

# 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 GB 操作说明书 CN

Edition版本 2020 Printed in China 中国印制 Part No.零件号 1304-330100

为了安全地使用, 请您在产品使用前仔细阅读本使用说明书。  
工业缝纫机的特性之一, 是在机针和旋梭等运动部件附近进行操作, 而这些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, 正确地使用本缝纫机。  
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.  
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 counterclockwise 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 shown on the electronic 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清洗机头表面。
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 thread take-up cover while the machine is operating.  
3. Be sure to turn the power switch OFF before tilting the machine.  
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 place 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 with any of them removed.  
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

#### 1. 机器简介 Profile of the machine

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。超长杆行程, 大互动量交替压脚, 使缝厚能力更出色。

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、汽车坐垫、帐篷、沙发等皮革、帆布、厚重装饰布、织带类物品的缝制。

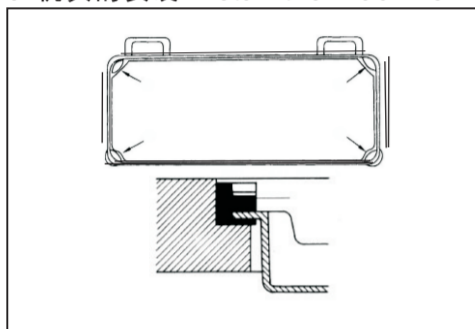
Thick material up and down feeding a single straight needle sewing machine system, using the link type feed, thread take-up pick-line, Rotating hook line, form 301 stitch. Extended nose design, make operation more spacious space rotation. Long needle bar stroke, a large amount of interaction alternating presser foot, so that Seam thickness capacity is even more remarkable.  
This machine adopts oil pump auto lubrication, smooth running light, low noise, vibration, especially for hand luggage, car seat, sofas and other leather, Canvas, heavy fabrics, sewing items like ribbon.

#### 2. 规格 Specifications

型号 Type	单针机型	三自动机型
用途 Tailor	中厚料-厚料 Thick	
最高转速 Sewing speed	2200rpm	
最大针距 Stitch length	9mm	
针杆行程 Needle	38mm	
挑线杆行程 Thread take-up	73mm	
压脚交互量 Presser foot interactive quantity	2.0-5.5mm	
外压脚操作系统 The presser foot operating system	标盘 Standard plate	
机针 Needle	DPx17 22#/23#	
旋梭 Hook	全自动润滑大旋梭 Auto-lubrication with big hook	全自动润滑大旋梭(前缘) Auto-lubrication with bighook (auto-trimmer)
润滑系统 Lubrication system	自动供油 Auto-lubrication	
绕线方式 Type of winding	内置绕线器 Built-in winding device	
剪线装置 Trimming device	无 X	有 o
倒缝装置 Reverse stitching device	无 X	有 o
自动抬压脚装置 Footlifter	无 X	选配 Optional
电子夹线器装置 Electrical tread nippe	无 X	有 o
压脚提升高度 Press foot hoisting height control	手摆 Hand control	7mm
	膝提 Knee	16mm
配套电机功率 (W)	750W	750W

### 使用说明书 Operation Instruction

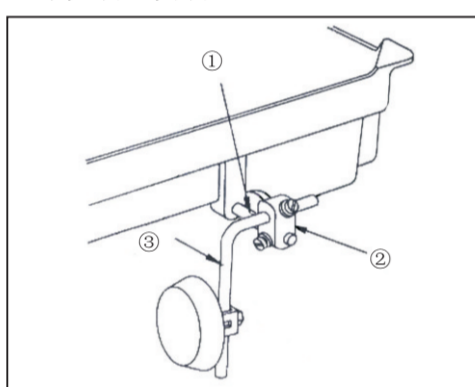
#### 3. 机头的安装 Install the machine



- 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, 与台板的机头较链相嵌合, 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 table socket.  
2. Hold the oil reservoir in the middle of the rubber cushion.  
3. Put the head connecting hook 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. 在轴上装上膝控铰链接头②。
3. 在膝控铰链轴上装上膝控铰链弯轴组件③。

