

SIRUBA

INSTRUCTIONS BOOK

DL7200D-NM1/NH1



IMPORTANT SAFETY INSTRUCTIONS

To get the most out of the many functions of this machine and operate it in safety, 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 read it at anytime 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 device must be in position when the machine is ready for word 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 or disconnect the power plug of the machine from the receptacle.
 - 7-1 For threading needle(s), looper, spreader etc. And replacing bobbin.
 - 7-2 For replacing part(s) of needle, presser foot, throat plate, looper, spreader, feed dog, needle guard, folder, cloth guide ect.
 - 7-3 For repair work.
 - 7-4 When leaving the work place or when the working place is unattended.
8. If you should allow oil, grease, etc. Use 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. Repair, remodeling and adjustment works must only be done by appropriately trained technicians or specially skilled Personnel. Only spare parts designated by can be used for repairs.
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.
13. Before making repair and maintenance works on the machine equipped with pneumatic parts such as an air cylinder, the air compressor has to be detached from the machine and the compressed air supply has to be cut off. Existing residual air pressure after disconnecting the air compressor from the compressed air supply has to be expelled. Exceptions to this are only adjustments and performance checks done by appropriately trained technicians or specially skilled personnel.
14. Periodically clean the machine throughout the period of use.

15. 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.
16. An appropriate power plug has to be attached to the machine by electric technicians. Power plug has to be connected to a grounded receptacle.

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19. Warning hints are marked with the two shown symbols.



Danger of injury to operator or service staff



Items requiring special attention

FOR SAFE OPERATION

 DANGER	<p>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.</p>
 CAUTION	<p>1.To avoid personal injury, never operate the machine with any of the belt cover, finger guard or safety devices removed.</p> <p>2.To prevent possible personal injuries caused by being caught in the machine, keep your fingers, head and clothes away from the handwheel, V belt and the motor while the machine is operation. In addition, place nothing around them.</p> <p>3.To avoid personal injury, never put your hand under the needle when you turn “ON” the power switch to operate the machine.</p> <p>4.To avoid personal injury, never put your fingers into the thread take-up cover while the machine is operation.</p> <p>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.</p> <p>6.To avoid possible personal injuries, be careful not to allow your fingers in the machine when tilting/raising the machine head.</p> <p>7.To avoid possible accidents because of abrupt start of the machine, turn OFF the power to the machine when tilting the machine head.</p> <p>8.If your machine is equipped with a servo-motor does not produce noise while the machine when tilting the machine head.</p> <p>9.To avoid electrical shock hazards, never operate the sewing machine with the ground wire for the power supply removed.</p> <p>To prevent possible accidents because of electric shock or damaged electrical components(s), turn OFF the power switch in prior to the connection/disconnection of the power plug.</p> <p>10.</p>

BEFORE OPERATION



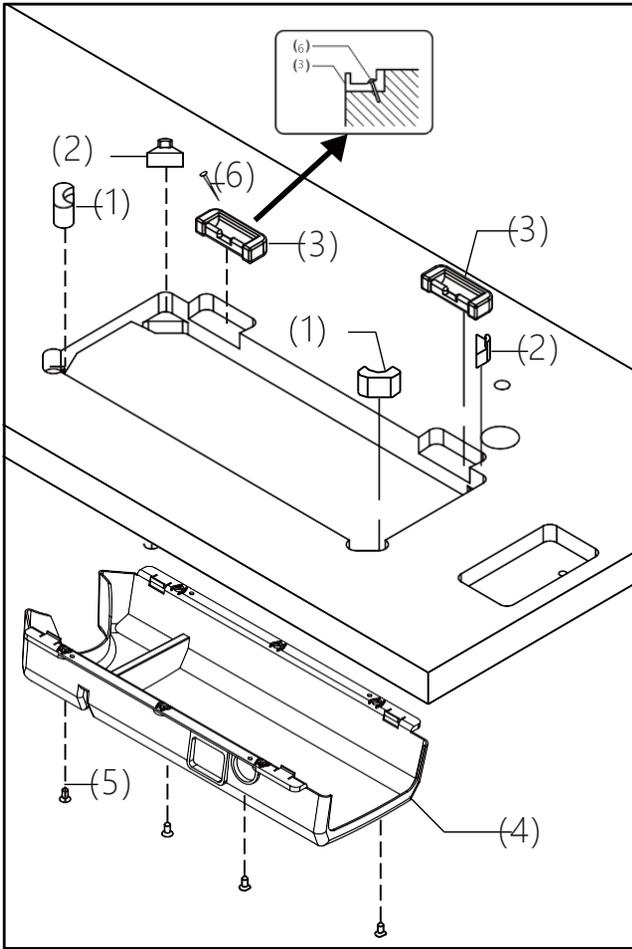
CAUTION

To avoid malfunction and damage of the machine, confirm the following.

