

INSTRUCTIONS:'MASCOTTE' 1268B LOCKSTITCH BLAKE MACHINE

Catalogue Reference: 9/8/1

Technical Data .....	Section 1
Installation .....	Section 2
Controls .....	Section 3
Setting up .....	Section 4
Operating .....	Section 5
Lubrication .....	Section 6
Maintenance .....	Section 7
Fault Finding .....	Section 8
Wiring Diagram .....	Section 9
Safety .....	Section 10
Illustrated Parts List .....	Section 11



**Whitfield Wylie Limited**  
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WH6B MACHINES are designed to operate with the accessories supplied as initial equipment.  
 The Company can accept no responsibility for malfunction if unapproved accessories or spares are used.

Our policy being one of continuing development and improvement, we reserve the right to alter specifications without notice.

TECHNICAL DATA

Height: 65 ins. 1651mm.  
Width: 25 $\frac{1}{2}$  ins. 648mm.  
Depth: 28 ins. 711mm.  
Weight: 481 lb. 218 kg.  
Motor: 0.5 HP. (0.37 kW) Syn. speed: 1000 rpm  
Rotation: Handwheel turns clockwise, viewed from the right.  
Speed (approx): 80 or 120 stitches/minute.  
Stitch length: Infinitely variable from 3mm ( $\frac{1}{8}$ " ) to 12mm ( $\frac{1}{2}$ " ).  
Maximum work thickness: 20mm ( $\frac{3}{4}$ " ).  
Needle size: 5 or 6  
Thread, shuttle: 6 or 5 cord, right twist, pre-waxed.  
Thread, horn: 5 or 6 cord, left twist, soft finish.  
Thread lubricant: 1 part soluble oil to 10 parts water.

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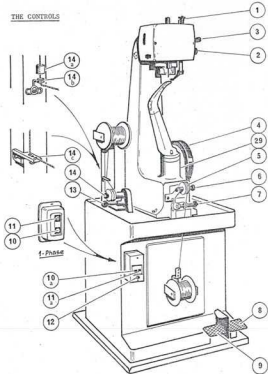
### INSTALLATION

The machine must stand firmly and level, using packing pieces under the corners if necessary. It is not normally necessary to screw the machine to the floor, but holes are provided in the base for this purpose if desired.

The machine must be connected to the mains power supply through a fused isolator of not less than 10 amps (3 phase) or 13 amps (1 phase) capacity. The machine must be earthed.

ALL ELECTRICAL CONNECTIONS MUST BE MADE ONLY BY A QUALIFIED ELECTRICIAN.

THE CONTROLS



1. Presser Foot spring adjuster and locknut
2. Stitch length adjuster and locknut
3. Presser Foot raising hand lever
4. Handwheel
5. Thread tension handwheel
6. Thread tension adjuster
7. Thread straightener adjuster
8. Presser Foot raising treadle
9. Clutch treadle
10. STOP button (1 phase machines)
11. START button (1 phase machines)
- 10a. STOP button (3 phase machines)
- 11a. START button (3 phase machines)
12. Mains warning light (3 phase machines)
13. Bobbin winder operating knob
14. Bobbin winder clamp nut
- 14a. Friction rubber
- 14b. Thread eye
- 14c. Thread guide (Machines Serial No:810 onwards)
29. Horn locking screw

## SETTING UP

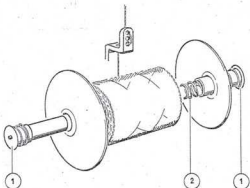
### Threading - Horn:

Fit the cop of thread (6 cord, left twist, soft finish) to the cop holder on the front of the machine. Remove the two-part spindle (1) by pressing the two halves inwards to compress the light spring (2) and lifting the assembly out of the bracket. Separate the two halves, taking care not to drop out the spring (2), which is loose. In later models this spring is not fitted.

Insert the two halves in either end of the cop, as shown, and replace in the bracket. Pass the thread through the thread guide above the cop, as shown.

It is essential that the thread takes the correct course through the machine, as shown in the diagram. Normally, the machine is delivered with a length of thread in position, so that it is only necessary to tie the lower end securely to the thread from the cop and pull it through. In order to pull it through, the thread lock must be in the released position; that is, with the handwheel turned so that the needle is rising. Help the thread through by rolling the aluminium tension wheel (11) forward with the palm of the hand at the same time as pulling the thread.

