使用说明书

高速平缝机

HIGH-SPEED LOCKSTITCH SEWING MACHINE SERIES

OPERATION MANUAL

目　录

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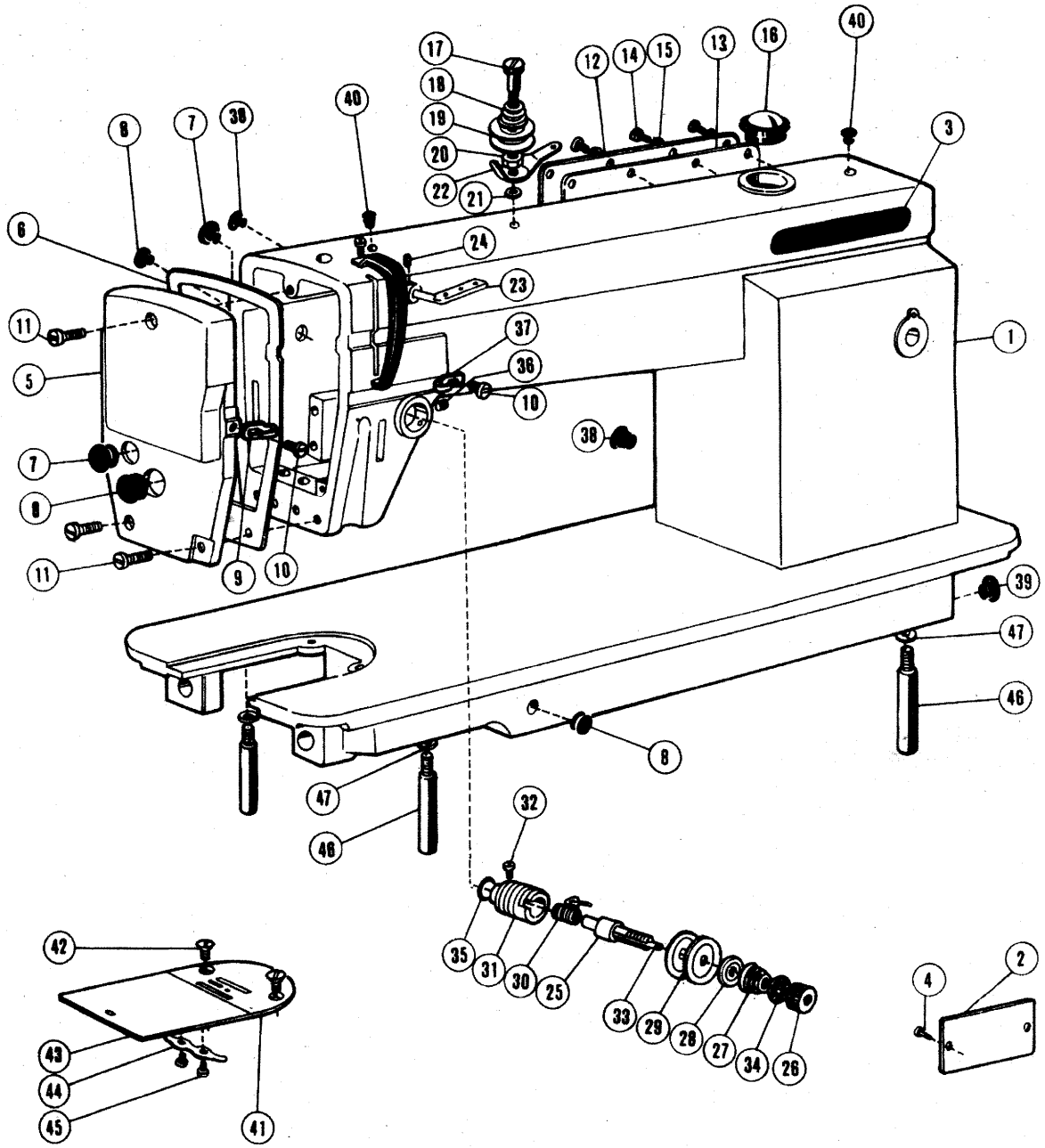
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1、机壳部件　ARM BED COMPONENTS

序号	图　号	名　　称		件数	备　注
1	1-1	车壳	Arm bed	1	M10 x 60
2	1-1A	底板	Bed plate	1	M12 x 30
3	1-1B	机壳螺钉（长）	Arm bed screw (long)	2	销6 x 28
4	1-1C	机壳螺钉（短）	Arm bed screw (short)	2	
5	1-1D	机壳锥销	Arm bed pin	2	
6	1-2	型号牌	Model plate	1	2.5 x 5
7	1-3	商标牌	Trade mark plate	1	
8	1-4	铭牌铆钉	Mark rivet	4	
9	1-5	面板	Face plate arm	1	
10	1-6	面板垫片	Gasket	1	
11	1-7	面板橡皮塞(Ø9)	Rubber plug	1	
12	1-7A	回油观察孔橡皮塞(Ø9)	Rubber plug	1	
13	1-8	面板橡皮塞(Ø11.8)	Rubber plug	1	
14	1-8A	抬牙轴紧圈螺钉孔橡皮塞(Ø11.8)	Rubber plug	1	
15	1-8B	膝控提升杆杠(左)螺钉孔橡皮塞(Ø11.8)	Rubber plug	1	
16	1-9	面板线勾	Face plate thread guide	1	
17	1-10	面板线勾螺钉	Screw	1	
18	1-10A	线勾螺钉	Thread eyelet screw	1	
19	1-11	面板螺钉	Face plate screw	3	
20	1-12	后盖板	Behind cover	1	
21	1-13	后盖板垫片	Behind cover washerplate	1	
22	1-14	后盖板螺钉	Screw	8	
23	1-15	后盖板螺钉垫圈	Screw gasket	8	
24	1-16	油窗组件	Oil sight window components	1	
25	1-17	小夹线螺钉	Small tension screw	1	
26	1-18	小夹线弹簧	Small tension screw	1	GB896-76
27	1-19	小夹线板	Small tension disc	2	挡圈3
28	1-20	小夹线过线板垫块	Gasket	1	
29	1-21	开口挡圈	Snap ring	1	
30	1-22	小夹线过线板	Small tension thread guide plate	1	
31	1-23	三眼线勾	Three-hole thread eyelet	1	
32	1-24	三眼线勾螺钉	Screw	1	
33	1-25	夹线螺钉	Screw	1	
34	1-26	夹线螺母	Tension nut	1	
35	1-27	夹线弹簧	Tension spring	1	
36	1-28	松线板	Tension disc holder	1	
37	1-29	夹线板	Tension disc	2	
38	1-30	挑线簧	Take-up spring	1	
39	1-31	夹线调节座	Tension post socket	1	
40	1-32	夹线调节螺钉	Screw	1	
41	1-33	松线钉	Thread release pin	1	
42	1-34	夹线螺母止动板	Tension screw stopper	1	
43	1-35	O型圈	Rubber ring	1	
44	1-36	夹线调节座固定螺钉	Set screw	1	
45	1-37	线勾	Thread eyelet	1	
46	1-38	橡皮塞(Ø8.8)	Rubber	2	
47	1-39	橡皮塞(Ø77)	Rubber	1	
48	1-40	红色橡胶塞(Ø5.7)	Red rubber	2	
49	1-41	针板(B1.6)	Throat plate	1	
50	1-42	针板螺钉	Screw	2	
51	1-43	推板	Bed slide asm	1	
52	1-44	推板簧	Bed slide spring	1	
53	1-45	推板簧螺钉	Screw	2	
54	1-46	底板撑杆	Bed plate stud	3	
55	1-47	弹簧垫圈	Spring ring	3	挡圈6

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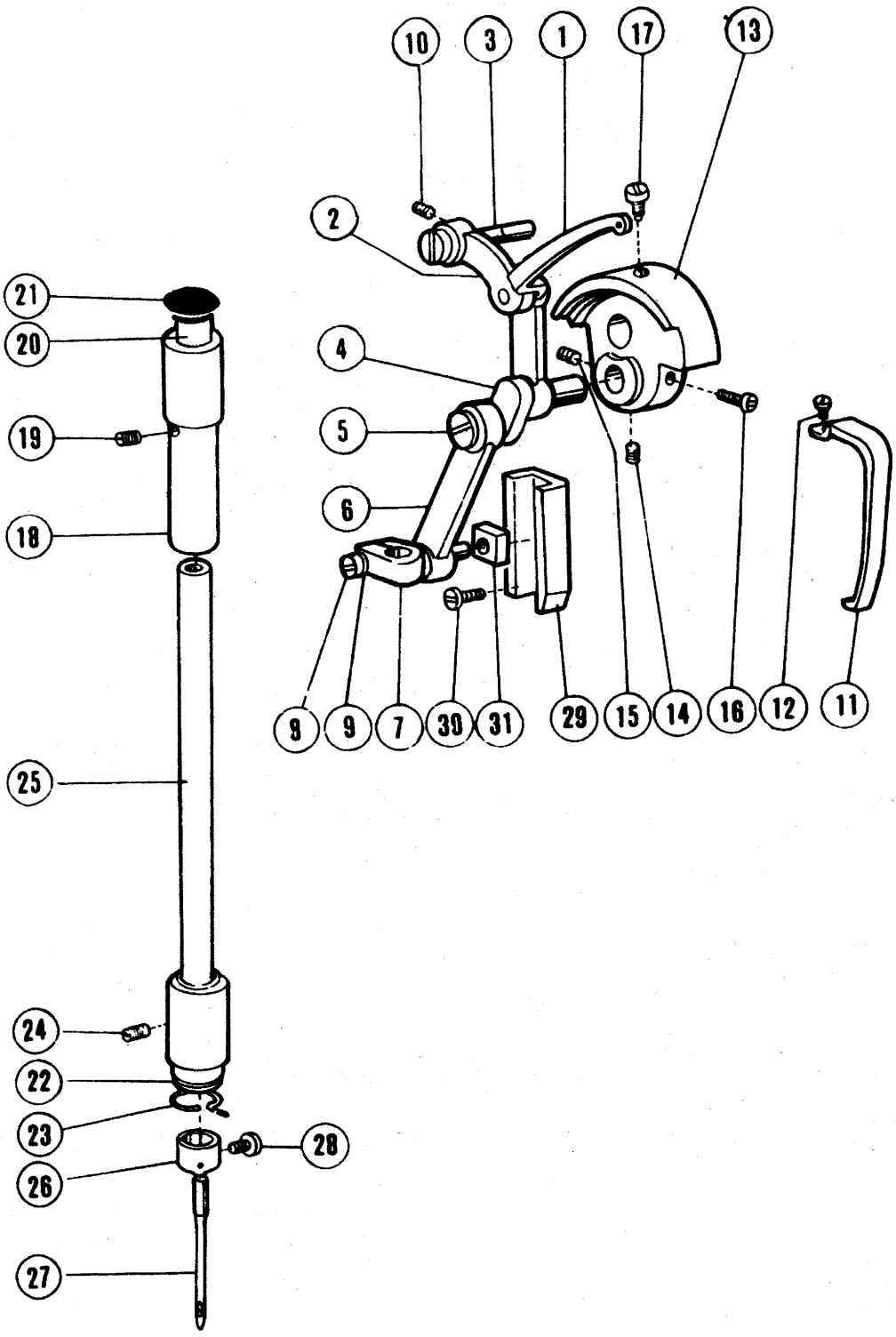
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2、针杆挑线部件　　THREAD TAKE-UP COMPONENTS

序号	图　号	名　　称		件数	备　注
1	2-1	挑线杆	thread take-up lever	1	
2	2-1A	挑线杆孔套	thread take-up hole-bushing	1	
3	2-1B	挑线杆轴套(小)	thread take-up bushing (small)	1	
4	2-1C	挑线杆轴套(大)	thread take-up bushing (big)	1	
5	2-1D	针杆连杆轴套(大)	needle bar bushing (large)	1	
6	2-2	挑线连杆	thread take-up lever link	1	
7	2-3	挑线连杆铰链轴	hinge shaft of jointed lever for cross stitching	1	
8	2-4	挑线曲柄	thread take-up asm	1	
9	2-4A	滚针轴承	needle shaft bushing	2	
10	2-5	挑线曲柄螺钉(左旋)	screw(left twist)	1	
11	26	针杆连杆	needle bar crank rod	1	
12	2-6A	针杆连杆轴套	needle bar crank rod bushing	1	
13	2-7	针杆接头	needle bar connecting rod	1	
14	2-8	针杆接头螺钉	screw	1	
15	2-9	针杆接头螺钉垫圈	screw gasket	1	
16	2-10	挑线连杆铰链轴螺钉	screw	1	
17	2-11	挑线杆防护罩	thread take-up lever cover	1	
18	2-12	挑线杆防护罩螺钉	screw	1	
19	2-13	针杆曲柄	counterweight	1	
20	2-14	挑线曲柄螺钉	screw	1	
21	2-15	挑线曲柄定位螺钉	screw	1	
22	2-16	针杆曲柄螺钉	screw	1	
23	2-17	针杆曲柄定位螺钉	screw	1	
24	2-18	针杆轴套(上)	needle bar bushing, upper	1	
25	2-19	针杆轴套(上)螺钉	screw	1	
26	2-20	针杆轴套(上)毡塞	felt plug of pin holder sleeve (up)	1	
27	2-21	针杆轴套(上)橡皮塞(Ø8.8)	robber plug of pin holder sleeve (up)	1	
28	2-22	针杆轴套(下)	needle bar bushing, lower	1	
29	2-23	针杆轴套(下)过线勾	needle bar thread guide	1	
30	2-24	针杆轴套(下)螺钉	needle bar bushing screw	1	
31	2-25	针杆组件	needle bar components	1	
32	2-26	针杆过线环	overpassing ring of pin holder	1	
33	2-27	机针	needle	1	
34	2-28	夹针螺钉	screw	1	
35	2-29	针杆接头滑块导轨	joint slideway of pin holder	1	
36	2-30	滑块导轨螺钉	screw of slideway	2	
37	2-31	针杆接头滑块	slide block	1	

