



PEGASUS®

M900 (Adjustment of the gauge parts)

INSTRUCTIONS

M932 Series: Safety stitch machine

M952 Series: Overedgers

M922 Series: Double chainstitch machine

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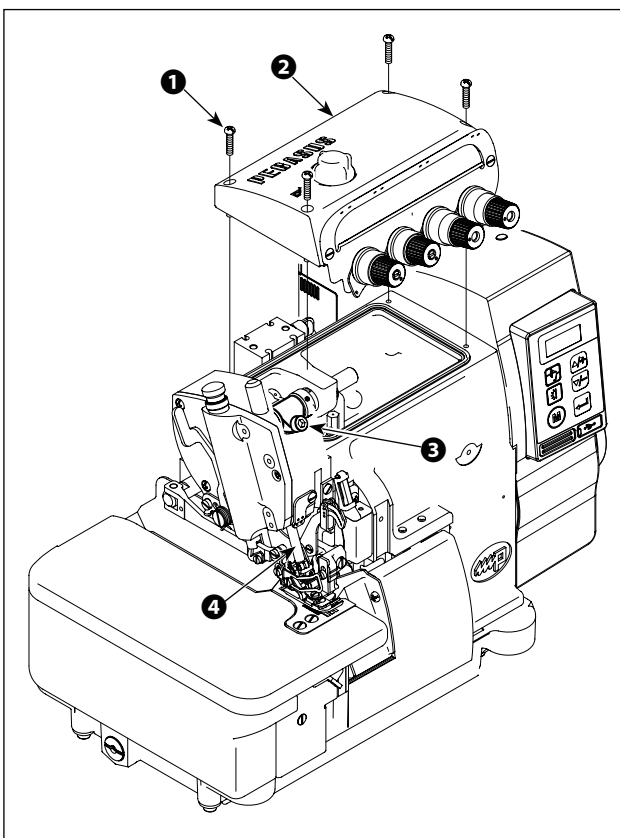
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1. Adjusting the needle height



WARNING

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

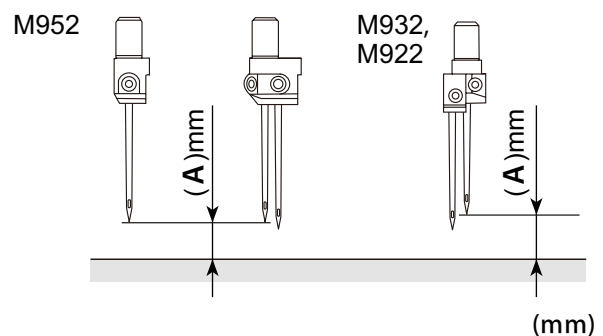


Note

After adjusting the needle height, check to see if the relationship between the needle and the looper is correct.

Adjust the distance (A) between the point of the needle and the top surface of the needle plate when the needle is at the top of the needle position.

- 1) Loosen four screws ①, and remove the top cover ②.
- 2) Loosen screw ③. Move the needle bar ④ to the required height. After this adjustment is made, tighten screw ③.
- 3) Close the top cover ② and tighten four screws ①.



M952		M932	
Subclass	(A)	Subclass	(A)
-01,-16S2, -17,-180	10.1	-38,-44,-70	10.6
-13,-52,-181	10.4	-48,-48P2	10.1
-13H,-52H	12.1	-86,-355,-551	12.0
-23B	11.6	-86H	12.1
-90	13.5	M922	
		-02	8.7