Should it become necessary to re-thread the machine, refer to the diagrams on the following pages.



## OPERATING

Preparation of Work: It must be remembered that any groove, channel or slit cut in the sole to receive the stitches must be positioned in relation to the edge of the innersole, not the sole. If placed too near the edge, there is a great risk of running off the edge of the innersole, which will probably deflect the needle, breaking the thread and possibly the needle and/or Horn Tip, apart from damaging the shoe.

Remove any sock lining before sewing and ensure that, if the shoe has a tongue, this is pulled out of the way through the laces to prevent it from being sewn down.

Check that there is sufficient thread on the bobbin for the work in hand.

Switch on the motor.

There must be at least 4" (10 cm) of thread hanging from the shuttle.

If the machine has been unused for some time, the thread from the lubricant pot to the whirl will have dried and must be pulled through until it is felt to be wet. The machine must be in the "needle rising" position (that is, with the lock off) in order to do this. It will also be necessary to help the thread through by rolling the aluminium tension wheel (11) forward with the palm of the hand whilst pulling the thread. Do not turn the tension wheel without also pulling the thread at the same time, otherwise loose loops of thread can be formed which can cause entanglement.

Turn the horn with its arch to the left and pull the horn thread down securely under the spring clip near the top of the horn. It must be understood that the first stitch cannot be picked up unless the thread is in this position for starting, coming down and across the side of the horn nearest the operator. Leave at least 4" (10 cm) of thread hanging loose from the clip.

Raise the presser foot fully by depressing the right hand treadle and place the shoe on the horn, toe to the right, so as to start sewing at the waist on the far side. Lower the presser foot, ensuring that, if sewing in a groove, the projection on the underside of the foot sits in the groove.

Hold the work with the hands on top, to hold it down, and allow the presser foot to feed it along at its own pace, neither helping or impeding it. Do not try to regulate the speed of the machine by slipping the clutch, as it is not designed for this. The speed with the clutch fully engaged is low enough to enable handling to be easily mastered with very little practice. On reaching the toe, turn the shoe and horn together, transferring the right hand to the heel.

The ideal stopping position is at the completion of a stitch; that is, just as the loop of thread has passed over the shuttle and been drawn down by the take-up lever. If the machine is not stopped at this point, turn the handwheel by hand, in its normal direction of rotation, until the required position is reached, and then

turn it backwards until the presser foot moves to the right. The lock is off in this position, so that the presser foot can be raised and the work removed from the horn. Pull the shoe away from the horn, at the same time turning the aluminium tension wheel, in order to draw out sufficient thread to start the next shoe. Cut the shuttle thread close to the sole and allow the horn thread to go slack before cutting it, otherwise the spring action of the take-up mechanism may snatch the thread back through the whirl, necessitating re-threading.

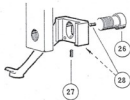
Thread tension adjustment: This is made by tightening or slackening the knurled adjuster (6) on the spindle of the aluminium tension wheel. This adjustment is extremely sensitive and must be made with great care, using only sufficient tension to pull the shuttle thread well down into the sole. Too much tension will result in thread breakage. The thread straightener (7) requires only very light tension.

To regulate stitch length: Slacken the knurled locknut on the Adjusting Screw (2) and turn the screw anti-clockwise to lengthen the stitch, or clockwise to shorten it. This adjustment is quite sensitive and should be made with care, finding the desired setting by experiment. Retighten the locknut securely.

To change the Presser Foot: A selection of Presser Feet is provided, which can be readily interchanged to suit the work in hand or the operator's preference.

To take off the foot, remove the large screw (26).

When replacing, check for height and alignment. The small screw (27) regulates the height by projecting into the elongated hole in the Foot and bearing on the screw (26). Before tightening the screw (26), push the Foot up as far as it will go and ensure that its underside clears the top of the horn. If it does not, slacken the screw (27) which will allow it to be pushed up further. Check alignment by looking from the left hand side to ensure that the projection on the underside of the Foot is in line with the needle. If not, this can be corrected by the two screws (28). Slacken the screw (26) a little and, holding the foot tightly against the bar, tighten either the upper or lower adjusting screw. The upper will move the foot towards, or the lower away from, the operator. Ensure that the Foot is pushed right up and re-tighten the screw (26) securely.



