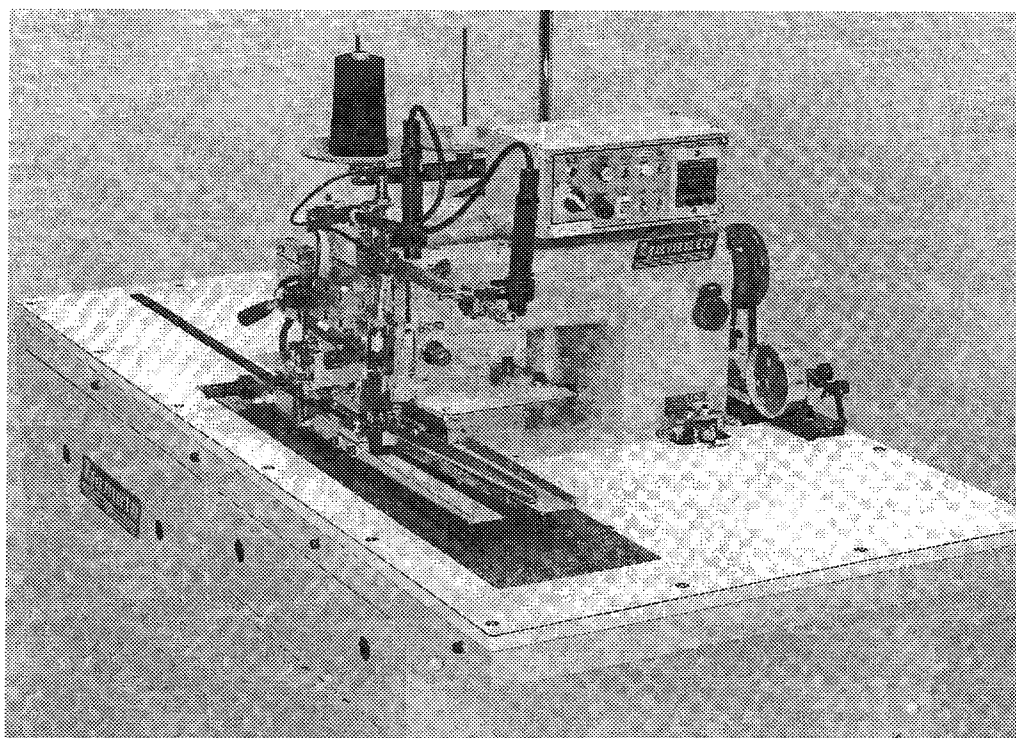


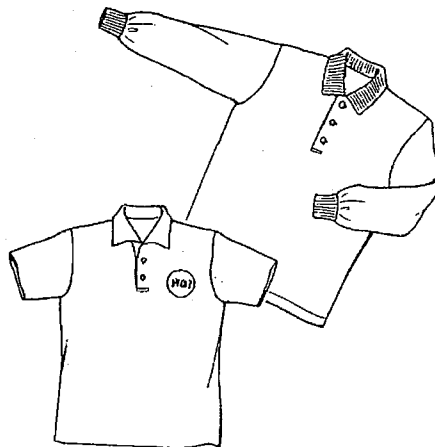
Yamato[®]

INSTRUCTIONS
FOR
CLASS PV-270/RP-1



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1. Specifications

Sewing Speed:	Max. 2,000 stitch/min
Sewing Length:	60~270mm
Sewing width:	3~6mm
Stitch Length:	standard 2.3mm
Productivity:	900~1,200pcs/8hrs (This may be changed according to the sewing condition.)
Power Supply:	standard 3 phase, 200V, 50Hz, 550W
Air Supply:	0.55MPa(5.5kgf/cm ²), 10 ℓ/min(Air Compressor is required.)
Sewing Head:	1 needle lock stitch with reverse stitch (at the sewing start and finish)
Needle to be used:	Organ DB×1 #14 (standard) or DB×1KN #11
Thread to be used:	spun yarn #50 or #60, polycore thread #50

2. Installation

2-1 Unpacking

After unpacking carefully, check that Machine is not damaged.

2-2 Installation

Adjust the height and level with 4 Casters.

2-3 Removing Shipping Lock

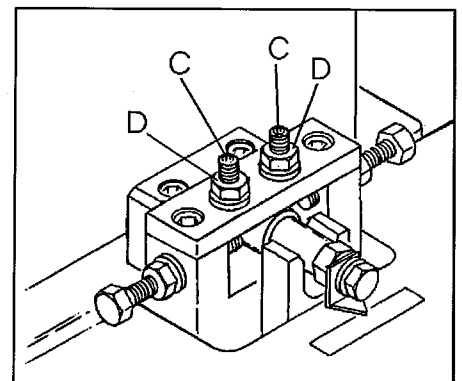
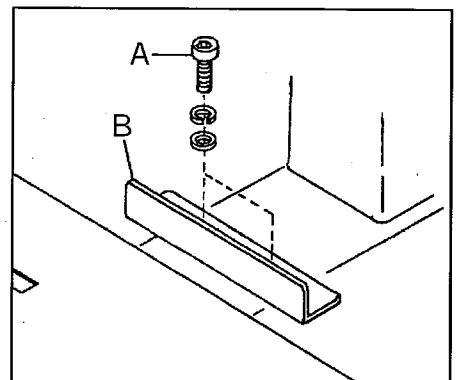
Sewing Head has been fixed by Shipping Lock(B) not to move up and down in transport.

Loosen Screws(A) before removing Shipping Lock(B).

Sewing Head has been fixed by 2 Stop Screws(C).

Loosen Lock Nuts(D) before turning Stop Screws(C) to the clockwise to move Sewing Head right and left slightly.

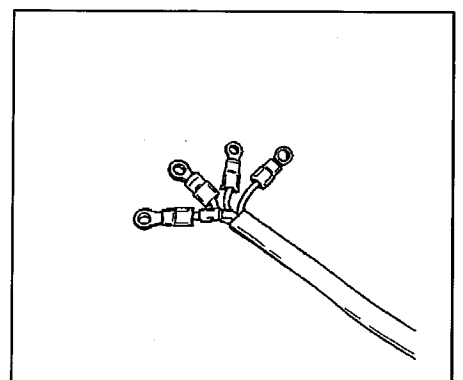
Then, fix Sewing Head with Lock Nuts(D).

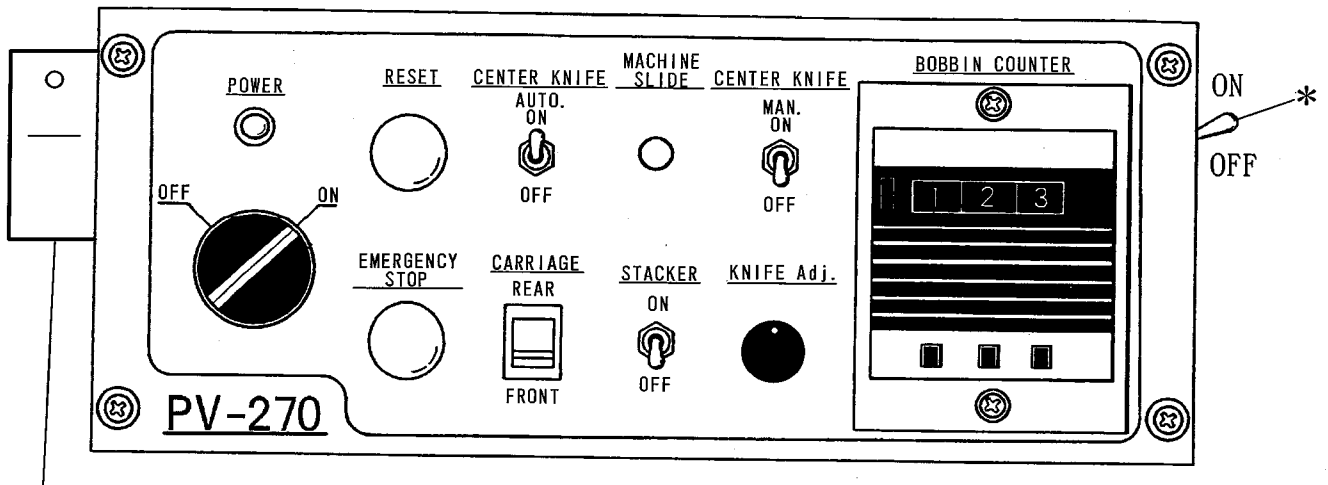


2-4 Connection of Power Cords

Connect red, black, and white cords of Power Cords to the power supply system of the factory. Green cord is an earth line. Connect it correctly.

Note: A machine may malfunction because of an electric noise, if you do not connect it correctly.





Needle Thread Monitor (*: Needle Thread Monitor Switch)

2-5 Checking the rotating direction of Carriage Motor and Positioner Motor

To check the moving of Carriage, turn ON Power Source Switch. When turning Carriage Switch to REAR, does Carriage move to the rear? When turning it to FRONT, does Carriage move to the front?

If moved Carriage wrong, interchange two of the three Power Cords.

When moved Carriage correctly, Positioner Motor also rotates correctly (to the clockwise).

Note 1: Do not touch Socket which changes the rotating direction.

Note 2: To move Carriage correctly, move it slightly.

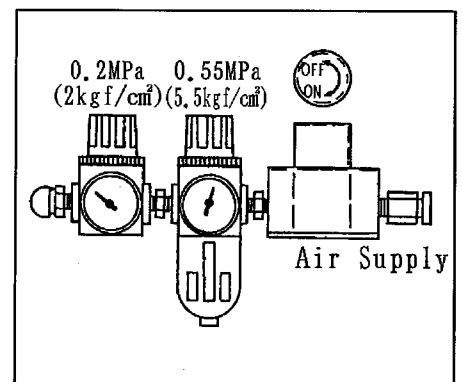
Note 3: After moving it correctly, move it to the hindmost position.

2-6 Connection of air system

Connect Air Supply Hose to Connector.

Set the air pressure to 0.55MPa (5.5kgf/cm²) as illustrated right.

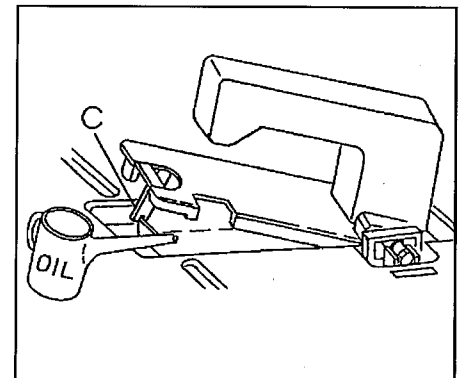
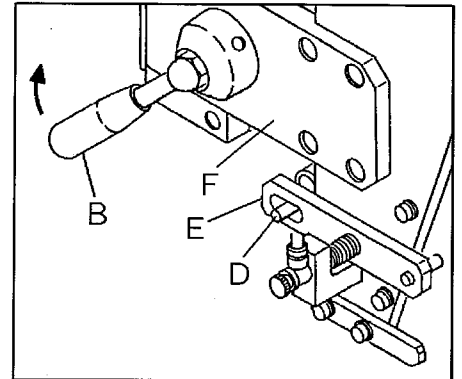
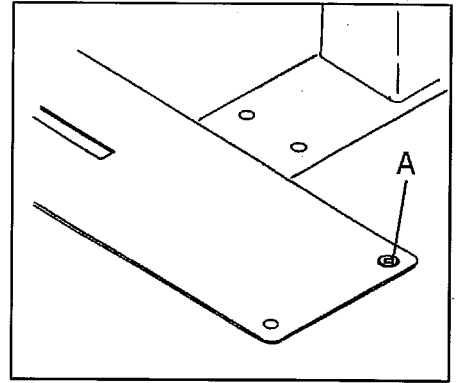
Set Regulator for the sliding of Sewing Head to 0.2MPa (2kgf/cm²).



