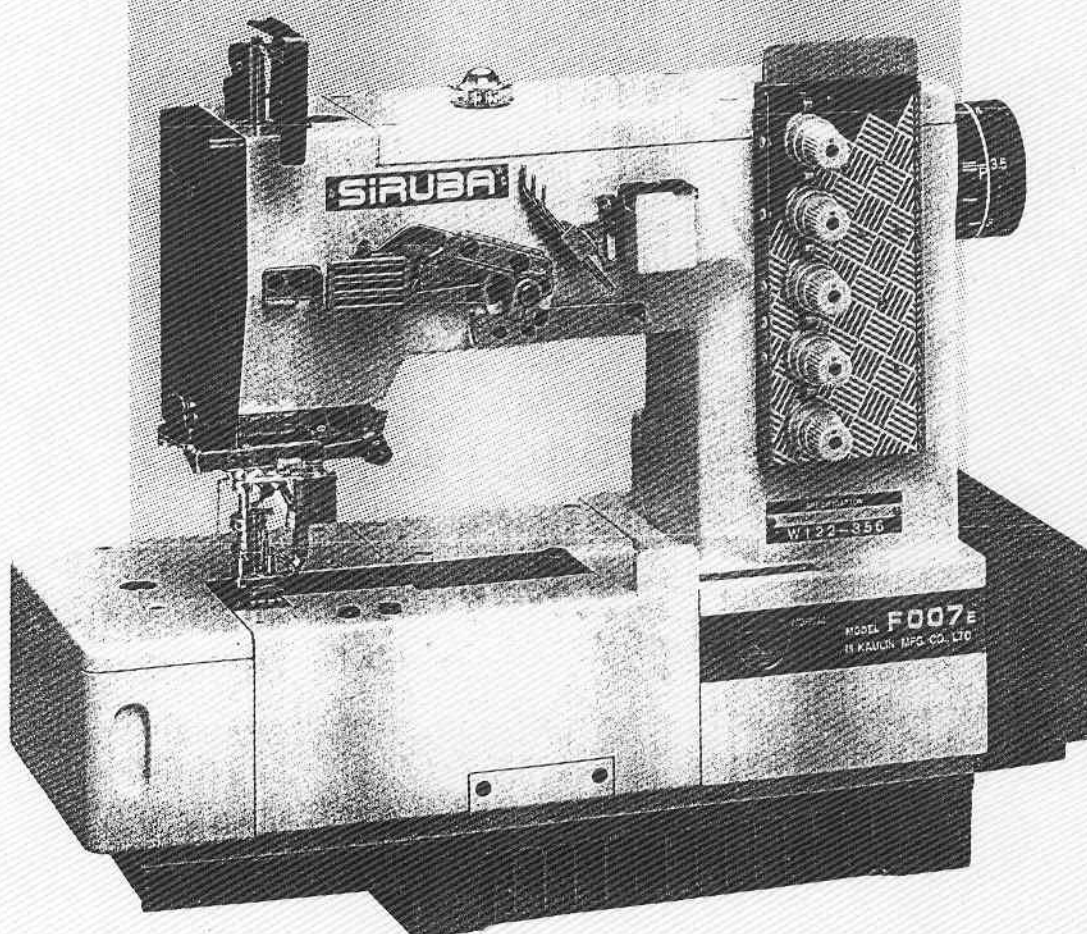


SIRUBA®

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 - LOJA

使用說明書 & 零件圖
INSTRUCTION & PARTS BOOK

 - ORIGINAL



亨林股份有限公司

使用說明

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- .馬達與皮帶
- .潤滑
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ESCHMANN

使用說明

OPERATION GUIDE

安裝

INSTALLATION

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)

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.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)

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.皮帶輪與縫合轉速請照表 1.

3.Regarding machine speed and motor pulley diameter, please refer to Table 1.

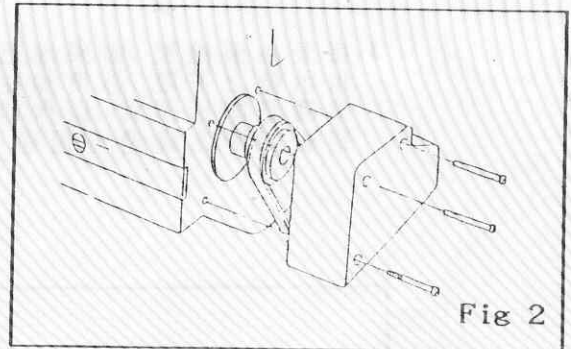
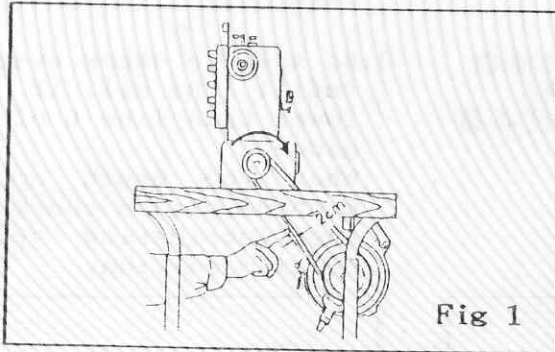


Table 1 (表 1)

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.桌板厚度約 50mm.

2.The standard thickness of table is about 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。

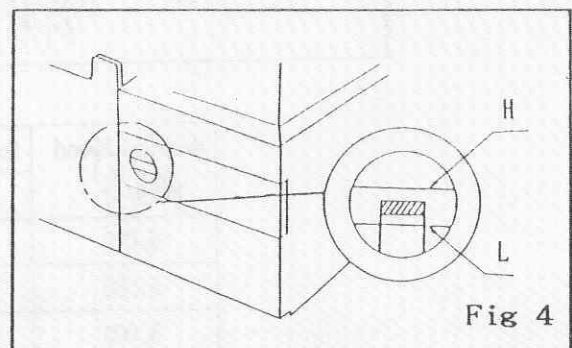
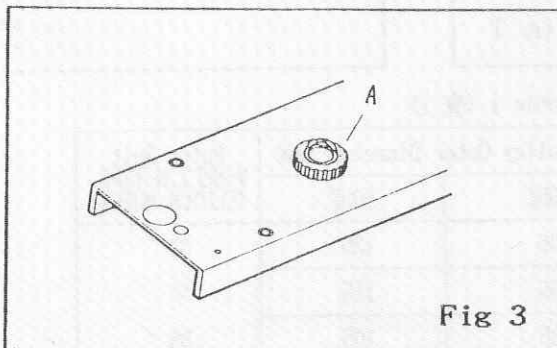
MOTOR AND BELT

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.

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。

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.



* 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。

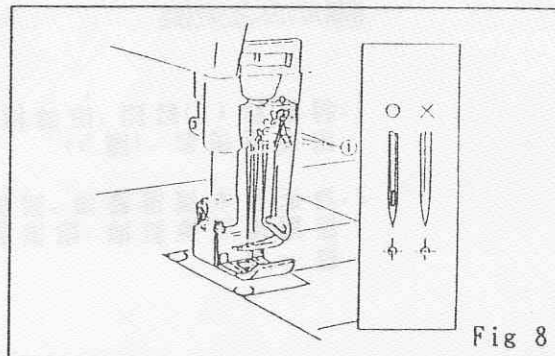
* Before starting a brand new
machine or a machine which has
not been used for more than a
couple of week, lubricate the
needle bar.

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34,35頁.

* Needle size of special model, please refer to page 34,35.

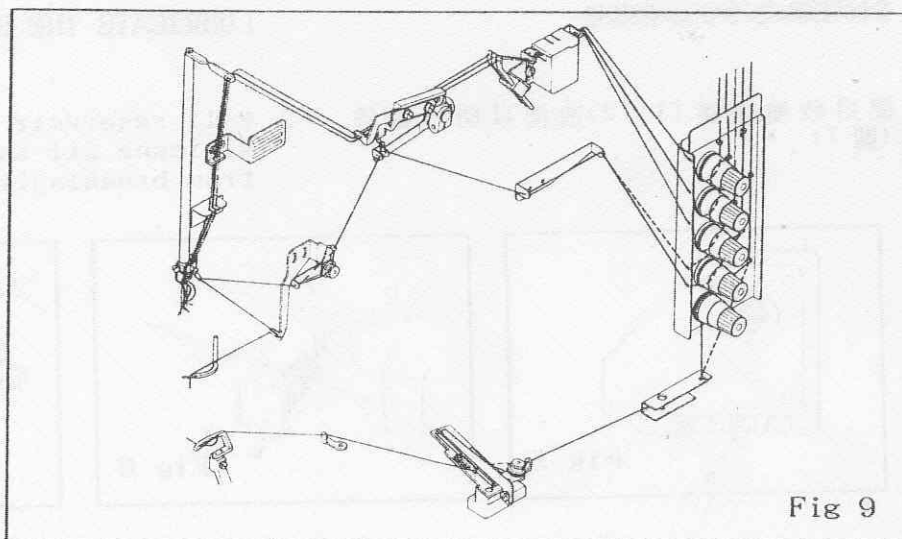


穿線方法

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.



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.

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)

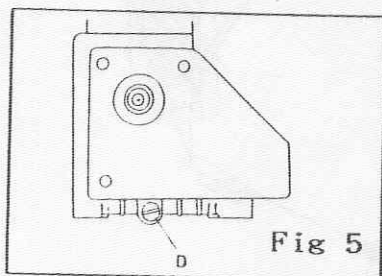


Fig 5

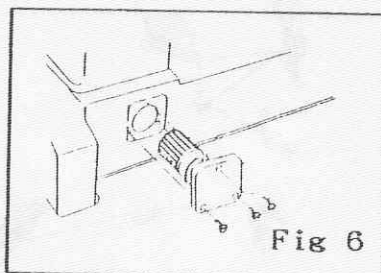


Fig 6

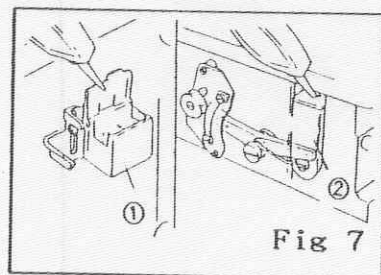


Fig 7

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)

HOW TO REPLACE THE NEEDLES

3. 重新鎖緊螺絲 (1)

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).

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.

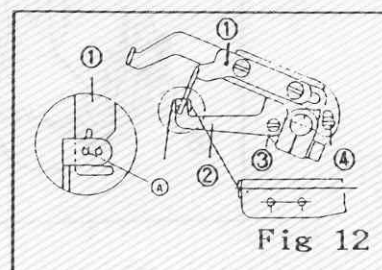
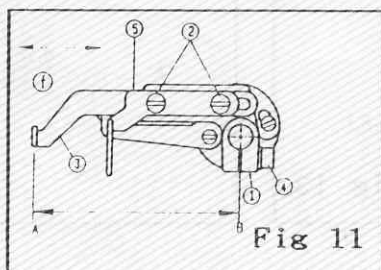
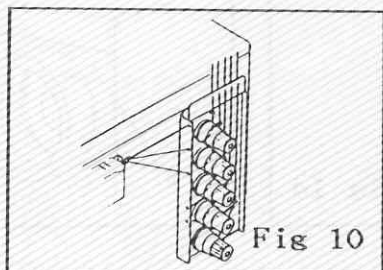
3. Do not move the Spreader Thread Take-Up (5) when making above adjustments.

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 4.0mm無階段性調整或一英吋 6-18針。

ADJUSTING STITCH LENGTH

Stitch length can be adjusted variably in range from 1.2mm-4.0mm, or 6-18 stitches per inch.

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

1.Keep pressing the push button(A) with your left hand, then turn the handwheel with you 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)

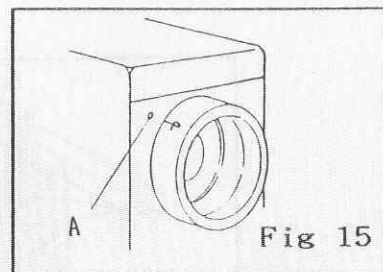
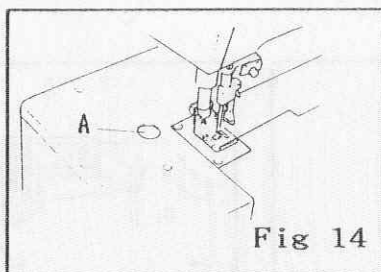
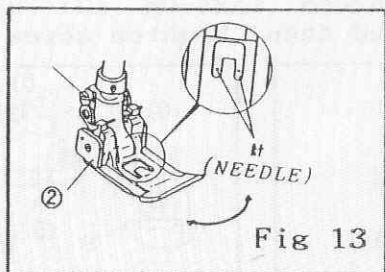
2.Keep turning handwheel for a inquired stitch length, whose scale indicated on the handwheel must be aligned with, then stop pressing the button. (Fig 15)

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.



維修說明

MAINTENANCE GUIDE

針棒高度調整

THE HEIGHT OF NEEDLE BAR

- 1.當針棒升至最高處,左針與針板之標準距離請參照表3.(圖18)
- 2.打開機頭之側蓋螺絲(1),並鬆開螺絲(2),上下調整針棒之高度後再固定之。(圖19)

- 1.When the needle bar is lifted to the highest position, the standard settings between the left needle point and the Needle Plate are listed in Table 3. (Fig 18)
- 2.Remove the cap screw (1), loosen the screw (2), adjust the Needle Bar up or down to required height then fix it.(Fig 19)

注意：

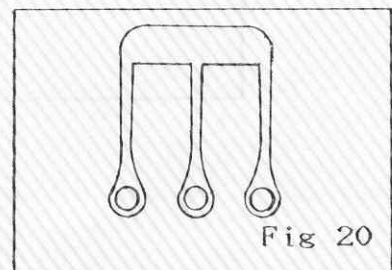
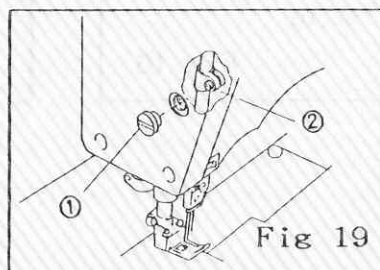
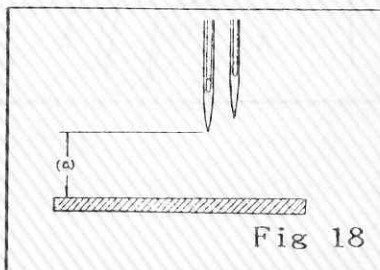
Remark:

- (1)針必須完全插入針繡孔中。
- (2)經過調整後,必須確定每一根針是通過針板的針孔中央。(圖20)

- (1)Insert the needles into the holder holes as far as they can go.
- (2)After the adjustments, make sure that every needle passes through the center of the needle hole in the needle plate, and the gap is even.(Fig 20)

TABLE 3 (表3)

2 - NEEDLE		3 - NEEDLE	
NEEDLE GAUGE 針 距	LEFT NEEDLE HEIGHT(a) 針棒高度	NEEDLE GAUGE 針 距	LEFT NEEDLE HEIGHT(a) 針棒高度
4.0 mm	9.3 mm	5.6 mm	9.0 mm
		6.4 mm	9.0 mm



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時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

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。

ADJUSTING DIFFERENTIAL FEED RATIO

The differential feed ratio of this machine is adjustable from 1:0.3 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.