Foot pressure.

The spring pressure on the Foot can be regulated by the knurled Adjuster (1). Slacken the locknut and turn the Adjuster clockwise to increase the pressure or anti-clockwise to decrease it, afterwards re-tightening the locknut. The pressure is unlikely to require such alteration. Generally speaking, soft materials require less and hard materials more pressure.

Flat work.

For sewing leather goods, such as brief cases etc., it is helpful to lock the rotation of the Horn by tightening the recessed screw (29) in the right hand side of the Horn base. The Horn may be locked in any position. Be sure the lock is released before sewing shoes.



## LUBRICATION

THE MACHINE MUST BE ISOLATED FROM THE ELECTRICITY SUPPLY BEFORE CARRYING OUT ANY MAINTENANCE OR LUBRICATION OPERATIONS.

### Weekly:

Apply W&B Machine Oil to the following points:-

- Head, right hand side: Spring-ball lubricator below Stitch Length Adjuster.  
Insert oil can through openings in head casing and lubricate moving parts generally.
- Head, top: Turn machine to raise needle and lubricate upper part of Needle Bar.  
Operate Foot Raising Treadle and lubricate upper part of Presser Foot Bar.
- Head, left-hand side: Insert oil can through openings and lubricate moving parts generally.  
Oil hole in Presser Foot actuating lever fulcrum.
- Head, front: Shuttle race.  
Fulcrum and roller of Thread Lifter Lever.  
Lower part of Presser Foot Bar.  
Turn machine to lower needle and lubricate lower part of Needle Bar.
- Horn: Lubricate the Whirl and Pinion through the hole in the Horn Cap. Turn the machine over a few revolutions and wipe away surplus oil, to avoid contamination of work.  
Spring-ball lubricator near top of Horn.  
Open Horn front and lubricate the gears at the bottom, including the oil hole under the large gear.
- Right hand side of base: Open the transparent inspection cover, turn the machine so that the Take-up Lever is down, and lubricate the gears and the thread roll on the Take-up Lever.
- Thread tension mechanism: Lubricate the thread rolls and sliding parts of the Auxiliary Take-up.
- At six monthly intervals: Remove the two cover plates on the back of the head column and apply grease liberally to the gears. Use Castrol Spherol AP3 or equivalent.

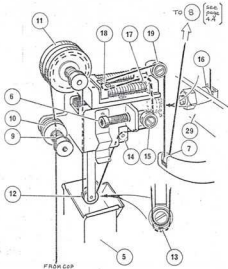
It is necessary to remove the whole Thread Tensioning Assembly from the machine for threading, as the various rolls are otherwise inaccessible.

First remove the Lubricant Pot (5) by pulling it downwards. Taking the weight of the assembly in one hand, remove the two screws (6). The assembly can be withdrawn and removed by tilting it upwards.

Take the thread coming from the cop, pull apart the two discs of the Thread Straightener (10) and pass the thread through the hole in the spindle (9). It then takes two turns round the aluminium Tension Wheel (11) and goes down under the Lubricator Roll (12). MAKE SURE that it passes INSIDE the cage at (13), NOT as shown by the dotted line. From here, pass it over the small roll (14) and under the roll (15) again ensuring that it is inside the cage. The thread must then go through the Thread Lock (16) inside the machine, so lead it up behind the bar (29). It need not be positioned in the Lock yet, as this can be done later. Take it over the roll (17), under the sliding roll (18) and over (19), inside the cage. Pull a good length of thread (say, 24" (60 cm) through and set the assembly aside.

Turn the machine so that the Take-up Lever is down and just starting to rise again, when the lock will be off and the roll (7) accessible by opening the transparent inspection cover on the right hand side of the Horn base. Pass the wire threader provided in the kit down through the hole (8) in the centre of the gear in the base of the Horn. Take the thread coming from (19), pass it under the Take-up roll (7), engage it in the eye of the wire threader and draw it up and out through the hole (8).

The Thread Tensioning Assembly can now be refitted, ensuring that the thread between (15) and (17) is positioned between the plates of the Thread Lock (16).



