

ONEn(B1N) 电脑高速平缝机系列 产品使用说明书

产品标准代号：QB/T2380-2013

Standard code of the products：QB/T2380-2013

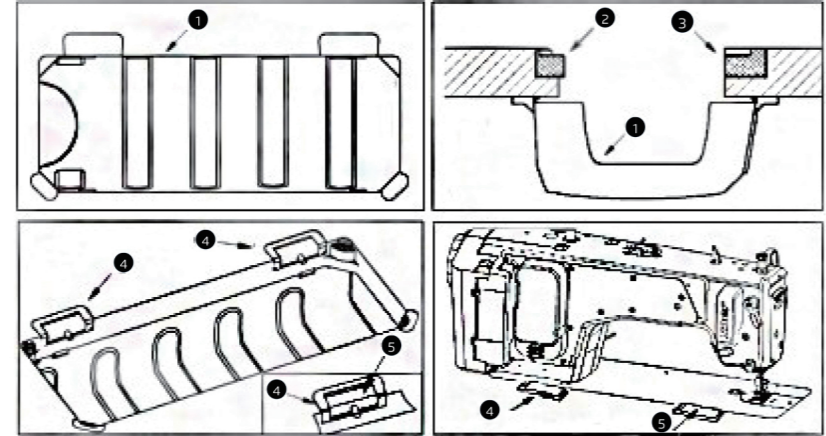
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1.规格/SPECIFICATIONS

用途	中厚料、厚料
缝纫速度	最高 3,000rpm
最大针脚长度	4.5 mm
机针	DPx5 #18~#21 (#21)
压脚高度（自动抬压脚）	9mm (标准) 12mm (最大)
使用机油	New Defrix Oil NO.10 机油

Application	Medium-weight materials, Heavy-weight materials
Sewing speed	Max. 3,000rpm
Max.Stitch length	4.5 mm
Needle	DPx5 #18~#21 (#21)
Presser foot lift	9mm (standard) ;12mm (Max.)
Lubricating oil	New Defrix Oil NO.10

2.缝纫机的安装/INSTALLATION



(1) 油盘托盘安装

- 1) 将油盘托盘 ① 安装在台板背面。
- 2) 将机头支架 ②、机头座垫 ③ 分别安装在台板上。如图所示，安装时确保两个机头支架 ② 朝向操作者一边，两个将机头座垫 ③ 是在有机头连接钩 ④ 的那一侧。
- 3) 先将机头连接钩座 ⑤ 安装在台板上，再将机头连接钩 ⑥ 放入底板孔内，最后将机头放置于台板上，且机头连接钩 ⑥ 要与台板上的机头连接钩座 ⑤ 相嵌合。

(1)The installation of plastic reservoir

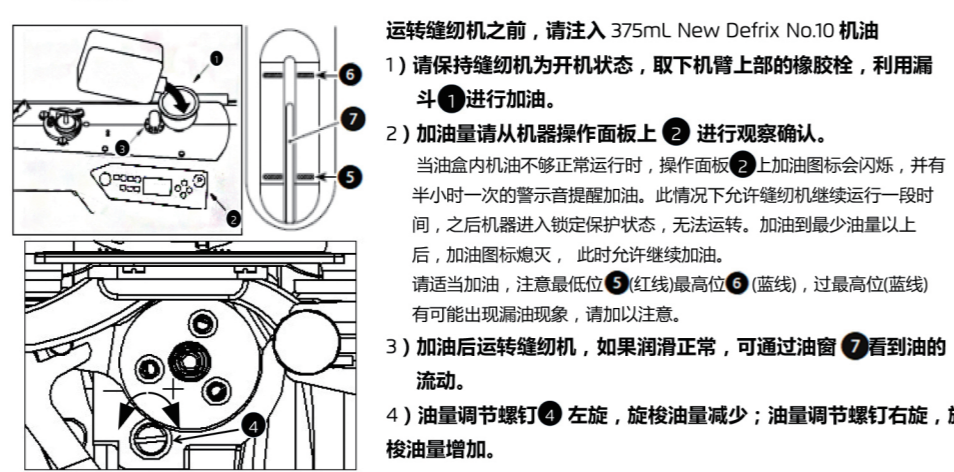
- 1)Install the plastic reservoir ① under the stand & table.
- 2)Put the machine holder ① and the machine cushion ② on the stand & table.As is shown in the chart,making sure that the machine holders ① are pointing to the operator during the installing and the two machine cushion ② are on the side which is with machine head connecting hook ⑤.
- 3)Install the machine head connecting hook base ⑥ on the stand & table,and then put machine head connecting hook ⑥ in the baseplate hole,at last,put the head on the stand & table,making sure machine head connecting hook ⑥ is nested in the machine head connecting hook base ⑥ which is on the stand & table.

