

SERVICE MANUAL

FOR

MODEL SR-150 ^{SR} ₁₅₅

CHUNKY RIBBER

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GENERAL SPECIFICATIONS OF THE SR-150 CHUNKY RIBBER

1. Needle Pitch 9 mm
2. Number of needle 110
3. Racking 6 needle pitch
4. Needle Bed Dropping.. 2-stage drops
5. Suitable Yarns..... Normal thick to extra thick yarns

1. Adjustments for the needle bed

1-1 Backward-forward positioning adjustment

Before adjusting the position of the needle bed against the knitter needle bed, check the backward-forward position of the ribber needle bed for the correct measurement as described below.

1) Checking Method

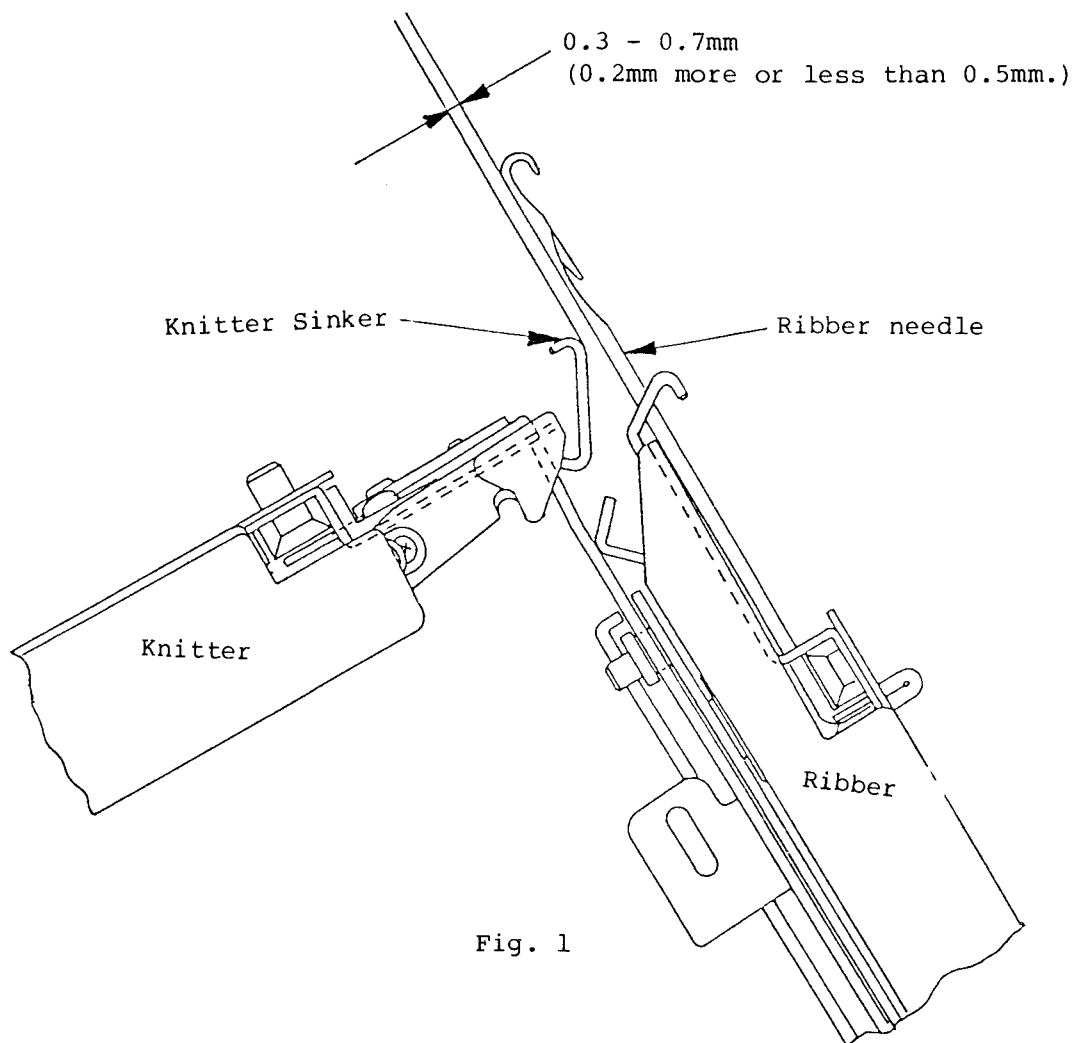
a) Set the Swing Indicator at 3 on the P scale using the Swing Handle.

b) Push up the needles (three needles) between 50 and 53 into D position. Measure using a feeler gauge the clearance between the Ribber needle and the Knitter sinker posts.

The measurement should be within 0.3 - 0.7mm.

(If feeler gauge is not available around, use the stitch scale for the Knit Contour as its thickness is 0.5mm.)

c) If the measurement between the ribber needle and the knitter sinkers is out of the standard measurement, adjust the position of the ribber needle bed referring to adjusting method given on the next page.



2) Adjusting Method

- a) Remove the Knitter Clamp securing the push-up cam, and lay down the push-up cams.
- b) Loosen the binding head screw (3x4) securing the backward-forward locational plate.
- c) Move the Ribber needle bed forward or backward to have the clearance between the ribber needles and the knitter sinkers to the standard measurement.
- d) When the ribber needle bed is adjusted to the correct position against the knitter, fasten the screw and then secure the push-up cams with the knitter clamps. Raise the Push-up cams.

