

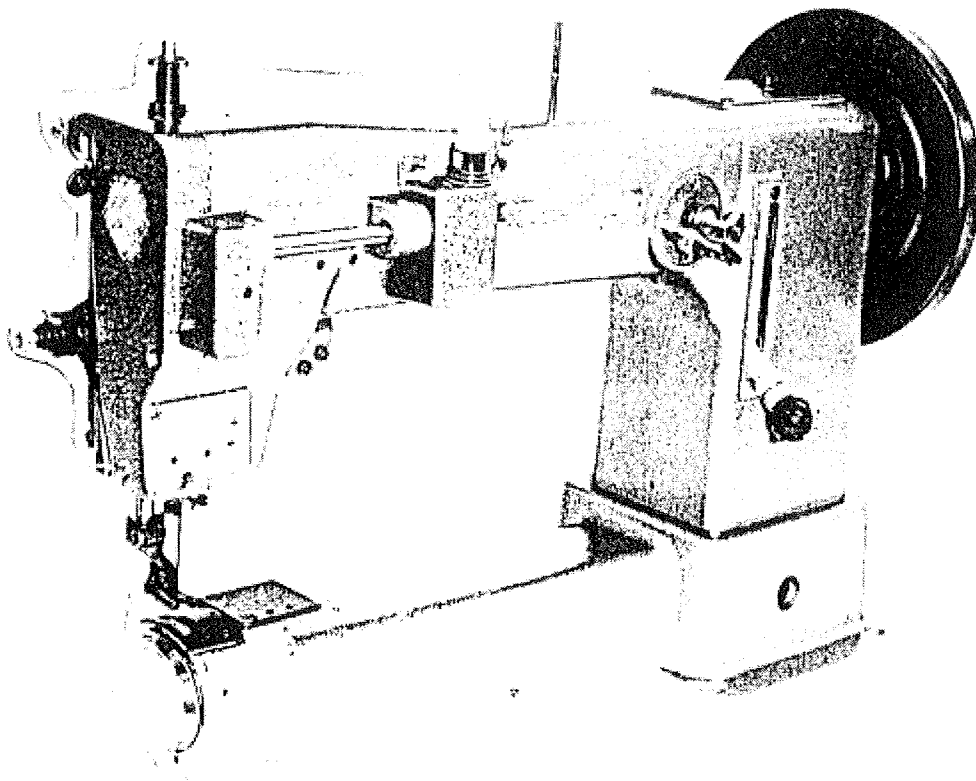
# **CONSEW<sup>®</sup>**

CONSOLIDATED SEWING MACHINE CORPORATION  
131 WEST 25<sup>TH</sup> STREET, NEW YORK, NY 10001

## **Model**

**751R, 752R, 754R, 756R**

**Long arm, cylinder bed, single needle, lockstitch machines  
For ultra heavy materials with oscillating large hook  
and reverse**



# Specifications of

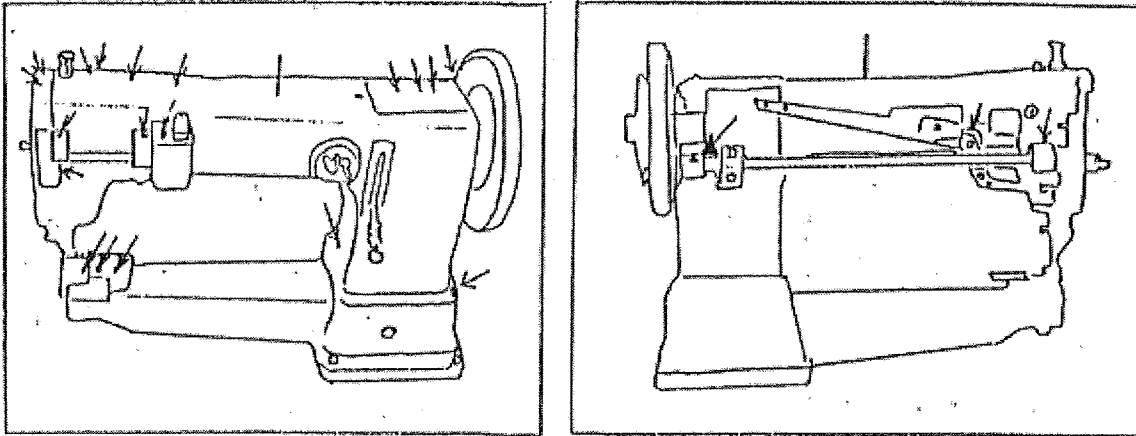
Sewing speed:	Max. 1,200 s.p.m. (Max. sewing speed will be changed by the models and applications)
Needle type:	DD x 1 # 22-25, Standard #24
Number of needle:	Single needle
Sewing type:	Lockstitch
Hook:	Oscillating large hook
Hobbin:	Type (24 $\phi$ x 30.3 width)
Thread:	Cotton or synthetic fiber
Feed system:	<ul style="list-style-type: none"> <li>{ 756R Needle, upper &amp; lower feed, reverse feed</li> <li>{ 754R Needle, lower feed, reverse feed</li> <li>{ 751R Lower feed, reverse feed</li> <li>{ 752R Upper &amp; lower feed, reverse feed</li> <li>{ Upper &amp; lower feed, reverse feed</li> <li>(Capable of intermediate shirring)</li> </ul>
Stitch length:	Max. 10mm
Presser foot:	<ul style="list-style-type: none"> <li>( 756R Alternating foot (walking foot &amp; presser foot)</li> <li>{ 754R Flat bed</li> <li>{ 751R Roller foot or flat bed</li> <li>{ 752R Alternating foot (walking foot &amp; presser foot)</li> <li>( - ditto -</li> </ul>
Presser lift:	20mm by knee lifter (10mm by lever)
Thread take-up:	Cam type
Thread take-up stroke:	90.5mm
Needle bar stroke:	51mm
Bed shape:	Cylinder bed (tubular type 82 $\phi$ )
Bed size:	82 $\phi$ x 600mm
Working space:	200mm x 400mm
Net weight (head only):	65Kg
JIS classifications:	LS 3
Motor:	400W. 4P clutch motor
Motor pully:	60 $\phi$ (50HZ) 50 $\phi$ (60HZ)
V Belt:	M62
Applications:	Suitable for sewing of shoes, bags, satchels, sport-goods, luggages, ultra heavy materials.

