

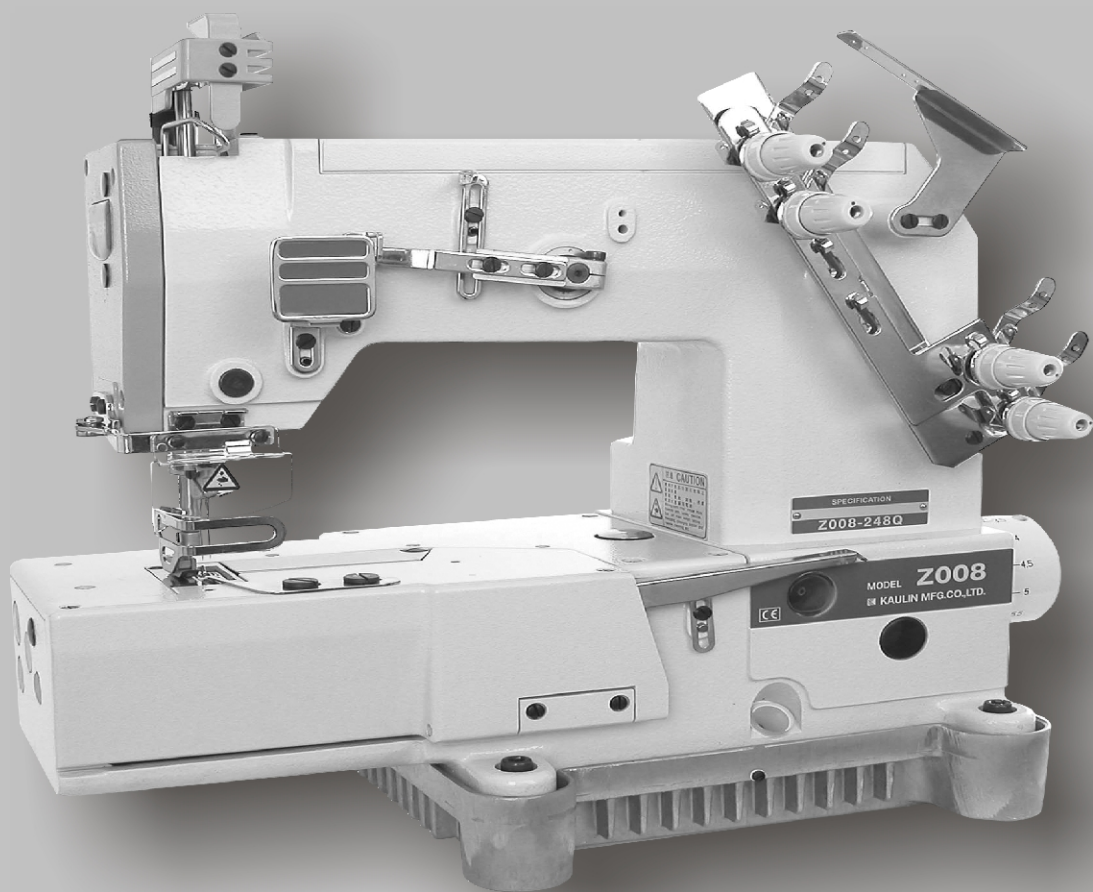
# SIRUBA®

銀箭牌工業用縫紉機

INDUSTRIAL SEWING MACHINE

# Z008

## 使用說明書 INSTRUCTION BOOK



CE



高林股份有限公司  
KAULIN MFG. CO., LTD.

# EC DECLARATION OF CONFORMITY

According to the following EC Directive

Machinery Directive : 98 / 37 / EC , as amended by 89/336/ EEC and 73/23/ EEC.

The undersigned, ROBERT TSAI , representing KAULIN MFG. CO., LTD. 11F 128 Sec. 3 Min Shen E. Road, Taipei , Taiwan ROC., manufacturer, declares that the machine described hereafter :

## Zig-Zag Chain Stitch Machine

Model :Z008

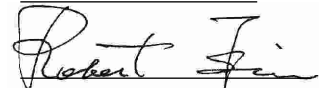
Provided that it is used and maintained in accordance with the generally accepted codes of good practice and the recommendations of the instructions manual, meets the essential safety and health requirements of the Machinery Directive.

For the most specific risks of the machine, safety and compliance with the essential requirements of the Directive has been based on elements of : the European Standard EN 292 - 1 & - 2 : 1992 Safety of machinery ; basic concepts, general principles for design.

The compliance of the model with the requirements of EC Machinery Directive was established by AIB-VINCOTTE Inter n.f.p, Avenue A. Drouart 27-29 , B 1160 , Brussels, Belgium(Notified body under the number 26 for machinery listed in annex IV of EC Machinery Directive ).

Date : SEP. / 15 / 2005

Signature :



Qualification : R&D MANAGER

## General Safety Instructions

**Warning !** When using this machine, basic safety precautions should always be followed to reduce the risk of fire, electric shock and personal injury, including the following.

Read all these instructions before operating this product and save these instructions.

### **1.Keep work area clean.**

Cluttered areas and benches invite injuries.

### **2.Consider work area environment.**

Do not expose power to rain. Do not use machine tools in damp or wet locations. Keep work area well lit. Do not use power tools where there is risk to cause fire or explosion.

### **3.Guard against electric shock.**

Avoid body contact with earthed or grounded surfaces (e.g. pipes, radiators, ranges refrigerators ).

### **4.Keep children away.**

Do not let visitors touch the tool or extension cord.

### **5.Dress properly.**

Do not wear loose clothing or jewelry, they can be caught in moving parts. Wear protecting hair covering to contain long hair.

### **6.Do not abuse the cord.**

Never carry the machine by cord or yank it to disconnect it from the socket. Keep the cord away from heat, oil and sharp edges.

### **7.Maintain machine with care.**

Follow instructions for lubrication and changing accessories. Inspect tool cord periodically and if damaged have it repaired by an authorized serviced facility.

### **8.Disconnect machine**

When not in use, before servicing and when changing accessories.

### **9.Avoid unintentional starting.**

Do not carry a plugged in tool with a finger on the switch. Ensure switch is off when plugging in .

### **10.Check damaged parts.**

Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function.

### **11. Warning.**

The use of any accessory or attachment, other than those recommended in this instruction manual, may present a risk of personal injury.

### **12. Have your tool repaired by a qualified person.**

Repairs should only be carried out by qualified persons using original spare parts.

## **Special Warning For Electric Connection !**

- 1.Incorporate this machine only with "CE" certificate hold-to-run control device.
- 2.Follow the instruction manual device to install control device.
- 3.Always earth machine appropriately during operation.
- 4.Before adjustment, parts change or servicing must be sure to pull out the plug from socket to prevent the hazard of unintentionally start of machine.

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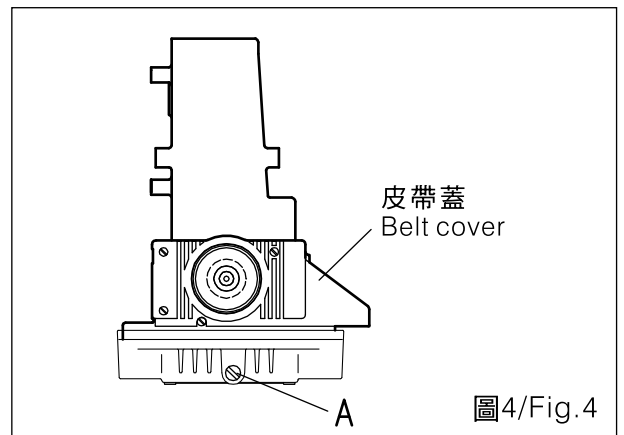
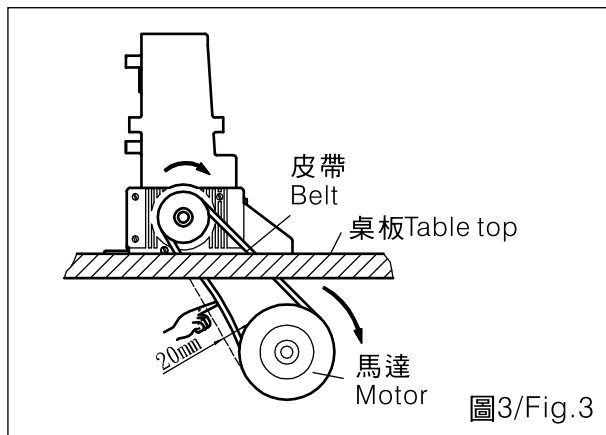
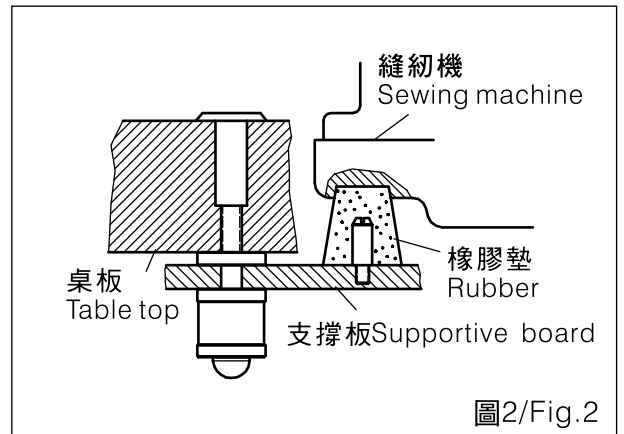
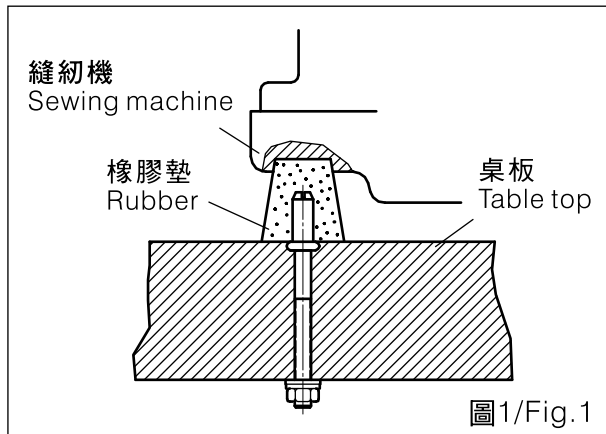


