

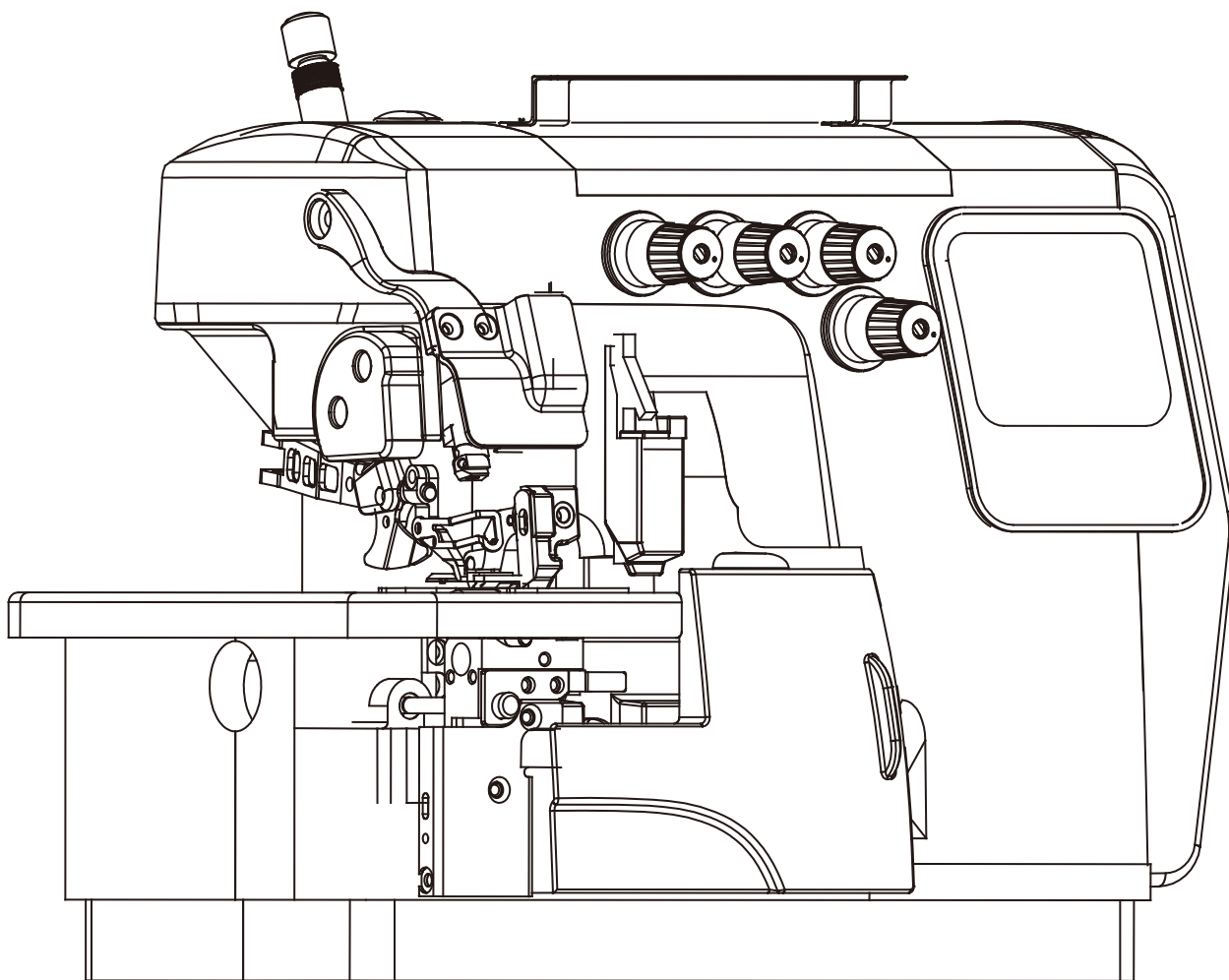
# 高速直驱智能包缝机

High Speed Direct Drive OverLock Sewing Machine

使用说明书

Instruction Book

---



- 
- 1.本零件样本是根据截止2022年3月的资料为基准编制的。
  - 2.若设计参数或结构有变更,恕不另行通知。
  - 3.使用之前请仔细阅读使用说明书,我们希望您能长期愉快地使用本机,请保存好说明书,以备查阅。

- 1.This list was prepared based on information available in March 2022.
- 2.Reserve the right to change the parameters or structure without prior notice.
- 3.Please read this instruction manual carefully before use. We hope you will enjoy the use of your machine for a long time. Please remember to keep this maunal in a safe place.

# 目 录

## CONTENTS

1.开机前注意事项	
Attention befor operation .....	2
2.使用注意事项	
Caution in using .....	2
3.机器的安装	
Installation .....	3
4.线架的安装	
Mounting the thread stand .....	3
5.机器的润滑	
Lubrication .....	4
6.润滑油的更换	
Oil Change .....	5
7.滤油器的更换	
Replacing oil filter .....	5
8.HR装置的供油	
Filling the HR device with silicon oil .....	6
9.穿线的方法	
Threading .....	6
10.线状态的调节	
Adjusting the thread tension .....	8
11.机针的更换	
Replacing the needle .....	8
12.压脚压力的的调节	
Adjusting the Presser foot pressure .....	9
13.差动比的调节	
Adjusting the differential feed ratio .....	9
14.针脚长度的调节	
Adjusting the stitch length .....	10
15.刀片的更换	
Replacing the knife .....	11
16.刀的研磨方法	
Grinding method of knife .....	12

## 1.开机前注意事项 Attention before operation

- 1.机器最初使用之前，必须将机器表面的油脂和灰尘用洁净的软布擦拭干净。
- 2.机器出厂时经过严格的调试和检验，但由于长途的运输及搬运过程，会收到强烈的震动和冲击，可能会造成机件的松动和位移，应做一次周密检查。用手转动手轮，看机件之间转动有无困难，是否有碰撞及不正常的声响，如有应作适当的调整，机器情况正常后才能正式试机。
- 3.油盘内没注油绝不能开机。
- 4.确认电源插头是否正确连接。
- 5.机器运转时，手轮转向是顺时针方向（从手轮外侧面看）。

1.Before you put the machine into operation for the first time after the set-up, clean thoroughly.

2.The machine is adjusted and inspected very strictly before leaving the factory, yet after the long distance delivery and loading, the machine parts may loose or displace the strong shock and hit, you are requested to check it carefully. To move the hand-wheel by hand, to see if there's any difficulty for parts moving, and if there's any impact or unusual sound. If yes, adjust the machine properly, and run the machine until under the normal condition.

3.Never operate the machine without lubricate the oil pan.

4.Confirm the power plug has been properly connected to the power supply.

5.The direction of rotation of the sewing machine is clockwise as observed from the hand-wheel side.

## 2.使用注意事项 Caution in using

- 1.当接通电源或机器运转时，请勿将手与机针接触。
- 2.机器运转时，请勿将手指伸入挑线杆护罩内。
- 3.操作者用手送料时，请勿将手指伸入护指架。
- 4.机头翻动及维修清理时，一定要切断电源。
- 5.操作者离开机器时，必须切断电源。
- 6.机器运转时，注意头或手以及衣物等不得靠紧手轮。
- 7.电机罩、护指器或其他安全装置被拆除时，不得运转机器。
- 8.不能用香蕉水等油漆稀释剂擦洗机头表面。

1.To avoid personal injury, never put your hand under the needle when you turn "ON" the power switch or operate the machine.