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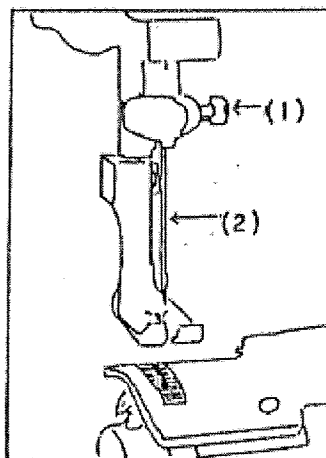
## 1 Lubrication

Lubricate all points indicated by arrows in figure.



## 2 Needle

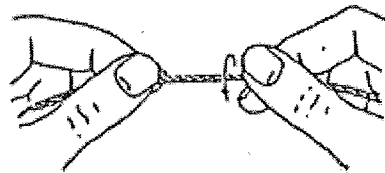
Turn the balance wheel over toward you until the needle bar reaches its highest point. Loosen the needle clamp screw(1). Hold and insert the needle(2) into the needle bar hole up as deeply as it will go, keeping the long groove of the needle to the left and eye of the needle in line with machine arm directly. Securely tighten it with needle clamp screw(1).



### 3 Thread

For needle (Upper thread) use left-twisted thread only, and for bobbin (Lower thread) use either left or right twisted thread.

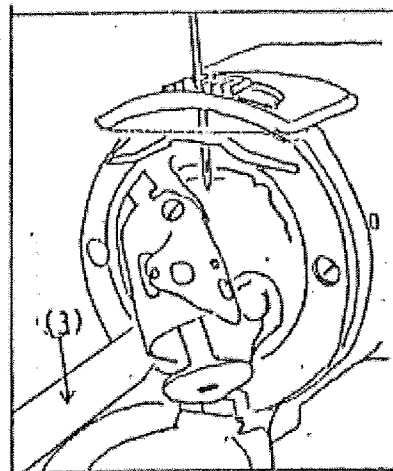
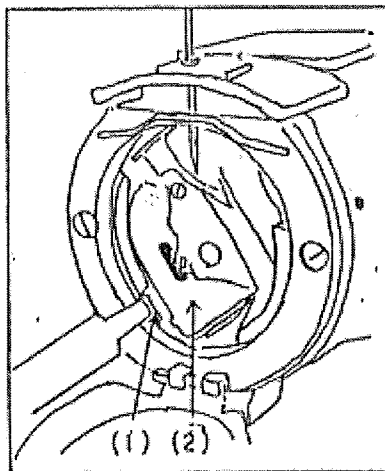
To find out thread twist, hold the thread as shown by illustration, and turn the thread over toward you between the thumb and forefinger of right hand, and then left-twisted thread will wind tighter strands, and right-twisted thread will unwind.



### 4 Insertion and Removal of Bobbin

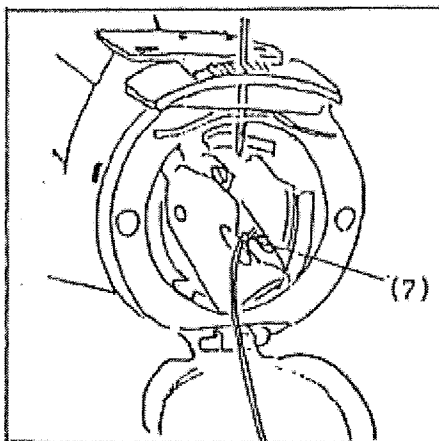
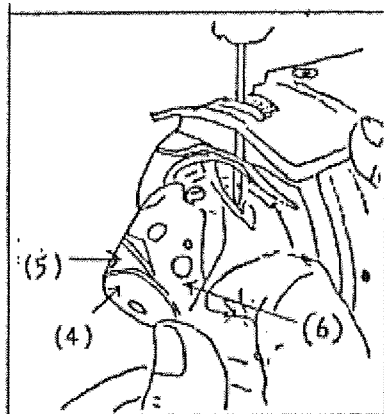
#### § Removal of Bobbin

Open the hook cover and drop-down the needle bar at lowest point, then insert the opener(3) between the snap spring(1) and bobbin case(2) and depress the snap spring and pull up the bobbin case outward, then take the bobbin out of the bobbin case.



