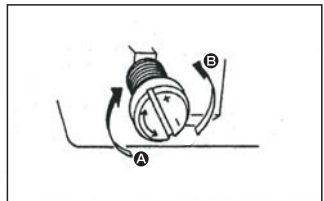


Integrated direct drive computer flat sewing machine

安全上需要特别加以注意的事项。

 Items requiring special attention

- 旋梭油量的调节 /Adjusting the amount of oil supplied to the hook



- 1) 把下轴外套的油量调节螺丝向“+”的方向(Ⓐ方向)转动,油量将变多,向“-”的方向(Ⓑ方向)转动,油量将变少。
- 2) 调整后,应空转30秒钟左右,并进行油量的确认。
- 1)More oil will be supplied as oil amount adjust screw mounted on the hook driving shaft is turned toward "4" in directionⒶ. As oil amount adjust screw is turned toward "- " in directionⒷ, the amount of oil will be decreased.
- 2) After adjusted, the machine must be idling for 30 seconds.It can be confirmed the state of oil supplied.

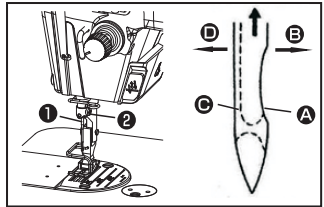
8.机针的安装/ATTACHING THE NEEDLE

注意

为了防止意外的启动造成的事故,请关掉电源后进行。

WARNING

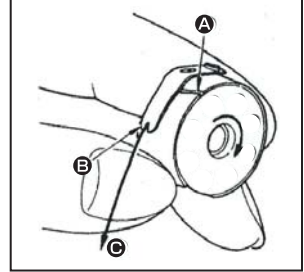
Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



- *标准用针为DB×1#14。机针有各种编号,需根据所用线的粗细和缝料来选择合适的机针。
- 1) 转动飞轮使机针上升到最高位置。
- 2) 旋松机针螺钉Ⓐ,使机针Ⓐ的凹弧部分Ⓐ正对右方向Ⓑ。
- 3) 将机针朝箭头方向插入针杆底部的孔,直到插不进为止。
- 4) 旋紧机针螺钉Ⓐ。
- 5) 务必使机针的长槽Ⓒ正对左方向Ⓓ。

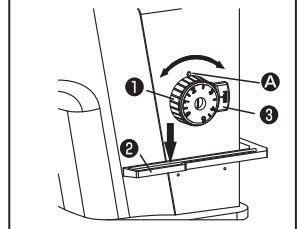
- *A needle of DB×1#14 should be used. Select a proper needle size according to the count of thread and the type of material used
- 1) Turn the handwheel until the needle bar reaches the highest point of its stroke.
- 2) Loosen screwⒶ, and hold needleⒶ with its intended partⒶ facing exactly to the right in directionⒷ.
- 3) Insert the needle in direction of the arrow until it will go no further.
- 4) Securely tighten screw.
- 5) Check that long grooveⒸ of the needle is facing exactly to the left in directionⒹ.

9.梭心的安装方法/SETTING THE BOBBIN INTO THE BOBBIN CASE



- 1) 把线穿过梭壳的线槽Ⓐ,朝Ⓑ方向拉出,将线通过夹线簧下从线孔Ⓒ引出。
- 2) 拉底线Ⓒ,确认梭心是否按箭头方向转动。
- 1) Pass the thread through thread slitⒶ, and pull the thread in directionⒷ.By so doing, the thread will pass under the tension spring and come out from notchⒸ.
- 2) Check that the bobbin rotates in the direction of the arrow when threadⒸ is pulled.

10.针距的调节/ADJUSTING THE STITCH LENGTH



- 1) 按下针距旋钮卡扣Ⓑ,同时将针距旋钮Ⓐ按箭头方向转动,旋至所需针距对应数字对准机壳上的刻点Ⓐ。
- 2) 当需要缩短针距时,需同时将送料扳手Ⓒ朝箭头方向下压后,再按 1) 方式转动针距旋钮。
- 1) Push the fastenerⒷ, turn stitch length diaⒶ in the direction of the arrow, and align the desired number to marker dotⒶ on the machine arm.
- 2) When you want to decrease the stitch length, turn stitch length dia while pressing feed leverⒸ in the direction of the arrow.