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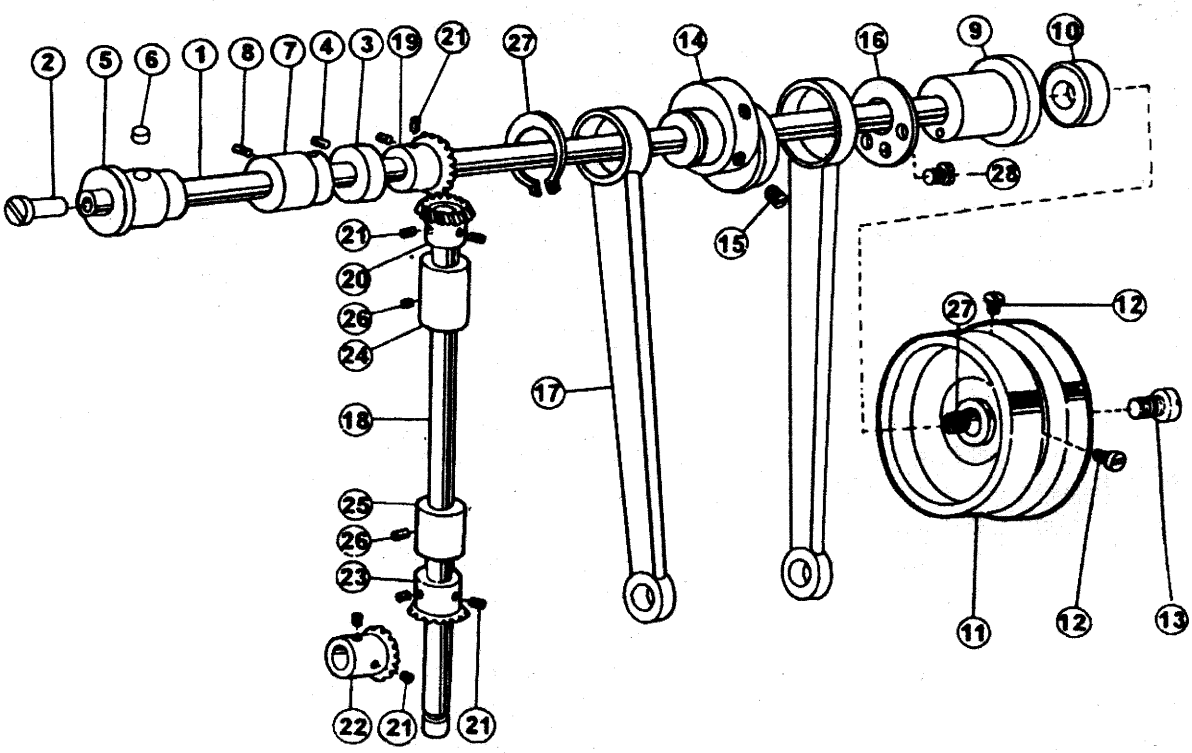
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3、上轴竖轴部件 MAIN SHAFT & UPRIGHT SHAFT COMPONENTS

序号	图 号	名 称		件数	备 注
1	124T3-001A1	上轴	arm shaft	1	
2	124T3-001A2	上轴调油钉	oil adjustment screw	1	
3	22T3-002B1	上轴紧圈	collar for arm shaft	1	
4	22T3-002B2	上轴紧圈螺钉	set screw	2	
5	124T3-002B1	上轴左轴套	arm shaft bushing (left)	1	
6	124T-002B2	油毡	felt	1	
7	22T-004	上轴轴套（中）	arm shaft bushing (middle)	1	
8	22T-002	上轴轴套（中）螺钉	set screw	1	
9	124T3-003C1	上轴右轴套	arm shaft (right)	1	
10	124T3-003C2	上轴右轴套油封	oil seal	1	
11	36T3-002C1	主动轮	balance wheel	1	
12	36T3-002C2	主动轮螺钉	set screw	2	
13	22T3-008	上轴油封螺钉	screw	1	
14	36T3-003	凸轮	lifing eccentric	1	
	114T3-001	凸轮	lifing eccentric	1	
15	22T1-013	凸轮螺钉	set screw	1	
	22T5-001A4	凸轮螺钉	set screw	1	
16	36T3-004	凸轮挡板	eccentric stopper	1	
17	22T3-009D1	抬牙连杆	crank rod for feed lifting rock shaft	1	
18	22T3-010E1	竖轴	vertical shaft	1	
19	22T3-010E2a1-2	上轴伞齿轮	bevel gear for arm shaft	8	
20	22T3-010E2a2-2	竖轴上伞齿轮	bevel gear for vertical shaft (upper)	1	
21	22T2-005B3	伞齿轮螺钉	set screw	1	
22	22T3-010E2b1-2	下轴伞齿轮	bevel gear for hook shaft	1	
23	22T3-010E2b2-2	竖轴下伞齿轮	bevel gear for vertical shaft (lower)	1	
24	22T3-011	竖轴轴套（上）	vertical shaft bushing (upper)	1	
25	22T3-011	竖轴轴套（下）	vertical shaft bushing (lower)	1	
	78T3-001	竖轴轴套（下）	vertical shaft bushing (lower)	1	
26	22T2-002	竖轴轴套螺钉	set screw	2	
27	22T3-009D1b	抬牙连杆挡圈	crank rob for stopper	1	
28	100T6-012	送布凸轮挡板螺钉	set screw	3	

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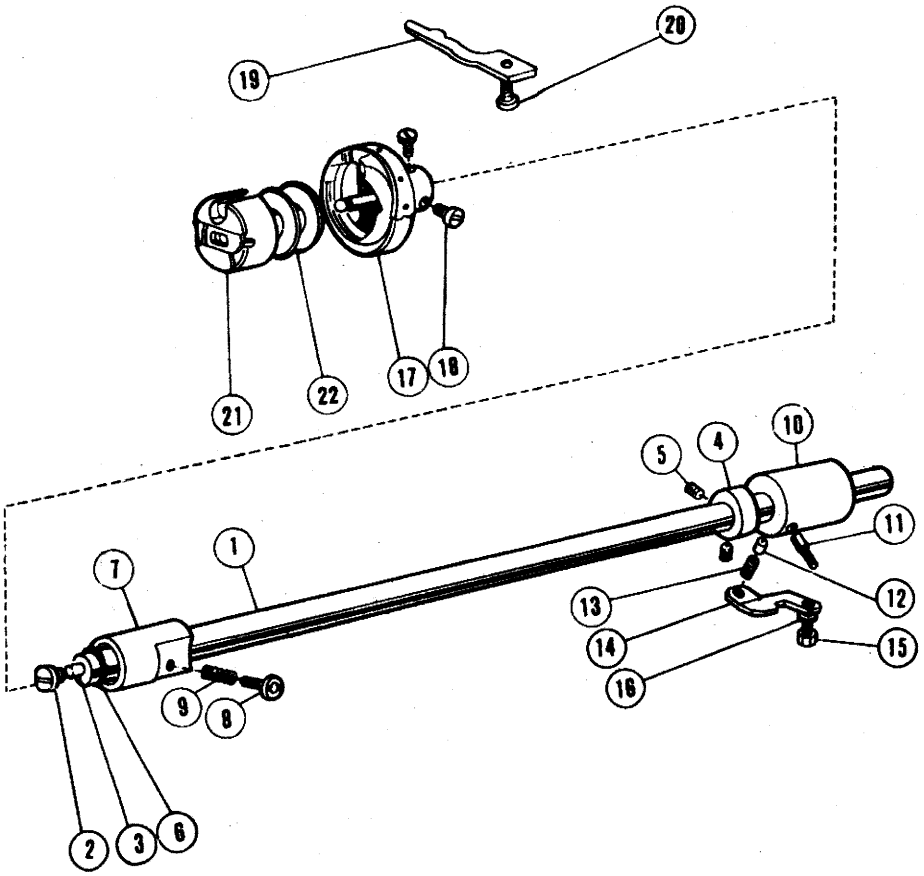

4、钩线部件　HOOK DRIVING SHAFT COMPONENTS

序号	图　号	名　　称		件数	备　注
1	4-1	下轴	hook driving shaft	1	
2	4-2	下轴滤油塞螺钉	oil seal screw	1	
3	4-3	下轴滤油塞	oil seal	1	
4	4-4	下轴紧圈	thrust collar asm	1	
5	4-5	下轴紧圈螺钉	screw	2	
6	4-6	下轴油封	thrust coller asm	1	
7	4-7	下轴轴套（左）	hook driving shaft (left)	1	
8	4-8	油量调节螺钉	oil adjusting screw	1	
9	4-9	油量调节弹簧	oil adjusting spring	1	
10	4-10	下轴轴套（右）	hook driving shaft (right)	1	
11	4-11	下轴轴套油管	oil pipe	1	
12	4-12	柱塞	plunger	1	
13	4-13	柱塞弹簧	plunger spring	1	
14	4-14	挡板	guard plate	1	
15	4-15	挡板螺钉	screw	1	
16	4-16	挡板螺钉弹簧垫圈	spring gasket	1	垫圈6
17	4-17	旋梭组件	hook component	1	
18	4-18	旋梭螺钉	hook screw	2	
19	4-19	旋梭定位勾	hook set guide	1	
20	4-20	旋梭定位勾螺钉	screw	1	
21	4-21	梭心套组件	bobbin bushing compinents	1	
22	4-22	梭心	boobbin	1	

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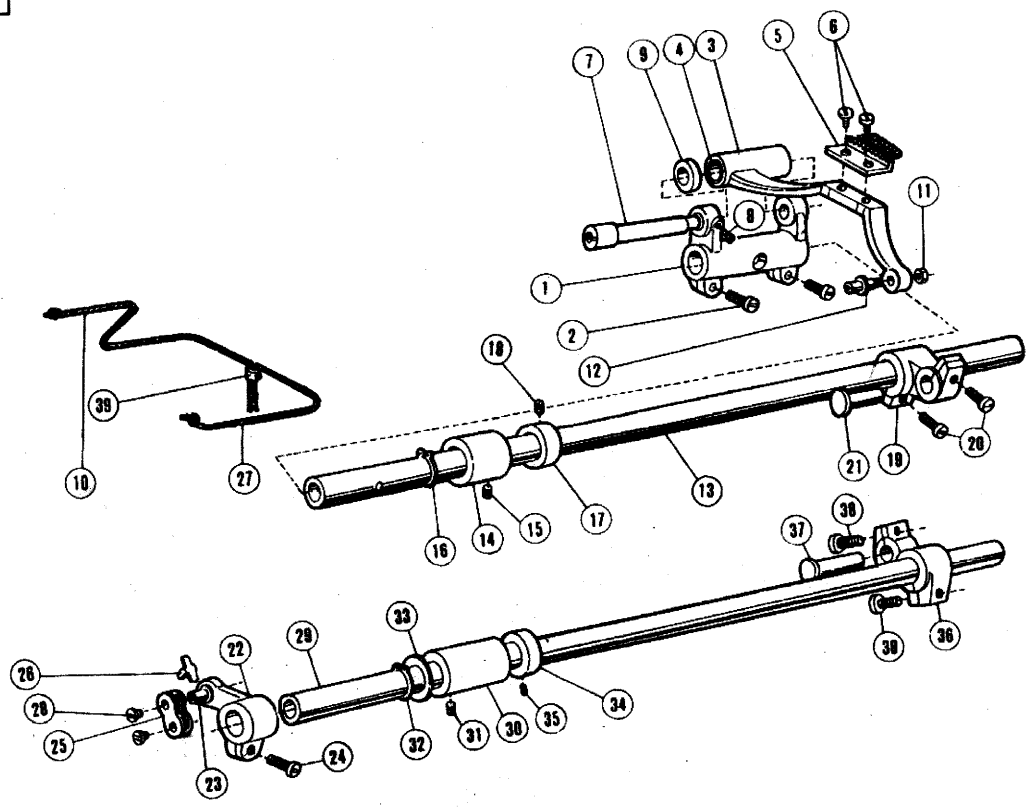

5、送布部件 FEED MECHANISM COMPONENTS

序号	图 号	名 称		件数	备 注
1	5-1	牙架曲柄	feed driving rocker	1	
2	5-2	牙架曲柄螺钉	screw	2	
3	5-3	牙架	feed bar	1	
4	5-4	牙架轴套	feed bar bushing	1	
5	5-5	送布牙	feed dog	1	
6	5-6	送布牙螺钉	feed dog screw	2	
7	5-7	牙架曲柄轴	feed dog asm shaft	1	
8	5-8	牙架曲柄轴螺钉	screw	1	
9	5-9	牙架垫圈	fees dog gasket	1	
10	5-10	牙架曲柄油线	oil line of indentation rack crank	1	Ø.5 × 300
11	5-11	牙架连杆铰链轴螺母	nut	1	
12	5-12	牙架连杆铰链轴	gemel shaft	1	
13	5-13	送布轴	feed rocker shaft	1	
14	5-14	送布轴轴套	feed rocker shaft bushing	1	
15	5-15	送布轴轴套螺钉	screw	1	
16	5--16	轴用弹性挡圈	retaining ring	1	挡圈15
17	5-17	送布轴紧圈	thrust collar asm	1	
18	5-18	送布轴紧圈螺钉	screw	2	
19	5-19	送布轴曲柄	feed rocker shaft crank asm	1	
20	5-20	送布轴曲柄螺钉	screw	2	
21	5-21	送布轴曲柄铰链轴	hing pin	1	
22	5-22	抬牙轴曲柄（左）	feed driving shaft asm	1	
23	5-23	抬牙轴曲柄铰链轴	gemel shaft	1	
24	5-24	抬牙轴曲柄（左)螺钉	screw	1	
25	5-25	牙架连杆	feed bar connecting rod	1	
26	5-26	牙架连杆油线夫	oil line nip offeed bar connecting rod	1	
27	5-27	牙架连杆油线	oil wick	1	Ø2.5 × 300
28	5-28	牙架连杆螺钉	screw	2	
29	5-29	抬牙轴	feed driving shaft	1	
30	5-30	抬牙轴轴套	feed driving shaft bushing	1	
31	5-31	抬牙轴轴套螺钉	screw	1	
32	5-32	轴用弹性挡圈	spring ring	1	挡圈15
33	5-33	抬牙轴轴套垫圈	thrust collar asm	1	
34	5-34	抬牙轴紧圈	thrust collar asm	1	
35	5-35	抬牙轴紧圈螺钉	screw	2	
36	5-36	抬牙轴曲柄（右）	feed driving shaft asm	1	
37	5-37	抬牙轴曲柄铰链轴	gemel shaft	1	
38	5-38	抬牙轴曲柄（右)螺钉	asm(left)screw	2	
39	5-39	油线夫	oil thread tension	1	

