

## H6 系列

## 产品使用说明书

## H6 series product instruction manual

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## 杰克缝纫机

JACK SEWING MACHINE

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## 1.主要技术规格

缝料	中厚料、厚料
最高转速	2200 针 / 分
最大针距	10mm
最大缝厚能力	8mm
压脚交互量	3.5-5.5mm
机针	DPx17(20#~23#)
压脚提 升高度	手控 7mm 膝控 16mm
旋梭	自动润滑大旋梭
供油方式	全自动供油

## 1.MAIN SPECIFICATIONS

Material	Medium and heavy duty
Max sewing speed	2200spm
Max. stitch length	10mm
Max. thickness	8mm
Alternate presser foot lift volume	3.5-5.5mm
Needle	DPx17(20#~23#)
Presser foot lift	by hand 7mm by knee 16mm
Hook	Auto-lubricating big rotating hook
Lubrication	Auto lubrication

## 2.操作准备

### (1) 试擦机器

机头装箱前为了防止机件生锈，各部分均涂有较厚的防锈油脂，同时机头装箱后，还可能在较长的贮藏和长途运输阶段造成油脂硬化和积聚在机器表面的灰尘，所以必须将表面的油脂和灰尘用汽油和洁净的软布试擦干净。

### (2) 检查

机器出厂时，虽然经过周密的检查和试验，但在长途运输中也可能受到强烈的振动使机件松动或歪曲，所以应该作一次周密仔细的检查，并用手轻轻转动主动轮，看机件之间有无转动困难，碰撞现象或其它不均匀的阻力，不正常的声响，如有应做适应的调整，机器情况正常后才可正式试车。

## 2.PREPARATION

### (1) Cleaning the machine

Before leaving the factory, the machine parts are coated with rust-preventive grease, which may be hardened and contaminated by dust during storage and shipment. This grease must be removed with gasoline.

### (2) Examination

Though every machine is confirmed by strict inspection and test before leaving the factory, the machine parts may be loose or deformed after long distance transportation with jolt. A thorough examination must be performed after cleaning the machine. Turn the balance wheel to see if there is running obstruction, parts collision, uneven resistance or abnormal noise. If these exist, adjustment must be made accordingly before run-in operation.

### 3. 润滑 (图 1) / Lubrication (Fig1)

#### 1. 油量

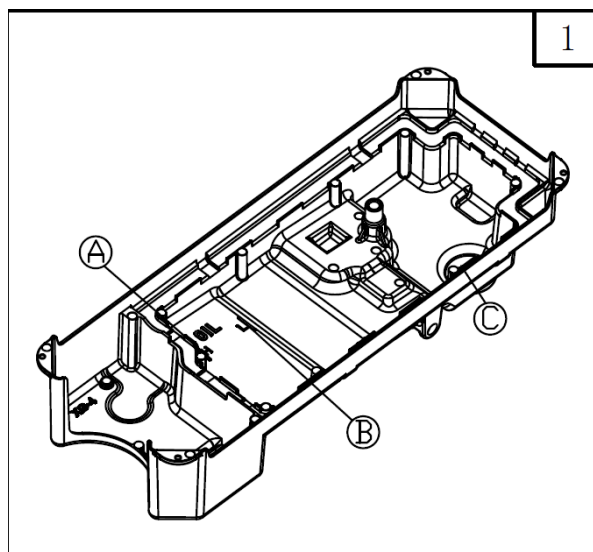
油量必须按油盘内标记加注。图中标记 (A) 是油量最高位。(B) 是油量最低位。注意油量不得低于标记 (B)，否则缝纫机各部位就会出现进油停止，造成发热咬死等情况。

#### 2. 加油

必须使用 10# 高速缝纫机油，运转前油量加至标记 (A)。

#### 3. 换油

- ① 旋下放油螺钉 (C)，排净废油。
- ② 扫清油盘污尘，旋紧放油螺钉 (C)，加注新油。



#### 1. Oil amount

Please fill the oil according to the mark indicated on the oil pan. Mark (A) means the highest position. Mark (B) means the lowest position. If the oil amount is lower than the Mark (B), oil will not be pumped and machine will be jammed.

#### 2. Fill the oil

Please fill the 10# sewing oil into the oil pan until to the Mark (A).

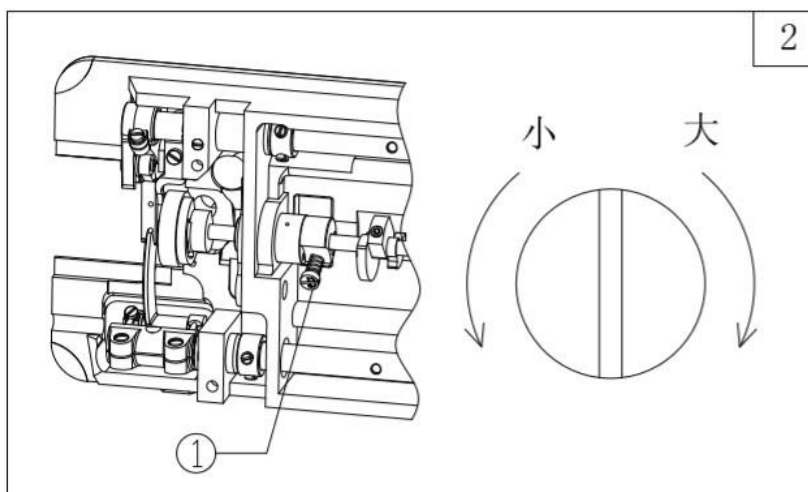
#### 3. Change the oil

- ① Uninstall the screw (C), and drain out the used oil.
- ② Clean the oil pan, and tighten the screw (C), fill the fresh oil again according the requirement.

### 4. 调节旋梭油量 (图 2)/Adjusting the amount of oil in the hook(Fig 2)

放倒机头，转动油量调节螺钉①调节油量大小。

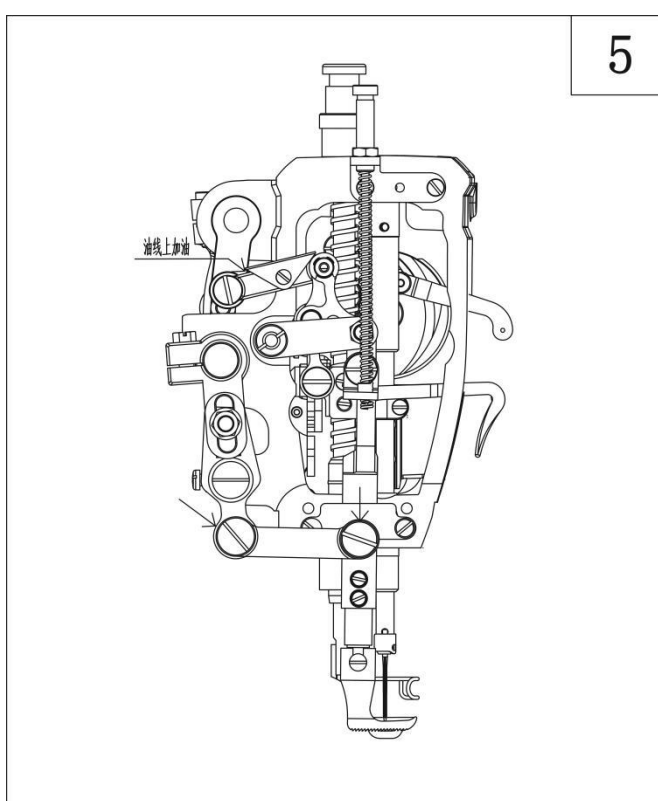
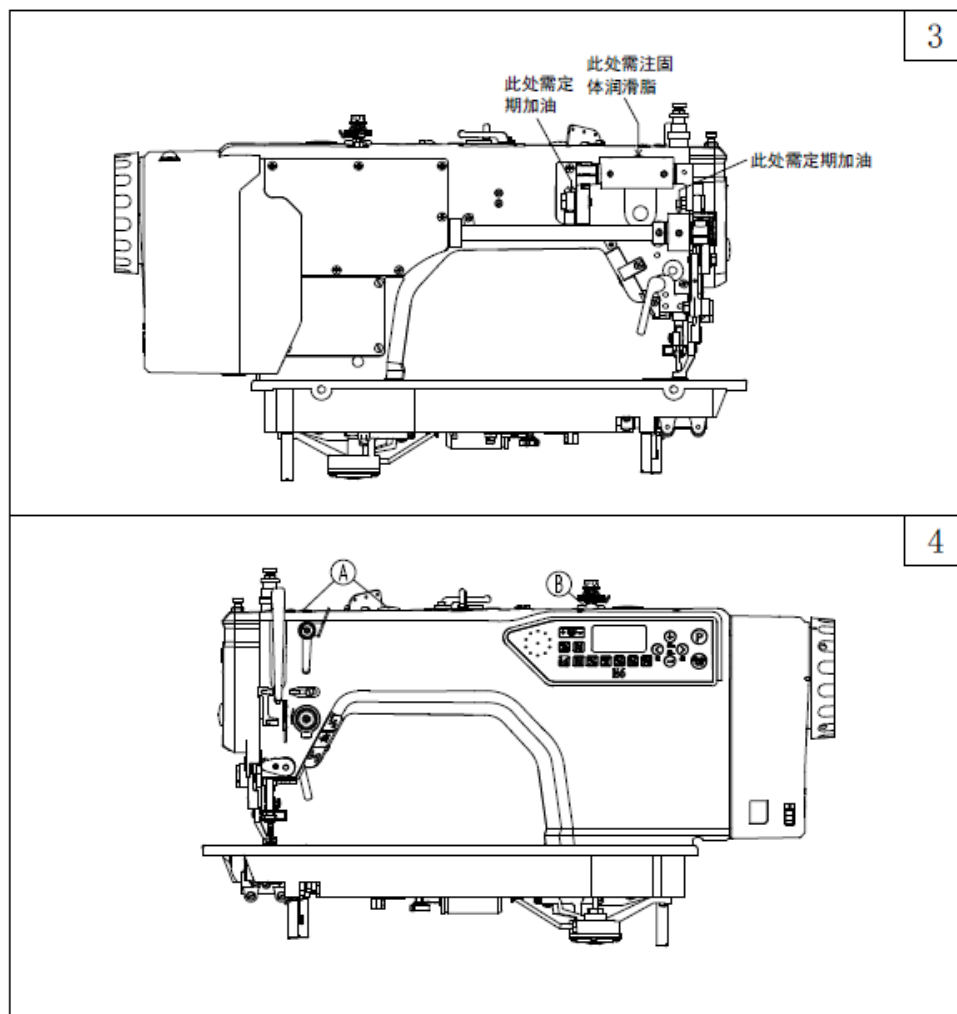
Put down the head and tighten or loosen oil amount adjustment screw to increase or decrease the amount of oil in the book.



