

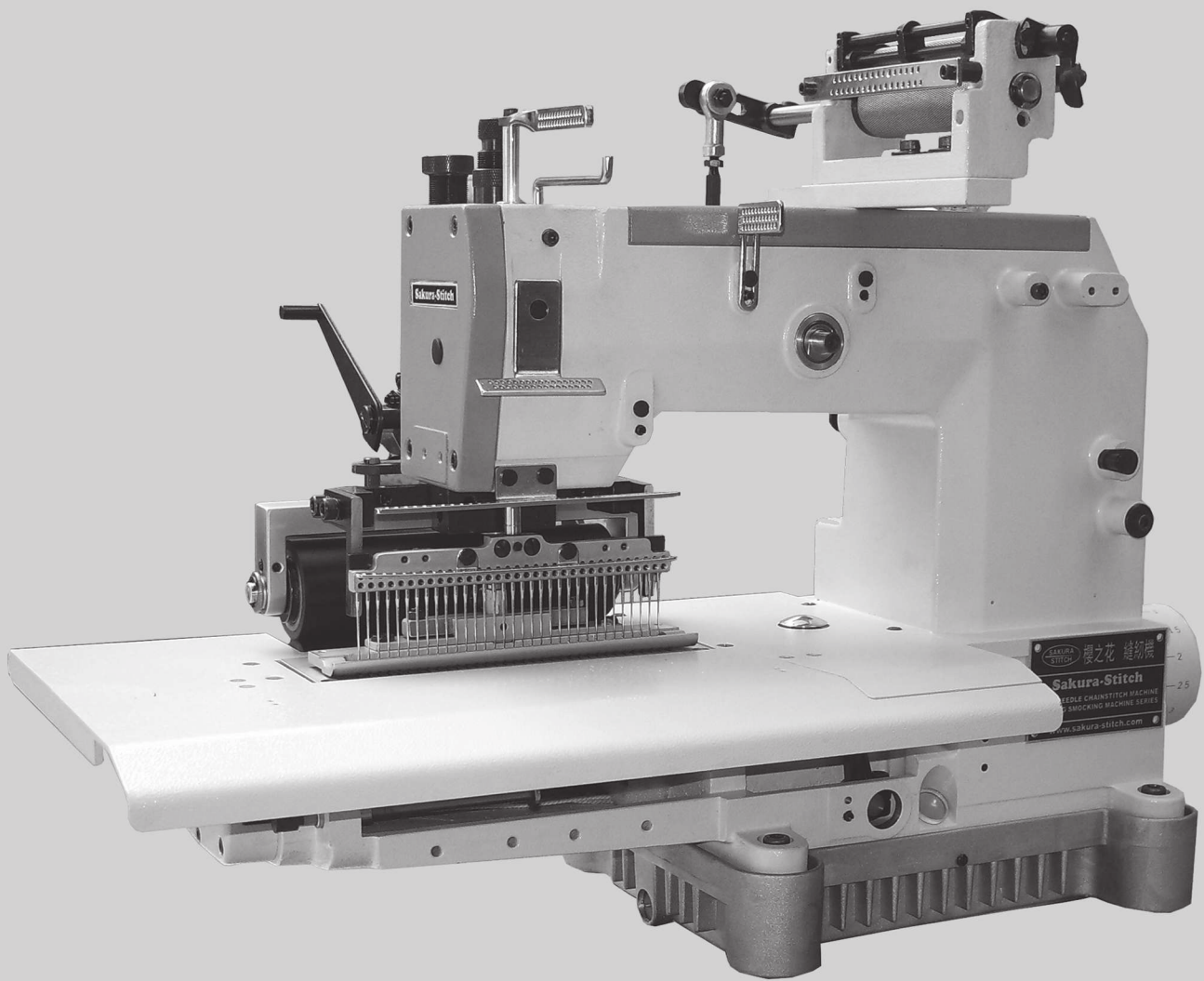
Sakura-Stitch

INDUSTRIAL SEWING MACHINE

櫻之花縫紉機

使用說明書

INSTRUCTION BOOK



CE

Sakura-Stitch Garment Machineries Co., Ltd.

櫻之花服裝機械設備有限公司

重要安全事項說明

IMPORTANT SAFETY INSTRUCTIONS

感謝您購買本機器,為了使這台機器能獲得最佳功能以及安全的操作,務必請正確的使用這台機器,使用前請仔細閱讀使用說明書,希望您能長期使用它.請記得將此說明書放在容易取得的地方.

- 1.當您使用機器時,除了以下事項外,請注意其他基本安全措施.
- 2.使用機器前,除了這本使用說明書外,請詳細閱讀其他相關說明書.此外,請妥為保存這本使用說明書,以便需要時可以隨時取閱.
- 3.先確認機器是符合貴國安全規定及標準後,再使用機器.
- 4.當機器完成操作準備時,所有安全配備必需安裝就緒,在缺少所述安全配備下操作是不被允許的.
- 5.此機器應由受過適當訓練之操作員操作.
- 6.為了安全,我們建議您配戴安全眼鏡.
- 7.以下情形請先關閉電源或拔掉插頭:
 - (1).穿針線,線導片,天平等以及更換梭子時.
 - (2).更換針,押具,針板,送具,頂針片,喇叭,車布導板,以及其他附屬配件時.
 - (3).維修工作時.
 - (4).離開工作場所或工作場所無人看顧時.
 - (5).若使用離合器馬達而無煞車片裝置時,必需待馬達完全停止.

For operating safely and to get the most out of the many functions of this machine, you must operate it correctly. Please read and follow the instructions of this manual, and keep it at hand for future references. We are confident that you will enjoy this machine as much as we enjoyed manufacturing it.

- 1.When you use this machine, please pay attention to the basis safety measures.
- 2.Before using this machine, please read this manual and all related instructions. In addition, please save this manual for your future needs.
- 3.Please use this machine after it has been ascertained that it conforms with safety standards and regulations of your country.
- 4.It is not allowed to operate this machine without the specified safety devices. All safety devices must be in right position. When the machine is ready for operation.
- 5.This machine must be operated by an appropriately trained operator.
- 6.For your own safety, we suggest you wear goggles.
- 7.Please turn off the power switch or disconnect it before doing the following tasks :
 - (1).Threading needle(s), adjusting thread Take-up(s), thread guide(s), and / or replacing bobbin(s).
 - (2).Replacing needles, presser feet, needle plates, feed dogs, needle guards, folders, cloth guides and other parts or accessories.
 - (3).Repairing this machine.
 - (4).When the operator is leaving the working place or when the working place is unattended.
 - (5).While clutch motors without brake pads are used, motors must come to completely stop.

8. 假如不慎讓機器及配件使用之油或油脂, 接觸到眼睛, 皮膚或誤食時, 請立刻以水清洗接觸部位並立即就診.
 9. 在未確認電源是否關閉, 請勿擅自碰觸運轉中之零件或配件。
 10. 維修, 修改及調整等工作, 需由受過適當訓練的技師或熟手為之. 維修時只許使用由櫻之花指定之零件.
 11. 一般維修及檢查工作必須由受過適當訓練的人員為之.
 12. 電子零件維修及保養工作必須由資深的電子技師為之, 或由非常熟練的人員檢查及指導, 及當發現零件損壞時, 應立刻停止機器運轉
 13. 在做裝有氣動式零件(例如氣缸)機器的維修及保養工作前, 機器連接空壓機及高壓空氣必須予以關閉, 機器中殘存高壓氣體必需予以消除, 此外調整及性能檢查只能由受過適當訓練的技師或熟手為之.
 14. 機器使用一段時間, 必需定期清理.
 15. 為使機器能正常操作, 機台務平放地上, 機器避免在強烈噪音的環境下操作.
8. By any chance, if you allow grease, oil, or any fluid contact your skin or eyes, please wash the contacted area completely with clean water and consult a medical doctor. If the fluid was swallowed contact a medical doctor immediately.
 9. Before confirming the power is turned off, do not touch any operating part or device.
 10. Qualified technicians are required for machine adjustment, modification, and repair. Only genuine parts from Sakura-Stitch are recommended for replacement. Damage resulted in using generic parts are subject to your own risk.
 11. Routine maintenance and check-up have to be performed by appropriately trained persons, or qualified technicians.
 12. Qualified technician or well-trained persons are required for services to electronic components knowledge of electronic is essential for conducting adjustment or repair tasks. Stop the machine immediately when discover the failure of any of the electronic components.
 13. The air hose has to be detached from the machine and the compressor or air supply has to be cut off before repairing and servicing the machine equipped with pneumatic parts such as an air cylinder. Qualified technicians or well-trained persons are required for adjustment and repairs.
 14. To ensure the best performance, periodically clean up on the machine is necessary.
 15. To level the machine on the ground is essential in order to ensure a proper operation and lower noise. Avoid operating a machine at a noisy surrounding.

16. 選用適當的電源插頭, 並由電子技師將其按裝在機器上, 且插頭必需插在接地線之插座上.
 17. 機器只允許被使用於指定用途上, 其他用途是不允許的.
 18. 修改或變更機器必需依照安全規定及標準, 同時採取有效的安全措施, 本公司不承擔任何私自因修改或變更機器所引起損壞之責.
 19. 警告提示以兩種符號標示:
 - (1). 對操作員或服務人員之傷害危險為了避免觸電之危險, 請勿打開馬達電器箱之外蓋, 也不要觸摸電器箱裡面之零件.
 - (2). 必需特別注意事項
 - a. 絕對不可在移開皮帶蓋, 手指保護蓋或安全配件後, 進行機器操作.
 - b. 為了避免被機器纏住, 當機器運轉中, 您的手, 頭髮及衣服, 需遠離手輪, 皮帶及馬達, 此外這些部位周圍不可放置任何物品.
16. A proper power plug must be used with this machine by electrician. Please connect the power plug to a grounded receptacle.
 17. This machine can only be used for the designed purpose. Other uses of this machine are not allowed.
 18. Any modification or conversion made on this machine must be conformed with the safety standards and regulations. Precaution is necessary. We assume no responsibility for damage caused by modification or conversion of this machine.
 19. Two safety warning signs are applies :
 - (1) For the safety of operators and service persons, please don't open the cover of any electronic control boxes of motor or other devices and don't touch any components inside to avoid electrical shock hazards.
 - (2) Always keep in mind :
 - a. Please keep your hair, fingers and cloths away from the hand wheel "bobbin winder", V belt and motor while the machine is in operation to prevent the risk of injuries by tangled into them.
 - b. Please never put your fingers under the needle or in the thread take up cover when you turn on the power switch or operate the machine.

- c. 當您打開電源開關後或機器已在運轉中, 絕不可將您的手放在針的下方或針線控線桿外蓋中.
 - d. 當機器運轉中,梭頭高速轉動,為了避免對手可能引起之傷害, 必需確定您的手保持遠離梭頭附近, 此外, 當更換梭子時, 確定電源開關已關閉.
 - e. 當放置或抬起機頭時, 小心勿將手置於機器中.
 - f. 為了避免機器突然啟動而引起可能意外,當機頭傾斜或移開皮帶蓋及皮帶時,請關掉機器電源.
 - g. 如果您的機器是配置伺服馬達, 機器於靜止狀態時,馬達是不會產生噪音的, 為了避免機器突然啟動而引起可能意外, 故請關掉機器電源.
 - h. 為了避免觸電之危險,請絕不要在移開電源接地線後操作機器
 - i. 為了避免觸電或電子零件損壞而引起之可能意外, 請先切斷電源, 再插上或拔掉插頭.
- c. Please never put your fingers under the needle or in the thread take up cover when you turn on the power switch or operate the machine.
 - d. While the machine is in operation, the hook rotates at a high speed. Please keep your hands away from the area of hook to prevent possible injury to your hands. In addition, please make sure to turn off the power of the machine while changing bobbins.
 - e. Be careful not to place your fingers inside the machine when moving / raising the machine head to avoid possible physical injuries.
 - f. Please turn off the power of the machine before tilting the machine head or removing the belt cover and the V belt to avoid possible accidents due to abrupt start of this machine.
 - g. The motor does not produce noise while the machine is at rest if your machine is equipped with a servo motor. So, please turn off the power of this machine to avoid possible accidents due to abrupt start of the machine.
 - h. Never operate the sewing machine with the ground wire removed to avoid electrical shock hazards.
 - i. Please turn the power switch off in prior to the connection or disconnection of the power plug to prevent possible accidents due to electric shock or damaged electronic components.

特別事項

為了避免機器故障及損壞,請先確定以下事項

- 1.當您安裝好機器後,做第一次機器操作前,請徹底清潔機器.
- 2.清除運送途中累積之灰塵及溢出之油脂.
- 3.確定電壓安裝正確.
- 4.確定電源插頭正確地接上電源.
- 5.當使用電壓與標示電壓不同時,請勿使用機器.
- 6.確定機器轉動方向是否正確.

警告 :

以下各步驟,請先將電源關掉,以免因為機器突然啟動造成之意外

WARNING

Please confirm the following to avoid malfunction and damage to this machine.

- 1.Clean this machine completely before putting this machine in operation for the first time after set up.
- 2.Clean all dust and oil gathered during transportation.
- 3.Confirm that the voltage are set correctly and phase (single or 3 phase) of motor.
- 4.Confirm that the power plug is properly connected to the power supply.
- 5.Never use the machine where the voltage type is different to the designated on shown on the motor nameplate.
- 6.Confirm that the direction of the rotation of the machine pulley is correct.

Warning :

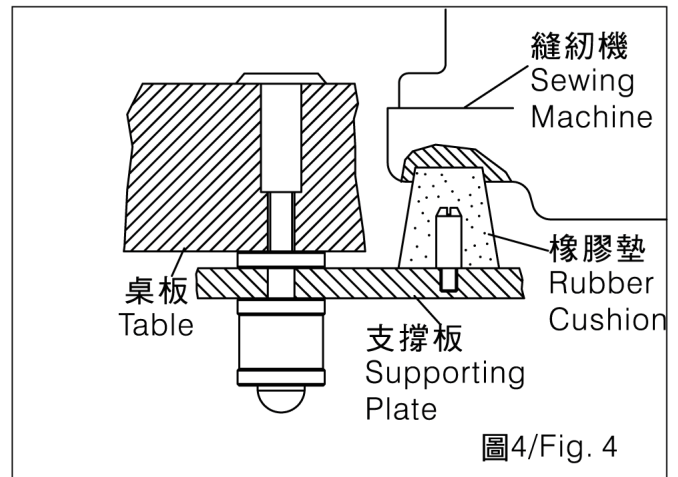
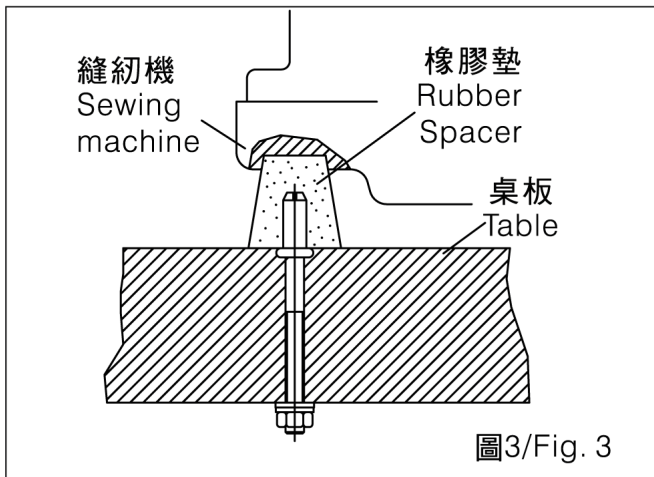
Before doing the following operation or adjustment, please turn the power off to prevent accidents caused by abrupt start of the sewing machine.

機器如何安裝

HOW TO INSTALL THE MACHINE

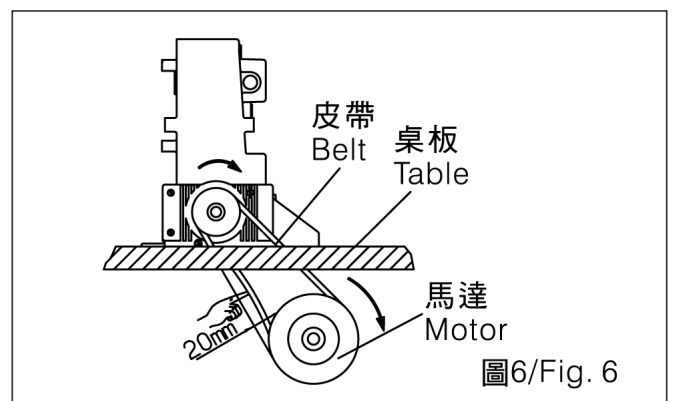
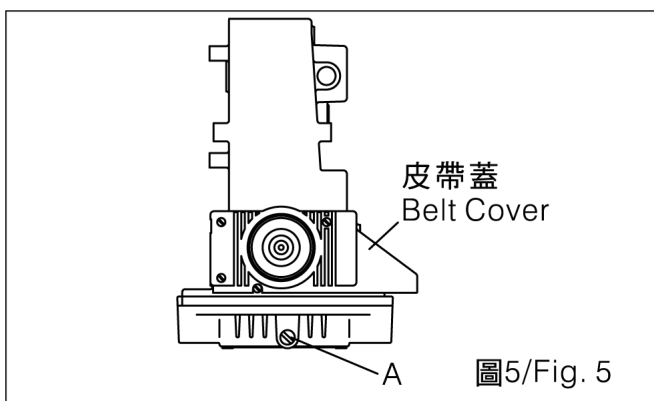
1. 依本機器所附桌板裁製圖及零件組合圖所列之配件，依序安裝防震基座及線架。
(如圖3, 圖4所示)

1. Use the accessories of the machine one by one to install the anti-shock seat and thread stand as the attached table cut-out and the parts list showed. (Fig. 3, Fig. 4)



2. 馬達之轉向為順時針方向，皮帶之鬆緊度以用手指能向內壓20 mm為宜，同時為安全起見，請務必鎖上皮帶蓋。(如圖5, 圖6所示)

2. The motor operating direction is clockwise. The best tightness is to be able to press the belt in 20 mm by a finger. Meanwhile, for the safety, please lock the belt cover. (Fig. 5, Fig. 6)



3. 皮帶輪及縫合轉速，請參照表4。

3. Please refer to Table 4 to see the operating speed of the belt wheel.

馬達轉速(每分鐘轉速) Motor Speed (S.P.M.)	馬達皮帶輪的外徑 (mm) Outer Diameter of the Motor Belt Wheel (mm)	
	60Hz	50Hz
4,500	ø90	ø105
4,000	ø80	ø95
3,500	ø70	ø85

表4/Table 4

注意：

- (1). 使用新機器最初一個月運轉速度約為最高速之80%，並請選擇正確的馬達皮帶輪尺寸。(表4)
- (2). 桌板厚度約為50 mm。
- (3). 馬達規格：離合器馬達，3相2極400瓦特(1/2HP)。
- (4). 皮帶規格：M型V字皮帶。

NOTE:

- (1). In the first month, the max speed of the new machine is 80% of its original speed. Please choose the correct size of the motor belt. (Table 4)
- (2). Table thickness is about 50 mm.
- (3). The specification of the motor: clutch motor, 3 phase, 2 poles, 400 W (1/2HP)
- (4). The specification of the belt: M type, V belt.

潤滑油之注入與更換

FILL AND CHANGE THE LUBRICATION OIL

新機器運裝前均已將油倒盡，因此機器使用前必須加入潤滑油。

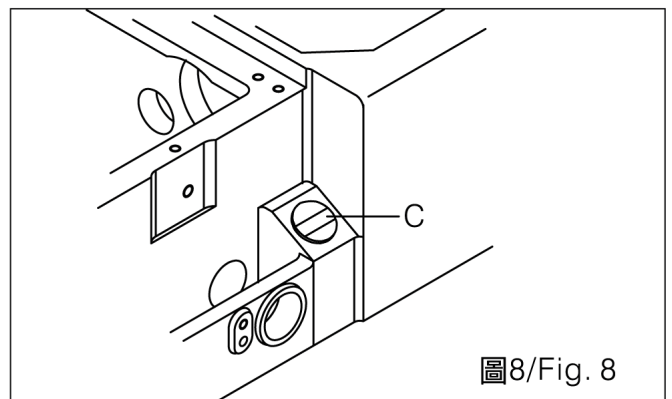
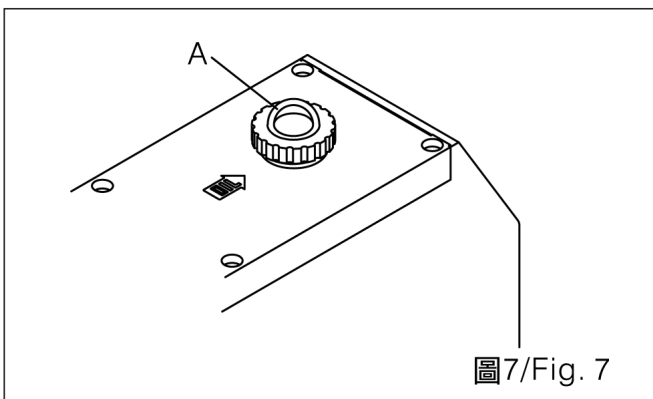
The oil is empty in each new machine before shipping. Therefore, it is necessary to fill the lubrication oil before using.

1. 潤滑油之注入(圖7，圖8)：

- * 將A旋開，以包裝箱內所附之超高速潤滑油或選用MOBIL #10或ESSO #32等級之潤滑油加入，使油窗C位於上油標線即可，然後再鎖緊A。

1. Fill the lubrication oil (Fig.7, Fig. 8):

- * Loosen A, and fill it with the super high-speed lubrication oil attached with the packing box. Or, you may use MOBIL #10, ESSO #32, or equivalents. When the oil reaches the high oil line of the oil inspection lens C, lock A tightly.



