

JUKI TRAVETE

FY 1850

高速單針加固縫紉機
HIGH SPEED 1-NEEDLE TACKING SEWING MACHINE

說明書

Operation instruction



中国飞跃
CHINA FEIYUE

STUART JUKI TRAVEL

FY 1850

高車縫紉機

HIGH SPEED NEEDLE MACHINE

能開書

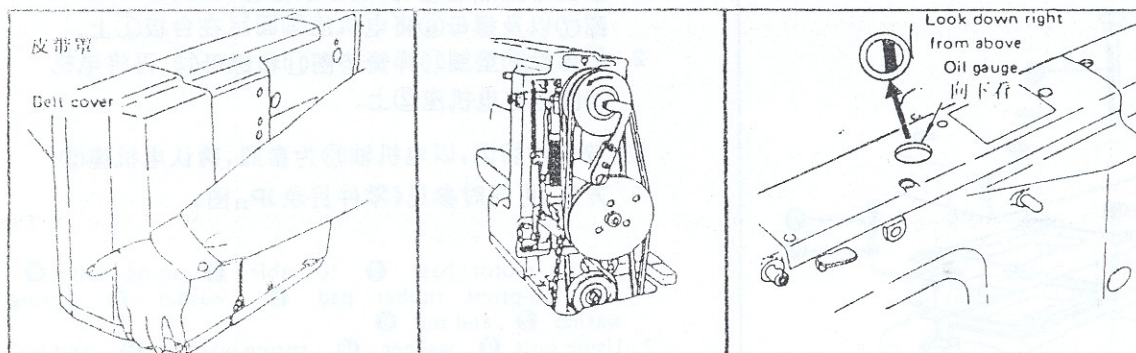
Operation instruction

中國出版
CHINA PUBLISHING

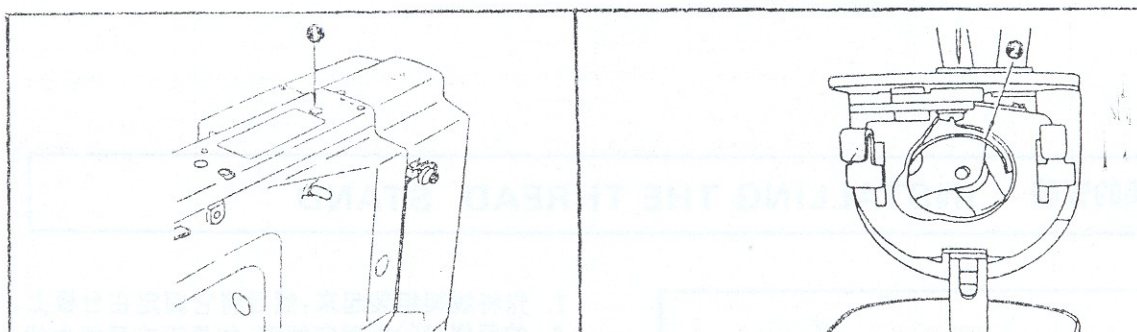


操作前注意事项

CAUTIONS BEFORE OPERATION



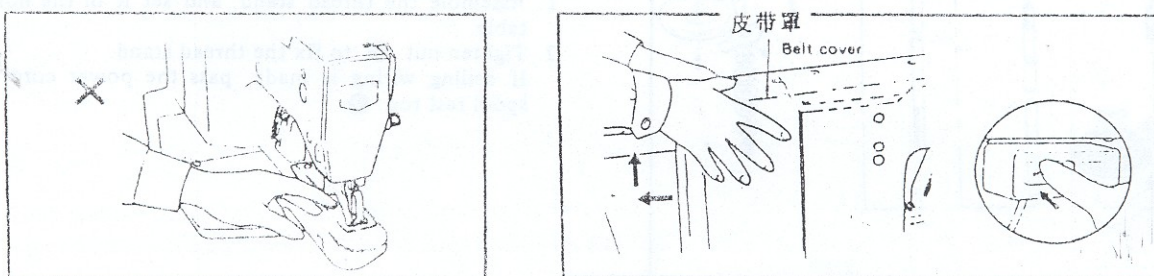
1. 搬动机器时切勿搬动皮带罩。
 2. 机器上轴转动方向为箭头方向, 不得反向。
 3. 观察图中油标处是否有红色标记, 如果有则要根据后面“九、机器的润滑”栏中所述进行加油。
1. Do not hold the belt cover when carrying the sewing machine
 2. The sewing machine should run in the arrowed direction. Never allow the machine to run in the reverse direction.
 3. If the red color is observed in the oil gauge when looking down from just above the oil gauge, supply the lubricating oil according to "9. Lubrication".



4. 在新的或放置已久的机器起动前, 要通过油孔①向上轴部件加几滴润滑油, 再向梭道表面②加一滴油。
4. Before starting a machine which has been newly set up or has not been used for a long period of time, apply a few drops of the lubricating oil to main shaft components through hole ①, one drop to the racing surface ② of the shuttle race,

操作中的注意事项

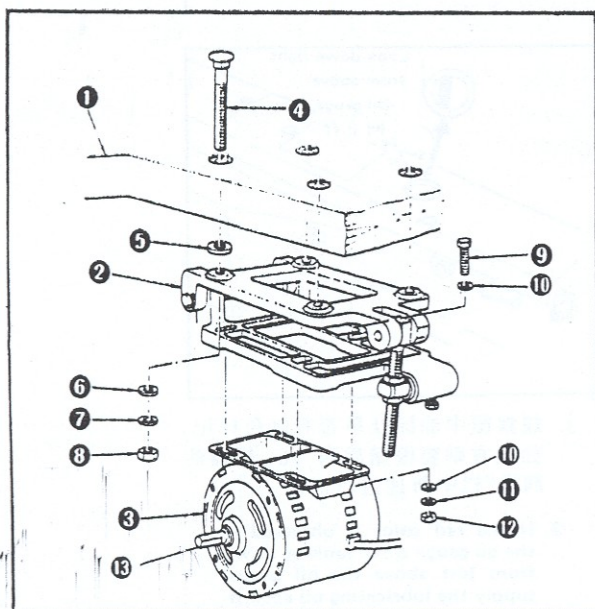
CAUTIONS IN OPERATION



1. 在操作机器过程中切勿将手指靠近压脚。
2. 拆卸皮带罩前, 务必将电源开关关掉。
3. 在操作机器过程中, 不要将手指或头发接近任何转动件, 如 V 型皮带绕线轮等, 以免发生人身事故。
4. 操作机器时, 切勿将皮带罩, 护指安全框及护眼安全板拆掉。

1. Do not place your fingers near the work clamp foot while the machine is in operation
2. Make sure to turn off the power switch before removing the belt cover.
3. Never bring your fingers or hair close to, or place anything on the handwheel, V-belt, bobbin winder wheel or motor during operation. It may lead to serious personal injuries.
4. If your machine is provided with a belt cover, finger guard and eye guard, never operate your machine with any of them removed

一、电机的安装 INSTALLING THE MOTOR



1. 按图示用螺栓④、防震橡胶垫⑤、垫圈⑥、弹簧垫圈⑦以及螺母⑧将电机座②固定在台板①上。
2. 用螺栓⑨、垫圈⑩、弹簧垫圈⑪和螺母⑫，再将电机③固定在电机座②上。

注：按装时切记，以电机轴⑬为参照，确认电机座②方向，可同时参见《零件目录》P₂₁图。

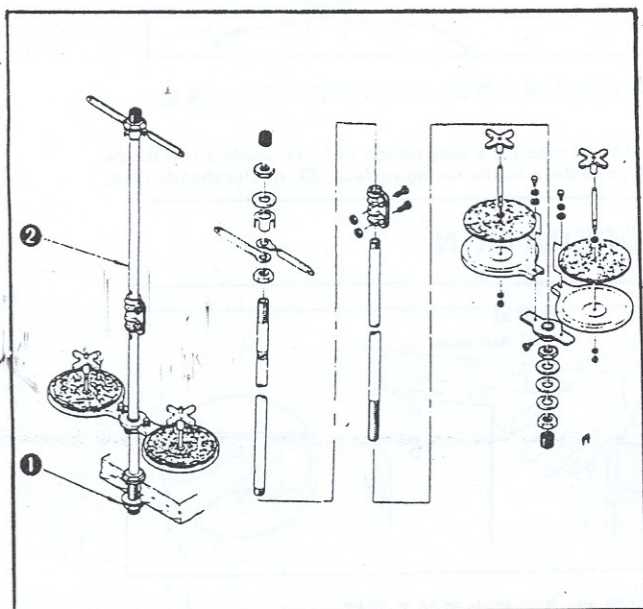
1. Attach motor base ② to table ① using bolt ④, vibration-proof rubber pad ⑤, washer ⑥, spring washer ⑦, and nut ⑧.
2. Using bolt ⑨, washer ⑩, spring washer ⑪, and nut ⑫, install motor ③ to motor base ②.

Note:

When installing, please determine the direction of the motor base ② comparing with the shaft of motor

⑬ You can also see the figure of "Parts List" Page 21.

二、线架的安装 INSTALLING THE THREAD STAND

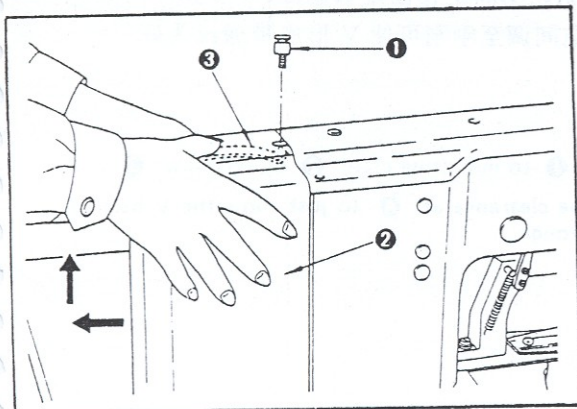


1. 先将线架组装起来，然后将它固定在台板上。
2. 拧紧螺母①以固定线架，如果设有吊式电线，则可将电源线通过线架杆空心穿过。

1. Assemble the thread stand, and set it in the hole in the table.
2. Tighten nut ① to fix the thread stand.
If ceiling wiring is made, pass the power cord through spool rest rod ②.

