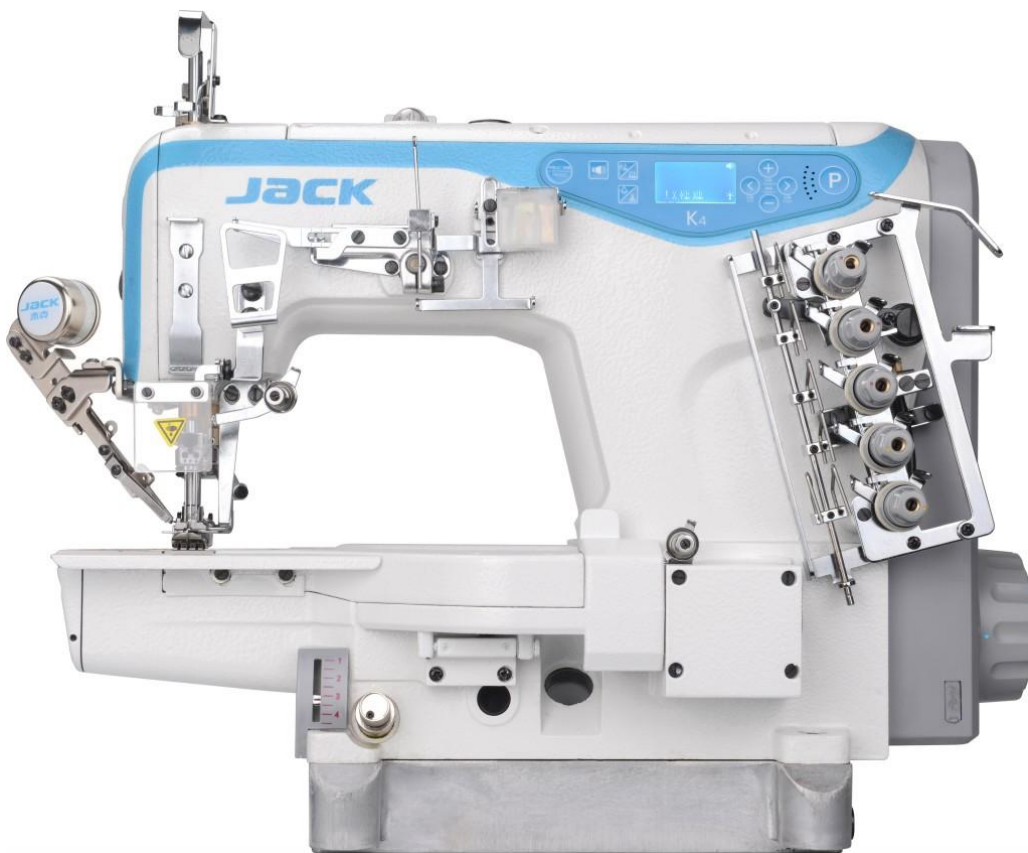


JACK

K4 系列使用说明

K4 series' use manual



一、规格 First. specification

机种名称 type	小头式高速绷缝机 High Speed Computerized Cylinder-bed Interlock Machine
型式 model name	K4
缝迹形式 Stitch type	ISO 标准 : 406/407/602/605 ISO standard : 406/407/602/605
用途 use	针织、编织产品的包边缝、包缠缝 Knitting, knitting products of the wrap seam 、wrapping
缝纫速度 Sewing speed	最高转速 The maximum speed : 5500RPM 出厂转速 Factory speed : 4000RPM
针幅 Needle width	3 根针 3Needle : 5.6mm、6.4mm 2 根针 2Needle : 2.8mm、3.2mm、5.6mm、6.4mm
差动送布比 Differential feed ratio	0.8-1.3
缝迹长度 Stitch length	1.5mm-4.5mm
使用机针 Needle type	UY128GAS 11#、14# (标准 standard : 11#)
针杆行程 Needle bar stroke	33mm
压脚高度 Presser foot height	7.0mm
体积 volume	纸箱体积 Carton size : 675mm×450mm×602mm 机器体积 Machine size : 500mm×380mm×260mm
重量 weight	净重 net weight : 52Kg 毛重 Gross weight : 62Kg

表 1

二、各部分的名称 Second, the name of each part

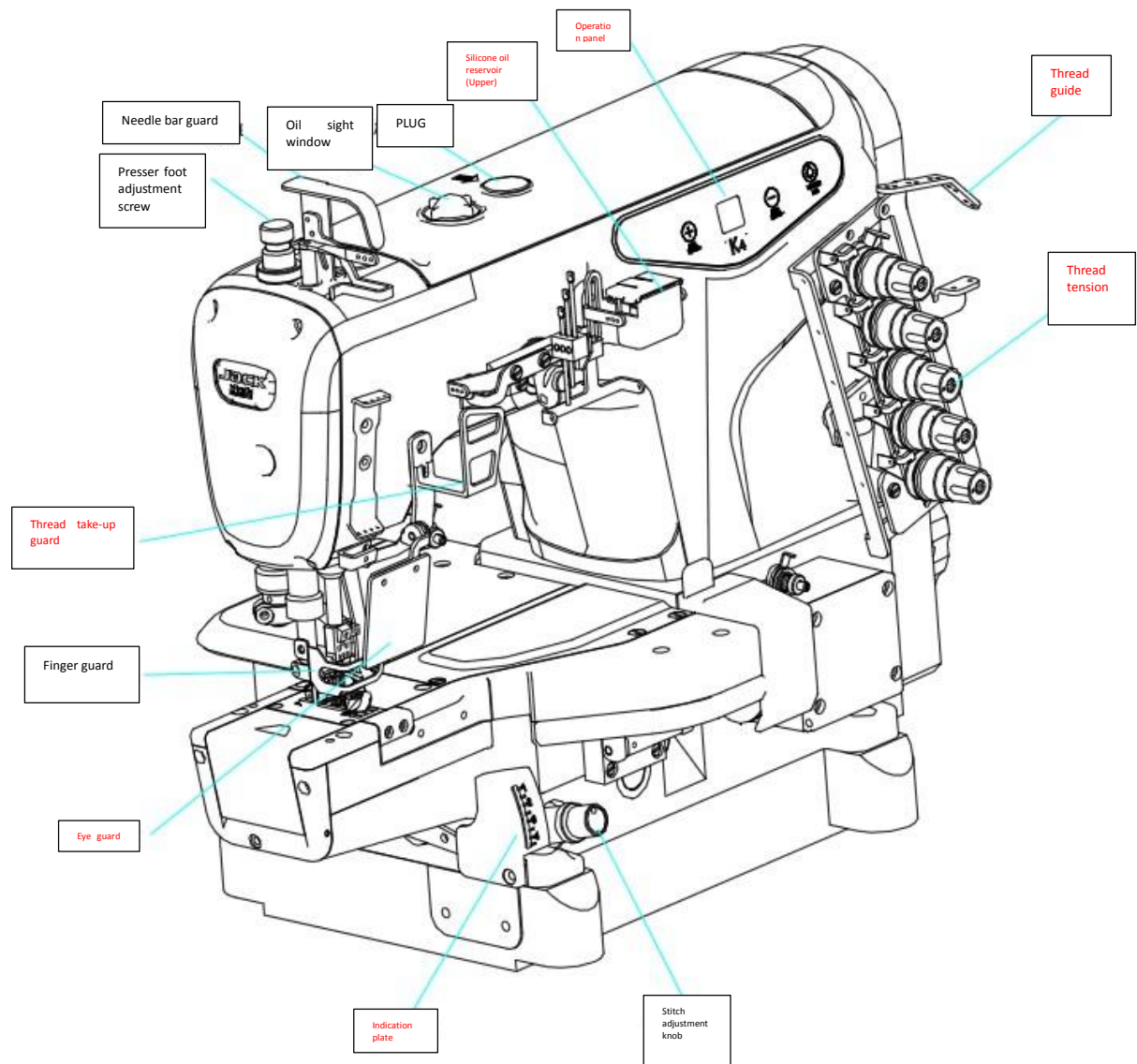


图 Figure2-1

简介：K4机器电控与机械一体，可以在机器上调节电控相关参数，实现了人性化的人机交换模式，操作便利！

Introduction : K4 , which control box is integrated into machine head, parameters can be adjusted on machine directly, achieved interpersonal exchange, easy and convenient to operate !

三、安装方法 Third, the installation method

1、台板尺寸及其安装方法

1、 table size and installation method

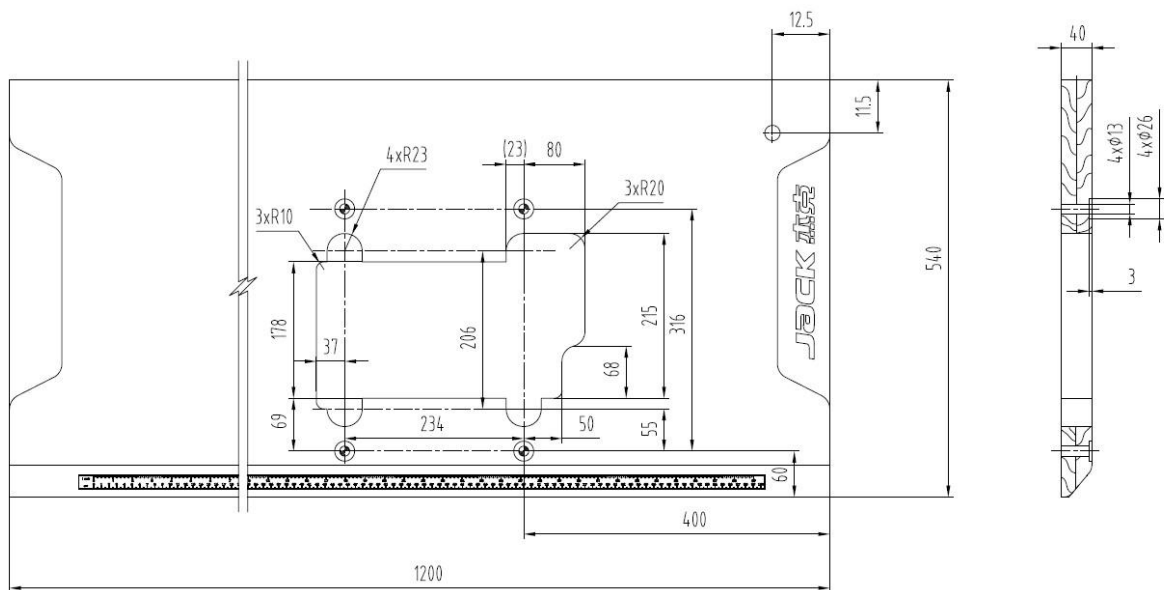


图 3-1

2、链条的安装

2、 the installation of the chain

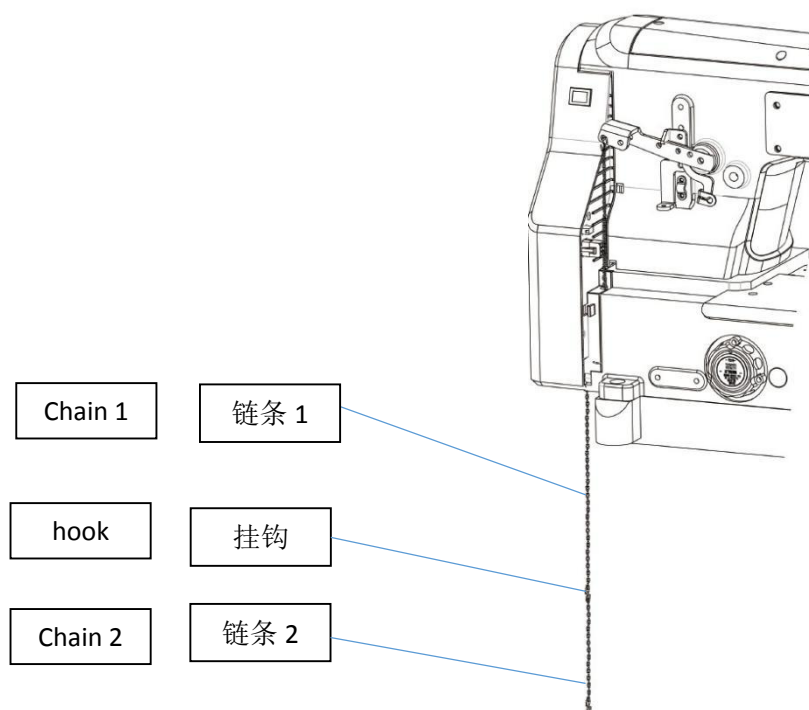


图 3-2

脚踏板链条如上图所示安装

Pedal chain installed as shown above

四、关于加油、注油 Fourth, on the Lubrication, oiling

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

Note: In order to prevent personal accident caused by the sudden start of the machine, please turn off the power, make sure the motor does stop turning and then operate!

1、出厂加油

机器出厂时，机油均被排放，因初次使用缝纫机前，请一定要加入机油，推荐使用机油：白油 22#，加油时请拿开标有 OIL 的加油口盖子，把机油加到油尺的上下刻线之间，加油完成后转动缝纫机，看油窗是否有机油喷出，如果没有机油喷出，请进行检修。

When the machine is shipped from the factory, the oil is discharged. Be sure to add the oil before using the sewing machine for the first time. It is

1, the factory refueling

recommended to use the oil 22#. When filling, open the plug marked with OIL and add the oil between the upper and lower engraved lines. Turn on the sewing machine after refueling to see if there is any oil spilled in the oil window. If there is no oil spilled, please carry out overhaul.