## 5.试车（图 3、4、5）/Test run (Fig 3 4 5)

新机器在开始使用和长期搁置重新使用时先卸下机头上部的橡皮塞（A）和面板，按图示的位置充分加油，然后装上面板，抬起压脚进行低速运转 1000-1500 针/分，并观察油窗（B）的喷油情况，润滑正常后，仍需保持低速 30 分钟的运转试验，以后逐步提高缝纫速度；经过一个月左右的使用，使机器充分跑合。然后根据工作的性质再提高到一定缝速。图 5 箭头所示，提升轴中套处每隔半年加注固体润滑脂，摆动轴前套处每隔 1-2 天滴加白油 1-2 滴，溢出白油擦拭干净。

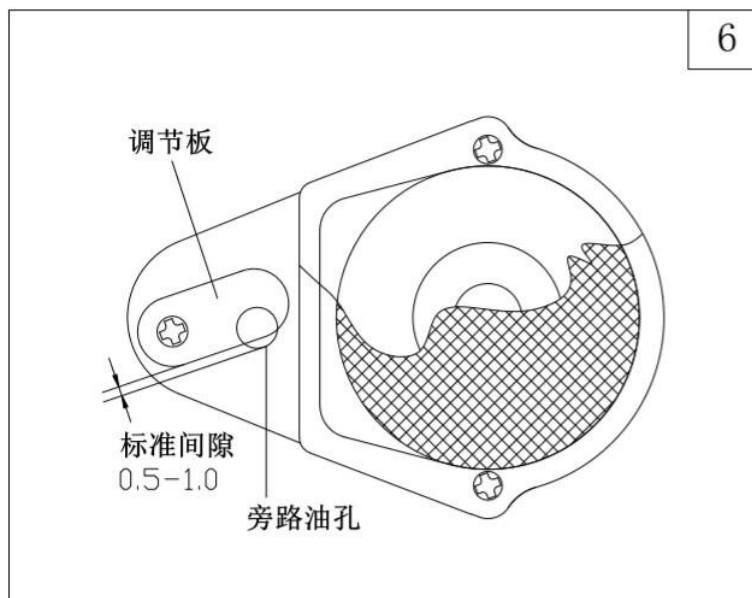
When the new machine starts to use or is put on hold for a long time, it first unloads the rubber plug (A) and the panel on the upper part of the machine head, fills up the oil sufficiently according to the graphic position, then installs the upper panel, and raises the Presser Foot to run 1000-1500 needles/min at low speed, and observes the oil injection situation of the oil window(B). After lubrication is normal, it still needs to keep running at low speed for 30 minutes. After testing, the sewing speed is gradually increased, and after about one month's use, the machine can fully run and sew. Then according to the nature of the work, it can be increased to a certain seam speed. As shown by the arrow in Fig.5, the solid grease is added every six months in the sleeve of the lifting shaft, and 1-2 drops of white oil are added every 1-2 days in the front sleeve of the swinging shaft, and the white oil is wiped clean.



## 6.油泵进油调节（图 6） / OIL PUMP SUPPLY ADJUSTMENT（Fig 6）

通常情况下，不作油泵进油调节，在低速运转时，观察油窗，无喷油现象时，请合拢间隙。

Generally no adjustment is for oil pump. When the machine is running at a low speed, observe the oil screen .If no oil splashing, close the clearance.



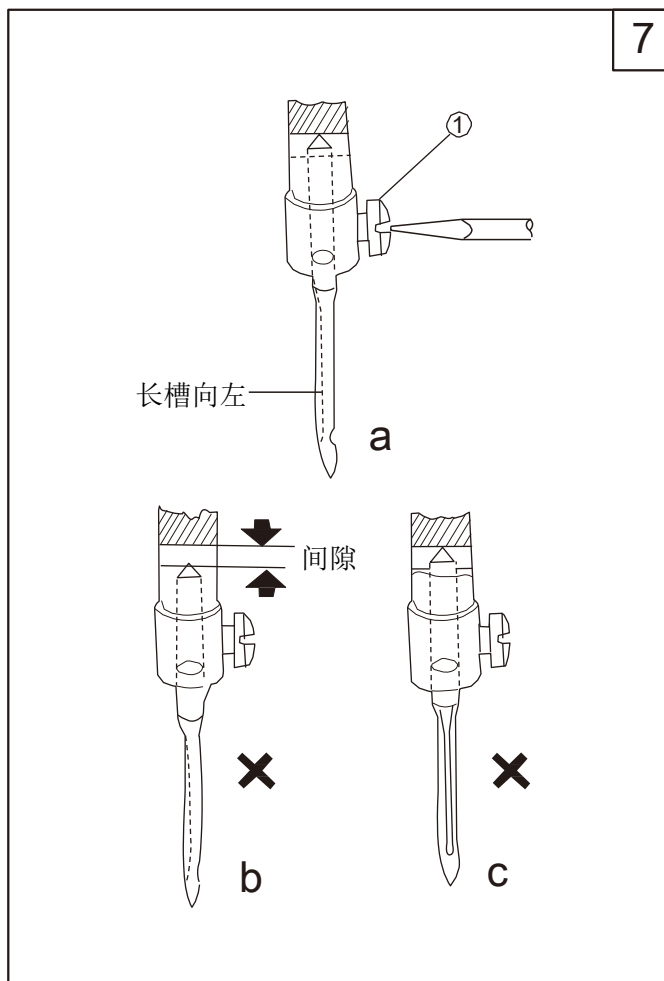
## 7.安装机针（图 7） / Installing the needle（Fig 7）

转动上轮，使机针上升到最高位置，旋松夹针螺钉。将机针的长槽朝向操作者的左面，然后把针柄插入针杆下部的针孔内，使其碰到针杆孔的底部为止，再旋紧夹针螺钉 1 固定机针即可。

注意：如图（b）所示，机针没有碰到针杆孔的底部。如图（c）所示针槽方向面对操作者，都是错误的。

Turn the upper wheel to raise the needle to the highest position and loosen the needle clamping screw. Point the long groove of the needle toward the left of the operator, and then insert the needle handle into the needle hole at the bottom of the needle bar until it touches the bottom of the needle bar hole, and then tighten the needle clamp screw 1 to fix the needle.

Note: As shown in figure (b), the needle does not touch the bottom of the needle bar hole. As shown in figure (c), the direction of the needle groove facing the operator is wrong



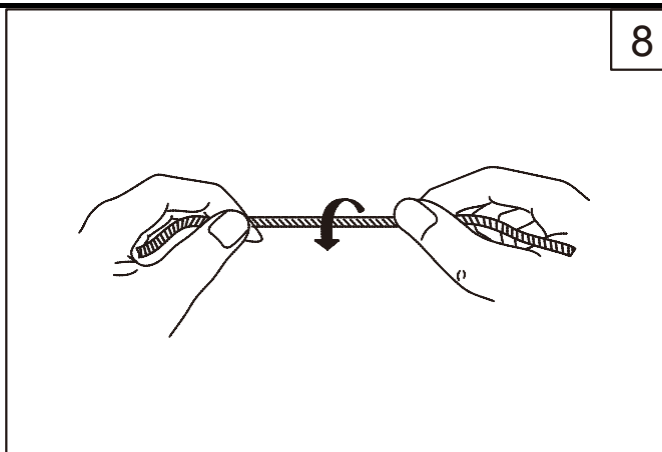
## 8.机针、缝线和缝料的配合（图8） / Matching of needle, suture and sewing material（Fig 8）

面线采用左捻线，底线则左、右捻均可使用，缝线捻向的鉴别，可按图十所示把缝线捏住，以右手按图箭头方向搓转缝线，若线股越搓越紧，则是左捻线，反之即为右捻线。

请使用 DP×17 型或 135×17 型机针，机针的粗细应适合缝料的性质。如用过细的机针缝制紧厚的织物，机针就容易折断，也会引起跳针、断线等现象。相反如果用过粗的机针缝制紧密的织物，则会因针孔太大而损坏织物。所以应根据缝料性质不同，机针和缝线的粗细都要适当地进行选择。

The upper thread is left-twisted, and the bottom thread can be twisted left or right. To identify the twisting direction of the suture, you can pinch the suture as shown in Figure 10 and twist the suture in the direction of the arrow with your right hand. The tighter the twist, the left twist, and the opposite is the right twist.

Please use DP×17 or 135×17 needles. The thickness of the needle should be suitable for the nature of the sewing material. If you use a needle that is too thin to sew tight and thick fabrics, the needle will easily break, and it will also cause skipped stitches and thread breakage. On the contrary, if a thick needle is used to sew tight fabrics, the fabric will be damaged due to too large needle holes. Therefore, the thickness of the needle and thread should be appropriately selected according to the nature of the sewing material.



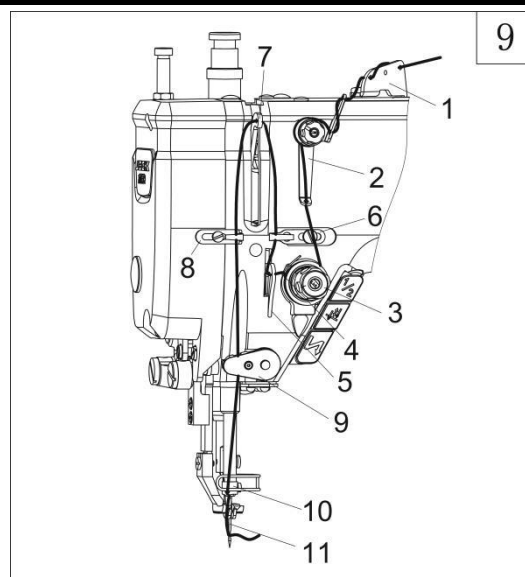
## 9.穿面线（图9） / Needle thread（Fig 9）

穿面线时针杆应在最高位置，然后将线架上引出线头按顺序穿线。

- （a）穿过上面三孔线勾1。
- （b）穿过机壳上部小夹线过线板2上的左过线孔，再通过小夹线板，然后穿过小夹线过线板2上的下过线孔。
- （c）在夹线座的夹线板3之间通过。
- （d）向上穿过挑线簧4，经过大线勾5和线勾6，向上从右向左穿过挑线杆7的穿线孔。
- （e）向下通过面板线勾8，电子夹线器9，及针杆过线环10，从左面穿过机针11的针孔，并引出100毫米左右的线备用。引底线时，先将面线头捏住，转动主动轮使针杆向下运动，再回升到最高位置，然后拉起捏住的面线线头，底线即被牵引上来，最后将底、面二根线头一起置于压脚下前方。

When threading the upper thread, the needle bar should be at the highest position, and then thread the thread ends on the

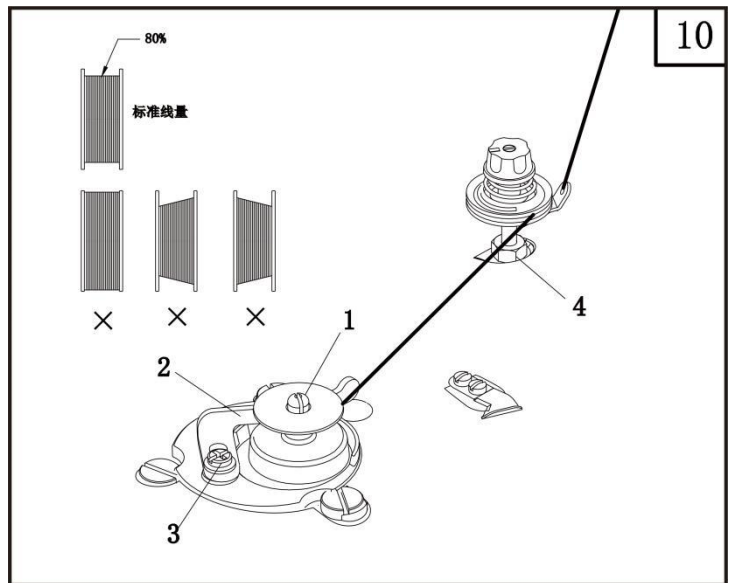
thread stand in order.(a) Pass through the upper three-hole hook ①.(b) Pass through the left thread hole on the small thread clamping plate ② on the upper part of the casing, then pass the small thread clamping plate, and then pass through the lower thread hole on the small thread clamping plate ②.(c) Pass between the thread tension plates ③ of the thread tension seat.(d) Pass the thread take-up spring ④ upwards, pass the large thread hook ⑤ and the thread hook ⑥, and pass the thread take-up lever ⑦ upwards from right to left. (e) Go down through the panel thread hook ⑧, lower thread hook ⑨, and needle bar thread passing ring ⑩, pass through the needle hole of the hole machine needle ⑪ from the left, and draw out a thread of about 100 mm for use. When drawing the lower thread, first pinch the upper thread end, turn the driving wheel to move the needle bar downward, and then return to the highest position, then pull up the pinched upper thread end, the lower thread is pulled up, and finally the bottom and upper thread .The thread ends are placed together in front of the presser foot.





