

CHAPTER 3: KNITTING OPERATION

"A Delicate Job, Handle with Care."

3.1 Yarn Supply: Changing Yarn Feeding Amount

Note that the yarn feeding amount, calculated in length (mm) per machine revolution, can be modified in 2 simple ways, i.e.

- Changing effective Q.A.P. diameter
- Changing HTD sprockets combination

(Refer to Appendix 1.3 for schematic illustration of this section)

Usually, changing the effective Q.A.P. diameter is enough. The procedure is as followed:

- Step 1: STOP machine
Step 2: LOOSEN toothed-belt (or punched-tape) by loosening tape-tensioner
Step 3: LOOSEN lock-nut with special "C" spanner (provided in tool box)
Step 4: HOLD the fixed plate firmly with on hand, and rotate the adjustable plate to the required diameter. Note: Effective diameter is engraved on fixed plate.
Step 5: TIGHTEN lock-nut
Step 6: RECORD new setting for future reference
Step 7: TIGHTEN toothed-belt (or punched-tape)

Should the required yarn feeding amount cannot be achieved by changing Q.A.P. effective diameter, the new sprocket combinations can be used. However, the sprockets have to be changed manually. The 27-teeth and 53-teeth sprockets are shipped as a spare.



Warning: STOP machine before open Sprocket Box !

Options	Sprocket Combination (no. of teeth)			Yarn Feeding Amount For Diameter Range 30"-34" (mm Per Machine Rev.)	
	A-1	A-2	B	Q.A.P. "A" Ø95-Ø170-Ø245	Q.A.P. "B" Ø95-Ø170-Ø245
Standard Factory Setting	36	36	36	5560-9950-14340	5560-9950-14340
* Option #1 (For Terry & Fleece)	36	27	53	5560-9950-14340	2830-5070-7300
Option #2	36	53	27	5560-9950-14340	10920-19540-28160

Table (3.1) Yarn Feeding Amount