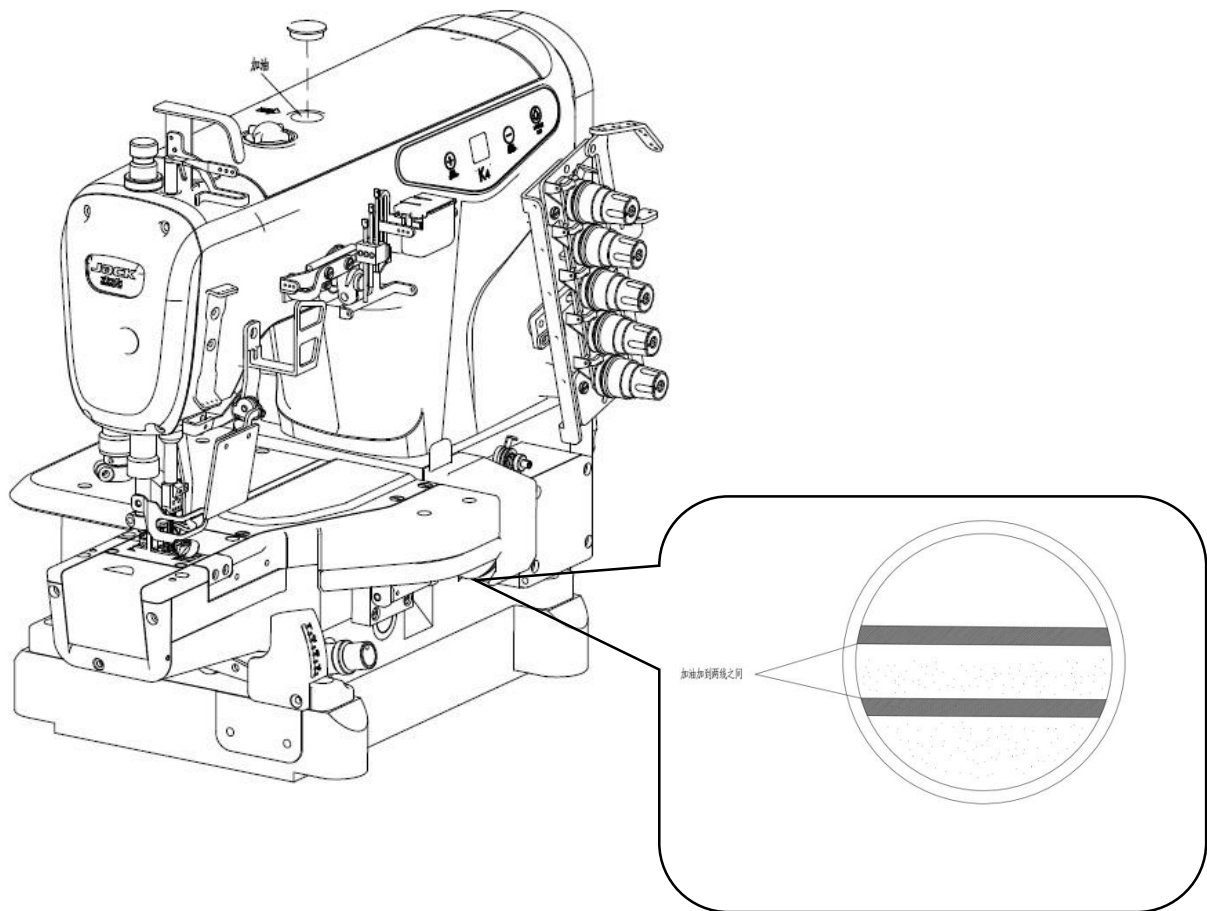


图4-1

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

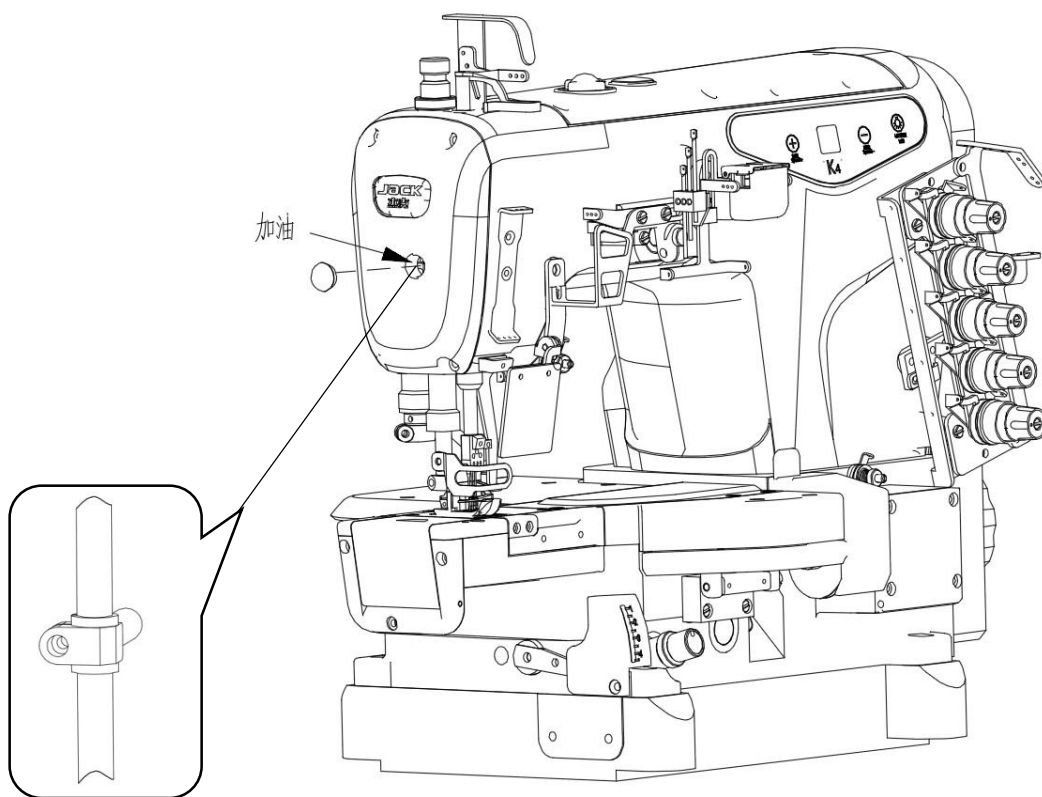
Note: In order to prevent personal accident caused by the sudden start of the machine, please turn off the power, make sure the motor does stop turning and then operate!

2、出厂注油

机器出厂首次使用或较长时间没有使用缝纫机时，请一定向针杆滴 2-3 滴机油，滴在针杆扎头与针杆的连接处，确保针杆机构润滑。

2, factory oiling

When the machine is used for the first time in the factory or when the sewing machine is not used for a long time, be sure to drop 2-3 drops of oil to the needle bar and drop it at the junction of the bar head and needle bar to ensure the needle bar mechanism is lubricated.



被加油机构 (fueling agencies)

图 Figure4-2

五、缝纫机的使用方法

Fifth、the use of sewing machines

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

Note: In order to prevent personal accident caused by the sudden start of the machine, please turn off the power, make sure the motor does stop turning and then operate!

1、机针的安装方法

安装机针时，机针头部需要完全插入针古里，且机针凹槽部位向里侧。

1、 the needle installation method

When installing the needle, the needle head needs to be completely inserted into the needle clamp, and the needle groove is to the inside.

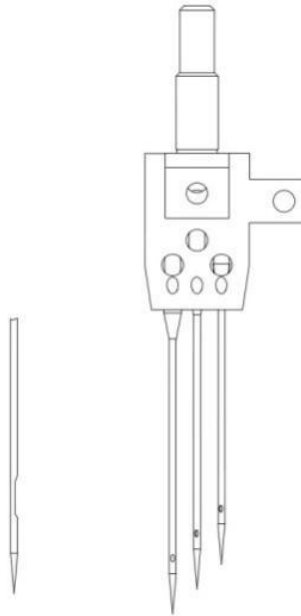


图 5-1

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

Note: In order to prevent personal accident caused by the sudden start of the machine, please turn off the power, make sure the motor does stop turning and then operate!

2、穿线方法

2、threading method

①、标准穿线法：①, standard threading method:

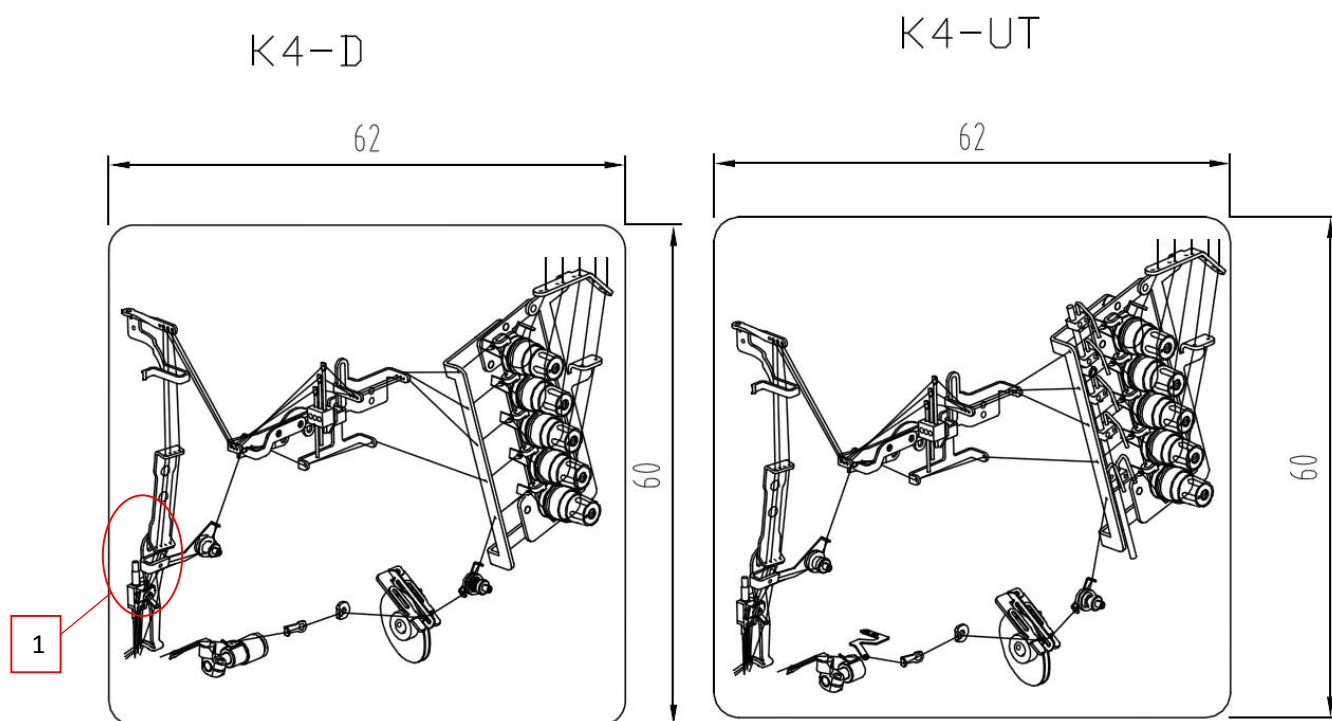


图 5-2

当机针线伸缩量较大时：When the needle thread stretching in a larger amount

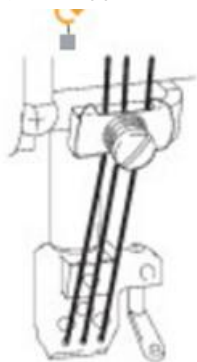


figure5-3

当机针线伸缩量较小时:When the needle thread stretching in a smaller amount

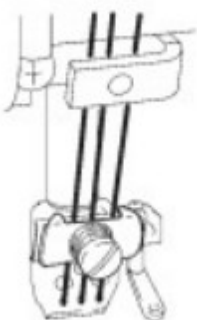


figure5-4

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

Note: In order to prevent personal accident caused by the sudden start of the machine, please turn off the power, make sure the motor does stop turning and then operate!

3、针距调节

3、stitch length adjustment

机器针距可以在 1.5mm-4.5mm 范围内任意调整(实际缝料线迹长度,随布料的种类和厚度有所不同), 缝纫机针距的调节是通过旋转针距调节旋钮调节的, 顺时针旋转, 针距变大, 逆时针旋转, 针距变小。

Machine stitch length can be adjusted within the range of 1.5mm-4.5mm (actual sewing stitch length, depending on the type and thickness of the cloth). The sewing machine stitch length is adjusted by rotating the stitch length adjusting knob. Clockwise Rotation, needle length becomes larger, counterclockwise rotation, stitch length becomes smaller.

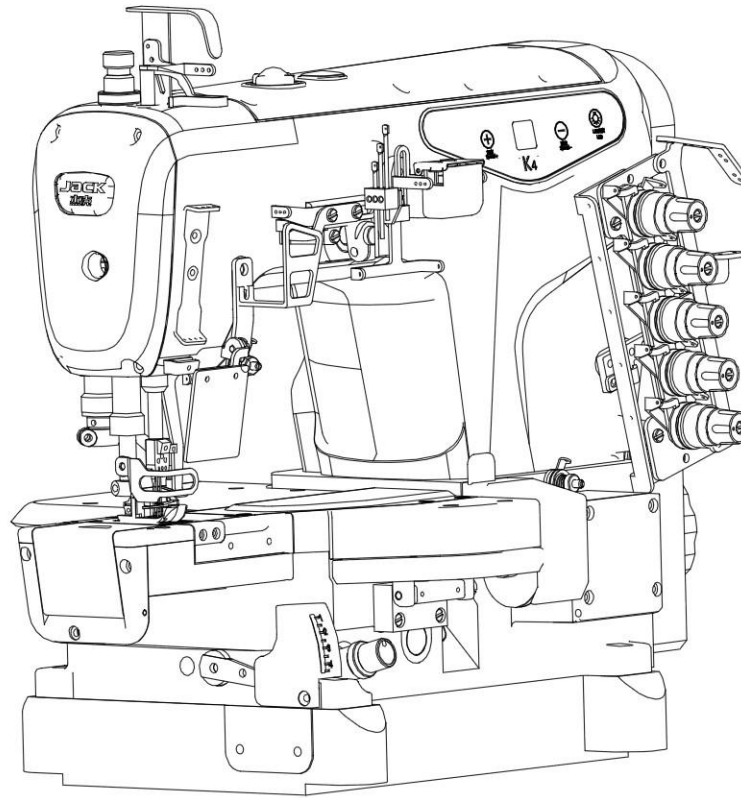


图 5-5 Figure 5-5

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

Note : In order to prevent the machine from personal accident suddenly, please turn off the power supply, confirm the motor really stop running again then operate !

4、差动的调节 Differential regulation

差动调节范围在 0.8-1.3 内，松开调节螺钉，上下扳动，往上是顺差动，往下是逆差动。 Within differential range of 0.8-1.3, loose and adjust screw, throw up and down, up is To Shrink, down is To Stretch.

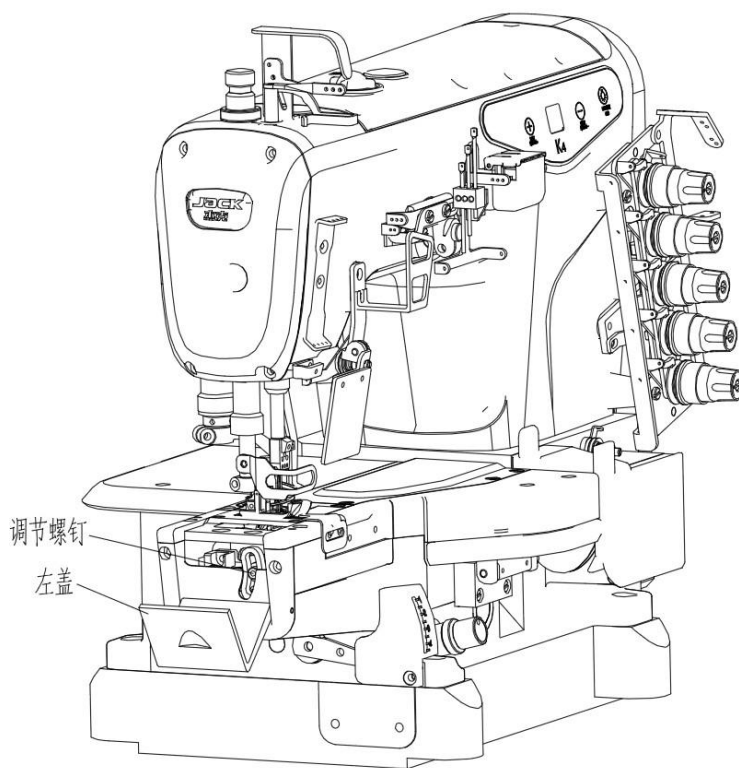


图 5-6 Figure 5-6

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

Note : In order to prevent the machine from personal accident suddenly, please turn off the power supply, confirm the motor really stop running again then operate !

