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第一部分
操作說明

OPERATION INSTRUCTION

1. 技術數據 Specifications

綫迹形式 Stitch type.....	301 (鎖式綫迹 Lockstitch) 在
滾輪壓脚下通過高度 Clearance under roller presser.....	7mm 空間寬度 Clearance
width.....	245mm 空間高度 Clearance
height.....	115mm 柱式底板高度 Post
height.....	180mm

縫細機機頭尺寸 Sewing head dimensions

長度 Length.....	大約 /approx.615mm 寬
度 Width.....	大約 /approx.240mm 高
度 (臺板以上) Height (above table)	大約 /approx.500mm 底
板尺度 Bedplate dimensions.....	518X177mm

機型分類 Type

單針和雙針 Single needle and double needle

A 型 model A..... 適用於縫劍輕薄型材料 For sewing lightweight materials

B 型 model B..... 適用於縫朝中等厚度材料 For sewing medium-weight materials C 型 model

C..... 適用於縫細厚材料 For sewing medium-heavy materials

縫細綫規格 Nm (最大) Thread thickness Nm (max.synthetic)

A 型 model A.....	60/3
B 型 model B.....	41/3
C 型 model C.....	15/3

機針型號 Needle model

A 型單針 Model A single needle.....	70/134
B 型單針 Model B single needle.....	90/134
B 型雙針 Model B double needle.....	90/134-35
C 型單針 Model C single needle.....	120/134
C 型雙針 Model C double needle.....	120/134-3 5

最高速度 Max.speed

A、B 型.....	3000 綫迹/分/spm
C 型.....	2000 綫迹/分/spm

2. 安裝 Installation

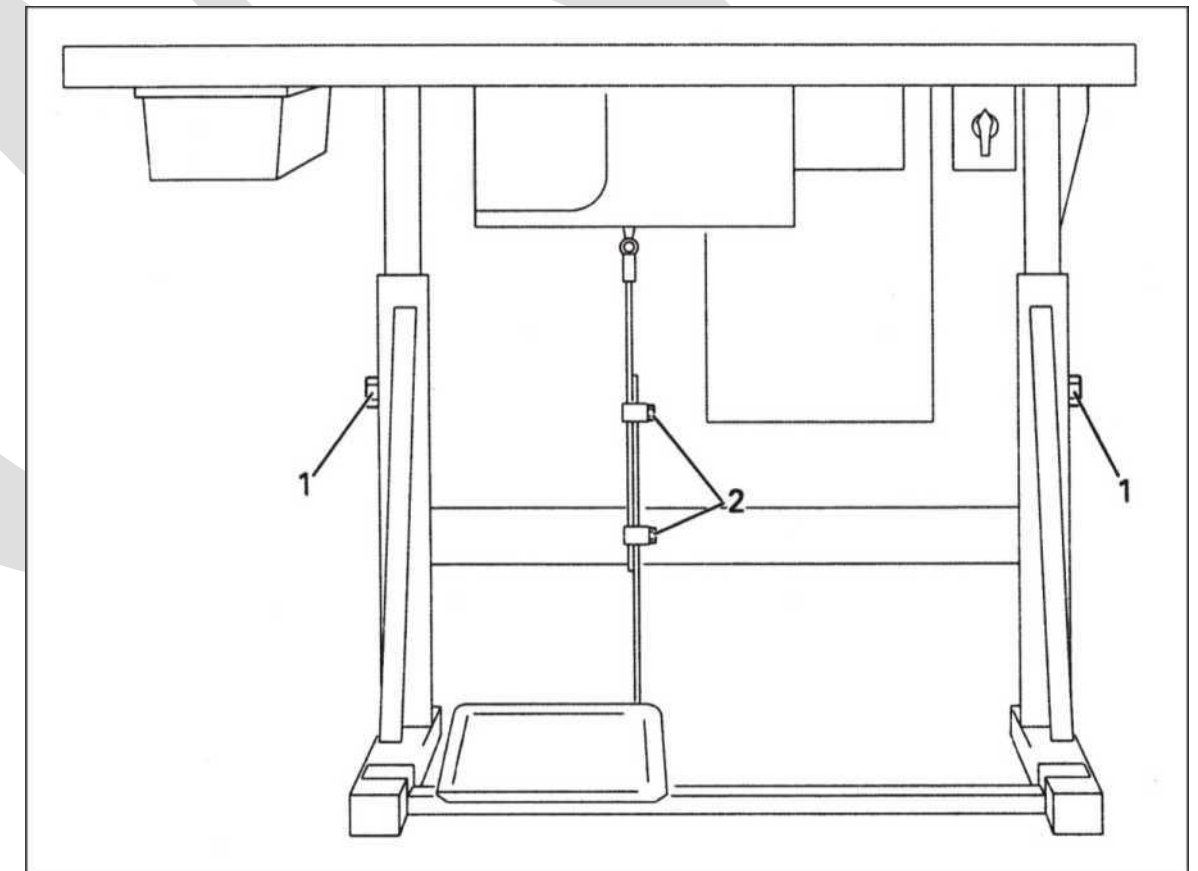
在機器安裝地點，必須有與機器相符的電源接口。

在機器安裝地點，必須有平整、堅固的地面，以及充分的照明。

The site where the machine is installed must be provided with suitable connections for electric current.

It must be ensured that the standing surface of the machine site is firm and horizontal, and that sufficient lighting is provided for.

2.01 臺板高度的調整 Adjust the table height



鬆開螺釘 1 和 2，並將臺板調整至所需的高度；將螺釘 1 牢固地擰緊；

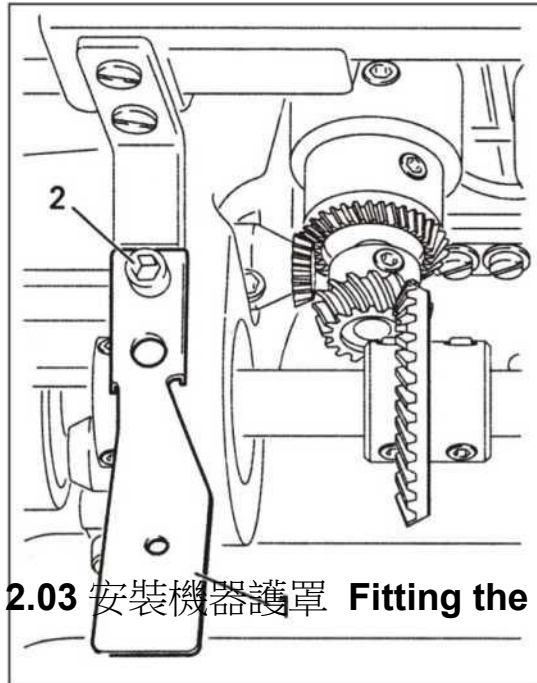
將踏板調至所需的位置，並且將螺釘 2 擰緊。

Loosen screws 1 and 2, and set the table height as required;

Firmly tighten screw 1:

Set the required pedal position and tighten screw 2.

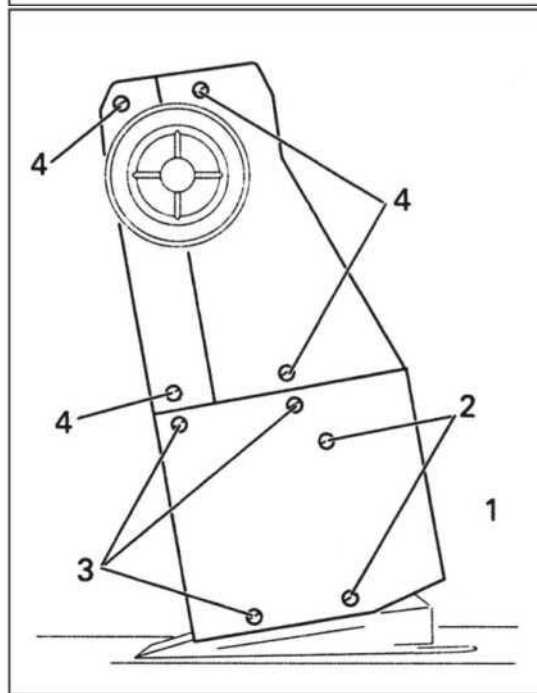
2.02 安裝翻轉保險 Fitting the tile lock



關閉電源總開關；
 用螺栓 2 固定翻轉保險 1。
 注：不許開動沒有翻轉保險 1 的機器！有在機頭和臺板之間被擠傷的危險！

Switch off the machine;
 Screw on the tilt lock 1 provided in the accessories, using screw 2.
 Note: Do not operate the machine without tilt lock 1! Danger of crushing between sewing head and table top!

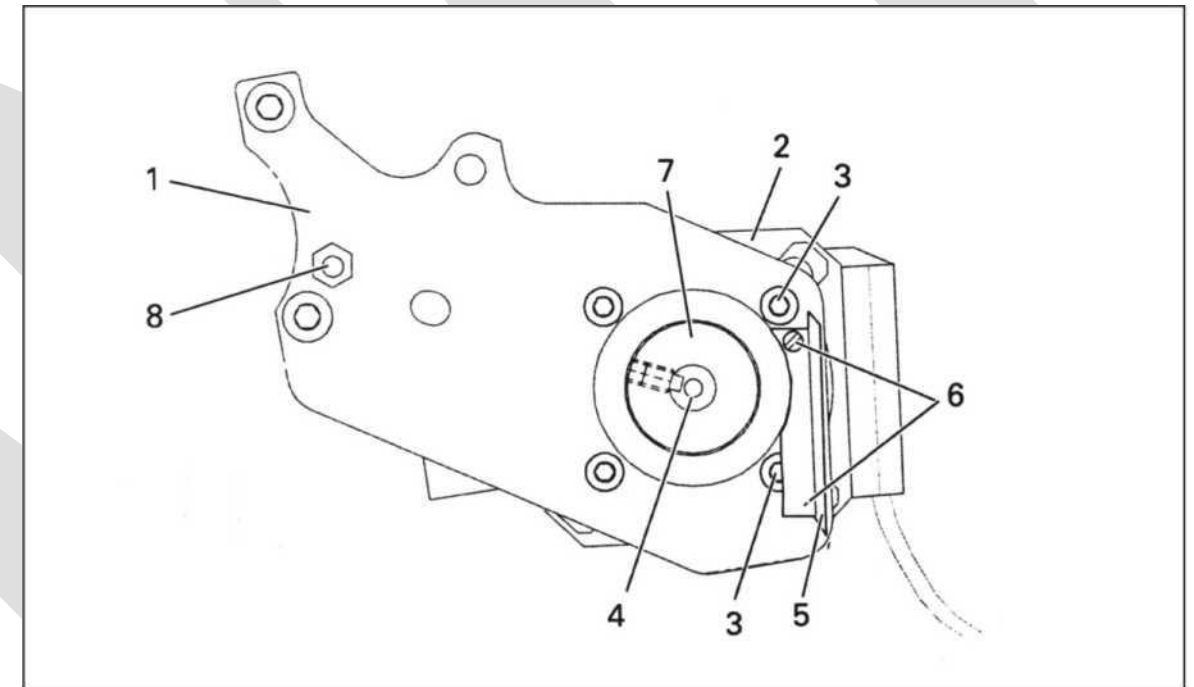
2.03 安裝機器護罩 Fitting the machine cover



在螺釘 2 的頭部後面（螺釘 2 預先擡在機殼上），將護罩 1 沿下部的槽滑入并用螺釘 3 固定，然後通過通孔擡緊螺釘 2；用螺釘 4 固定左右兩部分護罩。

Slide the slots of the lower section of the cover 1 behind the heads of screws 2 and attach with screws 3 then tighten screws 2 through the holes;
 Attach right and left cover sections with screws 4.

2.04 將帶法蘭的電機安裝到墊板上 Mounting the flange motor



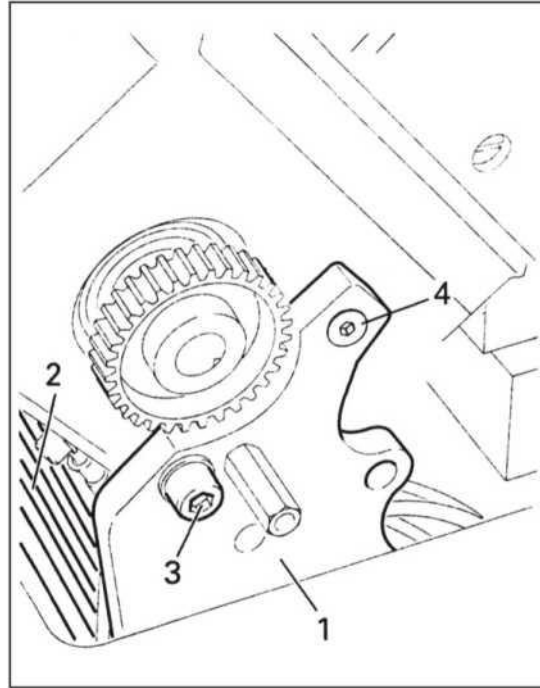
如上圖所示，用螺栓 3 將墊板 1 固定到電動機 2 上；
 從電動機軸 4 上移去楔鍵；
 用螺栓 6 固定角支座 5；
 安裝帶齒的皮帶輪 7 到電動機軸 4 上。螺釘的尖部要定位于電動機軸的凹槽中；將螺釘 8 擡入到墊板 1 中。

Attach bearing plate 2 to motor 2 with screws 3 as shown in Fig.
 Remove the wedge from motor shaft 4;
 Attach an angle bracket 5 with screws 6;
 Fit toothed belt wheel 7 to the motor shaft 4, so that the point of the screw is located in the groove of the motor shaft;
 Screw threaded stud 8 into the bearing plate.

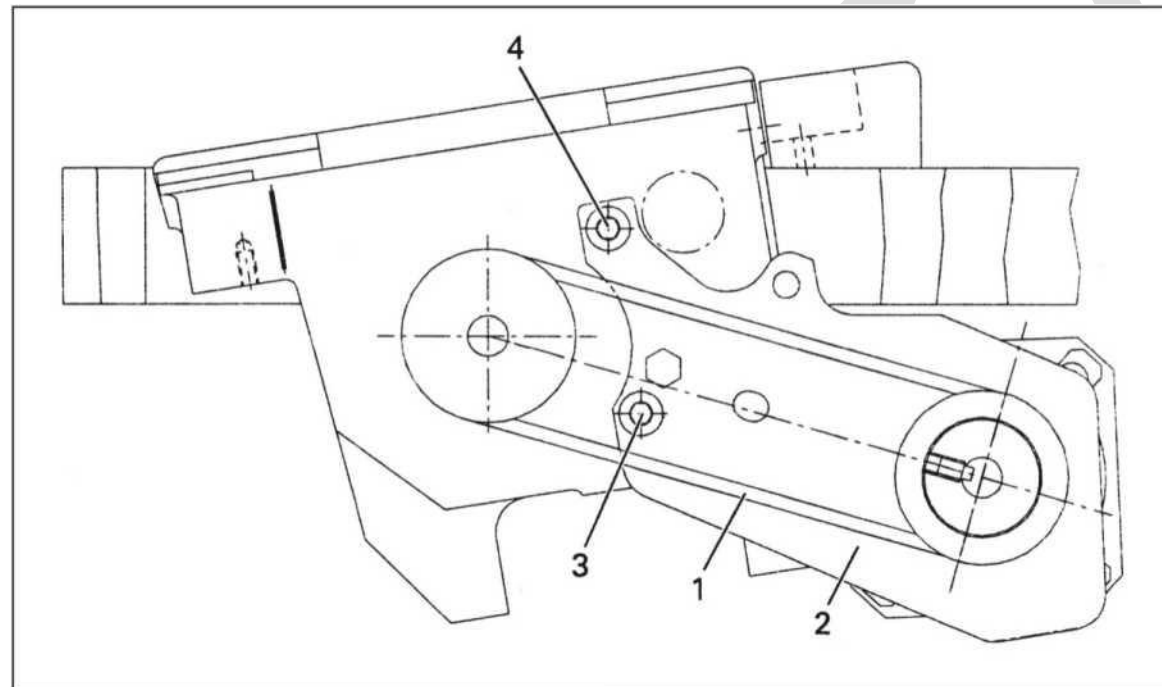
2.05 安裝帶法蘭的電動機到機器上 Mounting the flange motor to the machine

將板 1 固定到機器外殼上（祇是輕微地擡緊螺栓 3）。

Attach bearing plate 1 of motor 2 to the machine case with screws 3 (only tighten screws 3 slightly)



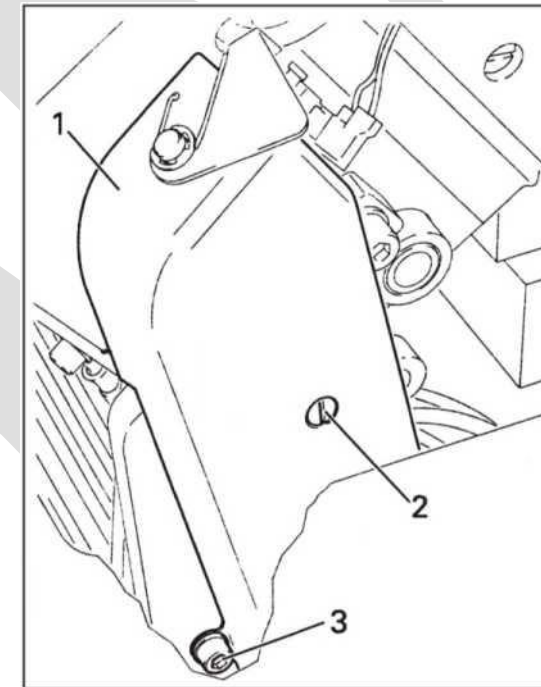
2.06 安裝齒形皮帶并調整皮帶張力
Mounting the toothed belt and adjusting the tension



在這個位置安裝齒形皮帶 1；
 擺動電動機的墊板 2，以張緊齒形皮帶；
 在這個位置擰緊螺栓 3。
 in this position fit toothed belt 1;

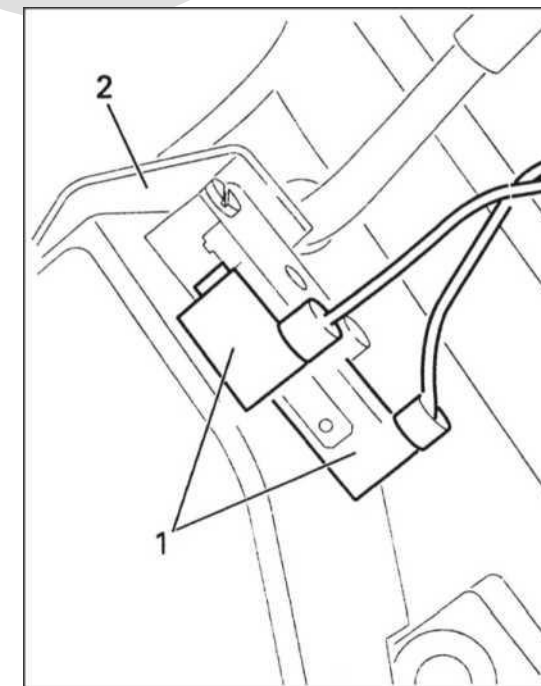
Swing the bearing plate 2 of the motor ,so that the toothed belt is tensioned; In this position tighten screws 3.