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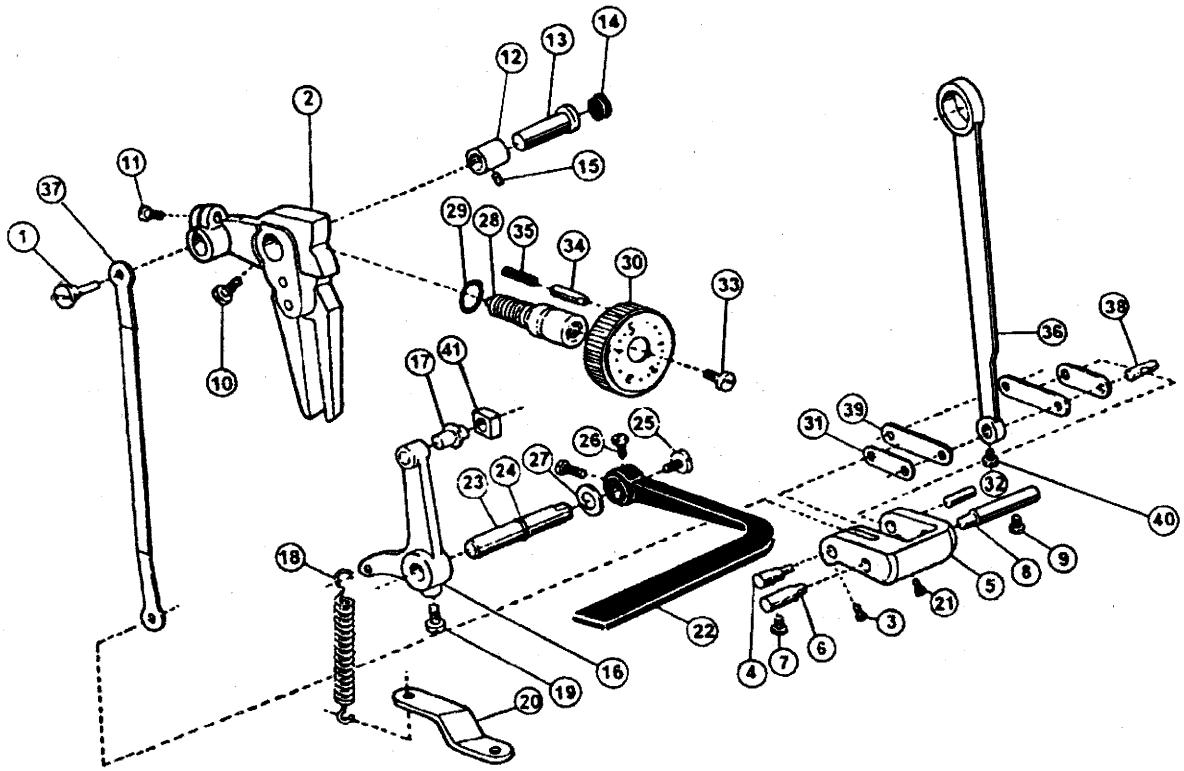
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6、针距调节部件　　STITCH LENGTH REGULATING MECHANISM

序号	图　号	名　　称		件数	备　注
1	36T5-001	针距调节连杆销钉	feed regulator screw	1	
2	57T5-001	针距座	feed regulator	1	
	124T5-002	针距座	feed regulator	1	
3	36T5-008E8	连杆偏心轴螺钉	set screw	1	
4	36T5-008E9	连杆偏心轴	eccentric shaft	2	
5	36T5-008E10	折距调节曲柄	stitch adjusting crank	1	
6	36T5-009H02	针距调节曲柄定位销(左)	stitch adjusting pin(left)	1	
7	22T6-008D3	左定位销螺钉	set screw (left)	1	
8	36T5-009H01	针距调节曲柄定位销（右）	stitch adjusting pin (right)	1	
9	22T6-008D3	右定位销螺钉	set screw (right)	1	
10	22T5-010D4	针距座螺钉	set screw	1	
11	22T2-019	针距座夹紧螺钉	screw	1	
12	22T5-003	针距座轴套	feed regulator bush	2	
13	22T5-004	针距座轴	feed regulator	1	
14	36T5-003	橡皮塞	rubber plug	1	
15	22T2-002	针距座轴套紧固螺钉	set screw	1	
16	22T5-012E1	倒缝操纵杆曲柄	bartaking crank	1	
17	22T5-012E1a1	操纵杆曲柄滑块轴	shaft for bartanking crank	1	
18	57T5-004B1	操纵杆曲柄拉簧	spring	1	
19	22T5-013	操纵杆曲柄螺钉	screw	1	
20	57T5-005	拉簧架	spring stand	1	
21	36T5-008E7	短连杆销螺钉	set screw	8	
22	36T5-006C2	倒缝操纵杆	bartaking lever	1	
23	36T5-006C1a1	倒缝操纵杆短轴	bartaking lever shaft	1	
24	GB1235-76	O型密封圈	O ring	1	
25	22T5-010D3	倒缝操纵杆吊紧螺钉	set screw	1	
26	22T5-010D4	倒缝操纵杆螺钉	set screw	1	
27	22T5-011	倒缝操纵杆垫圈	washer	1	
28	124T5-001A2	针距调节螺杆	feed regulater screw	1	
29	22T5-006C4	O型密封圈	O rubber ring	2	
30	124T5-001A1-1	针距旋钮	dial	1	
	124T5-001A1-2	针距旋钮	dial	1	
31	36T5-008E4H01	曲柄短连杆	waiking foot link	2	
32	36T5-008E6	曲柄短连杆销	pin	3	
33	22T5-006C3	针距旋钮螺钉	screw	4	
34	22T5-008	止动销	stopper pin	5	
35	22T5-009	止动销弹簧	spring	6	
36	36T5-008E2	送布连杆	feeding rod	7	
37	36T5-008E3	针距调节连杆	stitch adjusting rod	8	
38	36T4-004H02	曲柄连杆长销	waiking foot pin	9	
39	36T5-008E4H02	曲柄长连杆	connecting link	10	
	114T5-003	曲柄颉颃连杆	connecting link	11	
40	36T5-008E5	送布连杆螺钉	screw	12	
41	22T5-012E1a2	操纵杆曲柄滑块	guilding block	13	

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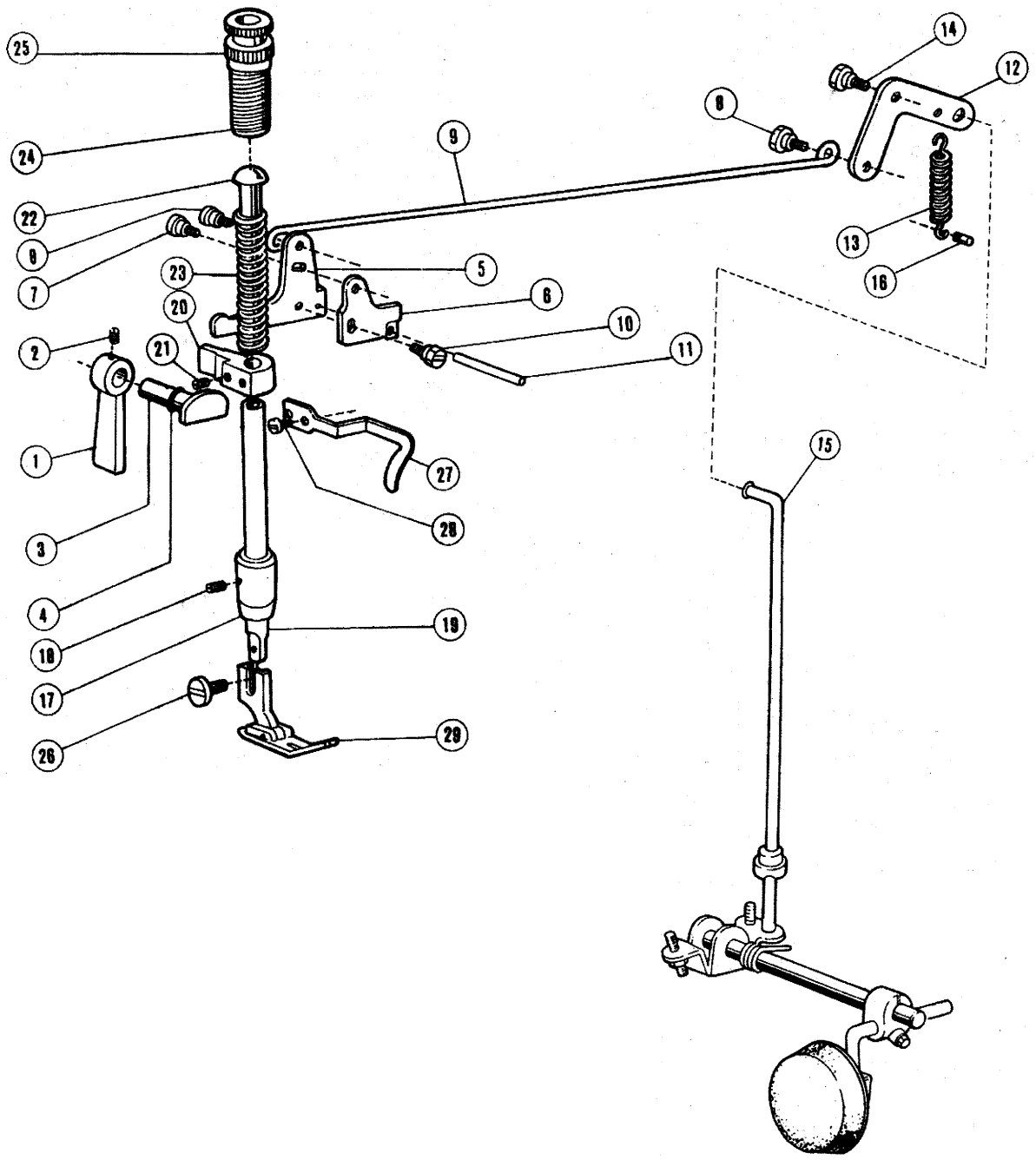
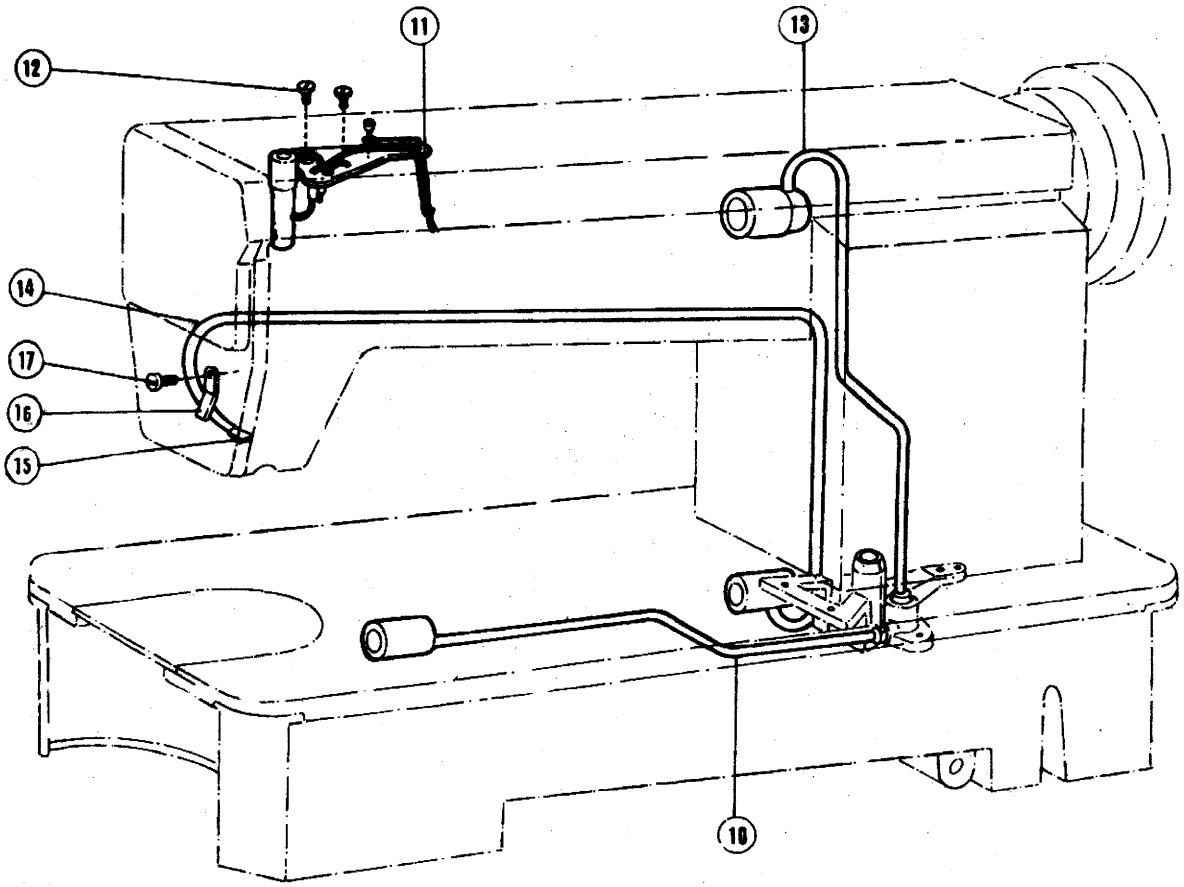
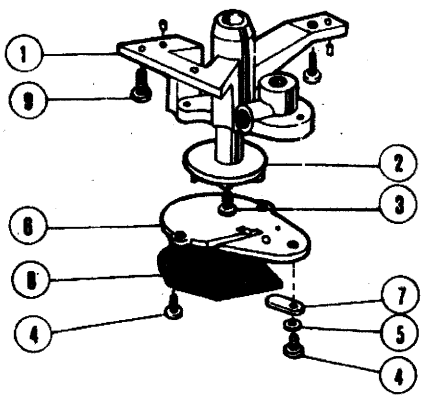


7、压脚部件　LIFTER COMPONENTS

序号	图　号	名　　称		件数	备　注
1	7-1	压脚扳手	hand lifter lever	1	
2	7-2	压脚扳手螺钉	screw	1	
3	7-3	压紧杆提升凸轮	hand lifter cam asm	1	
4	7-4	压紧杆提升凸轮油封	rubber ring	1	8 x 1.9
5	7-5	膝控提升杠杆(左)	hand lifter sam	1	
6	7-6	松线凸轮	tension release plate	1	
7	7-7	膝控提升杠杆(左)螺钉	link shaft screw	1	
8	7-8	铰链螺钉	screw	2	
9	7-9	膝控提升拉杆	lifting lever connecting rod	1	
10	7-10	松线凸轮螺钉	tention release plate screw	1	
11	7-11	松线杆	release rod	1	
12	7-12	膝控提升杠杆(右)	lifting lever link shaft(left)	1	
13	7-13	膝控提升杠杆(右)弹簧	lifting lever link shaft spring (left)	1	
14	7-14	膝控提升杠杆(右)螺钉	screw(left)	1	
15	7-15	膝控提升连杆	lifting lever connecting rod	1	
16	7-16	弹簧销	spring pin	1	
17	7-17	压紧杆轴套	pressing lever shaft bushing	1	
18	7-18	压紧杆轴套螺钉	screw	1	
19	7-19	压紧杆	pressing lever	1	
20	7-20	压紧杆导架	guided bracket for pressing lever	1	
21	7-21	压紧杆导架螺钉	guiding rack`s screw of pressing lever	1	
22	7-22	压紧杆弹簧导柱	guided pole	2	
23	7-23	压紧杆弹簧	spring of pressing lever	1	
24	7-24	调压螺钉	presser spring regulator	1	
25	7-25	调压螺钉锁紧螺母	nut	1	
26	7-26	压脚螺钉	hand lifter screw	1	
27	7-27	大线勾	line hook	1	
28	7-28	大线勾螺钉	line hook screw	1	
29	7-29	压脚组件	presser bar components	1	