5、压脚压力调节 Adjust presser foot pressure

请把压脚压力在缝迹稳定范围内尽量调弱

调节压脚压力时，拧松压脚调节螺母，并将压脚调节螺杆顺时针或逆时针旋转，顺时针旋转则压脚压力变大，逆时针旋转，则压脚压力变小。

It should be as light as possible, yet be sufficient to obtain the proper stitch formation.

When adjust pressure for presser foot ,loosen adjusting screw presser foot , and make presser foot adjusting screw clockwise or counterclockwise

rotation, when clockwise, the pressure of presser foot is Heavy, when counterclockwise, the pressure of presser foot is Light.

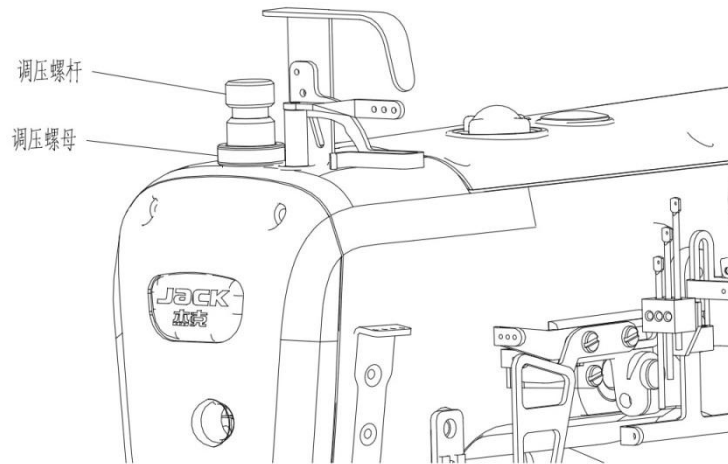


图 5-7 Figure 5-7

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

Note : In order to prevent the machine from personal accident suddenly, please turn off the power supply, confirm the motor really stop running again then operate !

6、线张力调节 Thread tension adjustment

夹线器按照布料、线、线迹宽度的不同，及使用条件的变化而变化。对照使用条件，调整夹线器的螺母，顺时针方向转，线紧；逆时针方向转，线松。

Thread clamp device according to the different fabric, thread and width of the thread, and the changeable conditions of use. Controlled conditions of use, adjust the nut thread clamp device, turn clockwise, tight thread; Turn counterclockwise, thread loose.

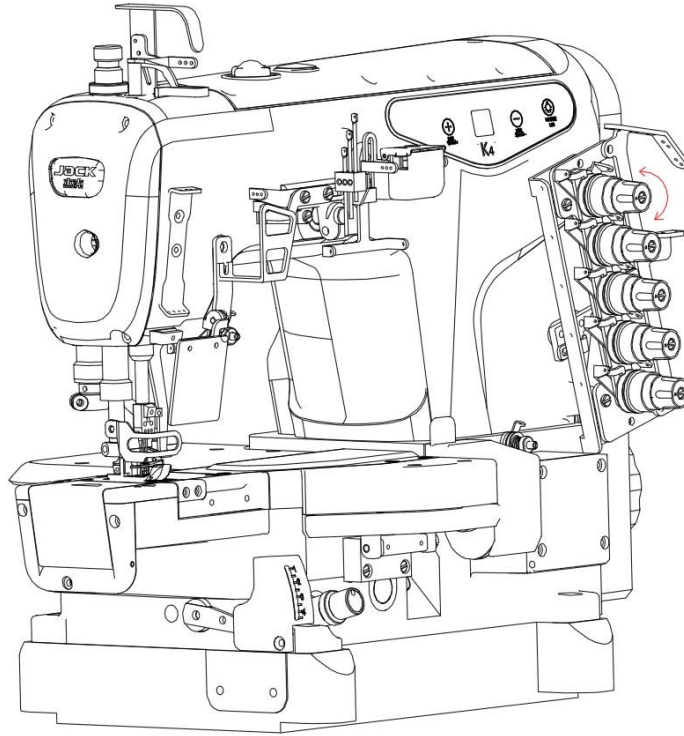


图 5-8 Figure 5-8

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

Note : In order to prevent the machine from personal accident suddenly, please turn off the power supply, confirm the motor really stop running again then operate !

7、滤油器的检查和更换 Inspect and replace oil filter

过滤器有灰尘在上面，不能正常使用，每使用 6 个月后请进行检查或更换。

注：如果油按规定的油量加入，油窗喷出的油量异常、过弱、有气泡等现象时，请及时更换或清扫过滤器

There are dust on oil filter, it couldn't normal use, every six months for inspection or replacement, please.

Note: if the oil in accordance with the provisions, oil window spewing oil abnormal, too weak, the phenomenon such as bubbles, please timely replace or clean oil filter.

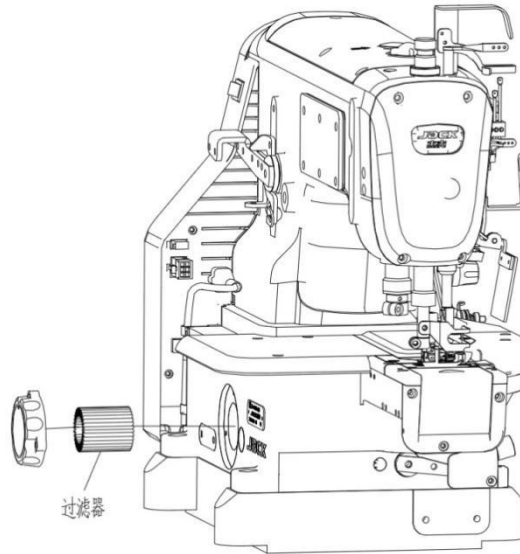


图 5-9 Figure 5-9

六、缝纫机调整 Sewing machine adjustment

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作

Attention：In order to prevent the sudden start of the machine which causing a personal accident, please turn off the power, make sure the motor does stop rotating before operating!

1、冷却器导线器的调整

松开紧定螺钉，把各导线杆高度调整为图示的尺寸，然后拧紧紧定螺钉(图7-1)，针对不同布料时可通过调节A、B、C的高度来调节挑线量，导线杆的高度增加挑线量减小，导线杆的高度降低挑线量增加(图1)。

1、Cooler **wire** guide adjustment.

Adjust the release needle thread guide hight to the number below , then tightening screw (Figure7-1) , Accounting to different fabric, we can change thread taking up length by adjusting needle thread guide hight A、B、C , Thread taking up quantity increase when needle thread guide hight decrease and thread taking up quantity decrease when needle thread guide hight increase. (Figure 1) 。

A	B	C
12	21	32

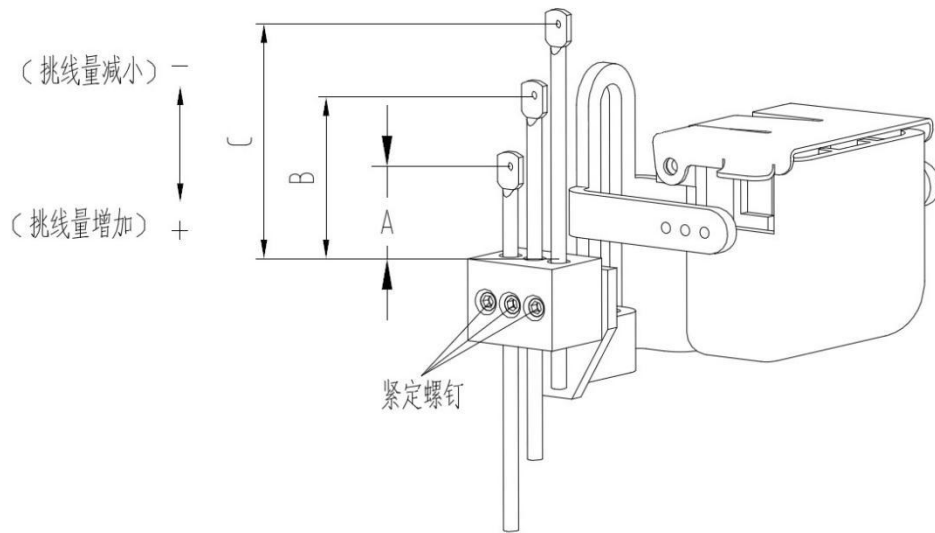


Figure 7-1

2、松开紧定螺钉，左右移动针线操作器，如图 2 所示，把针线操作器边缘到摆动挑线杆轴的中心调整至 80mm，然后拧紧紧定螺钉，针对不同布料时可通过调节针线操作器边缘到摆动挑线杆轴的中心的距离来调节挑线量，针线操作器边缘到摆动挑线杆轴的中心的距离加大，挑线量减小，针线操作器边缘到摆动挑线杆轴的中心的距离减小，挑线量加大（图 8-2）。

2、Release set screw , shuffling the needle thread operator , showed by figure 8-2 , change the distance between margin of needle thread operator and center of shuffling release pole rod to 80mm, then tight the set screw. For various type of fabric, we can adjust the thread taking up length by change this distance. The distance between margin of needle thread operator and center of shuffling release pole rod increase, the thread taking up length decrease. Also, the distance decrease, the thread taking up length increase.

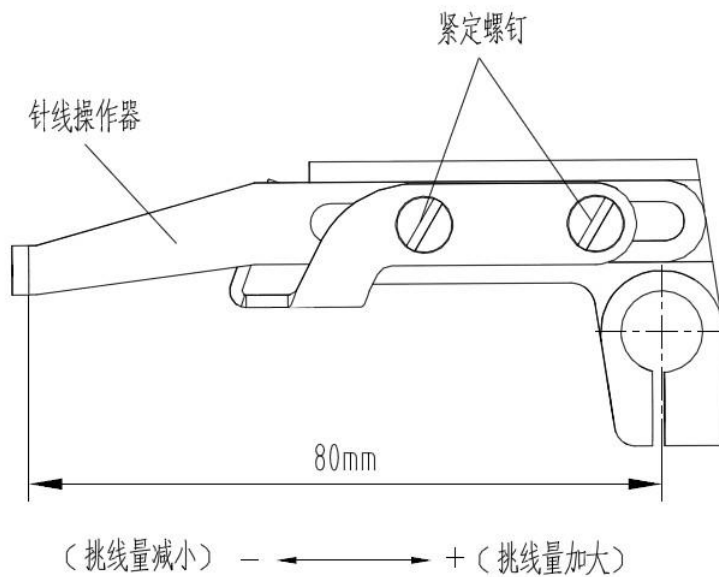


Figure8-2

3、分布导线器的调整

分布导线器①在最高点时，松开紧定螺钉③，分布导线器的导线线道里侧上端调整成与分布导线器的长槽下端一致，然后拧紧紧定螺钉③（图 8-3）。

3、Adjustment of spreader thread take up

① at the top point , release set screw③ , make the top of inner guide line fix to the bottom of guider slot, then tight the set screw ③ (Figure 8-3) 。

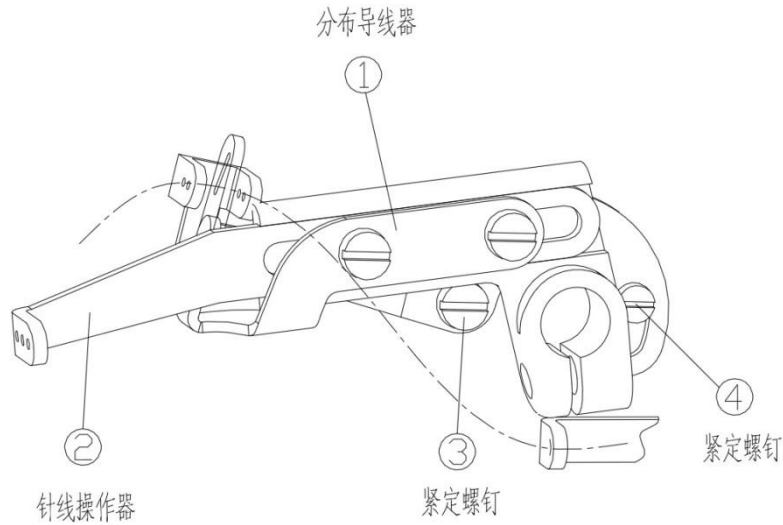


Figure 8-3

4、打线凸轮及打线凸轮导线器的调整

①、打线凸轮位置调整

当机针处于最高点时（图 8-4），调整打线凸轮，使之恰好开始打线。

5. Adjusting the looper thread cam thread guide and the looper thread cam

1、Adjustment of thread cam and thread cam guider

①、Hit thread cam adjustment

When needle at the top (Figure 8-4) , adjust hit thread cam , make it at the position that just start hit thread.

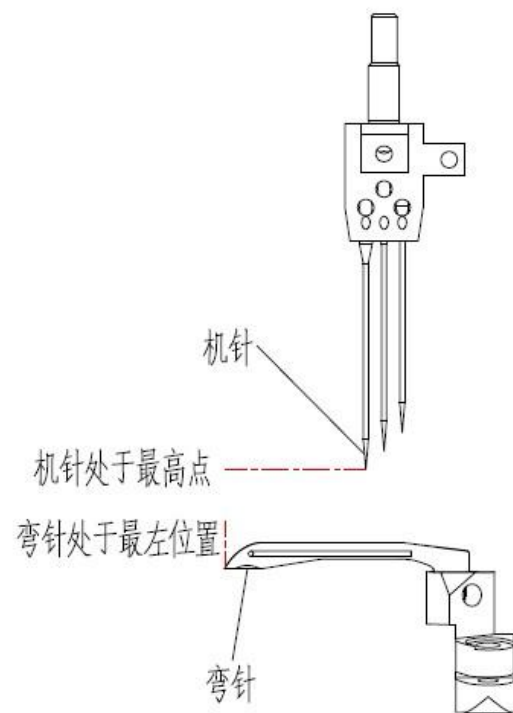


图8-4

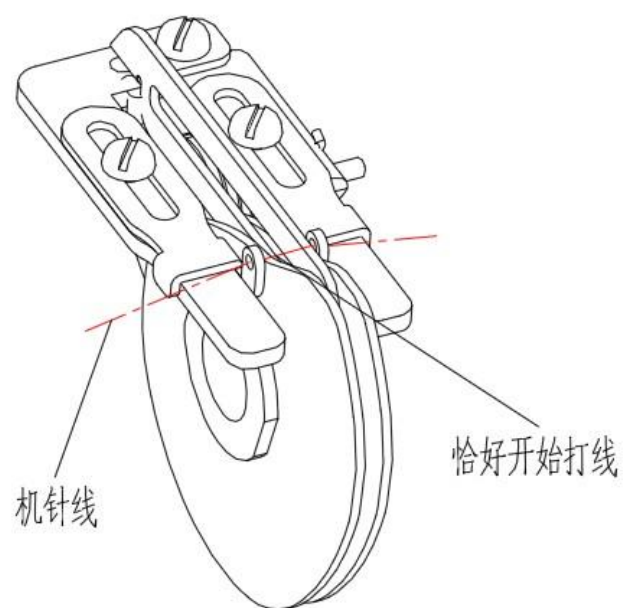


图5

②、打线凸轮打线量调整

当需要调节底线打线量时，松开紧定螺钉，调节分线片位置，分线片往上移动打线量减小，分线片往下运动，打线量增加。（图6）

②、Adjusting thread guides of CAM

When adjusting the base thread distance, first loose screw and adjust dividing thread plate position. If dividing thread plate moving up ,the thread distance get less, while vice versa.