2.To avoid personal injury, never put your fingers into the thread take-up cover while the machine in operation.

3.Never put your finger into the protect shelf, when feeding the cloth by hand.

4.To avoid possible accidents because of abrupt start of machine, turn OFF the power to the machine when tilting or repairing the machine head.

5.Always turn OFF the power when leaving the machine.

6.To prevent possible personal injuries caused by being caught in the machine, keep your fingers, head and clothes away from the hand-wheel, while the machine in operation. In addition, place nothing around them.

7.To avoid personal injury, never operate the machine with any of the motor cover, finger guide or safety devices removed.

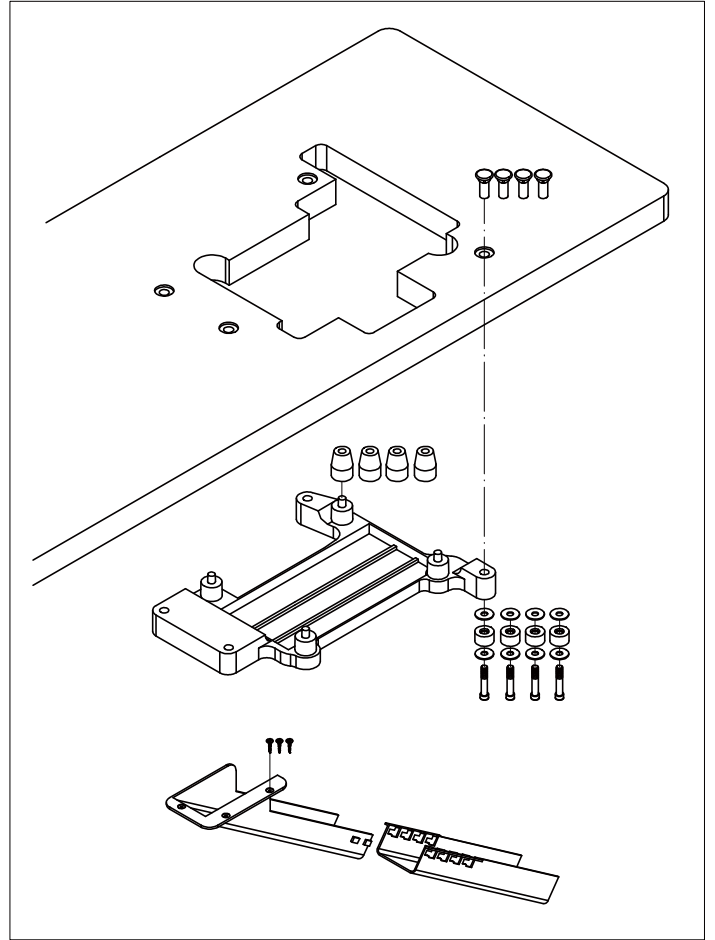
8.Never clean the surface of the machine head with the paint dilution like banana oil.

### 3.机器的安装 Installation

- 1.将托盘与导料槽按右图所示进行安装。
- 2.安装好后将机头轻轻地放在托盘上。

1.Install tray and guide trough as shown on the right.

2.Once installed, place the machine lightly on the tray.



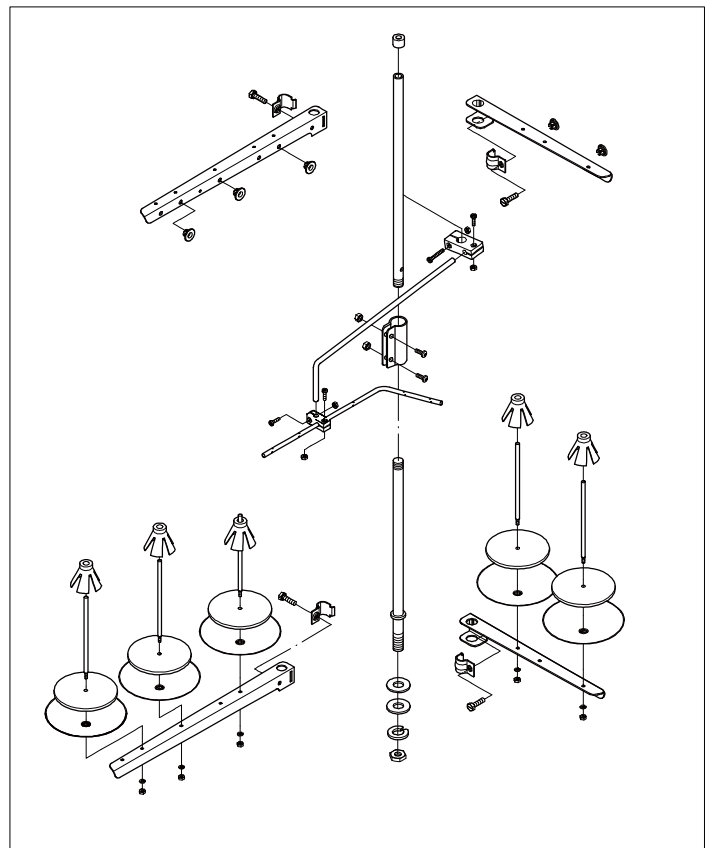
### 4.线架的安装 Mounting the thread stand

1.安装线架部件，并将它插入缝纫机台板孔里。

2.旋紧线架杆下节螺母固定线架装置。

1.Install the thread stand parts insert it into the hole in table top.

2.Tighten the spool rest rod (lower) nut and fix the thread stand unit.



## 5.机器的润滑 Lubrication

使用缝纫机时，如果油面②指到游标窗③的下刻度线以下时，请对机器进行加油。

加油步骤如下：

1.卸下上盖上的喷油视窗①，使用附带的加油壶加入缝纫机油（10号白油）。

2.请把油加满至油面②指到游标窗③的上刻度线位置。请注意加油过多的话，缝纫机油会溢出机头。

3.加完油后，装上喷油视窗①。

在第一次使用缝纫机或有相当一段时间没有使用缝纫机时，请用加油壶在针杆曲柄④、针杆⑤和上弯针台⑥处分别给油2-3滴。

注意：

1.为了防止缝纫机的意外启动，请关掉电源之后再进行操作。

2.新机开始第一次缝纫前，请卸上盖上的喷油视窗①，使用附带的加油壶加入200ml缝纫机油（26号白油）。

Fill gearbox if the pointer ② below the lower tick mark in the oil mark window ③ when using the sewing machine.

The step of lubrication are as follow:

1.Remove the rubber plug ①,fill with oil using the oil bottle in accessory box.(No.10 white oil)

2.Fill oil until the oil pointer ② reaches the upper tick mark in the oil mark window ③. Do not fill too much oil otherwise the oil will flow into the head when turnover the machine.