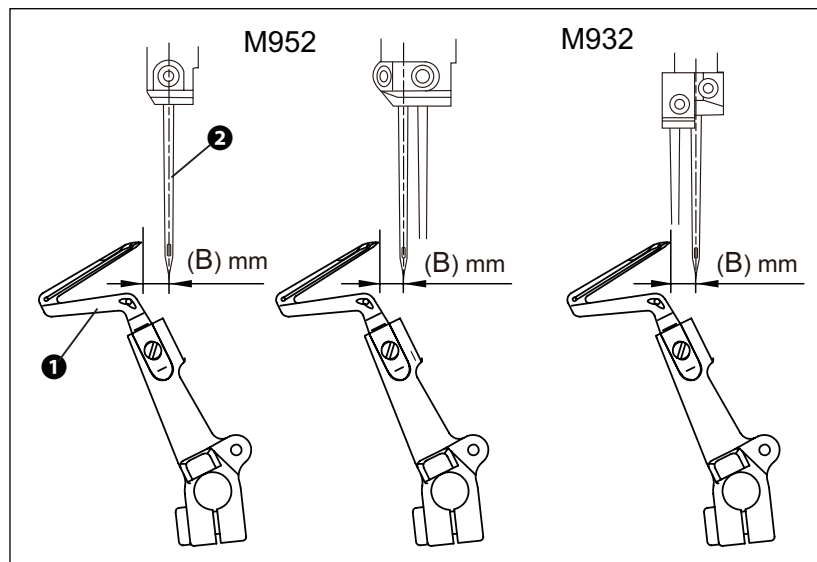
2. Relationship between the needle and the looper



WARNING

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

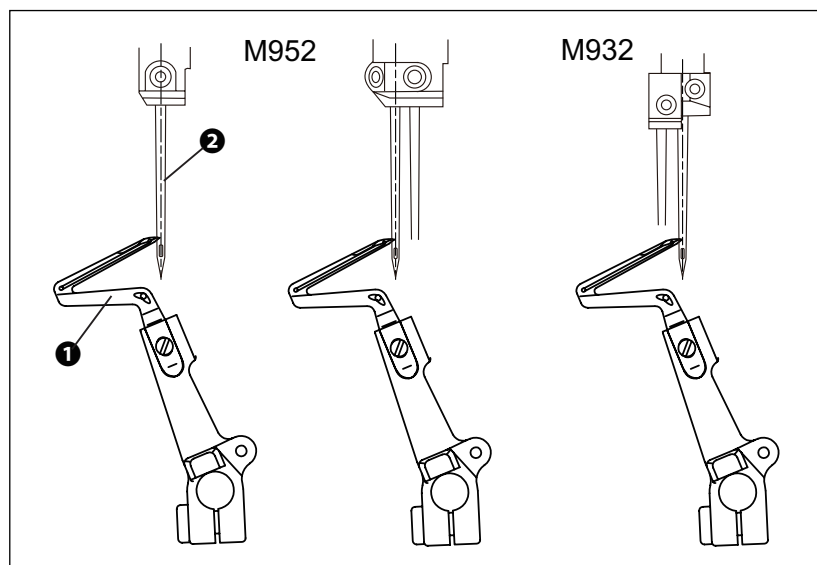
2-1. Relationship between the overedger needle and the lower looper



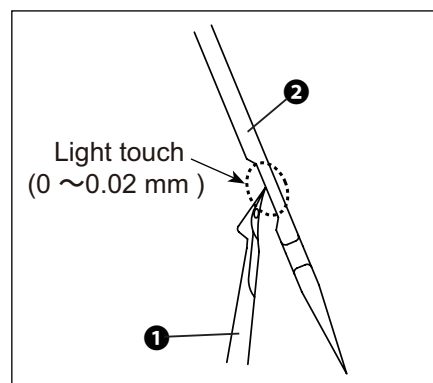
- 1) There should be (B) mm from the point of the lower looper ❶ to the center of the needle ❷ when the lower looper ❶ is at its farthest position to the left.

(mm)

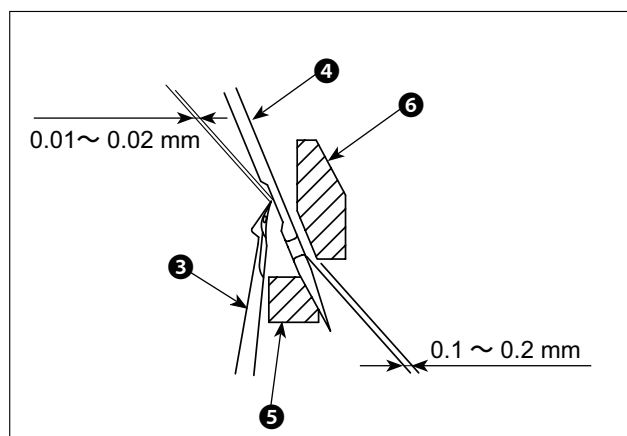
M952		M932	
Subclass	(B)	Subclass	(B)
-01,-13, -16S2,-17, -23B,-52, -180,-181	4.2	-38,-44, -48,-48P2, -70,	3.9
		-86,-86H,	3.4
-13H,-52H	3.8	-355,-551	3.6
-90	2.0		



- 2) The point of the lower looper ❶ should touch the needle lightly (0 mm ~ 0.02 mm) when the lower looper ❶ reaches the center of the needle ❷.



