



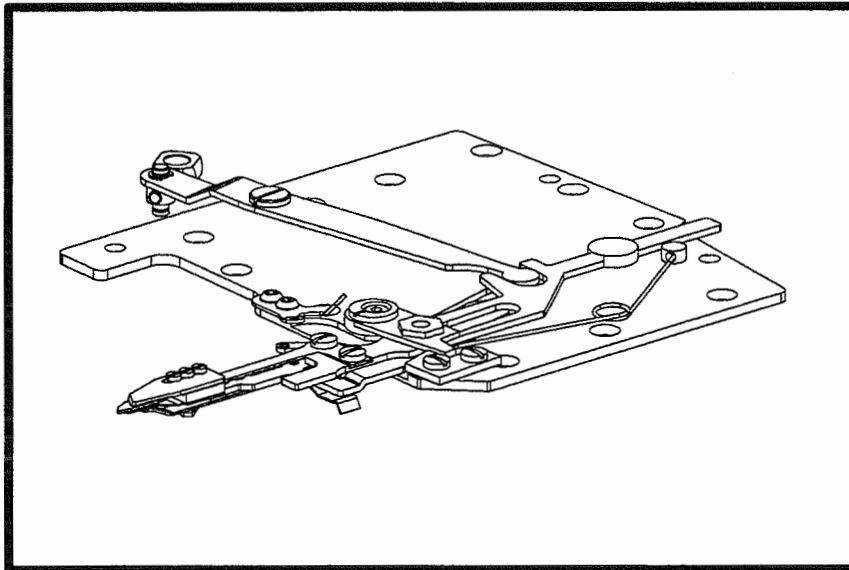
Union Special
INDUSTRIAL SEWING EQUIPMENT

**MANUAL NO.
EN9603**

UNDER BED THREAD TRIMMER ASSEMBLY 29480AWB

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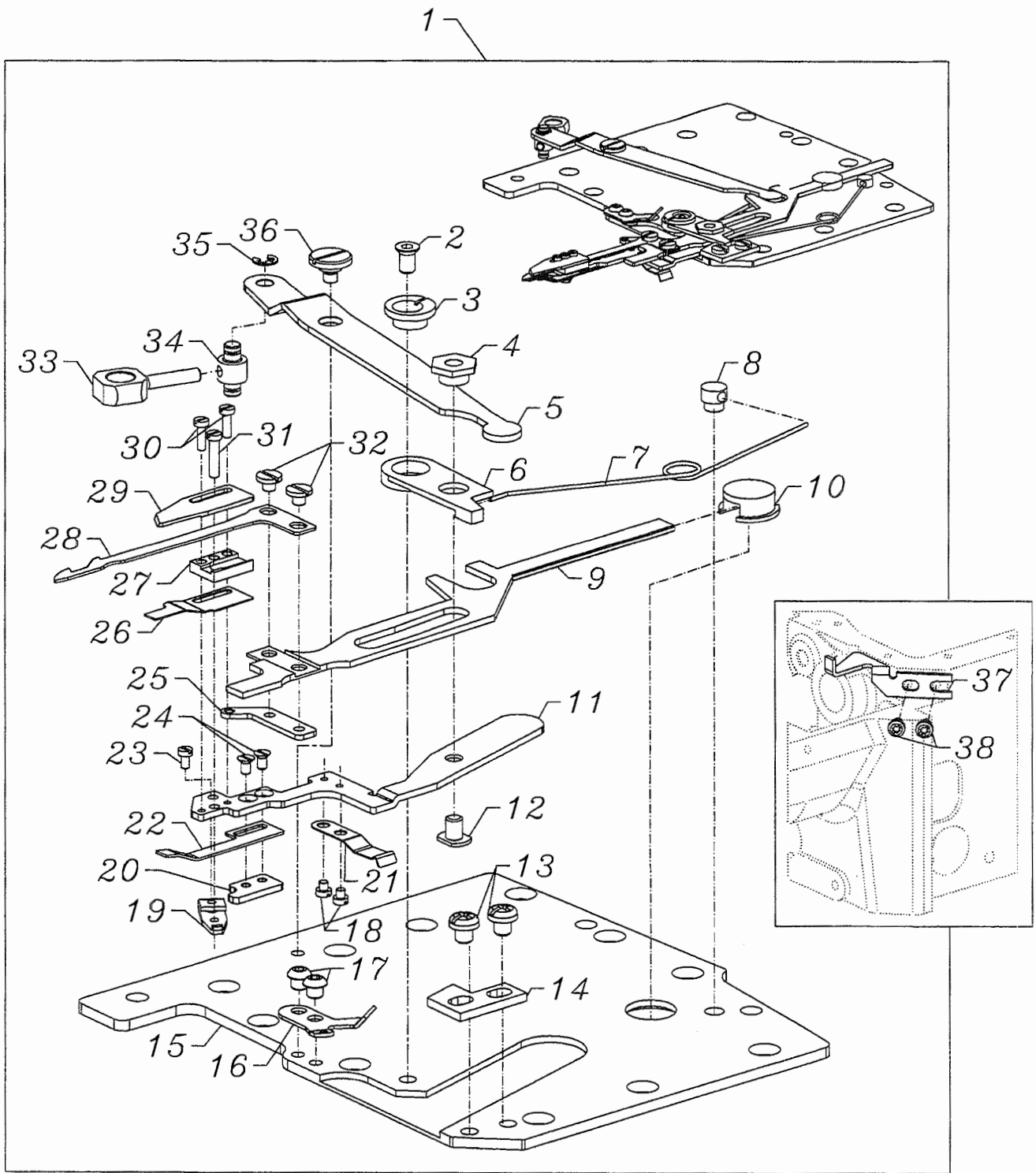
PREFACE