押具壓力強度之調整

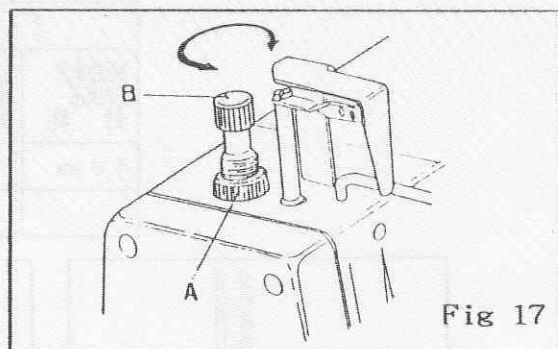
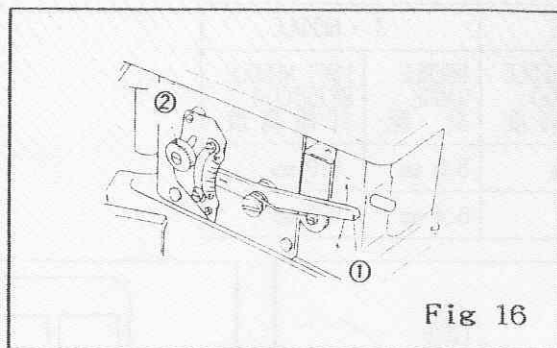
在布料推送順暢且縫合完美之情況下, 押具壓力儘量輕些。

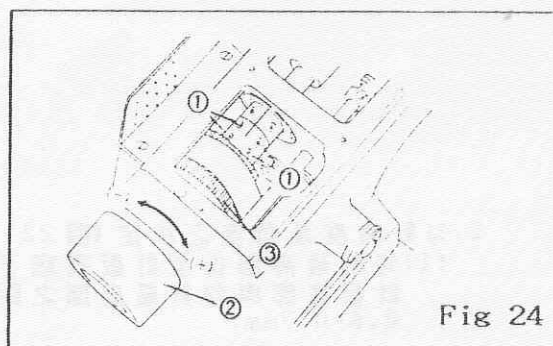
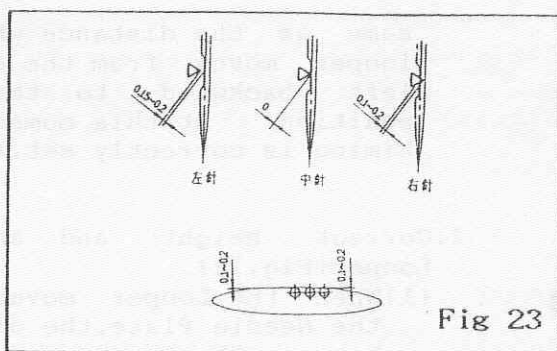
- * 鬆開螺母 A, 轉動螺絲 B, 調整其適當壓力後再鎖緊螺母。(圖 17)

ADJUSTING 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, then fasten nut A. (Fig 17)





4. 當勾針移至最左邊時右針中央線到勾針針尖之距離如附表 4。

4. The standard settings of the Looper is when the Looper moves to extreme right, the distance between the center-line of the right needle and the looper point are listed in Table 4.

調整時, 先將勾針移至最右點後在按下步驟調整:

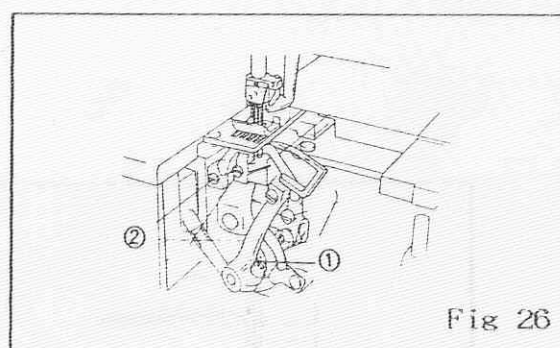
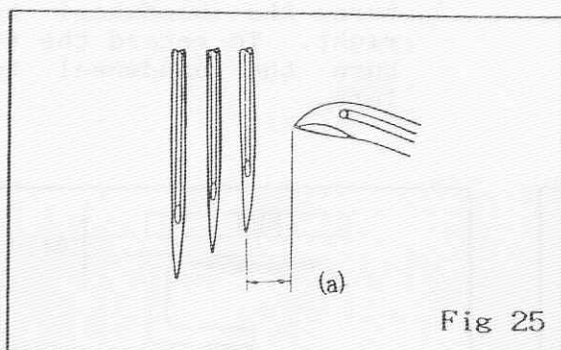
To adjust, move the looper to its right exact point, then follow the procedures below:

調整 (A) 的距離鬆開螺絲 (1) 並左右移動勾針座 (2) 至如表 4 之距離。(圖 25, 26)

To adjust the distance of (A) loose the screw (1) and move the Looper Holder to right or left, for the distance as listed in Table 4. (Fig 25, 26)

TABLE 4 (表 4)

2 - NEEDLE		3 - NEEDLE	
NEEDLE GAUGE 針 距	DISTANCE (a) 距 離	NEEDLE GAUGE 針 距	DISTANCE (a) 距 離
4.0mm	3.8mm	5.6mm	3.2mm
		6.4mm	2.8mm



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 22)

(1) 勾針最高部份至針板孔底下時，針板底部與勾針最高部之距離為 0.6-0.7mm.

(2) 勾針之角度與針水平連線成 3° .

3. 針與勾針間隙之關係 (圖 23)

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.22)

(1) When the Looper moves below the Needle Plate, the distance between the Looper and Needle Plate should be about 0.6 - 0.7mm.

(2) The angle between the Looper and the correcting line should remain at 3° .

3. Relations between looper and needles in motion. (Fig.23)

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 0.1-0.2mm. The orbit of looper's motion is in the shape of a regular ellipse.

調整時：(圖 24)

1. 打開機器上蓋；

2. 鬆開四個螺絲 (1)，並轉動手輪 (2) 及上皮帶齒輪之心軸 (3) 位置。

3. 欲提早勾針運轉時間時，將皮帶 (2) 略向右轉，反之則向左轉。

To adjust: (Fig. 24)

1. Remove the arm cover.

2. Loose the 4 screws (1), adjust the handwheel (2) and the crankshaft (3) of the upper belt gear.

3. To accelerate the timing of the looper against the needle turn the handwheel to the right. To retard the timing, turn the handwheel to the left.

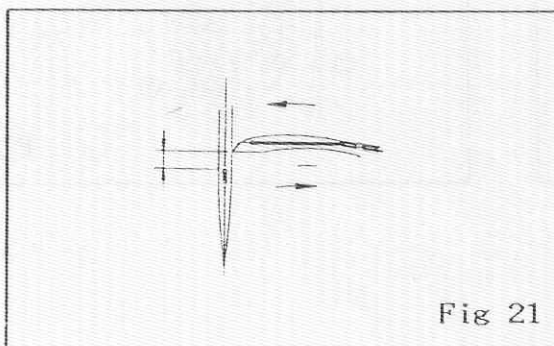


Fig 21

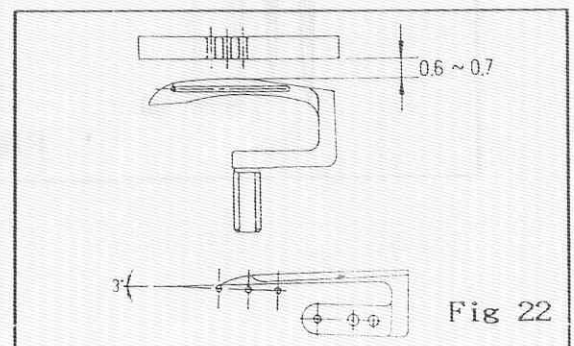


Fig 22

勾針控線盤之調整

ADJUSTING THE LOOPER THREAD TAKE-UP

當左針針尖在如下位置時，勾針控線盤即將勾針線放鬆。

The looper thread cam should release the thread of the Looper when the point of the left needle is in the following position:

1. 對雙針機型，左針針端在勾針 2/3 之處；(圖 28)

1. For the 2-needle model, while the end of the left needle is in 2/3 position of the looper. (Fig 28)

2. 對三針機型，左針針端與勾針下緣等高。(圖 29)

2. For the 3-needle machine, the end of the left needle is vertical to the lower edge of the Looper. (Fig. 29)

調整時：鬆開螺絲 (1)，轉動勾針控線盤 (2)。勾針控線盤之調整 (圖 30)。

To adjust: loosen the screw (1), then turn the Looper Thread cam (2). (Fig 30)

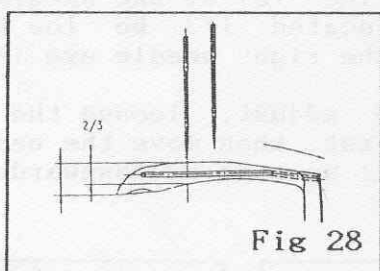


Fig 28

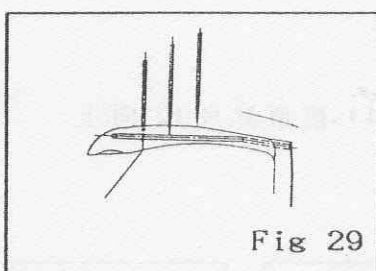


Fig 29

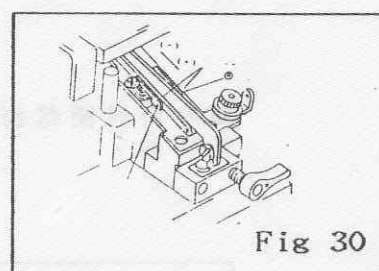


Fig 30

前頂針片調整

ADJUSTING THE FRONT NEEDLE GUARD

1. 當勾針從最右點前進至最左點時，勾針通過針的後面，前針護片 (1) 則在針的前面通過其間隙 (a) 為 0.2-0.3mm (圖 31)

1. When the looper goes from the right exact point to the left exact point, it passes behind the needles and the front needle guard (1) is in front of the needles, the clearance (a) is 0.2 - 0.3mm. (Fig 31)

2. 調整時：鬆開螺絲 (2) 並前後移動針護片 (1)

2. To adjust, loosen the screw (2), and move the front needle guard (1) back or forth.

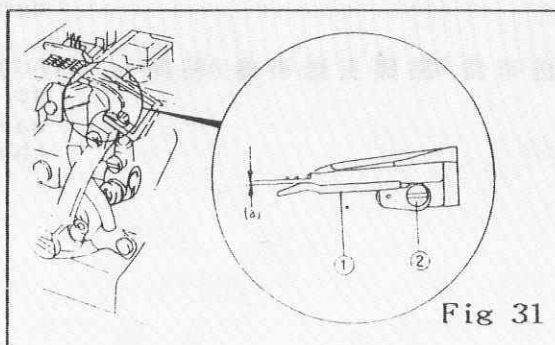


Fig 31

後頂針片之調整

ADJUSTING THE REAR NEEDLE GUARD

當勾針尖端在右針中央線之後方時，頂針片在它們之間的活動空隙是 0-0.5MM. (圖 32)

When the looper point is behind the right needle, the centerline of the needle guard should have a clearance of about 0-0.5mm between the looper point and the right needle. And it is also the same clearance of 0 - 0.5mm between the middle needle and the looper point when the looper point is in the rear of the centerline of the middle needle. (Fig 32)

1. 為了得到空隙 0-0.5MM, 請鬆開螺絲 (1), 並前後移動頂針片座 (2). (圖 33)

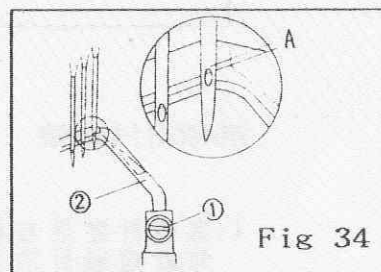
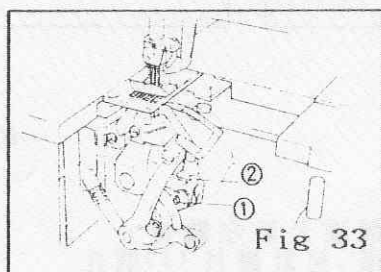
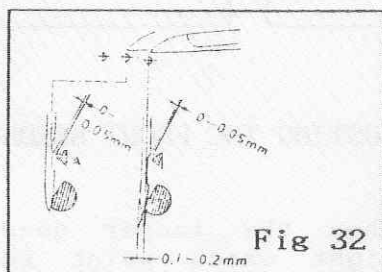
1. In order to gain a clearance about 0 - 0.05mm, loosen the screw (1), then move the needle guard (2) back or forth. (Fig 33)

2. 當針在最低點時，頂針片之延線 A 是位於右針眼的 1/3 位置。(圖 34)

2. When the needle is in below the top of its lowest position, the line (A) of the needle guard is located 1/3 below the top of the right needle eye. (Fig. 34)

*調整時鬆開螺絲 (1), 使頂針片 (2) 向上下移動。

*To adjust, loosen the screw (1) first, then move the needle guard (2) upwards or downwards.