2.07 安裝帶法蘭電動機的皮帶防護罩
Mounting the belt guard of the flange motor



用螺釘 2 和 3 固定皮帶防護罩。
 Attach belt guard 1 with screws 2 and 3.

2.08 連接安全開關 Connecting the safety switch

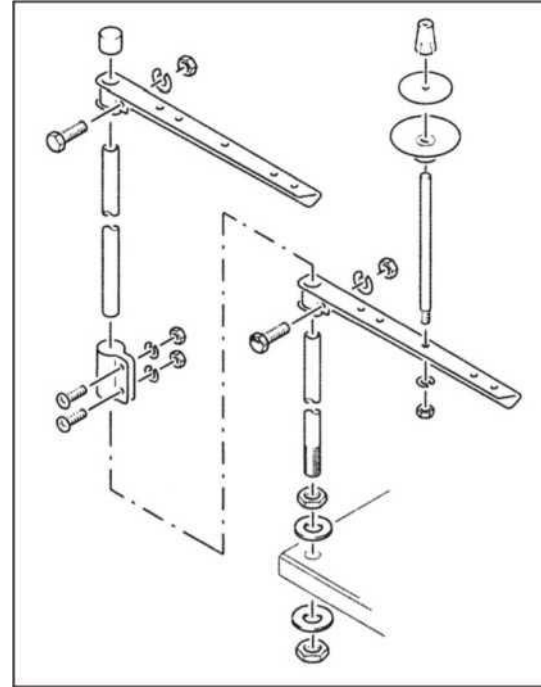


如圖所示，連接安全開關 2 的插頭 1。
 Connect plug i of safety switch in Fig..

2.09 安裝綫架 Fitting the reel stand

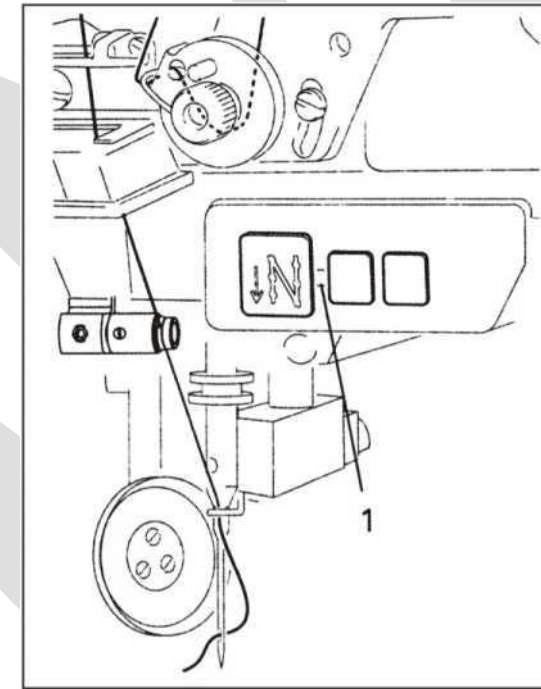
如圖所示安裝綫架：
然後將綫架插入臺板的孔中并用隨帶的螺母可靠地固定。

Fit the reel stand as shown in Fig.
Afterwards insert the stand in the hole of the table top and secure it with the nuts provided.



3.02 有綫迹計數功能的梭芯綫控制器

Bobbin thread monitoring with stitch counting

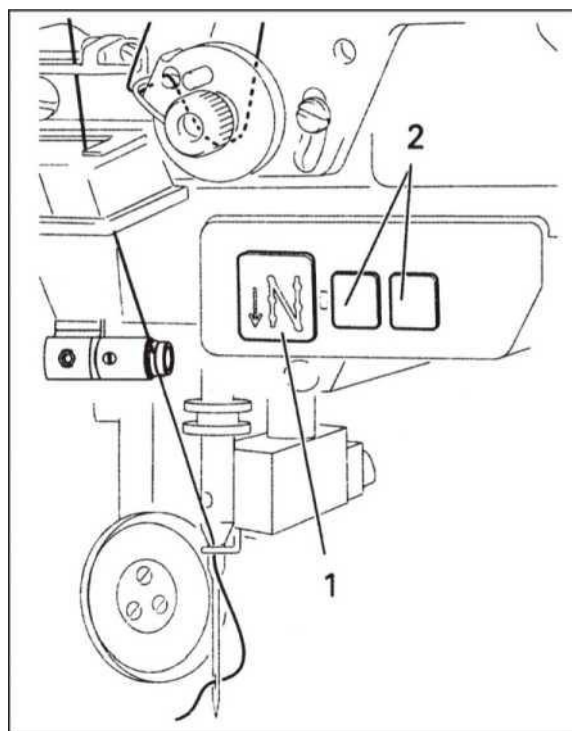


在達到預設綫迹數量前大約 100 個綫迹，發光二極管 1 開始閃爍；在剪綫後和更換梭芯後，綫迹計數器就開始計數。

About 100 stitches before reaching the preset number of stitches, diode 1 flashes;
After the thread has been trimmed and the bobbin changed, the stitch counting begins anew.

3. 操作件 Controls

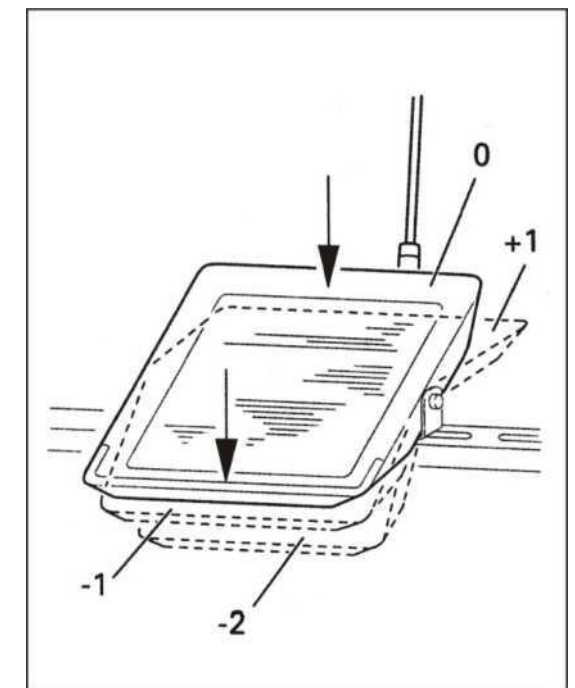
3.01 機頭按鍵 Keys on the machine head



在縫紉過程中，祇要按下按鍵 1，機器的縫紉方向就反轉；
按鍵 2 是用來設置參數的，請詳見電控說明書。

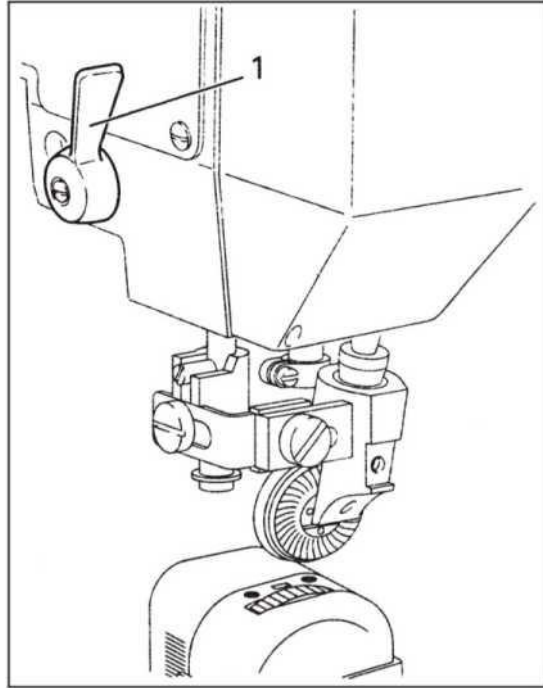
As long as key 1 is pressed during sewing, the machine sews in reverse;
Keys 2 can be used for parameter settings, Instruction Manual of Electronic Control.

3.03 踏板 Pedal



0 = 靜止位置 Neutral position
+1 = 縫紉 Sewing
-1 = 抬起滾輪壓腳 Raise roller presser
-2 = 剪綫 Trim sewing threads

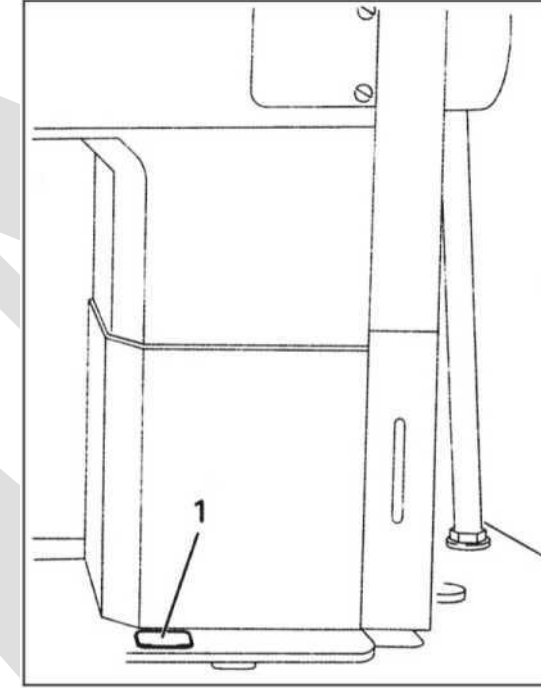
3.04 滾輪壓脚扳手 Lever for lifting roller presser



可以通過轉動扳手 1 抬起滾輪壓脚。

The roller presser can be raised by turning lever 1.

3.06 綫迹長度設置按鍵 Key for setting stitch length



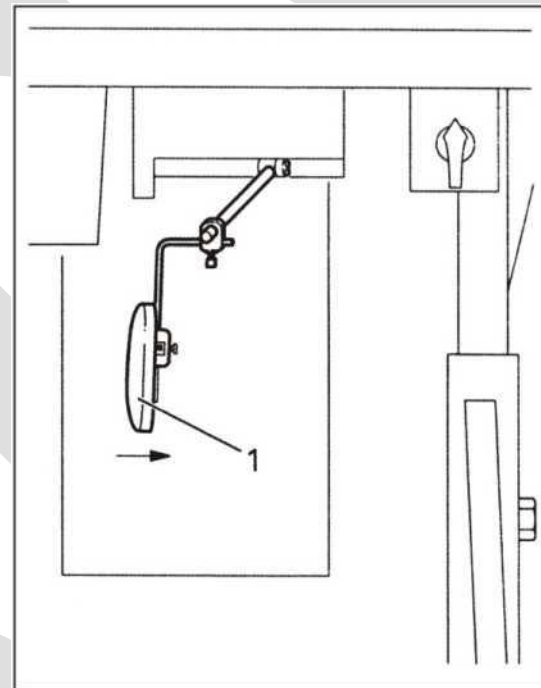
通過按下按鍵 1 并旋轉手輪來設置 綫迹長度。

The stitch length is set by pressing key 2 and turning the balance wheel.

3.05 膝控 Knee lever

可以通過向箭頭所示方向擠壓膝控杆 1 來抬起滾輪壓脚。

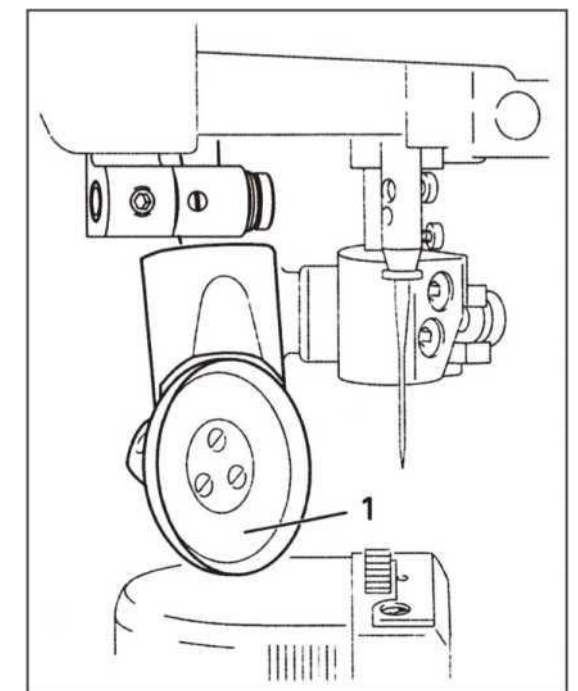
The roller presser can be raised by pressing the knee lever 1 in the direction of the arrow.



3.07 滾輪壓脚向外擺動 Swing out roller presser

當滾輪壓脚抬起後，可以通過向下 輕拉它，使其向外擺動。

When the roller presser is raised, it can be swung out by pulling it lightly down-wards.



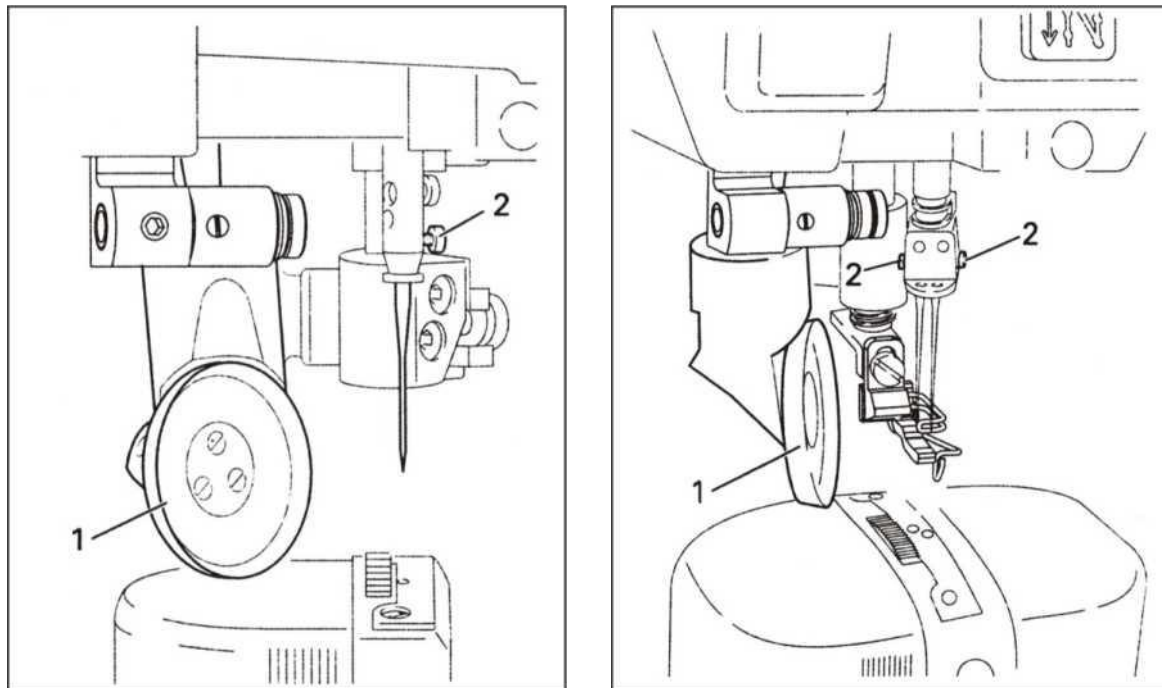
4 · 縫紉操作準備 Preparation

必須遵守本說明書中所有的規定和提示，特別要注意所有的安全規定；
所有機器準備工作祇允許由受過相應培訓的人員完成；
在所有的機器準備工作時，必須通過關閉總開關或者從電源插座上拔出插頭，以使機器斷電。

All instructions and regulations in this instruction manual must be observed, special attention must be paid to all safety regulations ;
All setting-up work must only be carried out by personnel with the appropriate training ;
For all setting-up work the machine must be disconnected from its power supply by turning off the on/off switch, or removing the plug from the electric power socket.

4.01 安裝機針 Inserting the needle

抬起滾輪壓腳 1 并將其向外擺動；
鬆開螺釘 2 并插入機針，使機針的長槽背對着各自勾綫的旋梭（即勾綫旋梭在左，長槽就向



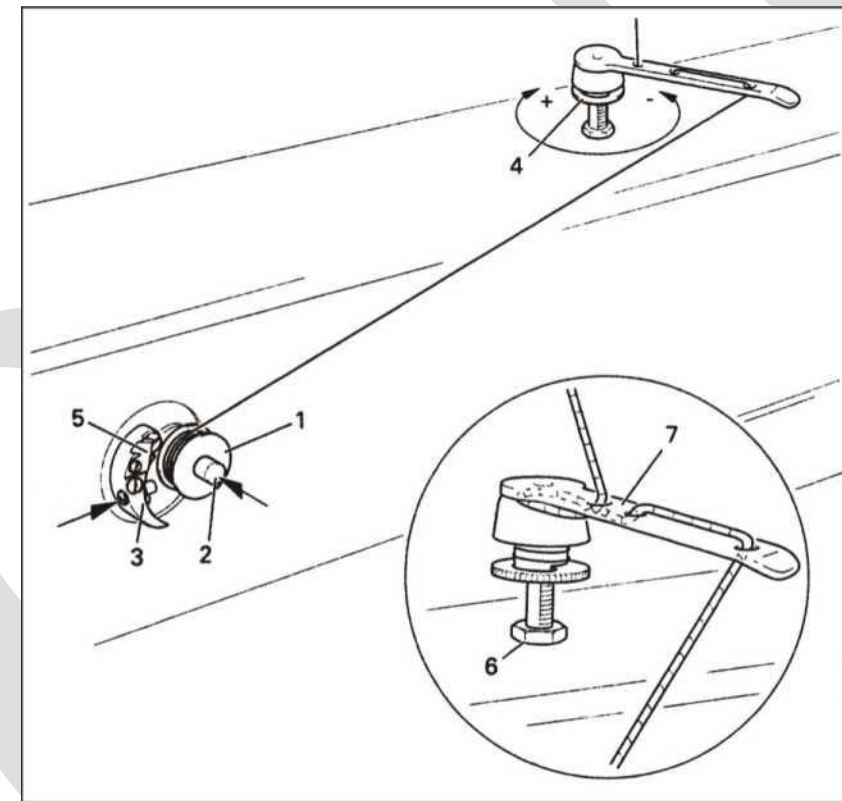
右；勾綫旋梭在右，長槽就向左）；
擰緊螺釘 2 并將滾輪壓腳擺回到原位置。

Raise the roller presser 1 and swing it out;
Loosen screws 2 and insert the needle as far as possible, the long groove must be contrary to the hook (If the hook is on the left, the long groove must be on the right); Tighten screw 2 and swing roller presser 1 back into position.

將一個空的梭芯 1 安裝到繞綫器軸 2 上；
如圖所示，給梭芯穿綫，并將綫順時針方向在梭芯上繞幾圈；同時壓下繞綫器軸 2 和杠杆 3，

4.02 繞梭芯綫，調整梭芯綫的張力。

Winding the bobbin thread ,adjusting the thread tension.



啓動繞綫器。

Place an empty bobbin 1 onto bobbin shaft 2;
Thread the bobbin in accordance with Fig. and wind it anti-clockwise around bobbin 1 a few times;
Switch on the bobbin winder while at the same time pressing bobbin winder spindle 2 and lever 3.