2. 潤滑油之更換

- * 將螺絲A鬆開，使油槽之油完全排出後再鎖緊。
- * 為延長本機器之壽命，請於開始使用四個星期後更換新油，爾後約每四個月更換一次。

2. Change the lubrication oil:

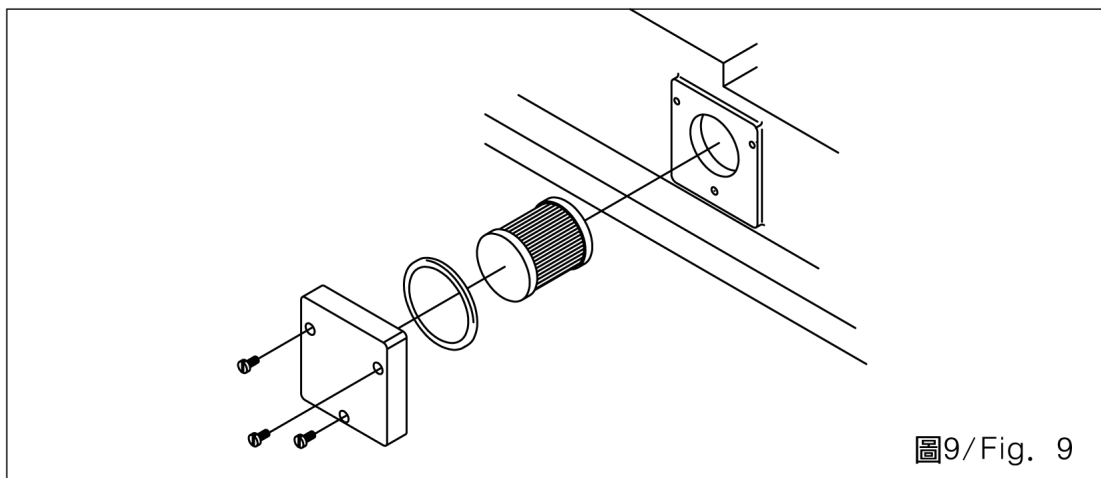
- * Loosen screw A, and re-lock it after the oil in the oil tank has emptied.
- * For extending the term of use, please change the oil after 4 weeks after first use. Then, change the lubrication oil every 4 months.

3. 濾油器之更換(圖9)：

- * 本機器特別裝有濾油器，約每使用一個月後應卸下清洗，必要時得更換新品。

3. Change the oil filter (Fig. 9)

- * This model has equipped an oil filter especially. This filter should be cleaned every one month, and should change a new one if necessary.



針之更換

CHANGE THE NEEDLE

- * 選用針之規格與尺寸請參照表5。

- * Please refer Table 5 to know the specifications and the sizes of the needles.

針的規格系統 NEEDLE SYSTEM	針的尺寸 NEEDLE SIZE
Schmetz UY113GS	#70 - #160
Organ DV x 57	#14 - #18

表5/Table 5

- * 旋開螺絲A並取下針。(圖10)
- * 將新針插入針座之針孔最底端，並使針之凹槽向著自己。
- * 車如果針穿裝不正確，不但會引起跳針、斷線，還會損壞勾針，務必注意。
- * 重新鎖緊螺絲A。

- * Loosen screw A and take off the needle. (Fig. 10)
- * Insert the new needle into the needle hole of the needle seat until the needle reaches to the bottom. In addition, turn the needle to have the groove on the needle facing you.
- * If installed the needle incorrectly, it will cause skipped stitches, broken threads, and will break the needle. Please be very careful about this.
- * Retighten the screw A.

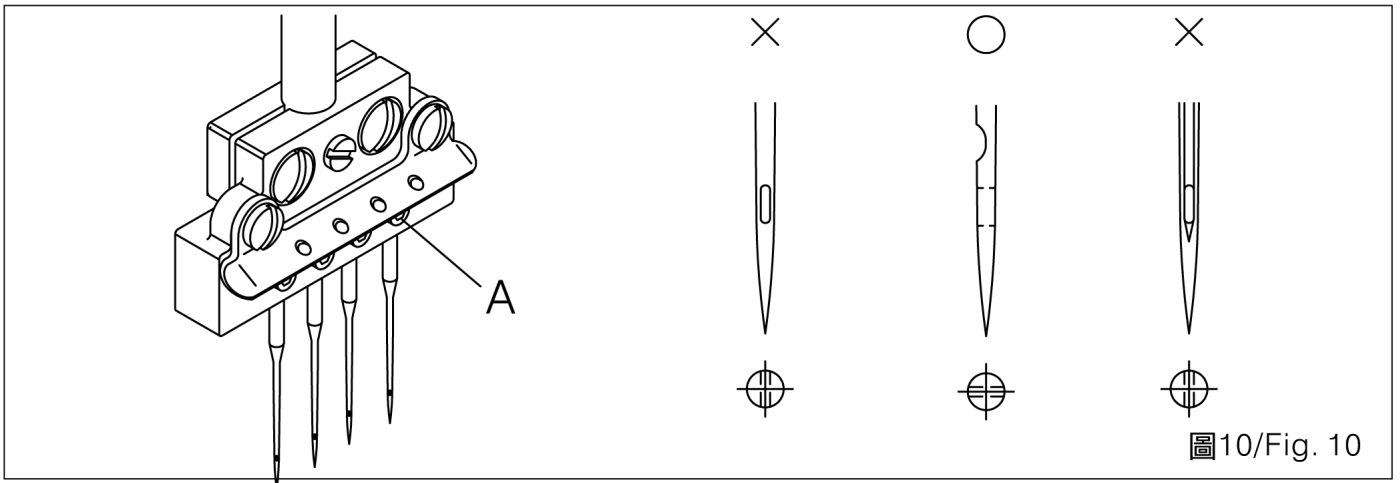


圖10/Fig. 10

穿線方法

THREADING

1. 請確實按照圖示作好針之穿線，錯誤之穿線將引起斷線，跳針或車縫不平坦等現象。(圖11)

1. Please thread as the figure illustrated, otherwise, it may cause thread-broken, skipped stitches, or uneven stitches. (Fig. 11)

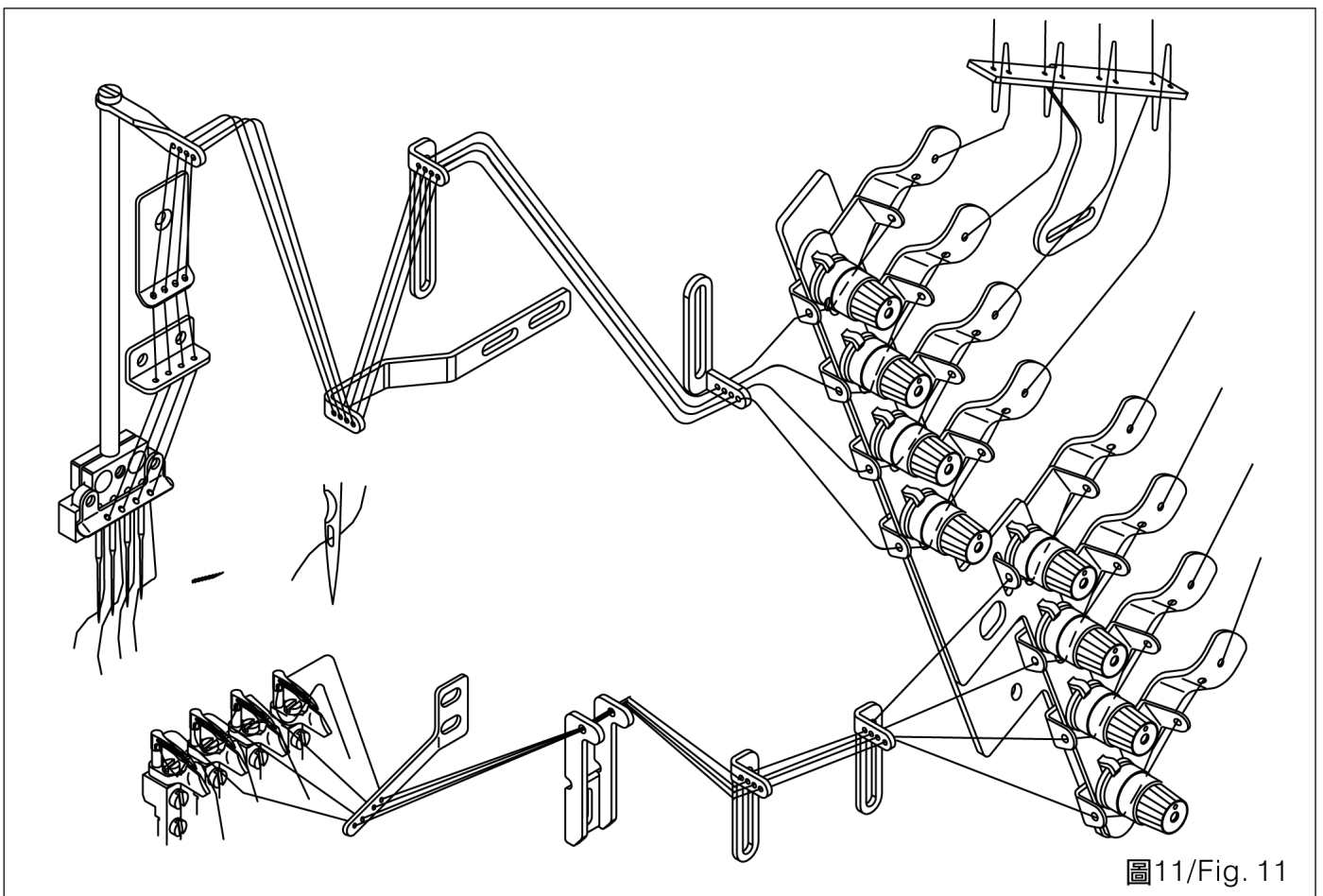


圖11/Fig. 11

2. 在穿勾針線時，應將鉤針座引出軸沿箭頭方向拉出使鉤針座向前彈出，然後進行穿線。(圖12)

2. When threading, the leading shaft of the looper holder should be pull out as the arrow direction, so that the looper holder will slightly move forward. Then, proceed threading. (Fig. 12)

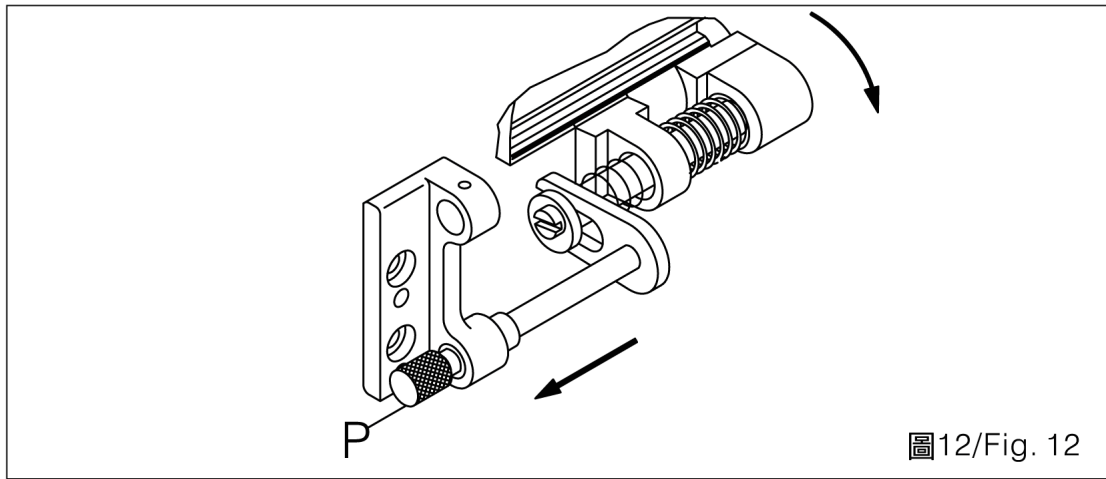


圖12/Fig. 12

控線調整

控線強弱必須根據車縫布料層數線的種類與車縫的針距等不同而做不同之調整。(圖11)

- * 將控線鈕順時針方向旋轉時，線越緊，反之則越鬆。

針控線桿之調整(圖13)

- * 針線控線桿B依縫線使用種類來選擇使用之狀態，放鬆螺絲A將B上下移動調整，在使用伸展性大的縫線時將B上移，反之下移。

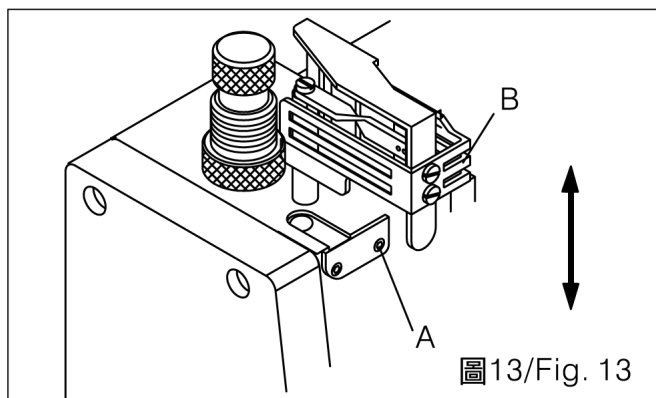


圖13/Fig. 13

THREAD CONTROL ADJUSTMENT

The thread tension strength should be adjusted differently according to the fabric, the layers amount of the sewing fabric, and the stitch length. (Fig. 9)

- * Rotate the thread control knob clockwise, and the thread tension will be tighter. Otherwise, the tension will be looser.

Adjust the needle thread control rod (Fig. 13)

- * Based on the thread types to adjust the needle thread control rod B to the best using status. Loosen screw A to move B up or down to adjust. Move B upward when using high extensibility thread. Otherwise, move B downward when using low extensibility thread.

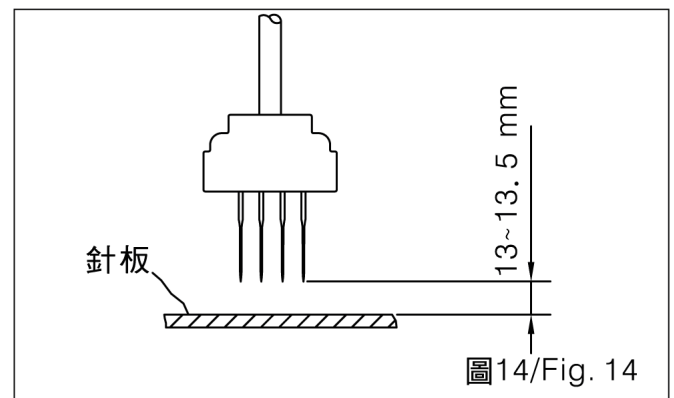


圖14/Fig. 14

針高度之調整

- * 當針棒上升至上死點時，調整針尖與針板面之距離為13~13.5 mm(圖14)

ADJUST THE NEEDLE HEIGHT

- * When the needle bar rises to the upper dead point, adjust the distance from pinpoint to the surface of the needle plate to be 13~13.5 mm. (Fig. 14)

- * 打開上方之側蓋橡膠塞A，並鬆開螺絲B，上下調整針棒之高度後再固定之。(圖15)

- * Open the rubber plug A of side cover on the top, and loosen screw B. Then fix it after adjust the height of the needle bar up and down.(Fig. 15)

注意：經過調整後，必須確定每一根針是通過針板的針孔中央。(圖16)

Note: Make sure that every needle is through the central of the needle hole of the needle plate after adjustment. (Fig. 16)

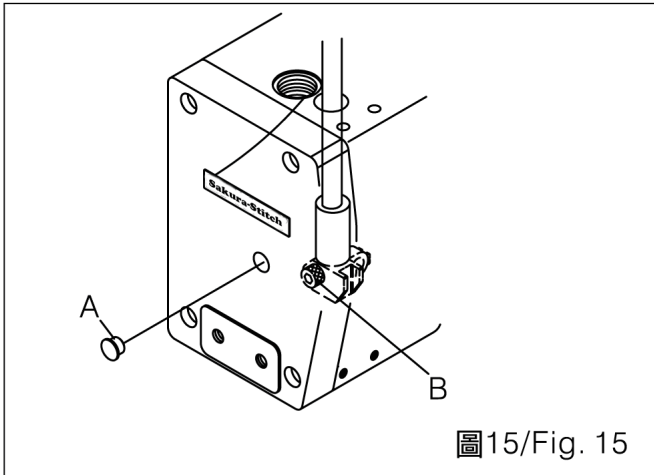


圖15/Fig. 15

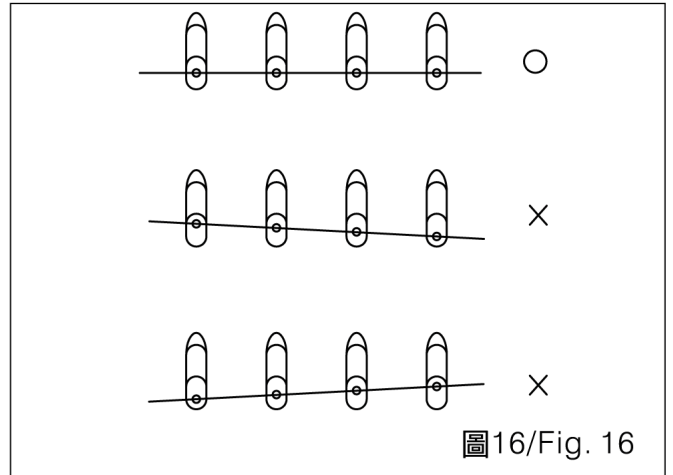


圖16/Fig. 16

護針片調整

ADJUST THE NEEDLE GUARD PLATE

放鬆螺絲A，調整護針片，使其與針之間隙為0~0.1 mm(圖17)後，再鎖緊螺絲A。

Loosen screw A, and adjust the distance from the needle guard plate to the need to be 0~0.1 mm. Then, tighten the screw A. (Fig. 17)

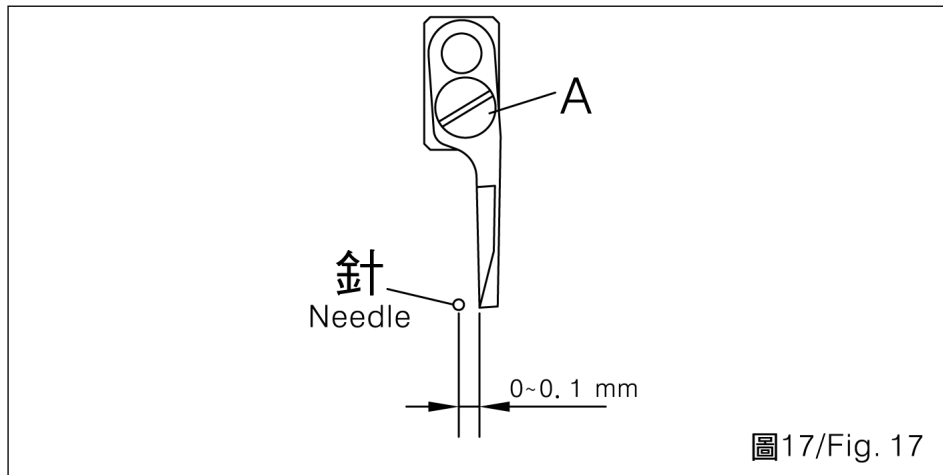


圖17/Fig. 17

針與勾針之調整

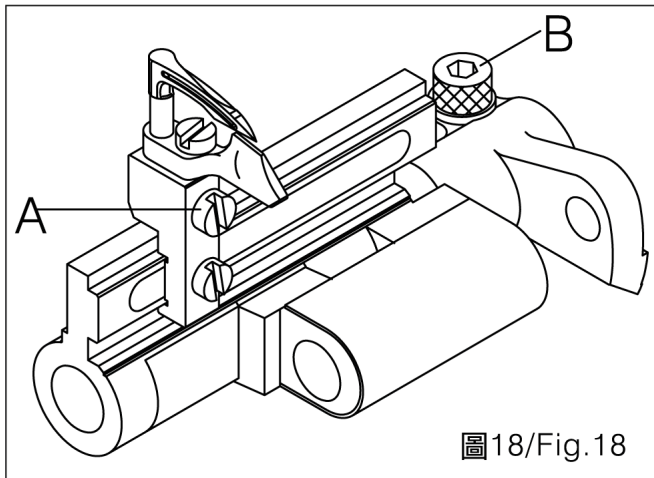
ADJUST THE NEEDLE AND THE LOOPER

1. 將勾針完全插入勾針座內稍微鎖緊。(圖18)
2. 轉動皮帶輪使針上升，並使勾針前進至左側中心線。(圖19)

1. Insert the looper into the looper holder completely, and tighten it a little. (Fig. 18)
2. Turn the belt pulley to raise the needle and to move the looper forward to the left central line of the needle. (Fig. 19)

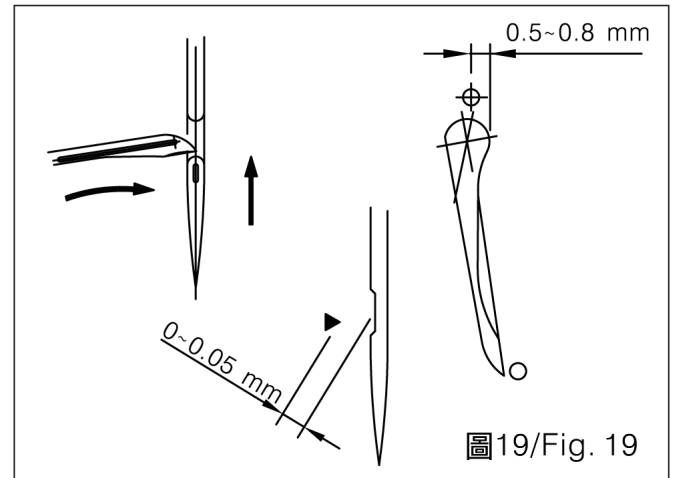
3. 調整勾針尖與針側之間隙為0~0.05mm。

4. 再鎖緊螺絲A。



3. Adjust the looper so that the distance between the looper top and the needle side is 0~0.05 mm.

4. Retighten the screw A.



勾針調整

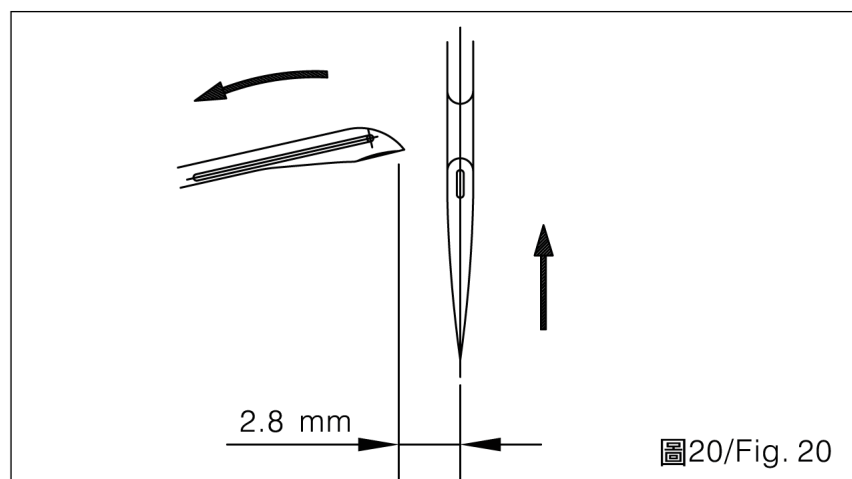
當針位於下死點時，勾針尖端與針中心線之間隙為2.8mm。(圖20)

調整時將勾針底座驅動桿固定螺絲B放鬆，前後調整勾針座後再鎖緊螺絲B。(圖18)

ADJUST THE LOOPER

When the needle locates at the lower dead point, the distance from the looper top to the central line of the needle is 2.8 mm. (Fig. 20)

For the adjustment, please loosen the fixed screw B of the drive rod of the looper seat, adjust the looper seat back and forth, and then retighten the screw B. (See Fig. 18)



針與勾針之時位關係

針由下死點開始往上移，且勾針由後死點往前移至如(圖21)A所示之位置時，勾針尖與針

TIMING POSITION OF THE NEEDLE AND THE LOOPER

When the needle starts moving up from the lower dead point, and the looper starts moving forward from the rear dead point to the position A show as the Fig. 21, the

孔上方之距離為1.5mm。

distance from the looper top to the upper point of the needle hole is 1.5 mm.

