

# 花样缝电脑平缝机 A9 Series

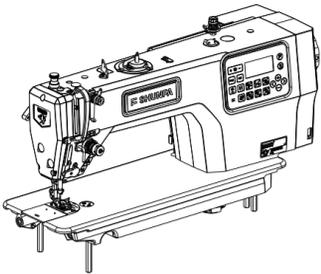
## Computerized special stitch pattern lockstitch sewing machine

# 使用说明书

## OPERATION MANUAL

### 零件手册

### PARTS BOOK

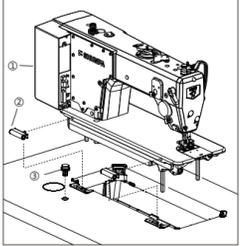


### 安全操作事项 FOR SAFE OPERATION

1. 为避免触电, 请不要打开机器的电箱盖, 也不要接触电箱内部组件。
2. To avoid electrical shock hazards, never open the cover of the electrical box for the motor nor touch the components mounted inside the electrical box.
1. 为避免人身伤害, 移动防护罩、护手挡或安全装置时, 请不要开动机器。
2. 为尽可能避免机器运转造成的人身伤害, 手指、头部和衣服要远离上轮, 上轮周围不要放置任何物品。
3. 为避免人身伤害, 当打开电源开关或操作机器时, 切勿将手放在机针下方。
4. 为避免人身伤害, 机器运转时, 切勿将手放入挑线杆防护罩内。
5. 旋梭运转时, 切勿将手指放在旋梭附近。另外, 装拆芯芯时, 请关闭机器电源开关。
6. 为尽可能避免人身伤害, 当抬起旋梭起机头时, 切勿将手指插入机器内部。
7. 为尽可能避免机器的突然启动所造成的事故, 抬起机头时, 请关闭机器的电源。
8. 机器配有电机, 机器未运转时, 电机无噪音; 为避免机器的突然启动所造成的事故, 请关闭机器的电源开关。
9. 为尽可能避免触电或电器组件受损, 在插上或拔下插头之前, 请关闭电源开关。
1. To avoid personal injury, never operate the machine with any of the belt cover, finger guard of safety devices removed.
2. To prevent possible personal injuries caused by being caught in the machine, keep your fingers, head and clothes away from the handwheel, cover and the motor while the machine is in operation. In addition, place nothing around them.
3. To avoid personal injury, never put your hand under the needle when you turn ON the power switch or operate the machine.
4. To avoid personal injury, never put your fingers into the thread take-up cover while the machine is in operation.
5. The hook rotates at a high speed while the machine is in operation. To prevent possible injury to hands, be sure to keep your hands away from the vicinity of the hook during operation. In addition, be sure to turn OFF the power to the machine when replacing the bobbin.
6. To avoid possible personal injuries, be careful not to allow your fingers in the machine when tilting/raising the machine head.
7. To avoid possible accidents because of abrupt start of the machine, turn OFF the power to the machine when tilting the machine head.
8. If your machine is equipped with a serve-motor, the motor does not produce noise while the machine is at rest. To avoid possible accidents due to abrupt start of the machine, be sure to turn OFF the power to the machine.
9. To prevent possible accidents because of electric shock or damaged electrical component(s), turn OFF the power switch in prior to the connection /disconnection of the power plug.

### 2-3. 机头 Machine head

- ① 机头
- ② 机头铰链 (2pcs)
- ③ 机头支柱



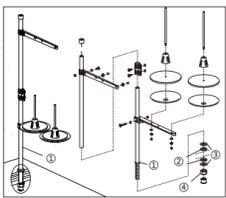
- ④ Hinges head
- ⑤ Hinges (2pcs)
- ⑥ Frame support bar

### 2-4. 线架 Cotton stand

- ① 线架
- ② Cotton stand

注意: 将螺母①拧紧以便将两个橡胶垫圈②和垫圈③夹紧, 使线架①固定。

NOTE: Securely tighten the nut ①, so that the two rubber cushions ② and the washer ③ are securely clamped and so that the cotton stand ① does not move.



### 重要安装事项

为使您正确使用本机, 须了解本机的各种功能充分了解, 以便安全操作。使用前请仔细阅读使用说明书。我们希望您能长期愉快地使用本机。请保存好说明书, 以备查阅。

1. 无论您何时使用本机, 须了解基本的安全事项, 包括但不限于下列事项。
2. 速读所有说明, 并保存好使用说明书。如果需要, 请随时翻阅。
3. 使用本机前, 必须弄清与本机有安全相关规定。标准在您的国家是否适用。
4. 使用本机前或使用本机时, 所有安全装置必须配备齐全。机器运转时, 无安全装置属违章操作, 决不允许。
5. 操作人员必须经过适当的培训。
6. 为了您的人身安全, 我们建议您戴上防护眼镜。
7. 下列情况下, 请关闭电源开关或拔下电源插头:
  - 7-1 机针穿线和换梭心;
  - 7-2 更换机针、压脚、针板、送料牙、布料导板等;
  - 7-3 进行维修时;
  - 7-4 操作无人时;
8. 在机器加油油嘴时, 若不小心让油液接触眼睛、皮肤或咽下机油或润滑油, 请立即清洗被沾染部位或去医院检查。
9. 无论机器运转与否, 严禁乱动机器零部件和配套装置。
10. 机器的维修、改造和调整等工作必须由专业技术人员进行。
11. 应由专业人员进行一般的维修和检查工作。
12. 必须在专业维修人员或专业技术人员的指导下进行有关电器部件的维修。任何电器部件一经发现受损, 立即停止机器运转。
13. 使用期间要定期全面彻底清洗机器。
14. 正常使用本机时, 必须进行试运行, 工作环境远离强噪音源, 如高频电焊机。
15. 由电气人员选择合适的插头和有地的插座。
16. 若需要改造或改进本机, 请采用有效可行的安全措施。本公司对此而产生的伤害不承担责任。
17. 本机只适用于专业缝纫。
18. 两种警告提示符:
  - ⚠️ 操作人员或维修人员请注意
  - ⚠️ 特别注意事项

