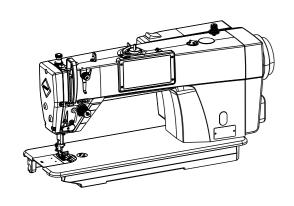
花样缝电脑平缝机 D9A-C/D9S-C Series D10A/D10S Series Computerized special stitch pattern lockstitch sewing machine

使用说明书 **OPERATION MANUAL** 零件手册 **PARTS BOOK**



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。

• 重要安装事项 •

- 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。
- . 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。
- . 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,
- 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眼镜。 下列情况下,请关闭电源开关或拔下电源插头:
- -1 机针穿线和换梭心
- -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份 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。
- . 机器的维修、改造和调整等工作必须由专业技术人员进行。
- . 应由专业受训人员进行一般的维修和检查工作。 2. 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。

3. 油盒内机油液面高度没有在正常范围内绝不能开车。

the grease and dust from the surface using soft cloth and gasoline.

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

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。

. 当接通电源或机器运转时,请勿将手与机针接触。 . 机器运转时,请勿将手指伸入挑线杆防护罩内。 . 操作者用手送料时,请勿将手指伸入护针架。

只有在停机时,才能装卸防护罩或其它保护装置。 不能用香蕉水等油漆稀释剂擦拭机头表面。

机头翻动及拆手盖时,一定要切断电源。 操作者离开机器时,必须切断电源。

- 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。
- . 由电气人员选择合适的插头和有地线的插座。 5. 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。

开机前的注意事项 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,还可能在较长的贮藏和

2 机器出厂时 虽经讨图廖的检查和试验 但在长途运输中也可能受到强列的震动使机件松动或歪曲

1. The machine head is coated with a thick layer of rust-prevention grease before encasement, and

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.

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

Precautions for Use

The upper wheel shall rotate countercoccurate which it is viewed normal action and action of pper wheel) when the machine is operating.

The counterper wheel shall rotate countercoccurate which is viewed normal action and action of the pper wheel) when the machine is operating.

The counterper wheel shall rotate countercoccurate which is viewed normal action and action and action of the per which is a counterper wheel in the property of the per which is a counterper wheel in the per which is a counterper which is a counte

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

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

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

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

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

7. 本机只适用于专业缝纫。 19.两种警告提示符:

6. 生产日期见合格证。

操作人员或维修人员请注意

特别注意事项

安全操作事项 FOR SAFE OPERATION



- . 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。 . To avoid electrical shock hazards, neither open the cover of the electrical box
- or the motor nor touch the components mounted inside the electrical box 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。
 为尽可以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
- 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。
- 为尽可以避免人身伤害,当糨起或拾起机头时, 忽将手指放入机器内部、为尽可以避免机器的突然启动所造成的事故, 拾起机头时, 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。
- 1. To avoid personal injury, never operate the machine with any of the belt cover,
- in to avoid personal injury, ever operate in machine with any of the best coveringer guard of 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 over 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
- urn 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.
- So the whole triads line is in Operation.

 So 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 wer to the machine when replacing the bobbin. 6. To avoid possible personal injuries, be careful not to allow your fingers in
- the machine when tiling/raising the machine head.
- 7. To avoid possible accidents because of abrupt start of the machine, turn
- OFF the power to the machine when tiling the machine head. 8. If your machine is equipped with a serve-motor, the motor does not
- produce noise while the machine is at rest. To avoid possible accidents due t abrupt start of the machine, be sure to turn OFF the power to the machine.
- Never put your finger into the protection cover of take-up lever during operation of the machine.
 The operator must not put his finger into the needle guard bracket when he feeds the sewing aterials by hand. 4. Operator must trim off the electricity supply before he turns over the machine head or removes 9. To prevent possible accidents because of electric shock or damaged 5. The operator must trim off the electricity supply before he gets away from the machine
- electrical component(s), turn OFF the power switch in prior to the co /disconnection of the power plug.

2-3. 机头 Machine head

- ①. 机头
- ②. 机头铰链 (2pcs) ③. 机头支柱
- ①. Machine head ②. Hinges (2pcs)③. Frame support bar

2-4. 线架 Cotton stand

注意: 将螺母④拧紧以便将两个橡胶垫圈(2)

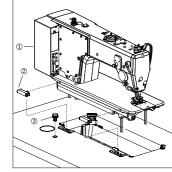
Securely tighten the nut @ ,so that

the two rubber cushions ② and the

washer ③ are securely clamped and so that the cotton stand ① does not

①Cotton stand

和垫圈③夹紧, 使线架①固定



<u>⚠</u> 注意 CAUTION

topped.

