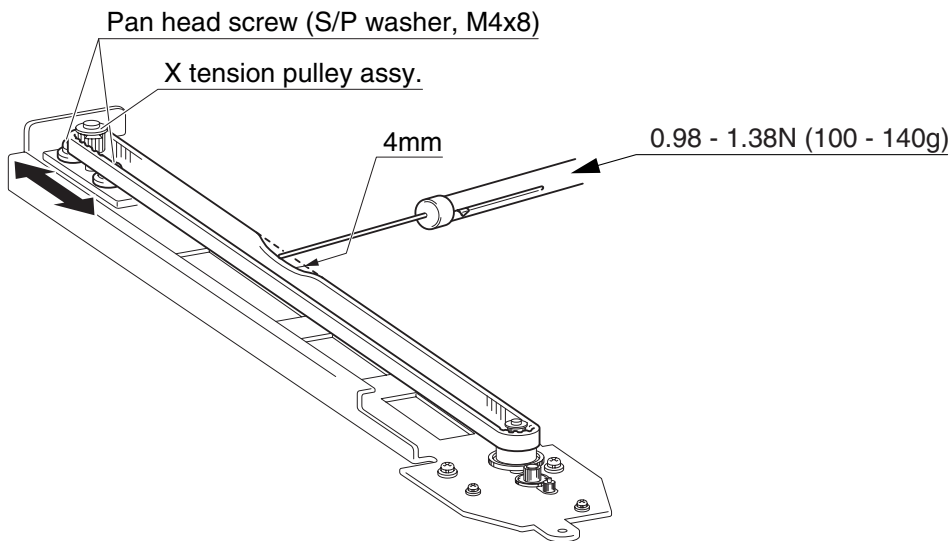
#### [Adjustment standard]

4mm slack by pushing the center of the belt with a force of 0.98 to 1.38N (100 to 140g).

#### [Adjustment procedure]

1. Loosen the 2 pan head screws (S/P washer, M4x8).
2. Move the X tension pulley assy. right and left to adjust the X belt tension.
3. Tighten the 2 pan head screws (S/P washer, M4x8). (tightening torque: 1.17 to 1.57N·m)

XC2277001	Push-pull gauge (3N)
-----------	----------------------



### ■ Y timing belt

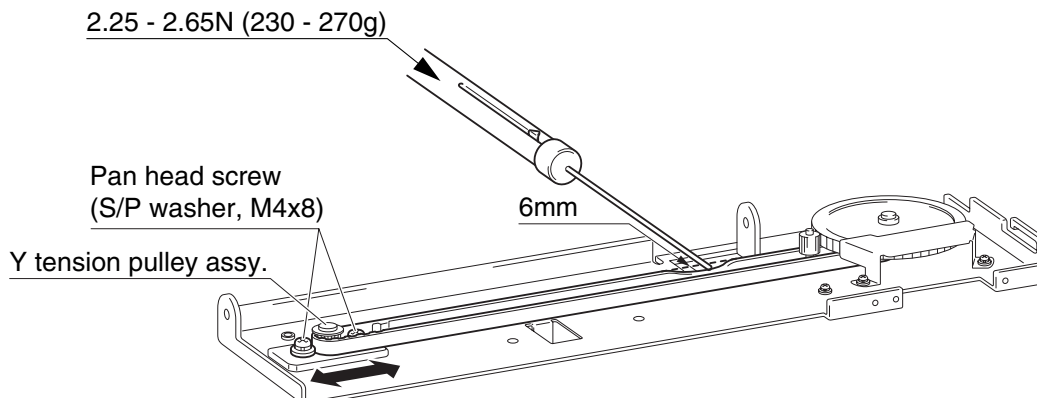
#### [Adjustment standard]

6mm slack by pushing the center of the belt with a force of 2.25 to 2.65N (230 to 270g).

#### [Adjustment procedure]

1. Loosen the 2 pan head screws (S/P washer, M4x8).
2. Move the Y tension pulley assy. right and left to adjust the Y belt tension.
3. Tighten the 2 pan head screws (S/P washer, M4x8). (tightening torque: 1.17 to 1.57N·m)

XC2277001	Push-pull gauge (3N)
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Repairing or adjusting the embroidery unit, check this adjustment.

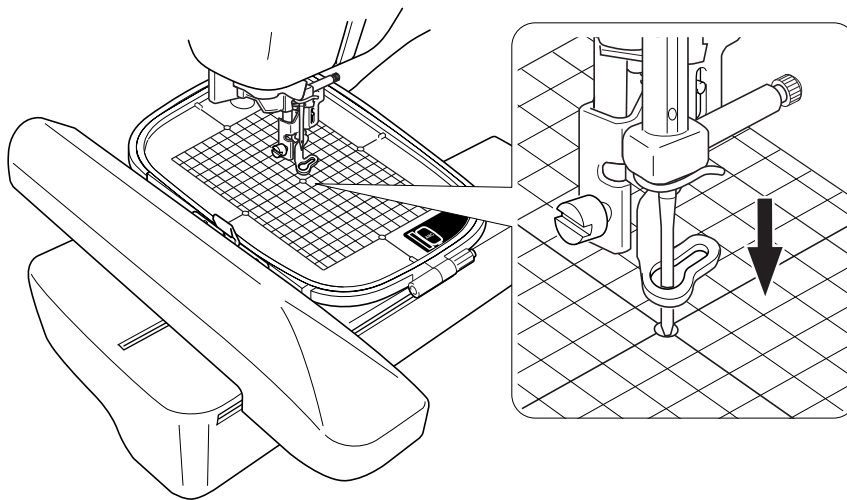
[Adjustment standard]

The needle drops in the center of embroidery sheet hole.

[Adjustment procedure]

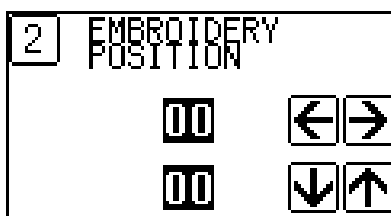
■ Checking the embroidery unit center position

1. Remove the presser foot.
2. Attach the embroidery unit to the machine. (Remove embroidery hoop.)
3. Turn on the power, and press the [OK] button on the screen (Move the carriage).
4. Put the embroidery sheet on the embroidery hoop.
5. Attach the embroidery hoop to the embroidery unit.
6. Turn the pulley by hand and check the needle drops in the center of the embroidery sheet hole.



■ In case the needle does not drop in the center of the embroidery sheet hole.

1. Select the test mode “2” (Embroidery Position Adjust mode).
2. Adjust the needle position by pressing the button on the screen for the needle to drop in the center of the embroidery sheet hole.
3. After adjustment, turn the power off (adjusting value is memorised automatically)





# 5 Failure Investigation for Electronic Parts

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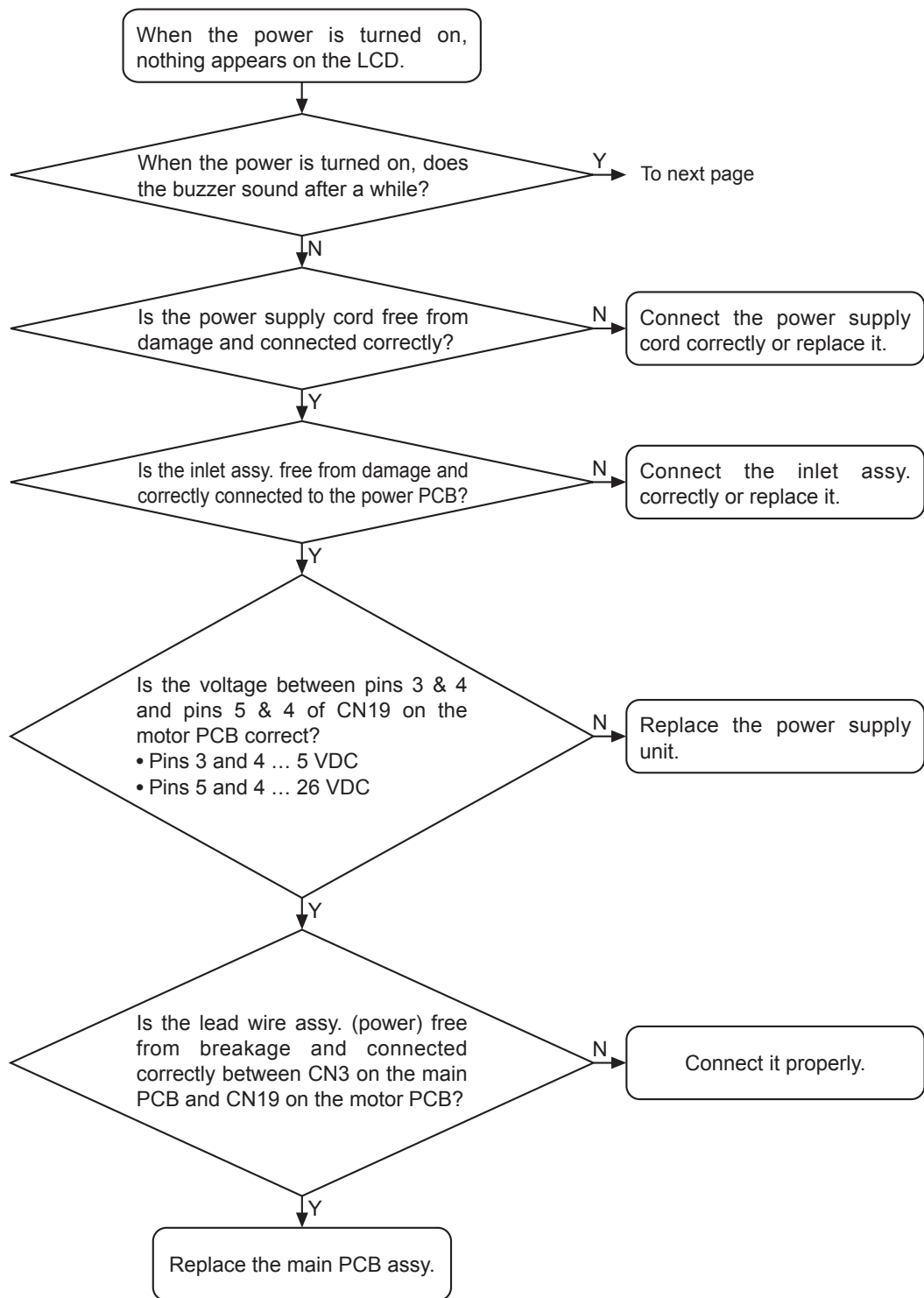
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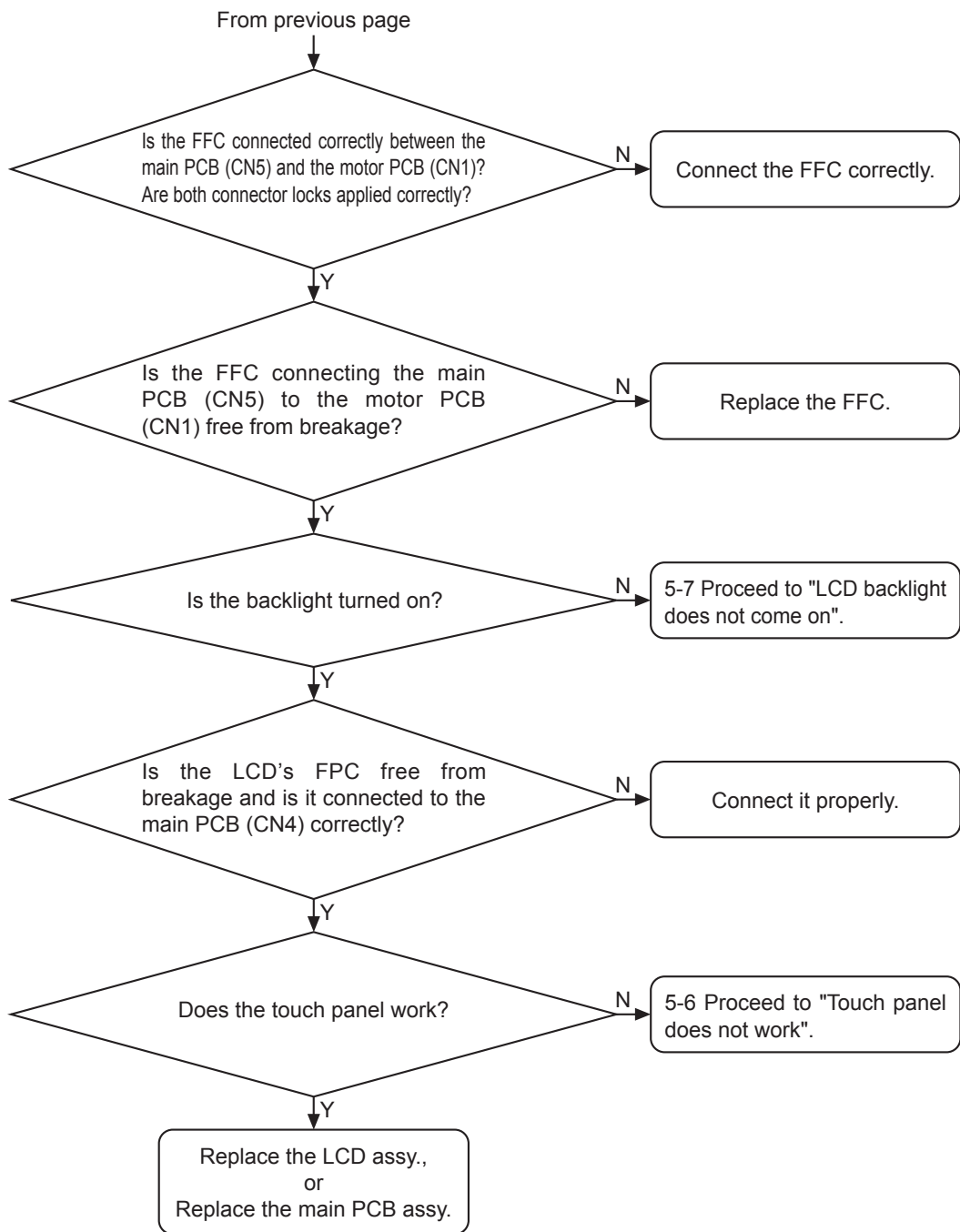
\* Perform resistance measurements after turning off the power, and detaching the connectors to be measured from the PCB.

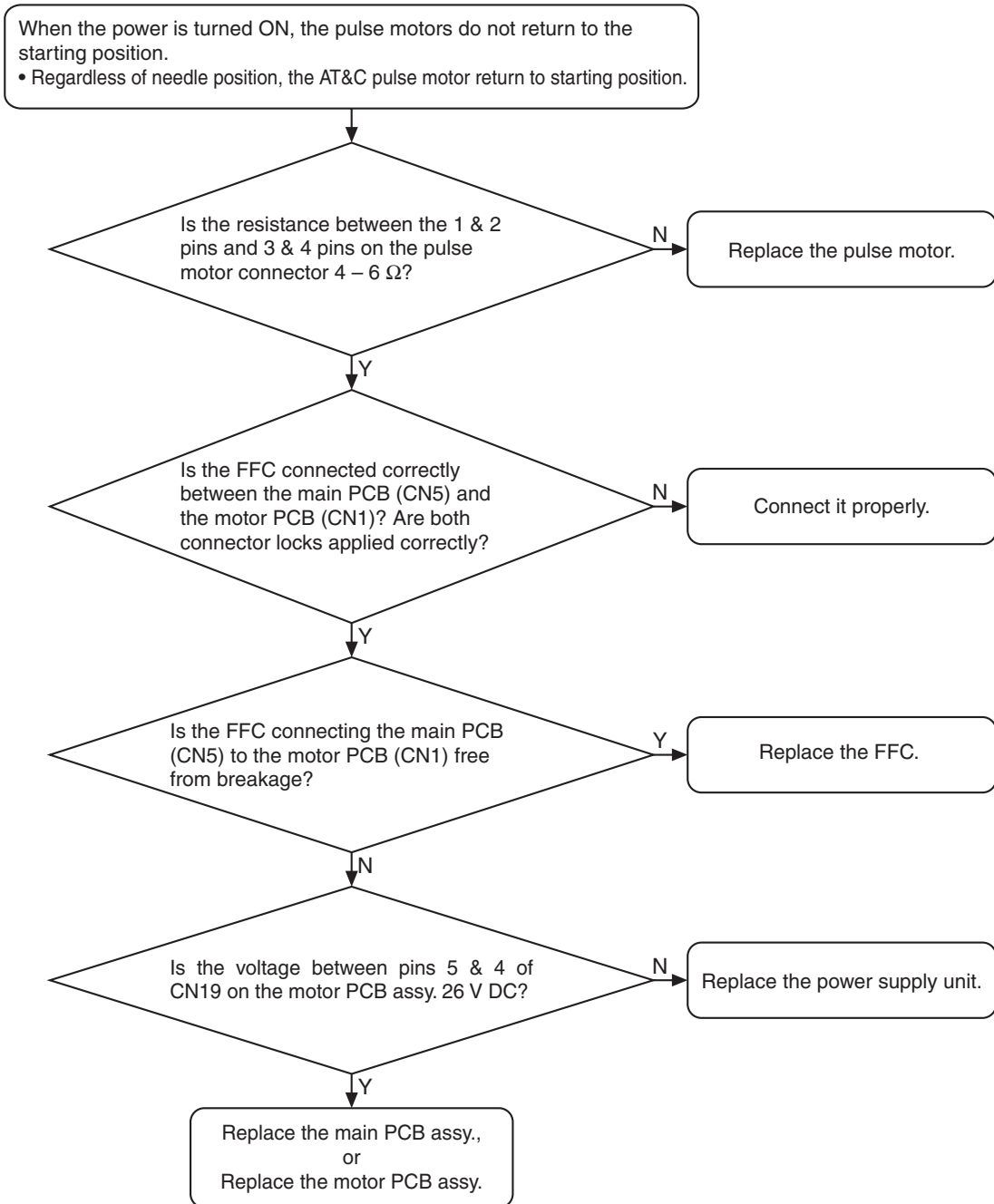
Error message list .....	5 - 2
The power does not come on .....	5 - 3
Pulse motors do not return to starting position .....	5 - 5
The touch panel does not work .....	5 - 6
LCD backlight does not come on .....	5 - 7
Main motor does not turn .....	5 - 8
Main motor rotation abnormal .....	5 - 10
Cannot sew pattern correctly .....	5 - 11
Thread tensioning is not correct .....	5 - 12
Thread cutter does not work normally .....	5 - 13
Bobbin winding cannot be done .....	5 - 14
Lamp does not come on .....	5 - 15
Bobbin thread detection does not work normally .....	5 - 17
Upper thread sensor does not work normally .....	5 - 18
Card cannot be used normally .....	5 - 19
USB cannot be used normally .....	5 - 20
Embroidery unit does not operate normally .....	5 - 21
Error is displayed .....	5 - 24
Replacement of main PCB assy or motor PCB assy .....	5 - 27
Correspondence table of "Model" and "Printed-circuit board" .....	5 - 28