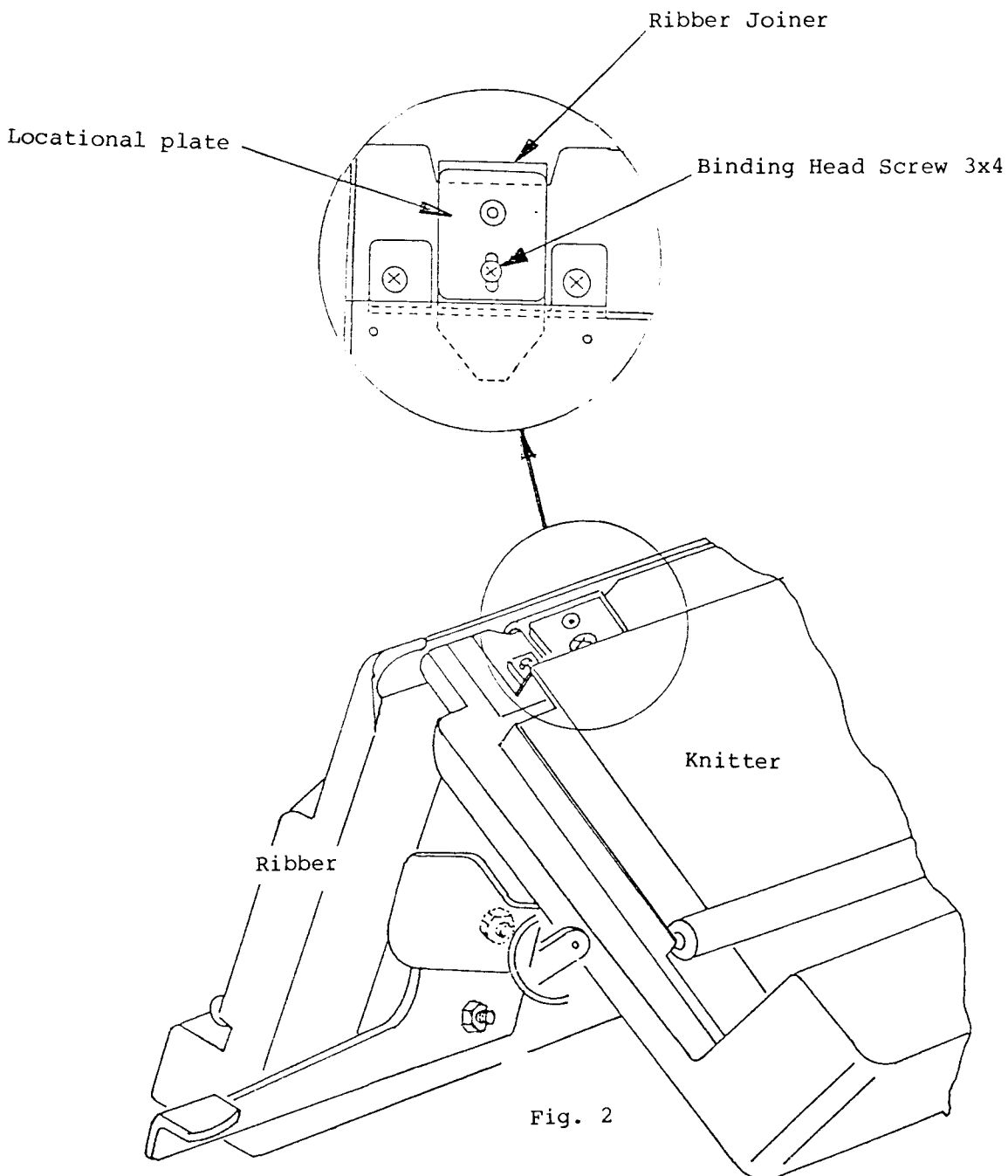


Fig. 2

1-2 Up-Down positioning adjustment

Before adjusting, check the up-down position of the ribber needle bed for the standard measurement as described below.

Check the measurement with the push-up cams in upright position.

1) Checking method

a) Set the Swing Indicator at 3 on the P scale using the Swing Handle.

b) Push up three needles on the knitter between 50 and 53 into D position. Check the clearance between the knitter needle and the ribber sinker for the correct measurement of 0.3 - 0.7 mm using a feeler gauge.

(If the feeler gauge is not available around, use the stitch scale as its thickness is 0.5mm.)

c) If the clearance is out of the correct measurement, adjust it referring to the adjusting method given on the next page.

