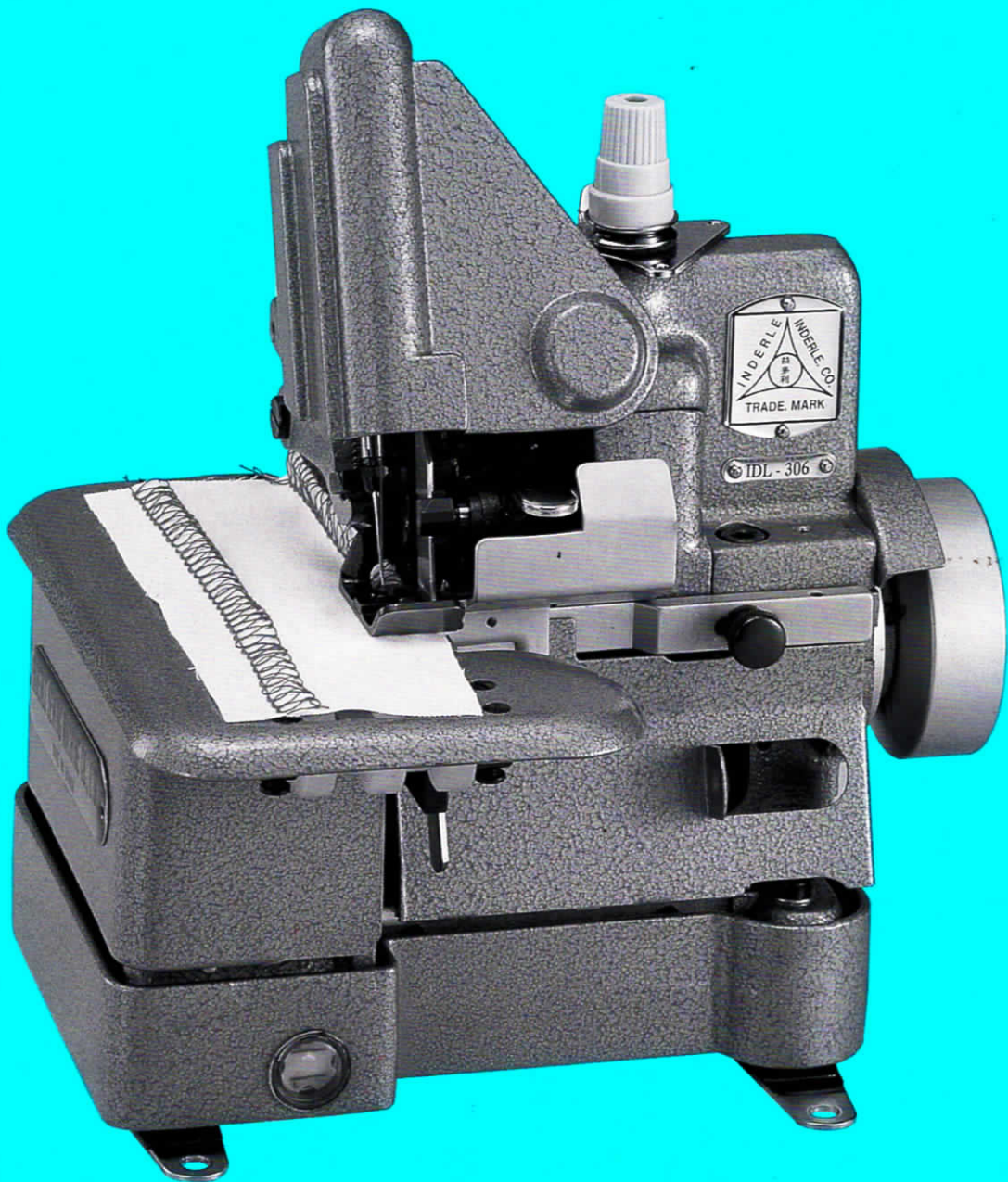





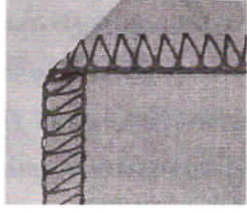
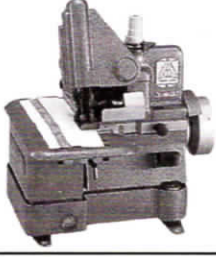
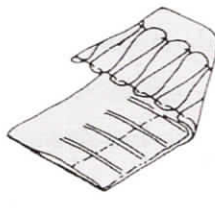
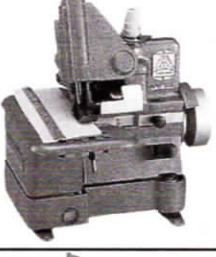
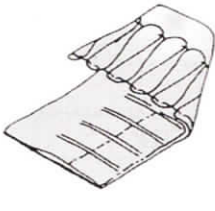








益多利縫機有限公司 INDERLE

INSTRUCTIONS FOR IDL-300 SERIES



*HIGH SPEED OVERLOCK
SEWING MACHINE*

		MODEL-302 (1 THREAD) ABUTTED SEAM SEWING MACHINE 一般皮革、染整接布機專用 (1線) For joining temporarily the abutted edges of piece goods for processing in bleaching, dyeing and printing factories.
		MODEL-303 (3 THREAD) OVERLOCK ABUTTED SEAM SEWING MACHINE 拷克車接布機專用 (3線) For joining temporarily the abutted edges of piece goods for processing in bleaching, dyeing and printing factories.
		MODEL-306 (2 THREAD) ABUTTED SEAM SEWING MACHINE 一般染整接布機專用 (2線) For joining temporarily the abutted edges of piece goods for processing in bleaching, dyeing and printing factories.
		MODEL-306A (2 THREAD) ABUTTED SEAM (MORE WIDTH) SEWING MACHINE 皮革、刷毛布厚類接布機專用 (特寬2線) For joining temporarily the abutted edges of piece goods for processing in bleaching, dyeing and printing factories.
	  3 P 2 P	MODEL-308 (2 THREAD、3 THREAD) CARPET OVEREDGING、NO TRIMMER SEWING MACHINE 地毯包邊機(厚類)無附切刀 (2線、3線) For overedging on carpet and similar goods of heavy materials.
	  3 P 2 P	MODEL-309 (2 THREAD、3 THREAD) CARPET OVEREDGING、WITH TRIMMER SEWING MACHINE 地毯包邊機(中厚類)附切刀 (2線、3線) For overedging on carpet and similar goods of heavy materials.

SPECIFICATIONS

MODEL	NEEDLE	THREAD	mm	ABUTTED WIDTH	mm	CUFT	G.W.	N.W.
MODEL-302	DCx27 #16	1	----	10-13	1.8-6	1.4 CUFT	16 KG	13 KG
MODEL-303	DCx27 #16	3	----	8-10	1.8-6	1.4 CUFT	16 KG	13 KG
MODEL-306	DCx27 #16	2	----	10-13	1.8-6	1.4 CUFT	16 KG	13 KG
MODEL-306A	DCx27 #16	2	----	12-14	1.8-6	1.4 CUFT	16 KG	13 KG
MODEL-308	DMx5 #23 TTx81#23	3	10	----	1.8-4.5	1.4 CUFT	16 KG	13 KG
MODEL-309	DMx5 #23 TTx81#23	3	10	----	1.8-4.5	1.4 CUFT	16 KG	13 KG

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1、 Classification of Machines / 機型

IDL-302 : For joining temporarily the abutted edges of piece goods for processing in bleadching, dyeing and printing factories. (1 Thread)

皮革及一般布料染整專用單線接布機

IDL-306 : For joining temporarily the abutted edges of piece goods for processing in bleadching, dyeing and printing factories. (2 Threads)

染整專用雙線接布機

IDL-306A : For joining temporarily the abutted edges of piece goods for processing in bleadching , dyeing and printing factories . (2 Threads & width seam)

皮革及一般布料專用雙線接布機

IDL-308 : For sewing Carpet and other materials of extra heavy duty, without knives for cutting fabric. (3 Threads)

無切刀 3 線地毯包邊機

IDL-309 : For sewing Carpet and other materials of extra heavy duty, with knives for cutting fabric. (3 Threads)

附切刀 3 線地毯包邊機

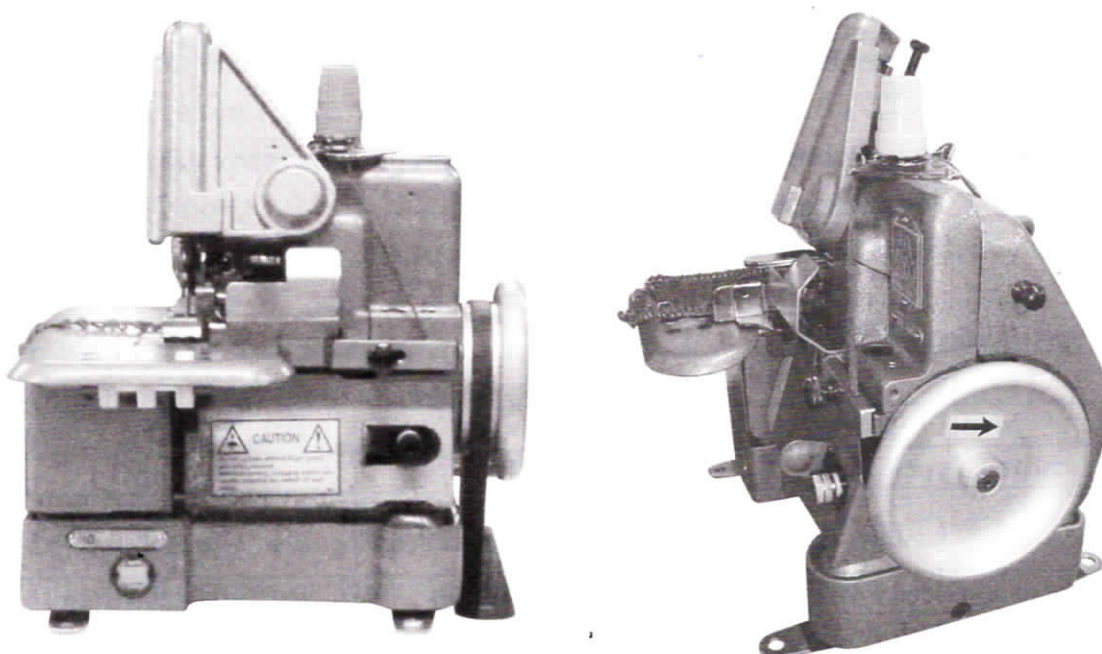
2、 Specification / 規格

Model / 型號	IDL-308、309	IDL-302、306、306A
Stitch Type / 線跡	504 (ISO)	503 (ISO)
Use / 功能	For carpet overedge 地毯包邊機	For abutted seam. 染整接布機
Sewing Speed / 轉速	Up to 3,000 s.p.m.	Up to 4,200 s.p.m.
Stitch Length / 針距	1.6~4.2mm / 6~16 stitches per inch	
Width of Overedge Seam / 包邊寬度	9.0 mm (standard)	Seam width 7 mm Open width 14 mm
Needle Size / 針號	DMX5 #22 #23	DCX27 #16
Needle Bar Stroke 針柱衝程	30 mm	
Presser Foot Lifting 押腳高度	4.3 mm	2.5 mm
Lubrication Oil / 潤滑油	“ SF OIL ” or “ TERESSO 46 ”	

3、 Installation / 安裝

Standard Installation—the machine shall be installed on the top face of Table. Put the machine at the fixed place on the Table and tighten Screws. The machine is obtainable in a set with Table, if necessary, as we are ready to supply all parts concerned together with Table. Fit Velt Cover to Velt Cover Support as shown in the sketch.

機器必須安裝在桌板的頂面，將機頭放置於桌面固定的地方並用螺絲鎖緊，然後才能開始安裝其他桌上的零組件。機頭安裝如下列圖示：



4、 Sewing Speed and Rotation of Pulley / 浦力 Pulley 的旋轉方向與轉速

The highest sewing speed is 3,000 s. p. m. for IDL-308、IDL-309 and 4,200 s. p. m. for IDL-306. For the brand – new machines, it is recommended to rotate 15% ~ 20% under max. speed for the initial 200 hours (one month approximately). This manner will bring the good result to the durability of machines. Sa seen from the side of Pulley, the machine rotates to the right direction.

IDL-308 & IDL-309 最高縫速為 3,000 S.P.M.，IDL-302 & IDL-306 & IDL-306A 最高縫速為 4,200 S.P.M.。對於新機頭建議在最初的200小時內使用低於最高縫速15%~20%的縫紉速度使用，將會提高機頭的耐久性。朝浦力Pulley方向看去，浦力Pulley是向右方旋轉。

5、 Setting of Motor and Belt / 馬達及皮帶設定

Clutch Motor of 200 W (1/4 HP) shall be used and V-Belt of Type “M” also. To position the Motor, as the sketch shows, align both center lines of Motor Pulley and Machine Pulley exactly.

200W (1/4 HP) 離合器馬達 Clutch Motor 必須搭配 “M”-V 字型皮帶 Belt 使用，馬達的放置位置如下列圖示，機頭的浦力 Pulley 與馬達的浦力 Pulley 的相對位置須調整為一直線。

External Diameter Of motor Pulley 馬達浦力的外部直徑	Rotation of Machine / 機型			
	IDL-302、306、306A		IDL-308、309	
	50HZ	60HZ	50HZ	60HZ
50mm	--	3,200	--	2,300
55mm	--	3,500	--	2,600
60mm	3,200	3,800	2,300	2,800
65mm	3,500	4,200	2,600	3,000
70mm	3,800	--	2,800	--
75mm	4,000	--	3,000	--
80mm	4,300	--	--	--

External Diameter of Machine Pulley specified on the Table here above are those nearest to calculated values, because Pulleys are being sold at the step of 5mm in the market.

6、 Lubricant / 潤滑系統

6-1、 Lubrication Oil / 潤滑油

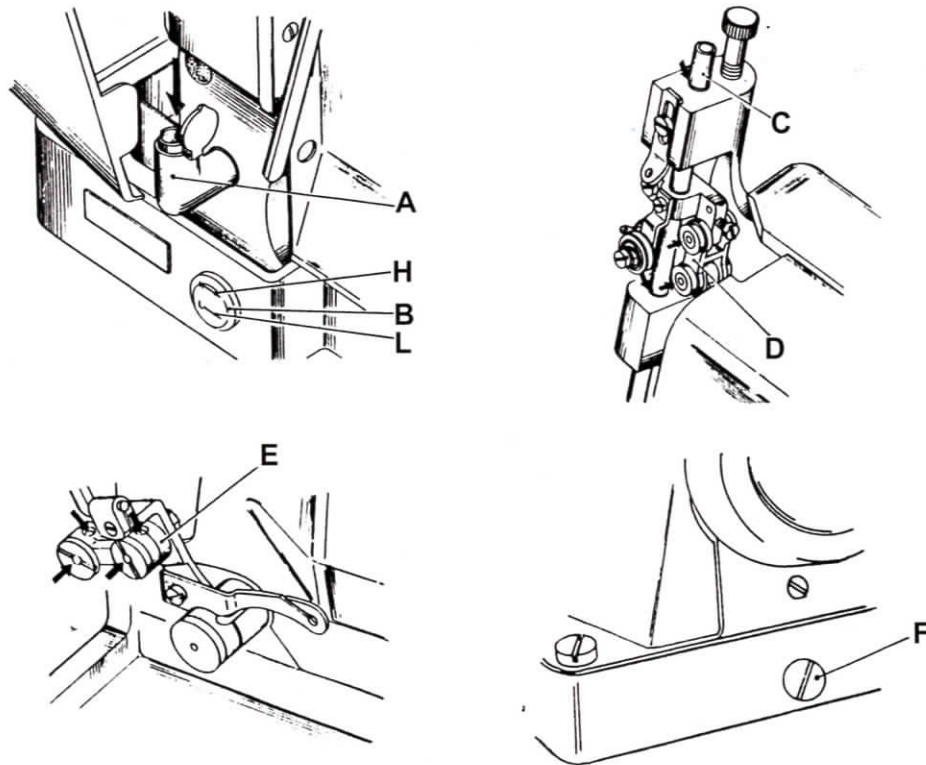
Use “SF OIL” or “TERESSO 46” as the lubricant for this machine.