三、拆卸皮带罩

REMOVING THE BELT COVER

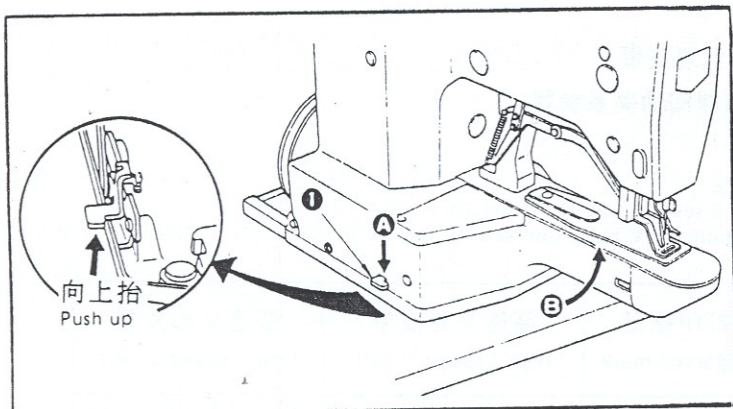


1. 将机器放在安装位置后,拧去螺钉①,皮带罩即可容易而迅速地装卸。
2. 拆卸皮带罩,先朝你的方向拉出使锁紧板簧③脱开,然后向上提,即可拆下。安装皮带罩时则按上述步骤反之即可。

1. After carrying the sewing machine to a desired installing place, remove setscrew ①, then belt cover ② can be attached or removed very easily and quickly.
 2. To remove the belt cover, pull it towards you until holding spring ③ is released, then lift it off.
- ★ Install the belt cover by reversing the above procedure.

四、机头的翻转

RAISING THE MACHINE HEAD

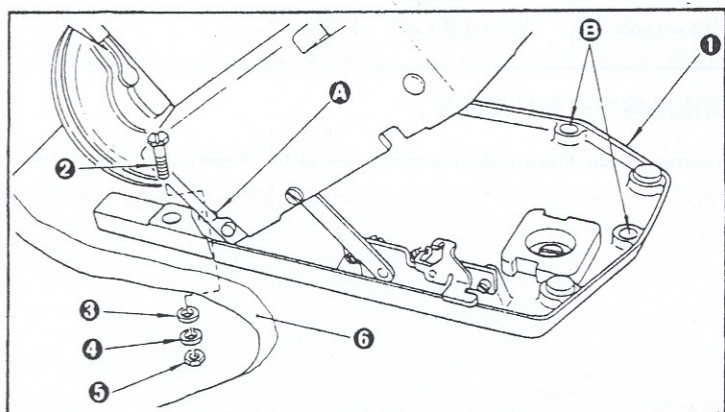


1. 拆去皮带罩,在机器固定在台板上的情况下,沿方向A按下机头锁紧板①时,即可翻转机头。
 2. 放开机头锁紧板,然后继续延方向B翻转机头直到锁紧为止。
- 若要放下机头则可抬起机头锁紧板即可放下机头。

1. Remove the belt cover. With the machine head set in its installing position on the machine table, raise the machine head in direction B while pushing down (in direction) A bed locker ①.
 2. Releasing the bed locker, further raise the machine head in direction B until it locks.
- ★ To lower the machine head, push up the bed locker to release the lock.

五、机头的安装

INSTALLING THE MACHINE HEAD

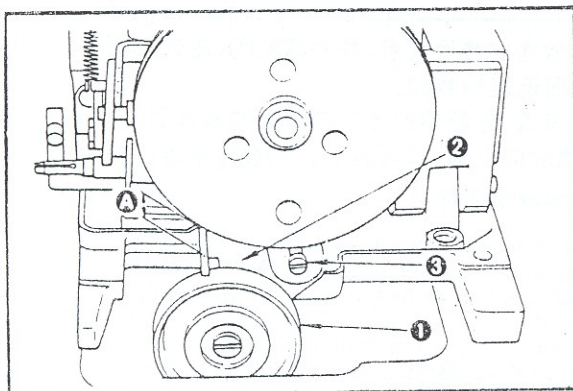


1. 首先将机座①用螺栓②垫圈③和④以及螺母⑤(每种3件),固定在台板⑥上。
2. 首先固定A点,然后翻转机头,再固定两B点。

1. Install bed mounting base ① to machine table ⑥ using bolts ②, flat washers ③ and ④, and nut ⑤ (each 3 pcs.).
2. Fix point A before raising the machine head. Then fix two points B.

六、安装空转皮带轮

ATTACHING THE IDLER PULLEY



由螺钉③将涨紧轮①固定在固定板②上。

(注): 将 A 处空间调至刚刚可使 V 形皮带通过为好。

Fix idler pulley ① to mounting plate ② by screw ③

(Note) Adjust the clearance at ② to just allow the V belt to pass it through.

七、电机皮带轮及皮带的选择和安装

MOTOR PULLEYS AND BELTS

(一) 选择 Choose

1. 该型机器使用 O 型三角皮带。
2. 该机使用两条 V 形皮带, 一个是高速皮带, 一个是低速皮带。
3. 下面表格所列为各种电机皮带轮, V 形皮带以及缝速间的关系参数。

1. M-type V belts are used for this model of sewing machine.
2. This sewing machine uses two V belts, one for high-speed sewing, and the other for low-speed sewing.
3. The table below shows the relation between the motor pulleys, V belts, and sewing speeds.

频率 Frequency	缝速针/分 Sewing speed	电机皮带轮图号 Motor pulley part No.	打印标记 Engarved mark	高速 V 形皮带 High-speed V belt	低速 V 形皮带 Low-speed V belt
50Hz	2300	* 11-9	50-2300	11-12 (50")	11-12 (46")
	2000	* 11-9	50-2000	11-12 (49")	
	1800	* 11-9	50-1800	11-12 (48")	
60Hz	2300	* 11-9	60-2300	11-12 (49")	11-12 (46")
	2000	* 11-9	60-2000	11-12 (48")	
	1800	11-9	60-1800	11-12 (47")	

注: 带 * 号的电机皮带轮仅用于使用棉线的机器, 请订购使用棉线的电机皮带轮。

Note: The motor pulleys marked with asterisks are applicable only to cotton thread. Please order the motor pulleys for threads other than cotton thread.

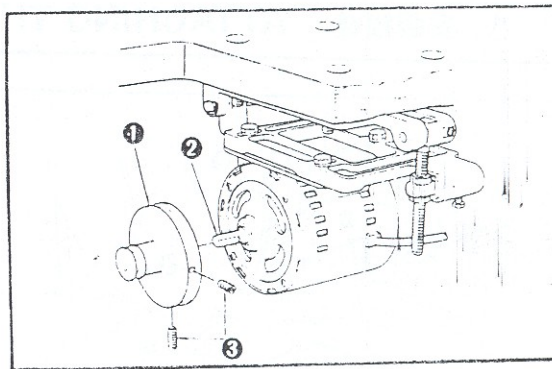
(二) 安装

* 安装电机皮带轮

Installing the motor pulley

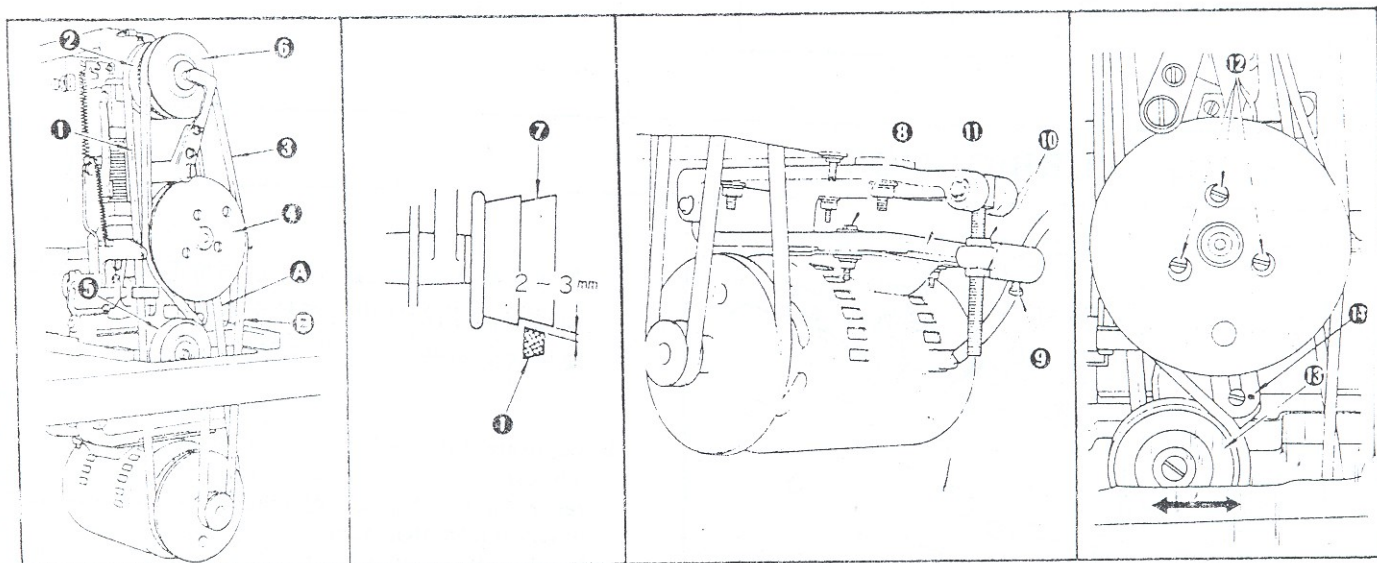
首先将电机皮带轮①装在电机轴②上,使一个螺钉③固定在电机轴的平面上,然后将另一个螺钉③固定即可。

Set motor pulley ① onto motor shaft ② so that one of two setscrews ③ meets the flat part of the motor shaft. Then tighten setscrews ③.



