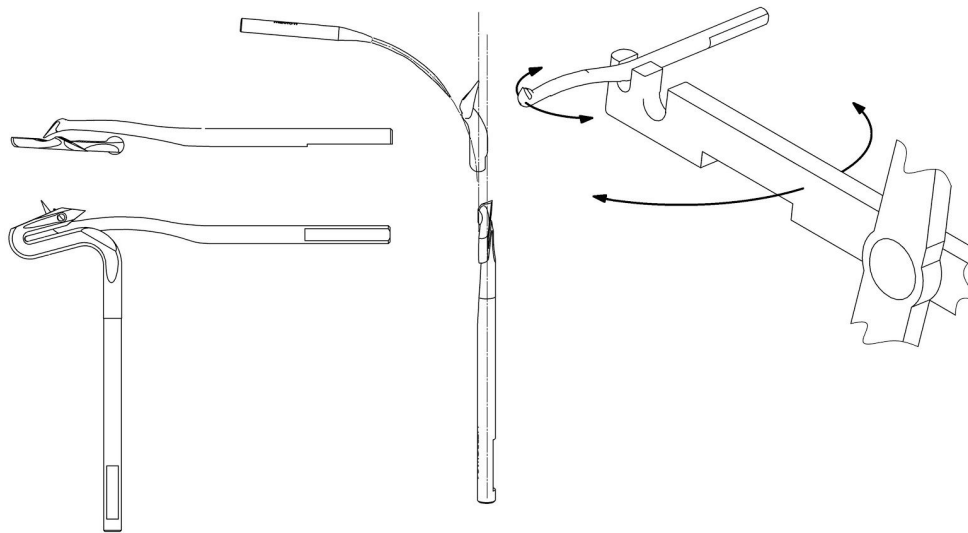


MERROW®

INSTRUCTIONS

For Setting and Bending Genuine Merrow Loopers

LOOPER BENDING



Merrow Sewing Machine Company, Inc.

502 Bedford Street, Fall River, Massachusetts 02720 USA

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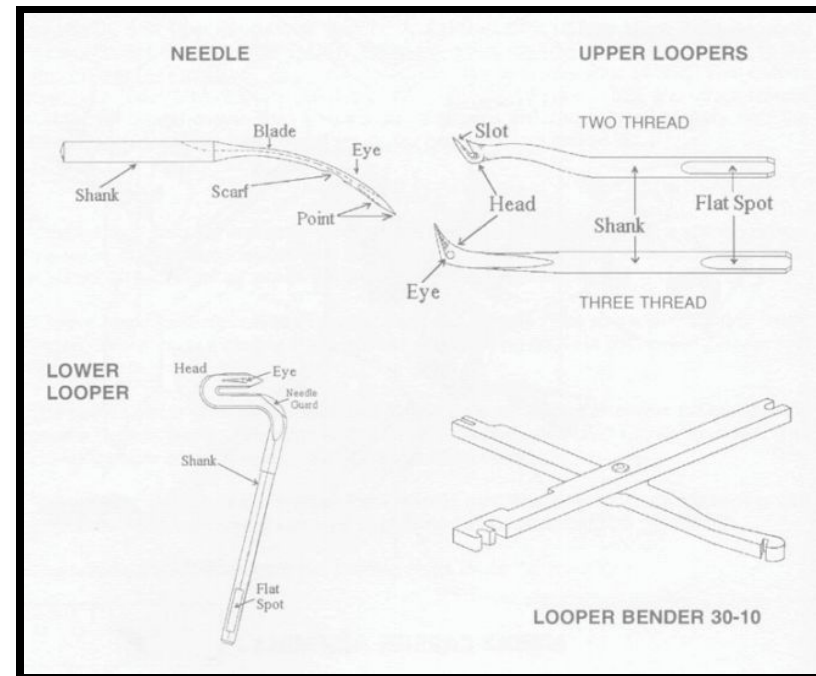
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MERROW LOOPERS

The following instructions will provide general information for Merrow machine looper setting. Specific styles of Merrow machines may have slightly different looper styles and shapes, but the general adjustment is consistent for all Merrow machines. Additional information can be found in the machine-specific Set-Up and Operations Manuals found in the support section of the Merrow website. Please contact Merrow Customer Service, or your local Merrow representative with any questions.