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

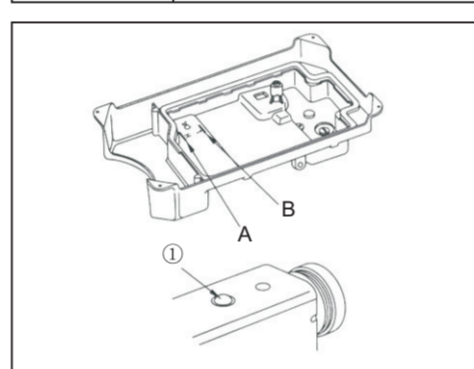
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### 使用说明书 Operation Instruction

#### 5. 润滑 Lubricating



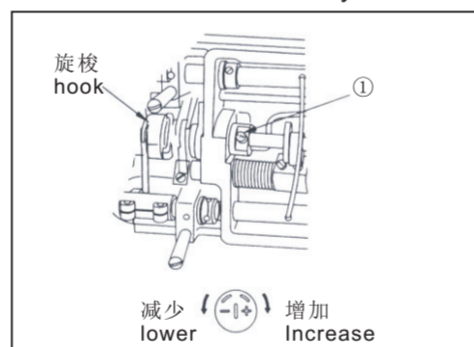
加油结束之前, 不能接触电源开关, 否则误踩踏板启动, 可能会受伤事故。加润滑油时, 请使用保护身体的眼镜。手套防止与眼或皮肤接触, 同时应放在小孩碰不到的地方。首次使用机头时, 或长时间不使用, 必须加油。  
Plug in only after oil supply is finished. If the operator mistakenly steps on the pedal with the plug in, the machine will start automatically and can cause severe injuries. When handling lubricants,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

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, 可能会发生身体损伤事故。使用离合式马达时, 关闭电源后, 由于惯性, 马达会暂时旋转。马达完全停止后, 进行操作。  
Always turn off the power when mounting a needle. If the operator mistakenly steps on the pedal while the power is on, the machine will start automatically and can result in physical injuries. 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 inertia. Start 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



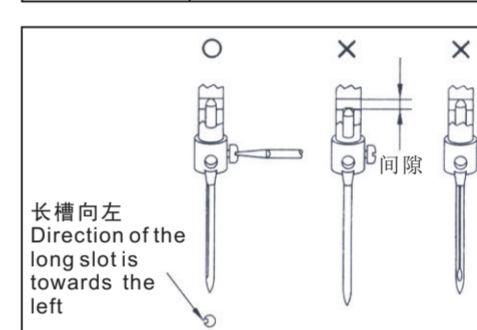
顺时针 (+) 转动油量调整螺丝①, 出油量会增加。相反逆时针 (-) 转动油量调整螺丝①时, 出油量会减少。  
注: 调整该螺钉后, 机器应至少运转30秒钟, 然后检查旋梭出油量。  
When you turn clockwise (+) the lubrication adjustment screw ① inserted in the front bushing of the lower shaft, the amount of oil will increase while turning to counterclockwise (-) will decrease the amount. 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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### 使用说明书 Operation Instruction

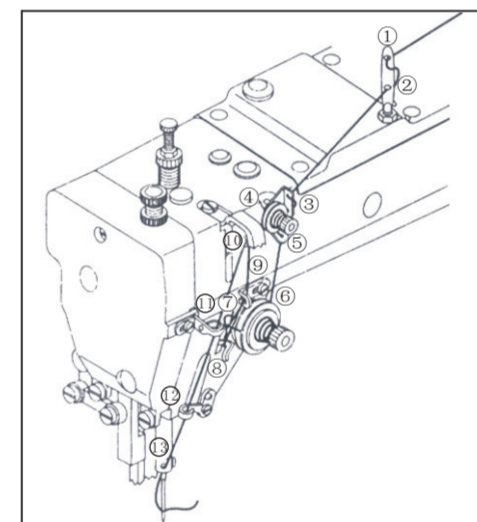
#### 7. 安装机针 Replace needles

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



插入机针至底部, 拧紧螺钉, 保持长槽方向向左。  
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。  
Needle should reach the bottom of needle bar, and then tighten the screw. Direction of the long slot is towards the left.  
Needle should reach the bottom of needle bar, and then tighten the screw. Direction of the long slot is towards the left.