* 安装电机皮带

Attaching the belts

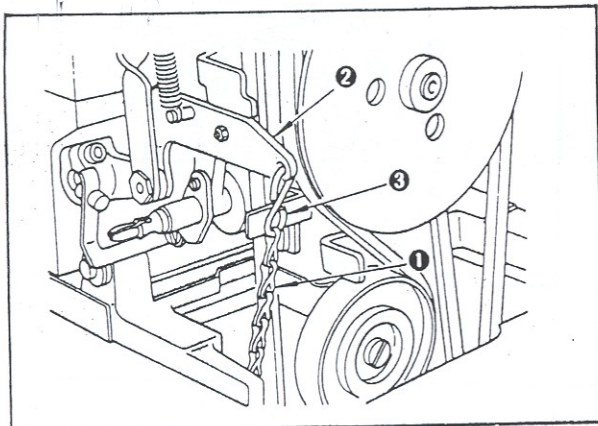


- (1) 将高速 V 形皮带①装在高速皮带轮②和大直径的电机皮带轮上。
- (2) 将低速 V 形皮带装在低速皮带轮⑥上,并通过减压轮①和涨紧轮⑤装在小直径的电机皮带轮上。
- (3) 将电机皮带轮前后移动至使高速 V 形皮带①和绕线轮⑦之间的距离为 2~3mm 为止。
- (4) 松开螺钉⑧并左右移动电机以使在绕线时高速 V 形皮带均匀地与绕线轮保持接触。(参见十五, 梭芯的绕线)
- (5) 松开螺钉⑨通过螺母⑩进行调整上下移动电机⑪,使得当您在高速 V 形皮带中部④处,互相压动时可有 10mm 的压动量
- (6) 松开螺钉⑫,并且沿箭头方向移动涨紧轮⑬,以便当您在低速 V 形皮带中部③处相互压动时可有 10mm 的压动量。(在安装涨紧轮⑬时,要使其紧固螺钉与固定板上的标记孔⑭并列)。

1. Set high-speed V belt ① on the large diameters of high-speed pulley ② and the motor pulley.
2. Set low-speed V belt ④ on the small diameters of lowspeed pulley ⑥ and the motor pulley through pressure decreasing pulley ① and idler pulley ⑤.
3. Move the motor pulley back or forth to provide a 2 to 3mm clearance between high-speed V belt ① and bobbin winder wheel ⑦.
4. Loosen setscrew ⑧, and move the motor to the right or left to make adjustment so that the high-speed V belt comes evenly in contact with the bobbin winder wheel when the bobbin winder is used (refer to 15, Winding a bobbin).
5. Loosen setscrew ⑨ and move motor base ⑪ up or down by adjusting nut ⑩ to perform adjustment so that the high-speed V belt slacks about 10mm when you push the belt at middle ④.
6. Loosen setscrew ⑫, and move idler pulley ⑬ in the arrowed direction to perform adjustment so that the low speed V belt slacks about 10mm when you push the belt at middle ③. (At this time, set the idler pulley so that it is aligned with engraved marker dot ⑭ on the installing plate.)

八、安装锁链

ATTACHING THE CHAIN

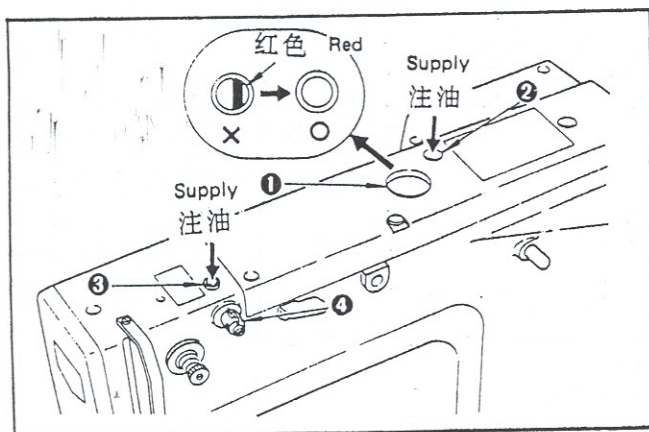


将 S 型链勾③挂在起动杆②上,然后再将链条①挂在 S 型链勾上。

Hook S-shaped hook ③ into the hole in the tip of starting lever ②, and attach chain ① to the S-shaped hook.

九、润滑

LUBRICATION



每天要润滑一次机器,可通过润滑油孔②加油观察油标①,直到油标中的红标记消失为止。
使用润滑油采用变压器油即可(SYB1351)

1. Lubricate the machine once everyday. Supply the lubricating oil through lubricating hole ② until the red color in oil gauge ① completely disappears as observed from right above the oil gauge.
2. Use Juki New Defrix Oil No. 2 or spindle oil No. 2 as the lubricating oil.

使用合成纤维线时注意:

要向油孔③加入硅油,这时检查一下已穿过过线勾④的线上面,是否有硅油。

★ When using the thread guide a synthetic fiber thread

Supply silicone oil through silicone oil lubricating hole ③ when using thread guide ④ for a synthetic fiber thread. At this time, check that the thread which has passed through thread guide ④ has the silicone oil on it.

十、机器的操作

OPERATING THE SEWING MACHINE

操作机器程序如下:

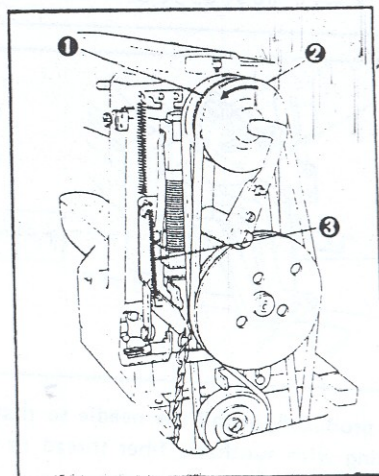
1. 打开电源开关。
2. 稍微踏下起动踏板,压脚即落下,如果您想使压脚再抬起,则放开踏板即可。
3. 再继续踏动起动踏板,则机器即开始打结,这时应马上放开脚踏板。
4. 当机器完成一个加固结缝后,线即被自动剪断,压脚自动抬起。

Operate the sewing machine in the following procedure:

1. Turn on the power switch.
2. Depress the starting pedal a little, and the work clamp foot will come down. When you want to make the work clamp foot go up, release the pedal.
3. Further depress the pedal, and the sewing machine starts bar-tacking. Immediately after the sewing machine starts bar-tacking, release the pedal.
4. When the machine has completed the specified bar-tacking cycle, the work clamp foot will automatically go up, and the needle and bobbin threads are trimmed before the machine stops.

(注意):

1. 当机器开始打结时要尽快地释放起动踏板, 否则机器就不会在预定的位置上停下来。
2. 如果你不完全释放踏板, 则机器将可能停在第一针处, 这时可以再完全地踏下踏板以进行缝纫。
3. 如果完全踏下踏板, 机器仍不起动, 则关上开关, 取下皮带罩, 然后以低速皮带轮②的箭头方向转动转速轮①(带滚花纹)。
4. 该机器在较寒冷的早晨可能运转得不灵活, 这是因为机器使用的润滑油脂所致, 在这种情况下, 可在工作前空转 5~6 次即可。



手动操作机器:

关掉开关, 取下弹簧③的上端, 沿箭头方向使低速皮带轮转两圈, 压脚即落下, 然后踏下起动踏板, 这时机器即可手动操作。

- (Cautions)
1. Be sure to release the pedal as soon as the machine starts bar-tacking, or else the machine will not stop at the predetermined point.
 2. If you fail to depress the pedal sufficiently, the machine may stop at the first stitch. In this case, depress the pedal gain sufficiently.
 3. If the machine will not start even when you depress it strong enough, turn of the power switch, and remove the belt cover. Then turn changeover pulley ① (Knurled part) in the arrowed direction of low-speed pulley ②.
 4. This sewing machine may run rather unsmoothly on a cold morning because it uses grease for the lubrication of several parts. In such a case, allow the machine to idle for 5 or 6 times before starting the work.

★ To operate the sewing macine manually;

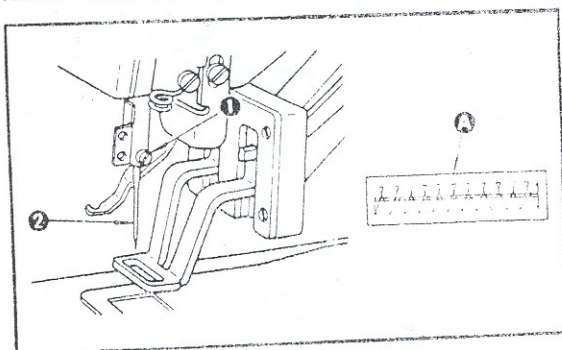
Turn off the power switch, remove the upper end of spring ③, give low-speed pulley ② two turns in the arrowed direction and the work clamp foot will come down. Then depress the starting pedal, and the machine can be run manually.

