





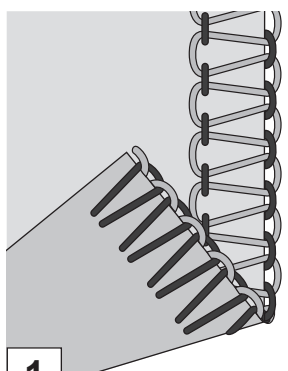






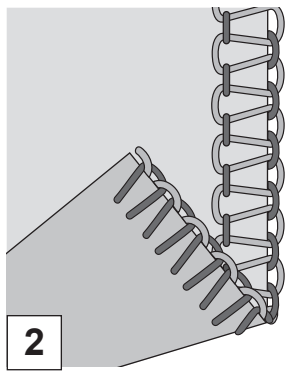






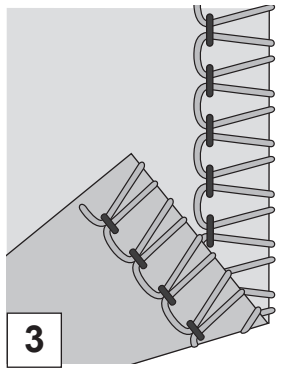








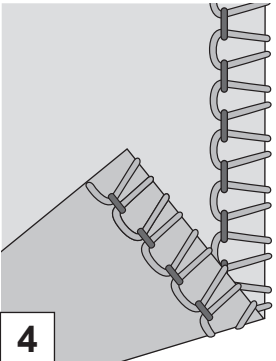






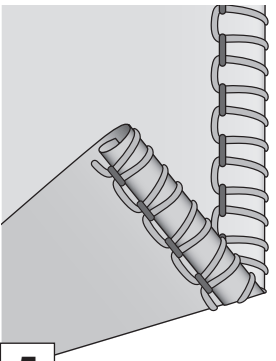






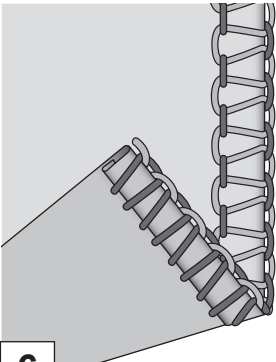






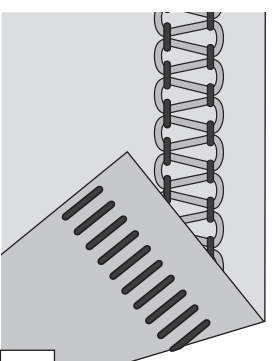






Stitch table

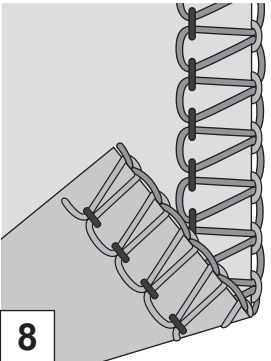







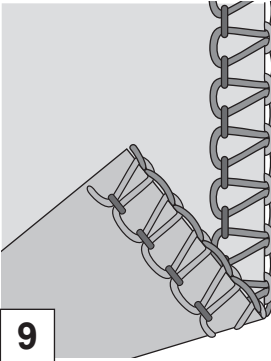







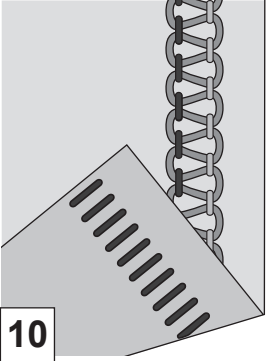







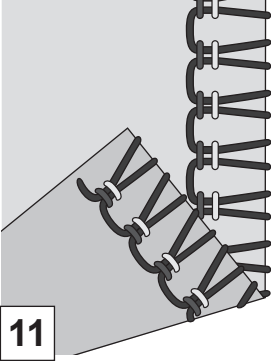







Explanation of the fabric symbols

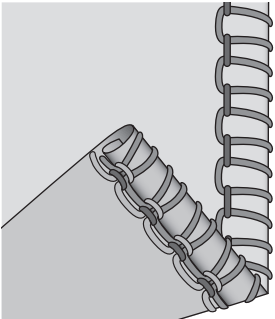






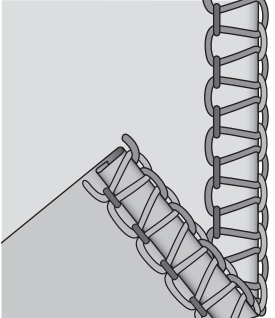






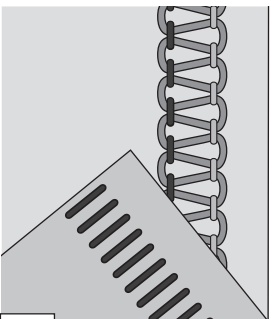






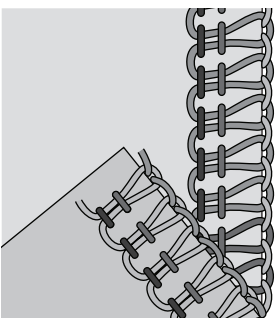






	Woven light Chiffon, voile, organza, batiste, silk, etc.		Stretch light charmeuse, nylon, tricot, single knit jerseys, etc.
	Woven medium Cotton, chino, wool, satin, etc		Stretch medium double knit, velour, swimwear, etc.
	Woven heavy denim, canvas, terrycloth, etc.		Stretch heavy sweater knits, fleece, etc.