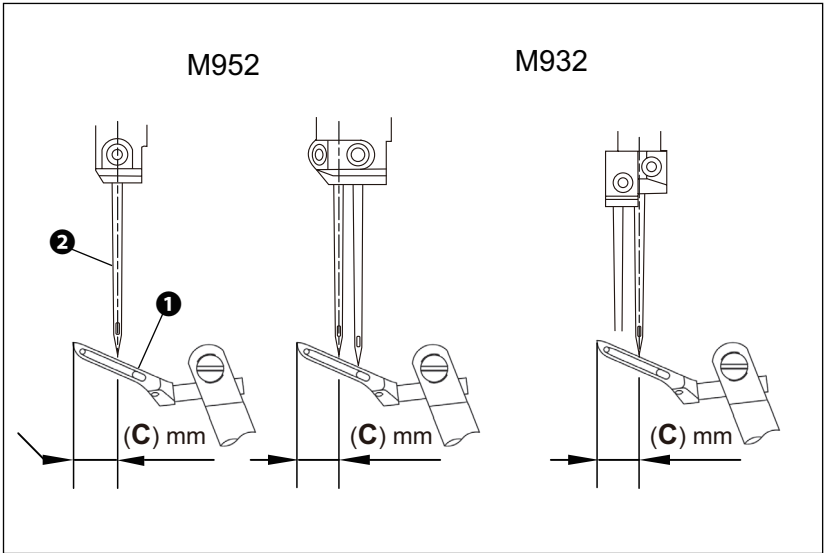
2-2. Relationship between the overedger needle and the needle guard



When the lower looper ❸ reaches the center of the needle ❹ (the left needle on the 2-needle machine), there should be a clearance of 0.01 mm ~ 0.02 mm between the point of the lower looper ❸ and the needle ❹. In order to obtain the clearance above, adjust the rear needle guard ❺.

When the needle ❹ is closest to the front needle guard ❻, there should be a clearance of 0.1 mm ~ 0.2 mm between the front needle guard ❻ and the needle ❹.

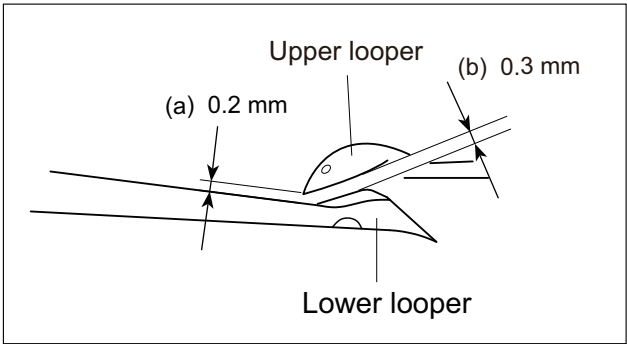
2-3. Relationship between the overedger needle and the upper looper



There should be (C) mm from the point of the upper looper ❶ to the center of the needle ❷ when the upper looper ❶ is at its farthest position to the left.

