

MAQI

使 用 说 明 书

美 机 缝 纫 机

MAQISEWING MACHINE

OPERATION MANUAL

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危险警告 Warning



机器运作过程中，必须在机器的前后各保留 1m 的自由工作范围，以保证人员能够随时地，不受限制地接近机器。

During the operation of the machine, a free working range of 1m must be kept in front and behind the machine to ensure that personnel can be close to the machine at any time without restriction.



在缝纫过程中，不许在缝纫针区域抓取任何东西！有被针伤的危險！

During the sewing process, do not grab anything in the sewing needle area! In danger of a needle injury!



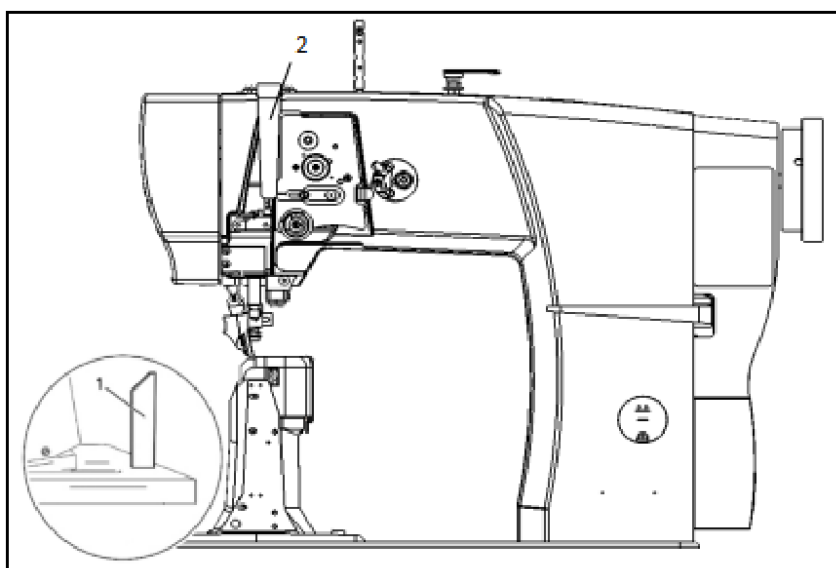
调整工作过程中，不许在工作台上放任何物品！有被四下乱飞的物品伤害的危險！

In the process of adjustment, do not put any items on the workbench! There is a danger of being hurt by the objects flying around!



不许开动没有支承件 1 的机器！因为机头非常重，当向后倾斜时，机器有向后翻到的危險！

Do not start a machine without support 1! Because the nose is very heavy, when tilted backwards, the machine is in danger of turning backwards!



在向后倾斜机器前关闭总开关！有被机器意外地启动伤害的危險！

Turn off the master switch before tilt the machine backward! In danger of being accidentally started by the machine!



不许开动没有挑线杆防护罩 2 的机器！有被挑线杆的动作伤害的危險！

Do not start the machine without the pick rod protective cover 2! There is a risk of being hurt by the movement of the pick pole!

2. 安装 Installation

在机器安装地点,必须有与机器相符的电源接口。

在机器安装地点,必须有平整、坚固的地面,以及充分的照明。

The site where the machine is installed must be provided with suitable connections for electric current.

it must be ensured that the standing surface of the machine site is firm and horizontal, and that sufficient lighting is provided for

2.01 台板高度的调整 Adjust the table height

松开螺钉 1 和 2,并将台板调整至所需的高度;

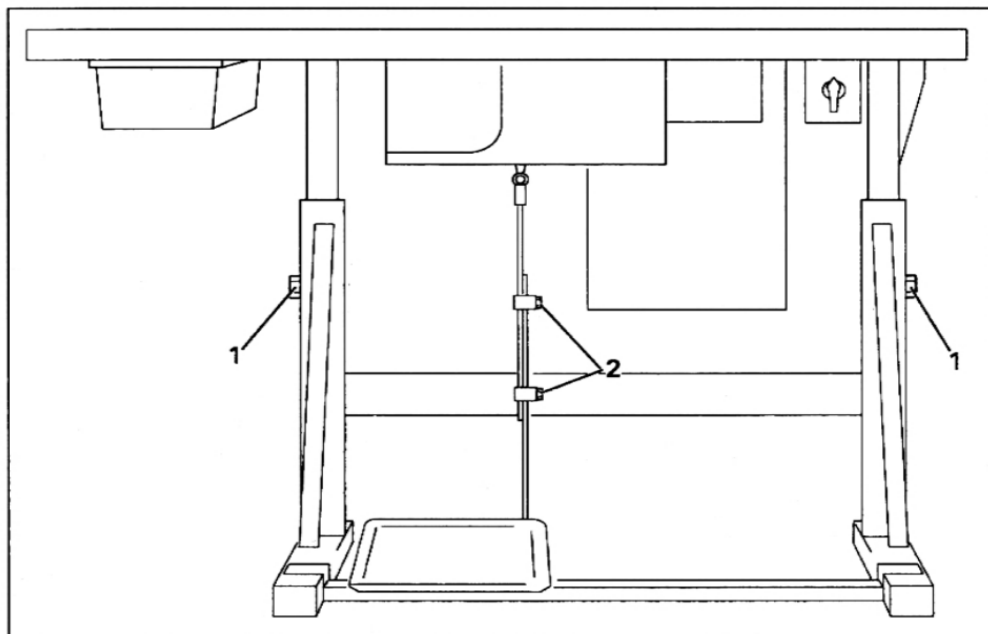
将螺钉 1 牢固地拧紧;

将踏板调至所需的位置,并且将螺钉 2 拧紧。

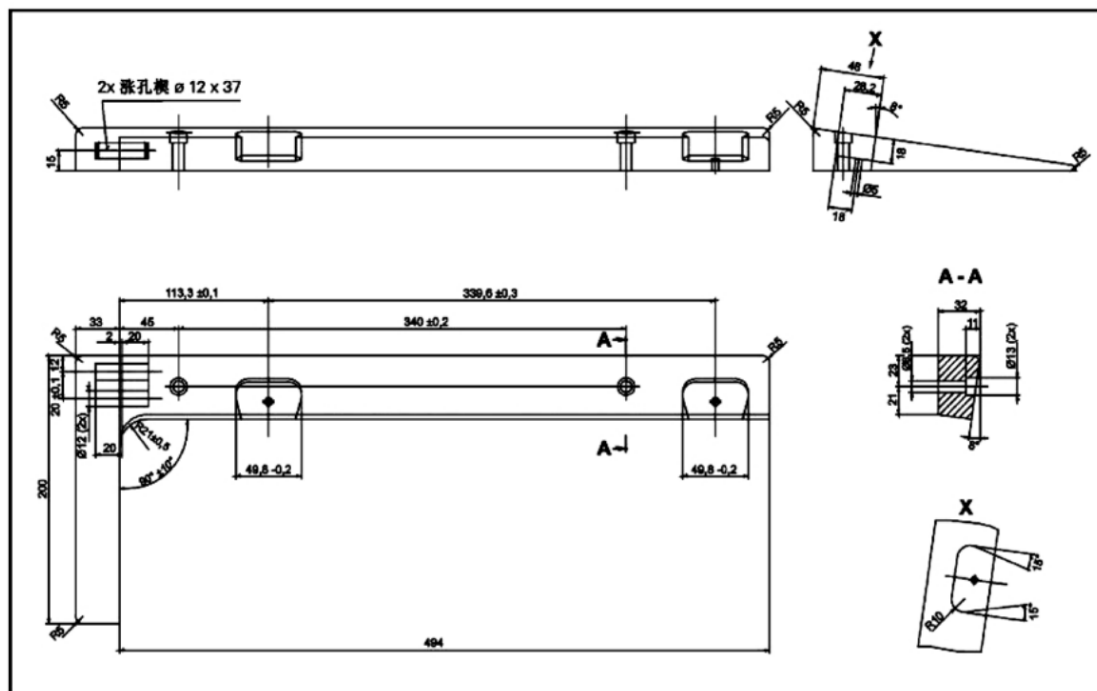
Loosen screws 1 and 2, and set the table height as required;

