

MODEL MOR-816
2-NEEDLE, 5-THREAD, VARIABLE TOP FEED
SAFETY STITCHER (RAKE-IN TYPE)

MODEL MOR-814
2-NEEDLE, 4-THREAD, VARIABLE TOP FEED
OVEREDGER (RAKE-IN TYPE)

INSTRUCTION BOOK

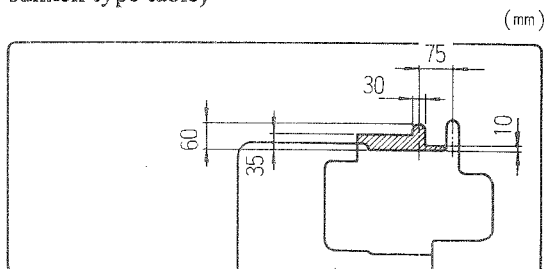
MOR-800 series models have basically the same mechanism as those of MO-800 series models excepting that the top feed mechanism is incorporated in MOR-800 models. By this reason, you are requested to refer to a separate Instruction Book for MO-800 models for the common instructions omitted from this book. For example, refer to the Instruction Book for MO-816-DD4 when your machine is MOR-816-DD4.

1. SPECIFICATIONS

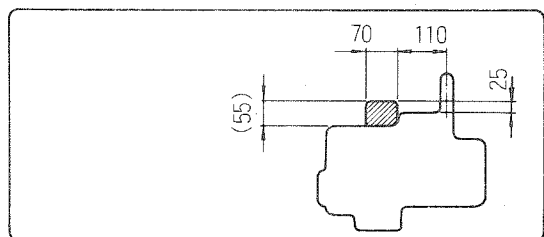
	MOR-816				MOR-814S	
	DD4	DF6	FF6	RH6/601	BD4	BD7/606
Sewing speed	Max. 4,000 s.p.m.					
Top feed differential feed ratio	1:0.75 ~ 1:1.3 (main feed dog : top feed dog) : standard 1:1 ~ 1:2 (main feed dog : top feed dog) : stitch length does not exceed 3.0mm (1/8")					
Top feed dog lift	6.5 mm (1/4")				6 mm (15/64")	
Presser foot lift	5.5 mm (7/32")				5 mm (13/64")	

2. MACHINE TABLE

(Fully-sunken type table)

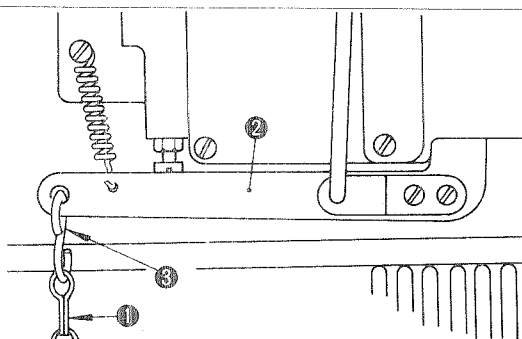


(Semi-sunken type table)