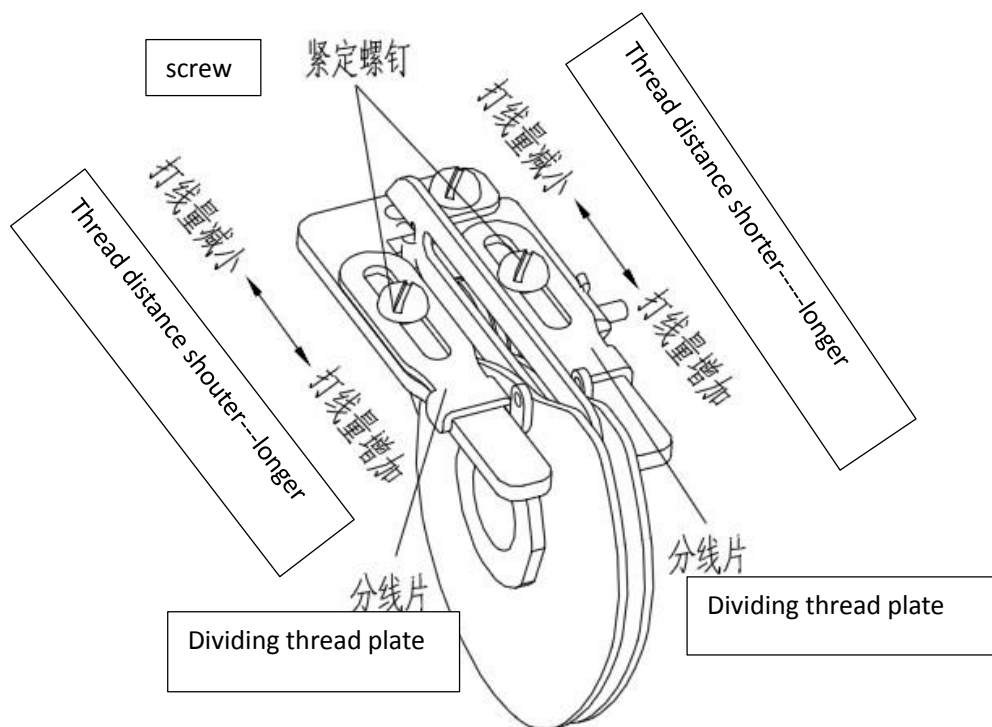


图6(Picture 6)

5、机针高度调整

首先调整机针与针板的间隙，保证机针与针板的间隙均等，调整机针高度，机针运行到最高点，针板到左针针尖的高度为H（图7），H参数如下表：

5、Adjusting needle height

Firstly, adjusting the gap between the needle and the needle plate to ensure the gap is equal. And then adjusting needle height ,when the needle run to the highest point,the height of needle plate to left needle pinpoint is H(Picture 7),and H parameter as follows:

<div> <div>标准</div> <div>standards</div> <div>机型</div> <div>Machine</div> <div>Model</div> </div>	标准行程 (30.8mm) Standards(30.8mm)	高行程 (33.4mm) Height(33.4mm)
型号 Model	左针高度H left needle Height	左针高度H Left needle Hight
K4-01GB×356	7.5	9
K4-01GB×364	7.1	8.6
K4-02BB×356	7.5	9
K4-01BB×364	7.1	8.6
K4-35AC×356	9	9
K4-35AC×364	8.6	8.6

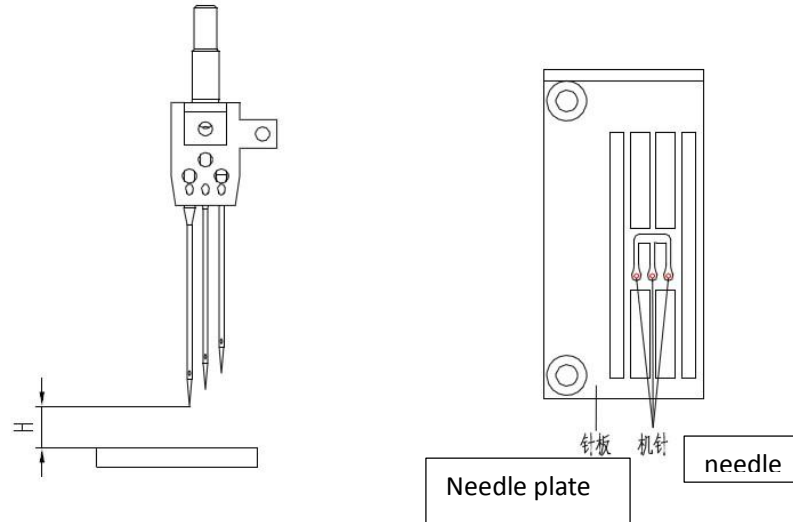


图7(picture 7)

6、弯针的调整方法

6、Looper adjusting methold

①、弯针与机针引量的调节

当机针在最低点时，弯针在最右点，弯针针尖到右针中心点距离为弯针与机针的引量A（图8），详细参数见下表：

①、Adjusting the distance of looper to needle

When needle in the lowest point, and looper in the right end point, the distance between looper pinpoint to right needle middle point is called Leading distance A (Picture 8)between looper to needle,the detailed parameter see as follows:

机型 Model	标准 Standard	标准行程（30.8mm） Standards(30.8mm)	高行程（33.4mm） Height (33.4mm)

型号 Model	弯针与机针引量A Leading distance A between looper to needle	弯针与机针引量A Leading distance A between looper to needle
K4-01GB×356	3.5-3.8	3.0-3.2
K4-01GB×364	3.1-3.4	2.6-2.8
K4-02BB×356	3.5-3.8	3.0-3.2
K4-01BB×364	3.1-3.4	2.6-2.8
K4-35AC×356	3.1-3.3	3.0-3.2
K4-35AC×364	2.7-2.9	2.6-2.8

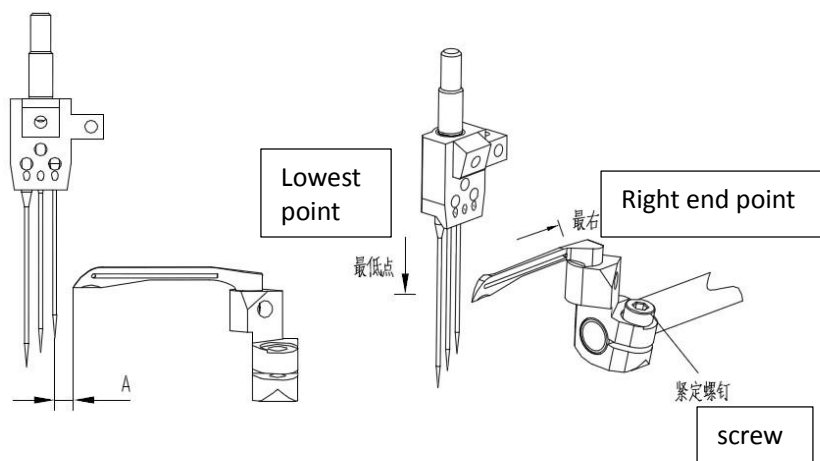


图8(Picture 8)

②、弯针与机针间隙的调整

弯针从最右端运行到中针中心后，把弯针与机针间隙调整为0-0.05mm（图9），弯针继续向左运动，当弯针运行到左针中心是，弯针与左针间隙为0.05-0.1mm（图9）。

②、Adjusting the distance between looper and needle

When looper moving from right at needle middle, adjusting the distance of looper and needle to be 0-0.05 mm(Picture 9), and looper continue to moving towards left, when is arrive the middle of left needle, the distance of looper and left needle is 0.05-0.1mm(picture 9) .

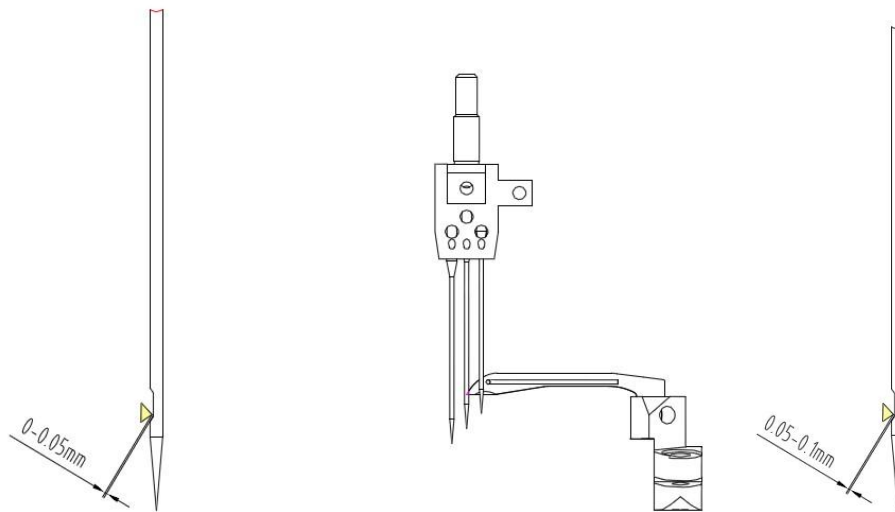


图9 Picture 9

7、后护针的调节

针杆在最低点时，调整后护针，使护针在右针孔上方1/3处，弯针先端最右位置开始到右针中心时>右针和弯针的先端前后间隙为0-0.05mm（图10）

7、 Adjusting rear guard needle

When the needle bar is at the lowest point, adjusting the rear guard needle to make it on 1/3 of the right needle hole, the right end of looper to the middle of right needle>the front and rear clearance of the right needle and loopeer is 0-0.05mm (Figure 10).

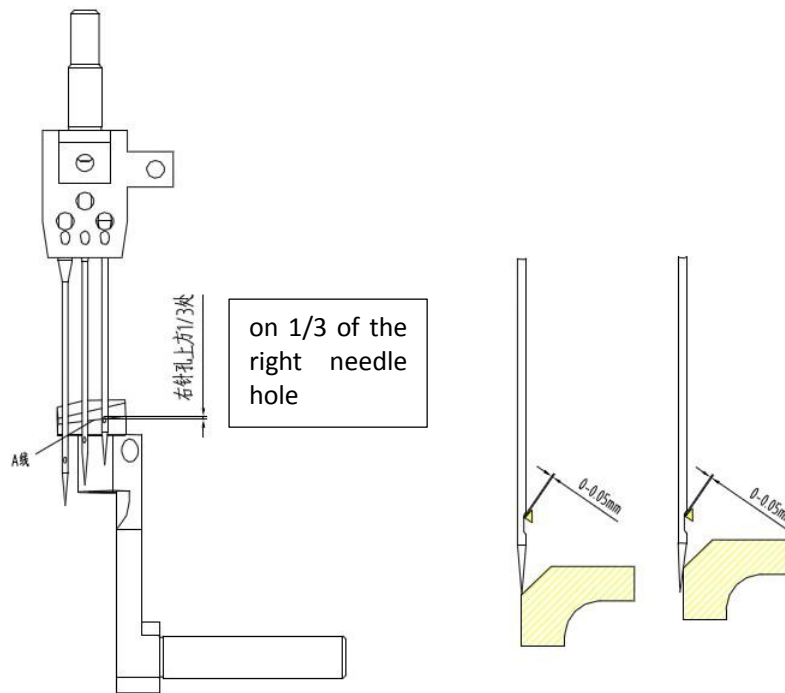


图10 picture 10

8、摆动挑线杆的同步和线环的关系

8、The relationship between swing timing bar and thread loop

提要：如果由于线环过大或过小等找出机器跳针、断线时，可以通过调节摆动挑线杆来调整线环的大小。

Tips: you can adjust swing timing bar to adjust the size of thread loop, if the thread loop is too large or too small that leads to needle-skipping, thread-broken problems.

利用过线球连杆调整

Making use of over-thread bar to adjust

松开紧定，调节过线球连杆，移动过线球连杆想前或向后，向前移动则线环变小，向后移动则线环变大。（图11）

Loose set, adjusting over-thread bar, moving the bar forward or backward,

if forward movement, the thread loop get smaller, otherwise if backward movement, the thread loop get larger.

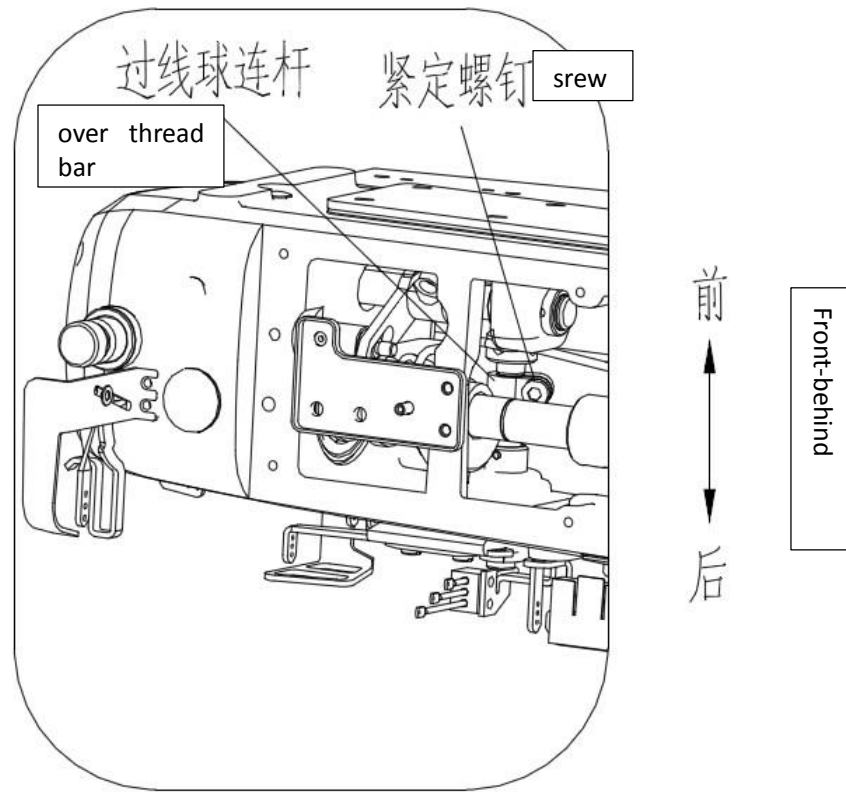


图11 (Picture 11)

9、送布牙高度的调整

9、Adjusting feed teeth height

调整送布牙高度 ,牙齿来到最高点时 ,松开螺钉2 ,将主送布牙高度调整刀1.2mm ,然后拧紧螺钉2 ,同理松开螺钉1 ,将差动送布牙的高度调整到1.2mm ,然后拧紧螺钉1。

Adjusting feed teeth height,when feed teeth get the maxmium point,loose srew2,and adjusting the feed teeth height to 1.2mm,then ,tighten screw2 and loose screw1, adjusting the feed teeth

hight to 1.2mm,and after that tighten srew1.