# 安裝

# INSTALLATION

1. 依本機器所附桌板裁製圖及件組合圖所列之配件，依序安裝防震機座，及線架(圖 1.2)。
2. 馬達之轉向為順時針方向，皮帶之鬆緊度以用手指能向內壓20mm為宜，同時為安全起見請皮帶蓋必須鎖上。(圖.3,4)
3. 皮帶輪及縫合轉速。(圖. 5)使用新機器最初一個月運轉速度約為最高速之80%，並請選擇正確的馬達皮帶輪尺寸。

1. Assemble the machine with accessories inside the machine carton step by step. Firstly assemble the rubbers and thread rack. (Fig. 1,2)
2. Motor turns as clockwise. Proper belt tension is 20mm moved by a finger pressing. Besides, for operation safety the belt cover has to be assembled. (Fig. 3,4)
3. Pulley size and motor S.P.M (Fig.5) Machine running speed for the first month of new machines should be 80% of the full speed, and select correct pulley size as (Fig. 5) shows.



| 馬達轉速 Motor (R.P.M) | 馬達皮帶輪的外徑 Pulley size (mm) |      |
|--------------------|---------------------------|------|
|                    | 60Hz                      | 50Hz |
| 3500               | 60                        | 75   |
| 3500               | 60                        | 75   |

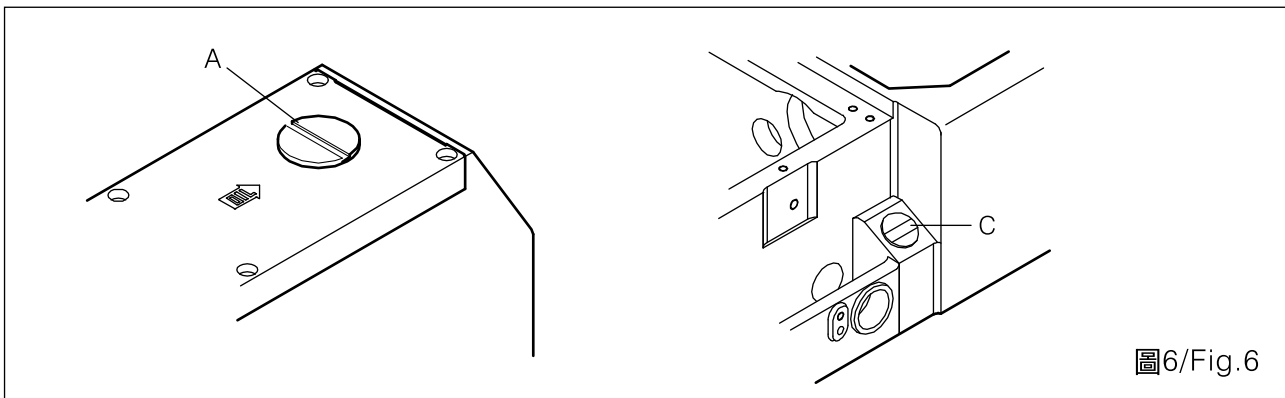
圖5/Fig.5

## 潤滑

- 1.潤滑油之注入- 將(A)旋開，以包裝箱內所附之超高速潤滑油或選用Mobil# 10或ESSO #32 #33等級之潤滑油加入，直至油窗(C)內之=油標線間即可，然後再鎖緊(A). (圖. 6)
- 2.潤滑油之更換
  - (1) 將螺絲(A)鬆開，使油槽之油完全排出後再鎖緊。(圖4)
  - (2) 為延長本機器之壽命，請於開始使用四星期後更換新油，爾後約每四個月更換一次。
  - (3) 濾油器之更換，本機器特別裝有濾油器，約每使用一個月應卸下清洗，必要時得要更換新品。(圖8)

## LUBRICATION

- 1.Lubricator filling Open (A), fill the machine with the lubricator in the accessory box (or Mobil# 10, ESSO#32 and #33) until it reaches sign “=” showed in the glass (A). (Fig. 6)
- 2.Lubricator replacement
  - (1)Loosen screw (A), let the lubricator flow out completely and then tighten it.
  - (2)First lubricator replacement shall be after four weeks, then the replacement will only be needed every four months.
  - (3)Oil filter cleaning and replacement. Please clean the oil filter every month and replace it when it's necessary. (Fig.8)



## 針之更換

- 1.選用針之規格與尺寸，請參照(圖.7)
- 2.旋開螺絲(A)並取下針(圖.9)
- 3.將新針插至含針孔最底端，並使針之凹弧面向自己。
- 4.車針與勾針有密切之關係，如果車針安裝不正確，不但會引起跳針、斷針，還會損壞勾針，所以應充份注意，在更換車針時，應將車針背面的針孔朝向正後方，才行安裝。
- 5.重新鎖緊螺絲(A).

## NEEDLE REPLACEMENT

- 1.For needle Spec. and No., please refer to ( Fig. 7).
- 2.Loosen screw (A) and take off the needle (Fig. 9)
- 3.Insert needle into the needle hole till the end, and make the needle groove face yourself.
- 4.If needle installation is not correct, needle skipping and needle breaking will be caused and looper will be damaged, too. Therefore make needle hole which is at back side of the needle face exactly the machine back side when replacing needle.
- 5.Tighten screw (A)

圖7/Fig.7

|          |                |                |
|----------|----------------|----------------|
| 針規格Spec. | UY 163         | UO 163         |
| 針號 No.   | #9,#11,#12,#14 | #9,#11,#12,#14 |

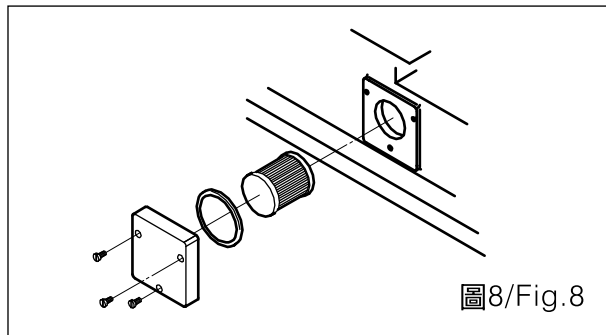


圖8/Fig.8

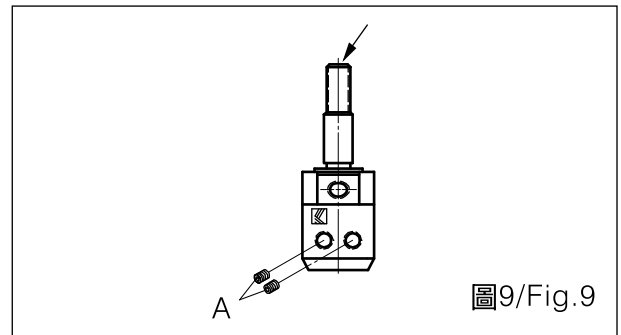


圖9/Fig.9

## 穿線方法

## THREADING

1.請確實按照圖示穿線，錯誤之穿線將會引起斷線，跳針或車縫不平坦等現象。(圖.10)

1.Please thread in accordance with Fig. showed below. Any incorrect threading may cause thread breaking, stitches missing or uneven stitches. (Fig. 10)

註：(1)(2)為上線，(3)(4)均為圈結線，在單針的情形下，則(1)為上線，(3)為圈結線。

NOTES : Thread (1) and (2) are needle threads and (3) and (4) are looper. For single needle machine, thread (1) is for needle and thread (3) is for looper.

