

## 工业缝纫机安全使用注意事项：

- 1.必须遵守基本措施；
- 2.必须经过专业培训，掌握缝纫机设备性能。
- 3.使用前应检查所有安全装置。
- 4.在安装机针、更换机针、压脚、针板、旋梭、梭子或修理时，应立即关闭电源；
- 5.离开缝纫机或工作场所时应关闭电源；
- 6.使用离合马达时，要等待马达完全停止后再进行；
- 7.缝纫机及附属装置使用的机油，润滑油等液体流入眼睛或沾到皮肤上应立即清洗；
- 8.禁止用手触摸缝纫机通电时的零件或装置；
- 9.有关工业用平缝机与包缝机的修理、改造、主要机构的调整由专门技术人员来进行；
- 10.一般的维修保养由专人进行；
- 11.在电气方面的修理应在电气技术员的监督和指导下进行；
- 12.缝纫机使用期间应定期清扫；
- 13.为了正常安全运转，应安装地线，同时应在不受高频焊接机等强噪声源影响的环境下使用；
- 14.电源插头应由专人安装；
- 15.工业用平缝机、包缝机在指定用途以外不能使用。

## 环保要求：

- 1.使用过程中产生的废油及其他废弃物请根据当地环保的要求进行合理的处置。
- 2.请在使用完后及时关闭电源，减少电能的消耗。
- 3.请在说明书要求的电压及环境下使用，已延长产品的使用寿命，减少废弃物的产生。
- 4.机器报废后请勿将本机器及其附件作为普通的生活垃圾处理。请遵守本设备及其附件处理的本地法令，并支持回收行动。

## Notes for safe use of industrial sewing machines:

1. Basic measures must be observed.
2. Pass the specialized training and master sewing machine equipment performance.
3. All safety devices should be checked before use.
4. When installing needle, and changing needle, presser foot, plate, hook, shuttle or repairing, the power supply should be turned off immediately.
5. Power should be turned off when leaving the sewing machine or workplace.
6. When using the clutch motor, please wait until the motor stops completely.
7. The machine oil and other liquids used in sewing machines and ancillary devices should be cleaned immediately when they are put into eyes or touch skin.
8. Do not touch the parts or devices when the machine is powered by hand.
9. The repair, renovation and adjustment of the main mechanisms of the relevant industrial sewing machines and overseers shall be carried out by specialized technicians.
10. General maintenance is carried out by specially-assigned persons.
11. Electrical repairs should be performed under the supervision and direction of the electrical technician.
12. The machine should be cleaned regularly during operation.
13. In order to operate normally and safely, ground lines should be installed, and they should be used in an environment free from strong noise sources such as high frequency welding machine.
14. Power plug should be installed by specially-assigned person.
15. Industrial lockstitch sewing machine and overlock sewing machine can not be used except the designated use.

## Environmental requirements:

1. Please dispose the waste oil and other waste products properly according to local environmental protection requirements.
2. Please turn off the power after use to reduce power consumption.
3. Please use under the voltage and environment required in the manual to extend the service life of the product and reduce waste generation.
4. Do not treat the machine and its accessories as ordinary household garbage after being scrapped. Please comply with local laws governing the disposal of the equipment and its accessories and support recycling operations.

# 使用说明书/Manual book

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## 1 安全 Safety

- 机器应该由受过专业培训或具有足够操作经验者在完全阅读和理解本说明书后操作。
- This machine may only be operated by adequately trained operators and only after having completely read and understood the Instruction Manual!
- 机器不能在安全装置下操作，必须遵循有关操作的所有安全规定。
- This machine may only be used for the purpose for which it is intended and may not be operated without its safety devices. All safety regulations relevant to its operation are to be adhered to.
- 当换缝纫零件（如机针、轮钱、针板和梭子）、穿线、离开机器后无人操作或者在维修保养时，应该关掉转换开关或拔掉电源插头。
- When exchanging sewing tools (e.g. needle, roller presser, needle plate and bobbin), when threading the machine, when leaving the machine unattended and during maintenance work, the machine is to be separated from the power supply by switching off the On/Off switch or by removing the plug from the mains!
- 日常维护工作应由受过训练的人员进行。
- Everyday maintenance work is only to be carried out by appropriately trained personnel!
- 维修和特殊的维护工作只能由合格的服务人员或受过专业培训的人员进行。
- Repairs and special maintenance work may only be carried out by qualified service staff or appropriately trained personnel!
- 电器设备操作只能由受过相关训练的人员操作。
- Work on electrical equipment may only be carried out by appropriately trained personnel!
- 不允许在带有电压的零件和装置上工作。
- Work is not permitted on parts and equipment which are connected to the power supply.



- 必须在遵守所有相关的安全规定的前提下才能修改和变更机器。
- Modifications and alterations to the machine may only be carried out under observance of all the relevant safety regulations!
- 在维修工作中只允许使用我们批准使用的备件，需要明确指出的是，所有不是由我们供货的备件和附件都未经我们检查，也没有被我们批准使用。装入和/或使用这样的产品可能会对机器的设计特性造成负面影响，对由于使用非原装零件造成的损失，我们不承担任何责任。
- Only spare parts which have been approved by us are to be used for repairs! We expressly point out that any replacement parts or accessories which are not supplied by us have not been tested and approved by us. The installation and/or use of any such products can lead to negative changes in the structural characteristics of the machine. We are not liable for any damage which may be caused by non-original parts.

## 2 特点及用途 Special features and applications

单/双针高速罗拉车（自动剪线、自动回缝、自动抬压脚）用于制鞋业，特别适用于缝制高档皮鞋、包袋、手套、帽子等弧形中厚料物品。

Single/Double Needle Post-bed Sewing Machine (Thread Trimming/Backstitch Sewing/Presser Foot) is used for shoe manufacturing, It is especially available for sewing on medium heavy weight articles with arc-shaped, such as superior leather shoes, hand bags, gloves, caps etc, it ensures you easy daily maintenance.



任何没有被制造商确认的机器使用都是不合理的，制造商不承担任何使用不当造成的机器损坏。合理的使用机器应遵循制造商确认的所有操作，包括调试、维护和维修措施。

Any and all uses of this machine which have not been approved of by the manufacturer are considered to be inappropriate! The manufacturer cannot be held liable for any damage caused by the inappropriate use of the machine! The appropriate use of the machine includes the observance of all operational, adjustment, maintenance and repair measures required by the manufacturer!

