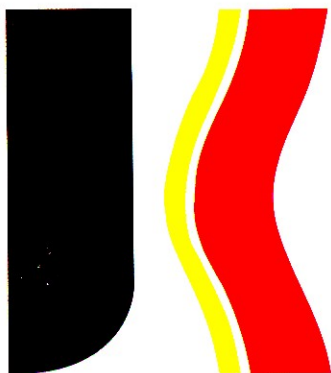




JK-T530

西裤裤耳暗缝机

Industrial Trousers Ears

Blind Stitch Machine

零件样本 · 使用说明书

Operation Manual Parts Book



CONTENTS

Opertion Manual

1. Unpacking Machine.....	1
2. Setting-up Machine.....	1
3. Handwheel Rotation and Speed.....	1
4. Oiling and Maintenance.....	1
5. Replacing Needle.....	2
6. Threading Machine.....	3
7. Inserting the Work and Starting to sew.....	3
8. Adjustment of Needle Penetration.....	4
9. Stitch Length Regulation.....	4
10. Needle Recommendation.....	5
11. Removal of the Work from the Machine.....	5
12. Belt Loop Making.....	6

Parts Book

13. Machine Frame & Covers Components.....	8
14. Main Shaft Mechanism Components.....	10
15. Needle Carrier & Feed Dog Mechanism Components.....	12
16. Looper Drive Mechanism & Presser Foot Parts Components.....	14
17. Ridge Forming Disc & Feed Plate Mechanism Components.....	16
18. Disc Oscillating Mechanism & Knee Press Shaft Parts Components.....	18
19. Knee Press Components & Standard Accessories.....	20

1.Unpacking Machine

Open packing box by carefully removing its cover so as not to damage the machine or those of its parts which project from the top, such as the tension parts.

Small accessory parts are packed separately in individual packages. Do not discard any packing materials without prior scrutiny as to contents.

Clean from machine all greases, dirt or dust. Pay particular attention to area around the looper mechanism and looper.

2. Setting-up Machine

Assemble knee lifter lever to machine and place on sewing table so that lever is 13 mm distant from front edge of the table. Line up belt groove in belt pulley of handwheel with belt groove of drive mechanism(motor or clutch).

Mark three screw holes for fastening machine to sewing table and place felt pad under machine bed before machine is tightened down.

3. Handwheel Rotation and Speed

Turn handwheel only in direction away from operator for clockwise rotation. Be sure motor drive is wired up to obtain the same clockwise rotation. The recommended operating speed of a brand new machine is 1,800 to 2,000 stitches per minute. After a breaking-in period of several weeks and after the operator has become skilled in the operation of the machine, the speed can be increased up to 2,500 stitches per minute.

4. Oiling and Maintenance

It is important not to operate the machine before oil of good quality has been filled in each and every oil hole along the top of the machine. When breaking-in a new machine oiling should be done sparingly several times a day. Thereafter, one oiling daily will be sufficient. After oiling, wipe machine carefully to avoid soiling of the material.

Do not operate without material under the presser foot unless the knee lever is depressed. This will prevent damage to the needle and the feed dog as well as the feed plattens.

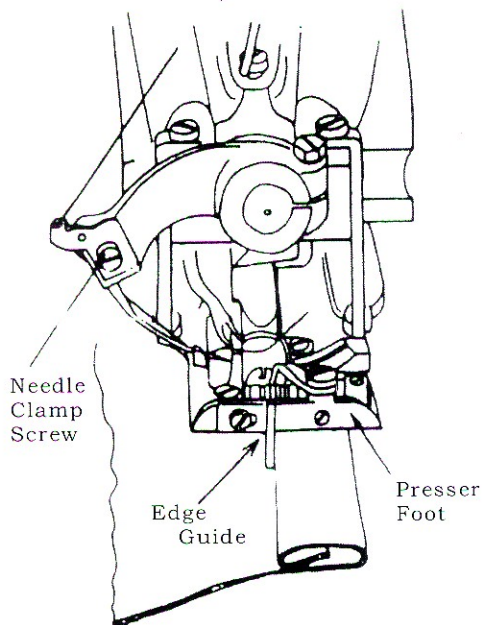
5. Replacing Needle

Turn handwheel away from operator(clockwise) until needle reaches the end of its return stroke(extreme left hand position). Adjust penetration dial to least amount of penetration(turn clockwise towards 1).

Remove old or defective needle by loosening needle clamp screw. Insert new needle into seat in needle clamp as far as it will go. Tighten needle clamp screw.

Turn handwheel slowly away from operator and observe movement of needle. The curved portion of the needle should bear slightly on the needle guide groove in the left hand part of the presser foot.

Fig.1



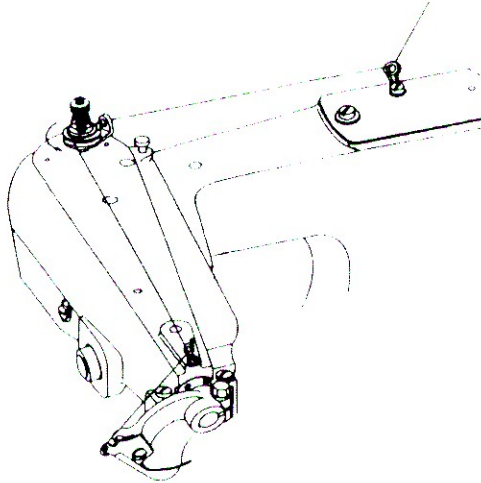
Always replace bent or blunt needles. They affect the satisfactory operation of the machine.(see Fig.1)

6. Threading Machine

Turn handwheel of machine in clockwise direction away from operator until needle carrier reaches its furthest left hand position.

And proceed as follows.(see Figs 2)

Fig.2



7. Inserting the Work and Starting to sew

Depress knee lifter. This causes the feed plate to swing downward and creates a gap between the presser foot and the feed plate.

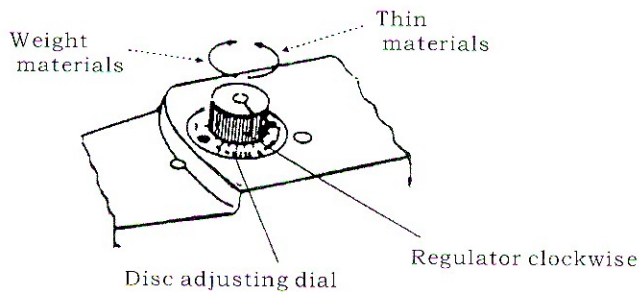
Insert the work in the gap just opened in such a manner that the folded or sewn edge of the material is alongside the edge guide of the presser foot.(see Fig.1)

When the material is in proper position, completely release the knee lifter. Get the machine started slowly and watch the material pass edge guide rather than to observe the action of the needle.

8. Adjustment of Needle Penetration

The type of material to be blind stitched governs the degree of needle penetration which is required. It is, therefore, recommended to stitch a few centimeters as a test and make adjustments for penetration depending on the appearance of the trial stitching. (see Fig.3)

Fig.3



9. Stitch Length Regulation

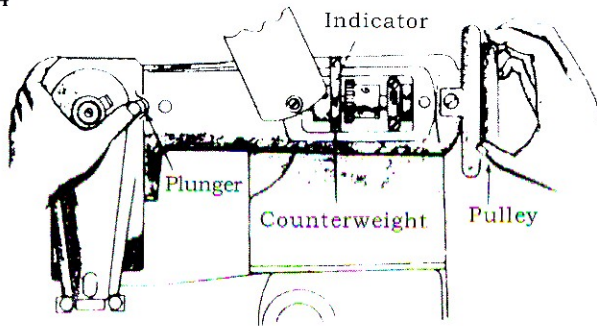
Stitch length adjustment can be easily effected by adjusting needle driving eccentric in arm.

