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|----------|---|
| CS-5371N | SINGLE NEEDLE, LOCKSTITCH, POST-BED MACHINE WITH A LARGE HOOK |
| CS-5372N | TWIN NEEDLE, LOCKSTITCH, POST-BED MACHINE WITH A LARGE HOOK |

Please read this Instruction Manual carefully before using the unit in order to get the most out of it and to enjoy using it for a long time. Please keep this Instruction Manual at hand taking care not to lose it.

INSTRUCTION MANUAL

BEFORE OPERATION

1. Do not operate the machine even for trial before lubrication it.
2. Confirm that the voltage and phase (single or 3-phase) are correct by checking them against the ratings shown on the motor nameplate.
3. When running your machine for the first time after the set-up, check the rotational direction of the handwheel. ★ Turn on the power switch. Run the machine at a low speed while checking the rotational direction of the handwheel. (The handwheel should turn counterclockwise as observed from the handwheel side.)
4. For the first month, run the machine at speed of 1800 s.p.m. or less.

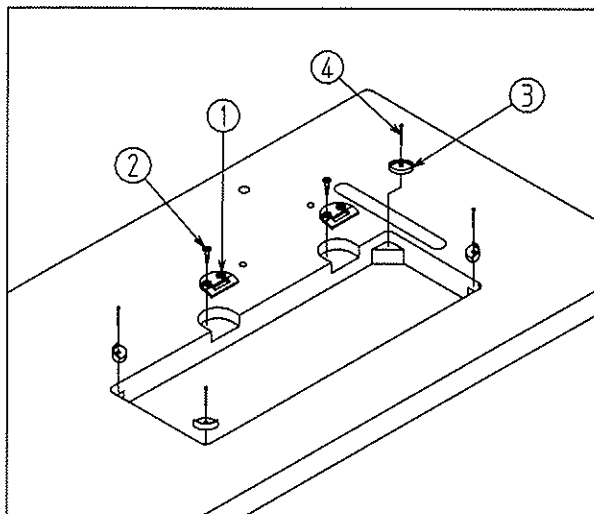
CAUTIONS IN OPERATION

1. Keep your hands away from the needle when you turn on the power switch or while the machine is operating.
2. During operation, be careful not to allow your or any other person's head or fingers to come close to the handwheel, V-belt, bobbin winder or motor. Also, do not place anything close to them.
3. Do not turn the machine with the finger guard, belt cover or any other protectors removed.
4. Be sure to turn off the power switch and confirm that the motor is completely stopped before removing the V-belt.

SPECIFICATIONS

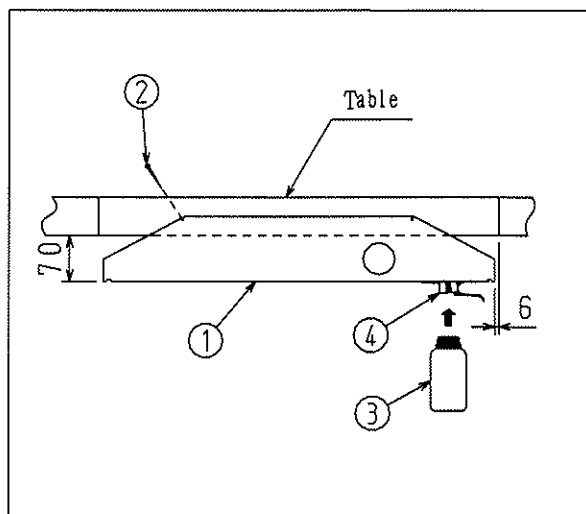
| | |
|----------------------|--|
| Usage | Bags, Shoes, Medium-weight materials |
| Sewing speed | Max. 2400s.p.m. |
| Stitch length | Forward stitch: 6 mm, Reverse stitch: 6 mm |
| Needle | DPx5 #14~#18 (normal: #16) |
| Lift of presser foot | Hand lifter: 8 mm, Knee lifter: 12 mm |
| Lubricating oil | Machine oil (white spindle oil) |

1. SETTING UP THE SEWING MACHINE



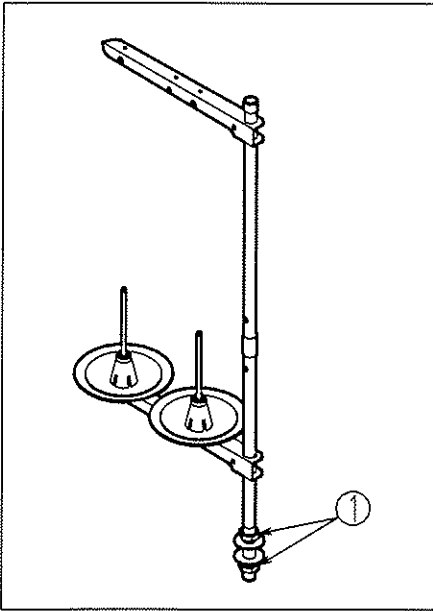
① Installing the cushion

Fasten the hinge supporter ① and rubber cushion ③, on the table using the nails ② and woodscrew ④.



