

直驱高速平缝机

DIRECT-DRIVE HIGH-SPEED
LOCKSTITCH SEWING MACHINE

使用说明书

OPERATION MANUAL

零件手册

PARTS BOOK

使用说明

为使您正确使用本机,须对本机的各种功能充分了解,以便安全操作。

使用前请仔细阅读使用说明书,我们希望您能长期愉快地使用本机,请保存好说明书,以备查阅。

1. 无论您何时使用本机,须了解基本的安全事项,包括但不限于下列事项。
2. 通读所有说明,并保存好使用说明书。如果需要,请随时翻阅。
3. 使用本机前,必须弄清与本机有关安全规定、标准在您的国家是否适用。
4. 使用本机前或使用本机时,所有安全装置必须配备齐全。机器运转时,无安全装置属违章操作,决不允许。
5. 操作人员必须经过适当的培训。
6. 为了您的人身安全,我们建议您戴上防护上镜。
7. 下列情况下,请关闭电源开关或拔下电源插头:
 - 7-1 机针穿线和换梭心;
 - 7-2 更换机针、压脚、针板、送料牙、布料导板等;
 - 7-3 进行维修时;
 - 7-4 操作区无人时。
8. 在机器加油润滑时,若不小心让油接触眼睛、皮肤或咽下机油或润滑油,请立即清洗被沾染部位或去医院检查。
9. 无论机器运转与否,严禁乱动机器零部件和配套装置。
10. 机器的维修、改造和调整等工作必须由专业技术人员进行。
11. 应由专业受训人员进行一般的维修和检查工作。
12. 必须在专业电器人员或专业技术人员的指导下进行有关电器部件的维修,任何电器部件一经发现受损,立即停止机器运转。
13. 使用期间要定期全面彻底清洗机器。
14. 正常操作本机时,必须进行试运转,工作环境远离强噪音源,如高频电焊机等。
15. 由电气人员选择合适的插头和有地线的插座。
16. 若需要改造或改进本机,请采用有效可行的安全措施。本公司对由此而产生的伤害不承担责任。

17. 本机只适用于专业缝纫。

18. 两种警告提示符：



操作人员或维修人员请注意



特别注意事项

INSTRUCTION MANUAL

To get the most out of the many functions of this machine and operate it insafely,it is necessary to use this machine correctly.

Please read this Instruction Manual carefully before use.We hope you will enjoy the use of your machine for a long time.Please remember to keep this manual in a safe place.

1. Observe the basic safety measures, including, but not limited to the following ones, whenever you use the machine.
2. Read all the instructions, including, but not limited to this Instruction Manual before you use the machine, in addition, keep this Instruction Manual so that you may read it at any-time when necessary.
3. Use the machine after it has been ascertained that it conforms with safety rules/standards valid in your country.
4. All safety devices must be in position when the machine is ready for work or in operation The operation without the specified safety devices is not allowed.
5. This machine shall be operated by appropriately-trained operators.
6. For your personalprotection,we recommend that you wear safety glasses.
7. For the following, turn off the power switch of disconnect the power plug of the machine from the receptacle.
 - 7-1 For threading needle(s) and replacing bobbin.
 - 7-2 For replacing part(s) of needle, presser foot, throat plate, feed dog, cloth guide etc.
 - 7-3 For repair work.
 - 7-4 For when leaving the working place of when the working place is unattended.

8. If you should allow oil, grease, etc. used with the machine and devices to come in contact with your eyes or skin or swallow any of such liquid by mistake, immediately wash the contacted areas and consult a medical doctor.
9. Tampering with the live parts and devices, regardless of whether the machine is powered, is prohibited.
10. Repairing, remodeling and adjustment works must only be done by appropriately trained technicians or specially skilled personnel.
11. General maintenance and inspection works have to be done by appropriately trained personnel.
12. Repair and maintenance works of electrical components shall be conducted by qualified electric technicians or under the audit and guidance of specially skilled personnel. Whenever you find a failure of any of electrical components, immediately stop the machine.
13. Periodically clean the machine throughout the period of use.
14. Grounding the machine is always necessary for the normal operation of the machine. The machine has to be operated in an environment that is free from strong noise sources such as high-frequency welder.
15. An appropriate power plug has to be attached to the machine by electric technicians, Power plug has to be connected to grounded receptacle.
16. Remodel or modify the machine in accordance with the safety rules/standards while taking all the effective safety measures. We assume no responsibility for damage caused by remodeling or modification of the machine.
17. The machine is only allowed to be used for the purpose intended. Other uses are not allowed.
18. Warning hints are marked with the two shown symbols.



Danger of injury to operator or service staff



Items requiring special attention

安全操作事项



1. 为避免触电,请不要打开电机的电箱盖,也不要触摸电箱内部组件。



1. 为避免人身伤害,移动防护罩、护手挡或安全装置时,请不要开动机器。
2. 为尽可能避免机器运转造成的人身伤害,手指、头部和衣服应远离上轮,上轮周围不要放置任何物品。
3. 为避免人身伤害,当您打开电源开关或操作机器时,切勿将手放在机针下方。
4. 为避免人身伤害,机器运转时,切勿将手放入挑线杆防护罩内。
5. 旋梭运转时,勿将手指放在旋梭附近。另外,换梭芯时,请关掉机器电源开关。
6. 为尽可能避免人身伤害,当翘起或抬起机头时,勿将手指放入机器内部。
7. 为尽可能避免机器的突然启动所造成的事故,抬起机头时,请关掉机器的电源。
8. 机器配有电机,机器未运转时,电机无噪音;为避免机器的突然启动所造成的事故,请关掉机器的电源开关。
9. 为尽可能避免触电或电器组件受损,在插上或拔下插头之前,请关掉电源开关。

FOR SAFE OPERATION



1. To avoid electrical shock hazards, neither open the cover of the electrical box for the motor nor touch the components mounted inside the electrical box.



1. To avoid personal injury, never operate the machine with any of the belt cover, finger guard or safety devices removed.
2. To prevent possible personal injuries caused by being caught in the machine. Keep your fingers, head and clothes away from the handwheel, cover and the motor while the machine is in operation. In addition, place nothing around them.
3. To avoid personal injury, never put your hand under the needle when you turn ON the power switch or operate the machine.
4. To avoid personal injury, never put your fingers into the thread take-up cover while the machine is in operation.
5. The hook rotates at a high speed while the machine is in operation. To prevent possible injury to hands, be sure to keep your hands away from the vicinity of the hook during operation. In addition, be sure to turn OFF the power to the machine when replacing the bobbin.
6. To avoid possible personal injuries, be careful not to allow your fingers in the machine when tilting/raising the machine head.
7. To avoid possible accidents because of abrupt start of the machine, turn OFF the power to the machine when tilting the machine head.
8. If your machine is equipped with a servo-motor, the motor does not produce noise while the machine is at rest. To avoid possible accidents due to abrupt start of the machine, be sure to turn OFF the power to the machine.
9. To prevent possible accidents because of electric shock or damaged electrical component(s), turn OFF the power switch in prior to the connection /disconnection of the power plug.

目 录

CONTENTS

使用说明

Operation Instruction

1	开车前的注意事项 Precautions Prior to Startup	3
2	使用注意事项 Precautions for Use	3
3	主要技术规格 Main Technical Specifications	4
4	机器的安装 Mounting the Machine	5
5	机器的润滑 Lubrication	5
6	旋梭油量调节 Oil mass Adjustment of Rotating Hook	6
7	机针的装法 Mounting the Needle	8
8	梭芯的装法 Mounting the Bobbin	9
9	面线的穿法 Threading the Needle Thread	9
10	底线的卷绕 Winding up the Bobbin Thread	9
11	针距的调节 Adjusting the Stitch Length	11
12	线架的安装 Mounting the Thread Stand	11
13	膝提高度的调节 Adjusting the Knee Lifting Height	12
14	挑线簧的调节 Adjusting the Take-up Spring	12
15	缝线张力调整 Adjusting the Tension of Stitch Thread	13
16	压脚扳手 Presser Foot Lever	14
17	挑线杆挑线量的调节 Adjusting the Take-up Amount of Take-up Lever	14

18	压脚压力的调节 Adjusting the Presser Foot Pressure	15
19	手动抬压脚高度的调节 Adjusting the Manual Foot Lifting Height	15
20	送料牙的高度 Height of the feed dog	16
21	送料牙的倾斜 To tilt the feed dog	16
22	送料相位的调节 Adjusting the feed timing	17
23	机针与旋梭的位置的调整 Adjusting the Positions of Needle and Rotating Hook	18
24	踏板的操作 Operating the Treadle	19
25	踏板的压力与行程 Pedal Pressure and Pedal Stroke	19
26	踏板的调整 Adjustment of the Pedal	20
27	手触补针装置的使用 The usage of manually fill needle devices	21

1 开车前的注意事项

1 Precautions Prior to Startup

1. 机头装箱前为了防止机件生锈,在部分均涂有较厚的防锈油脂,同时机头装箱后,还可能可能在较长的贮藏和长途运输阶段造成油脂硬化和在机器表面积聚灰尘,所以必须将表面的油脂和灰尘用汽油和洁净的软布擦拭干净。

2. 机器出厂时,虽经过周密的检查和试验,但在长途运输中也可能受到强烈的震动使机件松动或歪曲,所以应该做一次周密的检查,并用手转动上轮,看机件之间有无转动困难、碰撞现象或其它不均匀的阻力,不正常的声响,如有应作适当的调整,机器状态正常后才可正式试车。

3. 油箱内机油液面高度没有在正常范围内绝不能开车。

4. 机器运转时,上轮转向应该是逆时针方向(从上轮外侧面看)。

5. 确认电控铭牌上所标电压及相位是否正确。

6. 生产日期见合格证。

1.The machine head is coated with a thick layer of rust-prevention grease before encasement, and the encased machine head may possibly be subjected to grease hardening and dust buildup on the machine surface in process of long storage and long-haul traffic; therefore, take care to remove the grease and dust from the surface using soft cloth and gasoline.

2.Though the machine was inspected and tested with care before factory leaving, it might be affected by violent vibration resulting in looseness or distortion of the machine parts; therefore the operator shall thoroughly check the machine, turn the upper wheel by hand and check it for difficulty in free rotation, slight impact, and other uneven resisting force or abnormal noises, and make appropriate adjustment if any to restore the machine state before formal trial run.

3.Never start up the machine if the oil liquid level in the oil box falls outside the normal range.

4.The upper wheel shall rotate counterclockwise (when it is viewed from the lateral surface of the upper wheel) when the machine is operating.

5.Check whether the voltage and phases indicated on the electric-control data plate are correct.

6.The date of manufacture is indicated on the certificate of conformity.

2 使用注意事项

2 Precautions for Use

1. 当接通电源或机器运转时,请勿将手与机针接触。

2. 机器运转时,请勿将手指伸入挑线杆防护罩内。

3. 操作者用手送料时,请勿将手指伸入护针架。

4. 机头翻动及拆手盖时,一定要切断电源。

5. 操作者离开机器时,必须切断电源。
6. 机器运转时,绝不允许头或手以及任何东西靠近上轮、绕线器。
7. 只有在停机时,才能装卸防护罩或其它保护装置。
8. 不能用香蕉水等油漆稀释剂擦拭机头表面。

1.Never touch the needle by hand when the machine is powered on or while it is operating.

2.Never put your finger into the protection cover of take-up lever during operation of the machine.

3.The operator must not put his finger into the needle guard bracket when he feeds the sewing materials by hand.

4.Operator must trim off the electricity supply before he turns over the machine head or removes the hand cover.

5.The operator must trim off the electricity supply before he gets away from the machine.

6.Prohibit the head, hands and anything to approach the upper wheel and bobbin winder while the machine is operating.

7.Never remove or mount the protection cover or other protection devices before the machine is stopped.

8.Never wipe up the surface of machine head using paint thinner such as acetone.

3 主要技术规格 Main Technical Specifications

规格		参数
缝料		薄料至中厚料
最高缝速		5000针/分
最大针距		5毫米
机针		DB×19#~18#
压脚提升高度	手控	5.5毫米(最大)
	膝控	13毫米(最大)
润滑系统		自动
润滑油		10号白油
电机功率		220伏/550瓦

Specification		Parameter
Application		For light materials and medium heavy materials
Max sewing speed		5000RPM
Max stitch length		5mm
Needle		DB×19#~18#
Presser foot lift height	Hand lifter	5.5mm(Max)
	Knee lifter	13mm(Max)
Lubricating system		Auto
Lubrication oil		10# White oil
Motor power		220V/550W

4 机器的安装 (图1、图2、图3、图4) Mounting the Machine (Fig.1, Fig. 2, Fig.3 and Fig. 4)

1.油盘的安装

1) 油盘②应放置在台板上的凹槽四角上。
2) 将两只机头座垫①安装在油盘②的A边 (朝操作者一边), 将两只油盘支座③安装在油盘②的B边 (机头连接钩接合一边), 然后放上油盘②。

3) 将机头连接钩⑤插入底板销孔内, 与台板的机头连接钩座④相嵌合再把机头放到油盘四只角的机头座垫上。

1. Fixing oil tray

1) Put the oil tray ② on the four groove corners on the sewing table.

2) Fix two arm cushion ① to the A side of oil tray ② (facing the operator). Fix the two stand bases ③ to the B side of oil tray ② (hinge side), then fix the oil tray ②.

3) Insert machine head coupling hook ⑤ into the pin holes in the bottom plate such that it is embedded into the coupling hook seat ④, and put the machine head onto the seating washer on four corners of the oil tray.

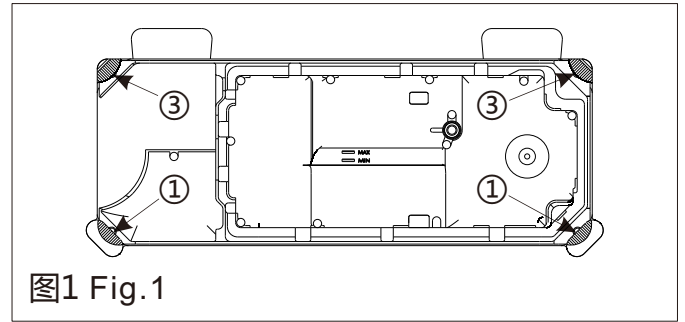


图1 Fig.1

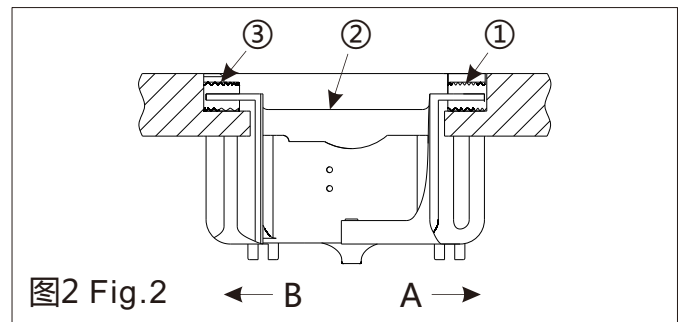


图2 Fig.2

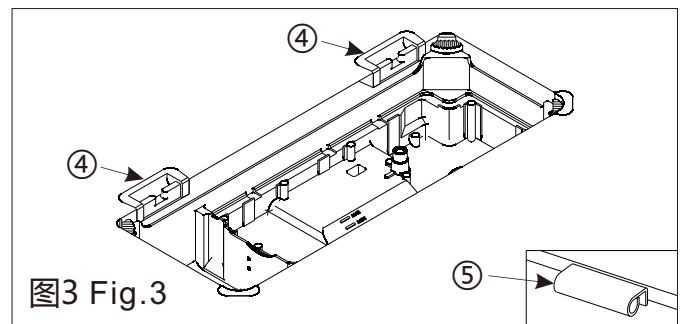


图3 Fig.3

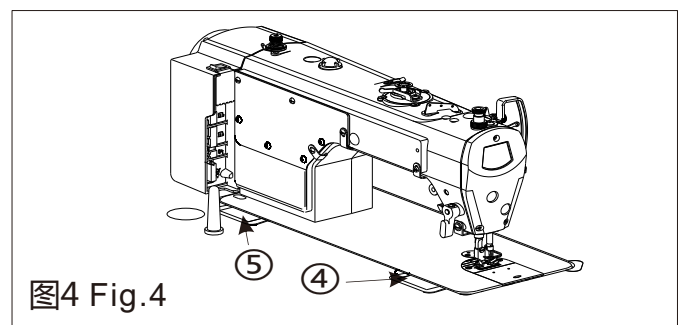


图4 Fig.4

5 机器的润滑 (图5) Lubrication (Fig.5)

1. 润滑须知

1) 向油盘①注入缝纫机油 (10号白油) 至“MAX”记号部A。
2) 当油面低于MIN记号B时, 应再加油。

1. Information on lubrication

1) Fill oil pan ① with sewing machine oil (10 while oil) up to MAX mark A.
2) When the oil level lowers below MIN mark B, refill the oil pan with the specified oil.