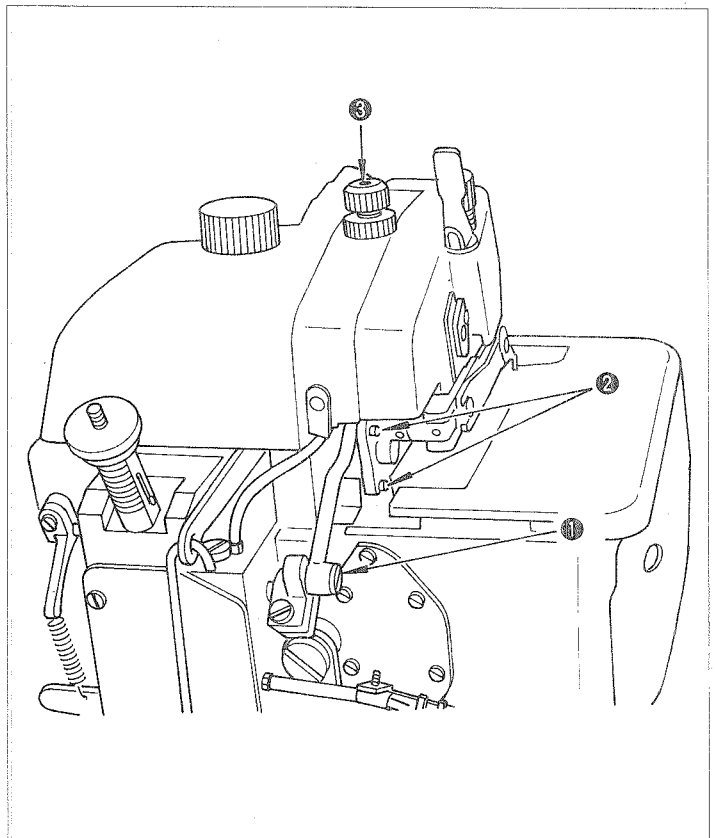
When you install the machine head on an existing table, cut the shadowed portion as illustrated.

3. PRESSER LIFTING CHAIN



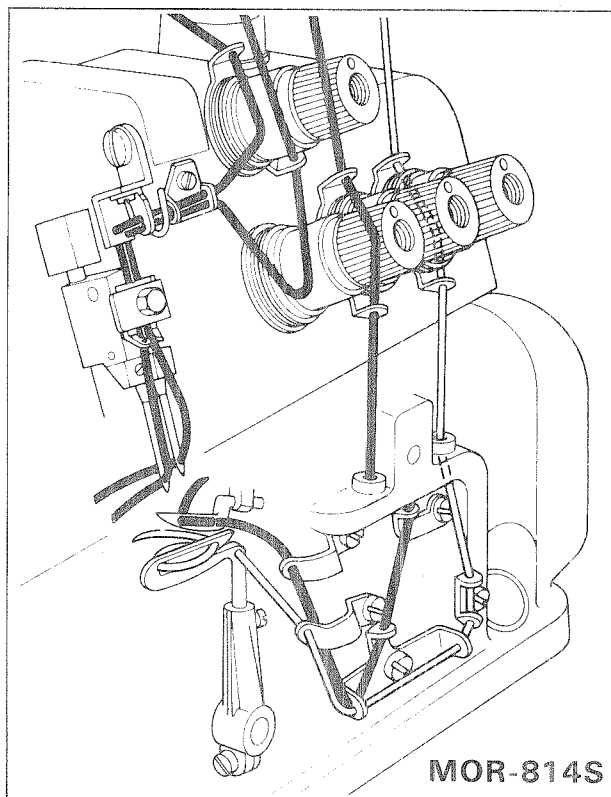
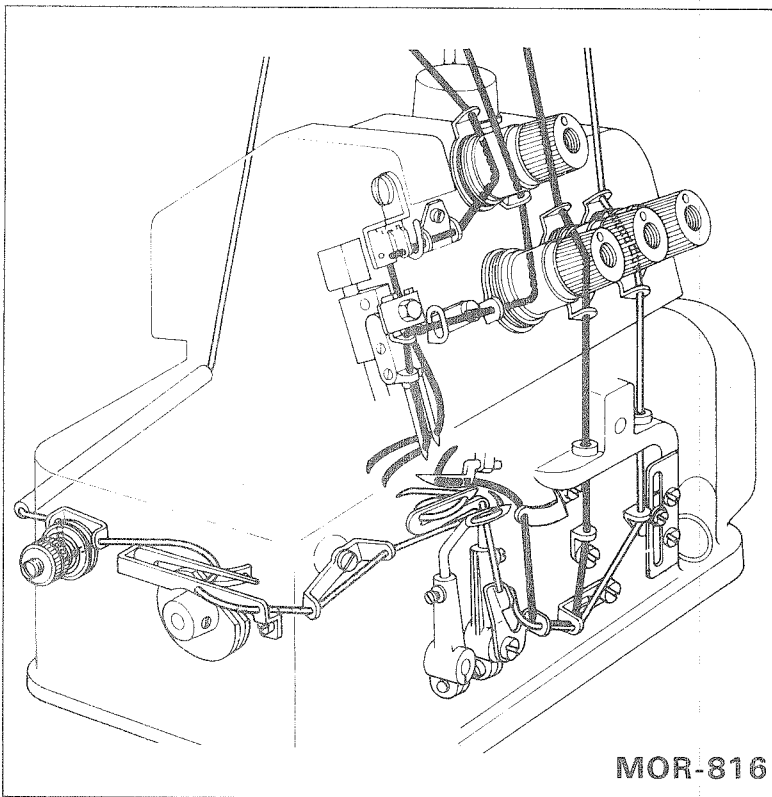
Attach presser lifting chain ① to a connection hole in the top end of lifting lever ② using "S" shape hook ③