縫紉過程中的梭芯繞綫

在梭芯 1 上的綫張力可以用滾花螺母 4 進行調節；
當梭芯繞滿綫後，繞綫器自動停止；
如果繞綫不均勻，可以鬆開螺母 6,相應轉動調整導綫板 7 并擰緊螺母 6。

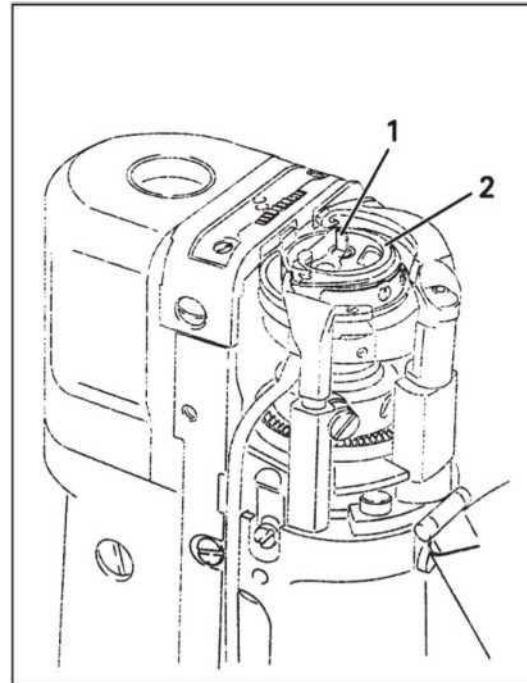
The bobbin fills up during sewing
The tension of the thread on bobbin 1 can be adjusted with knurled nut 4;
The bobbin winder stops automatically when bobbin is full;
If the thread is wound unevenly, loose nut 6 and turn thread guide 7 accordingly .Retighten nut 6 after the adjustment.

4.03 取出/裝入梭殼

Removing/Inserting the bobbin case

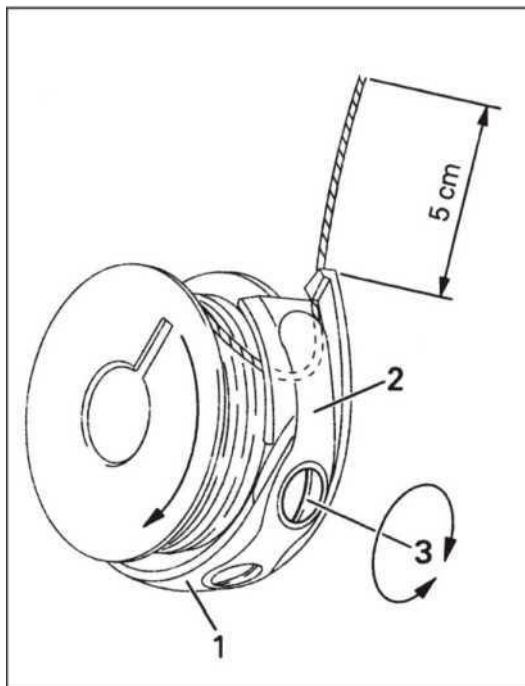
取出梭殼：
打開旋梭蓋；
抬起梭門閂 1 并取出梭殼 2。
裝入梭殼：
裝入梭殼 2；
關閉梭門閂 1 并重新合上旋梭蓋。

Removing the bobbin case :
Open the post cap ;
Raise latch 1 and remove bobbin case 2.
Inserting the bobbin case :
Insert bobbin case 2;
Close the latch 1 and close the post cap.



4.04 梭殼穿綫/調節梭芯綫的張力

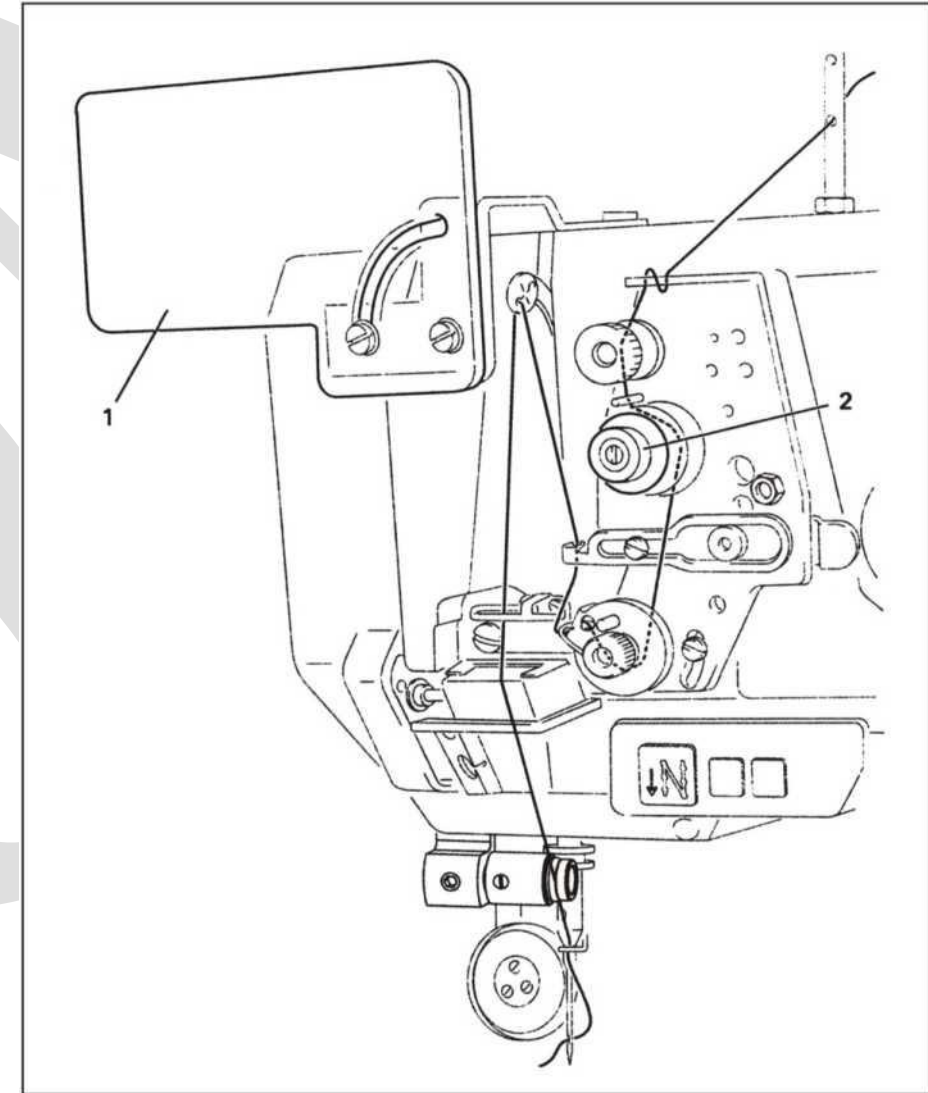
Threading the bobbin case/Adjusting the bobbin thread tension



將梭芯裝入梭殼 1 中；
將綫穿過彈性壓板 2 下的狹槽中； 將綫穿過凹口處；
通過旋動螺釘 3 調節梭芯綫張力。
Insert the bobbin into the bobbin case;
Pass the thread through the slot under spring 2;
Pass the thread through the notch; Adjust the thread tension by turning screw 3.

4.05 單針機型上穿針綫并調整針綫張力

Threading the needle thread and regulating its tension on the single needle machine on model single needle.

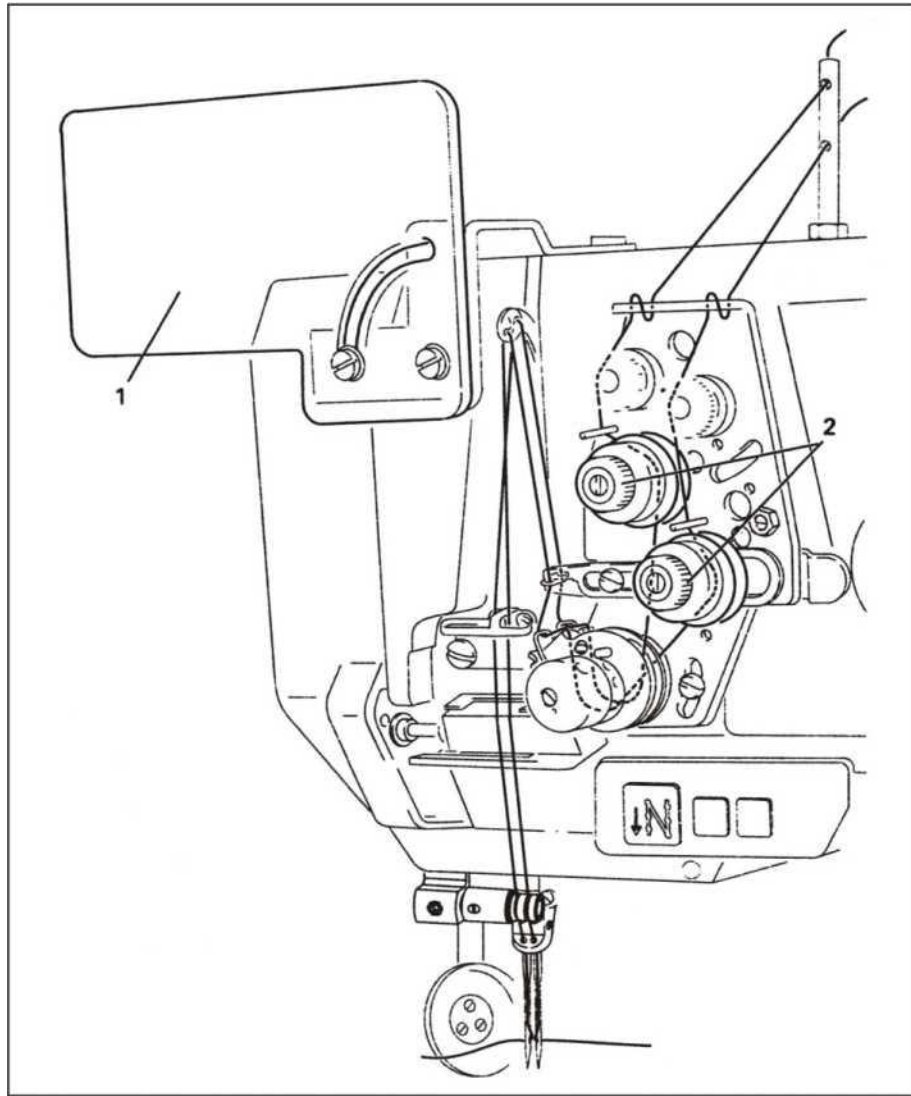


向上擺動護眼罩 1；
如圖所示穿針綫；
在左旋梭機型上，針綫是從右向左穿；而在右旋梭機型上，針綫是從左向右穿；
通過轉動滾花螺母 2 調節針綫的張力。

Tilt up the eye guard 1 ;
Thread the needle thread as shown in Fig;
On model left hook the needle is threaded from the right to the left ,and on model right hook from the left to the right,
Adjust the needle thread tension by turning milled nut 2.

4.06 雙針機型上穿針綫并調整針綫張力

Threading the needle thread and regulating its tension on the single needle machine on model double needle.

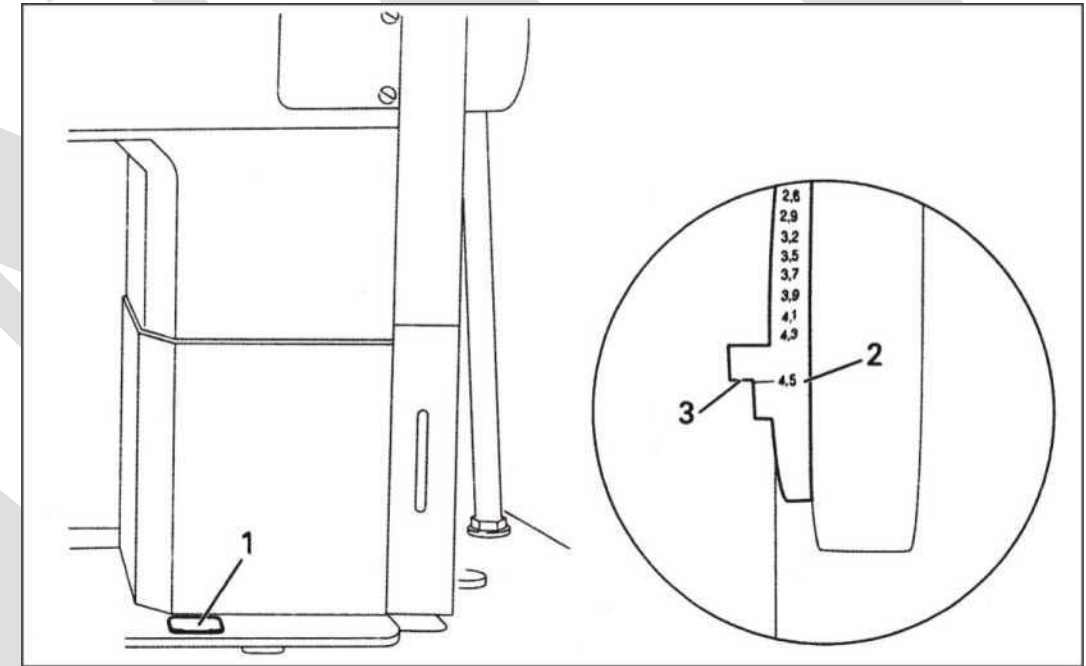


向上擺動護眼罩 1；
如圖所示穿兩個針綫；
在左邊的機針上，針綫是從右向左穿；而在右邊的機針上，針綫是從左向右穿；
通過轉動滾花螺母 2 調節針綫的張力。

Tilt up the eye guard 1;
Thread the needle thread as shown in Fig;
The left needle is threaded from the right to the left ,and the right needle from the left to the right;

Adjust the needle thread tension by turning milled nut 2. 油量檢查（綫潤滑/旋梭潤滑）每天，
開機之前 給旋梭加油.....每天，開機之前 傘齒
輪副潤滑.....每年一次 檢查/調節
空氣壓力.....每天，開機之前 清潔
空氣濾清器/潤滑器的過濾網.....在需要時

4.07 設置綫迹長度 Setting the stitch length



按下鍵 1 并同時轉動手輪直到綫迹調節器吻合嵌入定位位置；
保持按下鍵 1 并來回地轉動手輪，直到在刻度盤 2 上所需要設置的綫迹長度數字 與皮帶護
罩凹槽的下邊緣 3 處對齊。

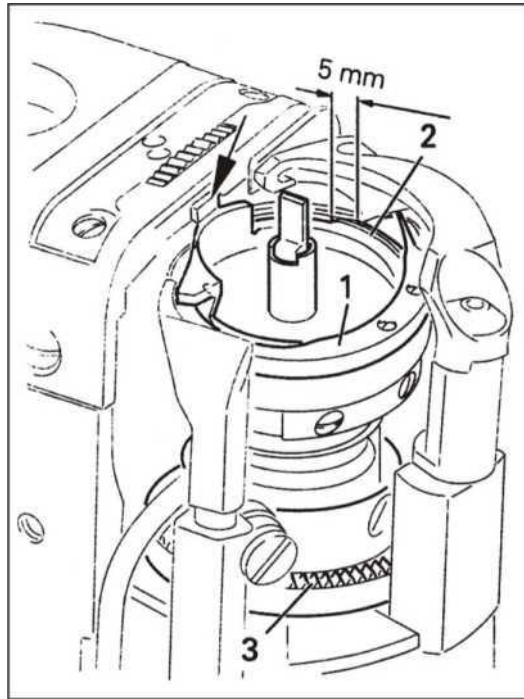
Press key 1 and at the same time turn the balance wheel until the stitch setter clicks into position ;
Hold down key 1 and turn the balance wheel to and fro until the stitch length
required is shown on the scale 2 opposite the bottom edge 3 of the belt guard recess.

5 • 維護與保養 Care and maintenance

清潔.....每天，如果持續運轉時，每天多次

Clean..... daily, more frequently if in continuous operation
Oil level (thread lubrication/hook lubrication).....daily, before use Oil the
hook.....daily, before use
Lubricate the level gears.....once a year
Check/adjust air pressure.....daily, before use Clean
air filter of air filter/lubricator..... when required

5.01.清潔 Cleaning



每天清潔旋梭，旋梭腔和齒輪 3,如果持續運行時，每天清潔多次。

Clean the hook ,hook compartment and toothed wheel 3 every day, several times if in continuous use.

關閉機器電源；

將針杆升到最高位置；

打開旋梭蓋，取出梭殼和梭芯；

擰鬆內梭頭舌 1 的螺釘；

轉動手輪，直到梭殼 2 的尖端進入旋梭的導槽內大約 5mm；

取出梭殼 2；

用石蠟清潔旋梭槽；

當放入梭殼 2 時，要確信梭殼 2 的凸出鼻端部分嚙合入針板的凹槽中；

Bring the needle bar to its highest position,

Open the post cap and remove the bobbin case cap and the bobbin ;

Unscrew hook gib 1,

Turn the hand wheel until the point of bobbin case 2 penetrates into the groove of the hook race approx.5mm ;

Remove bobbin case 2,

Clean the hook race with paraffin ;

When inserting the bobbin case 2, ensure that the horn of the bobbin case 2 engages in the groove of the needle plate ;

5.02 給旋梭加油 Oiling the hook

關閉機器電源；

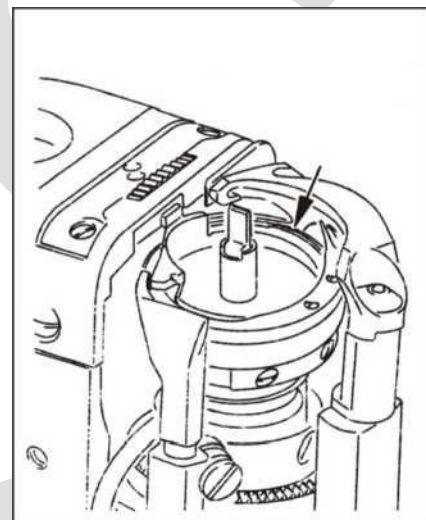
每天注 1-2 滴油到內梭頭舌的孔 1 中；

在機器試車前及在長期停機後，注入幾滴油到旋梭的槽中(參見箭頭所示)。

Switch the machine off;

Pour 1 -2 drops of oil into hole I of the hook gib daily;

Before commissioning the machine, and after long periods out of operation, pour a few drops of oil into the hook race (see arrow).