## 10.绕线调节（图 10） /winding the bobbin thread (Fig 10)

- 1.打开电源。
  - 2.将梭芯插入绕线轴①的底部。
  - 3.根据箭头所示的方向，先将线在梭芯上绕几圈
  - 4.扳动绕线摆杆②。
  - 5.将压脚抬起来。
  - 6.踩下踏板，便开始自动绕底线了。
  - 7.当梭芯绕满后，绕线摆杆②便会自动复位。
- \*如果梭芯线排列不齐，可以通过松开过线架螺丝钉④及移动绕线摆杆②位置进行调节。
- \*绕线量由满线跳板上的满线度调节螺钉③加以调节。注意:适当的绕线量为平行绕线至梭芯外径的 80%。



1. Turn the power on;
  2. Place the bobbin onto the bobbin winder shaft 1;
  3. Wind the thread several circles around the bobbin in the direction indicated by arrow;
  4. Push down the bobbin presser arm 2;
  5. Lift the presser foot;
  6. Depress the treadle, the winding operation will start;
  7. Once finished, the bobbin presser arm 2 will recover automatically.
- \*If the thread winding is not neat and even, loosen the screw 4 to adjust the position of bobbin winder base.
- \*Turn the screw 3 to adjust the bobbin winding amount.

Tighten the screw to increase the winding amount.

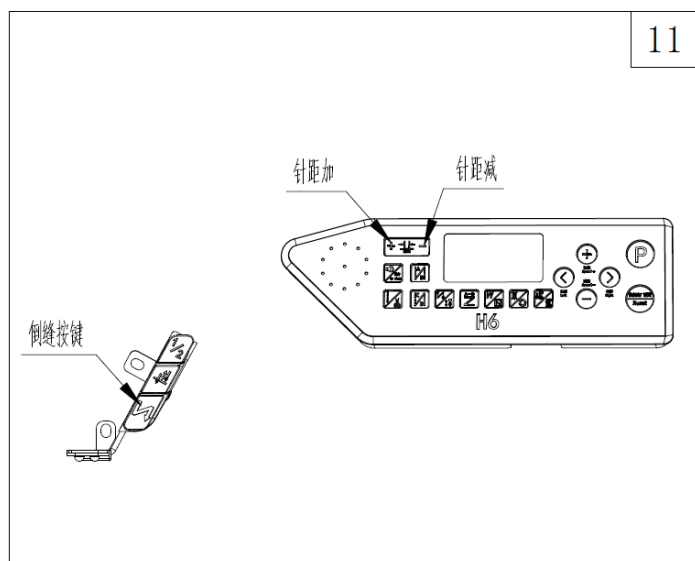
Loosen the screw to increase the winding amount;

Note: The proper winding amount should be around 80% of the bobbin capacity.

## 11.针距、倒顺送料（图 11） / Needle pitch, reverse feed (Fig 11)

针距的长短，可以通过操作面板针距按键来调节。按下“+”，针距增加；按下“-”，针距减少，针距大小精确到0.1mm。

需要倒向送料时，可以按压倒缝开关组件中的倒缝按键，进行倒缝；手放松后，恢复顺向送料。



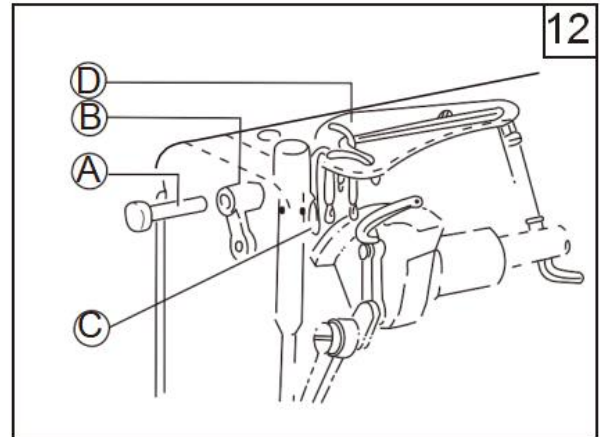
The length of needle distance can be adjusted by using the needle distance button of the operation panel to press "+" to increase the needle distance. Press "-", needle spacing is reduced, needle spacing size is accurate to 0.1 mm. When the material needs to be fed backwards, the inverted seam button in the pressing seam switch assembly can be pressed for inverted seam. After the hands are relaxed, the feeding is resumed.



## 12.挑线部位进油（图 12） / Oil in the thread take-up part（Fig 12）

挑线，针杆部位采用羊毛软线进油。长期使用后，如失去正常的进油作用，软（油）线被污染或硬化，就应更换新的羊毛软线，更换方法如下：

- 打开机头面板，卸下调压螺钉、调压螺钉锁紧螺母和压紧杆等。
- 再卸下挑线连杆铰链轴（A）和挑线连杆（B）。
- 拉出针杆上套筒的软油线（C）。
- 旋松机壳顶部（左方）上两只油线固定板螺钉，把油线固定板（D）从机头中取出。
- 重新换羊毛软线。
- 安装的过程是上述过程的相反。



The thread take-up and the needle bar are filled with wool soft thread. After long-term use, if the normal oil intake function is lost, the soft (oil) thread is contaminated or hardened, a new wool soft thread should be replaced. The replacement method is as follows:

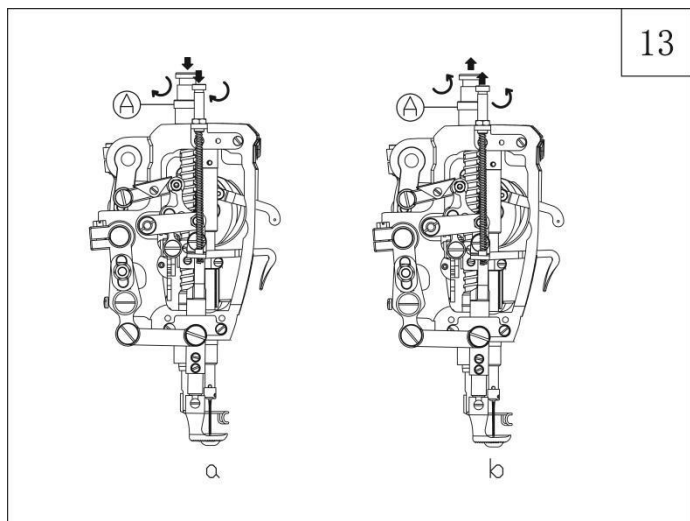
- Open the machine head panel, and remove the pressure regulating screw, pressure regulating screw lock nut and compression rod.
- Then remove the thread take-up link hinge shaft (A) and the thread take-up link (B).
- Pull out the soft oil line (C) of the upper sleeve of the needle bar.
- Loosen the two oil line fixing plate screws on the top (left) of the casing, and take the oil line fixing plate (D) out of the machine head.
- Change the wool cord again.
- The installation process is the opposite of the above process.

## 13.压脚压力调节（图 13） / ADJUST THE PRESSURE OF PRESSER FOOT（Fig 13）

压脚的压力，要根据缝料的厚度加以调节。首先旋松调压螺钉锁紧螺母(A)，缝厚料时，应加大压脚压力，这时将机头顶部的调压螺钉按图 a 所示箭头方向转动，反之，缝纫薄料时，可按图 b 所示的方向转动调压螺钉，以减少压脚的压力。最后旋紧调压螺钉锁紧螺母(A)即成。压脚的压力，应以能正常推送缝料为宜。

Pressure of presser foot is to be adjust in accordance with thickness of materials to be sewn. First loosen Lock Nut(A). For heavy materials,

turn the pressure regulating thumb screw as shown in Fig.3(a) to increase the pressure, while for light materials, turn the pressure regulating thumb screw as shown in Fig.3(b) to decrease the pressure. Then tighten Lock Nut(A). The pressure of presser foot is recommended to be less as long as normal feeding is ensured.



#### 14.缝线张力（图 14 15）/Suture tension（Fig 14 15）

缝线的张力要根据缝料的差别，缝线的粗细以及其他一些因素变动。

实际使用中，是根据缝纫出来的线迹，来调整底、面线的张力，使之得到正常的线迹。

底线张力调整，只要用小号螺钉起子旋转梭心套上梭皮螺钉（A）加大或减小底线压力即可。

一般来说，底线如果用 50# 涤纶线，梭心装入梭心套后，拉出缝线穿过梭心套线孔，捏住线头吊起梭心套，梭心套则能缓缓下落，就可以使用。

面线张力以底线张力为基础。面线张力调整，主要变换夹线组件中挑线簧张力，挑线簧摆动幅度，夹线簧张力及线勾的位置等。

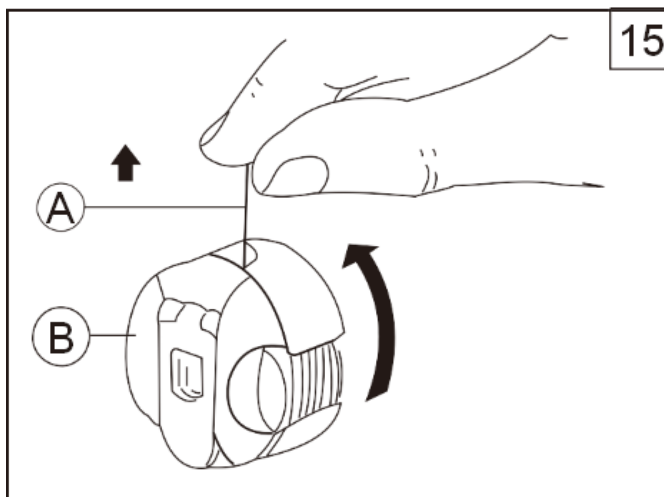
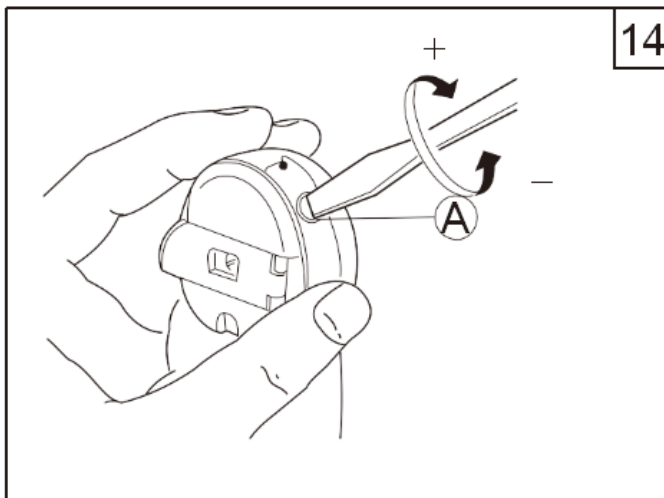
The tension of the suture varies according to the difference of the sewing material, the thickness of the suture and other factors.

In actual use, the tension of the bottom and upper threads is adjusted according to the stitches sewn out to obtain normal stitches.

To adjust the bobbin thread tension, just use a small screwdriver to turn the bobbin screw (A) on the bobbin case to increase or decrease the bobbin thread pressure.

Generally speaking, if 50# polyester thread is used for the bottom thread, after the bobbin is loaded into the bobbin case, pull out the suture through the bobbin case thread hole, Pinch the end of the thread and lift the bobbin case, the bobbin case can fall slowly, You can use it.

