

User's Manual

GARUDAN[®]

FTD7000 Series



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PREFACE

FTD SERIES IS DIRECT DRIVE HIGH SPEED FLAT BED INTERLOCK MACHINE AND CAN ACHIVE EXCELLENT EFFICIENCY, STABLE QUALITY AND DURABLE MACHINE LIFE.

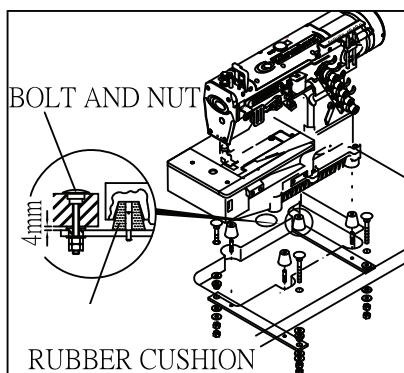
SAFETY NOTICE

1.
BELT COVER MUST BE INSTALLED.
2.
MAKE SURE THE MOTOR WIRING IS INSTALLED PROPERLY.
3.

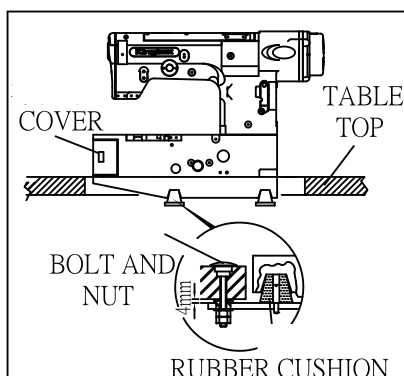
MAKE SURE TO CUT OFF THE ELECTRICITY AND WAIT TILL MOTOR STOPS COMPLETELY BEFORE CONDUCT PRE-OPXERATION INSPECTION.CLEANING,THREADING AND CHANGING THE NEEDLES.
4.
FOR NEW MACHINES, PLEASE DO NOT RUN EXCEED 4,500 RPM DURING THE FIRST MONTH USAGE.
5.
DO NOT OVER-ADDING THE LUBRICATION OIL.
6.
PLEASE DRIP ONE DROP OF OIL ON THE NEEDLE BAR BEFORE OPERATION.
7.
PLEASE MAKE SURE THE NEEDLES ARE INSTALLED PROPERLY.
8.
PLEASE MAKE SURE THE THREADING IS CORRECT.
9.
PLEASE MAKE SURE TO CLEAN THE MACHINE AND SHUT OFF THE ELECTRICITY POWER AFTER DAILY OPERATIO.

2.

TABLE TOP INSTALLATION



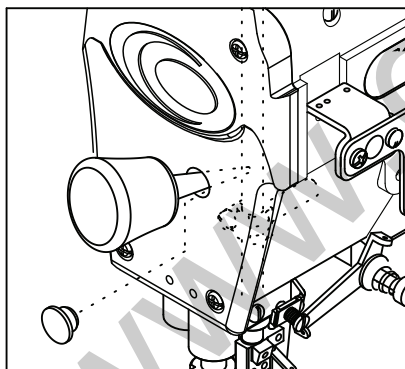
INSTALL THE MACHINE CORRECTLY REFERRING TO THE ILLUSTRATION. SET BOLTS AND NUTS TO MACHINE TABLE AND PUT RUBBER CUSHIONS ON BOLTS AND REST THE MACHINE ON THEM SECURELY.



IF USING RUBBER CUSHION TO ADJUST THE HEIGHT OF MACHINE THEN, MUST MAKE SURE THERE IS NO INTERFERENCE BETWEEN MACHINE AND TABLE TOP, SO CAN OPEN UP THE OIL FILTER SIDE COVER WITHOUT ANY PROBLEM.

3.

BEFORE OPERATION



IF USING A NEW MACHINE OR A MACHINE WHICH HAS NOT BEEN RUNNING FOR A WHILE, OIL THE NEEDLE BAR AND THE LOOPER BAR 2 OR 3 DROPS BEFORE RUNNING THE MACHINE.

4.

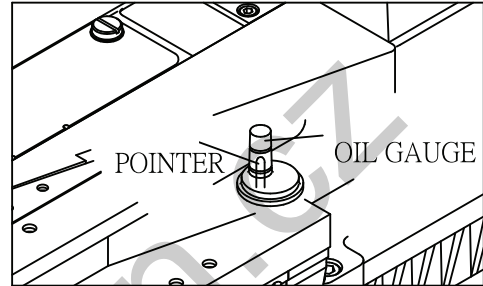
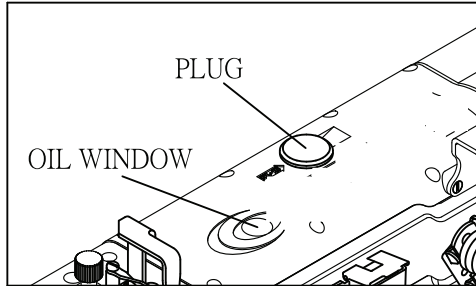
LUBRICATION OIL AND COOLING OIL

4-1

LUBRICATION OIL AND COOLING OIL

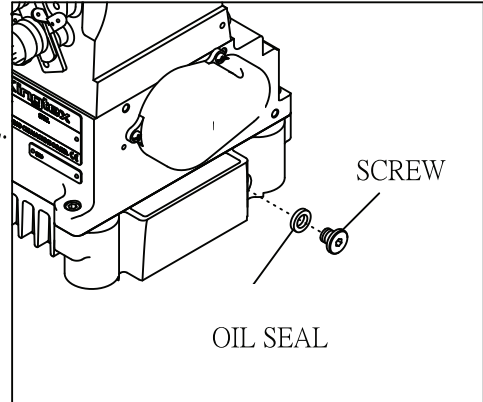
PLEASE USE MOBIL #10 OR EQUIVALENT OIL FOR LUBRICATION OIL AND USE SILICONE OIL FOR COOLING OIL.