#### 8. 穿面线 Routing upper thread

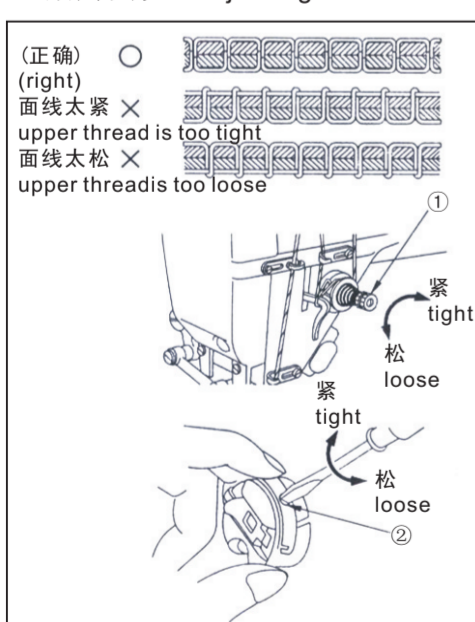


将挑线杆转到最高位置, 然后如图所示穿线。  
Into the thread take-up position, then as shown threading.

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### 使用说明书 Operation Instruction

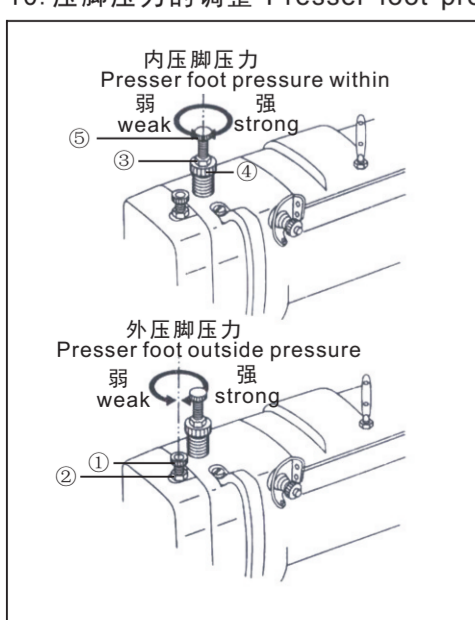
#### 9. 线张力调整 Adjusting the thread tension



1. 线调整装置  
如图所示, 顺时针转动压力调整螺母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 clockwise to make it weaker.

#### 10. 压脚压力的调整 Presser foot pressure

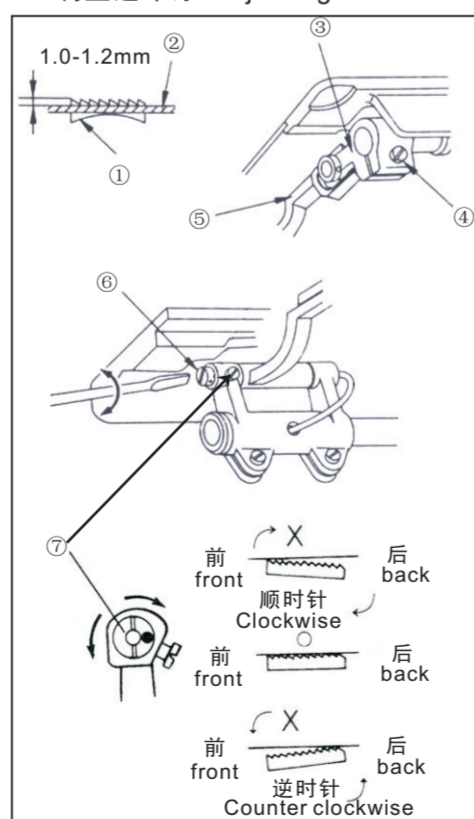


要调整内压力时, 顺时针转动压力调整螺丝①, 压力会变强, 相反则会变弱。调整后, 必须完全拧紧固定螺丝②。  
外压脚也同样, 顺时针转动压力调整螺丝③, 压力会变强, 相反则会变弱。调整后, 必须完全拧紧固定螺丝④。此外, 左右转动辅助压力调节螺丝, 进行微调调节。  
The pressure of the upper feed presser foot becomes stronger when you turn the pressure adjustment screw ① clockwise, and becomes weaker in case of turning it counterclockwise.  
After the adjustment, be sure to tight the fixing nut ②.  
The auxiliary presser foot is same to the upper feed presser foot: the pressure increases when you turn the pressure adjustment screw ③ clockwise, and becomes weaker in case of turning it counter clockwise.  
After the adjustment, be sure to tight the fixing nut ④.  
In case of fine adjustment, use the auxiliary pressure adjustment screw ⑤.

