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使 用 说 明
Operation Manual

开车前的注意事项：
BEFORE OPERATION

1. 油盘内未加油绝不能开车。
2. 机器运转时，从上轮外侧看转向应为逆时针方向。注意，不能倒转。
3. 在第一月中，不要选用大尺寸的电动机皮带轮。
4. 确认电动机标牌上标的电压及相位是否正确。

1. **Never operate the machine unless its oil pan has bas been filled with oil.**
2. **After setting up the machine, check the direction of motor rotation. To check it, turn the handwheel by, hand to bring the needle down, and turn the power switch ON while observing the handwheel. (The handwheel should turn counteclockwise as observed from the handwheel side.)**
3. **Do not use a larger motor pulley for the first one month.**
4. **Confirm that the voltage and phase (single or 3-phase) are correct by checking them against the ratings shown on the motor nameplate.**

使用注意事项：
OPERATION PRECAUTIONS

1. 接通电源开关或机器运转时，请勿将手放到针的下面。
2. 机器运转时，请勿将手指伸入挑线杆护罩内。
3. 机头翻动及拆三角皮带时，一定要切断电机开关。
4. 操作者离开机器时，必须切断电源。
5. 机器运转期间，注意不允许将头或手以及任何东西靠近上轮"V"形皮带、绕线轮和电动机。
6. 拆卸皮带罩、防护罩，或者其它保护装置时，请勿开动机器。
7. 不要用香蕉水等油漆稀释剂擦洗机头表面。

1. **Keep your hands away from the needle when you turn the power switch ON or while the machine is operating.**
2. **Do not put your fingers into the hread take-up cover while the machine is operating.**
3. **Be sure to. turn the power switch OFF before tilting the machine head or removing the V belt.**
4. **When an operator leaves from the machine, make sure to turn off the power.**
5. **During operation, be careful not to allow your or any other person's head or hands to come close to the handwheel, V belt, bobbin winder or motor, Also. do not place anything close to them. Doing so may be dangerous.**

6. **If your machine is provided with a belt cover, finger guard or any other protectors, do not operate your machine with any of them removed.**
7. **Don't clean the face of machine head with thinner.**

1. 机器的安装(图1、图2、图3、图4)
1. INSTALLATION (Fig.1,Fig.2,Fig.3,Fig.4)

・油盘安装：
1) 先将油盘支架❶和油盘座垫❷分别套在油盘❸的四角上，再将油盘❸安装在台板上。
2) 如图所示，安装时要确保两个油盘支架❶朝向操作者一边，两个油盘座垫❷是在有机头连接钩❺的那一侧。
3) 先将机头连接钩座❹安装在台板上，再将机头连接钩❺放入底板孔内，最后将机头放置于台板上，且机头连接钩❺要与台板上的机头连接钩座❹相嵌合。

***Installing the oil pan**

1) Firstly, oil pan holder❶and Oil pan cushion❷should be set in the four corners of the oil pan❸, and then install the oil pan❸on the stand & table.
2) As is shown in the chart, making sure that the two oil holders❶are pointing to the operator during the installation and the two oil pan cushions❷are on the side which is with machine head connecting hook❺.
3) Install the machine head connecting hook base❹on the stand & table, and then put the machine head connecting hook❺in the baseplate hole, at last, put the head on the stand & table, making sure machine head connecting hook❺ is nested in the machine head connecting hook base❹which is on the stand & table.

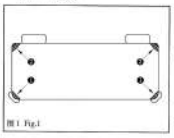


图1 Fig.1

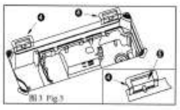


图3 Fig.3

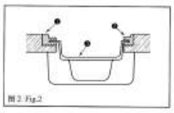


图2 Fig.2

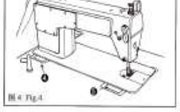


图4 Fig.4

2. 机器的润滑(图5、图6)
2. LUBRICATION (Fig.5, Fig.6)

1. 润滑须知：(图5)
・开车前：
1) 向油盘①内加缝纫机油(10号白油)至HIGH记号部位A。(图5)
2) 当油面低于LOW记号B，应再加油。
3) 加油后，开动机器，应看到油液飞溅到油窗②上，说明润滑正常。
4) 至于飞溅的油量多少与总润滑油量多少无关。
・注意：
使用新机器或者长期未使用过的机器时，应在每分钟1800~2200转的状态下使机器进行十分钟左右的适应性运转。

1. Information on lubrication (Fig.5)

***Before starting the machine**

1) Fill oil pan ② with sewing machine oil (10 white 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 oil 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.