- Before you put the machine into operation for the first time after the set up, clean it thoroughly.
- Remember all dust gathering during transportation and oil it well.
- Confirm that the power plug has been properly connected to the power supply.
- Never use the machine in the state where the connected to the power supply.
- The direction of rotation of the sewing machine is counterclockwise as observed from the handwheel side. Be careful not to rotate it in reverse direction.

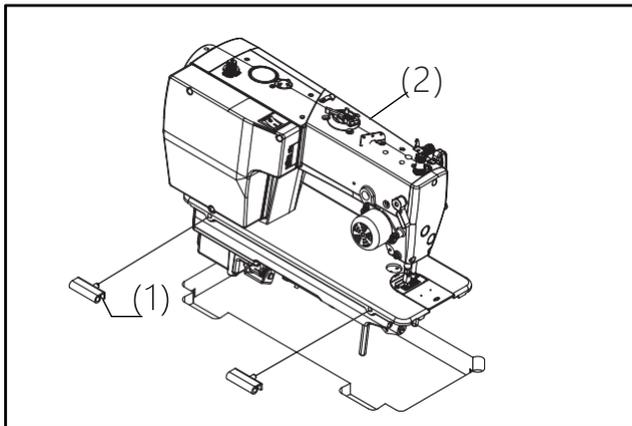
1 . MACHINE SPECIFICATIONS

		M	H
USE		Medium-weight materials	Heavy-weight materials
Max.Sewing speed		5,000 sti/min	4,000 sti/min
Max.Stitch speed		5mm	7mm
Presser foot height	Lifting lever	6mm	6mm
	automatic	6-10mm (Adjustable)	6-10mm (Adjustable)
Feed dog height		1.0mm	1.2mm
(DB×1, DP×5) Needle		#9-#18	#19-#22
		No.10 white oil	

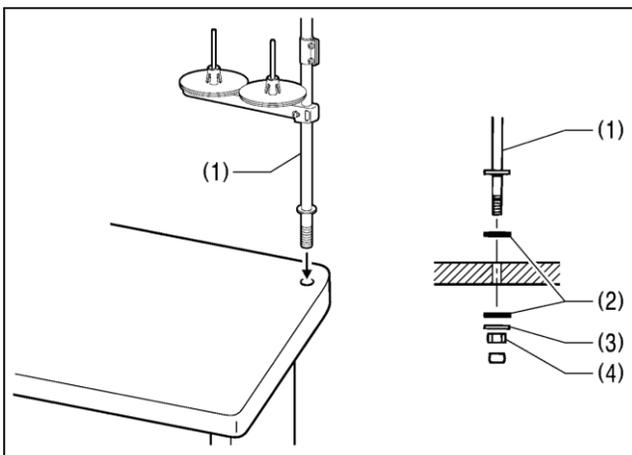


3. Install

- (1) Head cushions(big)[2 pcs]
- (2) Head cushions(small)[2 pcs]
- (3) Rubber cushions[2 pcs]
- (4)Tray
- (5) Screw [4 pcs]
- (6) Nail [8 pcs]



- ### 4. Machine head
- (1) Hinges [2 pcs]
 - (2) Machine head



- ### 5. Cotton stand
- (1)Cotton stand

NOTE:

Securely tighten the nut(4) so that the two rubber cushions(2) and the washer(3) are securely clamped and so that the cotton stand(1) does not move.

