

# KH Chain Cutter-Installation

**L32**

## Preparation

### 1. Removing the existing parts

Remove the needle plate, fabric guard and cloth plate.

### 2. Interchanging existing parts

(Replacement: Table 4; Modification Fig.16)

- If the special replacement cloth plate is to be used, refer to Table 4.
- If the existing cloth plate is to be modified, refer to Fig.16.

## Installing the Chain Cutter (Fig. 17)

Fit the parts in the sequence 1 to 6.

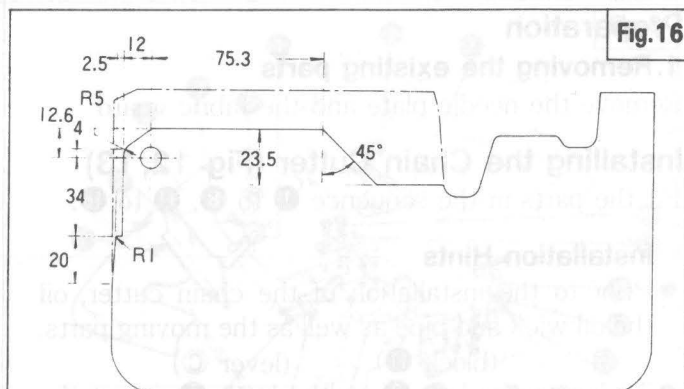
### Installation Hints

- When pin ① is fitted, the driver slot should be aligned as shown in Fig.17.
- Prior to the installation of the chain cutter, oil the oil wick and pipe as well as the moving parts.
- The position of the chain cutter should be adjusted by loosening the screw ④ after fitting the needle plate and cloth plate. When the chain cutter is in the correct position the clearance around the cloth plate guide ⑤ as well as the clearance between the cloth plate and needle plate should be 0.4mm (See Fig.18). Note too, that the Cloth plate guide ⑤ should be installed in such a way that its upper surface is 0.5mm higher than the upper surface of the needle plate (See Fig.19).
- To adjust the overlap of the blades, remove the clothguide plate ⑤ again. The correct overlap is 0.3mm (See Fig.20). To make this adjustment, rotate the pulley and move the upper knife to its highest position. Then loosen screw ⑦ and move the lower blade ⑧ until it is correctly adjusted.
- Rotate the pulley and check that the upper and lower blades engage smoothly and that they cut the thread cleanly.

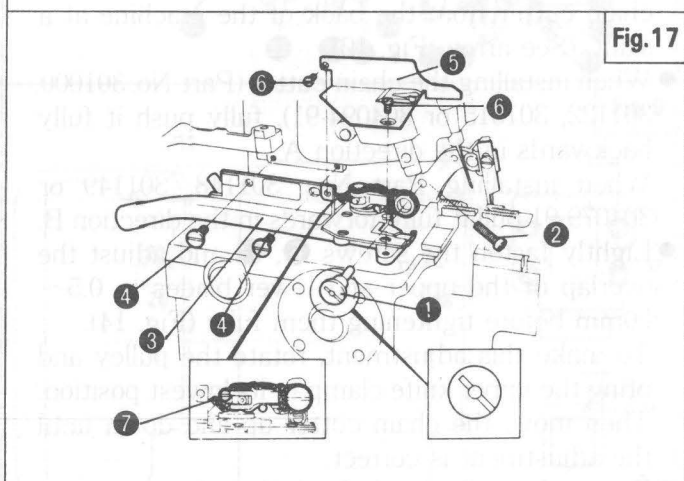
**Table 4**

Special cloth plates for KH device.

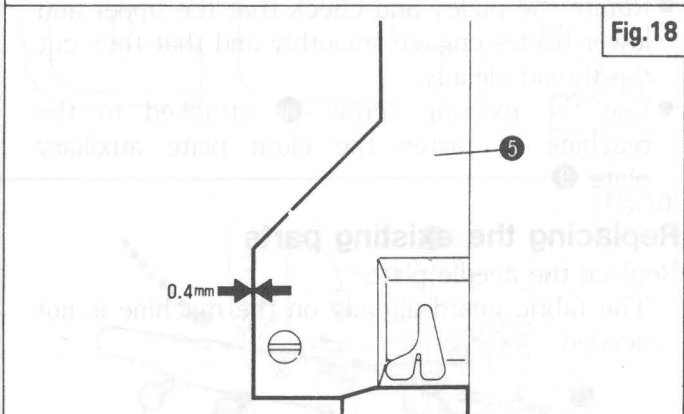
Machine Model		Cloth Plate	Remarks
Model No.	Needle Plate	Part No.	
L 32	2N ~3W	303758	Fig.16



