

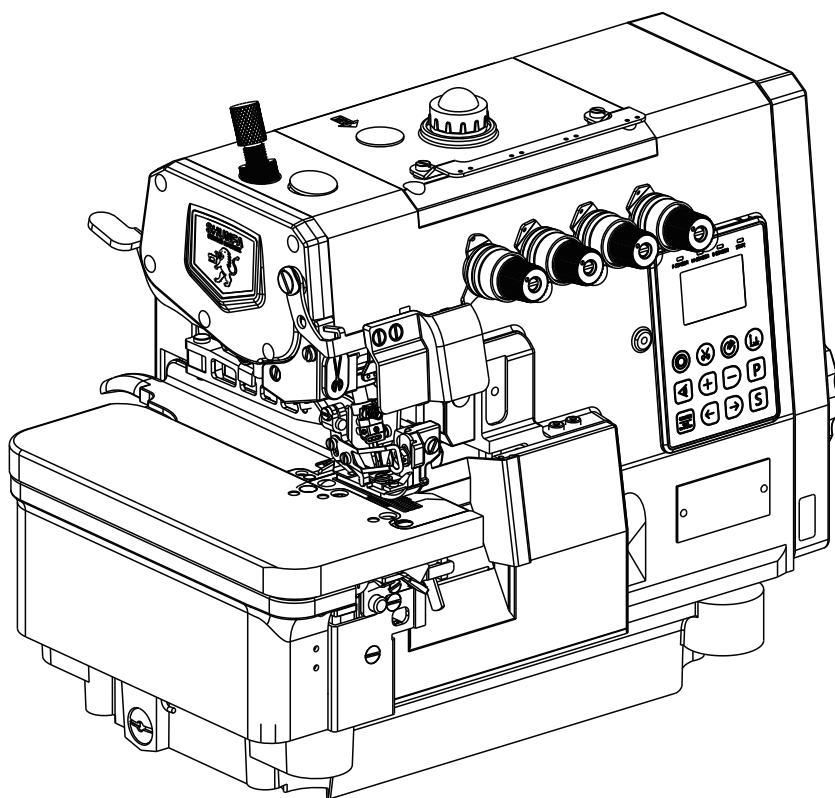
# ALFA

## INSTRUCTION MANUAL

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### HIGH-SPEED OVERLOCK SEWING MACHINE

- **A1950**
- **A1955**



# IMPORTANT SAFETY INSTRUCTIONS

To get the most out of the many functions of this machine and operate it in safety, it is necessary to use this machine correctly. Please read this Instruction Manual carefully before use. We hope you will enjoy the use of your machine for a long time. Please remember to keep this manual in a safe place.

1. Observe the basic safety measures, including, but not limited to the following ones, whenever you use the machine.
2. Read all the instructions, including, but not limited to this Instruction Manual before you use the machine, in addition, keep this Instruction Manual so that you may read it at any-time when necessary.
3. Use the machine after it has been ascertained that it conforms with safety rules/standards valid in your country.
4. All safety devices must be in position when the machine is ready for work or in operation. The operation without the specified safety devices is not allowed.
5. This machine shall be operated by appropriately-trained operators.
6. For your personal protection, we recommend that you wear safety glasses.
7. For the following, turn off the power switch or disconnect the power plug of the machine from the receptacle.
  - 7-1 For threading needle(s) and replacing bobbin.
  - 7-2 For replacing part(s) of needle, presser foot, throat plate, feed dog, cloth guide etc.
  - 7-3 For repair work.
  - 7-4 For when leaving the working place or when the working place is unattended.
8. If you should allow oil, grease, etc. used with the machine and devices to come in contact with your eyes or skin or swallow any of such liquid by mistake, immediately wash the contacted areas and consult a medical doctor.
9. Tampering with the live parts and devices, regardless of whether the machine is powered, is prohibited.
10. Repairing, reforming and adjustment works must only be done by appropriately trained technicians or specially skilled personnel.
11. General maintenance and inspection works have to be done by appropriately trained personnel.
12. Repair and maintenance works of electrical components shall be conducted by qualified electric technicians or under the audit and guidance of specially skilled personnel. Whenever you find a failure of any of electrical components, immediately stop the machine.
13. Periodically clean the machine throughout the period of use.
14. Grounding the machine is always necessary for the normal operation of the machine. The machine has to be operated in an environment that is free from strong noise sources such as high-frequency welder.
15. An appropriate power plug has to be attached to the machine by electric technicians, Power plug has to be connected to grounded receptacle.
16. Remodel or modify the machine in accordance with the safety rules/standards while taking all the effective safety measures. We assume no responsibility for damage caused by reforming or modification of the machine.
17. The machine is only allowed to be used for the purpose intended. Other uses are not allowed.
18. Warning hints are marked with the two shown symbols.



