

# SIRUBA

使用說明書與零件圖

INSTRUCTIONS BOOK & PARTS LIST

■700LQ





## 溫馨提醒

請儘快下載 SIRUBA APP，並將您的機器註冊，以便獲得原廠的保固。APP 還提供多項有用的資訊。



## 安全警示

有關於縫紉機，自動化機構，以及其他輔助設備（以下統稱為機器），在工作中無可避免會接近機器移動區域，也就有伴隨著潛在風險。因此，我們強烈要求操作者，維修技師一定要先仔細閱讀並瞭解本操作手冊的內容。

安全指示係包含了某些未載於規格書上的加裝配件。

現場管理者有責任要求所有操作者要閱讀並瞭解機器的操作與注意事項。

未能確實遵守本手冊所記載的事項，將可能導致機器的損害，或是人員的傷亡。

### 警告標示說明

	<p>高壓電危險</p> <p>在機器關機後十分鐘內， 勿開啟電控箱。</p>		<p>零部件移動區</p>
	<p>零部件高速移動區</p> <p>勿接近，以避免人員受傷。</p>		<p>勿接近，以避免人員受傷。</p>

標告標示說明		標告標示說明	
	<p>機器零部件移動區，勿接近，以避免人員損傷。</p>		<p>請注意，在操作過程中握住縫紉機會傷到您的手。</p>
	<p>有電，危險。</p>		<p>小心被機械捲件受傷！</p>
	<p>高溫度區！危險，勿靠近。</p>		<p>如果觸摸按鈕托架，可能會造成人身傷害。</p>
	<p>強光！勿直視，以避免眼睛受傷。</p>	一般安全標示	
	<p>小心頭部撞擊！</p>		<p>機器運行方向</p>
			<p>電氣接地位置標示</p>

## 安全須知

### 危險

意外事件將會導致人員受傷甚至死亡，也會造成財產的損害。

當有必要進行電控系統的檢修時，務必要關閉電源，並等候至少 5 分鐘以上才能打開電控箱／操作箱，以避免電擊。

### 注意

#### 1. 基本預防

- (1) 在操作前務必先閱讀操作手冊與其他機器電件的說明書，請妥善保存操作手冊與說明書以便隨時查閱。
- (2) 這些注意措施包含了機器上加裝，但未列在規格書上的項目。
- (3) 務必要戴護目鏡與手套，以避免破損零件所帶來的傷害。
- (4) 有裝戴心臟調節器的人員，請先詢問醫護人員有關注意事項。

#### 2. 安全裝置與警告標示

- (1) 操作前要檢查，並確認所有的安全設施有妥善安裝且運作正常。
- (2) 若安全設施因維修需要而移動，在機器重新啟動操作前，請確認安全設施有重新安裝回原位，並且運作正常。
- (3) 機器上的安全警告標示要保持完整與可辨視。如果有污損或遺失，請儘以更新。
- (4) 未能確實遵守安全規範，將會導致人員受傷，甚至影響生命安全。

#### 3. 應用與修改

- (1) 嚴格禁止機器使用在非原始設計用途。也禁止以任何不是操作手冊上記載的方式來操作機器。
- (2) 嚴格禁止修改機器。任何未經原廠許可的變動將不在保固範圍內。
- (3) 機台一經修改變動，本公司將不擔負財務損失，人員傷亡的責任。

#### 4. 教育與訓練

- (1) 工廠主管人員有義務提供機台使用人（操作者／維修者）相關的教育訓練。良好的教育訓練不僅可以避免造成人員傷害，也可以避免財產的損失。
- (2) 操作人員操作機器之前，都必需接受過良好的訓練。
- (3) 機器的維修保養必須由合格的技師執行。

#### 5. 必須關閉電源的情況：

如何關閉電源：按壓下緊急停止開關（如果機器有配置的話），關閉電源，拔除電源線。

- (1) 當機器出現異常時，按下緊急停止開關（如果有配置），關閉電源。
- (2) 為了避免機器突然起動造成意外，在操作機器前，要先確定機器電源關閉，再行開啟電源。
- (3) 當檢查或清潔機器時，關閉電源，並確定機器已完全停止運作。
- (4) 當維修機器時（如更換或調整零件），要關閉電源，並確定機器已完全停止運作。

6. 拔除電源線時，務必要抓住電源插頭，而非抓住電源線，以避免斷裂，電擊，甚至火災。

7. 當機器停止運作，且無人看管時，要關閉電源。

8. 萬一停電或電力供應出現不穩，關閉電源，以避免意外發生。

## 在不同階段的注意事項

### 1. 運輸

- (1) 當搬運或移動機器時，請考量機器重量，選擇安全合適的方式。請參考機器規格。
- (2) 採取足夠的安全防護，以避免機台在搬運或移動中掉落。
- (3) 為避免意外，運送時不要重覆使用包裝材料。

### 2. 拆箱

- (1) 在拆箱前，檢查機器是否平穩放置，並採用適當的工具維持拆箱過程的穩定。
- (2) 進行拆箱時，遵循外箱上的指示，小心外箱上的釘子或碎片。

### 3. 安裝：

#### 3A. 桌板與腳架

- (1) 採用原廠的桌板以確保機器得到足夠的保護與支撐。如果在安裝或維修時，需要暫時將機器置放於物件上，請確定該物件有足夠的支撐力。
- (2) 如果桌板有裝置滾輪，滾輪需要有煞車鎖定機構，而且在操作與維修時，煞車機構必需鎖定。

#### 3B. 電線與管路

- (1) 電線與管路的材質必需符合規範與需求。
- (2) 電線與管路不能夠有折彎或壓迫。移動的零配件上，電線與管路需有至少 30mm 以上的預留量。
- (3) 接線時不能有跳火。
- (4) 所有接頭都必需確實固定。當拆除時，務必要抓住接頭本體。

#### 3C. 接地

- (1) 接地是必需的。且需由合格的技師來施工。
- (2) 在操作前需確認接地有確實。

#### 3D. 馬達

- (1) 馬達的選用，必需符合規範與需求。
- (2) 如果馬達為皮帶傳動，務必要安裝保護措施以避免捲入危險。

### 4. 在開始操作前

- (1) 在開啟電源前，確認所有接頭，電線，管路都完好無損，確實連結。
- (2) 檢查皮帶輪的轉向與標示為同一方向。
- (3) 確認腳架滾輪都已鎖定。
- (4) 保持作業範圍淨空。

## 5. 在操作中

- (1) 注意手，頭髮，布料不在機件移動範圍。不要將個人物品置放於機器上。
- (2) 機器會高速運作。保持雙手遠離移動機件範圍。機器完全停止前不要靠近。
- (3) 在移動物件或重新設定機器時，注意不要被機器或零件撞擊。
- (4) 避免突然起動造成意外，在檢查或維修馬達或皮帶時，務必關閉電源並確認機器完全停止。
- (5) 機器停止時，伺服馬達是無聲的。注意要關閉電源以免突然起動。
- (6) 永遠保持電控箱的風扇與氣道淨空。

## 6. 潤滑

- (1) 請依照說明書指示，選用合格的油脂來潤滑機件。
- (2) 如果油品接觸到眼睛或身體，立即以清水沖洗。如有不適，立即尋求醫護人員協助。
- (3) 如果油品不慎進入身體，立即尋求最近的醫療協助。

## 7. 維修保養

- (1) 只有合格的技師或工程師能夠進行維修服務，包含機器調整與修理。只採用原廠的零件進行更換。如果採用非原廠零件，或是因不當維修／調整所造成的傷害，本公司將不負任何責任。
- (2) 只有合格的技師或認證的工程師才能對電控系統進行維修或保養。
- (3) 當對氣動原件（如氣缸）進行維修保養時，務必先拔除風源，並將氣體完全洩除，以避免突然啟動。
- (4) 在調整或更換部件後，檢查所有螺絲是否鎖固。
- (5) 定期清潔是必需的。在清潔前務必先關閉電源，並確認機台完全停止。
- (6) 如果運作異常或不良，立即停止操作並關閉電源。聯絡授權經銷商或我們公司以尋求技術協助。
- (7) 當保險絲故障，立即關閉電源，找出故障原因並予以排除後，更換同規格的新的保險絲。
- (8) 定期檢查與清潔風道，電線與管路。

## 8. 工作環境

- (1) 機器必需不用電磁波干擾。
- (2) 電源供應必需良好且穩定。電壓波動不得超過 10%。
- (3) 隨時檢查空壓的壓力與品質。如果氣源不穩定，請安裝合適器材以改善。
- (4) 機器操作環境，室溫 5° C ~ 35° C, 相對濕度 35%~85%.
- (5) 為了保護電子元件與安全起見，當有劇烈氣溫變化而導致凝水時，立即關閉並拔除電源，並靜候至完全乾燥為止。
- (6) 為了安全起見，當有打電或閃電時，請停止操作，關閉並拔除電源。
- (7) 勿在機器週遭使用電視或收音機，以避免干擾。
- (8) 依當地法令規範，在操作中採取必要的防護。
- (9) 關於包裝材料，潤滑油品，以及機器（含零配件）的丟棄，請依各地政府法規的規範執行。

## A WARM REMINDER

please register your Siruba machine online or through Siruba App at once, as to gain the full warranty protection. You may also acquire more useful information through Siruba APP.



## GENERAL SAFETY INSTRUCTION

For the sewing machine, automatic mechanic system, and auxiliary devices (hereinafter referred as “machine” ), it is inevitable to conduct work near moving parts of the machine. This means that there is always a potential risk from the moving parts. Operators actually operating the machine and service technicians performing maintenance and repair are strongly advised to read and understand fully the following instructions in advance.

The safety instructions include items which are not listed in the specifications of your product. It is the manager/ supervisor’s responsibility to have their fellow workers fully understand before operation.

Fail to follow the instructions may cause damage to properties, severe injure or even death.

Explanation of warning indications and labels.

	<p>HIGH VOLTAGE DANGER</p> <p>Do not open the power cabinet within 10 minutes after the power off.</p>		<p>Machine moving area!</p>
	<p>High speed moving area!</p> <p>Stay away and keep clear to avoid injury.</p>		<p>Stay away and keep clear to avoid injury.</p>

WARNING LABELS		WARNING LABELS	
	<p>A risk of cut and injury from moving parts. Stay away and keep clear.</p>		<p>Be aware that holding the sewing machine during operation can hurt your hands.</p>
	<p>A risk of electric shock. Stay away and keep clear.</p>		<p>There is a risk of entanglement in the belt resulting in injury.</p>
	<p>A risk of burn from the high temperature area. Stay away and keep clear.</p>		<p>There is a risk of injury if you touch the button carrier.</p>
	<p>Avoid direct eye contact with the laser beam or other light source.</p>	GENERAL SAFETY INDICATIONS	
	<p>A risk of injury to head from upper contact. Apply proper protection (helmet) and keep clear.</p>		<p>The correct direction is indicated.</p>
	<p>A risk of injury to head from upper contact. Apply proper protection (helmet) and keep clear.</p>		<p>Grounding connection as indicated.</p>

## SAFETY PRECAUTIONS

### Danger

An accident means ” to cause personal injury or death, or damage to property. ”

When it is necessary to perform service on electrical parts, be sure to turn the power off and wait for 5 minutes or more before opening the power cabinet/box in order to avoid electrical shock.

### Caution

#### 1. Basic precaution

- (1) Read the manual and other papers supplied with accessories of the machine before operation. Keep the manual and papers at hand for quick reference.
- (2) The content of this section includes items which are not listed in the specification of your product.
- (3) Always wear safety goggles and gloves to avoid accident caused by parts breakage.
- (4) For those who use a heart pacemaker, please consult the medical specialist first.

#### 2. Safety devices and warning labels

- (1) Check to ensure all safety devices are correctly installed in place and properly before operation.
- (2) If any of the safety devices is removed for service cause, please be sure to replace it back to position and verify that it works normally before resuming operation.
- (3) Always keep the warning labels adhered on the machine clearly visible. If any of the labels missing or contaminated, replace with a new one at soon.
- (4) Fail to obey instructions above may cause severe injury or death to the operators.

#### 3. Application and modification

- (1) It is prohibited to use the machine for any application other than its original intention, or in any manner other than that prescribed in the instruction manual.
- (2) Never modify or alter the machine. Any unauthorized change of the specification will not be covered by the warranty.
- (3) Our company assumes no responsibility/liability to damages, injuries, or death resulting from the machine which has been modified or altered.

#### 4. Education and training

- (1) The plant managers/supervisors are obliged to provide education and training to operators and service technicians. A good education/training plan not only avoids personal injury but also prevent damage to the property.
- (2) Only a well-trained operator is allowed to operate the machine.
- (3) Only a certified technician is allowed to perform service to the machine.

#### 5. Situations that you must turn off the power

Turning off the power: press EMG Stop (if there is one), switch off the power, and remove the power plug from the outlet.

- (1) When there is a failure or abnormality, press EMG Stop (if there is one), switch off the power.
- (2) To prevent accident resulting from abrupt start of the machine, before operating the machine, always turn off the power and switch on again.
- (3) When cleaning or inspecting the machine, make sure the machine stops completely after turning off the power.
- (4) When performing service (i.e. changing of adjusting any component), make sure the power is off and the machine stops completely.



6. Remove the power plug by holding the plug section instead of the cord to avoid electrical shock, leakage, or fire accident.
7. Turn off the power whenever the machine is left unattended between works.
8. In case of a power failure or black out, turn off the power to avoid damage or accident.

## PRECAUTIONS TO BE TAKEN IN VARIOUS OPERATION STAGES

### 1. Transportation

- (1) When lift or move the machine, please take the machine weight into consideration and apply a safe manner. Refer to the specification for the information you need for transportation.
- (2) Apply sufficient safety measures when lifting or moving the machine to avoid falling or dropping.
- (3) To avoid unexpected accident, do not reuse the packing material for transportation.

### 2. Unpacking

- (1) Before proceeding to unpacking, check the balance of the machine and apply necessary tools to hold the proper position.
- (2) When unpacking, follow the instruction printed on the cartoon. Be careful of the nails and chips when unpacking from a wooden rack.

### 3. Installation:

#### 3A. Table and Stand

- (1) Only adopt a qualified genuine table and stand to assure the holding support. In case you need to leave the machine on a surface temporarily for service, make sure the surface is strong enough to hold the weight.
- (2) If casters are applied to the table stand, adopt casters with a locking mechanism only and lock them well to secure the machine during the operation and service.

#### 3B. Cable and Wire

- (1) The cables and wires must comply with the specification and requirement.
- (2) The cables and wires shall be free from bending or extra force. Reserve a free space of at least 30mm between cables/wires and the moving parts.
- (3) Do not apply starburst connection when wiring.
- (4) All connectors must be fixed securely. And always hold the connector body when removing it.

#### 3C. Grounding

- (1) Grounding is necessary and must be done by a certified technician. (2) Check and ensure the grounding is secured before operation.

#### 3D. Motor

- (1) The motor must comply with the specification and requirement.
- (2) If there is a belt in the motor transmission, adopt or apply a proper protector to avoid entangling.

### 4. Before Operation

- (1) Before turning on the power, make sure all the connectors, cables, and wires are free from damage, dropout, or looseness.
- (2) Check and make sure the pulley rotation follows the same direction as labels.

- (3) Make sure all the stand casters are locked or fixed in position.
- (4) Keep the working area clean from obstacles.

## 5. During Operation

- (1) Always keep your fingers, hair, or clothing away from the moving components and moving area. Do not place your personal belongings on the machine.
- (2) The machine is designed to run at high speed. Always keep your hands away from the moving area. Do not resume the work cycle until the machine stops completely.
- (3) Be careful not to be caught by the machine or components when removing or resetting the machine.
- (4) To avoid accident caused by abrupt start, when performing service on the motor or belt, make sure the power is off and the machine stops completely.
- (5) A servo motor is silent as the machine stops. Be sure to turn off the power to avoid an abrupt start. (6) Always keep the fan and airway of the power cabinet clean from any obstacle.

## 6. Lubrication

- (1) Apply only qualified oil and grease onto the parts as instructed in the manual.
- (2) If the lubricant contacts your eye or body, wash it off immediately. Consult a medical care if necessary.
- (3) If the lubricant goes into your body accidentally, go to the nearby medical care immediately.

## 7. Service

- (1) Only a certified engineer/technician is allowed to perform service to the machine, including adjusting and repairing. Use only genuine parts for replacement. Our company assumes no responsibility/liability for any accident caused by improper repair or adjustment, or the use of any parts other than genuine one.
- (2) Only a certified technician or authorized engineer is allowed to repair or maintenance the electric system.
- (3) When performing service to air-driven parts, like an air cylinder, first disconnect the air supply and expel the air completely to avoid abrupt start.
- (4) Check all screws and nut are fixed well after adjusting and replacement.
- (5) A periodical cleaning is necessary. Make sure the power is off and the machine stops completely before cleaning.
- (6) If the machine functions poorly or abnormally, stop the operation and turn off the power. Contact the authorized dealers or us to request for a technical service support.
- (7) When there is a fuse failure, turn off the power, find out the cause of the failure and apply solution to it, then replace with a new one with the same spec.
- (8) Periodically check and clean the fan airway and the cable/wiring.

## 8. Working Environment

- (1) The machine should be free from the affection of electro-magnetic wave.
- (2) The power supply should be in good and reliable condition, the fluctuation of rated voltage should be less than 10%.
- (3) Always check the air pressure and quality. Some extra device might be needed if the supply is not reliable.
- (4) The machine is designed to be used with ambient temperature  $5^{\circ}\text{C} \sim 35^{\circ}\text{C}$ , relative humidity 35%~85%.
- (5) To protect the electronic components and for safety cause, when there is a frost resulting from a dramatic temperature rise, disconnect the power and wait until it dry completely.
- (6) For safety cause, when there is a thundering or lightening, stop the operation and disconnect the power supply.
- (7) Do not use TV or radio nearby the machine as to avoid interference.
- (8) Apply necessary protection during operation. Follow applicable regulations set by local administration.
- (9) For disposal of packages, lubricant, and product, please follow the applicable regulations set by local administration.

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MODEL		700LQ	
Net Weight(Kg)	27	Noise Level, dB(A)	82dB(A)
Serial No.		Vibration (m/sec <sup>2</sup> )	
Dimension	Length	Width	Height
	35cm	22cm	31cm



**注意CAUTION**



清潔作業前，請切斷電源。當誤觸啓動開關時，縫紉機動作易導致人員受傷。  
Turn off the power switch before carrying out cleaning. The machine may operate if the treadle is pressed incautiously, which could result in injury.



加潤滑油和黃油時，務必戴好保護眼鏡和手套，以防潤滑油進入眼中或沾在皮膚上，易引起發炎。  
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 be resulted.



潤滑油或黃油不能飲用，否則將會引起嘔吐和腹瀉，將油放在小孩拿不到的地方。  
Furthermore, do not drink or eat the oil nor the grease for they can cause vomiting and diarrhea. Keep the oil away of the reach of children.

縫紉機頭倒下或豎起時，請以雙手進行操作。  
Use both hands to hold the machine head when tilting or returning it to its original position.



單手操作時，因縫紉機的重量較重，萬一滑落易導致受傷。  
If only using one hand to move the machine, the weight of the machine head may cause slipping and you may get hurt.

定期保養項目(表7)

Periodical Maintenance Items(Table7)

保養循環 Maintenance Cycle	保養項目 Maintenance Items
每天 Daily	1. 清潔送料具上之棉絮 1. Clean the lint on the feed dog.
	2. 檢查油盤是否有足夠之液態油。(油量在油鏡之上、下兩紅漆記號間) 2. Check if there has enough liquid oil inside the oil pan. (The amount should be between the red up and down paint mark of the oil level gauge.)
	3. 保持機器及操作台清潔 3. Keep the machine and the operation table clean.
	4. 清潔手輪濾網上之棉絮 4. Clean the fiber on the filter net of the hand wheel.
每週 Weekly	1. 保持電源外觀乾淨 1. Keep the power cords looking clean and neat.
	2. 保持操作面板乾淨 2. Keep the operational panel clean
	3. 檢查電源零件是否鬆脫或在正確位置 3. Check if the power parts is loosening or still at the right position
每三個月 Quarterly	1. 更換油盤內之液態油 1. Change the liquid oil inside the oil pan

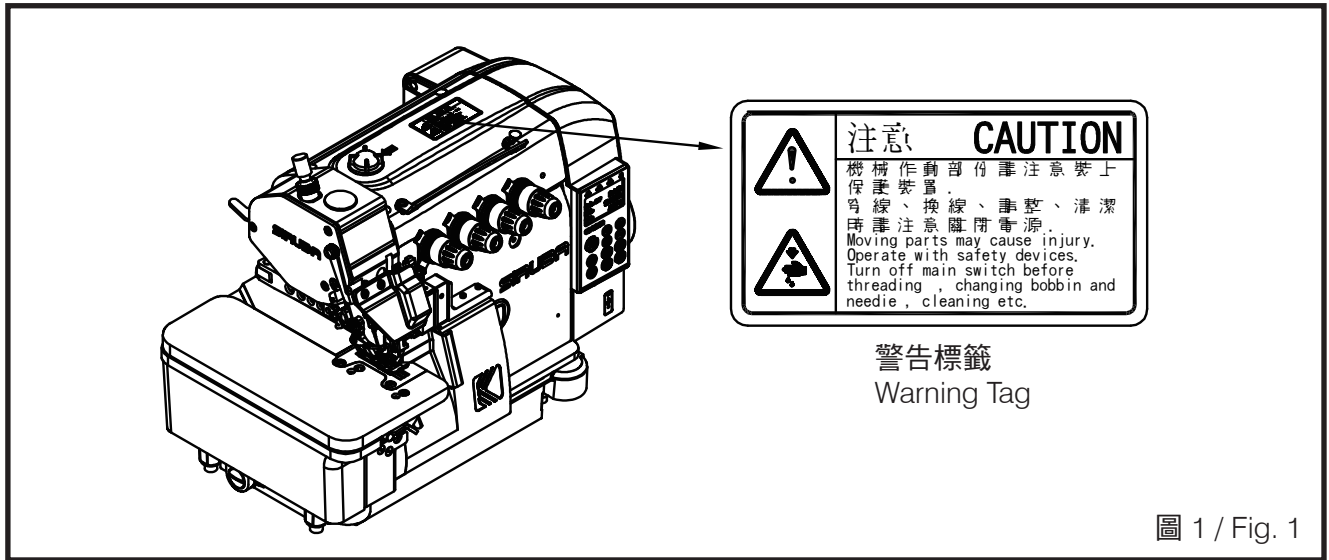
表7/Table7

## 警告標籤

## WARNING TAG

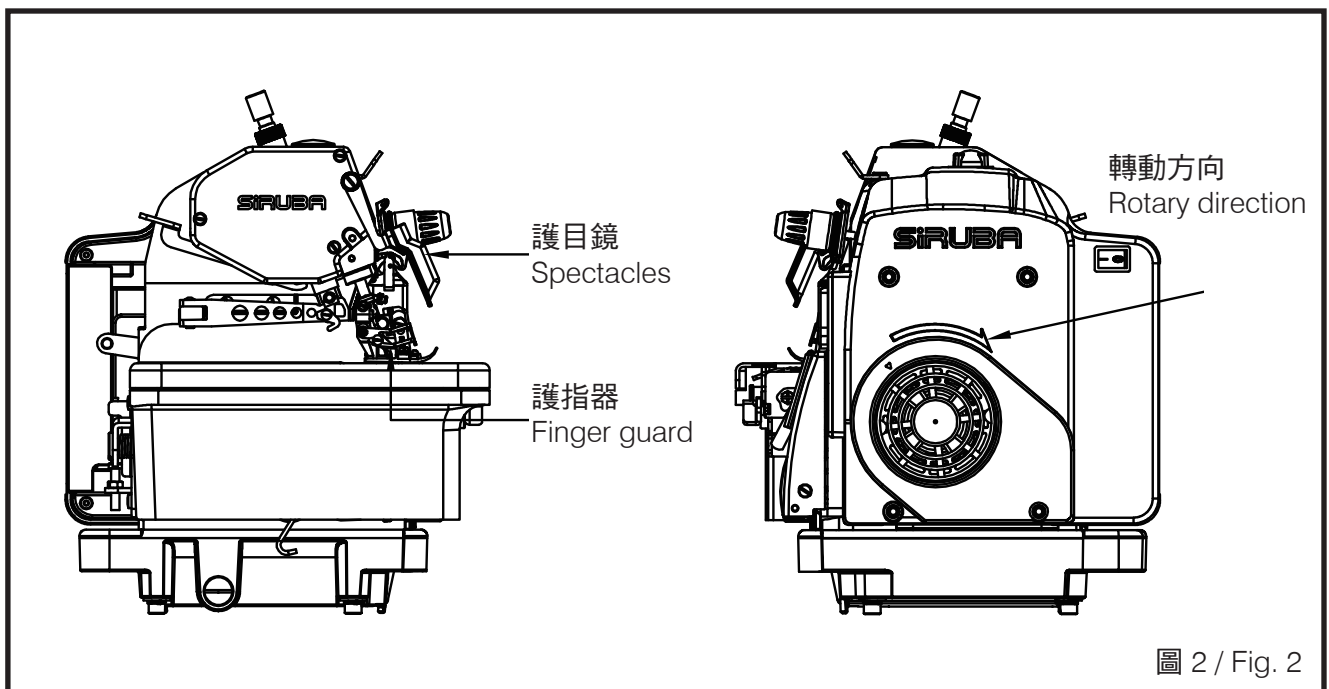
1. 縫紉機上有警告標籤 (圖 1)。
2. 當使用縫紉機時，請遵守標籤上的說明。  
如果標籤脫落或模糊不清，請和購買商店聯繫。

1. The following warning tags will be attached on the sewing machine.(Fig. 1)
2. When using the sewing machine, please follow the instructions of the tags. please contact the dealer if any of the tags is fallen off or fuzzy.



