

# 自动剪线双针机

Auto-trimmer Double Needle Machine

Instructions for Operating GB

操作说明书 CN

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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，正确地使用本缝纫机。  
此样本是二零二一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 2021 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，一定要按下插头切断电源。
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，一定要按下插头切断电源。
7. 不要用丙酮等油漆稀释剂清洗机头表面。
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 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 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:

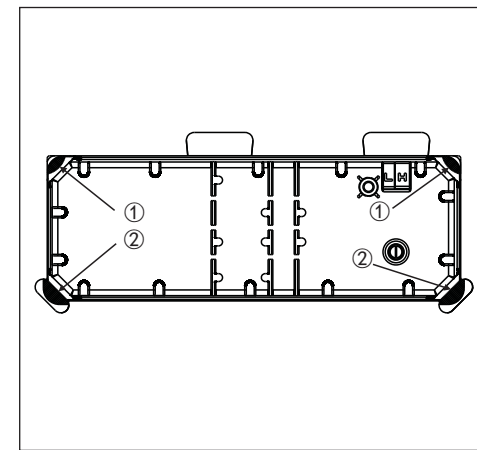
1. 使用过程中产生的废油及其他废弃物请根据当地环保的要求合理的处置。
2. 请在说明书要求的电压及环境下使用，已延长产品的使用寿命，减少废弃物的产生。
3. 机器报废后请勿将本机器及其附件作为普通的生活垃圾处置，请遵守本设备及其附件处理的本地法令，并支持回收行为。
1. The waste oil and other wastes that produced in the process of using should be disposed reasonably according to the local environmental requirements.
2. Please use 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.

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使用说明书 Operation Instruction

## 1. 缝纫机的安装 Installation

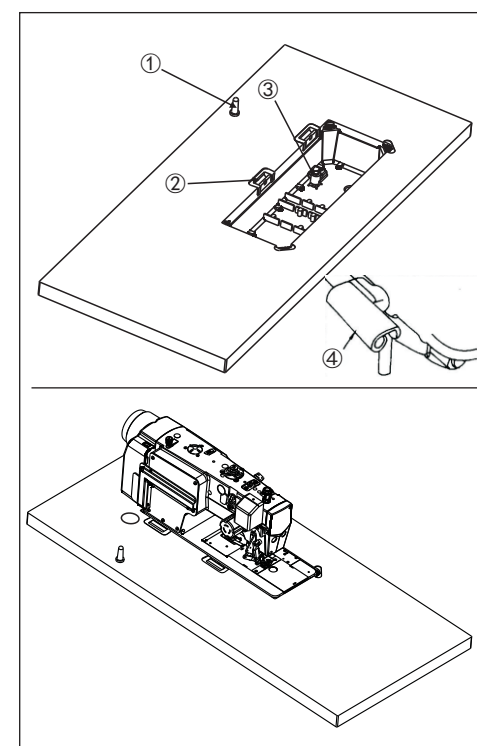
### (1) 油盘的安装 Installing the oil pan



- 1) 油盘应搁在工作台凹槽四角。
- 2) 如图所示，先将两只油盘支座小①与两只油盘支座大②分别置于油盘的四周，然后将油盘③与油盘支座按如图所示方向放置于台板上。

1) The oil pan should rest on the four corners of the machine table groove.  
2) Fix two rubber seats ① and two rubber seats ② on the four corners of the oil pan ③ the oil pan should rest on the machine table groove.

### (2) 铰链的安装 Installing the hinge



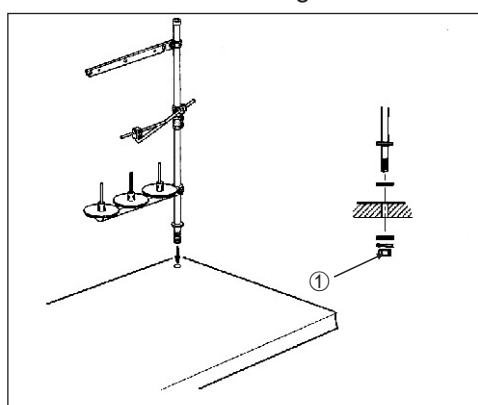
- 1) 将油盘放入台板槽内并将膝控顶杆支撑杆③放入油盘孔内；
- 2) 将机头支柱①放入台板孔内；
- 3) 将机头连接钩④放入底板孔内，与台板的机头连接钩座②相嵌合，再将机头放到四只角的机头支座上。

1) Put the oil pan into the table groove and put the knee lever support rod ③ into the oil pan hole.  
2) Fit hinge ① into the opening in the machine bed.  
3) Put the head connecting hook socket ④ into table hole, then connect the head connecting hook socket ② and the head connecting hook which should be on the head, and the machine head will be put on the oil reservoir.

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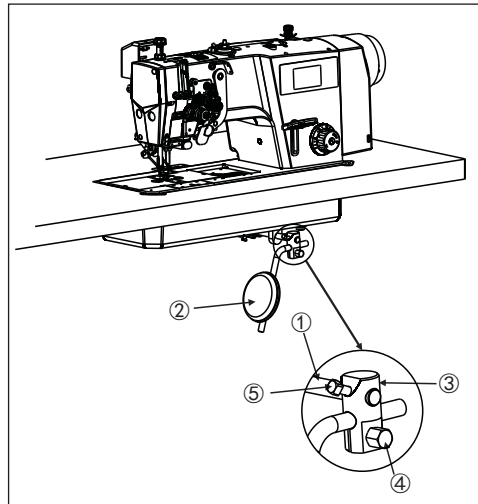
## 2. 线架的安装 Installing the thread stand



- 1) 如图所示把线架安装到台板上角孔上。
- 2) 用固定螺母①固定线架。

1) Assemble the thread stand unit, and insert it in the hole in the machine table.  
2) Tighten locknut ① to fix the thread stand.