送布齒高度調整

ADJUSTING THE HEIGHT OF FEED DOG

1. 主送布齒上升至最高位置是 0.8-1.2 MM. (圖 35)

1. The height of Main Feed Dog is 0.8 - 1.2mm when it is in the highest position. (Fig 35)

2. 調整差動送布齒 B 點與主送布齒 A 點同樣高度。

2. Adjust the Differential Feed Dog so that the point B is at the same height as the point A of the Main Feed Dog.

*調整時鬆開 MC41, MC44 螺絲 SK245, 並上下移動送布齒。(請參考 MC 零件圖)

To adjust, loosen the screws SK245 of MC41, and move the Feed Dog upwards or downwards. (Please refer to Parts List of MC group)

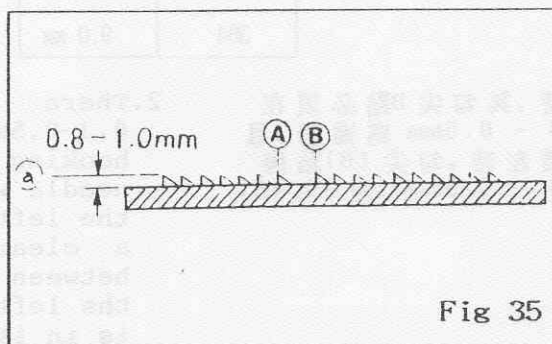


Fig 35

送布齒傾斜調整

當送布具升至最高點時,送布齒齒尖成一直線,且與針板平行。

ADJUSTING THE FEEDING TILT

The straight line (a), crossing the whole Feed Dog tooth tips, is parallel with the needle plate when the Feed Dog is raised to the highest position.

調整時:(圖 37)

To adjust: (Fig 37)

1. 卸下螺絲 (1) 及上蓋 (2) (3)。
2. 鬆開螺絲 (4), 並轉動螺絲 (5), 以調整齒傾斜角度。

1. Remove the screws (1) and the cover (2) (3).
2. Loosen the screw (4) and turn the screw (5) to adjust the feeding tilt.

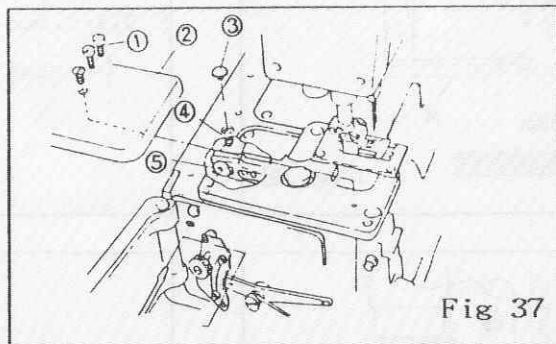


Fig 37

上叉之設定

SETTING THE POSITION OF SPREADER

1. 上叉之高度如附表 5。

1. The height of the Spreader as Table 5.

Table 5 (表5)

規 格 GAUGE SET	上叉高度 HEIGHT OF SPREADER
240	9.3 mm
356	9.0 mm
364	9.0 mm

2. 上叉(1)移動時,其勾尖B點必須在左針前約 0.3 - 0.5mm 處通過,且上叉(1)移至最左時,勾尖(B)點與左針距約 4.5 - 5.0mm。(圖 39,40)

2. There is a clearance about 0.3-0.5mm between the Spreader's hooking point and the left needle when the Spreader passes the left needle. And there is a clearance about 4.5 - 5.0mm between the hooking point(3) and the left needle when the Spreader is in its left dead point. (Fig 39,40)

調整時：

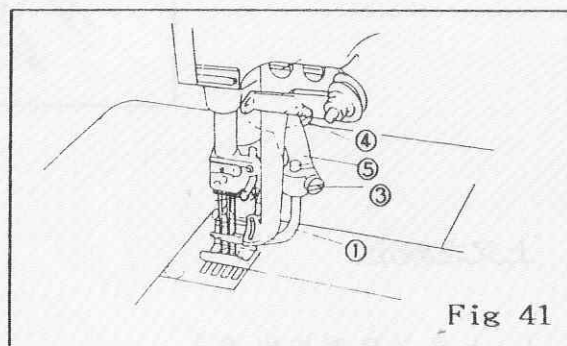
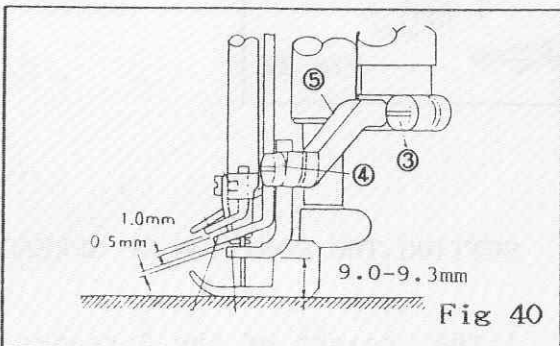
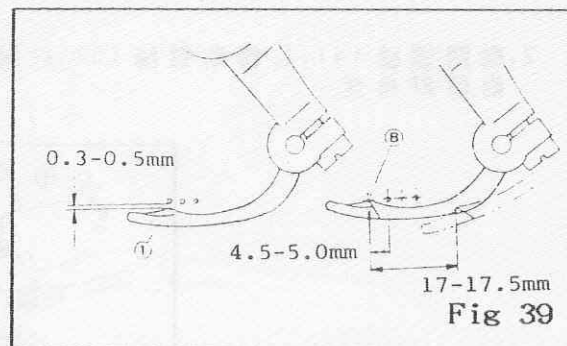
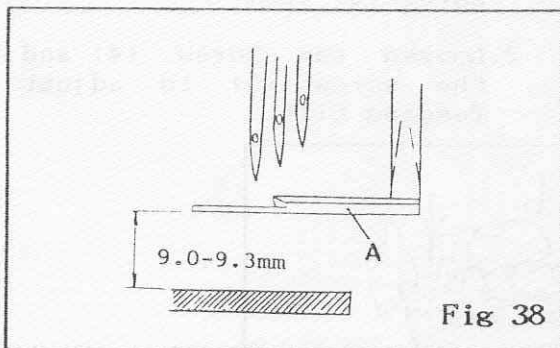
To adjust:

1. 鬆開螺絲 (4), 轉動勾針桿(5), 及前後移動上叉(1), 然後固定位置, 鎖緊螺絲(4)。(圖 41)

1. Loosen the screws (4), and move the spreader (1) back or forth, while turning the spreader lever (5), after finishing the setting, tighten the screw (4). (Fig 41)

2. 上下移動上叉(1), 使其離針板之高度如附表 5。

2. Move the spreader (1) upwards or downwards to set its height from the needle plate as Table 5, then fasten the screw (3).



上叉導板位置之調整

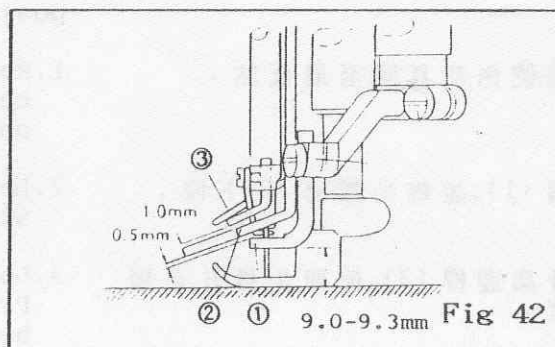
SETTING THE POSITION OF SPREADER THREAD GUIDE

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) 之間隙為 0.5mm. (圖 42)

1. When the needle bar is in its lowest position, the Thread Guide (2) should be set just below the eye of of the guide (3). And the clearance between the Thread Guide (2) and the Spreader (1) should be set to 0.5mm. (Fig 42)

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 42)

2. When the Needle Bar moves to its lowest position, the clearance should be 1.0mm between the Spreader Thread Guide (2) and the Needle Thread Guide (6). The concavity of the Spreader and the thread eye should face each other. (Fig 42)



上叉行程調整

ADJUSTING THE SPREADER STROKE

上叉行程是 17-17.5mm. (圖 39)

The Spreader's stroke is 17-17.5mm (Fig 39)

1. 移開上蓋和螺絲 (1). (圖 43)
2. 鬆開螺母 (2), 並上下移動連桿 (3)

1. Remove the Arm Cover and the screw (1). (Fig 39)

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

*欲減少其行程, 將連桿 (3) 向上移。

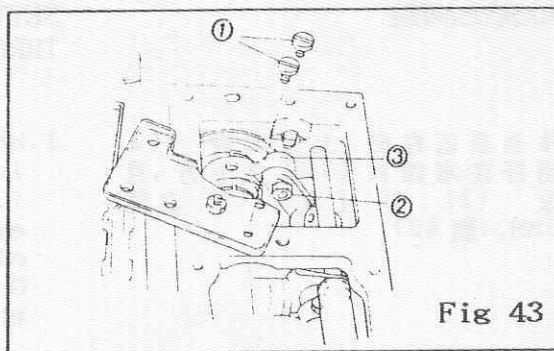
*In order to decrease the Spreader's stroke, move the Connecting Rod (3) upwards.

*欲增加其行程, 將連桿 (3) 向下移。

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

3.調整後,將上述螺絲鎖緊。

3.After adjustments, remember to fasten the above said screws.



押具提升之調整

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(a)為5mm。(圖44)

Presser Foot Lift means the distance between the Presser Foot and the Needle Plate when the Presser Foot is at its highest position. (Fig 44)

1.轉運手輪使送料具降至最低點。

1.Rotate the handwheel to lower the Feed Dogs to the lowest position;

2.鬆開螺帽(1),並轉動螺絲(2)下降。

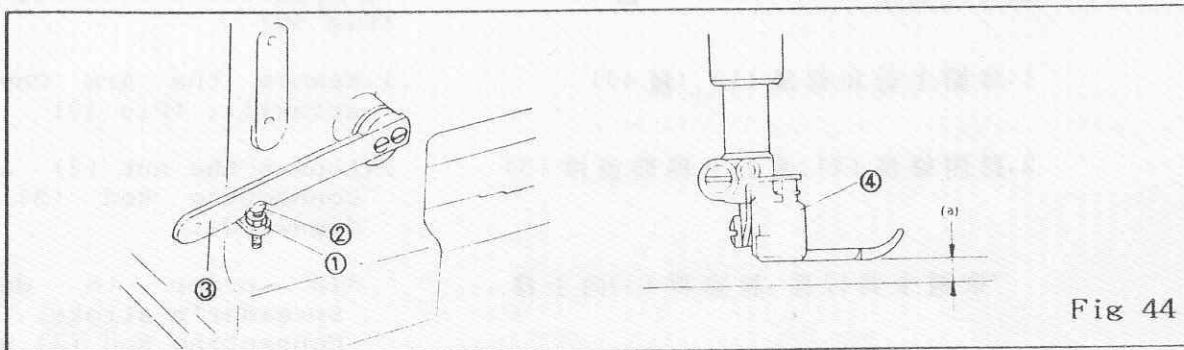
2.Loose the nut (1) and lower the screw (2);

3.降低或升高連桿(3),使押具提升至適當之高度。

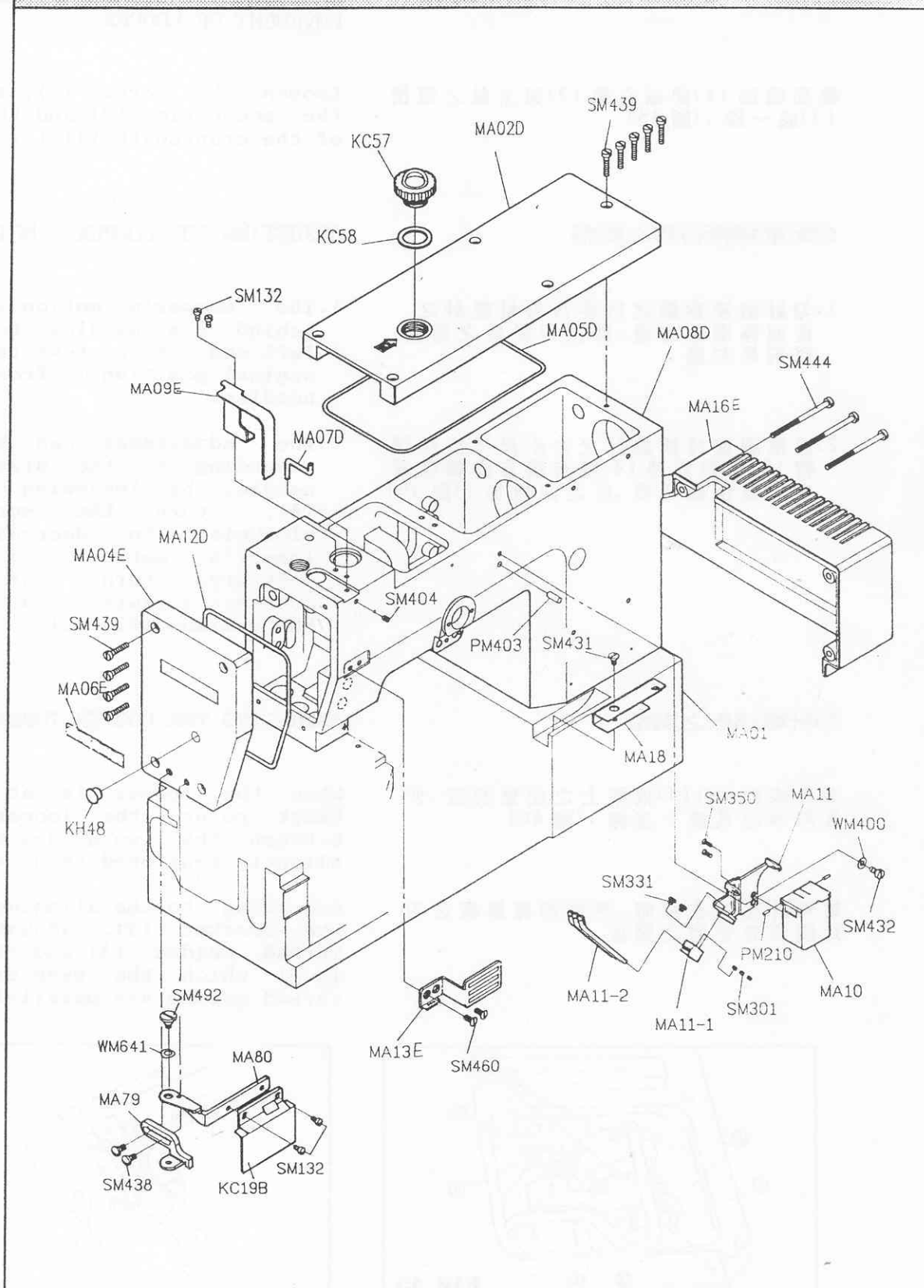
3.Lower the lever(3) and raise the Presser Foot to the proper height