3. 安全防護裝置及 ↷ 轉動方向。(圖 2)

3. Safety protection device and ↷ rotary direction. (Fig.2)



## 護針安全圖說

## SAFETY ILLUSTRATION OF THE NEEDLE GUARD

- 本縫紉機之押具防護裝置如圖所示，為保護操作者之操作安全，嚴禁將此裝置拆卸。  
(圖 3)

- The presser foot protection device is as shown as the figure 3.  
For safety of all operators, this device is restricted to disassemble. (Fig.3)

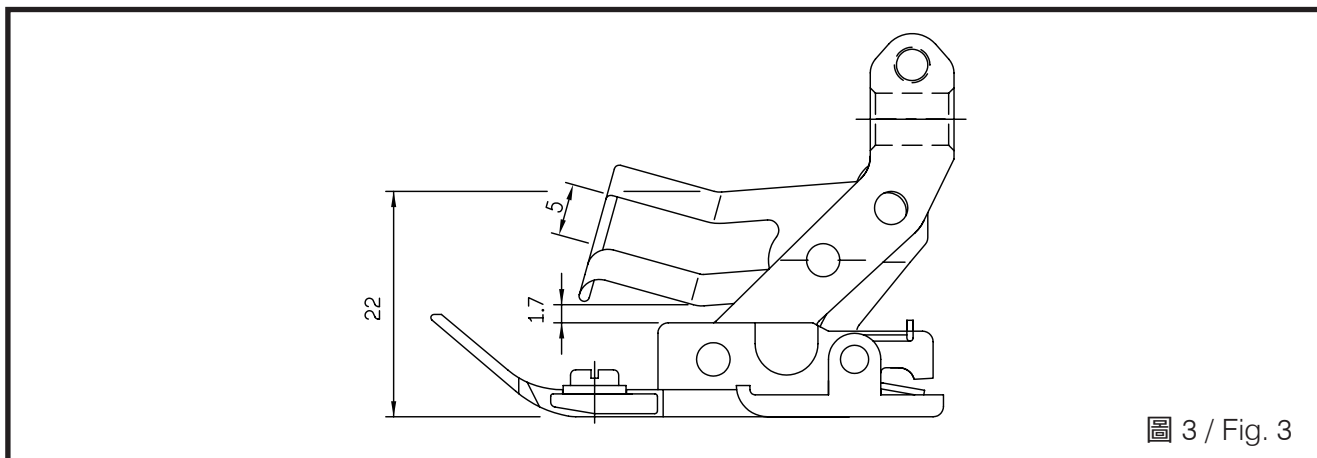


圖 3 / Fig. 3

## 搬運縫紉機

## MOVING THE SEWING MACHINE

- 應按圖適用左手托住前機殼本體，右手撐扶住機頭底部進行搬運，搬運時需穿著安全鞋。  
(圖 4)

- To move the sewing machine, please follow the figure shows. Using left hand to hold the front machine cover body, and right hand to hold the bottom plate to move. Please wear safety shoes while moving. (Fig.4)

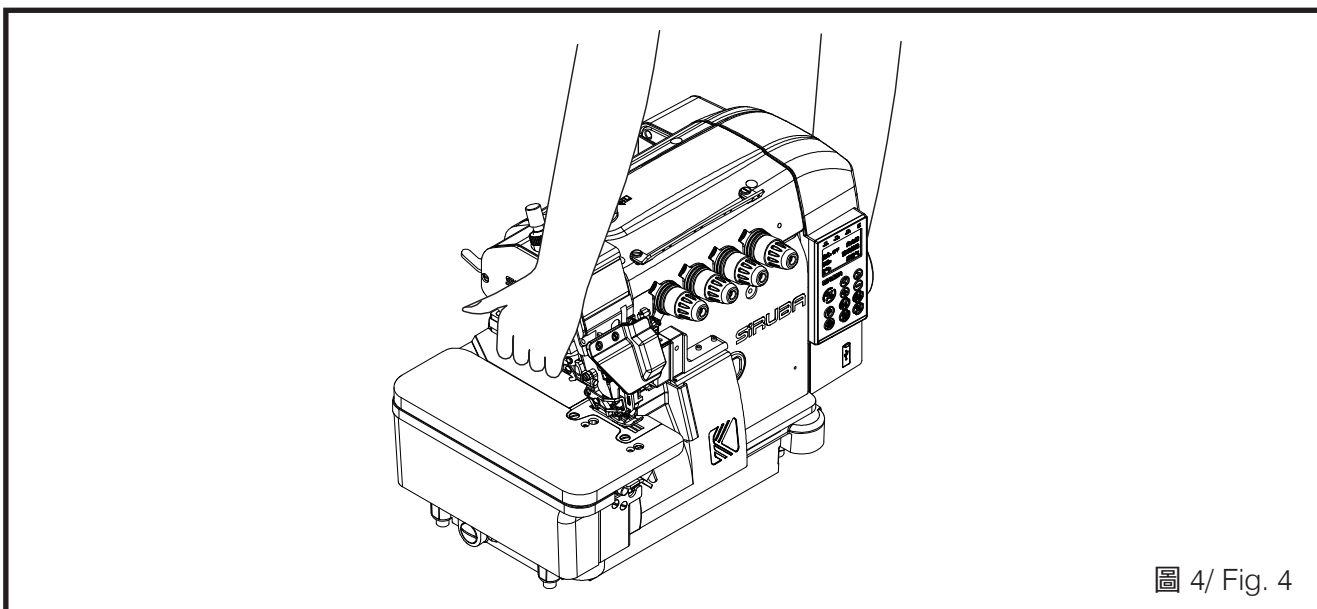


圖 4 / Fig. 4

## 縫紉機的安裝位置

## THE INSTALLATION POSITION OF THE SEWING MACHINE

1. 勿將該縫紉機置於設備附近，如電視機、收音機或無線電話等，否則這些設備可能會對縫紉機的電子干擾所影響。(圖 5)
2. 應將縫紉機直接插入 AC 電源插座，如果使用延長線，可能會造成操作故障。

1. Please do not install the sewing machine near the equipments, such as Television, Radio, or Wireless Telephone. Or these equipments will experience electronic interference. (Fig.5)
2. The wire should insert the AC power socket directly. If using the extension wire, this might cause malfunction.

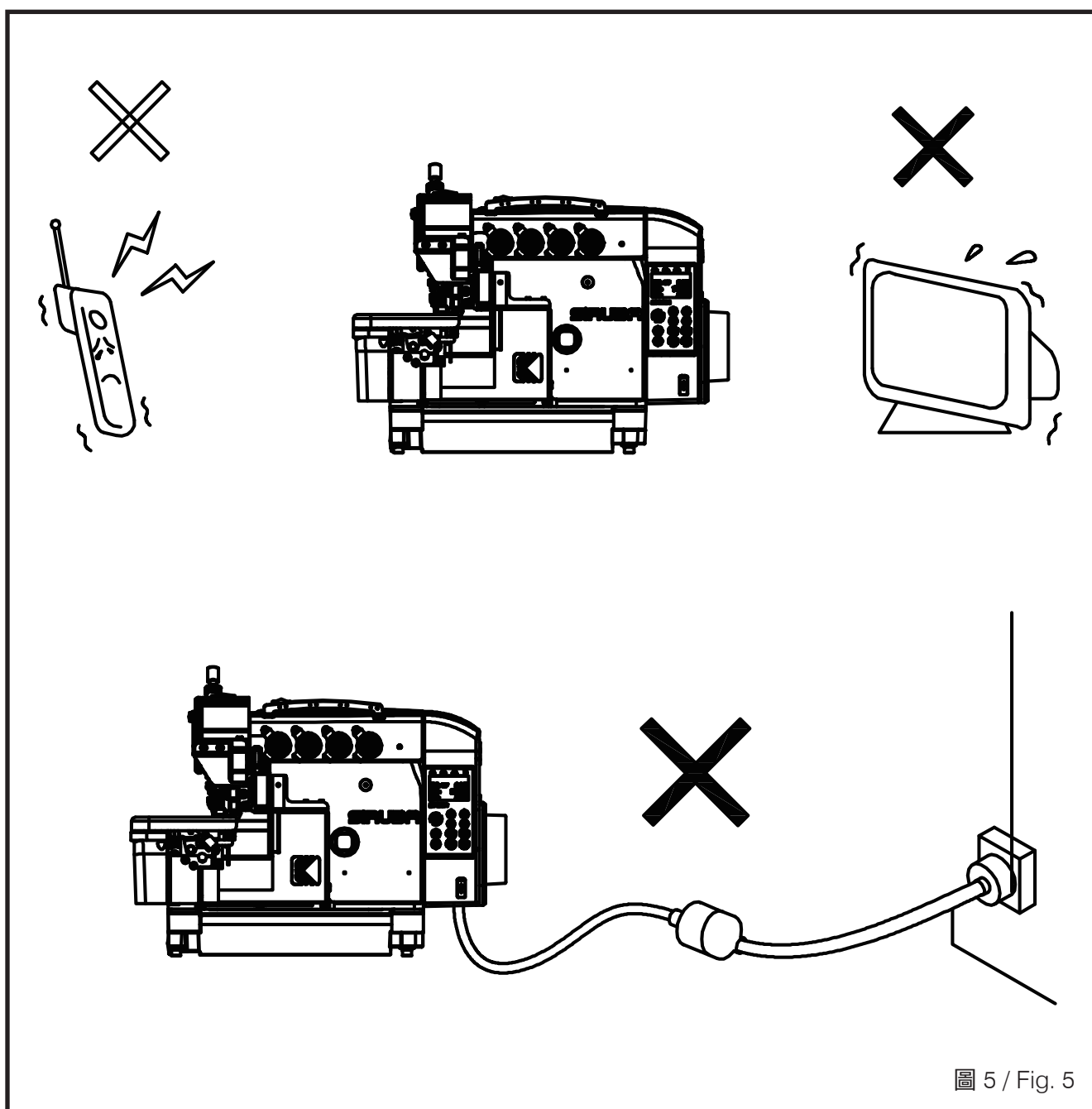


圖 5 / Fig. 5



# 規格

# SPECIFICATIONS

1. 型號分類表示：






1.Description:

747
LQ
-
514
M
-
3
-
2
4
ECA

(1)    (2)    (3)    (4)    (5)    (6)    (7)    (8)

- (1) 表示線數分 737、747、757、767
- (2) 機種別
- (3) 縫合方式 (圖表 1)

- (1) Thread numbers / Four types :  
737、747、757、767
- (2) Machine type
- (3) Sewing type (Chart 1)

型式 Type	504	512	514	516	644
圖形 Pattern					

圖表 1 / Chart 1

- (4) 車縫布料
  - F: 輕薄布料
  - L: 薄布料
  - M: 中厚布料
  - H: 厚布料
- (5) 送具型式
- (6) 針寬
- (7) 包邊寬度  
3: 3mm, 4: 4mm, 5: 5mm, 6: 6mm
- (8) 配件

- (4) Sewing materials
  - F: Fine weight material
  - L: Light weight material
  - M: Medium weight material
  - H: Heavy weight material
- (5) Feed dog type
- (6) Needle width
- (7) Seam width  
3: 3mm, 4: 4mm, 5: 5mm, 6: 6mm
- (8) Attachment

## 2. 規格說明 (表 1)

## 2. Specification (Tab.1)

機型 Model	700LQ
最高縫速 Max Stitch Speed	7000rpm / 7000rpm
噪音值 Noise Level	82 分貝以下 under 82 dB
縫距 Stitch Length	4 / 5 / 6 mm
針棒行程 Stroke of the needle bar	標準行程 (Standard lift) 24.3 ±0.2 mm
押具揚程 Presser Foot Lift	5.5mm
押具壓力 Presser Foot Pressure	5kg
送具高度 (凸出針板面) Feed Dog Height (over the plate)	0.7~0.9mm
使用針 Needle for Use	DCX27
送具傳動方式 Feed Dog Transmission	偏心輪、連桿 Eccentric, Connecting Rod
送具齒寬度 Teeth Width of the Feed Dog	1.6mm
縫目調整裝置 Stitch Adjusting Device	按鈕調整 Button Adjustment
押具裝置 Presser Foot Device	彈簧式、旋鈕調整式 Spring Type, Knob Adjustment Type
加油方式 Oil Filling	儲油槽儲存方式，毛氈、棉線毛細管自動供油 Oil tank storage type. Automatic oil supply by Oil felt, cotton thread capillary action.
回油方式 Oil Return Solution	偏心泵浦 Eccentric Pump
使用油 Oil for Use	提供專用油 (MOBIL #10) Provide Specific Oil (MOBIL #10)
使用油脂 Grease for Use	提供專用油脂 (物料編號：C25114) Provide Specific Grease (Part No. C25114)

表 1 / Tab. 1

各部件名稱

NAMES OF MAJOR PARTS

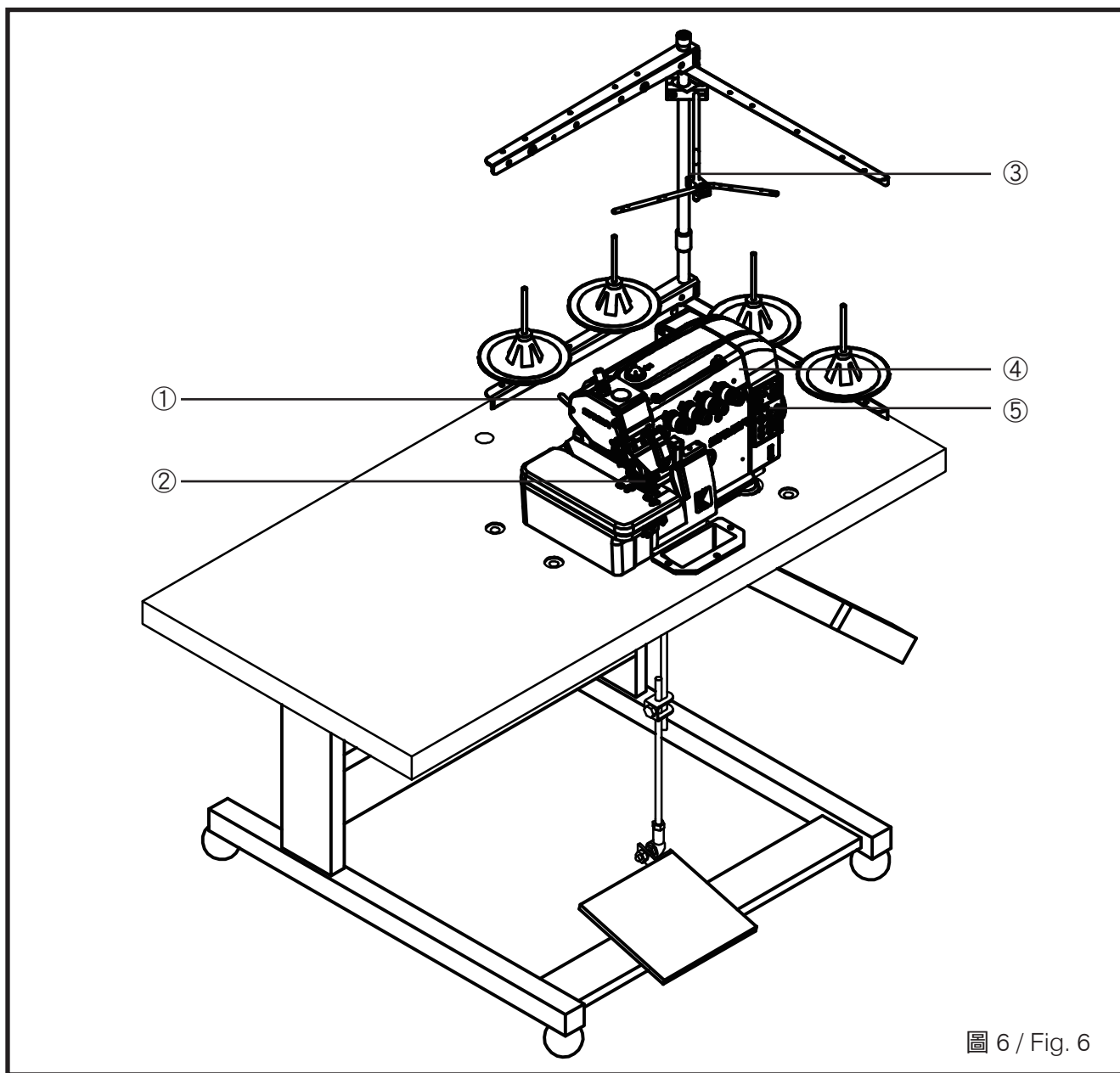


圖 6 / Fig. 6

- (1) 押具扳手 (圖 6)
- (2) 押具
- (3) 線架
- (4) 油窗
- (5) 電控箱

- (1)Lifting lever (Fig. 6)
- (2)Presser foot
- (3)Thread stand
- (4)Oil gauge window
- (5)Electric control box



### 注意CAUTION



請讓受過培訓的技術人員來安裝縫紉機。

Machine installation should only be carried out by a qualified technician.



請委託購買商店電氣專業人員進行電氣配線。

Contact your dealer or a qualified electrician for any electrical work that may need to be done.



縫紉機重30公斤, 安裝工作必須由兩人以上來完成。

The sewing machine weighs 30kg. The installation should be carried out by two or more people.



在安裝完成前, 請不要連接電源, 如果誤按啟動開關, 縫紉機動作會導致受傷。

Do not connect the power cord until installation is complete. The machine may operate if the treadle is depressed by mistake, which could result in injury.



縫紉機頭倒下豎起時, 請用雙手進行操作。單手操作時因縫紉機的重量萬一滑落易導致受傷。

Use both hands to hold the machine head when tilting it back or returning it to its original position. If only using one hand, the weight of the machine head may be too heavy to hold, and may cause human physical injuries.

1. 縫紉機拆箱搬運過程中, 不可扶持布板蓋  
①。(圖 7)

1. While moving the sewing machine, please do not hold the below side of the cloth cover ①.(Fig. 7)

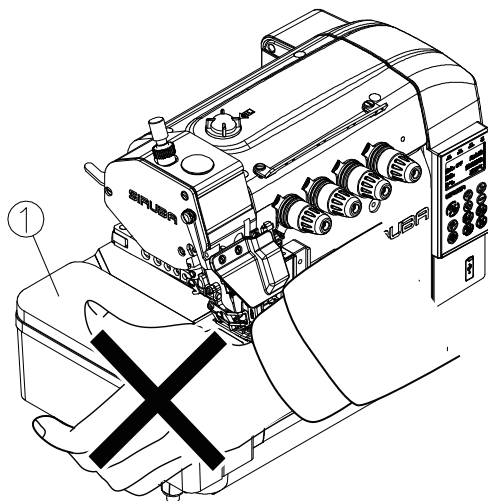
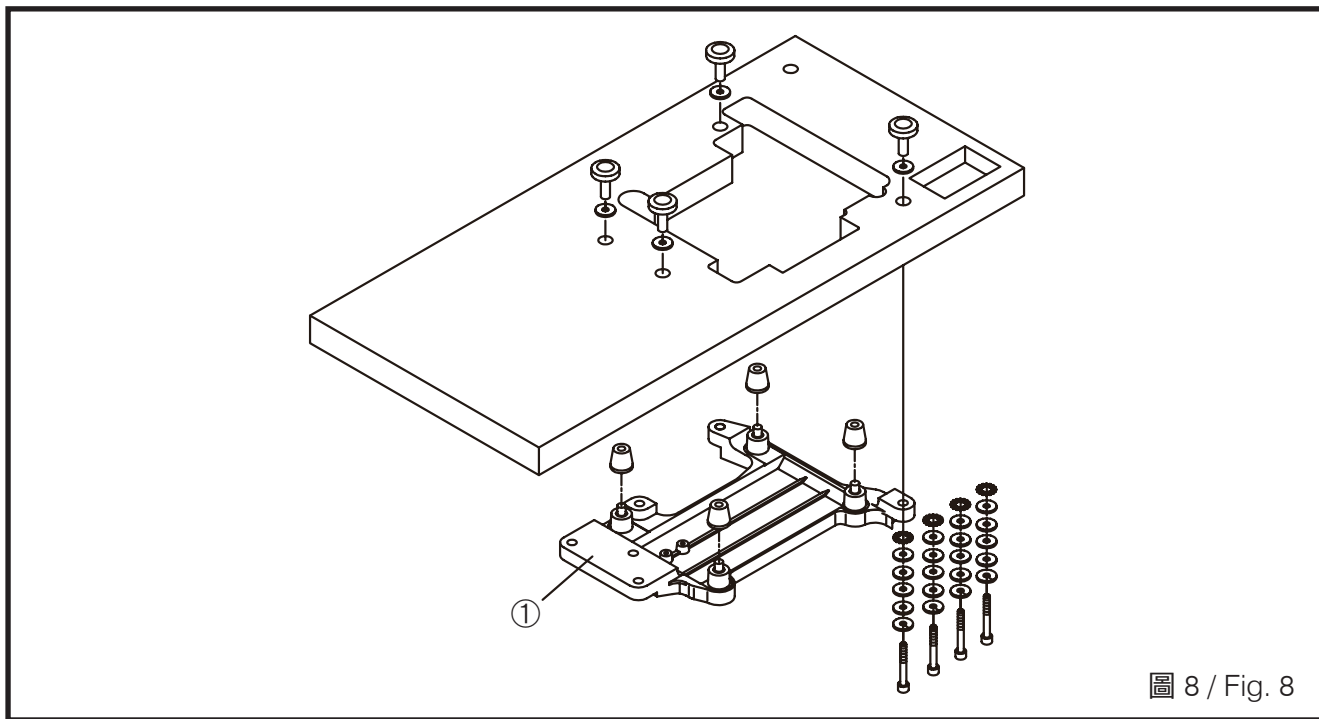


圖 7 / Fig. 7

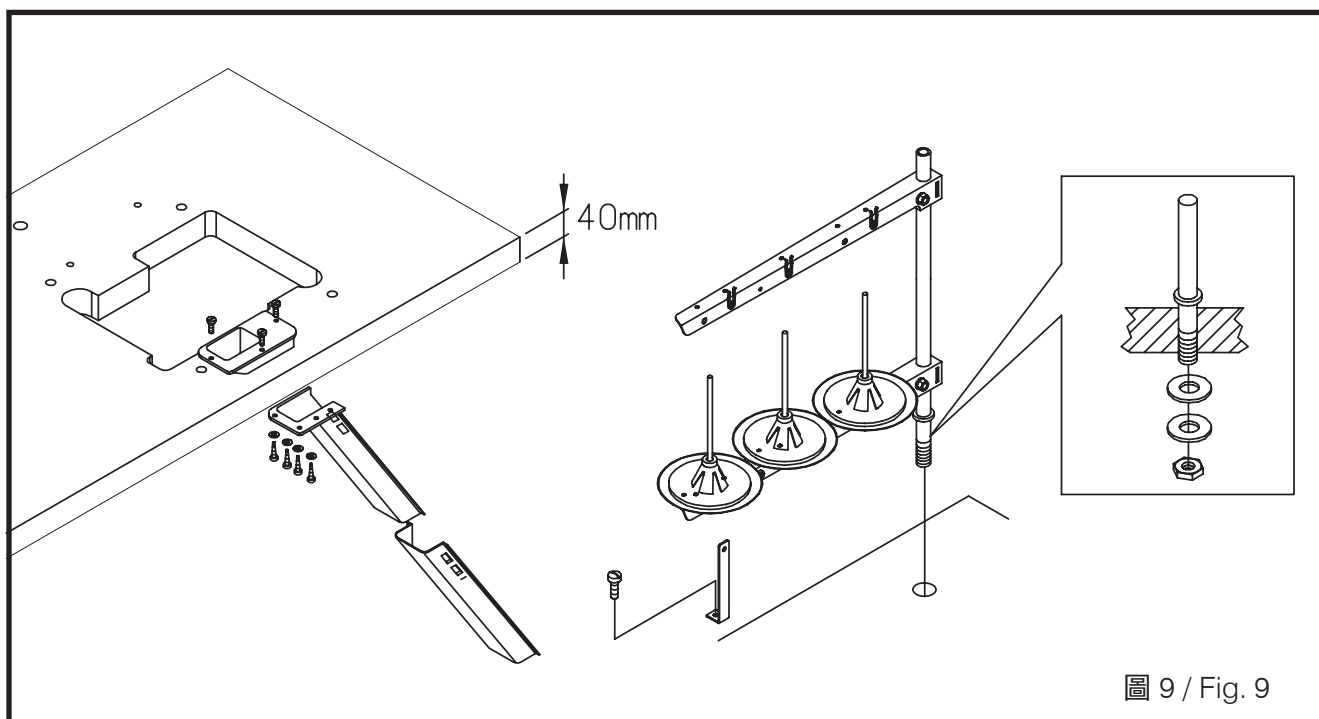
2. 依本機所附桌板裁製圖及零件組合圖所列之配件，依序安裝防震機座鋁板①。(圖 8)

2. Please refer to the attached table cut-out diagram and the parts list to assemble the anti-chock machine aluminum plate ① in order. (Fig.8)



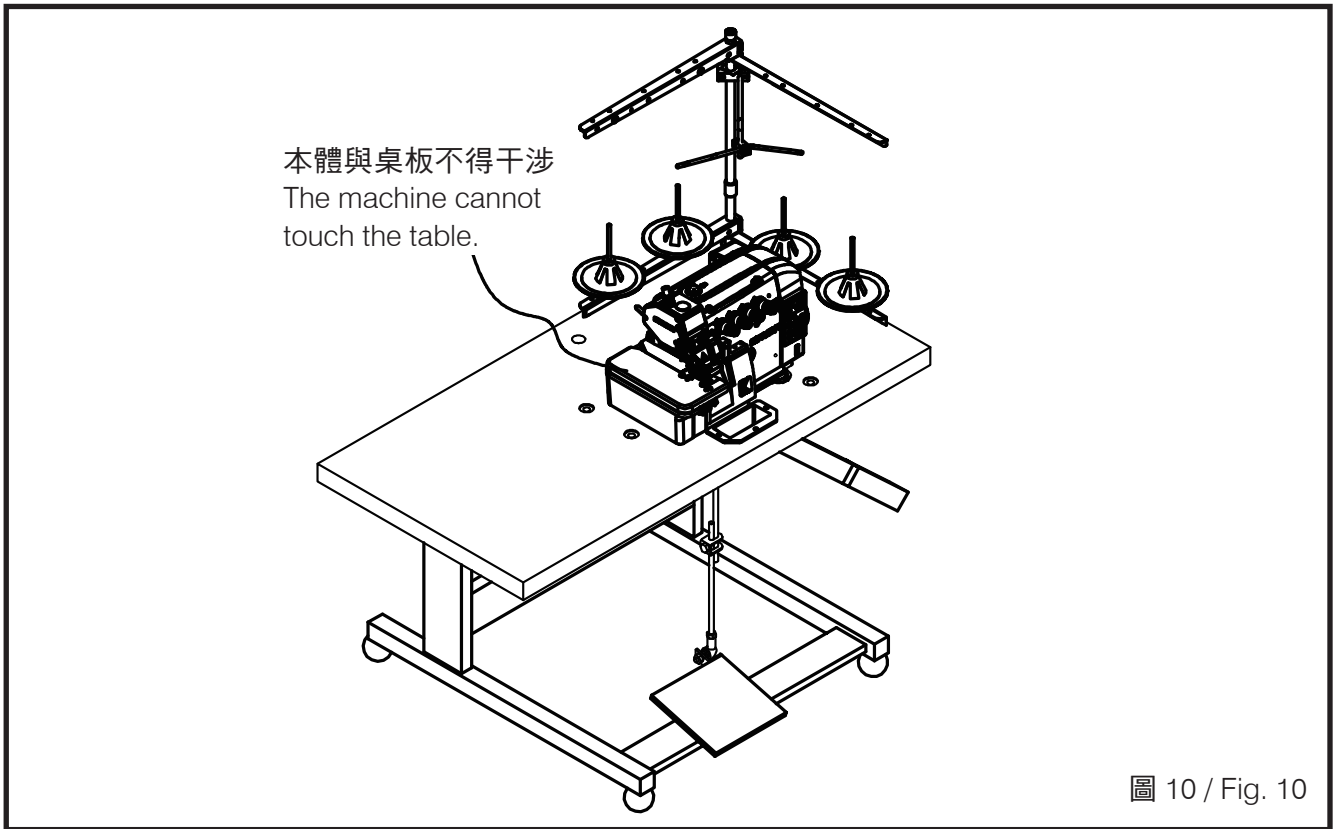
3. 裝置導布屑及線架。(圖 9)

3. Assemble the waste disposal set and the thread stand. ( Fig.9)



4. 在桌板上完成踏板傳感器的安裝後，將縫紉機機頭放在桌板上。(圖 10)

4. After the completion of installation of the pedal sensor on the table, place the sewing machine head on the table. (Fig.10)

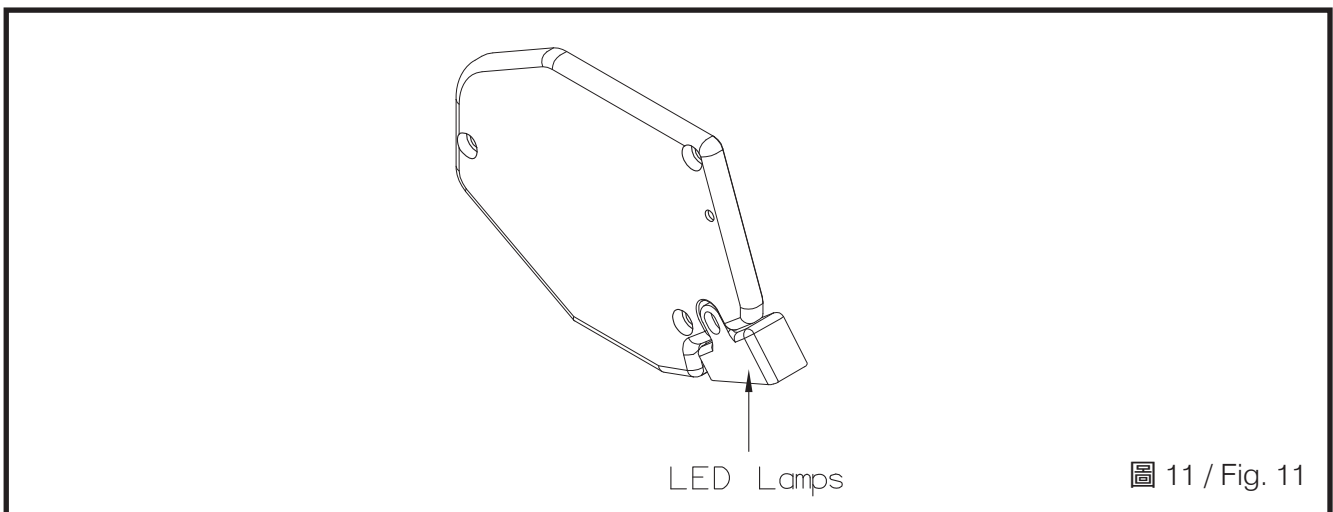


## 照明設備

## LIGHTENING EQUIPMENT

貼心使用者設計的照明機構，其採用不發熱、壽命長之發光二極體 LED 燈具，讓使用者能方便於穿線。(圖 11)

Thoughtful lightening equipment is deigned for the operators. Non-heating and long life LED lamps are adopted so that the operators can thread easily.(Fig.11)



## 新機器使用規定

## HOW TO OPERATE THE NEW MACHINE

1. 新機器在最初啟用磨合期的四個星期內，請用低於最高速度 20% 的速度運轉，之後換上新潤滑油，才運轉至最高速度。
2. 定期之清潔保養，確保延長機器之使用壽命。

1. Please operate this machine in 80% of the maximum speed in the first four weeks for engagement. After four weeks, please do not operate under the maximum speed until replacing the new lubrication oil.
2. Periodically maintain and clean the machine to ensure and extend the usage term of the machine.