2. Lubrication



CAUTION



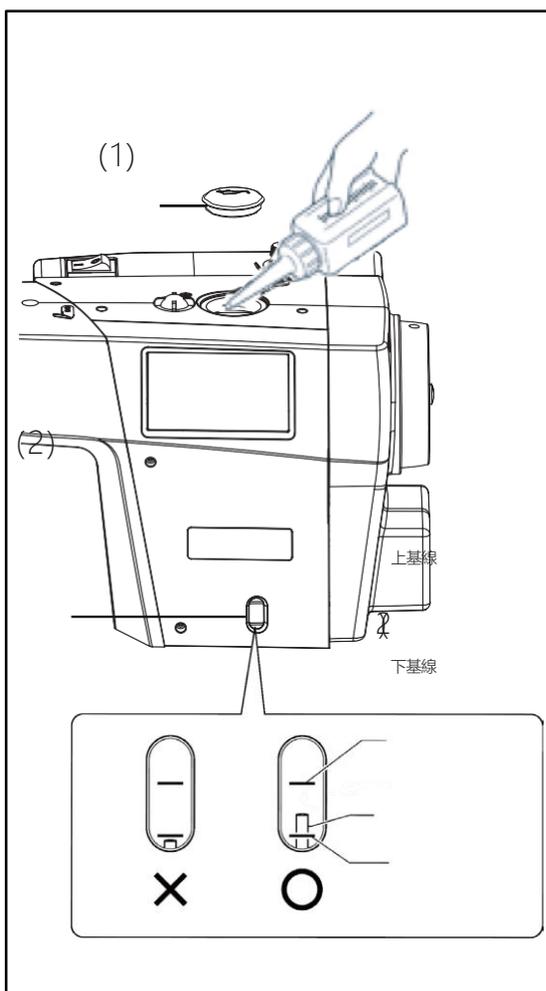
Do not connect the power cord until lubrication has been completed, otherwise the machine may operate if the treadle is depressed by mistake, which could result in injury.



Be sure to wear protective goggles and gloves when handling the lubricating oil and grease, so that they do not get into your eyes or onto your skin, otherwise inflammation 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.



Before the first time use this sewing machine, you need to add oil to ensure the lubrication of the mechanical parts 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 gauge (3) is steable between the top and bottom baselines

Note: the oil guage can't be over the top baseline in the window

If the oil gauge (3) is lower than the bottom baseline, machine must be added oil

3. THREADING THE UPPER THREAD

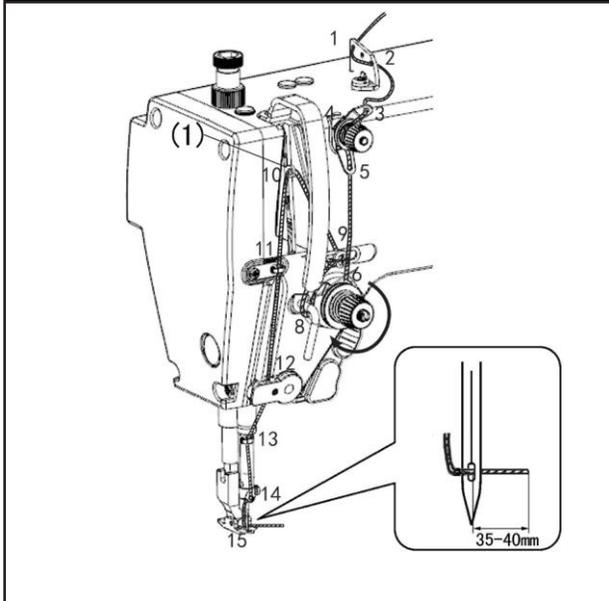


CAUTION



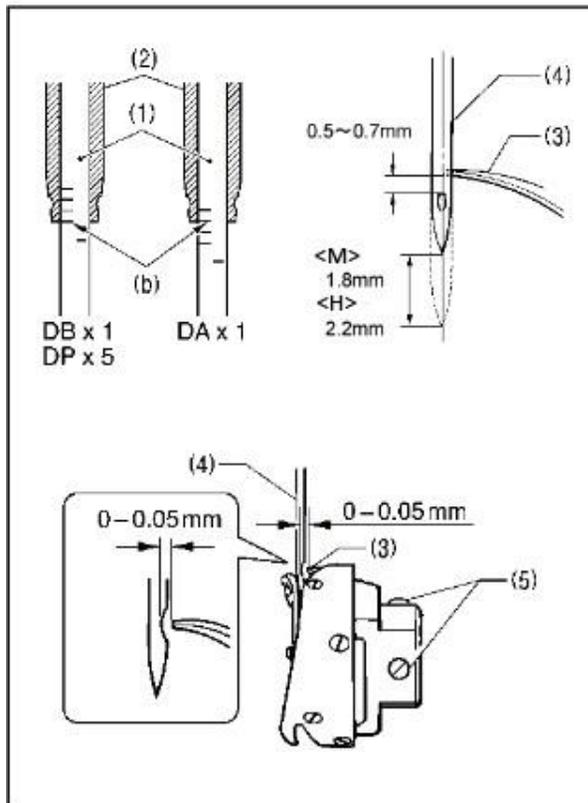
Turn off the power switch before threading the upper thread.