針棒由上方往下移時，勾針由前死點往後移至如(圖21)B所示位置時，勾針與針孔上方之距離為3mm，以上即為正確之關係位置，即勾針在針中心位置往回時，差1.5mm。

When the needle moves down, and the looper moves backward from the front to the position B shown as Fig. 21, the distance from the looper to the upper point of the needle hole is 3 mm. That is the correct relationship position, which means the looper is 1.5 mm away from the needle central position.

調整時，將偏心凸輪A的固定螺絲B放鬆，前後調整即可調整其間之時位關係(圖22)。

While adjusting, loosen the fixed screw B of the eccentric A and move the eccentric A back and forth to adjust the time correlation position .(Fig. 22)

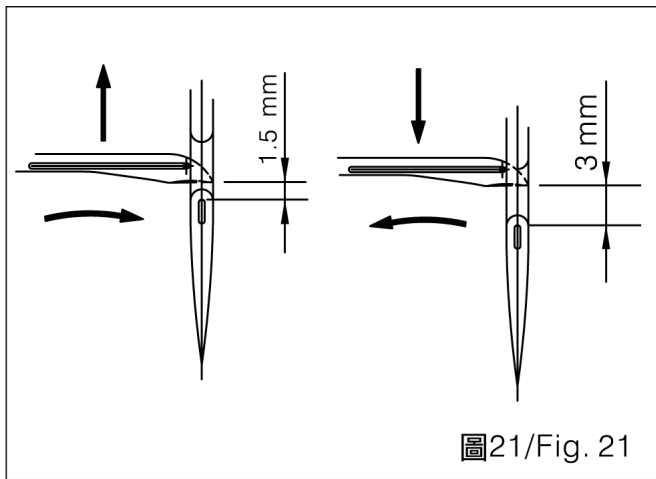


圖21/ Fig. 21

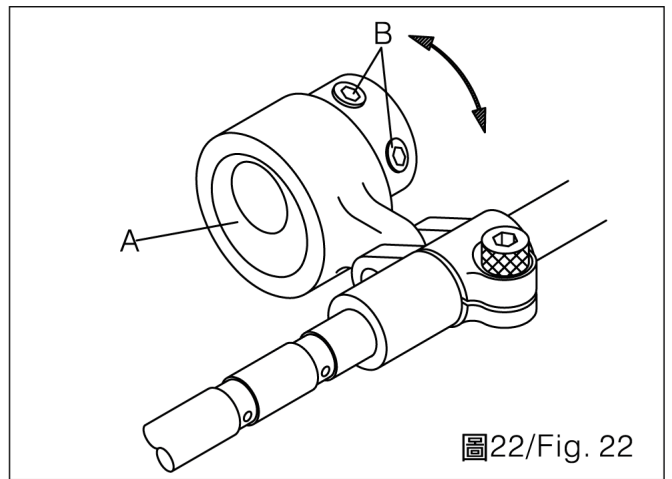


圖22/ Fig. 22

撥線桿之固定

FASTEN THE THREAD WIPER

撥線桿A與車針之間隙為0.2~0.4 mm。(圖23)

The distance between the thread wiper A and the needle is 0.2~0.4 mm. (Fig. 23)

當針棒於下方位置時，將撥線桿A固定螺絲B (圖24)放鬆調整至(圖23)所示之尺寸，並注意各桿之平行，再鎖緊。

When the needle locates at lower position, loosen the fixed screw B on the thread wiper A (Fig. 24), adjust the wiper to the size show as Fig. 23. Be careful of the parallel of each wiper, and then retighten the screw B.

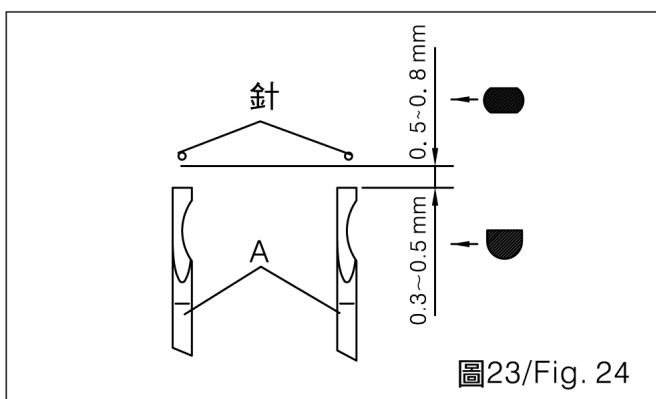


圖23/ Fig. 24

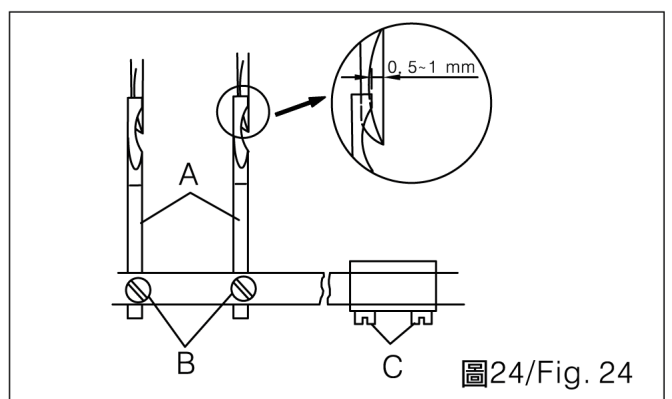


圖24/ Fig. 24

勾針與撥線桿之關係

THE RELATIONSHIP BETWEEN LOOPER AND THREAD WIPER

當撥線桿A於左死點位置時，撥線桿A右端與勾針右端二者之間隙為0.5~1 mm。(圖24)而勾針與撥線桿A之間隙為0~0.1 mm。(圖25)

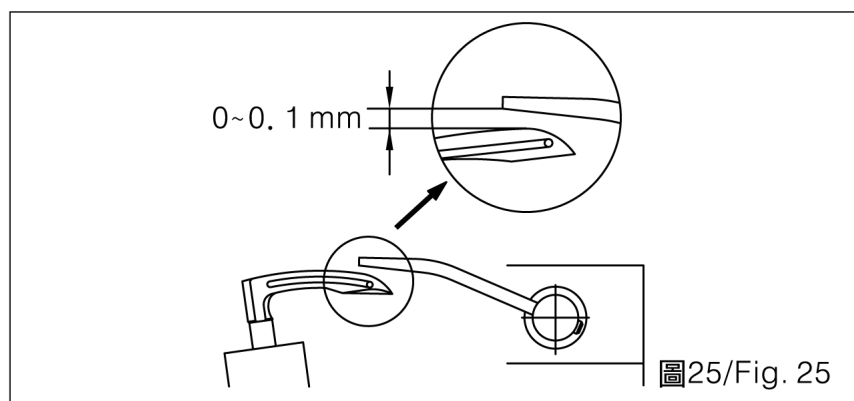
When the thread wiper A is at the left dead point, the distance from the right side of the thread wiper A to the right side of the looper is 0.5~1 mm (Fig. 24). As well as it is 0~0.1 mm from the looper to the thread wiper A. (Fig. 25)

調整時：

When adjusting:

1. 先放鬆再稍鎖緊撥線桿心軸固定螺絲C(圖24)
2. 旋轉皮帶輪使撥線桿心軸連桿移到左死點。
3. 調整使符合上述條件，再鎖緊螺絲C。

1. Loosen the fixed screw C of the thread wiper main shaft, and then retighten it a little. (Fig.24)
2. Turn the belt wheel to move the thread wiper main shaft connecting rod to the left dead point.
3. Adjust the device to match the conditions describing above and relock screw C.

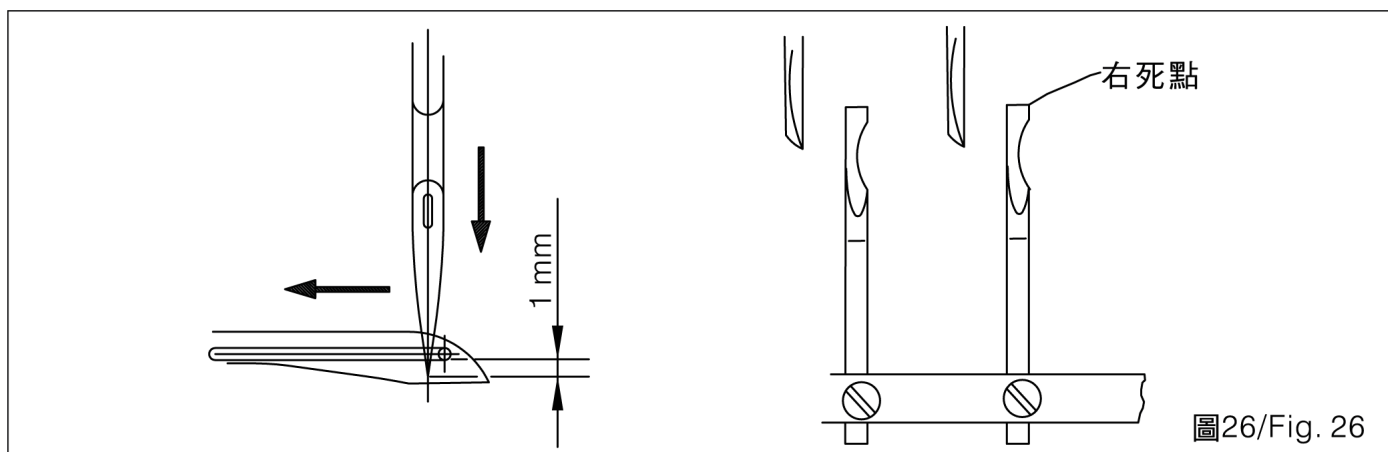


針、勾針與撥線桿之時位關係

TIMING POSITION AMONG NEEDLE LOOPER, AND THE THREAD WIPER

當針尖下降至勾針孔間隙約1mm，撥線桿A正好由右死點向左移。(圖26)

When the needle top moves down to be 1 mm lower than the looper hole, the thread wiper A will right move to the left from the right dead point. (Fig. 26)



勾針線控線桿之調整

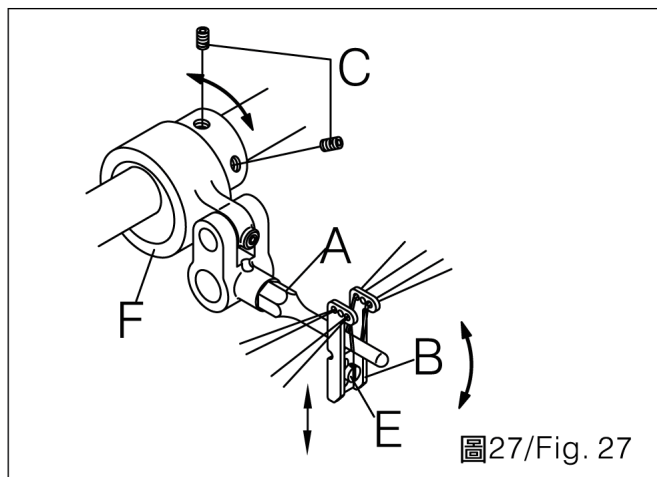
當針棒由上死點下降至車針位於勾針背面的中心位置時，勾針線控線桿A也正好由下死點往上抬起。(圖27)

調整時：

1. 放鬆偏心凸輪F固定螺絲C前後調整至正確方位，再鎖緊螺絲C，往前轉變快，往後轉變慢。
2. 微調整時，放鬆螺絲E，將線導片B上下移動調整再鎖緊螺絲E。

線的出線量因所使用的線而異，其出線量為：

棉線，SP線：7~15 mm (D) (圖28)
伸縮尼龍線：10~15 mm (D) (圖28)



ADJUST THE LOOPER THREAD CONTROL ROD

When the needle bar goes down from the upper dead point and the needle locates at the central of the looper rear side, the looper thread control rod A just happens to move upward from the lower dead point. (Fig. 27)

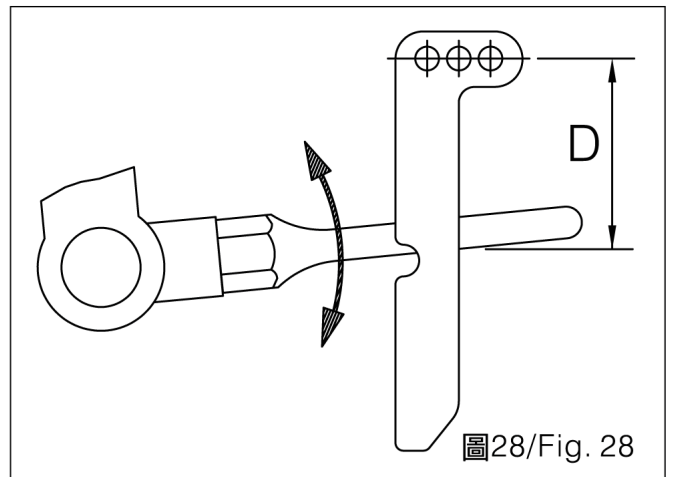
Adjusting:

1. Loosen the fixed screw C of the eccentric F, and adjust it back and forth to the right position. Then, retighten the screw C. Turn the screw forward, the eccentric will be faster, whereas turn it backward, the eccentric will be slower.
2. For doing micro-adjustment, loosen screw E, and move the thread guide B up and down to adjust. Then retighten the screw E.

The threading amount will be different because of the thread used.

The amount is:

Cotton, SP thread: 7~10 mm (D)(Fig. 28)
Elastic Nylon thread: 10~15 mm (D) (Fig.28)



送具調整

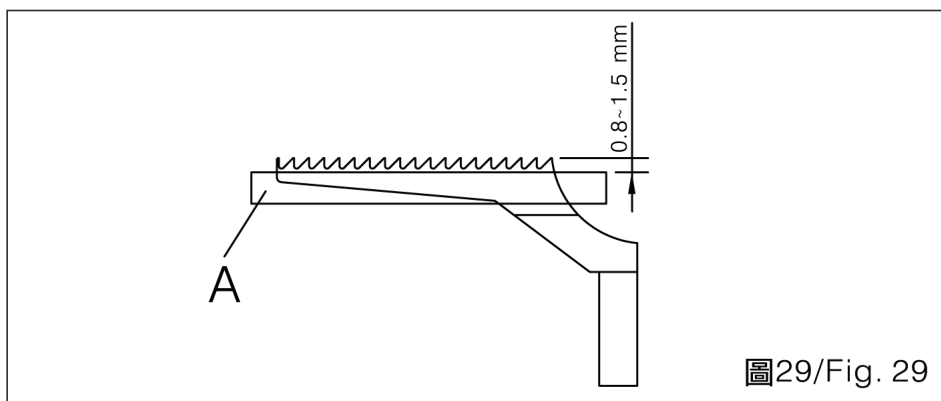
高度調整(圖29)

送具C升至最高點時，送具齒間面與針板面之距離為0.8~1.5 mm，平均為1.2 mm。

ADJUST THE FEED DOG

Adjust the height (Fig. 29)

When the feed dog C moves to the upper dead point, the distance from the top of the teeth plate to the surface of the needle plate is 0.8~1.5 mm, as well as the average value is 1.2 mm.

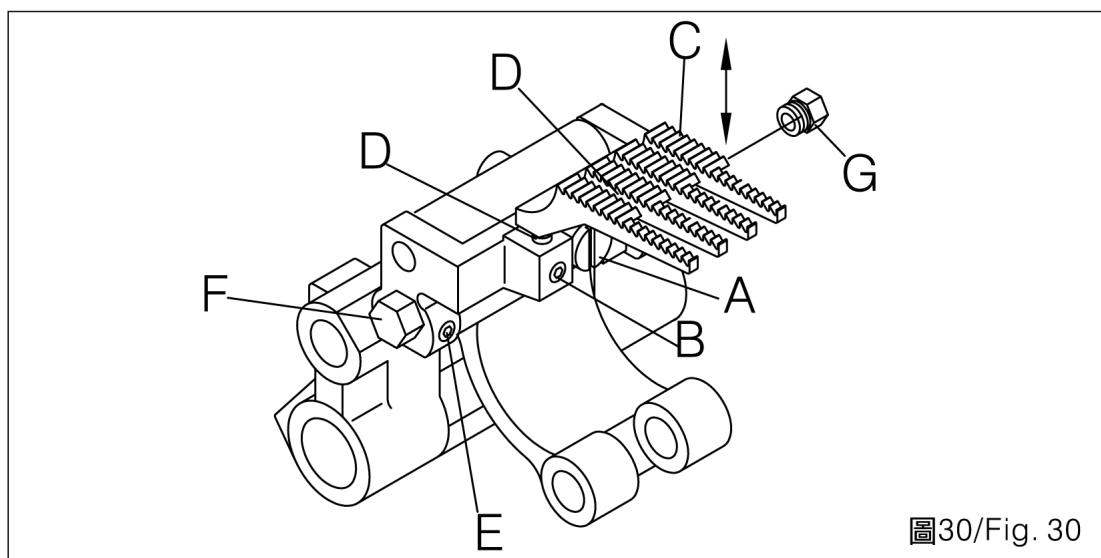


調整時參照(圖30)

1. 放鬆送具C固定螺絲A。
2. 上下移動送具C使符合上述條件時，再鎖緊螺絲A。
3. 將高度固定銷D之固定螺絲B放鬆，調整固定銷至頂，直至送具C底部再鎖緊螺絲B。
4. 此時亦應確認送具C左右方向的平行。

When doing adjustment, please refer to Fig. 30

1. Loosen the fixed screw A of the feed dog C.
2. Move the feed dog C up and down to match the condition mentioned above, and then tighten the screw A.
3. Loosen the fixed screw B of the height fixed pin D, and move the fixed pin to top. Lock the screw B after the pin D reach the bottom of the feed dog C.
4. At this moment, please confirm the parallel between the left and the right side of the feed dog C.



送具平行調整

ADJUST THE FEED DOG'S PARALLEL

送具上升至上死點時應與針板平行(圖29)

When the feed dog moves to the upper dead point, it should parallel the needle plate. (Fig. 29)

調整時：

固定螺栓F，將螺帽G放鬆，調整送料具螺絲E，使送料具C與針板面平行，再鎖緊螺帽G。(圖30)

For adjustments: (Fig. 30)

Fasten the bolt F, and loosen the screw nut G. Then, adjust the screw E of the feed dog, so that the feed dog C can parallel the need plate. Tighten screw nut G after that.

縫目之調整

壓下按鈕A，並轉動皮帶輪，使按鈕卡住針具距調整組，再轉動皮帶輪至所需之縫目後，放開此按鈕(圖31)

欲調長縫目時，將皮帶輪往順時針方向旋轉，反之則小。

調整縫目時，馬達須在停止狀態。

ADJUST THE STITCH

Press the button A, and roll the belt wheel to make the button lock the needle distance adjustment set. After rotate the belt wheel to the desired stitch, release the button A. (Fig. 31)

For longer stitch, rotate the belt wheel clockwise. Turn the wheel counter clockwise to have shorter stitch thereagainst. The motor must stay at dormant status while adjusting the stitch.

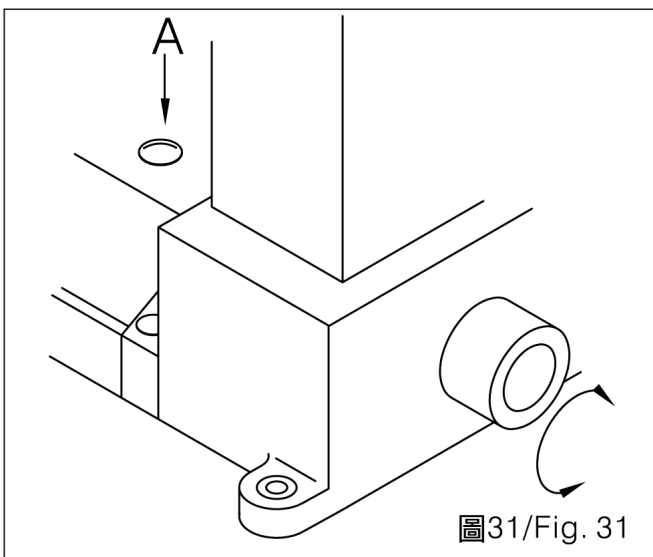


圖31/ Fig. 31

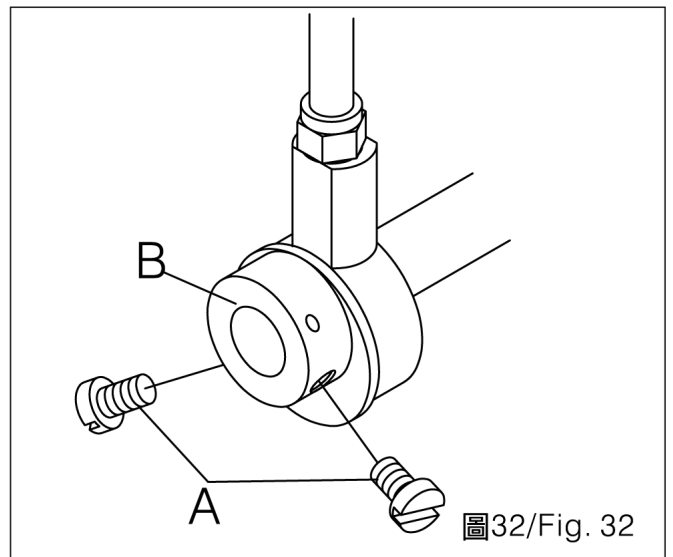


圖32/ Fig. 32

後控引輪調整

與針棒時位關係(圖32)

當針棒由下死點往上移24mm時，後拉引輪開始轉動，即為正確之時位關係。

調整時：

1. 放鬆偏心凸輪B之固定螺絲A後，再稍鎖緊。

ADJUST THE REAR CONTROL GUIDING WHEEL

The correlation with the needle bar (Fig. 32)
When the needle bar moves up from the lower dead point about 24 mm, the rear control guiding wheel starts rotating, and this is the correct timing correlation position.

