

# CSA-1371CTLD

## 直驅式高速筒型綳縫機

### Direct Drive, High Speed, Cylinder-Bed, Interlock Machine



# 使用說明書

## INSTRUCTION MANUAL

No:A1371CTLD00

Read safety Instructions carefully and understand them before using.  
Retain this Instruction Manual for future reference.

爲了安全地使用，請您在使用之前仔細閱讀本使用說明書。  
另外，請您注意保管本使用說明書，以便隨時查閱。

中国缝纫机设备网

[www.fengrenjicn.com](http://www.fengrenjicn.com)



## 使用說明

### 1. 規格:

|            |                                                           |
|------------|-----------------------------------------------------------|
| 型號.....    | CSA-1371CTLD                                              |
| 名稱.....    | 直驅式高速筒型綳縫機                                                |
| 尺寸.....    | 475mm(長) * 220mm(寬) * 405mm(高)                            |
| 筒長.....    | 280mm                                                     |
| 重量.....    | 39Kg                                                      |
| 綳縫型式.....  | ISO 406, 407, 602, 605                                    |
| 縫速.....    | 6000 針 / 分鐘 (加裝后滾輪型4500針 / 分鐘)                            |
| 縫目.....    | 1.4mm ~ 3.6mm                                             |
|            | 針數: 7-18針 / 英寸      8-21 針 / 30mm                         |
| 使用針.....   | 史密茲或風琴 UY128GAS#65 ~ #90                                  |
| 針距.....    | 雙針: 3.2mm, 4.0mm, 4.8mm, 5.6mm, 6.4mm<br>3針: 5.6mm, 6.4mm |
| 針棒沖程.....  | 31mm                                                      |
| 押腳提升度..... | 最高7.0mm (有上飾線之車種最高5.0mm)                                  |
| 送料調整.....  | 旋轉按鈕                                                      |
| 差動比例.....  | 最高前送1:2.9<br>最高后送1:0.3                                    |
| 差動之調整..... | 調整螺絲或使用調節搬手<br>(操作時可藉移動調整搬手由外面調整)                         |
| 注油方式.....  | 藉送油幫浦自動給油<br>(與噴油系統合並使用)                                  |
| 油料.....    | TERESSO 46 或 YAMATO SF OIL                                |
| 儲油量.....   | 1000c.c.                                                  |
| 裝設.....    | 直接裝置於車板上或半沉式 (附特製支架)                                      |

## Manual Instruction

### 1.Specification:

|                             |                                                                |
|-----------------------------|----------------------------------------------------------------|
| Model.....                  | CSA-1371CTLD                                                   |
| Name.....                   | Direct Drive,High Speed,Cylinder-Bed,Interlock Machine         |
| Size.....                   | 475mm(length)*220mm(width)*405mm(height)                       |
| Cylinder length.....        | 280mm                                                          |
| Weight.....                 | 39Kg                                                           |
| Interlock sewing type.....  | ISO 406,407,602,605                                            |
| Sewing speed.....           | 6000 needle/minute( back puller type 4500needle/minute)        |
| Stitch length.....          | 1.4mm~3.6mm                                                    |
|                             | Needle quantity:7-18needle/inch      8-21needle/30mm           |
| Needle type.....            | SCHMETZ or ORGANUY128GAS#65~#90                                |
| Needle gauge.....           | Double needle:3.2mm,4.0mm,4.8mm,5.6mm,6.4mm                    |
|                             | Three needle:5.6mm,6.4mm                                       |
| Needle bar stroke.....      | 31mm                                                           |
| Foot lift.....              | Highest7.0mm(with upper decoration thread sewing:Highest5.0mm) |
| Feed adjustment.....        | Rotate button                                                  |
| Differential ratio.....     | MAX: front feed 1:2.9                                          |
|                             | MAX: back feed 1:0.3                                           |
| Differential adjustment.... | Adjustment screw or use adjustable wrench                      |
|                             | (adjustment outside by use adjustable wrench)                  |
| Oiling way.....             | Automatic oil by oil feed bar.                                 |
|                             | (Used in combination with the oil injection system)            |
| Oil type.....               | TERESSO46 or YAMATO SF OIL                                     |
| Oil reserves.....           | 1000c.c.                                                       |
| Installation.....           | Mounted directly on the table or semi-submerged table          |
|                             | (attached special stand)                                       |

## 2. 車頭裝設:

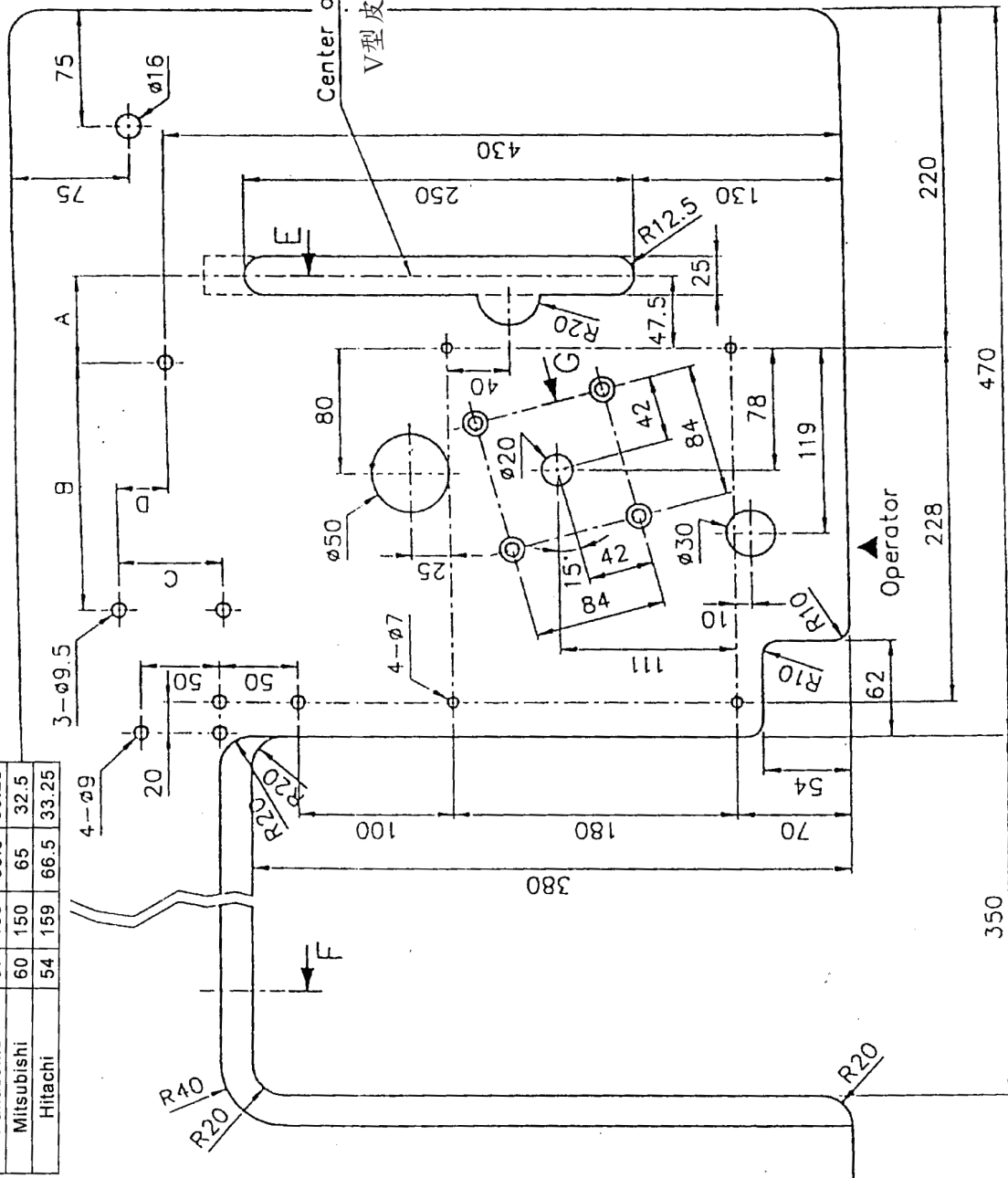
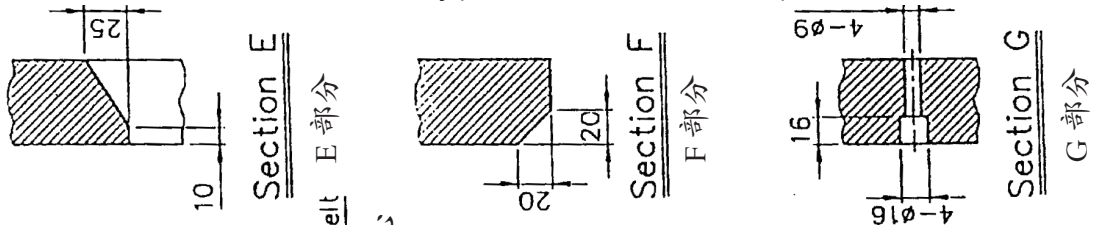
## 2. Installation of machine head on table:

