Model

751R, 752R, 754R, 756R

Long arm, cylinder bed, single needle, lockstitch machines
For ultra heavy materials with oscillating large hook
and reverse
Specifications of

Sewing speed: Max. 1,200 s.p.m. (Max. sewing speed will be changed by the models and applications)

Needle type: DD x 1 # 22-25, Standard #24

Number of needle: Single needle

Sewing type: Lockstitch

Hook: Oscillating large hook

Bobbin: Type (24Φ x 30.3 width)

Thread: Cotton or synthetic fiber

Feed system: (756R Needle, upper & lower feed, reverse feed
(754R Needle, lower feed, reverse feed
(751R Lower feed, reverse feed
(752R Upper & lower feed, reverse feed
Upper & lower feed, reverse feed
(Capable of intermediate shirring)

Stitch length: Max. 10mm

Presser foot: (756R Alternating foot (walking foot & presser foot)
(754R Flat bed
(751R Roller foot or flat bed
(752R Alternating foot (walking foot & presser foot)

Presser lift: 20mm by knee lifter (10mm by lever)

Thread take-up: Cam type

Thread take-up stroke: 90.5mm

Needle bar stroke: 51mm

Bed shape: Cylinder bed (tubular type 82Φ)

Bed size: 82Φ x 600mm

Working space: 200mm x 400mm

Net weight (head only): 65Kg

JIS classifications: LS 3

Motor: 400W, 4P clutch motor

Motor pulley: 60Φ (50HZ) 50Φ (60HZ)

V Belt: M62

Applications: Suitable for sewing of shoes, bags, satchels, sport-goods, luggages, ultra heavy materials.
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1 Lubrication

Lubricate all points indicated by arrows in figure.

2 Needle

Turn the balance wheel over toward you until the needle bar reaches its highest point. Loosen the needle clamp screw (1). Hold and insert the needle (2) into the needle bar hole up as deeply as it will go, keeping the long groove of the needle to the left and eye of the needle in line with machine arm directly. Securely tighten it with needle clamp screw (1).
Thread

For needle (Upper thread) use left-twisted thread only, and for bobbin (Lower thread) use either left or right twisted thread.
To find out thread twist, hold the thread as shown by illustration, and turn the thread over toward you between the thumb and forefinger of right hand, and then left-twisted thread will wind tighter strands, and right-twisted thread will unwind.

Insertion and Removal of Bobbin

§ Removal of Bobbin

Open the hook cover and drop-down the needle bar at lowest point, then insert the opener(3) between the snap spring(1) and bobbin case(2) and depress the snap spring and pull up the bobbin case outward, then take the bobbin out of the bobbin case.
§ Insertion of Bobbin

When inserting, pull out the thread and depress it, then insert the bobbin(4) in the bobbin case(5). Pull the thread upward passing through the thread slit(7) of the bobbin case. You can pull out the thread through the thread passing hole through underneath the tension spring(6). Make sure that the snap spring in the shuttle is clicked after pressing bobbin case into the shuttle.

5 Winding the Bobbin Thread

Bobbin winding should be made by the following order.

(1) Spool pin — (2) Thread guide (arm) — (3) Needle thread tension thread guide — passing through the clearance between two tension discs — (4) Needle thread tension thread guide — (5) Bobbin (winding several times) — (6) Move the bobbin winding lever.

Winding volume should be adjusted by the screw(7) and positioning of the moving the lever(6).
Upper Threading

Upper threading should be made by the following order.

(1) Spool pin — (2) Thread guide of thread tension — (3) Clearance of two tension discs — (4) Thread guide of thread tension
(5) Thread controller disc — wind a time — (6) Thread guide —
(7) Tension spring — (8) Thread take-up — (9) Thread guide, face plate
(10) Needle cramp — (11) Needle

Tension of Bobbin Thread and Needle Thread

(A) Balanced tension

(A) When stitch tension is well balanced, the bobbin thread is engaged with the needle thread at the center of given material thickness, as shown by Fig. (A)

(B) Tight needle of loose bobbin thread tension

(B) Fig. (B) shows unbalanced tension, tight needle thread or loose bobbin thread.