The machine may operate if the treadle is depressed by mistake, which could result in injury.



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 out at the sewing start.

4. Adjusting the needle and rotary hook timing



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 line (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 time.)

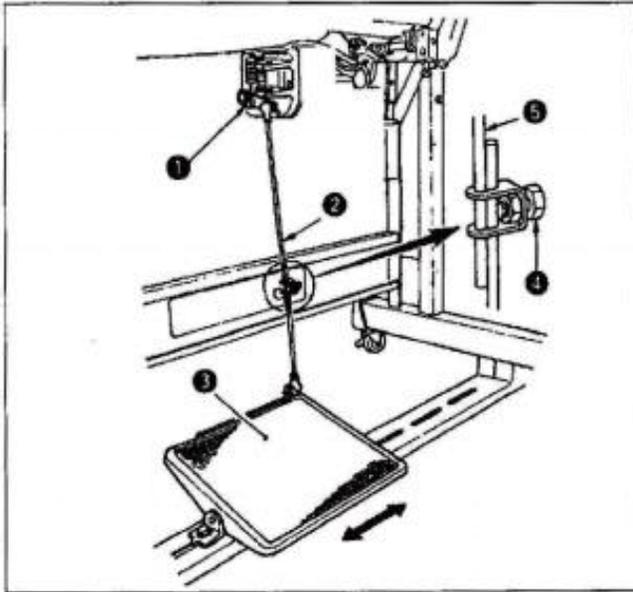
1. Turn the machine pulley to raise the needle bar (1) from its lowest position until reference line (b) is aligned with the lower edge of the needle bar bush D (2) as shown in the illustration.
2. Loosen the set screws (5), and then align the tip of the rotary hook (3) with the center of the needle (4).
The distance between the tip of the rotary hook (3) and the needle (4) should be approximately 0-0.05mm.
3. Securely tighten the set screws (5).

5. ADJUSTMENT OF THE PEDAL



WARNING:

Turn off the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



(1) Installing the connecting rod

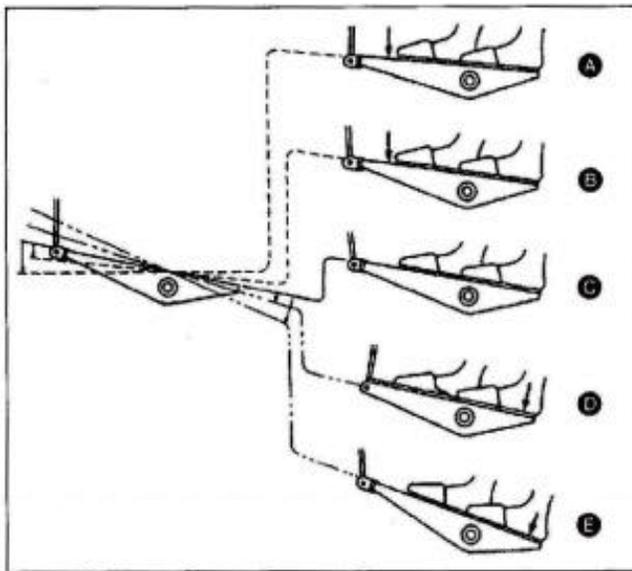
1) Move pedal ③ to the right or left as illustrated by the arrow so that motor control lever ① and connecting rod ② are straightened.

(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 ④, and adjust the length of connecting rod ⑤.

PEDAL OPERATION



(1) The pedal is operated in the following four steps:

1) The machine runs at low sewing speed when you lightly depress the front part of the pedal ②.

2) The machine runs at high sewing speed when you lightly depress the front part of the pedal ①.

(If the automatic reverse feed stitching has been preset, the machine runs at high speed after it completes reverse feed stitching)

3) The machine stops (with its needle up or down) when you reset the pedal to its original position ③.

