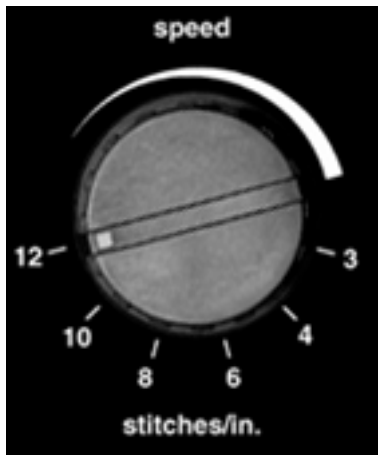
I/S-98 adjustment procedure for REV1.4G, REV2.0G (GAMMILL)

REV 1.4G of the IntelliStitch software provides adjustment means to set the needle speed, the needle positioner's up and down positions and the freehand speed range. The SPEED SELECTOR dial is used to select the adjustment modes:



STITCHES/INCH SETTING	ADJUSTMENT MODE
12	needle speed
10	needle position
3	freehand speed range

If other than the above settings is selected a beep will indicate improper setting when attempting to start the adjustment.

The MODE SWITCH is used to select between incrementing 

and decrementing 

an adjusted parameter.

To enter the adjustment mode, hold the RED BUTTON down while powering up the unit.

A. NEEDLE SPEED ADJUSTMENT

In this mode the needle speed for the needle positioner and the regulated stitching can be adjusted.

Note that the needle positioner speed adjustment will change parameters that affect the needle top position and the freehand speed range, so it should be performed first.

NEEDLE POSITIONER SPEED

1. Turn the SPEED SELECTOR dial to 12 stitches/inch position

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2. Push and hold down . A needle positioning step (up or down) will be made and is turned on indicating the unit is ready for adjustment.

1. Check the speed and strength of the needle movement. The proper setting should provide just enough strength to stitch through the fabric going down and pull out going up without jamming. Avoid setting the needle speed too high, for it may cause the needle to run over its top and bottom position.

2. If the speed and strength are sufficient, release , the adjustment is completed.

3. If the speed and strength are not sufficient, while still holding down, set the MODE SWITCH to REG. FREE if the speed needs to be decreased, to REG. FREE if increasing is necessary.

4. While still holding down, hit . A beep will indicate that the speed was increased/decreased and the new value was stored in the computer's memory. A missing beep indicates that a high/low limit was reached.

5. Release and repeat the procedure from Step 2 until the desired speed is reached.

REGULATED STITCHING SPEED

1. With the SPEED SELECTOR DIAL still at the 12 stitches/inch position push and hold down . A fast single stitch will be made and is turned on indicating the unit is ready for adjustment.

2. Check the speed of the stitch. The speed should as high as possible without causing double stitching.

1. If the speed is acceptable, release , the adjustment is completed.

2. If the speed is not acceptable, while still holding down, set the MODE SWITCH to REG. FREE if the speed needs to be decreased, to REG. FREE if increasing is

necessary.

3. While still holding  down hit  . A beep will indicate that the speed was increased/decreased and the new value was stored in the computer's memory. A missing beep indicates that a high/low limit was reached.

4. Release  and repeat the procedure from Step 1 until the desired speed is reached.

B. NEEDLE POSITION ADJUSTMENT

The needle positioner adjustment has two steps: First a mechanical adjustment of the needle position sensor should be performed using fast single stitch, followed by the adjustment of the up and down positions.

MECHANICAL ADJUSTMENT (TIMING)

Remove the cover from the needle position sensor. You will find one of the following needle position sensor mounting designs.

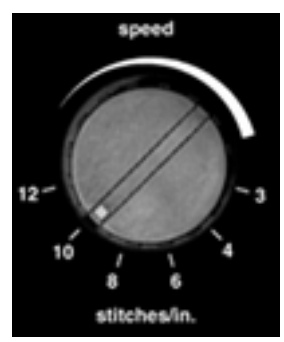
TYPE A design:
The sensor's body (b) is held in position inside the mounting ring by a setscrew (s).
The red tape marker (m) indicates the weak spot on the sensor's body. You must avoid positioning the sensor with the marked area under the screw.

TYPE B design:
The sensor is mounted on a rotating disk assembly (d) held in position by three screws (s). This design allows turning the sensor to any position.

1. Turn the SPEED SELECTOR dial to 10 stitches/inch position.

2. Hit  . A fast single stitch will be made.

3. If the needle stops at or slightly before its top position, continue with the up/down position adjustment.



1. If the needle does not stop at the right position, loosen up the mounting screw(s) and turn the sensor's body while making repetitive stitches by  until the needle stops at the desired position.
   TYPE A design: If at this position the setscrew is over the red marker, turn the sensor clockwise until the marker gets out from under the screw.

2. When the needle stops at the desired position tighten the mounting screw(s).
   TYPE A design: You should apply just enough tension to hold the sensor in place. Stronger tightening may damage the body of the sensor.

3. Replace the cover on the needle position sensor.

UP/DOWN POSITION ADJUSTMENT

1. With the SPEED SELECTOR DIAL at 10 stitches/inch setting push and hold down  . A needle positioning step (up or down) will be made and  is turned on indicating the unit is ready for adjustment. **To differentiate between the "up" and "down" positions a beep will sound when the needle is supposed to be at the "up" position.**

1. Check the up or down position of the needle.

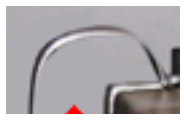
When adjusting the "up" position, the take-up lever should be at this position to release the thread from the hook.

When adjusting the "down" position, the needle should stop at its lowest position.

2. If the position is correct, release  , and go to Step 1 to check the other position.

3. If the position is not acceptable, turn the needle shaft manually, always in forward direction, while  is still held down.
   Note that some overrun will occur which should be considered when turning the needle to the new position:

When adjusting the "up" position, turn the



When adjusting the "down"

handwheel until the take-up lever reaches this position on its way up.

position, turn the handwheel until the needle reaches this position on its way down.

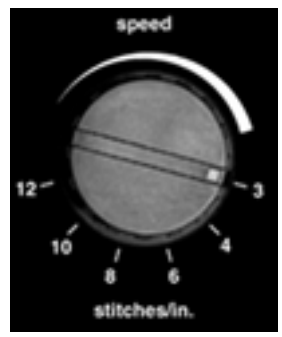
4. While keeping  down, hit  . The buzzer will sound to indicate that the new position was stored in the computer's memory.

5. Release  and repeat the procedure until the desired needle positions are reached.

Note that in some cases excessive overrun and occasional double stitching may occur during the up/down position adjustment. This may be due to unnecessary high needle positioner speed. In such cases a repeated needle positioner speed adjustment is necessary to eliminate the effect.

C. FREEHAND SPEED RANGE ADJUSTMENT

1. Turn the SPEED SELECTOR dial to 3 stitches/inch position.



2. Push and hold down  . The motor will start run continuously with the slowest freehand speed and  will indicate that the unit is ready for adjustment.

1. Check all the other speed settings by turning the SPEED SELECTOR dial while holding  down. **Note that  should be held down continuously during the whole procedure.**

2. If the speed settings are acceptable, release  , the adjustment is completed.

3. If the speed settings are not acceptable, while still holding  down, set the MODE SWITCH to  if the speed needs to be decreased, to  if increasing is necessary.

4. While still holding  down hit  . A beep will indicate that the speed was increased/decreased. Repeat the procedure from Step 3 until the desired speed range is reached.

5. Release  to save the adjusted speed range in the computer's memory.

After the adjustments are made the power should be turned off and on again to start the unit in normal operating mode.

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