

高速绷缝机 C5000-356-D3B/02
HIGH SPEED INTERLOCK
SEWING MACHINE

使用说明书

Operation Original Instructions

零件手册

Parts Book

浙江中捷缝纫科技有限公司

地址：浙江省玉环市大麦屿兴港东路 198 号

ZOJE SEWING MACHINE CO.,LTD

DAMAIYU HING KONG ROAD NO. 198, YUHUAN,

ZHEJIANG, CHINA

目录Contents

1. 使用说明书 INSTRUCTION MANUAL

1. 1. 安全事项和注意事项 Safety instruction and notes for procedure	1-7
1. 2. 安装台的组装Assembling the machine rest board	8
1. 3. 缝纫机的安装 Sewing machine installation	8
1. 4. 皮带轮护盖的安装Installing the belt cover	8
1. 5. 缝纫机的旋转方向 Operating direcion of machine pulley	8
1. 6. 关于供油Lubrication	9
1. 7. 给HR装置供油Silicone oil for H.R.device	10
1. 8. 穿线的方法Threading	11-12
1. 9. 压脚压力的调节Ajusting presser foot pressure	13
1. 10. 差动比的调节Adjusting the differential feed ratio	13
1. 11. 针脚长度的调节Adjthing stitch length	13
1. 12. 线状态的调节Adjusting the thread tension	14
1. 13. 缝纫机的清扫Cleaning the machine	14
1. 14. 机针的更换Replacing the needle	15
1. 15. 机油的更换Oil replacement	15
1. 16. 排油的方法To drain the oil	15
1. 17. 油泵滤油网的检查与清扫Cheaking and cleaning the oil filter	16

2. 零件手册 PARTS LIST

2. 1. 机壳结构(1) Machine bed frame (1)	17-18
2. 2. 机壳结构(2) Machine bed frame (2)	19-20
2. 3. 机壳结构(3) Machine bed frame (3)	21-22
2. 4. 下轴传动机构 Crank shaft drive mechanism	23-24
2. 5. 上轴传动机构 Arm shaft drive mechanism	25-26
2. 6. 针杆机构 Needle bar mechanism	27-28
2. 7. 保针机构 Needle guard mechanism	29-30
2. 8. 弯针机构 Looper drive mechanism	31-32
2. 9. 送布机构 Feede mechanism	33-35
2. 10. 差动调节机构 Differential feed mechanism	36-37
2. 11. 压脚机构 Presser foot mechanism	38-39
2. 12. 绷针机构 Spreader mechanism	40-41
2. 13. 挺线及夹线机构 Thread tension mechanism	42-43
2. 14. 挑线机构 Needle&spreader thread handling	44-45
2. 15. 打线凸轮机构 Looper thread handling	46-47
2. 16. 润滑机构(1) Lubrication mechanism(1)	48-49
2. 17. 润滑机构(2) Lubrication mechanism(2)	50-51
2. 18. 硅油盒机构 HR device	52-53
2. 19. 线架 Thread stand	54-55
2. 20. 台板及附件 Parts for semi-submerged installation	56-57
2. 21. 卷边专用件 Folder Asm	58-59
2. 22. 直驱电机结构Esdd Motor Components	60-61
2. 23. 一体机专用件Integrated Machine Specific Parts	62-63
2. 24. C5专用件C5 Specific Parts	64-65
2. 25. 针位互换清单Gauge Parts List	66

1、前言 Introduction

- 该书是为了安全使用本产品的使用说明书。

This is the instruction manual that describes how to use this product safely.

- 在使用该产品之前,务必阅读此书,在充分理解掌握缝纫机的操作、检查、调整、维修等方法之后,再进行使用。

Read this instruction manual and learn very carefully how to operate, adjust and service this sewing machine before beginning any of the procedures.

- 工业用缝纫机是在缝纫作业中,操作者距机针等运动着的缝纫机部件近距离进行操作的。

所以时常有接触缝纫机运动部件的危险性,这点应充分认识。

因此,为了确保安全,需要本公司提供安全的产品,使用者正确安全的操作。对于顾客也有一些必要的安全对策和要
求。缝纫机使用的有关人员务必熟读本书与驱动装置的使用说明书,在实施必要的安全对策之后,再充分使用缝纫机。

You should realize first that there is always the risk of contacting moving parts, such as needles because you have to work at point-blank range to them when you are operating industrial sewing machines.

For safety it is essential that we supply safe products and you use them correctly and safely.

There may be some safety measures that you yourself must take.

Therefore, you should read and understand very carefully this instruction manual together with that of the driving equipment and take necessary safety measures in order to use this machine efficiently and effectively.

2、安全措施 Safety precautions

①用途·目的 Applications, purpose

本公司的工业用缝纫机,是以提高服装业的质量和生产率为目的而研究开发的商品。因此除以上用途以外,请绝对不要使用。

Our industrial sewing machines have been developed in order to increase quality and/or production in the sewing industry. Accordingly never use our products for other than intended use described above.

②使用环境 Circumstances

本公司的工业用缝纫机,根据使用的环境,有可能给缝纫机的寿命、性能及安全带来不良影响。

The environment in which our industrial sewing machines are used may seriously affect their lives, functions, performance and/or safety. For safety, do not use the machine under the circumstances below.

1. 在靠近高频焊接机等产生干扰的机器设备旁边。

Do not use the machine near objects which make noise such as a high-frequency welder, etc.

2. 产生药品蒸气气氛的地方,及受药品飞溅等地方使用或保管。

Do not use or store the machine in the air which has vapor from chemicals, or do not expose the device to chemicals.

3. 屋外、高温高湿、直接曝曬阳光的地方。

Do not leave the machine outside, in high temperatures or the direct sun.

4. 周围的温度、湿度很大,会给缝纫机带来坏影响的地方。

Do not use the machine in the places of high ambient temperature and humidity that seriously affects sewing machines.

5. 额定电压常超过±10%以上的电压变动较厉害的地方。

Do not use the machine on the condition that the voltage fluctuation range is more than ±10% of the rated voltage.

6. 电源容量无法确保控制马达规格上所需要的容量时。

Do not use the machine in the place where the supply voltage specified for the control motor cannot be properly obtained.

③安全措施 Safety measures

(1) 进行维修保养、检验时的安全保护 Safety precautions when you perform maintenance on the machine.

在对缝纫机进行检查、修理、清扫等维护作业时,请关掉电源开关,将电源插销从插座上拔下,并确认踩缝纫机踏板也不会转动之后,再进行操作。但是,有必要接通电源进行作业时,请制定防止缝纫机意外转动或操作者错误而导致危险的安全操作准则,并遵守一切安全防护规则。

Always turn off the power, unplug the machine and then make sure that the machine does not run by pressing the treadle before performing any maintenance, such as checking, repairing, cleaning, etc. However, if you need to perform these procedures with the power on, to prevent accidents due to the unexpected start of the machine and users misoperation, establish your own procedures for safety and follow them.

在进行以下作业时,务必关掉电源开关,将电源插销从插座上拔下之后进行。

Always turn off the power and unplug the machine before performing the procedures shown below.

- 加油 Lubrication
 - 穿线 Threading
 - 打扫缝纫机 Cleaning
 - 换机针 Replacing the needle
 - 进行供油元件的清扫和更换时。Checking/replacing oil element
 - 更换机油 Replacing the oil
- 在进行以下作业时，请务必关掉电源开关之后进行。Always turn off the power before performing the procedures shown below.
- 调节针脚时 Adjusting the stitch length
 - 调节差动比时 Adjusting the differential feed ratio

(2) 开始运转前的检验事项 Before operating the machine

- 在开始操作运转缝纫机前，先检查缝纫机皮带及缝纫部分，看是否有损伤，功能不良等问题。万一有异常现象时，应立即修理或采取必要的措施。

Check the machine head and unit for any damage and/or faulty function at the start of each day.

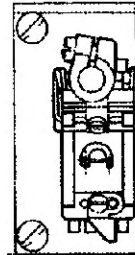
If there should be something wrong with the machine, immediately perform repairs and/or other necessary procedures.

- 务必用手触摸来确认针箍是否固定好。Check by hand to see if the needle holder is secured.

※ 请注意针尖有危险。Be careful of the needle point.

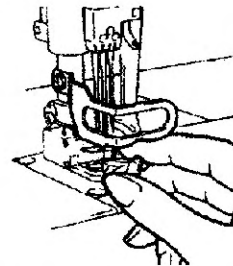
- 在使用缝纫机之前，务必确认压脚是否在正确的位置。
(用手轻轻转动手轮，认针尖是否落在压脚的针孔中心)

Before starting the machine, make sure that the presser foot is positioned correctly (turn the machine pulley slowly by hand to see if the needle point is centered in the needle drop hole on the presser foot).



- 务必检查压脚是否牢固的固定好。(使用抬压脚机构抬起压脚，用手前后左右扳动，检查压脚是否有松动)

Check to see if the presser foot is secured (raise the presser foot by the foot lifter and press it by hand front to back and left to right).



(3) 培训·进修 Training

- 为了防止事故，缝纫头或缝纫系统的操作人员及维修保养专员，应先学会所需知识和有关技能，以其工作的安全。为此，请由客户的管理单位给她们安排培训计划，而实施充分的训练。

To prevent accidents, operators and service/maintenance personnel should have proper knowledge and skills for safe operation.

To ensure so, managers must design and conduct training for these people.

3、各操作过程的注意事项 Notes for each procedure

① 开箱 Unpacking

1. 缝纫机机头在出厂时包装好后装入纸箱运出的。从印刷在纸箱上的标记字样确认上下后，请从上到下按顺序开箱。

The machine is packaged in a cardboard box before shipping. Unpack your machine in orderly sequence while checking them right-Side up by referring to the indications, such as logo, etc printed on the boxes.

2. 把缝纫机机头从缓冲包装材料里拿出时，绝对不要提拿与机针部位或过线器等有关的部件。否则会发生危险或损伤机器。

Never hold the area near the needle and/or thread guide related parts when taking out the machine from the cushion.

3. 在取出缝纫机机头时，请注意重心的位置，小心谨慎的取出。

Take out the machine very carefully while checking the position of the center of the gravity.

4. 开箱用过的纸箱如果以后还用的话，请好好保存放好。

Keep the cardboard box and packing carefully in case secondary transport is needed in the future.

包装材料的处理 Disposal of the packaging

- 包装材料包括木头、纸张、纸箱、VCE纤维。恳请顾客负有责任的将包装材料正确适当的进行处理。

The packaging material of the machine consists of wood, paper, cardboard and VCE fiber. The proper disposal of the packaging is the Responsibility of the customer.

缝纫机废物的处理 Disposal of machine waste

1. 缝纫机的废物, 请客商负责任进行处理。The proper disposal of machine waste is the responsibility of the customer.
2. 制造缝纫机所使用的材料有铁、铝、锌及各种塑料。The materials used on the machines are steel, aluminum, brass and various plastics.
3. 缝纫机的废物应遵照当地环境保护的有关规定进行处理。必要时委托专门的厂家进行处理。

The machine waste is to be disposed of in accordance with the locally valid environmental protection regulations. A specialist should be commissioned if necessary.

※有油污的部件务必遵照当地环境保护的有关规下, 分别进行处理。

The parts contaminated with lubricants should be disposed off separately according to the locally valid environmental protection regulations.

在顾客领地内移动缝纫机 Transport within the customer's premises

- 关于在顾客领地内移动缝纫机, 本制造厂商没有责任。移动时为了避免缝纫机掉落摔坏, 请注意不要倾斜缝纫机是。

The manufacturer assumes no liability for transport within the customer's premises. Care should be taken to transport the machine in an upright position avoiding it from dropping or falling down to the ground when it is moved.

②搬运 Transportation

1. 缝纫机机头的搬运一定要两个人以上进行。另外, 用人直接搬运应只限于搬往缝纫机台或小台车。其他搬运务必使用小台车进行。

The machine should be carried by at least more than two people when it is mounted on the table and/or a hand truck. Be sure to use a hand truck for other transportation.

2. 移动缝纫机机头时, 用右手抓住传动轮, 左手垮在机头里, 扎实牢固的搬起。缝纫机上沾有油污在搬动时容易滑脱摔坏, 搬运前请好好擦净机头上的油污。

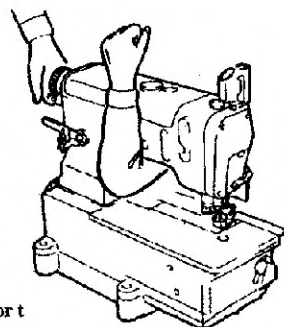
To carry the machine, hold the machine pulley tightly with your right hand and the machine arm with your left upper arm. If the machine and/or your hands are stained with oil, the machine may be easy to slip out of your hands and fall to the floor. Therefore, wipe off the oil carefully.

3. 在往缝纫机台板上或小台车上搬运时, 请注意不要过分冲击或震动, 以免缝纫机倒斜造危险。

Care should be taken to avoid excessive shock and shake when the machine is mounted on the table and/or transferred using a hand truck. Otherwise the machine may fall down.

4. 如果要第二次运送缝纫机并要包装时, 请一定擦干净机头上的油污。否则搬运时会滑脱摔坏机头或油污使包装材料变质穿底。

Wipe off the oil from the machine before packaging it again for secondary transport. Otherwise the machine may easily slip out of your hands or the bottom of the box may come off while in transit.



③安装·准备 Installation preparation

缝纫机台板 Machine table

1. 请使用能充分承受缝纫机机头重量及搬运时产生的反作用力的缝纫机台板(台板、铁架)。

Use the machine table (table board, metal legs) that completely carries the machine and is fully resistant to warping while the machine is running.

2. 应充分考虑缝纫机装配部件和操作光线的明亮度, 放置在容易作业的环境中。如果光线不是十分明亮时, 应根据需要安装照明电灯。

Arrange the working environment for easy operation by considering where to place the machine and the brightness around the working area. If the illumination is insufficient, control or change lighting as required.

3. 在运转缝纫机时, 为防止操作者踩踏板时脚滑脱造成事故, 一定要在缝纫机踏板上安装防止滑脱的垫子。

Attach a non-slip pad to the treadle (foot switch). Otherwise the operator may slip off the treadle while running the machine, causing trouble.

4. 在考虑操作者姿势的前提下, 决定台板面的高度(工作时的高度)。

Adjust the height of the table according to a working posture of the operator.

接线 Cables

1. 请牢固的插好缝纫机机头与电机连接线的插头。缝纫机机头与电机用连接线进行连接时, 务必在将电源开关关闭的状态下进行操作。

When connecting the cables between the machine and the motor, be sure to turn off the power and connect each cable connectors securely.

2. 在使用中请不要给连接线过多的力。

Do not strain the cables in use.

3. 请不要过度弯曲连接线。

Do not bend the cables excessively.

4. 接近运动部件(如传动轮、V形皮带等)的连接线, 应最小距离在25mm处进行安装。

When connecting the cables that are close to the moving parts, such as pulley or V belt, keep a distance of 25mm at least between them.

5. 必要时考虑连接位置或加设护罩来保护连接线。

Protect each cable using a cover or adjusting its position if necessary.

6. 固定连接线时绝对不要使用订书针, 以免发生漏电或火灾。

Never use staples to fasten the cables, otherwise it causes a short circuit and/or a fire.

电机 Motor

1. 缝纫机电机的安装请遵照电机厂家的使用说明书，正确的进行安装。

Install the machine motor correctly by referring to the instruction manual supplied by the manufacturer.

2. 为了防止被卷入皮带轮的危險，请选用带有防止卷入的缝纫机电机。

Select the machine motor equipped with the pulley cover so that any part of your body etc, is not caught in the belt.

④使用缝纫机油 Handling machine oil

1. 在油盘内没有注入油以前请绝对不要进行运转。

Never start the machine with no oil in the reservoir.

2. 机油进入眼睛会使眼睛发炎，所以在使用时请戴防护眼镜以免机油进入眼睛。

If machine oil gets in your eyes, it may cause eye irritation. To prevent the machine oil from getting in your eyes, wear a pair of protective glasses.

※万一进入眼睛，请用干净水冲洗15分钟再请医生进行治疗。

Should machine oil gets in your eyes, wash them with fresh water for 15 minutes and then go to see a doctor.

3. 机油接触皮肤后，请马上用水和肥皂洗干净。

Avoid skin contact, immediately wash contacted areas completely with water and soap.

4. 绝对不要使机油进入口腔。

Never swallow machine oil.

5. 机油请保管在孩摸不到的地方。

※万一进入口腔，不要硬性呕吐，马上请医生进行治疗。

Keep machine oil out of the reach of children.

※If swallowed, do not induce vomiting immediately go to see a doctor.

6. 废油、废容器的处理方法有必须遵照法令的义务，请根据法令正确处理。如不知道时请与购买部门联系后，正确进行处理。

Dispose of the waste oil and/or containers properly as demanded by law. If you have further questions on its disposal, consult the store or shop at which you purchased it.

7. 为了防止灰尘、水分的混入，使用完后保管机油时请盖紧油箱盖，放在没有阳光直射的荫凉处保管。

After opening the oil container, be sure to seal it to prevent dust and water from getting into the oil and keep it in the dark to avoid direct sunlight.

⑤运转缝纫机前的注意事项 Before starting the machine

缝纫机台板 Machine table

1. 打开电源臆，请确认接线或接头是否有损伤、脱落、松动等外观上的异常。

Before turning the power on, visually check the cables and connectors for defective conditions, such as damage, disconnection and/or loosening.

2. 在打开电源时，请不要将手放在机针附近或传动轮附近。

Never bring your hands close to the needle and/or pulley when turning on the power.

3. 最初开始运转缝纫机时，打开电源确认传动轮的运转方向。缝纫机的正运转从传动轮侧来看是向右旋转。

When the machine is used for the first time, turn on the power and then check the rotating direction of the machine pulley.

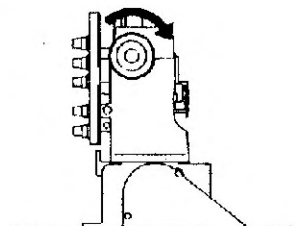
The machine pulley should turn clockwise as seen from the machine pulley.

4. 操作缝纫机者应为受过适当训练、充分理解本书及使用说明书的内容之后，再进行操作使用。

Well trained operators should use the machine after studying these precautions and the instruction manual carefully.

5. 最初使用的一个月应降低速度。请使用在最高转速的3/4以下的转速。

Run the machine at the speed less than 3/4 of its maximum for first one month.



⑥运转缝纫机中的注意事项 Precautions while you are running the machine




- 1.在拆卸下护眼板、护指架、传动轮护罩等安全装置的状态下、请不要运转缝纫机。
Do not run the machine with the safety devices removed,such as eye guard,linger guard,pulley cover,etc.
- 2.缝纫机在运转中是很危险的、绝对不要将手放入机针下。
Never bring your hands under the needle while running the machine.
- 3.使用离合器式电机时关掉电源之后电机仍然会继续旋转一会儿。这时踩缝纫机踏板后缝纫机会运动是很危险的，请特别小心。
A clutch motor keeps on running for a while after the power is turned off.Therefore,be careful even after the power is turned off as the machine could start running by pressing the machine treadle.
- 4.缝纫机在运转中是很危险的，所以绝对不要将手指、头发、衣服接近手轮、V形皮带、电机传动轮、挑线器、针棒。同时，也不要将剪刀、镊子、工具等放在以上部位。
To prevent accidents,never bring any bart of your fingers,hair and clothes near the machine pulley,v belt,motor pulley,thread take-up and needle bar.Also never leave scissors,tweezers, tools,etc,around these areas.
- 5.在不使用缝纫机时或者操作者离开缝纫机时，一定要将电源开关关掉。
Always turn off the power while the machine is not used or before leaving the machine table.
- 6.停电时务必将电源关掉。
In the event of a power failure,be sure to tum off the power.
- 7.在操作缝纫机时，请穿着不易被机械卷入的服装。
While operating the machine,wear clothes that cannot be caught in the machine.

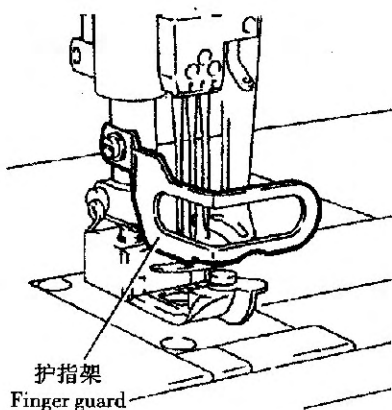
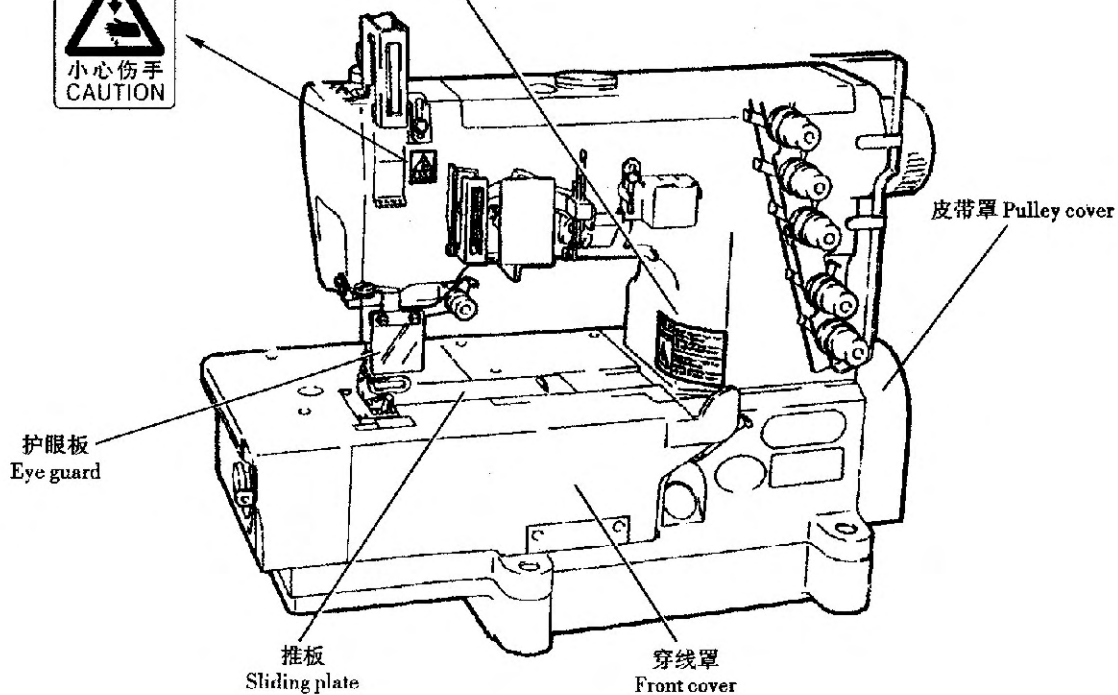
⑦维护、检查、修理 Maintenance,Chcek,Repair

- 1.维护、检查、修理的作业应由受过特别训练的人并在充分理解本书及使用说明书的内容之后，再进行作业。
Well trained people should perform maintenance,check and repair of the machine after studying these precautions and the instruction manual carefully.
- 2.为了维护、检查、修理要将缝纫机机头放倒时，务必将电源开关关掉，把电源插头从插座上拔下，并确认即使踩缝纫机踏板缝纫机也不会转动之后，再进行操作。
If it is necessary to lay the machine backward for maintenance,check and repair,always turn off the power,unplug the machine and press the treadle to make sure that the machine dose not operate before beginning any of the procedures.
- 3.在安装或拆卸V形皮带时，务必将电源开关关掉，把电源插头从插座上拔下，并确认即使踩缝纫机踏板缝纫机也不会转动之后，再进行操作。
Before installing/removing the V belt,always turn off the power,unplug the machine and press the treadle to make sure the machine does not operate.
- 4.对于缝纫机机头的日常检查或定期检查，应按照本书及使用说明书的指示，切实认真的进行。
Carry out daily maintenance work and periodical inspections properly by following these precautions and the instruction manual.
- 5.缝纫机的修理或部件的更换请使用本公司的真实部件。对于不得当的修理、调整或使用假冒伪劣部件所造成的事故，本公司将不负一切责任。
Employ Pegasus genuine barts when repairing the machine and/or replacing the parts.We are not responsible for accidents caused by any lmpoer repair/adjustment and substituting other barts for thoes manufactured by Pegasus.
- 6.请不要根据顾客自己的判断对缝纫机进行改造。否则因改造而发生的事故，本公司将不负一切责任。
Do not attempt to modify the machine at your own discretion.We are not responsible for accidents caused by the mooification.
- 7.临时因修理、调整而拆卸下的安全装置、安全护罩，待作业完后务必按原来的状态安装好。
Be sure to replace the safety devices and/or safety covers that are temporarily removed for maintenance and/or adjustment.
- 8.维护、检查、修理的作业完成后，请检查接通电源之后是否确实没有危险。
After performing maintenance,check and repair,make sure that turning on the power does not pose any danger to you.

安全须知 请先仔细阅读 Be sure to study very carefully for safety.

4、警告标签粘贴的位置与安全保护装置 Location of warning labels and safety devices

	注意	运动的部分容易受伤。 安装安全保护装置方可进行 缝制作业。切断电源以后才 可进行穿线、交换梭芯或针、 清扫或调整作业。
	CAUTION	
		Moving parts may cause injury. Operate with safety devices. Turn off main switch before threading, changing bobbin and needle, cleaning etc.



5、安全保护装置 Protectors for safety

这个项目是为了使大家都知道各种安全保护装置，并记载了各部分的注意事项。

This chapter describes each protector for safety. Therefore, read and study the following carefully.

(1) 护眼板 Eye guard

为了眼睛的安全，绝对不要在打开护眼板的状态下操作缝纫机。护眼板是为了在缝纫中针断了时，使断针不会飞入眼睛而安装的护眼罩。

For the safety of eyes, do not operate the machine with the eye guard open. The eye guard will prevent any pieces of the broken needle from getting into your eyes if the needle should break during sewing.

(2) 护指架 Finger guard

为了防止上下运动的机针与人接触而产生危险，在机针附近安装了护指架。但是，在护指架上方为了便于穿线而留有间隙。如果将手指从间隙伸入，机针有可能会刺伤手指造成危险。

To prevent the needle that moves up and down from contacting any of your body, the finger guard is installed close to the needle. However, there is clearance above the finger guard for easy threading. Be careful that the needle may penetrate any of your fingers if you insert it into this clearance.

(3) 皮带罩 Pulley cover

缝纫机的传动轮和V形皮带轮都被罩在皮带罩内，在缝纫中（特别在高速运转中）与人接触是很危险的。为了避免危险，务必长时使护罩处于安装好的状态。

The machine pulley and V belt are covered with the pulley cover. The machine pulley and the V belt rotate at high speed during sewing.

To prevent accidents, operate the machine with the pulley cover installed in place.

(4) 传动轮 Pulley

请确认缝纫机传动轮的旋转方向，正确的旋转方向在传动轮侧看是向右转的。

Check the direction in which the machine pulley rotates. It should rotate clockwise as seen from the pulley.

(5) 压脚 Presser foot

从针板表面压脚的上升量是5mm以上，这个间隙有夹手指的危险。在用膝盖开关抬升压脚时或用踏板自动抬升压脚时，请不要将手指伸入压脚下方。

There is a clearance of more than 5mm between the top surface of the needle plate and the presser foot. Be careful that none of your fingers are caught in this clearance. Never insert any of your fingers under the presser foot when raising the presser foot with the knee switch or automatically raising it with the treadle.

(6) 穿线罩 Front cover

弯针的运动从缝纫机正面看时，是进行左右往复的圆弧运动。为了避免进行圆弧运动的弯针与人接触，务必请在穿线罩闭合的状态下操作缝纫机。

The looper travels left to right while drawing an arc as seen from the front of the machine. To prevent the looper from contacting any part of your body, be sure to operate the machine with the front cover closed securely.