Firmly tighten screw 1;

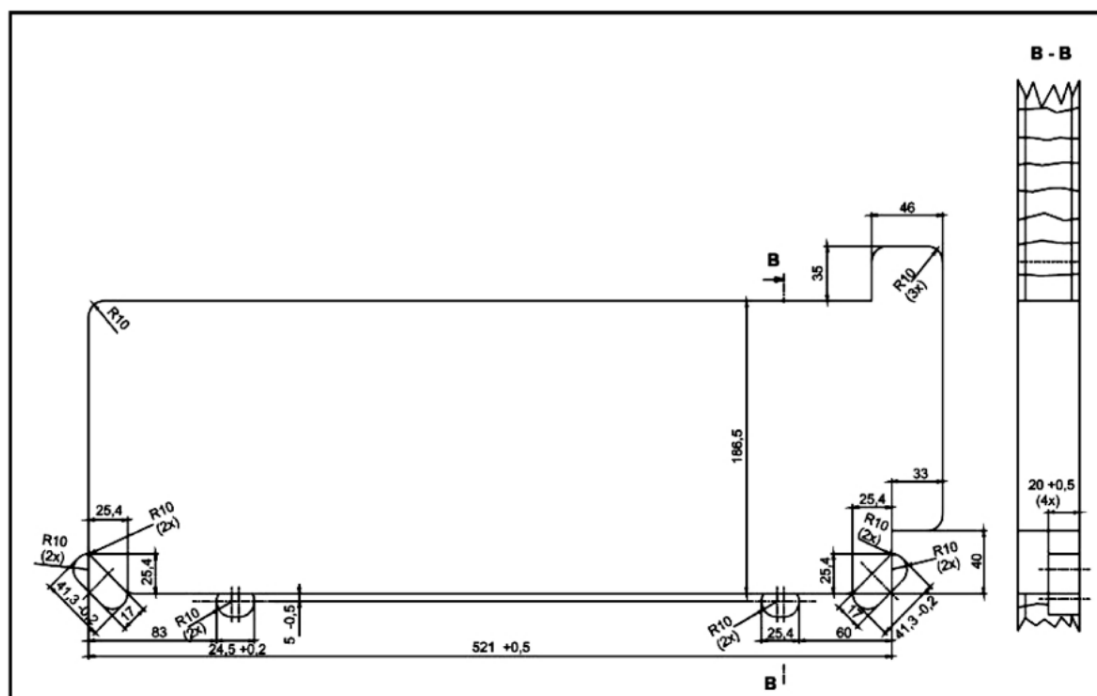
Set the required pedal position and tighten screw 2.