十一、面料及机针的选用 MATERIALS AND NEEDLES TO BE USED

面料 Material	机针 Needle	针板座 Needle plate needle nole guide	产品种类 Class or work
合成纤维料 Synthetic fiber material	# 14(DP×5, 高级) # 14(DP×5, SUPER needle)	3-19.1	男西装、女装 Men' suits, Ladies' wear
中厚料 Medium-weight material	# 16(DP×5)	3-19.1	男西装、女装 Men's suits, Ladies' wear
厚料 Heavy-weight material	# 18(DP×5)	3-19.1	工作服、外装 Working wear, overcoats

十二、机针的安装

ATTACHING THE NEEDLE



松开螺钉①，将机针②完全插入针杆孔中，并使机针长槽面向操作者，然后拧紧螺钉①即可。

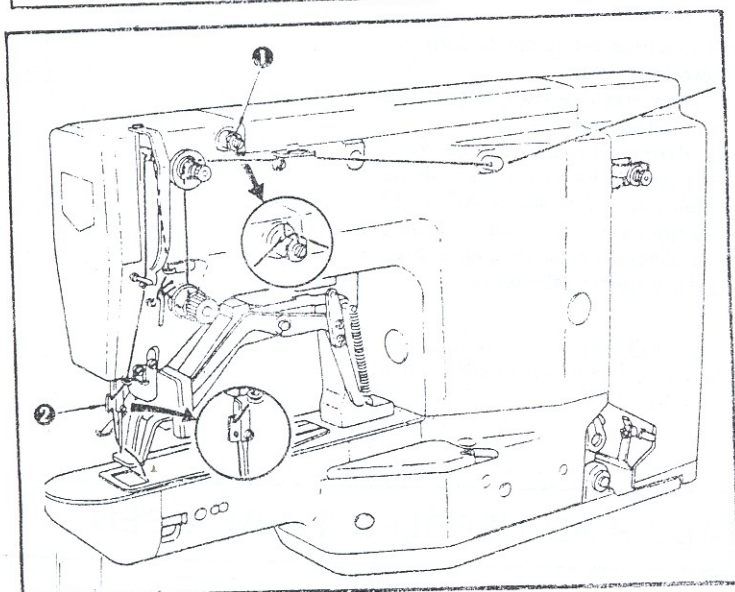
(注): 1. 如果打结出现图中所示A, 则可将机针稍向左转一下。2. 缝制合成纤维布料时, 用合成纤维线, 并且使用特别好的机针。

Loosening setscrew ①, insert needle ② fully into the needle bar hole with the long groove of the needle facing towards you, then tighten setscrew ①.

(Note) 1. If the bar-tacking stitches as A shown above are produced, install the needle so that it slightly faces to the left. 2. Use a SUPER needle for synthetic fiber when sewing with synthetic fiber thread or material.

十三、穿线

THREADING THE MACHINE



穿针方法如图所示, 最后留在机针上的线头大约4厘米。

(注): 1. 用合成纤维线时(使用硅油)要把线通过硅油润滑的过线钩①。

2. 用细线时, 只须穿过针杆导线板②上一个孔即可。

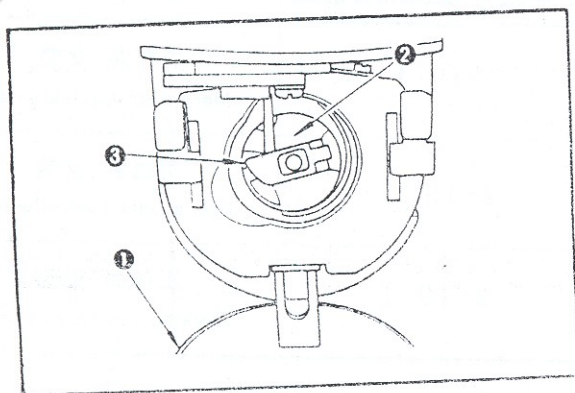
Thread the machine in the order as shown above. Leave thread of approx. 4cm on the needle.

(Note) 1. For a synthetic fiber thread (silicone oil is used), pass the thread also through silicone lubricant thread guide ①.

2. For a thick thread, pass the thread through only one of the two holes in needle bar thread guide ②.

十四、装卸梭芯套

REMOVING AND INSTALLING THE BOBBIN CASE

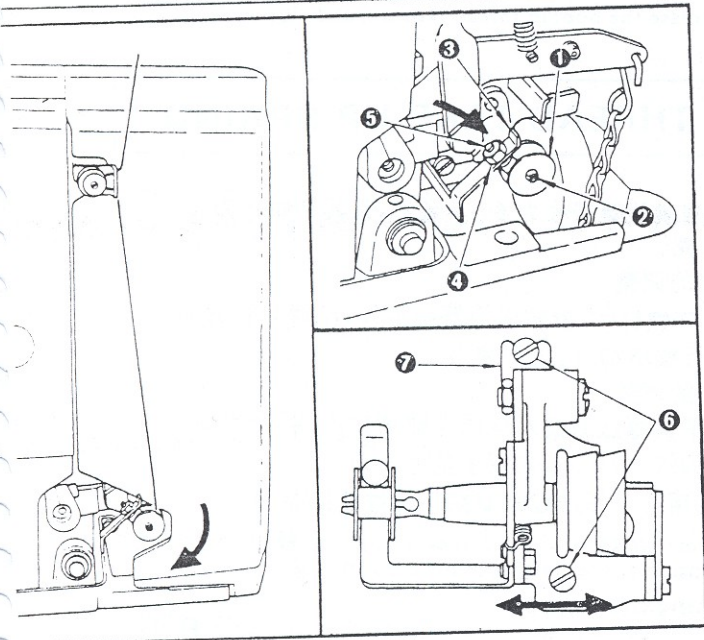


1. 打开罩盖①。
2. 抬起梭芯套②的梭门盖③即可取出。
3. 要将梭芯套装入梭床时, 先将梭芯套装入摆梭轴, 然后按紧梭门盖即可听到到位的声音。

1. Open cylinder arm cap ①.
2. Raise and hold the latch lever of bobbin case ② to take it out. The bobbin in the bobbin case does not fall as far as latch lever ③ is raised and held.
3. To load the bobbin case into the shuttle, fit it onto the shaft of the shuttle and snap in the latch lever of the bobbin case.

十五、梭芯的绕线

WINDING A BOBBIN



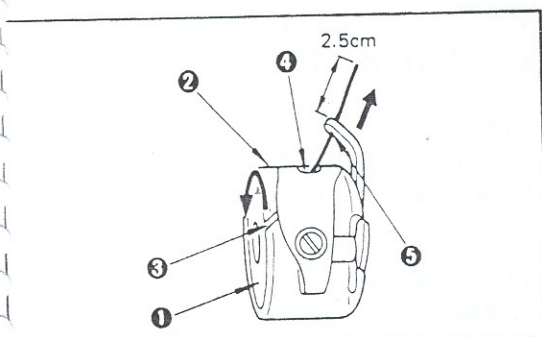
1. 将梭芯①装在绕线轴②上。
2. 将线按图所示绕在梭芯上 4~5 圈。
3. 将绕线行程板③压向梭芯, (如图箭头方向), 即开始绕线, 待梭芯绕满 (梭芯容量的 80%) 即自动停止绕线。
4. 若要调节梭芯的绕线量, 可松开螺母④和螺钉轴⑤进行调节。
5. 如果梭芯绕线不平整, 可松开螺钉⑥, 并移动绕线固定板⑦ (沿箭头方向) 进行调整即可。

1. Attach bobbin ① to bobbin winder spindle ②.
2. Thread the winder in the order as illustrated and wind the thread onto the bobbin four or five turns.
3. Push bobbin winder trip latch ③ towards the bobbin (in the arrowed direction), and the winder starts to wind the bobbin. The winder will automatically stop as soon as it has wound a predetermined amount (80% of the capacity of the bobbin) of thread round the bobbin.
4. To adjust the amount of thread wound round the bobbin, loosen nut ④ and screw in adjusting screw ⑤ to decrease the thread amount.

If the thread is not wound evenly round the bobbin, loosen screw ⑥ and move bobbin winder base ⑦ in the arrowed direction to make adjustment.

十六、梭芯套的穿线

THREADING THE BOBBIN CASE



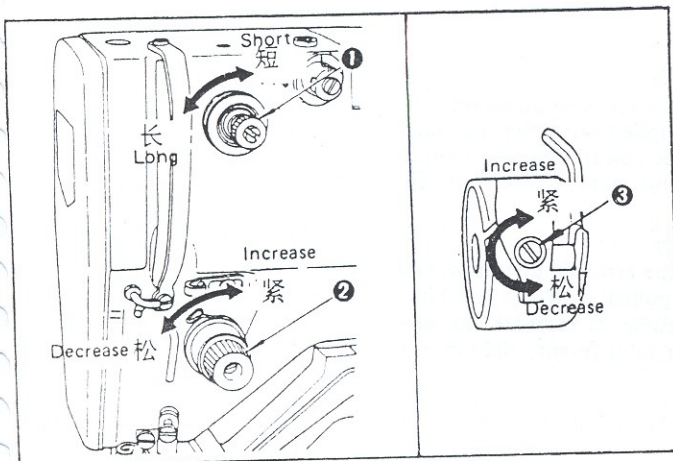
1. 将梭芯①装入梭芯套②中, 并使梭芯绕线方向为逆时针方向。
2. 将线通过槽口③, 并使其经过弹簧片下面, 通过线出口④, 这时拉线, 梭芯转动方向应为逆时针, 即图所示方向。
3. 然后, 再将线穿过孔⑤, 并使线头保留约 2.5 厘米即可。

1. Hold bobbin ① in hand so that it spins counter-clockwise and set it in bobbin case ②.
2. Pass the thread through slot ③ in the bobbin case. Pull the thread to pass it under the tension spring out to thread exit ④. At this time, confirm that the bobbin spins in the arrowed direction when the thread is pulled.

