

SUPER HIGH SPEED OVERLOCK SEWING MACHINE

**Operation Manual
Parts Book**



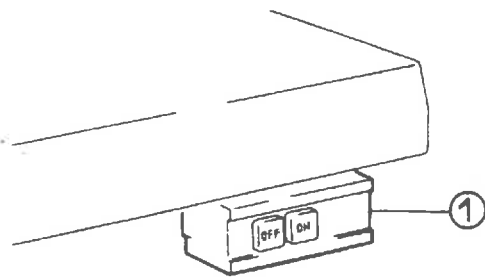
为了安全

对于缝纫机本身及各种装置，我们充分考虑它的安全性。请遵照基本的操作方法，安全的进行工作

- 拆除为保证安全所设置的装置、零件的情况下使用，是非常危险的，请绝对不要拆除后使用。
- 缝纫机在使用时，请不要在缝纫机台板上放置工具及缝纫时不必要的物品。
- 在对缝纫机进行检修、调节、清扫、穿线、换针等时，为防止发生事故，务必请切断电源。在确定即使踩缝纫机踏板，缝纫机也不动之后，再进行操作。

注意

使用离合式马达的情况下，在关掉电源①后因惯性作用马达仍会继续旋转。这时如不注意踩动缝纫机踏板②时，缝纫机会突然动作，这是很危险的。请在关掉电源后，仍继续踩动踏板②，直至缝纫机完全停下来为止。



- 在离开缝纫机台时，请务必关掉电源。
- 停电时也请务必关掉电源。
- 为了总是安全地、运转良好的使用缝纫机，日常的检点是不可缺少的。请予以注意。



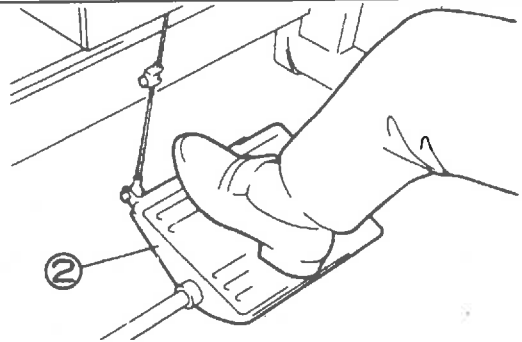
CAUTION

OBSERVE THESE SAFETY PRECAUTIONS
Though takes the utmost care to produce safe sewing machines and devices, operators should follow these basic safety rules.

- To prevent accidents, do not remove safety devices or parts while operating the machine.
- Do not leave tools or other unnecessary objects on the machine table while operating the machine.
- Before maintenance, adjusting, cleaning, threading or replacing the needle, and to prevent accidents, be sure the power is turned off. Check that the machine will not operate when the pedal is pressed.

Note

In case a clutch type motor is used, it will keep on rotating by inertia after turning off power supply. ① If the machine pedal ② is stepped on inadvertently, it is dangerous because the machine will move unexpectedly. Keep on stepping on the pedal ② until the machine comes to a stop after turning off power supply.



- Turn the power off before leaving the machine table.
- In the event of a power failure, be sure to turn the machine off.
- Check that the machine is securely grounded.

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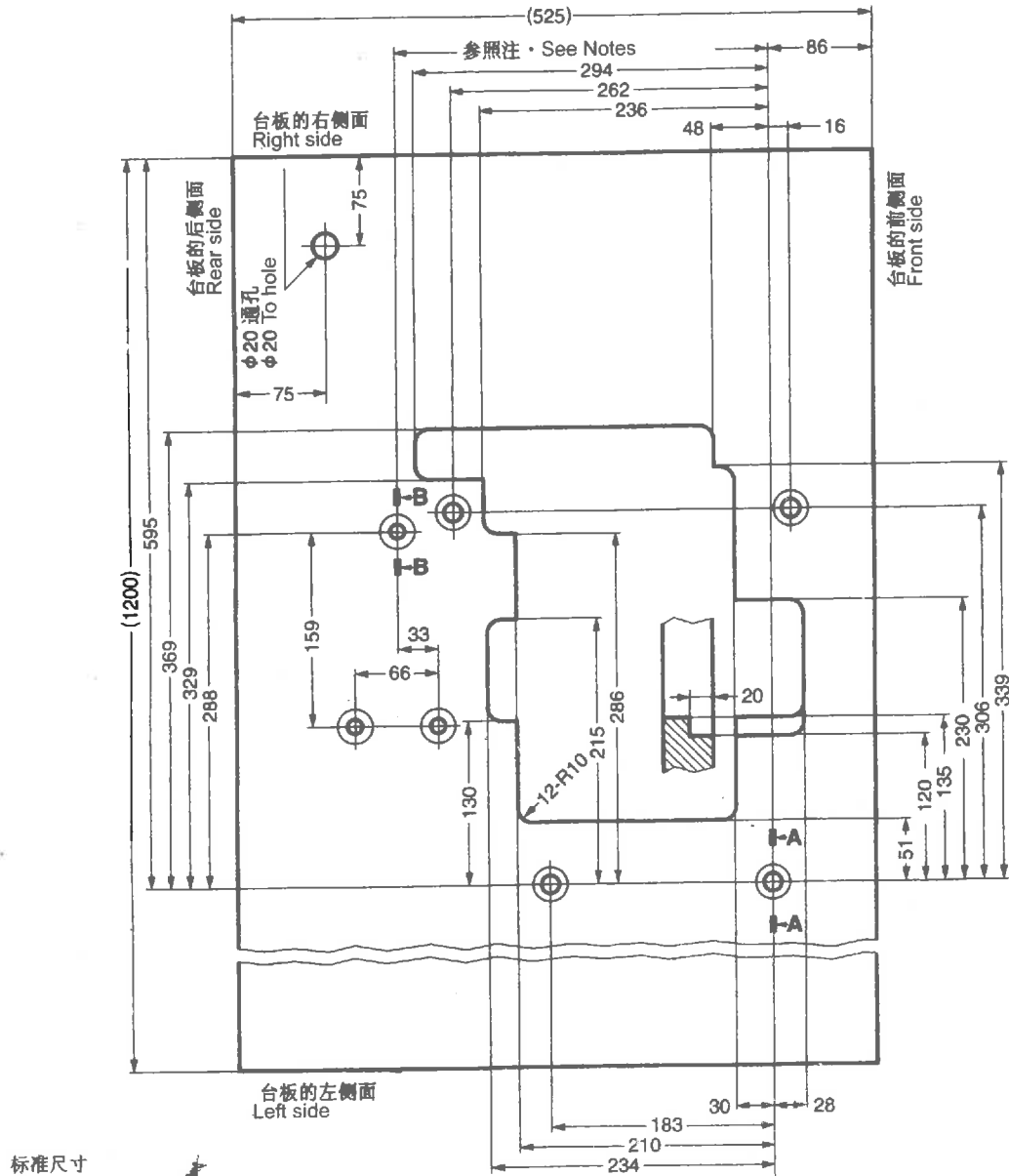
在使用之前
BEFORE OPERATING

台板加工图

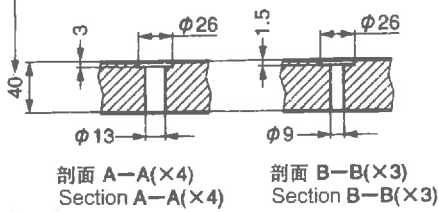
Schematic diagram of the machine table

请参照下图进行台板的加工。

Cut the table referring to the diagram.



标准尺寸
Standard dimension



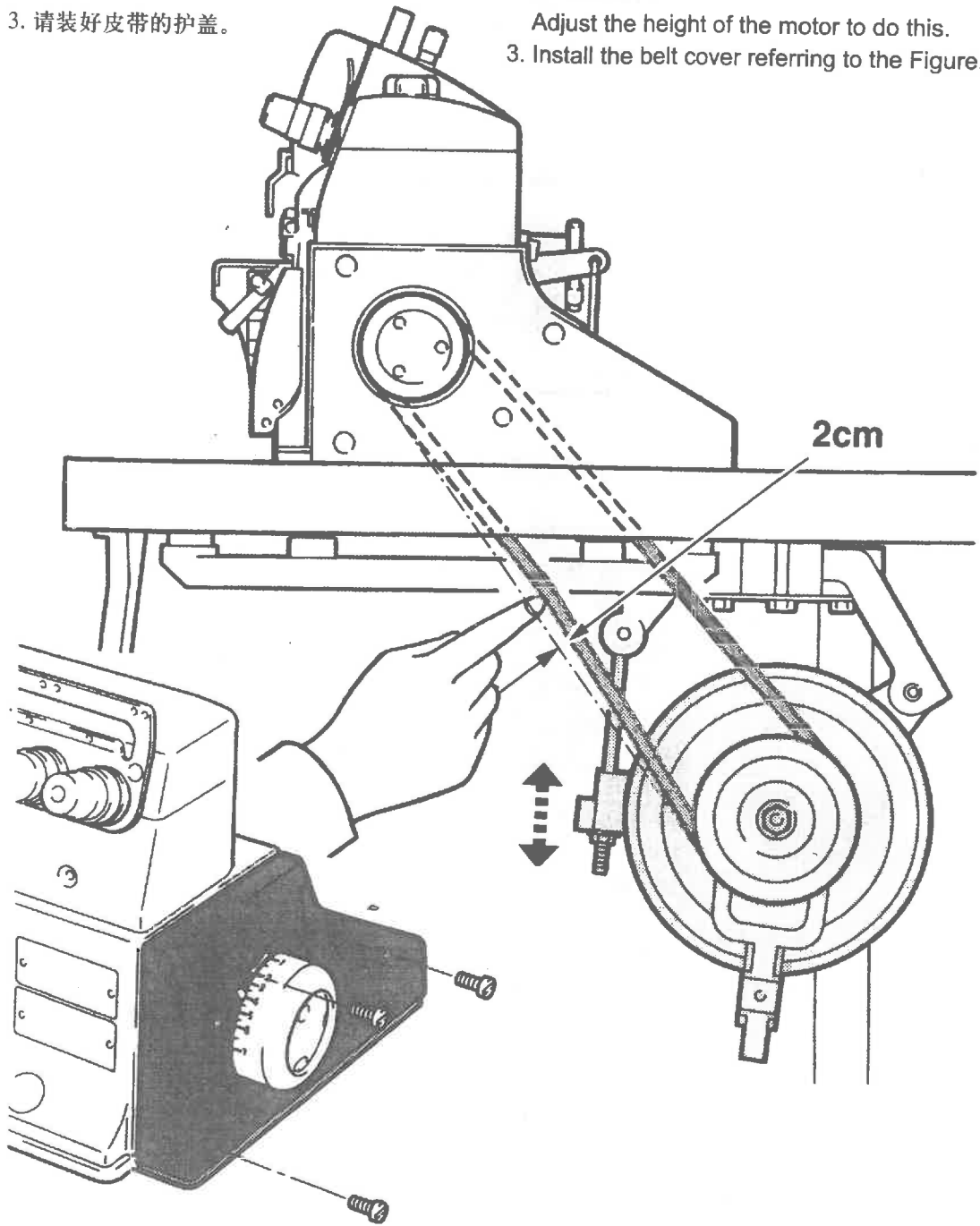
- 注
- 使用类似于日本产的马达时 306mm
 - 使用类似德国EFKA或QUICK公司马达时 334mm
- Notes
- Dimension for motors in Japan 306mm
 - Dimension for EFK motor 334mm

在使用之前
BEFORE OPERATING

缝纫机的安装方法 Installing the machine head

1. 将缝纫机装于台板之上，给缝纫机侧皮带轮和马达侧皮带轮装上V形皮带。
2. 将马达高低调整到用手按压皮带中间，约有2cm左右的松弛量为好。
3. 请装好皮带的护盖。

1. Mount the machine head on the machine rest board.
2. Adjust the tension of the belt so that it can be about 2cm bent inward when you press the middle of it.
Adjust the height of the motor to do this.
3. Install the belt cover referring to the Figure.

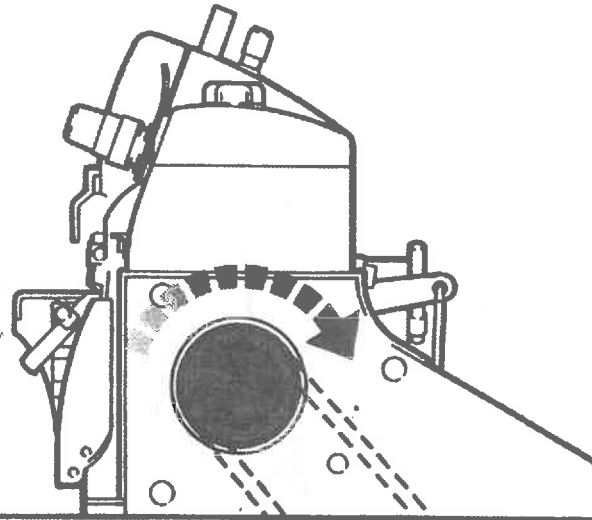


在使用之前
BEFORE OPERATING

缝纫机的旋转方向及转数 The machine speed and turning direction

缝纫机的旋转方向，从皮带轮侧看是向右转的。

The machine pulley rotates clockwise as seen from the machine pulley side.



参照下表选用与所使用的缝纫机对应的转数

Check your machine type and run it at appropriate speed as listed in the table below.