3) 加油后，开动机器，应看到油液飞溅到油窗②上，说明润滑正常。

4) 至于飞溅的油量多少与总润滑油量多少无关。

3) When you operate the machine after lubrication, you will see splashing oil through oil sight window ② if the lubrication is adequate.

4) Note that the amount of the splash oil is unrelated to the amount of the lubricating oil.



注意:

1. 为了防止缝纫机的意外启动，请关掉



电源之后再进行操作。



Caution:

1. To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.

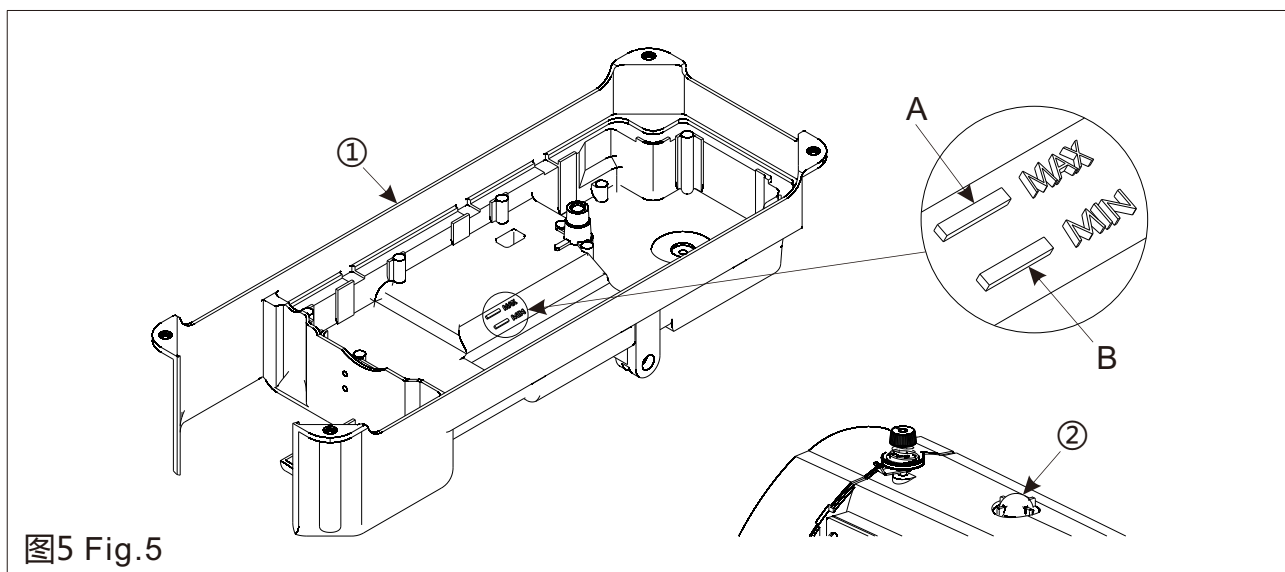


图5 Fig.5

6 旋梭油量调节 (图6、图7、图8) Oil mass Adjustment of Rotating Hook (Fig. 6, Fig. 7, Fig. 8)

1. 调节方法

1) 旋梭的油量是用旋梭油量调节螺钉①来调节：当旋梭油量调节螺钉朝 + 方向A转动时，油量将增大；朝 - 方向B转动时，油量将减小。

2) 调节油量后缝纫机应进行约30秒钟的空转，以确认油量状态。

1. Adjustment method

1) Adjust the oil mass of rotating hook using adjusting screw ①: Turning the adjusting screw of the front shaft sleeve on bottom shaft towards + direction A, the oil amount will increase, and towards - direction B, the oil amount will decrease.

2) When adjustment of oil mass is over, allow the sewing machine to idle for about 30 seconds to confirm the state of oil mass.



注意:

1. 为了防止缝纫机的意外启动，请关掉



电源之后再进行操作。



Caution:

1. To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.



2.油量的确认方法

1) 机头冷却时，请进行三分钟左右的空转(适当的间歇运转)。

2) 请在缝纫机转动时将油量确认专用纸插入(具体操作见图8所示)。

3) 油量确认时间为5秒。



注意:



- 1.进行上述操作时，确认油盘内的油面高度处在“MAX”和“MIN”范围内。
- 2.旋梭是高速运转的。为了防止人身事故，调节油量时，要充分注意手指不要碰到旋梭。

1. Confirming the Oil Mass

1) To cool down the machine head, allow it idle for about 3 minutes (appropriate discontinuous running).

2) Insert the special oil mass confirmation paper when the sewing machine is rotating (detailed operations are described in Fig. 8).

3) Oil mass confirmation time lasts for 5 seconds.



Caution:



1. Prior to the above-mentioned operation, Make sure the oil height in the oil plate ranges between MAX and MIN.
2. Rotating hook works at high speed. To prevent human injury, the operator shall keep his fingers away from the rotating hook during oil mass adjustment.

3.油量适合标样

1) 右图标样(见图8)根据不同的缝制工序需求进行增或减的微调整，但应注意不要增加或减少过多。油量过少时会引起旋梭发热，油量过多时会污染缝料。

2) 用油量确认专用纸测试三次，直至确认3次油量确认专用纸油迹均无变化为止。

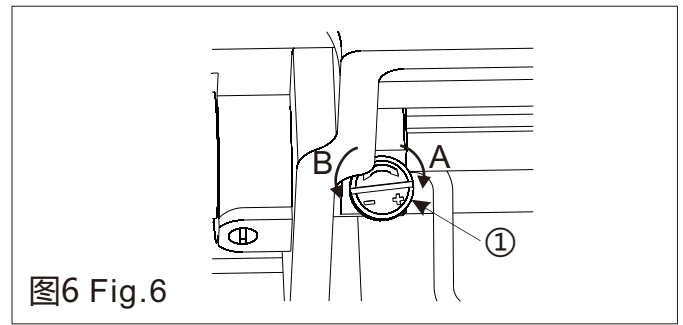


图6 Fig.6

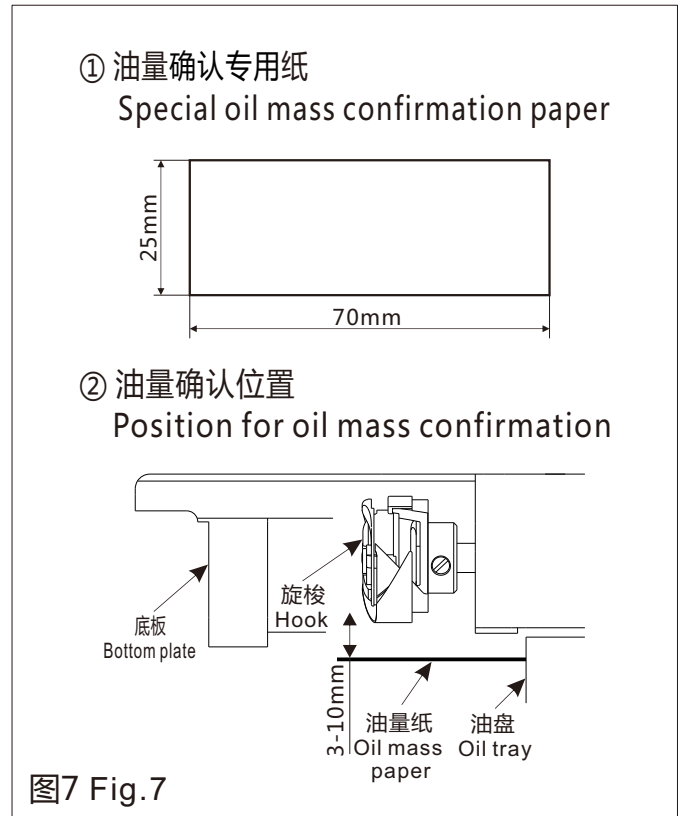


图7 Fig.7

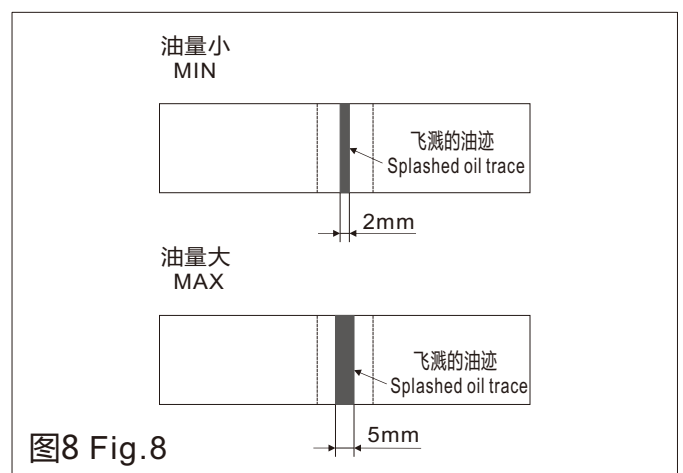


图8 Fig.8

3. Guide sample of oil mass adequacy

1) The guide sample shown in the right-hand figure (see Fig. 8) may be finely adjusted (increased or reduced) as per different sewing processes; however, excessive increase or reduction shall be avoided. Too little oil mass may lead to rotating hook heating, and overmuch oil mass may lead to contamination of the sewing materials.

2) Test the oil mass 3 times using special oil mass confirmation paper till the oil traces indicated by the special paper show no changes.

7 机针的装法 (图9) Mounting the Needle (Fig.9)

1. 转动上轮使机针上升到最高处。
2. 拧松支针螺钉②，手拿机针①将机针①的凹弧部分A正对右方向B。
3. 将机针朝箭头方向插入针孔的底部，直至插不进为止。
4. 拧紧支针螺钉②。
5. 务必使机针的长槽C正对左方向D。

1. Turn the upper wheel to allow the needle to reach its maximum height.
2. Unscrew needle carrying screw ②, hold needle ① by hand, and align the indentation A of needle to right direction B.
3. Insert the needle into the bottom of needle hole in direction of arrow till it reaches the end point.
4. Screw down the needle carrying screw ②.
5. Take care to ensure that the elongated slot C on the needle is aligned to the left direction D.



注意:



1. 为了防止缝纫机的意外启动，请关掉电源之后再进行操作。
2. 机针有各种编号，请根据所用线的粗细和缝料来选择适当的机针。



Caution:



1. To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.
2. Needles are available in different sizes. Please select appropriate needle as per the thickness of threads and the sewing materials.

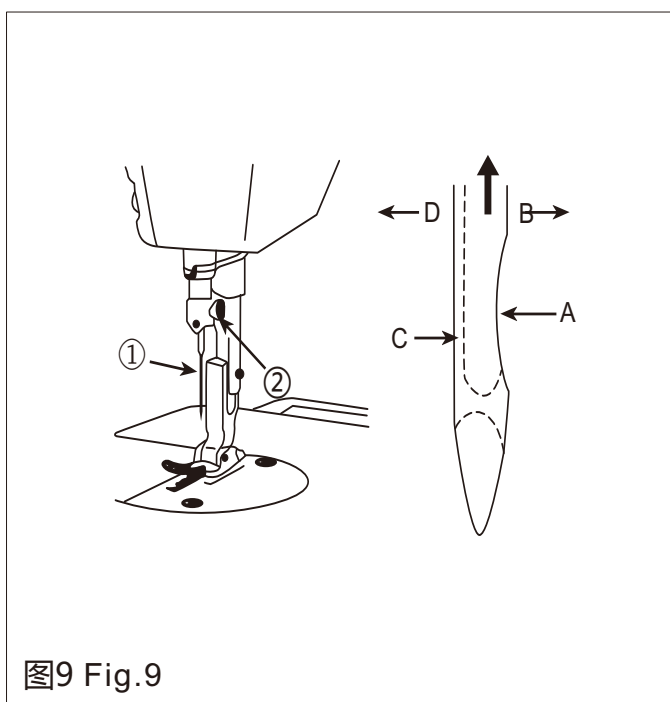


图9 Fig.9

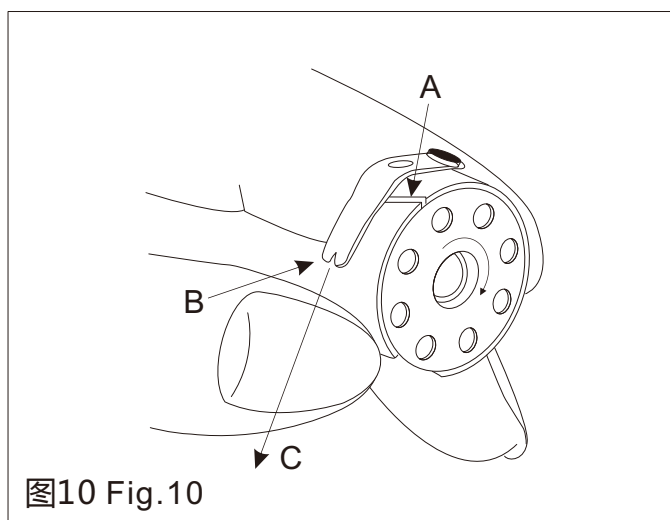


图10 Fig.10

机。梭芯①向C方向转动，线卷绕到梭芯①上。卷绕线满后卷绕手柄③自动向B方向弹开并停止卷绕。

4) 取下梭芯①，用绕线切刀④切断机线。



注意:



1.卷绕底线时，请将要卷绕的底线处于梭芯①和夹线板③之间拉线状态下开始绕线。

2.不进行缝制时给梭芯①绕底线时，请把面线从挑线杆孔上抽出来，把梭芯①从旋梭里卸下来后再进行。

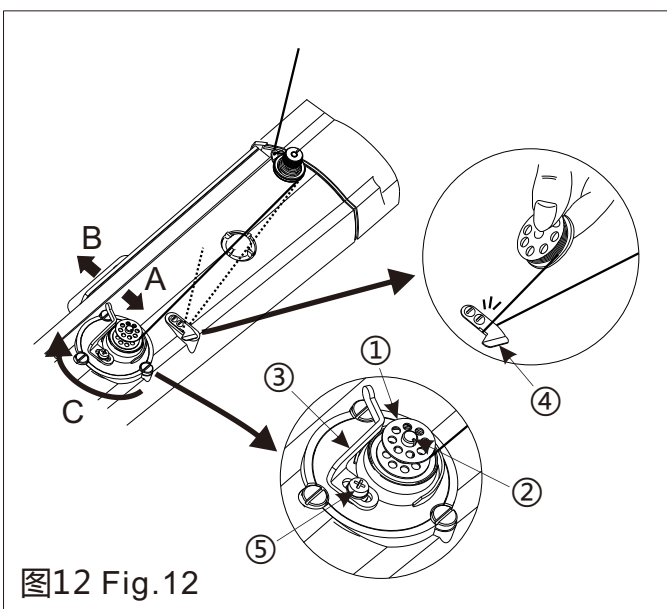


图12 Fig.12

2.底线卷绕的调节

1) 调整底线卷线量时，请拧松固定螺钉⑤，把卷绕手柄③移动到A方向或B方向，然后再固定螺钉⑤。A方向变少，B方向变多。

2) 如果线不能平绕梭芯时，请拧松螺母⑥，转动绕线夹线器，调整夹线板⑦的高度：

a.旋梭①中心和夹线板⑦中心高度一样时为标准位置。

b.下部卷的多时，向如右图D方向移动绕线夹线器的位置，上部卷的多时，向如右图E方向移动绕线夹线器的位置。

A, and run the sewing machine. Bobbin ① is rotated in direction C, and thread is reeled onto bobbin ①. Once the reel is full, winding lever ③ is pushed toward direction B, and winding is over.

4) Remove bobbin ①, and trim off the thread using winding trimmer ④.



Caution:



1. To reel the bobbin thread, set the bobbin thread to between bobbin ① and thread gripper plate ③ in taking-up mode, and start thread winding.

2. To reel bobbin thread onto bobbin ① when no sewing is performed, draw the needle thread out of hole in the take-up lever, remove bobbin ① out of rotating hook.