### 开机前的注意事项 Precautions Prior to Startup

1. 机头装配前为了防止机件生锈, 在部分均涂有较厚的防锈油膜, 同时机头装配后, 还能在较长的贮藏和长途运输阶段造成油垢硬化和在机器表面形成灰尘, 所以必须将表面的油垢擦去并用汽油和洁剂的软布擦拭干净。
2. 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震动或其他机械冲击或弯曲, 所以应进行一次粗略的检查, 并打开手轮上盖, 检查机头有无转动阻滞、碰壁现象或其它不均匀的阻力, 不正常声响的, 如有应作适当的调整, 机器状态正常后方可正式工作。
3. 油盒机油油面高度没有在正常范围内也不能开车。
4. 机器运转时, 上轮转向应该是逆时针方向 (从上方外侧看)。
5. 确认电控按钮上所标电压及相位是否正确。
6. 生产日期见合格证。
1. The machine head is coated with a thick layer of rust-prevention grease before encasement, and the enclosed machine head may possibly be subjected to grease hardening and dust buildup on the machine surface in process of long storage and long-haul traffic; therefore, take care to remove the grease and dust from the surface using soft cloth and gasoline.
2. Though the machine was inspected and tested with care before factory leaving, it might be affected by violent vibration resulting in looseness or distortion of the machine parts; therefore the operator shall thoroughly check the machine, turn the upper wheel by hand and check it for difficulty in free rotation, slight impact, and other uneven resisting force or abnormal noises, and make appropriate adjustment if any to restore the machine state before formal trial run.
3. Never start up the machine if the oil liquid level in the oil box falls outside the normal range.
4. The upper wheel shall rotate counterclockwise (when it is viewed from the lateral surface of the upper wheel) when the machine is operating.
5. Check whether the voltage and phases indicated on the electric-control data plate are correct.
6. The date of manufacture is indicated on the certificate of conformity.

### 使用注意事项 Precautions for Use

1. 当接通电源或机器运转时, 请勿将手与机针接触。
2. 机器运转时, 请勿将手指伸入挑线杆防护罩内。
3. 操作者用手送料时, 请勿将手指伸入护针架。
4. 机头翻动及拆手轮时, 一定要切断电源。
5. 操作者离开机器时, 必须切断电源。
6. 机器运转时, 绝不允许头部或手以任何东西靠近上轮、挑线杆。
7. 只有在停机时, 才能拆卸防护罩或其它保护装置。
8. 不能用香蕉水等油漆稀释剂擦拭机头表面。
1. Never touch the needle by hand when the machine is powered on or while it is operating.
2. Never put your finger into the protection cover of take-up lever during operation of the machine.
3. The operator must not put his finger into the needle guard bracket when he feeds the sewing materials by hand.
4. Operator must trim off the electricity supply before he turns over the machine head or removes the hand cover.
5. The operator must trim off the electricity supply before he gets away from the machine.
6. Prohibit the head, hands and anything to approach the upper wheel and bobbinwinder while the machine is operating.
7. Never remove or mount the protection cover or other protection devices before the machine is stopped.
8. Never wipe up the surface of machine head using paint thinner such as acetone.

### 3. 加油方法 Lubrication

注意: 为了防止意外的自动启动的事故, 请关闭电源后进行。

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

### 运转缝纫机前

1. 请把机油倒进油槽①里, 一直加到横线标②的位置。
2. 油槽的油面降到横线标②以下时, 请再次补充机油。
3. 加油后运转缝纫机, 如果油面正常, 可以通过油窗③看到油的流动。
4. 油流动量的多少, 与油量的多少无关。

新缝制机或长时间没有使用的缝制机在使用之前, 应进行10分钟3000-5000rpm的磨合运转。

### Information on lubrication

1. Fill oil pan ① with Machine 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 ③ if the lubrication is adequate.
4. Note that the amount of the splashing oil is unrelated to the amount of the lubricating oil.

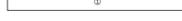
When you first operate your machine after setup of an extended period of disuse, run your machine at 3,000 to 3,500 rpm for about 10minutes for the purpose of break in.

### 面油量的调整

1. 调整挑线杆合针杆曲柄轴部①的油量时, 转动油量调节旋钮②进行调整。
2. 调整好后, A 从图的位置向 B 方向转动, 转动到接近针杆曲柄轴②时, 油量减小。
3. 从图上所示的位置向 C 方向转动, 当转到与针杆曲柄的正对的位置时, 油量最大。

Adjusting the amount of oil supplied to the face plate parts

1. Adjusting the amount of oil supplied to the thread takeup and needle bar crank ② by turning adjust ①.
2. The minimum amount of oil is reached when marker dot A is brought close to needle bar crank ② by turning the adjust pin in direction B.
3. The maximum amount of oil is reached when marker dot A is brought to the position just opposite from the needle bar crank by turning the adjust pin in direction C.



### IMPORTANT SAFETY INSTRUCTIONS

To get the most out of the many functions of this machine and operate it safely, it is necessary to use this machine correctly. Please read this Instruction Manual carefully before use. We hope you will enjoy the use of your machine for a long time. Please remember to keep this manual in a safe place.