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

在加油未完成前,请勿插上电源。

3. 加油方法 Lubrication

- 当误踩下脚踏板时,缝纫机运作会导致人员受伤。 使用润滑油时,请务必戴好保护眼镜和保护手套等,以防润滑油落入眼中或沾在皮肤上
- 使用润滑油时,请务必截好保护眼镜和保护于套寺,以 这是引起发炎的原因。 另外,润滑油不能饮用,否则会引起呕吐和腹泻。 将油放在儿童拿不到的地方。 在剪去油箱的油嘴口时,请一定要拿住油箱的根部。
- 在努去油桶的加速 中, 中, 人名英国 (1997) 如果拿油嘴口部位,剪刀容易伤到手,成为受伤的原因。
- Do not connect the power cord until lubrication has been completed, otherwi the machine may operate if the treadle is depressed by mistake. Which could result in injury.

 Be sure to wear protective goggles and gloves when handing the lubricating of
- and grease, so that they do not get into your eyes or onto your skin, otherwise flammation can result. Furthermore, do not drink the oil or eat the grease under any circumstances,
- as they can cause vomiting and diarrhea.

 Keep the oil out of the reach of children.

 When cutting the nozzle of the oil tank, hold the base of the nozzle securely. If you hold the end of the nozzle, injury from the scissors may result.

初次使用缝纫机前需添加润滑油以保证 机器各部件的润滑, 以延长机器寿命

- 2.将白油注入机头加油孔中 3.加油过程中观察测量视窗②,使油量计③ 稳定在上下基线之间
- (1) 油量计不可超过视窗 F其线
- (2) 如油量计③低于下基线,则必须加
- 润滑油 Refore the first time use this machine you need to add oil to ensure the ubrication of the mechanical parts of the machine to prolong the service life of the machine ,to prolong the service life of the machine.
- 1. Open the oil rubber ①
- 2. add oil into the machine 3. look at the oil window ② during adding oil, to make the oil guage ③ is steable tween the top and bottom ba
- (2) If the oil guage ③ is lower than the buttom baseline, machine must be added oil

IMPORTANT SAFETY INSTRUCTIONS -

- To get the most out of the many functions of this machine andoperate it insafety, 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
- 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
- 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 personal protection, 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.
- 7-4 For when leaving the working place of when the working place is unattended. A 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
- 9. Tampering with the live parts and devices, regardless of whether the machine is powered, is
- Repairing, reforming 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 your 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 enviorment that is free from strong noise sources such as
- An appropriate power plug has to be attached to the machine by electric technicians, Power
- 10. An appropriate power pior last to be attached to the machine by electinic 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 assumes no responsibility for damage caused by reformin or modification of the machine.

 17. The machine is only allowed to be used for the pose intended. Other used are not allowed.
- Warning hints are marked with the two shown symbols.

Danger of injury to operator or service staff

Items requiring special attention

1.缝纫机规格 MACHINE SPECIFICATIONS

0				D9A/D10A	D9S/D10S	
,		用途 USE		薄料、中厚料 Medium-weight materials	薄料、中厚料 Medium-weight materials	
		最高缝速 MAX. Sewing speed		5000sti/min	4000sti/min	
		最大针距 MAX.Stitch length		5mm/7mm	5mm	
Pro		压脚高度	手抬 lifting lever	5.	5mm	
		Presser foot	膝控 Knee lifter	13mm		
		height	自动 automatic	10)mm	
		送料牙高度		1.0mm/1.2mm	1.0mm	
		机针 Needle		DBx1 9#-18#		
		润滑油		15号白油 NO.10 White oil		

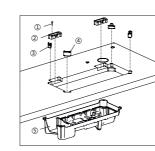
2. Though the machine was inspected and tested with care before factory leaving, it might be affected by violent vibration resulting in looseness or distortion of the machine parts; therefore the operator shall thoroughly check the machine, turn the upper wheel by hand and check it for

①. Speed controle ②. 连杆



2-2. 安装 Installation ①. 鞋钉 (8个) ②. 机头连接钩座 (2个)

