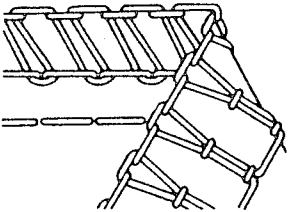


MO-2512

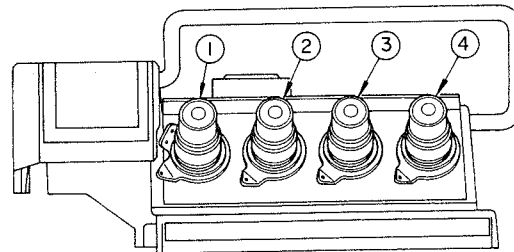
Stitch type - - - - 512 (U.S.A. stitch types standard)

| Stitch conformation | Number of needles | Number of threads | Always available models | Max. sewing speed (Normal sewing speed) (s.p.m.) | Application |
|---|-------------------|-------------------|--|--|---|
|  | 2 | 4 | MO-2512E-CD4-300 MO-2512E-CD6-300 MO-2512E-CF6-500 MO-2512E-DD6-500 MO-2512E-DF6-500 | 7500 (7000) | Imitation safety stitching of general fabrics and knit materials Imitation safety stitching of medium- to heavy-weight materials |

Main replacement parts

Thread tensioner asm

Refer to standard subclass list

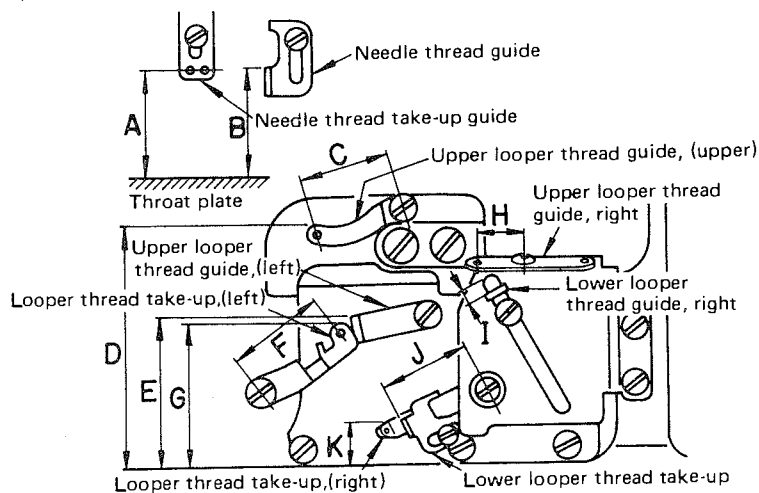


- ① Thread tension spring asm..... (red) B31017040B0
- ② Thread tension spring asm..... (yellow) B31027040B0
- ③ Thread tension spring asm..... (yellow) B31027040B0
- ④ Thread tension spring asm..... (blue) B31027040B0

ADJUSTMENT OF THE SEWING MACHINE

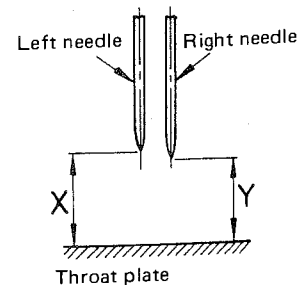
1. Adjustment of the thread take-ups and thread guides

(Position the thread take-ups and thread guides as shown below.)



2. Height of needles

(Adjust the height of the needles to meet the requirements shown below when they are at the highest point of their stroke.)

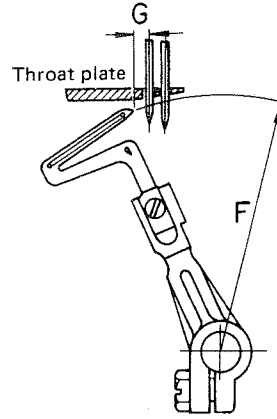
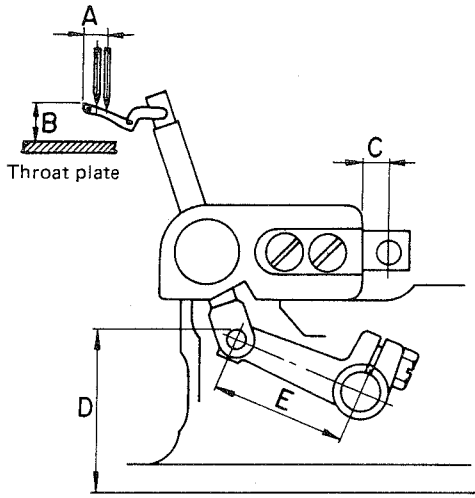


| Thread | Symbol | A | B | C | D | E | F | G | H | I | J | K |
|-----------------------------|--------|----|----|------|------|------|----|------|------|----|----|----|
| For general | | 74 | 74 | 22.5 | 63.5 | 40.5 | 26 | 40.5 | 13 | 14 | 23 | 14 |
| Looper thread, Wooly thread | | 74 | 74 | 22.5 | 63.5 | 40.5 | 26 | 45 | 18.5 | 14 | 23 | 14 |

| Subclass | Symbol | X | Y |
|----------|--------|------|-----|
| CD4, CD6 | | 10.5 | 9.2 |
| CF6 | | 10.5 | 9.2 |
| DD6, DF6 | | 10.5 | 8.9 |

3. How to adjust the upper and lower loopers

(Adjust the upper and lower loopers as shown below when they are at the extreme left of their travel.)