5 RULES

1. Always use **Genuine Merrow Loopers** in your Merrow machine. Genuine Loopers are specially tempered to allow proper bending adjustment and sewing performance.
2. Always bend loopers using the Merrow **30-10 Looper Bender** tool.
3. Always insert a **NEW Genuine Merrow Needle** into the machine before adjusting the loopers.
4. **NEVER** bend the needle!
5. Always bend the looper slightly farther than the desired location. The **loopers are tempered to allow bending** and will spring back towards their original (pre-bent) position.



Looper Bending Instructions

Merrow industrial sewing machines do not need to be set for timing. The internal cams control the timing of the machine, and also control the throw of the loopers. Merrow loopers are nearly self-setting, but may need slight bending to achieve proper stitch formation.

Step 1: Preparation

Before bending loopers, swing the presser foot assembly away from the needle, and remove the needle plate. Next, remove the lower looper thread tube, feed dogs, upper fabric guard, and dust shield. These parts are removed to accessibility, and will need to be returned after the loopers are properly bent.

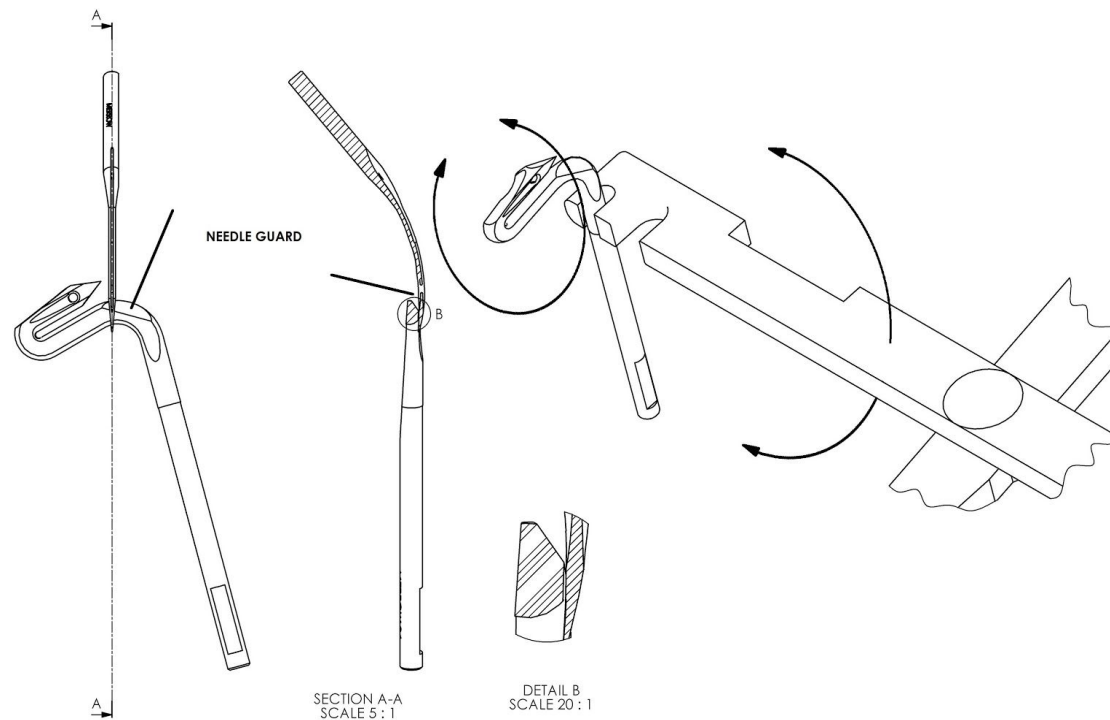
- Loosen the looper set-screws and remove both loopers.
- Insert a NEW Genuine Merrow Needle into the needle carrier. Make sure the needle is properly installed, and that the shank of the needle is in contact with the Needle Carrier Stop Pin.
- For proper setting, the Upper and Lower Looper must co-operate with the needle. You will set the loopers in the following order:
 - LOWER LOOPER to NEEDLE
 - UPPER LOOPER TO LOWER LOOPER
- Insert the LOWER LOOPER into the lower looper carrier, and push it into the carrier until it stops. Tighten the set screw against the flat spot on the shank of the looper. Do not insert the UPPER LOOPER until the LOWER LOOPER is set properly.