1. Observe the basic safety measures, including, but not limited to the following ones, whenever you use the machine.
2. Read all the instructions, including, but not limited to this Instruction Manual before you use the machine. In addition, keep this Instruction Manual so that you may read it at any-time when necessary.
3. Use the machine after it has been ascertained that it conforms with safety rules/standards valid in your country.
4. All safety devices must be in position when the machine is ready for work or in operation. The operation without the specified safety devices is not allowed.
5. This machine shall be operated by appropriately-trained operators.
6. For your personal protection, we recommend that you wear safety glasses.
7. For the following, turn off the power switch or disconnect the power plug of the machine from the receptacle.
  - 7-1 For threading needle(s) and replacing bobbin.
  - 7-2 For replacing part(s) of needle, presser foot, throat plate, feed dog, cloth guide etc.
  - 7-3 For repair work.
  - 7-4 For when leaving the working place of when the working place is unattended.
8. If you should allow oil, grease, etc. used with the machine and devices to come in contact with your eyes or skin or swallow any of such liquid by mistake, immediately wash the contacted areas and consult a medical doctor.
9. Tampering with the live parts and devices, regardless of whether the machine is powered, is prohibited.
10. Repairing, reforming and adjustment works must only be done by appropriately trained personnel. Repair and maintenance works of electrical components shall be conducted by qualified electric technicians or under the audit and guidance of specially skilled personnel. Whenever you find a failure of any of electrical components, immediately stop the machine.
11. Periodically clean the machine through the period of use.
12. Grounding the machine is always necessary for the normal operation of the machine. The machine has to be operated in an environment that is free from strong noise sources such as high-frequency welder.
13. An appropriate power plug has to be attached to the machine by electric technicians. Power plug has to be connected to grounded receptacle.
14. Remodel or modify the machine in accordance with the safety rules/standards while taking all the effective safety measures. We assume no responsibility for damage caused by reforming or modification of the machine.
15. The machine is only allowed to be used for the spose intended. Other used are not allowed.
16. Warning hints are marked with the two shown symbols.
  - ⚠️ Danger of injury to operator or service staff
  - ⚠️ Items requiring special attention

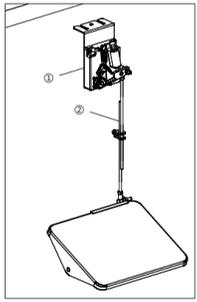
- ⚠️ Danger of injury to operator or service staff
- ⚠️ Items requiring special attention

### 1. 缝制机规格 MACHINE SPECIFICATIONS

用途 USE	薄料、中厚料	厚料
MAX. Sewing speed	5000sti/min	4000sti/min
最大针距	5mm	7mm
MAX. Stitch length	5mm	7mm
压脚高度	5.5mm	13mm
压脚脚高	5.5mm	13mm
送料	1.0mm	1.2mm
机针 Needle	DBx1 9#-18#	DPx5 18#-22#
润滑油	15号白油	NO.10 White oil

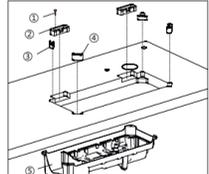
### 2-1. 安装方法 Installation

- ① 调速器
- ② Speed controller
- ③ 连杆
- ④ Connecting rod



### 2-2. 安装 Installation

- ① 鞋钉 (8个)
- ② 机头连接座 (2个)
- ③ 连杆
- ④ 头部防震垫 (2个)
- ⑤ 托盘 (1个)



### 4. 面线的穿法 Threading the upper thread

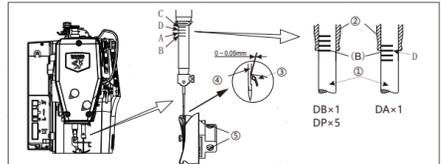
#### 注意 CAUTION

在穿线过程中, 请切断电源。当误按启动开关时, 缝制机会导致人员受伤。The machine may operate if the treadle is depressed by mistake, which could result in injury.

在穿引面线之前转动手轮, 抬高挑线杆①, 这样会使穿线更加容易, 并防止面线在缝制开始时脱落。

Turn the machine pulley for raising the thread take-up ① before threading the upper thread. This will make threading easier and it will prevent the thread from coming out at the sewing start.

### 5. 机针和旋梭的同步 Adjusting the needle and rotary hook timing



当机针①从最低位置向上移动1.8mm (2.2mm用于M和H规格), 到达旋梭与机针轴套②下端对齐的位置时, 旋梭尖③应刚好与机针①对齐。如果不对, 请按下列步骤调整: 1. 转动挑线杆手轮, 使机针①从最低位置向上到如图所示的基准线④与机针轴套②的下端保持对齐为止; 2. 旋梭固定螺钉⑤(3个), 调整旋梭⑤与机针④之间的间隔为0-0.05mm; 3. 拧紧固定螺钉⑥(3个)。

1. The tip of the rotary hook ③ should be aligned with the center of the needle ④ when the needle ④ moves up 1.8mm (2.2mm for M and H specifications) from its lowest position to the position where reference line B is aligned with the lower edge of the needle bar bush ② as shown in the illustration. (the distance from the upper edge of the needle hole to the rotary hook tip will be 0.5 to 0.7mm at this time)
1. Turn the machine pulley to raise the needle bar ① from its lowest position until reference line B is aligned with the lower edge of the needle bar bush ② as shown in the illustration.
2. Loosen the set screws ⑤, and then align the tip of the rotary hook ③ with the center of the needle ④. The distance between the tip of the rotary hook ③ and the needle ④ should be approximately 0-0.05mm.
3. Securely tighten the set screws ⑥.

### 6. 踏板的调整 Adjustment of the pedal

#### 注意 CAUTION

为了防止意外启动造成的事故, 请关闭电源后再进行。

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

1. 踏板角度的调整: 1) 向前踩踏板时, 踏板的角度可以调节踏板的角度。旋紧螺钉①, 上下移动上盖板的下方连接杆②以调节踏板连接杆的长度。
2. 调节完成后压紧螺钉③。
2. 踏板压力的调整: 脚踏板在踩上和松开踏板时, 缝制时进行低油脚脚。如感觉踏板力比较轻时, 请旋紧力调节弹簧④挂注在踏板固定螺钉⑤的位置上调节踏板力。以a为最小, b, c, d依次逐渐增大。
3. 踏板回力的调整: 1) 松开脚踏板, 脚踏板回力调节螺钉⑥: 拧紧时减小踏板回力, 拧松时增大踏板回力。2) 调节脚踏板回力后, 拧紧调整螺钉⑦。