- 头部防震垫(小) (2个) ⑤. 托盘 (1个)
- ①. Nail (8pcs) ②. Rubber cushions (2pcs) Head cushions(small) (2pcs) Head cushions(big) (2pcs) ⑤. Tray (1pcs)



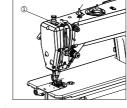
4. 面线的穿法 Threading the upper thread

<u>⚠</u> 注意 CAUTION

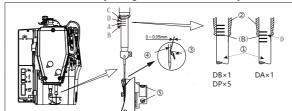
在穿线过程中,请切断电源。当误按动启动开关时,缝纫机动作会导致人员受伤。 Turn off the power switch before threading the upper thread.
The machine may operate it the treadle is depressed by mistake, which could

在穿引面线之前转动手轮,抬高挑线杆①, 开始时脱落

Turn the machine pulley and raise the thread take-up ① before threading the upper thread. This will make threading easier and it will prevent the thread from coming



5. 机针和旋梭的同步 Adjusting the needle and rotary hook timing



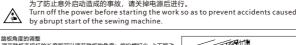
针杆①从最低位置向上移动1.8mm(2.2mm用于M和H规格),到达基线B与针杆轴套②下端对齐的位置时,旋梭尖③ 与机計中心创对系,如國际示。從此計計入上改線与旋線之的医囊为5.50.7mm) 转动建切机手轮,使针杆①从最低位置上升到如图所示的基线B与针杆稳套②的下端保持对齐为止 旋松圆定罐钉⑤[37],使快采(3)与机针(4)的中心一致。此齿旋模尖(3)与机针(2)间的间隙为0-0.05mm

The tip of the rotary hook ③ should be aligned with the center of the needle ④ when the needle bar ① moves up 1.8mm (2.2mm for -M and -H specifications) from its lowest position to the position where reference ling B is aligned with the lower edge of the needle bar bush ② as shown in the illustration. (the distance from the upper edge of the needle hole to the rotary hook tip will be 0.5 to 0.7mm at this 1. Turn the machine pulley to raise the needle bar ① from its lowest position until reference line B is align with the lower edge of the needle bar Ush O ② as shown in the illustration. 2.Loosen the set screws ③, and then align the tip of the rotary hook ③ with the center of the needle ④. The distance between the tip of the rotary hook ③ and the needle ④ should be approximately 0-0.05m 3.Securely tighten the set screws ⑤.

6. 踏板的调整 Adjustment of the pedal

<u>⚠</u> 注意 CAUTION

为了防止意外启动造成的事故,请关掉电源后进行。



1. 膝板角度的调整 1) 调节施施连接杆的长度即可以调节踏板的角度: 旋松螺钉①,上下移动 上连接杆①和下连接杆①就可以调节踏板连接杆的长度。 2) 调节完成后旋紧螺钉②。 将脚放在踏板上并向前轻踩踏板时,缝纫机进行低速缝纫。如感觉踩踏力比

以a为最小、b. c. d依次逐渐增大)。) 松开螺母⑥,旋转螺栓⑦调节踏板返回力: 拧紧螺栓⑦则踏板返回力将增) 调节完踏板返回力后,请拧紧螺母⑥。

交轻时,将踩踏力调节弹簧@挂在踏板旋臂拨杆(S)的位置上进行调节(踩踏力

I ranjusting the angle of treadle 1). Adjusting of the length of treadle connecting the land in the land of the land in the length of treadle connecting of the land of the land in the length of treadle connecting of by moving upward/downward the upper connecting of @ and lower connecting rod @. "Screw down screw @ when adjustment is over."

**Adjustment of the strength of pedalThe sewing machine run at a low speed when step forth on we panel slightly. If the strength is insufficient, hang the stepping adjustment spring @ on we panel spiral arm driving lever @ in order to adjust strength (a is the minimum stepping rength .b.c.d increase gradually).