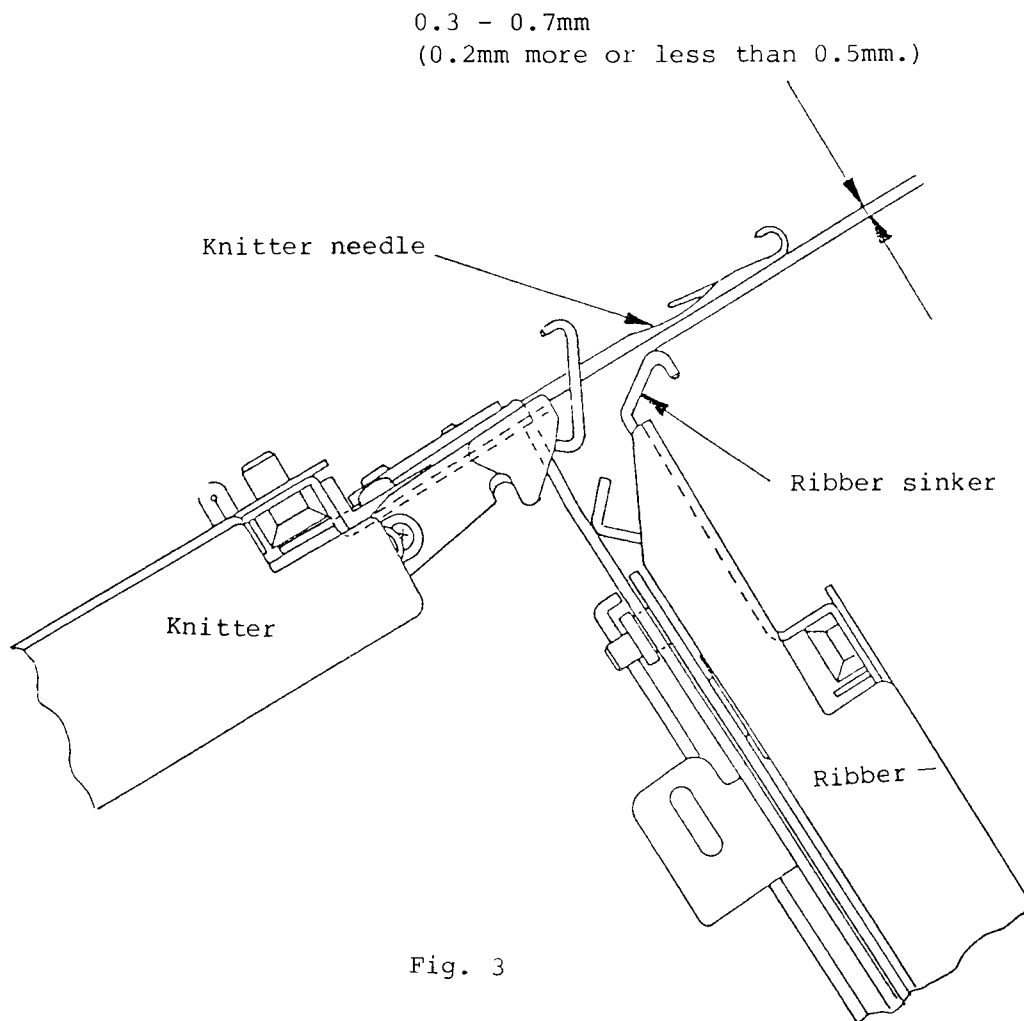


Fig. 3

2) Adjusting method

a) At the back of the ribber needle bed, loosen the hexagonal nut securing the ribber joiners using a 7mm spanner.

b) Swing the up-down adjusting lever to have the ribber needle bed to the correct position against the knitter needle bed.

* If the ribber needle bed needs to be moved up, swing the Lever upward.

* If the ribber needle bed needs to be moved down, swing the Lever downward.

c) When the adjustment has been finished, fasten the hexagonal nut.

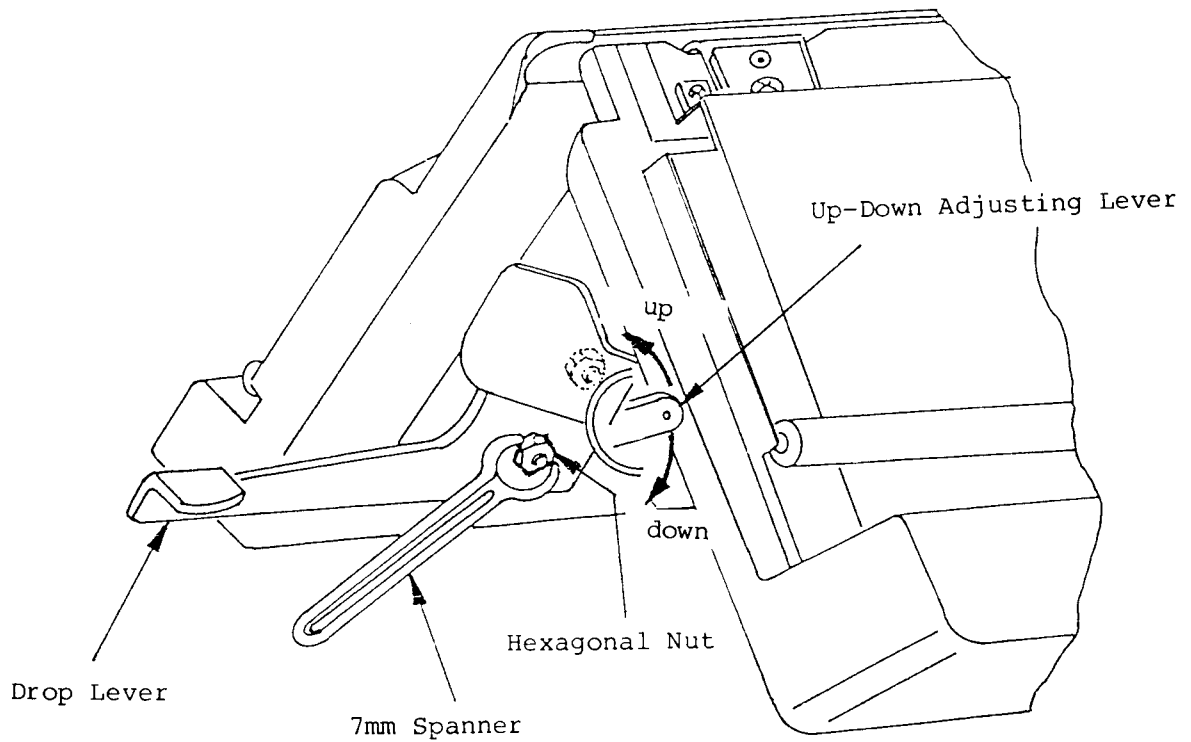
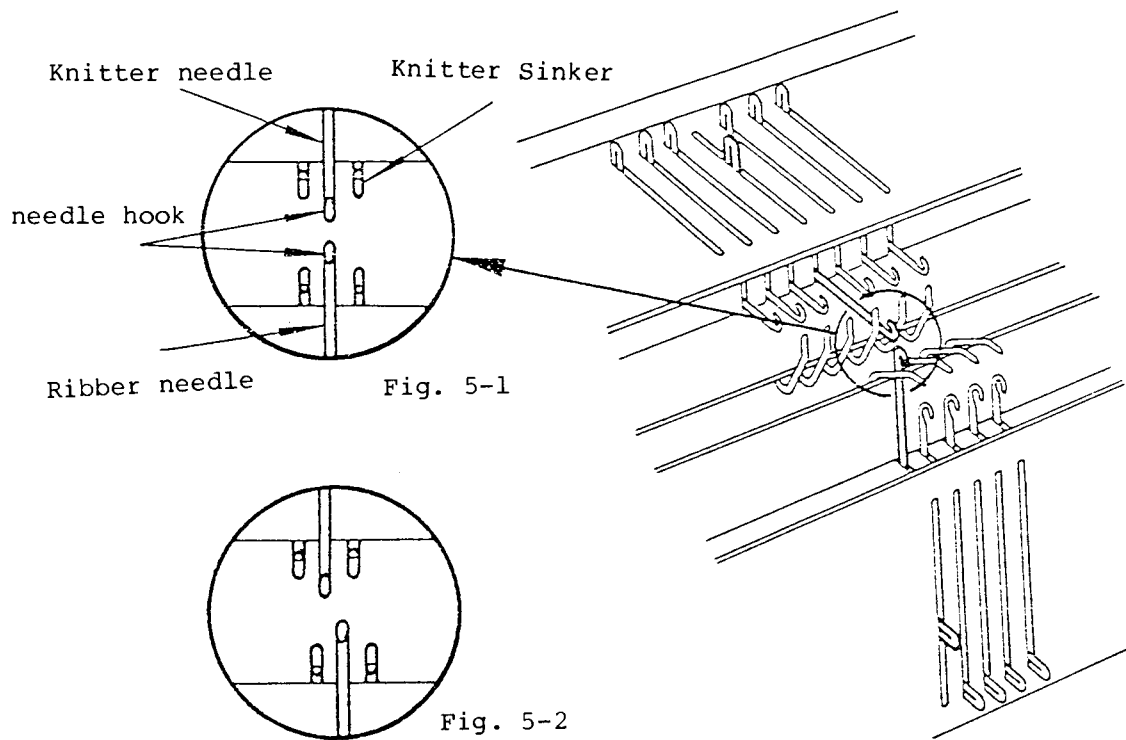