Danger of injury to operator or service staff



Items requiring special attention

**ALFA**

# FOR SAFE OPERATION



1. To avoid electrical shock hazards, neither open the cover of the electrical box for the motor nor touch the components mounted inside the electrical box.



1. To avoid personal injury, never operate the machine with any of the belt cover, finger guard of safety devices removed.
2. To prevent possible personal injuries caused by being caught in the machine. Keep your fingers, head and clothes away from the handwheel, cover and the motor while the machine is in operation. In addition, place nothing around them.
3. To avoid personal injury, never put your hand under the needle when you turn ON the power switch or operate the machine.
4. To avoid personal injury, never put your fingers into the thread take-up cover while the machine is in operation.
5. The hook rotates at a high speed while the machine is in operation. To prevent possible injury to hands, be sure to keep your hands away from the vicinity of the hook during operation. In addition, be sure to turn OFF the power to the machine when replacing the bobbin.
6. To avoid possible personal injuries, be careful not to allow your fingers in the machine when tiling/raising the machine head.
7. To avoid possible accidents because of abrupt start of the machine, turn OFF the power to the machine when tiling the machine head.
8. If your machine is equipped with a serve-motor, the motor does not produce noise while the machine is at rest. To avoid possible accidents due to abrupt start of the machine, be sure to turn OFF the power to the machine.
9. To prevent possible accidents because of electric shock or damaged electrical component(s), turn OFF the power switch in prior to the connection /disconnection of the power plug.

## Precautions Prior to Startup

1. The machine head is coated with a thick layer of rust-prevention grease before encasement, and the encased machine head may possibly be subjected to grease hardening and dust buildup on the machine surface in process of long storage and long-haul traffic; therefore, take care to remove the grease and dust from the surface using soft cloth and gasoline.
2. Though the machine was inspected and tested with care before factory leaving, it might be affected by violent vibration resulting in looseness or distortion of the machine parts; therefore the operator shall thoroughly check the machine, turn the upper wheel by hand and check it for difficulty in free rotation, slight impact, and other uneven resisting force or abnormal noises, and make appropriate adjustment if any to restore the machine state before formal trial run.
3. Never start up the machine if the oil liquid level in the oil box falls outside the normal range.
4. The upper wheel shall rotate counterclockwise (when it is viewed from the lateral surface of the upper wheel) when the machine is operating.
5. Check whether the voltage and phases indicated on the electric-control data plate are correct.
6. The date of manufacture is indicated on the certificate of conformity.

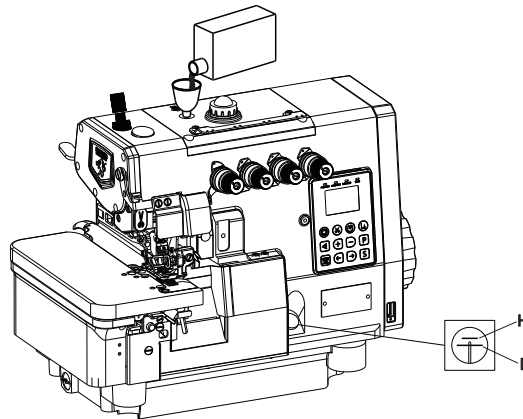
## Precautions for Use

1. Never touch the needle by hand when the machine is powered on or while it is operating.
2. Never put your finger into the protection cover of take-up lever during operation of the machine.
3. The operator must not put his finger into the needle guard bracket when he feeds the sewing materials by hand.
4. Operator must trim off the electricity supply before he turns over the machine head or removes the hand cover.
5. The operator must trim off the electricity supply before he gets away from the machine.
6. Prohibit the head, hands and anything to approach the upper wheel and bobbin winder while the machine is operating.
7. Never remove or mount the protection cover or other protection devices before the machine is stopped.
8. Never wipe up the surface of machine head using paint thinner such as acetone.