## 潤滑油之注入與更換

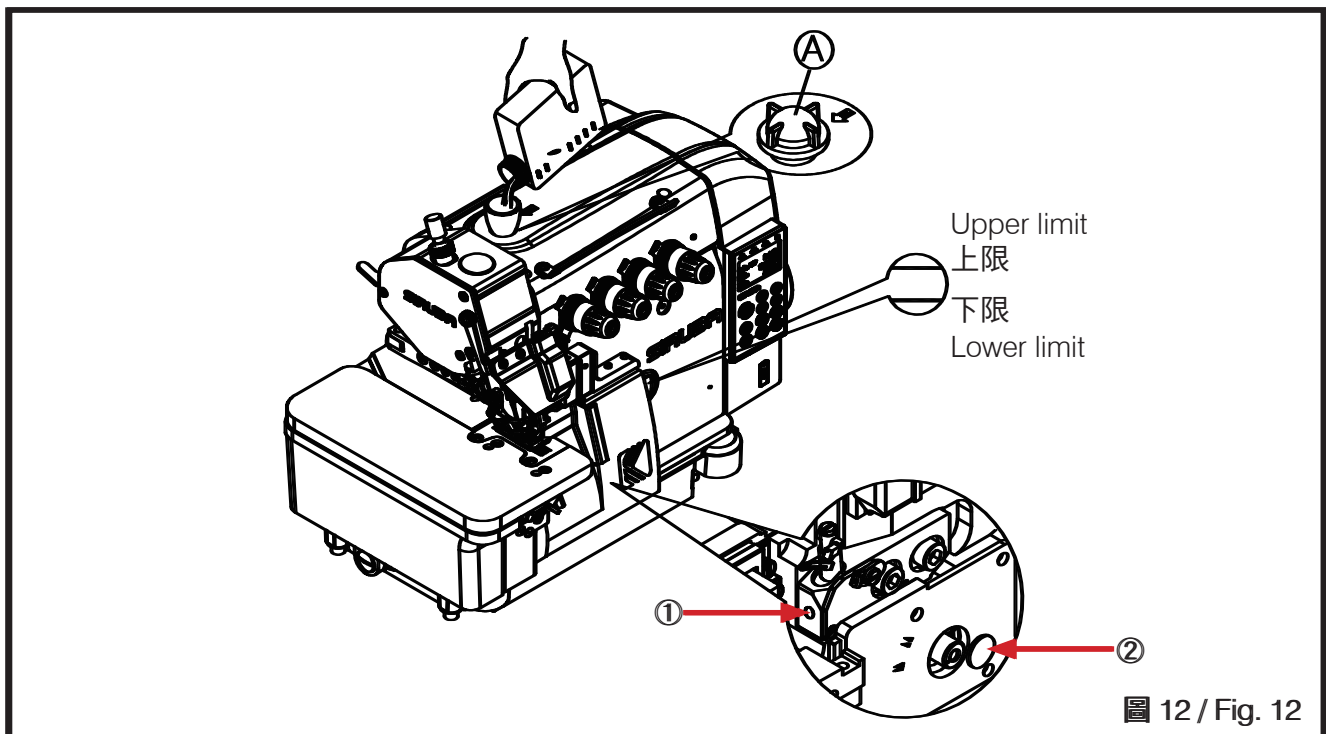
## LUBRICATION AND DRAINAGE

### 1. 潤滑油之注入 (圖 12)

- (1) 將油鏡(A)旋開，以包裝箱內所附之超高速潤滑油或選用 ESSO#32(或 MOBIL#10) 等相當之機油加入，使油量指示桿位於油標上下之間即可，然後再鎖緊油鏡(A)。
- (2) 通過①和②的尖端補充專用油脂(物料編號：C25114)，為有效確保機器的平穩運行，定期補充潤滑脂(每隔 1~2 年一次)。

### 1.Fill the lubrication oil (Fig.12)

- (1)Remove the oil level inspection leng (A) and fill it with the attached ultra high speed lubricating oil, or choose ESSO#32 (or MOBIL #10)or equivalent. Tighten the oil level inspection leng (A) after the oil level indicator locates between the two marking lines.
- (2)Replenish grease( Part No. C25114) by means of a tip of ① & ② the like, In order to effective to ensure smooth operation of the machine, periodical replenishment of the grease. (once every 1~2 years).



## 2. 潤滑油之更換 (圖 13)

- (1) 將螺絲Ⓑ放鬆旋開，使油槽內的油完全排出後再將螺絲Ⓑ鎖緊。
- (2) 為延長本機器之壽命，請於開始使用後四個星期更換新油，爾後約每四個月更換一次。
- (3) 為延長本機器之壽命，特別裝有濾油器之機構，請在每使用一個月後卸下清洗乾淨，必要時得換新品。

## 2. Drainage and refill the oil : (Fig. 13 )

- (1) Loosen the screw Ⓑ and drain all the oil inside the oil tank. Then, tighten the screw Ⓑ again.
- (2) In order to extend the term of usage, please replace the oil after the first four week, and then replace it every four months.
- (3) To extend the usage term, this machine has equipped an oil filter. Please disassemble and clean it every month, as well as change it if needed.

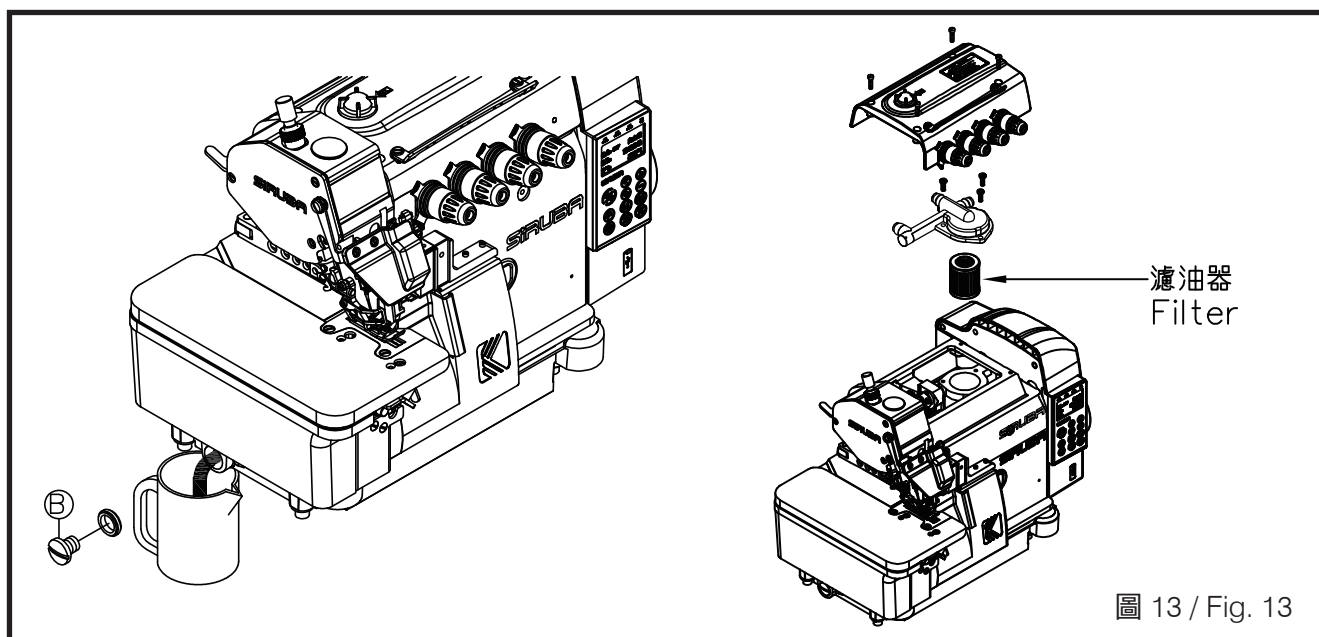


圖 13 / Fig. 13

## 3. 針之冷卻油

使用油：矽油 (SILICON OIL)。(圖 14)

## 3. Needle cooling lubrication oil: SILICON OIL. (Fig. 14 )

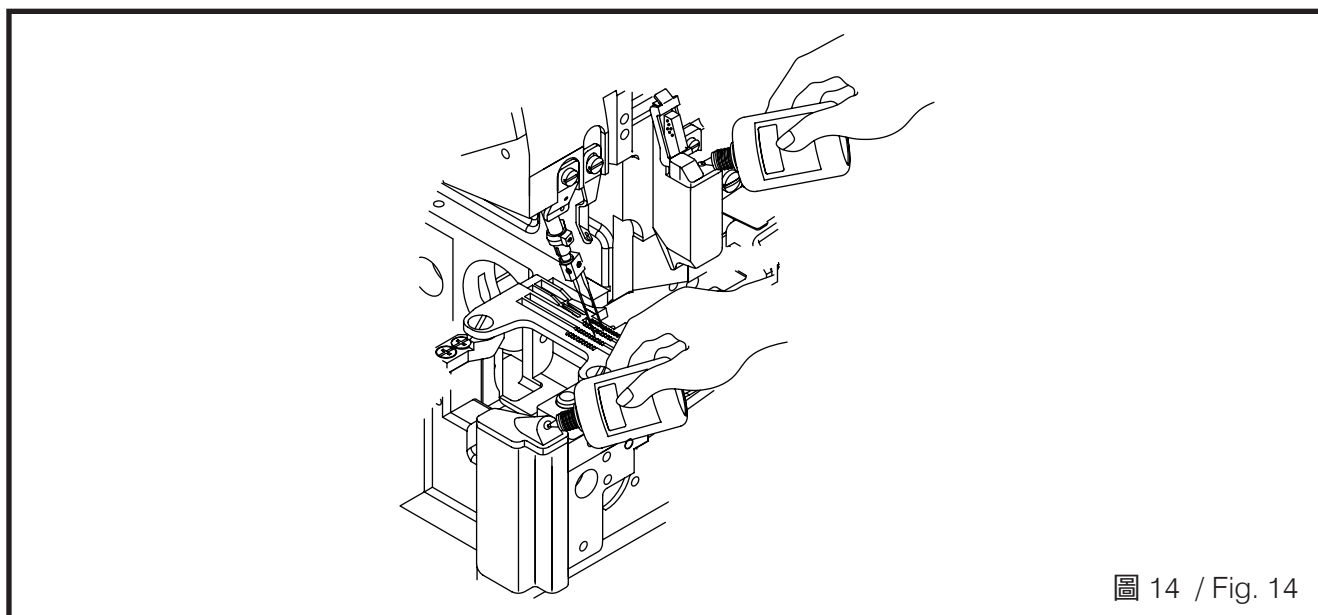


圖 14 / Fig. 14



## 穿線方式

## THREADING THE MACHINE

- 請確實按照圖示穿線，錯誤之穿線將引起斷線、跳針或車縫不平……等現象。

- Follow the procedures for threading. Wrong threading may cause thread breaking, stitch skipping or unexpected sewing.

1.737 用穿線圖 (圖 15)

1. For three thread only 737(Fig. 15)

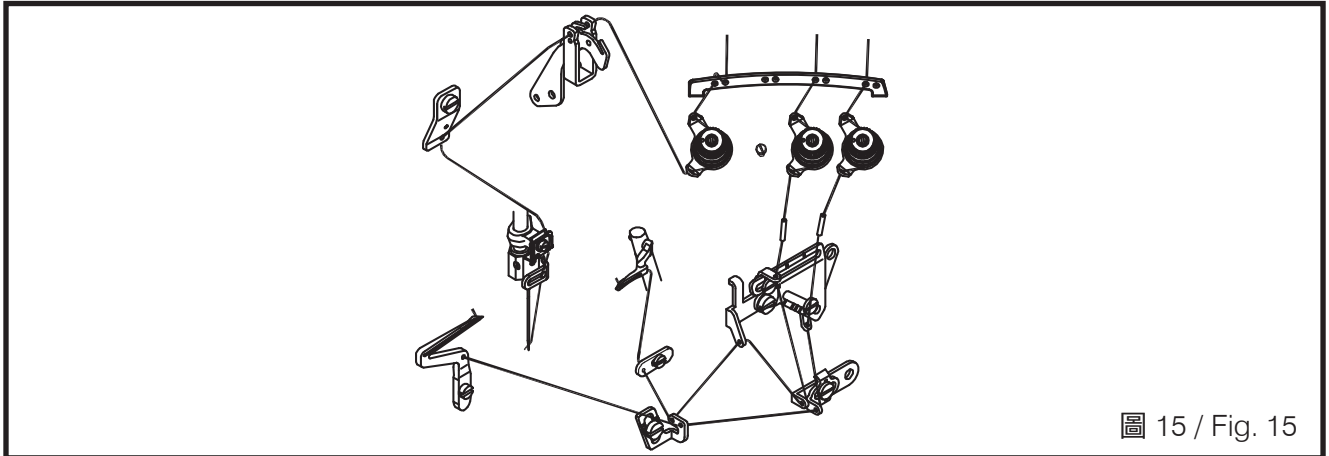


圖 15 / Fig. 15

2.747 用穿線圖 (圖 16)

2. For four thread only 747(Fig. 16)

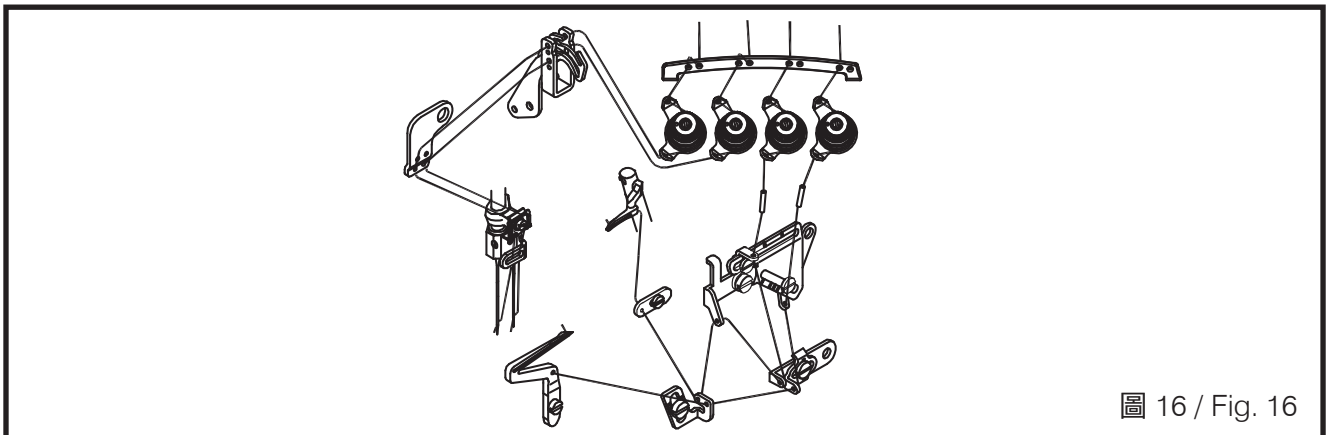


圖 16 / Fig. 16

3.757 用穿線圖 (圖 17)

3. For five thread only 757(Fig. 17)

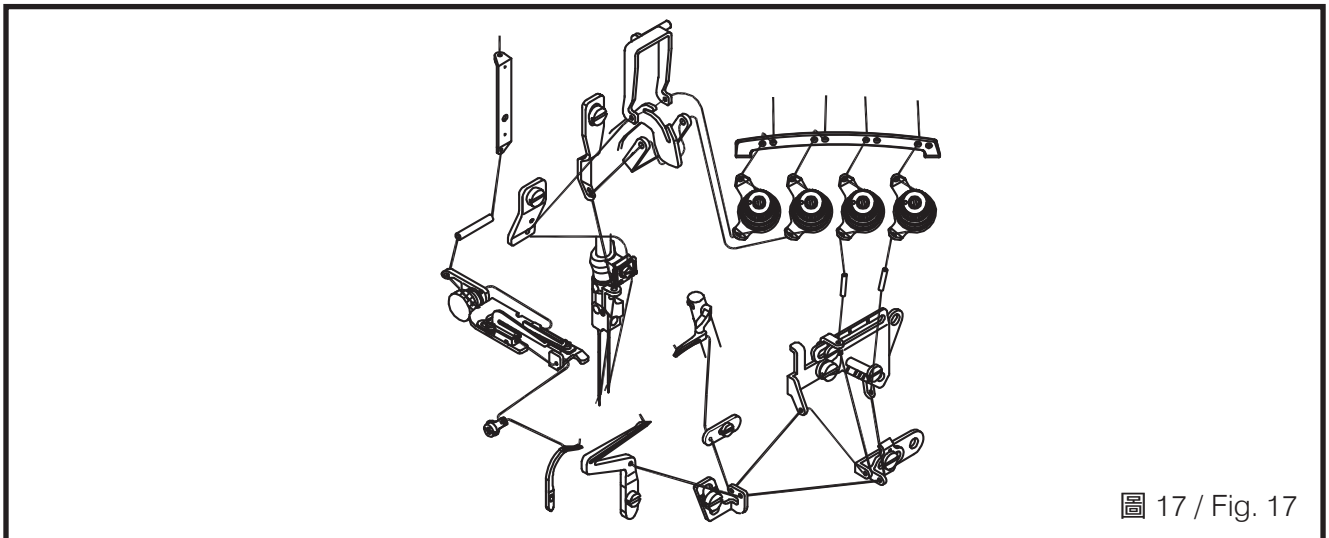
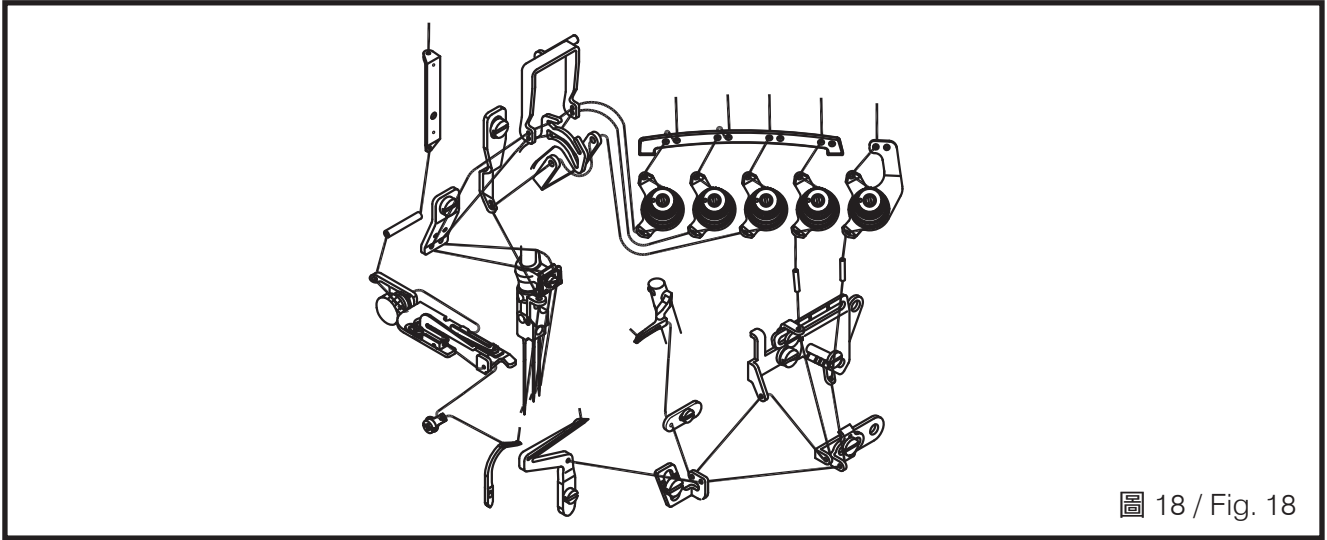


圖 17 / Fig. 17

3.767 用穿線圖 (圖 18)

3. For five thread only 757(Fig. 18)



## 控線調整

## ADJUST THREAD TENSION

線張力必須根據縫合布料種類，布料厚薄，線及包邊寬度等之差異而做不同的調整。順時針旋轉張力控制螺帽，縫線張力加大，反之減弱。

The thread tension should be adjusted properly according to the kinds and the thickness of the materials, stitch length, and seam width, etc. In addition, adjust the nuts case by case individually. Turn the nuts clockwise will increase the thread tension. Otherwise, the thread tension will be decreased.

1. 調整鈕之控線關係。(圖 19)

(1) 調整鈕①控制雙環針線或左邊拷克線。

(2) 調整鈕②控制包邊針線。

(3) 調整鈕③控制上勾針線。

(4) 調整鈕④控制下勾針線。

(5) 調整鈕⑤控制雙環勾針線。

1. Thread tension adjusting nuts. (Fig.19)

(1)The first adjusting knob ① controls double chain stitch threads or the left over-lock needle thread.

(2)The second adjusting knob ② controls the seam lock needle thread.

(3)The third adjusting knob ③ controls the seam lock needle thread.

(4)The fourth adjusting knob ④ controls the lower looper thread.

(5)The fifth adjusting knob ⑤ controls the lower looper thread.

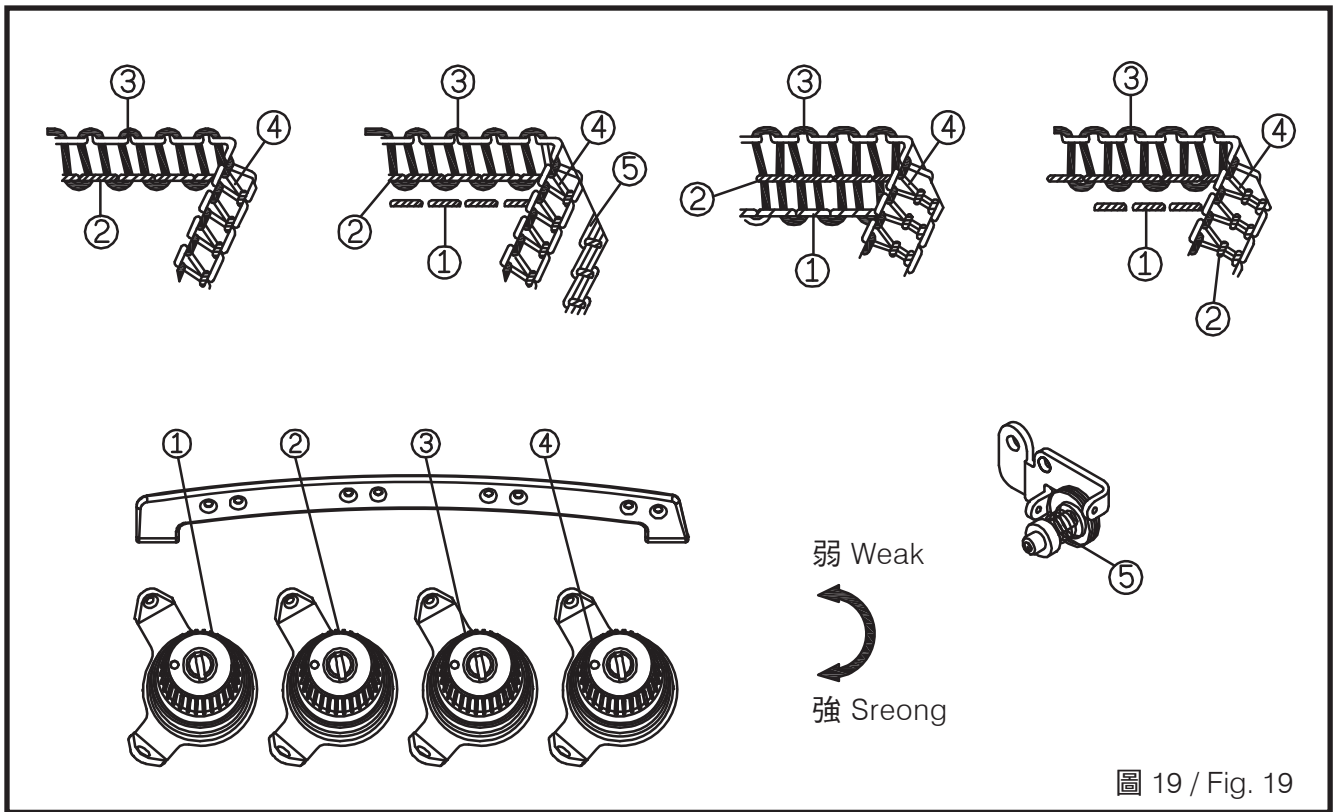


圖 19 / Fig. 19

2. 針線控線關係 (圖 20)

- (1) 縫合方式 504、512、514 時，將過線組件 ⑥ 移至最下端，縫合方式 516 時，則將過線組件 ⑦、⑧ 移至最上端。
- (2) ⊕ 表示增加針線放線量。
- (3) ⊖ 表示減少針線放線量。

2. Needle thread control. (Fig. 20)

- (1) When the sewing type is set to 504, 512 or 514, move the threading part ⑥ to the lowest part. When the sewing type is 516, move the threading part ⑦ and ⑧ to the highest point.
- (2) The ⊕ direction indicates to increase the length.
- (3) ⊖ means to decrease the needle thread length.

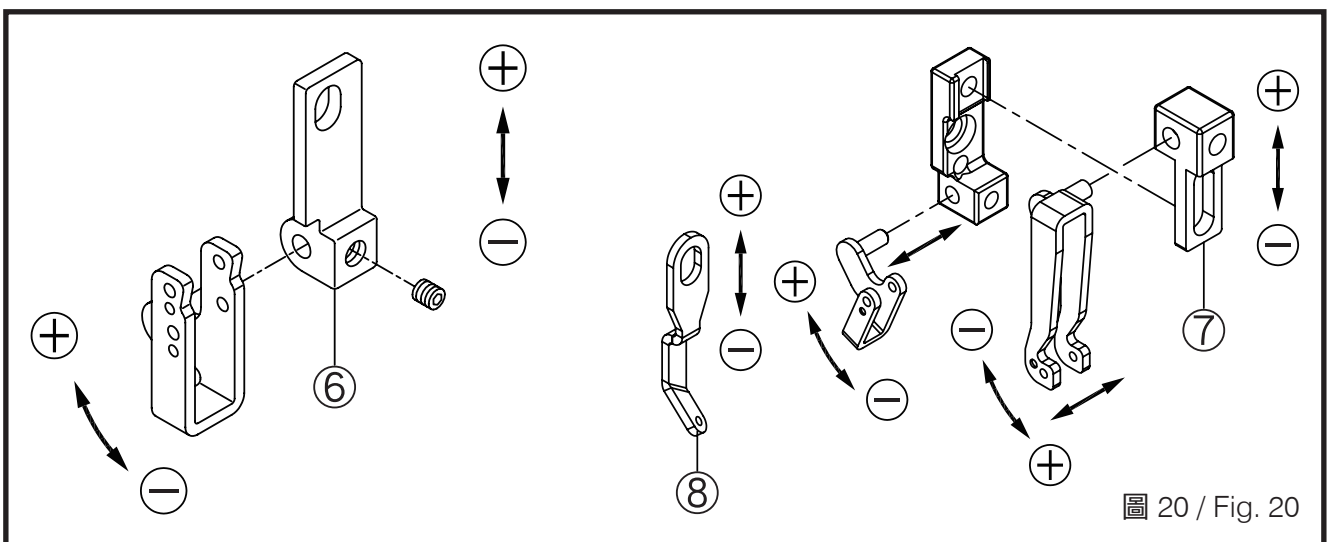


圖 20 / Fig. 20

### 3. 勾針控線關係 (圖 21)

- (1) 若縫合方式 504，上勾針移至最低時，將 ⑨ 及 ⑩ 調至 ⊕ 位置。
- (2) 固定線導板 ⑪、⑫ 如下：  
⊕ 方向為縫合線較多，⊖ 反之較少。

### 3. Looper thread control.( Fig. 21)

- (1) When the sewing type is 504 and the upper looper is on the lowest point, adjust ⑨ and ⑩ at the position of ⊕.
- (2) Adjust fixed thread guide plate ⑪ and ⑫ as the following: The direction ⊕ is for more thread in sewing seam, and the ⊖ direction is for less thread in sewing seam.