The upper thread tension is based on the lower thread tension. The upper thread tension adjustment mainly changes the tension of the thread take-up spring in the thread tension assembly, the swing amplitude of the thread take-up spring, the tension of the thread tension spring and the position of the thread hook.



## 15.挑线簧调节（图 16、17） / Thread take-up spring adjustment (Fig 16 17)

挑线簧摆动幅度为 5~8 毫米。缝纫簿的缝料（短针距）则要减弱挑线簧的张力放宽摆动幅度，缝制特别厚的缝料则反之。

### 1、挑线簧张力调节

先旋松夹线调节座螺钉（A），夹线螺钉（B）就能转动，顺时针转动时张力增加，反之则减少，调节好后，仍将夹线调节座螺钉（A）旋紧。

控制方法：

松开夹线调节座螺钉（A），将夹线螺钉（B），逆时针转动，使挑线簧 C 的张力压缩到 0，再把夹线螺钉（B）顺时针转动，至挑线簧（C）触及夹线调节止动缺口，然后，夹线螺钉（B）再逆时针回转二分之一转动角度即可，最后旋紧夹线调节螺钉座（A）。

2、挑线簧摆动幅度的调节旋松夹线调节座固定螺钉（B），转动夹线器（C），调节其摆动幅度，夹线器（C）顺时针转动，摆动幅度增大，反之则减少。通常，机器在出厂前，挑线簧均已调整妥善，只是在缝纫特殊的缝料或特殊的缝线时，才需要重新进行调整。

The swing amplitude of the thread take-up spring is 5-8 mm. Sewing material for sewing book (short needle Width), the tension of the thread take-up spring should be weakened to relax the swing range, and the reverse is the case when sewing particularly thick sewing materials.

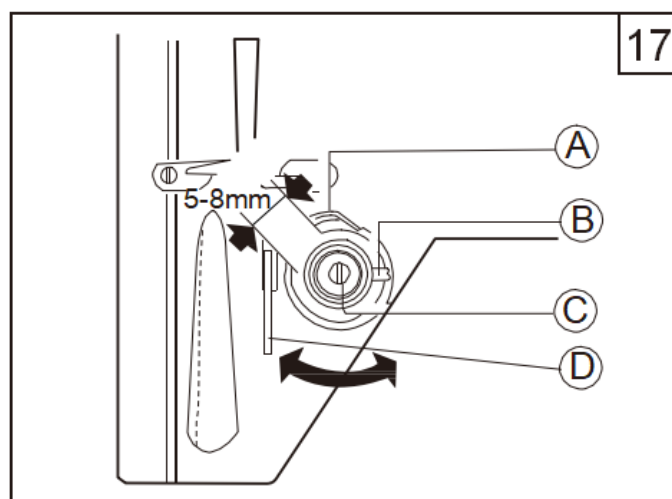
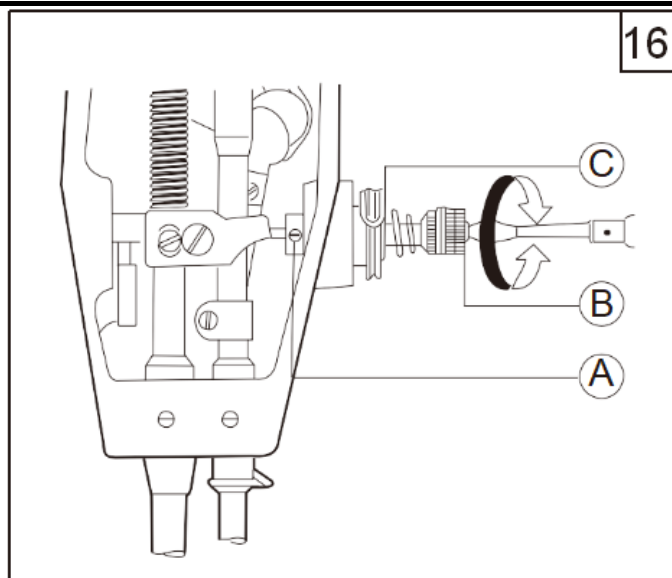
### 1. Thread take-up spring tension adjustment

First loosen the thread tension adjusting seat screw (A), the thread tension screw (B) can be turned, the tension will increase when turned clockwise, and vice versa, the tension will decrease. After adjustment, still tighten the thread tension adjusting seat screw (A).

Control Method:

Loosen the thread tension adjusting seat screw (A), turn the thread tension screw (B) counterclockwise to compress the tension of the thread take-up spring C to 0, and then turn the thread tension screw (B) clockwise to the thread take-up spring (C) Touch the notch of the thread tension adjustment stop, then, turn the thread tension screw (B) counterclockwise by half the angle of rotation, and finally tighten the thread tension adjustment screw seat (A).

2. Adjustment of the swing amplitude of the thread take-up spring. Loosen the fixing screw (B) of the thread clamp adjusting seat, turn the thread clamp (C) to adjust its swing range, turn the thread clamp (C) clockwise, the swing amplitude increases, and vice versa. Usually, the thread take-up spring has been adjusted properly before the machine leaves the factory. It is only necessary to readjust it when sewing special sewing materials or special sewing threads.



## 16.底面线张力调节（图 18、19、20） / Bottom thread tension adjustment（Fig 18 19 20）

线勾装配位置的调节，关系到缝纫质量的优劣。线勾装配位置，应适合缝料与缝纫条件。

线 勾 位 置	左 侧	中 间	右 侧
			
缝 料	厚 料	中厚料	薄 料




缝纫机的正常线迹应该如图a，如果线迹不正常，会出现缝料起皱和断线现象，应对底、面线的张力加以调节。使之达到正常的线迹。

a、如果面线太紧，底线太松，则应逆时针旋转夹线螺母，放松面线的压力。或用小号螺钉起子旋紧梭皮螺钉，加大底线的压力。

b. 如果面线太松，底线太紧，则应顺时针旋转夹线螺母，以加大面线的压力或用小号螺钉起子，旋松梭皮螺钉，减少底线的压力。

c. 如出现图 d、e 的线迹，也可以参照上述方法加以调节。

The adjustment of the assembly position of the thread hook is related to the quality of sewing. The hook assembly position should be suitable for sewing material and sewing conditions.

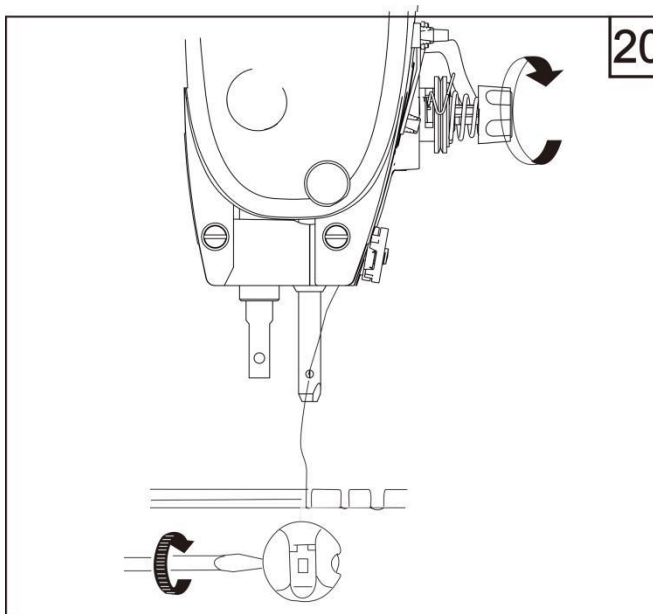
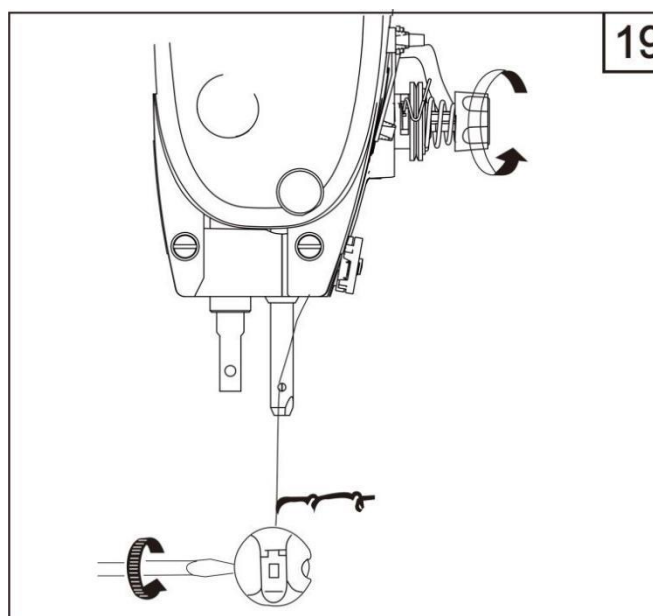
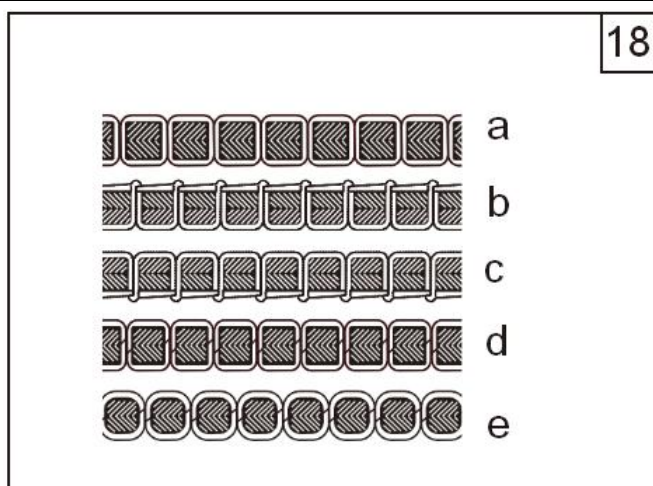
Wire hook position	Left	middle	right
			
Sewing material	Thick material	Medium thickness material	thin material

The normal stitches of the sewing machine should be as shown in Figure a. If the stitches are abnormal, the sewing material will wrinkle and thread breakage. The tension of the bottom and upper threads should be adjusted. Make it reach the normal stitch.

a. If the upper thread is too tight and the bottom thread is too loose, turn the thread clamping nut counterclockwise to relax the pressure on the upper thread. Or use a small screwdriver to tighten the bobbin screw to increase the pressure on the bottom thread.

b. If the upper thread is too loose and the bottom thread is too tight, turn the thread tension nut clockwise to increase the pressure on the upper thread or use a small screwdriver to loosen the bobbin screw to reduce the pressure on the bottom thread.

c. If the traces in Figure d and e appear, you can also adjust them by referring to the above method.