(7) 推板 Sliding plate

下线挑线器在缝纫时为了挑出一定量的下线在做旋转运动，为了避免进行旋转运动的下线挑线器与人接触，务必请在推板闭合的状态下操作缝纫机。

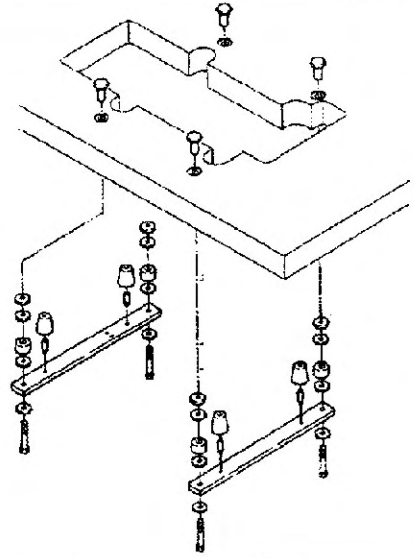
The looper thread take-up rotates in order to supply the required amount of looper thread during sewing. To prevent the looper thread take-up from contacting any of your body, be sure to operate the machine with the sliding plate closed securely.

安装台的组装 Assembling the machine rest board

请参照下图组装安装台。

组装时注意不要留缝隙或松动的地方，确实可靠的进行安装。

Assemble the components comprising the machine rest board by referring to the illustration below. Be sure to secure all rods, nuts and bolts firmly with no shake.



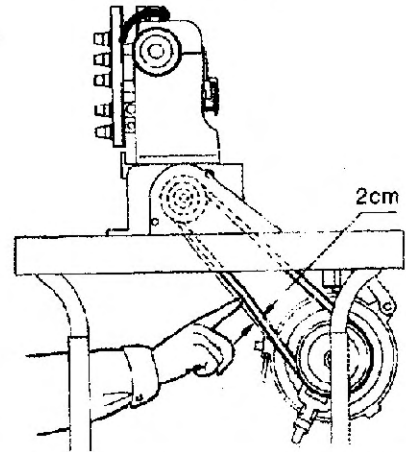
缝纫机的安装 Sewing machine installation

安装缝纫机时，务必将缝纫机的电源关掉，将插头从电源插销上拔下来之后再进行。

Always turn off the power, unplug the machine and then well-qualified technicians should install the machine.

请将缝纫机安装在台板上之后，再安装V形传动皮带，然后调节缝纫机电机的位置，使之用手按压V形传动皮带中间部分时能有2cm的余量。

Mount the machine on the machine rest board first. Put the V belt in place. Position the machine motor so that an approx 2cm deflection can be obtained by pressing the center of the belt (see the illustration).



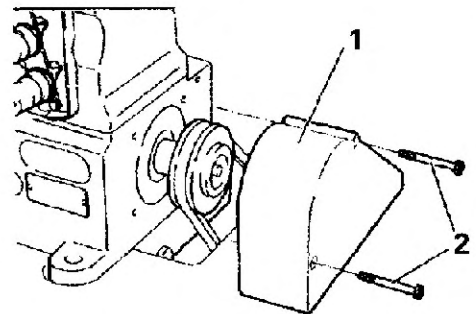
皮带轮护盖的安装 Installing the belt cover

安装皮带轮护盖时，务必将缝纫机的电源关掉，将插头从电源插销上拔下来之后再进行。

Always turn off the power, unplug the machine and then well-qualified technicians should install the belt cover.

请参照右图，用螺丝2将皮带轮护盖1安装在缝纫机上。

Install belt cover 1 on the machine with screws 2.



缝纫机的旋转方向 Operating direction of the machine pulley

缝纫机的旋转方向从手轮一侧看是向右旋转的。The machine pulley rotates clockwise as seen from the end of the machine pulley.

关于供油 Lubrication

在加机油或换机油时，请务必使用本公司指定的机油，如果使用指定以外的机油，有可能损坏缝纫机。

When lubricating the machine and/or replacing the oil, use our company recommended oil. Using other oils may damage the machine.

1. 使用的油类 Use the following oil

请使用本公司指定的高速缝纫机油或者使用与此相同的ESSOTEX SM22(Exxon Mobil制造)。Our company designated oil: HIGH SPEED SEWING MACHINE OIL or Equivalents: ESSOTEX Sm22 manufactured by Exxon Mobil.

2. 供油的方法 To fill the machine with oil

揭开供油口的盖子1，加油至油面到达油标尺的H线和L线中间，加完油后，请盖好供油口的盖子1。

Remove cap 1. Add the oil until the oil level (see oil gauge 2) reaches (H). After filling the tank with oil, replace cap 1.

3. 油的规定量 Required amount of oil

油标尺2的H线和L线表示着油量的上限和下限。为使油面经常保持在R线和L线之间，请常常检查注意加油。

(H) on oil gauge 2: Upper limit (L) on oil gauge 2: Lower limit The oil level should always lie between (H) and (L).

4. 用手加油 Manual lubrication

在用手加油时，务必将缝纫机的电源关掉，将插头从电源插销上拔下来之后再进行。

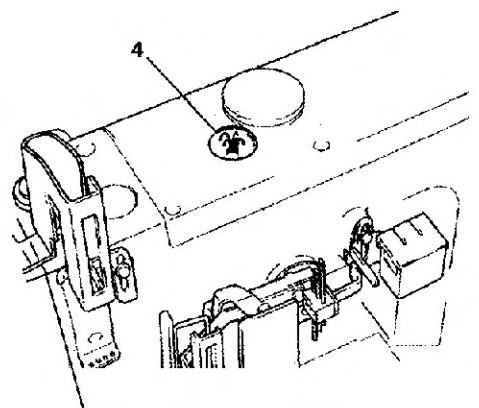
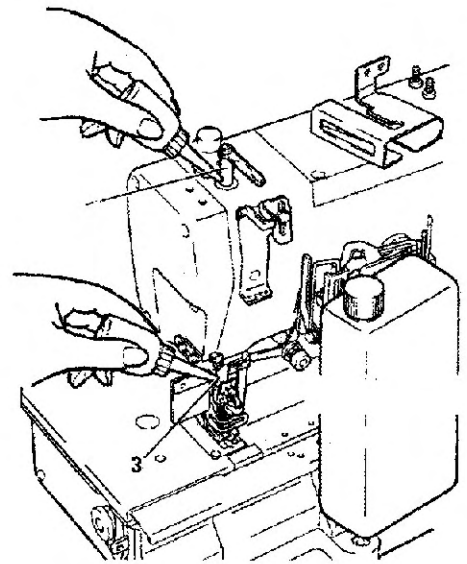
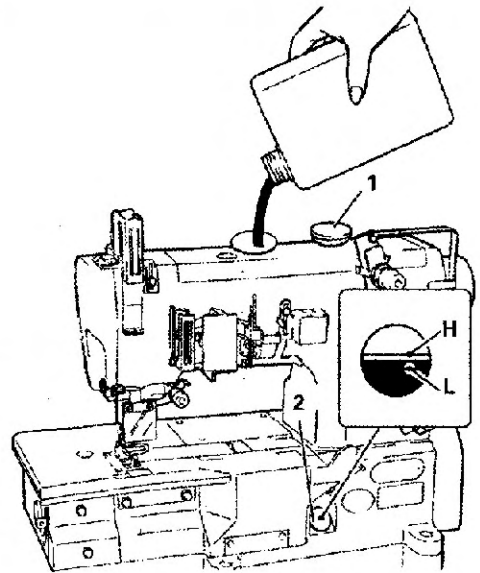
Always turn off the power and unplug the machine when you apply oil by hand. In the beginning of using the sewing machine, or when using the sewing machine for a long time without using it, apply two or three drops of oil to needle bar 3 by hand.

Apply two or three drops of oil to needle bar 3 by hand when the machine is used for the first time or left unused for some time.

5. 检查机油的循环状况 Checking oil circulation

请在加完油后，踩下缝纫机踏板，使缝纫机运转，通过油窗4检查机油的循环状况是否良好。

Once the machine has been properly filled with oil, press the machine treadle to run the machine and check gauge window 4 to see if the oil is flowing.



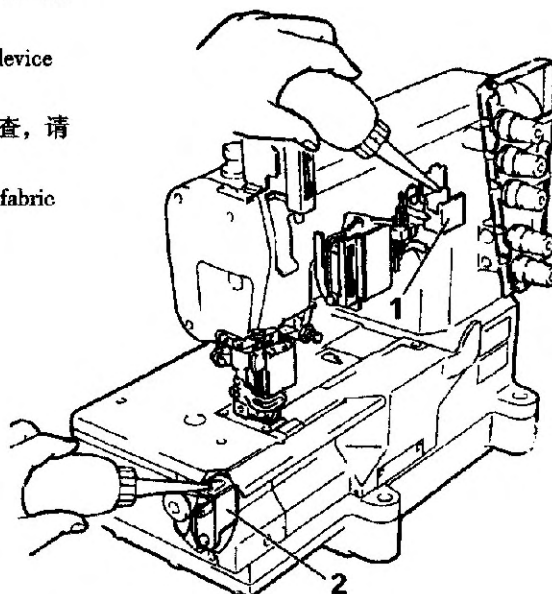
给HR装置供油 Silicone oil for H.R. device

在给HR装置供油时，务必将缝纫机的电源关掉，将插头从电源插销上拔下来之后再行。

Always turn off the power and unplug the machine when you fill the HR device with silicone oil.

在HR装置的硅油盒1·2，为了防止机线断线加有硅油，请经常检查，请尽早补充硅油。

Fill silicone oil tanks 1, 2 with silicone oil. To prevent thread breakage or fabric damage, add the silicone oil before it is too low.



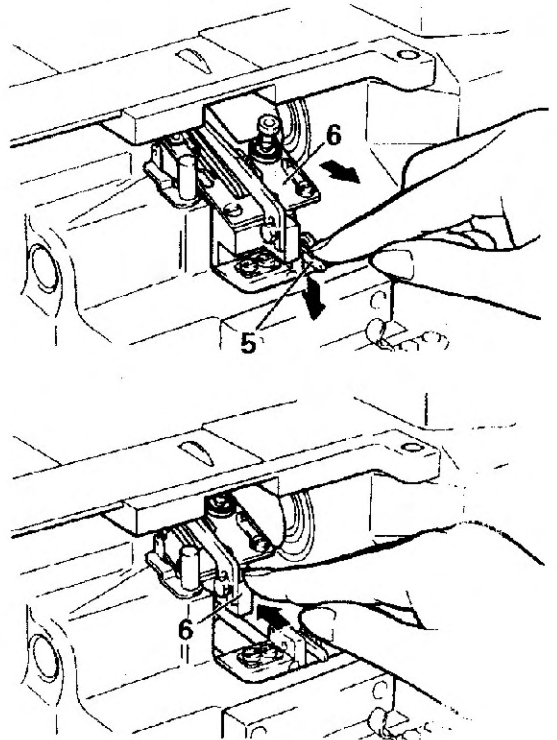
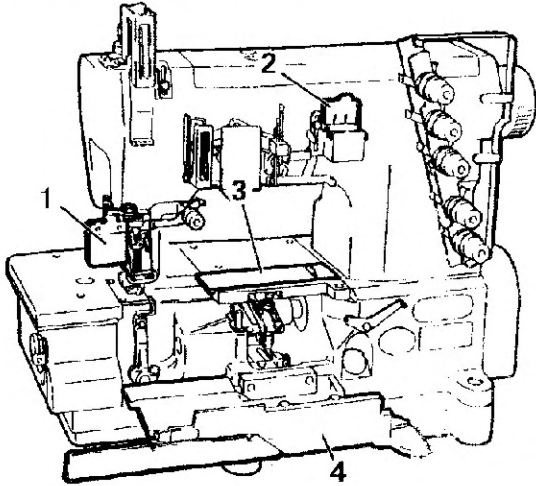
穿线的方法 Threading

在进行穿线时，务必将缝纫机的电源关掉，将插头从电源插销上拔下来之后再行。

Always turn off the power and unplug the machine when you thread the machine.

1. 请打开护眼罩1和护盖2、3、4

Open eye guard 1 and covers 2,3 and 4.



2. 请按板手5，这时下线挑线器6会挑出来，穿好线后，在返回原来的位置时，请按下下线挑线器6。

Press lever 5 and bracket 6 comes out toward you. After threading, press bracket 6 into place.

3. (如果已穿好线时)

In case the machine is threaded previously
A部：请将已穿好的线与缝纫用线连接起来。

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

B部：针线 Needle thread

将连接的针线穿到针眼前后，剪掉接头，再重新穿针线。

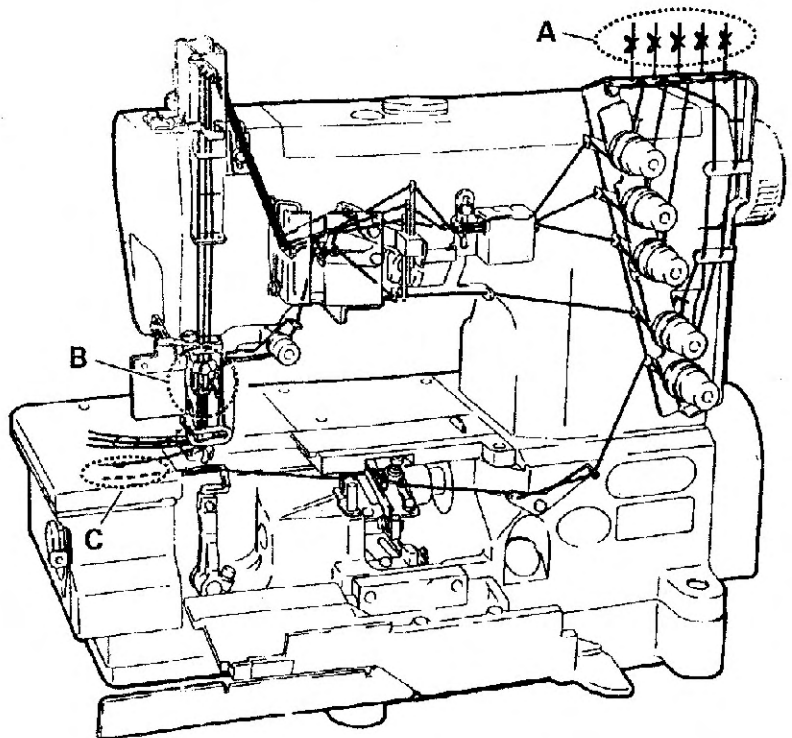
Trim the knots off neatly before passing through the eye of the needle to thread.

C部：弯针线、上装饰线

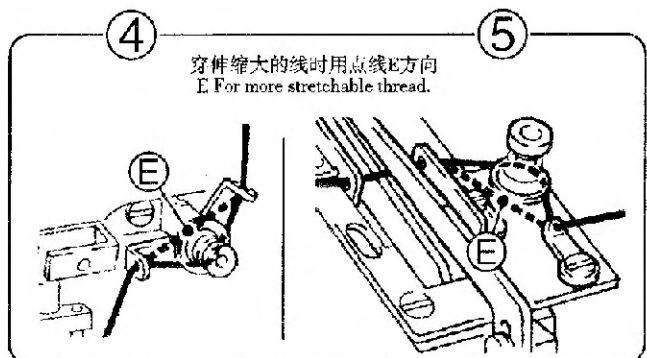
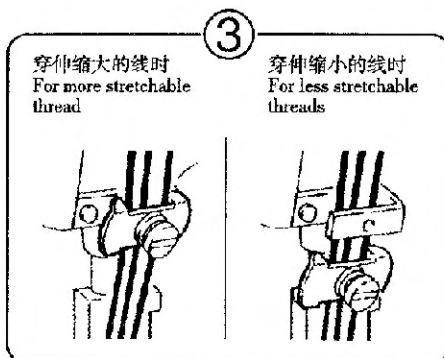
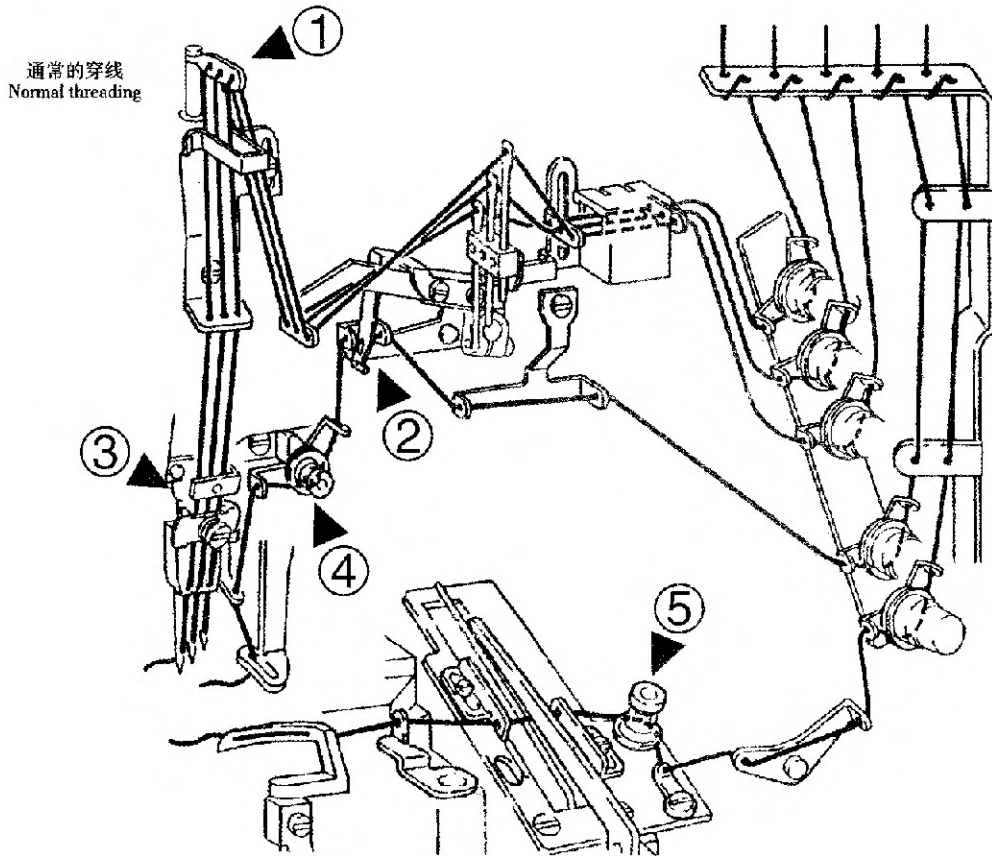
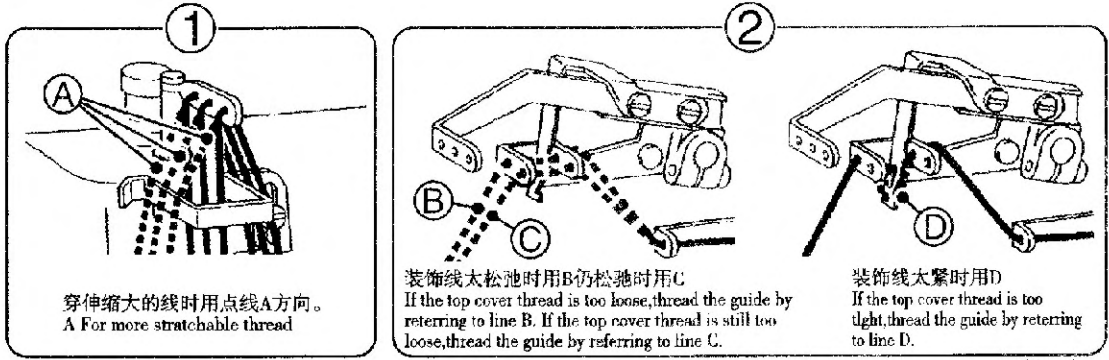
Looper thread, Top cover thread.

可一直将连接的线头穿好后，再用剪刀剪掉线头整好。

Trim the knots off neatly after passing through the eye of the looper.



4. 穿线图 Threading diagram



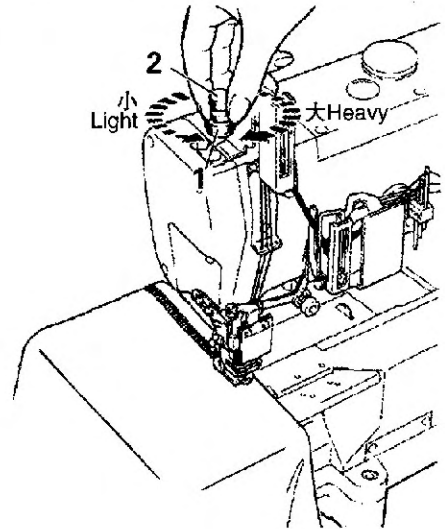
压脚压力的调节 Adjusting presser foot pressure

压脚的压力在送布能正确的进行，并且能缝出稳定针脚的范围内，请尽量使用较小的压力为宜。

The presser foot pressure should be as light as possible, yet sufficient to feed the fabric correctly and provide the uniform stitch formation.

松开螺母1，旋转螺丝2进行调节，调节完后拧紧螺母1。

Loosen nut 1, Adjust the presser foot pressure, Adjustment is made by turning screw 2 clockwise or counterclockwise. Tighten nut 1.



差动比的调节 Adjusting the differential feed ratio

1. 松开螺母3，将板手4向下扳，则差动比变大，缝纫的布料会伸长。

Loosen nut 3 for the differential feed ratio adjustment.

To increase the differential feed ratio, lower lever 4.

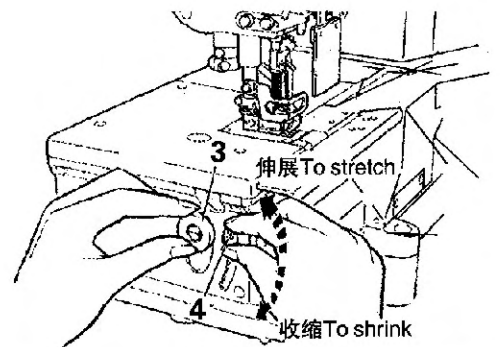
The finished fabric is shrunk.

To decrease the differential feed ratio, raise lever 4.

The finished fabric is stretched.

2. 调节完后，请将螺母3拧紧。

After this adjustment tighten nut 3.



针脚长度的调节 Adjusting stitch length

在调节针脚长度时，务必将缝纫机的电源关掉，并将插头从电源插销上拔下来之后，再请专门的技术人员进行操作。

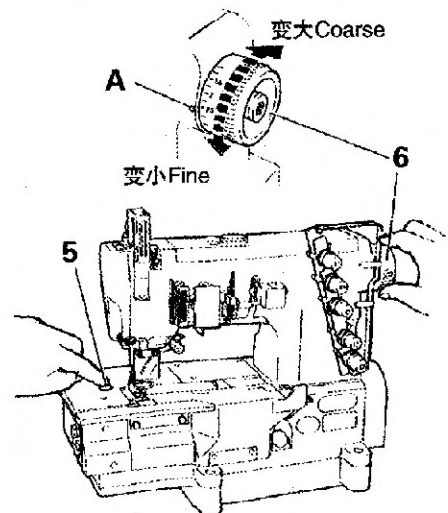
Always turn off the power and unplug the machine when adjusting the stitch length.

1. 一边轻轻按着套式按钮5，一边转动手轮6，这时套式按钮会陷下去一些。

While pressing the push button 5, turn the handwheel 6 to seek the position at which the push button 5 goes further into the depth.

2. 请继续按着套式按钮5，并转动手轮6，使所希望的刻度与记号A相吻合。

Then keeping the push button 5 pressed, turn the handwheel 6 and set the desired scale to the aligning mark A.



注: Note

缝纫针脚长度的调节，请务必在调节差动比之后进行。

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

线状态的调节请用针线调节旋钮1，上装饰线调节旋钮2和下弯针调节旋钮3进行调节。

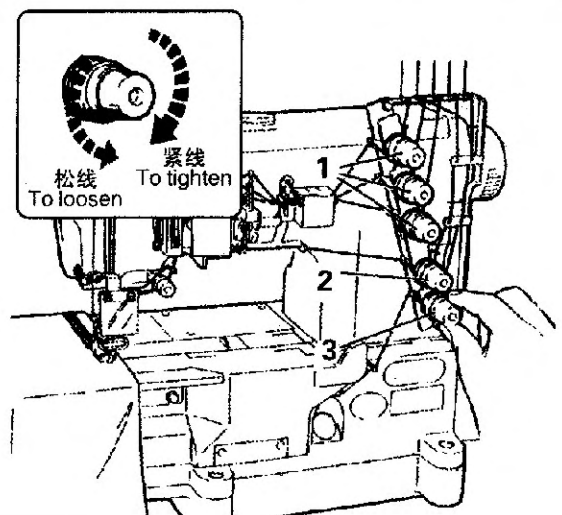
To obtain the proper thread tension, adjust needle thread tension knobs 1, top cover thread tension knobs 2 and looper thread tension knob 3.

想将线拉紧一些时，可将各旋钮向右旋转，想松一些时可向左旋转。在能取得均匀且漂亮缝纫效果的情况下，尽量采用较松的夹线状态。

To tighten the thread, turn each knob clockwise.

To loosen the thread, turn each knob counterclockwise.

Each thread tension should be as light as possible, yet be sufficient to produce balanced and beautiful stitches.



缝纫机的清扫 Cleaning the machine

在清扫缝纫机时，务必将缝纫机的电源关掉，将插头从电源插销上拔下来之后再行。

Always turn off the power and unplug the machine when you clean the machine.

1. 打开穿线罩4和推板5，请松开螺丝6，卸下针板7。

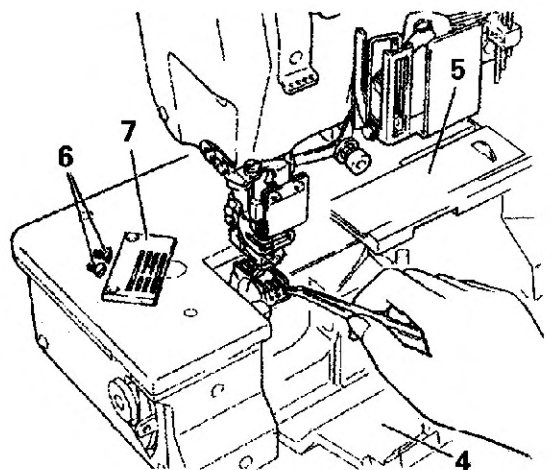
Open front cover 4 and slide plate 5. Loosen screws 6 and remove needle plate 7.

2. 请打扫针板的空槽和送布牙周围。

Clean the grooves of the needle plate and the area around the feed dogs.

3. 请用螺丝6安装针板7，并且关闭穿线罩4和推板5。

Replace needle plate 7 with screws 6. Then close front cover 4 and slide plate 5.



机针的更换 Replacing the needle

在更换机针时，务必将缝纫机的电源关掉，将插头从电源插销上拔下来之后再行。

Always turn off the power and unplug the machine when you replace the needle(s).

1. 请使用红色把柄（1.5mm）的六角螺丝刀松开固定螺丝1。

Loosen screw(s) 1 using a red-handled key wrench(1.5mm).

2. 用附带工具箱的镊子将旧针取下来。

Remove the old needle(s) by using a pincette (provided as accessories).

3. 将机针的凹槽朝着缝纫机后面进行安装。

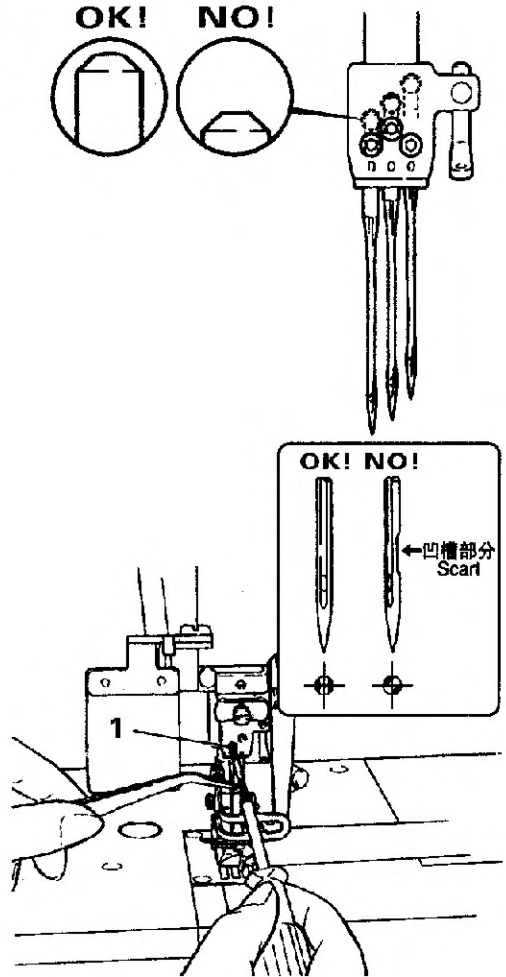
Fix the needle so that its scarf faces the rear side of machine.