4.調整後螺絲(2)使頂至連桿(3),並固定螺絲(1)。

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



PARTS LIST FOR MA GROUP



針與勾針前後移動時間關係之調整

鬆開螺絲 (1) 使偏心輪 (2) 與主軸之凹槽 (3) 成一線。(圖 45)

ADJUSTING THE TIMING BETWEEN THE NEEDLE AND THE BACK AND FORTH MOVEMENT OF LOOPER

Loosen the screw (1), and align the eccentric (2) and the groove of the crankshaft (3). (Fig 45)

勾針前擺動行程之調整

1. 勾針前後運動之行程乃勾針從針之後面移至最左邊, 然後再從針之前面回到最右邊。
2. 通常調整時依據針之大小尺寸放鬆螺帽 (5) 調整螺絲 (4) 順時鐘方向轉動減少前後恍動行程, 反之則增加。(圖 45)

ADJUSTING THE LOOPER'S MOTION

1. The Looper's motion is passed behind the needles to the far left end, then reverts to the original position in front of the needles.
2. The adjustment can be done, according to the size of the needle, by loosening the screw (4), turn the screw (5) clockwise to decrease the looper's motion. On the contrary, turn the screw counter-clockwise to increase the motion. (Fig 45)

勾針導線板之調整

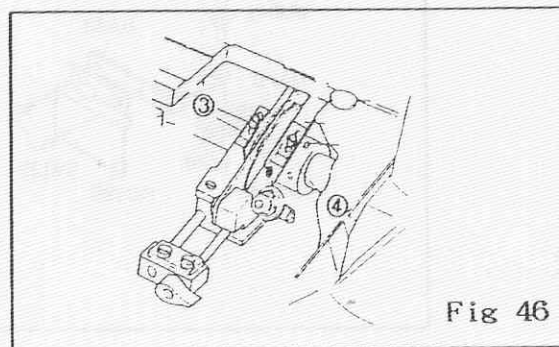
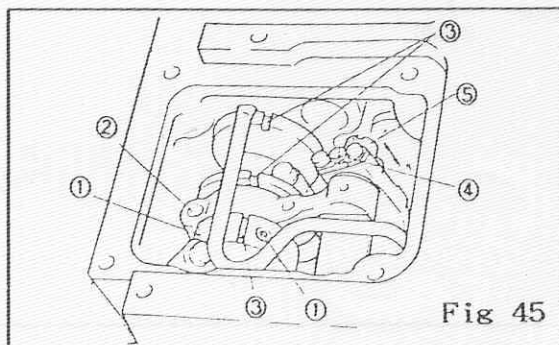
兩導線板 (3) (4) 依架上之記號安裝, 使其兩導線孔成一直線。(圖 46)

ADJUSTING THE LOOPER THREAD GUIDES

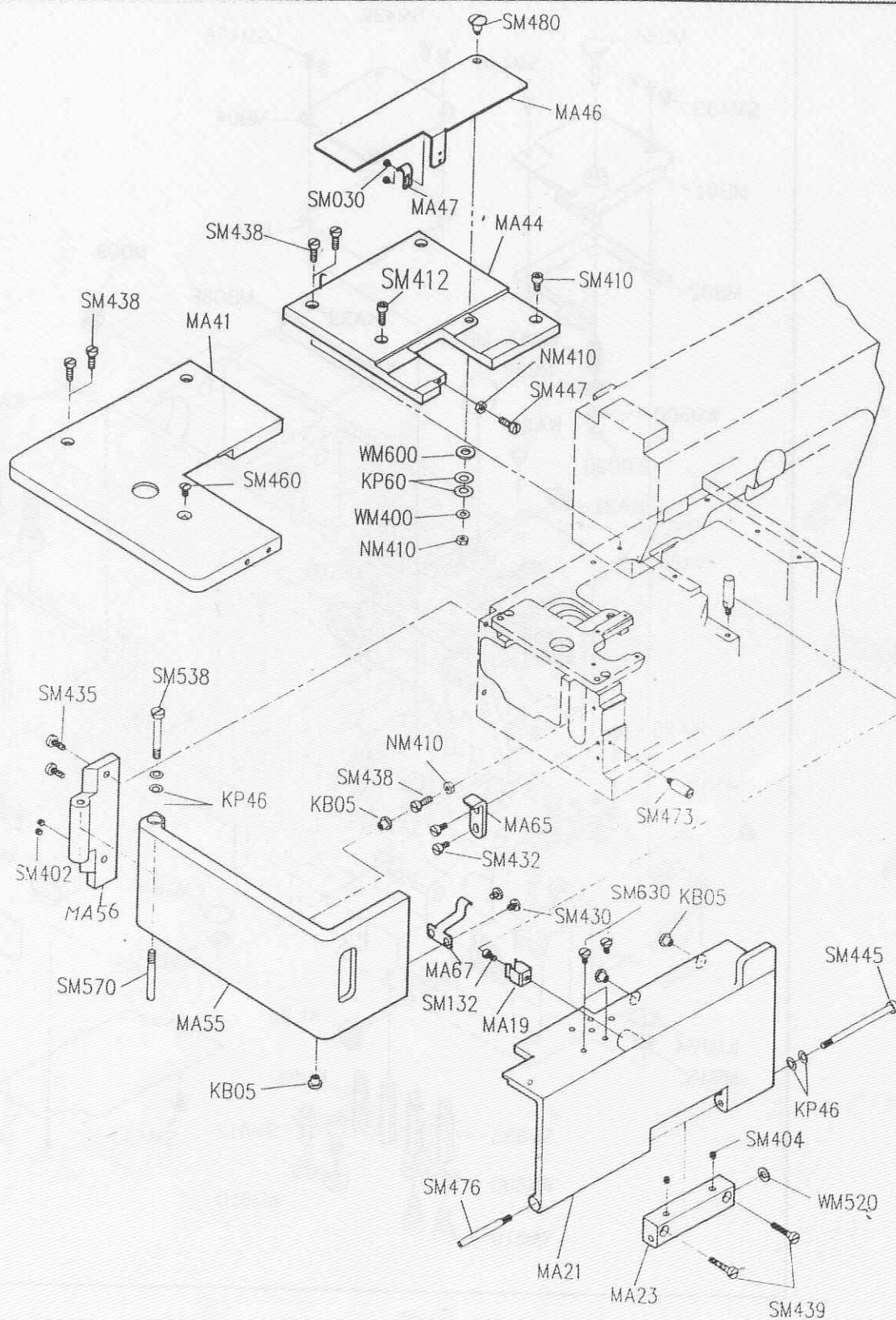
When the looper is at the left exact point, the looper thread between the two guides should be slightly tensioned (Fig. 46)

當勾針在最左邊時, 經過兩導線板之勾針線僅有些微之緊度。

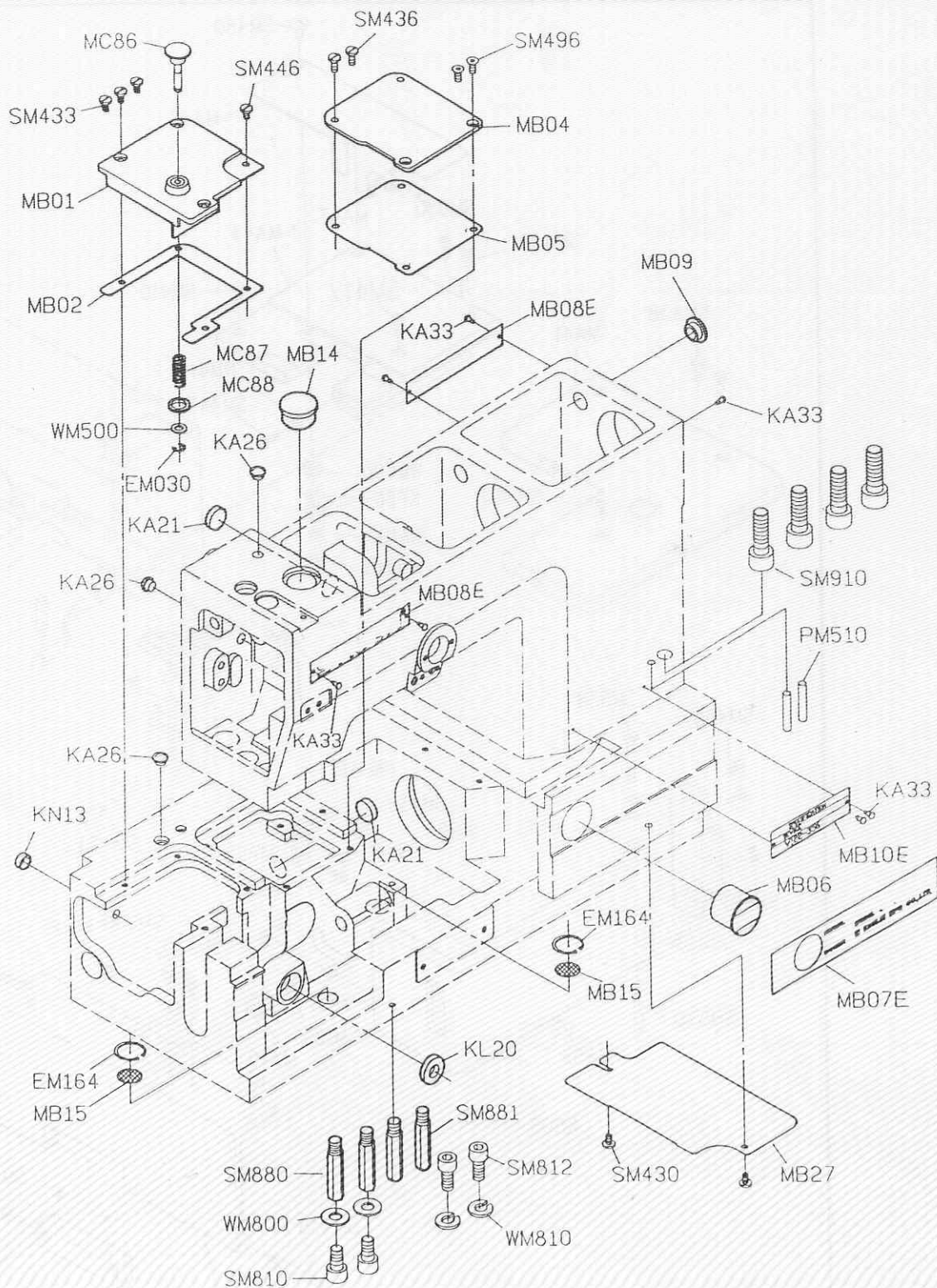
According to the alining mark on the bracket (3), adjust the two Thread Guides (3) and (4) to the level which the eyes of the two thread guides are parallel.