Adjustment of stenoning return strength. Adjusting the angle of treadle

strengtn ,0,Ca increase graoually) \$Adjustment of stepping return strength |||| \$Adjustment of stepping return strength ||| \$\text{\$\text{\$L}\$} osign ||| \$\text{\$\text{\$W\$}} and turn bolt $(\text{$\text{$\text{$\text{$}}}})$ to adjust stepping return strength : tighten bolt <math>(\text{$\text{$\text{$\text{$}}}})$ the strength decreases. $2|\text{$\text{$\text{$\text{$\text{$\text{$}\text{$\text{$}\text{$}\text{$\text{$}\text{$\text{$}\text{$\text{$}\text{$\text{$}\text{$\text{$}\text{$\text{$}\text{$\text{$}\text{$\text{$}\text{$\text{$}\text{$\text{$}\text{$\text{$}\text{$\text{$}\text{$}\text{$\text{$}\text{$\text{$}\text{$\text{$}\text{$\text{$}\text{$}\text{$\text{$}\text{$\text{$}\text{$\text{$}\text{$}\text{$\text{$}\text{$}\text{$\text{$}\text{$}\text{$}\text{$\text{$}\text{$}\text{$}\text{$\text{$}\text{$}\text{$\text{$}\text{$}\text{$}\text{$\text{$}\te$

踏板操作 Pedal operation

- 1.踏板有4级操作: 向前轻踩踏板为低速缝纫(图示B)。 再用力向前联踏板则变为高速键纫(图示A)。 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 射在上停针或下停针位置 圆示心, 再用力向后踩踏板为切线动作(图示E)。
-) 使用自动压脚提升装置时,在停止和切线之间增加一级开关D。 5轻踩踏板为压脚提升动作,继续向后强力踩踏板,压脚下降进行 t动作,再次进行压脚提升动作。 ne treadle has 4 operation levels
- 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)

 4)The machine trims threads when you fully depress the back part of the pedal. (as show in the picture A)

 5)When the auto-lifer is used one more operating switch is provided between
- etual_tas show in the picture */)
 When the auto-file is used,one more operating switch is provided between the sewing machine stop switch and thread imming switch. The presser foot goes up when you lightly depress the back part of the pedal(D),and if you further depress he back part the thread trimmer is actuated.

7-2. 送料牙倾斜的调节 Adjust the lean of feed dog

A (2)

1. 转动手轮. 将送料牙④升到针板的最高位置。 2.将缝纫机放倒,并支到机头支柱上。 3.旋松牙架座②上的紧固螺钉①。

转动,送料牙前端放下;向B方向转动,送料牙前端抬起 (当送料牙升到附标的墨声的墨西 心销③上的刻点C与牙架座②上的刻横D对齐,送料牙与 针板平行)。 5.调节完成后拧紧牙架座②上的紧固螺钉①。

1.Turn the pulley until the feed dog ④ rises to the highest position. 2.Turn over the sewing machine head on the

supporting bar 3.Unscrewing the tightening screw (1) in the teeth pedestal ②.

4.Adjust the eccentric pin ③ by screw driver: Fall

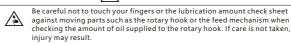
- front site of tooth feed when moving the eccentric pin ③ towards A, and raising it when move towards B.(When raising the tooth feedto the highest position, The standard lean position of feed dog is that mark C on eccentric pin ③ should be at the same level D with mark on the teeth
- pedestal 2 and the feed dog should be parallel with needle plate.)
 5.Remember to tighten the tightening screw① in the teeth pedestal @ after adjusting
- · 为了防止起皱,可降低送料牙前端。 为了防止在重叠缝纫时布料不一致(缝线不合),可提高送料牙前端。
- · In order to prevent puckering, lower the front of the feed dog.
- In order to prevent the material from slipping,raise the front of the feeddog. readjust the height of the feed dog.

- 调节送料牙的倾斜度后,送料牙的高度也会发生改变,因此请重新调节送料牙的高度。
- The height of the feed dog will change after the angle has been adjusted, so it will be necessary to

∴ CAUTION

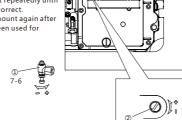
9. Oil mass Adjustment of Rotating Hook





Use the following procedure to check the amount of oil being supplied to the rotary hook or when changing the sewing speed.

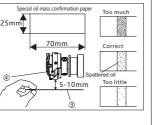
1) Adjust the oil mass of rotating hook using djusting screw ① or screw ② : Screw down turn it to the right) adjusting screw ① or inscrew (turn it to the left) the adjusting screw(2) to raise the oil mass otherwise to ower the oil mass. Amount repeatedly united to the lubrication amount is correct. 2)Check the lubrication amount again after the sewing machine has been used for the sewing machine has been used for approximately two hours.



