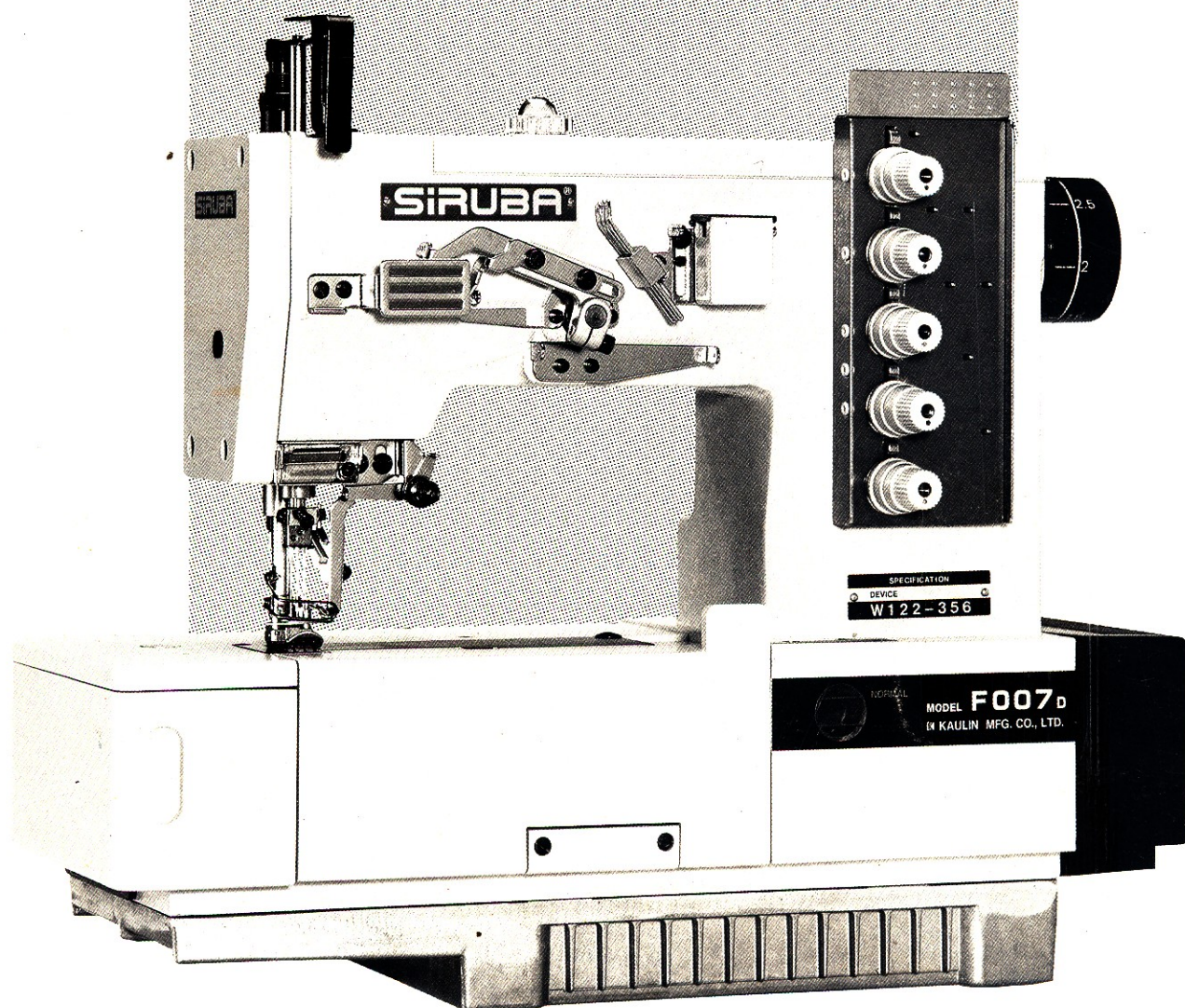


SIRUBA®

F007D



使用說明書&零件圖 INSTRUCTION & PARTS BOOK



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
- . 濾油器之更換
- . 針與線之更換
- . 針之更換
- . 穿線方法
- . 控線調整
- . 針控線桿之調整
- . 上叉控線桿之調整
- . 押具之調整
- . 縫目長度之調整
- . 差動比之調整
- . 押具壓力強度之調整

維修說明

- . 針棒高度調整
- . 針與勾針之盤時位置關係
- . 勾針控線片之調整
- . 前頂針片之調整
- . 後頂針片之調整
- . 送料具高度調整
- . 送料具傾斜調整
- . 上叉導板位置之調整
- . 上叉行程調整
- . 押具提升之前後移動時間
- . 針與勾針之前後擺動
- . 係之調整
- . 勾針前後擺動之調整
- . 勾針線導板之調整

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 OIL FILTER 3
- . LUBRICATING THE NEEDLES AND THREADS 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 RATIO 7
- . ADJUSTING THE PRESSURE OF PRESSER FOOT 7

MAINTENANCE GUIDE

- . THE HEIGHT OF NEEDLE BAR 8
- . TIMING OF NEEDLE AND LOOPER 8
- . ADJUSTING THE LOOPER THREAD TAKE-UP 11
- . ADJUSTING THE FRONT NEEDLE GUARD 11
- . ADJUSTING THE REAR NEEDLE GUARD 12
- . ADJUSTING THE HEIGHT OF FEED DOG 12
- . ADJUSTING THE FEEDING TILT 13
- . SETTING THE POSITION OF SPREADER
THREAD GUIDE 15
- . ADJUSTING THE SPREADER'S STROKE 15
- . ADJUSTING PRESSER FOOT LIFT 16
- . ADJUSTMENTING THE TIMING OF NEEDLE
AND LOOPER 17
- . ADJUSTING THE LOOPER'S MOTION 17
- . ADJUSTING THE LOOPER THREAD GUIDES 17

SPARE PARTS LIST 18-33

SPARE PARTS CONVERSION CHART 34

TABLE CUT-OUT 35-37

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。

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.

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 20mm 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 20 mm. 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.

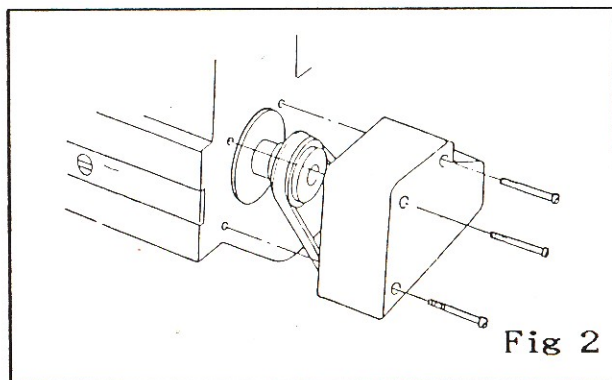
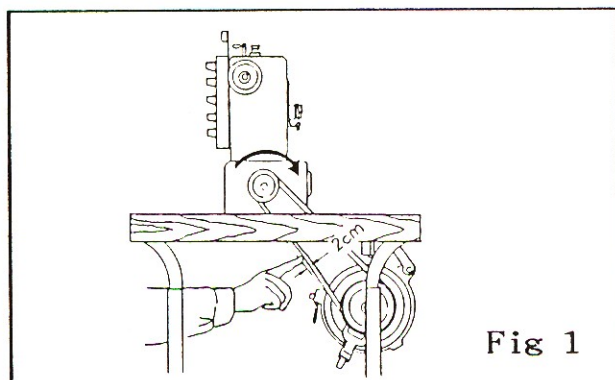


Table 1 (表 1)

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

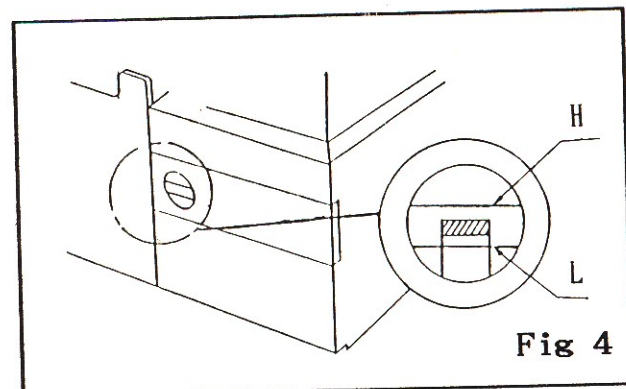
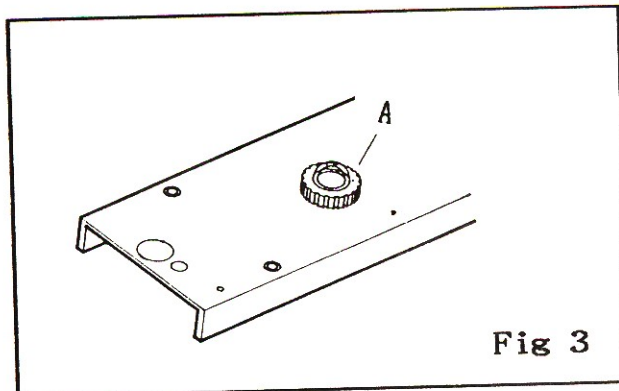
1. Clutch motor, 1/2 HP (400W)
3 phase, 2 pole M type V belt.
2. The center line of both motor
and machine's pulley must be
aligned each other when
installing the motor.

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
指示窗之下限時,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。

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.



* 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.

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 weeks 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

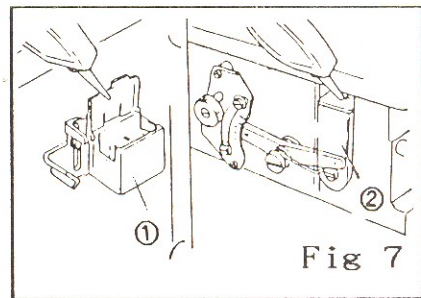
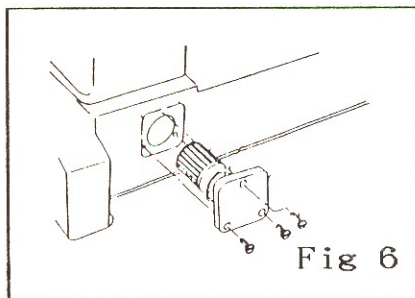
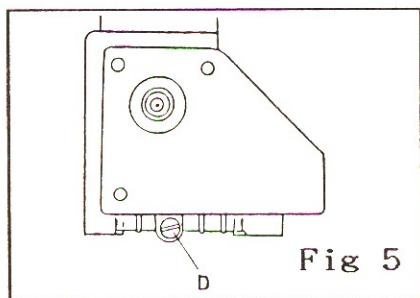
This machine is equipped with an oil filter, and the filter must be cleaned every month. Replace the filter if necessary. (Fig 6)

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)



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) 並取下舊針, 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

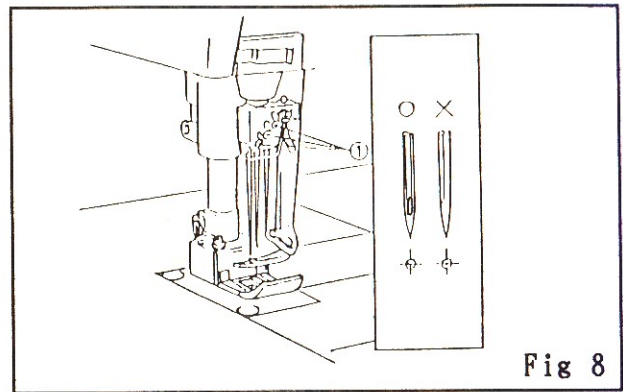


Fig 8

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.

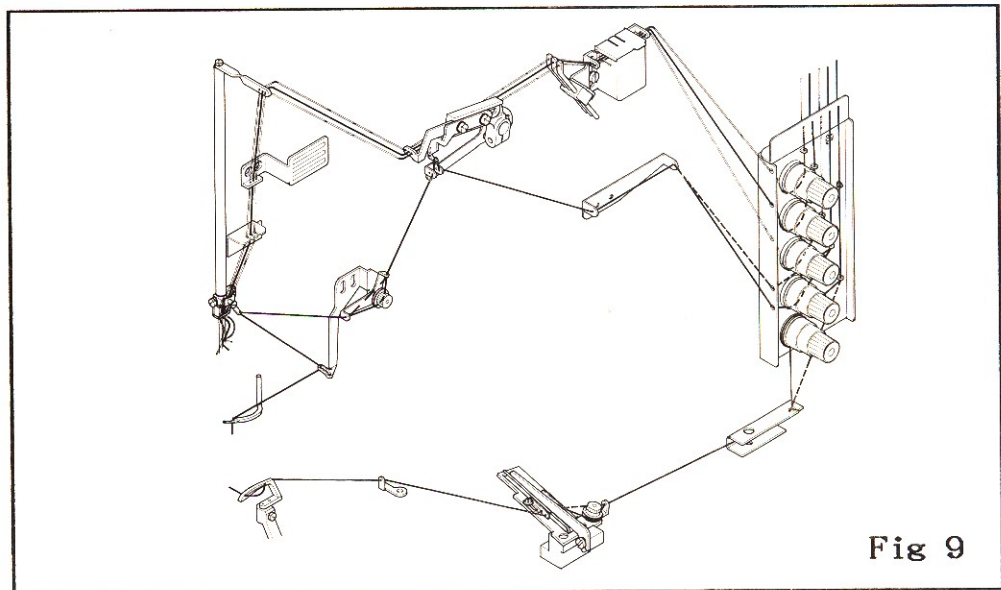


Fig 9

拉線鬆緊度調整

ADJUSTING THREAD TENSION

拉線強弱必須根據車縫材料，厚薄，線與針距等不同而做調整。將拉線控制鈕（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 types and the thicknesses of the fabrics being sewed;
2.The threads;
3.The needle gauge.

If you turn the thread tension knob (1) clockwise, thread will be tighter. (Fig 10)
If you turn it counter-clockwise, will be looser.