4. 用镊子将新针插入到针箍架孔的最深处。

Insert a new needle into the neele hole as far it will go by using a pincette.

5. 然后使用红色把柄（1.5mm）的六角螺丝刀拧紧固定螺丝1。

Tighten screw(s) 1 using a red-handled key wrench(1.5mm).



机油的更换 Oil replacement

缝纫机在开始使用1个月后更换一次机油，然后请每6个月更换一次机油。如果不更换机油继续使用，缝纫机有可能发生故障。

Replace the oil one month after the first use and thereafter every six months. If you keep using the old oil it may cause the damage to the machine.

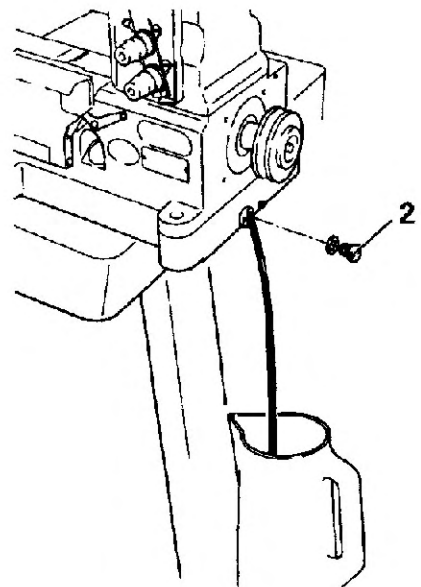
排油的方法 To drain the oil

1. 请卸开油箱底座排油孔盖螺丝2，排出旧油。

Drain the oil by removing screw 2 on the left side of the oil pan.

2. 排完油后，将排油孔盖螺丝2拧紧。

Tighten screw 2 after draining.



油泵滤油网的检查与清扫 Checking and cleaning the oil filter

在进行油泵滤油网的检查与清扫时, 务必将缝纫机的电源开关关掉, 将电源插头从插座上拔下之后, 请专门的技术人员进行操作。

Always turn off the power, unplug the machine and then well-qualified technicians should check and clean the oil filter.

每6个月请将油泵滤油网卸下来检查、清扫一次。

Check and clean the oil filter every six months.

To check and clean the oil filter.

1. 卸下螺丝1、2, 然后请卸下油盘3。

Remove screws 1 and 2, Remove oil reservoir 3.

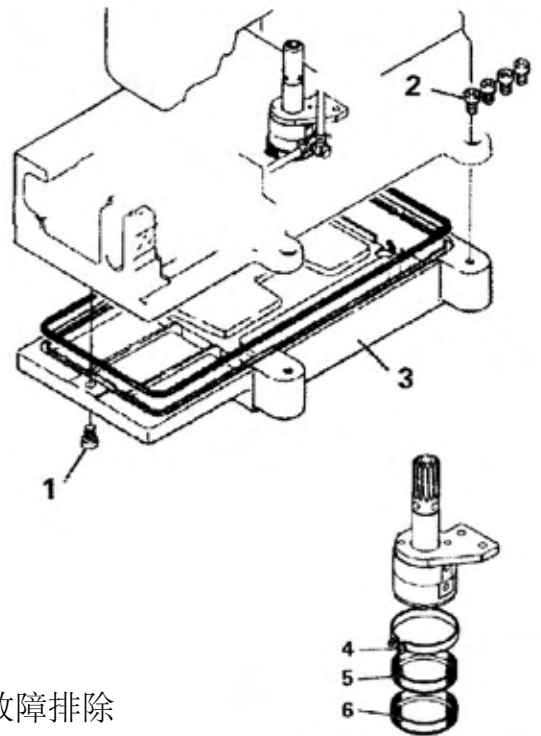
2. 松开螺丝4, 拆卸下过滤网5(内)和过滤网6(外), 然后请进行检查和清扫。

Loosen screw 4, Remove inner and outer filters 5 and 6.

Then check and/or clean these filters.

3. 请将油盘3(内)过滤网5和(外)过滤网6按原来的样子进行安装。

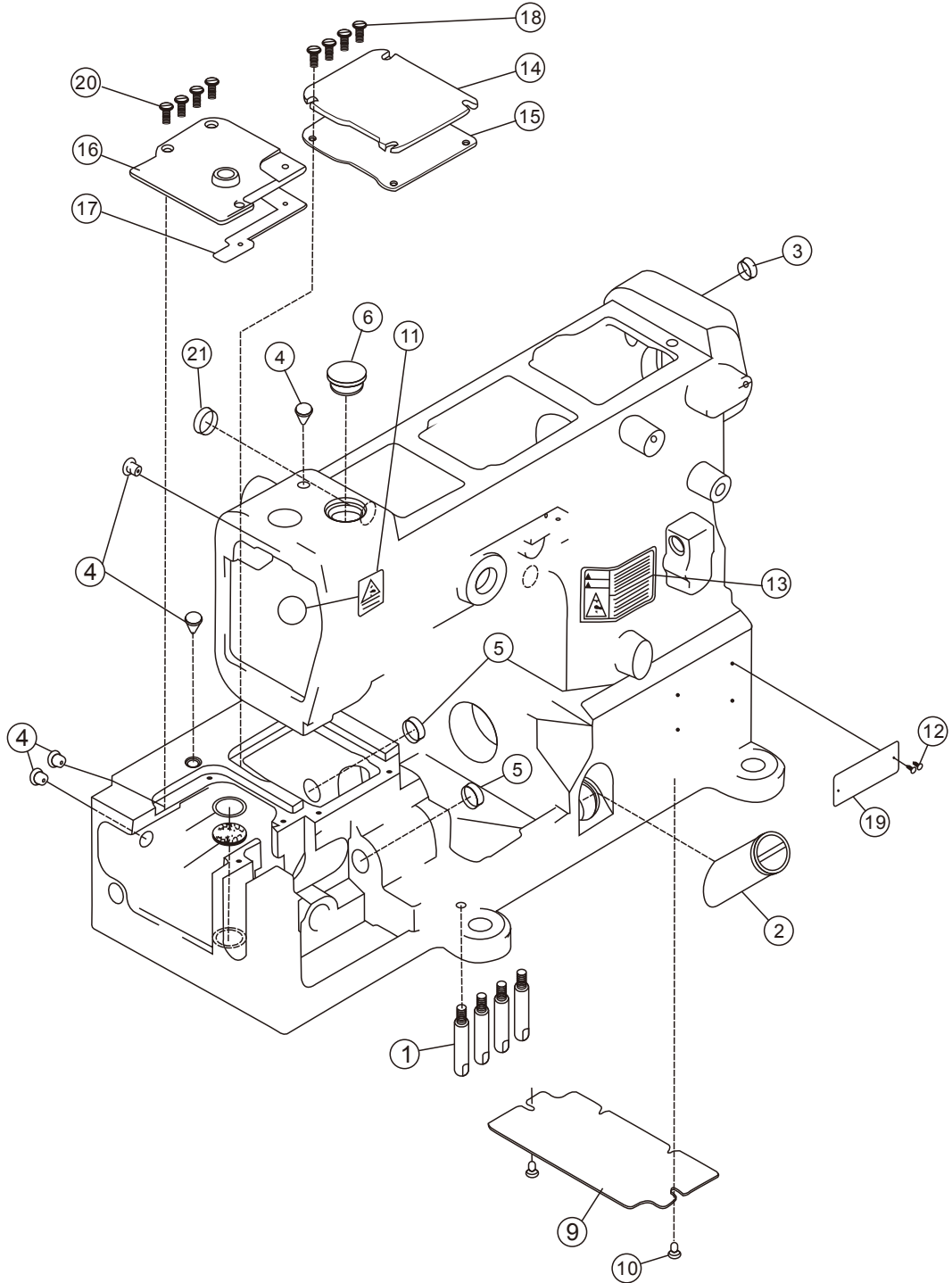
Reinstall oil reservoir 3, filters 5 (inner) and 6 (outer).



Troubleshooting 故障排除

Problems 问题	Possible Causes 原因	Possible Solutions 解决方案
Needle break 断针	1. Needle is installed wrong 机针安装错误	1. Install needle correctly 重新安装机针
	2. Wrong needle type or size 机针型号错误	2. Use proper needle for fabric and thread 更换合适的机针
	3. Needle is bended 机针变形	3. Change the needle 更换机针
	4. Wrong relation with needle guards 护针器连接错误	4. Readjust the needle guard 重新调整护针器
	5. Wrong relation with looper 弯针连接错误	5. Readjust the looper 重新调整弯针
	6. Needle does n't center the needle slot of needle plate or presserfoot 机针未在针板或压脚的针槽中心	6. Readjust the needle plate or presserfoot 重新调整针板或压脚
	1. Low quality thread 线的质量差	1. Change the thread 换线
	2. Thread is thicker than needle hole 线比针眼厚	2. Use proper needle for fabric and thread 用适合布料和线的针
Thread break 断线	3. Wrong threading 穿错线	3. Rethread the machine correctly 给机器重新正确穿线
	4. Thread tension is too strong 线张力过强	4. Readjust the thread tension unit 重新调整线张力单元
	5. Needle is installed wrong 机针安装错误	5. Install needle correctly 重新正确安装机针
	6. Thread stand installed wrong 线架安装错误	6. Install thread stand correctly 重新正确安装线架
	7. Overheat of the needle 机针过热	7. Fill in the silicon oil and/or readjust the needle guard 加硅油/重新调整护针器
	8. Wrong relation of needle and looper 机针和弯针的错误连接	8. Readjust needle and looper relation 重新调整机针和弯针
	1. Wrong relation of needle and looper 机针和弯针的错误连接	1. Readjust needle and looper 重新调整机针和弯针
	2. Wrong threading 穿线错误	2. Rethread the machine correctly 给机器重新正确穿线
Skip stitches 跳针	3. Needle is installed wrong 机针安装错误	3. Install needle correctly 正确安装机针
	4. Inadequate thread tension 线张力不足	4. Readjust the thread tension nuts 重新调整螺母线张力
	5. Looper point is damaged 弯针尖磨损	5. Replace by a new part 更换弯针
	7. Wrong installation of needle guard 护针安装错误	7. Install needle guard correctly 重新调整护针

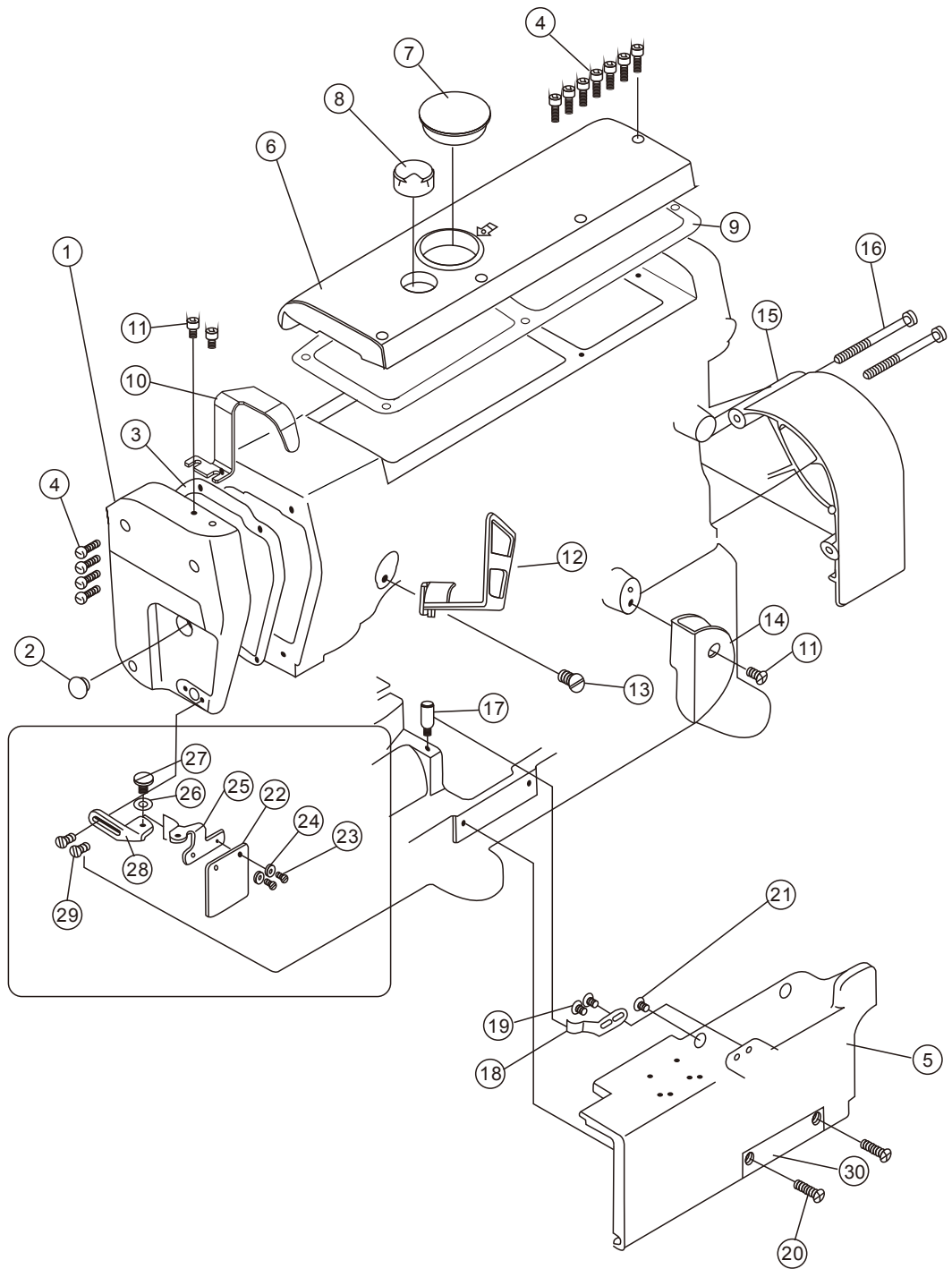
2.1 机壳结构 (A) MACHINE BED FRAME (A)



2.1 机壳结构(A) MACHINE BED FRAME(A)

序号 PEF NO	件 号 PART NO	名 称	DESCRIPTION	数量 QTY	
				562A	562A-BD
1	10042368	机座螺钉	BED PIN	4	4
2	10042369	油量指示窗	OIL LEVEL GAUGE	1	1
3	10042370	抬压轴后油塞	PLUG	1	1
4	10042371	机头油塞	PLUG	4	4
5	10010782	橡胶塞	PLUG	2	2
6	10008964	橡胶塞	PLUG	1	1
7	10003330	Φ18 挡圈	RING	3	3
8	10012087	滤油网	FILTER	3	3
9	10042376	底盖板	COVER	1	1
10	10042377	底盖板螺钉	SCREW	2	2
11	10043147	三角形标贴	CAUTION LABEL	1	1
12	10002840	2×5 铆钉	PIN	2	2
13	10008936	机头安全提示牌	STICKER	1	1
14	10042378	弯针传动盖板	TOP COVETR PLATE (RIGHT)	1	1
15	10042379	弯针传动盖板垫	GASKET	1	1
16	10042380	针距按钮盖	TOP COVETR PLATE (LEFT)	1	1
17	10042381	针距按钮盖密封垫	GASKET	1	1
18	10042382	弯针传动盖板螺钉	SCREW	4	4
19	10052657	型号牌☆	MMODEL CARD☆	1	1
20	10042440	针距按钮盖螺钉	SCREW	4	4
21	10010931	油封	OIL SEAL	1	1

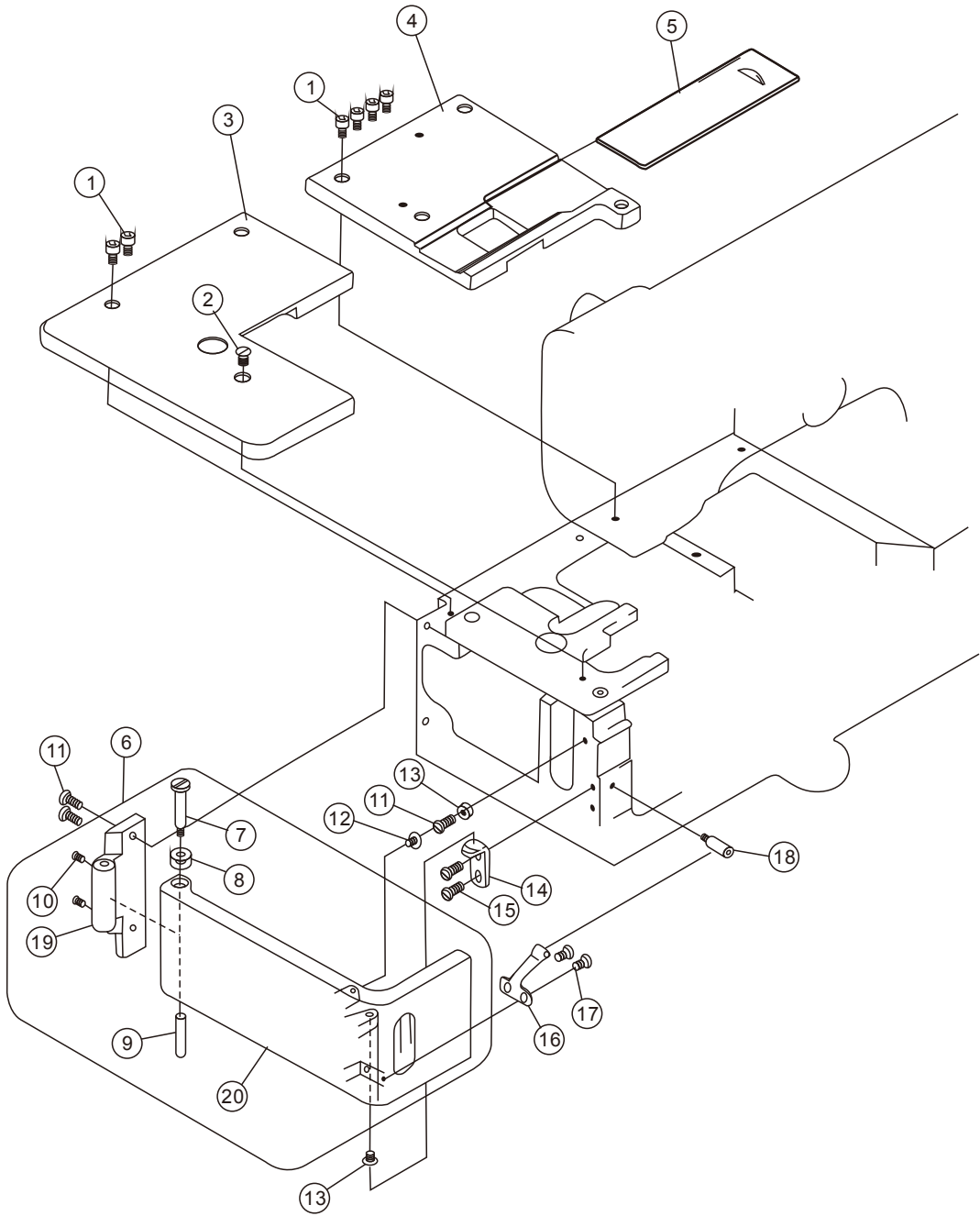
2.2 机壳结构 (B) MACHINE BED FRAME (B)



2.2 机壳结构(B) Machine Bed Frame(B)

序号 PEF NO	件号 PART NO	名称	DESCRIPTION	数量 QTY	
				562A	562A-D
1	10042384	面板☆	FACE PLATE☆	1	1
2	10013170	橡胶塞	PLUG	1	1
3	10042386	面板密封垫	PANEL SEAL GASKET	1	1
4	10042387	面板螺钉	SCREW	11	11
5	10052829	穿线罩板 *	FRONT COVER	1	0
6	10042389	上盖板	UPPER COVER PLATE	1	1
7	10042390	上盖闷头	PLUG	1	1
8	10042391	喷油窗	OIL SIGHT WINDOW	1	1
9	10042392	上盖板垫	SEAL	1	1
10	10042393	挑线杆防护罩	NEEDE BAR GUARD	1	1
11	10011264	挑线杆防护罩螺钉	SCREW	3	3
12	10042395	过线防护罩	BARCKET	1	1
13	10004974	螺钉	SCREW	1	1
14	10042397	底过线导板	LOOPER THREAD GUIDE COVER	1	1
15	10042398	皮带罩☆	PULLER COVER☆	1	1
16	10042399	皮带罩螺钉	SCREW	2	2
17	10042400	底线过线连接柱	SCREW	1	1
18	10042401	穿线罩弹簧	FLAT SPRING	1	1
19	10010837	螺钉	SCREW	2	2
20	10042403	穿线罩板铰链螺钉	SCREW	2	2
21	10042404	防震垫	CUSHION	1	1
22	10042405	防护罩	EYE GUARD	1	1
23	10042406	防护罩螺钉	SCREW	2	2
24	10042407	防护罩垫圈	WASHER	2	2
25	10042408	防护罩支架	BRACKET	1	1
26	10009470	垫圈	WASHER	1	1
27	10042410	螺钉	SCREW	1	1
28	10042411	防护罩座	BRACKET	1	1
29	10042412	螺钉	SCREW	2	2
30	10042415	穿线罩铰链	COVER	1	1

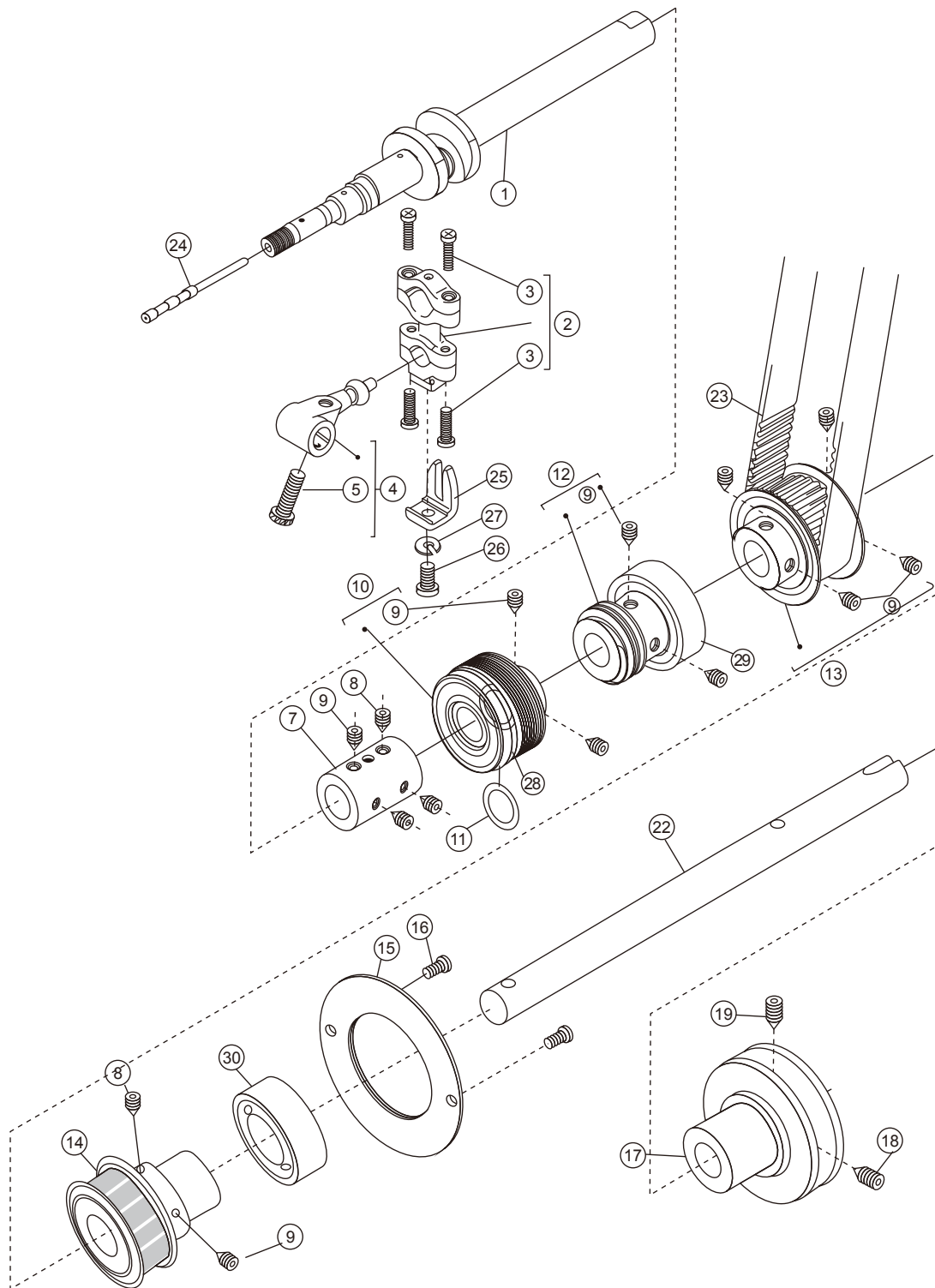
2.3 机壳结构(C) MACHINE BED FRAME (C)



2.3 机壳结构(C) MACHINE BED FRAME(C)

序号 PEF NO	件号 PART NO	名称	DESCRIPTION	数量 QTY	
				562A	562A-BD
1	10042387	螺钉	SCREW	6	6
2	10042420	缝台左罩定位螺钉	SCREW	1	1
3	10042421	缝台左罩	BED COVER (LEFT)	1	1
4	10042954	缝台右罩	BED COVER (RIGHT)	1	1
5	10042423	推板组件	COVER	1	1
6	10043224	左侧罩组件	SUDE COVER ASSEMBLY	1	1
7	10042427	螺钉	SCREW	1	1
8	10042419	垫圈	SPRING	4	4
9	10042428	左侧罩铰链销轴	PIN	1	1
10	10042429	铰链上头螺钉	SCREW	2	2
11	10042412	螺钉	SCREW	3	3
12	10042404	防震塞	CUSHON	2	2
13	10042424	螺母	NUT	1	1
14	10042425	防震板	BRACKLT	1	1
15	10011264	螺钉	SCREW	2	2
16	10042426	前罩板弹簧	FALT SPRING	1	1
17	10010837	螺钉	SCREW	2	2
18	10042400	螺钉	SCREW	1	1
19	10042430	左侧板铰链板	LINK COVER	1	1
20	10042431	左罩板	COVER (LEFT)	1	1