8





8、油泵部件　LUBRICATING OIL PUMP ASM

序号	图　号	名　　称		件数	备　注
1	8-1	油泵体	lubricating oil pump	1	
2	8-2	油泵叶轮	oil pump impeller	1	
3	8-3	油泵叶轮螺钉	oil pump impeller screw	1	
4	8-4	油泵调节板螺钉	screw	3	
5	8-5	油泵调节板螺钉弹簧垫圈	spring gasket	1	
6	8-6	油泵体盖板	oil pump cover	1	
7	8-7	油量调节板	oil adjusting plate	1	
8	8-8	螺泵滤网组件	filter components	1	
9	8-9	油泵体螺钉	screw	3	
10	8-10	下轴油管组件	lower-shaft oil tube components	1	
11	8-11	油线固定板大组件	large components of locating board for oil line	1	
12	8-12	油线固定板螺钉	screw of locating board of oil line	2	
13	8-13	上轴油管组件	upper shaft oil tube components	1	
14	8-14	回油管	oil return tube asm	1	
15	8-15	回油管滤油毡	tapis of oil return tube	1	
16	8-16	回油管夹	oil return tube holder	1	
17	8-17	回油管夹螺钉	screw	1	

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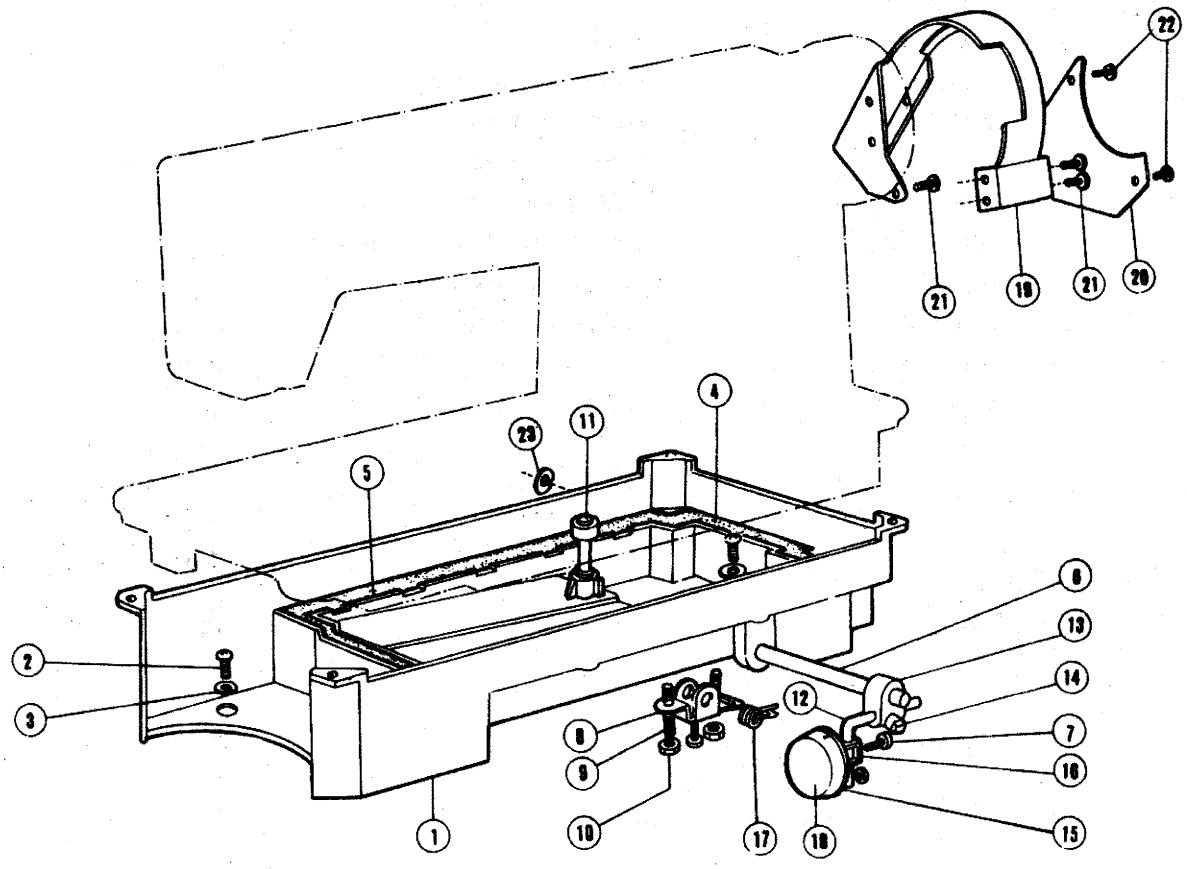

9、油盘部件　OIL RESERVOIR COMPONENTS

序号	图　号	名　　称		件数	备　注
1	9-1	油盘	oil reservoir asm	1	
2	9-2	放油螺钉	oil drain screw	2	
3	9-3	放油螺钉垫圈	oil drain cap gasket	2	
4	9-4	油盘垫（大）	Gasket(L)	1	
5	9-5	油盘垫（小）	Gasket(S)	1	
6	9-6	膝控铰链轴	Knee press rod	1	
7	9-7	膝控复位弹簧	spring	1	
8	9-8	膝控限位架	knee-controlled throttling frame	1	
9	9-9	膝控限位调节螺钉	screw	2	
10	9-10	调节螺母	nut	2	
11	9-11	膝控提升顶杆	knee-controlled lifting standing lever	1	
12	9-12	膝控碰块弯杆	knee lifter plate rod	1	
13	9-13	碰块弯杆接头	bearing bracket	1	
14	9-14	碰块弯杆接头螺钉	screw	2	
15	9-15	膝控碰块	knee press plate	1	
16	9-16	碰块架	knee press plate frame	1	
17	9-17	碰块架螺钉	spring	1	
18	9-18	碰块垫	knee press plate cover	1	
19	9-19	皮带罩架	belt cover frame	1	
20	9-20	皮带罩板	belt cover board	1	
21	9-21	皮带罩板螺钉（小）	screw(S)	3	
22	9-22	皮带罩板螺钉（大）	screw(L)	3	
23	9-23	开口挡圈	thrust ring	1	GB896-76挡圈9

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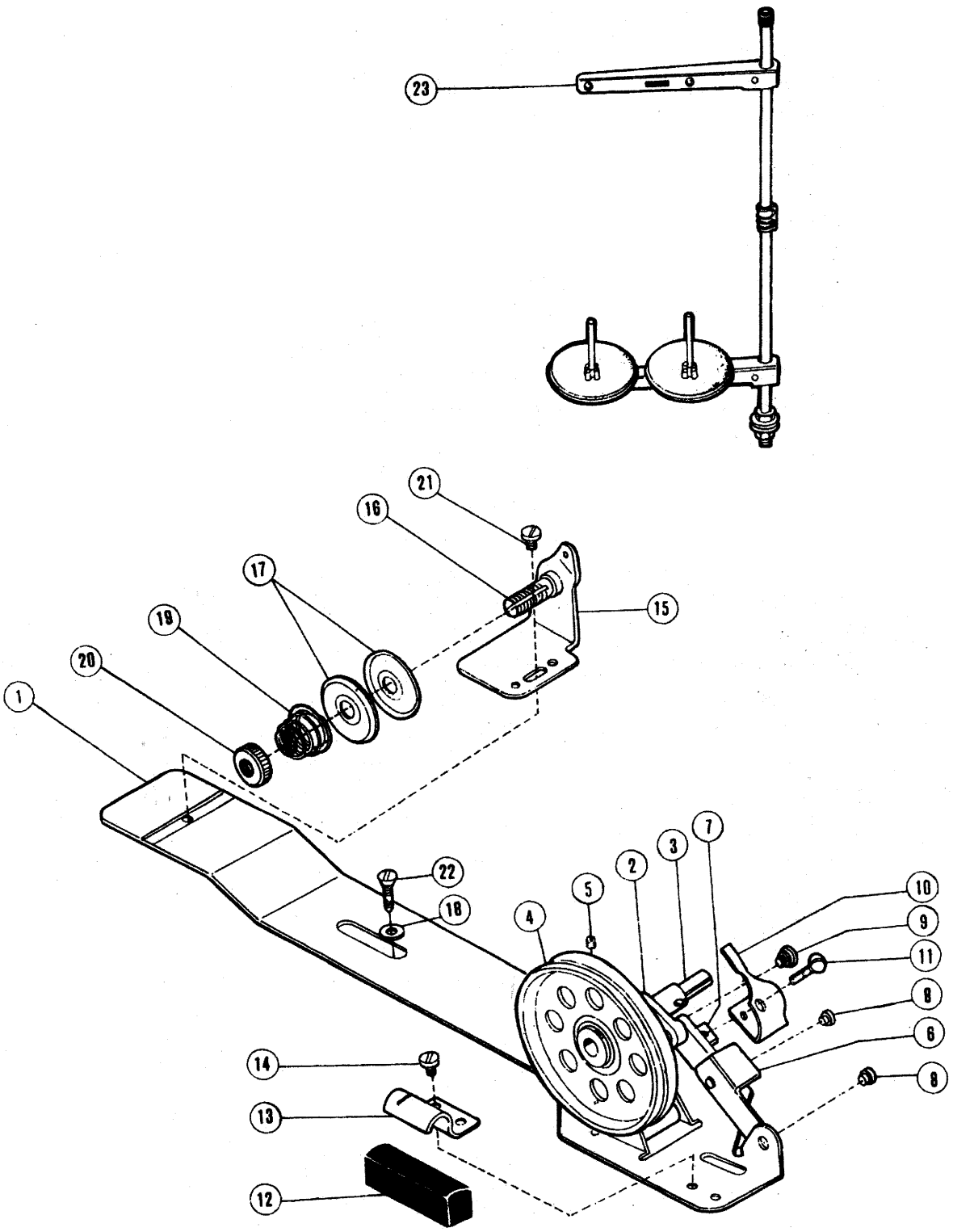

10、绕线部件　BOBBIN WINDER COMPONENTS

序号	图　号	名　　称		件数	备　注
1	10-1	绕线器底架	bobbin winder base asm	1	
2	10-2	绕线架组件	bobbin winder components	1	
3	10-3	绕线架轴	bobbin winder shaft	1	
4	10-4	绕线架顶杆	bobbin winder frame rod	1	
5	10-5	绕线架顶杆、弹簧	bobbin winder frame rod, spring	1	
6	10-6	绕线轴	bobbin winder shaft	1	
7	10-7	绕线轮	bobbin winder asm	1	
8	10-8	绕线轮螺钉	screw	1	
9	10-9	绕线摆杆	bobbin winder swinging lever	1	
10	10-10	绕线连杆	bobbin winder frame rod	1	
11	10-11	铆钉	rivet	2	
12	10-12	绕线连杆螺钉	bobbin winder frame rod screw	1	
13	10-13	压板	presser plate	1	
14	10-14	满线度调节螺钉	hinge screw	1	
15	10-15	制动块	rubber brake stopper	1	
16	10-16	制动块固定勾	rubber brake locating hook	1	
17	10-17	制动块固定勾螺钉	screw	1	
18	10-18	过线架	thread tension bracket	1	
19	10-19	过线架夹线螺钉	hinge screw	1	
20	10-20	过线架夹线板	tention disc	1	
21	10-21	绕线架木螺钉垫圈	wood screw washer	2	
22	10-22	夹线簧	tention spring	1	
23	10-23	夹线螺母	tention stud-nut	1	
24	10-24	过线架螺钉	screw	1	
25	10-25	绕线架木螺钉	wood screw	2	
26	10-26	线架组件	thread frame components	1	螺钉5 x 20

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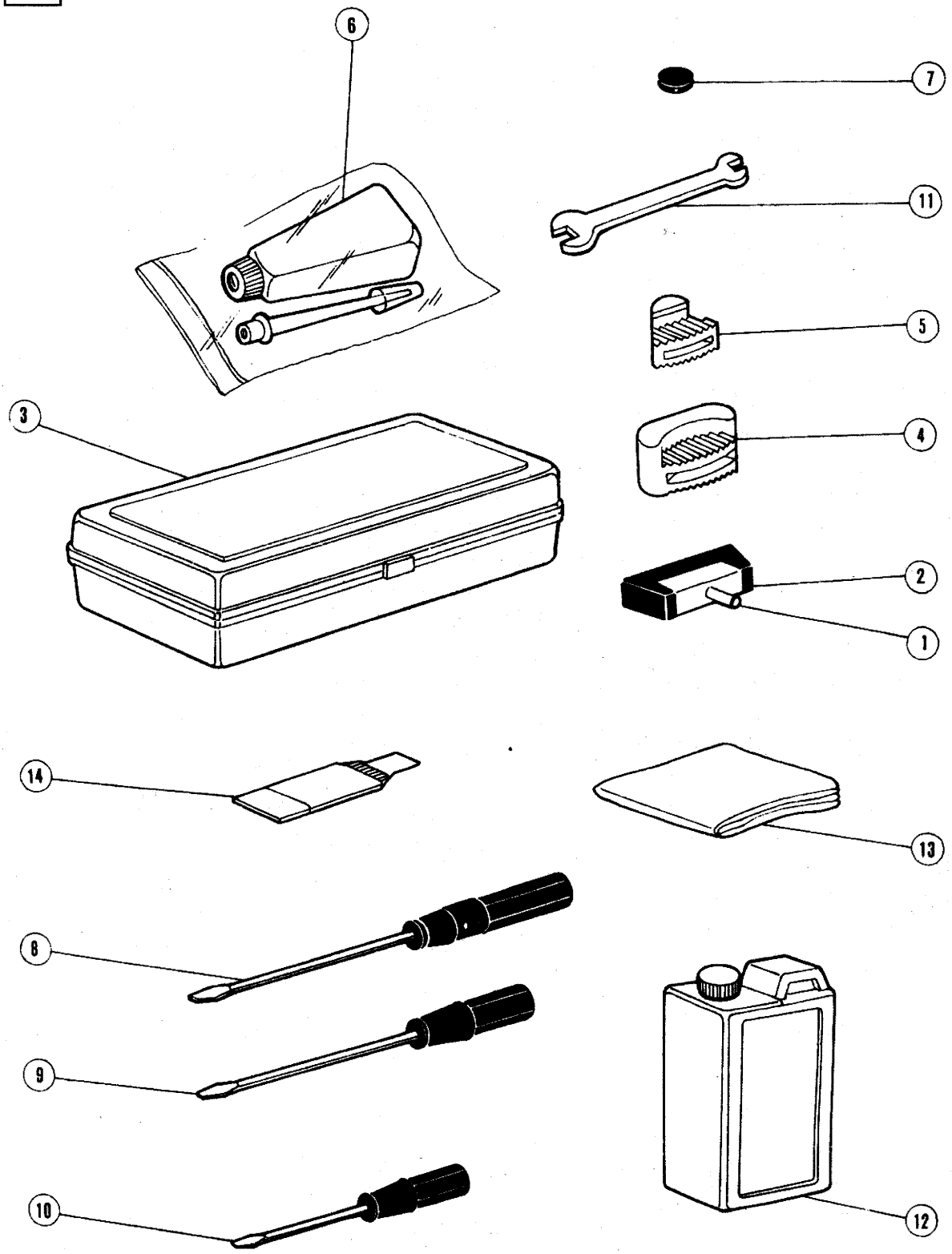