Step 2: Setting the LOWER LOOPER (Guarding the Needle)

Note the needle guard in the diagram (the angled cut on the lower looper).

1. Turn the handwheel clockwise and watch the path of the needle as it passes the needle guard.
2. For proper operation, the top corner of the needle point (where the point meets the blade) should contact the needle guard with a little pressure. To gauge this, a slip of notebook paper (0.003" thick) should fit between the needle and the needle guard with minimal resistance.
3. The LOWER LOOPER can be bent, as shown in the diagram, to bring the needle guard closer or further from the needle as required.

Helpful Hint: Turning the tool upwards (clockwise, as shown) will move the needle guard further from the needle.



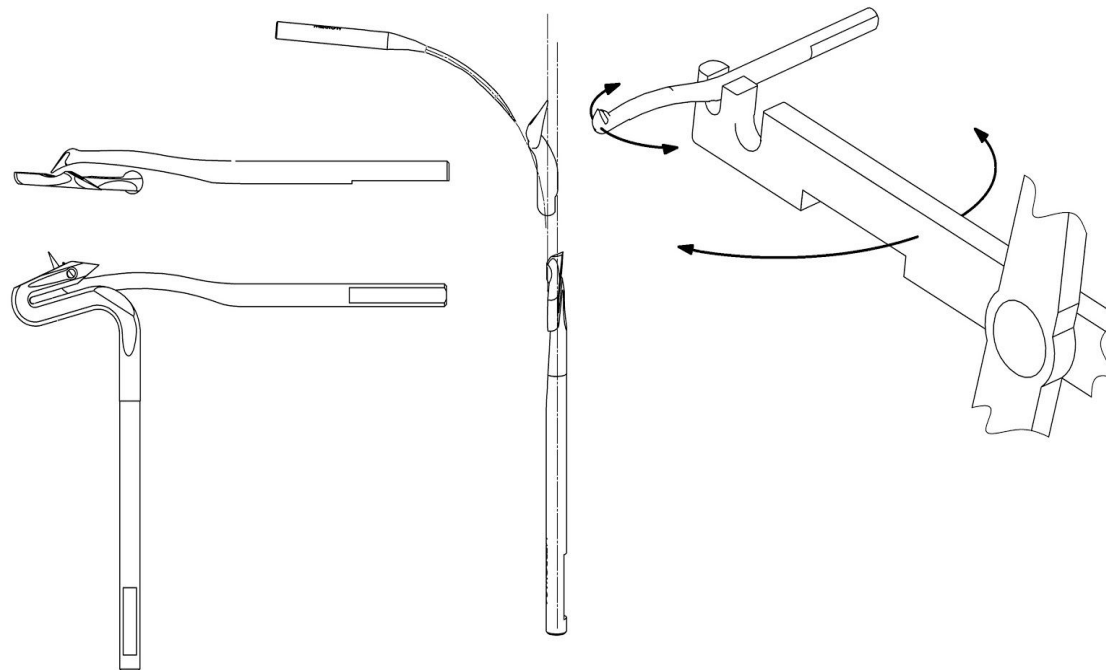
-GUARDING THE NEEDLE-

-Note the needle guard - the angled cut on lower loopers except #92

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Step 3: Setting the UPPER LOOPER (Horizontal Adjustment)

1. Insert the UPPER LOOPER into the upper looper carrier, and push it into the carrier until it stops. Tighten the set screw against the flat spot on the shank of the looper.
2. Turn the handwheel clockwise (slowly, by hand) and watch the motion of the UPPER LOOPER'S point.
 - a. The point of the UPPER LOOPER should fall behind the scarf of the LOWER LOOPER, but should NOT touch it.
 - b. The backside of the UPPER LOOPER should be forward enough so the needle falls cleanly behind it without touching.
3. The UPPER LOOPER can be bent and adjusted as shown until no interference can be felt.