### 2-1. 車板開孔圖

\* 直接裝置於車板上 (A標準式)

## 2-1. Table open hole drawing

\*Install machine head on table directly(A:standard installation)

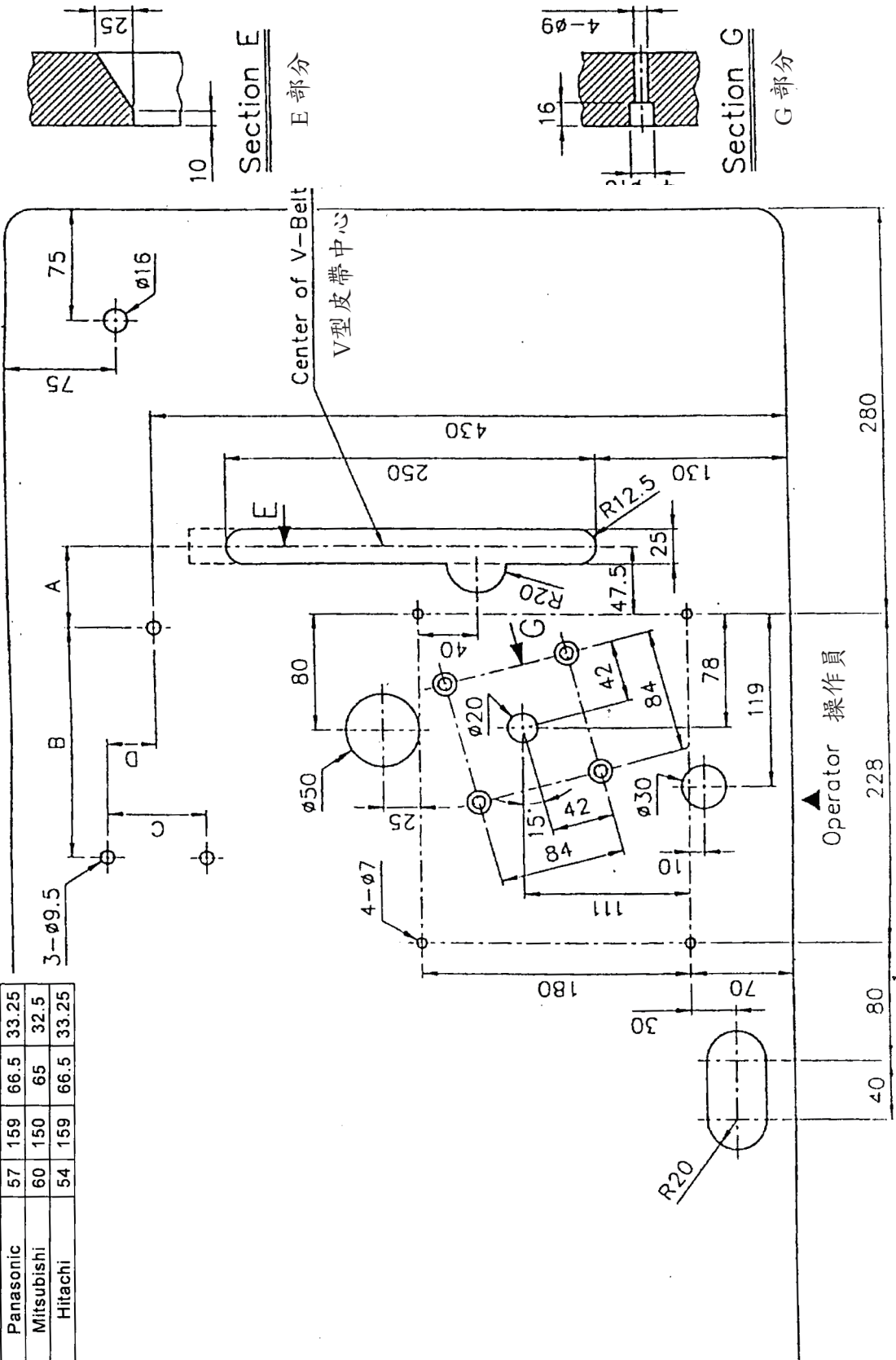


| Motor Maker | A  | B   | C    | D     |
|-------------|----|-----|------|-------|
| Panasonic   | 57 | 159 | 66.5 | 33.25 |
| Mitsubishi  | 60 | 150 | 65   | 32.5  |
| Hitachi     | 54 | 159 | 66.5 | 33.25 |

- \* 直接裝置於車板上 (B)
- \* Install machine head on table directly(B)

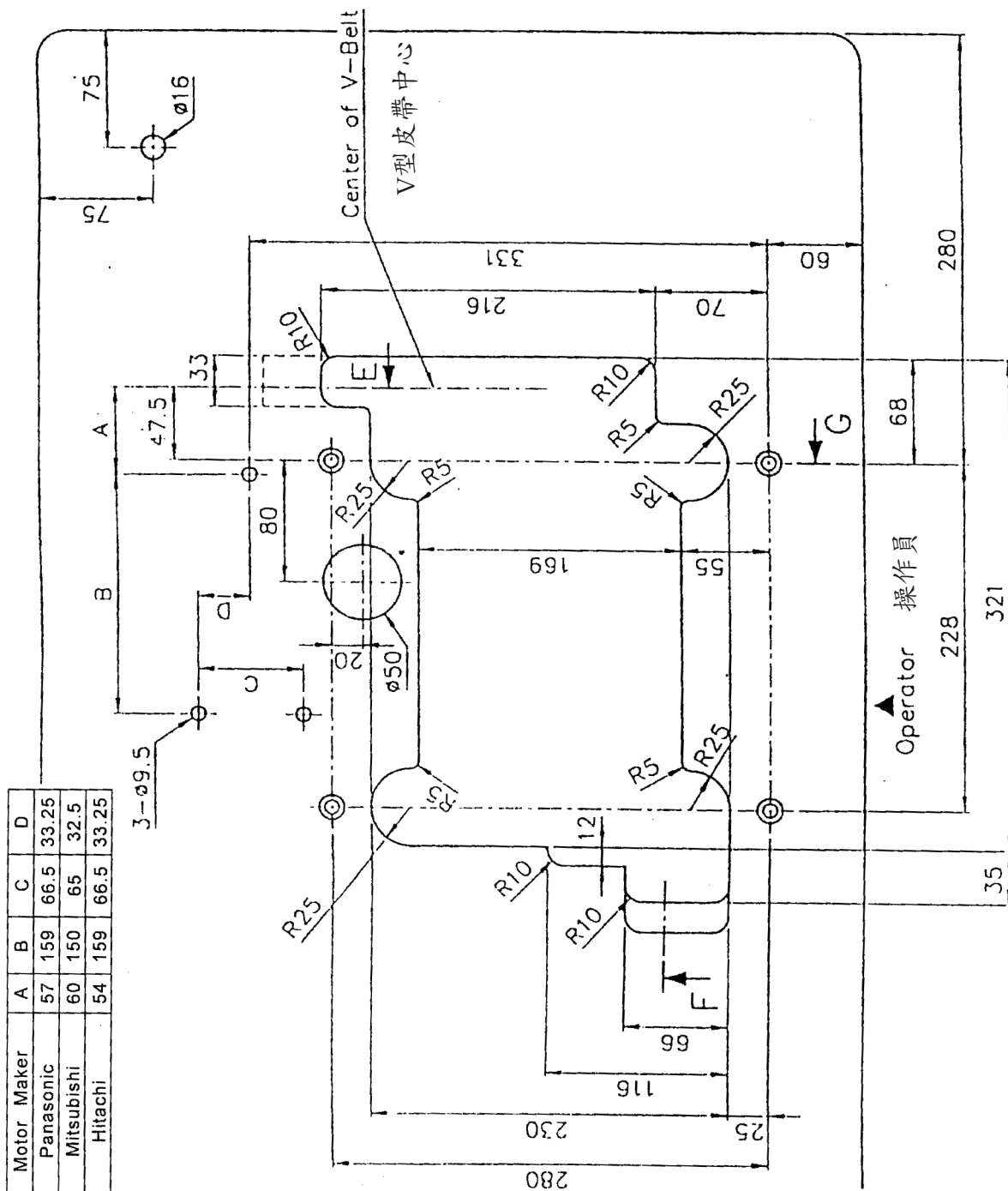
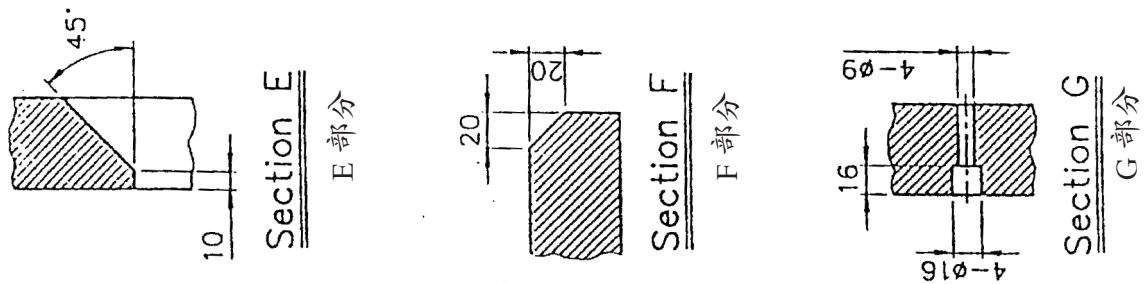
電機標記

| Motor Maker | A  | B   | C    | D     |
|-------------|----|-----|------|-------|
| Panasonic   | 57 | 159 | 66.5 | 33.25 |
| Mitsubishi  | 60 | 150 | 65   | 32.5  |
| Hitachi     | 54 | 159 | 66.5 | 33.25 |