When adjusting:

1. Loosen the fixed screw A on the eccentric B a little, and then retighten a little.

2. 旋轉皮帶輪至上述條件後，再鎖緊螺絲A，往前轉時間變快，往後轉則變慢。

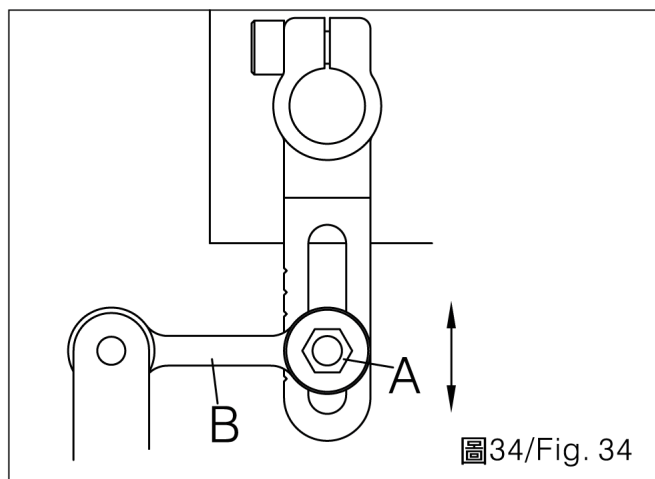
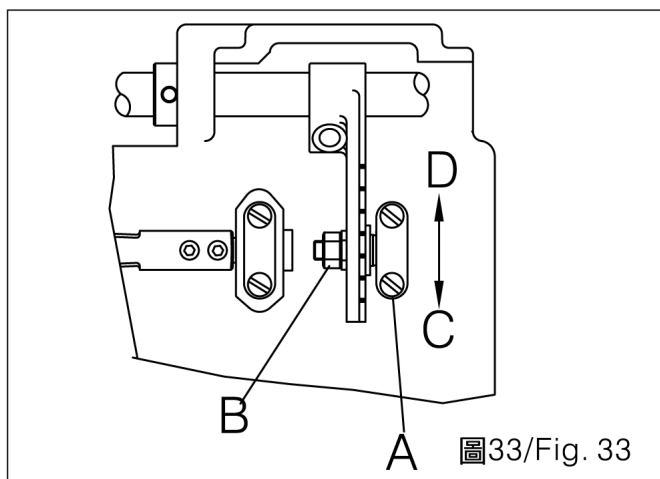
2. Rotate the belt wheel to be as the conditions mentioned above, and then lock screw A. Turning it forward will shorten the moving time, whereas turning it backward will extend the moving time.

後拉滾輪供給量之調整

ADJUST THE SUPPLEMENT OF THE REAR PULL WHEEL

1. 取下上蓋。
2. 放鬆連桿A上之螺帽B。(圖33)
3. 將連桿A前後移動，往前移(C方向)則供給量少，往後移(D方向)則供給量大。
4. 供給量依縫紉情形適當調整。
5. 微量調整時，放鬆螺帽A將連桿B上下移動，往上量少，往下量多。(圖34)

1. Take off the upper cover.
2. Loosen the screw B on the connecting rod A. (Fig. 33)
3. Move the connecting rod A back and forth. Move forward means less supplements, and move backward means more supplements.
4. Adjust the supplements appropriately based on the sewing conditions.
5. When doing micro-adjustment, loosen screw A and move the connecting rod up and down to adjust. Move upward means more supplements, and move downward means less supplements. (Fig. 34)



上下滾輪間隙調整

ADJUST THE DISTANCE BETWEEN UPPER AND LOWER GEAR

將上滾輪放至最低點，上滾輪與下滾輪之齒間隙為0.5 mm，且兩滾輪平行。(圖35)

Place the upper gear down to the lower dead point. The distance between the teeth of the upper and lower gear is 0.5mm, as well as they are parallel. (Fig. 35)

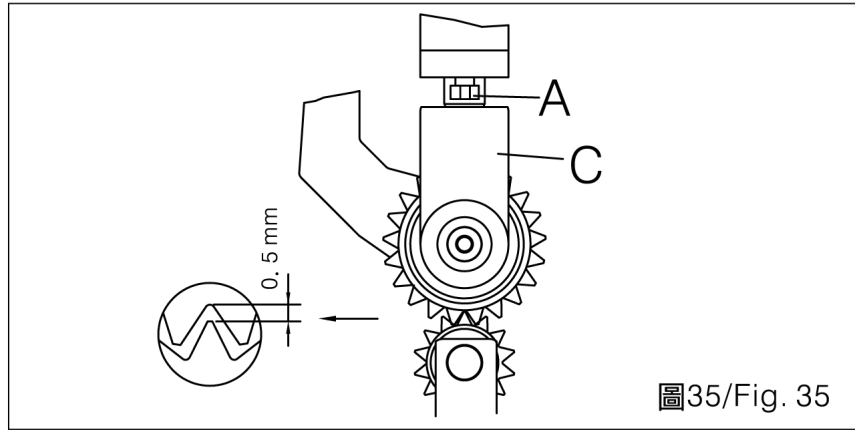


圖35/Fig. 35

調整時：

1. 兩滾輪平行之調整(圖35)

將螺絲A放鬆，調整兩滾輪平行後，稍鎖緊螺絲A，上下移動固定座C，使上下滑動順暢，再鎖緊螺絲A。

2. 間隙0.5 mm之調整(圖36)

如圖36所示，將螺帽D及螺絲H放鬆，調整螺絲H，使上下滾輪之間隙為0.5 mm再鎖緊螺帽D，稍放鬆螺絲K並調整連桿J，使螺絲L與連桿J之長圓孔下方間隙為0.5 mm，再鎖緊螺絲K。

When adjusting:

1. Adjust the parallel condition of the two gears. (Fig. 35)

Loosen screw A to parallel the 2 gears, and then tighten the screw A a little. Move the fixed seat C up and down to make sure the movement is smooth, and retighten the screw A tightly.

2. Adjust the distance of 0.5 mm. (Fig. 36)

As shown in Fig. 36, loosen the screw nut D and screw nut H to adjust screw H to make the distance between upper and lower gear is 0.5 mm. Then, tighten the screw D. Loosen screw K a little, and adjust the connecting rod J to keep a distance of 0.5 mm from the screw L to the bottom of the long round hole of the connecting rod J. Then, retighten screw K.

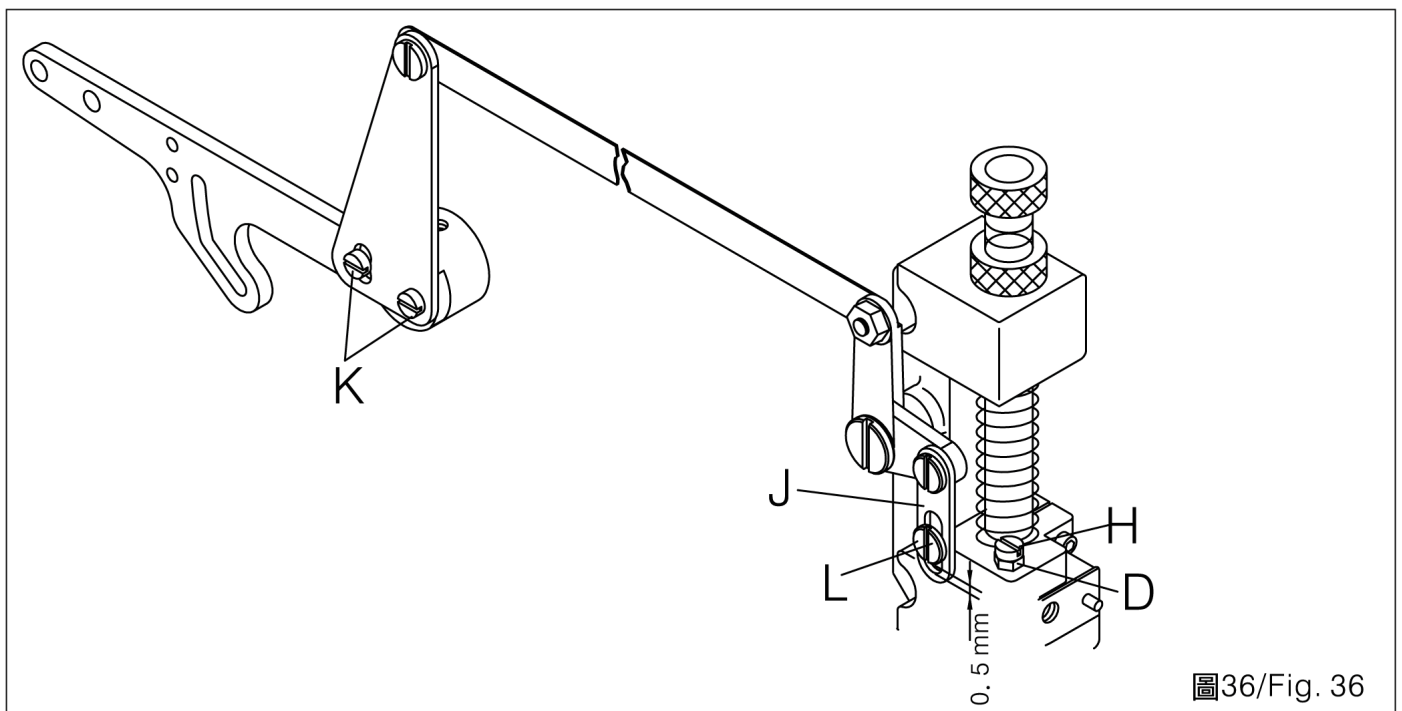


圖36/Fig. 36

3. 上滾輪壓力之調整(圖37)
 將壓力調整螺絲A往順時針方向轉動，則
 壓力加大，反之則減小。

3. Adjust the pressure of the upper gear.
 (Fig. 37)
 Rotate the pressure adjustment screw A
 clockwise, and the pressure will increase.
 Otherwise, the pressure will decrease.

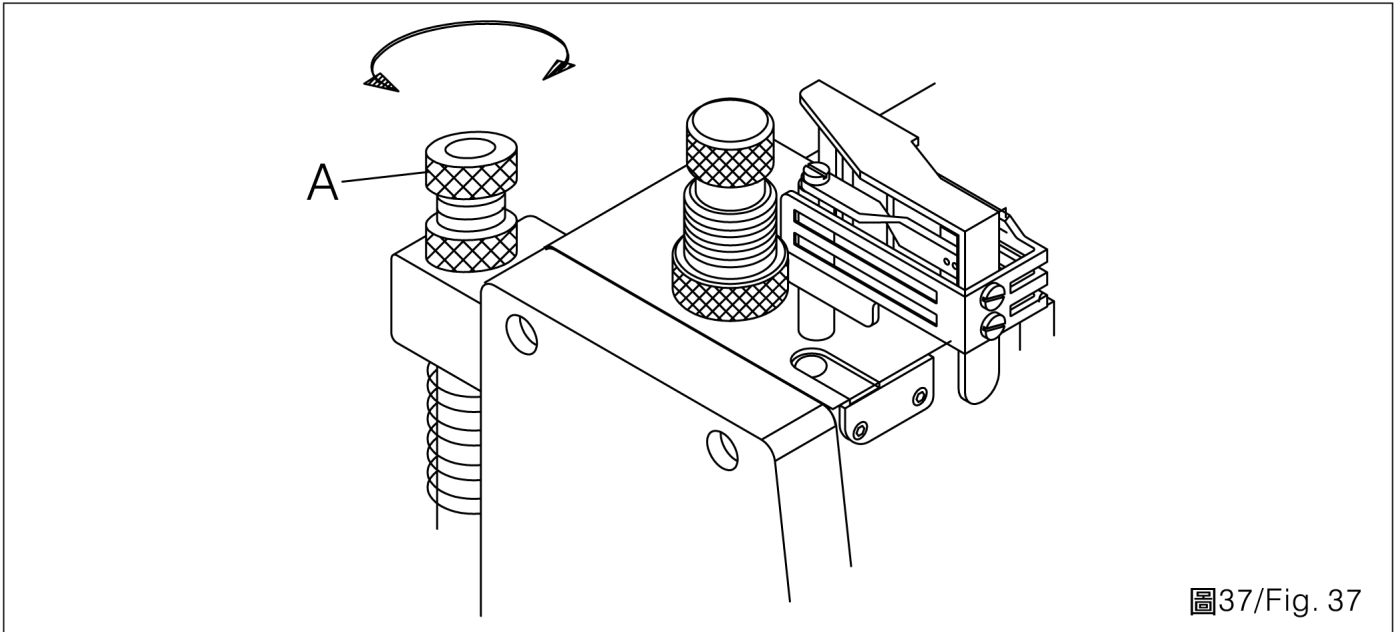


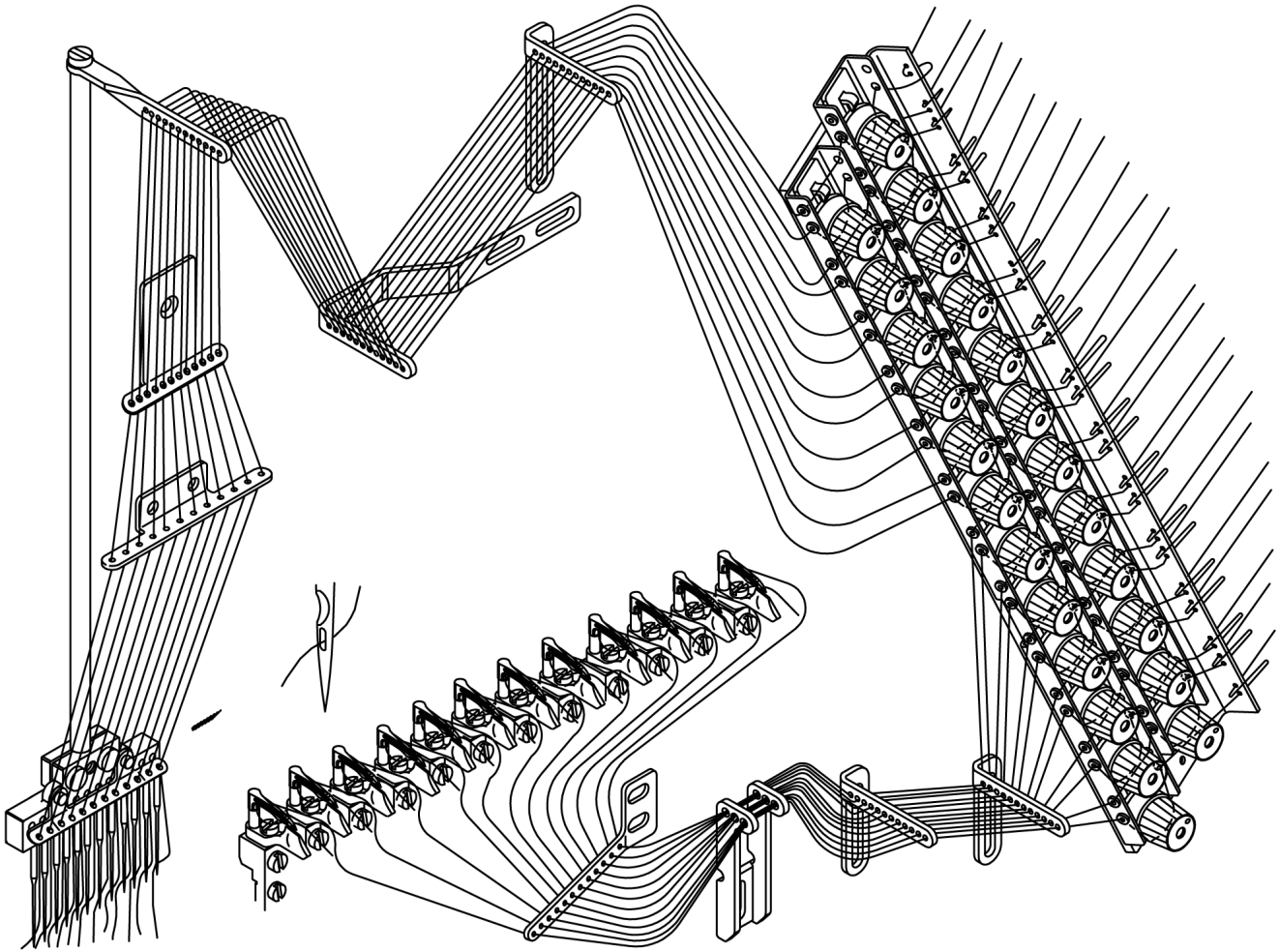
圖37/Fig. 37

4. 上下滾輪之使用請參照表6

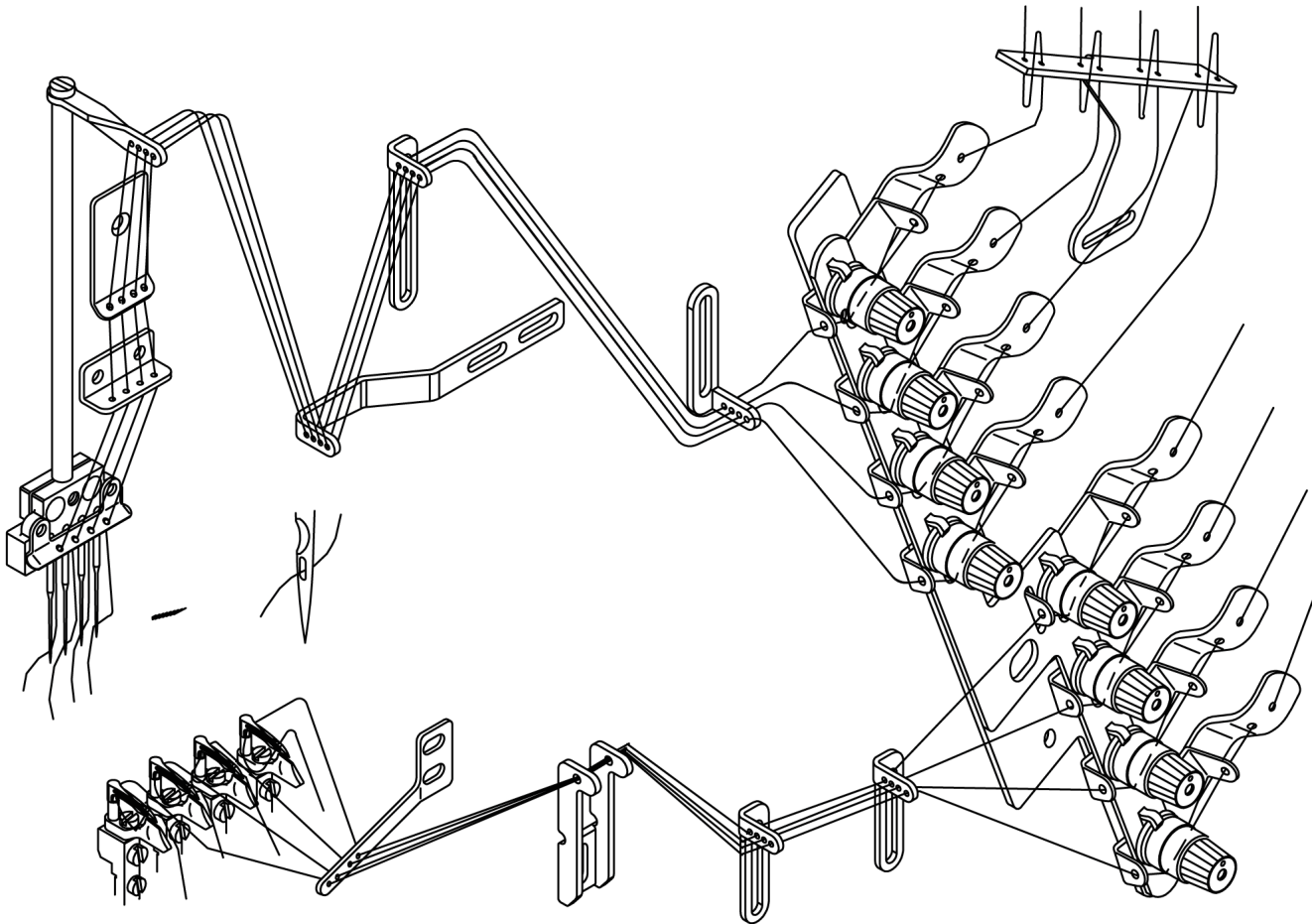
4. For the use of the upper and lower gear,
 please refer Table 6.