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### 使用说明书 Operation Instruction

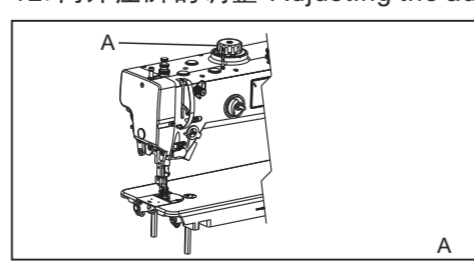
#### 11. 调整送布牙 Adjusting the feed dog



1. 送布牙高度  
(1) 送布牙①应高于针板②平面 0.1-1.2mm 为宜。  
1) 放松送布牙曲柄(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。

1. Feed dog height.  
(1) Feed dog ① should higher than ② 1.0mm.  
(2) Adjust the feed dog height.  
1) Loosen the screw ④ in crank ③ and lower down ⑤.  
2) After adjust, tight the screw ④.  
(2) Adjust the feed dog angle.  
(1) Loosen screw ⑦.  
(2) Adjust ⑥.  
(3) Finish and tightening ⑦.

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



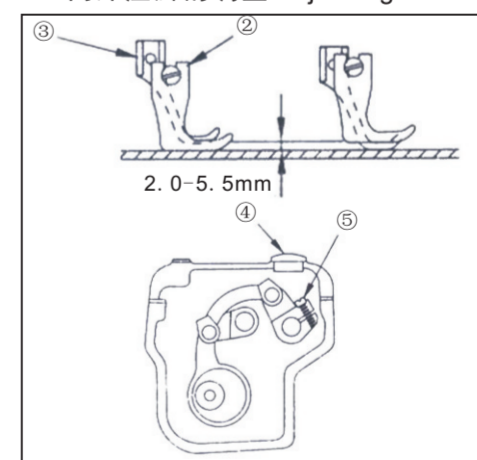
1. 交互运动的调整  
(1) 内外压脚的交互量调整范围为2mm-5.5mm。  
(2) 内外压脚的交互运动量可通过机壳上的提升压脚标盘A来调节。  
注: 由小到大进行调整时, 顺时针转动压脚交互量调节旋钮A。相反, 由大到小进行调整时, 逆时针转动压脚交互量调节旋钮A。

1. Adjustment of interactive motion  
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 lifting the presser foot.  
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.

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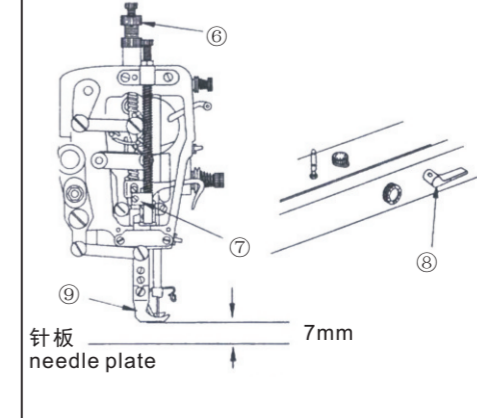
### 使用说明书 Operation Instruction

#### 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) 增加外压脚②的提升量并减少内压脚③的提升量。  
1) 取下上盖板上橡皮塞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, 再旋紧螺钉⑤。  
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起针板。  
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 inner and outer presser foot  
(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 same value.  
(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 ⑤, 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钉⑦。  
让外压脚⑨提升到离针板上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 ⑥ and the bracket fixing screw ⑦, so 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 ⑦ and adjust adequately the pressure adjustment screw ⑥.

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