

⚠ 为了安全

对于缝纫机本身各种装置，我们充分考虑到它的安全性。请遵照基本的操作方法，安全的进行工作。

- 拆除为保证安全所设置的装置，零件的情况下使用，是非常危险的，请绝对不要拆除后使用。
- 缝纫机在使用时，请不要在缝纫机台板上放置工具及缝纫时不必要的物品。
- 在对缝纫机进行检修、调节、清扫、穿线、换针等工作时，为防止发生事故，务必请切断电源，在确认即使踩下缝纫机踏板，缝纫机也不转动之后，再进行操作。

⚠ OBSERVE THESE SAFETY PRECAUTIONS

Though Our takes the utmost care to produce safe sewing machines and devices, operators should follow these basic safety rules.

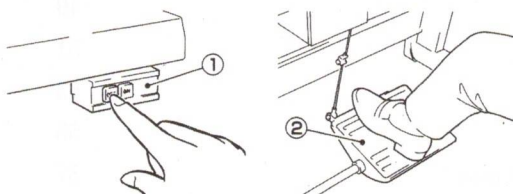
- To prevent accidents, do not remove safety devices or parts while operating the machine.
- Do not leave tools or other unnecessary objects on the machine table while operating the machine.
- Before maintenance, adjusting, cleaning, threading or replacing the needle, and to prevent accidents, be sure the power is turned off. Check that the machine will not operate when the pedal is pressed.

注意

使用离合式马达的情况下，在关掉电源①后因惯性作用会继续旋转。这时如不注意踩动缝纫机踏板②时，缝纫机会突然动作，这是很危险的。请在关掉电源后，仍继续踩动踏板②，直至缝纫机完全停下来为止。

Note

In case a clutch type motor is used, it will keep on rotating by inertia after turning off power supply. ① If the machine pedal ② is stepped on inadvertently, it is dangerous because the machine will move unexpectedly.



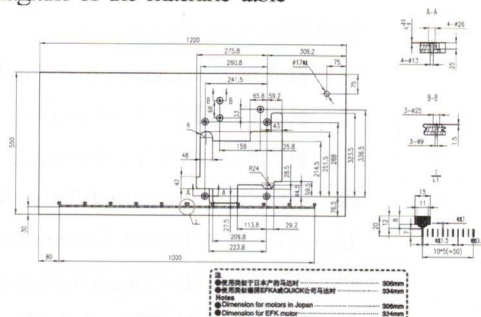
- 在离开缝纫机台时，务必请关掉电源。
- 停电时也请务必关掉电源。
- 为了总是安全地，运转良好的使用缝纫机，日常的点检是不可缺少的，请予以注意。
- Turn the power off before leaving the machine table.
- In the event of a power failure, be sure to turn the machine off.
- Check that the machine is securely grounded.

台板加工图

请参照下图进行台板的加工

Schematic diagram of the machine table

Cut the table referring to the diagram



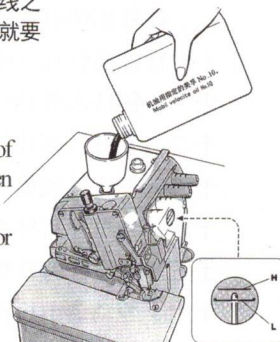
供油

加油量是使油面处于H线与L线之间为好。当油面低于L线时，就要及时补充机油。

Lubrication

After filling the oil pan, the top of the indicator should lie between (H) and (L) lines.

Add oil, when the oil level indicator reaches or goes below (L).

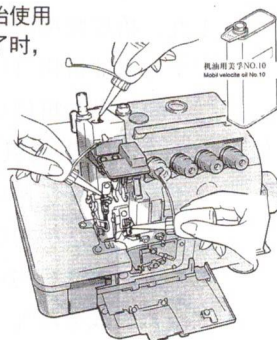


手动给油

手动给油是在缝纫机最开始使用时。或相当一段时间没使用了时，请供给2~3滴油。

Manual Lubrication

Apply 2 or 3 drops of oil by hand when the machine is used for first time or has been left unused for some time.