***Precaution**

When you first operate your machine after set up or after an extended period of disuse, run your machine at 1,800 s.p.m. to 2,200 s.p.m. for about 10 minutes for the purpose of break..in.

2. 面部油量采用油线渗油的方法：(图6)

2. The amount of oil supplied to the face plate parts apply the plug of main shaft to control (Fig.6)

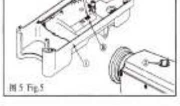


图5 Fig.5

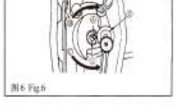


图6 Fig.6

3. 面线的穿法(图7)
3. THREADING THE MACHINE HEAD (Fig.7)

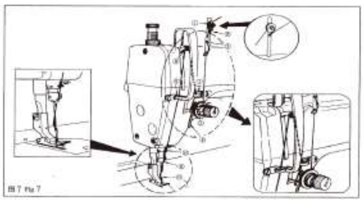


图7 Fig.7

4. 缝线张力(图8)
4. THREAD TENSION (Fig.8)

1. 面线张力的调节：
1) 根据不同的缝制条件，用夹线螺母来调整面线张力。
2) 若把螺母①按顺时针方向（即A方向）转动时，面线张力将增大。
3) 若把螺母①按逆时针方向（即B方向）转动时，面线张力将减小。

2. 底线张力的调节：
1) 将夹线螺钉②朝顺时针方向（即C方向）转动时，底线张力将增大。
2) 将夹线螺钉②朝逆时针方向（即D方向）转动时，底线张力将减小。

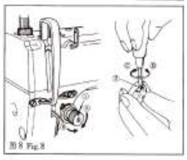


图8 Fig.8

1. Adjusting the needle thread tension

1) Adjust the needle thread tension using tension adjust nut ① according to the sewing specifications.
2) As you turn nut ① clockwise (in direction A), the needle thread tension will increase.
3) As you turn nut ① counterclockwise (in direction B), the tension will decrease.

2. Adjusting the bobbin thread tension

1) As you turn tension adjust screw ② clockwise (in direction C), the bobbin thread tension will increase.
2) As you turn screw ② counterclockwise (in direction D). the bobbin thread tension will decrease.

5. 挑线簧(图9)
5. THREAD TAKE UP SPRING (Fig.9)

1. 改变挑线簧①的振动量：
1) 旋松定位螺钉②。
2) 把夹线螺钉③朝顺时针方向（即A方向）转动时，挑线簧的摆动量将增大。
3) 把夹线螺钉朝逆时针方向（即B方向）转动时，挑线簧的摆动量将减小。

2. 改变挑线簧①的张力：
1) 旋松定位螺钉②，取出夹线器(组件)⑤。
2) 旋送定位螺钉⑥，并转动夹线螺钉③。
3) 把夹线螺钉③朝顺时针方向（即A方向）转动时，挑线簧的张力将增大。
4) 把夹线螺钉③朝逆时针方向（即B方向）转动时，挑线簧的张力将减小。

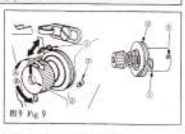


图9 Fig.9

1. Changing the stroke of thread take-up spring ①

1) Loosen setscrew ②.
2) As you turn tension post ③ clockwise (in direction A), the stroke of the thread take-up spring will be increased.
3) As you turn the knob counterclockwise (in direction B), the stroke will be decreased.

2. Changing the pressure of thresd take-up spring ①

1) Loosen setscrew ②, and take out tension asm ⑤.
2) Loosen setscrew ⑥, and remove tension post ③.
3) As you turn tension post ③ clockwise (in direction A), the pressure will be increased.
4) As you turn the post counterclockwise (in direction B), the pressure will be decreased.

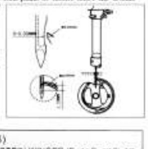
6. 针与旋梭的关系(图10)
6. THE RELATION BETWEEN THE NEEDLE AND THE HOOK (Fig.10)

针与旋梭的关系应配合如下：
1) 转动上轮，使针杆位于最低点，再旋松针杆连接柱定位螺钉。
2) 针杆高度的确定
拉动针杆，水平透过内梭内边缘可看到针孔在1/3-1/2下漏（机针必须安装到位），机针埋线槽朝左，然后旋紧针杆连接柱螺钉。
3) 旋梭位置的确定
先将旋梭梭尖朝上，转动上轮，针杆从最低点回升时，观察旋梭与机针配合关系，当旋梭梭尖位于机针孔边上端1.2mm时且梭尖平面距机针短槽平面0-0.05mm时（保证梭尖位于机针的中心线部位），旋紧旋梭螺钉。

