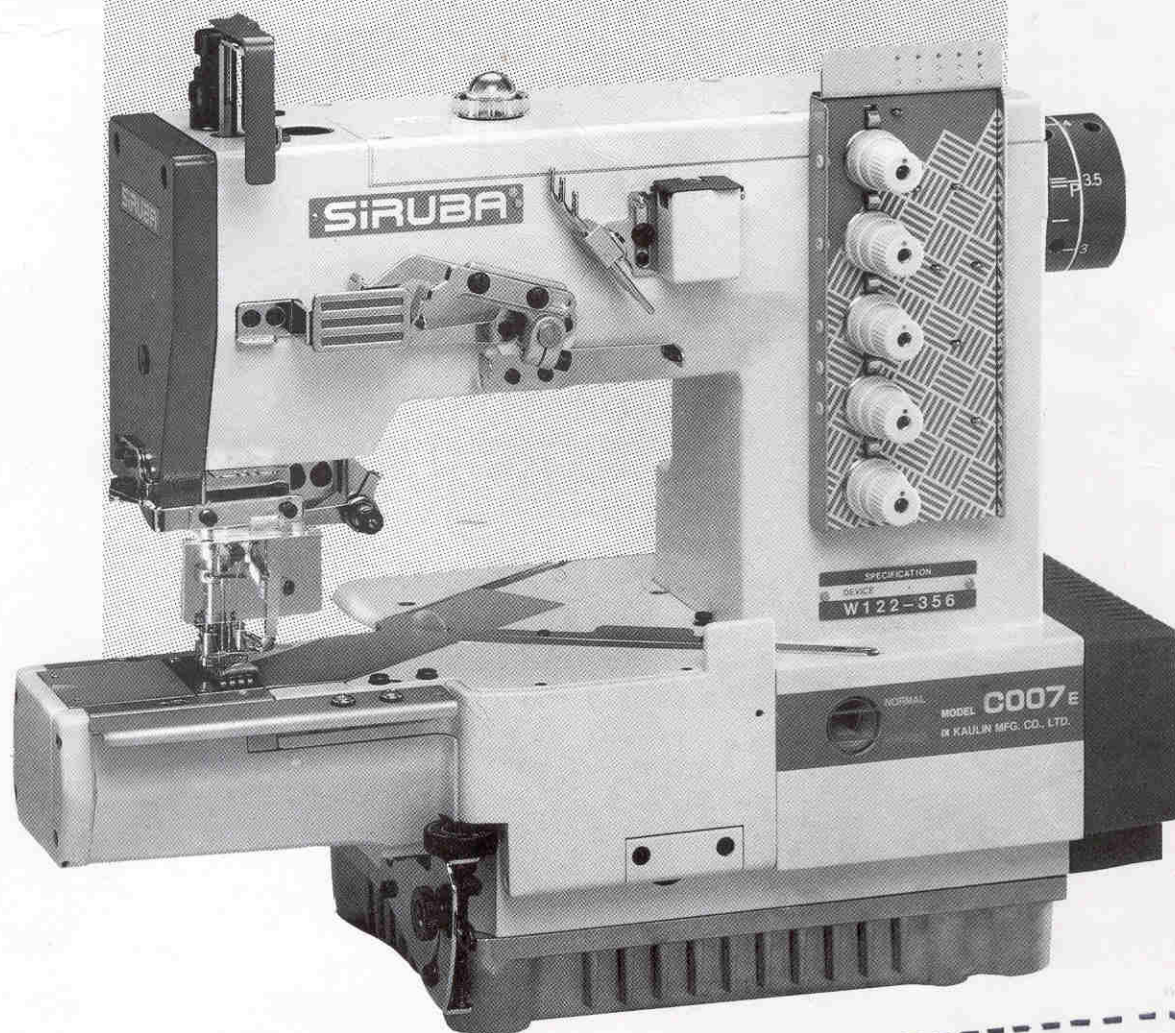


SIRUBA®

C007E



ESCANIADO

使用說明書&零件圖 INSTRUCTION & PARTS BOOK



- ORIGINAL



高林股份有限公司
KAULIN MFG. CO., LTD.

使用說明

- .安裝
- .馬達與皮帶
- .潤滑
- .潤滑油之更換
- .針之更換
- .穿線方法
- .拉線鬆緊度調整
- .針線控線桿之調整
- .上叉控線桿調整
- .押具之調整
- .縫目長度之調整
- .差動比調整
- .押具壓力強度之調整

維修說明

- .針棒高度調整
- .針與勾針之時位關係
- .針與勾針之調整
- .針與後護針片之調整
- .針與前護針片之調整
- .送布齒高度調整
- .上叉之設定
- .上叉導板位置之調整
- .上叉行程調整
- .押具提升之調整
- .勾針線調整
- .勾針控線桿的位置
- .棉屑之清除

零件圖
規格表
桌板圖

OPERATION GUIDE

- .INSTALLATION 1
- .MOTOR AND BELT 2
- .LUBRICATION 2
- .HOW TO CHANGE OIL 3
- .HOW TO REPLACE THE NEEDLES 3
- .THREADING 4
- .ADJUSTING THREAD TENSION 4
- .ADJUSTING NEEDLE THREAD TAKE-UP 5
- .ADJUSTING SPREADER THREAD TAKE-UP 5
- .ADJUSTING PRESSER FOOT 6
- .ADJUSTING STITCH LENGTH 6
- .ADJUSTING DIFFERENTIAL FEED RATIO 7
- .ADJUSTING THE PRESSURE OF PRESSER FOOT 7

MAINTENANCE GUIDE

- .THE HEIGHT OF NEEDLE BAR 8
- .TIMING OF NEEDLE AND LOOPER 8
- .ADJUSTING NEEDLE AND LOOPER 10
- .ADJUSTING THE NEEDLE AND REAR NEEDLE GUARD 11
- .ADJUSTING THE NEEDLE AND FRONT NEEDLE GUARD 11
- .ADJUSTING THE HEIGHT OF FEED DOG 12
- .SETTING THE POSITION OF SPREADER 13
- .SETTING THE POSITION OF SPREADER GUIDE 13
- .ADJUSTING THE SPREADER STROKE 14
- .ADJUSTING PRESSER FOOT LIFT 14
- .ADJUSTMENT OF LOOPER THREAD 15
- .THE POSITION OF LOOPER THREAD TAKE-UP 16
- .CLEAN UP DUST 16

- PARTS LIST 17
- PARE PARTS CONVERSION CHART 31
- TABLE CUT-OUT 33

使用說明

OPERATION GUIDE

安裝

1. 依本機器所附桌板裁製圖及另件組合圖所列之配件，依序安裝防震機座，線架。(及廢料槽 -FR機種)
2. 馬達之轉向為順時鐘方向，皮帶之鬆緊度以用手指向內壓下 2cm 為宜，同時為了安全起見，請皮帶蓋必須鎖上。(圖 1,2)
3. 皮帶輪與縫合轉速請照表 1。

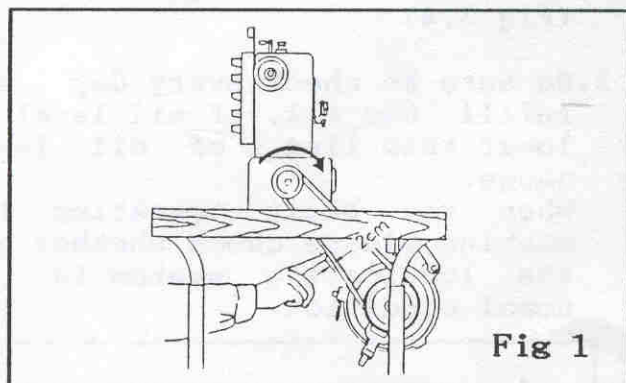


Fig 1

INSTALLATION

1. Before installing machine, please refer to table cut-out drawing, and the necessary attachment as enclosed, according to the sequence of installation, to fix quake-proof base, thread stand. (and the cloth waste chute for FR model)
2. Be sure that the motor turning direction is clockwise, and the motor belt tension can be pressed with finger inward about 2 cm. For safety reason, please fasten the belt cover. (Fig 1,2)
3. Regarding machine speed and motor pulley diameter, please refer to Table 1.

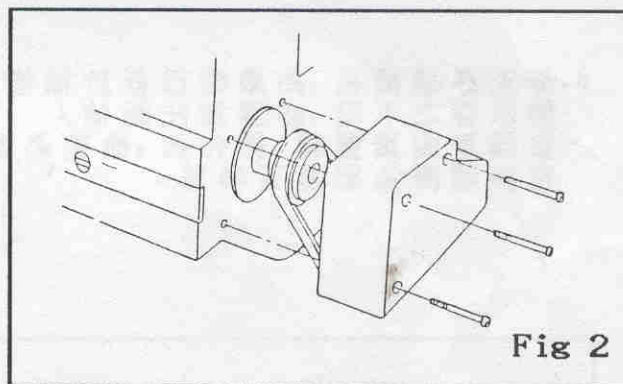


Fig 2

Table 1 (表 1)

Machine Speed (S.P.M.) 轉速/分	Motor Pulley Outer Diameter (mm)		Motor Belt V-BELT, M-TYPE (CLUTCH MOTOR)
	60HZ	50HZ	
6,000	105	125	36 "
5,500	95	115	↑
5,000	85	105	35 "
4,500	80	95	↓
4,000	70	85	34 "

注意：

1. 使用新機器最初一個月運轉速度約為最高轉速之 80%，並請選擇正確的馬達皮帶輪尺寸(如表 1)。

Remarks:

1. During the first month of using the machine, the maximum speed shouldn't exceed 80% of the speed listed in Table 1. Make sure to choose the correct size of motor pulley.
2. The standard thickness of table is about 50mm.

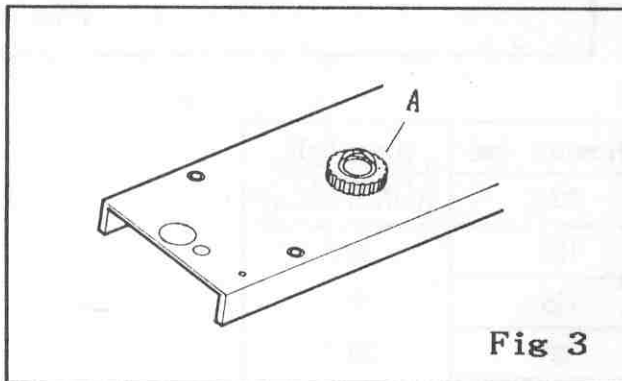
2. 桌板厚度約 50mm.

馬達與皮帶

1. 離合器馬達 1/2馬力 (或 400瓦),
3 相 2 極 M 番 V 型皮帶。
2. 馬達位置之安裝必須是機器皮帶輪與
馬達皮帶輪的中心線必須一直線。

潤滑

1. 請選用 MOBIL#10 或 ESSO#32或同級之
潤滑油。
2. 由於新機器在裝運前已將油倒盡,因
此新機器在使用前必須注入新油,轉
開螺絲 "A"將油注入機器中,待油量滿
至油標指示上下線之間即可。
(圖 3,4)
3. 每天必須檢視,如果油已低於油標
指示窗之下限,必須加注新油。
當機器開始運轉,操作前,檢視必須
整個潤滑系統是否暢通。



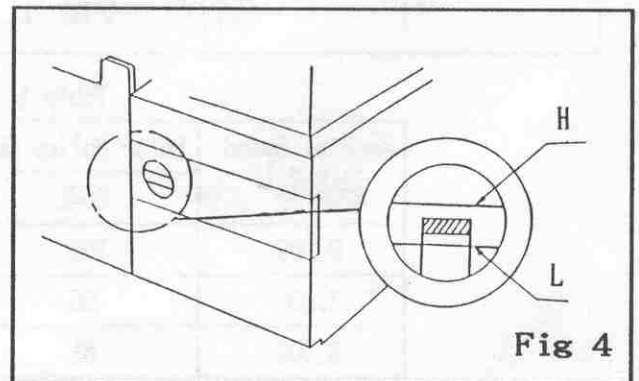
* 開箱之新機器或久放未使用而重新
要使用時,請在針棒上下部份加油
潤滑。

MOTOR AND BELT

1. Clutch motor, 1/2 HP (400W)
3 phase, 2 pole M type V belt.
2. The center line of both motor's
and machine's pulley must be
aligned each other, when
installing the motor.

LUBRICATION

1. Please oil Mobil #10 or Esso #32
or its equivalent.
2. The lubricating oil has been
drained from the machine before
delivery, to remove screw(A), and
fill the oil until the oil
level reaches between lines H
and L of oil level gauge.
(Fig 3,4)
3. Be sure to check every day and
refill the oil, if oil level is
lower than line L of oil level
gauge.
When you begin operating the
machine, please check whether all
the lubricating system is at
normal condition.



* Before starting a brand new
machine or a machine which has
not been used for more than a
couple of week, lubricate the
needle bar.

潤滑油之更換

1. 將螺絲 (1) 鬆開, 使油槽之油完全排出後再鎖緊。(圖 5)
2. 為延長本機器壽命, 請於開始使用四星期後更換新油, 爾後約每四個月更換一次。

HOW TO CHANGE OIL

1. Loosen screw (1), drain all the oil from the tank, then fasten the screw. (Fig 5)
2. For extending the life of the machine, change oil after the initial 4 week operation. after that, change oil every four months.

濾油器之更換

本機器特別裝有濾油器, 約每使用一個月後應卸下清洗, 必要時得換新品。(圖 6)

HOW TO REPLACE THE OIL FILTER

This machine is equipped with an oil filter, and the filter must be cleaned every month. Replace the filter if necessary. (Fig 6)

針與線之冷卻與潤滑

使用矽油注滿 (1)(2) 油槽以防止斷線。(圖 7)

LUBRICATE THE NEEDLES AND THREADS

Fill reservoir (1) and (2) with silicone oil to prevent the thread from breaking. (Fig 7)

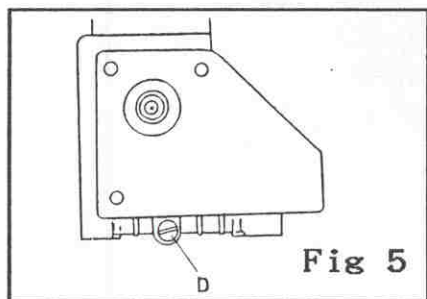


Fig 5

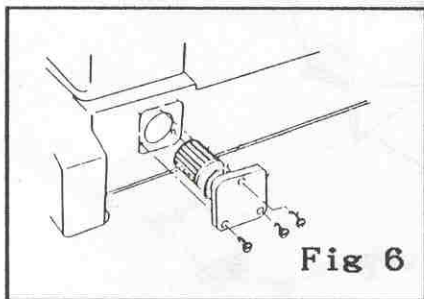


Fig 6

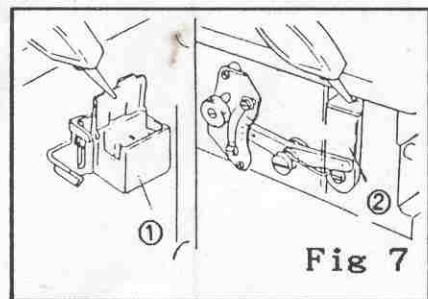


Fig 7

針之更換

1. 選用針之規格與尺寸請參照 (表 2)。
2. 旋開螺絲 (1) 並取下針, 將新針插至針座最底端, 並使針之長溝面向自己。(圖 8)
3. 重新鎖緊螺絲 (1)

HOW TO REPLACE THE NEEDLES

1. See table 2 for the sizes and the specifications of the needles.
2. Loosen screw (1), then pull out the used needles. Insert the new needles into the holder holes as far as they can go, and let the long groove of the needle face you. (Fig 8)
3. Fasten screw (1).

Table 2 (表 2)

NEEDLE SYSTEM 針代號	NEEDLE SIZE/針尺寸	
	2 NEEDLES	3 NEEDLES
SCHMETZ UY128GAS	# 70	# 75
ORGAN 128GAS	# 10	# 11

* 特殊機種針之代號請參考第31頁。

* Needle size of special model, please refer to page 31.

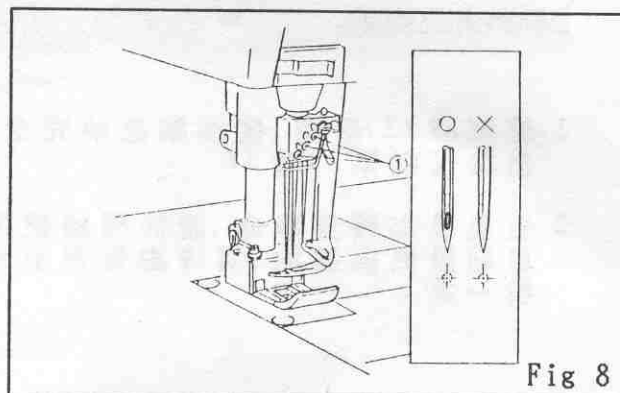


Fig 8

穿線方法

THREADING

請確實按照圖示各種不同縫合情況穿線，錯誤之穿線將引起斷線，跳針或車縫不平坦等現象（圖 9）

Follow the procedures shown in (Fig 9) for threading. Wrong threading may cause thread breaking, skipping stitch, puckering or unexpected sewing.