\* 半沉式

\*semi-submerged



電機標記

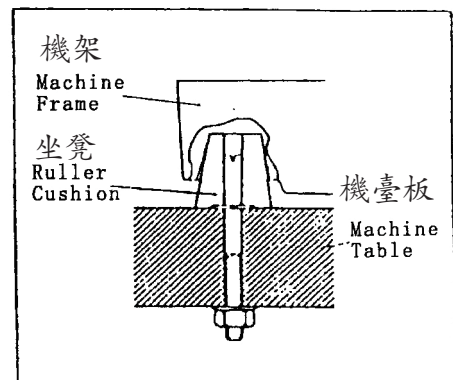
| Motor Maker | A  | B   | C    | D     |
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| Panasonic   | 57 | 159 | 66.5 | 33.25 |
| Mitsubishi  | 60 | 150 | 65   | 32.5  |
| Hitachi     | 54 | 159 | 66.5 | 33.25 |

## 2-2. 車頭裝設

依圖示正確裝設，將螺桿及螺帽鎖於桌板上，再於螺桿上端植上橡膠墊，然后再將車頭穩固的與其結合於車板上。

## 2-2. Installation of machine head

Installing the machine correctly according to the picture, fix the thread rod and nut on the table, then put rubber blanket on the thread rod, and fix the machine head on the machine table

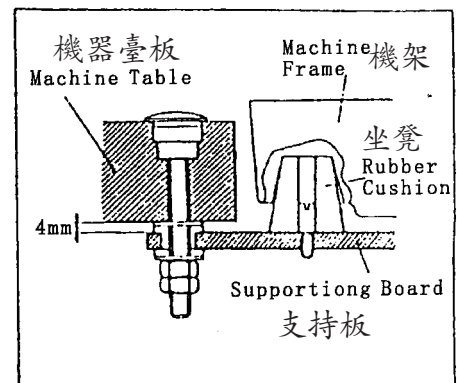


## 2-3. 半沉式裝法

依圖示正確裝設，將螺帽鎖於支架上，再將支架固定於桌板上，在螺帽上植上橡膠，再將車頭穩固的置於其上。

## 2-3. Semi-submersible method

Following the picture, fix the nut on the supporting board, and fix the supporting board on the table, put the rubber cushion on the nut, and fix the machine head on it.

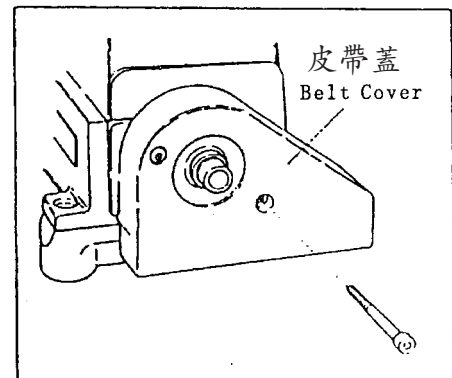


## 2-4. 裝設皮帶

依圖示正確裝設。

## 2-4. Installing belt

Installing correctly according to the picture.



## 3. 縫速與皮帶輪方向:

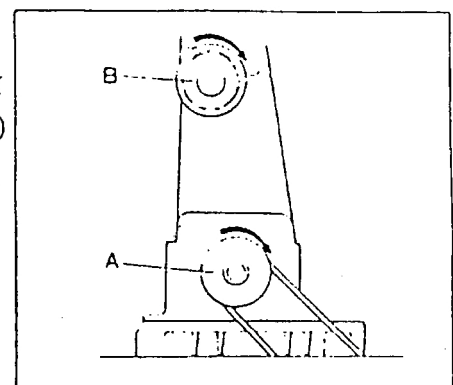
本機之最高縫速為6000轉/分鐘，一般縫速為5500轉/分鐘(加裝后滾輪時最高縫速4500轉/分鐘，一般縫速為4000轉/分鐘)建議裝機后200小時(約一個月，操作時以5000轉/分鐘為之，以延長機器使用壽命，此后可以用一般縫速。

依圖示皮帶輪轉動方向與上端手動轉輪皆為順時鐘方向。

## 3. Sewing speed and direction of belt

The max sewing speed of the machine is 6000/min, the normal speed is 5500/min (after installing rear roller, the max speed is 4500/min, the normal speed is 4000/min). It is better to operate at speed 5000/min when the machine is installed in 200 hours (one month), so it can extend the machine's life. It operates at the normal speed after 200 hours.

According to the picture, the direction of rotation of belt and the hand wheel on the top are clockwise direction.

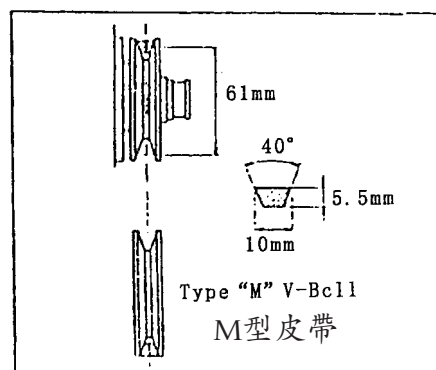


## 4. 馬達與皮帶:

使用3相.2極.400W (1 / 2HP) 離合器馬達及M型皮帶,  
馬達裝設需於踏板動作時其轉輪與車頭皮帶輪上下對正。

## 4. Motor and belt

Using three phases, two poles, 400w (1/2HP) clutch motor and M belt, installing of motor should adjustment with the rotation and hand wheel when pedal is moving.



| 馬達飛輪直徑<br>The flywheel<br>diameter of | 機頭轉速s.p.m.<br>Machine head speed s.p.m. |        |
|---------------------------------------|-----------------------------------------|--------|
|                                       | 50 HZ                                   | 60 HZ  |
| 75                                    | —                                       | 4, 000 |
| 80                                    | —                                       | 4, 200 |
| 85                                    | —                                       | 4, 500 |
| 90                                    | 4, 000                                  | 5, 000 |
| 100                                   | 4, 500                                  | 5, 500 |
| 110                                   | 5, 000                                  | 6, 000 |
| 120                                   | 5, 500                                  | —      |
| 130                                   | 6, 000                                  | —      |

\* 由於市售馬達之皮帶輪縫距為5mm, 上述之直徑僅為最接近之計算值。

\*Because the motor on the market with a 5mm sewing distance, the data above is the approaching figure.

## 5. 加油:

## 5. Add lubricating oil

## 5-1. 油料

使用TERESSO 46 或 YAMATO SF OIL

## 5-1. oil

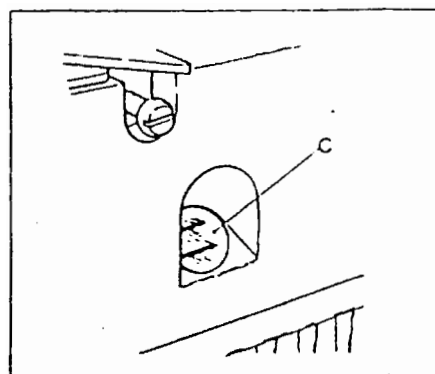
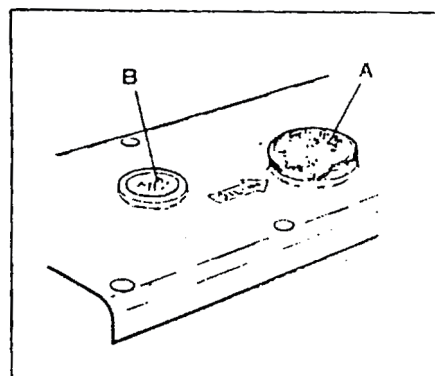
Using TERESSO 46 OR YAMATO SF OIL

## 5-2. 注油

由於機器於運送過程已將油料事先排出, 在使用機器前先取下油罩 (A), 再將油注放, 直到油表 (C) 之上限, 以確保機器免於故障。

## 5-2. Add lubricating oil

The oil on the machine was exhausted during shipping, before using the machine, take off oil shield, add lubricating oil until the oil meter gets upper limit, making sure to prevent the machine from breakdown.