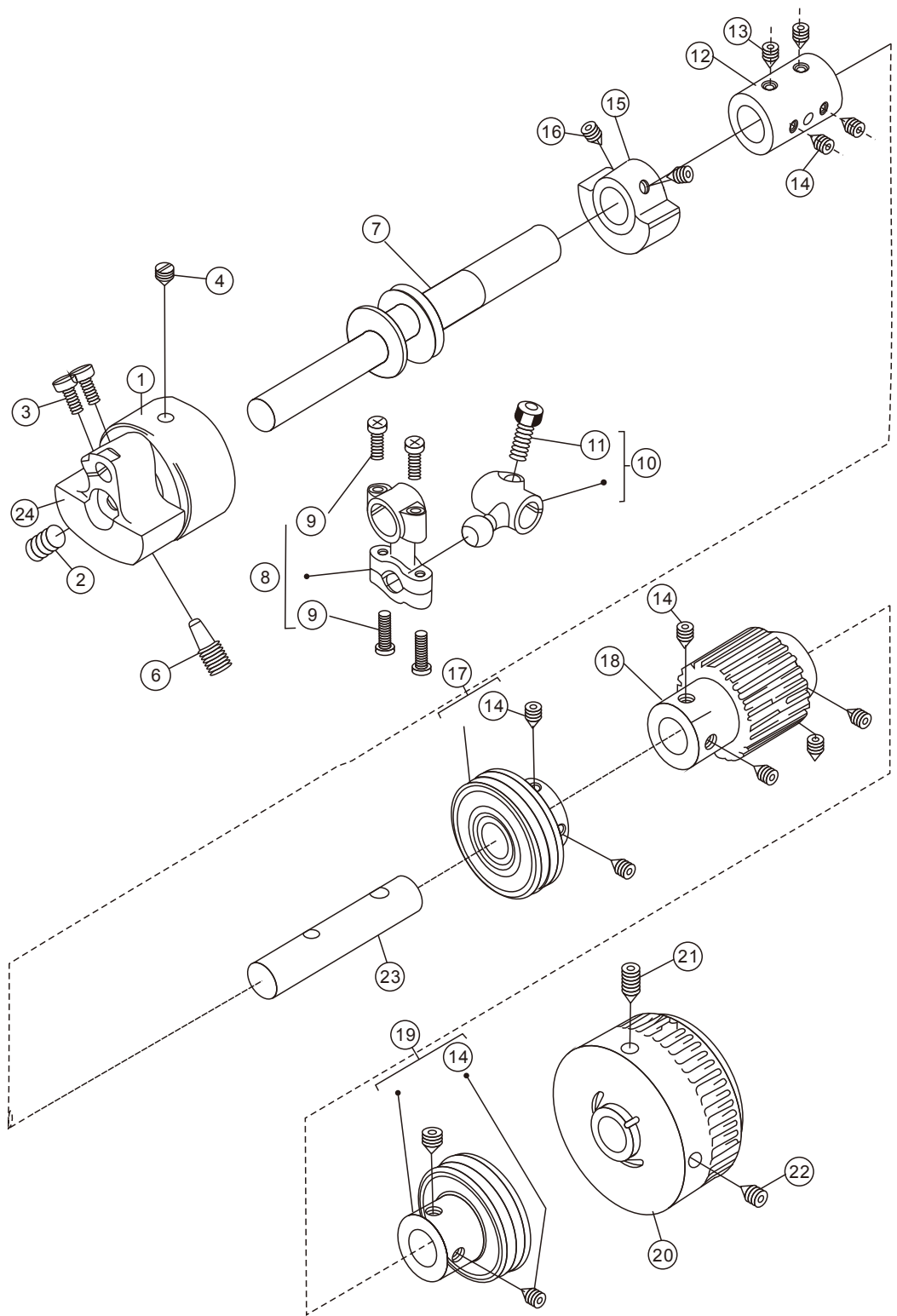
2.4 下轴传动机构 CRANK SHAFT DRIVE MECHANISM



2.4 下轴传动机构 CRANK SHAFT DRIVE MECHANISM

序号 PEF NO	件号 PART NO	名称	DESCRIPTION	数量 QTY	
				562A	562A-BD
1	10042432	下轴前节轴	CRANK SHAFT ASSEMBLY	1	1
2	10042454	弯针连杆组件	CONNECTION ASSEMBLY	1	1
3	10042387	螺钉	SCREW	8	8
4	10042433	球曲柄	CRANK)	1	1
5	10042434	螺钉	SCREW	1	1
6					
7	10042436	联轴器	JOINT	1	1
8	10042437	螺钉	SCREW	2	2
9	10042438	螺钉	SCREW	12	12
10	10042455	下轴中衬套	BUSHING	1	1
11	10053064	O型圈	O RING	1	1
12	10042459	油泵涡轮	BUSHING	1	1
13	10042910	主动同步带轮组件	GEAR	1	1
14	10042909	打线主动同步带轮组件	GEAR	1	1
15	10042439	压紧圈	COVER	1	0
16	10042440	压紧圈螺钉	SCREW	2	0
17	10042441	皮带轮	SCREW	1	0
18	10042442	螺钉	SCREW	1	0
19	10042443	螺钉	SCREW	1	0
20					
21					
22	10043209	下轴后节	SHAFT	1	0
23	10050281	同步带	TIMING BELT	1	1
24	10042448	下轴油量调节芯针	ADJUSTING BAR	1	1
25	10042449	叉口	GUIDE	1	1
26	10042450	叉口螺钉	SCREW	1	1
27	10042451	开口垫圈	WASHER	1	1
28	10047363	轴承O型圈组件	BEARING	1	1
29	10047364	轴承O型圈组件	BEARING	1	1
30	10042466	轴承	BEARING	1	1

2.5 上轴传动机构 ARM SHAFT DRIVE MECHANISM

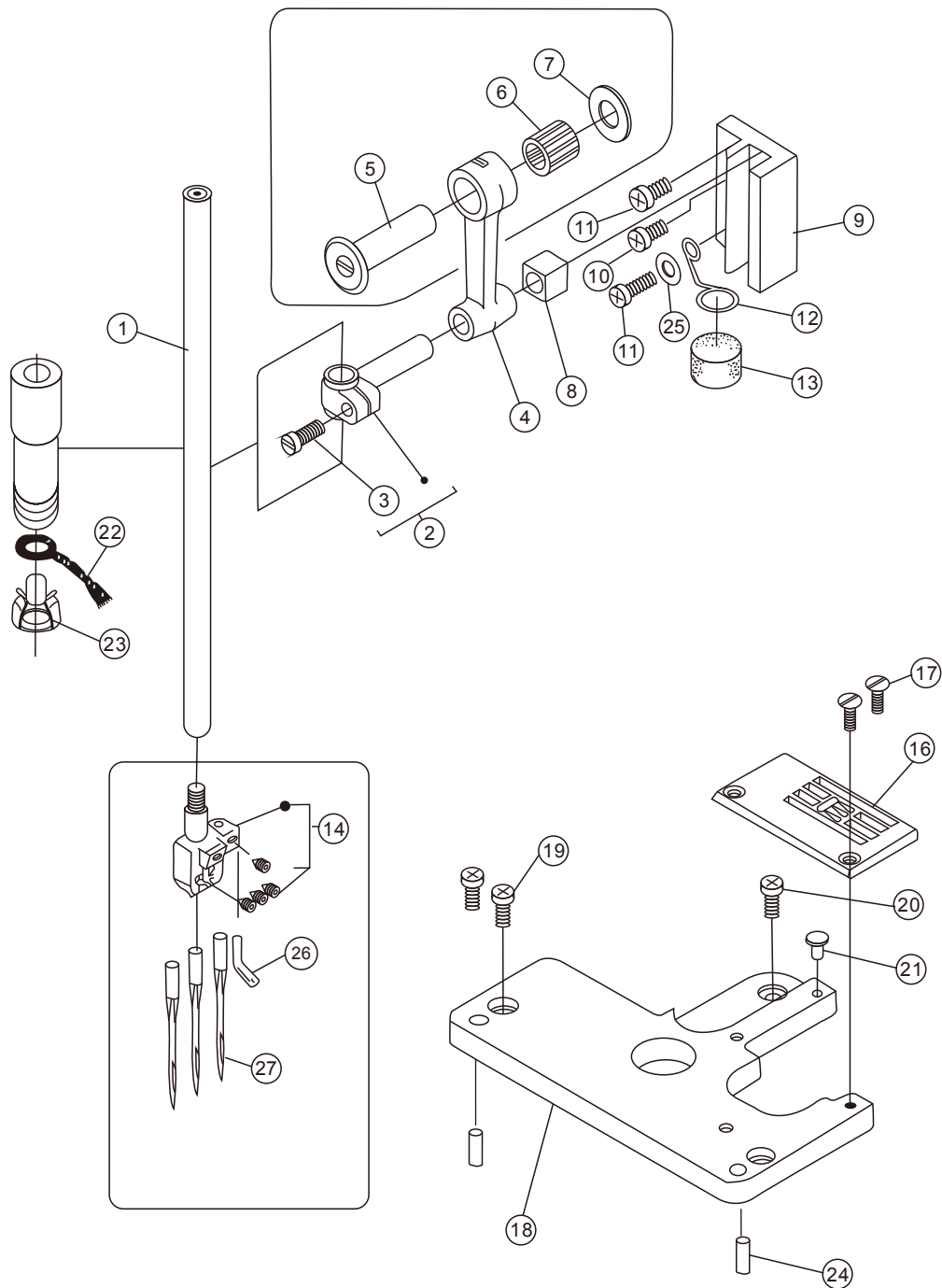


2.5 上轴传动机构 ARM SHAFT DRIVE MECHANISM

序号 PEF NO	件号 PART NO	名称	DESCRIPTION	数量QTY	
				562A	562A-BD
1	10051893	针杆曲柄轴承组	MOTION ASSEMBLY	1	1
2	10042480	针杆曲柄紧固螺钉	SCREW	1	1
3	10042481	针杆曲柄夹紧螺钉	SCREW	2	2
4	10005196	定位螺钉	SCREW	1	1
6	10042470	长锥定位螺钉	SCREW	1	1
7	10042471	上轴前节曲轴	CRANK SHAFT	1	1
8	10042484	上线挑线连杆	CONNECTION ASSEMBLY	1	1
9	10042387	螺钉	SCREW	4	4
10	10042472	上挑线球曲柄	BALL CRANK	1	1
11	10042434	球曲柄螺钉	SCREW	1	1
12	10042436	联轴器	JOINT	1	1
13	10042437	联轴器定位螺钉	SCREW	1	1
14	10042438	螺钉	SCREW	10	10
15	10042473	上轴平衡块	BALANCE WEIGHT	1	1
16	10042511	螺钉	SCREW	2	2
17	20014769	上轴前衬套轴承组	BUSHING	1	1
18	10042475	从动时规轮	GEAR(UPPER)	1	1
19	20014770	后衬套组件	BUSHING	1	1
20	10042476	手轮★	HAND WHEEL	1	1
21	10042442	螺钉	SCREW	1	1
22	10042443	螺钉	SCREW	1	1
23	10042474	上轴后节	SHAFT	1	1
24	10042479	针杆曲柄	NEEDLE BAR CRANK	1	1

2.6 针杆结构

NEEDLE BAR MECHANISM



2.6 针杆机构 NEEDLE BAR DRIVEMECHANISM

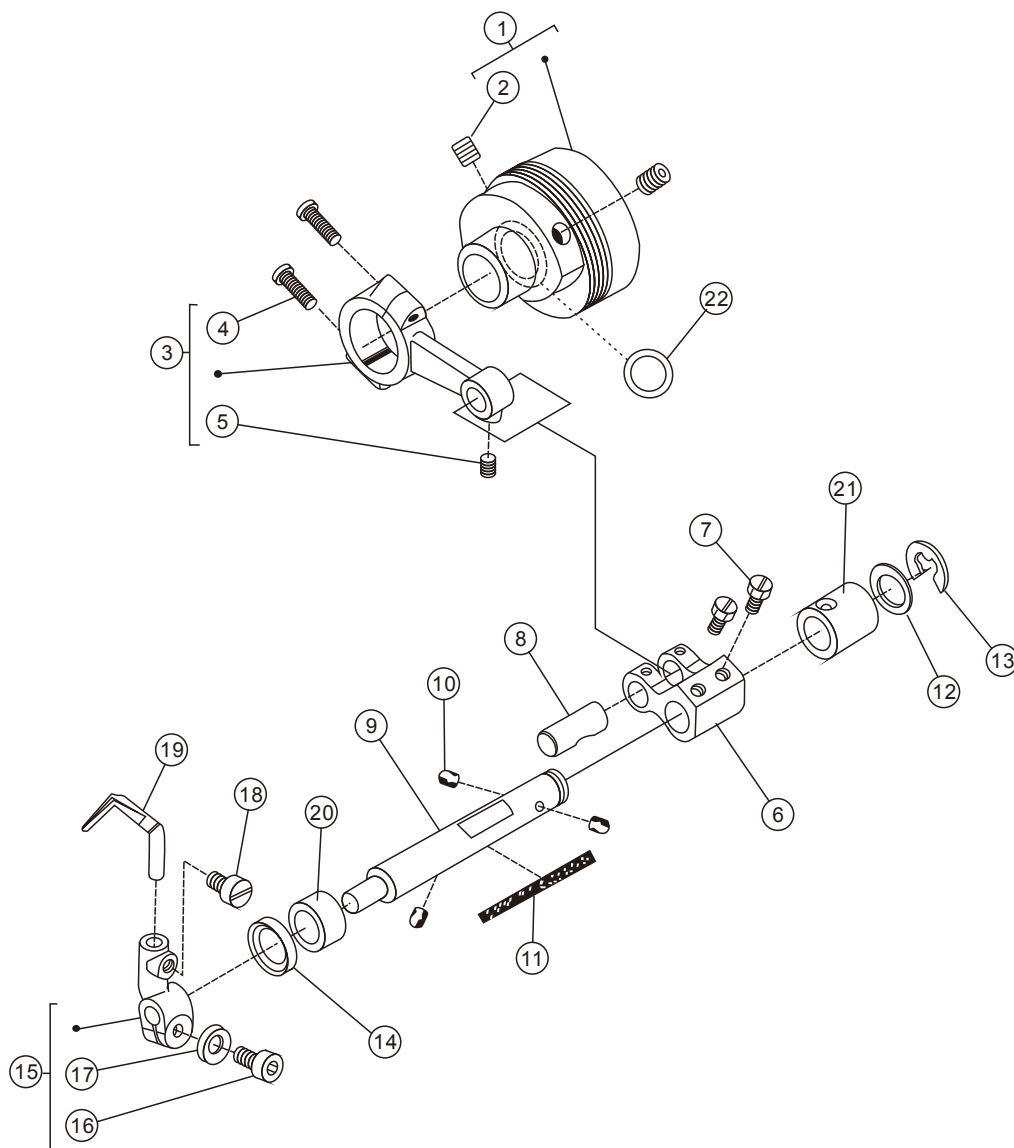
序号 PEF NO	件 号 PART NO	名 称	DESCRIPTION	数量QTY	
				562A	562A-BD
1	10042487	针杆	NEEDLE BAR	1	1
2	10042488	针杆接头	NEEDLE BAR CLAMP	1	1
3	10042489	针杆接头螺钉	SCREW	1	1
4	10042490	针杆连杆	NEEDLE BAR DRIVING LINK	1	1
5	10042491	针杆连杆销	PIN	1	1
6	10048172	滚针轴承	NEEDLE BEARING	1	1
7	10042493	垫圈	WASHER	1	1
8	10042494	针杆滑块	BLOCK	1	1
9	10042495	针杆滑块座	NEEDLE BAR BLOCK GUIDE	1	1
10	10012752	螺钉	SCREW	1	1
11	10003102	针杆滑块座螺钉	SCREW	2	2
12	10042497	油毡定位圈	LATCH	1	1
13	10042498	油毡	SPONGE	1	1
14	*	针夹螺钉组件	NEEDLE HOLDER	1	1
16	*	针板	NEEDLE PLATE	1	1
17	10042502	针板螺钉	SCREW	2	2
18	10042503	针板接板	BRACKET	1	1
19	10011264	螺钉	SCREW	2	2
20	10042440	螺钉	SCREW	1	1
21	10042504	防震塞	CUSHION RUBBER	1	1
22	10008069	油线	OIL WICK	1	1
23	10042506	针杆上套油线夹头	OIL WICK RETAINER	1	1
24	10042509	针板接板定位销	PIN	2	2
25	10002954	垫圈	RING	1	1
26	10042291	过线杆	THREAD GUIDE	1	1
27	10004902	UY128GBS 11#机针	NEEDLE	3	3

“*” 具体内容看专用件

Part number for “*”

Please refer the '2.23. Gauge Parts list'

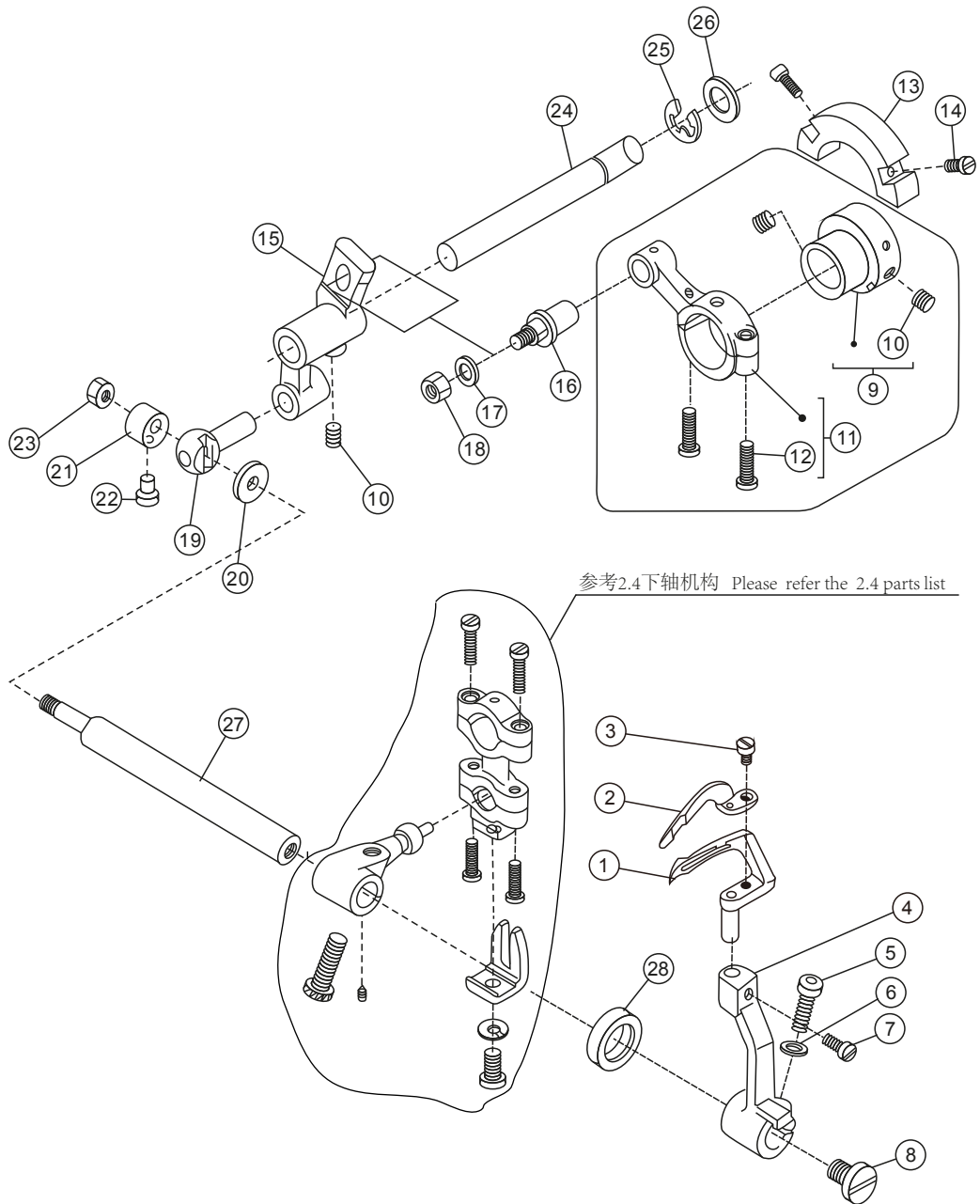
2.7 保针机构 NEEDLE GUARD MECHANISM



2.7 保针机构 NEEDLE GURAD MECHANISM

序号 PEF NO	件号 PART NO	名称	DESCRIPTION	数量 QTY	
				562A	562A-BD
1	10042527	下轴前衬套	ECCENTRIC ASSEMBLY	1	1
2	10042511	下轴前衬套螺钉	SCREW	2	2
3	10042528	保针连杆组件	CONNECTION ASSEMBLY	1	1
4	10042387	螺钉	SCREW	2	2
5	10042429	螺钉	SCREW	1	1
6	10042512	保针曲柄	CRANK	1	1
7	10042513	保针曲柄螺钉	SCREW	2	2
8	10042514	保针曲柄销	PIN	1	1
9	10042515	保针轴	SHAFT	1	1
10	10008090	油线	OIL WICK	1	1
11	10008088	油线	OIL WICK	1	1
12	10042518	保针轴垫圈	WASHER	1	1
13	10050347	挡圈	RING	1	1
14	10042520	保针轴骨架防油圈	OIL SEAL	1	1
15	10042521	保针座	NEEDLE GUIDE HOLDER	1	1
16	10042445	螺钉	SCREW	1	1
17	10009429	垫圈	WASHER	1	1
18	10042523	螺钉	SCREW	1	1
19	10043132	后保针	NEEDLE GUIDE (REAR)	2	2
20	10042525	保针轴左套	BUSHING (LEFT)	1	1
21	10042526	保针轴右套	BUSHING (RIGHT)	1	1
22	10042456	下轴前衬套 O 型圈	O RING	1	1

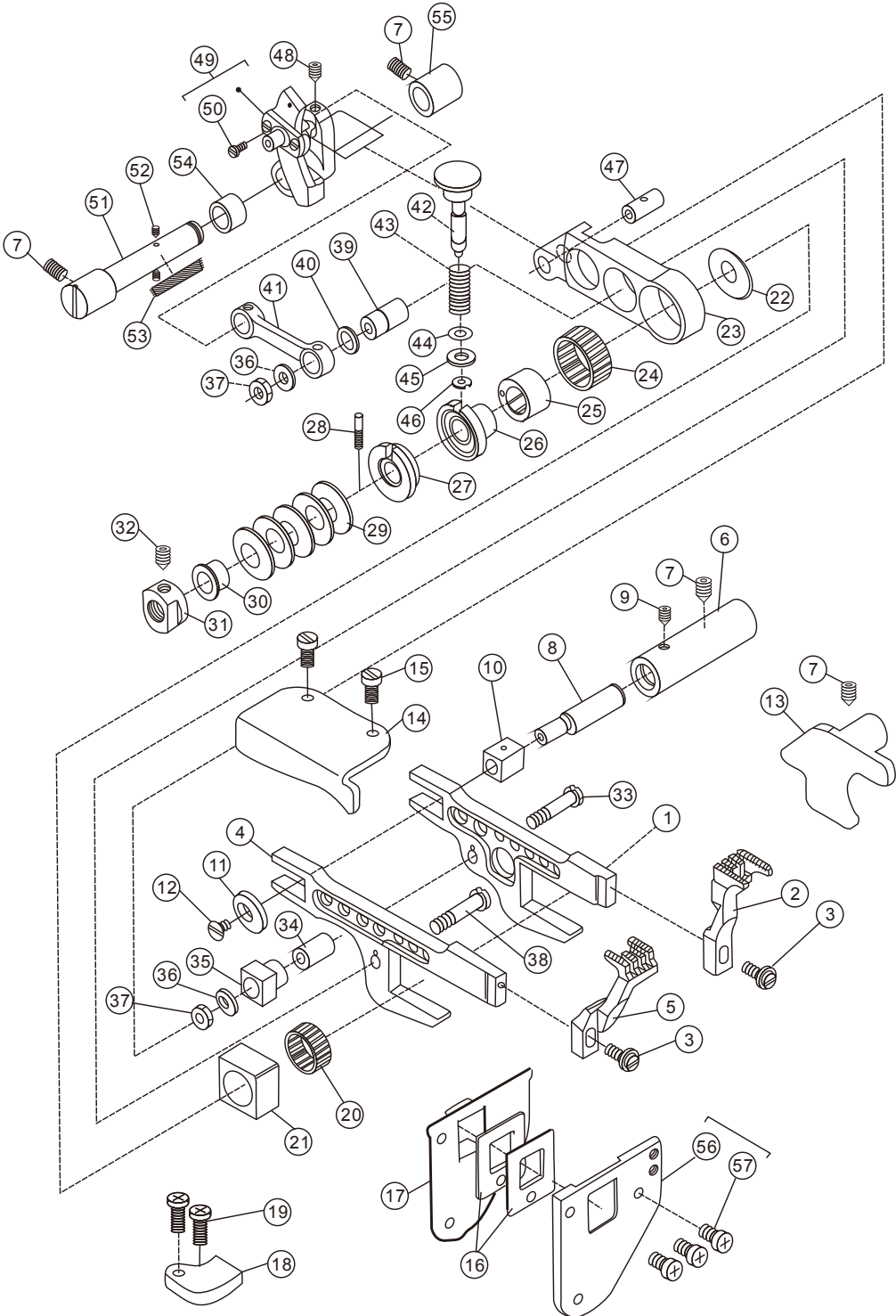
2.8 弯针机构 LOOPER DRIVE MECHANISM



2.8 弯针机构 LOOPER DRIVE MECHANISM

序号 PEF NO	件 号 PART NO	名 称	DESCRIPTION	数量 QTY	
				562A	562A-BD
1	10043134	弯针	LOOPER	1	1
2	10043135	前保针	NEEDLE(FRONT)	1	1
3	10042524	螺钉	SCREW	1	1
4	10042529	弯针曲柄	LOOPER HOLDER ASSEMBLY	1	1
5	10042478	螺钉	SCREW	1	1
6	10009429	垫圈	WASHER	1	1
7	10012032	螺钉	SCREW	1	1
8	10042531	弯针曲柄调节螺钉	SCREW	1	1
9	10042534	偏心凸轮	ECCENTRIC ASSEMBLY	1	1
10	10042511	螺钉	SCREW	3	3
11	10042548	弯针连杆组件	CONNECTION ASSEMBLY	1	1
12	10042387	螺钉	SCREW	2	2
13	10042535	平衡块	BALANCE WEIGHT	1	1
14	10042536	螺钉	SCREW	2	2
15	10042537	弯针调节摆杆	CRANK	1	1
16	10042538	弯针调节柱	SCREW	1	1
17	10042234	垫圈	WASHER	1	1
18	10042540	螺母	NUT	1	1
19	10042541	弯针防止挡接头	BLOCK PIN	1	1
20	10042542	垫圈	WASHER	1	1
21	10042543	偏心紧圈	COLLAR	1	1
22	10042513	螺钉	SCREW	1	1
23	10042544	螺母	NUT	1	1
24	10042545	弯针调节摆轴	SHAFT	1	1
25	10050347	挡圈	RING	1	1
26	10042518	垫圈	WASHER	1	1
27	10042533	弯针轴	SHAFT	1	1
28	10009399	油封	OIL SEAL	1	1