・注意：若间隙太小，会磨损梭尖，若间隙太大，则会引起跳针。
・旋梭原来用什么型号，调换后，也需使用原来的型号。

The relation between the needle and the hook should be as follows;

1) Turn the pulley, make the needle stay the lowest point, then loosen the screw.
2) The height of the needle bar
Pull the needle bar, you can see the pinhole basset 1/3-1/2 level through edge of Inside hook (needle must be position). Turn needle cover wire slot left, then tighten setscrew.
3) The hook position
First move the point of hook in the direction, when running strap pulley needle bar risen from the lowest, Observe cooperate relation of the hook and needle. When hook point above Pinhole about top of 1.2mm and when plane of the hook point form plane of needle short bar 0.05mm (keep the align hook blade point with the center of needle), tighten the hook setscrews.



* Preaution

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. shall be in conformity with the very type of the hook installed in the sewing machine of original assemblage.**

7. 皮带罩绕线器的装法(图11、图12、图13)
7. INSTALLING THE BELT COVER AND THE BOBBIN WINOER (Fig.11,Fig.12,Fig.13)

1. 安装程序：
1) 在台板上钻四只木螺钉导孔A、B、C、D。
2) 将罩壳支柱①装入机壳的螺孔内。
3) 将上轮前罩壳③从后斜方装入，使上轮套过上轮前罩壳③的孔内。
4) 将上轮后罩壳②放置在导孔C D上。
5) 用螺钉和垫圈④⑤⑥，将上轮前罩壳固定在支柱上，此时的螺钉紧固扭矩请控制在螺钉④为30kgfcm，螺钉⑤为25kgfcm，拧紧紧固扭矩超过以上程度，会无效果。
6) 盖上上轮前罩盖板⑦。
7) 将上轮后罩壳②向后方移动，在上轮后罩壳②的橡胶部分碰到上轮前罩壳③时，再移动0.5~1mm，将其用木螺钉和垫圈固定。
8) 用木螺钉将绕线器⑧固定在导孔A和B上。

1.Installing procudure

1) Drill four wooden screw guide holes A, B, C and D in the machine table.
2) Insert support ① in the tapped hole in the arm.
3) Install the front belt cover ③, get the hand wheel in the middle of the hole.
4) Install the back belt cover ② at C and D.
5) Using the screws ④, ⑤ and washer ⑥ fix the front belt cover ③ on the support the tighting torque for the screw ④ is about 30kgfcm, for the screw ⑤ is about 25 kgfcm.
6) Fix the cover ⑦.
7) Move the back belt cover ② backward until its rubber touches the front belt cover ③, then move farther more 0.5-1 mm, fix it using the wooden screws and washers.
8) Fix bobbin winder ⑧ at A and B using the wooden screws.

图11 Fig.11

图12 Fig.12

图13 Fig.13

8. 膝提高度的调节(图14、15 图)
8. ADJUSTING THE HEIGHT OF THE KNEE LIFTER (Fig.14,Fig.15)

1) 用膝提时的标准压脚高度是10毫米。
2) 用膝提调整螺钉①可以调节压脚提升量至13毫米。
3) 当压脚提升量超过10毫米时，不能使处于最低位置的针杆②的底端与压脚③相碰。

1) The standard height of the presser foot lifted using the knee lifter is 10 mm.
2) You can adjust the presser foot lift up to 13 mm using knee lifter adjust screw ①.
3) When you have adjusted the presser foot lift to over 10 mm, be sure that bottom end of needle bar ② in its lowest position does not hit preser foot ③.

图14 Fig.14

图15 Fig.15

9. 规格
9. SPECIFICSTIONS

用途 Application	高速平缝机 HIGH-SPEED LOCKSTITCH
缝料 Sewing material	一般毛料、薄料、中厚料 General materials (light-weight and medium-weight cloth)
缝速 Sewing speed	最大每分钟3000针 [illegible]
线迹长度 Stitch length	5mm (最大) 5mm (max)
压脚提升高度（膝控） Press foot lifting height	13mm (最大) 13mm (max)
机针 Needle	DB×1 #9~#18 (标准为#14) DP×5 #20~#23 (标准为#21)
润滑油 Lubrication oil	10# 白油 10# white oil