3.膝动提升高度的调整/ADJUSTING THE HEIGHT OF THE KNEE LIFTER



- 1) 膝动提升的标准高度为 10mm。
- 2) 调节膝动提升调节螺丝 ① 可以把压脚高度最大调整到 13mm。
- 3) 压脚提升到 10mm 以上时，请注意机针 ② 的前端下降到最低下，不能碰到压脚 ③。
 - 1) The standard height of the presser foot lifted using the knee lifter is 10mm.
 - 2) You can adjust the presser foot lifted up to 13mm using knee lifter adjust screw ①.
 - 3) When you have adjusted the presser foot lift to over 10mm,be sure that the bottom end of needle bar ② in its lowest position does not hit presser foot ③.

4.加油/LUBRICATION



- 1) 保持缝纫机为开机状态，取下机器上部的橡胶胶，利用漏斗 ① 进行加油。
- 2) 加油量请从机器操作面板上 ② 进行观察确认。
当油盘内机油不够正常运行时，操作面板 ② 上加油图标会闪烁，并有半小时一次的警告音提醒加油。此情况下允许缝制机继续运行一段时间，之后机器进入锁定保护状态，无法运转。加油到最少油量以上后，加油图标熄灭，此时允许继续加油。
请适当加油，注意最低位 ③（红线最高位 ④（虚线），过最高位虚线）有可能出现漏油现象，请加以注意。
- 3) 加油后运转缝纫机，如果润滑油正常，可通过油窗 ⑦ 看到油的流动。
- 4) 油量调节螺钉 ⑧ 左旋，旋梭油量减少；油量调节螺钉右旋，旋梭油量增加。
- 5) 新机使用 1 个月请更换机油，后续每 6 个月请更换机油。
※油流动量的多少，与油量的多少无关。

运转缝纫机之前，请注入 375mL New Defrix No.10 机油

1) 请保持缝纫机为开机状态，取下机器上部的橡胶胶，利用漏斗 ① 进行加油。

2) 加油量请从机器操作面板上 ② 进行观察确认。
当油盘内机油不够正常运行时，操作面板 ② 上加油图标会闪烁，并有半小时一次的警告音提醒加油。此情况下允许缝制机继续运行一段时间，之后机器进入锁定保护状态，无法运转。加油到最少油量以上后，加油图标熄灭，此时允许继续加油。
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Before the machine operation,please inject 330mL New Defrix No.10 oil

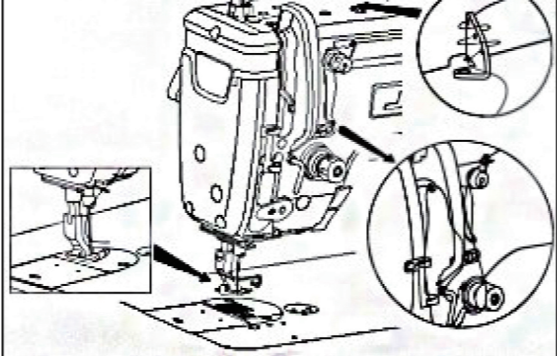
1) Please keep the sewing machine open, take off the rubber plug on the upper arm , and use a funnel ① to add oil.