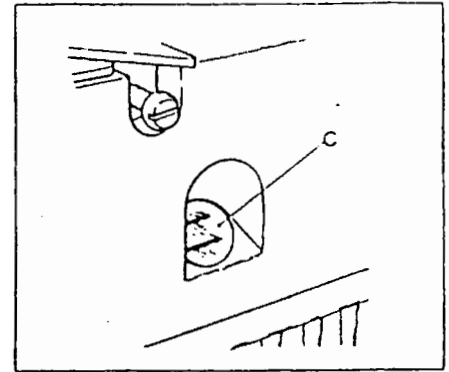


## 5-3. 油表與噴嘴

每日使用機器前，請先檢查油表（C），若油料指示不在油表之二條線之內，須再加油，確定在開始操作時，油能從噴嘴噴出。

## 5-3. Oil meter and muzzle

Before using the machine every day, please check the oil meter, if the direction of oil is not between the two lines, and it should add more oil, making sure that oil can eject from the muzzle before start operating.



## 5-4. 換油

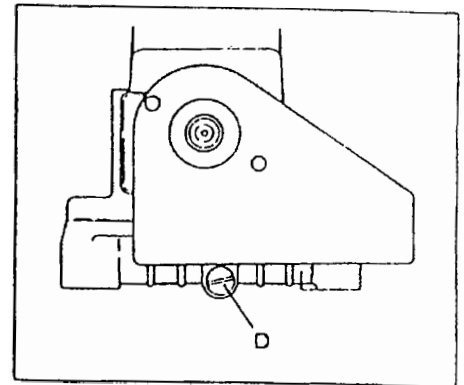
為延長機器使用壽命，車頭使用第一次到250小時，油料須全部換過，其程序如下：

- (1.) 將皮帶取下，車頭搬離車板。
- (2.) 取下螺絲（D），將油排出，注意不要沾到皮帶。
- (3.) 油全部排出后，再將螺絲（D）鎖緊。
- (4.) 再灌滿油時，請參閱“5-2. 注油”。

## 5-4. Exchange oil

In order to extend the using life of machine, the head-machine should be used to 250 hours at the first use, and oil should be exchanged, the procedure is:

- (1). take off the belt, removed the head-machine away from panel-machine.
- (2). take off screw(D), discharge the oil, take care and do not stained to the belt.
- (3). when all of the oil is discharged, locking the screw(D) again.
- (4). when filled the oil, please reference “5-2. oiling”.



## 5-5. 換濾油芯

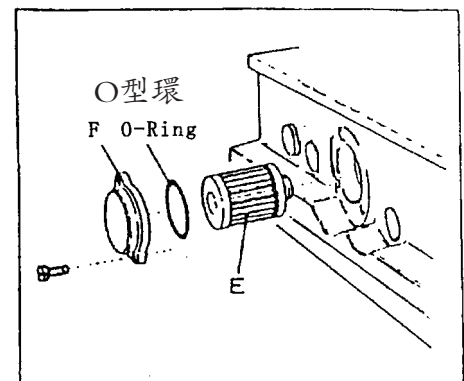
當濾油芯（E）被灰塵阻塞即無法正確噴油，請每半年檢查一次，若油已注滿但噴油嘴無油，或很少油噴出，就須檢查濾油芯，檢查濾油芯時，取下封罩（F），若有灰塵阻塞請更新。

注意：在取下濾油芯時，小心其含油會滴出。

## 5-5. Exchange oil filter core

If it unable to oil injection correct because the oil filter core(E) is blocked by ash, so please check once per half-year. If the oil is filled but no oil in nozzle, or less oil erupt, so the oil filter core should be checked. Take off enclosure(F) when checking, please refresh if have ash blocked.

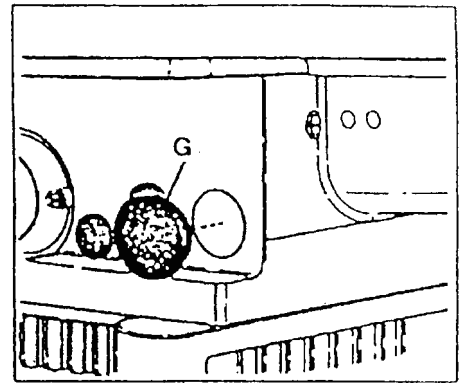
Attention: care more about the oil will drop when take off the oil filter core.



## 5-6. 車頭之清潔

每日在使用過後，請擦拭除去灰塵及線屑，打開前蓋及側蓋，並使用空氣噴槍等，每隔1~2周取下車頭後側之橡膠塞（G），用空氣噴槍或用鑷子除去濾油芯周圍之灰塵或雜物。

當濾油芯蓋阻塞，送料台附近的油無法流到油槽，導致凸輪組發生濺油現象。



## 5-6. The clean of head-machine

Please clean the ash and thread after use everyday. open front-cap and side-cap, take off the rear side rubber stopper of head-machine every 1~2 week, use air-gun or tweezers to wipe off the surround of ash or sundries of oil filter core.

When oil filter core is blocked, the nearby of oil can not influx to the feeding panel, lead to oil splashing phenomenon to the cam group.

## 6. 正確之操作:

## 6. Correct operation

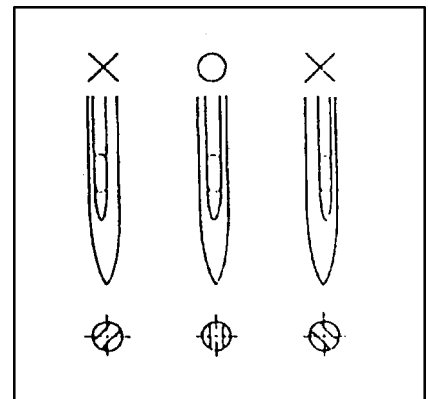
## 6-1. 針之使用及裝設

可使用史密茲UY128GAS或風琴，有幾種規格可使用，依不同原廠材質有下列選擇。

## 6-1. The use and install of needle

Can use Smith UY128GAS or organ, and have some specifications to use according to different raw materials have different choices:

|                                     |    |    |    |    |    |    |
|-------------------------------------|----|----|----|----|----|----|
| 日本規格<br>Japanese specification      | 9  | 10 | 11 | 12 | 13 | 14 |
| 公制規格<br>Metric system specification | 65 | 70 | 75 | 80 | 85 | 90 |



換針時，確定凹槽須完全朝后。

When exchange needle, please ensure the groove should backward completely.