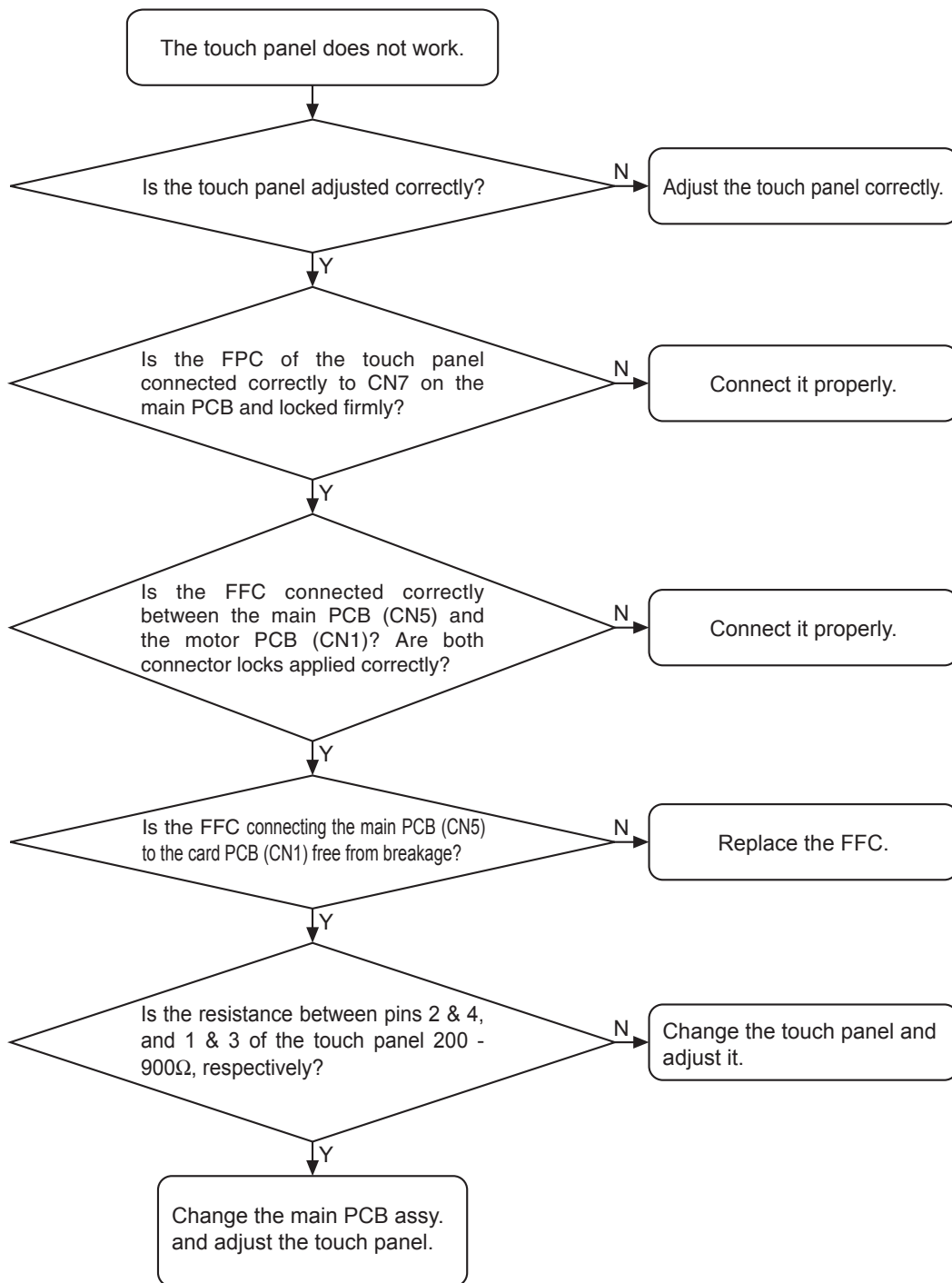


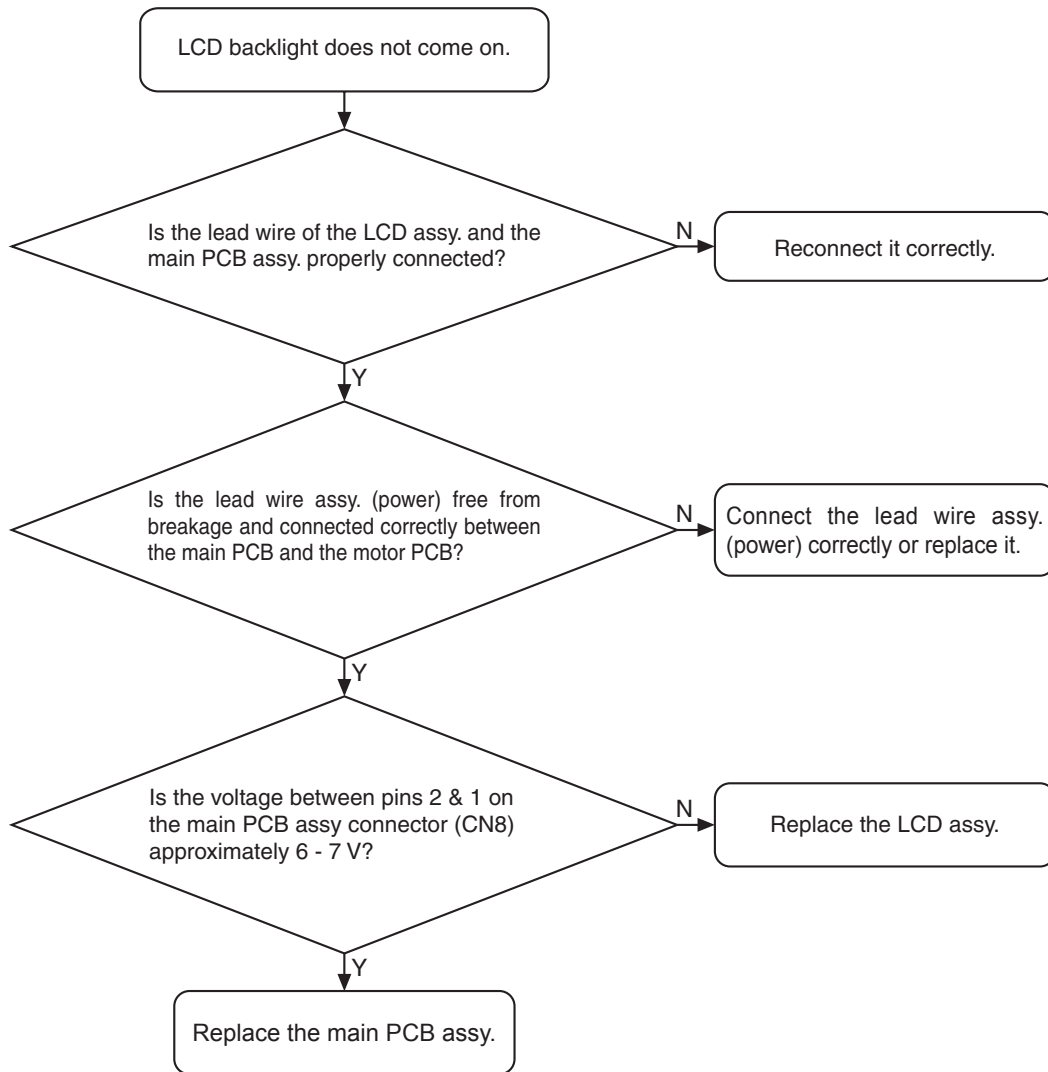
<b>Error display</b>	<b>Cause</b>
F01 (5 - 24)	Abnormal rotation in main motor.
F02 (5 - 24)	Key pressed continually with power ON (operation system SW).
F04 (5 - 25)	FC disconnect
F05 (5 - 26)	Dirty speed sensor
F06 (5 - 26)	NP sensor disconnect
The safety device has been activated.	No rotation in main motor.
A malfunction occurred. Turn the machine off, then on again *-PM	Each pulse motor has not returned to its original position.