### 3 技术参数 Specifications

机针类型 Stitch type: ..... DP5X16 (#11- #21)

最大缝目 Max stitch length ... 7 mm/单针Single Needle 5mm/双针 Double Needle

最高缝纫速度 S.P.M ... 2500r/min/单针Single Needle 2200r/min双针Double Needle

噪音 Noise data ..... ≤82dB

净重 N.W ..... 67KG

毛重 G.W ..... 76KG

机壳尺寸 Sewing head dimensions:

总长 Length ..... 630 mm

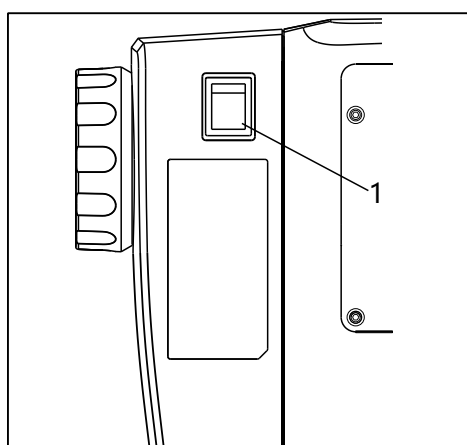
总宽 Width ..... 220 mm

高度 (台板以上) Height (above table) ..... 460 mm

台板尺寸 Bedplate dimensions ..... 1200 x 540 mm

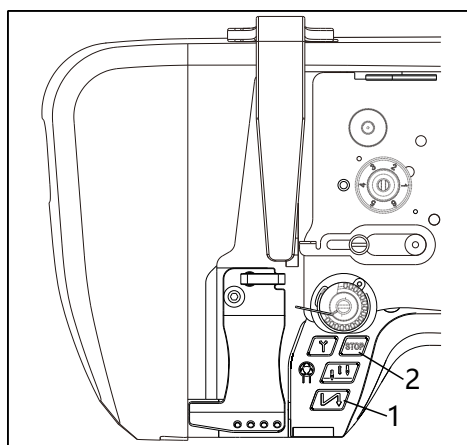
### 4 控制器 Controls

#### 4.01 控制开关 Controls On/off switch



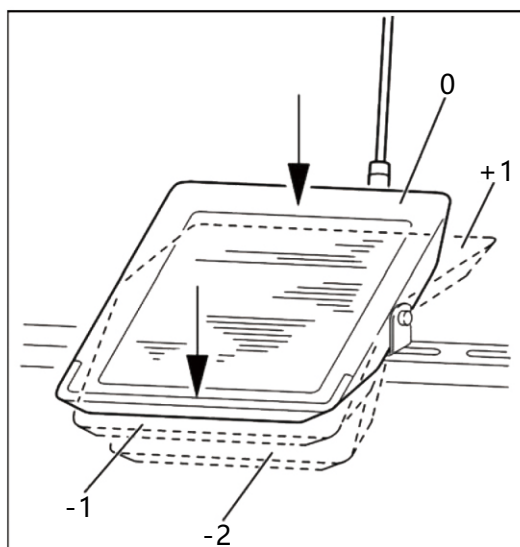
- 通过 1 键来接通或关闭电源。
- Through the key 1 to switch on or off the power

#### 4.02 机头开关 Keys on the machine head



- 机器工作时，按下按钮 1，机器倒针。
- 按钮 2 用于穿线及停机。
- As long as key 1 is pressed during sewing, the machine sews in reverse.
- Key 2 can be used to thread or shut down.

#### 4.03 脚踏板 Pedal



0=中间位 (机器不工作)

+1=机器处于缝制状态

-1=抬压脚

-2=剪线, 单段缝制结束

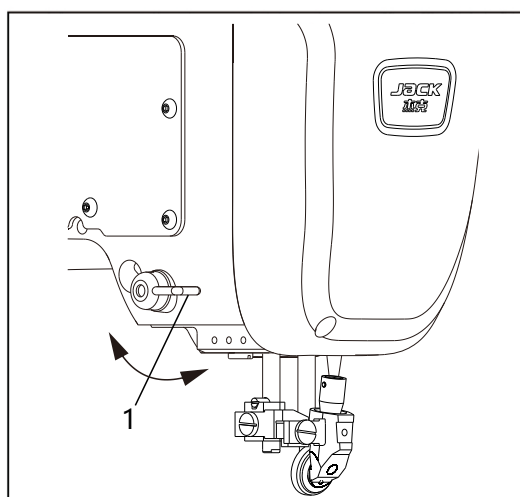
0=Neutral position

+1=Sewing

-1=Raise roller presser

-2=Trim sewing threads, end program segment

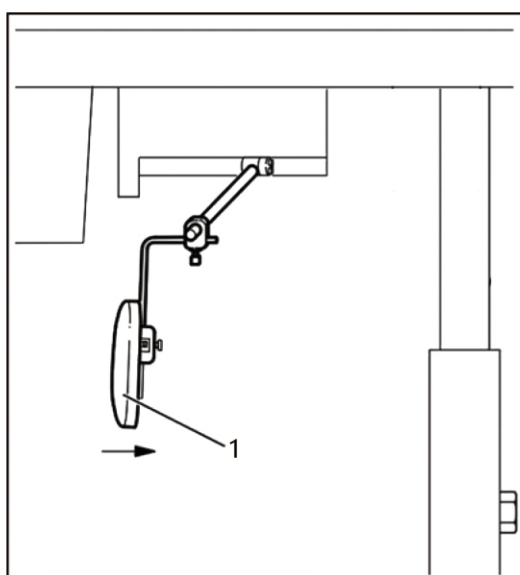
#### 4.04 手动抬压脚 Lever for lifting roller presser



•通过压棒提杆 1 可抬起轮钱组件。

•The roller presser can be raised by turning lever 1.

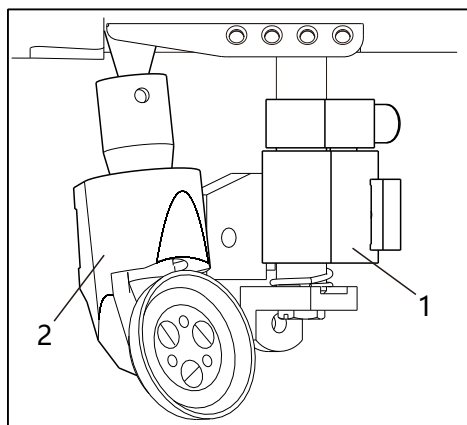
#### 4.05 膝控杠杆 Knee lever



•按箭头所示方向移动膝控杠杆 1 可抬起轮钱组件。

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

#### 4.06 轮钱转向 Swing out roller presser



- 当轮钱抬起时，可以压下1，推动轮钱2使之旋转。
- When the roller presser is raised, press down 1 and roller presser 2 can be swung out by pulling it lightly downwards.