THE LUBRICATION OIL HAS BEEN DRAINED OFF COMPLETELY BEFORE DELIVERY, ADDING OIL TO THE UPPER LINE OF OIL GAUGE (C) BY REMOVING SEAL PLUG (A). ALSO, PLEASE MAKE SURE THE OIL FLOWS OUT OF NOZZLE (B) AT THE START OF OPERATION.

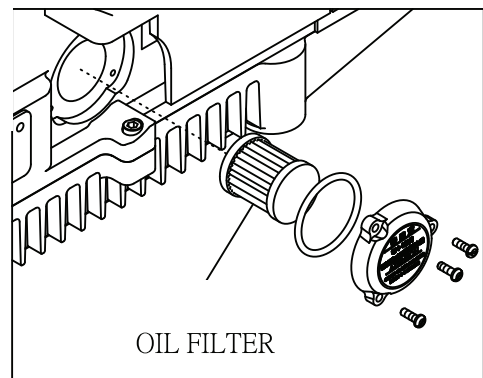


FOR THE LONGER LIFE OF MACHINE, CHANGE LUBRICATION OIL COMPLETELY AFTER 250 HOURS (OR 4 WEEKS) OF INITIAL OPERATION.

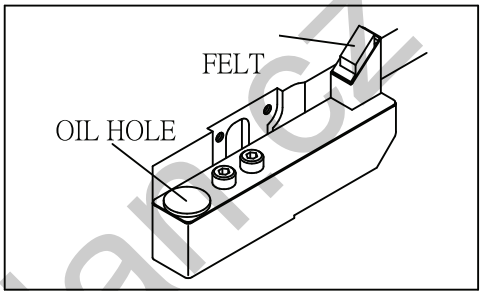
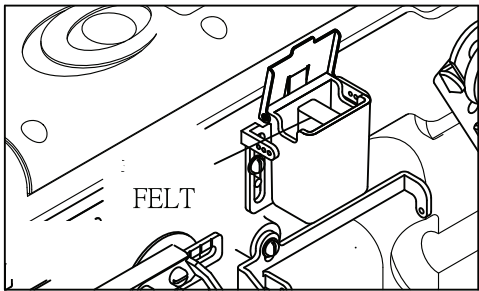
- A. REMOVE MACHINE HEAD FROM MACHINE TABLE.
- B. LOOSEN SCREW (D) AND DRAIN OFF ALL THE OIL FROM INSIDE OF THE MACHINE.
- C. AFTER DRAINED, TIGHTEN SCREW (D) BACK.
- D. WHEN REPLENISHING OIL, PLEASE REFER TO PARAGRAPH 4-2. "FEEDING OIL" ABOVE.



ALTHOUGH THE MACHINE IS USING OIL PUMP LUBRICATION AND SPLASHING LUBRICATION SYSTEMS, PLEASE CHECK AND CLEAN OIL FILTER EVERY MONTH. AND WHEN NO OIL OR SMALL AMOUNT OF OIL COMES OUT OF NOZZLE ALTHOUGH THE INDICATOR SHOWS NORMAL, PLEASE CHECK OIL FILTER AND REPLACE IT IF NECESSARY.



AVOID NEEDLE BREAKING, SKIP STITCHES OR THREAD MELTING PROBLEMS ETC. PLEASE FILL COOLING OIL TANK AND FELT WITH SILICONE OIL. HOWEVER, UNDER SOME SPECIAL CIRCUMSTANCES, CAN NOT USE SILICONE OIL OR NO NEED TO USE SILICONE OIL THEN, YOU CAN TAKE FELT OFF FROM RESERVOIR



5. NEEDLE

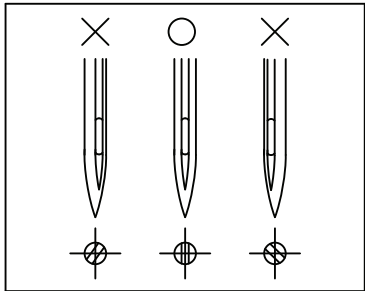
5-1 NEEDLE SELECTION

NEEDLE UY128GAS OF SCHMETZ OR ORGAN IS TO BE USED. THERE ARE MANY SIZES OF NEEDLE, AND THE MOST SUITABLE NEEDLE, EXCEPT MODEL FTD7060 WHICH IS USING UY118GKS, SHOULD BE BASED ON THE THICKNESS AND KIND OF FABRICS USED.