3. Pass the thread through hole ⑤, and allow the thread to trail about 2.5cm from the hole.

十七、线的松紧调整

THREAD TENSION



* 机针线松紧的调整

将 1 号压线器①沿顺时针方向旋转时, 在剪线后留在机针上的线头量就会减短, 反之则增长, 最小留线量以针线不得滑出机针为原则。当 2 号压线器②沿顺时针旋转时, 机针线的张力增加, 反之减少。

* 梭芯线松紧的调整

旋转调节螺钉③沿顺时针方向, 梭芯线的张力增加, 反之减少。

★ Adjusting the needle thread tension

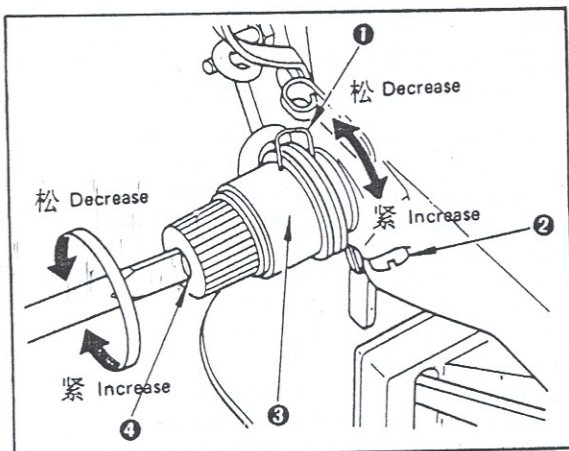
As thread tension controller No. 1 ① is turned clockwise, the length of the thread remaining on the needle after thread trimming will decrease, and vice versa. Minimize the length of the thread remaining on the

needle as far as the thread does not slip off the needle. As thread tension controller No. 2 ② is turned clockwise, the needle thread tension increases, and vice versa.

★ Adjusting the bobbin thread tension

Turning thread tension adjusting screw ③ clockwise will increase the bobbin thread tension, and vice versa.

十八、挑线簧的调整 ADJUSTING THE THREAD TAKE-UP SPRING



通常挑线簧行程为 6~8 毫米,且其初始张力为 30~50 克。

* 行程的调整

松开螺钉②,旋转压力器组件③,沿顺时针方向旋转时行程增加,反之则减小。

* 张力的调整

将平头螺丝刀插入夹线螺轴槽口④,顺时针旋转可增加张力,反之,则减小压力。

(注):使用合成纤维线时要减小挑线簧的张力。

The normal stroke of thread take-up spring ① is 6 to 8mm, and the tension at the starting point is 30 to 50g.

★ Adjusting the stroke

Loosen screw ②, and turn tension controller assembly ③ clockwise to increase the stroke or counterclockwise to decrease it.

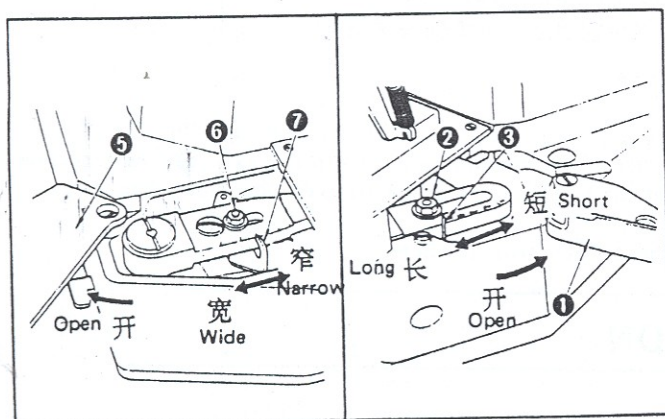
★ Adjusting the tension

Insert the blade of a flat-bit screwdriver into the groove in the tension post ④, and turn it clockwise to increase the tension or counterclockwise to decrease it.

(Note) Decrease the tension of the thread take-up spring for a synthetic fiber thread.

十九、打结长度调整和宽度的调整

ADJUSTING THE LENGTH AND WIDTH OF BAR-TACKING



* 打结长度的调整

沿箭头方向按推右侧盖①将其打开,然后松开螺母②将调节板向操作者方向滑动时,可增长打结长度,反之则减小打结长度,调节完毕要将螺母②拧紧后盖好右侧盖①。

* 打结宽度的调整

沿箭头方向将左侧盖⑤按动推开,松开螺母⑥然后沿逆时针方向转动调节板⑦可增加打结宽度,反之则减小打结宽度,调整完毕后将螺母⑥拧紧并盖上左侧盖⑤。

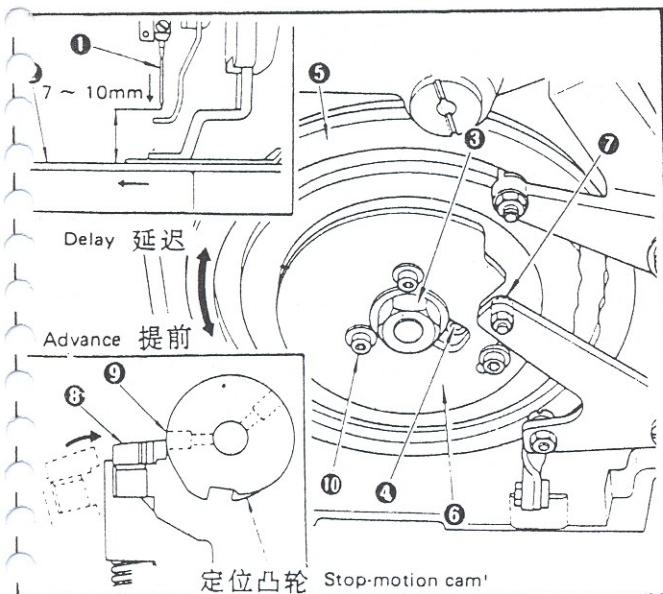
★ Adjusting the bar-tacking length

Push and open bed cover (A) ① in the arrowed direction, and loosen nut ② using the wrench supplied with the machine. Turn feed across regulator ③ towards you to increase the bar-tacking length, and vice versa. After adjustment, tighten nut ② and close bed cover (A) ①.

★ Adjusting the bar-tacking width

Push and open bed cover (B) ⑤ in the arrowed direction, and loosen nut ⑥ using the wrench supplied with the machine. Turn feed regulator ⑦ counterclockwise to increase the bar-tacking width, and vice versa. After adjustment, tighten nut ⑥, and close bed cover (B) ⑤.

二十、送料时间的调整 ADJUSTING THE FEED TIMING

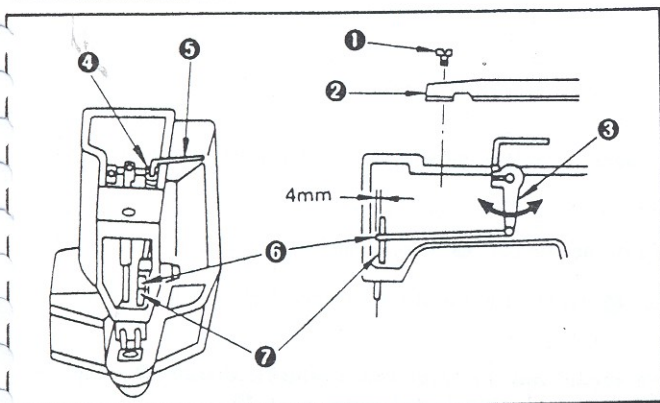


1. 将机头翻转(见“四、机头的翻转”)。
2. 松开六角螺母③和内六角螺钉④转动送料凸轮⑤进行调整,使机针降到距针板表面②距离为7~10毫米时完成拖布,沿顺时针方向转动送料凸轮则延长完成拖布时间,反之则缩短完成拖布时间。
3. 调整完毕,务必要将内六角螺钉④和六角螺母③拧紧。
* 如上所述当机针高度约为7毫米时,线的张力较为合适。
* 如果使用合成纤维线,起始线迹松弛时可以如上所述将机针高度调至约10毫米,即可防止出现这种现象。
4. 因为制动变速凸轮⑥和送料凸轮⑤一起转动,为此要松开螺钉⑩,转动制动变速凸轮进行调整,使得在最后一针时停车块⑧落入定位凸轮⑨第一螺钉处,以使制动变速凸轮转子轴⑦由低速运转进入停止运动。