## 3. 膝提组件的安装 Knee lifter asm



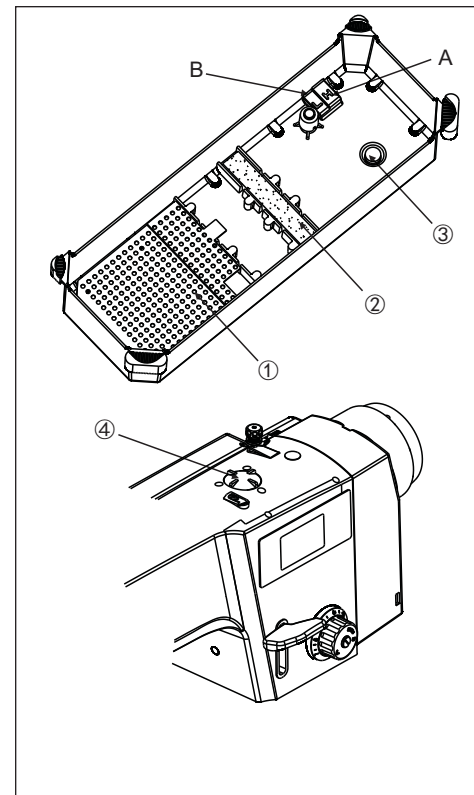
- 1) 将操纵杆组件②装到膝抬压脚连接轴①上，并用操纵杆接头③连接，最后拧紧接头螺钉④和⑤；
- 2) 根据个人需求，拧松接头螺钉④可调整操纵杆左右的位置，拧紧接头螺钉⑤可调整操纵杆的前后位置。

1) Install the Knee lifter plate rod ASM ② on the knee foot lifter ①, then connect it with regulator link ③, finally tighten connection screw ④ and ⑤.  
2) Accordingly to your requirement, unscrew the connection screw ④ can adjust the regulator position (left and right). Unscrew the connection screw can adjust the regulator position (front and behind) ⑤.

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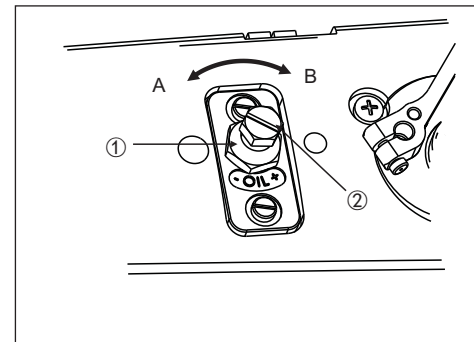
## 4. 加油 Lubrication



- 1) 将油盘过滤网①和油盘过滤毡②分别放入油盘内，再将油盘磁铁③放入油盘内，具体位置如图。
- 2) 把专用10#缝纫机润滑油加入到油盘内，加到H标记A的位置。
- 3) 如果油面降到L标记B以下时，请再次把油加至H位置。
- 4) 加油后运转缝纫机，润滑正常时应能看到油窗④里油面跳动。
- 5) 油跳动的量与油量的多少无关，因此不用担心。

(注意) 新缝纫机或较长时间没有使用的缝纫机，应进行约10分钟每分钟1500针的磨合运转。  
1) Put the oil pan filter ① and the oil pan filter felt ② into the oil pan, and then put the oil pan magnet ③ into the oil pan, the specific positions are shown in the picture.  
2) Fill oil pan with New Special Oil up to HIGH mark.  
3) When the oil level lowers below L mark, refill the oil pan with the specified oil.  
4) When you operate the machine after lubrication, you will see splashing oil through oil sight window ④ if the lubrication is adequate.  
5) Note that the amount of the splashing oil is unrelated to the amount of the lubricating oil. (Caution) When you first operate your machine after setup or after an extended period of disuse, run your machine at 1500 s.p.m. for about 10 minutes for the purpose of break-in.

## 5. 面部油量的调节 Adjustment of facial oil



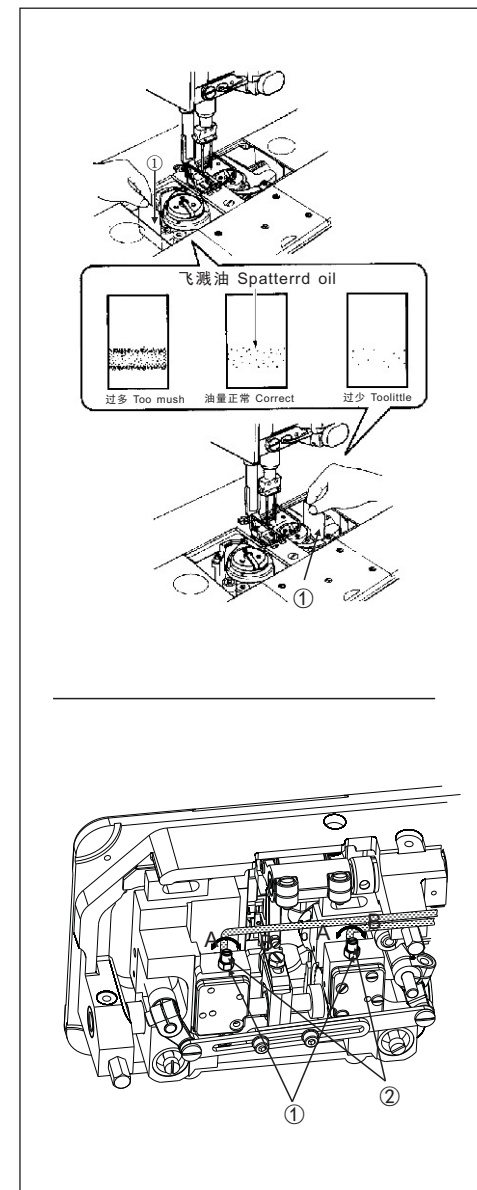
- 1) 拧松锁紧螺母①，调整面部调节螺钉②，沿顺时针B方向调整油量减少，沿逆时针A方向调整，油量变大，调整好以后，重新锁紧螺母①。

loosen the locked nut ①, adjust the adjustment screw ② adjust the oil amount in clockwise direction B to decrease, adjust in the counterclockwise direction A, the oil amount becomes bigger. After adjustment, re-tighten the nut ①.

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## 6. 旋梭油量的确认和调节 Confirm the amount of oil



- 1) 切断电源开关；
- 2) 取下机针和梭芯；
- 3) 用抬压脚扳手抬起压脚；
- 4) 接通电源开关；
- 5) 以缝纫机实际运转的速度进行约1分钟的空转；
- 6) 将油量测试纸①插入旋梭的左侧并握住，以缝纫机的实际转速运转8秒（右侧旋梭用同样方式检测）；
- 7) 确认飞溅到测试纸上的油量。

Hook lubrication amount checking  
1) Turn off the power switch  
2) Remove the needle and the bobbin  
3) Use the hand lifter to take up the presser foot  
4) Turn on the power switch  
5) Run the machine at the normal sewing speed for about 1 minute without sewing any material.  
6) Place the lubrication amount check sheet ① to the left of the rotary hook and hold it in place while running the sewing machine at the normal sewing speed for about 8 seconds. (Right side checking as the same way)  
7) Check the amount of oil which has splattered onto the sheet.

