节能一体上下复合/ 综合送料厚料平缝机

Energy Saving And Composite/ Compound Feeding Lockstitch Sewing Machine

Instructions for Operating

操作说明书 CN

Edition版本

中国印制

为了安全地使用,请您在产品使用之前阅读本使用说明书。 工业缝纫机的特性之一, 是要在机针和旋梭等运动零部件附近进行操作, 而这些零部件 很容易引起受伤的危险,所以请在受过培训的人员或有熟练操作技术的人员的指导下,正确

此样本是二零二零年八月的数据而制成的,后期零件更改,恕不另行通知。

Read safety instructions carefully and understand them before operation. With industrial sewing machines, it is normal to carry out work while positioned directly in front of moving parts such as the needle and thread take-up lever, and consequently there is always a danger of injury that can be caused by these parts. Follow the instructions from training personnel and instructors regarding safe and correct operation before operating the machine so that you will know how to use it correctly This sample book is made in August 2020 and is subject to change without notice

为了您的安全使用 **SAFETY INSTRUCTIONS**

开机前的注意事项 Before Operation:

1.油盘内未加油绝不能开启缝纫机。

2.机器运转时,从手轮外侧看转向应为逆时针方向。注意,不能反方向旋转。

3.确认电控标识上的电压及相位是否正确。

1. Never operate the machine unless its oil reservoir has been filled with oil

by, hand to bring the needle down, and turn the power switch ON while obsering the handwheel. (The handwheel should turn counteclockwise as observed from the handwheel side) 3. Confirm that the voltage and phase(single or 3-phase) are correct by checking them against the ratings

2.After setting up the machine, check the direction of motor rotation. To check it, turn the handwheel

shown on the elcectronic identification

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部。

2.机器运转时,请勿将手指伸入挑线杆护罩内。

3.机头翻倒时,一定要拔下插头切断电源。 4.操作者离开机器时,必须切断电源。

5.机器运转期间,注意不允许任何人的头或手以及任何东西靠近绕线轮和手轮。 6.装拆防护罩,或者其他保护装置时,一定要拔下插头切断电源。

7.不要用丙酮等油漆稀释液剂擦洗机头表面。

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 finger 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.
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 bobbin winder or handwheel. Also, do not piace anything close to them. Doing so may be dangerous. 6. If your machine is provided with a finger guard or any other protectors, do not operate your machine

7.Don't clean the face of machine head with thinner.

环保要求 Environmental requirements:

1.使用过程中产生的废油及其他废弃物请根据当地环保的要求合理的处置。

2.请在说明书要求的电压及环境下使用,已延长产品的使用寿命,减少废弃物的产生。 3.机器报废后请勿将本机器及其附件作为普通的生活垃圾处置,请遵守本设备及其附件处理 的本地法令,并支持回收行为。

1. The waste oil and other wastes that produced in the process of using should be disposed reasonably according to the local environmental requirements. 2. Please use it under the voltage environment required by the instruction, so as to prolong the service life

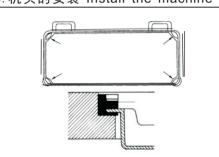
of the product and reduce the production of wastes.

3.Please don't treat the machine and its accessories as daily wastes when the machine discard, please

follow the local laws of the treatment of this equipment and its accessories and support recycle behavior.

使用说明书 Operation Instruction

3. 机头的安装 Install the machine

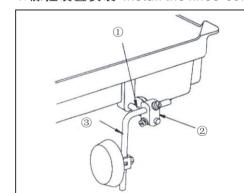


1)将机头支座固定在工作台凹槽四角。 2)将油盘四角搁在机头支架的中间。 3)将机头连接钩放入底板孔内,与台板的 机头铰链相嵌合, 再将机头放到四只角的 机头支座上。

1.Put the rubber cushion on the four corner of the tale 2.Hold the oil reservoir in the middle of the rubber

cushion 3 Put the head connecting book socket into table then connect the head connecting hook socket and the head connecting hook which should be on the head. and the machine head will be put on the oil reservoir.

4. 膝控装置安装 Install the knee-control device



1. 尽量拉出膝控铰链轴①,进行适当安装。 2. 在轴上装上膝控碰块接头②。 3. 在膝控碰块接头上装膝控碰块弯轴组件

EN

1.Pull the device ① and adjust it. 2.Install the joint 2. 3.Install device (3).