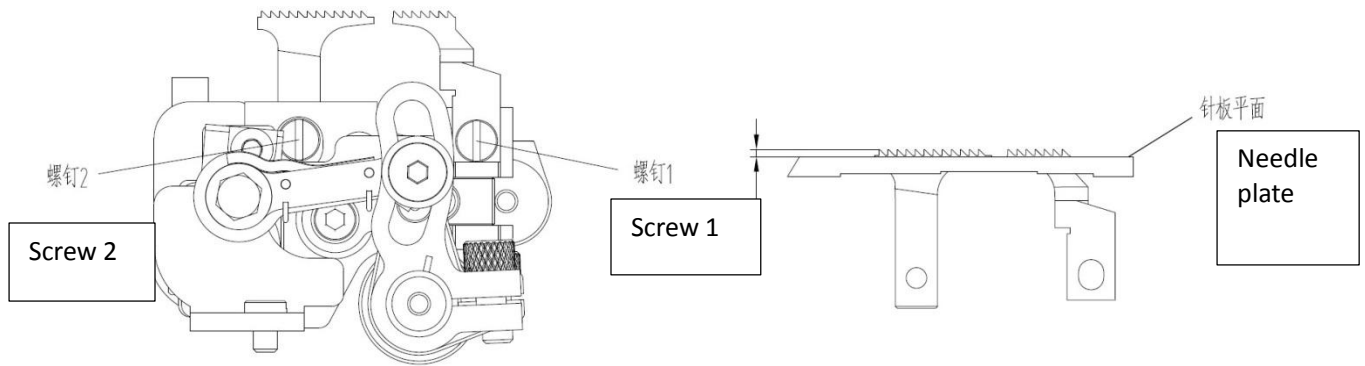


图12 picture12

10、喂针的安装位置

10、Installation position of spreader

喂针高度是针板上平面到喂针下面的距离为H，调整喂针高度，松开螺钉1，上下移动喂针（图13），使其高度为为H，H的具体取值如下表：

Spreader height H is the distance between needle plate to needle ,adjusting Spreader height, and loosing screw 1, then move Spreader up or down(picture 13) to adjusting the height is H, the specific references as follows:

机型model	标准	标准行程 (30.8mm)	高行程 (33.4mm)
		Standards(30.8mm)	Height(33.4)

型号 model	喂针高度H Spreader height H	喂针高度H Spreader height H
K4-01GB×356	7.8	9.2
K4-01GB×364	7.8	8.8
K4-02BB×356	7.8	9.2
K4-02BB×364	7.8	8.8
K4-35AC×356	7.8	9.2
K4-35AC×364	7.8	8.8

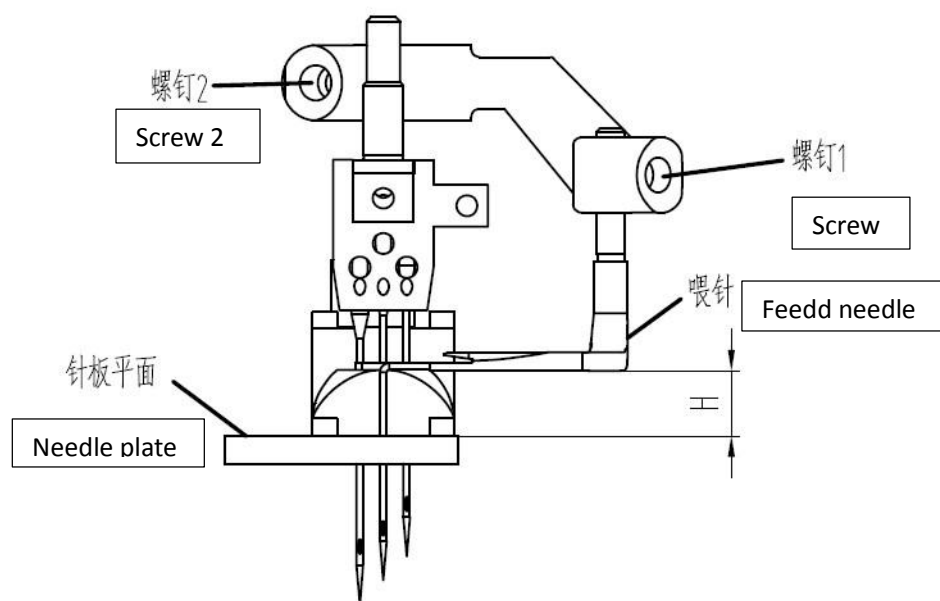


图13(Picture 13)

喂针从右往左运动，松开螺钉1，调整喂针针尖与左针间隙调整喂0.5mm，喂针继续向左运动到左极限，松开螺钉2，调整喂针与左针中心的间隙为4.5-5.0mm，然后拧紧螺钉2。

Spreader moving from right towards to left, loose screw 1, adjusting the distance between Spreader pinpoint and left needle to be 0.5mm, and

Spreader continue to move towards left to the end; and then loosening screw 2, adjusting the distance between Spreader and left needle middle to be 4.5-5.0mm, next is tighten screw 2.

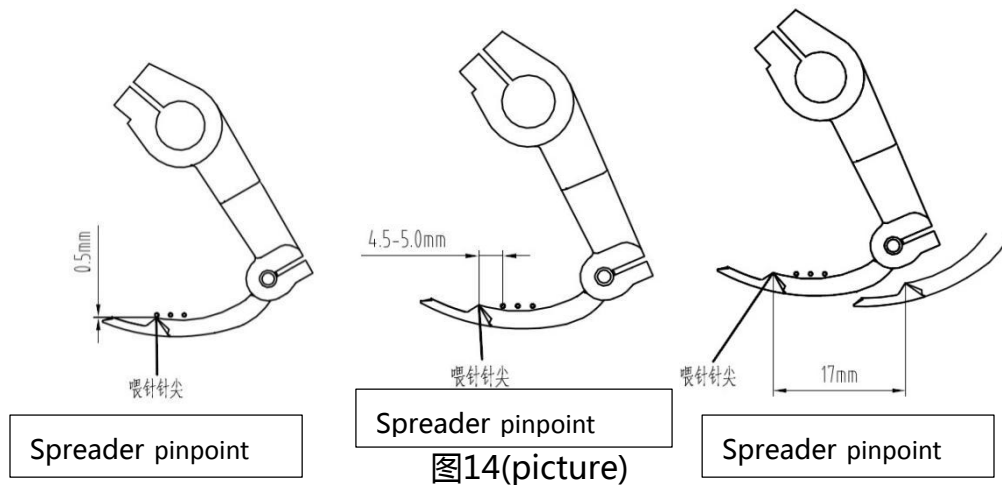


图14(picture)

11、弯针向左运动通过各针的内侧，调整针和前护针和的间隙为0.3-0.5mm，对照线的粗细，针线能顺利通过，前护针尽量靠近安装。调整前护针与前护针架为0.5mm。

11. Looper moving towards left through the inside of all needles, adjusting the distance between needle and front guard needle to be 0.3-0.5mm.

Checking thread is thick or thin to ensure the thread can be pass needle successfully, the front guard needle should near to installation. And adjusting the distance between front guard needle and front guard needle protect device to 0.5mm.

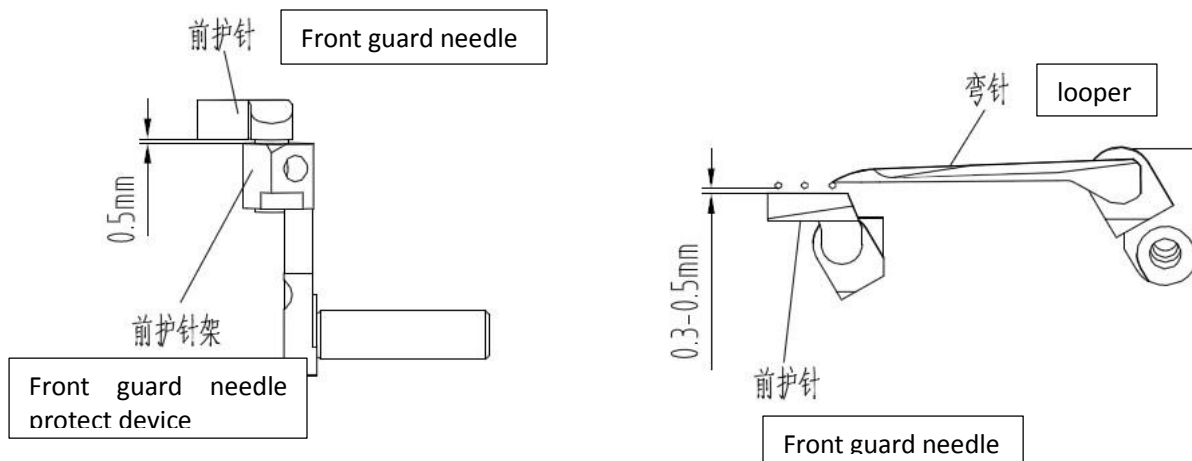


图15

12、压脚高度调节

12. Adjusting presser height

调节压脚高度时，调整螺钉的高度，不让压脚和其他零件相接触，然后用螺母进行固定。

When you are adjusting presser height, you should adjust the screw height to avoid presser touching other spare parts, and then fix it with nut

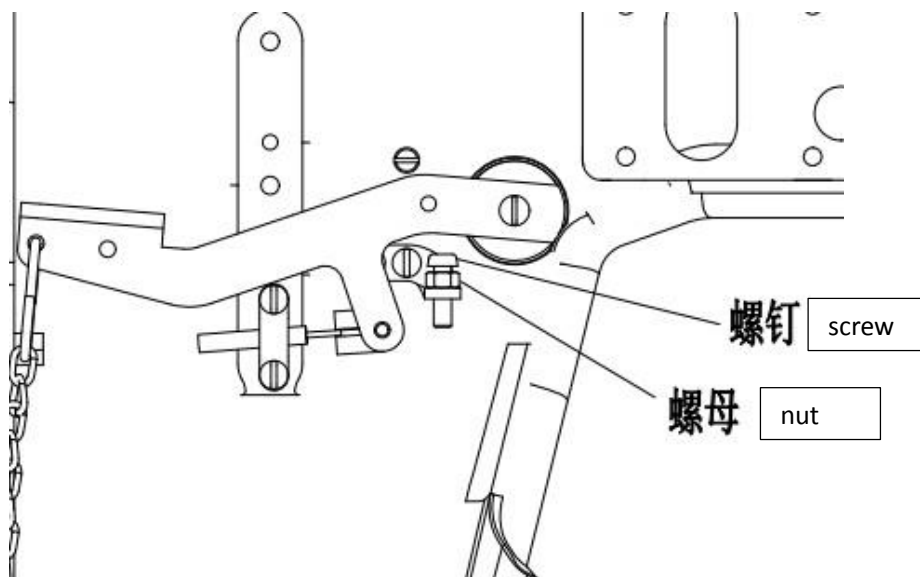


图16

七、下切刀调整 adjust lower cutter

1、下切刀左右位置调整 adjust left and right positions of lower cutter

进行下切刀调整时应使缝纫机机针处于上停针点，并关闭电控进行手动调试，手推剪线电磁铁运动通过刀盘驱动连杆带动下切刀组件向左运动(图1)，动刀向左移动(机头位置)到最左时，，动刀刀 b 尖须超出弯针孔 0.5-1.0mm，定刀下平面与弯针上平面间隙为 0-0.1mm(图2)，调节下切刀左右位置可松开紧定螺钉 2，通过调节曲柄 2 左右方向来调节下切刀位置(图3)，

When we adjust lower cutter we need to make needle point in the above on the sewing machine , and close the electronic control to manual debug,the movement of hand shear wire magnet is through the to make lower cutter component movement to the left (figure 1), At the time of the moving cutter moves to the far left position (nose position), the point of moving cutter should be 0.5 -1.0 mm beyond the hole of the looper, distance between the lower plane of the stationary knife and upper plane of the looper is 0-0.1 mm (figure 2), Adjusting the left and right position can loosen the 2, by adjusting the crank 2 left and right to regulate lower cutter position (figure 3),

当下切刀组件复位时，下切刀组件刀架与下切刀安装版边缘距离为 4mm(图4)，如上述条件在调节过程中无法同时满足，则需要通过松开调节螺母 1 与调节螺母 2 来调节剪线电磁铁行程，通过调节电磁铁行程满足上述调节要求，剪线电磁铁标准行程为 20mm(图3)。

when lower cutter component reset, distance between component tool rest of the lower cutter and incised edge of lower cutter is 4 mm (figure 4), if the above conditions can't meet at the same time, then need to loosen nut 1 and nut 2 to adjust the process of shearing electromagnet, by adjusting the process of shearing electromagnet to meet the requirements of the above regulation, standard of shearing electromagnet is 20 mm (figure 3).