潤滑系統使用 SF OIL 或 TERESSO 46 針車油。

6-2、 Oil Feeding / 油料供應

Oil in the machine will have been drained completely at the time of delivery, so it must be fed with new oil before operation. Feeding shall be made quietly to Oil Cap(A) and the oil surface must be kept between two Lines(H) , (L) on Oil Sight Gauge(B) . And, at least once each in the morning and afternoon, feed oil manually to Needle Bar(C) , Needle Bar Connecting Link(D) and Lower Looper Connecting Link(E) . However, fabrics may be soiled when feeding oil around Needle Bar too much. Take care , please .

油料在機器運轉輸送中將會被消耗，所以機頭在運轉前必須添加新的針車油。油料由油蓋 Oil Cap(A)添加至油面到油表 Oil Sight Gauge(B)的 H 線及 L 線之間為止，並且在早上及下午最後一次使用後必須對針柱 Needle Bar(C)、針柱連結桿 Needle Bar Connecting Link(D)及下鉤針連結桿 Lower Looper Connecting Link(E)添加潤滑油，但是針柱 Needle Bar 若添加太多潤滑油時可能會污染到布料。



6-3、Oil Exchange / 潤滑油的替換

After the initial 200 hour's use of new machine, to keep it long life, remove Drain Screw (F) under the Pulley and drain used oil completely to change for new oil.

At this time remove Base from the machine and clean filter Screens and inside of the Base. The cleaning must be made 2 or 3 times regularly in a year.

新機頭在最初的200小時運轉後請替換新油料以增加機器壽命，請轉開在浦力 Pulley 下方的排油螺絲 Drain Screw(F)並更換新的油料。此時，並移開底座 Base 上的機頭，清洗過濾器 Filter Screens 及底盤，每年必須定期做 2~3 次的清洗。

7、 Proper Operation / 操作運轉

7-1、 Needle to Be Used- / 車針的使用、

For IDL-302、306、306A : DCX27 #16

For IDL-308、309 : DMX5 #22 #23

As the standard size, #22 or # 23 is used.

But, # 16 can be used by changing Stitch Plate and Needle Guard.

So, the needle of suitable size to the sewing condition must be selected.

IDL-302、306、306A使用 DCX27 #16 的車針。

IDL-308、309 使用 DMX5 #23 的車針。

7-2、 Setting of Needle / 車針的安裝

Needle must be set correctly facing its scarf towards the back side of machine as shown in the sketch.

The setting order is :

1 > Turn Pulley until Needle Bar(A) reaches its highest position.

2 > Loosen Nut(B) of Needle Clamp by Wrench Spanner and pull off the needle downwards.

3 > Insert new needle to Needle bar to the facing is obtained as mentioned above.

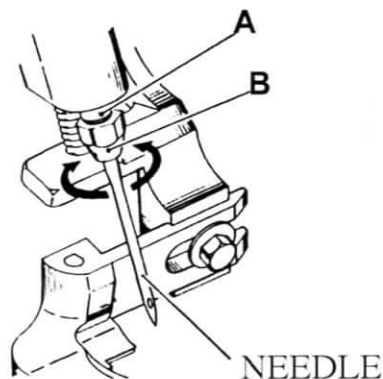
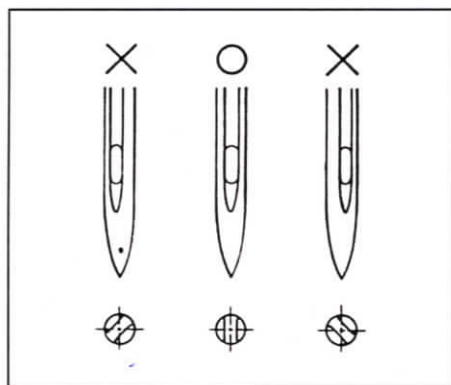
車針必須像下列圖示般安裝，針頭的斜面必須背向機器安裝。

安裝步驟：

(1)、轉動浦力 Pulley 直到針柱 Needle Bar(A)上移到最高位置。

(2)、將針留 Nut of Needle Clamp(B)鬆開並取下車針。

(3)、放入新的車針於針柱Needle bar(A)內並調整好位置後鎖緊針留 Nut(B)。



7-3、 Threading / 穿線

Threading must be made correctly according to the sketch .

A : Needle Thread B : Upper Looper Thread C : Lower Looper Thread

縫紉線必須像下列圖示般的正確安置。

A : 車針穿線法 Needle Thread ◦

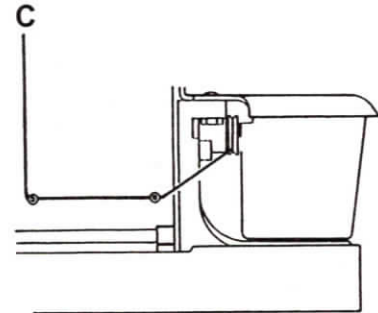
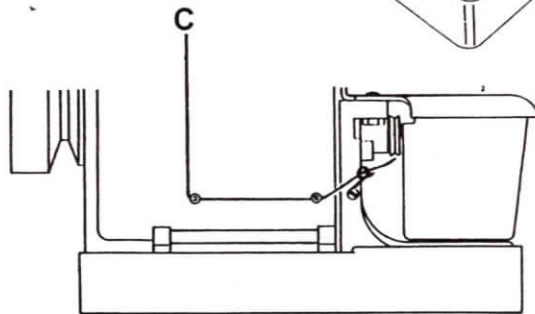
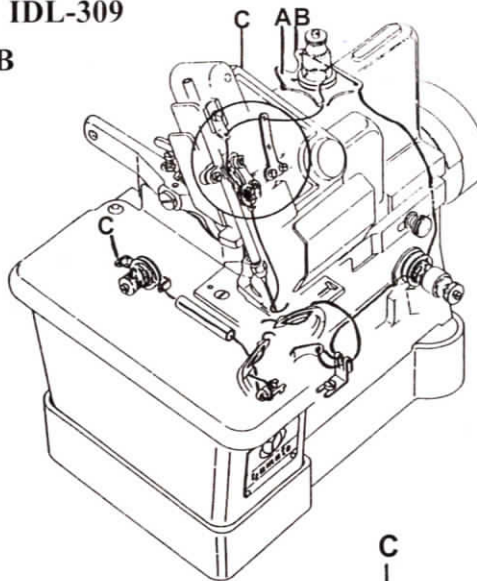
B : 上鉤針穿線法 Upper Looper Thread ◦

C : 下鉤針穿線法 Lower Looper Thread ◦

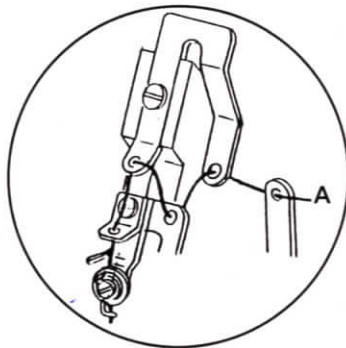
IDL-303 IDL-304

IDL-308 IDL-309

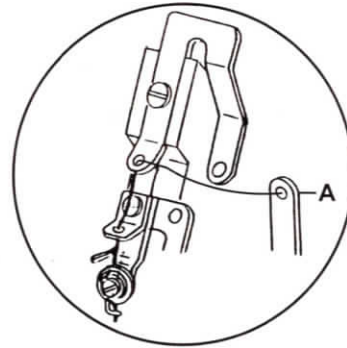
IDL-309B



IDL-302



IDL-306
IDL-306A



7-4、 Thread Tension / 線的鬆緊

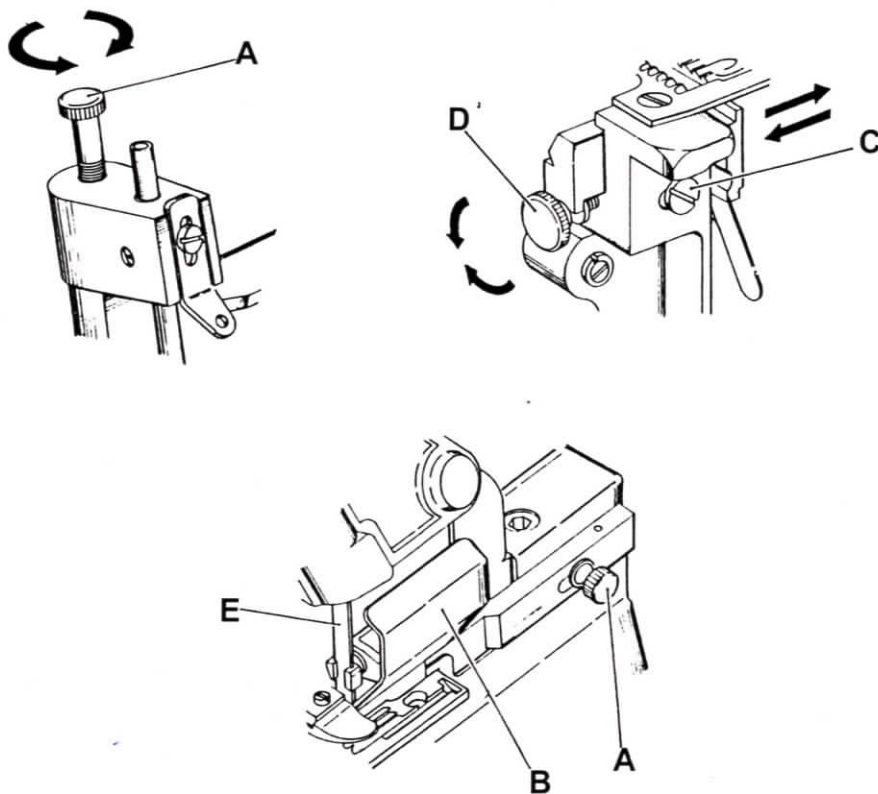
Thread tension shall be varied according to the kind of fabrics on threads, width of overedge seam, stitch length and other factors. So, adjust the thread tension mechanism for needle thread and upper, lower looper threads to obtain the suitable seam.

線的鬆緊會因線本身的材質、縫合的寬度 Width of Overedge Seam 及針距的長度 Stitch Length 和其他因素而多樣化，故可由調整車針 Needle 及上下鉤針的紗拉組彈簧來達到適當的縫合效果。

7-5、 Pressure of Presser Foot / 押腳的壓力

the pressure of Presser Foot must be adjusted as weakly as possible. If it is too weak, however, uniformity in the feeding and seaming may be lacked. The pressure shall be strengthened when Adjusting Screw(A) is turned to right and weakened by turning(A) to left.

押腳的壓力必須盡可能的調低，但如果調的太低則會影響車縫的針距與線跡的穩定度，押腳的壓力可由調整螺絲 Screw(A) 來改變，轉右邊則增加押腳壓力、轉左邊則會減少押腳壓力。



7-6、 Adjustment of width of Overedge Seam IDL-306、309

The width of Overedge Seam can be adjusted by cutting margin of material by knife.

縫接寬度 Width of Overedge Seam 的調整 (IDL-306、IDL-309)
依照布料被裁刀裁切的大小來調整邊緣縫接口的寬度。

The adjustment is made in the following order :

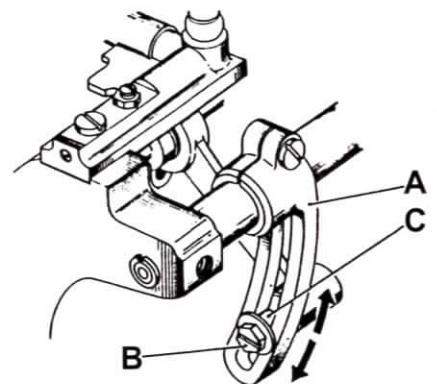
- 1 >、 Loosen Screw(A) of Chip Guard and move the Chip Guard(B) to the right.
- 2 >、 Loosen Screw(C) for Lower Knife Holder, and turn Screw(D) . Turning(D) to the right the width of Overedge Seam becomes wide and turning it to the left it becomes narrow.
- 3 >、 After adjustment, tighten Screw(C) .
- 4 >、 With Chip guard(B) contacting lightly to the Upper Knife(E) , tighten Screw(A) .

調整步驟:

- (1)、 鬆開螺絲Screw(A) 並把護刀蓋 Chip Guard(B) 向右推開。
- (2)、 轉開下刀座螺絲 Screw for Lower Knife Holder(C) 並調整螺絲 Screw(D) , 螺絲 Screw(D) 轉右邊會增加縫接的寬度, 轉左邊則會減少縫接的寬度。
- (3)、 調整完畢後, 鎖緊螺絲 Screw(C) 。
- (4)、 於護刀蓋 Chip Guard(B) 輕觸上切刀Upper Knife(E) 後, 鎖緊螺絲 Screw(A) 。

7-7、 Adjustment of Stitch Length / 針距長度 Stitch Length 的調整

Stitch length can be adjusted from 1.6 mm to 6 mm steplessly. To obtain the stitch length as you desire, loosen Adjusting Screw(B) of Feed Regulator(A) and move Feed Dog Driving Connecting Rod(C) up and down along the groove of the Regulator(A) . The stitch length becomes long when the Rod(C) is raised and short when the Rod(C) is lowered.



針距長度 **Stitch Length** 能調整到 1.6 mm~6 mm，可依需求調整針距長度。

調整步驟：

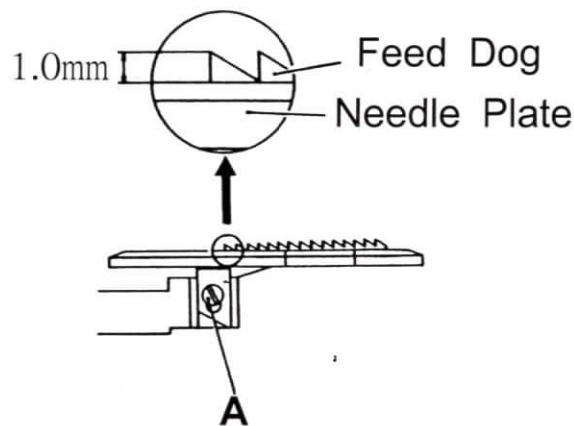
- (1)、鬆開狗齒調整器的調整螺絲 **Screw of Feed Regulator(B)**，並順著調整器的凹溝向上及向下移動狗齒連結桿 **Feed Dog Driving Connecting Rod(C)**。
- (2)、當連桿 **Rod(C)** 往上移動時針距長度便會變長，向下移動時針距長度便會減短。

8、Proper Adjustment / 一般調整

8-1、Adjustment of Feeding Mechanism / 狗齒機構的調整

1>、Height / 高度

When Feed Dog reaches the highest position, loosen Screw(A) and adjust the last teeth edge on the tail of Feed Dog to have 1.0 mm for the height from top of Stitch Plate.



當狗齒達到最高點時，鬆開螺絲 **Screw(A)** 並調整狗齒 **Feed Dog** 使其尾部的最後一齒離針板表面高度約 1.0 mm。

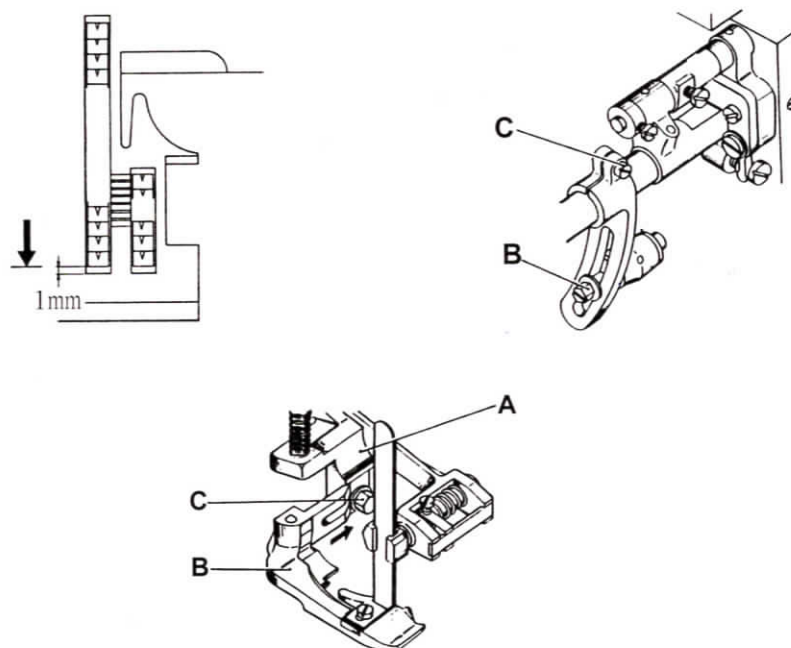
2>、Longitudinal Position / 擺動位置

Loosen Adjusting Screw(B) of Feed Regulator and tighten it at the highest position .