使用说明书 Operation Instruction

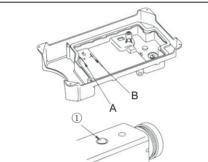
5. 润滑 Lubricating



加油结束之前,不能接触电源开关,否则误踩踏板启动,可能会受伤事故。加润滑油时,请使用保护身体的眼镜。手套防止与眼或皮肤接触, 同时应放在小孩碰不到的地方。 首次使用机械时,或长时间不使用时,必须加油。 Plug in only after oil supply is finished. If the operator mistakenly steps on the pedal with the plug in, the machine will start automatically and can cause severe injuries. When handling lubricants, wear protective glasses or gloves to avoid contact with

your eyes or skin. Inflammation may be caused otherwise. Never drink lubricants since they can cause vomiting or diarrhea. Keep out of the reach of children. Operate the machine only after adding oil when the machine is being used for the first time or has been left unused for a long time.

将油注入油盘A位置。



在操作过程中,需经常检查油位高度,如油位 低于B位置时须加油至A位置。 注意:操作机器时,可以通过油窗①检查油润 滑情况。

Fill oil pan with new special oil up to A. In the operating process, need to check the level of the oil level. After filling the oil pan, the oil surface should lie A lines. Note: Operating machine, Can through the oil window

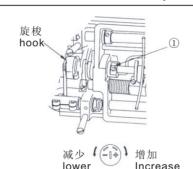
① check the oil lubrication condition.

注意

在以下机器的调整时,请关闭电源开关。误踩踏板机械启动时,可能会 使用离合式马达时,关闭电源后,由于惯性,马达会暂时旋转。马达完 注意
CAUTION Always turn off the power when mounting a needle. If the operation in the power is on, the machine will start automatically and can result

When using clutch motor, be aware that the motor will continue to rotate for a while even after the power is switched off due to inerlia. Starl to work on the sewing machine only after the motor has come to a complete stop.

6. 旋梭润滑的调整 Rotary hook lubrication adjustment



顺时针(+)转动油量调整螺丝①,出油量会 增加,相反逆时针(-)转动油量调整螺丝① 时,出油量会减少。 注:调整该螺钉后,机器应至少运转30秒钟, 然后检旋梭出油量。

When you turn clockwise (+) the lubrication adjustment screw (1) inserted in the front bushing of the lowery shaft, the amount of oil will increase while turning to counterclockwise (-) will decrease the amount.

Note: Adjust the screws, the machine should be running at least 30 seconds, then check whether the oil into the hook.

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EN

型号 Type

用途 Tailor

旋梭 Hook

1. 机器简介 Profile of the machine

Seam thickness capacity is even more remarkable.

2. 规格 Specifications

最高转速 Sewing speed

最大针距 Stitch length

挑线杆行程 Thread take-up

润滑系统 Lubrication system

绕线方式 Type of winding

剪线装置 Trimming device

自动抬压脚装置 Footlifter

Press foot hoisting

neight control

倒缝装置 Reverse stitching device

电子夹线器装置 Electrical tread nippe

配套电机功率 (W)

手提 Hand control

膝提 Knee

压脚交互量 Presser foot interactive quantity

外压脚操作系统 The presser foot operating systen

针杆行程 Needle

帐篷、沙发等皮革、帆布、厚重装饰布、织带类物品的缝制。

本系列平缝机单直针,采用连杆式送料,挑线杆挑线,旋梭勾线,形成301线迹。机 头加长设计,令操作回转空间更宽敞。超长针杆行程,大互动量交替压脚,使缝厚能力

本机采用油泵自动润滑,运转轻滑、噪音低、振动小,特别适合手箱包、汽车座垫、

Thick material up and down feeding a single straight needle sewing machine system, using the link type feed,

thread take-up pick-line, Rotating hook line, form 301 stitch. Extended nose design, make operation more

luggage, car seat, tents, sofas and other leather, Canvas, heavy fabrics, sewing items like ribbon.

spacious space rotation. Long needle bar stroke, a large amount of interaction alternating presser foot, so that

This machine adopts oil pump auto lubrication, smooth running light, low noise, vibration, especially for hand

单定针机型

全自动润滑大旋梭

无 ×

无 ×

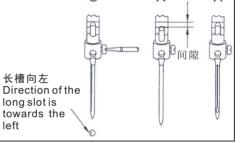
无 ×

无 ×

7. 安装机针 Replace needles

注意

为了防止意外的启动造成的事故,请关掉电源后进行。 Turn OFF the power before starting the work so as to prevent accidents caused by abrupt 注意 | furn OFF the power bolo... | Start of the sewing machine.