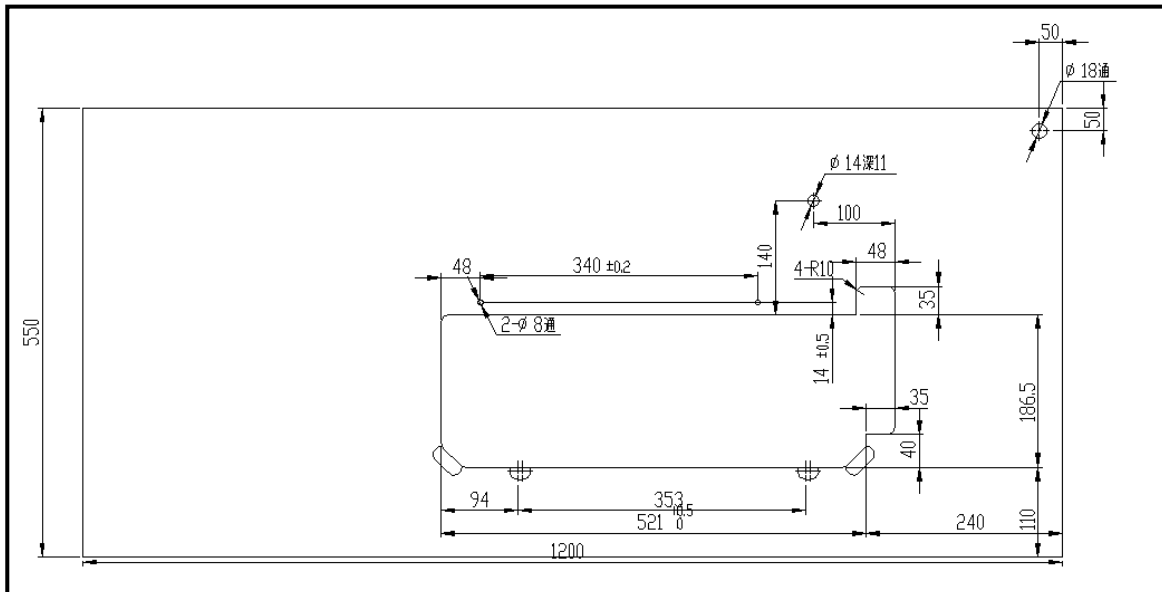
2.02 安装倾斜支撑块



2.03 台板开槽部位尺寸



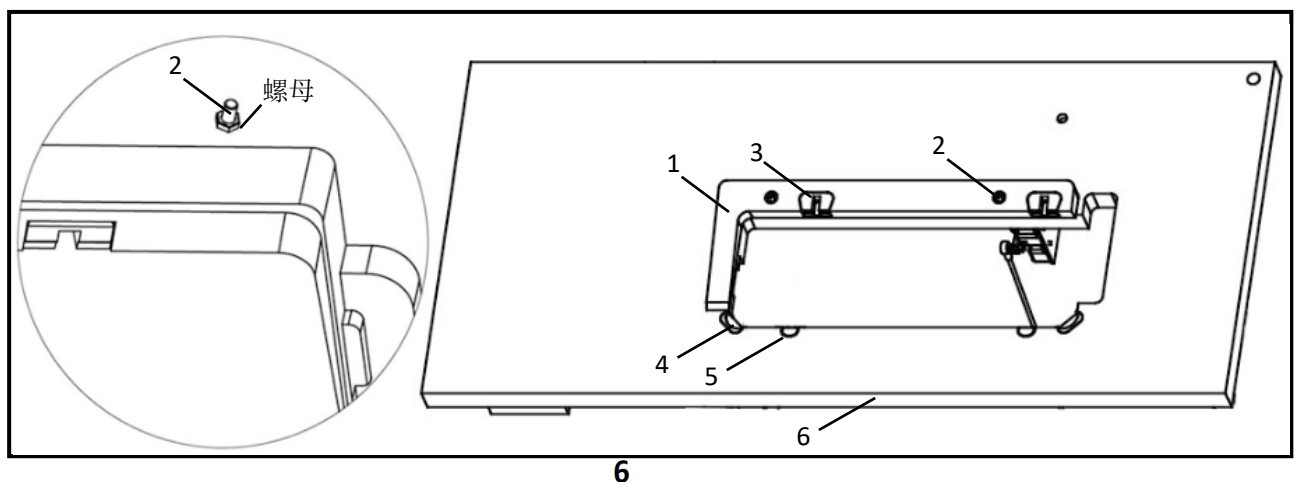
2.04 安装台板



2.05 安装七字型木架 Installation of Seven Type Wooden Frame

如图所示在七字型木架 1 上安装机头铰链座组件 3，马叉螺钉 2 穿过七字型木架 1、台板 6，使用螺母预紧马叉螺钉 2，随后在台板 6 上嵌入机头坐垫 4、机头支座 5。

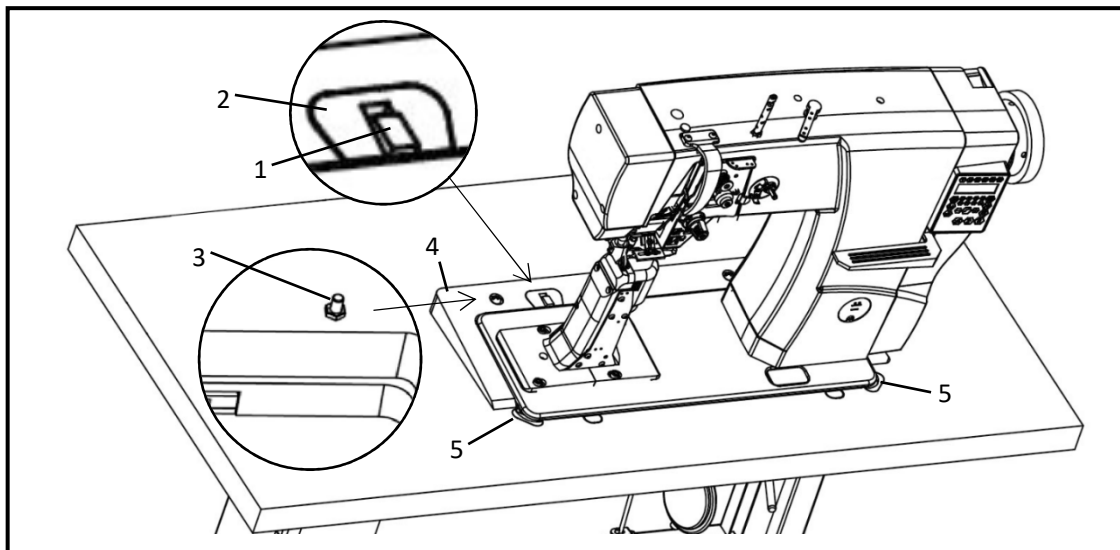
Mount the head hinge base assembly 3 and the horse fork screw 2 on the seven shaped wooden frame 1 as shown. Through the 7-shaped Wooden frame, the bedplate, use the nut to pretighten the fork screw 2, and then on the bedplate 6. The head cushion 4 and the head support 5 are embedded in the upper part of the machine.



2.06 调整七字型木架 Adjust the seven - shaped wooden frame

如图所示将机头放置在台板上，机头上的铰链轴 1 应嵌入铰链座 2 内，释放马叉螺钉 3，随后调整机头位置，底板应有效压在机头坐垫 5 上，同时木架 4 应随机头移动，尽可能的靠近机头，调整完成后固定马叉螺钉 3。

The head is placed on the table plate as shown. The hinge shaft 1 on the head should be embedded in the hinge seat 2, release the horse fork screw 3, and then adjust the machine. The head position bottom plate is effectively pressed against the head seat 5, while the wood frame 4 shall be random head moves as close to the head as possible. Fixed after adjustment. Horse Fork Screw 3.

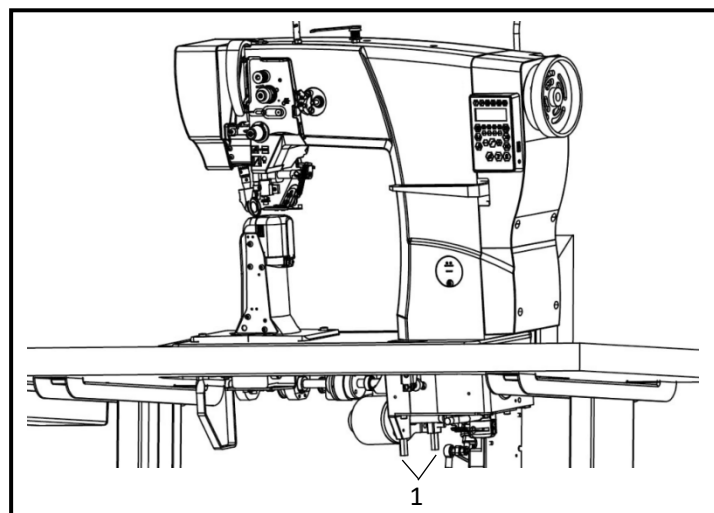


2.07 拆除支脚螺钉 Removal of Brace Screws

Removal of Brace Screws

在将油盘安装到台板底部前，使用开口扳手拆除支脚螺钉 1。

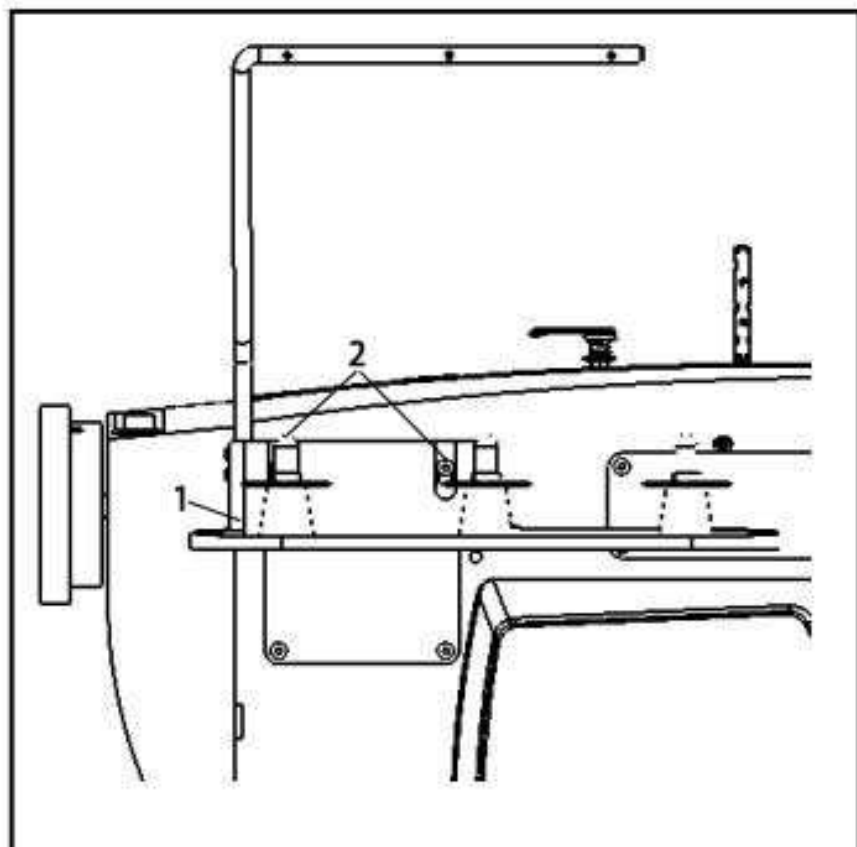
Before installing the oil pan to the bottom of the tray, Remove Brace Screws 1.