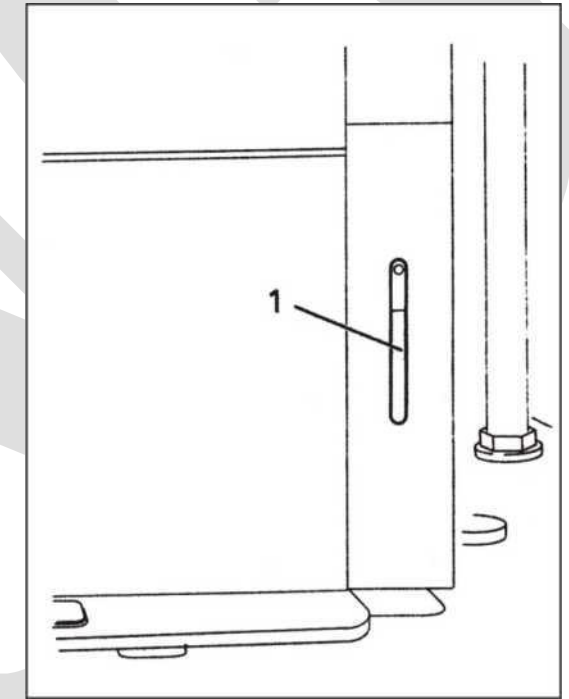
5.03 旋梭潤滑油盒 Oil bowl for hook lubrication

擰緊內梭頭舌 1 的螺釘并蓋上旋梭蓋。在每次開機前檢查油量，必須始終保持油盒 1 中有油。如果需要可通過加油孔加油。

祇允許使用在 40P 時平均粘度為 22.0mm²/ S 和在 15P 時密度為 0.865g/cm³ 的潤滑油。

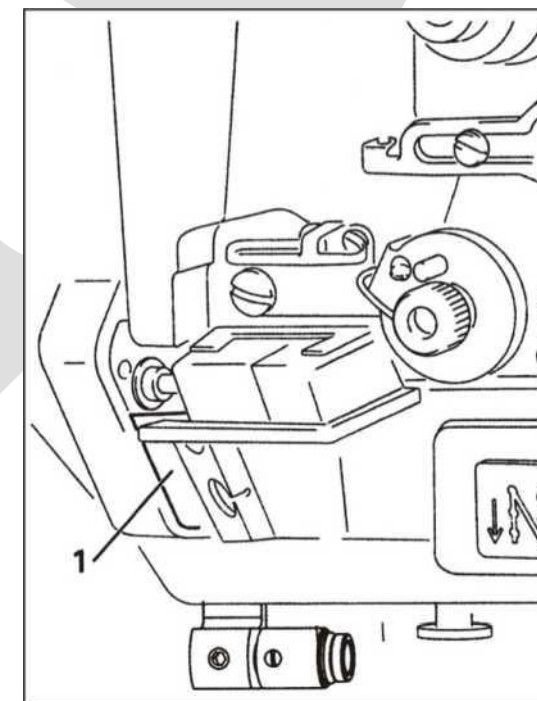
Check the oil level before each use .there must always be oil in reservoir 1 .If required refill oil through hole.

Use only oil with a mean viscosity of 22.0mm²/s at 40P and a density of 0.865 g/cm³ at 15*0.



5.04 給綫潤滑系統的油盒加油

Filling the oil reservoir of the thread lubrication unit



在每天開機前檢查油量，如有需要，可通過加油孔加油到標記處。我們推薦使用綫潤滑油。

Control the oil level before each use. If necessary Jill oil up to mark through hole. We recommend thread lubrication oil.

5.05 給傘齒輪副潤滑 Lubricating the bevel gears

關閉機器電源！

所有傘齒輪副每年必須加一次新油脂。

向後翻轉機頭到支撐件上。

Switch the machine off!

All bevel gears must be supplied with new grease once a year.

Tilt the sewing head back onto the support.

如圖所示雙針機型的傘齒輪副。

塗油脂到齒輪的全部齒側面(見箭頭所示)。

在將機頭放回垂直位置時，先向後按翻轉保險 1,并用雙手將機頭放回垂直位置。

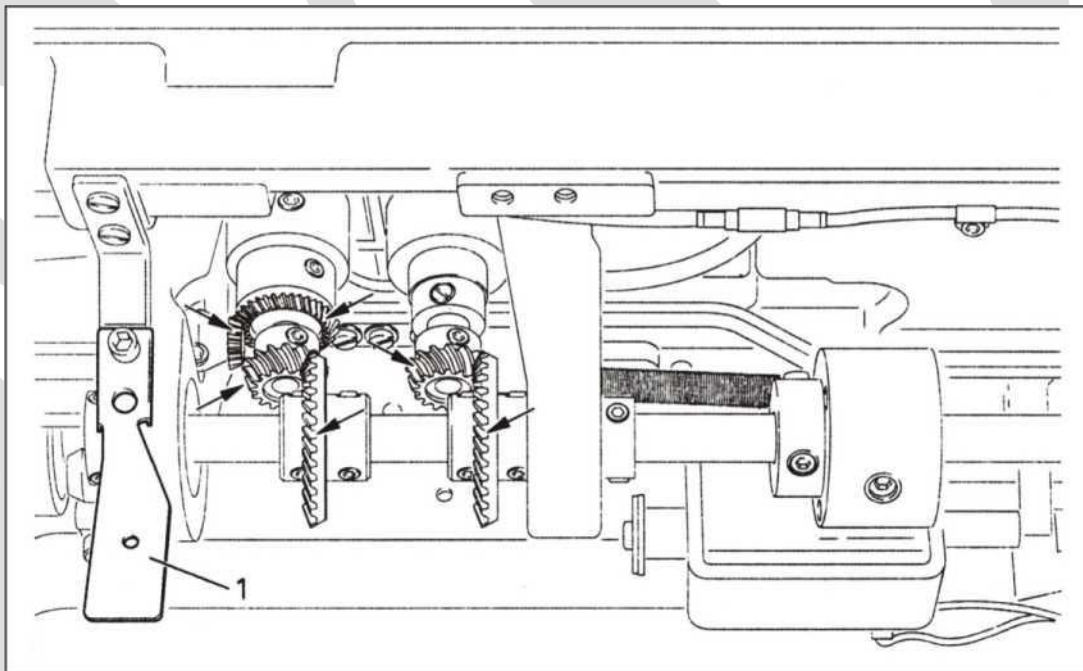
Fig. shows the bevel gears of the double needle machine.

Apply grease to all the tooth flanks and the rack (see arrows).

To set the sewing head upright, press tilt lock 2 backwards and set the sewing head upright using both hands.

我們推薦使用滴點大約為 150P 含鎊油脂。

We recommend sodium grease with a dripping point of approx.150P.



警告：必須用雙手將機頭放回垂直位置

有在機頭和臺板之間被擠傷的危險！

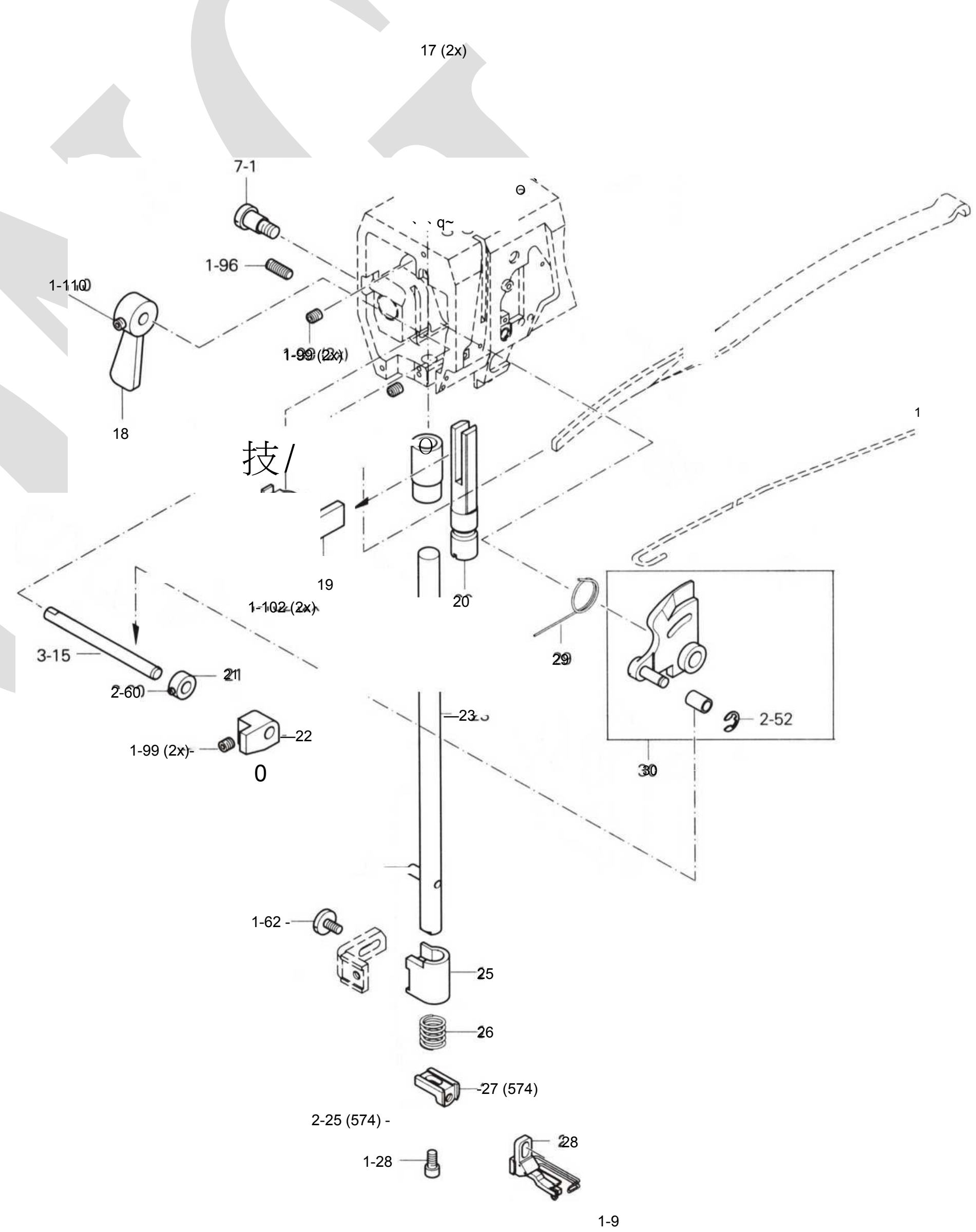
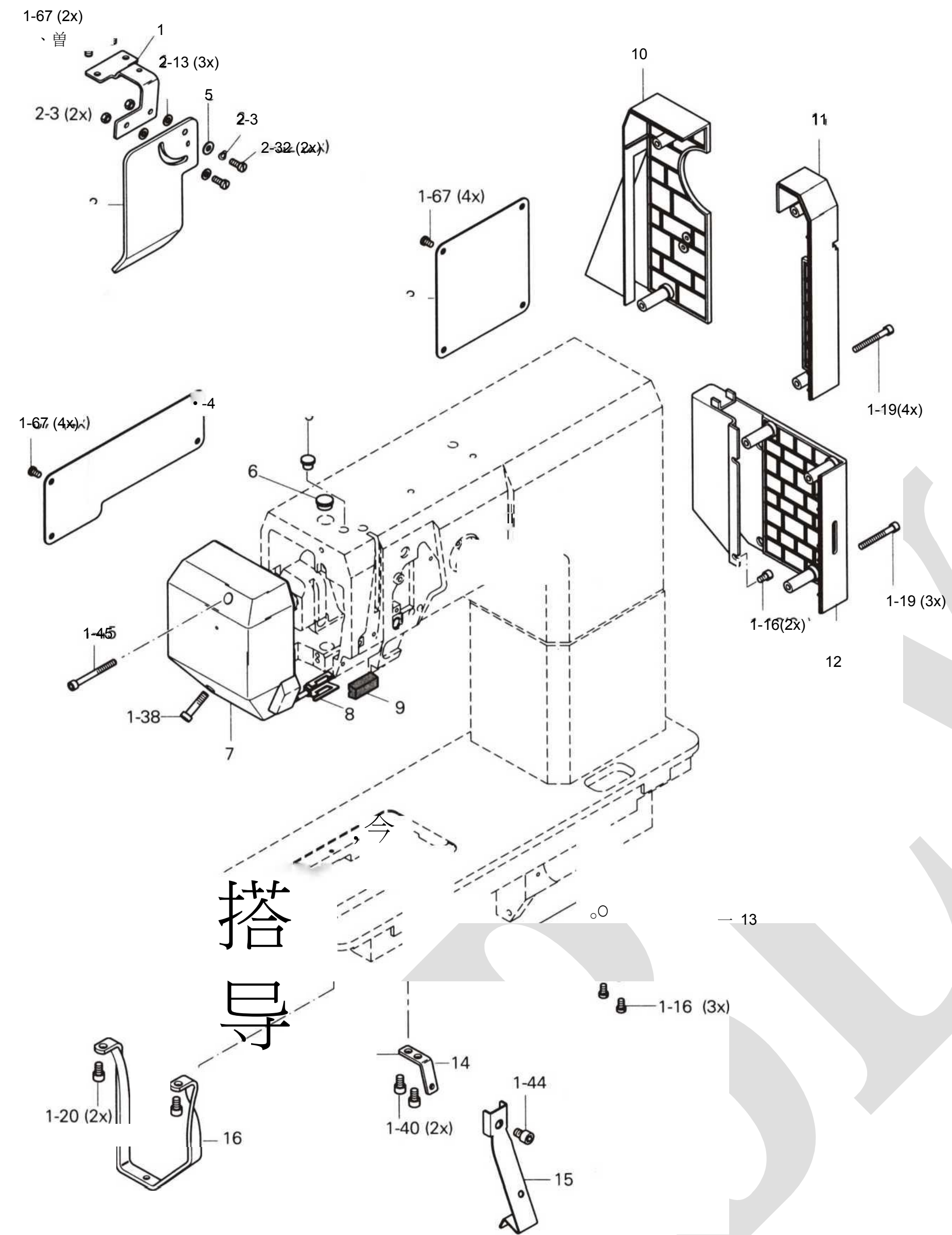
Warning :Use both hands to set the sewing head upright.

Danger of crushing between the sewing head and the table top !

