

OPERATING INSTRUCTIONS

for Cloth Roll Towel processing

This process is used to provide better cleaning and faster drying of the cloth roll towel and often an overall faster handling operation for preparing the towels for processing and for rewinding.

The concept is to put two or three tied loose loops along an edge of the flaked bundle. The loose loops secure the layers of cloth so that the bundle does not come apart in the laundry process and allows separation of the layers of cloth for better cleaning and faster drying.

Some experimentation is suggested to get the size and number of loops used to be the best combination for the length of the flaked bundle you create and the cleaning/drying methods you use.

Follow the instructions from the manufacturer and substitute the following for "OPERATION OF THE MACHINE" in order to process cloth roll towel flaked bundles.

THREADING THE MACHINE:

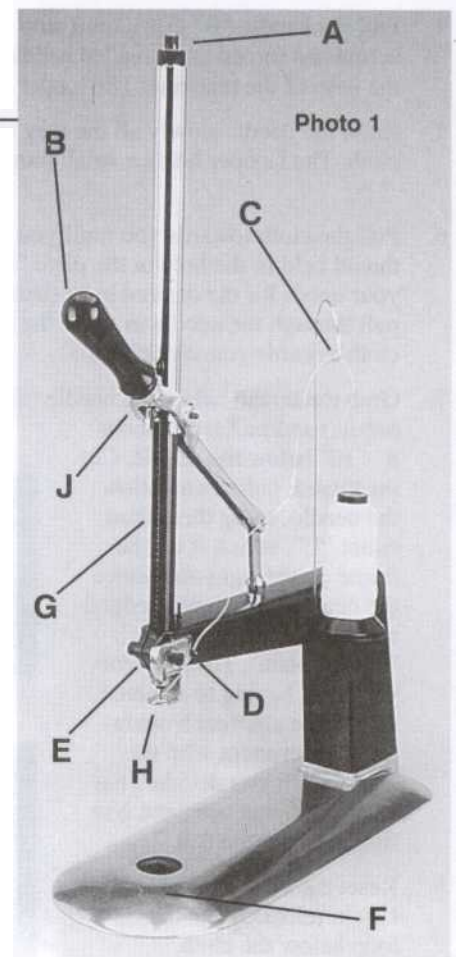
Thread from spool through thread eye "C" to the thread hole "D" in the rear of the thread cutter; then to the needle eye "H". Thread needle from the spool side of the machine.

TO REMOVE NEEDLE:

Remove knurled cap "A" from top of machine - turn counter-clockwise to remove. Lift needle rod and needle assembly clear from the machine. Loosen bottom set screw and remove the needle from rod. When replacing needle and re-assembling needle rod in machine, refer to instruction sheet #672C 1-110.

OILING: Oil rod and tube at "G" twice a week.

THREAD: It is advised that the special heavy nylon thread developed for this cloth roll towel processing is used. Using a lighter weight thread may result in breakage and trangling of the towels during processing.



OPERATION OF THE MACHINE for cloth roll towel flaked bundle processing

CAUTION: Make sure that the black Looper Locking Latch (located on the left above the needle) is pressed down PRIOR to each needle stroke-failure to do so could result in a broken needle, other damage to the unit, and lack of creating the necessary bottom thread loop.

CAUTION: Make sure all objects including hands and fingers are away from the needle area before each needle stroke. Serious injury can result to the operator from the failure to keep hands and fingers clear of the area to be stitched.

1. Take the flaked towel bundle and place it on the front beveled portion "F" so that you can make a stitch about 1" - 3" in from the top edge (farthest away from you) of the cloth and in from the left side about 8" - 10" (in enough from the left side to secure all the layers of the flaked cloth). You can experiment with these distances to fit your needs. See figure 1 & 2.

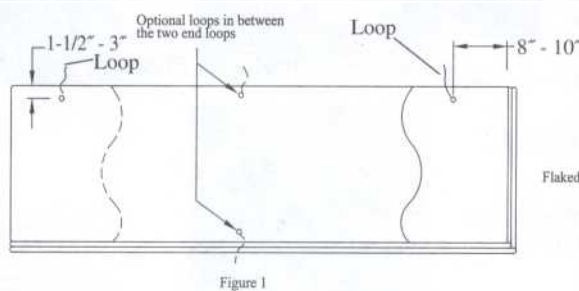


Figure 1

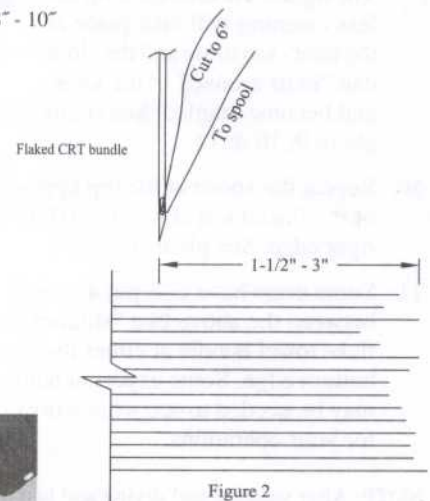


Figure 2

2. Pull out about 8" of thread from the needle before starting the process. The length pulled out can be varied to meet your needs. See photo 2.