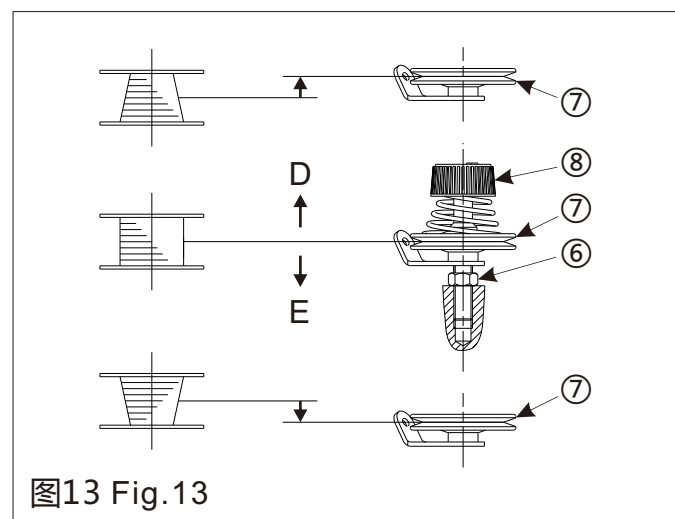


图13 Fig.13

1. Adjusting the bobbin thread winding

1) To adjust the winding capacity of bobbin thread, unscrew fixing screw ⑤, set winding lever ③ in direction A or direction B, and fix screw ⑤ again. Direction A is intended for reduction, and direction B is intended for increase.

2) If thread cannot be wound onto the bobbin flatly, unscrew nut ⑥, turn the winding tension disco, and adjust the height of height of thread gripper plate ⑦.

a. The standard position is reached once the center heights of rotating hook ① and thread gripper plate ⑦ are identical.

c.调整绕线夹线器到合适位置后，把固定螺钉⑥拧紧。

3) 调整底线卷绕张力时，请转动线张力螺母⑧进行调整。

b.If the winding amount on the lower part is bigger, move the winding tension disco in direction D indicated in the right-hand figure. If the winding amount on upper part is bigger, move the winding tension disco in direction E indicated in the right-hand figure.

c.When the winding tension disco reaches its suitable position, screw down fixing screw ⑥.

3)Adjust the winding tension of bobbin thread by turning thread tension nut ⑧.

11 针距的调节 (图14) Adjusting the Stitch Length (Fig. 14)

1.将送料距旋钮①朝箭头方向转动，旋至所需数字对准机壳上的刻点A。

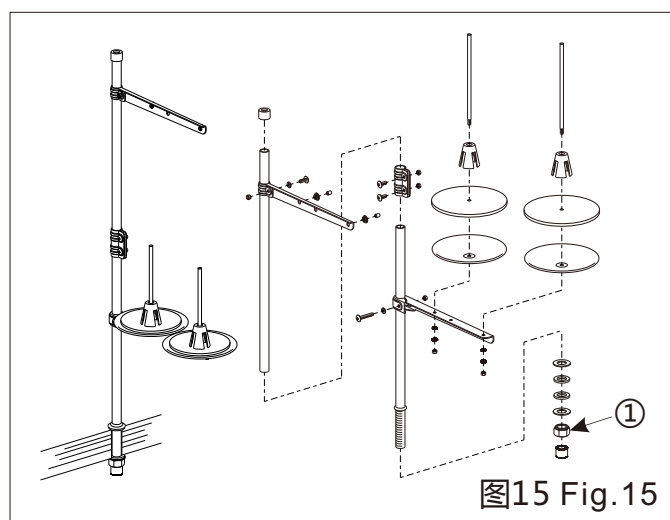
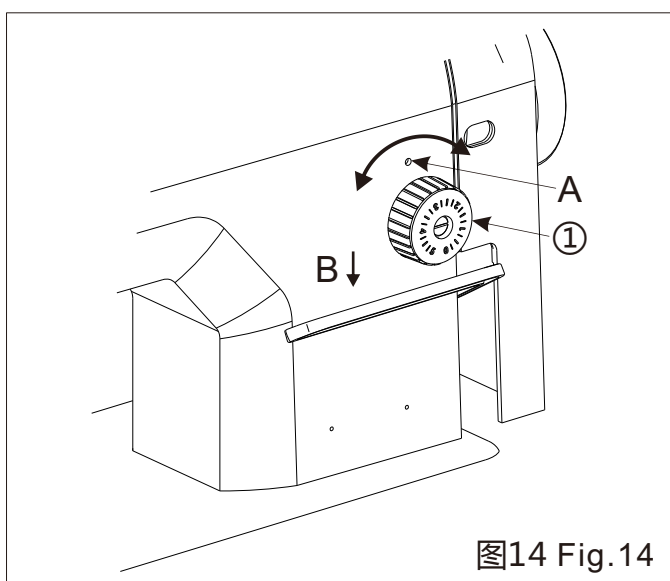
2.旋钮上的刻度数字用毫米表示。

3.当你想缩短线迹长度时，把倒送料扳手②朝B方向压下的同时并转动送料距旋钮。

1.Turn stitch length dial ① in the direction of the arrow, and align the desired number to marker dot "A" on the machine arm.

2.Scale mark digits are expressed on the knob in millimeters.

3.To reduce the stitch length, hold down the reverse feed lever ② in direction B, and turn the feeding distance knob.



12 线架的安装(图15) Mounting the Thread Stand (Fig. 15)

1.如右图所示那样将线架部件安装到缝纫机台板线架安装孔上。

2.旋紧线架杆下节固定螺母①固定线架。

1.As shown in right-hand figure, mount the thread stand component onto the mounting hole for thread stand on the sewing machine table.

2.Screw down retaining nut ① for lower segment of thread stand lever to fix the thread stand.

13 膝提高度的调节 (图16、图17)

Adjusting the Knee Lifting Height (Fig.16, Fig. 17)

- 1.膝提时的标准高度是10mm。
- 2.用膝提调整螺钉①可以调节压脚提升量，最大可至13毫米。

- 1.Standard knee lifting height is 10mm.
- 2.Knee-lifting adjusting screw ① may be used to adjust the lifting amount of presser foot, and the maximum lifting amount may reach 13mm.



注意:



- 1.为了防止缝纫机的意外启动，请关掉电源之后再进行操作。
- 2.当压脚提升超过10mm时，请不要运转缝纫机，因为针杆②与压脚③会相碰。



Caution:



- 1.To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.
- 2.When the presser foot lifting exceeds 10mm, do not run the sewing machine because needle bar ② may collide with presser foot ③.

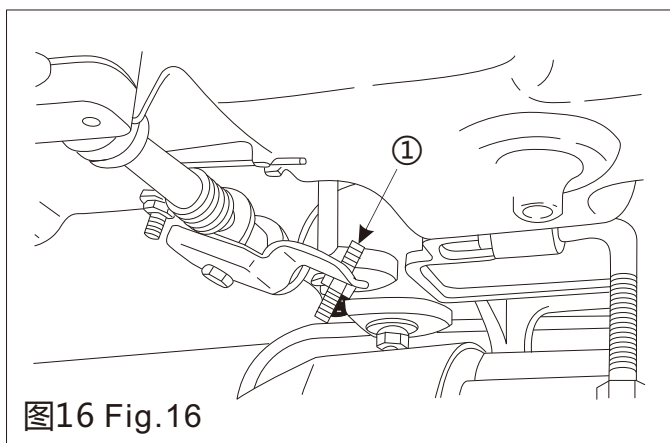


图16 Fig.16

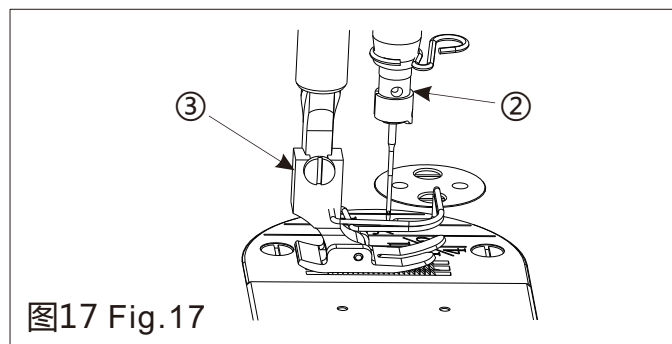


图17 Fig.17

14 挑线簧的调节 (图18、图19)

Adjusting the Take-up Spring (Fig.18, Fig. 19)

- 1.挑线簧摆动量的调节
 - 1) 若将夹线器⑤中的螺钉③朝顺时针方向(即A方向)转动时，挑线簧①的摆动量将增大；若朝逆时针方向(即B方向)转动时，挑线簧①的摆动量将减小。
- 2.挑线簧张力的调节
 - 1) 旋松螺钉②，取出夹线器⑤(组件)。
 - 2) 旋松线器⑤中螺钉④。
 - 3) 若将夹线器⑤中的螺钉③朝顺时针方向(即A方向)转动时，挑线簧①的张力将增大；若逆时针方向(即B方向)转动时，挑线簧①的张力将减小。

- 1.Adjusting the oscillating quantity of take-up spring
 - 1) The oscillating quantity of take-up spring ① is increased if screw ③ in tension disco ⑤ is turned clockwise (namely in direction A), and it ① is reduced if the screw is turned counter clockwise (namely in direction B).
- 2.Adjusting the tension of take-up spring
 - 1) Unscrew screw ②, and take out tension disco ⑤(assembly).
 - 2) Unscrew screw ④ in tension disco ⑤.
 - 3) The tension of take-up spring ① is increased if screw ③ in tension disco ⑤ is turned clockwise (namely in direction A), and it ① is reduced if the screw is turned counterclockwise (namely in direction B).

4) 调节结束后旋紧螺钉④，并将夹线器⑤(组件)装入机器中再旋紧螺钉②。

3.挑线簧调整适当的判断依据

1) 确认挑线簧①的张力调整后，把面线向B方向拉出，如果在挑线簧①达到最低位置之前面线B处就被拉动,请减弱挑线簧①的张力。



注意:



- 1.为了防止缝纫机的意外启动，请关掉电源之后再进行操作。
- 2.通常机器在出厂前,挑线簧均已调整妥善，只是在缝纫特殊的缝料或特殊的缝线时，才需要重新进行调整。

4) Screw down screw ④ when adjustment is over, fit tension disco ⑤(assembly) into the machine, and screw down screw ②.

3.Judgment basis for adjustment adequacy of take-up spring

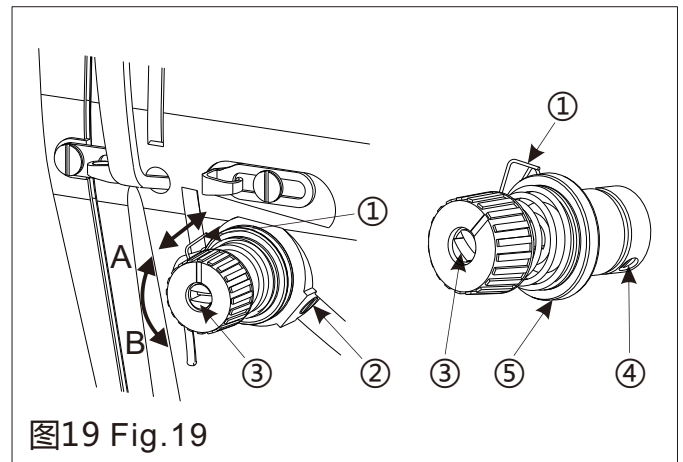
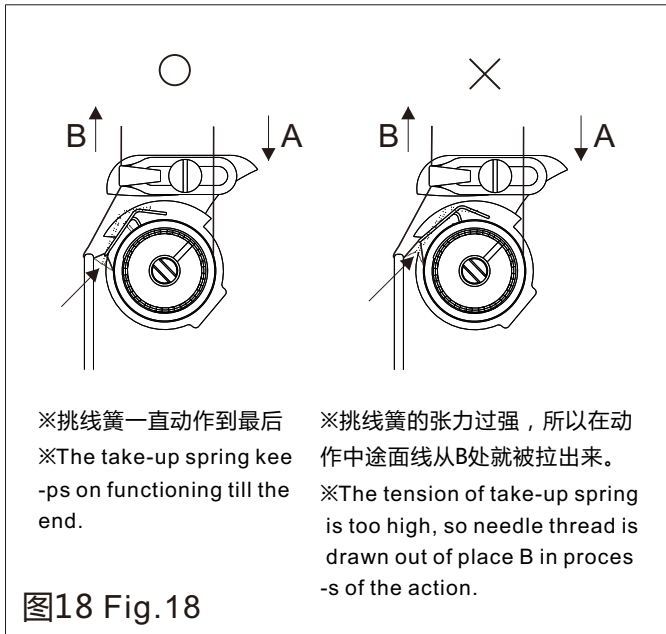
1) Confirm that the tension of take-up spring ① is properly adjusted, draw out the needle thread in direction B. If place B of needle thread is drawn before take-up spring ① reaches its lowest position, reduce the tension of take-up spring ①.



Caution:



- 1.To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.
- 2.The take-up spring is already adjusted properly before the machine leaves the factory as a rule, and it requires readjustment only for sewing of special materials or usage of special stitch threads.



15 缝线张力调整 (图20) Adjusting the Tension of Stitch Thread (Fig.20)

1.面线张力的调节

1) 若将夹线器中的调节螺母①朝顺时针方向(即A方向)转动时，面线张力将增大；若朝逆时针方向(即B方向)转动时，面线张力将减小。

2.底线张力的调节

1) 若将夹线螺钉②朝顺时针方向(即C方向)转动时，底线张力将增大；若朝逆时针方向(即D方

-1.Adjusting the tension of needle thread

1) The tension of needle thread is increased if the adjusting nut ① in tension disco is turned clockwise (namely in direction A), and it is reduced if the nut is turned counterclockwise (namely in direction B).

2.Adjusting the tension of bobbin thread

1) The tension of bobbin thread is increased if the adjusting screw ② is turned clockwise (namely in direction A), and it is reduced if t

向)转动时，底线张力将减小。



注意:



1.为了防止缝纫机的意外启动，请关掉

电源之后再进行操作。

the screw is turned counterclockwise (namely in direction B).



Caution:



1. To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.

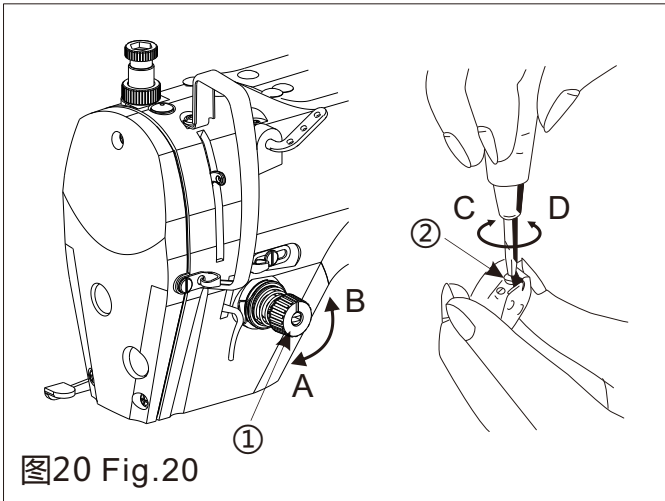


图20 Fig.20

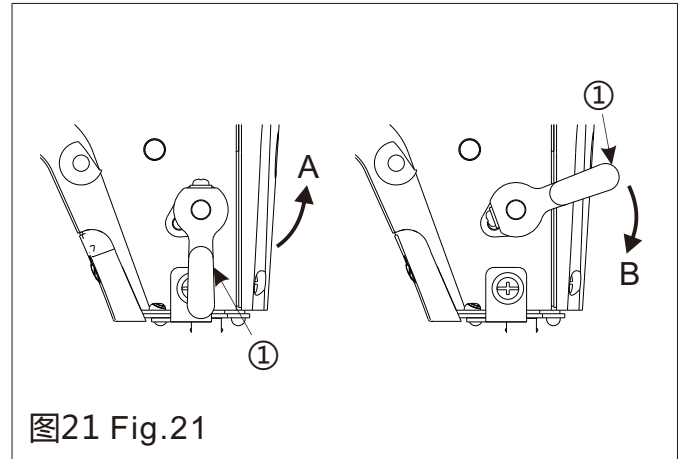


图21 Fig.21

16 压脚扳手 (图21) Presser Foot Lever (Fig.21)

1. 停车后将压脚扳手①朝A方向转动使压脚抬起(压脚的抬起量约为5.5mm)。

2. 当压脚扳手①朝B方向转动时，压脚将放回原来的位置。

1. Shut down the machine, turn presser foot lever ① in direction A to uplift the presser foot (for about 6mm).

2. When presser foot lever ① is turned in direction B, presser foot will be returned to its original position.

17 挑线杆挑线量的调节 (图22) Adjusting the Take-up Amount of Take-up Lever (Fig.22)

1. 右线钩上的刻线C与螺钉中心一致时为标准位置。



2. 缝制厚料时，应旋松螺钉①再将右线钩②朝左方向(即A方向)移动，以增大挑线量，调节完成后旋紧螺钉①。



3. 缝制薄料时，应旋松螺钉①再将右线钩②朝右方向(即B方向)移动，以减小挑线量，调节完成后旋紧螺钉①。

1. The standard position is obtained when graduation line C on right thread hook is aligned to screw center.

2. For thick material sewing, unscrew screw ① and move right thread hook ② to the left (namely in direction A) to increase the take-up amount, and screw down screw ① when adjustment is over.