2.Confirming the Oil Mass 1) Remove the thread from all points from the thread take-up to the needle. 2) Use the lifting lever to lift the presser foo
3) Run the machine at the normal sewing

speed for approximately 3 minute without sewing any material (following the same start/stop pattern as when actually sewing) 4) Place the lubrication amount check shee 3) underneath the rotary hook (4) and hold it here.Then run the sewing machine at the normal sewing speed for 10 seconds.(Any type of paper can be used as the lubrication nt check sheet ③). 5) Check the amount of oil which has

spattered onto the sheet(3).



8. 线张力的调节 Adjusting the Tension of Stitch Thread

®

<u>⚠</u> 注意 CAUTION

7-1. 标准调整 Standard adjustment

Maintenance an by a qualified.

全 全 致受伤。

·检查、调整和维修

7-1. 调线量的调整

1.旋松螺钉①。

3.调节完成后拧紧螺钉①。

1.Unscrewing the screw ①.

nook is aligned to screw center.)

. 1

0

时为标准位置)。 3 调节完成后拧

it was

·更换旋梭、切刀等易损零部件

2.移动右线钩②进行调节: 朝左方向(即A方向)移动,

2.Move the right thread hook ② to adjust : the thread

amount of thread take-up lever will increase if turned

it towards left (A direction), while turning it to the right (direction B) and the thread amount of thread take-up

lever will decrease accordingly. (The standard position

s obtained when graduation line C on right thread

B.Remember to tight the screw ① after adjusting.

挑线量将会增加; 反之朝右方向(即B方向)移动, 挑线量将会减少。(右线钩上的刻线C与螺钉中心一致

<u>⚠</u> 注意 CAUTION

与电气有关的维修、保养和检查请委托购买商店或电气专业人员进行。

取下的安全保护装置,再次安装时,请务必安装在原位上,并检查能否正常地发挥作用

缝纫机头倒下或竖起时,请用双手进行操作。单手操作时因缝纫机的重量万一滑落易导

Use both hands hold the machine head when tilting it back or returning it to

its original position. If only one hand is used the weight of the machine head may cause your hand to slip, and your hand may get caught.

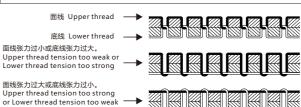
发生下列情况时,请关闭电源,并拔下电源插头,否则误踩下踏板时,缝纫机运作会导

只有经过训练的专业人员才能进行缝纫机的维修、保养和检查。

Maintenance and inspection of the sewing machine

取出梭芯套时,请关闭电源。 当误踩下踏脚板时,缝纫机动作会导致人员受伤。 Turn off the power switch before removing or inserting the bobbin case.

The machine may operate of the treadle is depressed by mistake, which could



.底线张力的调节 拉住从梭芯套中露出的线头,旋转调节螺钉①

反之则底线张力变小。 thread which hanging from the bobbin case and use the adjusting rotating scerw @ to regulate. The tension of the bottom thread is become strong by tight the screw @, loose

the screw to make it weak. 底线张力调节标准:旋转调节螺钉①直至梭芯套以自重慢慢垂落。 The adjust standard of the bottom thread tension: Rotating the

adjusting screw (1) till the bobbin case can falling slowly by it's own weight 在底线张力调节之后,调节面线张力以使针脚均匀平整。 使用压脚扳手将压脚放下。 转动夹线螺母②进行调节: 朝顺时针方向(即A方向)转动

时, 面线张力将增大; 朝逆时针方向(即B方向)转动时, 面 线张力将减小。 2. Adjusting the tension of needle thread

when toward anti-clockwise (B).

松开,调整上动刀③角度。

常切线。

10. 切线 Thread trimming

. 使用粗线或不能切线时,将螺钉①和螺钉②

上动刀③向里侧倾斜时,刀面压力长升。 外侧倾斜时,刀面压力下降。

3. 调整好上动刀③角度后重新拧紧螺钉①和

4.调整后请手动上下动刀架,确认是否可以正

osen the screw① and ②, adjustment

surface presser drop.

3. Adjust the knife ③ anger, then retighten

4. After adjustment, manually move up and

down the knife holder to confirm whether the machine can trim thread normally o

the moving knife ③ angle.

2. Knife ③ tilted to the inside, the knife

the screw ① and screw ②.