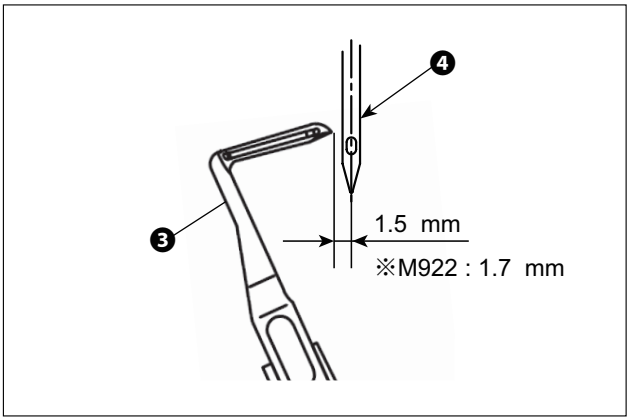
M952		M932	
Subclass	(C)	Subclass	(C)
-01,16S2, -17,180	5.1	-38,-44, -48,-48P2, -70,-86	5.1
-13,-23B, -52,181	5.8		
-13H,-52H, -90	5.5	-355,-551 -86H	5.8 6.5

2-4. Relationship between the upper looper and the lower looper

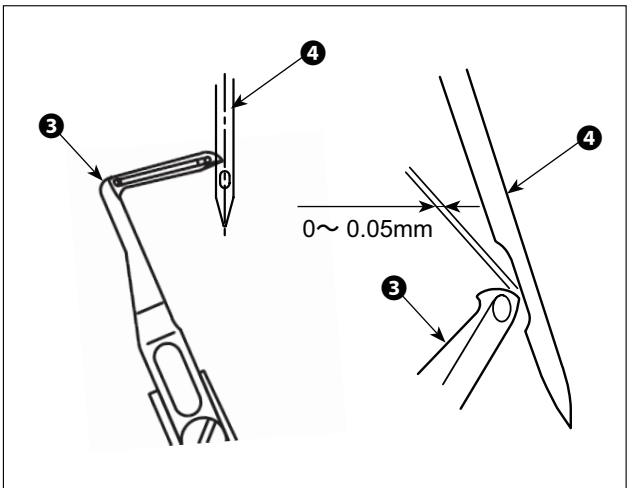


When the point of the upper looper intersects the back of the lower looper, the clearance (a) should be 0.2 mm, and the clearance (b) should be 0.3 mm.

2-5. Relationship between the double chainstitch needle and the double chainstitch looper

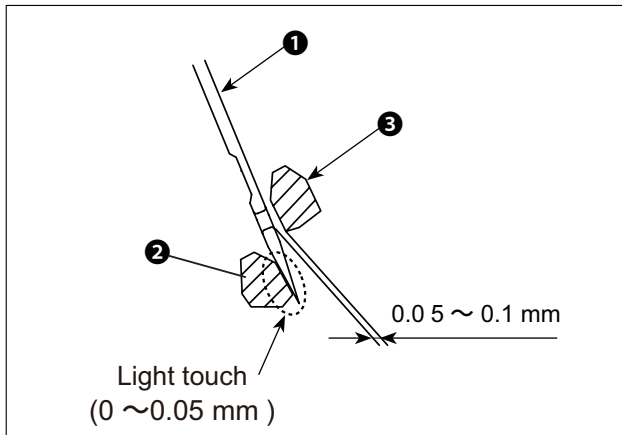


When the double chainstitch looper ❸ is at its farthest position to the left, there should be 1.5 mm (M922: 1.7 mm) between the point of the double chainstitch looper ❸ and the center of the double chainstitch needle ❹.



When the double chainstitch looper ❸ reaches the center of the double chainstitch needle ❹, there should be 0 mm ~ 0.05 mm between the point of the double chainstitch looper ❸ and the double chainstitch needle ❹.

2-6. Relationship between the double chainstitch needle and the needle guard



When the double chainstitch needle **1** is at the lowest position, the rear needle guard **2** should touch the double chainstitch needle **1** lightly (0 mm ~ 0.05 mm).