When Feed Dog comes to the foremost by turning Pulley , adjust the allowance between Front of groove in Stitch Plate and the point of Feed Dog to be 1mm. Then, tighten Screw(C) of Feed Regulator.

After the above adjustment , refer to 7-7 “Adjustment of Stitch Length” Screw of Feed Regulator(C) . adjust to obtain the suitable stitch length by loosening Adjusting Screw(B) .

鬆開狗齒調整器的調整螺絲 **Screw of Feed Regulator(B)**，並在最高點位置時鎖緊。轉動浦力 **Pulley** 讓狗齒 **Feed Dog** 移到最前面，調整狗齒讓針板的凹槽與狗齒最前點的間距約 **1mm** 時，鎖緊針距調整器的絲 **Screw of Feed Regulator(C)**。



8-2、Adjustment of Presser Foot Mechanism / 押腳機構調整

1 >、Fitting of Presser Foot / 安裝押腳

Turn Pulley until Needle Bar comes the highest position, then insert Presser Foot(B) to the groove of Presser Arm(A). And, turn Pulley again and adjust the needle to drop to the center of needle drop portion on Presser Foot. And tighten Screw(C).

轉動浦力 **Pulley** 直到針柱 **Needle Bar** 上移到最高位置，然後將押腳 **Presser Foot(B)** 插入押腳臂 **Presser Arm** 的凹槽(A)。其次轉動浦力並調整車針使其下降到押腳上的車針孔，然後鎖緊螺絲 **Screw(C)**。

2 >、Height of Presser Foot / 押腳的高度

Adjust the height according to the following order :

a >、Remove Foot lifter Lever(D) .

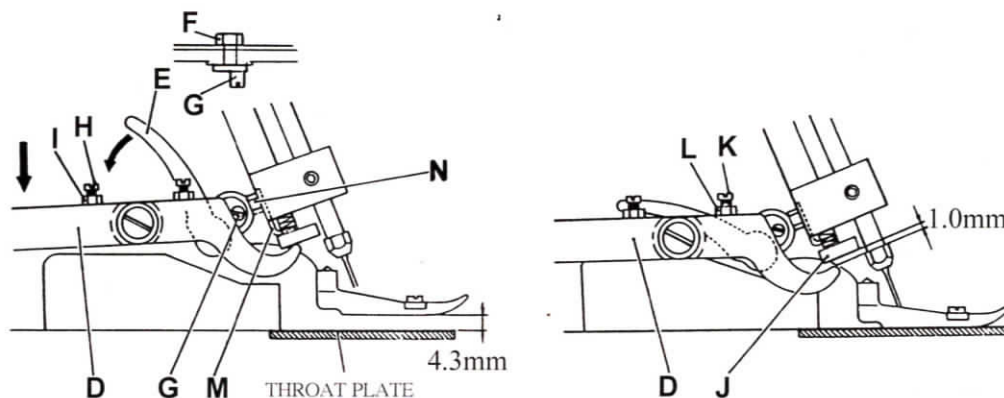
b >、Raise foot Lifter Hand lever(E) .

c >、Loosen Nut(F) and turn Screw(G) of Presser Arm Eccentric to obtain 4.3mm (2.5 mm for IDL-306) , the distance between the bottom of Foot and the top face of Stitch Plate. Re-tighten Nut(F) .

- d > 、 Fit foot Lifter Lever(D) .
- e > 、 Loosen Adjusting Screw(H) and push Foot Lifter Lever(D) downwards by hand until Foot Lifter Hand Lever(E) falls to the arrow direction . Tighten Nut(I) .
- f > 、 When Presser Foot Lowers to the top face of stitch Plate, turn Adjusting screw(K) and adjust the allowance between foot Lifter Lever(D) and the bottom of Presser Arm(J) to be 1.0 mm, then tighten Nut(L) .

依照下列步驟調整押腳高度：

- (a) 、移動押腳拉桿 Foot Lifter Lever(D) 。
- (b) 、抬起押腳手拉桿 Foot Lifter Hand Lever(E) 。
- (c) 、鬆開螺絲帽 Nut(F) 並轉動押腳偏心螺絲 Screw of Presser Arm Eccentric(G) 使押腳底部與針板 Stitch Plate 的表面間距 機型：309 為 4.3 mm / 機型：306 為 2.5mm，然後鎖緊螺絲帽 Nut(F) 。
- (d) 、調整押腳拉桿 Foot Lifter Lever(D) 。
- (e) 、鎖緊調整螺絲 Screw(H)，並且用手把押腳拉桿 Foot Lifter Lever(D) 向下押直到押腳手拉桿 Foot Lifter Hand Lever(E) 下降到箭頭的方向為止，然後鎖緊螺絲帽 Nut(F) 。
- (f) 、當押腳下降到針板的表面時，轉動調整螺絲 Screw(K) 使押腳拉桿 Foot Lifter Lever(D) 和押臂 Presser Arm 底部(J) 的間距為 1.0mm，然後鎖緊螺絲帽 Nut(L) 。



During operation , when Presser Foot agrounds on the very thick part of fabric and lifts beyond 4.3 mm , Loper may contact the Foot . As the result , Loper and other parts may be dam aged . For those obstruction as mentioned above , keeping the Foot lifted in 4.3 mm , apply Presser Arm Stopper(M) to Presser Arm(J) and tighten Screw(N) .

若在運轉當中押腳因厚重布料且會被向上頂超過 4.3mm 時，鉤針 Looper 可能會觸碰到押腳 Foot 造成鉤針和其他零件的損害。對於上述情況可使押腳抬起 4.3 mm 並讓押臂制止器 Presser Arm Stopper(M) 頂住押臂 Presser Arm(J) 然後鎖緊螺絲 Screw(N)。

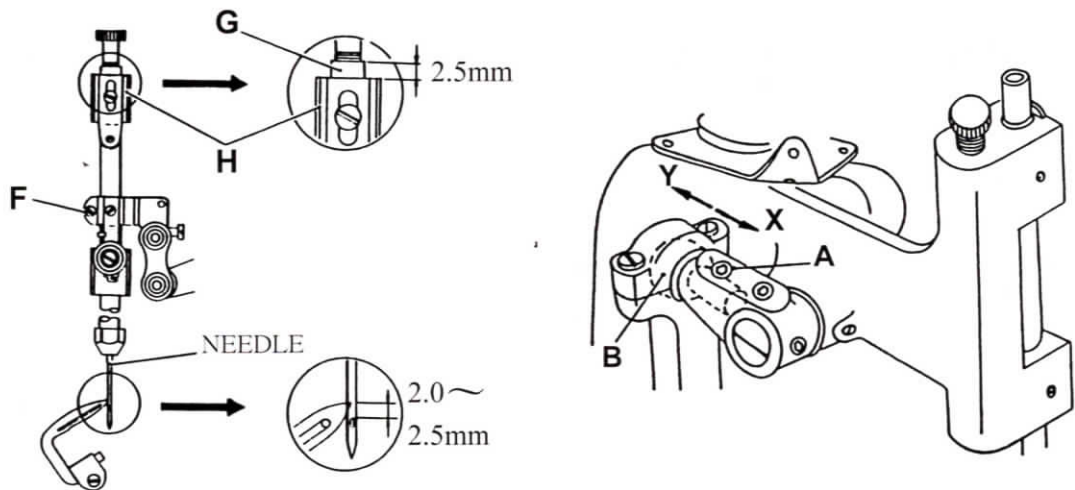
8-3、Adjustment of Needle Bar Stroke / 針柱上下擺動幅度Stroke的調整

The standard stroke of Needle Bar is 30 mm.

After loosening Screw(A), when Needle Bar Driving Crank Ball Stud(B) is put inside to the arrow direction(X) the stroke becomes big, and outside to the direction(Y) the stroke becomes small. Tighten Screw(A) after adjustment.

When Ball stud is put inside to the direction(X), be carefully that rod does not contact with crankshaft.

針柱上下擺動的標準幅度為 30mm，鬆開螺絲 Screw(A) 並且當連結球栓 Needle Bar Driving Crank Ball Stud(B) 向內(X) 方向移動時，則擺動幅度會變大(針柱拉高)，向外(Y) 方向移動時則針柱上下擺幅會變小，等調整到適當位置後鎖緊螺絲 (A)。當連結球栓Ball被放往(X) 方向時請注意不要碰觸到軸面。



8-4、Height of Needle Bar and Longitudinal Position of Lower Looper / 針柱的最高位置與下鉤針的擺動位置

When Lower Looper(E) moves to right from left end and its point reaches the center of Needle, adjust the distance between the looper point and the upper edge of needle eye to be 2.0~2.5 mm.

This adjustment is made by loosening Screw(F) of Needle Bar Connecting Bracket.

When Needle Bar lowers to its bottom, the distance between both upper edges of Needle Bar(G) and Arm(H) shall be 2.5mm. which is considered as the standard distance generally.

The point of Lower Loper passes behind Needle and they must be closed as near as possible but without touch. This adjustment is made by loosening Screw(I) .

當下鉤針 Lower Loper(E) 由右方移動到車針左方終端時，下鉤針的針尖要接觸到縫針的中心點位置，並調整鉤針的針尖與縫針針孔的上邊緣的間距為2.0~2.5 mm，此處由針柱托架螺絲 Screw of Needle Bar Connecting Bracket(F) 來調整。當針柱降至它的底部時，針柱 Needle Bar(G) 頂端與針臂 Needle Arm(H) 頂端的間距應該為2.5mm，這是一般標準的間距。下鉤針的針尖通過車針的背後時必須盡可能的靠近但不能相互碰觸，避免零件損壞。

8-5、Timing between Needle and Lower Loper / 車針與下鉤針的定位

When Lower Loper swings to left end, the distance between its point and the center of Needle shall be 3.0 mm. This adjustment is made by loosening Screw(J) and putting the Ball Stud(K) inside or outside. By putting the Ball Stud(K) inside to the direction(X) , the moving amount of the looper mechanism becomes big, and outside to the direction(Y) the amount becomes small. Owing to the abovementioned, the position of Lower Loper at its left end is changed inevitably. Furthermore, the portion(L) of Lower looper must always stick to Lower Loper Holder Arm.

當下鉤針向左移到終端時，針尖與車針中心點的間距應為 3.0mm，此可由螺絲Screw(J)與球栓 Ball Stud(K) 的內外移動來調整。把球栓 Ball Stud(K)往(X)方向內移則下鉤針的擺動速度將會變快，反之往(Y)方向外移則會變慢。歸於上述，下鉤針左移的最終位置的改變是不可避免的，且下鉤針的(L) 部份必須插牢於下鉤針臂 Lower Loper Holder Arm。

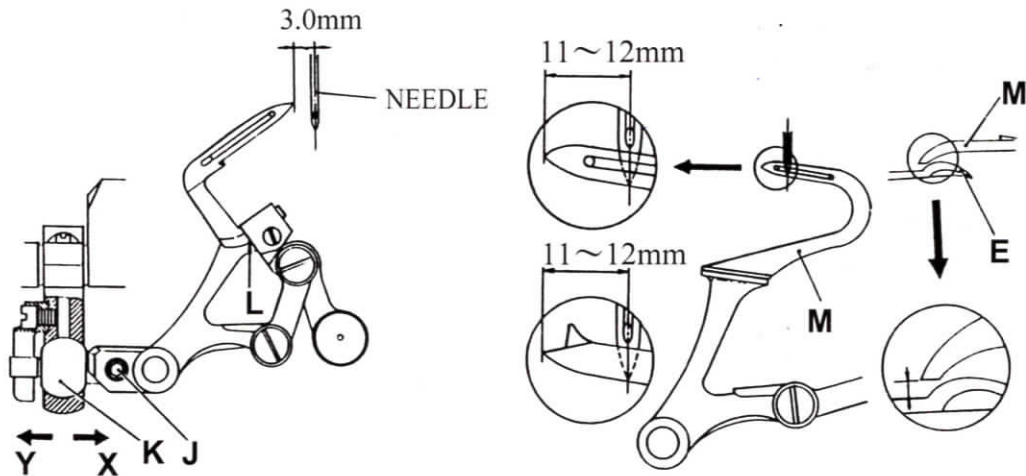
8-6、Relation between Upper and Lower Loopers / 上下鉤針的定位

When Upper Loper(M) and Lower Loper(E) meet together, the point of Upper Loper passes the depression just under the swelling on the back of the point of Lower Loper. at this moment, both Loopers must be closed as nearly as possible but without touch.

When Upper looper passes the front side of Needle and reaches the left end of its movement, the distance between the point of Upper Loper and the center of Needle shall be 11~12 mm approximately .

(In case of IDL-306 the distance the point of Spreader and the center of Needle should also be 11~12 mm.)

當上鉤針 Upper Looper(M)與下鉤針 Lower Looper(E)相會時，而上鉤針的針尖通過下鉤針的凹槽時，上下鉤針應盡可能的接近但不能相碰觸。當上鉤針通過車針的前端並且左移到終端時，上鉤針的針尖與車針的中心點間距必須為 11~12 mm。

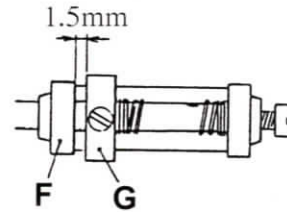
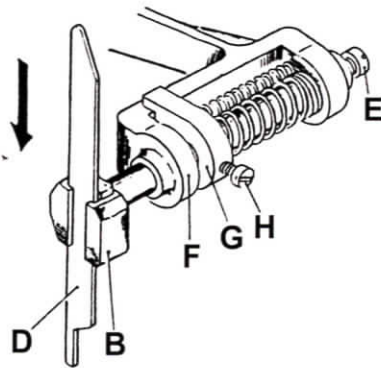
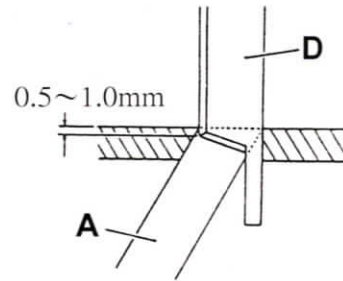
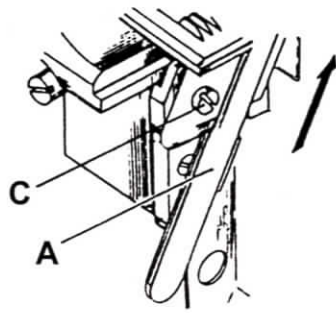


8-7、Adjustment of Upper and Lower Knives / 上下切刀的調整

To fit Lower Knife(A) , push Upper Knife Holder(B) to right and insert the Lower Knife upwards along the groove on Lower Knife Holder. In the above fitting, make the Blade of Lower Knife even with the top face of Stitch Plate or a little lower (0~0.3 mm) . This Adjustment is made by loosening Screw(C) . When Upper Knife(D) lowers to the bottom , adjust the engagement with Lower Knife(A) to be 0.5~1.0 mm. This adjustment is made by loosening Screw(E) of Upper Knife Clamp. The pressure of engagement of both Knives shall be adjusted by loosening Screw(H) .

When Upper Knife Holder Guide(G) is moved to right the pressure becomes strong and to left the pressure becomes weak. Under the standard condition of pressure, the allowance between Upper Knife Driving Arm Stud(F) and Holder Guide(G) shall be 1.5mm.

下切刀 Lower Knife(A) 適當的調整，將上刀座 Upper Knife Holder(B) 向右推並延著下刀座的凹槽向上插入下刀片，使下刀片對齊針板的上表面或低於 0~0.3 mm，此處調整可由螺絲 Screw(C) 來達成。當上刀片 Upper Knife(D) 降至底部時，調整上刀座底部與下切刀 Lower Knife(A) 的間距約 0.5~1.0mm，此處可由上刀鉗螺絲 Screw of Upper Knife Clamp(E) 來調整。上下切刀的壓力可由螺絲 Screw(H) 來調整，當上刀座導引塊 Upper Knife Holder Guide(G) 向右移動時壓力就會增加，反之向左移動時就變弱。在標準的壓力條件下，上刀傳動臂 Upper Knife Driving Arm Stud(F) 與導引塊 Holder Guide(G) 的間距為 1.5 mm。

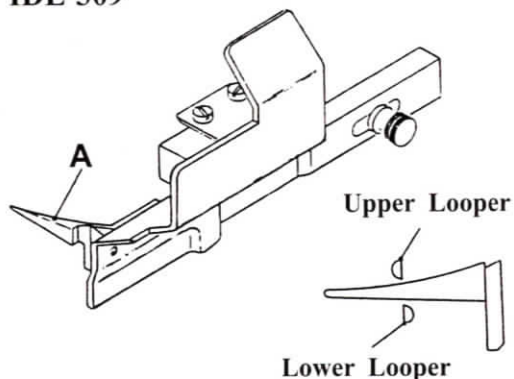


8-8、Adjustment of Auxiliary Stitch Tongue / 輔助舌 Auxiliary Stitch Tongue 的調整

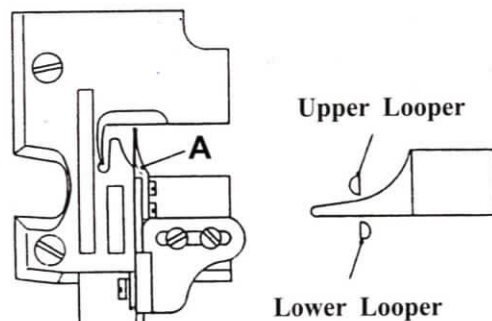
When fixing Auxiliary Stitch Tongue, take care that it does not touch Upper and Lower Loper.