3. For thin material sewing, unscrew screw ① and move right thread hook ② to the right (namely in direction B) to reduce the take-up amount, and screw down screw ① when adjustment is over.

-  **注意:**
 1.为了防止缝纫机的意外启动，请关掉电源之后再进行操作。

-  **Caution:**
 1.To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.

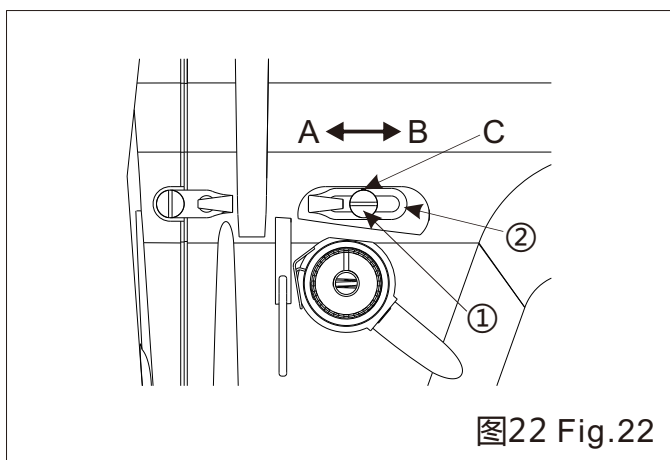


图22 Fig.22

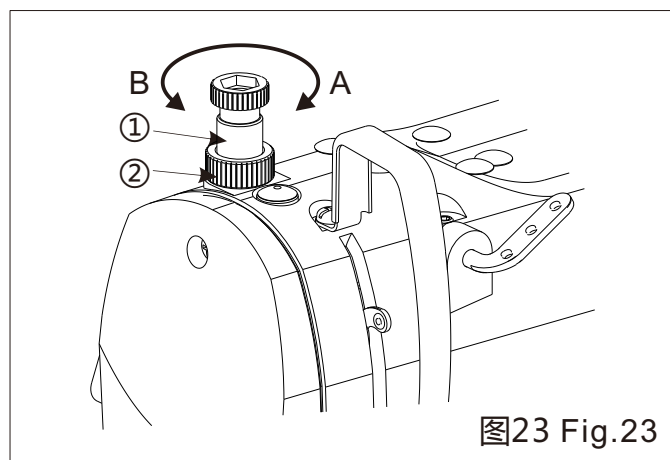






图23 Fig.23

18 压脚压力的调节 (图23) Adjusting the Presser Foot Pressure (Fig.23)

- 1.旋松调压螺母②。
- 2.若将调压螺钉①朝顺时针方向(即A方向)转动时，压脚压力将增强；若朝逆时针方向(即B方向)转动时，压脚压力将减弱。
- 3.调节完成后旋紧调压螺母②。

- 1.Unscrew pressure adjusting nut ②.
- 2.Presser foot pressure is increased if pressure adjusting screw ① is turned clockwise (namely in direction A); the pressure is reduced if the screw is turned counterclockwise (namely in direction B).
- 3.Screw down pressure adjusting nut ② when adjustment is over.

-  **注意:**
 1.为了防止缝纫机的意外启动，请关掉电源之后再进行操作。
 2.对一般布料而言，调压螺钉①的标准高度为32~34毫米，(4.5公斤力)左右。

-  **Caution:**
 1.To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.
 2.When the presser foot lifting exceeds 10mm, do not run the sewing machine because needle bar ② may collide with presser foot ③.

19 手动抬压脚高度的调节 (图24) Adjusting the Manual Foot Lifting Height (Fig.24)

- 1.将压脚扳手朝顺时针转动使压脚抬起，旋松压杆导架紧固螺钉①，上下移动压杆②来调节手动抬压脚高度(压脚高度为针板面与压脚底面的距离，手动抬压脚高度的标准值为5.5mm)。
- 2.调节结束后，拧紧压杆导架紧固螺钉①。

- 1.Turn clockwise the presser foot lever to up-lift the presser foot, unscrew tightening screw ① of presser bar spring bracket, moving upward/downward pressure bar ② to adjust the manual foot lifting height (presser foot height indicates the distance from the surface of needle plate to the bottom surface of presser foot, and



注意:

- 1.为了防止缝纫机的意外启动,请关掉电源之后再进行操作。

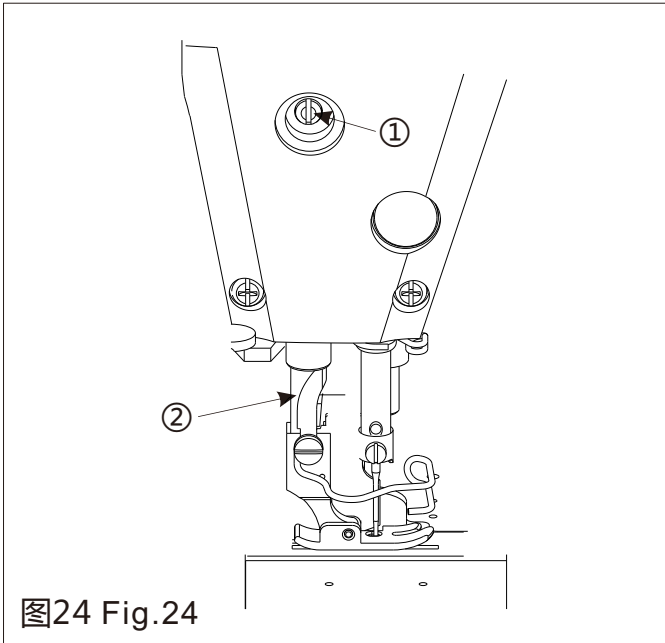


图24 Fig.24

- the standard value of manual foot lifting height is 6mm).
2. When adjustment is over, screw down tightening screw ① of presser bar spring bracket.



Caution:

1. To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.

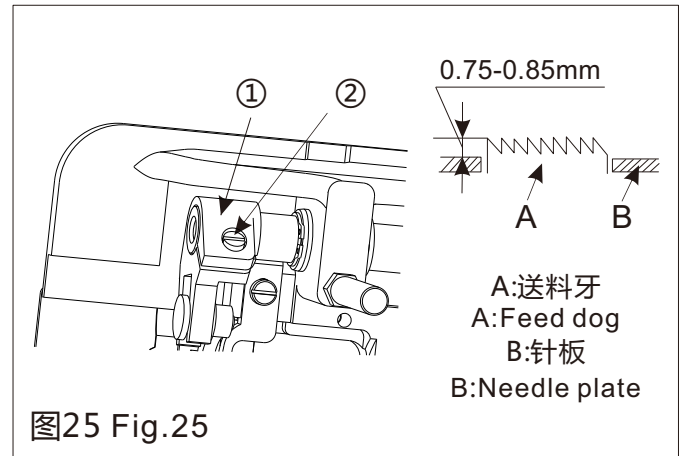


图25 Fig.25

20 送料牙的高度 (图25) Height of the feed dog (Fig.25)

- 1.送料牙一般应比针板高出0.75-0.85毫米。
- 2.送料牙高度的调节
 - 1) 旋松抬牙叉形曲柄①的紧固螺钉②。
 - 2) 上下移动牙架进行调节。
 - 3) 旋紧曲柄螺钉②。

1. The feed dog is factory-adjusted so that it just out from the throat plate 0.75 to 0.85mm.
2. To adjust the height of the feed dog
 - 1) Loosen screw ② of crank ①.
 - 2) Move the feed bar up or down to make adjustment.
 - 3) Securely tighten screw ②.



注意:

- 1.为了防止缝纫机的意外启动,请关掉电源之后再进行操作。



Caution:

1. To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.

21 送料牙的倾斜 (图26) To tilt the feed dog (Fig.26)

- 1.标准的倾斜,是在牙架销上的刻点A与牙架座①上的刻点对齐。
- 2.为了防止浮线,要送料方向高,则旋松固定螺钉,用螺丝刀把牙架销朝箭头方向转动90°。

1. For standard adjustment, align point A with point ①.
2. To prevent thread float, it has to make the sending direction higher, so loose the screw and turn the feeding bar shaft 90° in the direction of the arrow with a screwdriver.

3.为了防止缝料的潜移，要送料方向低，则牙架销朝箭头相反方向转动90°。

3.To prevent uneven material feed , turn the feeding bar shaft 90° in the opposite direction from the arrow with a screwdriver.



注意:



1.为了防止缝纫机的意外启动，请关掉电源之后再进行操作。

2.无论什么时候，调节送料牙的倾斜，送料牙的高度会发生变化；所以，在调整之后，请再次确认送料牙的高度。



Caution:



1.To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.

2.Whenever make the adjustment , the height of the feed dog changes. so after adjustment , please check the height of the feed dog again.

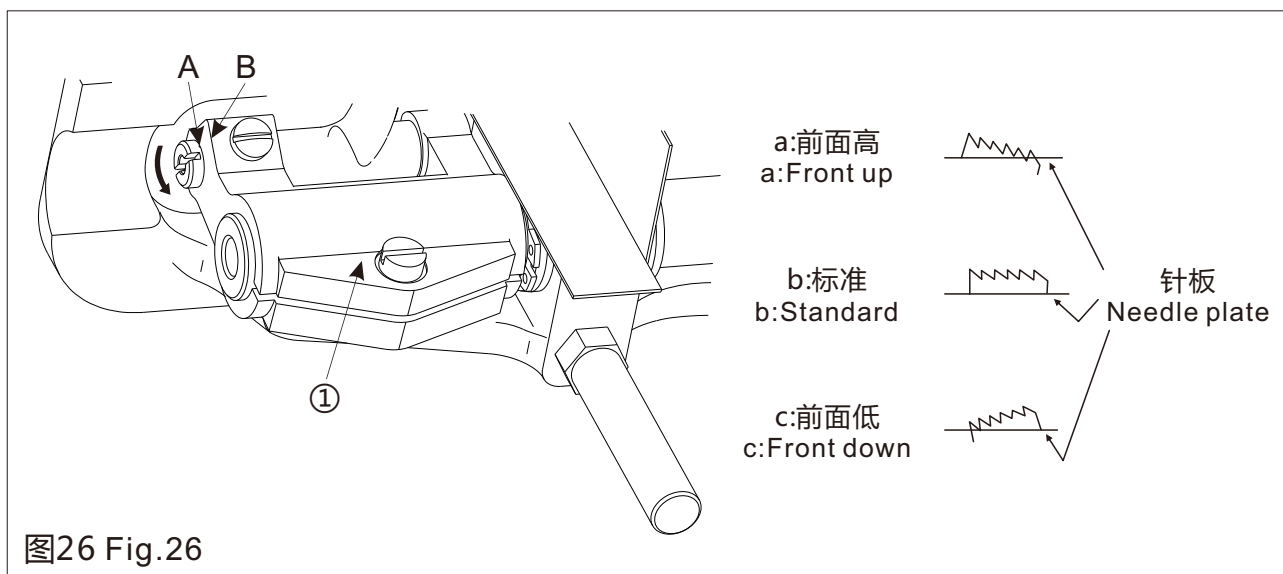


图26 Fig.26

22 送料相位的调节 (图27) Adjusting the feed timing (Fig.27)

1.在标准相位下，将送料偏心轮①的定位螺钉A与上轴挡圈②的定位螺钉B对齐。

2.调整时，旋松送料偏心轮上的两个定位螺钉③，将送料偏心轮调到适当的位置上，然后拧紧定位螺钉。

3.为了防止缝料的潜移，要加快送料相位，可将送料偏心轮朝箭头方向调整。

4.调为了增大线迹的紧密度，要减慢送料相位，可将送料偏心轮朝箭头相反方向移动。

1.To obtain the standard feed timing align setscrew "A" on feed eccentric cam ① with setscrew "B" on main shaft thrust collar ②.

2.To make adjustment , loosen two setscrews ③ to release the feed eccentric cam , properly position the eccentric cam. Then retighten the setscrews.

3.To advance the feed timing in order to prevent uneven material feed , move the feed eccentric cam in the direction of the arrow.

4.To delay the feed timing in order to increase stitch tightness , move the feed eccentric cam in the opposite direction for the arrow.



注意:

1.为了防止缝纫机的意外启动,请关掉电源之后再进行操作。



2.千万小心不要将送料偏心轮移动得太多,不然会造成断针现象。

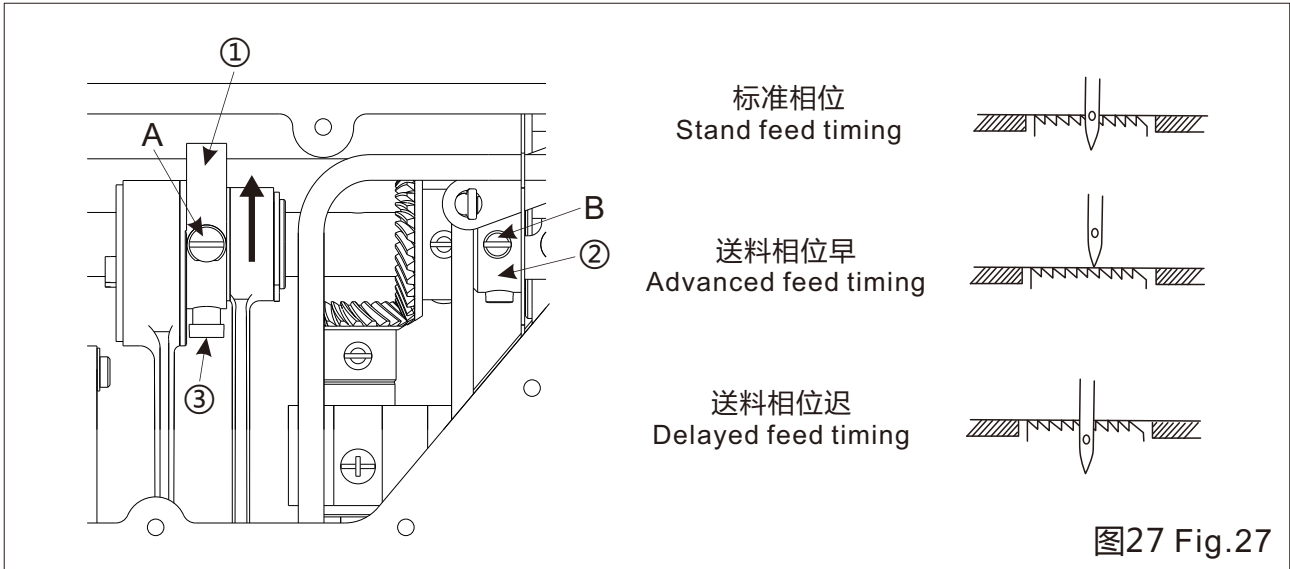


Caution:

1.To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.



2.Be careful not to move the feed eccentric cam too far, or else needle breakage may result.



23 机针与旋梭的位置的调整 (图28) Adjusting the Positions of Needle and Rotating Hook (Fig.28)

1.转动上轮,使针杆下到最低点,再旋松针杆连接柱紧固螺钉①。

2.使针杆②上的刻线A对准针杆下轴套③的下端,然后旋紧针杆连接柱紧固螺钉①。

3.旋松3颗旋梭紧固螺钉并转动上轮,使针杆②的上刻线B对准针杆下轴套③的下端。

4.移动旋梭使旋梭的勾线尖⑤对准机针④的缺口处并使机针④的缺口处与旋梭的勾线尖⑤间隙为0.04~0.1mm,然后拧紧旋梭紧固螺钉。

1.Turn the upper wheel to allow the needle bar to reach its lowest point, and unscrew trip bolt ① of needle bar joint pin.