2.08 安装线架 Fitting the reelstand

如图所示安装线架：
将线架1的长槽挂在螺钉2上，
随后锁紧螺钉2。

Install the wire rack as shown:
Hang the long slot of the wire
rack 1 on the screw 2,
Then lock the screw 2.



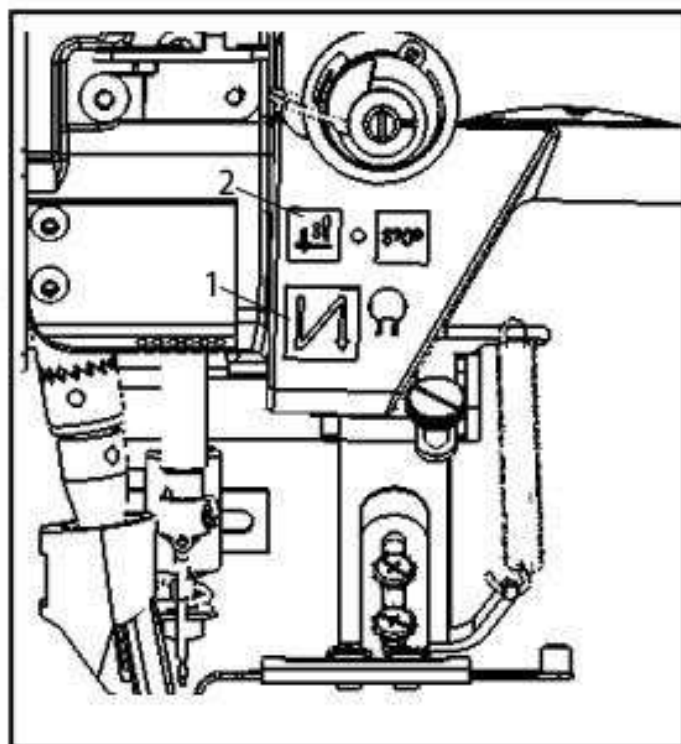
3. 操作件 Controls

3.01 机头按键 Keys on the machine head

在缝纫过程中,只要按下按键 1,机器的缝纫方向就
反转:

按键 2 是用来设置参数的,请详见电控说明书。

As long as key 1 is pressed during
sewing, the machine sews in reverse;
Keys 2 can be used for parameter
settings, Instruction Manual of
Electronic Control.

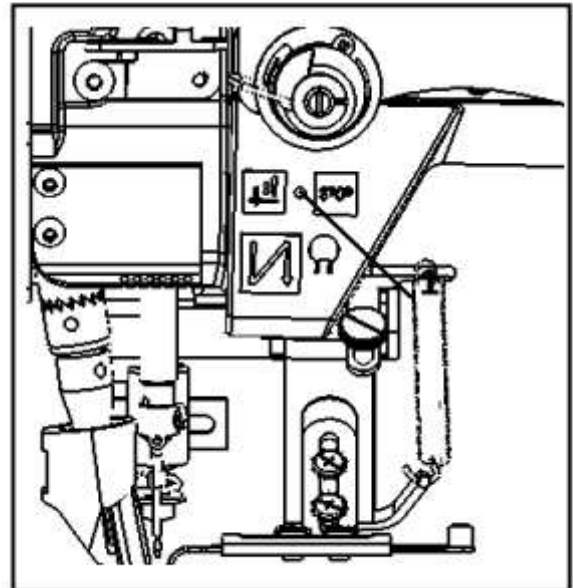


3.02 有线迹计数功能的梭芯线控制器

Bobbin thread monitoring with stitch counting

在达到预设线迹数量前大约 100 个线迹,发光二极管 1 开始闪烁;
在剪线后和更换梭芯后,线迹计数器
就开始计数。

About 100stitches before reaching the
preset number of stitches,diode 1
Flashes;
After the thread has been trimmed and
the bobbin changed the stitch counting
begins anew.



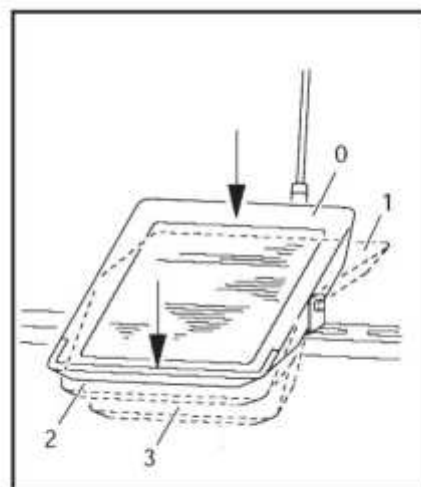
3.03 踏板 Pedal

0=静止位置 Neutral position

1=缝纫 Sewing

2=抬起滚轮压脚 Raiser roller presser

3=剪线 Trim sewing threads

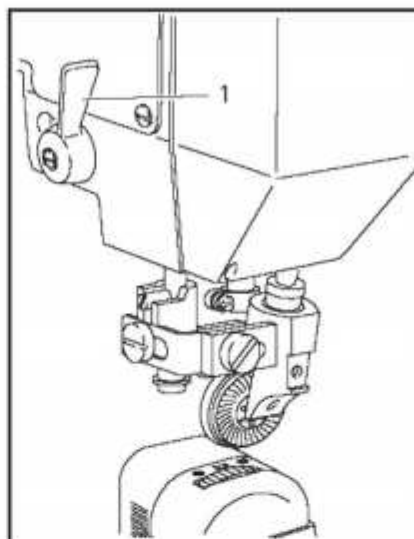


3.04 滚轮压脚扳手

Lever for lifting roller presser

可以通过转动扳手 1 抬起滚轮压脚。

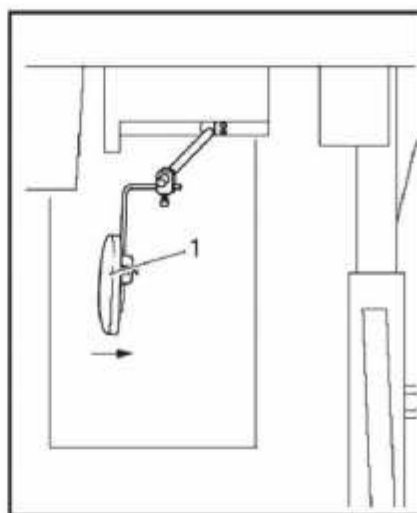
The roller presser can be raised by turning lever 1.