② Installing oil pan

- 1) Fasten the oil pan ① on the table using nails ② (at 4 places).
- 2) Install the oiler ③ to the oiler supporter ④.



2. INSTALLING THE THREAD STAND

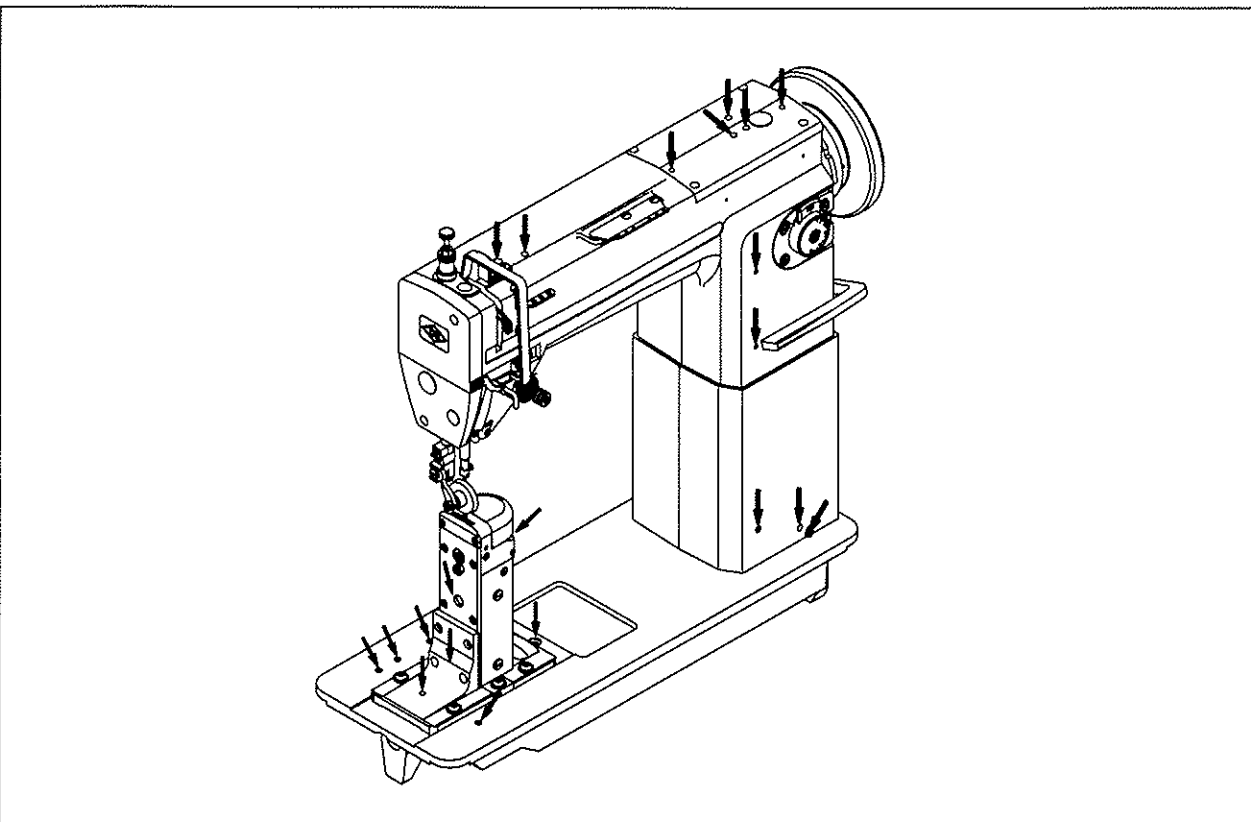
Assemble the thread stand, and install it to the right-hand side of the far side of the table with nuts ①

3. LUBRICATION



CAUTION

TURN THE SWITCH OFF THE POWER SUPPLY TO PREVENT FROM UNEXPECTED INJURY. BE SURE TO CONFIRM THE STOP OF ROTATION OF THE MOTOR BEFORE OPERATIONS.



Before starting the machine.

1) Prior to operation, be sure to properly lubricate the points marked with the arrows.

When oiling all sections requiring lubrication, after installation of the machine has been completed, wait for a while (approximately 10 minutes) so that oil can penetrate each section sufficiently before starting continuous operation.

When starting the machine initially and after kept away for a long time without using at all, apply two or three drops of oil each section noted with an arrow mark, and to operate the machine continuously, apply two or three drops of oil each section whenever starting operation in the morning and in the afternoon.