## 17.机针与旋梭同步调整（图 21.22.23.24） / Synchronous adjustment of needle and rotary hook (Fig 21 22 23 24)

### 1、机针位置的调节

用手转动主动轮，使针杆（C）下降至最低位置，卸下面板（A）上的橡皮塞，旋松针杆（C）上的针杆接头螺钉（B），上下移动针杆（C），初步定出同步位置（针杆的同步位置，当针杆下降至最低位置时，机针线孔的中心（D）应与旋梭内周面（E）在同一位置上。如图24所示位置）。旋紧针杆接头螺钉（B），塞上橡皮塞即成。

### 2、旋梭同步的调节

旋梭和机针之间的相互运动关系，对缝纫性能的影响很大。标准的同步关系是：用手转动上轮，使机针向下运动到最低位置后再向上回升2.2毫米，这时旋梭钩线尖(D)，应与机针的中心线（C）一致，在此位置时，钩线（D）应高于机针线孔（E）上边约1.2毫米。

在调节旋梭的同步关系时，还要注意到旋梭尖与机针的侧面间隙。机针（D）缺口，底部与旋梭钩线尖（C）的间隙为0.05毫米

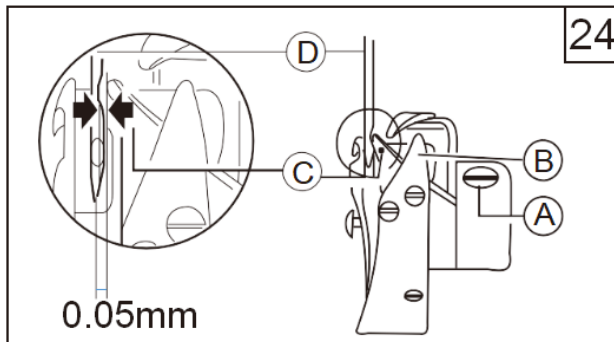
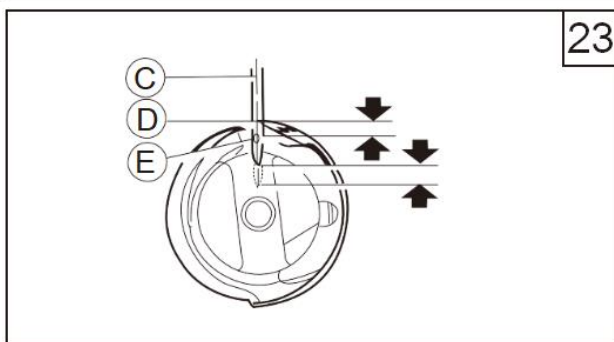
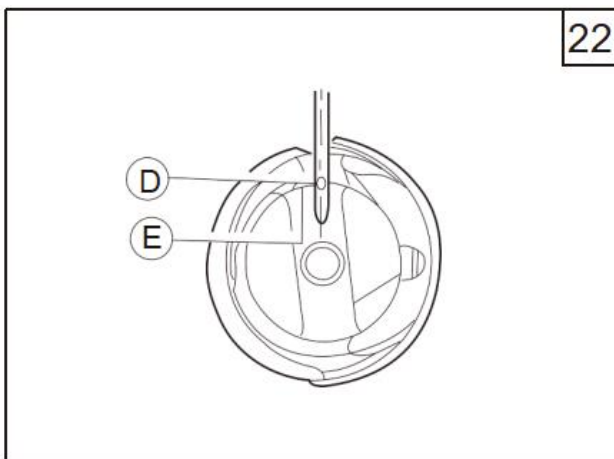
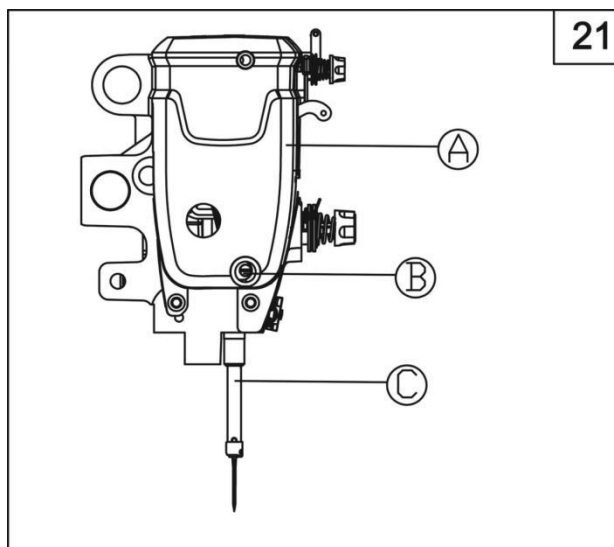
#### 1. Adjustment of needle position

Turn the driving wheel by hand to lower the needle bar (C) to the lowest position, remove the rubber plug on the panel (A), loosen the needle bar connector screw (B) on the needle bar (C), and move the needle bar (C) up and down. The synchronization position is initially determined (the synchronization position of the needle bar. When the needle bar is lowered to the lowest position, the center (D) of the needle thread hole should be at the same position as the inner circumference (E) of the hook. As shown in Figure 24 Show location). Tighten the needle bar connector screw (B), and plug the rubber stopper.

#### 2. Adjustment of the hook synchronization:

The mutual movement relationship between the hook and the needle has a great influence on the sewing performance. The standard synchronization relationship is: turn the upper wheel by hand to make the needle move down to the lowest position and then rise back up by 2.2 mm. At this time, the hook thread tip (D) should be consistent with the needle center line (C). At this position, the hook thread (D) should be about 1.2 mm higher than the upper edge of the needle thread hole (E).

When adjusting the synchronization relationship of the rotary hook, also pay attention to the side clearance between the tip of the rotary hook and the needle. The needle (D) notch, the clearance between the bottom and the hook thread tip (C) is 0.05 mm.





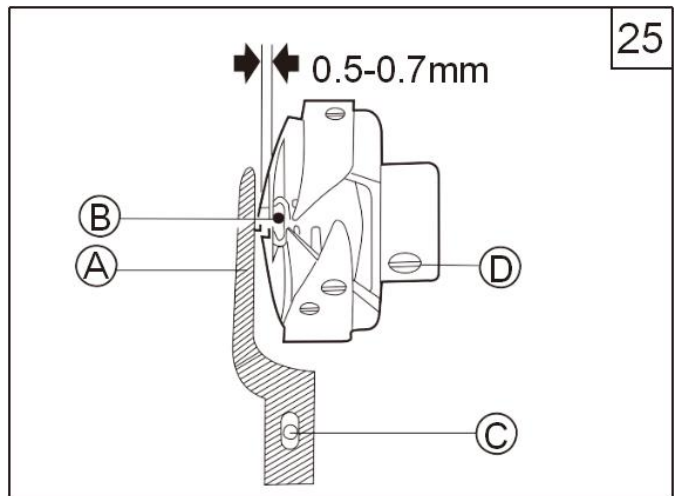
## 18.旋梭装卸（图 25） / Hook loading and unloading（Fig 25）

先将针杆上升到最高位置，拆下针板，取下机针和梭心套。旋下定位勾螺钉（C），把旋梭定位勾（A）取下。再旋松旋梭螺钉（D）。使旋梭在它的转动轴上能够自由转动，接着用手转动上轮，使送料牙架走向高处。到此，可以用手去旋转旋梭，使它让过牙架徐徐取出。安装旋梭过程是上述过程的回复。

旋梭定位勾的安装位置应是旋梭定位勾（A）的勾尖侧面与机针（B）的侧面应成一致。另外其两侧面之间隙为0.5~0.7毫米。

First raise the needle bar to the highest position, remove the needle plate, and remove the needle and bobbin case. Unscrew the positioning hook screw (C), and take off the hook positioning hook (A). Loosen the hook screw (D) again. Make the rotary hook rotate freely on its rotating shaft, and then turn the upper wheel by hand to make the feeding frame move to a high place. At this point, you can rotate the hook by hand to make it slowly take out the tooth frame. The hook installation process is a response to the above process.

The installation position of the hook positioning hook should be such that the side of the hook tip of the hook positioning hook (A) and the side of the needle (B) should be consistent. In addition, the gap between the two sides is 0.5 to 0.7 mm.



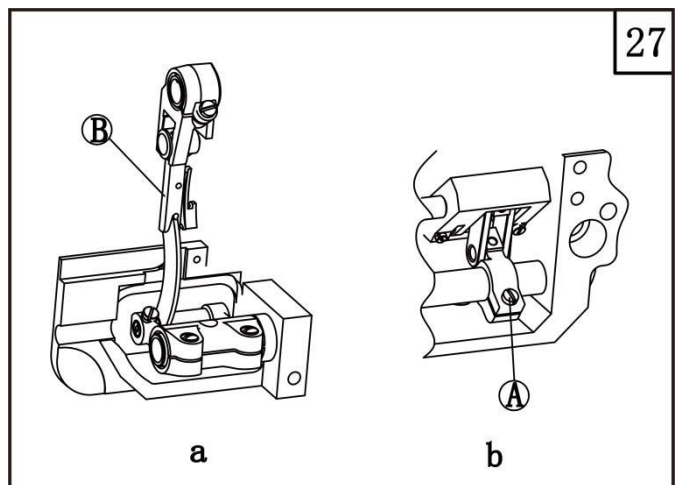
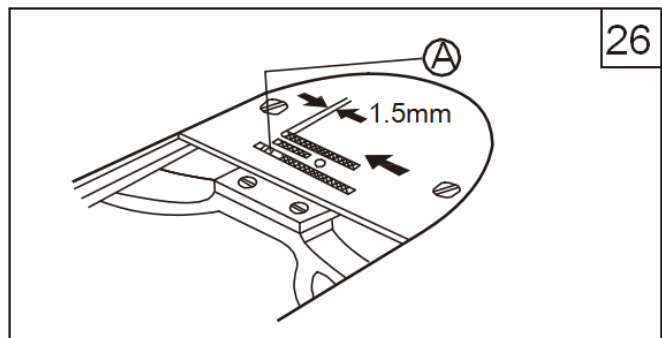
## 19.送布牙安装（图 26、27） / Feed dog installation（图 26 27）

a. 当送布量最大，送布牙（A）前端靠近针板槽前侧时，送布牙前端与针板槽前侧的间距为1.5毫米，这是标准的送布牙安装位置。

b. 调节送布牙位置时，先让送布牙运动至针板最前侧停止，然后旋松送布轴曲柄螺钉（A）（见27b），将牙架（B）按图27a所示箭头方向移动，以调节位置，调节好后，再把螺钉（A）旋紧。

a. When the feed amount is the largest and the front end of the feed dog (A) is close to the front side of the needle plate groove, the distance between the front end of the feed dog and the front side of the needle plate groove is 1.5 mm. This is the standard feed dog installation position.

b. When adjusting the position of the feed dog, first let the feed dog move to the front side of the needle plate and stop, then loosen the feed shaft crank screw (A) (see Figure 29b), and set the bracket (B) as shown in Figure 29a. Move in the direction of the arrow to adjust the position. After adjustment, tighten the screw (A).



## 20.送布牙平面调节（图 28） / Feeding tooth plane adjustment（Fig 28）

送布牙一般是水平位置。高于针板平面 0.8~1.2毫米。当缝制条件需倾斜时应调节。

- 旋松牙架曲柄轴螺钉（A）。
- 用螺钉起子压在牙架曲柄偏心轴的槽里，使偏心轴左右转动。
- 最后将（A）螺钉拧紧。

送布牙前面高时，可防止布料起缩，不容易出现空针。

送布牙前面低时，可防止布料跑偏，底线不易断

The feed dog is generally horizontal. 0.8~1.2mm above the plane of the needle board. It should be adjusted when the sewing conditions need to be inclined.

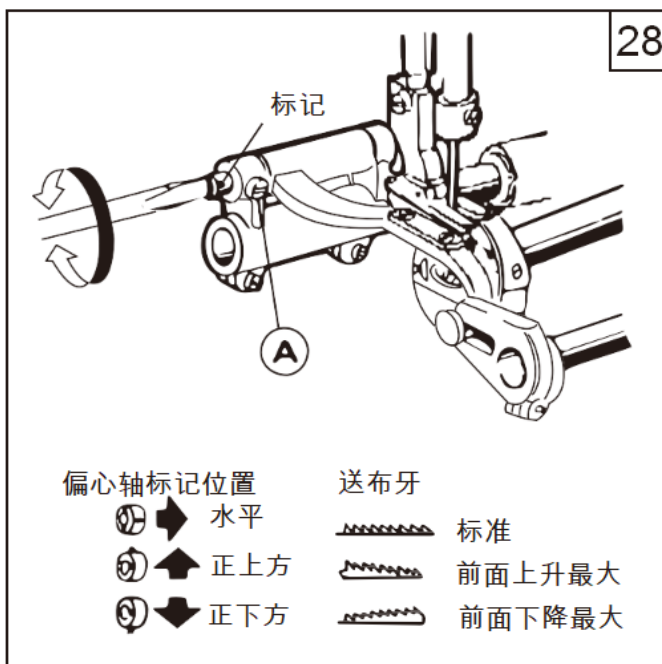
a. Loosen the crankshaft screw (A) of the tooth frame.

b. Use a screwdriver to press in the groove of the eccentric shaft of the bracket crank to make the eccentric shaft rotate left and right.

c. Finally tighten the (A) screw.