## § Insertion of Bobbin

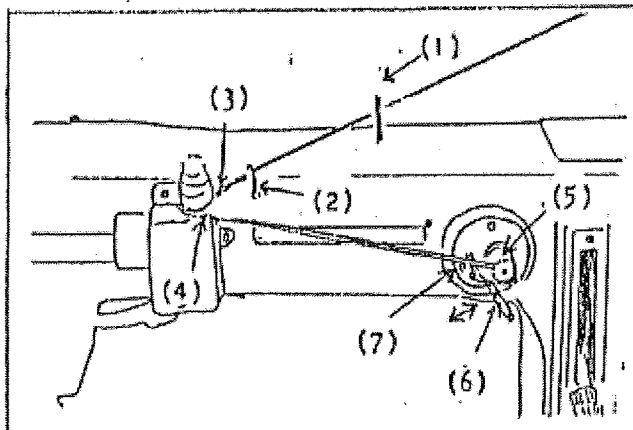
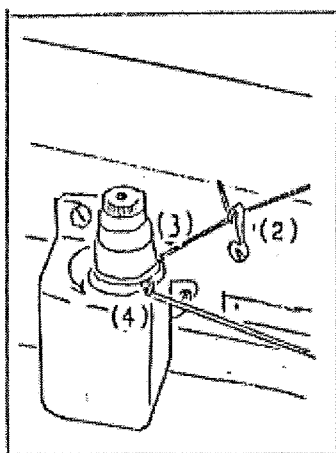
When inserting, pull out the thread and depress it, then insert the bobbin(4) in the bobbin case(5). Pull the thread upward passing through the thread slit(7) of the bobbin case. You can pull out the thread through the thread passing hole through underneath the tension spring(6). Make sure that the snap spring in the shuttle is clicked after pressing bobbin case into the shuttle.



## 5 Winding the Bobbin Thread

Bobbin winding should be made by the following order.

(1) Spool pin — (2) Thread guide (arm) — (3) Needle thread tension thread guide — passing through the clearance between two tension discs — (4) Needle thread tension thread guide (5) Bobbin (winding several times) — (6) Move the bobbin winding lever.

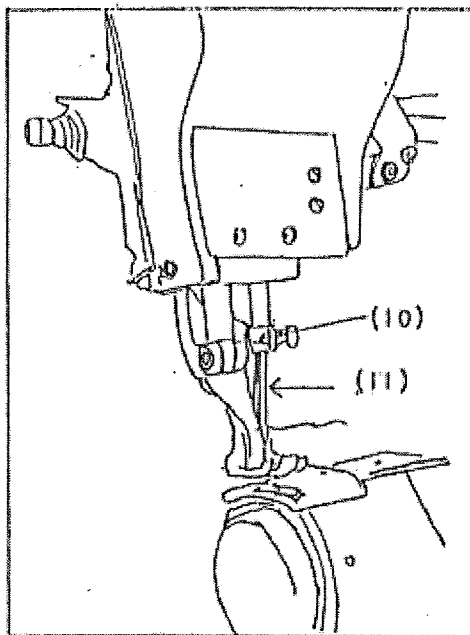
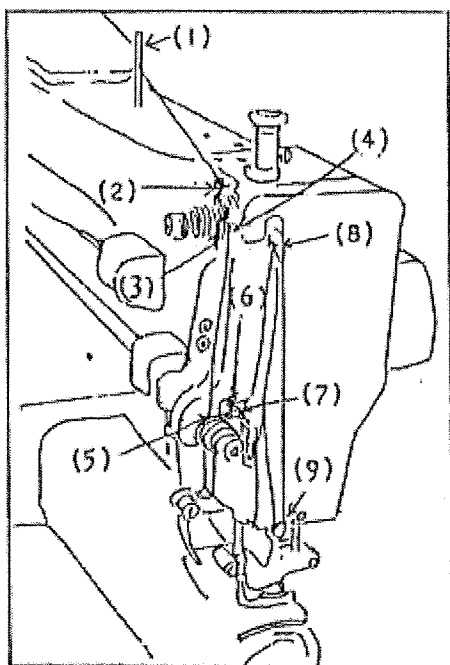


Winding volume should be adjusted by the screw(7) and positioning of the moving the lever(6).

## Upper Threading

Upper threading should be made by the following order.