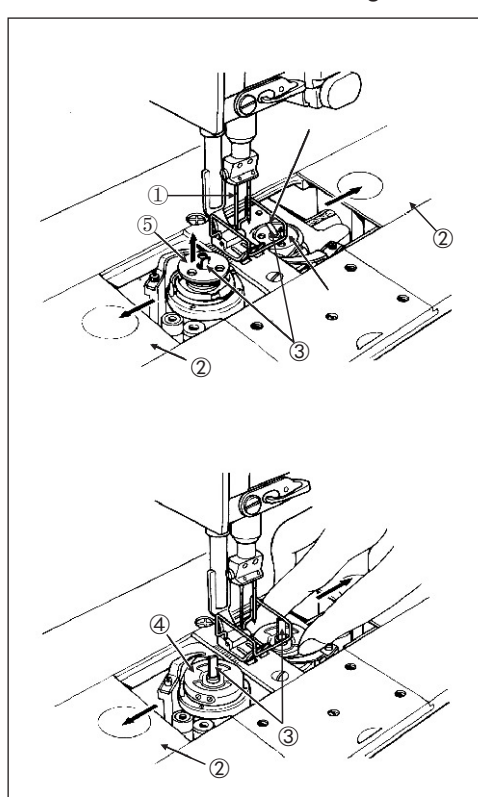
- 1) 旋梭油量的调节
- 2) 拧松油量调节螺母①，调整旋梭油量调节螺钉②，沿顺时针B方向调整油量减少，沿逆时针A方向调整，油量变大，调整好以后，重新锁紧螺母①。

Hook lubrication amount adjustment  
Loosen the adjusting nut ①, adjust the hook oil quantity adjustment screw ②, adjust the oil quantity in clockwise direction B to decrease, and adjust in the counterclockwise direction A to increase. After adjustment, re-tighten the nut ①.

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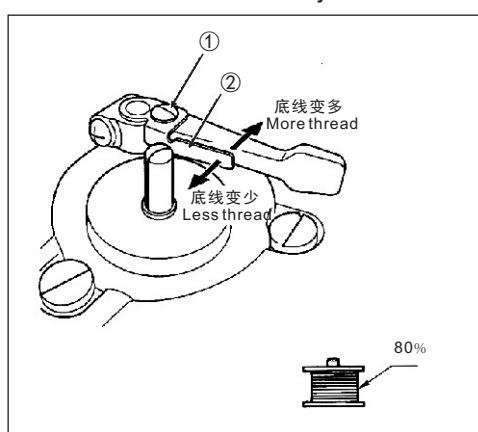
## 7. 梭芯的拆卸方法 Removing the bobbin



- 1) 无梭芯套  
将机针停在最高位置，将左右推板②向两边分开，竖立起旋梭把③，取出梭芯⑤。
- 2) 有梭芯套  
将机针①停在最高位置，将左右推板②向两边分开，竖立起旋梭把③，取出梭芯套④，取出梭芯⑤。

1) No bobbin case  
Stop the needle ① at the highest position, separate the left and right push plates ② to both sides, erect the hook ③, and take out the bobbin ⑤.  
2) With bobbin case  
Stop the needle ① at the highest position, separate the left and right push plates ② to both sides, erect the hook ③, take out the bobbin case ④, and take out the bobbin ⑤.

## 8. 梭芯绕线量的调整 Adjust the bobbin winding amount



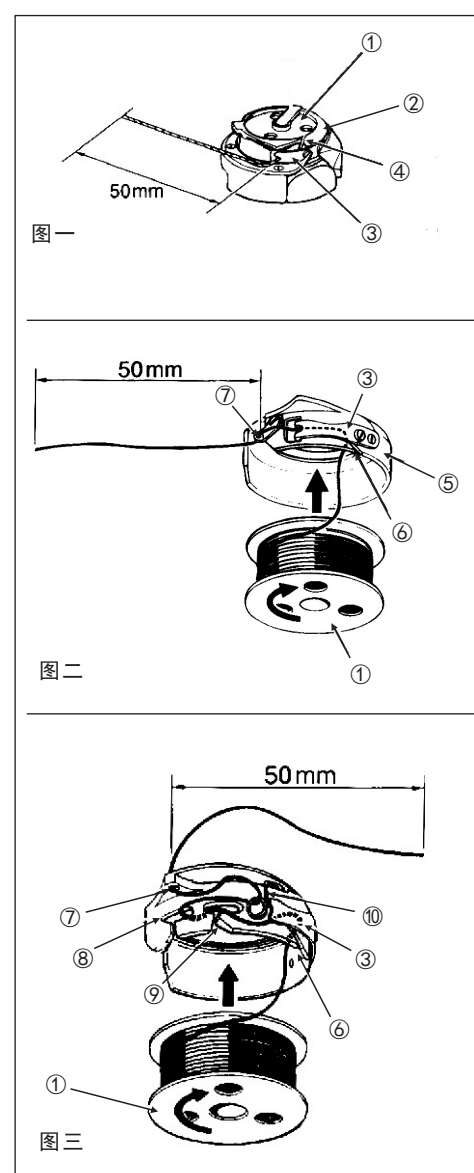
- 1) 松开梭芯压杆螺钉①，左右移动梭芯调节板②来调整梭芯的绕线量；
- 2) 调整完成后重新拧紧梭芯压杆螺钉①。

Note: The winding amount of the bobbin should be about 80% of the bobbin.  
1) Loosen the bobbin presser screw ①, move the bobbin adjusting plate ② left and right to adjust the winding amount of the bobbin.  
2) After adjust, re-tighten the bobbin presser screw ①.

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## 9. 底线的穿线方法 Winding the bobbin thread