给HR装置供油

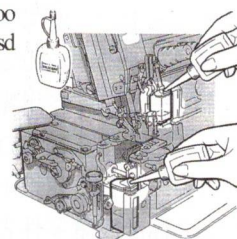
为防止断线，尽早给HR装置供油。

注：关于购买硅油，请询问代理店或与公司营业部联系。

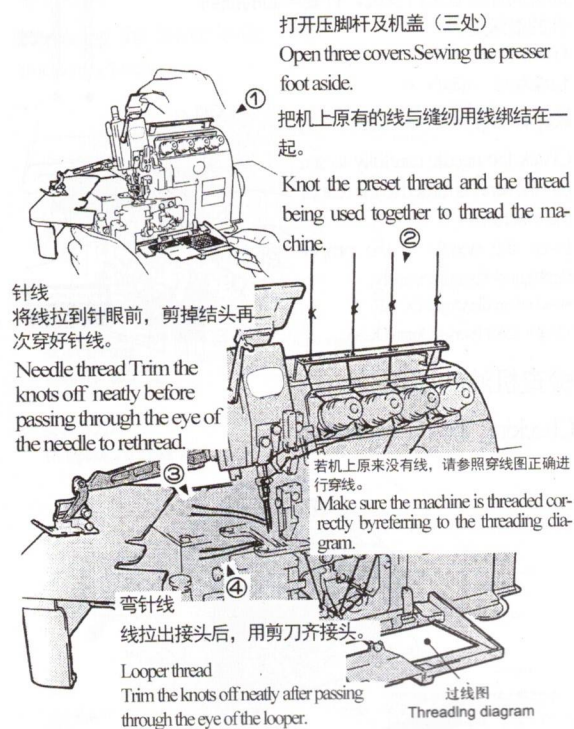
Filling the HR device with silicon oil

Fill the HR device with oil before it is too low in order to prevent needle thread breakage and fabric damage.

Note: Use Pegasus recommended silicon oil, [UNION CARBIDE CORPORATION] UCC L-45(10)



穿线的方法 Threading

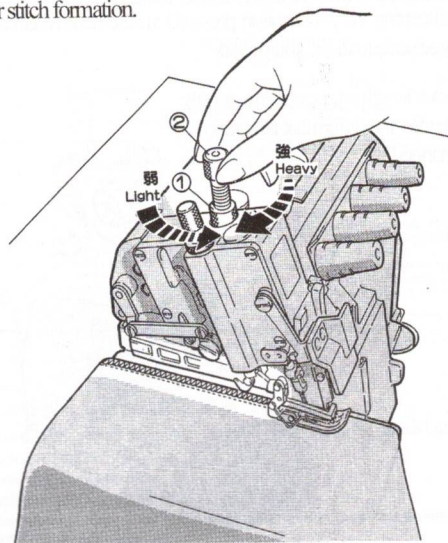


上送布牙压力的调节

请松动螺母①拧动螺母②，对上送布牙压力进行调节在能得到稳定线迹的范围内，请尽量调松。

Adjusting the top feed pressure

Loose the adjusting nut ① and turn adjusting ② to adjust the top feed pressure. It should be as light as possible. Yet be sufficient to obtain the proper stitch formation.

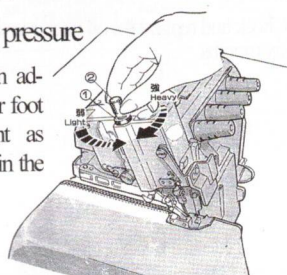


压脚压力的调节

压脚压力的调节，松动螺母①，调节螺母②，在送布得到稳定状态下尽可能使用较弱的压力为好。

Adjusting the presser foot pressure

Loosen adjusting nut ① and turn adjusting nut ② to adjust the presser foot pressure. It should be as light as possible, yet be sufficient to obtain the proper stitch formation.