JAPANESE SIZE	9	10	11	12	13	14
METRIC SIZE	65	70	75	80	85	90

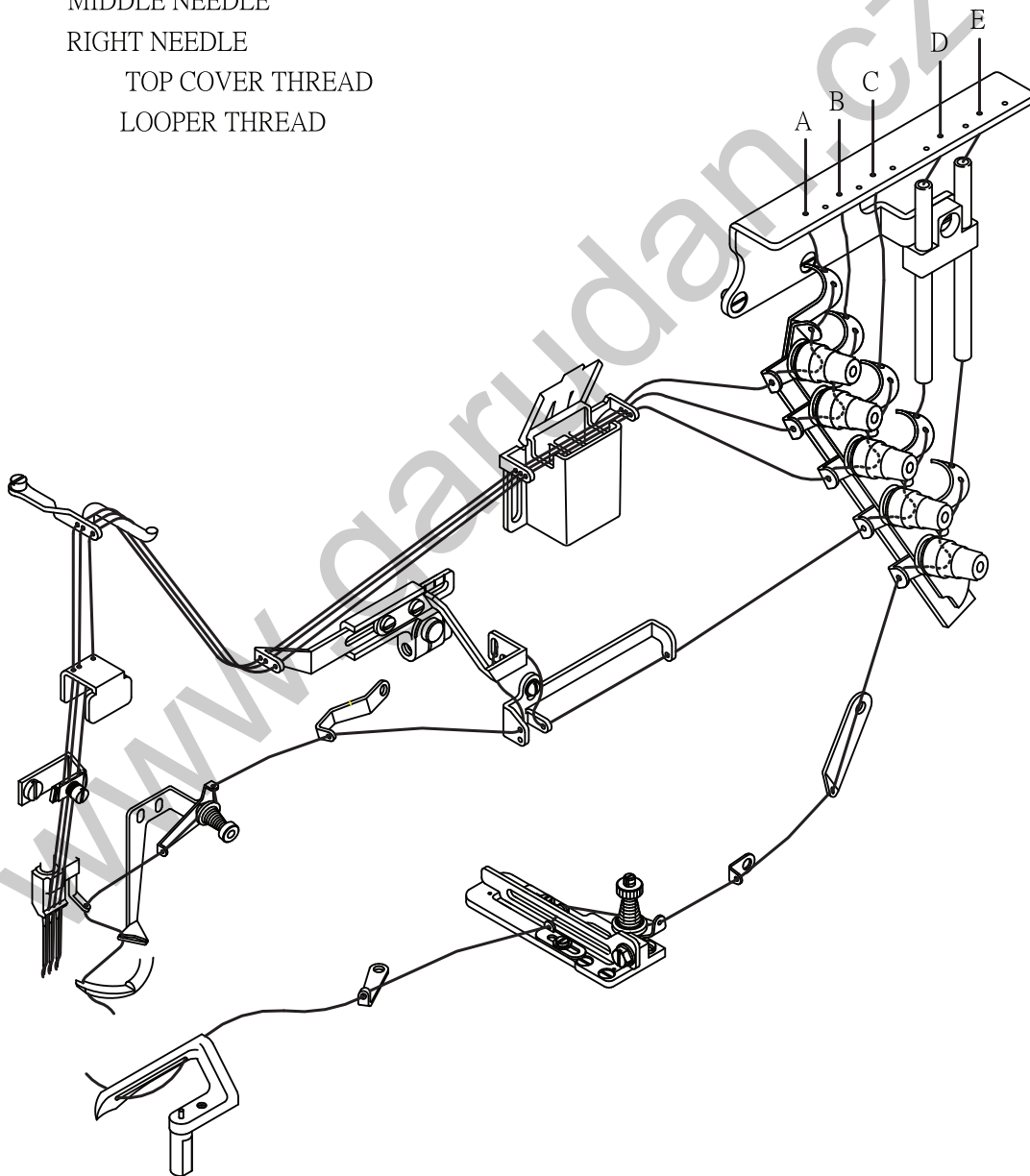
5-2 HOW TO REPLACE THE NEEDLES

WHEN REPLACING NEEDLES,THE NEEDLES SHOULD BE INSTALLED CORRECTLY. THE SCARF OF NEEDLES SHOULD BE FACED CENTER BACKWARD.



THREADING SHOULD BE MADE CORRECTLY, REFERRING TO THE ILLUSTRATION. IMPROPER THREADING MIGHT CAUSE SKIP STITCH, THREAD BREAKAGE AND UNEVEN SEAM ETC. THE THREADING FOR THREE NEEDLE MACHINE IS SHOWN IN THE ILLUSTRATION BELOW. FOR TWO NEEDLE MACHINE, THREADING IS THE SAME EXCEPT ONLY TWO NEEDLE THREADS.

- A LEFT NEEDLE
- B MIDDLE NEEDLE
- C RIGHT NEEDLE
- D TOP COVER THREAD
- E LOOPER THREAD



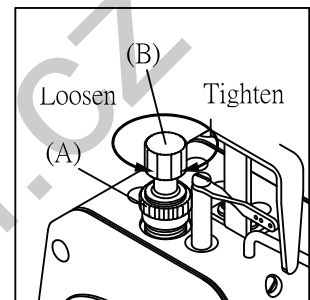
6.

PROPER OPERATION ADJUSTMENT

DUE TO THE THICKNESS OF FABRICS, DIFFERENT MATERIALS, DIFFERENT KINDS OF THREAD, DIFFERENT STITCH REQUIREMENTS, THE CHANGES OF DIFFERENTIAL RATIO, ALL IS AFFECTING THE SWING PERFORMANCE. THUS, MUST CONDUCT THE PROPER OPERATION ADJUSTMENT IN ORDER TO GET BEST SEWING EFFECTS.

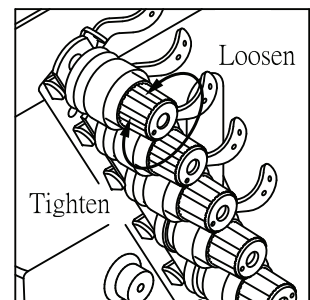
6-1 PRESSURE OF PRESSER FOOT

TO INCREASE THE PRESSURE OF PRESSER FOOT, TURN ADJUSTING SCREW (B) CLOCKWISE AFTER LOOSENING LOCK NUT (A) AND TO DECREASE, TURN IT COUNTERCLOCKWISE. PRESSURE OF PRESSER FOOT SHOULD BE AS WEAK AS POSSIBLE SO LONG AS PRESSER FOOT CAN OPERATE PROPERLY.



6-2 THREAD TENSION

DIFFERENT THREADS HAVE DIFFERENT TENSIONS AND EVEN SAME THREADS WILL HAVE DIFFERENT TENSIONS WHEN GO THROUGH DIFFERENT THREADING HOLES. EACH THREAD TENSION CAN BE ADJUSTED BY INDIVIDUAL TENSION NUT TO INCREASE THREAD TENSION, TURN TENSION NUT CLOCKWISE, TO DECREASE THREAD TENSION, TURN TENSION NUT COUNTERCLOCKWISE. PLEASE USE LEAST THREAD TENSION AS LONG AS IT WILL NOT AFFECT THE SEWING EFFECTS.



6-3

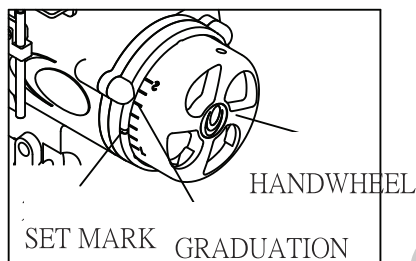
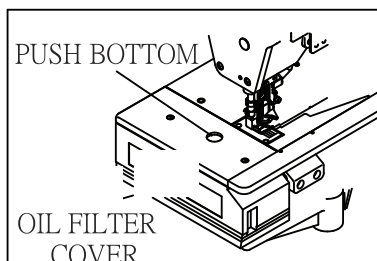
ADJUSTING STITCH LENGTH

ADJUSTMENT OF STITCH LENGTH CAN BE MADE STEPLESSLY FROM 1.4MM/PER STITCH TO 3.6MM/PER STITCH.