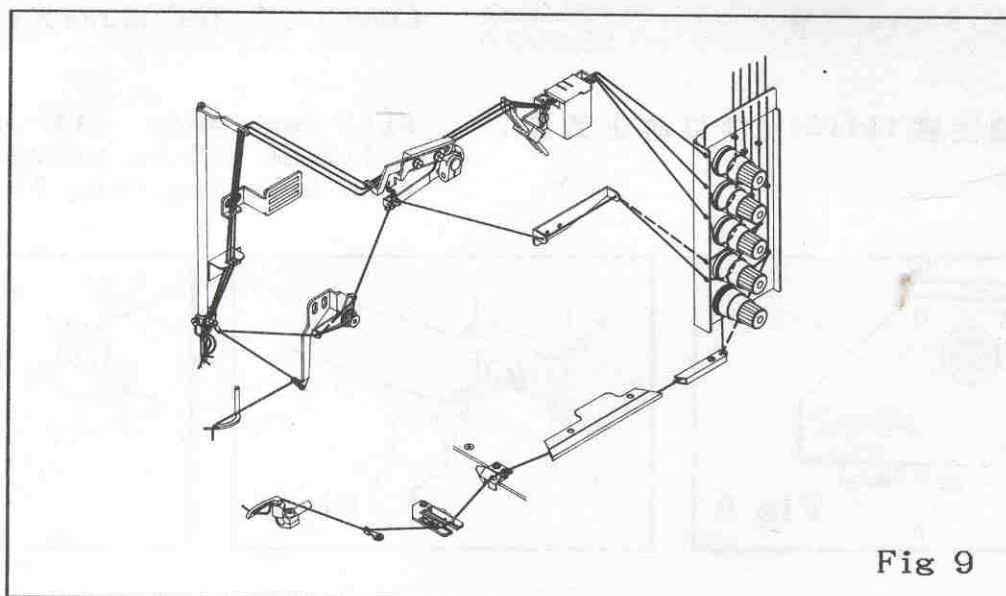


Fig 9

拉線鬆緊度調整

ADJUSTING THREAD TENSION

拉線強弱必須根據車縫布料，料質厚薄，線與針距等不同而做調整。將控制鈕（1）順時鐘方向旋轉時，線越緊反之則越鬆。（圖 10）

The tensions of the threads should be adjusted according to:

1. The material and the thicknesses of the fabrics being sewed;
2. The threads;
3. The needle gauge.

If you turn the thread tension knob clockwise, thread will be tighter. (Fig 10)

If you turn it counter-clockwise, will be looser.

針線控線桿之調整

1. 轉動手輪使針棒位於最低位置時, 針線控線桿擺臂 (1) 的上邊必須成水平, 必要時放鬆螺絲 (4) 調整之。(圖 11)

2. 將螺絲 (2) 鬆開, 調整 A B 兩點的距離約 75mm 後再鎖緊。

註:

欲將針線調鬆時, 將控線桿 (3) 向左方向移動。

欲將針線調緊時, 將控線桿 (3) 向右方向移動。

3. 上叉控線桿 (5) 不要調動。

ADJUSTING NEEDLE THREAD TAKE-UP

1. When the needle bar is in the lowest position, the top edge of the Needle Thread Take-Up should remain horizontal. To adjust the position of the Take-Up, loosen the screw (4) first. (Fig 11)

2. Loosen screw (2) and adjust the length between point A and B to about 75mm, then fasten screw (2) tightly.

Note:

To loosen the needle thread, turn the Needle Thread Take Up (3) toward the left. To tighten turn it toward the right.

3. Do not move the Spreader Thread Take-Up (5) when making above adjustments.

上叉控線桿調整

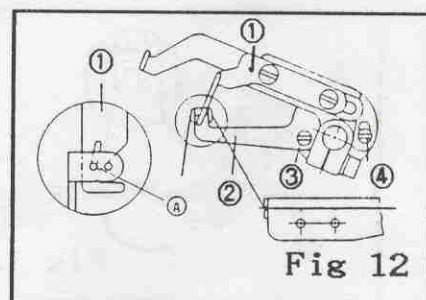
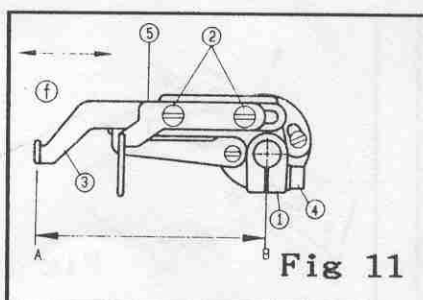
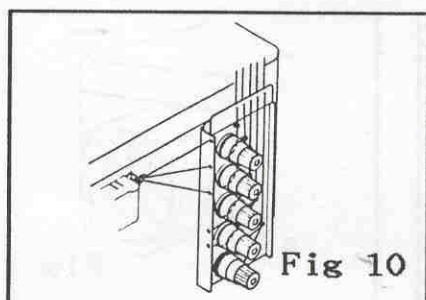
1. 當上叉控線桿 (1) 擺至最高點時, 另一張線桿 (2) 上的小孔 (A) 必須與張線桿 (1) 上之長溝底同高。(圖 12)

2. 必要調整時: 先鬆開螺絲 (3) 及 (4), 上下擺動上叉控線桿 (2), 調整後鎖緊之

ADJUSTING SPREADER THREAD TAKE-UP

1. When the Spreader Thread Take-Up (1) is adjusted to the top, the small hole of the other Spreader Thread Take-Up (A) must be at the same level with the long groove of the Spreader Thread Take-Up (1). (Fig 12)

2. To adjust, loosen screw (3) and (4), and move the Spreader Thread Take-Up (2) up or down, and then, tighten screw again.



押具之調整

鬆開螺絲(1),左右搖動,調整押具(2),使針尖端剛好位於如示之中心點。調整後,再鎖緊螺絲(1)。(圖 13)

ADJUSTING PRESSER FOOT

Loosen screw(1) and adjust Presser Foot(2) left and right to a proper position to let the needle may get into the center of Presser Foot's eyelet.

After adjusting, tighten screw (1) (Fig 13)

縫目長度之調整

縫目長由 1.2至 3.6mm無階段性調整或一英吋 7-18針。

ADJUSTING STITCH LENGTH

Stitch length can be adjusted variably in range from 1.2mm-3.6mm, or 7-18 stitches per inch.

1.用左手壓下按鈕(A),再以右手轉動手輪,直到左手指感覺按鈕嵌入到機器內部卡筍。(圖 14)

1.Keep pressing the push button(A) with your left hand, then turn the handwheel with your right hand until your left hand finger feels the push button lock in.(Fig 14)

2.斷續轉動手輪,選擇所需之縫目長度對準(B)然後放開按鈕。(圖 15)

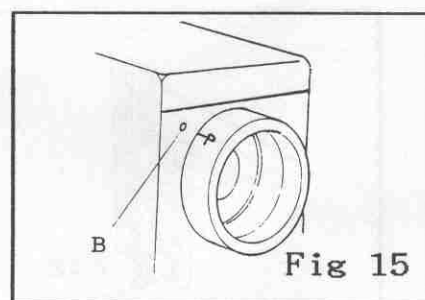
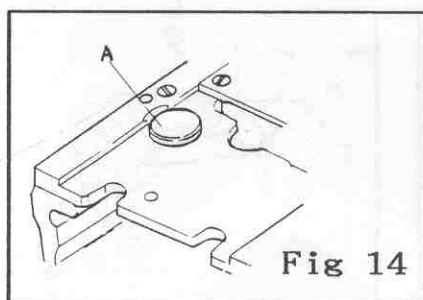
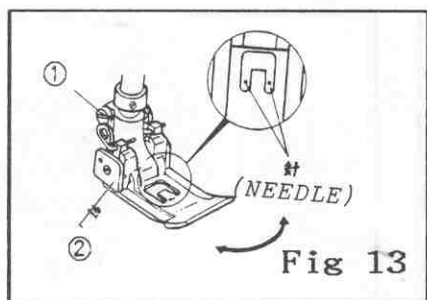
2.Keep turning handwheel for a inquired stitch length, whose scale indicated on the handwheel must be aligned with, then stop pressing the button. (Fig 15)

3.欲調長針距時,將手輪逆時針方向旋轉;反之則小。

3.Turn the handwheel counter-clockwise to increase the stitch length, and clockwise to decrease.

4.針距之調整會使差動比改變,故針距調整後,需接著調整差動比。

4.After adjusting stitch length the differential ratio will usually be changed too. So adjustment of differential ratio is required.



差動比調整

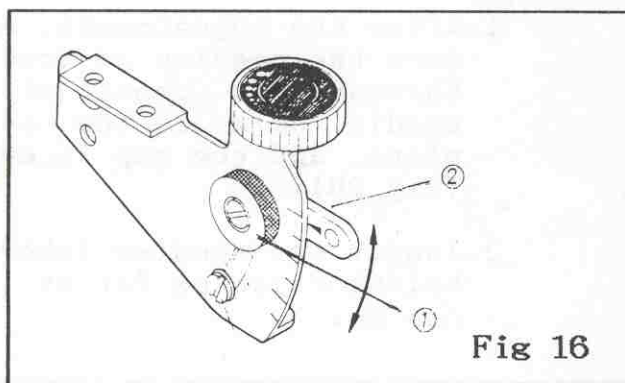
本機器之差動比可從 1:0.3 調整至 1:2.9 鬆開螺母 (2), 上下移動來調整差動比 (圖 16)

- * 要伸張布料車縫時, 則將調整桿 (1) 往上移。
- * 需摺景車縫時, 則將調整桿 (1) 往下移。

押具壓力強度之調整

在布料推送順暢且縫合完美之情況下, 押具壓力儘量輕些。

- * 鬆開螺母 A, 轉動螺絲 B, 調整其適當壓力後再鎖緊螺母。(圖 17)



ADJUSTING DIFFERENTIAL FEED RATIO

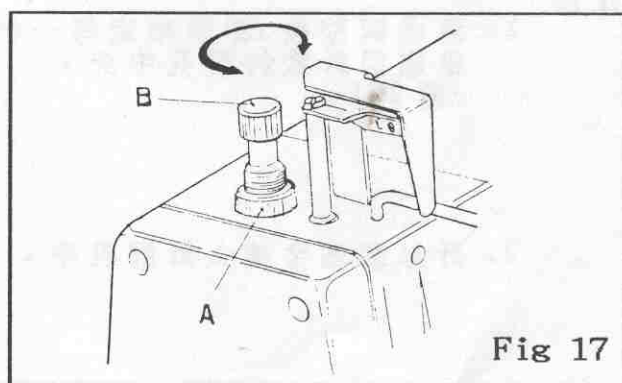
The differential feed ratio of this machine is adjustable from 1:03 to 1:2.9 (Fig 16).

- * To adjust the ratio, loosen the nut (2), move the indicator (1) up or down.
- * To stretch the cloth, move the indicator (1) upward; To gather the cloth, move the indicator (1) downward.

ADJUSTING THE PRESSURE OF PRESSER FOOT

Pressure of the Presser Foot should be as light as possible, so that cloth can be feeded and sewed smoothly.

- * To adjust, loosen nut A, turn screw B for suitable pressure, the fasten nut A. (Fig 17)



針棒高度調整

THE HEIGHT OF NEEDLE BAR

1. 當針棒移至最高點時, 左針尖端與針板面距離如附表 3, 為針棒之標準高度。(圖 18)

1. When the needle bar is moved to the top, the distance between left needle point and the needle plate should be as table 3. This is the standard height of needle bar. (Fig 18)

Tabel 3 (表3)

規格種類 GAUGE SIZE	左針高度(MM) HEIGHT OF LEFT NEEDLE
240	9.0
248	8.7
356	8.2
364	7.8

2. 自前蓋上螺絲孔 (A), 將螺絲起子插入鬆開針棒固定螺絲 (B), 然後上下調整針棒的高度, (圖 19)

2. Use a screw driver insert through holde (A) and loosen screw (B) of Needle Bar Bracket, then adjust the Needle Bar to a proper height. (Fig 19)

注意:

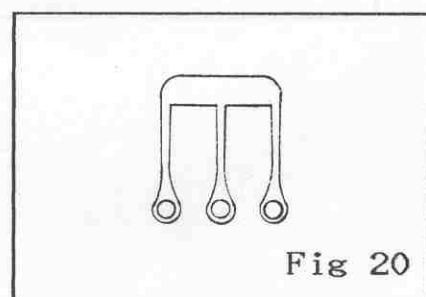
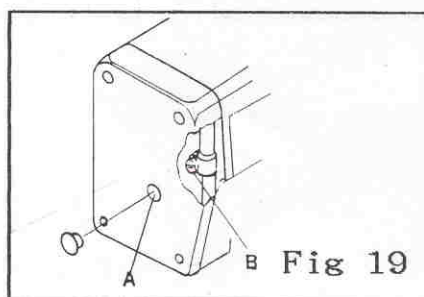
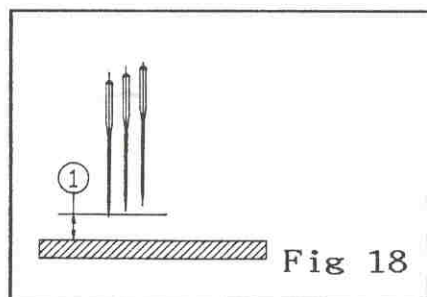
NOTE:

1. 經過調整後, 必須確定每一針是通過針板的針孔中央。(圖 20)

1. After the adjustments, make sure the needles go presses through the center of the needle hole in the needle plate, and the gap is even. (Fig 20)

2. 針必須完全插入針繡孔中。

2. Insert the needles into the holder holes as far as they can go.



針與勾針之時位關係

TIMING OF NEEDLE AND LOOPER

1. 當勾針由右死點往左移至左針中心與針孔上方之距離與勾針由左死點往右回移實左針中心與針孔上方之距離均相等, 此時時位即正確。(圖 21)

1. When the looper moves from the extreme right forward to the center of the left needle, the distance between the looper

top and needle hole should be same as the distance when the looper moves from the extreme left backward to the same position. At this moment, the timing is correctly set.(Fig.21)

2. 勾針高度及角度之決定 (圖 21)

(1) 把勾針上移至與針板正下方時，
使勾針與針板之間相距為
0.8-1mm.

(2) 勾針之角度與針水平連線成 2.5° .

3. 針與勾針間隙之關係 (圖 22)

勾針由右往左移至中心時，其中針間隙為 0.00mm，右針為 0.1-0.2mm 再往左移至左死點後回到右死點再移至右針時與右針微接觸約 0.15-0.2，則勾針前後運動之軌跡為正橢圓。

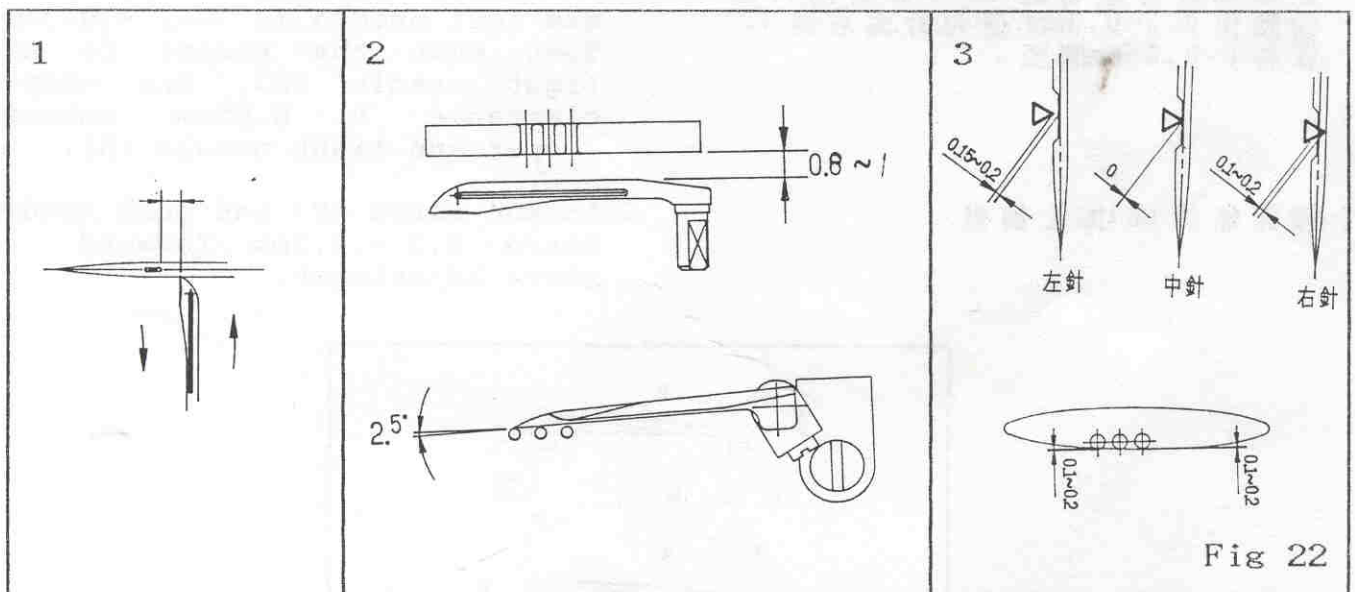
2. Correct height and angle of Looper (Fig.21)

(1) When the Looper moves below the Needle Plate, the distance between the Looper and Needle Plate should be about 0.8 - 1mm.

