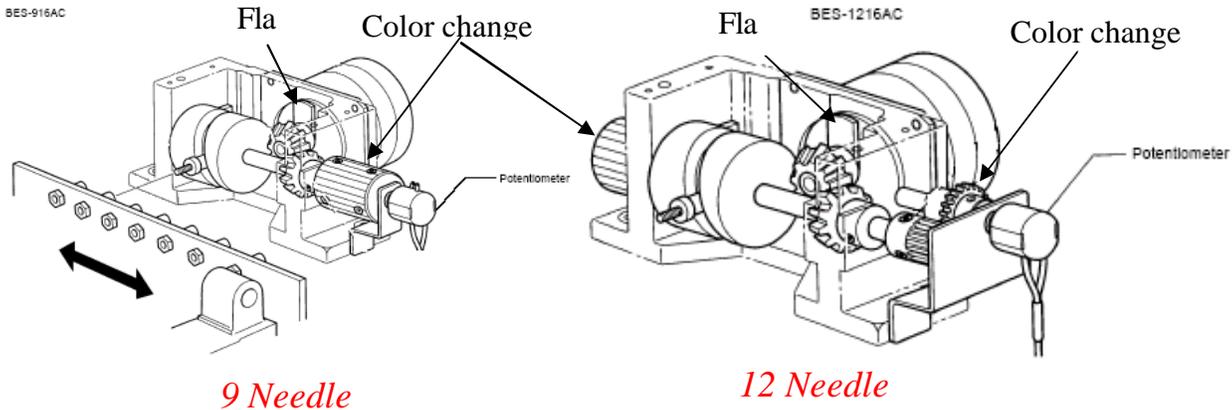
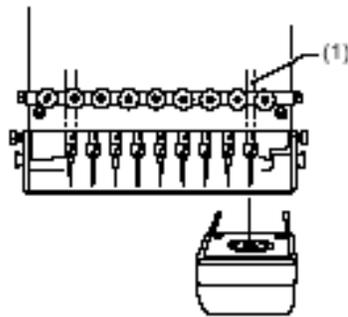
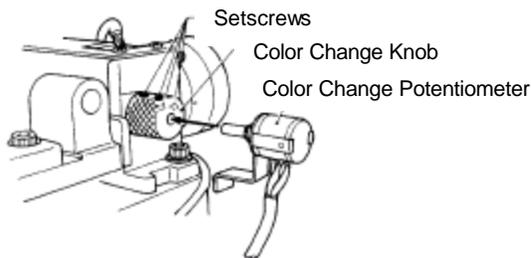


**Title:** Color Change Potentiometer Replacement for SA style machines  
**Date:** March 3, 2009  
**Models:** BES-916, BES-1216, BE-0901 & BE-1201

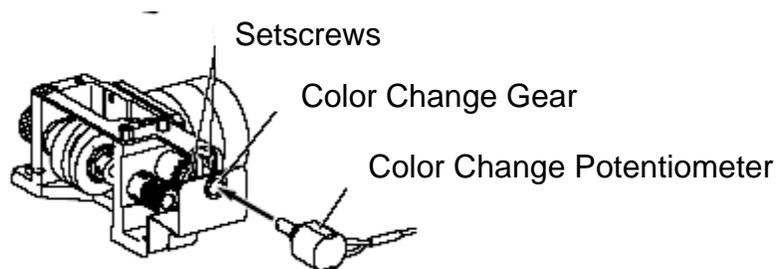
With power to the machine off, turn color change knob until machine is on needle number one and the flag on the motor gear is sticking straight up. The flag will be underneath the color change assembly cover and can best be viewed with a flashlight aiming at approximately 45 degrees into the color change assembly at about the height of the take-up levers from the right hand side of the machine.



Remove the old color change potentiometer by loosening the two outer setscrews, the ones closest to the potentiometer, that hold the color change potentiometer to the gear or knob, depending on whether you have a 9 or 12 needle machine, and slide the color change potentiometer out.

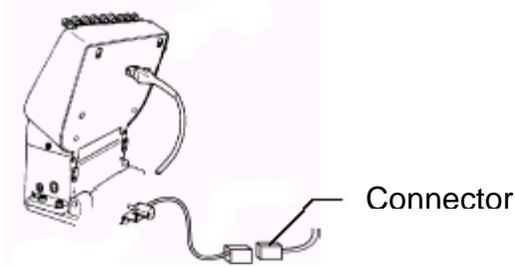


9 Needle Machine

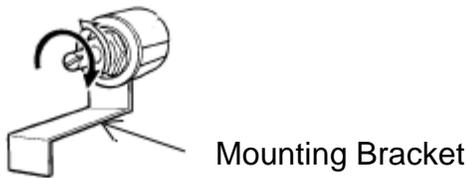


12 Needle Machine

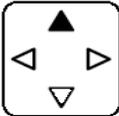
Unplug the old color change potentiometer by following the cable out of the potentiometer and unplugging at the connector.



Remove the mounting bracket from the old color change potentiometer with a wrench and install on the new potentiometer in the same orientation as the old one.



Plug the new color change potentiometer into the connector but do not connect mechanically to the machine.

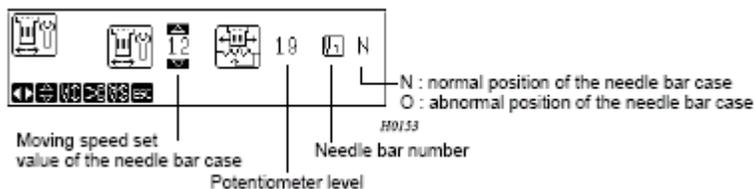
Press and hold the up arrow,  on the panel while turning on the machine. Continue to hold up arrow down until a menu is displayed asking you to confirm going into test mode. Press the  to

go into the test mode. It will then ask you for a password. Input    and press the  key.

Select the  icon with the  or  jog key and press the  key.

Select the  icon with the  or  jog key and press the  key.

The following screen will be displayed.



Turn the shaft sticking out of the potentiometer slowly until you get a reading of 19 on the potentiometer level on the display. The machine will also start beep continuously when the number 19 is displayed.

Insert the new potentiometer into the knob or gear of the color change assembly being careful not to turn the shaft while doing it. After you get the potentiometer in place, the machine should still be beeping and 19 displayed on the panel. If not, then turn shaft of potentiometer until it comes back.

Tighten the two outer setscrews of the color change assembly knob or gear to hold it in place. One setscrew will be accessible from the top, which you should do first. Then, turn the color change knob to get to the other one.

Press the  key and turn the power off to the machine.

Power back on the machine and check the color changing. It should be fine and the machine ready to run.