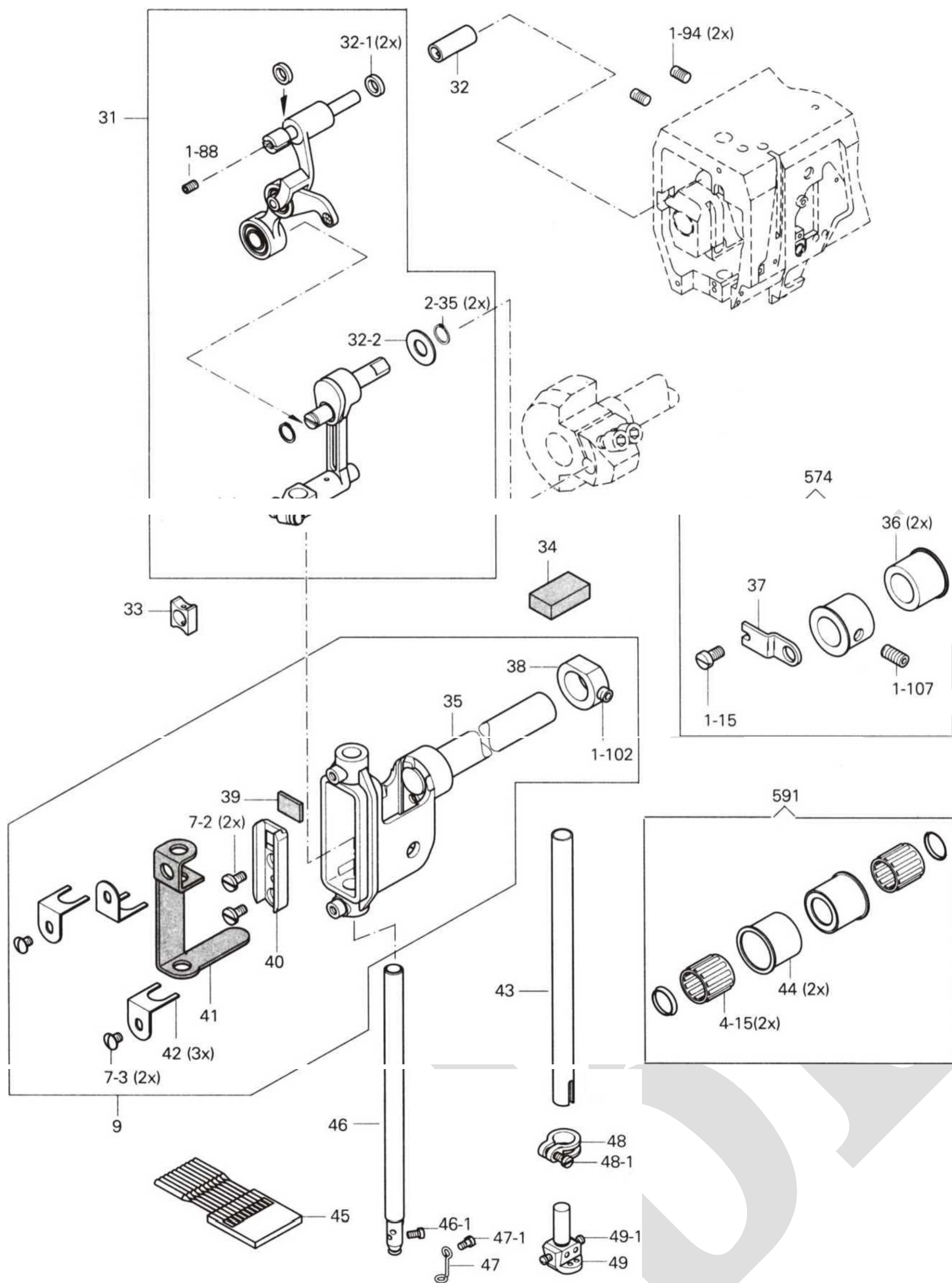
第二部分 零件部分 PARTS LIST

機身零件
 ■ Housing sections

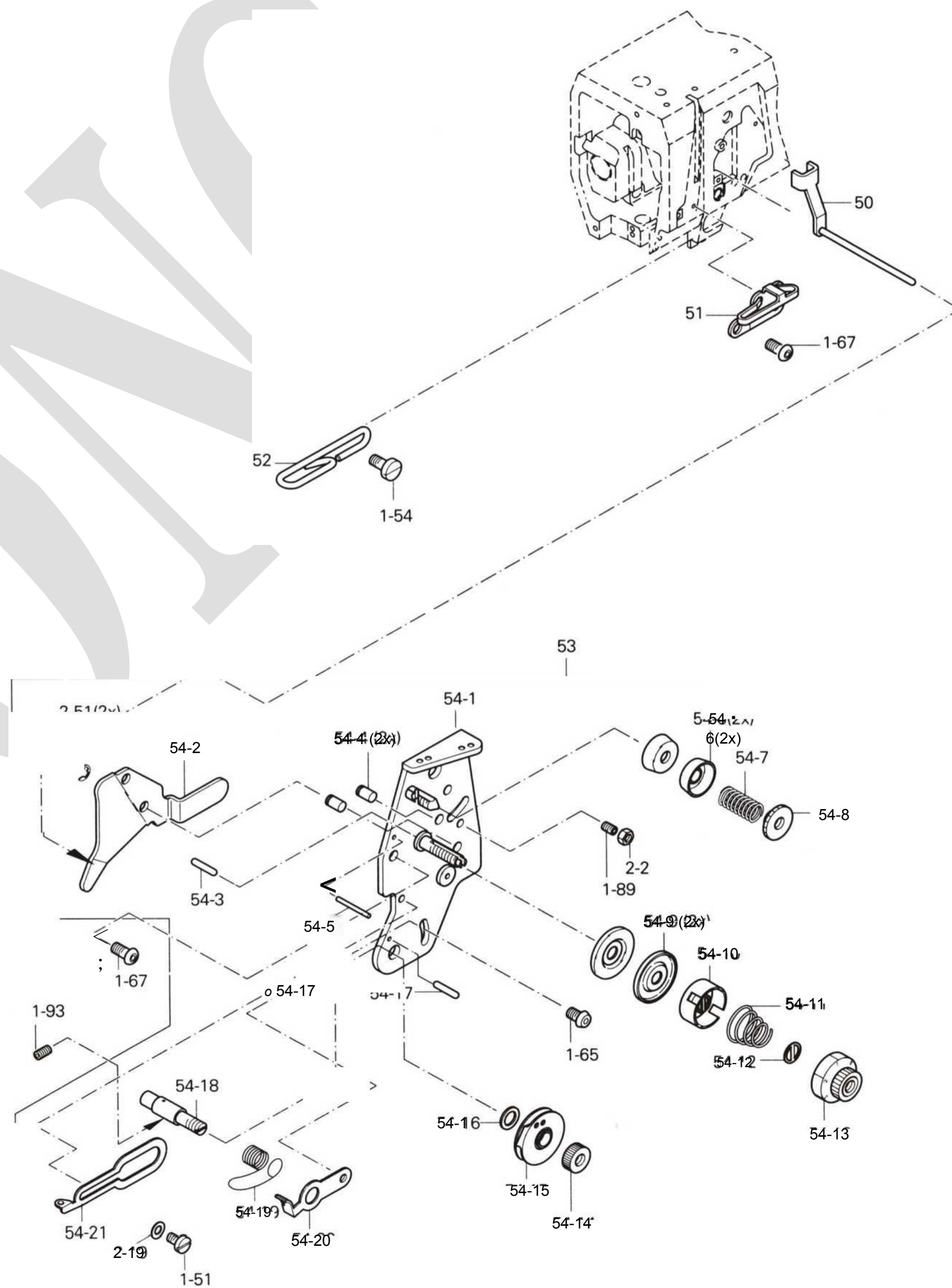
2 機頭零件
 £ ■ U ' Needle head parts



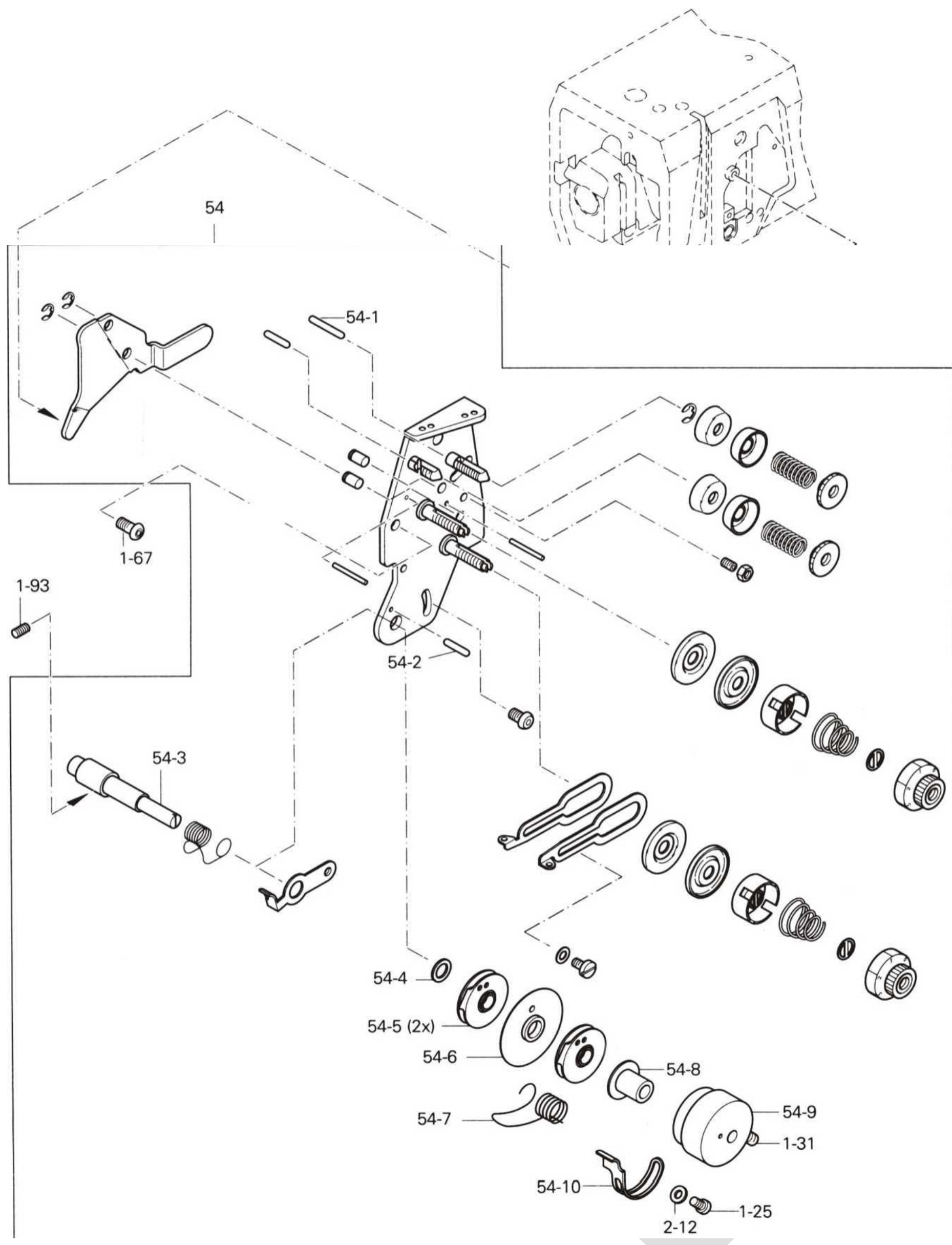
2-02 機頭零件
Needle head parts



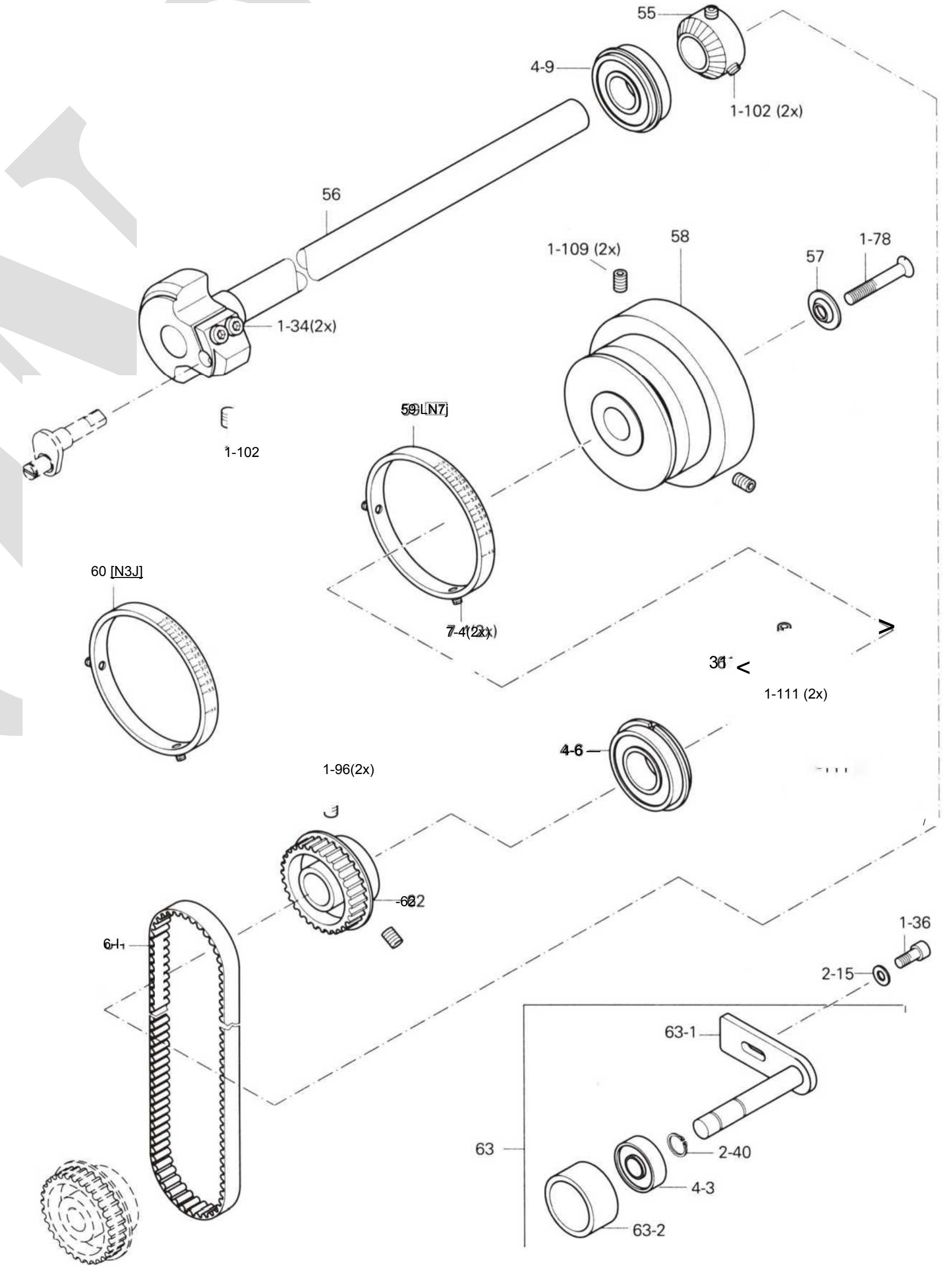
2.03 機頭零件 Needle
head parts

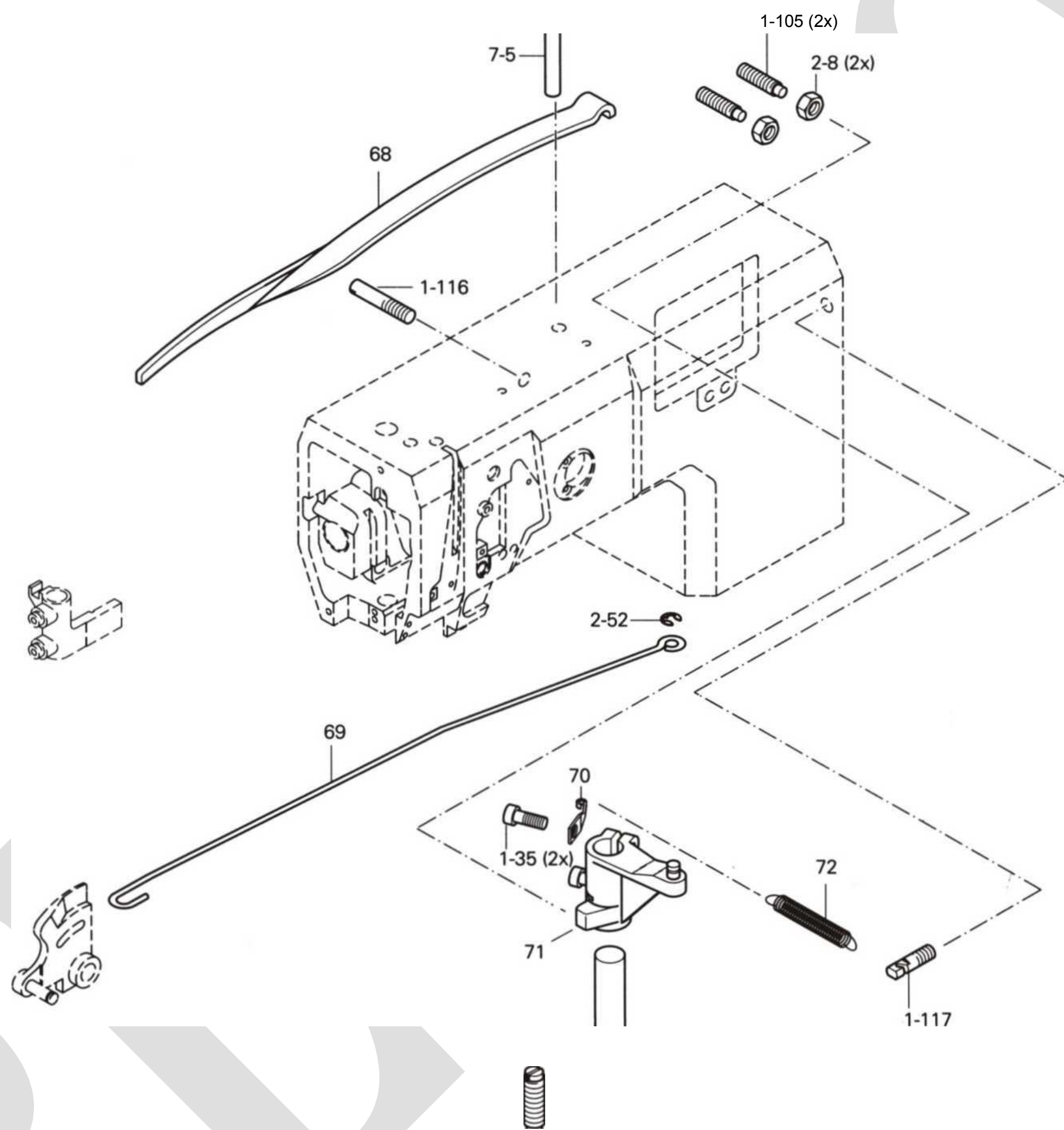
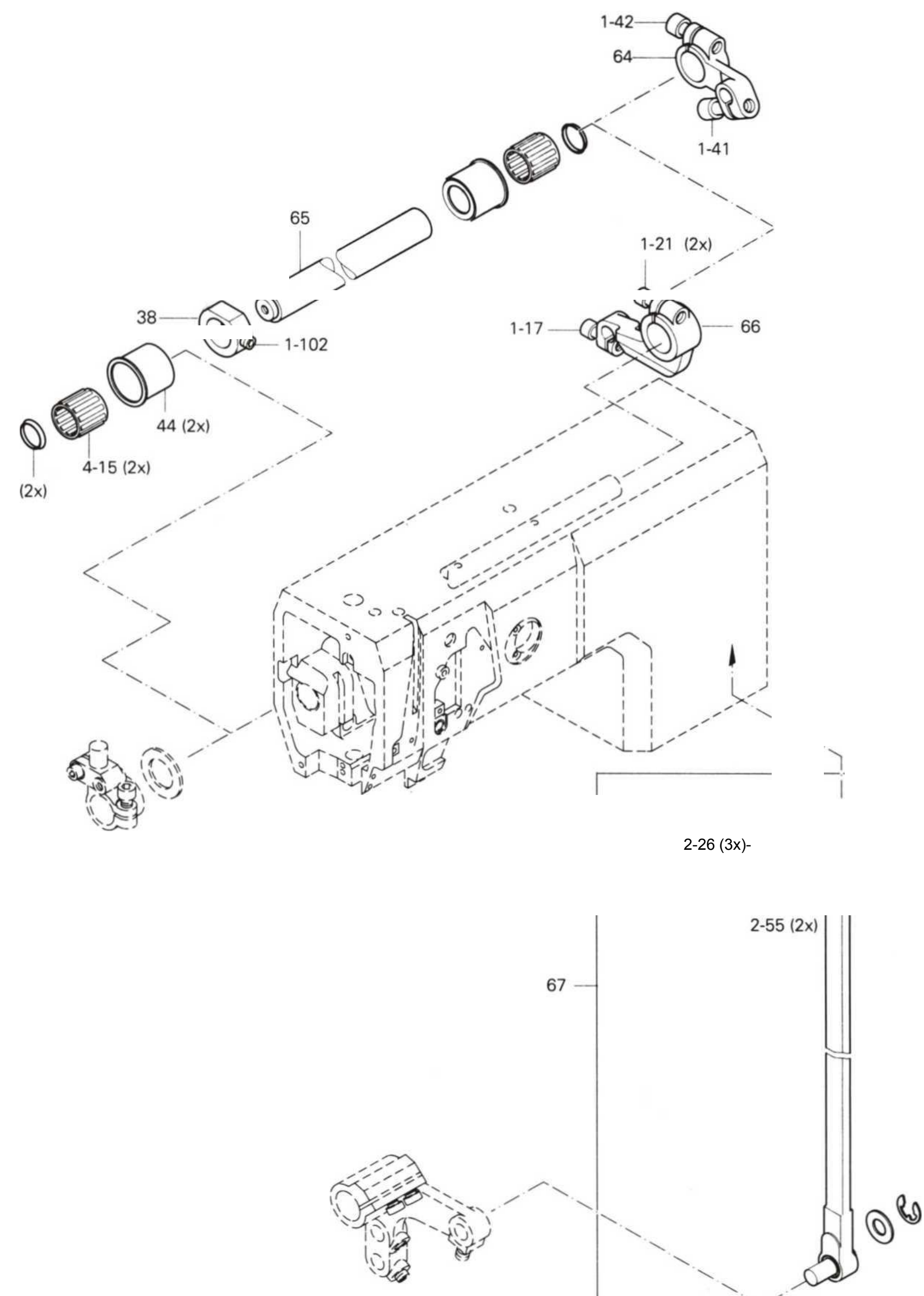