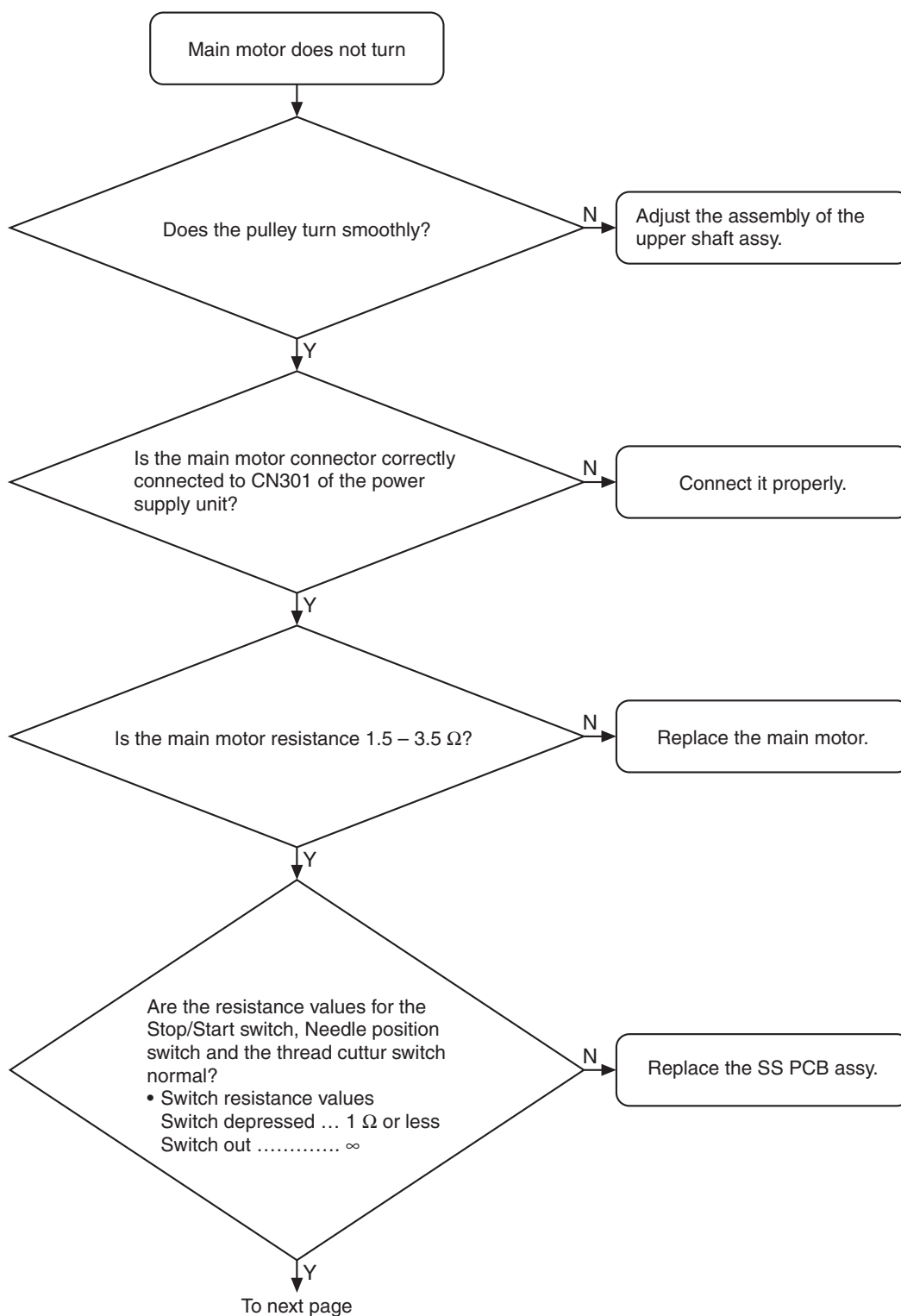


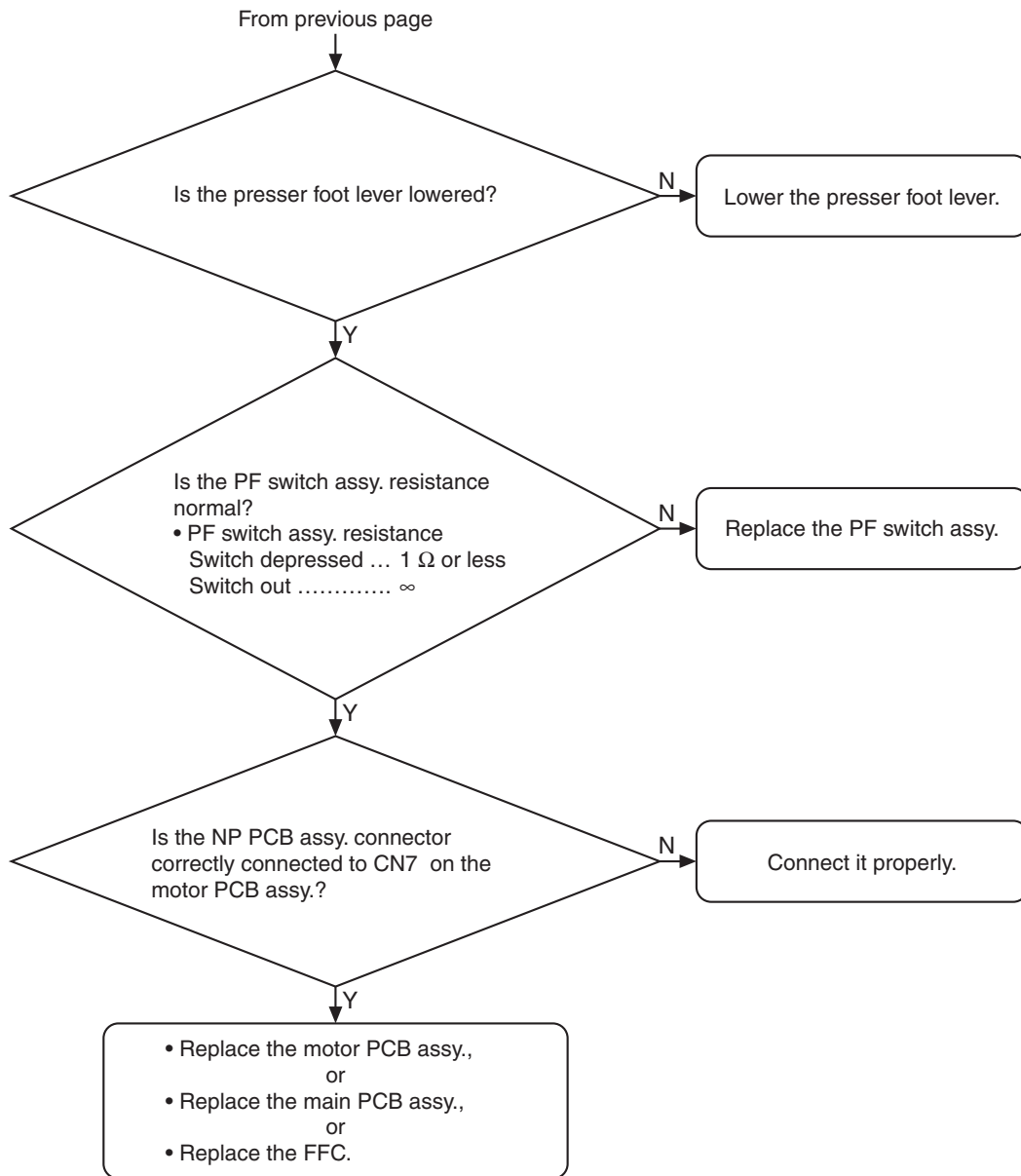




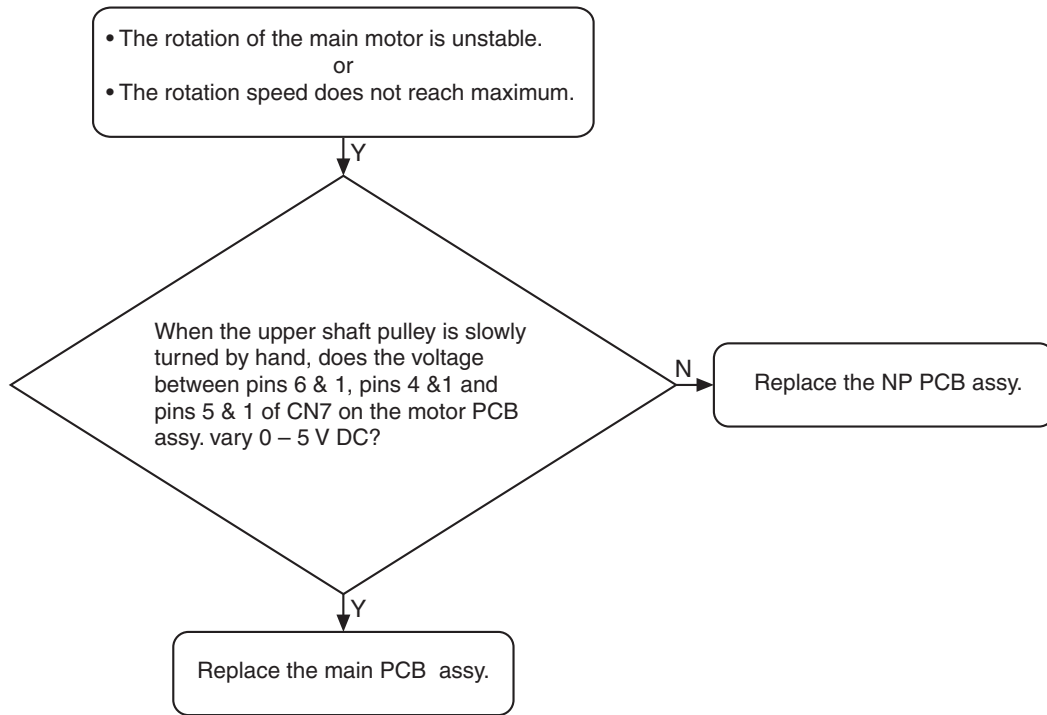


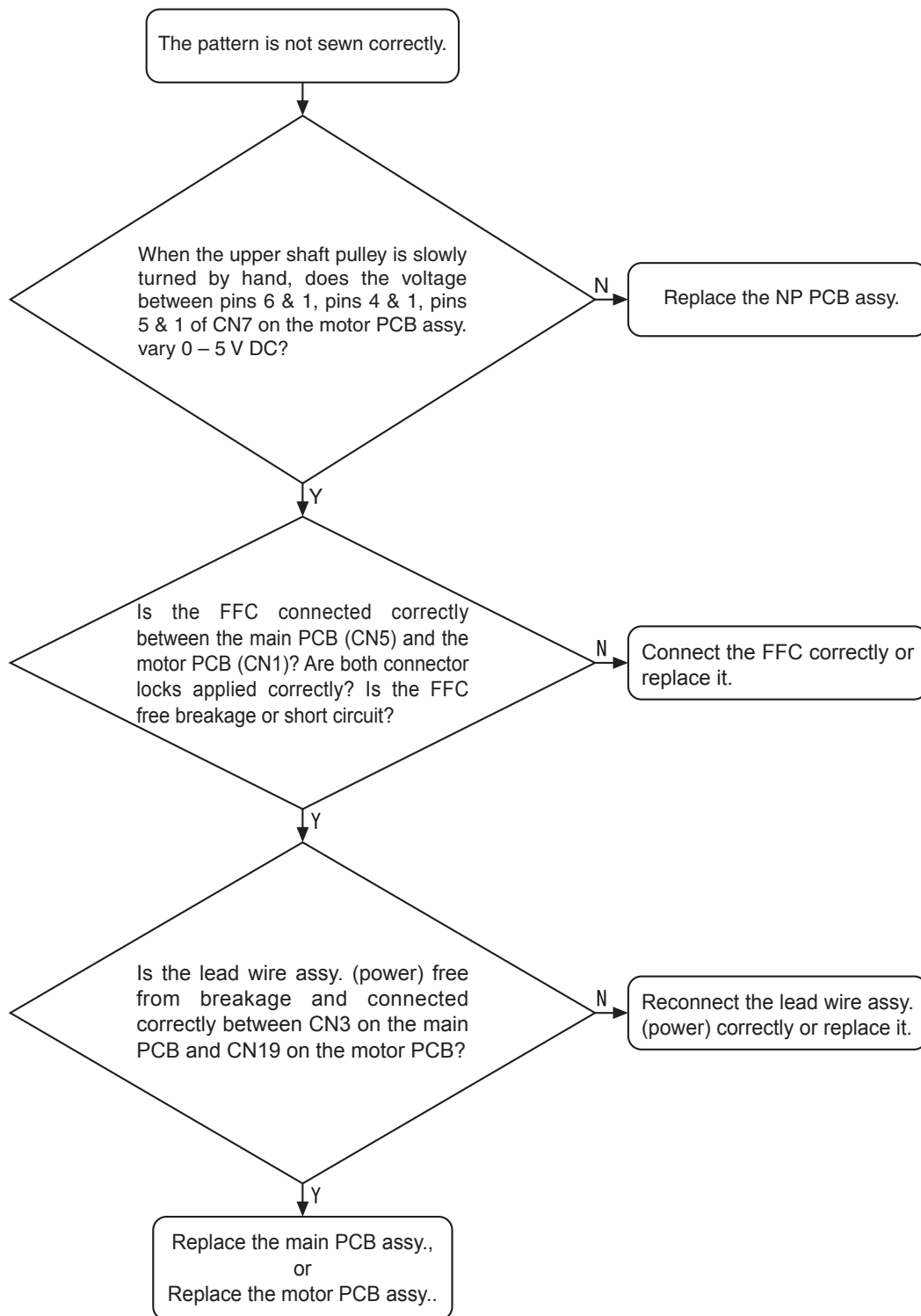


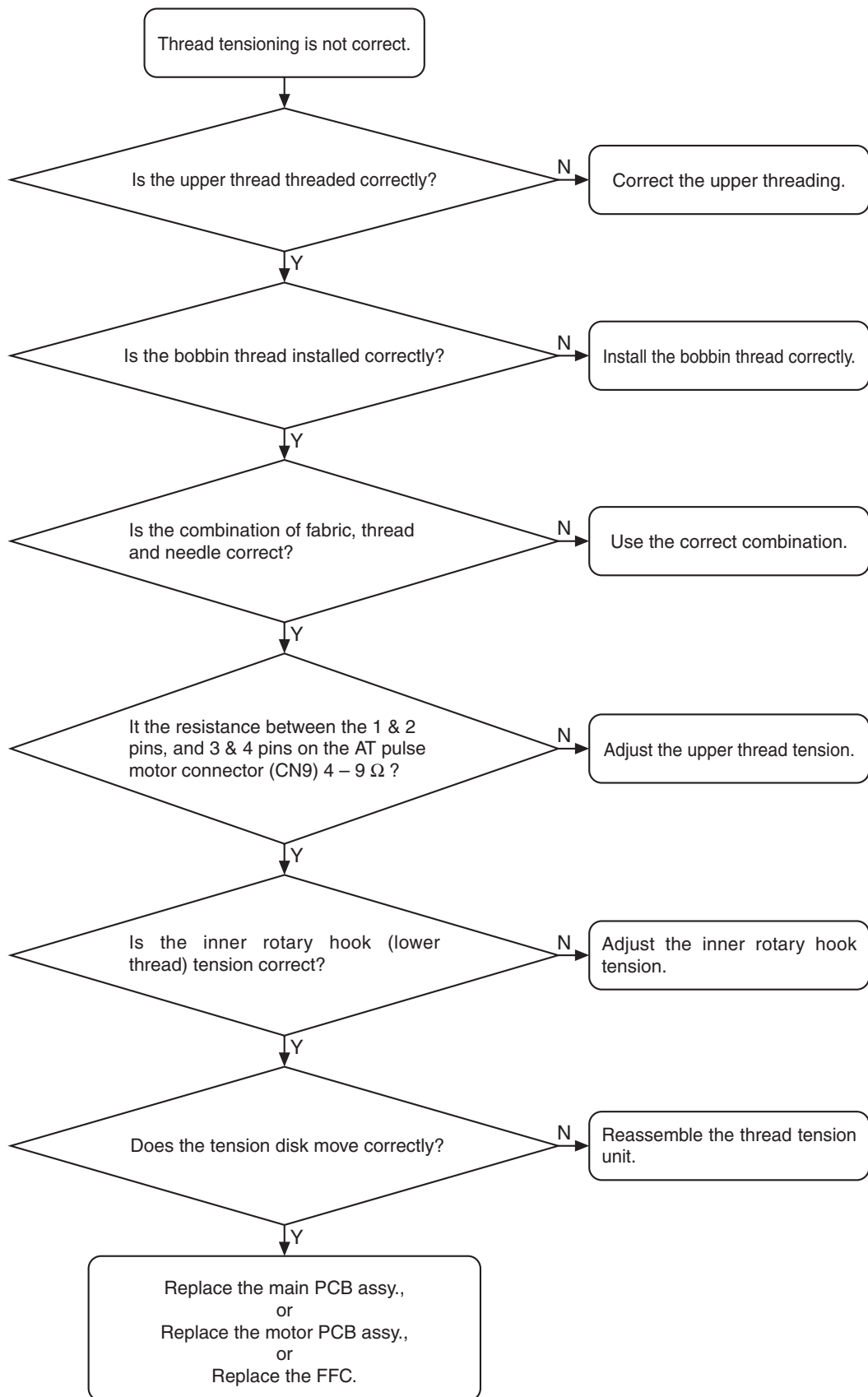


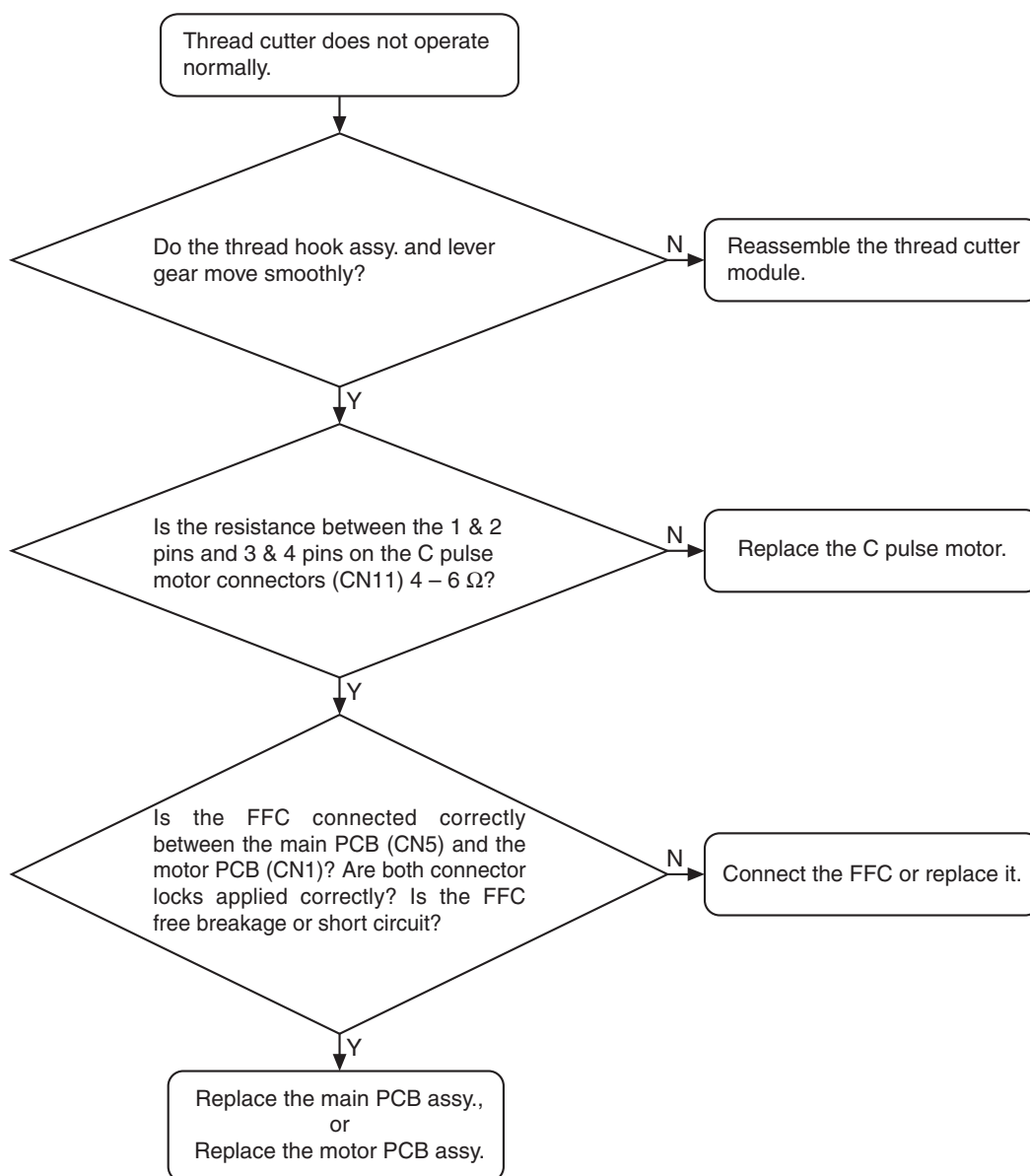


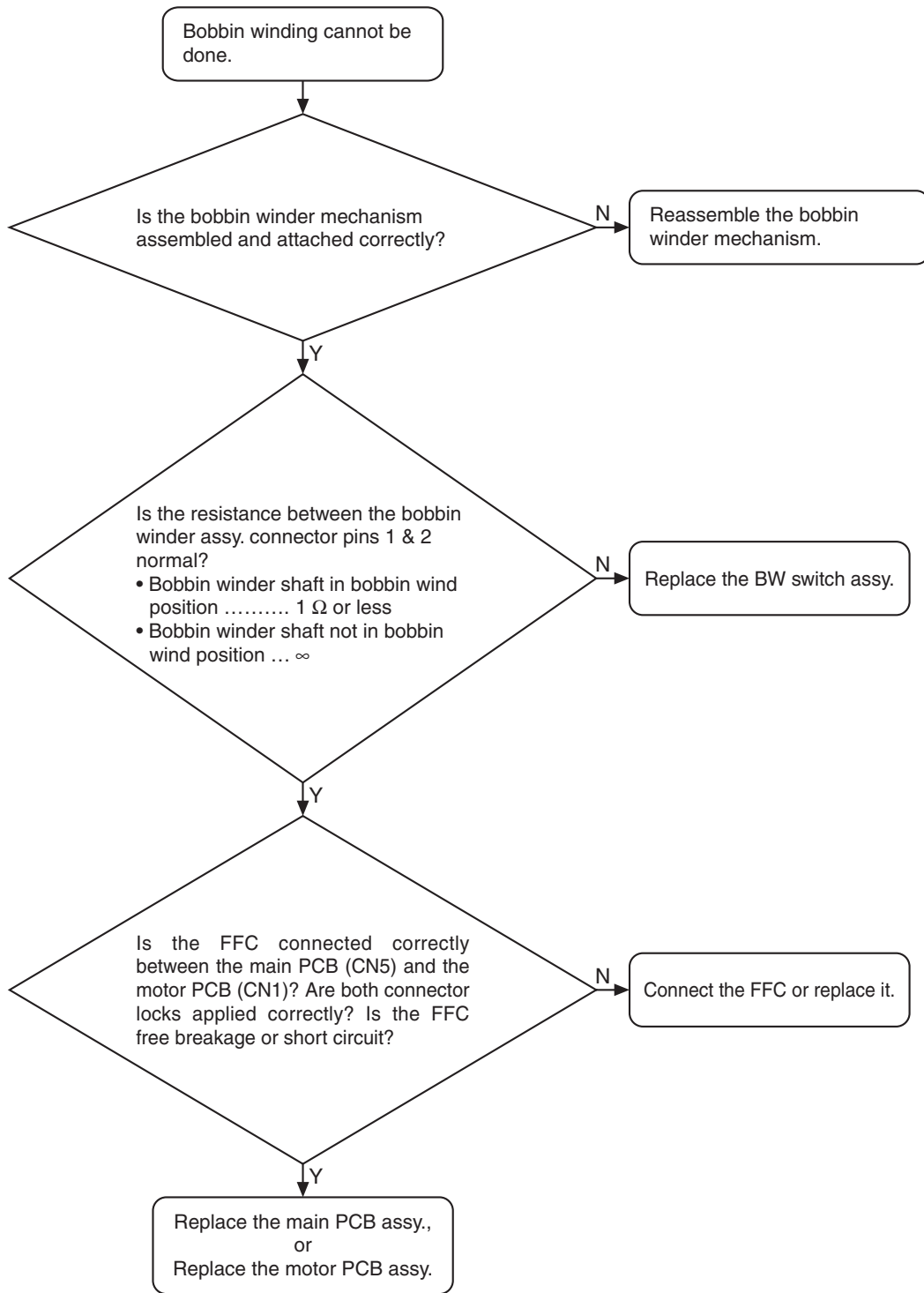


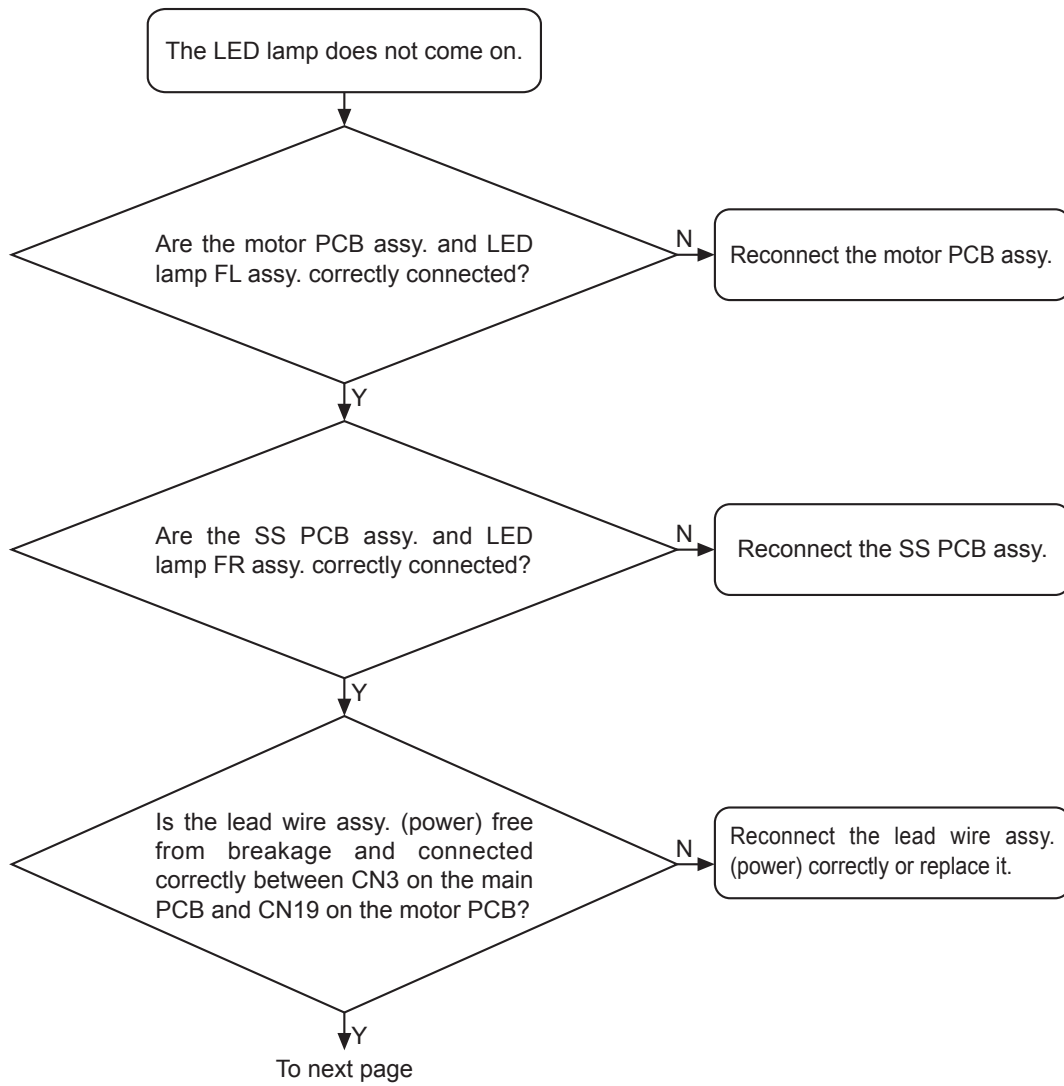


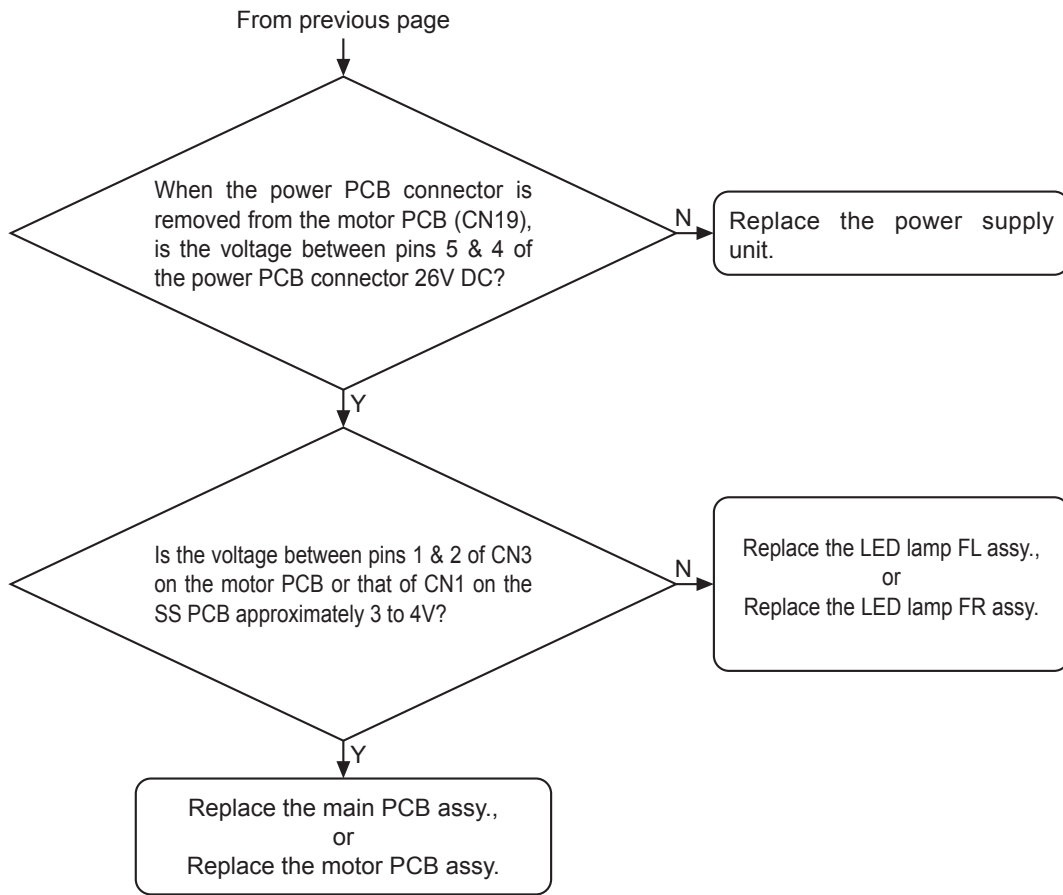


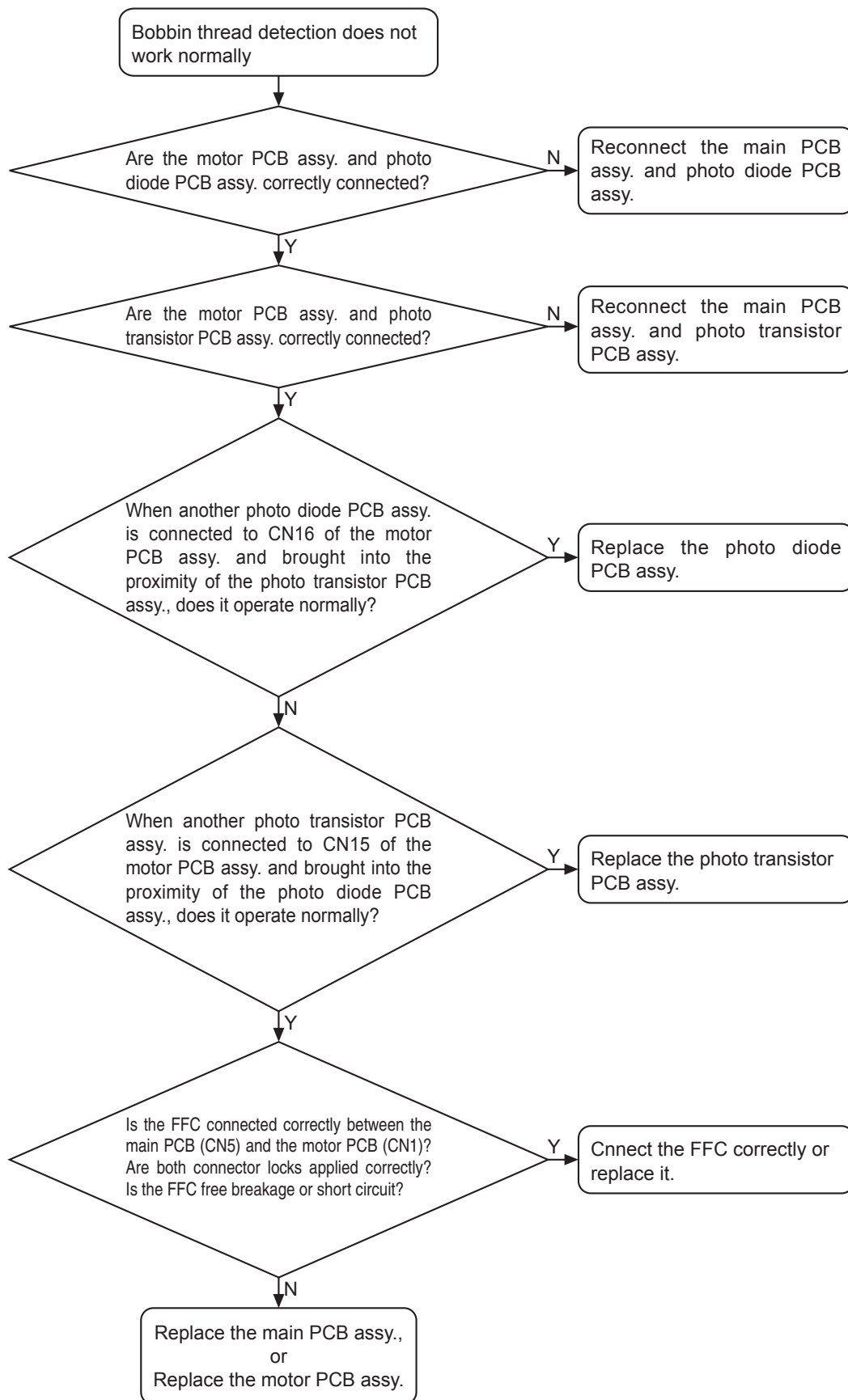




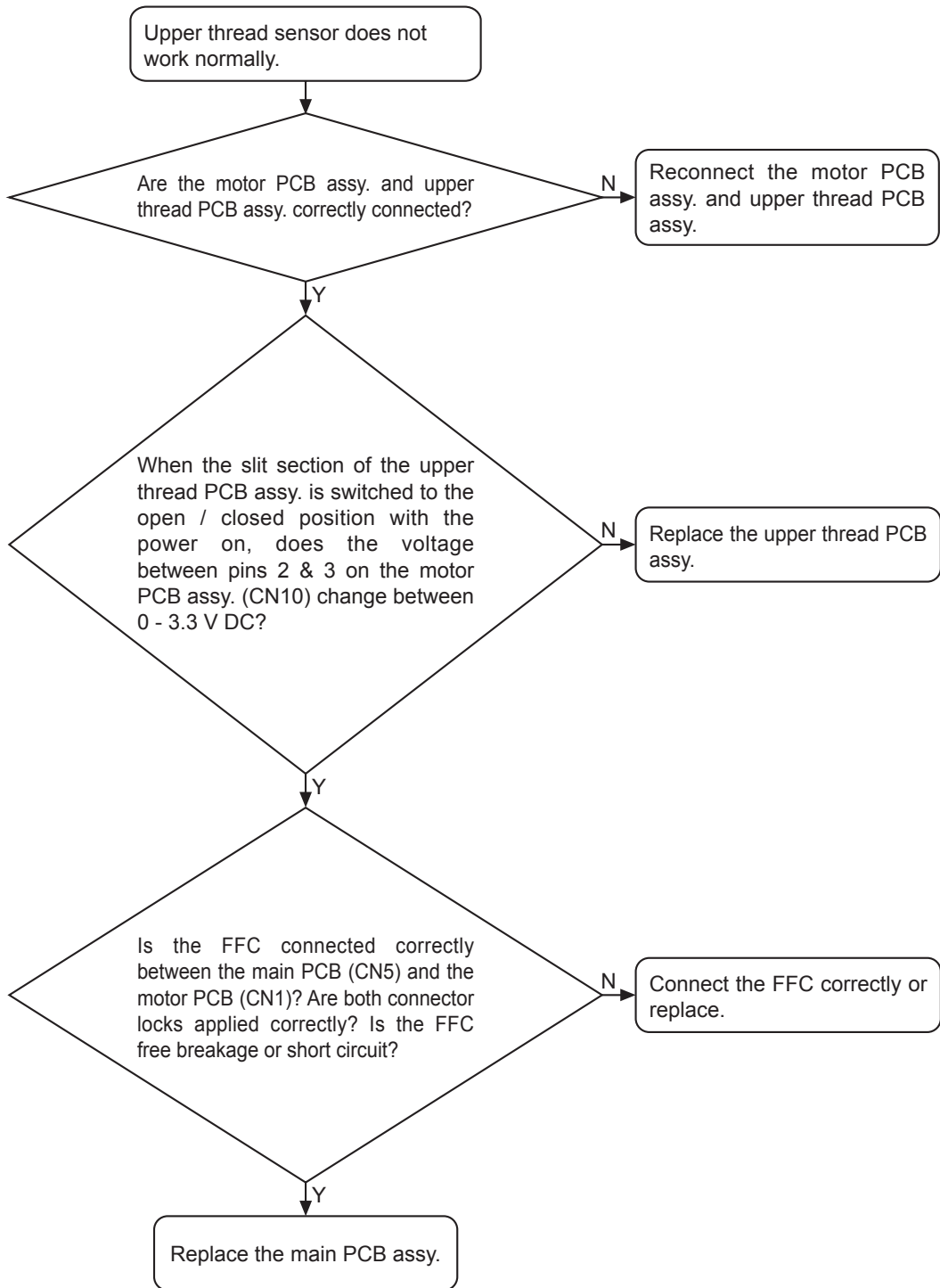


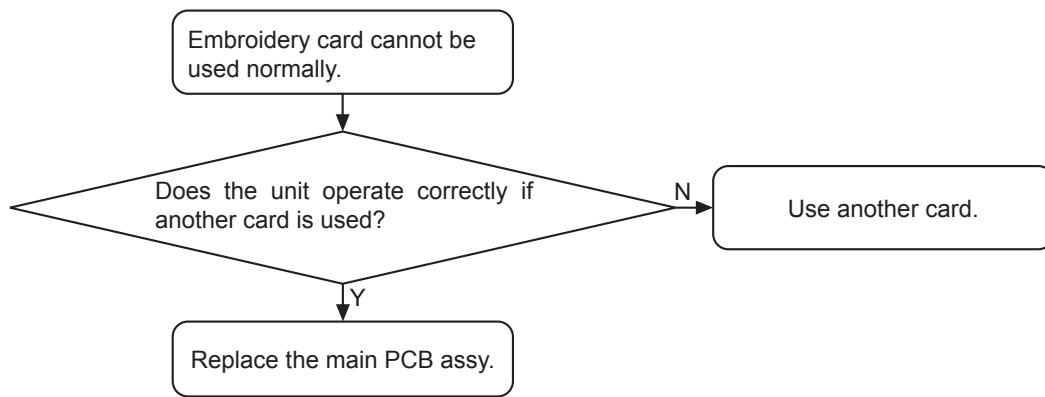


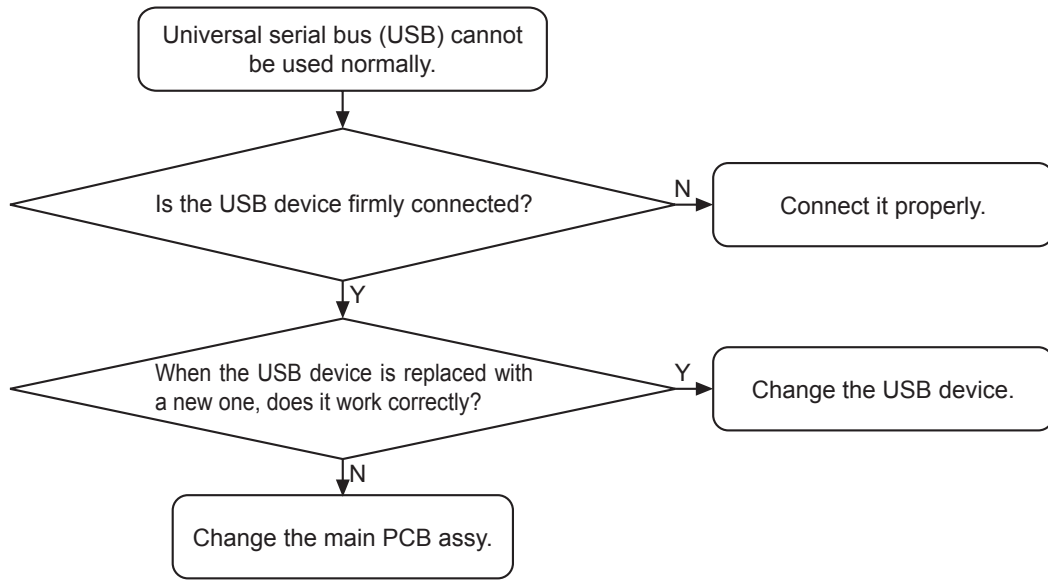


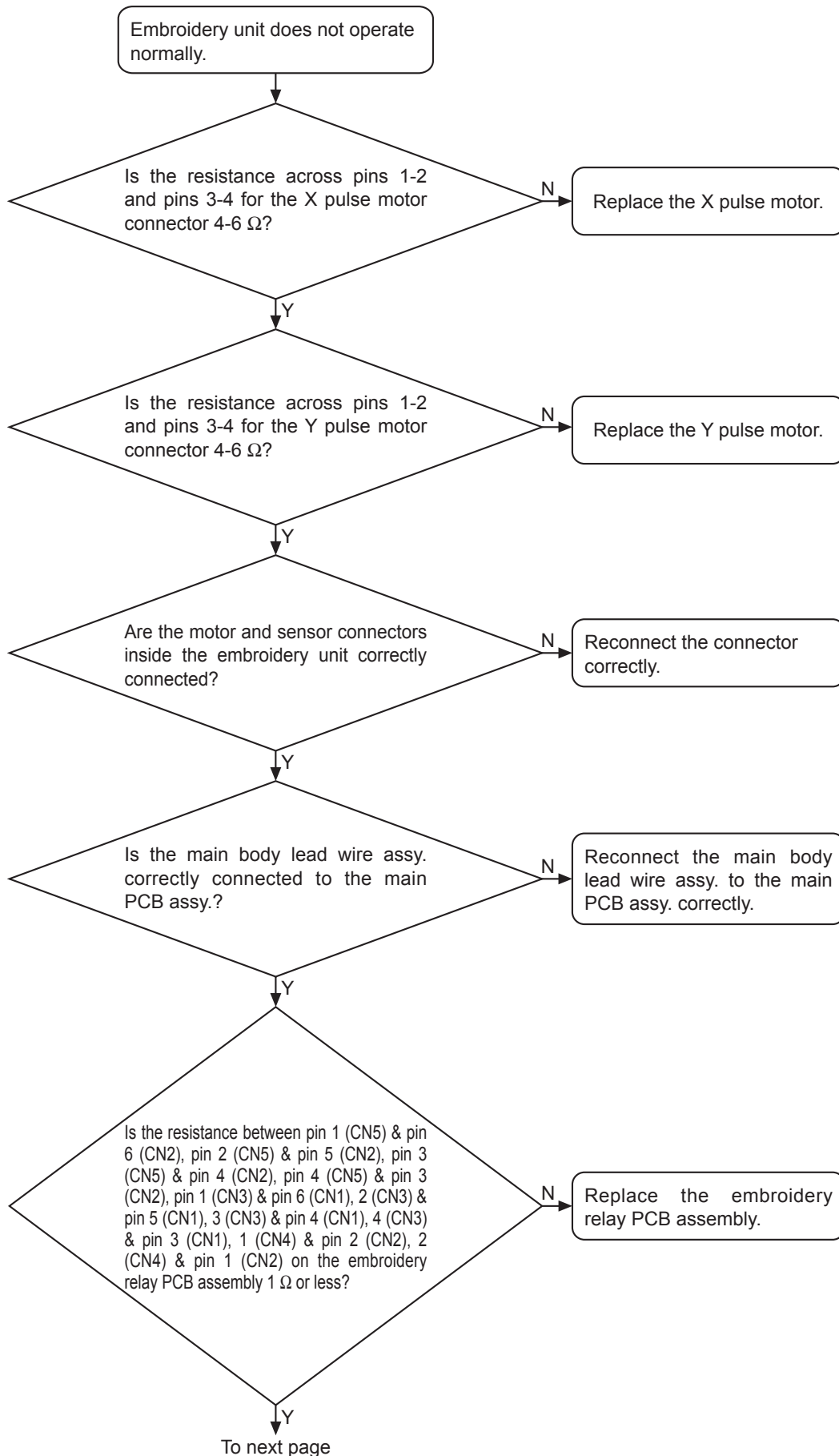