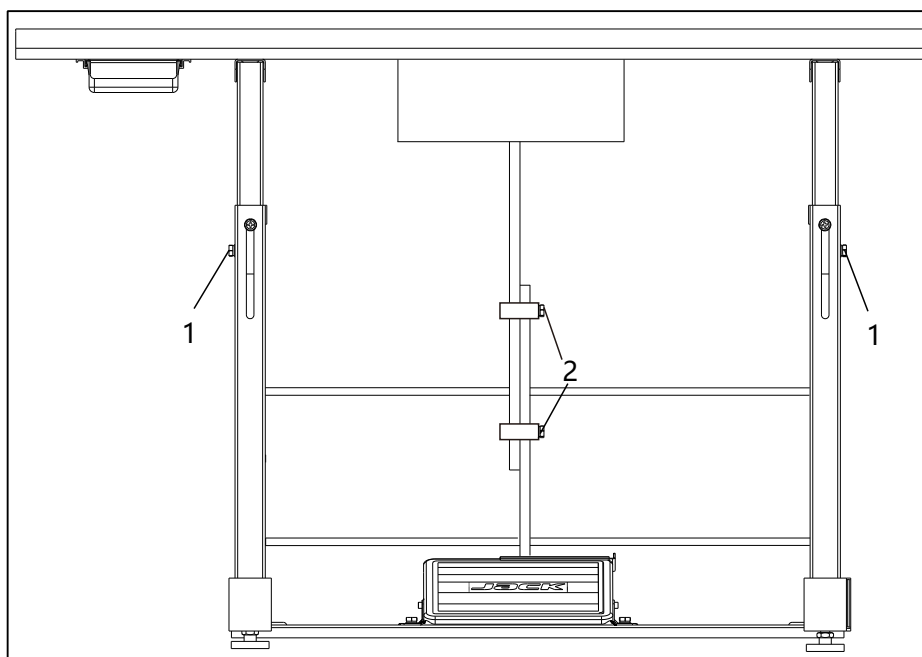
### 5 安装 Installation



为了运输方便，包装时要求尽可能的降低台板。以下描述如何调整台板高度。

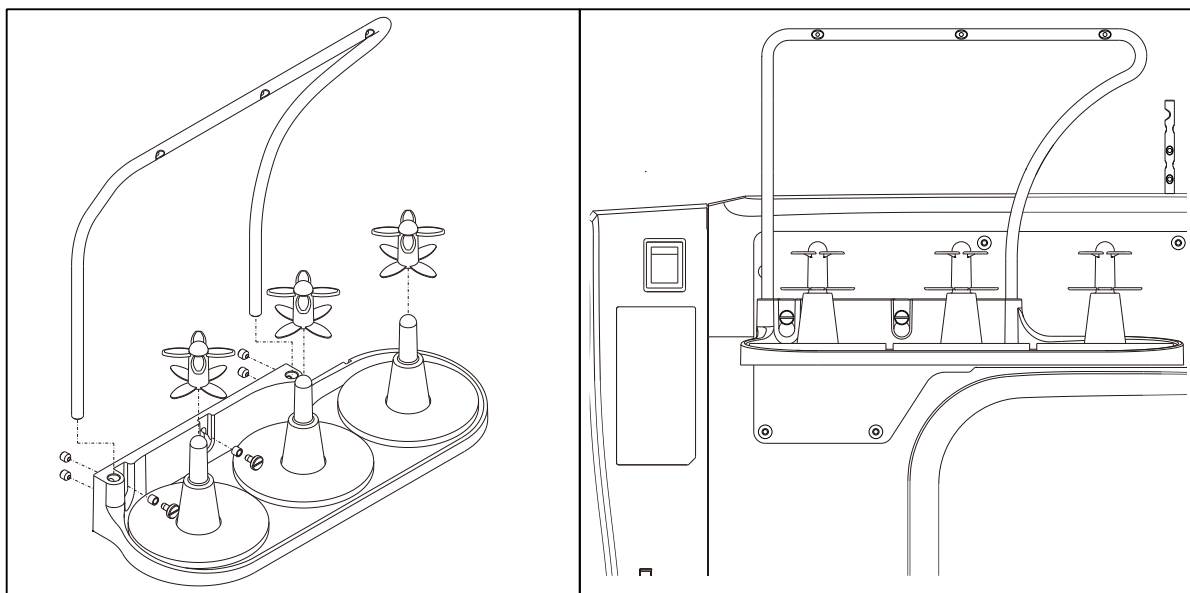
The method of packaging used requires that the table top be lowered for transport. The following is a description of how to adjust the height of the table top.

#### 5.01 调整台板高度 Adjusting the table-top height



- 松开螺钉 1 和螺钉 2 按需要调整台板高度。
- 锁紧螺钉 1。
- 调整脚踏板至您可以舒适工作的位置，然后锁紧螺钉 2。
- Loosen screws 1 and 2 and set the desired table-top height
- Tighten screws 1 well.
- Adjust the position of the pedal so that you can operate it comfortably and tighten screw 2.

## 5.02 安装线架 Fit the thread stand



- 如图所示安装线架。
- Fit the thread stand as shown.

## 6 调试 Commissioning



本说明书中的所有指令和条例必须遵循，特别要注意安全说明。

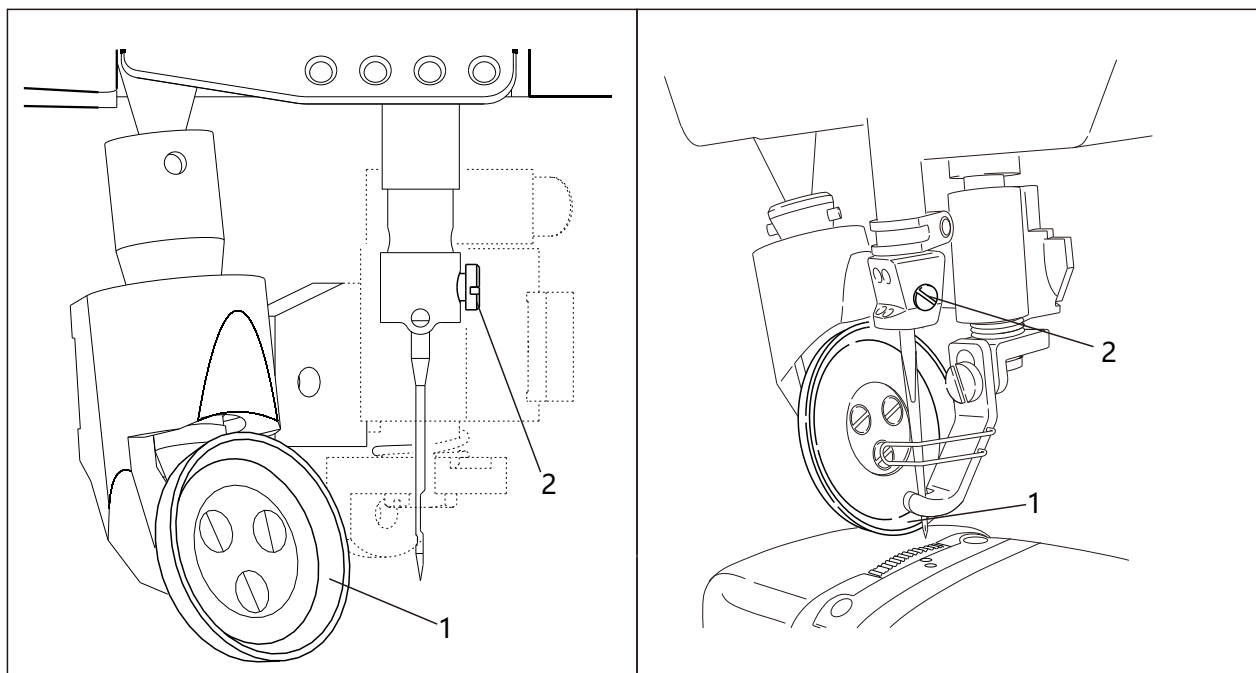
All instructions and regulations in this instruction manual must be observed. Special attention must be paid to all safety regulations!



所有安装工作必须由受过相关培训的人员进行。安装时关掉开关，脱离电压，或拔掉电源插座上的插头。

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.

## 6.01 安装机针 Inserting the needle



关掉机器，机器的意外启动可能会对您造成受伤的危险。

Switch off the machine!

Danger of injury due to unintentional starting of the machine!