2.Align graduation line A on needle bar ② to the lower end of lower shaft sleeve ③ of needle bar, and screw down tightening screw ① of needle bar joint pin.

3.Unscrew 3 tightening screws of rotating hook, turn the upper wheel, and align graduation line B on needle bar ② to the lower end of lower shaft sleeve ③ of needle bar.

4.Move the rotating hook such that its thread hooking tip is aligned to the notch on needle ④, ensure that the clearance between notch on needle ④ and thread hooking tip ⑤ ranges from 0.04 to 0.1mm, and screw down the tightening screw of rotating hook.



注意:

1.为了防止缝纫机的意外启动,请关掉



电源之后再进行操作。

2.若机针④的缺口处与旋梭勾线尖⑤的间隙过小,会磨损旋梭梭尖;若间隙过



Caution:

1.To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.



大，会引起跳动针。

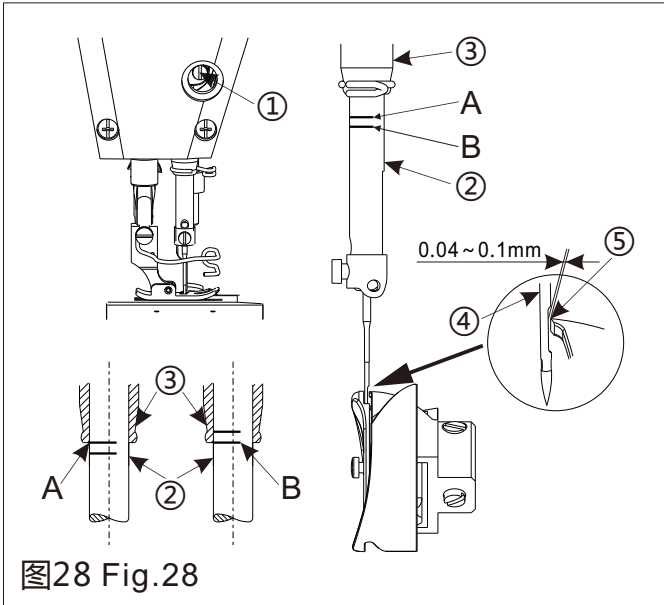


图28 Fig.28

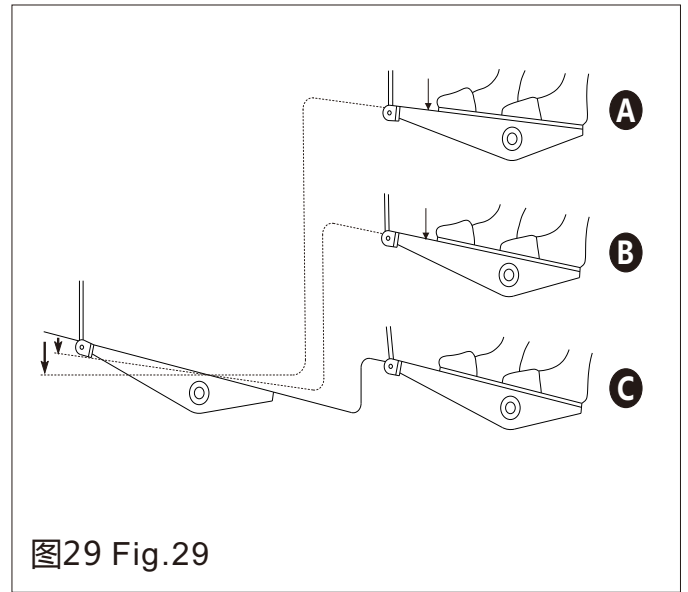


图29 Fig.29

24 踏板的操作 (图29) Operating the Treadle (Fig. 29)

1. 踏板有4级操作：

- 1) 向前轻踩踏板为低速缝纫(图示B)。
- 2) 再用力向前踩踏板则变为高速缝纫(图示A)。
- 3) 当脚不向踏板施力，则踏板回复到原始状态时，缝纫机停止运转(机针在上停针或下停针位置)(图示C)。

1. The treadle has 4 operation levels:

- 1) The machine runs at low sewing speed when you lightly depress the front part of the pedal. (as show in the picture B)
- 2) The machine runs at high sewing speed when you further depress the front part of the pedal. (as show in the picture A)
- 3) Penal back to the initial position when stop stepping on it and the machine stop working. (needle in the upper or down position) (as show in the picture C)

25 踏板的压力与行程 (图30) Pedal Pressure and Pedal Stroke (Fig.30)



注意:

1. 为了防止缝纫机的意外启动，请关掉



电源之后再进行操作。



Caution:

1. To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.



1. 踏板踩踏压力的调整

- 1) 摘下踏板压力调节弹簧①进行调节。
- 2) 把弹簧挂到左侧压力变小。
- 3) 把弹簧挂到右侧压力变大。

2. 踏板反踏力的调整

- 1) 用反踏调节螺钉②进行。
- 2) 旋紧调节螺钉，返踏力变大。

1. Adjusting the pressure required to depress the front part of the pedal.

- 1) This pressure can be changed by altering the mounthing position of pedaling pressure adjust spring①.
- 2) The pressure decreases when you hook the spring on the left side.
- 3) The pressure increases when you hook the spring on the right side.

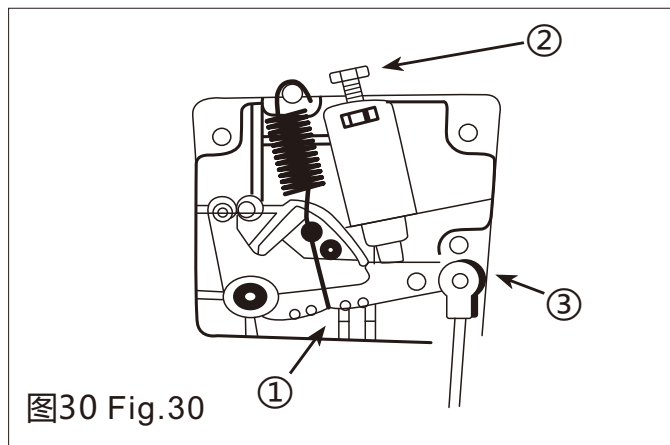
2. Adjusting the pressure required to depress

3) 旋松调节螺钉，返踏力变小。

3. 踏板踩踏行程的调整

1) 把连杆安装在左侧孔内，行程变小。

2) 反之行程变大。



the back part of the pedal

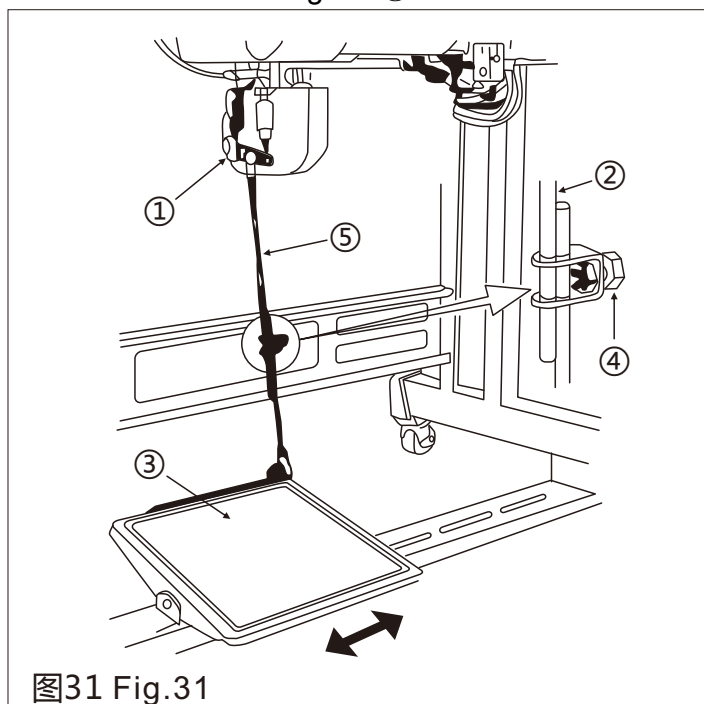
1) This pressure can be adjusted using regulator screw ②.

2) The pressure increases as you turn the regulator screw in.

3) The pressure decreases as you turn the screw out.

3. Adjusting the pedal stroke

1) The pedal stroke decreases when you insert connecting rod ③ into the left hole.



26 踏板的调整 (图31) Adjustment of the Pedal (Fig. 31)



注意:

1. 为了防止缝纫机的意外启动，请关掉



电源之后再进行操作。



Caution:

1. To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.



1. 拉杆位置的调整

1) 左右移动踏板调节板，将踏板曲柄 ①和拉杆部件②垂直连接。

2. 踏板角度的调整

1) 踏板的倾斜，可以根据拉杆长度的调节自由改变。

2) 旋松螺钉④，就可以调节拉杆②的长度。

1. Installing the connecting rod

1) Move pedal to the right or left as illustrated by the arrows so that motor control lever and connecting rod are straightened.

2. Adjusting the pedal angle

1) The pedal tilt can be freely adjusted by changing the length of the connecting rod.

2) Loosen adjust screw, and adjust the length of connecting rod.

目 录

CONTENTS

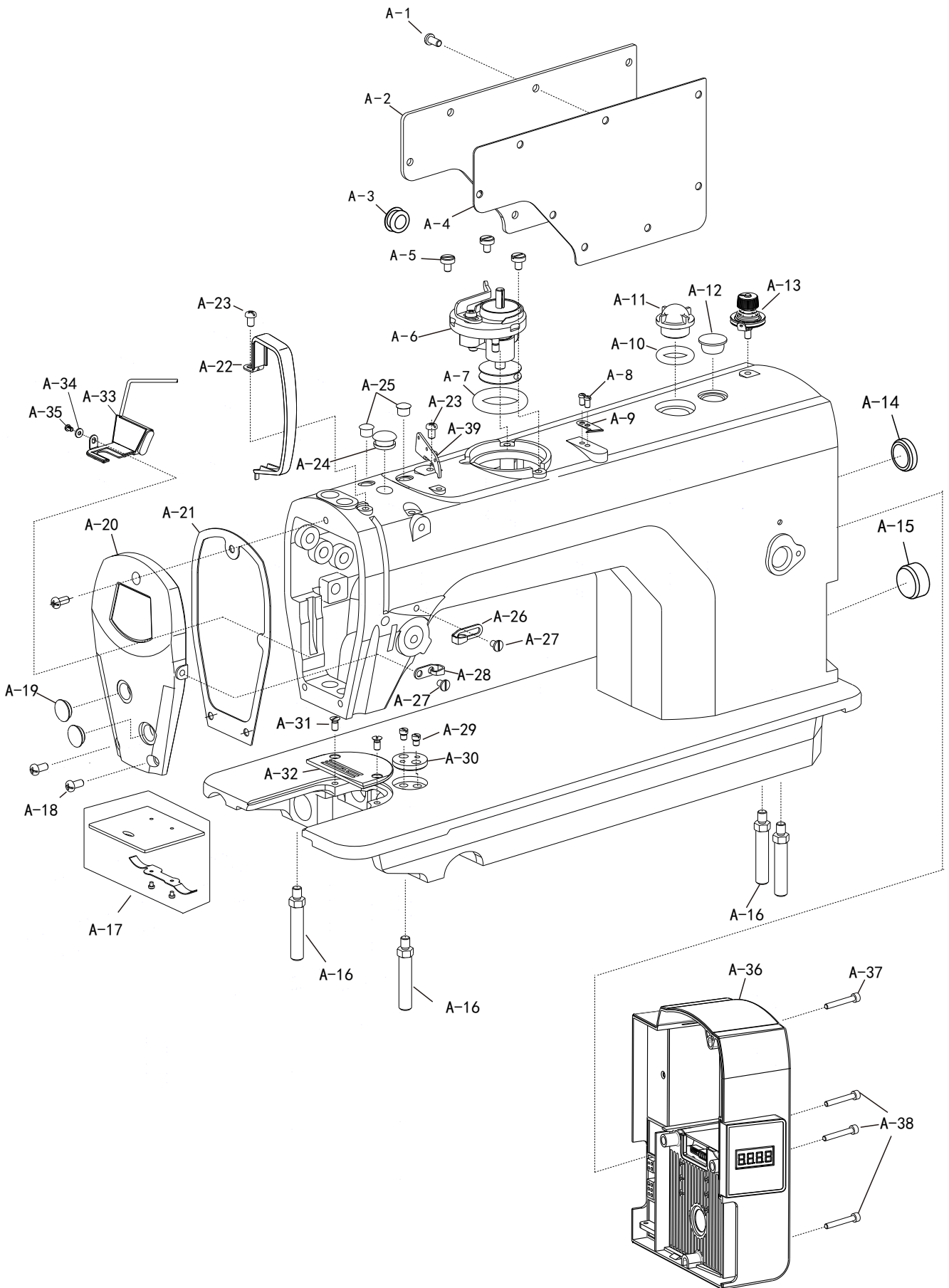
零件样本 Parts Book

A	机壳分组件 Machine Frame & Miscellaneous Cover Components	1
B	上轴、挑线分组件 Main Shaft & Thread Take-up Cover Components	3
C	针杆、夹线分组件 Needle bar & thread tension components	5
D	压料、松线分组件 Presser bar & tension release components	7
E	钩线分组件 Hook of driving shaft components	9
F	送料分组件 Feed mechanism components	11
G	润滑分组件 Lubrication Components	14
H	油盘、膝抬压脚分组件 Presser Foot Components Of Oil Plate Knee Lift	16
I	过线架分组件 Components Of Thread-running Stand	18
J	附件 Auxiliaries	20