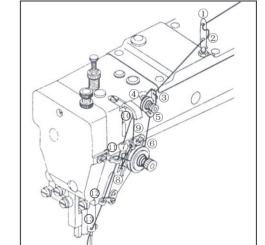
注意: 用涤纶线倒缝时若发生断线,前机针 的长槽向前侧转,有可能会避免该情况发生。 一般避免将长槽朝向后侧。

插入机针至底部, 拧紧螺钉, 保持长槽方向

Needle should reach the bottom of needle bar, and

then tighten the screw. Direction of the long slot is

8. 穿面线 Routing upper thread



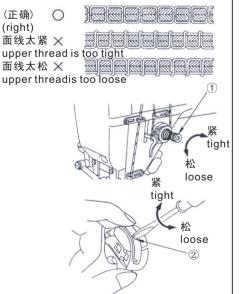
Into the thread take-up position, then as shown

将挑线杆转到最高位置, 然后如图所示穿

threading.

使用说明书 Operation Instruction

9. 线张力调整 Adjusting the thread tension



1. 线调整装置 如图所示, 顺时针转动压线螺母①, 面线 张力会变强,相反则会变弱。根据布料、 缝线、线距等缝纫条件,线的张力会有所 不同, 因此需要按照不同情况, 进行调整。 2. 底线张力调整 如图所示,在底线调整螺钉②上利用起子,

顺时针转动,底线张力会变强,相反则会 变弱。

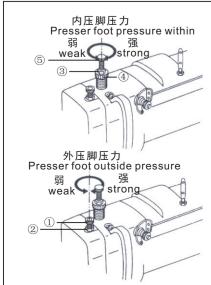
1.Thread control assembly

Like in Figure, turning the tension adjustment nut ① of the thread tension control assembly clockwise makes the upper thread tension stronger and

counterclockwise makes it weaker. The result of the needlework depends on the sewing conditions such as the sewing material, used thread and stitch length. So please adjust as desired. 2. Adjusting the thread take up tension

As in Figure 27, insert the driver into the groove ② of the thread tension control assembly. Turn clockwise to make the spring tension stronger and counter

10. 压脚压力的调整 Presser foot pressure



要调整内压力时, 顺时针转动压力调整螺 丝①,压力会变强,相反则会变弱。调整 后,必须完全拧紧固定螺丝②。 外压脚也同样, 顺时针转动压力调整螺丝 ③,压力会变强,相反则会变弱。调整后,

必须完全拧紧固定螺丝④。此外, 左右转

动辅助压力调节螺丝,进行微细调节。

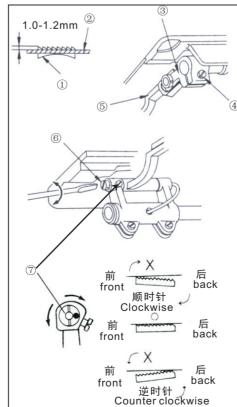
The pressure of the upper feed presser foot becomes stronger when you turn the pressure adjustment screw clockwise, and becomes weaker in case of turning.

it counterclockwise.

After the adjustment, be sure to tight the fixing nut2. The auxiliary presser foot is same to the upper feed presser foot: the pressure increases when you turn the pressure adjustment screw3 clockwise, and becomes weaker in case of turning it counter clockwise. After the adjustment, be sure to tight the fixing nut4. In case of fine adjustment, use the auxiliary pressure adjustment screw5.

