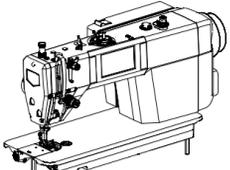


花样缝电脑平缝机 S610 Series

Computerized special stitch pattern lockstitch sewing machine

使用说明书 OPERATION MANUAL 零件手册 PARTS BOOK



重要安装事项

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。

- 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。
- 速读所有说明,并保存好使用说明书。如果需要,请随时翻阅。
- 使用本机前,必须弄清与本机有安全相关规定。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,决不允许。
- 操作人员必须经过适当的培训。
- 为了您的人身安全,我们建议您戴上安全防护镜。
- 下列情况下,请关闭电源开关或拔下电源插头:
 - 7-1 机针穿线和换线时;
 - 7-2 更换机针、压脚、针板、送料牙、布料导板等;
 - 7-3 进行维修时;
 - 7-4 操作无人时。
- 在机器加油前时,若不小心让油接触眼睛、皮肤或咽下机油或润滑油,请立即清洗被沾染部位或去医院检查。
- 无论机器运转与否,严禁乱动机器零件和配套装置。
- 机器的维修、改造和调整等工作必须由专业技术人员进行。
- 应由专业人员进行一般的维修和保养工作。
- 必须在专业维修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。
- 使用期间要定期全面彻底清洗机器。
- 正确操作本机时,必须进行运转,工作环境远离强噪声源,如高频电焊机等等。
- 由电气人员选择合适的插头和有地的插座。
- 若需要改造或改进本机,请采用有效可行的安全措施。本公司对此而产生的伤害不承担责任。
- 本机只适用于专业缝纫。
- 两种警告提示符:
 - 操作人员或维修人员请注意
 - 特别注意事项

IMPORTANT SAFETY INSTRUCTIONS

To get the most out of the many functions of this machine and operate it safely, it is necessary to use this machine correctly. Please read this Instruction Manual carefully before use. We hope you will enjoy the use of your machine for a long time. Please remember to keep this manual in a safe place.

1. Observe the basic safety measures, including, but not limited to the following ones, whenever you use the machine.
2. Read all the instructions, including, but not limited to this Instruction Manual before you use the machine. In addition, keep this Instruction Manual so that you may read it at any-time when necessary.
3. Use the machine after it has been ascertained that it conforms with safety rules/standards valid in your country.
4. All safety devices must be in position when the machine is ready for work or in operation. The operation without the specified safety devices is not allowed.
5. This machine shall be operated by appropriately-trained operators.
6. For your 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) and replacing bobbin.
 - 7-2 For replacing part(s) of needle, presser foot, throat plate, feed dog, cloth guide etc.
 - 7-3 For repair work.
 - 7-4 For when leaving the working place when the machine is unattended.
8. If you should allow oil, grease, etc. used with the machine and devices to come in contact with your eyes or skin or swallow any of such liquid by mistake, immediately wash the contacted areas and consult a medical doctor.
9. Tampering with the live parts and devices, regardless of whether the machine is powered, is prohibited.
10. Repairing, 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 you find a failure of any of electrical components, immediately stop the machine.
13. Periodically clean the machine through the period of use.
14. Grounding the machine is always necessary for the normal operation of the machine. The machine has to be operated in an environment that is free from strong noise sources such as high-frequency welder.
15. An appropriate power plug has to be attached to the machine by electric technicians. Power plug has to be connected to grounded receptacle.
16. Remodel or modify the machine in accordance with the safety rules/standards while taking all the effective safety measures. We assume no responsibility for damage caused by reforming or modification of the machine.
17. The machine is only allowed to be used for the spose intended. Other used are not allowed.
18. Warning hints are marked with the two shown symbols.
 - Danger of injury to operator or service staff
 - Items requiring special attention

6. 踏板的调整 Adjustment of the pedal

注意 CAUTION

为了防止意外启动造成的事故,请关电源后再行操作。
Turn off the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

1. 踏板角度的调整: 1) 向前踩踏板时,踏板长度可以调节踏板的角度。旋紧螺钉①,上下移动上盖杆(向下为踏板角度减小)以调节踏板长度。
2. 调节完成后再旋紧螺钉②。
2. 踏板压力的调整: 脚踏板在踩上并向前踩踏板时,缝切机作低速运转。如感觉踏板力较轻时,将踏板力调节弹簧挂注在踏板力调节螺钉③的a或b或c或d处来逐渐增大。a为最小,b,c,d依次逐渐增大。
3. 踏板回弹的调整: 1) 松开脚踏板,脚踏板回弹时脚踏板回弹力: 拧紧脚踏板回弹力将大拧松脚踏板回弹力将减小。2) 调节脚踏板回弹力后,拧开脚踏板螺母。

1. Adjusting the angle of treadle
1) Adjust the angle of treadle only by adjusting the length of treadle connecting rod unscrew screw ①, and adjust the length of treadle connecting rod ② by moving upward/downward the upper connecting rod of ② and lower connecting rod ③.
2) Screw down screw ② when adjustment is over.
2. Adjustment of the strength of pedal
The sewing machine runs at a low speed when step forward on the pedal slightly. If the strength is insufficient, hang the stepping adjustment spring ③ on the panel spiral arm driving lever ③ in order to adjust strength. It is the minimum stepping strength. a, b, c, d increase gradually.
3. Adjustment of stepping return strength
1) Loosen nut ④ and turn bolt ⑤ to adjust stepping return strength: tighten bolt ⑤, the strength increases/loosen bolt ⑤, the strength decreases.
2) Tighten nut ④ after adjusting stepping return strength.