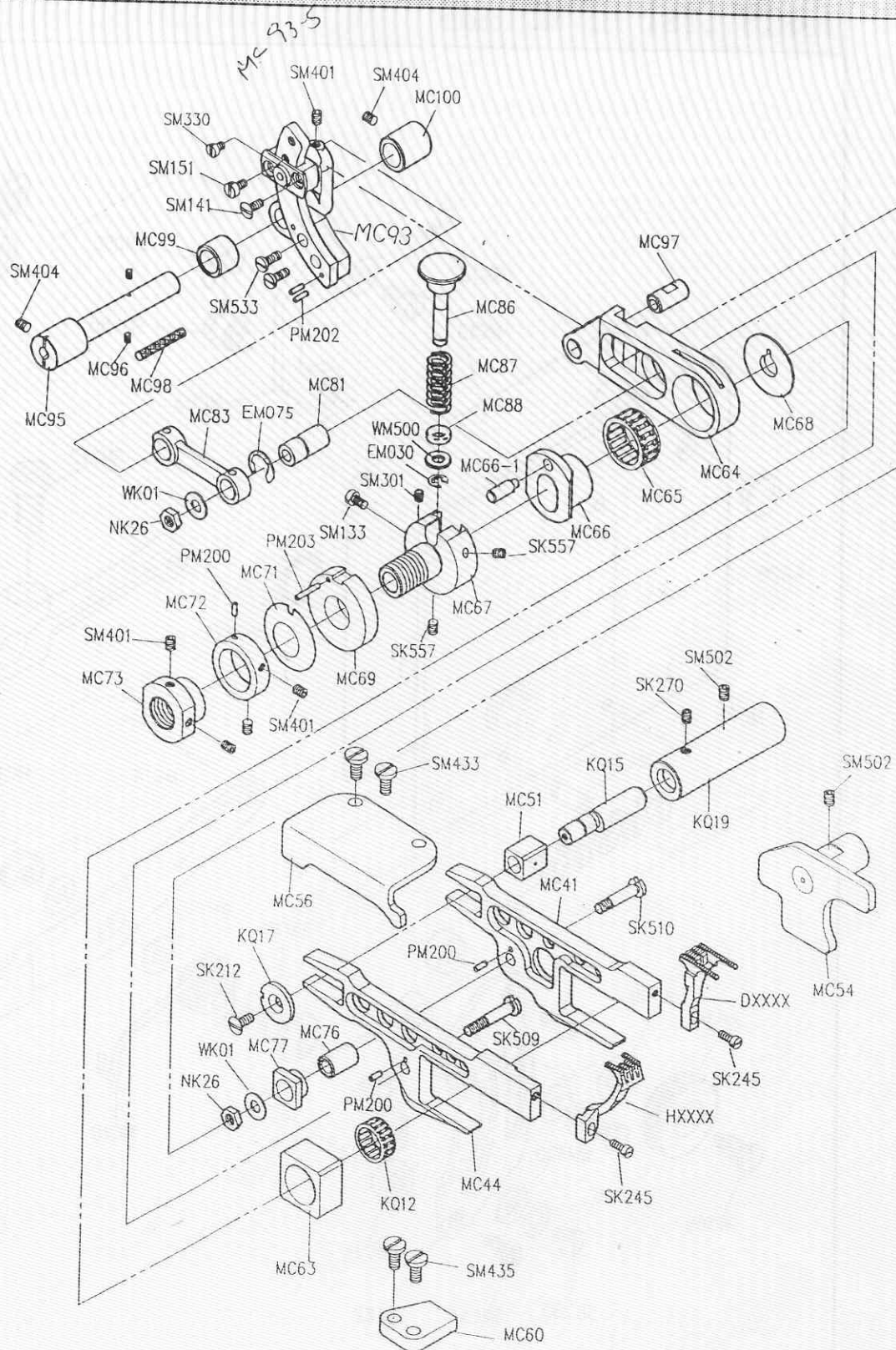
PARTS LIST FOR MA GROUP



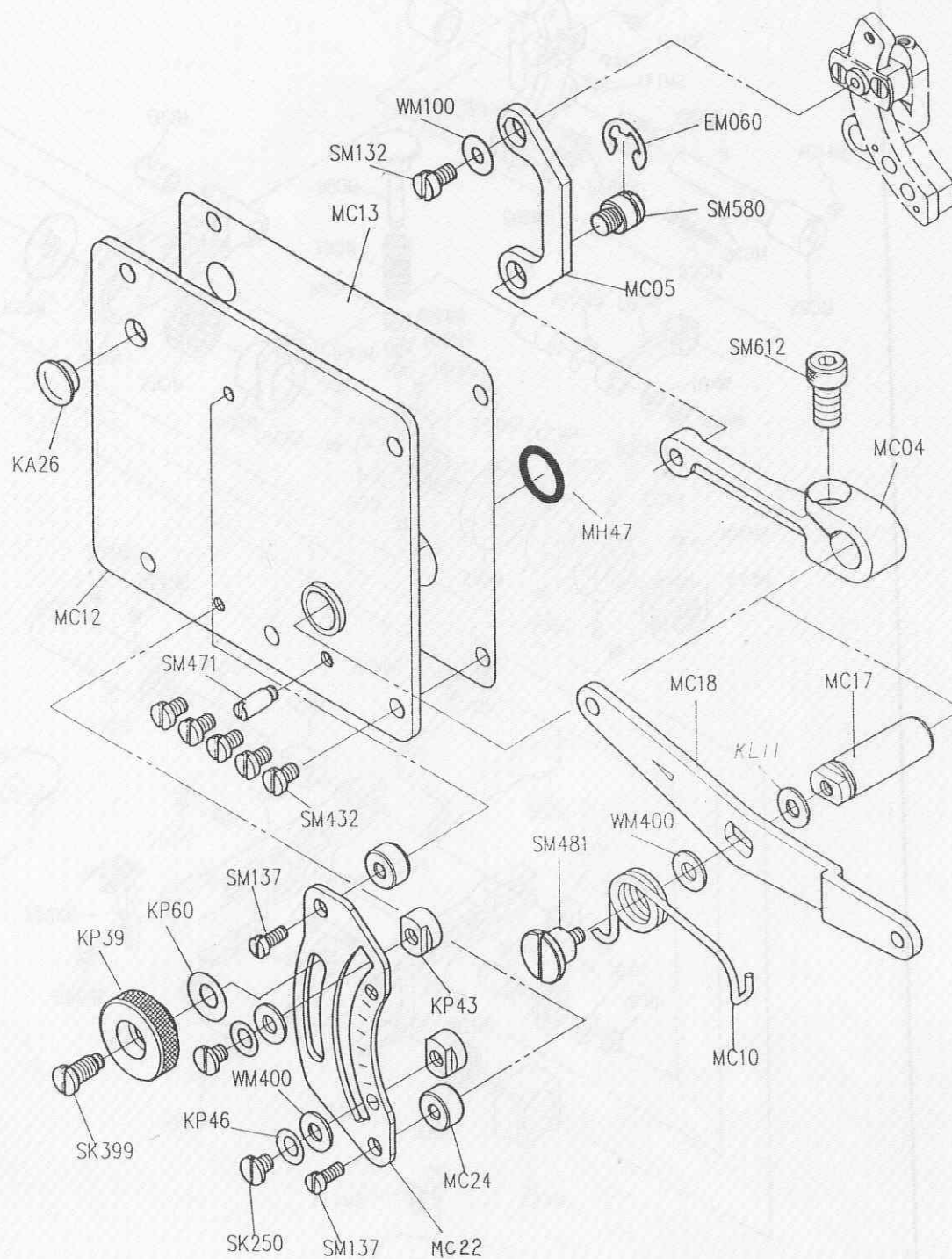
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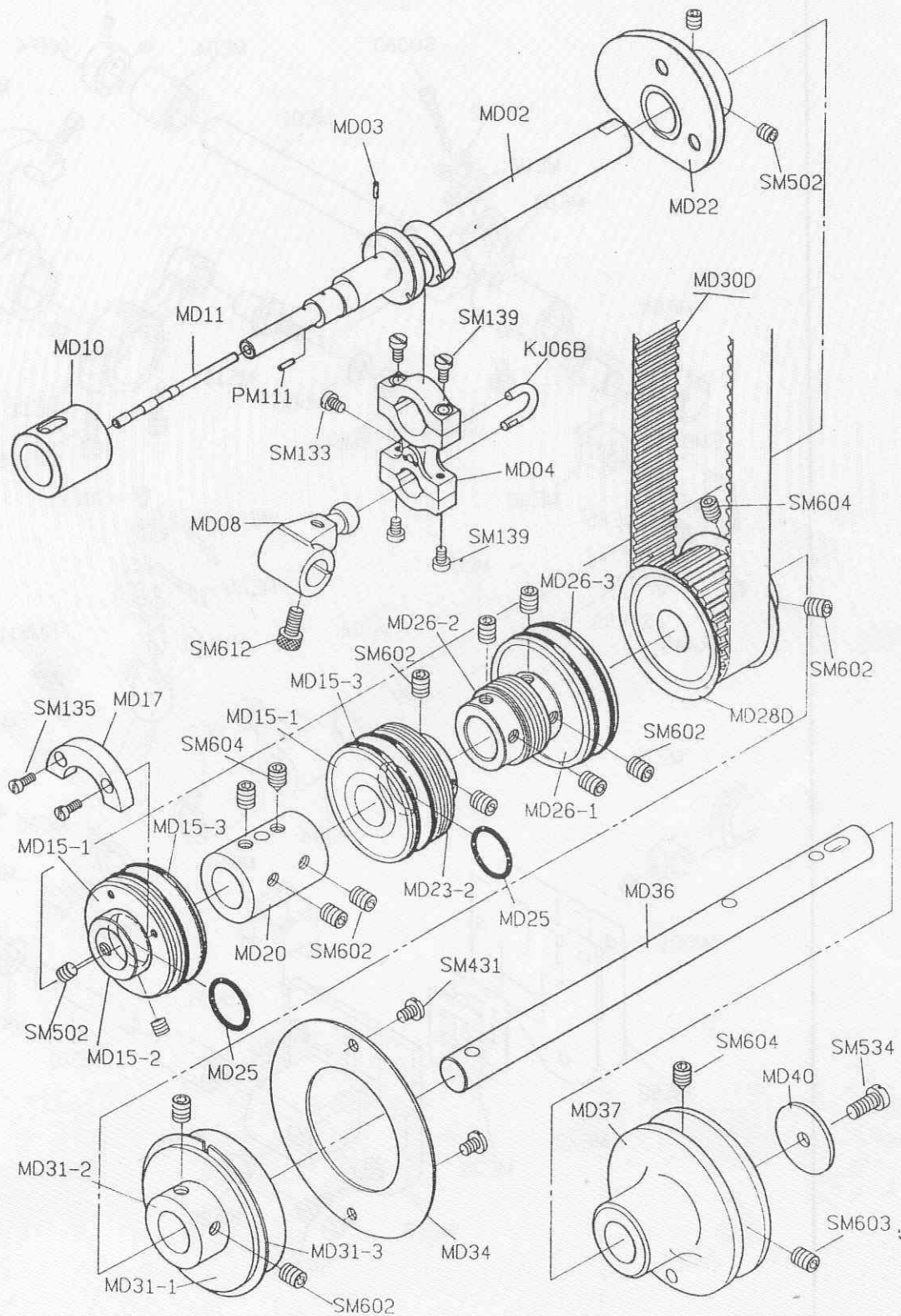
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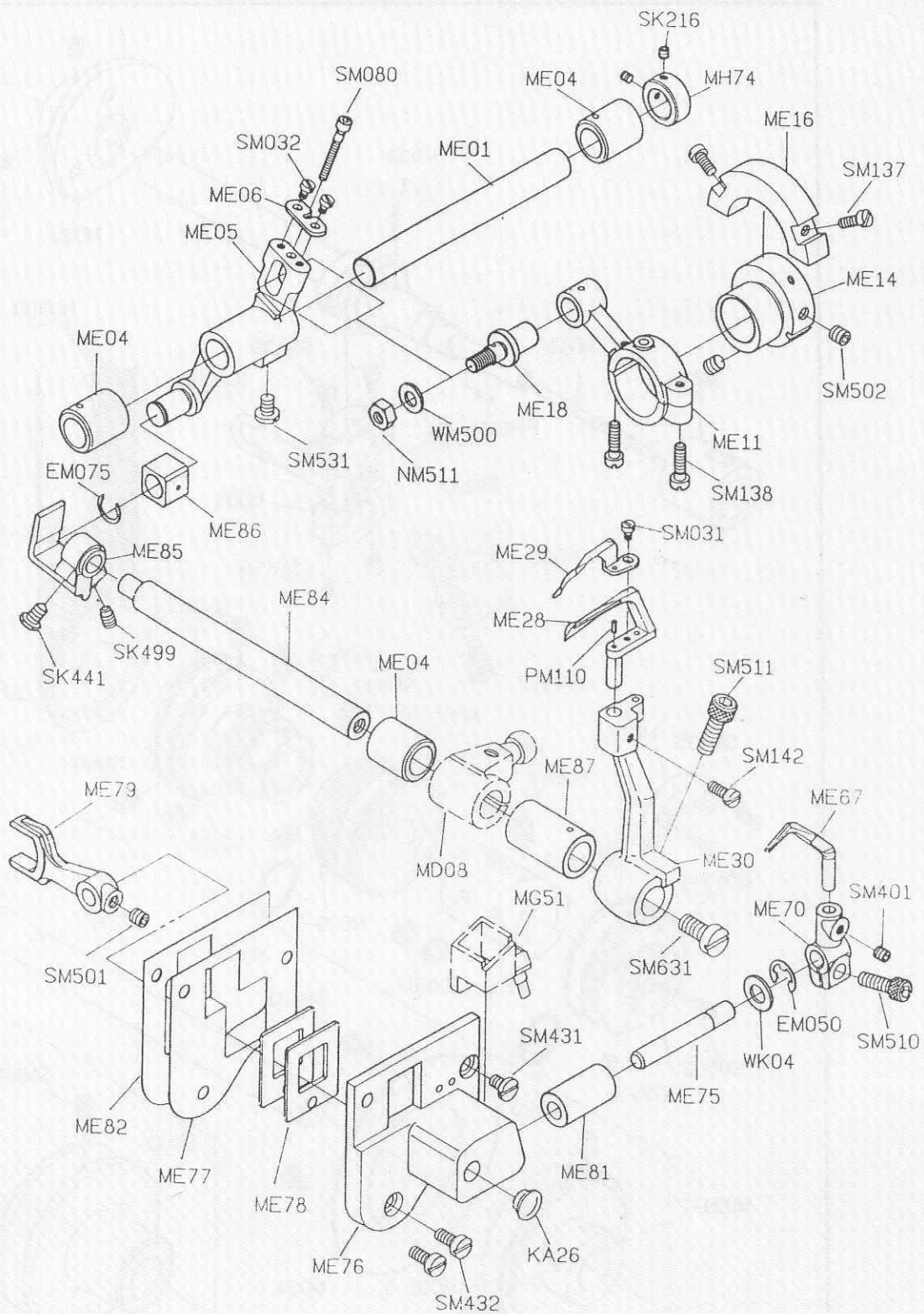
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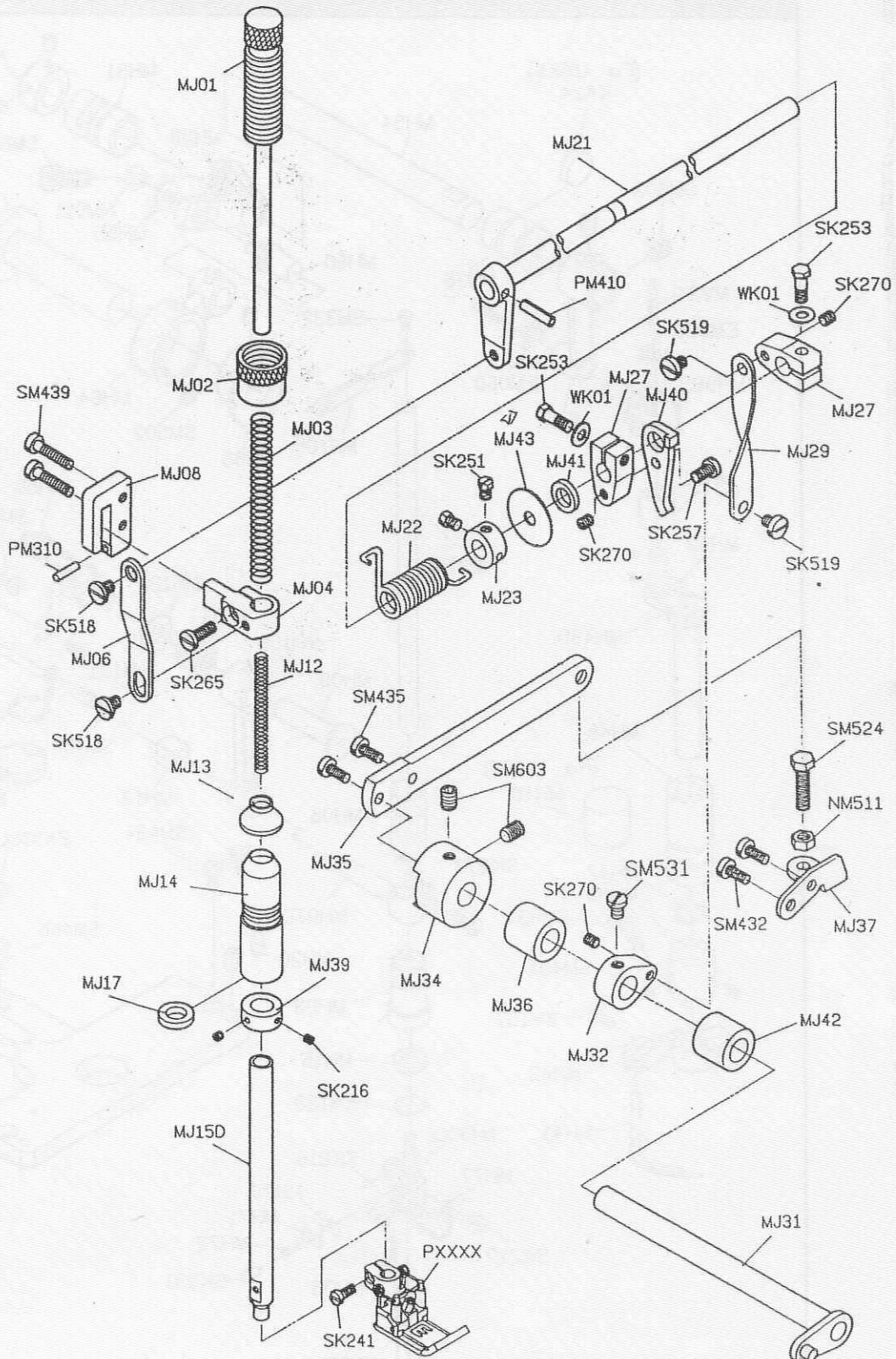
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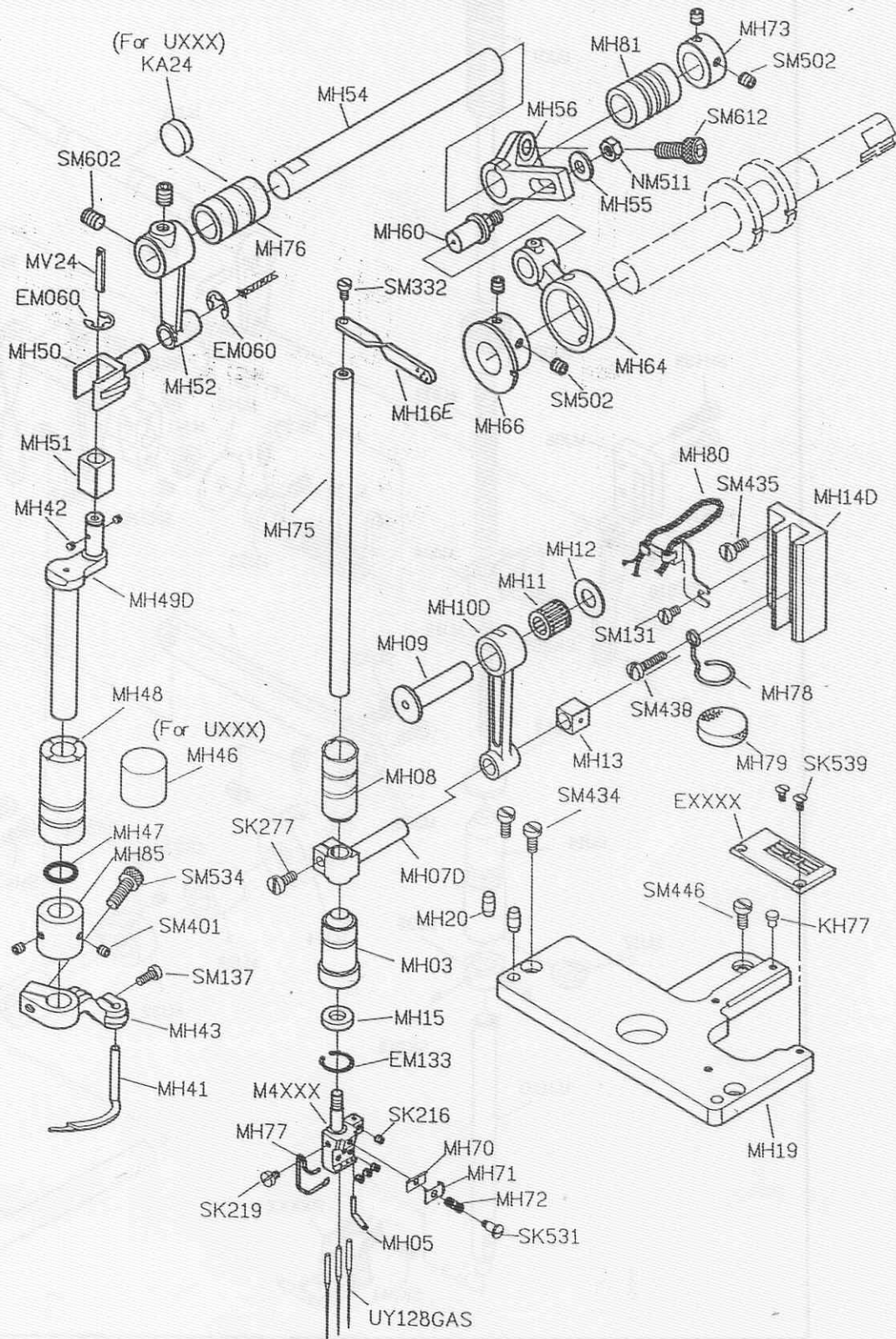
PARTS LIST FOR ME GROUP