當固定輔助舌 Auxiliary Stitch Tongue 時，必須注意輔助舌不能碰觸到上下鉤針。

**IDL-306
IDL-309**



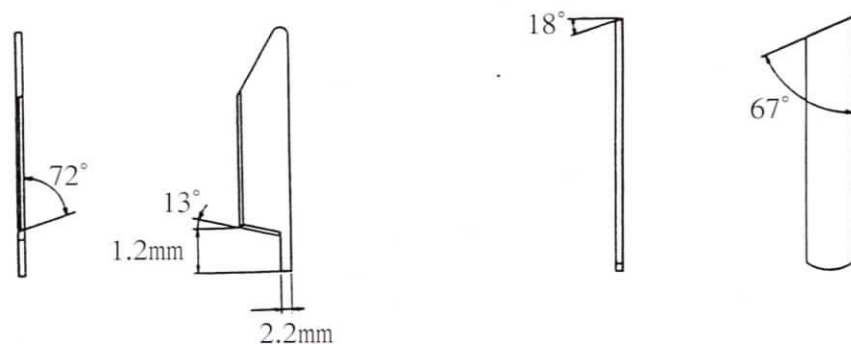
IDL-308



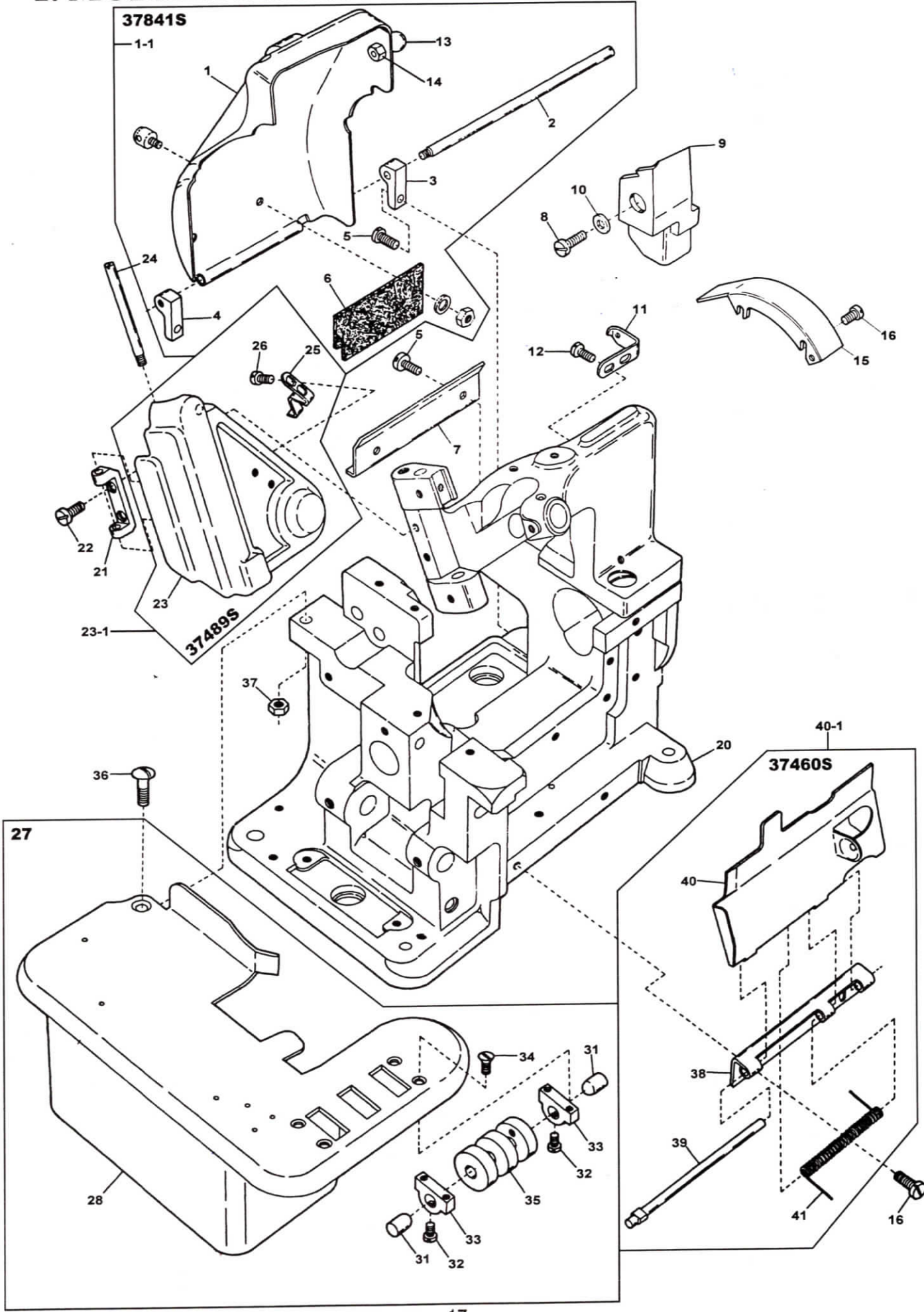
8-9、Sharpening of Knives / 切刀的研磨

Knives must be re-sharpened when the sharpness become blunt. The sketches show angles of Blade on both knives. When Sharpening Upper Knife, the part(H) must be 12 mm as the dimension indicated.

切刀變鈍時須研磨使其變銳利，下圖顯示刀身銳角的角度。



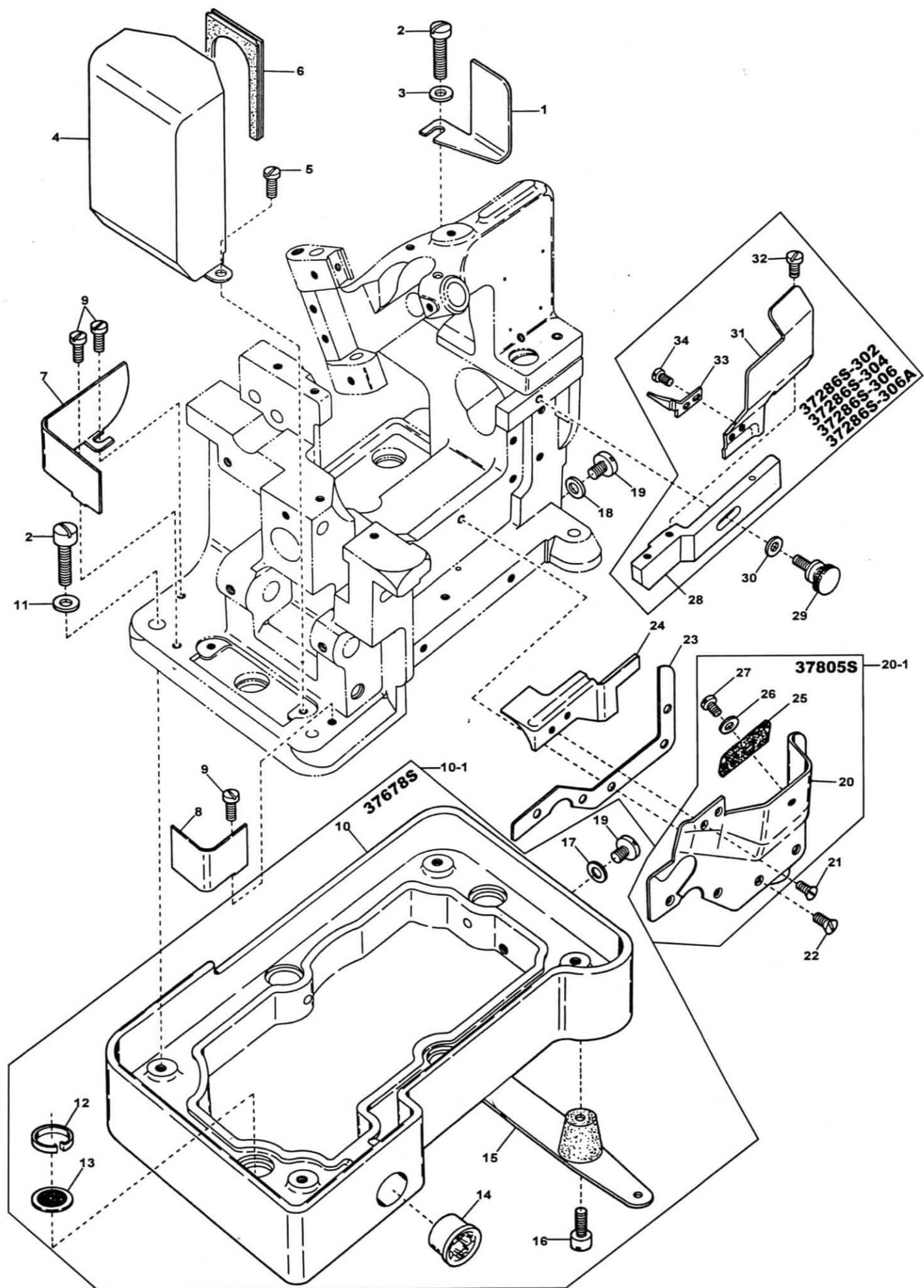
1. MODEL:302/303/304/306/306A/306S



1 . MISCELLANEOUS COVERS (1)

REF NO.	PARTS NO.	DESCRIPTION	
1	37841	Rear Cover Unit	
1-1	37841S	Complete Set	
2	37612	Rear Cover Hinge Pin	
3	37609	Rear Cover Hinge (Right)	
4	37610	Rear Cover Hinge (Left)	
5	7609	Screw	
6	37569	Rear Cover Felt	
7	38229	Plate	
8	1175	Screw	
9	37622	Front Cover (Fixed)	
10	541	Washer	
11	37613	Rear Cover Spring	
12	1196	Screw	
13	37841SC	Ball Screw	
14	37841N	Nut	
15	37544	Belt Cover	
16	1208	Screw	
17	----	----	
18	----	----	
19	----	----	
20	----	Machine Frame Unit	
21	37616	Needle Bar Cover Bracket	
22	7616	Screw	
23	37489	Needle Bar Cover	
23-1	37489S	Complete Set	
24	37617	Needle Bar Cover Pin	
25	37618	Needle Bar Cover Latch Spring	
26	1227	Screw	
27	----	Cloth Plate Complete Set	
28	37495	Cloth Plate	
29	----	----	
30	----	----	
31	37453	Roller Holder	
32	3433	Screw	
33	37809	Roller Holder Bracket	
34	5345	Screw	
35	37452	Roller	
36	2419	Screw	
37	144	Nut	
38	37605	Front Cover Hinge	
39	37606	Front Cover Hinge Pin	
40	37460	Front Cover	
40-1	37460S	Complete Set	
41	37607	Front Cover Restoring Spring	
REF NO.	MODEL	PARTS NO.	DESCRIPTION
20	IDL-302	37482	Machine Frame Unit
	IDL-303	37801	Machine Frame Unit
	IDL-304	37801	Machine Frame Unit
	IDL-306	37482	Machine Frame Unit
	IDL-306A	37801	Machine Frame Unit
27	IDL-302	37495S	Cloth Plate Complete Set
	IDL-303	37834S	Cloth Plate Complete Set
	IDL-304	37834S	Cloth Plate Complete Set
	IDL-306	37495S	Cloth Plate Complete Set
	IDL-306A	37834S	Cloth Plate Complete Set

2. MODEL:302/303/304/306/306A/306S

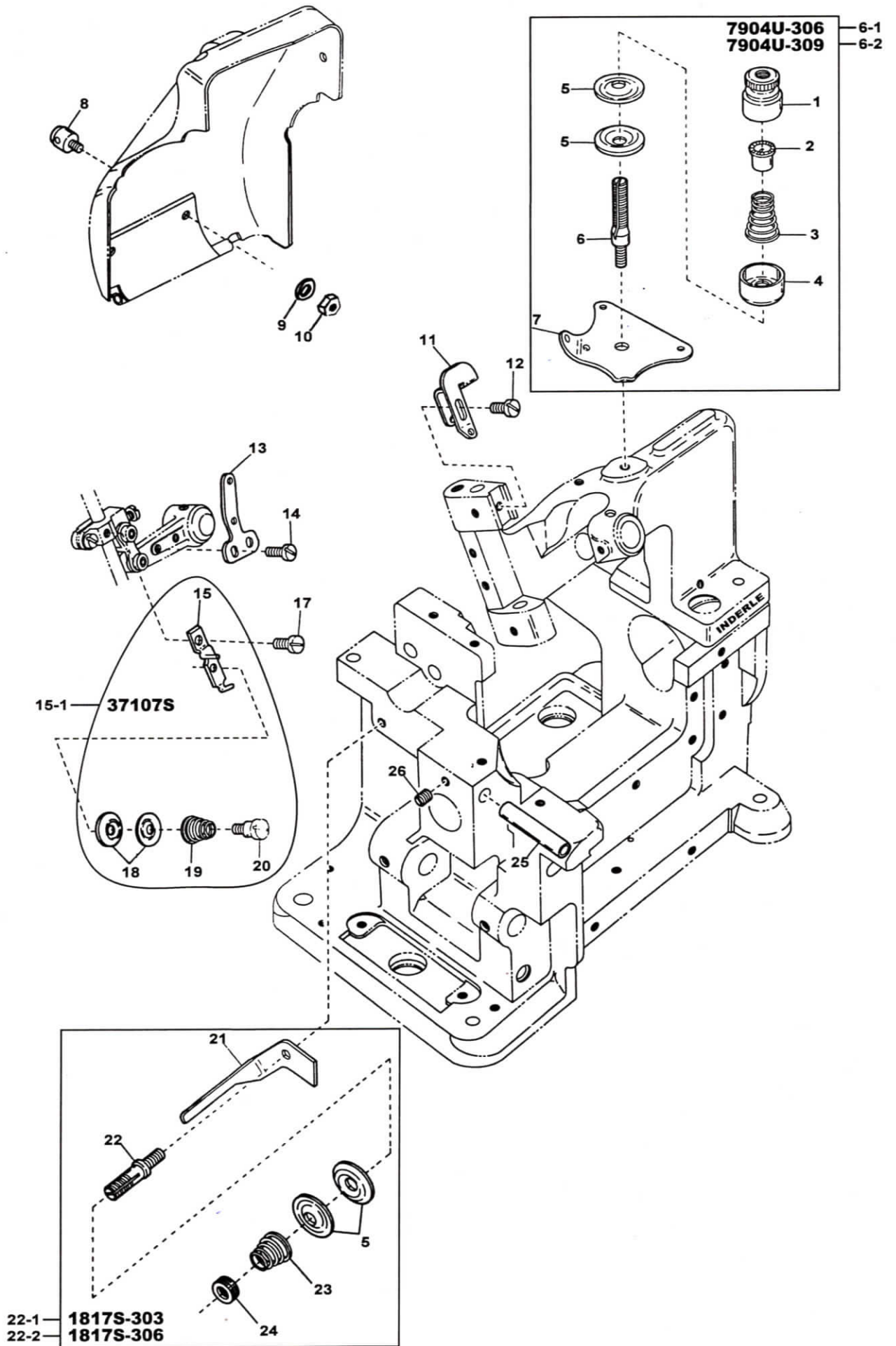


2. MISCELLANEOUS COVERS (2)

REF NO.	PARTS NO.	DESCRIPTION
1	37709	Dust Plate
2	7763	Screw
3	562	Washer
4	37624	Looper Connecting Rod Cover
5	9604	Screw
6	37699	Looper Connecting Rod Cover Gasket
7	37626	Angled Cover (Large)
8	37627	Angled Cover (Small)
9	1208	Screw
10	37678	Base
10-1	37678S	Complete Set
11	500	Washer
12	37681	Oil Filter Screen Camp
13	37680	Oil Filter Screen
14	37679	Oil Sight Gauge
15	37540	Base Rubber Cushion Unit
16	5083	Screw
17	567	Gasket
18	567	Gasket
19	5062	Screw
20	37805	Front Oil Shield
20-1	37805S	Complete Set
21	1613	Screw
22	7619	Screw
23	37620	Front Oil Shield Gasket
24	37842	Front Oil Shield (Upper)
25	37692	Felt
26	531	Washer
27	7616	Screw
28	37466	Chip guard Holder
29	1218	Screw
30	554	Washer
31	----	Chip Guard (Upper)
32	7609	Screw
33	----	Auxiliary Stitch Tongue
34	4237	Screw