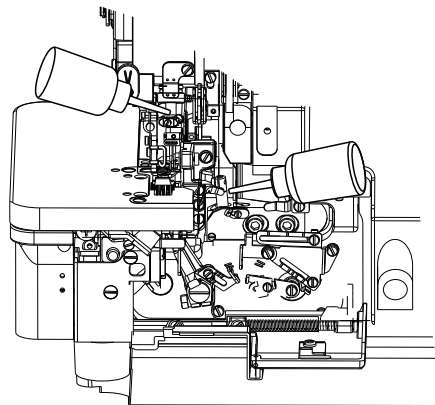
# Oil supply



After filling the oil pan , the top of the indicator should be between (H) and (L) lines.  
Add oil , when the oil level indicator reaches or goes below (L).

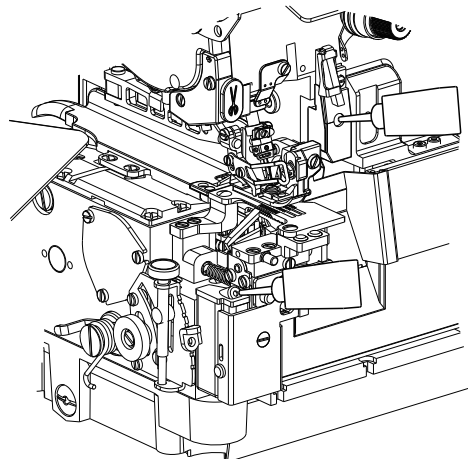


Apply 2 or 3 drops of oil by hand when the machine is used for the first time or has been left unused for some time.

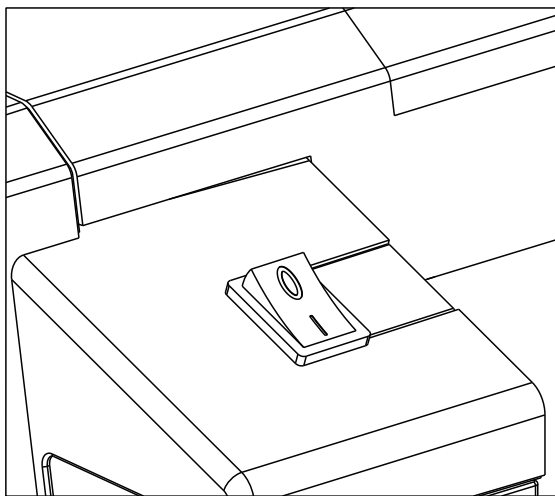


Fill the HR device with oil before it is too low in order to prevent needle breakage and fabric damage.

Note : Use Pegasus recommended silicon oil .  
(union carbide corporation)