A

机壳分组件

Machine frame&miscellaneous cover components

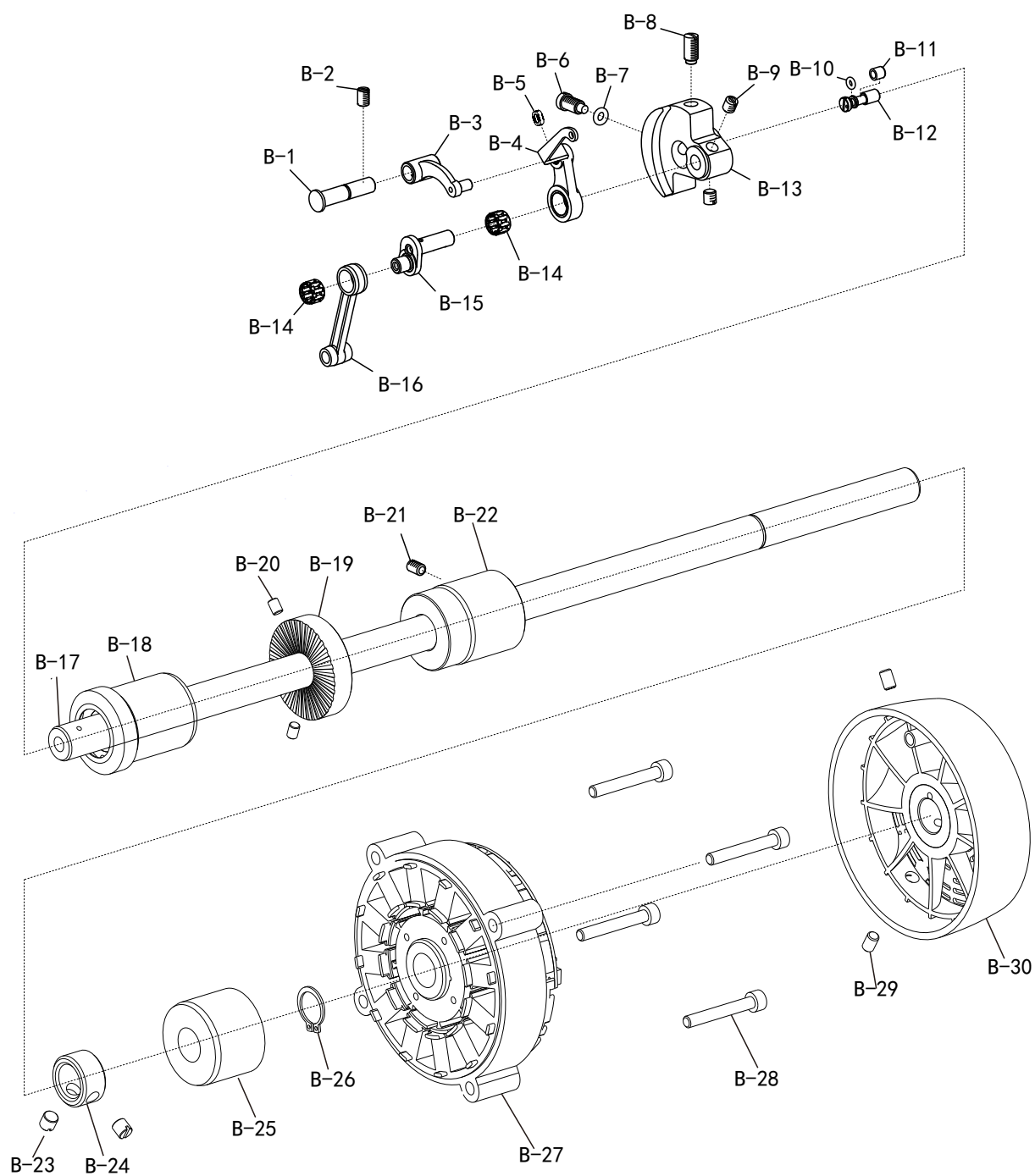


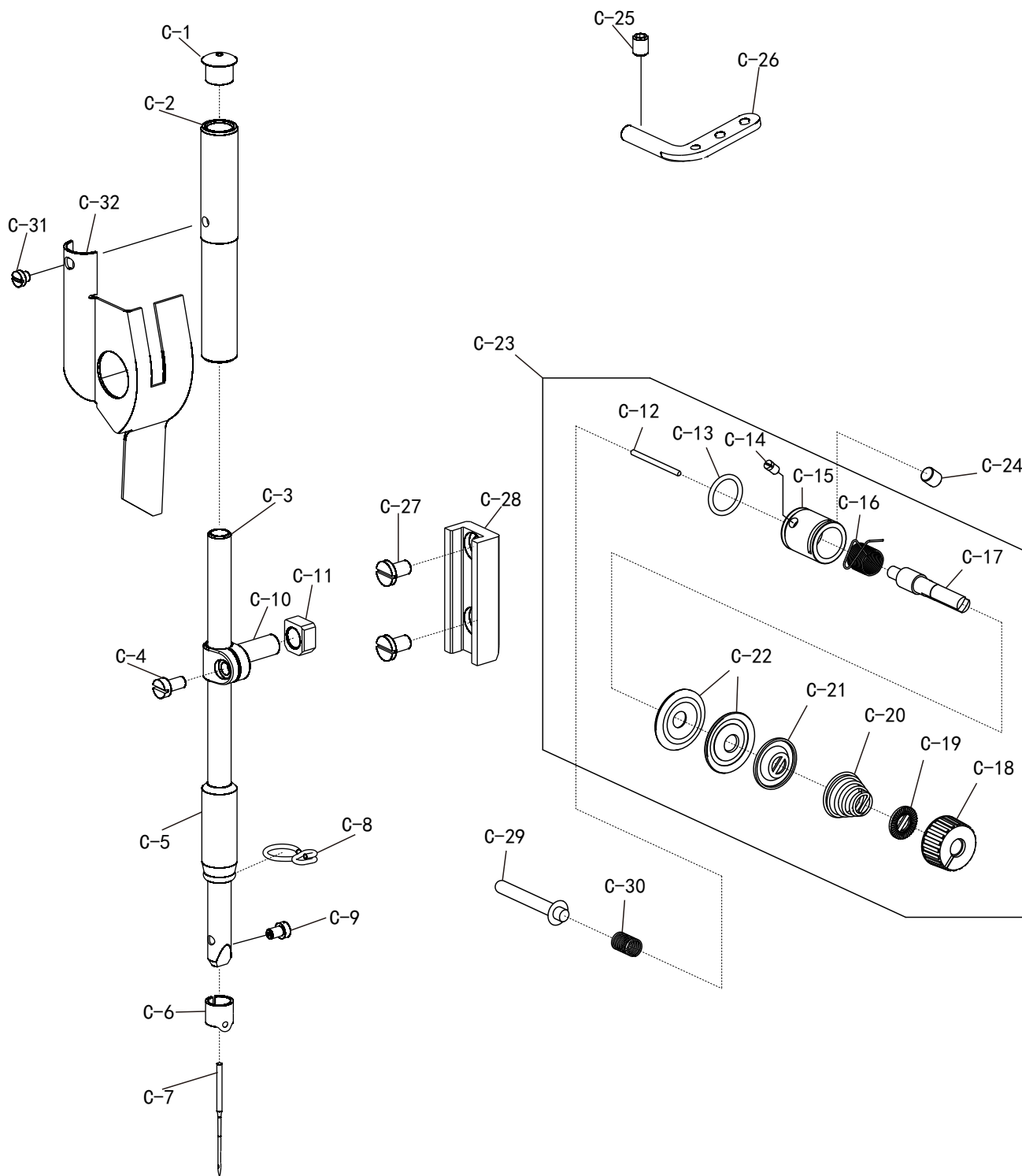
A

机壳分组件

Machine frame&miscellaneous cover components

序号 Ref.No.	物料号 Part.No.	名称	Description	数量 Q'ty	备注 Remark
A-1	10008972	螺钉	Screw	8	
A-2	20003774	后窗板	Side plate	1	
A-3	10008977	橡胶塞	Rubber plug	1	
A-4	10010877	后窗板垫	Side plate gasket	1	
A-5	10004380	螺钉	Screw	3	
A-6	10031086	绕线器	Bobbin wider ASM.	1	
A-7	10008773	橡胶轮	Rubber ring	1	
A-8	10050423	螺钉	Screw	2	
A-9	10011149	绕线切刀	Thread cutter	1	
A-10	10008939	O形圈	O-ring	1	
A-11	10008938	油窗	Oil window	1	
A-12	10009576	橡胶塞	Rubber plug	1	
A-13	10034382	绕线夹线器	Bobbin thread tension ASM.	1	
A-14	10008975	橡胶塞	Rubber plug	1	
A-15	10008941	橡胶塞	Rubber plug	1	
A-16	10002577	底板支柱	Bed screw stud	4	
A-17	10013706	推板部件	Side plate ASM.	1	
A-18	10008972	螺钉	Screw	3	
A-19	10008977	橡胶塞	Rubber plug	2	
A-20	20013583	面板	Face Plate	1	
A-21	10039362	面板垫	Face Plate Packing	1	
A-22	10014082	挑线杆防护罩	Thread take-up lever cover	1	
A-23	10008934	螺钉	Screw	2	
A-24	10008942	橡胶塞	Rubber plug	1	
A-25	10008943	橡胶塞	Rubber plug	2	
A-26	10008940	右线钩	Arm thread guide right	1	
A-27	10008973	螺钉	Screw	2	
A-28	10008937	左线钩	Arm thread guide left	1	
A-29	10004374	螺钉	Screw	2	
A-30	10004373	限位挡片	Ruler plate	1	
A-31	10009005	螺钉	Screw	2	
A-32	10026544	针板	Needle plate	1	
A-32	10005917	针板	Needle plate	1	-5
A-32	10008039	针板	Needle plate	1	S7
A-33	10053207	点动补针组件	The jog fill needle components	1	
A-34	10011168	垫片4.8	Washer 4.8	1	
A-35	10008934	SM3/16"×28螺钉	Screw SM3/16"×28	1	
A-36	10053206	一体式电控	Integrated electric control	1	
A-37	10012080	M4×20螺钉	Screw M4×20	1	
A-38	10049837	M5×35螺钉	Screw M5×35	3	
A-38	10052992	过线板	Thread tension guide	1	







针杆、夹线分组件

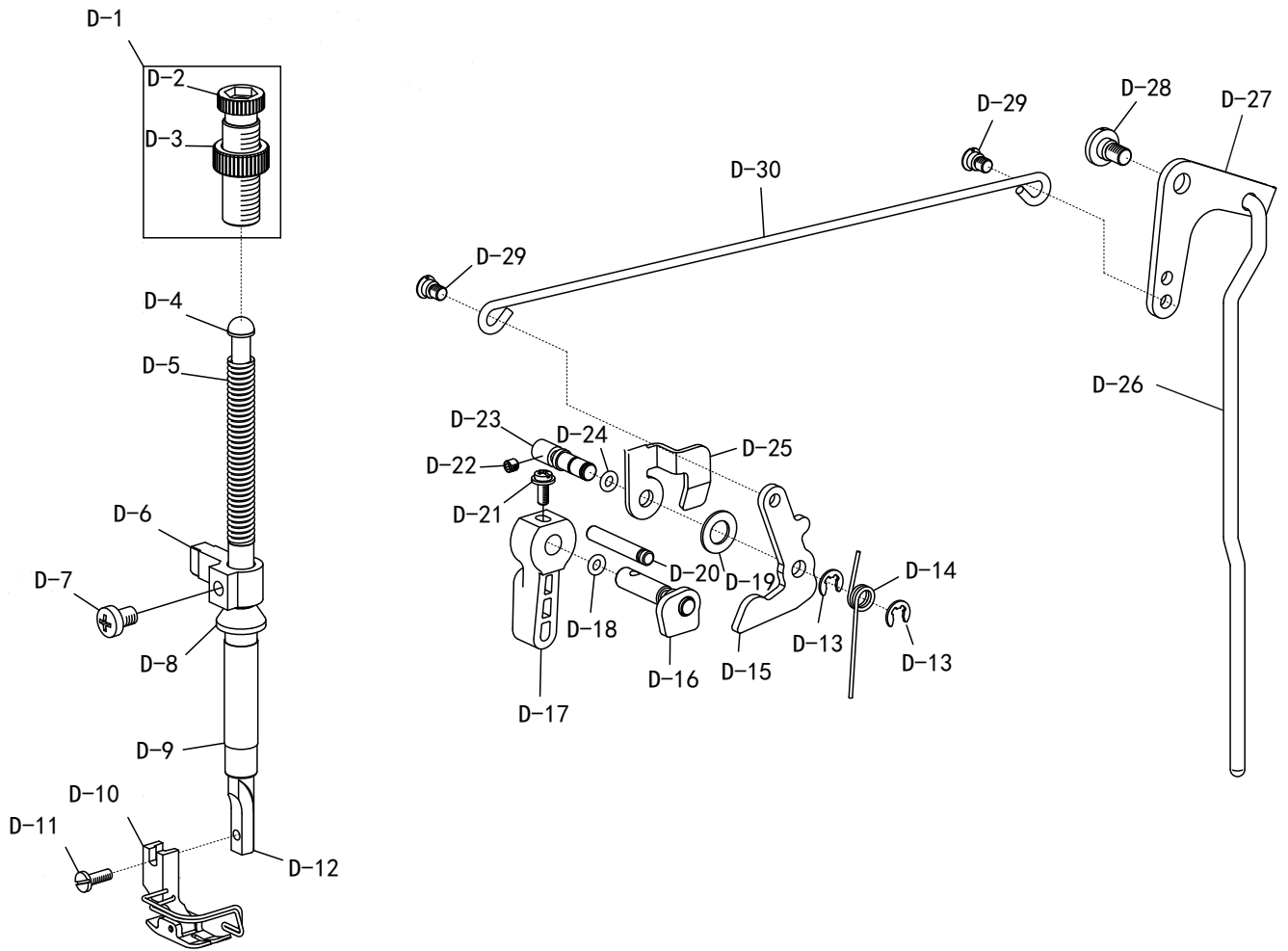
Needle bar & thread tension components

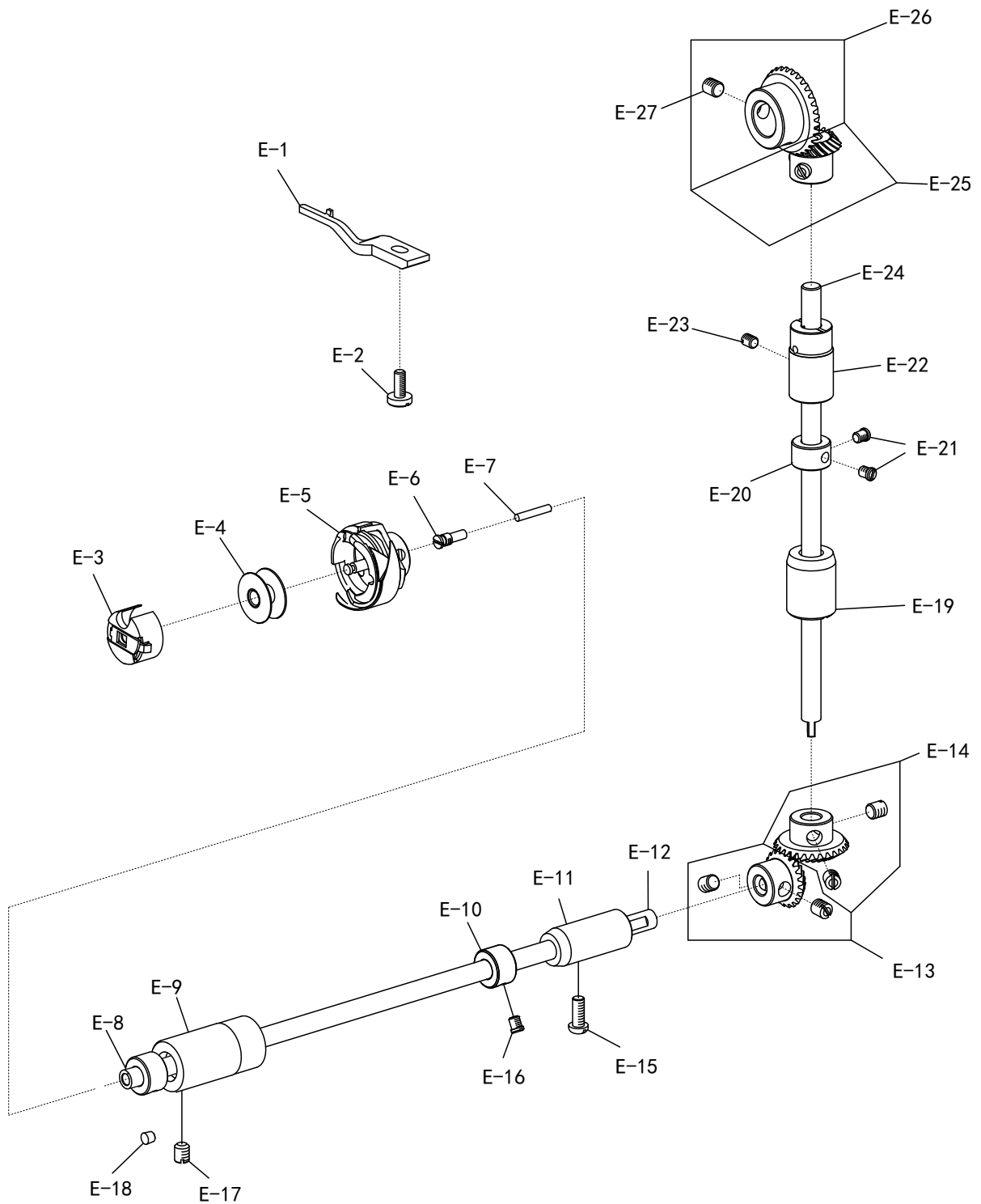
序号 Ref.No.	物料号 Part.No.	名称	Description	数量 Q'ty	备注 Remark
C-1	10010587	橡胶塞	Rubber plug	1	
C-2	10011063	针杆上轴套	Bearing support	1	
C-3	10041608	针杆	Needle bar	1	
C-3	10041609	针杆	Needle bar	1	-5
C-4	10030286	螺钉	Screw	1	
C-5	10014117	针杆下轴套	Bearing support	1	
C-5	10005916	针杆下轴套	Bearing support	1	-5
C-6	10005943	针杆下轴套线钩	Needle bar thread guide	1	
C-7	10003468	机针	Needle DB×1 14#	1	
C-7	10003634	机针	Needle DP×5 21#	1	-5
C-8	10010591	针杆线钩	Needle bar thread guide	1	
C-8	10005943	针杆线钩	Needle bar thread guide	1	-5
C-9	10010588	支针螺钉	Screw	1	
C-10	10052735	针杆连接柱	Needle bar holder	1	
C-11	10052734	针杆连接柱滑块	Slide block	1	
C-12	10004184	松线钉	Thread release pin	1	
C-13	10004183	O形圈	O-ring	1	
C-14	10004200	螺钉	Screw	1	
C-15	10039524	挑线簧调节座	Tension post socket	1	
C-16	10004201	挑线簧	Spring	1	
C-17	10004177	夹线螺钉	Screw	1	
C-18	10012981	夹线螺母	Nut	1	
C-19	10004199	夹线制动板	Tension disc stopper	1	
C-20	10004176	夹线簧	Spring	1	
C-20	10005941	夹线簧	Spring	1	
C-21	10004179	松线板	Thread release disc	1	
C-22	10004180	夹线板	Tension disc holder	2	
C-23	10041354	夹线器	Thread take-up device	1	
C-23	10041543	夹线器	Thread take-up device	1	-5
C-24	10006264	螺钉	Screw	1	
C-25	10008934	螺钉	Screw	1	
C-26	10010640	三眼线钩	Three-hole thread eyelet	1	
C-27	10010308	螺钉	Screw	1	
C-28	10053109	导轨	Screw	1	
C-29	10012140	松线辅钉	Tension release supporting pin	1	
C-30	10010642	弹簧	Spring	1	