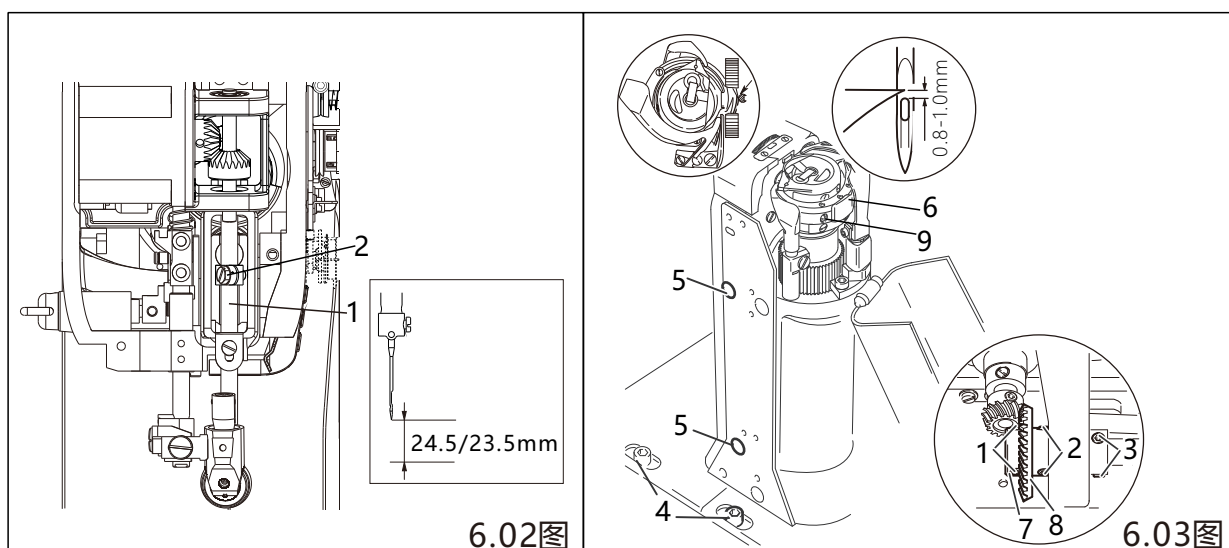
- 提升压脚 1 且向外旋转。
- 松掉螺钉 2，将机针插入最深处。长沟槽必须面向左（单针）。
- 松掉螺钉 2，将机针插入最深处，左针的长沟槽向右，右针的长沟槽向左（双针）。
- 锁紧螺钉 2，压脚转向至原位。
- Raise the roller presser 1 and swing it out.
- Loosen screw 2 and insert the needle as far as possible. The long groove must face to the left (Single needle).
- Loosen screws 2 and insert the needles as far as possible. The long groove of the left needle is facing right, and that of the right needle is facing left (Double needle).
- Tighten screws 2 and swing roller presser 1 back into position.

## 6.02 调整机针的高度 Adjusting the needle height

- 当针棒位于上死点时，针尖到针板间必须有(单针24.5/双针23.5mm)的距离。
- 松开螺钉2来调整针棒1。不要转动针棒。
- When the needle bar is at top dead centre, there must be a clearance of (Single needle 24.5/Double needle 23.5 mm) between the needle point and the needle plate.
- Adjust needle bar 1 by screw 2. Without turning it.

## 6.03 旋梭勾线及护针片调整(单针)

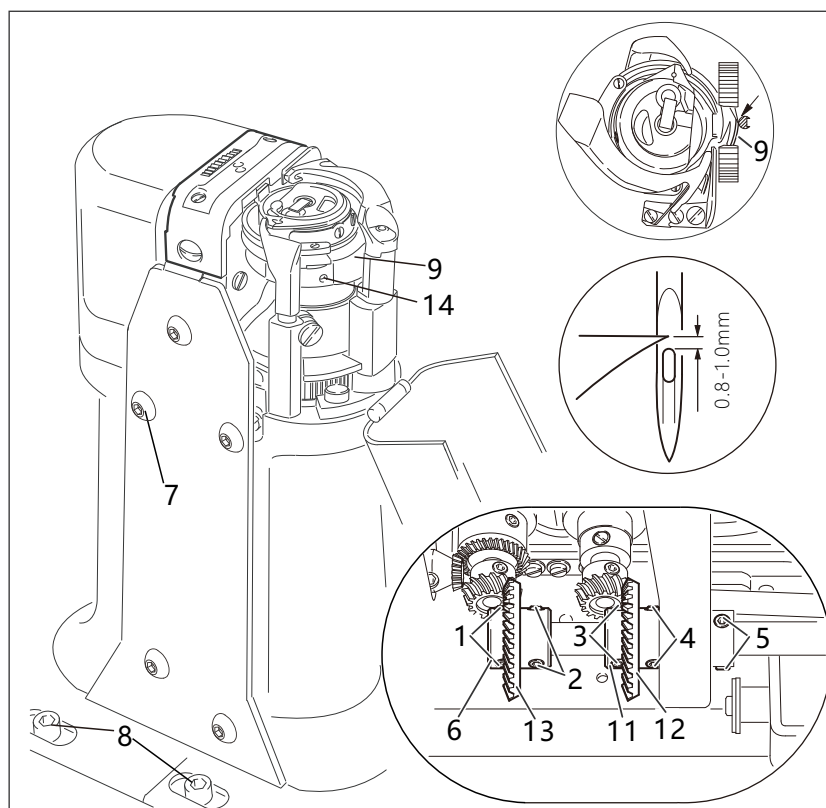
### Adjusting hook line and needle guard(Single needle)



- 将针距设置为“0”。针棒置于下死点后上升2.6mm。
- 拧松螺钉1-5，将旋梭尖对准针中心，确保护针片6不得挤压针。针孔的上缘应位于旋梭尖下方0.8-1.0mm处。
- 移动边座使旋梭尖与针有0.05-0.1mm的距离，拧紧螺钉4和3。
- 注意锥齿轮间隙，拧紧螺钉2及定环7上的螺钉1。
- 调整螺钉9使护针片6与针有轻微接触。拧紧螺钉5。
- 以上操作仅能由专业人员完成。
- Set stitch length at "0". Bring needle bar to 2.6mm past bottom dead center.
- Loosen screws 1-5, set hook point at needle center, making sure that the needle is not deflected by needle guard 6. The top of the needle eye must be below the hook point 0.8-1.0 mm.
- Adjust hook post, making sure that there is 0.05-0.1mm between hook and needle, tighten screws 4 and 3.
- Making sure that there is some clearance in the bevel gear, tighten screws 2 and 1. Adjust screw 9, making sure that the needle guard 6 touch the needle lightly. Tighten screw 5.
- All following adjustment may only be carried out by expert staff trained for this purpose.

## 6.04 旋梭勾线及护针片调整(双针)

### Adjusting hook line and needle guard(Double needle)

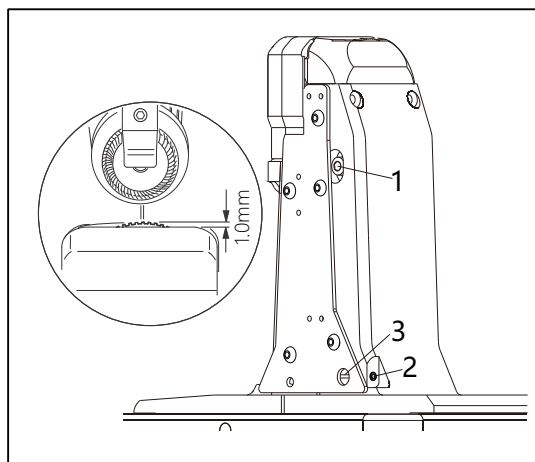


- 将针棒置于下死点后上升 2.8mm。
- 拧松螺钉 1-8，将两个旋梭尖对准针中心，确保护针片 9 不得挤压针。针孔的上缘应位于旋梭尖下方 0.8-1.0mm 处。
- 移动边座使旋梭尖与针有 0.05-0.1mm 的距离，拧紧螺钉 8 和 5。
- 注意锥齿轮间隙，拧紧螺钉 2/4 和 1/3。
- 调整螺钉 14 使护针片 9 与针有轻微接触。
- 以上操作仅能由专业人员完成。
- Bring needle bar to 2.8mm past bottom dead center.
- Loosen screws 1-8, set two hook points at needle center, making sure that the needle is not deflected by needle guard 9. The top of the needle eye must be to below the hook point 0.8-1.0 mm.
- Adjust hook post, making sure that there is 0.05-0.1mm between hook and needle, tighten screws 8 and 5.
- Making sure that there is some clearance in the bevel gear, tighten screws 2/4 and 1/3.
- Adjust screw 14, making sure that the needle guard 9 touch the needle lightly.
- All following adjustment may only be carried out by expert staff trained for this purpose.