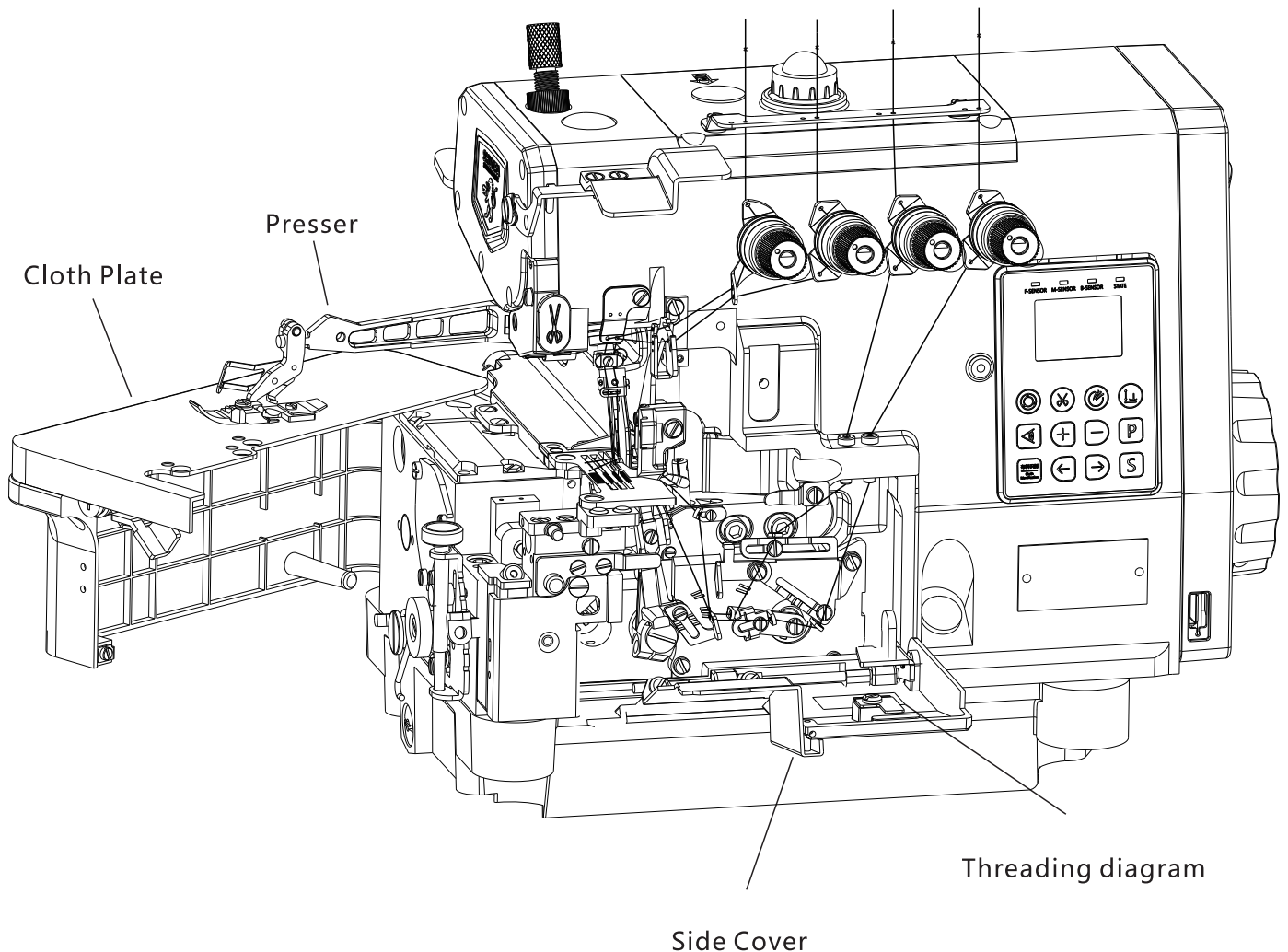


1. Though Our takes the utmost care to produce safe sewing machines and devices , operation should follow these basic safety rules.
2. To prevent accidents ,do not remove safety devices or parts while operating the machine.
3. Do not leave tools or other or other unnecessary objects on the machine table while operating the machine.
4. Before maintenance , adjusting ,cleaning , threading or replacing the needle , and to prevent accidents , be sure the power is turned off . Check that the machine will not operate when the pedal is pressed .
5. Turn the power off before leaving the machine table .
6. In the event of a power failure , be sure to turn the machine off .
7. Check that the machine is securely .



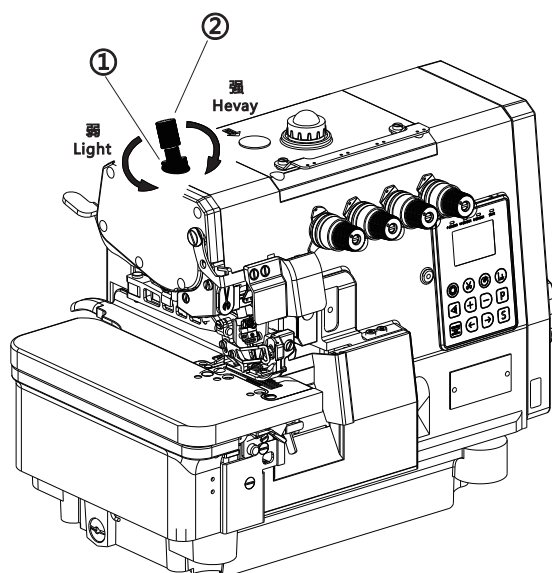
# Threading

1. Open three covers.  
Presser, Cloth Plate, Side Cover
2. Knot the preset thread and the thread being used together to thread the machine.
3. Trim the knots off neatly before passing through the eye of the needle to rethread.
4. Trim the knots off neatly after passing through the eye of the looper.
5. Make sure the machine is threaded correctly by referring to the threading diagram.