踏板操作 Pedal operation

1. 踏板有级操作: 1) 向前踩踏板到底时(如图A所示), 2) 再用力向前踩踏板时变为高速操作(如图A所示), 3) 当脚不向前踩踏板时,脚踏板回到原位时,缝切机停止运转(如图B所示)上图中箭头所指为踏板行程C点。
- 4) 再用力向后踩踏板为切切操作(如图B所示)。
- 5) 使用自动压脚提升装置时,在停止和切切之间加上一级开关D, 前后后踏板压力压脚提升时,脚踏板向后强力压脚,压脚下降进行切切操作,再次进行压脚提升时。

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 A).
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) When you stop stepping on it and the machine stop working (needle in the upper or down position) (as show in the picture B).
4) The machine runs threads when you fully depress the back part of the pedal (as show in the picture A).
5) When the auto-lifter is used one more operating switch is provided between the sewing machine stop switch and thread trimming switch. The presser foot goes up when you lightly depress the back part of the pedal (D) and if you further depress the back part the thread trimmer is actuated.

7-1. 标准调整 Standard adjustment

注意 CAUTION

只有经过训练的专业人员才能进行缝切机的维修、保养和检查。Maintenance and inspection of the sewing machine should only be carried out by a qualified. Ask your dealer or a qualified electrician to carry out any maintenance and inspection of the electrical system. 取下安全保护装置,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。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. 缝切机头倒下或抬起时,请用双手进行操作。单手操作时因缝切机的重量万一滑落易导致受伤。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,否则踩下踏板时,缝切机运作会导致受伤。检查、调整和维修要更换接、切刀等易损零部件。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. When carrying out inspection, adjustment and maintenance - When replacing common parts such as the rotary hook and knife.

7-1. 调线调整

1. 旋松螺钉①。
2. 移动右线钩②进行调节: 向左方向(即A方向)移动,挑线量会增加;反之向右方向(即B方向)移动,挑线量将会减少。(右线钩上的刻线C与螺钉中心一致时为标准位置)。
3. 调节完成后拧紧螺钉①。

1. Unscrewing the screw ①.
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 is obtained when graduation line C on right thread hook is aligned to screw center).
3. Remember to tight the screw ① after adjusting.

7-2. 送料牙的高度 Adjustment of the Height of feed dog

1. 转动手轮,将送料牙升到针板的最高位置。
2. 将脚踏板放下,并支到机头支柱上。
3. 旋松送料牙形曲柄上的紧固螺钉①。
4. 转动送料牙形曲柄进行调整,将送料牙形曲柄②向A方向转动,送料牙变高;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,中厚料机送料牙形曲柄的标准高度为0.8-1.0mm,厚料机送料牙形曲柄的标准高度为1.1-1.3mm。
5. 调节完成后拧紧送料牙形曲柄上的紧固螺钉①。

1. Turn the pulley until the feed dog rises to the highest position.
2. Turn over the sewing machine head on the supporting bar.
3. Unscrewing the tightened screw ① in the feed lifting crank ②.
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 towards B direction the feed dog will be lower. (When the feed dog in the highest position, the standard height of the middle-heavy machine is 0.8-1.0mm and standard height of the heavy duty machine is 1.1-1.3mm).
5. Remember to tighten the tightening screw ① in the feed lifting crank ② after adjusting.

安全操作事项 FOR SAFE OPERATION

1. 为避免触电,请不要打开机器的电箱盖,也不要接触电箱内部组件。
1. To avoid electrical shock hazards, do not open the cover of the electrical box for the motor nor touch the components mounted inside the electrical box.
1. 为避免人身伤害,移动防护罩、护手挡安全装置时,请不要启动机器。
2. 为尽可能避免机器运转造成的人身伤害,手指、头部和衣服应远离上轮,上轮周围不要放置任何物品。
3. 为避免人身伤害,当您打开电源开关或操作机器时,切勿将手放在机针下方。
4. 为避免人身伤害,机器运转时,切勿将手放入挑线杆防护罩内。
5. 旋松送料牙时,切勿将手指放在送料牙附近。另外,更换芯时,请关闭机器电源开关。
6. 为尽可能避免人身伤害,当抬起旋梭时,切勿将手指放入机器内部。
7. 为尽可能避免机器的突然启动所造成的事故,抬起机头时,请关闭机器的电源。
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,请关闭机器的电源开关。
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,请关闭电源开关。
1. To avoid personal injury, never operate the machine with any of the belt cover, finger 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, cover and the motor while the machine is in operation. In addition, place nothing around while the machine is in operation.
3. To avoid personal injury, never put your hand under the needle when you turn ON the power switch or operate the machine.
4. To avoid personal injury, never put your fingers into the thread take-up cover while the machine is in operation.
5. The hook rotates at a high speed while the machine is in operation. To prevent possible injury to hands, be sure to keep your hands away from the vicinity of the hook during operation. In addition, be sure to turn OFF the power to the machine when replacing the bobbin.
6. To avoid possible personal injuries, be careful not to allow your fingers in the machine when tilting/raising the machine head.
7. To avoid possible accidents because of abrupt start of the machine, turn OFF the power to the machine when tilting the machine head.
8. If your machine is equipped with a serve-motor, the motor does not produce noise while the machine is at rest. To avoid possible accidents due to abrupt start of the machine, be sure to turn OFF the power to the machine.
9. To prevent possible accidents because of electric shock or damaged electrical component(s), turn OFF the power switch in prior to the connection /disconnection of the power plug.