1. 轉動機器使針棒處於最低位置時, 針線控線桿擺臂 (1) 的上邊必須成水平, 必要時可放鬆螺絲 (4) 調整之。(圖 11)

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

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

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

註：

欲將針線調緊些, 則將控線桿 (3) 向左方向移動。

欲將針線調鬆些, 則將控線桿 (3) 向右方向移動。

Note:

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

3. 上叉控線桿 (5) 不要調動。

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

上叉控線桿調整

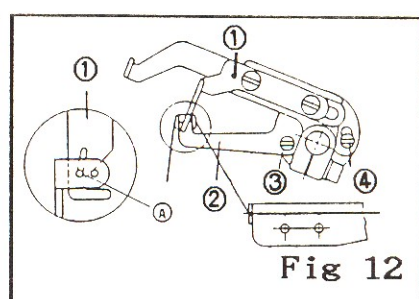
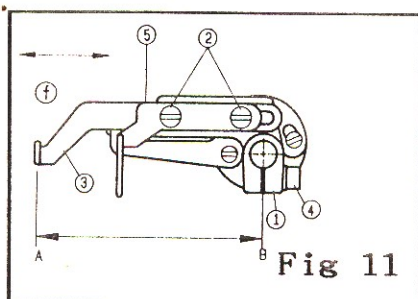
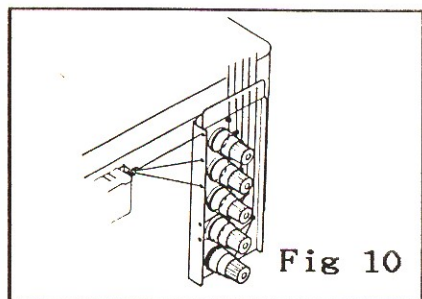
ADJUSTING SPREADER THREAD TAKE-UP

1. 當上叉控線桿 (1) 調至最高點, 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)

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

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無階段式調整或一英寸 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),再以右手轉動皮帶輪,直到左手指感覺按鈕嵌入到機器內部卡筈。(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.斷續轉動皮帶輪,選擇所需之縫目長度對準(B)然後左手放開按鈕。(圖 15)

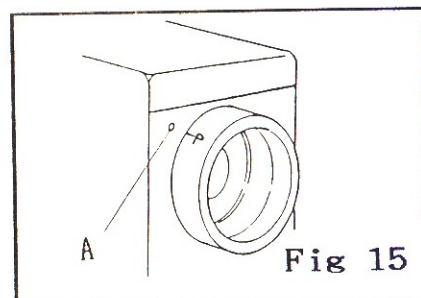
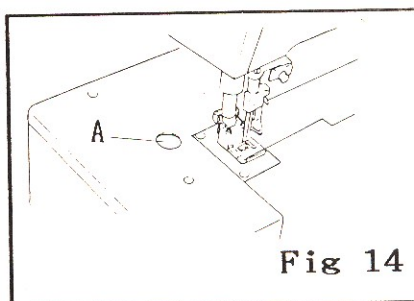
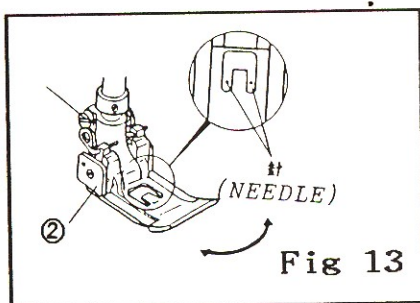
2.Keep turning handwheel for a inquired stitch length, whose scale indicated on the handwheel must be aligned with, then stop pressing the button. (Fig 15)

3.欲調長針距時,將皮帶輪順時針方向旋轉;反之則小。

3.Turn the handwheel clockwise to increase the stitch length, and counter-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 (1), 上下移動調整桿來調整差動比。(圖 16)

*要伸張布料車縫時, 則將調整桿 (2) 往上移。

*需摺景車縫時, 則將調整桿 (2) 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 A。(圖 17)

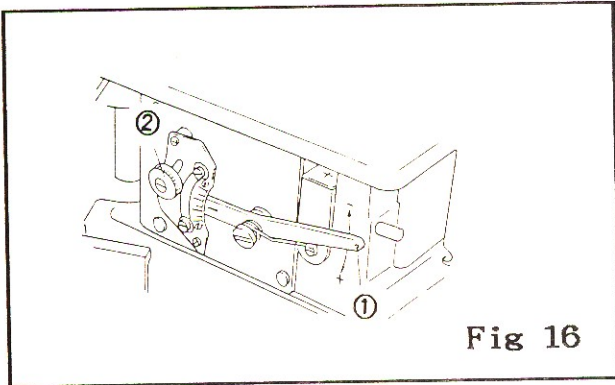


Fig 16

ADJUSTING DIFFERENTIAL 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 (1), move the indicator (2) up or down.

*To stretch the cloth, move the indicator (2) upward;
To gather the cloth, move the indicator (2) 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, then fasten nut (A). (Fig 17)

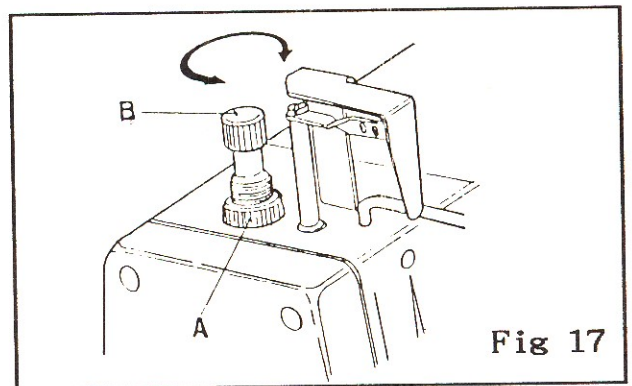


Fig 17

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：

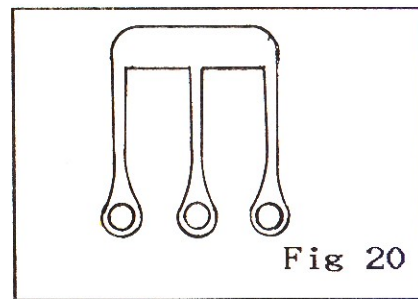
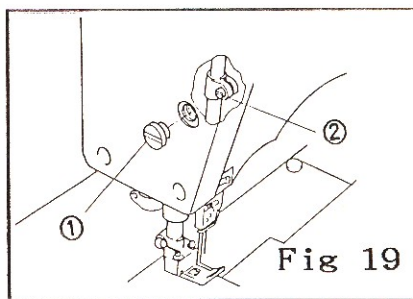
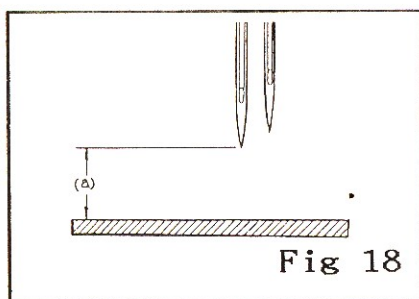
- (1)針必須完全插入針繡孔中。
- (2)經過調整後,必須確定每一根針是通過針板的針孔中央。(圖 20)

Remark:

- (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	8.5 mm
		6.4 mm	8.1 mm



針與勾針之時位關係

TIMING OF NEEDLE AND LOOPER

- 1.當針棒移至最低點時,勾針也剛好是最右點,亦即針棒開始提昇時,勾針也跟著開始向左移,且勾針是從後面通過,再由前退回原來之位置。(圖 21)

1. When the Needle Bar is in the lowest position, the Looper should be at the extreme right point. Therefore, when the Needle Bar starts to move up meanwhile the Looper starts to move to the left. And its route is passing behind the needles, then reverting

to the original position in front of the needles. (Fig 21)

調整時：(圖 22)

- (1) 打開機器上蓋；
- (2) 鬆開螺絲 (1)，並轉動皮帶輪 (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。

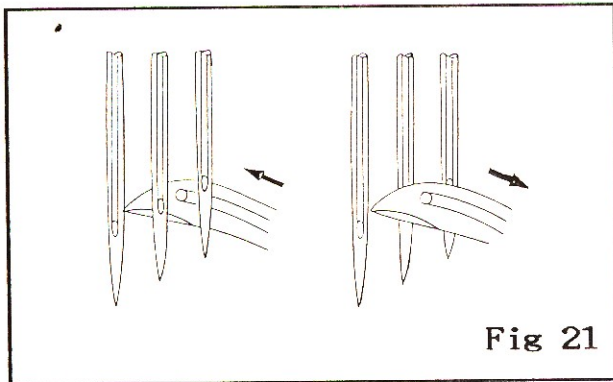


Fig 21

To adjust: (Fig. 22)

1. Remove the Arm Top cover.
2. Loose the screws (1), turn the handwheel (2) and the crankshaft of the Upper Belt Gear (3).
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.

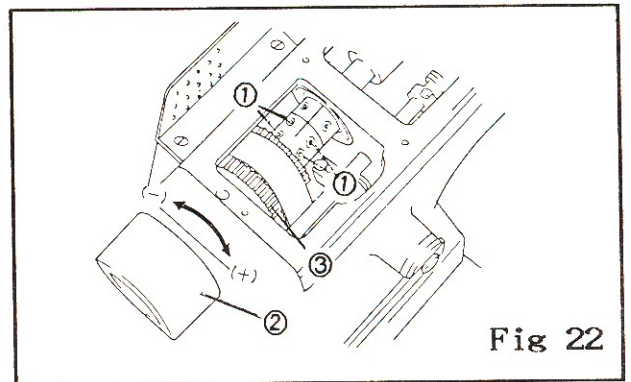


Fig 22

- (4) 當下勾針移至最左邊針之針中心點時勾針尖端與最左針之針眼之距離約 1.0-1.2mm，且針與勾針的空隙約 0-0.05mm。(圖 23)

- (4) When the Loper point is behind the left needle, the distance between the Loper point and the top edge of the left needle's eye should be 1.0 - 1.2 mm. The clearance between the needle and the looper should be 0 - 0.05 mm. (Fig 23)

- (5) 當左針下降至針尖與勾針上沿齊時，勾針眼之中心與左針中心線距離約 5.0-6.0mm。(圖 24)

- (5) When the left needle goes down and its point is flush with the looper blade, the distance between the center of the looper's eye and the centerline of the extreme left needle should be 5.0 mm-6.0 mm. (Fig 24)

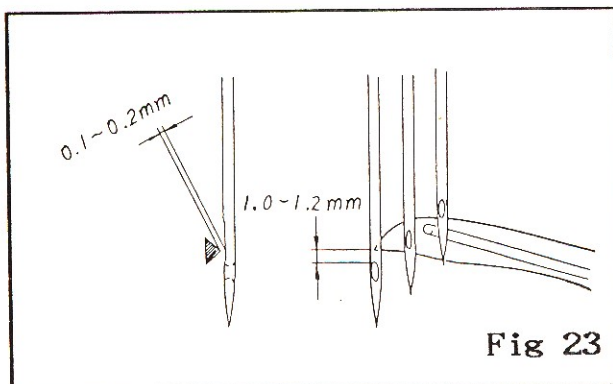


Fig 23

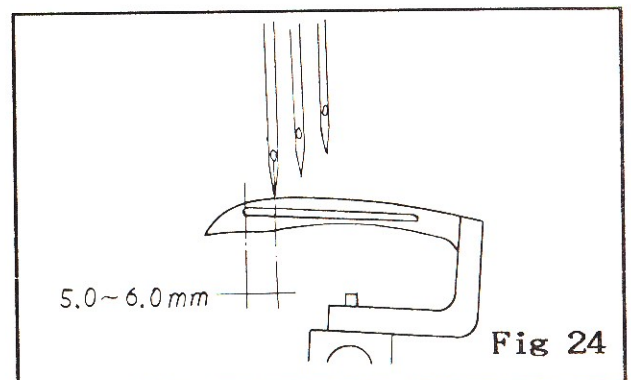


Fig 24

2. 當勾針移至最左邊時右針中央線到勾針針尖之距離如表 4.

The standard settings of the Looper is when the looper moves to extreme right, The distance between the centerline 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再按下列步驟調整:

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

1. 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)

1. 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)

2. 調整與勾針之間隙

2. To set clearance between the needle and the Looper:

*當勾針針端位於左邊針中央線の後方時,左針之針眼與勾針尖端的空隙約 0.1-0.2 mm. (圖 23)

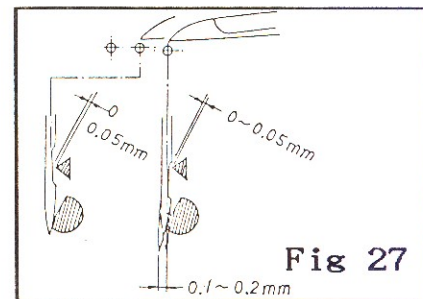
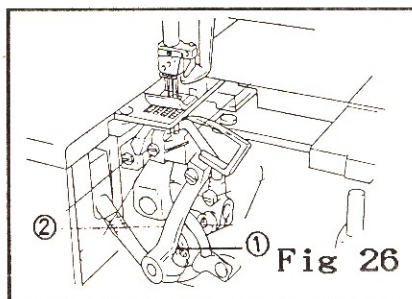
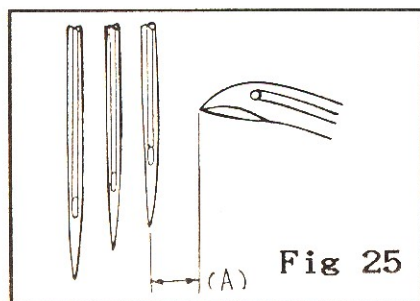
*When the Looper point is behind the left needle, the distance between the Looper point and the top edge of the left needle's eye should be 1.0 - 1.2 mm. The clearance between the needle and the looper should be 0 - 0.05 mm. (Fig 23)

*假如是三針機器時,當勾針尖位於中間針之針中心後面時,針與勾針之間隙是 0-0.05mm. (圖 27)

*For three needle machines, when the looper point is behind the centerline of the middle needle, the clearance between the needle and the Looper should be 0-0.5mm. (Fig 27)

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	4.0 - 4.3mm	5.6mm	3.2 - 3.5mm
		6.4mm	2.8 - 3.1mm



勾針控線盤之調整

ADJUSTING 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。

- 1.對雙針機型,左針針端在勾針之 2/3 處;(圖 28)
- 2.對三針機型,左針針端與勾針下緣等高。(圖 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)。

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

- 1.For the 2-needle machine, while the end of the left needle is in 2/3 position of the Looper. (Fig 28)
- 2.For the 3-needle machine, the end of the left needle is vertical to the lower edge of the Looper. (Fig. 29)

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

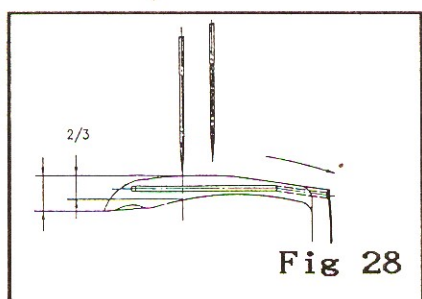


Fig 28

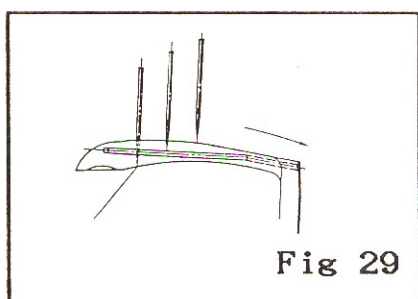


Fig 29

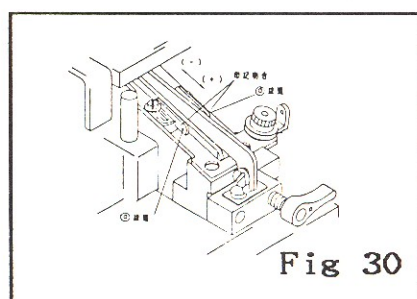


Fig 30

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。(圖 31)

- 2.針和前針護片間之空隙必須儘可能小至只讓線通過即可。

- 3.調整時:鬆開螺絲(2)並前後移動針護片(1)。

- 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. (Fig 31)

- 2.The clearance between the needles and the Front Needle Guard should remain so close that only the needle threads can pass through.