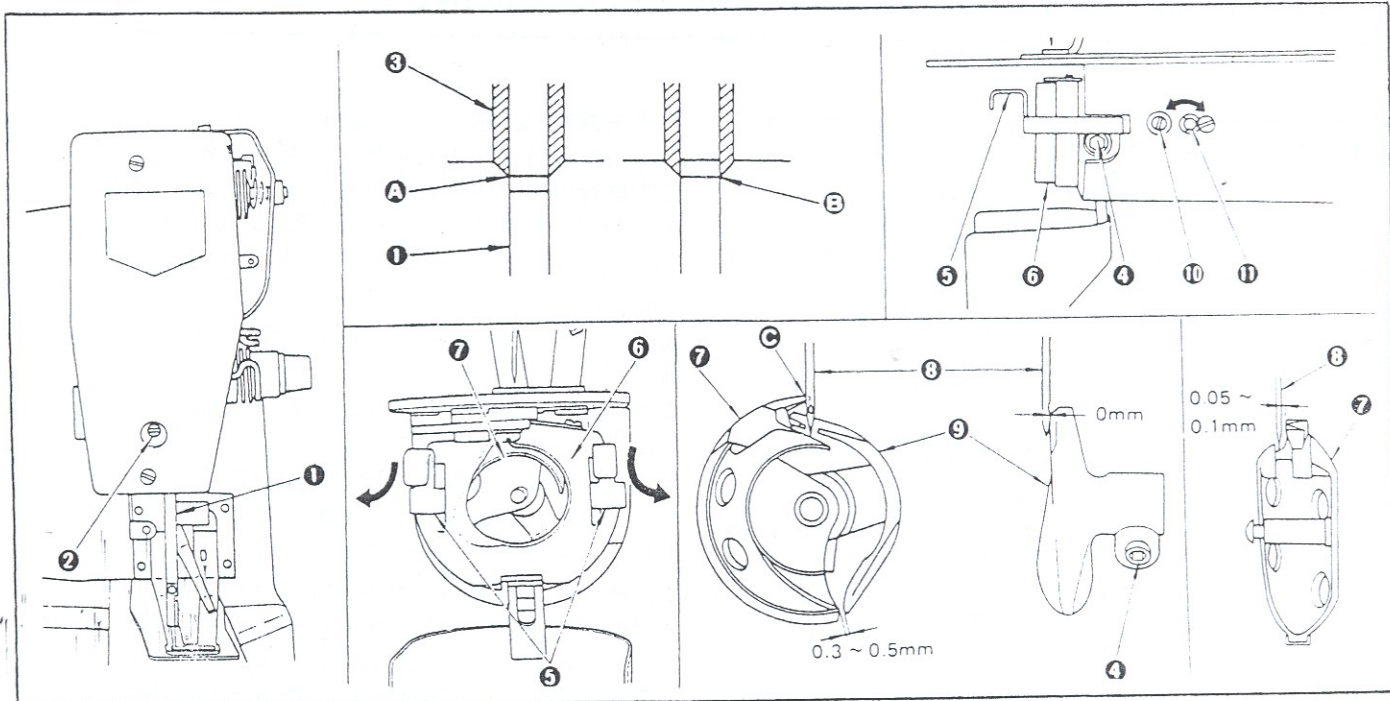
1. Raise the machine head. (See "4. Raising the machine head")
2. Loosening hexagon nut ③ and socket screw ④, turn feed cam ⑤ to perform adjustment so that the material feed is completed at the moment the point of needle ① has lowered to a height of 7 to 10mm above the surface of throat plate ②. Turning the feed cam clockwise will delay the completion of the material feed, and vice versa. After adjustment, securely tighten socket screw ④ and hexagon nut ③.
3. Better thread tension is obtained as the above-mentioned height is adjusted to about 7mm. If starting stitches formed are loose when using a synthetic fiber thread, adjust the above-mentioned height to about 10mm in order to prevent such trouble.
4. Stop-motion regulating cam ⑥ is turned together with feed cam ⑤. Therefore, loosen setscrew ⑩ and turn the stop-motion regulating cam to make adjustment so that stop-motion regulating cam roller ⑦ enters stop motion from the low-speed revolution when stop-motion hook ⑧ falls onto stop-motion cam screw No. 1 ⑨ at the final stitch.

二十一、松紧线时间的调整

ADJUSTING THE THREAD TENSION RELEASE TIMING



1. 卸掉五个螺钉①,取下上盖②。
2. 用内六角扳手⑤将松线摆杆③上的内六角螺钉④松开,然后转动松线摆杆以使当压脚抬起时,松线杆端部至支承板间距离为4毫米。
3. 调整完毕,务必要拧紧内六角螺钉④
1. Remove five setscrews ① to take off top cover ②
2. Loosen socket screw ④ of tension arm ③ by L-shaped wrench ⑤, and turn the tension arm to make adjustment so that a 4mm clearance is provided between the end of connecting rod ⑥ and that of tension post support plate ⑦ when the work clamp foot is up (when connecting rod ⑥ is retreated).
3. After adjustment, securely tighten socket screw ④



(机针高度的调整)

1. 用手转动转速轮使针杆①降至其行程的最低位置(见“手动操作机器”)。
2. 取下橡胶堵,然后松开螺钉②。
3. 用手转动转速皮带轮使针杆①上的刻度上线A对准针杆下套③的底端,然后固定螺钉②。(摆梭的定位)。
4. 继续转动转速皮带轮直到针杆①上的下刻度线B对准针杆下套③的底端。
5. 分别松开梭托螺钉④,并将梭床左右压板⑤分别打开,这时即可将梭床盖⑥取下。
(注):这时一定要小心,不要使摆梭掉出。
6. 完成上述步骤后,即可进行调整以使当摆梭⑦尖部对准机针⑧的中心C时,机针⑧与梭托⑨前面之间没有间隙,然后固定梭托螺钉④。
7. 松开螺钉⑩,顺时针或逆时针方向转动梭床体调节轴⑪以使机针⑧与摆梭⑦之间的间隙调至0.05~0.1毫米,调整后紧固好螺钉⑩。
8. 调整完毕,将梭床盖⑥装入即可。
(注):这时一定要注意梭床体不可再发生转动。

(Adjusting the height of the needle bar)

1. Turn the changeover pulley by hand to bring needle bar ① to the lowest position of its stroke (see "To operate the sewing machine manually").
2. Remove the rubber cap, and loosen setscrew ②.
3. Turn the driving pulley by hand to make upper marker line A engraved on the needle bar meet the bottom end of lower bushing ③ of the needle bar. Tighten setscrew ②.

(Positioning the shuttle)

4. Further turn the driving pulley until lower marker line B engraved on needle bar ① meets the bottom end of lower bushing ③ of the needle bar.
5. Loosen shuttle driver setscrew ④, and open shuttle race latches ⑤ to the right and left, respectively while pulling them towards you to remove shuttle race ring ⑥.

(Note) At this time, be careful not to allow shuttle ⑦ to fall.

6. Perform adjustment so that no clearance is provided between the needle and the front end of shuttle driver ⑨ when the blade point of shuttle ⑦ is aligned with center C of needle ⑧. Then tighten shuttle driver setscrew ④.

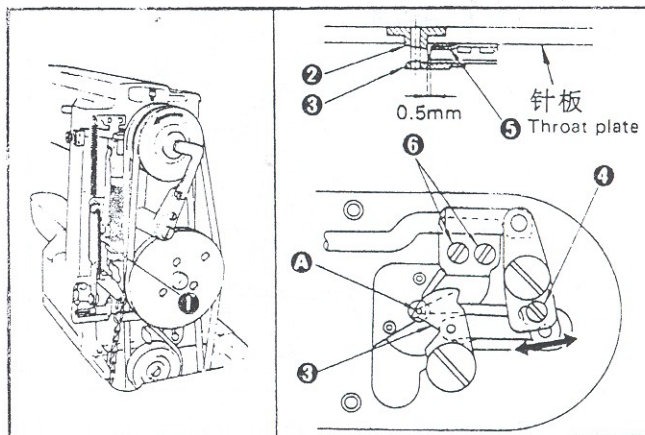
(Caution) At this time, be very careful not to cause the shuttle race to slip in the direction of rotation.

7. Loosening setscrew ⑩, turn shuttle race adjusting shaft ⑪ clockwise or counterclockwise for adjustment to provide a 0.05 to 0.1mm clearance between needle ⑧ and shuttle ⑦, then tighten setscrew ⑩.
8. After adjustment, install shuttle race ring ⑥.

二十三、剪线刀的调整

ADJUSTING THE THREAD TRIMMER

1. 取下起动杆拉力弹簧①, 然后起动机(此时当机器停止时, 压脚不抬起)。
 2. 松开调节螺钉④, 然后可沿箭头方向进行调整剪刀③位置, 使其上面的孔A对准针板座②上的针孔。
 3. 松开螺钉⑥可调整固定剪刀⑤的位置, 使其与针板座②之间的距离调至0.5毫米即可。
1. Remove starting lever tension spring ①, and start the machine. (The work clamp foot stays down when the machine stops.)
 2. Loosen adjusting screw ④ and adjust the position of moving knife ③ in the arrowed direction to align hole A of the moving knife with the needle hole in needle hole guide ②.
 3. Loosen setscrew ⑥ and adjust the position of counter knife ⑤ to provide a 0.5mm clearance between needle hole guide ② and counter knife ⑤.



二十四、压脚的横向调整

ADJUSTING THE LATERAL POSITION OF THE WORK CLAMP FOOT

松开螺母③, 并沿方向⑤转动横向进给联杆, 使压脚中心向左移或沿方向④转动, 则压脚中心向右移。

- * 42针打结时, 线迹的第26针位应在压脚框内的正中间。
- * 28针打结时, 线迹的第18针位应在压脚框内的正中间。
- * 21针打结时线迹的第13针位应在压脚框内的正中间。

(注): 若想校正压脚中心的偏差, 可松开螺母, 详见“十九、打结长度及宽度的调整”部分, 并可用手来适当扳动压脚, 向左或向右以达到调整的目的。

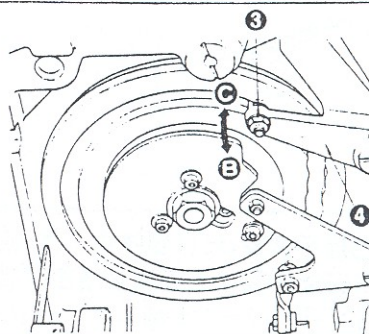
26th stitch (for 42-stitch large bar-tacking)

18th stitch (for 28-stitch large bar-tacking)

13th stitch (for 21-stitch large bar-tacking)

第26针(用于42针)
第18针(用于28针)
第13针(用于21针)

Left 左 ← → 右 Right



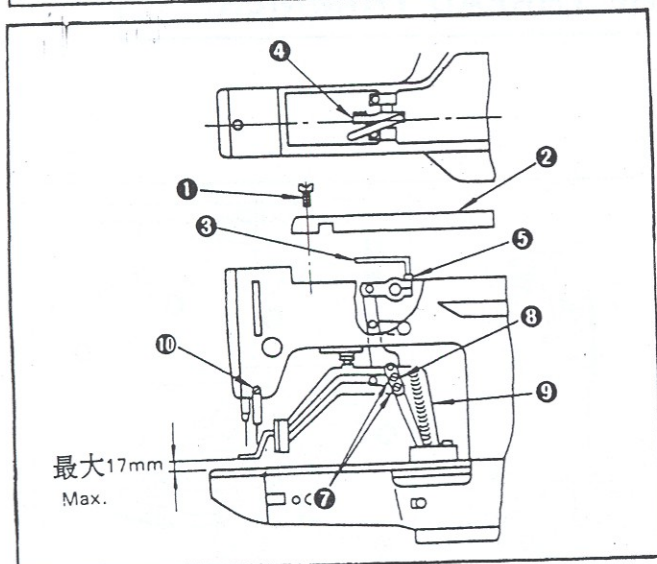
Loosen nut ③, and move feed across regulator in direction ⑤ to shift lateral center ④ of work clamp foot ① to the right or in direction ⑥ to shift it to the left.