开机前的注意事项 Precautions Prior to Startup

1. 机头装配前为了防止机件生锈,在部分均涂有较厚的防锈油,同时机头装配后,还能在较长的贮藏和长途运输阶段涂油碳化或在机器表面涂覆灰尘,所以必须将表面的油脂及用汽油和洁净的软布擦拭干净。
2. 机器出厂时,虽经过周密的检查和试验,但在长途运输中也可能受到强烈的震动使机件松动或弯曲,所以应进行一次全面检查,并转动上轮,使机头完全转动自如,碰触或观察其它不均匀的阻力,不正常的声响,如有应作适当的调整,机器状态正常后方可正式试车。
3. 进油盒内机油面高度没有在正常范围内也不能开车。
4. 机器运转时,上轮转向应该是逆时针方向(从上轮外圈看)。
5. 确认电控自动上标电压及相位是否正确。
6. 生产日期见合格证。
1. The machine head is coated with a thick layer of rust-prevention grease before encasement, and the encased machine head may possibly be subjected to grease hardening and dust buildup on the machine surface in process of long storage and long-haul traffic; therefore, take care to remove the grease and dust from the surface using soft cloth and gasoline.
2. Though the machine was inspected and tested with care before factory leaving, it might be affected by violent vibration resulting in looseness or distortion of the machine parts; therefore the operator shall thoroughly check the machine, turn the upper wheel by hand and check it for difficulty in free rotation, slight impact, and other uneven resisting force or abnormal noises, and make appropriate adjustment if any to restore the machine state before formal trial run.
3. Never start up the machine if the oil liquid level in the oil box falls outside the normal range.
4. The upper wheel shall rotate counterclockwise (when it is viewed from the lateral surface of the upper wheel) when the machine is operating.
5. Check whether the voltage and phases indicated on the electric-control data plate are correct.
6. The date of manufacture is indicated on the certificate of conformity.

使用注意事项 Precautions for Use

1. 当接通电源或机器运转时,请勿将手与机针接触。
2. 机器运转时,请勿将手指伸入挑线杆防护罩内。
3. 操作者用手送料时,请勿将手指伸入针架。
4. 机头翻动及拆手面时,一定要切断电源。
5. 操作者离开机器时,必须切断电源。
6. 机器运转时,绝不允许头部以及任何物体靠近上轮、挑线杆。
7. 只有在停机时,才能拆卸防护罩或其它保护装置。
8. 不能用香蕉水等油漆稀释剂擦拭机头表面。
1. Never touch the needle by hand when the machine is powered on or while it is operating.
2. Never put your finger into the protection cover of take-up lever during operation of the machine.
3. The operator must not put his finger into the needle guard bracket when he feeds the sewing materials by hand.
4. Operator must trim off the electricity supply before he turns over the machine head or removes the hand cover.
5. The operator must trim off the electricity supply before he gets away from the machine.
6. Prohibit the head, hands and anything to approach the upper wheel and bobbinwinder while the machine is operating.
7. Never remove or mount the protection cover or other protection devices before the machine is stopped.
8. Never wipe up the surface of machine head using paint thinner such as acetone.

1. 缝切机规格 MACHINE SPECIFICATIONS

	620	620M	620H
用途 USE	薄料、中厚料	厚料	厚料
MAX. Sewing speed	5000sti/min	4000sti/min	4000sti/min
最大针距 MAX. Stitch length	5mm	7mm	7mm
压脚高度 手抬 lifting lever		5.5mm	
压脚高度 膝控 Knee lifter		13mm	
压脚高度 自动 automatic		9.5mm	
送料牙	1.0mm	1.2mm	1.2mm
机针 Needle	DBx1 9#-18#	DPx5 18#-22#	
润滑油	15号白油 NO.10 White oil		

2-1. 安装方法 Installation

- ①. 调速器
- ②. Speed controller
- ③. 连杆
- ④. Connecting rod

2-2. 安装 Installation

- ①. Nail (8pcs)
- ②. Rubber cushions (2pcs)
- ③. Head cushions(small) (2pcs)
- ④. Head cushions(big) (2pcs)
- ⑤. Tray (1pcs)

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

1. 转动手轮,将送料牙升到针板的最高位置。
2. 将缝切机放倒,并支到机头支柱上。
3. 旋松压架①上的紧固螺钉②。
4. 用螺丝刀转动偏心销③进行调节: 将偏心销③向A方向转动,送料牙前缘放下;向B方向转动,送料牙前缘抬起(当送料牙升到针板的最高位置时,送料牙标准倾斜角为偏心销③上的刻点C与压架①上的刻线D对齐,送料牙与针板平行)。
5. 调节完成后拧紧压架①上的紧固螺钉②。

1. Turn the pulley until the feed dog ① rises to the highest position.
2. Turn over the sewing machine head on the supporting bar.
3. Unscrewing the tightening screw ② in the teeth pedestal ①.
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 feeds to 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 ① and the feed dog should be parallel with needle plate.)
5. Remember to tighten the tightening screw ② in the teeth pedestal ① after adjusting.