It is necessary to remove the whole Thread Tensioning Assembly from the machine for threading, as the various rolls are otherwise inaccessible. To do this, first take off the Auxiliary Take-up Slide by removing the two screws (3). Do not disturb the headless screws (4). Take off the Lubricant Pot (5) by pulling it downwards. Taking the weight of the assembly in one hand, remove the two screws (6). The assembly comes away and can be removed by tilting it sideways.

Take a good length of thread (say, 24" (60cm)) and pass it under the roll on the Take-up Lever (7). Pass the wire threader provided in the kit down through the hole (8) in the centre of the gear in the base of the Horn and draw up the thread from (7) through the Horn base and out through (8). Lead the other end out through the front of the machine.

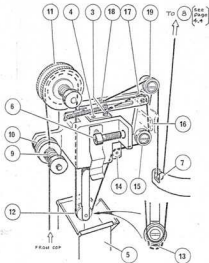
Take the thread coming from the cop and pass it through the hole in the spindle (9) between the two discs of the Thread Straightener (10). It then takes two turns round the aluminium Tension Wheel (11) and goes down under the Lubricator Roll (12). **MAKE SURE** that it passes **INSIDE** the cage at (13), **NOT** as shown by the dotted line. From here, pass it over the small roll (14) and under the roll (15), again ensuring that it is inside the cage.

Take the end of the thread coming from the Take-up Lever (7) and pass it over the roll (19), inside the cage.

The assembly is now refitted to the front of the machine and the thread from (15) led up **BETWEEN THE PLATES OF THE THREAD LOCK (16)** and out through the front of the machine.

Take the Auxiliary Take-up Slide and pass the thread over the front roll (17) and under the sliding roll (18), then refit the Slide to the top of the Tensioning Assembly.

The thread from (19) is now tied securely to the thread from (18) and drawn up through the Horn Base from (8) and cut off below the knot.



Horn threading - all models.

From (8), the thread lies in the groove in the front of the roll (20) and behind the pin (21). Ignore the eye (22), which is no longer used, and pass the thread up through the small hole in the Whirl (23) and out through the Horn Cap.

Replace the Lubricant Pot, which must contain a mixture of 1 part emulsifying oil (provided in the kit) to 10 parts water, sufficient to cover the Lubricator Roll (12). The cap of the oil bottle makes a useful measure.

It is important that the level of lubricant in the pot is not allowed to fall below the centre of the roll, or thread breakage may result.

Shuttle threads:

The bobbin is wound with 5 cord, right twist, pre-waxed thread.

To remove the Bobbin Case from the Shuttle:

Take the punch provided in the kit and press upwards on the spring-loaded bush (24), moving it sideways in the direction of the arrow to free the slide (25) from its groove inside the shuttle; be careful not to drop it.

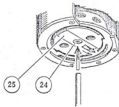
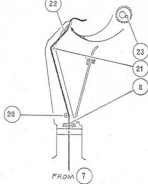
Invert the Bobbin Case and tip out the Bobbin.

To wind the Bobbin:

Place a cop of thread on the cop holder of the bobbin winder.

Pass the thread through the friction rubber (14a) (see Section 3). When the machine is delivered, the rubber will have a length of thread through it and be tied to the eye (14b), so that it will only be necessary to tie the end of this thread to that from the cop and pull it through. Failing this, it can be drawn through the rubber by means of a needle held in a pair of pliers.

Pass the thread through the eye and take it as far as the bobbins on the winder spindle. Slacken the knurled Clamp



Nut (14) sufficiently to enable the two bobbins to be separated and pass the end of the thread through the small hole in the bobbin flange to project about  $\frac{1}{8}$ " (3mm) on the outside. Tighten the Clamp Nut, so that this small projecting end is trapped between the two bobbins and thus held.

Switch on the motor and pull the operating knob (13) to the left, which will start the spindle. As the bobbin fills, guide the thread if necessary with the handle of a knife or similar to keep it level. When full, push in the operating knob. Do not wind so full that the thread projects beyond the flanges of the bobbin, or it will jam in the bobbin case.

Remove the Clamp Nut, take off the full bobbin and, if no more bobbins are to be wound, replace the Nut to prevent it from being lost.