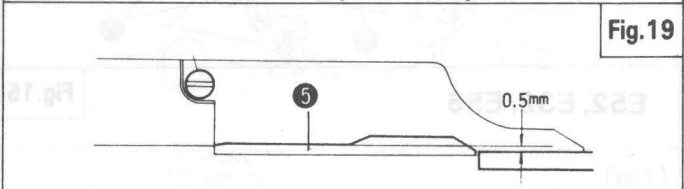
**Fig.16**



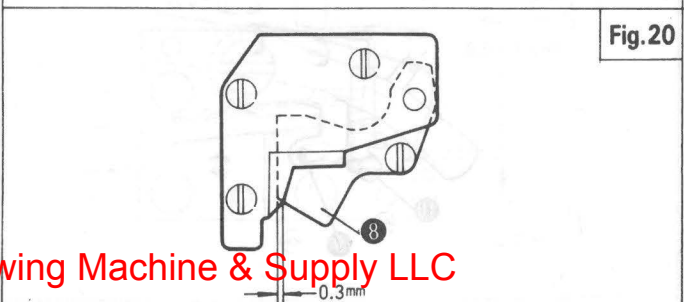
**Fig.17**



**Fig.18**



**Fig.19**



**Fig.20**

# KH Chain Cutter-Installation

## E32

### Preparation

#### 1. Removing the existing parts

Remove the needle plate, fabric guard and cloth plate.

#### 2. Interchanging existing parts

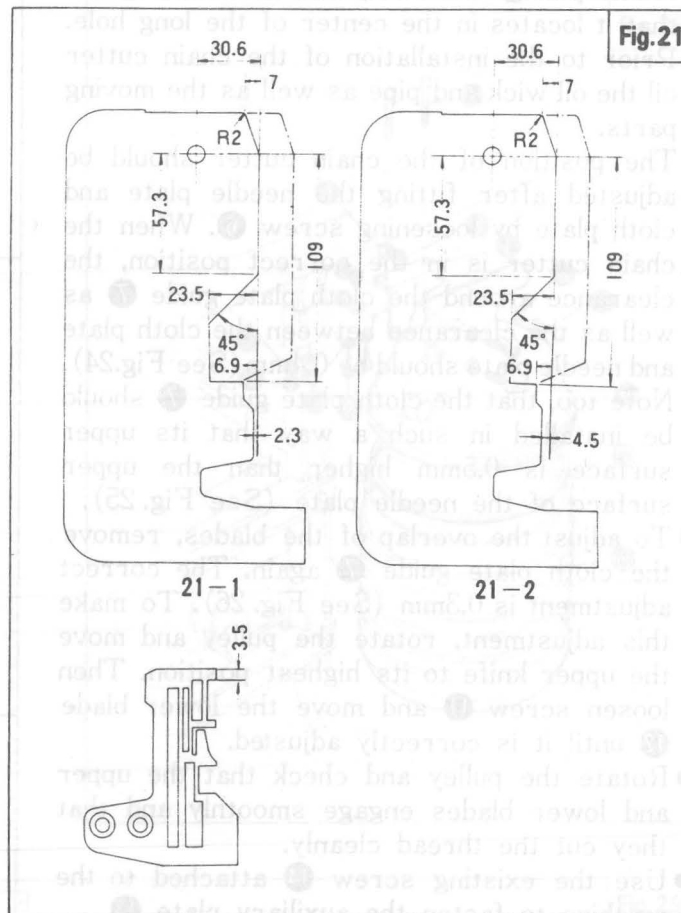
(Replacement: Table 5; Modification: Fig.21)

- If the special replacement cloth plate is to be used, refer to Table 5 and select the appropriate part.
- If the existing cloth plate is to be modified, refer to Fig. 21.
- Modify the needle plate fitted to the machine as shown (Fig. 21)

**Table 5**

Special cloth plates for KH device.