使用说明书 Operation Instruction

11. 调整送布牙 Adjusting the feed dog



(1)送布牙①应高于针板②平面1.0-1.2mm 1)放松抬牙曲柄(前)③上的螺钉④,然后将 牙架⑤上下移动。

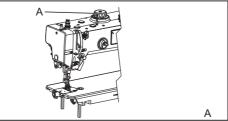
2) 调整结束后, 旋紧螺钉④。 2. 调整送布牙倾角

(1)旋松螺钉⑦. (2)用螺钉刀左右旋转牙架曲柄偏心轴⑥进 行整。若顺时针转动, 牙架曲柄偏心轴⑥、 牙齿前高后低, 若按相反方向逆时针转动 牙架曲柄偏心轴⑥、牙齿前低后高。

(3)调整结束,旋紧螺钉⑦。 EN

1. Feed dog height. (1)Feed dog $\begin{tabular}{ll} $\overset{-}{\mbox{0}}$ should higher than <math>\begin{tabular}{ll} \mathbb{Z} 1.0mm. \end{tabular}$ (2)Adjust the feed dog height. 1)Loose the screw 4 in crank 3 and lower down 5. 2)After adjust,tight the screw 4. 2. Adjust the feed dog angle. (1)Loose screw 7. (2)Adjust 6

12. 内外压脚的调整 Adjusting the auxiliary and upper feed presser foot



1. Adjustment of interactive motion

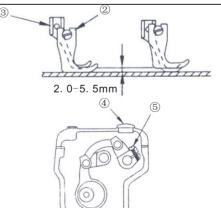
1)内外压脚的交互量调整范围为2mm-5.5mm。 2) 内外压脚的交互运动量可通过机壳上的 注:由小到大进行调整时,顺时针转动压脚交

互量调节旋钮A。相反,由大到小进行调整时, 逆时针转动压脚交互量调节旋钮A。

Note: When adjusting the amount from small to big, You can turn the dial A (the adjusting knob) clockwise. To the opposite, when adjusting the amount from big to small, turn the dial A counterclockwise.

使用说明书 Operation Instruction

12. 内外压脚的调整 Adjusting the auxiliary and upper feed presser foot



2. 改变内外压脚的交互运动的平衡

1)取下上盖板上的橡皮塞④。 2)旋转主动轮直到内压脚③从针板上抬起。

3)旋松螺钉⑤。 4)将内压脚向下调到接触针板,再旋紧螺

(1)增加外压脚②的提升量并减少内压脚③

5)这样,内压脚的提升量就减少一定的值, 而外压脚的提升量则增加同样的数值。 (2)与上面相反的情况,减少外压脚的提升 量,增大内压脚提升量的调整如下:

1)首先,旋转主动轮直到外压脚抬离针板。 2)旋松螺钉⑤。 3)调好后,旋紧螺钉⑤。这样将减少外压

脚的提升量

2. To change the balance the interactive movement of

(1) Increase the height of outer presser foot ② and decrease the height of inner presser foot ③. 1) Remove rubber stopper 4 from the upper back cover.

2) Rotate the hand wheel until inner presser foot ③ lift from the needle plate.

3) Loosen the screw (5).

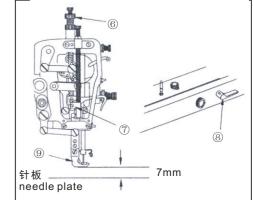
4) Lower the inner presser foot to the needle plate and tighten screw (5).

5) In this way, the height of the inner presser foot decreased by a certain value and the outer increased by the

(2) Contrary to the above, to decrease the height of the outer presser foot and increase the height of the inner presser foot, the adjustment is as follows: 1) Firstly, rotate the hand wheel until the outer presser foot lifted from the needle plate

2) Loosen screw (5).

3) After adjustment, tighten screw 3, thus decreasing the height of the outer presser foot. 3. 外压脚的调整方法



松开调压螺钉⑥和压杆导架螺钉⑦。 提升压脚扳手⑧时,上下调整压杆导架螺

让外压脚⑨提升到离针板上面8毫米的位置。 调整完后,完全拧紧压杆导架螺钉⑦。适 当调好调压螺钉⑥。

3. Adjusting the auxiliary presser foot

Loosen the presser bar pressure adjustment screw ® and the bracket fixing screw (7). Adjust vertically the bracket fixing screw ⑦so that the auxiliary presser foot 9 goes up by 8mm from the upper side of the needle plate when the presser bar lifter (8) is up. When the adjustment is finished, fix tightly the bracket

fixing screw ⑦and adjust adequately the pressure adjustment screw ⑥.

1. 交互运动的调整 提升压脚标盘A来调节。

(3)Finish and tighting ⑦.