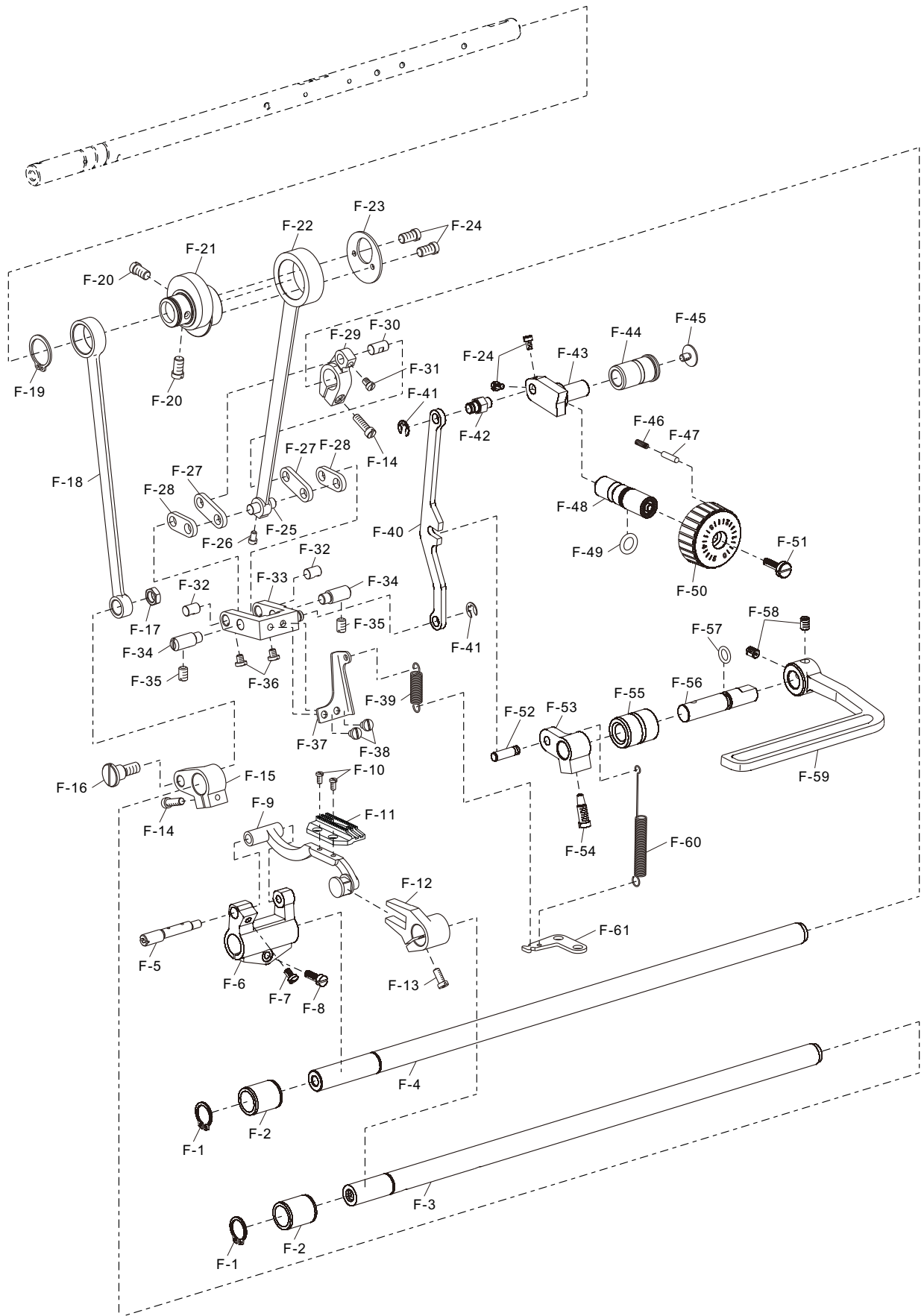
D

压料、松线分组件

Presser bar & tension release components







F

送料分组件

Feed mechanism components

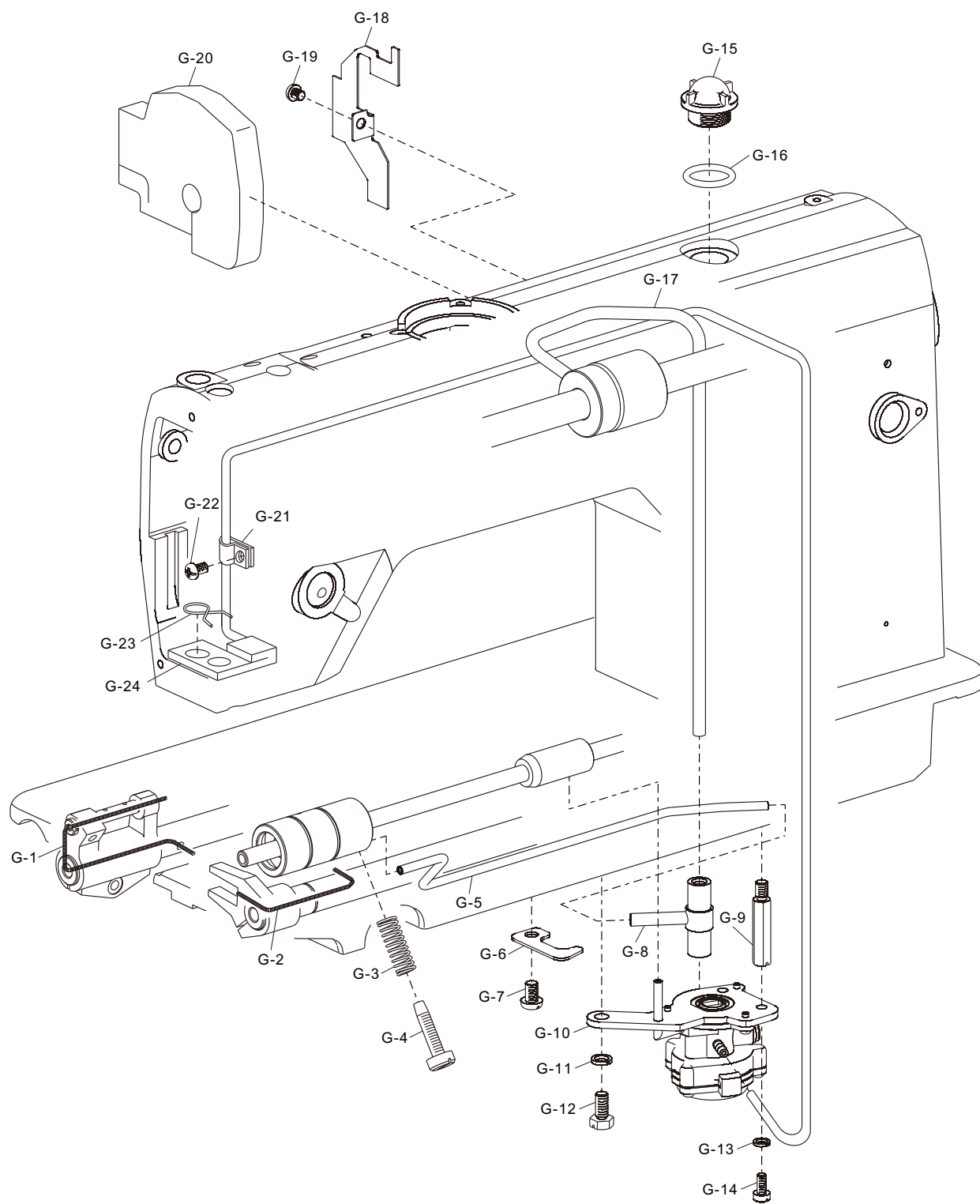
序号 Ref.No.	物料号 Part.No.	名称	Description	数量 Q'ty	备注 Remark
F-1	10010090	13.8×1挡圈	Closing ring 13.8×1	2	
F-2	10014116	送料抬牙轴轴套	Shaft sleeve	2	
F-3	10010097	抬牙轴	Feed driving shaft	1	
F-4	10010073	送料轴	Feed rocker shaft	1	
F-5	10004440	牙架座偏心销	Pin	1	
F-6	10004474	牙架座	Feed bar driving crank	1	
F-7	10010074	SM11/64"×40螺钉	Screw SM11/64"×40	1	
F-8	10004993	SM3/16"×28螺钉	Screw SM3/16"×28	1	
F-9	20001665	牙架部件	Feed bar ASM.	1	
F-10	10010099	SM1/8"×44螺钉	Screw SM1/8"×44	2	
F-11	10026545	送料牙	Feed dog	1	
F-11	10006005	送料牙	Feed dog	1	-5
F-11	10026357	送料牙	Feed dog	1	S7
F-12	10042079	抬牙叉形曲柄组件	Crank	1	
F-12	10043177	抬牙叉形曲柄组件	Crank	1	S7
F-13	10004628	SM11/64"×40螺钉	Screw SM11/64"×40	1	
F-14	10010095	SM3/16"×28螺钉	Screw SM3/16"×28	2	
F-15	10010086	抬牙后曲柄	Crank	1	
F-16	10010091	抬牙连杆轴位螺钉	Screw	1	
F-17	10004475	SM9/32"×28螺母	Nut SM9/32"×28	1	
F-18	10010084	抬牙连杆	Connecting rod	1	
F-19	10010089	18.5×1.2挡圈	Closing ring 18.5×1.2	1	
F-20	10010092	SM1/4"×40螺钉	Screw SM1/4"×40	2	
F-21	10010115	送料偏心轮	Feed drive eccentric cam	1	
F-21	10005991	送料偏心轮	Feed drive eccentric cam	1	S7
F-22	10010072	送料连杆	Connecting rod	1	
F-22	10006004	送料连杆	Connecting rod	1	S7
F-23	10010098	送料偏心轮盖板	Thrust cover	1	
F-23	10005992	送料偏心轮盖板	Thrust cover	1	S7
F-24	10010643	SM9/64"×40螺钉	Screw SM9/64"×40	4	
F-25	10010069	送料连杆销	Pin	1	
F-26	10010071	SM9/64"×40螺钉	Screw SM9/64"×40	1	
F-27	10010068	送料长摆动板	Connecting plate	2	
F-28	10010075	送料短摆动板	Connecting plate	2	
F-29	10010076	送料曲柄	Crank	1	
F-30	10010096	送料曲柄销	Pin	2	
F-31	10013015	SM11/64"×40螺钉	Screw SM11/64"×40	1	
F-32	10010087	短摆动板连接销	Pin	2	
F-33	10010088	送料摆动板座部件	Feed adjusting ASM.	1	
F-33	10028750	送料摆动板座部件	Feed adjusting ASM.	1	
F-34	10010102	送料摆动板座左右销	Pin	2	

F

送料分组件

Feed mechanism components

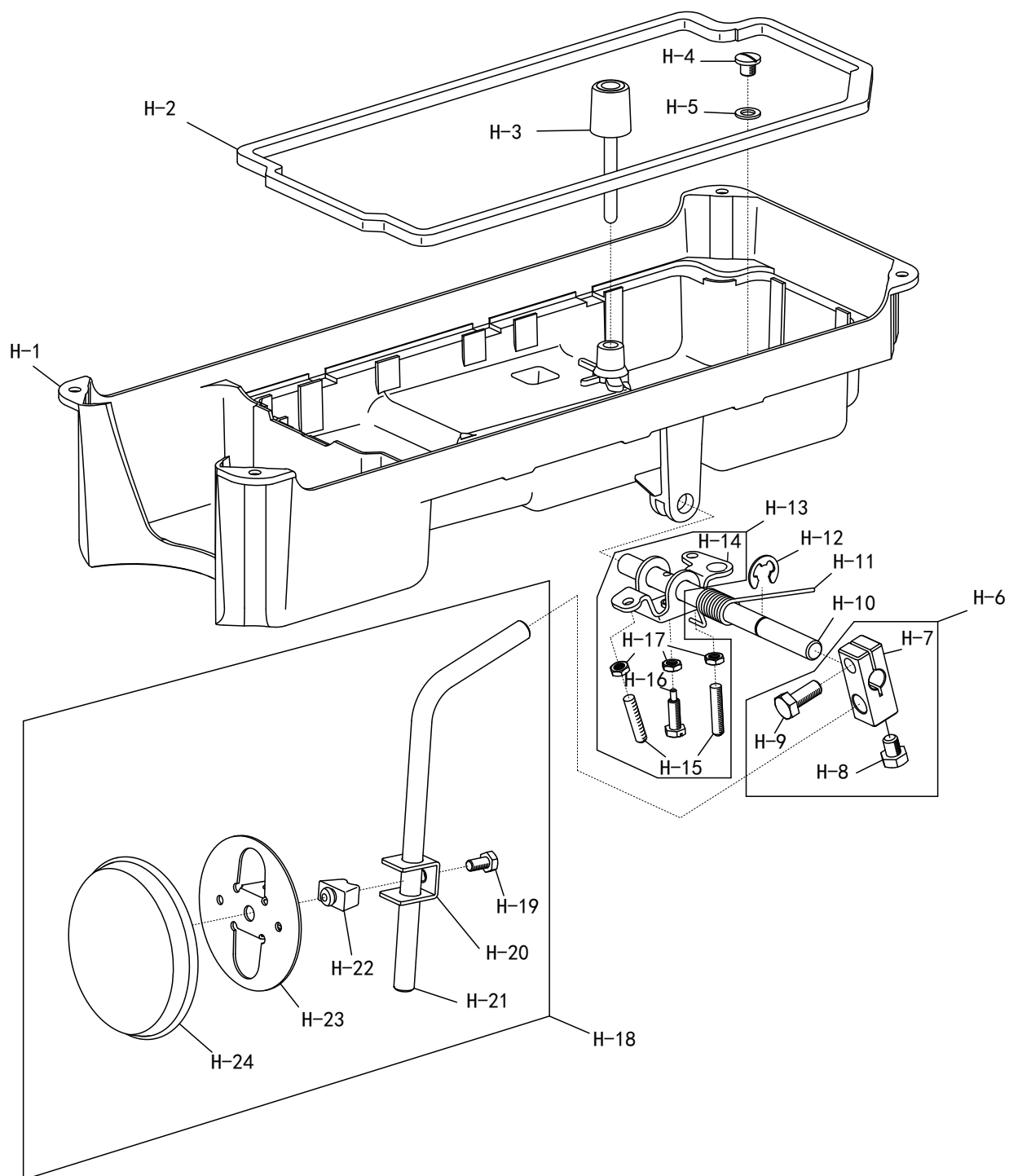
序号 Ref.No.	物料号 Part.No.	名称	Description	数量 Q'ty	备注 Remark
F-35	10010506	SM15/64"×28螺钉	Screw SM15/64"×28	2	
F-36	10010197	SM9/64"×40螺钉	Screw SM9/64"×40	2	
F-37	10010282	摆动板座复位板	Plate	1	
F-38	10010285	SM11/64"×40螺钉	Screw SM11/64"×40	2	
F-39	10010284	摆动板座复位簧	Spring	1	
F-39	10012990	摆动板座复位簧	Spring	1	-5/S7
F-40	10010283	倒送料连杆	Feed adjust rod	1	
F-40	10037069	倒送料连杆	Feed adjust rod	1	S7
F-41	10010649	5.1×0.6挡圈	Closing ring 5.1×0.6	2	
F-42	10010288	倒送料连杆销	Pin	1	
F-43	10010242	送料调节器	Feed regulator	1	
F-43	10027597	送料调节器	Feed regulator	1	S7
F-44	10014120	送料调节器轴套	Shaft sleeve	1	
F-45	10010238	螺钉	Screw	1	
F-46	10013869	旋钮锁簧	Spring	1	
F-47	10013870	旋钮锁销	Pin	1	
F-48	10011025	送料调节螺柱	Screw	1	
F-49	10010240	9.2×2.7 O形圈	O-ring 9.2×2.7	1	
F-50	10035275	送料距旋钮	Feed dial	1	
F-50	10027596	送料距旋钮	Feed dial	1	S7
F-51	10010281	SM3/16"×28螺钉	Screw SM3/16"×28	1	
F-52	10010287	倒送料曲柄销	Pin	1	
F-53	10053108	倒送料曲柄	Crank	1	
F-53	10031548	倒送料曲柄	Crank	1	S7
F-54	10010236	倒送料曲柄螺钉	Screw	1	
F-55	10014119	倒送料轴轴套	Shaft sleeve	1	
F-56	10010241	倒送料轴	Reverse feed shaft	1	
F-57	10010243	7.8×2 O形圈	O-ring 7.8×2	1	
F-58	10040504	M6螺钉	Screw M6	2	
F-59	20003459	倒送料扳手	Reverse feed control lever	1	
F-60	10010237	倒送料拉簧	Spring	1	
F-60	10012991	倒送料拉簧	Spring	1	-5/S7
F-61	10010235	拉簧固定板	Plate	1	
F-61	10012987	拉簧固定板	Plate	1	-5/S7