2 04 機頭零件
 ◆ . v-r \needle head parts

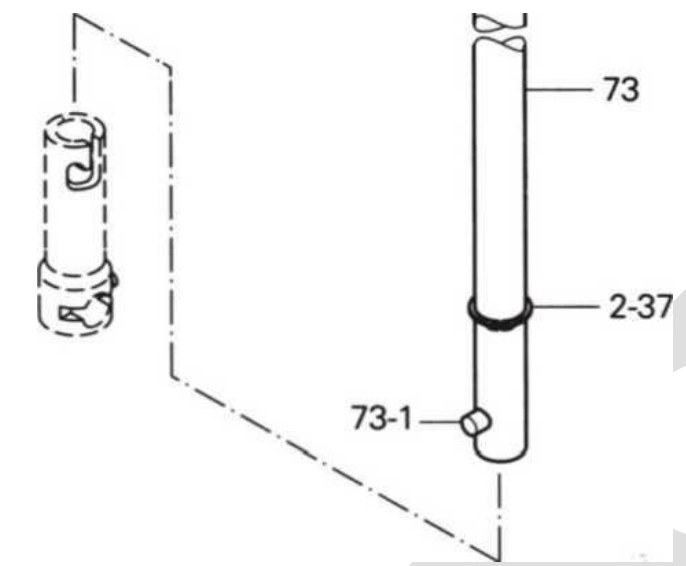


O ni 機臂零件 J.U ' Arm parts

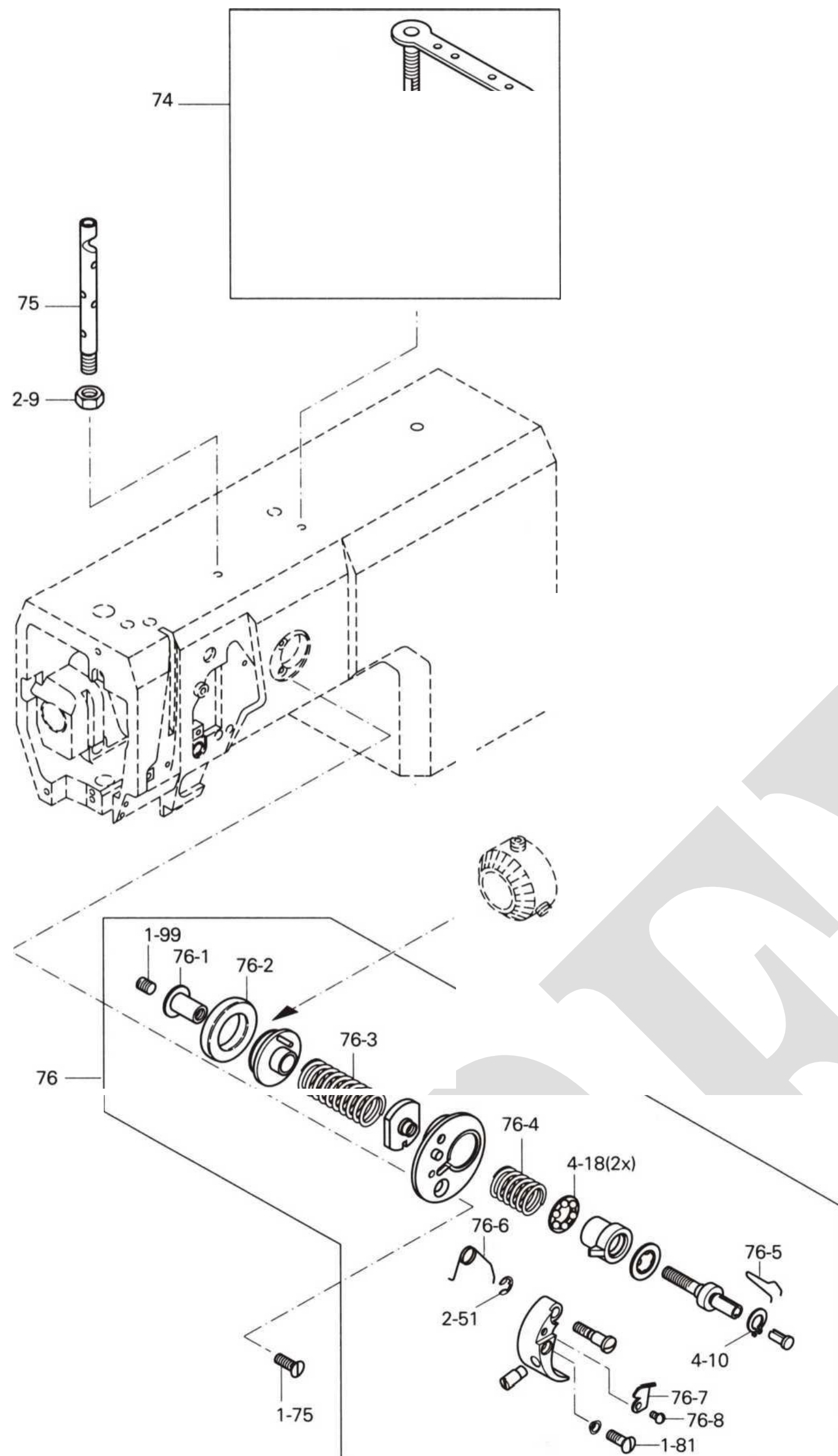




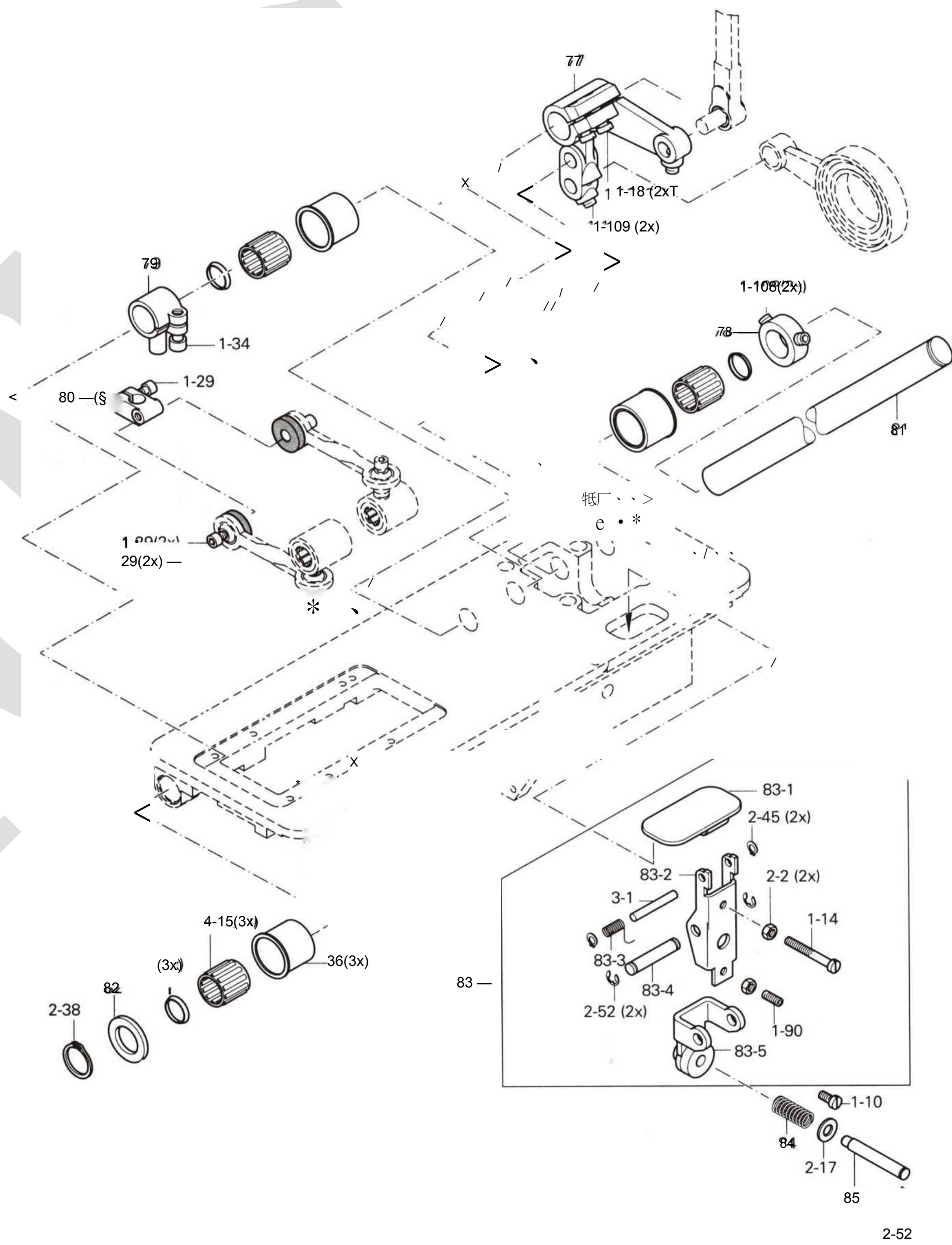
3-03 題誅.