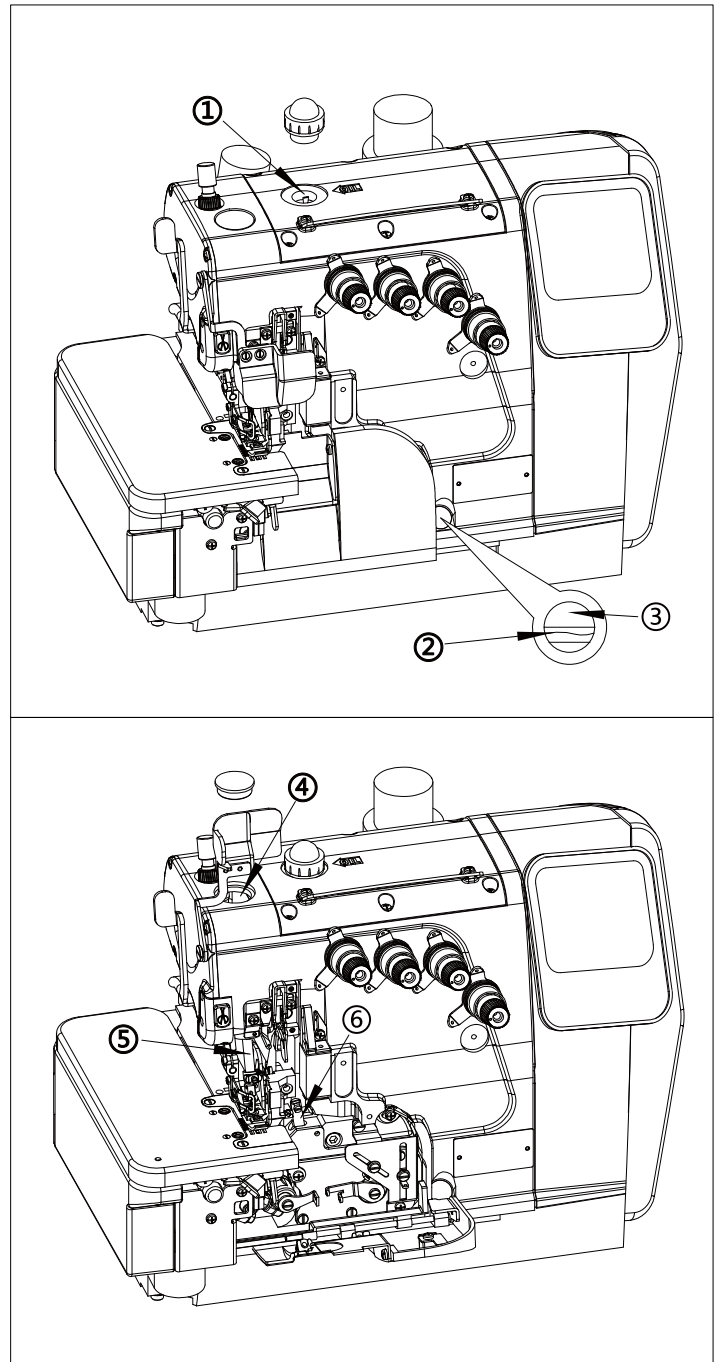
3.Close the rubber plug ① of oil filler after finishing lubrication.

The first use of the machine or a period of time not to use the machine, please use the gas pot in the needle bar crank④, the needle bar⑤ and the needle bending station respectively⑥ to 2-3 drops of oil.

Caution:

1.To prevent the unexpected startup of sewing machine,turn OFF the power supply before the operation is conducted.

2.when using the new machine for the first time,open the rubber plug ① and fill with 200ml oil.(No.26 white oil)



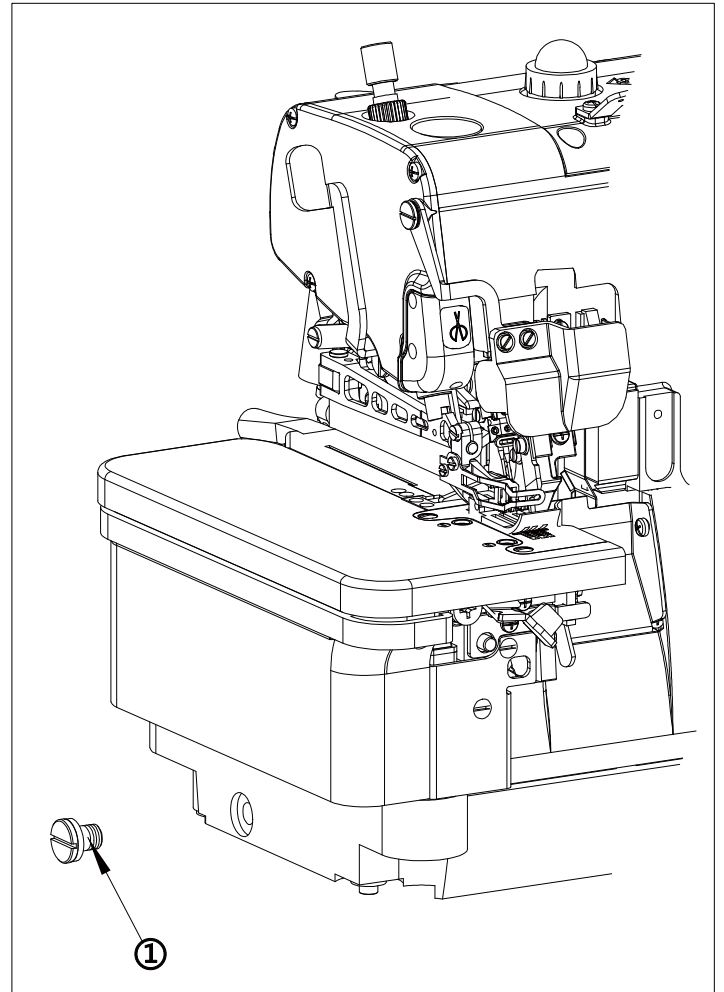
## 6. 润滑油的更换 Oil Change

1. 将放油螺丝①松开，使油槽内的机油完全排出后，再将放油螺丝①锁紧，再重新注入新油。

2. 为了延长本机的使用寿命，请于开始使用的一个月内更换第一次新油，往后约每6个月更换一次。

1. Remove screw ① and drain all the oil from the tank. After draining, tighten screw ①. And refill new oil.

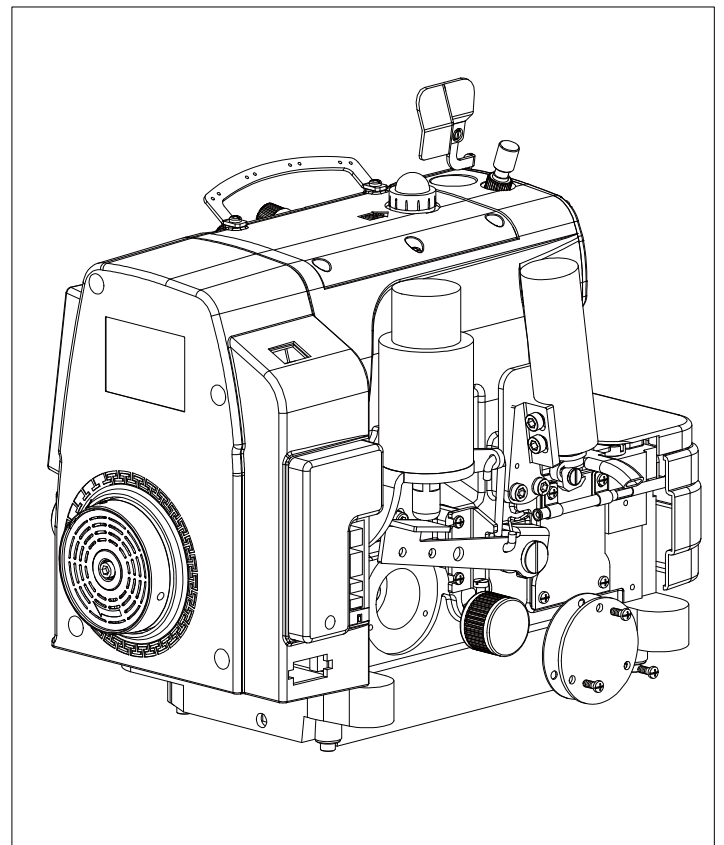
2. For the long life of machine, please change lubrication oil completely after one month of initial operation. After first time, to change lubrication oil every 6 months.



