



MAUSER
S P E Z I A L

MH-1341

Single Needle
Top And Bottom Feed
Lockstitch Sewing Machine

Operating Manual

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Thank you very much for buying our sewing machine. Before using your new machine, please read the safety instructions below and the explanations given in the Operation Instruction.

With industrial sewing machines, it is normal to carry out work while positioned directly in front of moving parts such as the needle and thread take-up lever, and consequently there is always a danger of injury that can be caused by these parts. Follow the instructions from training personnel and instructors regarding safe and correct operation before operating the machine so that you will know how to use it correctly.

This sample book is made in June 2019 and is subject to change without notice.

SAFETY INSTRUCTIONS

1. Safety indications and their meanings

This instruction manual and the indications and symbols that are used on the machine itself are provided in order to ensure safe operation of this machine and to prevent accidents and injury to yourself or other people.

The meaning of these indications and symbols are given below.

Indications

	DANGER	The instructions which follow this term indicate situations where failure to follow the instructions will almost certainly result in death or severe injury.
	CAUTION	The instructions which follow this term indicate situations where failure to follow the instructions could cause injury when using the machine or physical damage to equipment and surroundings.

Symbols



----- This symbol () indicates something that you should be careful of. The picture inside the triangle indicates the nature of the caution that must be taken.
(For example, the symbol at left means "beware of injury".)



----- This symbol () indicates something that you must not do.



----- This symbol () indicates something that you must do. The picture inside the circle indicates the nature of the thing that must be done.
(For example, the symbol at left means "you must make the ground connection".)



⚠ DANGER



Wait at least 5 minutes after turning off the power switch and disconnecting the power cord from the wall outlet before opening the face plate of the control box. Touching areas where high voltages are present can result in severe injury.

⚠ CAUTION

Environmental requirements

- | | |
|--|---|
| <p>⚠ Use the sewing machine in an area which is free from sources of strong electrical noise such as high-frequency welders. Sources of strong electrical noise may cause problems with correct operation.</p> <p>⚠ Any fluctuations in the power supply voltages should be within $\pm 10\%$ of the rated voltage for the machine. Voltage fluctuations which are greater than this may cause problems with correct operation.</p> <p>⚠ The power supply capacity should be greater than the requirements for the sewing machine's electrical consumption. Insufficient power supply capacity may cause problems with correct operation.</p> | <p>⚠ The ambient temperature should be within the range of 5°C to 35°C during use. Temperatures which are lower or higher than this may cause problems with correct operation.</p> <p>⚠ The relative humidity should be within the range of 45% to 85% during use, and no dew formation should occur in any devices. Excessively dry or humid environments and dew formation may cause problems with correct operation.</p> <p>⚠ Avoid exposure to direct sunlight during use. Exposure to direct sunlight may cause problems with correct operation.</p> <p>⚠ In the event of an electrical storm, turn off the power and disconnect the power cord from the wall outlet. Lightning may cause problems with correct operation.</p> |
|--|---|

Installation

- | | |
|---|---|
| <p>⊘ Machine installation should only be carried out by a qualified technician.</p> <p>⚠ Contact your dealer or a qualified electrician for any electrical work that may need to be done.</p> <p>⚠ The sewing machine weighs approximately 40kg. The installation should be carried out by two or more people.</p> <p>⊘ Don't connect the power cord until installation is complete, otherwise the machine may operate if the foot switch is depressed by mistake, which could result in injury.</p> <p>⚠ Be sure to connect the ground. If the ground connection is not secure, you run a high risk of receiving a serious electric shock, and problems with correct operation may also occur.</p> <p>⚡ Install the safety covers to the machine head and motor.</p> | <p>⚠ Hold the machine head with both hands when tilting it back or returning it to its original position. Furthermore, after tilting back the machine head, do not push the face plate side or the pulley side from above, as this could cause the machine head to topple over, which may result in personal injury or damage to the machine.</p> <p>⚠ All cords should be secured at least 25mm away from any moving parts. Furthermore, do not excessively bend the cords or secure them too firmly with staples, otherwise there is the danger that fire or electric shocks could occur.</p> <p>⚠ If using a work table which has casters, the casters should be secured in such a way so that they cannot move.</p> <p>⊘ Be sure to wear protective goggles and gloves when handling the lubricating oil and grease, so that they don't get into your eyes or onto your skin, otherwise inflammation can result. Furthermore, do not drink the oil or eat the grease under any circumstances, as they can cause vomiting and diarrhoea. Keep the oil out of the reach children.</p> |
|---|---|



⚠ CAUTION

Sewing

- | | |
|---|---|
| <p> This sewing machine should only be used by operators who have received the necessary training in safe use beforehand.</p> <p> The sewing machine should not be used for any applications other than sewing.</p> <p> Be sure to wear protective goggles when using the machine.
If goggles are not worn, there is the danger that if a needle breaks, parts of the broken needle may enter your eyes and injury may result.</p> <p> Turn off the power switch at the following times, otherwise the machine may operate if the foot switch is depressed by mistake, which could result in injury.</p> <ul style="list-style-type: none"> ·When threading the needle ·When replacing the needle and bobbin ·When not using the machine and when leaving the machine unattended | <p> If using a work table which has casters, the casters should be secured in such a way so that they cannot move.</p> <p> Attach all safety devices before using the sewing machine. If the machine is used without these devices attached, injury may result.</p> <p> Do not touch any of the moving parts or press any objects against the machine while sewing as this may result in personal injury or damage to the machine.</p> <p> If an error occurs in machine operation, or if abnormal noises or smells are noticed, immediately turn off the power switch. Then contact your nearest dealer or a qualified technician.</p> <p> If the machine develops a problem, contact your nearest dealer or a qualified technician.</p> |
|---|---|

Cleaning

- | | |
|--|---|
| <p> Turn off the power switch before carrying out cleaning, otherwise the machine may operate if the foot switch is depressed by mistake, which could result in injury.</p> | <p> Be sure to wear protective goggles and gloves when handling the lubricating oil and grease, so that they do not get into your eyes or onto your skin, otherwise inflammation can result. Furthermore, do not drink the oil or eat the grease under any circumstances, as they can cause vomiting and diarrhoea. Keep the oil out of the reach of children.</p> |
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1. 机器简介 Profile of the machine

本系列平缝机单直针，采用连杆式送料，挑线杆挑线，旋梭勾线，形成301线迹。机头加长设计，令操作回转空间更宽敞。超长针杆行程，大互动量交替压脚，使缝厚能力更显出色。

本机采用油泵自动润滑，运转轻滑、噪音低、振动小，特别适合手箱包、汽车座垫、帐篷、沙发等皮革、帆布、厚重装饰布、织带类物品的缝制。

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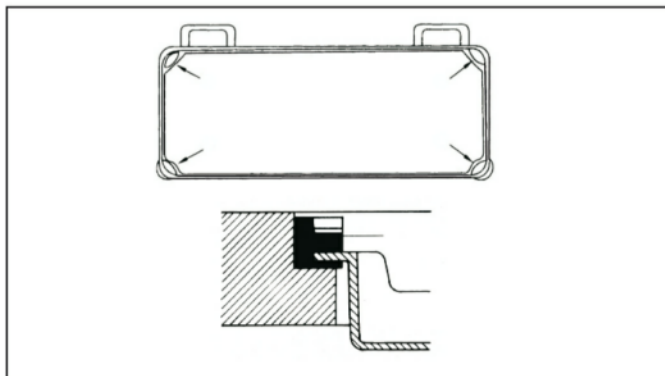
Thick material up and down feeding a single straight needle sewing machine system, using the link type feed, thread take-up pick-line, Rotating hook line, form 301 stitch. Extended nose design, make operation more spacious space rotation. Long needle bar stroke, a large amount of interaction alternating presser foot, so that Seam thickness capacity is even more remarkable.

This machine adopts oil pump auto lubrication, smooth running light, low noise, vibration, especially for hand luggage, car seat, tents, sofas and other leather, Canvas, heavy fabrics, sewing items like ribbon.

2. 规格 Specifications

型号 Type	外挂机型 Plug in type	单定针机型 Single needle type	三自动机型 Tri-automaton
用途 Tailor	中厚料~厚料 Thick		
最高转速 Sewing speed	2200rpm		
最大针距 Stitch length	9mm		
针杆行程 Needle	38mm		
挑线杆行程 Thread take-up	73mm		
压脚交互量 Presser foot interactive quantity	2.0-5.5mm		
外压脚操作系统 The presser foot operating system	标盘 Standard plate		
机针 Needle	DPx17 22#/23#		
旋梭 Hook	全自动润滑大旋梭 Auto-lubrication with big hook		全自动润滑大旋梭(剪线) Auto-lubrication with big hook(auto-trimmer)
润滑系统 Lubrication system	自动供油 Auto-lubrication		
绕线方式 Type of winding	内置绕线器 Built-in winding device		
剪线装置 Trimming device	无 ×		有 o
倒缝装置 Reverse stitching device	无 ×		有 o
自动抬压脚装置 Footlifter	无 ×		选配 Optional
电子夹线器装置 Electrical tread nippe	无 ×	无 ×	有 o
压脚提升高度 Press foot hoisting height control	手提 Hand control	7mm	
	膝提 Knee	16mm	
配套电机功率 (W)		550W	750W

3. 机头的安装 Install the machine



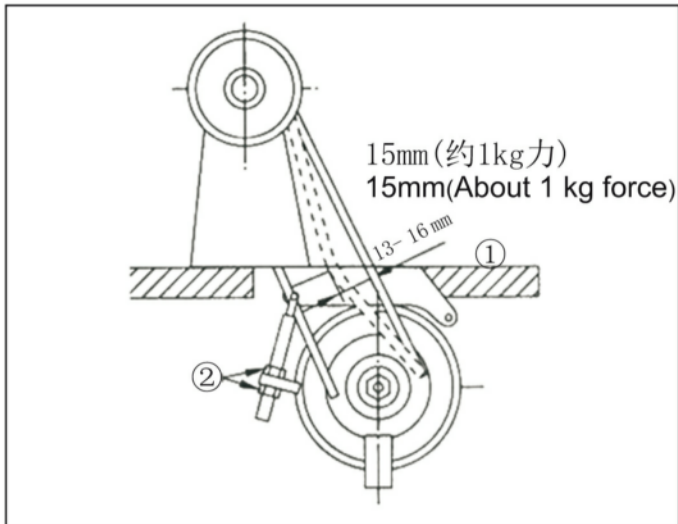
- 1) 将机头支座固定在工作台凹槽四角。
- 2) 将油盘四角搁在机头支架的中间。
- 3) 将机头连接钩放入底板孔内，与台板的机头铰链相嵌合，再将机头放到四只角的机头支座上。

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- 1.Put the rubber cushion on the four corner of the tale socket
- 2.Hold the oil reservoir in the middle of the rubber cushion.
- 3.Put the head connecting hook socket into table, then connect the head connecting hook socket and the head connecting hook which should be on the head, and the machine head will be put on the oil reservoir.