Go about it as follows:

Turn handwheel by hand pushing plunger until same is felt to drop into a recess within the mechanism inside the arm of the machine.

With the plunger remaining depressed into this recess continue turning the handwheel either forward or in reverse until the desired number of stitches per inch is visible on indicator. (See Fig.4)

Fig.4



10. Needle Recommendation

The recommended needle is Japan system LW×6T

Size	Material
3(11)	New synthesize Fiber Materials, Cottons, Silks, Acetates, Dacron and similar type of extremely-thin to thin materials.
3 1/2 (14)	Medium weight Materials. Woolens and Others.
4(16)	Thick materials for coast, house furnishings.

11. Removal of the Work from the Machine

Stop machine and turn handwheel away from operator until needle is completely out of the material. Press the knee lifter to the right and pull the work-piece rearward out of the machine with a quick stroke. This will lock the last stitch and break the thread.

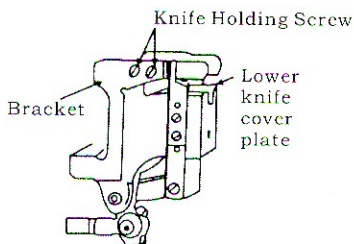
Remarks: In case that the thread will be cut after felling extremely thin materials and/or thin materials, in order to prevent from the damage of materials or from the shrinkage of the sewing thread, please cut the thread with scissors .

12. Belt Loop Making

① Adjusting Top Knives

Loosen 4 knife holding screws and set top edge of knives in parallel with top edge of bracket. Then tighten screw.(see Fig.6)

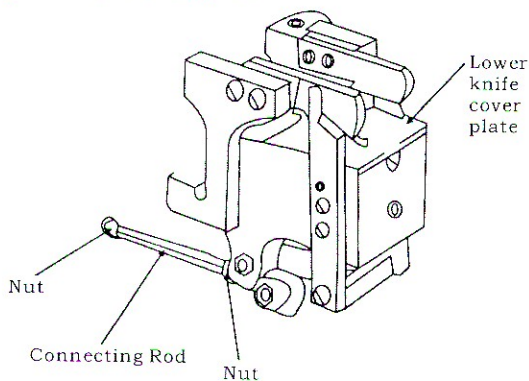
Fig.6



② Adjusting Lower Knives

Turn handwheel clockwise until lower knives are at top of stroke. Loosen nut on ball joint connecting rod and turn connecting rod until front edge of lower knife is 1 mm above bottom edge of top knife. Tight nuts(see Fig.7)

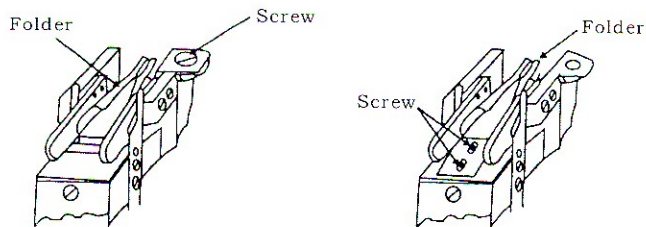
Fig.7

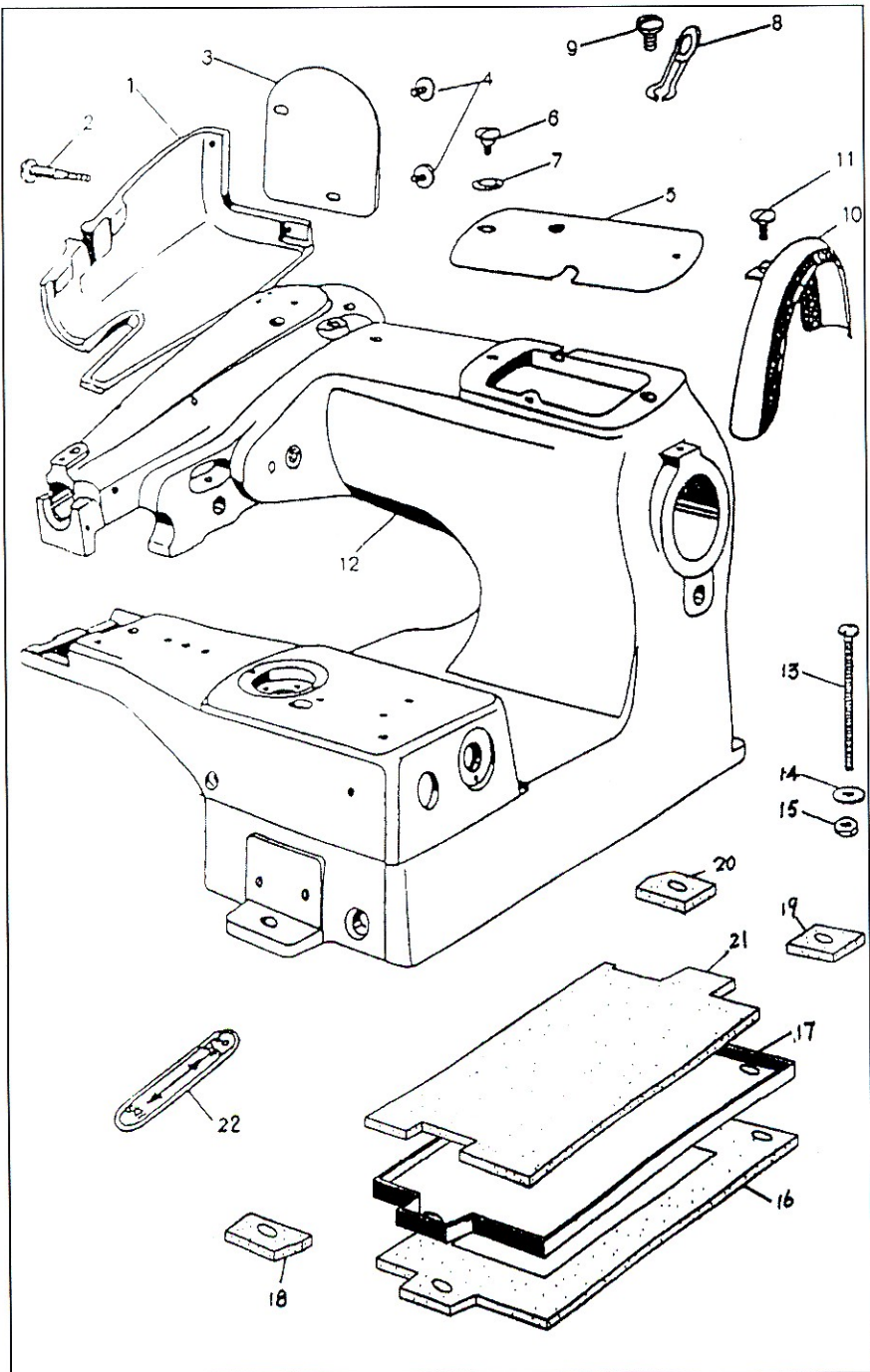


③ Adjusting Folder

Loosen screw and adjust folder sideways until stitch is set at edge of top fold of belt loop(in case of single fold) or at center of top fold of belt loop(in case of double fold).(see Fig.8)