1. Adjusting the angle of treadle: 1) Adjust the angle of treadle only by adjusting the length of treadle connecting rod unscrew screw ①, and adjust the length of treadle connecting rod ② by moving upward/downward the upper connecting rod ② and a lower connecting rod ③.
- 2) Screw down screw ③ when adjustment is over.
2. Adjustment of the strength of pedal: The sewing machine run at a low speed when step forward from the pedal slightly. If the strength is insufficient, hang the stepping adjustment spring ④ on the panel spiral arm driving lever ⑤ in order to adjust strength. It is the minimum stepping strength h, c, d increase gradually.
3. Adjustment of stepping return strength: 1) Loosening nut ⑥ and turn bolt ⑦ to adjust stepping return strength: tighten bolt ⑦, the strength increase; loosen bolt ⑦, the strength decrease.
- 2) Tighten nut ⑥ after adjusting stepping return strength.

### 踏板操作 Pedal operation

1. 踏板有四种操作: 1) 向前踩踏板时, 踏板回力减小(图A); 2) 再用力向前踩踏板时, 踏板回力增大(图B); 3) 当脚不向前踩踏板时, 脚踏板回到原状时, 缝制时停止运转(图C); 4) 再用力向后踩踏板时, 踏板回力减小(图D); 5) 使用自动压脚升降装置时, 在停止和启动之间加一级开关D, 前后压脚板在压脚升降时, 踏板回力力强, 压脚下降进行压脚操作, 再返回压脚升降时。
1. The treadle has 4 operation levels: 1) The machine runs at low sewing speed when you lightly depress the front part of the pedal (as show in the picture A).
- 2) The machine runs at high sewing speed when you further depress the front part of the pedal (as show in the picture B).
- 3) pedal back to the initial position when stop stepping on it and the machine stop working (needle in the upper or down position) (as show in the picture C).
- 4) The machine runs threads when you fully depress the back part of the pedal (as show in the picture D).
- 5) When the auto-lift is used, one more operating switch is provided between the sewing machine stop switch and thread turning switch. The presser foot goes up when you lightly depress the back part of the pedal (D), and if you further depress the back part the thread trimmer is actuated.

### 7-2. 送料牙倾斜的调节 Adjust the lean of feed dog

1. 转动手轮, 将送料牙①开到斜板②的最高位置。
2. 将缝制机放倒, 并支到机头支柱上。
3. 旋松压架③上的紧固螺钉④。
4. 用螺丝刀转动偏心销⑤进行调节: 将偏心销⑤向A方向转动, 送料牙前部翘起; 向B方向转动, 送料牙前部降低(当送料牙开到斜板②的最高位置时, 送料牙标准倾斜角为偏心销⑤上的刻点C与压架座③上的刻线D对齐, 送料牙与斜板平行)。
5. 调节完成后拧紧压架座③上的紧固螺钉④。



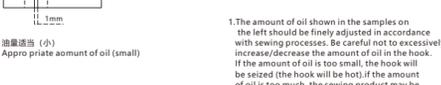
1. Turn the pulley until the feed dog ① rises to the highest position.
2. Turn over the sewing machine head on the supporting bar.
3. Unscrewing the tightening screw ④ in the teeth pedestal ③.
4. Adjust the eccentric pin ⑤ by screw driver: Fall front site of tooth feed dog when moving the eccentric pin ⑤ towards A, and raising it when move towards B. (When raising the tooth feed dog to the highest position, the standard lean position of feed dog is that mark C on eccentric pin ⑤ should be at the same level D with mark on the teeth pedestal ③ and the feed dog should be parallel with needle plate.)

1. 为了防止起皱, 可降低送料牙前缘。
2. 为了防止在重缝缝制时布料不一致(线迹不合), 可提高送料牙前缘。
3. 调节送料牙的倾斜度后, 送料牙的高度也会发生改变, 因此请重新调节送料牙的高度。
1. In order to prevent puckering, lower the front of the feed dog.
2. In order to prevent the material from slipping, raise the front of the feeddog.
3. The height of the feed dog will change after the angle has been adjusted, so it will be necessary to readjust the height of the feed dog.

### 9. 关于旋梭部油量(迹)调整方法 Adjusting thr amount of oil(oil splashes) in the hook

油量 (油迹) 适合标准/Sample showing the appropriate amount of oil

从旋梭飞出的油/Splashes of oil from the hook



油量适当 (小) Appropriate amount of oil (small)

从旋梭飞出的油/Splashes of oil from the hook

油量适当 (大) Appropriate amount of oil (large)

1. The amount of oil shown in the samples on the left should be finely adjusted in accordance with sewing process. Be careful not to excessively increase/decrease the amount of oil in the hook. If the amount of oil is too small, the hook will be seized (the hook will be hot); if the amount of oil is too much, the sewing product may be stained with oil.
2. Adjust the amount of oil in the hook so that the oil amount (oil splashes) should not change while checking the oil amount three times (on the three sheets of paper).

### 7-1. 标准调整 Standard adjustment

#### 注意 CAUTION

1. 只有经过训练的专业人员才能进行缝制机的维修、保养和检查。Maintenance and inspection of the sewing machine should only be carried out by a qualified.
1. 与电气有关的维修、保养和检查需委托购买商店或电气专业人员进行。Ask your dealer or a qualified electrician to carry out any maintenance and inspection of the electrical system.
1. 取下安全保护装置, 再次安装时, 请务必安装在原位上, 并检查能否正常地发挥作用。If any safety devices have been removed, be absolutely sure to re-install them to their original positions and check that they operate correctly before using the machine.
1. 缝制机头倒下或抬起时, 请用双手进行操作。单手操作时因缝制机的重量万一滑落易导致受伤。Use both hands hold the machine head when tilting it back or returning it to its original position. If only one hand is used the weight of the machine head may cause your hand to slip, and your hand may get caught.
1. 发生下列情况时, 请关闭电源, 并拔下电源插头, 否则踩下踏板时, 缝制机运作会导致受伤。检查、调整和维修: 要更换旋梭、切片等易损零部件。Turn off the power switch and disconnect the power cord from the wall outlet at the following times. Otherwise the machine may operate if the treadle is depressed by mistake, which could result in injury. When carrying out inspection, adjustment and maintenance - When replacing consumable parts such as the rotary hook and knife.