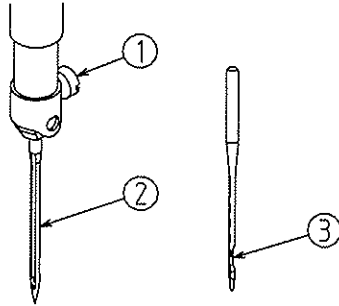
4. HOW TO INSTALL THE NEEDLE



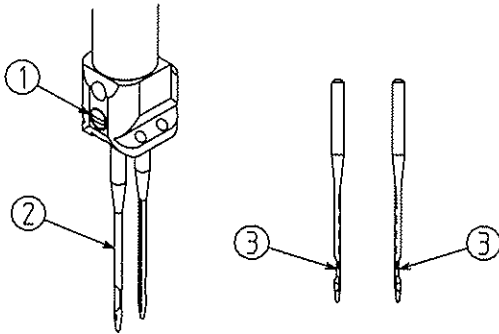
CAUTION

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MODLE CS-5371N



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★ BE SURE TO POWER-OFF THE MOTOR

The normal needle system is 'DPX5'.

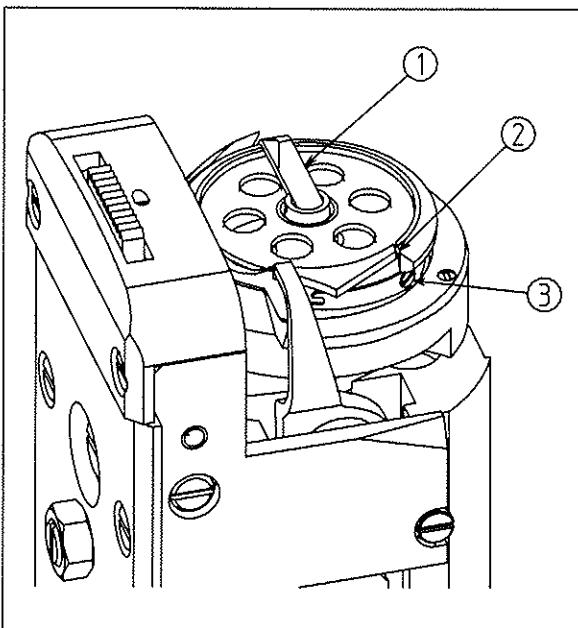
- 1) Turn the handwheel by hand and raise the needle bar to its top position
- 2) Loosen screw ① and insert the needle ② into the hole until it will go no further.
◇ Insert the needle with its recess ③ facing directly to the right-hand side, in case of the modle CS-5372N, the recess of each needle should face to outside.
- 3) Securely tighten the screw in the needle

5. HOW TO INSTALL THE BOBBIN



CAUTION

TURN THE SWITCH OFF THE POWER SUPPLY TO PREVENT FROM UNEXPECTED INJURY. BE SURE TO CONFIRM THE STOP OF ROTATION OF THE MOTOR BEFORE OPERATIONS.



◇ Removing the bobbin

Slide out the bed slide plate open the bobbin case latch ① and pick up bobbin

◇ Inserting the bobbin

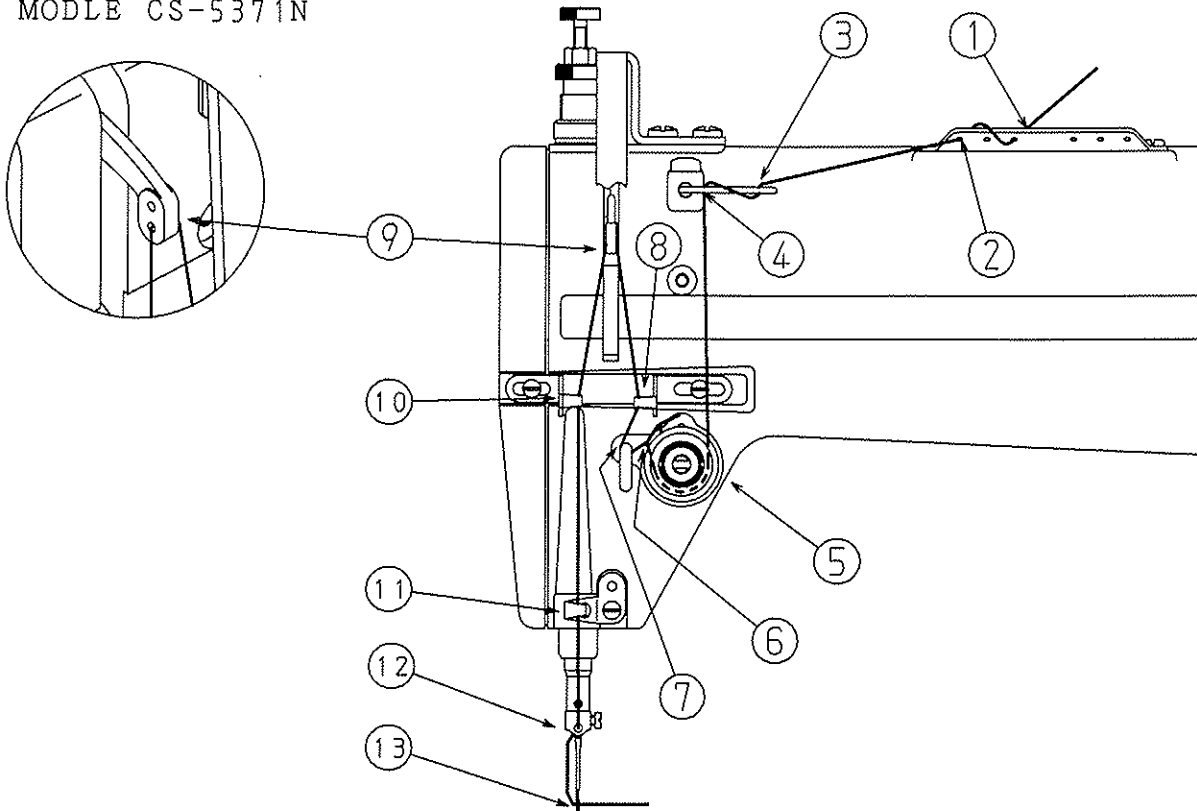
- 1) Draw out the thread end about 5cm and put the bobbin into the rotary hook and close the bobbin case latch ①.
- 2) Pull the drawn out thread into the slot ②, and draw out the thread under the spring ③.
- 3) Close the bed slide plate.

