

ENGLISH

**DDL-8000AS, AB
Long pitch kit
INSTRUCTION MANUAL**

1.General

The long pitch kit is an optional part kit that changes the maximum stitch length to 7 mm (standard: 5 mm).

Target model: DDL-8000ASSH、8000ASSJ、8000ABSH、8000ABSJ

2.List of long pitch kit parts

Part number of the long pitch kit: 40218620 (with four teeth)

· List of parts supplied with the machine

Description	Parts No.	Qty
Feed dog	40216364	1
Throat plate	23645807	1
Stitch dial	40216547	1
Hexagon socket head bolts M5X0.8 L=16	SM6051602TP	1
Plain washers M5	WP0531000SD	3

Part number of the long pitch kit: 40218621 (with three teeth)

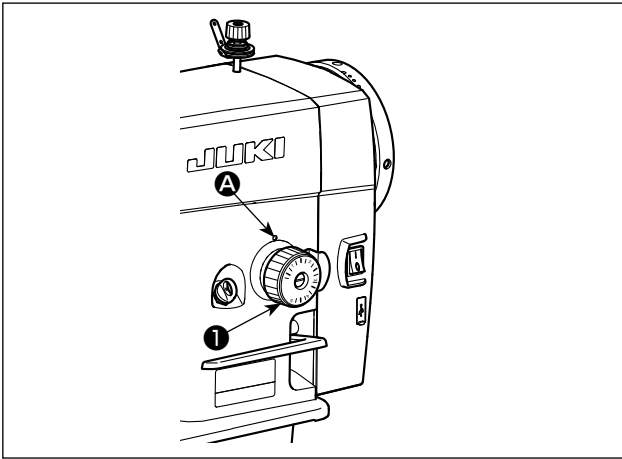
· List of parts supplied with the machine

Description	Parts No.	Qty
Feed dog	40218606	1
Stitch dial	40216547	1
Hexagon socket head bolts M5X0.8 L=16	SM6051602TP	1
Plain washers M5	WP0531000SD	3

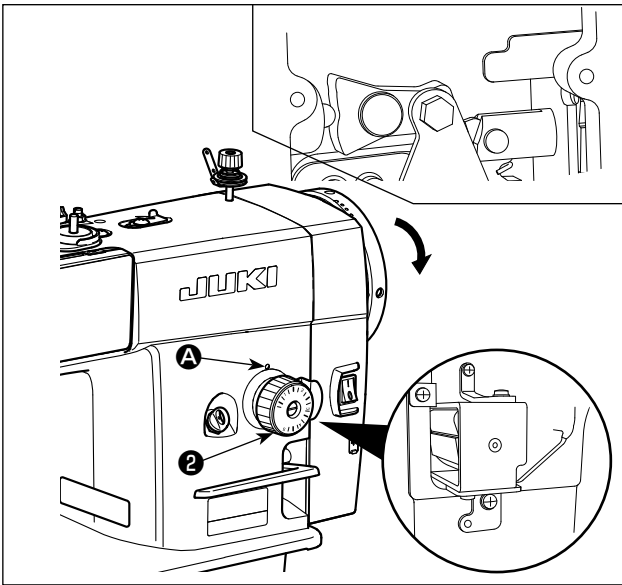
3. Required tools

- * Various kinds of flat-blade screwdrivers
- * Phillips-head screwdriver
- * Hexagonal wrench key
- * Connector pin extracting tool
- * Spacer with plate thickness of 1 mm

4. Installation procedure

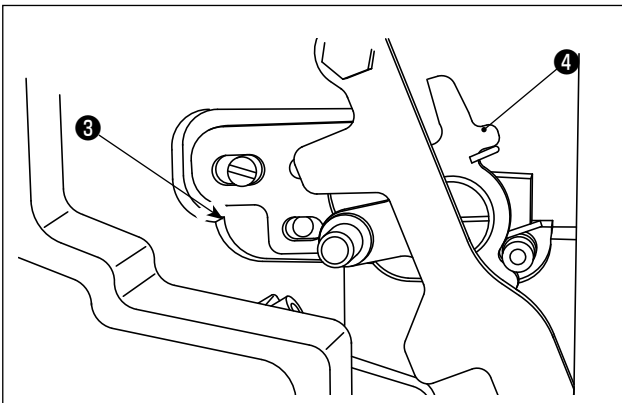


- 1) Replace the stitch dial with the one for long pitch.
Turn the current stitch dial ❶ clockwise to align its scale mark "0" to the marker dot ❸ on the machine arm. Then, remove the setscrew. Attach the stitch dial (40216547) ❷ for long pitch in such a way that its scale mark "0" is aligned with the marker dot on the machine arm.