2) Please observe the oil amount on the operation pane ②. when the machine oil cannot ensure the normal operation of the machine, the icon on the operation panel ② would twinkle to warn us to add oil. In this situation,the machine would operate for a period of time. After that, the machine would be locked and can not operate. Only when the oil is higher than the minimum quantity line, the warning icon will be off. And we can continue to oiling machine to the maximum oil line. And then the other icon on the operation panel ③ would light up and send out warning tone to warn us that the oil is full and stop oiling.

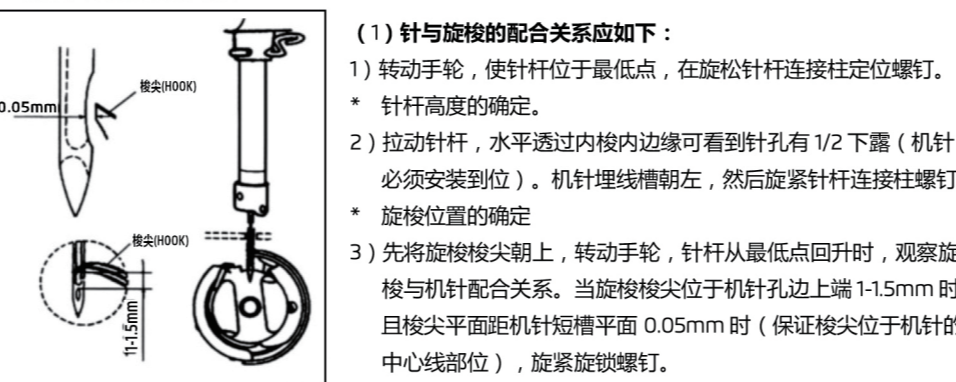
3)Running the machine after adding oil, if it's normal of lubrication, we can see the oil flow through the window ⑦.

How much the flow oil is no relevant to how much oil .
The new machine should be replaced after 1 month, and the oil should be replaced every six months later.

5.上线的穿线方法/THREADING THE MACHINE HEAD



6.机针与旋梭的关系/NEEDLE-TO-HOOK RELATIONSHIP

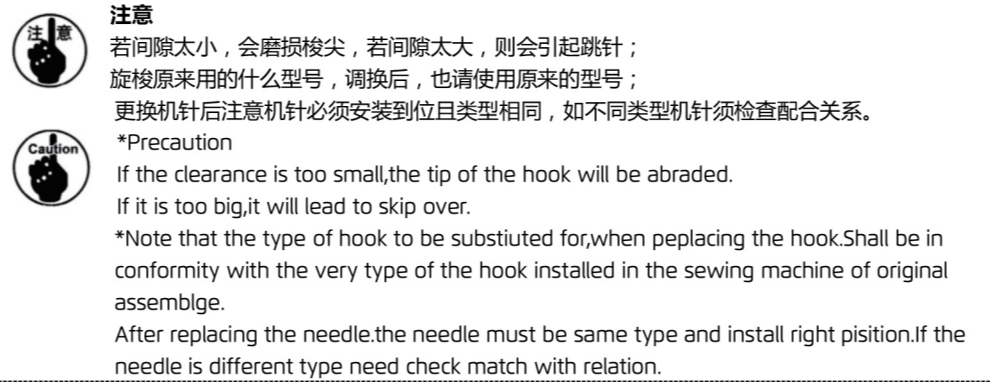


(1) 针与旋梭的配合关系应如下：

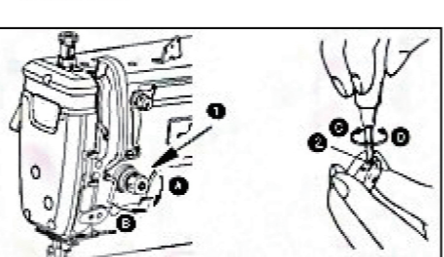
- 1) 转动手轮，使针杆位于最低点，在旋梭杆连接柱定位螺钉。
* 针杆高度的确定。
- 2) 拉动针杆，水平透过内梭内边缘可看到针孔有 1/2 外露（机针必须安装到位）。机针埋线槽朝左，然后旋紧针杆连接柱螺钉。
* 旋梭位置的确定
- 3) 先将旋梭梭尖朝上，转动手轮，针杆从最低点回升时，观察旋梭与机针配合关系。当旋梭梭尖位于机针孔边上端 1-1.5mm 时且梭尖平面距机针短槽平面 0.05mm 时（保证梭尖位于机针的中心线部位），旋紧旋梭螺钉。