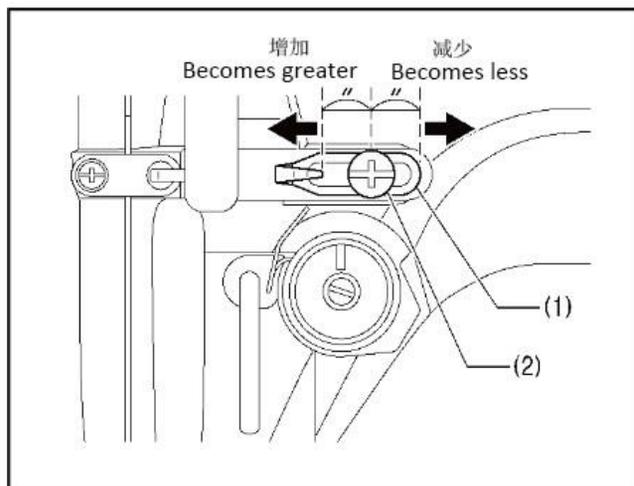
4) The machine trims threads when you fully depress the back part of the pedal ④.

* If your machine is provided with the Auto-lifter an addition step is given between the machine stop and thread Trimming step. The presser foot goes up when you lightly depress the back part of the pedal ⑤, and if you further depress the back part, the thread trimmer is actuated.

6. STANDARD ADJUSTMENT

 CAUTION	
 <p>Maintenance and inspection of the sewing machine should only be carried out by a qualified technician.</p>	 <p>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.</p>
 <p>Ask your dealer or a qualified electrician to carry out any maintenance and inspection of the electrical system.</p>	 <p>Turn off the power switch and disconnect the power cord from the wall outlet at the following times, otherwise the machine may operate if the treadle is depressed by mistake, which could result in injury.</p>
 <p>If any safety devices have been removed, be absolutely sure to re-install them to their original positions and check that they operate correctly before using the machine.</p>	<p>·When carrying out inspection, adjustment and maintenance</p> <p>·When replacing consumable parts such as the rotary hook and knife</p>
 <p>Secure the table so that it will not move when tilting back the machine head. If the table moves, it may crush your feet or cause other injuries.</p>	

7-1. R Adjusting arm thread guide R



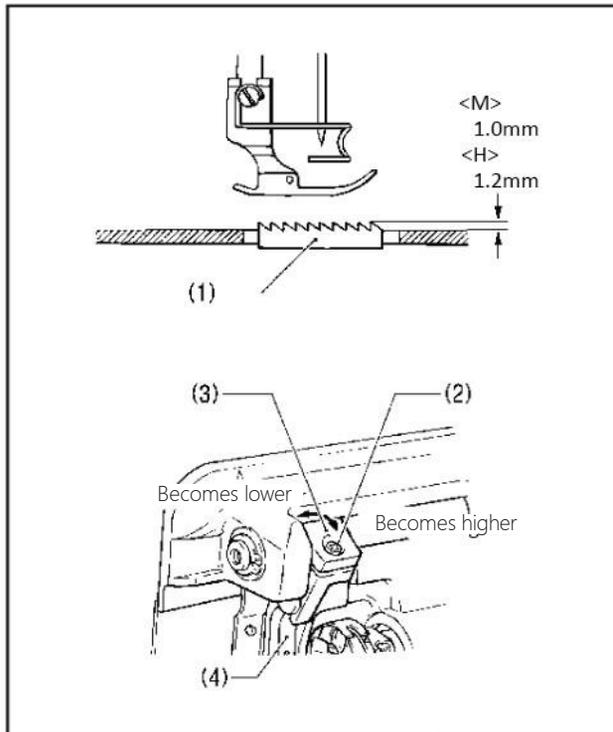
The standard position of arm thread guide R (1) is the position where the screw (2) is in the center of the adjustable range for arm thread guide R (1) .

To adjust the position, loosen the screw (2) and then move arm thread guide R (1) .

·When sewing thick material, move arm thread guide R (1) to the left. (The thread take-up amount will become greater.)

·When sewing thin material, move arm thread guide R (1) to the right. (The thread take-up amount will become less.)