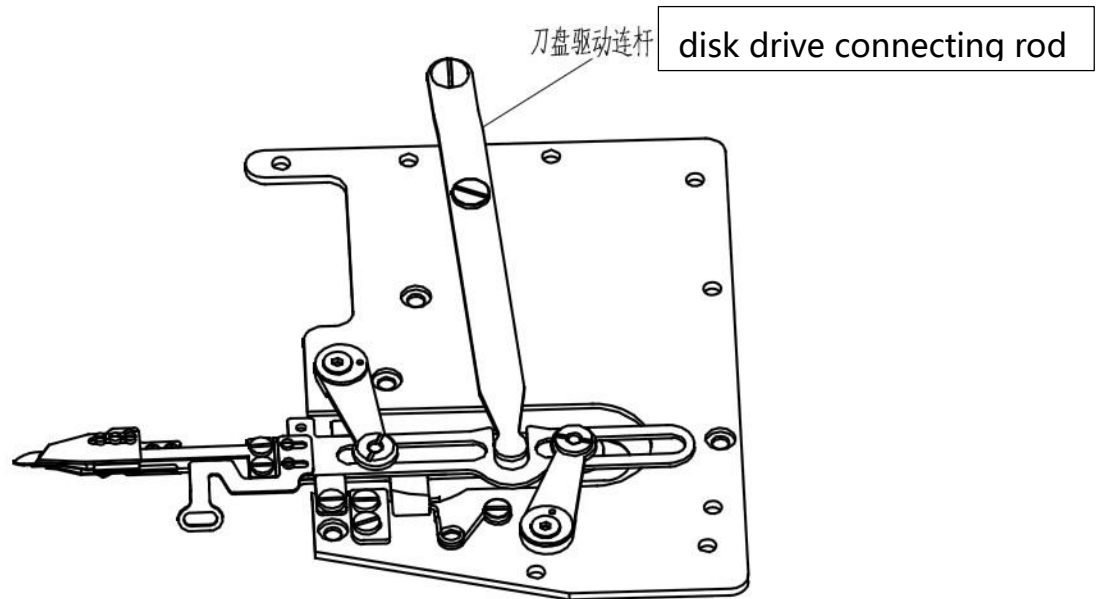


Figure 1

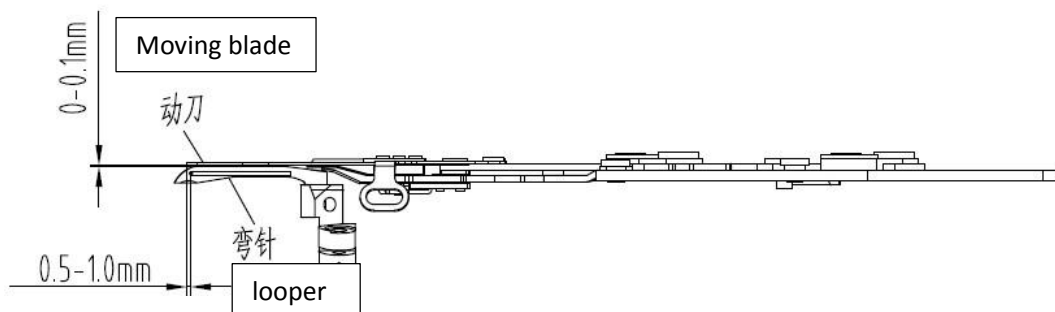


Figure 2

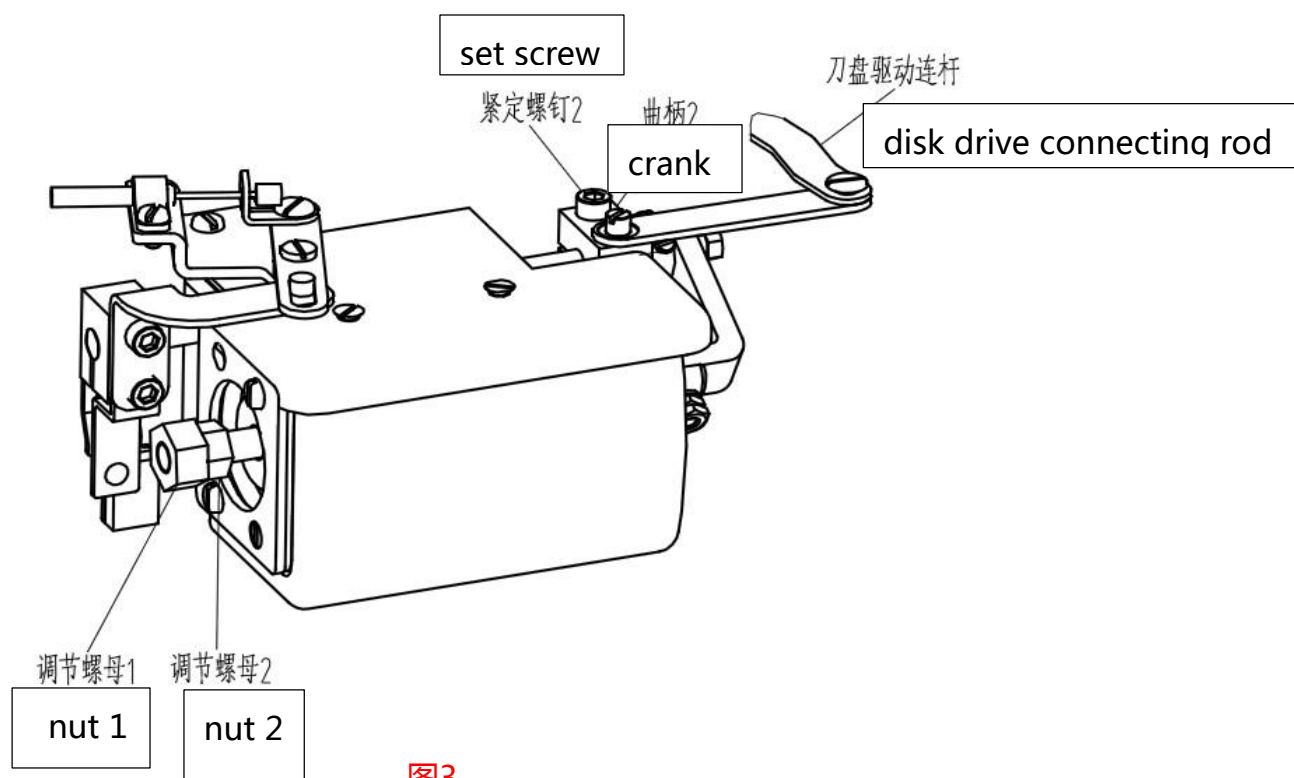


图3

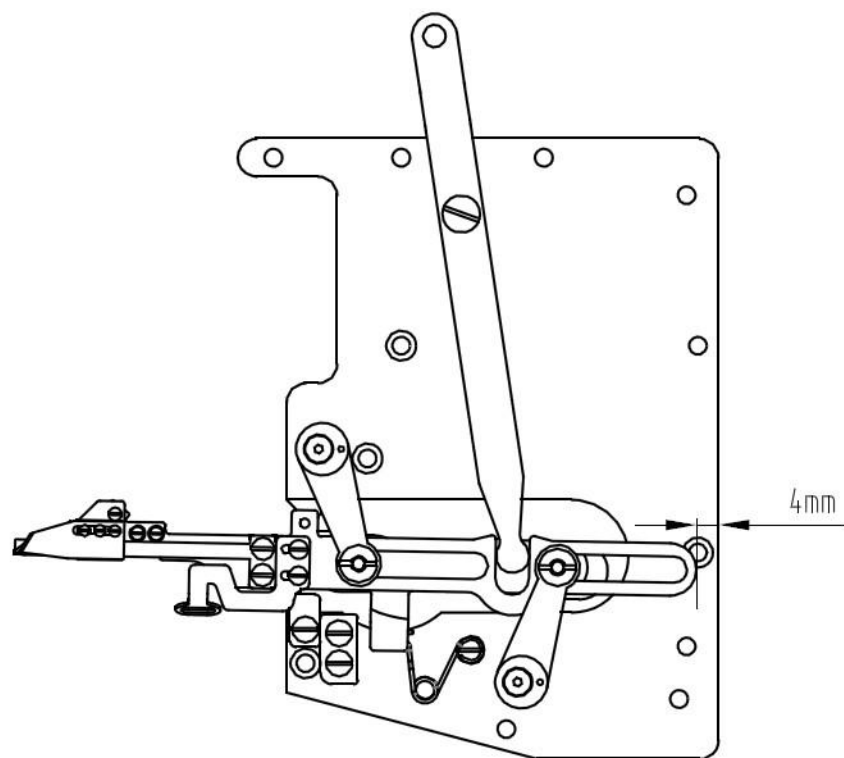


图4

2、下切刀前后位置的调整

adjust before and after positions of lower cutter

当下切刀组件由初始位置向左运动，动刀刀尖运动到弯针处，约在弯针宽度中心，前后 1/2 位置 (图 5)，调整时可通过松开紧定螺钉 2，再转动偏心销，使动刀前后移动，调整刀正确位置 (图 6)。

When lower cutter components moves from the initial position to the left, the moving blade moves to the place of looper, roughly in the center width of the looper, 1/2 position (figure 5), we can by loosening set screw 2, then turn to made it move back, adjust the cutter correct position (figure 6).

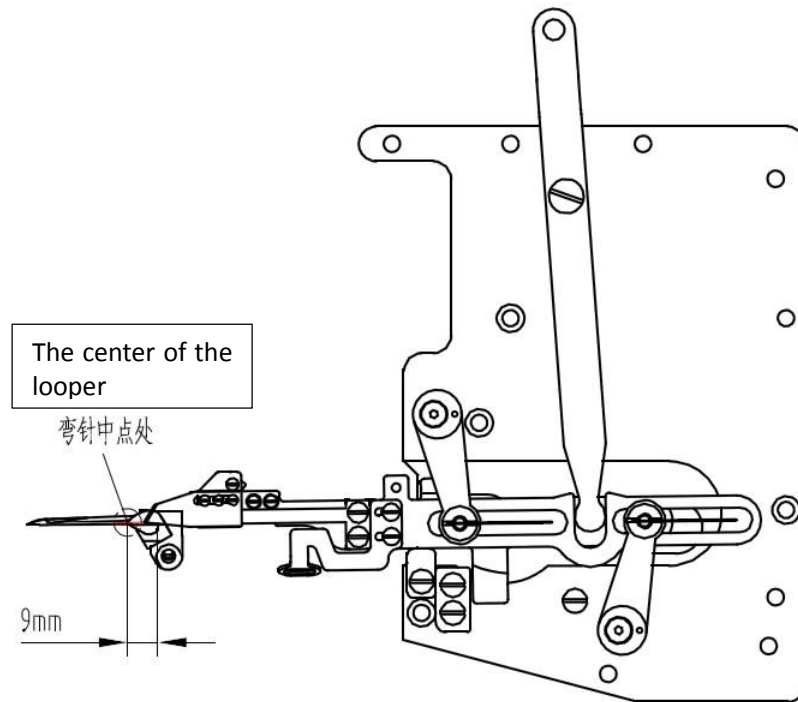


图 5

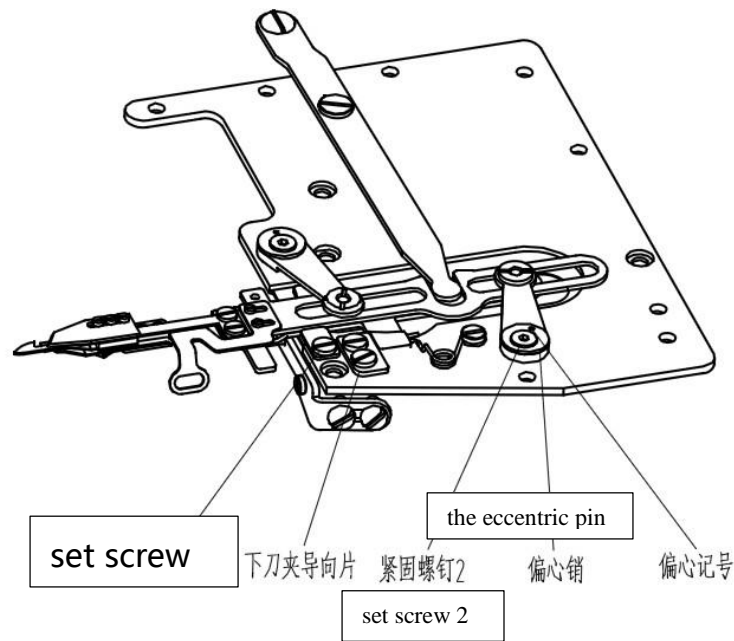


图 6

3、下切刀组件相对位置调整

Adjust relative position of the lower blade component

注意:下切刀组件安装前须先检查下切刀组件相对位置是否正确, 是否有卡点。

Note: Before install the lower blade ,we must check the relative position of the lower blade component and there is a card point or not.

当动刀运动到最右时, 也就是下切刀组件初始状态时, 动刀与定刀前端的啮合距离为 0.5-1mm (图 7), 调整时可通过松开螺钉 1 (图 9), 移动定刀调整动刀与定刀的相对位置, 动刀与定刀啮合距离 0.5-1mm , 动刀与定刀平行(图 7、图 8)。松开螺钉 1 调整夹线片的前后及左右位置, 保证夹线片与定刀平行(图 10)。压力片的调整可通过调节螺钉 4 , 移动压力片, 使其与定刀尖端距离 4mm , 且与定刀平行(图 11)。

When moving blade moves to the far right, when is it in the original

state, the engaging distance between the point of moving blade and fixed blade is 0.5-1 mm (figure 7), adjustments can be loosen screw 1 (figure 9), moving the fixed blade to adjust the relative position of the moving blade with the fixed blade, engaging distance between the moving blade and the fixed blade is 0.5-1 mm , at that time the moving blade is parallel to the fixed blade (figure 7 and figure 8).

Loosen the screw 1 to adjust the before and back distance , and ensure that the clip is parallel to the fixed blade. (FIG. 10).

The adjustment of the clip can be adjusted by adjusting the screw 4, moving the clip, to make the distance between it and fixed cutter is 4mm, and is parallel to the set cutter. (figure 11).