(2) The angle between the Looper and the correcting line should remain at 2.5° .

3. Relations between looper and needles in motion. (Fig.22)

When the looper moves from right end forward to the middle needle the clearance between is 0; when the looper moves from the extreme left end and backward to right needle, the clearance between the looper and needle is about 0.15-0.2mm. The orbit of looper's motion is in the shape of a regular ellipse.



- 3 針車 -

1. 當勾針 (A) 由右移至左邊時, 其針端 (E), 與中間針 (C), 幾乎接觸 (約 0 - 0.05mm)
2. 調整前, 請拆下右針 (B), (圖 22)
3. 鬆開勾針座上之螺絲 (F) 後, 如上調整距離。
4. 調整後, 將左針 (B) 再裝上, 假如此針與勾針有所接觸, 請調整針護片向前方壓出 0.2 - 0.3mm 距離使 (B) 針與勾針之間之距離在 0 - 0.05mm 間。

- FOR 3 NEEDLES MACHINES -

1. When the Looper moves to the left with its point meeting with the middle needle (C), the clearance between the Looper point and needle should be 0 - 0.5mm.
2. Before adjusting, please remove right needle from needle clamp. (Fig 22)
3. Loosen screw (F) and adjust accordingly.
4. After adjusting insert the right needle back to needle clamp. If the needle touches looper, please push the needle guard 0.2-0.3mm forward to allow the standard clearance between needles (B) and Looper remain 0 - 0.05mm.

- 2 針車 -

1. 當勾針尖端 (E) 與左針 (H) 中心相遇時, 勾針針端與左針之距離為 0.2-0.3mm, 之後勾針移至右針 (G) 中心針護片向前壓出 0.2-0.3mm, 使勾針與右針 (G) 保持 0-0.05mm 間隙。

- FOR 2 NEEDLES MACHINES -

1. When the Looper point (E) meets with the left needle (H), the clearance between Looper point and left needle is 0.2 - 0.3mm. Then move the Looper to the right needle (G), and keep a clearance 0 - 0.05mm between looper and right needle (G).
2. Loosen screw (F) and push needle Guard 0.2 - 0.3mm forward for above adjustment.

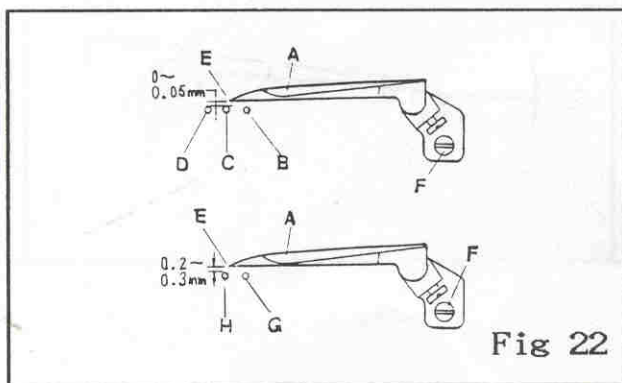


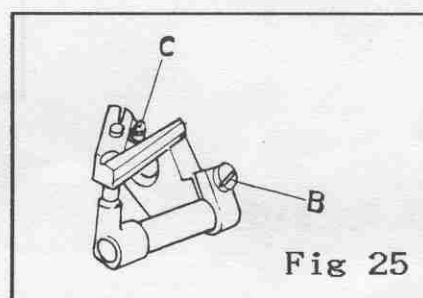
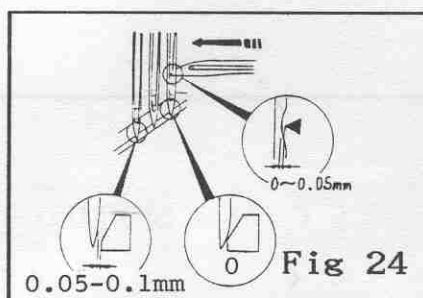
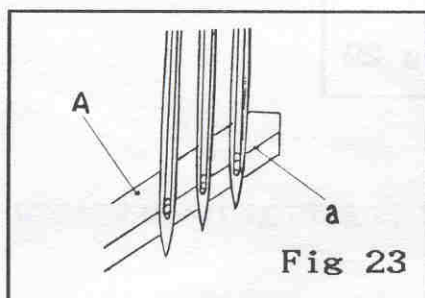
Fig 22

針與後護針片調整

ADJUSTING NEEDLE AND REAR NEEDLE GUARD

1. 後護針片之高度 -
當針棒移至最低位置時，護針片 (A) 的 (a) 線，位於針孔之中心線上。
(圖 23)
2. 後護針片之位置 -
當勾針針尖移到右針中心線時，針與勾針之間隙為 0-0.05mm。移至左針中心時左針與針頂之間隙為 0.05-0.1mm。
(圖 24)
3. 鬆開螺絲 (B)，(C) 按上述調整正確之位置。(圖 25)

1. The height of Rear Needle Guard -
When the Needle Bar goes down to the lowest position, the line (a) of the Needle Guard (A) should be at the center of needle's eyelet. (Fig 23)
2. When looper point comes near to the center of right needle the clearance 0-0.5mm between them. When Looper point comes near to the center of left needle the clearance is 0.05-0.1mm between left needle and rear needle guard. (Fig 24)
3. Loose screw (B) (C) for above adjustment. (Fig 25)

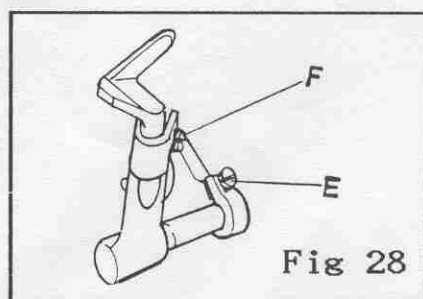
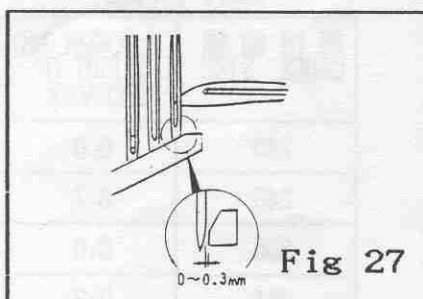
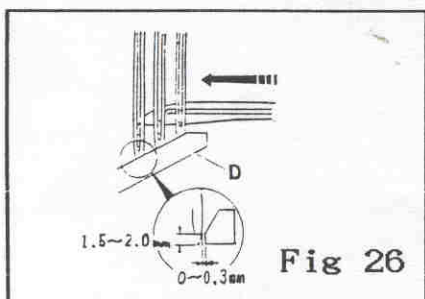


針與前護針片調整

ADJUSTING NEEDLE AND FRONT NEEDLE GUARD

1. 當勾針針端移到左針針中心線時，針的尖端在 1.5-2.0mm 的位置，而針與前護針片 (D) 之間距為 0-0.3mm，又當勾針退到右針中心的位置時，針與前護針片 (D) 的距離亦為 0-0.3mm。
(圖 26, 27)
2. 鬆開螺絲 (E) 與 (F) 如上述之位置調整。
(圖 28)

1. When looper point shift to the center of left needle it should be set about 1.5 - 2.0mm higher than the left needle point. The clearance 0-0.3mm between needle and Front Needle Guard should be left. (Fig 26, 27)
2. Loose screw (E) & (F) for above adjustment. (Fig 28)

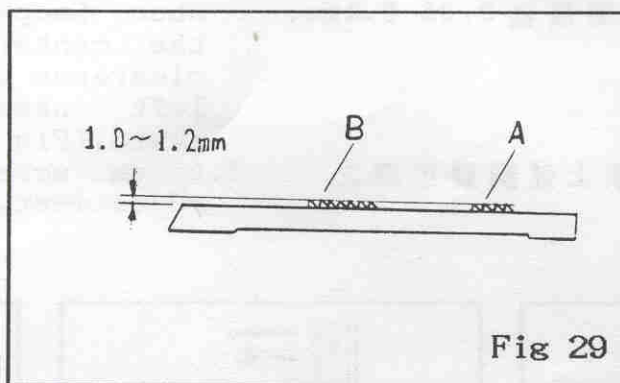


送布齒高度調整

ADJUSTING THE HEIGHT OF FEED DOG

當布齒在最高位置時,送布齒齒尖面與針板面平行,此時主送布齒(A)與差動送布齒(B),高度相同且齒面與針板面差1.0-1.2mm。(圖 29)

When the Feed Dog rises up to the highest position, the surface of Feed Dog is parallel to the surface of Needle Plate, besides, the teeth of main and differential Feed Dog must be aligned the standard height of Feed Dog is about 1.0 - 1.2mm from its top teeth to Needle Plate. (Fig 29)



上叉之設定

SETTING THE POSITION OF SPREADER

1.當上叉由右往左邊移時,上叉之勾線尖端(a)與左針之距離為0.3-0.5mm,當上叉(A)移至最左時,上叉勾線之尖端(a)與左針中心線距為4.5-5.5mm。(圖 31)

1. When the Spreader moves from the right to the left there will be a clearance 0.3 to 0.5mm between thread hooking point of Spreader and left needle. When Spreader (A) shifts to the extreme of the left, the clearance between the center of left needle and thread hooking point (a) of Spreader should be 4.5 to 5.5mm. (Fig 31) Please note, under 4.0mm, may cause skip thread.

4.0mm以下時左針針線由於上叉線之壓力易造成或左針跳線。

2.上叉之下端面與針板面之距離如附表4。(圖 32)

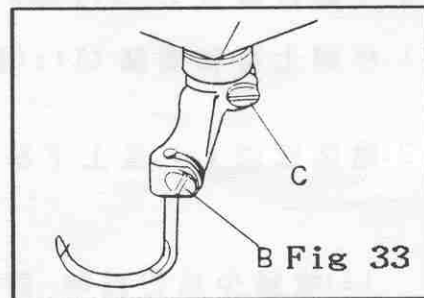
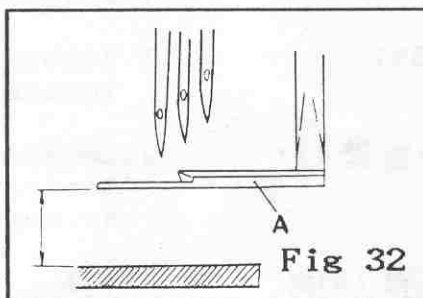
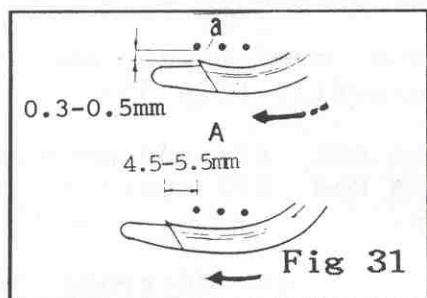
2. The distance between the bottom face of Spreader to the surface of Needle Plate as table 4 (Fig 32)

Table 4 (表4)

規格種類 GAUGE SIZE	上叉高度(MM) HEIGHT OF SPREADER
240	9.0
248	8.7
356	8.0
364	7.7

3.請鬆開螺絲 (B), (C) 依上述之情況調整。(圖 33)

3. Loose screw (B) and (C) for above adjustment. (Fig 33)



上叉導板位置之調整

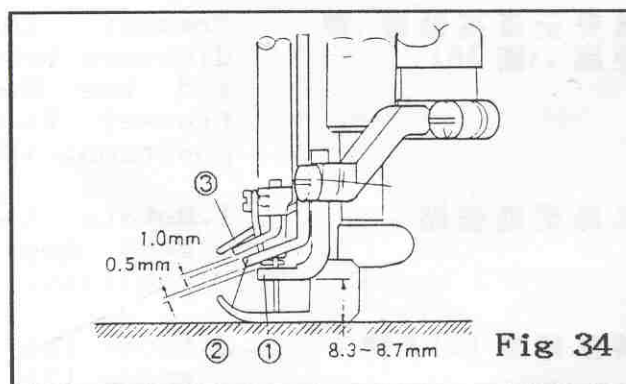
SETTING THE POSITION OF SPREADER THREAD GUIDE

1. 當針棒移至最低點時, 上叉導板 (2) 之線溝剛好在導線片 (3) 孔之下方, 且上叉導板 (2) 與上叉 (1) 之間隙 0.5mm. (圖 34)

1. When the needle bar is in its lowest position, the Thread Guide should be set just below the eye of the guide (3). And the clearance between Thread Guide (2) and the Spreader (1) should be set to 0.5mm. (Fig 34)

2. 當針棒移至最低位置時, 導線片 (3) 與上叉導板 (2) 之距離為 1.0mm 且線孔與線溝必須相對。(圖 34)

2. When the Needle Bar moves to its lowest position, the clearance should be 1.0mm between the Spreader Thread Guide (2) and the Thread Guide (3). The concavity of the Spreader and the thread eye should face each other. (Fig 34)



上叉行程調整

ADJUSTING THE SPREADER'S STROKE

上叉的行程是 17-17.5mm

The spreader stroke is 17-17.5mm.

1.移開上蓋和螺絲 (1); (圖 35)

1. Remove the arm cover and the loosen screw (1). (Fig 35)

2.鬆開螺絲 (2), 並上下移動連桿 (3)

2. Loosen the nut (2) and move the Connecting Rod (3) upwards or downwards.

(a) 欲減少其行程時, 將連桿 (3) 向上移;

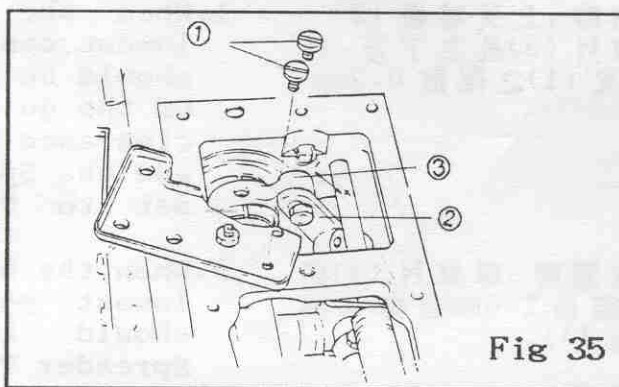
(a) In order to decrease the Spreader's stroke, move the Connecting Rod (3) upwards.

(b) 欲增加其行程時, 將連桿 (3) 向下移。

(b) In order to increase the Spreader's stroke, move the Connecting Rod (3) downwards.

調整後, 將上述螺絲鎖緊。

After adjustments, remember to fasten the above said screws.



押具提升調整

ADJUSTING PRESSER FOOT LIFT

押具提升是指當押具升至最高點時, 押具底面與針板間之距離。(圖 36)

Presser foot lift means the distance between the Presser Foot and the Needle Plate when the Presser Foot is at its highest position. (Fig 36)

1. 旋轉手輪使送料具降至最低點。

1. Rotate the handwheel for the Feed Dogs move to the lowest position;

2. 鬆開螺帽 (1), 並轉動螺絲 (2) 下降。

2. Loose the nut (1) and lower the screw (2);

3. 降低連桿 (3), 使押具提升至適當之高度

3. Lower the lever (3) and raise the Presser Foot to the proper height

4.調整後即上升螺絲(2)至頂至連桿(3),
並固定螺絲(1)。

* W 型 -- 行程 5 mm.

* U 型 -- 行程 7 mm.

4. After the adjustments as above,
raise the screw (2) up to touch
the lever (3) and tighten the nut
(1) to lock the position.

* W type timing 5mm.

* U type timing 7mm.