1) For the interaction amount of the inner and outer presser foot, The adjustment range is 2mm-5.5mm. 2) The interactive amount of the inner and outer presser foot can also be adjusted through the dial A which is for

有o 选配 Optional

全自动润滑大旋梭(剪线) Auto-lubrication with bighool

三自动机型

中厚料~厚料 Thick

2200rpm

9mm

38mm

73mm

2. 0-5. 5mm

标盘 Standard plate

DPx17 22#/23#

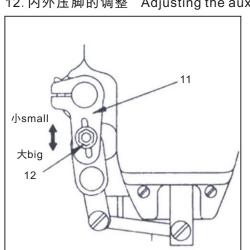
自动供油 Auto-Jubrication

内置绕线器 Built-in winding device

7mm

16mm

12. 内外压脚的调整 Adjusting the auxiliary and upper feed presser foot

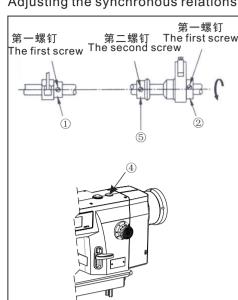


4. 外压脚运动量的调整 外压脚和送布牙运动量以1:1为标准,根 据缝制条件,能调整外压脚的运动量。 松开位于压脚摆动曲柄(左)11上的螺母12, 往上移动提升压脚变动曲柄轴, 运动量会 变小,相反就会变大。

Adjusting feeding amount of auxiliary presser foot The normal proportion of feeding amount between the feed dog and the auxiliary presser foot is 1:1. You can adjust the feeding amount of the auxiliary presser foot in accordance with the conditions of materials in use. loosen the nut 12 and move upward the presser foot vertical move control shaft, and the feeding amount becomes smaller. If you move it downward, the amount increases. Be sure to tight the nut 12 when the adjustment is finished.

13. 送布牙同步关系的调整

Adjusting the synchronous relationship of the feed dog



1. 转动手轮, 使针杆位于最高位置; 2. 打开上盖,如图所示位置:送布凸轮" 左"①的第一颗螺钉和送布凸轮"右"②上的 第一颗螺钉与上轴中心线位于同一平面上。 注: 送布凸轮②的位置调节, 可以取下上 盖上的橡皮塞④进行调整,但是单齿轮⑤ 不易看到,调节时应小心保护。

1.turn the pulley with hands to fix the needle bar to the

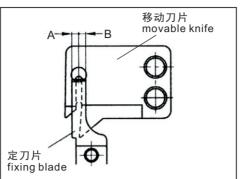
highest point. 2. The standard position will be when the center of the No.1 fixing bolt of the presser foot vertical move cam 1) is aligned with the center line of the upper shaft, the bottom of the No. 1 fixing bolt of the feed cam 2 is aligned with the center line of the upper shaft. Caution: When adjusting the feed lifting cam⁽²⁾ users canremove the rubber plug4 of the upper cover. During adjusting, users should be cautious because it is hard to have a vision of the single gear 5.

使用说明书 Operation Instruction

14. 剪线机构的调整 Adjusting for thread trimmer (自动剪线型) 1. 本缝纫机的切线机构如下图所示。

1. The structure of thread trimmer of this machine is as follows in figure. Base for solenoid counecting link 电磁铁安装架 Thread trimmer solenoid 剪线电磁铁 Thread guide 栏线板 || || Thread trimming solenoid 剪线凸轮 定刀片 knife 动刀片 oving knife 归位弹簧 return sping 煎线驱动曲板 剪线凸轮左曲柄 剪线凸轮右曲柄 thread trimme camasm crank (lift) camasm crank (right)

10



2. 定刀与动刀的调整

(1)如图所示,其标准是动刀片断面位于定 刀片中央的。

(2)若图上的A部变大,就会发生三段线。 这成为切线后从针孔里脱离锋线的原因。 此外, 若B部变大, 就成为切线错误的原因, 因此请注意。

(1) Like in Figure , the standard position is where the cut part of the movable knife is aligned with the center of the fixed blade. (2) When part A becomes bigger in figure, three pieces of threads are to be produced, causing the thread

2. Adjusting fixing blade and movable knife

missing after the trimming. If part B becomes bigger, it can cause a trimming miss So be cautious in adjusting the right position.