6. HOW TO THREAD THE MACHINE HEAD

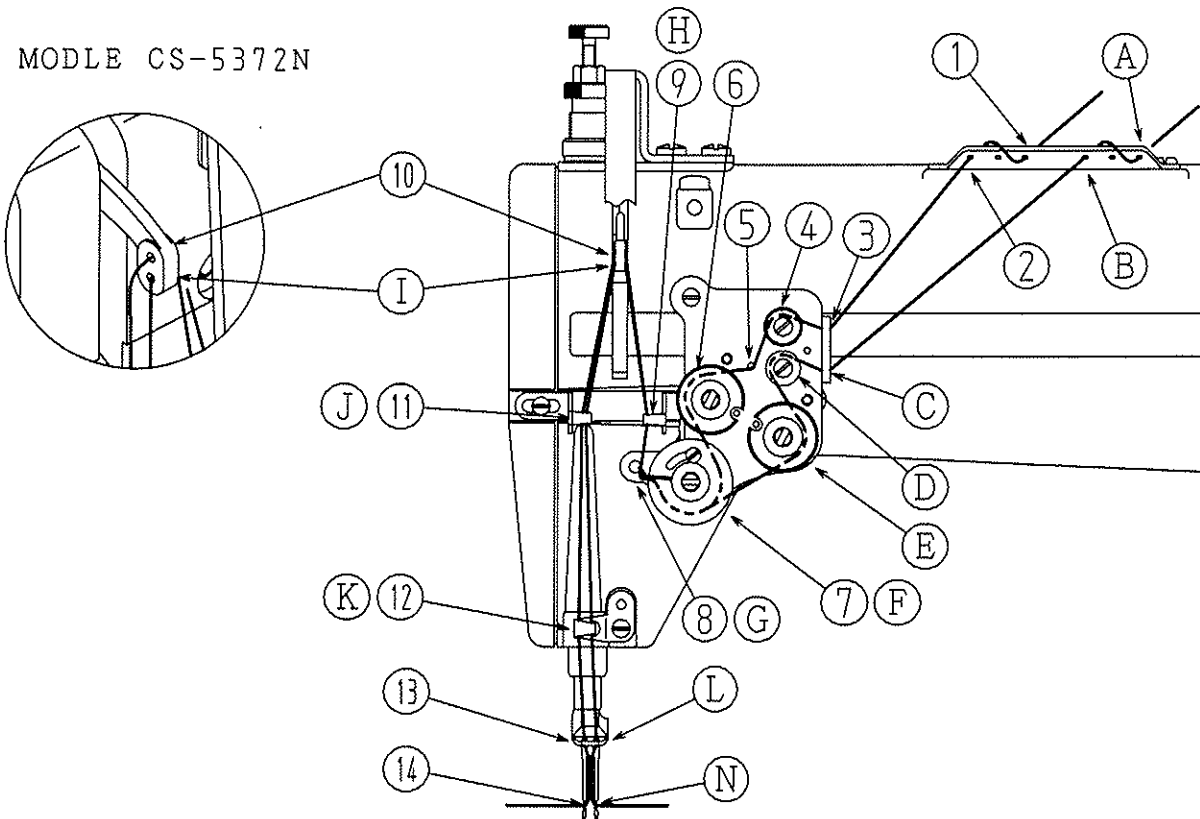
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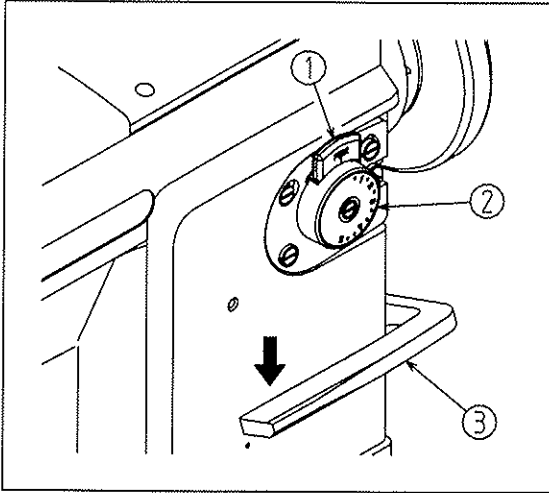