This Engineer's Manual has been designed to assist you in adjusting under bed thread trimmer assembly 2980AWB.

It is the desire of Union Special that each machine run at its optimum performance. Adjustments listed in this manual are designed specifically for your machine and are written with utmost precision to assure long lasting service.

This manual has been comprised on the basis of available information. Changes in design and/or improvements may incorporate a slight modification of configuration in illustrations or adjustments.



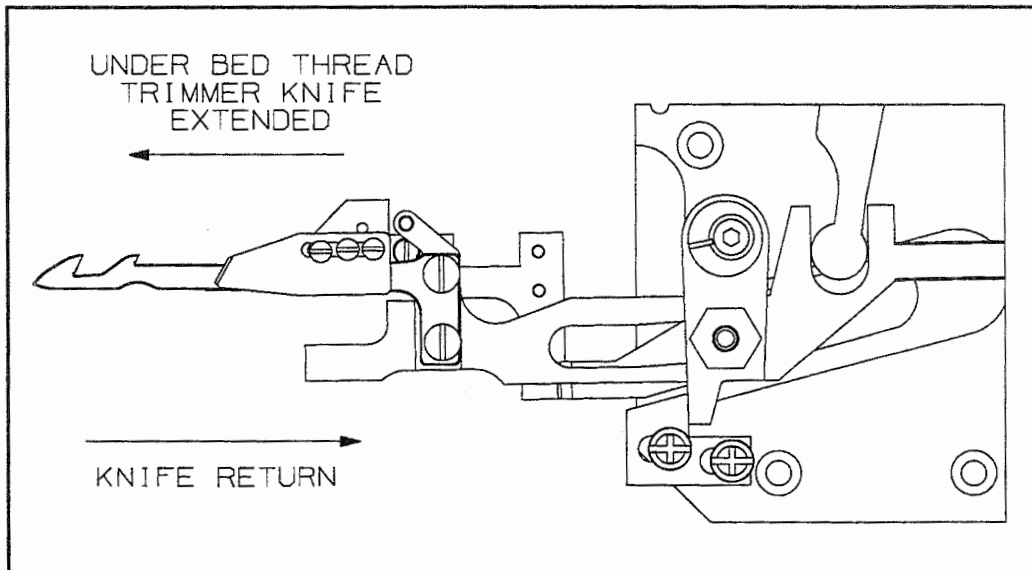


STANDARD ADJUSTMENTS

UNDER BED THREAD TRIMMER

ELECTROPNEUMATIC DRIVE

Adjust the metering screws so that thread trimmer mechanism and knife move smoothly left to right and the threads are cleanly cut and clamped.



STANDARD ADJUSTMENTS

UNDER BED THREAD TRIMMER ASSEMBLY

With the needles at top dead center:

Lower knife (G) should extend past the end of looper (Q) by:

$15/32''$ (12.0mm).

The tip of lower knife (G) should be centered front to back, to the rear edge of the flat on top of looper (Q).