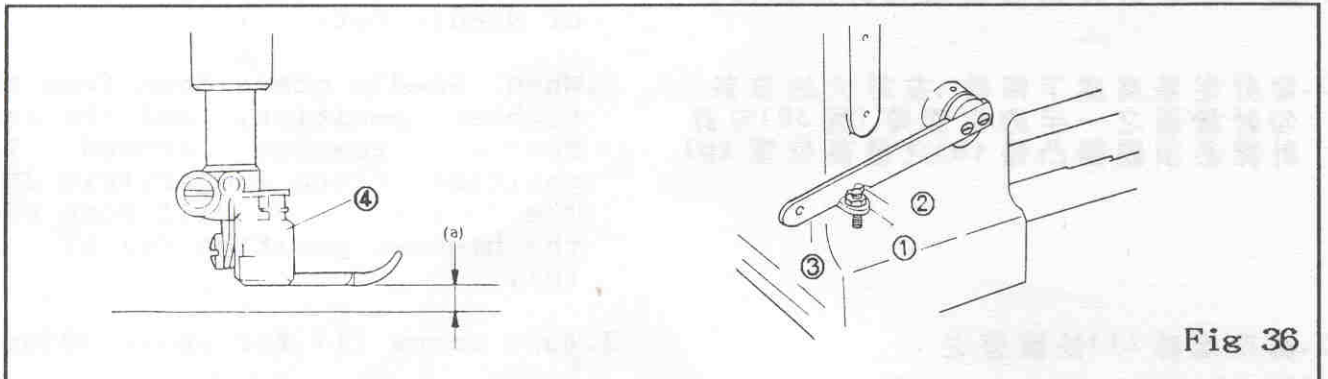


Fig 36

勾針線調整

ADJUSTMENT OF LOOPER THREAD

1. 勾針線控制桿的支撐片上的符號(D)
必須與線孔(E)與(F)成一直線。(圖 37)

* 欲增加勾針線量時,線導片(G)與(H)
向上移動。

* 欲減少勾針線量時,線導片(G)與(H)
向下移動。

2. 請特別注意,過多的勾針線量,可能造
成跳針,所以這種調整必須恰到好處。

3. 如果使用呢絨線,移動線導片(G),(H)
到最前端,且不經過過線組(K)。(圖 37)

1. The counter mark (D) which was
shown on the supporting plate of
Looper Thread Take-up must
be aligned with thread guide
(E) and (F). (Fig 37)

* To increase the Take-Up
amount of looper thread move
guide (G) and (H) upward.

* To decrease the Take-Up
amount of Looper Thread move
guide (E) and (F) downward.

2. Please note, excessive take-up
amount may cause skip stitch, so
this adjustment must be set
properly.

3. If using woolly thread, please
move forward (G) and (H) to the
top. And, the thread doesn't
have to pass under the tension
disc (K). (Fig 37)

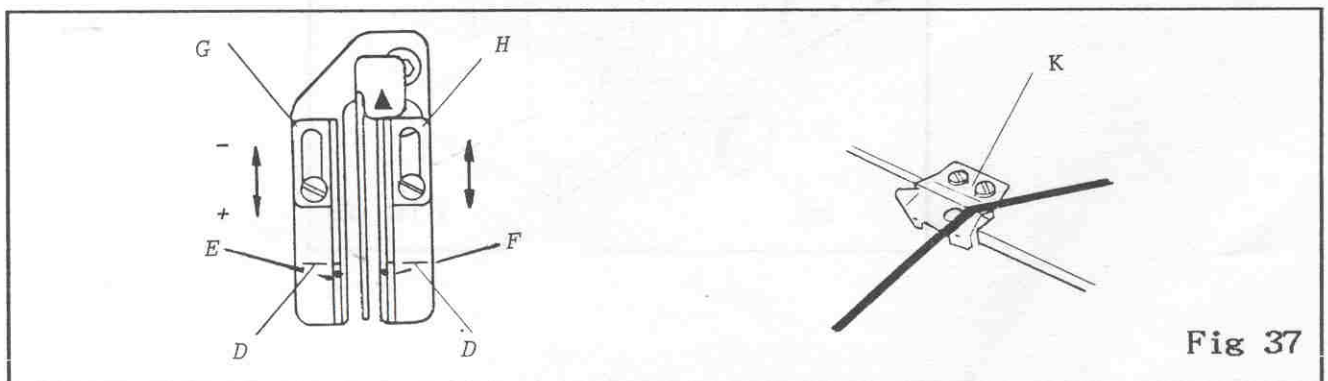


Fig 37

勾針控線桿的位置

THE POSITION OF LOOPER THREAD TAKE-UP

1.圖 38是從針棒側面觀察勾針控線凸輪。

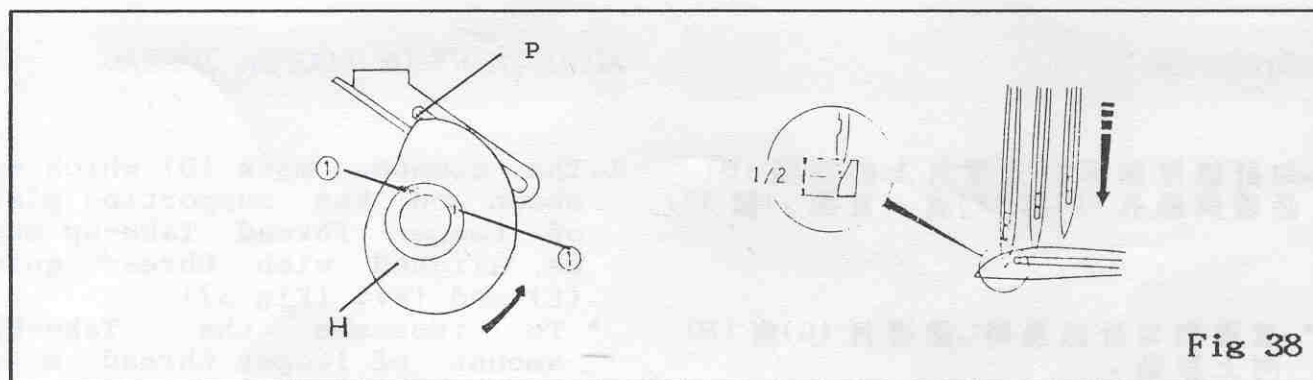
1. Fig. 38 is viewed from the side of Needle Bar.

2.當針從最高處下降時,左針大約位於勾針後面之半的位置時(圖 38)勾針針線必須脫離凸輪(H)之最高位置(P)

2. When Needle comes down from the highest position, and the left Needle reaches around 1/2 position of the looper. (Fig 38) The looper thread will come over the highest position (P) of cam (H).

3.調整螺絲(1)並調整之。

3. Turn screw (1) for above adjustment.

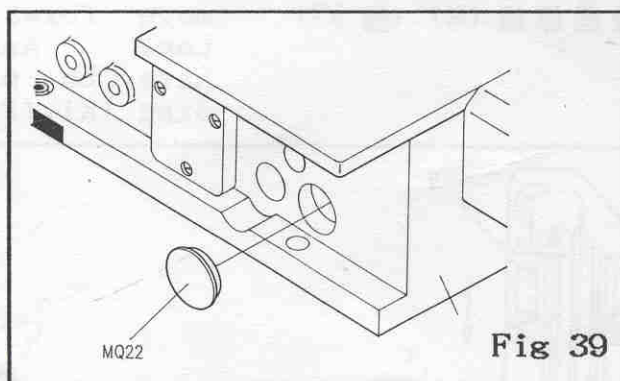


棉屑之清除

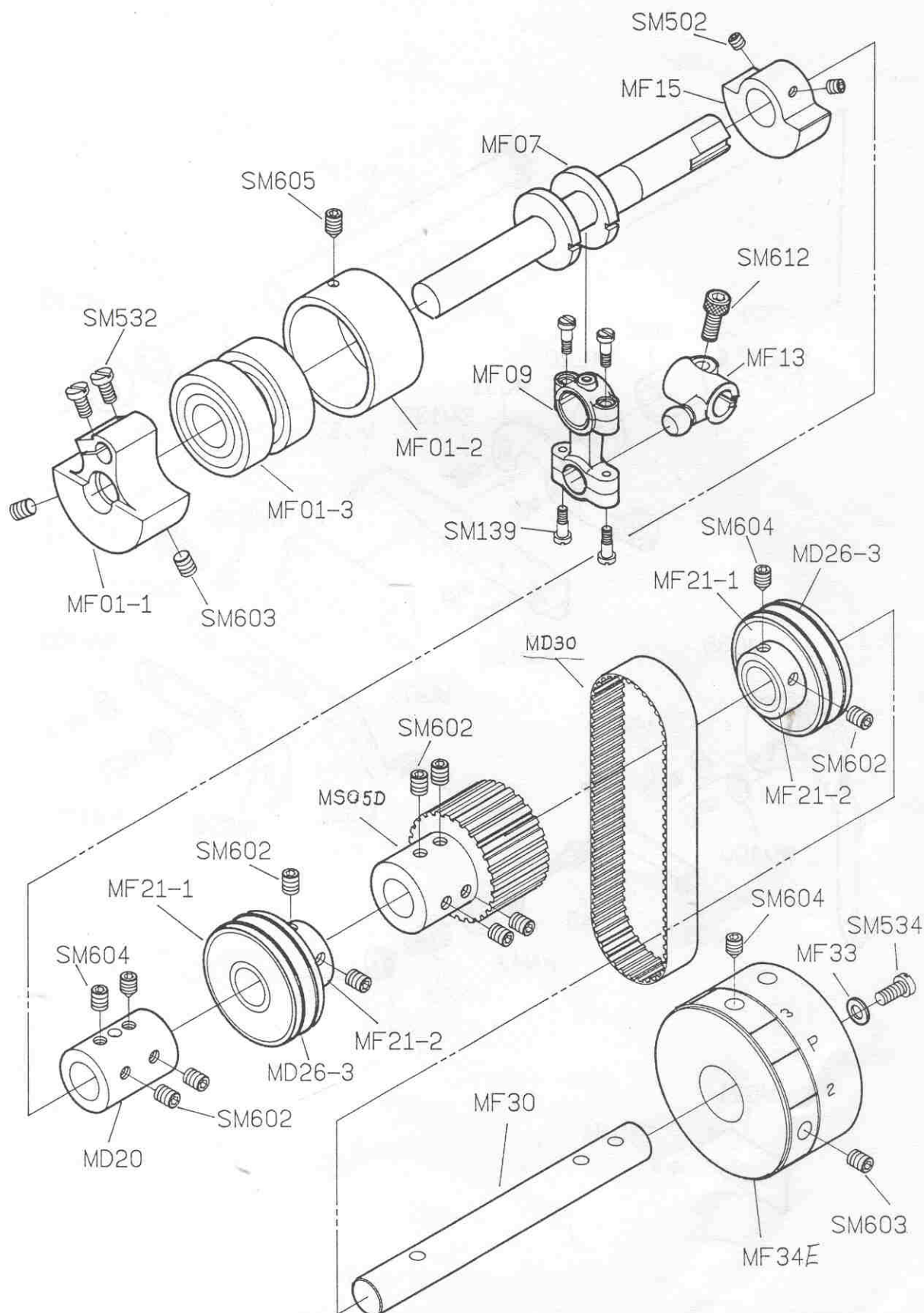
CLEAN UP DUST

請定期打開MQ22,清除棉屑,以維護機器壽命。(圖39)

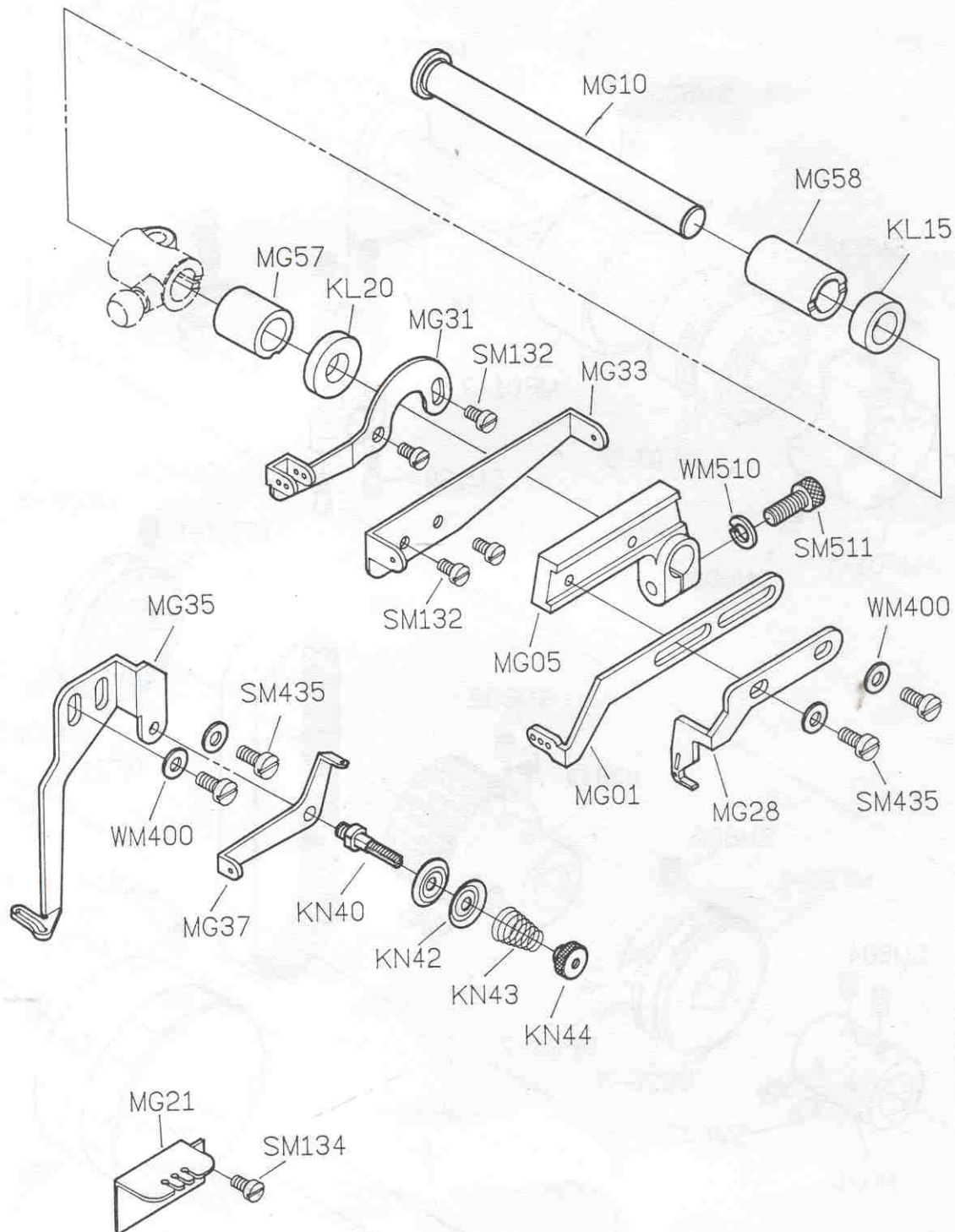
Please unplug the stopper, clean up dust and waste every month. (Fig. 39)