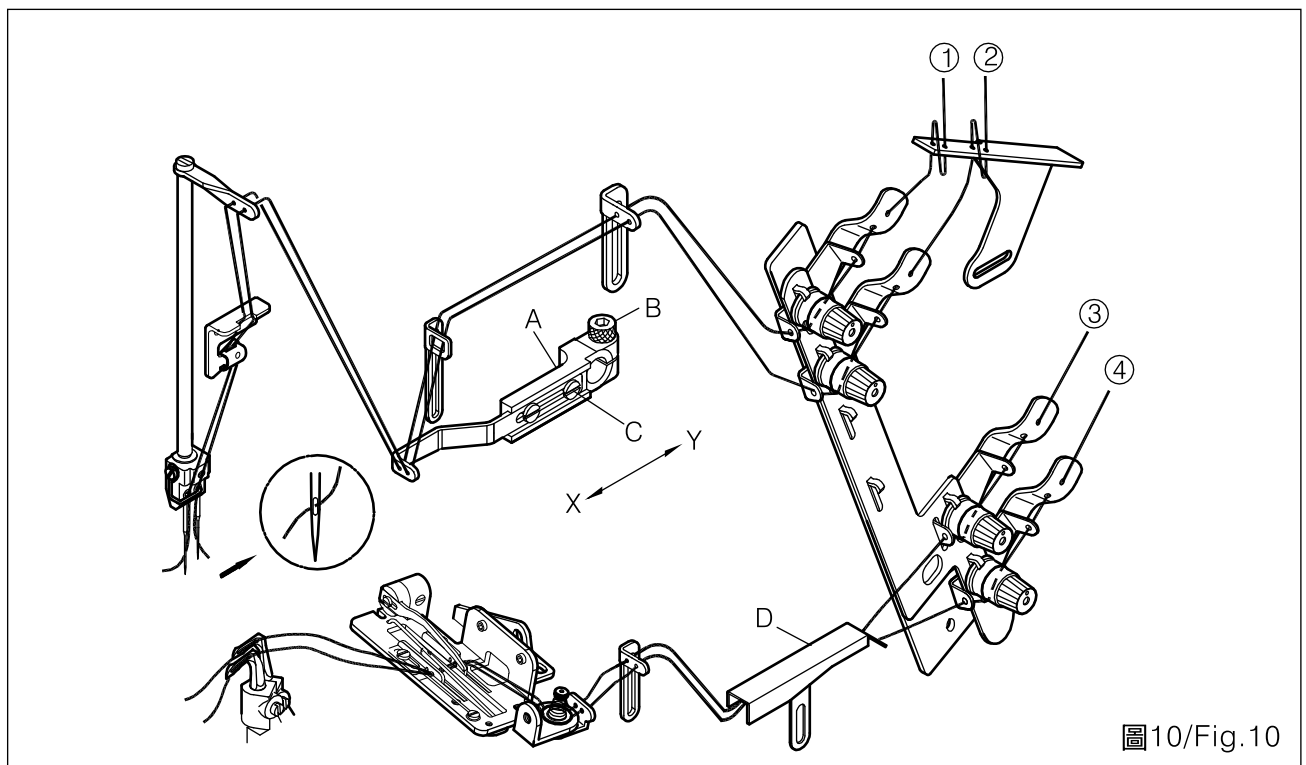


圖10/Fig.10

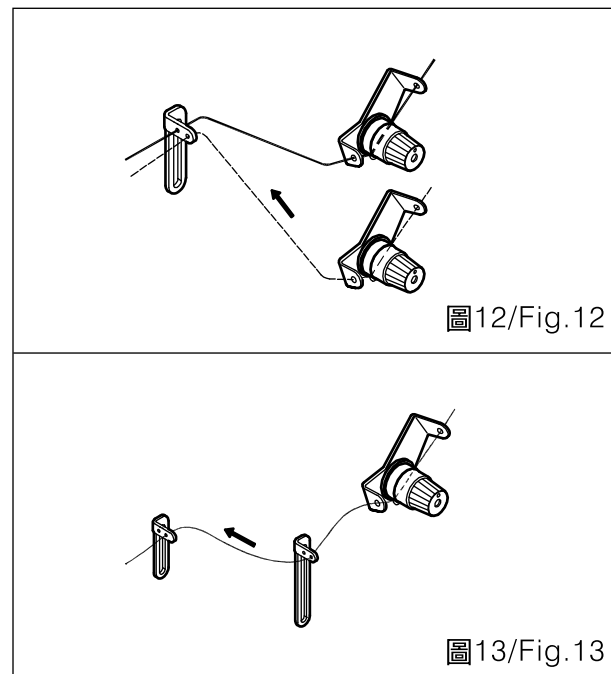
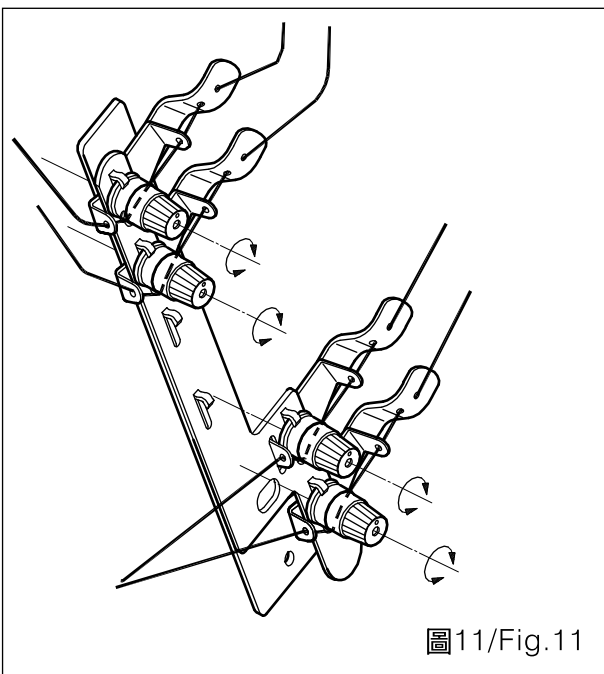


## 控線調整

## THREAD TENSION ADJUSTMENT

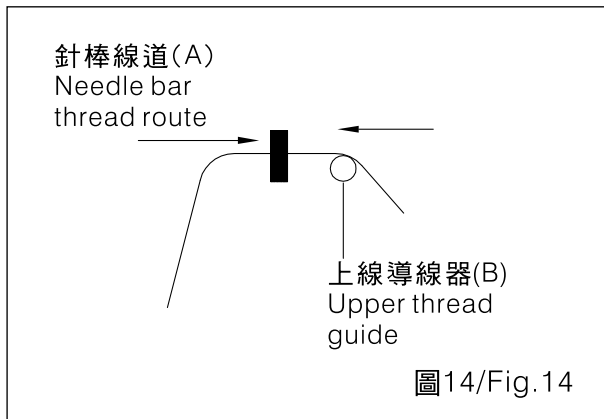
1. 控線強弱必須根據車縫材料種類，厚薄，線的材料，如線徑支數，及縫距等不同，而做不同之調整，其張力在縫紉平整穩定之範圍內應儘可能小，厚布張力大，薄布張力小，伸縮尼龍張力小，棉布張力大。(圖.11)
2. 將控線鈕順時針方向旋轉時，線越緊，張力變大，反之越鬆，張力小，張力超越規格強度時，將會引起斷線和跳針現象。
3. 縫線張力以上線和下線的張力調到下列壓力值為標準。
  - (1). 上線為75g - 90g (紗線，斯潘彈性纖維線，特多龍線等)。(圖.11)  
測量方法-沿著箭頭所指方向，即朝著後面的線道，使張力計朝向縫線張力調整器引出的線而起作用。(圖.12)
  - (2). 下線為8g-15g (30/4紗線，特多龍，尼龍線等)  
測量方法-沿著箭頭所指方向，使張力計有效看出。(圖.13)
    - 鋸齒飾邊的標準用線如下：  
上線為50/3紗線  
下線為30/4，30/5 紗線。
    - 如使上線在允許範圍內儘量拉緊，則裝飾縫的縫跡更為鮮明美觀。

1. Thread tension shall be adjusted according to the stitching materials, thickness, thread materials and stitching length. Thread tension shall be very little for flat fabric. High tension for thick material and cotton thread. Little tension for thin material and nylon thread. (Fig. 11)
2. Turn the thread nod clockwise to increase thread tension and counterclockwise to reduce thread tension. Excessive tension may cause thread breaking and missing stitches.
3. Standard thread tension
  - (1). Upper thread: About 75-90g. (Fig.11)  
Measurement: Measuring along the "arrow" sign. (Fig.12)
  - (2). Lower thread: About 8-15g  
Measurement: Measuring along the "arrow" sign.
    - Standard thread for Single zig-zag decorative edge stitching  
Upper thread: 50/3 thread  
Lower thread: 30/4, 30/5 thread
    - Within tolerance, higher upper thread tension will make better stitching.