为了防止起皱,可降低送料牙前缘。
为了防止在重缝制时布料不一致(缝线不合),可提高送料牙前缘。
调节送料牙的倾斜度后,送料牙的高度也会发生变化,因此请重新调节送料牙的高度。
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.
The height of the feed dog will change after the angle has been adjusted, so it will be necessary to readjust the height of the feed dog.

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

注意 CAUTION

取出梭芯套时,请关闭电源。
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.

面线 Upper thread
底线 Lower thread

面线张力过小或底线张力过大。
Upper thread tension too weak or Lower thread tension too strong

面线张力过大或底线张力过小。
Upper thread tension too strong or Lower thread tension too weak

1. 底线张力的调节: 拉在梭芯套中露出的线头,旋转调节螺钉①进行调节: 旋紧调节螺钉①则底线张力变大,反之则底线张力变小。
1. Adjusting the tension of bobbin thread: Hold the end of a thread which hanging from the bobbin case and use the adjusting rotating screw ① to regulate. The tension of the bottom thread is become strong by tight the screw ①, loose the screw to make it weak.
2. 面线张力的调节: 在底线张力调节之后,调节面线张力以使针脚均匀平整。
1) 使用压脚架时将压脚放下。
2) 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。
3) 调整面线张力时,将螺钉③和螺钉④松开,调整上动力④的角度。
4) 调整上动力④的角度时,刀面压力将长升,向外侧倾斜时,刀面压力下降。
5. 调整好后上动力④的角度后重新拧紧压脚架①和螺钉④。
2. Adjusting the tension of needle thread
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 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 when toward anti-clockwise (B).

9. 关于旋梭部油量(迹)调整方法 Adjusting thr amount of oil(oil splashes) in the hook

注意 CAUTION

调整梭芯套时,请关闭电源。
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.

面线 Upper thread
底线 Lower thread

面线张力过小或底线张力过大。
Upper thread tension too weak or Lower thread tension too strong

面线张力过大或底线张力过小。
Upper thread tension too strong or Lower thread tension too weak

1. 旋松螺钉①。
2. 移动右线钩②进行调节: 向左方向(即A方向)移动,挑线量会增加;反之向右方向(即B方向)移动,挑线量将会减少。(右线钩上的刻线C与螺钉中心一致时为标准位置)。
3. 调节完成后拧紧螺钉①。

1. Unscrewing the screw ①.
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 is obtained when graduation line C on right thread hook is aligned to screw center).
3. Remember to tight the screw ① after adjusting.

2-3. 机头 Machine head

- ①. 机头
- ②. 机头铰链 (2pcs)
- ③. 机头支柱

- ①. Hinges head
- ②. Hinges (2pcs)
- ③. Frame support bar

2-4. 线架 Cotton stand

- ①. 线架
- ②. Cotton stand

注意: 将螺母①拧紧以便将两个橡胶垫圈②和垫圈③夹紧,使线架④固定。

NOTE: Securely tighten the nut ①, so that the two rubber cushions ② and the washer ③ are securely clamped and so that the cotton stand ④ does not move

3. 加油方法 Lubrication

注意: 防止上轮零件的启动造成的事故,请关闭电源后再行操作。
Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

运转缝切机前

- 1) 请给机头进油槽①里,一直加到视线标以上A的位置。
- 2) 油槽的油面降到视线标B以下时,请再次补充机油。
- 3) 加满后连续运转几圈,如果润滑油正常时,可以通过油窗②看到油的流动。
- 4) 油流动量的多少,与油量的多少无关。

Information on lubrication

- 1) Fill oil pan ① with Machine Oil up to HIGH mark A.
- 2) When the oil level lowers below LOW mark B, refill the oil pan with the specified oil.
- 3) When you operate the machine after lubrication, you will see splashing of through oil sight window ② if the lubrication is adequate.
- 4) Note that the amount of the splashing oil is unrelated to the amount of the lubricating oil.

run your machine at 3,000 to 3,500 rpm. for about 10 minutes for the purpose of break-in.

面油油量的调整

- 1) 调整线杆和针杆轴油窗①的油量时,转动面油调整螺钉②进行调节。
- 2) 调整线杆③从图A的位置向④方向转动,转动到接近视线标⑤时,油量最小。
- 3) 从图A所示的位置向④方向转动,当转到与针杆轴油窗⑤对齐时,油量最大。

Adjusting the amount of oil supplied to the face plate parts

- 1) Adjust the amount of oil supplied to the thread take-up and needle bar crank ② by turning adjust pin ①.
- 2) The minimum amount of oil is reached when marker dot A is brought close to needle bar crank ② by turning the adjust pin in direction ④.
- 3) The maximum amount of oil is reached when marker dot A is brought to the position just opposite from the needle bar crank by turning the adjust pin in direction ⑤.

4. 面线的穿法 Threading the upper thread

注意 CAUTION

在穿线过程中,请切断电源。当误按启动开关时,缝切机动作会导致人员受伤。
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.

在穿引面线之前转动手轮,抬高挑线杆①,这样会使穿线更加容易,并防止面线在缝切开始时脱落。
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 out at the sewing start.

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

当机针①从最低位置向上移动1.8mm(2.2mm用于M和H规格),到达旋梭与针杆轴套下端对齐的位置时,旋梭尖②应和机针①对齐,如图显示。使机针①上端与旋梭尖②之间的距离为0.5-0.7mm。
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 ③, and then align the tip of the rotary hook ④ with the center of the needle ①. The distance between the tip of the rotary hook ④ and the needle ① should be approximately 0.5-0.6mm.
3. Securely tighten the set screws ③.