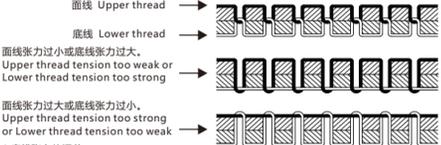
### 7-1. 调线量的调整

1. 旋松螺钉①。
2. 移动右线轴②进行调节: 朝左方向(即A方向)移动, 挑线量将会增加; 反之朝右方向(即B方向)移动, 挑线量将会减少。(右线轴上的刻线C与螺钉中心一致时为标位置)。
3. 调节完成后拧紧螺钉①。
1. Unscrewing the screw ①.
2. Move the right thread hook ② to adjust: the thread amount of thread take-up lever will increase if turned it towards left (A direction), while turning it to the right (direction B) and the thread amount of thread take-up lever will decrease accordingly. (The standard position is obtained when graduation line C on right thread hook is aligned to screw center).
3. Remember to tight the screw ① after adjusting.

### 8. 线张力的调节 Adjusting the Tension of Stich Thread

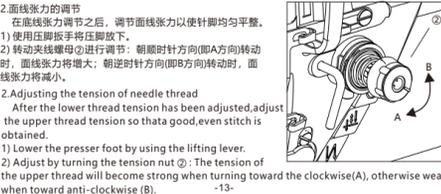
#### 注意 CAUTION

取出机芯芯套时, 请关闭电源。当踩下脚踏板时, 缝制机会导致人员受伤。The machine may operate of the treadle is depressed by mistake, which could result in injury.



1. 底线张力的调节: 拉紧从梭芯中露出的线头, 旋转调节螺钉①, 底线张力变大; 反之则底线张力变小。
1. Adjusting the tension of bobbin thread: Hold the end of a thread which hanging from the bobbin case and use the adjusting rotating screw ① to regulate. The tension of the bottom thread is become strong by tight the screw ①, loose the screw to make it weak.

2. 面线张力的调节: 在底线张力调节之后, 调节面线张力以使针脚均匀平整。
- 1) 使用压脚时, 将压脚放下。
- 2) 转动调线螺母②进行调节: 顺时针方向(即A方向)转动时, 面线张力将增大; 逆时针方向(即B方向)转动时, 面线张力将减小。
2. Adjusting the tension of needle thread: After the lower thread tension has been adjusted, adjust the upper thread tension so that a good, even stitch is obtained. 1) Lower the presser foot by using the lifting lever. 2) Adjust by turning the tension nut ②: The tension of the upper thread will become strong when turning toward the clockwise (A), otherwise weak when toward anti-clockwise (B).



### 10. 踏板压力和行程 Pedal pressure and pedal stroke

注意: 为了防止意外的自动启动造成的事故, 请关闭电源后再进行。

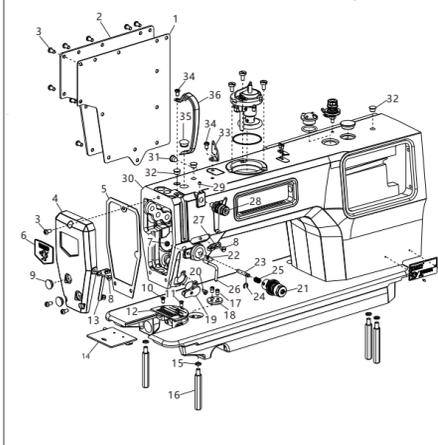
Waring: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

1. 踏板压力的调整: (1) 换成前踩踏板弹簧①可以调整。(2) 把弹簧挂到左侧之后, 压力变轻。(3) 挂到右侧之后变重。
2. 踏板回力的调整: (1) 用旋梭回力压力调节弹簧②可以调整。(2) 拧紧调节螺丝则压力变大。(3) 拧松调节螺丝则压力变小。
3. 踏板行程的调整: (1) 把连杆③搬到右侧的孔里之后行程变大。
1. Adjustment of pedal pedaling pressure: (1) It can be adjusted by replacing it with front tread spring ①. (2) After the spring is hung on the left, the pressure becomes lighter. (3) Be hung into the right after the heavy. 2. Adjustment of pedal back stepping force: (1) It can be adjusted by stepping back on the pressure adjusting spring ② with the pedal. (2) Tighten the adjusting screw to increase the pressure. (3) Loosen the adjusting screw to reduce the pressure. 3. Adjustment of pedal pedaling stroke: (1) After inserting the connecting rod ③ in to the hole on the right, the stroke becomes larger.