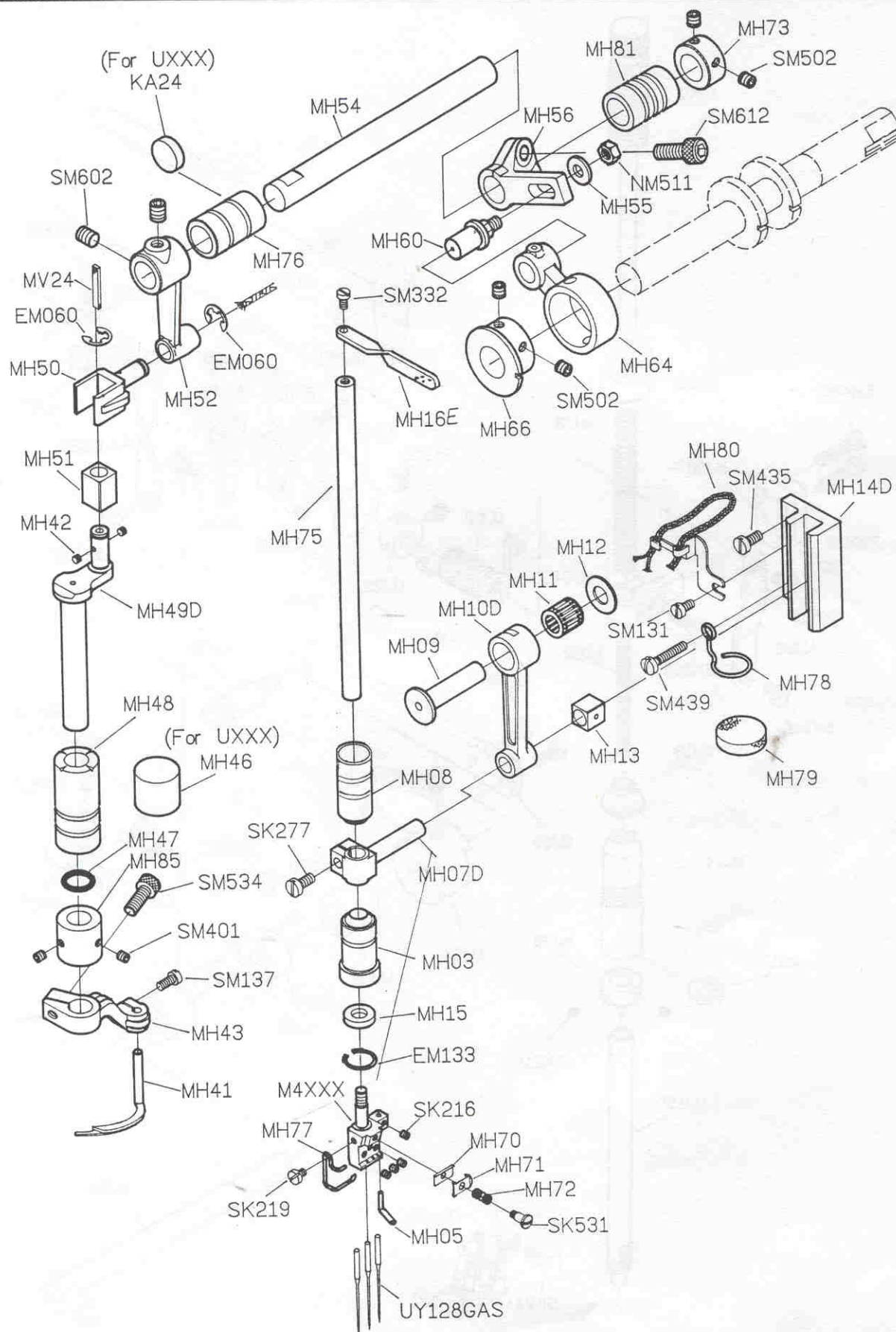
PARTS LIST FOR MF GROUP



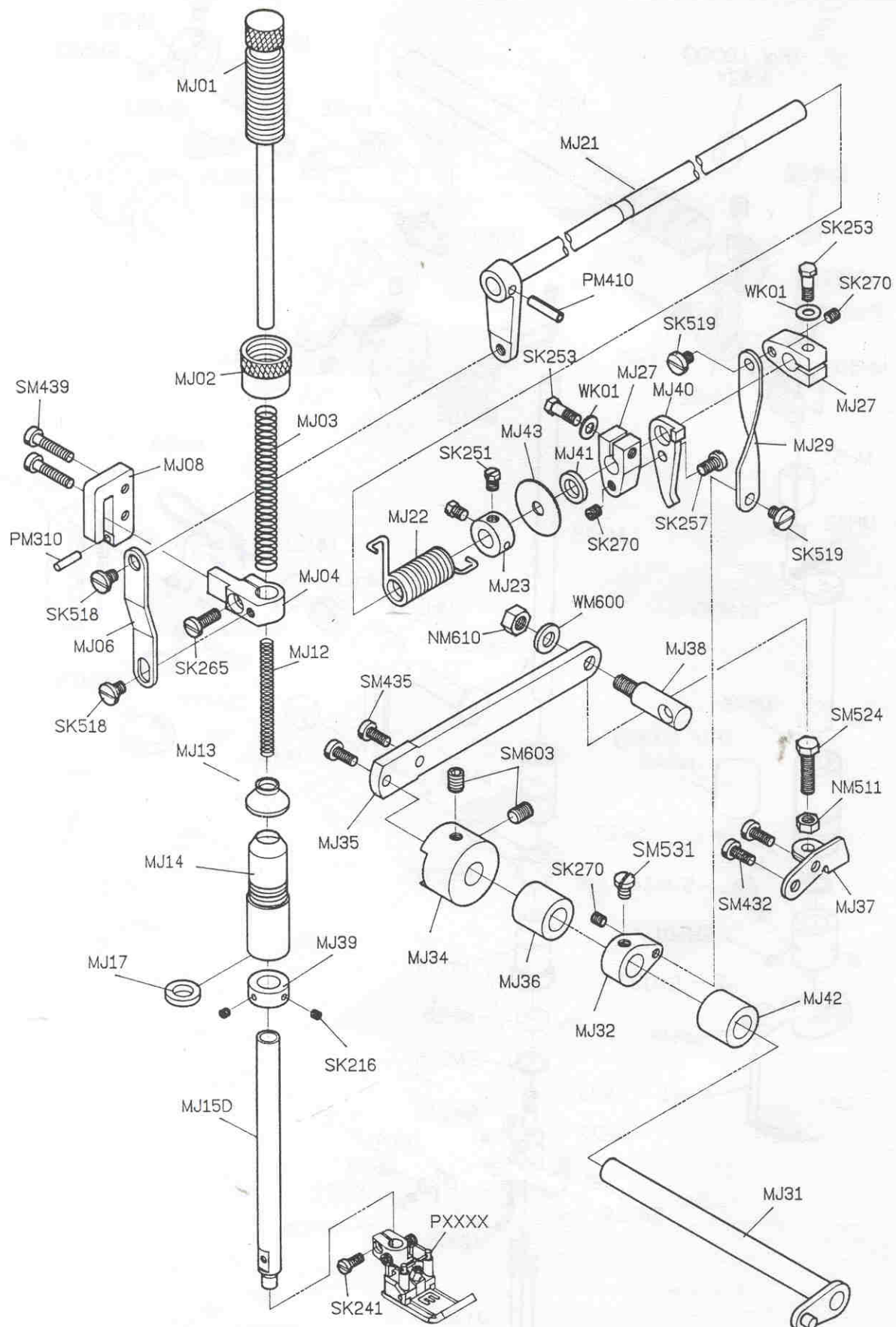
PARTS LIST FOR MG GROUP



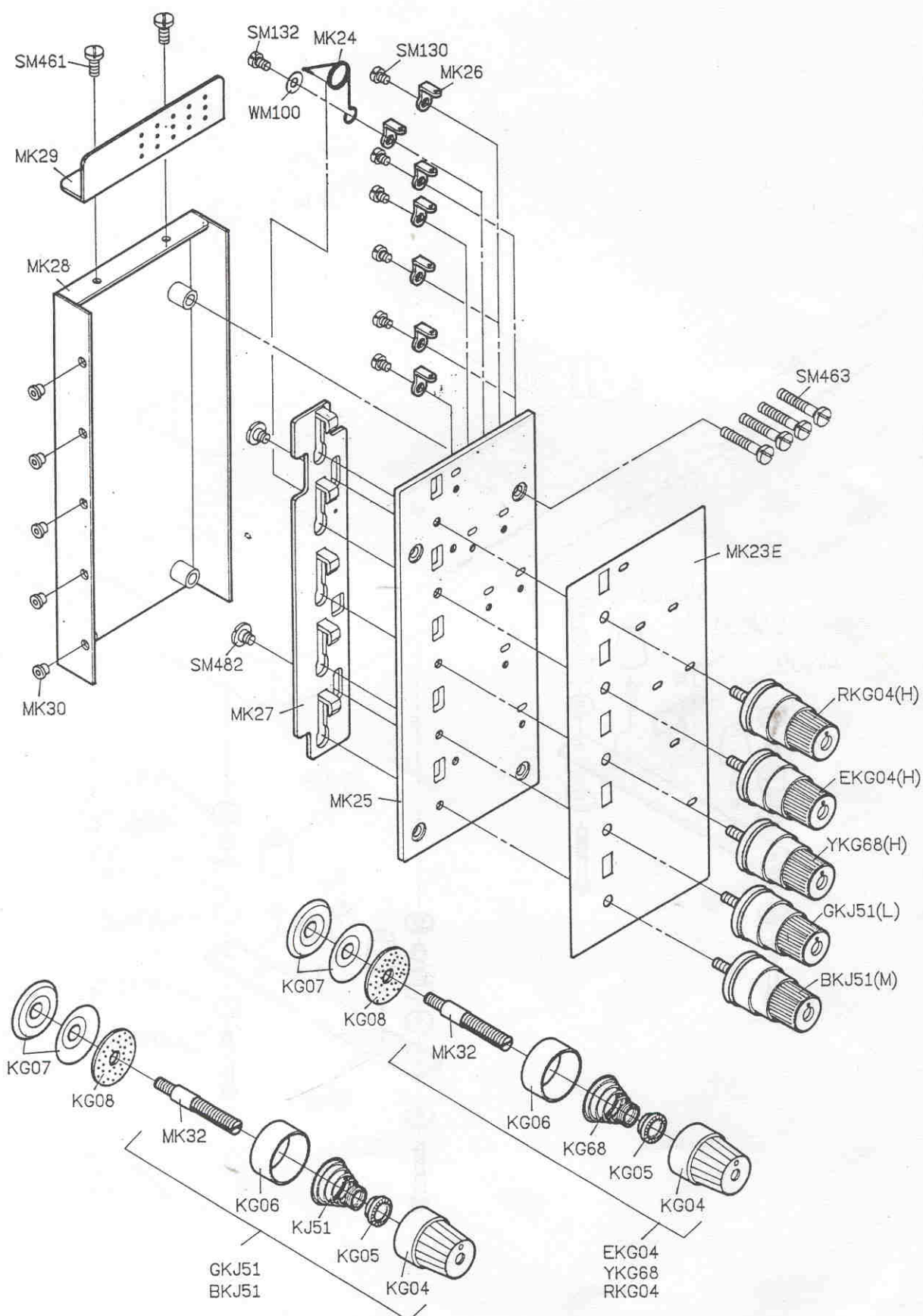
PARTS LIST FOR MH GROUP



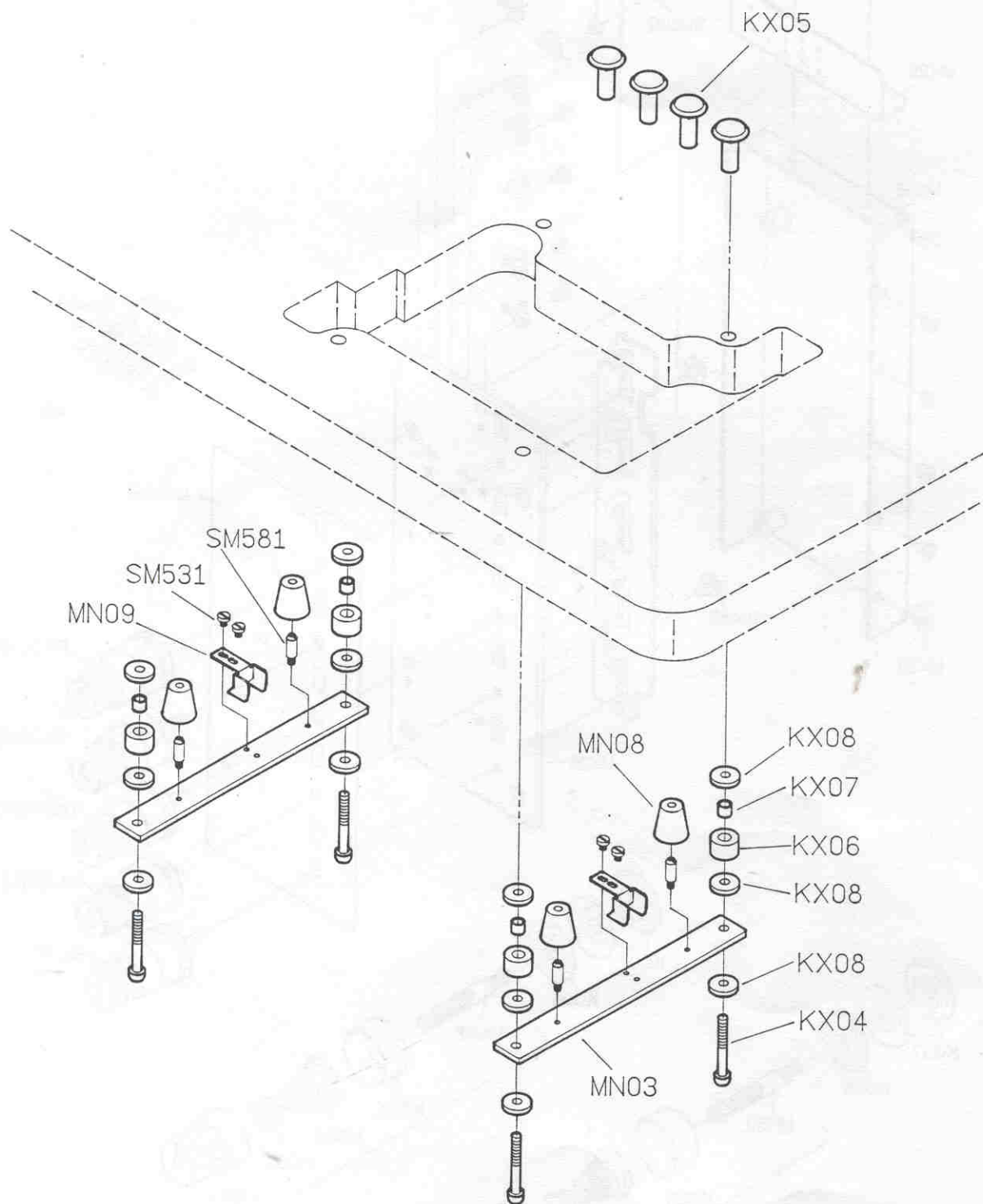
PARTS LIST FOR MJ GROUP



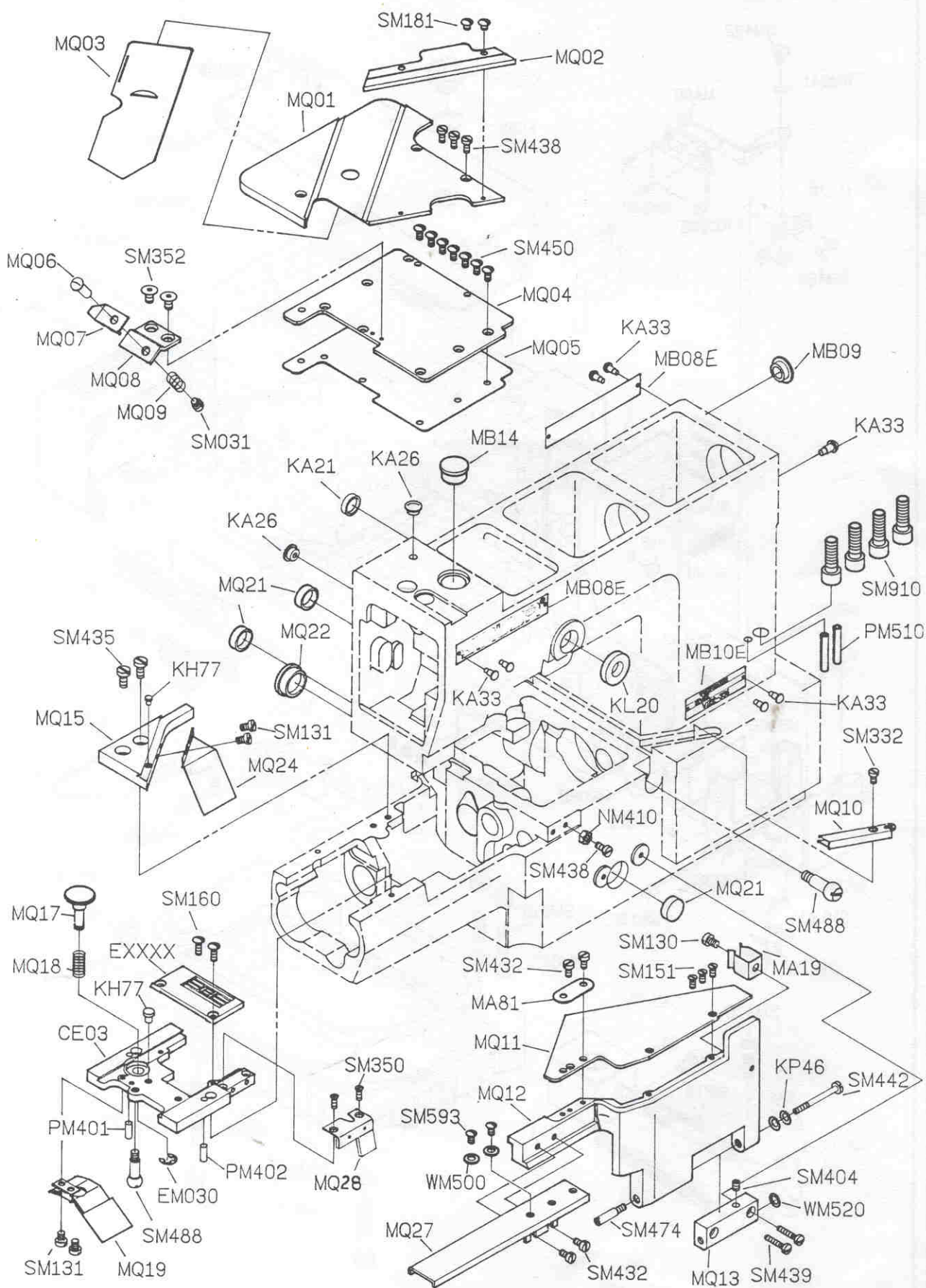
PARTS LIST FOR MK GROUP



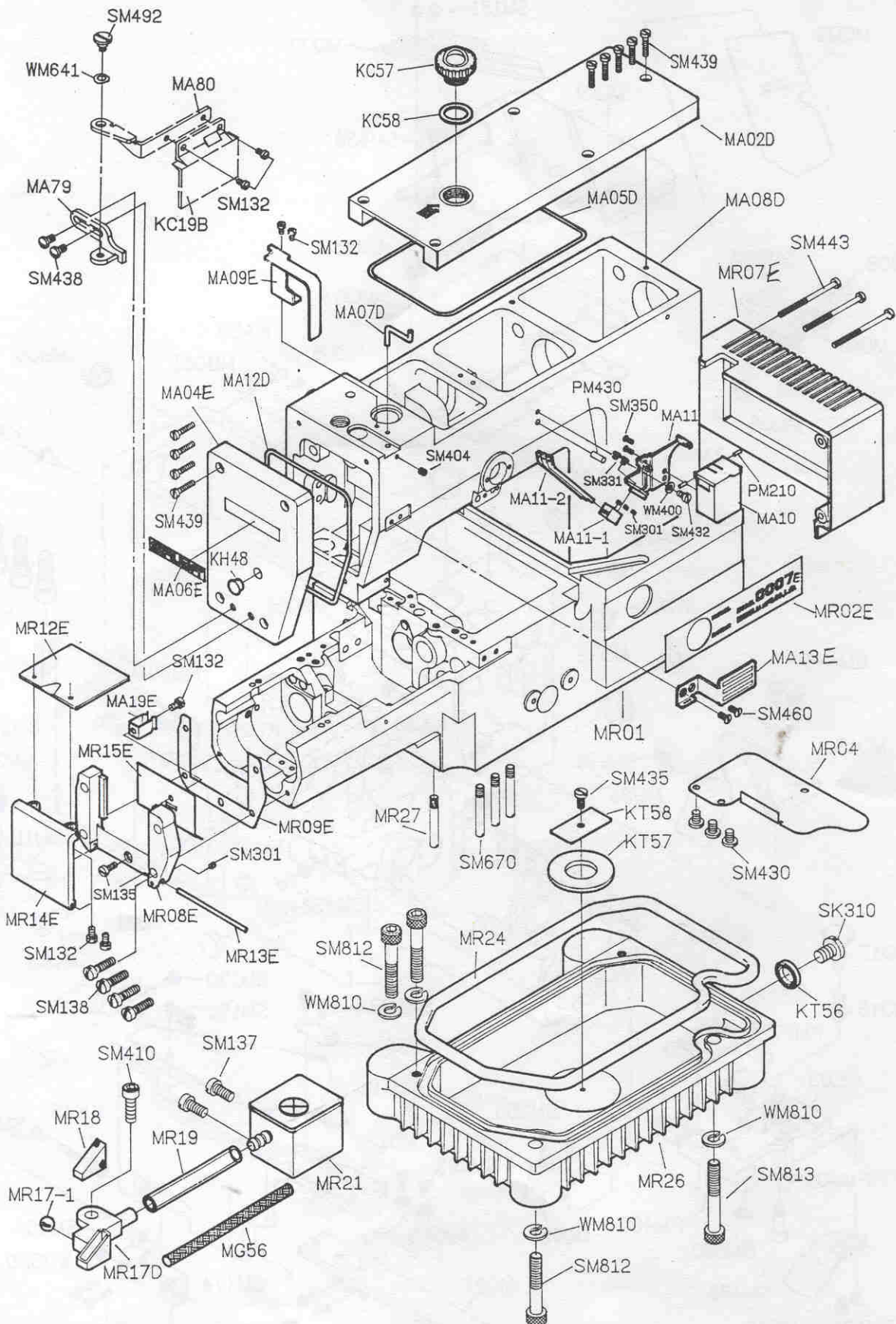
PARTS LIST FOR MN GROUP



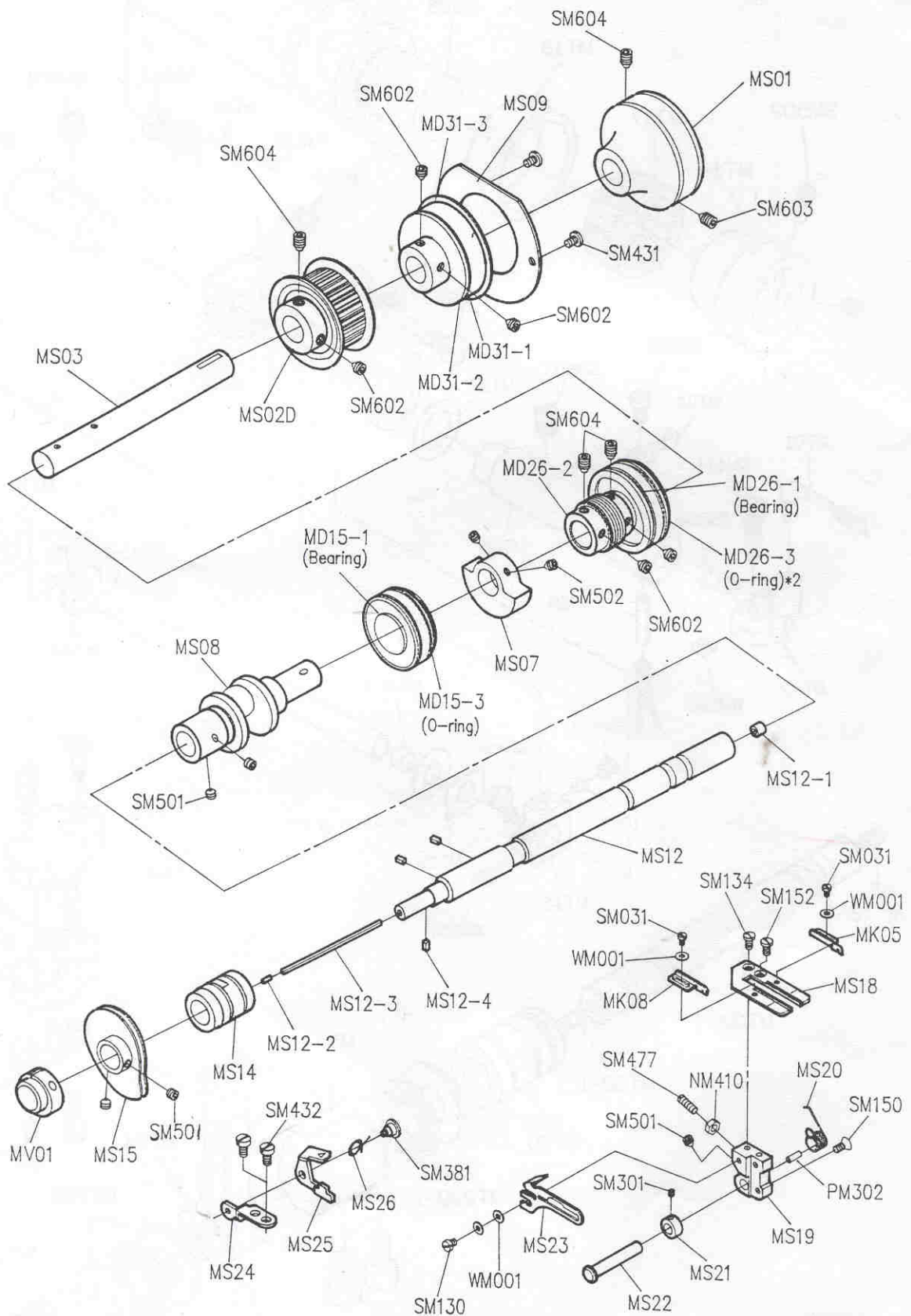
PARTS LIST FOR MQ GROUP



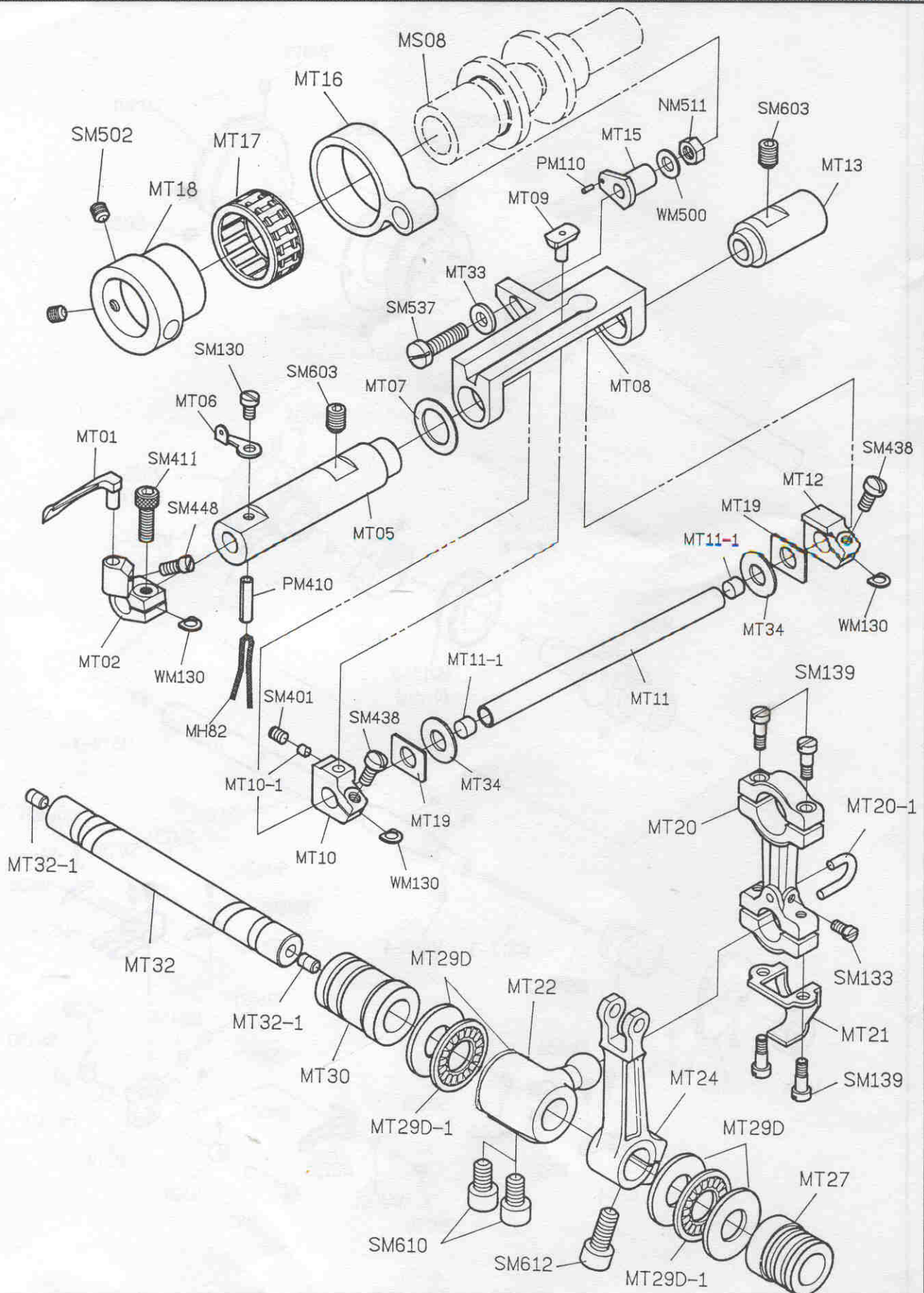
PARTS LIST FOR MR GROUP



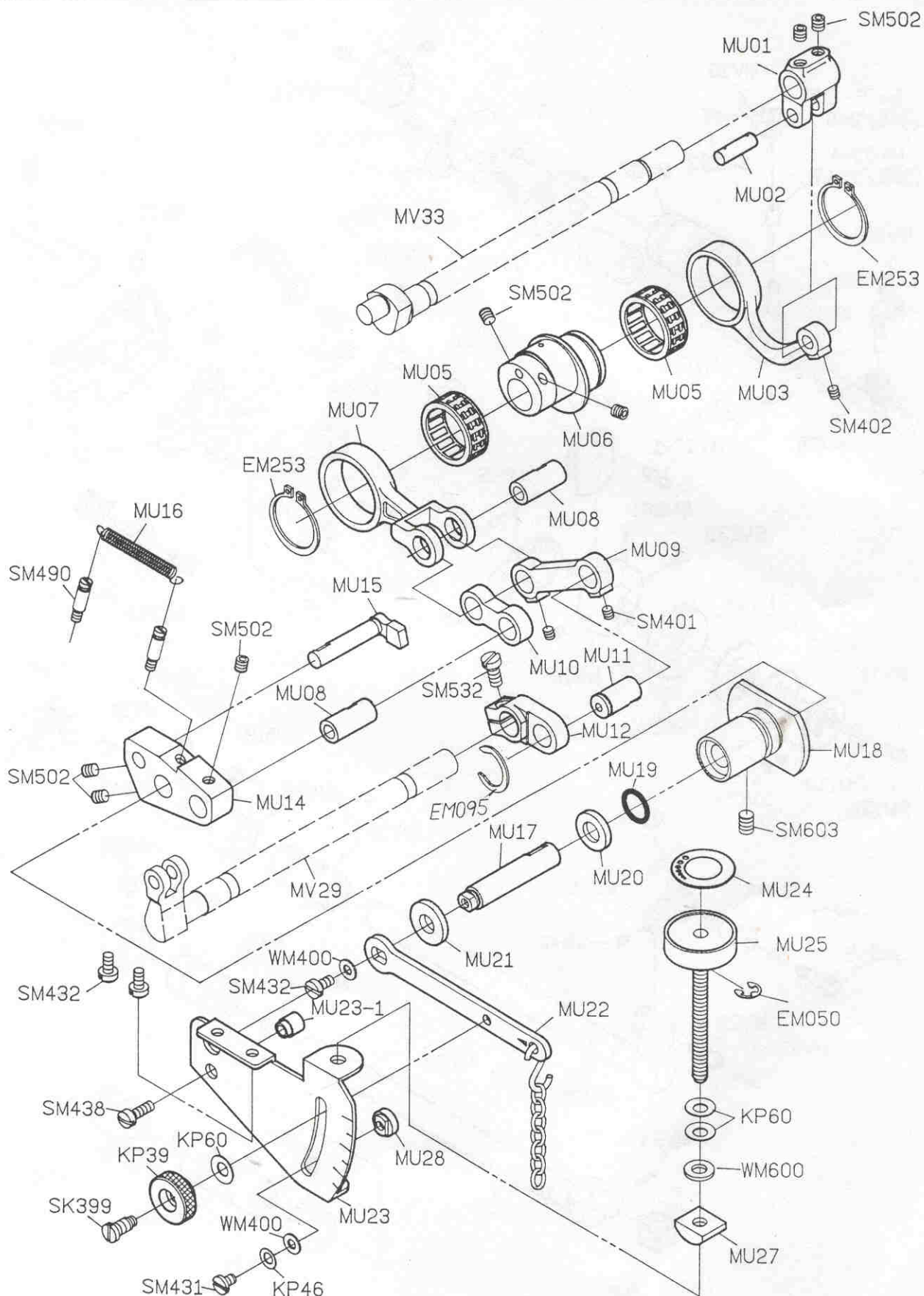
PARTS LIST FOR MS GROUP



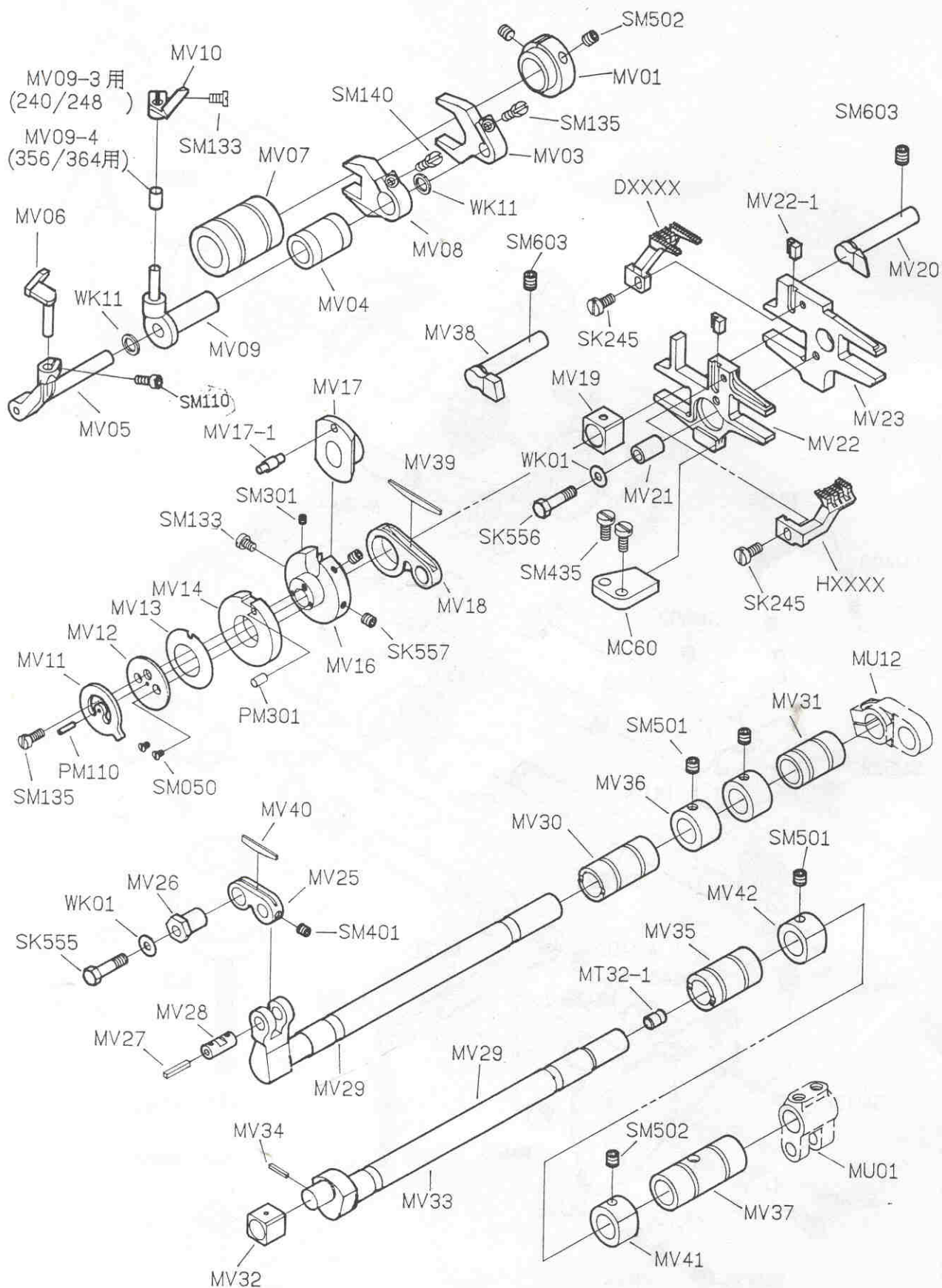
PARTS LIST FOR MT GROUP



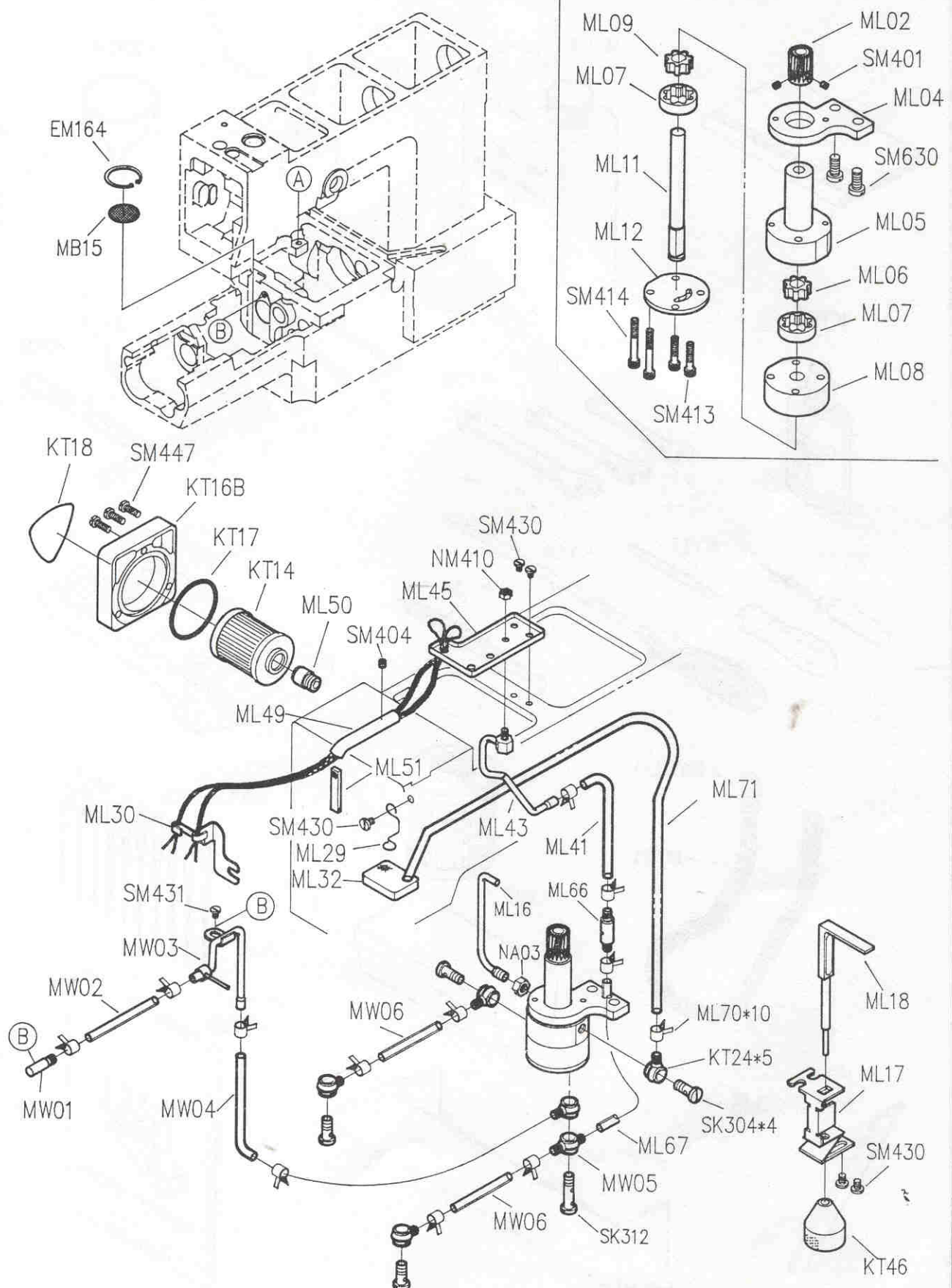
PARTS LIST FOR MU GROUP



PARTS LIST FOR MV GROUP



PARTS LIST FOR MW GROUP



PARTS LIST FOR MY GROUP

MY01



MY02



KY03



KY04



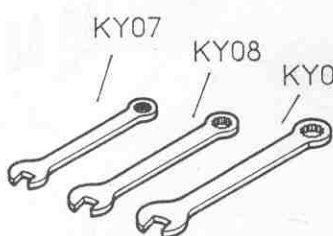
KY05



KY07

KY08

KY09



MY09

MY08

MY10

MY11

MY12

KY11

1.5

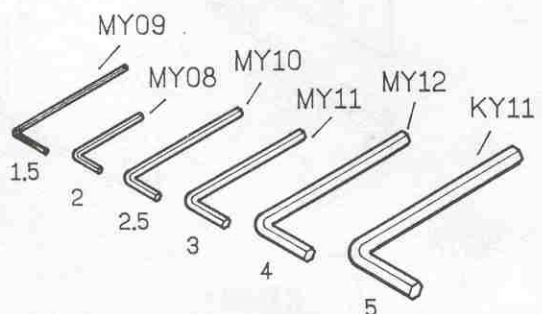
2

2.5

3

4

5

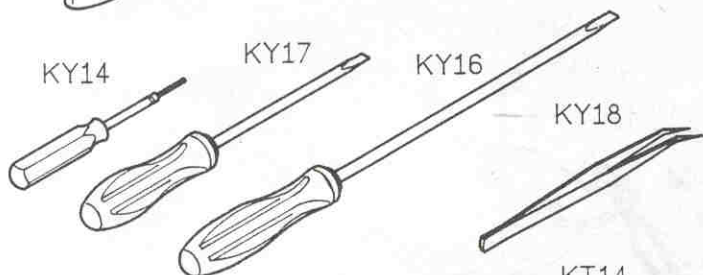


KY14

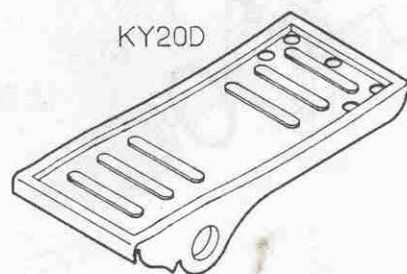
KY17

KY16

KY18



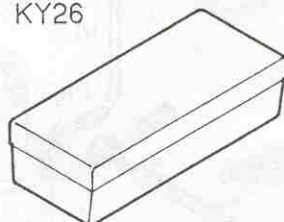
KY20D



KT14

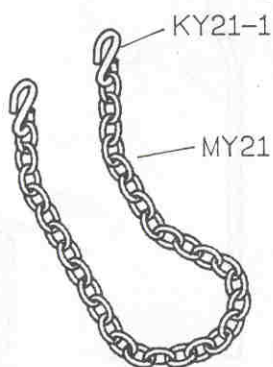