9. 关于旋梭部油量(迹)调整方法 Adjusting thr amount of oil(oil splashes) in the hook

油量(油迹)适合标准 / Sample showing the appropriate amount of oil

从旋梭①中流出的油 / Splashes of oil from the hook

- 1) 油量适当(小): Appropriate amount of oil (small)
- 2) 油量适当(大): Appropriate amount of oil (large)

油量适当(小): Appropriate amount of oil (small)

油量适当(大): Appropriate amount of oil (large)

10. 切线 Thread trimming

1. 使用粗线或不能切线时,将螺钉①和螺钉②松开,调整上动力④的角度。
2. 上动力④向内侧倾斜时,刀面压力将长升,向外侧倾斜时,刀面压力下降。
3. 调整好后上动力④的角度后重新拧紧压脚架①和螺钉④。
4. 调整好后上动力④的角度后重新拧紧压脚架①和螺钉④。

1. When use thick thread or not trim, loosen the screw ① and ②, adjustment the moving knife ④ angle.
2. Knife ④ tilted to the inside, the knife surface pressure presser.
3. Adjust the knife ④ angle, then retighten 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.

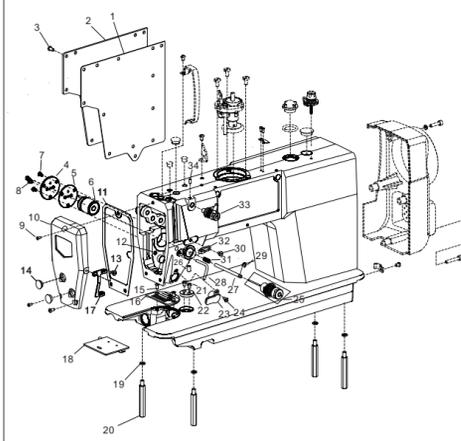
11. 踏板压力和行程 Pedal pressure and pedal stroke

注意: 为了防止意外的自动启动造成的事故,请关电源后再行操作。
Turn Off the power before starting thr work so as to prevent accidents caused by abrupt start of the sewing machine.

1. 踏板压力的调整: (1) 旋松脚踏板弹簧①可以调整。(2) 把弹簧挂到左侧之后,压力变轻。(3) 挂到右侧之后变重。
2. 踏板行程的调整: (1) 脚踏板回弹力力调节弹簧②可以调整。(2) 拧紧调节踏板行程压力变小。(3) 拧松调节踏板行程压力变大。
3. 踏板行程的调整: (1) 把连杆③插到右侧的孔里之后行程变大。

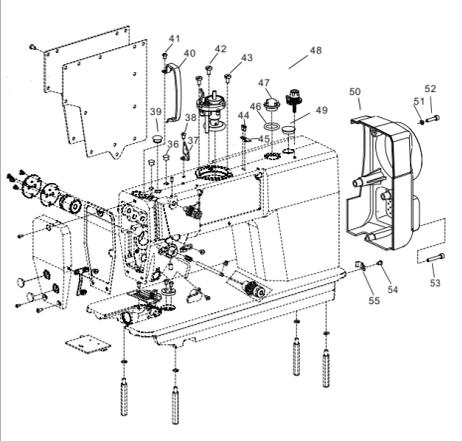
1. Adjustment of pedal pedaling pressure (1). It can be adjusted by replacing it with front tread spring ①. (2). After the spring is hung on the left, the pressure becomes lighter. (3). Be hung into the right after the heavy. 2. Adjustment of pedal back stepping force (1). It can be adjusted by stepping back on the pressure adjusting spring ② with the pedal. (2). Tighten the adjusting screw to increase the pressure. (3). Loosen the adjusting screw to reduce the pressure. 3. Adjustment of pedal pedaling stroke (1). After inserting the connecting rod ③ in to the hole on the right, the stroke becomes larger.

1. 机壳分组件/Machine frame&miscellaneous cover components



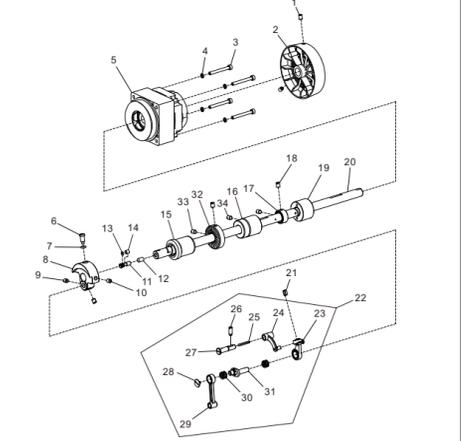
序号 Ref.No.	物料号 Part.No.	名称	Description	数量 Qty	备注 Remark
1	29.07.005	后盖板垫	Side plate gasket	1	
2	29.07.003	后盖板	Side plate	1	
3	02.09.033	螺钉	Screw	10	
4	XXXXXX	电磁铁固定板	Fixed Plate	1	
5	XXXXXX	电磁铁固定板垫	Fixed Plate gasket	1	
6	XXXXXX	松线电磁铁部件	Electromagnets	1	
7	XXXXXX	螺钉	Screw	3	
8	XXXXXX	螺钉	Screw	1	
9	02.09.013	螺钉	Screw	3	
10	29.07.064	面板	Face plate	1	
11	29.07.004	面板垫	Face plate gasket	1	
12	29.01.204-1	六角螺母	Nut	1	
13	02.09.010	螺钉	Screw	1	
14	02.05.016	面板塞	Rubber plug	2	
15	02.09.026	螺钉	Screw	2	
16	29.01.114	针板	Needle plate	1	
17	05.01.028	针板	Needle plate	1	H
18	29.07.011	左线钩	Arm thread guide left	1	
19	02.06.001	推板部件	Side plate ASM.	1	
20	23.302	弹簧垫圈	Washer	4	
21	01.01.001	底板支柱	Bed screw stud	4	
22	02.09.035	螺钉	Screw	2	
23	29.07.056H	卷边器	Ruler plate	1	
24	11.05.099	螺钉	Screw	1	
25	02.02.012BZ	夹线器部件	Thread take-up device	1	
26	02.02.012BZ	夹线器部件	Thread take-up device	1	H
27	02.09.035	螺钉	Screw	1	
28	29.01.204	侧盖钩	Side plate gasket	1	
29	23.300	开口挡圈	Snap ring	1	
30	02.09.010	螺钉	Screw	1	
31	29.01.199	松线螺钉弹簧	Spring	1	
32	02.07.012	右线钩	Arm thread guide right	1	
33	29.01.053BZ	上夹线器	Thread take-up device	1	
34	29.02.108	螺钉	Screw	1	