### 7-2. 送料牙的高度 Adjustment of the Height of feed dog

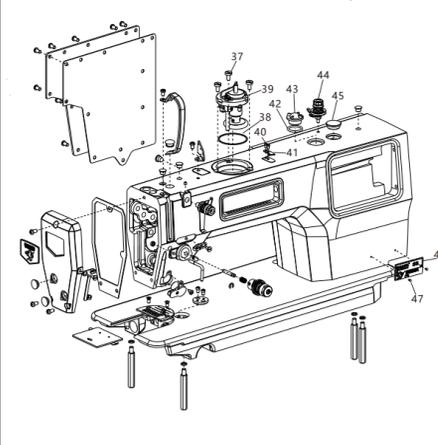
1. 转动手轮, 将送料牙开到斜板的最高位置。
2. 将缝制机放倒, 并支到机头支柱上。
3. 旋松送料牙变形曲柄①上的紧固螺钉②。
4. 转动送料牙变形曲柄①进行调节: 将送料牙变形曲柄①向A方向转动, 送料牙变高; 反之向B方向转动, 送料牙变低(当送料牙开到斜板的最高位置时, 中厚料机送料牙变形曲柄的标准高度为0.8-1.0mm, 厚料机送料牙变形曲柄的标准高度为1.1-1.3mm)。
5. 调节完成后拧紧送料牙变形曲柄①上的紧固螺钉②。
1. Turn the pulley until the feed dog rises to the highest position.
2. Turn over the sewing machine head on the supporting bar.
3. Unscrewing the tightened screw ② in the feed lifting crank ①.
4. Rotating the feed lifting crank ① to make adjustment: the feed dog will be higher when the feed lifting crank ① is turn towards A direction; turn towards B direction the feed dog will be lower. (When the feed dog in the highest position, the standard height of the type of medium-heavy machine is 0.8-1.0mm and standard height of the heavy duty machine is 1.1-1.3mm.)
5. Remember to tighten the tightening screw ② in the feed lifting crank ① after adjusting.

1. 机壳分组件/Machine frame&miscellaneous cover components



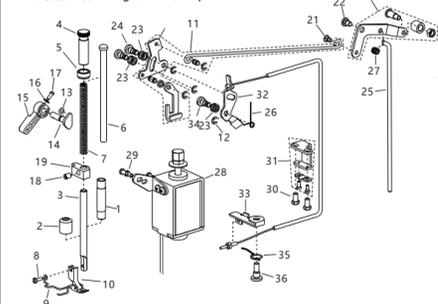
序号 Ref.No.	物料号 Part.No.	名称 Name	Description	数量 Qty	备注 Remark
1	11.002.00014	后窗板垫	Side plate gasket	1	
2	20.02.01.00012	后窗板	Side plate	1	
3	17.02.00102	螺钉	Screw	16	
4	20.02.01.00011	面板	Face plate	1	
5	11.002.00017	面板垫	Face plate gasket	1	
6	15.03.00009	商标牌	Trademark	1	
7	17.04.00019	六角螺母	Nut SM11/64"×40 L=3	1	
8	17.02.00083	螺钉	Screw SM11/64"×40 L=6	2	
9	11.001.00027	橡胶塞Φ9.9	Rubber plug	2	
10	17.02.00279	螺钉	Screw SM11/64"×40 L=9	1	
11	17.02.00095	螺钉	Screw SM11/64"×40 L=8.5	1	
12	11.002.00008	针板	Needle plate	1	
13	11.002.00002	左线钩	Arm thread guide left	1	
14	11.001.00026	推板组件	Side plate ASM	1	
15	17.05.00077	标准型弹簧垫圈5	Washer	4	
16	11.000.00001	床板支柱	Bed screw stud	4	
17	17.02.00104	螺钉	Screw SM11/64"×40 L=5.5	2	
18	1002A0002	卷边器座	Ruler plate	1	
19	11.002.00010	电子夹线器组件	Electromagnet	1	
20	17.01.00121	螺钉	Screw M4 L=5	1	
21	11.002.00004	夹线器组件	Thread take-up device	1	
22	17.01.00139	螺钉	Screw M6 L=10	1	
23	11.001.00062	张力释放支撑销	Tension release supporting pin	1	
24	17.05.00015	开口挡圈4	Side plate gasket	1	
25	11.001.00063	松线螺钉弹簧	Spring	1	
26	11.002.00001	缓线钩	Slow line hook	1	
27	11.001.00003	右线钩	Arm thread guide right	1	
28	11.002.00006	小夹线器部件	Thread take-up device	1	
29	17.01.00120	螺钉	Screw M4 L=4	1	
30	19.04.01.00028	机壳组件	Chassis	1	
31	11.001.00008	橡胶塞Φ8.8	Rubber plug	3	
32	11.001.00009	橡胶塞Φ8.5	Rubber plug	3	
33	11.002.00005	三眼过线板	Thread tension guide	1	
34	17.02.00081	螺钉	Screw SM3/16"×28 L=6	2	
35	11.001.00012	橡胶塞Φ12.5	Rubber plug	1	
36	11.002.00009	挑线杆防护罩	Thread take-up lever cover	1	

1. 机壳分组件/Machine frame&miscellaneous cover components



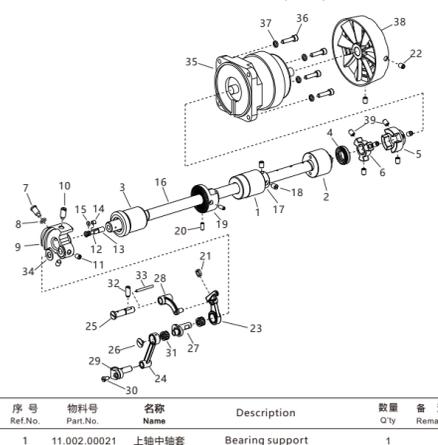
序号 Ref.No.	物料号 Part.No.	名称 Name	Description	数量 Qty	备注 Remark
37	17.01.00109	螺钉	Screw M5 L=10	3	
38	11.001.00019	橡胶密封垫	Gasket	1	
39	11.002.00007	挑线器组件	Bobbin wider ASM	1	
40	17.02.00269	螺钉	Screw SM9/64"×40 L=4.5	2	
41	11.001.00006	割线刀	Thread cutter	1	
42	11.001.00120	O型圈Φ24.5	O-ring	1	
43	11.001.00119	油窗	Oil window	1	
44	11.002.00016	底线夹线器组件	Thread take-up device	1	
45	11.001.00013	橡胶塞Φ20.5	Rubber plug	1	
46	15.03.00008	型号牌	Trademark	1	
47	15.03.00062	标准铆钉2.5	Rivet	2	