Apply a little oil to the inside of the Bobbin Case and insert the bobbin, passing the thread out through the small hole in the side of the Case. Pull the end of the thread to make sure that it runs freely.

Leaving the thread to hang down, replace the Bobbin Case in the Shuttle in such a position that the lip on the end of the Slide (25) is at the opposite side of the Shuttle from the shuttle point. Press the Bobbin Case back to its original position, when a distinct 'click' will be heard as the spring-loaded bush (24) re-engages in the hole in the Slide.

The machine is now ready for work.

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### Driving Belts

Driving belts must be just tight enough to drive without slipping. Excessive tension will overload the belts and shaft bearings, resulting in overheating and rapid failure.

If, after prolonged use, the belts should show signs of slipping, by the machine slowing down under normal working load, they can be tightened by lowering the motor. Access is by removal of the back panel of the base of the machine; remove the two screws from the top corners of the panel and lift it up and out.

Adjustment is by means of the threaded rod and nuts which support the back of the motor mounting. Slacken the top nut slightly, then turn the nut below the mounting clockwise to allow the motor to drop a little under its own weight. Check carefully that none of the belts is over-tight, then retighten the top nut securely and replace the back panel.

Should it be necessary to replace a belt, these are ordered under the following Part Numbers:- (state whether 3ph. or 1 ph.)

Motor to Clutch: Belt No: 2397; Fastener No: 2396

Clutch to Handwheel: Belt No: 2071; Fastener No: 2396

Motor to Bobbin Winder Countershaft Pulley: Belt No: 2398; Fastener No: 2399

B/Winder C/Shaft Pulley to Bobbin Winder (Round leather): Belt No: 2453; Fastener No: 2454

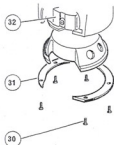
Before removing the belt from the motor to the clutch, note on which step of the motor pulley it is fitted, for correct replacement.

### Shuttle

Should the shuttle be jammed by a piece of thread becoming trapped in it, it must be removed to clear the obstruction.

Remove the five screws (30) which hold the Shuttle Ring (31) in position. Be prepared for the Ring and Shuttle to come away when the last screw is removed; these are expensive precision parts and must not be dropped. If, after removing the Ring, the Shuttle does not come out readily, insert a screwdriver in the space above it and prise gently downwards.

Thoroughly clean and inspect the parts, lightly oil and replace. When refitting the Ring, insert all five screws loosely before tightening any and tighten them evenly all round. After assembly, it must be possible to move the



Shuttle freely with the finger within the "play" left between it and the Shuttle Driver (32) for the passage of the thread. If the Shuttle is tight, dismantle again and investigate.

#### Thread Divider (33)

The setting of this part is of utmost importance.

To check it, turn the machine slowly by hand so that the needle is rising, pulling up a loop of thread. Hold the two strands of the loop together at the Horn Tip, as they would be if drawn through the needle hole in the work and watch the action of the Divider as it moves from right to left. It must pass under the needle, with its point in line with the needle point, just not touching it, so that it will pass cleanly through the loop, separating the threads for the entry of the Shuttle point. Should adjustment be necessary, the Divider is made of malleable steel and can be carefully bent with pliers into the correct position, being careful not to raise any burrs on it which could snag the thread.

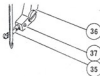
To remove the Divider, take out the screw (34) and lift it off. When replacing, if a new screw is to be used, first remove the Shuttle and check, after inserting (34), that it does not protrude through the back of the Shuttle Driver, where it could catch the thread or bind the Shuttle. If it does, remove it, and grind off just sufficient for it to lie flush with the back of the Driver.



#### Thread Lifter (35)

This must be set so that, as the Shuttle point passes through the thread loop, the Lifter takes the loop from behind the needle and holds it whilst the descending needle runs clear of it and then releases it to pass over the Shuttle. It is retained in the Lever (36) by the screw (37); if this screw is slackened, the Lifter may be moved in or out to regulate its length. If too short, it will miss the loop, leaving the thread on the barb of the needle when the Shuttle tries to take it, and the thread will break.

As well as being set to the correct length, the Lifter must lie close to the back of the needle, with just sufficient clearance for the thread to pass easily between them. Should this require adjustment, the Lifter, like the Divider, is of malleable steel and can be bent, again being careful not to burr it.