When the front of the feed dog is high, the fabric can be prevented from shrinking and shrinking, and empty stitches are not easy to appear.

When the front of the feed dog is low, the fabric can be prevented from running off and the bottom thread is not easy to break.



## 21.针距误差调节 / Synchronous feeding adjustment

在空闲模式下，长按  $\textcircled{P}$ +针距加进入正缝参数修改界面，长按  $\textcircled{P}$ +针距减进入倒缝参数修改界面。在参数修改界面短按  $\textcircled{<}$  或  $\textcircled{>}$  键切换修改的参数位，按  $\textcircled{+}$  或  $\textcircled{-}$  键修改针距补偿参数大小，修改后短按  $\textcircled{P}$  键保存针距补偿比例，面板显示 ok 表示参数设置成功，短按  $\textcircled{P}$  键退出当前界面。

In idle mode, long press  $\textcircled{P}$  + stitch length plus to enter the forward sewing parameter modification interface, and long press  $\textcircled{P}$  + stitch length minus to enter the reverse stitch parameter modification interface. In the parameter modification interface, short press the  $\textcircled{<}$  or  $\textcircled{>}$  key to switch the modified parameter position, press the  $\textcircled{+}$  or  $\textcircled{-}$  key to modify the stitch length compensation parameter size, short press the  $\textcircled{P}$  key to save the stitch length compensation ratio after modification, the panel displays ok to indicate that the parameter setting is successful, short press the  $\textcircled{P}$  key to exit the current interface.



## 22.送布同步调节（图 30,31,32） / Synchronous feeding adjustment（Fig 30 31 32）

### 1、标准位置

转动上轮，降低送布牙（A），当和针板表面（B）相平时，机针（C）的针尖应与针板、送布牙表面同在一水平面上。

调整可以通过调节送布凸轮和抬牙凸轮的安装位置进行。

### 2、抬牙凸轮的安装

打开后盖板，卸下挡油板，用左手逆时针转动上轮，油孔对上上轴齿轮第二只固定螺钉

（A），以上轴齿轮第二只固定螺钉（A）为基准，抬牙凸轮的第二只固定螺钉（B）中心，将对齐（A）中心，稍微向下偏一点。

### 3、送布凸轮的安装

继续逆时针转动上轮，以抬牙凸轮第二只紧固螺钉（B）为基准，进布凸轮的第三只紧固螺钉（C）中心，将对齐（B）中心，稍微向上偏一点（如将两螺孔缺口标记对成一直线亦可）。

#### 1. Standard position

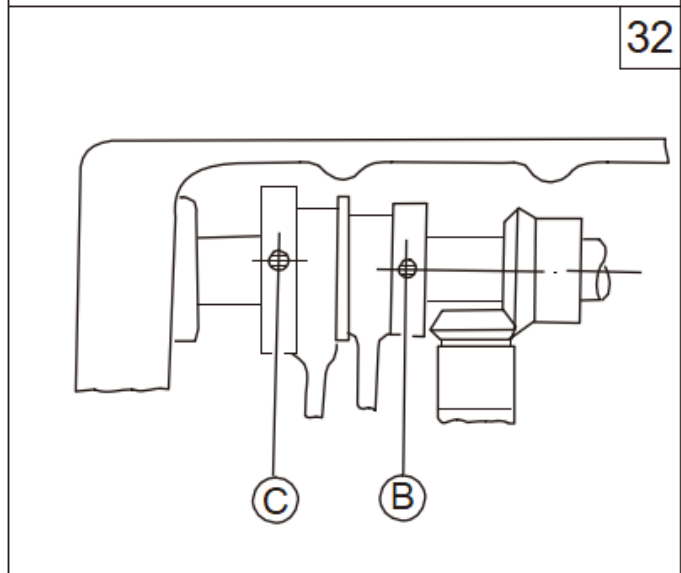
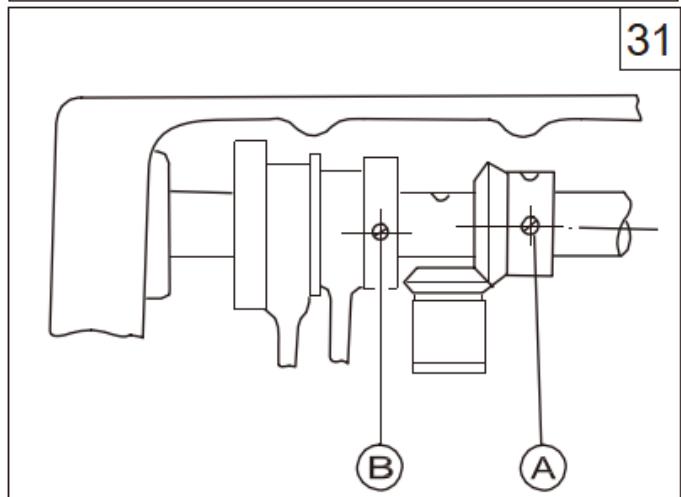
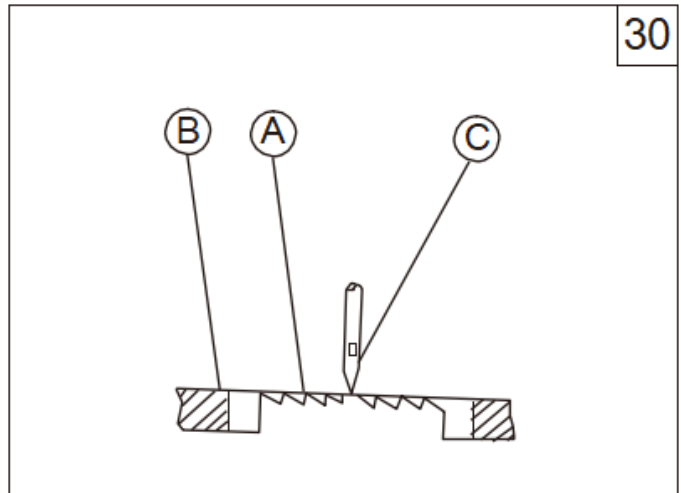
Turn the upper wheel to lower the feed dog (A). When it is level with the needle plate surface (B), the needle point of the needle (C) should be on the same level as the needle plate and the surface of the feed dog. The adjustment can be carried out by adjusting the installation positions of the cloth feeding cam and the lifting cam.

#### 2. Installation of the lifting cam

Open the rear cover, remove the oil baffle, turn the upper wheel counterclockwise with your left hand, use the second fixing screw (A) of the upper shaft gear as the reference, and the center of the second fixing screw (B) of the lifting cam will be aligned (A) The center, slightly lower.

#### 3. Installation of feeding cam

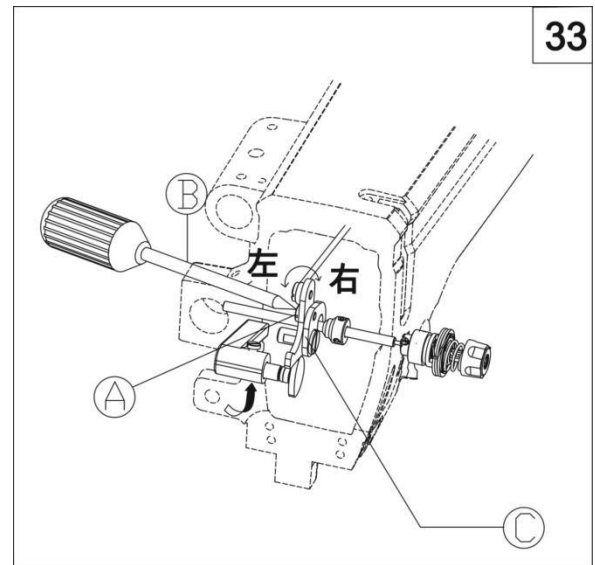
Continue to turn the upper wheel counterclockwise, and take the second fastening screw (B) of the lifting cam as the reference, and lay the center of the third fastening screw (C) of the cam, which will be aligned with the center of (B), slightly upward ( If the marks of the two screw holes are aligned in a straight line)



### 23.松线器挺线调节（图 33） / Adjust opening time of the tension discs（Fig 33）

压脚在提升范围内，夹线器上的夹线板有一个张开期，挺线的时间可进行调节。调节时，先卸下机头背面的橡皮擦，用螺丝刀（B）旋松膝控提升杠杆（左）螺钉（A），这时松线板（C）可以左右转动，往右移挺线慢，往左移挺线快。

The tension discs should be pushed apart to open when the presser foot is lifted. But the open timing of the tension discs can be adjusted as follows: Remove face plate and the rubber plug at rear side of arm and loosen screw (A) of the knee lifting lever (left), then the tension releasing cam can be moved leftward or rightward when the cam is moved right-ward. It is later to open, otherwise it is earlier to open.



### 24.上送料机构的调节（图 34） / Adjusting the tension releasing mechanism（Fig 34）

上、下同步送料是该产品的重要性能之一。在缝纫过程中，应根据各种缝料的摩擦系数的不同和缝纫工艺的不同要求，对上送料机构的摆压脚滑块与摆压脚轴的中心距（L）进行调节。

调节方法：

增大中心距 L——上送料量增大。

减小中心距 L——上送料量减少。

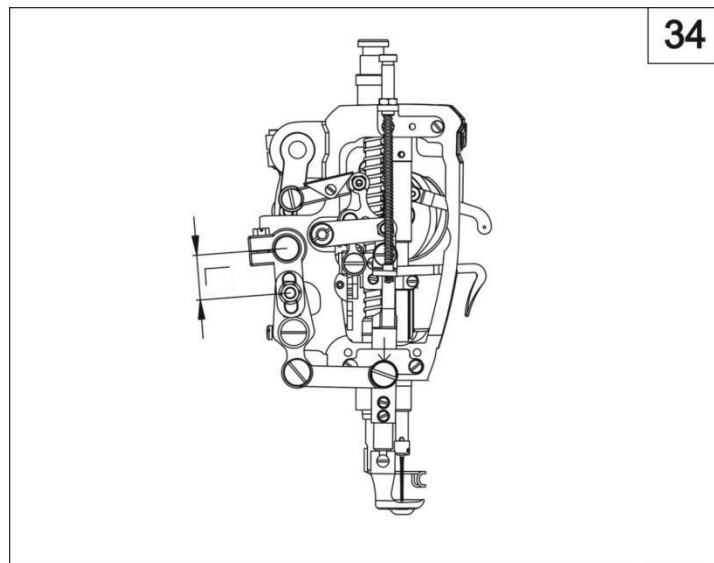
对于某些制品的特殊缝纫要求，如缝件的上层的送料量要求大于（或小于）下层的送料，也可以根据以上原理在一定范围内调节使用。

During the sewing, the center gauge (L) between the walking foot sliding block and its shaft can be adjusted according to the differences of the friction coefficients of the friction coefficients of materials and the sewing process.