MODLE CS-5372N



Thread the machine head as illustrated

7. ADJUSTING THE STITCH LENGTH

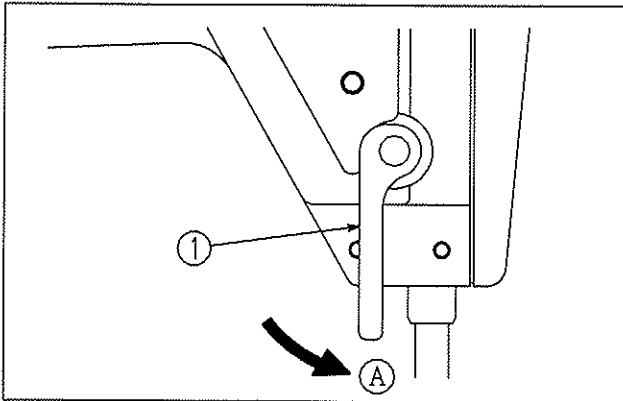


To adjusting the stitch length, push the lock plate ①. Align the stitch length dial ② indicator to the line of the lock plate turning stitch length dial counterclockwise or clockwise

★ Reverse stitching

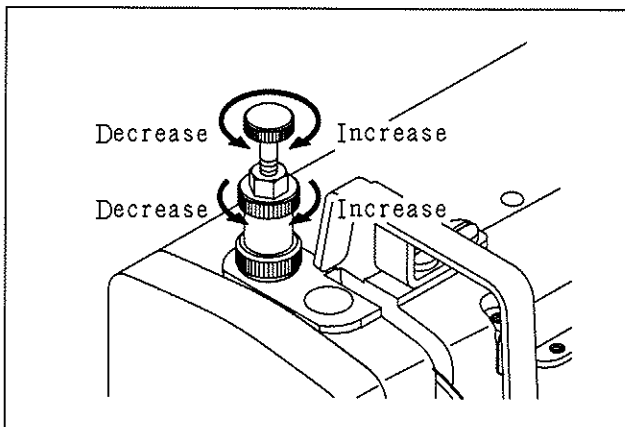
- 1) Push the feed lever ③ down
- 2) The machine performs reverse feed stitching as long as the lever is held depressed
- 3) The moment you release the lever, the machine resumes the normal stitching mode

8. LIFTING THE PRESSER FOOT



- 1) Turn the hand lifter lever ① counterclockwise (toward A), the presser foot up.

9. ADJUSTING THE PRESSER FOOT PRESSURE



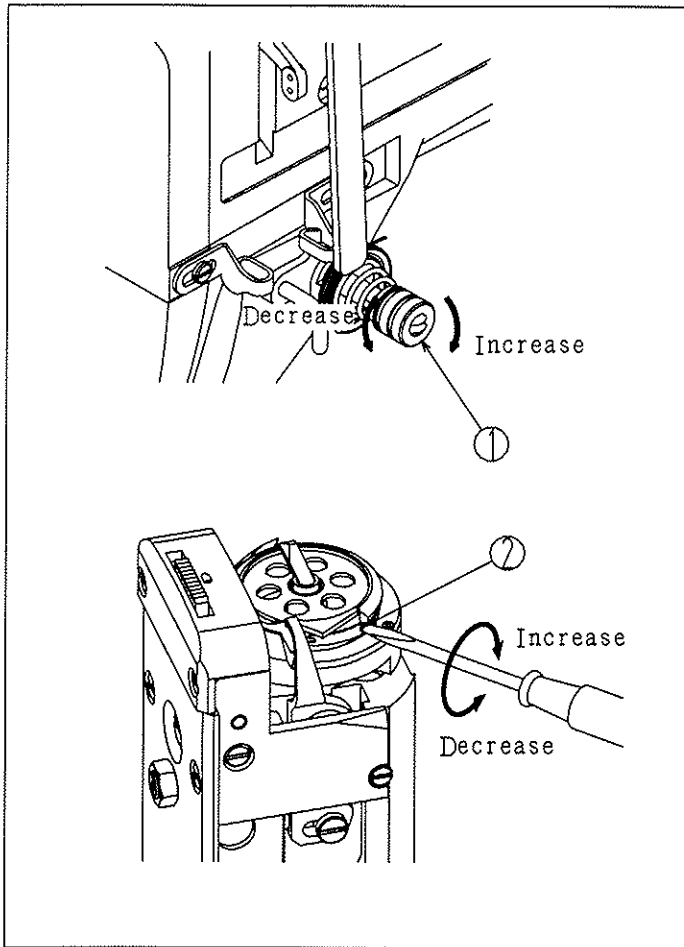
- 1) Turn the presser spring regulator to the right to increase and to the left to decrease pressure