Fig. 4

1-3 Needle Alignment

When the Ribber is attached onto the Knitter and the Swing Indicator is set at a number on the P scale, the needles on the ribber must be in a face to face position with the knitter needles.

Check by pushing 6 needles at the centre of both needle beds to see if their hooks are confronting with each other.



1. Adjusting Method

- a) If the ribber needles are displaced of the correct position, loosen two screws (3x8) securing the Half Pitch Adjusting Plate, and pat either end of the ribber needle bed by hand to have the ribber bed to the correct position.

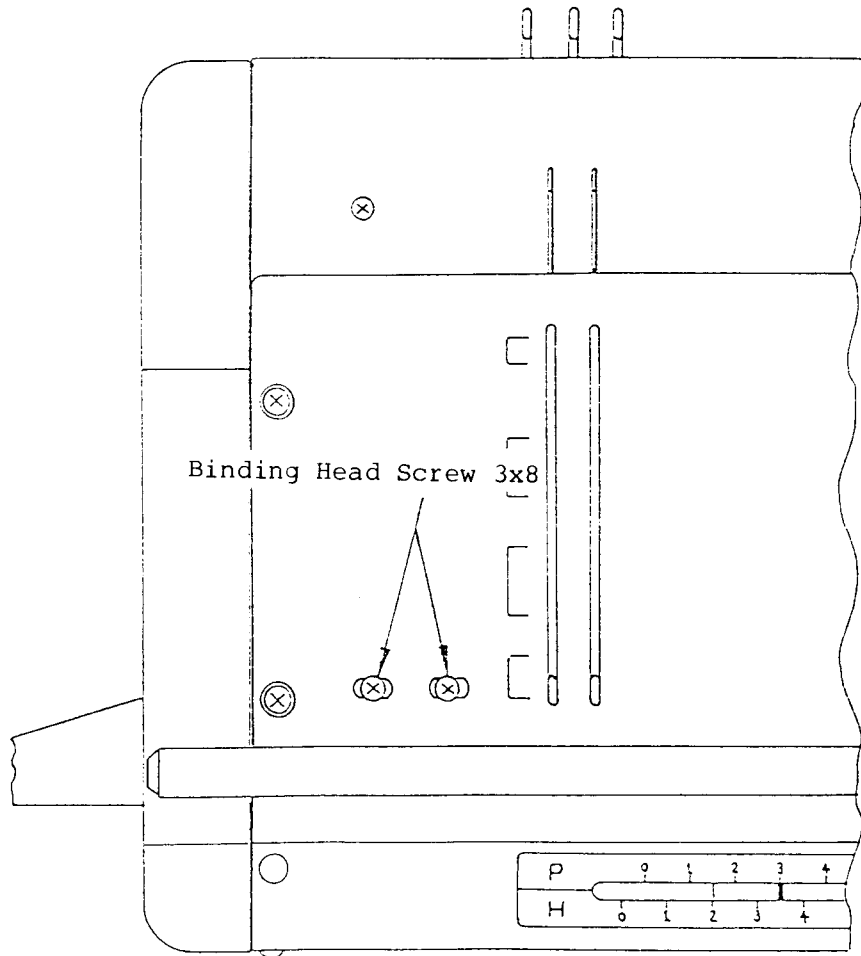
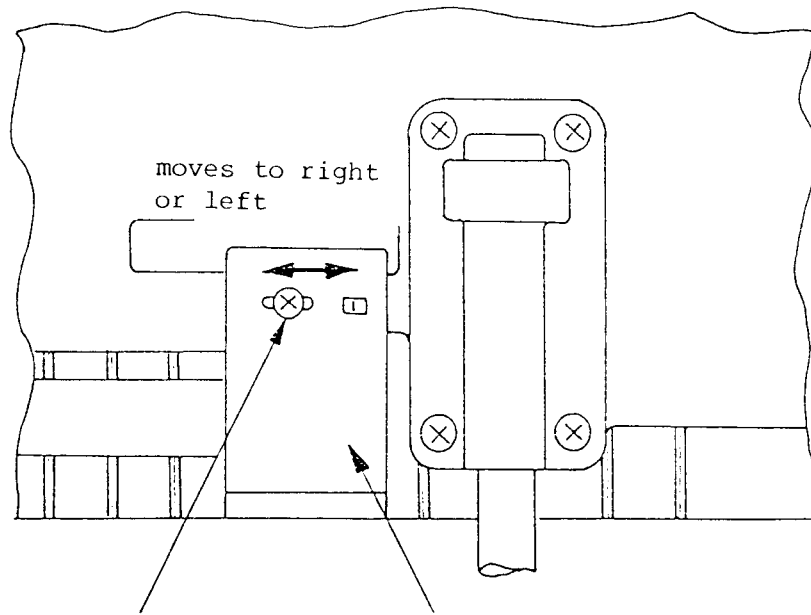