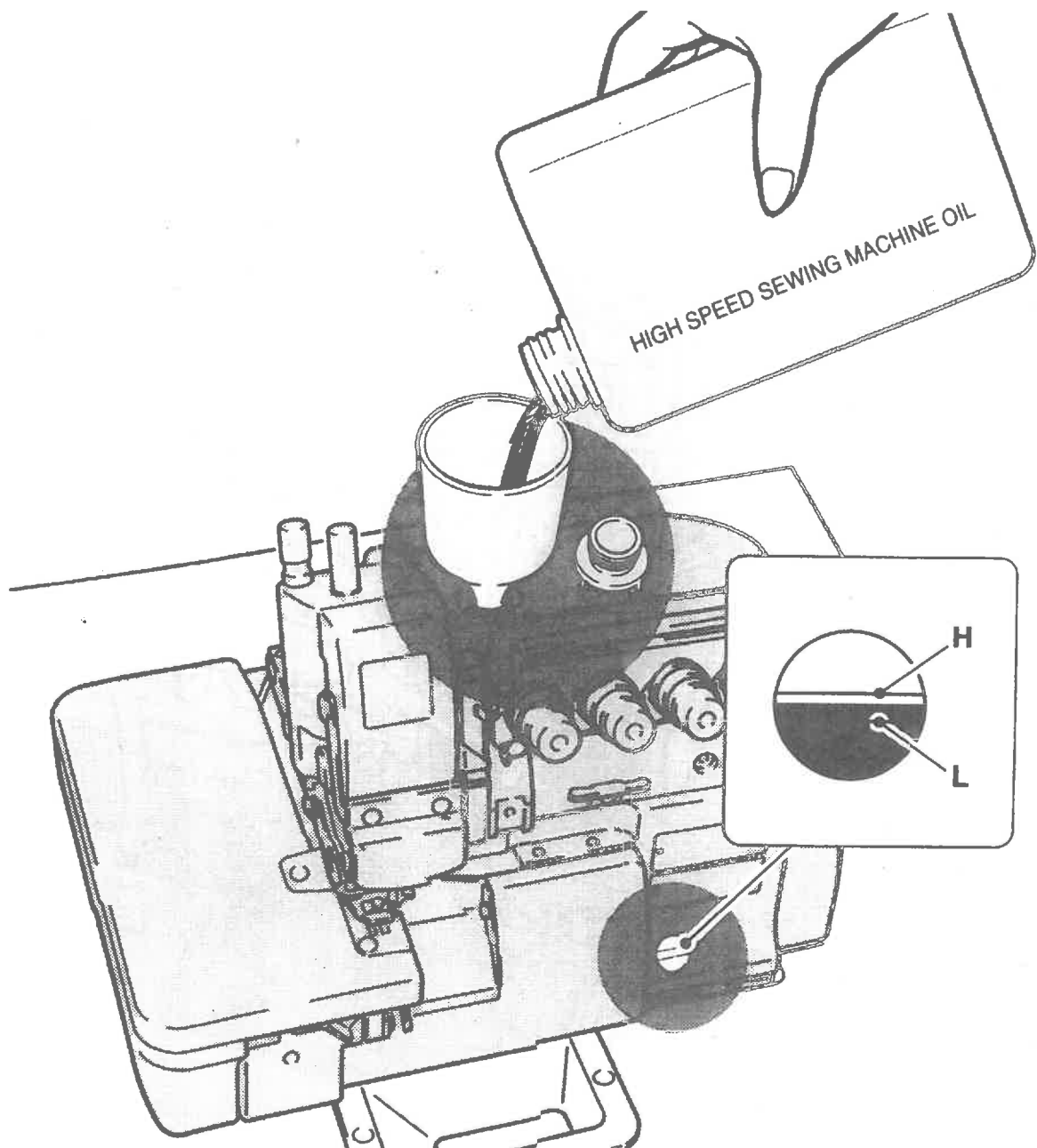
缝纫机机型 Modelo de máquina	最高旋转数 (r.p.m) Velocidad máxima (r.p.m)
700-36	6,500
700-38	6,500
700-48	5,500
700-48P2	5,000
700-70	6,500
700-86	5,500
700-355	6,000
700-01	7,000
700-13	6,500
700-16S2	6,500
700-17	7,000
700-23B	6,000
700-54A	5,000
700-55A	5,000
700-180	7,000
700-181	6,500

在使用之前
BEFORE OPERATING

供油 Lubrication

加油量是使油面处于H线与L线之间为好。
当油面低于L线时，就要及时补充机油。
机油请使用本公司指定的 [HIGH SPEED SEWING MACHINE OIL] (ISO 粘度与 VG22 相同)。

After filling the oil pan, the oil surface should lie between (H) and (L) lines.
Add oil, when the oil surface reaches or goes below (L).
Note: Use recommended [HIGH SPEED SEWING MACHINE OIL]. (ISO VG22)



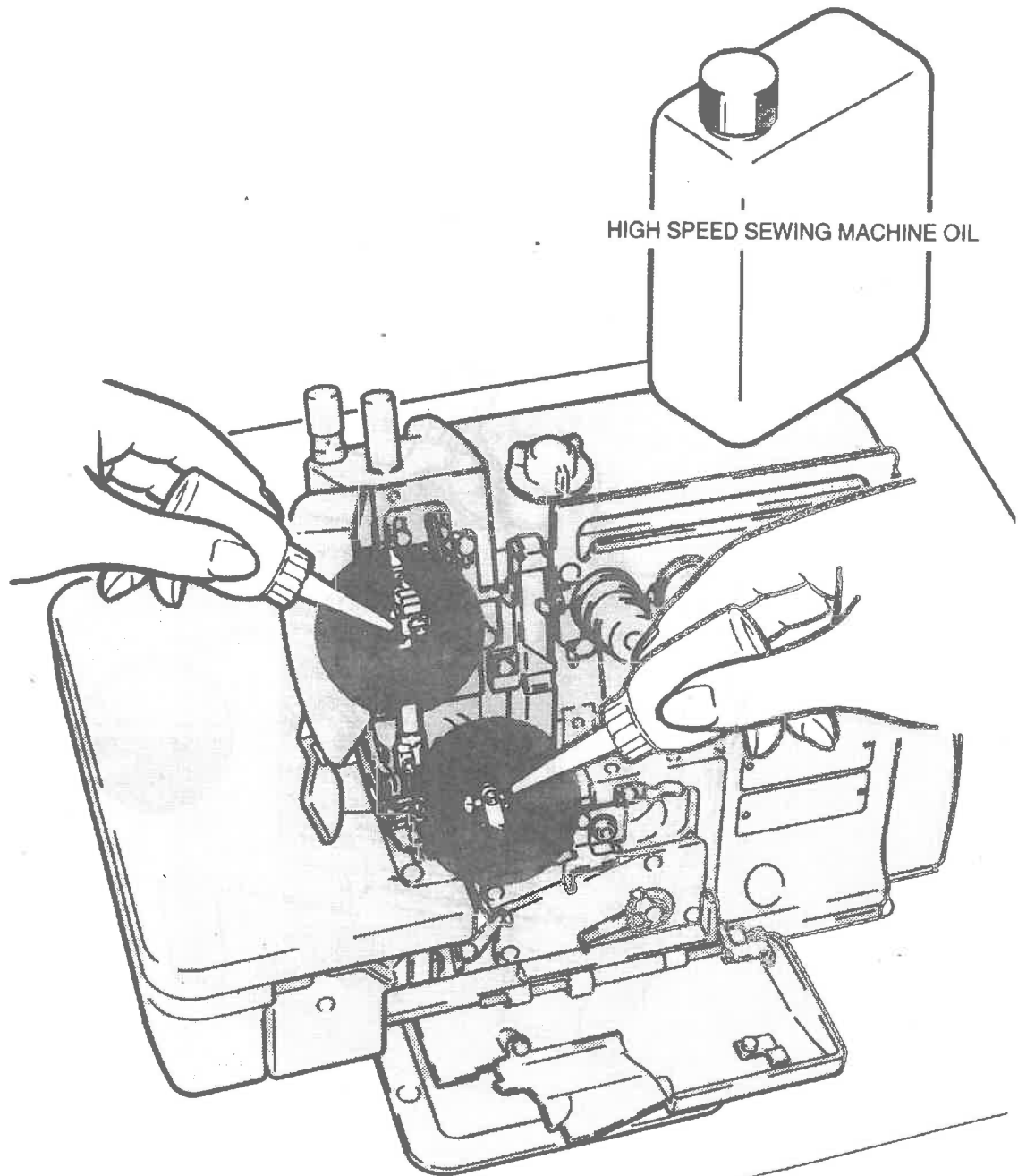
在使用之前
BEFORE OPERATING

手动供油 Manual lubrication

手动给油是在缝纫机最初开始使用时。或相当一段时间没使用了时，请供给2~3滴油。机油请使用本公司指定的 [HIGH SPEED SEWING MACHINE OIL] (ISO 粘度 VG22 相同)。

Apply 2 or 3 drops of oil by hand when the machine is used for the first time or has been left unused for some time.

Note: Use recommended [HIGH SPEED SEWING MACHINE OIL]. (ISO VG22)



在使用之前
BEFORE OPERATING

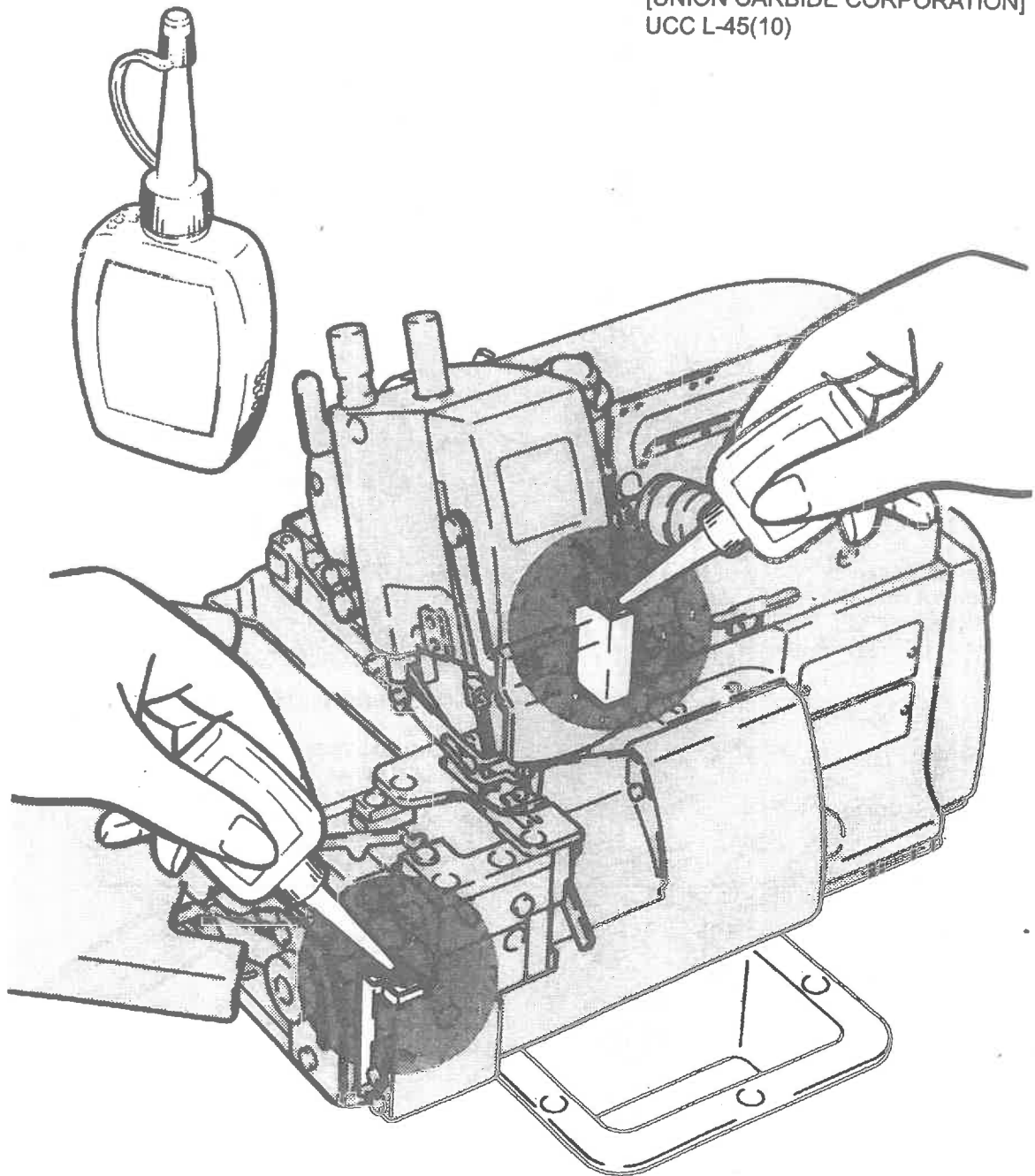
给HR装置供油 Filling the HR device with silicon oil

为了防止布纤维或线被切断，请尽早给HR装置供油。

注：关于购买硅酯油，请咨询缝纫机代销店或与本公司营业所联系。

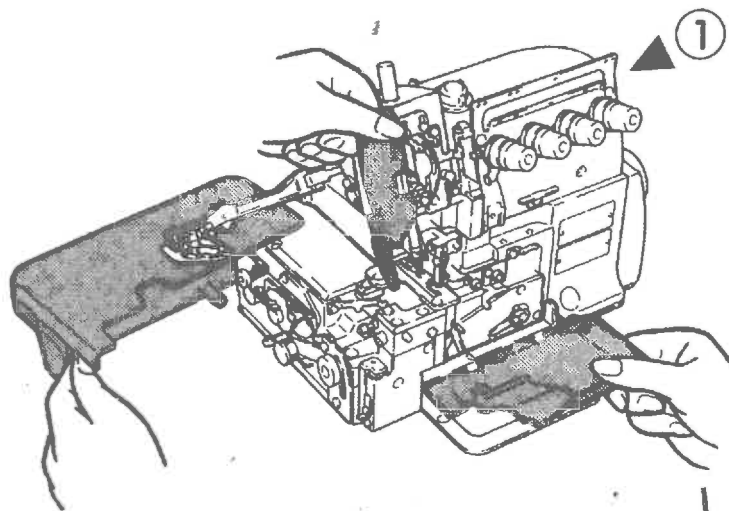
Fill the device with oil before it is too low in order to prevent needle thread breakage and fabric damage.

Note: Use recommended silicon oil
[UNION CARBIDE CORPORATION]
UCC L-45(10)



在使用之前
BEFORE OPERATING

穿线的方法 Threading



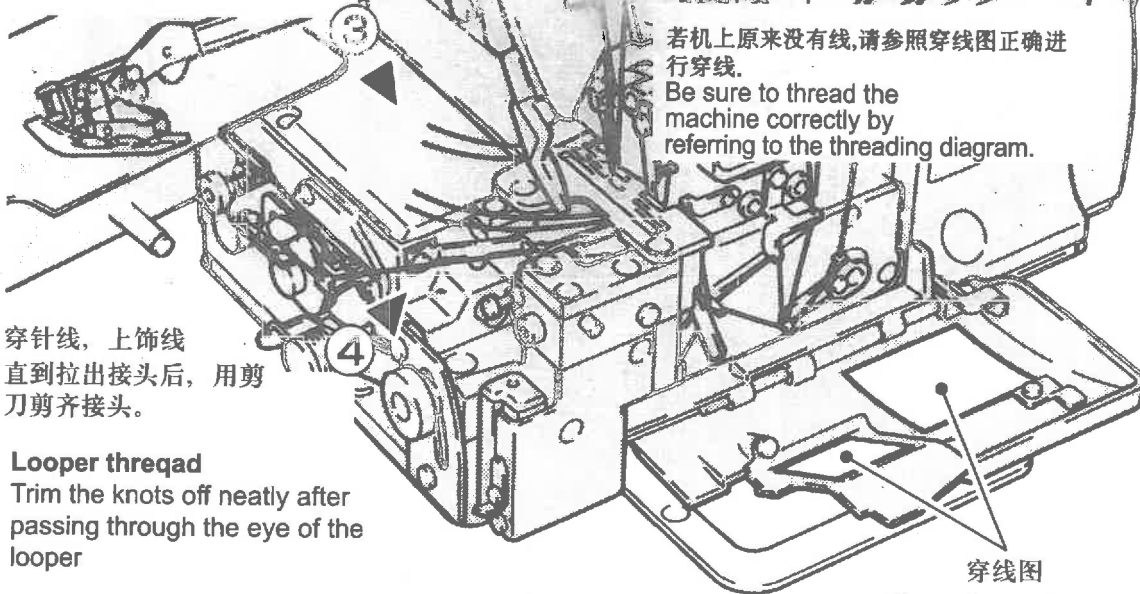
- ① 打开压脚杆及机盖（三处）
Open three covers.
Sewing the presser foot aside.

把机上原有的线与缝纫
用线绑结在一起。

Knot the preset thread and the
thread being used to
thread the machine.

针线
将线拉到针眼前，剪掉
结头再次穿好针线。

Needle thread
Trim the knots off neatly
before passing through
the eye of the needle to
rethread.



若机上原来没有线,请参照穿线图正确进
行穿线。
Be sure to thread the
machine correctly by
referring to the threading diagram.