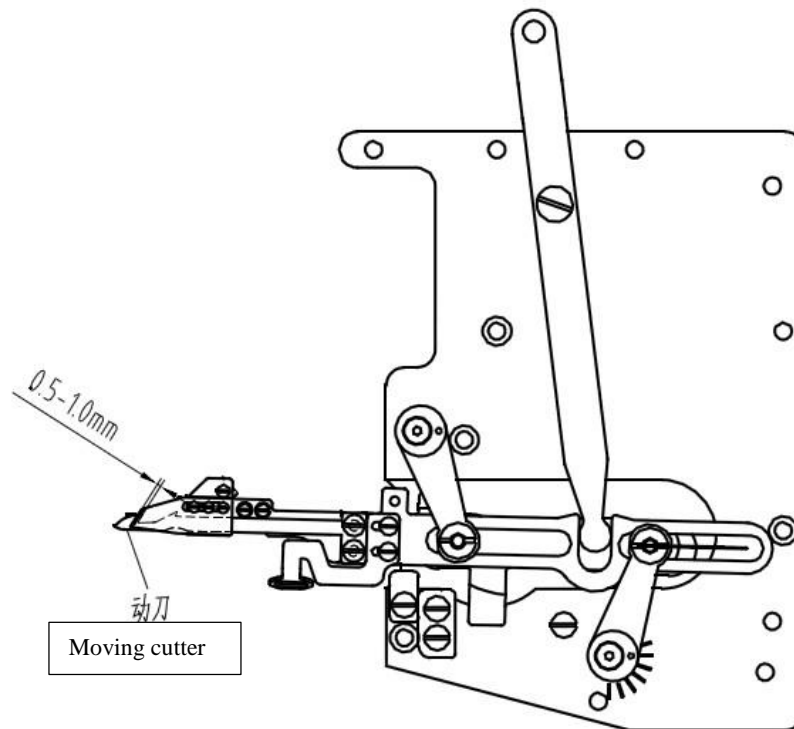


图 7

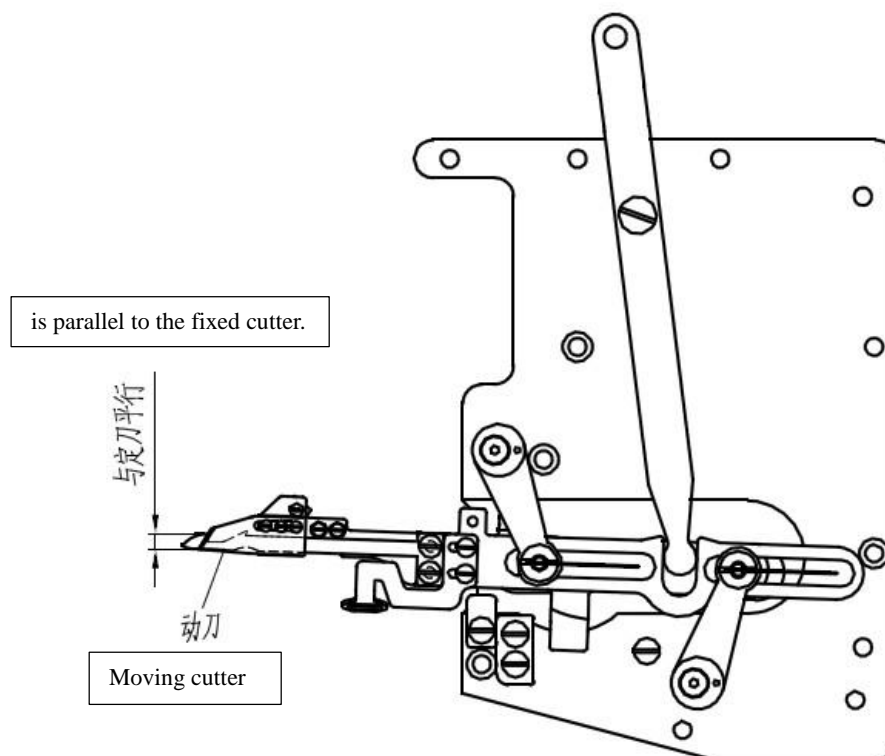


图 8

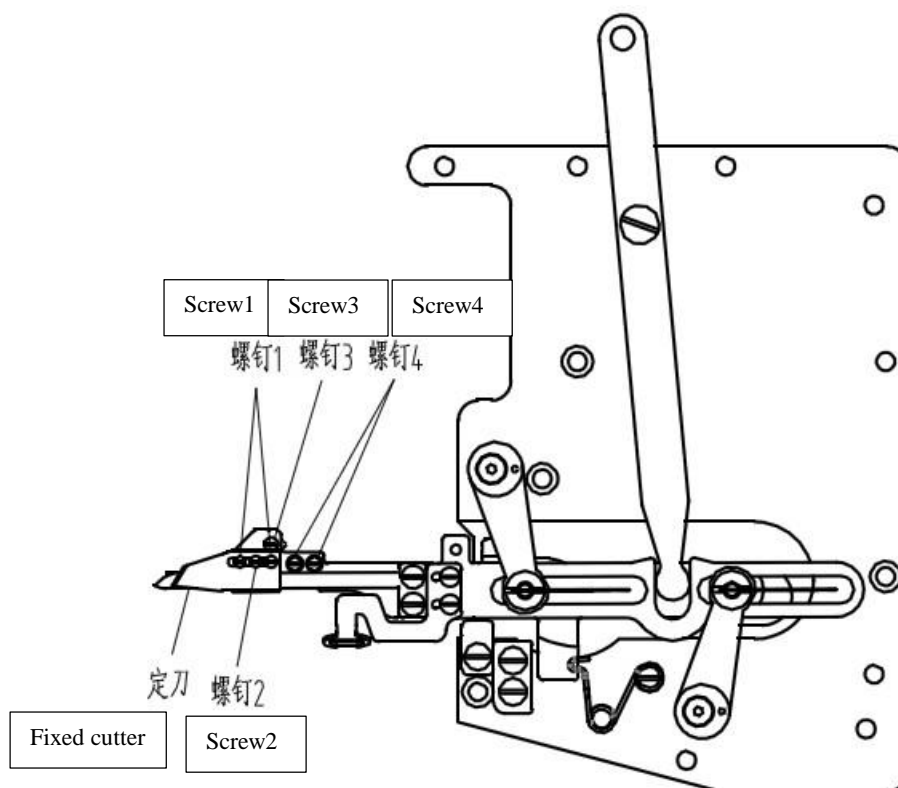


图 9

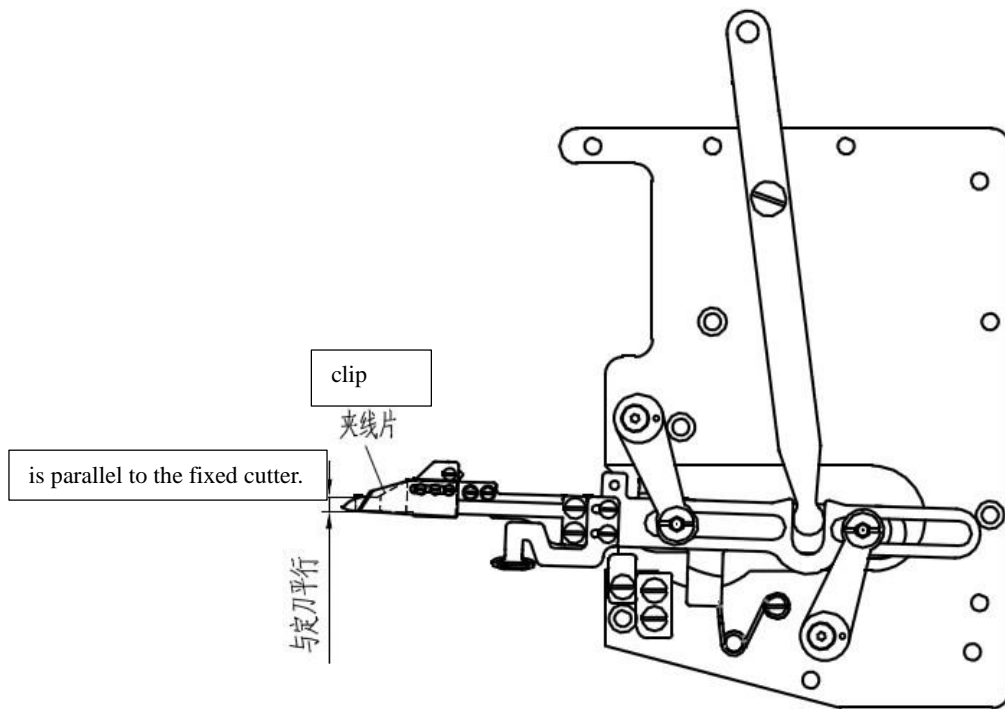


图 10

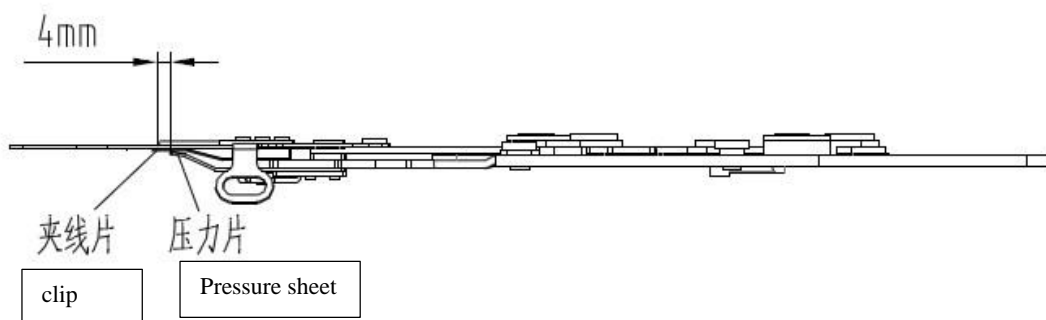


图 11

4、夹线片及压力片的调整

Adjust clip and pressure sheet

当下弯针线被下切刀组件切断后，动刀与夹线片需将底线（下弯针线）稳定夹住，调节夹线片与动刀之间的夹紧力，可由紧定螺钉旋转来调整，顺时针方向则夹紧力越大，反之则夹紧力越小（图 12）。

When the lower looper was cut of lower blade components , we need use moving blade and the clip to steadily the bottom line (lower looper) , to adjust the clamp force between the clip and moving blade ,it can be adjusted by rotating set screw , clockwise for clamp force is bigger and bigger, otherwise is smaller and smaller. (figure 12).

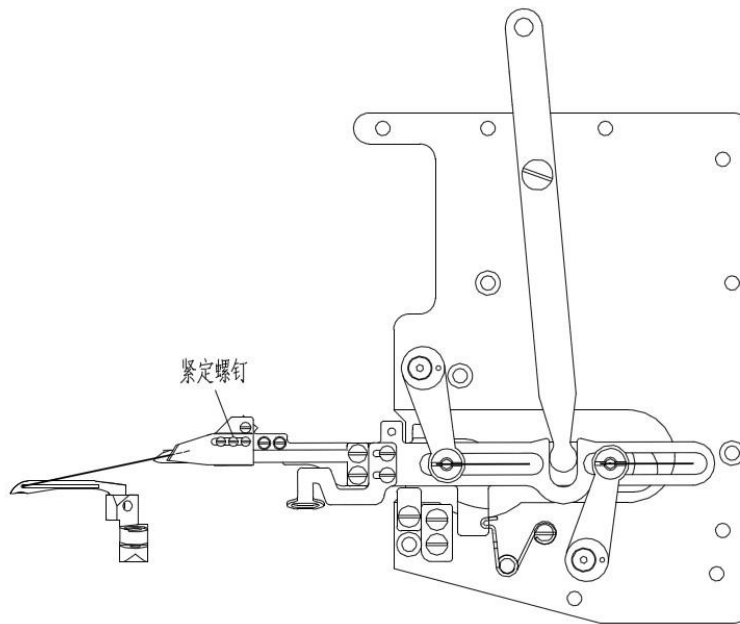


图 12

注意：

- 1、下切刀组件完成调试后，需再次手动推动下切刀组件的定刀剪线，确认相对位置准确，下切刀组件推出及复位均无卡点后方可重启电控，然后进行剪线。
- 2、当下切刀组件需要进行调整时，需确认针杆处于最高点，下弯针处于最右点，然后方可手动推动下切刀组件确认相关位置。

八、上切刀组调整

注意：安装调整上切刀组前，必须先确认针杆处于最高点，且喂针与机针位置处于

标准状态。

1、上切刀组动刀与定刀啮合量的调整

请把定刀与动刀的啮合量调整为0.5-1.0mm，可通过松开紧定螺钉，上下移动动刀架，调整定刀与动刀的啮合量为0.5-1.0mm（图13）。

note:

1. After the lower cutter assembly is finished debugging, it is necessary to manually push the cutter of the lower cutter assembly again to confirm the relative position is accurate. The lower cutter assembly is released and reset without any stuck before restarting the electric control and then cutting the wire.

2, when the lower cutter assembly needs to be adjusted, be sure to confirm the needle bar at the highest point, the lower looper at the far right point, and then can only manually push the lower cutter assembly to confirm the relevant position.

Second, adjust the top cover thread trimmer

Note: Before installing and adjusting the top cover thread trimmer, confirm that the needle bar is at the highest point and the position of the needle and the needle are in the standard state.

1, on the knife group knife and fixed knife meshing amount of adjustment
Adjust the amount of engagement between the fixed knife and movable knife to 0.5-1.0mm. By loosening the set screw, move the movable knife

holder up and down to adjust the amount of engagement between the fixed knife and movable knife to 0.5-1.0mm (Figure 13).

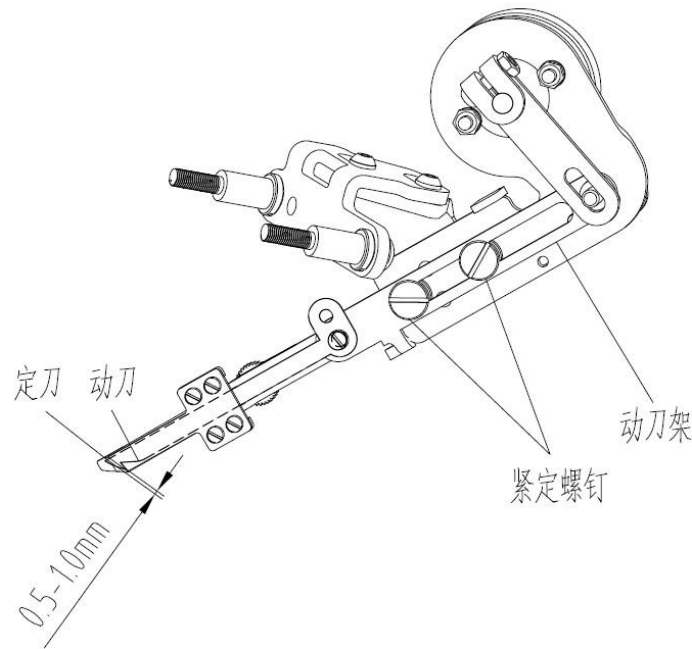


图13

2、上切刀组弹簧夹紧力的调整

上饰线切线后，被夹紧弹簧夹持，调节夹紧弹簧夹紧力，松开紧定螺母转动紧定螺钉，可以调节夹紧弹簧的夹紧力，拧紧紧定螺钉夹紧弹簧夹紧力加大，拧松紧定螺钉夹紧弹簧的夹紧力减小，调整完成后，拧紧紧定螺母（图14）

注意：请在能夹紧上饰线的范围内，尽量把夹持力调整到稍小范围！

2, spring clamping force of up thread trimmer asms adjustment

Trim the upper thread trimmed by the clamping spring to adjust the clamping force of the clamping spring and release the clamping nut to rotate the clamping screw to adjust the clamping force of the clamping

spring and tighten the clamping screw. If the force increases, loosen the set screw. The clamping force of the clamping spring decreases. After the adjustment is completed, tighten the set nut (Figure 14)

Note: Please be able to clamp the upper decorative line range, try to adjust the clamping force to a lesser extent!