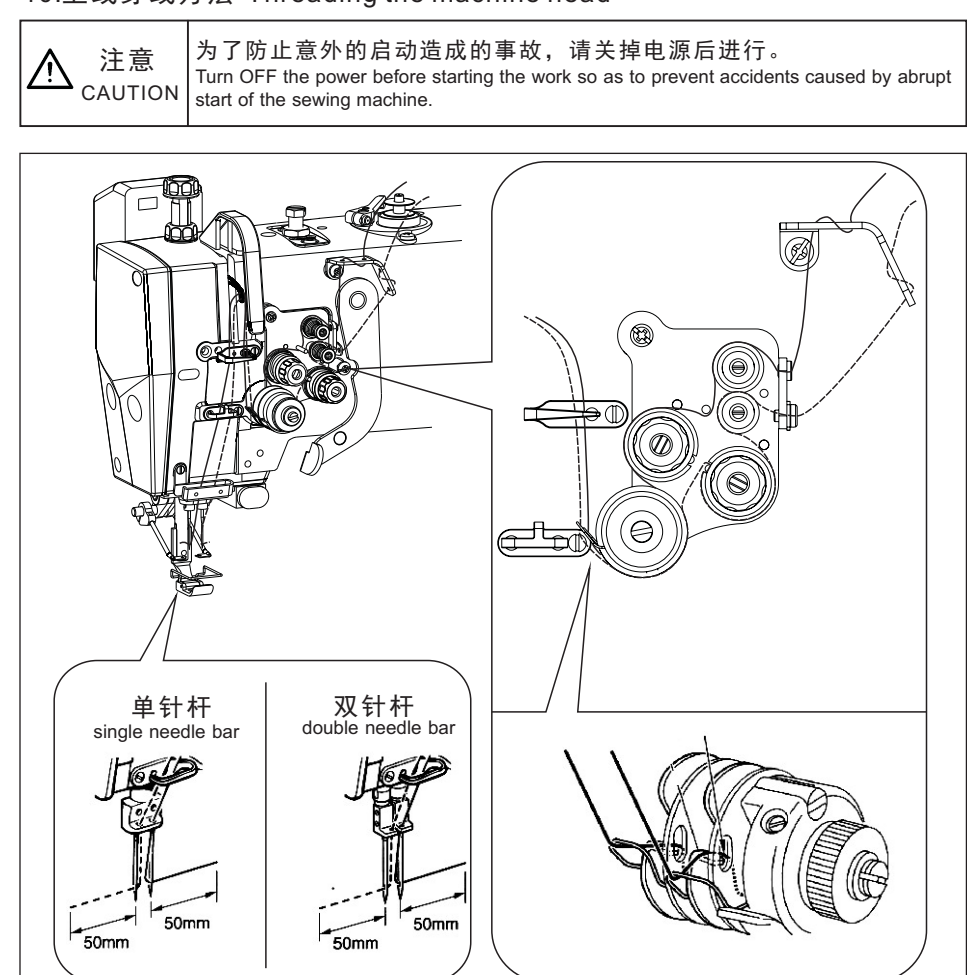
- 1) 单针杆小旋梭机型底线穿线方法  
如左图一所示，将梭芯①放入旋梭②内，将线从旋梭的线槽④穿入后，从底线张力调整盘③的端部拉出来，线长约50mm。
- 2) 单针杆大旋梭机型底线穿线方法  
如左图二所示，首先将梭芯①放入梭芯套⑤内，然后将线穿过线槽⑥，并经过张力弹簧③，从过线孔⑦拉出，线长约50mm。
- 3) 双针杆机型底线穿线方法  
如左图三所示，首先将线穿过线槽④，并经过张力弹簧③，再将线穿过⑧⑨，使线钩在底线张力弹簧⑩上，最后将线从过线孔⑦拉出，线长约50mm。

1) The way to wind the bobbin thread for the single needle small hook model  
As the left picture 1 shows, insert the bobbin ① into the bobbin winder ②, pass the bobbin thread through thread curve ④ in the rotary hook, and then pass it under the thread tension adjusting disc, pull the thread out for around length of 50mm.  
2) The way to wind the bobbin thread for the single needle big hook model  
As the left picture 2 shows, firstly insert the bobbin ① into the bobbin winder ⑤, then pass the bobbin thread through thread curve ⑥ in the rotary hook, and then pass it under the thread tension spring ③, pull out the thread through thread hole to a length of approximately 50mm.  
3) The way to wind the bobbin thread for the double needle model  
As the left 3rd picture shows, Pass the bobbin thread through slit ④ firstly, pass it under the thread tension spring ③, then pass thread through ⑧⑨, and then through the spring ⑩, finally pass the thread through the thread hole ⑦ and pull out about 50mm.

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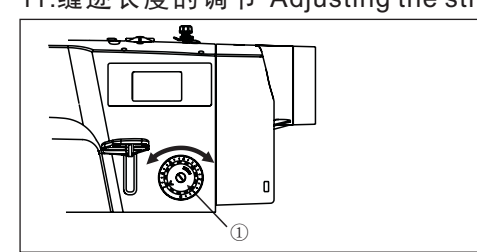
使用说明书 Operation Instruction

## 10. 上线穿线方法 Threading the machine head



注意 CAUTION 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 start of the sewing machine.

## 11. 缝迹长度的调节 Adjusting the stitch length



- 1) 按下旋钮①同时沿箭头方向旋转，把箭头位置对准标盘的刻线。
- 2) 刻度盘的数字单位为mm。

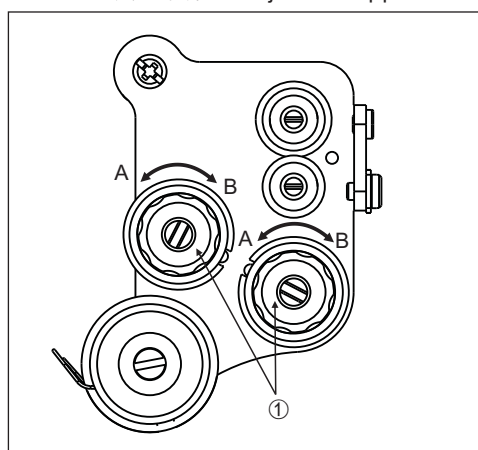
1) Press down the needle pitch knob ① and rotate it along the direction of the arrow to align the arrow position with the marking line of the dial.  
2) The dial calibration is in millimeters.

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### 12. 线张力的调整 Thread tension adjustment

#### (1) 面线张力的调整 Adjust the upper thread tension

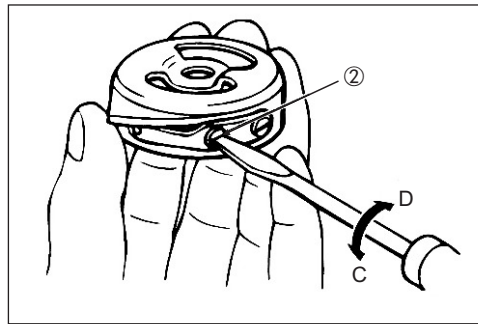


- 1) 把线张力螺母①向顺时针(B方向)转动, 上线张力变强。
- 2) 向逆时针方向(A方向)转动则变弱。

**EN**

- 1) Turn the adjusting screw ① to direction B (clockwise), the tension becomes stronger.
- 2) Turn the adjusting screw ① to direction A (counterclockwise), the tension becomes weaker.

#### (2) 底线张力的调整 Adjust the lower thread tension



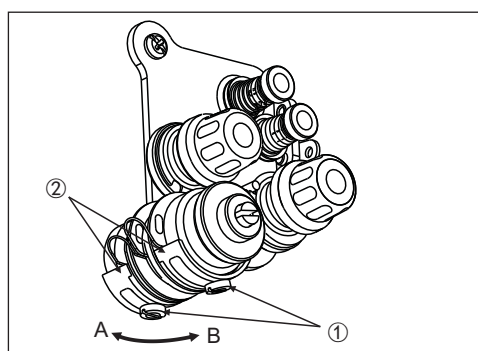
- 1) 如图所示, 向顺时针方向(D方向)转动张力调整螺钉②, 底线张力会变大;
- 2) 向逆时针方向(C方向)转动则张力变小。

**EN**

- 1) As shown in the picture, turn the tension adjustment screw ② clockwise (direction D), the lower thread tension will be stronger.
- 2) Turn to counterclockwise (direction C), the tension will be weaker.