## 6.05 调整送金轮的高度(单针)

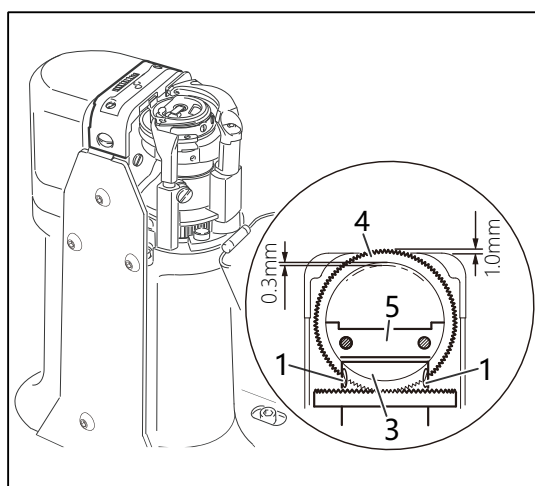
### Adjusting the height of the feed wheel(Single needle)



- 向外摆动轮钱组件。拧松螺钉 1 和 2。
- 调整偏心销 3, 使送金轮高出针板约 1.0mm。拧紧螺钉 2 和 1。
- Swing out the roller presser. Loosen screws 1 and 2.
- Adjust eccentric 3, making sure that the feed wheel should protrude from the needle plate by 1.0mm. Tighten screws 2 and 1.

## 6.06 调整送料齿轮的高度(双针)

### Adjusting the height of the gear(Double needle)

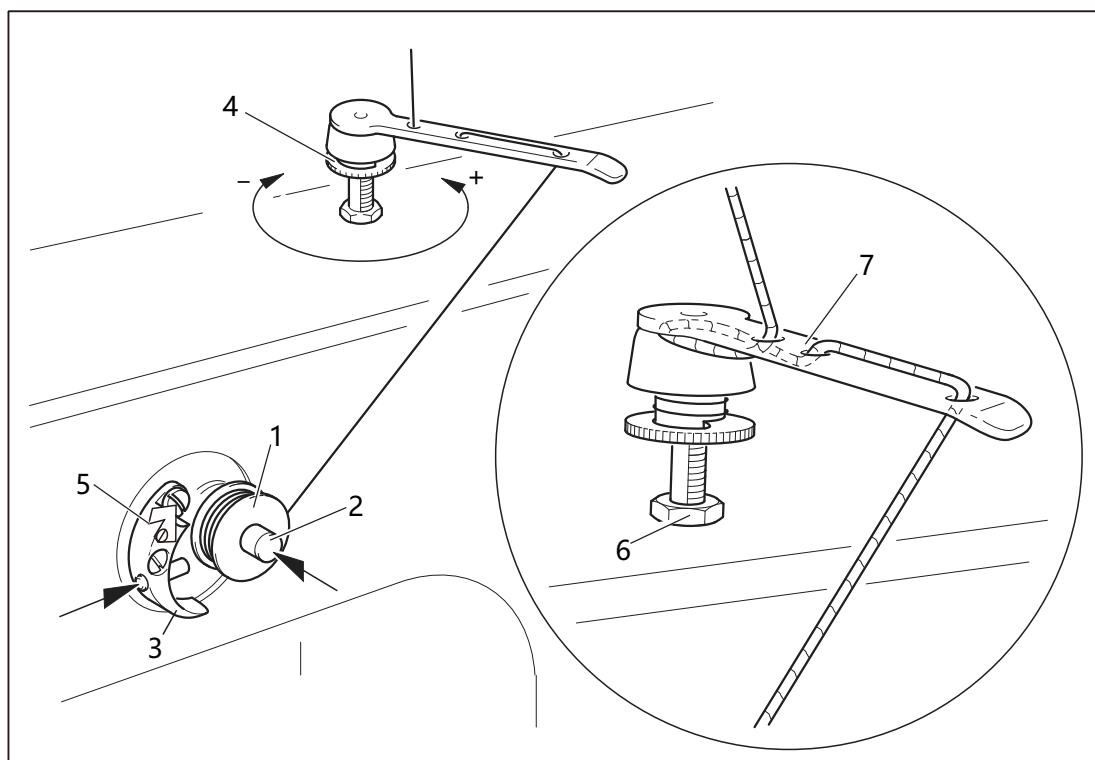


- 向外摆动轮钱组件。拧松螺钉 1。
- 调整送料平面齿轮 3, 使当在送料齿轮 4 上施加压力时, 它高出针板约 1.0mm。注意送料平面齿轮 3 和送料齿轮 4 的齿要相互正确地啮合。
- 拧紧螺钉 1。
- 当没有向送料齿轮 4 上施加压力时, 其在垂直方向应有 0.3mm 间隙。如果没有, 则松开螺钉 2, 调整固定板 5, 拧紧螺钉 2。
- 以上操作仅能由专业人员完成。

- Swing out the roller presser. Loosen screws 1.
- Adjust the feeding plane wheel 3. When pressure is applied to the gear 4, it should protrude from the needle plate by 1.0mm. Take care to see that the teeth of the feeding plane wheel 3 and gear 4 lock into each other properly.
- Tighten screws 1.
- When no pressure is applied to the gear 4, it should have a vertical clearance of approx. 0.3mm. If not, loosen screws 2 and adjust fixing plate 5. Finally, tighten screws 2.
- All following adjustment may only be carried out by expert staff trained for this purpose.

## 6.07 绕底线, 调节缝线张力

### Winding the bobbin thread, adjusting the thread tension



- 安装空梭子 1 至梭子轴 2 上。
- 按图穿线且逆时针旋转梭子几圈。
- 按下梭子轴 2 和顶杆 3 接通打线器。
- Place an empty bobbin 1 onto bobbin shaft 2.
- Thread the bobbin in accordance with the pictures 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.



机器运转时梭子会自动绕满。

The bobbin fills up during sewing.