Fig. 6

Note: When the needle alignment is adjusted, the Swing Indicator must also be adjusted to the correct position.

1-4 Adjustment for Swing Indicator

- a) Set the Swing Indicator at 3 on the P scale.
- b) If the Indicator is displaced of the correct position, loosen the screw (3x6) securing the Indicator at the back of the needle bed, and move the Indicator to the right or the left till it correctly comes at P-3.



Binding Head Screw 3x6 Swing Indicator

Fig. 7

1-5 Sinkers Alignment (Measurement between the Sinkers and the Rail)

The measurement is 150.0 ± 0.25 mm

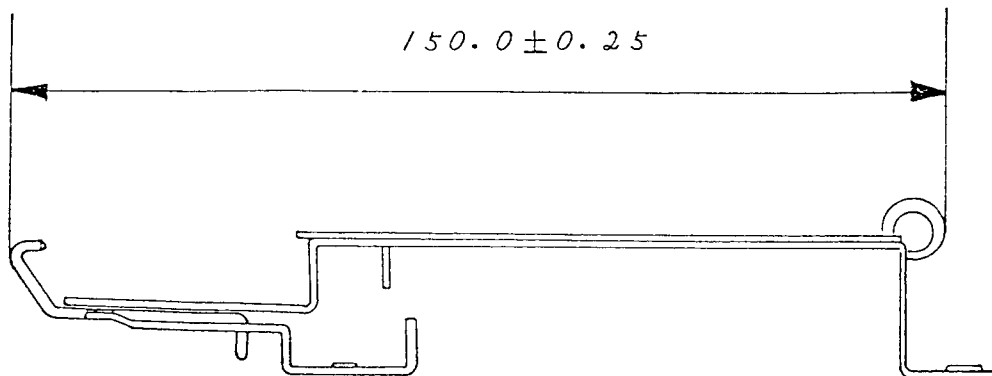


Fig. 8

2. Relation between the Yarn Feeder and the Needles

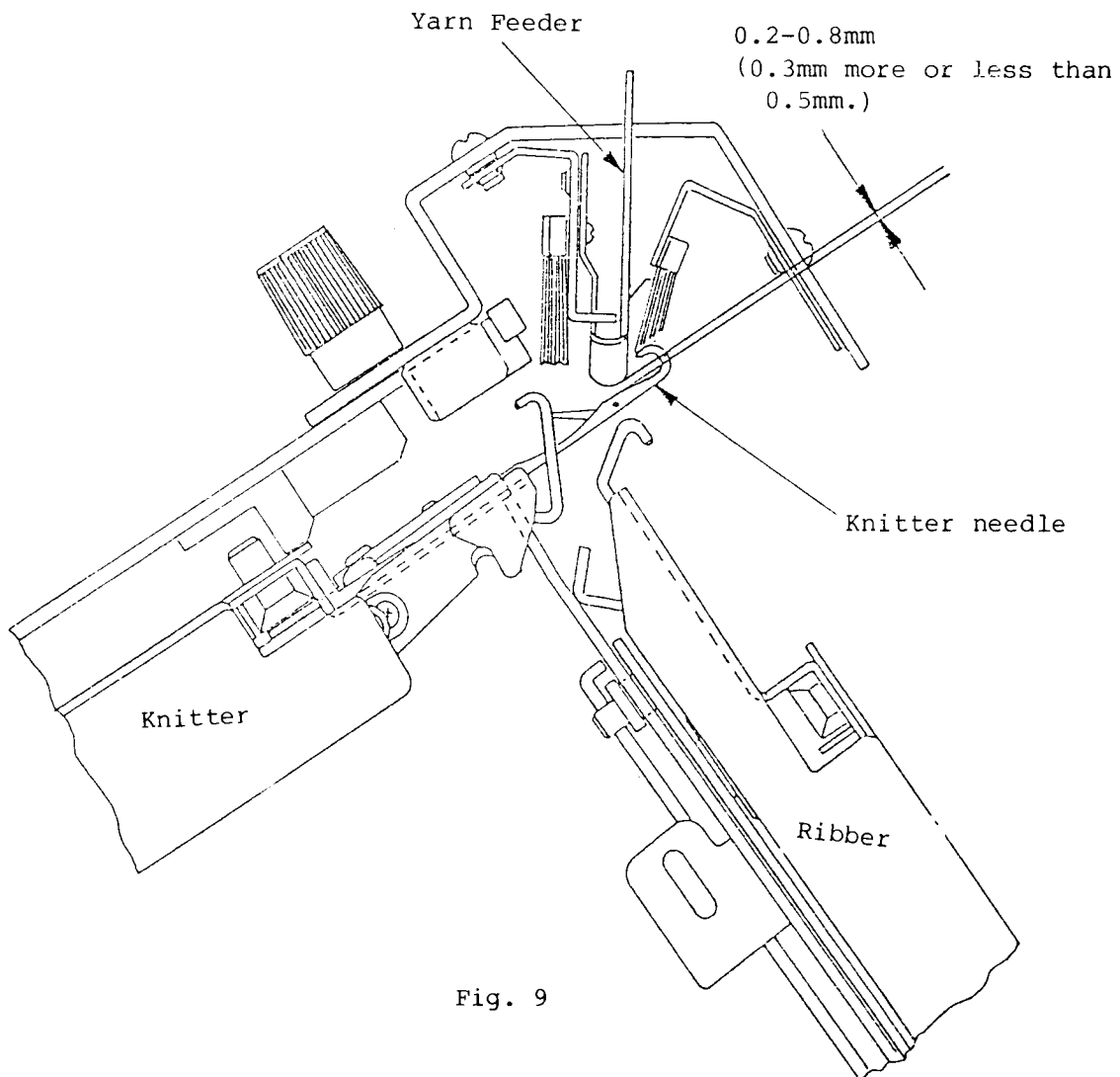
2-1 Up-Down positioning for the Yarn Feeder