4. 皮带的安装 Installation

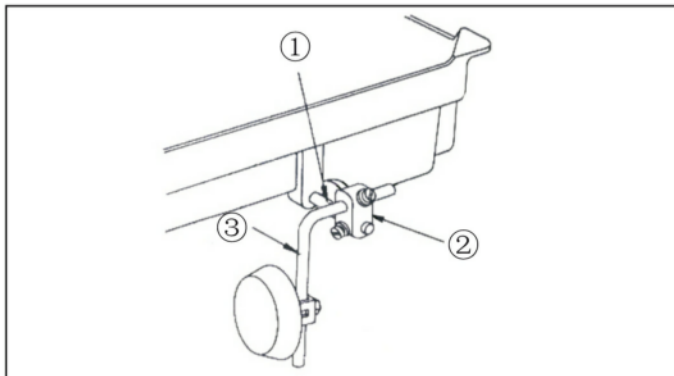


1. 放倒机头, 在电机下皮带轮上安装三角皮带①。
2. 用手指以1kg力压三角皮带①, 调整螺母②, 使皮带弯曲程度为13-16mm。

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1. Tilt back the machine head, and then place the belt ① onto the motor pulley and the machine pulley.
2. Turn the nut ② to adjust so that there is 13-16mm of deflection in the belt ① when it is pressed with a finger.

5. 膝控装置安装 Install the knee-control device

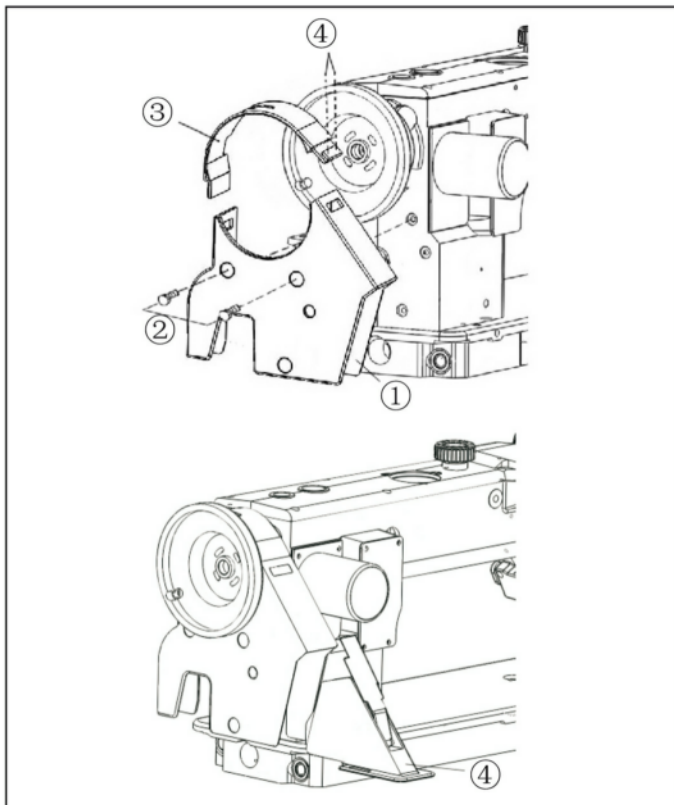


1. 尽量拉出膝控铰链轴①, 进行适当安装。
2. 在轴上装上膝控碰块接头②。
3. 在膝控碰块接头上装膝控碰块弯轴组件③。

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1. Pull the device ① and adjust it.
2. Install the joint ②.
3. Install device ③.

6. 皮带罩的安装 Install the belt cover



1. 利用三个固定螺丝, 把皮带护罩①固定在缝纫机机体上。

此时, 若把缝纫机稍微往后倾斜, 就会易于组装皮带护罩①。

组装完皮带护罩①后, 把皮带护罩③的前部插在皮带护罩①的小孔里, 利用固定螺丝④把其后部固定好。

2. 把皮带护罩④伏贴在工作台上。

此时, 请注意, 不让皮带在皮带护罩④内部干涉。

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1. Fix the belt cover ① to the machine's body using 3 fixing screws ②.

You can assemble it more easily if you slightly incline the machine.

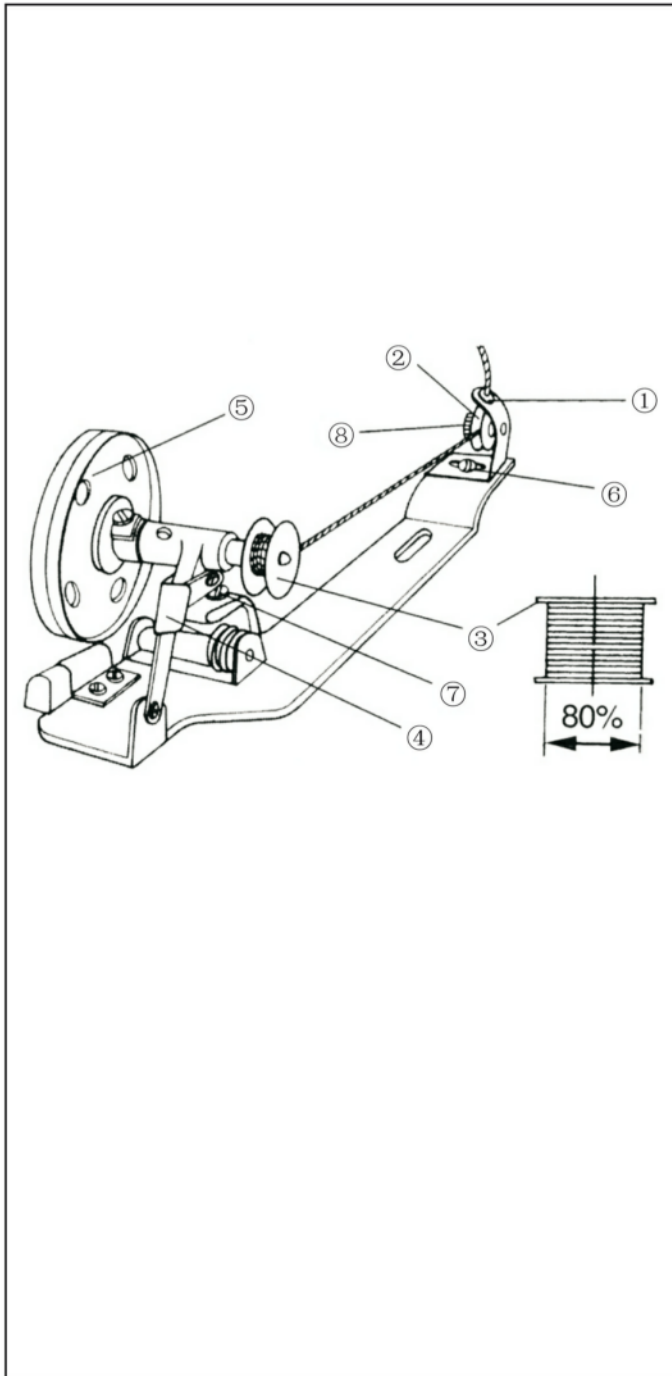
When the assembly of the belt cover is finished, insert the front side of the belt cover ③ into the groove of belt cover ① and fix the back side with the fixing screw ④.

2. Attach the belt cover ④ to the table.

Please make sure that the belt do not intervene with the inside of the belt cover ④.



7. 绕底线及调整 Winding and adjusting lower thread



A. 绕底线

- (1) 把线从孔①中穿出，从夹线器②的后面绕到前面。
- (2) 把线拉到梭芯③，从底顺时针绕5-6圈。
- (3) 推杠杆④，让滑轮⑤触到V皮带后，启动机械。
- (4) 梭芯绕完底线后，滑轮⑤自动从V-皮带移开。
- (5) 梭芯绕底线量以80%左右为宜。

B. 绕底线调整

- (1) 底线绕得不均匀时，松开螺丝⑥后左右移动进行调整，然后重新拧紧螺丝⑥。
- (2) 顺时针转动调整螺丝⑦时，底线绕线量会增加，相反则减少。
- (3) 顺时针转动螺母⑧时，梭芯绕的底线张力会增加，相反则减小。

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A. Winding lower thread

- (1) Pass the thread thru the hole ① from the rear to the frontal side of the tension adjusting dish ②
- (2) Bring the thread to the bobbin ③ and wind it clockwise 5 to 6 times from the bottom.
- (3) Push the lever ④ so that the pulley ⑤ touches the V-belt and run the machine.
- (4) The pulley ⑤ automatically is separated from the V-belt when the lower thread is wound in the bobbin.
- (5) The adequate amount of the pulled-out lower thread is about 80%.