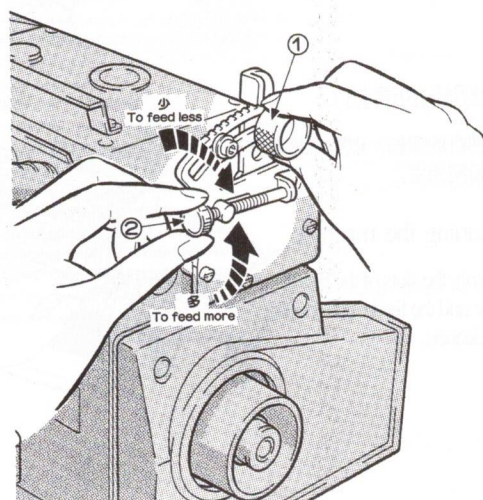


上送布牙前后量的调节

请松动螺母①后拧动螺母②来调节上送布牙的前后量

Adjusting the top feed front-to-back

After loosening the adjusting nut ①, turn the adjusting nut ② to adjust the top feed front-to-back motion.

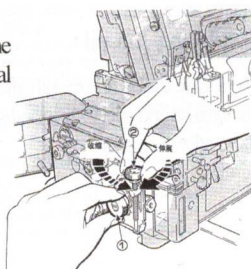


差动比的调节

差动比的调节松开螺母①调节螺母②。

Adjusting the diff. feed ratio

Loosen the adjusting nut ① and turn the adjusting nut ② to adjust the differential feed ratio.



针脚长度的调节

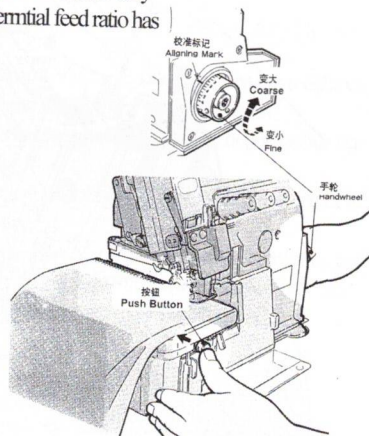
1. 按住按钮，旋转手轮，按钮会陷进更深处。
2. 这时边按住按钮，边转动手轮，使校准标记对准所希望的数值。

注：针脚长度的调节务必请在调节差动比之后进行。

Adjusting the stitch length

1. While pressing the push button, turn the handwheel to seek the position at which the push button goes further into the depth.
2. Then, keeping the push button pressed, turn the handwheel and set the desired scale to the aligning mark.

Note: Stitch length adjustment must only be made after the differential feed ratio has been changed.

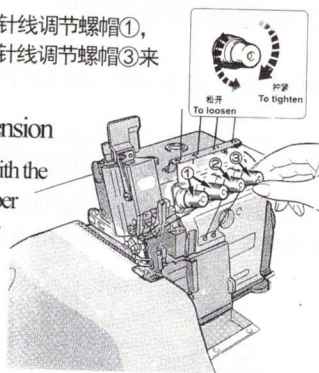


线状态的调节

线张力状态的调节，请用针线调节螺帽①，上弯针线调节螺帽②，弯针线调节螺帽③来进行调节。

Adjusting the thread tension

Make tension adjustments with the needle thread knob ①, the upper looper knob ②, and the lower looper knob ③.

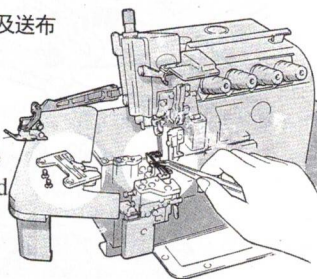


缝纫机的清扫

缝纫机的清扫，以针板槽及送布牙周围为主。

Cleaning the machine

Mainly the slots of the needle plate and the feed rows should be cleaned.



换针

准确辨认针的前后，请将针凹向着后方，即背向操作者进行安装。针要牢固的插到孔的最深处。

标准使用针：风琴DC×27

包缝系列：风琴DC×5

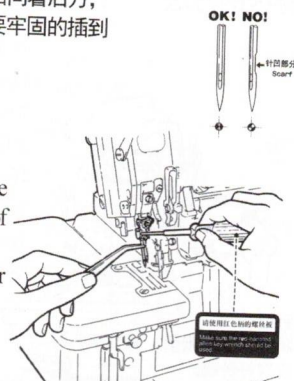
Replacing the needle

Check the needle carefully to see that the scarf is turned to the rear of the machine.

Insert the needle to the proper depth, and fasten securely.