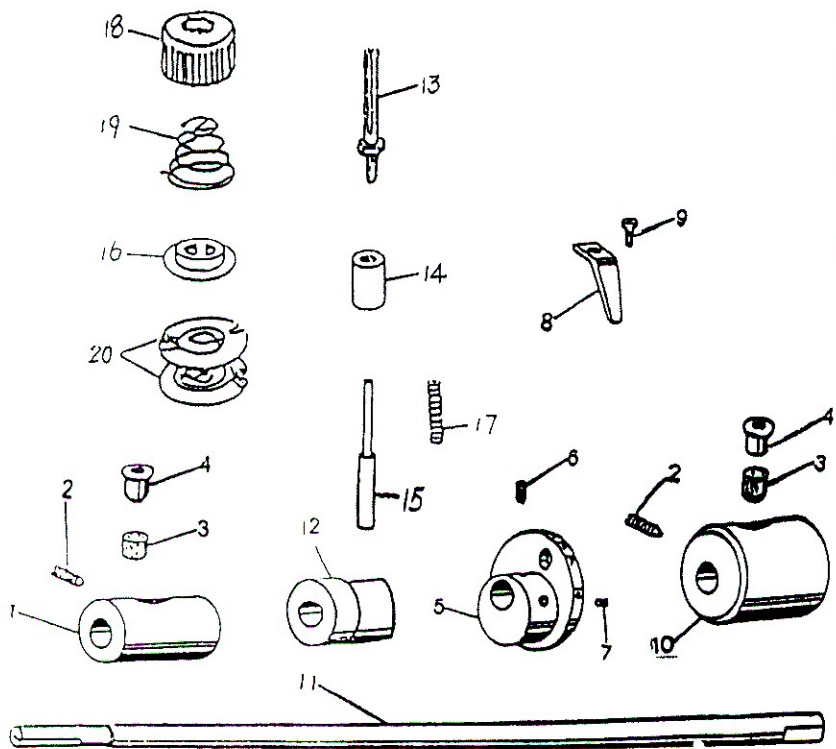
Fig.8





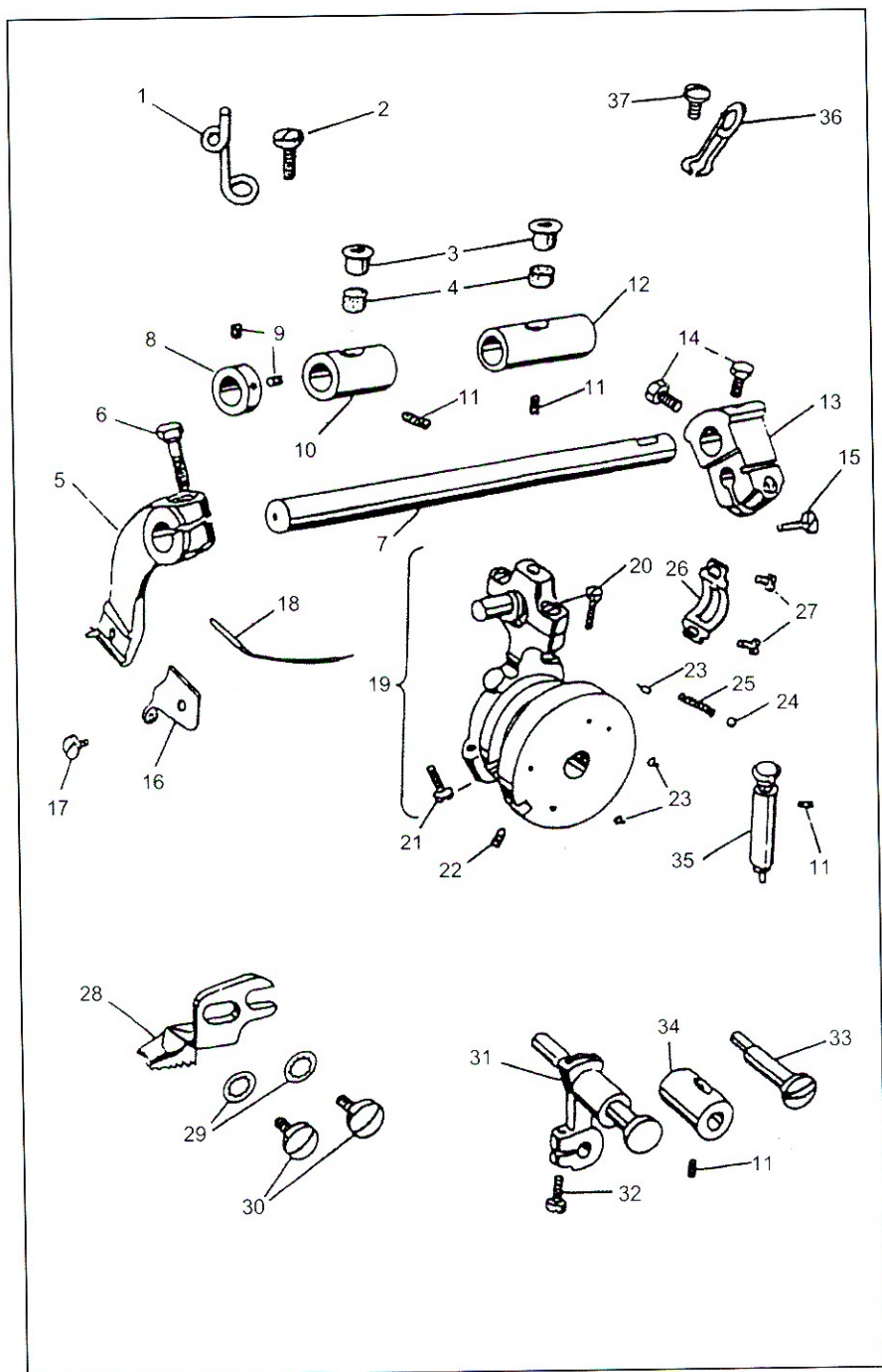
13. Machine Frame & Covers Components

Ref.No.	Symbol	Parts No.	Description
1	3A-1	4139	Arm Side Cover
2	3A-2	4144-A	Arm Side Cover Set Screw
3	3A-3	4137	Arm Top Cover Plate
4	3A-4	5227	Arm Top Cover Plate Screw
5	3A-5		Arm Top Cover Plate
6	3A-6	4141	Arm Top Cover Plate Screw
7	3A-7	4140-A	Arm Top Cover Plate Washer
8	3A-8	4203-A	Thread Guide
9	3A-9	4193	Thread Guide Set Screw
10	3A-10	4143	Blet Guard
11	3A-11	4048-A	Blet Guard Set Screw
12	3A-12	AM-101EX	Machine Frame
13	3A-16	AC-15	Machine Base Clamp Screw
14	3A-17	AC-17	Machine Base Washer
15	3A-18	AC-16	Machine Base Nut
16	3A-15	4214	Machine Base Rubber Pad
17	3A-15a		Machine Base Oil Plate
18	3A-20		Oil Plate Rubber Pad(A)
19	3A-21		Oil Plate Rubber Pad(B)
20	3A-22		Oil Plate Rubber Pad(C)
21	3A-23		Oil Plate Felt Pad
22	3A-19	4226	Skip Stitch Label