4. LUBRICATION



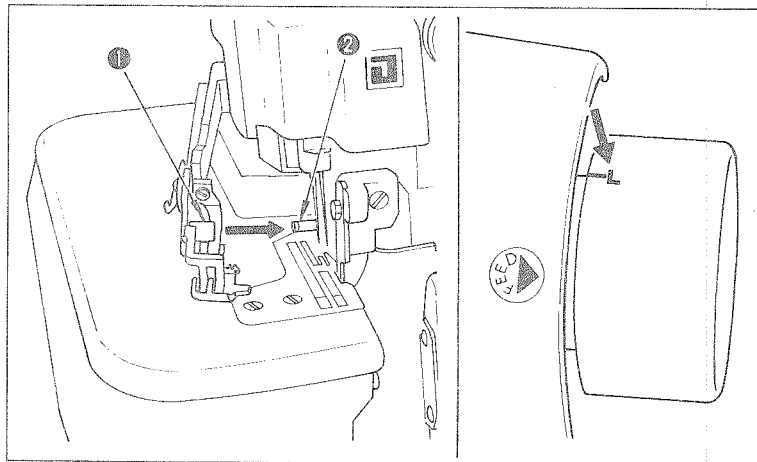
Before operating a new machine or a machine which has not been used for a long period of time, apply a few drops of lubricating oil to hinge screw ① in the top feed link (B), top feed driving arm pins (upper and lower) ② and top feed presser bar ③ respectively.

5. THREADING THE MACHINE



Thread the machine according to the drawing given below. (the same drawing is on the rear of the looper cover of the machine).

6. PRESSER FOOT

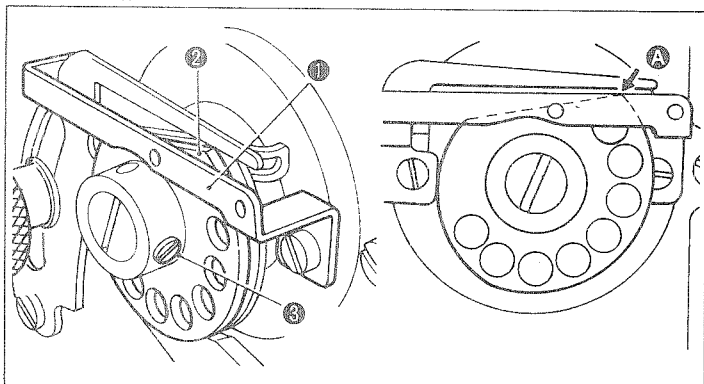


When you remove the presser foot, rotate the pulley until the letter "L" comes to the top, and the presser foot will easily come off. When you return it to the original position, make sure that the letter "L" is at the top. (Other operations of this machine are the same as those of MO-800).

* The standard pressure is 4 kg.

(CAUTION) Before operating the machine, ensure that driving arm pin ② is inserted in driving arm bushing ①.