4. 压脚分组件/Hang Lifter Components



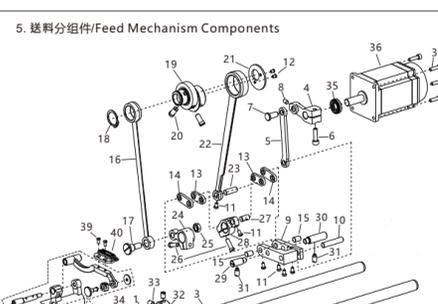
序号 Ref.No.	物料号 Part.No.	名称 Name	Description	数量 Qty	备注 Remark
1	11.002.00042	压杆衬套	Bearing support	1	
2	11.001.00067	压杆防油套	Oil proof sleeve	1	
3	11.001.00066	压杆	Pressure rod	1	
4	11.001.00072	调压螺钉	Screw SM1/2"×28 L=41	1	
5	11.001.00073	调压螺母	Nut SM1/2"×28 L=8	1	
6	11.001.00070	调压导杆	Pressure rod	1	
7	11.001.00071	调压簧	Spring	1	
8	17.02.00064	螺钉	Screw SM9/64"×40 L=11	1	
9	11.001.00069	护脚架	Protect sheif	1	
10	11.002.00108	针距螺钉	Needle bar thread guide	1	
11	11.029.00001	抬压脚前杆组件	Lifting lever link	1	
12	11.001.00074	抬压脚前杆	Lifting lever	1	
13	11.002.00003	压脚升降板	Plate	1	
14	11.002.00032	抬压脚拉杆	Lifting lever connectin	1	
15	17.02.00071	螺钉	Pin	1	
16	11.001.00075	前杆销	Pin	1	
17	17.05.00017	前杆销衬套	Pin sleeve	1	
18	11.002.00056	开口挡圈5	Snap ring	2	
19	11.002.00057	开口挡圈6	Snap ring	3	
20	11.001.00113	O型圈	O-ring	1	
21	11.002.00046	压脚板手凸轮	Trigger cam	1	
22	15.02.00048	压脚板手	Cam	1	
23	11.002.00047	平垫圈	Washer	1	
24	17.02.00085	螺钉	Screw SM9/64"×40 L=9.5	1	
25	17.02.00089	螺钉	Screw SM1/4"×40 L=8	1	
26	11.001.00066	压杆导架	Presser guide bar bracket	1	
27	11.002.00050	抬压脚后杆组件	Lifting lever link	1	
28	17.02.00047	抬压脚后杆	Lifting lever connecting rod	1	
29	11.002.00054	平垫圈8	Washer	1	
30	11.001.00059	螺母	Nut SM15/64"×28 L=20.5	1	
31	17.02.00086	螺钉	Screw SM11/64"×40 L=10	1	
32	17.02.00087	螺钉	Screw SM15/64"×28 L=11	1	
33	11.002.00043	橡胶垫圈Φ8	Washer	6	
34	17.03.00002	橡胶销	Lifting lever connecting rod	2	
35	11.002.00049	抬压脚前杆	Spring	1	
36	11.003.00017	松线踏板复位簧	Spring	1	
37	11.002.00093	抬压脚后杆弹簧	Spring	1	
38	18.06.00020	抬压脚电磁铁组件	Electromagnet components	1	
39	17.02.00102	螺钉	Screw SM3/16"×28 L=9	4	
40	17.02.00263	螺钉	Screw SM15/64"×28 L=11	1	
41	11.003.00023	下压板	Platen	1	
42	11.003.00023	压板	Screw SM9/64"×40 L=7.5	2	
43	11.029.00002	松线顶板组件	Apical plate	1	
44	11.003.00021	松线座	Loose wire base	1	
45	17.03.00003	橡胶销	Screw M8*1.0 L=20	1	
46	11.003.00022	松线簧	Spring	1	
47	17.02.00264	螺钉	Screw SM11/4"×28 L=21	1	

2. 上轴、挑线分组件/Main shaft&thread take-up components



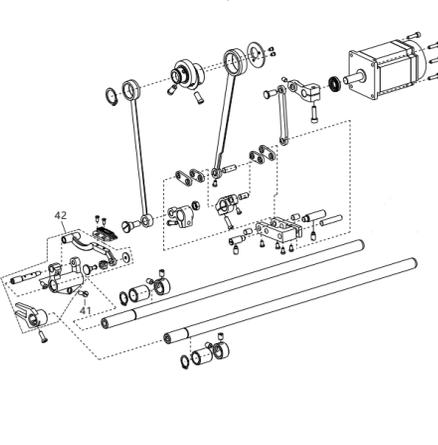
序号 Ref.No.	物料号 Part.No.	名称 Name	Description	数量 Qty	备注 Remark
1	11.002.00021	上轴中轴套	Bearing support	1	
2	11.002.00023	上轴后轴套	Bearing support	1	
3	11.002.00022	上轴前轴套	Bearing support	1	
4	11.001.00032	油封Φ15	Oil seal	1	
5	11.003.00011	外联轴器	Coupling	1	
6	11.003.00010	内联轴器	Coupling	1	
7	17.02.00078	螺钉	Screw SM9/32"×28 L=14.5	1	
8	11.000.00038	O型圈	O-ring	1	
9	11.002.00025	针杆曲柄	Counter weight	1	
10	17.02.00077	螺钉	Screw SM9/32"×28 L=16	1	
11	17.02.00071	螺钉	Screw SM15/64"×28 L=7	1	
12	11.000.00039	曲柄油量调节阀	Adjusting pin	1	
13	11.002.00026	曲柄油量限制块	Felt	1	
14	11.011.00002	曲柄油量调节阀套	Sleeve of adjusting pin	1	
15	11.000.00038	O型圈	O-ring	1	
16	11.010.00009	上轴	Main shaft	1	
17	11.002.00027	上轴挡圈	Thrust collar	1	
18	17.02.00089	螺钉	Screw SM1/4"×40 L=8	2	
19	11.002.00117	挑线器驱动轮	Wheel	1	
20	17.02.00261	螺钉	Screw SM11/64"×40 L=10	2	
21	11.001.00039	挑线杆防油套	Oil resistant cover	1	
22	17.01.00113	螺钉	Screw M6 L=8	8	
23	11.002.00094	挑线杆	Electromagnet	1	
24	11.002.00098	针杆连杆	Needle bar crank rod	1	
25	11.002.00099	咬线轴	Thread take-up crank shaft	1	
26	11.002.00100	螺钉	Screw SM9/64"×40 L=6	1	
27	11.002.00095	挑线曲柄	Needle bar crank	1	
28	11.002.00097	挑线连杆	Thread take-up bar	1	
29	11.002.00096	针杆连接柱	Needle bar holder	1	
30	17.02.00129	螺钉	Screw SM9/64"×40 L=6	1	
31	17.06.00001	轴承	Bearing	2	
32	17.02.00079	螺钉	Screw SM15/64"×28 L=15	1	
33	16.05.00023	挑线连杆润滑油	Oil thread	1	
34	11.001.00038	针距曲柄护板	Protective plate	1	
35	18.01.02.00010	上轴电机	Motor	1	
36	17.01.00113	螺钉	Screw M5 L=20	4	
37	17.05.00077	弹簧垫圈	Washer	4	
38	20.02.01.00013	手轮	Head wheel	1	
39	17.01.00113	螺钉	Screw M6 L=8	8	