1. 机壳分组件/Machine frame&miscellaneous cover components



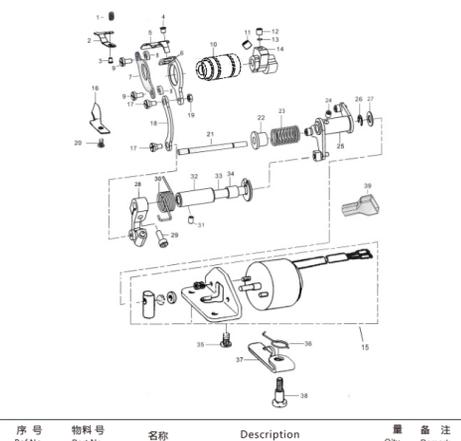
序号 Ref.No.	物料号 Part.No.	名称	Description	数量 Qty	备注 Remark
35	02.05.017	橡胶塞	Rubber plug	1	
36	02.01.179	三股过线板	Thread tension guide	1	
37	29.07.063	螺钉	Screw	1	
38	02.09.067	螺钉	Screw	1	
39	02.05.013	橡胶塞	Rubber plug	1	
40	29.07.084	挑线杆护套	Thread take-up lever cover	1	
41	02.09.007	螺钉	Screw	1	
42	29.02.005	螺钉	Screw	3	
43	29.07.082	挑线器部件	Bobbin wider ASM.	1	
44	29.02.096	螺钉	Screw	2	
45	29.01.017	挑线杆	Thread cutter	1	
46	02.05.005	O形圈	O-ring	1	
47	02.05.006	油窗	Oil window	1	
48	29.01.053BZ	挑线夹线器部件	Thread take-up device	1	
49	29.01.109	橡胶塞	Rubber plug	1	
50	30.01.096	电机罩壳	Cover Piece	1	
51	0000	垫圈	Washer	3	
52	29.02.097	螺钉	Screw	3	
53	0000	螺钉	Screw	1	
54	02.09.007	推板部件	Side plate ASM.	1	
55	05.05.016	电线夹	Cable clip	1	

2. 上轴、挑线分组件/Main shaft&thread take-up components



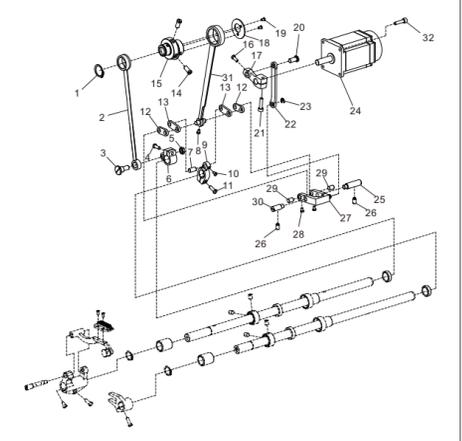
序号 Ref.No.	物料号 Part.No.	名称	Description	数量 Qty	备注 Remark
1	29.02.103	螺钉	Screw	2	
2	29.07.083	上轮	Head wheel	1	
3	29.07.067	螺钉	Screw	1	
4	23.303	弹簧垫圈	washer	4	
5	30.01.094	上轴电机	Motor	1	
6	02.09.004	螺钉	Screw	1	
7	01.03.012	O形圈	O-ring	1	
8	29.01.151	针杆曲柄	Counter weight	1	
9	01.04.019	挑线杆	Thread take-up lever	1	
10	29.01.042	动刀架	Knife bracket	1	
11	XXXX	压板紧固螺钉	Washer	2	
12	29.01.211	下轴前轴套	Bearing support	1	
13	XXXX	剪线凸轮固定螺钉	Screw 1/4"x40 L=10	1	
14	XXXX	剪线凸轮固定螺钉	Screw 1/4"x40 L=6	1	
15	XXXX	剪线凸轮垫片	Washer	1	
16	29.01.047	切线凸轮	Thread cutter cam	1	
17	XXXX	剪线电磁铁组件	Mthread trimmer solenoid asm	1	
18	29.07.077	分线器	Hneedle guard patch	2	H
19	XXXX	刀轴连杆	Screw SM11/64"x40	2	
20	29.01.029	刀轴连杆	Thread driving crank	1	
21	XXXX	刀轴连杆螺母	Nut SM11/64"x40	1	
22	02.09.034	分线器固定螺钉	Screw SM9/64"x40 L=6	1	
23	29.01.048	刀轴驱动轴	Thread cutter driving shaft	1	
24	XXXX	扭簧端盖	Spring cover	1	
25	XXXX	切线凸轮复位簧	Spring	1	
26	XXXX	剪线驱动轴固定螺钉	Screw SM1/4"x40 L=6	1	
27	02.04.015H	挑线杆部件	Thread take-up lever Asm.	1	H
28	02.04.019	挑线杆	Thread take-up lever	1	H
29	02.04.018	挑线杆	Thread take-up bar	1	
30	23.76	油线	Oil thread	1	
31	02.09.005	螺钉	Screw	1	
32	02.04.020	挑线杆轴套	Thread take-up crank shaft	1	
33	29.01.064	螺钉	Screw	1	
34	29.01.049	针杆连杆	Needle bar crank rod	1	
35	01.04.030	滚珠轴承	Bearing	2	
36	02.04.016	挑线曲柄	Needle bar crank	1	
37	02.04.016H	挑线曲柄	Needle bar crank	1	H
38	29.04.014	主驱动轮	Wheel	1	
39	29.02.039	螺	Screw	2	
40	01.10.040	螺	Screw	2	