2.9 送布机构 FEED MECHANISM



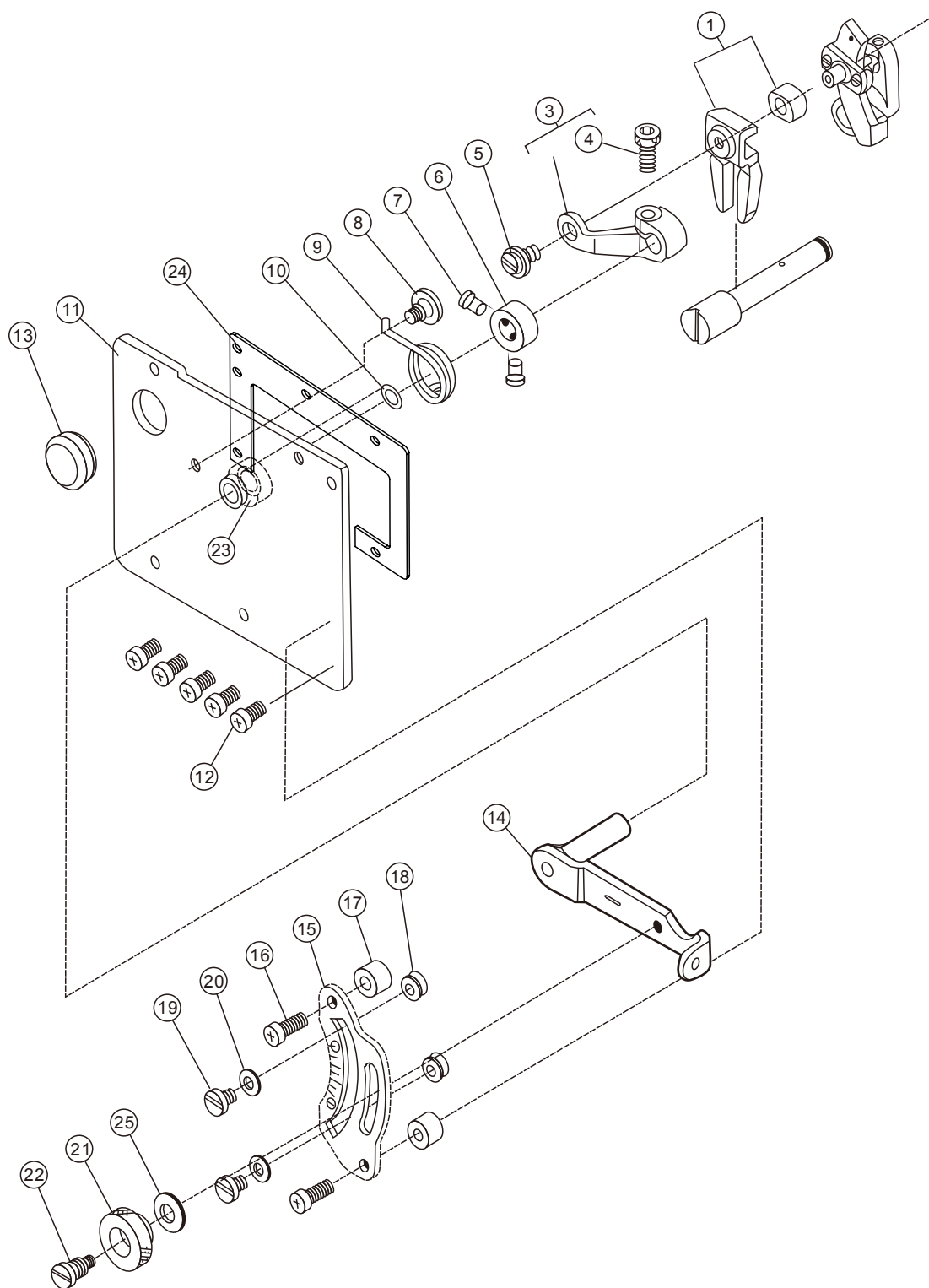
2.9 送布机构 FEED MECHANISM

序号 PEF NO	件 号 PART NO	名 称	DESCRIPTION	数量 QTY	
				562A	562A-BD
1	10042549	送料牙架	MAIN FEED BAR	1	1
2	*	主送布牙	MAIN FEED DOG	1	1
3	10042551	螺钉	SCREW	2	2
4	10042552	差动牙架	DIFFERENTIAL FEED BAR	1	1
5	*	差动送布牙	DIFFERENTIAL FEED DOG	1	1
6	10042554	偏心轴套	BUSHING	1	1
7	10042511	螺钉	SCREW	4	4
8	10042555	牙架偏心轴	ECCENTRIC PIN	1	1
9	10042556	偏心轴套螺钉	SCREW	1	1
10	10009633	滑块	GUIDE BLOCK	1	1
11	10042558	偏心垫片	WASHER	1	1
12	10042559	偏心轴螺钉	SCREW	1	1
13	10042560	牙架右限位板	RIGHT POSITION PLATE	1	1
14	10042561	牙架上限位板	UPPER POSITION PLATE	1	1
15	10042440	螺钉	SCREW	2	2
16	10042563	胶垫片	OIL SGIELD	1	1
17	10042564	垫板	COVER	1	1
18	10042565	左限位板	LEFT POSITION PLATE	1	1
19	10042412	螺钉	SCREW	2	2
20	10047403	滚针轴承	NEEDLE BEARING	1	1
21	10042567	牙架前滑块	BLOCK	1	1
22	10042568	凸轮送布连杆垫圈	WASHER	1	1
23	10042569	送布连杆	MAIN FEED LINK	1	1
24	10048638	滚针轴承	NEEDLE BEARING	1	1
25	10042571	凸轮	ECCENTRIC	1	1
26	10042572	送布调节凸轮	REGULATOR	1	1
27	10050150	针距调套	ECCENTRIC RETAINER	1	1
28	10043138	销螺钉	SCREW	1	1
29	10042574	碟形弹簧圈	SPRING	6	6
30	10042575	台阶套	SPACER	1	1
31	10042576	螺母	NUT	1	1
32	10012014	台阶套紧定螺钉	SCREW	1	1
33	10042577	送布滑块连接螺钉	SCREW	1	1
34	10042578	送布滑块套	BUSHING	1	1
35	10042579	送布滑块	GUIDE BLOCK	1	1

2.9 送布机构 FEED MECHANISM

序号 PEF NO	件号 PART NO	名称	DESCRIPTION	数量 QTY	
				562A	562A-BD
36	10042580	垫片	WASHER	2	2
37	10042581	螺母	NUT	2	2
38	10042582	连接螺钉	SCREW	1	1
39	10042583	送布连杆销套	BUSHING	1	1
40	10042584	开口挡圈	RING	1	1
41	10042585	差动送布连杆	DIFFERENTIC FEED LINK	1	1
42	10042586	针距按钮	PIN	1	1
43	10042587	针距按钮簧	SPRING	1	1
44	10042588	针距按钮 O 型圈	O RING	1	1
45	10013509	垫圈	WASHER	1	1
46	10009669	开口挡圈	RING	1	1
47	10042590	送布连杆销	RING	1	1
48	10042591	差动器紧定螺钉	SCREW	1	1
49	10042598	差动器组件	CRANK	1	1
50	10042524	差动器螺钉	SCREW	1	1
51	10042592	差动器轴	SHAFT	1	1
52	10008090	油线	OIL WICK	1	1
53	10008090	油线	OIL WICK	1	1
54	10042595	差动器隔套	SPACER	1	1
55	10042596	差动器轴套	BUSHING	1	1
56	10042597	弯针盖	BRACKET	1	1
57	10011264	螺钉	SCREW	3	3

2.10 差动调节机构 DIFFERENTIAL FEED MECHANISM



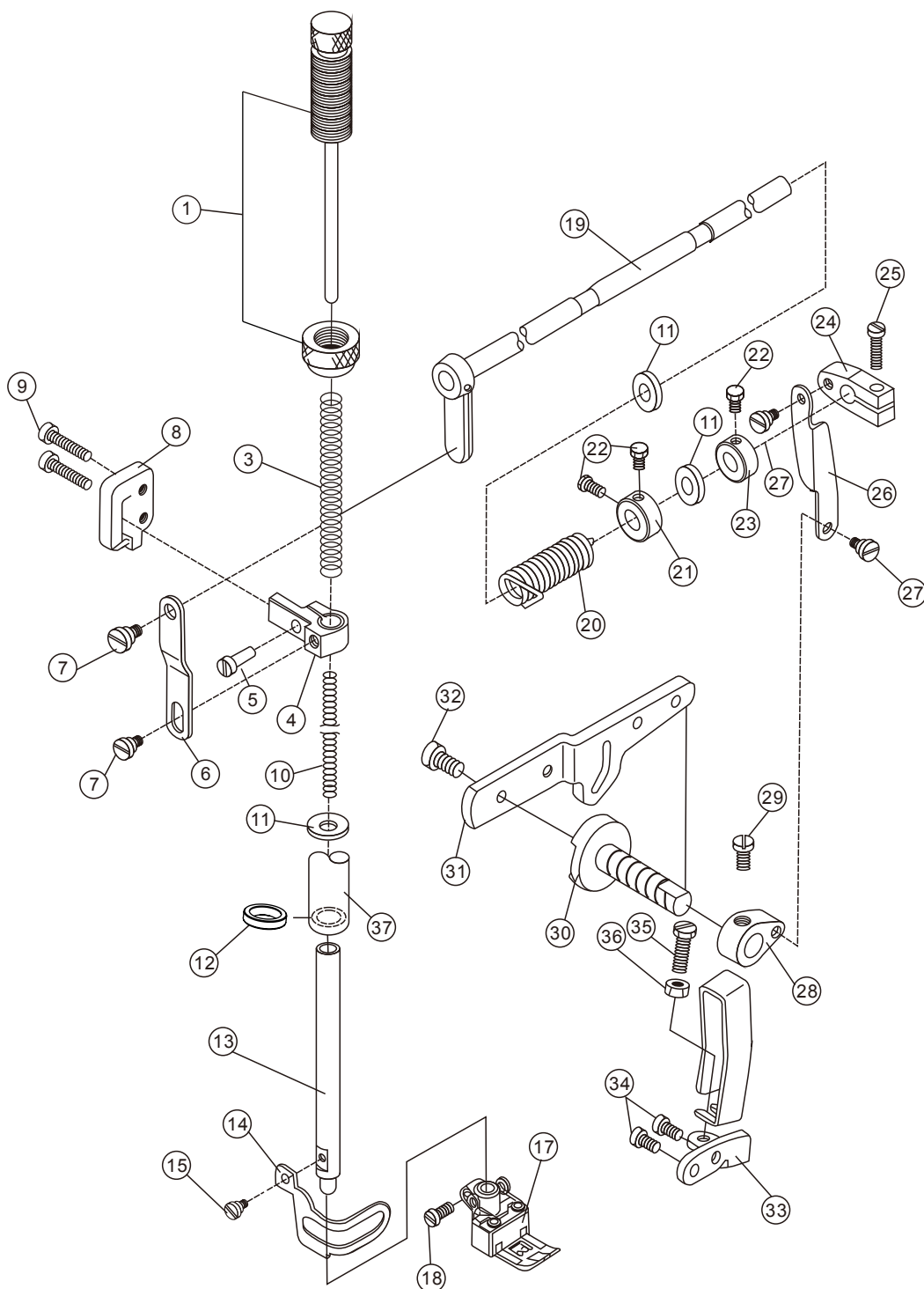
2.10 差动调节机构 DIFFERENTIAL FEED MECHANISM

序号 PEF NO	件号 PART NO	名称	DESCRIPTION	数量QTY	
				562A	562A-BD
1	10050801	差动器吊板滑块组件	GUIDE BLOCK	1	1
3	10042159	差动调节曲柄	LEVER	1	1
4	10042160	差动调节曲柄螺钉	SCREW	1	1
5	10042161	差动调节吊板螺钉	SCREW	1	1
6	10042162	差动扳手紧圈	COLLAR	1	1
7	10043440	螺钉	SCREW	2	2
8	10042410	螺钉	SCREW	1	1
9	10042164	差动调节复位弹簧	SPRING	1	1
10	10042165	O型圈	O RING	1	1
11	10042178	主板	BRACKET	1	1
12	10011264	螺钉	SCREW	5	5
13	10042166	闷头	PLUG	1	1
14	10042167	差动扳手	LEVER ASSEMBLY	1	1
15	10042468	差动刻度板	SCALE PLATE	1	1
16	10042387	螺钉	SCREW	2	2
17	10042169	刻度板隔套	SPACER	2	2
18	10042170	螺母	NUT	2	2
19	10042171	刻度板固定螺钉	SCREW	2	2
20	10042176	垫圈	WASHER	2	2
21	10042172	孔刻度板螺母	NUT	1	1
22	10042173	螺钉	SCREW	1	1
23	10042179	衬套	BUSHING	1	1
24	10042175	主板密封垫	GASKET	1	1
25	10042174	刻度盘垫片	WASHER	1	1

2.11 压脚结构

PRESSER FOOT MECHANISM

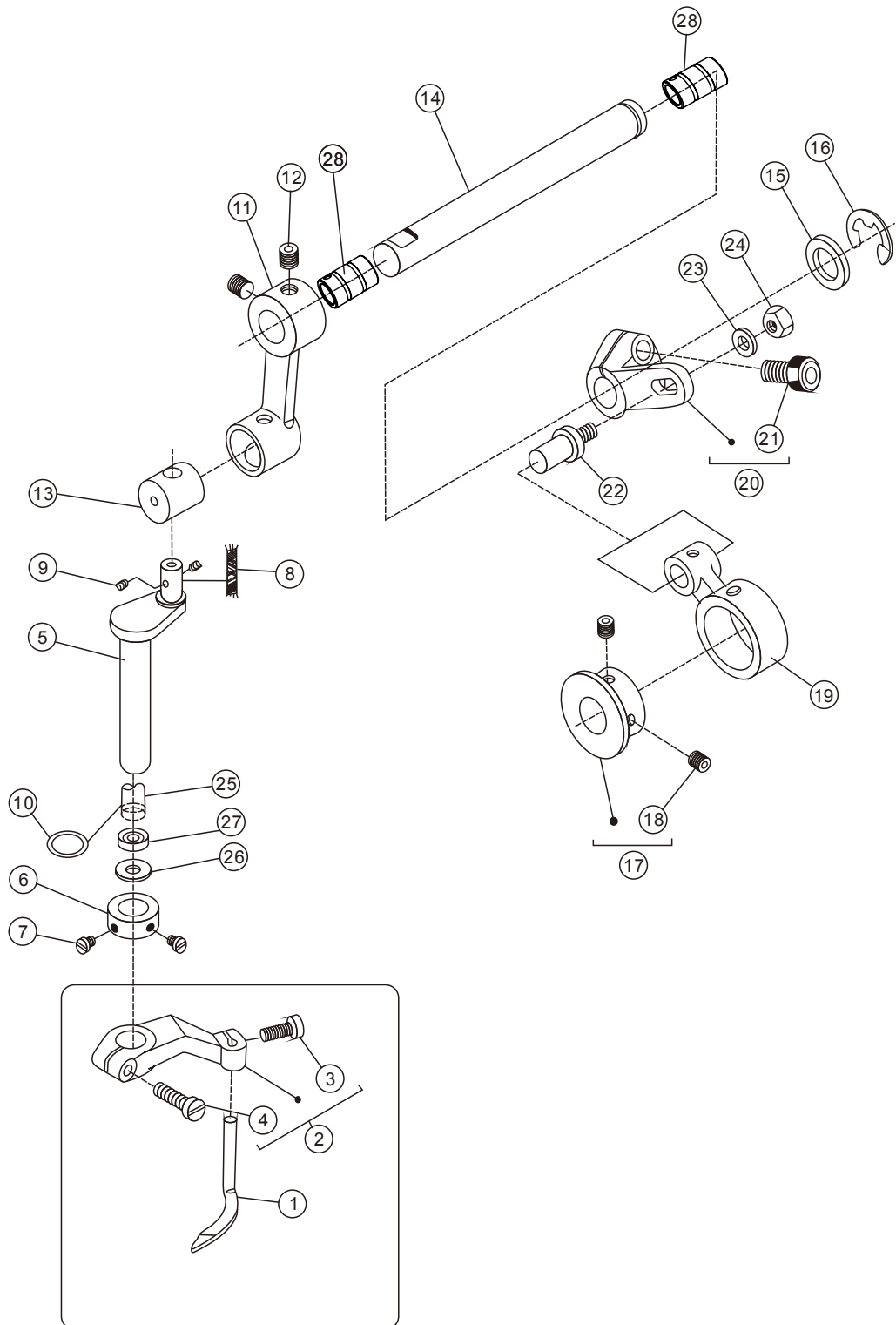
MECHANISM



2.11 压脚机构 PRESSER FOOT MECHANISM

序号 PEF NO	件号 PART NO	名称	DESCRIPTION	数量QTY	
				562A	562A-BD
1	10050802	调压螺钉螺母组件	ADJUSTING NUT BAR	1	1
3	10042182	调压外弹簧	SPRING	1	1
4	10042183	压紧杆导架	PRESSER BAR CLAMP	1	1
5	10042184	压紧杆导架螺钉	SCREW	1	1
6	10042185	抬牙脚吊杆	LINK	1	1
7	10042186	螺钉	SCREW	2	2
8	10042187	压杆导架座	GUIDE ASSEMBLY	1	1
9	10042188	螺钉	SCREW	2	2
10	10042189	调压内弹簧	SPRING	1	1
11	10011457	压紧杆防油罩	OIL GUARD	3	3
12	10042213	压紧杆油封	OIL SEAL	1	1
13	10042192	压紧杆	RESSER BAR	1	1
14	10042193	压紧防护罩	FINGER GUARD	1	1
15	10042194	压紧防护罩螺钉	SCREW	1	1
16					
17	*	压脚组件	PRESSER FOOT ASSEMBLY	1	1
18	10042196	螺钉	SCREW	1	1
19	10042215	抬牙脚轴组件	LEVER	1	1
20	10042197	抬牙脚弹簧	SPRING	1	1
21	10042198	抬牙脚轴紧圈	COLLAR	1	1
22	10042513	螺钉	SCREW	3	3
23	10042199	限位紧圈	COLLAR	1	1
24	10042200	抬牙脚调节曲柄	BELL CRANG (UPPER)	1	1
25	10042201	螺钉	SCREW	1	1
26	10042202	抬牙脚吊板	LINK	1	1
27	10042203	螺钉	SCREW	2	2
28	10042204	吊杆曲柄	BELL CRANG (LOWER)	1	1
29	10042205	吊杆曲柄螺钉	SCREW	1	1
30	10042206	拉杆座	SHAFT	1	1
31	10042207	抬牙脚拉杆	LEVER	1	1
32	10042208	螺钉	SCREW	1	1
33	10042209	右限位板	BRACKET	1	1
34	10011264	螺钉	SCREW	2	2
35	10042210	螺钉	SCREW	1	1
36	10042540	螺母	NUT	1	1
37	10042211	压紧杆套	BUSHING	1	1

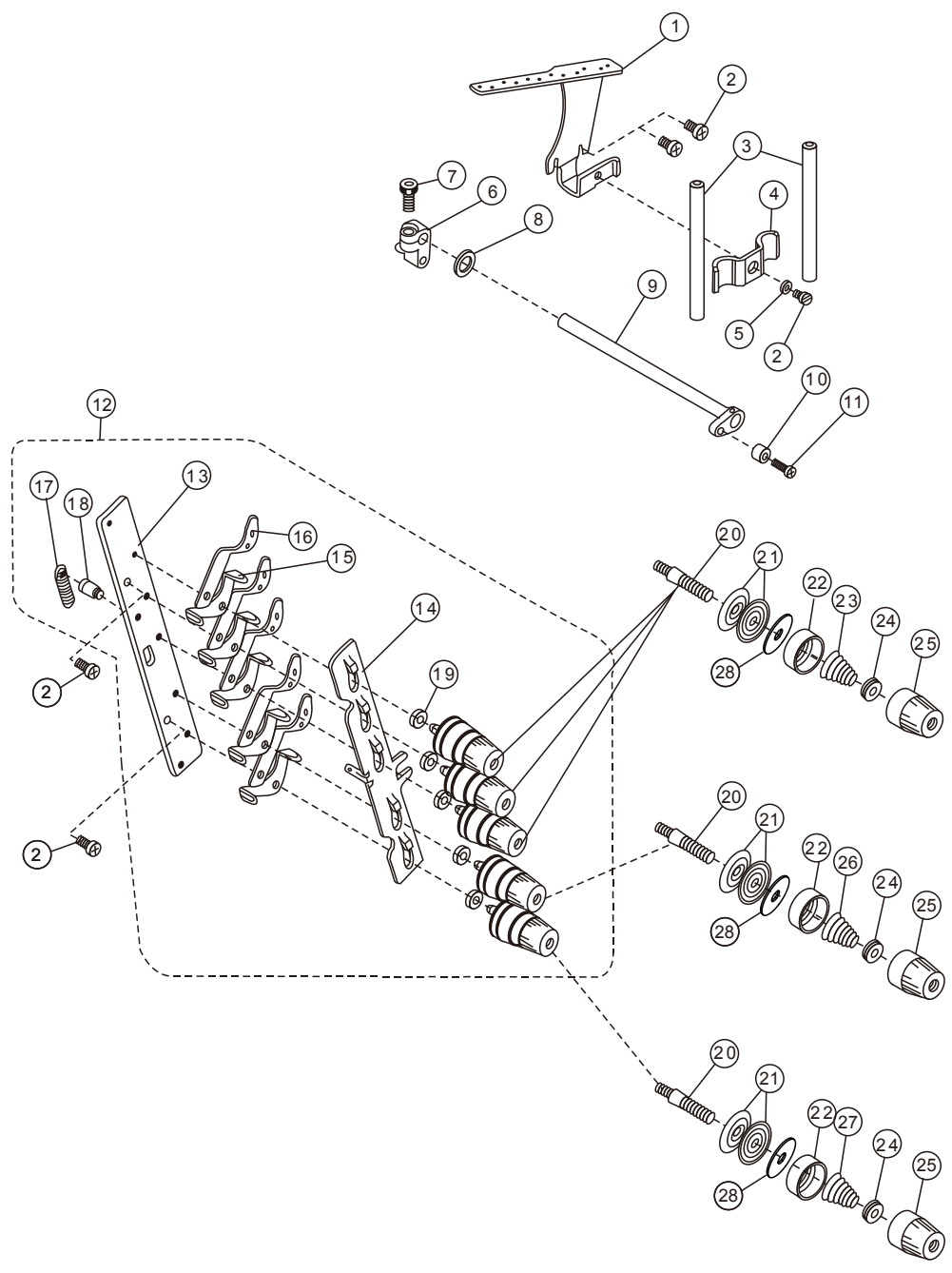
2.12 绷针结构 SPREADER MECHANISM



2.12 绷针机构 SPREADER MECHANISM

序号 PEF NO	件号 PART NO	名称	DESCRIPTION	数量 QTY	
				562A	562A-BD
1	10043140	绷针	SPREADER	1	1
2	10042218	绷针下摆杆	LEVER ASSEMBLY	1	1
3	10042412	螺钉	SCREW	1	1
4	10042219	绷针下摆杆紧定螺钉	SCREW	1	1
5	10042220	绷针曲柄	CRANK SHAFT	1	1
6	10042221	绷针紧圈	COLLER	1	1
7	10042406	螺钉	SCREW	2	2
8	10008090	油线	OIL WICK	1	1
9	10042223	油线	FELT	2	2
10	10042224	绷针竖轴 O 型圈	O RING	1	1
11	10042225	绷针上摆杆	CRANK	1	1
12	10042438	螺钉	SCREW	2	2
13	10042226	绷针连接柱	BLOCK	1	1
14	10042227	绷针横轴	SHAFT	1	1
15	10042228	绷针横轴垫圈	WASHER	1	1
16	10042229	开口挡圈	RING	1	1
17	10042230	绷针凸轮	ECCENTRIC ASSEMBLY	1	1
18	10042418	螺钉	SCREW	2	2
19	10042231	绷针连杆	CONNECTION	1	1
20	10042232	绷针调节摆杆	CRANK	1	1
21	10042434	绷针调节摆杆螺钉	SCREW	1	1
22	10042233	绷针调节螺钉	SCREW	1	1
23	10042234	绷针调节螺钉垫圈	WASHER	1	1
24	10042540	螺母	NUT	1	1
25	10042235	绷针竖套	BUSHING	1	1
26	10042237	绷针竖套油封垫圈	WASHER	1	1
27	10009399	绷针竖套油封	OIL SEAL	1	1
28	10042236	绷针横轴轴套	BUSHING	2	2

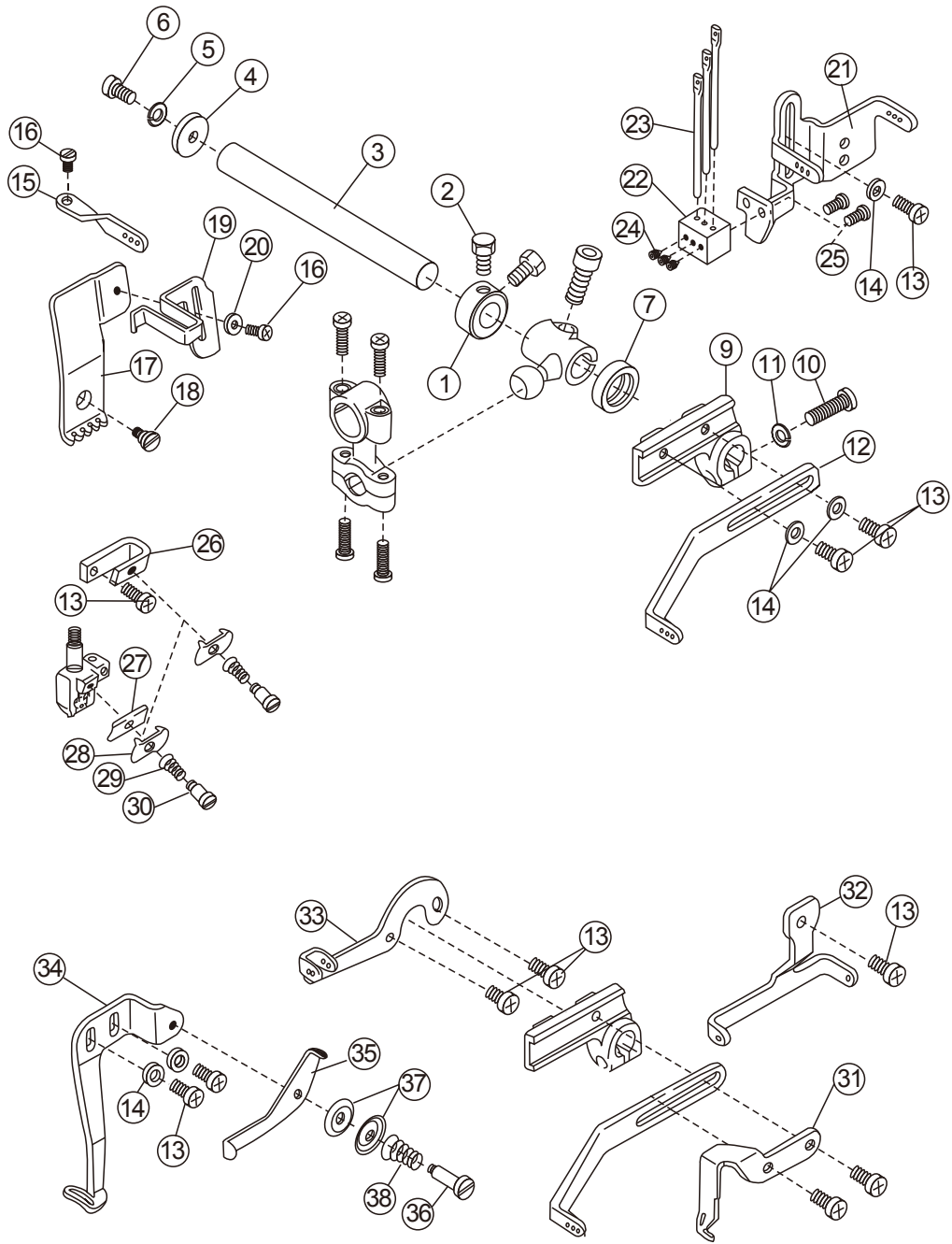
2.13 挺线及夹线机构 THREAD TENSION MECHANISM



2.13 挺线及夹线机构 THREAD TENSION MECHANISM

序号 PEF NO	件 号 PART NO	名 称 DESCRIPTION	数量 QTY	
			562A	562A-BD
1	10042243	过线架	1	1
2	10011264	过线架螺钉	5	5
3	10042244	过线管	2	2
4	10042245	过线管压板	1	1
5	10003083	垫圈	1	1
6	10042241	松线曲柄	1	1
7	10042160	松线曲柄 螺钉	1	1
8	10042242	垫圈	1	1
9	10042238	挺线轴	1	1
10	10042239	隔套	1	1
11	10042240	隔套螺钉	1	1
12	10042247	五线过线板组件	1	1
13	10042248	挺线板	1	1
14	10042249	过线座	1	1
15	10042252	压线过线板 2	5	5
16	10042253	夹线过线板 1	5	5
17	10042250	挺线扳拉簧	1	1
18	10042251	挺线板螺钉	1	1
19	10042254	垫圈	5	5
20	10042255	夹线螺钉	5	5
21	10042256	夹线板	10	10
22	10042257	夹线座	5	5
23	10042258	强夹线簧	3	3
24	10042261	夹线防松圈	5	5
25	10042262	夹线螺母	5	5
26	10042259	弱夹线簧	1	1
27	10042260	中夹线簧	1	1
28	10051990	夹线板垫	5	5