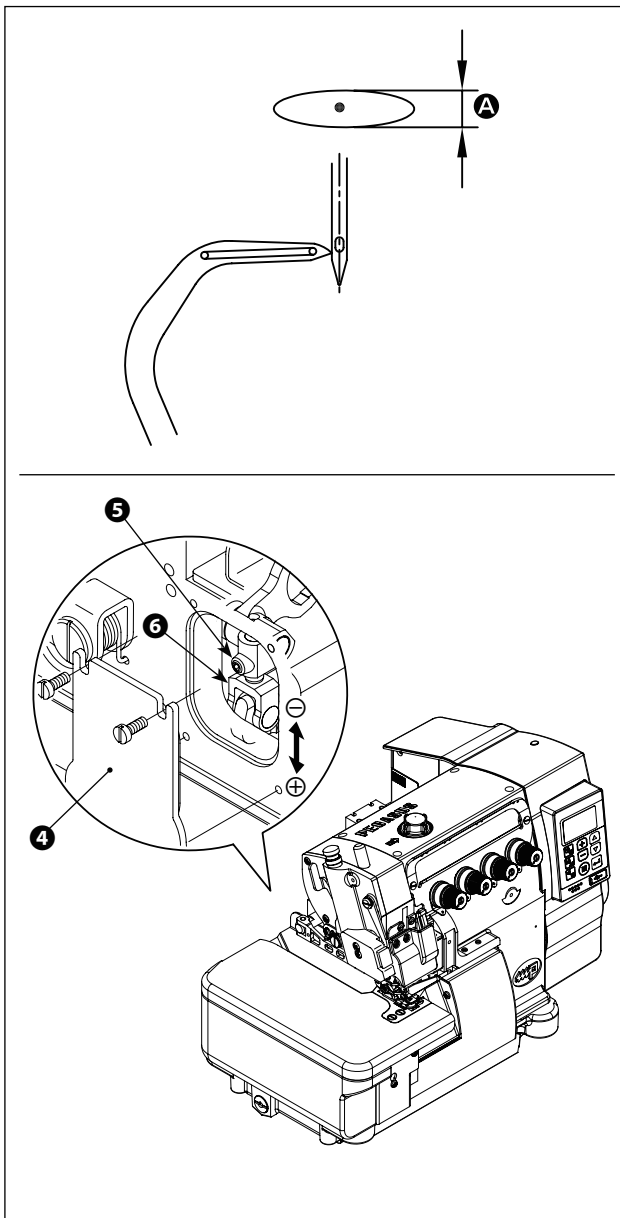
When the double chainstitch needle **1** is at the lowest position, the clearance between the double chainstitch needle **1** and the front needle guard **3** should be 0.05 mm ~ 0.1 mm.

3. Adjusting the amount of the front-to-back movement of the double chainstitch looper



WARNING

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.



The motion of the double chainstitch looper describes an ellipse. In order to adjust the amount of the front-to-back movement **A** of the double chainstitch looper, follow the procedures shown below.

Open the cover **4** on the back of the machine. Slightly loosen screw **5**. This adjustment is made by moving the link **6** up and down.

In order to increase the amount of the front-to-back movement of the double chainstitch looper, move the link **6** in the direction of \oplus .

In order to decrease the amount of the front-to-back movement of the double chainstitch looper, move the link **6** in the direction of \ominus .

After this adjustment is made, tighten screw **5**. Finally, close the cover **4**.