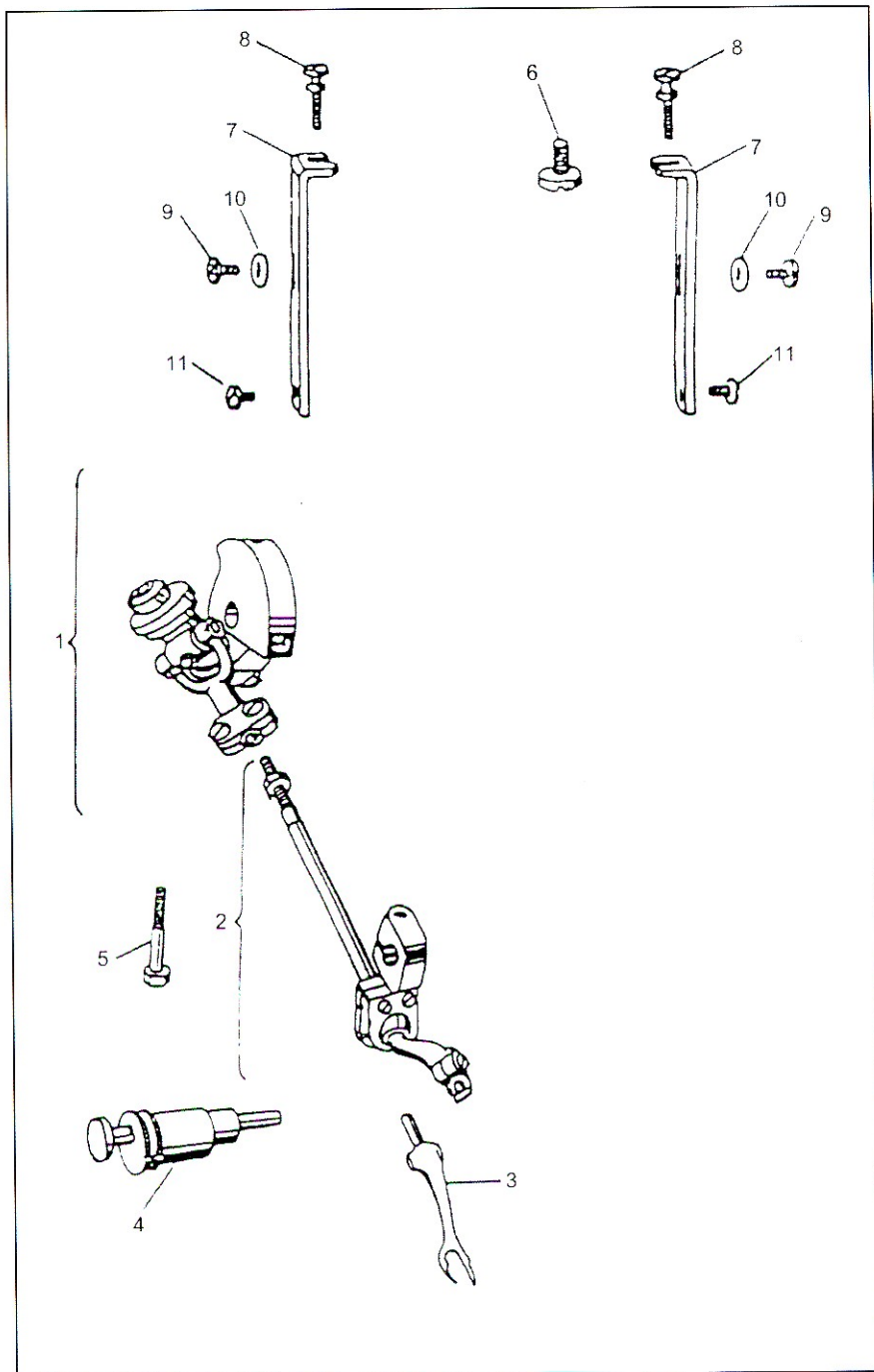
14. Main Shaft Mechanism Components

Ref.No.	Symbol	Parts No.	Description
1	3B-1	11005	Main Shaft Bushing(Front)
2	3B-2	096010	Main Shaft Bushing Set Screw
3	3B-3	4127-A	Oiling Felt
4	3B-4	4128-A	Oil Cap
5	3B-5	4133	Counterweight(w/Stitch Length Numbers)
6	3B-6	132	Counterweight Set Screw(Short)
7	3B-7	98	Counterweight Set Screw(Long)
8	3B-8	4134	Stitch Length Indicator
9	3B-9	124	Stitch Length Indicator Set Screw
10	3B-10	11006	Main Shaft Bushing(Rear)
11	3B-11	4003-A	Main Shaft
12	3B-12a		Eccentric Sleeve
13	3B-18		Thread Tension Staff
14	3B-19		Thread Tension Releasing Pin Bushing
15	3B-20		Thread Tension Releasing Pin
16	3B-21		Thread Tension Washer
17	3B-22		Thread Tension Releasing Pin Spring
18	3C-3	81	Thread Tension Nut
19	3C-4	79-B	Thread Tension Spring
20	3C-5	5190	Thread Tension Disc



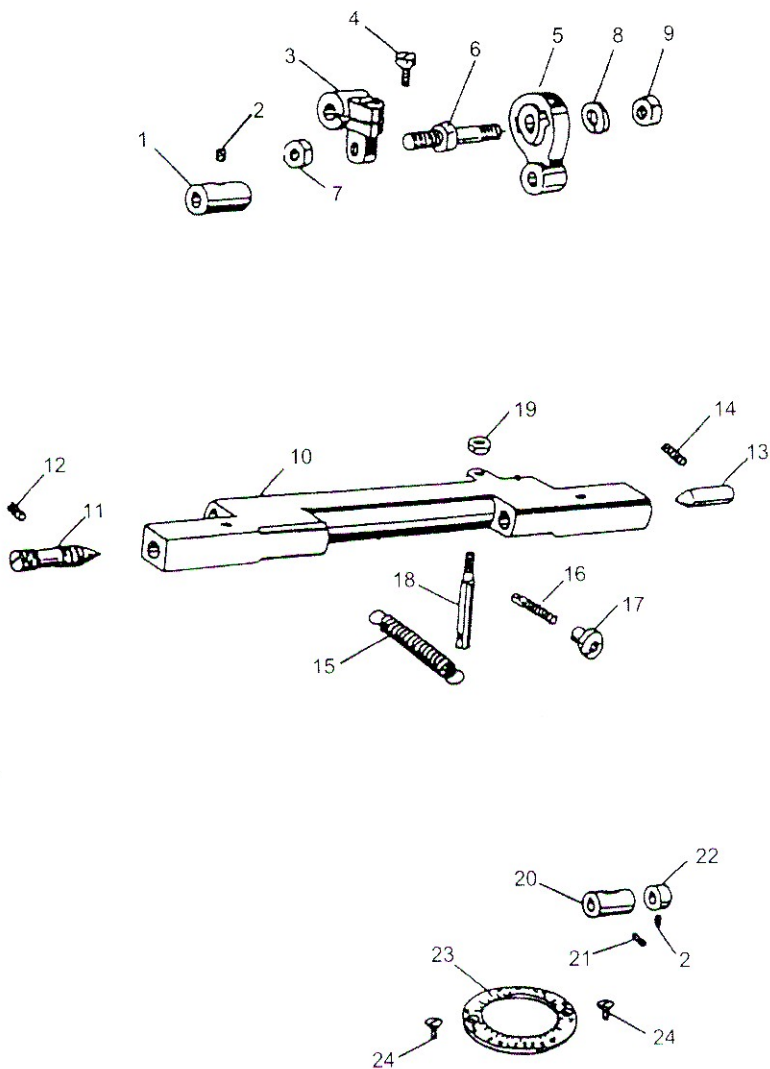
15. Needle Carrier & Feed Dog Mechanism Components

Ref.No.	Symbol	Parts No.	Description
1	3C-1	4135	Thread Guide
2	3C-2	113-A	Thread Guide Set Screw
3	3B-4	4128-A	Oil Cap
4	3B-3	4127-A	Oiling Felt
5	3C-10	4023-A	Needle Carrier
6	3C-11	4024	Needle Carrier Set Screw
7	3C-12	4019	Needle Carrier Shaft
8	3C-13	4022	Needle Carrier Shaft Collar
9	3C-14	129-B	Needle Carrier Shaft Collar Set Screw
10	3C-15	11032	Needle Carrier Shaft Bushing(Front)
11	3C-16	129-A	Needle Carrier Shaft Bushing Set Screw
12	3C-17	11033	Needle Carrier Shaft Bushing (Rear)
13	3C-19	4017-A	Needle Carrier Shaft Crank
14	3C-20	4018-C	Needle Carrier Shaft Crank Set Screw
15	3C-21	114-A	Needle Carrier Shaft Crank Clamp Screw
16	3C-22	4025-A	Needle Clamp
17	3C-23	121	Needle Clamp Set Screw
18	3C-24	4181	Needle(System LW×6T)
19	3C-25	1151-B	Needle Driving Eccentric Assembly w/Rod Regulator & Screws(Ref NOs.20-23)
20	3C-26	214012	Ball connecting Rod Set Screw(Short)
21	3C-27	214016	Ball connecting Rod Set Screw(Long)
22	3C-28	4009-B	Needle Driving Eccentric Set Screw
23	3C-29	4012-A	Stitch Regulator Screw
24	3C-30	4010	Stitch Regulator Ball
25	3C-31	1011-A	Stitch Regulator Spring
26	3C-32	4014	Ball Connecting Rod Cap
27	3C-33	4015	Ball Connecting Rod Cap Set Screw
28	3C-37	4047-C	Feed Dog
29	3C-38	2528-A	Feed Dog Washer
30	3A-11	4048-A	Feed Dog Set Screw
31	3C-40	1152-AA	Feed Link & Stud
32	3C-41	4173	Feed Link Clamp Screw
33	3C-43	4044	Feed Link Eccentric Stud
34	3C-44	4043	Feed Link Eccentric Stud Bushing
35	3C-46	520-A	Stitch Length Regulating Plunger Assembly
36	3A-8	4023-A	Thread Guide
37	3A-9	4193	Thread Guide Set Screw