3.05 膝控 Kne lever

可以通过向箭头所示方向挤压膝控杆 1 来抬起滚轮压脚。

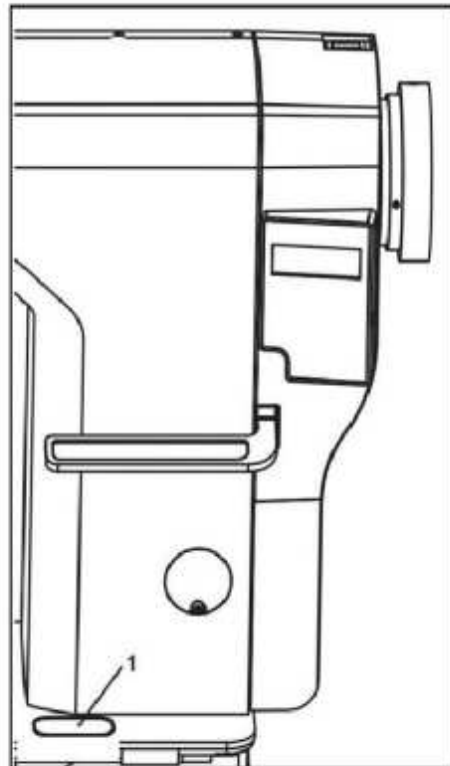
The roller presser can be raised by pressing the knee lever 1 in the direction of the arrow.



3.06 线迹长度设置按键 Key for setting stitch length

通过按下按键 1 旋转手轮来设置线迹长度。

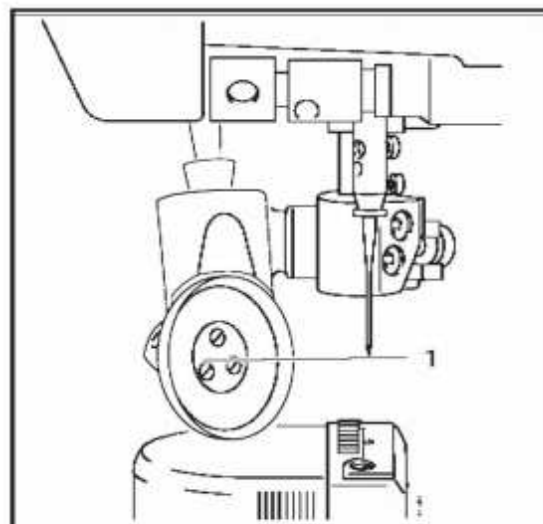
The stitch length is set by pressing
key1 and turning the balance wheel



3.07 滚轮压脚向外摆动 Swing out roller presser

当滚轮压脚抬起后,可以通过向下
轻拉它,使其向外摆动。

When the roller presser is raised,it
Can be swung out by pulling it
lightlydown-wards.



4. 缝纫操作准备 Preparation

必须遵守本说明书中所有的规定和提示,特别要注意所有的安全规定:

所有机器准备工作只允许由受过相应培训的人员完成:

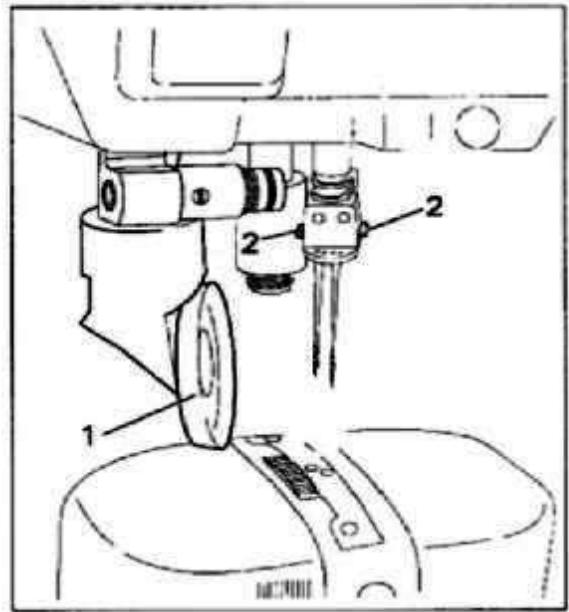
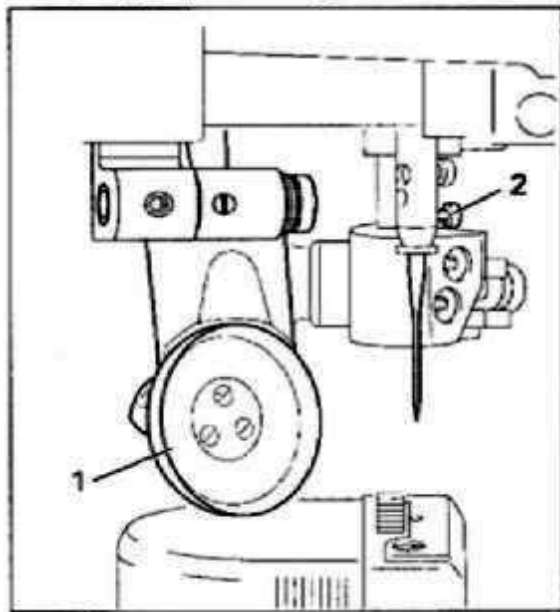
在所有的机器准备工作时,必须通过关闭总开关或者从电源插座上拔出插头,以使机器断电。

All instructions and regulations in this instruction manual must be observed, special attention must be paid to all safety regulations;

All setting-up work must only be carried out by personnel with the appropriate training;

For all setting-up work the machine must be disconnected from its power supply by turning off the on/off switch, or removing the plug from the electric power socket.

4.01 安装机针 Inserting the needle



抬起滚轮压脚 1 并将其向外摆动:

松开螺钉 2 并插入机针,使机针的长槽背对着各自勾线的旋梭(即勾线旋梭在左长槽就向右;勾线旋梭在右,长槽就向左):

拧紧 螺钉 2 并将滚轮压脚摆回到原位置。

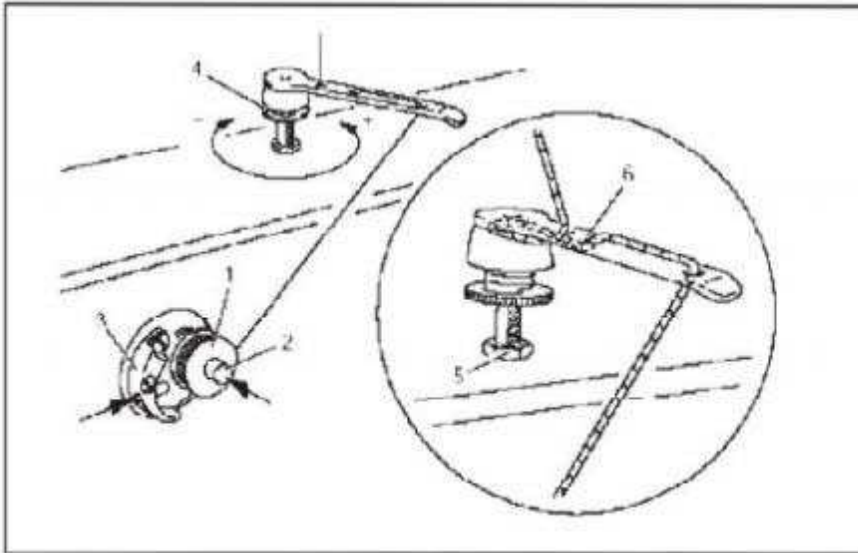
Raise the roller presser 1 and swing it out:

Loosen screws 2 and insert the needle as far as possible, the long groove must be contrary to the hook (if the hook is on the left, the long groove must be on the right).