## 6-2. 穿線

請依圖示穿線，不正確之穿線會導致跳針、斷線或縫目不穩。

A.B.C.....針線      D.....上飾線      E.....鉤針線

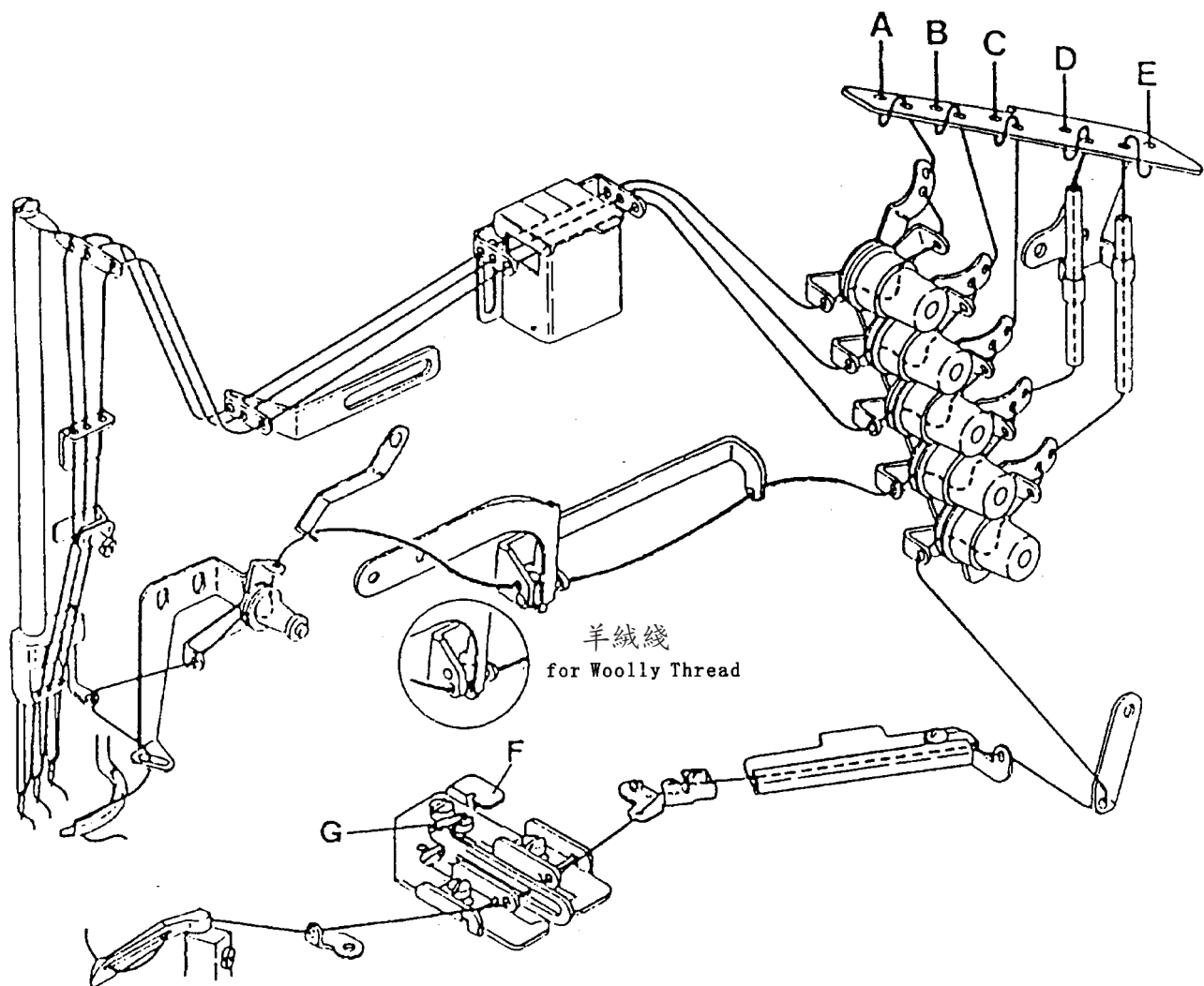
三線繃縫之穿線方式如下圖所示，二線繃縫機穿線法與三線繃縫機同，差別只在上針線只有2線。穿線時按（F），提起支持板，穿線過后再按（G）恢復原狀。

## 6-2. Threading

Please threading as pictures indicate, incorrect threading will lead to skipped needle/break line or unstable sewing.

A.B.C-----needle thread      D-----up-thread      E-----crochet thread

The threading method of three-thread seaming like the picture indicate, the same as two-thread, and the difference is the up-needle-thread only have 2 threads. press (F) when threading, rise support panel, press (G) again after threading to recovery.

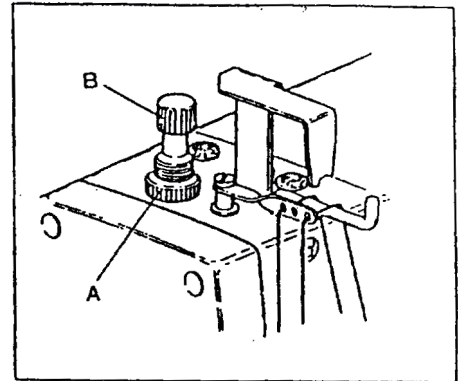


## 6-3. 壓腳之壓力

要增強壓腳之壓力，在調松螺帽（A）后，以順時鐘方向轉動調整螺絲。要減低壓腳之壓力，則以反針順序為之。壓腳之壓力請維持在最輕的情況，以便利機器之操作。

## 6-3. Adjust the pressure of the press foot

First loose the nut (A), twist the screw in the clock-wise direction to increase the pressure, twist the screw in the anti-clockwise direction to reduce the pressure, in the normal situation, please keep the pressure of the press foot be least.

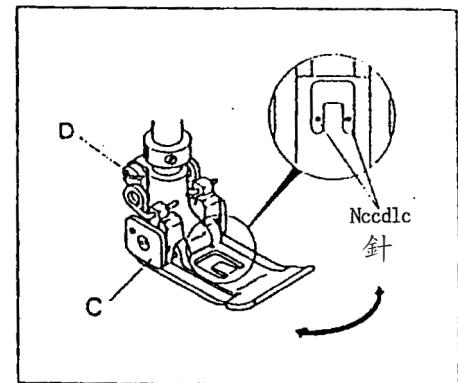


## 6-4. 調整壓腳

調整壓腳時，旋松螺絲（D）並移動壓腳之頂端向右或向左，以調整至適合針孔的程度，調整完后，請再鎖緊螺絲（D）

## 6-4. Adjust the press foot

First loose the screw (D) and move the top of the press foot to the left or right, then tighten the screw (D).



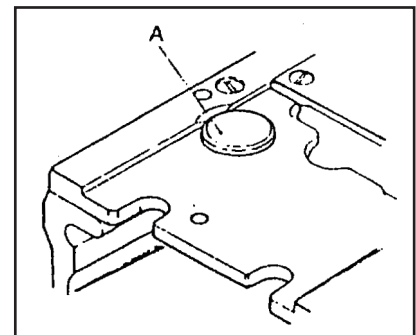
## 6-5. 調整縫目

可無段調整，由1.4mm 到 3.6mm，下表顯示每英寸（25.4mm）及每30mm之縫目針數

## 6-5. Adjust the stitch length

Adjust the stitch length from 1.4mm to 3.6mm.

| 縫目 (mm)<br>Stitch length (mm) | 每英寸針數<br>Count Per Inch | 每 30mm 針數<br>Count per 30mm |
|-------------------------------|-------------------------|-----------------------------|
| 3.6                           | 7                       | 8                           |
| 2.4                           | 10.5                    | 12.5                        |
| 1.4                           | 18                      | 21                          |



## \* 改變縫目

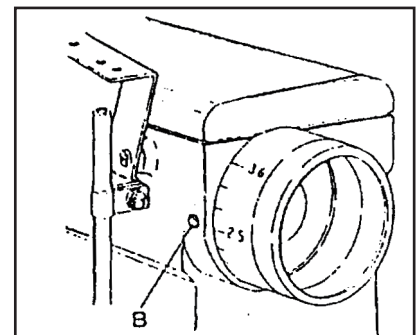
以左手將按鈕（A）輕壓，直到其頂端與內部零件接觸，再以右手轉動轉輪，直到按鈕已被導入。此時用力壓按鈕（A）並將轉輪持續轉動，再將（B）對準轉輪之刻度（mm）至需要之縫目后再放手。

\* 注意：若本繃縫機有UT裝置（下切），並已裝上定位馬達，在調整縫目時馬達開關需先關掉

## \* Change the stitch length

Press the button (A) lightly until its top touches the machine inner with left hand, then turn round the wheel until the button (A) is imported, press the button (A) hard moving the wheel to make the B face the stitch length you need. then release the button.

\*Note: If the machine is equipped with the UT and needle position motor, please turn off the motor switch first.

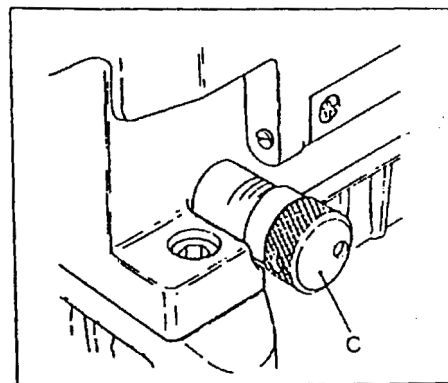


## 6-6. 調整差動

可以轉動 (C) 以調整一般正差動或逆差動，由於機子之主傳動與差動系各自獨立進行，當主傳動之縫目改變，差動亦同時進行改變，因此調整差動勢在必為。差動亦以刻度為之，譬如：若需要之縫目定在“2”，若轉動旋鈕(C)至“2”則差動為1:1，若超過“2”則為正差動，少於“2”則為逆差動，主傳動之上很為“4”。

- ◆旋轉旋鈕 (C) 到 (D) 時，差動調節臂會跟著移動，設定好差動比后，請鎖緊固定螺帽 (E)。

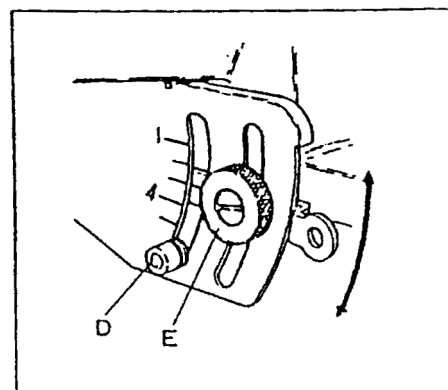
當使用最大差動比時，旋轉旋鈕 (C) 並將差動調節臂設定於刻度“1”，在車縫之同時，亦可在調節臂系上鏈子隨時調整差動比。



## 6-6. Adjust the the differential

Turn around the (C) to adjust the positive differential or negative differential ,since the main transmission and the the differential are separated ,the differential needs to adjust when the main transmission has been changed for example , when you need to set the stitch length 2,if the (C) is at 2, at this situation ,the differential should be 1:1 ,if turn round c over 2,the it is should be positive differential ,if C is less than 2 ,it is should be “4”on main rotation.