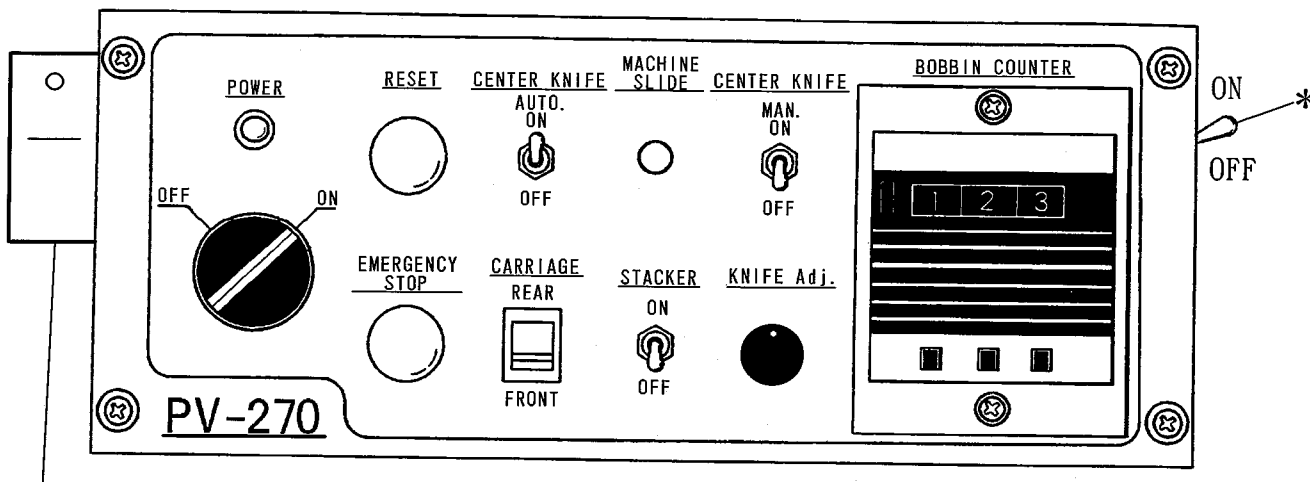
2-7 Lubrication

At the shipment, Oil Reservoir has no oil. Supply it with oil as follows:

- ① To remove Slide Plate, remove Screw(A).
- ② To open Open Plate(F) which has Center Knife Mechanism, loosen Lever(B).
- ③ Raise the left side of Sewing Head before fixing it with Stop Lever(C).
- ④ Remove Cover on the right side of Machine Unit.
- ⑤ With seeing Oil Gauge, supply Oil Reservoir with oil ranging from the upper line to the lower one.
- ⑥ Fix the Cover on the right side.
- ⑦ Remove Stop Lever(C) before returning Sewing Head.
- ⑧ Close the Open Plate to place Center Knife Driving Pin(D) in the slot of Driving Lever(E). Tighten Lever(B).
- ⑨ Fix Slide Plate with Screw(A).



3. Description and Function of Control Panel



Needle Thread Monitor (*: Needle Thread Monitor Switch)

(1) POWER

ON.....All Power Supplies are turned on.

OFF....Power Supplies are turned off.

Note : Input portion of each parts in Control Box has been applied.
Turn Power Supply OFF and remove the plug before adjusting,
repairing and other working.

(2) CARRIAGE

Switch to operate Carriage manually.

REAR.....Carriage move to the backward while pressing and stop at the hindmost.

(MIDDLE)...Carriage stop.

FRONT.....Carriage move to the forward while pressing and stop at the foremost.

Note : The auto-sewing performance can be started only when Carriage stay at the foremost.

(3) CENTER KNIFE(AUTO.)

ON....Center Knife operate during the auto-sewing performance.

OFF....Center Knife do not operate.

(4) CENTER KNIFE(MAN.)

ON....Center Knife lower.

This Switch should be used for adjusting the position and engagement with Fixed Knife.

Note : Center Knife operate only when Sewing Head stays at the right position.

Push MACHINE SLIDE before moving Machine Head to the right.

OFF....Center Knife rise.

Note : When turning this Switch ON, Emergency Stop works.

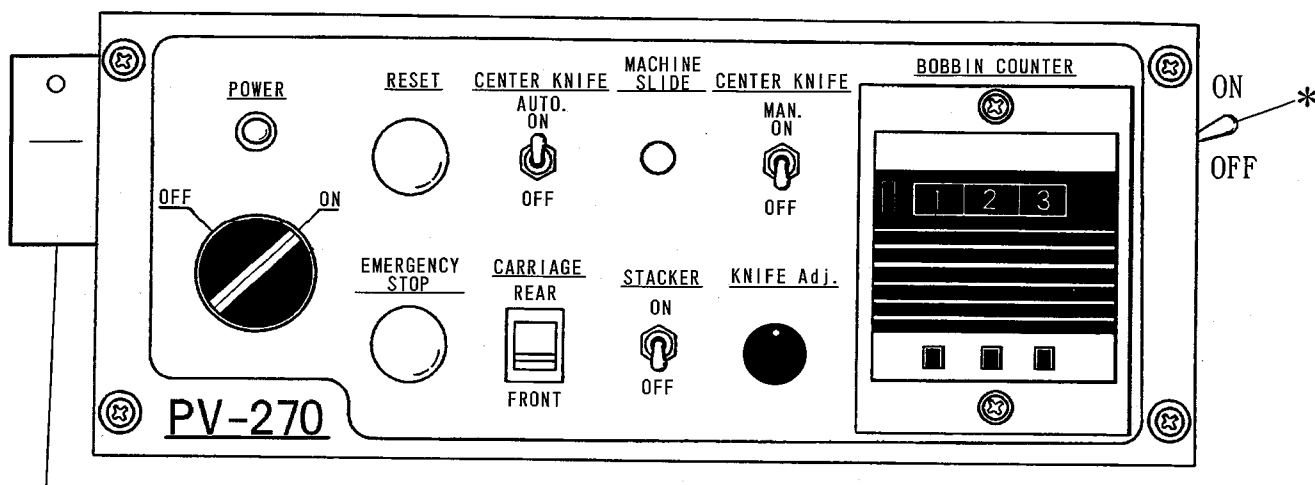
To release it, press RESET button.

Sewing Head returns to the leftmost position.

(5) KNIFE Adj. (Center Knife micro adjustment)

To cut material longer, turn this Adjusting Knob clockwise.

To cut shorter, turn counterclockwise.



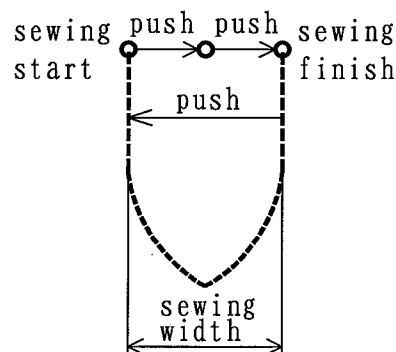
Needle Thread Monitor (*: Needle Thread Monitor Switch)

(6) MACHINE SLIDE

Whenever pushing this button, Sewing Head moves in three steps(left-middle-right) only for the sewing width.

Note 1: The auto-sewing performance can be started only when Sewing Head stays at the leftmost position.

Note 2: When pushing RESET, Sewing Head can be returned to the leftmost position.



(7) STACKER

ON...Stacker operates.(This equipment is optional.)

OFF...Stacker does not operate.

Note: With no Stacker, this Switch does not work.

(8) EMERGENCY STOP

Push this button when needle breakage and other troubles are caused. This button lights and all operations stop.(Clamp Foot rise.)

(9) RESET

When pushing this Switch, it can work as follows:

① Releasing EMERGENCY STOP.

○ Turning FRONT of CARRIAGE Switch on — Carriage return to the foremost.

○ Turning REAR of CARRIAGE Switch on — Carriage move to the hindmost.

② Moving Sewing Head to the leftmost position.

③ For 'Keep System'(see 8-1 on page 10), Clamp Foot(Right and Left) and Front Placket Clamp(Right) rise.

(10) BOBBIN COUNTER

To set the numbers — while pushing Button(A), push other Buttons.

This Counter has count-down system.

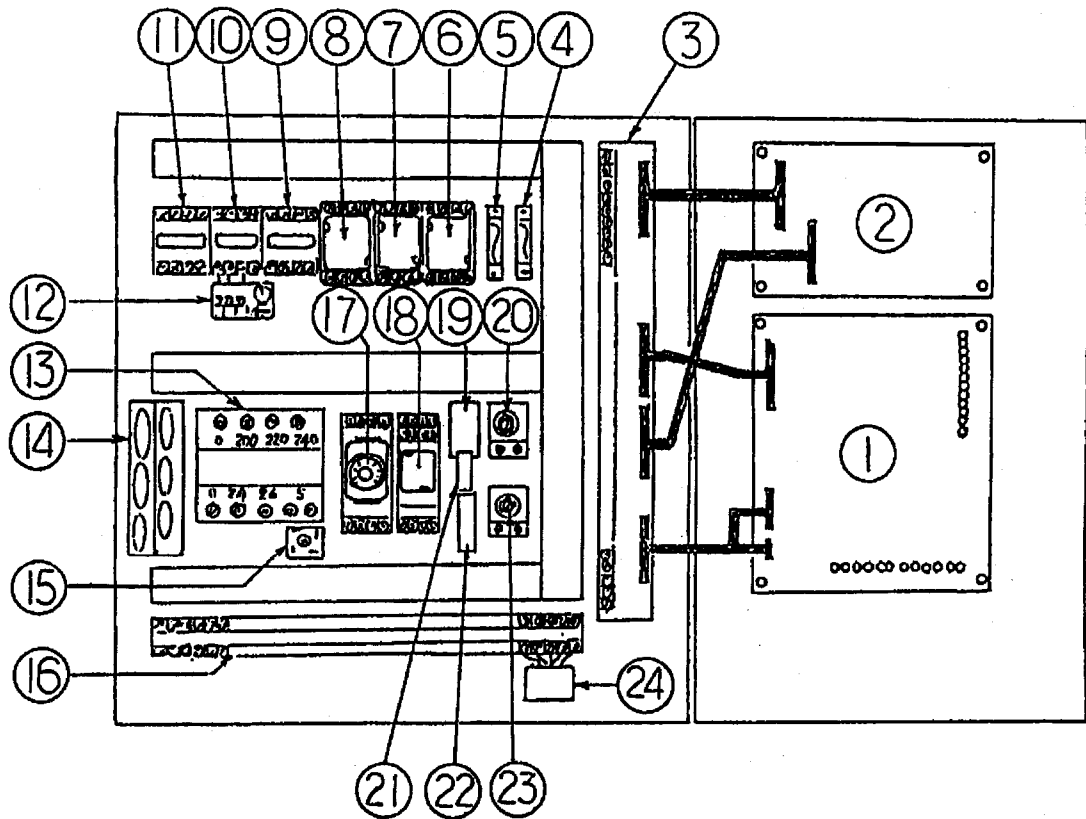
When '0' is indicated, Machine does not operate.