7. ADJUSTMENT OF THE LOOPER THREAD CAM (MOR-816)



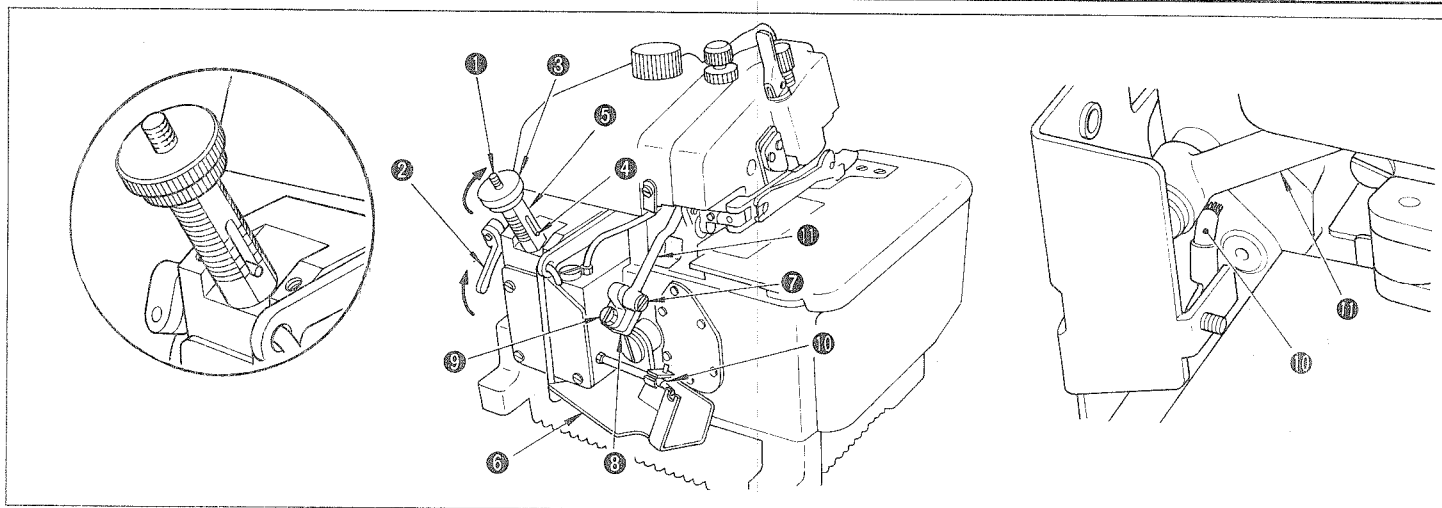
Right edge ① of the flat part of chain looper thread cam ② must be at the level of the upper face of chain looper thread cam ② thread guide ① when the needle is at the highest point of its stroke. Loosen screw ③ and adjust the looper thread cam.

8. TOP FEED AMOUNT

The top feed amount varies when the bottom feed amount (stitch length) is changed by the push button. (Refer to MO-800 Instruction Book for how to adjust the stitch length.)

(CAUTION) When you operate the machine at the maximum top differential feed ratio (1:2), ensure that the stitch length does not exceed 3.0mm (1/8").

9. ADJUSTING THE TOP DIFFERENTIAL FEED RATIO



You can change the top feed amount without changing the bottom feed amount, by turning top-feed adjusting nut ③ on the back of the head as follows:

1. Move top feed stopper arm ② in the direction of the arrow, and top-feed shaft ① will become loose. Then turn top-feed adjusting nut ③ in the direction of the arrow, and pin ④ will come out to make the differential feed mechanism function. Since the use of the differential feed mechanism efficiently prevents the cloth from slipping, adjust it properly according to the characteristics of the materials and the sewing processes.

2. After the adjustment, move top feed stopper arm ② in the reverse direction and be sure to fix shaft ① in place.

★ **1 : 0.75 ~ 1 : 1.3 (main feed dog : top feed dog) — standard**

When pin ④ stays between the third and the fourth lines from the bottom engraved on shaft metal ⑤, the top differential feed ratio is about 1 : 1.

The pin corresponding to the highest line indicates that the differential feed ratio is about 1 : 1.3, while the pin to the lowest line indicates the ratio about 1 : 0.75.