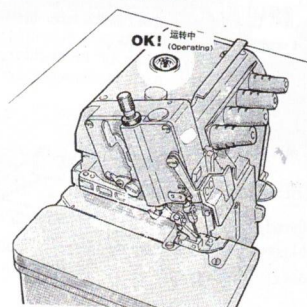
Standard needle: Organ DC×27

5200H(3200H) series: Organ DC×5



检查机油的循环

Checking the oil circulation

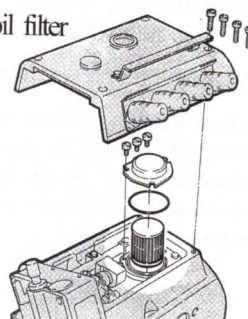


检查油质量，更换油

机油每6个月检查并更换。

Checking and replacing the oil filter

Check and replace the oil filter every six months.

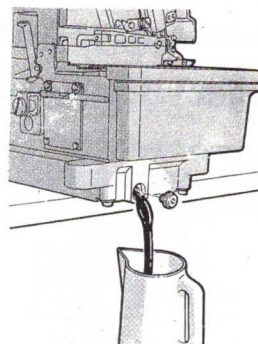


换机油

机油的更换，请在使用开始1个月后将更换一次，然后，每6个月更换一次。供油请参见第2页。

Replacing the oil

Replacing the oil one month after the first use and every six months thereafter. (See p2.)

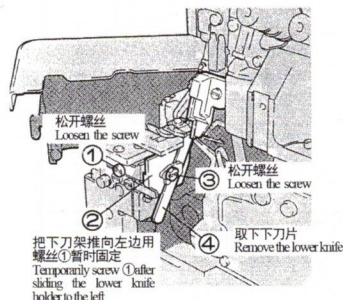


下刀片的更换

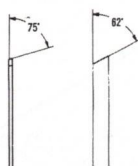
卸下下刀片

Replacing the lower knife

To remove the lower knife

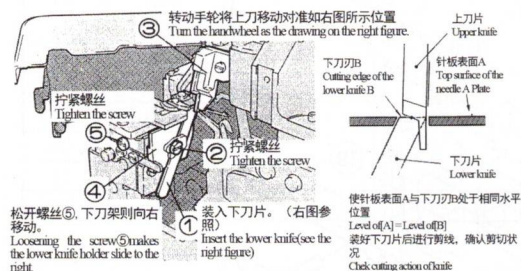


下刀片正确的研磨角度
Correct angles to resharpen the lower knife



安装下刀片

To replace the lower knife



调整基准表									
机	机型	针高度 (±0.1)	下刀针 引量	出量	高度	上刀针 右位置	上刀针 左位置	二重环 针引量	送布 斜度
1	唐-7900(十针)H40-320	10.5	3.5	5.4~5.7	10.5	13.5	右	/	针板上表面水平
2	唐-7900(十针)H40-420	11.5	4.2	5.4~5.7	11.5	13.5	左	/	针板上表面水平
3	唐-7900(十针)H40-430	11.5	4.2	5.4~5.7	11.5	13.5	左	/	针板上表面水平
4	唐-7900(十针)H40-320	10.5	3.5	4.4~4.7	10.5	14.5	左	1.5	针板上表面水平
5	唐-7900(十针)H40-420	10.5	3.5	4.4~4.7	10.5	14.5	左	1.5	针板上表面水平
6	唐-7900(十针)H40-320	11.5	3.5	4.4~4.7	10.5	14.5	左	1.5	针板上表面水平
7	唐-7900(十针)H40-420	11.5	4.2	4.4~4.7	11	14.5	左	1.7	针板上表面水平

参数表 Parameter list

参数	Parameter	参数作用	function	参数说明	description
V	速度	速度=显示值×100 (转/分) Speed=Value show in the digital X100(RPM/Min)			
M	自动停针功能开关 Set needle position function	0: 关闭自动停针功能 1: 打开自动停针功能			
Y	自动停针 Parameter for needle position	右数码管上横亮表示上针位; 右数码管下横亮表示下针位。 Digital tube show "—" in upper location means upper needle position and in down location means down needle position. 注意: 当M参数设置为0时, Y参数将不显示。 Note: Y do not work when M value is 0			
b	电机转动方向 Set the rotation	数码管笔划转动方向表示电机转动方向 The LED light running direction in the right side digital tube means the rotation of the motor			