Method: Increase L -- the upper feed amount enlarged

Reduce L -- the upper feed amount shorten

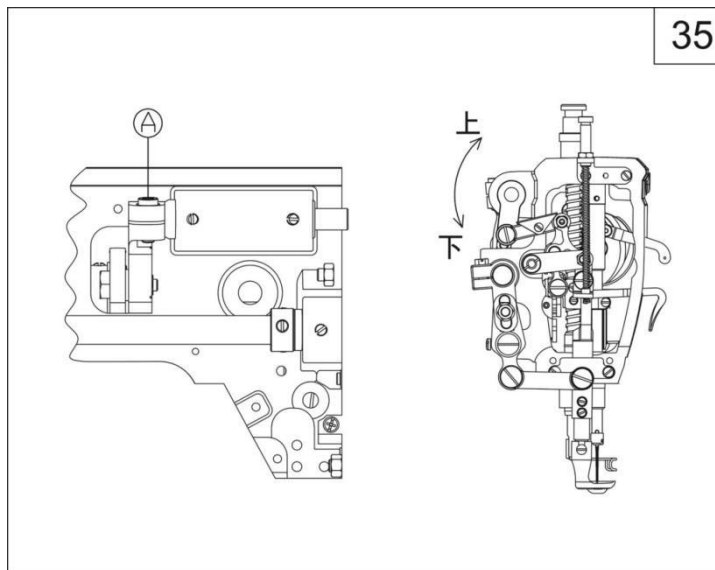
For special sewing requirements, for example, the upper layer of material needs more amount than the lower layer does, in this case, adjustment can be done in the range of above theory for operation.



## 25.压脚交叉提升机构的调节（图 35）/Adjusting presser foot alternate lift mechanism (Fig35)

根据缝料疏松和结实程度的不同，在缝纫中，对摆压脚、小压脚的交叉提升量，可在一定的范围内进行适当的调节。在一般的中厚料缝纫中，摆压脚提升量为 5.5mm 之内，小压脚提升时为 3.5mm 左右。当其他机构不变的情况下，两压脚提升量之和基本上是一定值。两提升量的变化近似于按反比定律变化。即：摆压脚的提升量增加，则小压脚的提升量就减少。反之亦然。

调节方法：旋松偏心轮连杆调节曲柄螺钉 A，按图示向上转动压脚升降前曲柄，摆压脚的提升量增大，反之，向下转动，小压脚的提升量减少。但其调节量有一定的范围，不宜过大。调好后，将螺钉拧紧，用手转动上轮，检查一切正常后方可使用。

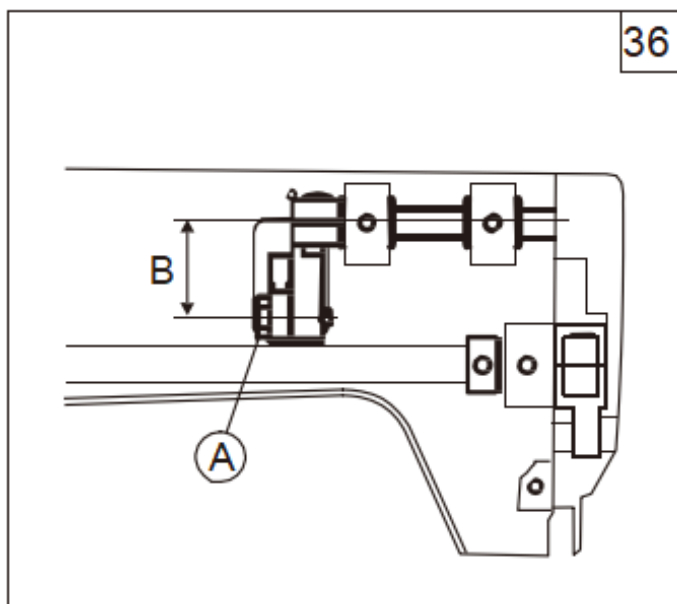


During the sewing, the alternate lift amount can be adjusted according to the nature of material. In general sewing, the amount of walking foot is 5.5mm, and the presser foot lift amount is 3.5mm.

Method: loosen the screw A, turn presser foot front crank up ward to increase the amount of walking foot. Turn it downward to reduce the presser foot amount, the range of adjusting amount is not too

## 26.摆压脚、小压脚总提升量的调节（图 36）/Adjusting the lift amount of presser foot together with walking foot (Fig36)

在缝纫过程中，要改变摆压脚、小压脚的总提升量，其调节方法是：先将偏心轮连杆螺钉（A）旋松，然后调节该螺钉与压脚升降轴中心距 B；如果使摆压脚、小压脚的总提升量都增加，则使中心距 B 调小；反之，则可使总提升量都减少。其调节量也有一定的范围，调节幅度不宜过大，调节好后，将螺钉拧紧，慢慢转动上轮，检查有无碰撞现象，一切正常后方可使用。

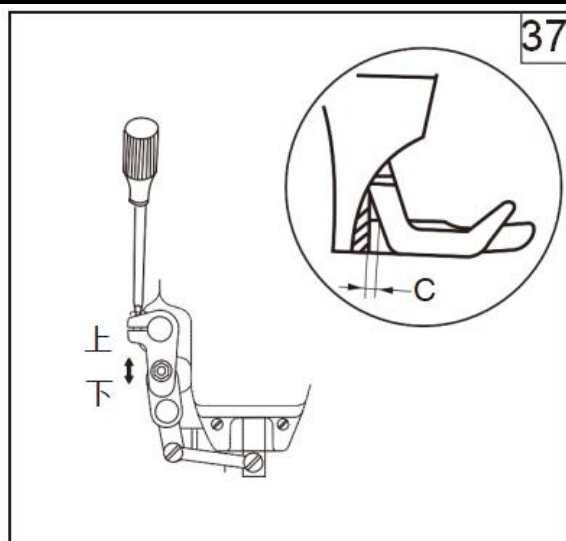


The lift amount of walking presser foot together with presser foot can also be adjusted slightly. When adjusting, loosen screw (A) adjust its center distance B between the screw (A) and the presser foot lift shaft. The lift amount is increased as to shorten the center distance B, and the lift amount is decreased as to widen the center distance B. After adjustment, tighten the nut again.

## 27.摆压脚、压脚前后方向间隙的调节 (图 37) / Adjusting the clearance between presser foot and walking foot (Fig 37)

在缝纫过程中,有时用大针距缝纫,有时用小针距缝纫,在大针距缝纫时,摆压脚前后的行程比较大。反之,就小了。为了在缝纫过程中,使摆压脚槽的前端与小压脚后端面不碰撞,且保证有一定的间隙 C (一般取 1.5mm 左右)。故在小针距缝纫时,需要摆压脚向针杆靠拢点,调节方法:首先旋松摆压脚前曲柄螺钉,然后向上转动压脚摆动轴,则摆压脚就向针杆靠拢,调节时,应该注意间隙 C 的定值要求。

In sewing operation, for preventing the walking foot from striking on presser foot a proper clearance C of approx. 1.5mm should be maintained between them. When the clearance is too small or too big, necessary to adjust, loosen rear crank screw and turn the rock shaft, then the walking foot moves near the needle bar. When adjust, be sure to note the fixed number of the clearance C.



## 28.定期清扫 (图 38,39,40) / Clean regularly (Fig 38 39 40)

请根据使用程度,定期进行清扫送布牙、旋梭、梭心套和油泵滤网等。

### 1、送布牙的清扫

先卸下针板,清除送布牙 (A) 间距 (牙槽) 内的尘垢,然后再安好针板。

### 2、旋梭的清扫

清除旋梭 (A) 周围的尘垢,如图所示,同时用软布拭擦梭心套。

### 3、油泵滤网的清扫

如图所示,清除滤网 (A) 上的尘屑。

Please regularly clean the feed dog, rotary hook, bobbin case and oil pump filter according to the degree of use.

#### 1. Cleaning the feeding teeth

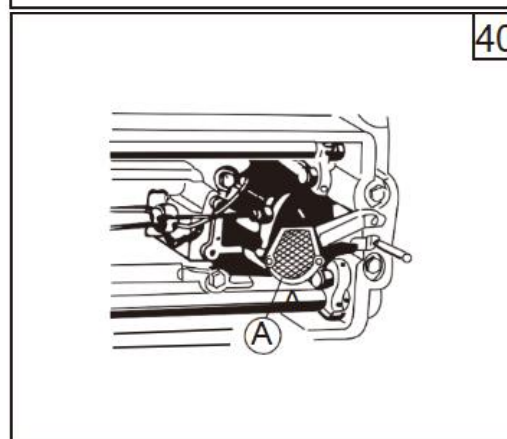
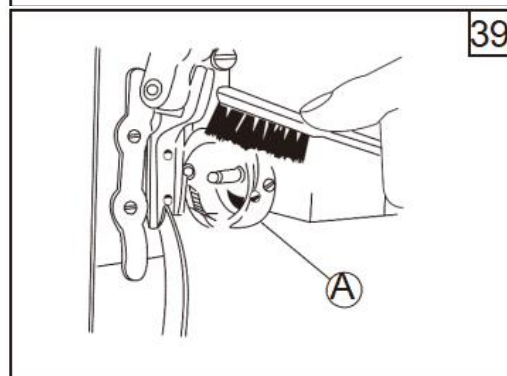
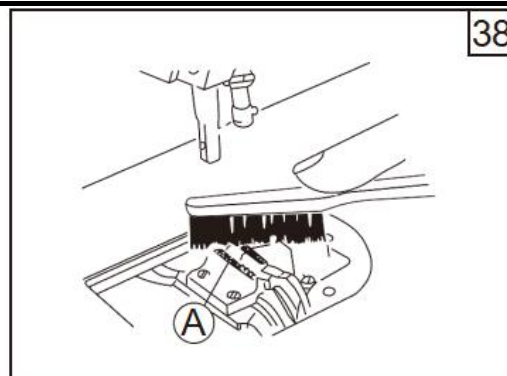
Remove the needle plate first, remove the dust and dirt in the gap (teeth) of the feed dog (A), and then install the needle plate.

#### 2. Cleaning the hook

Clean the dust around the hook (A), as shown in the figure, and wipe the bobbin case with a soft cloth.

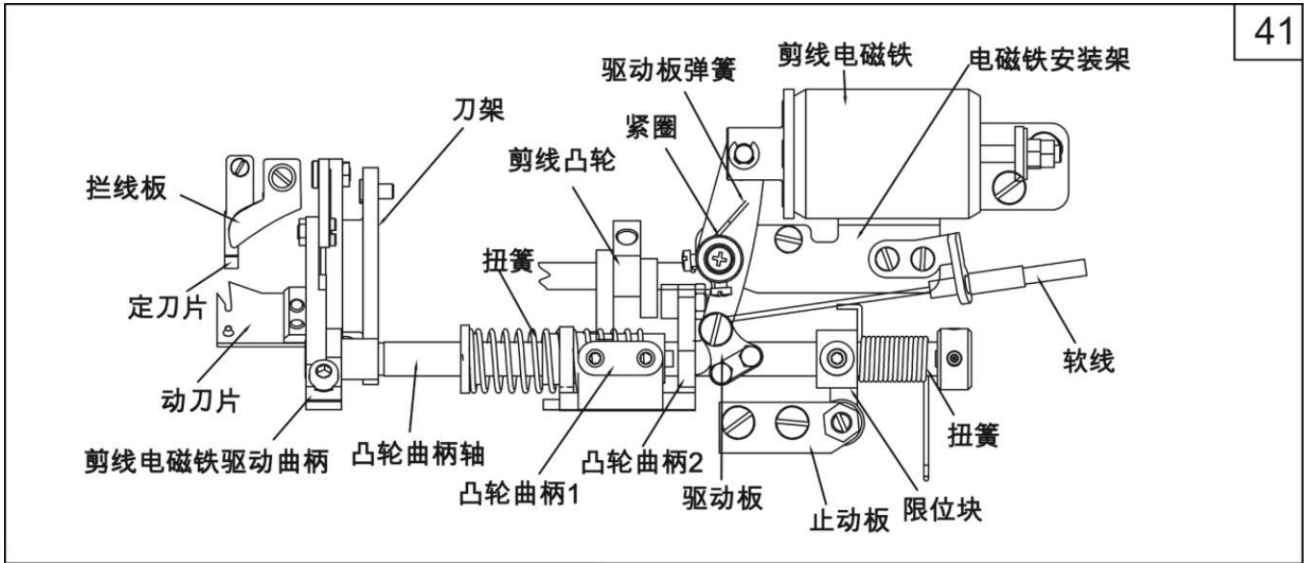
#### 3. Cleaning the oil pump filter

As shown in the figure, remove the dust on the filter (A).