10. THREAD TENSION



CAUTION

TURN THE SWITCH OFF THE POWER SUPPLY TO PREVENT FROM UNEXPECTED INJURY. BE SURE TO CONFIRM THE STOP OF ROTATION OF THE MOTOR BEFORE OPERATIONS.



(1) Adjusting the needle thread tension

Turn the thread tension nut ① clockwise to increase or counterclockwise to decrease the needle thread tension.

(2) Adjusting the bobbin thread tension

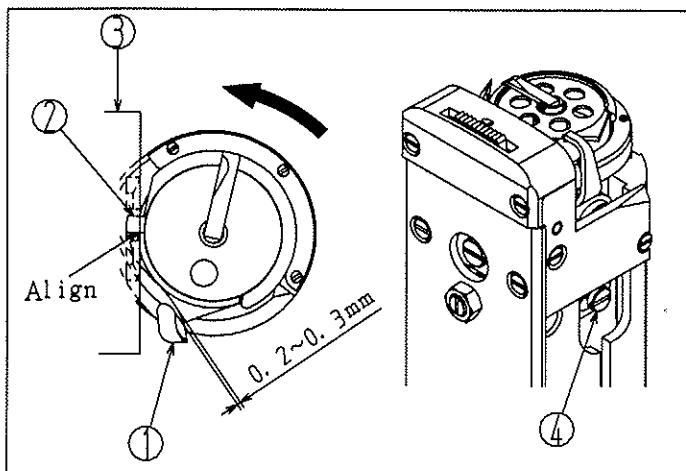
Turn the tension screw ② clockwise to increase or counterclockwise to decrease the bobbin thread tension.

11. HOW TO ADJUST THE BOBBIN CASE OPENING LEVER



CAUTION

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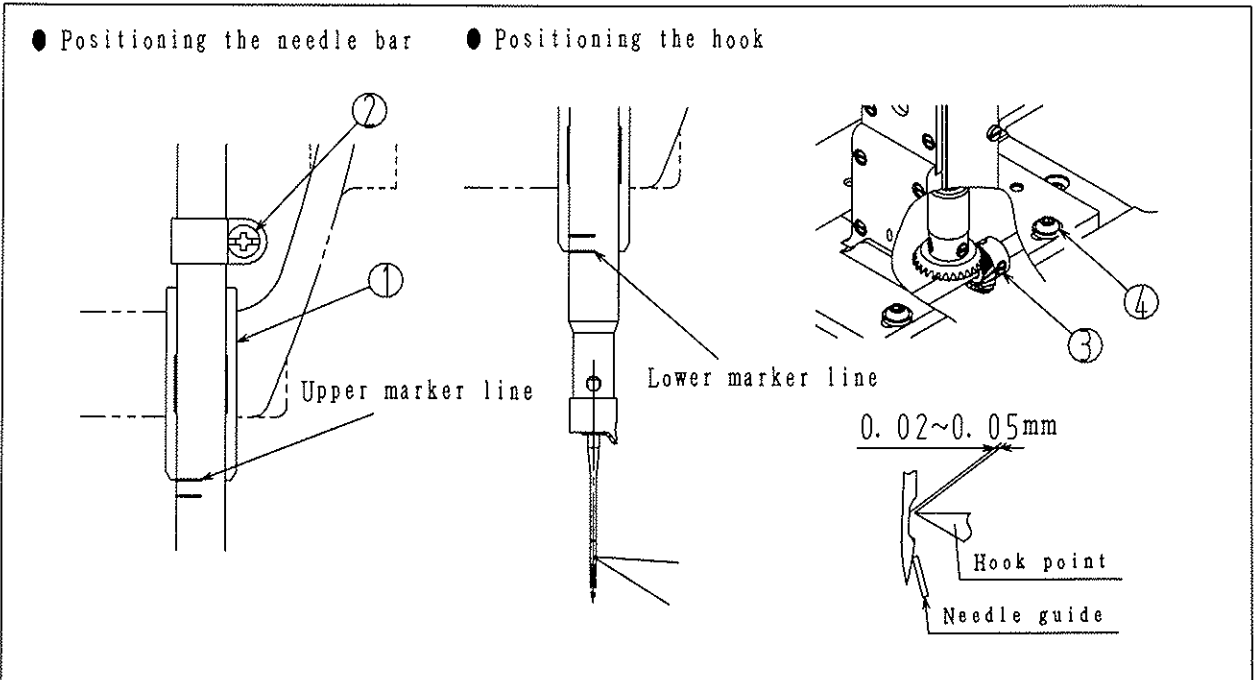
1) Turn the handwheel by hand, and bring the bobbin case opening lever ① until it will go no further.