- (1) Spool pin — (2) Thread guide of thread tension — (3) Clearance of two tension discs — (4) Thread guide of thread tension
- (5) Thread controller disc — (6) Thread guide — (7) Tension spring — (8) Thread take-up — (9) Thread guide, face plate
- (10) Needle cramp — (11) Needle



## 7 Tension of Bobbin Thread and Needle Thread



(A) Balanced tension

- (A) When stitch tension is well balanced, the bobbin thread is engaged with the needle thread at the center of given material thickness, as shown by Fig. (A)



(B) Tight needle or loose bobbin thread tension

- (B) Fig. (B) shows unbalanced tension, tight needle thread or loose bobbin thread.



(C) Loose needle or tight bobbin thread tension

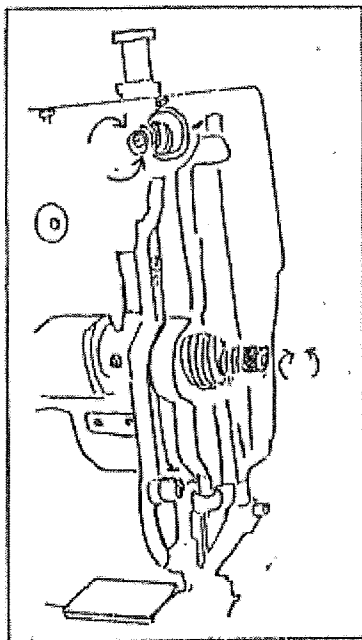
- (C) Fig. (C) shows unbalanced tension, loose needle thread or tight bobbin thread.

## § Adjusting Needle Thread Tension

To adjust tension of needle thread,  
turn Tension Regulating Thumb.

By turning the knurling nut clockwise ↻ ,  
needle thread tension increases.

By turning the knurling nut counter-clockwise ↺ ,  
needle thread tension decreases.

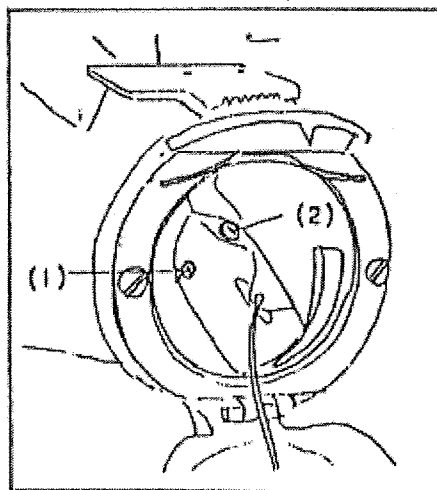


## § Adjusting Bobbin Thread Tension

To adjust tension of the bobbin thread,  
turn Tension Regulating Screw.

By loosen set screw(1) and adjusting  
tension regulating screw(2).  
The set screw(1) should exactly be  
tightened after tension of the bobbin  
thread was adjusted.

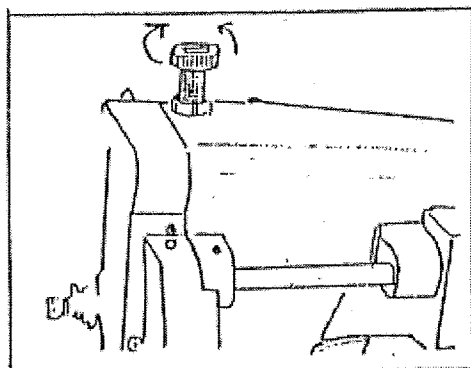
By turning the set screw clockwise ↻ ,  
bobbin thread tension increases, and  
turning the set screw counter-clockwise  
↺ , bobbin thread tension decreases.





## 8 Pressure of Presser Foot

By turning the pressure regulating thumb screw clockwise ↻, pressure increases, and turning pressure regulating thumb screw counter-clockwise ↺, pressure decreases. Tension regulating nut should be tightened after pressure was adjusted. adjustment should be made to suit for the materials being sewn.

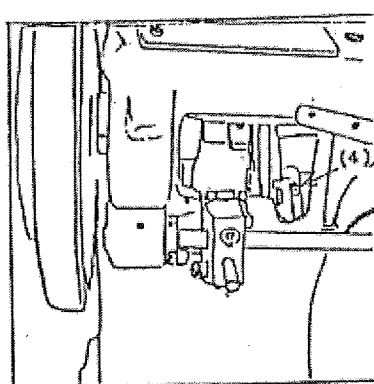
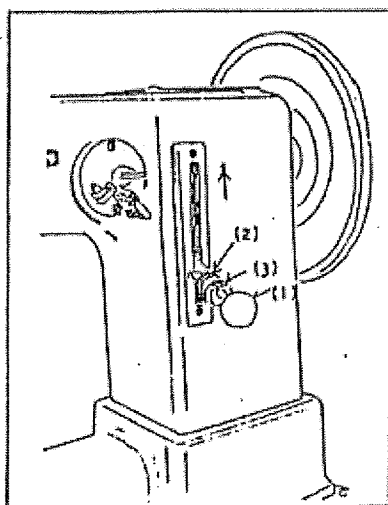


## 9 Adjustment of Stitch Length

By pull-up ↑ feed regulating lever(1), reverse stitch is performed, and push-down ↓ feed regulating lever(1), forward stitch is performed.