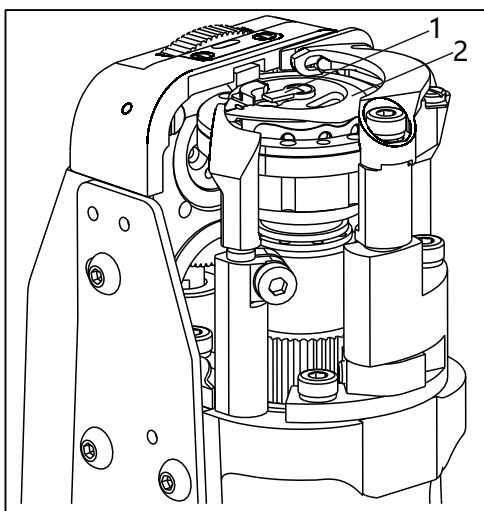
- 梭子 1 上线的张力可以通过滚花螺丝 4 调节。
- 梭子上的线绕满时会自动停止绕线。
- 拿下绕满线的梭子 1, 通过切刀 5 剪线。
- The tension of the thread on bobbin 1 can be adjusted with knurled screw 4.
- The bobbin winder stops automatically when bobbin 1 is full.
- Remove the filled bobbin 1 and cut the thread on knife 5.



如果绕线不均匀，松掉螺丝 6 根据需要旋转绕线柄 7，调整好后锁紧螺丝 6。

If the thread is wound unevenly, loosen nut 6 and turn thread guide 7 accordingly. Retighten nut 6 after the adjustment.

## 6.08 拆卸/安装梭壳 Removing/Inserting the bobbin case



关掉机器，机器的意外启动可能会对您造成伤害。

Switch the machine off! Danger of injury if the machine is started accidentally!

拆卸梭壳：

- 打开大釜盖
- 拔起闭锁 1 取出梭壳 2.

Removing the bobbin case:

- Open the post cap.
- Raise latch 1 and remove bobbin case 2.

安装梭壳：

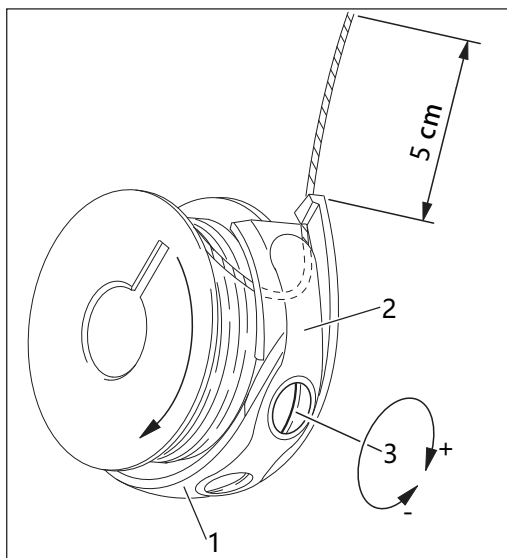
- 放入梭壳 2.
- 按下闭锁，关上大釜盖。

Inserting the bobbin case:

- Insert bobbin case 2.
- Close the latch and close the post cap.

## 6.09 梭壳穿线/调整梭线张力

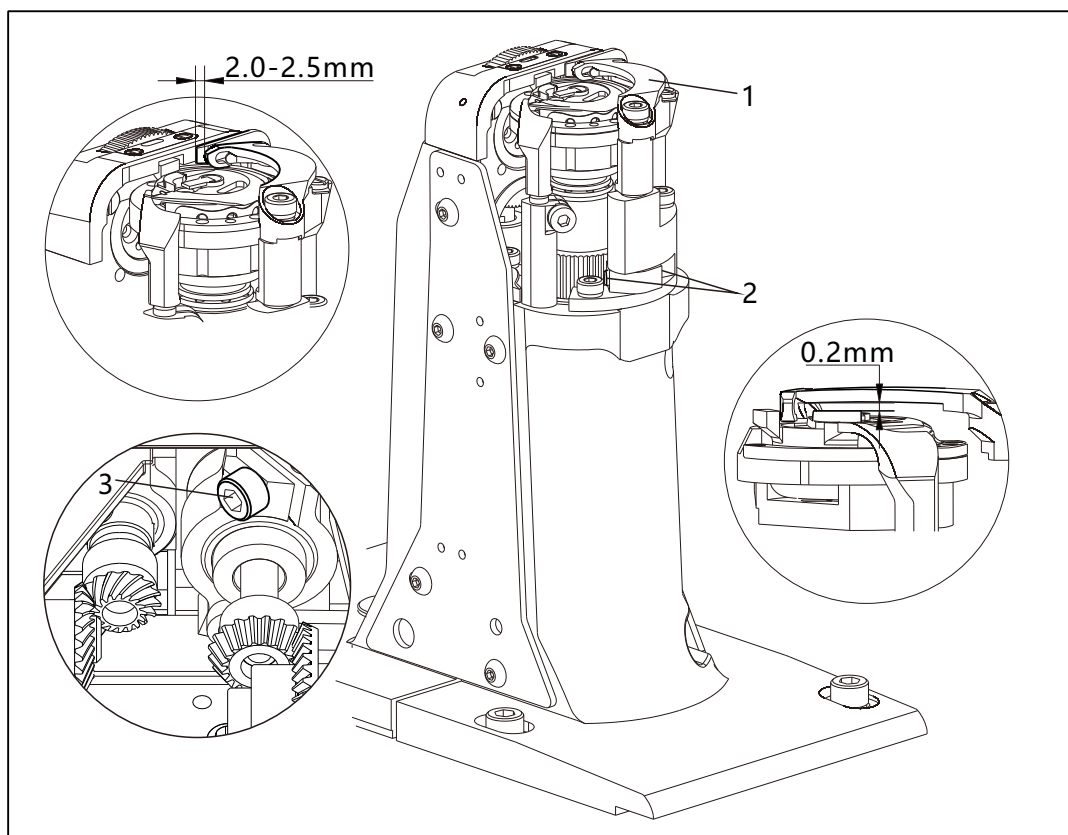
### Threading the bobbin case/Adjusting the bobbin thread tension



- 装入梭子至梭壳 1 内。
- 线穿过弹板 2 下面的槽内。
- 线穿过凹口。
- 通过旋转螺丝 3 调整线的张力。
- Insert the bobbin into the bobbin case 1.
- Pass the thread through the slot under spring 2.
- Pass the thread through the notch.
- Adjust the thread tension by turning screw 3.