- 3.To adjust, loosen the screw (2), and move the Front Needle Guard (1) back or forth.

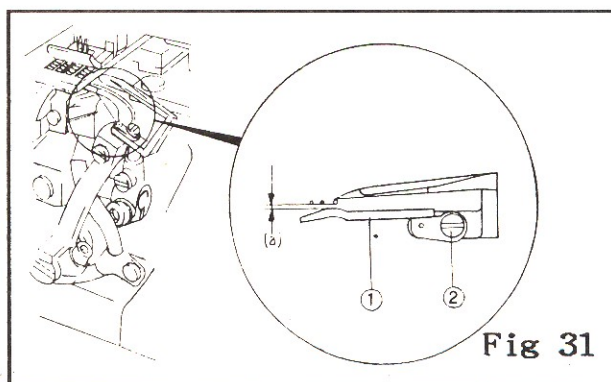


Fig 31

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.爲了得到空隙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.(Fig33)

- 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) then move the Rear Needle Guard upwards or downwards.

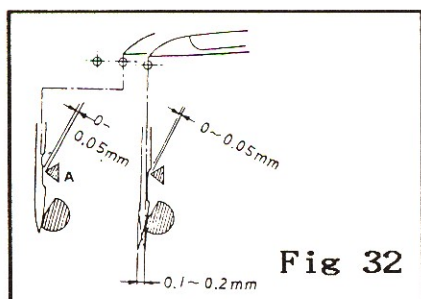


Fig 32

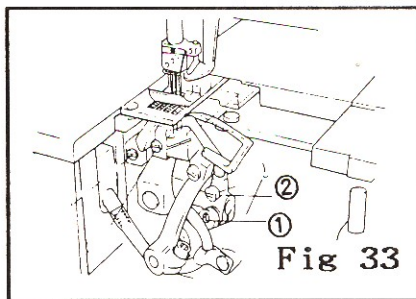


Fig 33

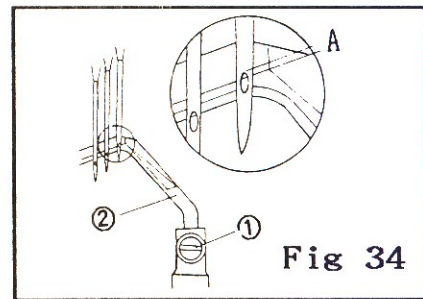


Fig 34

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0.8-1.2MM。(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 level height as the point A of the Main Feed Dog.

調整時鬆開螺絲 (4)(5), 並上下移動送布齒。(圖 36)

To adjust, loosen the screws (4)(5), and move the feed dog upwards or downwards. (Fig 36)

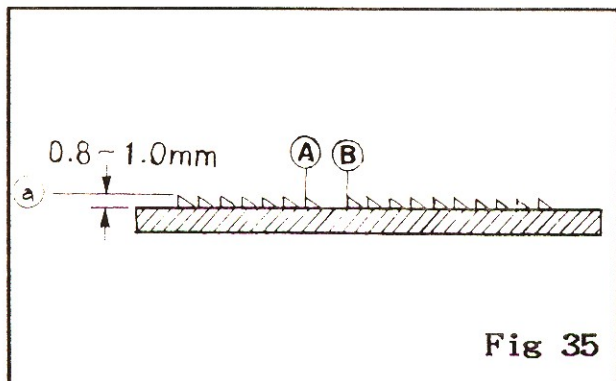


Fig 35

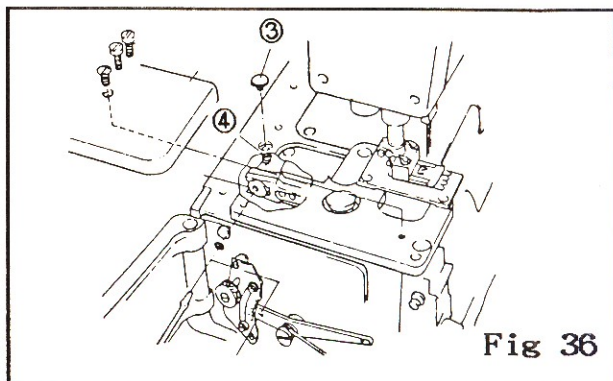


Fig 36

送布齒傾斜調整

ADJUSTING THE FEEDING TILT

當送布齒升至最高點時, 送布齒齒尖成一直線, 且與針板平行。

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.

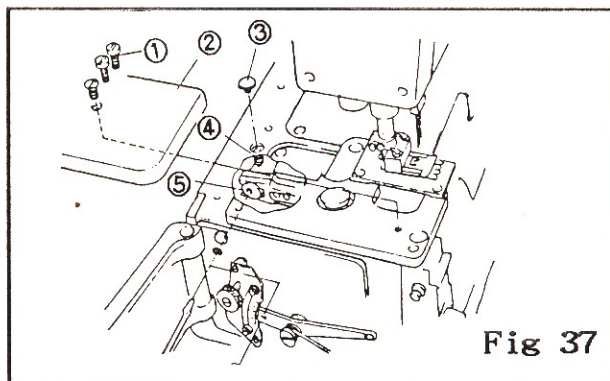


Fig 37

上叉之設定

SETTING THE POSITION OF SPREADER

1. 上叉之高度為 8.5MM. (圖 38)

1. The height of the Spreader must be kept at around 8.3-8.7mm from the top surface of the Needle Plate. (Fig 38)

3. 上叉(1)移動時,其勾尖B點必須在左針前約0.5MM處通過上叉導板,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 0.5mm 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 (B) and the left needle when the Spreader is in its extreme left point. (Fig 39,40)

調整時：

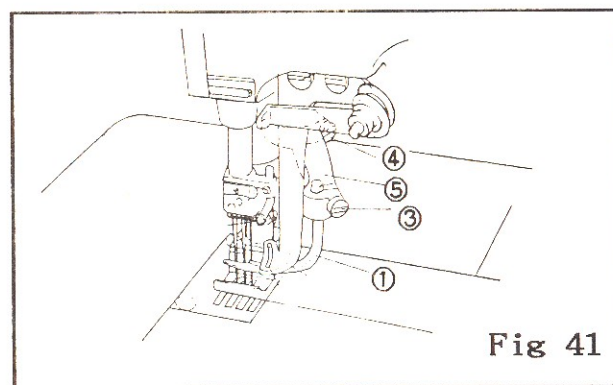
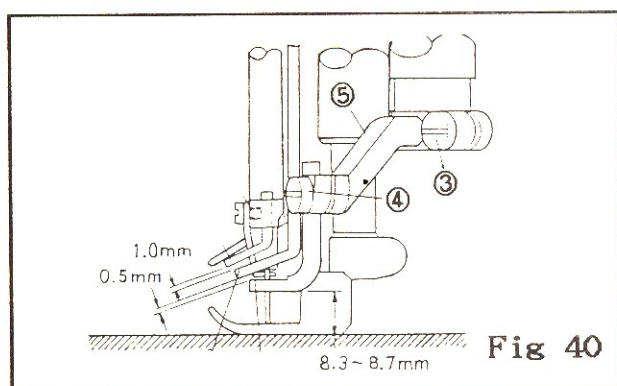
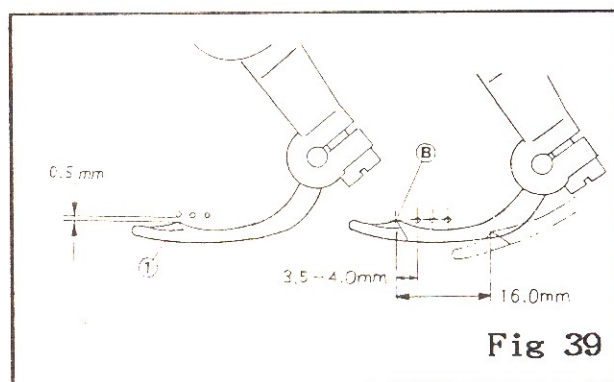
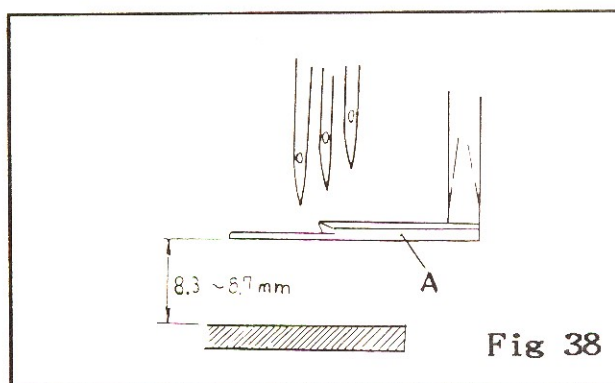
- (1). 鬆開螺絲(4),轉動上叉搖桿(5),及前後移動(1),然後固定位置,鎖緊螺絲(4)。(圖.41)

To adjust:

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). 上列移動上叉(1),使其離針板之高為8.5MM,然後鎖緊螺絲(3)。

2. Move the spreader (1) upwards or downwards to set its height from the needle plate to 8.5mm, 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,裝飾線導板(2)之線溝剛好在導線片(3)孔之下方,且裝飾線導板(2)與裝飾線勾針(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 the guide (3). And the clearance between 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,針線導線片(3)與裝飾線導板(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 (3). The concavity of the Spreader and the thread eye should face each other. (Fig 42)

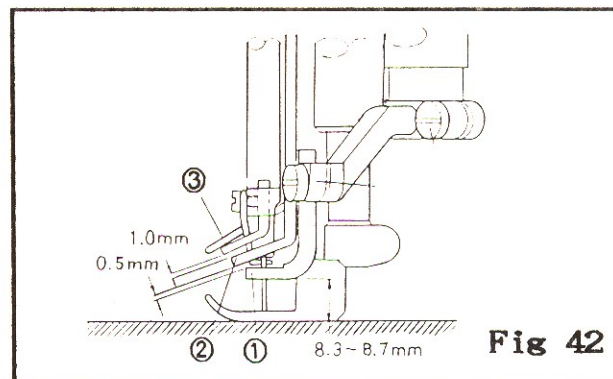


Fig 42

上叉行程調整

ADJUSTING THE SPREADER STROKE

上叉的行程是17-17.5。(圖39)

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

1.移開上蓋和螺絲(1)。(圖43)

1.Remove the Arm Cover and the screw (1). (Fig 43)

2.鬆開螺母(2),並上下移動連桿(3)

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。

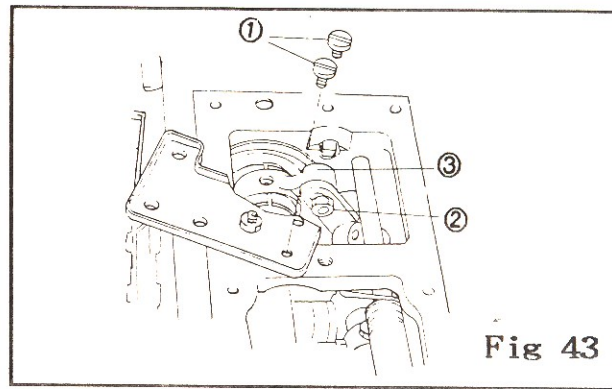
*In order to decrease the Spreader's stroke, move the Connecting Rod (3) upwards.