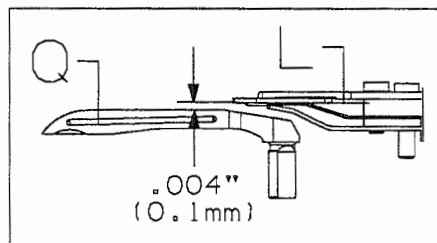
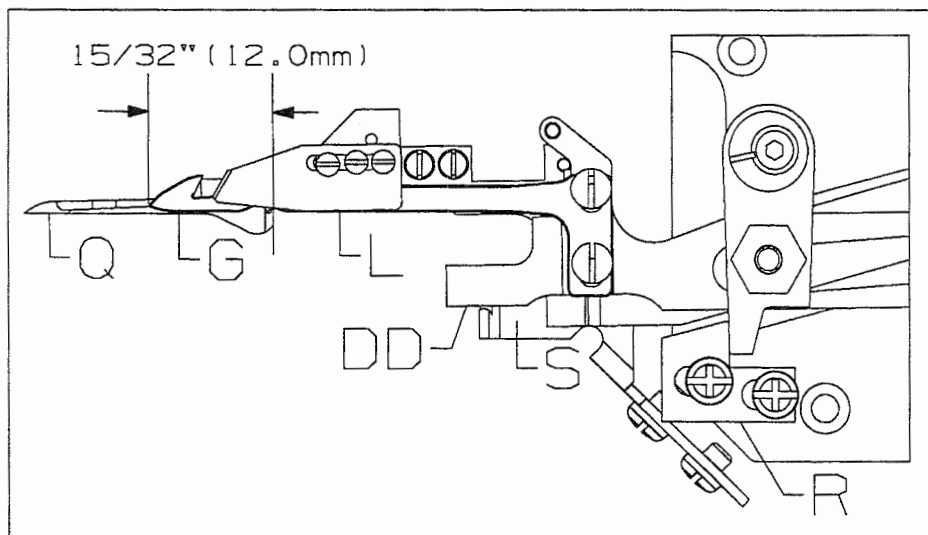
Stop (R) sets the distance of the upper knife and springs to the looper, it should be centered in its slots.

Guide (S) should just contact edge (DD) of knife mechanism.

On cover stitch machines knife (G) should be set slightly rearward $.005''$ (.10mm) of the standard adjustment.

The bottom of upper knife (L) should clear looper (Q) by:

$.004''$ (0.1mm).



STANDARD ADJUSTMENTS

UNDER BED THREAD TRIMMER ASSEMBLY

Upper knife (L) should overlap lower knife (G) by:

.020" (0.5mm).

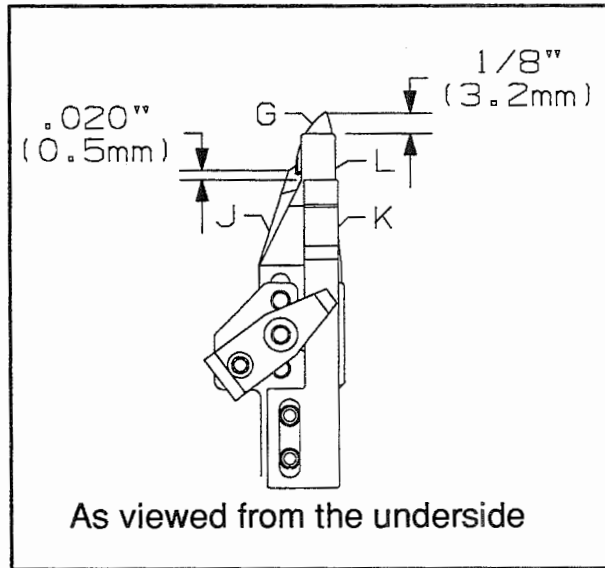
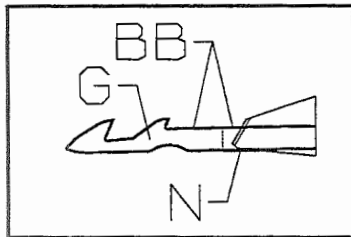
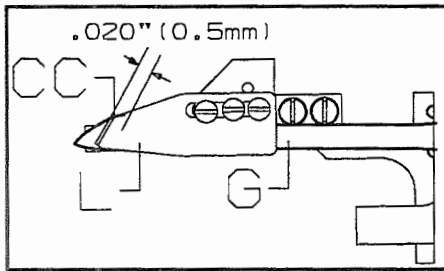
The distance from clamping leaf spring (N) to the tip of lower knife (G) should be:

1/8" (3mm). Clamping leaf spring (N) should be flush with knife at edge (BB).

NOTE: The clamping leaf spring must be set to only clamp the looper thread, NOT the needle threads.

The distance from tension leaf spring (M) to the back of upper knife (L, @ point CC) should be:

.020" (0.5mm).