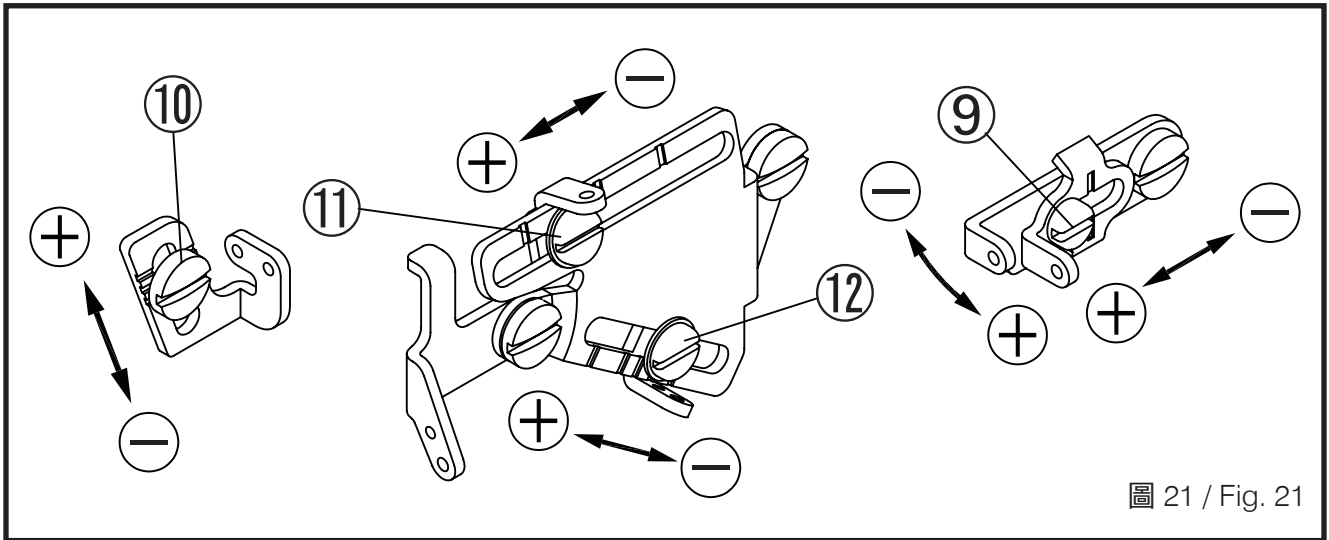


圖 21 / Fig. 21

### 4. 環縫線凸輪控線關係 (圖 22)

- (1) 調整底線導致線環不穩定 (鬆塌或成形不足) 時。
- (2) ⊕ 表示增加針線放線量。
- (3) ⊖ 表示減少針線放線量。

### 4. Chainstitch thread cam control .( Fig.22)

- (1) Adjusting the lower thread causes the thread ring unstable (too loose or didn't form a thread ring).
- (2) ⊕ means to have more thread amount while sewing.
- (3) ⊖ means to have less thread amount while sewing.

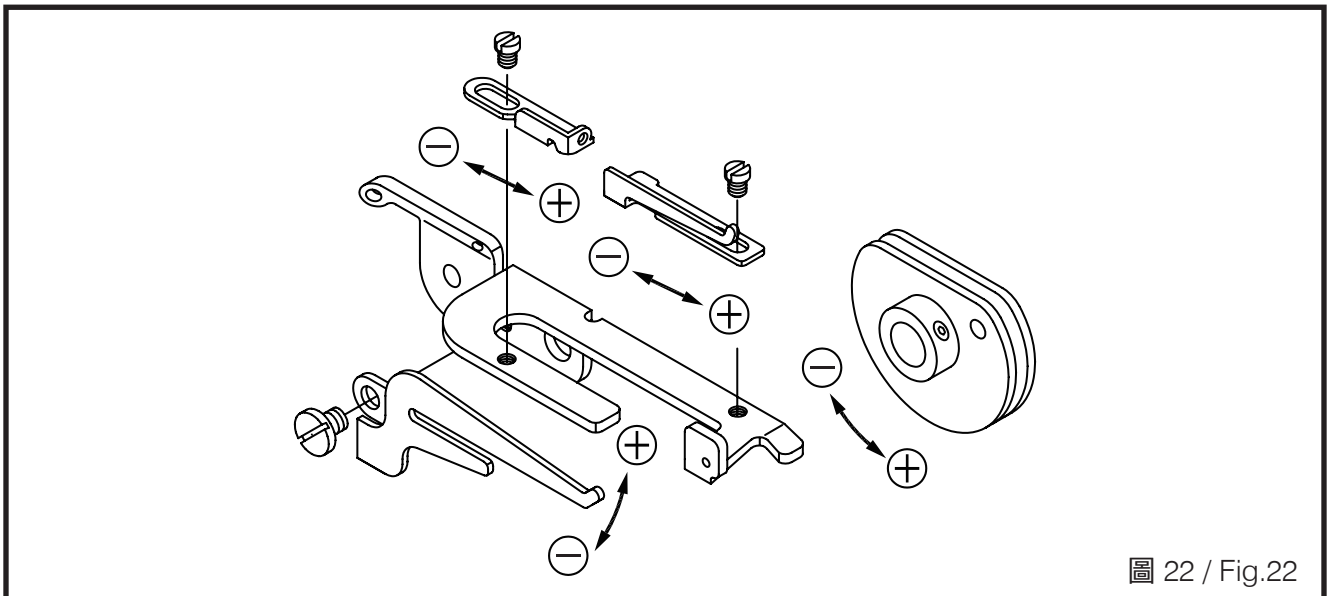


圖 22 / Fig.22

## 換針方式

1. 使用 DCX27 或同規格之針。
2. 旋開螺絲 ① 並取下針。
3. 將新針插至針孔最底端，並使針之溝面向自己，固定螺絲 ①。(圖 23)

## REPLACE THE NEEDLE

1. Please use the needle DCX27 or the equivalents.
2. Loosen the screw ① and take off the needle.
3. Insert the new needle till reaching the end, as well as the long groove faces your side. Tighten the screw ①. (Fig.23)

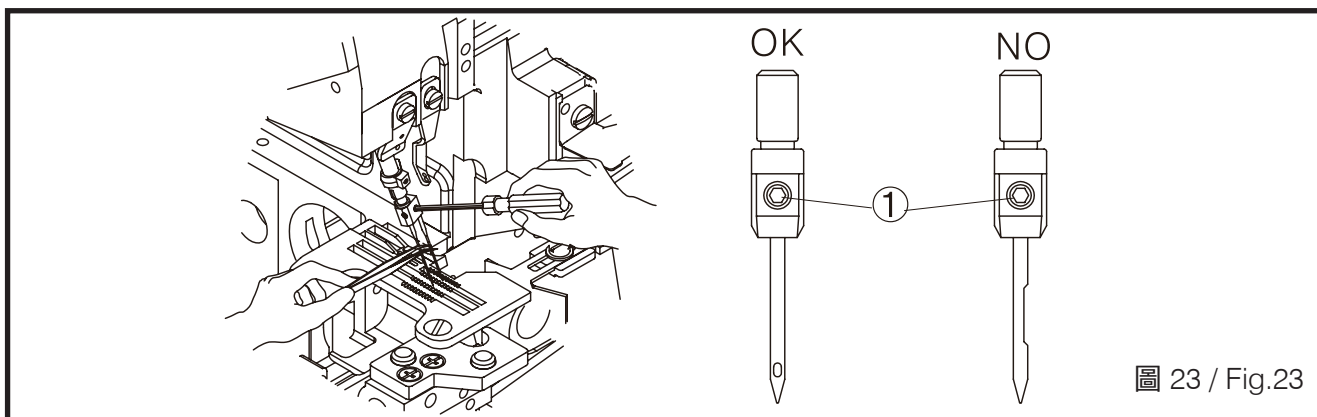


圖 23 / Fig.23

## 針距調整

- 通常依據車縫布料，差動比等之不同而調整。持續壓下按鈕 ① 並轉動手輪使按鈕卡住，再轉動手輪至所需之針距後放開此按鈕。(圖 24)(表 2)

## ADJUST THE STITCH LENGTH

- The stitch length is adjusted according to the fabrics, the differential ratio or other factors. Keep pressing the button ① and turn the pulley till the button is locked. Then, release the button after reaching the desired stitch length.( Fig.24)(Tab.2)

最大差動比 Maxi Diff ratio	機種 Machine type	皮帶輪刻度 Pulley scale						
		1	2	3	4	5	6	7
1:2	接縫 Seaming	0.6	1.13	1.66	2.19	2.72	3.25	3.8
1:3	摺縫 Shirring	0.6	1.03	1.46	1.89	2.32	2.71	3.2
1:1.3	包邊 Serging	0.8	1.5	2.2	2.9	3.6	4.3	5
1:4	特規 Special	0.6	1.02	1.44	1.66	2.28	2.7	-

表 2 / Tab.2

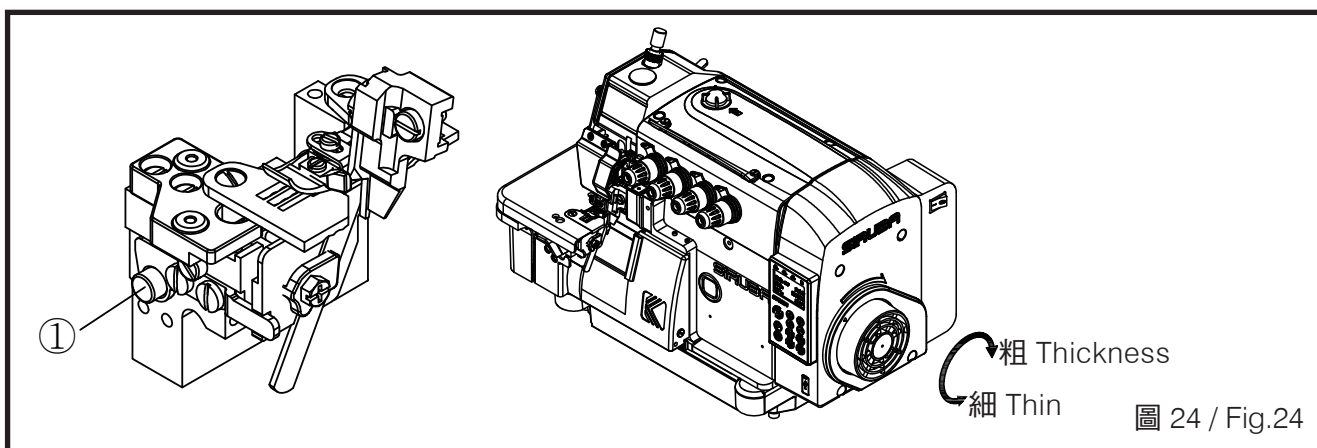


圖 24 / Fig.24

## 差動比調整

## ADJUST THE DIFFERENTIAL FEED RATIO

若主送具之運動行程大於差動送具運動行程時，布料車縫時會伸張，反之則會收縮。

If the stroke of the main feed dog is larger than the stroke of the differential feed dog, the fabric will be extended while sewing. Otherwise, it will be shrunk.

### 1. 調整方法一：

為放鬆調整鈕 ①，當調整桿 ② 向下調整時使布料收縮，反之則伸張，調整後再鎖調整鈕 ①。(圖 25)(表 3)

### 1.Adjust solution 1:

Loosen the adjusting nut ①. Adjust the adjusting rod ② downward will shrink the fabric, whereas move it upward will extend the fabric. Tighten the adjusting nut ① after the adjustment finishes. (Fig.25)(Tab.3)

刻度 Scale		1	2	3	4	5
差動傳送比 Differential feed ratio	1:1.3	-	1:0.7	1:0.9	1:1.1	1:1.3
	1:2	1:0.7	1:1	1:1.14	1:1.17	1:2
	1:3	1:1	1:1.5	1:2	1:2.5	1:3
	1:4	1:1.1	1:1.6	1:2.3	1:2.3	1:3.3

表 3 / Tab.3

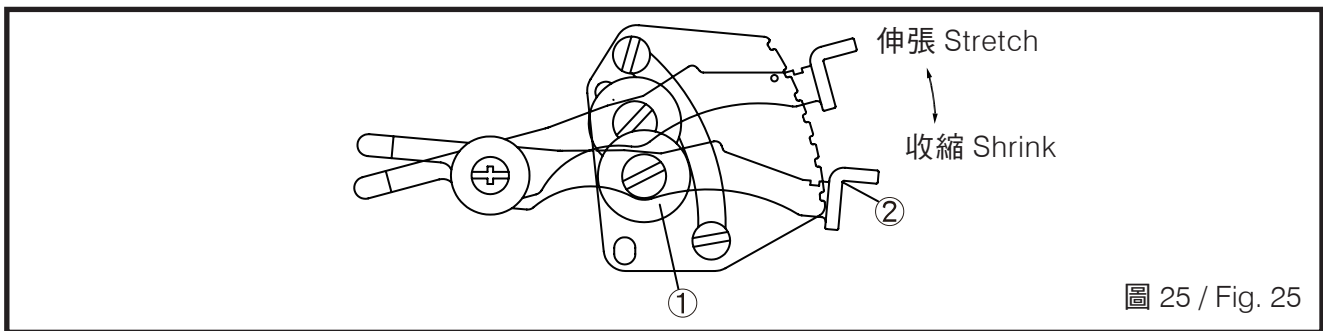


圖 25 / Fig. 25

### 2. 調整方法二：

- (1) 鬆開螺絲 ③ 並從機台後方移開外蓋 ④。
- (2) 鬆開螺帽 ⑤，上下移動連桿 ⑥  
欲增加差動比，把連桿⑥往 (+) 方向移動  
欲減少差動比，把連桿⑥往 (-) 方向移動。
- (3) 在調整過後，把外蓋 ④ 放回機台後方並鎖回螺絲③。(圖 26)

### 2.Adjust solution 2:

- (1) Loosen the screw ③ and remove the cover ④ from the rear side of the machine bed.
- (2) Loosen the nut ⑤, and move the connecting rod ⑥ upward and downward. To increase the differential feed ratio, move the connecting rod ⑥ to (+) direction. To decrease it, move the connecting rod ⑥ to (-).
- (3) After adjusting, put the cover ④ back to the rear of the machine bed and tighten the screw ③.(Fig.26)

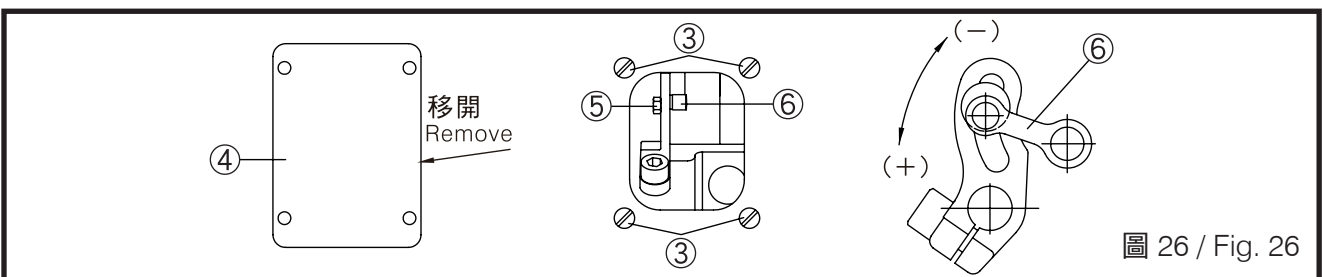


圖 26 / Fig. 26

## 更換切刀

### 1. 更換上切刀

- (1) 放鬆螺絲①將下刀座②向左邊推，輕鎖螺絲①。
- (2) 取下螺絲③換上新刀片後，輕輕鎖緊螺絲③。
- (3) 轉動皮帶輪使上刀移至下死點，調整上刀高低使上刀與下刀相交約 0.5~1.0mm，鎖緊螺絲。
- (4) 放鬆螺絲①使下刀座還原位置，並試驗上下刀能確實剪斷車縫線，鎖緊螺絲①。

### 2. 更換下切刀

- (1) 放鬆螺絲①將下刀座②向左邊推，輕鎖螺絲。(圖 27)
- (2) 放鬆螺絲④取下舊刀換上新刀。
- (3) 調整下刀之刀口與針板面平齊後，鎖緊螺絲④。
- (4) 放鬆螺絲①使下刀座還原位置並試驗上下刀能確實剪斷車縫線，鎖緊螺絲①。(圖 27)

## REPLACE THE TRIMMERS

### 1. Replace the upper trimmer:

- (1) Loosen the screw ① and move the lower trimmer holder ② to the left. Then, tighten the screw ① a little.
- (2) Remove the screw ③ and put the new trimmer. Then, tighten the screw ③ a little.
- (3) Turn the pulley to move the upper trimmer to the lower dead point. Adjust the height of the upper trimmer so that the upper trimmer can cross the lower trimmer about 0.5 ~ 1.0 mm. After that, tighten the screw .
- (4) Loosen the screw ① and return the lower trimmer to its original position. Test if the upper and the lower trimmer can cut the thread exactly, and then tighten the screw ①.

### 2. Replace the lower trimmer:

- (1) Loosen the screw ① and move the lower trimmer holder ② to the left. Then, tighten the screw ① a little. (Fig. 27)
- (2) Loosen the screw ④. Take off the trimmer and replace a new one.
- (3) Adjust the edge of the lower trimmer to be align with the surface of the needle plate. Then, tighten the screw ④.
- (4) Loosen the screw ① to return the lower trimmer holder to its original position and test if the upper and the lower trimmer can cut the thread exactly. Then, tighten the screw ①. (Fig. 27)

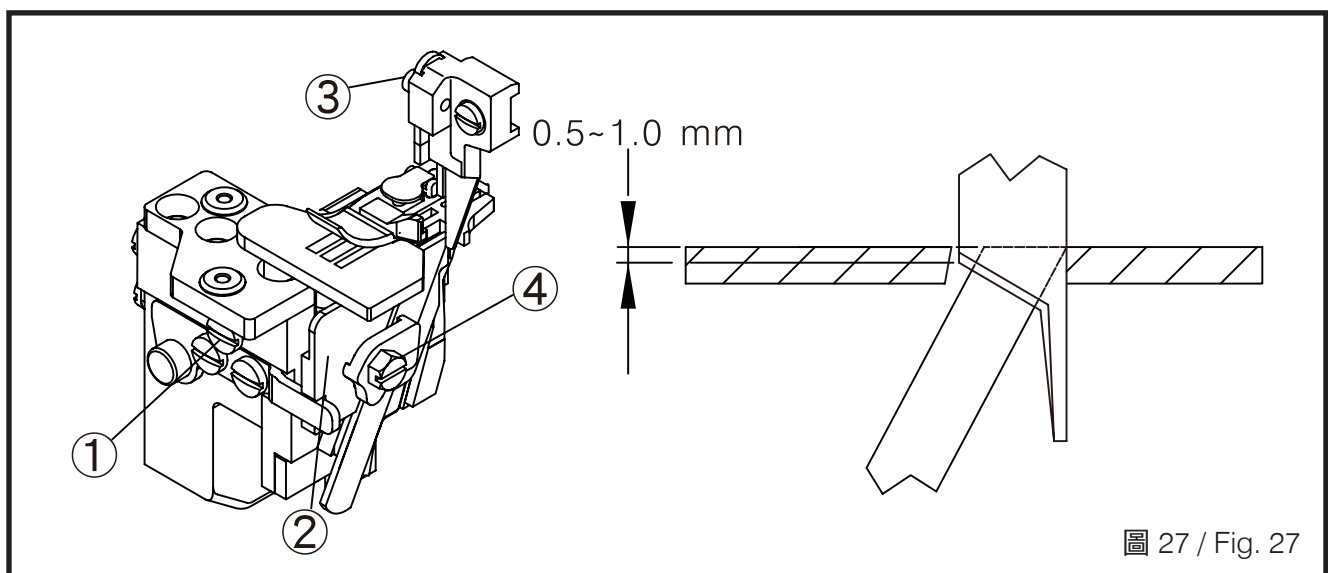


圖 27 / Fig. 27

## 包邊寬度調整

1. 轉動手輪，將上刀移至下死點。(圖 28)
2. 放鬆螺絲①，向左移動下刀座疊②後，暫時輕鎖螺絲①。
3. 放鬆螺絲③，移動上刀座向左或向右，直到達到所要的包邊寬度後再鎖緊螺絲③。
4. 放鬆螺絲①，使下刀座②位置還原，並測試能切斷車縫線後，鎖緊螺絲①。

## ADJUST THE HEM WIDTH

1. Turn the pulley to move the upper trimmer to the lower dead point. (Fig.28)
2. Loosen the screw ① and move the lower trimmer holder ② to the left, and then tighten the screw ① a little.
3. Loosen the screw ③ and move the upper trimmer holder left or right till reaching the desired width. Then, tighten the screw ③.
4. Loosen the screw ① to return the lower trimmer holder ② left or right till reaching the Test if the trimmers can cut the thread, and then tighten the screw ① .

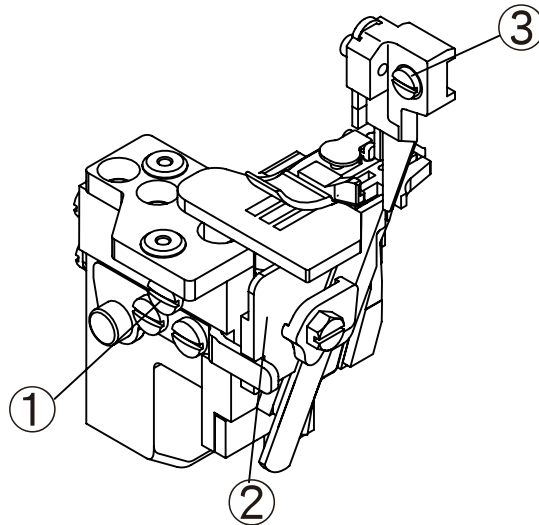


圖 28 / Fig. 28



## 針高度之調整

1. 轉動手輪使針上昇至最高點時，針尖至針板面之距離為 (a)。(圖 29)
2. 調整：
  - (1) 打開上蓋①。
  - (2) 放鬆螺絲②，移動針棒至所需高度鎖緊螺絲②。
  - (3) 放回上蓋①須密合鎖緊。

## ADJUST THE NEEDLE HEIGHT

1. The (a) is the distance from the needle tip to the surface of the needle plate when the needle is risen to the highest point after turning the pulley.(Fig.29)
2. Adjustments:
  - (1) Open and remove the upper cover ① .
  - (2) Loosen the screw ②, and move the needle bar to the desired height. Then, tighten the screw ② .
  - (3) Put the upper cover ① back, and seal it.

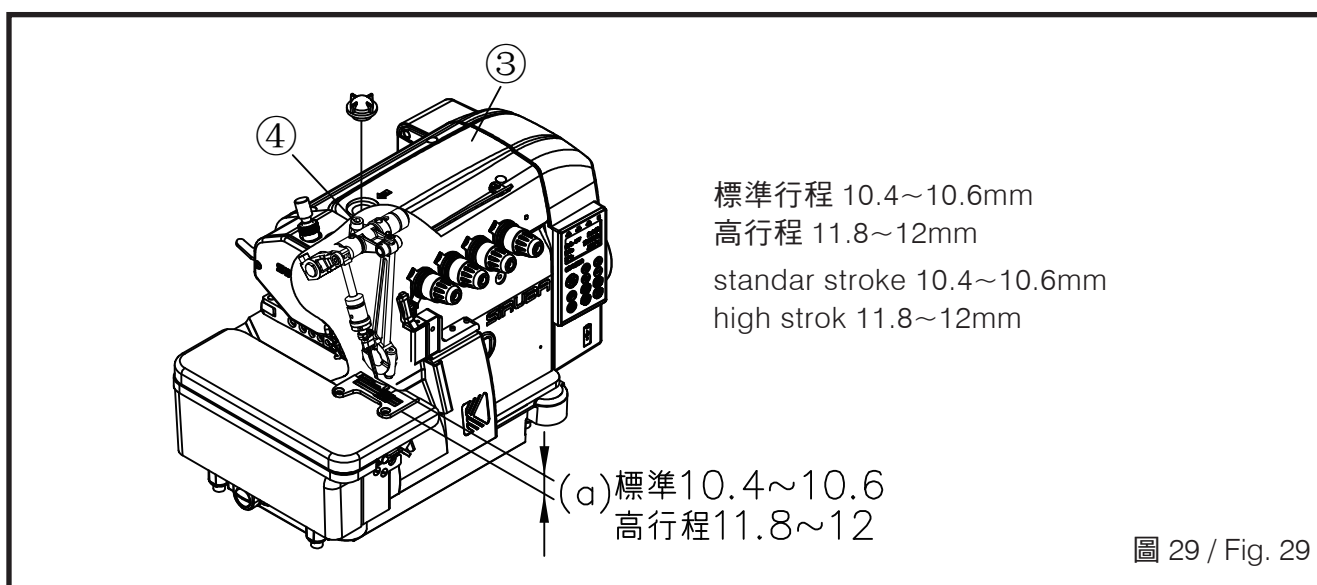


圖 29 / Fig. 29

## 押具調整

1. 押具位置調整
  - (1) 放鬆押具壓力①及押具螺絲⑦。
  - (2) 移動押具⑥使其押具槽與針板之針槽一致押具底平壓於針板上，鎖緊螺絲⑦。
  - (3) 放鬆螺絲⑤左右移動④，使③與②吻合，且②能上下活動輕順，鎖緊螺絲⑤。
  - (4) 調整適當壓力，螺絲①順時針方向旋轉，壓力加大，反之減弱。(圖 30)

## ADJUST THE PRESSER FOOT

1. Adjust the presser foot position.(Fig.30)
  - (1) Release the pressure spring ① of the presser foot and the screw ⑦ of the presser foot.
  - (2) Move the presser foot ⑥ so that the groove of the presser foot can align with the groove of the needle plate. Also, the bottom of the presser foot can stand on the needle plate flatly, and then tighten the screw ⑦ .
  - (3) Loosen the screw ⑤ , and move ④ left and right so that ③ can match ② and ② can move upward and downward smoothly. Then, tighten the screw ⑤ .
  - (4) To adjust to a proper pressure: turn the screw ① clockwise will increase the pressure, where as turn it counter clockwise will decrease the pressure.