布料 Fabric	使用齒輪 Gear	上輪 Upper gear	下輪 Lower gear
平織布料 Woven fabric		平輪 Flat wheel	平輪 Flat gear
薄布料 Thin fabric		27 齒 27 teeth	16 齒 16 teeth
厚布料 Thick fabric		22 齒 22 teeth	14 齒 14 teeth

表6/Table 6



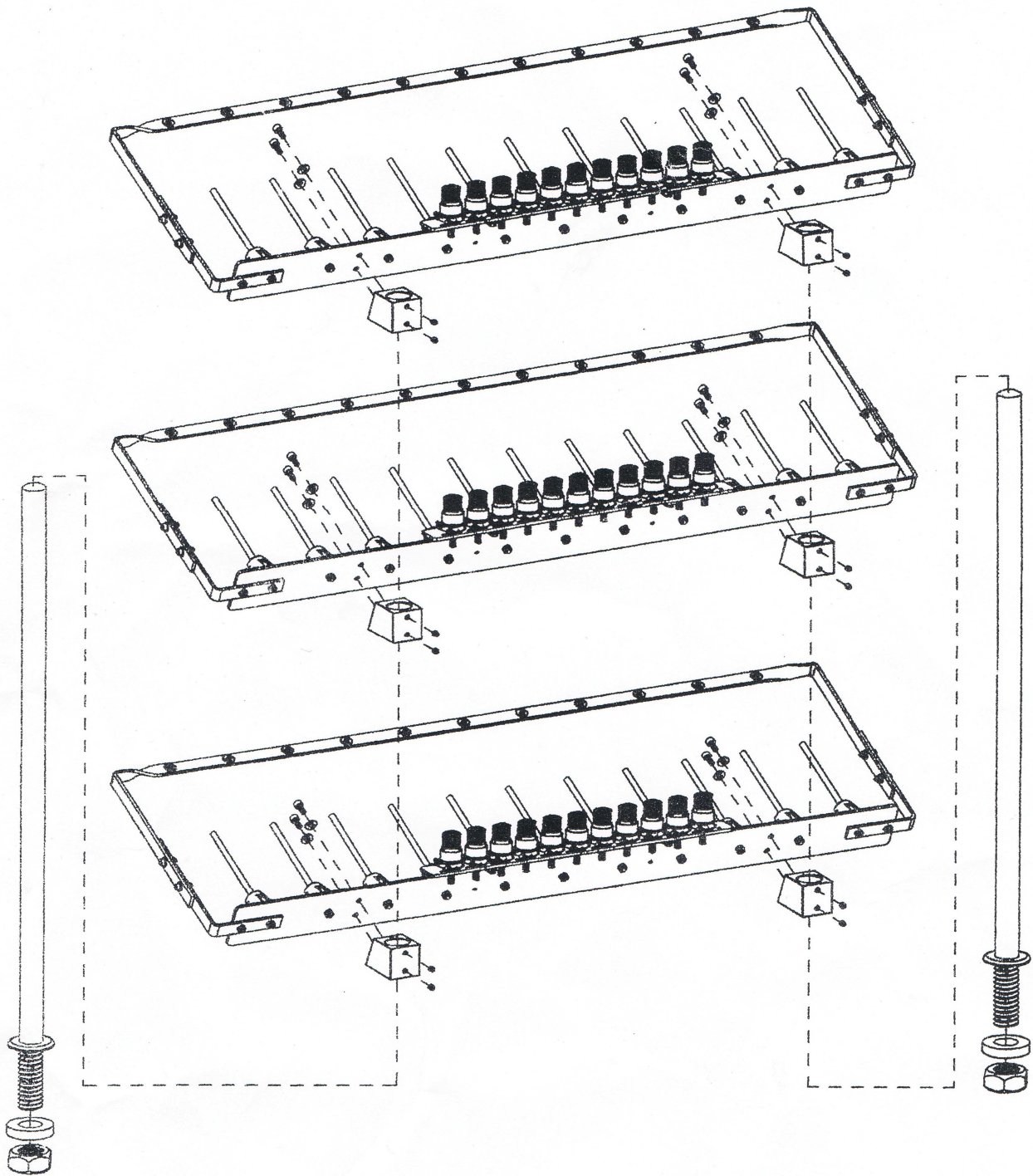
十二針穿線圖
THREADING DIAGRAM FOR 12 NEEDLES



四針穿線圖
THREADING DIAGRAM FOR 4 NEEDLES

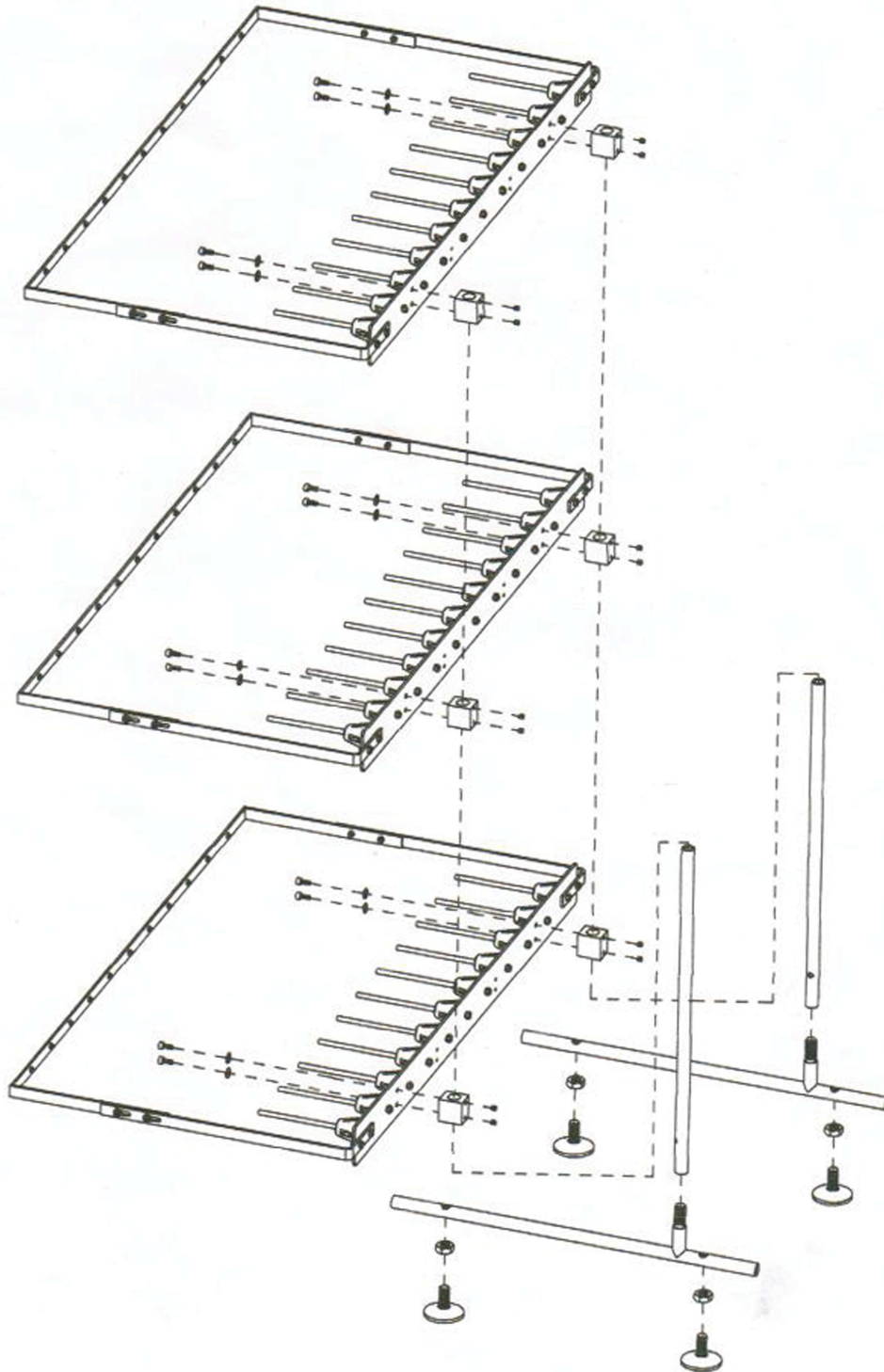
Table Top Thread Stand Assembly Guide

線裝配圖



Bottom Elastic Thread Stand Assembly Guide

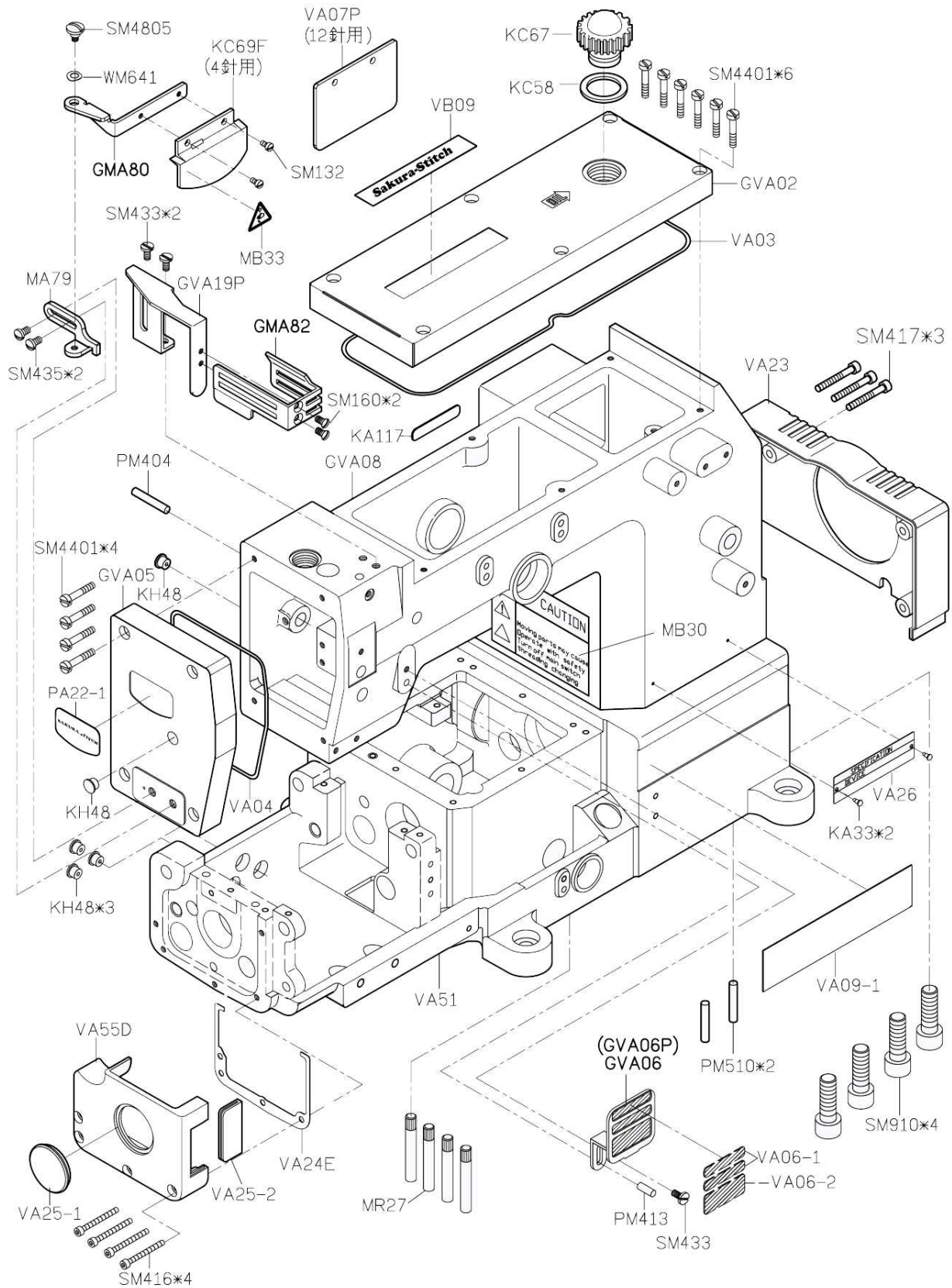
底線線架裝配圖



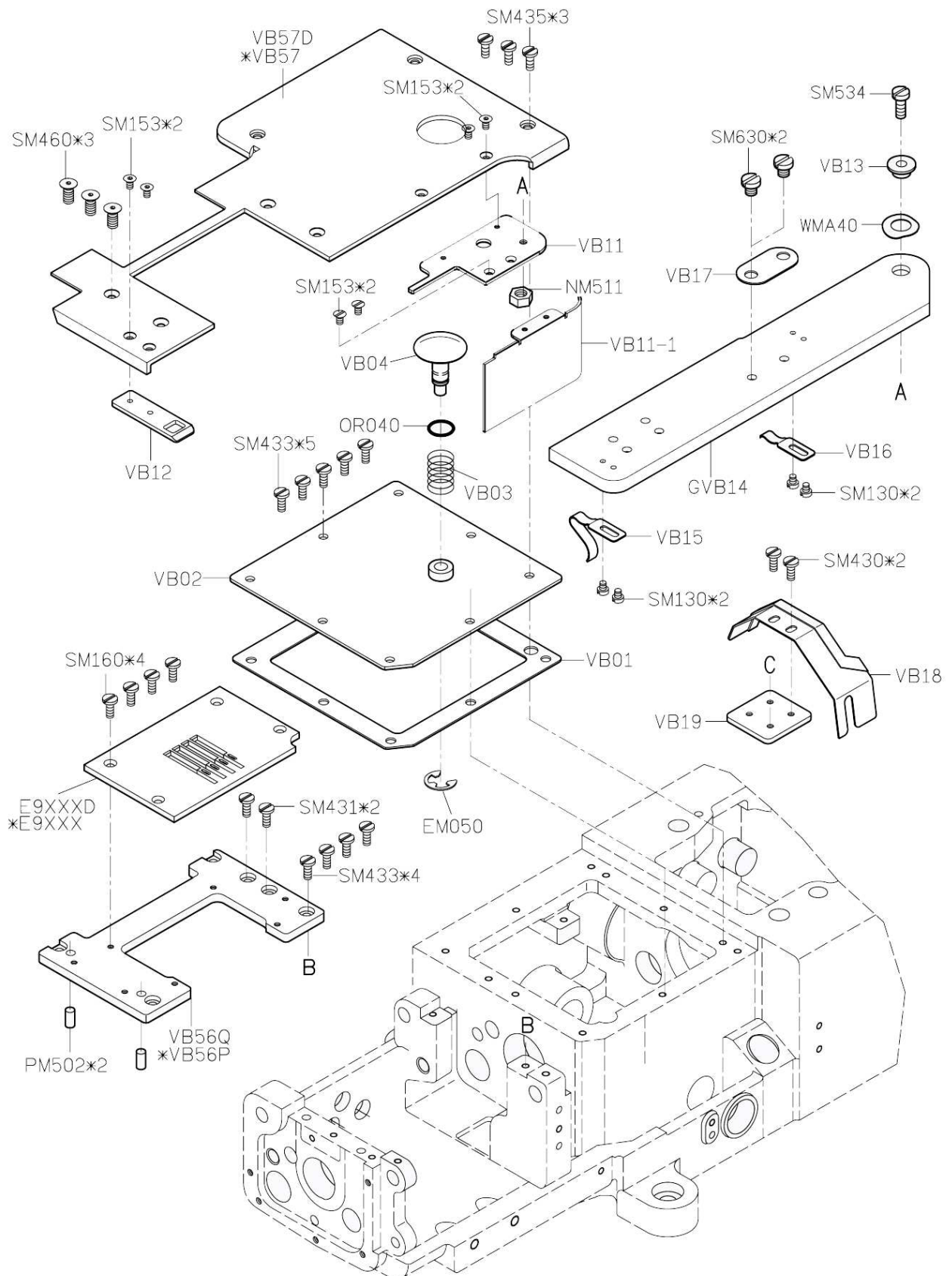
PART BOOK

零件圖