Tighten screw 2 and swing roller presser 1 back into position.

4.02 绕梭芯线,调整梭芯线的张力。

Winding the bobbin thread,adjusting the thread tension.



将一个空的梭芯 1 安装到绕线器轴 2.上:

如图所示,给梭芯穿线,并将线顺时针方向在梭芯上绕几圈:

同时压下绕线器轴 2 和杠杆 3.启动绕线器。

Place an empty bobbin 1 onto bobbin shaft 2;

Thread the bobbin in accordance with Fig.and wind it anti-clockwise around bobbin 1a few times;

Switch on the bobbin winder while at the same time pressing bobbin winder spindle 2 and lever 3

缝纫过程中的梭芯绕线

在梭芯 1 上的线张力可以用滚花螺母 4 进行调节:

当梭芯绕满线后,绕线器自动停止:

如果绕线不均匀,可以松开螺母 5.

相应转动调整导线板 6 并拧紧螺母 5

The bobbin is up during sewing

The tension of the thread on bobbin 1 can be adjusted with knurled nut 4:

The bobbin winder stops automatically when bobbin 1 is full:

If the thread is wound unevenly,loosen nut 5 and turn thread guide 6 accordingly.Relighten nut 5 after the adjustment

4.03 取出/装入梭壳 Removing/Inserting the bobbin case

关闭机器电源! 有被机器意外地起动伤害的危险!

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

取出梭壳:

打开旋梭盖:

抬起梭门门 1 并取出梭壳 2。

Removing the bobbin case:

Open the post cap:

Raise latch 1 and remove bobbin case 2.

装入梭壳:

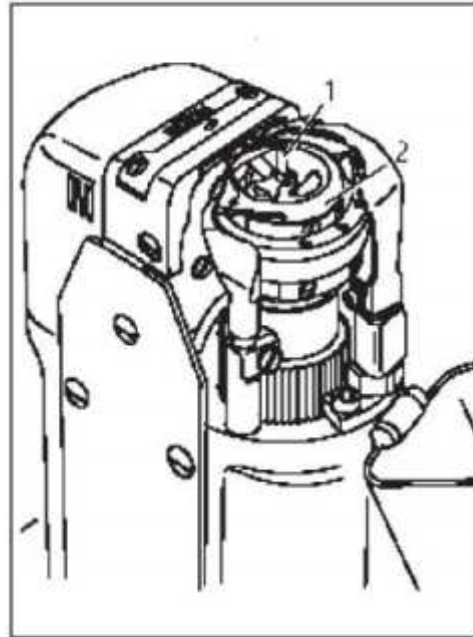
装入梭壳 2:

关闭梭门门 1 并重新合上旋梭盖。

Inserting the bobbin case:

Insert bobbin case 2:

Close the latch 1 and close the post cap.



4.04 梭壳穿线/调节梭芯线的张力 Threading the bobbin case/Adjusting the bobbin threadTension

将梭芯装入梭壳 1 中;

将线穿过弹性压板 2 下的狭槽中;

将线穿过凹口处;

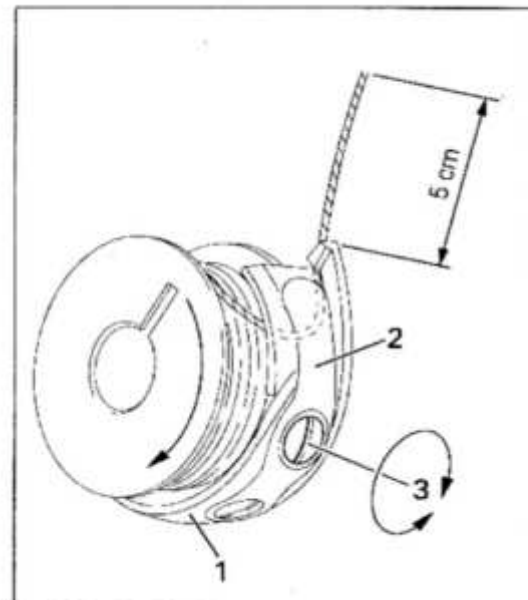
通过旋动螺钉 3 调节梭芯线张力。

Insert the bobbin into the bobbin case;

Pass the thread through the slot under spring 2;

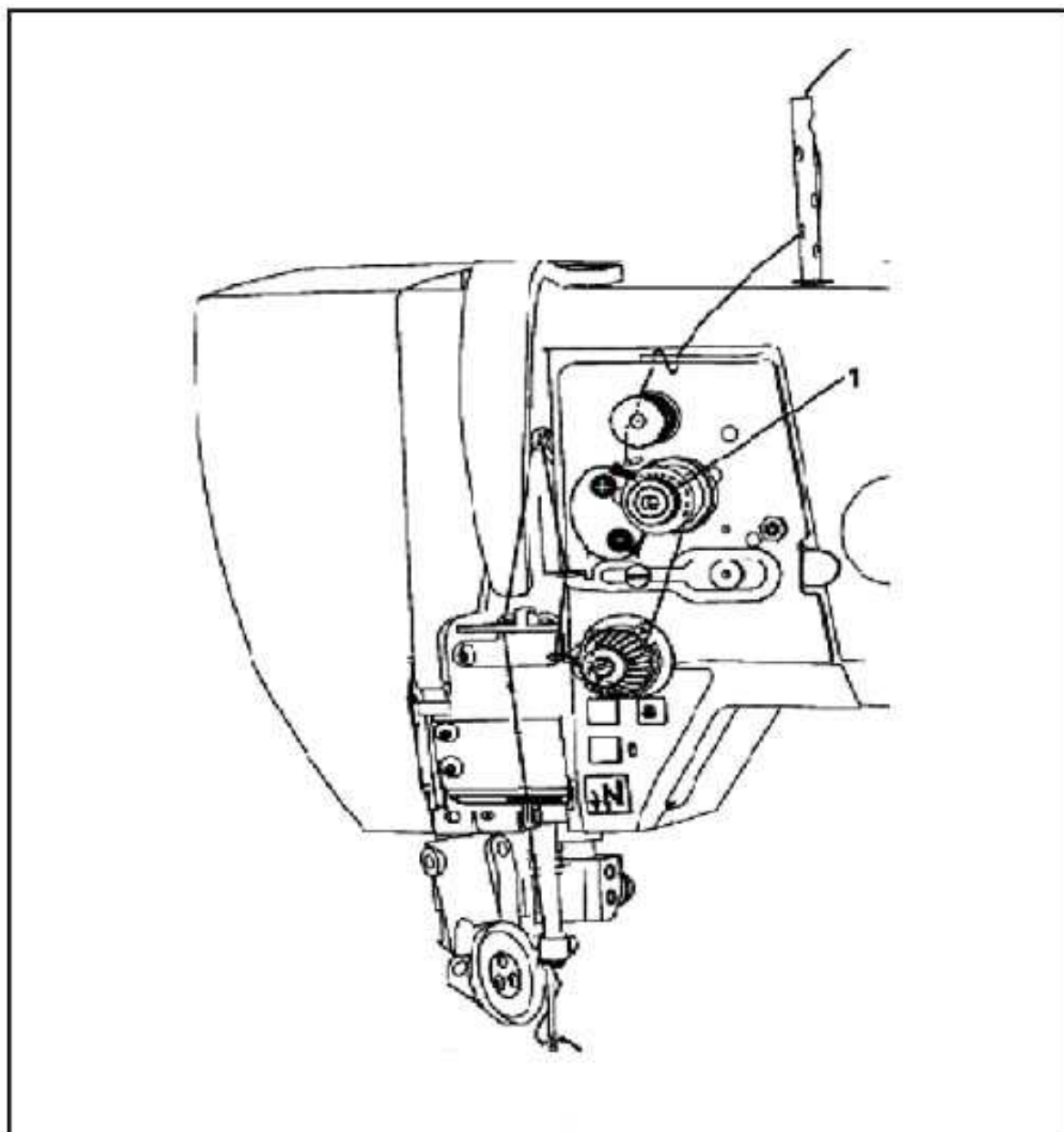
Pass the thread through the notch;