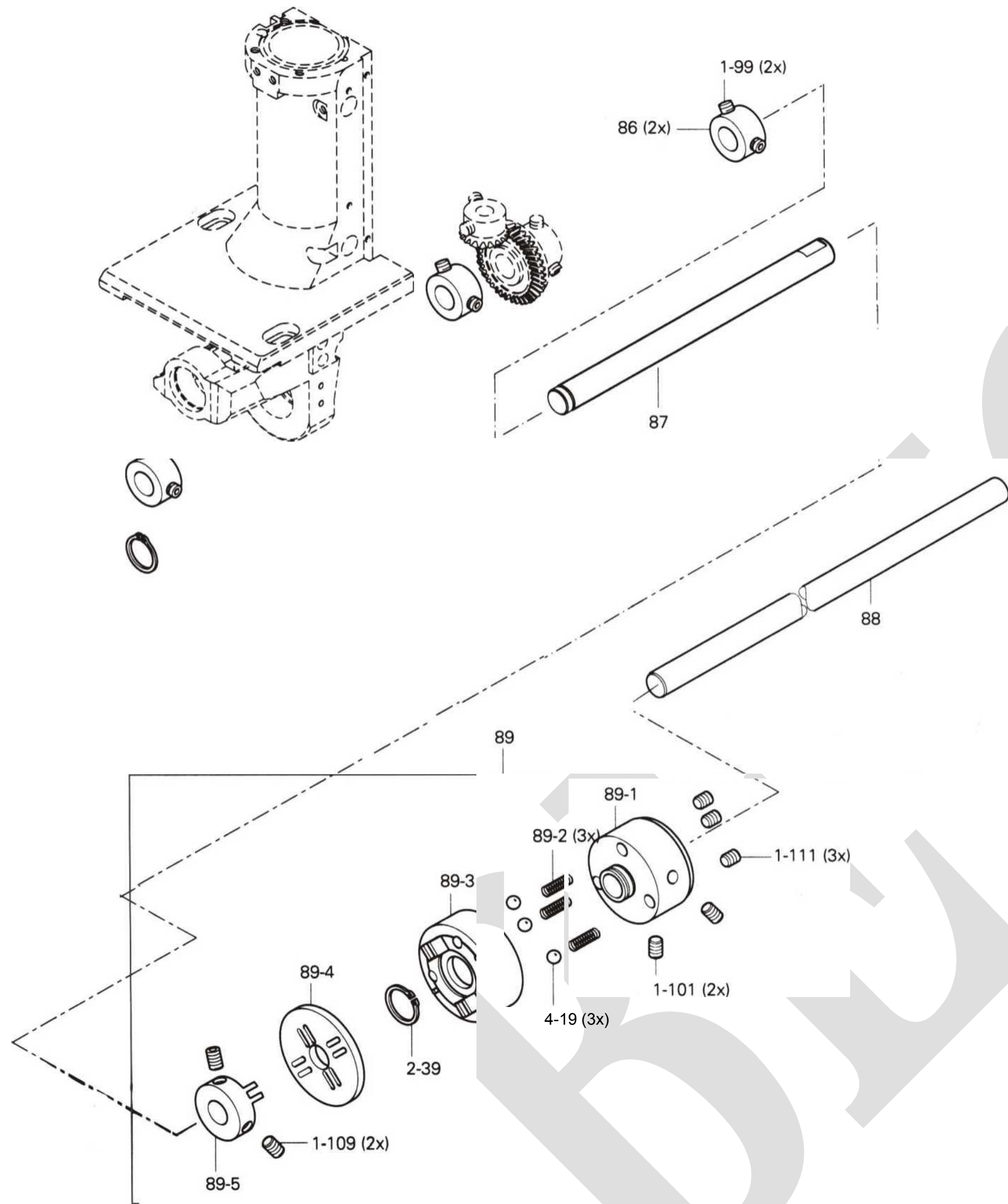
3.04 題驚 ts



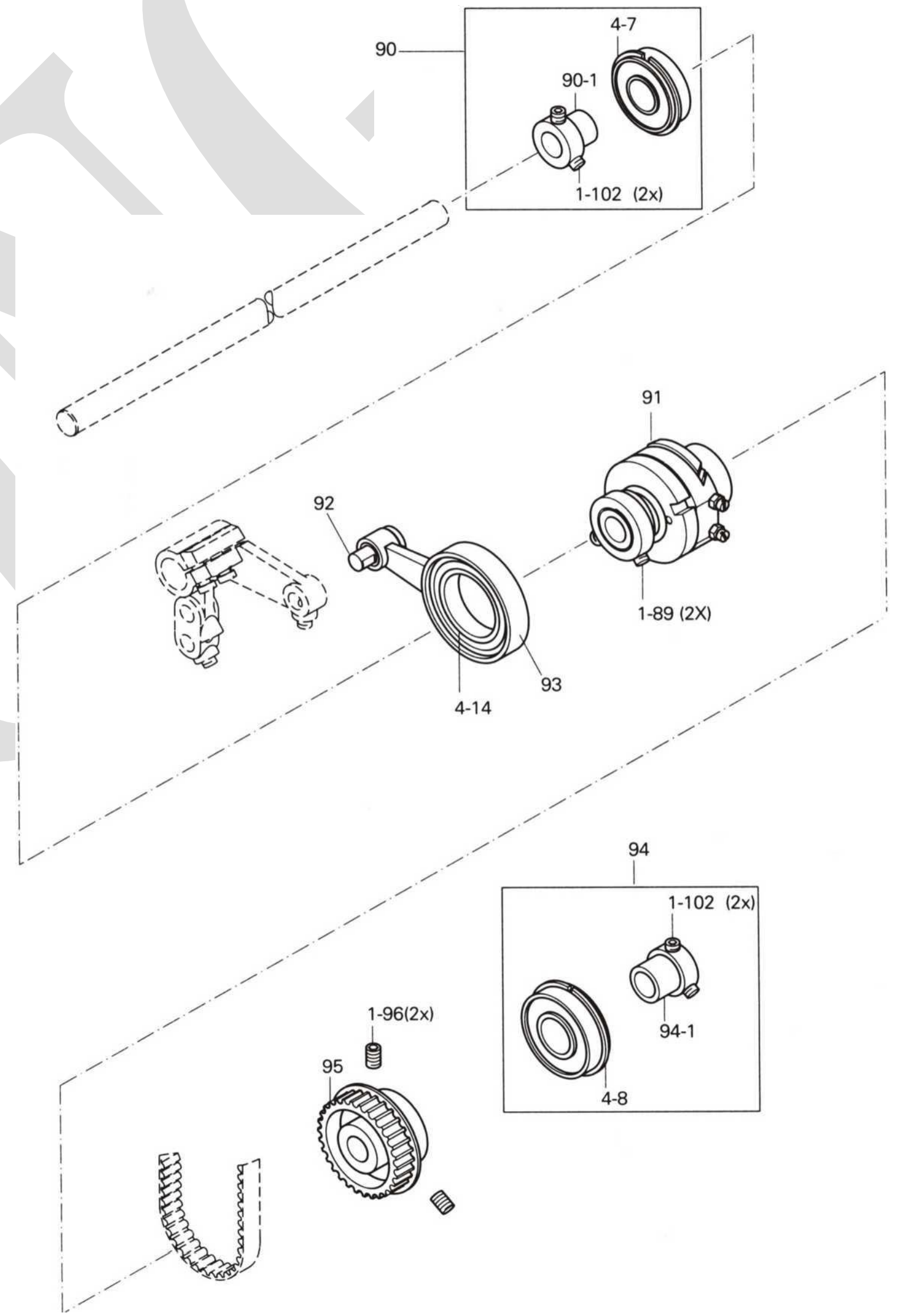
4 01 底板零件 "u 1 Bedplate parts



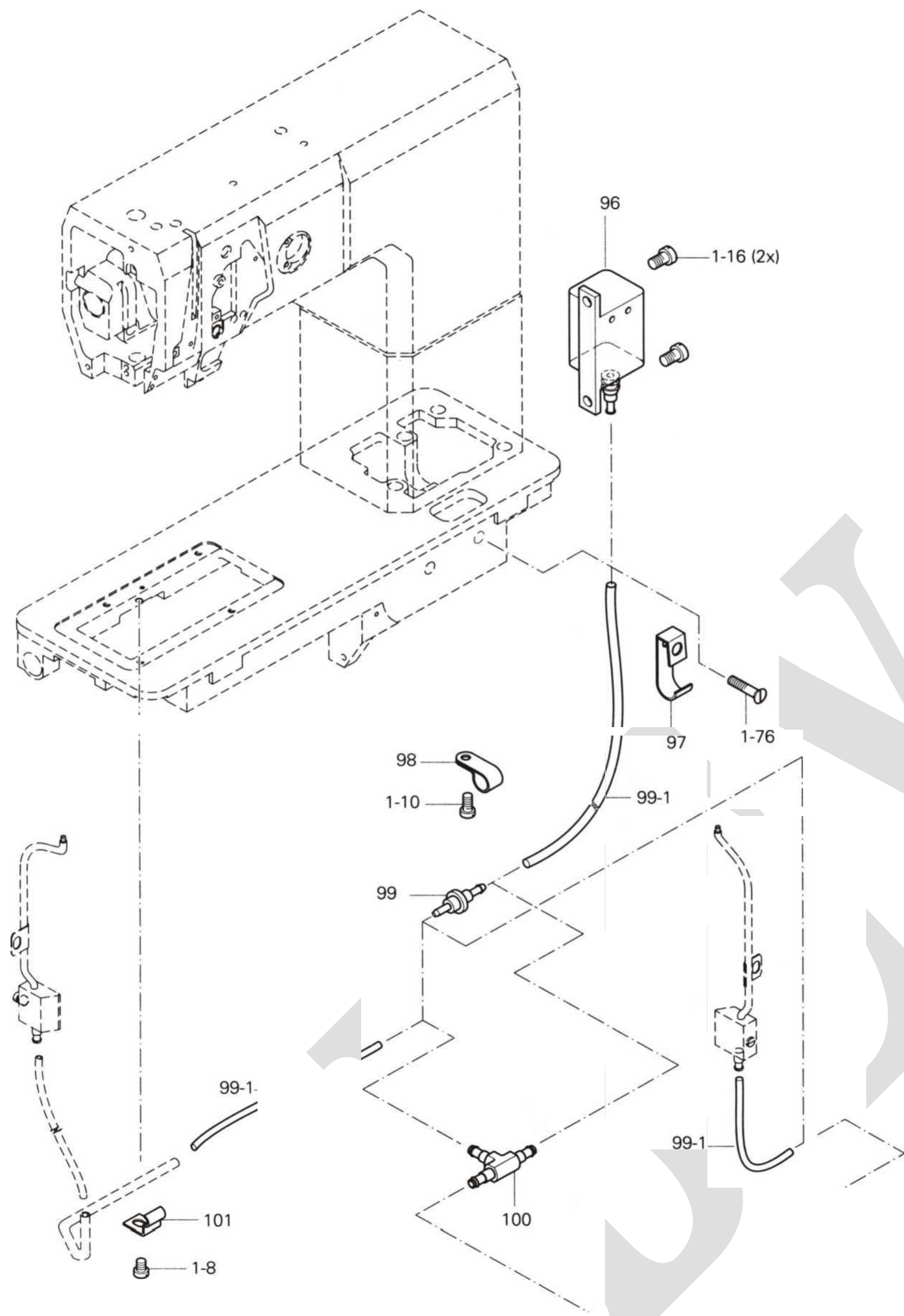
4.02 底板零件
Bedplate parts



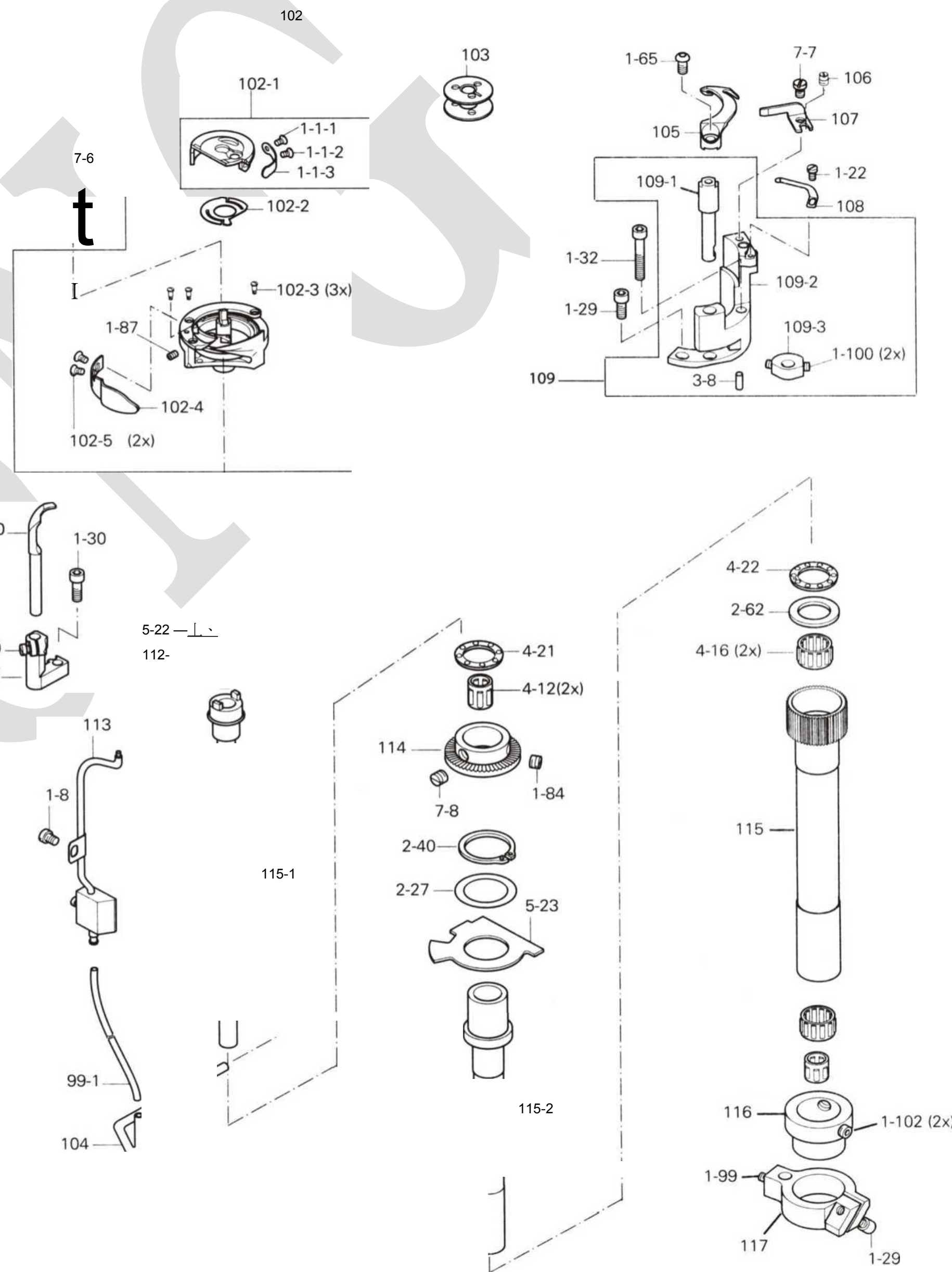
4.03 底板零件
Bedplate parts



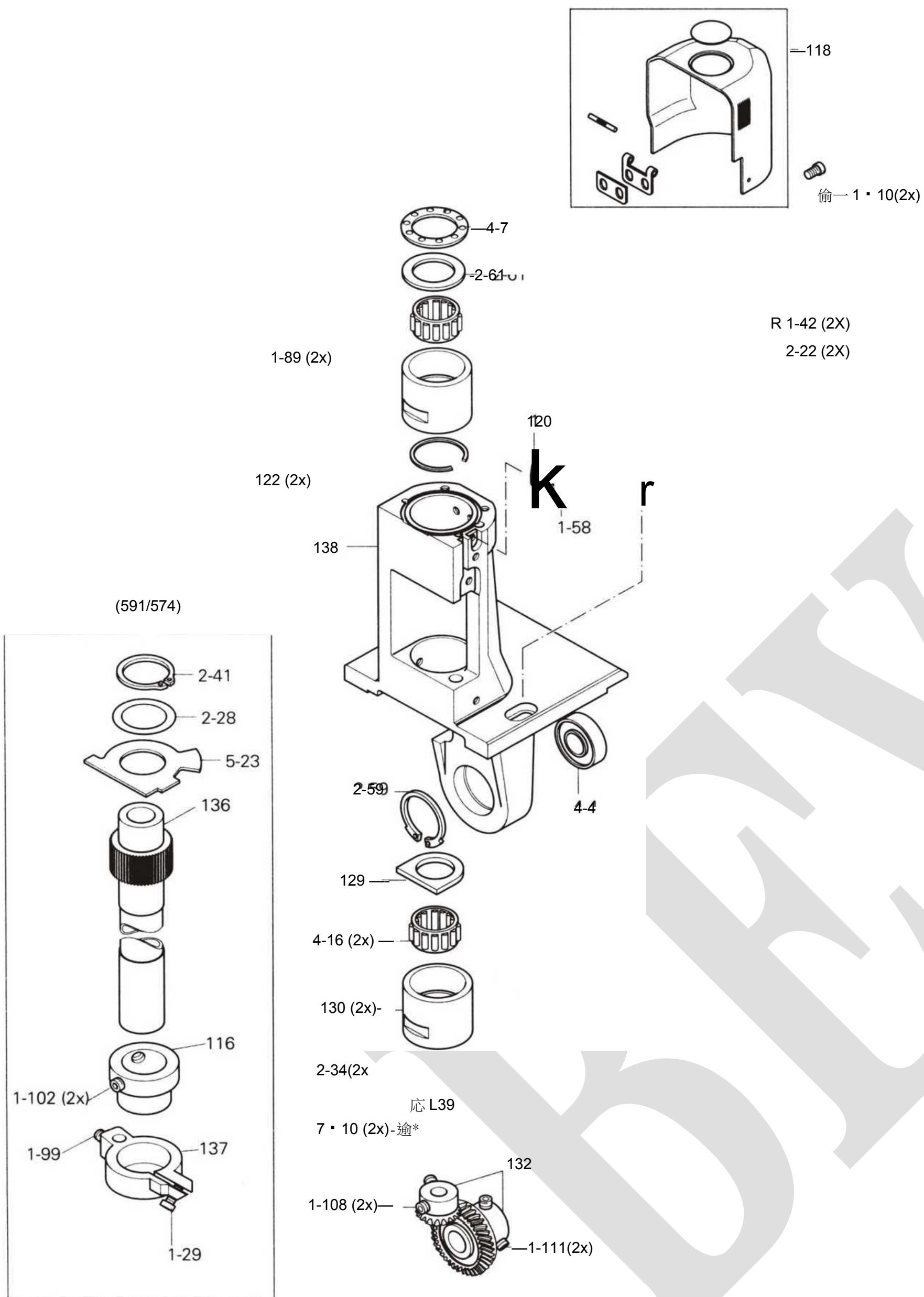
A **04** 底板零件
r Bedplate parts



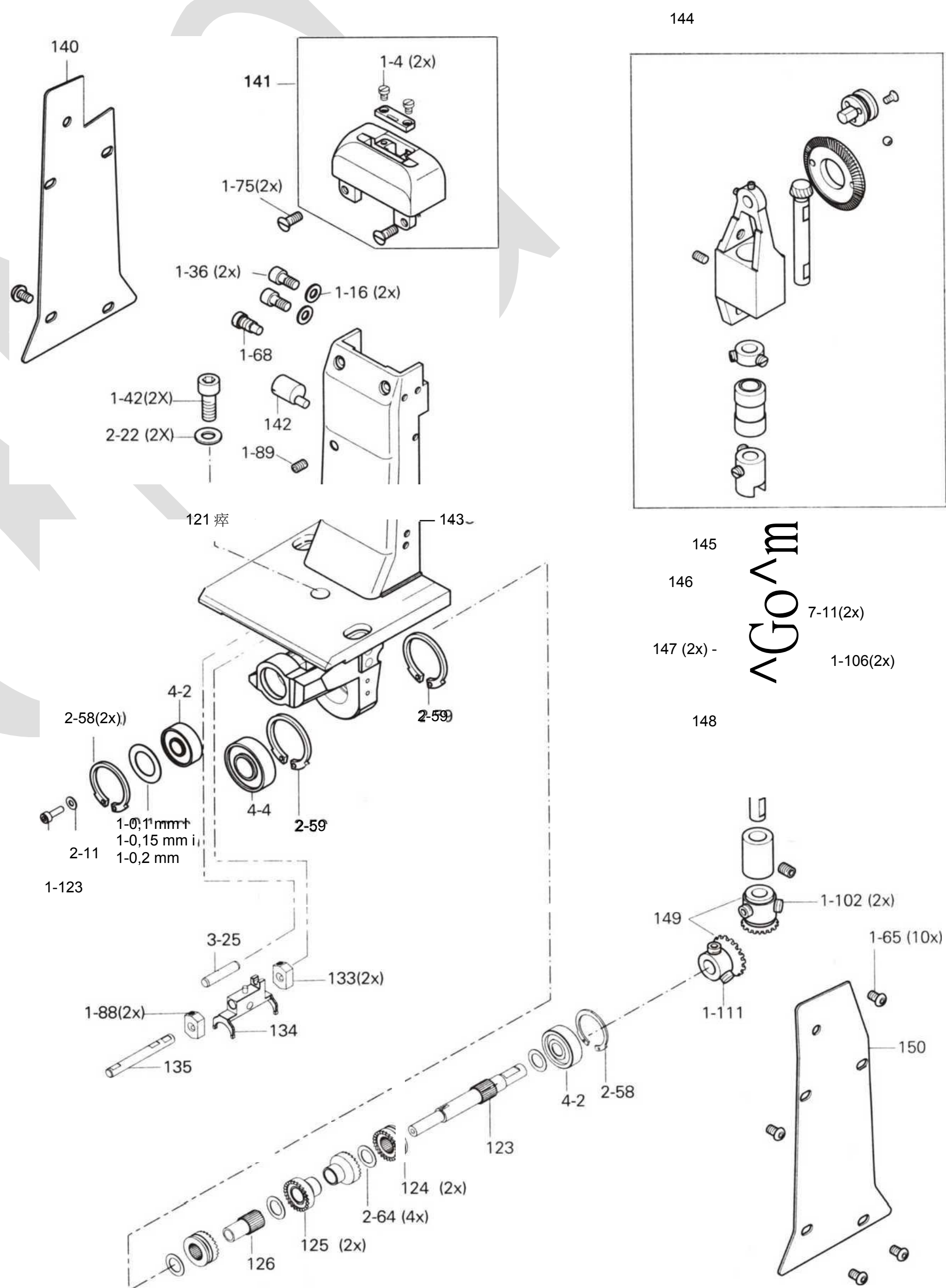
只 **ni** 左旋梭座
1 Hook postjeft



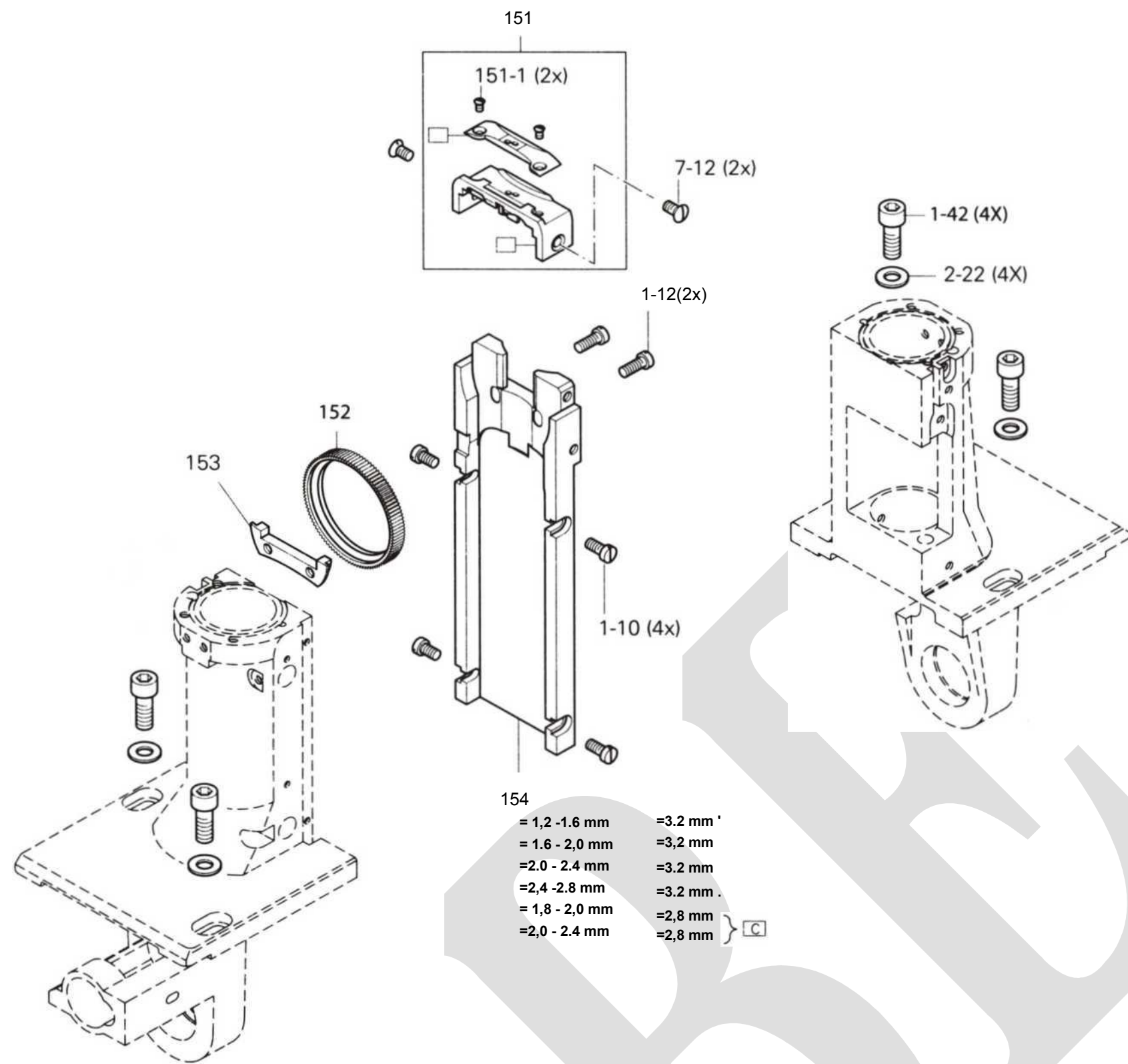
u no 右旋梭座
Hook post, right



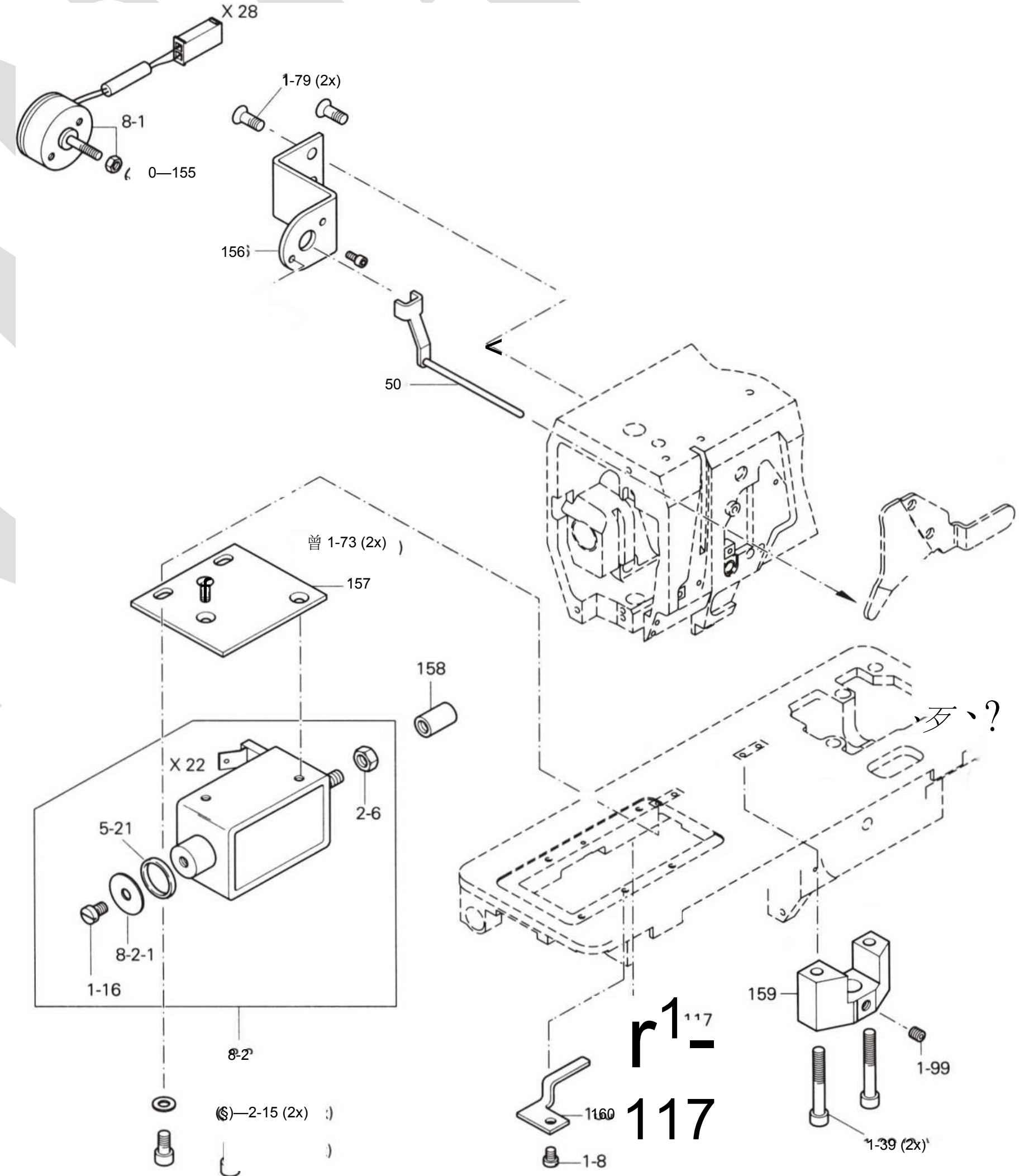