. When use thick thread or not trim,

After the lower thread tension has been adjusted, adjuthe upper thread tension so that a good, even stitch is 1) Lower the presser foot by using the lifting lever.
2) Adjust by turning the tension nut ②: The tension of

the upper thread will become strong when turning toward the clockwise(A), otherwise weak

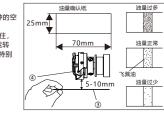
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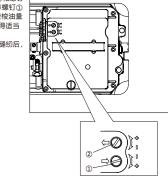
外侧 back



4. 安装后检查膝控组件是否灵活。 1. The electronic knee assembly ② is fixed on the plate and the fixed screw ① is

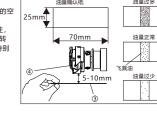
)调节油量后缝纫机在进行约2小时的缝纫后,

再次检查以确认供油量。



2.油量的确认方法)拆去挑线杆至机针上的面线。 ?) 用抬压脚扳手抬起压脚。

- 运转(适度的断续运转)
- 5) 确认飞溅到测试纸③上的油量。

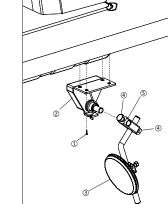


11. 膝控的安装 Knee control installation

tightened.

2. Connect the knee control assembly ③ with the knee control joint ⑤ and the

electronic knee assembly ②. 3. Tighten the screw (4). 4. Check whether the knee control is flexible after installation



1.转动手轮,将送料牙升到针板的最高位置。

3. 旋松抬牙叉形曲柄②上的紧固螺钉①。 4.转动抬牙叉形曲柄②进行调节: 将抬牙叉形曲柄 ②向A方向转动,送料牙将变高;反之向B方向转动 送料牙将变低(当送料牙升到针板的最高位置时,中

Adjustment of the Height of feed dog

厚料机型送料牙距针板的标准高度为0.8-1.0mm 厚料机型的标准高度为1.1-1.3mm)。 5.调节完成后拧紧抬牙叉形曲柄②上的紧固螺钉①。

Turn the pulley until the feed dog rises to the highest position. 2.Turn over the sewing machine head on the supporting bar.

B.Unscrewing the tightened screw ① in thefeed lifting crank ②. 厚料 H: 1.1-1.3mm 4.Rotating the feed lifting crank ② to make adjustment: the feed dog will be higher when

the feed lifting crank ② is turn towards A direction; Turn off the power switch and disconnect the power cord from the wall outlet turn towards B direction the feed dog will be lower. at the following times. Otherwise the machine may operate if the treadle is depressed by mistake, which could result in injury.

When carrying out inspection, adjustment and maintenance

When replacing consumable parts such as the rotary hook and knife. (When the feed dog in the highestposition, the

7-2. 送料牙的高度

2.将缝纫机放倒,并支到机头支柱上。

heavy duty machine is 1.1~1.3mm) 5.Remember to tighten the tightening screw ① in the feed lifting crank ② after adjusting.

standard height of the type of medium-heavy machine is 0.8~1.0mm and standard height of the

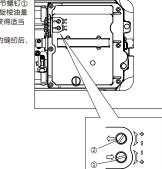
9. 旋梭供油量的调整

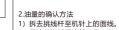
/ 注意 在检查旋梭供油量时,手指和油量测试纸不能碰到旋梭和送布机构等运动部件

如果更换了旋梭或要变更缝纫速度时,请按下述步骤重新调整旋梭的供油量

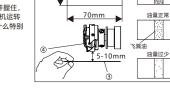
1. 前 27亿 1) 旋梭的油量是用旋梭油量调节螺钉①和螺钉 ②来调节: 拧紧(向右转动)旋梭油量调节螺钉① 或拧松(向右转动)旋梭油量调节螺钉②旋梭油量

将增多,反之旋梭油量将减少,直至获得适当

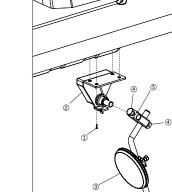




) 以缝纫机实际缝纫时的转速进行约3分钟的空 l) 将油量测试纸③插入旋梭④的下面并握住 以缝纫机实际进行缝纫时的转速使缝纫机运转 10秒钟。(对油量测试纸③的纸质没有什么特别