(C) Loose needle or tight bobbin thread tension

(C) Fig. (C) shows unbalanced tension, loose needle thread or tight bobbin thread.
§ Adjusting Needle Thread Tension

To adjust tension of needle thread, turn Tension Regulating Thumb.

By turning the knurling nut clockwise \(\rightarrow\), needle thread tension increases.

By turning the knurling nut counter-clockwise \(\leftarrow\), needle thread tension decreases.

§ Adjusting Bobbin Thread Tension

To adjust tension of the bobbin thread, turn Tension Regulating Screw.

By loosen set screw(1) and adjusting tension regulating screw(2). The set screw(1) should exactly be tightened after tension of the bobbin thread was adjusted.

By turning the set screw clockwise \(\rightarrow\), bobbin thread tension increases, and turning the set screw counter-clockwise \(\leftarrow\), bobbin thread tension decreases.
Pressure of Presser Foot

By turning the pressure regulating thumb screw clockwise (\(\rightarrow\)), pressure increases, and turning pressure regulating thumb screw counter-clockwise (\(\leftarrow\)), pressure decreases.
Tension regulating nut should be tightened after pressure was adjusted.
Adjustment should be made to suit for the materials being sewn.

Adjustment of Stitch Length

By pull-up \(\uparrow\) feed regulating lever(1), reverse stitch is performed, and push-down \(\downarrow\) feed regulating lever(1), forward stitch is performed.

By turning knurling nut(2) & (3) clockwise (\(\rightarrow\)), feed length decreases, and turning knurling nut (2) & (3) counter-clockwise (\(\leftarrow\)), feed length increases.
Knurling nut(2) & (3) should be tightened each other after desired stitch length was determined.

(Note)
When upward & downward moving of the feed regulating lever is loosened, feed adjusting screw(4) should be tightened.
Timing of Thread Tension Releasing Mechanism

(a) When moving the lifting lever(1) for knee lifter, upper thread is adjusted to loosen.

(b) Adjustment

Pull-up the presser bar lifter(3), clearance should be made over 1mm between tip of the tension releasing plate and tension disc, and then tighten the screws(2) on the tension releasing plate.
11 Removal of Shuttle Race Body

Tighten the shuttle race back spring screw(1), then loosen and take off the two shuttle race screws(2) and remove the shuttle race body and shuttle hook.

(Note)
In case of the removal of shuttle race body, without tightening of shuttle race back spring screw(1), shuttle race back and shuttle race back spring may run out and/or may difficult to set the shuttle race body. The shuttle race back spring screw(1) is surely loosened, while the materials are being sewn.

12 Adjusting on the Each Points

(A) Adjusting Needle Position Against Needle Hole of the Feed Dog.
Needle should be positioned at the center of needle hole of feed dog and moved together with the feed dog.
(a) Loosen feed (upper) shaft connecting screw(2), upper feed length will differ by the moving (push-in or pull out) of feed (upper) shaft connector(B)(1),
(b) Loosen feed (upper) shaft connector(A)screw(3), and needle set at the center of needle hole of feed dog, then, tighten the screw(3).

(Note) Feed (upper) shaft connector(A)(4) is fixed and the screw(3) is tightened for the prevention of the moving of leftward and rightward.
(B) Adjusting of Feed Dog Height

Taking off the needle in
The height of feed dog is adjusted 1.3mm - 1.5mm
above the surface of the throat plate, at the
lowest point of needle bar by feed dog height
adjustable screw(1).

In
The height of feed dog is adjusted 1.3mm - 1.5mm
above the surface of the throat plate at the
lowest point of needle bar.

Refer to Removal of Shuttle Race Body

(C) Adjusting the Forward and Backward Position of
Needle Bar Frame

Correct position between needle bar frame and
presser bar is determined by the distance
between presser bar and needle bar being 16mm
under the stitch length being "0"mm.