## 29.剪线装置的调整（图 41,42,43,44,45）/Adjustment of thread trimmer（Fig 41 42 43 44 45）

### 1.剪线装置（结构见图 41）/Thread trimmer (See structure on chart structure on chart 41)

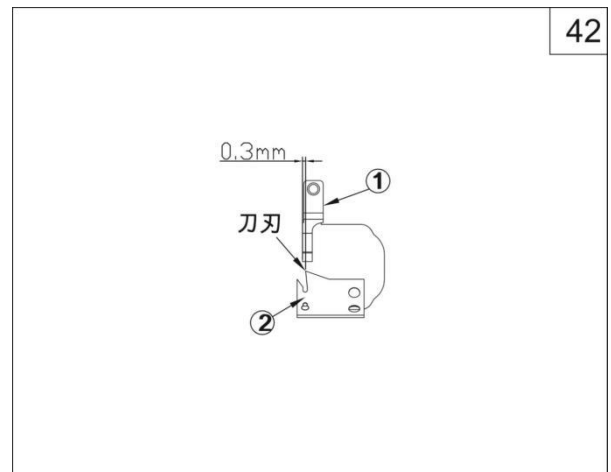


### 2.定刀片与动刀片的关系：（见图 42）

定刀片 1 与动刀片 2 的位置应保证 0.3mm。

### 2. Relation of counter knife and moving knife (see chart 42)

The position of counter knife ① and moving knife ② should keep the distance of 0.3mm.

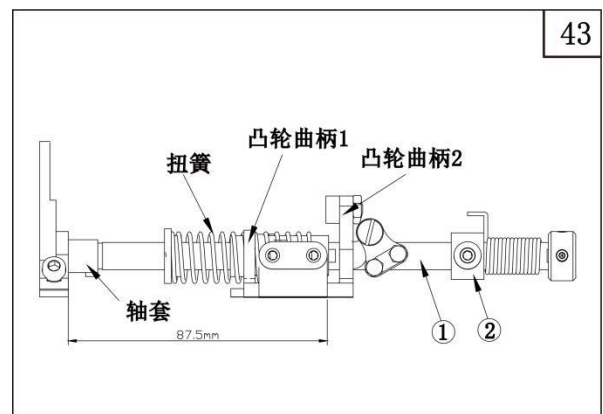


### 3.凸轮曲柄轴（见图 43）

- (1)装配时，将凸轮曲柄 1 最先安装在底板上。
- (2)凸轮曲柄 1 必须如图所示安装，固定在凸轮曲柄轴 1 上的平面处。
- (3)轻轻转动凸轮曲柄轴 1，将限位块 2 安装在凸轮曲柄轴 1 上的平面处。

### 3.Thread shear rock arm shaft (see chart 43)

- (1)When assembling, install thread shear rock arm shaft ① on the baseplate first of all.
- (2)Install thread shear rock arm shaft ① according to chart 12 and fasten on the plane place of thread shear rock arm shaft ①.
- (3)Turn lightly thread shear rock arm shaft ① and install stop block onto the plane place of thread shear rock arm shaft ①



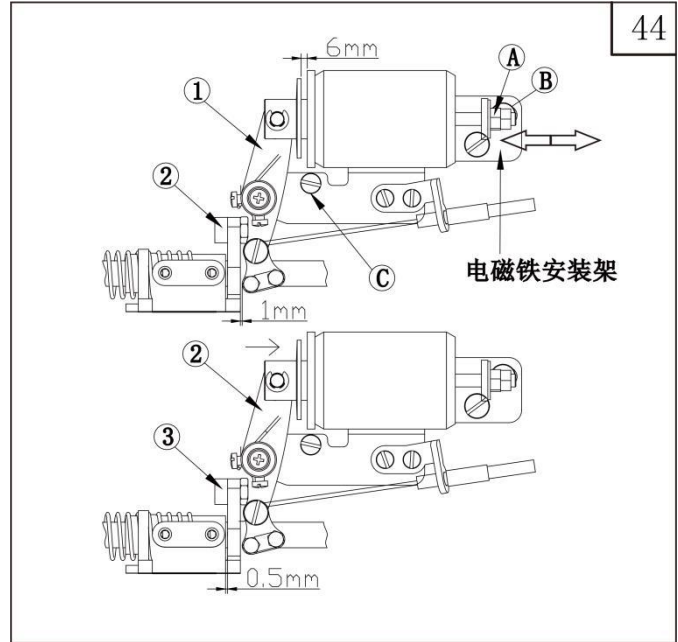
#### 4. 安装剪线电磁铁（见图 44）

##### (1) 剪线电磁铁的行程：

- a. 标准的行程为 6.0mm。
- b. 通过调节螺母 A 来调整行程。

##### (2) 安装剪线电磁铁：

- a. 剪线电磁铁用螺钉 B 和 C 来固定。
- b. 在安装时必须保证驱动板 1 与凸轮曲柄 2 之间的间隙 1mm。
- c. 电磁铁工作时，凸轮曲柄 3 与凸轮曲柄 2 之间会有 0.5mm 的间隙，这时标准的情况。如需调整可以如图 13 所示箭头方向滑动电磁铁安装架。



#### 4. Install magnetic plug (see chart 44)

##### (1) The movement locus of magnetic plug:

- a. The standard movement locus of magnetic plug is 6.0mm
- b. Adjust the movement locus by Nut A

##### (2) Install magnetic plug:

- a. The magnetic plug is fastened by screw B and screw C.
- b. The gap should keep 1mm between driven plate ① and cam crank ② when installing.
- c. When the magnetic plug running, the standard gap is 0.5mm between cam crank ③ and cam crank ②. If demand to adjust the gap between cam crank ③ and cam crank ②, please slip electromagnetic mounts according to direction of arrow on chart 13.

#### 5. 刀片的调整（见图 45）

##### (1) 动刀片与定刀片的关系：

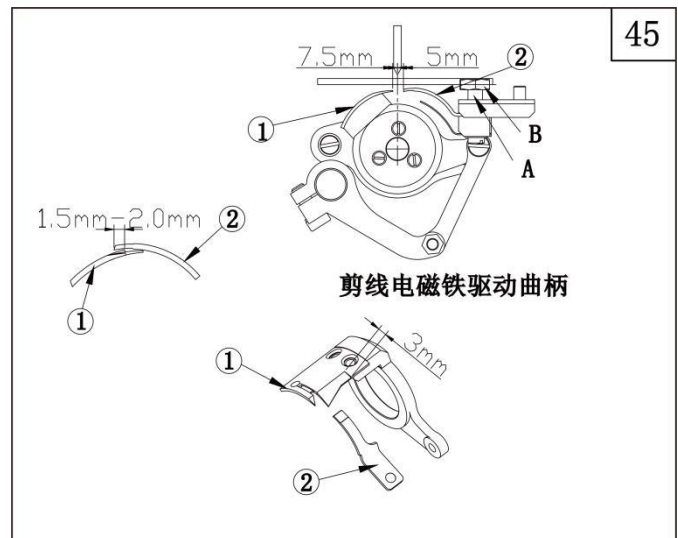
如图所示，动刀片 1 与机针中心的距离为 7.5mm，定刀片 2 与机针中心的距离为 5mm。

##### (2) 刀片的调整：

开动电磁铁，启动机器。这样，剪线凸轮会使动刀片 1 右旋转。当动刀片 1 左移到其最远位置时与定刀片 2 的间隙为 1.5-2.0mm。

##### (3) 剪线电磁铁的调整：

- A. 如果剪线情况不良，尤其当线较粗时，只需增加剪线压力即可。
- B. 剪线压力可如下所述进行调整：松开螺母 B，通过调节螺钉 A 来调节螺母 B。



#### 5. Adjustment of the knife (see chart 45)

##### (1) Relation of counter knife and moving knife:

According to chart 14, the distance between moving knife and needle center is 7.5mm and the distance between counter knife and needle center is 5mm.

##### (2) Adjustment of the knife:

Start magnetic plug and turn on the machine. So thread shear cam make moving knife ① to turn to right. When moving knife ① move to the furthest position, the gap is 1.5-2.0mm with counter knife ②.

##### (3) Adjustment of magnetic plug:

- A. If the situation of trimming thread is bad, especially that thread is too thick, it only add the pressure of trimming thread.
- B. Adjust the pressure of trimming thread as follows: Loosen nut B and adjust nut B by adjusting screw A.



### 30.工业缝纫机安全使用注意事项/ /Notes for safe use of industrial sewing machines

- 1.必须遵守基本措施；
- 2.必物经过专业培训，对缝纫机设备性能有所了解；
- 3.使用前应检查所有安全装置；
- 4 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；
- 5.离开缝纫机或工作场所时应关闭电源；
- 6.使用离合马达时，要等待马达完全停止后再进行；
- 7.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；
- 8.禁止用手触摸缝纫机通电时的零件或装置；
- 9.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；
- 10.一般的维修保养由专人进行；
- 11.在电气方面的修理应在电气技术员的监督和指导下进行；
- 12 缝纫机使用期间应定期清扫；
- 13.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；
- 14.电源插头应由专人安装；
- 15.工业用平缝机、包缝机在指定用途以外不能使用。

1. Basic measures must be observed.
2. Pass the specialized training and master sewing machine equipment performance.
3. All safety devices should be checked before use.
4. When installing needle, and changing needle, presser foot, plate, feed dog, bent needle, hook or repairing, the power supply should be turned off immediately.
5. Power should be turned off when leaving the sewing machine or workplace.
6. When using the clutch motor, please wait until the motor stops completely.
7. 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.
8. Do not touch the parts or devices when the machine is powered by hand.
9. The repair, renovation and adjustment of the main mechanisms of the relevant industrial sewing machines and overseers shall be carried out by specialized technicians.
10. General maintenance is carried out by specially-assigned persons.
11. Electrical repairs should be performed under the supervision and direction of the electrical technician.
- 12 The machine should be cleaned regularly during operation.
13. 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.
14. Power plug should be installed by specially-assigned person.
15. Industrial lockstitch sewing machine and overlook sewing machine can not be used except the designated use.

### 31.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进行合理的处置。
  - 2.请在使用完后及时关闭电源，减少电能的消耗。
  - 3.请在说明书要求的电压及环境下使用，以延长产品的使用寿命，减少废弃物的产生。
  - 4.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理。请遵守本设备及其附件处理的本地法令，并支持回收行动。
1. Please dispose the waste oil and other waste products properly according to local environmental protection requirements.
  2. Please turn off the power after use to reduce power consumption.
  3. Please use under the voltage and environment required in the manual to extend the service life of the product and reduce waste generation.
  4. Do not treat the machine and its accessories as ordinary household garbage after being scrapped. Please comply with local laws governing the disposal of the equipment and its accessories and support recycling operations.



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