KY26

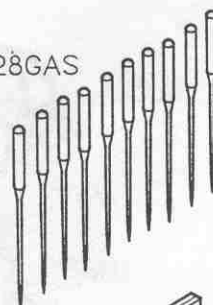


KY21-1

MY21

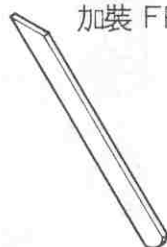


UY128GAS

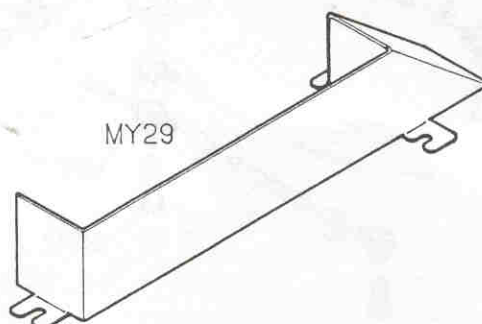


FR40

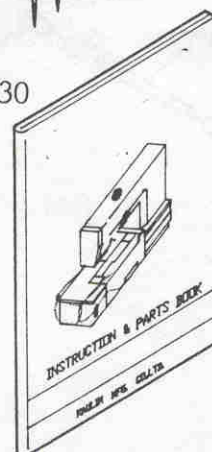
加裝 FR 時用



MY29



MY30

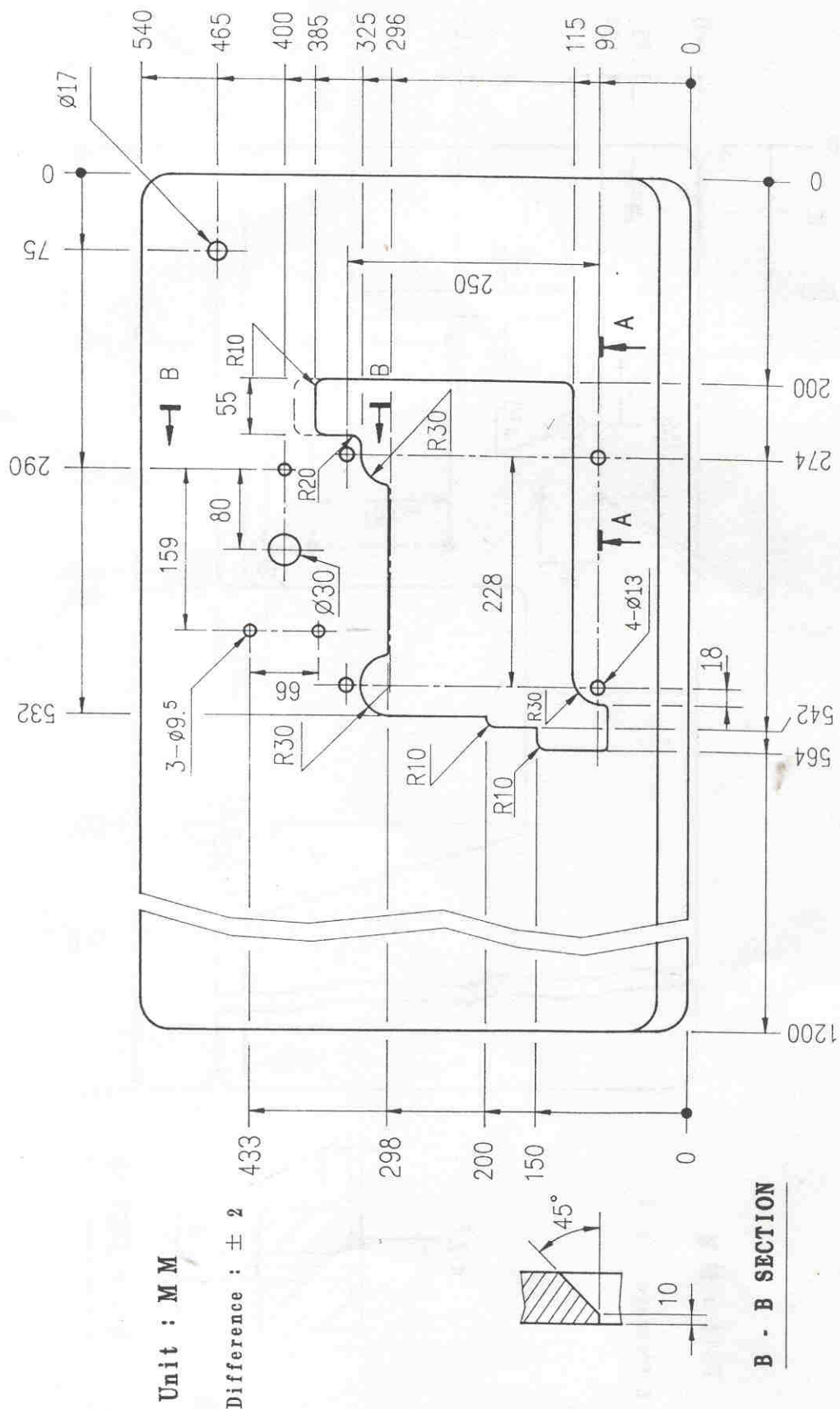


SPARE PARTS CONVERSION CHART

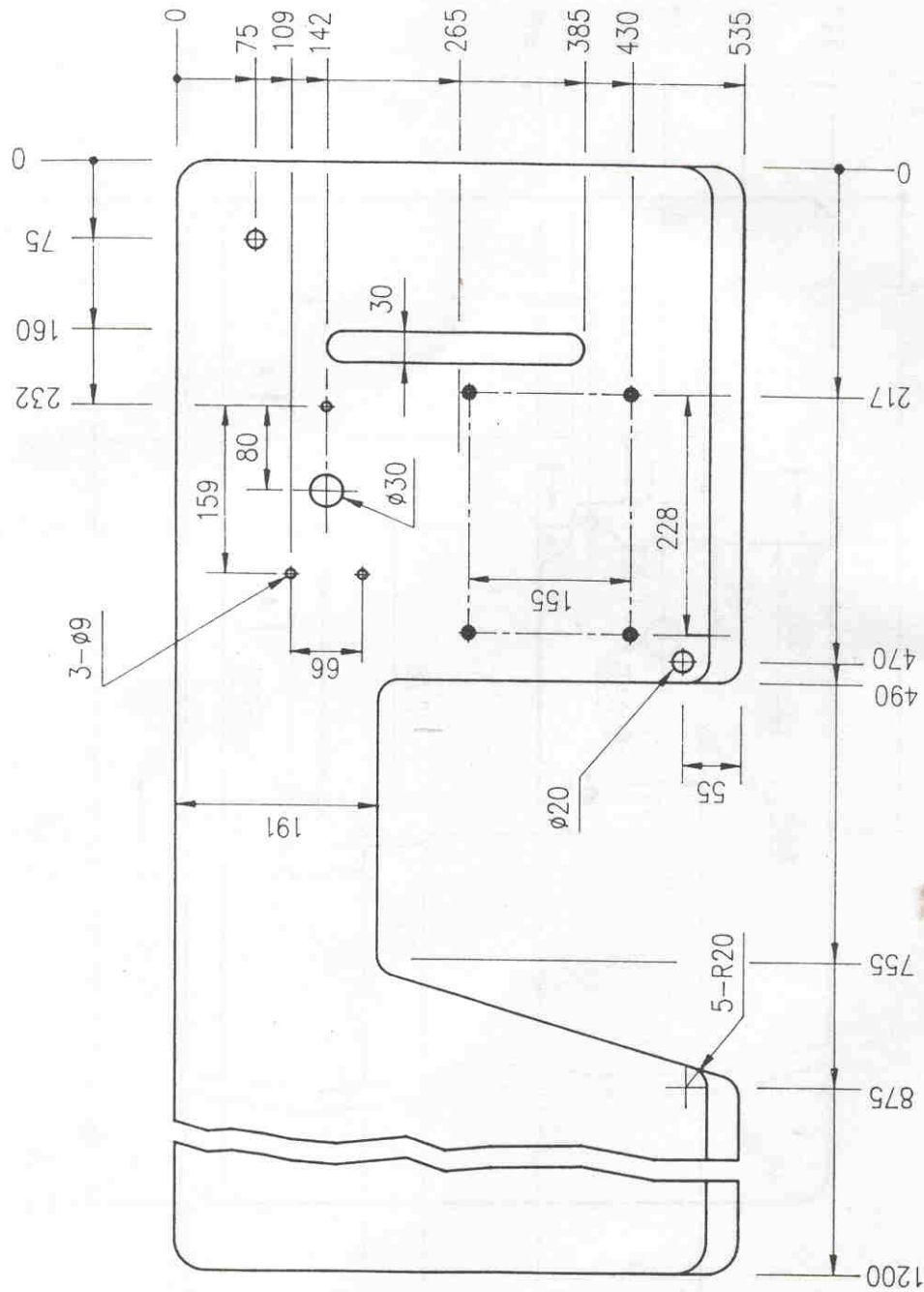
MODEL CYLINDER BED	GAUGE SIZE	NEELDE CLAMP	NEEDLE PLATE	MAIN FEED DOG	DIFF. FEED DOG	PRESSER FOOT	SPREADER	NEEDLE UY128GAS
W122	240 248 256 356 364	M4240 M4248 M4356 M4356 M4364	E3524 E3525 E3826S E3826 E3827	D4206 D4206 D4206 D4206 D4207	H4258 H4258 H4258 H4258 H4259	P0014 P0015 P0116 P0116 P0117	MH41	#10 #10 #11 #11 #11
U122	240 248 356 364	M4240 M4248 M4356 M4364	E3524 E3525 E3826 E3827	D4206 D4206 D4206 D4207	H4258 H4258 H4258 H4259	P0214 P0215 P0316 P0317	----	#10 #10 #11 #11
W122 /UTP	240 248 356 364	M4240 M4248 M4356 M4364	E3524P E3525P E3826P E3827P	D4206 D4206 D4206 D4207	H4258 H4258 H4258 H4259	P0014 P0015 P0116 P0117	UT99	#10 #10 #11 #11
U122 /UTQ	240 248 356 364	M4240 M4248 M4356 M4364	E3524P E3525P E3826P E3827P	D4206 D4206 D4206 D4207	H4258 H4258 H4258 H4259	P0214 P0215 P0316 P0317	----	#10 #10 #11 #11