B. Adjustment of winding lower thread

- (1) In case that the lower thread is wound irregular, loosen the bolt ⑥ and adjust by moving it sideways, and tight it again.
- (2) The amount of wound lower thread becomes larger when you turn adjusting screw ⑦ clockwise, and it becomes smaller in case of turning it counterclockwise.
- (3) The tension of lower thread that wound in the bobbin can be adjusted by turning the nut ⑧: it increases with clockwise turning and it decreases when you turn counterclockwise.

8. 润滑 Lubricating


注意
CAUTION

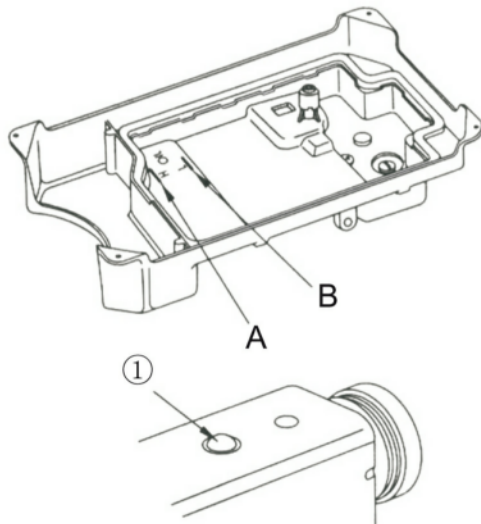
加油结束之前，不能接触电源开关，否则误踩踏板启动，可能会受伤事故
加润滑油时，请使用保护身体的眼镜。手套防止与眼或皮肤接触，同时应放在小孩碰不到的地方。

首次使用机械时，或长时间不使用时，必须加油。

Plug in only after oil supply is finished. If the operator mistakenly steps on the pedal with the plug in, the machine will start automatically and can cause severe injuries.

When handling lubricants, wear protective glasses or gloves to avoid contact with your eyes or skin. Inflammation may be caused otherwise. Never drink lubricants since they can cause vomiting or diarrhea. Keep out of the reach of children.

Operate the machine only after adding oil when the machine is being used for the first time or has been left unused for a long time.



将油注入油盘A位置。

在操作过程中，需经常检查油位高度，如油位低于B位置时须加油至A位置。

注意：操作机器时，可以通过油窗①检查油润滑情况。

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Fill oil pan with new special oil up to A .

In the operating process, need to check the level of the oil level. After filling the oil pan, the oil surface should lie A lines.

Note: Operating machine, Can through the oil window ① check the oil lubrication condition.


注意
CAUTION

在以下机器的调整时，请关闭电源开关。误踩踏板机械启动时，可能会发生身体损伤事故。

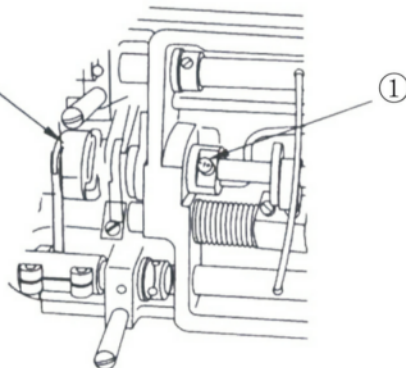
使用离合式马达时，关闭电源后，由于惯性，马达会暂时旋转。马达完全停止后，进行操作。

Always turn off the power when mounting a needle. If the operator mistakenly steps on the pedal while the power is on, the machine will start automatically and can result in physical injuries.

When using clutch motor, be aware that the motor will continue to rotate for a while even after the power is switched off due to inertia. Start to work on the sewing machine only after the motor has come to a complete stop.

9. 旋梭润滑的调整 Rotary hook lubrication adjustment

旋梭
hook



减少 lower
增加 Increase

顺时针 (+) 转动油量调整螺丝①，出油量会增加，相反逆时针 (-) 转动油量调整螺丝①时，出油量会减少。

注：调整该螺钉后，机器应至少运转30秒钟，然后检查旋梭出油量。

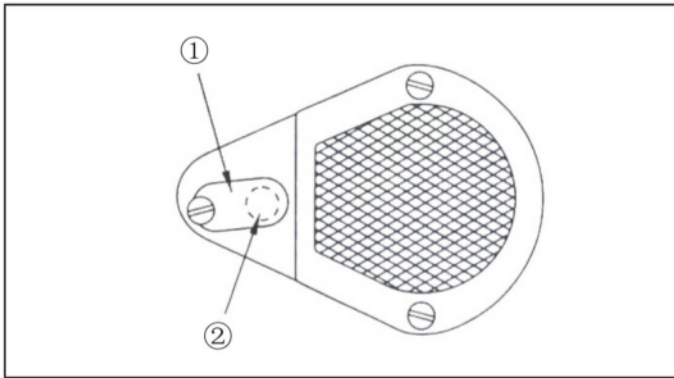
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When you turn clockwise (+) the lubrication adjustment screw ① inserted in the front bushing of the lower shaft, the amount of oil will increase while turning to counterclockwise (-) will decrease the amount.

Note: Adjust the screws, the machine should be running at least 30 seconds, then check whether the oil into the hook.



10. 油泵的调整 Pump adjustment



调整方法如下:

油量调节板①应充分盖住通油孔②, 如果减少供油量, 就将通油孔②适当的打开.

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Adjustment:

Oil leakage adjust device ① should cover the oil hole ②, if reduce the oil supplying, open oil hole ② properly.

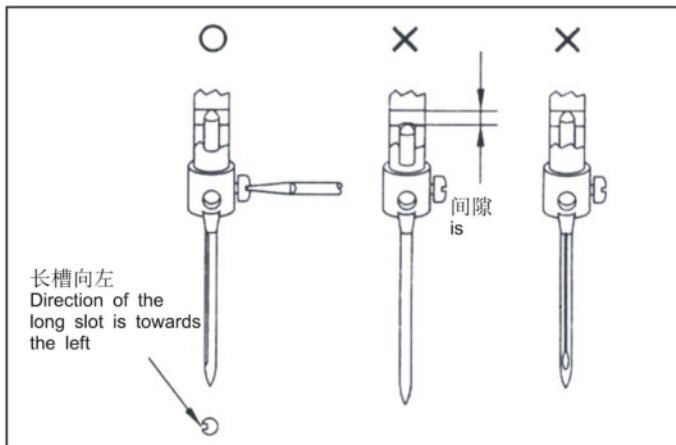
11. 安装机针 Replace needles



注意
CAUTION

为了防止缝纫机的意外启动, 请关掉电源之后进行操作

Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



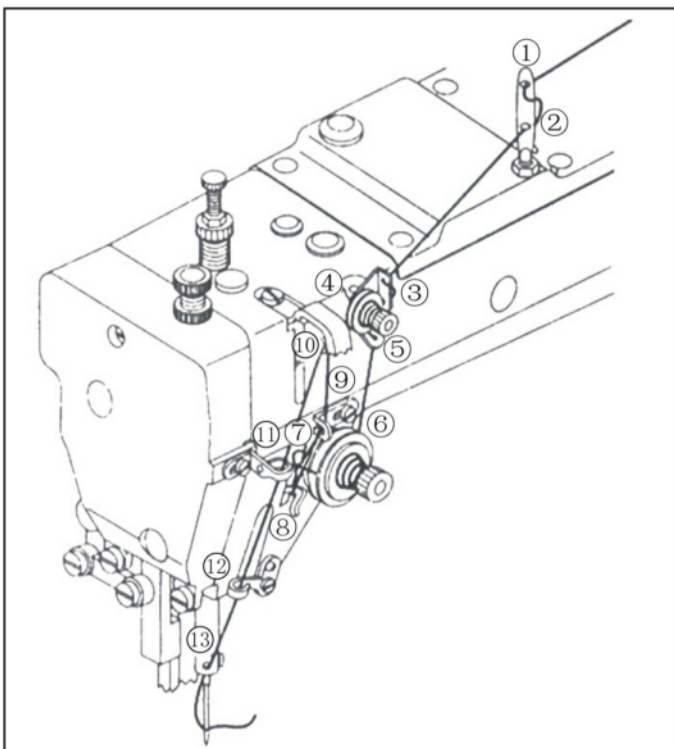
插入机针至底部, 拧紧螺钉, 保持长槽方向向左.

注意: 用涤纶线倒缝时若发生断线, 前机针的长槽向前侧转, 有可能会避免该情况发生. 一般避免将长槽朝向后侧.

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Needle should reach the bottom of needle bar, and then tighten the screw. Direction of the long slot is towards the left.