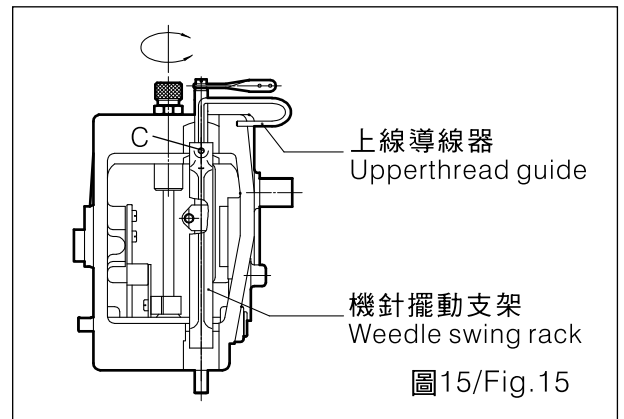
## 上線導線器之調整

1. 當針棒處於下死位置時，應使針棒線道A的線孔中心與上線導線器B的外徑處於同一水平位置。(圖.14)
2. 在上線的線過小時(有伸縮性的線)，應使上線導線器向上移動，而使線圈變大，應鬆開螺絲C而調整上線導線器向上移動。



## ADJUSTMENT OF UPPER THREAD GUIDE

1. When needle bar is at the bottom dead point, the needle bar thread shall be parallel with the out side of upper thread guide B (Fig. 14)
2. If the upper thread loop is too small (ex. Nylon thread), please loosen screw C and move the upper thread guide upward. (Fig. 15)

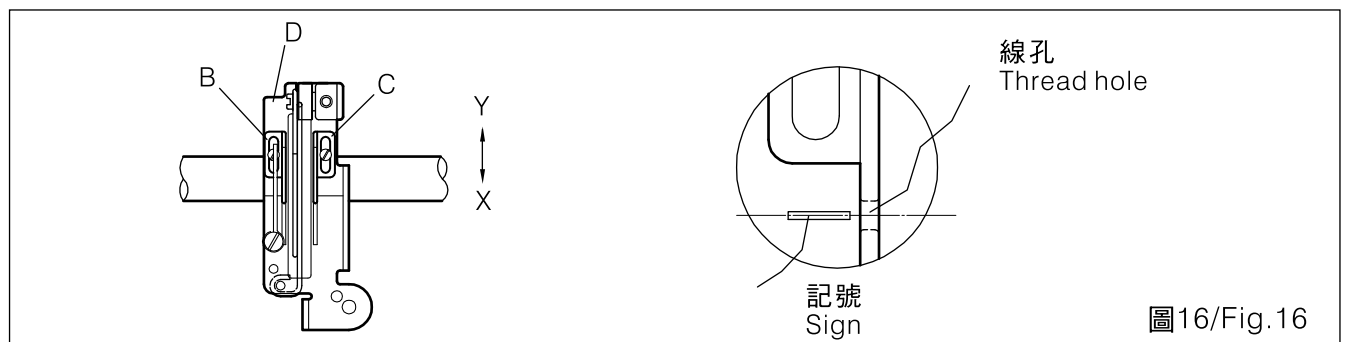


## 圈結縫張力調整

1. 勾針線控片B, C之線孔與支撐板D上的記號成一直線時為標準位置(圖.16)
  - a. 欲增加勾針線量時，控線片B, C往X移動。
  - b. 欲減少勾針線量時，控線片B, C往Y移動。
2. 當勾針回覆往右移，而針也由上往下至勾針背面，與勾針尖底部平行位置時，控線凸輪正好處於最高點H點之位置(圖.17)

## LOOPER THREAD TENSION ADJUSTMENT

1. Looper thread controllers B, C should be parallel with the sign on D. (Fig. 16)
  - a. To increase looper thread-Controllers B, C moved to the X way.
  - b. To reduce looper thread-Controllers B, C moved to the Y way.
2. When looper goes back to the right, needle goes downward at the back side of looper and parallel with the bottom of looper point. The H point of thread cam is at the highest position. (Fig. 17)



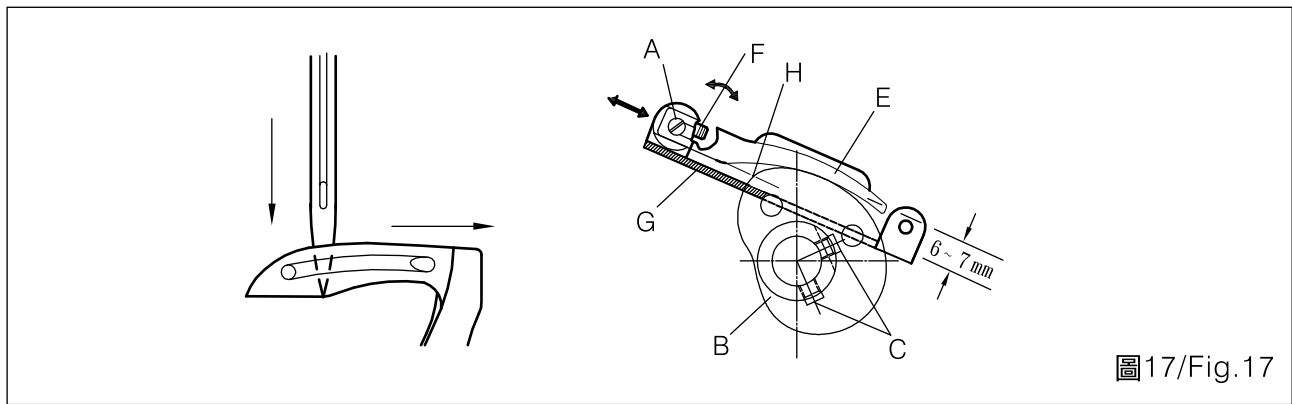


圖17/Fig.17

3. 勾針線導片E之位置，應放鬆螺絲F調整，使勾針導片E之下緣與導板G上之問隙為6-7mm 的位置 (圖.17)

3. The position of looper thread guide E should to loosen screw F to adjust the clearance between the bottom side of looper thread guide E and upper side of G to 6-7 mm.

### 押具壓力強度之調整

### PRESSURE ADJUSTMENT FOR PRESSER FOOT

1. 在布料推送順暢且縫合完美之情況下，押具壓力儘量輕些。(圖.18)
  - A. 鬆開螺母A，轉動螺絲B，調整其適當壓力後再鎖緊螺母A。(圖.18)
  - b. 順時針C方向調整加強壓力，反之D方向則減小。(圖.18)

1. In general, smaller pressure is better. (Fig. 18)
  - a. Loosen nut A, turn screw B to adjust the pressure. Then tighten nut A. (Fig. 18)
  - b. Turn clockwise C direction to increase the pressure. Turn counterclockwise D direction to reduce the pressure. (Fig. 18)