1. 将电子膝控组件②固定在台板上,旋紧固定螺钉①。 2. 将膝控组件③与膝控接头⑤、电子膝控组件②连接。 3. 拧紧螺钉④。



1. 机壳分组件/Machine frame&miscellaneous cover components	序号 物料号 名称 Description 数量 备注 Remark	1. 机壳分组件/Machine frame&miscellaneous cover components	序号 Ref.No.
3 2 2 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3	1	36 37 38 39 40 41 42 43 44 49 45 46 47	1 2 3 4 4 5 6 6 7 8 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41
Section	1. 机壳分组件/Machine frame&miscellaneous cover components	P	序号 Ref.No. 35 36 37 38
21- 2. 上轴、挑线分组件/Main shaft&thread take-up components 7	Pert No.	23- 3. 针杆、勾线分组件/Needle bar & Hook of driving shaft components	5. 送料分

	5. 送料	序号 Ref.No. 35 36 37 38	2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 31 31 31 31 31 31 31 31 31	序号 Ref.No.
42	分组件/Feed M	物料号 Part.No. 301020249 301380040	301030154 301150162 301020245 301030299 301030169 301600057 301030292 301040011 301020258 301040011 301090058 301590675 301040012 301280017 301280017 301280017 301280017 301280017 301280017 301280017 301590282 301330038 301030291 30160037 301140532 30130038 301130147 301590303 3011590292 301390293 301590293 301590293 301590293 301170012	物料号 Part.No. 301030158 301130193
	-30 Mechanism Com	名称 Name 油封 脚轴 抽压压卸曲相 柄件驱动钉片 建加油 电极性 化甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基	O型 计下 医竖螺针上螺竖竖螺挡螺竖螺下螺螺梭滑滑螺针针毛针的钉胶钉 胶矿 医路针 计编码 医侧角 下 计下 医竖螺针上螺竖竖螺挡螺竖螺下螺螺梭滑滑螺针针毛针的钉胶钉 医肺圈 医腹部 计编码 中心 中心 中心 一个一个一个一个一个一个一个一个一个一个一个一个一个一个一个一个一个一个一个	名称 Name 下轴后轴套
46		Description Oil seal Shaft Crank Crank Crank Screw SM11/64**40 L=13 Washer Washer Washer Screw SM11/64**40 L=3 Fish eye joint Screw M6×0.75 L=12	O-ring Bearing support Needle bar thread guide Hook driving shaft Bearing support Screw SM15/64*×28 L=7 Bearing support Screw SM1/4×40* L=8 Upright shaft Gear Screw SM1/4×40* L=8 Thrust collar Screw SM1/4×28 L=4 Gear Screw SM1/4×40* L=8 Gear Screw SM1/4×40* L=8 Gear Screw SM1/4×40* L=8 Gear Screw SM1/4×40* L=8 Gear Screw SM1/6*×40 L=10 Bobbin case Slider Guide rail Screw SM9/64*×40 L=7.5 Needle bar Bearing support Wool felt Needle bar thread guide Needle DB×1 14# Screw SM1/8* ×44 L=4 Rubber plug Oil stoper Washer Screw SM1/8*×44 L=4 Oil wick Screw SM3/16*×40 L=13 Hook 7.94BTR Positioning finger Bobbin Thread Oil seal	Description Bearing support
45.0		数量 Q'ty 1 1 1 1 1 1 1 1 1	2 1 1 1 1 1 1 1 2 2 4 4 1 2 2 4 1 1 1 1	数量 Q'ty
45		备 注 Remark		备 注 Remark
43 301030167 44 301130198 45 301130094 43	序号 物料号 Ref.No. Part.No. 41 301590272 42 301160291	5. 送料分组件/Feed M	16 17 13 23 15 16 17 18 3 19 7 18 3 9 10	4. 压脚分组件/Hang L
牙牙架等等。	名称 Name 螺钉 牙架组件		23 11	ifter Compon
Feed bar driving crank Pin Screw SM11/64*×40 L=8 Feed bar Pin Lifting fork Slider Washer Bearing support Oil seal Oil seal Rubber plug	7 5 6 13 7 5 6 13 7 5 6 6 13 7 5 6 6 13 7 5 7 5 6 6 13 7 7 5 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7 7	28- nponents 21 21 21 8 4 35	27 30 37 37 35 33 38 36 34 33 33 34 33 33 34 33	ents