Before adjusting the Yarn Feeder, check it for the correct position as described below in the following manner.

1) Checking Method

- a) Push up 3 needles between 50 - 53 at the left end of the knitter into D position.
- b) Set the Russel Lever at "0".
- c) Bring the Carriage to those needles in D position so that the Yarn Feeder comes at the centre needle.
- d) From the left side of the Arm, check the clearance between the bottom of the Yarn Feeder and the needle.

The clearance should be within the range of 0.2-0.8mm in visual check.



2. Adjusting Method

- a) Mark the contour of the screws (3x6) fixing the Yarn Feeder as in fig. 10.
- b) When those two screws are removed, the Yarn Feeder comes off, but care should be taken to avoid losing plain washers on the Yarn Feeder.

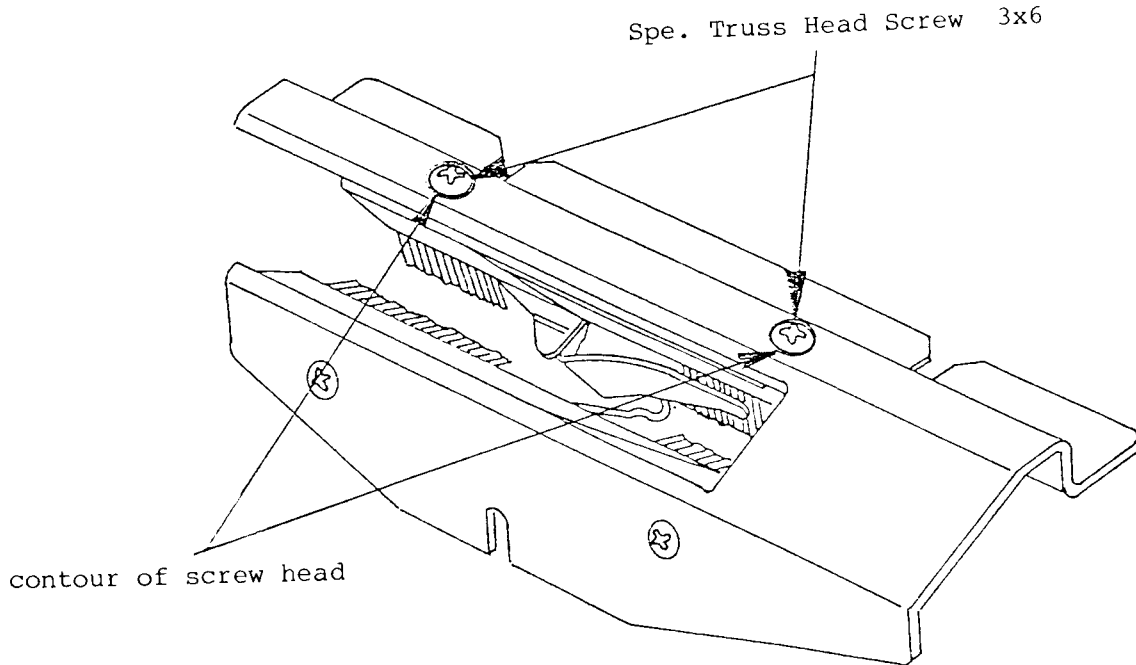


Fig. 10

- c) By adding or removing the plain washer between the Arm and the Yarn Feeder, adjust the up-down position of the Yarn Feeder to the standard measurement from the stem of the needle in D position.

The plain washer is available in the following different thicknesses.

4x8x0.2	4x8x0.8	4x8x1.2
4x8x0.6	4x8x1.0	

2-2 Forward-Backward adjustment for the Yarn Feeder

Before adjusting the Yarn Feeder, check it for the correct position as illustrated below, in the following manner.