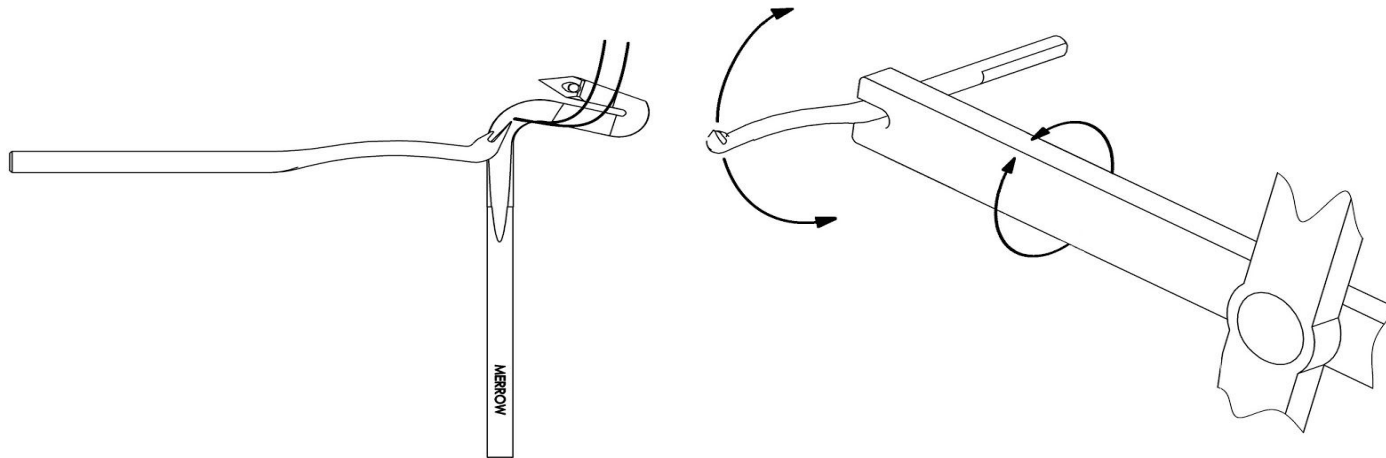


-UPPER LOOPER HORIZONTAL ADJUSTMENT-

Step 4: Setting the UPPER LOOPER (Vertical Adjustment)

1. For Best Performance, the point of the UPPER LOOPER should pass through the deepest area of the LOWER LOOPER scarf.
 - a. This can be adjusted by bending the UPPER LOOPER vertically, as shown.

Helpful Hint: Vertical adjustment of the UPPER LOOPER may require additional horizontal adjustment to make sure the UPPER LOOPER and LOWER LOOPER are properly set with each other.



-UPPER LOOPER VERTICAL ADJUSTMENT-

Step 5: Final Review

After following steps 1-4, the Loopers should be set and working with each other and the Needle. Return the lower looper thread tube, feed dogs, upper fabric guard, and dust shield to their original position. The looper settings will be verified after threading and chaining off the stitch. Manually rotate the handwheel clockwise to watch the thread transfer between the needle and loopers before running the machine with the motor.