16. Looper Drive Mechanism & Presser Foot Parts Components

Ref.No.	Symbol	Parts No.	Description
1	3D-1	538-A	Looper Drive Crank Assembly
2	3D-9	539-A	Looper Carrier Assembly
3	3D-16	4039	Looper
4	3D-17	505	Eccentric Sleeve & Pin
5	3D-18	4038	Eccentric Sleeve Clamp Screw
6	3D-19	4050	Presser Foot Set Screw
7	3D-20	4061-A	Presser Foot Bracket
8	3D-21	4062	Presser Foot Bracket Adjusting Screw
9	3D-22	121-B	Presser Foot Bracket Holding Screw
10	3D-23	11158	Presser Foot Bracket Washer
11	3D-24	4186-A	Presser Foot Holding Screw

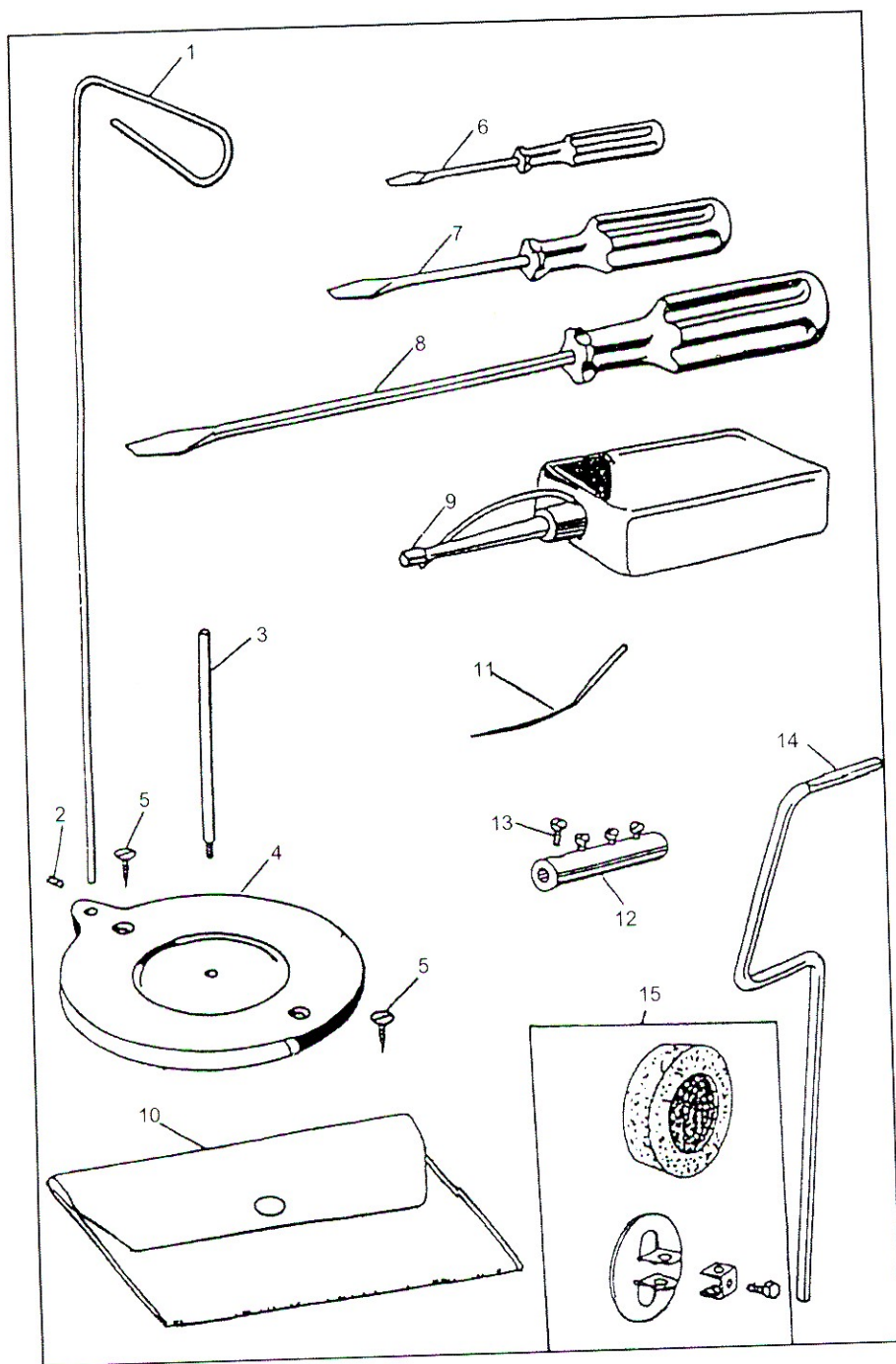


17. Ridge Forming Disc & Feed Plate Mechanism Components

Ref.No.	Symbol	Parts No.	Description
1	3E-6	4111	Ridge Forming Disc Shaft Collar
2	3C-14	129-B	Ridge Forming Disc Shaft Collar Set Screw
3	3E-8	4112	Ridge Forming Disc Shaft Crank
4	3E-9	113-B	Ridge Forming Disc Shaft Crank Set Screw
5	3E-10	11519	Ball Joint
6	3E-11	4230	Ball Joint Stud
7	3D-9-3	4176	Ball Joint Stud Nut
8	3E-13	8179	Ball Joint Spring Washer
9	3E-14	17203	Ball Joint Nut
10	3E-15	4102	Disc Adjusting Holder
11	3E-16	11048	Disc Adjusting Holder Pivot Bearing Screw
12	3B-7	98	Disc Adjusting Holder Pivot Bearing Screw Set Screw
13	3E-18	11049	Disc Adjusting Holder Pivot Bearing Pin
14	3E-19	11050	Disc Adjusting Holder Pivot Bearing Pin Set Screw
15	3E-20	4104	Disc Adjusting Holder Spring
16	3E-21	4105	Disc Adjusting Holder Spring Screw
17	3E-22	4106	Disc Adjusting Holder Spring Nut
18	3E-23	4103-B	Disc Adjusting Holder Spring Stud
19	3E-24	5208	Disc Adjusting Holder Spring Stud Nut
20	3C-44	4043	Feed Plate Shaft Bushing
21	3B-2	96010	Feed Plate Shaft Bushing Set Screw
22	3E-28	4090	Feed Plate Shaft Collar
23	3E-39	11255-N	Disc Adjusting Dial
24	3E-40	4129	Disc Adjusting Dial Set Screw