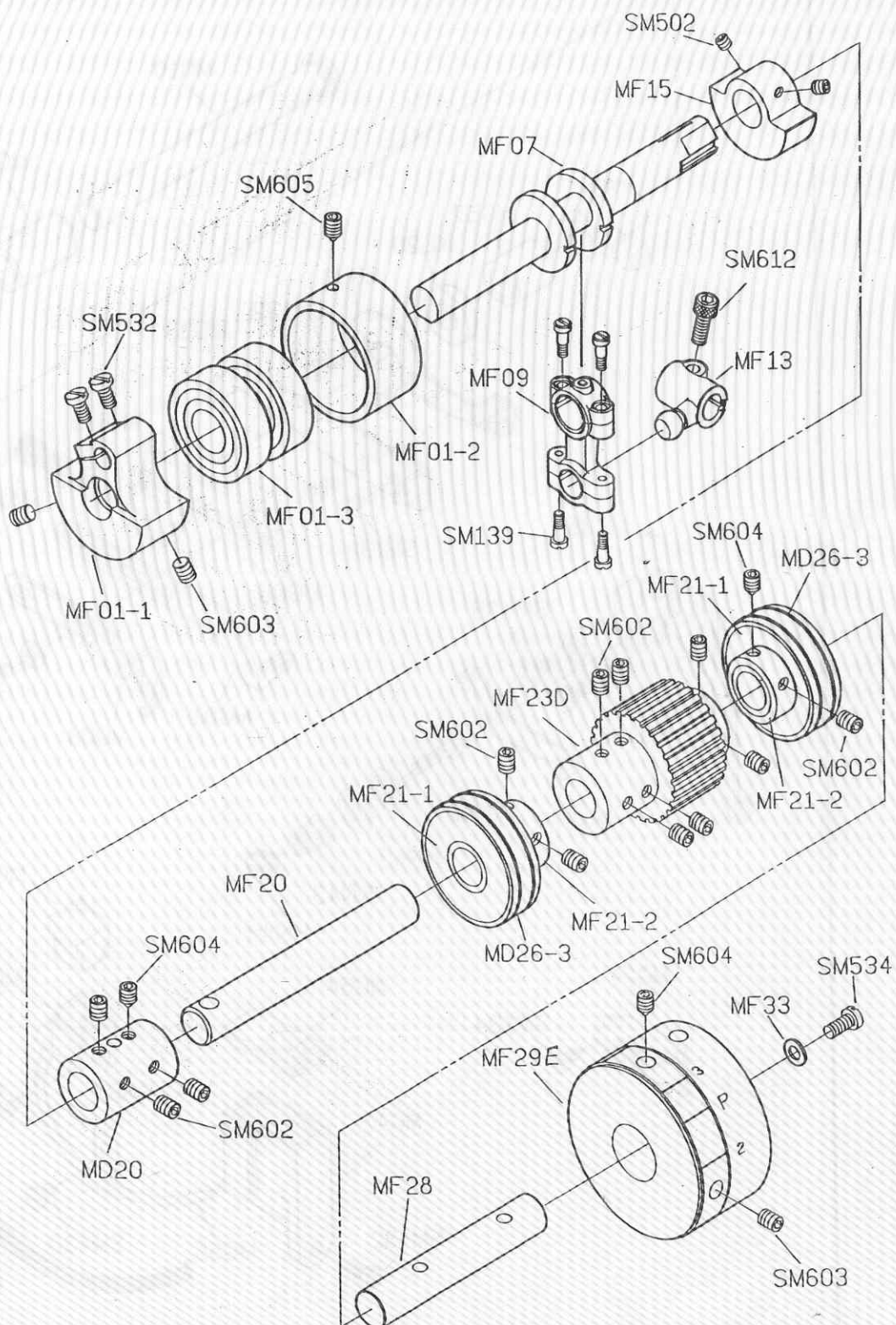
PARTS LIST FOR MJ GROUP



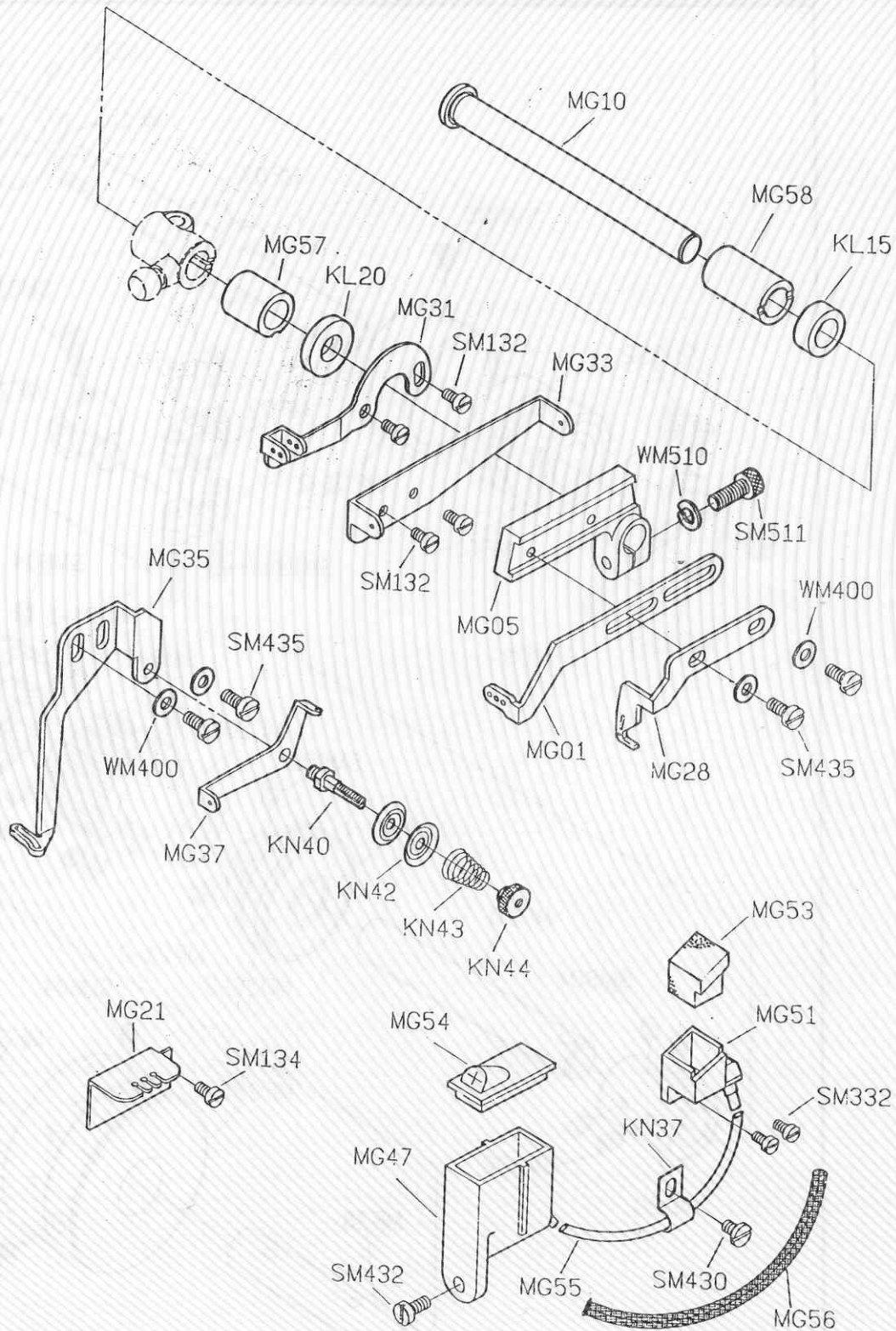
PARTS LIST FOR MH GROUP



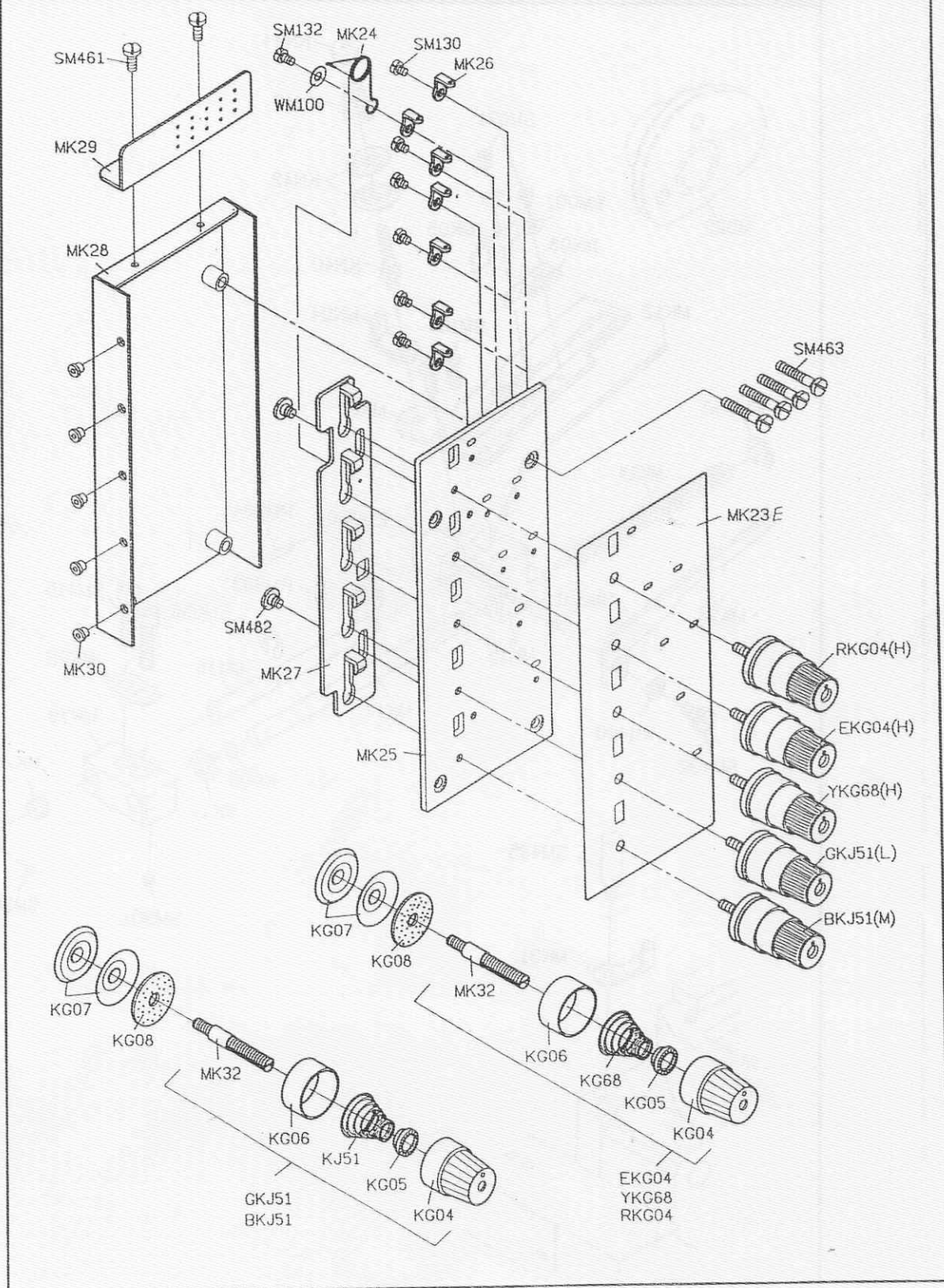
PARTS LIST FOR MF GROUP



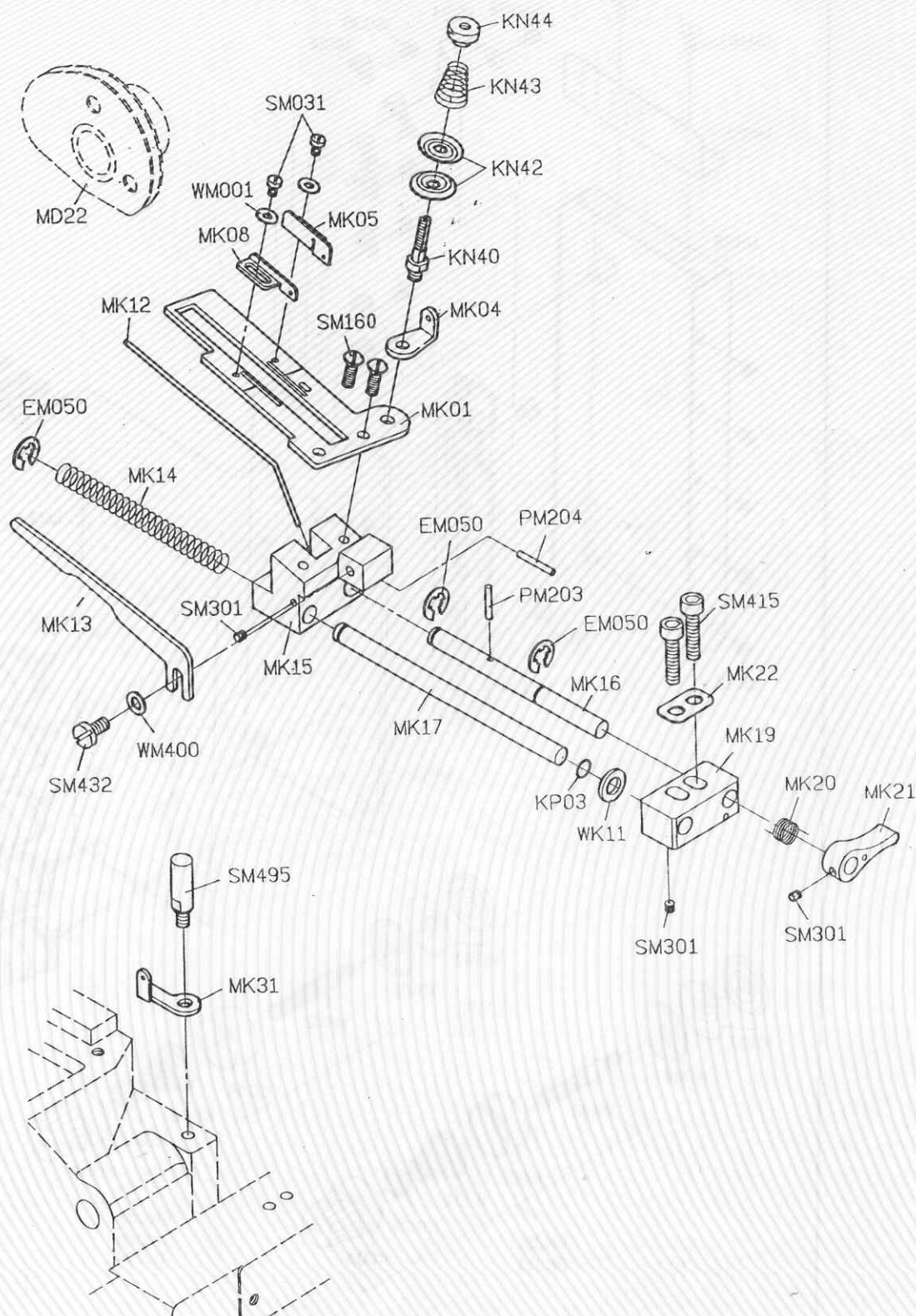
PARTS LIST FOR MG GROUP