*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。(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.轉動皮帶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。

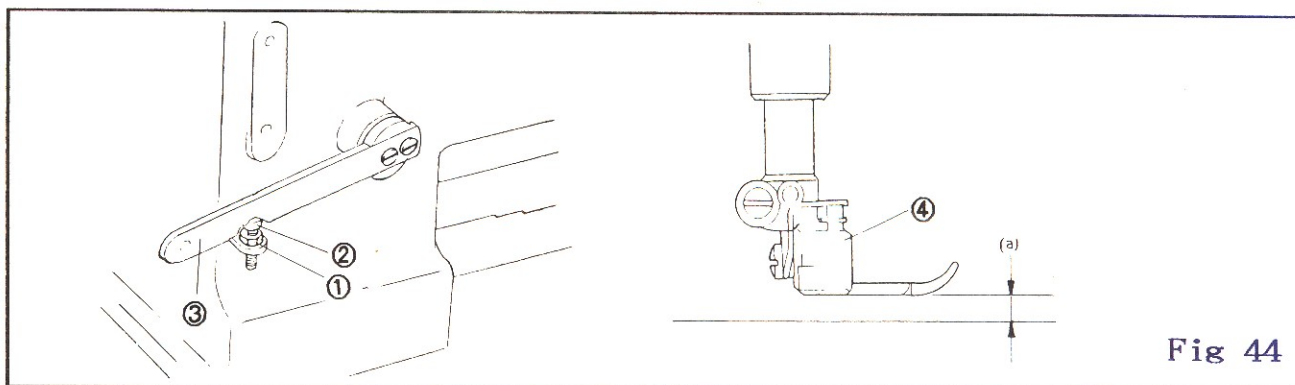
2.Loose the nut (1) and lower the screw (2);

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)使頂往連桿(3),並固定螺絲(1)。

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



針與勾針前後移動時間關係之調整

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

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

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

勾針前後擺動行程之調整

ADJUSTING THE LOOPER'S MOTION

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晃動行程, 反之則增加。(圖 45)

1. The Looper's motion is passes 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)

勾針線導板之調整

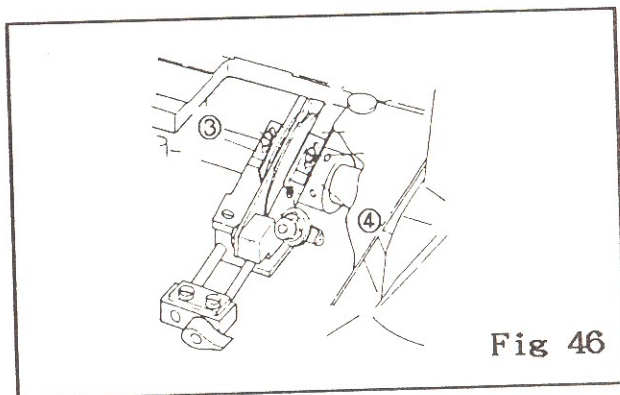
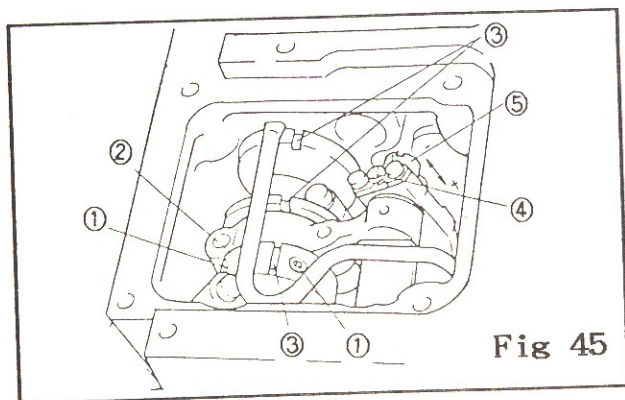
ADJUSTING THE LOOPER THREAD GUIDES

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)

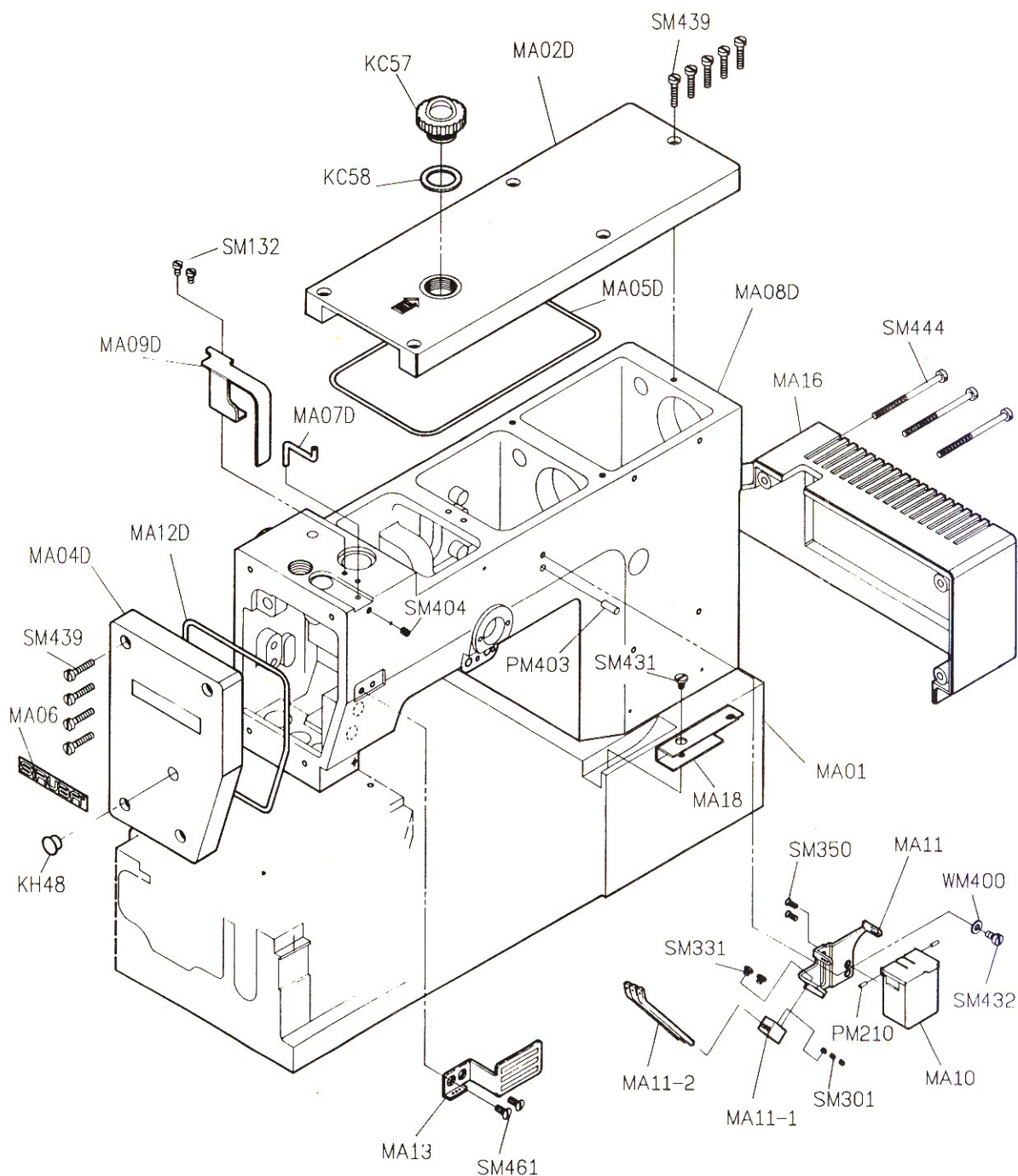
When the Looper is at the left exact point, the looper thread between the two guides should be slightly tensioned (Fig. 46)

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。

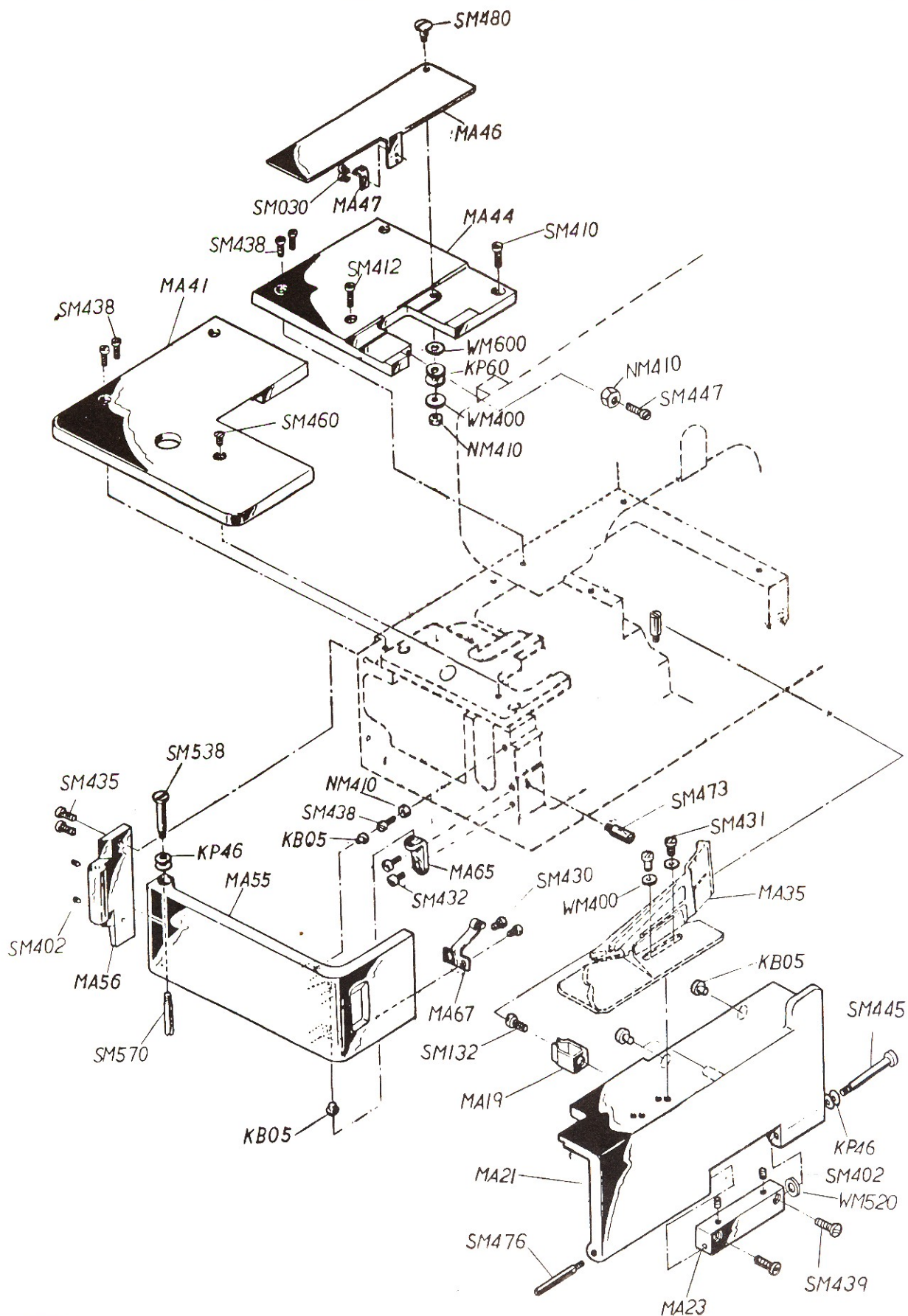
According to the alining mark on the bracket (3), adjust the two Thread Guides (3) and (4) to the level which the eyes of the two thread guides are parallel.