## 7. 滤油器的更换 Replacing oil filter

本机装有滤油器，新机使用一个月后必须更换新品。此后仅需每6个月更换一次。

This machine is equipped with an oil filter, to change the oil filter after one month of initial operation. After that, please change oil filter every 6 months.



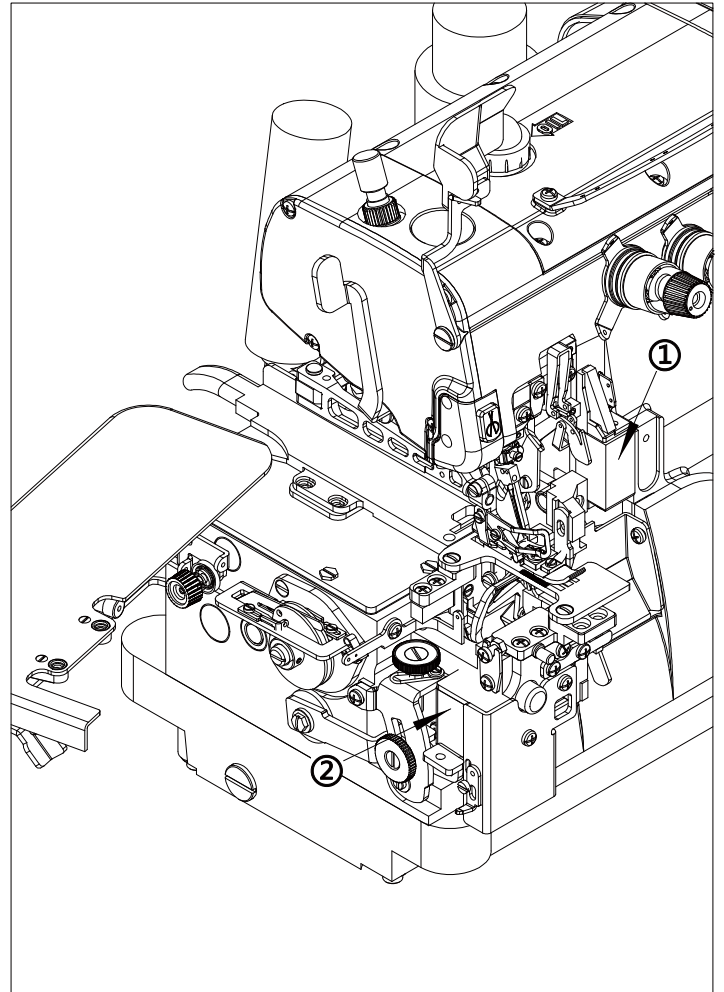
## 8.HR装置的供油 Filling the HR device with silicon oil

在HR装置的硅油箱①和②中，为了防止机线断线加有硅油。请经常检查，尽早补充硅油。

注意：

为了防止缝纫机的意外启动，请关掉电源之后再进行操作。

Fill the HR device ① and ② with oil before it is too low in order to prevent needle thread breakage and fabric damage.



## 9.穿线的方法 Threading

1.打开缝台①、护眼罩②、前盖③，压脚台④。穿过线以后请恢复到原来位置。

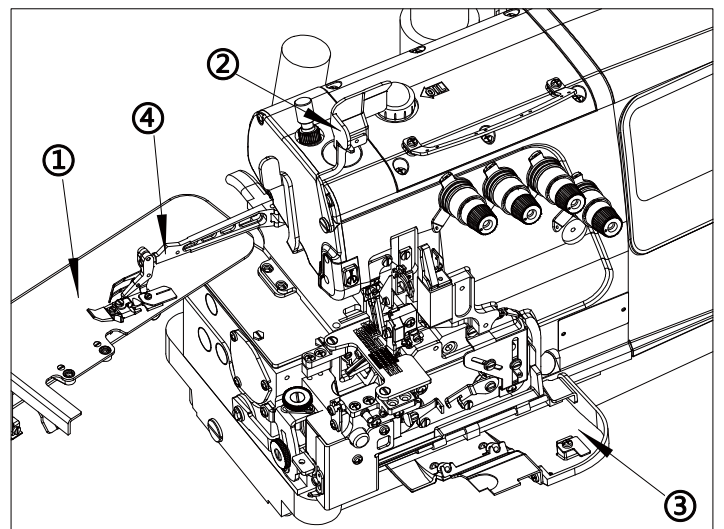
2.参照穿线图正确地进行穿线。

注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。

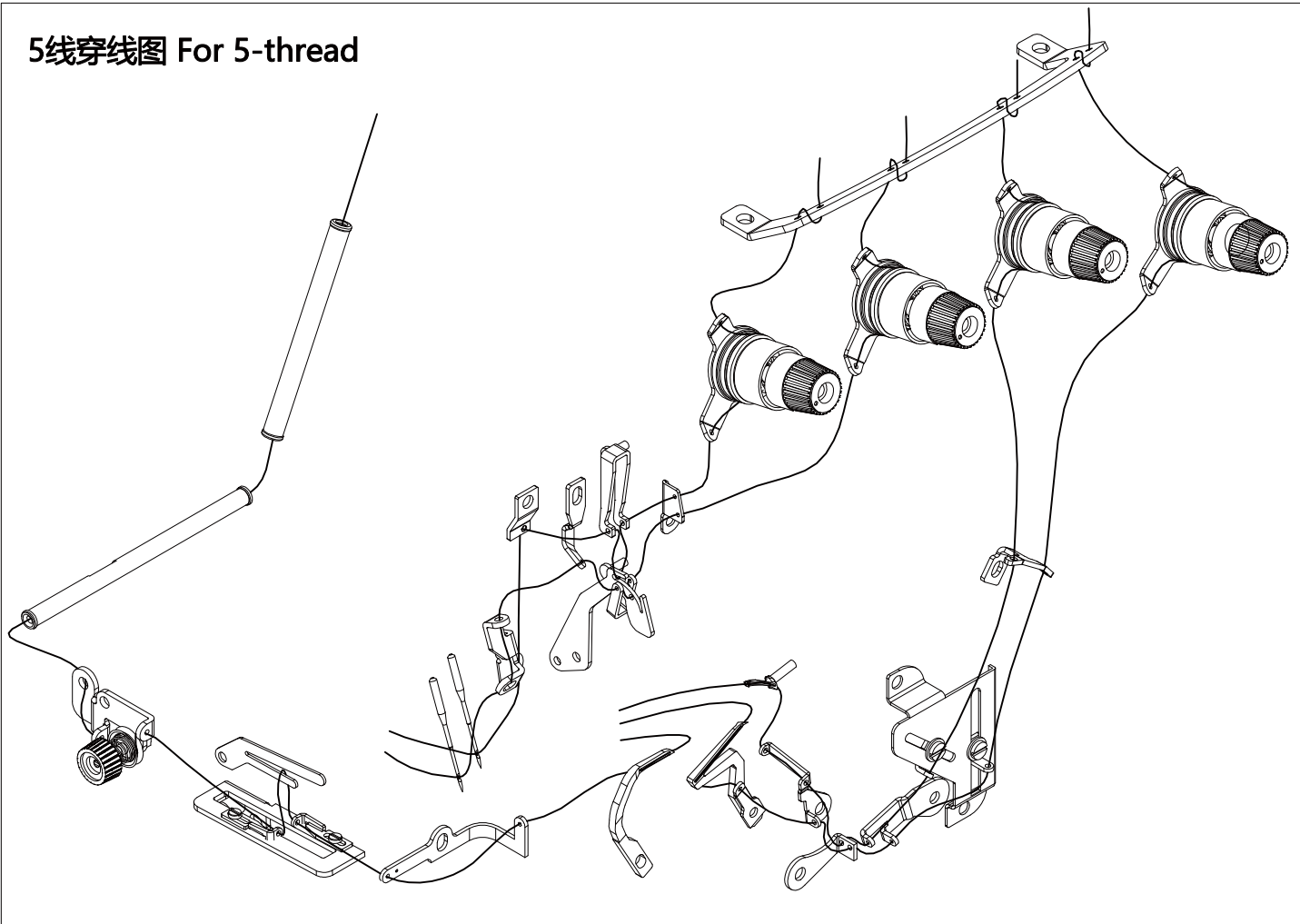
1.Open the Cloth plate①, eye shield②, the front cover③, the presser④. Please go back to your original position after threading.