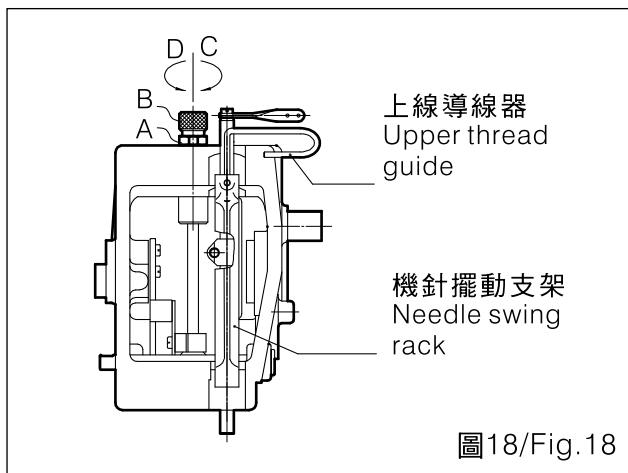


圖18/Fig.18

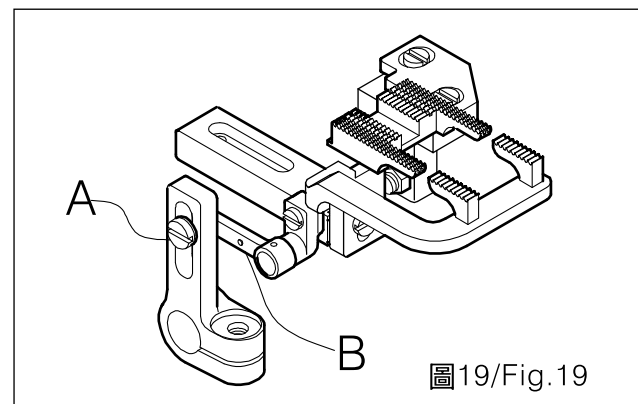


圖19/Fig.19

### 送布量之調整

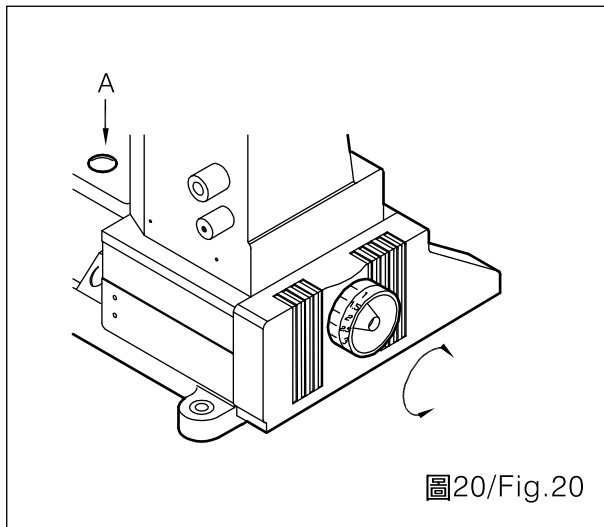
### MATERIAL FEEDING ADJUSTING

1. 調整差動送布量
  - (1). 調整差動送布量時需鬆開連接曲柄的固定螺絲A。(圖.19)
  - (2). 若將連接曲柄B往上移動，則差動量變大，否之往下移動則變小。

1. Adjust differential feed
  - (1). Loosen screw A as showed (Fig. 19)
  - (2). Move parts B up for increasing differential feed. Move it down to reduce.

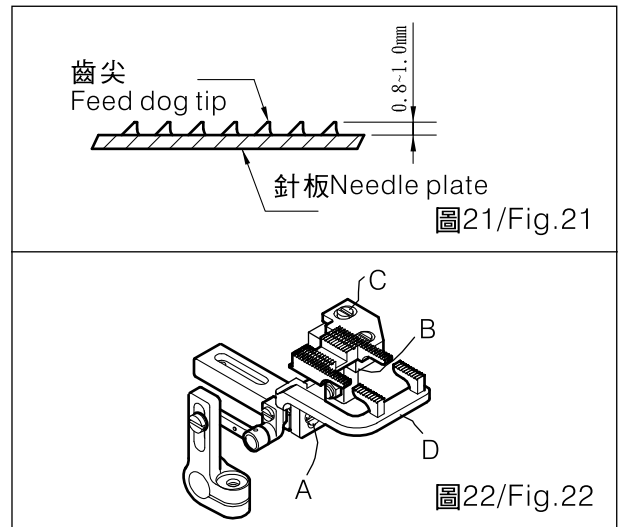
## 2. 調整主送布量

- (1). 用手壓下縫距調整按鈕A，並轉動皮帶輪，使按鈕卡住針距調整組(當聽到一聲，即已扣入)再順時針或反時針轉動皮帶輪至所需之縫距數字後再將手放開此按鈕，欲調大縫距時將皮帶輪順時針方向轉動，反之則小，調整縫距時，馬達需要在停止狀態。(圖20)
- (2). 該縫紉機的縫距數以調整範圍為每吋(25.4mm) 18針-30針。



## 2. Stitch length adjustment

- (1). Pressing button A and turn the hand wheel. When the button A is engaged, turn the hand wheel clockwise to increase stitch length or counterclockwise to reduce stitch length, and then release button A. The adjustment should operate when motor is stop. (Fig. 20)
- (2). Stitch length range is 18-30 stitches / per inch.



## 送具調整

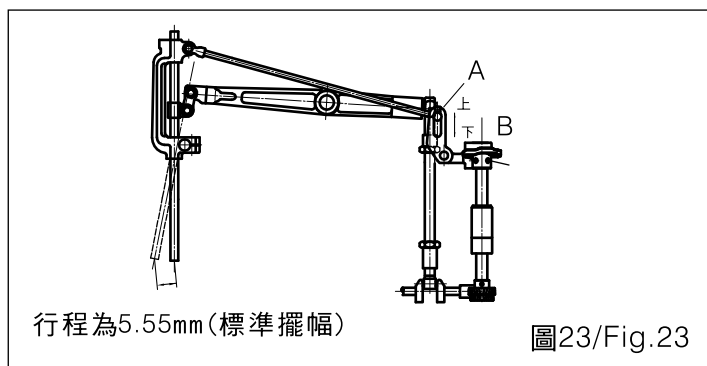
1. 送具C.D升至最高點時，送具齒尖面與針板面之距離為0.8-1.0 mm。(圖.21)
2. 調整:
  - (1).放鬆C. D送具之固定螺絲A. B.
  - (2).上下移動送具C.D使符合上述條件時，再鎖緊螺絲A, B。此時應當心護針片是否正確(請參考護針片之調整)(圖.22)

## FEED DOG HEIGHT ADJUSTMENT

1. When feed dog is at the highest position, clearance between feed dog tip and needle plate is about 0.8-1.0mm (Fig. 21)
2. Adjustment:
  - (1).Loosen screw A & B on feed dog C & D.
  - (2).Adjust feed dogs C & D to proper position, then tighten screw A & B. Beware of needle guard position is correct.(Refer to needle guard adjustment)(Fig. 22)

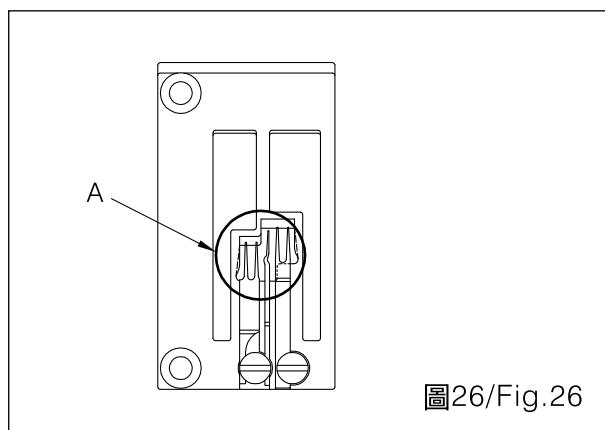
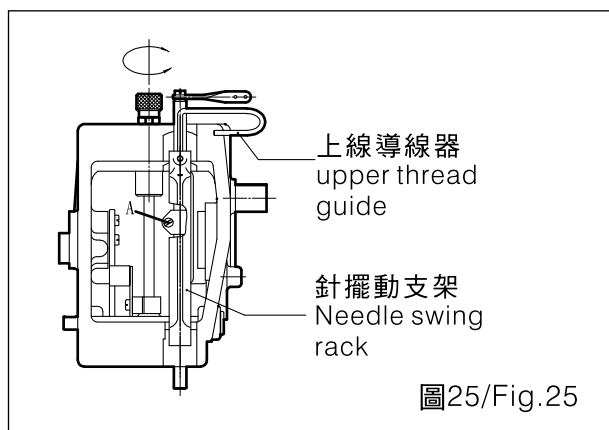
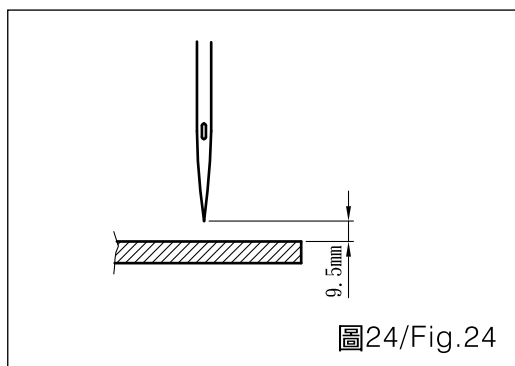
## 針的標準擺幅

該縫紉機的標準擺幅(鋸齒縫寬度)為5.55mm，應鬆開針擺動連接偏心距A之固定螺絲而進行調整，若向上移動則車針擺幅變大，反之向下移動則車針擺幅變小。(圖.23)



## ZIG-ZAG WIDTH

The standard zig-zag width is 5.55mm. For adjustment, loosen screw A, move it up ward to increase the width, or move it downward to decrease the width. (Fig.23)