### 13. 挑线器弹簧张力的调整 Adjust the tension of the thread take-up spring

#### (1) 挑线器挑线量的调整 Adjusting the thread take-up amount

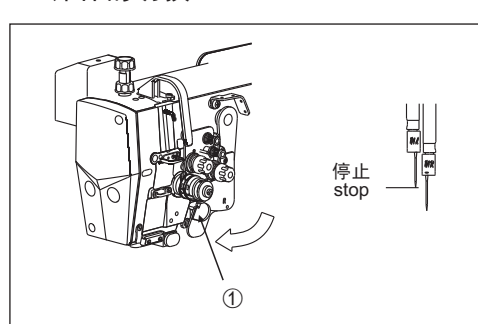


- 1) 如图所示, 拧松限位螺钉①, 将挑线簧限位板螺钉往顺时针(A方向)转动, 挑线簧的挑线量将变少, 相反则会变多。挑线簧的工作量一般为5至10mm。

**EN**

As shown in the picture, loosen the limit screw ①, and turn the thread take-up spring limit plate screw clockwise (direction A), the thread take-up amount will decrease, otherwise it will increase. The workload of the thread take-up spring is generally 5 to 10 mm.

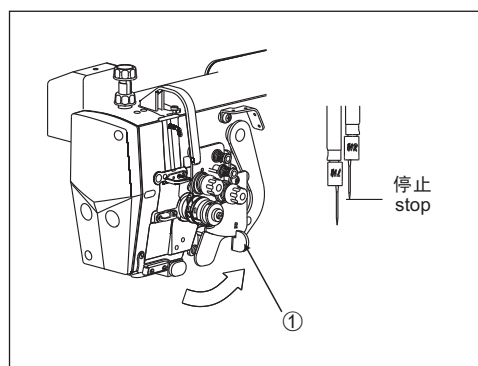
### 17. 针杆的切换 The switch of needle bar



1. 停止左侧针杆时  
把变位扳手①移动到L(左侧)

**EN**

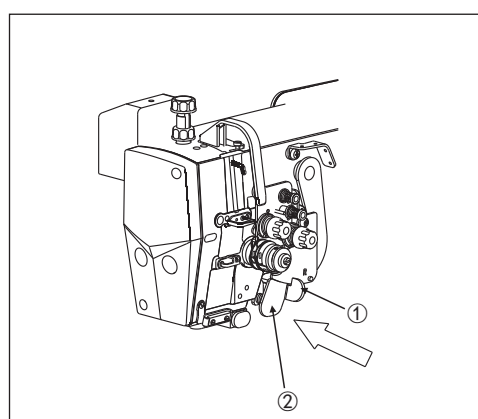
- 1) When the left side needle bar stops  
Move the position-changing lever ① to L (left side).



2. 停止右侧针杆时  
把变位扳手①移动到R(右侧)

**EN**

- 2) When the right side needle bar stops  
Move the position-changing lever ① to R (Right side)

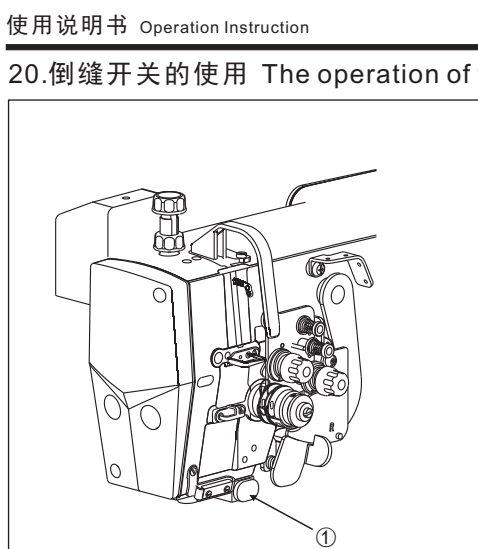


3. 双针杆缝制时  
往垂直方向按下针杆复位板②, 则变位扳手①自动回到原位。

**EN**

- 3) When the two needle bars work together  
Push the reset plate ② towards vertical direction, then position-changing lever ① will back to original position.

### 20. 倒缝开关的使用 The operation of thread nipper switch

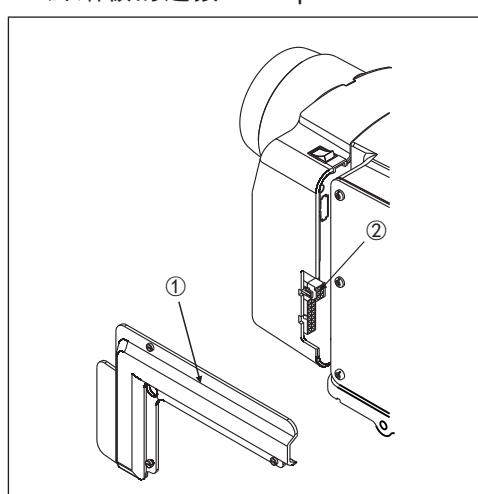


1. 在缝制过程中, 按下倒缝开关①, 则机器马上倒缝, 松开后则正常缝制。
2. 在停止缝制时(不剪线的情况下), 按下倒缝开关①, 则进行补针动作。

**EN**

- 1) During the sewing process, the moment you press on the thread nipper, the machine performs reverse feed stitching, and the machine resumes normal feeding at the moment the thread nipper is released.
- 2) When sewing stops (meantime without thread trimmer), press on the thread nipper, it will work as mending stitch function.

### 21. 脚踏板的连接 Foot pedal control system connection



- 先拧下后线盖上的三个螺钉, 卸下后线盖①, 然后将脚踏板的连接头插入②处后, 装回后线盖①。

**EN**

Loose the three screws, discharge back wire cover ①, put the pedal plug into the connector ②, then re-install the back wire cover.

### 22. 踏板的调整 Adjustment of the pedal



1. 连接杆的安装
- 1) 向箭头方向移动踏板调节板③, 让马达控制杆①和连接杆②成一直线。
2. 踏板的角度
- 1) 调节连接杆的长度即可以改变踏板的角度。
- 2) 拧松调节螺丝④, 移动连接杆②进行调节。

**EN**

- 1) Installing the connecting rod
- 1) Move pedal ③ to the right or left as illustrated by the arrows so that motor control lever ① and connecting rod ② are straightened.
- 2) Adjusting the pedal angle
- 1) The pedal tilt can be freely adjusted by changing the length of the connecting rod.
- 2) Loosen adjust screw ④, and adjust the length of connecting rod ②.