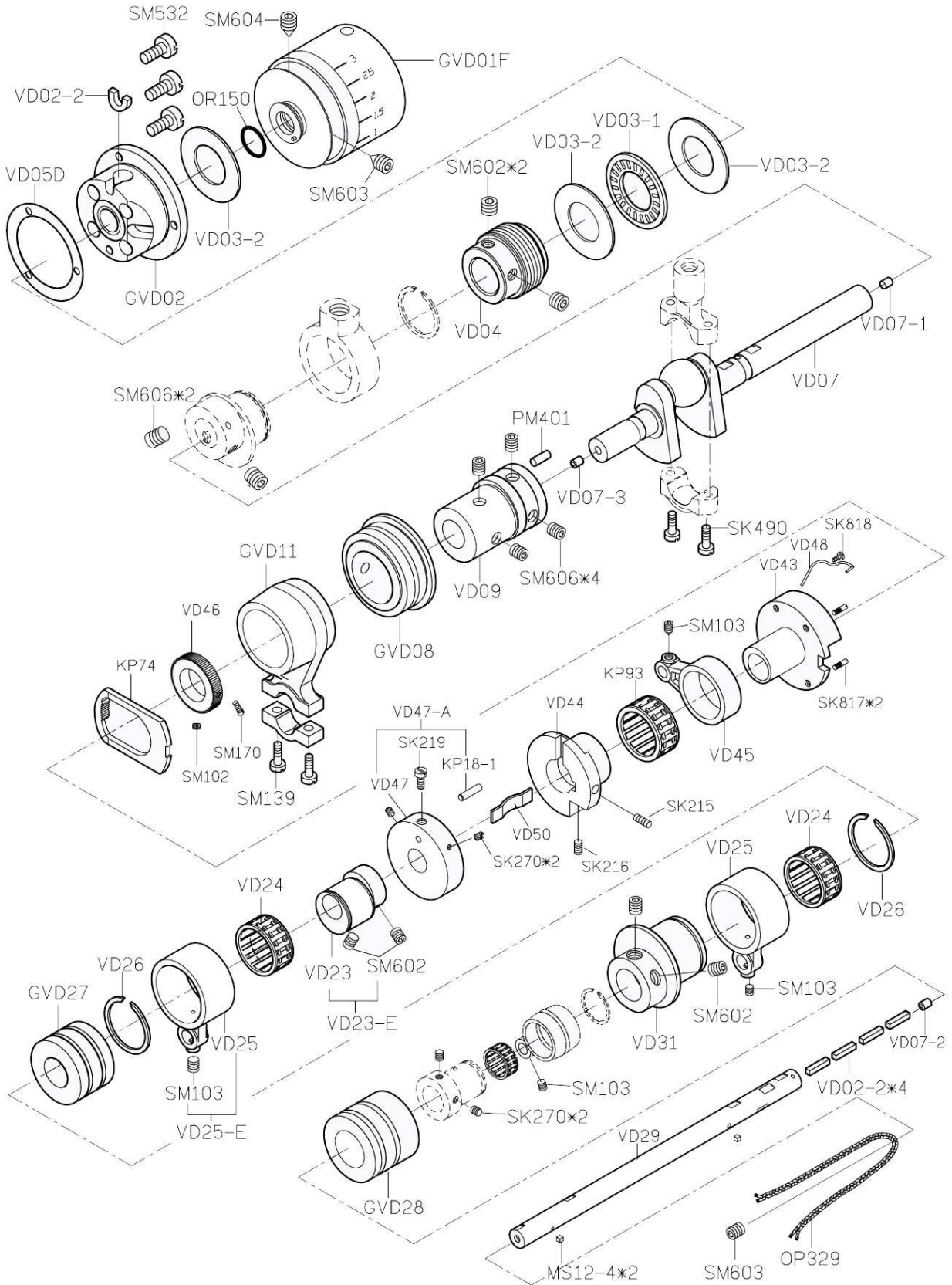
PARTS LIST FOR VA GROUP



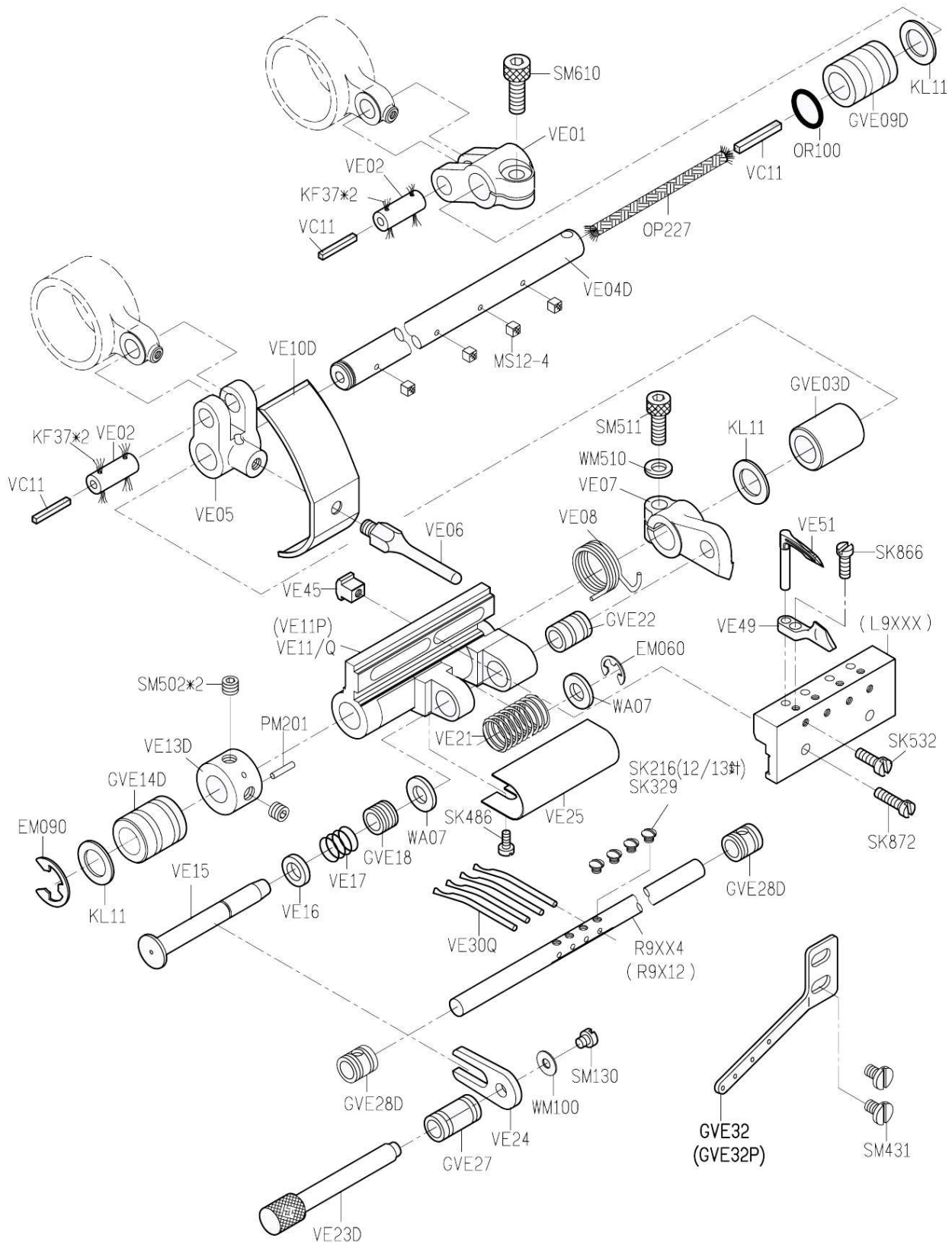
PARTS LIST FOR VB GROUP



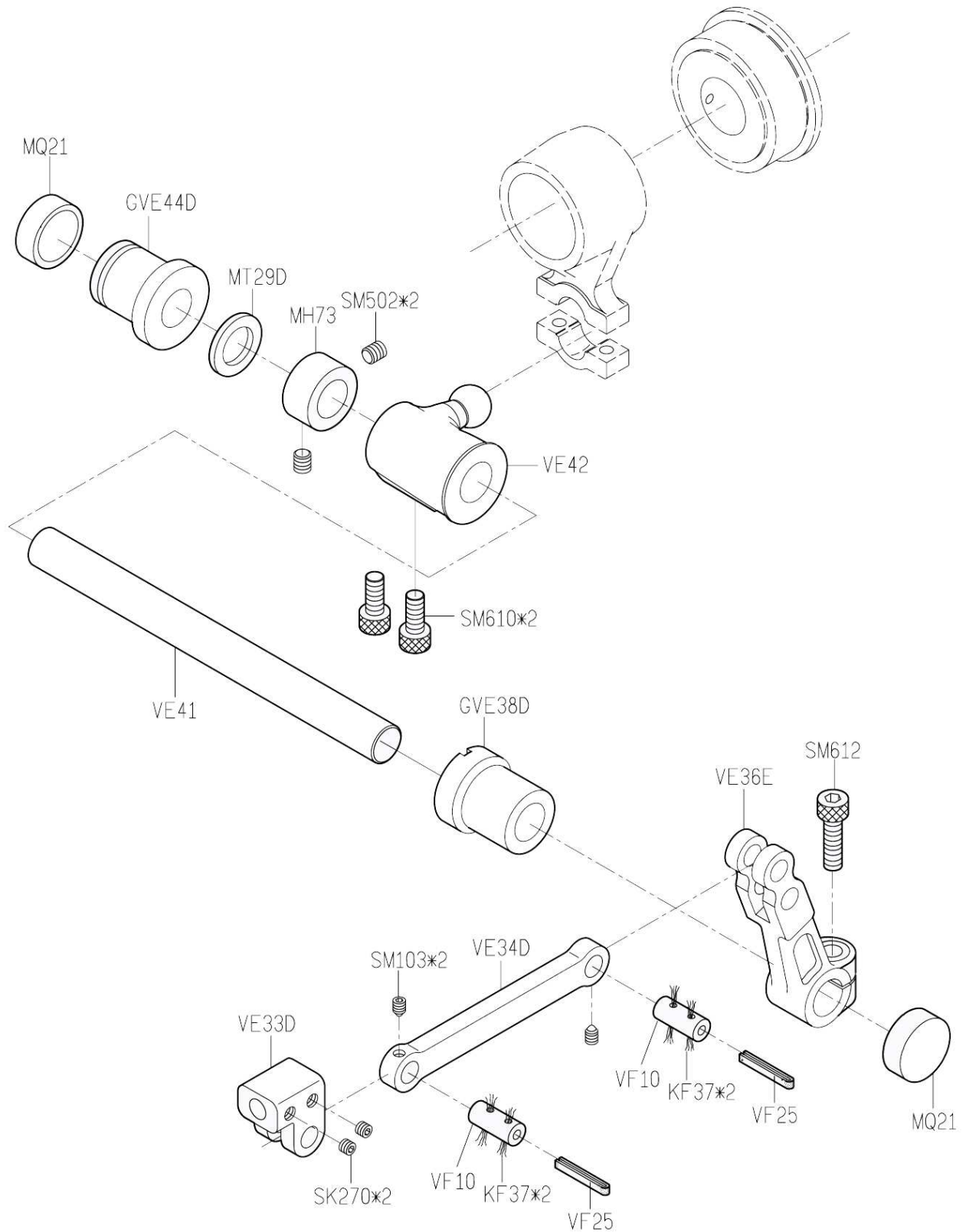
PARTS LIST FOR VD GROUP



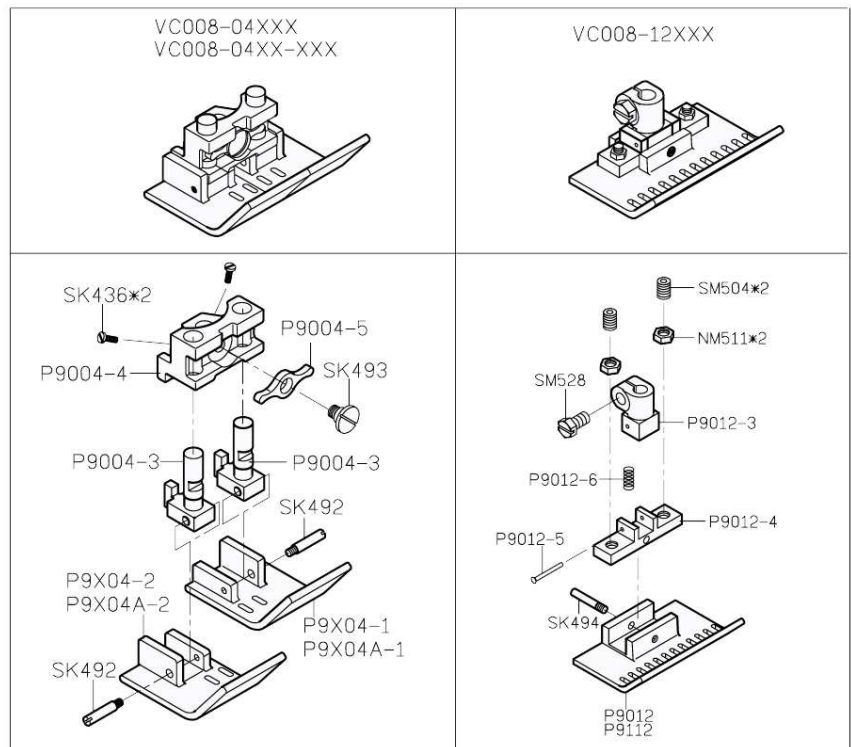
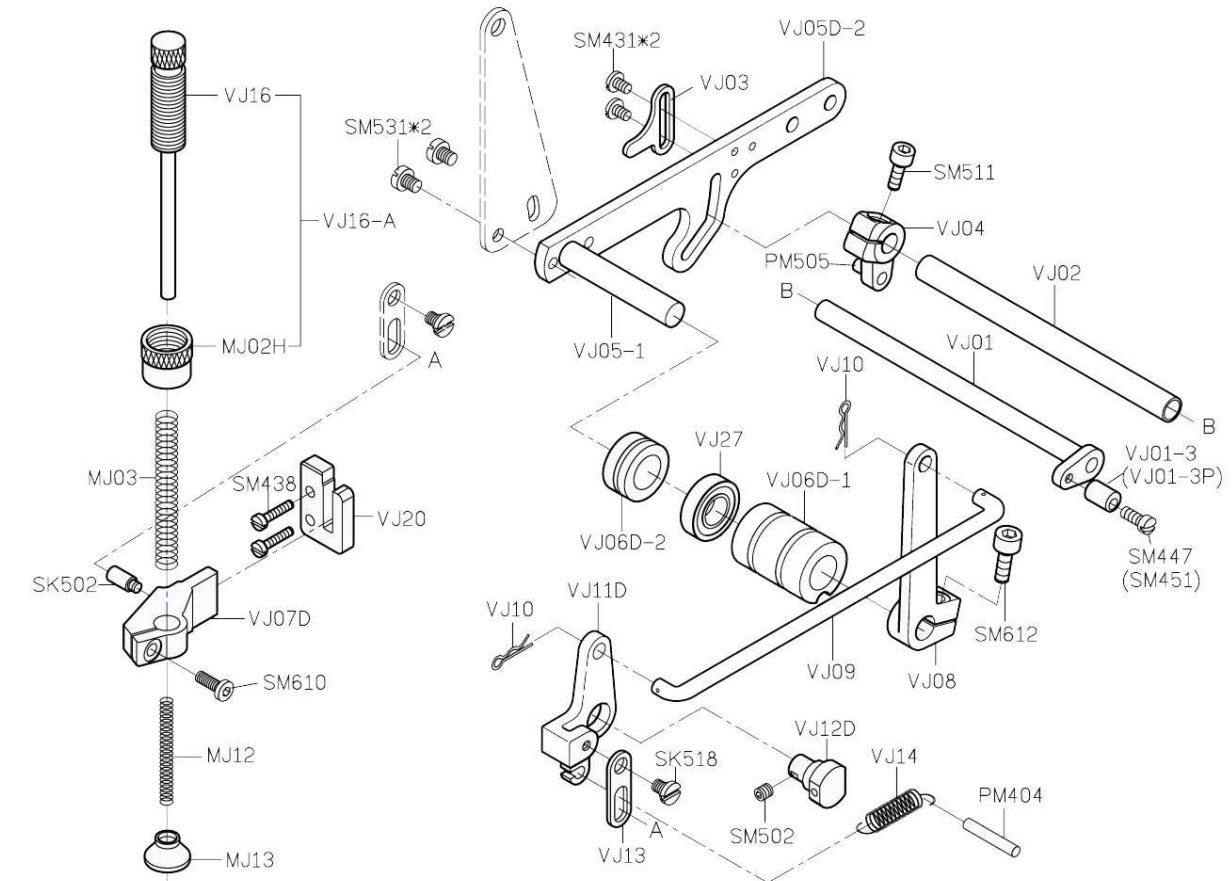
PARTS LIST FOR VE GROUP



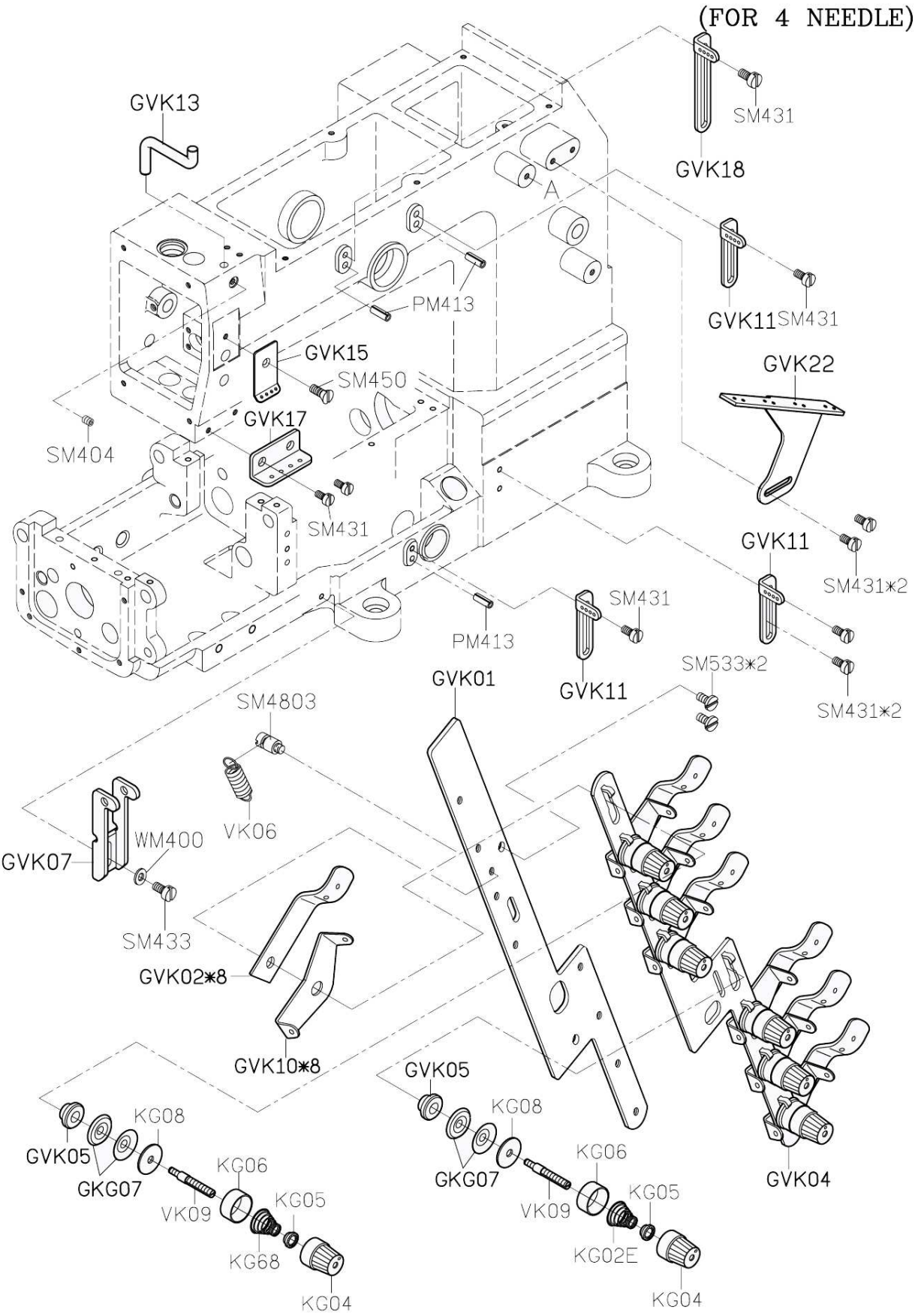
PARTS LIST FOR VE GROUP



PARTS LIST FOR VJ GROUP

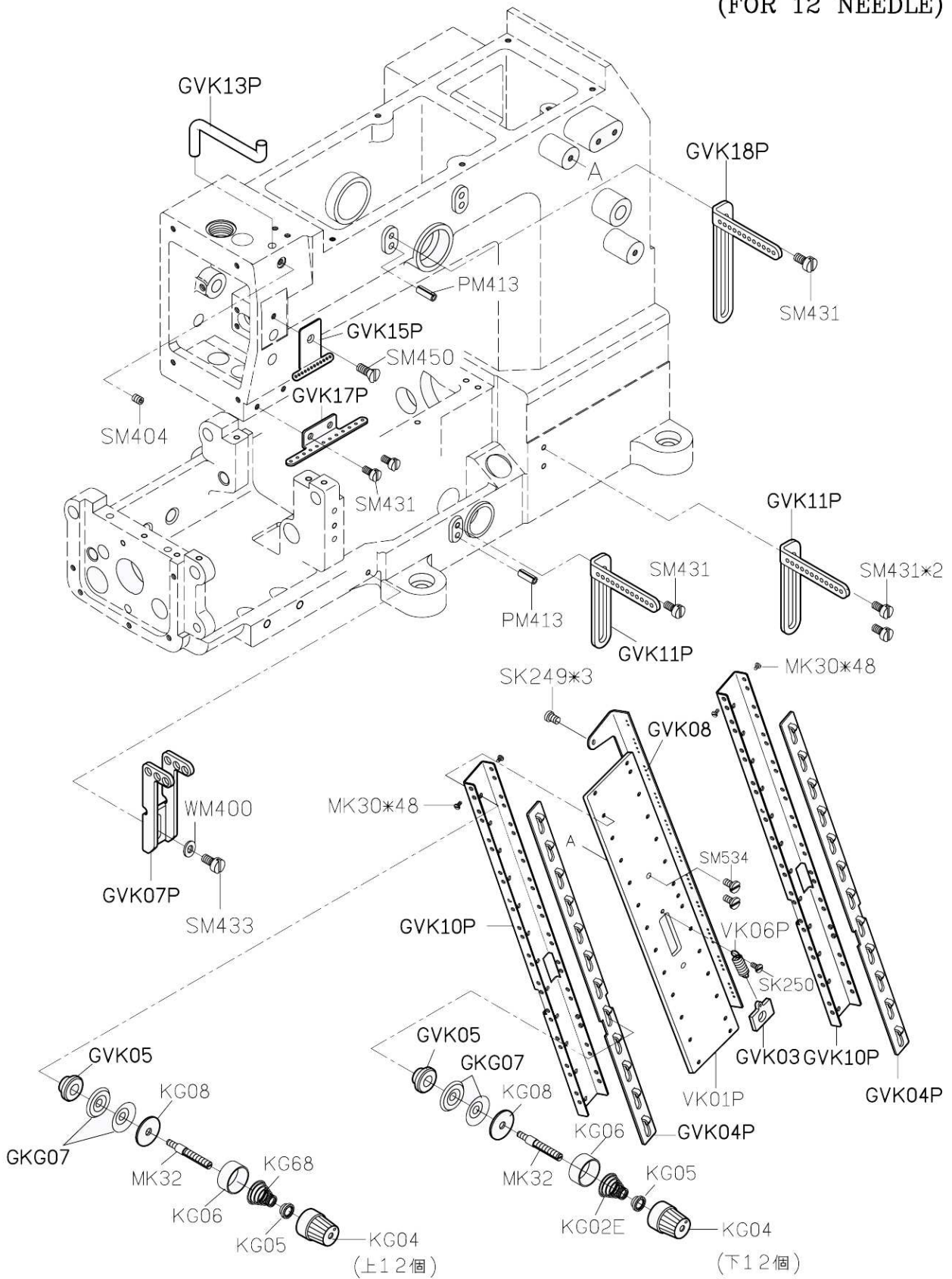


PARTS LIST FOR VK GROUP

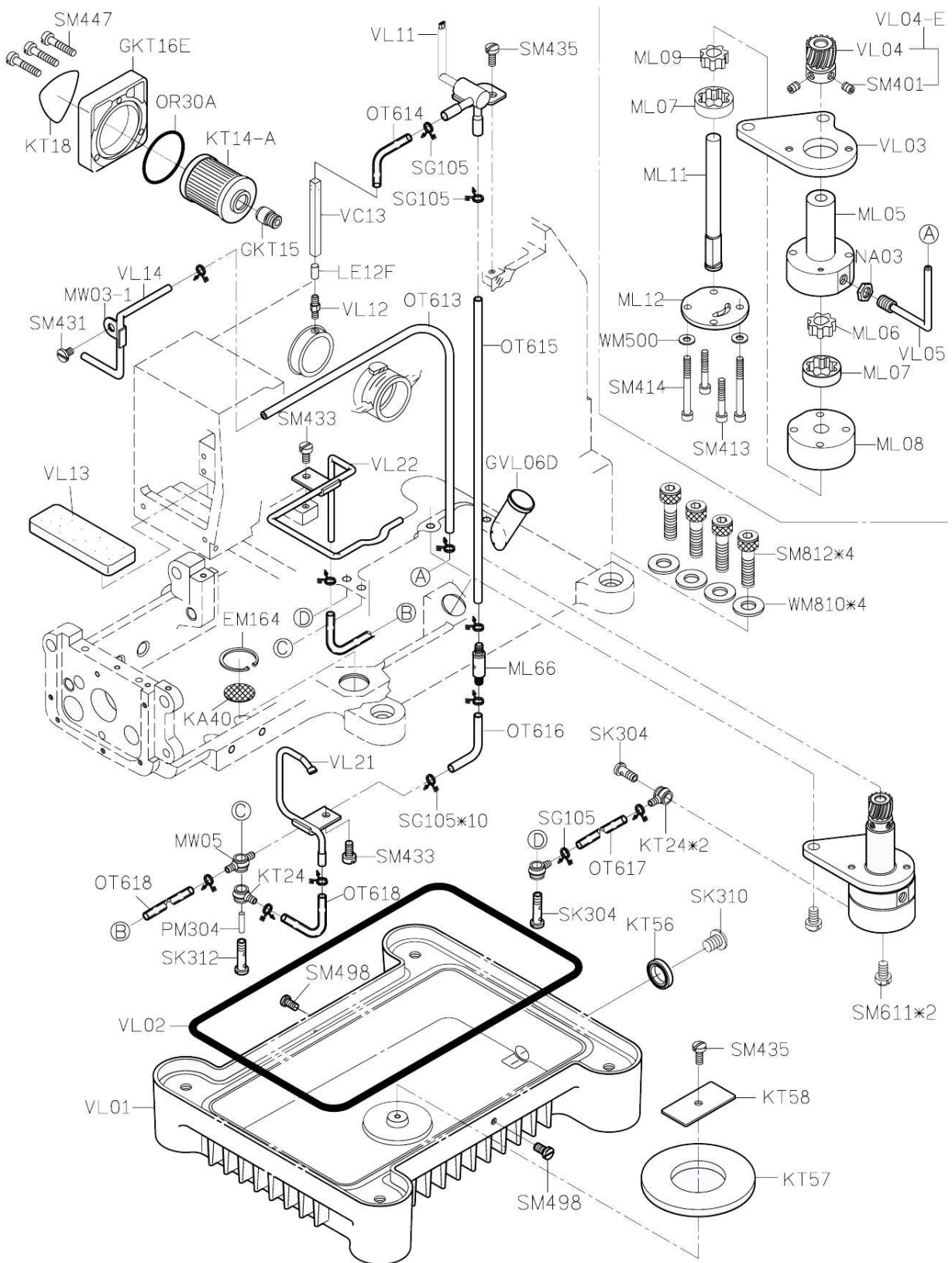


PARTS LIST FOR VK GROUP

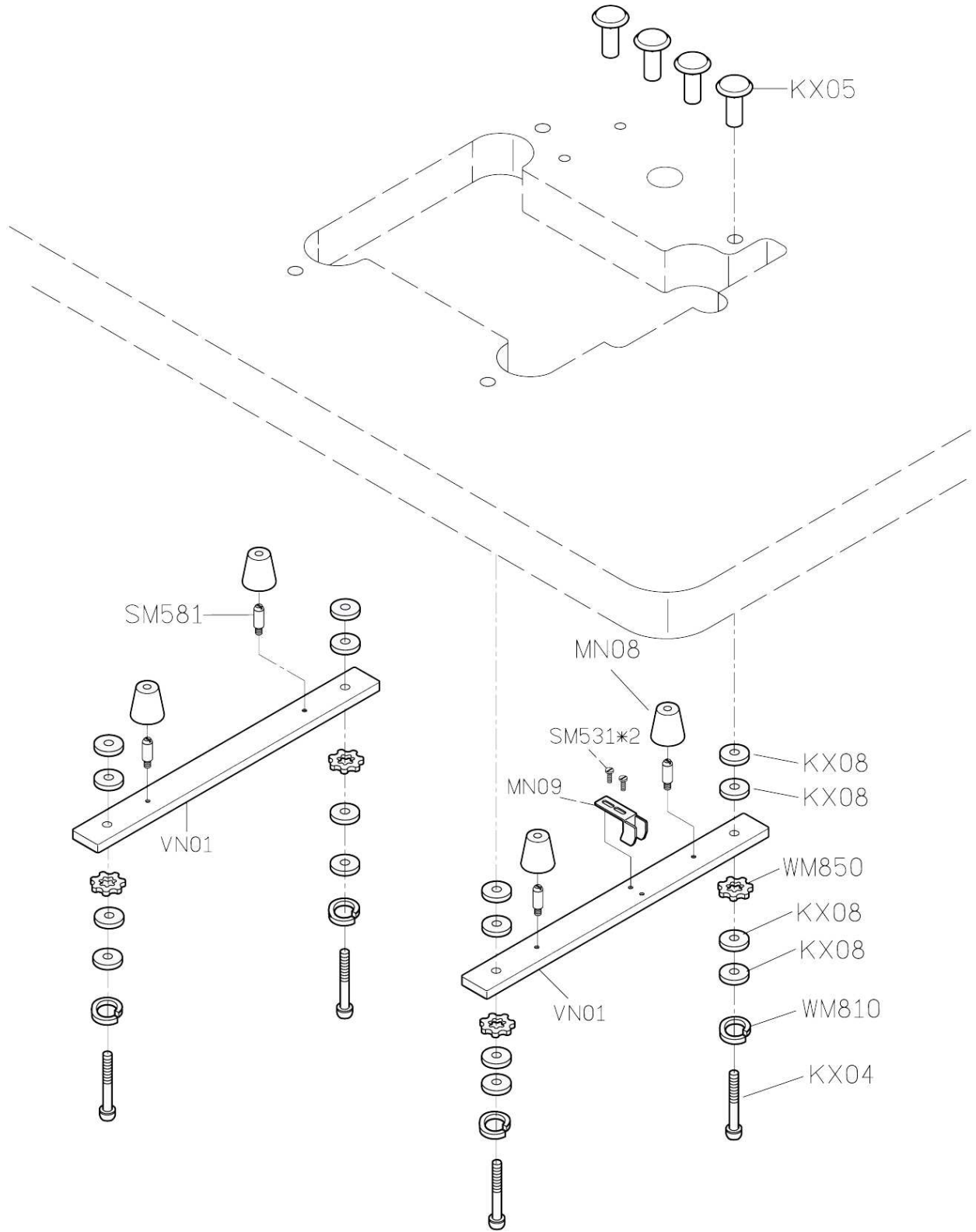
(FOR 12 NEEDLE)