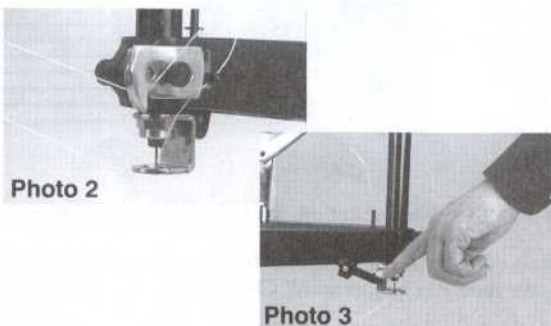


Photo 2

Photo 3

3. Press down on the Looper Locking Latch (to the left and above the needle) See photo 3.

4. Pull the handle "B" down until stop "J" makes contact with the threadmarker housing. This action has forced the threaded needle through the material and released the Loper contained in the base of the machine. The looper catches and holds the tread loop. See photo 4.
5. Raise the needle slowly all the way to the top position above the cloth. The Loper holds a small loop under the plate in the unit.
6. Pull the cloth towards you until you can see the bottom loop of the thread held in the hole in the plate "F" (experiment with this to fit your needs for the desired loop size). The thread in the needle will pull through the needle to make the loop longer as you pull the cloth towards you. See photo 5.
7. Grab the thread below the needle (the one that runs through the needle) and pull it out about 8" - 10" below the needle. Cut the thread, pulled out below the needle, using the thread cutter "E", which is on the frame on the right and above the needle (two double edged razor blades behind the "silver" plate). This prevents you from having to rethread the needle after each operation. Experiment with the length until you decide what is best for your operator. See figure 4 & photo 6 & 7.
8. Reset the Loper Locking Latch, releasing the thread loop below the cloth. See photo 8.
9. Pull the loop around to the top of the cloth and use the loose ends of the thread to tie a few half hitch knots through the thread loop (see sketches). The tightness or looseness of the loop is up to you (try one that is loose enough to easily get three fingers through the space between the loop and the cloth). The tighter the knotted loop the less cleaning will take place at the knot - too loose and the cloth can "twist around" at the knot and become tangled. See figure 5 & 6, photo 9, 10 & 11.
10. Repeat the above at the top opposite end of the flaked roll about 8" - 10" in the right edge. See photo 12.
11. Some users have also put a "stitch" in-between the above two "stitches" of the flake towel bundle at either the top or bottom edge. Some experimentation may be needed to see what works best for your operations.

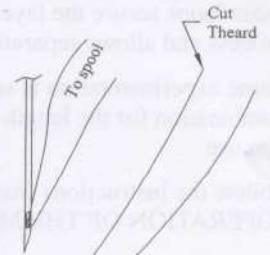
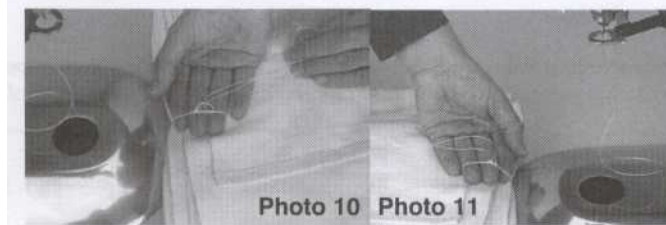
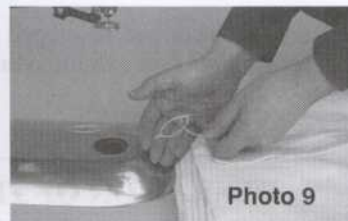
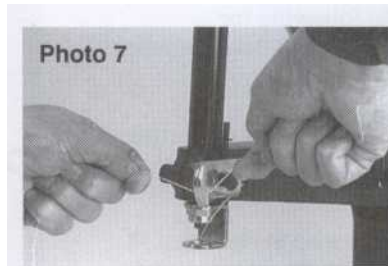
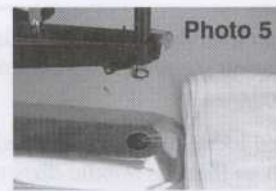
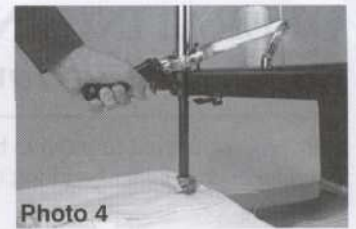
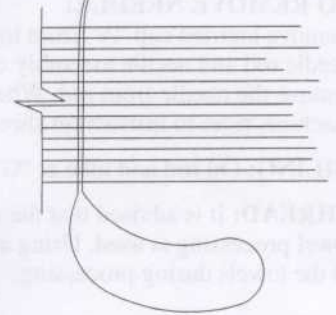
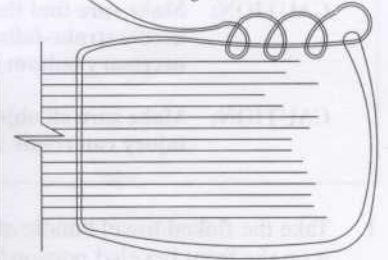


Figure 4



Make sure the knot is tight but the loop is loose

Figure 5



Tie with three "half hitch" knots or similar to secure the thread loop and leave the loop loose (suggest loose enough to get three finger into the tied loop)

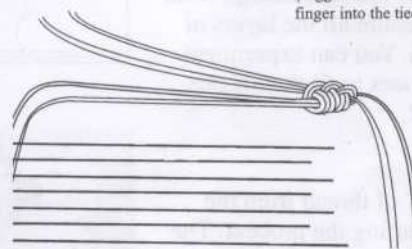


Figure 6

NOTE: After washing and drying and just prior to rewinding cut the thread loop with scissors and pull out the thread.

Rewind the towel. NOTE: because the towels don't stick together, like they do when using rubber bands and other methods that confine a section of the flaked bundle, the speed of rewinding can generally be increased. Check with your operators and equipment to see if this is feasible.

Follow the instructions in your manual for all other operations such as: care, maintenance, oiling, needle setting, repairs, etc.