Reset it.

(11) NEEDLE THREAD MONITOR and its ON/OFF SWITCH

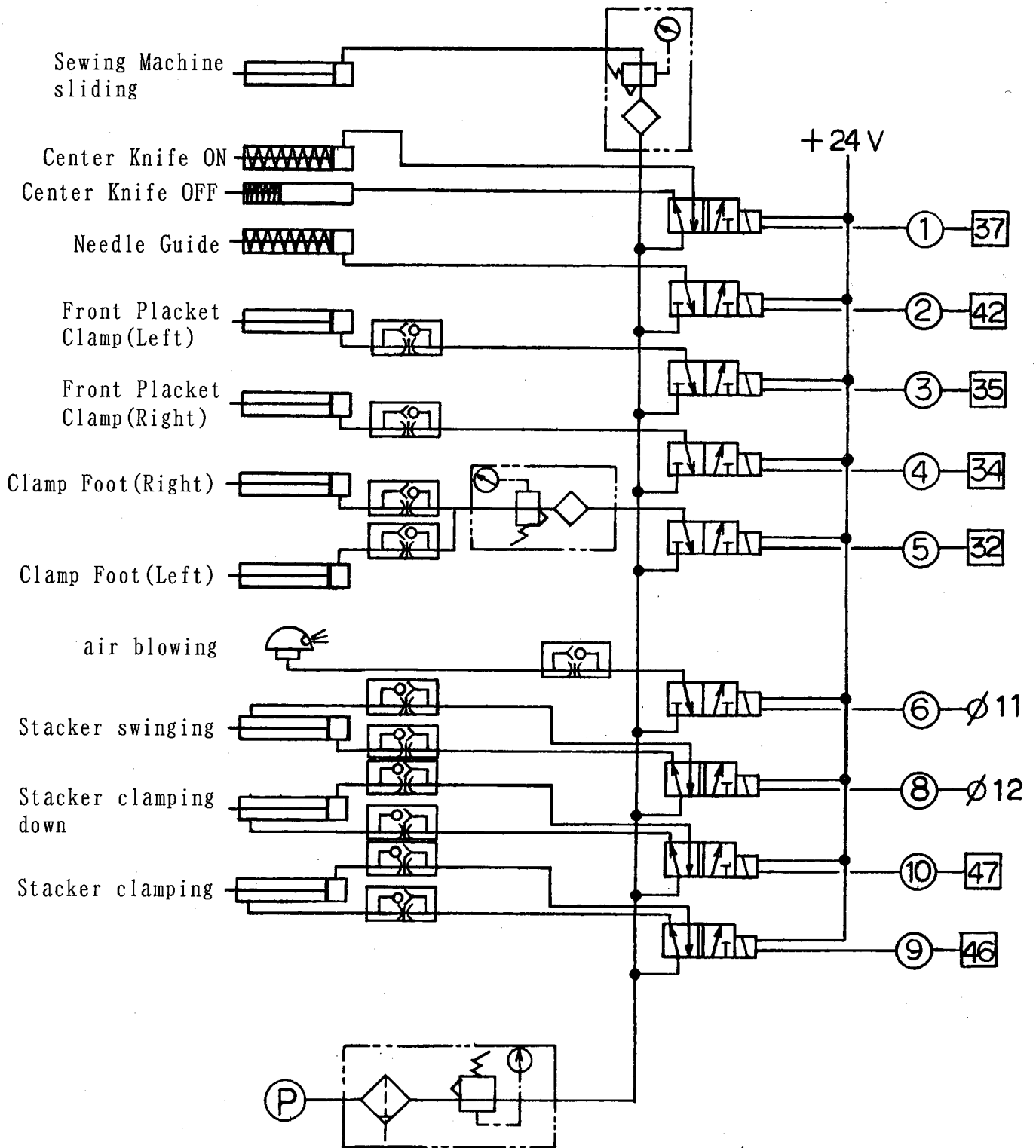
When Needle Thread Monitor functions (when needle thread is broken) and Lamp for Emergency Stop lights, all the operations are stopped automatically.

4. Control Box



- ① Main Control Board
- ② Sub Control Board
- ③ Intermediate Board
- ④ Fuse(for Work Locating Lamp, 5A)
- ⑤ Fuse(for the circuit of Power Source, 5A)
- ⑥ Relay(for moving Carriage to the front, DC24V)
- ⑦ Relay(for moving Carriage to the rear, DC24V)
- ⑧ Relay(for Emergency Stop, DC24V)
- ⑨ Power Relay(for moving Carriage to the front)
- ⑩ Power Relay(for moving Carriage to the rear)
- ⑪ Power Relay(for Machine Motor)
- ⑫ Thermal Relay(for the geared motor)
- ⑬ Transformer
- ⑭ Power supply
- ⑮ Rectifying Device
- ⑯ Terminal
- ⑰ Speed Controller(for V Motor)(for sliding Sewing Head right and left, The graduation is set to 5.)
- ⑱ Relay(for rotating V Motor and Machine Motor)
- ⑲ Capacitor
- ⑳ Variable Resistor(for the straight sewing)
- ㉑ Spark Quenching Circuit
- ㉒ Resistor
- ㉓ Variable Resistor(for the V shape sewing)
- ㉔ Motor Controller

6. Air Piping Diagram



○ ... SOL. Intermediate Terminal No.

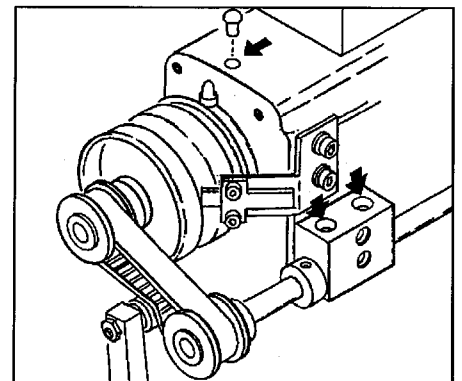
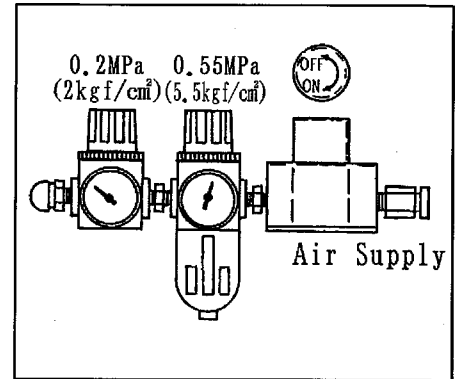
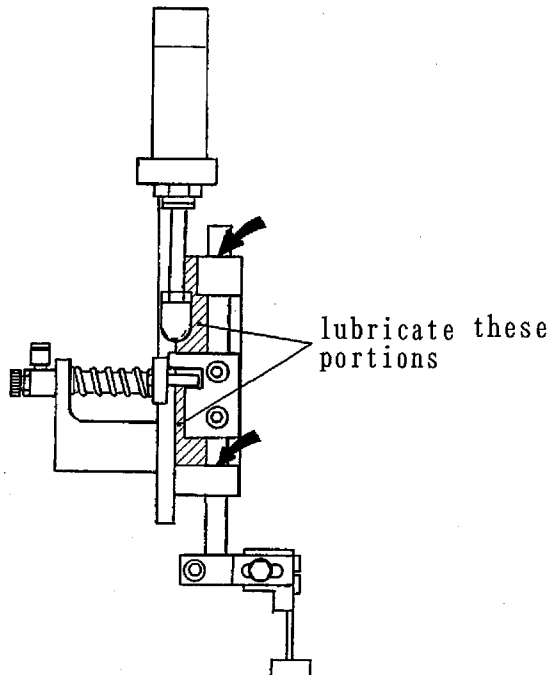
□ ... Intermediate Terminal No.

∅ ... Terminal No. in Control Box

7. Checking Before Operating

- ① Is the set point of air pressure proper?
Regulator from Air Supply :0.55MPa(5.5kgf/cm²)
Regulator for sliding Sewing Head:0.2MPa (2kgf/cm²)
- ② Does not Needle bend?
Does not the tip of Needle break?
- ③ Is the threading correct?
- ④ Are not Clamp Foot Rubber and Front Placket Clamp Rubber damaged?
- ⑤ When lowering Clamp Foot, is it even with Slide Plate?
- ⑥ Is the position which Work Locating Lamp irradiates proper?
- ⑦ Is the quantity of oil in Oil Reservoir proper?
- ⑧ Does Center Knife cut well?
Is the position of Center Knife proper?
- ⑨ Did you finish a daily lubricating?

Portion of a daily lubrication



8. Operating and Automatic cycle sewing

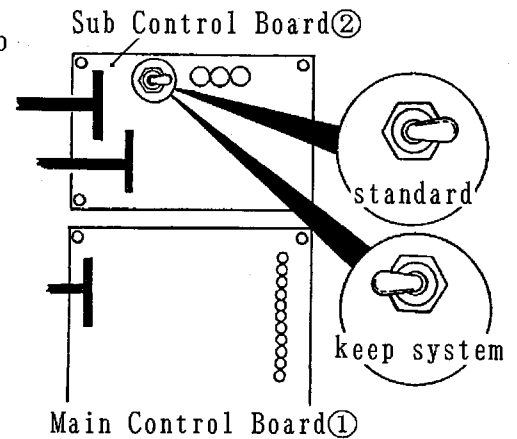
8-1 Operating

For the standard operation, turn Toggle Switch on Sub Control Board in Control Box to the right side.

For the keep-system operation, turn this Switch to the left side.

Note : Foot Switch has three-stepped system.

Do not treadle to the bottom once.



☆ Standard operation

- ① Turn Power Source Switch ON.
- ② Place a fabric in the sewing position with Work Locating Lamp and Positioning Light.
- ③ Treadle Foot Switch to the first step.
Clamp Foot(Right and Left) lower to fix the fabric.
- ④ Place a front placket on Clamp Foot.
- ⑤ Treadle Foot Switch to the second step.
Front Placket Clamp(Right) lowers to fix the front placket.
- ⑥ Treadle Foot Switch to the third step.
Front Placket Clamp(Left) lower to fix the front placket.
While treadling Foot Switch, push Start Switch.
- ⑦ The auto-sewing performance starts. Release Foot Switch.