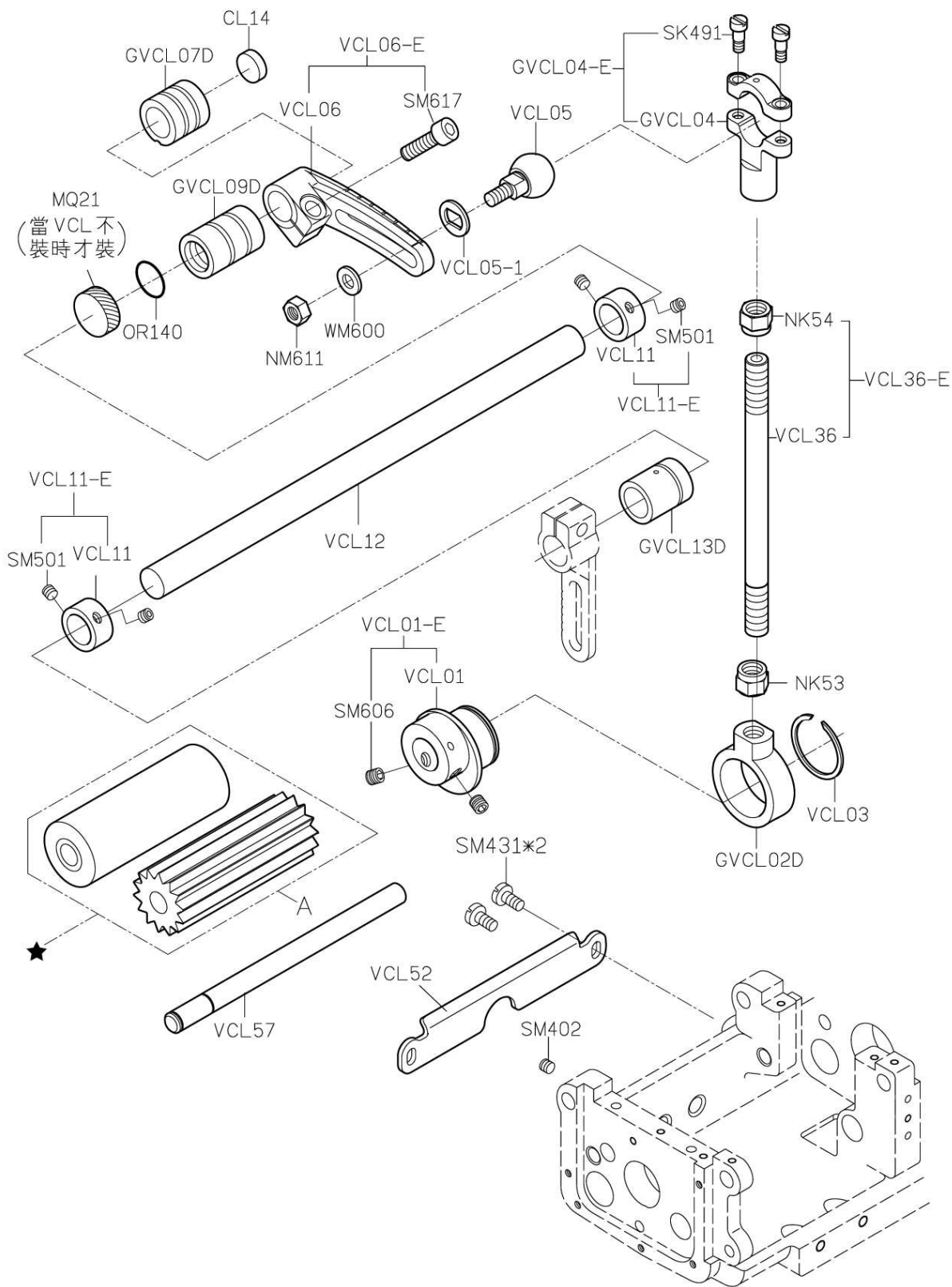
PARTS LIST FOR VL GROUP



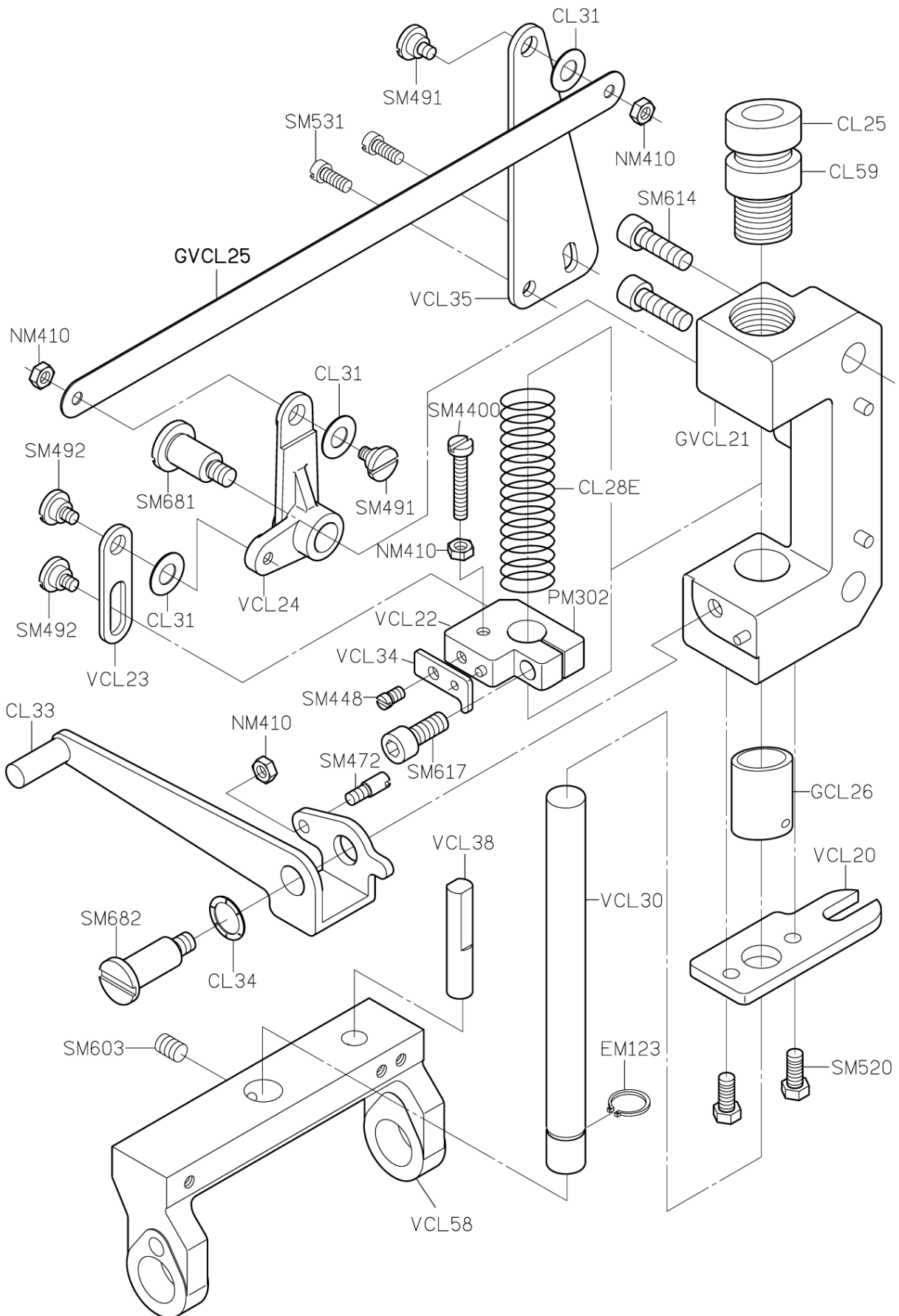
PARTS LIST FOR VN GROUP



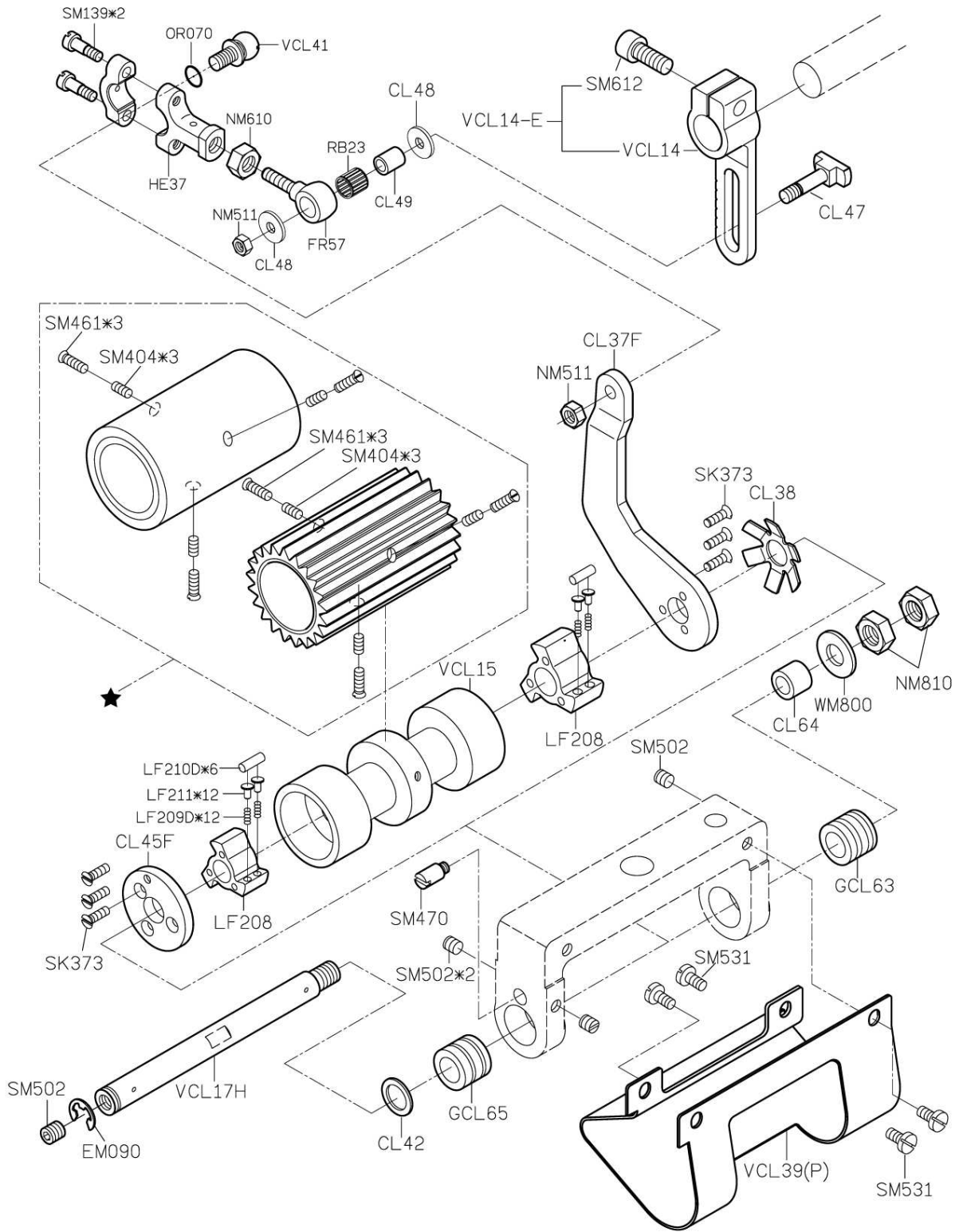
PARTS LIST FOR VCL GROUP



PARTS LIST FOR VCL GROUP



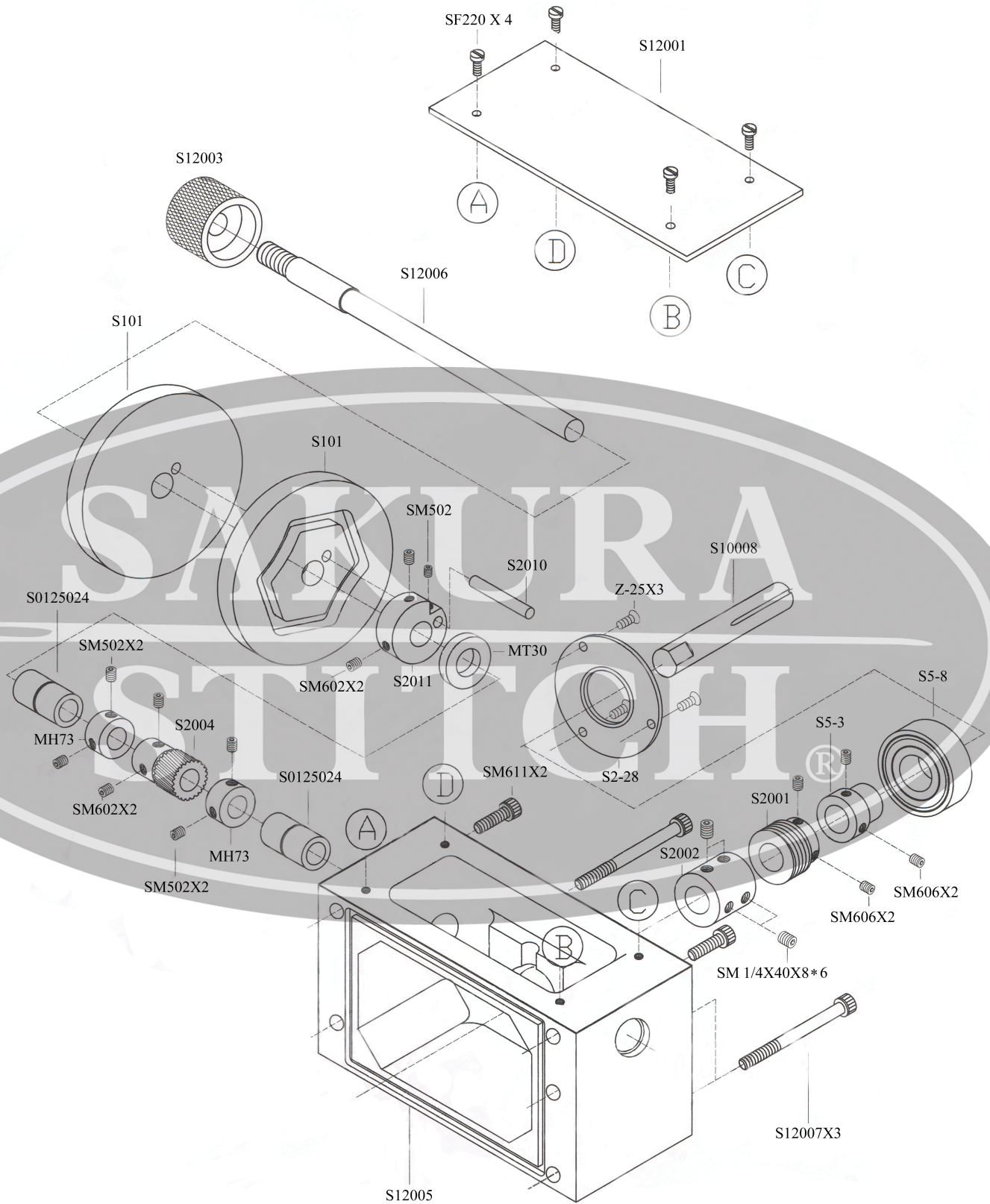
PARTS LIST FOR VCL GROUP



SMOCKING DEVICE SPARE PART
打攬裝置零件圖

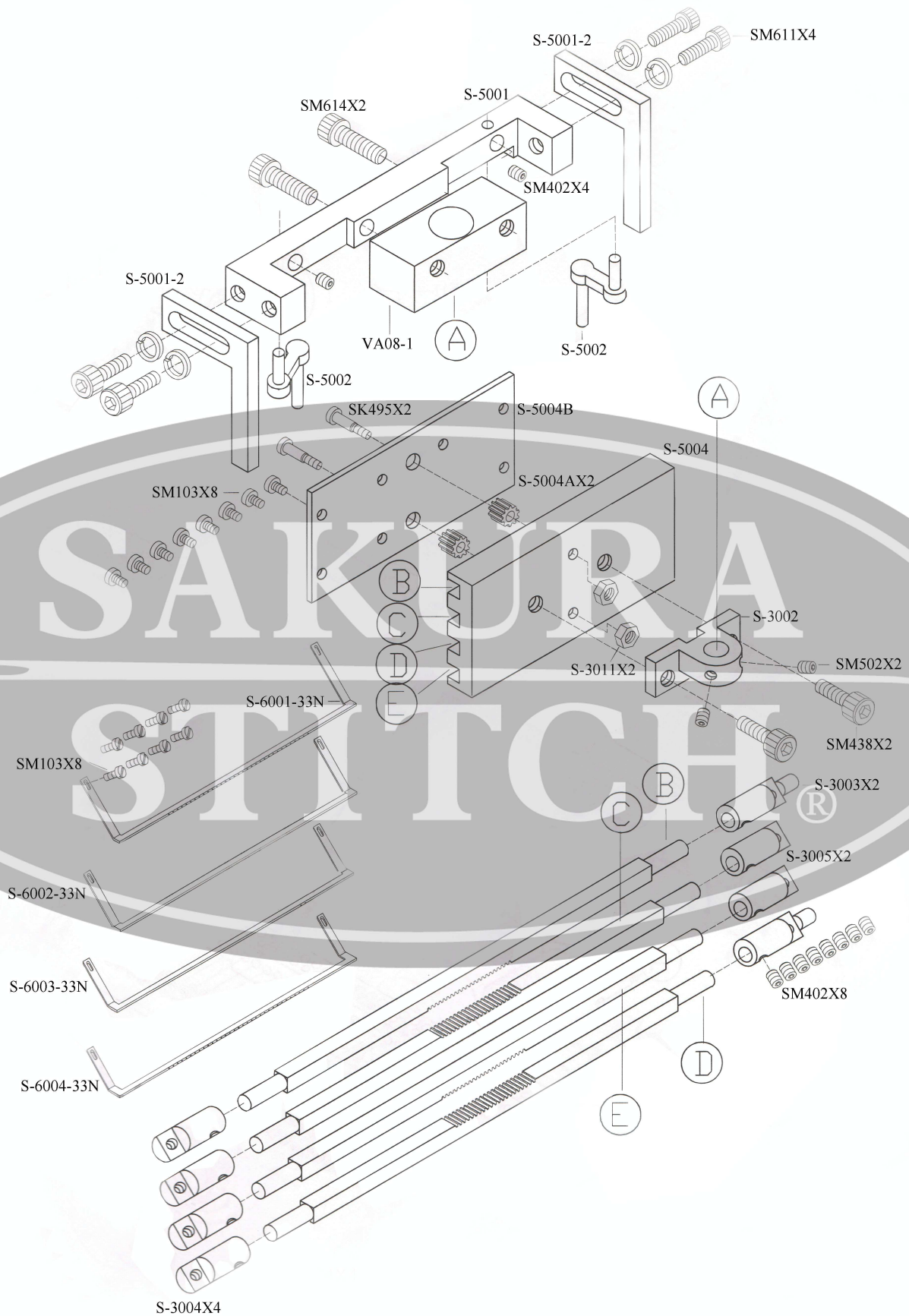
打攬齒輪箱及花盤結構圖

Smocking Gear Box & Cam System



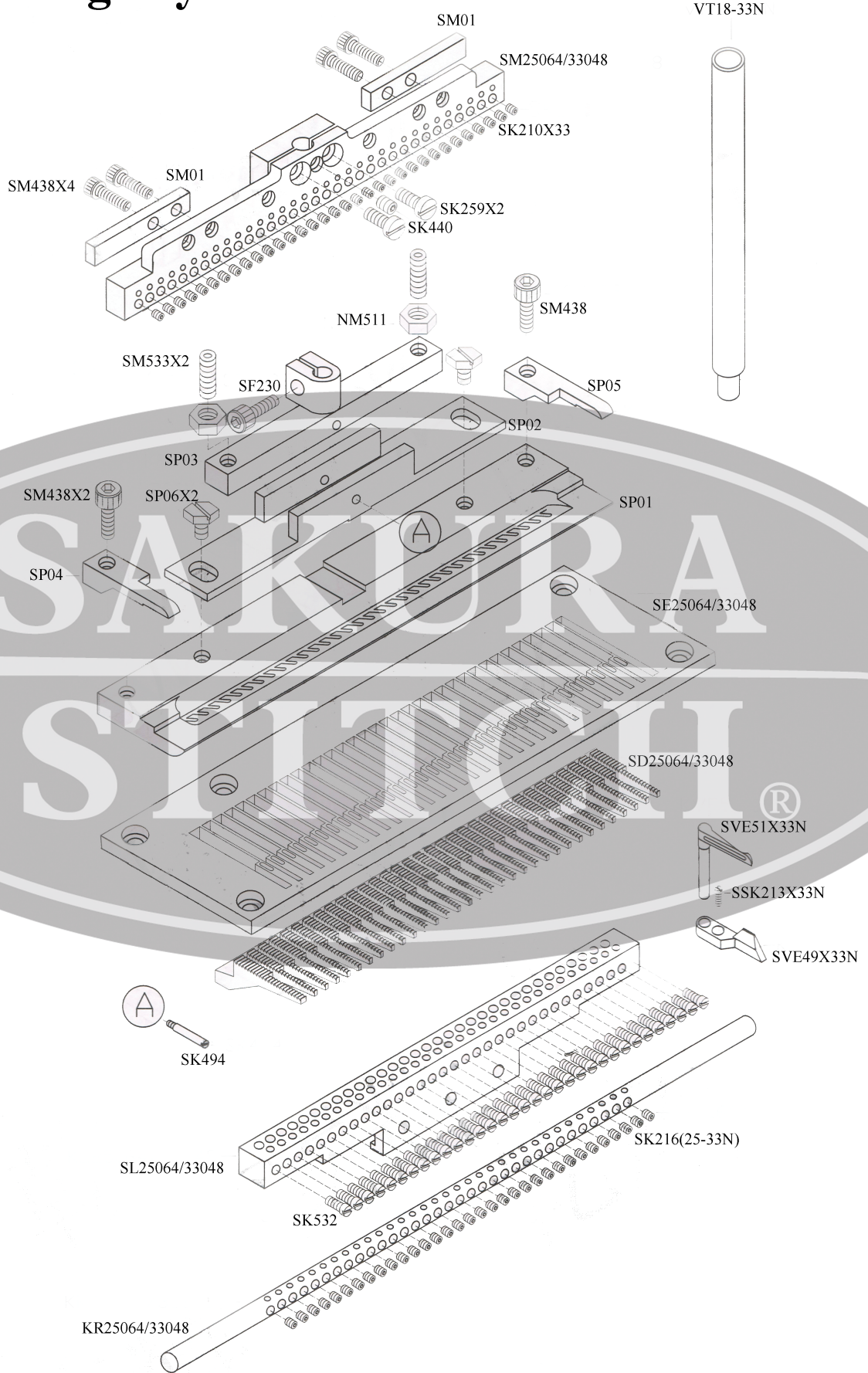
打攬架結構圖

Smocking Stand System



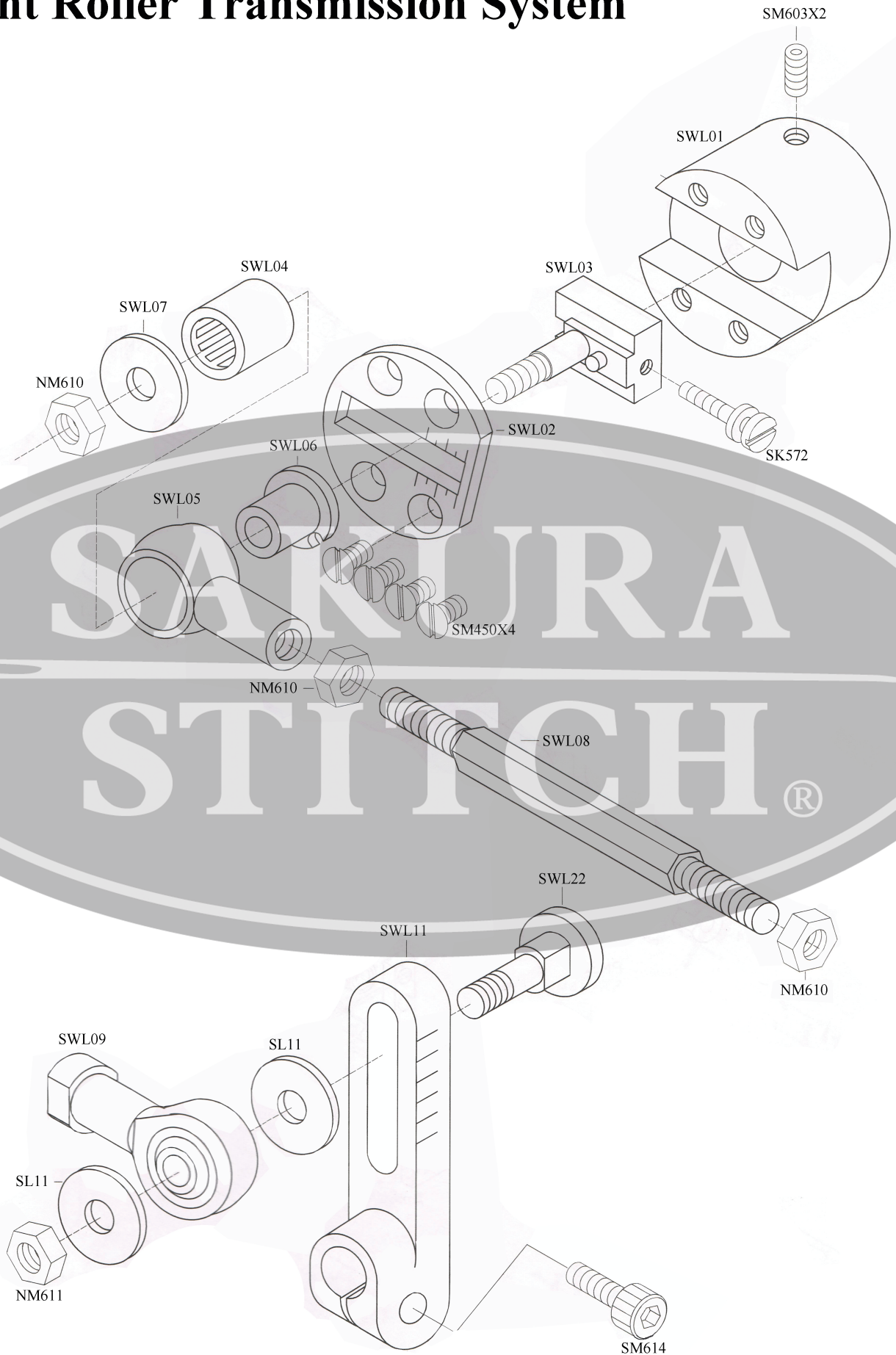
針位組結構圖

Needle Gauge System