### Whirl and Pinion

These are highly stressed and probably the first to wear out and require replacement. When the teeth become badly worn, excessive backlash makes it impossible to maintain the precise timing necessary to place the thread on the barb of the needle. Missed stitches will occur, particularly when the Horn is turned to stitch round toes, and the parts must then be replaced.

### Replacement

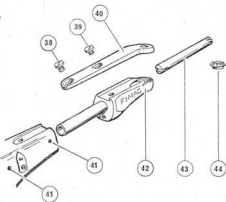
Remove the two screws (38) and (39). Note that (39) is shorter than (38) and goes nearer the tip of the Horn. Lift off the Horn Cap (40). Slacken the two screws (41) and withdraw the Horn Tip (42). The Pinion (43) is loose and may either come away with the Tip or be left protruding from the Horn; in either case, remove and discard it, together with the worn Whirl (44).

Replace the Tip (42). Obstruction may be felt, preventing it from being pushed right in; this will be when it comes against the end of the Pinion Shaft inside the Horn. Gently rotating the Horn back and forth whilst pushing in the Tip will lead the Shaft into the bore of the Tip and enable it to be pushed fully home. Do not tighten the screws (41) yet.

Lightly oil the new Pinion and insert it in the Tip, rotating it until its forked lower end engages with the tongue on the Pinion Shaft, so that it can be pushed fully home.

Check the wear in the pinion-to-shaft joint by attempting to rotate the Pinion. If it can be moved more than half a tooth overall, the wear in the joint is excessive and the Shaft must also be replaced. Remove the Horn Tip and Pinion; insert a pair of tweezers or long pointed pliers into the bore of the Horn and lift out the Shaft. Insert the new Shaft (forked end downwards) and rotate until it goes fully home. Refit the Horn Tip and Pinion as previously described.

Keeping one finger on the end of the Pinion to prevent it from coming out, withdraw the Tip sufficiently to permit the Whirl to be placed in position so that its teeth will engage with the Pinion when the Tip is pushed home, but do not push the Tip home yet, as the Whirl must be timed first, in accordance with instructions on the following page.





### To time the Whirl:

Turn the machine by hand, so that, with the needle rising, its point is just level with the under face of the shuttle, as at (45). Turn the Horn with its back towards the operator; the Whirl must be set as shown, with the small hole at the position of five on a clock-face. Push the Horn Tip fully home in the Horn.

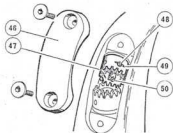
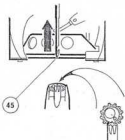
Before tightening the two screws (41) to secure the Horn Tip, the Cap (40) must first be refitted and the screws (38) and (39) tightened to ensure alignment.

After tightening (41), carefully rotate the Horn. It must turn freely; if any resistance is felt, it will be because the new Pinion is fouling the underside of the Horn Cap and/or its teeth are meshing too deeply with the Whirl. This is adjusted as follows:

Remove the Horn Cap (40).

Remove the Cover (46) on the back of the Horn.

Turning the Horn a little will cause the bevel gear (47) to rotate, revealing the three binding screws. One of these screws (48) is identified by having a groove (49) out across the hole. Slacken this screw one turn; this will free the Pinion Adjusting Screw (50). Turn the Adjusting Screw anti-clockwise, whilst pressing the Pinion down with a finger, to lower the Pinion and take it further out of mesh with the Whirl. The correct adjustment is to have the teeth well in mesh, but the Pinion not fouling the inside of the Cap, which can only be found by experiment. When a satisfactory adjustment has been made, re-tighten the screw (48) to lock it and replace the Cover (46) and the Horn Cap (40).



FAULT FINDING

An asterisk (\*) against an item in the "Remedy" column indicates that this is best carried out by a Service Engineer.

NOTE: Thread breakage is often caused by bad handling and faulty preparation of work. Ensure that there are no faults in these regions before adjusting the machine.