☆ Keep-system operation

- ① Turn Power Source Switch ON.
- ② Place a fabric in the sewing position with Work Locating Lamp and Positioning Light.
- ③ Treadle Foot Switch to the bottom.
Clamp Foot(Right and Left) lower to fix the fabric.
(Even if releasing the Foot Switch soon after treadling, Clamp Foot keep lowering.) For raising Clamp Foot, press RESET on Control Panel.
- ④ Place a front placket on the Clamp Foot.
- ⑤ Treadle Foot Switch to the bottom.
Front Placket Clamp(Right) lowers to fix the front placket.
(Even if releasing Foot Switch soon after treadling, the Front Placket Clamp (Right) keeps lowering.) For raising Front Placket Clamp, press RESET on Control Panel.
- ⑥ Treadle Foot Switch to the bottom.
Front Placket Clamp(Left) lowers to fix the front placket.
(When releasing Foot Switch, Front Placket Clamp(Left) rises.)
- ⑦ The auto-sewing performance starts.
Release Foot Switch.

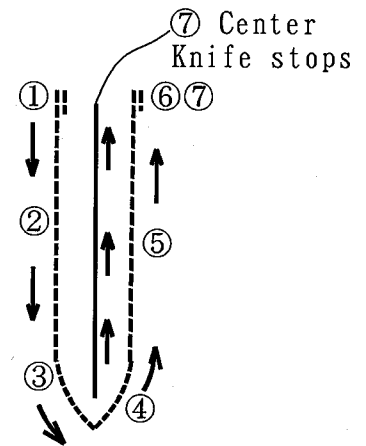
Ref. : We can supply you with Foot Switch only for keep-system, which is optional.

《For starting the auto-sewing performance》

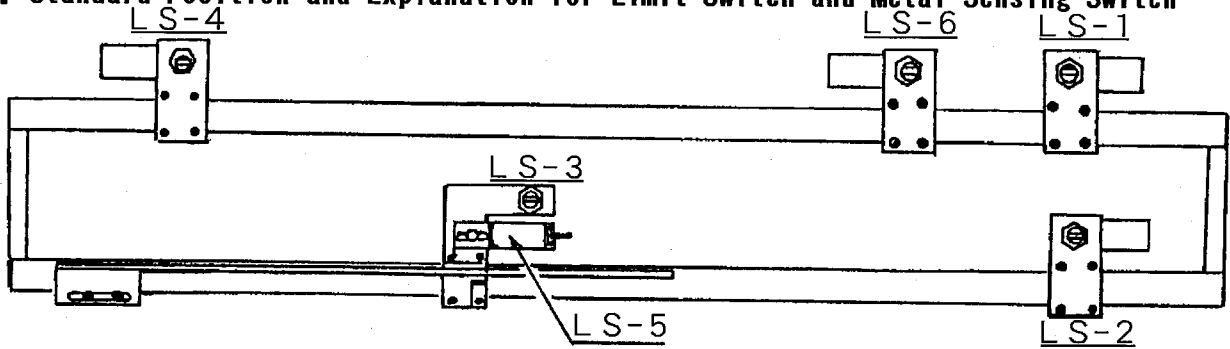
	Condition of Machine	Limit Switch	Input Matrix
1	Thread Take-up stays at the uppermost of its travel.	LS-7	16
2	Carriage stay at the foremost position.	LS-1	11
3	Sewing Head stays at the leftmost.	LS-9	12
4	Bobbin Counter indicates '1' and more.	This is connected to Start Switch directly.	—
5	Foot Switch is treadled to the third step.	FLS-3	17
6	Start Switch is turned ON. ↓ The sewing performance starts.	LS-8	1

8-2 Automatic cycle sewing

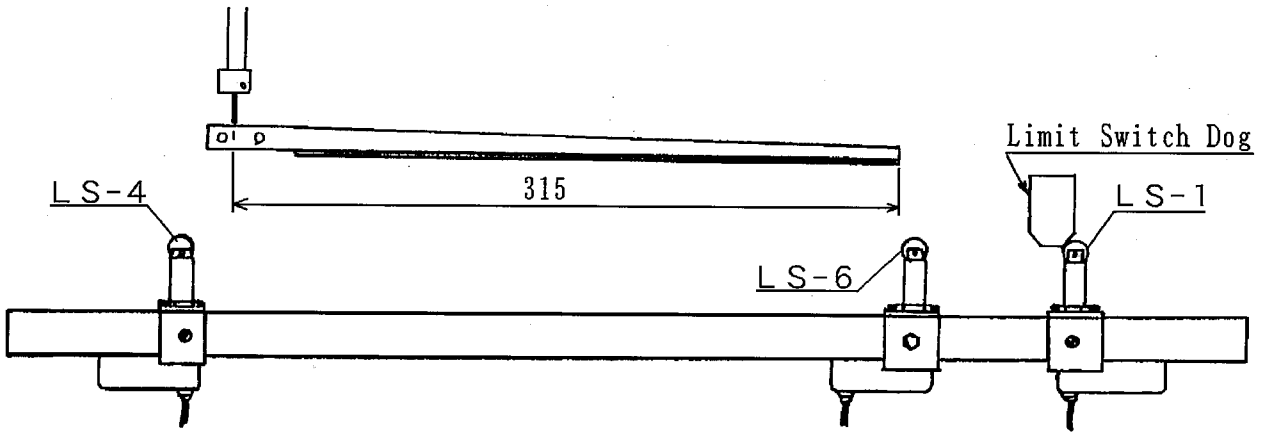
- ① The sewing performance starts at the left end as shown in the right figure.
At the sewing start, reverse stitch is performed automatically.
- ② The straight sewing is performed in the length which you require.
- ③ The sewing of the left curve is performed.
- ④ The sewing of the right curve is started at the tip of V shape.
Center Knife begins to cut the fabrics.
- ⑤ The right straight sewing is performed.
- ⑥ At the sewing finish, reverse stitch is performed automatically.
- ⑦ The sewing performance and Center Knife stop.
- ⑧ The thread is cut. → The cycle sewing is finished.



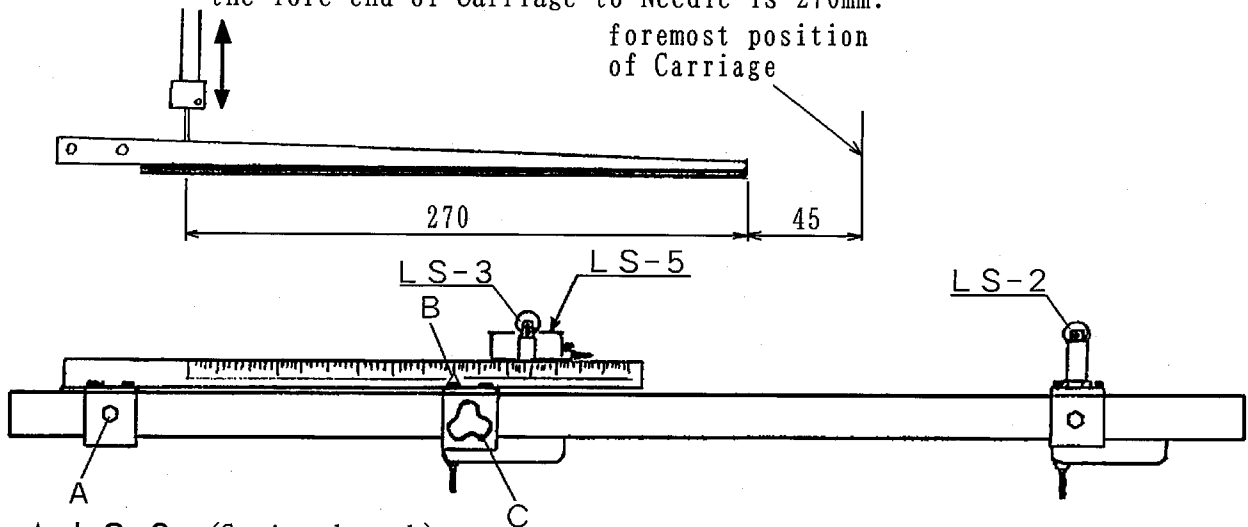
9. Standard Position and Explanation for Limit Switch and Metal Sensing Switch



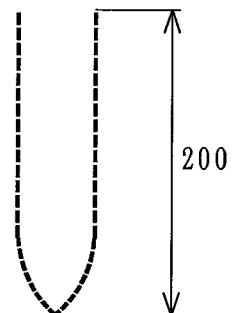
☆ LS-1 (Foremost position of Carriage)
When Carriage stay at the foremost position, the distance from Needle to the end of Clamp Foot is 315mm.



☆ LS-2 (Sewing start)
Carriage move back 45mm in distance, which is from pushing Start Switch to starting the sewing. At the same time, the distance from the fore end of Carriage to Needle is 270mm.

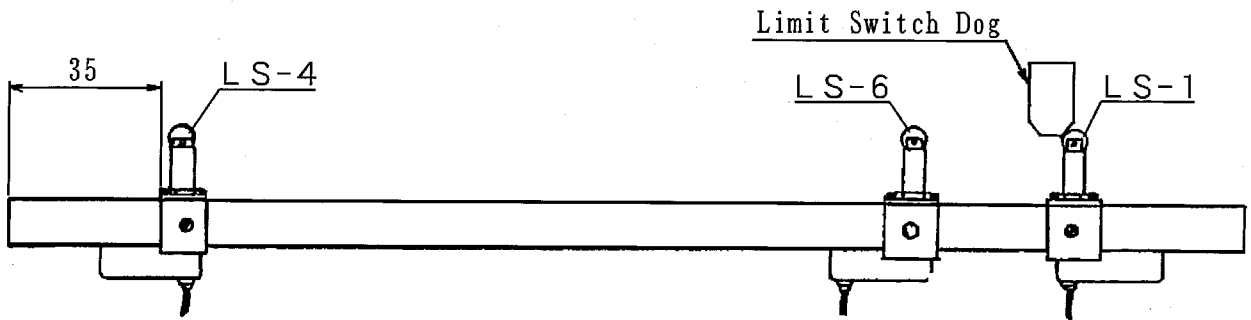


☆ LS-3 (Sewing length)
When the shape of 'V' is changed, the sewing length should be also changed. Perform the trial sewing prior to determining the shape. Measure the sewing length of the trial sewing. Suppose the sewing length to be 200mm. Loosen Screw(A) before making Pointer(B) indicated 200 in Scale. Fix Scale with Bolt(A). Loosen Knob Bolt(C). Make Pointer(B) indicated the sewing length as desired. The sewing can be performed actually.