## 6.10 调整动刀的位置

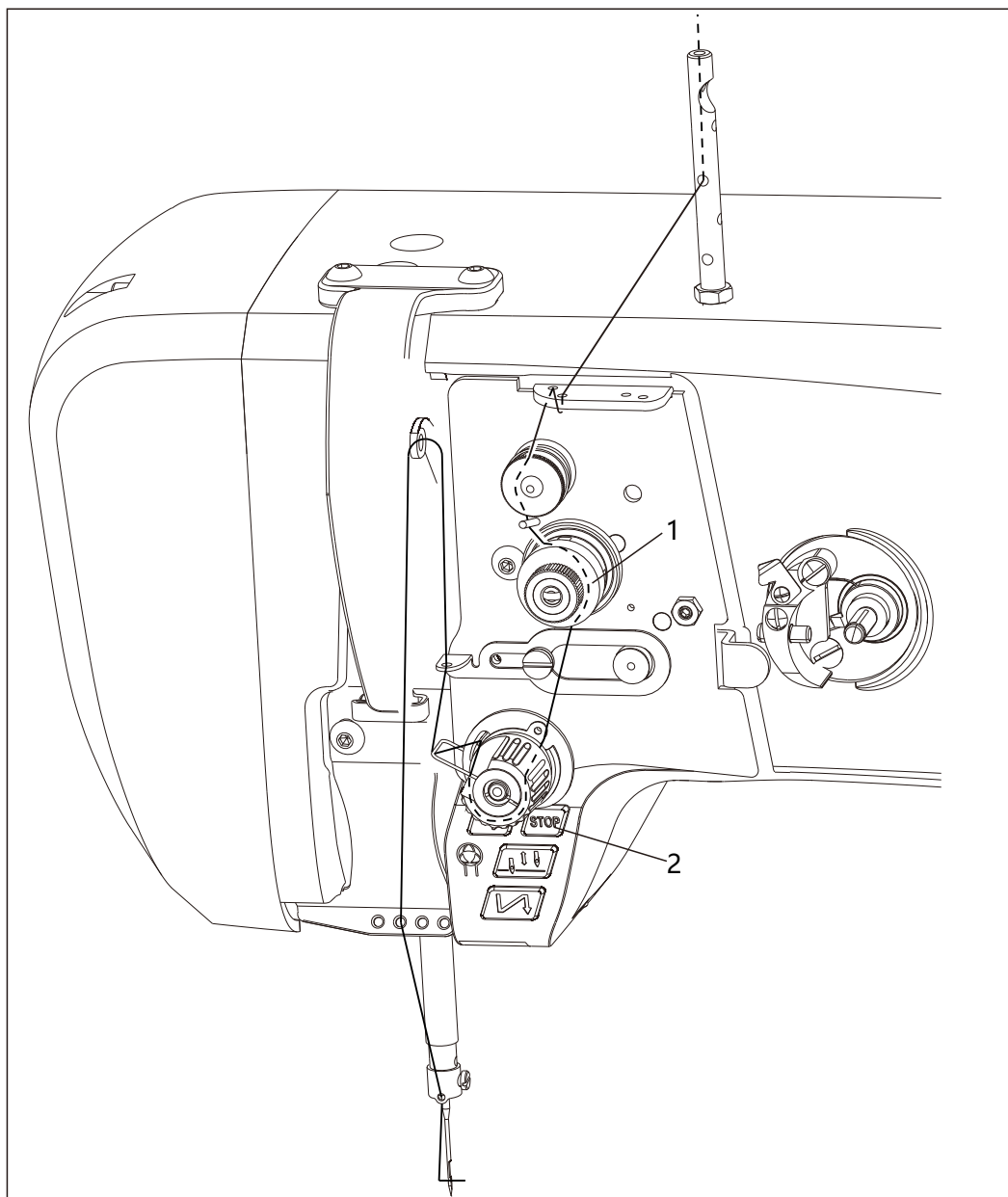
### Adjusting the position of the moving knife



- 松开两个螺钉 2。调整动刀 1 的高度，使动刀底边与梭壳最高点有 0.2mm 距离。拧紧螺钉 2。
- 松开螺钉 3。调整动刀 1 的位置，使空挡时动刀刃位于定刀刃后面 2.0-2.5mm。拧紧螺钉 3。
- 以上操作仅能由专业人员完成。
- Loosen screws 2. Adjust the height of the moving knife, making sure that the bottom edge of the moving knife should be at a distance of 0.2 mm from the top of the bobbin case. Tighten screws 2.
- Loosen screws 3. Adjust the position of the moving knife, making sure that when the moving knife is in its neatural position, the edge of moving knife should be positioned approx. 2.0-2.5 mm behind the edge of the fixed knife. Tighten screw 3.
- All following adjustment may only be carried out by expert staff trained for this purpose.

## 6.11 单针穿线及调节张力

### Threading the needle thread and regulating its tension(Single needle)



关掉机器或按“STOP”键2。机器的意外启动可能会对您造成伤害。

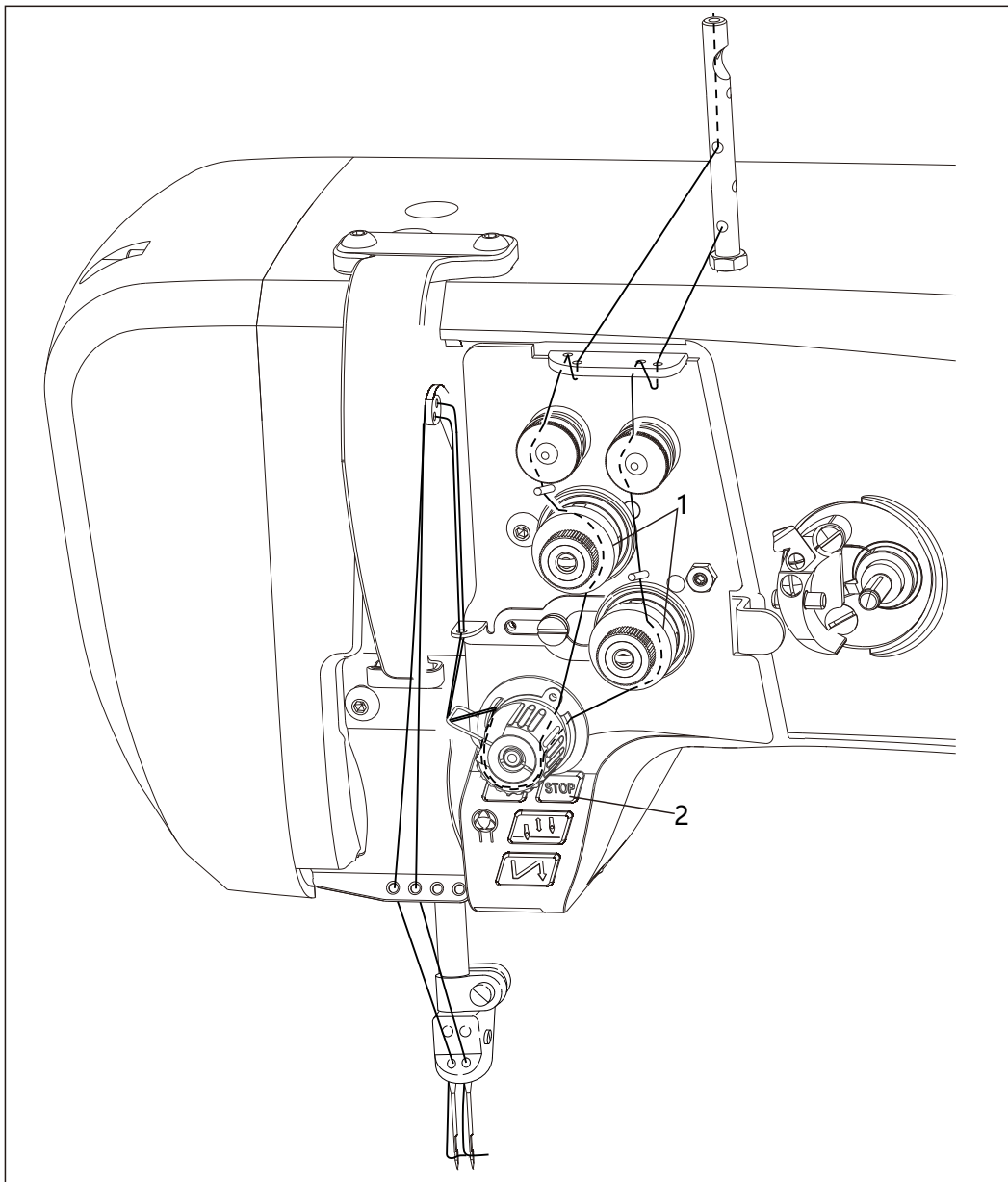
Switch the machine off or press the key “STOP” 2.