REF NO.	MODEL	PARTS NO.	DESCRIPTION
31	IDL-302	37461	Chip Guard
	IDL-303	37461	Chip Guard
	IDL-304	37461	Chip Guard
	IDL-306	37487	Chip Guard
	IDL-306A	37461	Chip Guard
33	IDL-302	37286-306A	Auxiliary Stitch Tongue
	IDL-304	37286-304	Auxiliary Stitch Tongue
	IDL-306	37286	Auxiliary Stitch Tongue
	IDL-306A	37286-306A	Auxiliary Stitch Tongue
	IDL-306S	37286-306A	Auxiliary Stitch Tongue

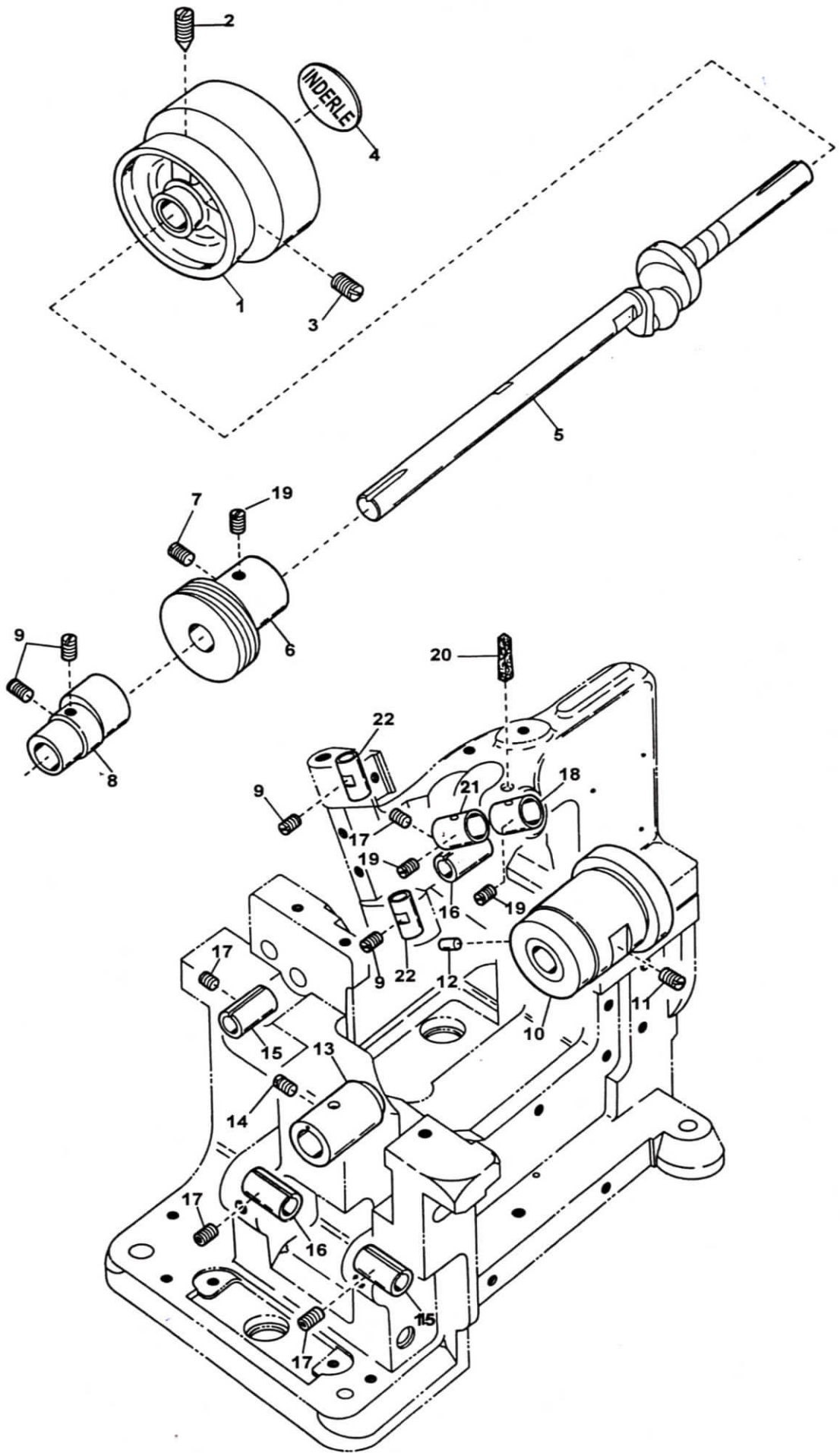
3. MODEL:302/303/304/306/306A/306S



3. MISCELLANEOUS THREAD EYELETS

REF NO.	PARTS NO.	DESCRIPTION	
1	37634	Thread Tension Spring Cap	
2	37170	Tension Spring Bushing	
3	-----	Needle Thread Tension Spring	
4	37635	Thread Tension Spring Retainer	
5	31111	Tension Disc	
6	7904	Tension Post	
6-1	7904U-306	Complete Set	
6-2	7904U-309	Complete Set	
7	37812	Tension Disc Eyelet	
8	38364	Rear Cover Thread Eyelet	
9	531	Washer	
10	12	Nut	
11	37262	Needle Thread Eyelet	
12	4358	Screw	
13	37060	Needle Thread Sewing Eyelet	
14	1196	Screw	
15	37107	Needle bar Thread Retainer Bracket	
15-1	37107S	Complete set	
16	-----	-----	
17	1222	Screw	
18	37108	Thread Retainer Disc	
19	37109	Thread Retainer Spring	
20	1093	Screw	
21	37016	Side Thread Latch	
22	1817	Tension Post	
22-1	1817S-303	Complete set	
22-2	1817S-306	Complete set	
23	-----	Looper Thread Tension Spring	
24	56	Adjusting Nut	
25	37112	Lower Looper Thread Pipe	
26	1457-3	Screw	
REF NO.	MODEL	PARTS NO.	DESCRIPTION
3	IDL-302	37115	Needle Thread Tension Spring
	IDL-303	37113	Needle Thread Tension Spring
	IDL-304	37115	Needle Thread Tension Spring
	IDL-306	37115	Needle Thread Tension Spring
	IDL-306A	37115	Needle Thread Tension Spring
	IDL-306S	37115	Needle Thread Tension Spring
	IDL-308	37632	Needle Thread Tension Spring
	IDL-309	37632	Needle Thread Tension Spring
21	IDL-303	37016	Side Thread Latch
	IDL-304	38074	Side Thread Latch
	IDL-306	37016	Side Thread Latch
	IDL-306A	37016	Side Thread Latch
	IDL-306S	37016	Side Thread Latch
23	IDL-303	37632	Looper Thread Tension Spring
	IDL-304	37115	Looper Thread Tension Spring
	IDL-306	37115	Looper Thread Tension Spring
	IDL-306A	37115	Looper Thread Tension Spring
	IDL-306S	37115	Looper Thread Tension Spring

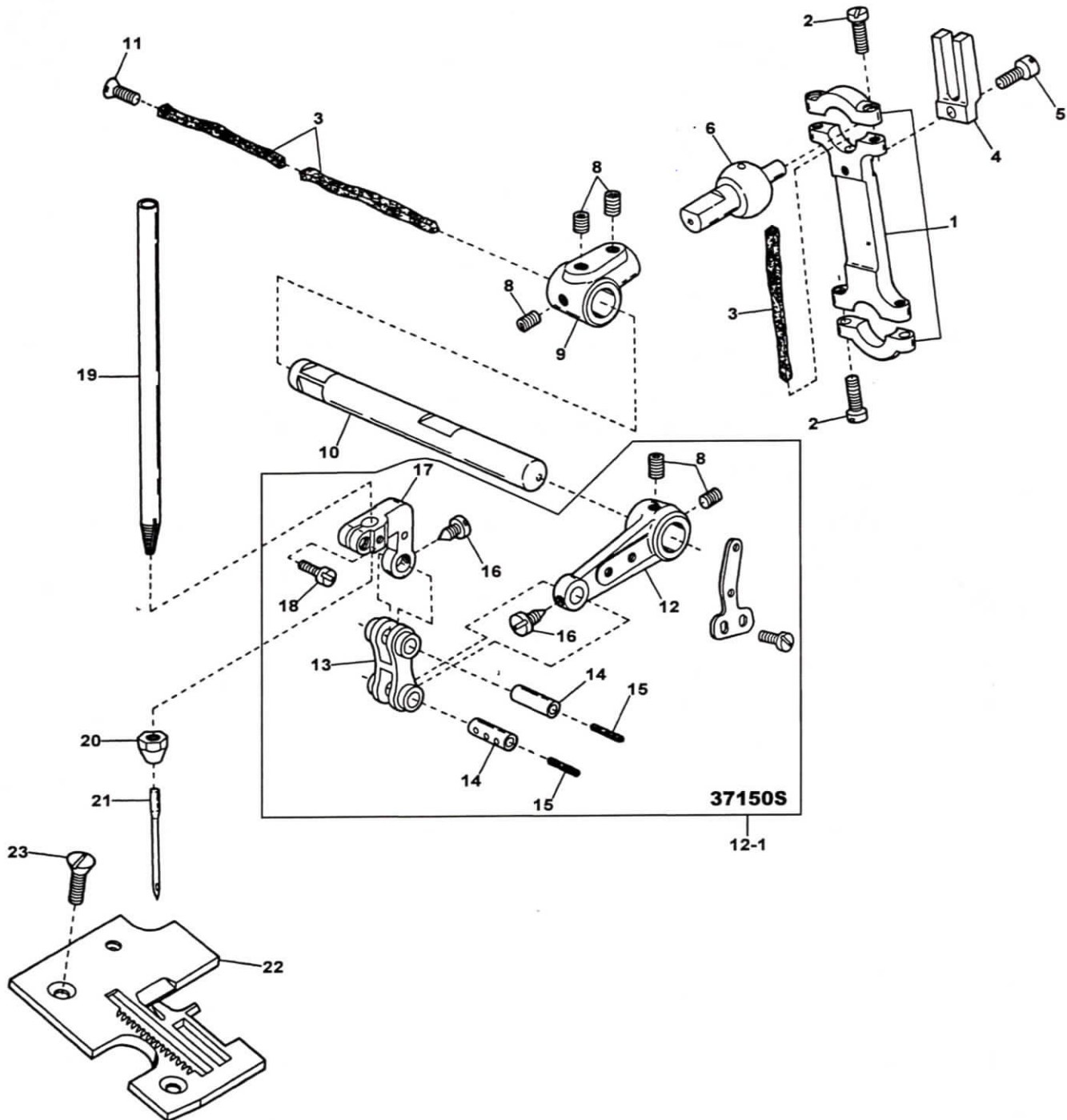
4. MODEL:302/303/304/306/306A/306S



4. MISCELLANEOUS CRANKSHAFT & BUSHINGS

REF NO.	PARTS NO.	DESCRIPTION	
1	-----	Pulley	
2	3591	Screw	
3	3593	Screw	
4	989	Hand wheel Mark	
5	37799	Main Crankshaft	
6	37650	Feed Driving Eccentric	
7	7650	Screw	
8	37462	Feed and Upper Knife Eccentric	
9	1457	Screw	
10	37547	Crankshaft Bushing (Right)	
11	3639	Screw	
12	294	Oil Wick	
13	37645	Crankshaft Bushing (Middle)	
14	2022	Screw	
15	37409	Feed Bar and Upper Looper Bushing	
16	37654	Feed Bar and Upper Looper Bushing	
17	3635	Screw	
18	37133	Needle Bar Driving Crank Bushing (Front)	
19	3434	Screw	
20	290	Oil Wick	
21	37134	Needle Bar Driving Crank Bushing (Rear)	
22	37049	Needle Bar Bushing	
PREF NO.	MODEL	PARTS NO.	DESCRIPTION
1	IDL-302	37703	Pulley
	IDL-303	37703	Pulley
	IDL-304	37816	Pulley
	IDL-306	37703	Pulley
	IDL-306A	37703	Pulley

5. MODEL:302/303/304/306/306A/306S

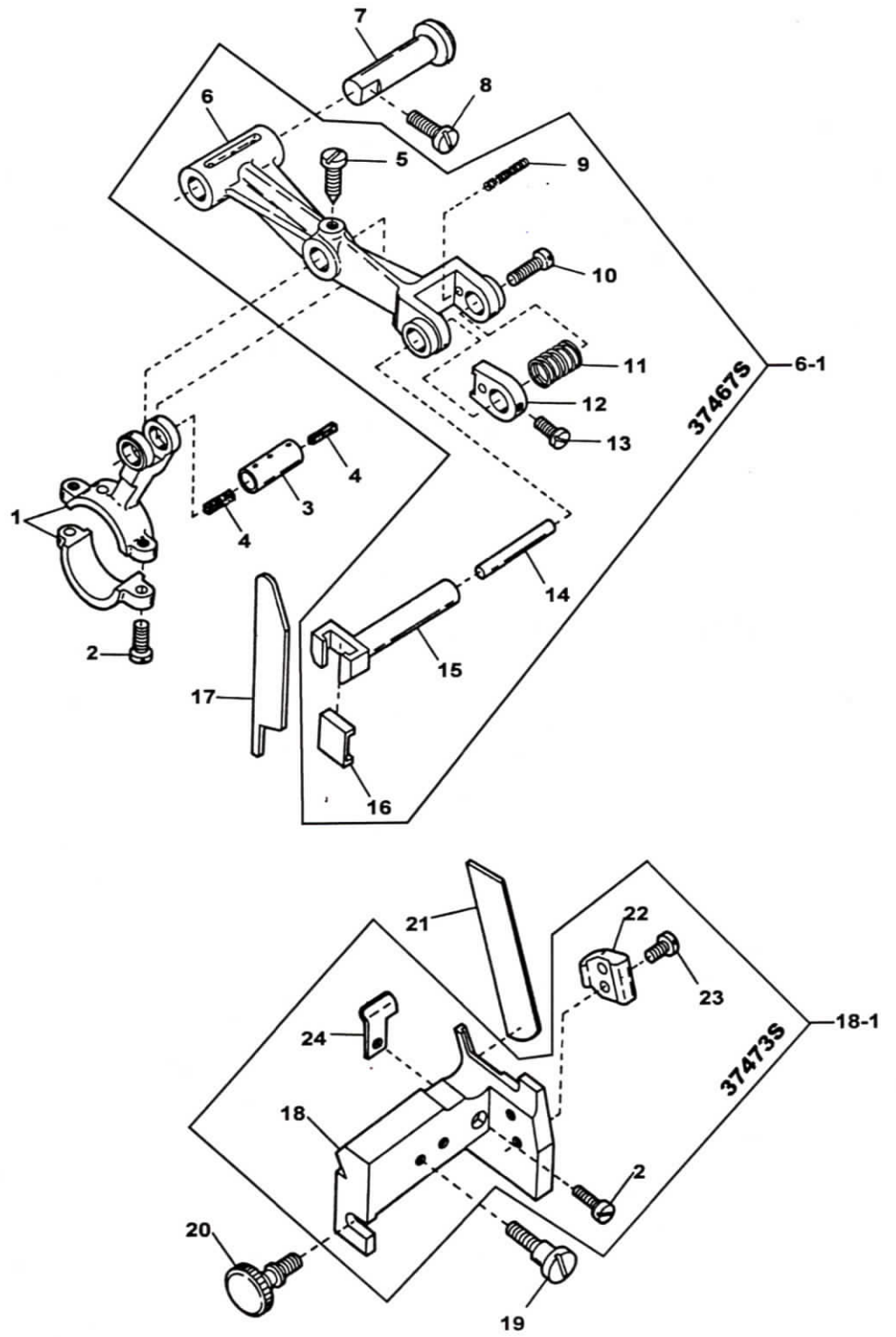


5. NEEDLE BAR DRIVING MECHANISM

REF NO.	PARTS NO.	DESCRIPTION	
1	37057	Needle Bar Connecting Rod	
2	7311-1	Screw	
3	304	Oil Wick	
4	37130	Connecting Rod Guide Fork	
5	1175	Screw	
6	37132	Driving Crank Ball Stud	
7	----	----	
8	3635	Screw	
9	37127	Driving Crank (Rear)	
10	37059	Driving Crankshaft	
11	3433	Screw	
12	37150	Driving Crank (Front)	
12-1	37150S	Complete Set	
13	90321	Connecting Link	
14	90320	Connecting Link Pin	
15	278	Oil Wick	
16	4313	Screw	
17	37818	Needle Bar Connecting Bracket	
18	4435	Screw	
19	37062	Needle Bar	
20	62	Nut	
21	----	Needle	
22	----	Stitch Plate	
23	1732	Screw	