穿针线，上饰线
直到拉出接头后，用剪
刀剪齐接头。

Looper thread
Trim the knots off neatly after
passing through the eye of the
looper

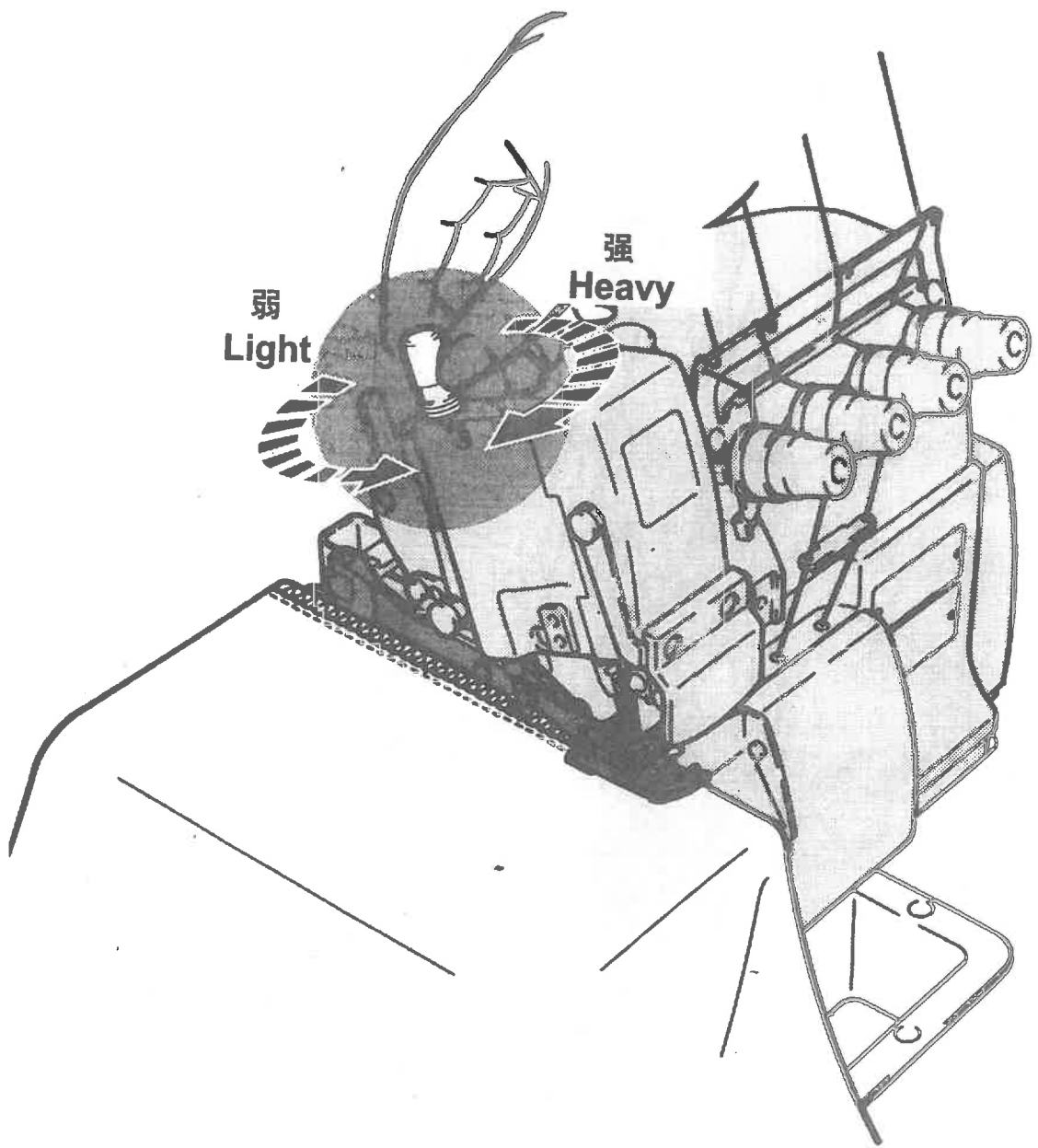
穿线图
Threading diagram

试缝
TEST SEWING

压脚压力的调节 Adjusting the presser foot pressure

压脚压力的调节可旋转螺帽进行调节。在送布状态良好并能取得均匀针脚的范围內，尽可能使用较弱的压力为好。

Turn adjusting screw to adjust the presser foot pressure. It should be as light as possible, yet be sufficient to obtain the proper stitch formation.



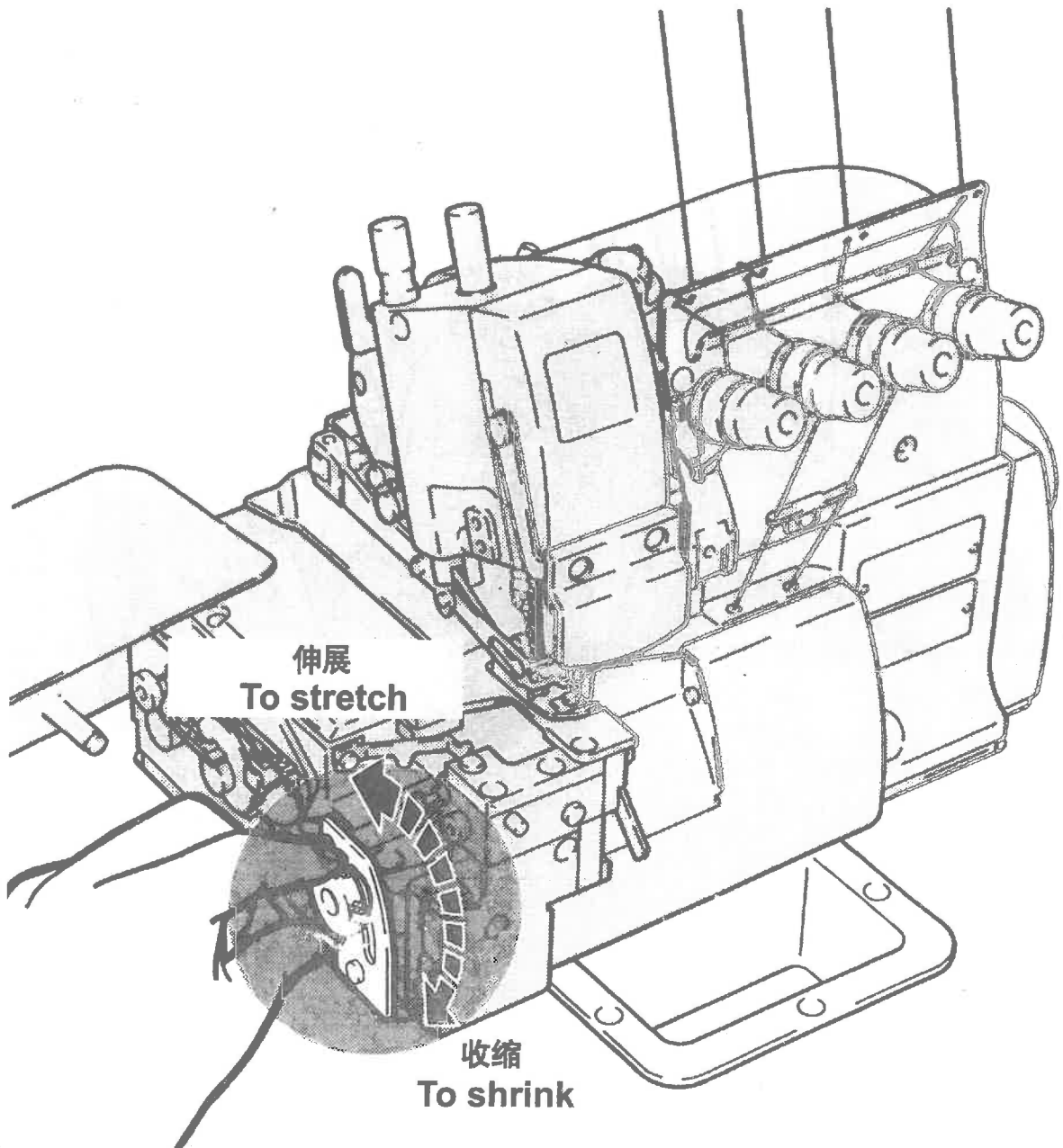
试缝
TEST SEWING

差动比的调节 Adjusting the diff. feed ratio

差动比的调节是松开螺母后，上下移动来进行调节。调节完后，将螺母拧紧。

Loosen the nut and move the lever up and down to obtain the correct differential feed ratio.

Tighten the nut after positioning the lever as desired.



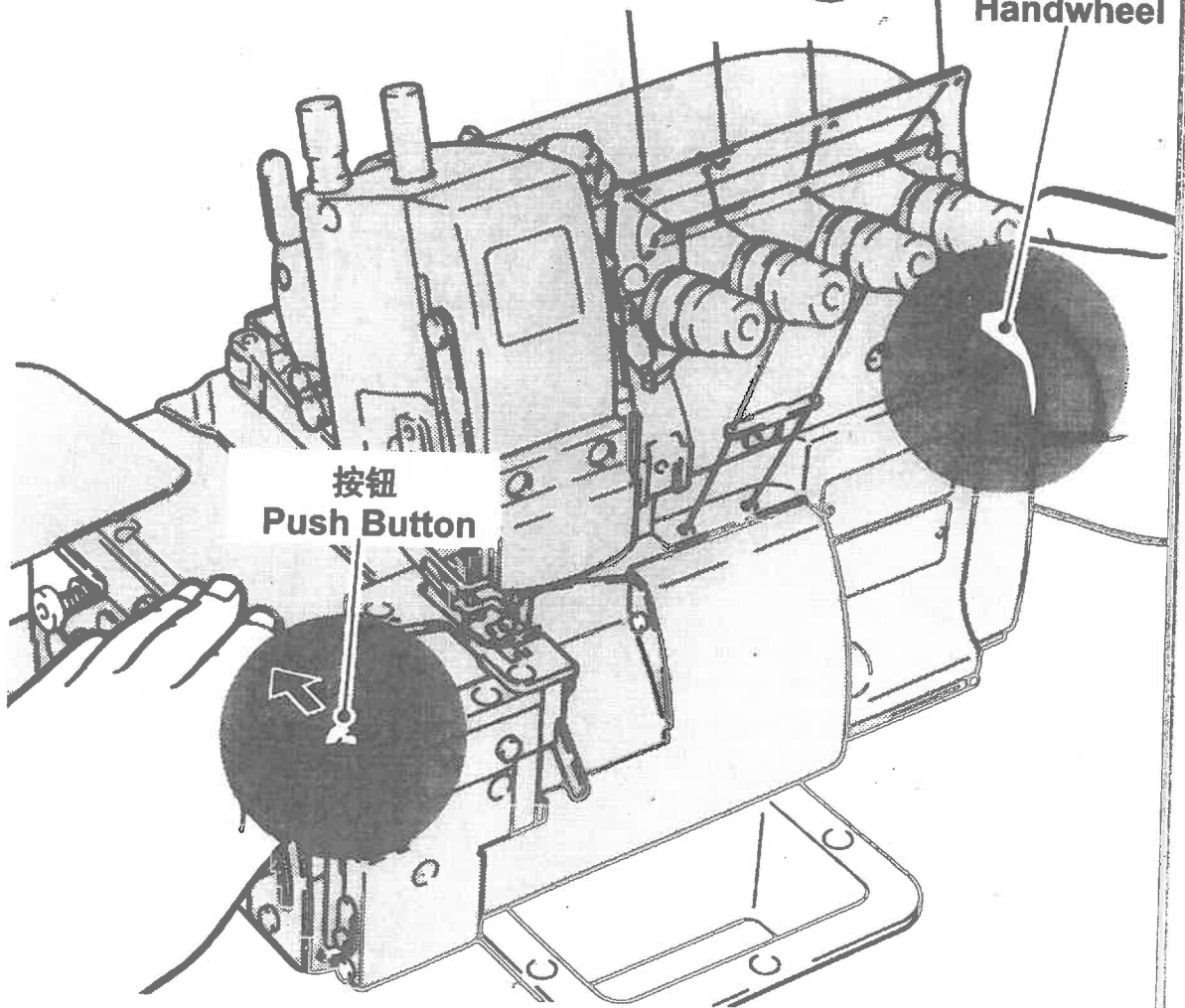
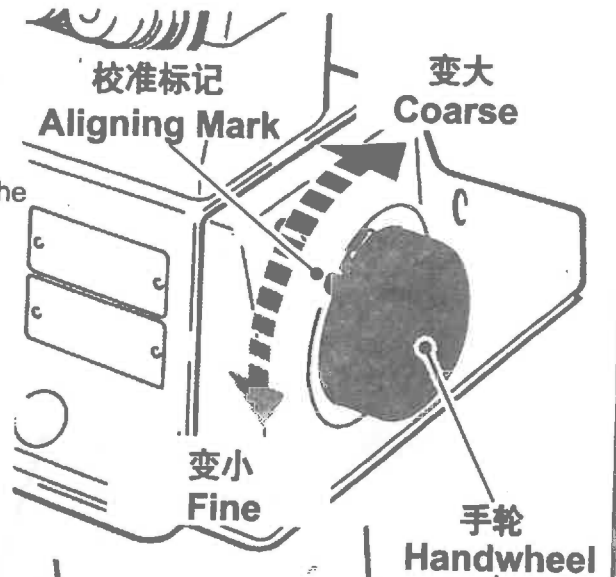
针脚长度的调节 Adjusting the stitch length

1. 摁住按钮，旋转手轮，按钮会陷进更深处。
2. 这时边摁住按钮，边转动手轮，使校准标记号对准所希望的数值。

- ① While pressing the push button, turn the handwheel to seek the position at which the push button goes further into the depth.
- ② Then, keeping the push button pressed, turn the handwheel and set the desired scale to the aligning mark.

注：针脚长度的调节务必请在调节差动比之后进行。

Note: Stitch length adjustment must only be made after the differential feed ratio has been changed.