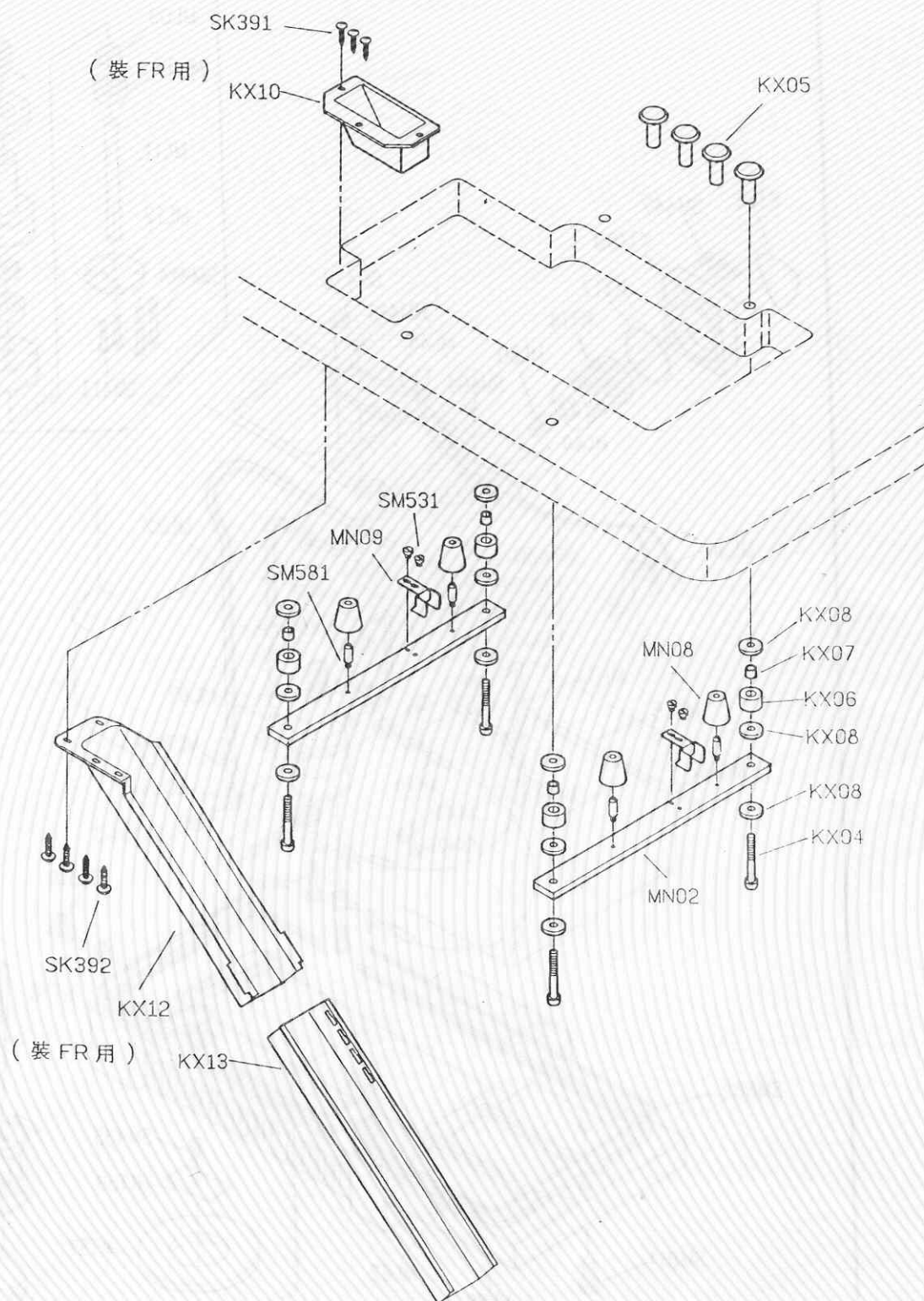
PARTS LIST FOR MK GROUP



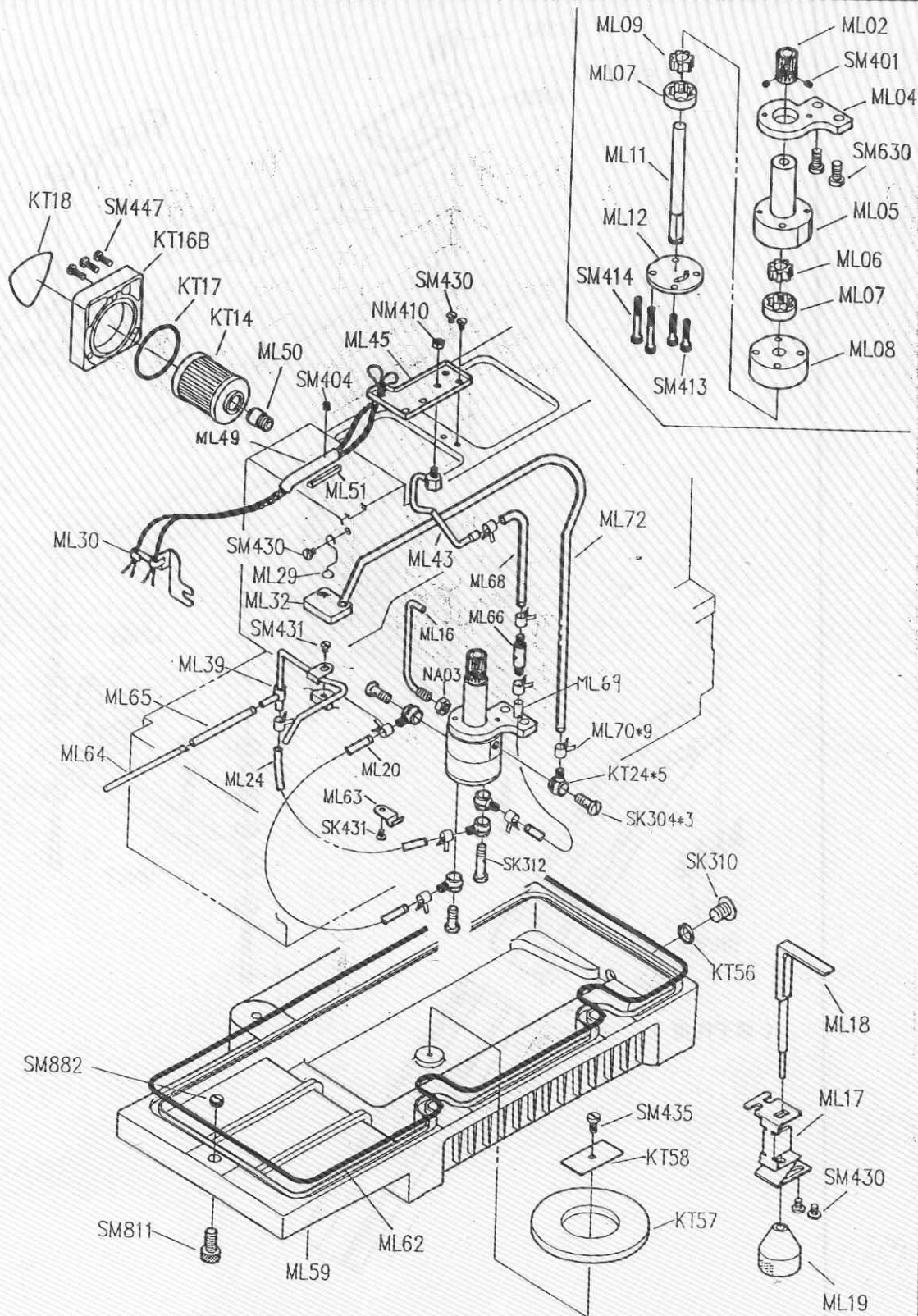
PARTS LIST FOR MK GROUP



PARTS LIST FOR MN GROUP



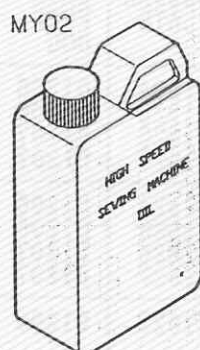
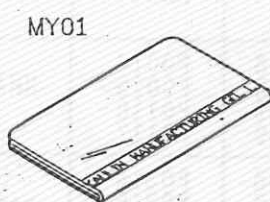
PARTS LIST FOR ML GROUP