Danger of injury if the machine is started accidentally!

- 如图所示穿线
- 穿线方向为从左到右。
- 通过滚花螺丝1可以调节线的张力。
- Thread the needle thread as shown.
- The needle is threaded from the left to the right.
- Adjust the needle thread tension by turning milled screw 1.

## 6.12 双针穿线及调节张力

### Threading the needle thread and regulating its tension(Double needle)



关掉机器或按“STOP”键2。机器的意外启动可能会对您造成受伤的危险。

Switch the machine off or press the key “STOP” 2.

Danger of injury if the machine is started accidentally!

- 双针穿线方法如图所示
- 左针穿线方向为从右到左，右针的穿线方向为从左到右。
- 通过滚花螺丝1可以调节线的张力。
- Thread both needle threads as shown.
- 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 tensions by turning milled screws 1.

## 7 维护和保养 Care and maintenance

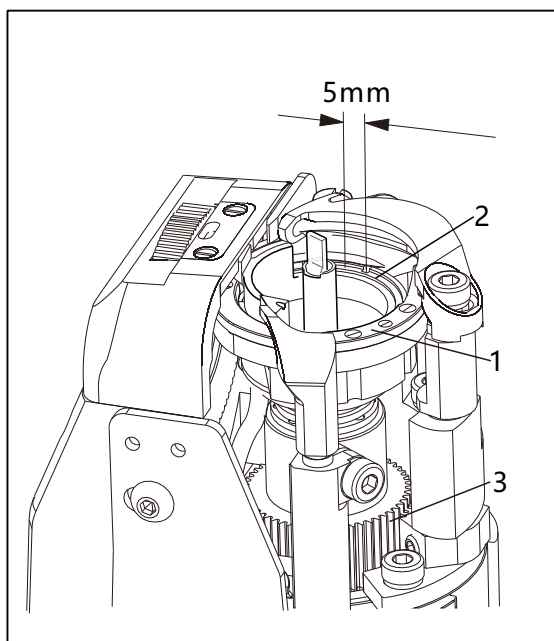
### 7.01 维护和维护周期 Servicing and maintenance intervals

清理.....	每天, 连续操作时更频繁
检查油位 (面线润滑/梭头润滑) .....	每天使用之前
梭头槽的注油 .....	每天使用之前
传动齿轮的润滑 .....	一年一次
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 bevel gears .....	once a year

### 7.02 清理 Cleaning

在机器连续使用时, 每天都需对梭头、内釜、平面送料齿轮清理几次。

Clean the hook, hook compartment and toothed wheel daily, several times if in continuous use.



关掉机器, 机器的意外启动可能会对您造成受伤的危险

Switch the machine off!

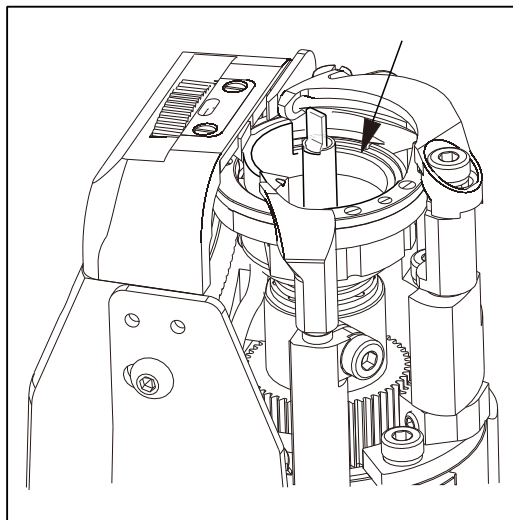
Danger of injury if machine is started accidentally!

- 将针棒移至最高点。
- 打开大釜盖, 取下梭壳盖和梭子。
- 旋松压板 1。旋转手轮直到梭壳尖点进入梭头槽内约 5mm。
- 取下梭壳 2。用石蜡清理梭壳。
- 放入梭壳时要确保梭子能顺利装入。
- 梭壳凸起插入针板槽内。
- 锁紧压板 1。关上大釜盖。

- Bring the needle bar to its highest position.
- Open the post cap and remove the bobbin case cap and the bobbin.
- Unscrew hook gip 1. Turn the handwheel until the point of bobbin case 2 penetrates into the groove of the hook race approx. 5 mm.
- 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.
- Screw hook gip 1 back on and close the post cap.



### 7.03 梭头槽的润滑 Oiling the hook



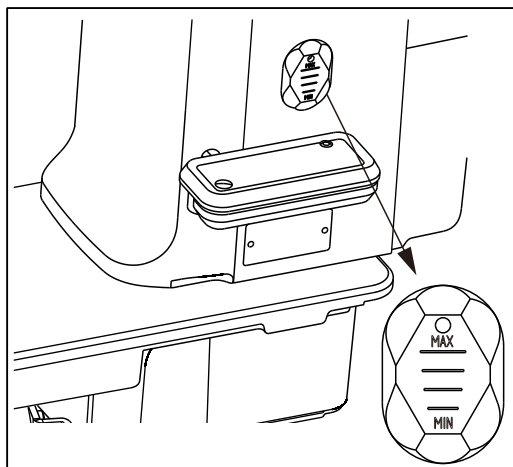
关掉机器, 机器的意外启动可能会对您造成伤害的危险。

Switch the machine off!

Danger of injury if the machine is started accidentally!

- 在机器调试前或机器长期未操作的情况下, 需要将勾线器 (见箭头) 滴几滴润滑油。
- Before commissioning the machine, and after long periods out of operation, pour a few drops of oil into the hook race (see arrow).

### 7.04 梭头的润滑注油 Oil bowl for hook lubrication



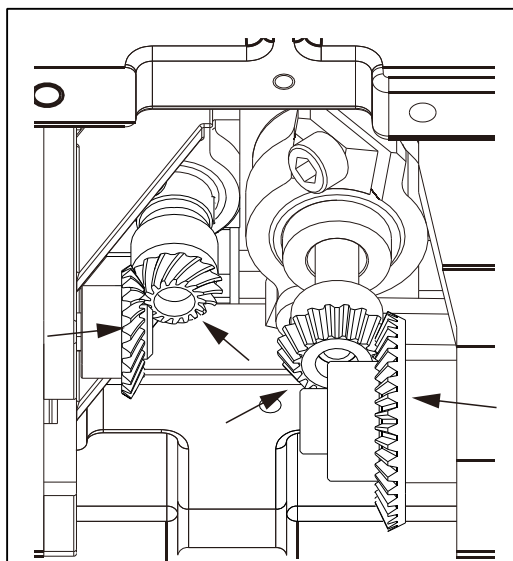
使用之前必须检查油位。确保油量位于 MIN 和 MAX 之间。

Check the oil level before each use.

Making sure that the oil level is between MIN and MAX.

- 如果需要可以从油箱 1 注油孔加油。
- If required refill oil through hole of reservoir 1.

### 7.05 传动齿轮的润滑 Lubricating the bevel gears



关掉机器, 机器的意外启动可能会对您造成伤害的危险。

Switch the machine off!

Danger of injury if the machine is started accidentally!

- 所有的传动齿轮必须每年提供一次新的油脂。
- 倾斜机器可方便操作。
- All bevel gears must be supplied with new grease once a year.
- Tilt the sewing head back onto the support.