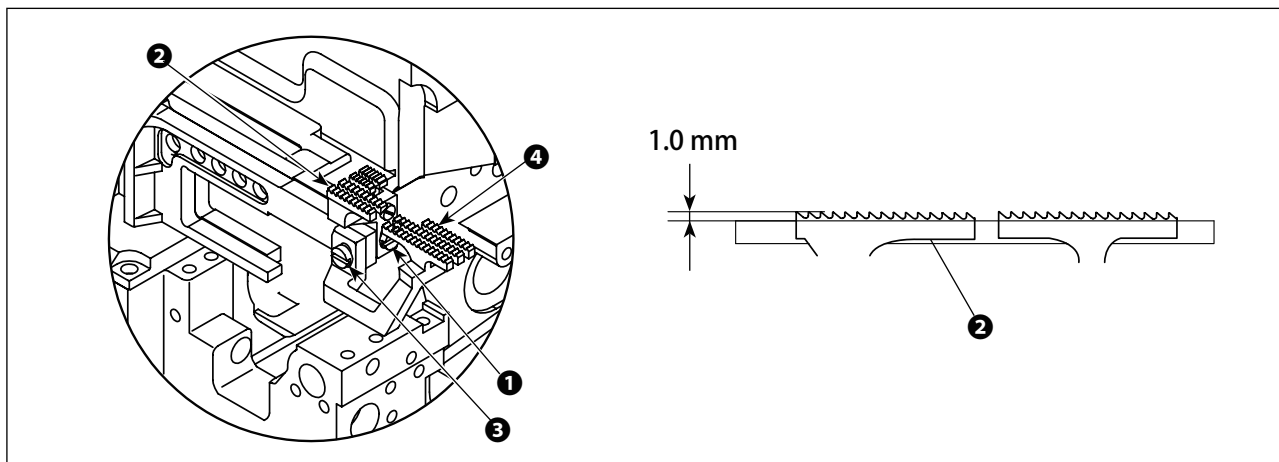
4. Adjusting the feed dog



WARNING

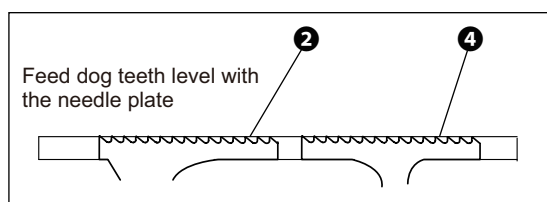
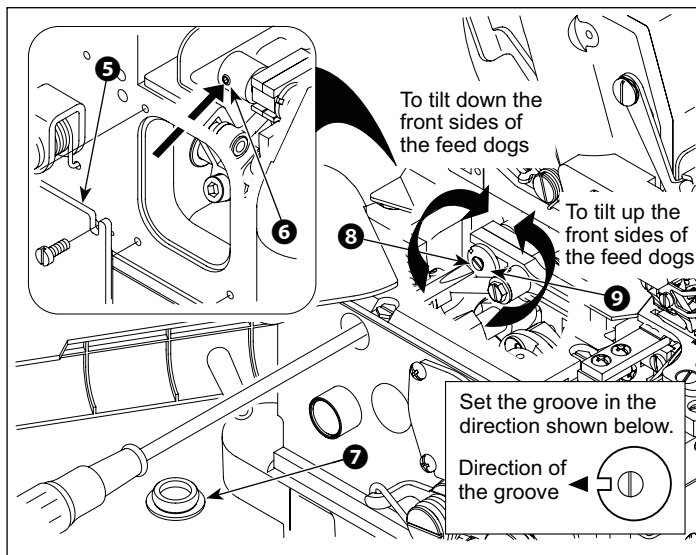
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

4-1. Adjusting the feed dog height



- 1) Bring the main feed dog **2** to the highest position by turning the machine pulley.
- 2) Loosen screw **1**. There should be a height of 1.0 mm above the top surface of the needle plate at the second or third tooth from the rear side of the main feed dog **2**. After this adjustment is made, tighten screw **1**.
- 3) Turn the machine pulley so that the teeth of the main feed dog **2** are level with the top surface of the needle plate. Loosen screw **3** so that the teeth of the differential feed dog **4** are also level with the top surface of the needle plate. After this adjustment is made, tighten screw **3**. (If this adjustment is not made properly, adjust again as stated above by referring to 4-2 Adjusting the inclination of the feed dog.)

4-2. Adjusting the inclination of the feed dog

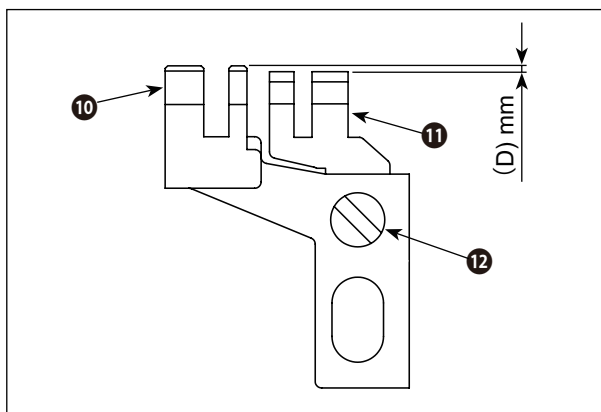


Remove the cover **5**. Loosen screw **6**. Then remove the cover **7**. All the points of the feed dog teeth should be level above the top surface of the needle plate. This adjustment is made by turning screw **8**. After this adjustment is made, tighten screw **6**, and replace the covers **5** and **7**.

Note

Check the direction of the groove of washer **9**.