1 1 1 1 1 1 1 1 1 1 1 2 2 2 2 1 1	数量 备注 Oty Remark	36 37	25 22 20 22 20 28	
25	15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40	序号 Ref.No. 1 2 3 4 5 6 6 7 8 9 10 11 12 13 14	2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 31 31 32 33 34 35 36 37 38 38 39 30 31 31 31 31 31 31 31 31 31 31	序号 Ref.No.
24 17	301320034 301590285 301150112 301380039 301590149 301140544 301320028 301390304 301590304 301590277 3013050069 301050070 301590277 301590361 301150112 301640085 301590323 301590380 301190063 301590402	物料号 Part.No. 301030132 301020276 301020235 301310075 301320039 301590150 301020096 301590324 301160140 301590371	301130226 301020257 301590325 301600077 301140514 301150161 301590298 301150076 301200077 301600269 301340027 301130144 301380018 301070077 301590286 301590295 301280014 3011590280 301590290 3015900	物料号 Part.No. 301030134
3 10 3 10 5 6 8 7 22 27 27 25	K摆拾螺轴送螺送送送拾六螺送送摆摆螺给钉轴油针螺螺送螺钉钉用料钉料料料对角钉料料动动钉牙钉用料钉料料料对角钉料料动动钉牙管 弹偏偏连连后螺 帕朗板板 送送 弹齿型 由曲板板 送之 弹向机 电子标记 特斯格隆座 料性的机 牙齿 电电分析 电调频 医角膜 电电子 计算量 医二甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基甲基	名称 Name 前轴牙料轴轴 前胎牙料距距钉 即距钉即距钉面动钉钉 螺螺螺螺螺螺螺螺螺螺螺螺螺螺螺螺螺螺螺螺螺螺螺螺螺螺球 顶上	压压调调调螺护压拾给压拾前开开 O 压压平螺螺压拾螺螺螺筒拾螺叉指附压压脚压杠口口型脚脚垫钉钉杆压钉钉胶纹母杠压钉型阻压承压钉钉封防螺螺导簧 架 前前降杠挡挡圈扳扳圈 导脚 墊销 杆脚 φ脚 脚钳挡挡圈 扳扳圈 零 一种 位拉 10.曲 套 位拉 10.曲 套 新 4 年 1 年 1 年 1 年 1 年 1 年 1 年 1 年 1 年 1 年	名称 Name 压杆衬套
21 11 15 16 13 20 19 8 20 19 8 21 11 29 30 30 6 8 7 8 9 19 19	Pin Connecting rod Screw SM9/32" × 28 L=22 Snap ring Feed drive eccentric cam Screw SM1/4" × 40 L=13 Thrust cover Connecting rod Pin Lifting rocker Nut SM1/4" × 40 L=4.5 Screw SM3/16" × 28 L=15 Pin Feed rocker Pin Pin Screw SM15/64" × 28 L=10.5 Thrust collar Screw SM1/4" × 28 L=8 Snap ring Oil seal Motor Screw SM1/64" × 40 L=10.5 Feed dog Screw SM1/64" × 44 L=6	Description Bearing support Feed driving shaft Feed driving shaft rocker Link Screw M5 L=18 Pin Screw M5 L=6 Feed adjusting Pin Screw SM9/64* ×40 L=5 Screw SM9/64* ×40 L=6 Short link Short link	Oil proof sleeve Pressure rod Screw SM1/2"×28 L=41 Nut SM1/2"×28 L=8 Pressure rod Spring Screw SM9/64"×40 L=11 Protect shelf Presser foot ASM. Lifting lever link Lifting lever Plate Lifting lever connectin Pin Snap ring O-ring Trigger cam Cam Washer Screw SM9/64"×40 L=9.5 Screw SM1/4"×40 L=8 Presser guide bar bracket Lifting lever link Screw SM3/16"×32 L=7 Screw SM15/64"×28 L=11 Washer Screw M8×1.0 L=15.5 Screw M6×1.0 L=10 Spring Lifting lever connecting rod Screw M5×1.0 L=13 O-ring Crank Bearing support Screw M5×1.0 L=13 Screw SM15/64"×28 L=10.5 Oil seal	Description Bearing support
31 32 33 33	2 1 1 1 1 2 1 1 1 1 1 1 1 1 1 1 1 1 1 1	数量 Q'ty 2 1 1 1 1 1 1 1 1 1 2 2 2	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	数量 Q'ty
		备 注 Remark		备 注 Remark

序号	P			
36- 37- 37-	-38- 8 注 Remark 9. D9S步进送料送料组件/Feed Mechanism Components	-45-	-46-	-47-
A		48-	.49-	-50-
作品 作品 作品 作品 作品 作品 作品 作品	P	-48-	-52-	-50-