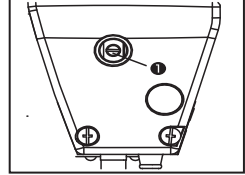
11.压脚高度的调节/ADJUSTING THE HEIGHT OF THE PRESSER BAR

注意

为了防止意外的启动造成的事故,请关掉电源后进行。

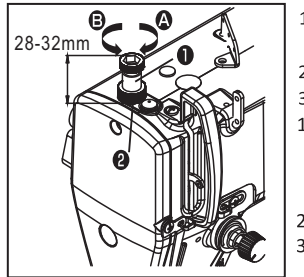
WARNING

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



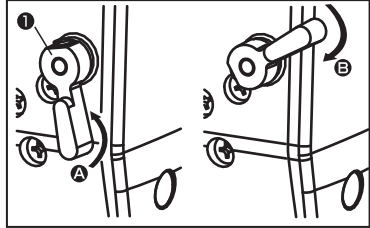
- 1) 旋松压杆导架紧固螺钉Ⓐ,调节压杆高度和角度
- 2) 调节后,拧紧紧固螺钉。
- 1) Loosen set screwⒶ, and adjust the presser bar height or the angle of the presser foot.
- 2) After adjustment, securely tighten the setscrew.

12.压脚压力的调节/PRESSER FOOT PRESSURE



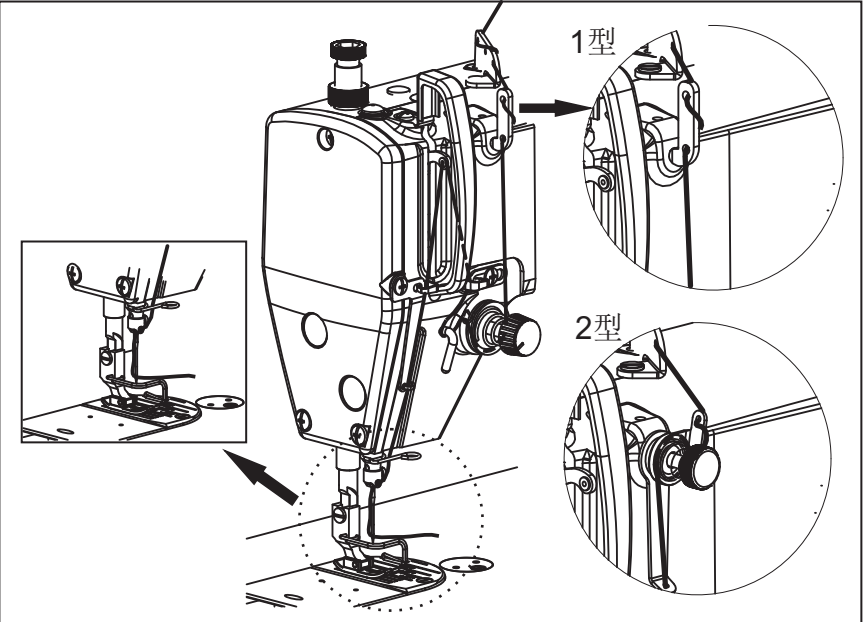
- 1) 旋松调压螺母Ⓑ。顺时针(即Ⓐ向)转动调压螺杆Ⓐ,压力将增大,逆时针(即Ⓑ向)转动调压螺杆,压力将减小。
- 2) 调节后,旋紧调压螺母Ⓑ。
- 3) 对于一般布料,调压螺杆标准高度为28-32mm。
- 1) Loosen nutⒷ. As you turn presser spring regulatorⒶ clockwise (in directionⒶ), the presser foot presser will be increased.As you turn presser spring regulator counterclockwise (in directionⒷ) the presser foot presser will be decreased.
- 2) After adjustment, tighten nutⒷ.
- 3) For general fabrics, the standard height of presser spring regulator is 28 to 32mm.