- ◆Move the C to D,the differential arm will move at the same time,when the differential ratio si certain ,please tighten the screw(E) ,when set the differential ratio max ,move the C and put the differential arm to 1,when the machine are working ,you can adjust the differential ratio.



\* 縫目不同時，差動的範圍隨之改變

\*The differential range will change while adjusting the stitch length

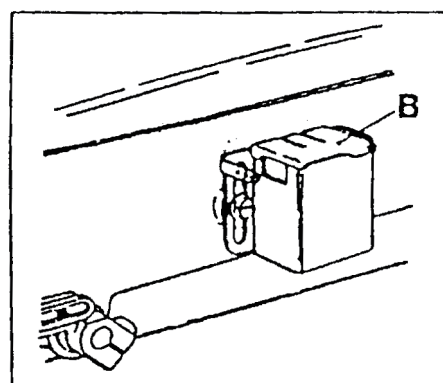
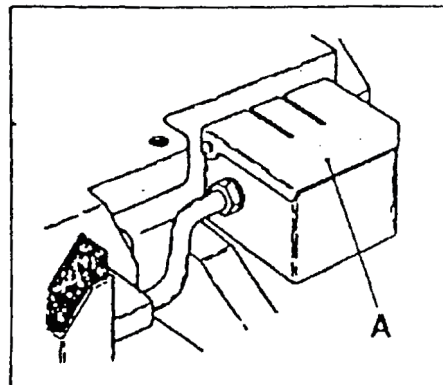
| 縫目 (mm)<br>Stitch length (mm) | 最大縮縫<br>Max contraction stitch | 最大伸縫<br>Max stretching stitch |
|-------------------------------|--------------------------------|-------------------------------|
| 3.6                           | 1:1.1                          | 1:0.3                         |
| 2.5                           | 1:1.6                          | 1:0.4                         |
| 2.0                           | 1:2.0                          | 1:0.5                         |
| 1.4                           | 1:2.9                          | 1:0.7                         |

## 6-7.HR & SP裝置 (油壺)

在高速車縫的情況下，針與布料的磨擦會產生熱量，以致造成斷線、跳針及針孔過大的情況，尤其是在使用合成纖維的布料或化纖線時，爲了減少這種情況，本機型附有HR裝置(針尖冷卻)和SP裝置(針線浸油)。這種使用針車油(白矽油)的方式有很好的效果。

注意：1.打開HR盒的蓋子和SP盒的蓋子，檢查油量，不足時隨時添加。

注意：2.盡管上述之油壺裝置常被建議使用，然而在考量實際車縫時，有時並不需要，此時，請將其中之油棉取出，因爲在這種情況下最好不要讓線及針經過未浸過油的油棉。



## 6-7. HR&SP DEVICE

Under high speed bind stitch ,it perhaps make a lot of heat causing thread damage 、 skip needle、 hole of needle too big , especially working with synthetic fibre cloth or Chemical fibre line,in case these situations ,HR(the point of needle cool down) &SP(thread touching the oil) DEVICE are used with the machine .the oil has great effect on the bind stitch.

Note : 1. Open the HR cover and SP cover .check the volume of oil ,please add the oil in time.  
2. when there is no need to use the HR&SP DEVICE ,please put out the oil cotton,since the needle and thread can not touch the cotton when the cotton has no oil insid

## 7. 調整:

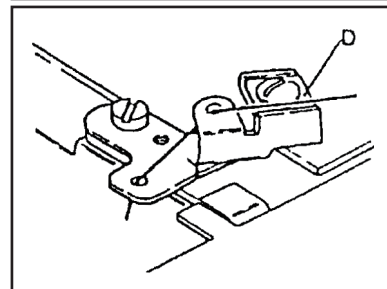
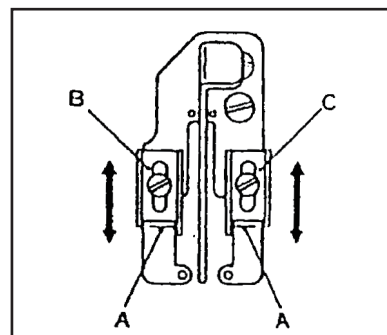
### 7. Adjustment

#### 7-1. 調整底線導線

將圖中支持板之 (A) 對劑，(B)、(C) 線孔對正即可。要底線結線較緊時，將 (B)、(C) 推向前，反之要較松時則推向后。

注意：底線結線不要調得過緊，否則容易跳針。

當底線使用毛線時，將 (B)、(C) 推向前，而且線不要通過底線之小調子盤 (D)。



#### 7-1. Adjust the guide thread of bottom thread

Align the support plate A, and the thread hole B,C.,push forward the B and C when the thread tied;if the thread are loosen,you can push back.

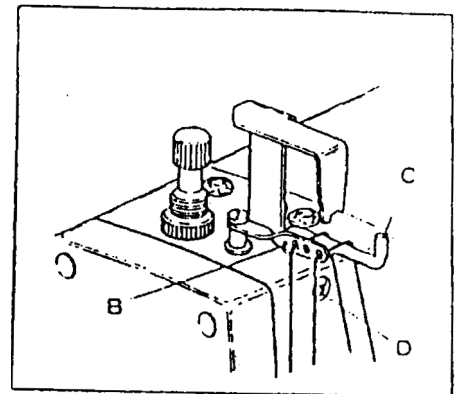
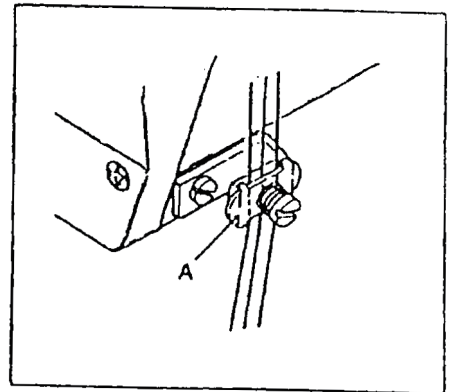
Attention: don't adjust the thread too tight,otherwise it's easy to jump stitch  
When using the woolen thread ,push forward B,C,don't pass the D.

## 7-2. 調整縫線

- ◆對於某些線的車縫，線若不易控制，造成鉤線困難，引起跳針現象，此時若縫線須經過圖示（A）之小型張力控制鈕。
- ◆使用具伸縮性之化纖線時，線環之穩定性不夠須使用導線棒，標準設定時，將針棒降至最低點，導線之線孔（B）之中心要與導線棒上緣（C）對齊，且（B）與（C）需平行。  
導線棒（C）上、下、左、右之調整，可以在放松固定螺絲（D）為之。

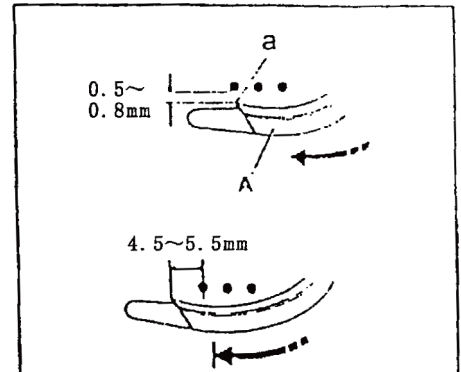
## 7-2. Adjust the stitch

- ◆For some stitch thread, if the thread not easy to control and hard to hook the thread, cause jump stitch, make it through the A.
- ◆When using the elastic thread, thread ring is not stable, should use the guide bar, when setting the criterion, let the needle bar at the lowest position, align the thread hole B and guide bar C. You can adjust the loose by screw D.