THE TABLE BELOW SHOWS THE STITCH LENGTH.

STITCH LENGTH	STITCH NUMBER	STITCH NUMBER
3.6mm	7 PER/ INCH	8 PER/30MM
2.4mm	10.5 PER/ INCH	12.5 PER/30MM
1.4mm	18 PER/ INCH	21 PER/30MM

PRESS PUSH BUTTON (C) WITH LEFT HAND LIGHTLY UNTIL ITS TIP CONTACT TO THE PART INSIDE. KEEP PRESSING, TURN HANDWHEEL WITH RIGHT HAND UNTIL THE TIP OF PUSH BUTTON GETS INTO THE HOLE, AT THIS THIS POINT, PRESS IN PUSH BUTTON STRONGLY AND TURN HANDWHEEL. ONE GRADUATION ON THE CIRCUMFERENCE OF HANDWHEEL INDICATES A STITCH LENGTH(M.M). WHICH SHOULD BE ALIGNED WITH THE SET MARK (D). THEN RELEASE HAND.



6-4

ADJUSTING DIFFERENTIAL FEED

1.

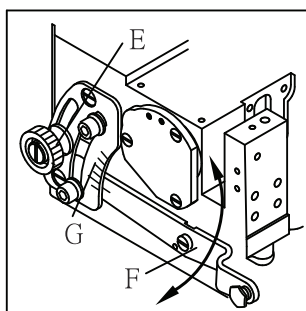
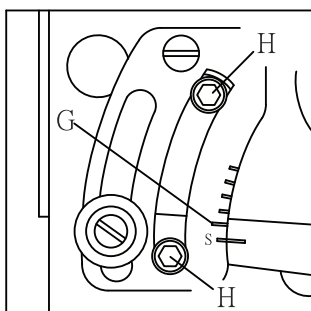
WHEN ADJUSTING NORMAL DIFFERENTIAL FEED (SHRINK SEWING), LOOSEN NUT(E) MOVING LEVER (F) UP AND DOWN AND SET IT AT THE DESIRED POSITION BY TIGHTENING NUT (E). WHEN LEVER IS SET AT GRADUATION (LONG) (G), THE RATIO OF MAIN FEED TO DIFFERENTIAL FEED GRADUATION OF UPPER PART REPRESENT 1:1.25 ,1:1.5 , 1:1.75, 1:2 IN ORDER FROM THE BOTTOM.

2.

WHEN ADJUST REVERSE DIFFERENTIAL FEED (STRETCH SEWING), BY THE TIME WHEN THE LEVER IS LOWERED BELOW GRADUATION (LONG) (G), THE FEED BECOMES REVERSE DIFFERENTIAL FEED. WHEN IT IS SET AT "S", THE RATION OF MAIN FEED TO DIFFERENTIAL FEED IS 1:0.7

3.

ADJUSTMENT OF DIFFERENTIAL FEED DURING OPERATION: FIXING LOWER AND UPPER STOPPERS (H) AT DESIRED POSITIONS AND TO SET UP THE LOWER AND UPPER DIFFERENTIAL LIMITS, THEN, MOVE THE LEVEL UP AND DOWN IN ORDER TO OBTAIN THE DESIRED DIFFERENTIAL RATIO.



E : SET SCREW
F : LEVEL
G : GRADUATION
H : STOPPER

THE RANGE OF DIFFERENTIAL RATIO VARIES ACCORDING TO THE STITCH LENGTH.REFER TO THE TABLE BELOW

STITCH LENGTH	MAX. NORMAL DIFF	MAX. REVERSE DIFF
3.6MM	1 : 1.2	1 : 0.7
2.5MM	1 : 1.6	1 : 0.7
2.0MM	1 : 1.8	1 : 0.7
1.4MM	1 : 2.0	1 : 0.7

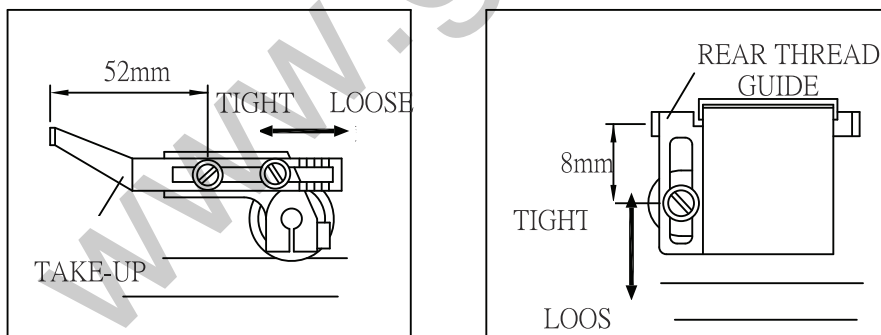
6-5

ADJUSTING THE NEEDLE THREAD TAKE-UP

DIFFERENT THREADS HAVE DIFFERENT STRECTCH TENSIONS AND CAUSING SKIP STITCHING THREAD BREAKING AND UNSTABLE STITCHING EASILY. THIS MACHINE EQUIPPED WITH THREAD TAKE-UP, FRONT NEEDLE THREAD GUIDE, REAR THREAD GUIDE AND AUXILIARY THREAD TENSION CONTROL GUIDE IN ORDER TO GIVE BETTER CONTROL OF THE LOOPER THREAD TAKE-UP AND STABLIZE THE STRECTCHING OF LOOPER THREAD.