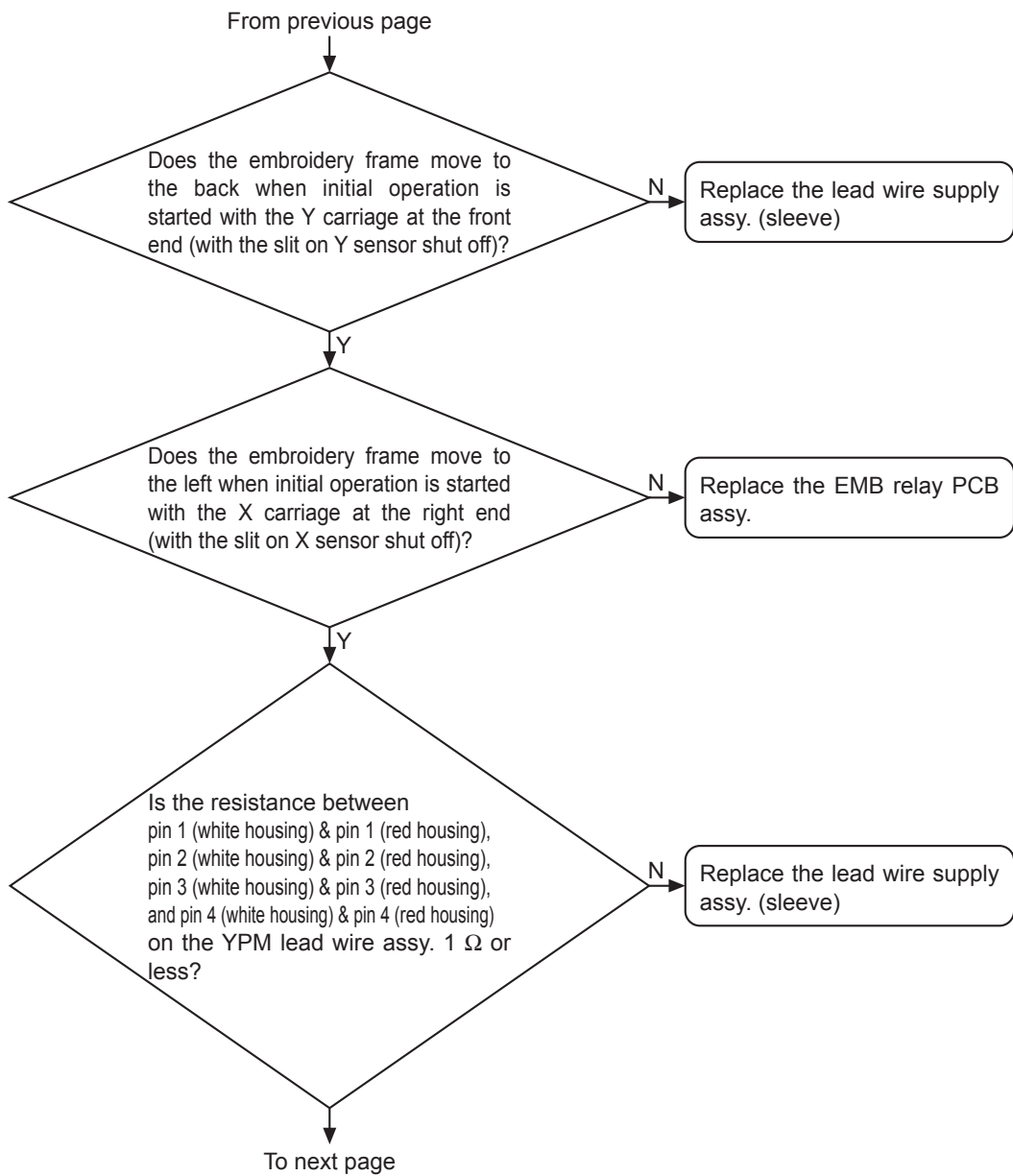


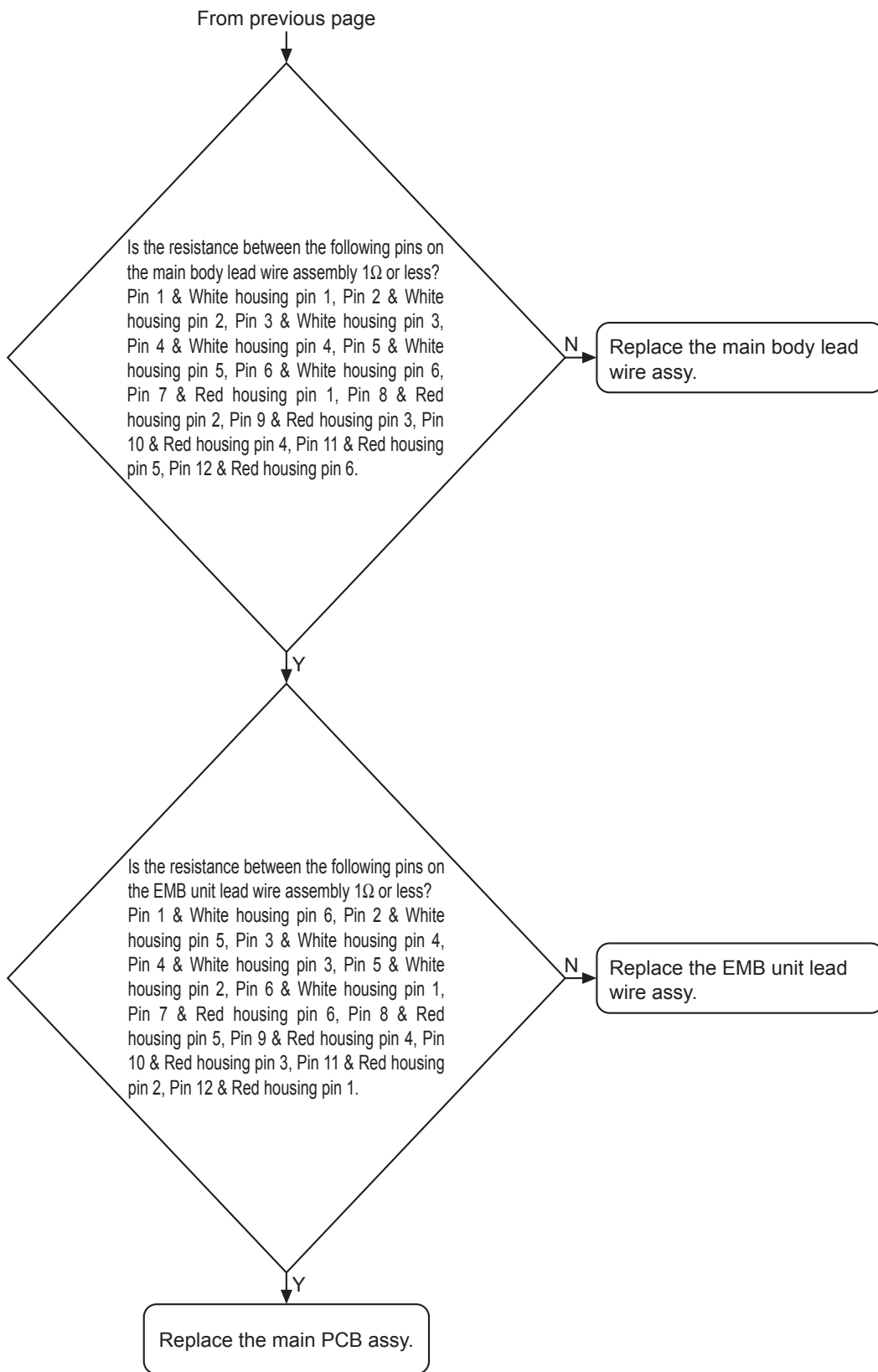


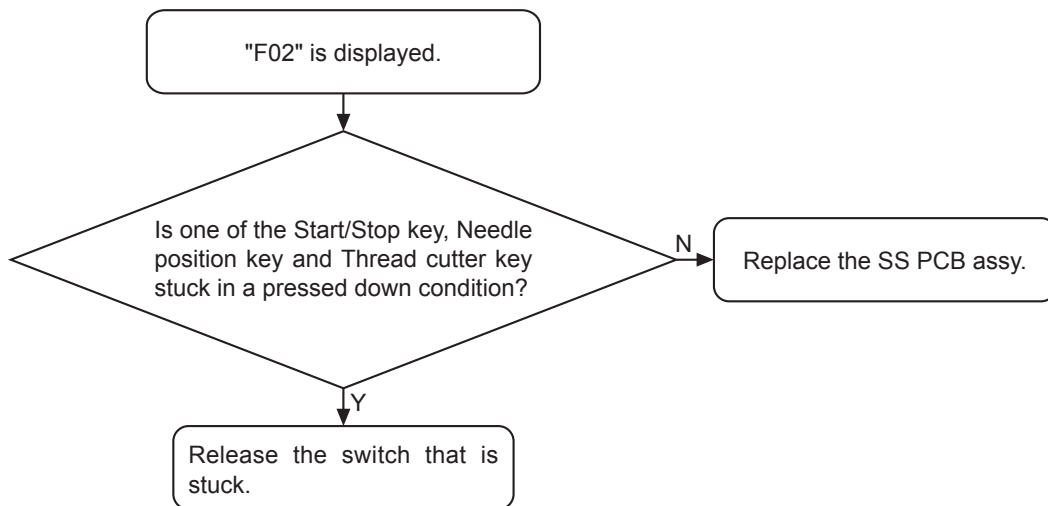
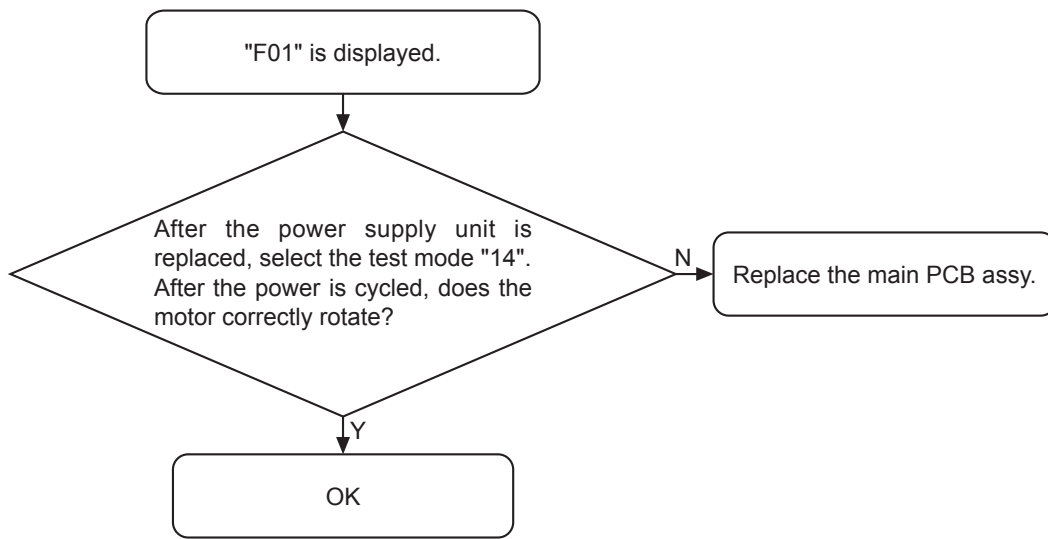


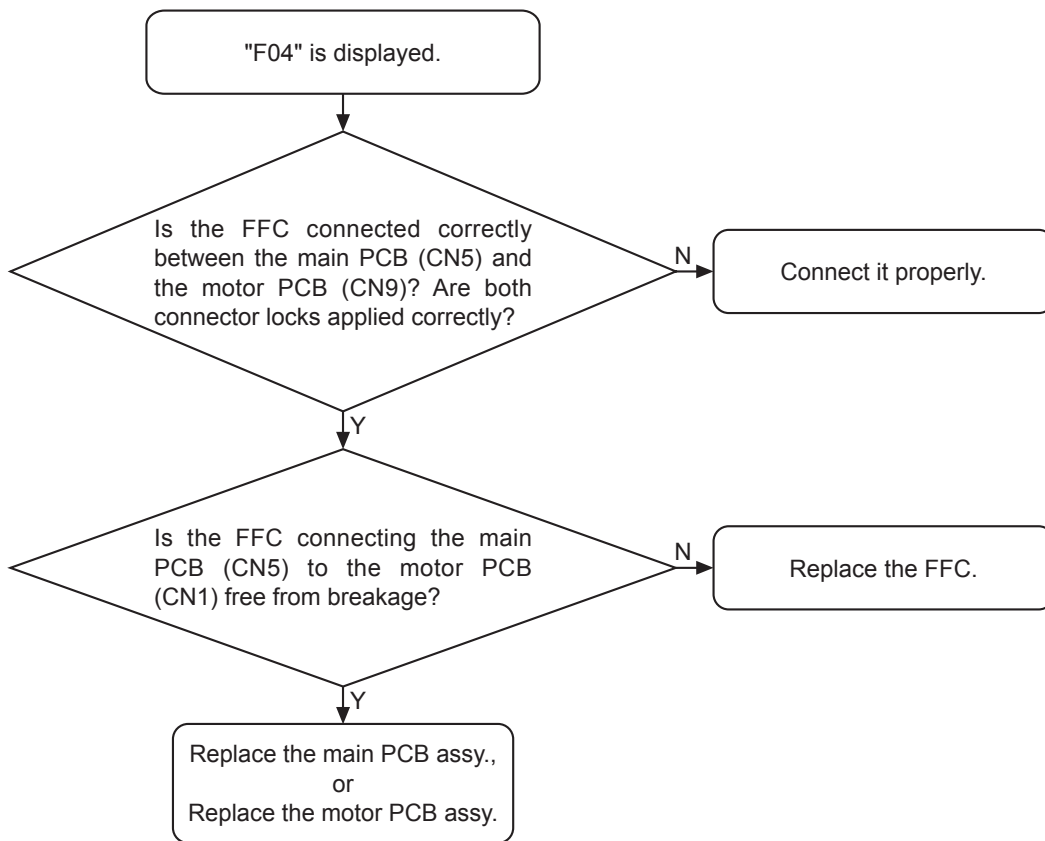




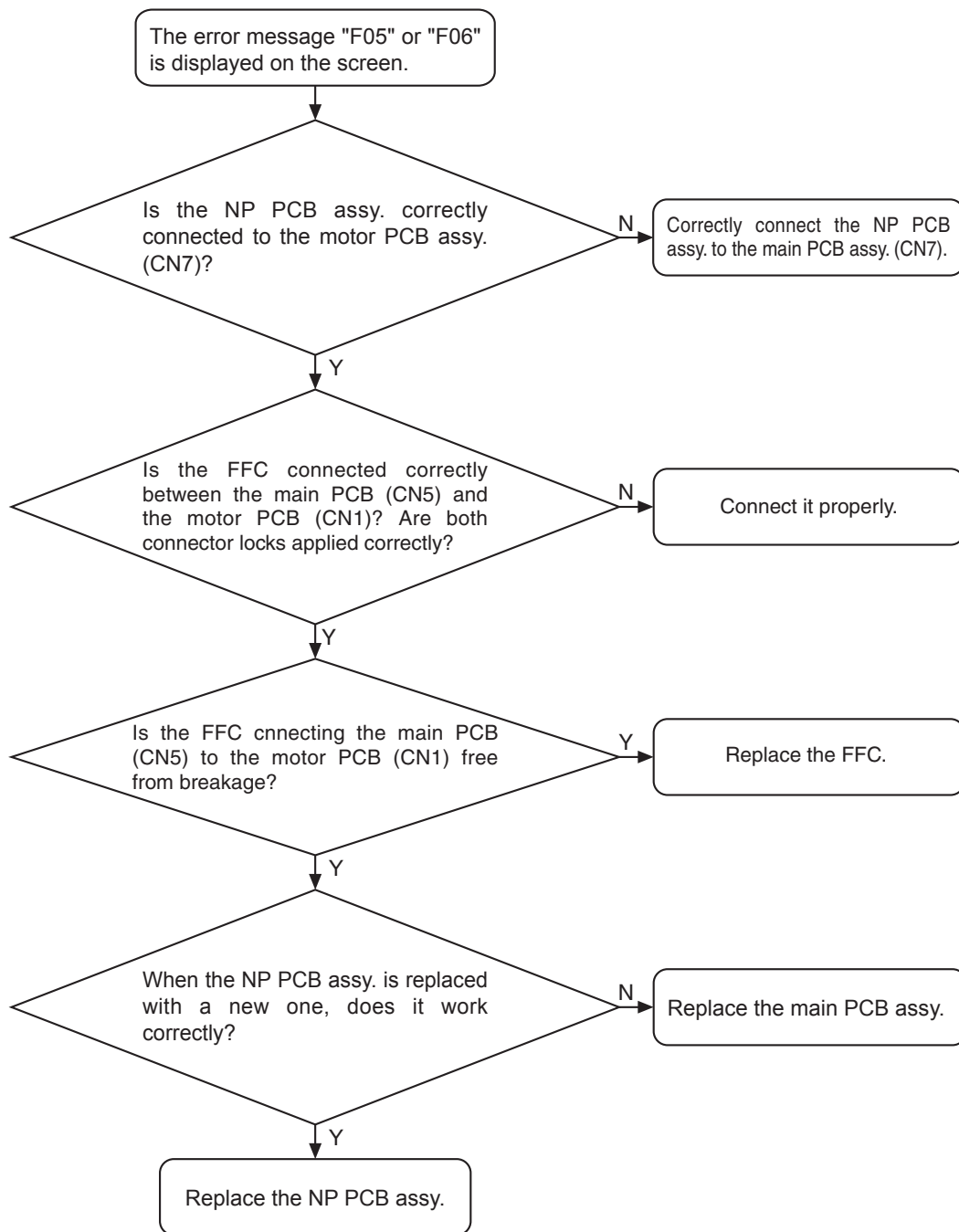












**Do not replace the main PCB assy and motor PCB assy simultaneously.**

The setting data required to run the sewing machine correctly is stored in both the main PCB assy and the motor PCB assy. When either PCB assy is replaced, the setting data is automatically copied from the other to the new PCB assy.