7 左送料輪座
Feed wheel postjeft



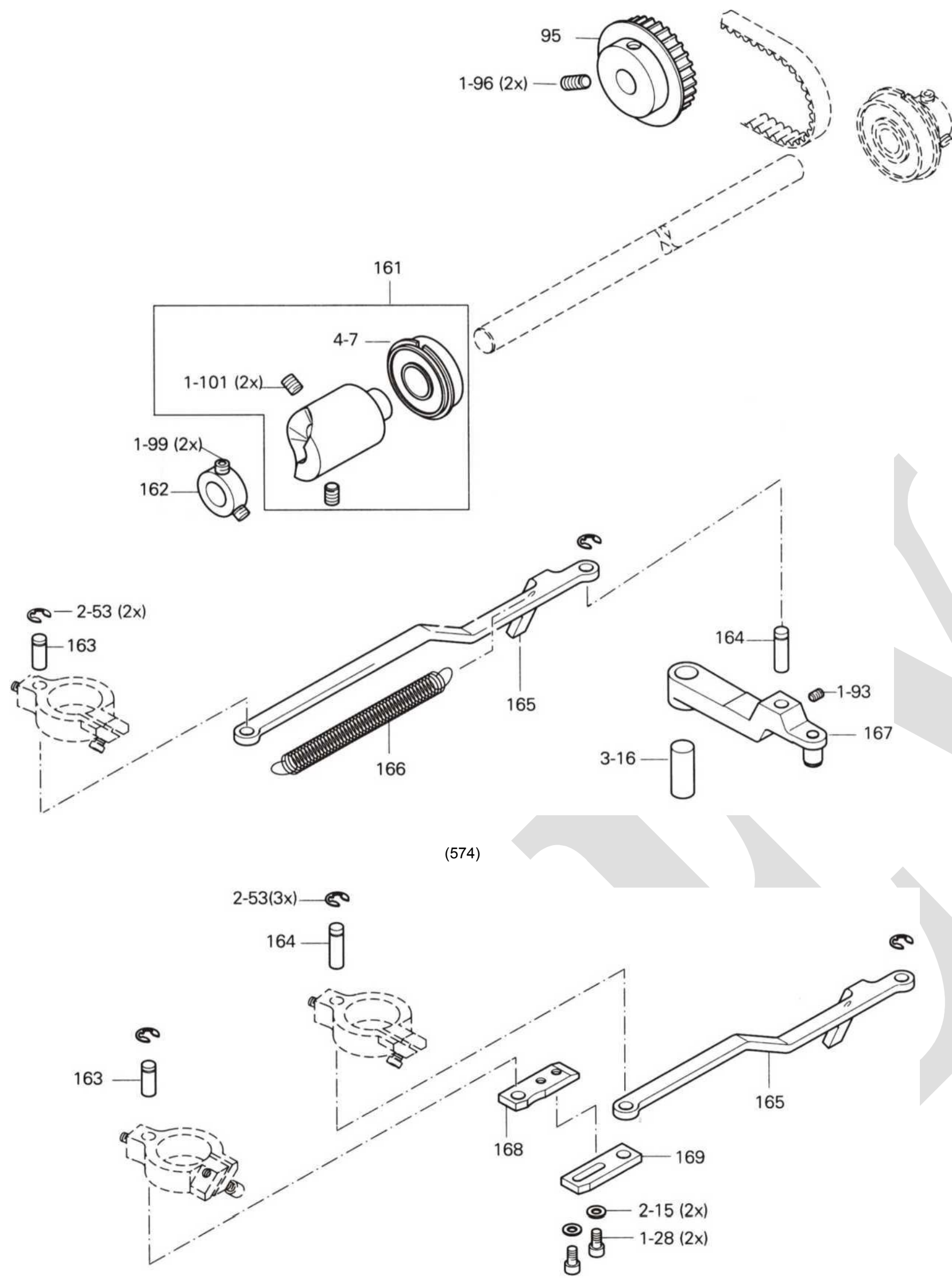
R 送料岭托板
 ◎ ■ Feed wheel mounting plate



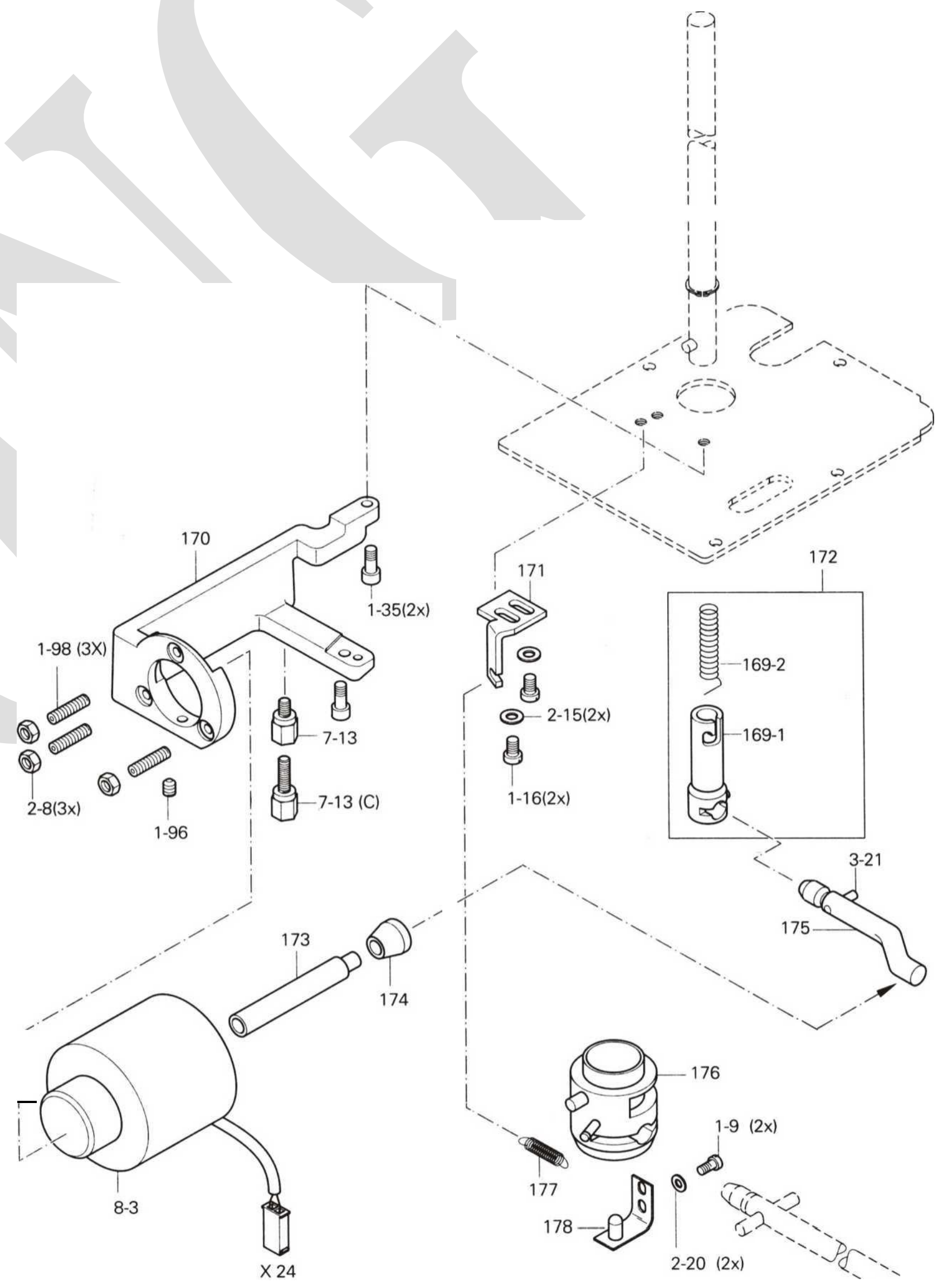
q ni 切线器
 ◦ ■ Thread trimmer



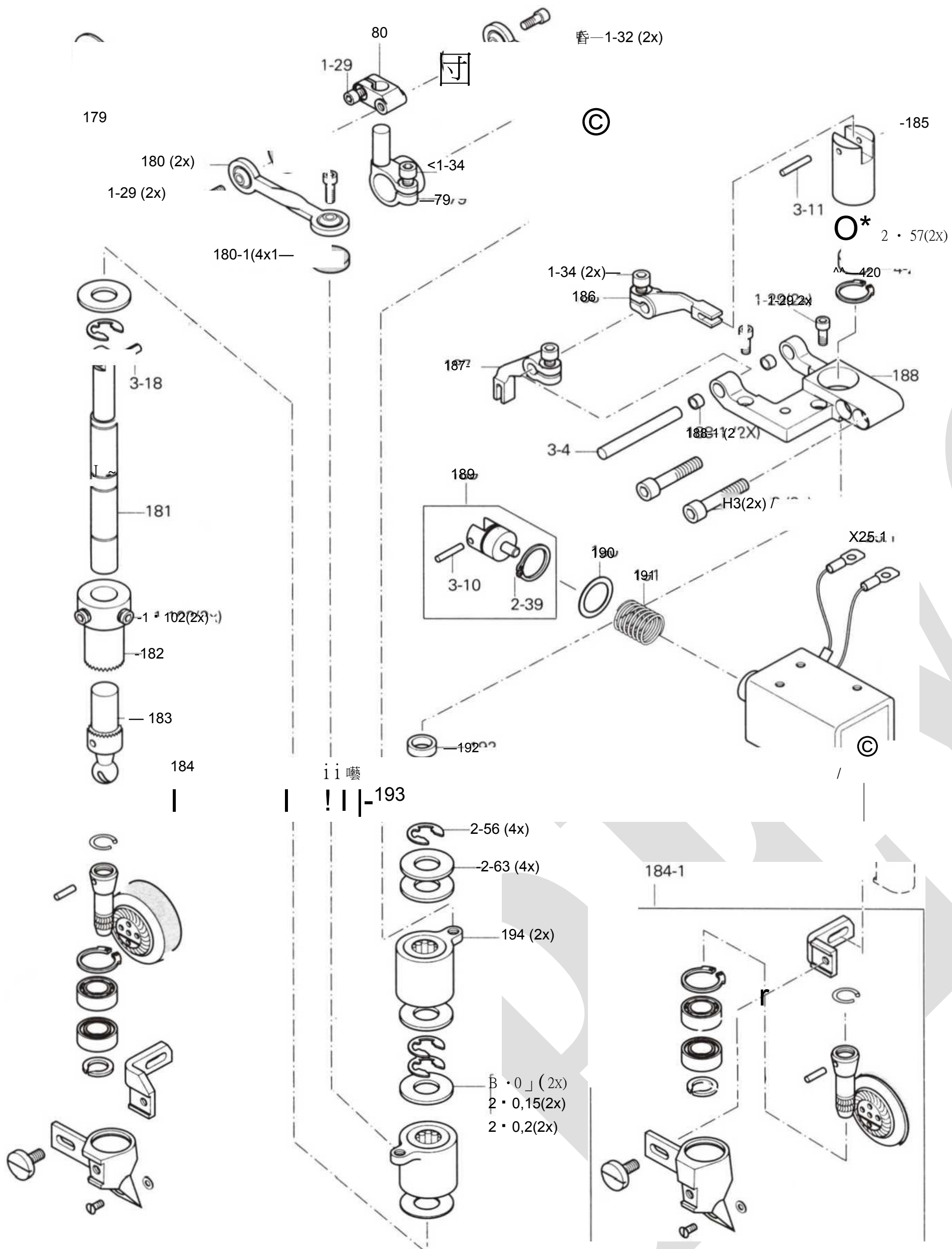
9.02 切綫器
Thread trimmer



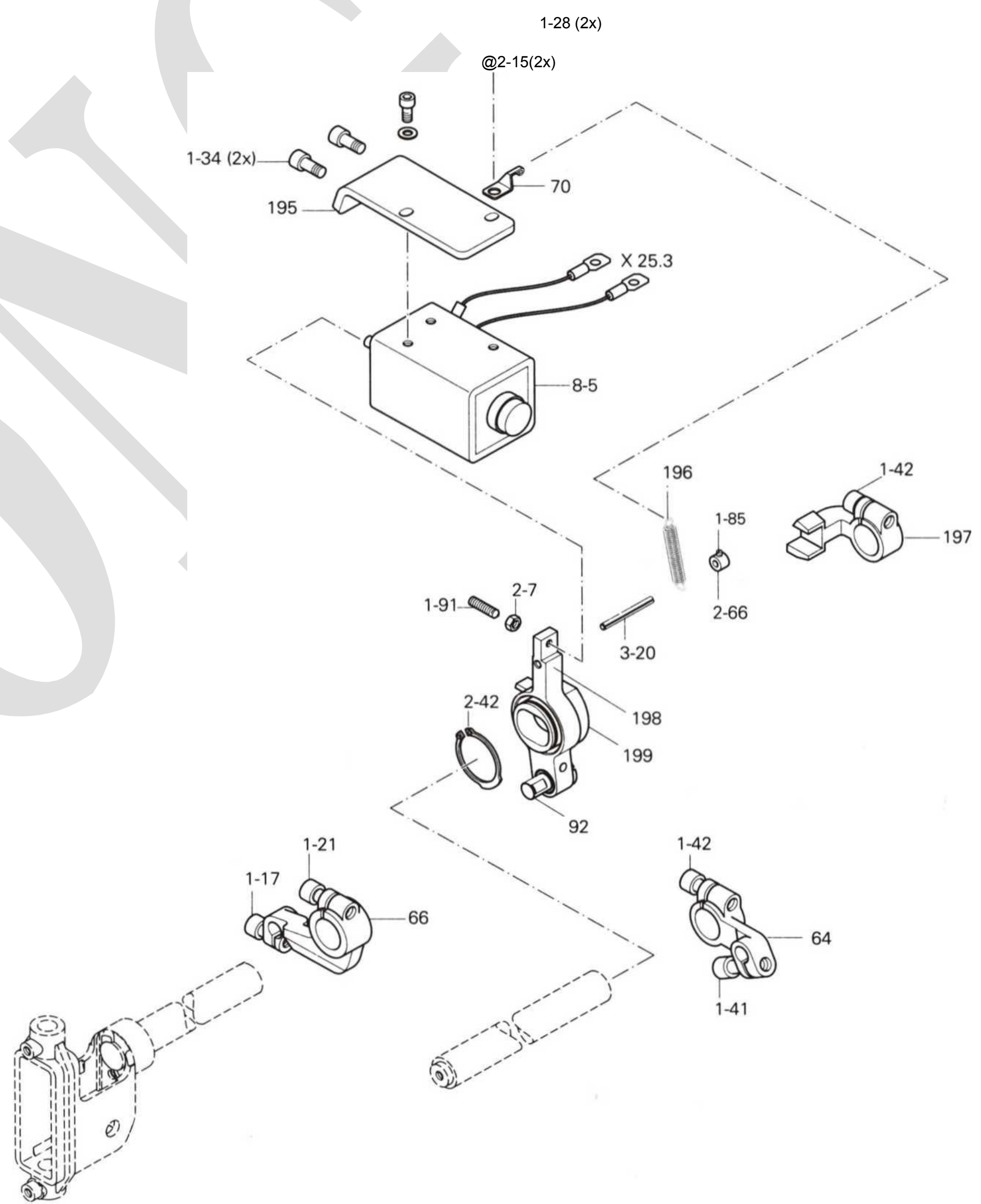
10. 壓脚自動提升器
Automatic presser foot lifter



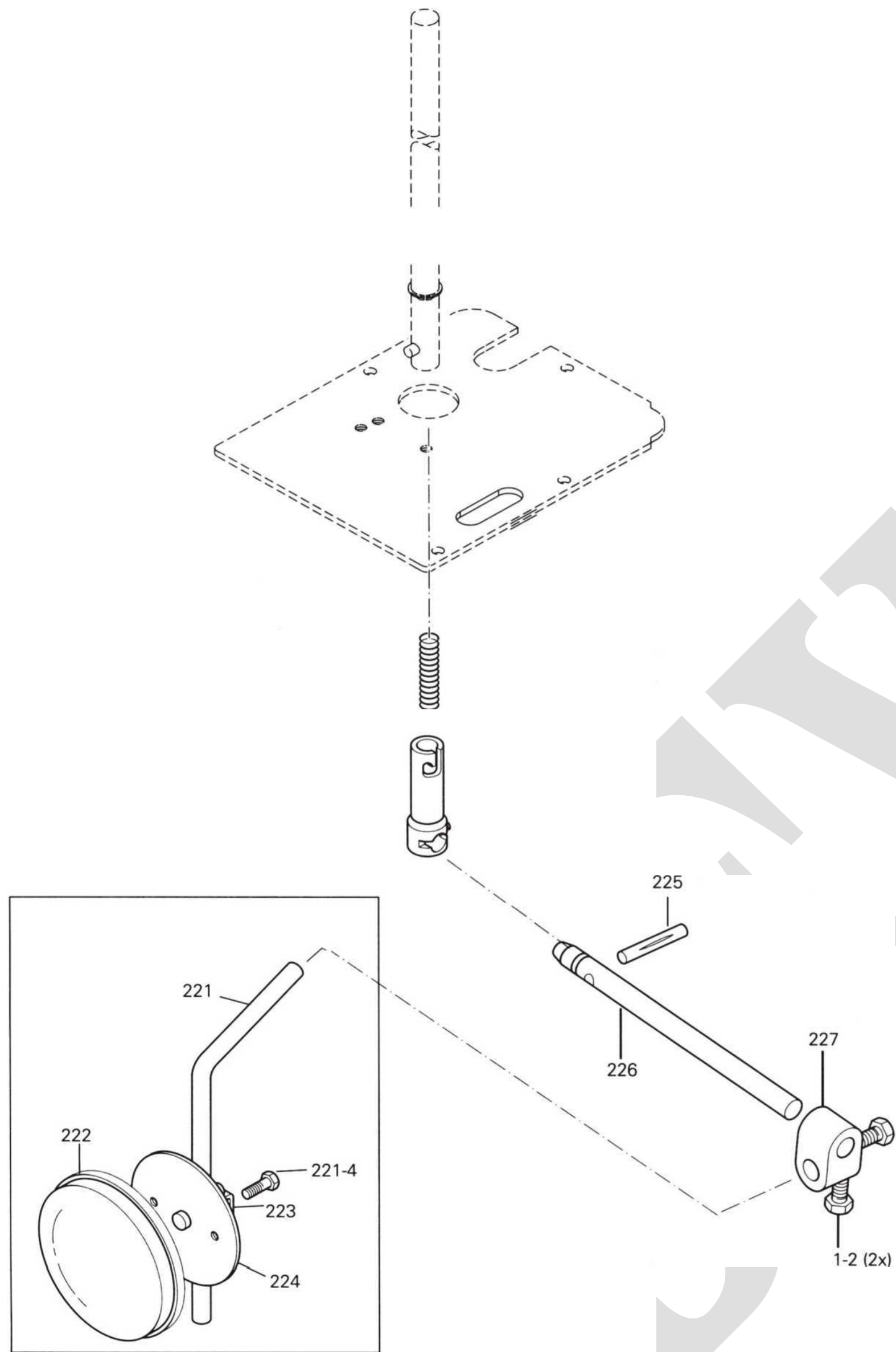
11 ni 鎖緊裝置
U' Backtacking mechanism



11.02 鎖緊裝置 Backtacking mechanism



膝鬆綫器零件
Pine hub parts of the knee



1代 用于桌板的零件
Parts for table top