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电磁铁链接件 固定螺钉

electromagnet link a

0. 5mm

fixed screw 4.6mm

剪线凸轮左曲柄 left crank of the thread trimming cam 归位弹簧 剪线凸轮右曲柄 right crank of the thread trimming car shaft sleeve 87. 5mm

(1)装配时,将剪线曲柄轴①最先装在底板 (2)剪线凸轮左、右曲柄必须如图所示安

装,固定在剪线轴①上的平面处。 (3)轻轻转动剪线轴①,将限位块②安装在

3. Adjusting the crank of the thread trimming cam (1)While assembling, users should first set the crank shaft of the thread trimming cam on the platform. (2)The left and right crank must be set on the flat of the thread trimming shaft referring to the Figure. (3) Gently rotate the trimming shaft ①, and set the set block ② on the flat of the trimming shaft ①.

4. 安装剪线电磁铁 (1)剪线电磁铁的行程: A. 标准的行程为4.6mm.

B. 通过调节螺母A来调整行程。

(2)剪线电磁铁的调整

A. 电磁铁的安装位置以电磁铁工作时, 凸 轮左曲柄③与凸轮右曲柄②之间有0.5mm间 隙为标准。

B. 如需调整, 可按图所示箭头方向移动电 磁铁安装架。

4. installation of thread trimmer

(1)working amount of the thread trimming solenoid. A. The standard working amount of the thread trimming solenoid is 4.6mm.

B. By adjusting the nut to adjust A trip. (2)adjusting the thread trimming solenoid

A. If you run the solenoid under this circumstance, a gap of 0.5mm occurs between the left crenk 3and the right crank 2. This state is the standard.

电磁铁安装 架螺钉

mounts screw

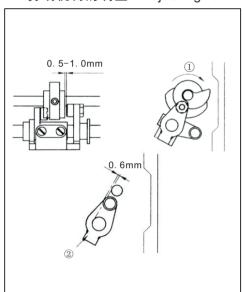
螺母A 架螺钉 nut A electromagne

B. If you need to adjust. Can be shown as shown in figure and direction of arrow mobile electromagnet mounts.

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14. 剪线机构的调整 Adjusting for thread trimmer(自动剪线型)



5、安装剪线凸轮 (1)转动手轮,挑线杆位于最低点时,在启 动剪线电磁铁状态下,朝正方向回转剪线凸 轮①直到接触滚柱,然后固定凸轮。 (2)剪线电磁铁关闭, 使凸轮曲柄②恢复到 原始位置, 凸轮与滚柱端面以0.5-1.0mm间 隙为标准。

5. Installing the thread trimmer CAM (1) Turn the handwheel, until the wire rod is at the lowest position, meantime starting the thread trimmer electromagnet, turn the thread trimmer CAM ① to the positive direction until it touches the roller, then fix the

(2) Turn off trimmer electromagnet, put CAM crank back to the original position, and take this as the standard: the distance between CAM and roller is 0.5-1.0mm.

6、刀片位置调整

(2)动刀移动量调整:

(3)刀片压力调整:

需增加定刀张力即可。

钉A来调节刀片压力。

1.5mm。

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(1)动刀与定刀的位置调整:

如图所示, 动刀①与机针中心的距离为7.5

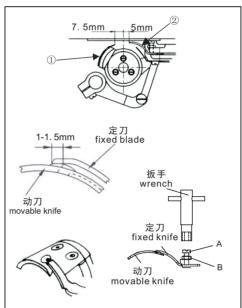
开动电磁铁,启动机器.剪线凸轮会使动刀 ①向右旋转。当动刀①移动到其最远位置 时, 其断面定刀②的端点进行到1.0mm-

如果剪线情况不良, 尤其当线较粗时, 只

定刀张力可调整:松开螺母B,通过调节螺

mm,定刀②与机针中心的距离为5mm。

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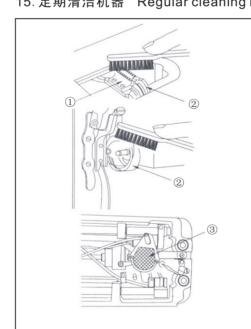
6. Adjusting the position of blade (1) Adjusting the position of the movable knife $\ensuremath{\textcircled{\scriptsize 1}}$ and the fixed blade 2.