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

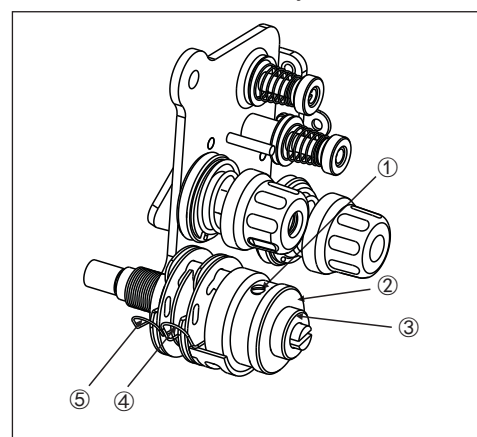


1. 踏板踩踏压力的调整
- 1) 摘下踏板压力调节弹簧①进行调节。
- 2) 把弹簧挂到左侧A向压力变轻。
- 3) 挂到右侧B向压力变大。
2. 踏板还力的调整
- 1) 用返踩调节螺丝②可以进行调节。
- 2) 拧紧调节螺丝压力变大。
- 3) 拧松螺丝压力变轻。
3. 踏板行程的调整
- 1) 把连接杆③安装到左侧的孔内, 行程变小。

**EN**

- 1) Adjusting the pressure required to depress the front part of the pedal
- 1) This pressure can be changed by altering the mounting position of pedaling pressure adjust spring ①.
- 2) The pressure decreases when you hook the spring on the left side.
- 3) The pressure increases when you hook the spring on the right side.
- 2) Adjusting the pressure required to depress the back part of the pedal
- 1) This pressure can be adjusted using regulator screw ②.
- 2) The pressure increase as you turn the regulator screw in.
- 3) The pressure decrease as you turn the screw out.
- 3) Adjusting the pedal stroke
- 1) The pedal stroke decreases when you insert connecting rod ③ into the left hole.

### (2) 挑线簧张力的调整 Adjust the tension of the thread take-up

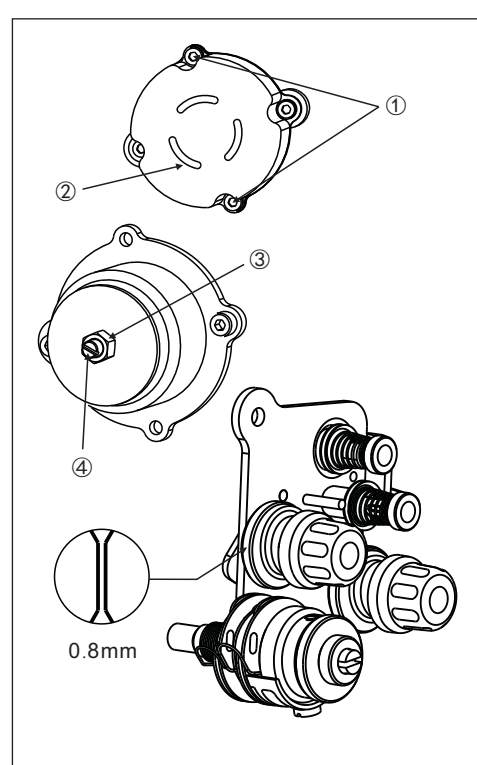


- 如图所示, 拧松夹线器固定螺丝①, 调节螺母②可改变外侧挑线簧④的挑线力, 调节螺母③可改变内侧挑线簧⑤的挑线力。挑线簧的张力一般为30g至70g。

**EN**

As shown in the picture, loosen the fixing screw ①, the adjusting screw ② can change the thread take-up force of the outer thread take-up spring ④ and the nut ③ can change the thread take-up force of the inner thread take-up spring ⑤. The tension of the spring is generally 30g to 70g.

### 14. 夹线器开量的调节 Adjust the opening of the thread clamp

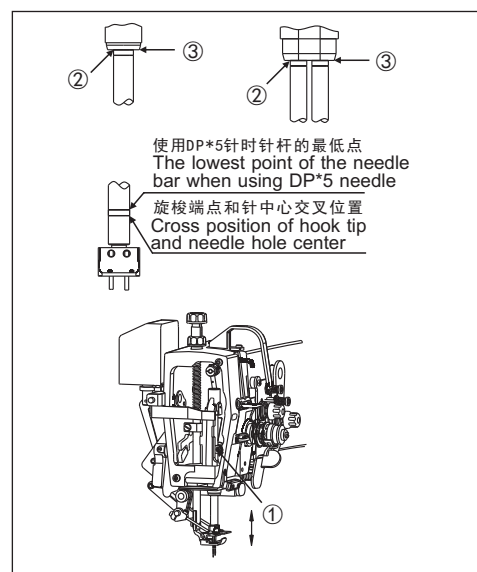


- 1) 拧掉2颗松线电磁铁固定螺钉①。
- 2) 取下松线电磁铁罩壳②。
- 3) 拧松电磁铁螺母③。
- 4) 用螺丝刀转动电磁铁芯螺钉④, 往顺时针方向转动夹线器开量变大, 相反则会变小。
- 5) 夹线器开量一般在0.8mm左右。

**EN**

- 1) Unscrew the 2 fixing screws ①.
- 2) Remove the cover of the solenoid ②.
- 3) Loosen the screw ③.
- 4) Use a screw driver to turn the solenoid screw ④, and turn the thread clamp clockwise to increase the opening, and vice versa.
- 5) The opening of the thread clamp is generally about 0.8mm.

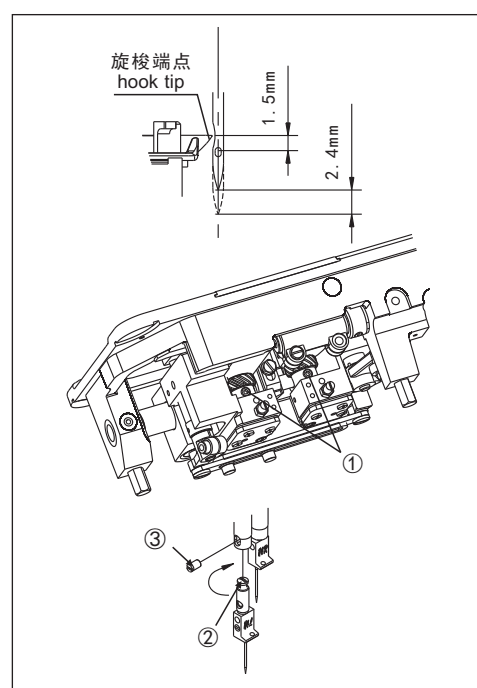
### 18. 机针与旋梭的关系 Needle and hook relationship