5. 剪 分组件/Thread Trimmer Components



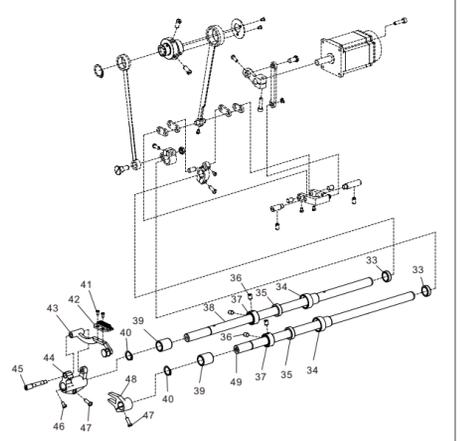
序号 Ref.No.	物料号 Part.No.	名称	Description	数量 Qty	备注 Remark
1	XXXX	固定刀	Fixed knife	1	
2	XXXX	固定刀螺钉	Screw SM9/64"x40 L=9	1	
3	XXXX	固定刀螺钉	Screw SM11/64"x40 L=4	1	
4	XXXX	刀架	Motorial knife	1	
5	29.01.017	刀架	Knife bracket	1	
6	29.01.044	刀架压板	Knife bracket presser	1	
7	XXXX	刀架压板垫圈	Washer	1	
8	29.01.007	O形圈	O-ring	2	
9	29.01.211	下轴前轴套	Bearing support	1	
10	XXXX	剪线凸轮固定螺钉	Screw 1/4"x40 L=10	1	
11	XXXX	剪线凸轮固定螺钉	Screw 1/4"x40 L=6	1	
12	XXXX	剪线凸轮垫片	Washer	1	
13	29.01.047	切线凸轮	Thread cutter cam	1	
14	XXXX	剪线电磁铁组件	Mthread trimmer solenoid asm	1	
15	29.07.077	分线器	Hneedle guard patch	2	H
16	XXXX	刀轴连杆	Screw SM11/64"x40	2	
17	29.01.029	刀轴连杆	Thread driving crank	1	
18	XXXX	刀轴连杆螺母	Nut SM11/64"x40	1	
19	02.09.034	分线器固定螺钉	Screw SM9/64"x40 L=6	1	
20	29.01.048	刀轴驱动轴	Thread cutter driving shaft	1	
21	XXXX	扭簧端盖	Spring cover	1	
22	XXXX	切线凸轮复位簧	Spring	1	
23	XXXX	剪线驱动轴固定螺钉	Screw SM1/4"x40 L=6	1	
24	02.04.015H	挑线杆部件	Thread take-up lever Asm.	1	H
25	02.04.019	挑线杆	Thread take-up lever	1	H
26	XXXX	E型卡簧	Washer, E6	1	
27	XXXX	剪线电磁铁垫圈	Washer	1	
28	XXXX	切刀驱动曲柄臂	Cutter driving crank arm	1	
29	XXXX	驱动曲柄螺钉	Screw SM3/16"x32 L=17	1	
30	29.01.007	切刀驱动曲柄臂	Spring	1	
31	XXXX	剪线驱动轴套	Screw SM15/64"x28 L=10	1	
32	29.01.064	切刀驱动轴套	Cutter driving shaft bush	1	
33	29.01.049	切刀驱动曲柄轴	Short bush	1	
34	XXXX	剪线电磁铁固定螺钉	Screw SM15/64"x28 L=11	1	
35	XXXX	松线复位簧	Spring	1	
36	XXXX	松线复位簧	Spring	1	
37	XXXX	松线复位簧	Spring	1	
38	XXXX	松线复位簧	Spring	1	
39	XXXX	松线复位簧	Spring	1	