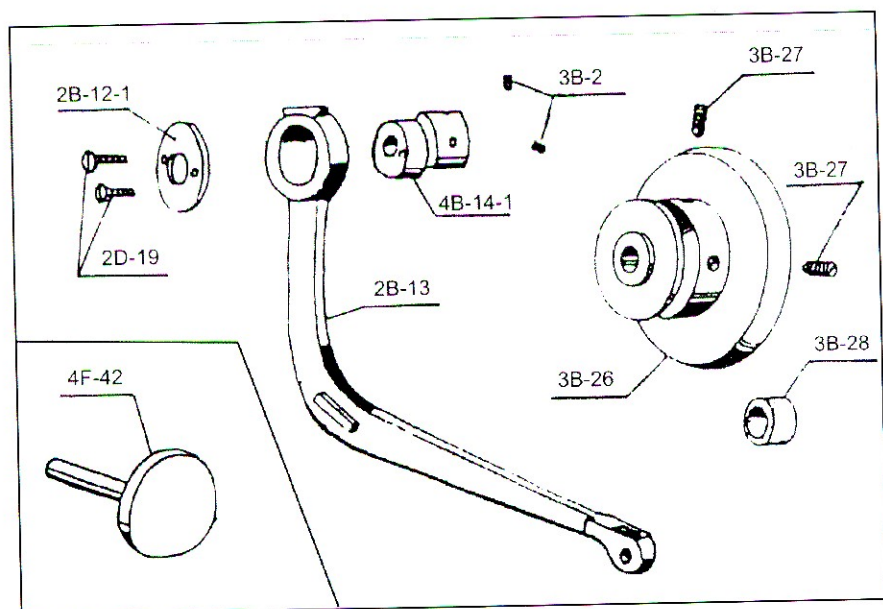
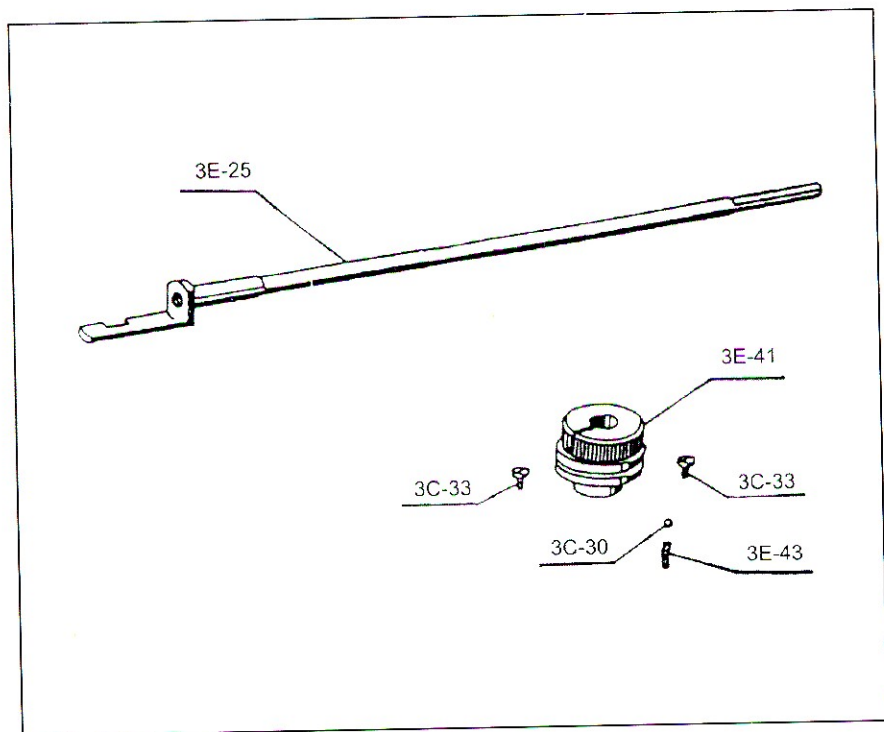
18. Disc Oscillating Mechanism & Knee Press Shaft Parts Components

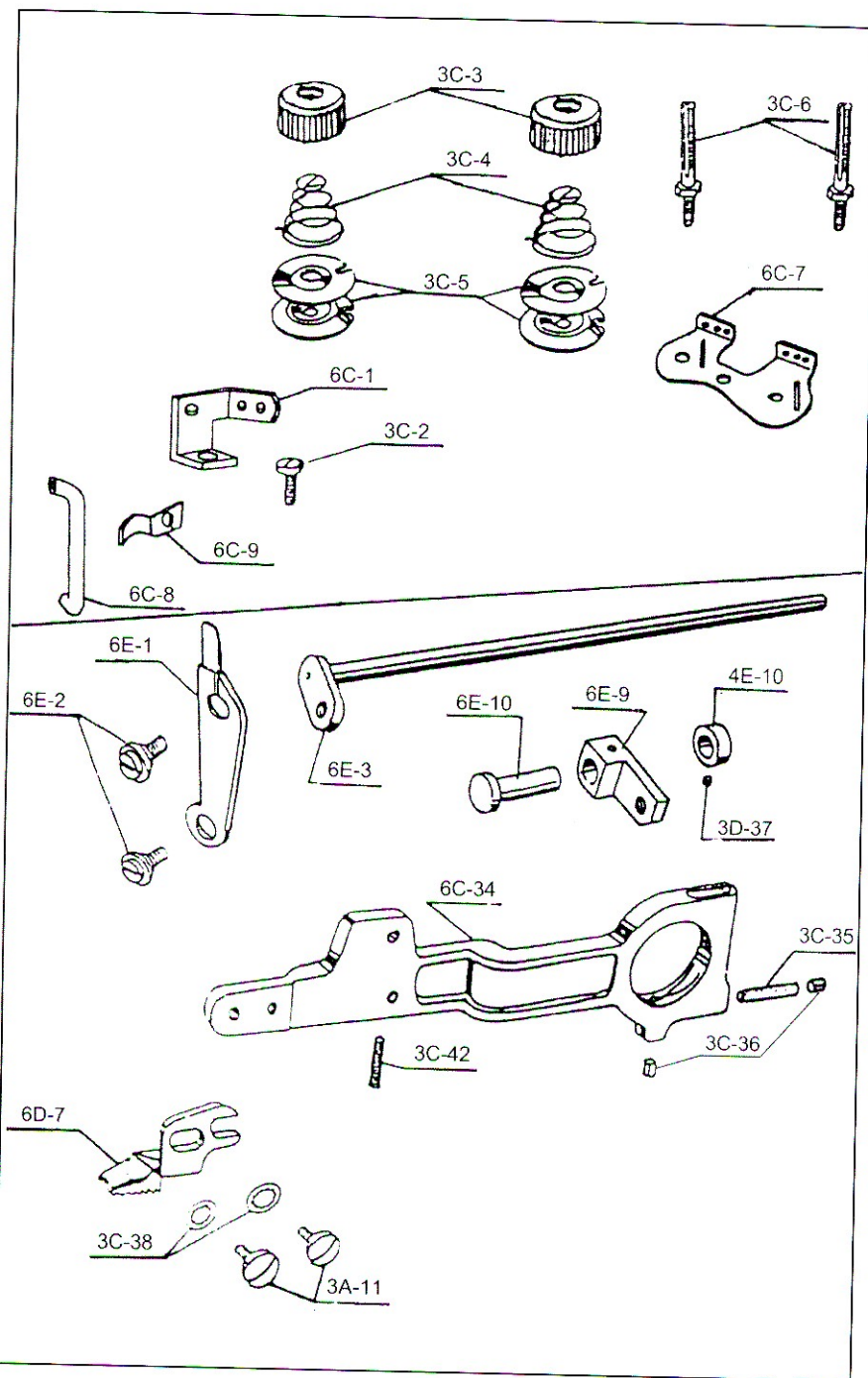
Ref.No.	Symbol	Parts No.	Description
1	3F-1	4073-A	Disc Oscillating Rod Bracket Spring
2	3F-2	4074	Disc Oscillating Rod Bracket Spring Screw
3	3F-3	4075	Disc Oscillating Rod Bracket Spring Nut
4	3F-4	4169	Connecting Rod
5	3B-16	4065	Connecting Rod Stud
6	3B-17	114-B	Connecting Rod Stud Set Screw
7	3F-7	S-4066-BB	Disc Oscillating Rod Assembly(W/Ref.No.8)
8	3C-14	129-B	Disc Oscillating Rod Shaft Set Screw
9	3F-9	4115-A	Disc Oscillating Rod Pin
10	3C-16	129-A	Disc Oscillating Rod Pin Set Screw
11	3B-16	4065	Disc Oscillating Rod Stud
12	3F-12	4031-A	Disc Oscillating Rod Stud Set Screw
13	3F-13	4069-A	Disc Oscillating Rod Bracket Spring Stud
14	3F-14	4070	Disc Oscillating Rod Bracket Spring Stud Nut
15	3F-15	4076	Disc Oscillating Rod Bracket Shaft
16	3B-18	4077-A	Disc Oscillating Rod Bracket Shaft Collar
17	3B-6	132	Disc Oscillating Rod Bracket Shaft Collar Set Screw
18	3B-2	96010	Disc Oscillating Rod Bracket Shaft Set Screw
19	3F-19	4098-A	Feed Plate Depressing Crank
20	3F-20	105	Feed Plate Depressing Crank Set Screw
21	3F-21	4178-A	Crank & Link Shoulder Screw
22	3F-22	5207	Crank & Link Shoulder Screw Nut
23	3F-23	4086	Connecting Link(Large)
24	3F-24	4067-A	Connecting Link Guide Screw
25	3F-25	4068-A	Connecting Link Guide Screw Nut
26	3F-26	4083	Knee Press Shaft Crank
27	3F-27	4084	Knee Press Shaft Crank Set Screw
28	3F-28	4087	Connecting Link(Small)
29	3F-29	4088-A	Connecting Link Set Screw
30	3F-22	5207	Connecting Link Set Screw Nut
31	3F-31	4085	Crank & Link Shoulder Screw
32	3F-32	4081-A	Knee Press Shaft Bushing
33	3F-33	4177	Knee Press Shaft Pipe
34	3F-34	11063-A	Knee Press Shaft
35	3F-35	11539	Knee Press Shaft Washer
36	3F-36	4221	Knee Press Stop Lever
37	3F-27	4084	Knee Press Stop Lever Clamp Screw
38	3F-38	4222-B	Knee Press Stop Lever Spring
39	3F-39	4116	Knee Press Stop Lever Spring Pin
40	3F-19	11050	Knee Press Stop Lever Limit Screw
41	3F-25	4068-A	Knee Press Stop Lever Limit Screw Nut
42	3F-43	4010	Skip-Stitch Selecting Ball
43	3F-44	4011	Skip-Stitch Selecting Spring
44	3F-45	4174	Skip-Stitch Selecting Spring Holder
45	3F-46	4170	Skip-Stitch Selecting Grip Bushing
46	3F-47	4172	Skip-Stitch Selecting Cam
47	3F-41	4173	Skip-Stitch Selecting Cam Set Screw
48	3F-49	4175-A	Skip-Stitch Selecting Cam Stud
49	3F-14	4070-A	Skip-Stitch Selecting Cam Stud Nut
50	6F-6	4198	Thread Nipper Spring
51	6F-1	11552	Thread Nipper Disc
52	6F-2	11551	Thread Nipper Staff
53	6F-3	11162	Thread Nipper Releasing Pin
54	6F-4	6053	Thread Nipper Releasing Pin Collar
55	3D-37	130-B	Thread Nipper Releasing Pin Collar Set Screw
56	6F-7		Thread Nipper Releasing Pin Plank
57	3G-3	11156	Screw
58	6F-5		Thread Nipper Releasing Pin Lever