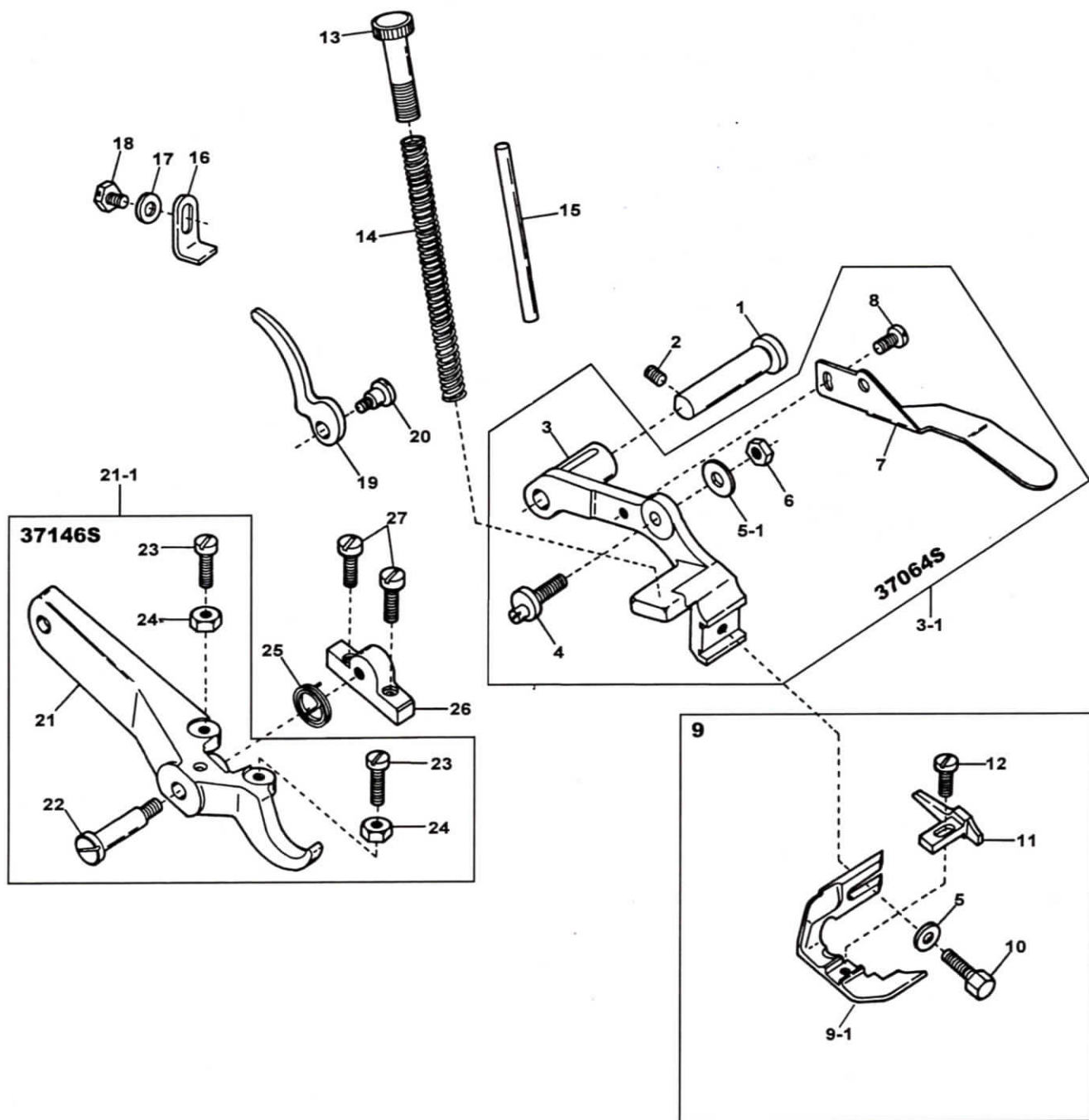
REF NO.	MODEL	PARTS NO.	DESCRIPTION
21	IDL-302	DCx27#16	Needle
	IDL-303	DCx27#16	Needle
	IDL-304	DMx5#23	Needle
	IDL-306	DCx27#16	Needle
	IDL-306A	DCx27#16	Needle
	IDL-306S	DCx27#16	Needle
22	IDL-302	37483-302	Stitch Plate
	IDL-303	37483-303	Stitch Plate
	IDL-304	37459B	Stitch Plate
	IDL-306	37483	Stitch Plate
	IDL-306A	37483-306A	Stitch Plate
	IDL-306S	37483-306S	Stitch Plate

6. MODEL:302/303/304/306/306A/306S



6. KNIFE DRIVING MECHANISM		
REF NO.	PARTS NO.	DESCRIPTION
1	37883	Upper Knife Connecting Rod
2	1174	Screw
3	37876	Connecting Rod Pin
4	290	Oil Wick
5	1176	Screw
6	37467	Upper Knife Driving Arm Stud
6-1	37467S	Complete Set
7	37552	Driving Arm Stud Pin
8	1156	Screw
9	30414	Upper Knife Holder Spring (Small)
10	1132	Screw
11	30413	Upper Knife Holder Spring
12	37478	Upper Knife Holder Guide
13	1222	Screw
14	37475	Upper Knife Clamp Pin
15	37470	Upper Knife Holder
16	37471	Upper Knife Clamp
17	37469	Upper Knife
	37469T	Upper Knife Tungsten
18	37473	Lower Knife Holder
18-1	37473S	Complete Set
19	2086	Screw
20	2369	Adjusting Screw
21	37472	Lower Knife
22	37474	Lower Knife Clamp
23	7405	Screw
24	37458	Needle Guard

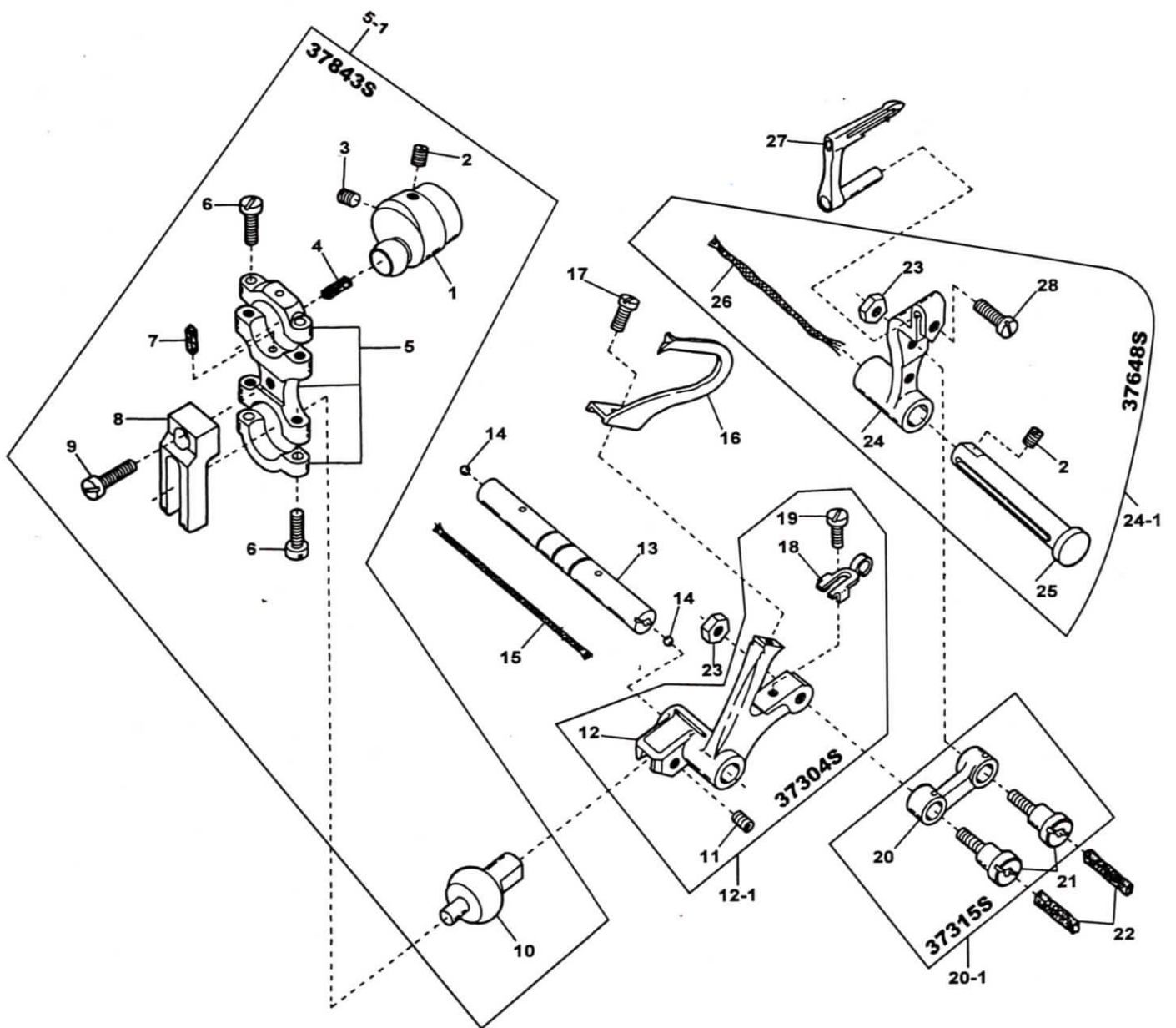
7. MODEL:302/303/304/306/306A/306S



7. PRESSER FOOT MECHANISM

REF NO.	PARTS NO.	DESCRIPTION	
1	37552	Presser Arm Hinge Stud	
2	3434	Screw	
3	37064	Presser Arm	
3-1	37064S	Complete Set	
4	7143	Eccentric Screw	
5	554	Washer	
5-1	541	Washer	
6	334	Nut	
7	37886	Auxiliary Foot Lifter Hand Lever	
8	1208	Screw	
9	----	Presser Foot, Complete Set	
9-1	----	Presser Foot Base	
10	2308	Screw	
11	----	Presser Foot Stitch Tongue	
12	4236	Screw	
13	2371	Adjusting Screw	
14	37065	Presser Spring	
15	37048	Presser Foot Positioning Pin	
16	37148	Presser Arm Stop	
17	531	Washer	
18	5541	Screw	
19	37144	Foot Lifter Hand Lever	
20	2214	Screw	
21	37146	Foot Lift Lever	
21-1	37146S	Complete Set	
22	2285	Screw	
23	2133	Screw	
24	334	Nut	
25	37147	Foot Lifter Lever Spring	
26	37145	Foot Lifter Lever Bracket	
27	7311	Screw	
REF NO.	MODEL	PARTS NO.	DESCRIPTION
9	IDL-302	37496-306A	Presser Foot Complete Set
	IDL-303	37496-303	Presser Foot Complete Set
	IDL-304	37848	Presser Foot Complete Set
	IDL-306	37496	Presser Foot Complete Set
	IDL-306A	37496-306A	Presser Foot Complete Set
	IDL-306S	37496-306S	Presser Foot Complete Set
9-1	IDL-303	37496B	Presser Foot Base
	IDL-304	37848B	Presser Foot Base
	IDL-306	37496B	Presser Foot Base
11	IDL-303	37268-303	Presser Foot Stitch Tongue
		37268-303W	Presser Foot Stitch Tongue (Width)
	IDL-304	37850	Presser Foot Stitch Tongue
	IDL-306	37268	Presser Foot Stitch Tongue

8. MODEL:302/303/304/306/306A



8. LOOPER DRIVING MECHINASM

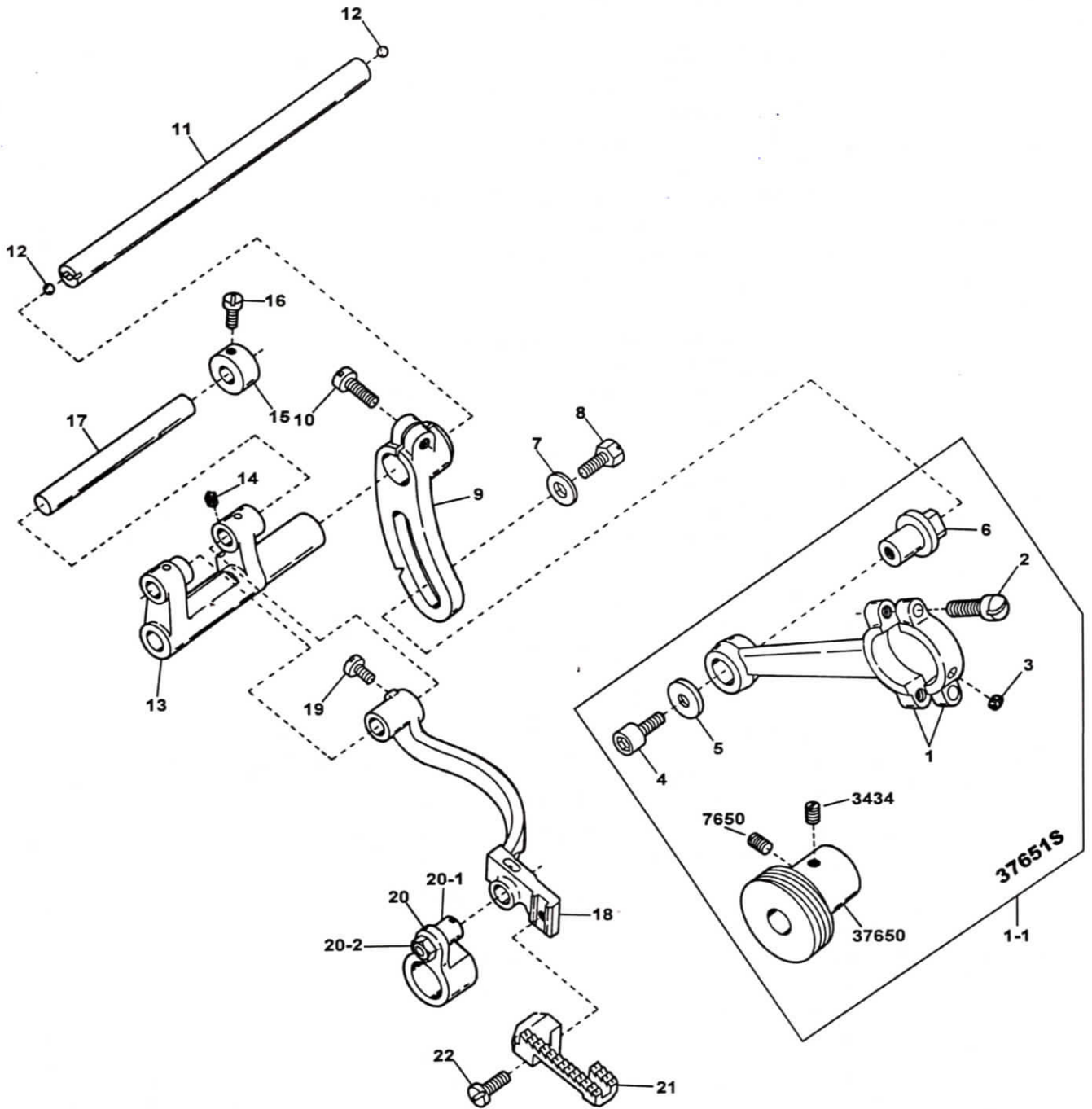
REF NO.	PARTS NO.	DESCRIPTION	
1	37831	Looper Driving Crank	
2	2022	Screw	
3	3635	Screw	
4	292	Oil Wick	
5	37843	Looper Connecting Rod	
5-1	37843S	Complete set	
6	7311-1	Screw	
7	294	Oil Wick	
8	37130	Connecting Rod Guide Fork	
9	1175	Screw	
10	37058	Holding Arm Ball Stud	
11	3635	Screw	
12	37304	Upper Looper Holding Arm	
12-1	37304S	Complete Set	
13	37647	Upper Looper Shaft	
14	9604	Screw	
15	----	Oil Wick	
16	----	Upper Looper (Spreader)	
17	1196	Screw	
18	37307	Upper Looper Thread Pull-off	
19	4236	Screw	
20	37315	Lower Looper Connecting Link	
20-1	37315S	Complete set	
21	1335	Screw	
22	290	Oil Wick	
23	18	Nut	
24	37648	Lower Looper Holder Arm	
24-1	37648S	Lower Looper Holder Arm Complete Set	
25	37649	Lower Looper Shaft	
26	----	Oil Wick	
27	----	Lower Looper	
28	7302	Screw	
REF NO.	MODEL	PARTS NO.	DESCRIPTION
16	IDL-302	37271	Upper Looper
	IDL-303	37832-303	Upper Looper
	IDL-304	37271-304	Upper Looper
	IDL-306	37271	Upper Looper
	IDL-306A	37271	Upper Looper
27	IDL-302	37288	Lower Looper
	IDL-303	37272-303	Lower Looper
	IDL-304	37076-304	Lower Looper
	IDL-306	37272	Lower Looper
	IDL-306A	37272	Lower Looper