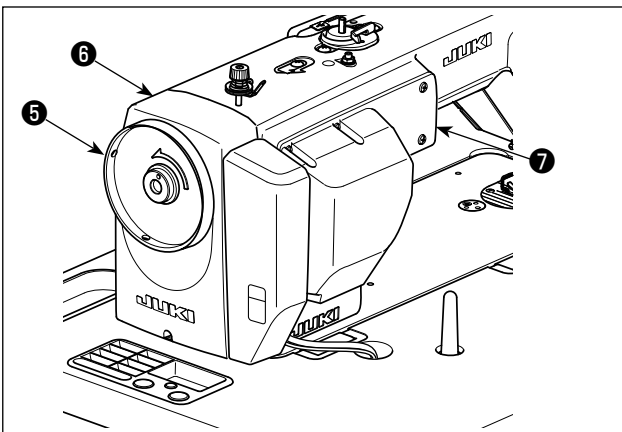
- 2) Remove the current throat plate. Then, align the scale mark "7" of the stitch dial ❷ with the marker dot ❸ on the machine arm.

Turn the handwheel by hand in the direction of the arrow to check to make sure that the feed dog interferes neither with the bed nor with the knife.



- 3) Replace the feed dog ❸ and throat plate ❹ for those for long pitch.

* For the sewing machine that has been factory-attached with the three-teeth feed dog at the time of standard shipment, the throat plate is not required to be changed.

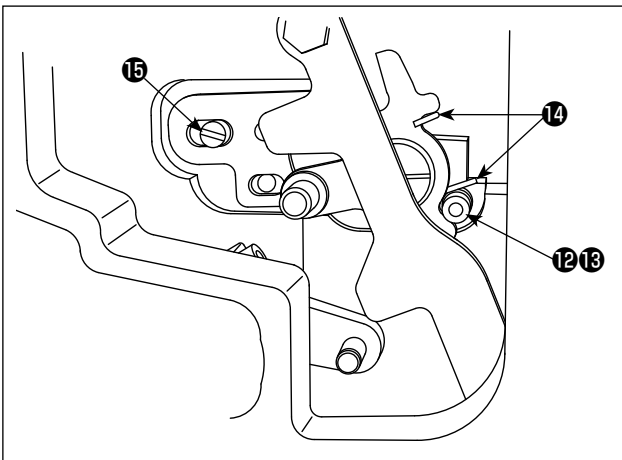
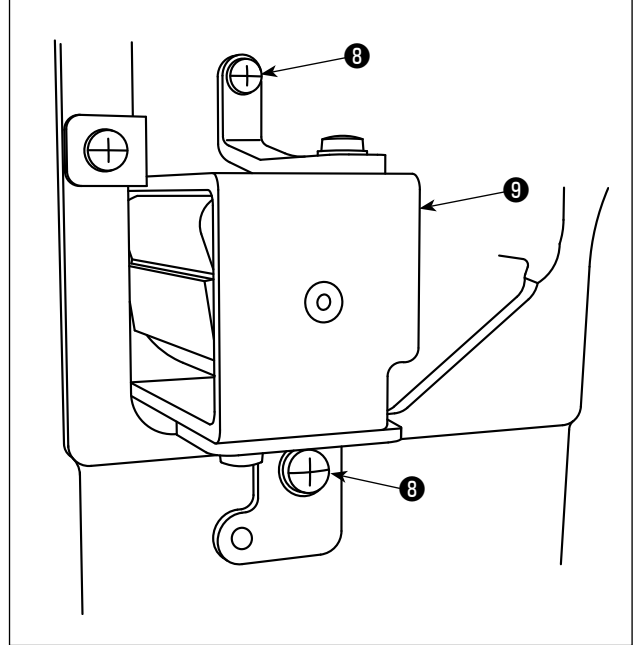
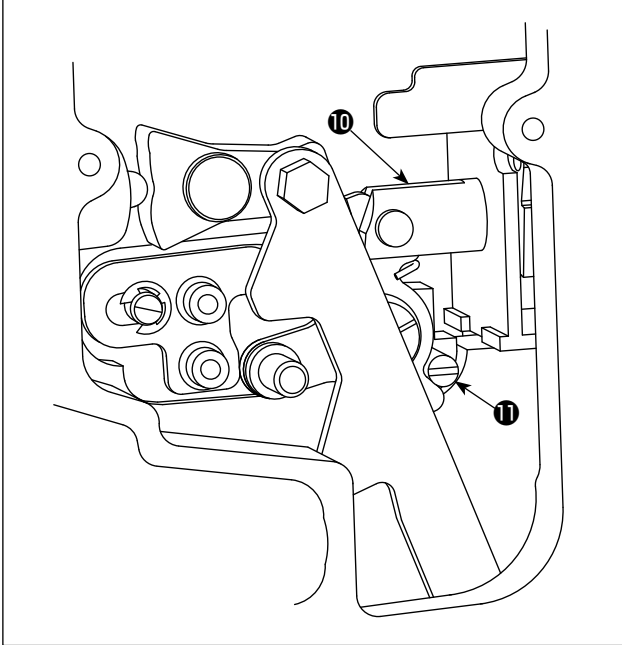


- 4) Detach the handwheel ❺ , cover ❻ and side plate ❼ .