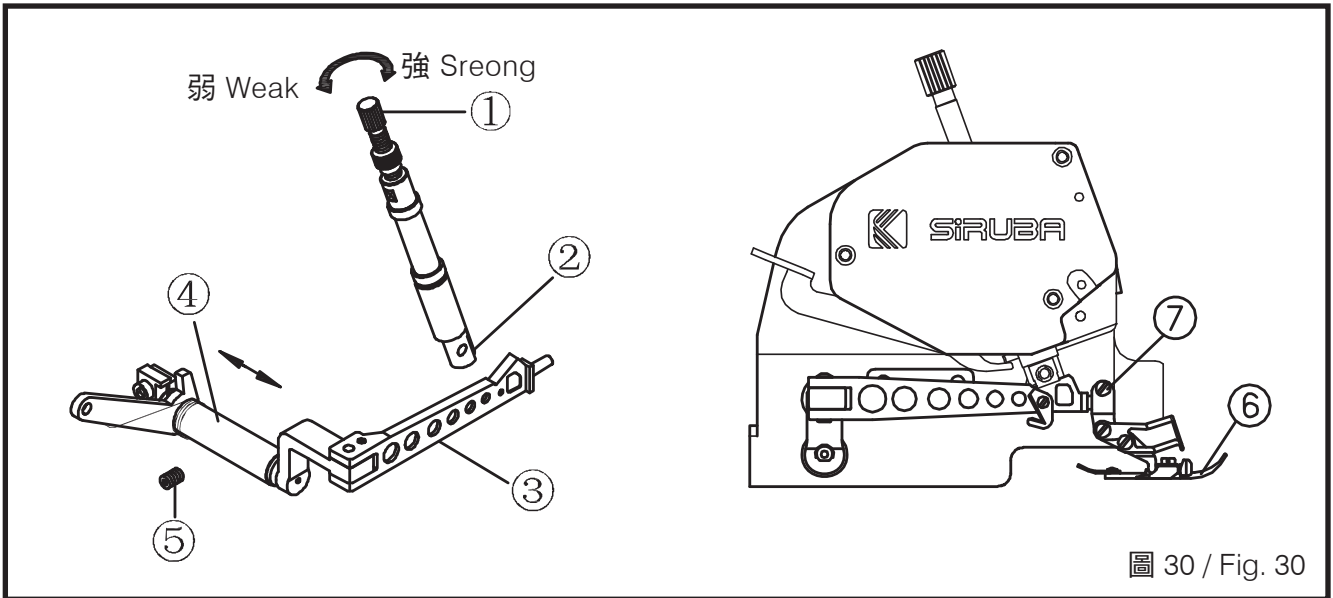


圖 30 / Fig. 30

## 2. 押具提升量調整

- (1) 轉動手輪使送具降至針板下，押具底平貼針板。
- (2) 放鬆螺帽④，壓下拉桿⑥使押具上昇至適當位置約 5.0~5.5mm，調整螺絲⑤及固定螺帽④。
- (3) 拉桿①與固定座②須保持有 1mm 的間隙可輕輕放鬆螺絲③調整。
- (4) 要確實鎖緊螺絲③。(圖 31)

## 2. Adjust the lift amount of the presser foot.

- (1) Rotate the pulley to move the feed dog downward until the feed dog is under the needle plate, as well as the bottom of the presser foot touches the needle plate flatly.
- (2) Loosen the nut ④, push down the lever ⑥ to arise the presser to the appropriate position, around 5.0 ~5.5mm. Adjust the screw ⑤ and fix the nut ④.
- (3) There should be a clearance of 1mm between the pull rod ① and the fixed bracket ②, which can be adjusted by loosening the screw ③ slightly.
- (4) After all the adjustments above please tighten the screw ③.(Fig.31)

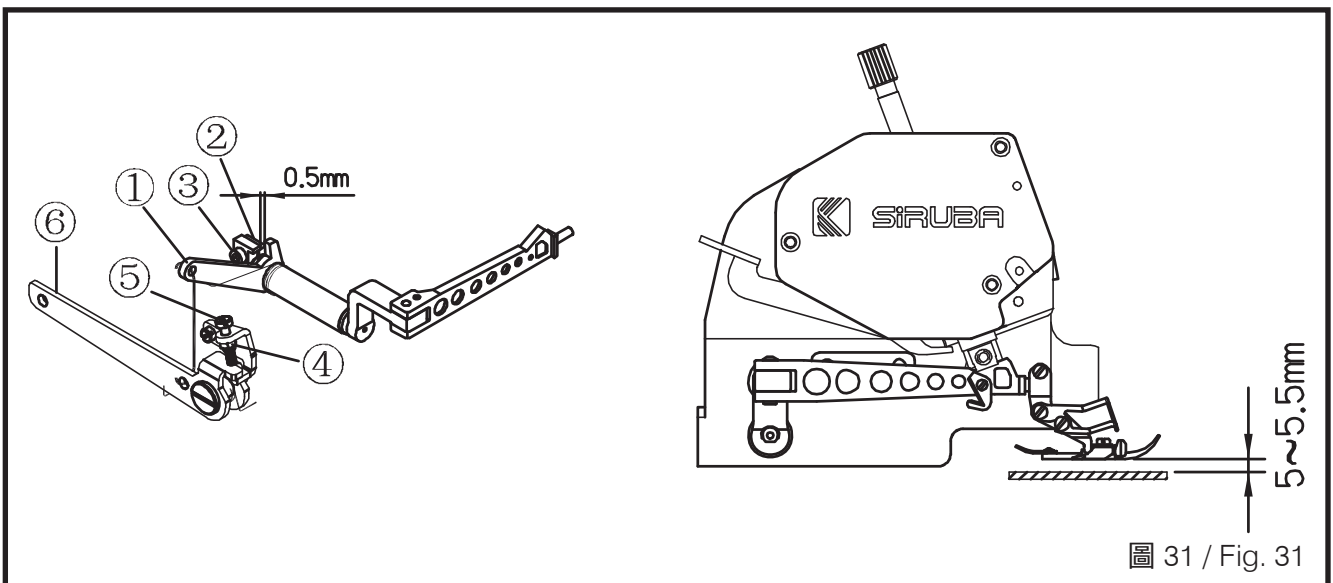


圖 31 / Fig. 31

## 送具調整

### 1. 送具高度調整

- (1) 轉動手輪使送具上升至針板上最高點。
  - (2) 放鬆螺絲①，上下移動主送具②，使其齒面高出針板面約 0.9~1.1mm，鎖緊螺絲①。
  - (3) 放鬆螺絲③，上下移動差動送具④，使其齒面高出針板面約 0.9~1.1mm 鎖緊螺絲③。
- (圖 32)

## ADJUST THE FEED DOG

### 1. Adjust the feed dog height.

- (1) Rotate the pulley to rise the feed dog the highest point of the needle plate.
- (2) Loosen the screw ①, and move the main feed dog ② up and down in order to keep the teeth side over the needle plate about 0.9~1.1mm. Then tighten the screw ①.
- (3) Loosen the screw ③, and move the differential feed dog ④ up and down in order to keep the teeth side over the needle plate about 0.9~1.1mm. Then, tighten the screw ③. (Fig.32)

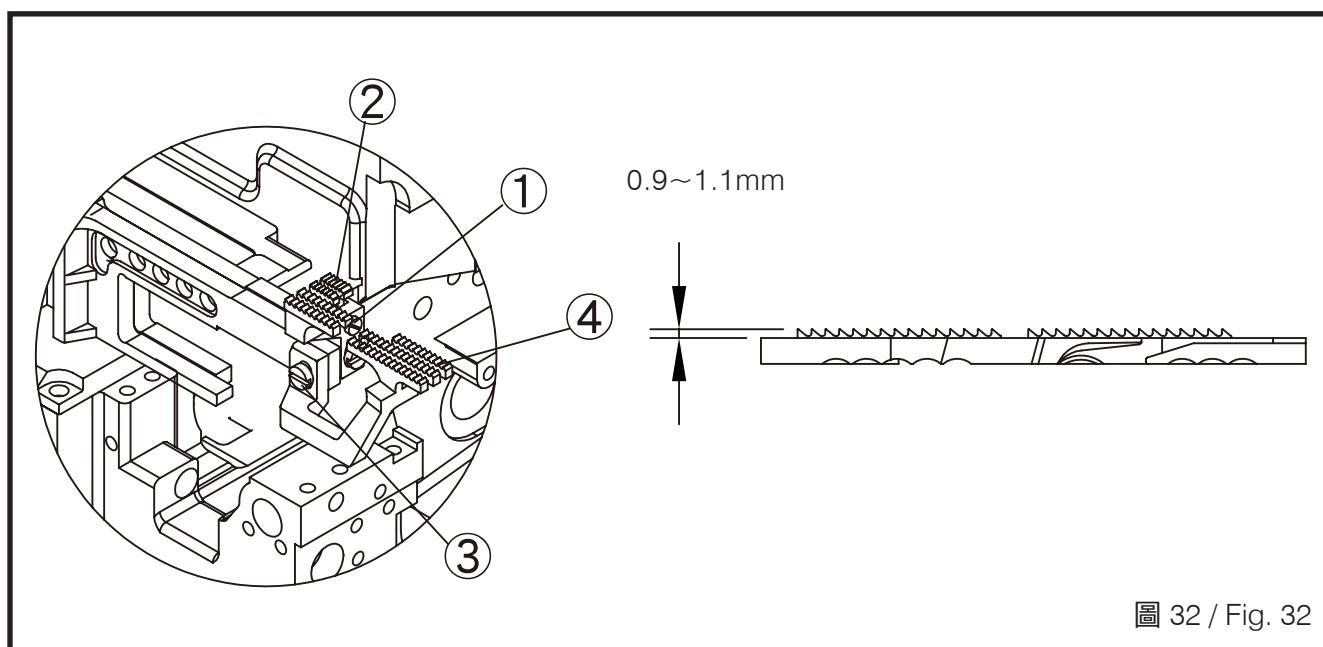


圖 32 / Fig. 32

## 2. 送具水平調整

- (1) 送具齒的齒面在運轉的循環中，必須保持針板面成水平。
- (2) 調整時放鬆螺絲⑤，旋轉後支軸⑥，齒面呈水平後固定螺絲⑤。(圖 33)

## 2. Adjust the feed dog horizontally.

- (1) During operation, the teeth side of the feed dog should keep parallel with the surface of the needle plate.
- (2) For adjustment, loosen the screw ⑤, and rotate the rear support shaft ⑥. Do not tighten the screw ⑤ until the teeth side of the feed dog is horizontal. (Fig. 33)

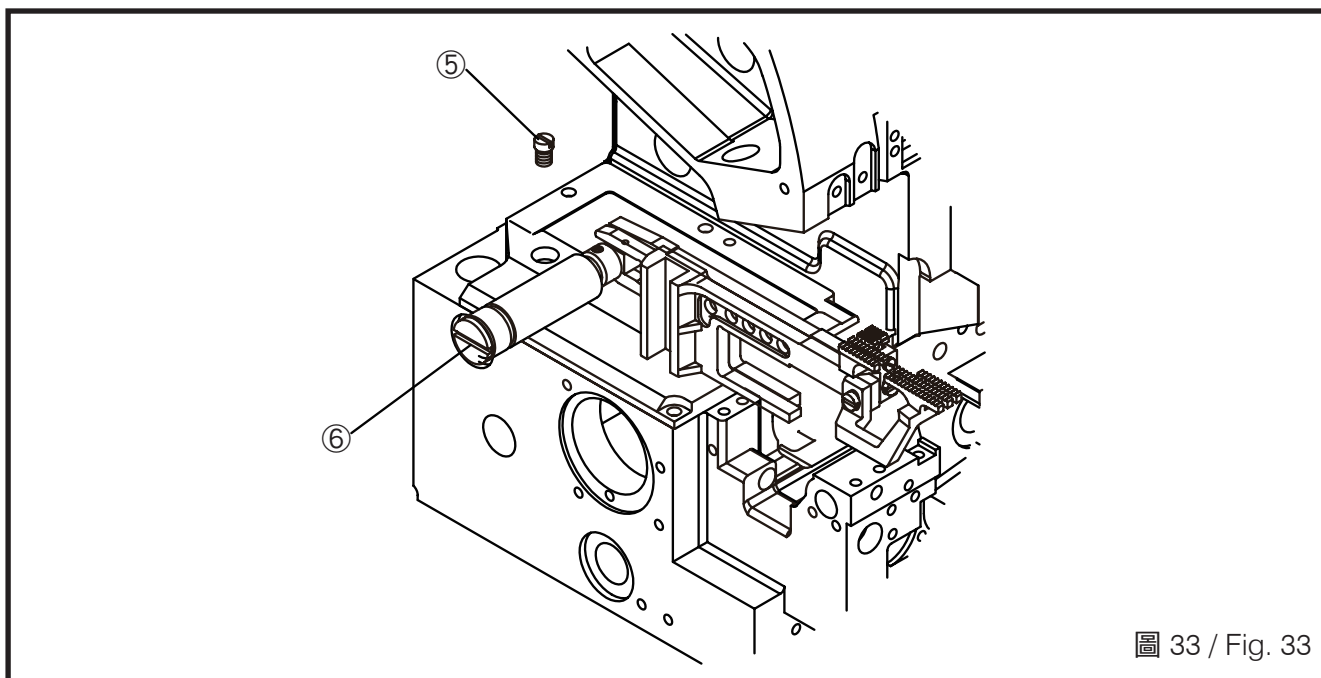


圖 33 / Fig. 33

## 3. 輔助送布齒高度

- 輔助送具⑦，其齒面比送布齒齒面低 0.3~0.5mm，可放鬆螺絲⑧來調整。(圖 34)

## 3. Adjust the auxiliary feed dog height.

- The teeth side of the auxiliary feed dog ⑦ is 0.3~0.5mm lower than the feed dog. The height can be adjusted by loosening the screw ⑧. (Fig. 34)

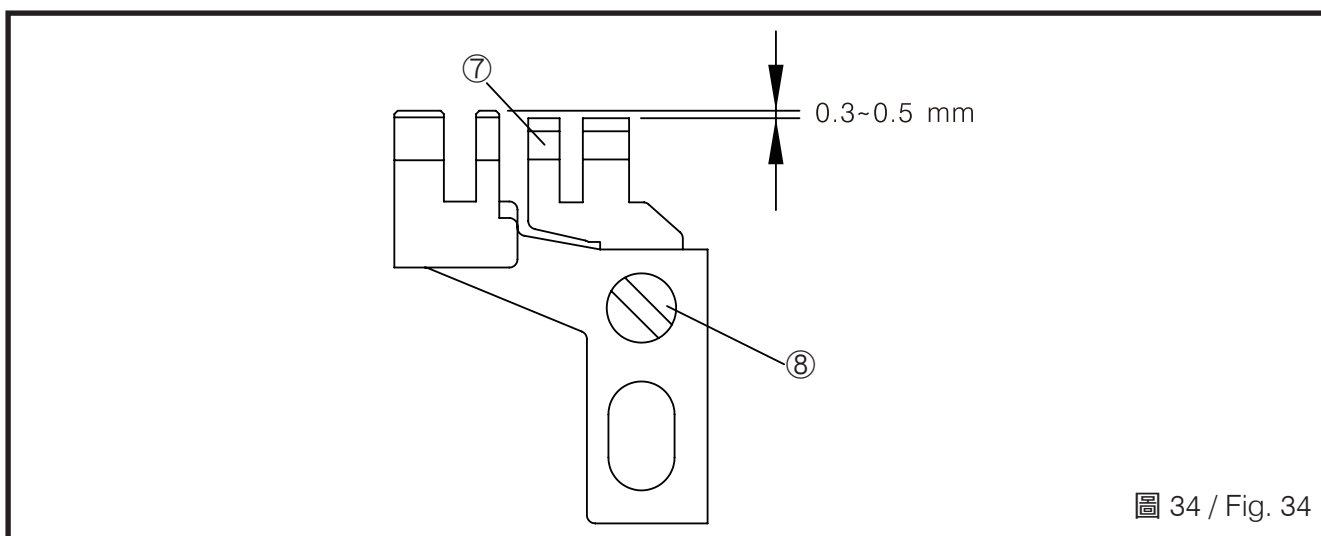


圖 34 / Fig. 34

## 針與勾針之關係

## THE RELATIONSHIP BETWEEN NEEDLE AND LOOPER

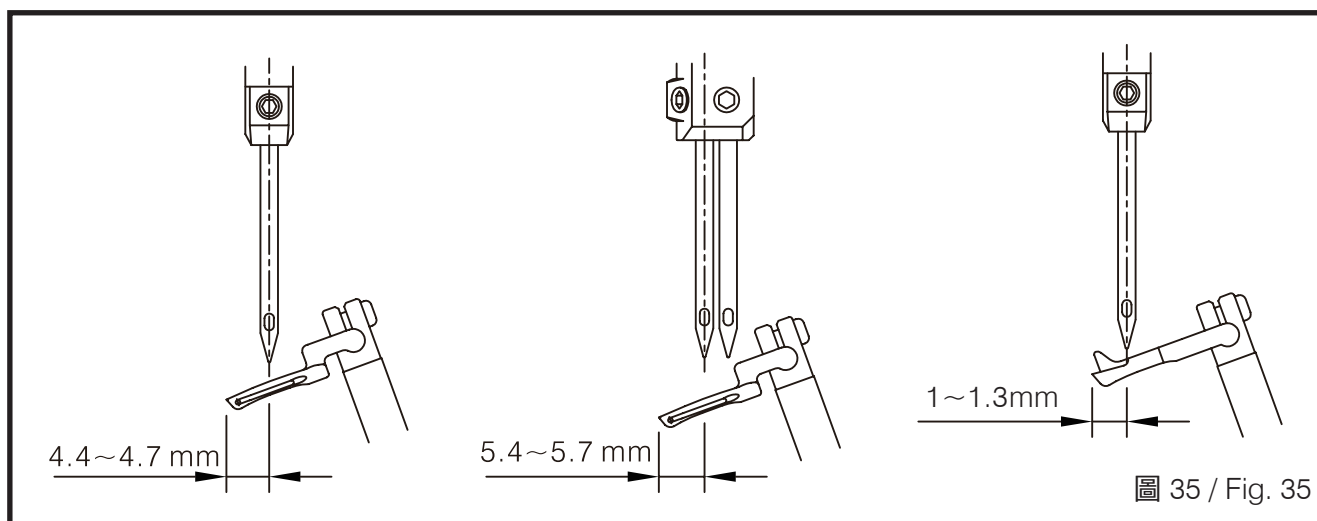
### 1. 針與上勾針之關係

當上勾針移至最左時，勾針尖端與針中心距約 4.4 ~ 4.7mm，雙針時其左針中心與勾針尖端距約 5.4~5.7mm。(圖 35)

### 1.The relationship between the needle and the

When the upper looper moves to the leftest point, the distance from the looper tip to the middle line of the needle is 4.4 ~ 4.7mm.

For double needles model, the distance from the looper tip to the middle line of the left needle is 5.4~5.7mm.(Fig.35)

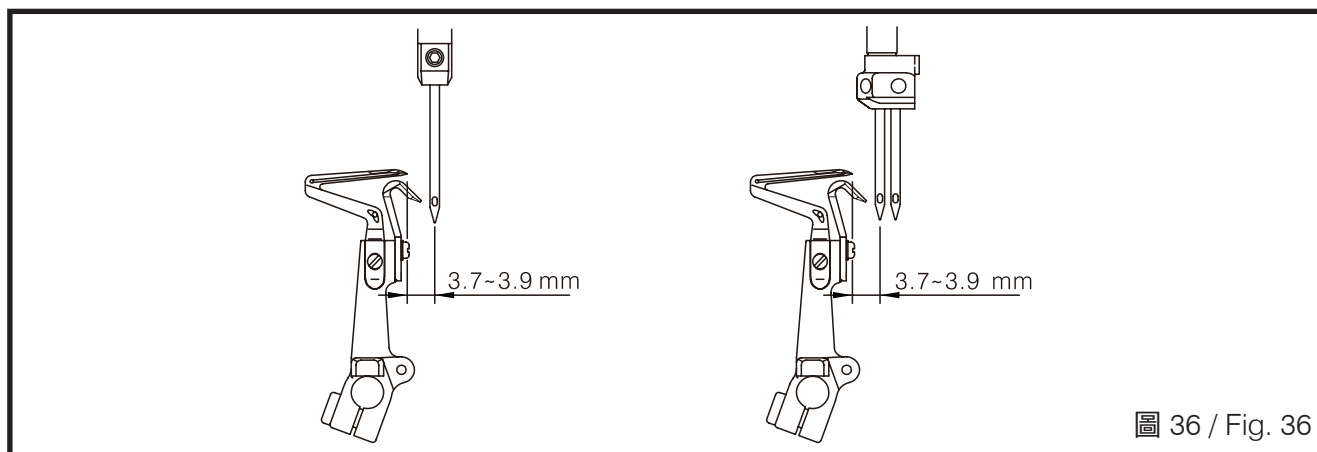


### 2. 針與下勾針之關係

(1) 當下勾針移至最左時，勾針尖端與針中心距約 3.7~3.9mm(雙針時以左針為主)。(圖 36)

### 2.The relationship between the needle and the lower looper.

(1)When the lower looper moves to the leftest point, the distance between the looper tip and the middle line of the needle should be about 3.7~3.9mm. For double needles model, the distance is from the lower looper tip to the middle line of the left needle. ( Fig.36)



- (2) 當下勾針向右移至針中心時 (雙針以左針為主) 針與勾針之間隙為 0~0.05mm。  
(圖 37)

- (2) The relationship between the needle and the middle line of the needle (use the left needle as standard when it's double needle model), the clearance between them should be 0 ~ 0.05mm. ( Fig.37)

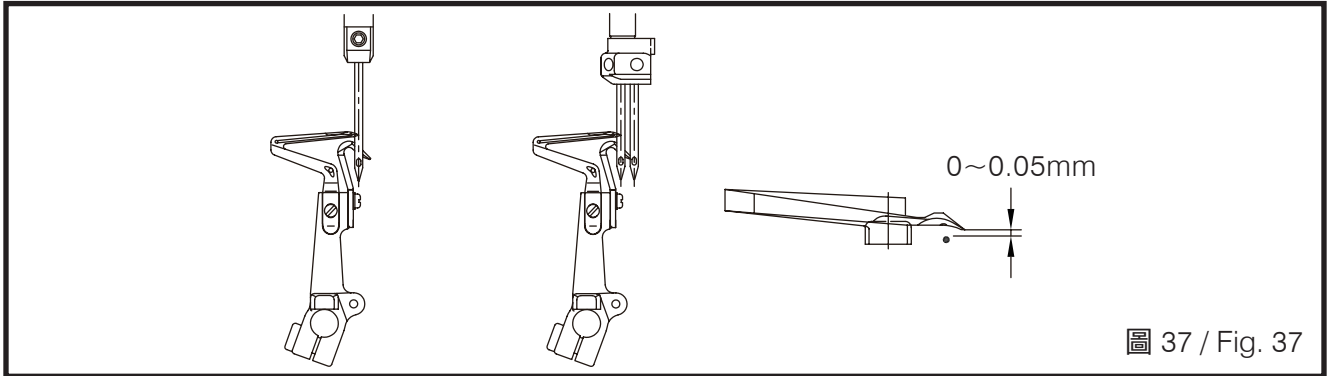


圖 37 / Fig. 37

3. 上勾針與下勾針之關係 (圖 38)  
當上下勾針相交時，兩勾針盡量接近，但不可磨擦或碰撞，其間隙 ① 點為 0.1~0.3mm  
② 點為 0.35~0.65mm。

3. The relationship between the upper looper and the lower looper. ( Fig.38)  
When the upper and the lower looper cross, keep them as close as possible. Somehow, the loopers shall not either touch or collide to each other. The clearance ① is 0.1~0.3mm, as well as the clearance ② is 0.35~0.65mm.

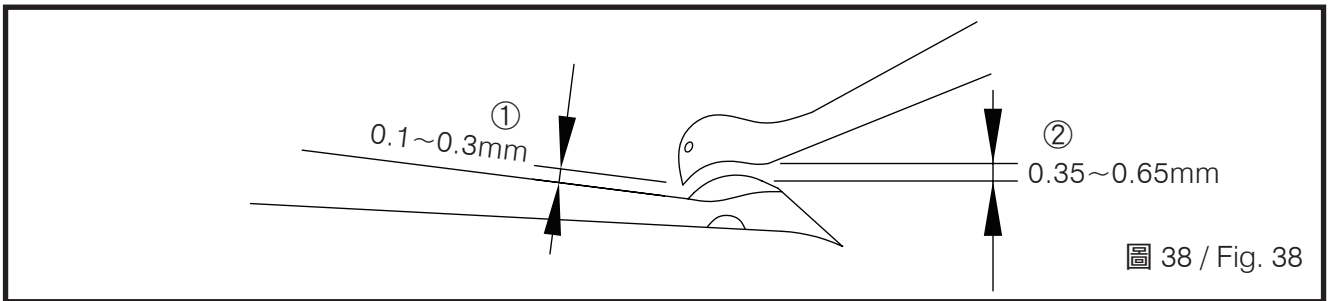


圖 38 / Fig. 38

4. 針與環縫勾針之關係  
當環縫勾針移至最左時，勾針尖端與針之中心距離為 1.6~2.3mm。(圖 39)

4. The relationship between the needle and the chainstitch looper.  
When the chainstitch looper moves to the leftest point, the distance from the chainstitch looper pin to the middle line of the needle is 1.6~2.3mm. ( Fig.39)

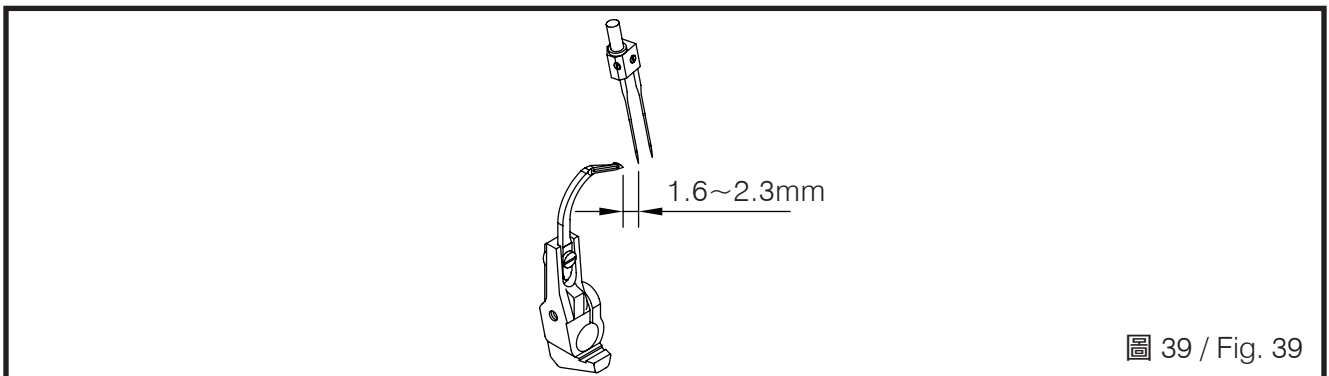


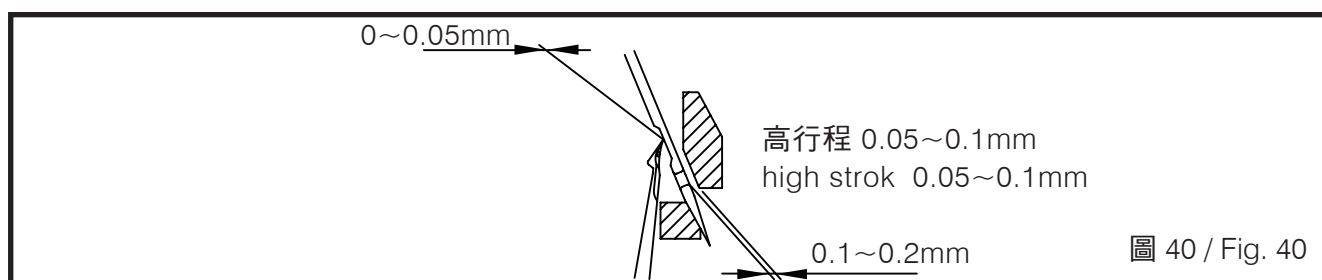
圖 39 / Fig. 39

## 5. 針與檔針片之關係

- (1) 當下勾針由左向右至針中心時 (雙針以左針為主) 針與後檔針片之間隙為  $0\sim 0.05\text{mm}$ 。
- (2) 當針在下死點時針與前檔針片之間隙為  $0.1\sim 0.2\text{mm}$ 。(圖 40)

5.The relationship between the needle and the needle guard.