## 針高度調整

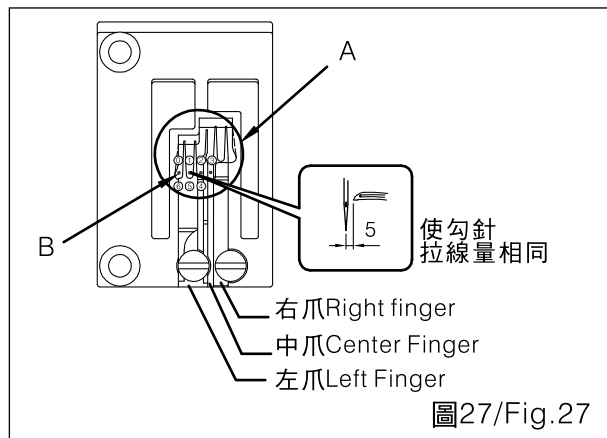
1. 該縫紉機的針棒高度:當針棒在上死點位置時，針板上表面到針端部的距離為9.5mm，應鬆開針棒夾具A的固定螺絲而進行調整之。(圖.24，25)
2. 在調整針棒高度時:應緩緩沿旋轉方向旋轉皮帶輪而使針棒擺動至最高的中心位置時，如A所示，調整使針能落入針板左爪和中爪的中間。(在雙針的情況下，應以左側針進行對準)(圖.26)

## NEEDLE HEIGHT ADJUSTMENT

1. Standard needle bar height: When needle bar is at the up dead point, loosen screw A to adjust the distance between needle tip and needle plate surface to 9.5mm. (Fig. 24, 25)
2. For adjusting needle bar height: Turn the hand wheel slowly to make needle bar at the highest center position, then adjust to make the needle go through the space between left and center needle plate fingers. (For two needle machines, we shall adjust the left needle.) (Fig.26)

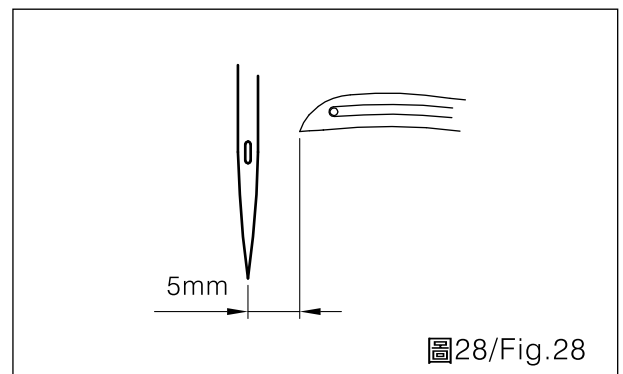
## 針與針板爪的關係

1. 如向視圖A所示，B為落針位置。圖中所記入的針數字是表示縫紉機每旋轉1轉的落針位置。(雙針的情況下，則表示左側針的落針位置)(圖.27)
2. 0, 1, 2, 3是表示皮帶輪旋轉1周而針向右移動1次之位置。4, 5, 6是表示皮帶輪旋轉1周而針向左移動1次之位置。該縫紉機的針擺動以每旋轉6周為一個單元。而回復到原來的落針位置。轉動縫紉機，調整左，右位置使0-6的落針位置能正確落入針板爪的中間。調整時應鬆開圖23B之螺絲調整之。



## NEEDLE AND NEEDLE PLATE FINGERS

1. B indicates the positions which needle will go through. The numbers indicate the stitching sequence. (For two needle machine, it indicates the left needle stitching sequence.) (Fig.27)
2. No. 0, 1, 2, 3 indicate the sequence which needle moves right by every hand wheel turn. 4, 5, 6 indicate the sequence which needle moves left by every hand wheel turn. Six hand wheel turns make one needle moving cycle. Loosen screw B (Fig. 23) to adjust needle zig-zag width and make needle goes through exactly each center between every two needle plate fingers.



## 勾針的拉線量 (針棒處於下死點位置)

### 決定勾針座的位置

1. 在(圖27)0的位置，使勾針端部對準離開針外徑5mm處的位置。(圖.28)
2. 在(圖27)3的位置，也應使勾針端部對準離開針外徑5mm處的位置。(圖.28)
  - A. 在進行上述(1)及(2)項調整時，應鬆開勾針座。如圖30固定螺絲G和束子固定螺絲F，左右移動加以調整。
  - B. 在決定好位置後，應先鎖緊勾針座D之固定螺絲G，再將束子E充份貼緊勾針座的端面，再鎖緊固定螺絲F。

## LOOPER THREAD PULLING (NEEDLE BAR AT THE BOTTOM DEAD CENTER)

### Position of looper set

1. When needle is at the "0" position (Fig. 27), make looper tip 5mm away from the needle (Fig. 28).
2. When needle is at the "3" position (Fig.27), make looper tip 5mm away from the needle (Fig.28)
  - A. Loosen screws G & F (Fig.30) for above (1) and (2) adjustment.
  - B. When the adjustment is done, retighten screw G first, then make parts E exactly next to parts D and retighten screw F.

3. 針與勾針的關係，如(圖27)所示，針向右移動的0位置及3位置，應調整使勾針的拉線量相同。
4. 調整相對於針的勾針拉線量
  - A. 在完成上述(1)及(2)的調整後，應調整勾針的拉線量。調整拉線量時針的落針位置應對準如(圖27)所示之0位置。
  - B. 針在上述位置時，當其運動範圍達到最下點時，勾針應處於其運動範圍的最右端。
  - C. 如(圖28)所示，當其運動範圍在最右端時，勾針端部與針外徑間的距離(相對於針的勾針拉線量)應為5mm。(圖.28)

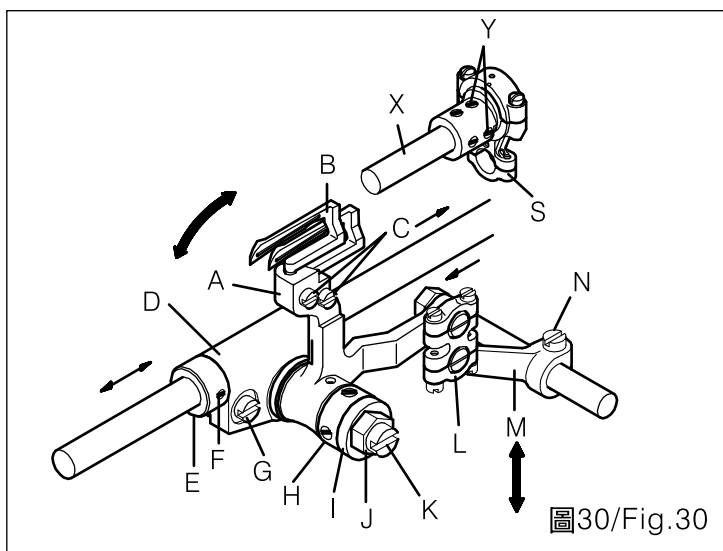
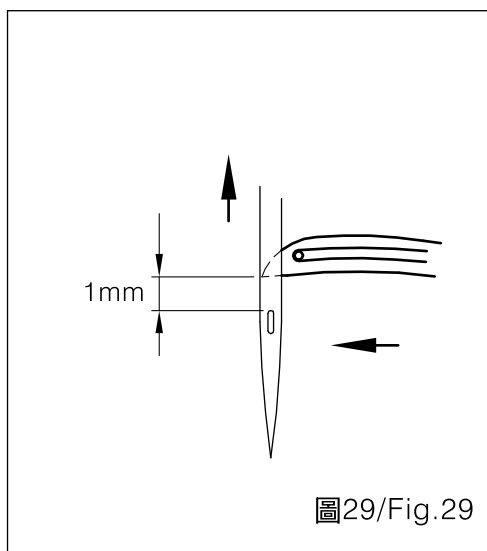
3. The relationship between needle and looper as (Fig. 27) shows. When needle is at both "0 & 3" positions, the looper thread pulling should be the same.
4. Looper thread pulling adjustment
  - A. After the above (1) & (2) adjustment are done, we should adjust the looper thread pulling, Make the adjustment when needle is at "0" position. (Fig.27)
  - B. When needle is at the bottom dead point, looper should be at the right dead point.
  - C. When looper is at the right dead point, distance between looper tip and needle right side is 5mm. (Fig.28)

## 針與勾針的左右同步關係

## NEEDLE AND LOOPER'S LEFT AND RIGHT ADJUSTMENT

1. 當針移動到最左側時，其處於(圖.27)所示0落針位置。當勾針由右向左移動，通過針的背側時，應對準自針外徑至針孔上的距離為1mm處的位置。(圖29)
2. 當勾針自左向右移動，通過勾針背側時，應對準自針外徑起至針孔上端的距離為1mm處的位置(圖31)即針與勾針的同步關係為，相對於針來說，勾針處於同步狀態，調整時應鬆開勾針擺動偏心輪(圖.30)的固定螺絲Y而加以調整。