- (1) 针杆上下位置固定
- 单针杆: 转动手轮, 让针杆处于最低点时, 如图松开针杆固定螺丝①, 进行调整, 以让针杆刻线②和针杆架下端③保持一致, 此后再固定好螺钉①。
- 双针杆: 采购组件, 针杆处于最低点时, 刻线②已与针杆架下端③保持一致。

**EN**

- (1) Fix the needle bar
- Single needle bar: Turn the handwheel until needle bar reached the lowest point of its stroke, Loose screw ① of the needle bar, then align the position until the scale mark ② with the bottom end of needle bar frame, then tighten the screw ① again.
- Double needle bar: Turn the handwheel until needle bar reached the lowest point of its stroke, And align the scale mark ② with the end of needle bar frame



- (2) 旋梭端点和针中心距离的调整
- A. 若是5mm标盘, 则把针距调整为2.5mm。若是7mm标盘, 则把针距调整为3.5mm。在此状态下, 如图所示, 把针杆从最低点上升2.4mm, 并拧松①号螺丝调整旋梭位置, 使得旋梭端点与针中心保持一致, 并位于针孔上方1.5mm处。
- B. 就双针杆而言, 如果左右针高度不同, 或者当针杆从最低点上升2.4mm时, 旋梭端点不位于针孔上方1-1.5mm处, 就如图拧松固定螺丝③, 把针架拉出, 旋转螺钉②来调节针的高低。
- C. 针与旋梭端点的距离调整
- 当针从最低点上升, 旋梭端点与针中心保持一致的时候, 如图所示, 为了让旋梭端点与针凹槽处最低点距离的控制为0.05-0.1mm之间, 则需要拧松螺钉④和螺钉⑤, 移动旋梭部件进行调整, 达到要求后拧紧螺钉④和⑤。

**EN**

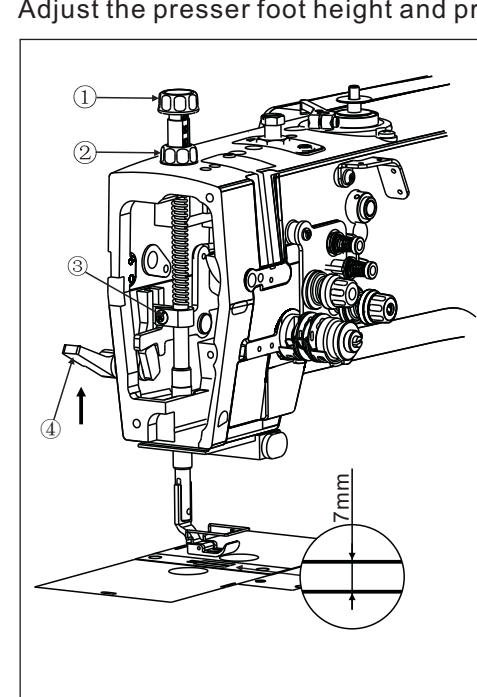
- (2) The adjustment of hook tip and center of needle hole.
- A. If the stitch length dial is 5mm, then adjust the stitch length to 2.5mm. If the stitch length dial is 7mm, then adjust the stitch length to 3.5mm. In this condition, adjust the needle bar form the lowest position to 2.4mm height, and loose the screw ① to adjust the hook, until align hook blade point with the center of needle hole, and provide a clearance height 1.5mm up over the needle hole.
- B. As for the double needle bar, if the height of left needle and the right needle is different, or when the needle bar is 2.4mm height from it is lowest position, and the hook blade point is not on the position 1-1.5mm up to the needle hole. Please loose the screw ③, pull the needle clamp out, turn the screw ② to adjust the height of the needle.
- C. Adjust the distance between needle and hook blade point. As the picture shows, when the needle go up for its lowest position, meantime keep the alignment of hook blade point and center of needle hole. We should provide a clearance of 0.05mm-0.1mm, if not, we need loose the screw ④ and screw ⑤, move the hook until meet the requirement, then tighten the screws again.

### 24. 规格 Specifications

用途 Application	单针杆小旋梭 Singer needle bar small hook	单针杆大旋梭 Singer needle bar big hook	双针杆小旋梭 Double needle bar small hook	双针杆大旋梭 Double needle bar big hook
最高缝纫速度 Max.sewing Speed	3000rpm	3000rpm	3000rpm	3000rpm
驱动类型 Max.stitch	直接驱动 Direct-drive			
最大针迹长度 Max.Stitch Length	5mm	7mm	5mm	7mm
压脚提升高度 (mm) Presser Foot Lift	手提 Hand lift	7mm		
	膝提 Knee lift	13mm		
	自动抬压脚 Auto lift	10mm(最大) 10mm(max.)		
机针 Needle	DPX5 -16	DPX5 -22	DPX5 -16	DPX5 -22
电机功率 (W) Motor Power	750W			
润滑油 Lubricating Oil	Special Oil 10#			

本产品执行标准 The product executive standard QB/T 4799-2015

### 15. 抬压脚高度和压脚压力的调整 Adjust the presser foot height and presser foot pressure

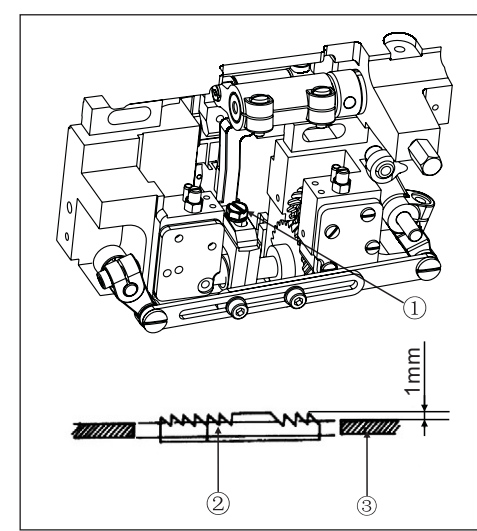


1. 压脚压力的调整
- 1) 拧松调压螺母②, 将调压螺钉①向顺时针方向转动, 压脚压力变大
- 2) 向逆时针方向转动, 则压力变小;
2. 调整完成后, 重新拧紧调压螺母②。
2. 抬压脚高度的调整
- 1) 松开压杆导架固定螺钉③;
- 2) 将压脚扳手④往上扳, 处于如图所示的状态;
- 3) 调整压脚到针板面的距离为7mm;
- 4) 重新锁紧压杆导架螺钉③。

**EN**

- 1) Presser foot pressure
- 1) Loosen the screw ②, turn the pressure adjustment screw ① clockwise, presser foot becomes stronger.
- 2) turn the pressure adjustment screw ① counter clockwise, presser foot becomes weaker.
- 2) After adjustment, re-tighten the nut ②.
- 2) Adjust the presser foot height
- 1) Loosen the fastening screw of the pressure rod guide ③.
- 2) Turn up the hand lifter lever ④, in the state as the picture shown.
- 3) Adjust the distance from the presser foot to the needle board surface to 7mm.
- 4) Re-tighten the fastening screw of the pressure rod guide ③.