2.Make sure the machine is threaded correctly by referring to the threading diagram.

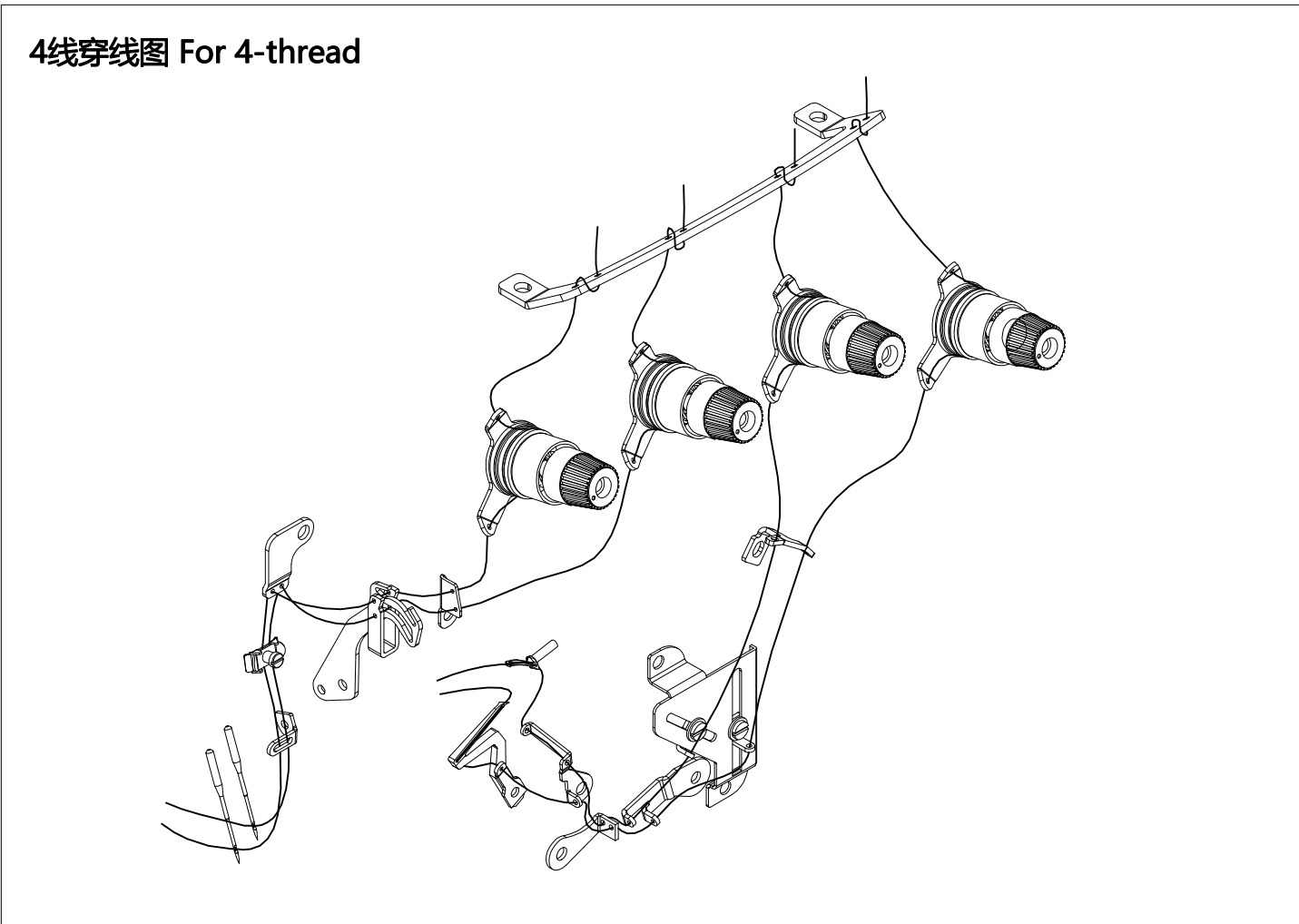
Caution:To prevent the unexpected startup of sewing machine,turn OFF the power supply before the operation is conducted.



### 5线穿线图 For 5-thread



### 4线穿线图 For 4-thread





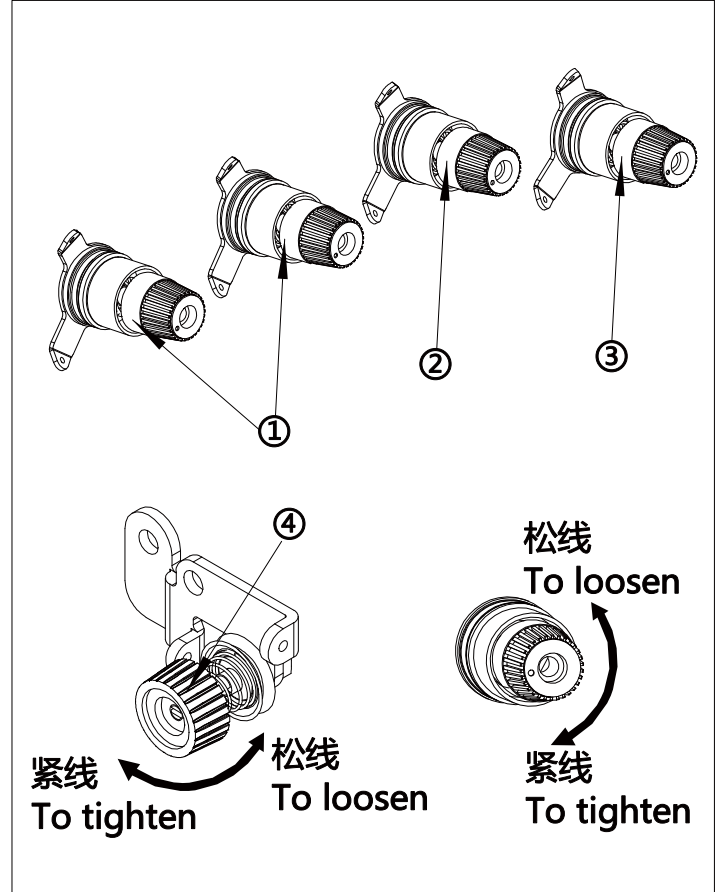
## 10.线状态的调节 Adjusting the thread tension

线状态的调节请用针线调节旋钮①，上弯针线调节旋钮②、下弯针线调节旋钮③、链线弯针线调节旋钮④进行调节。

想将线拉紧一些，可将各旋钮向右旋转，想松一些时可向左旋转。在能取得均匀且漂亮的缝纫效果下，尽量采用较松的夹线状态。

Make tension adjustments with the needle thread knob ①, the upper looper knob ②, and the lower looper knob ③.