13.关于手提压脚扳手/HAND LIFTER

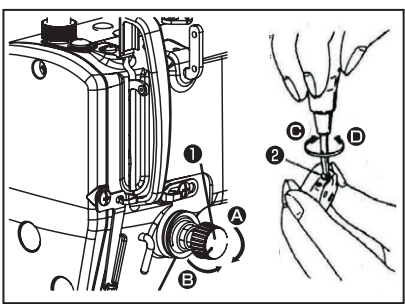


- 1) 停车后,将压脚扳手Ⓐ朝Ⓐ方向转动,使压脚抬起。
- 2) 手提压脚的抬起量约5-6mm。
- 3) 将压脚扳手Ⓐ朝Ⓑ方向转动,压脚将放下至原来位置。
- 1) Turn hand lifterⒶ in directionⒶ to lift the presser foot up.
- 2) The presser foot will go up to 5-6mm.
- 3) The presser foot will go back to its original position when hand lifterⒶ is turned down in directionⒷ.

14.面线的穿法/THREADING THE MACHINE HEAD

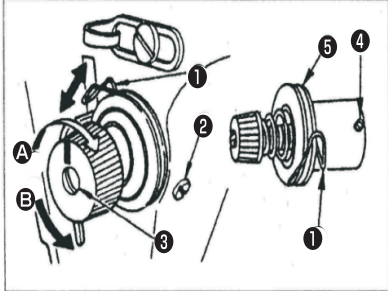


15.缝线张力/THREAD TENSION



- 1) Adjusting the needle thread tension
- ①.As you turn nutⒶ clockwise(in directionⒶ), the needle thread tension will increase.
- ②.As you turn nutⒶ counterclockwise(in directionⒷ), the needle thread tension will decrease.
- 2) Adjusting the bobbin thread tension
- ①.As you turn tension adjust screwⒶ clockwise(in directionⒷ), the bobbin thread tension will increase.
- ②.As you turn tension adjust screwⒶ counterclockwise(in directionⒹ), the bobbin thread tension will decrease.

16.挑线簧/THREAD TAKE-UP SPRING



- 1) Changing the stroke of thread take-up spring
- ①.Loosen setscrewⒶ.
- ②.As you turn tension postⒷ clockwise (in directionⒶ), the stroke of the thread take-up spring will be increased.
- ③.As you turn tension postⒷ counterclockwise (in directionⒷ), the stroke of the thread take-up spring will be decreased.
- 2) Adjusting the bobbin thread tension
- ①.Loosen setscrewⒶ, and remove thread tension(asm)Ⓑ.
- ②.Loosen setscrewⒶ.
- ③.As you turn tension postⒷ clockwise (in directionⒶ), the pressure will be increased.
- ④.As you turn tension postⒷ counterclockwise (in directionⒷ), the pressure will be decreased.

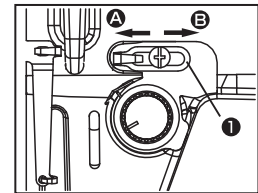
17.挑线杆挑线量的调整/ADJUSTING THE THREAD TAKE-UP STROKE

注意

为了防止意外的启动造成的事故,请关掉电源后进行。

WARNING

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



- 1) 缝制厚料时,向左Ⓐ的方向移动右线钩Ⓐ,以增加挑线量。
- 2) 缝制薄料时,向右Ⓑ的方向移动右线钩Ⓐ,以减小挑线量。
- 1) When sewing heavy-weight materials, move thread guideⒶ to the right (in directionⒶ) to increase the length of thread pulled out by the thread take-up.
- 2) When sewing light-weight materials, move thread guideⒶ to the left (in directionⒷ) to decrease the length of thread pulled out by the thread take-up.