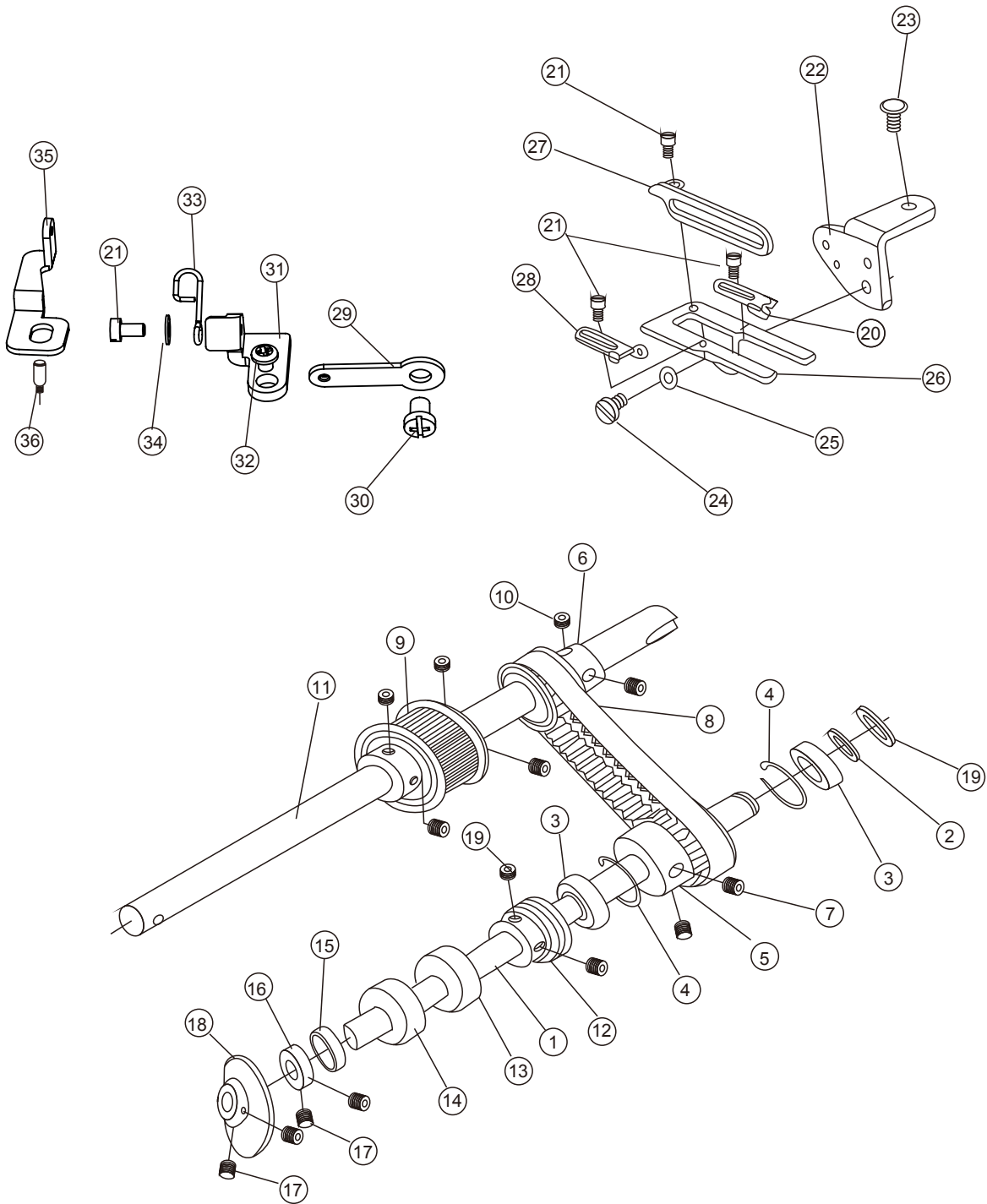
2.14 挑线机构 NEEDLE & SPREADER THREAD MECHANISM



2.14 挑线机构 NEED& SPREADER THREAD MECHANISM

序号 PEFNO	件 号 PARTNO	名 称	DESCRIPTION	数量QTY	
				562A	562A-BD
1	10042263	挑线杆轴紧圈	COLLAR	1	1
2	10042264	挑线杆轴紧圈螺钉	SCREW	2	2
3	10042265	挑线杆轴	SHAFT	1	1
4	10042266	垫圈	WASHER	1	1
5	10042267	止退圈	WASHER	1	1
6	10042268	止退圈紧固螺钉	SCREW	1	1
7	10009399	密封圈	OIL SEAL	1	1
9	10042269	挑线杆座	LEVER	1	1
10	10042478	挑线杆座夹紧螺钉	SCREW	1	1
11	10009429	止推垫圈	WASHER	1	1
12	10042270	挑线杆	THREADTAKE-UP	1	1
13	10011264	螺钉	SCREW	9	9
14	10003083	垫圈	WASHER	5	5
15	10042271	针杆上过线勾	THREADGUIDE	1	1
16	10042406	螺钉	SCREW	1	1
17	10042272	过线防护罩座	THREADGUIDE	1	1
18	10042273	过线防护罩座螺钉	SCREW	1	1
19	10042604	挑线防护罩	THREADSUPPORT	1	1
20	10042195	垫圈	WASHER	1	1
21	10042275	硅油过线座	THREADGUIDE	1	1
22	10042276	过线钉座	HOLDER	1	1
23	10042277	过线钉	THREADGUIDE	3	3
24	10042500	过线钉座紧定螺钉	SCREW	3	3
25	10042194	过线钉座固定螺钉	SCREW	2	2
26	10042278	小过线座	THREADTENSIONBRACKET	1	1
27	10042279	针扎过线板	THREADGUIDE	1	1
28	10042280	针扎过线压板	THREADRETAINER	1	1
29	10042281	针扎过线簧	SCREW	1	1
30	10042282	针扎过线螺钉	SCREW	1	1
31	10042283	上叉挑线杆	THREADTAKE-UP	1	1
32	10042284	底线过线座	THREADGUIDE	1	1
33	10042285	张线杆	THREADGUIDE	1	1
34	10042286	绷线过线下过线板	THREADGUIDE	1	1
35	10042287	绷线过线板	THREADGUIDE	1	1
36	10042288	夹紧螺钉	SCREW	1	1
37	10042289	过线压板	THREADRETAINER	2	2
38	10042290	压线簧	SPRING	1	1

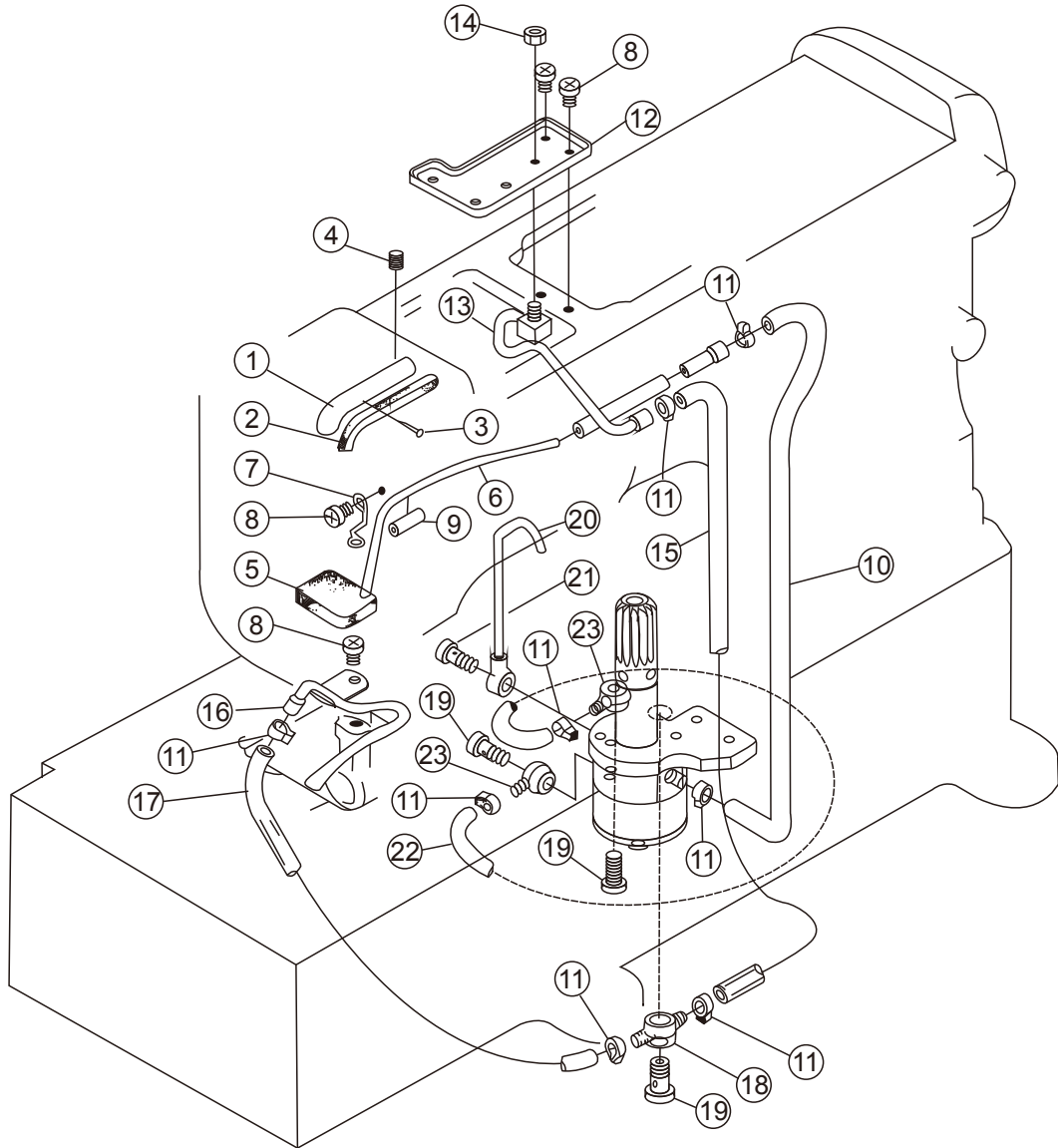
2.15 打线凸轮机构 LOOPER THREAD MECHANISM



2.15 打线凸轮机构 LOOPER THREAD MECHANISM

序号 PEF NO	件号 PART NO	名称	DESCRIPTION	数量 QTY	
				562A	562A-BD
1	10042931	打线凸轮轴	SHAFT	1	1
2	10003334	挡圈	RING	1	1
3	10042938	轴承	BRACKET	2	2
4	10027925	挡圈	RING	2	2
5	10042907	打线从动同步带轮	SMALL GEAR 1	1	1
6	10042909	打线主动同步带轮	SMALL GEAR 2	1	1
7	10042429	螺钉	SCREW	2	2
8	10042912	同步带	TIMING BELT	1	1
9	10042910	主动同步带轮	GEAR	1	1
10	10042429	螺钉	SCREW	2	2
11	10043209	下轴后节	SHAFT	1	1
12	10042911	打线凸轮右衬套	GEAR SLEEVE (RIGHT)	1	1
13	10011204	油封	OIL SEAL	1	1
14	10042937	轴承	BRACKET	1	1
15	10042228	垫圈	WASHER	1	1
16	10042916	挡圈	RING	1	1
17	10042418	螺钉	SCREW	6	6
18	10042917	打线凸轮	THREAD TAKE-UP	1	1
19	10042922	骨架油封	PLUG	1	1
20	10042927	右穿线板	THREAD GUIDE (RIGHT)	1	1
21	10042406	螺钉	SCREW	4	4
22	10042924	过线板座	BRACKET	1	1
23	10042382	螺钉	SCREW	1	1
24	10042921	轴位螺钉	SCREW	1	1
25	10042913	波形垫圈	WASHER	1	1
26	10042928	过线板	BRACKET	1	1
27	10042929	过线压板	THREAD GUIDE (CENTER)	1	1
28	10042925	左穿线板	THREAD GUIDE (LEFT)	1	1
29	10042293	小过线板	BRACKET	1	1
30	10042377	螺钉	SCREW	1	1
31	10042926	弹簧钩座	SPRING HOOK SEAT	1	1
32	10042394	螺钉	SCREW	1	1
33	10042953	弹簧钩	SPRING HOOKS	1	1
34	10042407	垫圈	WASHER	1	1
35	10042294	过线板	BRACKET	1	1
36	10042400	底线过线柱	SCREW	1	1

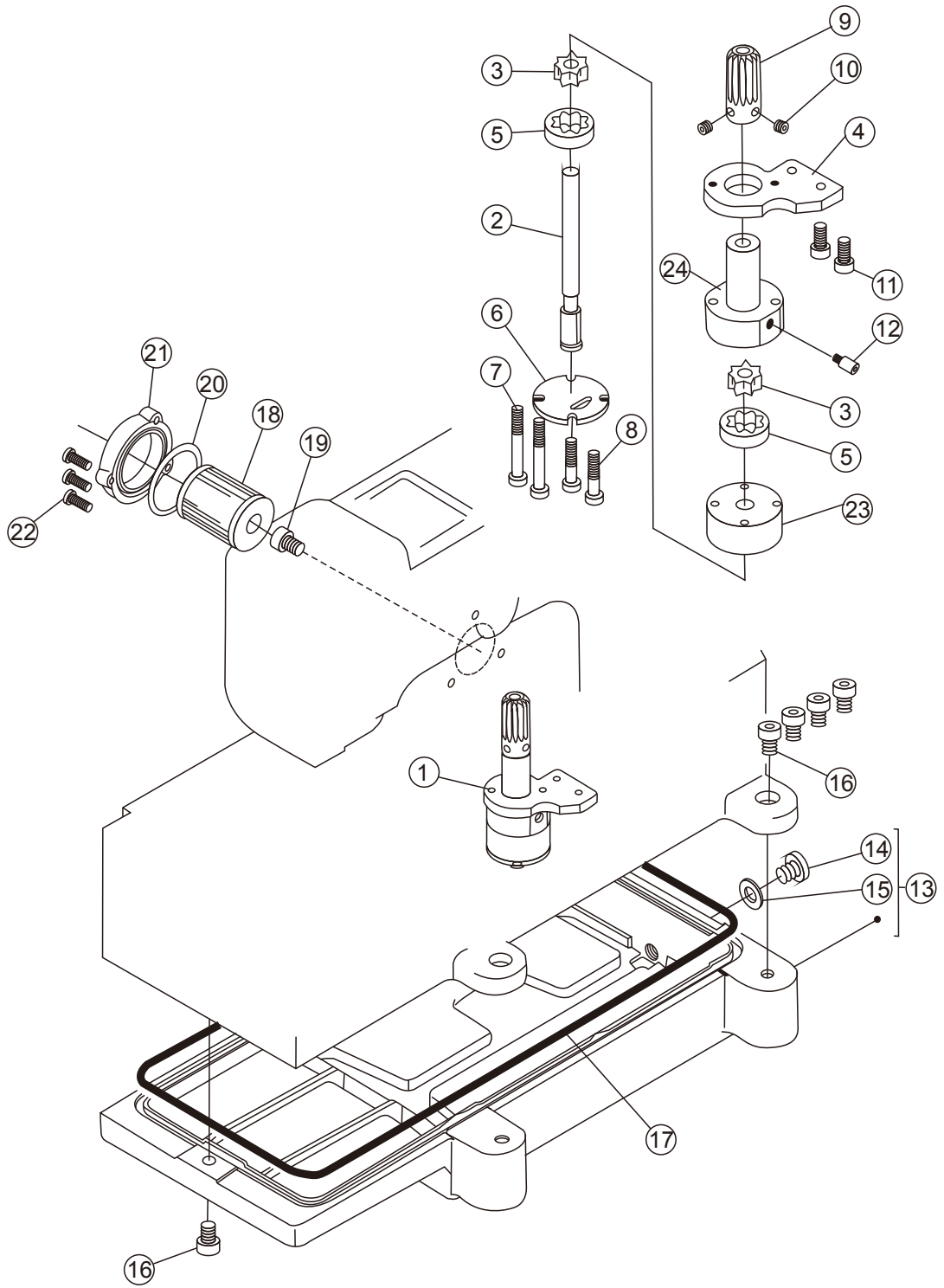
2.16 润滑机构 (A) LUBRICATION MECHANISM (A)



2.16 润滑机构(A) LUBRICATION MECHANISM(A)

序号 PEF NO	件号 PART NO	名称	DESCRIPTION	数量 QTY	
				562A	562A-BD
1	10042316	针杆曲柄过油管	OIL PIPE	1	1
2	10042317	针杆曲柄供油毡	FELT	1	1
3	10042318	油线钉	PIN	1	1
4	10042418	螺钉	SCREW	1	1
5	10051751	回油毡	FELT	1	1
6	10052322	回油铜管	PIPE	1	1
7	10052252	毛毡定位勾	LATCH	1	1
8	10010837	螺钉	SCREW	4	4
9	10007796	回油皮管	PIPE	1	1
10	10007796	回油皮管	PIPE	1	1
11	10011471	进油短油管夹	CLAMP	6	6
12	10042323	上油盘	OIL GUARD	1	1
13	10042324	上轴供油管	OIL DISTRIBUTOR	1	1
14	10042544	螺母	NUT	1	1
15	10007796	回油皮管	PIPE	1	1
16	10042326	下油管组件	OIL DISTRIBUTOR	1	1
17	10007796	回油皮管	PIPE	1	1
18	10012095	双通管接头	JOINT	1	1
19	10042329	螺钉双通油接头	JOINT SCREW	3	3
20	10042330	涡轮供油管组件	PIPE	1	1
21	10042331	螺钉小双通油接头	JOINT SCREW	1	1
22	10007796	回油皮管	PIPE	1	1
23	10012103	单通油管接头	JOINT	1	1

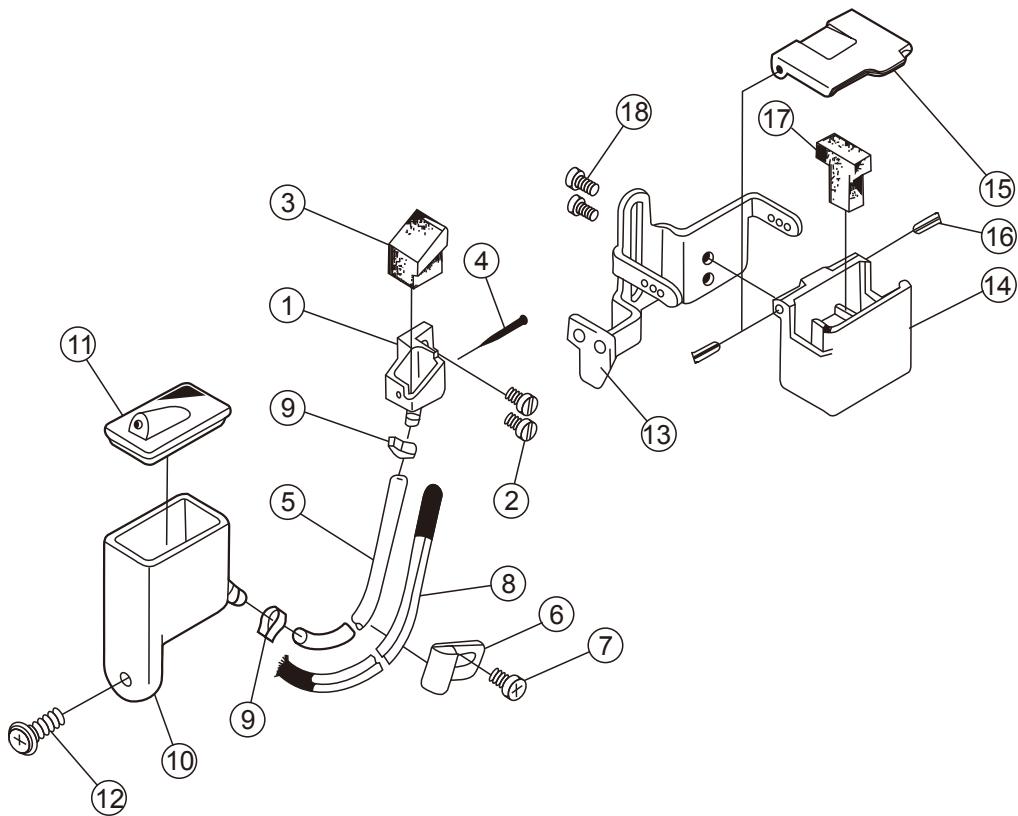
2.17 润滑机构 (B) LUBRICATION MECHANISM (B)



2.17 润滑机构(B) LUBRICATION MECHANISM(B)

序号 PEF NO	件号 PART NO	名称	DESCRIPTION	数量 QTY	
				562A	562A-BD
1	10042144	油泵组件	OIL PUMP ASSEMBLY	1	1
2	10042146	油泵轴	SHAFT	1	1
3	10042147	齿轮	ROTOR	2	2
4	10042145	固定板	SETTING BOARD	1	1
5	10042148	内齿轮	ROTOR	2	2
6	10042149	底板	COVER	1	1
7	10042150	长螺钉	SCREW	2	2
8	10042151	底板固定螺钉	SCREW	2	2
9	10042152	油泵涡轮	WORM WHEEL	1	1
10	10042418	螺钉	SCREW	2	2
11	10042160	固定板螺钉	SCREW	2	2
12	10042334	油泵回油管接头	JOINT SCREW	1	1
13	10042335	油盘	OIL RESERVOIR	1	1
14	10042336	油盘螺钉	SCREW	1	1
15	10042337	密封垫	WASHER	1	1
16	10042338	油盘下螺钉	SCREW	1	1
17	10042339	油盘防油垫	O RING	1	1
18	10043169	滤油器	FILTER ELEMENT	1	1
19	10042340	滤油器螺钉	SCREW	1	1
20	10042341	O型圈	O RING	1	1
21	10042342	滤油器盖	COVER	1	1
22	10042387	滤油器盖固定螺钉	SCREW	3	3
23	10042153	油泵壳体	OIL PUMP COVER	1	1
24	10042154	上油泵体	UPPER OIL PUMP	1	1

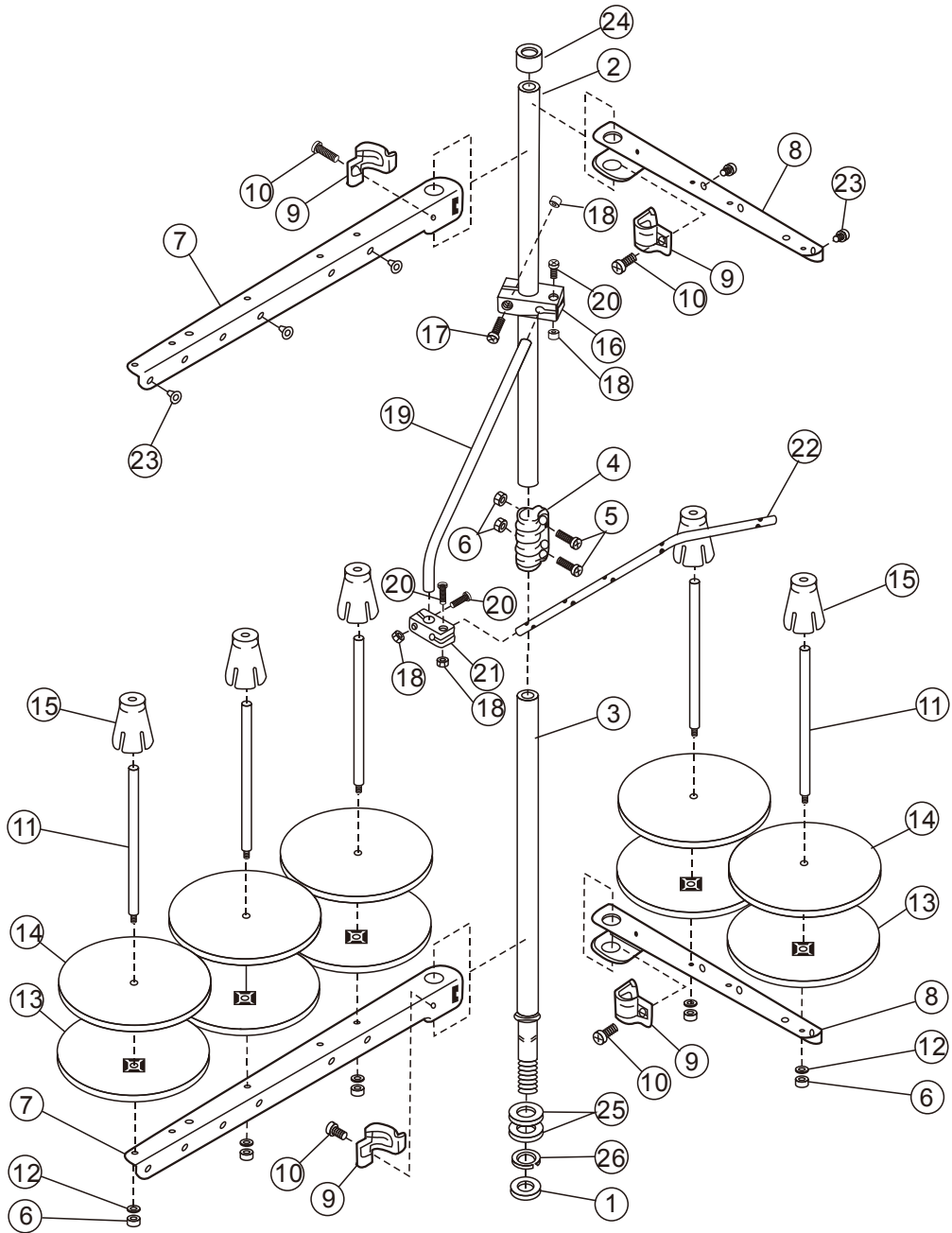
2.18 硅油盒机构 SILICON OIL RESERVOIR MECHANISM



2.18 硅油盒机构 SILICON OIL RESERVOIR MECHANISM

序号 PEF NO	件 号 PART NO	名 称	DESCRIPTION	数量 QTY	
				562A	562A-BD
1	10042343	硅油盒壳体	NEEDLE COOLER (LOWER)	1	1
2	10042194	螺钉	SCREW	2	2
3	10042344	硅油盒毛毡	FELT	1	1
4	10042318	大头针	PIN	1	1
5	10007796	油管	TUBE	1	1
6	10008228	油线压板	BRACKET	1	1
7	10042377	螺钉	SCREW	1	1
8	10008095	油线	OIL WICK	1	1
9	10011471	夹头	CLAMP	1	1
10	10042347	硅油驻盒	SILICON OIL RESERVIOR (LOWER)	1	1
11	10042348	硅油驻盒盖	CAP	1	1
12	10042387	螺钉	SCREW	1	1
13	10042275	硅油过线座	THREAD GUIDE	1	1
14	10042350	上硅油盒	SILICON OIL RESERVIOR (UPPER)	1	1
15	10042351	上硅油盒盖	CAP	1	1
16	10044981	销	FIN	1	1
17	10042349	上硅油毡	FELT	1	1
18	10010690	螺钉	SCREW	2	2