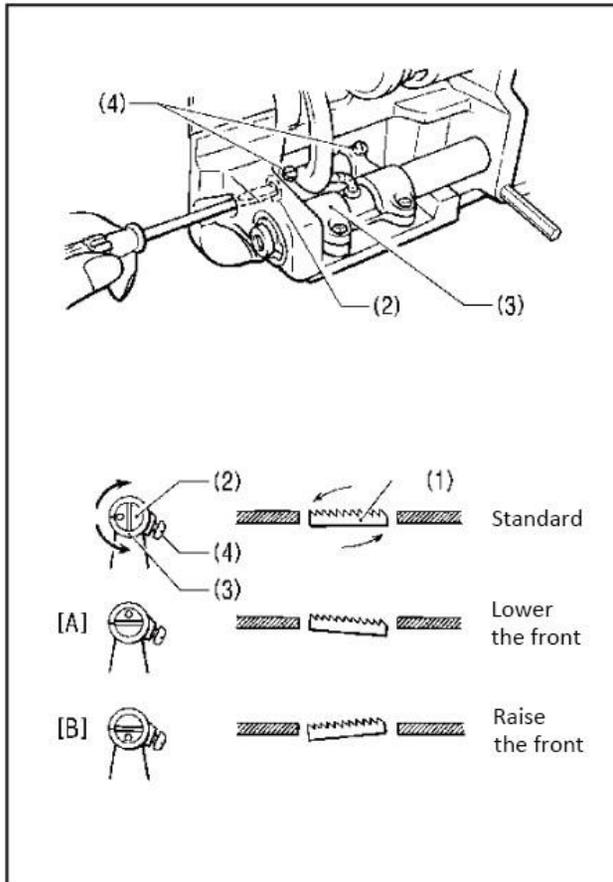
7-2. Adjusting the feed dog height



The standard height of the feed dog (1) when it is at its maximum height above the top of the needle plate is 1.0 mm for M specifications, and 1.2mm for H specifications.

1. Turn the pulley until the feed dog (1) rises to the highest Position.
2. Tilt back the machine head.
3. Loosen the screw (2).
4. Move the feed bar(3) up or down to make adjustment.
5. Tighten the screw (2).

7-3. Adjusting the feed dog angle



The standard angle for the feed dog (1) when it is at its highest position above the needle plate is when the “ ” mark on the shaft (2) is aligned with the feed rocker bracket arm (3) and the feed dog (1) is parallel to the needle plate.

1. Make the machine hand wheel backward, rise the feed dog from lowest position to the same position with needle plate.
2. Tilt back the machine head.
3. Loosen the two set screws (4).
4. Turn the shaft (2) in the direction of the arrow within a range of 90 with respect to the standard position. (Fig.[C])
In order to prevent puckering, lower the front of the feed dog (1).
In order to prevent the material from slipping, raise the front of the feed dog (1).
5. Securely tighten the set screws (4),

7.

Adjusting the thread tension



CAUTION



Turn off the power switch before removing or inserting the bobbin case.

The machine may operate if the treadle is depressed by mistake, which could result in injury.

Good even stitches



Upper thread

Lower thread



Upper thread tension too weak
Lower thread tension too strong



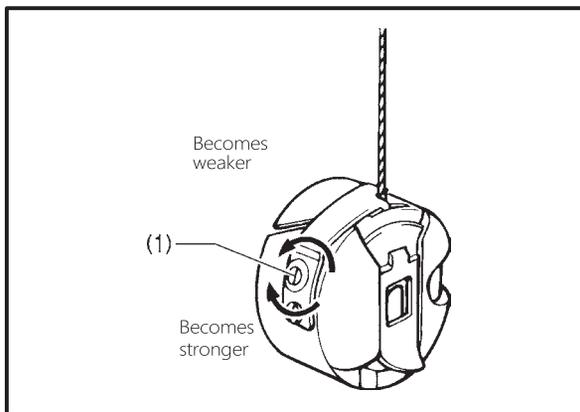
Increase the upper thread tension. Decrease the lower thread tension.



Upper thread tension too strong
Lower thread tension too weak

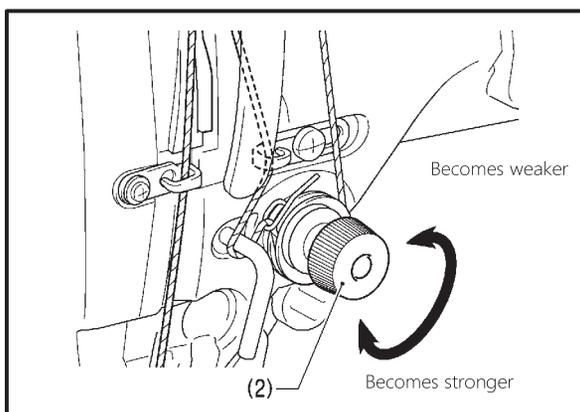


Decrease the upper thread tension. Increase the lower thread tension.