Adjustment of the clearance between presser
bar and needle bar is to be made by the screws(1).
(D) **Timing of Needle and Hook**

Positioning of needle and tip of the hook
When the needle bar has risen 4.5mm - 5.5mm from its lowest position, the tip of the hook should meet the center line of the needle.

Distance between the upper tip of the needle-eye and the tip of the hook shall be 2.5mm - 3mm.

Adjusting the height of needle bar
Loosen the screw of needle bar connecting stud(2) by wrench which inserts to the hole(1) of arm and adjust the needle bar(3) upward and downward.

Adjusting the position of the tip of hook
Loosen the screw(5) of the shaft crank by the spanner which inserts to the hole(4) of the head, then determine the forwardness or backwardness (high speed or low speed) of the tip of hook. Tighten the screw(5) after adjustment.
Clearance between needle and tip of hook: 0.05mm - 0.3mm

In "A" type: Determination of the position of needle bar rock frame.

Loosen the set screw(1) of the needle bar rock frame hinge stud, and the set screw(5) of the needle bar rock frame hinge stud(small) (4) positioned lower part of needle bar rock frame(2), and also the set screw(7) of the needle bar rock frame hinge stud(large)(6).

Then, moving the needle bar rock frame hinge stud(large)(6) to rightward➡️ , and also moving the needle bar rock frame leftward & rightward⬅️ , and turn the balance wheel, determines smooth position of the needle bar and adjust the clearance between needle and tip of the hook.

After determination of the clearance, tighten the set screw(2) of the needle bar rock frame hinge stud, and then put the needle bar rock frame hinge stud(small)(4) to slightly the needle bar rock frame position bracket(8).

And, put the needle bar rock frame hinge stud(large)(6) to the side face of the needle bar rock frame(2), and then turn the balance wheel and tighten the each screws exactly.

If the looseness of the leftward & rightward⬅️➡️ of the needle bar should happen, it will be resulted in the breaking of needle, stitch skipping.
Each timing for up/down strokes of presser foot (

a. Loosen and take off the cover screws(1), timing of walking foot is adjusted walking foot reach to feed dog before needle-eye reaches to feed dog, after downing the lever of presser bar lifter, turning the balance wheel toward you.
Adjustment is made by the two stopper screws of cam(2) (upward & downward).
By up & down the presser cam (upward & downward) ↑↓, walking foot against needle is touching to feed dog speedily and slowly.
As for type, adjusting feed dog and presser foot to set equivalent point on the upper face of the throat plate.

b. For the setting walking foot and presser foot equivalent, the lifting eccentric connection crank pinch screw(3) is to be adjusted.
Adjustment is to be made by the materials being sewn.

c. Up/down strokes of walking foot and presser foot is loosened by the screw(4)
Up↑ the screw(4), the stroke increases.
Down↓ the screw(4), the stroke decreases.
a. Use of the Differential Feed Mechanism

Pull-down the chain(1), upper feed volume increases by maximum 80% against lower feed volume

Pull-down the chain(1), upper feed length increases by maximum 80% against lower feed length.
(e.g., Lower feed:10mm, Upper feed:18mm)

Adjusting Upper Feed Length

Turn the dial(2) clockwise (✓), upper feed length decreases.
Turn the dial(2) counter-clockwise (✗), upper feed length increases.
Fixed position of feed length is adjusted by stopper(3) and stopper nut(4)

b. Adjusting Upper Feed Length Against Lower Feed Length

For adjusting equivalent the upper feed length against lower feed length.
Adjustment is to be made by the stopper screw(3) and stopper nut(4).
Turn the stopper screw(3) clockwise (✓), upper feed length increases.
Turn the stopper screw(3) counter-clockwise (✗), upper feed length decreases.

(Note)
Over turning of stopper screw(3) & stopper nut(4) counter-clockwise will cause the troubles that the top of feed adjusting lever touch with the feed upper shaft connector
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