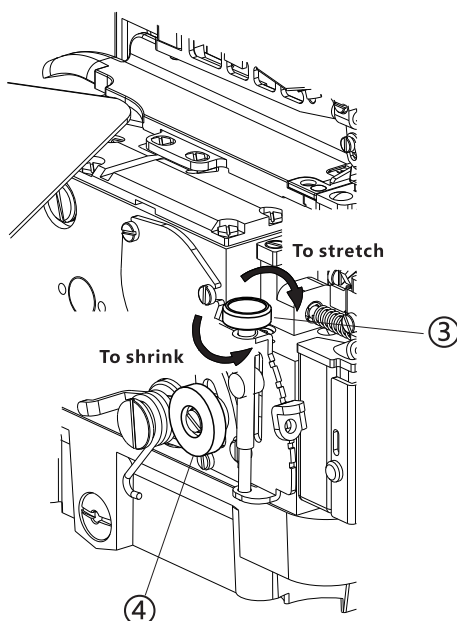
## Adjusting the presser foot pressure

Loosen adjusting nut ① and turn adjusting nut ② to adjust the presser foot. It should be as light as possible, yet be sufficient to obtain the proper stitch formation.



## Adjusting the diff

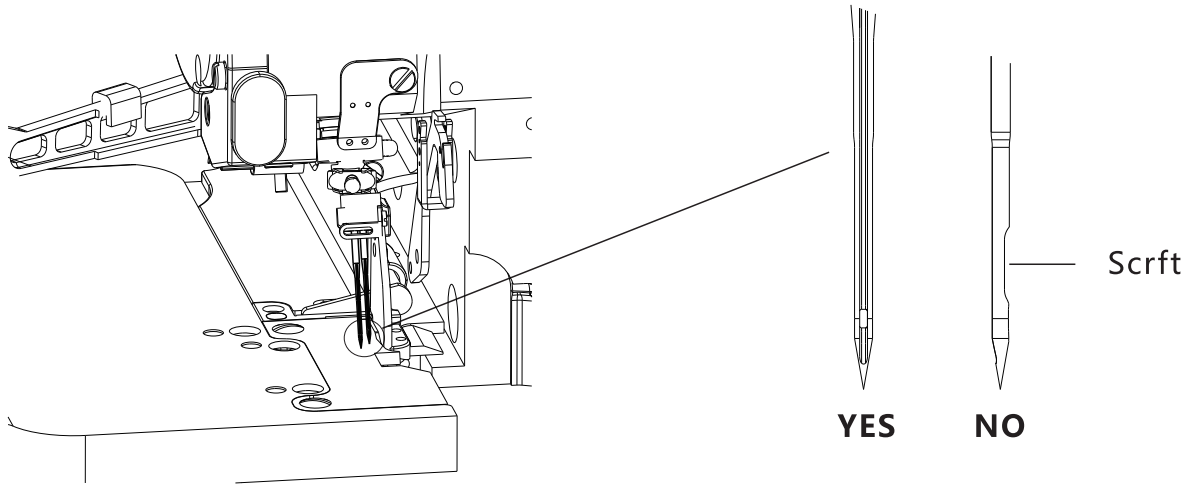
Loosen the adjusting nut ③ and turn the adjusting nut ④ to adjust the differential feed ratio.