SPARE PARTS CONVERSION CHART

MODEL FLAT-BED	GAUGE SIZE	NEELDE CLAMP	NEEDLE PLATE	MAIN FEED DOG	DIFF. FEED DOG	PRESSER FOOT	SPREADER	NEEDLE UY128GAS
W122	240 248 356 364	M4240 M4248 M4356 M4364	E1524 E1525 E1826 E1827	D1206 D1206 D1207 D1207	H1258 H1258 H1259 H1259	P0014 P0015 P0116 P0117	MH41	#10 #10 #11 #11
U122 <i>Feb made 1/4</i>	240 248 356 364	M4240 M4248 M4356 M4364	E1524 E1525 E1826 E1827	D1206 D1206 D1207 D1207	H1258 H1258 H1259 H1259	P0214 P0215 P0316 P0317	----	#10 #10 #11 #11
U122 /FP	232	M4232	E1623	D1206	H1257	P4011	----	#14
W123	240 248 356 364	M4240 M4248 M4356 M4364	E1534 E1535 E1836 E1837	D1206 D1206 D1207 D1207	H1258 H1258 H1259 H1259	P0014 P0015 P0116 P0117	MH41	#10 #10 #11 #11
W222 /FQ	240 248 356 364	M4240 M4248 M4356 M4364	E3024 E3025 E3326 E3327	D1215 D1215 D1216 D1216	H1261 H1261 H1262 H1262	P1814 P1815 P2116 P2117	MH41	#10 #10 #11 #11
U222 /FQ	240 248 356 364	M4240 M4248 M4356 M4364	E3024 E3025 E3326 E3327	D1215 D1215 D1216 D1216	H1261 H1261 H1262 H1262	P2314 P2315 P2616 P2617	----	#10 #10 #11 #11
W222 /FFD	240 248 356 364	M4240 M4248 M4356 M4364	E3024 E3025 E3326 E3327	D1215 D1215 D1216 D1216	H1261 H1261 H1262 H1262	P1814 P1815 P2116 P2117	MH41	#10 #10 #11 #11
U222 /FFD	240 248 356 364	M4240 M4248 M4356 M4364	E3024 E3025 E3326 E3327	D1215 D1215 D1216 D1216	H1261 H1261 H1262 H1262	P2314 P2315 P2616 P2617	----	#10 #10 #11 #11
W223	240 356 364	M4240 M4356 M4364	E3024 E3326 E3337	D1215 D1216 D1216	H1261 H1262 H1262	P1814 P2116 P2117	MH41	#10 #11 #11
W322 /FDC	356 364	M4356 M4364	E4826 E4827	D1207 D1207	H1359 H1359	P1406 P1407	MH41	#11 #11
U322 /FDC	356 364	M4356 M4364	E4826 E4827	D1207 D1207	H1359 H1359	P1606 P1607	----	#11 #11
W322 /FDE	356 364	M4356 M4364	E4836M E4837M	D1207 D1207	H1459 H1459	P2406 P2407	MH41	#11 #11
U322 /FDE	356 364	M4356 M4364	E4836M E4837M	D1207 D1207	H1459 H1459	P2606 P2607	----	#11 #11
W522 /FE(FFC) /FR	240 248 356 364	M4240 M4248 M4356 M4364	E6024 E6025 E6326 E6327	D2221 D2221 D2222 D2222	H2267 H2267 H2268 H2268	P2814 P2815 P3116 P3117	MH41	#10 #10 #11 #11
U522 /FE(FFC) /FR	240 248 356 364	M4240 M4248 M4356 M4364	E6024 E6025 E6326 E6327	D2221 D2221 D2222 D2222	H2267 H2267 H2268 H2268	P3314 P3315 P3616 P3617	----	#10 #10 #11 #11

PARTS LIST FOR MY GROUP



KY05



KY07

KY08

KY09



MY09

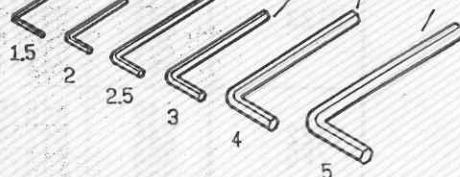
MY08

MY10

MY11

MY12

KY11

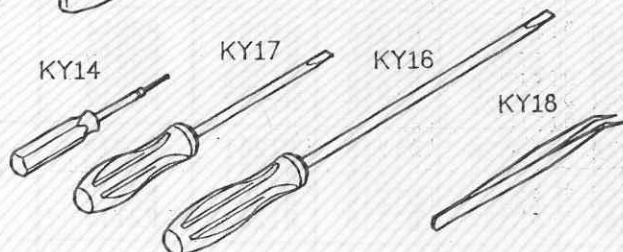


KY14

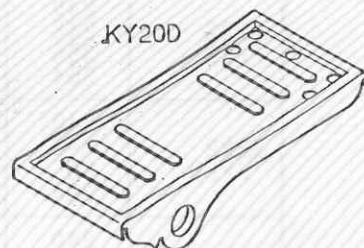
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KY16

KY18

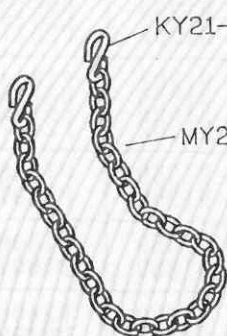


KY20D



KY21-1

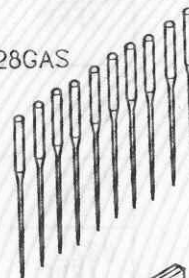
MY21



KT14

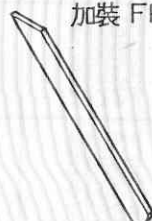


UY128GAS

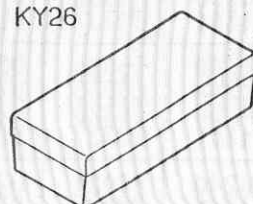


FR40

加裝 FR 時用

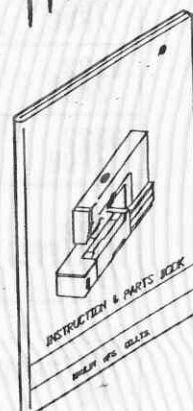


KY26



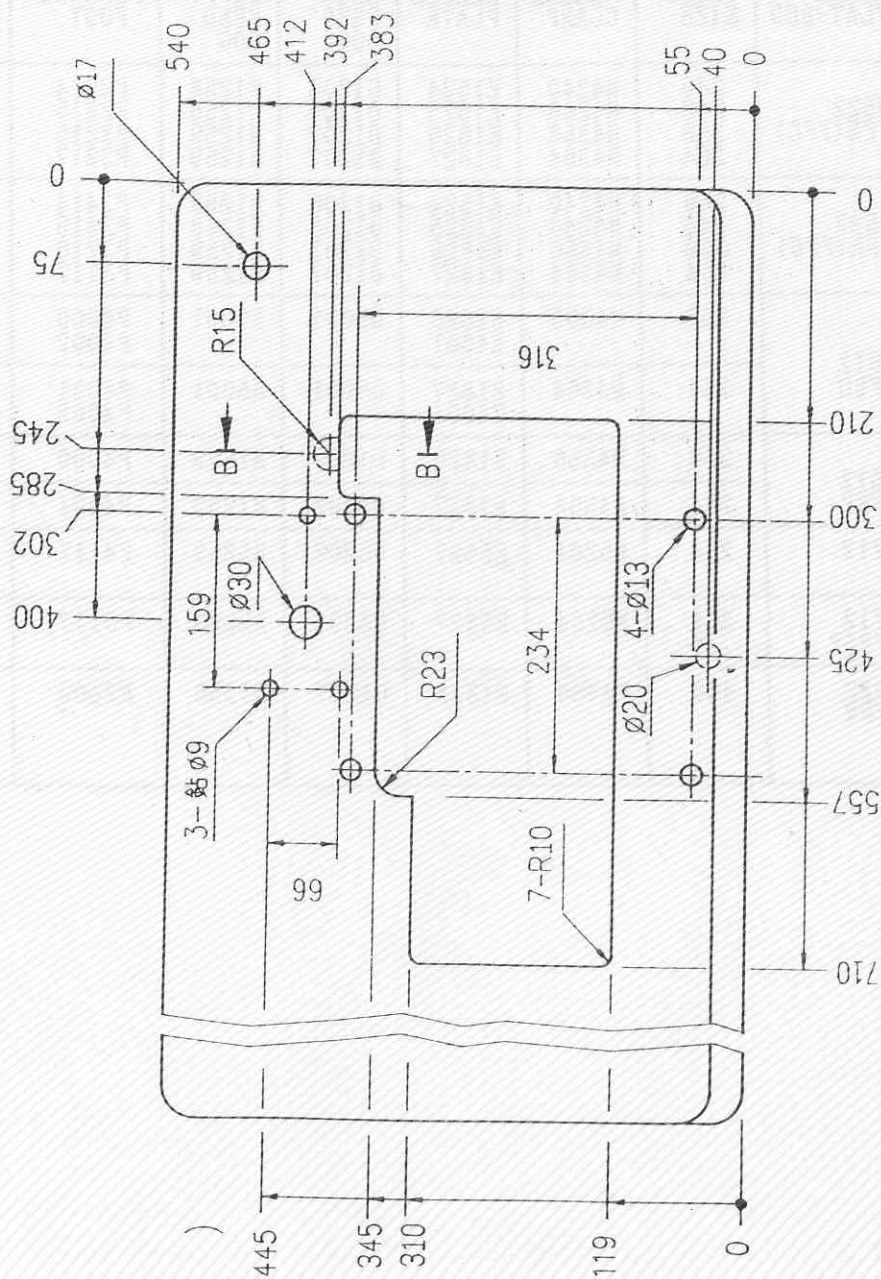
MY28

平車使用說明書



MODEL FLAT-BED	GAUGE SIZE	NEELDE CLAMP	NEEDLE PLATE	MAIN FEED DOG	DIFF. FEED DOG	PRESSER FOOT	SPREADER	NEEDLE UY128GAS
W522 /FE(FFC)	240 248 356 364	M4240 M4248 M4356 M4364	E1524 E1525 E1826 E1827	D1206 D1206 D1207 D1207	H1258 H1258 H1259 H1259	P2914 P2915 P3216 P3217	MH41	#10 #10 #11 #11
U522 /FE(FFC)	240 248 356 364	M4240 M4248 M4356 M4364	E1524 E1525 E1826 E1827	D1206 D1206 D1207 D1207	H1258 H1258 H1259 H1259	P3414 P3415 P3716 P3717	----	#10 #10 #11 #11
U612 /FBQ	256	M4356	E1826 E4001	D5001	H5001	P4000 P4002	----	#14 (#16)
	264	M4364	E1827 E4001	D5001	H5001	P4001 P4002	----	#14 (#16)
U612 /FBP	256	M4356	E1826	D1207	H1259	P4000	----	#14(#16)
	264	M4364	E1827	D1207	H1259	P4001	----	#14(#16)
U712	264	M5264	E5827	D5207	H5259	P4117	----	TV#3 #11 --#16
U712 /FSP	264	M5264	E5827	D5207	H5259	P5117	----	TV#3 #11 --#16
W922 /FW	460	M4460	E1828	D1207	H1259	P2408	MH41	MY1014B (UY118 GKS75) #11

TBBLE CUT-OUT NO. F007-T



Unit : M M

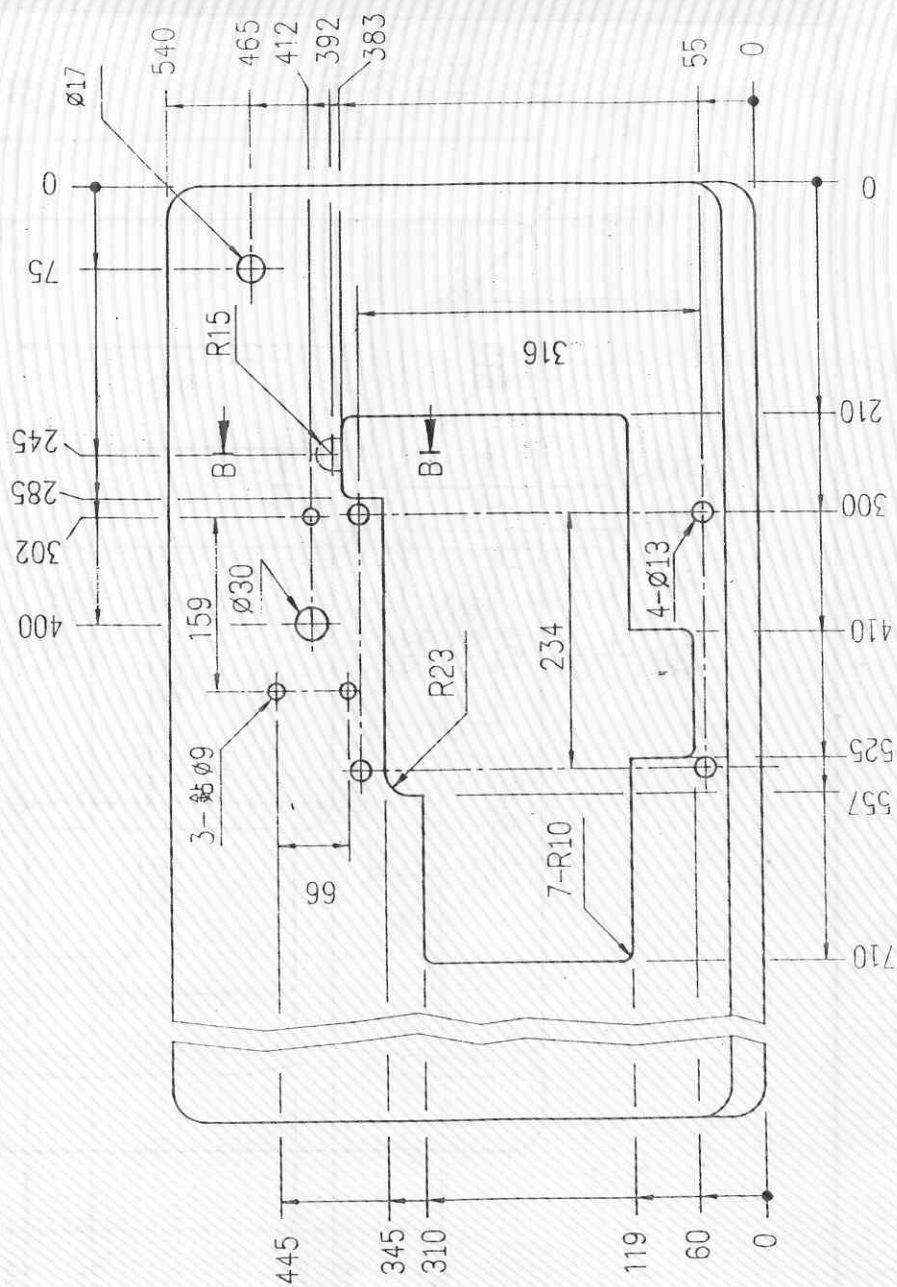
(ϕ 20 for FED

B · B SECTION

Difference : ± 2

[illegible]Difference : ± 2

TBBLE CUT-OUT NO. F007-T2



Unit : M M

B - B SECTION

Difference : ± 2