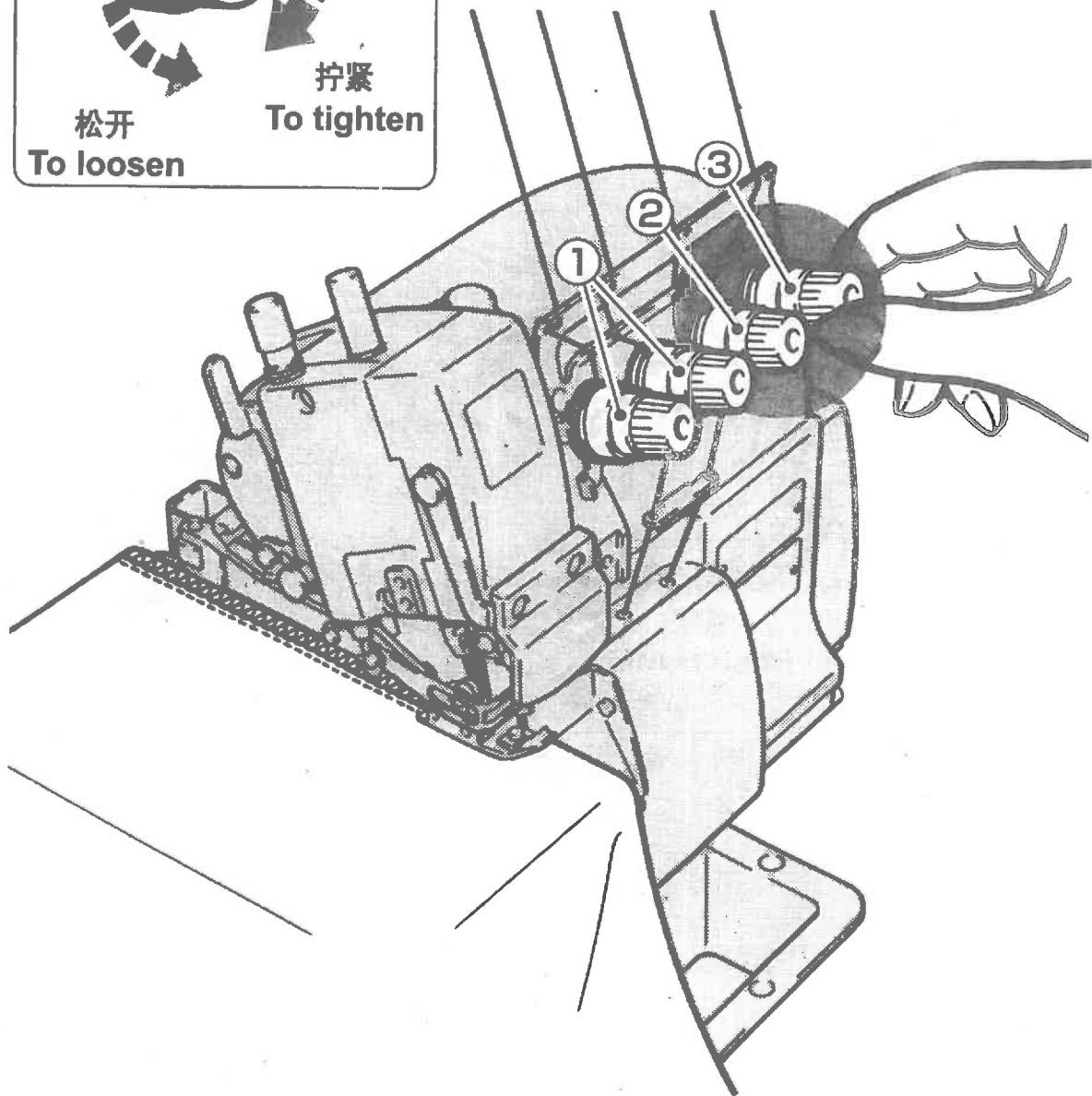
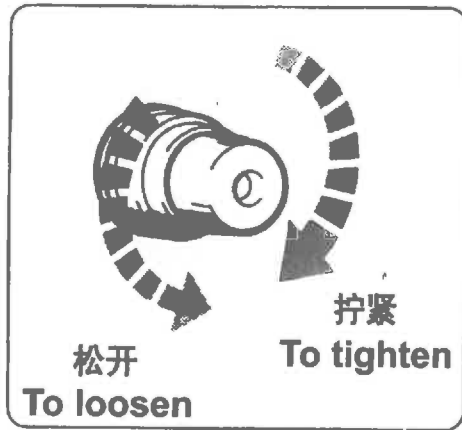




线状态的调节 Adjusting the thread tension

线张力状态的调节，请用针线调节螺帽①、上弯针线调节螺帽②、弯针线调节螺帽③来进行调节。

Make tension adjustments with the needle thread knob ①, the upper looper knob ②, and the lower looper knob ③.

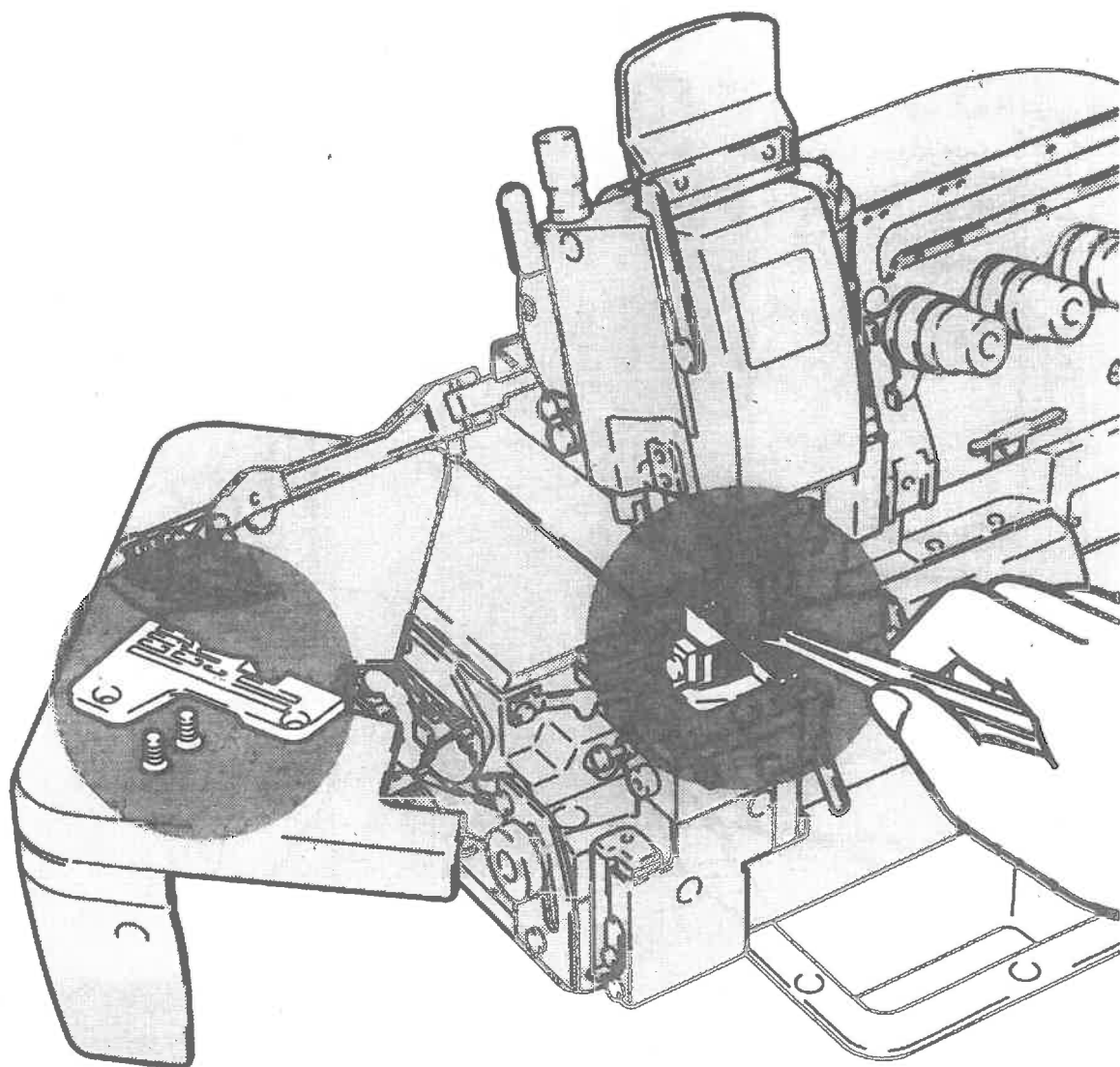


使用中的保养
MAINTENANCE
DURING USE

缝纫机的清扫 Cleaning the machine

缝纫机的清扫，以针板槽及送布牙周围为主。

Mainly the slots of the needle plate and the feed rows should be cleaned.



使用中的保养
MAINTENANCE
DURING USE

换针

Replacing the needle

准确辨认针的前后，请将针凹向着后方，即背向操作者进行安装。

针要牢固的插到孔的最深处。

- Check the needle carefully to see that the scarf is turned to the rear of the machine.
- Insert the needle to the proper depth, and fasten securely.

标准使用的缝纫针，请参照卷末附有的“机针标准”。

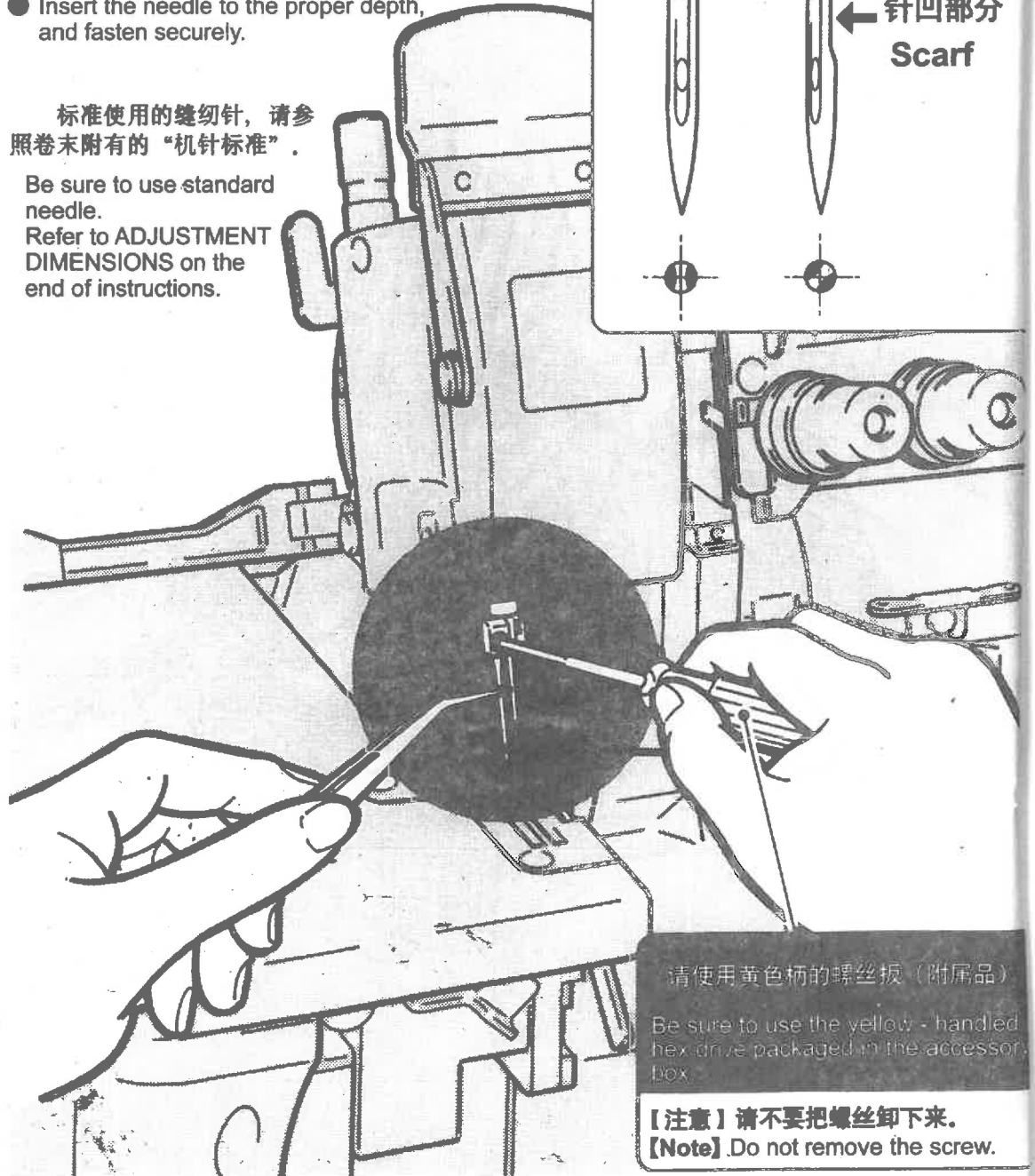
Be sure to use standard needle.
Refer to ADJUSTMENT DIMENSIONS on the end of instructions.

OK!

NO!



← 针凹部分
Scarf



请使用黄色柄的螺丝扳（附属品）

Be sure to use the yellow - handled hex drive packaged in the accessor box.

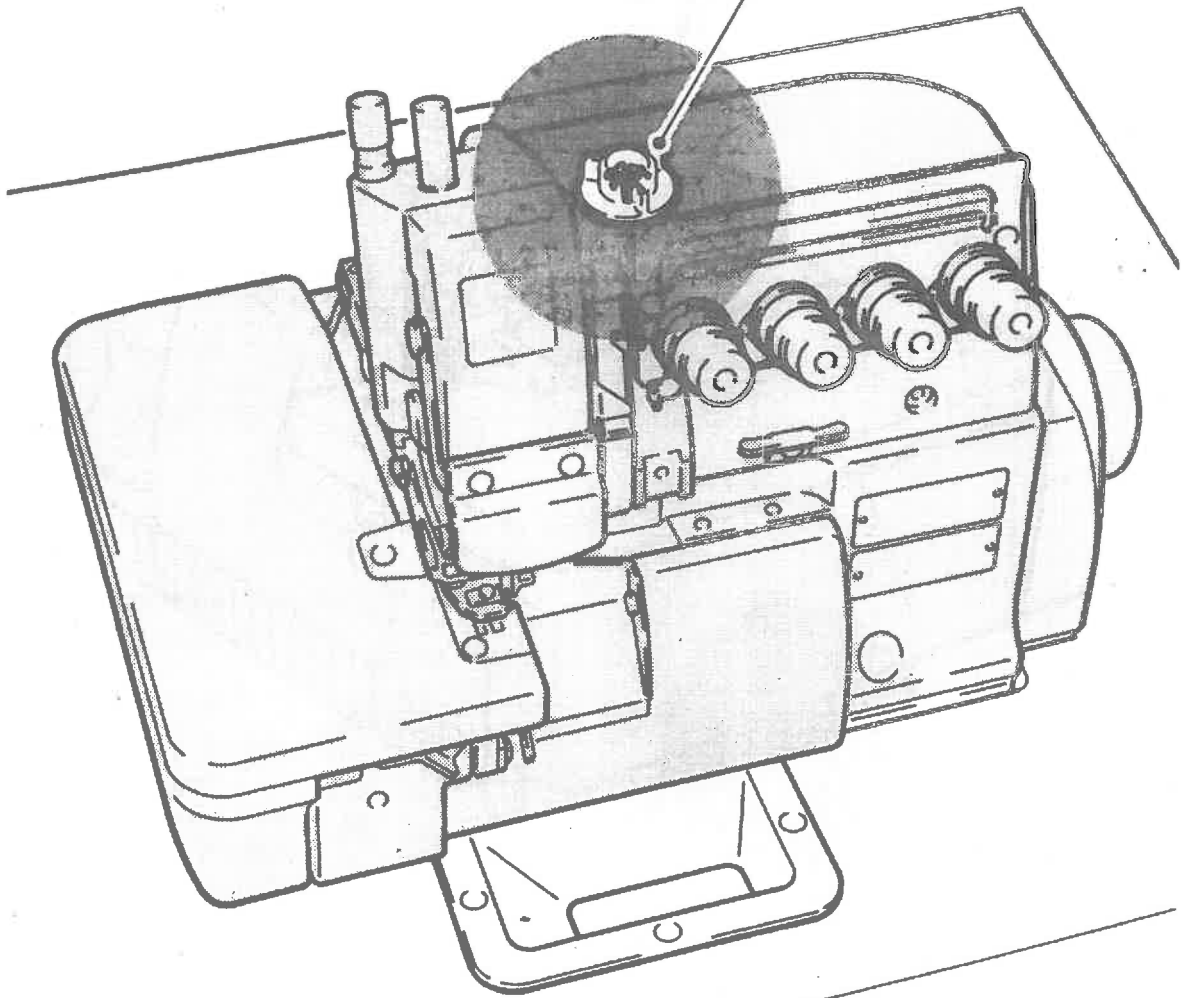
【注意】 请不要把螺丝卸下来。

【Note】 Do not remove the screw.