12. 穿面线 Routing upper thread



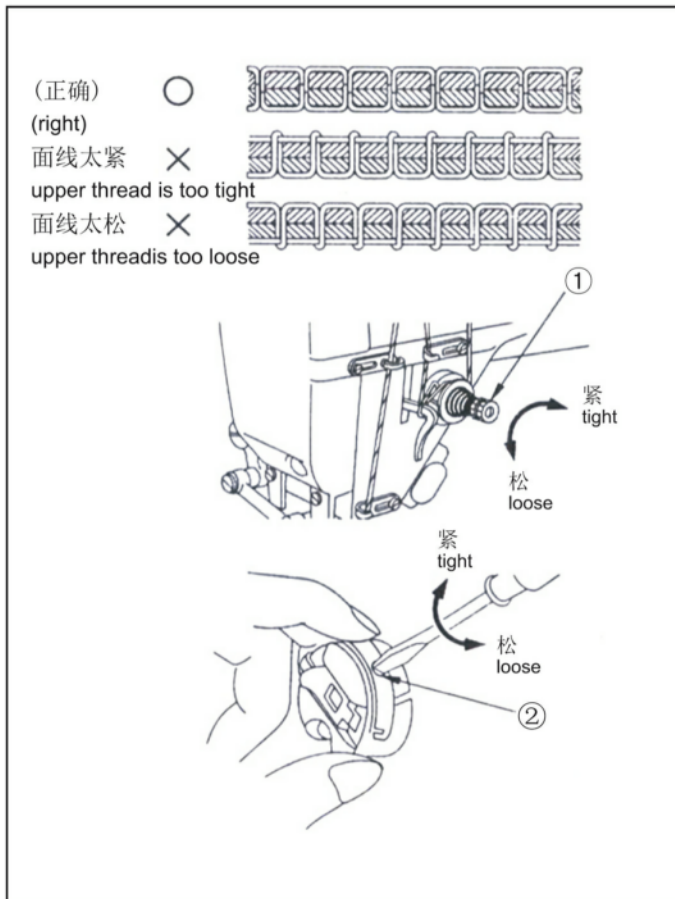
将挑线杆转到最高位置, 然后如图所示穿线.

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Into the thread take-up position, then as shown threading.



13. 线张力调整 Adjusting the thread tension



1. 线调整装置

如图所示，顺时针转动压线螺母①，面线张力会变强，相反则会变弱。根据布料、缝线、线距等缝纫条件，线的张力会有所不同，因此需要按照不同情况，进行调整。

2. 底线张力调整

如图所示，在线调整螺钉②上利用起子，顺时针转动，底线张力会变强，相反则会变弱。

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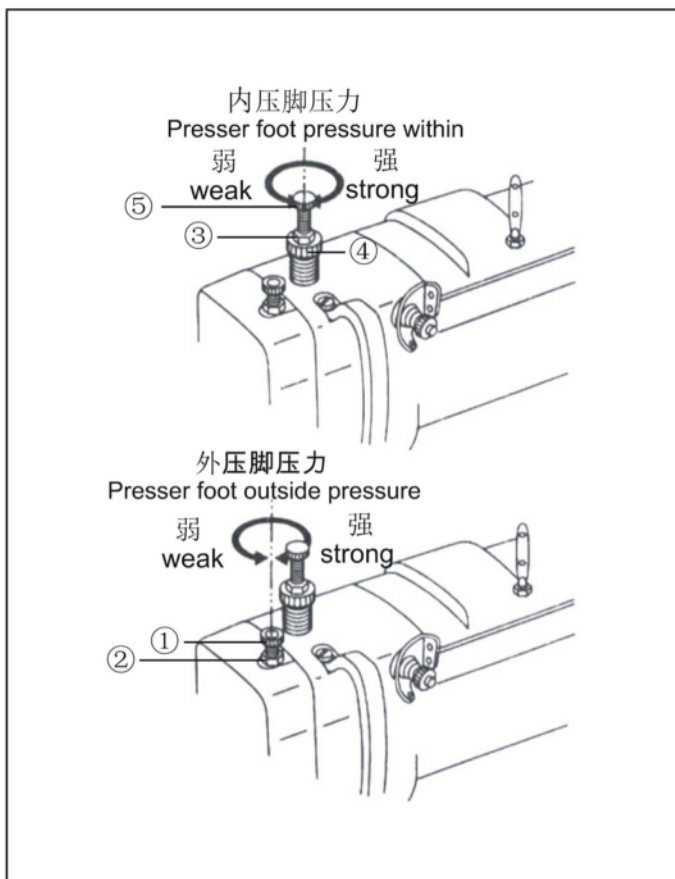
1. Thread control assembly

Like in Figure, turning the tension adjustment nut ① of the thread tension control assembly clockwise makes the upper thread tension stronger and counterclockwise makes it weaker. The result of the needlework depends on the sewing conditions such as the sewing material, used thread and stitch length. So please adjust as desired.

B. Adjusting the thread take up tension

As in Figure 27, insert the driver into the groove ② of the thread tension control assembly. Turn clockwise to make the spring tension stronger and counter clockwise to make it weaker.

14. 压脚压力的调整 Presser foot pressure



要调整内压力时，顺时针转动压力调整螺丝①，压力会变强，相反则会变弱。调整后，必须完全拧紧固定螺丝②。

外压脚也同样，顺时针转动压力调整螺丝③，压力会变强，相反则会变弱。调整后，必须完全拧紧固定螺丝④。此外，左右转动辅助压力调节螺丝，进行微细调节。

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The pressure of the upper feed presser foot becomes stronger when you turn the pressure adjustment screw ① clockwise, and becomes weaker in case of turning it counterclockwise.

After the adjustment, be sure to tight the fixing nut ②.

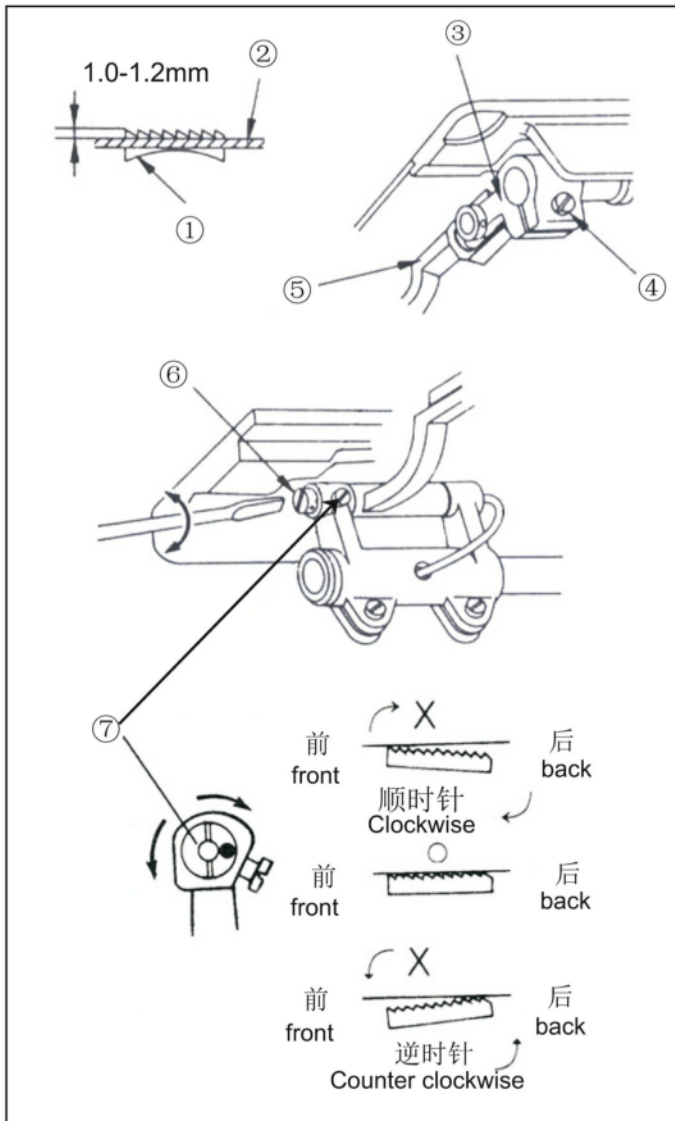
The auxiliary presser foot is same to the upper feed presser foot: the pressure increases when you turn the pressure adjustment screw ③ clockwise, and becomes weaker in case of turning it counter clockwise.

After the adjustment, be sure to tight the fixing nut ④.

In case of fine adjustment, use the auxiliary pressure adjustment screw ⑤.



15. 调整送布牙 Adjusting the feed dog



1. 送布牙高度

(1) 送布牙①应高于针板②平面1.0-1.2mm为宜。

1) 放松抬牙曲柄(前)③上的螺钉④, 然后将牙架⑤上下移动。

2) 调整结束后, 旋紧螺钉④。

2. 调整送布牙倾角

(1) 旋松螺钉⑦。

(2) 用螺钉刀左右旋转牙架曲柄偏心轴⑥进行整。若顺时针转动, 牙架曲柄偏心轴⑥、牙齿前高后低, 若按相反方向逆时针转动牙架曲柄偏心轴⑥、牙齿前低后高。

(3) 调整结束, 旋紧螺钉⑦。

EN

1. Feed dog height.

(1) feed dog ① should higher than ② 1.0mm.

(2) adjust the feed dog height.

1) loose the screw ④ in crank ③ and lower down ⑤ .

2) after adjust, tight the screw ④.

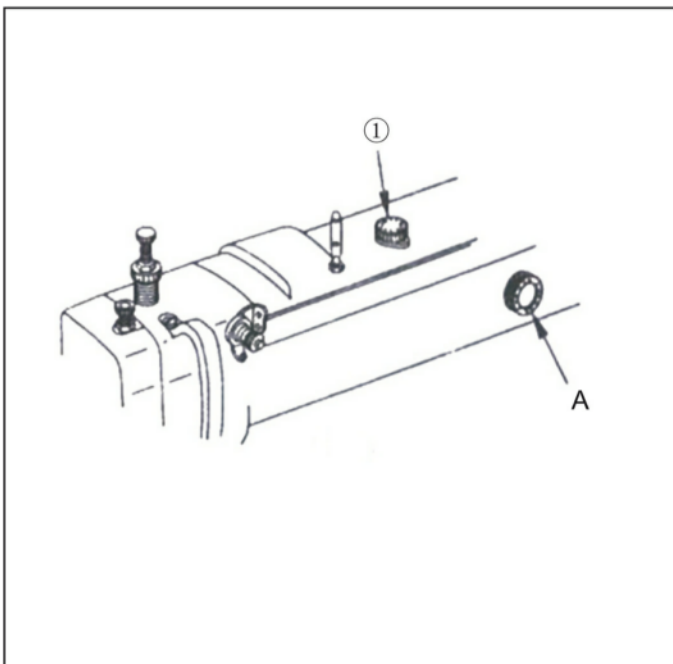
2. Adjust the feed dog angle.