Machine Model		Cloth Plate	Remarks
Model No.	Needle Plate	Part No.	
E 32	2 N	301243	Fig.21-1
E 32	2 W	301241	Fig.21-2
	3 N		
	3 W		



## Installing the Chain Cutter (Fig. 22, 23)

Fit the parts in the sequence 1 to 8.

### Installation Hints

- When pin ① is fitted, fasten screw ② so that it locates in the center of the long hole.
- Prior to the installation of the chain cutter oil the oil wick and pipe as well as the moving parts.
- The position of the chain cutter should be adjusted after fitting the needle plate and cloth plate by loosening screw ⑥. When the chain cutter is in the correct position, the clearance around the cloth plate guide ⑦ as well as the clearance between the cloth plate and needle plate should be 0.4mm (See Fig.24). Note too, that the cloth plate guide ⑦ should be installed in such a way that its upper surface is 0.5mm higher than the upper surface of the needle plate (See Fig.25).
- To adjust the overlap of the blades, remove the cloth plate guide ⑦ again. The correct adjustment is 0.3mm (See Fig.26). To make this adjustment, rotate the pulley and move the upper knife to its highest position. Then loosen screw ⑪ and move the lower blade ⑫ until it is correctly adjusted.
- Rotate the pulley and check that the upper and lower blades engage smoothly and that they cut the thread cleanly.
- Use the existing screw ⑭ attached to the machine to fasten the auxiliary plate ⑬.

Note too, that the Cloth plate guide ⑦ should be installed in such a way that its upper surface is 0.5mm higher than the upper surface of the needle plate (See Fig. 19).

- To adjust the overlap of the blades, remove the clothguide plate ⑦ again. The correct overlap is 0.3mm (See Fig. 20). To make this adjustment, rotate the pulley and move the upper knife to its highest position. Then loosen screw ② and move the lower blade ② until it is correctly adjusted.
- Rotate the pulley and check that the upper