(1) Adjust the timing between the needle and the hook as follow:

- 1) Turn the handwheel by hand to bring the needle bar down to the lowest point of its stroke,and loosen sntscrow.
- * Adjusting the needle bar height
- 2) Pull the needle baryou can see the pinhle basset 1/2 level through edge of inside hook(needle must be position). Turn needle cover wire slot left,then tighten setscrew.
- * Adjusting position a of the hook
- 3) First move the point of hook in direction, when running strap pulley needle bar risen from the lowest,Observe cooperate relation of the hook and needle.When hook point above Pinhole about top of 1mm to 1.5mm and when plane of the hook point form plane of needle short bar 0.05mm(keep the align hook blade point with the center of needle),tighten the hook setscrews.



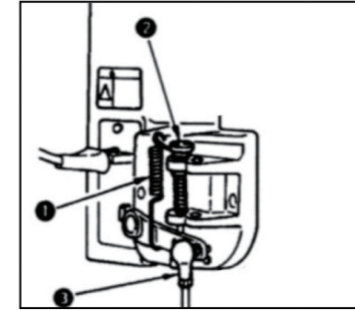
7.缝线张力/TREAD TENSION



- (1)Adjusting the needle thread tension
 - 1)Adjust the needle thread tension using tension adjust just nu ① according to the sewing specifications.
 - 2)As you turn nut ① clockwise(in direction A),the needle thread tension will increase.
 - 3) As you turn nut ① counterclockwise(in direction B),the tension will decrease.
- (2)Adjusting the bobbin thread tension
 - 1) As you turn tension adjust screw ② clockwise(indirection C),the bobbin thread tension will increase.
 - 2)As you turn screw ② counterclockwise(in direcrion D),the bobbin thread tension will decrease.

- (1) 面线张力的调节：
 - 1) 根据不同的缝制条件，用螺母 ① 来调整面线张力。
 - 2) 若把螺母 ① 按顺时针方向（即 A 方向）转动时，面线张力将增大。
 - 3) 若把螺母 ① 按逆时针方向（即 B 方向）转动时，面线张力将减小。
- (2) 底线张力的调节：
 - 1) 将夹线螺钉 ② 朝顺时针方向（即 C 方向）转动时，底线张力将增大。
 - 2) 将夹线螺钉 ② 按逆时针方向（即 D 方向）转动时，面线张力将减小。

8.踏板压力和行程/PEDAL PRESSURE AND PEDAL STROKE



(1) 踏板踩踏压力的调整

- 1) 更换踩踏弹簧 ① 的位置，可调整踩踏压力。
- 2) 把弹簧挂到左侧之后，压力变轻。
- 3) 挂到右侧之后变重。

(2) 踏板回弹力的调整

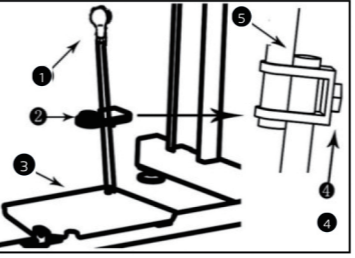
- 1) 用踏板回弹压力调节弹簧 ② 可以调整。
- 2) 拧进调节螺丝则压力变大。
- 3) 拧松调节螺丝则压力变小。

(3) 踏板踩踏行程的调整

- 1) 把连接杆 ③ 插到右侧的孔里之后行程变大。

- (1)Adjusting the pressure required to depress the front part of pedal
 - 1)This pressure can be changed by changing the mounting position of pedaling pressure adjust spring ①.
 - 2)The pressure decreases when you hook the spring on the left side.
 - 3)The pressure increases when you hook the spring on the right side.
- (2)Adjusting the pressure required to depress the back part of the pedal
 - 1)This pressure can be adjusted using regulator screw ②.
 - 2)The pressure increases as you turn the regulator screw in .
 - 3) The pressure decreases as you turn the screw out.
- (3)Adjusting the pedal stroke
 - 1)The pedal stroke increases when you insert connecting rod ③ into the right hole.