(1) loose screw ⑦.

(2) adjust ⑥.

(3) finish and tightening ⑦.

16. 内外压脚的调整 Adjusting the auxiliary and upper feed presser foot



1. 交互运动的调整

(1) 内外压脚的交互量调整范围为2mm-5.5mm。

(2) 内外压脚的交互运动量可通过机壳上的提升压脚标盘A来调节。

(3) 上盖板的标盘①是限制提升压脚标盘A的。

注: 由小到大进行调整时, 先调整标盘①, 再调整标盘A; 相反, 由大到小进行调整时, 先调整标盘A, 再调整标盘①。

EN

1. Interactive motion adjustment

(1) The vertical running range of the auxiliary presser foot and the upper feed presser foot is from 2 to 5.5 mm.

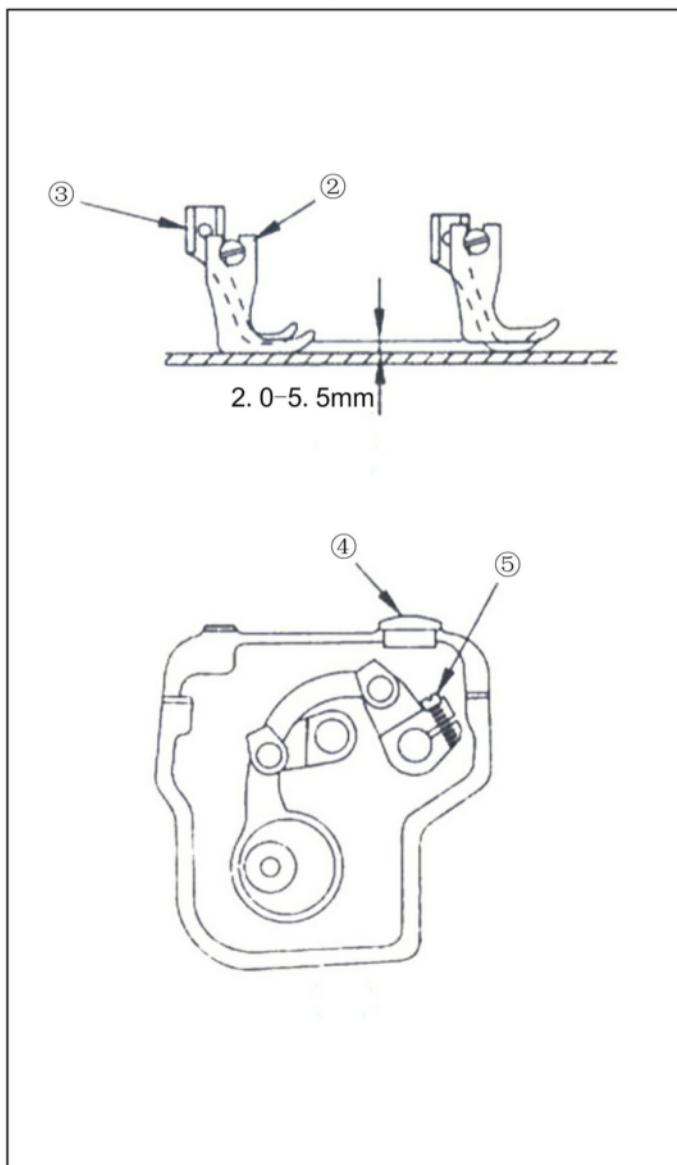
(2) The vertical running amounts of the auxiliary presser foot and the upper feed presser foot are easily adjustable from the climb device dial attached to the front side of the machine.

(3) The dial ① attached to the upper cover is a dial which controls the running amount dial A.

Caution: When you adjust the number from lower one to a higher, you should adjust the dial ① reverse case, the adjustment of the dial A should be done first.



16. 内外压脚的调整 Adjusting the auxiliary and upper feed presser foot



2. 改变内外压脚的交互运动的平衡

(1) 增加外压脚②的提升量并减少内压脚③提升量。

1) 取下上盖板上的橡皮塞④。

2) 旋转主动轮直到内压脚③从针板上抬起。

3) 旋松螺钉⑤。

4) 将内压脚向下调到接触针板，再旋紧螺钉⑤。

5) 这样，内压脚的提升量就减少一定的值，而外压脚的提升量则增加同样的数值。

(2) 与上面相反的情况，减少外压脚的提升量，增大内压脚提升量的调整如下：

1) 首先，旋转主动轮直到外压脚抬离针板。

2) 旋松螺钉⑤。

3) 调好后，旋紧螺钉⑤。这样将减少外压脚的提升量。

EN

2. To change the balance the interactive movement of inner and outer presser foot

(1) Increase the height of outer presser foot② and decrease the height of inner presser foot③.

1) Remove rubber stopper④ from the upper back cover.

2) Rotate the hand wheel until inner presser foot③ lift from the needle plate.

3) Loosen the screw⑤.

4) Lower the inner presser foot to the needle plate and tighten screw⑤.

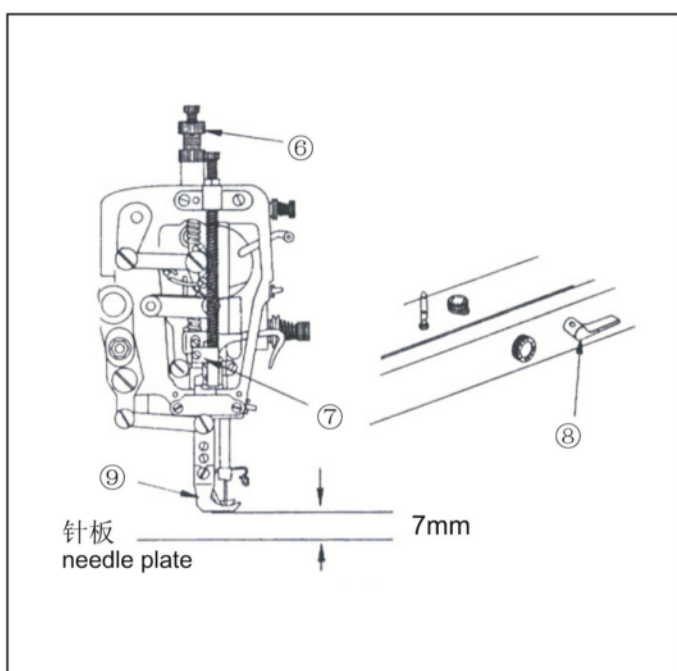
5) In this way, the height of the inner presser foot decreased by a certain value and the outer increased by the same value.

(2) Contrary to the above, to decrease the height of the outer presser foot and increase the height of the inner presser foot, the adjustment is as follows:

1) Firstly, rotate the hand wheel until the outer presser foot lifted from the needle plate.

2) Loosen screw⑤.

3) After adjustment, tighten screw⑤, thus decreasing the height of the outer presser foot.



3. 外压脚的调整方法

松开调压螺钉⑥和压杆导架螺钉⑦。

提升压脚扳手⑧时，上下调整压杆导架螺钉⑦。

让外压脚⑨提升到离针板上8毫米的位置。

调整完后，完全拧紧压杆导架螺钉⑦。适当调好调压螺钉⑥。

EN

3. Adjusting the auxiliary presser foot

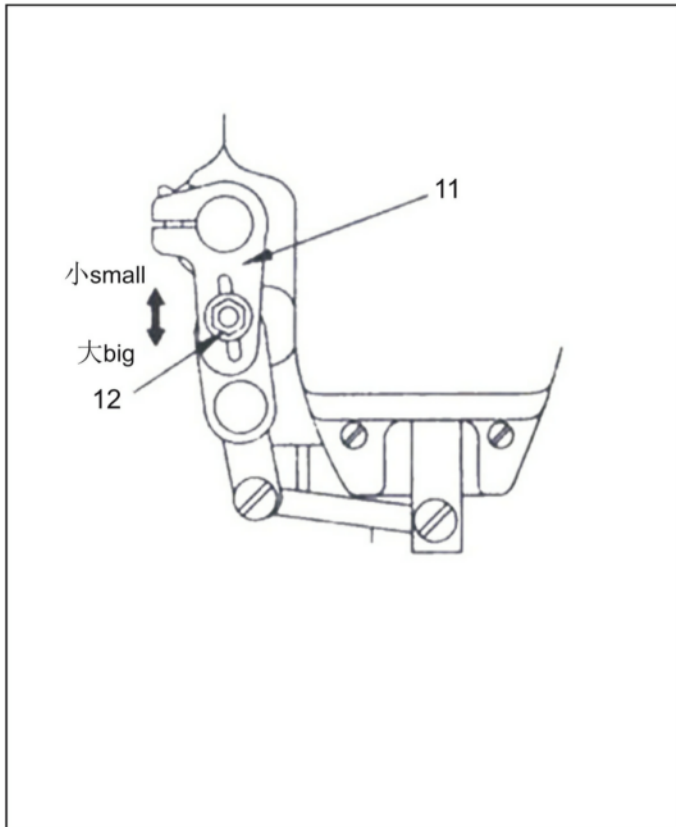
Loosen the presser bar pressure adjustment screw⑥ and the bracket fixing screw⑦.

Adjust vertically the bracket fixing screw⑦ so that the auxiliary presser foot⑨ goes up by 8mm from the upper side of the needle plate when the presser bar lifter⑧ is up.

When the adjustment is finished, fix tightly the bracket fixing screw⑦ and adjust adequately the pressure adjustment screw⑥.