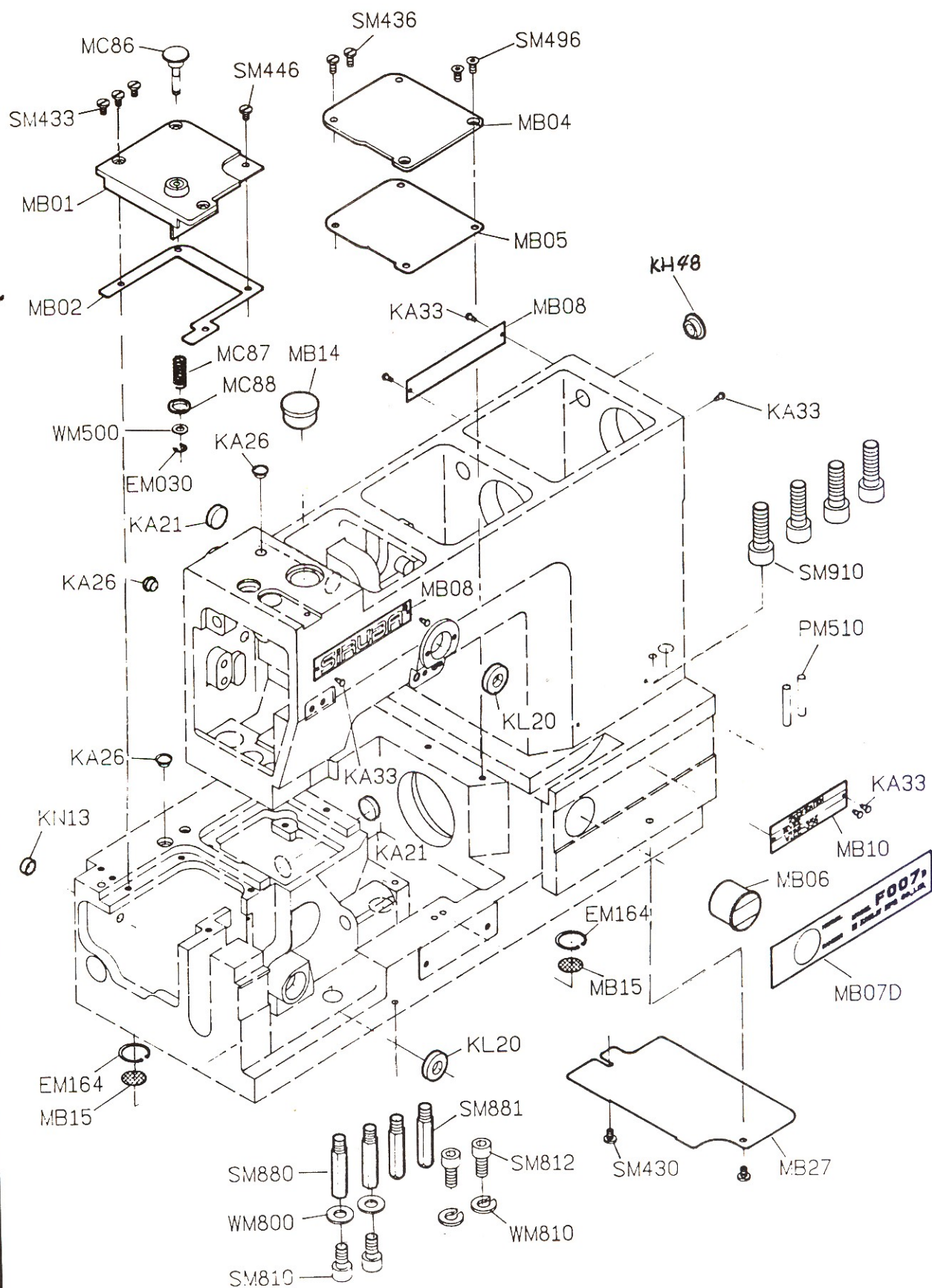
PARTS LIST FOR MA GROUP



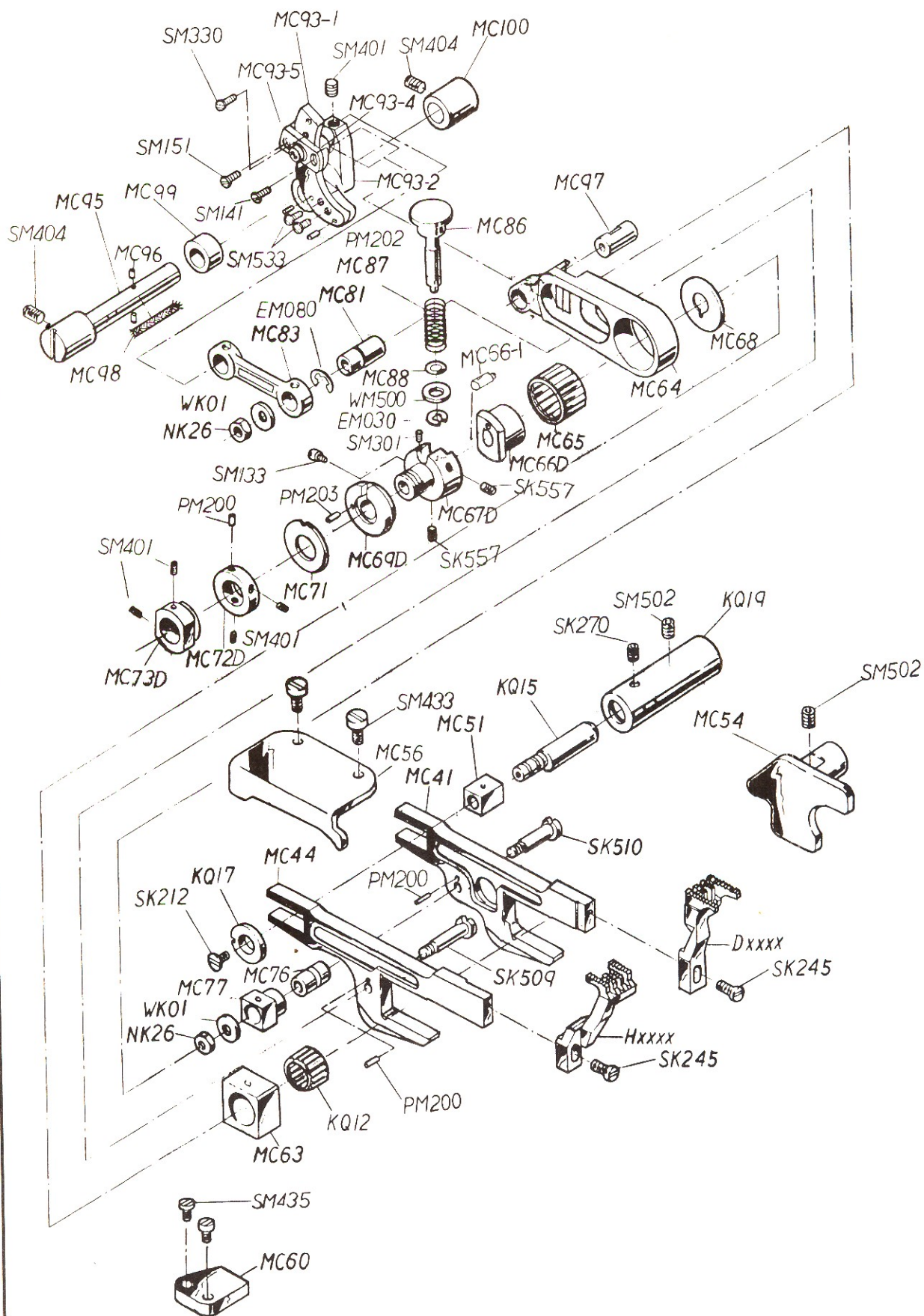
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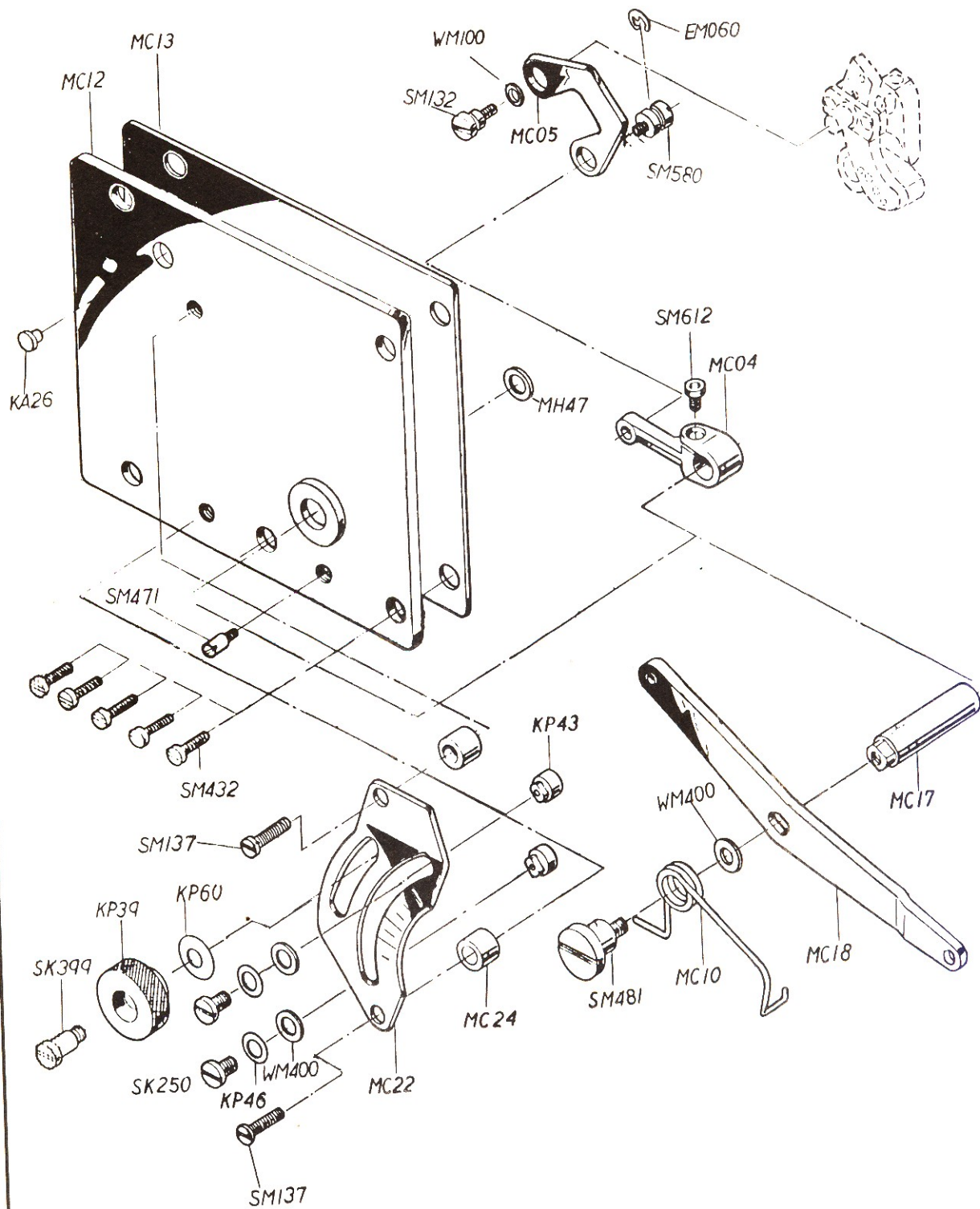
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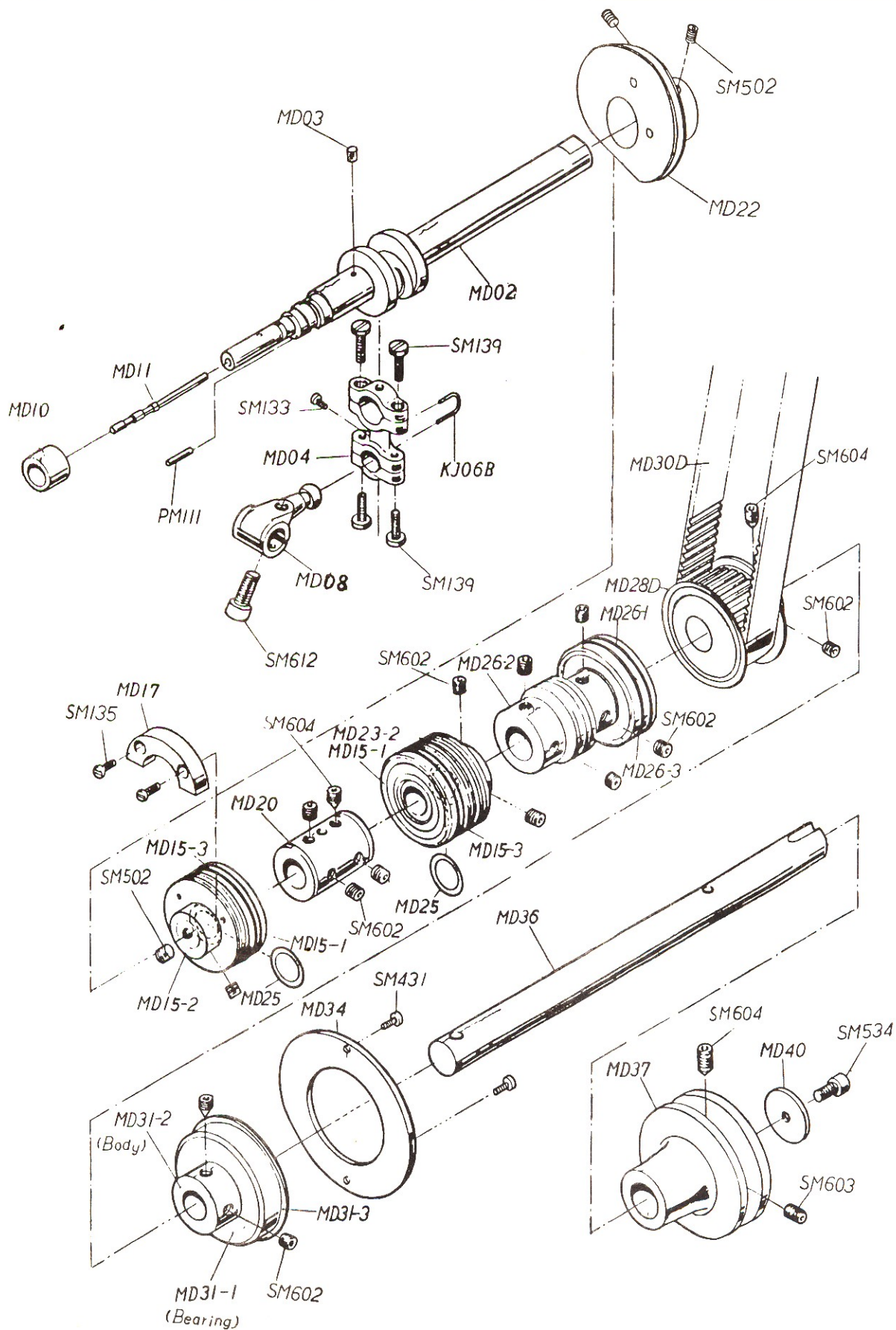
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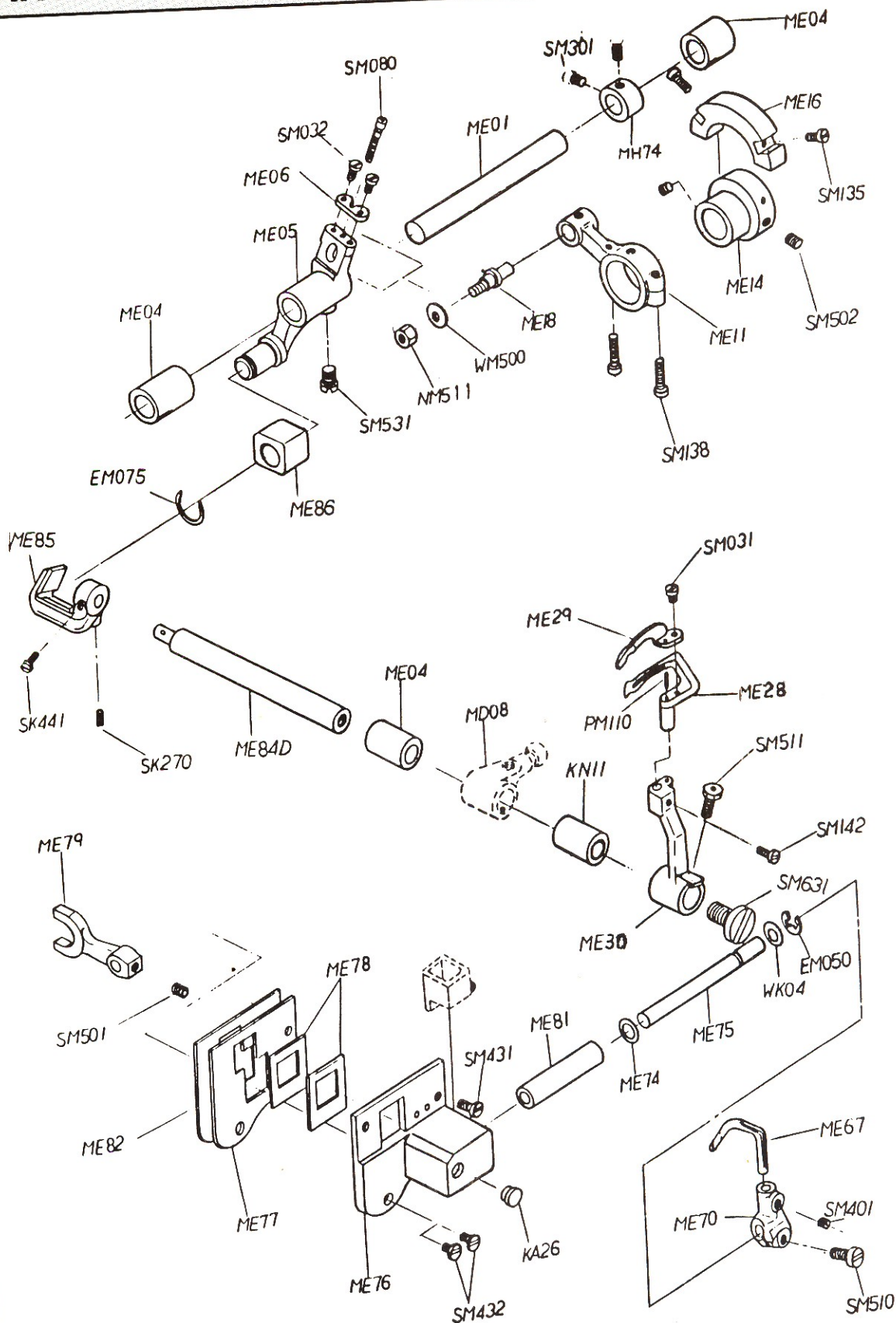
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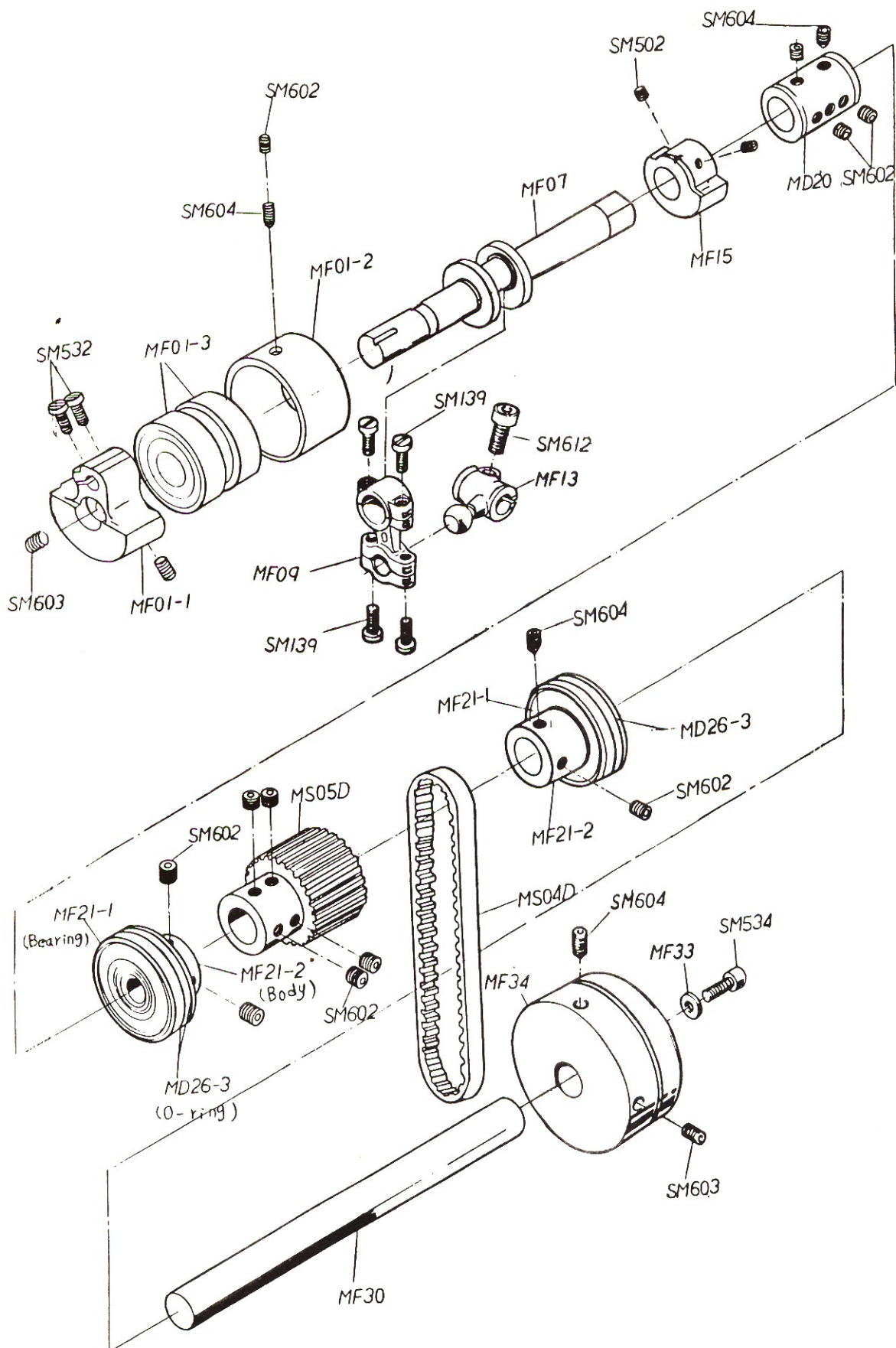
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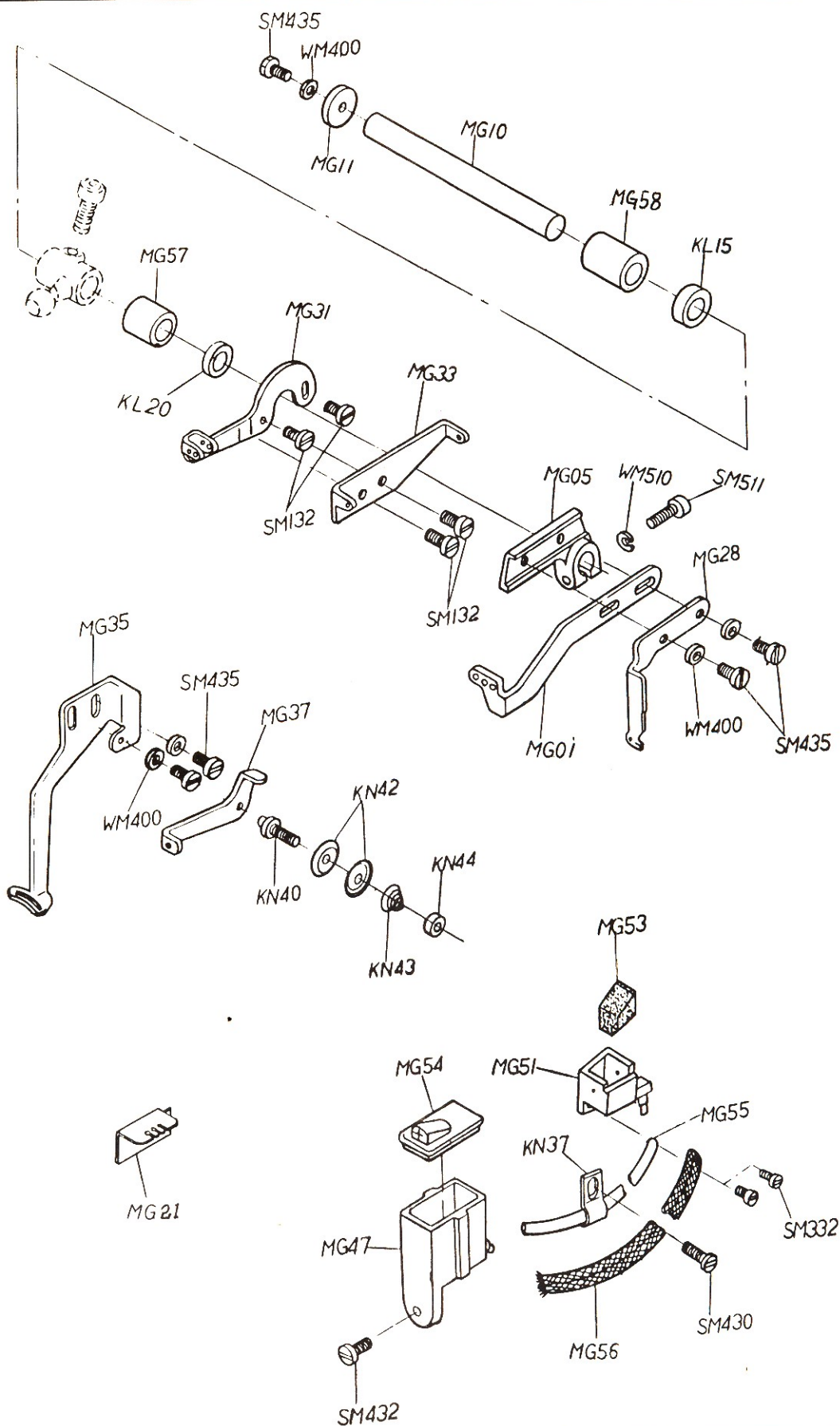
PARTS LIST FOR ME GROUP