By turning knurling nut(2) & (3) clockwise ↻, feed length decreases, and turning knurling nut (2) & (3) counter-clockwise ↺, feed length increases.

Knurling nut(2) & (3) should be tightened each other after desired stitch length was determined.

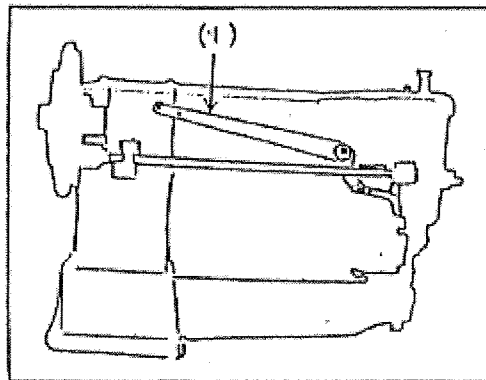


### (Note)

When upward & downward moving of the feed regulating lever is loosened, feed adjusting screw(4) should be tightened.

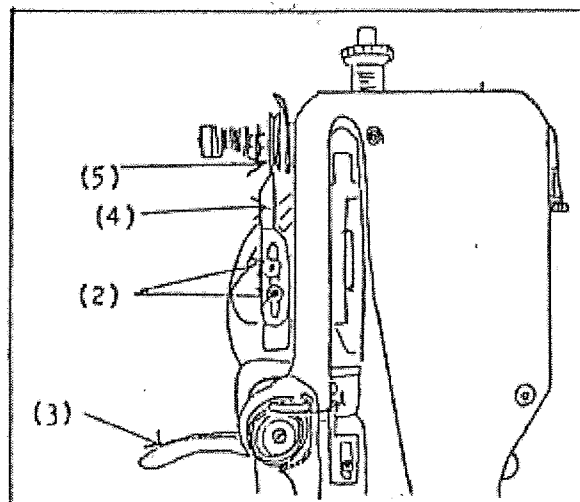
10 Timing of Thread Tension Releasing Mechanism

- (a) When moving the lifting lever(1) for knee lifter, upper thread is adjusted to loosen.



(b) Adjustment

Pull-up the presser bar lifter(3), clearance should be made over 1mm between tip of the tension releasing plate and tension disc, and then tighten the screws(2) on the tension releasing plate.

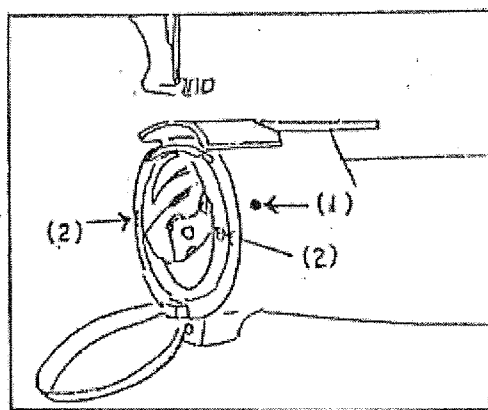


## 11 Removal of Shuttle Race Body

Tighten the shuttle race back spring screw(1), then loosen and take off the two shuttle race screws(2) and remove the shuttle race body and shuttle hook.

(Note)

In case of the removal of shuttle race body, without tightening of shuttle race back spring screw(1), shuttle race back and shuttle race back spring may run out and/or may difficult to set the shuttle race body. The shuttle race back spring screw(1) is surely loosened, while the materials are being sewn.



## 12 Adjusting on the Each Points

### (A) Adjusting Needle Position Against Needle Hole of the Feed Dog.

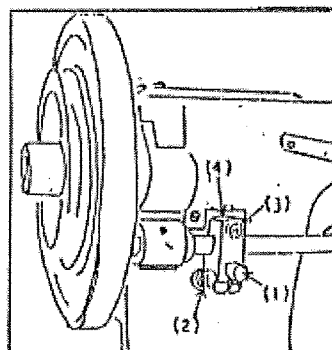
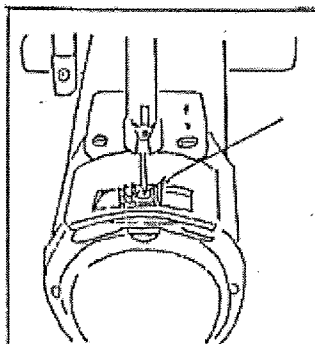
Dog. (

Needle should be positioned at the center of needle hole of feed dog and moved together with the feed dog.

(a) Loosen feed (upper) shaft connecting screw(2), upper feed length will differ by the moving (push-in or pull out) of feed (upper) shaft connector(B)(1),

(b) Loosen feed (upper) shaft connector(A)screw(3), and needle set at the center of needle hole of feed dog, then, tighten the screw(3).

(Needle dropping point is to be set at the center of needle hole of the feed dog.)