☆ LS-4 (Stopping to retreat by Carriage)

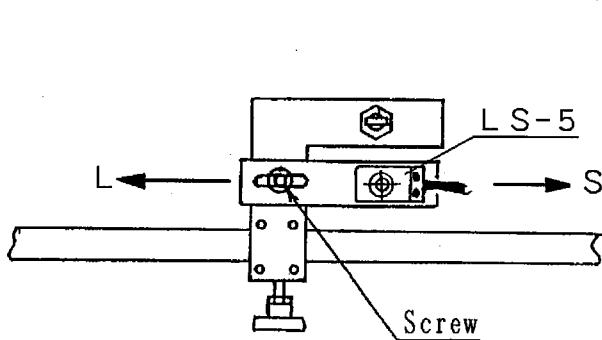
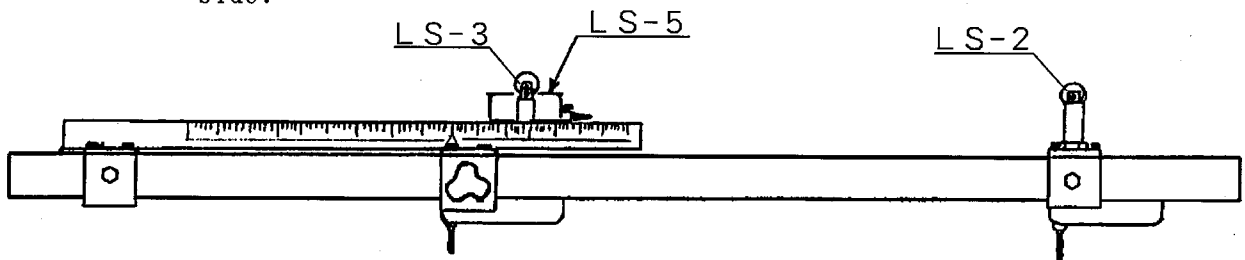
The distance from the back end of Rail to Limit Switch is 35mm.



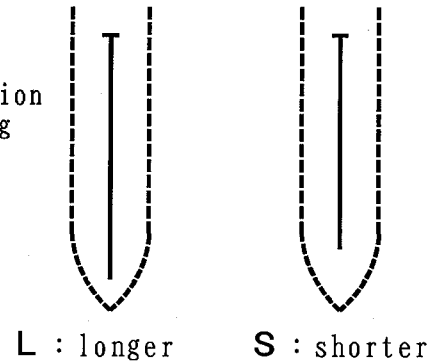
☆ LS-5 (Starting to cut by Center Knife)(Metal Sensing Switch)

The position which Center Knife starts to cut is set.

To cut longer, loosen Screw before sliding Metal Sensing Switch (LS-5) to 'L' side. To cut shorter, loosen Screw before sliding it to 'S' side.

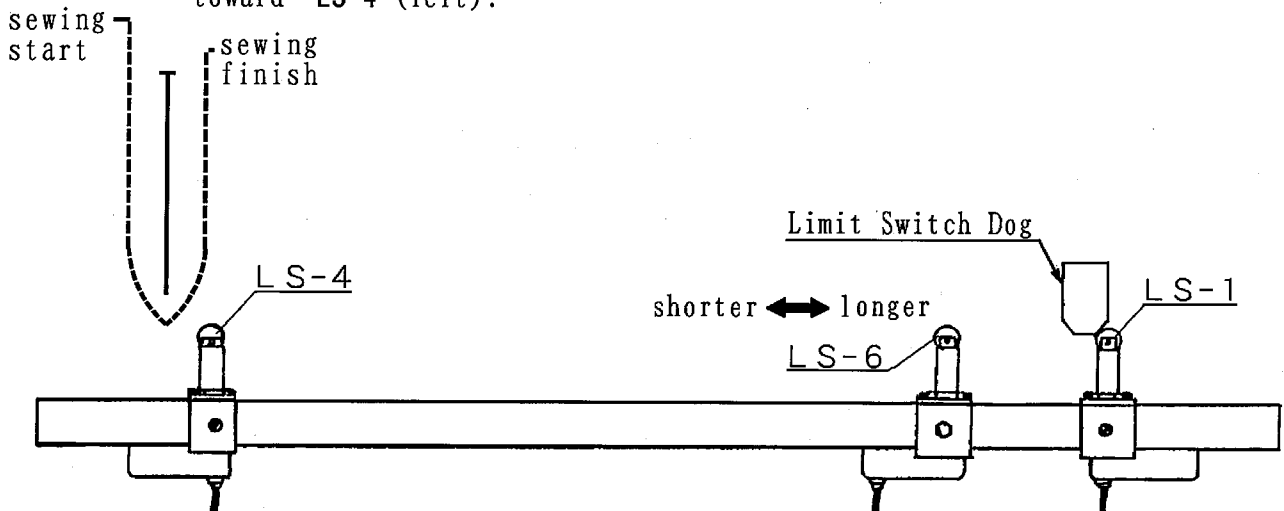


Note: LS-6 can determine the position of cutting finish.

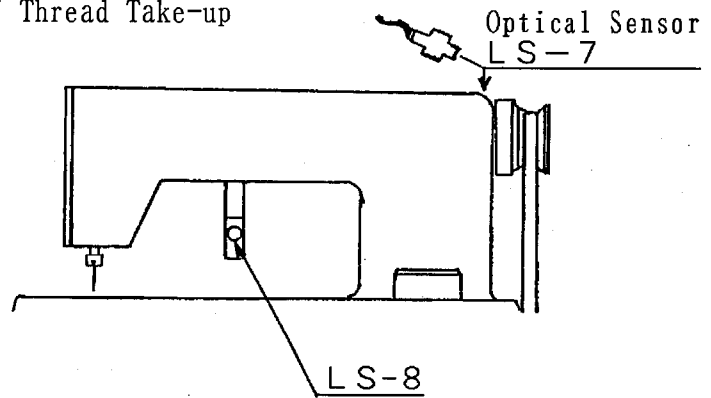


☆ LS-6 (Sewing finish)

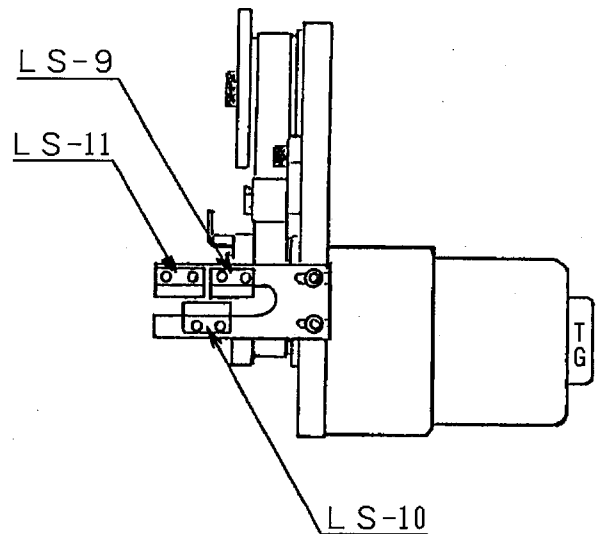
First, perform the trial sewing. To make the different length on right and left hand plackets, slide this Metal Sensing Switch to the position of sewing finish. To make the right sewing length longer, slide 'LS-6' toward 'LS-1' (right). To make it shorter, slide 'LS-6' toward 'LS-4' (left).



- ☆ LS-7 Uppermost position of Thread Take-up
- ☆ LS-8 Start Switch

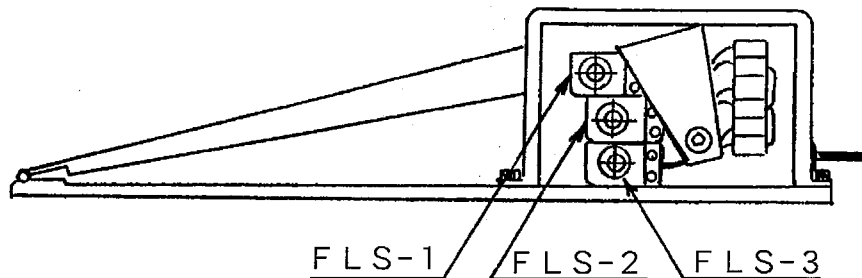


- ☆ LS-9 Start of V shape sewing (Metal Sensing Switch)
- ☆ LS-10 Tip of V shape sewing (Metal Sensing Switch)
- ☆ LS-11 Finish of V shape sewing (Metal Sensing Switch)

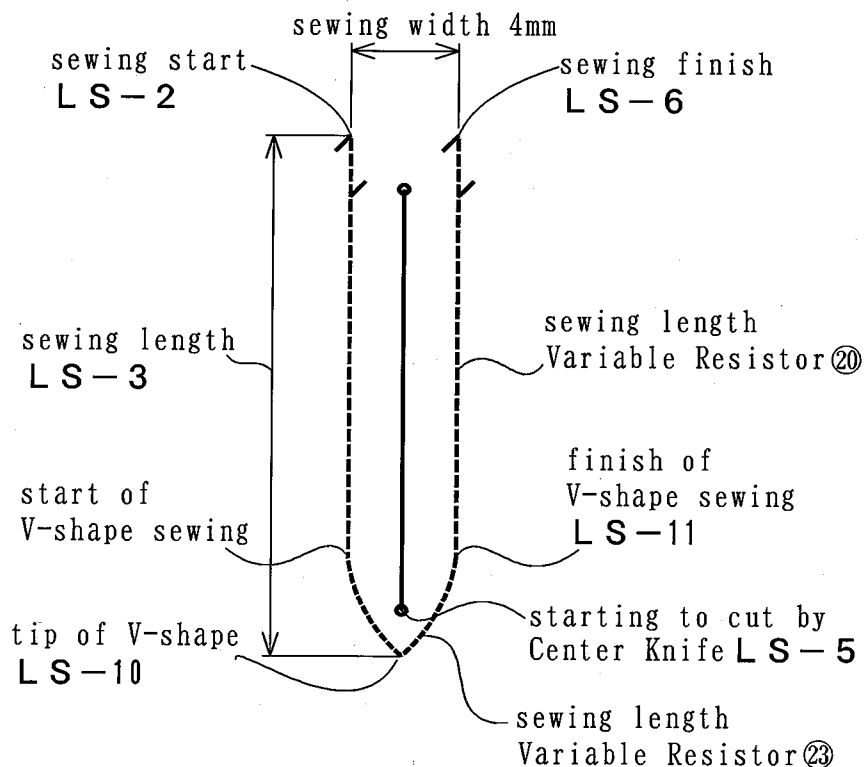


- ☆ Foot Switch (Metal Sensing Switch)
- FLS-1 Clamp Foot (Right and Left)
- FLS-2 Front Placket Clamp (Right)
- FLS-3 Front Placket Clamp (Left)

Note : To operate Front Placket Clamp (Left) with FLS-2 and Front Placket Clamp (Right) with FLS-3, interchange Air Hoses of Front Placket Clamp Cylinder.