Indication	Possible cause	Remedy
<p>Horn thread breaks;</p> <p>(a) as needle draws thread up.</p> <p>(b) as thread passes over shuttle.</p> <p>(c) below Whirl. (generally with bunching of strands)</p>	<p>(a)(1) Worn or damaged needle barb.</p> <p>(a)(2) Insufficient thread lubricant.</p> <p>(a)(3) Too much thread tension.</p> <p>(a)(4) Thread entangled below Horn. (see "Operating", Section 5)</p> <p>(b)(1) Incorrect setting of Divider.</p> <p>(b)(2) Incorrect setting of Lifter.</p> <p>(b)(3) Shuttle too tight, due to obstruction.</p> <p>(b)(4) Sharp edges on Shuttle and/or Divider and Lifter.</p> <p>(c)(1) Worn or damaged needle barb.</p> <p>(c)(2) Sharp edges on Whirl thread hole.</p> <p>(c)(3) Needle too high, through wear in needle motion.</p>	<p>Fit new needle.</p> <p>Top up lubricant pot.</p> <p>Release tension slightly.</p> <p>Check course of thread through tension, lock and take-up.</p> <p>Check and correct.</p> <p>Check and correct.</p> <p>Remove and clean shuttle and shuttle race.</p> <p>Check and polish with fine emery cloth and oil; clean thoroughly before reassembling.</p> <p>Fit new needle.</p> <p>Polish with string emery; clean thoroughly before reassembling.</p> <p>Fit new parts. *</p>
<p>Shuttle thread breaks.</p>	<p>Thread jammed due to badly wound bobbin.</p> <p>Sharp edge on hole in bobbin case.</p>	<p>Replace with properly wound bobbin.</p> <p>Polish with string emery; clean thoroughly before reassembling.</p>

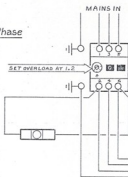
FAULT FINDING (continued)

Indication	Possible cause	Remedy
Repeated jamming of thread loop in Shuttle race.	See (b)(3) above.	
Missed stitches, particularly when rounding toe.	Excessive wear in Whirl and Pinion. Needle incorrectly set.	Fit new Whirl and Pinion (see "Maintenance", Section 7) Re-set.
Uneven stitch length.	Worn Presser Foot (slipping). Worn parts in Presser Foot motion.	Fit new Presser Foot. Fit new parts.* (Some improvement may result from increasing Presser Foot Spring pressure)

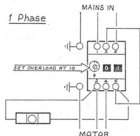
WIRING DIAGRAM

'MASCOTTE' 1268B  
LOCKSTITCH BLAKE MACHINE

3 Phase



1 Phase

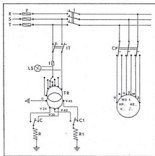


The following parts and/or instructions constitute safety devices and/or instructions in accordance with Section 6 (10) of the Health & Safety at Work etc. Act, 1974.

Part	Instructions
Driving pulley belt guard Bobbin winder belt guard	The machine must not be run unless these guards are properly fitted.
Head column upper and lower cover plates.	The machine must not be run unless these cover plates are properly fitted.
Take-up inspection cover.	The machine must not be run unless the cover is properly fitted.
Base front panel. Base back panel.	The machine must be isolated from the mains power supply when either panel is open. The electrical warning labels must be clearly legible.
Foot treadle guard.	The machine must not be switched on unless the guard is properly fitted.
General.	The machine must be isolated from the mains power supply before carrying out any maintenance operation.

## ILLUSTRATED PARTS LIST

- |        |  |
|--------|--|
| Drq. 1 | Horn assembly ML (Curved Horn)                     |
| 2      | Horn assembly MLO (Straight Horn)                  |
| 3      | Feed motion; Foot raising; Shuttle drive (part of) |
| 4      | Presser Foot assembly                              |
| 5      | Needle Bar motion; Shuttle drive (part of)         |
| 6      | Shuttle assembly                                   |
| 7      | Thread Lock and Take-up                            |
| 8      | Head Column internal gearing                       |
| 9      | Thread Feeder assembly                             |
| 10     | Countershaft and Clutch assembly                   |
| 11     | Bobbin Winder                                      |



N. cat.	Sim-bolo	Description
E1	I	Three-pole switch (motor)
E2	IT	Two-pole switch (transformer)
E3	C C1	Unipolar commutator (shuttle/winder)
E4	TR	Transformer 250 VA
E5	F	Three-pole fuse box
E6	f	Volt changer with fuses 4 A
E7	LS	Warning light
E8/1	CP	Polarity commutator
E8/2	CP	Three-pole switch
160	R R1	Resistance 24 V 100 W