- * For 42-stitch bar-tacking, adjust the lateral center at the 26th stitch.
- * For 28-stitch bar-tacking, adjust the lateral center at the 18th stitch.
- * For 21-stitch bar-tacking, adjust the lateral center at the 13th stitch.

(Note) To correct a slight deviation of the lateral feed center, loosen the nut described in "19. Adjusting the length and width of bar tacking", and push the work clamp foot to the right or left by hand to make adjustment.

二十五、压脚抬高的调整

ADJUSTING THE LIFT OF THE WORK CLAMP FOOT



压脚抬高最大可调至 17 毫米。

1. 在机器不工作情况下,取下五个螺钉①,取下上盖②。
 2. 用内六角扳手③,松开启动板摆杆的内六角螺钉⑤。
 3. 向下按动内六角板手③,即可提高压脚向上抬起高度;向上提内六角板手③,则可降低压脚高度。
 4. 调整完毕,务必将内六角螺钉⑤拧紧。
 5. 如果左右压脚不在一个水平面内,松开螺钉⑦,并调整压脚驱动板⑧,以调至左右压脚处在一个水平面内。
- (注): 注意不要使驱动板⑧与压脚架⑨发生干涉。如果压脚与拨线杆发生干涉,可通过螺钉⑩重新调整拨线杆的高度。

The lift of the work clamp foot can be adjusted up to 17mm.

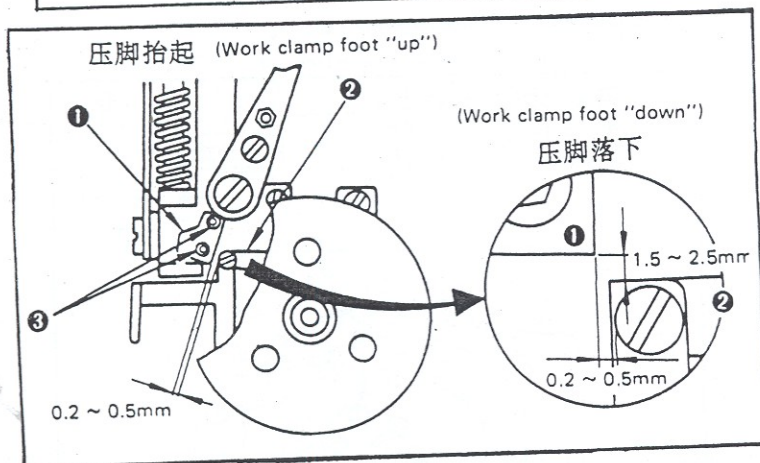
1. With the machine in stop mode, remove five setscrews ① to take off top cover ②.
2. Apply L-shaped wrench ③ to socket screw ⑤ of clamp ④, and loosen socket screw.

3. Push down L-shaped wrench ③ to increase the lift of the work clamp foot, or pull it up to decrease the lift.
4. Securely tighten socket screw ⑤ after adjustment.
5. If the right and left work clamp feet are not levelled, loosen screw ⑦ and adjust the position of work clamp foot lever support plate ⑧ to level them.

(Caution) Be careful not to cause work clamp foot lever support plate ⑧ to interfere with feed bracket ⑨.
If the work clamp foot lever support plate interferes with the wiper, readjust the height of the wiper using setscrew ⑩.

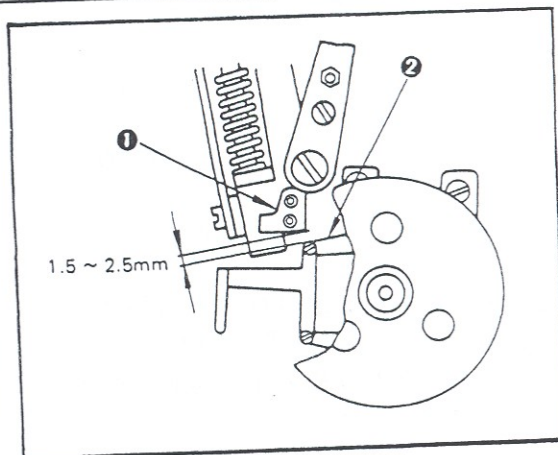
二十六、安全板的调整

ADJUSTING THE SAFETY PLATE



1. 打开两螺钉③进行调整,当机器停止工作,压脚抬起时,将安全板①与抬压脚联接板②之间的横向间隙调至 0.2~0.5 毫米,而当压脚落下时,安全板与抬压脚联接板之间纵向间隙调至 1.5~2.5 毫米。

1. Loosening two setscrews ③, perform adjustment so that a 0.2 to 0.5mm lateral clearance is provided between safety plate ① and lifting lever ② when the work clamp foot is up at the time of stop motion, and a 1.5 to 2.5mm longitudinal clearance between them when the work clamp foot is down.

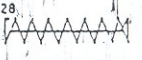


2. 观察在高速打结过程中,(压脚处于落下的状态)安全板①与抬压脚联接板②之间的纵向间隙是否为 1.5~2.5 毫米。

2. Check that the longitudinal clearance between safety plate ① and lifting lever ② is 1.5 to 2.5mm during the high-speed bar tacking (the work clamp foot is down).

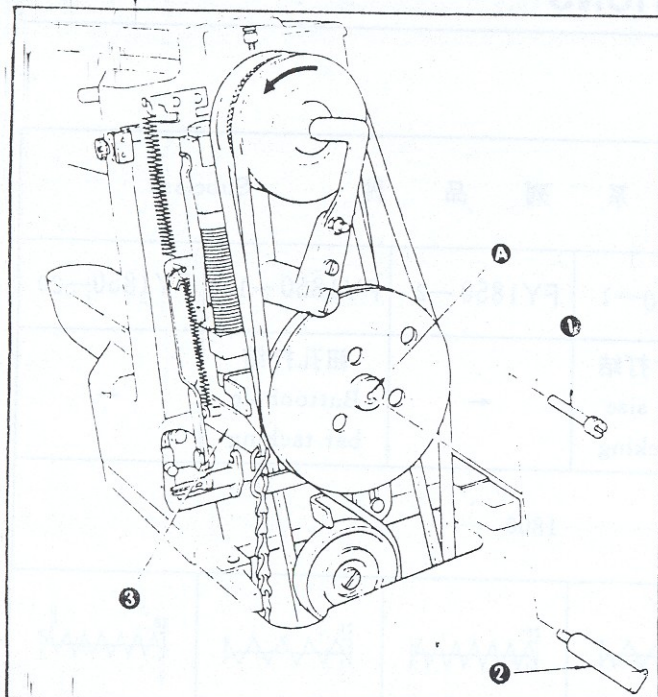
二十七、技术参数

SPECIFICATIONS

	标 准 Standard	系 列 品 种 Subclass			
型号 Model	FY1850	FY1850-1	FY1850-2	FY1850-10	FY1850-20
应 用 Application	大尺寸打结 Large size bar tacking	小尺寸打结 Small size bar tacking	←	钮孔打结 Buttonhole bar tacking	←
缝速(转/分) Sewing speed(s. p. m.)	1800				
线迹 类型 Stitching pattern					
针 数 Number of stitches	42	21	28	21	28
打结宽度 Bar tacking width(mm)	1.5~3	←	←	1.5~3 标准 2.5 (standard 2.5)	←
打结长度 Bar tacking length(mm)	8~16	4~8 标准 8 (Standard 8)	←	4~8 标准 6 (Standard 6)	←
机 针 Needle	DP×5 #14 #16	←	←	DP×5 #14 #16	←
压脚提升高度 Work clamp foot lift(mm)	最大 17 Max. 17				
润滑油 Lubricating oil	变压器油 Juki New Defrix Oil No. 2 or spindle oil No. 2 as the lubricating oil.				

二十八、减压联动控制器(装置)润滑方法

HOW TO SUPPLY GREASE TO THE REDUCER



对于联动控制机器使用半年以上或噪音较大时,要向减压装置加入润滑脂,步骤如下:

1. 停止机器运转并取下螺钉①。
2. 将随机附带的无盖润滑脂管旋入孔A中,并打出润滑脂。
3. 从孔A旋出油脂管后,用油孔螺钉①将润滑脂筒往里推。
4. 重复上述步骤,向孔内注入两次或酌量。
5. 拧紧螺钉①。

(注意:如果润滑脂没有顺利地进入机构中,则可把润滑脂管②旋入孔A,打开电机开关,并用起动机③上下晃动给压脚踏板,这样就可以使润滑脂很容易地进入机构中。

Supply grease to the reducer in accordance with the following procedure when the machine has been used for more than half year or if it chatters.

1. Stop the machine and remove screw ①.
2. Uncap grease tube ② supplied with the machine, screw the tube into hole A, and push the grease out of the tube.
3. Removing grease tube ② from A, push in the grease by screw ①.
4. Repeat the step of injecting the grease and pushing it in by the screw twice or so.
5. Tighten screw ①.

(Note) If the grease will not get into the unit smoothly, screw in grease tube ②, turn on the motor switch, and move the presser foot up and down two or three times using lever ③. By doing this, you can make the grease get into the unit easily.