1. When needle is at the left dead point, it should be at the "0" position (Fig. 27). When looper goes from right to left and stops at back side of the needle, it should be at 1mm from top of the needle hole. (Fig. 29)
2. When looper goes from left to right and stops at back side of the needle, it should be at 1mm from top of the needle hole. (Fig. 31) Loosen screw Y for adjustment. (Fig. 30)



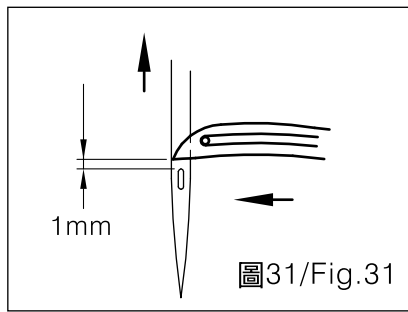


圖31/31

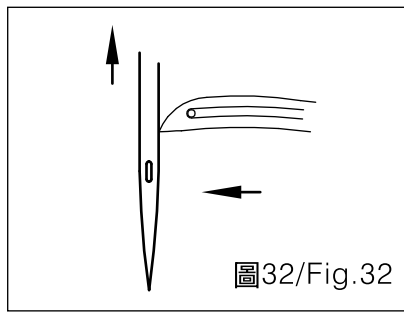


圖32/32

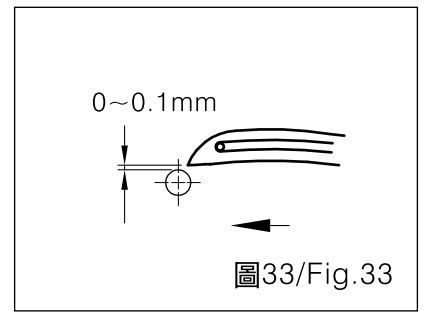


圖33/33

## 針與勾針的前後位置調整

應在針的落針位置(圖27)的1位置時，進行此項調整，當勾針自右向左移動而通過針的背側時(圖32)，勾針的端部與針相遇時的間隙(圖33)的F應儘可能小而又不能使針與勾針接觸相碰。調整時應鬆開勾針座(圖30) D的固定螺絲G，前後移動勾針座加以調整。

## NEEDLE AND LOOPER'S BACK AND FORTH ADJUSTMENT

Make this adjustment when needle is at "1" position (Fig. 27). When looper goes from right to left and through the back side of needle, the clearance between looper and needle is 0-0.1mm. Loosen screw G (Fig. 33) for adjustment.

## 勾針的背部彈簧調整

勾針背部彈簧是與裝飾線張力，跳針有關的動要部位，應加以注意。調整時所使用的線為#3/60。線通過勾針和背部彈簧之間隙的標準狀態(圖34) 接著調整背部彈簧的安裝螺絲和安裝角度，使背部彈簧給予線的張力為30g-45g的範圍內。

張力測量方法應按下述要領：

使背部彈簧接觸面的中央面向外側，沿著勾針下側和彈簧面接觸的同一方向，使張力計

## LOOPER SPRING ADJUSTMENT

The looper spring will effect decorative thread tension and missing stitches. Use thread #3/60 for adjustment. As fig. 34 showed the standard condition for thread goes through looper and looper spring. Adjust the screw and angle on the spring to make the spring tension to 30-45g. Measurement: Measuring along the "arrow" "sign" (Fig. 35)

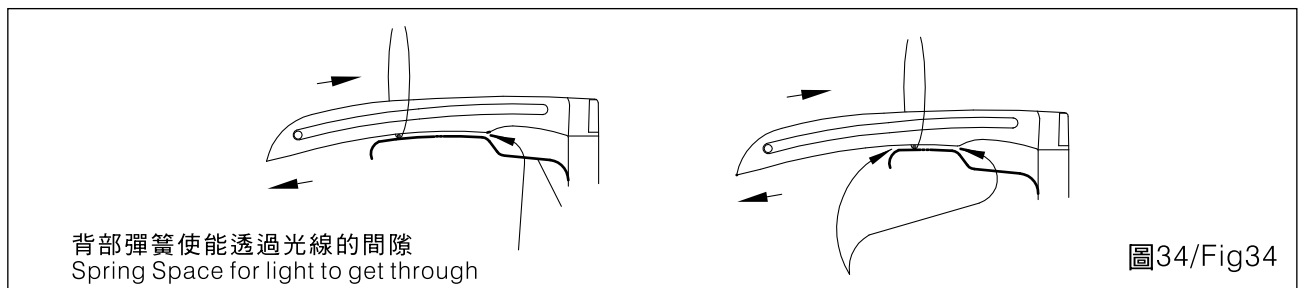


圖34/34

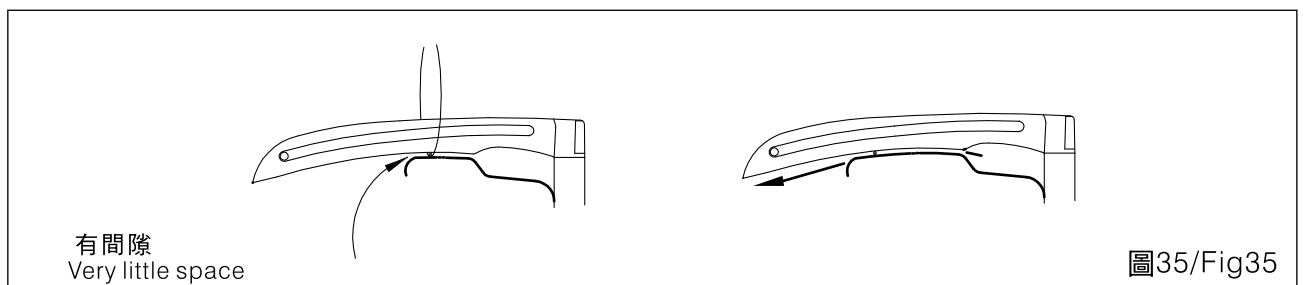


圖35/35

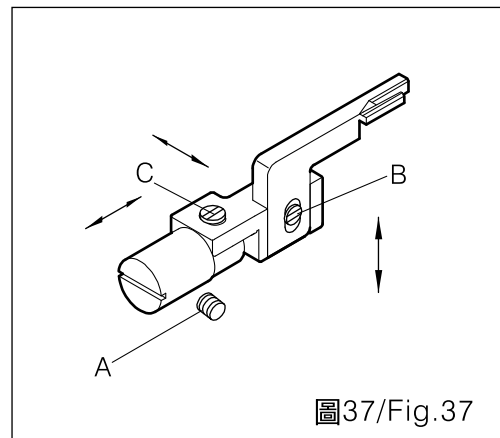
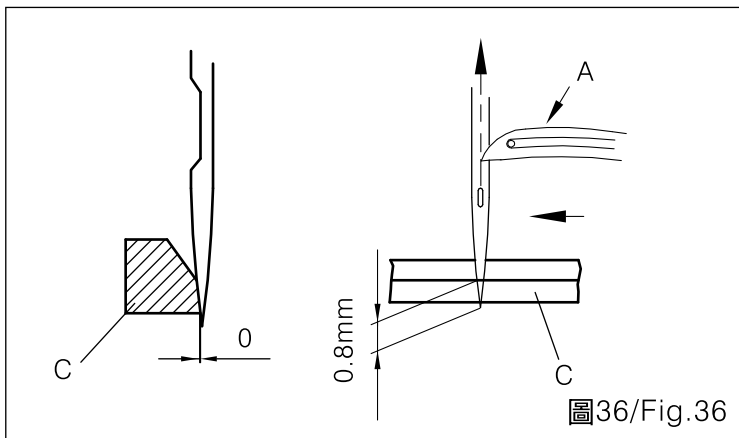


## 針和護針片的關係

## NEEDLE AND NEEDLE GUARD

1. 當勾針A剛開始與針相遇時，應在針端部向上約0.8mm處的位置安裝護針片C，此時針與護針片的間隙為0。但應注意不要讓護針片壓彎針。(圖.36)
2. 調整應鬆開固定螺絲A 調整左右，鬆開固定螺絲C調整前後，鬆開固定螺絲B調整上下，然後逐項固鎖之。(圖37)

1. When looper A is very close to the needle, fix the needle guard C 0.8mm above needle tip. The clearance between needle and needle guard is 0. Be wear of that don't let needle guard bend needle. (Fig. 36)
2. Loosen screw A for adjusting left and right, screw C for adjusting front and back, screw B for adjusting up and down. (Fig. 37)