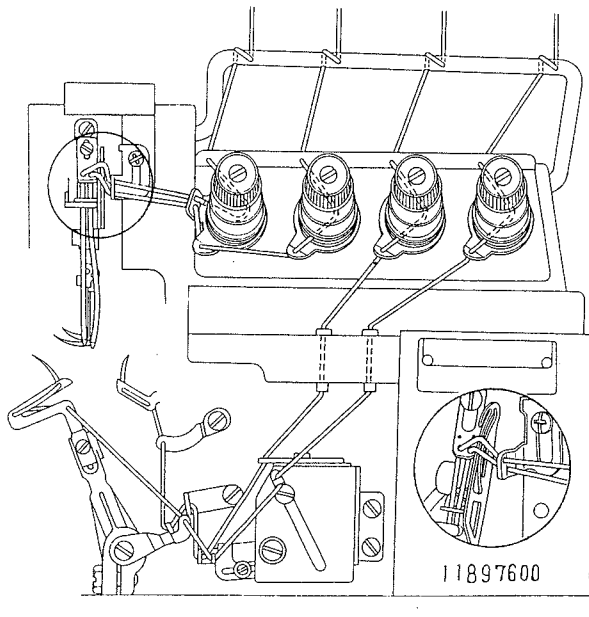


| Subclass | Symbol | A | B | C | D | E |
|----------|--------|-----|------|-----|------|----|
| CD4, CD6 | | 4.3 | 10.3 | 5.5 | 46.6 | 39 |
| CF6 | | 3.6 | 10.8 | 6 | 46.6 | 39 |
| DD6, DF6 | | 4 | 10.8 | 6 | 46.6 | 39 |

| Subclass | Symbol | F | G |
|----------|--------|------|-----|
| CD4, CD6 | | 66.4 | 3.5 |
| CF6 | | 66.4 | 2.6 |
| DD6, DF6 | | 66.4 | 2.6 |

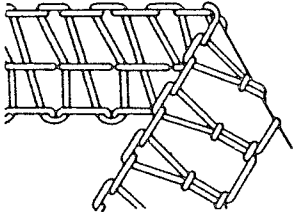
4. Threading the machine

(Set each thread as illustrated)



MO-2514

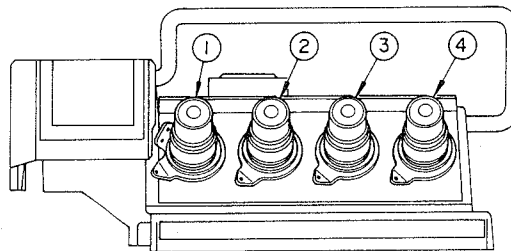
Stitch type - - - - 514 (U.S.A. stitch types standard)

| Stitch conformation | Number of needles | Number of threads | Always available models | Max. sewing speed (Normal sewing speed) (s.p.m.) | Application |
|---|-------------------|-------------------|-------------------------|--|---|
|  | 2 | 4 | MO-2514E-ZA5-100 | 8500 (8000) | Closing stitches on panty hose toes, and side seaming |
| | | | MO-2514E-XB5-100 | | |
| | | | MO-2514E-AB4-100 | 8000 (7500) | Overedging of knit materials such as knitwork and jersey. |
| MO-2514E-AD4-300 | | | | | |
| | | | MO-2514E-BB4-300 | 7500 (7000) | Overedging of medium-weight knit, jersey, heavy-weight and bulky materials. |
| | | | MO-2514E-BD4-200 | | |
| | | | MO-2514E-BD4-300 | | |
| | | | MO-2514E-BE4-300 | | |
| | | | MO-2514E-CD6-300 | | |
| | | | MO-2514E-BD6-300 | | |
| | | | MO-2514E-CD6-300 | | |

Main replacement parts

Thread tensioner asm

Refer to standard subclass list



Light-weight materials

- ① Thread tension spring asm. (yellow) B31027040B0
- ② Thread tension spring asm. (yellow) B31027040B0
- ③ Thread tension spring asm. (yellow) B31027040B0
- ④ Thread tension spring asm. (blue) B31037040B0