N. cat.	Sim-bolo	Description
E1	I	Interruttore tripolare (motore)
E2	IT	Interruttore bipolare (trasformatore)
E3	C C1	Commutatore unipolare (bobineur)
E4	TR	Transformateur 250 VA
E5	F	Tableau des fusibles tripolaires
E6	f	Variateur de voltage avec des fusibles 4 A.
E7	LS	Lampe de signalisation
E8/1	CP	Commutateur de polarité
E8/2	CP	Interruteur tripolaire
160	R R1	Résistance à bougie 24 V 100 W

N. cat.	Sim-bolo	Description
E1	I	Interruttore tripolare (motore)
E2	IT	Interruttore bipolare (trasformatore)
E3	C C1	Commutatore unipolare (spoletta/spolatore)
E4	TR	Trasformatore 250 VA
E5	F	Portafusibili tripolari
E6	f	Varia volts con fusibili 4 A
E7	LS	Lampada di segnalazione
E8/1	CP	Commutatore di polarità
E8/2	CP	Interruttore tripolare
160	R R1	Resistenza a candola 24 V 100 W

N. cat.	Sim-bolo	Description
E1	I	Interruptor tripolar (motor)
E2	IT	Interruptor bipolar (transformador)
E3	C C1	Commutador unipolar (lanzadera-deslanzadera)
E4	TR	Transformador 250 VA
E5	F	Portafusibles tripolares
E6	f	Cambiador de voltios con fusibles 4 A
E7	LS	Lámpara de señalización
E8/1	CP	Commutador de polaridad
E8/2	CP	Interruptor tripolar
160	R R1	Resistencia de bujía 24 V 100 W

N. cat.	Sim-bolo	Description
E1	I	Dreipolchscher (Motor)
E2	IT	Zweipoliger Schalter (Transformator)
E3	C C1	Einpoliger Umschalter (Untertadenapolett-Spulenrichtung)
E4	TR	Transformator 250 VA
E5	F	Dreipolige Sicherungshalter
E6	f	Voltwandler mit Abschmelzsicherungen 4 A.
E7	LS	Signallampe
E8/1	CP	Polumschalter
E8/2	CP	Dreipolchscher
160	R R1	Kerzenwiderstand 24 V 100 W



GRUPPO BICORNA - ML -

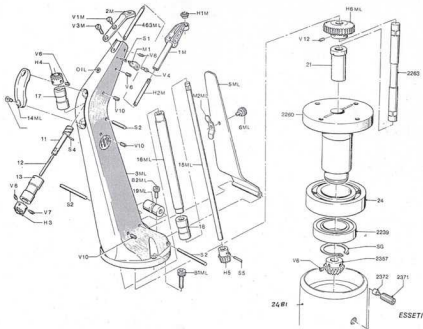
HORN - ML - ASSEMBLY  
GRUPE BICORNE - ML -GRUPPE HORN - ML -  
GRUPO BICORNIA - ML -

1268

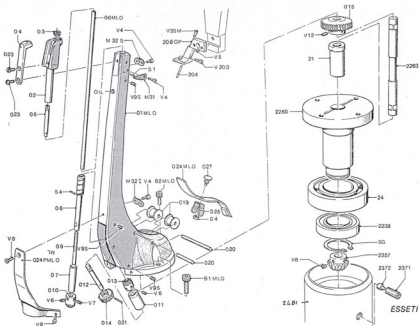
Tavola - Drawing

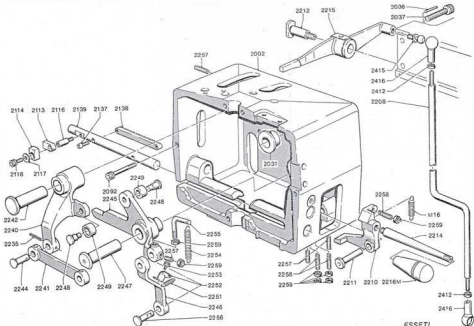
Table - Bild - Dwg

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ESSETI