6. 送料分组件/Feed Mechanism Components



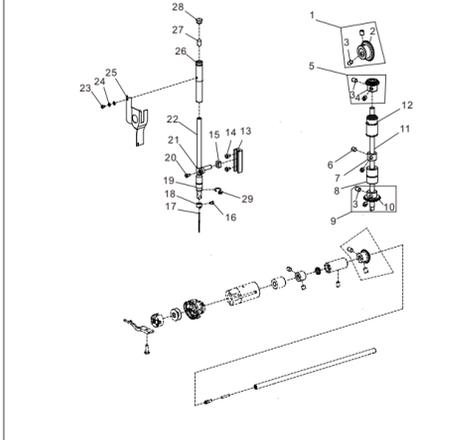
序号 Ref.No.	物料号 Part.No.	名称	Description	数量 Qty	备注 Remark
1	23.301	抽指挡圈	Snap ring	1	
2	02.07.016	抽指连杆	Connecting rod	1	
3	02.09.025	螺钉	Screw	1	
4	29.02.113	螺钉	Screw	1	
5	02.09.041	六角螺母	Nut	1	
6	02.07.023	抬牙后曲柄	Lifting rocker	1	
7	02.07.007	销	Pin	1	
8	02.09.011	螺钉	Screw	1	
9	02.07.020	送牙曲柄	Feed rocker	1	
10	02.07.020H	送牙曲柄	Feed rocker	1	H
11	02.09.011	螺钉	Screw	1	
12	01.10.023	螺钉	Screw	1	
13	02.07.008	短轴连杆	Short link	2	
14	02.07.008H	短轴连杆	Short link	2	H
15	02.07.009	长轴连杆	Long link	2	
16	02.07.022	送料偏心轮	Feed drive eccentric cam	1	
17	02.07.022H	送料偏心轮	Feed drive eccentric cam	1	H
18	29.02.101	螺钉	Screw	1	
19	29.07.038	针距曲柄	rocker	1	
20	02.07.011	偏心轮盖板	Thrust cover	1	
21	29.02.104	螺钉	Screw	2	
22	29.07.039	针距曲柄	rocker	1	
23	29.07.030	针距连杆	Link	1	
24	23.308	开口挡圈	Snap ring	1	
25	30.01.092	针距电机	Motor	1	
26	02.03.005	右轴	Pin	1	
27	02.09.005	螺钉	Screw	2	
28	29.07.089	挑线器部件	Feed adjusting ASM.	1	
29	02.09.011	螺钉	Screw	2	
30	02.07.010	销	Pin	2	
31	02.03.006	左轴	Pin	1	
32	0000	送料连杆	Connecting rod	1	
33	0000	螺	Screw	4	

6. 送料分组件/Feed Mechanism Components



序号 Ref.No.	物料号 Part.No.	名称	Description	数量 Qty	备注 Remark
33	0000	橡胶塞	Rubber plug	2	
34	29.01.036	送料前轴套	Bearing support	2	
35	29.01.036	油封	Oil seal	2	
36	0000	螺钉	Screw	4	
37	0000	送料轴	Thrust collar	2	
38	29.07.053	送料轴	Feed rocker shaft	1	
39	29.01.036	送料轴前轴套	Bearing support	2	
40	23.301	用性圈	Snap ring	1	
41	02.09.029	螺	Screw	2	
42	29.01.093	送料牙	Feed dog	1	H
43	29.01.092	牙架部件	Feed bar ASM.	1	
44	29.01.092-1	牙架曲柄	Feed bar driving crank	1	
45	29.01.092-2	牙架销	Pin	1	
46	29.01.092-3	螺钉	Screw	1	
47	29.01.092-4	螺钉	Screw	2	
48	29.01.092-6	拾牙叉形曲柄	Lifting fork	1	
49	29.07.052	拾牙	Feed driving shaft	1	

3. 针杆、勾线分组件/Needle bar & Hook of driving shaft components



序号 Ref.No.	物料号 Part.No.	名称	Description	数量 Qty	备注 Remark
1	29.01.190	上轴伞齿轮部件	Gear	1	
2	29.01.190-1	上轴伞齿轮	Gear	1	
3	29.01.190-2	螺钉	Screw	8	
4	29.01.189-1	变速箱伞齿轮部件	Gear	1	
5	29.01.189	变速箱伞齿轮	Gear	1	
6	01.10.039	螺钉	Screw	2	
7	29.07.020	挡圈	Thrust collar	1	
8	29.01.034	变速箱下轴套	Bearing support	1	
9	29.01.191	变速箱下轴套	Gear	1	
10	29.01.191-1	变速箱下轴套	Gear	1	
11	02.03.002	变速箱	Upright shaft	1	
12	29.01.038	变速箱上轴套	Bearing support	1	
13	02.04.014	滑块槽	Slide rail	1	
14	02.09.034	螺钉	Screw	2	
15	02.04.004	针杆连接柱滑块	Slider	1	
16	01.10.006	螺钉	Screw	1	
17	01.04.029	DBx1.14#机针	Needle DBx1.14#	1	
18	29.01.200	DPx5.18#机针	Needle DPx5.18#	1	H
19	02.04.011	针杆线钩	Needle bar thread guide	1	
20	02.01.011	针杆下轴套	Bearing support	1	
21	02.01.020	针杆下轴套	Bearing support	1	H
22	02.04.017-2	螺钉	Screw	1	
23	02.04.017	针杆连接柱	Needle bar holder	1	
24	02.04.008	针杆	Needle bar	1	
25	02.04.008H	针杆	Needle bar	1	H
26	02.09.037	螺钉	Screw	1	
27	23.309	垫圈	Washer	2	
28	02.05.020	面部防油板	Oil stopper	1	
29	02.04.012	针杆上轴套	Bearing support	1	
30	0000	毛毡	Wool felt	1	