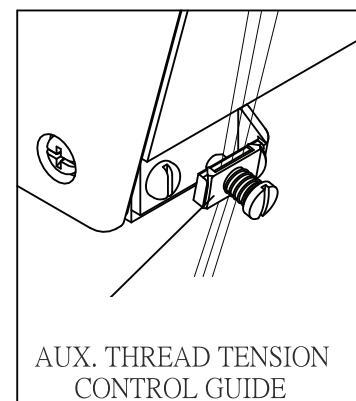
1

THE THREAD TAKE-UP AND REAR THREAD GUIDE WERE SET AT STANDARD POSITION BEFORE SHIPMENT. AS SHOWN ON FIGURE G/H. AND ALSO CAN BE ADJUSTED AS ARROW DIRECTIONS IF NECESSARY.



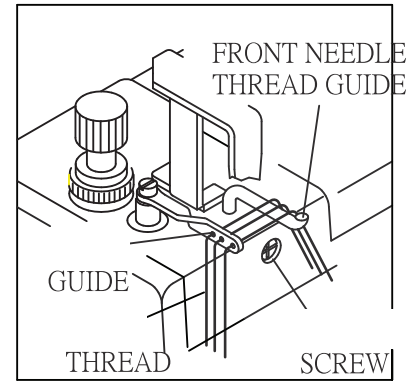
2.

SOME TIMES, IT IS NOT SO EASY TO FORM THREAD LOOP FOR SOME KINDS OF THREAD AND ALSO MAKE IT DIFFICULT FOR LOOPER TO CATCH THE NEEDLE THREAD, CAUSING SKIP STITCH. IN SUCH CASE, CAN USE AUXILIARY THREAD TENSION CONTROL GUIDE TO STABLIZE THE THREADS.



3.

IN CASE THE FORMATION OF NEEDLE THREAD LOOP IS UNSTABLE WHEN USING STRETCHABLE THREAD, YOU CAN SOLVE THIS BY ADJUSTING THE HEIGHT OF FRONT NEEDLE THREAD GUIDE, ESPECIALLY WHEN LOOPER MOVE FROM RIGHT TO THE LEFT. IF THE LEFT NEEDLE SKIP THE STITCH WHEN USING SYNTHETIC THREAD OR RIGHT NEEDLE INTERFERENCE WITH THE FORMATION OF THREAD LOOP WHEN USING BLENDED THREAD, YOU CAN USE FRONT NEEDLE THREAD GUIDE, WITH NEEDLE BAR AT THE LOWEST POSITION, THE CENTER OF THREAD HOLE OF REAR THREAD GUIDE EYELET SHOULD BE EVEN WITH THE SURFACE OF FRONT NEEDLE THREAD GUIDE AND FRONT NEEDLE THREAD GUIDE AND REAR THREAD GUIDE SHOULD BE PARALLEL WITH EACH OTHER.



6-6

ADJUSTING THE LOOPER THREAD TAKE-UP

A,B

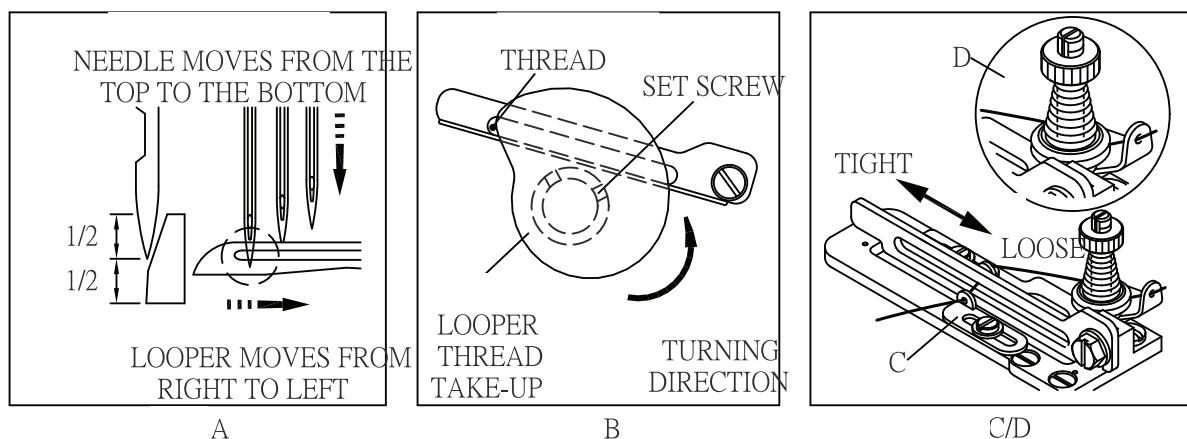
WHEN LEFT NEEDLE COMES DOWN TO THE HALF DISTANCE, THE THREAD MUST GET OFF FROM THE HIGHEST POSITION OF LOOPER THREAD TAKE-UP. THE ADJUSTMENT IS MADE BY LOOSENING SCREW, TURN THE LOOPER THREAD TAKE-UP TO THE PROPER POSITION AND TIGHTEN THE SCREW.

C

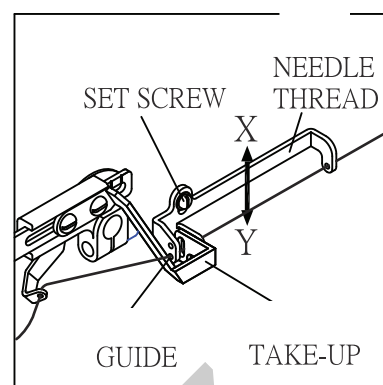
TO DECREASE THE AMOUNT OF LOOPER THREAD IN THE SEAM, MOVE THREAD GUIDE EYELET TO ALIGNING MARK TO INCREASE ITS TIGHTNESS. MOVE IT BACKWARD FOR LOOSENESS.

D

FOR STRETCHABLE THREADS, MOVE RIGHT AND LEFT THREAD GUIDES TO ALIGNING MARK AND ALSO THE LOOPER THREAD DOES NOT NEED TO GO THRU THREAD GUIDE.