★ **1 : 1 ~ 1 : 2 (main feed dog : top feed dog) — stitch length does not exceed 3.0mm (1/8")**

1. When you want to operate the machine at the differential feed ratio of 1 : 2, remove top feed link cover ⑥ and fix hinge screw ⑦ into the upper hole of top feed arm ⑧.

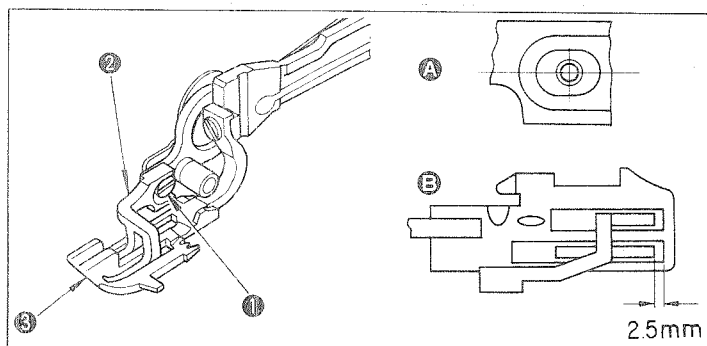
(CAUTION) Don't loosen the set screws ⑨ of top feed arm (C).

2. Fix top feed link cover. Set in the way that oil felt ⑩ which is attached to the cover rests in top feed link ⑪.

3. When pin ④ corresponds to the lowest line engraved on shaft metal ⑤, the ratio is about 1 : 1. When it corresponds to the highest line, the ratio is about 1 : 2.

(CAUTION) Ensure the stitch length is less than 3.0 mm (1/8"), when you use the machine at the ratio of 1 : 2.

10. HOW TO REPLACE TOP FEED DOG

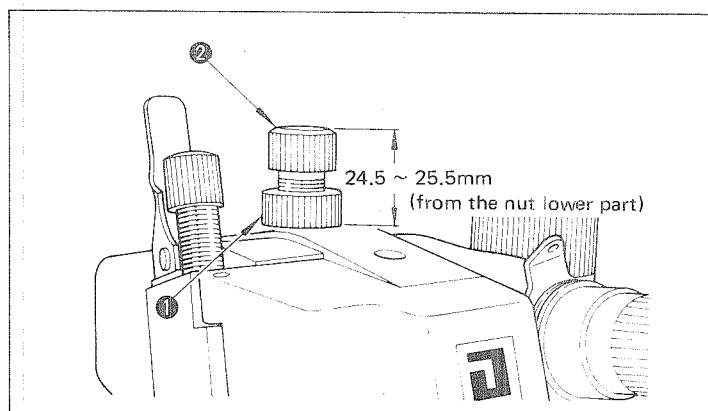


Loosen top feed dog set screw ①, and top feed dog ② will come off. When you attach top feed dog in place, in order to prevent it from beating against presser foot ③, take either of the following measures:

Ⓐ Tighten the screw in the middle of the setting slot of top feed dog.

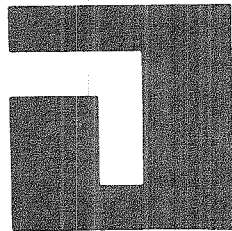
Ⓑ When the top feed dog beats against presser foot, advance top feed dog to the point that the gap between presser foot and top feed dog is 2.5 mm (3/32").

11. ADJUSTING PRESSURE OF TOP FEED DOG

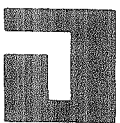


Loosen nut ② and tighten adjusting screw ① to increase the pressure of the top feed dog and the feeding power accordingly. The standard protrusion of the adjusting screw ① from the nut lower part is between 24.5mm (61/64") and 25.5mm (1").

(CAUTION) If you let it project more than 25.5mm (1"), the pressure of the top feed dog becomes too low and the top feed dog may jump with a noise. Tighten the screw until the noise drops.



(Please do not hesitate to contact our distributors or agents)
(in your area for further informations when necessary.)



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