使用中的保养
MAINTENANCE
DURING USE

检查机油的循环 Checking the oil circulation

OK! 运转中
Operating



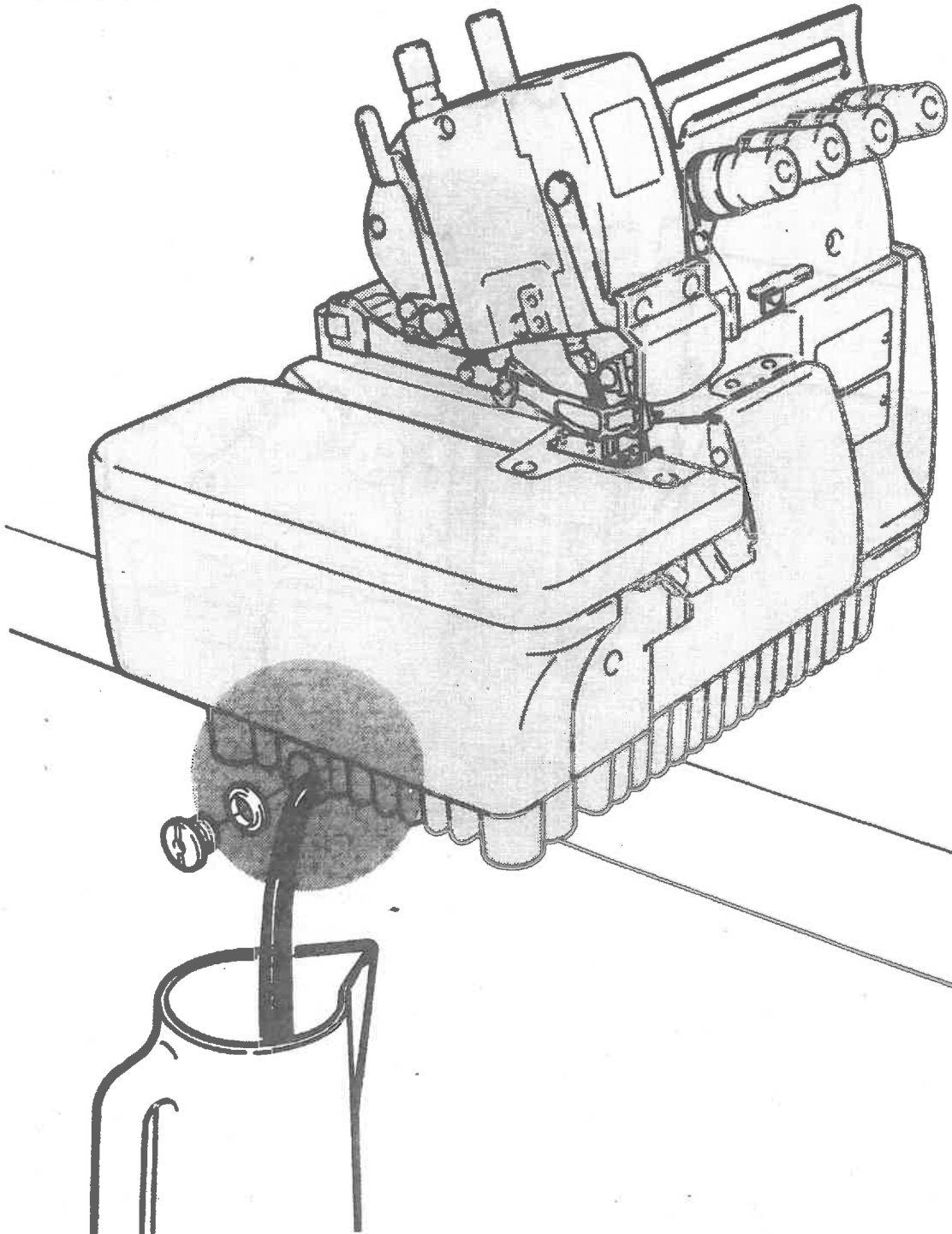
使用中的保养
MAINTENANCE
DURING USE

换机油 Replacing the oil

机油的更换，请在使用开始1个月后更换一次，然后，每6个月更换一次。

供油请参见第5页。

Replacing the oil one month after the first use and every six months thereafter. (See p 5.)

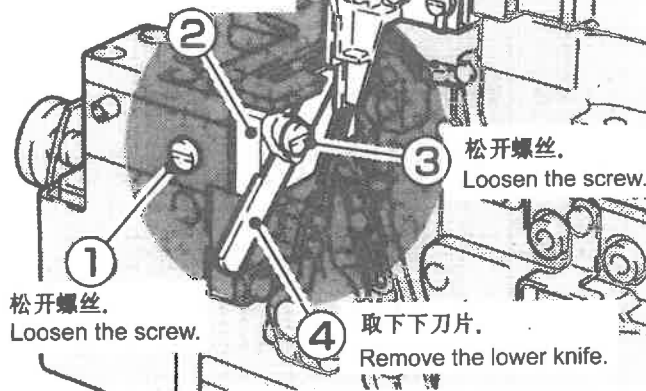


下刀片的更换 Replacing the lower knife

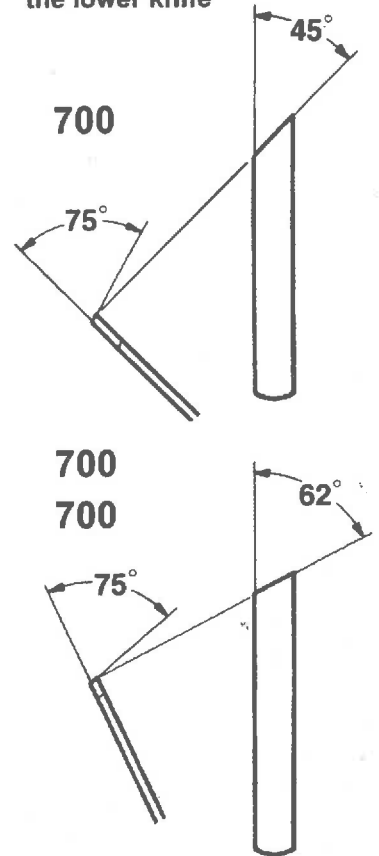
卸下下刀片 To remove the lower knife

把下刀架推向左边，
用螺丝①暂时固定。

Temporarily screw ①
after sliding the lower
knife holder to the left.



下刀片正确的研磨角度 Correct angles to resharpen the lower knife

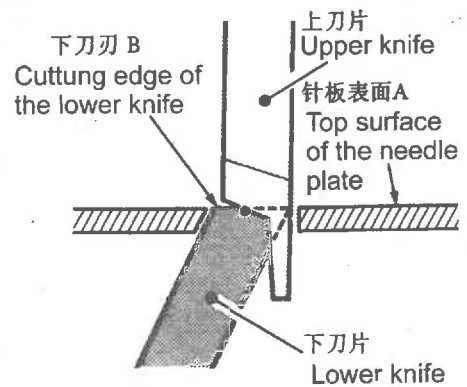
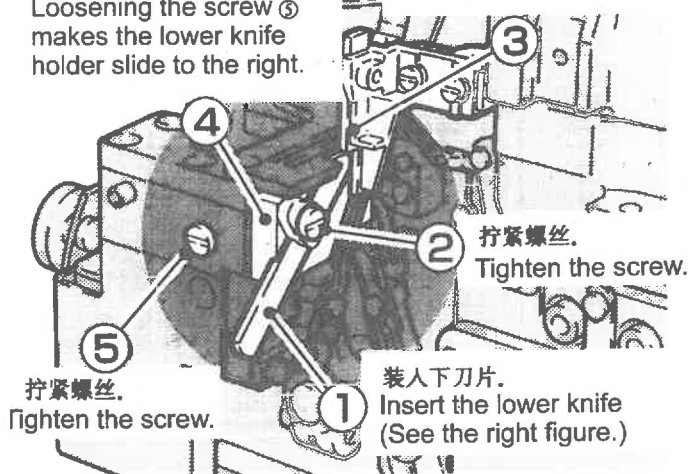


安装下刀片 To replace the lower knife

松开螺丝⑤，下刀架则
向右移动。
Loosening the screw ⑤
makes the lower knife
holder slide to the right.

转动手轮将上刀移动对准如
右图所示位置。

Turn the handwheel as the
drawing on the right figure.



使针板表面A与下刀刃B处于相同水平位置。










Level of [A] = Level of [B]

装好下刀片后进行剪线，确认剪切状况。










Check cutting action of knife

700 调整标准参数表 Adjustment dimensions

(mm)

									
700-36	10.6	3.9	5.1	0.9~1.1	5.5	1.5			
700-38	10.6	3.9	5.1	0.9~1.1	5.5	1.5			
700-48	10.1	3.9	5.1	0.9~1.1	5.5	1.5			
700-48P2	10.1	3.9	5.1	0.9~1.1	5.0	1.5			
700-70	10.6	3.9	5.1	0.9~1.1	5.5	1.5			
700-86	12.0	3.6	5.1	0.9~1.1	5.5	1.5			
700-355	12.0	3.6	5.8	0.9~1.1	5.5	1.5			

700 调整标准参数表 Adjustment dimensions

									
700-01	10.1	4.2	5.1	0.9~1.1	5.5				
700-13	10.4	4.2	5.8	0.9~1.1	5.5				
700-16S2	10.1	4.2	5.1	0.9~1.1	5.5				
700-17	10.1	4.2	5.1	0.9~1.1	5.5				
700-23B	11.6	4.2	5.8	0.9~1.1	7.0				
700-54A	10.1	4.2	5.1	0.9~1.1	6.0				
700-55A	10.4	4.2	5.8	0.9~1.1	5.5				
700-180	10.1	4.2	5.1	0.9~1.1	5.5				
700-181	10.4	4.2	5.8	0.9~1.1	5.5				

700 机针标准

Standard needle

	Organ DC X 27	
700-36	11	
700-38	14	
700-48	14	
700-48P2	14	
700-70	14	
700-86	21	
700-355	11	

700 机针标准

Standard needle

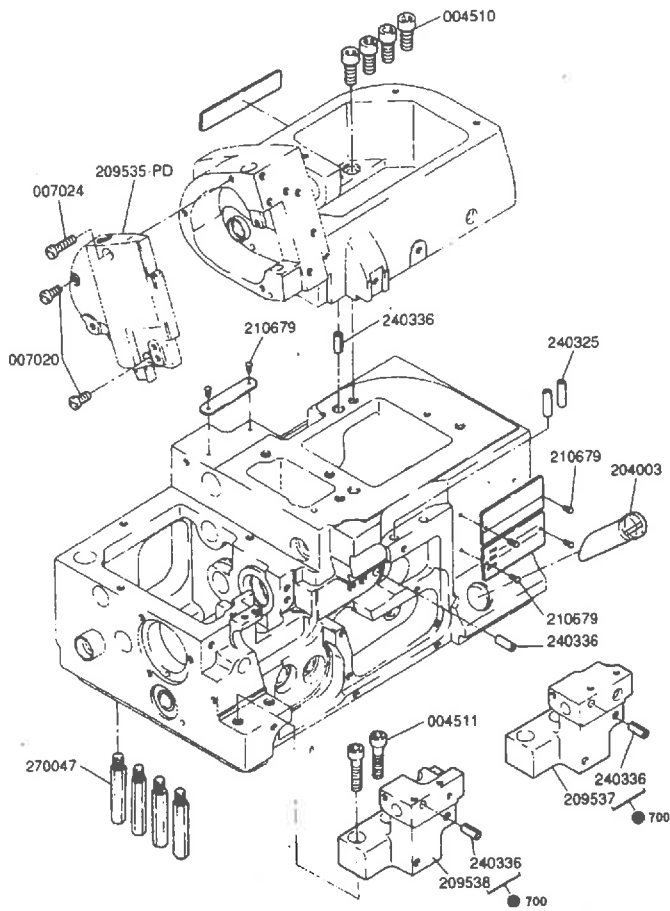
	Organ DC X 27	
700-01	9	
700-13	9	
700-16S2	11	
700-17	9	
700-23B	14	
700-54A	14	
700-55A	9	
700-180	9	
700-181	9	

700 针号对照表

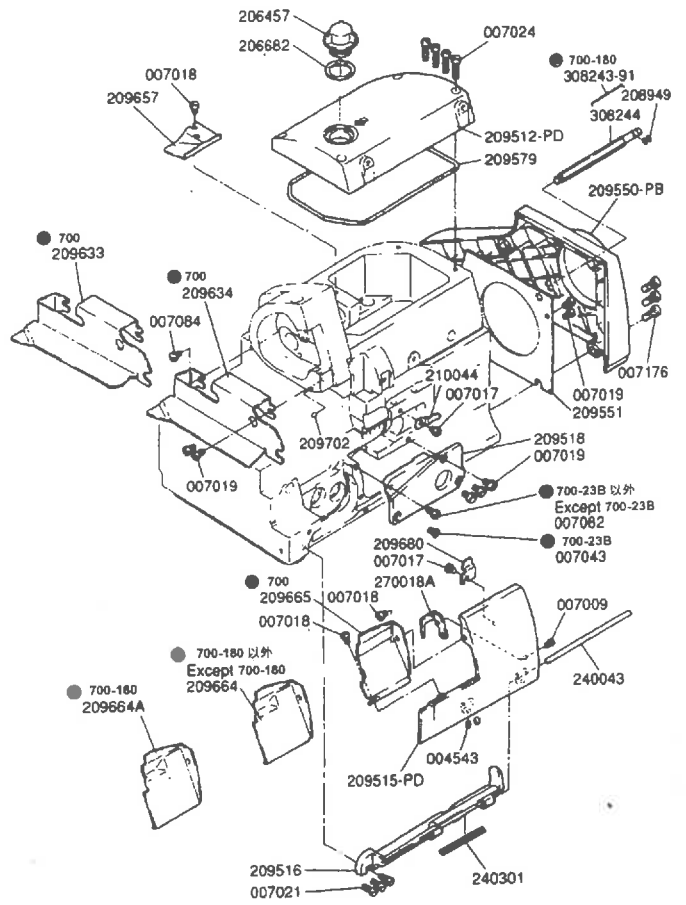
Comparison table for needle sizes

日本针号(Organ) Japanese size (Organ)	#	9	11	14	16	18	21
德国针号(Schmetz) Metric size (Schmetz)	N/m	65	75	90	100	110	130