<Lower thread tension>

Adjust by turning the adjustment screw (1) until the bobbin case drops gently by its own weight while the thread end coming out of the bobbin case is held.



<Upper thread tension>

After the lower thread tension has been adjusted, adjust the upper thread tension so that a good, even stitch is obtained.

1. Lower the presser foot.
2. Adjust by turning the tension nut (2).

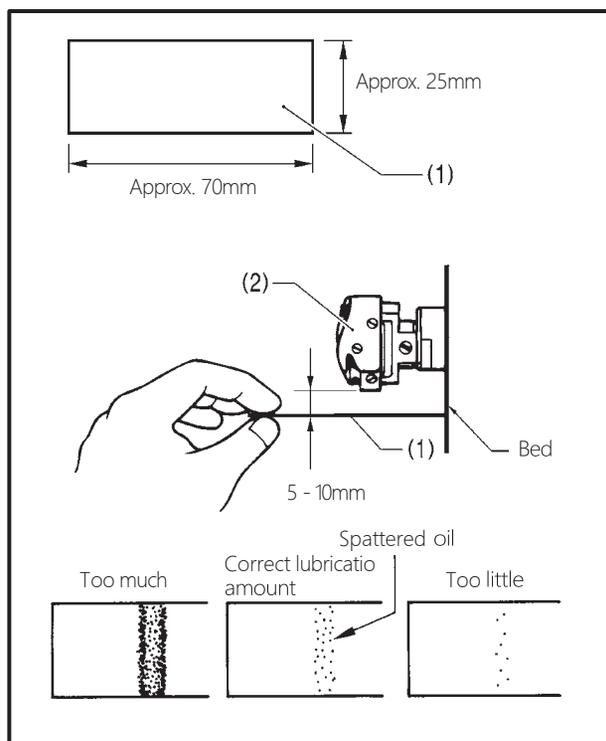
9. Adjusting the rotary hook lubrication amount

CAUTION



Be careful not to touch your fingers or the lubrication amount check sheet against moving parts such as the rotary hook or the feed mechanism when checking the amount of oil supplied to the rotary hook. If care is not taken, injury may result.

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



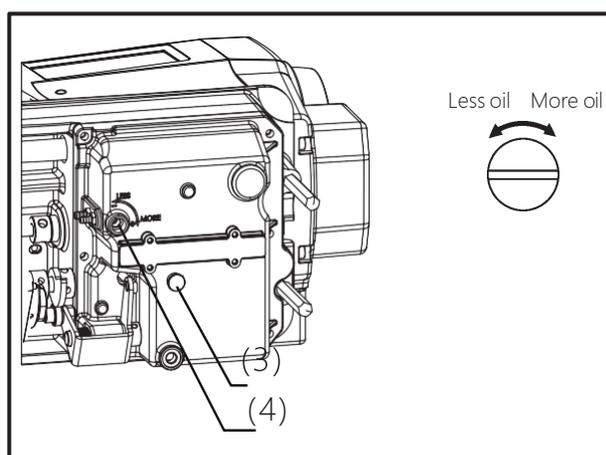
<Checking the lubrication amount>

1. Remove the thread from all points from the thread take-up lever to the needle.
2. Use the lifting lever to lift the presser foot.
3. Run the machine at the normal sewing speed for approximately 10 minutes without sewing any material (following the same start/stop pattern as when actually sewing).
4. Place the lubrication amount check sheet (1) to the left of the rotary hook (2) and hold it there. Then run the sewing machine at the normal sewing speed for 10 seconds. (Any type of paper can be used as the lubrication amount check sheet (1).)
5. Check the amount of oil which has spattered onto the sheet.

If adjustment is necessary, carry out the following operations in "Adjusting the lubrication amount".