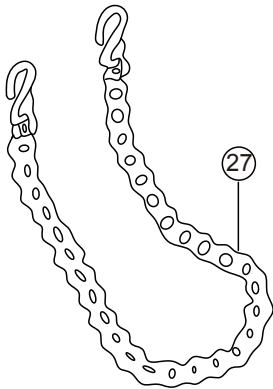
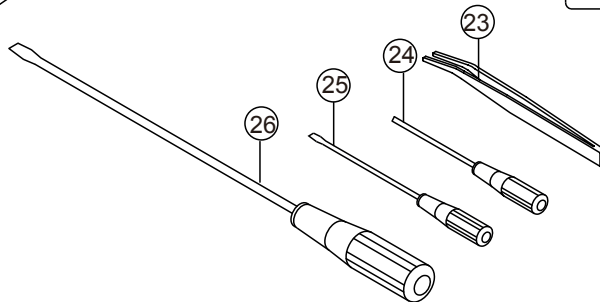
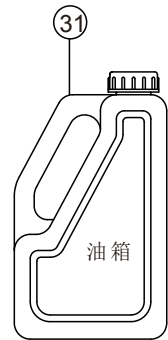
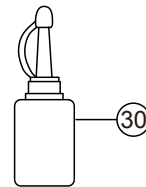
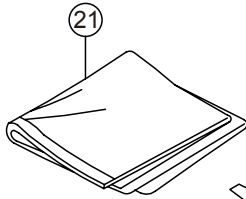
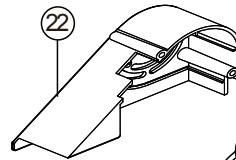
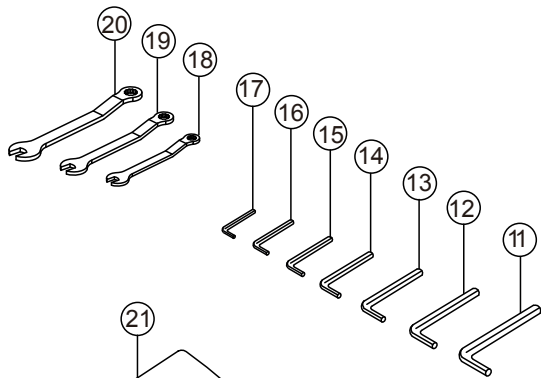
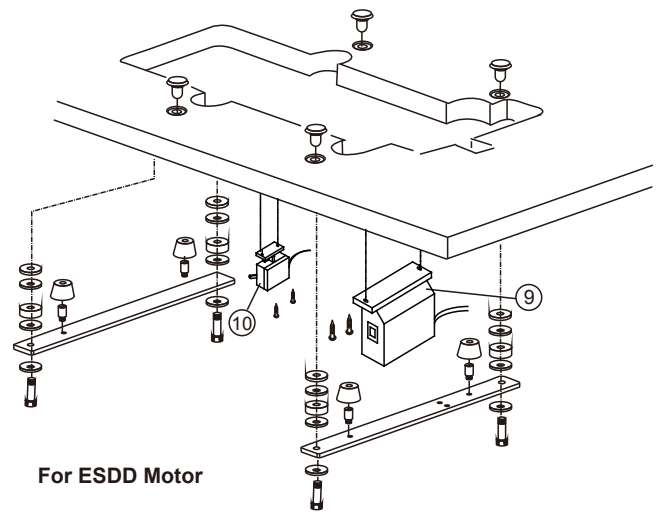
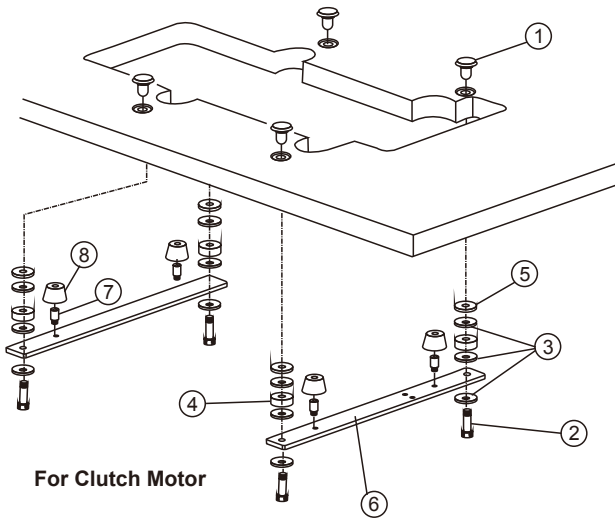
2.19 线架 THREAD STAND



2.19 线架 THREAD STAND

序号 PEF NO	件号 PART NO	名称	DESCRIPTION	数量 QTY	
				562A	562A-BD
1	10046021	螺母	NUT	1	1
2	10045996	上过线管	THREAD BAR(UPPER)	1	1
3	10045997	下过线管	THREAD BAR(LOWER)	1	1
4	10045998	过线夹	JOINT	1	1
5	10045999	螺钉	SCREW	2	2
6	10046000	螺母	NUT	7	7
7	10046001	上过线架	BRACKET	2	2
8	10046002	前过线架	BRACKET	2	2
9	10046003	夹子	HOLDER	4	4
10	10046004	螺钉	SCREW	4	4
11	10046005	线团固定柱	SPOOL PIN	5	5
12	10046006	弹簧垫圈	SPRING WASHER	5	5
13	10046007	线盘	SPOOL TRAY	5	5
14	10046008	线盘垫	SPOOL MAT	5	5
15	10046009	定心座	SPOOL PETAINING	5	5
16	10046010	中过线板夹紧块	BRACKET	1	1
17	10046011	螺钉	SCREW	1	1
18	10046012	螺母	NUT	4	4
19	10046013	中过线接杆	THREAD GUIDE BAR	1	1
20	10046014	螺钉	SCREW	3	3
21	10046015	中过线接头	BRACKET	1	1
22	10046016	中过线杆	THREAD GUIDE BAR	1	1
23	10046017	过线管	THREAD GUIDE	5	5
24	10046018	上立柱橡皮封	RID CAP	1	1
25	10046019	垫圈	WASHER	2	2
26	10046020	弹簧垫圈	SPRING WASHER	1	1

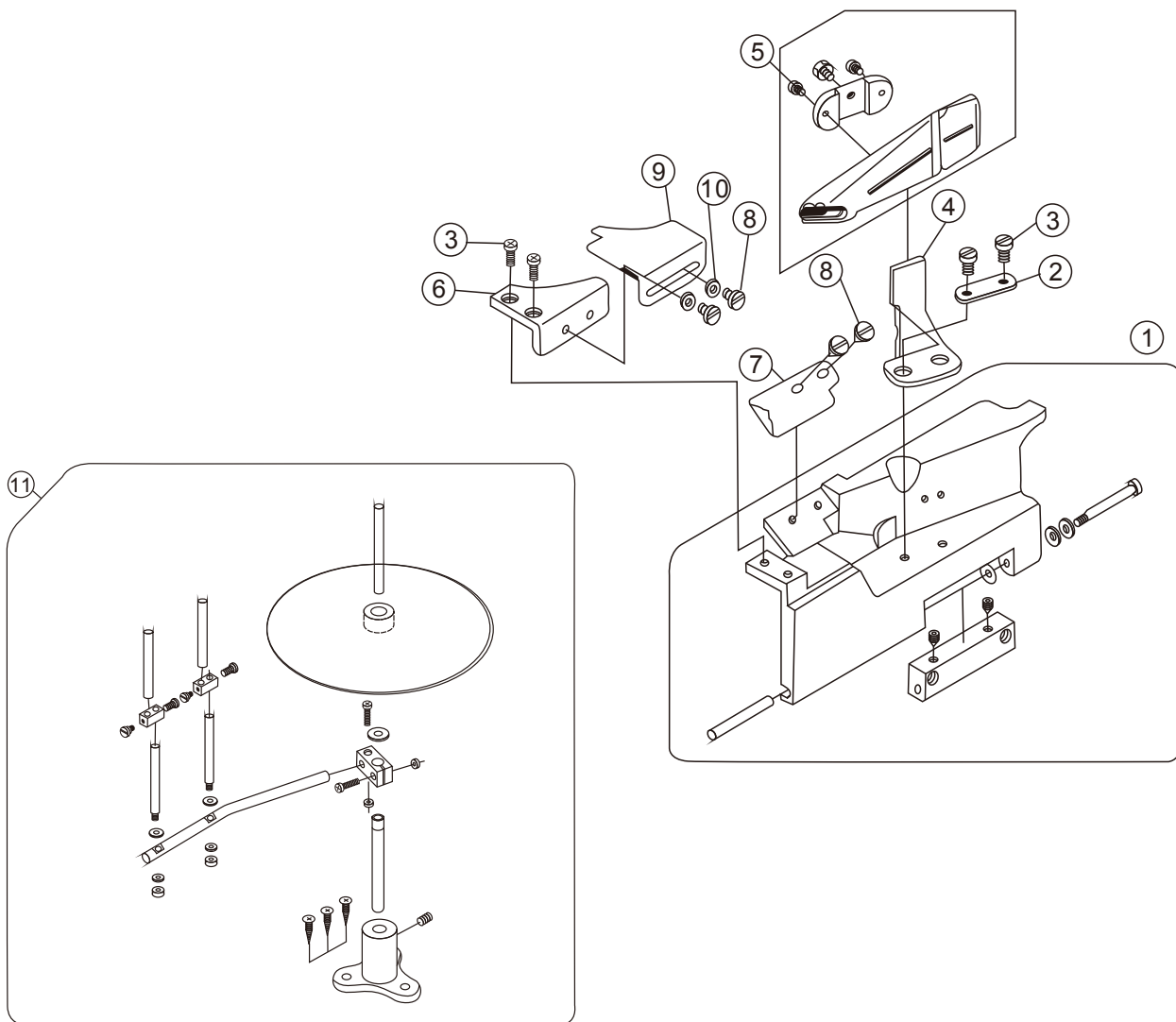
2.20 台板及附件 MACHINE SUPPORTING MECHANISM



2.20 台板及附件 MACHINE SUPPORTING MECHANISM

序号 PEF NO	件 号 PART NO	名 称	DESCRIPTION	数量 QTY	
				562A	562A-BD
1	10009596	台板螺钉	SCREW	4	4
2	10042354	长螺钉	BOLT	4	4
3	10042355	垫片	WASHER	12	12
4	10042356	大胶垫	SPACER	4	4
5	10042357	小胶垫	SPACER	4	4
6	10042358	承重板	REST BOARD	2	2
7	10042359	螺钉	SCREW	4	4
8	10042360	承重板胶垫	RUBBER CUSHION	4	4
9	10050653	绷缝三自动电控	ESDD CONTROL BOX ASSEMBLY	0	1
10	10042950	踏板控制器	SCREW	0	1
11	10009688	内六角扳手 6mm	ALLEN KEY 6mm	1	1
12	10009689	内六角扳手 5mm	ALLEN KEY 5mm	1	1
13	10009687	内六角扳手 4mm	ALLEN KEY 4mm	1	1
14	10043163	内六角扳手 3.5mm	ALLEN KEY 3.5mm	1	1
15	10009685	内六角扳手 3mm	ALLEN KEY 3mm	1	1
16	10009686	内六角扳手 2.5mm	ALLEN KEY 2.5mm	1	1
17	10009683	内六角扳手 2m	ALLEN KEY 2mm	1	1
18	10014185	扳手 6	WRENCH KEY (6)	1	1
19	10014122	扳手 7	WRENCH KEY (7)	1	1
20	10014186	扳手 8	WRENCH KEY (8)	1	1
21	10011311	机头罩☆	DUST COVER☆	1	1
22	10047361	皮带罩组件	BELT COVER ASSEMBLY	1	0
23	10004247	镊子组件	TWEEZERS	1	1
24	10009270	内六角开刀	SCREW DRIVER	1	1
25	10010995	中螺丝刀	SCREW DRIVER	1	1
26	10010994	大螺丝刀	SCREW DRIVER	1	1
27	20000813	踏板链条组件	CHAIN ASSEMBLY	1	1
28	10050369	UY128GAS 11#机针	NEEDLE #11	3	3
29	10045181	说明书☆	INSTRUCTION MANUAL☆	1	1
30	10011155	硅油瓶	OILER	1	1
31	10004455	油箱	IOL POUCH	1	1

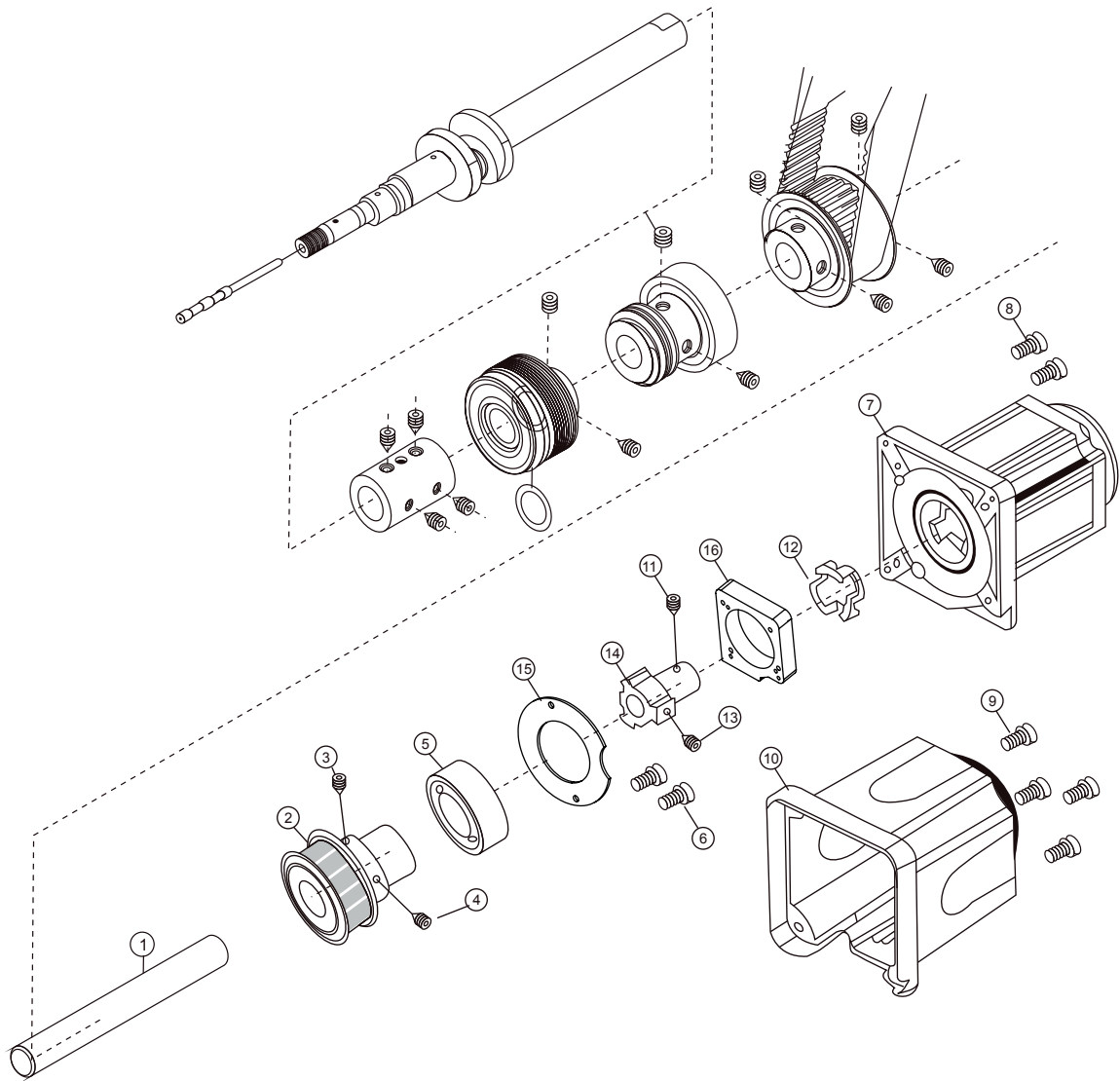
2.21 卷边专用件 FOLDER ASM



2.21 卷边专用件 FOLDER ASM

序号 PEF NO	件号 PART NO	名称	DESCRIPTION	数量 QTY	
				562A	562A-BD
1	10042955	穿线罩组件	FRONT COVER ASSEMBLY	1	1
2	10042863	卷便器支架垫片	WASHER	1	1
3	10042481	螺钉	SCREW	4	4
4	10042862	卷边器支架	BRACKET	1	1
5	10045989	卷边器组件	FOLDER ASSEMBLY	1	1
6	10042864	穿线罩板上板	FRONT COVER (SMALL)	1	1
7	10042867	挡料板	FABRIC GUARD	1	1
8	10042865	穿线罩板上板螺钉	SCREW	4	4
9	10042866	引布板	AUXILLARY PLATE	1	1
10	10042477	垫片	WASHER	2	2
11	10045990	托料盘组件	TAPE GUIDE ASSEMBLY	1	1

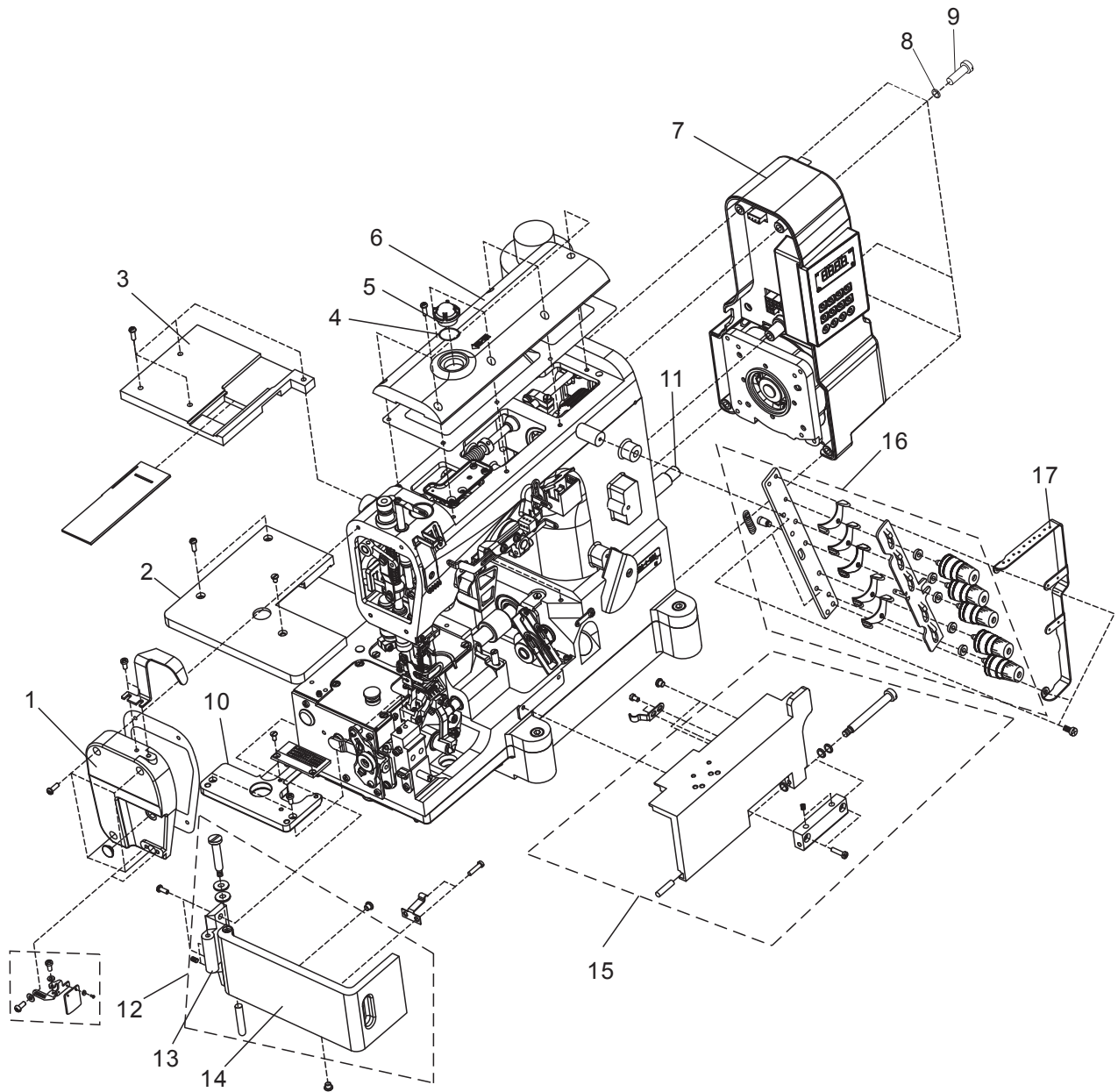
2.22 直驱电机结构 ESDD MOTOR COMPONENTS



2.22 直驱电机结构 ESDD MOTOR COMPONENTS

序号 PEF NO	件 号 PART NO	名 称	DESCRIPTION	数量 QTY	
				562A	562A-BD
1	10043209	下轴后节	SHAFT	0	1
2	10042909	打线主动同步带轮组件	GEAR	0	1
3	10042437	螺钉	SCREW	0	1
4	10042438	螺钉	SCREW	0	1
5	10042466	轴承	BEARING	0	1
6	10042440	螺钉	SCREW	0	2
7	10050544	直驱马达	DIRECT DRIVE MOTOR ASSEMBLY	0	1
8	10044437	螺钉	SCREW	0	4
9	10042387	螺钉	SCREW	0	4
10	10044438	电机罩	MOTOR COVER	0	1
11	10042437	联轴器定位螺钉	SCREW	0	1
12	10050577	电机联轴器	MOTOR COUPLING	0	1
13	10042437	螺钉	SCREW	0	1
14	10050659	联轴器组件	COUPLING	0	1
15	10042439	压紧圈	CLAMPING RING	0	1
16	10050545	转接板	EXCHANGE BOARD	0	1

2.23 一体机专用件 Integrated Machine Specific Parts

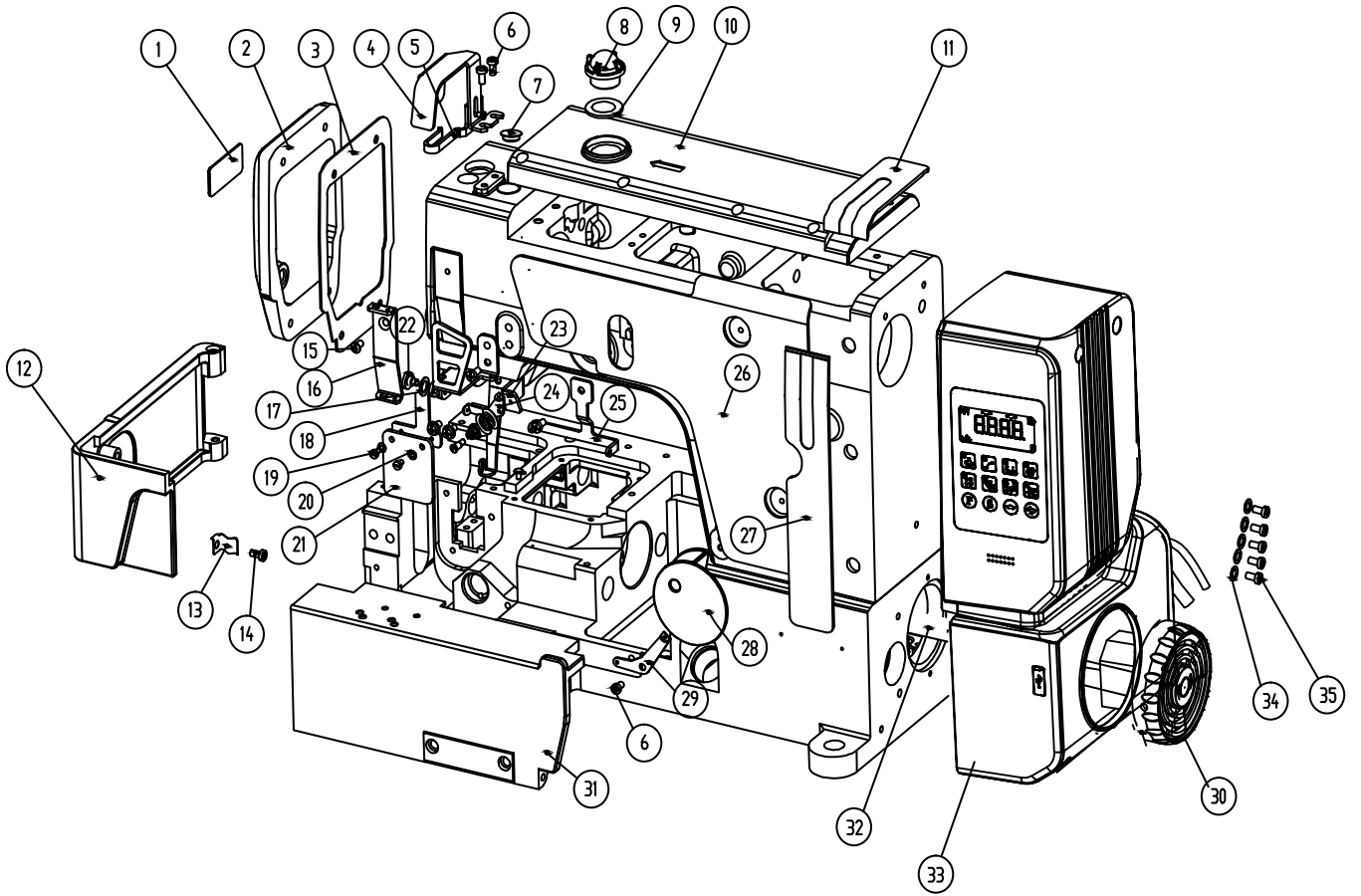


2.23. 一体机专用件

Integrated Machine Specific Parts

序号 No.	件号 Pars No.	名称	NAME OF PARTS	数量 Number
1	20019518	面板	FACE PLATE	1
2	20019537	缝台左罩	BED COVER (LEFT)	1
3	20019538	缝台右罩	BED COVER (RIGHT)	1
4	10009704	油窗垫	OIL WINDOW SPACER	1
5	10009757	油窗	OIL WINDOW	1
6	20019516	500、600上盖	UPPER COVER PLATE	1
7	10059115	绷缝500一体式电控	Integrated Machine DRIVE-BY-WIRE	1
8	10006115	垫圈	SPACER	5
9	10001497	螺钉	SET SCREW PAN (FT) MM5×35	5
10	10053781	针板接板	BRACKET	1
11	10054316	下轴后节	SHAFT	1
12	20019539	左侧罩组件	SUDE COVER ASSEMBLY	1
13	10053789	左侧板铰链板	LINK COVER	1
14	10053790	左罩板	COVER (LEFT)	1
15	20019536	穿线罩板组件	FRONT COVER ASSEMBLY	1
16	10054320	五线过线板组件	TENSION CONTROL MECHANISM	1
17	10054321	过线架	LINE FRAME	1

2.24 C5000专用件 C5000 SPECIFIC PARTS



2.24 C5000专用件

C5000 SPECIFIC PARTS

序号 PEF NO	件号 PART NO	名称	DESCRIPTION	数量QTY
1	10062054	面板装饰牌	DECK PLATE	1
2	20023635	面板C5	PANEL	1
3	10062322	面板密封垫	GASKET	1
4	10062279	针杆防护罩	SHIELD	1
5	10062280	针杆打线架	PIN RACK	1
6	10011264	螺钉	SCREW	3
7	10011099	橡胶塞	RUBBER PLUG	1
8	10008938	油窗	OIL WINDOW	1
9	10008939	O形圈	OIL RING	1
10	20023743	上盖板组件	UPPER COVER PLATE	1
11	10062290	装饰条上段	PLATE	1
12	20023642	左罩板组件C5	SUDE COVER ASSEMBLY	1
13	10062624	左侧罩限位簧	THE LIMIT REED	1
14	10010837	螺钉	SCREW	1
15	10042420	螺钉	SCREW	1
16	10062282	面线过线板	A LINE BOARD	1
17	10042913	波形垫圈	THE WAVE WASHER	1
18	10062284	护眼板支架	EYE GUARD	1
19	10042406	螺钉	SCREW	2
20	10042407	垫圈	WASHER	2
21	10042405	防护罩	SHIELD	1
22	10042410	螺钉	SCREW	1
23	10062285	装饰线下过线板	A LINE BOARD	1
24	10042287	绷线过线板	THREAD GUIDE	1
25	10062286	装饰线过线架	A LINE BOARD	1
26	10062289	装饰板	PLATE	1
27	10062291	装饰条下段	PLATE	1
28	10062292	底线过线防护罩	LOOPER THREAD GUIDE COVER	1
29	10059839	底线过线板	THEAD GUIDE	1
30	20023740	手轮C5	HAND WHEEL	1
31	20023643	穿线罩板组件C5	FRONT COVER	1
32	10062295	下轴后节	SHAFT	1
33	10062614	C5琦星电控	ELECTRIC CONTROL	1
34	10006115	垫圈	WASHER	5
35	10001497	螺钉	SCREW	5