If you replace the main PCB assy and motor PCB assy simultaneously, the setting data stored in the sewing machine cannot be copied to the new PCBs, causing the sewing machine to malfunction. When both PCB assys need replacing, be sure to replace them one at a time.

When the main PCB assy or motor PCB assy has been replaced, the setting data stored in the sewing machine is automatically copied to the new PCB. However, the screen shown in Fig. 1 may appear depending on the new PCB. In that event, follow the steps below to complete copying correctly.

1. Select "MAIN PC BOARD" ① when the main PCB assy was replaced, or select "MOTOR PC BOARD" ② when the motor PCB assy was replaced. (Fig. 1)

Copying the setting data stored in the sewing machine automatically starts.

**\*Note 1**

- Do not select a PCB different from the one that has been replaced.  
The setting data stored in the sewing machine cannot be copied correctly, causing the sewing machine to malfunction.

**\*Note 2**

- Do not turn OFF the power to the sewing machine while the setting data is being copied. Do not touch the sewing machine's touch panel or any buttons.  
The setting data stored in the sewing machine cannot be copied correctly, causing the sewing machine to malfunction.

2. When copying the setting data is completed, the sewing machine is automatically restarted.

\* Replacement of the PCB assy is completed.

**\*Note**

- When copying the setting data is completed, upgrade the software of the sewing machine to the latest version. If the software is not the latest version, the sewing machine may not run correctly.

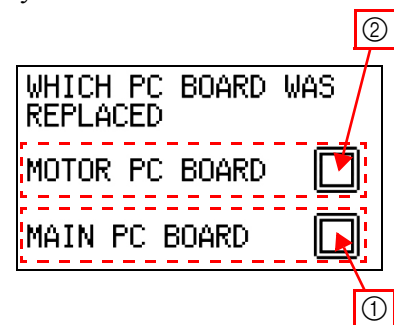
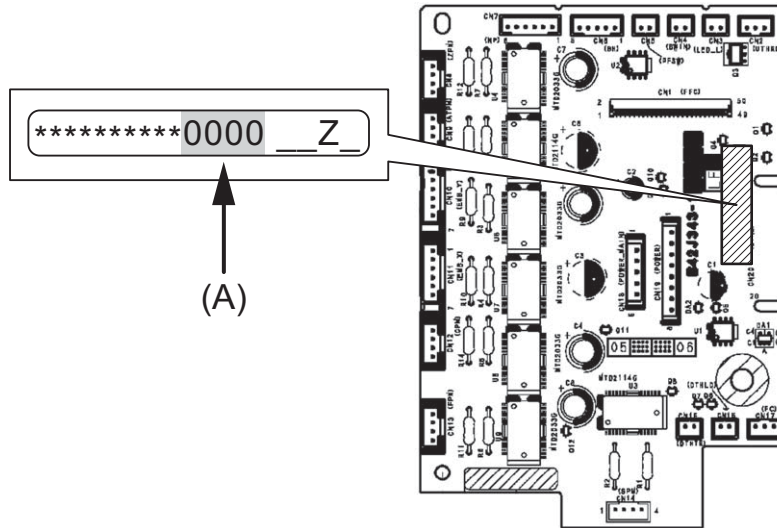


Fig. 1

If "SPEC DIFFERENCE" is displayed on the screen, it means that the specifications of the PCB assy that has been replaced differ from the sewing machine. Replace with the PCB assy with the same specifications as the sewing machine.

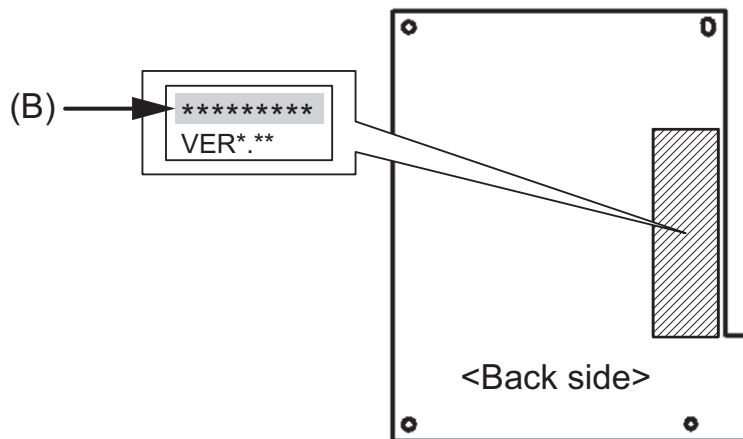
■ Motor PCB

Model	Specifications	Parts code	Marking character on (A)
PE-780D/NV780D PE-770/NV750E	for all country	XD1977***	1624



■ Main PCB

Model	Specifications	Parts code	Marking character on (B)
PE-780D/NV780D	for all country	XE6292***	XE6292***
PE-770/NV750E	for all country	XE6293***	XE6293***



# 6 Repair Manual

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In this chapter, projects the cause from contents of the malfunction of the products, and explains the method of the fix and the maintenance. When do not understand the cause of the malfunction and the method of the fix and the maintenance, use this chapter.

	Problem	Primary factors and causes	Repair method	Items for Inspection	Inspection method and standards
1	Stitch skipping Thread abrasion Thread breakage Seam unevenness Needle breaks	Needle tip damaged while sewing Needle catches and bends before or after sewing	Needle replacement	Tip damage to needle	Touch the needle tip with your finger, be sure that it is not damaged. (4-2)
				Needle curvature	Remove the needle, place on level block (horizontal block) and be sure there is no curvature. (4-2)
2	Power supply enter, but LCD display nothing	FFC (FFCSFBNCD-50) and main PCB assy. connector disconnected	Lock FFC after plug FFC in connector (3-34)	Sewing machine runs when switched on	When power is switched ON, conform that the LCD screen light.
		FFC (FFCSFBNCD-50) and motor PCB assy. connector disconnected	Lock FFC after plug FFC in connector (3-35)		
		Lead wire assy. power and main PCB assy. connector disconnected	Plug connector in (3-34)		
		Lead wire assy. power and motor PCB assy. connector disconnected	Plug connector in (3-35)		
	Sewing machine lamp (LED lamp) does not light (machine operation normal)	LCD and main PCB assy. FPC disconnected	FPC plug connector in (3-34)		
		Power supply unit and motor PCB assy. connector disconnected	Plug connector in (3-27)		
		Inlet assy. and power supply unit connector disconnected	Plug connector in (3-27)		
		Bad main PCB assy.	Replace main PCB assy. (2-7) (3-34)		
		Bad motor PCB assy.	Replace motor PCB assy. (2-15) (3-25)		
		Bad LCD	Replace LCD (2-8) (3-33)		
		Bad power supply PCB assy.	Replace power supply unit (2-13) (3-27)		
		Bad inlet assy.	Replace inlet assy. (2-14) (3-26)		
		Bad power supply cord	Replace power supply cord (2-13) (3-27)		
			Sewing machine lamp (LED lamp) does not light (machine operation normal)		
PCB unit: LED lamp-FR and SSVR PCB assy. connector disconnected	Plug connector in (3-31)				
Bad PCB unit: LED lamp-FL	Replace PCB unit: LED lamp-FL (2-13) (3-28)				
Bad PCB unit: LED lamp-FR	Replace PCB unit: LED lamp-FR (2-10) (3-31)				
Bad SSVR PCB assy.	Replace SSVR PCB assy. (2-10) (3-31)				
Bad motor PCB assy.	Replace motor PCB assy. (2-15) (3-25)				
Bad main PCB assy.	Replace main PCB assy. (2-7) (3-34)				
START/STOP lamp does not light	SSVR PCB assy. and main PCB assy. connector disconnected Bad SSVR PCB assy. Bad main PCB assy.	Plug connector in (3-31) (3-34)	Replace SSVR PCB assy. (2-10) (3-31) Replace main PCB assy. (2-7) (3-34)		

	Problem	Primary factors and causes	Repair method	Items for Inspection	Inspection method and standards
3	Even when the presser foot is raised with a straight line pattern, the sewing machine will not work (SS LAMP does not change green)	Bad PF switch assy. attachment position  PF switch assy. and motor PCB assy. connector connected Bad PF switch assy.	Adjust PF switch assy. attachment position (2-21) (3-20)  Plug connector in (3-35)  Replace PF switch assy. (2-21) (3-20)	Presser switch function	When the lift lever is lifted up and down, color of SS lamp change. <ul style="list-style-type: none"> <li>When the lift lever is raised: Red</li> <li>When the lift lever is lowered: Green</li> </ul>
4	Stitch skipping Thread abrasion Thread breakage	Bad needle interference adjustment Loose needle interference adjustment screw	Adjust needle interference (4-13)	Needle and tip gap	Refer to Clearance between needle and rotary hook point. (4-13)
		Bad front-back needle drop adjustment Bad needle plate A attachment position	Adjust back-front needle drop (4-17) Reattach needle plate A (3-57)	Back-front needle drop position	Refer to Needle and presser foot front/back position. (4-17)
		Bad needle bar rise adjustment Loose timing adjustment screws	Adjust needle bar rise (4-11)	Needle interference Needle and needle tip coincide	Refer to Needle bar rising. (4-11)
		Bad needle bar height adjustment Loose timing adjustment screws	Adjust needle bar height (4-12)	Needle bar height	Refer to Needle bar height. (4-12)
5	Does not start sewing (When press SS-button, electronic sounds)	main motor assy. and power supply unit connector disconnected Bad main motor assy.  Bad power supply PCB assy.	Plug connector in (3-27)  Replace main motor assy. (2-7) (3-34)  Replace power supply unit (2-13) (3-27)	Sewing machine runs when SS-button is pushed	Check that the sewing machine starts and stops when SS-button is pushed.
	Does not start sewing (When press SS-button, no electronic sounds)	SSVR PCB assy. and main PCB assy. connector disconnected NP PCB assy. and motor PCB assy. connector disconnected Bad SSVR PCB assy.  Bad NP PCB assy.  Bad foot controller jack assy.  Bad main PCB assy.  Bad motor PCB assy.	Plug connector in (3-34)  Plug connector in (3-27)  Replace SSVR PCB assy. (2-10) (3-31)  Replace NP PCB assy. (2-17) (3-25)  Replace foot controller jack assy.  Replace main PCB assy. (2-7) (3-34)  Replace motor PCB assy. (2-15) (3-25)		

	Problem	Primary factors and causes	Repair method	Items for Inspection	Inspection method and standards
6	Irregular rotation (rotation slow / fast / unstable)	<p>Grease or dust adhering to speed shutter</p> <p>Grease or dust adhering to NP sensor</p> <p>Bad NP PCB assy.</p> <p>Interference between NP PCB assy. and speed shutter</p> <ul style="list-style-type: none"> <li>• Damage to speed shutter</li> <li>• Damage to NP PCB assy.</li> </ul> <p>Bad motor PCB assy.</p> <p>Bad main PCB assy.</p>	<p>Remove grease or dust</p> <p>Remove grease or dust</p> <p>Replace NP PCB assy. (2-17) (3-25)</p> <p>Eliminate cause of interference</p> <p>Replace upper shaft assy. (2-32) (3-5)</p> <p>Replace NP PCB assy. (2-17) (3-25)</p> <p>Replace motor PCB assy. (2-15) (3-25)</p> <p>Replace main PCB assy. (2-7) (3-34)</p>	Machine operation while rotating	Rotate smoothly.
7	<p>Sewing sounds</p> <p>Inappropriate sounds</p> <ul style="list-style-type: none"> <li>• Thread take-up noise</li> <li>• Outer rotary hook noise</li> <li>• Upper shaft noise</li> <li>• Motor noise</li> <li>• Lower shaft noise</li> <li>• Needle contact noise</li> </ul>	<p>Shaft noise</p> <ul style="list-style-type: none"> <li>• Loose screws</li> </ul> <p>Outer rotary hook vertical rattle</p> <p>Upper shaft bushing out of oil</p> <p>Rattle along the thread take-up counter weight shaft</p> <p>Belt too tight</p> <p>Motor brush noise</p> <p>Lower shaft bushing out of oil</p> <p>Lower shaft axial rattle</p> <p>Noise of contact between needle and outer rotary hook</p> <ul style="list-style-type: none"> <li>• Bad needle interference adjustment</li> <li>• Loose needle interference adjustment screw</li> </ul>	<p>Retighten screws (2-41) (3-43)</p> <p>Reattach outer rotary hook (2-46) (3-56)</p> <p>Lubricate upper shaft bushing (3-5)</p> <p>Reattach thread take-up counter weight (2-42) (3-42)</p> <p>Adjust motor belt (4-7)</p> <p>Replace main motor assy. (2-15) (3-25)</p> <p>Lubricate lower shaft bushing (3-53)</p> <p>Reattach lower shaft B assy. (2-47) (3-55)</p> <p>Adjust needle interference</p>	Operating noise	Check that there is no abnormal noise at sewing.

	Problem	Primary factors and causes	Repair method	Items for Inspection	Inspection method and standards
8	Threading not possible	<p>Thread pushed out at the hook end</p> <ul style="list-style-type: none"> <li>Vertical slippage in needle thread block</li> </ul> <p>Hook extends right of the needle hole</p> <ul style="list-style-type: none"> <li>Wide gap between right side of needle and hook guide</li> <li>Needle curvature</li> <li>Needle slant (hole slant with slanted attachment of needle block)</li> <li>Threader hook assy. slippage</li> </ul> <p>Does not go into needle hole because of hook tip curvature</p>	<p>Adjust needle thread (4-14)</p> <p>Replace threader hook assy. (2-40) (3-45)</p> <p>Replace needle</p> <p>Replace needle bar (2-37) (3-49)</p> <p>Replace threader hook assy. (2-40) (3-45)</p> <p>Replace threader hook assy. (2-40) (3-45)</p>	Threading function	Con firm that the threading lever moves smoothly and that threading through the needle hole is possible.
	When the threader lever returns, it stops part way through.	<p>Threader shaft tangling</p> <p>Bad thread guide shape</p> <p>Needle thread shaft and top gap too small</p>	<p>Replace needle bar supporter assy. (2-38) (3-47)</p> <p>Replace hook assy. (2-40) (3-45)</p> <p>Replace needle bar supporter assy. (2-38) (3-47)</p>		
	Needle thread lever operation catches part way through.	<p>Bad needle stop position</p> <ul style="list-style-type: none"> <li>Bad NP PCB assy.</li> <li>Grease or dust adhering to NP PCB assy.</li> <li>Rotation shutter damage</li> <li>Bad needle thread block rotational position</li> </ul>	<p>Replace NP PCB assy. (2-17) (3-25)</p> <p>Remove grease or dust</p> <p>Replace upper shaft assy. (2-32) (3-5)</p> <p>Adjust needle thread block</p>		
9	Either upper thread tension or lower thread tension	<p>Upper thread tension is tight/loose</p> <p>Lower thread tension is too tight/loose</p> <p>Upper thread or lower thread unsuitable</p>	<p>Adjust upper thread tension (4-9)</p> <p>Adjust lower thread tension (4-19)</p> <p>Replace upper thread or lower thread</p>	<p>Upper thread tension</p> <p>Lower thread tension</p>	Check that the thread tension is good during actual sewing.



	Problem	Primary factors and causes	Repair method	Items for Inspection	Inspection method and standards
10	Embroidery sewing				
	• Needle breakage	Needle contacts outer rotary hook  Inner rotary hook release <ul style="list-style-type: none"> <li>• Inner rotary hook and inner rotary hook bracket assy. horizontal overlap is small</li> <li>• Inner rotary hook and inner rotary hook bracket assy. vertical overlap is small</li> </ul> Thread catches on spool presser (scratches on spool presser) Needle bends or needle tip breaks	Adjust clearance between needle and rotary hook point. (4-13)  Adjust inner rotary hook bracket assy. position (4-18)  Check the presence or absence of washer and spacer under the outer rotary hook shaft (2-46) (3-56)  Replace spool presser  Replace needle	Embroidery sewing	Check that the needle does not break during actual sewing and that there are no abnormal sounds during actual sewing.
	• Thread breakage stitch skipping	Bad needle bar rising adjustment Bad needle bar height adjustment Thread catches on spool presser (scratches on spool presser) Scratches on outer rotary hook Miss thread guide pathway	Adjust needle bar rising (4-11) Adjust needle bar height (4-12) Replace spool presser Replace outer rotary hook assy. (2-46) (3-56) Rethread	Embroidery sewing	Check that the thread does not break during actual sewing.
	• Seam unevenness	Presser foot inclines Scratches on inner rotary hook Scratches on outer rotary hook  Scratches around needle plate A needle hole Scratches on needle plate A surface Scratches around presser foot needle hole Burrs and scratches in thread guide pathway Lower thread slippage from thread tension spring of inner rotary hook	Adjust presser bar height (4-15) Replace inner rotary hook Replace outer rotary hook (2-46) (3-56) Replace needle plate A (2-45) (3-58)  Replace presser foot (2-41) (3-44) Replace parts with burrs and scratches Reset lower thread	Embroidery sewing	Check that stitches are not uneven during actual sewing.
• Stops during sewing	No gap for BW switch No play in SS-button, reverse button or vertical stop button	Adjust BW switch assy. position (2-27) (3-12) Reassemble SSVR PCB assy. (2-10) (3-31)	Embroidery sewing	Check that it does not stop during actual sewing.	

	Problem	Primary factors and causes	Repair method	Items for Inspection	Inspection method and standards
11	Upper thread detect does not operate normally	<p>Bad upthread PCB assy.</p> <p>Upthread PCB assy. and main PCB assy. connector disconnected</p> <p>Bad thread cutting shutter operation or broken</p> <p>Deformed thread take up spring or broken</p> <p>Bad motor PCB assy.</p> <p>Bad main PCB assy.</p>	<p>Replace upthread PCB assy. (2-19) (3-21)</p> <p>Plug connector in (3-34)</p> <p>Replace thread cutting shutter (2-29) (3-10)</p> <p>Replace thread take up spring (2-23) (3-17)</p> <p>Replace motor PCB assy. (2-15) (3-25)</p> <p>Replace main PCB assy. (2-7) (3-34)</p>	Detecting upper thread function	When set the upper thread and sew, detect the presence or absence of the upper thread.
	Lower thread detect does not operate normally	<p>Grease or dust adhering to lower thread sensor</p> <p>Lower thread sensor and motor PCB assy. connector disconnected</p> <p>Bad lower thread sensor</p> <p>Bad motor PCB assy.</p> <p>Bad main PCB assy.</p>	<p>Remove grease or dust from photo diode holder assy. (2-46) (3-56)</p> <p>Remove grease or dust from photo transistor assy. (2-50) (3-63)</p> <p>Plug connector of photo diode holder assy. in (3-56)</p> <p>Plug connector of photo transistor assy. in (3-63)</p> <p>Replace photo diode holder assy. (2-46) (3-56)</p> <p>Replace photo transistor assy. (2-50) (3-63)</p> <p>Replace motor PCB assy. (2-15) (3-25)</p> <p>Replace main PCB assy. (2-7) (3-34)</p>	Detecting lower thread remaining amount function	When set the bobbin that roll the thread and sew, defect the presence or absence of the lower thread.
12	Touch panel does not react	<p>Bad touch panel adjustment</p> <p>Touch panel assy. and main PCB assy. FPC disconnected</p> <p>Bad touch panel assy.</p> <p>Bad panel PCB assy.</p>	<p>Adjust touch panel attachment position (4-5)</p> <p>Lock it after connect FPC to connector (3-34)</p> <p>Replace touch panel assy. (2-8) (3-33)</p> <p>Replace panel PCB assy. (2-10) (3-31)</p>	Selecting pattern function	Check to be able to select the pattern from the touch panel.