1. 主要技术规格　1. MAIN SPECIFICATIONS

适　　用	薄料-中厚料
缝　　速	5000spm
针　　距	0-5mm
针杆行程	31.8mm
压脚提升	手动 5.5mm
	膝控 13mm
机　　针	DB × 1-2 $9^{\#}$-$14^{\#}$
供油方式	全自动供油
倒缝装置	有

1) Max. sewing speed: 5000 spm/5500 spm
2) Stitch length: 0-5mm reverse feeding available
3) Presser foot lift: 5.5mm(13mm by knee)
4) Needle bar stroke: 31.8mm
5) Take-up lever stroke: 58mm
6) Needle:N0.9-No. 14(DB x 116 x 231)
7) Head weight: 29.5kg
8) Head size: 520 x 178 x 335mm
9) Motor power: 0.4kw (clutch motor)

2. 操作准备　2. OPERATIONAL READINESS

(1) 拭擦机器

机头装箱前为了防止机件生锈，各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长途运输阶段造成油脂硬化和积聚在机器表面的灰尘，所以必须将表面的油脂和灰尘用汽油和洁净的软布拭擦干净。

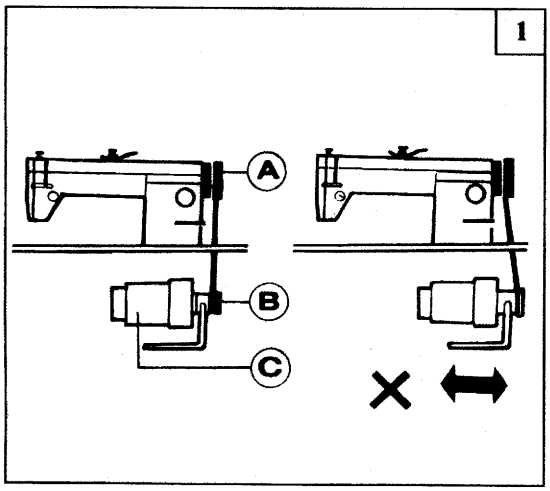
(2) 检查

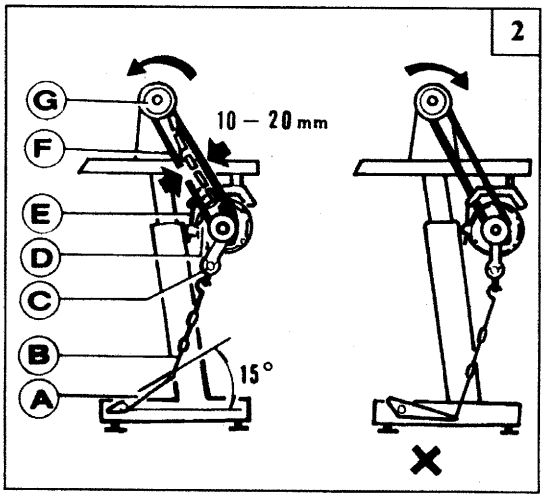
机器出厂时，虽经过周密的检查和试验，但在长途运输中也可能受到强烈的振动使机件松动或歪曲，所以应该作一次周密的检查，并用手转动主动轮，看机件之间有无转动困难，碰撞现象或其它不均的阻力，不正常的声响，如有应作适当的调整，机器情况正常后才可正式试车。

3. 安装电机(图1)　3. LNSTALL THE MOTOR (Fg. 1)

将电动机C左右移动，使缝纫机主动轮槽A与电动机皮带轮槽B的位置调整成一直线即可。

Align Motor Pulley Groove (B) and Balancc Wheel Groove (A) by moving the motor leftward or rightward.





4. 踏脚板与离合器拉杆连接(图2) 4. CONNECT THE CLUTCH LEVER WTTH THE PEDAL (Fig. 2)

1 踏脚板安装的倾斜度应与地面以15为宜。

2 调整电动机离合器，使缝纫机拉杆B与离合器拉杆C如图连成一直线，可使机器运转平稳，寿命延长。

3 缝纫机转动方向，从机头主动轮外侧看，应是逆时针方向。电动机的转向应一致，电动机转向可用电动机上电源插头换转180调整转向。

4 O型皮带F的张力调整，由电动机移动上下位置来达到F皮带张力的大小可用指将皮带按下，使皮带如图示弯曲10-20毫米程度即可。

1) The optimum tilt angle of Pedal (A) is approximately 15 deg.

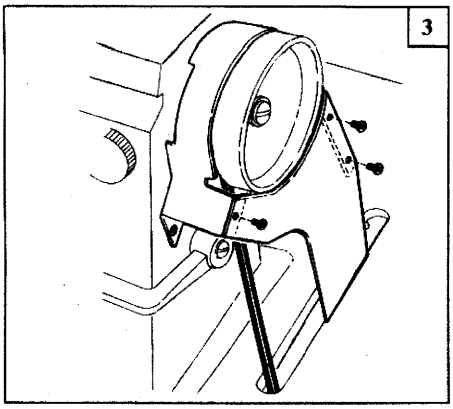
2) Adjust Clutch Cover (D) so that Clutch Lever (C) and Draw Bar (B) run in line as shown in Fig.6

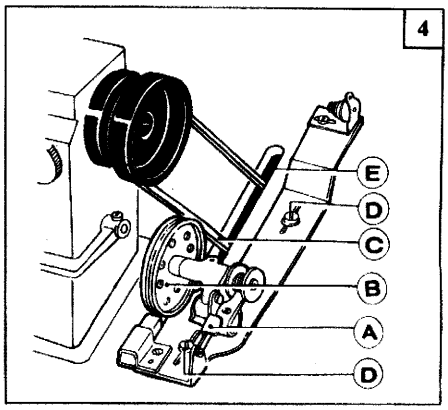
3) The balanee wheel should rotate counter-clockwise when viewed from the outside of Balance Wheel (G) The direction of the motor pulley rotation can be reversed by reversing (turning over 180 deg.) the power plug of the motor.

4) Adjust the tension of V-belt (F) by turning Motor Vertical Position Screw (E) The proper tension of the V-belt is slack of 10-20 mm when the belt is depressed at the center of the bclt by finger (See Fig.6)

5. 安装皮带罩 (图3)　5. INSTALL BELT COVER

(对缝纫机而言)
从安全考虑，应安装皮带罩。
(对电机而言)
从安全角度考虑，应使用皮带罩。





6. 安装绕线器 (图4)　6. INSTALL BOBBIN WINDER (Fig. 4)

安装绕线器时，先将绕线轮B对准皮带C的外边，绕线轮和皮带之间应有一定的空隙，并保证掀下绕线摆杆A时，绕线轮和皮带保持相互接触，机器转动时，皮带将使绕线轮一起转动。注意绕线器左右位置，应与台板皮带孔E平行，最后拧紧木螺钉D。

1) Keep Lever (A) Pushed ahead.

2) Adjust the bobbin winder in its longitudinal direction so that Bobbin Winder Pulley (B) is kept in contact with V-bele(C).

3) As for the alignment of the pulley and the V-belt. the winder should be in parallel with the slot in the table.

4) Secure the bobbin winder in position by using two Wood Screws (D).

7. 润滑 (图5)　7. PREPARATION AND LUBRICATION (Fig. 5)

1 油量

油量必须按油盘内标记加注。图中标记A是油量最高位，B是油量最低位。注意油量不得低于标记B，否则缝纫机各部位就会出现进油停止，造成发热咬死等情况。

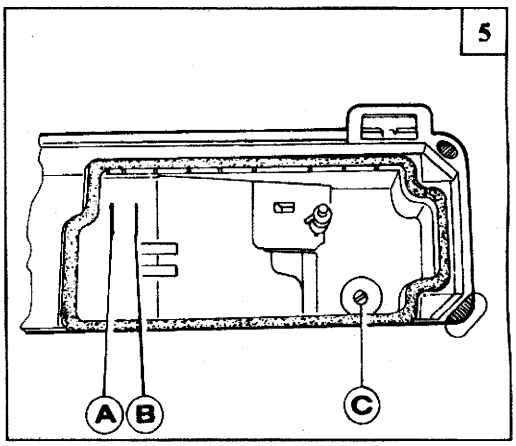
2 加油

必须使用特18#高速缝纫机油，运转前油量加至标记A。

3 换油

①旋下放油螺钉C，排净废油。

②扫清油盘污尘，旋紧放油螺钉C，加注新油。



1) Cleaning the machine

Before leaving the factory. the machine parts are coated with rust-preventive grease. which may be hardened and contaminatcd by dust during storage and shipment. This grease must be removed with gasoline.

2) Evaminatien

Though every machine is confirmed by strict inspection and test before leaving the factory. the machine parts may be loose or deformed after long distance transportation with jolt. A thorough examination must be performed after cleaning the machine. Turn the balanee wheel to see if there is running obstruction. parts collision. uneven resistanee or abnormal noise. If hese exist. adjustmentmust be made accordingly before run-in operation.

3) Oiling

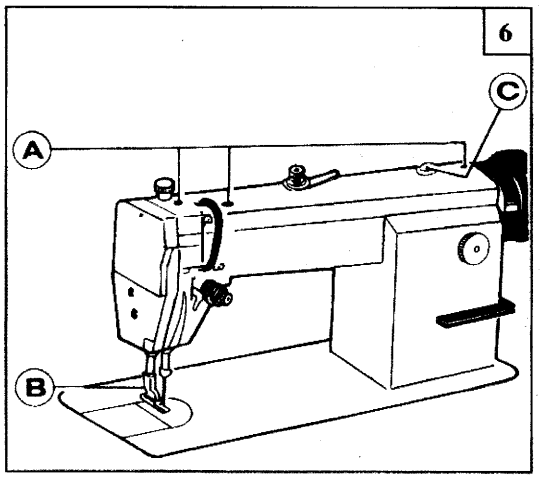
(1) Required amount of oil. Line (A) on the oil reservoir: Max. oil level. Line (B) on the oil reservoir: Min. oil level. If oil level goes down under Line (B) oil cannot be distributed to each part of the machine. thus causing the parts a seizure.

(2) Replenishing Always use No.18 special machine oil for high speed sewing. Be sure to replenish oil to Line (A) before starting operation.

(3) Replacing oil To replaee oil remove Screw (C) to drain oil After completely draining off oil. clean the oil reservoir and securely tighten Screw (C), then fill the reservoir with fresh oil.

8. 试车 (图6)　8. RUN-IN OPERATION (Fig. 6)

新机器在开始使用和长期搁置重新使用时，先卸下机头上部的红色橡皮塞，充分加油。然后抬起压脚进行低速运转2000-2500针／分，并观察油窗C的喷油情况，润滑正常，仍须保持低速30分钟运转试验，以后逐渐提高缝纫速度，经过一个月左右的使用，使机器充分跑合，然后根据工作的性质再提高到5000针/分。



Run-in operation is repuired for a new sewing machine.or a sewing machine left out of operation for a considerable length of time.

1) Remove Red Rubber Plugs (A) on the top of the arm and replenish sufficient amount of oil.

2) Lift Presser Foot (B)

3) Run the machine at a low speed (2000-2500spm) to check oil distributing condition through Oil Check Window (C).

4) Perform run-in operation at 2000-2500 spm for 30 minutes After a lapse of one month of service during which the working speed is increased gradually and the machine runs sufficiently well. the high speed 5000spm can be adopted according to the nasture of the work.

9. 旋梭油量调节 (图7)　9. Adjusting the lubrication of rotating hook(Fig.7)

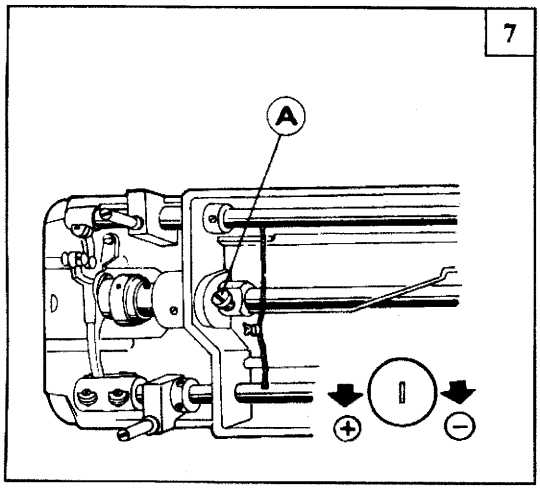
旋梭的油量，可以用油量调节螺钉A加以调节，顺时针方向("+"号方向)转动油量调节螺钉A，油量增多，逆时针方向("_"号方向)转动油量调节螺钉，则油量减少，油量调节螺钉A在回转5圈范围内调节量，拧向紧固位置时，油量最多，拧松转5圈时，油量最少。

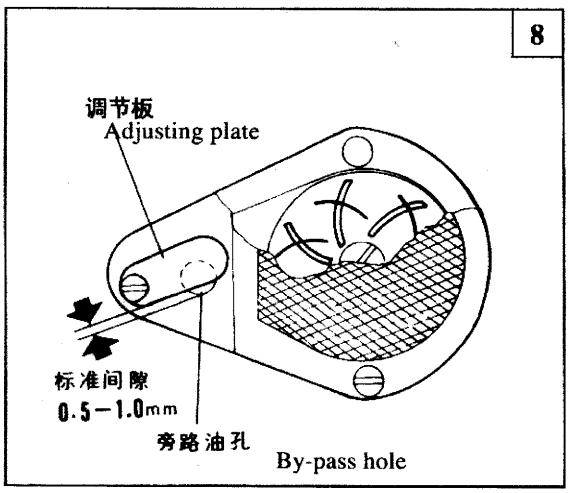
The lubrication of the rotating hook can be adjusted by Oil Adjusting Serew (A) as follows:

1) Turn Oil Adjusting Serew (A) clock wise to increase oil and turn Oil Adjusting Screw (A) clockwise to decrease oil.