1) Checking Method

- a) Set the Ribber Carriage and the Ribber Arm on the Knitter Carriage.
- b) Set the Cam Lever and the Set Lever on the Ribber Carriage at \cap and "0" respectively.
- c) Push 3 needles between left 50-53 on the Ribber needle bed into D position.
- d) Bring the knitter carriage to those needles in D position so that the Yarn Feeder comes to the centre needle of those 3 needles.
- e) Referring to the Fig. 11, check visually the position of the Yarn Feeder from the side of the Arm.

The bottom of the Yarn Feeder must be positioned at $-0.3 - 0.3\text{mm}$ in a linear relation with the top of the needle hook as illustrated.

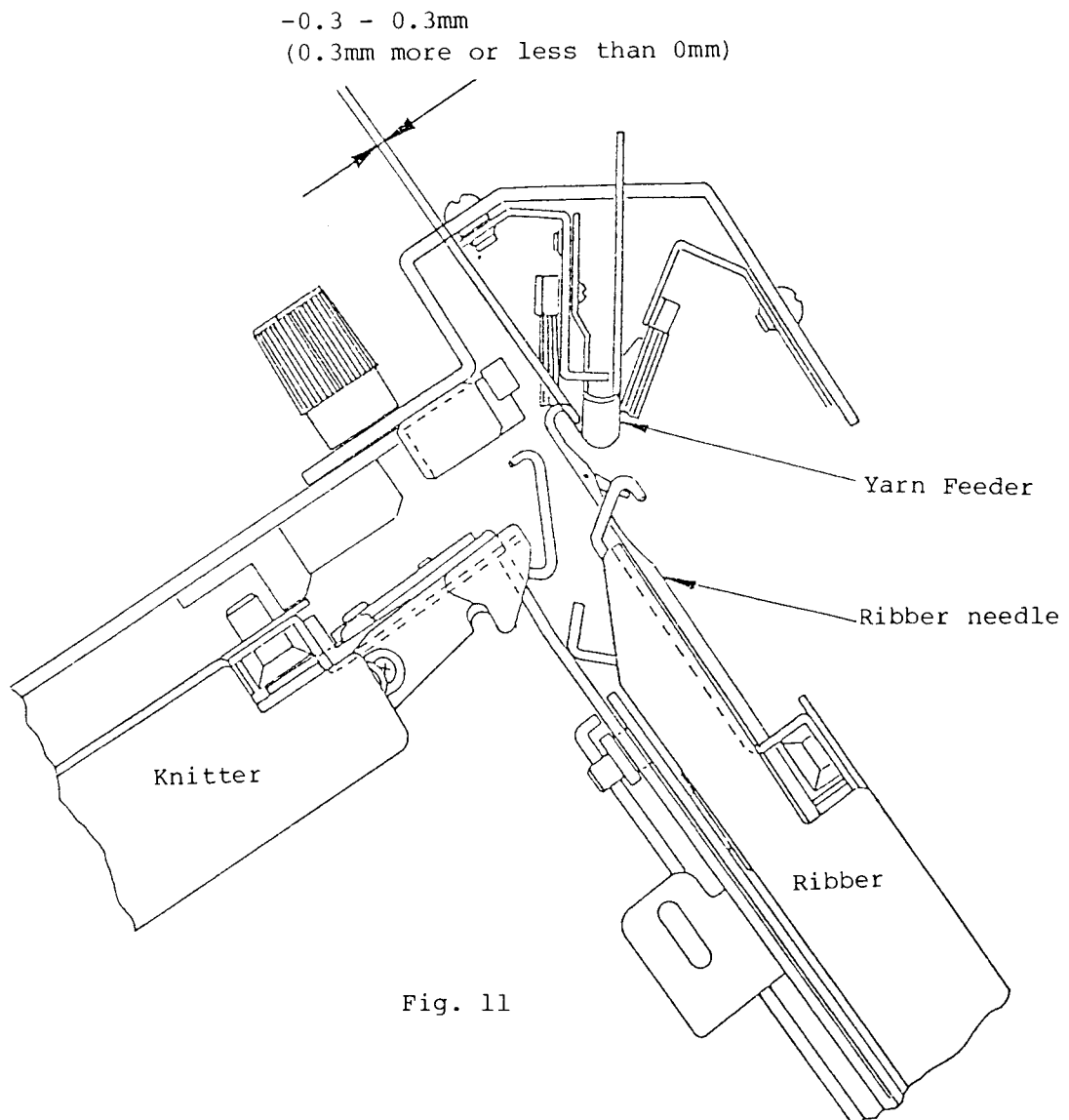


Fig. 11

2. Adjusting Method

- a) Of two screws (3x6) securing the Yarn Feeder, loosen either screw by 1/4 or 1/2 turn, and move the Yarn Feeder forward or backward.

Then loosen the second screw in the same manner as for the first screw and move it backward or forward to have those two screws in a parallel position