If you want to tighten the line, turn the knob to the right. When you want to loosen, turn left. Try to use a looser thread clamping condition to achieve a uniform and beautiful sewing effect.



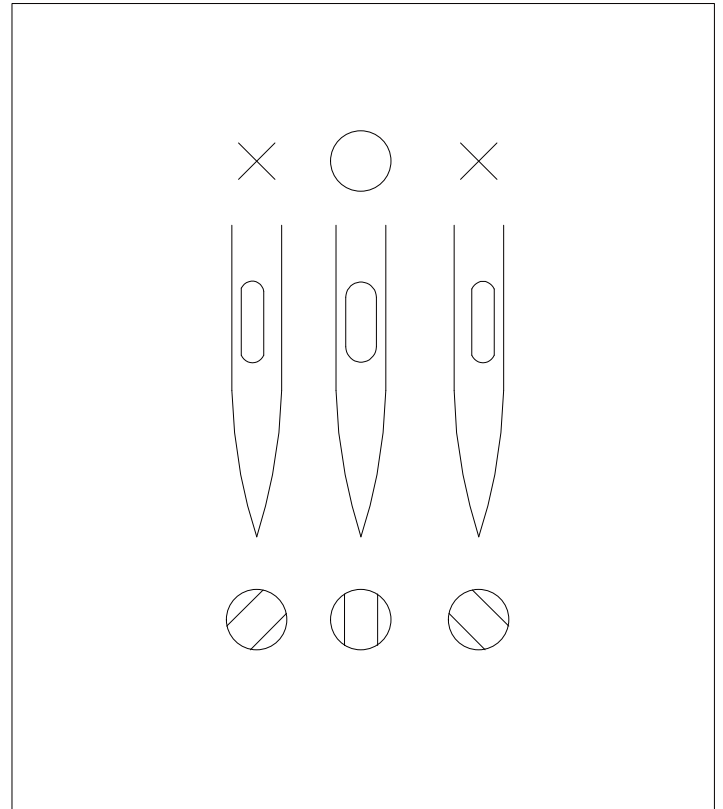
## 11.机针的更换 Replacing the needle

1.旋开锁针螺丝，并取下旧机针，将新机针插至针座的最顶端，且使长槽面向自己。

3.重新将锁针螺丝锁紧。

1.Loosen screw ,then pull out the used needles.Insert the new needles into the holder holes as far as they can go,and let the long groove of the needle face you.

3.Fasten screw .



## 12.压脚压力的调节 Adjusting the Presser foot pressure

1.若要求布料推送顺畅且缝合完美，压脚压力应当尽量轻些。

2.旋松调压螺母②。

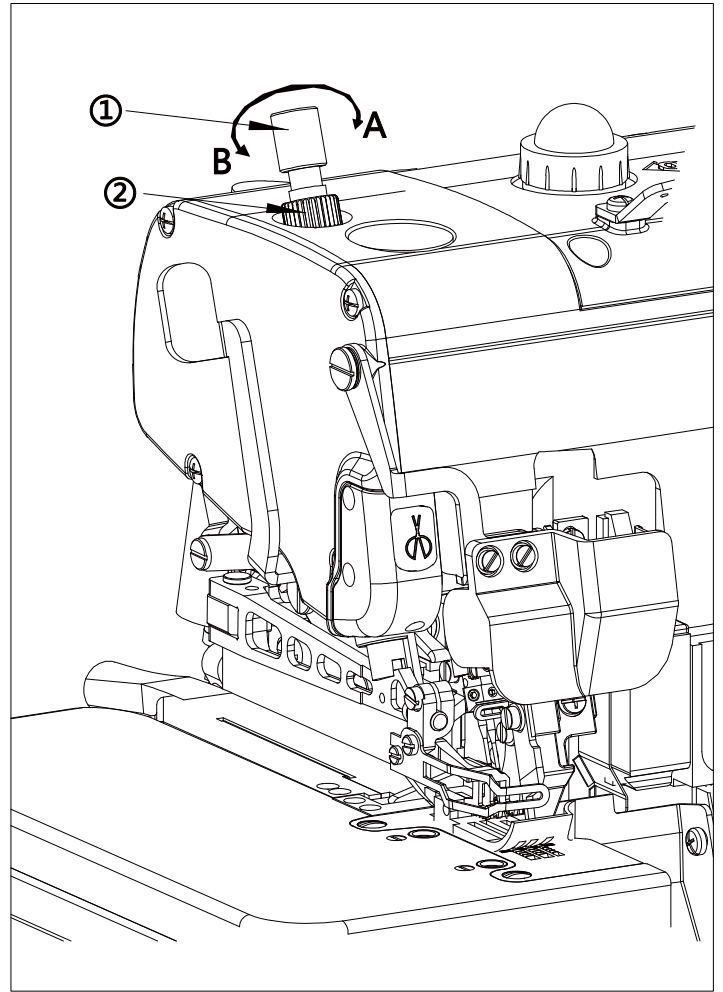
3.若将调压螺钉①朝顺时针方向（即A方向）转动时，压脚压力将增加；若朝逆时针方向（即B方向）转动时，压脚压力将减弱。

4.调节完成后旋紧调压螺母②。

1.Pressure of presser foot should be as weak as possible,so that cloth can be sewed and fed smoothly.

2.Unscrew pressure adjusting nut ②.