Please note:
The settings shown in this table are our recommendations based on normal conditions. It may be necessary to adjust the thread tension according to the stitch, type of fabric and thread you are using. For best results make tension adjustments in small increments of no greater than half a number at a time. Always test sew on a sample of your fabric before sewing on your garment.

Combination		Needle position	Stitch length	Stitch width	Differential feed	Stitch finger	2-thread converter	Thread tension			
Stitch	Fabric							Y	R	G	B
2-thread overlock, wide  1		Left	N	R(3.5)	N	S	Yes	0.0	-	-	5.0
								0.5	-	-	5.0
								1.0	-	-	5.0
								0.0	-	-	5.0
								1.0	-	-	5.0
					1.5			1.0	-	-	5.0
2-thread overlock, narrow  2		Right	N	R(3.5)	N	S	Yes	-	0.0	-	4.0
								-	0.5	-	5.0
								-	1.0	-	5.0
								-	0.0	-	4.5
								-	0.5	-	4.5
					1.5			-	1.0	-	5.0
2-thread overlock, wrap, wide  3		Left	N	R(3.5)	N	S	Yes	2.5	-	-	1.0
								3.5	-	-	1.0
								4.0	-	-	1.0
								2.5	-	-	1.0
								3.5	-	-	1.0
					1.5			4.0	-	-	1.0

Combination		Needle position	Stitch length	Stitch width	Differential feed	Stitch finger	2-thread converter	Thread tension			
Stitch	Fabric							Y	R	G	B
2-thread overlock, wrap, narrow 		Right	N	R(3.5)	N	S	Yes	-	3.5	-	2.0
								-	4.0	-	2.0
								-	5.0	-	2.0
								-	N	-	2.0
								-	4.0	-	2.0
					-			5.0	-	2.0	
2-thread rolled edge 		Right	1	3	N	R	Yes	-	N	-	2.0
								-	N	-	2.0
		Not recommended									
		Right	1	3	N	R	Yes	-	N	-	2.0
		Not recommended									
		Not recommended									
2-thread narrow edge 		Right	1	3	N	R	Yes	-	1.5	-	4.0
								-	1.5	-	4.0
		Not recommended									
		Right	1	3	N	R	Yes	-	2.0	-	4.0
		Not recommended									
		Not recommended									
2-thread flatlock stitch 		Left	N	R(3.5)	N	S	Yes	0.0	-	-	5.0
								0.5	-	-	5.0
								1.0	-	-	5.0
								0.0	-	-	5.0
								0.5	-	-	5.0
					1.5			-	-	5.0	

Combination		Needle position	Stitch length	Stitch width	Differential feed	Stitch finger	2-thread converter	Thread tension			
Stitch	Fabric							Y	R	G	B
3-thread overlock stitch, wide  8		Left	N	R(3.5)	N	S	No	2.5	-	N	N
								N	-	N	N
								3.5	-	N	N
								2.5	-	N	N
								N	-	N	N
								N	-	N	N
					1.5			-	N	N	
3-thread overlock stitch, narrow  9		Right	N	R(3.5)	N	S	No	-	2.5	N	N
								-	N	N	N
								-	3.5	N	N
								-	2.5	N	N
								-	N	N	N
								-	N	N	N
					1.5			-	N	N	
3-thread flatlock stitch, narrow  10		Left	N	R(3.5)	N	S	No	4.0	-	0.0	8.0
								4.0	-	0.0	8.5
								5.0	-	0.0	8.5
								4.0	-	0.0	8.0
								5.0	-	0.0	8.5
								5.0	-	0.0	8.5
								5.0	-	0.0	8.5
3-thread stretch overlock  11		Right	N	R(3.5)	N	S	No	-	N	1.0	7.0
								-	3.5	1.0	7.0
								-	4.0	1.0	7.0
								-	3.5	1.0	6.0
								-	3.5	1.0	6.0
								-	N	1.0	6.0
								-	N	1.0	6.0

Combination		Needle position	Stitch length	Stitch width	Differential feed	Stitch finger	2-thread converter	Thread tension			
Stitch	Fabric							Y	R	G	B
3-thread rolled edge  12		Right	1	3	N	R	No	-	2.0	5.0	7.0
								-	2.0	5.0	8.0
		Not recommended									
		Right	1	3	N	R	No	-	N	4.0	6.0
		Not recommended									
		Not recommended									
3-thread narrow edge  13		Right	1	3	N	R	No	-	N	5.0	N
								-	N	5.0	4.0
		Not recommended									
		Right	1	3	N	R	No	-	N	5.0	N
		Not recommended									
		Not recommended									
3-thread flatlock stitch, wide  14		Left	N	R(3.5)	N	S	No	0.5	-	5.0	7.0
								0.5	-	5.0	7.0
								0.5	-	5.0	7.0
								0.5	-	5.0	7.0
								0.5	-	5.0	7.0
								0.5	-	5.0	7.0
4-thread overlock stitch  15		Both	N	R(3.5)	N	S	No	2.5	2.5	N	N
								N	N	N	N
								3.5	3.5	N	N
				2.5	2.5	N		N			
				N	N	N		N			
				3.5	3.5	N		N			