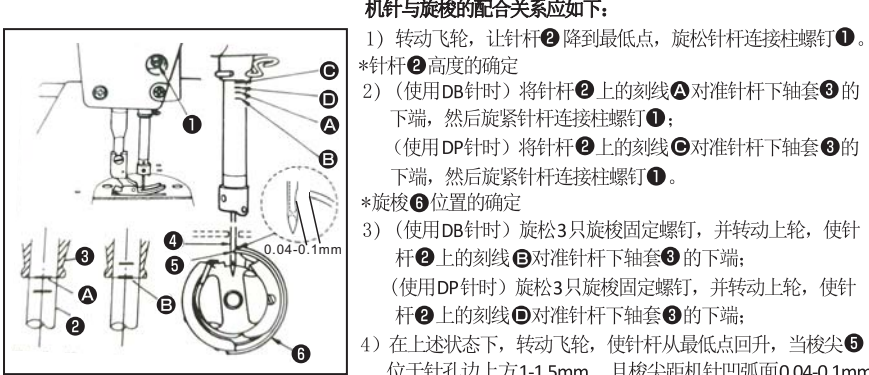
18.机针与旋梭的关系/NEEDLE-TO-HOOK RELATIONSHIP

注意

为了防止意外的启动造成的事故,请关掉电源后进行。

WARNING

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



- 机针与旋梭的配合关系应如下:
- 1) 转动飞轮,让针杆Ⓐ降到最低点,旋松针杆连接柱螺钉Ⓐ。
- *针杆Ⓐ高度的确定
- 2) (使用DB针时)将针杆Ⓐ上的刻线Ⓐ对准针杆下轴套Ⓑ的下端,然后旋紧针杆连接柱螺钉Ⓐ;
- (使用DP针时)将针杆Ⓐ上的刻线Ⓐ对准针杆下轴套Ⓑ的下端,然后旋紧针杆连接柱螺钉Ⓐ。
- *旋梭Ⓒ位置的确定
- 3) (使用DB针时)旋松3只旋梭固定螺钉,并转动上轮,使针杆Ⓐ上的刻线Ⓐ对准针杆下轴套Ⓑ的下端;
- (使用DP针时)旋松3只旋梭固定螺钉,并转动上轮,使针杆Ⓐ上的刻线Ⓐ对准针杆下轴套Ⓑ的下端;
- 4) 在上述状态下,转动飞轮,使针杆从最低点回升,当梭尖Ⓒ位于针孔边上方1-1.5mm,且梭尖距机针凹弧面0.04-0.1mm时(同时保证梭尖Ⓒ对准机针Ⓐ的中心),锁紧旋梭螺钉。

注意

为了防止意外的启动造成的事故,请关掉电源后进行。

WARNING

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

调整的时间应在针杆和钩如下:

1) Turn the handwheel to bright the needle barⒶ down to the lowest point of its stroke, and loosen setscrewⒶ.

*Adjusting the height of the needle bar height

2) (For a DB needle) Align marker lineⒶ on needle barⒶ with the bottom end of needle bar lower bushingⒷ, then tighten setscrew

(For a DP needle) Align marker lineⒶ on needle barⒶ with the bottom end of needle bar lower bushingⒷ, then tighten setscrew

*Adjusting the position of the hook

3) (For a DB needle) Loosen the screw of the rotary shuttleAlign marker lineⒶ on needle barⒶ with the bottom end of needle bar lower bushingⒷ.

(For a DP needle) Loosen the screw of the rotary shuttleAlign marker lineⒶ on needle barⒶ with the bottom end of needle bar lower bushingⒷ.

4) Rotate the flywheel when the needle rod rises from the lowest point,lock the screw of the rotary shuttle when the tip of the rotary shuttleⒶ is 1-1.5mm above the edge of the needle hole ,and the plane of the shuttle tip is 0-0.1mm from the plane of the short groove of the needle (ensure that the shuttle tipⒶ is at the center line of the needleⒶ).

*If the clearance is too small, the tip of the hook will be abraded. If it is too big, it will lead to skip over.

*Note that the type of hook to be substituted for,when replacing the hook.

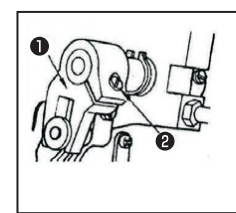
19.送料牙的高度/HEIGHT OF THE FEED DOG

注意

为了防止意外的启动造成的事故,请关掉电源后进行。

WARNING

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



- 调节送布牙的高度:
- 1) 拧松抬牙叉形曲柄Ⓐ的紧固螺钉Ⓐ。
- 2) 上下移动送料牙进行调节。
- 3) 调节完后,拧紧紧固螺钉Ⓐ。
- *If the clamping pressure is insufficient, the motion of the forked portion becomes heavy.