3.Presser foot pressure is increased if pressure adjusting screw ① is turned



## 13.差动比的调节 Adjusting the differential feed ratio

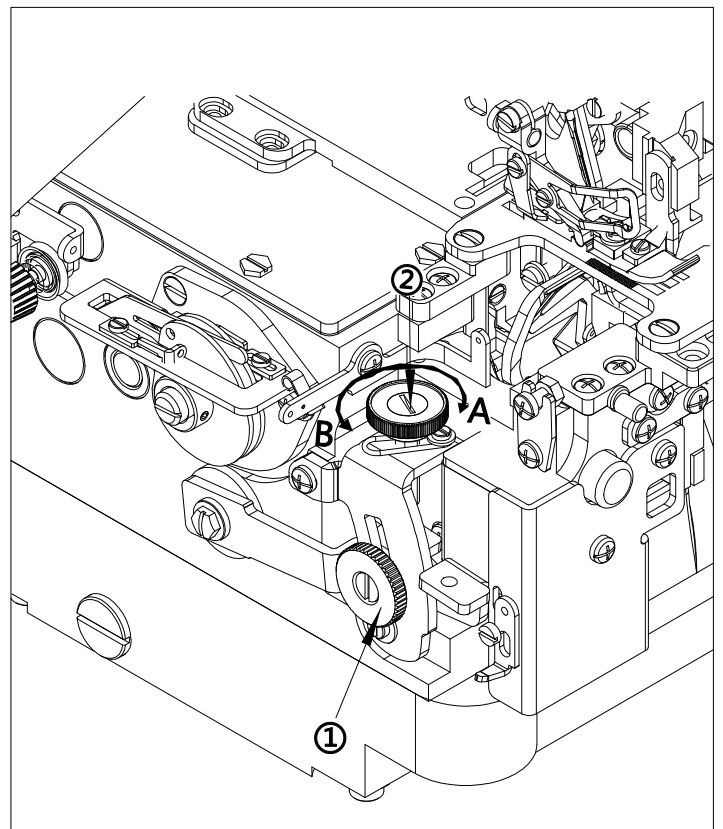
1.旋松螺母①。

2.若将调节螺母②朝顺时针方向（即A方向）转动时，差动比变小，缝好的布料会伸长；若朝逆时针方向（即B方向）转动时，差动比变大，缝好的布料会收缩。

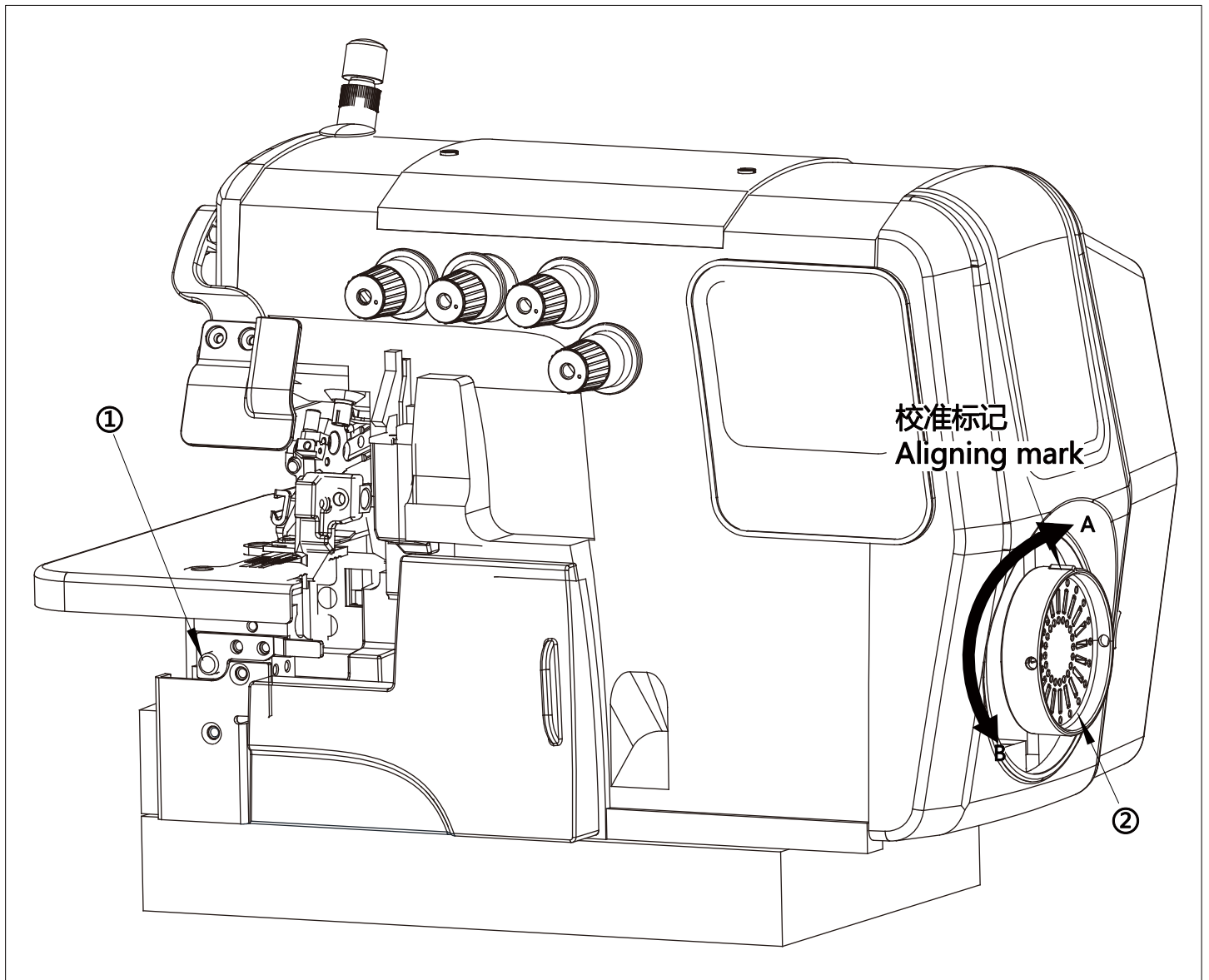
3.调节完成后旋紧螺母①。

1.Unscrew the adjusting nut ①.  
2.If the adjusting nut ② toward a clockwise direction (A direction) rotates, the differential is smaller than that of the sewed cloth will stretch; if in a counterclockwise direction (B direction) rotates, the differential ratio becomes larger, the sewed cloth will shrink.

3.Tighten nut ① when adjustment is complete.



## 14. 针脚长度的调节 Adjusting the stitch length



1. 按住按钮①，旋转手轮②，按钮①会陷进更深处。

2. 这时继续按住按钮①，若将手轮②朝顺时针方向(即A方向)转动时，针距变大;若将手轮②朝逆时针方向(即B方向)转动时，针距变小。

注意:

1. 为了防止缝纫机的意外启动，请关掉电源之后再进行操作。

2. 缝纫机针脚长度的调节，请务必在调节差动比之后进行。

1. While pressing the push button ①, turn the hand wheel ② to seek the position at which the push button goes further into the depth.