Adjust the thread tension by turningscrew 3.



4.05 单针机型上穿针线并调整针线张力

Threading the needle thread and regulating its tension on the single needle machine on model single needle.



如图所示穿针线：

在左旋梭机型空上,针线是从右向左穿；而在右旋梭机型上,针线冠从左向右穿；
通过转动滚花螺母 1 调节针线的张力

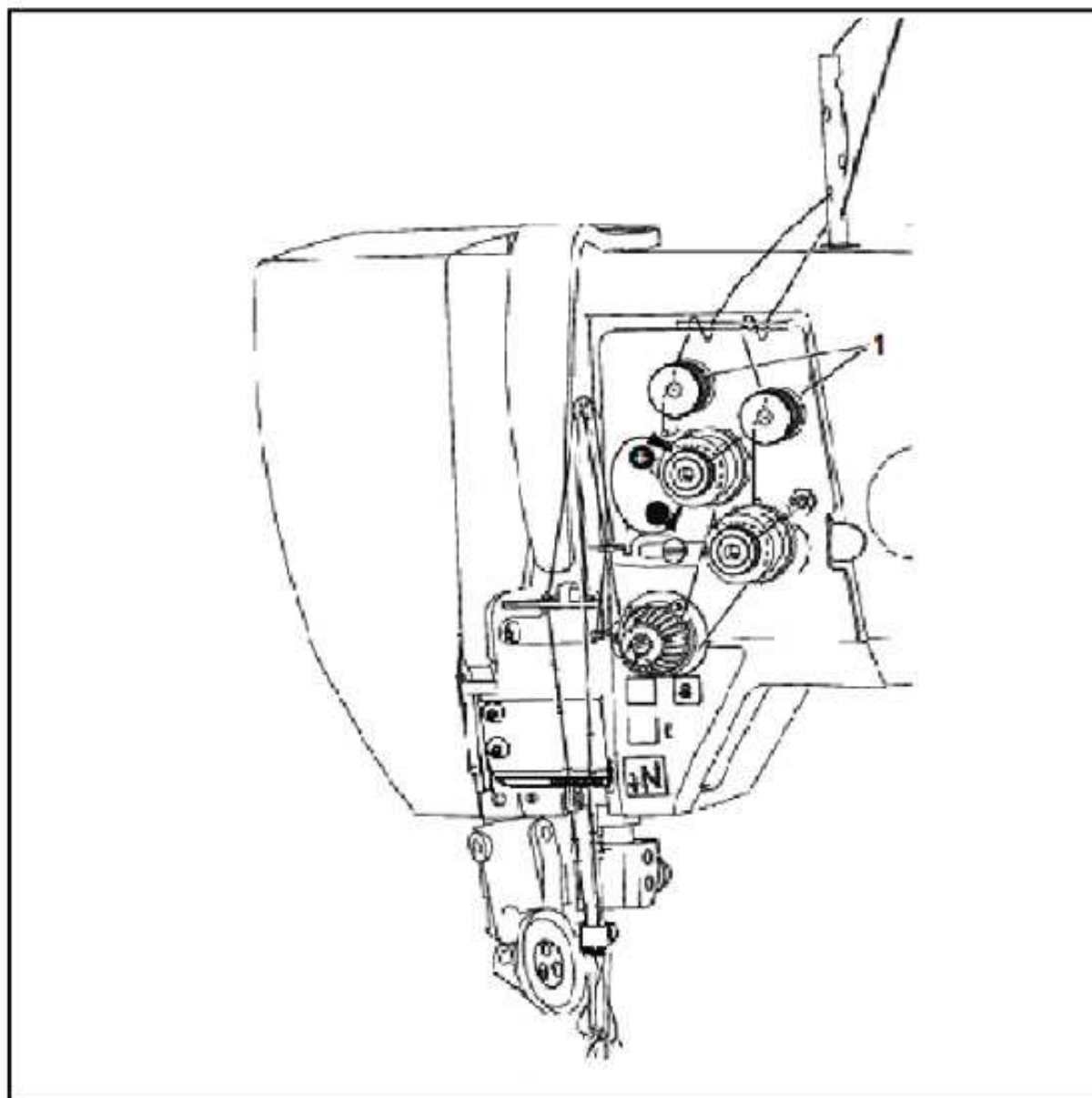
Thread the needle thread as shown in Fig:

on model left hook the needle is threaded from the right to the etiiand on model
light hook from the left to the right;

Adjust the needle thread tension by turning mile rut 1.

4.06 双针机型上穿针线并调整针线张力

Threading the needle thread and regulating its tension on the single medle machine on model double needle.



如图所示穿两个针线:

在左边的机针上,针线是从右向左穿;而在右边的机针上,针线是从左向右穿;

通过转动滚花螺母 1 调节针线的张力。

Thread the needle thread as shown in Fig.;

The left needle is threaded from the right to the left and the right needle from the left to the right;

Adjust the needle thread tension by turning milled nut 1.