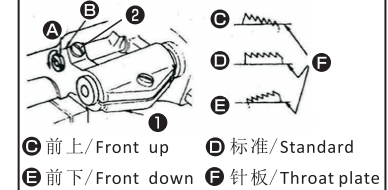
20.送料牙的倾斜度/TILT OF THE FEED DOG

注意

为了防止意外的启动造成的事故,请关掉电源后进行。

WARNING

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



- 1) 标准倾斜度(水平)是牙架销的刻点Ⓐ与牙架座Ⓐ的Ⓑ部一致,送料牙与针板保持平行的位置。
- 2) 为了防止布料褶皱,前上抬起送料牙时,拧松螺钉Ⓐ,将螺丝刀插入牙架销,按箭头方向旋转90°。
- 3) 为了减少料的倾斜,前下降送料牙时,拧松螺钉Ⓐ,将螺丝刀插入牙架销,按箭头方向相反旋转90°。

注意

为了防止意外的启动造成的事故,请关掉电源后进行。

WARNING

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

调节了送料牙之后,送料齿的高度会有变化,请再次确认。

1) The standard tilt (horizontal) of the feed dog is obtained when marker dotⒶ on the feed bar shaft is aligned with markerⒷ on feed rockerⒶ.The feed dog and the throat plate are parallel to each other as standard

2) To tilt the feed dog with its front up in order to prevent puckering, loosen the setscrew, and turn the feed bar shaft 90° in the direction of the arrow, using a screwdriver.

3) To tilt the feed dog with its front down in order to prevent uneven material feed, turn the feed bar shaft 90° in the opposite direction from the arrow.

*Whenever the feed dog tilt is adjusted, the feed dog height will be changed. So it is necessary to check the height after tilt adjustment.

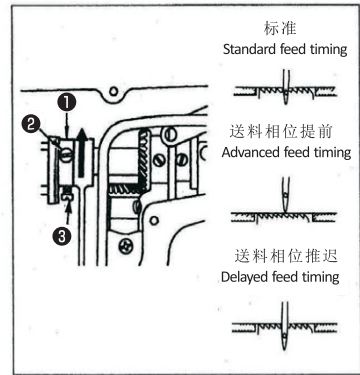
21.送料相位的调节/ADJUSTING THE FEED TIMING

注意

为了防止意外的启动造成的事故,请关掉电源后进行。

WARNING

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



- 1) 拧松送料偏心凸轮Ⓐ的固定螺钉Ⓐ、Ⓑ,朝箭头方向或反方向移动送布偏心凸轮,然后拧紧固定螺钉。
- 2) 标准调节位置是送料牙从针板下落时,送布牙上面与针孔下端对准针板上面的位置。
- 3) 提早送布相位以防止布料偏斜时,请向箭头方向移动送料偏心凸轮。
- 4) 为了良好的紧线而推迟相位时,请向逆箭头方向移动送料偏心凸轮。

注意

为了防止意外的启动造成的事故,请关掉电源后进行。

WARNING

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

1) Loosen screwsⒶ andⒷ in feed eccentric camⒶ, move the feed eccentric cam in the direction of the arrow or opposite direction of the arrow, and firmly tighten the screws.

2) For the standard adjustment, adjust so that the top surface of feed dog and the top end of needle eyelet are flush with the top surface of throat plate when the feed dog descends below the throat plate.

3) To advance the feed timing in order to prevent uneven material feed, move the feed eccentric cam in the direction of the arrow.

4) To delay the feed timing in order to increase stitch tightness, move the feed eccentric cam in the opposite direction from the arrow.

*Be careful not to move the feed eccentric cam too far, or else needle breakage may result.