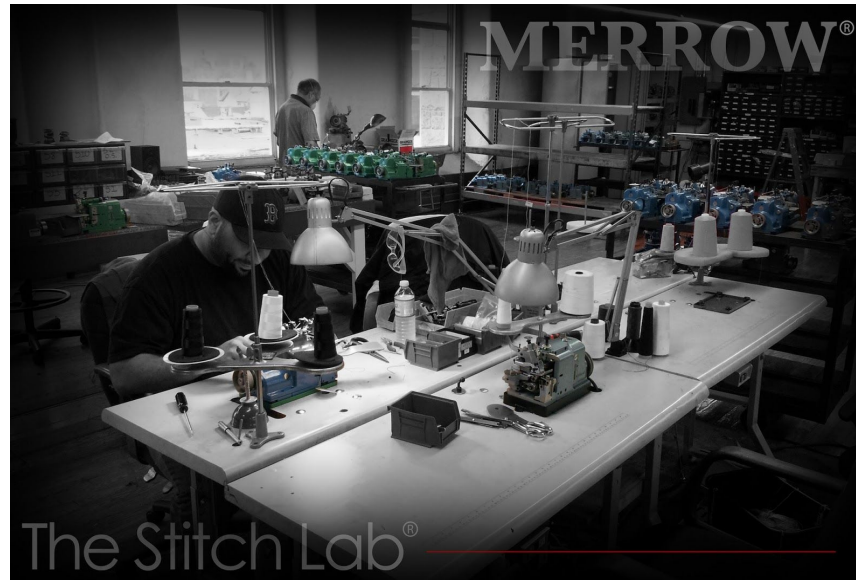


Helpful Hint: For Two Needle Machines (eg. MB-4DFO_2.0, MG-4DW-67) follow the above steps, except set the loopers to the inside needle. If the upper looper is blind (not threaded) set it as high as possible, making sure the point still clears the eye of the Lower Looper. This presents a wider open loop of thread for both needles to penetrate.



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The Merrow Stitch Lab



Merrow offers a comprehensive stitch lab designed to sew sample seams on customer fabric. Our stitch lab will sew a recommended array of stitches on your fabric to help implement your design and to display the proper stitch formation and profile. The Stitch Matters, and Merrow will help maximize the value of each seam. Generally, our sample department is able to sew-off material within a few days of receipt. This is a FREE service, available to all Merrow customers.

Please contact Merrow (p: 508.689.4095, e: support@merrow.com) if you are interested in Stitch Lab service.



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RECOMMENDED ACCESSORIES AND RESOURCES

MERROW FACTORY TRAINING

Come visit Merrow and learn how to service and support your Merrow Machine. We have trainings for ActiveSeam, Emblem, End-to-End Seaming and Merrow Stitch Design Development scheduled throughout the year. Trainings are designed for agents, mechanics, operators, designers, and plant managers. Please contact Merrow if you're interested - we would love to see you in Fall River!

Merrow Tool Kit

The Merrow tool kit contains all of the required tools to efficiently adjust and maximize the mechanical advantages of a Merrow machine. This kit includes a looper bender, multi-head nut driver, screwdriver, feed eccentric extractor, threading wires, tweezers, and thread snips.

High Efficiency Servo Motor

This is an extremely quiet and energy efficient Servo Motor with a digital display and needle positioner. With a Servo motor, you can control the speed of the motor with a switch that lets you adjust between 0 and 3450 RPM. This makes it ideal for experimental sewing and design work. The High Efficiency Servo motor is easy to program and is 75% more energy efficient than a standard clutch motor.

Merrow Stitch Cam Development Kit

A discounted collection of feed eccentrics to fit your development needs. Designed to allow an operator the flexibility to create spaced out, medium density, and total coverage stitches on a wide range of materials..

Spare Parts Package

A discounted bundle of the most common Genuine Spare Parts, including needles, loopers, and cutters. Save money and keep your machine running without interruption.

THE MERROW DEVELOPMENT CENTER

The Merrow Development Center works with Merrow customers to develop and configure unique stitch designs. This fee-based program goes beyond the standard sew-off offered by the Stitch Lab, and works with customers to understand your goals for fit, function, and design. The Development Center then creates stitching to achieve those goals. Please contact Merrow Customer Service if you are interested in working with our Development Center.

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HOW TO ORDER

Please contact your nearest certified Merrow Distributor or contact the Merrow Sewing Machine Company, 502 Bedford Street, Fall River, Massachusetts 02720, USA.

Phone (508) 689 4095
Fax (508) 689 4098
Email support@merrow.com.

Descriptive literature and samples of stitches will be provided upon request.



- I. Sewing machine heads are intended for integration into sewing units (table & motor sold separately). Applicable assembly and installation must be done according to instructions provided by the manufacturer or by an authorized Merrow distributor.
- II. Behind every Merrow sewing machine is more than 170 years of sewing machine building experience. Quality control is at the heart of the manufacturing process; accordingly, Merrow (The manufacturer) warrants all machines for a 1-year Limited Warranty for all materials and assembly, and a 10-Year limited warranty for the machine frame and internal cams. Please contact Merrow for complete details.

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