1 O. Adjustment for Sewing



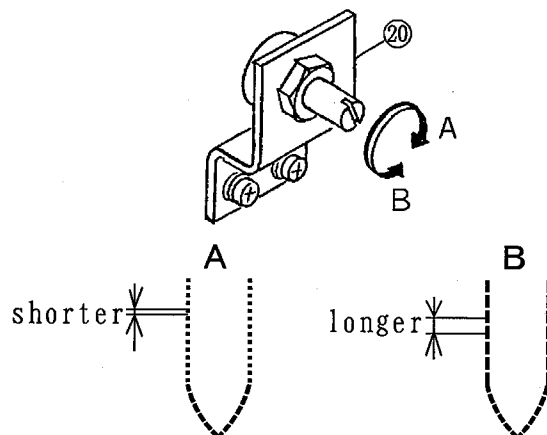
10-1 Adjustment for Stitch Length

☆ Straight sewing portion

At the shipment, the stitch length of the straight portion is set to 2.3mm.

For the shorter stitch length, turn Variable Resistor ⑳ in Control Box to the clockwise (A) to increase the rotating speed of Machine.

For the longer stitch length, turn it to the counterclockwise (B) to decrease the rotating speed of Machine.

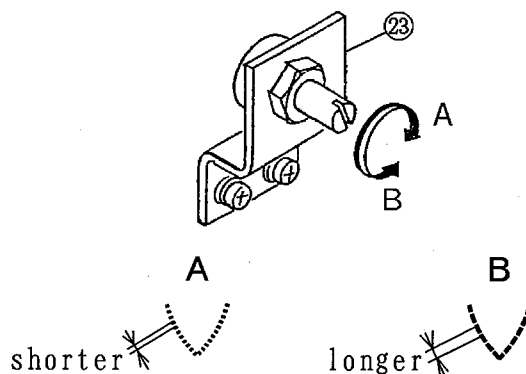


☆ V shape sewing portion

For the shorter stitch, turn Variable Resistor ㉓ in Control Box to the clockwise (A) to increase the rotating speed of Machine.

For the longer stitch, turn it to the counterclockwise (B) to decrease the rotating speed of Machine.

For the strength, the stitch length of V shape portion should be shorter than that of the straight portion.



10-2 Adjustment for V shape sewing

To make an obtuse-angled V shape, increase the graduation of Speed Controller ⑰ in Control Box.

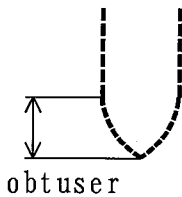
V Motor rotates quickly and Sewing Head slides to the right quickly.

To make a sharp-angled V shape, decrease the graduation of it.

V Motor rotates slowly and Sewing Head slides to the right slowly.

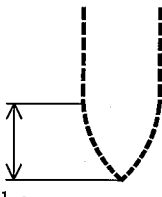
At the shipment, the graduation is set to 5.

increasing the graduation

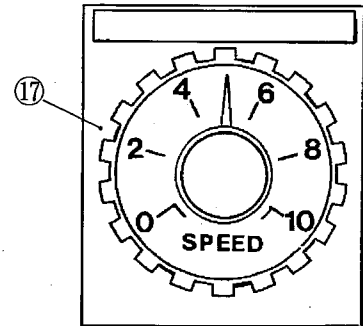


obtuser

decreasing the graduation



sharper



10-3 Change of the V shape

For changing the V shape, the position and angle of Light Intercept Plate(C) should be changed.



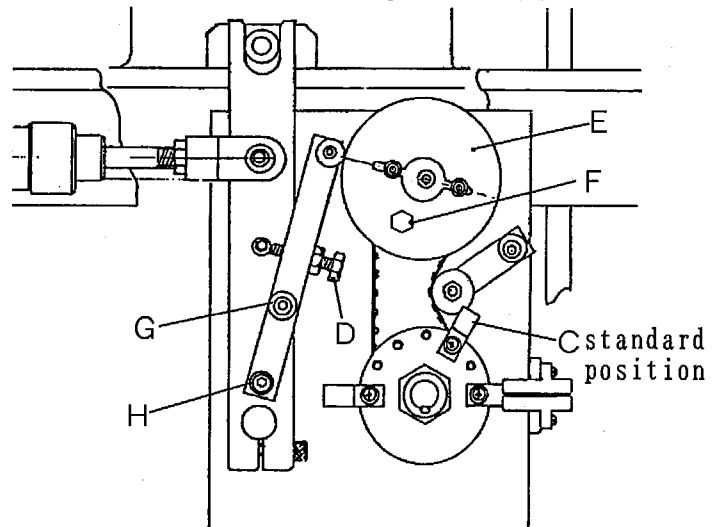
C : to the left



C : standard position shape of V



C : to the right



C standard position

10-4 Sewing position to Center Knife

Loosen Screw(G) and (H).

Loosen Lock Nut before turning Adjusting Screw(D).

The sewing position can be changed now.

After adjusting, tighten Screw(G) and (H).

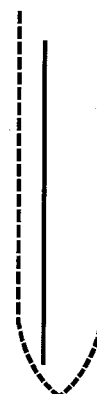
Note : The left 2 holes are not used.



The position of Center Knife is not changed.



To shift the sewing to the left, turn Screw(D) to the clockwise to slide Sewing Head to the left.



To shift the sewing to the right, turn Screw(D) to the counterclockwise to slide Sewing Head to the right.

10-5 Adjustment for the sewing width

Note : When adjusting, turn off Air Supply.

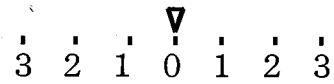
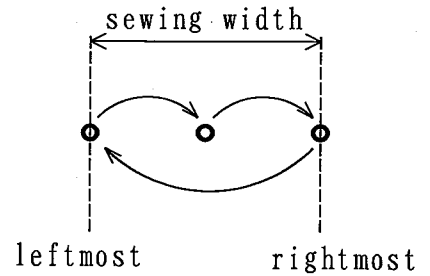
The sewing width can be adjusted by sliding Cam(E) to the right and left within the range from 3 to 6mm.

(At the shipment, it is set to 4mm.)

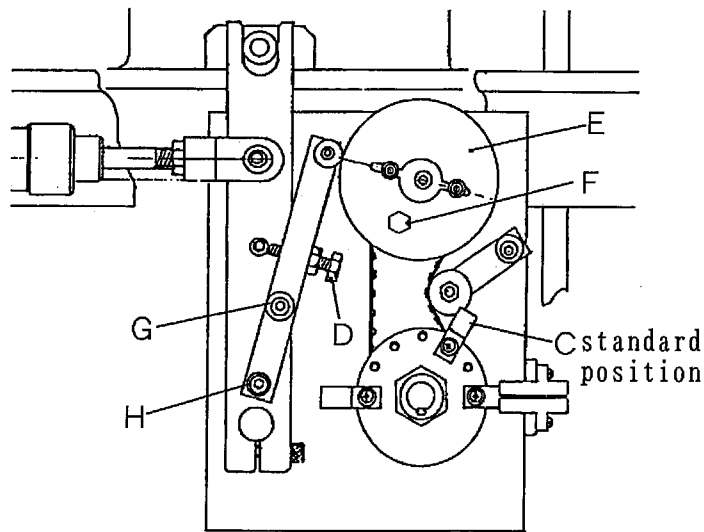
Loosen two Screws of Cam(E) with Bolt(F) before sliding Cam(E) to the right and left.

When checking the sliding width(sewing width) of Sewing Head, turn on the Air Supply.

Push MACHINE SLIDE on Control Panel before checking it with Scale on Machine Table.



Note : When Sewing Head stays at the mid position, Pointer does not always indicate '0'. It is changed by Adjusting Screw(D).



Note : The left 2 holes are not used.

1 1. Adjustment and Replacement

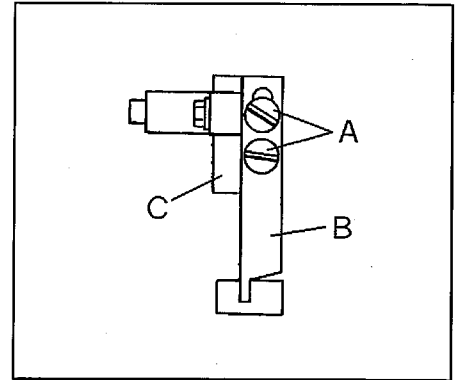
11-1 Replacement for Center Knife and Fixed Knife

☆ Center Knife

To replace Center Knife(B), Loosen 2 Screws(A).
When fixing it, fit Center Knife(B) to Center Knife Holder(C).

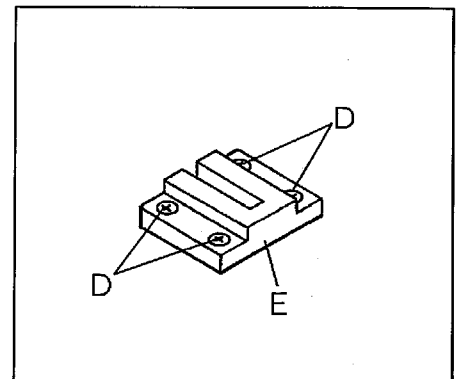
Make the top face of Center Knife(B) even with that of Center Knife Holder(C).

Then, tighten Screws(A).



☆ Fixed Knife

To replace Fixed Knife(E), remove Slide Plate before loosening 4 Screws(D).



11-2 Position of Center Knife and Fixed Knife

When lowering Center Knife(B) to the lowest position, make a clearance between top face of Fixed Knife(E) and the corner(b) of Center Knife 1.0mm.

To make it, loosen Screws(A).

When lowering Center Knife to the lowest position, touch the back side of Center Knife(B) with Fixed Knife(E).

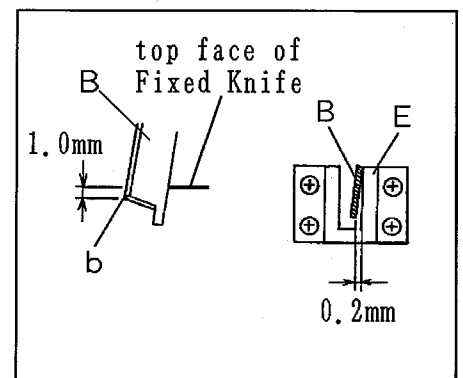
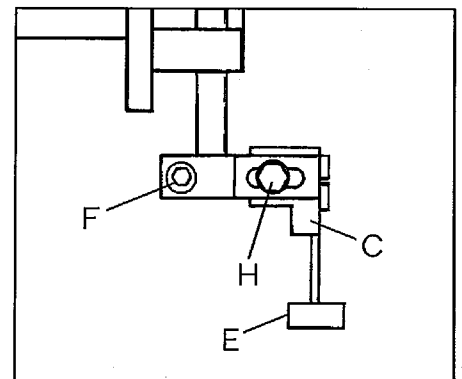
Make a clearance between the front side of Center Knife(B) and Fixed Knife(E) 0.2mm as shown in the lowest figure.

To adjust the clearance, loosen Screw(F).

To adjust Center Knife right and left, loosen Screw(H) before moving Center Knife Holder(C).

Note: After adjusting, check the cutting with a thread or a fabric.

Check that Center Knife returns with Return Spring smoothly.