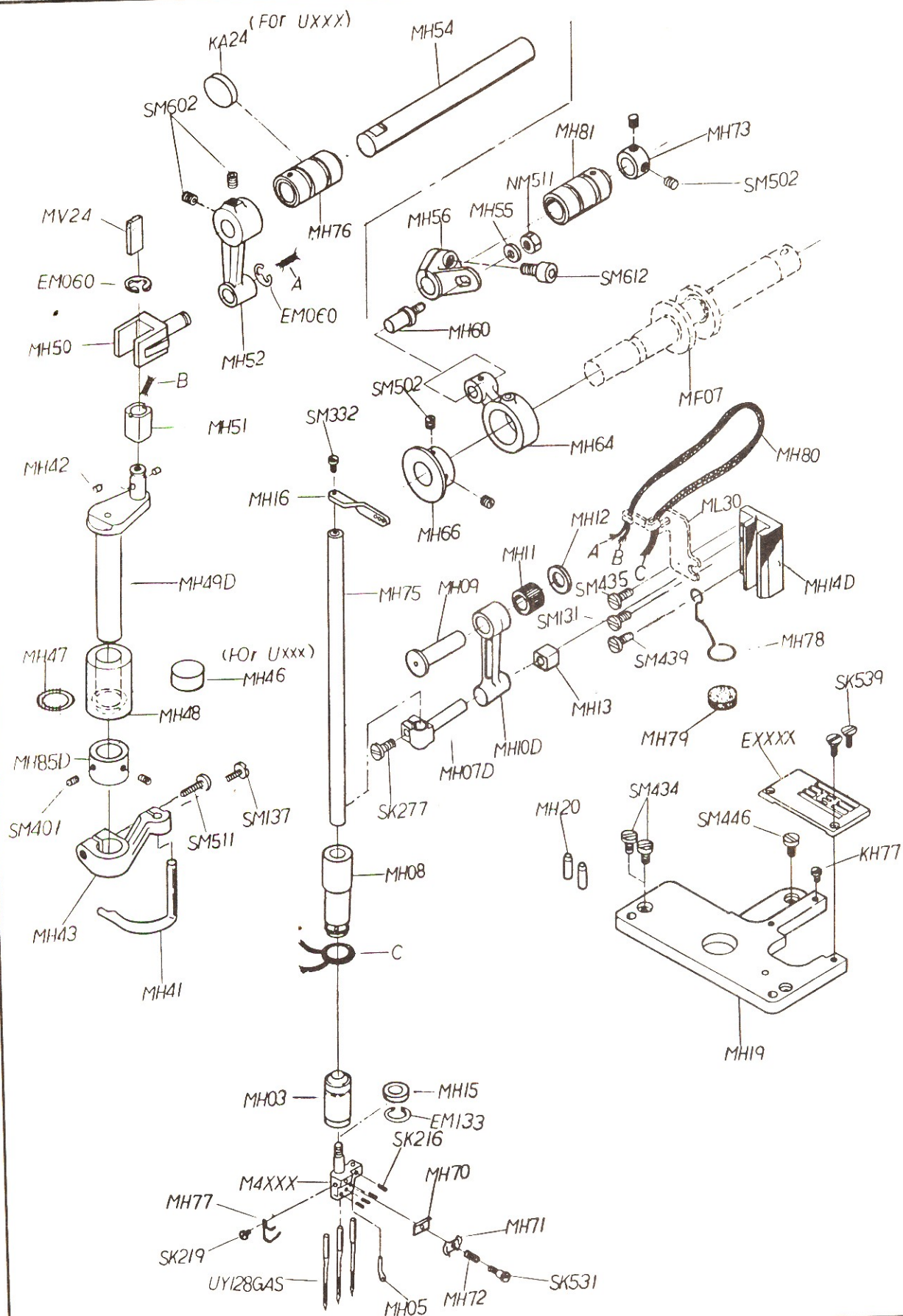
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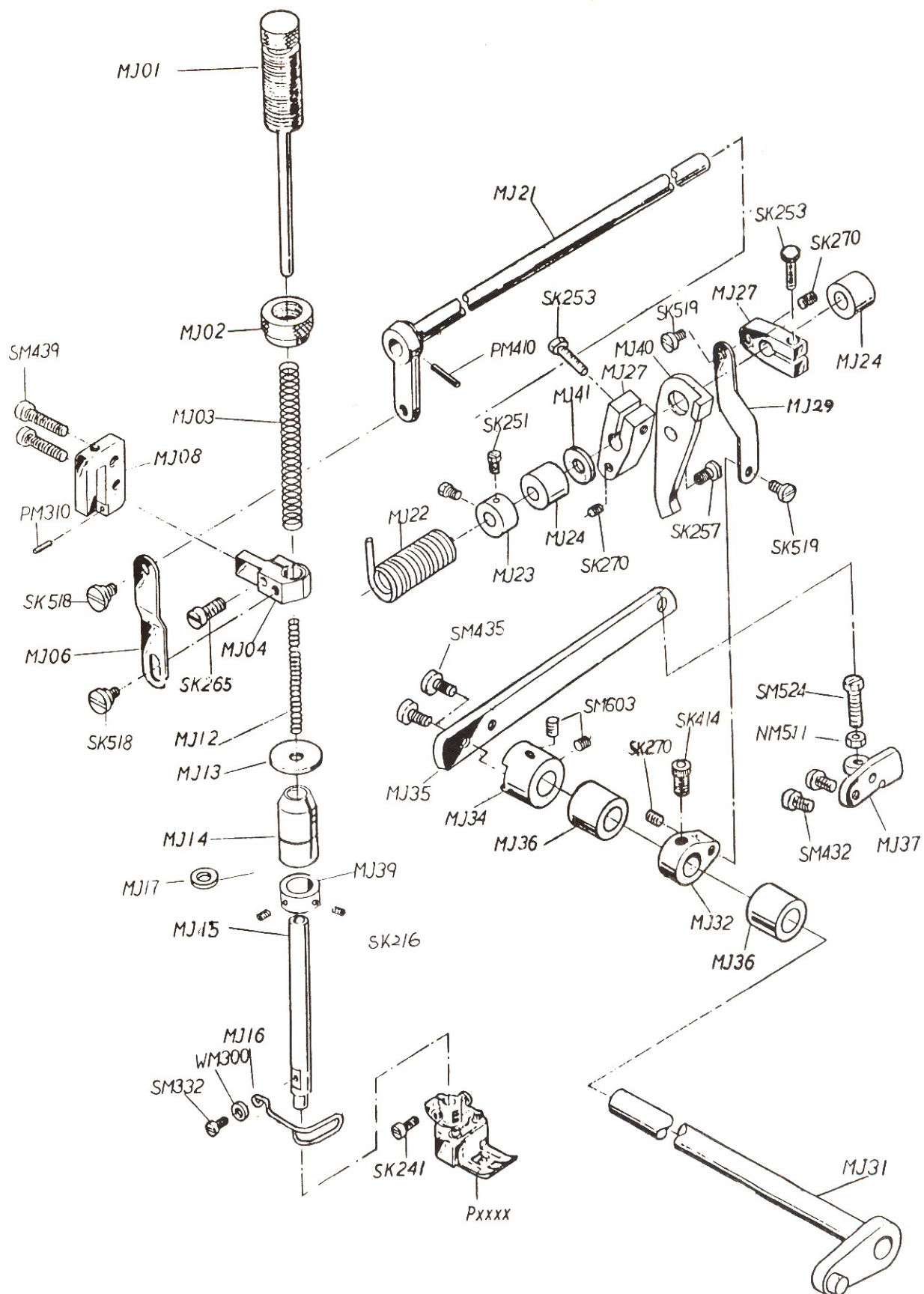
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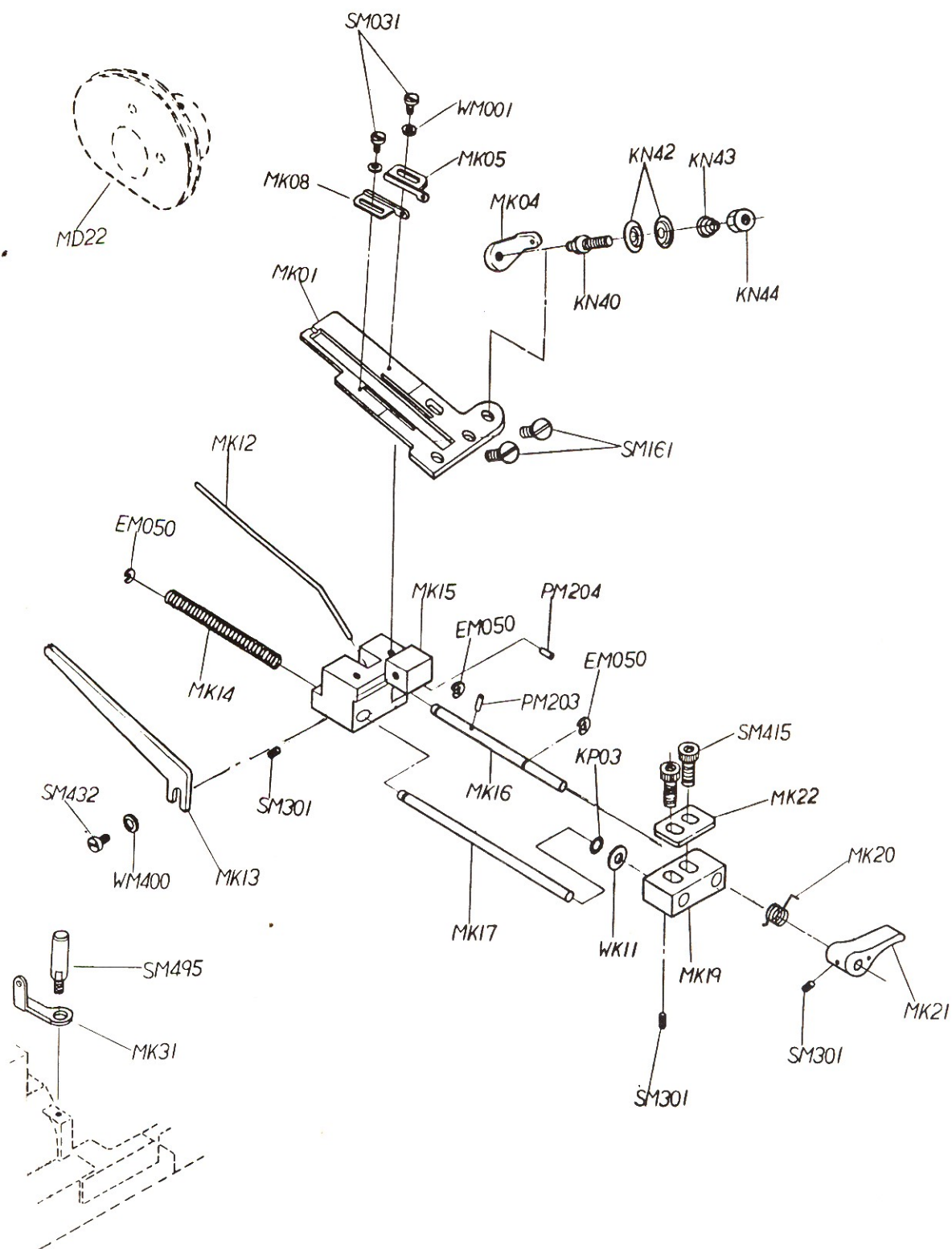
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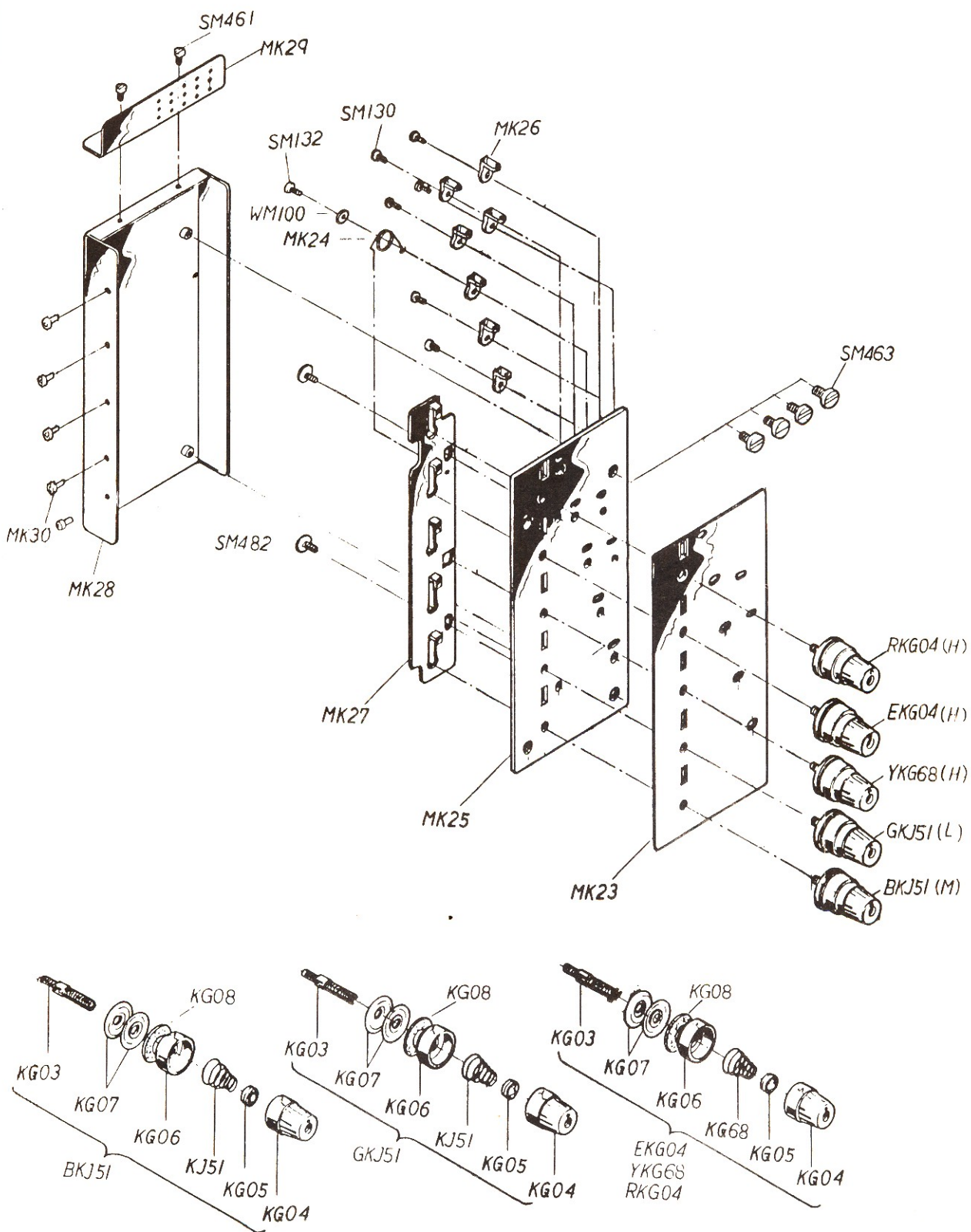
PARTS LIST FOR MJ GROUP