16. 内外压脚的调整 Adjusting the auxiliary and upper feed presser foot



4. 外压脚运动量的调整

外压脚和送布牙运动量以1:1为标准, 根据缝制条件, 能调整外压脚的运动量。

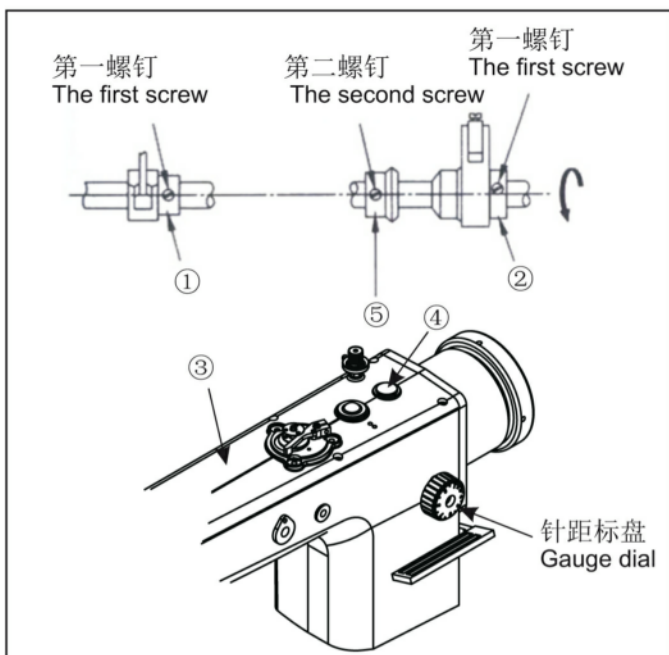
松开位于压脚摆动曲柄(左)11上的螺母12, 往上移动提升压脚变动曲柄轴, 运动量会变小, 相反就会变大。

EN

4. Adjusting feeding amount of auxiliary presser foot

The normal proportion of feeding amount between the feed dog and the auxiliary presser foot is 1:1. You can adjust the feeding amount of the auxiliary presser foot in accordance with the conditions of materials in use. loosen the nut 12 and move upward the presser foot vertical move control shaft, and the feeding amount becomes smaller. If you move it downward, the amount increases. Be sure to tight the nut 12 when the adjustment is finished.

17. 送布牙同步关系的调整 Adjusting the synchronous relationship of the feed dog



1. 转动手轮, 使针杆位于最高位置;

2. 打开上盖, 如图所示位置: 送布凸轮“左”①的第一颗螺钉和送布凸轮“右”②上的第一颗螺钉与上轴中心线位于同一平面上。

注: 送布凸轮②的位置调节, 可以取下上盖上的橡皮塞④进行调整, 但是单齿轮⑤不易看到, 调节时应小心保护。

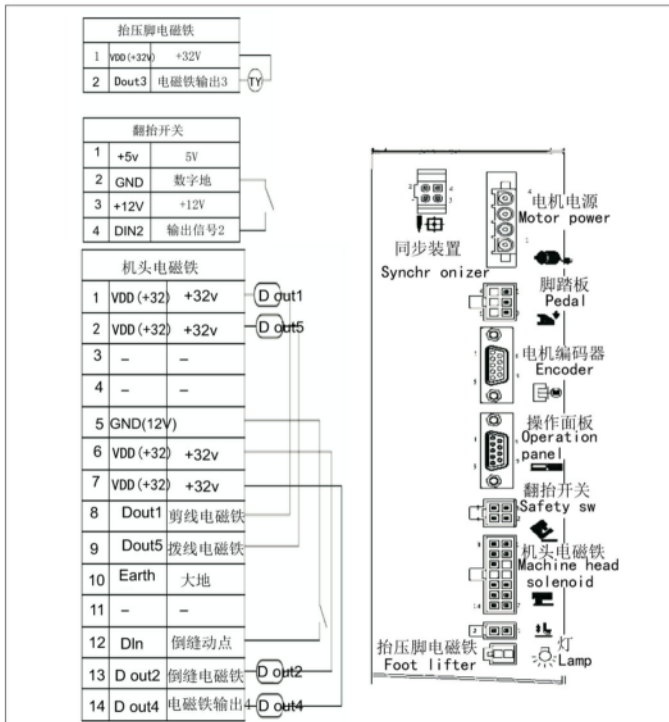
EN

1. turn the pulley with hands to fix the needle bar to the highest point.

2. The standard position will be when the center of the No. 1 fixing bolt of the presser foot vertical move cam ① is aligned with the center line of the upper shaft, the bottom of the No. 1 fixing bolt of the feed cam ② is aligned with the center line of the upper shaft.

Caution: When adjusting the feed lifting cam ②, users can remove the rubber plug ④ of the upper cover. During adjusting, users should be cautious because it is hard to have a vision of the single gear ⑤.

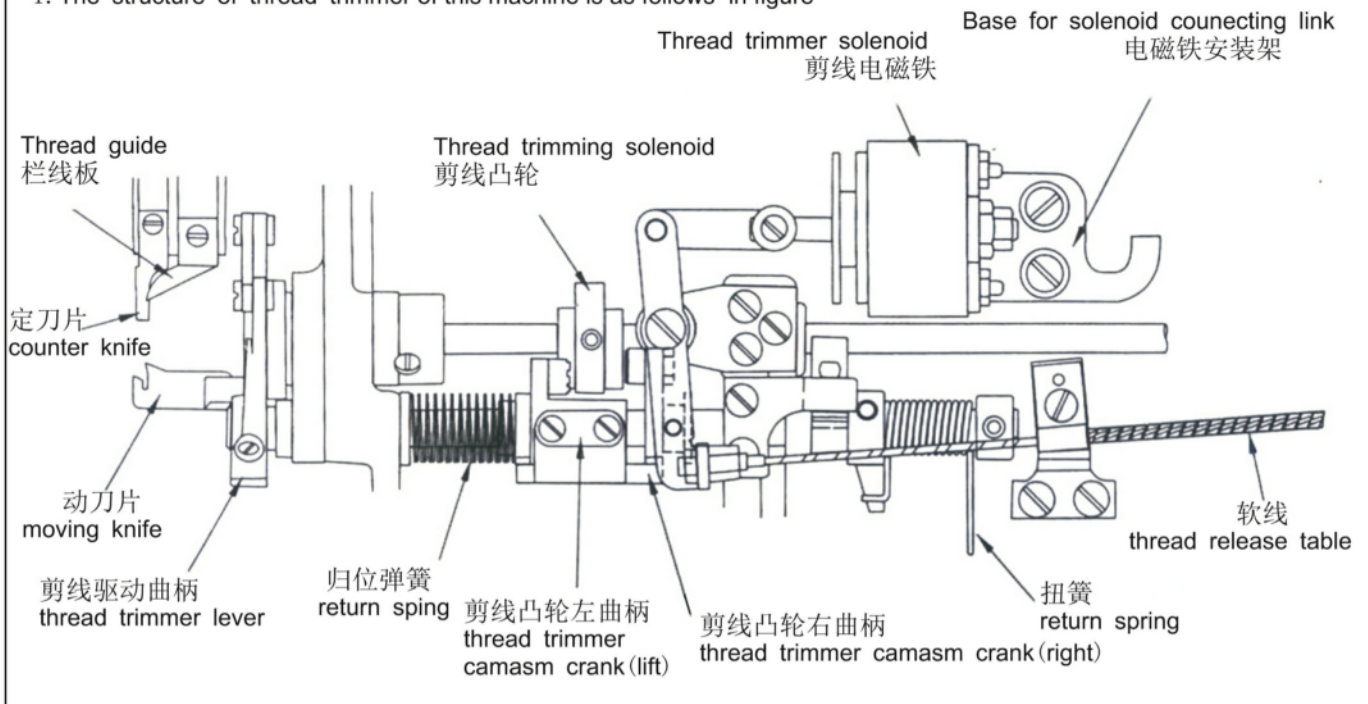
18. 接线 Connecting the wire



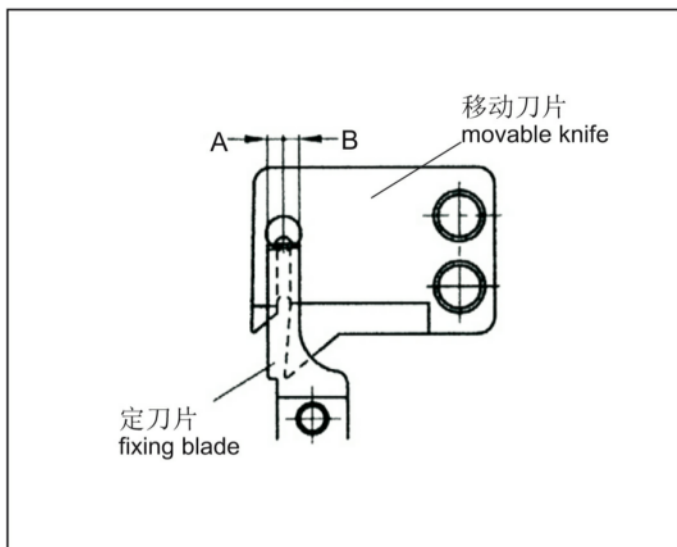
19. 剪线机构的调整 Adjusting for thread trimmer (自动剪线型)

1. 本缝纫机的切线机构如下图所示。

1. The structure of thread trimmer of this machine is as follows in figure



19. 剪线机构的调整 Adjusting for thread trimmer(自动剪线型)



2. 定刀与动刀的调整

(1) 如图所示，其标准是动刀片断面位于定刀片中央的。

(2) 若图上的A部变大，就会发生三段线。这成为切线后从针孔里脱离锋线的原因。

此外，若B部变大，就成为切线错误的原因，因此请注意。

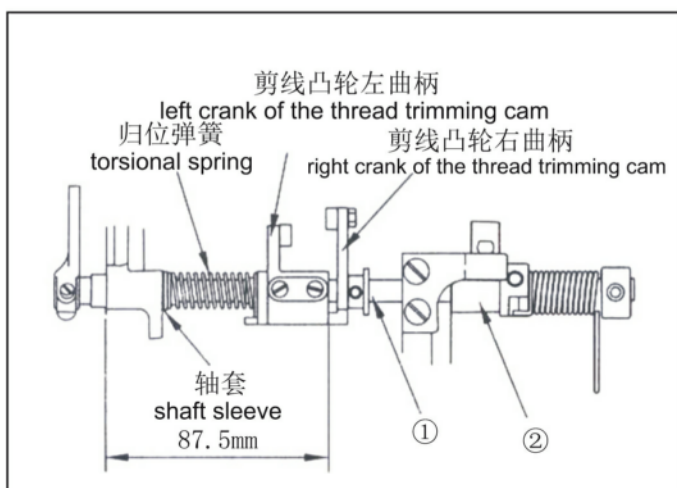
EN

2. Adjusting fixing blade and movable knife

(1) Like in Figure, the standard position is where the cut part of the movable knife is aligned with the center of the fixed blade.