4-3. Adjusting the auxiliary feed dog height



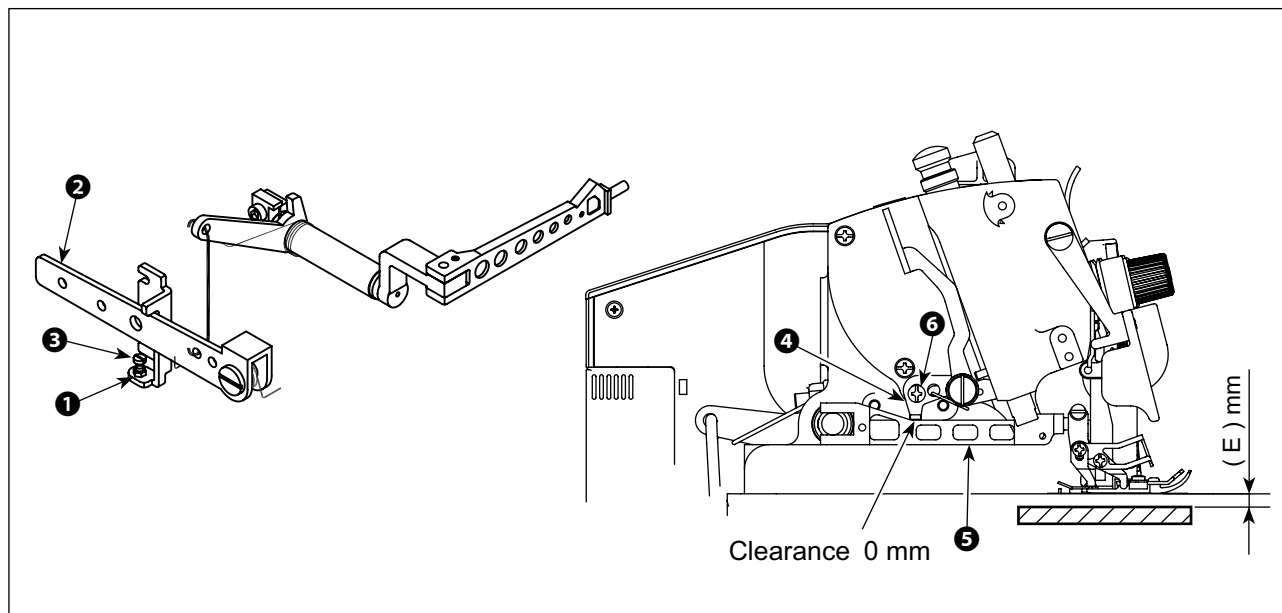
The level difference between the main feed dog 10 and the auxiliary feed dog 11 should be (D) mm.

In order to make this adjustment, loosen screw 12 and move the auxiliary feed dog 11 up and down.

(mm)

M952		M932	
Subclass	(D)	Subclass	(D)
-01, -13, -13H, -17, -23B	1.0	-38, -44, -48, -48P2, -70, -355	0.3
-16S2, -52, -52H, -181	0	-86, -86H, -551	0.6
-180	0.8	M922	
		-02	0

5. Adjusting the presser foot lift



- 1) The bottom of the presser foot should touch the needle plate flatly. In order to make this adjustment, lower the feed dog by turning the machine pulley.
- 2) Loosen nut 1. When the presser foot lift lever 2 is lowered, the distance between the top surface of the needle plate and the bottom of the presser foot should be (E) mm. In addition, screw 3 should touch the presser foot lift lever 2. After these adjustments are made, tighten nut 1.
- 3) When the presser foot is raised, the clearance between the stopper 4 and the presser arm 5 should be 0 mm. In order to make this adjustment, loosen screw 6, and move the stopper 4 up and down.

(mm)

(mm)

M952	
Subclass	(E)
-01, -16S2, -17, -180	5.5
-13, -13H, -52, -52H	6.0
-23B	7.0
-90	3.0
-181	4.8

M932	
Subclass	(E)
-38, -44, -48, -70, -86, -355, -551	5.5
-48P2	5.0
-86H	7.0
M922	
-02	3.5

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Cat. No. 9B2080000009  September 2022
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