2) Align the inner hook ② to the throat plate ③, and then turning inner hook ② counterclockwise by hand.

3) Loosen the screw ④, adjust the clearance between bobbin case opening lever and projection of the bobbin case to 0.2 to 0.3mm then securely tighten screw ④.

12. NEEDLE-TO-HOOK RELATIONSHIP

⚠ CAUTION TURN THE SWITCH OFF THE POWER SUPPLY TO PREVENT FROM UNEXPECTED INJURY. BE SURE TO CONFIRM THE STOP OF ROTATION OF THE MOTOR BEFORE OPERATIONS.



○ Adjusting the needle bar height

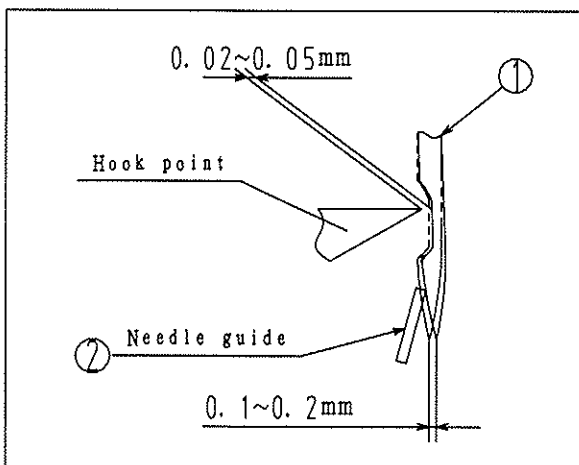
- 1) Bring the needle bar down to its lowest position, and adjust so that the upper marker line on the needle bar aligns with the bottom end needle bar lower bushing ①, then tighten screw ② needle bar clamp

○ Adjust the timing between the needle and the hook

- 2) Loosen screw ③ of the bevel gear and loosen screw ④ of the hook saddle.
- 3) Adjust so that the specified marker line on the ascending needle bar aligns with the bottom end needle bar frame.
- 4) Move the hook saddle to the right or left until a clearance 0.02 to 0.05mm is provided between the blade point of the hook and needle. After the adjustment, securely tighten the screw.
- 5) Then align the blade point of the hook with the center of the needle, and tighten screw ③ in the gear.

13. ADJUSTING THE NEEDLE GUIDE

⚠ CAUTION TURN THE SWITCH OFF THE POWER SUPPLY TO PREVENT FROM UNEXPECTED INJURY. BE SURE TO CONFIRM THE STOP OF ROTATION OF THE MOTOR BEFORE OPERATIONS.



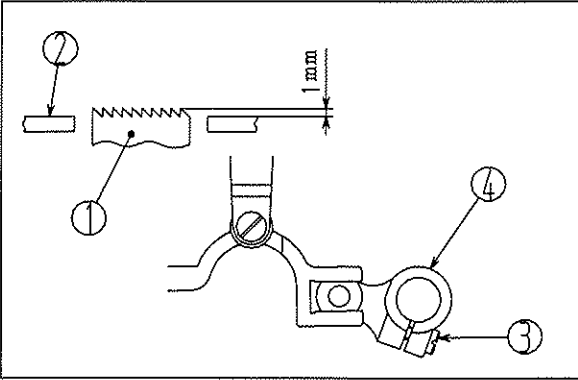
- ☆ Confirm the position of the needle guide in the hook when you changed the hook

The needle ① is a slight bend to 0.1 to 0.2 mm by needle guide ②.

Adjust the needle guide position to inside or outside direction using a screwdriver.