W222 /CQ	240 248 356 364	M4240 M4248 M4356 M4364	E4024 E4025 E4326 E4327	D3216 D3216 D3216 D3217	H3262 H3262 H3262 H3263	P1814 P1815 P2116 P2117	MH41	#10 #10 #11 #11
U222 /CQ	240 248 356 364	M4240 M4248 M4356 M4364	E4024 E4025 E4326 E4327	D3216 D3216 D3216 D3217	H3262 H3262 H3262 H3263	P2314 P2315 P2616 P2617	----	#10 #10 #11 #11
W322 /CC	356 364	M4356 M4364	E2826M E2827M	D2107L D2107L	H3259M H3259M	P2406 P2407	MH41	#11 #11
U322 /CC	356 364	M4356 M4364	E2826M E2827M	D2107L D2107L	H3259M H3259M	P2406 P2607	----	#11 #11
W322 /CC/UTP	356 364	M4356 M4364	E2826P E2827P	D2107L D2107L	H3259M H3259M	P2406 P2607	MH41	#11 #11
U322 /CC/UTQ	356 364	M4356 M4364	E2826P E2827P	D2107L D2107L	H3259M H3259M	P2406 P2407	----	#11 #11
W322 /CD	356 364	M4356 M4364	E3636 E3627	D4206 D4207	H4158 H4159	P1406 P1407	MH41	#11 #11
U322 /CD	356 364	M4356 M4364	E3636 E3627	D4206 D4207	H4158 H4159	P1606 P1607	----	#11 #11
W322 /CE	356 364	M4356 M4364	E2626 E2627	D1207	H3159	P1406 P1407	MH41	#11 #11
U322 /CE	356 364	M4356 M4364	E2626 E2627	D1207	H3159	P1406 P1407	----	#11 #11
W322 /CE/UTP	356 364	M4356 M4364	E2626P E2627P	D1207	H3159	P1406 P1407	UT99	#11 #11
U322 /CE/UTQ	356 364	M4356 M4364	E2626P E2627P	D1207	H3159	P1606 P1607	----	#11 #11
U322 /CF	248	M4348	E2625	D1206	H3158	P1605	----	#10