2) Oil Adjusting Screw (A) adjusts oil amount within 5 turns. When Oil Adjusting Screw (A) is fully tightened, oil amount is maxmum.

3) Readjustment depends on temperature. sewing speed and the like In praetice. oil amount can be judged as follows: remove the throat plate and place a piece of paper on instead. run the machine for about 20 seconds then check the oil splashed on the paper.





10. 油泵进油调节 (图8)　10. LUBRICATION ADJUSTMENT (Fig. 8)

通常情况下，不作油泵进油调节。在低速（2000转／分）运转时，观察油窗，没见喷油现象，请合扰间隙。

A. Adjusting oil pump

In ordinary operation. adjustment is not required for the oil pump. If oil splashing does not occur in the oil check window when the machine runs at a low speed (approx 2.000 spm) reduce the clearance of the by-pass hole.

B. Adjuating the lubrication of rotating hook (See Fig. 8).

11. 安装机针 (图9)　11. REPLACE NEEDLES (Fig. 9)

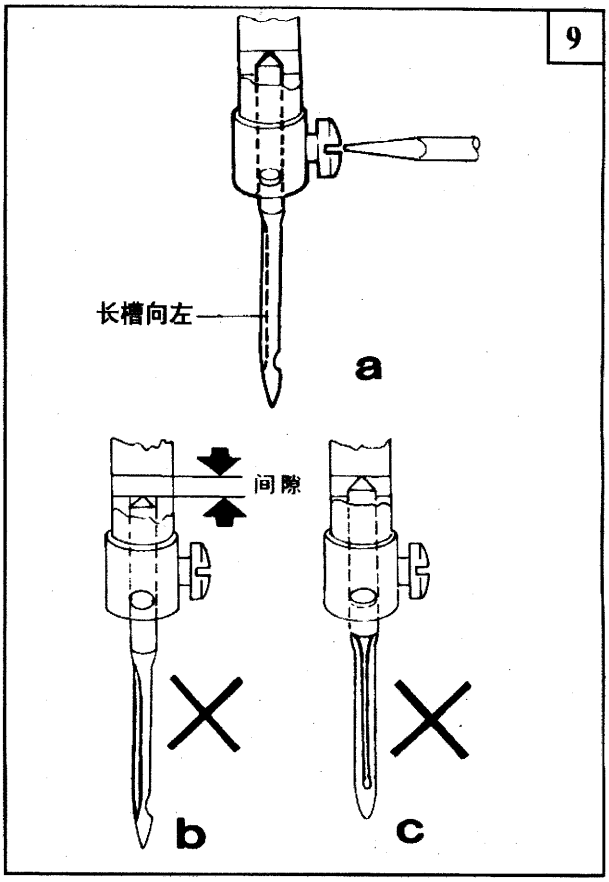
转动上轮，使机针上升到最高位置，旋松夹针螺钉1将机针的长槽朝向操作者的截左面，然后把针柄插入针杆下部的针孔内，使其碰到针杆孔的底部为止，再旋紧夹针螺钉1固定机针即可。

注意：如图b所示，机针没有碰到针杆孔的底部。如图c所示针槽方向面对操作者，都是错误的。

Turn the balance wheel to lift needle bar to the upper end of its stroke Loosen Needle Clamp Screw 1. While keeping the lon groove of the needle leftward fully insert the needle shank up to the bot tom of the needle socket Then tighten Needle Clamp Screw A.

Note: Fig (b): insufficient insertion.

Fig (c): wrong direction of long groove.



12. 机针、缝线规格与缝料关系 (图9)　12. NEEDLE, THREAD AND MATERISL TO BE SEWN

面线采用左旋线，底线则左、右旋线均可使用。

针用16 × 231 或 DB × 1, DA × 1机针。

机针号请根据缝线，缝料参改下表进行。

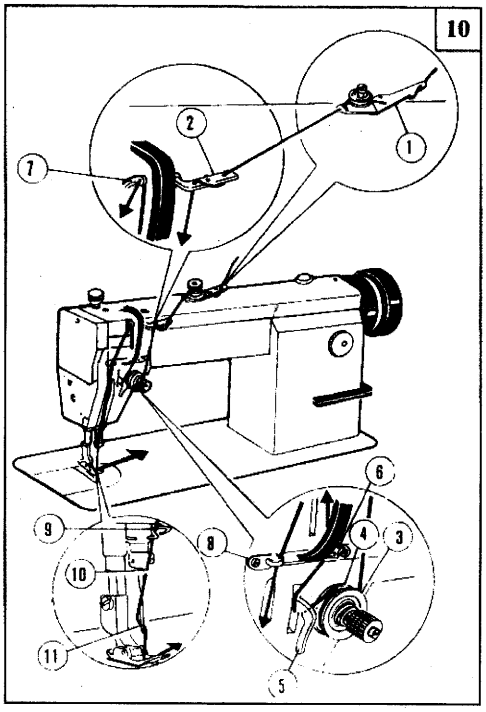
机针号 Needle Size	缝线号 Thread Number	布　料 Material
9#	100#-80#	绉纱，乔其纱，蝉翼纱等极薄料 georgette, hard crepe
11#	80#-60#	绢、平纹布、府绸等薄料 silk, muslin, poplin
14#	60#-50#	普通棉、毛织物等 cotton, light woolen
16#	50#-30#	平纹布、毛织物、防雨衣、薄皮革等 woolen, tarpaulin, thin leater

13. 穿线 (图10)　13. THREADING (Fig. 10)

穿面线时针杆应在最高位置，然后由线架上引出线头按顺序穿线。

引底线时，先将面线头捏住，转动主动轮使针杆向下运动，再回升到最高位置，然后拉起捏住的面线线头，底线即被牵引上来，最后将底，面二根线头一起置于压脚下前方。

To thread the needle thread. raise needle bar to the upper end of its stroke. lead the thread from spool and perform threading as shown in Fig.13. To draw the bobbin thread. hold the end of the needle thread and turn the balance wheel to lower the needle bar and then to lift it to its highest position. Pull the needle thread and the bobbin thread is drawn up. Put the ends of needle thread and bobbin thread frontward under presser foot.



14. 绕线调节 (图11)　14. WLNDOXG ADJUSTMENT (Fig. 11)

梭心线应排列整齐而紧密。如松浮不紧，可以加大过线架夹线板A的压力。如排列不齐，则要移动过线C的位置进行调整。调整时，先松开过线架螺钉B，单边绕线成图b时，向右移动过线架，单边绕线成图c时，向左移动过线架，自动排列整齐成图a后，再紧固之。

注意：绕涤纶，尼龙线时，特别要放松绕线压力，否则梭心D就可能产生断裂变形。

梭心线不要绕得过满，否则容易散落，适当的绕线量为平行绕线至梭心外径的80%。绕线量由满线跳上的满线度调节螺钉E加以调节。

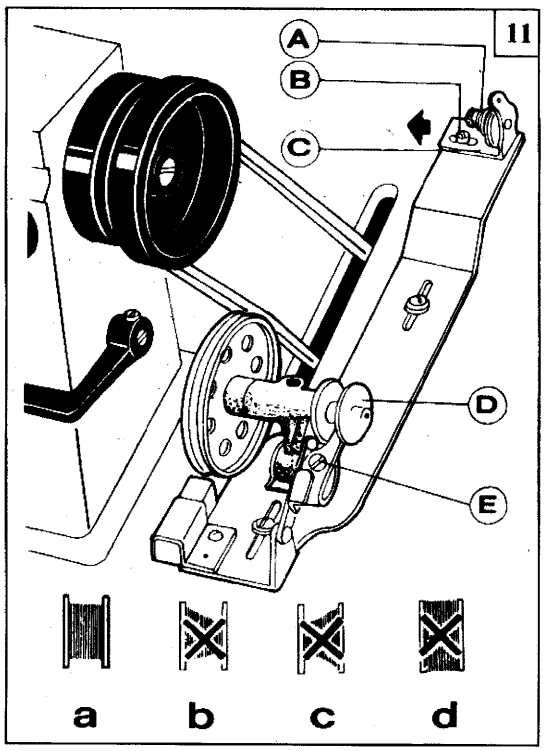
1) The wound bobbin thread should be neat and tight. if not. adjust the winding tension by turnlng. Tension Stud Nut (A) of bobbin winder tension bracket.

Note: nylon polyester thread should be wound with little tension otherwise. Bobbin (D) might break or deform.

2) When the wound thread layer dose not present a cylindrical shape as shown in Fig. 11(a). loosen Set Serew (B) of bobbin winder tension bracket and slide Bracket (C) leftward or rightward If thread is wound as shown in Fig. 11(b). move the bracket rightward. but if thread is wound as shown in Fig 11(c). move the bracket leftward

After adeguately positioning the bracket. tighten Set Screw (B).

3) Do not overfill the bobbin. The optimum length of thread will fill about 80% of bobbin capacity. This can be adjusted by Adjusting Screw (E) of bobbin win der stop latch.



15. 针距、倒顺送料 (图12) 15. SET STITCH LENGTH AND REVERSE FEEDING (Fig. 12)

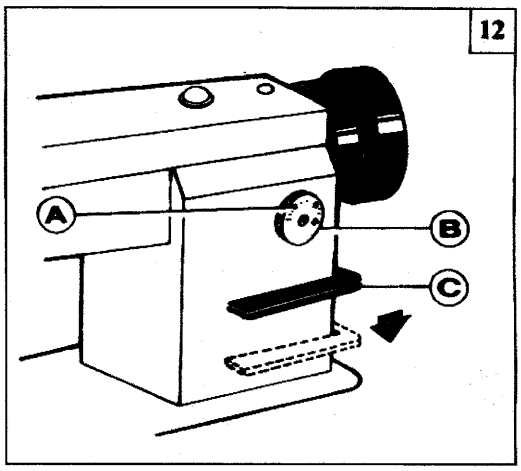
针距的长短，可以用转动针距标盘A来调节，针距标盘A的平面B上的数字表示针距长短尺寸（单位为毫米）。

倒向送料时，可以将倒缝操作杆C，向下揿压，即能进行倒送，手放松后，倒缝操作杆C自动复位，恢复顺向送料。

1) Stitch length can be set by turning Dial (A).

2) The figures on Face (B) of dial shew stitch lengthin mm.

3) Reverse feeding starts when Reverse Feed Lever (C) is depressed. and the machine will feed forward again if Reverse Feed lever (C) is released.



16. 压脚杆高度定位 (图13) 16. POSITION PRESSER BAR (Fig. 13)

先旋松压紧杆的调压螺钉锁紧螺母E，然后旋松调压螺钉A，卸下面板B的橡皮塞，旋松螺钉C，定出压紧杆的位置，(压紧杆的正确定位：在压脚上升最高时，针板面与压脚底面距离为50毫米)，旋紧螺钉C，塞上橡皮塞，再旋紧压紧杆的调压螺钉A，然后旋紧调压螺钉锁紧螺母E，即成。

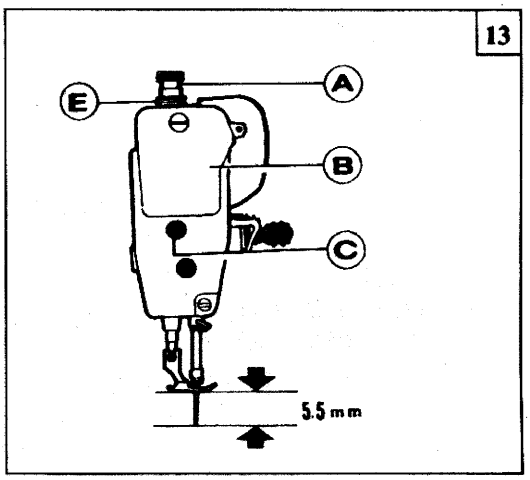
1) Loosen Lock Nut (E) and Pressure Regu lating Thumb Screw (A)

2) Remove rubber plug from Face Plate (B).

3) Loosen Screw (C) and adjust the position of Presser Bar (D) tillthe presser foot is 5.5mm above the throat plate with the presser foot lifted to its highest.

4) Tighten Screw (C) and put in the rubber plug.

5) Tighten Pressure Regulating Thumb Screw (A) and Lock Nut (E).



17. 压脚压力调节 (图14) 17. ADJUST THE PRESSURE OF PRESSER FOOT (Fig. 14)

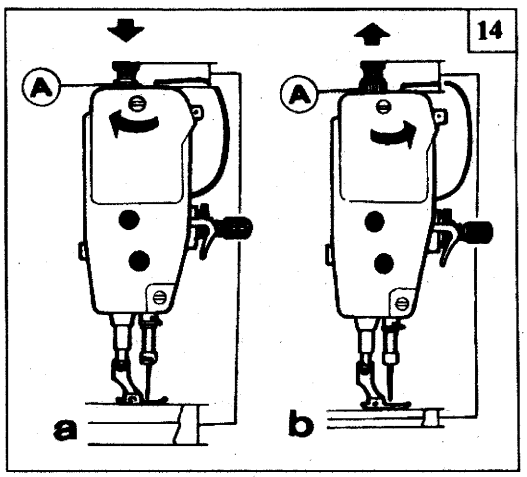
压脚的压力，要根据缝料的厚度加以调节，首先旋松调压螺钉锁紧螺母A，缝纫厚料时，应加大压脚压力，这时将机头顶部的调压螺钉按图A所示箭头方向转动，反之，缝纫薄料时，可按图B所示的方向，转动调压螺钉，以减少压脚的压力，最后旋紧调压螺钉锁紧螺母A即成。

压脚的压力，应以能正常推送缝料为宜。

Pressure of presser foot is to be adjusted in accordance with thickness of materials to be sewn.

First loosen Lock Nut (A) For heavy materials, turn the pressure regulating thumb screw as shown in Fig.14. (a) to increase the pressure, while for light materials, turn the pressure regulating thumb screw as shown in Fig. 14.(b) to decrease the pressure. Then tighten Lock Nut (A)

The pressure of presser foot is recommended to be less as long as normal feeding is ensured.