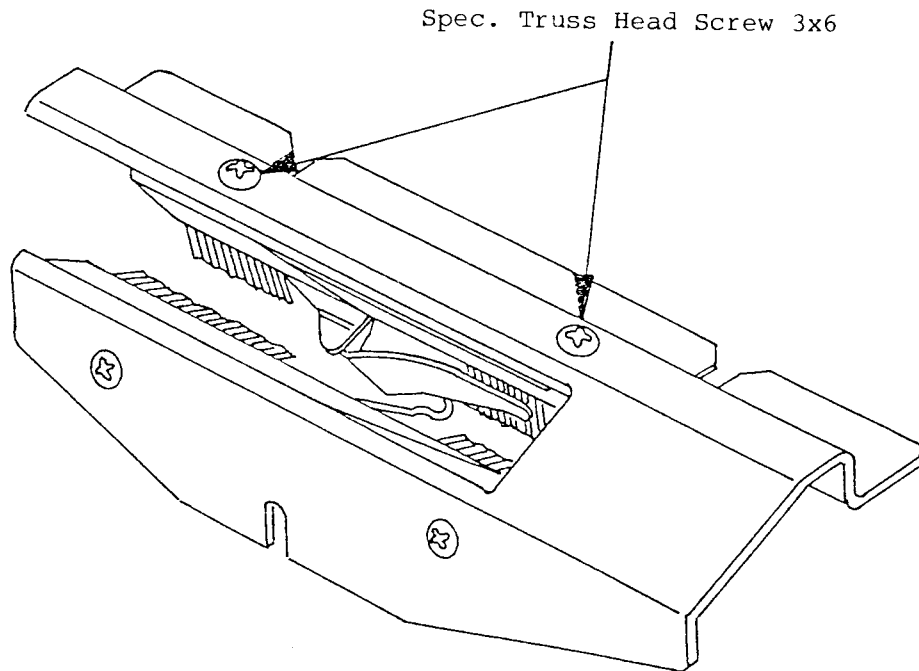


Fig. 12

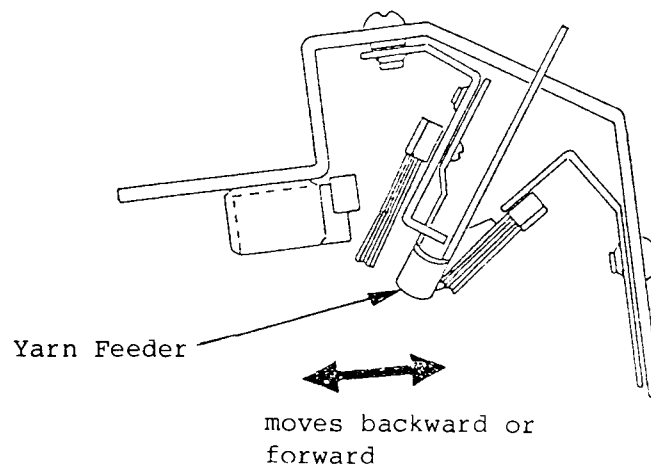


Fig. 13

* Checking after adjustment

Bring the Yarn Feeder at the needle in D position, and hold the butt of the needle to push it down to A position to feel if the hook of the needle is touching the bottom of the Yarn Feeder.

3. Standard Measurement for the Main Cams

Check the distance of the bottom edge of the main cams from the Carriage pipe in the following manner.

Set the Stitch Dial at 10, eliminate the play of the main cams by pushing the cams toward the Carriage Slider, and then measure the distance of the bottom of the Main Cams from the Carriage Pipe using a vernier caliper.

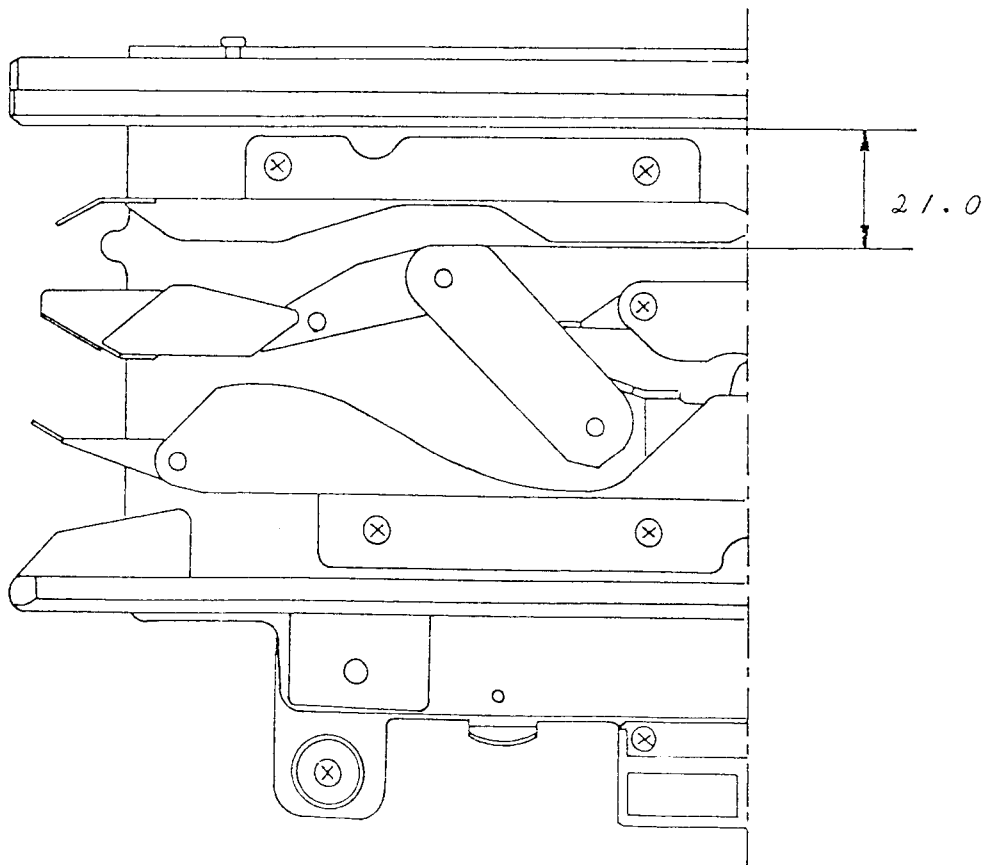


Fig. 14

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