维护与保养 Care and Maintenance

清洁.....	每天,如果持续运行时,每天多次
油量检查(线润滑/旋梭润滑).....	每天,开机之前
给旋梭加油.....	每天,开机之前
全齿轮润滑.....	每一次
检查/调节空气压力.....	每天,开机之前
清洁空气滤清器/润滑器的过滤网.....	在需要时

Clean.....	daily, more frequently in continuous operation
Oil level (tread lubrication/hook lubrication).....	daily, before use
Oil the hook.....	daily, before use
Lubricate the bevel gears.....	once a year
Check/adjust air pressure.....	daily, before use
Clean air filter of air filter/lubricator.....	when required



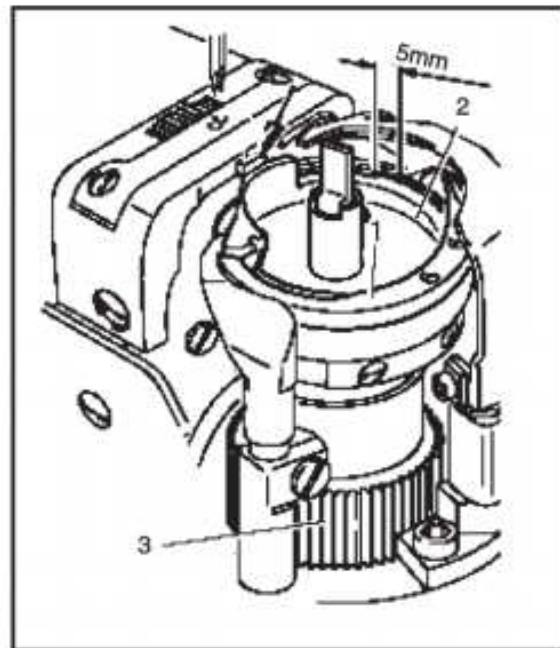
上述的保养间隔是根据每天单班作业的平均机器运行时间设定的。在机器运行时间增加的情况下, 建议缩短保养间隔。

These maintenance intervals are calculated for the average running time of a single shift operation. If the machine is operated more than this, shorter intervals are recommended.

5.01. 清洁 Cleaning

每天清洁旋梭,旋梭腔和齿轮 3,如果持续运行时,每天清洁多次。
Clean the hook, hook compartment and toothed wheel 3 every day.
several times if in continuous use.

关闭机器电源;
将针杆升到最高位置;
打开旋梭盖,取出梭壳和梭芯;
拧松内梭头舌 1 的螺钉;
转动手轮,直到梭壳 2 的尖端进入旋梭的
导槽内大约 5mm;
取出梭壳 2;
用石蜡清洁旋梭槽;
当放入梭壳 2 时,要确信梭壳 2 的凸出鼻
端部分啮合入针板的凹槽中;
拧紧内梭头舌 1 的螺钉并盖上旋梭盖。

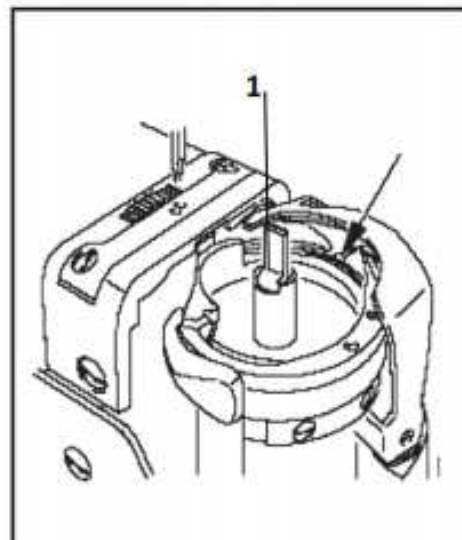


Bring the needle bar to its highest position;
Open the post cap and remove the bobbin case
cap and the bobbin;
Unscrew hook gib 1;
Turn the hand wheel until the point of bobbin case 2 penetrates into the groove of
the hook race approx. 5mm;
Remove bobbin case 2;
Clean the hook race with paraffin;
When inserting the bobbin case 2, ensure that the horn of the bobbin case 2
engages in the groove of the needle plate;
Screw hook gib 1 back on and close the post cap

5.02 给旋梭加油 Oiling the hook

关闭机器电源:
每天注 1-2 滴油到内梭头舌的孔 1 中:
在机器试车前及在长期停机后,注入几滴油到旋
梭的槽中(参见箭头所示)。

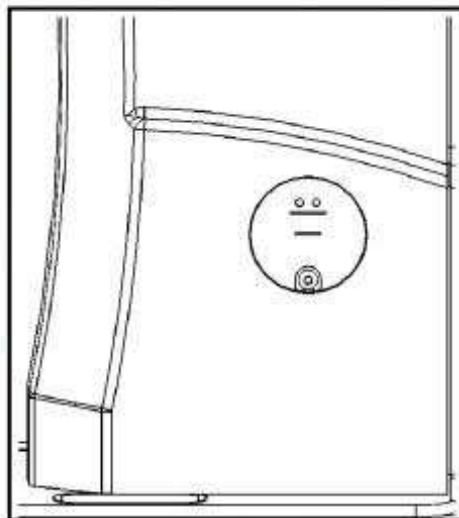
Switch the machine off;
Pour 1-2 drops of oil into hole 1 of the hook gib daily;
Before commissioning the machine, and after long
periods out of operation, pour a few drops of oil
into the hook race (see arrow).



5.03 旋梭润滑油盒 Oil bowl for hook lubrication

在每次开机前检查油量,必须始终保持油盒中有油。
如果需要可通过加油孔加油。只允许使用在 40℃时
平均粘度为 22.0mm/s 和在 15℃时密度为 0.865g/cm³
的润滑油。

Check the oil level before each use ,there must always
be oil in reservoir. If required refill oil through
hole. When refueling to 5CC, the oil level needs oil L cut
line on the plate, add oil to 14cc. When, oil surface and
oil pan H engraved line to. Use only oil with a mean
viscosity of 22.0mm/s at 40℃ C and a density of 0.865
g/cm³ at 15℃.



5.04 给伞齿轮副润滑 Lubricating the bevel gears

关闭机器电源!

所有伞齿轮副每年必须加一次新油脂。

向后翻转机头到支撑件上。

Switch the machine off!

All bevel gears must be supplied with new grease once a year.

Tit the sewing head back onto the support.

如图所示双针机型的伞齿轮副。

涂油脂到齿轮的全部齿侧面(见箭头所示)。

用双手将机头放回垂直位置。

Fig. shows the bevel gears of the double needle machine.

Apply grease to all the tooth flanks and the rack (see arrows).

Use both hands to return the nose to the vertical position.

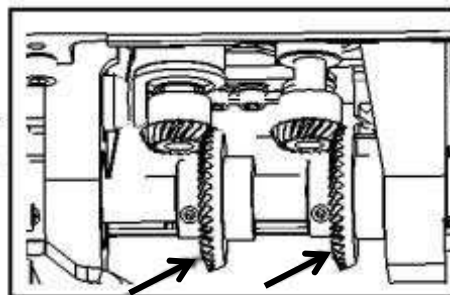
我们推荐使用滴点大约为 150° C 含钠油脂。

We recommend sodium grease with

a dripping point of approx. 150° C

警告: 必须用双手将机头放回垂直位置

有在机头和台板之间被挤伤的危险!



Warning: Use both hands to set the sewing head upright

Danger of rushing between the sewing head and the table top!