	Problem	Primary factors and causes	Repair method	Items for Inspection	Inspection method and standards
13	Thread cutter does not operate, even if press thread cutter switch	<p>Bad thread cutter pulse motor</p> <p>Thread cutter pulse motor and motor PCB assy. connector disconnected</p> <p>Thread cutter lever gear operation is heavy.</p> <p>Bad SSVR PCB assy.</p> <p>Bad motor PCB assy.</p> <p>Bad main PCB assy.</p>	<p>Replace thread cutter pulse motor (2-52) (3-60)</p> <p>Plug connector in (3-35)</p> <p>Reattach part that operation is heavy.</p> <p>Replace SSVR PCB assy. (2-10) (3-31)</p> <p>Replace motor PCB assy. (2-15) (3-25)</p> <p>Replace main PCB assy. (2-7) (3-34)</p>	Thread cutter function	Check that the thread is cut surely.
	Thread does not cut through thread cutter operate	<p>Lint or dirt adhering to thread hook assy.</p> <p>Bad timing to turn out of thread hook assy.</p> <ul style="list-style-type: none"> <li>• Grease or dust adhering to NP sensor</li> <li>• Bad NP PCB assy.</li> <li>• NP PCB assy. and motor PCB assy. connector disconnected</li> <li>• Timing shutter and NP PCB assy. interfere</li> </ul> <p>Thread hook assy. does not scoop thread</p> <ul style="list-style-type: none"> <li>• Bad thread hook assy. shape</li> <li>• Float spring plate thread hook lever</li> </ul> <p>Blunt lower thread cutter</p>	<p>Remove lint or dirt</p> <p>Remove grease or dust</p> <p>Replace NP PCB assy. (2-17) (3-25)</p> <p>Plug connector in (3-35)</p> <p>Clear off cause of interference</p> <p>Replace thread cutter assy. (2-29) (3-10)</p> <p>Replace spring plate (2-29) (3-10)</p> <p>Replace cutter pile assy. (2-5) (3-36)</p>		
14	Bobbin winder shaft not turning	<p>BW switch assy. and motor PCB assy. connector disconnected</p> <p>Bad BW switch assy.</p> <p>Bad BW switch assy. attachment position</p> <p>Bad motor PCB assy.</p> <p>Bad main PCB assy.</p>	<p>Plug connector in (3-35)</p> <p>Replace BW switch assy. (2-27) (3-12)</p> <p>Adjust BW switch attachment position (2-27) (3-12)</p> <p>Replace motor PCB assy. (2-15) (3-25)</p> <p>Replace main PCB assy. (2-7) (3-34)</p>	Bobbin winder function	Operate the bobbin winder, and check that there is no uneven bobbin winder or abnormal noise. Check that the amount of thread wound onto the bobbin is 80-90% of the bobbin diameter.
	Bobbin winding amount unsuitable	<p>Bad bobbin presser adjustment</p> <p>Loose bobbin presser attachment screw</p>	<p>Adjust bobbin presser position (4-16)</p>		
	Bobbin winder winds unevenly	<p>Bad bobbin winder guide assy. height adjustment</p> <p>Loose bobbin winder guide assembly screw</p>	<p>Adjust bobbin winder guide (4-16)</p>		

	Problem	Primary factors and causes	Repair method	Items for Inspection	Inspection method and standards
15	Embroidery machine does not operate	<p>X pulse motor and emb relay PCB assy. connector disconnected</p> <p>Y pulse motor and YPM lead wire connector disconnected</p> <p>YPM lead wire and emb relay PCB assy. connector disconnected</p> <p>Lead wire assy. and emb relay PCB assy. connector disconnected</p> <p>Lead wire assy. and motor PCB assy. connector disconnected</p> <p>Bad X pulse motor</p> <p>Bad Y pulse motor</p> <p>Bad emb relay PCB assy.</p> <p>Broken YPM lead wire</p> <p>Bad Y sensor PCB assy.</p> <p>Broken lead wire assy.</p> <p>Broken lead wire assy.</p> <p>Others</p>	<p>Plug connector in (3-74)</p> <p>Plug connector in (3-69)</p> <p>Plug connector in (3-74)</p> <p>Plug connector in (3-74)</p> <p>Plug connector in (3-35)</p> <p>Replace X pulse motor (2-59) (3-72)</p> <p>Replace Y pulse motor (2-63) (3-68)</p> <p>Replace emb relay PCB assy. (2-58) (3-74)</p> <p>Replace lead wire supply assy: sleeve (2-61) (3-69)</p> <p>Replace lead wire assy. (2-56) (3-76)</p> <p>Replace motor PCB assy. (2-15) (3-25)</p> <p>Replace main PCB assy. (2-7) (3-34)</p>	Embroidery function	Check that the carriage moves surely.

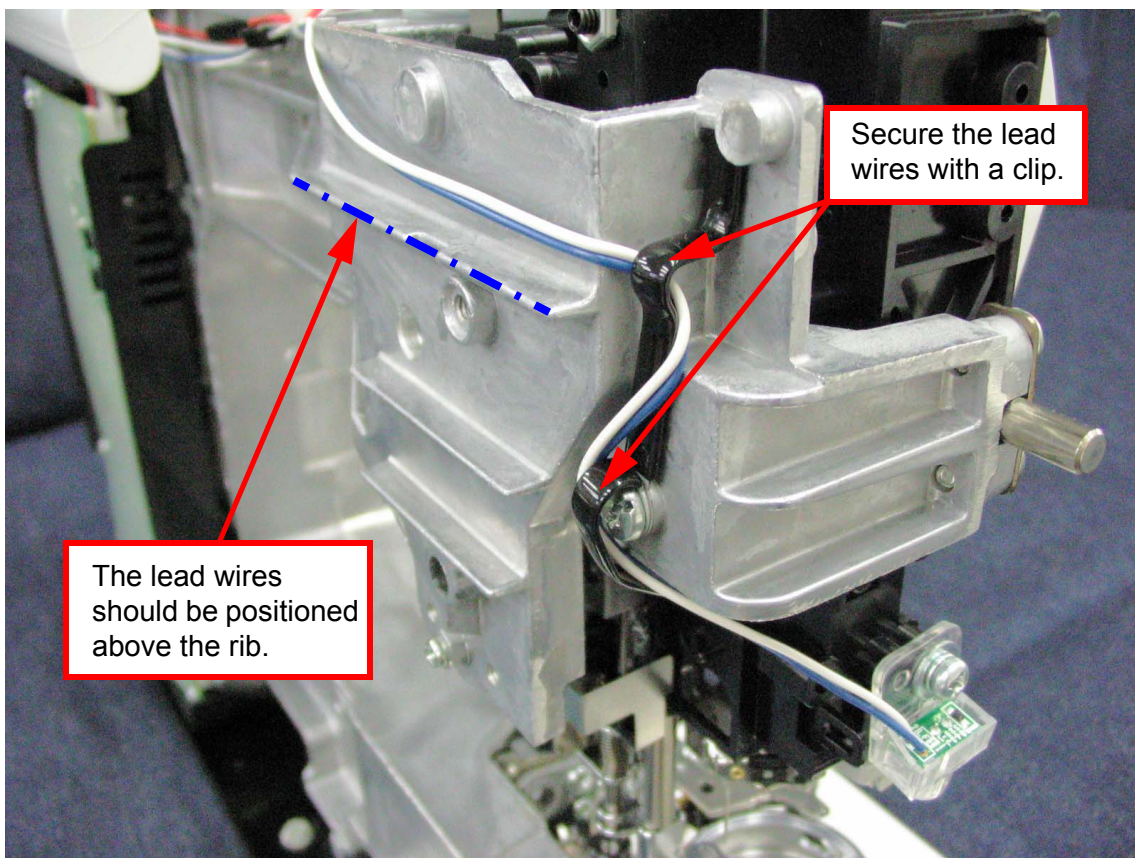


# 7 Special Instructions of Wiring

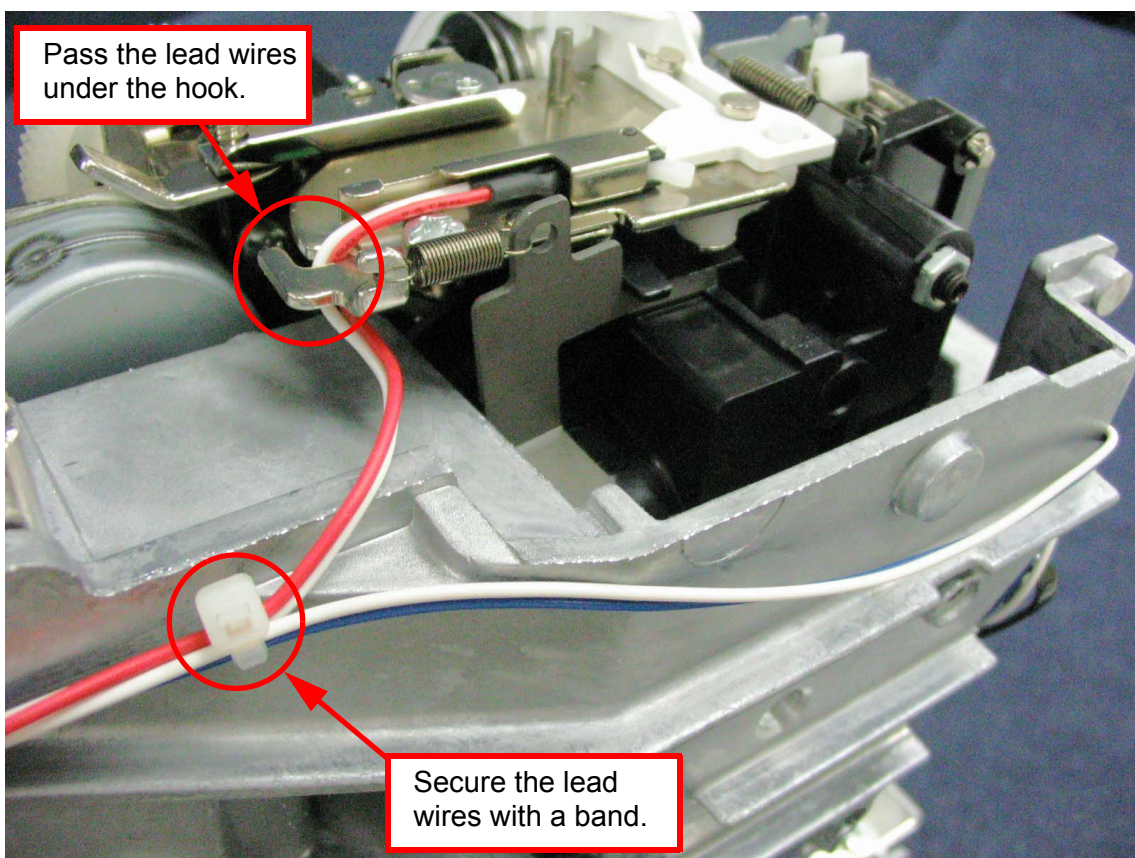
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Needle bar module wiring .....	7 - 2
Rotary hook module wiring .....	7 - 5
Motor PCB assembly wiring .....	7 - 6
Front cover assembly wiring .....	7 - 9
Embroidary unit assembly wiring .....	7 - 10

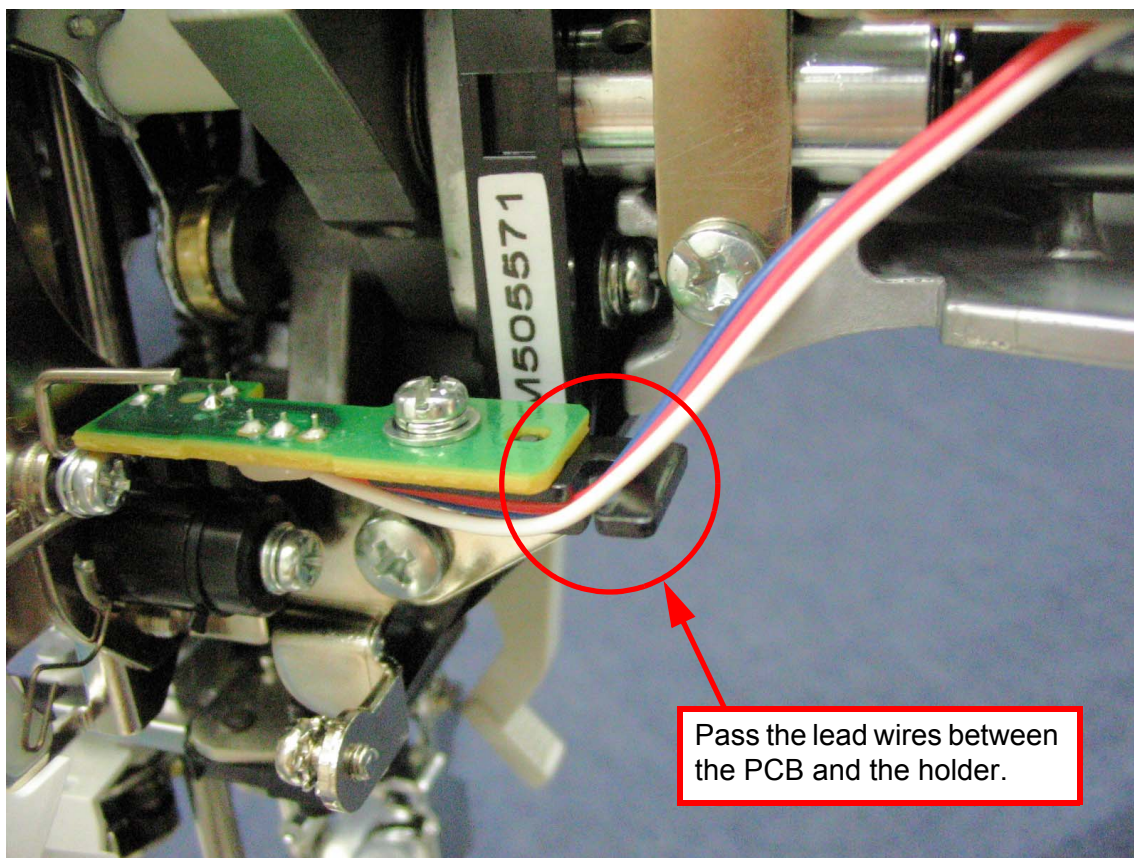
1. Wiring on left side of needle-presser module



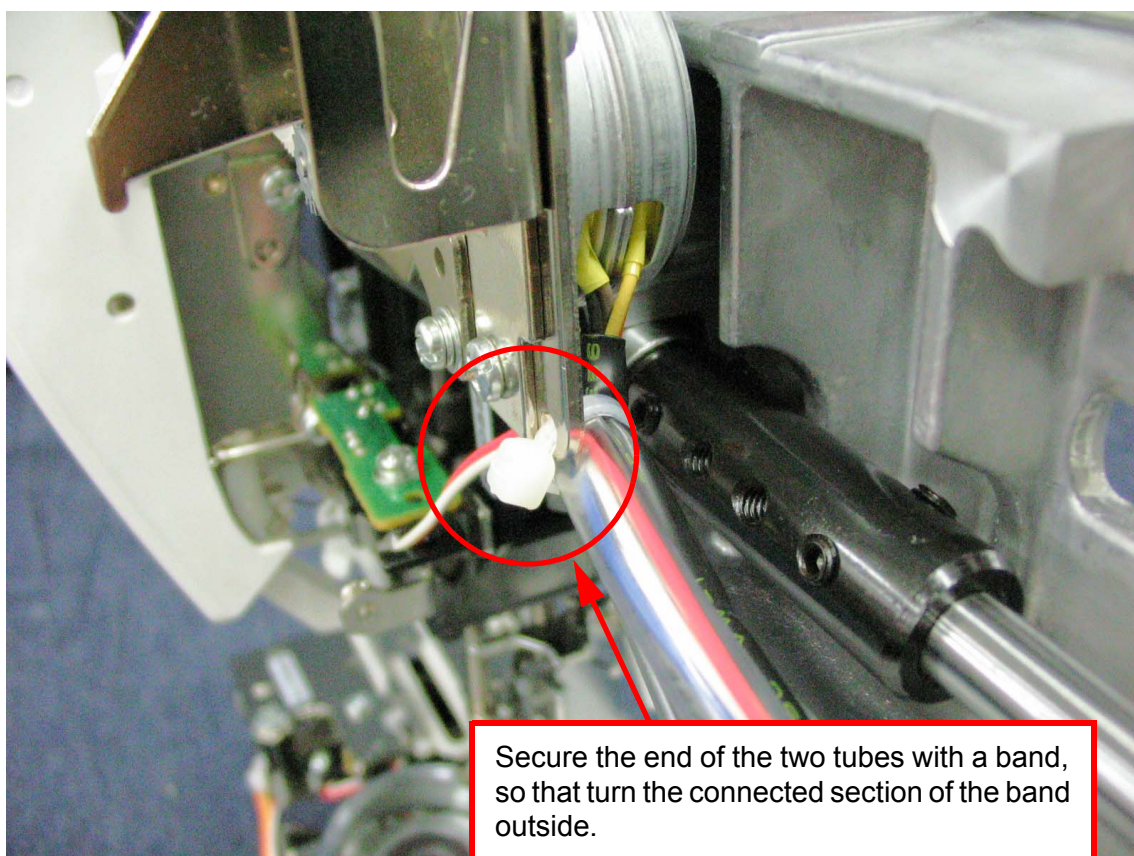
2. Wiring on upper side of needle-presser module



## 3. Wiring on right side of needle-presser module

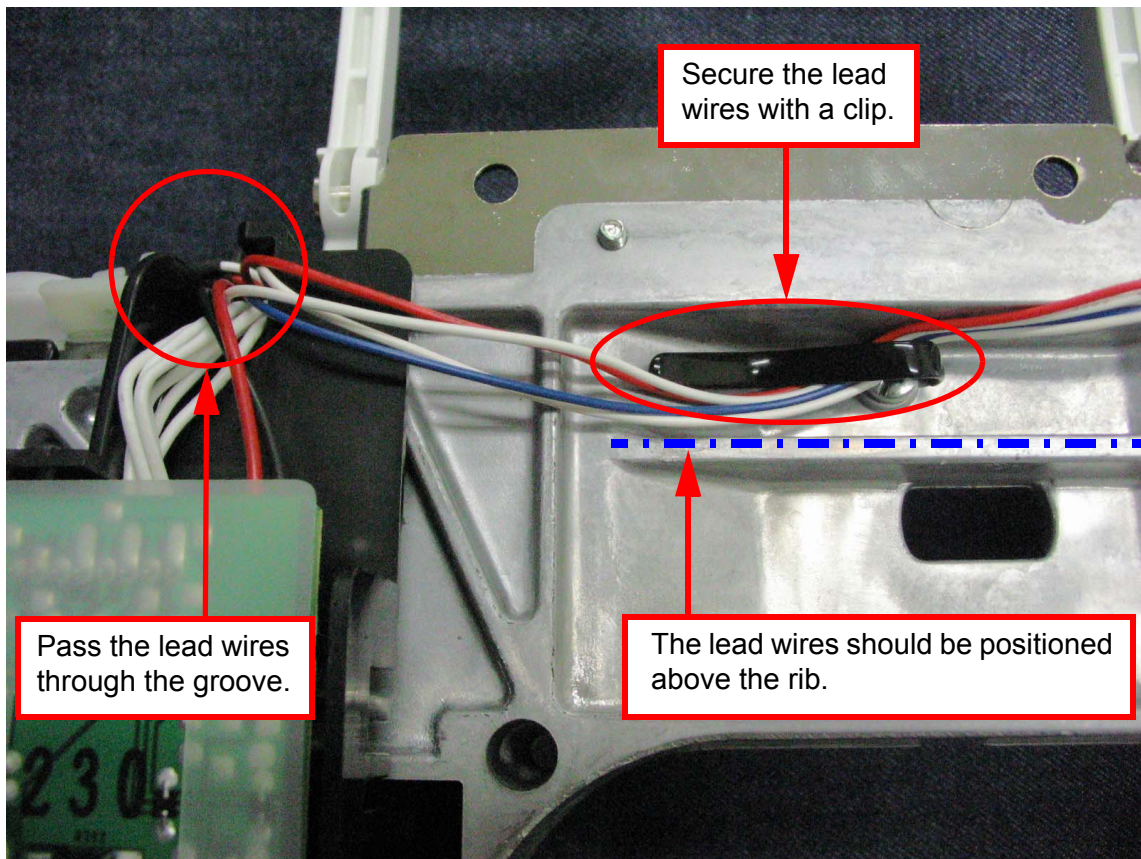


## 4. Wiring on right side of AT pulse motor assembly

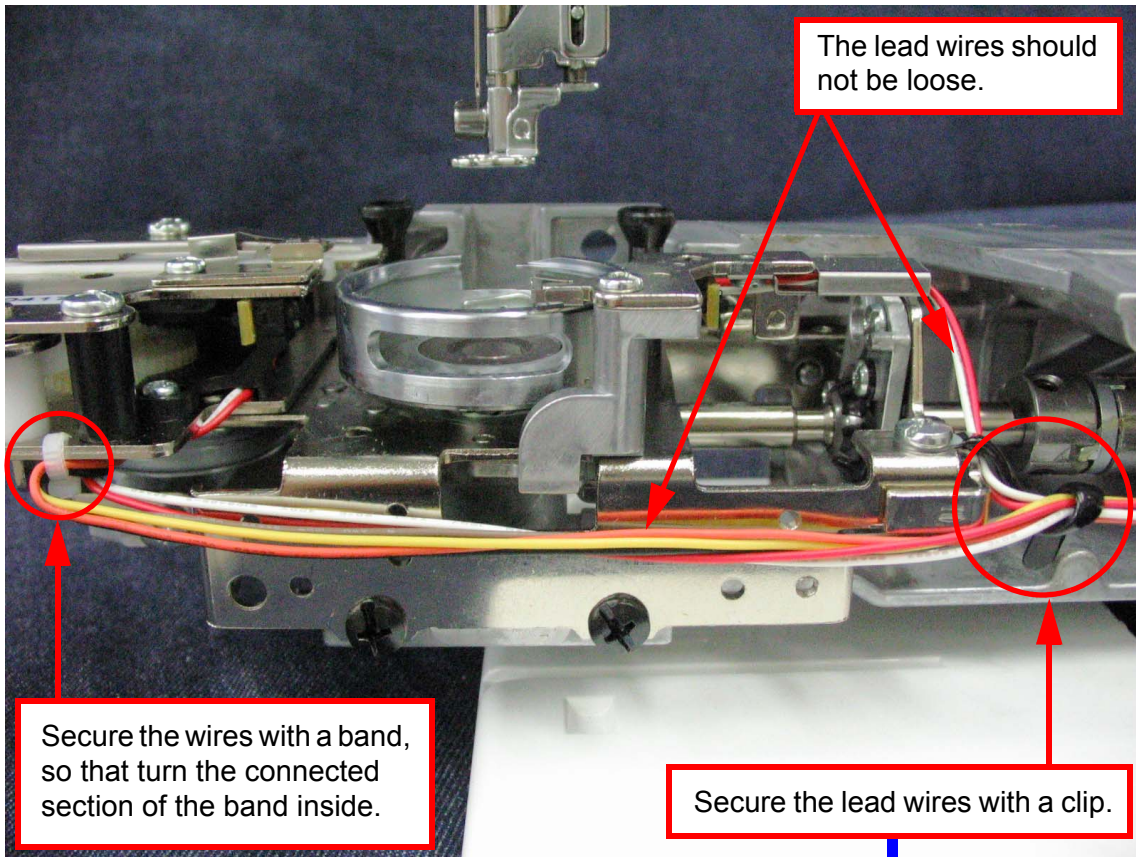




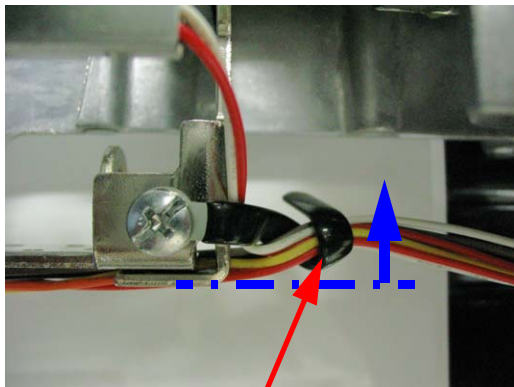
5. Wiring on back side of arm bed



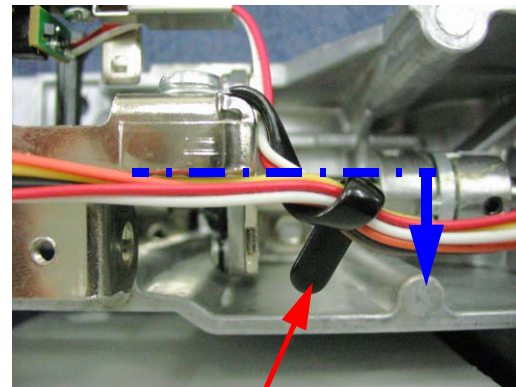
1. Wiring on front side of rotary hook module