## Replacing the needle

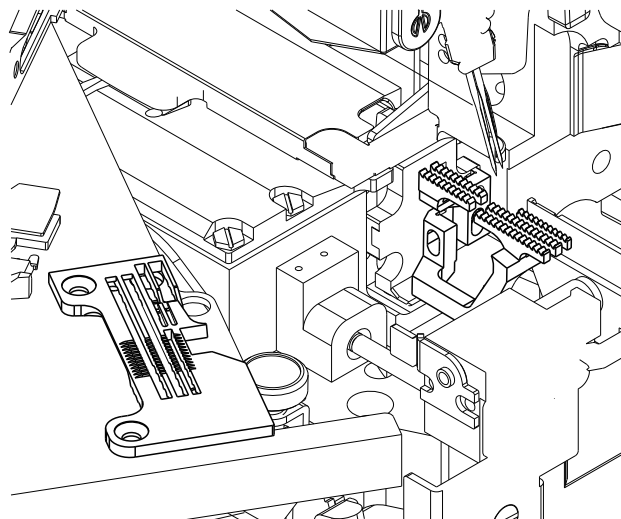
Check the needle carefully to see that the scarf is turned to the rear of the machine .

Insert the needle to the proper depth , and fasten securely .



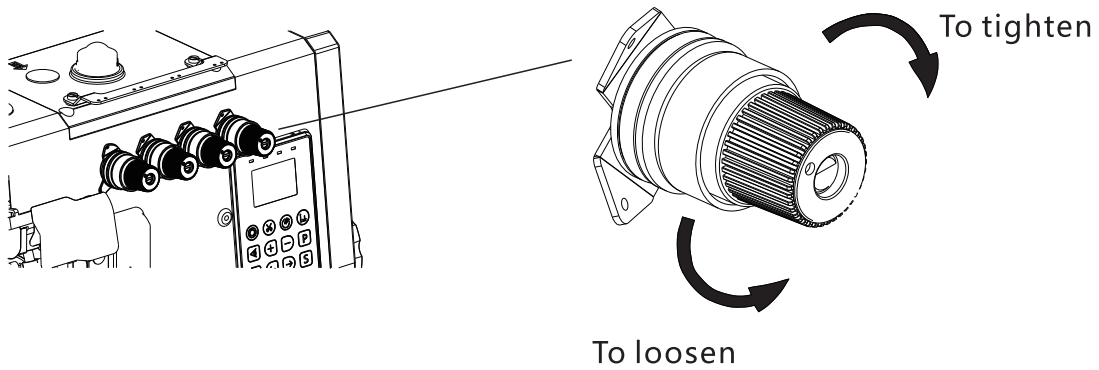
## Cleaning the machine

Mainly the slots of the needle plate and the feed rows should be cleaned .



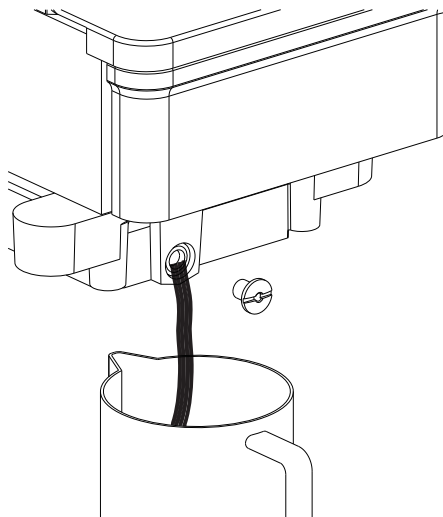
## Adjusting the thread tension

Please adjust the tension state of the wire using the wire clamp component .