and lower blades engage smoothly and that they cut the

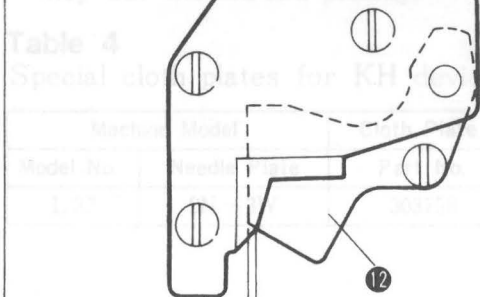


Fig.26

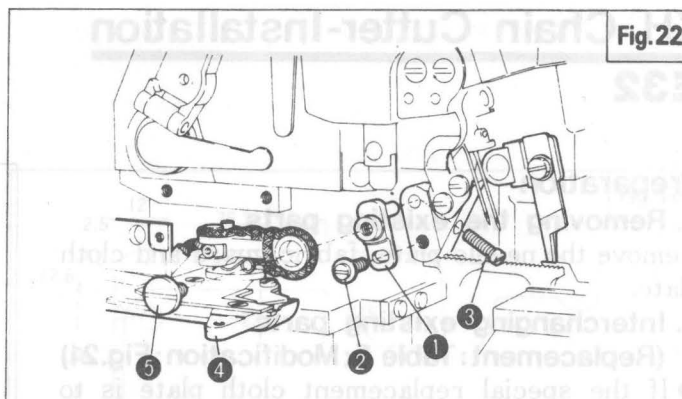


Fig.22

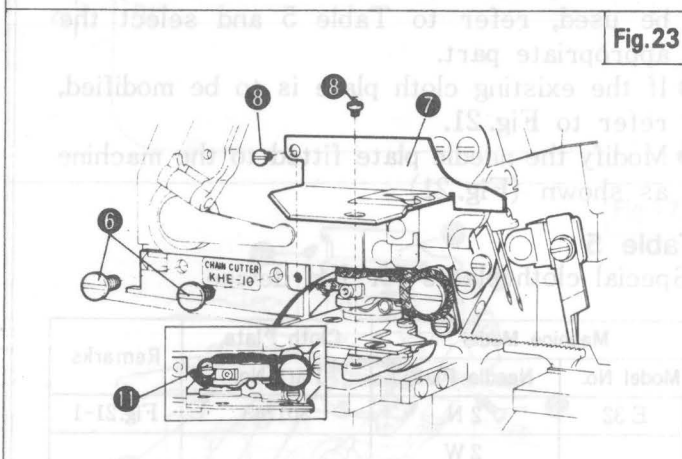


Fig.23

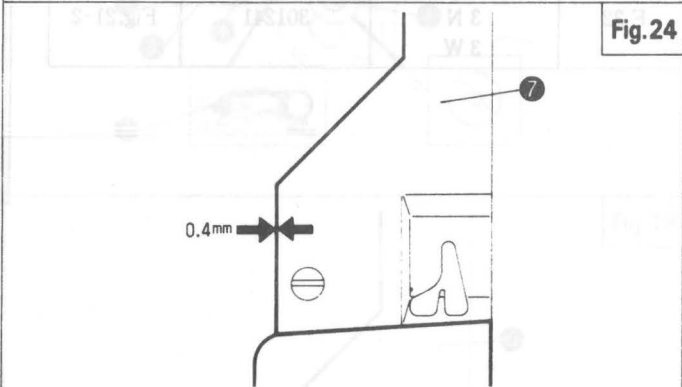


Fig.24

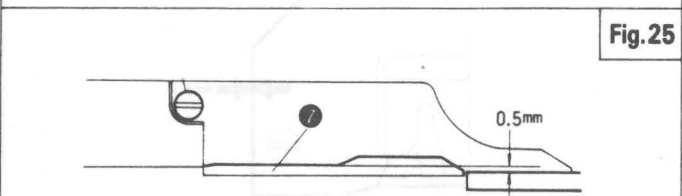


Fig.25

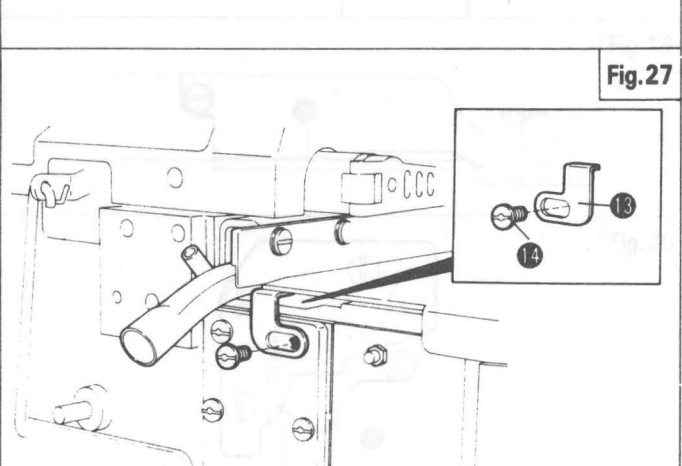


Fig.27

## Installing the Venturi Device

### Location (Figs. 30, 31)

Attach the device to the machine rest board depending on the machine type. (See Figs. 30, 31). Fit parts in sequence 1 to 4.

### Connecting the Air Pipes (Fig. 32)

#### 1. Connecting the air supply tube 5

After connecting the joint 7 to the compressor, locate the tube 5 on the joint 8 of the Venturi device and then tighten nut 9 securely.

#### 2. Connecting the air blower tube 6

When using a chain cutter with an air blower, connect the air blower 10 to the Venturi device with the tube 6 and loosen the screw 11.

#### 3. Connecting the tubes 16 and 17

Attach the two tubes as shown in Fig. 32.

The suction tube 16 connects the Venturi device to the chain cutter.

The air tube 17 connects the Venturi device to the waste receptacle.

- After all of the pipes have been correctly connected, the lever 13 should be connected to the foot pedal by the Chain 12.

### Adjustment

- i) Open the compressor valve and adjust the air supply so that it is less than  $10\text{kg/cm}^2$ .
- ii) Loosen nut 14 and turn the air regulator hand wheel 15 so the pressure is  $3\sim 3.5\text{kg/cm}^2$ .
- iii) Adjust the length of the chain 12 so that the chain cutter suction just starts to operate when the pedal is pressed lightly. The machine should only start to operate when the pedal is pressed harder.