11-3 Timing for driving Center Knife

To lower Center Knife Driving Pin(J) to the lowest point at the highest point of Thread Take-up, loosen 2 Screws(K) of Timing Pulley. For adjustment, turn Driving Shaft(L).

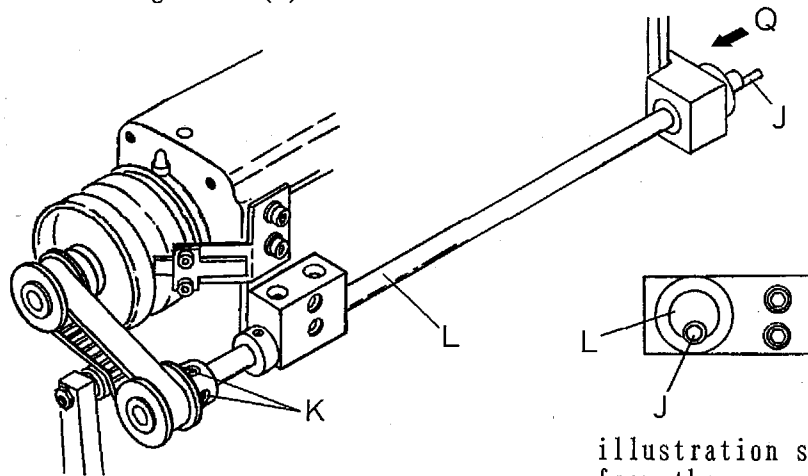


illustration seen
from the arrow(Q)

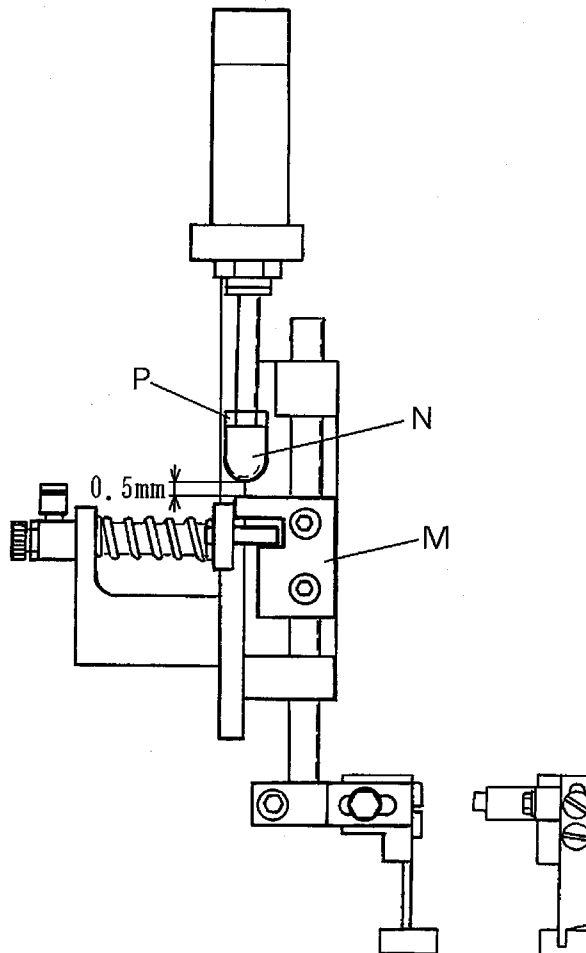
11-4 Clearance between Center Knife Knocker and Driving Base

When turning MAN. ON of CENTER KNIFE on Control Panel, at the highest position of Driving Base(M), make a clearance 0.5mm between Center Knife Knocker(N) and Driving Base(M).

To adjust it, loosen Lock Nut(P) before turning Center Knife Knocker(N).

Note: Too wide clearance can not make Center Knife moved up and down.

Too narrow clearance make high noise.



11-5 Front Placket Clamp and Clamp Foot

☆ Relation between Needle, Front Placket Clamp and Clamp Foot

The standard position of Front Placket Clamp and Clamp Foot is shown in the illustration.

☆ Height of Front Placket Clamp and Clamp Foot

When raising Front Placket Clamp and Clamp Foot to the highest position, the height of Front Placket Clamp is 30mm, Clamp Foot is 15mm, above the top face of Slide Plate.

To adjust Front Placket Clamp, loosen Lock Nuts before turning Screw(A).

To adjust Clamp Foot, loosen Lock Nuts before turning Screw(B)

Adjust another side of them, too.

☆ Replacement of Front Placket Clamp Rubber

① Loosen Screws(C) before removing Front Placket Clamp.

② Remove Front Placket Clamp Rubber.

③ Clean out the bonded face with thinner or others.

④ Stick a new Front Placket Clamp Rubber.

⑤ Fix Front Placket Clamp again.

Note: When lowering Clamp Foot and Front Placket Clamp, these must be even with Slide Plate. Then, tighten Screws(C).

☆ Replacement of Clamp Foot Rubber

① Loosen Screws(D) before removing Clamp Foot.

② Remove Clamp Foot Rubber

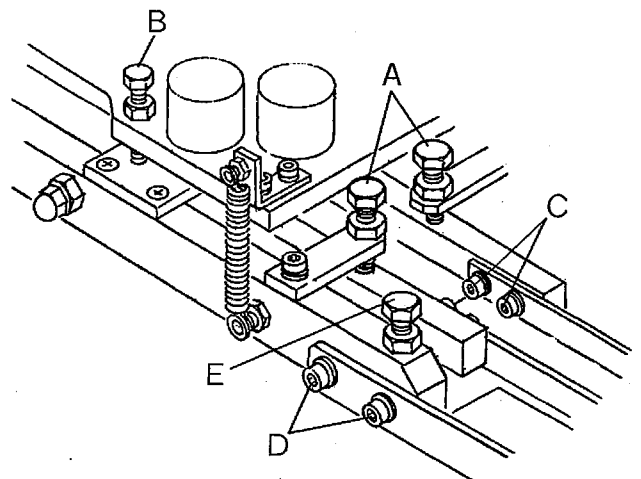
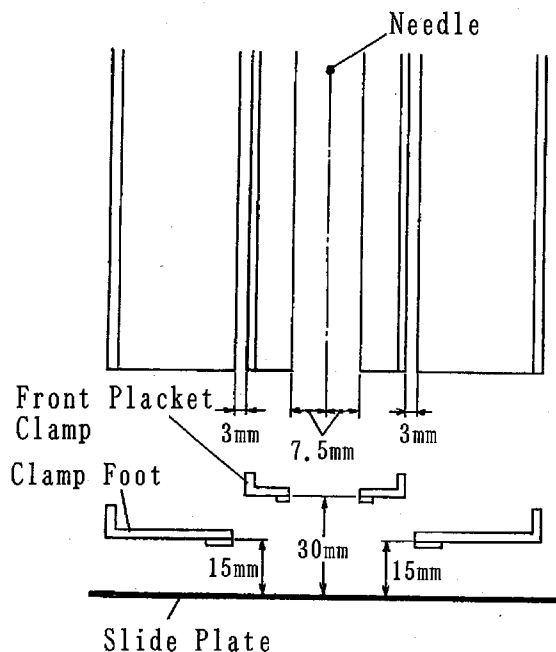
③ Clean out the bonded face with thinner or others.

④ Stick a new Clamp Foot Rubber.

⑤ Fix Clamp Foot again.

Note 1: When tightening Screws(D), lift the end of Clamp Foot.

Note 2: Lower Clamp Foot. Make sure that Clamp Foot is even with Slide Plate. To adjusting it, loosen Lock Nut before turning Adjusting Screw(E).



1 2. Adjustment for Stacker

12-1 Installation for Stacker

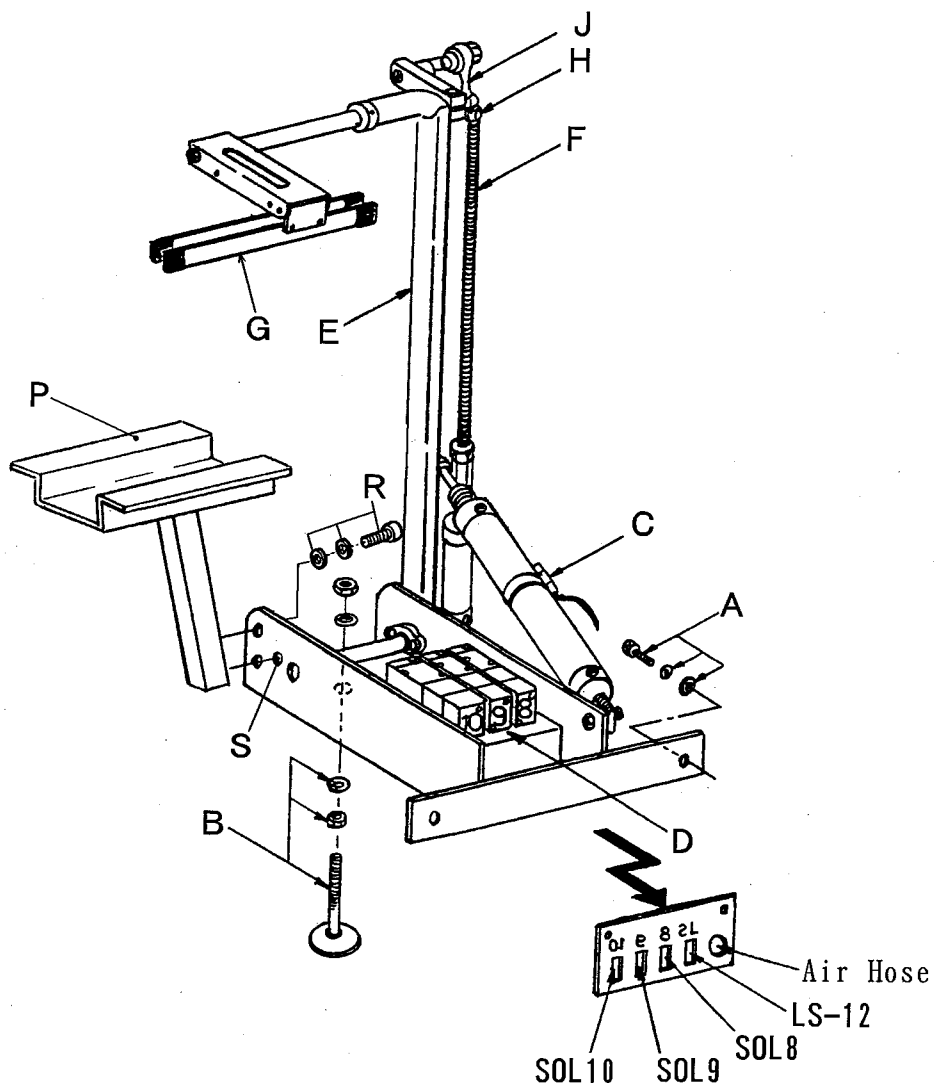
- ① Turn OFF Air Cock of Sewing Unit.
- ② Install Stacker to Sewing Unit with Screws(A) (2 pcs.).
- ③ Hold Stacker horizontally with Adjustable Bolt(B).
- ④ Connect Air Hose of Stacker.
- ⑤ Connect Connectors of Metal Sensing Switch(C) and Solenoid Valve(D) to the corresponding Connectors on Sewing Unit.