### 16. 送布牙的高度 Feed dog height

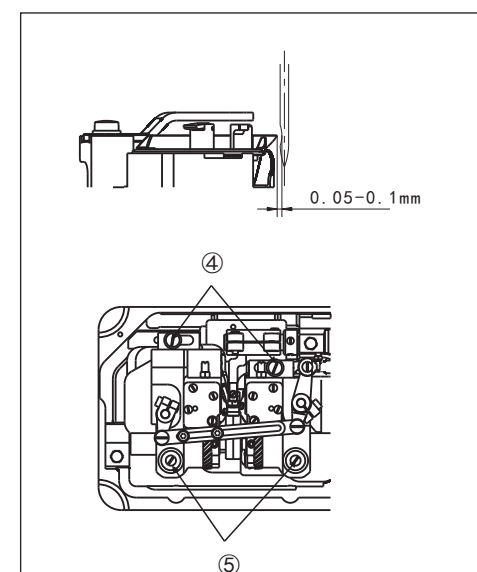


- 1) 转动手轮, 使送布牙停在最高点位置;
- 2) 拧松送布牙调整螺钉①, 调整送布牙②的高度;
- 3) 使送布牙②高于针板③上平面1mm左右;
- 4) 重新锁紧送布牙调整螺钉①。

**EN**

- 1) Turn the hand wheel to stop the feed dog at the highest point.
- 2) Loosen the screw ② and adjust the height of feed dog.
- 3) Feed dog ② should higher than the plate ③ about 1.0mm.
- 4) Re-tighten the feed dog adjusting screw ①.

### 18. 机针与旋梭的关系 Needle and hook relationship

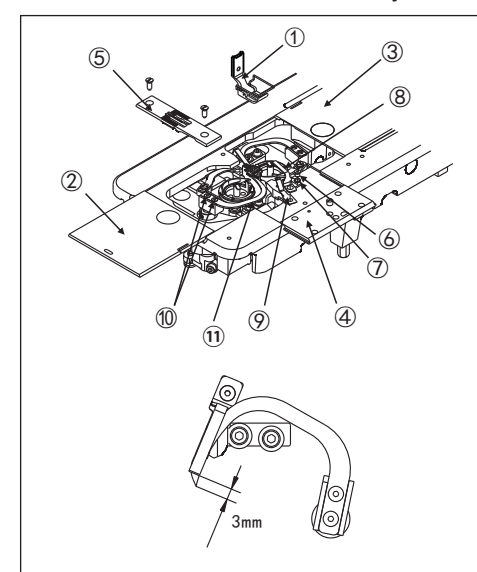


- (2) 旋梭端点和针中心距离的调整
- A. 若是5mm标盘, 则把针距调整为2.5mm。若是7mm标盘, 则把针距调整为3.5mm。在此状态下, 如图所示, 把针杆从最低点上升2.4mm, 并拧松①号螺丝调整旋梭位置, 使得旋梭端点与针中心保持一致, 并位于针孔上方1.5mm处。
- B. 就双针杆而言, 如果左右针高度不同, 或者当针杆从最低点上升2.4mm时, 旋梭端点不位于针孔上方1-1.5mm处, 就如图拧松固定螺丝③, 把针架拉出, 旋转螺钉②来调节针的高低。
- C. 针与旋梭端点的距离调整
- 当针从最低点上升, 旋梭端点与针中心保持一致的时候, 如图所示, 为了让旋梭端点与针凹槽处最低点距离的控制为0.05-0.1mm之间, 则需要拧松螺钉④和螺钉⑤, 移动旋梭部件进行调整, 达到要求后拧紧螺钉④和⑤。

**EN**

- (2) The adjustment of hook tip and center of needle hole.
- A. If the stitch length dial is 5mm, then adjust the stitch length to 2.5mm. If the stitch length dial is 7mm, then adjust the stitch length to 3.5mm. In this condition, adjust the needle bar form the lowest position to 2.4mm height, and loose the screw ① to adjust the hook, until align hook blade point with the center of needle hole, and provide a clearance height 1.5mm up over the needle hole.
- B. As for the double needle bar, if the height of left needle and the right needle is different, or when the needle bar is 2.4mm height from it is lowest position, and the hook blade point is not on the position 1-1.5mm up to the needle hole. Please loose the screw ③, pull the needle clamp out, turn the screw ② to adjust the height of the needle.
- C. Adjust the distance between needle and hook blade point. As the picture shows, when the needle go up for its lowest position, meantime keep the alignment of hook blade point and center of needle hole. We should provide a clearance of 0.05mm-0.1mm, if not, we need loose the screw ④ and screw ⑤, move the hook until meet the requirement, then tighten the screws again.

### 19. 动刀与定刀的更换 The way of changing fix knife and moving knife



- 1) 提升压脚①, 打开左推板②, 右推板③, 前推板④。
- 2) 卸下针板⑤。
- 3) 卸下固定螺丝⑥, 垫圈⑦, 和固定刀片⑧以及动刀防松弹簧⑨。
- 4) 卸下固定螺丝⑩, 和动刀片⑪。
- 5) 组装时, 按照拆开的顺序进行, 并确保动刀尖与定刀的距离为3mm, 如图所示。

**EN**

- 1) Let the presser foot up ①, open left push plate ②, right push plate ③, front push plate ④.
- 2) Remove the needle plate ⑤.
- 3) Remove the screw ⑥, gasket ⑦, and fix knife ⑧, lock leaf spring of moving knife ⑨.
- 4) Remove the screw ⑩ and the moving knife ⑪.
- 5) Installation refer to reverse order, and insure a 3mm distance between the moving knife blade and fix knife, as the picture shows.

### 24. 规格 Specifications

用途 Application	单针杆小旋梭 Singer needle bar small hook	单针杆大旋梭 Singer needle bar big hook	双针杆小旋梭 Double needle bar small hook	双针杆大旋梭 Double needle bar big hook
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驱动类型 Max.stitch	直接驱动 Direct-drive			
最大针迹长度 Max.Stitch Length	5mm	7mm	5mm	7mm
压脚提升高度 (mm) Presser Foot Lift	手提 Hand lift	7mm		
	膝提 Knee lift	13mm		
	自动抬压脚 Auto lift	10mm(最大) 10mm(max.)		
机针 Needle	DPX5 -16	DPX5 -22	DPX5 -16	DPX5 -22
电机功率 (W) Motor Power	750W			
润滑油 Lubricating Oil	Special Oil 10#			

本产品执行标准 The product executive standard QB/T 4799-2015