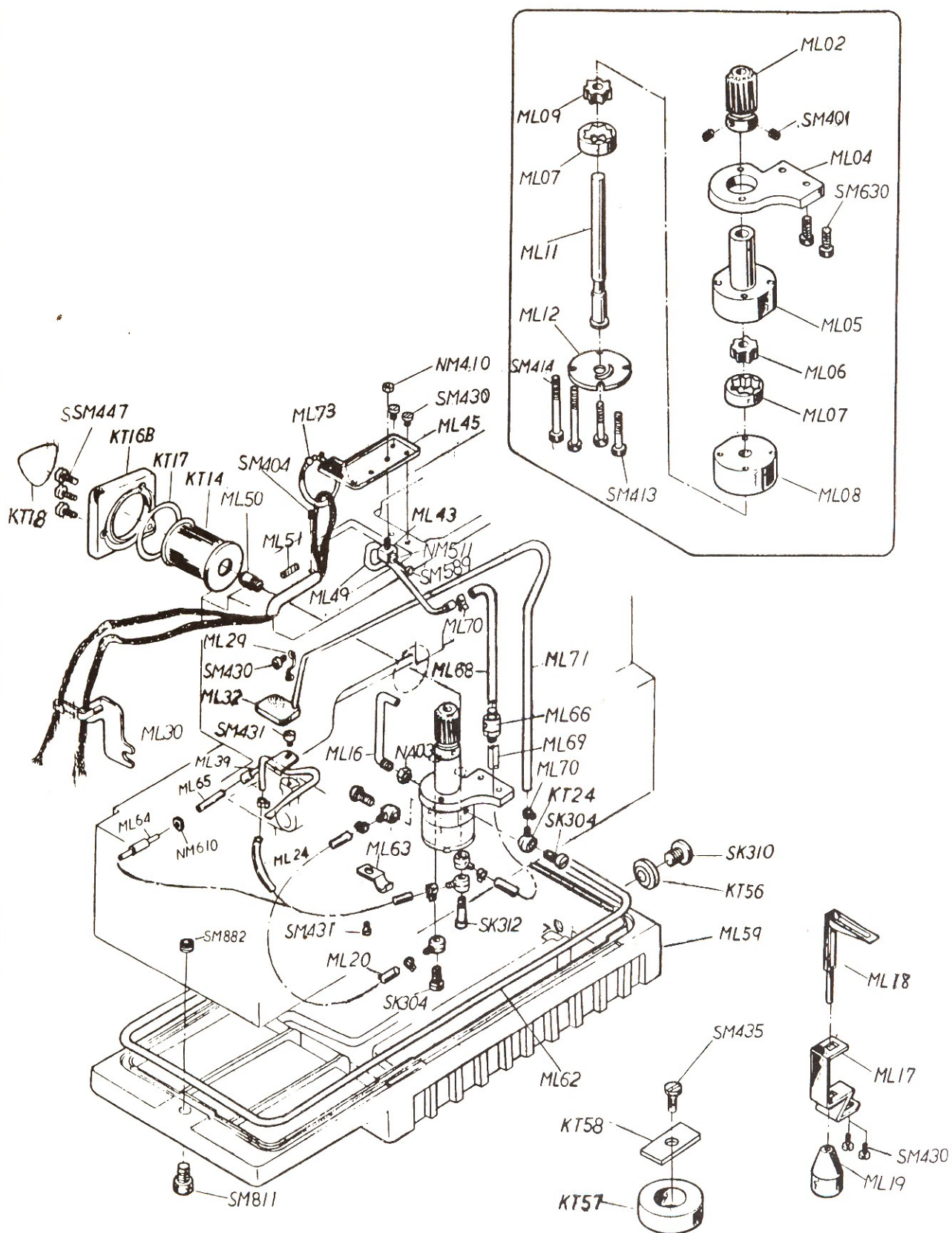
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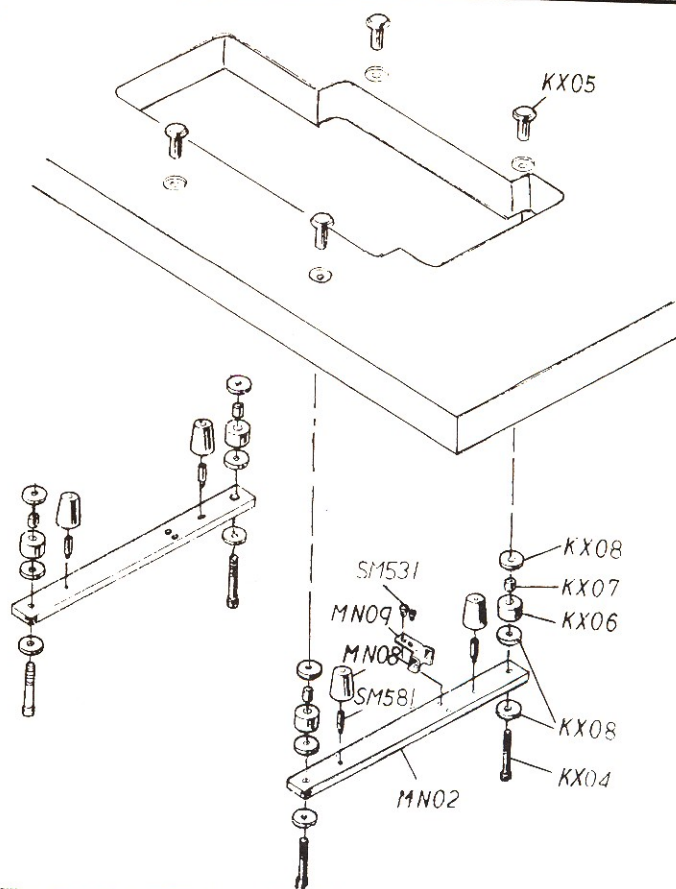
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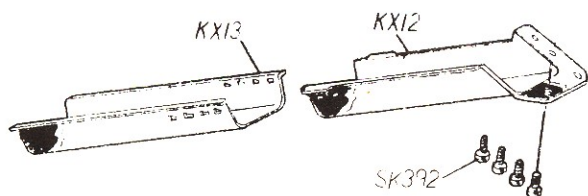
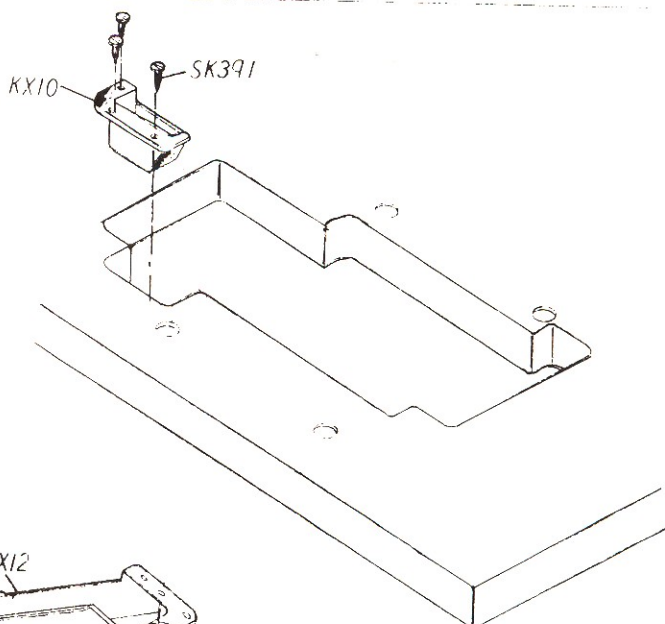
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PARTS LIST FOR MN GROUP