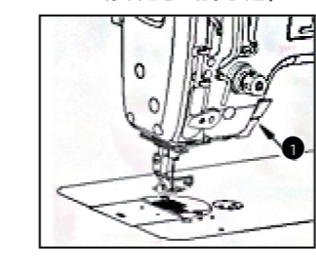
9.踏板的调整/ADJUSTMENT OF THE PEDAL



- (1) 连接杆的安装
 - 1)向箭头方向移动踏板调节板 ① 让连接杆球形头 ① 和连接杆 ② 成一直线。
- (2) 踏板的角度
 - 1)调节连杆的长度就可以自由的改变踏板的倾斜度。
 - 2)拧松调节螺丝 ③，拉出插入连接杆 ④ 进行调整。

- (1) Installing the connecting rod
 - 1)Move pedal to the right or left as illustrated by the arrow so that spher ical head and connecting rod are straightende.
- (2) Adjusting the pedal angle
 - 1)The pedal tilt can be freely adjusted by changing the length of the connecting rod.
 - 2)Loosen adjust screw,and adjust the length of connecting rod.

10.触键手动倒缝(盒式)/ONE-TOUCH TYPE REVERSE FEED STITCHING MECHANISM



(1) 使用方法

- 1) 按下开关按钮 ①，缝制机立即倒缝。
- 2) 在按下的时间内进行倒缝。
- 3) 手一松开立即变为正向缝制。

(1)How to operate

- 1)The moment switch bottom ① is pressed,the mahine performs reverse feed stitching.
- 2)The machine performs reverse feed stitching as long as the switch lever is held depressed.
- 3)The machine resumes normal feed stitching the moment the switch leveris released.

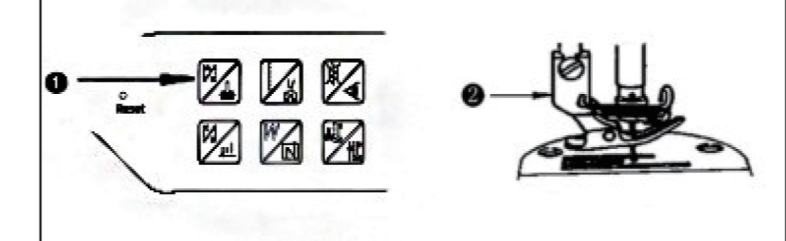
11.挑线簧/TREAD TAKE UP SPRING

- (1) 改变挑线簧 ① 的摆动量：
 - 1) 旋松定位螺钉 ②。
 - 2) 把夹线螺钉 ③ 朝 ① 顺时针方向（即 A 方向）转动时，挑线簧的摆动量将增大。
 - 3) 把夹线螺钉朝逆时针方向（即 B 方向）转动时，挑线簧的摆动量将减小。

(2) 改变挑线簧 ① 的张力：

- 1) 旋松定位螺钉 ②，取出夹线器（组件）③。
 - 2) 旋松定位螺钉 ④，并转动夹线螺钉 ⑤。
 - 3) 把夹线螺钉 ⑥ 朝顺时针方向（即 A 方向）转动时，挑线簧张力将增大。
 - 4) 把夹线螺钉 ⑥ 朝逆时针方向（即 B 方向）转动时，挑线簧张力将减小。
- (1)Changing the stroke of thread take-up spring ①
 - 1) Loosen setscrew ②.
 - 2)As you turn tension post ③ clockwise (in direction A),the stroke of thread take-up spring will be increased.
 - 3)As you turn the knob counterclockwise (in direction B),the stroke will be decreased.
 - (2)Changing the pressure of thread take-up spring ①
 - 1)Loosen setscrew ② ,and take out tension asm ③.
 - 2)Loosen setscrew ④ ,and remove tension post ⑤.
 - 3)As you turn tension post ⑥ clockwise(in direction A),the pressure will be increased.
 - 4)As you turn the post counterclockwise(in direction B),the pressure will be decreased.