(Note)

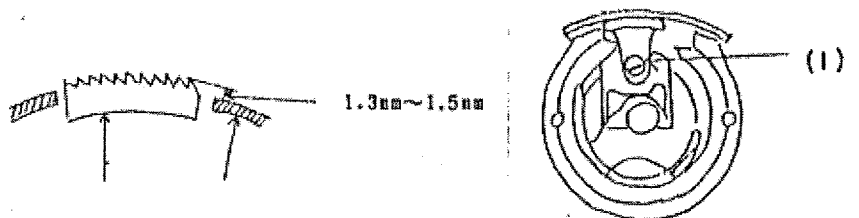
Feed (upper) shaft connector(A)(4) is fixed and the screw(3) is tightened for the prevention of the moving of leftward and rightward.

(B) Adjusting of Feed Dog Height

Taking off the needle in  
The height of feed dog is adjusted 1.3mm - 1.5mm  
above the surface of the throat plate, at the  
lowest point of needle bar by feed dog height  
adjustable screw(1).

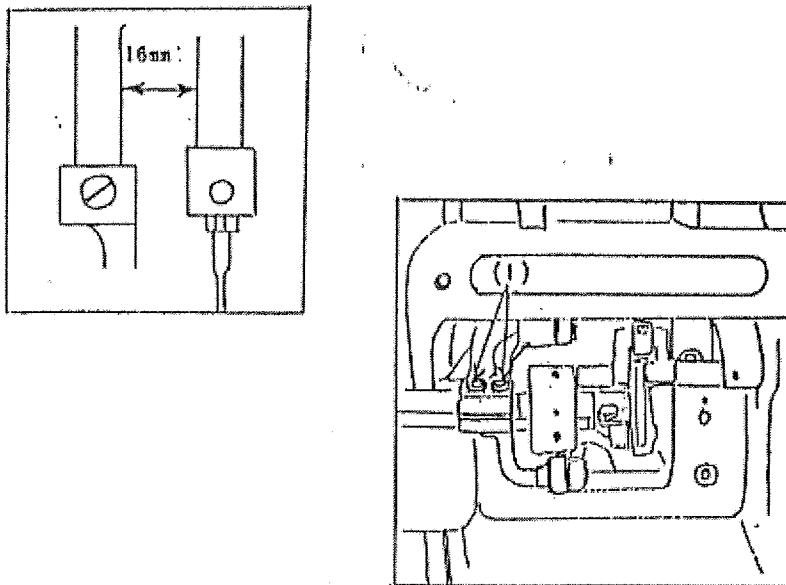
In  
The height of feed dog is adjusted 1.3mm - 1.5mm  
above the surface of the throat plate at the  
lowest point of needle bar.

Refer to Removal of Shuttle Race Body



(C) Adjusting the Forward and Backward Position of  
Needle Bar Frame

Correct position between needle bar frame and  
presser bar is determined by the distance  
between presser bar and needle bar being 16mm  
under the stitch length being "0"mm.

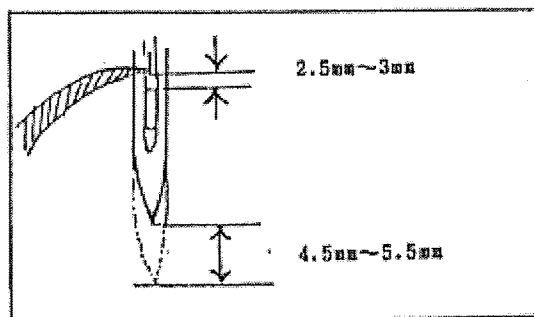


Adjustment of the clearance between presser  
bar and needle bar is to be made by the screws(1).

(D) Timing of Needle and Hook

Positioning of needle and tip of the hook

When the needle bar has risen 4.5mm - 5.5mm from its lowest position, the tip of the hook should meet the center line of the needle.



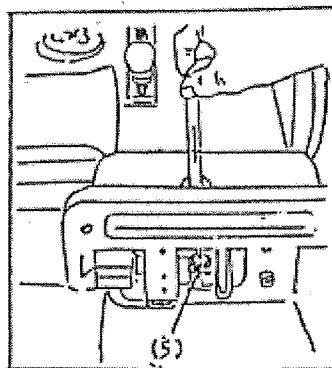
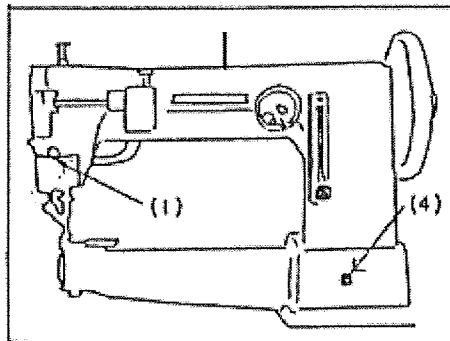
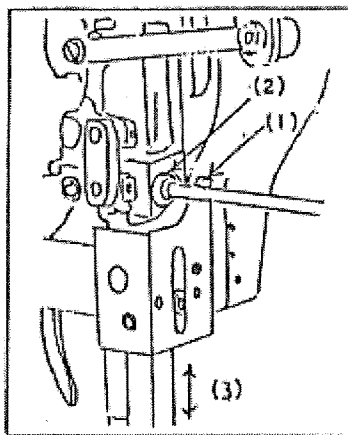
Distance between the upper tip of the needle-eye and the tip of the hook shall be 2.5mm - 3mm.