THE THREAD AMOUNT OF TOP COVER THREAD IS ADJUSTED BY SPREADER THREAD TAKE-UP. FOR STANDARD POSITION, LOOSENING SET SCREW, PUSH THREAD GUIDE UPWARD TO ITS HIGHEST POSITION AS X DIRECTION SHOWN. THEN TIGHTEN THE SET SCREW. FOR STRETCHABLE THREAD, PUSH THE THREAD GUIDE DOWNWARD AS Y DIRECTION AND THREAD MUST PASS THROUGH THE EYELET OF THREAD GUIDE.



7.

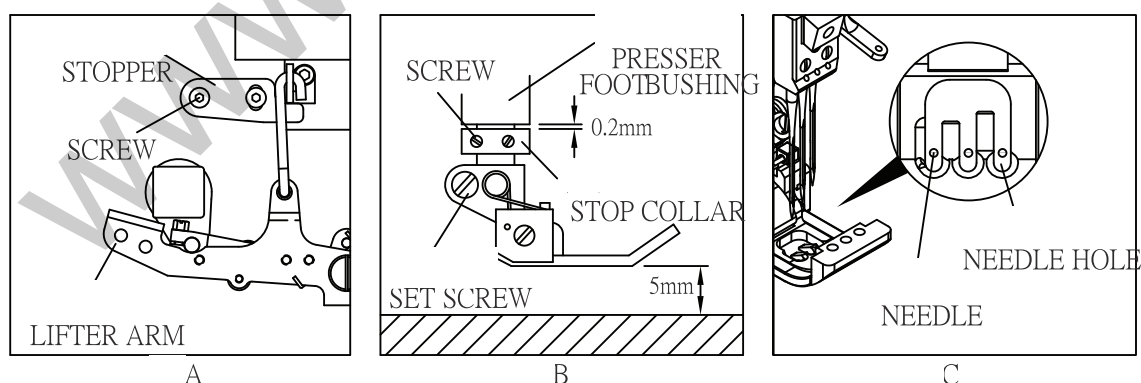
ADJUSTMENT OF MACHINE

THIS MACHINE WAS SET AT THE STANDARD POSITION BEFORE DELIVERY AND IT'S UNNECESSARY TO RE-ADJUST UNLESS UNDER SOME SITUATION AS CHANGING THE NEEDLE, LOOPER, DIFFERENT KIND OF FABRIC OR DIFFERENT SEWING THREADS. PLEASE ADJUST ACCORDING TO FOLLOWING ITEMS.

7-1

ADJUSTING PRESSER FOOT AND SETTING THE HEIGHT OF PRESSER FOOT

IT WILL BE EASIER TO CONDUCT SOME ADJUSTMENTS BY TAKING OFF THE PRESSER FOOT AS FOLLOWS :



A/B

LOOSENING SCREW IN ORDER TO LOOSEN STOPPER, LOOSENING SCREW AND COLLAR SCREW PRESSING DOWN LEVEL, LIFTING NEEDLE BAR IN ORDER TO TAKE OFF PRESSER FOOT.

C

AFTER FINISHED THE ADJUSTMENT, PLEASE TIGHTEN THE SCREW IN REVERSE SEQUENCE AND PLEASE MAKE SURE NEEDLE POINT RIGHT INTO THE CENTER OF THE NEEDLE HOLE OF PRESSER FOOT.

7-2

D,E,F)

ADJUSTING THE HEIGHT OF NEEDLE BAR AND NEEDLE DROP POINT

D.

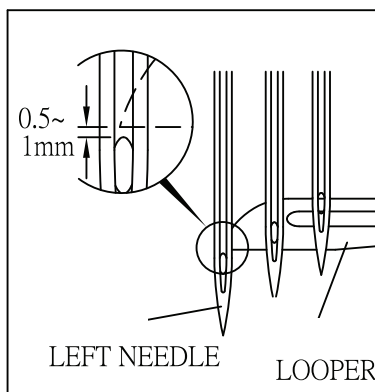
WHEN THE TIP OF LOOPER COMES TO THE CENTER OF LEFT NEEDLE, THE LOOPER SHOULD POSITION ABOVE THE UPPER END OF NEEDLE EYE BY 0.5-1.0 mm AS THIS IS THE STANDARD SET POSITION FOR NEEDLE BAR.

E.

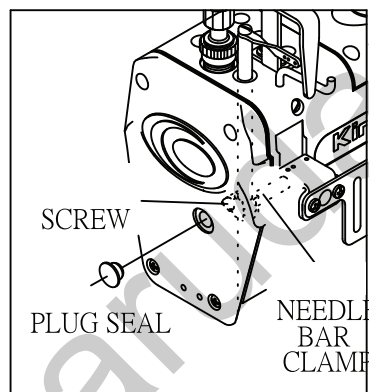
LOOSEN THE SCREW OF NEEDLE BAR CLAMP AND ADJUST THE NEEDLE BAR TO GET PROPER HEIGHT.

F.

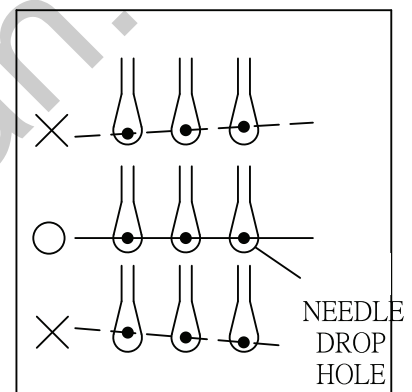
AFTER ADJUSTMENTS, TIGHTEN THE SCREW OF NEEDLE BAR CLAMP AND MAKE SURE THE NEEDLES ARE IN THE CENTER OF NEEDLE DROP HOLE OF NEEDLE PLATE.



D



E



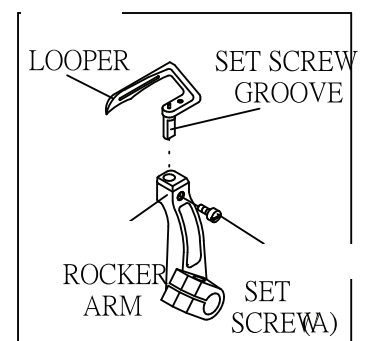
F

7-3

INSTALLING LOOPER

G.