- (1)When the lower looper moves from left to right to the central line of the needle (when it's double needle model, it means the left needle), the clearance from the needle to the rear needle guard is  $0\sim 0.05\text{ mm}$ .
- (2)When the lower looper moves from left to right to the central line of the needle and the front needle guard is  $0.1\sim 0.2\text{mm}$ . ( Fig.40)



## 環勾針運動量之調整

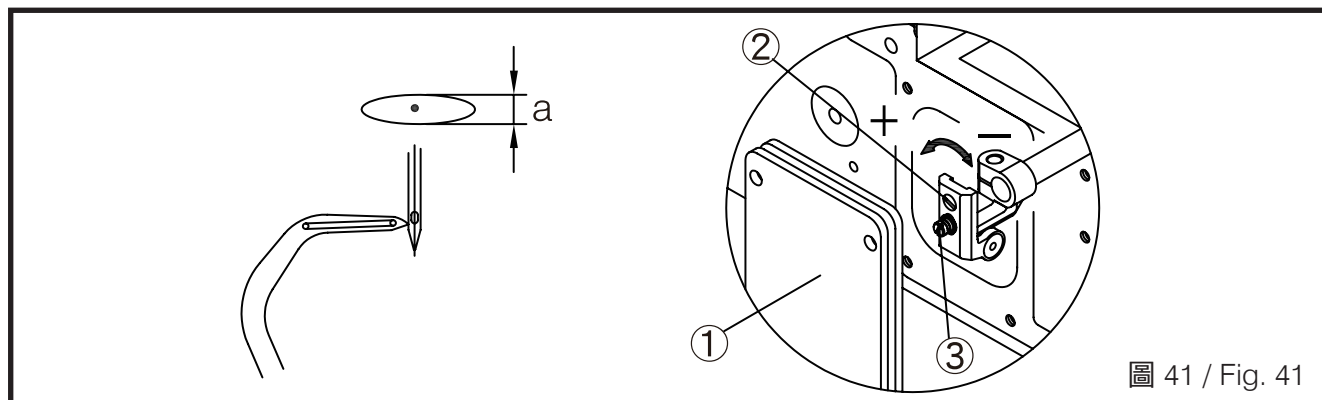
## ADJUST THE CHAINSTITCH LOOPER MOVEMENT AMOUNT

環勾針之運動呈橢圓形，當針號數變動過大時或有必要調整環勾針之前後運動量  $a$  時，請依照以下步驟調整。

1. 打開縫紉機背面的封蓋 ①。
2. 輕輕放鬆螺絲 ③。
3. 旋轉調整螺絲 ②，  
向  $\oplus$  方向加大前後運動量。  
向  $\ominus$  方向減少前後運動量。
4. 調整後鎖緊螺絲 ③。
5. 封蓋 ①。(圖 41)

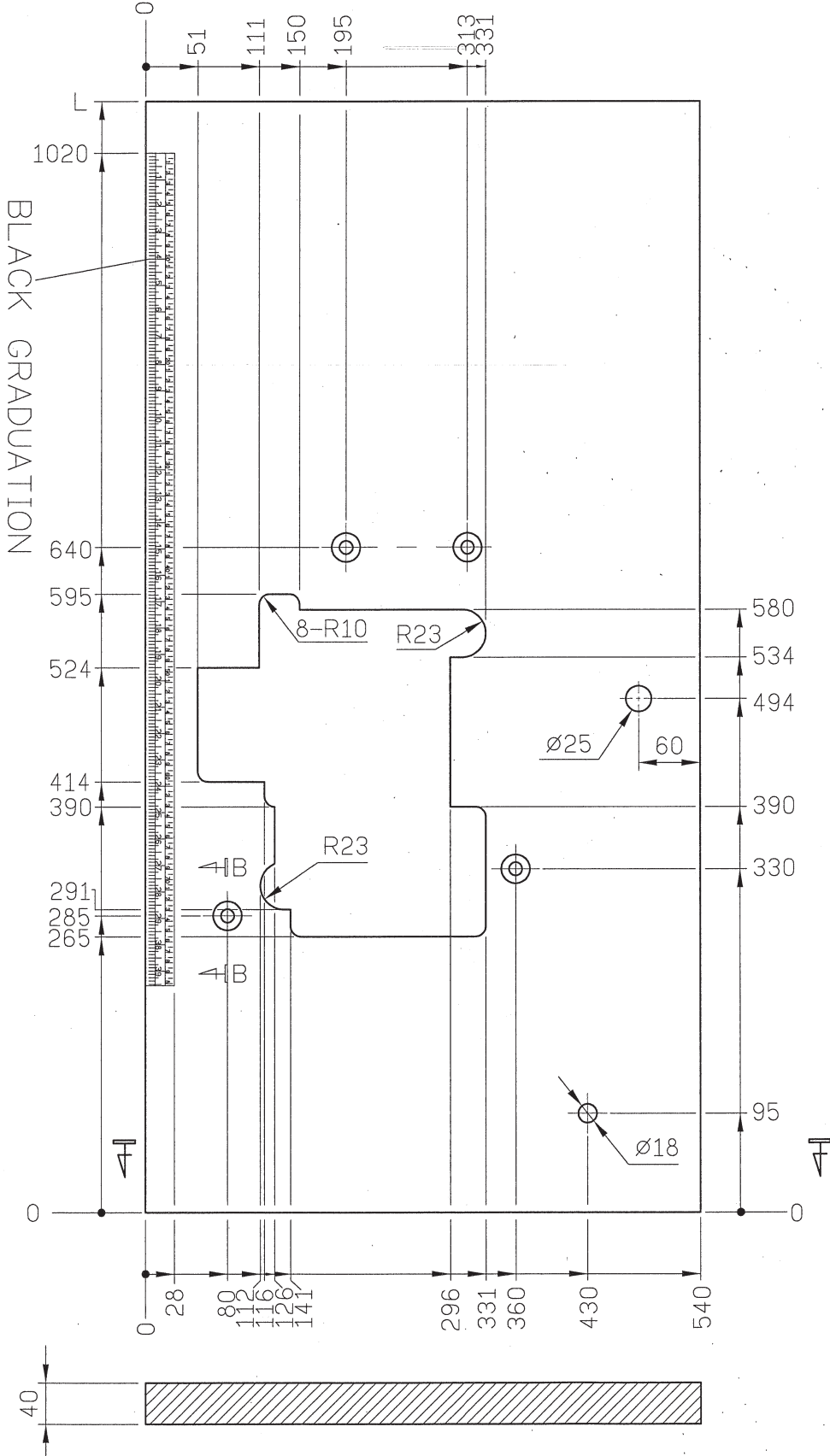
The movement of the chainstitch looper is oblong shape. When the difference of the changed needle number is too large, or if necessary to adjust the front/rear movement amount  $a$  of the chainstitch looper, please follow the steps below to adjust.

- 1.Open the sealed cover ① in the back side of the machine.
- 2.Loosen the screw ③ slightly.
- 3.Turn the screw ② to adjust. To increase the movement amount, turn to  $\oplus$  direction. To decrease the movement amount, turn to  $\ominus$  direction.
- 4.Tighten the screw ③ after the adjustment.
- 5.Then, seal the cover ①.( Fig.41)

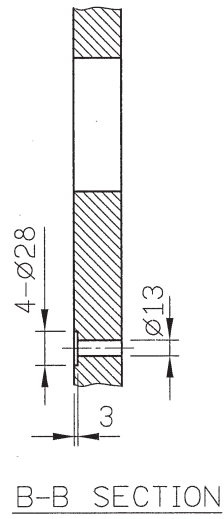


**SIRUBA**  
TABLE  
CUT - OUT

Series	Item Code	Subclass Remark	Mounting
<b>700LQ</b>	<b>700LQ-T</b>		Semi-submerged
			Date
			2021/03/25



單位 / UNIT: mm  
所有尺寸公差 / TOLERANCE:  $\pm 2$   
長度 (L): 1200  
重量 (W): 1.5Kg  $\pm 5\%$





**SIRUBA**  
TABLE  
CUT - OUT

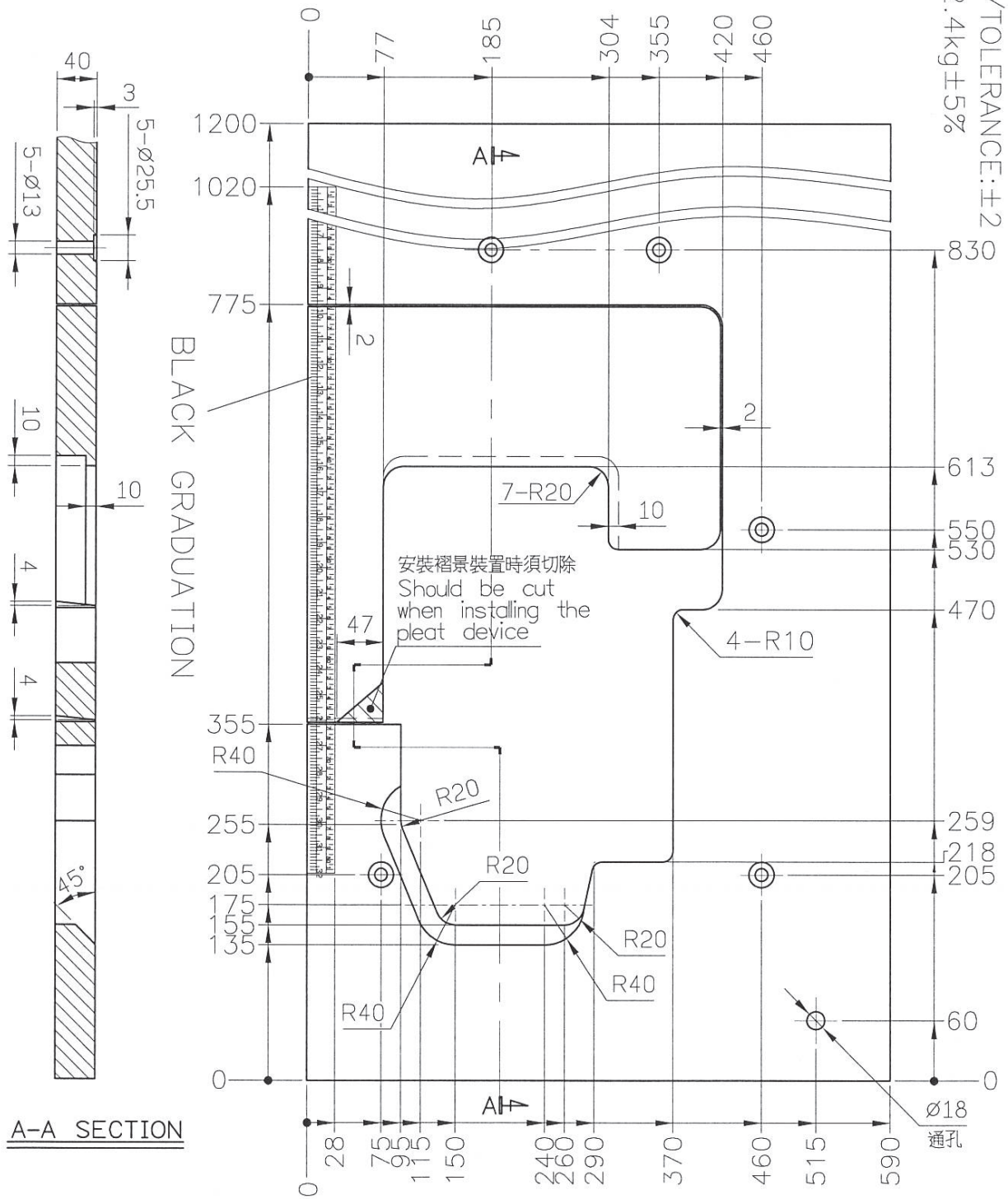
Series  
**700LQ**

Item Code  
**700LQ-T2**

Subclass Remark  
需配TBK-1 (包含TB201)  
Collocate With TBK-1  
(Including TB201)

Mounting  
Fully-submerged  
Date  
2021/06/10

單位 / UNIT: mm  
所有尺寸公差 / TOLERANCE: ±2  
重量 (W): 12.4kg ±5%



A-A SECTION

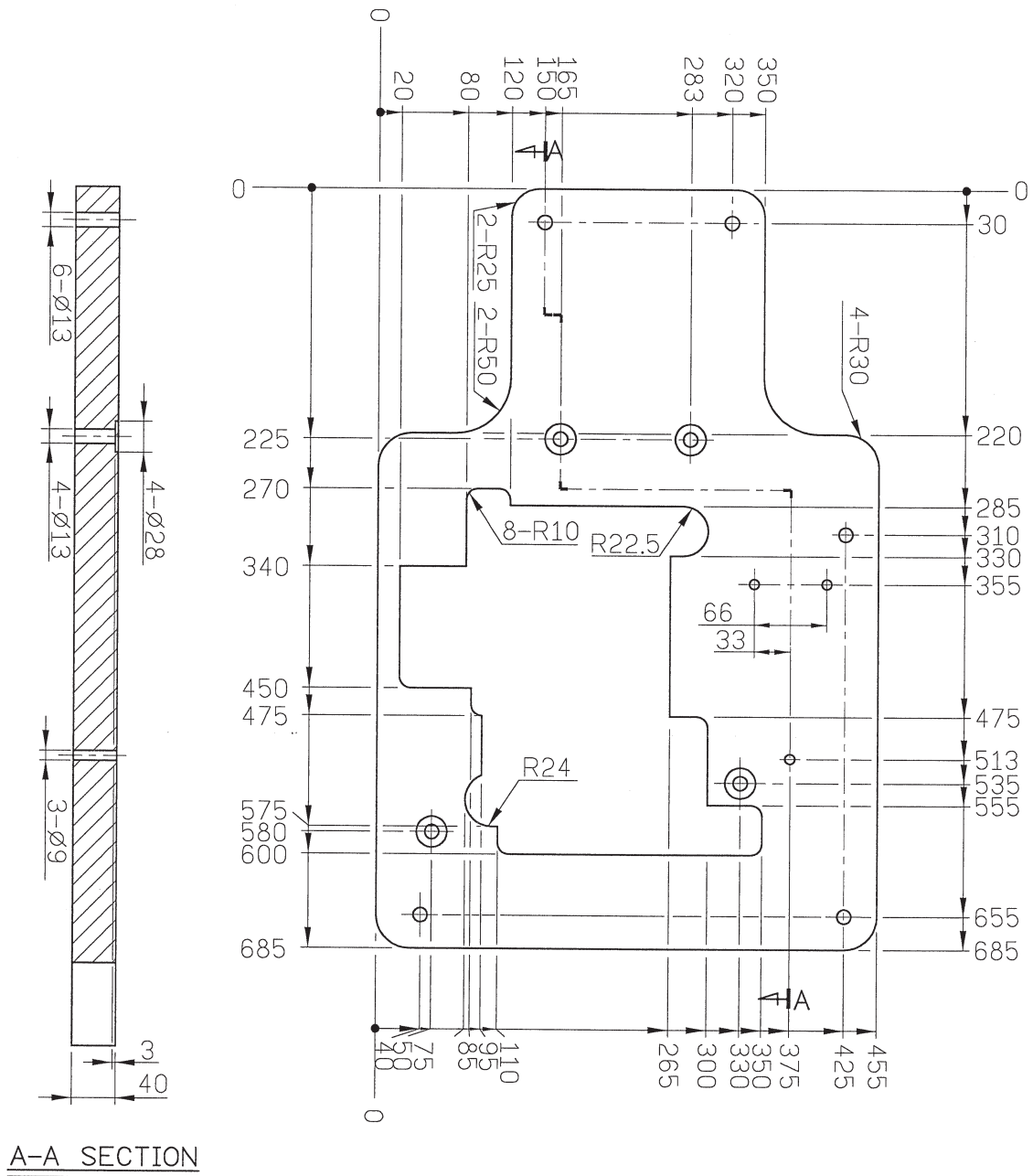
<b>SIRUBA</b> TABLE CUT - OUT	Series	Item Code	Subclass Remark	Mounting
	700K/988	TB201		Fully-submerged Fixed Table
	700L			Date
				2018/08/28

單位/UNIT:mm

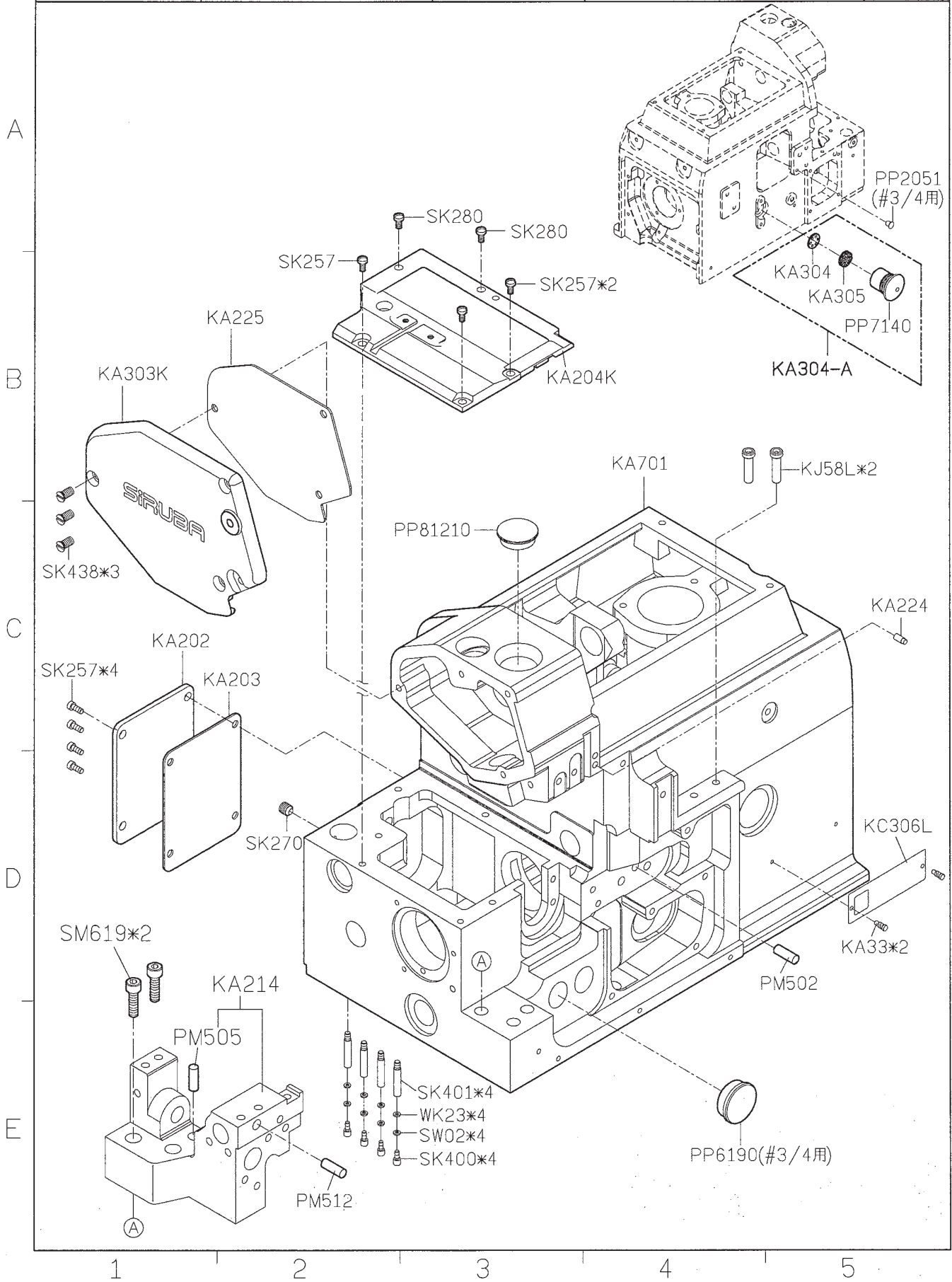
所有尺寸公差/DIFFERENCE:±2

重量(W):4.25kg±5%

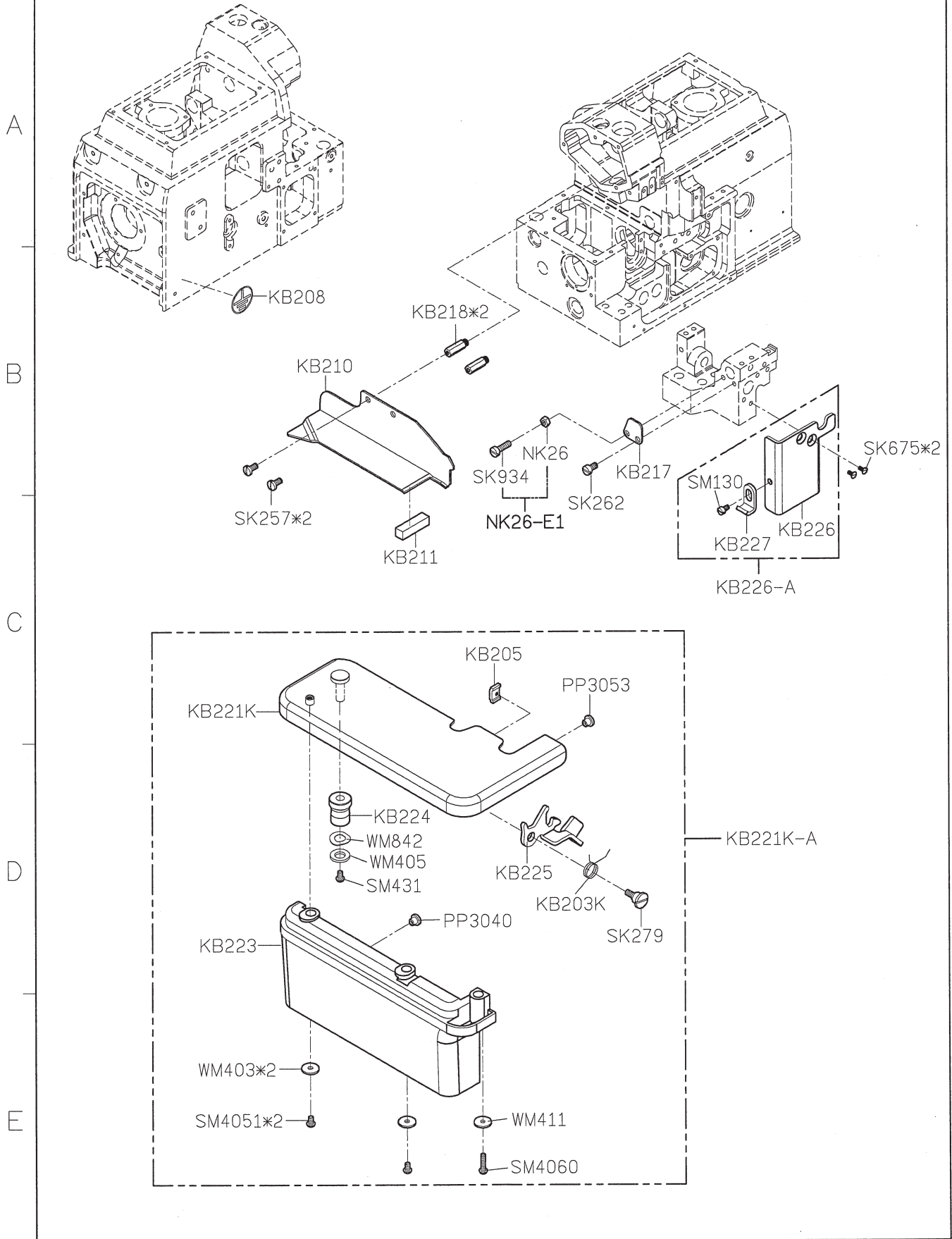
全封邊灰格紋光塑面台板/Plastic Table With All Sides Sealed With Gray Plaid



SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	700LQ	KA		1/1
				Date 2021/04/07

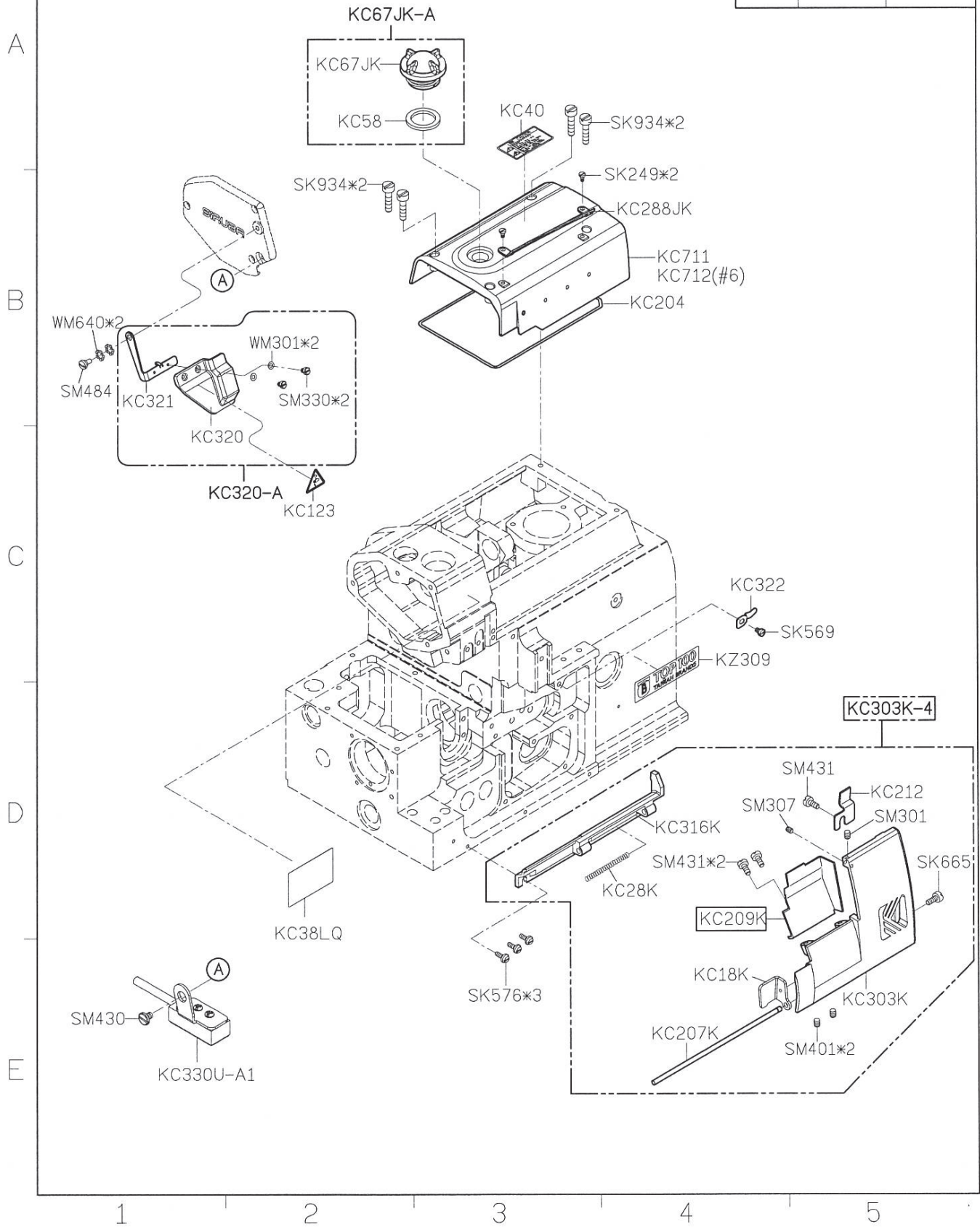


SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	700LQ	KB		1/1
				Date
				2021/03/25