18. 缝线张力 (图15、16) 18. ADJUST THREAD TENSION (Fig. 15. 16)

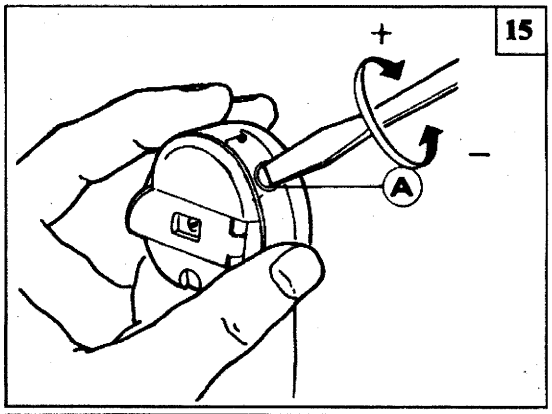
缝线的张力要根据缝料的差别，缝线的粗细以及其他一些因素而变动。

实际使用中，是依据缝纫出来的线迹。来调整底，面线的张力，使之得到正常的线迹。

底线张力调整，只要用小号螺钉起子旋转梭心套上梭皮螺钉A加大或减少底线压力即可。

一般来说，底线如采用60#棉线，梭心装入梭心套后，拉出缝线穿过梭心套线孔，捏住线头吊起梭心套，梭心套则能缓缓下落，就可以使用。

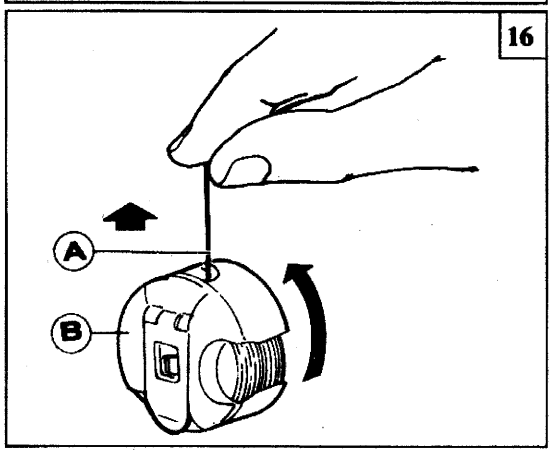
面线张力以底线张力为基准。面线张力调整，主要变换夹线组件中挑线簧张力，挑线簧摆动幅度，夹线簧张力，夹线板及线勾的位置等。



In principle, thread tension is to be adjusted in accordanee with materials, thread and ether factors.

In practice. thread tension is adjusted according to the stitches obtained. The needle thread tension should be adjusted with reference to the bobbin thread tension. Turn Tension Spring Rcgulating Screw (A) of bobbin case clockwise for more tension. or turn the screw counter-clockwise for less tension (See Fig. 15)

It is common practicc to test the bobbin thread tension as shown in Fig 16 Hold the end of the thread from delivery eye. If the bobbin case is falling slowly the proper tension is obtaincd. The needle thread tension can be adjusted by setting (1) the thread take -up spring tension (2) the thread take-up spring stroke and (3) tension spring. All these adjustments will be described in the following.



19. 挑线簧调节 (图17、18) 19. ADJUST THREAD TAKE-UP SPRING (Fig. 17. 18)

挑线簧摆动幅度8-10毫米。缝纫薄的缝料(短针距)，则要减弱挑线簧的张力和放宽其摆动幅度，缝制特别厚的缝料则反之。

1 挑线簧张力调节

先旋松夹线调节螺钉A，夹线螺钉B就能转动，顺时针转动时，张力增加，反之则减少，调节好后，仍将夹线调节座螺钉A旋紧。

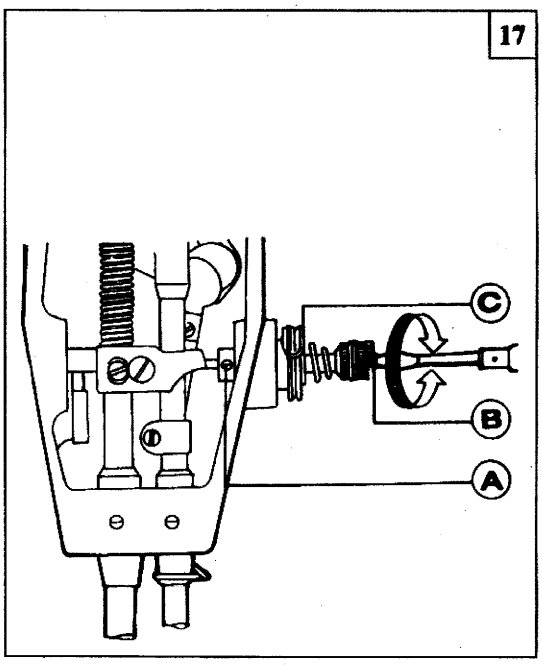
控制方法：

松开夹线调节座螺钉A，将夹线螺钉B，逆时针转动，使挑线簧C的张力压缩到O，再把夹线螺钉B顺时针转动，至挑线簧C触及夹线调节上止动缺口，然后夹线螺钉B再逆时针回转二分之一转动角度即可，最后旋紧夹线调节钉座A。

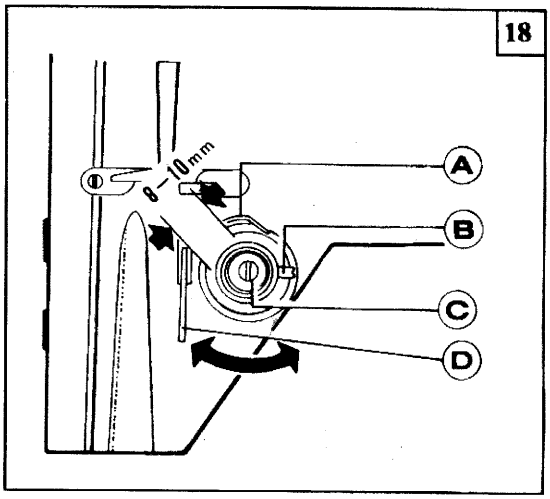
2 挑线簧摆动幅度的调节

旋松夹线调节座固定螺钉B，转动夹线器C，调节其摆动幅度，夹线器C顺时针转动，摆动幅度增大。反之则减少。

通常，机器在出厂前，挑线簧均已调整妥善。只是在缝纫特殊的缝料或特殊的缝线时，才需要重新进行调整。



The standard tension of thread take-up spring is about 25g. and its stroke runs from 8mm to 10mm. When sewing very thin fabrics at short stitch length, decrease the thread take-up spring tension and in crease the thread take-up spring stroke but for very thick fabrics, increase the spring tension and decrease the spring stroke.



1) Adjusting the thread take-up spring tension (See Fig. 17)

Loosen Set Screw (A). turn Tension Stud (B) clockwise to increase the spring tension. or turn the stud counter-clockwise to decrease the spring tension, After the adjustment. be sure to tighten Set Screw (A). The thread take-up spring tehsion should be about 30g. To Attain this, first loosen Set Screw (A). turn Tension Stud (B) counter-clockwise to decrease the tension of Thread Take-up Spring (C) to zero. then turn Tension Stud (B) clockwise until Spring (C) comes to the notch of thread tension regulating bushing. and again turn. Tension Stud (B) halfway back (counter-colockwise). After the adjustment, tighten Set Screw (A).

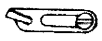
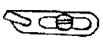
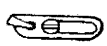
2) Adjusting the thread take-up spring stroke (See Fig.18)

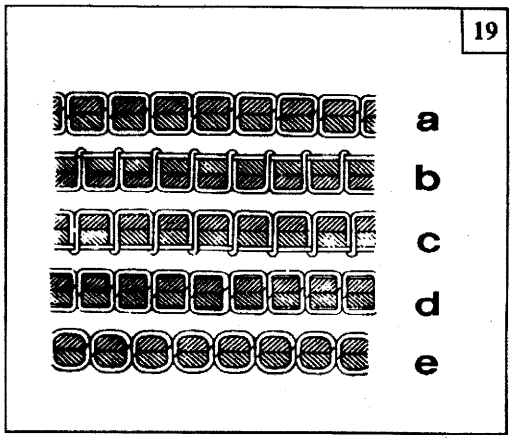
Loosen Set Screw(B). turn Stud (C) clockwise to increase the stroke or turn Stud (C) counter-clockwise to decrease the stroke. After the adjustment. tighten Set Screw (B). Before leaving the factory. the thread take-up spring has properly been adjusted. Read just ment is needed only in the case of special material or special thread.

20. 底面线张力调节 (图19、20、21) 20. ADJUST THREAD GUIDE AND THREAD TENSION (Fig. 19. 20. 21)

线勾装配位置的调节，关系到缝纫质量的优劣。线勾装配位置，应适合缝料与缝纫条件。

The position of the thread guide affects stitch tightness and therefore must be adjusted according to sewing materials and sewing conditions.

线勾位置 Thread guide position	左 侧 Leftward	中 间 Center	右 侧 Rightawrd
			
缝 料 Material weight	厚 料 Heavy	中厚料 Medium	薄 料 Light

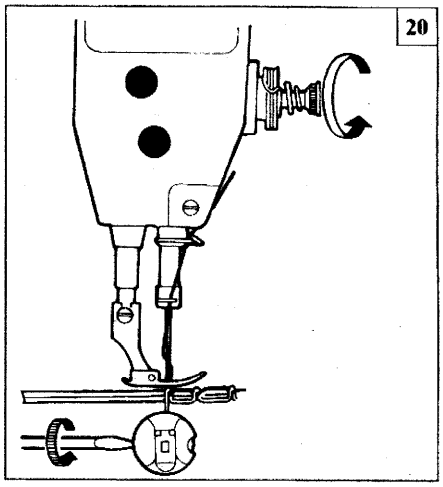


缝纫物的线迹应该如图A。如果线迹不正常时，会出现缝料起皱和断线现象，应对底、面线的张力加以调节。使之达到正常的线迹。

(1) 如果面线太紧，底线太松，则应逆时针旋转夹线螺母，放松面线的压力，或用小号螺钉起子，旋紧梭皮螺钉，加大底线的压力。

Fig. 19 shows different stitch forms. Normal stitch form should be as shown in Fig. 19 (a). When abnormal stitches cause puckering and thread breakage. the tension of needle thread and bobbin thread must be adjusted accordingly.

1) In case needle thread tension is too strong or bobbin thread tension is too weak. as shown in Fig. 19 (b). turn the thumb nut counter clock wise to decrease the needle thread tension. or tighten the tension spring regulating screw of bobbin case to increase the thread tension (See Fig. 20).

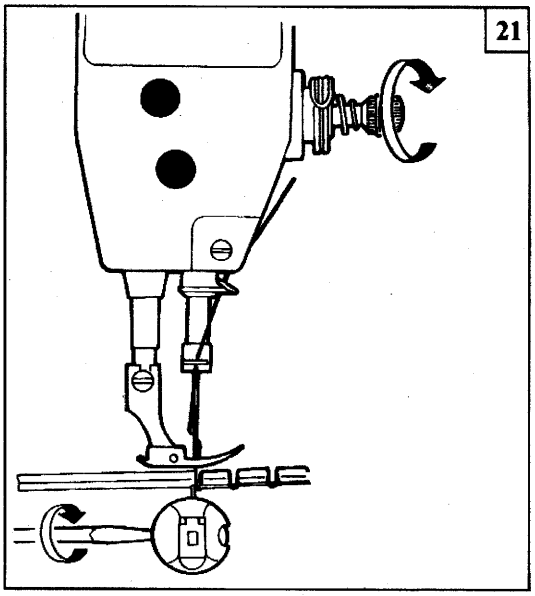


（2）如果面线太松，底线太紧，则应顺时针旋转夹线螺母，以加大面线的压力或用小号螺钉起子，旋松梭皮螺钉，减小底线的压力。

（3）如出现图b，e的线迹，也可以参照上述方法加以调节。

2) In case needle thread tension is too weak or bobbin thread tension is too strong, as shown in Fig. 19 (c). turn the thumb nut clockwise to increase the needle thread tension, or loosen the tension spring regulating screw of bobbin case to decrease the bobbin thread tension (See Fig.21)

3) In case of the stitch forms as shown in Fig. 19 (d) and (c) adjustments can be made with referenee to the above means.



21. 机针与旋梭同步调整（图22、23、24、25）　21. TIME NEEDLE TO ROTATING HOOK (Fig. 22. 23. 24. 25)

(1) 机针位置的调节：

用手转动主动轮，使针杆C下降至最低位置，卸下面板A上的橡皮塞，旋松针杆C上的针杆接头螺钉B，上下移动针杆C，定出同步位置（针杆的同步位置：针杆下降至最低位置时，针杆上的同步标记B与套筒A下端面成一致的位置，这时机针线孔的中心D与旋梭内面E也成一致位置如图23所示的位置）。旋紧针杆接头螺钉B，塞上橡皮塞即成。

A.Adjusting the needle position (See Fig 22)

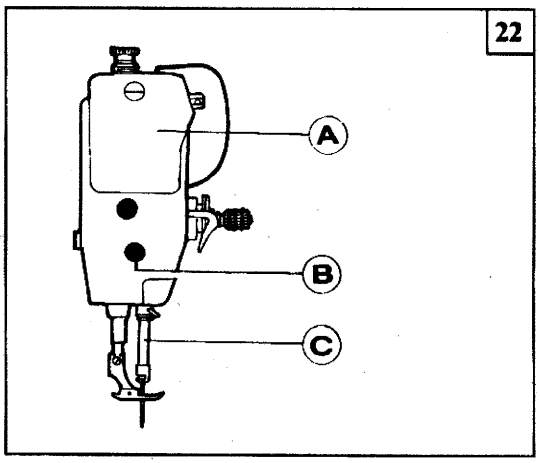
1) Turn balance wheel by hand to bring Needle Bar (C) to the lowest position of its stroke.

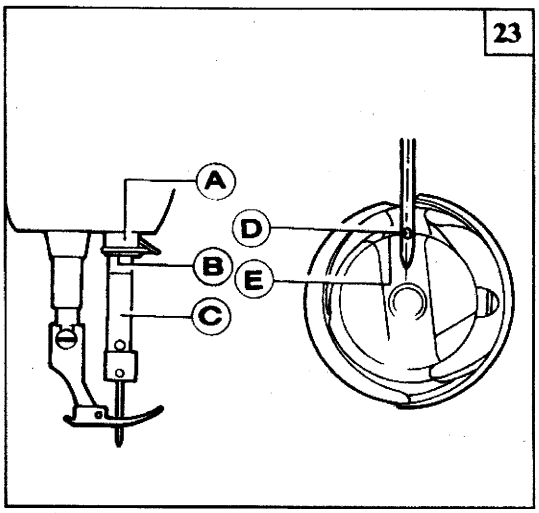
2) Remove rubber plug from Facc plate (A).

3) Loosen Set Screw (B) of needle bar adaptor.

4) Move Needle Bar (C)vertically to adjustneedle timing.

5) After the adjustment tighten. Set Screw (B) and put in the rubber plug. The standard needle timing(See Fig 23) is to alignTiming Mark (B) on the needle bar and the bottom of Needle Bar Bushing (A) and meanwhile align the lnner Surface (E) of the hook and t he center of Needle Eye (D) when the needle bar gets down to its lowest position.