Note: If the stacking condition is not stable, change the position to install Fabric Receiver(P). To change, loosen Screw(R) and replace the lower Screw to the hole(S) in Stacker Base, and then install Fabric Receiver(P) slantingly.

12-2 Adjustment for Clamp height

- ① Turn OFF Air Cock of Sewing Unit.
- ② Move Swing Arm(E) toward Sewing Unit fully.
- ③ Raise Connecting Shaft(F) fully by hand to lower Clamp(G).
- ④ Check the height of Clamp(G) to Slide Table.
(Adjust the height so that Clamp(G) lightly presses Slide Table when Clamp(G) lowers.)
- ⑤ If needed adjusting, loosen Nut(H) and turn Connecting Shaft(F).

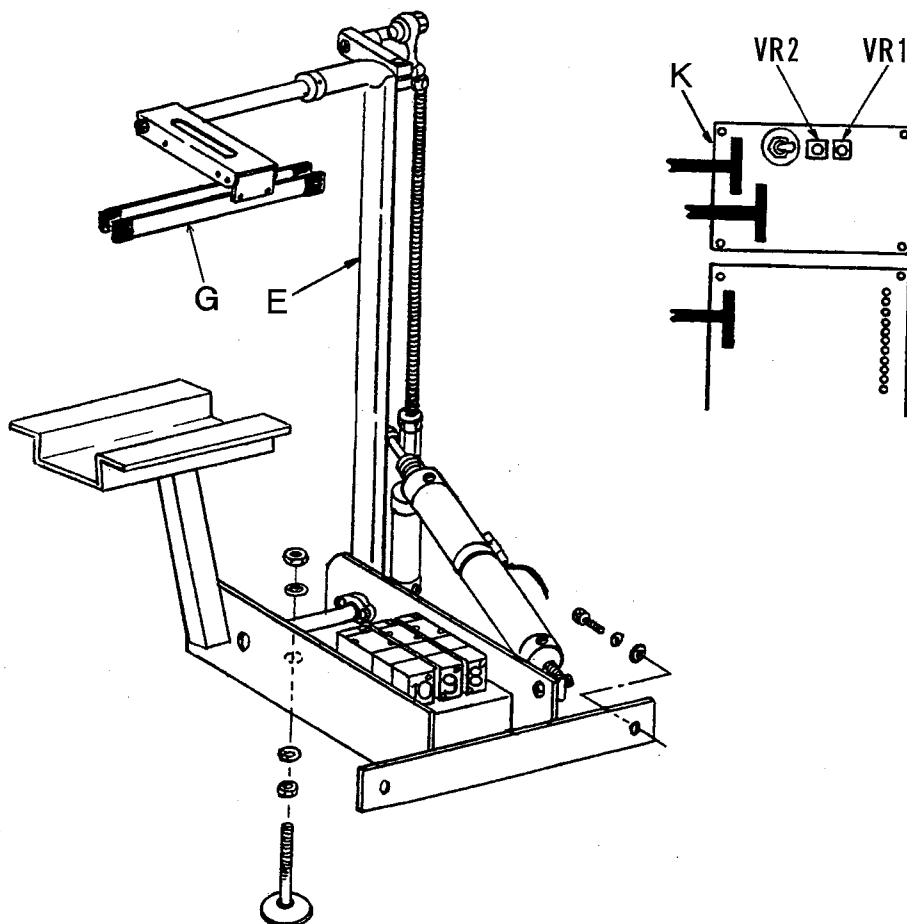
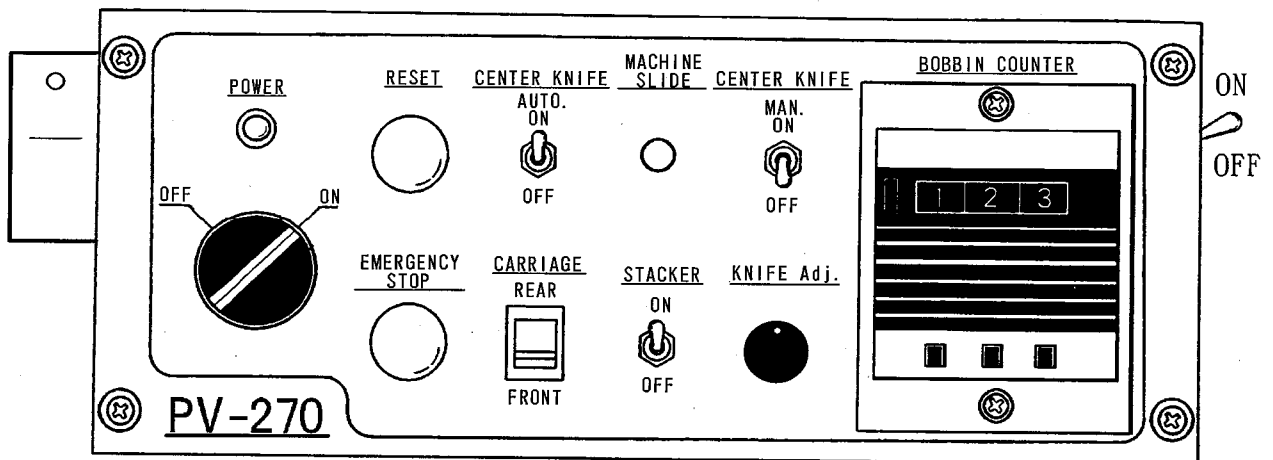
Note: If loosened or tightened Nut(H), be sure to use two spanners, the one to hold Rod End(J), and the other to loosen or tighten.



12-3 Adjustment for timing of Clamp

- ① Turn ON Power Source Switch and Air Cock of Sewing Unit.
- ② Turn ON STACKER on Control Panel.
- ③ Adjust timing with VR2 and VR1, Variable Resistors on Sub Control Board(K).
VR2...This adjusts the time after Clamp(G) lowers until Clamp(G) holds fabric.
VR1...This adjusts the time after Clamp(G) holds fabric until Swing Arm swings.
To increase time, turn each Variable Resistor clockwise.
To decrease time, turn counterclockwise.

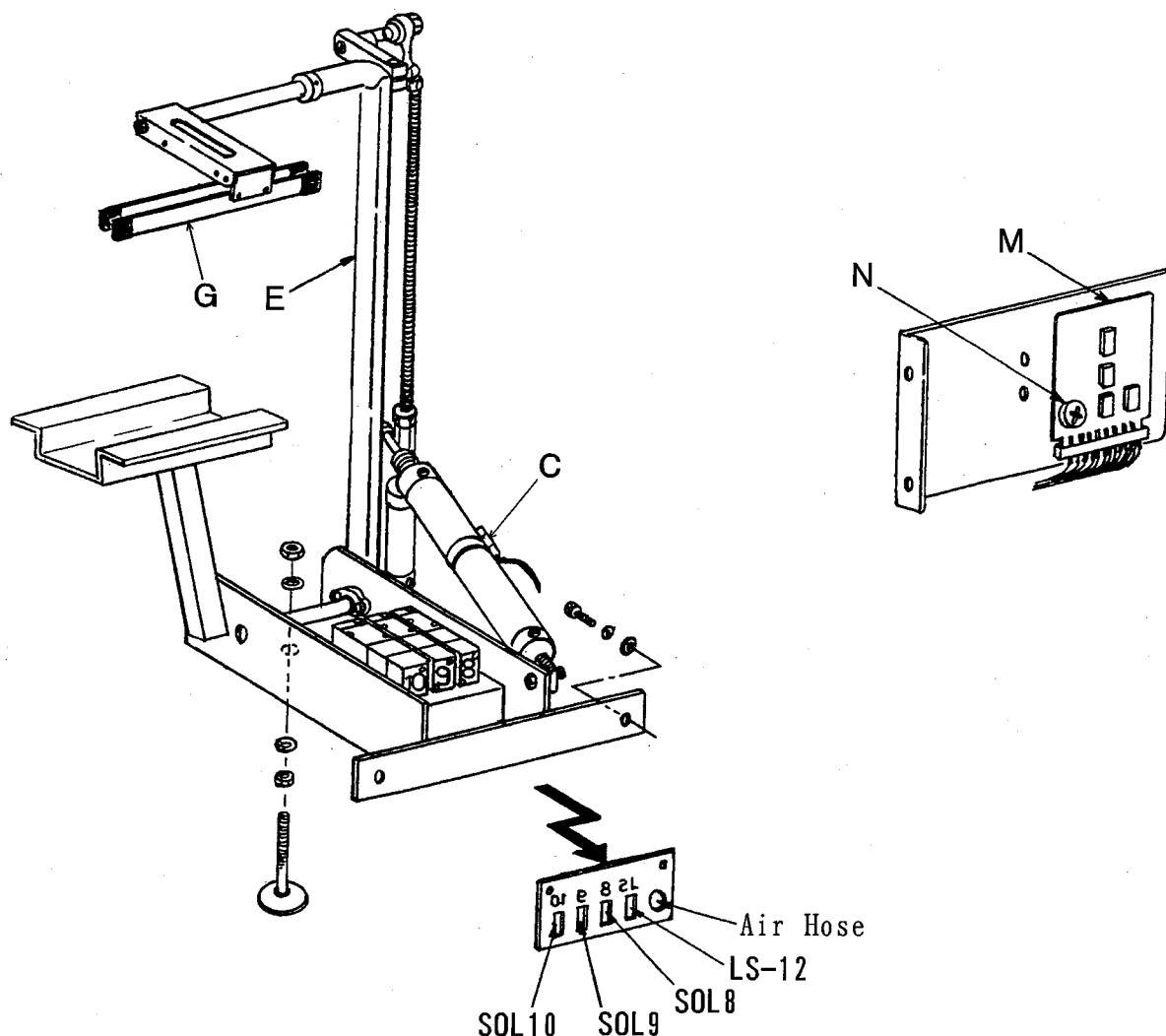
Note: This adjustment relates to the operating speed of Air Cylinder.
Adjust to Speed Controller.



12-4 Adjustment for releasing position of Clamp

To make Clamp(G) release quickly, slide Metal Sensing Switch(C) to right (Sewing Unit side). To make Clamp(G) release slowly, slide Metal Sensing Switch(C) to left.

Note: If Metal Sensing Switch(C) is slid to right too much, Clamp(G) does not release after Stacker operates.
If the Switch(C) is slid to left too much, Stacker does not operate.



12-5 Solenoid Valve and Variable Resistor

☆ Functions of Solenoid Valve

- SOL8···Swing Arm(E) swings.
- SOL9···Clamp(G) holds fabric.
- SOL10··Clamp(G) lowers.

☆ Variable Resistor

Turn Variable Resistor(N) on Board(M) for air blowing in Control Box counterclockwise fully to set to '0'.

Yamato

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YAMATO SEWING MACHINE MFG. CO., LTD.