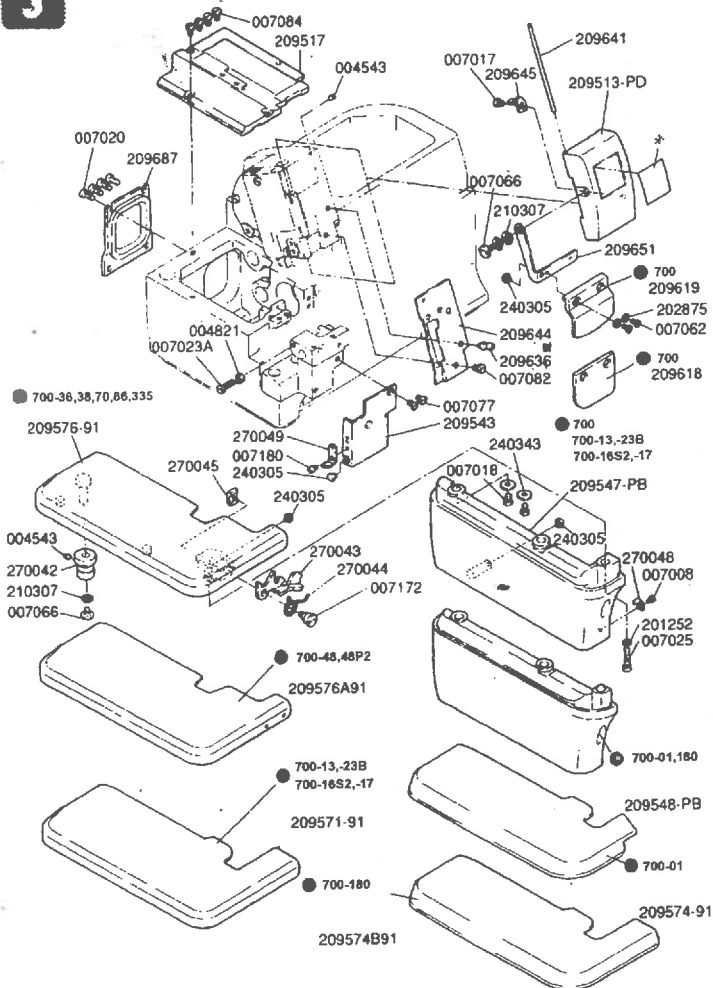
1



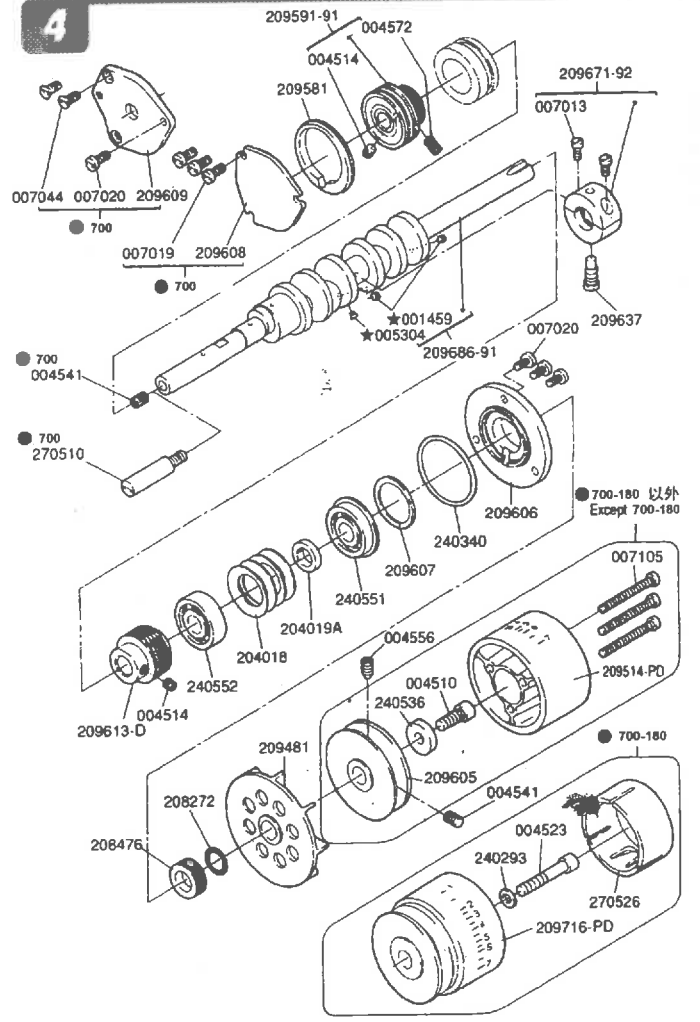
2



3

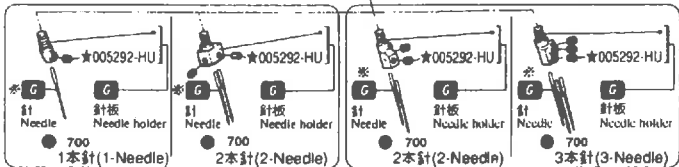
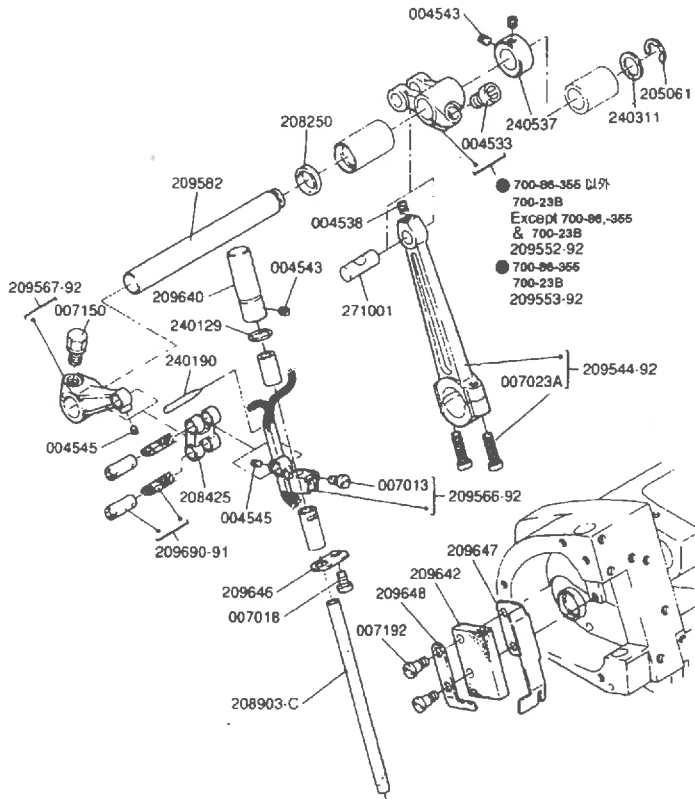


4



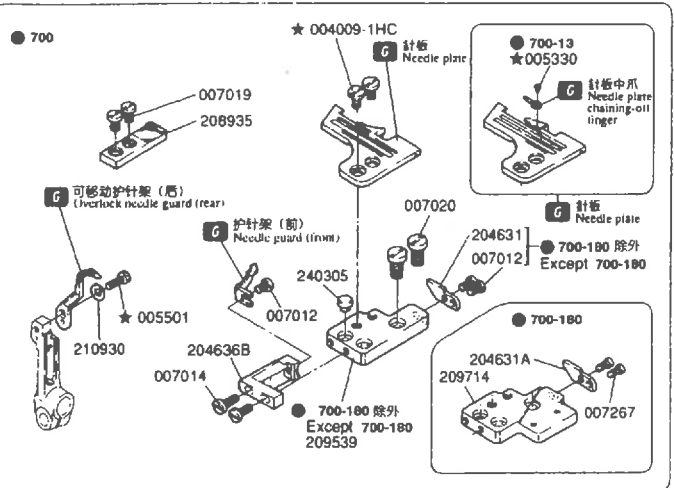
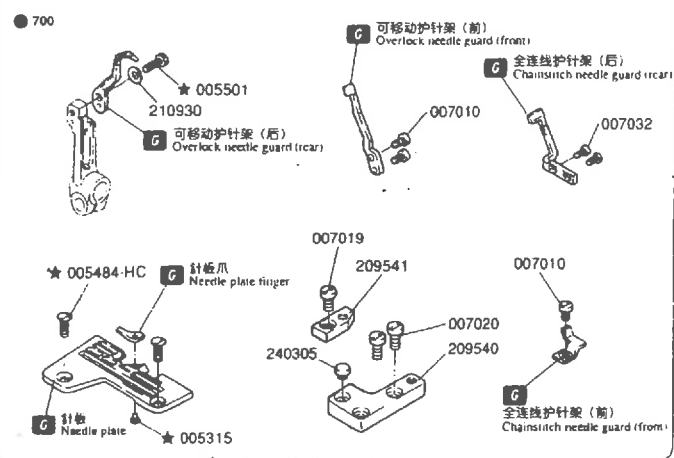
5

G 参照标准量表
Refer to the gauge parts list



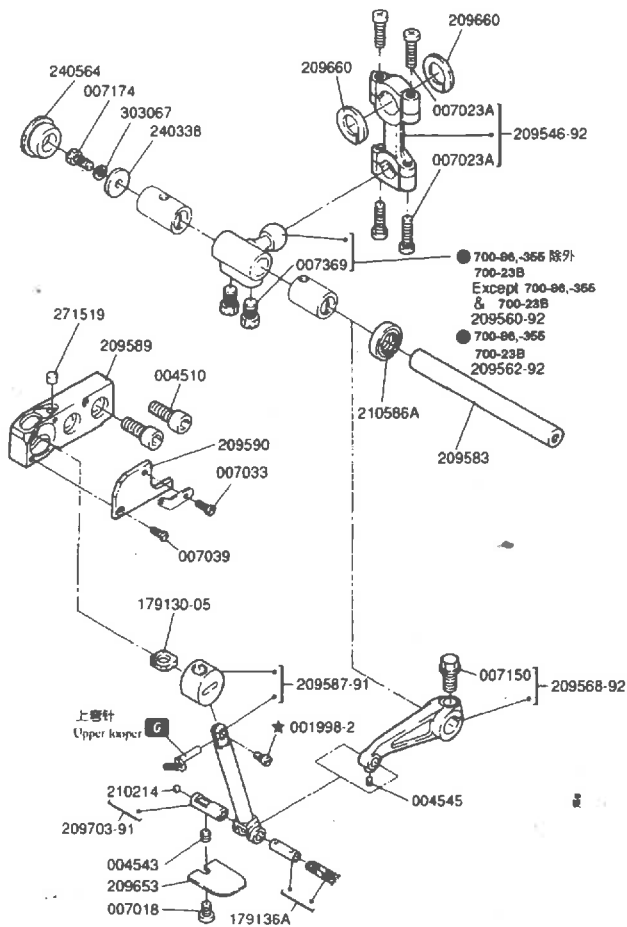
6

G 参照标准量表
Refer to the gauge parts list



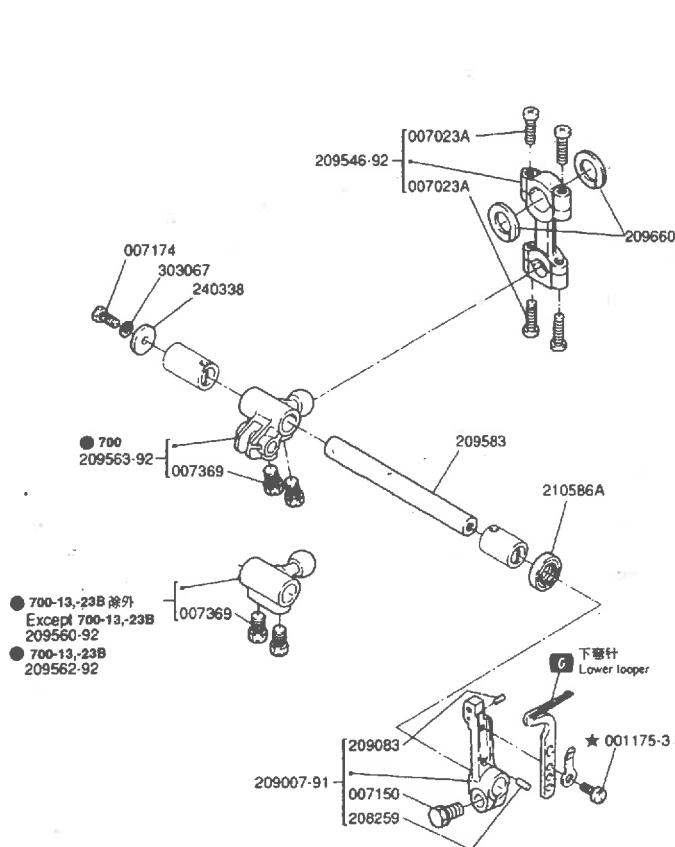
7

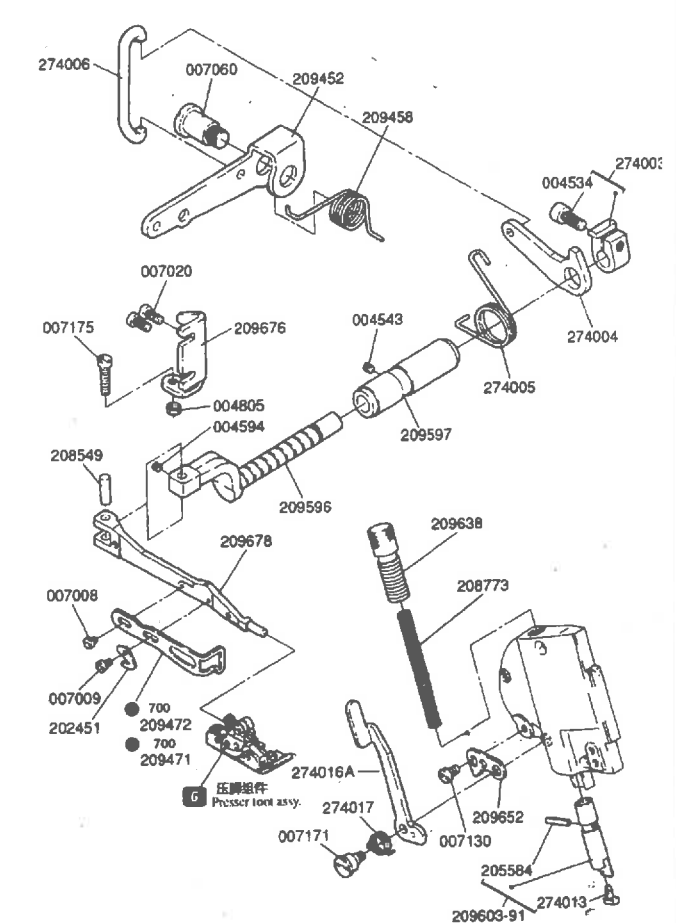
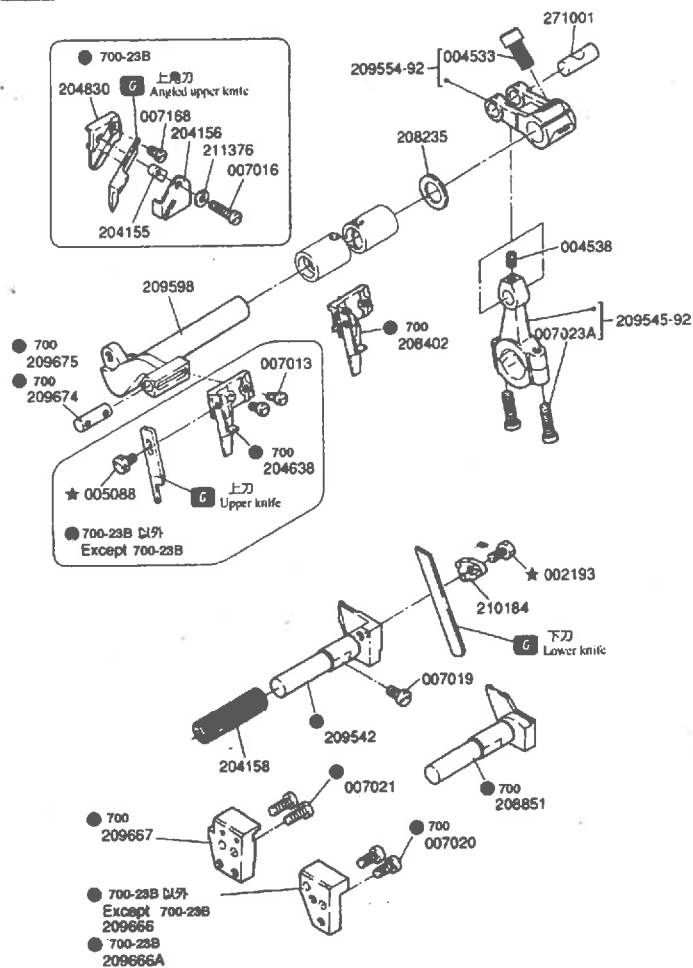
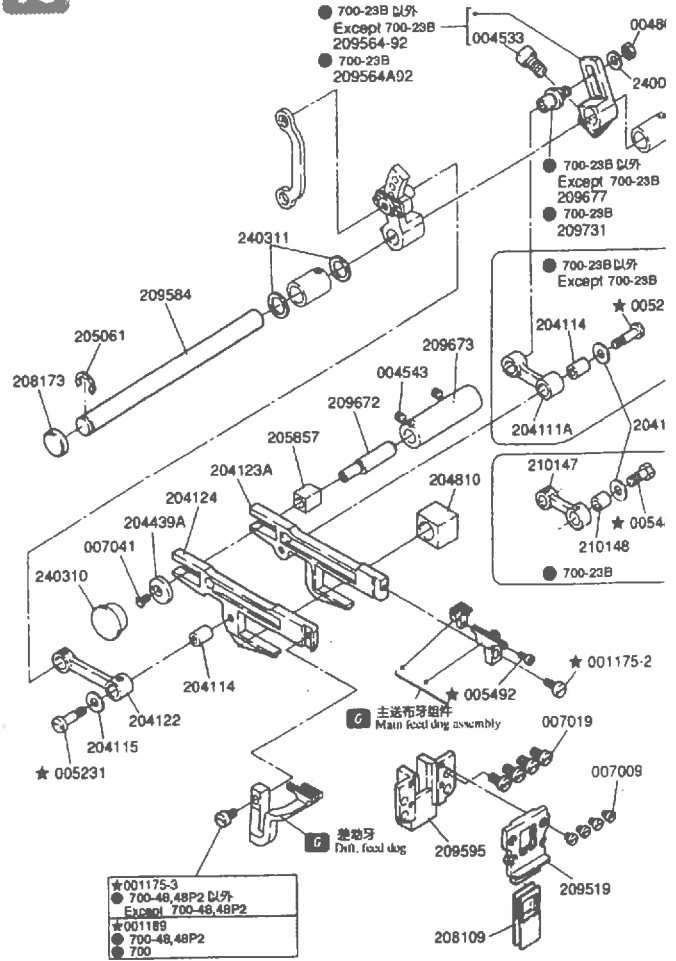
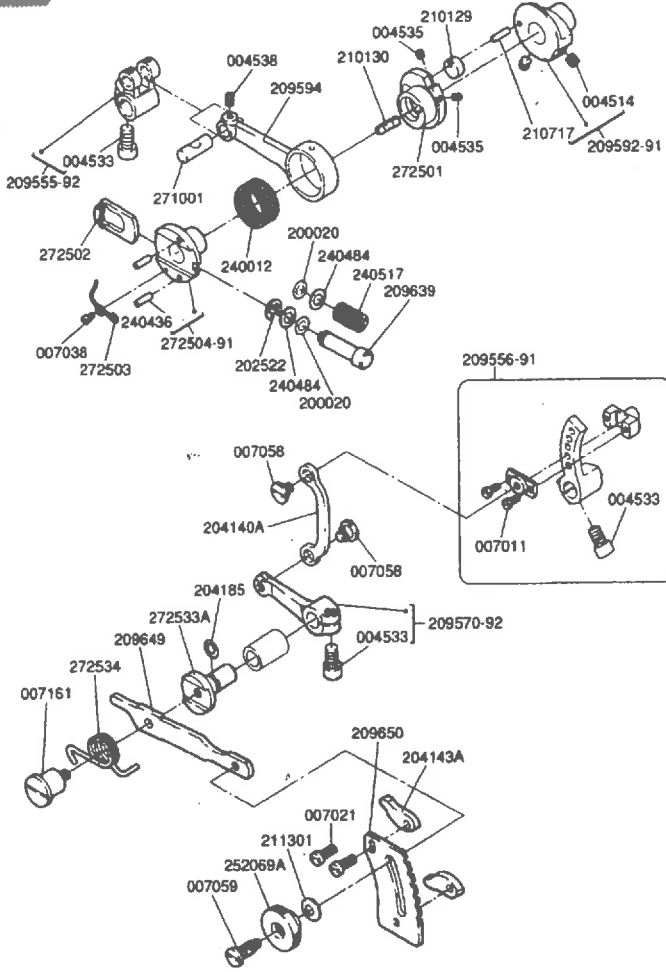
G 参照标准量表
Refer to the gauge parts list