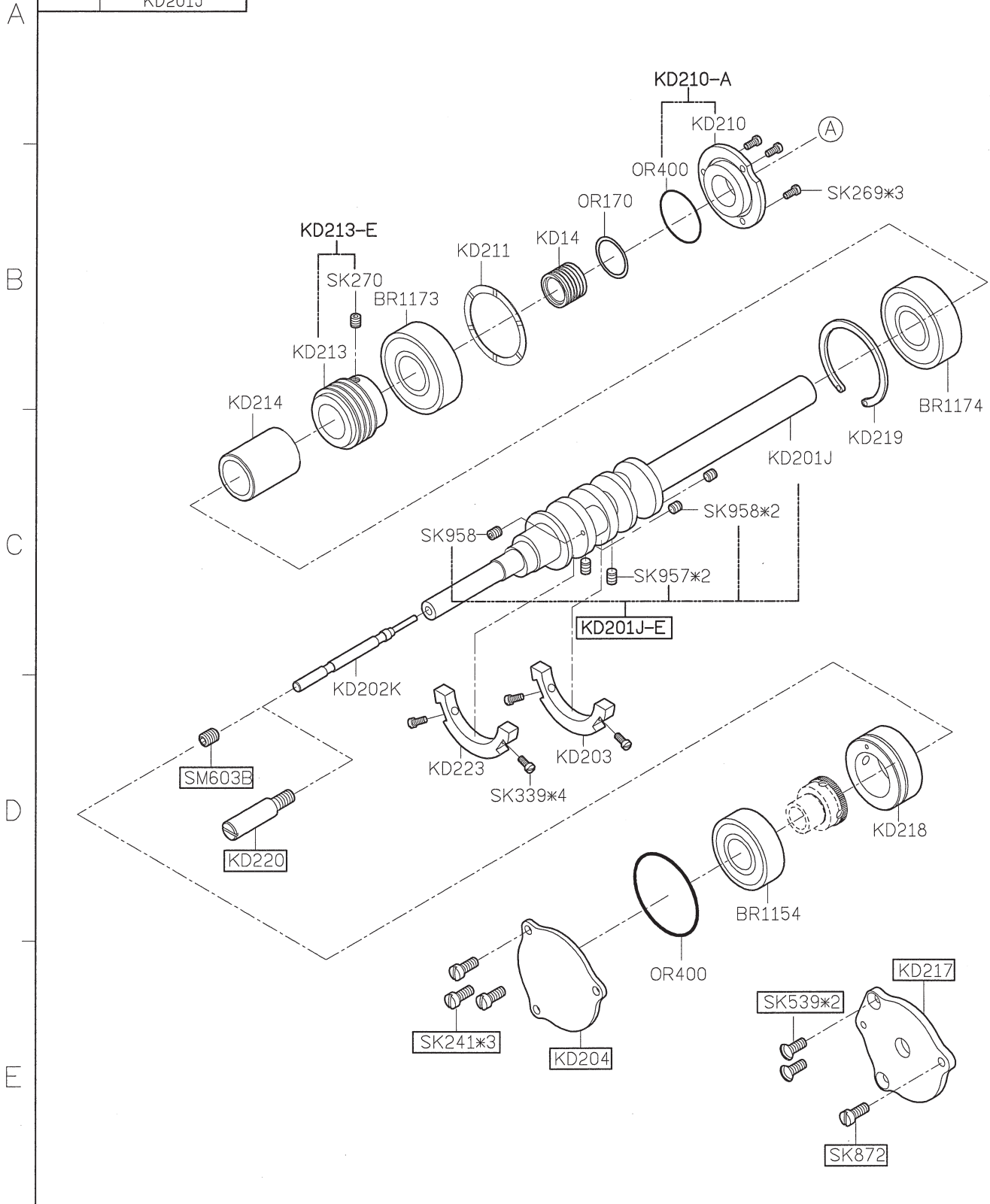
<b>SIRUBA</b> PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	700LQ	KC		1/1
				Date
				2021/09/15

MODEL	#3/#4	#5/#6
PARTS NO	KC209K	KC219K
	KC303K-4	KC303K-5

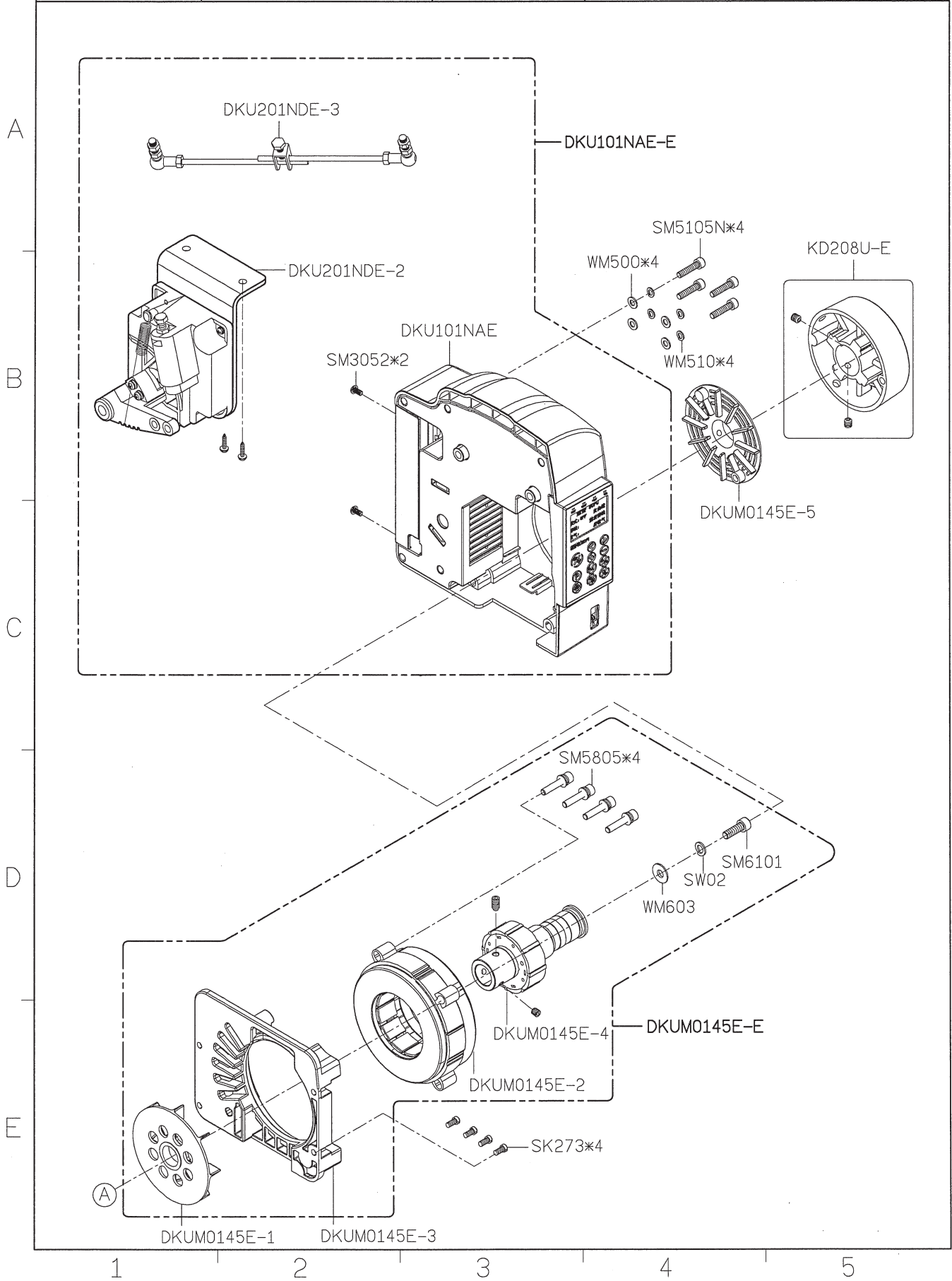


<b>SIRUBA</b> PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	<b>700LQ</b>	<b>KD</b>		1/2
				Date
				2021/03/25

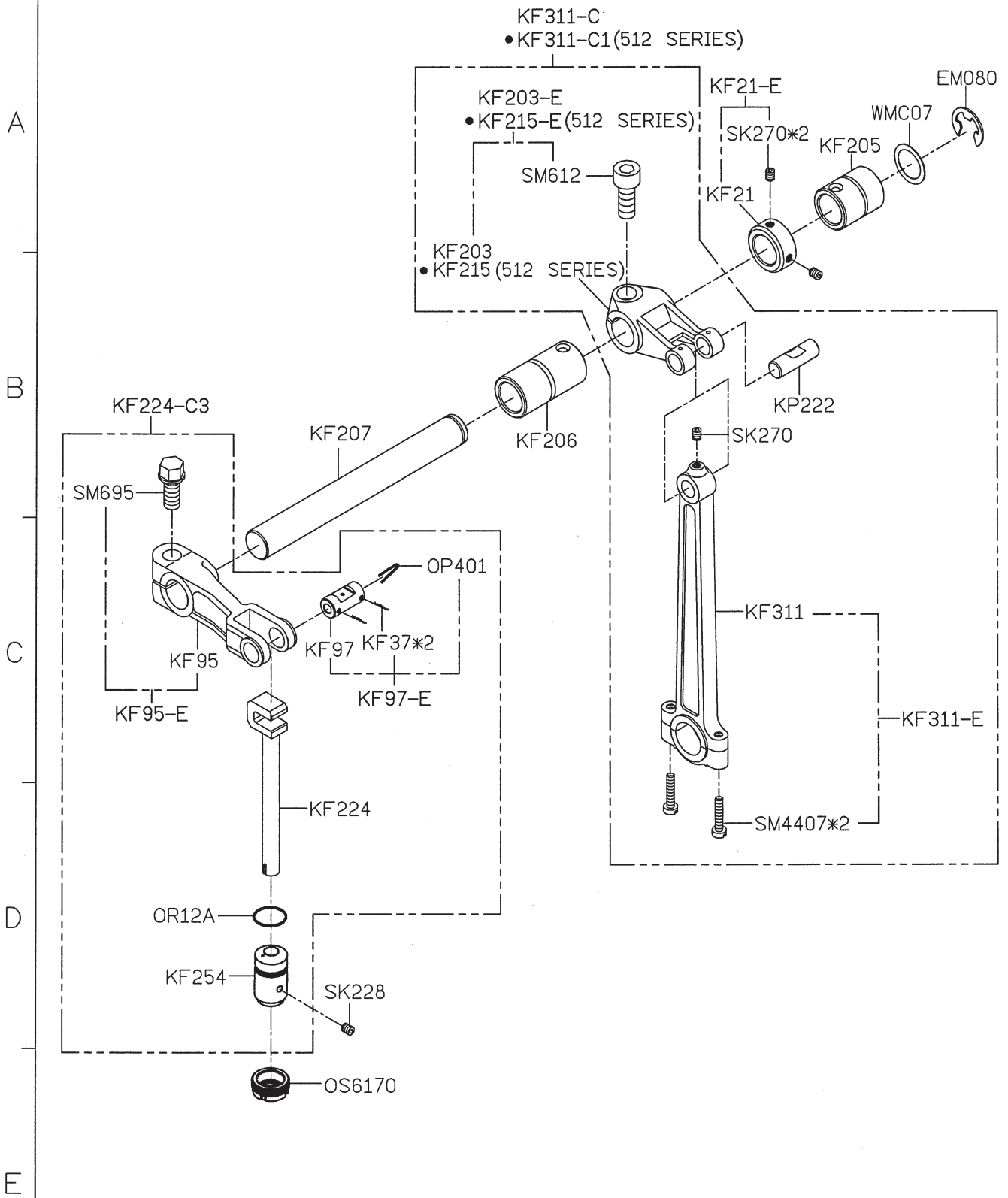
MODEL	#3/#4	#5/#6
PARTS NO	KD204	KD217
	SM603B	KD220
	SK241*3	SK539*2 SK872*1
	KD201J	



SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	700LQ	KD		2/2
				Date
				2021/03/25



SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	700LQ	KF		1/1
				Date
				2021/03/25





**SIRUBA**  
PARTS LIST

Series  
**700LQ**

Parts Group  
**KG**

Subclass / Remark

Page

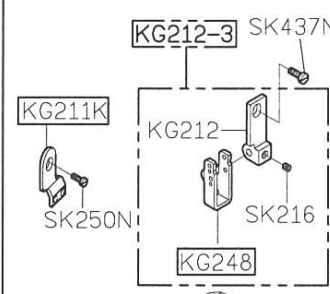
1/1

Date

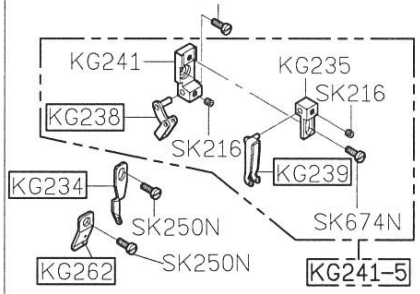
2021/09/15

MODEL	#3	#4	#5	#6
	KG262	KG211K	KG262	KG211K
	KG248	KG213K	KG239	KG246
	KG250K	KG269	KG243K	KG251K
	KG222	KG222	KG245	KG245
	KG225	KG225	KG261	KG261
	KG201	KG201	KG244	KG244
	KG93	KG92	KG267	KG267
	SK216	SK216	SK216*2	SK216*2
	SK250N	SK250N	SK250N*2	SK250N*2
	SK437N	SK437N	SK569 SK674N	SK569 SK674N
	SM251	SM251	SM250	SM250
	KG212-3	KG212-4	KG241-5	KG241-6
	KG223-4	KG223-4	KG223-5	KG223-5
			KG238	KG238
			KG41	KG41
			KG41-E	KG41-E
			KG234	KG234

FOR(#3/#4)



FOR(#5/#6)

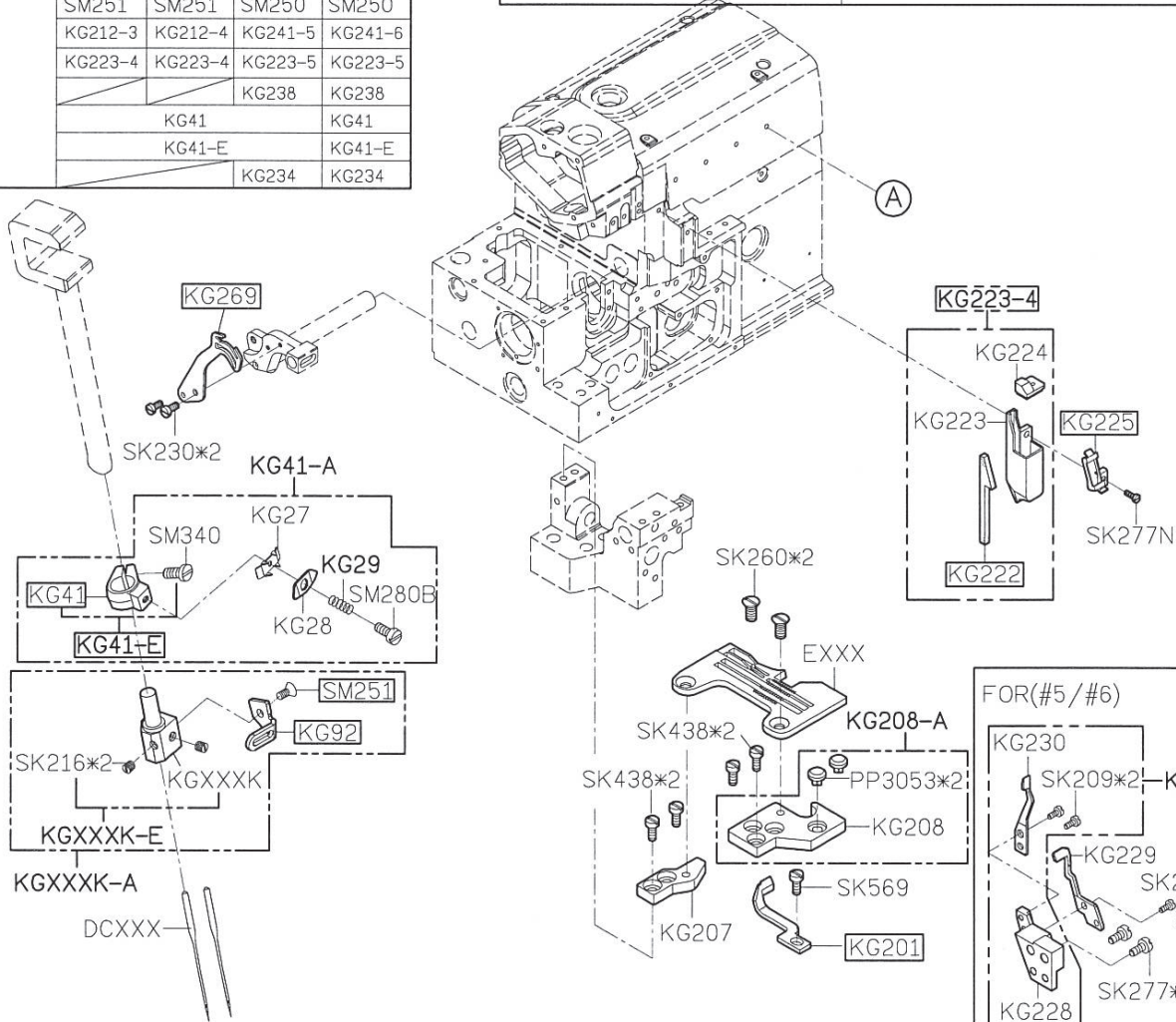


A PARTS NO

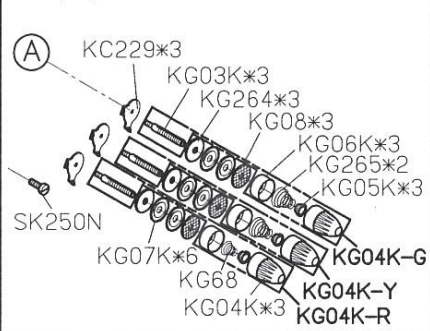
B

C

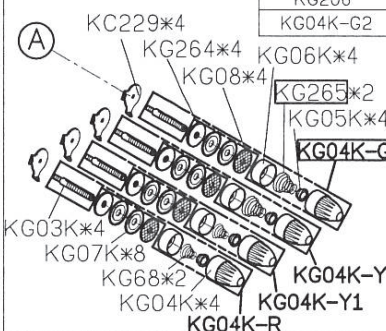
D



FOR(#3)

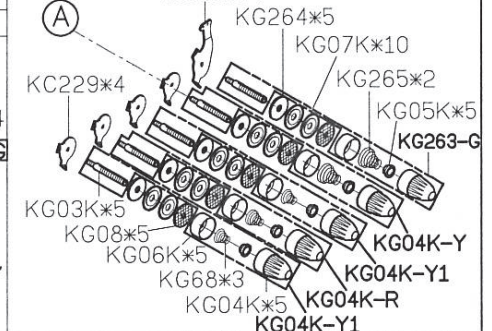


FOR(#4/#5)



H-3/H-4/X-3  
KG206  
KG04K-G2

FOR(#6)



1

2

3

4

5



<b>SIRUBA</b> PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	<b>700LQ</b>	<b>KL</b>		1/1
				Date
				2021/03/25

MODEL	#3/#4	#5/#6
PARTS NO	KJ222	
	KL202	
	KL211-A	
	KL205	KL209
		SK270
	KL205-E	KL209-E
	KL205-C	KL209-C

A

B

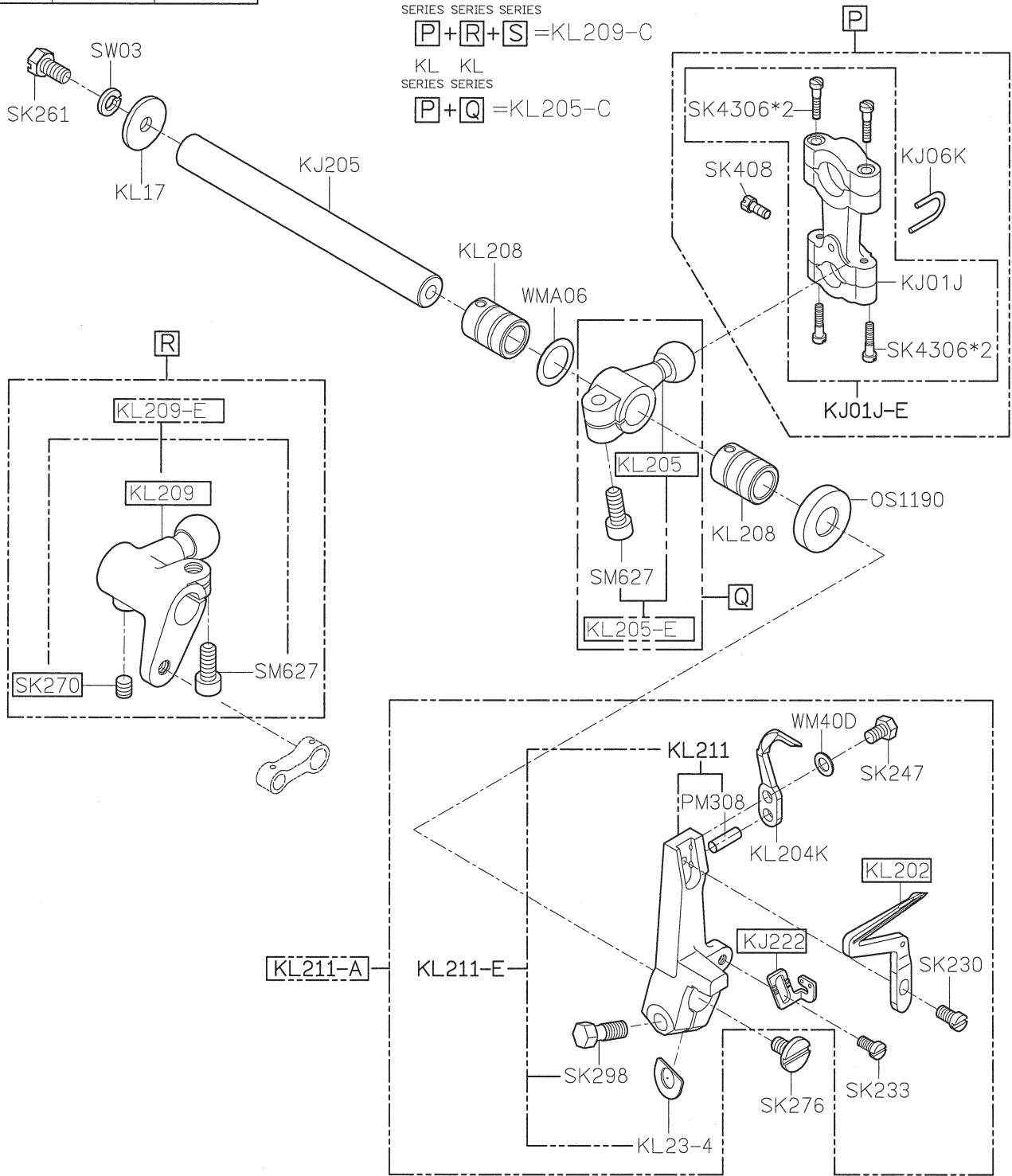
C

D

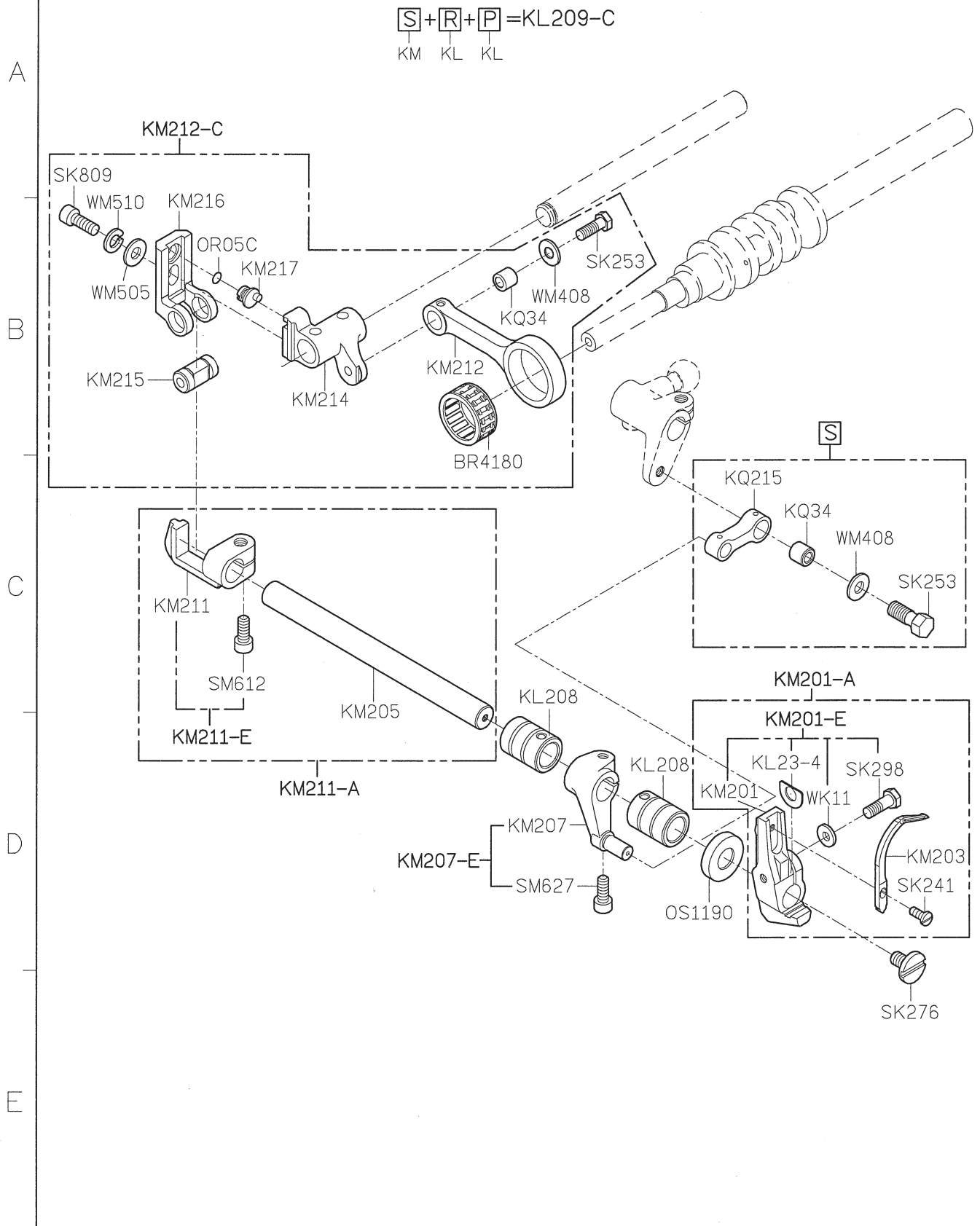
E

KL KL KM  
SERIES SERIES SERIES  
[P]+[R]+[S]=KL209-C

KL KL  
SERIES SERIES  
[P]+[Q]=KL205-C



SIRUBA PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	700LQ	KM		1/1
				Date
				2021/03/25