* Only items "5 and 6" are the steps of procedure that are required only for the DDL-8000AB.

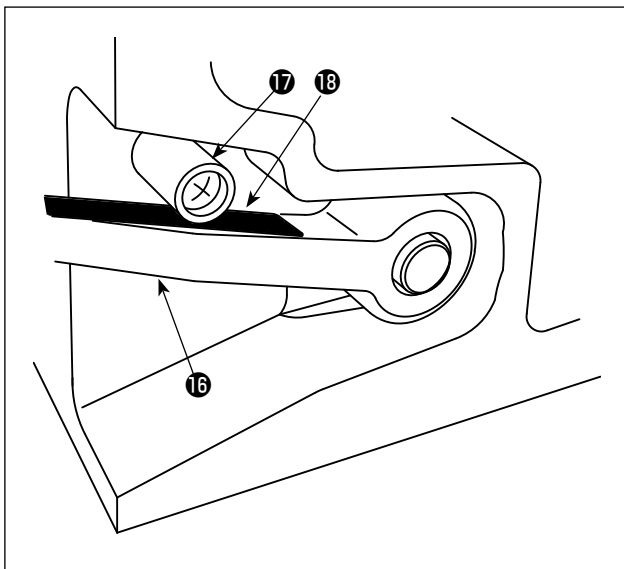
Note) When removing the condensation-stitch solenoid, a connector pin extractor is required.

5) Loosen solenoid setscrew **8** . Detach the condensation-stitch solenoid **9** , plunger **10** and condensation-stitch arm stopper **11** .

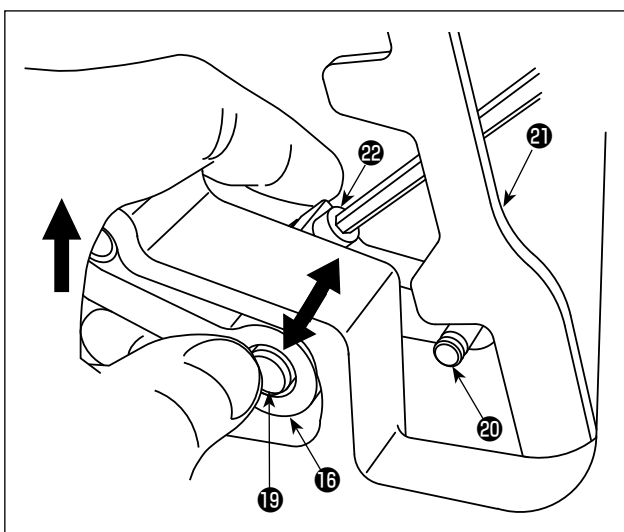


6) Set stitch dial **2** to "0 (zero)". Install one Hexagon socket head bolts **12** and three washers **13** to the arm instead of condensation stitch arm stopper **11** . Then, put condensation stitch spring **14** to the spring peg.

(Caution) Do not remove the condensation-stitch stopper **15 .**



- 7) Align the scale mark "7" of the stitch dial ② to the marker dot on the machine arm. Place a spacer ⑱ with plate thickness of 1 mm between the reverse feed lever ⑯ and the reverse feed lever stopper ⑰ .



- 8) While pushing up the reverse feed lever ⑯ in the direction of the arrow, keep the state that the axial backlash of the reverse feed arm ⑲ is removed. Tighten the setscrew ⑳ of the reverse feed arm at the position where the reverse feed arm pin ㉔ lightly comes in contact with the reed regulating rod ㉕ .

- 9) Align the scale mark "7" of the stitch dial ② with the marker dot on the machine arm. At this time, check to make sure that thread is a slight backlash (play) in the reverse feed lever ⑯ in its moving direction.

(Caution) If there is no aforementioned backlash, abnormal noise or breakage of the related parts may occur while the sewing machine is in operation.

- 10) Detach handwheel ⑤ once. Then, re-attach handwheel ⑤ to its home position after having attached cover ⑥ and side plate ⑦ .

(Caution) 1. In the case of using the stitch pitch that is larger than the one with the scale mark "5" of the stitch dial ②, the maximum sewing speed should be set to 3500 sti/min or less.

2. Be aware that, in the case of performing automatic reverse feed stitching with the stitch pitch that is larger than the one with the mark "5" of the stitch dial ②, the stitches sewn with the normal feed stitching and those sewn with the reverse feed stitching will not be the same.