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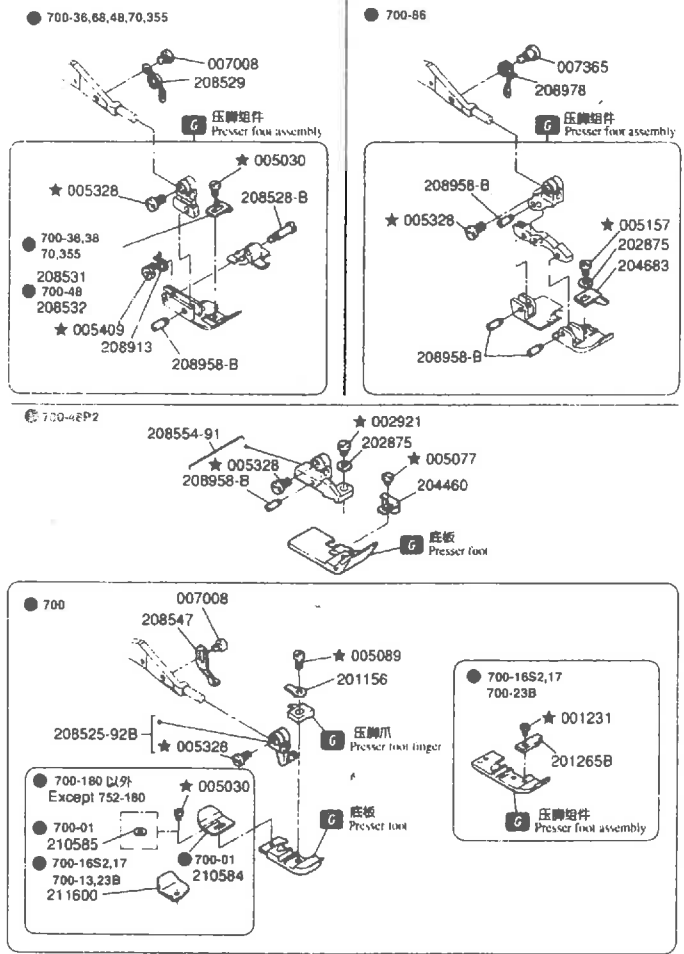
G 参照标准量表
Refer to the gauge parts list



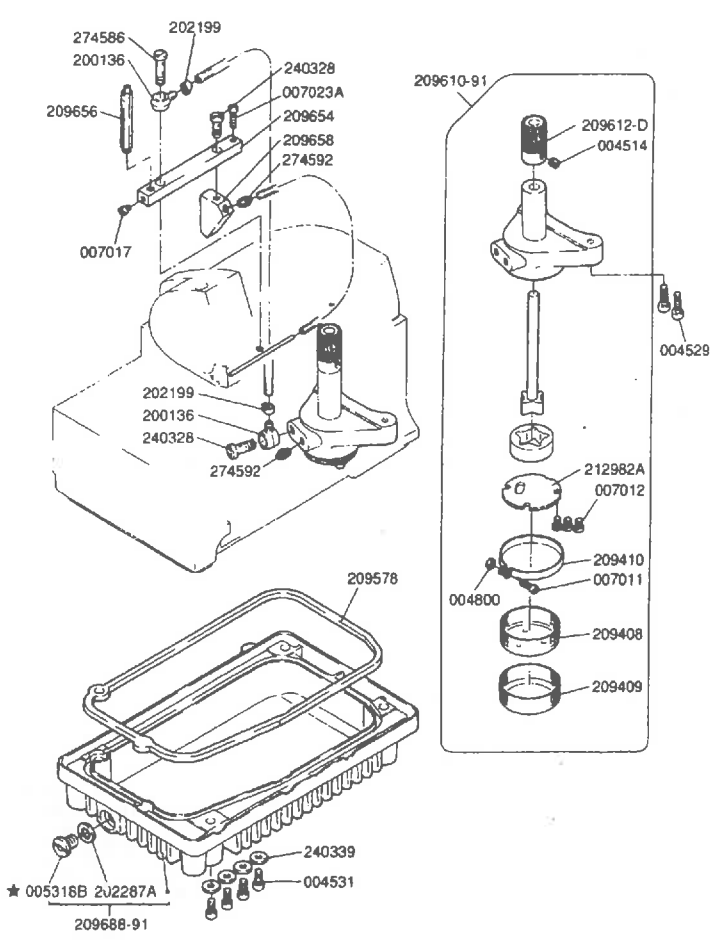


13

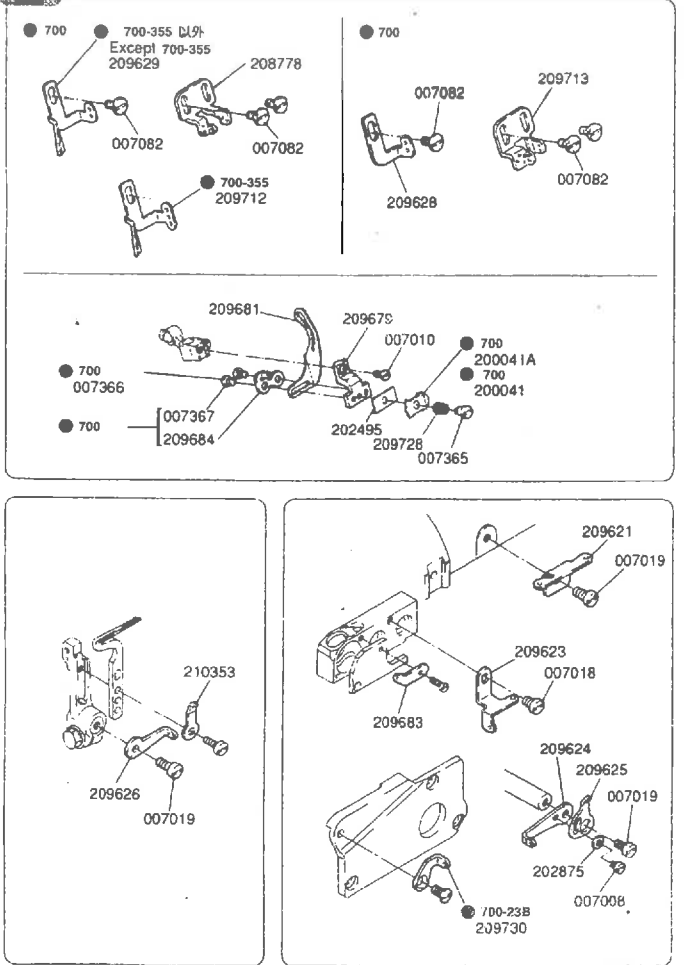
G 参照标准数量表
Refer to the gauge parts list.



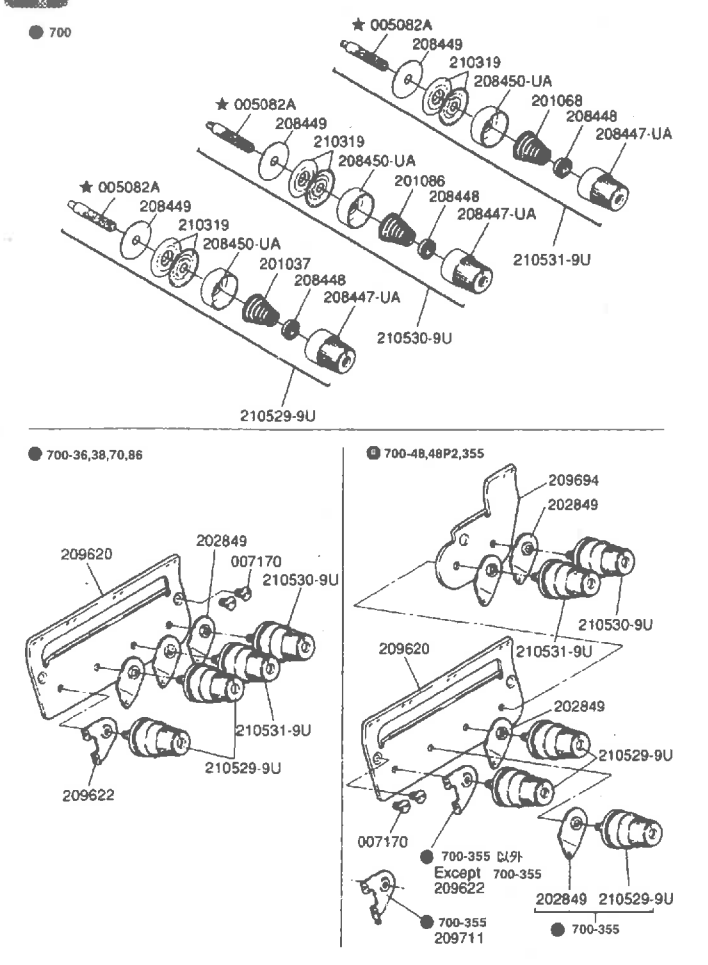
14



15

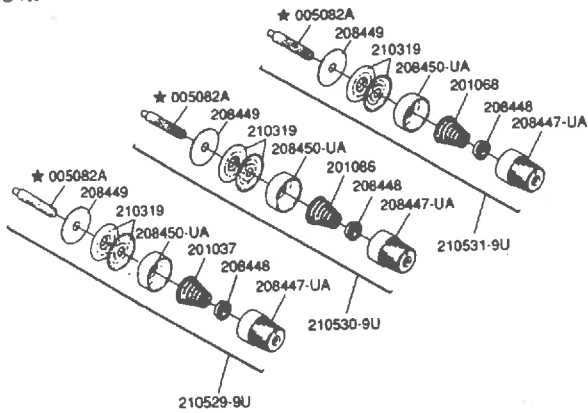


16

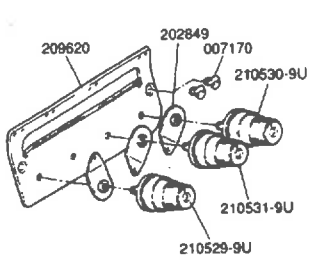


17

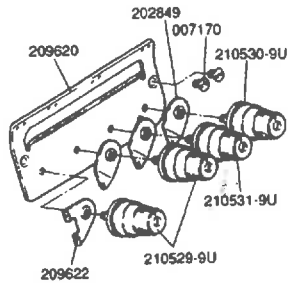
● 700



● 700-01,-16S2,-17,-180

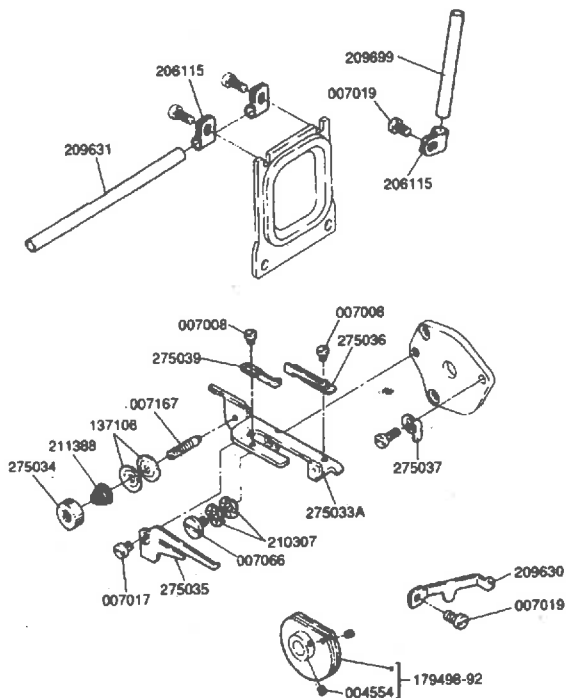


● 700-13,-23B



19

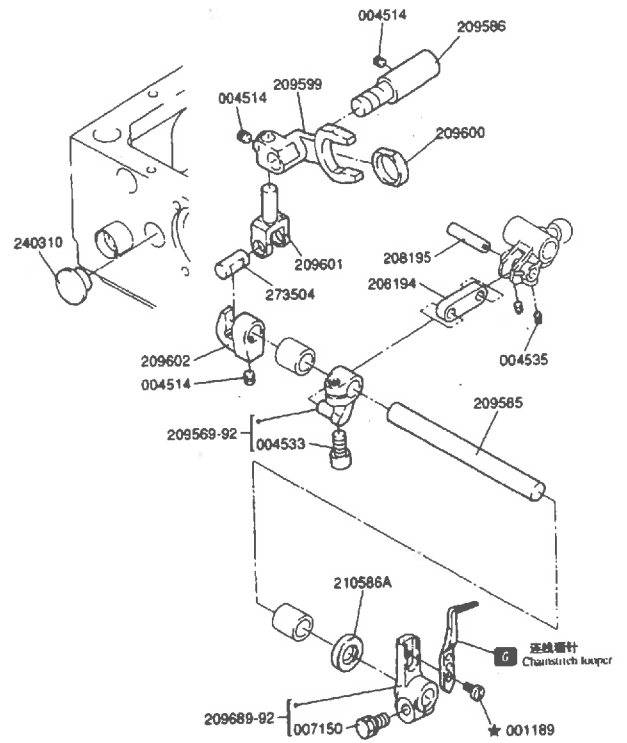
● 700



18

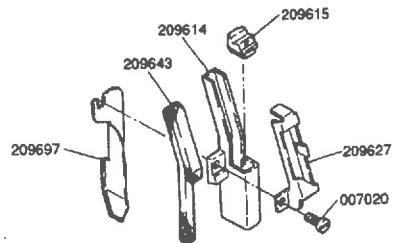
● 700

G 参照标准或量表
Refer to the gauge parts list.