INSERTING LOOPER ALL THE WAY INTO LOOPER HOLDER AND PLEASE MAKE SURE LOOPER IS FULLY FITTED INTO PROPER POSITION, THEN TIGHTENED SCREW (A).



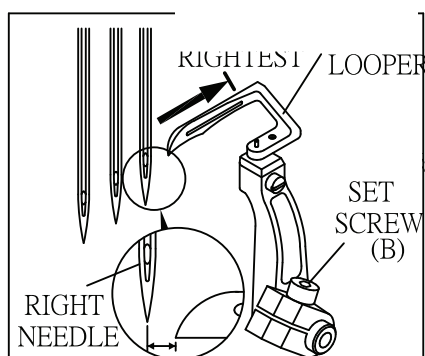
G

7-4

SETTING LOOPER

H.

THE LOOPER IS LOCATED AT THE EXTREME RIGHT WHEN NEEDLE BAR DECENT TO ITS LOWEST POINT. AND THE DISTANCE BETWEEN THE TIP OF LOOPER AND THE CENTER OF RIGHT NEEDLE IS VARIOUS, ACCORDING TO THE NEEDLE DISTANCE. PLEASE REFER TO THE TABLE BELOW FOR ADJUSTMENT AND THE ADJUSTMENT IS MADE BY LOOSENING THE SCREW (B) OF LOOPER HOLDER.



H

STANDARD DISTANCE BETWEEN THE TIP OF LOOPER AND THE CENTER OF RIGHT NEEDLE

NEEDLE DISTANCE (MM)	LOOPER MOVEMENT TO THE RIGHT (M M)
4.0	4.0 MM
4.8	3.6 MM
5.6	3.2 MM
6.4	2.8 MM

7-5

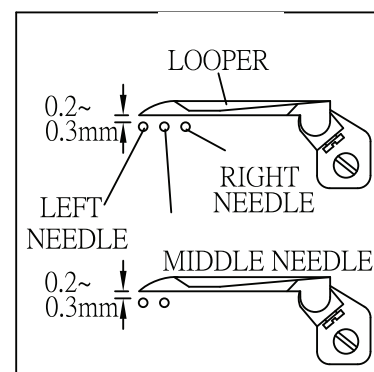
THE CLEARANCE BETWEEN LOOPER AND NEEDLE

I. FTD7000

WHEN THE TIP OF LOOPER MEETS THE CENTER OF LEFT NEEDLE. THE CLEARANCE BETWEEN THEM SHOULD BE 0.2-0.3mm. WHEN THE TIP OF LOOPER MEETS THE CENTER OF MIDDLE NEEDLE. THE CLEARANCE BETWEEN THEM SHOULD BE MINIMAL. WHEN THE TIP OF LOOPER MEETS THE CENTER OF RIGHT NEEDLE. THE CLEARANCE SHOULD BE 0-0.05 mm BETWEEN THE TIP OF LOOPER AND NEEDLE OF WHICH AFTER BEEN PUSHED FORWARD BY REAR NEEDLE GUARD 0.2-0.3 mm . THE ADJUSTMENT IS MADE BY LOOSENING SCREW OF LOOPER HOLDER.

FTD7000

WHEN THE TIP OF LOOPER MEETS THE CENTER OF LEFT NEEDLE, THE CLEARANCE BETWEEN THEM SHOULD BE 0.2-0.3 mm. WHEN THE TIP OF LOOPER MEETS THE CENTER OF RIGHT NEEDLE, THE REAR NEEDLE GUARD SHOULD PUSH, NEEDLE 0.2-0.3 mm FORWARD IN ORDER TO GET THE CLEARANCE OF 0-0.05 mm BETWEEN THE OF LOOPER AND NEEDLE.



I

7-6

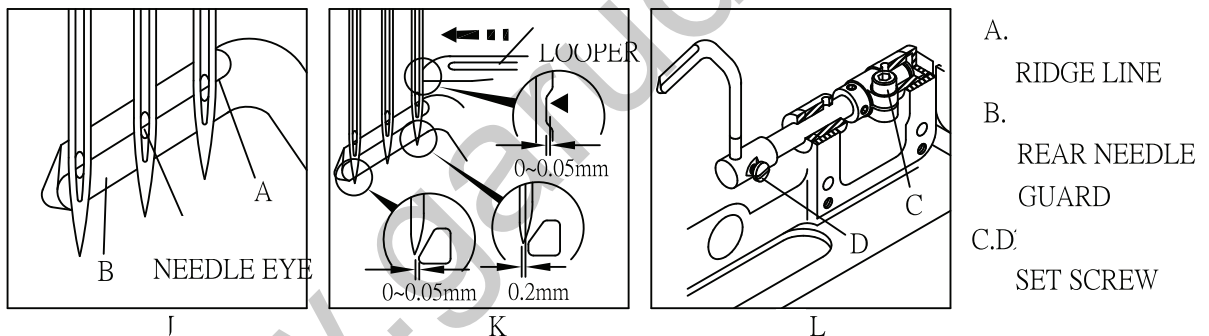
THE RELATION BETWEEN NEEDLE AND REAR NEEDLE GUARD

J. SETTING THE HEIGHT OF REAR NEEDLE GUARD

WHEN NEEDLES DESCEND TO THE LOWEST POSITION. THE RIDGE LINE (A) OF REAR NEEDLE GUARD (B) ALIGN WITH THE CENTER OF THE EYE OF EACH NEEDLE. THE ADJUSTMENT OF THE HEIGHT OF REAR NEEDLE GUARD IS MADE BY LOOSENING THE SCREW.

K/L SETTING THE ANGLE AND TIMING OF REAR NEEDLE GUARD

WHEN THE TIP OF LOOPER PASSES THE CENTER OF RIGHT NEEDLE. THE REAR NEEDLE GUARD WILL SLIGHTLY PUSH THE RIGHT NEEDLE FORWARD ABOUT 0.2-0.3 mm. AND AT THIS TIME, THE CLEARANCE BETWEEN LOOPER AND RIGHT NEEDLE IS 0-0.05 mm AND LOOPER WILL TOUCH MIDDLE NEEDLE SLIGHTLY. AND THE CLEARANCE BETWEEN LOOPER AND LEFT NEEDLE IS 0-0.05 mm. THESE ADJUSTMENTS ARE MADE BY LOOSENING THE SET SCREWS (C) AND (D).