**SIRUBA**

PARTS LIST

Series

**700LQ**

Parts Group

**KN**

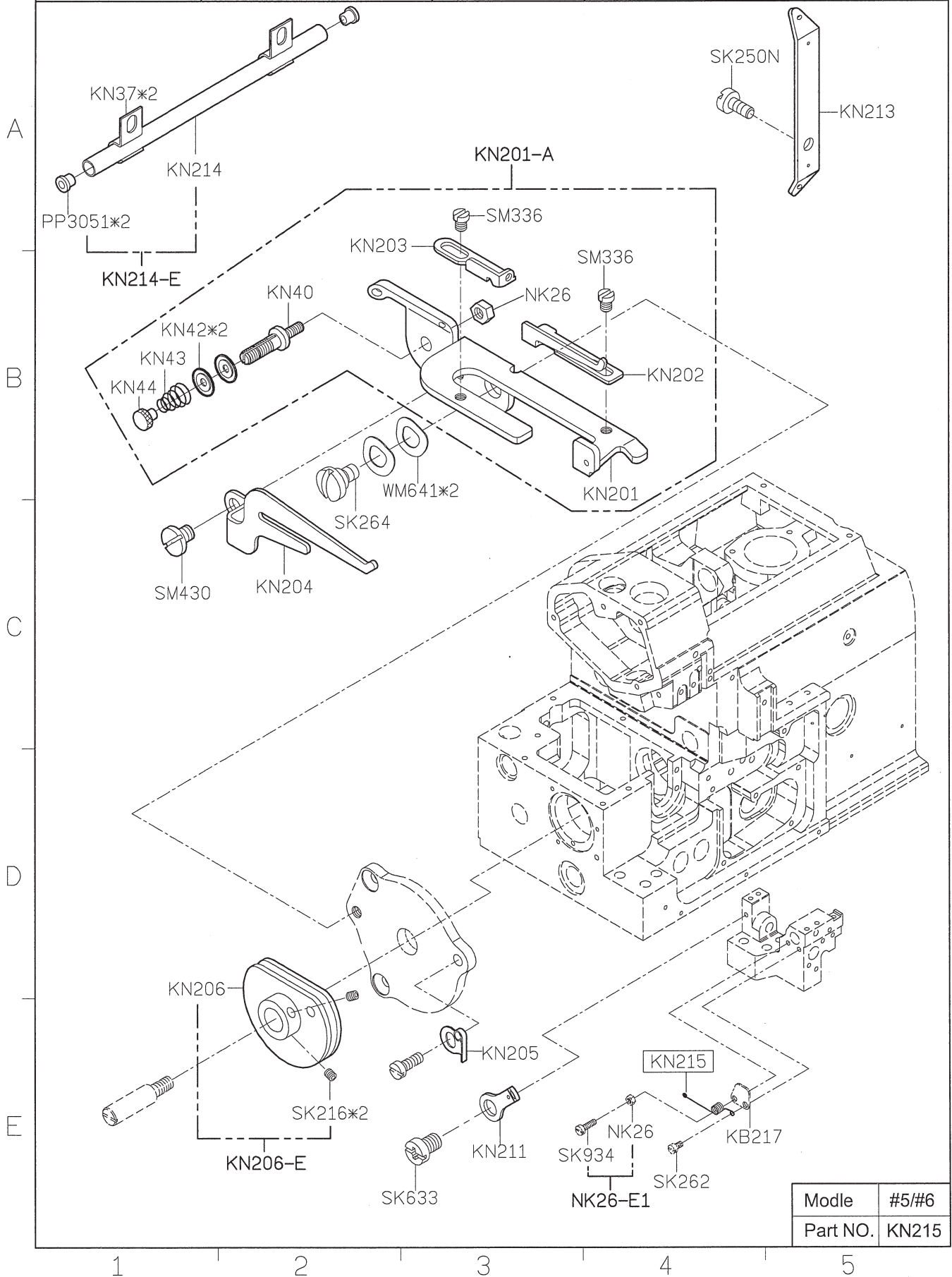
Subclass / Remark

Page

1/1

Date

2021/03/25







<b>SIRUBA</b> PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	<b>700LQ</b>	<b>KR</b>		1/1
				Date
				2021/03/25

MODEL	#3/#4	#5/#6
PARTS NO	KR202	KR218
	KR202-E	KR218-E
	KR311-C	KR311-C1
	KR206K	KR221
	KR206K-A	KR221-A
	KR209	KR219
	KR209-A	KR219-A
	KR35	KR35
KR212		

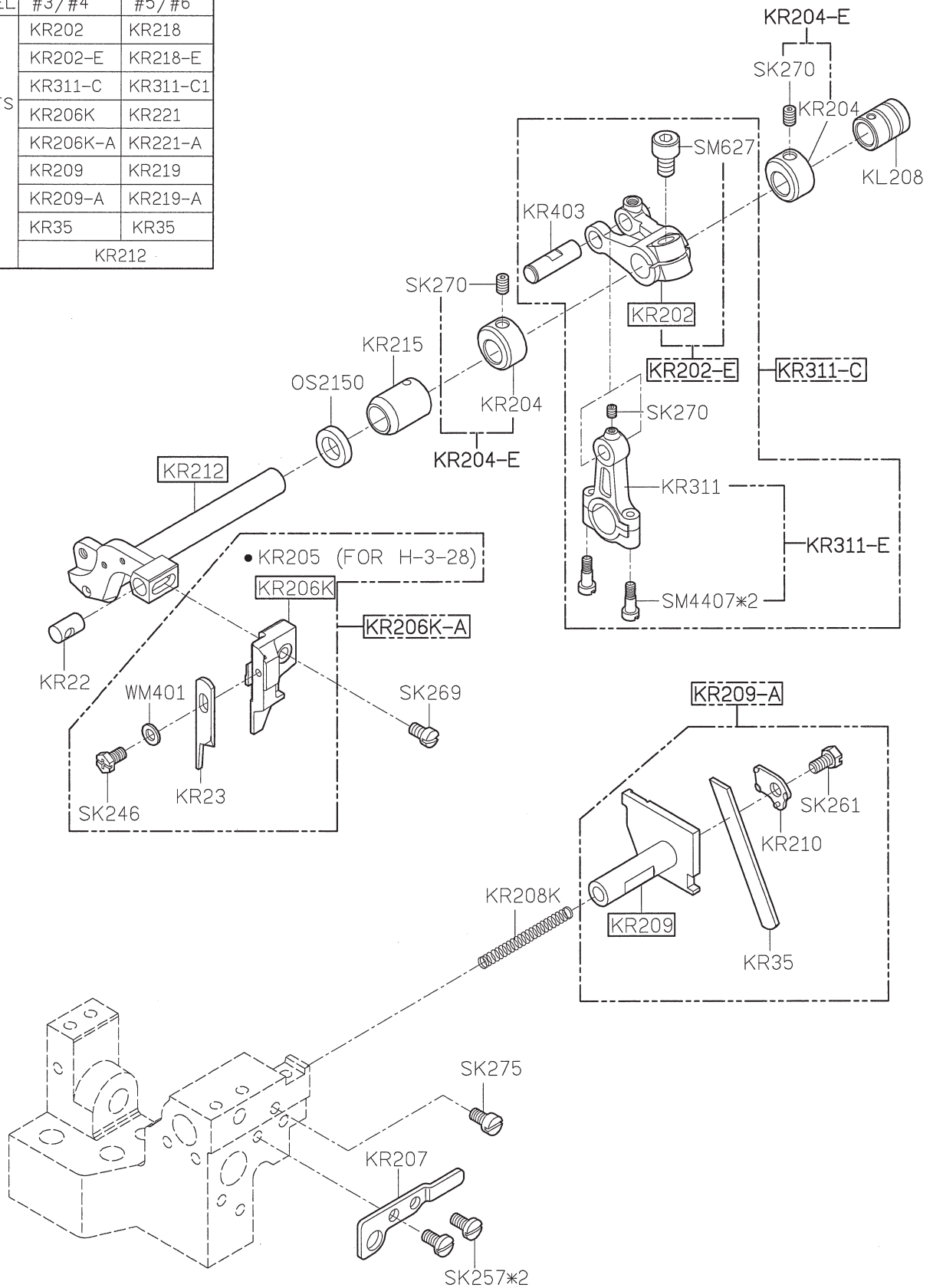
A

B

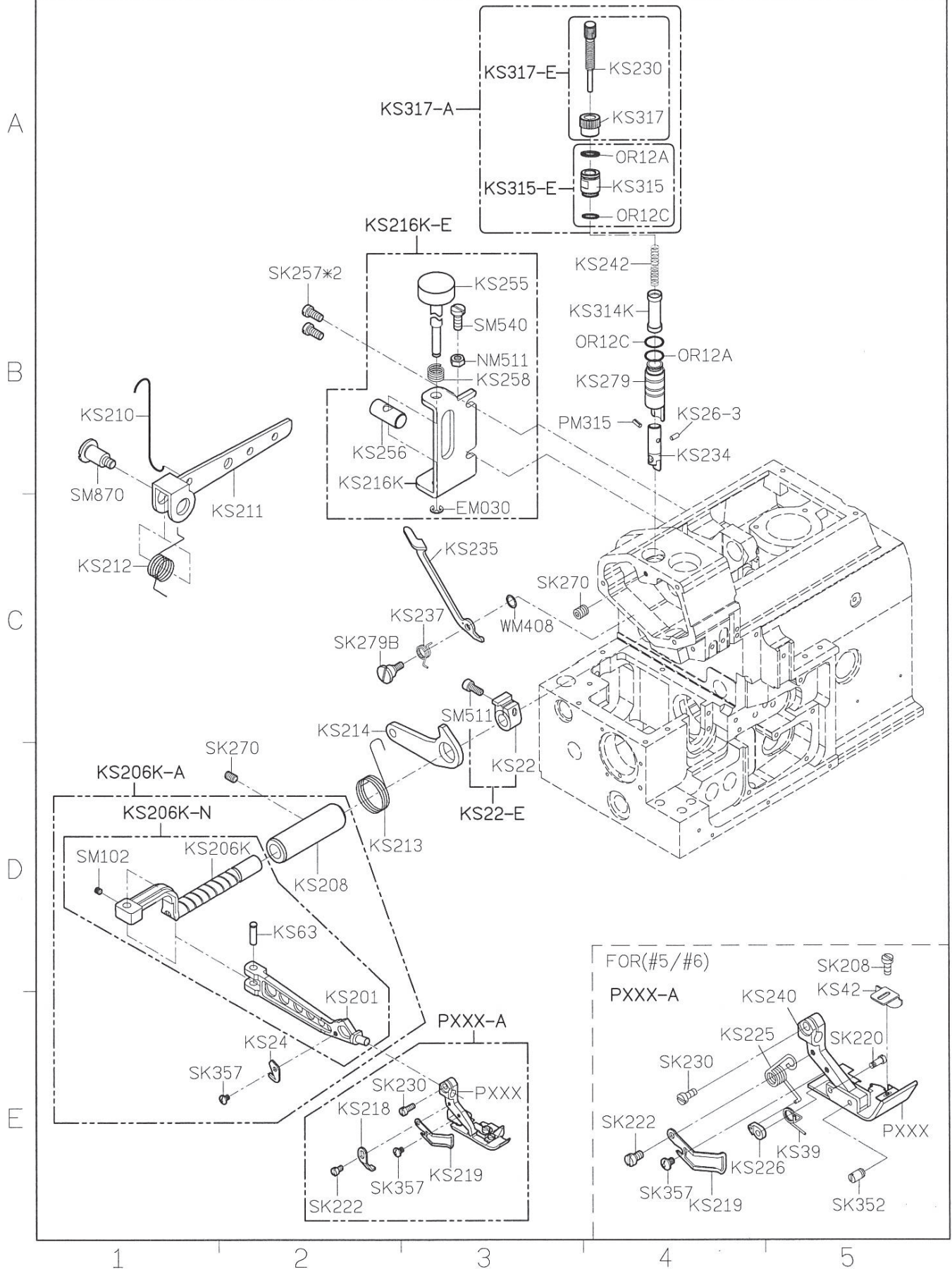
C

D

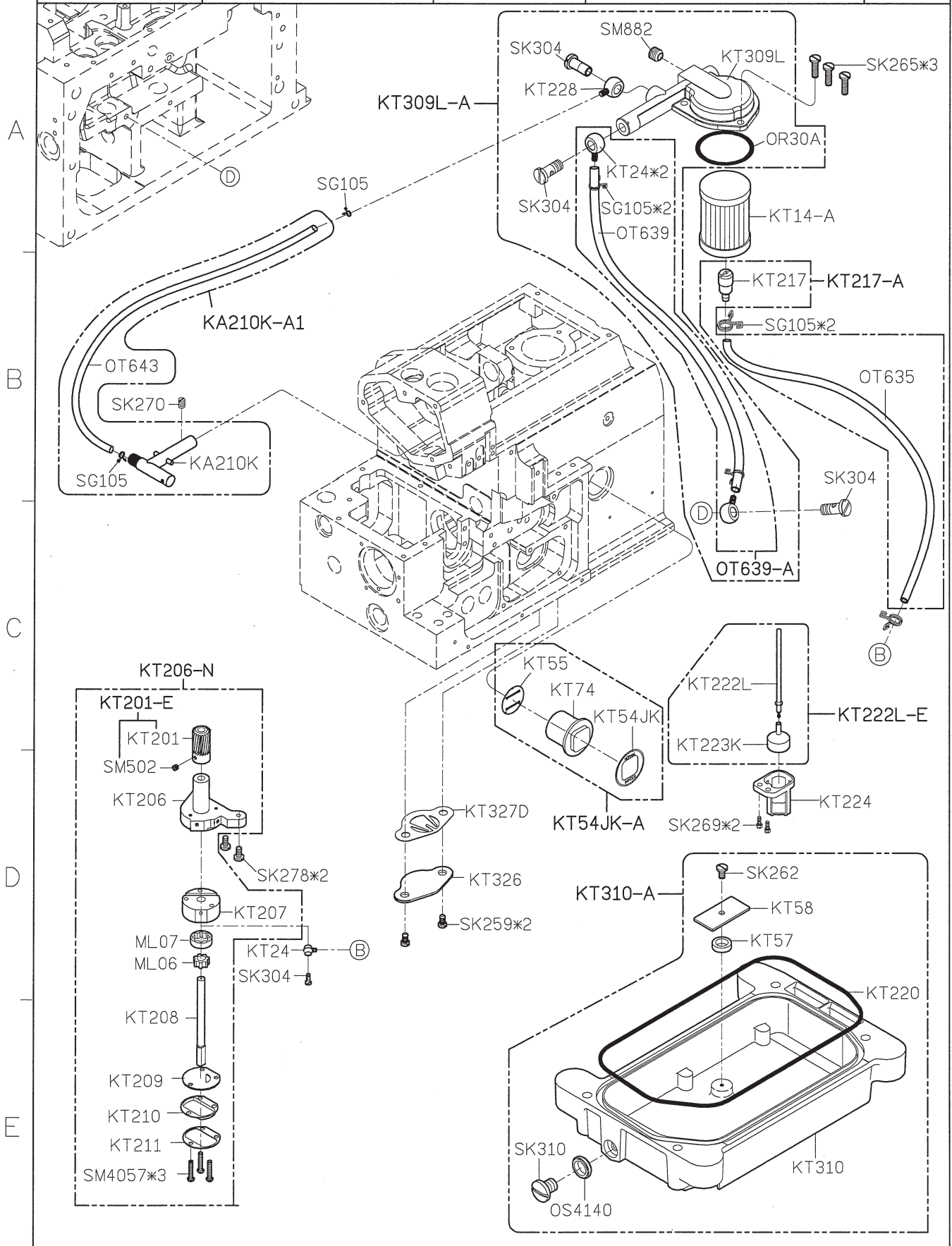
E







<b>SIRUBA</b> PARTS LIST	Series	Parts Group	Subclass / Remark	Page
	<b>700LQ</b>	<b>KT</b>		1/1
				Date
				2021/03/25



**SIRUBA**  
PARTS LIST

Series  
**700LQ**

Parts Group  
**KU**

Subclass / Remark

Page  
1/1  
Date  
2021/03/25

MODEL	#3/#4	#5/#6
PARTS NO	KU40	KU39
	KU220-4	KU220-5
	KU207	KU209
	KU206	KU211
	KU203-4	KU203-5
	SK277	SK437

**KU60-A**  
(FOR 505F1-04)

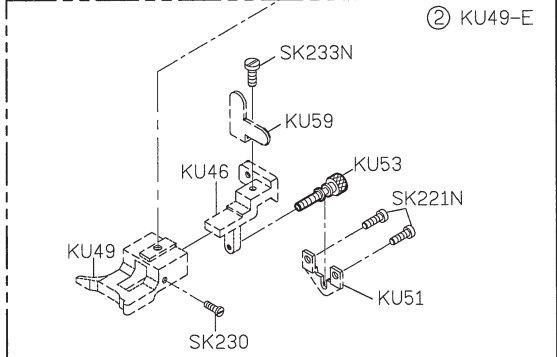
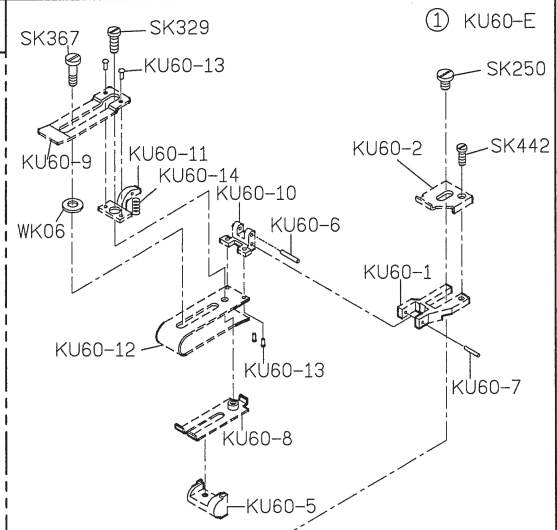
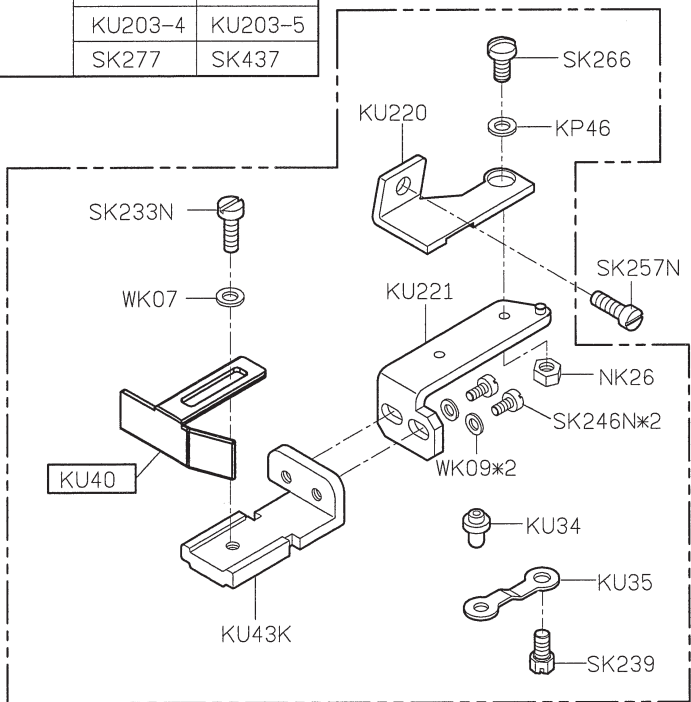
A

B

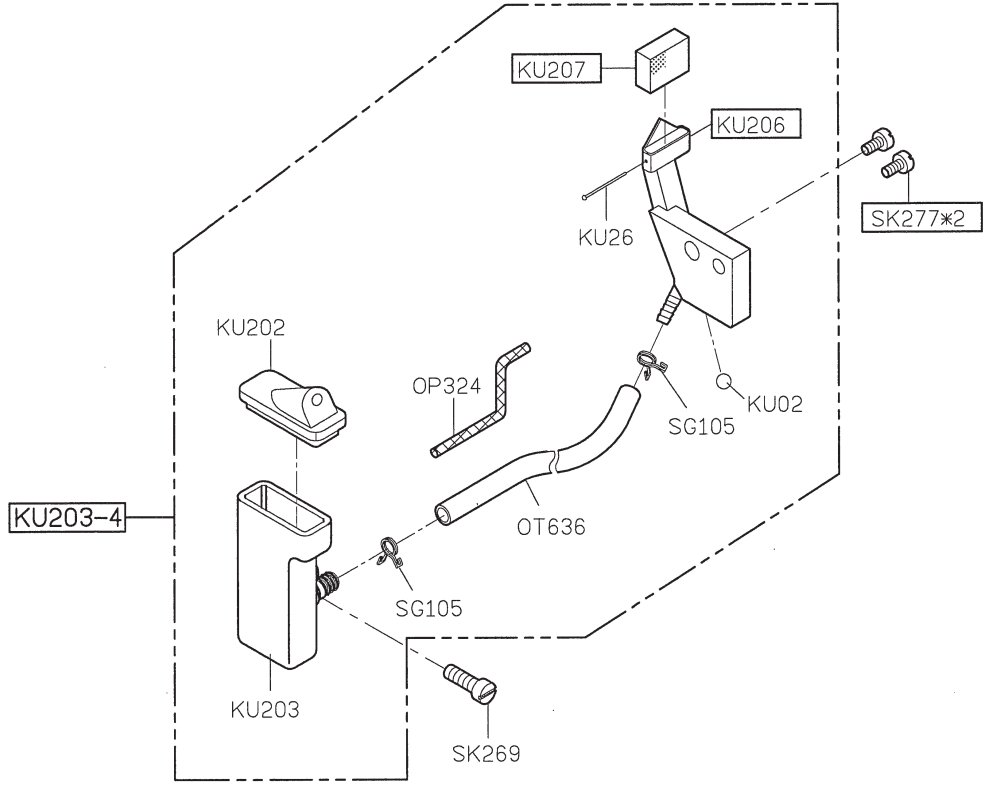
C

D

E

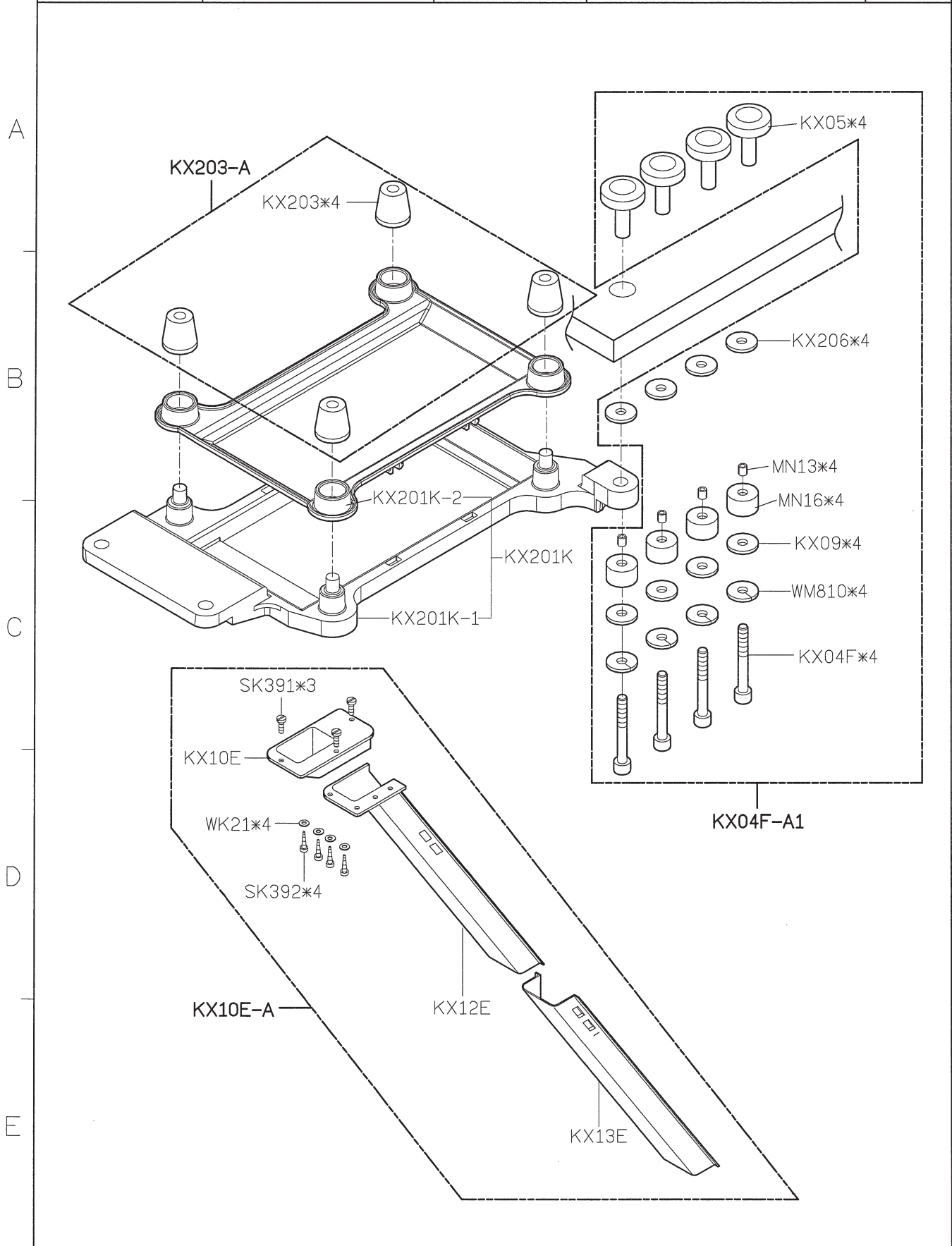


Option: **KU220-4**



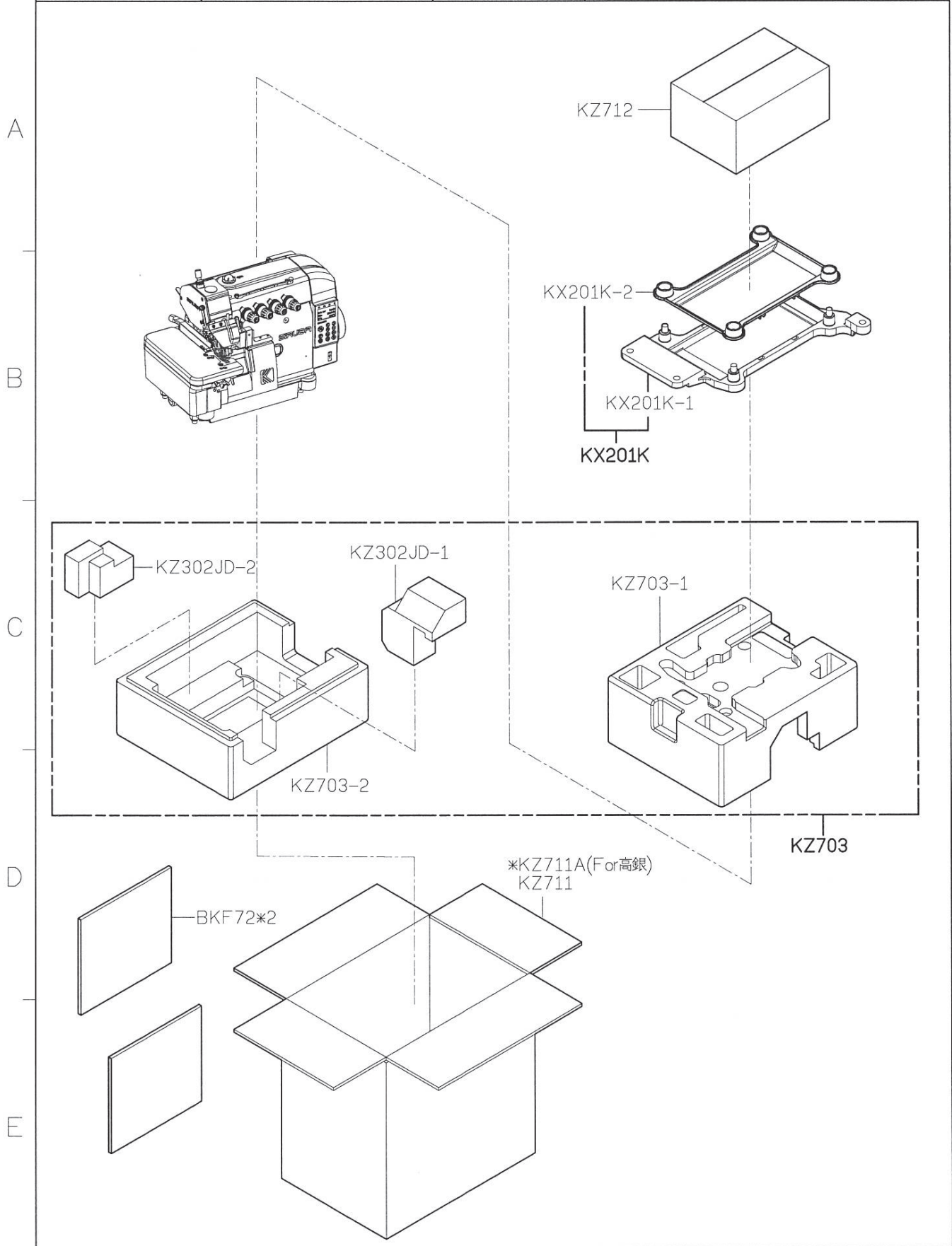
1                      2                      3                      4                      5

<b>SIRUBA</b> PARTS LIST	Series	Parts Group	Subclass Remark	Page
	<b>700LQ</b>	<b>KX</b>		1/1
				Date
				2021/03/25





SIRUBA PARTS LIST	Series	Parts Group	Subclass Remark	Page
	700LQ	KZ		1/1
				Date
				2021/09/15





高林股份有限公司  
KAULIN MFG. CO., LTD.

由於對產品的改良及更新，本產品使用說明書中與零件圖之產品及外觀的修改恕不事先通知！  
The specification and/or appearances of the equipment described in this instruction book & parts list are subject to change because of modification which will without previous notice.  
KZ08LQ.FEB.2022