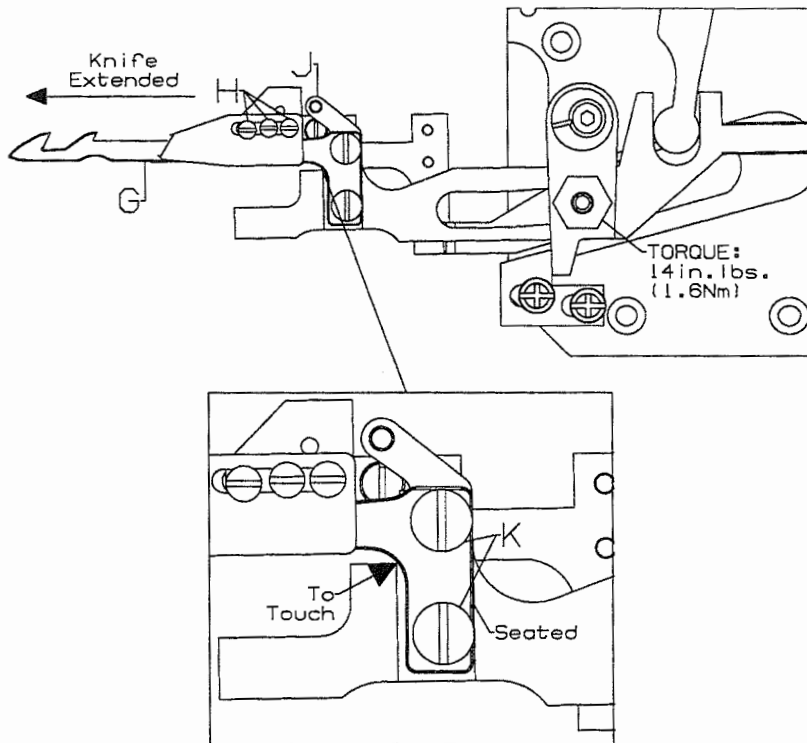


STANDARD ADJUSTMENTS

UNDER BED THREAD TRIMMER ASSEMBLY KNIFE ADJUSTMENT

When positioning lower knife (G), eyelet (J) must be seated to the right.

Lower knife (G) must be seated to the right and all the way forward when tightened.

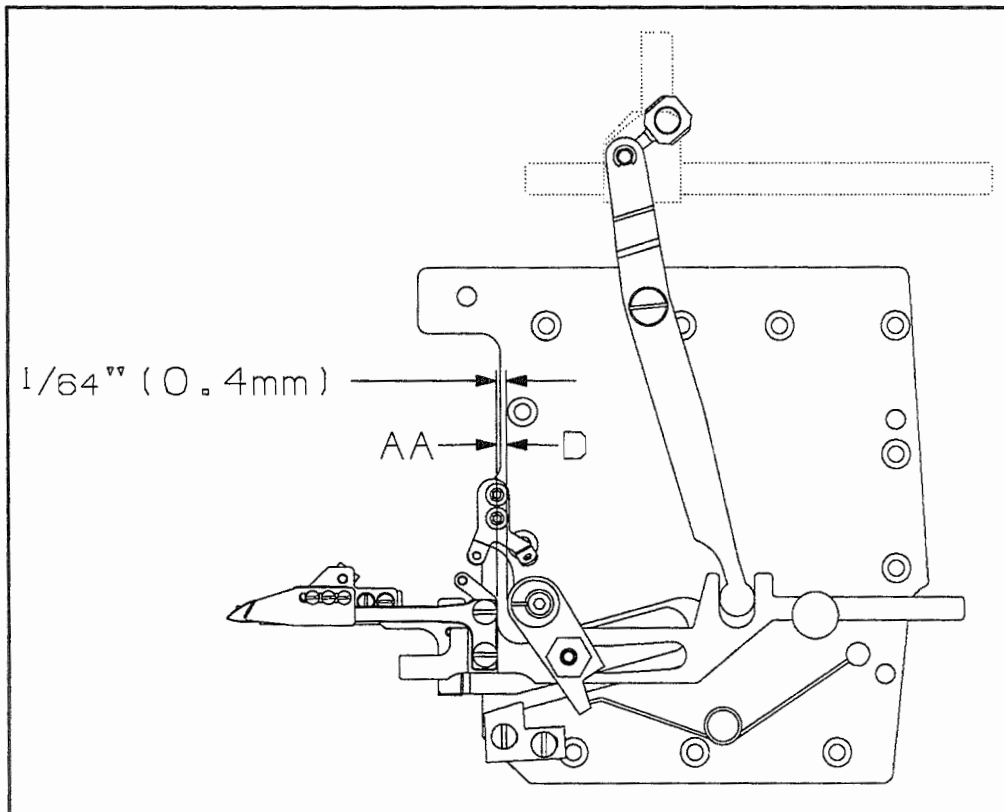


STANDARD ADJUSTMENTS

UNDER BED THREAD TRIMMER ASSEMBLY

When the thread trimmer is in its home position, the distance between edge (AA) and the protruding edge of lever (D) should be:

$1/64''$ (0.4mm).



STANDARD ADJUSTMENTS

UNDER BED THREAD TRIMMER

Set stroke of the driving solenoid to:

$45/64$ " (18mm). All gauges.