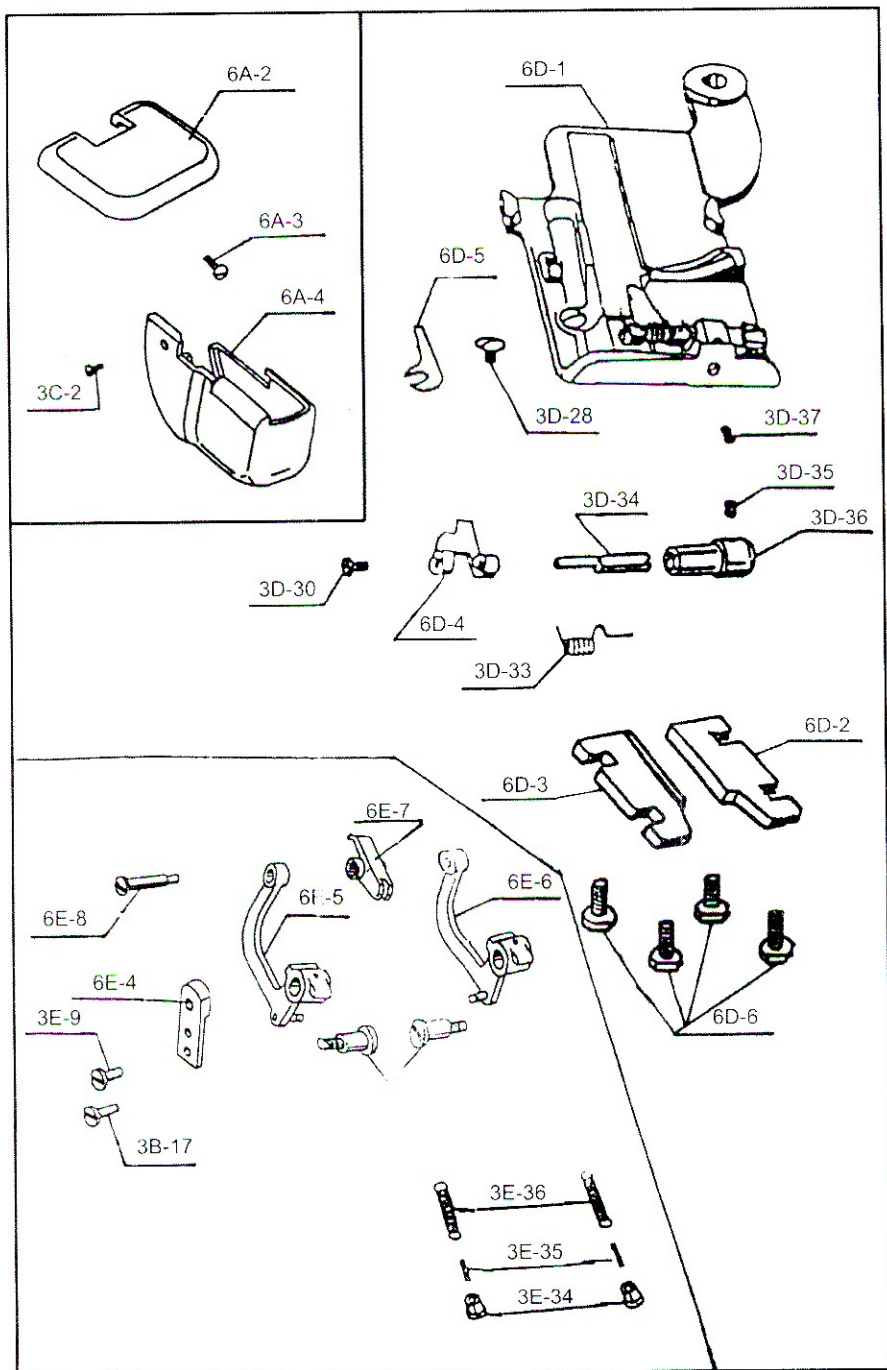


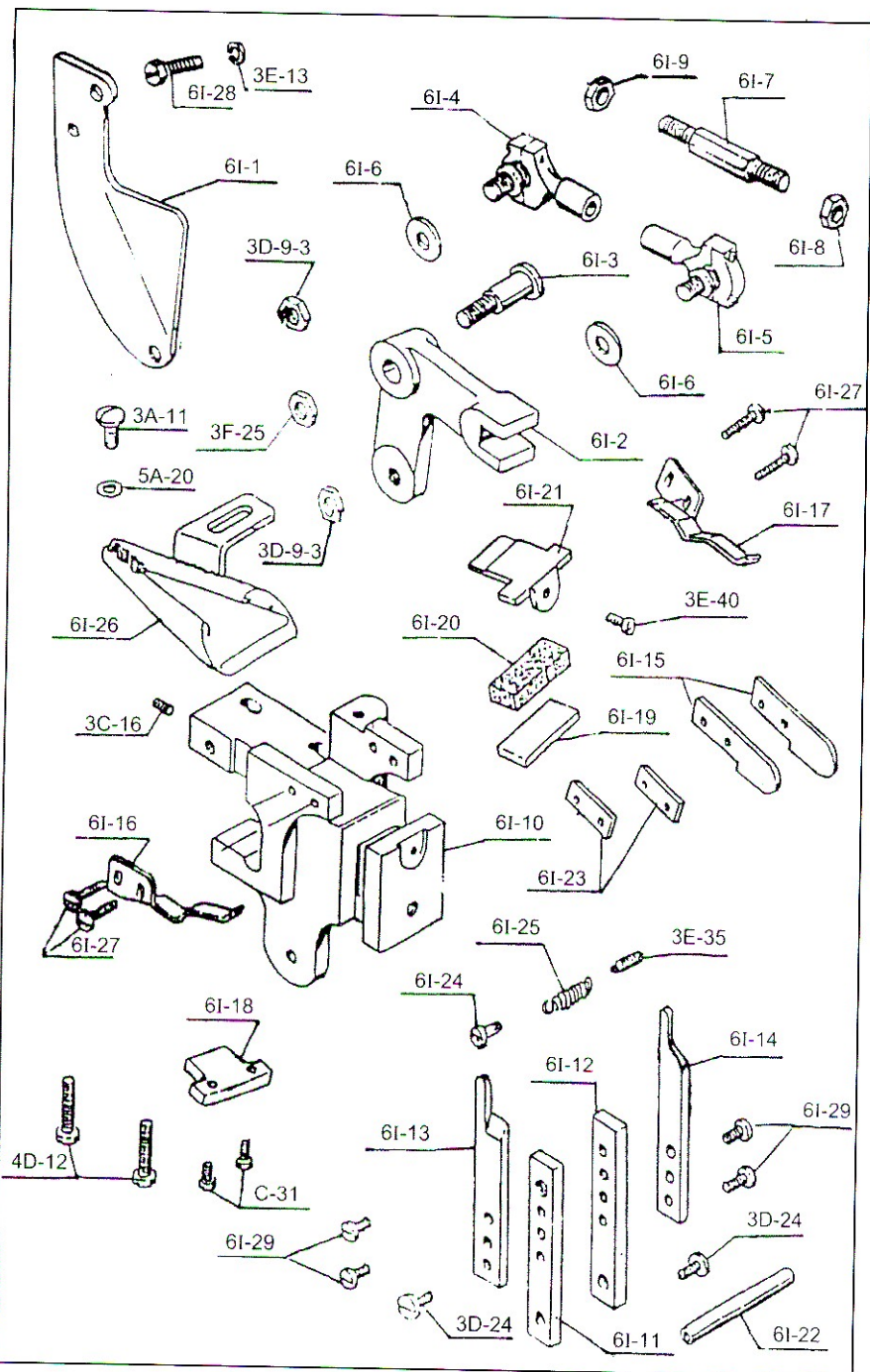
19. Knee Press Components & Standard Accessories

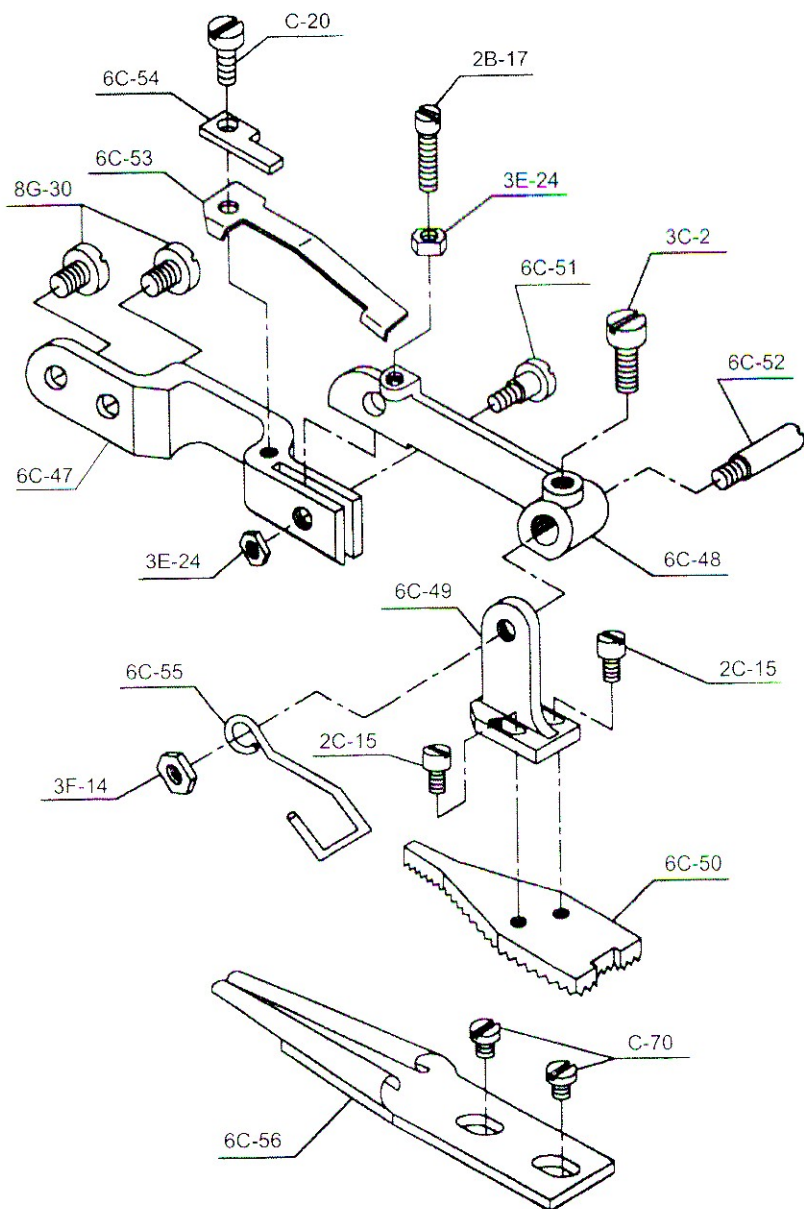
Ref.No.	Symbol	Parts No.	Description
1	3H-1	4152	Thread Guide
2	3C-16	129-A	Thread Guide Set Screw
3	3H-3	4151	Spool Pin
4	3H-4	4150	Cotton Stand Base
5	3H-5	AC-10A	Cotton Stand Base Wood Screw
6	3H-6	AC-03	Screw Driver(Small)
7	3H-7	AC-02	Screw Driver(Medium)
8	3H-8	AC-01	Screw Driver(Large)
9	3H-9	AC-04A/05	Oil & Oiler
10	3H-10	AC-08A	Accessory Bag
11	3H-11	4181	Needle (LW×6T)
12	3G-15	4146-B	Knee Press Rod Sleeve
13	3G-16	4147-C	Knee Press Rod Sleeve Set Screw
14	3G-17	4148-B	Knee Press Rod
15	3G-18	S-21088	Knee Press Rod Set











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