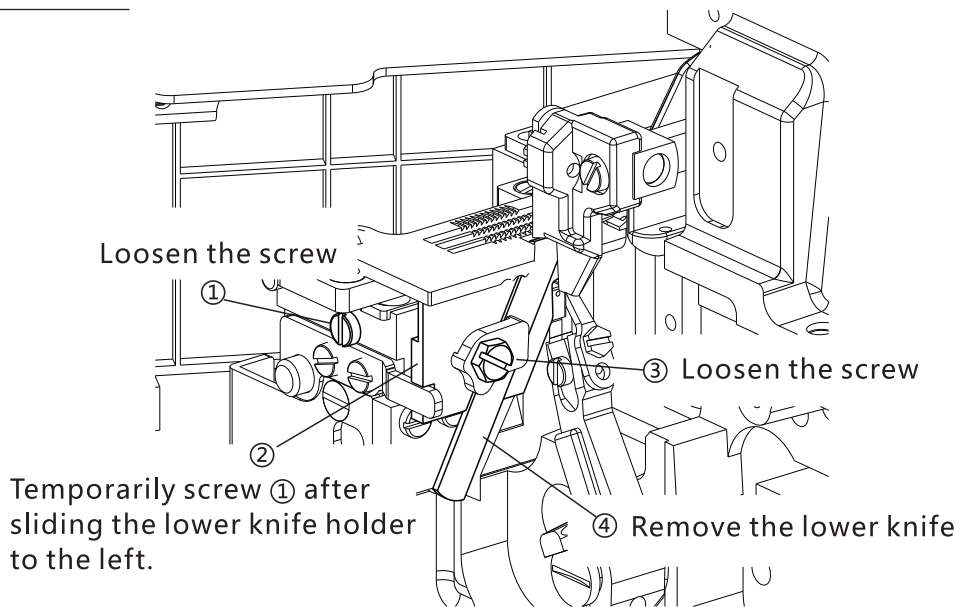
## Replacing the oil

Replacing the oil one month after the first use and every six months thereafter . (See P6)



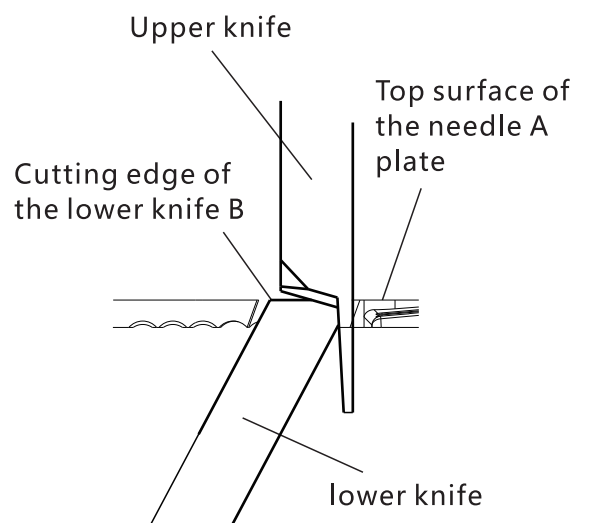
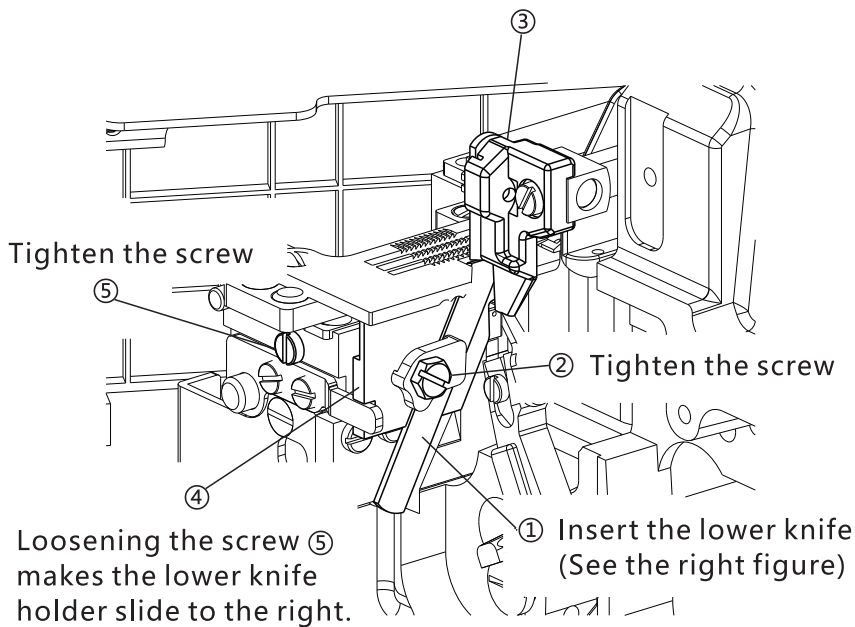
# Replacing the lower knife

- To remove the lower knife



- To replace the lower knife

Turn the handwheel as the drawing on the right figure



Level of A = level of B

- Check cutting action of knife