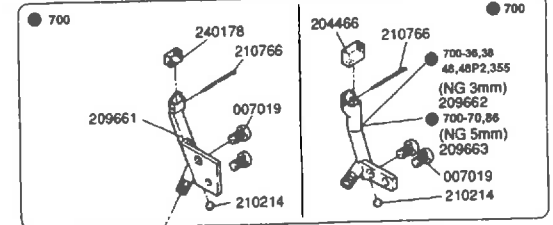


20

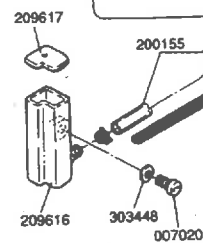
● 700



● 700

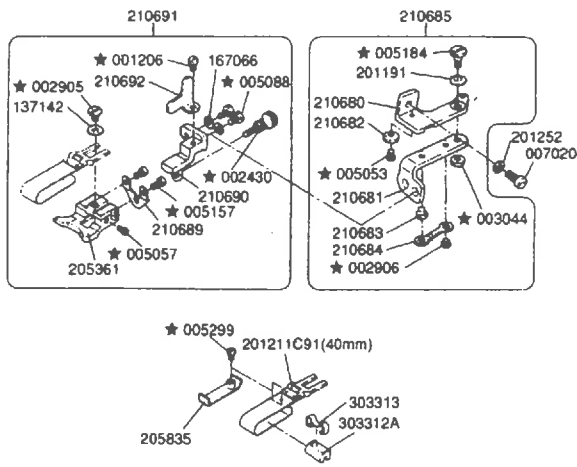


● 700

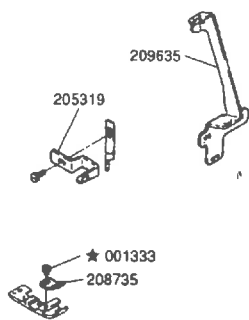


21

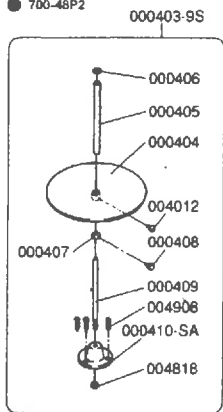
● 700-01



● 700-13

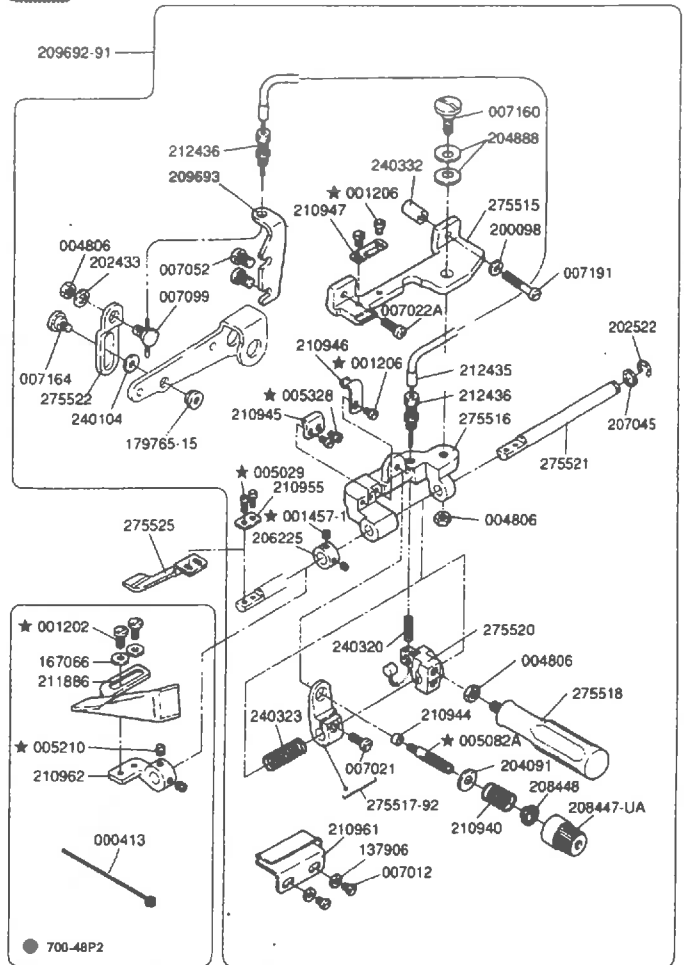


● 700-48P2



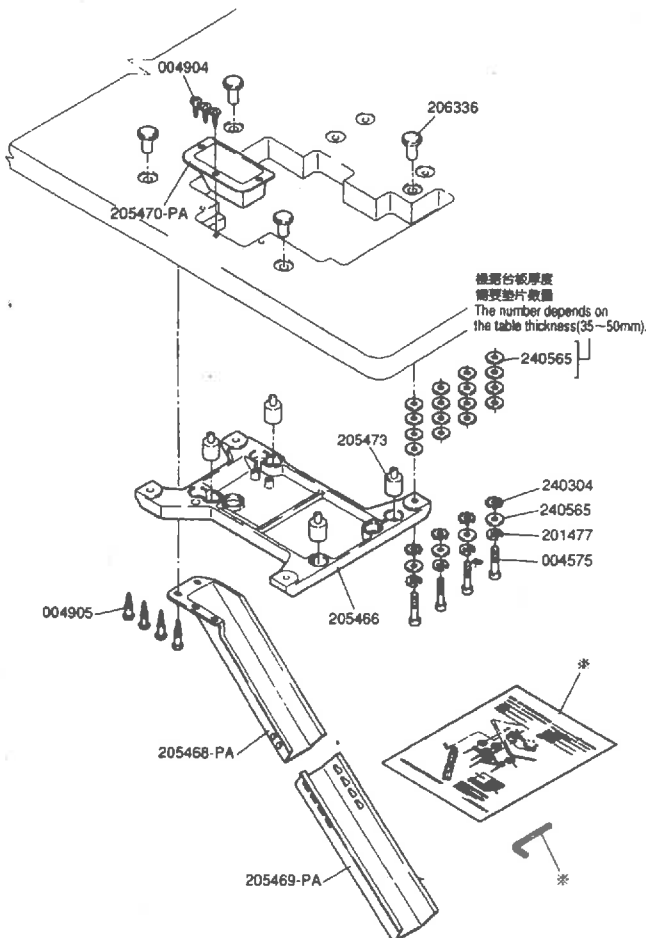
22

● 700-48,48P2

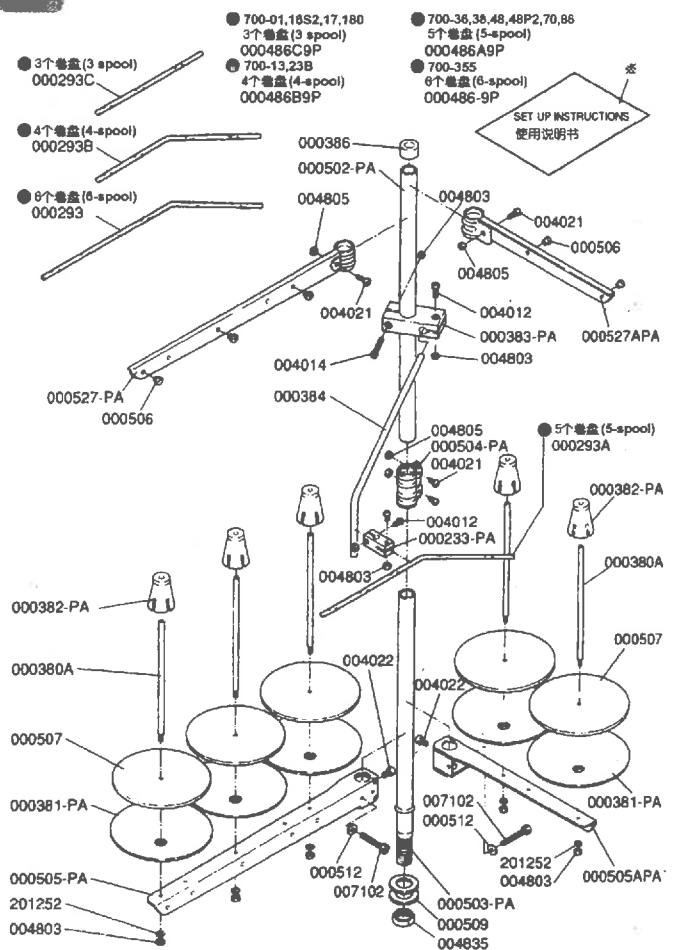


● 700-48P2

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700 标准度量零件表

700 GAUGE PARTS LIST



型号	间距		针板	针板爪	主送布牙组件	主送布牙	辅送布牙	差动送布牙	压脚组件	上弯针	下弯针	连线弯针
MACHINE TYPE /SPEC	GAUGE		NEEDLE PLATE	NEEDLE FINGER	MAIN FEED DOG ASS.	MAIN FEED DOG	AUX. FEED DOG	DIFF. FEED DOG	PRESSER FOOT ASS.	UPPER LOOPER	LOWER LOOPER	CHAINSTITCH LOOPER
	NG	SW										
700-36	3	4	204367	(210505)	208065	(204395)	(204425)	208218	208501	204062 #2	204072	209685
700-38	3	4	204367	(210505)	208066	(204396)	(208060)	208219	208501	204702 #4	204072	209685
700-48	3	4	204940	(210505)	208074	(204931)	(208061)	204420	208508	204702 #4	204072	209685
700-70	5	5	204360A	(210506)	208063	(204248B)	(208059)	208215	208502	204702 #4	204072	209685
700-86	5	6	204529	(210509)	208064	(204394)	(208059)	208217	208955	204703 #6	204072	209685-C
700-355	3x2	4	208648	(209158)	208066	(204396)	(208060)	208219	208649	204963 #8	204072	209685
700-48P2	3	4	204940	(210505)	208074	(204931)	(208061)	204420	204502A	204702 #4	204072	209685




型号	间距		上刀	下刀	可移动护针架		全连线护针架		针夹	机针		
					OVERLOCK NEEDLE GUARD		CHAINSTITCH NEEDLE					
					前	后	前	后				
MACHINE TYPE /SPEC	NG	SW	UPPER KNIFE	LOWER KNIFE	FRONT	REAR	FRONT	REAR	NEEDLE HOLDER	NEEDLE		
700-36	3	4	201121A	204161	209668	209009	204536	209669	208909B92	DCX27 #11		
700-38	3	4	201121A	204161	209668	209009	204536	209669	208909B92	DCX27 #14		
700-48	3	4	201121A	204161	209668	209009	204536	209669	208909B92	DCX27 #14		
700-70	5	5	201121A	204161	209668	209009	204042	209669A	208910B92	DCX27 #14		
700-86	5	6	201121A	204161	209668	209009	204042	209669A	208910B92	DCX27 #21		
700-355	3x2	4	201121A	204161	209668	209009	204536	209669	208965B92	DCX27 #11		
700-48P2	3	4	201121A	204161	209668	209009	204536	209669	208909B92	DCX27 #14		

700 标准度量零件表

700 GAUGE PARTS LIST



型号	间距		针板	针板爪	主送布牙组件	主送布牙	辅送布牙	差动送布牙	压脚组件	压脚爪	上弯针	下弯针
MACHINE TYPE /SPEC	NG	SW	NEEDLE PLATE	NEEDLE FINGER	MAIN FEED DOG ASS.	MAIN FEED DOG	AUX. FEED DOG	DIFF. FEED DOG	PRESSER FOOT ASS.	PRESSER FOOT FINGER	UPPER LOOPER	LOWER LOOPER
700-01	—	4	205773	—	208090-BF	(204729ABF)	(204674)	204730-BF	201152E	201155C #34	204062 #2	204072
700-13	2	4	202554E	(202791A)	208078-BF	(204675ABF)	(204674)	204676-BF	208730	208732 #32	204949 #11	204072
700-16S2	—	1.5	205465	—	208911	(204729A)	(208912)	204730	201230C	205525 #57	204062 #2	204072
700-17	—	4	202546E	—	208078-BF	(204675ABF)	(204674)	204676-BF	201230C	210371 #2	204062 #2	204072
700-23B	2.5	4.5	209508-45	—	209509-25F	(209416-25F)	(204674)	209417A25F	201230C	208050A #61	204990 #12	204991
700-54A	—	4	205321	—	208083	(204692A)	(204677)	204693	202182	210371 #2	204702 #4	204072
700-55A	2	4	202983	—	208083-BF	(204692ABF)	(204677)	204693BF	212182	201310A #55	204949 #11	204072
700-180	—	4	202618A	—	208090A16F	(204729B16F)	(204674)	204730A 16F	21473B	301433	204062 #2	204072
700-181	2	4	209732	—	209740-16F	(209741-16F)	(204677)	209742-16F	205253	209734 #66	209733 #14	204072



型号	间距		上刀	下刀	护针架		针夹	机针				
					NEEDLE GUARD							
					前	后						
MACHINE TYPE /SPEC	NG	SW	UPPER KNIFE	LOWER KNIFE	FRONT	REAR	NEEDLE HOLDER	NEEDLE				
700-01	—	4	201121A	202295	204659	209009	209670-92	DCX27 #9				
700-13	2	4	201121A	202295	204659	209009	208905A92	DCX27 #9				
700-16S2	—	1.5	201121A	202295	204659	209009	209670-92	DCX27 #11				
700-17	—	4	201121A	202295	204659	209009	209670-92	DCX27 #9				
700-23B	2.5	4.5	204835	202295	204659	209009	208906A92	DCX27 #14				
700-54A	—	4	201121A	202295	204659	209009	208905A92	DCX27 #14				
700-55A	2	4	201121A	202295	204659	209009	209670-92	DCX27 #9				
700-180	—	4	201121A	202295	204659	209009	209670-92	DCX27 #9				
700-181	2	4	201121A	202295	204659	209009	208905A92	DCX27 #9				