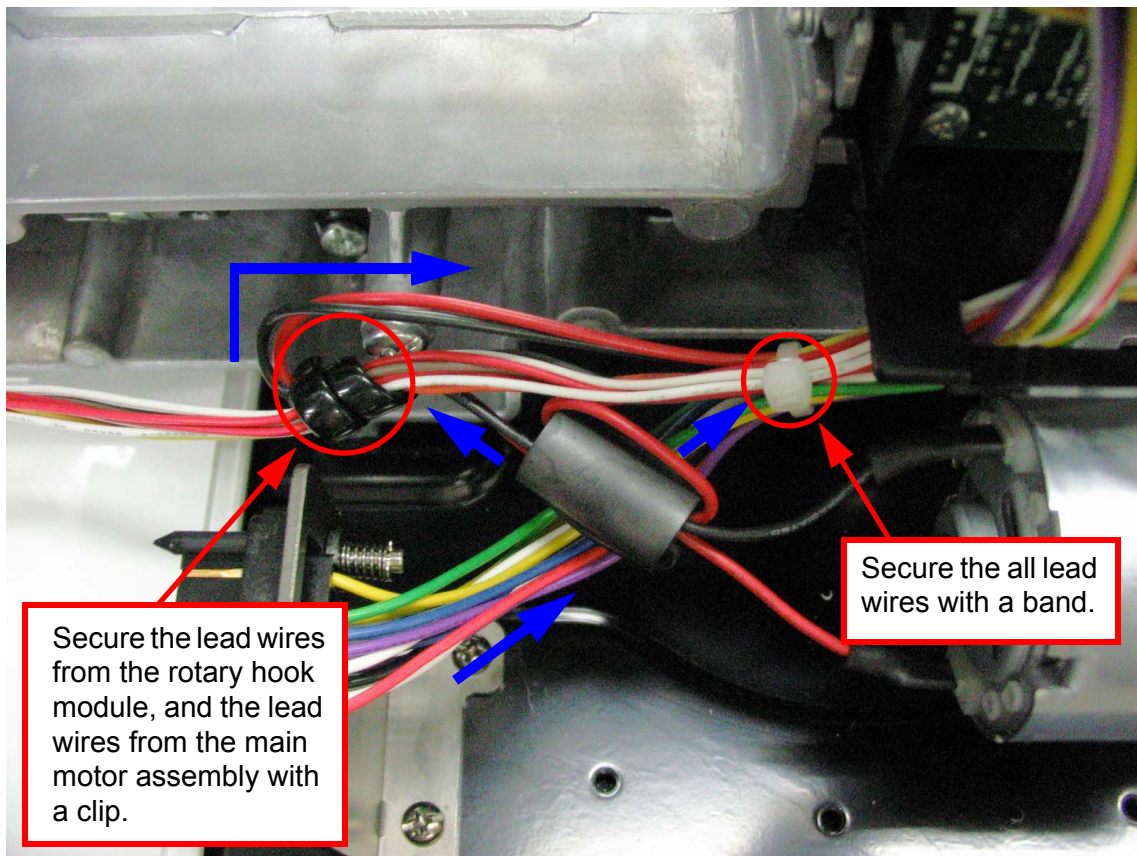
An enlarged figure from the upper side



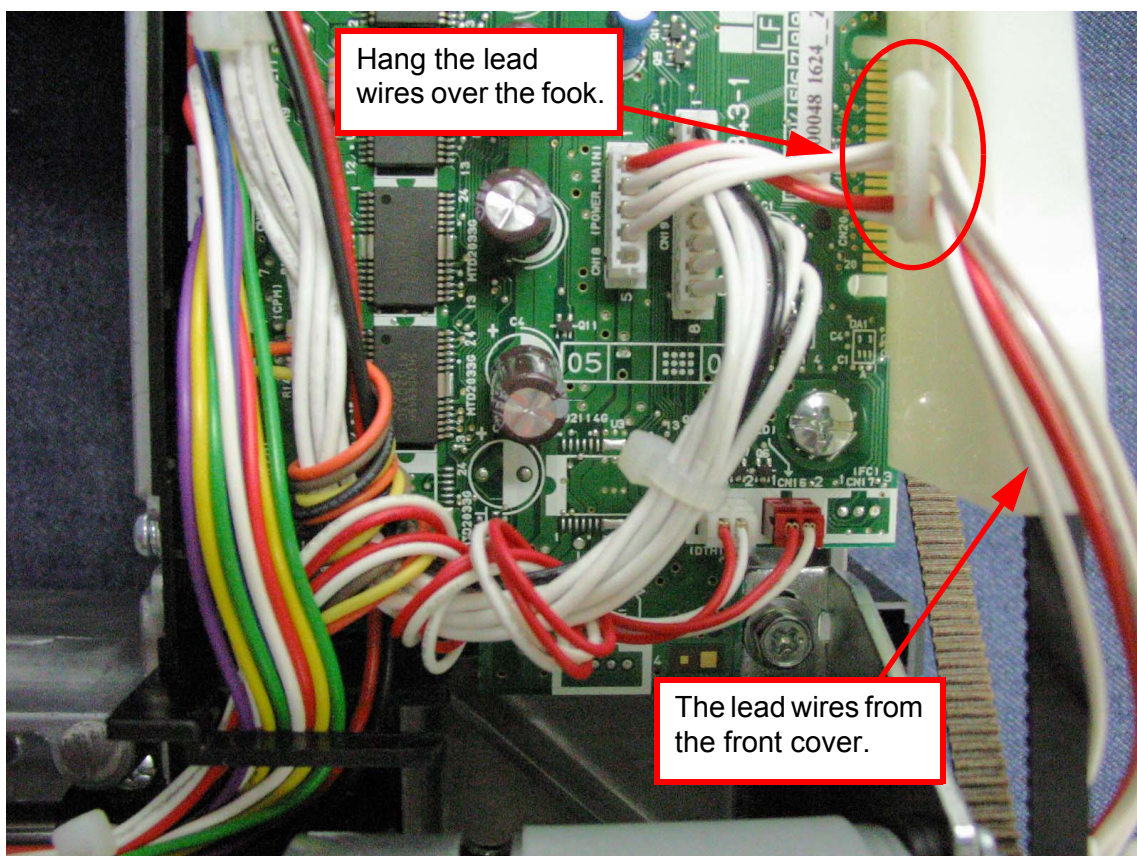
An enlarged figure from the front side



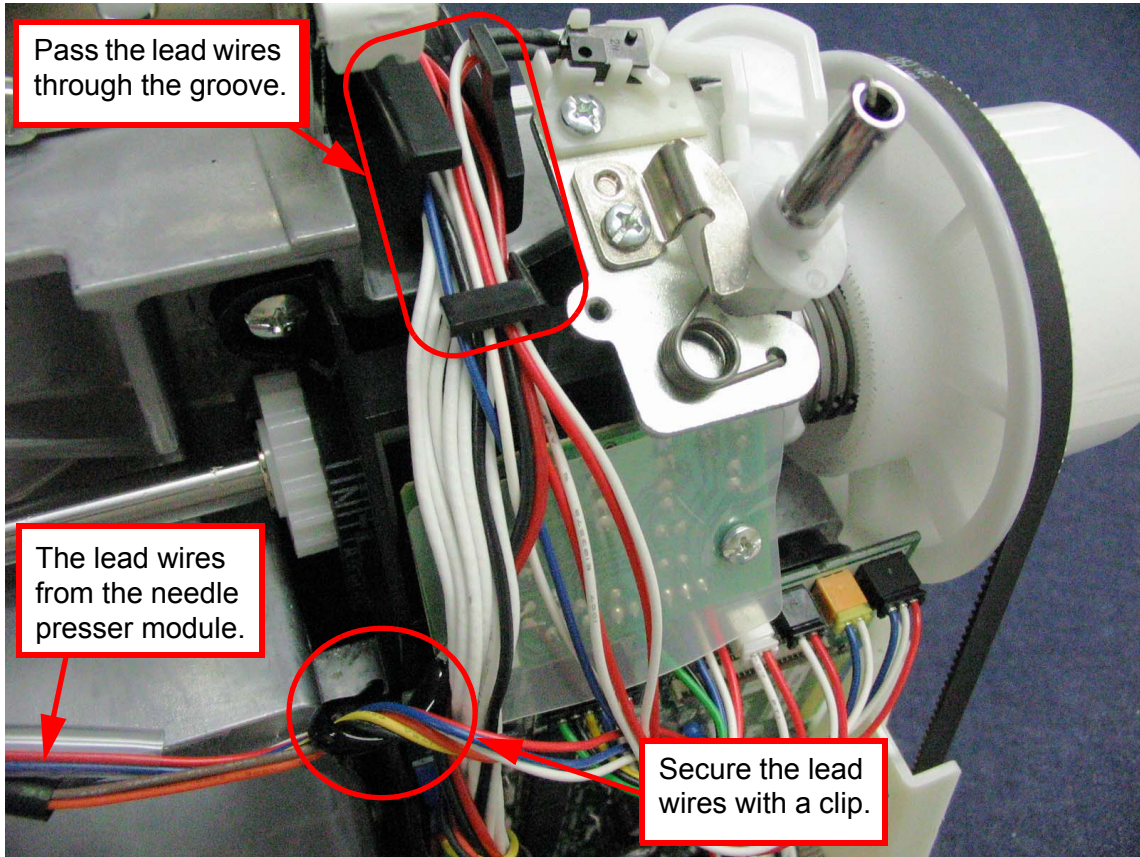
1. Wiring at lower left section of motor PCB



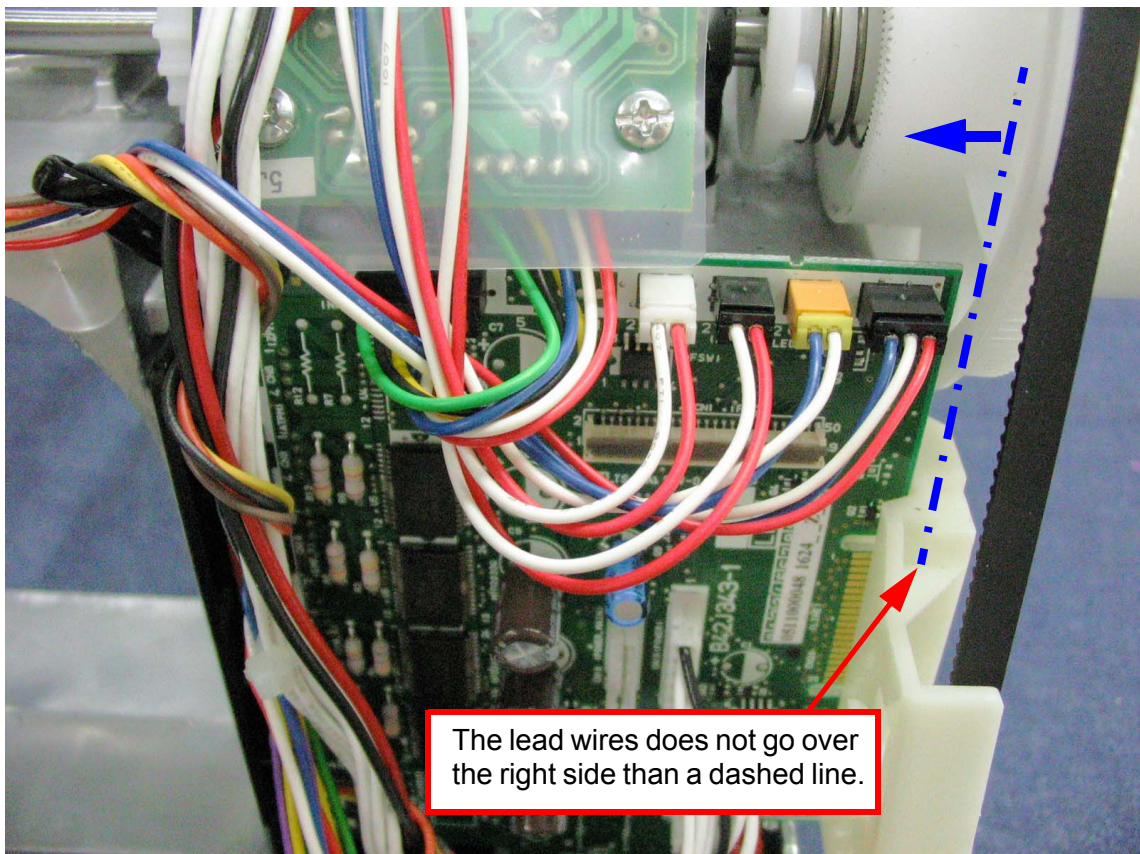
2. Wiring at lower section of motor PCB



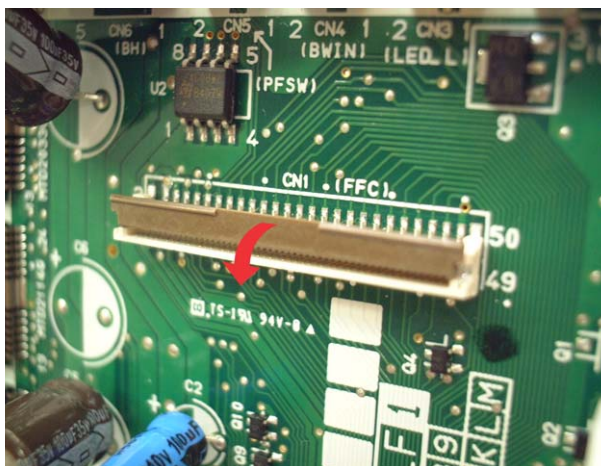
3. Wiring at top side of motor PCB



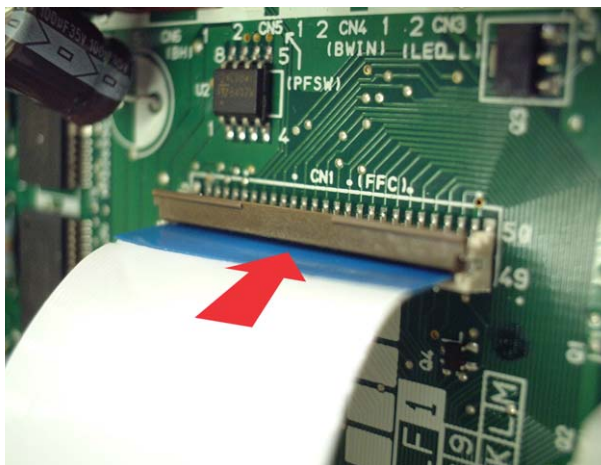
4. Wiring at upper section of motor PCB



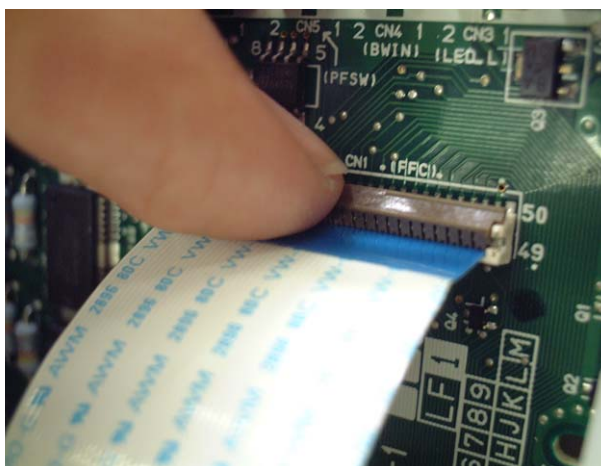
## 5. Wiring at middle section of motor PCB (Connecting the FFC from front cover assembly)