NOTE:

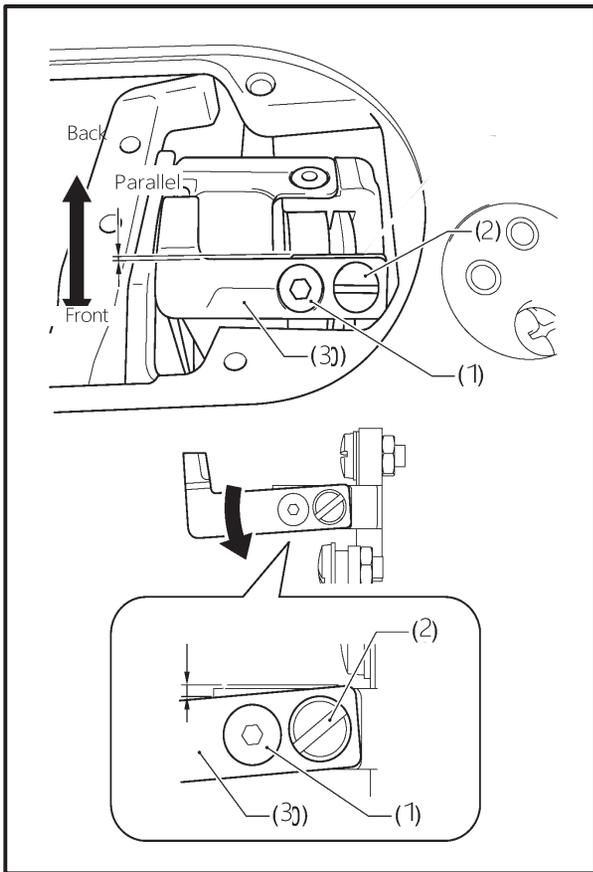
If the lubrication amount does not match the correct amount shown in the illustration at left (if the amount of spattered oil is too much or none at all), turn the adjusting screw (3) clockwise to fully tighten it, turn it back counterclockwise by 3 1/2 turns, and then carry out the following adjustment.



<Adjusting the lubrication amount>

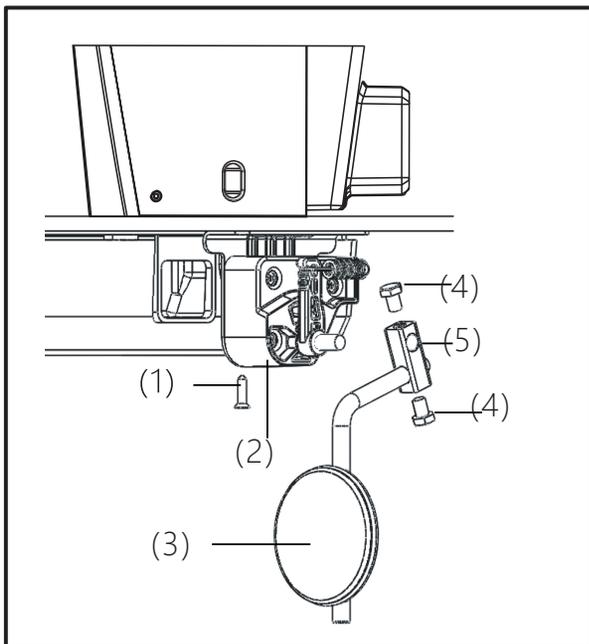
1. Tilt back the machine head.
2. Remove the rubber cap (3).
3. Turn the adjusting screw (4) to adjust the lubrication amount.
 - If the rotary hook adjusting screw (4) is turned clockwise, the lubrication amount becomes greater.
 - If the rotary hook adjusting screw (4) is turned counterclockwise, the lubrication amount becomes smaller.
4. Check the lubrication amount again according to the procedure given in "Checking the lubrication amount" above.
 - * Turn the rotary hook adjusting screw (4) and check the lubrication amount repeatedly until the lubrication amount is correct.
5. Put the rubber (3) stopper back in place.
6. Check the lubrication amount again after the sewing machine has been used for approximately two hours.

10. Thread trimming



1. When use thick thread or not trim, loosen the screw (1) and (2), adjustment the moving knife (3) angle.
2. Knife (3) tilted to the inside, the knife surface pressure rise. Slanting outward, the knife surface pressure drop.
3. Adjust the knife (3) anger, then re tighten the screw (1) and screw (2).
4. After adjustment, manually move up and down the knife holder to confirm whether the machine can trim thread normally or not.

11. Knee control installation



5. The electronic knee assembly (2) is fixed on the plate and the fixed screw (1) is tightened.
6. Connect the knee control assembly (3) with the knee control joint (5) and the electronic knee assembly (2).
7. Tighten the screw (4) .
8. Check whether the knee control is flexible after installation.



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KAULIN MFG. CO., LTD.

由於對產品的改良及更新，本產品零件圖及外觀的修改恕不事先通知。

The specification and/or appearances of the equipment described in this parts list are subject to change because of modification which will without previous notice.

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