(2) When part A becomes bigger in figure, three pieces of threads are to be produced, causing the thread missing after the trimming. If part B becomes bigger, it can cause a trimming miss.

So be cautious in adjusting the right position.



3. 剪线凸轮曲柄位置的调整

(1) 装配时，将剪线曲柄轴①最先装在底板上。

(2) 剪线凸轮左、右曲柄必须如图所示安装，固定在剪线轴①上的平面处。

(3) 轻轻转动剪线轴①，将限位块②安装在剪线轴①上的平面处。

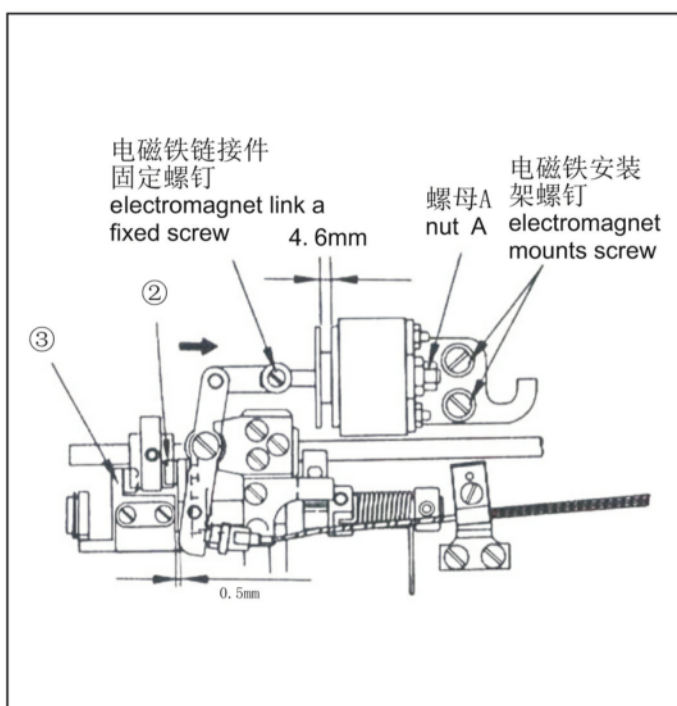
EN

3. Adjusting the crank of the thread trimming cam

(1) While assembling, users should first set the crank shaft of the thread trimming cam on the platform.

(2) The left and right crank must be set on the flat of the thread trimming shaft referring to the Figure.

(3) Gently rotate the trimming shaft①, and set the set block② on the flat of the trimming shaft①.



4. 安装剪线电磁铁

(1) 剪线电磁铁的行程：

A. 标准的行程为4.6mm.

B. 通过调节螺母A来调整行程。

(2) 剪线电磁铁的调整

A. 电磁铁的安装位置以电磁铁工作时，凸轮左曲柄③与凸轮右曲柄②之间有0.5mm间隙为标准。

B. 如需调整，可按图所示箭头方向移动电磁铁安装架。

EN

4. installation of thread trimmer

(1) working amount of the thread trimming solenoid.

A. The standard working amount of the thread trimming solenoid is 4.6mm.

B. By adjusting the nut to adjust A trip.

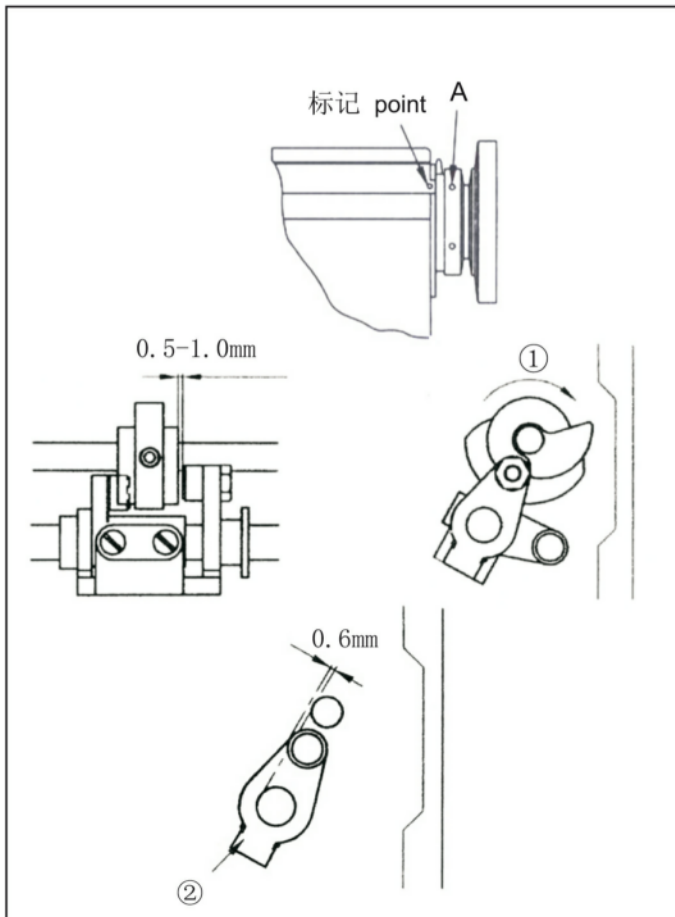
(2) adjusting the thread trimming solenoid

A. if you run the solenoid under this circumstance, a gap of 0.5mm occurs between the left crank ③ and the right crank ②. This state is the standard.

B. If you need to adjust. Can be shown as shown in figure and direction of arrow mobile electromagnet mounts.



19. 剪线机构的调整 Adjusting for thread trimmer(自动剪线型)



5. 安装剪线凸轮

- (1) 将主动轮上的第2标记点对准机壳上的定位标记点。
- (2) 在启动剪线电磁铁状态下，朝正方向回转剪线凸轮①直到接触滚柱，然后固定凸轮。
- (3) 剪线电磁铁关闭，使凸轮曲柄②恢复到原始置，这样凸轮与滚柱端面将以0.5-1.0mm间隙为标准。

EN

5 .Installation of thread trimming cam

- (1) Align the second timing carved line of the pulley with the arm's carved line.
- (2) Under the thread trimming solenoid is in operation, rotate the trimming cam ① clockwise and fix the cam when it connected with the roller.
- (3) When the thread cam following crank returned by stopping the operation of the thread trimming solenoid, the edge end between the cam and the roller should be from 0.5 to 1.0mm. It is the standard.

6. 刀片位置调整

- (1) 动刀与定刀的位置调整：

如图所示，动刀①与机针中心的距离为7.5mm，定刀②与机针中心的距离为5mm。

- (2) 动刀移动量调整：

开动电磁铁，启动机器。剪线凸轮会使动刀①向右旋转。当动刀①移动到你其最远位置时，其断面定刀②的端点进行到1.0mm-1.5mm。

- (3) 刀片压力调整：

如果剪线情况不良，尤其当线较粗时，只需增加定刀张力即可。

定刀张力可调整：松开螺母B，通过调节螺钉A来调节刀片压力。

EN

6. Adjusting the position of blade

- (1) Adjusting the position of the movable knife ① and the fixed blade ②

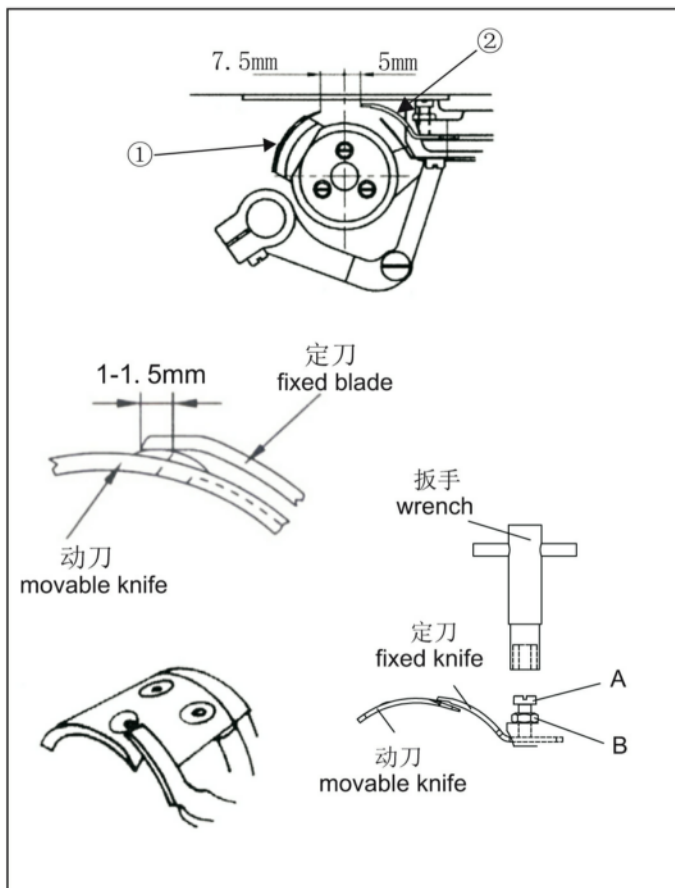
The standard position of the movable knife is 7.5mm from the needle center, and 5 mm for the fixed blade.