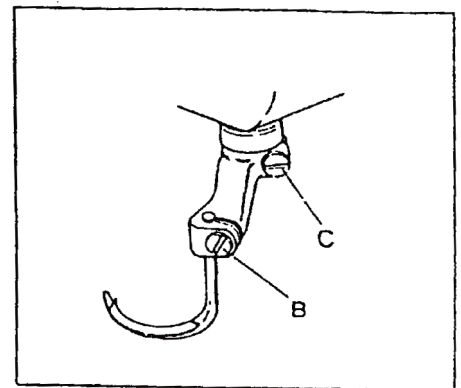
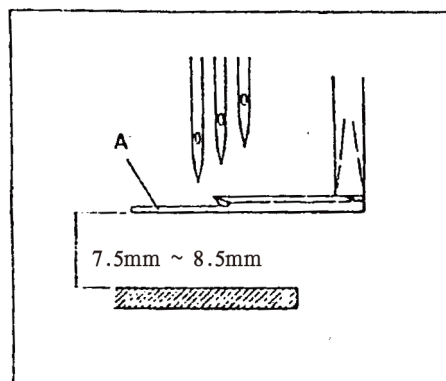
## 7-3. 縫線針與上彎針

- (1) 當上彎針（A）向左擺動，其針尖（a）過左針時與左針之間隙為0.5mm~0.8mm，但擺動到最左側則為4.5mm~5.5mm。  
二彎針須位於針板上方7.5mm~8.5mm處，調整時可於放松上彎針鎖針螺絲（B）或上彎針之針榴螺絲之後為之。



## 7-3. Stitch needle and upper looper

- (1) When upper looper A swing to the left, the distance of pin and left needle should be 0.5~0.8mm, or 4.5~5.5mm.  
The second looper should on the top 7.5~8.5mm, you can adjust the loose by screw B and needle clamp.

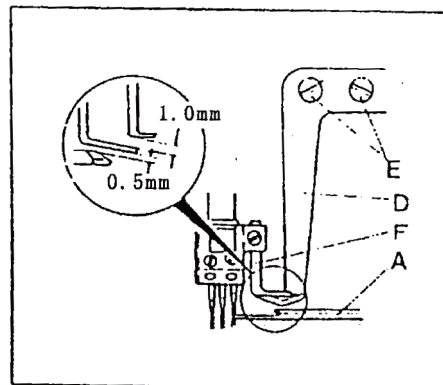


## (2). 裝設上飾線導線板

設定上飾線導線板 (D) 與上彎針 (A) 之間隙為 0.5mm, 然後將螺絲 (E) 鎖緊。這樣上彎針在擺向最右側時, 可以正確地鉤線。

## (2) Install the guide plate

Set the distance from guide plate D to upper looper is 0.5mm, and tight the screw E, MAKE SURE WHEN THE UPPER looper swing to the right, can hook the thread.



## (3). 裝設線掛

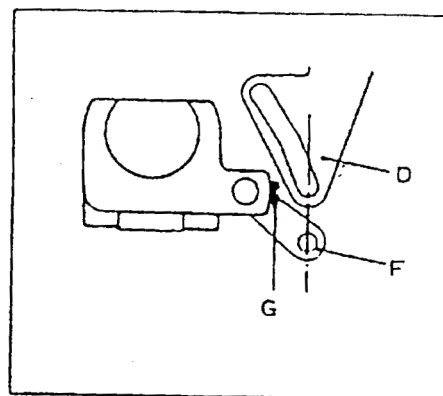
將針棒降到最低點, 上飾線導線板 (D) 與線掛 (F) 之間隙為 1.0mm, 此時將線掛 (F) 之導線孔與導線板 (D) 之線孔中心對齊, 再鎖緊螺絲 (G)。

\* 上述 (1)、(2)、(3) 項須依不同之線質做設定。

## (3) Install the thread guard

Put the needle bar in the lowest position, upper guide plate D to thread guard is 1.0mm. Align the F and the D, then tight screw G.

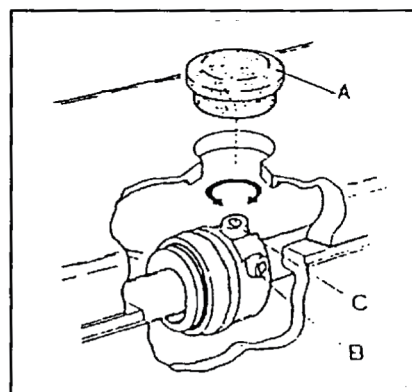
\*Above item (1),(2),(3) adjustment in according to different type of thread.



## 7-4. 調整滾輪進料量 (附滾輪機型)

進料量之調整如下:

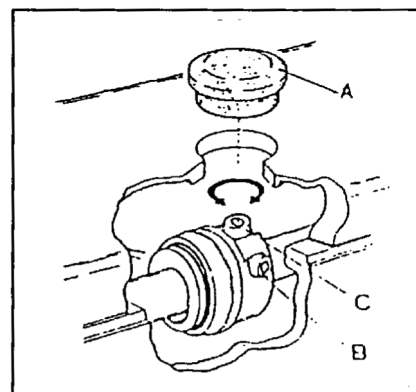
- (1). 取下上蓋之塞子 (A)。
- (2). 轉動手輪至送料偏心之螺絲 (B) 出現, 然後將 (B) 旋松。
- (3). 轉動手輪至送料偏心之調整螺絲 (C) 出現於塞子之洞口。
- (4). 要增加進料量, 將調整螺絲 (C) 往逆時針方向旋轉, 要減少進料量則往順時針方向旋轉。
- (5). 再以附件箱中之六角板手將偏心之螺絲 (B) 鎖緊, (扭力: 25Kgf - cm.)



#### 7-4. Adjustment of roller feed amount (Attached is roller model )

The adjustment of roller feed are as follows:

- (1)Take the plug between up and down cover
- (2)Turn hand -wheel until screw B show up,and then loosen screw B.
- (3)Turn hand-wheel,until screw(C) is on the hole of plug.
- (4)To increase feed rate ,turn screw (C) in counter-clockwise direction,and reduce feed rate in clockwise direction of accessory box to tighten screw (B).(Torsion :25kgf-cm)



#### 7-5. 上滾輪之壓力

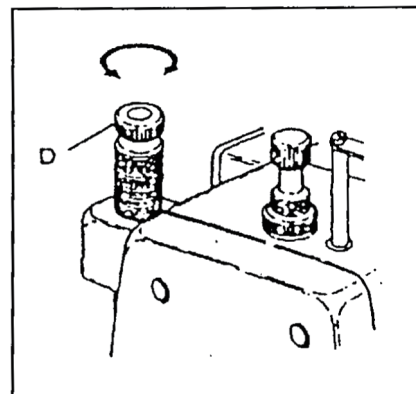
上滾輪與大滾輪間之壓力需調到最輕，僅可以送料的程度。

要增加壓力，調整螺絲（D）向順時針方向旋轉，要減低壓力則往逆時針方向旋轉。

#### 7-5. Pressure of up roller

Turn the stress between upper roller and big roller to lightest, only can feed.

To increase stress ,turn screw (D) in clockwise direction, otherwise in counterclockwise.



#### 車針與 下彎針定時之調整

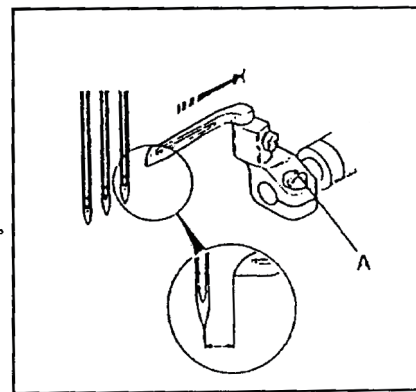
- (1).當車針在最低點，下彎針在最右側時，依下例之車針針距規範，右車針中心點與下彎針針尖之距離有其相對之數據，調整時先調松下彎針針榴之固定螺絲（A）

\* 下彎針退到最后端時，其針尖與針棒中心點距離為6mm.

#### Adjustment of needle and lower looper regularly

- (1)When the needle is in lowest position, looper is in the most right side,as the following sample showed, the distance between center of right needle and looper center has relative data.Loosen the setting screw of looper when adjusting!

\*When the looper returned to the end, the distance between needle tip and center is 6mm.



| 針距<br>Needle gauge | 標示符號<br>Mark symbol | 右車針與下彎針距離<br>Distance between right<br>needle and lower looper |
|--------------------|---------------------|----------------------------------------------------------------|
| 3.2mm (32)         | A                   | 4.4mm                                                          |
| 4.0mm (40)         | B                   | 4.0mm                                                          |
| 4.8mm (48)         | C                   | 3.6mm                                                          |
| 5.6mm (56)         | D                   | 3.2mm                                                          |
| 6.4mm (64)         | E                   | 2.8mm                                                          |

\* 為方便下彎針定時之調整，請使用定時固定規格 (Timing Gauge)此規格可向代理或逕向本公司索取。

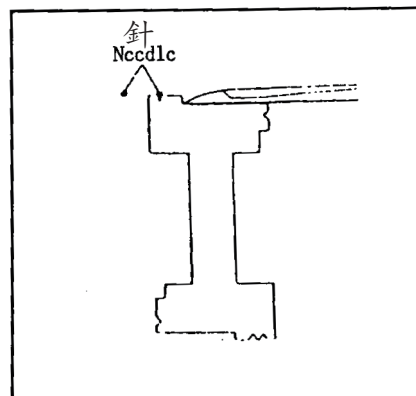
\* 定時固定規格

在此規格上有A、B、C、D、E符號，將右車針定位於V凹槽，並將下彎針移動到最右端，讀取到欲定符號后，可將下彎針針尖定位於設定之距離，然後將下彎針針榴之固定螺絲(A)鎖緊。

\* For convenience of adjustment looper, please use timing guage,this specification can get from company or agency!