The standard position of the movable knife is 7.5mm from the needle center, and 5 mm for the fixed blade. (2) Adjusting the progress amount of the movable knife If you run the machine putting the solenoid in the operation mode, the movable knife ① will rotate by the thread trimming cam. The standard will be where the cut part of the movable knife $\ensuremath{\textcircled{1}}$ progresses1.0 to 1.5 mm from the end edge of the fixed blade $\ensuremath{@}$ when the progress amount of the movable knife is in its

maximum. (3) Adjusting blade pressure In particular, when the cutting quality gets worse by using a thick thread, streng then a little bit the tension of the fixed blade.

In order to adjust the tension of the fixed blade, loosen the tension adjustment nut with the wrench box and adjust the tension using the tension adjustment bolt.

15. 定期清洁机器 Regular cleaning machine

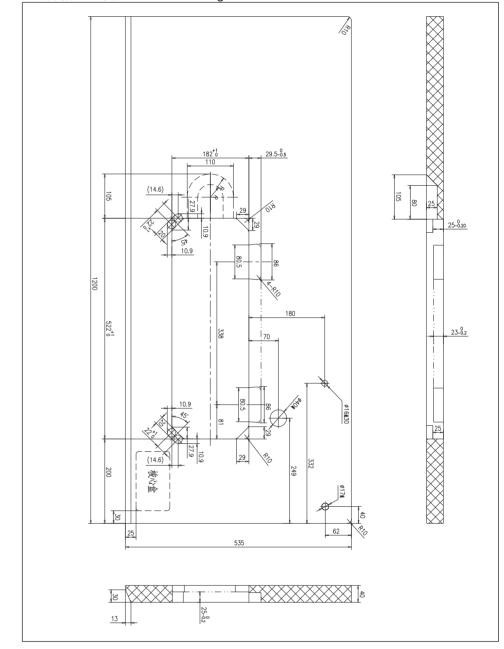


定期清扫送布牙①、旋梭②和油泵③。

Regular cleaning feed dog ①, hook② and pump hook

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16. 台板加工图 Schematic diagram of the machine table



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定刀 fixed knife

动刀 movable knife

	坟障原因及 Ⅰ机故障处:			
编号	故障状态	确认事项	故障原因	处理事项
	树 谷十	针的方向、高度	插针方向不好	把针向正确的方向重新插人,紧贴到最 上端
		针	针弯	换针
1		送布牙定时	机针与送布牙定时不好	调整送布牙定时
		针杆提升量	针与旋梭的定时不好	调整针与旋梭的定时
		针杆高度	针与旋梭的定时不好	调整针与旋梭的定时
		针与旋梭之间的间隙	针与旋梭的定时不好	调整针与旋梭的定时
	斯线	穿线状态	穿线错误	正确穿线
		针	针弯,针尖断了	换针
		针的方向、高度	插针位置不好	向正确方向插针
2		面线张力	面线张力过大	适当调整面线张力
		底线张力	底线张力过大	适当调整底线张力
		挑线器弹簧工作量	工作量过大	调整弹簧工作量
3	收线状态 不良	线张力	面线底线张力不好	调整上下线的张力
		挑线器弹簧张力	挑线器弹簧张力不适当	调整挑线器弹簧张力
		定位勾和旋梭间的间隙	定位勾和旋梭间的间隙不好	调整定位勾和旋梭间的间隙
	缝纫开始时, 面线掉出或跳 针	针的方向、高度	插针位置不好	向正确方向插针
		针	针弯,针尖断了	换针
		穿线方法	穿线错误	正确穿线
4		针与旋梭间的缝隙	针与旋梭的定时不好	调整针与旋梭的定时
_		切线后的面线余量	针上的面线余量过短	把控制面板的面线余量调整幅度调大
		分线片	切线后,分线片无法夹住底线	适当调整分线片的位置及张力
		针上面停止位置确认	针上面停止位置不好,缝纫开始时,挑 线器把面线拉出去	针上面停止时, 重新调整胶片位置
5	不能切线	动刀片与旋梭间的缝隙	动刀片与旋梭高度及距离不符合	重新调整动刀片的设定位置
		固定刀片张力确认	动刀片与固定刀片的张力及接触状态不好	调好动刀片与固定刀片的张力及接触状态
		针方向	插针状态不好	正确插针
		动刀片、固定刀片刀刃	动刀片、固定刀片刀刃有毛病或磨损	交换动刀片、固定刀片
		切线凸轮定时	切线凸轮定时不对	调整切线凸轮定时
		线松开工作量	线松开工作量过少	重新调整线松开工作量
6	切线结束后缝 线余量过短	切线定时	切线定时不对	调整切线定时
		夹线器的松紧量	夹线器松紧量过小	调整夹线器松线量
		辅助线张力调整装置 张力	辅助线张力调整装置张力过大	调整辅助线张力
		挑线器弹簧工作量	挑线器弹簧工作量过大	调整挑线器弹簧工作量
		控制面板的线松开调整 幅度	幅度调整得过小	把幅度调大