- (2) Adjusting the progress amount of the movable knife

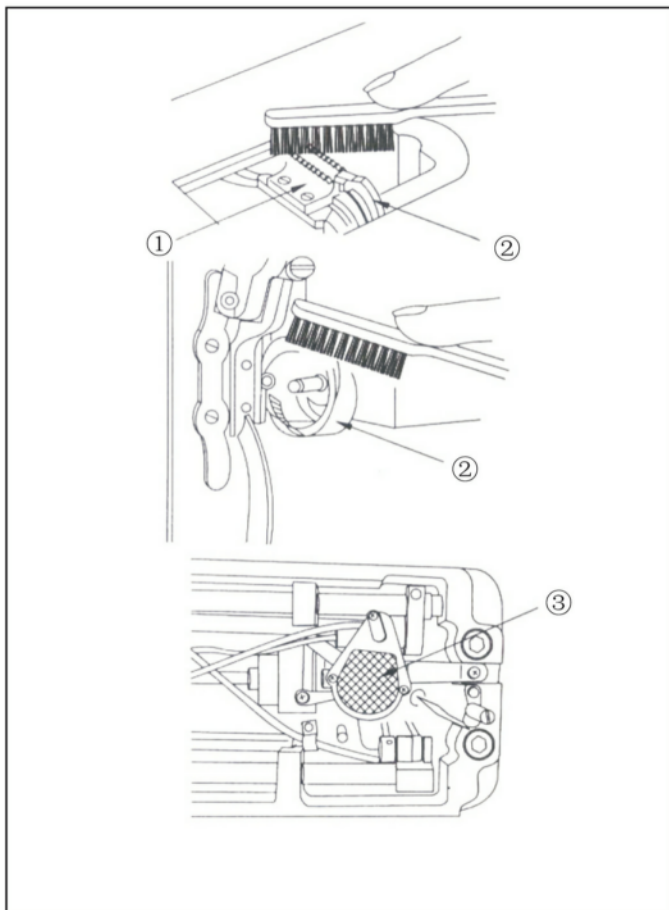
If you run the machine putting the solenoid in the operation mode, the movable knife ① will rotate by the thread trimming cam. The standard will be where the cut part of the movable knife ① progresses 1.0 to 1.5mm from the end edge of the fixed blade ② when the progress amount of the movable knife is in its maximum.

- (3) Adjusting blade pressure

In particular, when the cutting quality gets worse by using a thick thread, strengthen a little bit the tension of the fixed blade. In order to adjust the tension of the fixed blade, loosen the tension adjustment nut with the wrench box and adjust the tension using the tension adjustment bolt.



20. 定期清洁机器 Regular cleaning machine



定期清扫送布牙①、旋梭②和油泵③。

EN

Regular cleaning feed dog ①, hook ② and pump hook ③.

21. 故障原因及对策

缝纫机故障处理方法

编号	故障状态	确认事项	故障原因	处理事项
1	断针	针的方向、高度	插针方向不好	把针向正确的方向重新插入，紧贴到最上端
		针	针弯	换针
		锯齿定时	对针杆运动的锯齿定时不好	调整锯齿定时
		针杆提升量	针与旋梭的定时不好	调整针与旋梭的定时
		针杆高度	针与旋梭的定时不好	调整针与旋梭的定时
		针与锯齿之间的缝隙	针与旋梭的定时不好	调整针与旋梭的定时
2	断线	穿线状态	穿线错误	正确穿线
		针	针弯，针尖动了	换针
		针的方向、高度	插针位置不好	向正确方向插针
		面线张力	面线张力过大	适当调整面线张力
		底线张力	底线张力过大	适当调整底线张力
		挑线器弹簧工作量	工作量过大	调整弹簧工作量
3	穿线状态不良	线张力	面线底线张力不好	调整上下线的张力
		挑线器弹簧张力	挑线器弹簧张力不适当	调整挑线器弹簧张力
		开松机和旋梭间的缝隙	开松机和旋梭间的缝隙不好	调整开松机和旋梭间的缝隙
4	缝纫开始时，面线掉出或跳针	针的方向、高度	插针位置不好	向正确方向插针
		针	针弯，针尖动了	换针
		穿线方法	穿线错误	正确穿线
		针与旋梭间的缝隙	针与旋梭的定时不好	调整针与旋梭的定时
		切线后的面线余量	针上的面线余量过短	把控制面板的面线余量调整幅度调大
		底线把	切线后，底线把无法啮住底线	适当调整底线把的位置及张力
		针上面停止位置确认	针上面停止位置不好，缝纫开始时，挑线器把面线拉出去	针上面停止时，重新调整胶片位置
5	不能切线	动刀片与旋梭间的缝隙	动刀片与旋梭高度及距离不符合	重新调整动刀片的设定位置
		固定刀片张力确认	动刀片与固定刀片的张力及接触状态不好	调好动刀片与固定刀片的张力及接触状态
		针方向	插针状态不好	正确插针
		动刀片、固定刀片刀刃	动刀片、固定刀片刀刃有毛病或磨损	交换动刀片、固定刀片
		切线凸轮定时	切线凸轮定时不对	调整切线凸轮定时
		线松开工作量	线松开工作量过少	重新调整线松开工作量
6	切线结束后缝线余量过短	切线定时	切线定时不对	调整切线定时
		线张力调整碟的开量	线张力调整碟的开量过小	调整线松开工作量
		辅助线张力调整装置张力	辅助线张力调整装置张力过大	调整辅助线张力
		挑线器弹簧工作量	挑线器弹簧工作量过大	调整挑线器弹簧工作量
		控制面板的线松开调整幅度	幅度调整得过小	把幅度调大



21. Causes of troubles and troubleshooting

Sewing machine troubleshooting

No	Symptom	Checkpoints	Root cause	Corrective action
1	Needle breaks	Direction and height of needle	Needle is inserted into wrong position	Reinsert the needle correctly
		Needle	Needle is bent	Change the needle
		Timing of feed dog	Bad timing of feed dog	Adjust the timing of feed dog
		Ascending level of needle bar	Bad timing of needle and hook	Adjust the timing of needle and hook
		Height of needle	Bad timing of needle and hook	Adjust the timing of needle and hook
		Gap between needle and hook	Bad timing of needle and hook	Adjust the timing of needle and hook
2	Thread breaks	Threading method	Wrong threading	Thread the needle correctly
		Needle	Bent needle or broken needle tip	Change the needle
		Direction and height of needle	Needle inserted in the wrong position	Insert the needle correctly
		Upper thread tension	Too tight upper thread tension	Reduce tension of upper thread
		Lower thread tension	Too tight lower thread tension	Reduce tension of lower thread
		Working capacity of take-up lever spring	Loose upper thread	Adjust take-up lever spring
3	Poor thread adjustment	Thread tension	Upper and lower thread tensions are bad	Adjust the upper and lower thread tensions
		Thread take up spring tension	Thread take up spring tension is inadequate	Adjust the thread take up spring tension
		Gap between opener and hook	The gap between the opener and hook is inadequate	Adjust the gap between the opener and hook
4	Upper thread falls out when starting to sew or sewing is skipped.	Direction and height of needle	Needle is inserted into wrong position	Reinsert the needle correctly and push in to its highest level.
		Needle	Needle is bent	Change the needle
		Threading	Wrong direction	Insert the thread in the right way.
		Gap between the needle and the hook	The timing between the needle and hook is bad	Adjust the timing between the needle and hook
		Remaining upper thread length after trimming	The length of the remaining upper thread is too short	Increase the adjustment volume of the upper thread on the control box
		Lower thread holder	After trimming, lower thread holder does not hold the lower thread	Adjust the location and tension of the lower thread holder.
		Check the up-stop position of the needle	Due to problems in the up-stop position of the needle, the thread take up lever pulls the upper thread out of the needle when the sewing starts	Readjust the needle's up-stop film position
5	Trimming miss	The gap between the movable knife and the hook	The height and distance between the movable knife and the hook do not match	Readjust the movable knife setting position
		Check the tension of fixed knife	Tension and contact of movable and fixed knives are bad	Correct the tension adjustment and surface contact of movable and fixed knives.
		Direction of the needle	Needle is not inserted correctly	Insert the needle correctly
		Blade side of movable and fixed knives	Scratch and abrasion of movable and fixed knives	Replace movable knife or fixed knife.
		Trimming cam timing	The timing of trimming cam is wrong	Adjust the timing of trimming cam
		Thread release stroke	Thread release stroke is too small	Readjust the thread release stroke
6	Too short thread length after trimming	Trimming timing	Wrong trimming timing	Adjust the trimming timing
		Opening of the thread tension adjusting plate	The opening on the thread tension control plate is too small	Adjust the thread release stroke
		Tension of auxiliary thread tension adjustment assembly	Too strong tension on the auxiliary thread tension control assembly	Adjust the tension of the auxiliary thread tension control assembly
		Thread take up stroke	Thread take up stroke is too large	Adjust the thread take up stroke
		Thread release adjustment volume on the control box	Volume is adjusted to too low	Increase the volume adjustment.



22. 台板加工图 Schematic diagram of the machine table