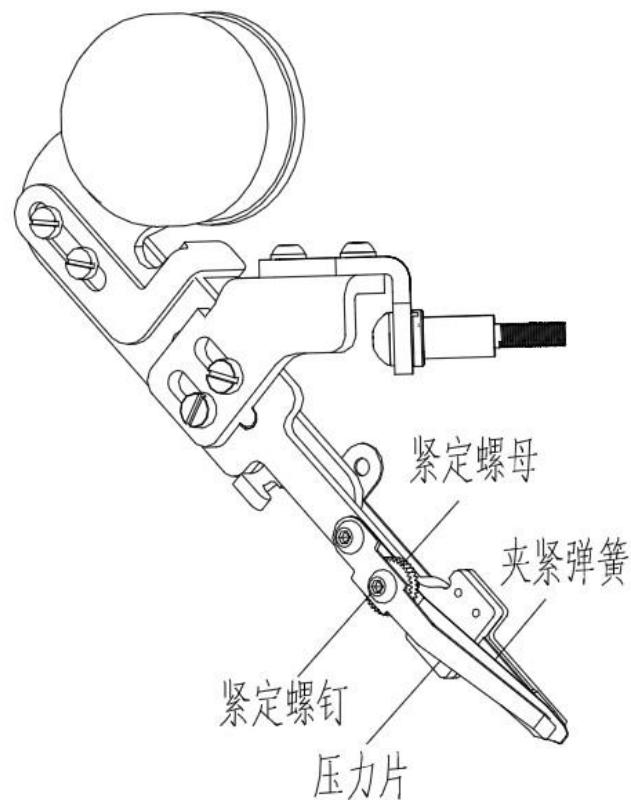


图14

3、上切刀组高度及角度的调整

当动刀往下运动，并运动到最低点时，动刀需在喂针与机针中间位置，动刀尖与压脚间距2-3mm，可通过调节紧定螺钉3和紧定螺钉4来调节安装板左右位置，从而调节上切刀组的角度，使动刀在机针和喂针中间（图15），动刀勾尖与喂针勾尖

基本齐平（图17），松开紧定螺钉1，上下移动挡板，可以调节动刀行程，同时松开紧定螺钉2，将整个上切刀上下移动，调节上切刀组的行程，调节标准。动刀运行到最低时，动刀尖与压脚间距为2-3mm。（图16）

3, on the top cover thread trimmer height and angle adjustment

When the movable knife moves downward and moves to the lowest point, the moving knife needs to be positioned between the needle and the needle. The distance between the movable knife tip and the presser foot should be 2-3mm. By adjusting the set screw 3 and the set screw 4 Adjust the mounting plate to the left and right to adjust the angle of the upper knife set so that the knife is centered between the needle and the needle (Figure 15). The tip of the knife is essentially flush with the tip of the needle (Figure 17) Set screw 1, move the baffle up and down, you can adjust the movable knife stroke, while loosening the set screw 2, move the entire cutter up and down, adjust the stroke of the cutter group, adjust the standard. Moving knife to the lowest operation, moving the tip and presser foot spacing of 2-3mm. (Figure 16)

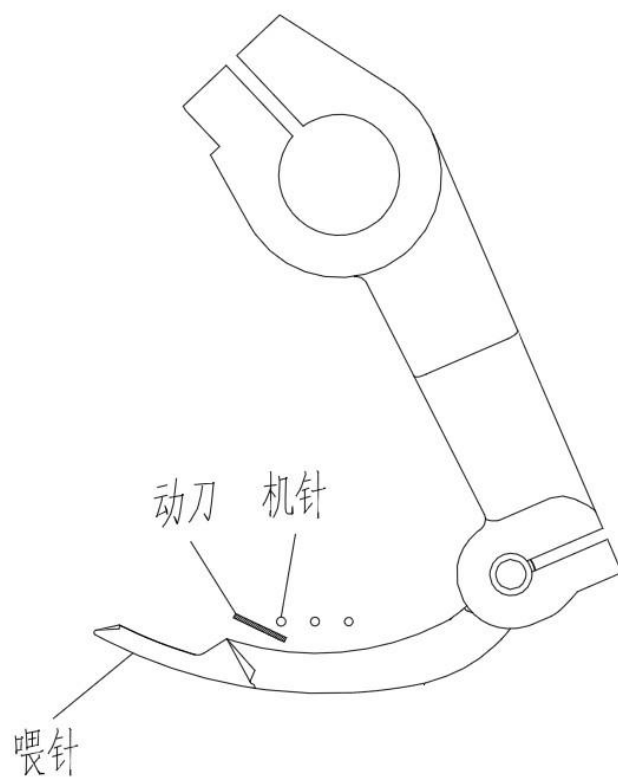


图15

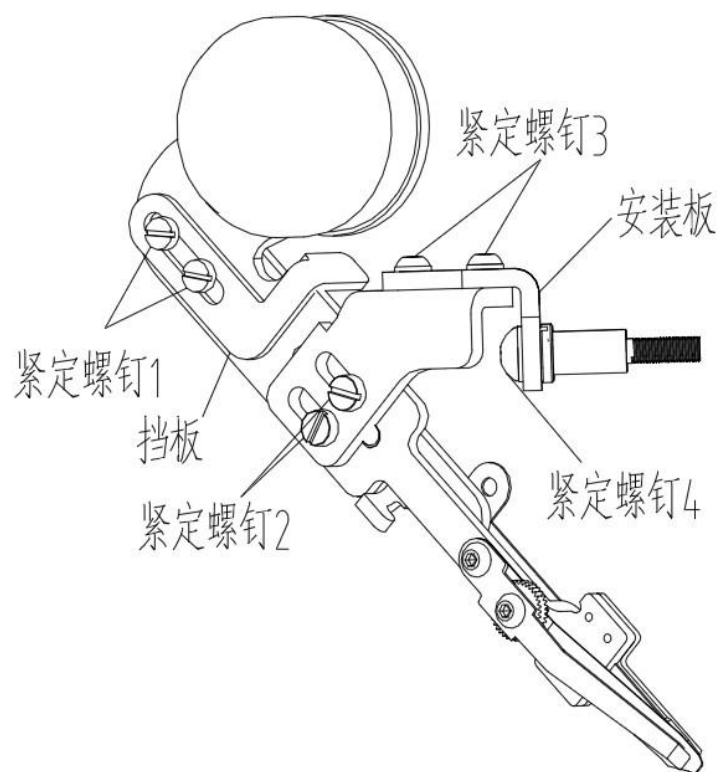


图16

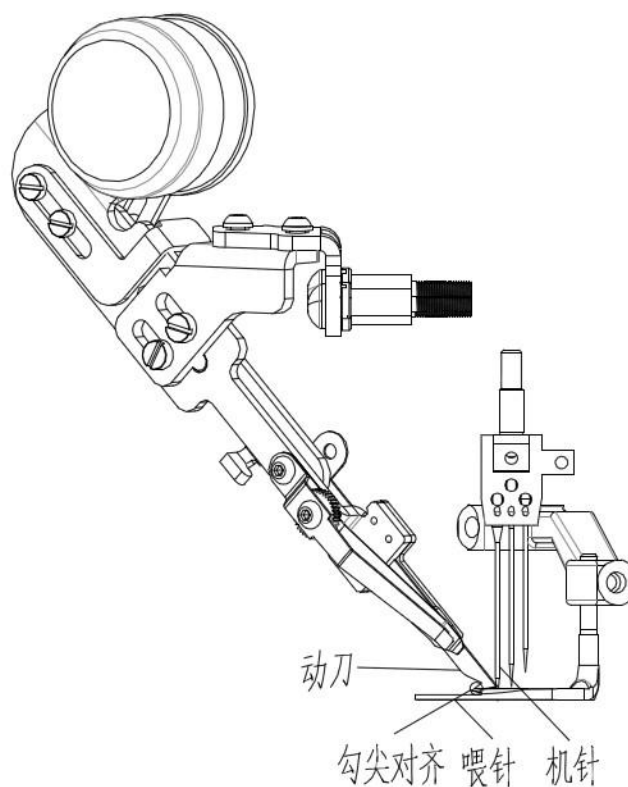


图17

九、拨线器的调整

1、拨线器高度调整

当拨线片往下运动到最低点时，拨线片底面与左机针（长针）针尖齐平（图18）。可以通过松开紧定螺钉1来调节拨线器上下位置，从而调节拨线器的高度（图19）。

2、拨线器前后位置调整

当拨线器通过压脚时，拨线片与压脚的间隙为1mm（图18），可通过松开紧定螺钉2来调节拨线器的前后位置，从而调节拨线器与压脚的间隙。

3、拨线器左右位置调节

当拨线片运行到最左端的时候 拨线片的勾尖与左针之间的距离为3.5mm(图20), 可通过松开紧定螺钉3来调节拨线器的左右位置。

Third, the adjustment of the wire

1, thread height adjustment

When the wiper is moved down to the lowest point, the underside of the wiper is flush with the left needle (long needle) tip (Figure 18). You can adjust the wiper position by loosening the set screw 1 Dial height (Figure 19).

2, before and after the wiper position adjustment

When the wiper passes the presser foot, the gap between the splinter and the presser foot is 1 mm (Figure 18) and the front and rear position of the wiper can be adjusted by loosening the set screw 2 to adjust the position of the wiper and presser foot gap.

3, about the position adjustment dial

When the wiper is run to the far left, the distance between the hook tip of the wiper and the left needle is 3.5 mm (Figure 20). Adjust the left and right positions of the wiper by loosening the set screw 3.

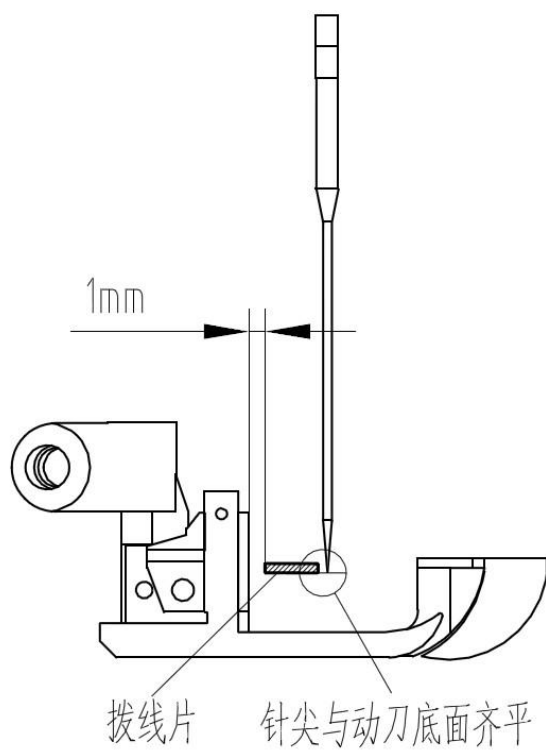


图18

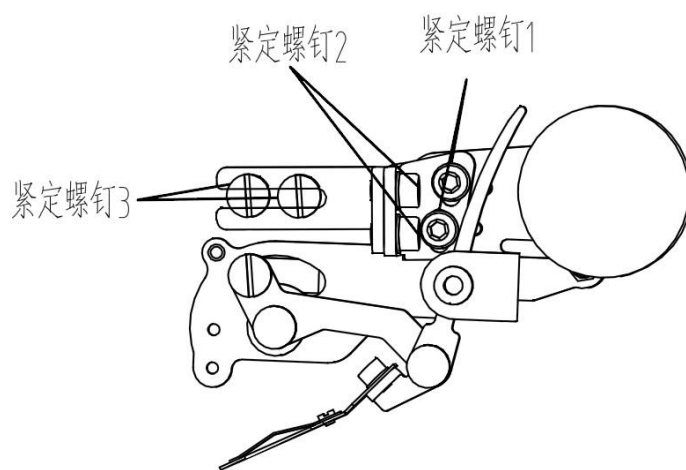


图19

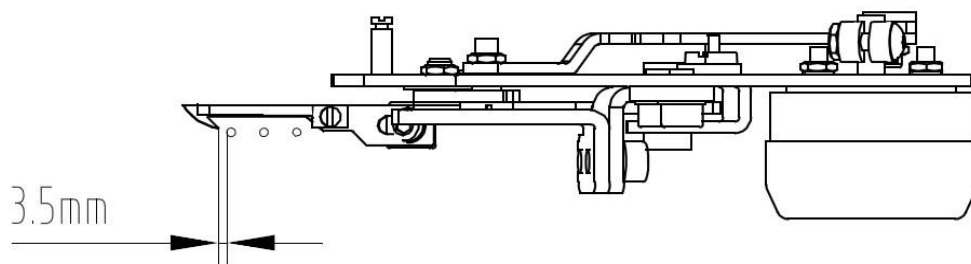


图20

十、安全开关的调整

调节安全开关与电磁阀间隙，安全开关与电磁阀间隙为0.5mm，可通过松开紧定螺钉上下调节安全开关与电磁阀的间隙，知道安全开关灯亮为止，然后拧紧紧定螺钉（图21）

Fourth, the safety switch adjustment

Adjust the clearance between the safety switch and the solenoid valve. The clearance between the safety switch and the solenoid valve is 0.5mm. Adjust the clearance between the safety switch and the solenoid valve by loosening the set screw. Until the safety switch is on and tighten the set screw (Figure 21)

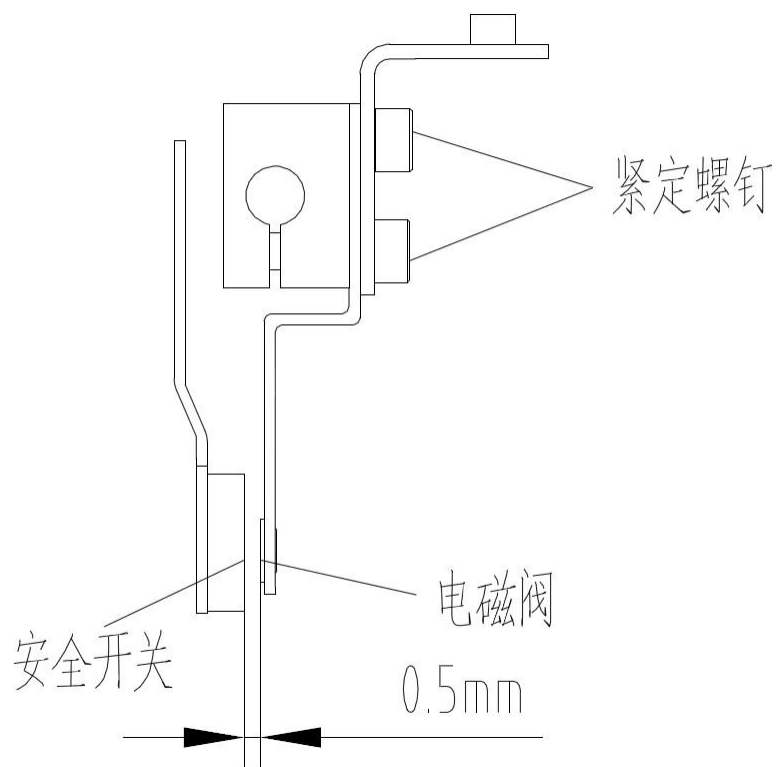


图21