MODEL CYINDER BED	GAUGE SIZE	NEELDE CLAMP	NEEDLE PLATE	MAIN FEED DOG	DIFF. FEED DOG	PRESSER FOOT	SPREADER	NEEDLE UY128GAS
W522 /FE(FFC)	240 356 364	M4240 M4356 M4364	E3524 E3826 E3827	D4206 D4206 D4207	H4258 H4258 H4259	P2914 P3216 P3217	MH41	#10 #11 #11
U522 /FE(FFC)	240 356 364	M4240 M4356 M4364	E3524 E3826 E3827	D4206 D4206 D4207	H4258 H4258 H4259	P3414 P3716 P3717	----	#10 #11 #11
W822 /CRL/CY	356 364	M4356 M4364	E0226 E0227	D2101 D1101	H2203 H2203	P2746 P2747	MH41	#11 #11
U822 /CRL/CY	356 364	M4356 M4364	E0226 E0227	D2101 D1101	H2203 H2203	P0946 P0946	----	#11 #11
W822 /CRL/CY /UTP	356 364	M4356 M4364	E0226P E0227P	D2101 D1101	H2203 H2203	P2746 P2747	UT99	#11 #11
W822 /CRL/CY /UTP	356 364	M4356 M4364	E0226P E0227P	D2101 D1101	H2203 H2203	P0946 P0947	----	#11 #11

TBBLE CUT-OUT NO. C007-T

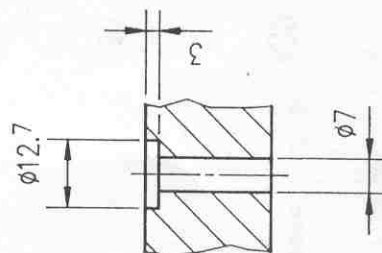


TBBLE CUT-OUT NO. C007-T1



Unit : M M

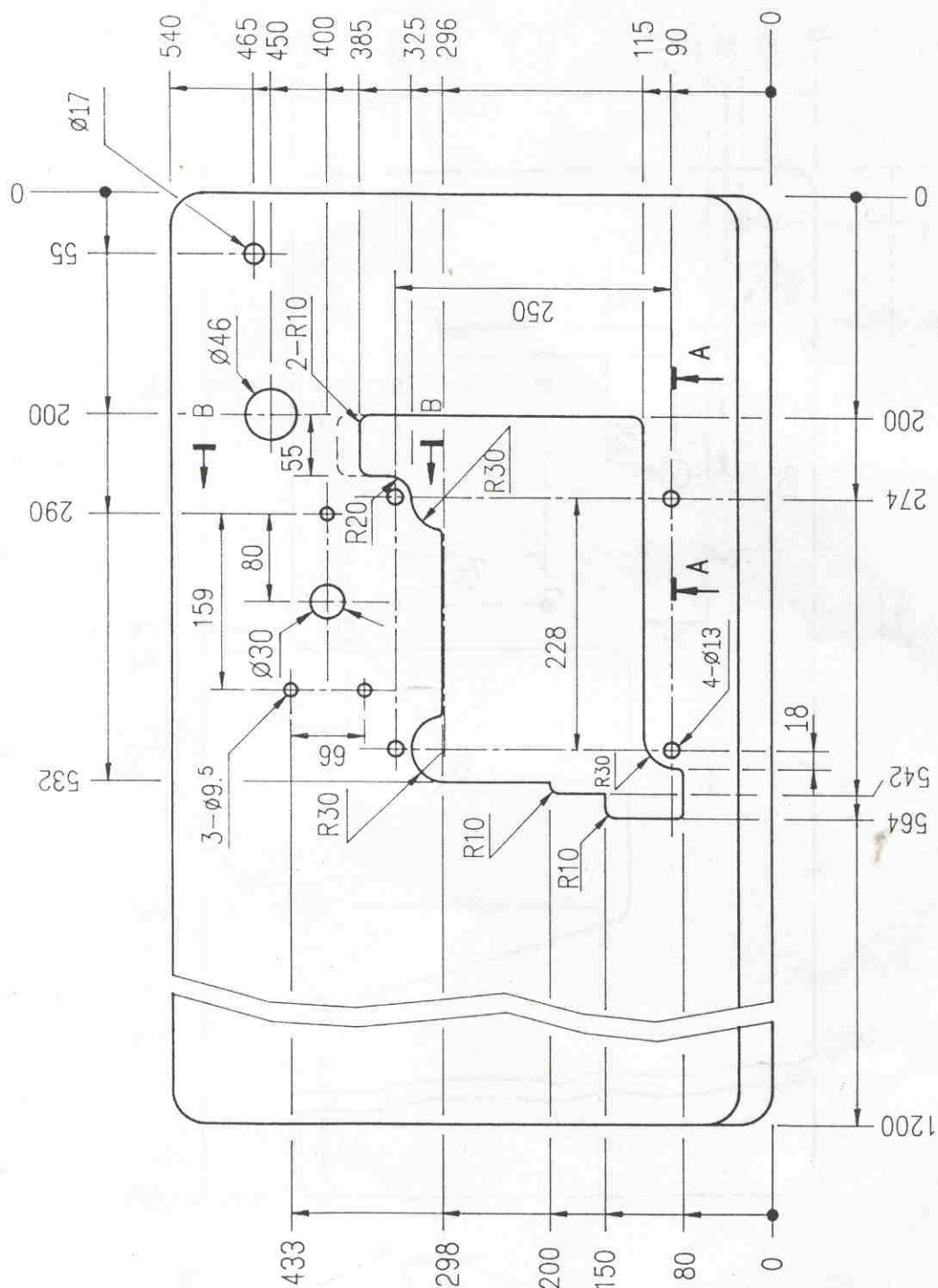
Difference : ± 2



A - A SECTION

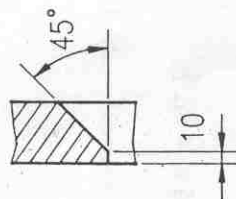
SM683-A for assemble

TBBLE CUT-OUT NO. C007-T3



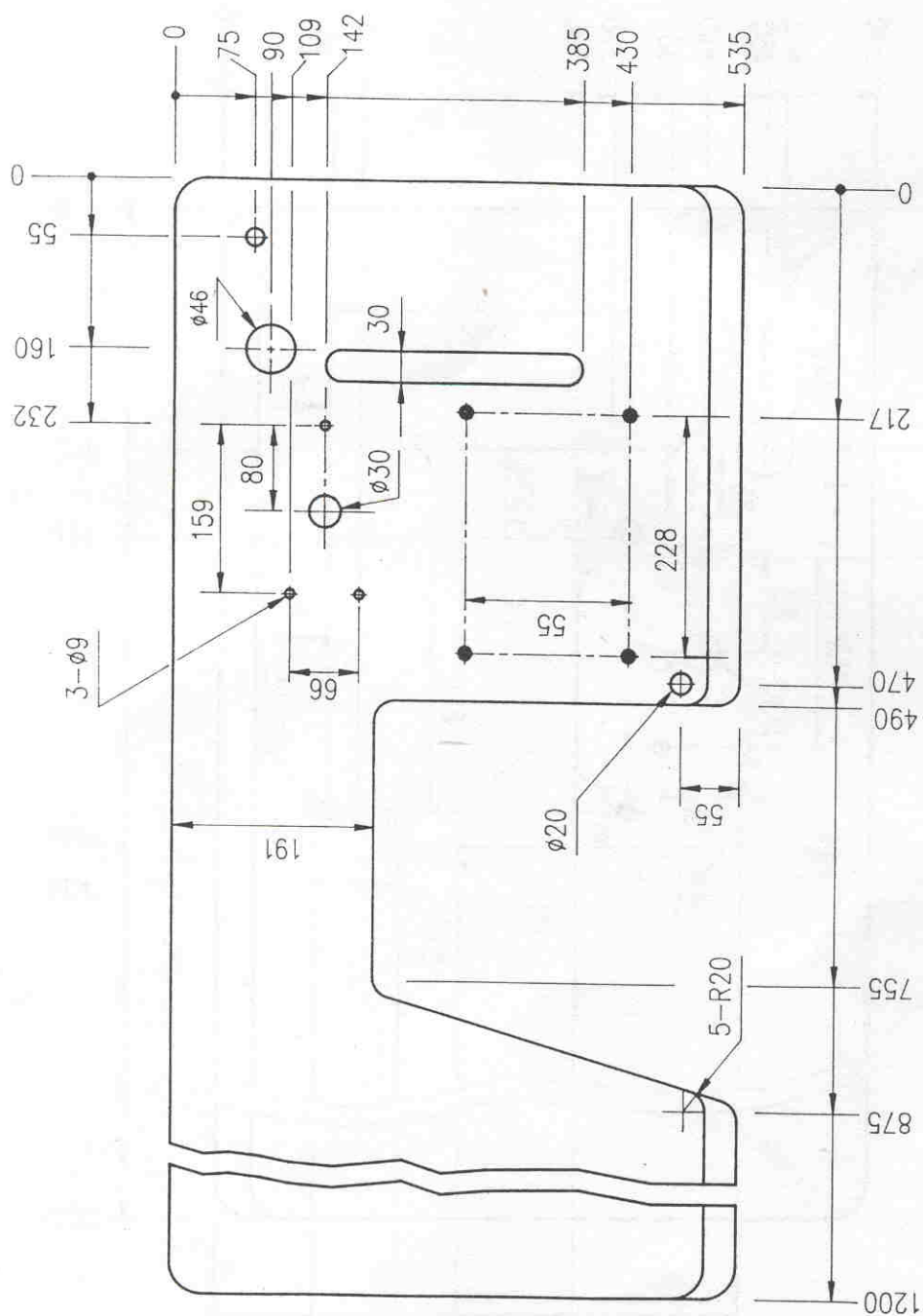
Unit : MM

Difference : ± 2



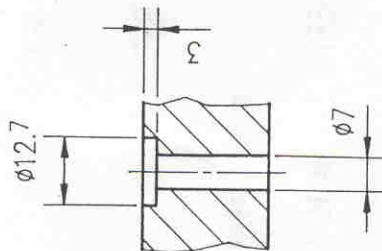
B - B SECTION

TBBLE CUT-OUT NO. C007-T4



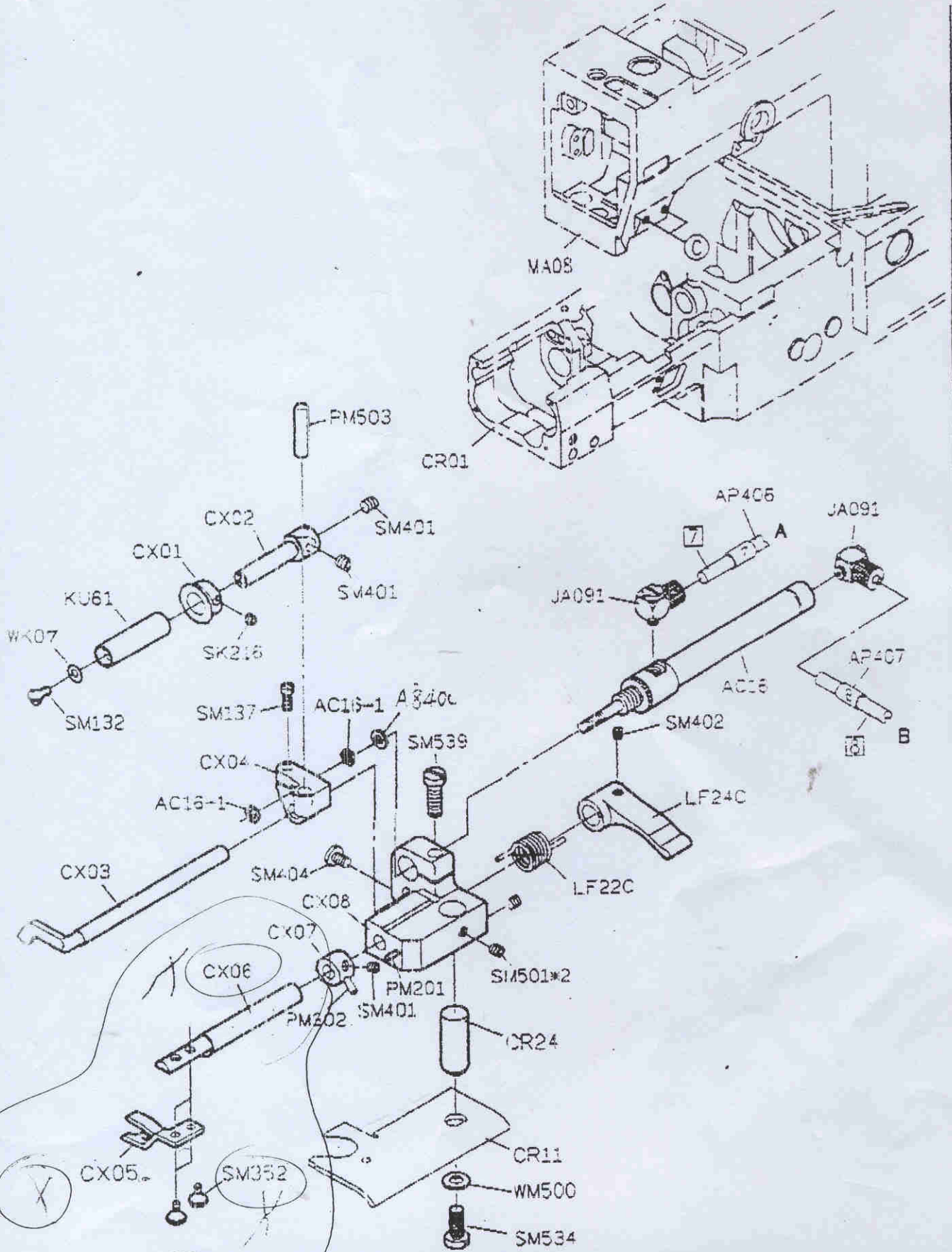
Unit : MM

Difference : ± 2



A - A SECTION

SM683-A for assemble



Em cada tempo que tiver
colocar uma xerox das 6 folhas.

conf.

85120

SIRUBA®