QD9623系列绷缝500简易说明书2017.12版

△安全指示 NO. 10403176

在安装或使用本产品前，使用者必须详细阅读本操作手册。
本产品须由受过正确训练的人员来安装或操作。安装作业时必须关闭所有电源，切记不可带电操作。

- 3) 所有标有△符号的指示，必须特别注意并按照说明书上的执行，以免造成不必要的损害。
- 4) 为安全起见，禁止以延长线作电源供应二项以上的电器产品使用。
- 5) 在连接电源线时，必须确定工作电压低于 AC 250V，且符合本产品标识中规定的额定电压值。

※注意：电控箱电源规格如为 AC220V 时，请勿插接至 AC380V 的电源插座上，否则将出现异常且电机无法动作。此时请立即关闭电源开关，重新检查电源。持续供应 380V 超过五分钟以上，将可能烧损电控箱内器件，而危及人身安全。

- 6) 请不要在日光直接照射的场所、室外及室温 45℃ 以上或 0℃ 以下的场所操作。
- 7) 请不要在暖气（电热器）旁、有露水的场所及在相对湿度 10% 以下或 90% 以上的场所操作。
- 8) 请不要在灰尘多的场所、具有腐蚀性物质的场所及有挥发性气体的场所操作。
- 9) 请注意所有电源线、信号线、接地线等接线时不要受压或过度扭曲，以确保使用安全。
- 10) 电源线的接地端须以适当大小的导线和接头连接到生产工厂的系统地线，此连接必须被永久固定。
- 11) 所有可转动的部分，必须以所提供的零件加以防范露出。
- 12) 在安装完成第一次开机后，先关闭切线功能以低速操作缝缝机并检查转动方向是否正确、运转是否稳定。
- 13) 在进行以下操作前，请先关闭所有电源：
 1. 在控制箱与马达上插拔任何连接插头时。
 2. 穿针线时。
 3. 翻抬缝缝机机头时。
 4. 修理或做任何机械上的调整时。
 5. 机器闲置不用时。
- 14) 修理或高层次的保养工作，仅能由受过训练的机电技师来执行。
所有维修用的零件，须由本公司提供认可，方可使用。
- 15) 使用本产品请远离高频电磁波和电波发射器等，以免所产生的电磁波干扰伺服驱动装置而发生误动作。
- 16) 请不要以不当物体来敲击或撞击本产品及各装置。

保修期限

本产品保修期限为购买日期起一年内或出厂月份起两年内。

保修内容

本产品在正常使用且无人为操作失误的前提下，于保修期间无偿为客户维修使能正常操作。但以下情况于保修期间将收取维修费用：

1. 不当使用包括误接高压电源、将产品移做其它用途、自行拆卸、维修、更改、或不依规格范围使用、进水进油及插入异物于本产品。
2. 火灾、地震、闪电、风灾、水灾、盐蚀、潮湿、异常电压及其它天灾或不当场所所造成的损害。
3. 客户购买后摔落本产品，或客户自行运输（或托付运输公司）造成的损害。

* 本产品在生产及测试上皆尽最大努力和严格控制使其达到高品质及高稳定的标准，但外部的电磁或静电干扰或不稳定的供应电源，仍可能对本产品造成影响或损害，因此操作场所的接地系统一定要确实做好，并建议用户安装故障安全防护装置（如漏电保护器）。

1. 按键说明

功能参数编辑键		进入或退出功能参数的编辑。
参数查看保存键		对所选参数号内容进行查看和保存：选择好参数号后按此键可以进行查看和修改操作，修改参数值后按此键则退出并保存参数
上调键		1、参数选择区内参数项递增键 2、参数内容区内设定数值递增键
下调键		1、参数选择区内参数项递减键 2、参数内容区内设定数值递减键
慢速起缝选择键		在开机界面，短按此键为慢速起缝选择键；对应小数点亮起为打开，熄灭为关闭；

2. 操作说明

2.1 恢复出厂设置

1. 在关机状态下，同时按住上键和下键开机，再按 S 键确认即可恢复；

2.2 进入用户模式及修改保存

1. 一般模式下按 P 键进入【用户参数区】。
2. 按 S 键进入参数内容值；通过“上”、“下”键更改内容值，按 S 键保存。

2.3 进入技术员模式及修改保存

1. 在关机状态，按住 P 键开机进入【技术员参数区】。
2. 按 S 键进入参数内容值；通过“上”、“下”键更改内容值，按 S 键保存。

3. 用户参数表&技术员参数表

3.1 用户参数表

参数项	中文说明	范围	初始值	内容值名称说明与备注
P01	最高转速	200-6000	5000	车缝时的最高转速设定（显示的数*10=实际速度）
P02	停针位选择	0-2	0	停针位设定（0：上停针；1：下停针；2：无定位）
P03	慢速起缝开关	0-1	0	慢速起缝开关设定（0：关；1：开）
P04	慢速起缝速度	200-1500	400	慢速起缝时的速度设定（显示的数*10=实际速度）
P05	慢速起缝针数	1-15	1	慢速起缝时的针数设定，每一单位代表半针
P06	最低转速	200-500	200	车缝时的最低转速设定（显示的数*10=实际速度）

3.2 技术员参数表

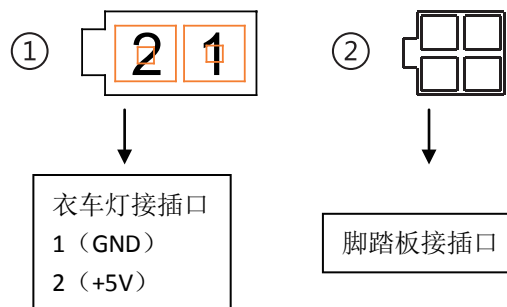
参数项	中文说明	范围	初始值	内容值名称说明与备注
P07	上定位调整	0-24	0	
P08	下定位调整	0-24	12	
P09	开机自动找上定位	0-1	1	0：开机不找上定位； 1：开机找上定位
P11	加速曲线调整（%）	1-100	32	控速器的加速爬升斜率设定
P15	补针方式	0-3	0	0：半针； 1：一针； 2：连续补半针； 3：连续补一针；
P16	机头灯亮度	0-4	4	0：熄灭； 1→4 亮度等级，数字越大亮度越大
P21	马达运转方向	0-1	0	马达运转方向设定（0：顺时针 1：逆时针）
P22	自动跑合速度	200-6000	3500	跑合速度的设置（显示的数*10=实际速度）
P23	自动跑合跑时间	1-250	20	测试中，设置跑时间
P24	自动跑合停时间	1-250	20	测试中，设置停时间
P25	A 项测试	0-1	0	A 项测试设定（速度持续运行）
P26	B 项测试	0-1	0	B 项测试设定（执行定位循环运行）
P29	吸气功能选择	0-2	1	0：关闭； 1：吸气功能； 2：半反踏气动抬压脚功能
P36	机型	1-10		

4. 错误代码表

错误码	内容	对策
E01	超电压	关闭系统电源，检测供应电源电压是否正确。（或是否超过使用规定的额定电压）。 若正确，请更换控制箱并通知售后服务。
E02	低电压	关闭系统电源，检测供应电源电压是否正确。（或是否低于使用规定的额定电压）。 若正确，请更换控制箱并通知售后服务。
E05	控速器接触异常	关闭系统电源，检查控速器接头是否松动或脱落，将其恢复正常后重启系统。若仍不能正常工作，请更换控速器并通知售后服务。

E07	电机堵转	转动机头手轮观察是否卡住。如卡住则先排除机械故障。 如转动正常，检查电机编码器接头和电机电源线接头是否松动。如有松动请修正。 如接触良好，检查供应电源电压是否异常或转速设置过高。如有请调整。 若仍不能正常工作，请更换控制箱并通知售后服务。
E09 E11	定位信号异常	关闭系统电源，检查电机编码器接口是否松动或脱落，将其恢复正常后重启系统。若仍不能正常工作，请更换电机并通知售后服务。
E14	编码器信号异常	关闭系统电源，检查电机编码器接口是否松动或脱落，将其恢复正常后重启系统。若仍不能正常工作，请更换电机并通知售后服务。
E15	电力模块不正常 过流保护	关闭系统电源，再重新开启。若仍不能正常工作，请更换控制箱并通知售后服务。
E17	机头保护开关没到正确位置	关闭系统电源，检查机头是否掀开，控制箱内滚珠开关是否移位或损坏。

5. 端口示意图 5.1 各个端口说明



⚠ Safety Instruction

- 1) Users are required to read the operation manual completely and carefully before installation or operation.
 - 2) The product should be installed and pre-operated by well trained persons
 - 3) All the instruction marked with sign ⚠, must be observed or executed; otherwise, bodily injuries might occur.
 - 4) For perfect operation and safety, it is prohibited that using extension cable with multi-outlet for power connection
 - 5) When connecting power supply cords to power sources, it is necessary to make sure that the power voltage is lower than 250V AC and matches the rated voltage indicated on the motor's name plate.
 ※Attention: If the Control Box is AC 220V system, please don't connect the Control Box to AC 380V power outlet. Otherwise, the error will occur and motor will not work. If that happens, please turn off the power immediately and check the power voltage. Continue supply 380V power over 5 minutes might damage the fuse F2, burst the electrolytic capacitors and the power module U14 of the main board and even might endanger the person safety.
 - 6) Please don't operate in direct sun light, outdoors area and where the room temperature is over 45°C or below 0°C.
 - 7) Please avoid operating near the heater at dew area or at the humidity below 10% or above 95%.
 - 8) Please don't operate in area with heavy dust, corrosive substance or volatile gas.
 - 9) Avoid power cord being applied by heavy objects or excessive force, or over bend.
 - 10) The earth wire of power cord must be connected to the system ground of the production plant by proper size of conduction and terminals. This connection should be fixed permanently.
 - 11) All the moving portions must be prevented to be exposed by the parts provided.
 - 12) Turning on the machine in the first time, operate the sewing machine at low speed and check the correct rotation direction.
 - 13) Turn off the power before the following operation:
 1. Connecting or disconnecting any connectors on the control box or motor.
 2. Threading needle.
 3. Raising the machine arm.
 4. Repairing or doing any mechanical adjustment.
 5. Machine is out of work.
 - 14) Repairing and high level maintenance work should only be done by electronic technicians with appropriate training.
 - 15) All the spare parts for repairing work must be provided or approved by the manufacturer.
 - 16) Don't use any objects to hit or ram the product.
- Guarantee Time
 Warranty period of this product is 1 year dated from purchasing, or within 2 years from ex-factory date.
- Warranty Detail
 Any trouble found within warranty period under normal operation, it will be repaired free of charge. However, maintenance cost will be charged in the following cases even if within warranty period:
1. Inappropriate use, including: wrong connecting high voltage, wrong application, disassemble, repair, modification by incompetent personnel, or operation without the precaution, or operation out of its specification range, or inserting other objects or liquids into the product.
 2. Damage by fire, Earth quake, lightning, wind, flood, salt corrosive, moisture, abnormal power voltage and any other damage cause by the natural disaster or by the inappropriate environments.
 3. Dropping after purchasing or damage in transportation by customer himself or by customer's shipping agency.
- * Note: We make our best effort to test and manufacture the product for assuring the quality. However, it is possible that this all a failsafe device. (Such as residual current breaker).

1. Keys Function

Entering the Parameter Mode		Press key P to enter into user parameter setting mode.
Setting Parameter Check and Save		After setting the function code, press this key to check the preset parameter and parameter accordingly; When the parameter is fixed, press key to save the setting and quit.
On the Adjustment Key		1. Choose the region parameter items of incrementing key 2. Parameter setting value incrementing key
Under the Adjustment Key		1. Choose the region parameter items of diminishing key 2. Parameter setting value decrementing key
Slow Play Seam Selection Shortcut		Slow play seam selection shortcuts.

2. Operating Instructions

2.1 Reset the System

1. Under the shutdown state, hold on the “up” key and “down” key to boot, then double-click the S key to confirm it, shutdown restart.

2.2 Enter the User Argument and Save Changes

1. Under normal mode, press key P enter to **【Use Parameter Area】**
2. Press S key enter to parameter content value; Changed the value through “up” “down” key

2.3 Enter Technician Mode and Save Changes

1. In the shutdown state, hold on key P to turn on machine and enter **【Technical Parameter Area】**
2. Press S key enter to parameter content value, changed the value through “up” “down” key, and then press S key to save the value.

3. User Parameter & Technician Parameter

3.1 User Parameter

Parameters	Parameter Function	Range	Default	Description
P01	Maximum Speed	200-6000	5000	Set the max sewing speed (show the actual number *10= speed).
P02	Needle Stop Position Selection	0-2	0	Set the needle stop position (0: Needle up 1: Needle down 2: OFF).
P03	Soft Start Switch	0-1	0	Soft start switch setting (0: OFF 1: ON).
P04	Soft Start Sewing Speed	200-1500	400	Soft start sewing speed setting (Show the actual number * 10= speed).
P05	Stitches Number of Soft Start	1-15	1	Set the stitches number of soft start, each unit is half stitch.
P06	Minimum Speed	200-500	200	Set the minimum speed (Show the actual number * 10= speed).

3.2 Technician Parameter

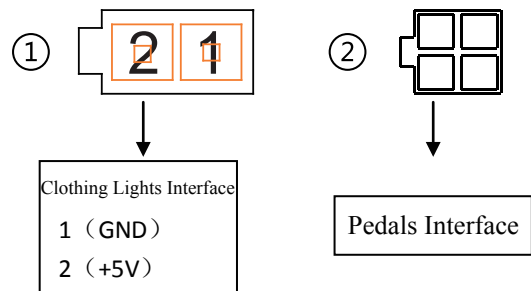
Parameters	Parameter Function	Range	Default	Description
P07	Up Position Adjustment	0-24	0	
P08	Down Position Adjustment	0-24	12	
P09	Needle Goes Up Automatically as Power Turned On	0-1	1	0: No Function 1: Power turned on, needle goes up position automatically
P11	Speed Curve Adjustment (%)	1-100	32	The larger the value, the faster to increase speed
P15	Stitch Correction Mode	0-3	0	0: Half stitch 1: One stitch 2: Continuous correct half stitch Continuous correct stitch and quickly stop machine
P16	Machine Head Lamp Brightness	0-4	4	0: OFF 1-4 the brightness grade, the more value the more brightness.
P21	Motor Rotate Direction	0-1	0	Motor rotate direction setting (0: clockwise 1: counter-clockwise)
P22	Auto Running Speed	200-6000	3500	Auto running speed setting (show the actual number * 10= speed)
P23	Auto Running Time	1-250	20	Set the auto running time in testing
P24	Auto Running Stop Time	1-250	20	Set the auto running stop time in testing
P25	Item A Test	0-1	0	Item A test setting (continue running with constant speed)
P26	Item B Test	0-1	0	Item B test setting (carry out the set loop running)
P29	Inhale Feature Selection	0-2	1	0: OFF; 1: Inhale feature; 2: Foot Lifting when half-heeling the pedal
P36	Type	1-10		

4. Error Code List

Error Code	Problem description	Measure
E01	Over-voltage	Turn off the machine, check the power supply voltage.(Or whether exceed the rated voltage of use). If there are still errors, please replace the control box and call for customer service..
E02	Low-voltage	Turn off the machine, check the power supply voltage.(Or whether under the rated voltage of use). If there are still errors, please replace the control box and call for customer service.
E05	Pedal connection error	Turn off the machine, please check if the pedal in bad connection or is too loose. To get it right and turn on. If there are still errors, please replace the control box and call for customer service.

5. Schematic Diagram of Port

5.1 Each Port Name



▲ Safety Instruction

- Users are required to read the operation manual completely and carefully before installation or operation.
 - The product should be installed and pre-operated by well trained persons
 - All the instruction marked with sign ▲, must be observed or executed; otherwise, bodily injuries might occur.
 - For perfect operation and safety, it is prohibited that using extension cable with multi-outlet for power connection
 - When connecting power supply cords to power sources, it is necessary to make sure that the power voltage is lower than 250V AC and matches the rated voltage indicated on the motor's name plate.
 ※Attention: If the Control Box is AC 220V system, please don't connect the Control Box to AC 380V power outlet. Otherwise, the error will occur and motor will not work. If that happens, please turn off the power immediately and check the power voltage. Continue supply 380V power over 5 minutes might damage the fuse F2, burst the electrolytic capacitors and the power module U14 of the main board and even might endanger the person safety.
 - Please don't operate in direct sun light, outdoors area and where the room temperature is over 45°C or below 0°C.
 - Please avoid operating near the heater at dew area or at the humidity below 10% or above 95%.
 - Please don't operate in area with heavy dust, corrosive substance or volatile gas.
 - Avoid power cord being applied by heavy objects or excessive force, or over bend.
 - The earth wire of power cord must be connected to the system ground of the production plant by proper size of conduction and terminals. This connection should be fixed permanently.
 - All the moving portions must be prevented to be exposed by the parts provided.
 - Tuning on the machine in the first time, operate the sewing machine at low speed and check the correct rotation direction.
 - Turn off the power before the following operation:
 - Connecting or disconnecting any connectors on the control box or motor.
 - Threading needle.
 - Raising the machine arm.
 - Repairing or doing any mechanical adjustment.
 - Machine is out of work.
 - Repairing and high level maintenance work should only be done by electronic technicians with appropriate training.
 - All the spare parts for repairing work must be provided or approved by the manufacturer.
 - Don't use any objects to hit or ram the product.
- Guarantee Time
 Warranty period of this product is 1 year dated from purchasing, or within 2 years from ex-factory date.
- Warranty Detail
 Any trouble found within warranty period under normal operation, it will be repaired free of charge. However, maintenance cost will be charged in the following cases even if within warranty period:
- Inappropriate use, including: wrong connecting high voltage, wrong application, disassemble, repair, modification by incompetent personnel, or operation without the precaution, or operation out of its specification range, or inserting other objects or liquids into the product.
 - Damage by fire, Earth quake, lightning, wind, flood, salt corrosive, moisture, abnormal power voltage and any other damage caused by the natural disaster or by the inappropriate environments.
 - Dropping after purchasing or damage in transportation by customer himself or by customer's shipping agency.
- * Note: We make our best effort to test and manufacture the product for assuring the quality. However, it is possible that this all a failsafe device. (Such as residual current breaker).

1. Button Display and Operating Instructions

Name	Key	Indicate
Function Parameter Edit		Press this key to enter or exit function parameter edit mode.
Setting Parameter Check And Save		For the content of the selected parameters check and save; after select parameter press this key to check and modify operation, after modified parameter value press this key to exit and save the parameter.
Parameter Increase/ Speed Increase		Increase the parameter/ Increase the sewing speed
Parameter Decrease/ Speed Decrease		Decrease the parameter/ Decrease the sewing speed
LED brightness adjustment		Press this key to adjust LED brightness.
Slow Launch Setting		Set used or cancelled slow launch function.
Automatic Presser Foot Lifting Setting		Click to shift auto presser foot lift OFF, intermediate stop presser foot lift, presser foot lift after trimming, presser foot lift after intermediate stop and trimming
Auto-suction		Set used or cancelled auto-suction function.
Needle Stop Position Selection		Set needle stop position.
Wiper Key		Set used or cancelled wiper function.
Upper knife trimming		Set used or cancelled upper knife trimming function.
Lower knife trimming		Set used or cancelled lower knife trimming function.

2 User Parameter

No.	Items	Range	Default	Description
P01	Maximum Sewing Speed (rpm)	100-6000	4500	Maximum speed of machine sewing
P02	Set accelerated curve (%)	10-100	80	Set the acceleration slope
P03	Needle UP/ DOWN	UP/DN	DN	UP: Needle Stops at Up Position DN: Needle Stops at Down Position
P07	Soft Start Speed (rpm)	200-1500	1000	
P08	Stitch Numbers for Soft Start	1-99	2	
P14	Slow start function selection	ON/OFF	OFF	
P15	Mending stitch mode	0-4	3	
P21	The position of the pedal for running	30-1000	500	
P22	The position of the pedal for the stop	30-1000	420	
P23	The position of the pedal for lifting presser foot	30-1000	280	
P24	The position of the pedal for thread trimming	30-500	130	
P29	The rate of thread trimming stop	1-45	20	
P36	Thread wiping switch selection	ON/OFF	OFF	
P37	Upper knife trimming output function setting	ON/OFF	ON	
P38	Lower knife trimming output function setting	ON/OFF	ON	
P39	Automatic presser foot lifting when pause function selection	UP/DN	DN	UP: ON DN: OFF
P40	Automatic presser foot lifting after trimming function selection	UP/DN	DN	UP: ON DN: OFF
P41	Counter display	0-9999		Display the quantity of finished sewing piece
P42	Information Display			N01 The control system version number N02 The panel version number N03 Speed N04 The pedal AD N05 The mechanical angle(up position) N06 The mechanical angle(down position) N07 Bushbar voltage AD
P43	Direction of Motor Rotation	CCW/CW	CCW	CW: Clockwise CCW: Counter Clockwise
P44	The rate of normal stop	1-45	25	
P46	Motor stop with a reverse angle after trimming function	ON/OFF	OFF	

P47	Adjust the reverse angle when motor stop after trimming	50-200	160	
P48	The minimum speed Limit (rpm)	100-500	200	Adjust the minimum speed.
P50	Foot lifter operation time to full output (ms)	10-990	150	
P51	Presser foot lifter operation duty cycle (%)	1-50	30	Presser foot lifter operate in duty cycle to save electricity and protect the electromagnet from over-heat.
P52	Motor starting delay time (ms)	10-990	150	Delay the start time, with automatic presser foot down.
P53	Lifting presser foot function selection	0-2	1	0: OFF 1: ON 2: Half back pedaling without function, back pedaling with function
P54	Lower knife trimming action time (ms)	10-990	100	Lower knife trimming sequence time
P55	Upper knife trimming action time (ms)	10-990	45	Upper knife trimming sequence time
P56	Power on and positioning	0-2	0	0: always not to find the up needle position 1: always to find the up needle position 2: If the motor is not into the up needle position, it will find the up needle position
P57	Hold time of presser foot lifter (s)	1-120	10	Forced shut-down after hold time.
P58	Up needle position adjustment	0-1439	40	Up Position Adjustment The needle will advance stop when the value decreased. The needle will delay stop when the value increased.
P59	Down needle position adjustment	0-1439	750	Down Position Adjustment The needle will advance stop when the value decreased. The needle will delay stop when the value increased.
P60	Testing Speed (rpm)	100-6000	4000	Setting testing speed.
P61	Testing A	ON/OFF	OFF	Continuous running testing.
P62	Testing B	ON/OFF	OFF	Start and stop testing with all functions.
P63	Testing C	ON/OFF	OFF	Start and stop testing without all function.
P64	Running Time of Testing	1-250	50	
P65	Stop Time of Testing	1-250	50	
P66	Machine protection switch selection	0-2	0	0: Disable 1: Testing zero signal 2: Testing positive signal

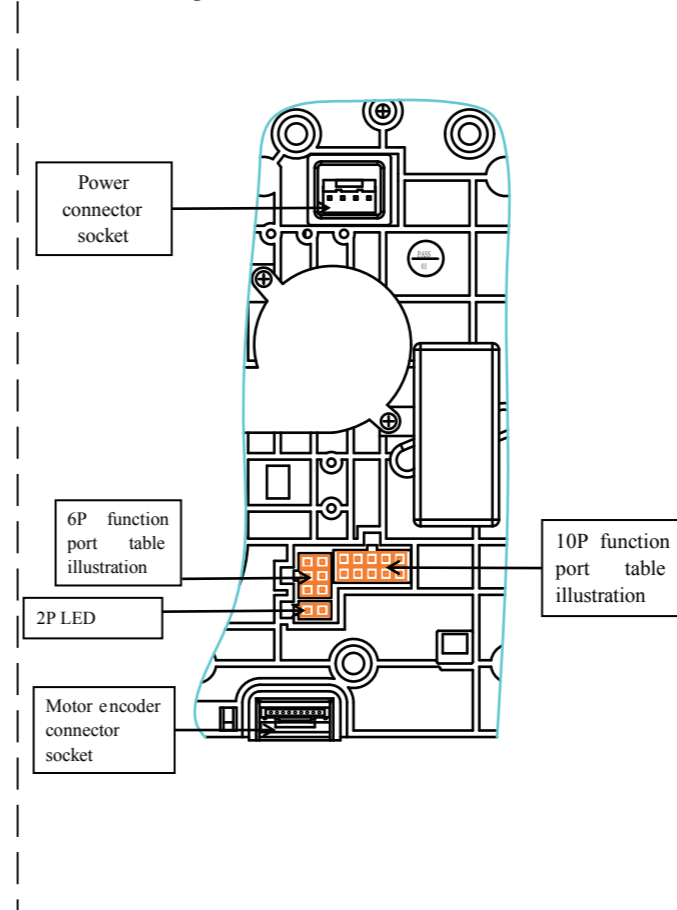
P67	Thread trimming protection switch selection	ON/OFF	ON	
P70	The factory type selection			
P71	Presser foot release operation duty cycle (%)	0-50	0	The buffer force of presser foot release operation.
P72	Up needle position adjustment	0-1439		Hand rotation manual to the appropriate position, press S key to save
P73	Down needle position adjustment	0-1439		Hand rotation manual to the appropriate position, press S key to save
P87	Upper knife trimming back delay times(ms)	10-990	50	
P89	Exchange overvoltage settings	500-1023	880	
P92	Correct the electrical angle of motor			Reading the initial Angle of encoder, the factory default was set, please do not change the values (parameter value cannot be changed manually, random change it will result the control box and motor abnormal or damaged).
P93	The delay time of the half back pedaling function(ms)	10-900	150	
P105	Electric/ pneumatic selection	0-1	0	0: Electric 1: Pneumatic
P108	Interlock suction function selection	ON/OFF	ON	
P109	The delay time before upper knife trimming action after finding up needle stop position	5-990	55	
P110	Lower knife trimming back delay times(ms)	60-990	60	
P112	Lower knife trimming output action time(ms)	10-990	100	
P113	Periodic signal of lower knife trimming output (%)	0-100	100	Force adjustment of lower knife trimming output
P117	The delay time of the presser foot release damping force (ms)	0-990	20	
P119	Electromagnet overcurrent protection selection	0-1	1	0: OFF 1: ON

Note: the parameter initial value is for reference only, the actual parameter value is based on the real thing.

3 Error Code List

Error Code	Problem description	Measure
E01	Over-voltage	Turn off the machine, check the power supply voltage (Or whether exceed the rated voltage of use). If there are still errors, please replace the control box and call for customer service.
E02	Low-voltage	Turn off the machine, check the power supply voltage (Or whether under the rated voltage of use). If there are still errors, please replace the control box and call for customer service.
E03	CPU communication error	Turn off the machine, please check if the operation panel in bad connection or is too loose. To get it right and turn on. If there are still errors, please replace the control box and call for customer service.
E05	Pedal connection error	Turn off the machine, please check if the pedal in bad connection or is too loose. To get it right and turn on. If there are still errors, please replace the control box and call for customer service.
E07	Motor locked-rotor error	Turn the machine handwheel, check if it is stuck. If it is stuck, you have to rule out the mechanical failure. If turn normal, check if the encoder and motor in bad connection or is too loose. If yes, please correct. If connection well, check if the power supply voltage is abnormal or sewing speed is too high. If yes, please adjust. If there are still errors, please replace the control box and call for customer service.
E10	Solenoid over-current	Turn off the machine, please check the related circuit is shorted or damaged.
E09	Positioning signal error	Turn off the machine, please check if the encoder in bad connection or is too loose. To get it right and turn on. If there are still errors, please replace the control box and call for customer service.
E14	Encoder error	Turn off the machine, please check if the encoder in bad connection or is too loose. To get it right and turn on. If there are still errors, please replace the control box and call for customer service.
E15	Power supply module abnormal over-current	Turn off the machine, then turn on again. If there are still errors, please replace the control box and call for customer service.
E16	Thread trimming switch is not in the correct position	Turn off the machine, check if the thread trimming switch back to the correct position.
E17	Machine protection switch is not in the correct position	Turn off the machine, check if the machine is turn over, or the mercury switch is shifted or damaged.
E20	Motor failed to start(Electrical angle error)	Turn off the machine, please check if the encoder and motor in bad connection or is too loose. To get it right and turn on. If there are still errors, please replace the control box and call for customer service.

4 Port Diagram



4.1 Function Port Description