错误代码一览表 List of error codes

E1	电机负荷过大, 请减轻负荷后重启电机; Motor with locked-rotor problem Please reduce the load capacity and then restart the motor 请检查缝料是否太厚; Please check if the sewing material is too heavy 机器是否缺少润滑; Please check if the machine needs lubrication. 检查10芯电机插件是否松动或者脱落; Please check if the 10core line connect well or not
E2	请检查供电电压是否正常; Please check the voltage 一般是负荷过大或者控制器故障引起的, 若重启后也不能解决, 建议联系经销商解决; Because of supercharge or controller failure, if turn on the motor again can't solve the problem, please contact the local agent 检查10芯电机插件是否松动或者脱落; Please check if the 10core line connect well or not
E3	出现此种状况, 需要关闭电源, 稍后再打开电源开关即可; Please turn off the power and then turn it on again. 若重启后也不能解决, 建议联系经销商解决; If can't solve the problem, please contact the local agent
E4	请检查电机10芯插头连接是否可靠, 霍尔信号线是否有断线, 插针是否退出或者变形; Please check if the 10core line connect well or not, please check if the connect line of hall is well or not
E5	请检查定位器插头连接是否可靠。 (如果定位器损坏或者不需要定位功能时, 当按P5后, 按住右键5秒3S, 就可以进入参数设置界面, 把P5设置成0, 即可关闭定位功能) Please check if the positioner connect well (if the positioner damage or don't need needle position function and with P5 code, please keeping press 5 around 3seconds, enter parameter modal, set P5 value into 0 can turn off the function)

注意: 系统报障后, 机器将无法运行, 显示屏将持续显示错误码, 请排除故障后再上电。
Note: If the control box give the error code made the machine can't run, please don't turn on the power till the problem solved

工业缝纫机安全使用注意事项

Notes for safe use of industrial sewing machines

- 必须遵守基本措施;
Basic measures must be observed.
- 必须经过专业培训, 对缝纫机设备性能;
Pass the specialized training and master sewing machine equipment performance.
- 使用前应检查所有安全装置;
All safety devices should be checked before use.
- 在安装机针、更换机针、压脚、针板、送布牙、弯针、旋梭或修理时, 应立即关闭电源;
When installing needle, and changing needle, presser foot, plate, feed dog, bent needle, hook or repairing, the power supply should be turned off immediately.
- 离开缝纫机或工作场所时应关闭电源;
Power should be turned off when leaving the sewing machine or workplace.
- 使用离合马达时, 要等待马达完全停止后再进行;
When using the clutch motor, please wait until the motor stops completely.
- 缝纫机及附属装置使用的机油, 润滑油等液体流入眼睛或沾到皮肤上应立即清洗;
The machine oil and other liquids used in sewing machines and ancillary devices should be cleaned immediately when they are put into eyes or touch skin.
- 禁止用手触摸缝纫机通电时的零件或装置;
Do not touch the parts or devices when the machine is powered by hand.
- 有关工业用平缝机与包缝机的修理、改造、主要机构的调整由专门技术人员来进行;
The repair, renovation and adjustment of the main mechanisms of the relevant industrial sewing machines and overseers shall be carried out by specialized technicians.
- 一般的维护保养由专人负责;
General maintenance is carried out by specially-assigned persons.
- 在电气方面的修理应在电气技术员的监督和指导下进行;
Electrical repairs should be performed under the supervision and direction of the electrical technician.
- 缝纫机使用期间应定期清扫;
The machine should be cleaned regularly during operation.
- 为了正常安全运转, 应安装地线, 同时应在不受高频焊接机等强噪声源影响的环境下使用;
In order to operate normally and safely, ground lines should be installed, and they should be used in an environment free from strong noise sources such as high frequency welding machine.
- 电源插头应由专人负责;
Power plug should be installed by specially-assigned person.
- 工业用平缝机、包缝机在指定用途以外不能使用。
Industrial lockstitch sewing machine and overlock sewing machine can not be used except the designated use.