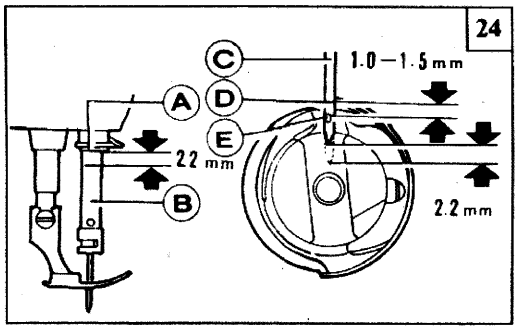


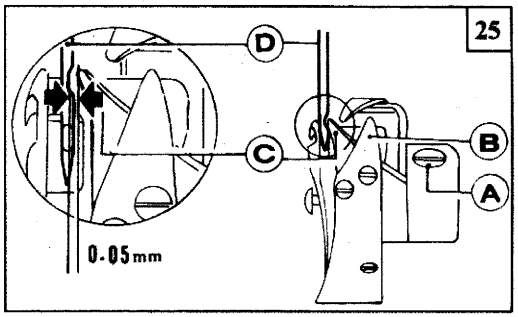


(2) **旋梭同步的调节:**

旋梭和机针之间的相互运动关系，对缝纫性能的影响很大，标准的同步关系是：当机针向下运动到最低位置后，目测针杆的同步标记A的间距为2.2毫米，把针杆B从最低位置上升 2.2 毫米，这时旋梭的钩线尖D应与机针的中心线C 一致，在此位置时，钩线尖D应高于机针线孔E上边1.0-1.5毫米。

在调节旋梭的同步关系时，还要注意到旋梭尖与机针的侧面间隙，机针D缺口。底部与旋梭钩线尖C的间隙为0.05毫米。





B. Adjusting the hook point timing

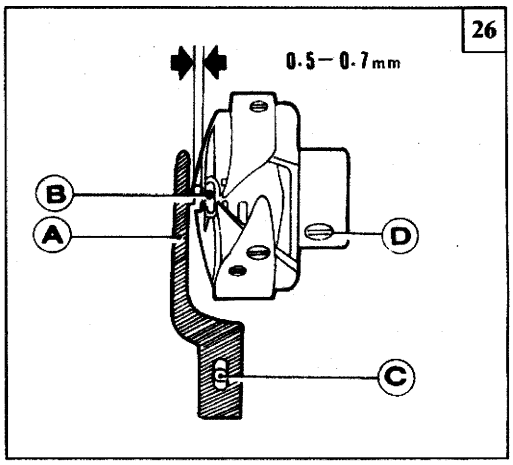
Timing of needle motion to rotating hook motion has a great effect on sewing performanee. The standard hook point timing (See Fig. 24) is to align Hook. Poing (D) and Needle Centerline (C) when Needle Bar (B) is lifted by 2.2 mm from the lower end of its stroke. Besides, Hook Point (D) should be 1.0-1.5 mm above the upper end of needle eye (E).

When adjusting the hook point timing also notice that the clearance between the bottom of needle notch and Hook Point (C) should be approx 0.05mm (See Fig. 25).

22. 旋梭装卸 (图26) 22. REPLACE ROTATING HOOK (Fig. 26)

先将针杆上升到最高位置，拆下针板，取下机针和梭心套，旋开旋梭定位勾螺钉C，把旋梭定位勾A取下。再旋松旋梭螺钉D。在此位置如果取出旋梭，旋梭将会与牙架相碰，此时可以转动主动轮使牙架上升到最高位置。然后扭转旋梭让过牙架位置，即能将旋梭很容易地取下。安装旋梭时，可以重复上述过程。

注意：旋梭定位勾的安装位置应是旋梭定位勾A的勾尖侧面与机针B的侧面应成一致，另外其两侧面之间隙为0.5 - 0.7毫米。



1) Lift needle bar to the highest position of its stroke.

2) Remove throat plate, take down needle and bobbin case.

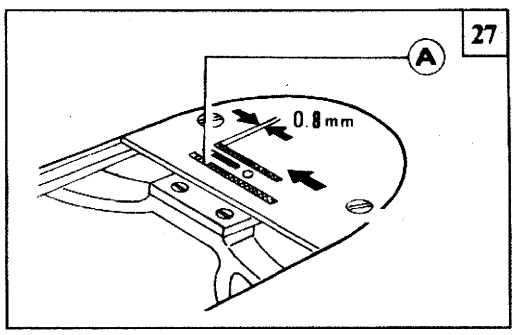
3) Loosen Screw (C) of hook positioner and take down Hook Positioner (A).

4) Loosen two Screws (D) of rotating hook.

5) Turn balancee wheel to raise feed bar to its highest position then take down the rotating hook by turning it away from feed bar.

6) Installing the hook can be done in reverse sequence.

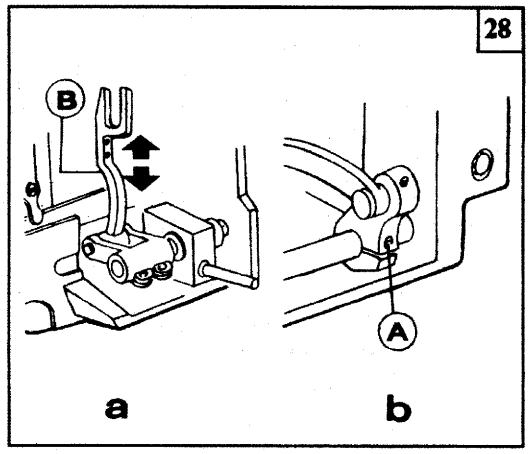
Note that Needle (B) and the convex surface of Hook Positioner (A) should align with a clearanee of 0.5 - 0.7 mm between them.



23. 送布牙安装(图27、28)　23. ADJUST THE POSITION OF FEED DOG (Fig. 27. 28)

1. 当送布量最大，送布牙A前端靠近板槽前侧时，送布牙前端与针板槽前侧的间距为0.8毫米，这是标准的送布牙安装位置。

2. 调节送布牙位置时，先让送布运动至针板最前侧停止，然后旋松送布轴曲柄螺钉A（见图28b），将牙架B按图28b所示箭头方向移动，以调节其间隙位置，调节好后，再把螺钉A旋紧。



The standard position of feed dog is that the clearance between the front end of the throat plate slot and the first tooth of the fully advanced feed dog is 1mm.as shown in Fig.27.

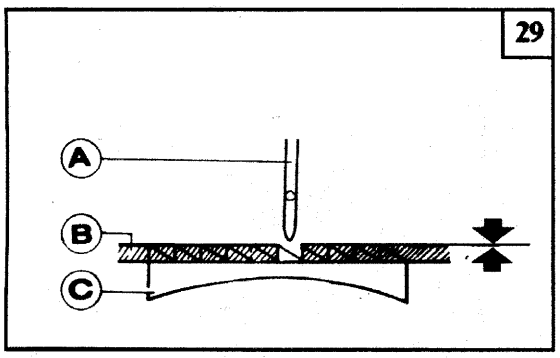
1) Fully advance the feed dog toward the front end of the throat plate slot.

2) Loosen Feed Rock Shaft Crank Screw (A) See Fig 28 (b).

3) Move Feed Bar (B) in the dircction shown by the arrow Fig 28 (a) to adjust the feed dog postiton.

4) After the adjustment. be sure to tighten Screw (A).

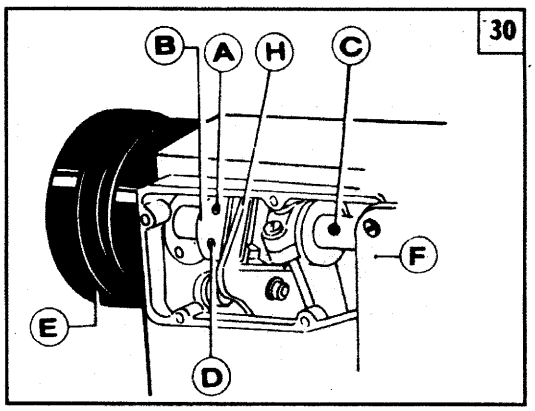
24. 送布牙与机针同步调节(图29、30、31)　24. TIME FEED MOTION TO NEEDLE MOTION (Fig. 29. 30. 31)

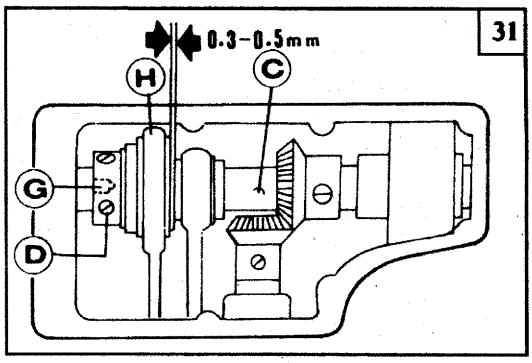


机针A尖端到达板面B时，送布牙C尖端与针板面B高低一致，此为标准同步关系。

不同步时的调节方法：先打开机壳后盖板F，旋松送布凸轮螺钉A、D，按住送布凸轮B，再缓缓转动主动轮，当上轴油孔C的上端与送布凸轮的基准孔G的下端一致时，即达到同步关系。

调节时，送布凸轮B与牙叉滑块H的间隙应为0.3 - 0.5mm，最后，旋紧送布凸螺钉A、D即可。





The standard timing of feed motion to needle motion is that the top of feed Dog (C) is flush with. Throat Plate Surface (B) when the point of Needle (A) reaches Throat Plate Surface (B) S ee Fig 29.

If feed motion is not timed to needle motion adjust as follows (See Fig. 30 and 31).

1) Remove Arm Side Cover (F).

2) Loosen Set Screws (A) and (D) of feed and feed lifting eccentric.

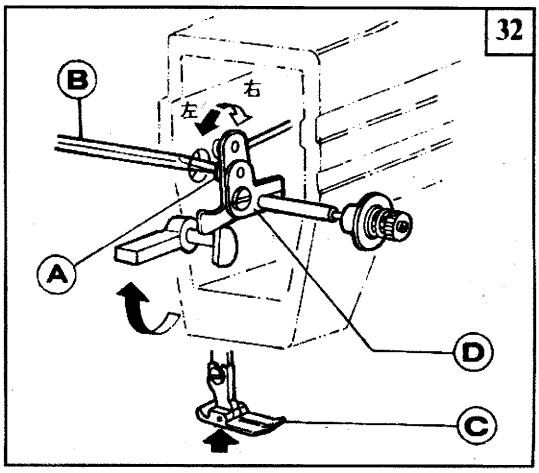
3) Hold Feed and Feed Lifting Eccentric (B) and turn B alancc Wheel (E) slowly until the upper edge of Arm Shaft Oil Hole (C) aligns with the lower edge of Reference Hole (G) of feed and feed lifting eccentric.

4) Leave a clearance of 0.3-0.5 mm between. Feed and Feed Lifting Eccentric (B) and Eccentric Sleeue (H) then tighten Screws (A) and (D).

25. 松线器挺线调节(图32)　25. ADJUST OPENING TIME OF THE TENSION DISCS (Fig. 32)

压脚在提升范围(2-7毫米)，夹线器上的夹线板有一个张开期，挺线的时间可进行调节，调节时，先卸下机头背面的橡皮塞，用螺丝刀B旋松膝控提升杠杆，(左)螺钉A，这时松线凸轮D可以左右移动，往右移挺线慢，往左移挺线快。

调节时，如有条件的话，在压脚C下垫上一块与压脚提升高度尺寸相等的垫块，则调节时方便。



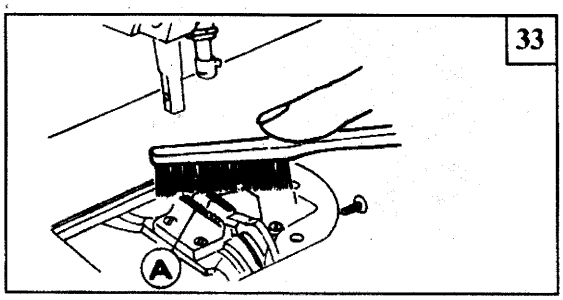
Within the presser foot lift range of 2-7mm opening time of the tension discs can be adjusted as follows.

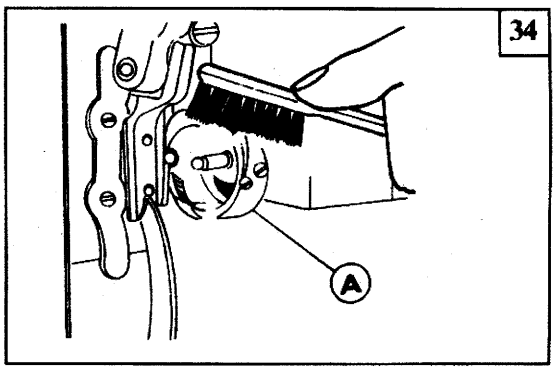
1) Remove the rubber plug from the back of arm and loosen Screw (A) of knee lifter lever (left).

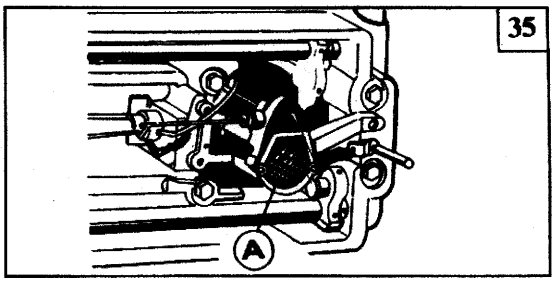
2) Move the tension releasing cam leftward for earlier opening or rightward for later opening It Will facilitate the adjustment to put under the presser foot a block as thick as the presser foot lift.

3) After the adjustment. fully tighten Screw (A).

25. 定期清扫(图33、34、35)　25. REGULAR CLEANING (Fig. 33. 34. 35)







请根据使用程度，定期进行清扫送布牙，旋梭，梭心套和油泵滤网等。

1. 送布牙的清扫

先卸下针板，清除送布牙A间距（牙槽）内的尘垢，然后再安好针板。

2. 旋梭的清扫

清除旋梭A周围的尘垢，如图所示，同时用软布拭擦梭心套。

3. 油泵滤网的清扫

如图所示，清除滤网A上的尘屑。

1)Cleaning feed dog (See Fig 33)

Remove the throat plate and clear off the dust and lint between feed dog tooth slots.

2)Cleaning rotating hook (See Fig 34)

Swing out the machine head and ckean the hook. Wipe the bobbin case with soft cloth

3)Cleaning oil pump screen (See Fig 35)

Swing out the machine head and clear off the dust and dirt on the oil pump screen.

6 系列