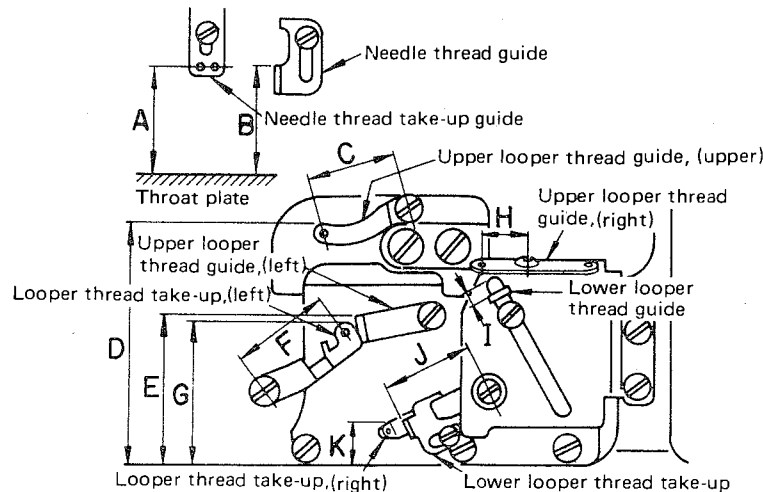
Standard, Heavy-weight materials

- ① Thread tension spring asm. (red) B31017040B0
- ② Thread tension spring asm. (yellow) B31027040B0
- ③ Thread tension spring asm. (yellow) B31027040B0
- ④ Thread tension spring asm. (blue) B31037040B0

ADJUSTMENT OF THE SEWING MACHINE

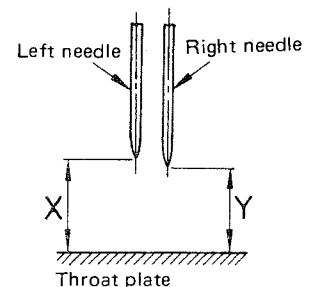
1. Adjustment of the thread take-ups and thread guides

(Position the thread take-ups and thread guides as shown below.)



2. Height of needles

(Adjust the height of the needles to meet the requirements shown below when they are at the highest point of their stroke.)

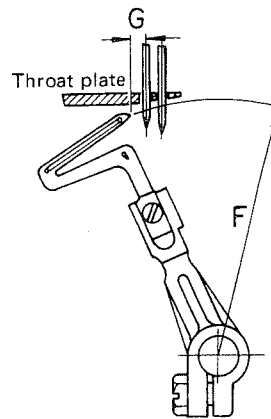
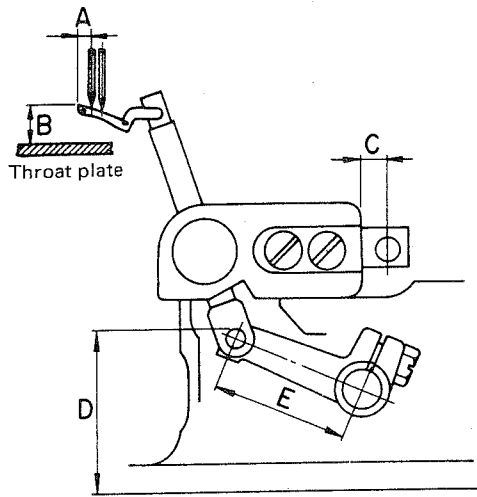


| Thread | Symbol | A | B | C | D | E | F | G | H | I | J | K |
|-----------------------------|--------|----|----|------|------|------|----|------|------|----|----|----|
| For general | | 74 | 74 | 22.5 | 63.5 | 40.5 | 26 | 40.5 | 13 | 14 | 23 | 14 |
| Looper thread, Wooly thread | | 74 | 74 | 22.5 | 63.5 | 40.5 | 26 | 45 | 18.5 | 14 | 23 | 14 |

| Subclass | Symbol | X | Y |
|----------|--------|------|-----|
| ZA5, XB5 | | 10 | 10 |
| AB4, AD4 | | 10 | 9.7 |
| BD4, BD6 | | 10 | 9 |
| CD4, CD6 | | 10.2 | 8.9 |

3. How to adjust the upper and lower loopers

(Adjust the upper and lower loopers as shown below when they are at the extreme left of their travel.)



| Subclass | Symbol | A | B | C | D | E |
|----------------------|--------|-----|------|-----|------|----|
| ZA5, XB5 | | 4 | 11 | 7 | 45 | 38 |
| AB4, AD4, BD4 BD6 | | 4.8 | 10.7 | 7 | 46.7 | 39 |
| CD4, CD6 | | 4.3 | 10.5 | 6.5 | 47.3 | 39 |
| BD4, BD6-307 | | 4.3 | 10.3 | 6 | 47.3 | 39 |
| BD6, BD7-4A0 | | 4.5 | 10.2 | 5.5 | 47.3 | 39 |

| Subclass | Symbol | F | G |
|----------------------|--------|------|-----|
| ZA5, XB5 | | 66.4 | 4 |
| AB4, AD4, BD4 BD6 | | 66.4 | 4 |
| CD4, CD6 | | 66.4 | 3.2 |
| BD4, BD6-307 | | 66.4 | 3.5 |
| BD6, BD7-4A0 | | 66.9 | 3.5 |

4. Threading the machine

(Set each thread as illustrated)