14. HEIGHT OF THE FEED DOG

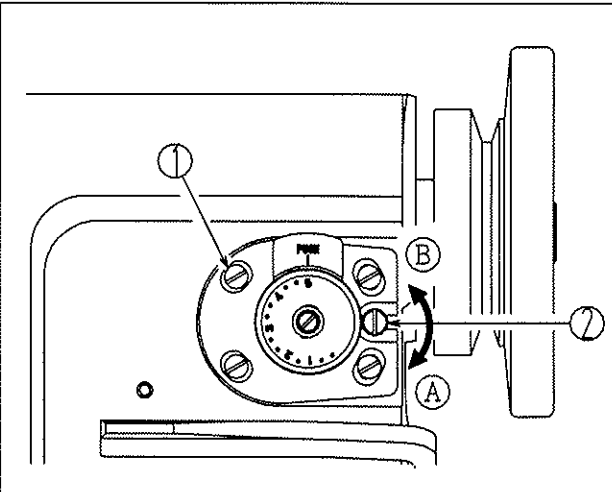
⚠ CAUTION TURN THE SWITCH OFF THE POWER SUPPLY TO PREVENT FROM UNEXPECTED INJURY. BE SURE TO CONFIRM THE STOP OF ROTATION OF THE MOTOR BEFORE OPERATIONS.



Feed dog ① is factory-adjusted to jut out 1.0mm from the surface of throatplate ②. When the feed dog height needs to be adjusted according to the sewing specifications or after the feed dog is replaced, do as follows:
① Loosen the screw ③.
② Move the feed bar ④ up or down to perform adjustment, then securely tighten the screw.

15. FORWARD/REVERSE SEAM RATIO

⚠ CAUTION TURN THE SWITCH OFF THE POWER SUPPLY TO PREVENT FROM UNEXPECTED INJURY. BE SURE TO CONFIRM THE STOP OF ROTATION OF THE MOTOR BEFORE OPERATIONS.



- ① Loosen four screws ①.
- ② When increasing the forward stitch length, turn the eccentric pin ② clockwise (toward A) using a screwdriver.
- ③ When decreasing the forward stitch length, turn the eccentric pin ② counterclockwise (toward B) using a screwdriver.
- ④ Then securely tighten the screws.

17. TROUBLE AND CORRECTIVE MEASURES

| Trouble | Causes | Corrective measures |
|---|---|--|
| <p>1. Thread breakage (Thread frays or wears out.)</p> <p>Needle thread remains 2 to 3 cm on the wrong side of the cloth)</p> | <p>① The thread path, needle point, hook point or bobbin case positioning finger has scratches.</p> <p>② The needle thread tension is too high</p> <p>③ The bobbin case opening lever clearance is too large.</p> <p>④ The needle hits the hook point.</p> <p>⑤ The needle thread tension is too low</p> <p>⑥ The thread take-up spring has an excessively high tension while it has an excessively small stroke.</p> <p>⑦ The timing between the needle and hook is too early or late.</p> | <p>○ Remove the scratches on the hook point using a fine sand paper. Buff the bobbin case positioning finger.</p> <p>○ Properly adjust the needle thread tension</p> <p>○ See '11. HOW TO ADJUST THE BOBBIN CASE OPENING LEVER'.</p> <p>○ See '12 NEEDLE-TO-HOOK RELATIONSHIP'.</p> <p>○ Properly adjust the needle thread tension</p> <p>○ Decrease the tension, and increase the stroke</p> <p>○ See '12 NEEDLE-TO-HOOK RELATIONSHIP'.</p> |
| 2. Stitch skipping | <p>① The clearance between the needle and the hook point is too large.</p> <p>② The timing between the needle and hook is too early or late.</p> <p>③ The presser foot pressure is too low</p> <p>④ The clearance between the top edge of the needle eyelet and the hook point is not correct.</p> <p>⑤ The bobbin case opening lever clearance is too large.</p> <p>⑥ The size of the needle is wrong</p> | <p>○ See '12 NEEDLE-TO-HOOK RELATIONSHIP'.</p> <p>○ See '12 NEEDLE-TO-HOOK RELATIONSHIP'.</p> <p>○ Increase the presser foot pressure.</p> <p>○ See '12 NEEDLE-TO-HOOK RELATIONSHIP'.</p> <p>○ See '11. HOW TO ADJUST THE BOBBIN CASE OPENING LEVER'.</p> <p>○ Replace the needle by one which one grade thicker.</p> |
| 3. Loose stitches | <p>① The thread has not been passed through the notch of the bobbin case tension spring</p> <p>② The thread path is poorly finished.</p> <p>③ The bobbin does not rotate smoothly.</p> <p>④ The bobbin case opening lever clearance is too large.</p> <p>⑤ The bobbin thread tension is too low</p> <p>⑥ The bobbin thread has been wound too tight.</p> | <p>○ Properly thread the bobbin case</p> <p>○ Grind it using a fine sand paper of a buff.</p> <p>○ Replace the bobbin or hook</p> <p>○ See '11. HOW TO ADJUST THE BOBBIN CASE OPENING LEVER'.</p> <p>○ Properly adjust the tension</p> <p>○ Decrease the bobbin thread winding tension</p> |

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* Appear and specification listed in this instruction manual are subjected to change without notice.

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