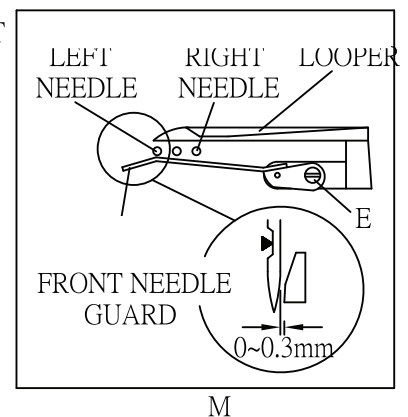


7-7

THE RELATION BETWEEN NEEDLE AND REAR NEEDLE GUARD

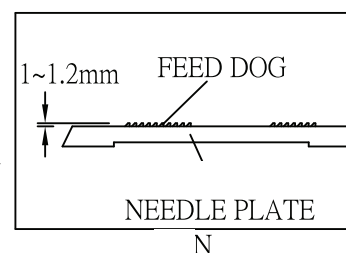
M.

WHEN THE TIP OF LOOPER COMES TO THE CENTER OF LEFT NEEDLE AND RIGHT NEEDLE, ADJUST THE CLEARANCES BETWEEN THOSE NEEDLES AND FRONT NEEDLE GUARD SHOULD BE 0 - 0.3 mm. THE ADJUSTMENTS ARE MADE BY LOOSENING SET SCREW (E) AND MOVE FRONT NEEDLE GUARD TO ITS DESIRED POSITION. THEN, TIGHTEN THE SET SCREW (E).



N.

WHEN FEED DOGS RISE TO ITS UPPER MOST, THE HEIGHT OF FEED DOGS IS 1 - 1.2 mm ABOVE THE TOP SURFACE OF NEEDLE PLATE AND DIFFERENTIAL AND MAIN FEED DOG ARE PARALLEL TO THE SURFACE OF NEEDLE PLATE.



8. TOP COVERSTITCH

8-1

INSTALLING AND SETTING THE SPREADER

A.

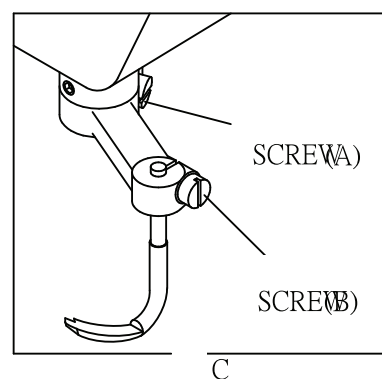
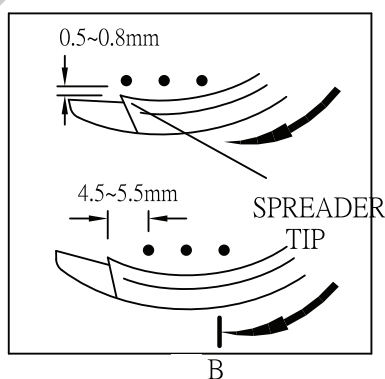
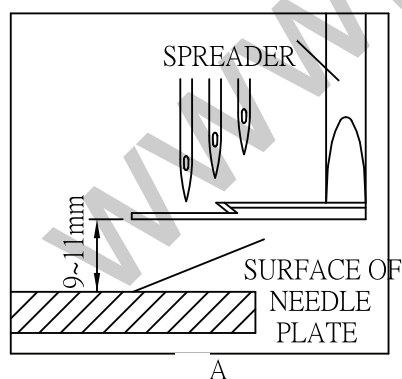
THE HEIGHT OF SPREADER IS 9-11 mm ABOVE THE SURFACE OF NEEDLE PLATE.

B.

WHEN SPREADER MOVES TO THE LEFT AND PASSES BEHIND THE LEFT NEEDLE, THE CLEARANCE IS 0.5- 0.8 mm. AND WHEN SPREADER REACHES THE EXTREME LEFT, THE DISTANCE BETWEEN TIP OF HOOKING BLADE AND THE CENTER OF LEFT NEEDLE IS 4.5-5.5 mm.

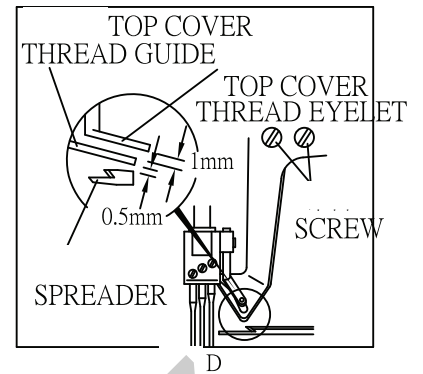
C.

THE ADJUSTMENTS ARE MADE BY LOOSENING SCREW (A) FOR THE HEIGHT OF LOOPER AND LOOSENING SCREW (B) FOR MOVING POSITION OF SPREADER LOOPER.



D.

THERE MUST HAVE A CLEARANCE OF 0.5 mm BETWEEN THE BOTTOM OF THE TOP COVER THREAD GUIDE AND SPREADER AND WHEN SPREADER COMES TO THE EXTREME RIGHT, AND AT THIS POSITION, THE THREAD IS CAUGHT BY THREAD HOOKING BLADE PROPERLY. AND HANGING LOOSELY ON THE TOP COVER THREAD GUIDE.



E.

WHEN NEEDLE BAR AT ITS LOWEST POSITION. THE CLEARANCE BETWEEN THE SURFACE OF TOP COVER THREAD GUIDE (A) AND THE UNDERNEATH OF TOP COVER THREAD EYELET (B) IS 1.0 mm. SET THE THREAD HOLE OF TOP COVER THREAD EYELET ON THE CENTER LINE OF THE SLOT OF TOP COVER THREAD GUIDE, THEN TIGHTEN SCREW.