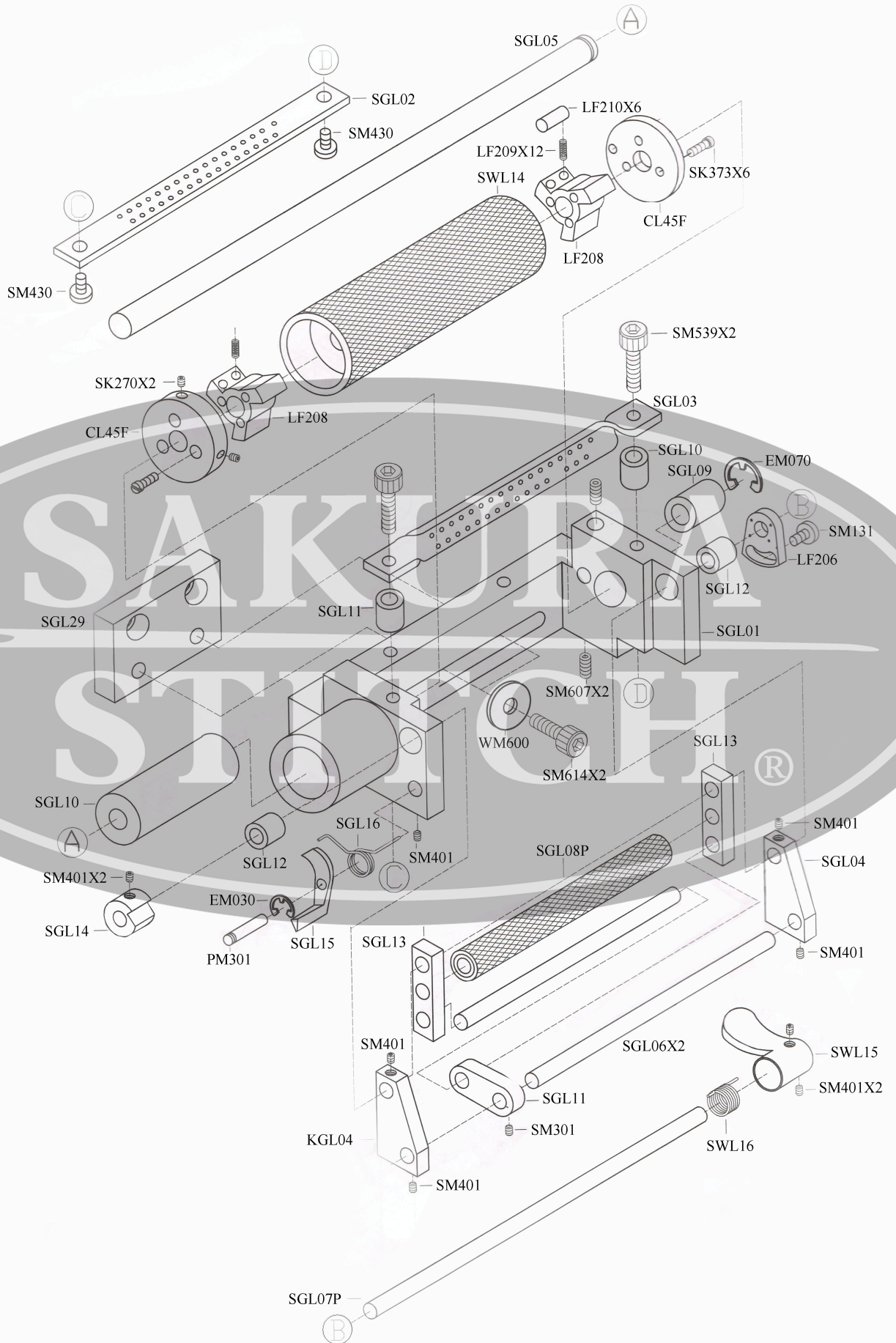
前拖輪傳動結構圖

Front Roller Transmission System



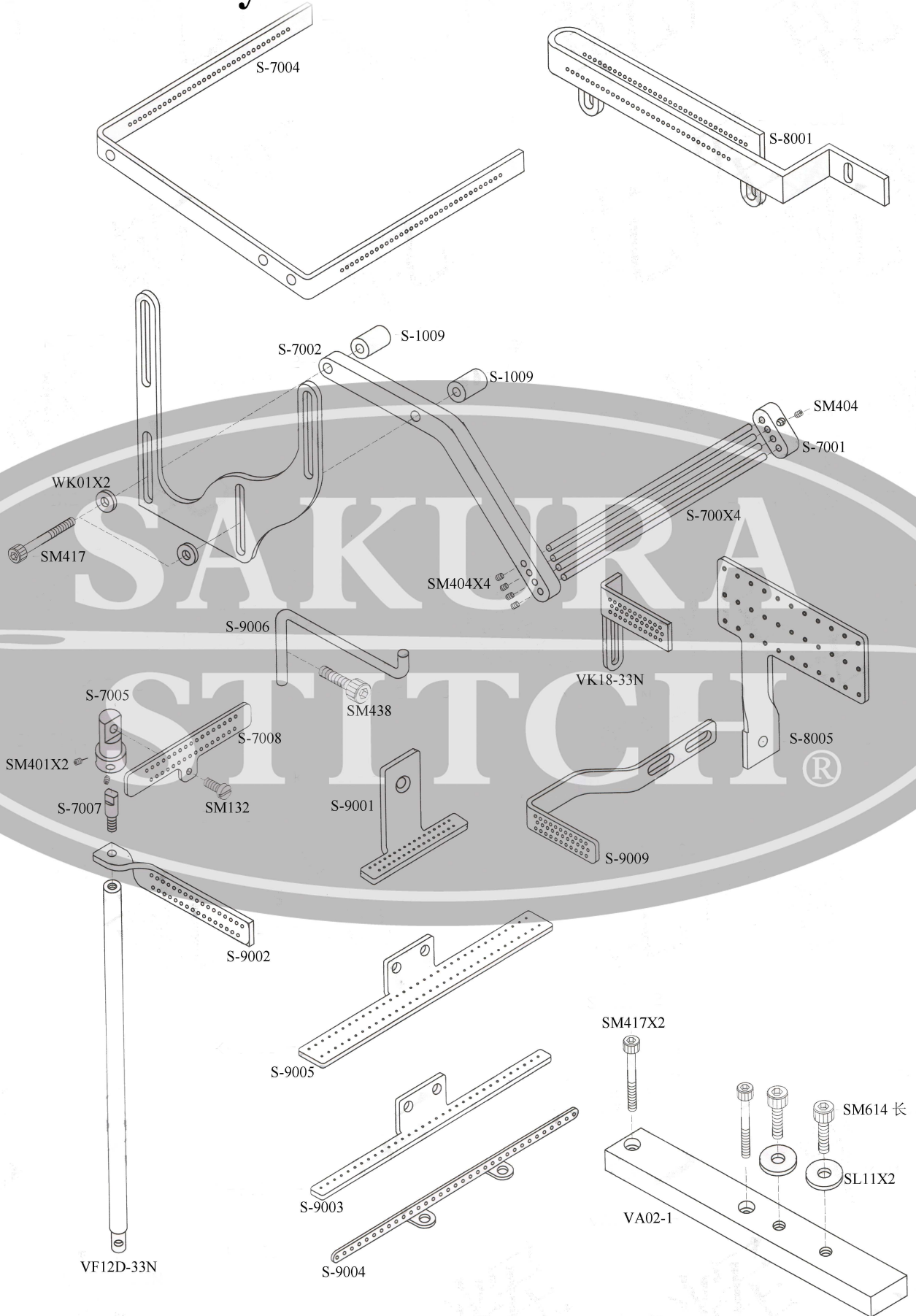
前拖輪結構圖

Front Roller System



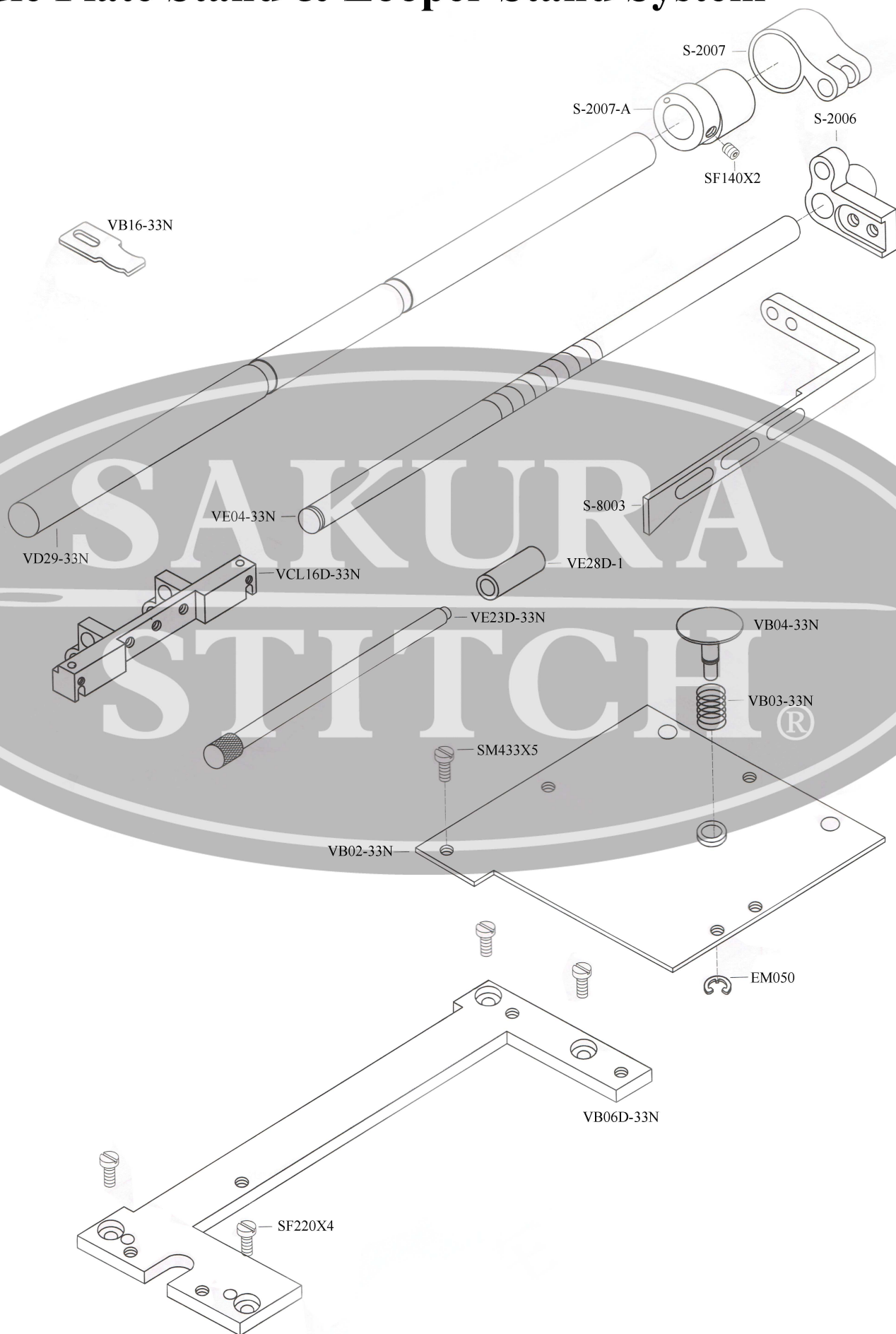
線路結構圖

Thread Route System



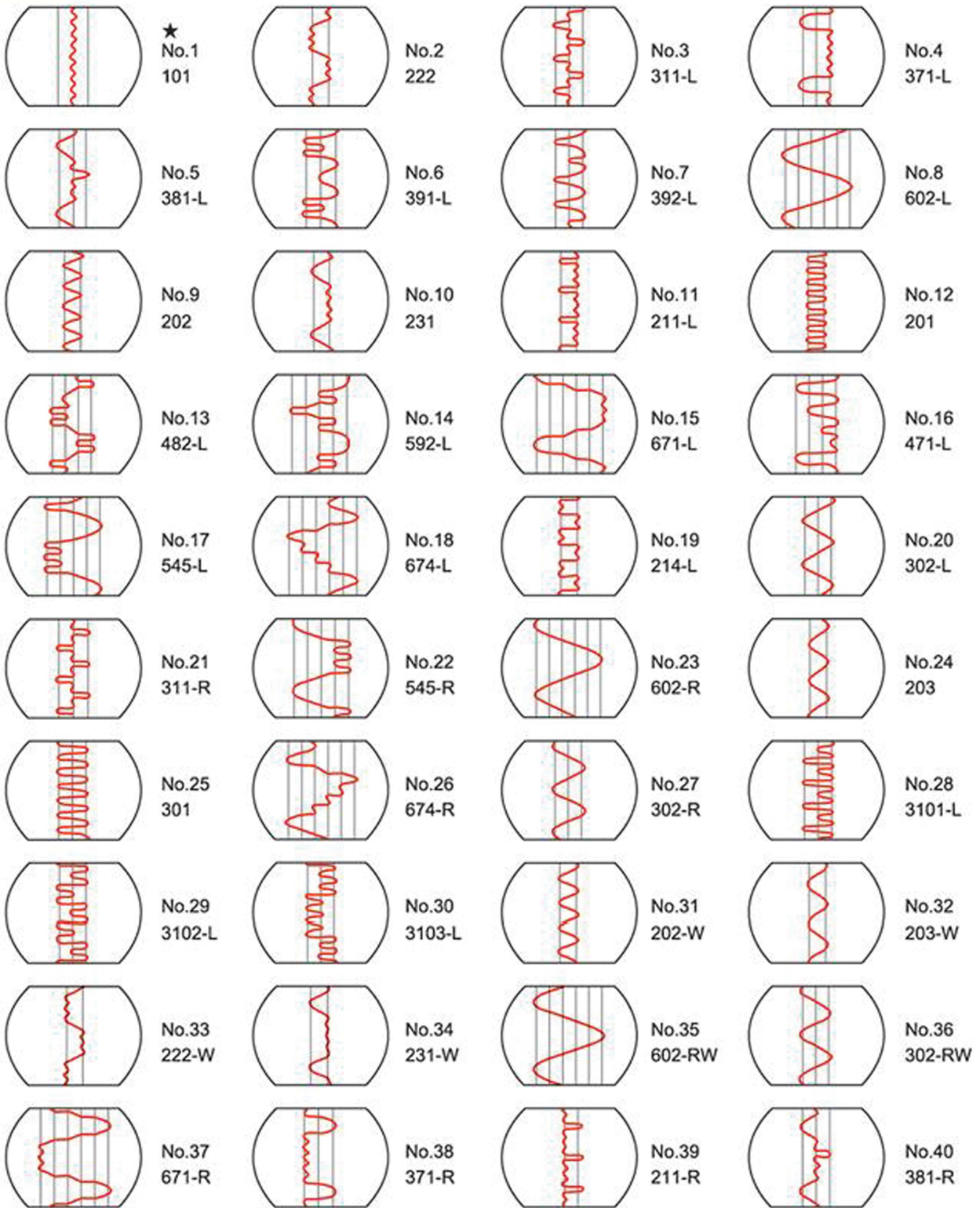
針板架彎針座結構圖

Needle Plate Stand & Looper Stand System



打攪車花盤圖

SMOCKING CAM PATTERNS



櫻之花服裝機械設備有限公司 **Sakura-Stitch Garment Machinerics Co., Ltd.**

The specification and/or appearances of the equipment described in this parts list are subject to change because of modification without previous notice.