

PROCEDURE FOR CHANGING DRIVE BELT OR FLYWHEEL BEARINGS ON MODEL 485

1. POSITION CONNECTING ROD AND ECCENTRIC AS SHOWN IN DIAGRAM 8, REMOVE OIL CUP OR GREASE FITTING, REMOVE 1ST 5/16-18 SET SCREW THEN LOOSEN 2ND SET SCREW BELOW.
2. THROUGH ACCESS HOLE IN FLYWHEEL HUB, LOOSEN THE 2 - 1/4 - 28 SET SCREWS IN INNER RACE OF SL-15 FLYWHEEL BEARING WITH A LONG 1/8" ALLEN WRENCH.
3. MOVE REED SWITCH TO A SAFE LOCATION THEN PULL CRANKSHAFT OUT OF THE COUPLING AND THROUGH THE FLYWHEEL JUST FAR ENOUGH TO BE ABLE TO REMOVE THE FLYWHEEL. CAUTION! DO NOT ROTATE SHAFT OR HEAD DRIVE CAM WHILE SEPARATED FROM COUPLING.
4. REPLACE SL-15 BEARING, E-8 THRUST BEARING AND VEE-BELTS (INSTALL A SPARE BELT AND TIE-WRAP AWAY FROM MOVING PARTS) THE TURNING SIDE OF THRUST BEARING MUST FACE TOWARD FLYWHEEL.
5. REINSTALL SHAFT THROUGH BEARINGS AND INTO SQUARE COUPLING.
6. AT THIS TIME CHECK TO BE SURE THAT MACHINE IS PROPERLY TIMED AS FOLLOWS: WITH POWER ON, MOTOR OFF, PULL GATE ASSEMBLY BACK TO ENGAGE STITCH MODE THEN ROTATE FLYWHEEL CCW BY HAND. FEED ROLLS SHOULD STOP TURNING WHEN HEAD FORMERS ARE ABOUT 1" ABOVE LINE OF BOX TRAVEL.
7. PUSH SHAFT ALL THE WAY INTO COUPLING, THEN PUSH FLYWHEEL ASSEMBLY TIGHT UP AGAINST THROAT SURFACE. WHILE HOLDING IN THIS POSITION, TIGHTEN THE 2 FLYWHEEL BEARING SET SCREWS AND THE CONNECTING ROD ECCENTRIC SET SCREWS.
8. REINSTALL REED SWITCH AND POSITION AS SHOWN IN 485 PARTS CATALOG. PUSH RESET BUTTON ON 102 COUNTER TO SHIFT BACK TO HIGH SPEED MODE.
9. ADJUST VEE-BELT TENSION, TURN MOTOR ON, RELEASE WIRE FEED INTO HEAD THEN TRIP THROUGH A FEW CYCLES OF 5-10 STITCHES EACH. HEAD STOPPING POSITION SHOULD BE CHECKED TO BE SURE THAT FORMER SLIDE HAS JUST STARTED ON ITS DOWN STROKE, IF NOT, LOOSEN AND ROTATE MAGNET DISC TO A POSITION THAT WILL ATTAIN THIS CONDITION.