Adjusting the height of needle bar

Loosen the screw of needle bar connecting stud(2) by wrench which inserts to the hole(1) of arm and adjust the needle bar(3) upward and downward.

Adjusting the position of the tip of hook

Loosen the screw(5) of the shaft crank by the spanner which inserts to the hole(4) of the head, then determine the forwardness or backwardness (high speed or low speed) of the tip of hook. Tighten the screw(5) after adjustment.



Clearance between needle and tip of hook: 0.05mm - 0.3mm

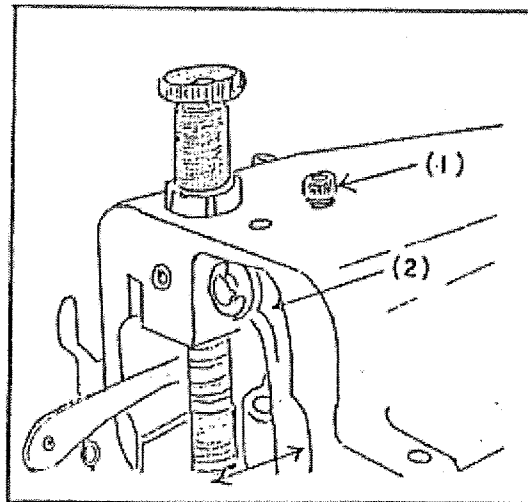
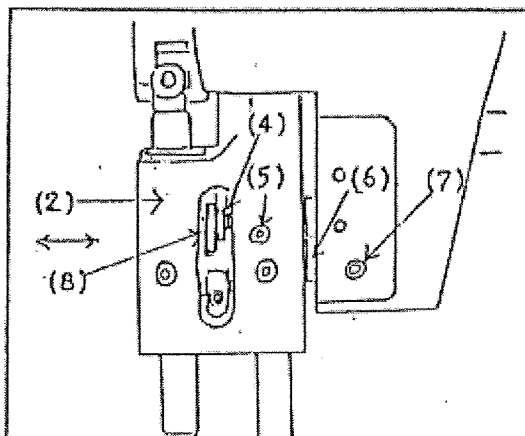
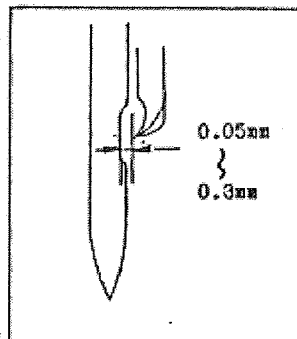
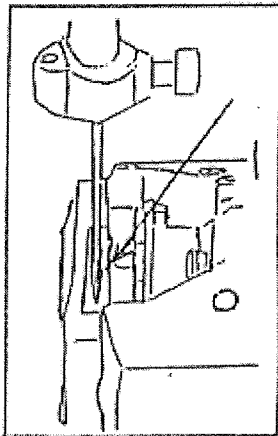
In & types: Determination of the position of needle bar rock frame.

Loosen the set screw(1) of the needle bar rock frame hinge stud, and the set screw(5) of the needle bar rock frame hinge stud(small) (4) positioned lower part of needle bar rock frame(2), and also the set screw(7) of the needle bar rock frame hinge stud(large)(6). Then, moving the needle bar rock frame hinge stud(large)(6) to rightward→, and also moving the needle bar rock frame leftward & rightward↔, and turn the balance wheel, determines smooth position of the needle bar and adjust the clearance between needle and tip of the hook.

After determination of the clearance, tighten the set screw(2) of the needle bar rock frame hinge stud, and then put the needle bar rock frame hinge stud(small)(4) to slightly the needle bar rock frame position bracket(8).

And, put the needle bar rock frame hinge stud(large)(6) to the side face of the needle bar rock frame(2), and then turn the balance wheel and tighten the each screws exactly.

If the looseness of the leftward & rightward↔ of the needle bar should happen, it will be resulted in the breaking of needle, stitch skipping.



Each timing for up/down strokes of presser foot

(

- a. Loosen and take off the cover screws(1), timing of walking foot is adjusted walking foot reach to feed dog before needle-eye reaches to feed dog, after downing the lever of presser bar lifter, turning the balance wheel toward you.

Adjustment is made by the two stopper screws of cam(2) (upward & downward).

By up & down the presser cam (upward & downward)  $\uparrow\downarrow$ , walking foot against needle is touching to feed dog speedily and slowly.

As for type, adjusting feed dog and presser foot to set equivalent point on the upper face of the throat plate.