\* Timing Gauge

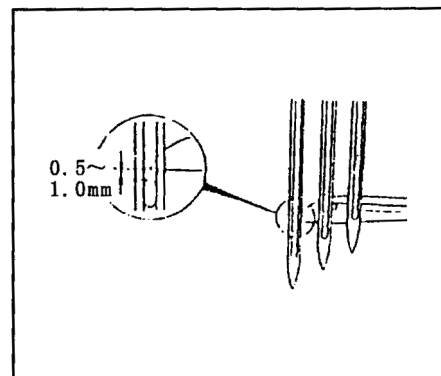
There is A,B,C,D mark on it,locate right needle to V groove,and move looper to the most right end,after reading the mark, move the looper to the setting position,and tighten the setting screw (A).



(2).設定針棒高度

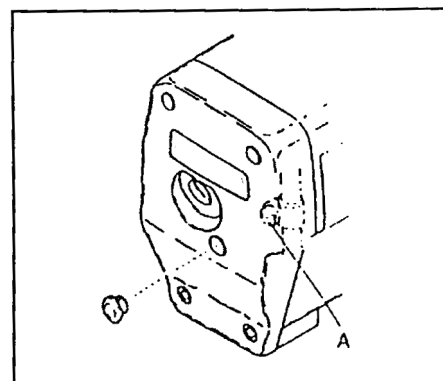
當下彎針之尖端對準左邊車針之中心時，其位置須在車針針孔的上方 0.5mm ~ 1.0mm處，亦即車針之高度依下彎針之標準設定，此標準值系以車針鎖定針榴且位於針孔之中心，而下彎針亦已正確地固定在針榴上。

調整針棒高度時，取下上臂針棒護蓋之孔塞，放鬆針棒固定器，固定螺絲(A)，上下移動針棒，將其調整至適當位置。



(2) Needle bar height setting

When the top of low looper point to the center of the left needle, its position should be 0.5mm-1.0mm upper the needle hole, also the height of the needle is set according to the low looper, whose standard is as the center of the hole of the needle clamp, while the low looper is also fix to the needle clamp correctly.



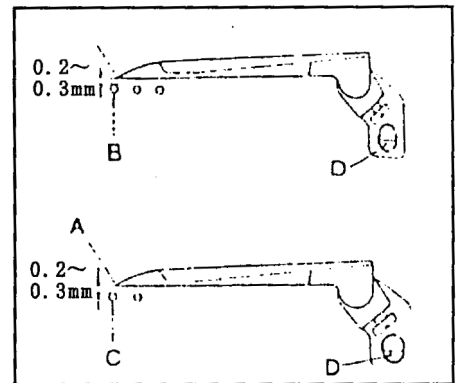
## (3). 車針與下彎針之前后間隙調整

## \* 3針機型之調整

當下彎針之尖端 (A) 與最左側車針 (B) 會合時，間隙為  $0.2\text{mm} \sim 0.3\text{mm}$ ，調整時放松下彎針針榴固定螺絲 (D)，再予以調整。

## \* 2針機型之調整

當下彎針之尖端 (A) 與左側車針 (C) 會合時，間隙為  $0.2\text{mm} \sim 0.3\text{mm}$ ，調整時放松下彎針針榴固定螺絲 (D)，再予以調整。



## (3) Adjust the gap between the needle and the looper

\* 3 needles: when the top of the low looper (A) meet the left needle (B), the gap is  $0.2\text{mm} \sim 0.3\text{mm}$ . When adjusting, loose the screw (D) of the low looper needle clamp, then adjust.

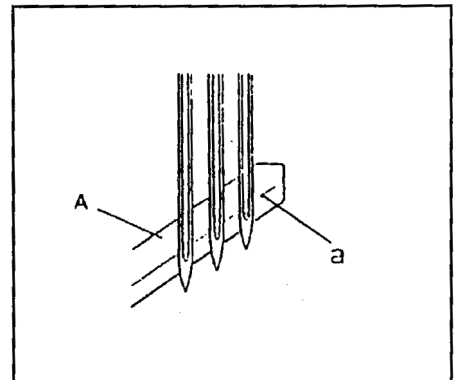
\* 2 needles: when the top of the low looper (A) meet the left needle (C), the gap is  $0.2\text{mm} \sim 0.3\text{mm}$ . When adjusting, loose the screw (D) of the low looper needle clamp, then adjust.

## (4). 后針受器位置

針棒降至最低點時，后針受器之稜線A要與車針針孔中心連線斜向對齊。

## (4) The position of the back needle:

when the needle bar reach the lowest point, A of the back needle holder should align with the center.

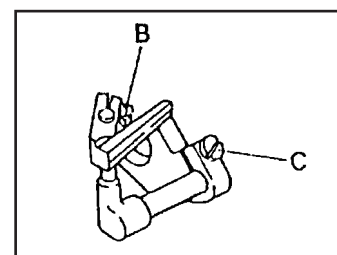
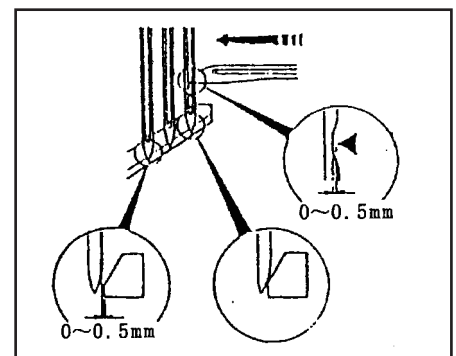


## \* 后針受器正確位置

當下彎針行進至右車針的中心點時，放松螺絲 (B)、(C)，將后針受器稍向前推，此時右車針與下彎針之間隙須為  $0 \sim 0.05\text{mm}$ ，左車針和后針受器間隙須為  $0 \sim 0.05\text{mm}$ 。

## \* The right position:

When the low looper reach the center of the right needle, loose the screw (B),(C), push the back needle forward, then the gap between the right needle and low looper is  $0 \sim 0.05\text{mm}$ , the gap between left needle and back needle is  $0 \sim 0.05\text{mm}$ .

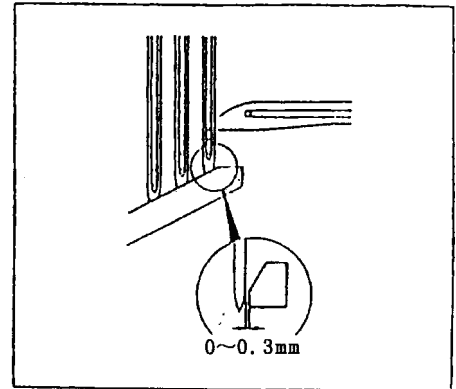
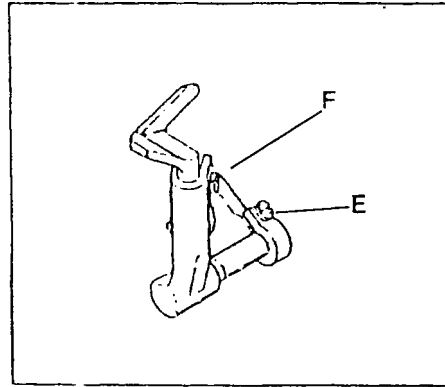
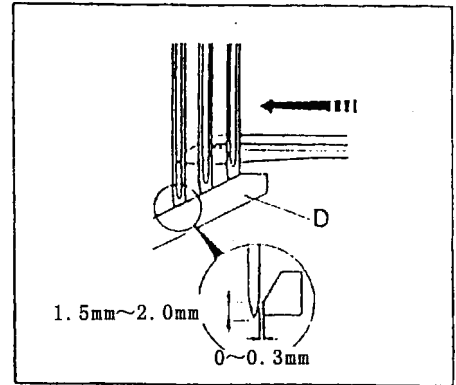


## (5). 前受針器位置

當下彎針行進至左車針的中心點時，前受針器須位於車針針尖上方1.5mm~2.0mm，調整時，放鬆螺絲(E)、(F)，將車針與前受針器的間隙調至0~0.3mm，下彎針擺回右車針時，其與前受針器之間隙亦得為0~0.3mm。

## (5) The position of the front needle holder

When lower looper reach the center of the left needle, the front needle holder should be 1.5mm-2.0mm above the needle top point. When adjust, loose the screw (E) (F), adjust the gap between needle and holder be 0-0.3mm, and low looper return to the right needle, the gap with front needle holder should be 0-0.3mm.



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