5. 送料分组件/Feed Mechanism Components



序号 Ref.No.	物料号 Part.No.	名称 Name	Description	数量 Qty	备注 Remark
1	11.001.00077	前轴套	Bearing support	2	
2	11.001.00076	拾牙轴	Feed driving shaft	1	
3	11.001.00075	送料轴	Feed driving shaft	1	
4	11.002.00089	针距曲柄	rocker	1	
5	11.002.00054	针距连杆	Link	1	
6	17.01.00168	螺钉	Screw M5 L=18	1	
7	11.002.00055	针距电机曲柄销	Pin	1	
8	17.01.00117	螺钉	Screw M5 L=6	1	
9	11.002.00056	摆动座	Feed adjusting	1	
10	11.002.00057	摆动座销	Pin	1	
11	17.02.00084	螺钉	Screw SM9/64"×40 L=5	6	
12	17.02.00270	螺钉	Screw SM9/64"×40 L=6	2	
13	11.001.00096	摆动短轴	Short link	2	
14	11.001.00095	长摆动短轴	Short link	2	
15	11.001.00094	摆动短轴	Pin	2	
16	11.001.00092	拾牙连杆	Connecting rod	1	
17	17.02.00094	螺钉	Screw SM9/32"×28 L=22	1	
18	17.05.00077	轴用弹性挡圈20	Snap ring	1	
19	11.002.00210	送料偏心轮	Feed drive eccentric cam	1	
20	17.02.00096	螺钉	Screw SM11/4"×40 L=13	2	
21	11.000.00050	送料偏心轮盖板	Thrust cover	1	
22	11.002.00053	送料连杆	Connecting rod	1	
23	11.001.00091	送料连杆销	Pin	1	
24	11.001.00100	拾牙后曲柄	Lifting rocker	1	
25	17.04.00018	六角螺母	Nut SM1/4"×40 L=4.5	1	
26	17.02.00055	螺钉	Screw SM3/16"×28 L=15	1	
27	11.001.00098	送料曲柄销	Pin	1	
28	11.001.00099	送料曲柄	Feed rocker	1	
29	11.001.00104	摆动板左销	Pin	1	
30	11.001.00105	摆动板右销	Pin	1	
31	17.02.00082	螺钉	Screw SM15/64"×28 L=10.5	2	
32	11.000.00075	拾牙送料轴挡圈	Thrust collar	1	
33	17.02.00089	螺钉	Screw SM1/4"×28 L=8	4	
34	17.05.00077	轴用弹性挡圈15	Snap ring	2	
35	11.002.00058	油封10	Oil seal	1	
36	18.01.02.00012	针距电机	Motor	1	
37	17.01.00129	螺钉	Screw M4 L=16	4	
38	17.02.00097	螺钉	Screw SM11/64"×40 L=10.5	1	
39	11.000.00082	送料牙	Feed dog	1	
40	17.02.00098	螺钉	Screw SM1/8"×44 L=6	2	

5. 送料分组件/Feed Mechanism Components



序号 Ref.No.	物料号 Part.No.	名称 Name	Description	数量 Qty	备注 Remark
41	17.02.00276	螺钉	Screw SM3/16"×28 L=15.5	1	
42	11.001.00109	牙架组件	Feed bar ASM	1	
1	11.002.00060	切线轴套	Bearing support	1	
2	11.002.00062	切刀驱动曲柄轴	Cutter driving crank shaft	1	
3	11.002.00061	驱动曲柄轴衬套	Short bush	1	
4	11.002.00063	切刀驱动轴	Thread cutter driving shaft	1	
5	11.002.00064	弹簧	Spring	1	
6	11.002.00065	凸轮曲柄复位簧	Thrimming cam crank asm	1	
7	18.01.03.00024	显示屏组件	Display screen	1	
8	18.01.06.00015	LOGO屏组件	Logo screen	1	
9	17.02.00283	螺钉	Screw SM11/64"×28 L=14	1	
10	11.002.00068	驱动曲柄复位簧	Spring	1	
11	11.002.00071	凸轮凸轮	Thread cutter cam	1	
12	11.002.00072	剪刀刀架	Knife bracket	1	
13	11.002.00073	活动刀	Movable knife	1	
14	17.02.00288	螺钉	Screw SM11/64"×40 L=5.5	2	
15	11.002.00074	剪刀连杆	Connecting rod	1	
16	11.002.00076	刀架压板螺母	Washer	2	
17	11.002.00075	剪刀压板	Knife bracket presser	1	
18	17.02.00044	螺钉	Screw SM11/64"×40 L=8	2	
19	17.				