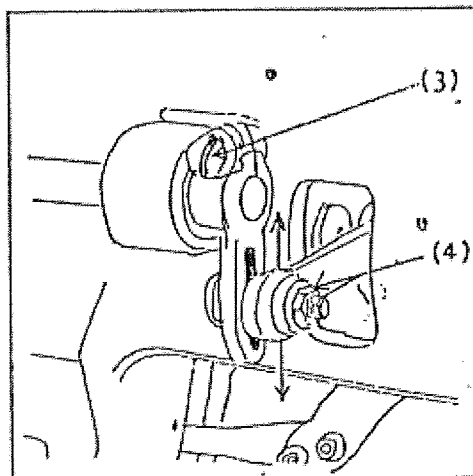
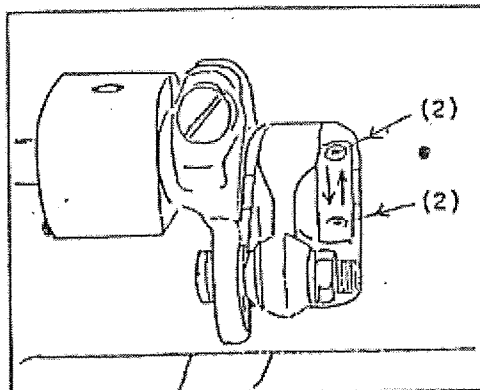
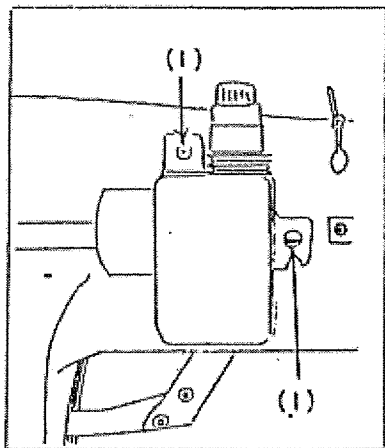
- b. For the setting walking foot and presser foot equivalent, the lifting eccentric connection crank pinch screw(3) is to be adjusted.

Adjustment is to be made by the materials being sewn.

- c. Up/down strokes of walking foot and presser foot is loosened by the screw(4)

Up  $\uparrow$  the screw(4), the stroke increases.

Down  $\downarrow$  the screw(4), the stroke decreases.



a. Use of the Differential Feed Mechanism

Pull-down the chain(1), upper feed volume increases by maximum 80% against lower feed volume

Pull-down the chain(1), upper feed length increases by maximum 80% against lower feed length.  
(e.g., Lower feed:10mm, Upper feed:18mm)

Adjusting Upper Feed Length

Turn the dial(2) clockwise ↻, upper feed length decreases.

Turn the dial(2) counter-clockwise ↺, upper feed length increases.

Fixed position of feed length is adjusted by stopper(3) and stopper nut(4)

b. Adjusting Upper Feed Length Against Lower Feed Length

For adjusting equivalent the upper feed length against lower feed length.

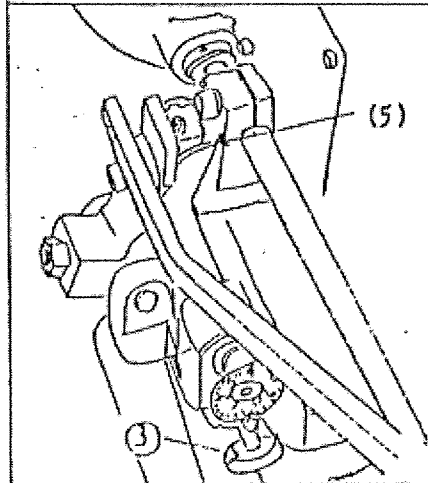
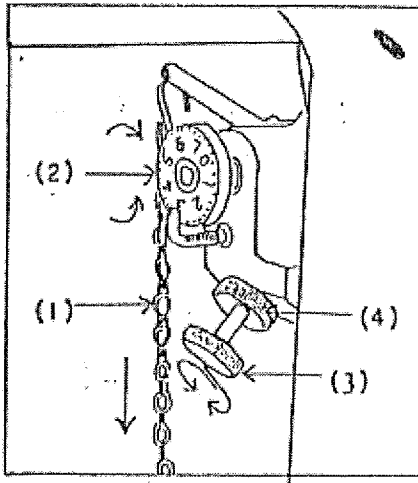
Adjustment is to be made by the stopper screw(3) and stopper nut(4).

Turn the stopper screw(3) clockwise ↻, upper feed length increases.

Turn the stopper screw(3) counter-clockwise ↺, upper feed length decreases.

(Note)

Over turning of stopper screw(3) & stopper nut(4) counter-clockwise will cause the troubles that the top of feed adjusting lever touch with the feed upper shaft connector





# **Consolidated Sewing Machine Corp.**

**website: [www.consew.com](http://www.consew.com)**

## **MAIN office**

131 W. 25th Street  
New York, NY 10001  
Tel: 212-741-7788  
Fax: 212-741-7787

## **Miami, FL**

4013 NW 79th Avenue  
Miami, FL 33166  
Tel: 305-471-0200  
Fax: 305-471-0243

## **Los Angeles, CA**

2320 South Hill Street  
Los Angeles, CA 90007  
Tel: 213-745-8844  
Fax: 213-745-8855