1. Raise the flap of the connector.

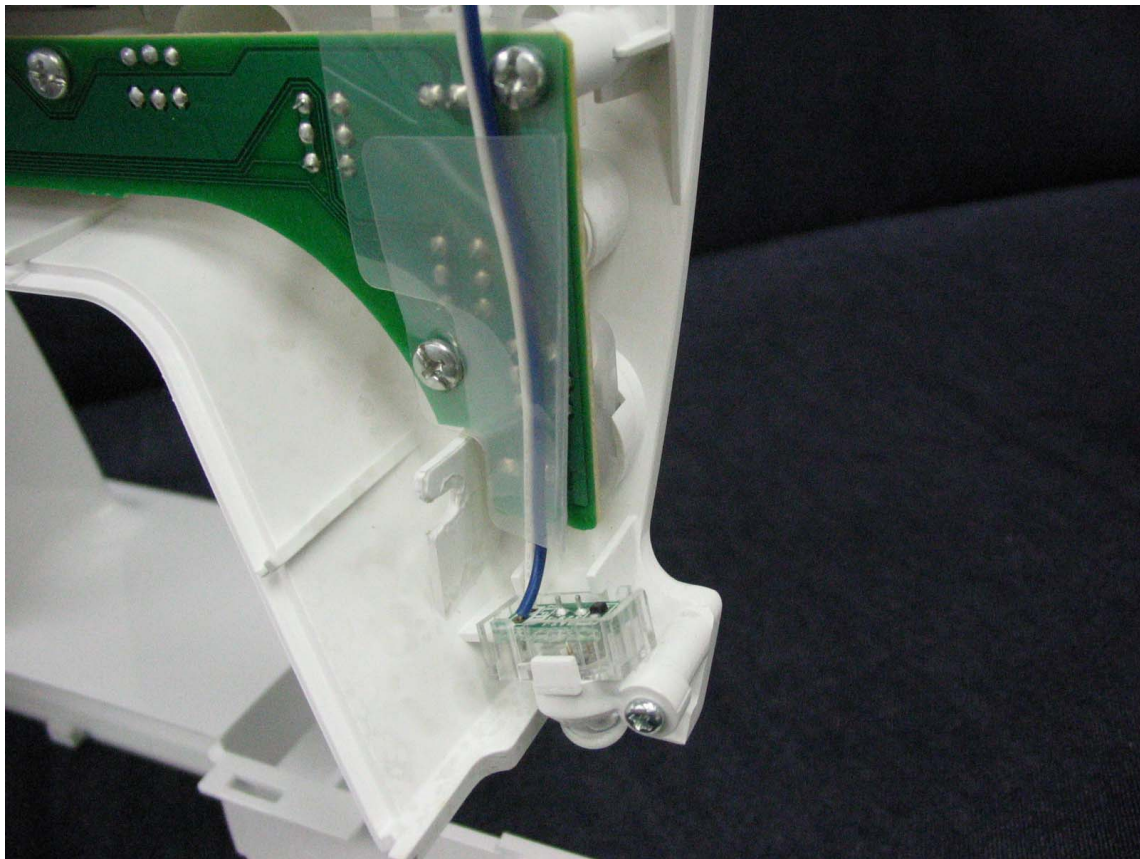


2. Insert the FFC in the connector.

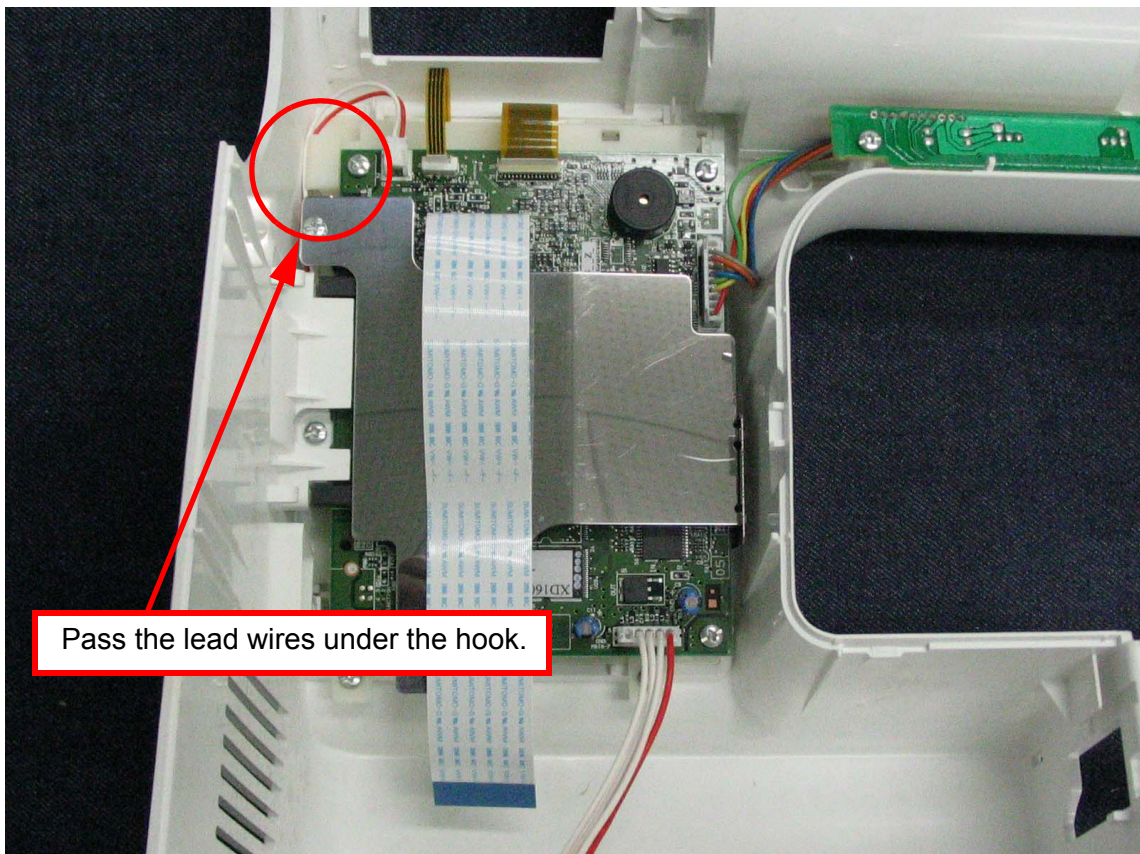


3. Push down the flap of the connector.

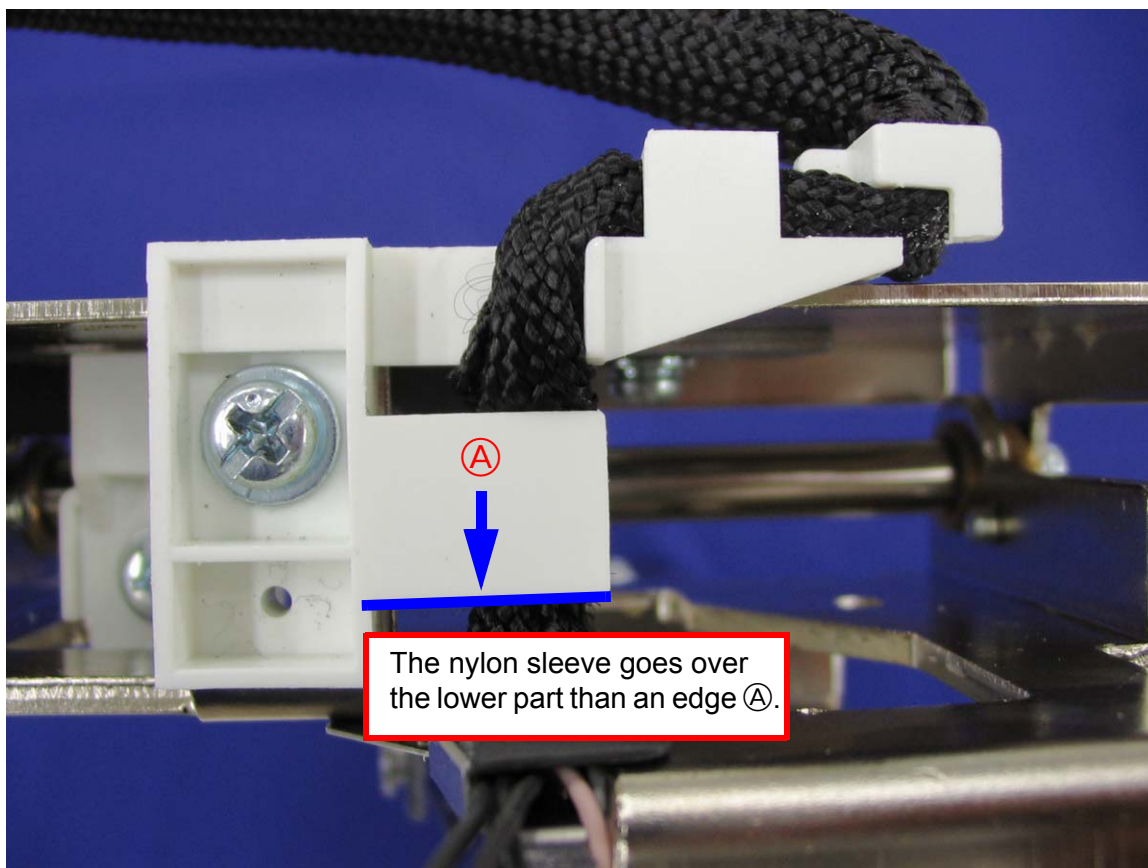
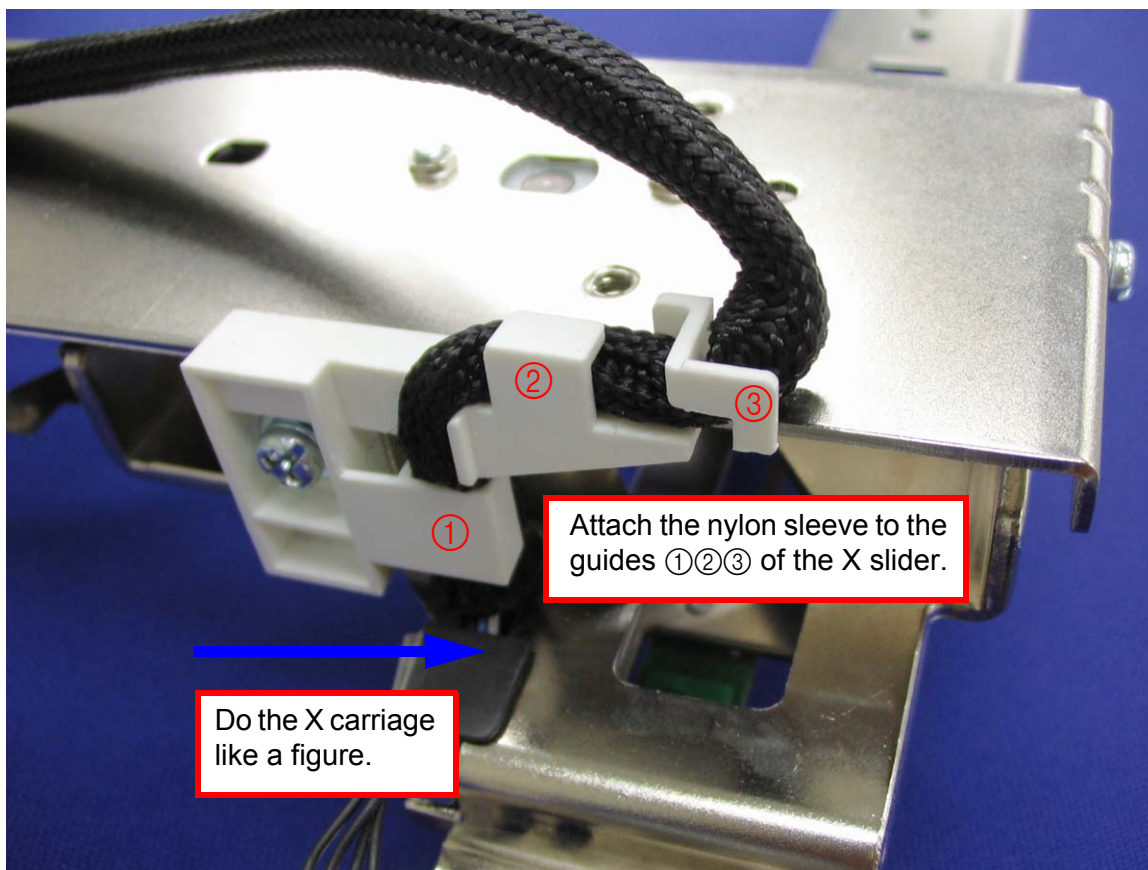
1. Wiring of LED lamp assembly



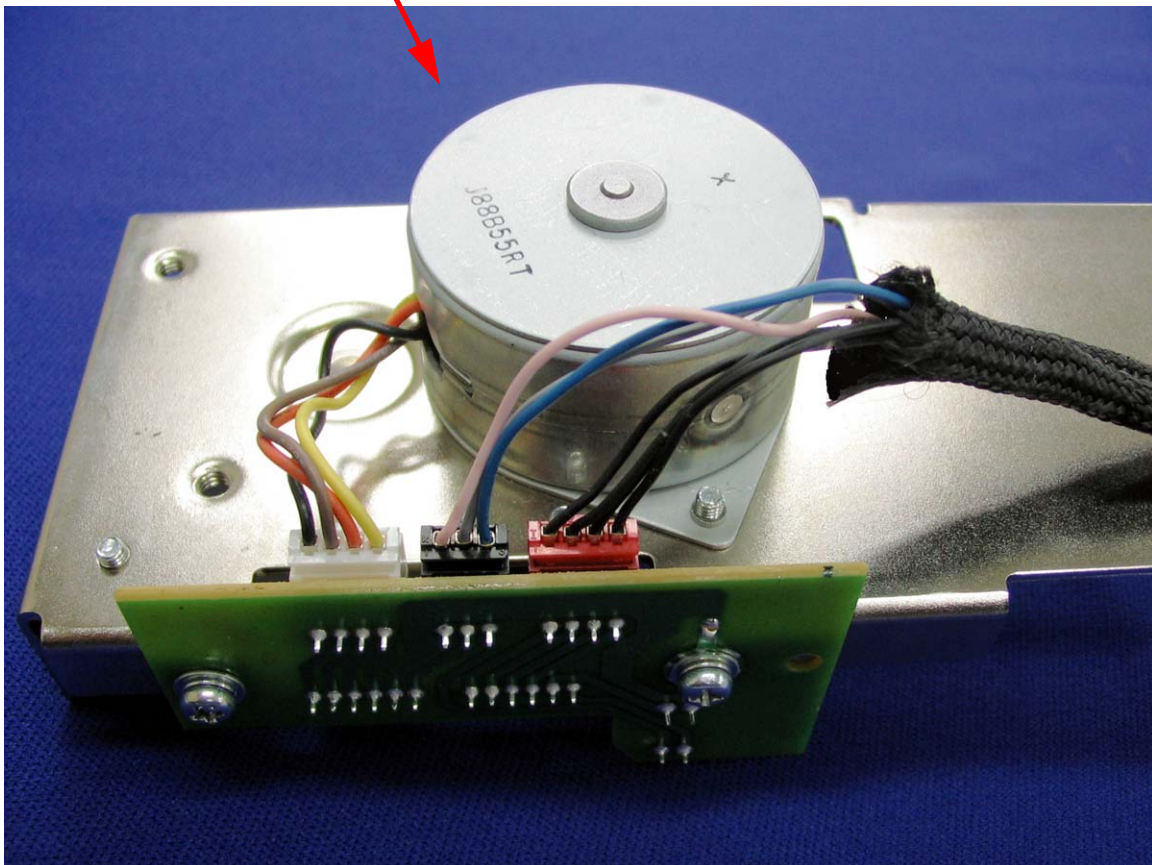
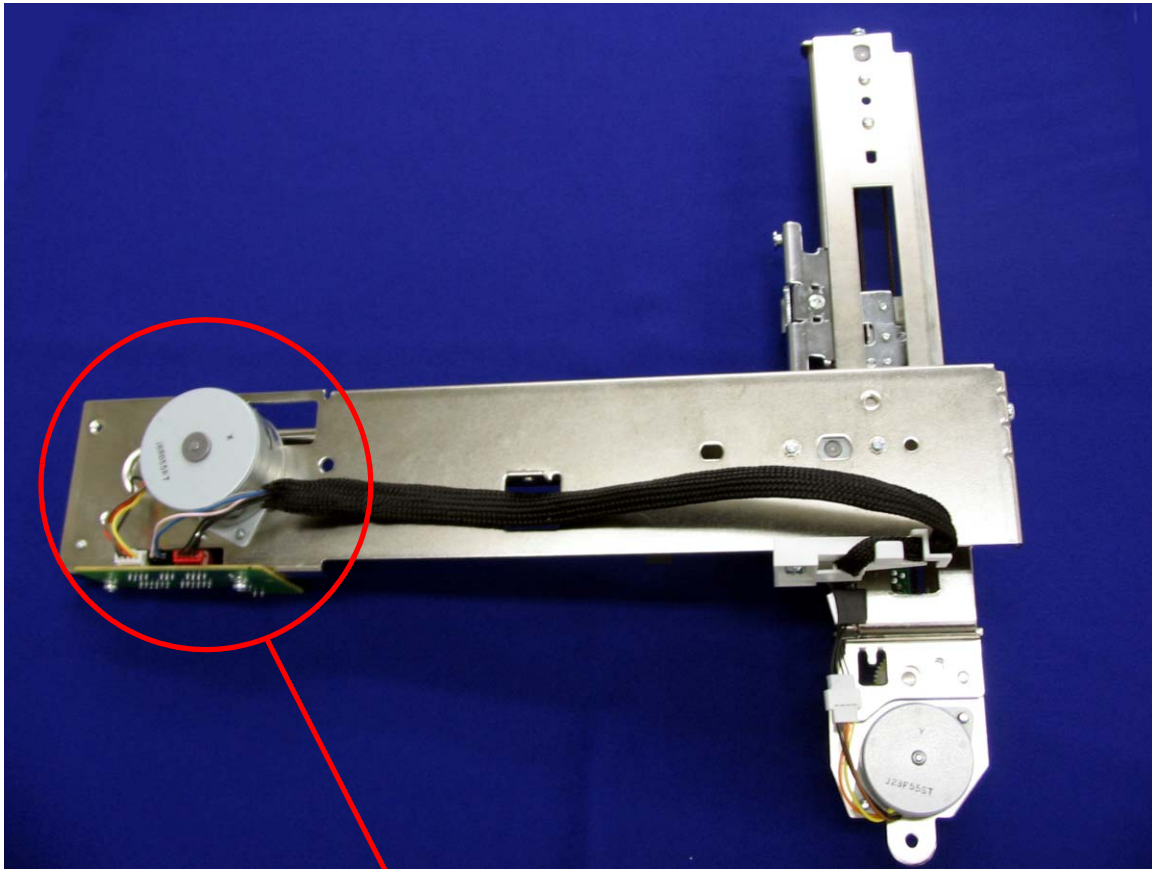
2. Wiring of main PCB assembly



1. Wiring of X slider assembly

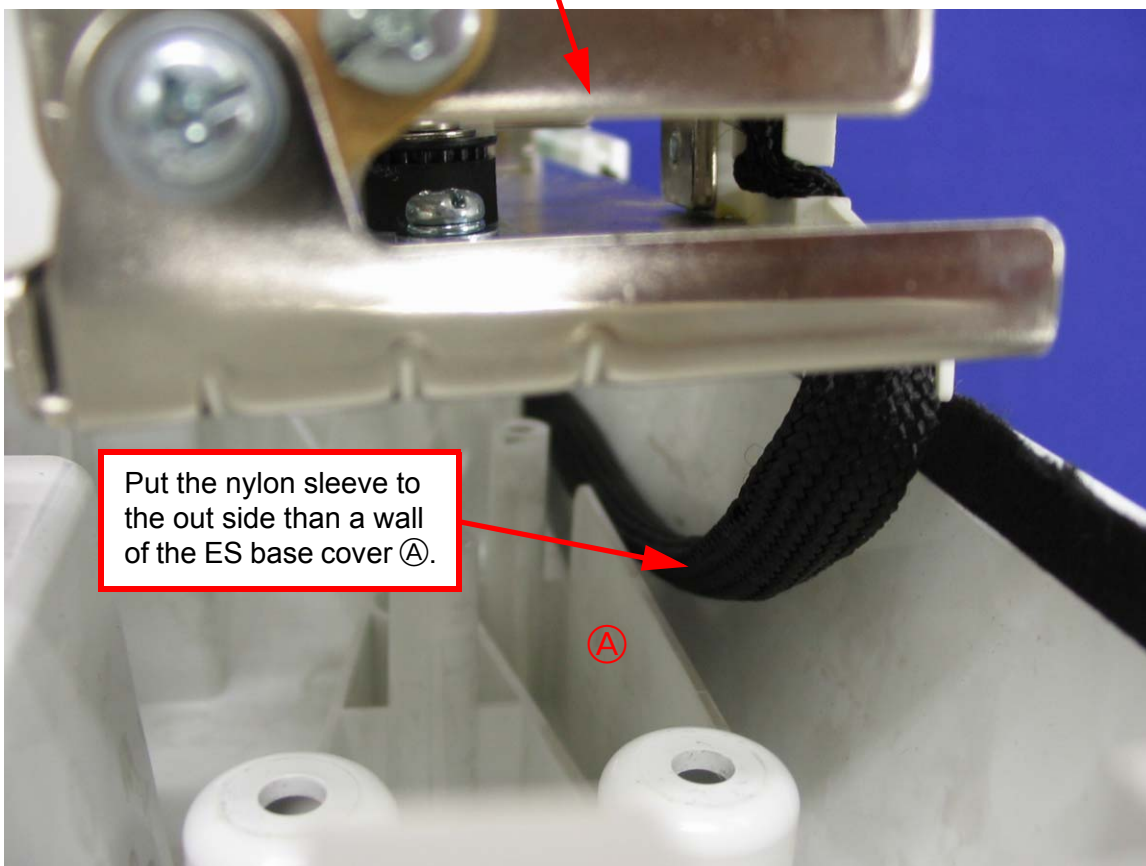
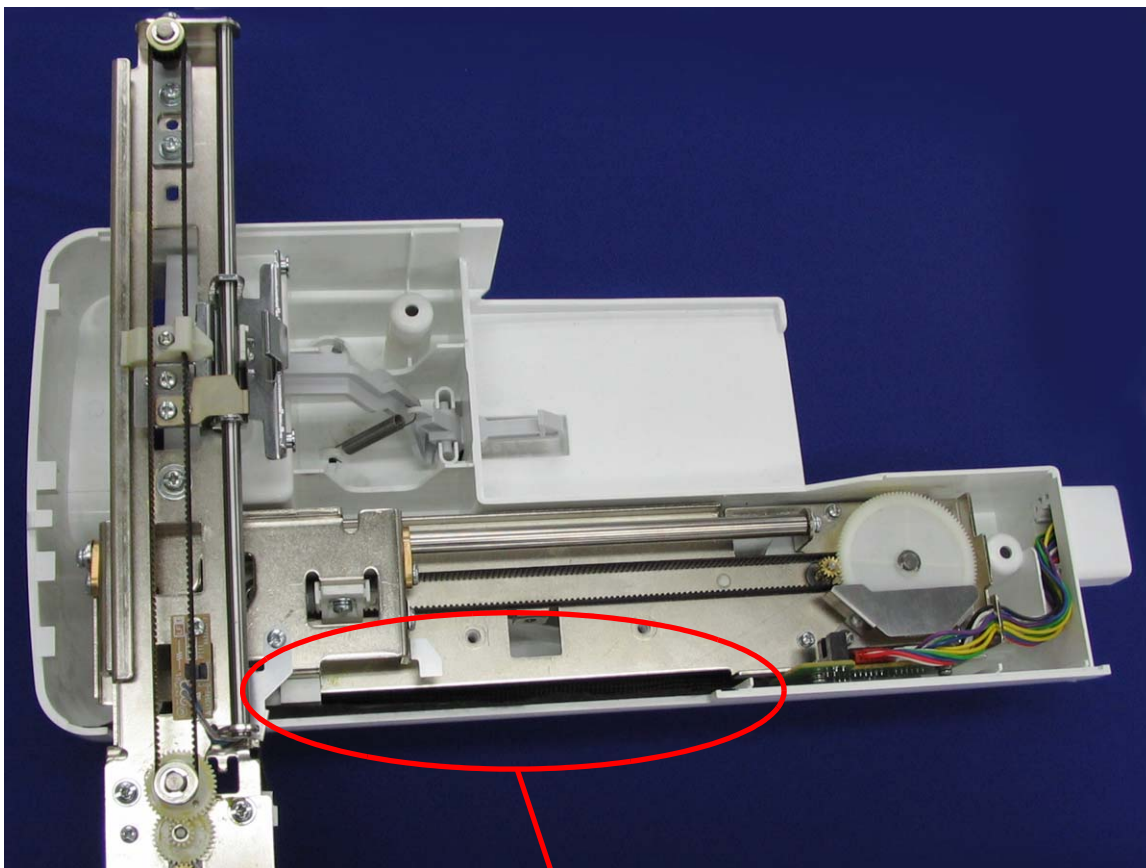


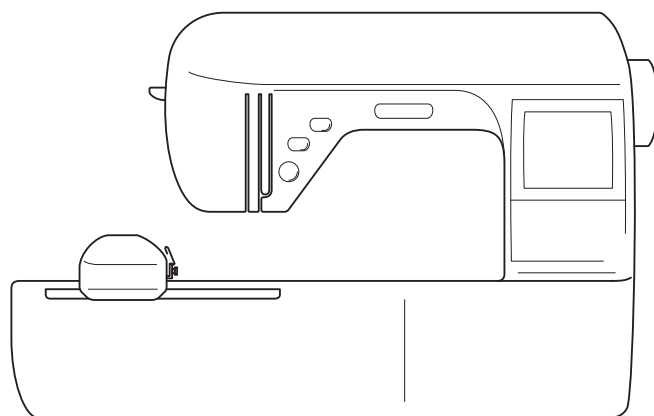
2. Wiring on back side of mainframe





3. Wiring on lower side of embroidery driving assembly





***PE780D/PE770/NV750E***  
***DZ820E/SB7900E/NV770E***