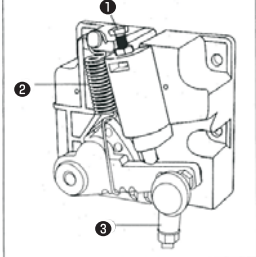
22.踏板压力和行程/PEDAL PRESSURE AND PEDAL STROKE

注意

为了防止意外的启动造成的事故,请关掉电源后进行。

WARNING

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



- 1) 踏板前踩踏压力的调整
- ①.更换拉簧Ⓐ下方钩挂位置,可以调整前踩踏压力。
- ②.把弹簧挂到左侧之后,压力变轻。
- ③.把弹簧挂到右侧之后,压力变重。
- 2) 踏板回弹力的调整
- ①.调整调节螺钉Ⓐ位置,可以调整回弹压力
- ②.拧进调节螺钉则压力变大。
- ③.拧出调节螺钉则压力变小。
- 3) 踏板踩踏行程的调整
- 将连杆Ⓐ插到拨杆右侧的孔里之后,行程将变大
- 1) Adjusting the pressure required to depress the front part of the pedal
- ①.This pressure can be changed by changing the mounting position of the springⒶ.
- ②.The pressure decreases when you hook the spring on the left side.
- ③.The pressure increases when you hook the spring on the right side.
- 2) Adjusting the pressure required to depress the back part of the pedal
- ①.This pressure can be adjusted using regulator screwⒶ.
- ②.The pressure increases as you turn the regulator screw in.
- ③.The pressure decreases as you turn the screw out.
- 3) Adjusting the pedal stroke
- The pedal stroke increases when you insert connecting rodⒶ into the right hole.

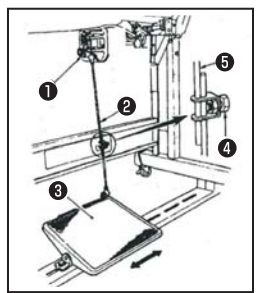
23.踏板的调整/ADJUSTMENT OF THE PEDAL

注意

为了防止意外的启动造成的事故,请关掉电源后进行。

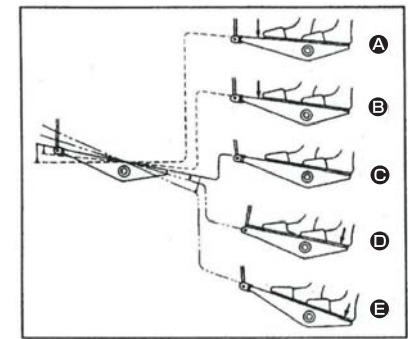
WARNING

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



- 1) 连接杆的安装
- 向箭头方向移动踏板调节板Ⓐ,让踏板拨杆Ⓐ和连接杆Ⓐ呈一直线。
- 2) 踏板的角度
- ①.调节连接杆的长度就可以自由地改变踏板的角度。
- ②.拧松调节螺丝Ⓐ,拉出插入连接杆Ⓐ进行调整。
- 1) Installing the connecting rod
- Move pedalⒶ to the right or left as illustrated by the arrow so that motor control leverⒶ and connecting rodⒶ are straightened.
- 2) Adjusting the pedal angle
- ①.The pedal tilt can be freely adjusted by changing the length of the connecting rod.
- ②.Loosen adjust screwⒶ, adjust the length of connecting rodⒶ.

24.踏板操作/PEDAL OPERATION



- 踏板按4个阶段进行操作。
- 1) 向前轻轻踩踏板为低速缝制Ⓑ。
- 2) 再用用力向前踩踏板则变为高速缝制Ⓐ。但是,开关设定为自动倒缝时,倒缝结束后进行高速缝制。
- 3) 把踏板回到脚踩空地放到踏板上的位置缝制机停止Ⓒ(机针上停止或下停止位置)。
- 4) 用力向后踩踏板则为切线动作Ⓒ。
- *使用自动压脚提升装置时,在停止和切线之间增加1级开关Ⓒ为自动提升压脚动作。
- The pedal operates in four stages
- 1) Step on the pedal slightly forward to sew at a low speedⒷ.
- 2) Press the pedal forward again to change to high-speed sewingⒶ. however,when the switch is set to automatic reverse sewing,high-speed sewing will be performed after the end of reverse sewing.
- 3) Reverse the pedal to the position where the foot is gently placed on the pedal,and the sewing machine stopsⒸ (needle up stop or down stop position).
- 4) Press the pedal backward with force,which is a tangent actionⒸ.
- *When using the automatic presser foot lifting device,a level switchⒸ is added between the stop and the tangent for automatic presser foot lifting.