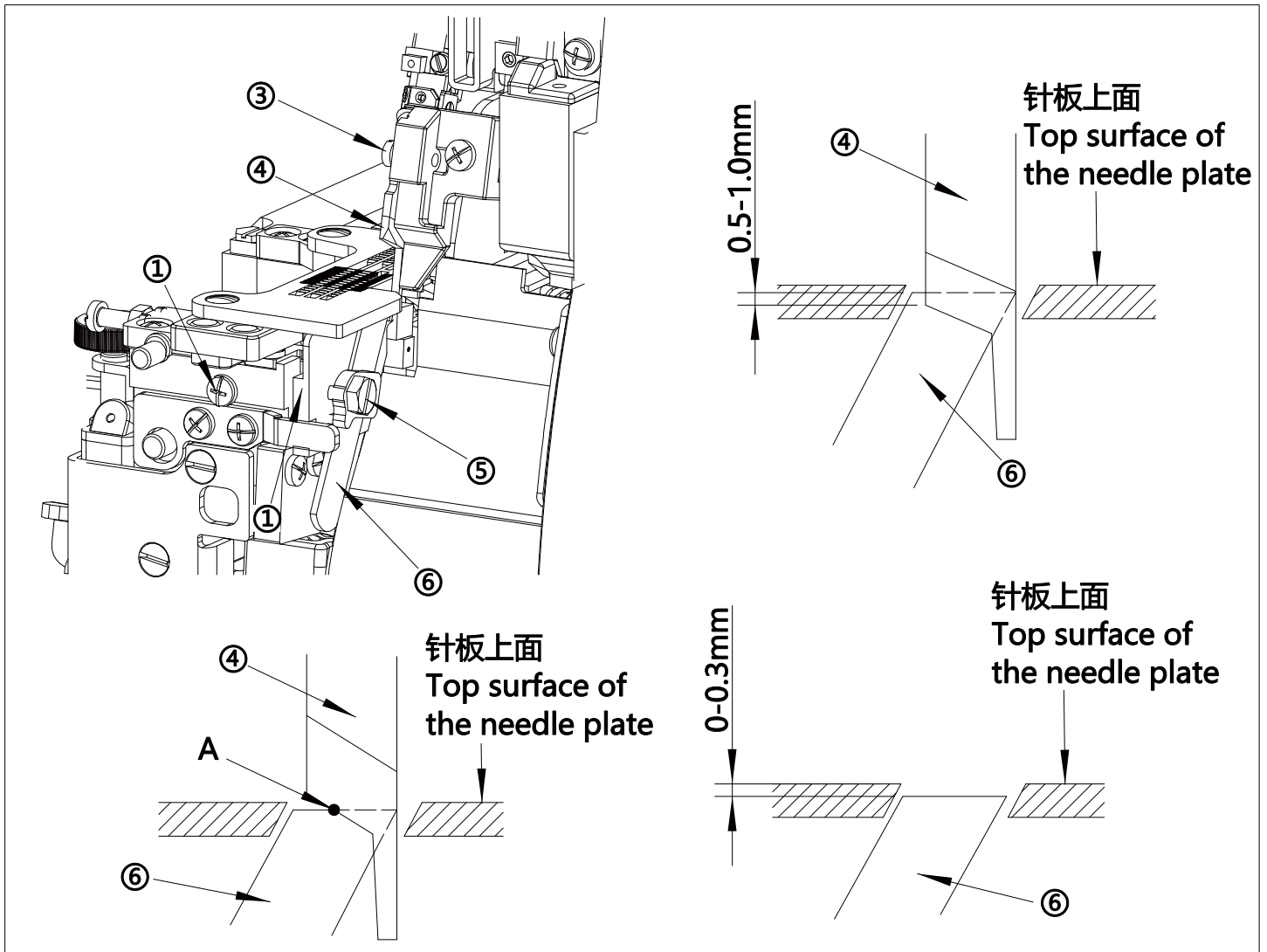
2. Then continue to press the push button ①. If the handwheel ② turns clockwise (A direction), the stitch length becomes larger; if the handwheel ② turns counterclockwise (B direction), the stitch length becomes smaller.

Caution:

1. To prevent the unexpected startup of sewing machine, turn OFF the power supply before the operation is conducted.

2. Before adjust the stitch length of sewing machines, be sure to adjust the differential feed ratio.

## 15.刀片的更换 Replacing the knife



### 1. 上刀的更换

- 1). 松动螺丝①，使下刀架②靠向最左边位置，使用螺丝①临时固定。
- 2). 拔出螺丝③，拆掉上刀④。用螺丝③临时固定新的上刀，旋转手轮，将上刀架置于最下边位置，上下移动上刀进行调节，使上刀和下刀相互咬合0.5-1.0mm的深度，拧紧螺丝③。
- 3). 将上刀④的刀中央A点对准与下刀⑥的刀中央部相交叉的位置，松动螺丝①，确认上刀与下刀没有间隙之后，拧紧螺丝①。
- 4). 在上下刀之间放入线，旋转手轮，确认可以顺利切断线。

### 2. 下刀的更换

- 1). 松动螺丝①，使下刀架②靠向最左边位置，使用螺丝①临时固定。
- 2). 松动螺丝⑤，取出下刀⑥，更换新的下刀。调节下刀，使下刀的刀刃与针板上方的间隙尺寸为0-0.3mm，拧紧螺丝⑤。
- 3). 根据更换上刀的步骤3、4进行操作。

### 注意:

1. 为了防止缝纫机的意外启动，请关掉电源之后再进行操作。
2. 刀片的刃部有划破手指的危险，操作时要特别小心注意。

### 1. Replacing of the upper knife

- 1). Loose screw①, and temporarily screw② after sliding the lower knife holder② to the left.

2).Unscrew screw③, and remove the upper knife④. Temporarily fix the newupper knife with the screw ③, rotate the hand wheel, place the upper knife holder at the bottom position, move the upper knife up and down to make the mutual occlusion about 0.5-1.0mm between the upper knife and the lower knife, tighten the screw③.

3).Center the A point of the upper knife to the point where the center of the lower part of the knife is crossed. Loosen the screws and confirm the gap between theupper and lower knives. Then tighten thescrews①.

4).Check cutting action of knife

2.Replacing the lower knife

1).Loose screw①, and temporarily screw① after sliding the lower knife holder② to the left.

2).Loose the screw⑤ , remove the lower knife⑥ , insert the new lower knife. Adjust the lower knife so that the clearance between the blade of the lower knife and the needle plate is 0-0.3mm, then tighten the screws ⑤.

3).Operate according to steps 3 and 4 for replacing the upper knife.

Caution:

1.To prevent the unexpected startup of sewing machine,turn OFF the power supply before the operation is conducted.

2.The edge of the blade has a risk of splitting the fingers. Be careful when you operate.

## 16.刀的研磨方法 Grinding method of knife

上刀的材质为超硬合金，可在很长的时间内不需要研磨。

刀的切断变钝时，请研磨下刀。

下刀的研磨方法

请参照图示正确地进行研磨。

研磨方法不对时会使刀变钝，不能很快地切断，请予注意。

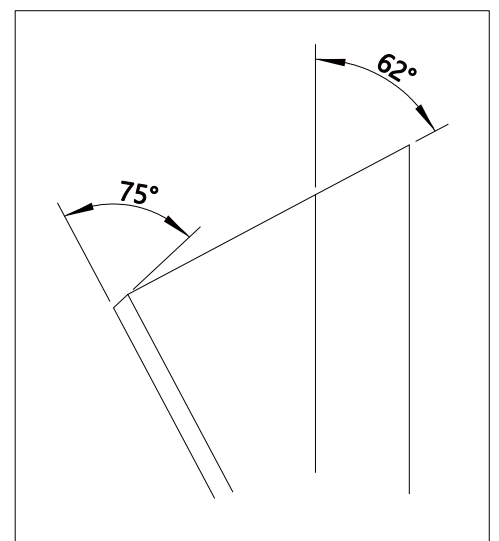
The upper knife is made of super hard alloy and does not require grinding for along time.

When the knife is cut off, grind the lower knife.












Grinding method for the lower knife

Please refer to the diagram for proper grinding.

If the grinding method is wrong, it will dull the knife and cannot be cut off very quickly. Please pay attention to it.



## 缝纫机规格 Specification

										
-3-04	1	3	#11	0	4	0.5-3.8	0.7-1.7	5.5	6500	
-4-26	2	4	#11	2	6	0.5-3.8	0.7-1.7	5.5	6500	
-5-35	2	5	#14	3	5	0.5-3.8	0.7-1.7	5.5	6000	
-5-55	2	5	#14	5	5	0.5-5	0.8-1.5	5.5	6000	
-5-56	2	5	#18	5	6	0.5-5	0.8-1.5	5.5	6000	

# 下沉式台板加工图 Sink plate processing map