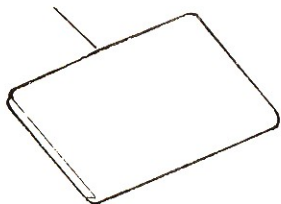


(For F007 FR ONLY)

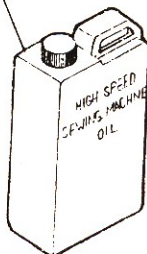


PARTS LIST FOR MY GROUP

MY01



MY02



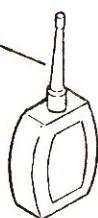
KY03



KY04



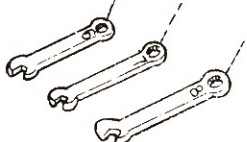
KY05



KY07

KY08

KY09



MY08 (2mm)

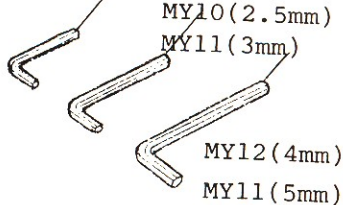
MY09 (1.5mm)

MY10 (2.5mm)

MY11 (3mm)

MY12 (4mm)

MY11 (5mm)



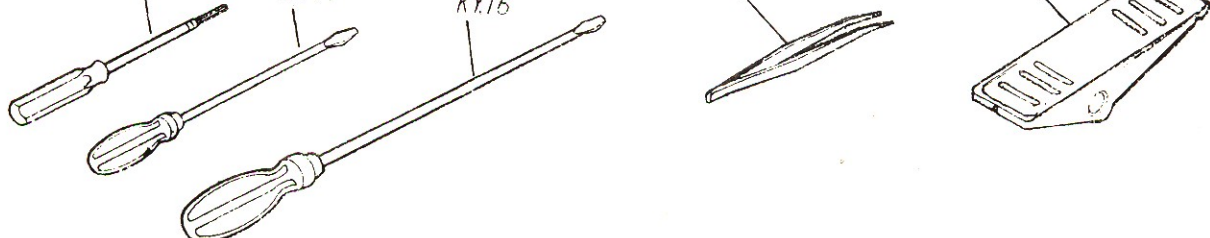
MY14

KY17

KY16

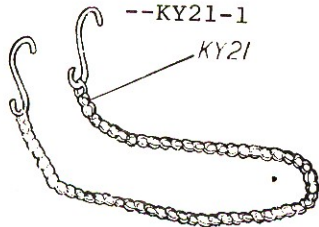
KY18

KY20D



--KY21-1

KY21



KT14



UY128GAS

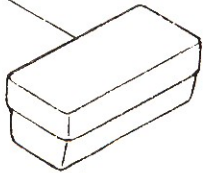


KR35

(FOR FR ONLY)



KY26



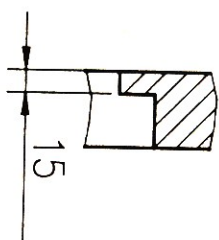
SPARE PARTS CONVERSION CHART

MODEL	GAUGE	NEEDLE HOLDER	NEEDLE PLATE	MAIN FEED DOG	DIFF. FEED DOG	PRESSER FOOT	SPREADER	NEEDLE UY128GAS
F007-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
F007-U122	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
F007-U122 /FP	232	M4232	E1623	D1206	H1257	P4011	----	#14
F007-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
F007-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
F007-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
F007-W223	240 356 364	M4240 M4356 M4364	E3034 E3336 E3337	D1215 D1216 D1216	H1261 H1262 H1262	P1814 P2116 P2117	MH41	#10 #11 #11
F007-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
F007-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
F007-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
F007-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
F007-U612 /FBQ	256	M4356	E1826 E4001	D5001	H5001	P4000 P4002	----	#14 (#16)
	264	M4364	E1827 E4001	D5001	H5001	P4001 P4002	----	#14 (#16)
F007-U612 /FBP	256	M4356	E1826	D1207	H1259	P4000	----	#14
	264	M4364	E1827	D1207	H1259	P4001	----	#16

圖板式乘車平針三

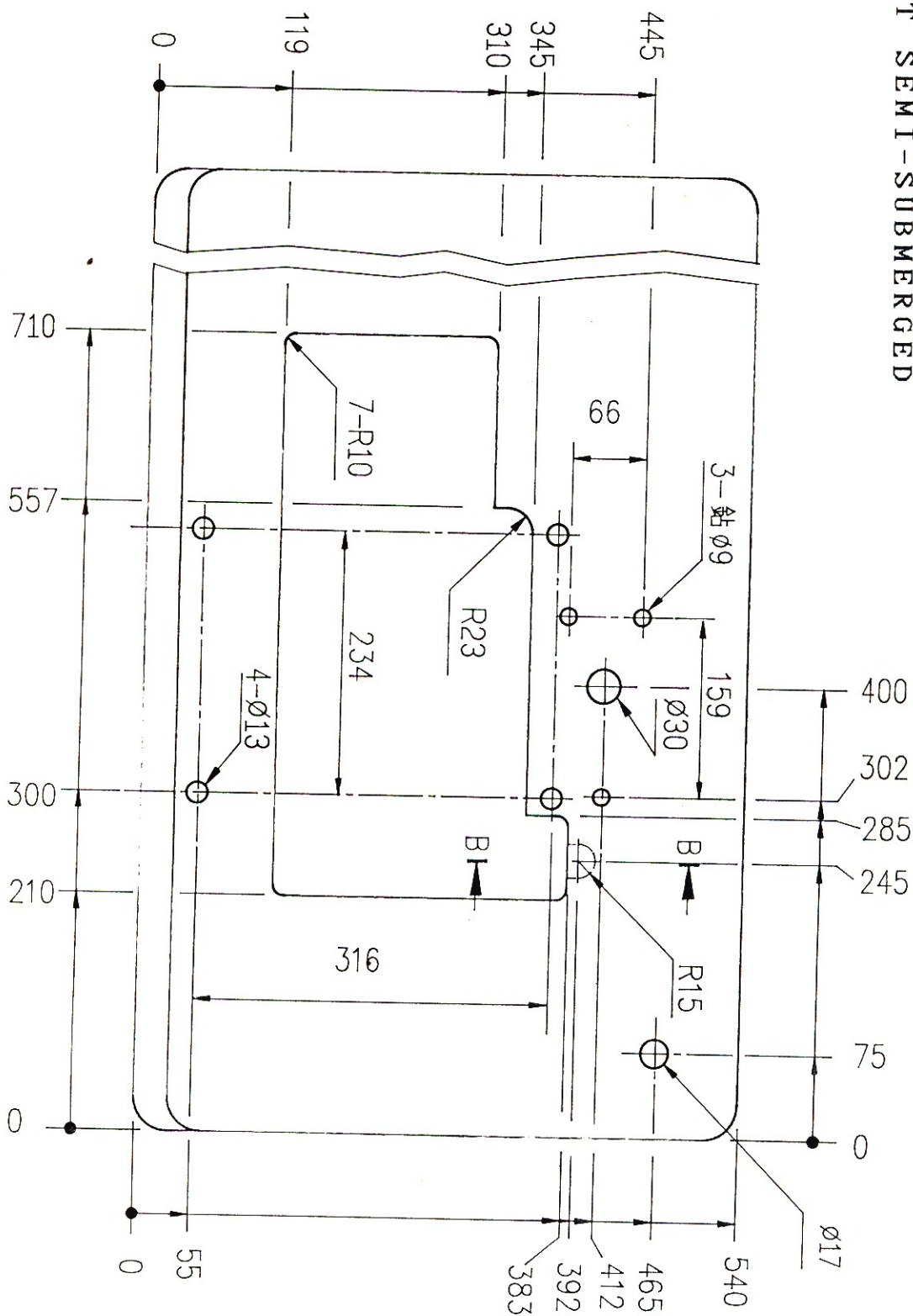
TABLE CUT-OUT SEMI-SUBMERGED

單位: MM
UNIT: MM



B-B 剖面

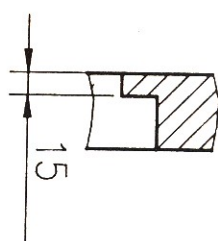
所有尺寸公差±2



三針平車下乘式桌板圖

單位：MM

UNIT: MM



B-B剖面

B-B SECTION

所有尺寸公差 ± 2

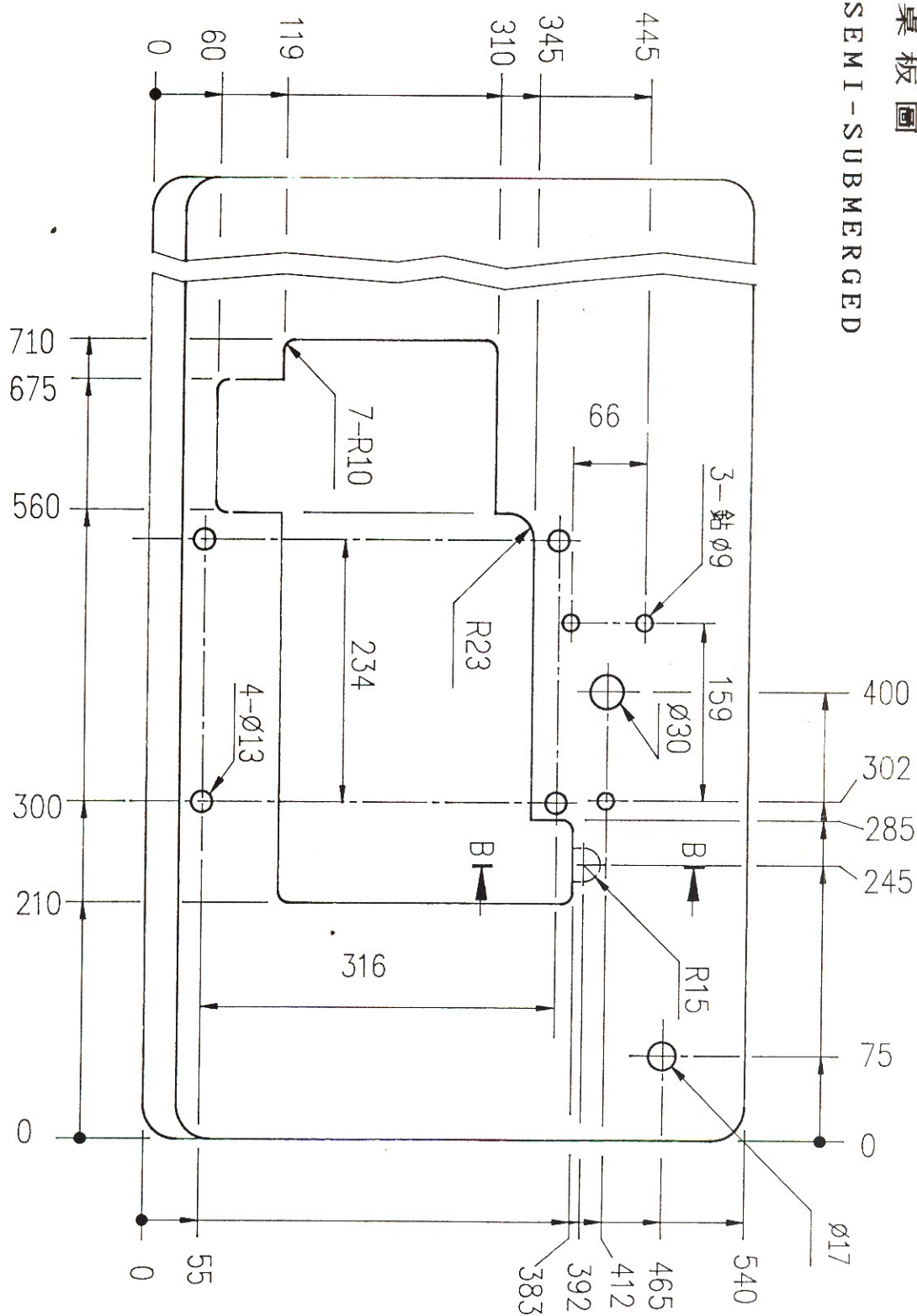
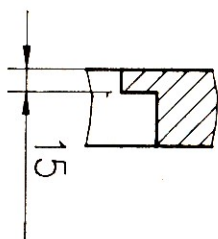


TABLE NO. F007-2
三針平車下乘式桌板圖

TABLE CUT-OUT SEMI-SUBMERGED

單位: MM

UNIT: MM



B-B 剖面
B-B SECTION

所有尺寸公差±2