*16

37271B

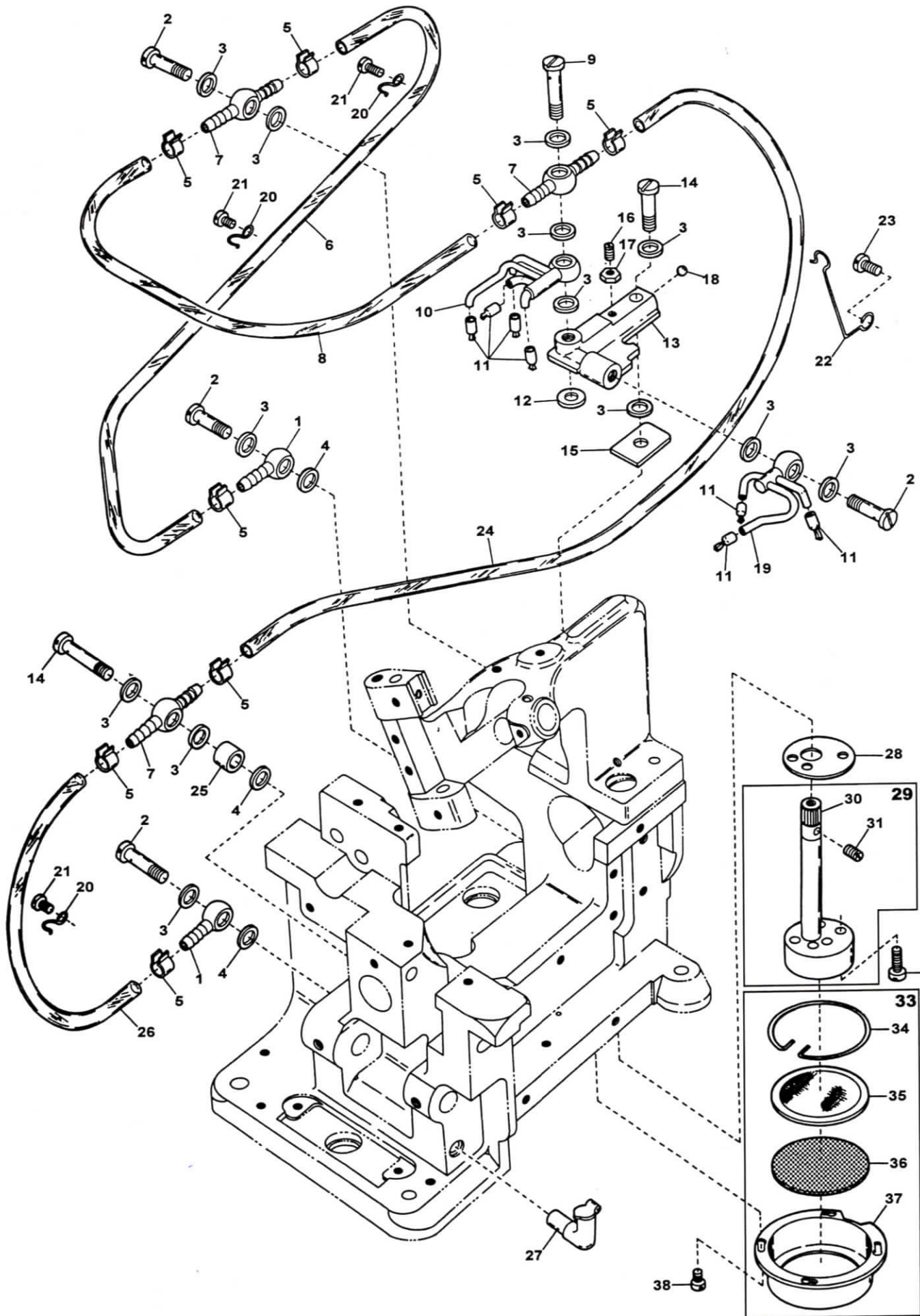
Upper Looper (Strong Base)

9. MODEL:302/303/304/306/306A



9. FEED DRIVING MECHANISM			
REF NO.	PARTS NO.	DESCRIPTION	
1	37651	Feed Dog Driving Connecting Rod	
1-1	37651S	Complete set	
	7650	Screw	
	3434	Screw	
	37650	Feed Driving Eccentric	
2	2043	Screw	
3	281	Oil Wick	
4	5028	Screw	
5	555	Washer	
6	38064	Connecting Rod Pin	
7	551	Washer	
8	5540	Screw	
9	37652	Feed Regulator	
10	1156-1	Screw	
11	37653	Feed Bar Shaft	
12	9604	Screw	
13	37256	Differential Feed Rocker	
14	287	Oil Wick	
15	37443	Collar	
16	1222	Screw	
17	37442	Feed Holder Pin	
18	37279	Feed Dog Holder	
19	9604	Screw	
20	37410	Feed Dog Driving Lever	
20-1	37410S	PIN SCREW	
20-2	37410N	NUT	
21	----	Plain Feed Dog	
22	1208	Screw	
REF NO.	MODEL	PARTS NO.	DESCRIPTION
21	IDL-302	37273-302	Plain Feed Dog
	IDL-303	37273-303	Plain Feed Dog
	IDL-304	37439	Plain Feed Dog
	IDL-306	37273	Plain Feed Dog
	IDL-306A	37273-306A	Plain Feed Dog
	IDL-306S	37273-306S	Plain Feed Dog

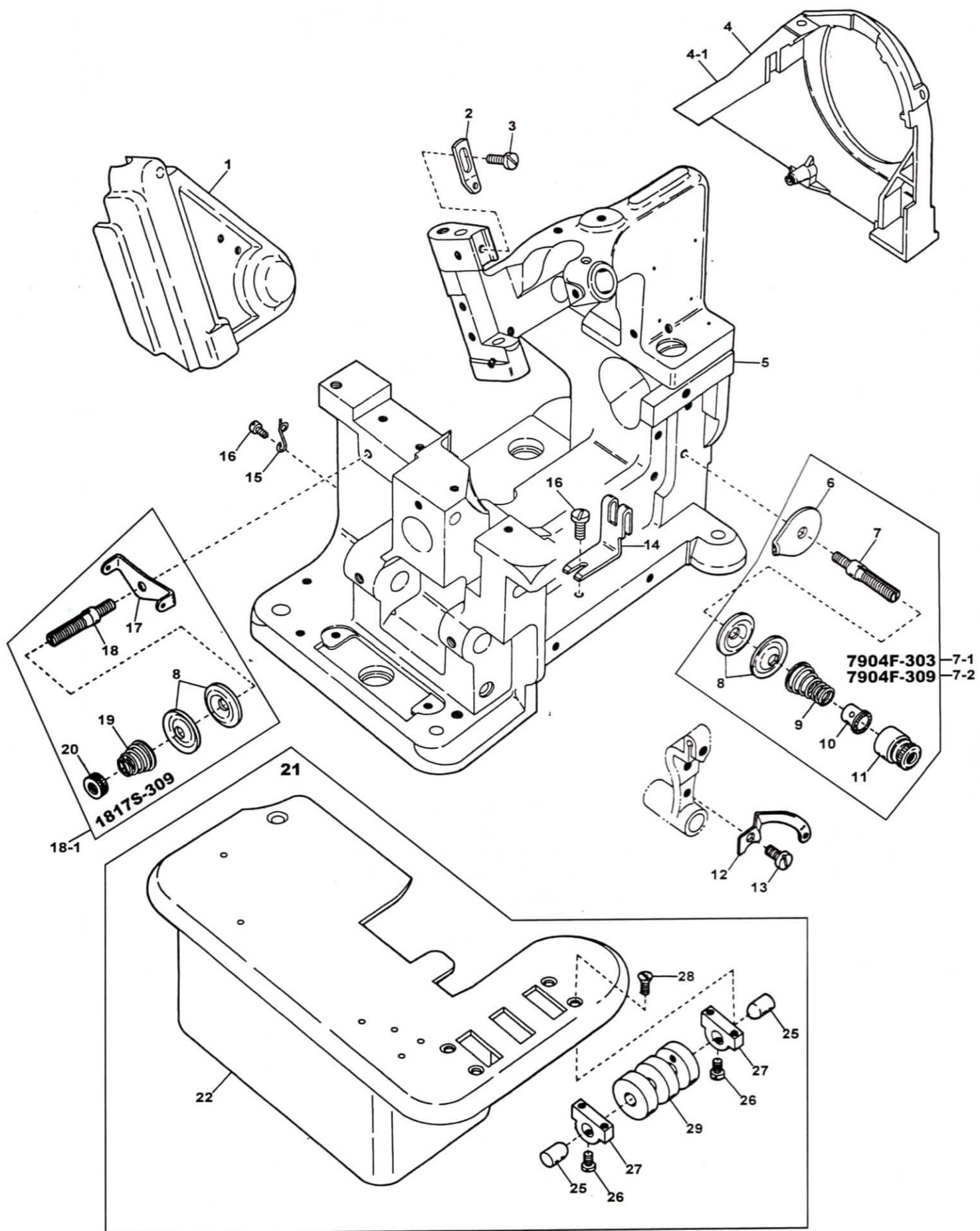
10. MODEL:302/303/304/306/306A



10. LUBRICATING MECHANISM

REF NO.	PARTS NO.	DESCRIPTION
1	37669	Oil Tube Fitting One Way End
2	7668	Oil Tube Fitting Stud
3	567	Seal
4	566	Seal
5	37675	Oil Tube Clamp
6	37433	Oil Tube
7	37668	Oil Tube Fitting Two Way
8	93619	Oil Tube
9	7667	Oil Tube Fitting Stud
10	37670	Oil Focal Point
11	37697	Oil Cap
12	569	Seal
13	37666	Oil Tube Joint Holder
14	7666	Oil Tube Fitting Stud
15	37667	Oil Tube Joint Holder Gasket
16	9209	Screw
17	340	Nut
18	637	Seal Plug
19	37479	Oil Focal Point
20	37677	Oil Tube Holder (Small)
21	1196	Screw
22	37676	Oil Tube Holder (Large)
23	1208	Screw
24	37432	Oil Tube
	37432S	Oil Tube Complete Set
25	37691	Oil Tube Joint Ring
26	37431	Oil Tube
27	37685	Oil Cup
28	37659	Oil Pump Gasket
29	37684	Oil Pump, Complete Set
30	37660	Worm Gear
31	3410	Screw
32	7658	Screw
33	38172	Pump Filter Screen, C. Set
34	38176	Pump Filter Screen Clamp
35	38175	Pump Filter Screen (Fine Mesh)
36	38174	Pump Filter Screen (Coarse Mesh)
37	38173	Pump Filter Case
38	7302	Screw

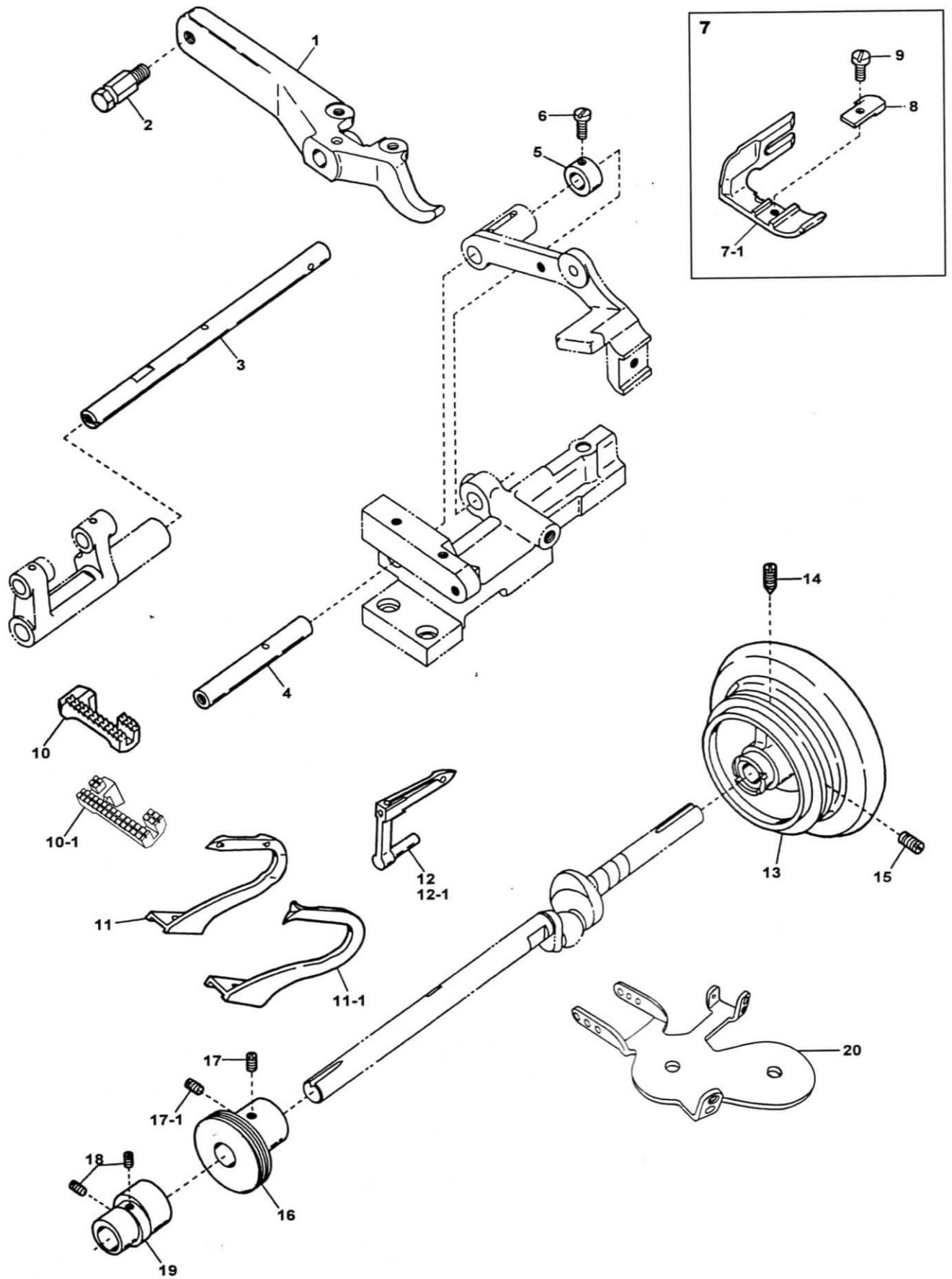
11. MODEL:308/309/309B



11. EXCLUSIVE PARTS (1)

REF NO.	PARTS NO.	DESCRIPTION	
1	37804	Needle Bar Cover	
2	37101	Needle Thread Eyelet	
3	4358	Screw	
4	2000002-306	Belt Cover	
4-1	2000002-309	Belt Cover	
5	37801	Machine Frame Unit	
6	37813	Tension Disc Eyelet	
7	7904	Tension Post	
7-1	7904F-303	Complete set	
7-2	7904F-309	Complete set	
8	31111	Tension Disc	
9	----	Upper Looper Thread Tension Spring	
10	37170	Tension Spring Bushing	
11	56	Adjusting Nut	
12	37833	Upper Looper Thread Pull-Off	
13	1222	Screw	
14	37814	Thread Take-Up Eyelet	
15	90185	Thread Eyelet	
16	1208	Screw	
17	38074	Tension Disc Eyelet	
18	1817	Tension Post	
18-1	1817S-309	Complete set	
19	37113	Lower Looper Thread Tension Spring	
20	56	Adjusting Nut	
21	37834S	Cloth Plate, Complete Set	
22	37834	Cloth Plate	
23	----	-----	
24	----	-----	
25	37453	Roller Holder	
26	3433	Screw	
27	37809	Roller Holder Bracket	
28	5345	Screw	
29	37452	Roller	
REF NO.	MODEL	PARTS NO.	DESCRIPTION
9	IDL-303	37632	Upper Looper Thread Tension Spring
	IDL-308	37113	Upper Looper Thread Tension Spring
	IDL-309	37115	Upper Looper Thread Tension Spring