桌板圖 T1

TABLE CUT-OUT T1

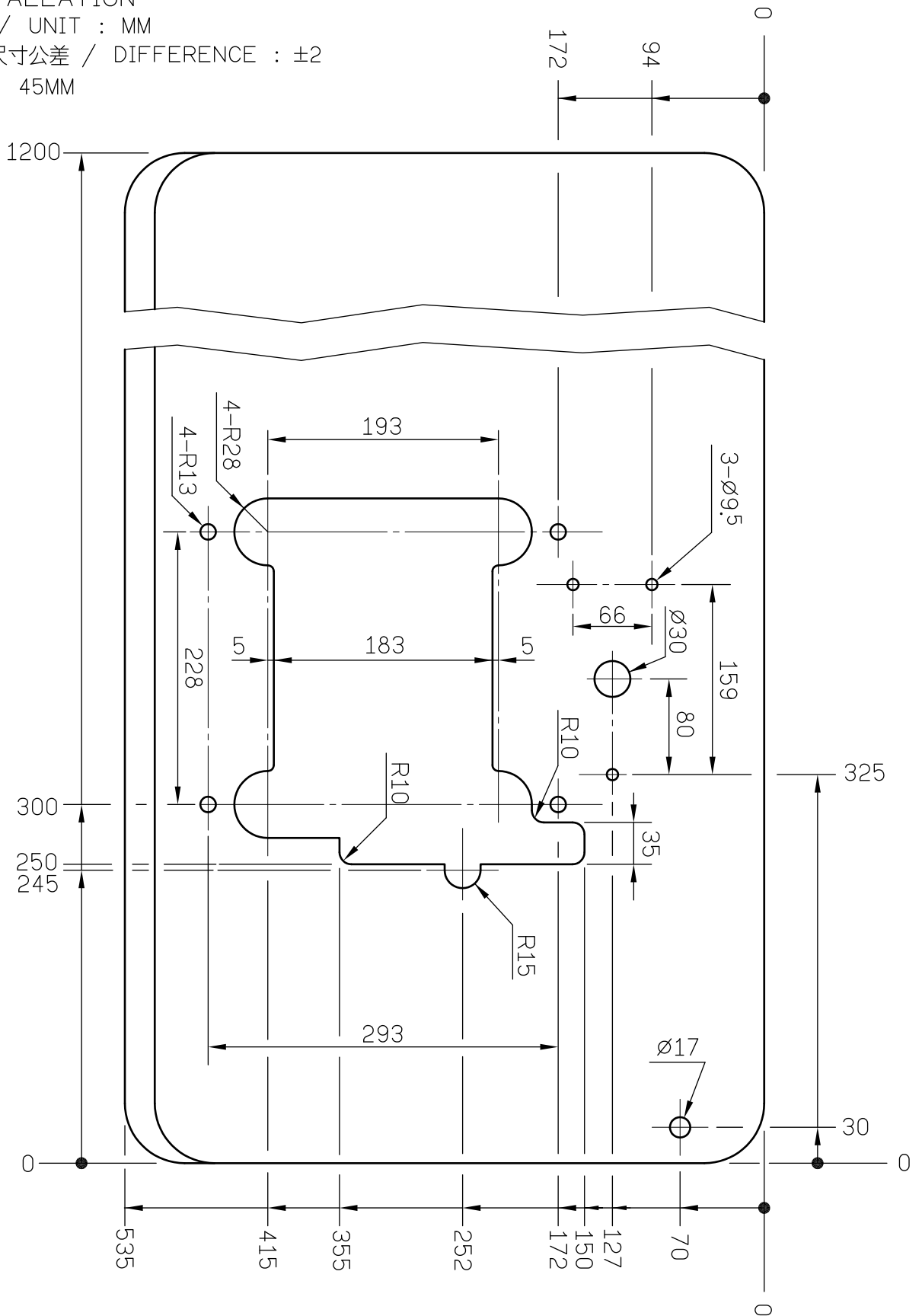
FOR Z008-T1 人字車下乘式桌板圖

SEMI-SUBMERGED  
INSTALLATION

單位 / UNIT : MM

所有尺寸公差 / DIFFERENCE :  $\pm 2$

厚度 : 45MM



# 桌板圖 T2

# TABLE CUT-OUT T2

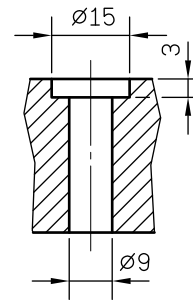
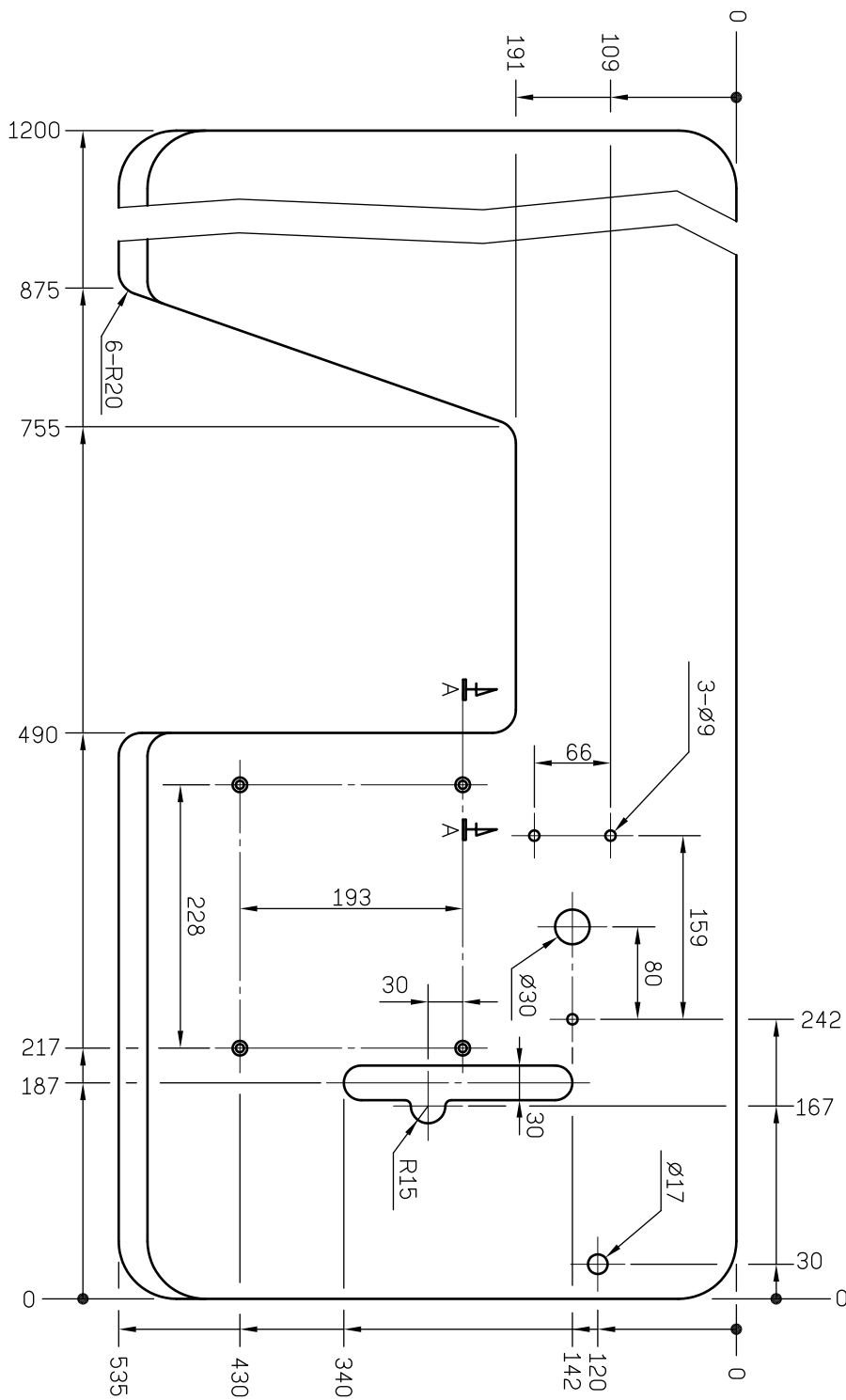
FOR Z008-T2 人字車上乘式桌板圖

TABLE TOP INSTALLATION

單位 / UNIT : MM

所有尺寸公差 / DIFFERENCE :  $\pm 2$

厚度 : 45MM



A-A剖面



# Z008

高林股份有限公司 KAULIN MFG. CO., LTD.