油盘、膝抬压脚分组件

Presser foot components of oil plate knee lift





润滑分组件
Lubrication Components

序 号 Ref.No.	物料号 Part.No.	名 称	Description	数量 Q'ty	备 注 Remark
G-1	10008067	φ2油线(430mm)	Oil wick(430mm)	1	
G-2	10008067	φ2油线(400mm)	Oil wick(400mm)	1	
G-3	10010341	旋梭油量调节簧	Spring	1	
G-4	10010344	旋梭油量调节螺钉	Screw	1	
G-5	10010345	旋梭供油管	Oil tube	1	
G-6	10010295	旋梭供油管压板	Pressing plate	1	
G-7	10010292	SM15/64"×28螺钉	Screw SM15/64"×28	2	
G-8	10010340	供油管接头	Oil connection	1	
G-9	10010293	油泵连接螺柱	Screw	1	
G-10	10008817	油泵部件	Oil pump ASM.	1	
G-11	10003077	弹簧垫圈6	Washer 6	1	
G-12	10050422	SM15/64"×28螺钉	Screw SM15/64"×28	1	
G-13	10005537	弹簧垫圈5	Washer 5	1	
G-14	10010066	SM11/64"×40螺钉	Screw SM11/64"×40	1	
G-15	10008938	油窗	Oil sight window	1	
G-16	10008939	19×3 O形圈	O-ring 19×3	1	
G-17	10023807	上轴供油管	Oil tube	1	
G-18	10010898	隔油板	Oil stoper	1	
G-19	10010899	SM3/16"×28螺钉	Screw SM3/16"×28	1	
G-20	10014197	挡油海绵	Foam rubber	1	
G-21	10004476	回油管夹	Holder	1	
G-22	10008934	SM3/16"×28螺钉	Screw SM3/16"×28	1	
G-23	10010294	回油毛毡夹	Oil felt preser	1	
G-24	20000778	回油管组件	Oil return tube ASM.	1	

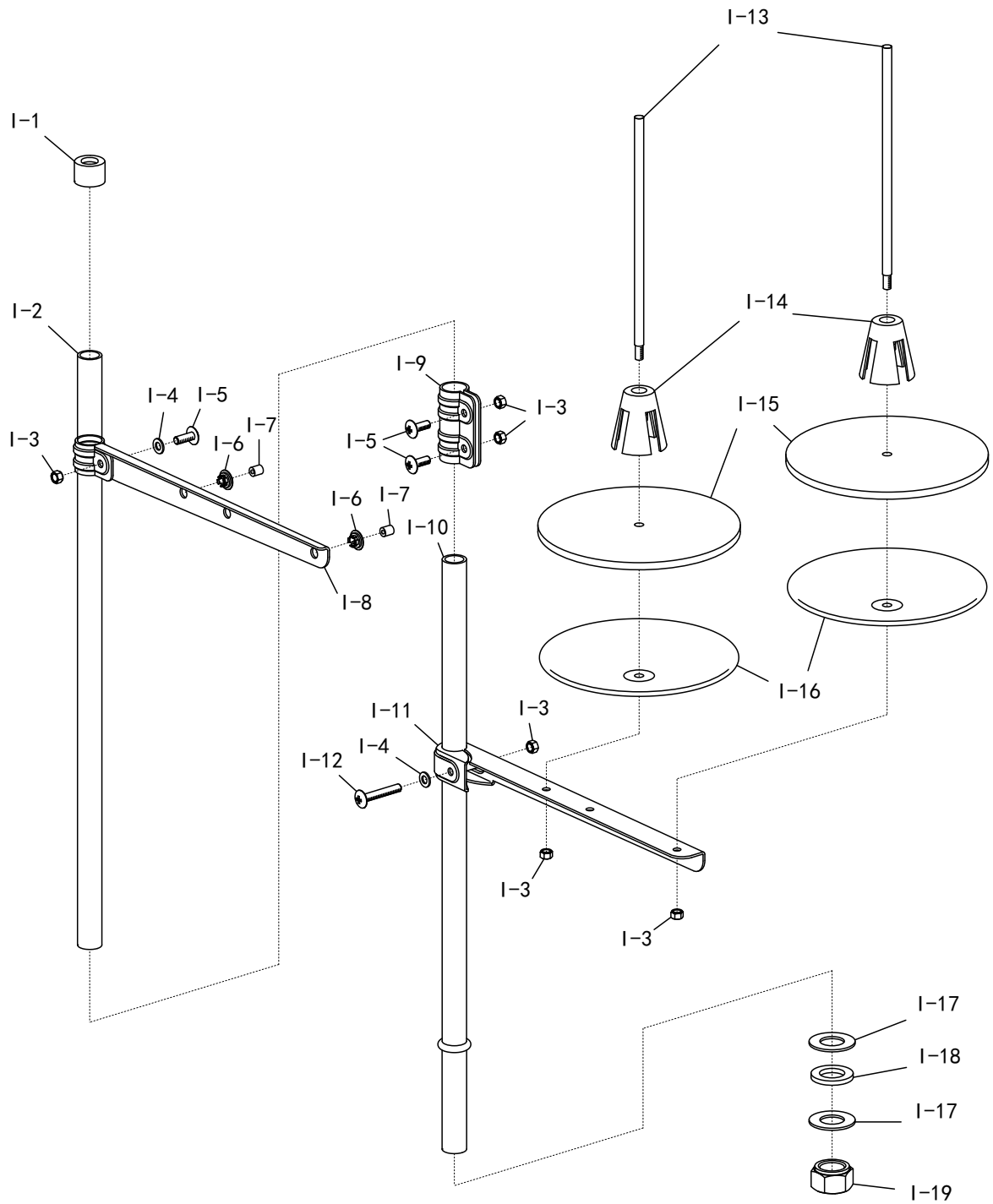


油盘、膝抬压脚分组件

Presser foot components of oil plate knee lift

序号 Ref.No.	物料号 Part.No.	名称	Description	数量 Q'ty	备注 Remark
H-1	10008313	油盘	Oil reservoir	1	
H-2	10014194	油盘垫	Oil reservoir gasket	1	
H-3	10009984	抬压脚顶销	Pin	1	
H-4	10009991	螺钉	Screw	1	
H-5	10009988	垫圈	Rubber ring	1	
H-6	10002562	操纵杆接头组件	Bracket ASM.	1	
H-7	10003896	操纵杆接头	Bracket	1	
H-8	10002610	螺钉	Screw	1	
H-9	10002613	螺钉	Screw	1	
H-10	10003899	抬压脚轴	Knee pressing shaft	1	
H-11	10003893	弹簧	Spring	1	
H-12	10002559	挡圈	Snap ring	1	
H-13	10002563	抬压脚双向曲柄部件	Crank ASM.	1	
H-14	10009987	抬压脚双向曲柄	Crank	1	
H-15	10003895	螺钉	Screw	2	
H-16	10003898	螺钉	Screw	1	
H-17	10003890	螺母	Nut	3	
H-18	10009985	操纵杆部件	Knee pressing plate ASM.	1	
H-19	10003894	螺钉	Screw	1	
H-20	10003897	操纵杆接头	Knee pressing plate holder	1	
H-21	10003901	操纵杆	Knee pressing plate rod	1	
H-22	10003900	操纵杆垫	Knee pressing plate rubber	1	
H-23	10003891	操纵板	Knee pressing plate	1	
H-24	10004223	操纵板软垫	Knee pressing cover	1	

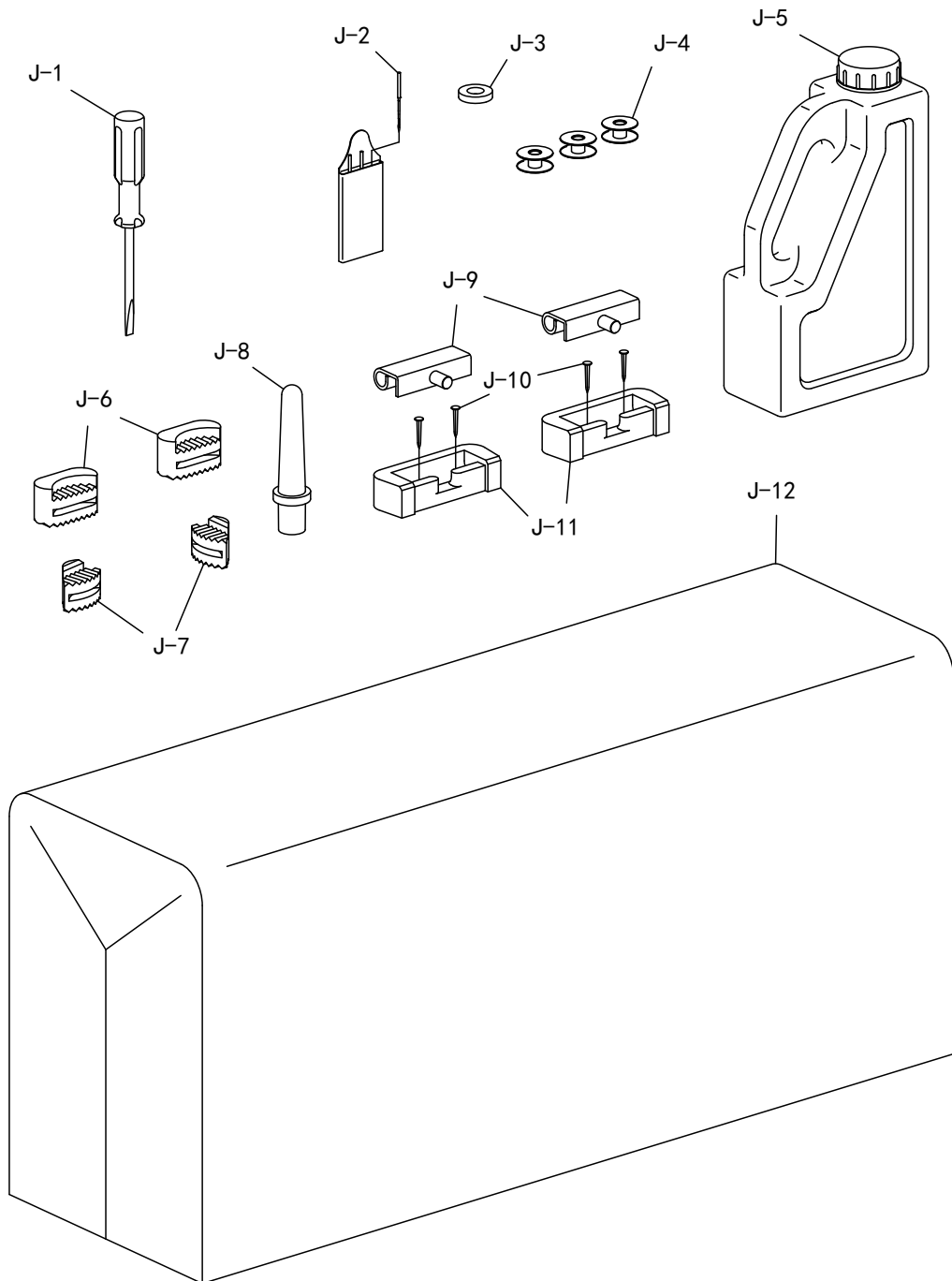
I 过线架分组件
Components of thread-running stand



I 过线架分组件

Components of thread-running stand

序号 Ref.No.	物料号 Part.No.	名称	Description	数量 Q'ty	备注 Remark
I-1	10004282	撑管套	Column cap	1	
I-2	10004293	线架上撑管	Column pipe (upper)	1	
I-3	10002953	螺母	Nut	6	
I-4	10003022	垫圈	Washer	2	
I-5	10003301	螺钉	Screw	3	
I-6	10004285	过线管套	Thread guide bushing	2	
I-7	10004289	过线管	Thread guide pipe	2	
I-8	10004298	上过线架	Thread hanger (upper)	1	
I-9	10004286	撑管夹	Column pipe connector	1	
I-10	10004291	线架下撑管	Column pipe (lower)	1	
I-11	10004284	下过线架	Thread hanger (lower)	1	
I-12	10003312	螺钉	Screw	1	
I-13	10004288	线轴	Spool pin	2	
I-14	10004287	线盘塑料压块	Spool cushion	2	
I-15	10004281	线盘软垫	Spool mat	2	
I-16	10004299	线盘	Spool seat disc	2	
I-17	10004290	垫圈	Washer	2	
I-18	10004295	垫圈	Washer	1	
I-19	10002985	螺母	Nut	1	
				1	



J

附件 Accessories

序 号 Ref.No.	物料号 Part.No.	名 称	Description	数量 Q'ty	备 注 Remark
J-1	10010995	中螺丝刀	Screw driver	1	
J-2	10003468	DB×1 14#飞虎机针	Needle	3	
J-2	10003634	DP×5 21#飞虎机针	Needle	3	-5
J-3	10003892	油盘磁铁	Oil reservoir magnet	1	
J-4	10010060	梭芯	Screw	3	
J-5	10004455	油箱部件	Oil bottle with oil	1	
J-6	10009986	油盘支座	Oil reservoir seat	2	
J-7	10009993	油盘座垫	Oil reservoir cushion	2	
J-8	10004466	机头连接钩部件	Head connecting hook	2	
J-9	10003889	机头连接钩座钉	Nail	4	
J-11	10011041	机头连接钩座	Head connecting hook socket	2	
J-12	10008849	机头罩	Head cover	1	



浙江中捷缝纫科技有限公司
ZOJE SEWING MACHINE CO., LTD.

地址：浙江省玉环县大麦屿开发区
Add: damaiyu Development Zone, Yuhuanxian, Zhejiang 317604, China
国内营销中心：Domestic Business Center
Tel: 0576-87338345 87338215 Fax: 0576-87338222
国际营销中心：International Business Center
Tel: +86-576-87333222 87338299 Fax: +86-576-87332702
www.zoje.com E-mail: sales@zoje.com

27 手触补针装置的法 (图32) The Usage of Manually Fill Needle Device(Fig. 32)

1.补针按键的使用方法

按一下补针按钮①缝纫机则作往前补半针，一直按着缝纫机则作连续往前补针。

注意：补针按钮①可在连续回缝除外，任何一种车缝中途停止时使用(未切线时)。

2.照明灯控制按钮的使用方法

开机后照明灯会全亮度打开，按动照明灯控制按钮②，灯的亮度会依次减弱，直至关闭，依次循环。

1.Use of reinforce sewing

Press the reinforce sewing button ①one time, the sewing machine reinforce forth with half stitch, press all the time, it continues sewing with forth reinforce.

Caution:in addition to continue back reinforce sewing,the reinforce sewing bouton can be as stop button ①during any sewing condition.(before trimming)

2.Use of the light push-button

The illuminating lamp goes on at full brightness once the machine is powered on. Push illuminating lamp control button ②to reduce in sequence the brightness till turn off.