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17. Causes of troubles and troubleshshooting

No	Symptom	Checkpoints	Root cause	Corrective action
1	Needle breaks	Direction and height of needle	Needle is inserted into wrong position	Reinsert the needle correctly
		Needle	Needle is bent	Change the needle
		Timing of feed dog	Bad timing of feed dog	Adjust the timing of feed dog
		Ascending level of needle bar	Bad timing of needle and hook	Adjust the timing of needle and hook
		Height of needle	Bad timing of needle and hook	Adjust the timing of needle and hook
		Gap between needle and hook	Bad timing of needle and hook	Adjust the timing of needle and hook
2	Thread breaks	Threading method	Wrong threading	Thread the needle correctly
		Needle	Bent needle or broken needle tip	Change the needle
		Direction and height of needle	Needle inserted in the wrong position	Insert the needle correctly
		Upper thread tension	Too tight upper thread tension	Reduce tension of upper thread
		Lower thread tension	Too tight lower thread tension	Reduce tension of lower thread
		Working capacity of take-up lever spring	Loose upper thread	Adjust take-up lever spring
3	Poor thread adjustment	Thread tension	Upper and lower thread tensions are bad	Adjust the upper and lower thread tensions
		Thread take up spring tension	Thread take up spring tension is inadequate	Adjust the thread take up spring tension
		Gap between opener and hook	The gap between the opener and hook is inadequate	Adjust the gap between the opener and hook
	Upper thread falls out when starting to sew or sewing is skipped.	Direction and height of needle	Needle is inserted into wrong position	Reinsert the needle correctly and push in to its highest level.
		Needle	Needle is bent	Change the needle
		Threading	Wrong direction	Insert the thread in the right way.
		Gap between the needle and the hook	The timing between the needle and hook is bad	Adjust the timing between the needle and hoo
4		Remaining upper thread length after trimming	The length of the remaining upper thread is too short	Increase the adjustment volume of the upper thread on the control box
		Lower thread holder	After trimming, lower thread holder does not hold the lower thread	Adjust the location and tension of the lower thread holder.
		Check the up-stop position of the needle	Due to problems in the up-stop position of the needle, the thread take up lever pulls the upper thread out of the needle when the sewing starts	Readjust the needle's up-stop film position
5	Trimming miss	The gap between the movable knife and the hook	The height and distance between the movable knife and the hook do not match	Readjust the movable knife setting position
		Check the tension of fixed knife	Tension and contact of movable and fixed knives are bad	Correct the tension adjustment and surface contact of movable and fixed knives.
		Direction of the needle	Needle is not inserted correctly	Insert the needle correctly
		Blade side of movable and fixed knives	Scratch and abrasion of movable and fixed knives	Replace movable knife or fixed knife.
		Trimming cam timing	The timing of trimming cam is wrong	Adjust the timing of trimming cam
		Thread release stroke	Thread release stroke is too small	Readjust the thread release stroke
6	Too short thread length after trimming	Trimming timing	Wrong trimming timing	Adjust the trimming timing
		Opening of the thread tension adjusting plate	The opening on the thread tension control plate is too small	Adjust the thread release stroke
		Tension of auxiliary thread tension adjustment assembly	Too strong tension on the auxiliary thread tension control assembly	Adjust the tension of the auxiliary thread tension control assembly

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18. 本产品执行标准是QB/T 4793-2015。工业用缝纫机计算机控制上、下 复合送料平缝缝纫机。

Zhe product implementation standard is QB/T 4793-2015. Industrial sewing machine computer controlled top and bottom feed lockstitch sewing machine.

Adjust the thread take up stroke

Thread take up stroke is too large

Thread take up stroke

Thread release adjustment volume on the control box

剪线轴①上的平面处。

3、剪线凸轮曲柄位置的调整