12.MODEL:308/309/309B

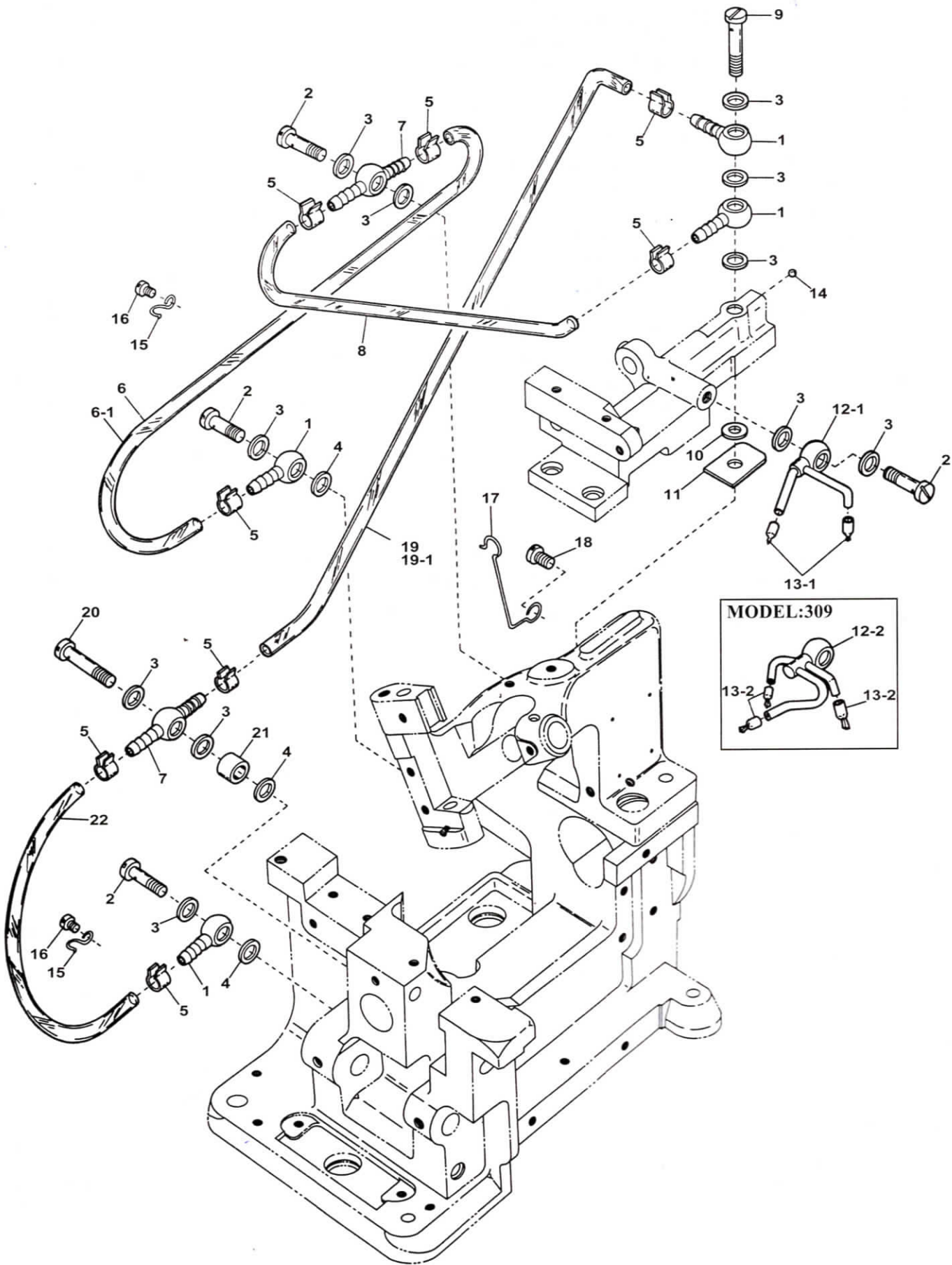


12. EXCLUSIVE PARTS (2)

REF NO.	PARTS NO.	DESCRIPTION
1	37755	Foot Lifter Lever
2	37757	Chain Latch Bolt
3	37835	Feed Bar Shaft
4	37826	Presser Arm Hinge Pin
5	37827	Collar
6	7302	Screw
7	37848	Presser Foot, Complete Set
7-1	37848B	Presser Foot Base
8	37850	Presser Foot Stitch Tongue
9	1228	Screw
10	37439	Plain Feed Dog
10-1	37439-309B	Plain Feed Dog
11	37832	Upper Looper
11-1	37271-309B	Upper Looper
12	37076	Lower Looper
12-1	37076-309B	Lower Looper
13	37816	Pulley
14	2347	Screw
15	1419	Screw
16	37438	Feed Driving Eccentric
17	3434	Screw
17-1	7650	Screw
18	1457	Screw
19	37437	Feed Lift & Upper Knife Eccentric
20	37812-L309B	Tension Disc Eyelet

*11. 37832B Upper Looper (Strong Base)

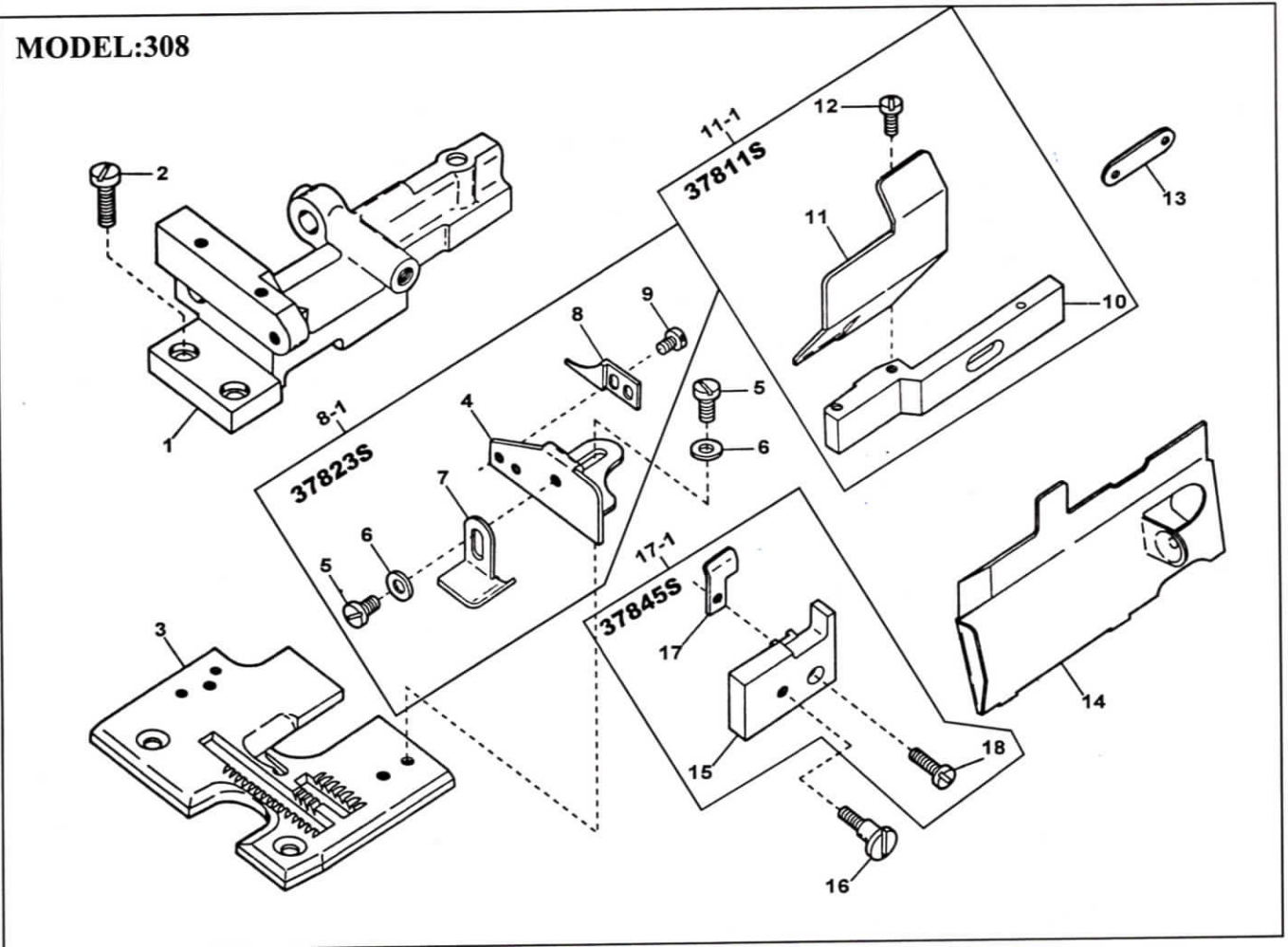
13.MODEL:308/309/309B



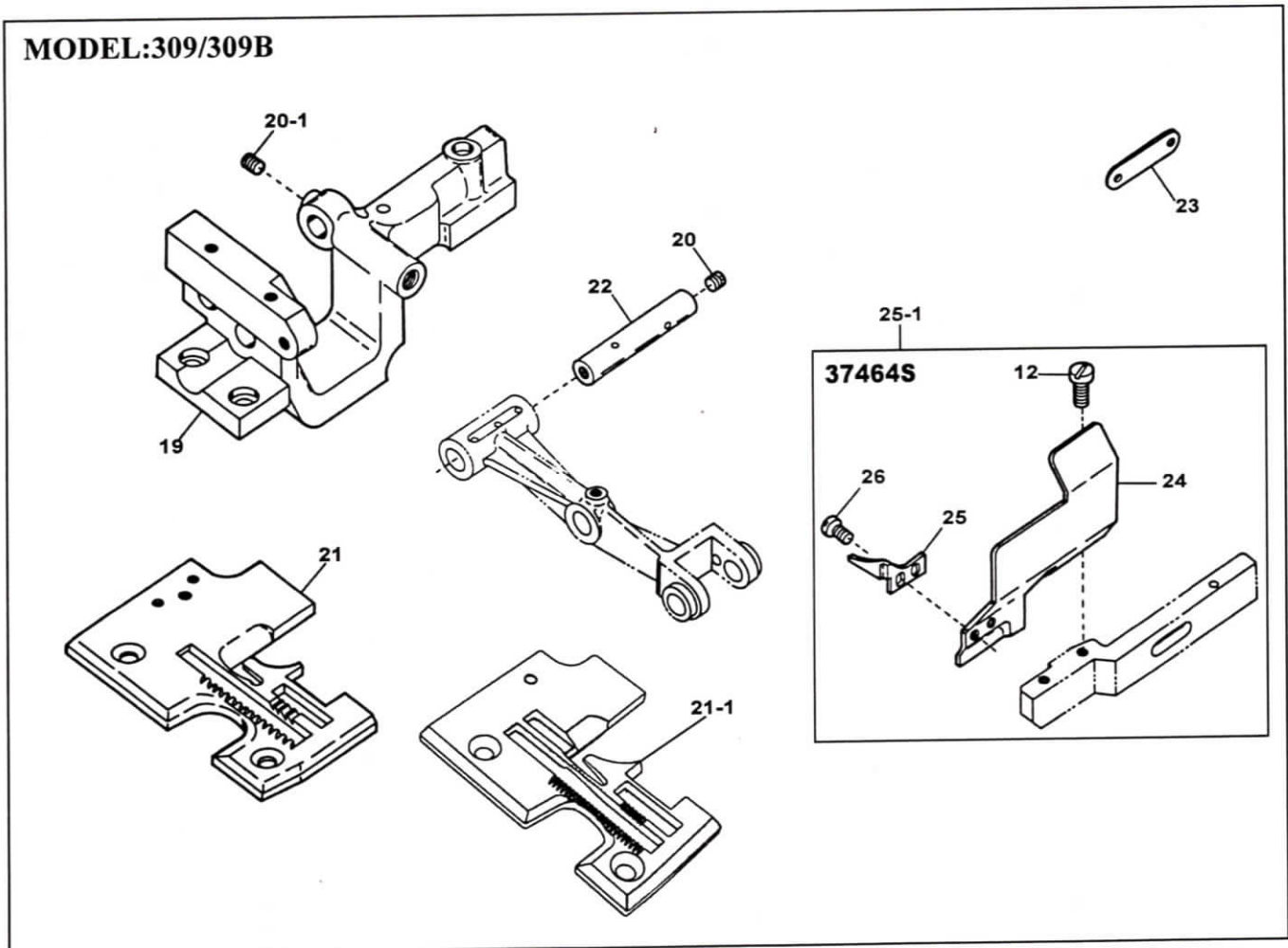
13. EXCLUSIVE PARTS (3)

REF NO.	PARTS NO.	DESCRIPTION
1	37669	Oil Tube Fitting One Way End
2	7668	Oil Tube Fitting Stud
3	567	Seal
4	566	Seal
5	37675	Oil Tube Clamp
6	37433	Oil Tube
6-1	37433S	Oil Tube Complete Set
7	37668	Oil Tube Fitting Two Way
8	37435	Oil Tube
9	6762	Oil Tube Fitting Stud
10	569	Seal
11	37667	Oil Tube Joint Holder Gasket
12-1	37715	Oil Focal Foimt Model : 308
12-2	37479	Oil Focal Foimt Model : 309
13-1	37697	Oil Cap Model : 308
13-2	37697	Oil Cap Model : 309
14	3433	Screw
15	37677	Oil Tube Holder (Small)
16	1196	Screw
17	37880	Oil Tube Holder (Large)
18	1208	Screw
19	37481	Oil Tube
19-1	37481S	Oil Tube Complete Set
20	7666	Oil Tube Fitting Stud
21	37691	Oil Tube Joint Ring
22	37431	Oil Tube

MODEL:308



MODEL:309/309B



14. EXCLUSIVE PARTS (4)

REF NO.	PARTS NO.	DESCRIPTION
1	37825	Foot Lifter Device Bracket
2	1156	Screw
3	37800	Stitch Plate
4	37821	Edge Guide
5	4358	Screw
6	532	Washer
7	37822	Fabric Guide
8	37823	Auxiliary Stitch Tongue
8-1	37823S	Complete Set
9	1228	Screw
10	37466	Chip Guard Holder
11	37811	Chip Guard
11-1	37811S	Complete set
12	7609	Screw
13	37839	Model Plate
14	37604	Front Cover
15	37824	Needle Guard Bracket
16	2086	Screw
17	37845	Needle Guard
17-1	37845S	Complete set
18	1174	Screw
19	37465	Foot Lifter Device Bracket
20	9604	Screw
20-1	1457-2	Screw
21	37459	Stitch Plate
21-1	37459-309B	Stitch Plate
22	37468	Upper Knife Driving Arm Stud Pin
23	37480	Model Plate
24	37461	Chip Guard
25	37464	Auxiliary Stitch Tongue
25-1	37464S	Complete set
26	4237	Screw

PARTS NO	PAGE NO	REF NO	PARTS NO	PAGE NO	REF NO	PARTS NO	PAGE NO	REF NO	PARTS NO	PAGE NO	REF NO	PARTS NO	PAGE NO	REF NO	PARTS NO	PAGE NO	REF NO
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18	8	23	1176	6	5	3434	12	17	7904	11	7	37271	8	16	37482	1	20
56	3	24	1196	1	12	3591	4	2	9209	10	16	37272	8	27	37482	1	20
56	11	11	1196	3	14	3593	4	3	9604	2	5	37273	9	21	37483	5	22
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PARTS NO	PAGE NO	REF NO	PARTS NO	PAGE NO	REF NO	PARTS NO	PAGE NO	REF NO	PARTS NO	PAGE NO	REF NO
37668	10	7	37826	12	4	37268-303W	7	11	37843S	8	5-1
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