12 少鸟巢功能/ Less bird's nest



- (1) 机器开启后，长按 ① 实现少鸟巢功能的开启和关闭；
- (2) 在开始缝制后，夹住的线头在缝制过程中多次无法割断后需要更换相匹配的压脚 ②。

- (1) After open the machine ,long press to ① achieve the function for the bird's nest of opening and closing.
- (2) After the start sewing, the thrum of the clamp cannot be cut off many times in the process of sewing ,then you need to change the matched presser foot ②.

工业缝纫机安全使用注意事项：

1. 必须遵守基本措施；
2. 必须经过专业培训，对缝纫机设备性能有所了解；
3. 使用前应检查所有安全装置；
4. 在安装机针、更换机针、压脚、针板、送布牙、弯针、旋梭或修理时，应立即关闭电源；
5. 离开缝纫机或工作场所时应关闭电源；
6. 使用离合马达时，要等待马达完全停止后再进行；
7. 缝纫机及附属装置使用的机油，润滑油等液体流入眼睛或沾到皮肤上应立即清洗；
8. 禁止用手触摸缝纫机通电时的零件或装置；
9. 有关工业用平缝机与包缝机的修理、改造、主要机构的调整由专门技术人员来进行；
10. 一般的维修保养由专人进行；
11. 在电气方面的修理应在电气技术员的监督和指导下进行；
12. 缝纫机使用期间应定期清扫；
13. 为了正常安全运转，应安装地线，同时应在不受高频焊接机等强噪声源影响的环境下使用；
14. 电源插头应由专人安装；
15. 工业用平缝机、包缝机在指定用途以外不能使用。

环保要求：

- 1、使用过程中产生的废油及其他废弃物请根据当地环保的要求进行合理的处置。
- 2、请在使用后及时关闭电源，减少电能的消耗。
- 3、请在说明书要求的电压及环境下使用，已延长产品的使用寿命，减少废弃物的产生。
- 4、机器报废后请勿将本机器及其附件作为普通的生活垃圾处理。请遵守本设备及其附件处理的本地法令，并支持回收行动。

Notes for safe use of industrial sewing machines：

- 1.Basic measures must be observed.
2. Pass the specialized training and master sewing machine equipment performance.
3. All safety devices should be checked before use.
4. When installing needle, and changing needle, presser foot, plate, feed dog , bent needle, hook or repairing, the power supply should be turned off immediately.
5. Power should be turned off when leaving the sewing machine or workplace.
6. When using the clutch motor, please wait until the motor stops completely.
7. The machine oil and other liquids used in sewing machines and ancillary devices should be cleaned immediately when they are put into eyes or touch skin.
8. Do not touch the parts or devices when the machine is powered by hand.
9. The repair, renovation and adjustment of the main mechanisms of the relevant industrial sewing machines and overseers shall be carried out by specialized technicians.
10. General maintenance is carried out by specially-assigned persons.
11. Electrical repairs should be performed under the supervision and direction of the electrical technician.
12. The machine should be cleaned regularly during operation.
13. In order to operate normally and safely, ground lines should be installed, and they should be used in an environment free from strong noise sources such as high frequency welding machine.
14. Power plug should be installed by specially-assigned person.
15. Industrial lockstitch sewing machine and overlock sewing machine can not be used except the designated use.

Environmental requirements：

- 1、Please dispose the waste oil and other waste products properly according to local environmental protection requirements.
- 2、Please turn off the power after use to reduce power consumption.
- 3、Please use under the voltage and environment required in the manual to extend the service life of the product and reduce waste generation.
- 4、Do not treat the machine and its accessories as ordinary household garbage after being scrapped. Please comply with local laws governing the disposal of the equipment and its accessories and support recycling operations.