二十九、故障及其排除方法

故 障	原 因	排 除 方 法	页 数
1. 开始打结时,针线从机针上脱出。	① 开始时跳线。 ② 剪线后留在机针上的线头过短。 ③ 梭芯线头过短。 ④ 进给时间不正确。	○ 调整机针与摆梭之间的间隙 0.05~0.1 毫米。 ○ 调整 2 号压线器的松紧线时间。 ○ 增加挑线弹簧的张力或者减小 1 号压线器的压力。 ○ 减小梭线的压力。 ○ 增加针板与固定剪刀之间的间隙。 ○ 正确调整进给时间。	
2. 经常断线或使用合成纤维线时扎线、融断。	① 摆梭或摆梭托有瑕疵。 ② 针板有划伤。 ③ 机针碰压脚。 ④ 梭床体槽里有较多的纤维绒。 ⑤ 针线张力过大。 ⑥ 挑线簧张力过大。 ⑦ 由机针产生的热而使合成纤维线融化。	○ 将其取下并用细磨石或软皮(布)去掉瑕疵。 ○ 用软皮去掉划伤或更换零件 ○ 调整压脚位置。 ○ 取下摆梭并清除梭床体里的纤维绒。 ○ 减小针线的张力。 ○ 减小挑线簧张力。 ○ 使用硅油。	
3. 经常断针	① 针弯。 ② 机针碰压脚。 ③ 进给时间不正确。 ④ 机针对布料太细。 ⑤ 摆梭托碰弯机针。	○ 更换机针。 ○ 纠正压脚偏量。 ○ 纠正进给时间。 ○ 根据布料更换较粗机针。 ○ 纠正摆梭托与机针的位置。	
4. 不剪线。	① 固定剪刀变钝。 ② 针板与固定剪刀的水平间隙不够。 ③ 动剪刀位置不正确。 ④ 最后一针跳线。	○ 更换定剪刀。 ○ 增大定剪刀的弯度。 ○ 纠正动剪刀的位置。 ○ 纠正机针与摆梭之间的运动时间。	
5. 经常发生跳线。	① 机针与摆梭的运动不协调。 ② 机针与摆梭之间的间隙过大。 ③ 针弯。 ④ 进给时间不正确。 ⑤ 摆梭托碰弯机针。	○ 纠正机针与摆梭的位置。 ○ 纠正机针与摆梭的位置。 ○ 更换机针。 ○ 纠正进给时间。 ○ 纠正摆梭托的位置。	
6. 缝线跑位	① 针线张力不够。 ② 松紧线机构失灵。 ③ 剪线后针线头过长。	○ 增加针线的张力。 ○ 检查一下在打结其间 2 号压线盘是否松线。 ○ 增加 1 号压线器的压力。	
7. 剪线时断线。	① 动剪刀位置不正确	○ 纠正动剪刀的位置。	

三十、钮孔收口部分的使用说明(FY1850-20 型)

1、操作程序:

- ①将钮孔放在压脚下,使钮孔与压脚的中心相吻合;
- ②确定好起始针位后,踏下起动踏板,左右压脚自动将钮孔的中缝收拢;
- ③在完成一个缝纫周期后,机器将自动停止。

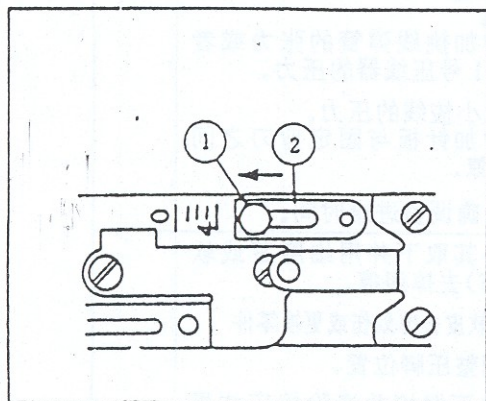


图 1

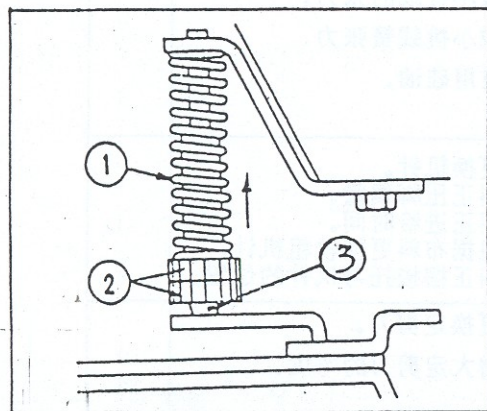


图 2

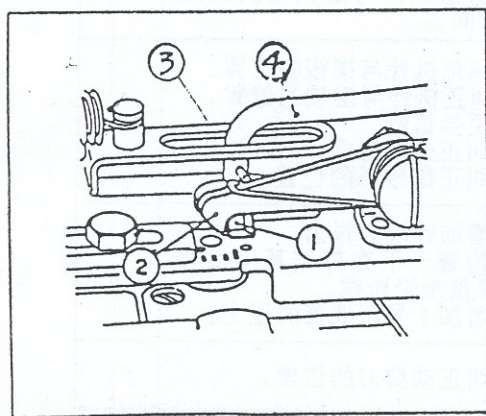


图 3

2、压脚收拢宽度的调整:(参照图 1)

当您根据钮孔尺寸,欲减小压脚收拢宽度时,可旋松“紧定螺钉①”,并按箭头方向推动“可调节板组件②”进行调节;

反之,如果您想增大收拢宽度时,按相反方向移动“可调节板组件②”

当控制器部件发生振动时,要可靠地旋紧“紧定螺栓①”。

3、压脚压力调节:(参照图 2)

如果压脚压力不足以防止衣料移位,应向上推,并取出“压缩弹簧①”的“定位轴③”,再沿箭头方向(向上)轻微旋转“调节螺母②”。

4、压脚的拆卸:(参照图 3)

当您欲拆卸压脚时,应向上推,卸下“压缩弹簧①”(见图 2),并拉出挡圈固定的“定位轴 *”,再从压脚“收口前拉杆④”上拆下“开口销③”,即可卸下压脚部件。

5、压脚“收口前、后拉杆”的调整:(参照图 3)

将压脚调至最前端(距操作者最近),旋松“收口前、后拉杆”的“紧定螺钉 *”并调节“收口前拉杆④”,以使“定位钩②”与“定位拖板组件①”的端部,相互啮合。

注: * :请见FY1850系列加固机零件目录第 26 页序号 20 的零件;

* *:请见FY1850系列加固机零件目录第 26 页序号 57 的零件。

TROUBLES AND CORRECTIVE MEASURES

Trouble	Cause	Corrective measures	Page
The needle thread slips off the needle at the start of bar-tacking.	① Stitches are skipped at the start. ② The needle thread remaining on the needle after thread trimming is too short. ③ The bobbin thread is too short. ④ The feed timing is bad.	○ Adjust the clearance between the needle and the shuttle to 0.05 to 0.1 mm. ○ Correct the thread tension release timing of the thread tension controller No. 2. ○ Increase the tension of the thread take-up spring, or decrease the tension of the thread tension controller No. 1. ○ Decrease the tension of the bobbin thread. ○ Increase the clearance between the needle hole guide and the counter knife. ○ Correct the feed timing.	13 10 10 10 14 12
Thread often breaks or synthetic fiber thread splits finely.	① The shuttle or the driver has scratches. ② The needle hole guide has scratches. ③ The needle strikes the work clamp foot. ④ Fibrous dust is in the groove of the shuttle race. ⑤ The needle thread tension is too high. ⑥ The tension of the thread take-up spring is too high. ⑦ The synthetic fiber thread melts due to heat generated on the needle.	○ Take it out and remove the scratches using a fine whetstone or buff. ○ Buff or replace it. ○ Correct the position of the work clamp foot. ○ Take out the shuttle and remove the fibrous dust from the shuttle race. ○ Reduce the needle thread tension. ○ Reduce the tension. ○ Use silicone oil.	15 13 10 11 7
The needle often breaks.	① The needle is bent. ② The needle hits the work clamp foot. ③ The feed timing is bad. ④ The needle is too thin for the material. ⑤ The driver excessively bends the needle.	○ Replace the bent needle. ○ Correct the position of the work clamp foot. ○ Correct the feed timing. ○ Replace it with a thicker needle according to the material. ○ Correctly position the needle and the shuttle.	9 15 12 8 13
Threads are not trimmed.	① The counter knife is dull. ② The difference in level between the needle hole guide and the counter knife is not enough. ③ The moving knife has been improperly positioned. ④ The last stitch is skipped.	○ Replace the counter knife. ○ Increase the bend of the counter knife. ○ Correct the position of the moving knife. ○ Correct the timing between the needle and the shuttle.	14 14 14 13
Stitch skipping often occurs.	① The motions of the needle and shuttle are not properly synchronized. ② The clearance between the needle and shuttle is too large. ③ The needle is bent. ④ The feed timing is bad. ⑤ The driver excessively bends the needle.	○ Correct the positions of the needle and shuttle. ○ Correct the positions of the needle and shuttle. ○ Replace the bent needle. ○ Correct the feed timing. ○ Correctly position the driver.	13 13 9 12 13
The needle thread comes out on the wrong side of the material.	① The needle thread tension is not high enough. ② The tension release mechanism fails to work properly. ③ The needle thread after thread trimming is too long.	○ Increase the needle thread tension. ○ Check whether or not the tension disc No. 2 is released during bar-tacking. ○ Increase the tension of the thread tension controller No. 1.	10 10 10
Threads break at time of thread trimming.	① The moving knife has been improperly positioned.	○ Correct the position of the moving knife.	14

地址: 中国浙江省台州市椒江机场中路109号
Add: Middle Airport Rd. Taizhou City Zhejiang China
电话: Tel: 0086-576-8155801/8155811/8155809
传真: Fax: 0086-576-8155800/8155815
邮政编码 Post Code: 318010

本资料所列之产品可能会因改良而所变动，以随机说明书为准，故不另行通知。中国飞跃保留对此资料的解释权。

经销商:
VENDOR: