

# 300U 围边机

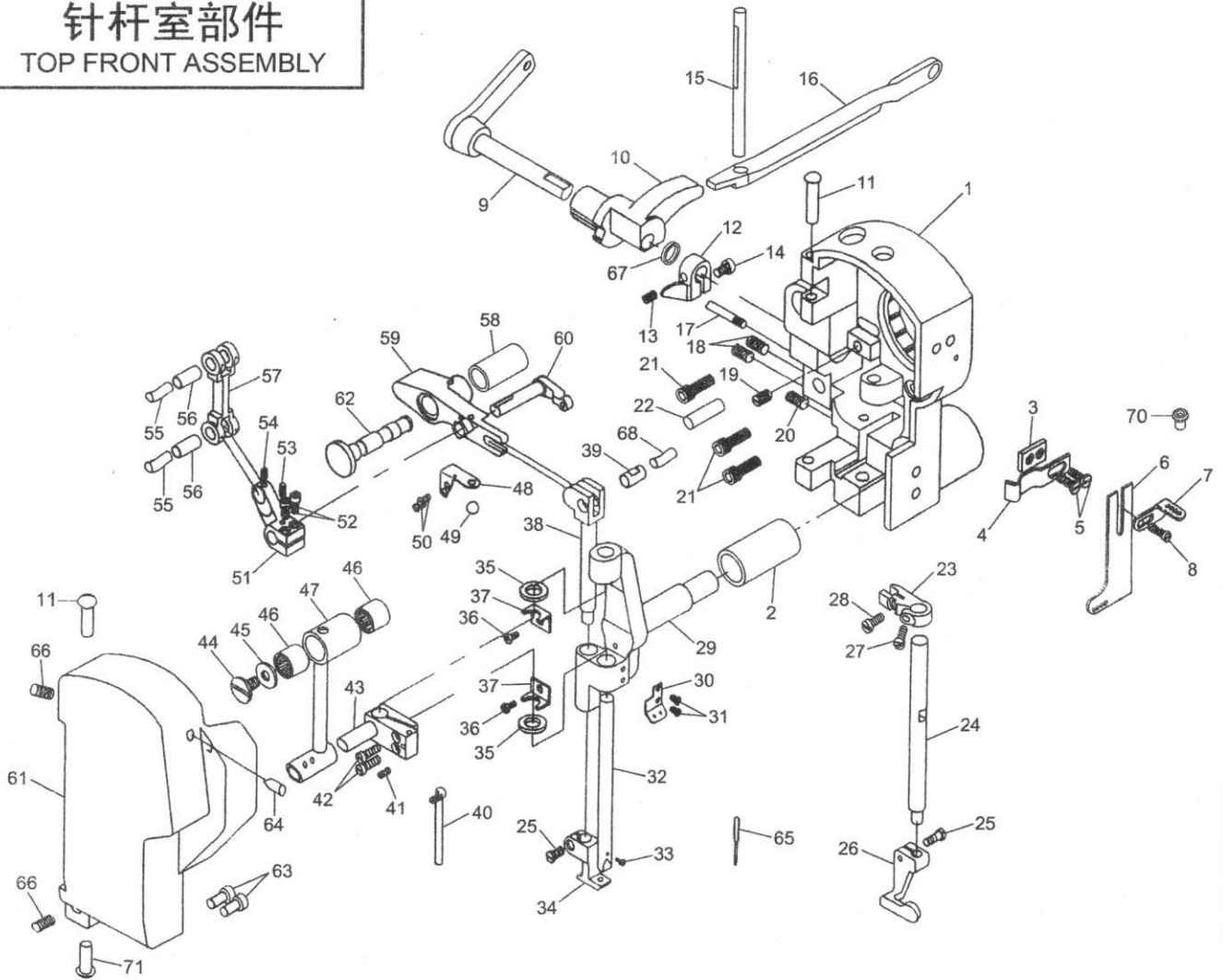
High Speed Flat Bed Chainstitch Machines

零件手册

Partsbook

# 针杆室部件

## TOP FRONT ASSEMBLY

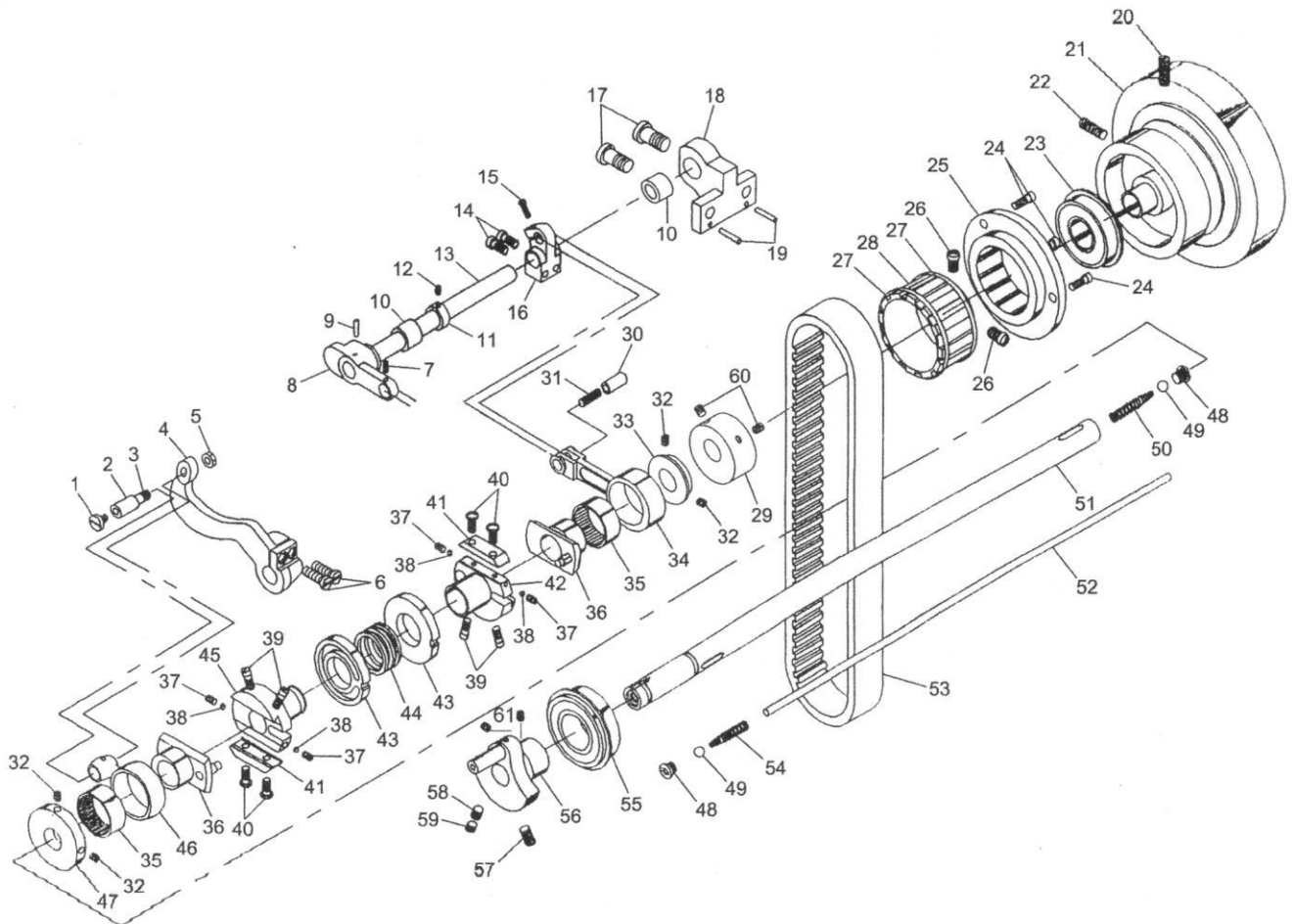


序号 Ref.-No	图号 Symbol	件号 Part.-No	零件名称 Description	数量 Amt. Req.
1	14A-1	415012	前盖 Face Plate	1
2	13A-2H		轴套 Bushing	1
3	13A-3	415016	弹簧板 Face Plate Lock Spring Plate	1
4	13A-4	268032	锁紧弹簧 Face Plate Lock Spring	1
5	13A-5	414534	半沉头螺钉 Screw M5×7.2	2
6	14A-6	268312	过线板 Needle Thread Guide	1
7	14A-7	268513	过线板 Needle Thread Guide	1
8	3C-2	414514	螺钉 Screw 11/64-40×10	1
9	14A-9	267612	压脚提升曲柄 Foot Lifter Crank	1
10	14A-10	267646	压紧杆簧杆支杆 Presser Bar Spring Arm Fulcrum	1
11	13A-9	268330	门销 Face Plate Hinge Stud	1
12	14A-12	415120	压脚提升杆 Foot Lifter Arm	1
13	8B-20	545213	紧定螺钉 Set Screw 7/32-32×6.5	1
14	14A-14	268173	夹紧螺钉 Pinch Screw M5×11	1
15	14A-15	267907	提升压紧杆导杆 Lifting Presser Bar Guide Rod	1
16	14A-16	267738	压紧杆簧杆 Presser Bar Spring Arm	1
17	14A-17	414566	销轴螺钉 Foot Lifter Crank Stop Screw Stud 3/16-32	1
18	13B-38a	544322	紧定螺钉 Set Screw 1/4-28×6	2
19	8D-29	544301	紧定螺钉 Set Screw 3/16-32×4.8	1
20	8D-29	544301	紧定螺钉 Set Screw 3/16-32×4.8	1

序号 Ref.-No	图号 Symbol	件号 Part.-No	零件名称 Description	数量 Amt.Req.
21	A-48	414504	螺钉 Screw M6×14	3
22	13A-10	548005	定位销 Arm Head Position Pin	1
23	14A-23	415059	提升压紧杆导块 Lifting Presser Bar Guide Block	1
24	14A-24	267628	提升压紧杆 Lifting Presser Bar	1
25	10B-54	414638	夹紧螺钉 Pinch Screw 11/64-40×7	2
26	14A-26C		提升压脚 Lifting Presser Foot	1
27	10H-8	414512	夹紧螺钉 Pinch Screw 9/64-40×12	1
28	2D-18-2		夹紧螺钉 Pinch Screw 9/64-40×8	1
29	14A-29	415045	针杆摇架 Needle Bar Rock Frame	1
30	14A-30	268219	导线架 Needle Bar Rock Frame Thread Guide	1
31	11-10a	414539	半圆沉头螺钉 Screw 9/64-40×7.3	2
32	14A-32	415041	针杆 Needle Bar	1
33	10C-27	414519	机针紧定螺钉 Needle Set Screw 9/64-40×6	1
34	14A-34	267659	摆动压脚 Vibrating Presser Foot	1
35	13A-34	268144	针杆油毡 Needle Bar Oiling Felt	2
36	2C-15	414522	螺钉 Screw 1/8-44×5.9	2
37	14A-37	268278	油毡夹 Needle Bar Oiling Felt Holder	2
38	14A-38	267657	摆动压杆 Vibrating Presser Bar	1
39	14A-39	267658	铰链销 Vibrating Presser Bar Hinge Stud	1
40	14A-40		导线钩 Needle Thread Guide	1
41	13A-22	544301	紧定螺钉 Set Screw 3/16-32×3.5	1
42	13C-32		螺钉 Pinch Screw 3/16-32×10.5	2
43	14A-43A		针杆连接轴 Needle Bar Connecting Stud	1
44	13A-29	414517	螺钉 Screw 3/16-32×8	1
45	13A-28	268139	垫圈 Needle Bar Connecting Link Cap Washer	1
46	13A-27	270266	滚针轴承 Needle Bar Connecting Link Needle Bearing	2
47	14A-47A		针杆连杆 Needle Bar Connecting Link	1
48	14A-48	267718	滚珠止动器 Presser Bar Spring Arm Ball Bearing Retainer	1
49	14A-49	276025	钢球 Presser Bar Spring Arm Ball Bearing	1
50	JGA-39	414548	螺钉 Screw M3×4	2
51	14A-51	415061	提升曲柄 Lifting Crank	1
52	13C-32		螺钉 Pinch Screw 3/16-32×10.5	2
53	14A-53		紧定螺钉 Set Screw M5×8	1
54	2F-3	141424	紧定螺钉 Set Screw 1/8-44×4.5	1
55	14A-55	244071	油绳 Oil Packing (wick)	2
56	14A-56	267617	曲柄连杆铰链销 Lifting Eccentric Connection Hinge Pin	2
57	14A-57	267627	曲柄连杆 Lifting Link	1
58	14A-58H		轴套 Sleeve	1
59	14A-59	415067	压脚提升杆 Lifting Lever	1
60	14A-60	267631	抬牙曲柄 Lifting Presser Bar Lifting Crank	1
61	14A-61A		面板 Face Plate	1
62	14A-62		提升杆铰链销 Lifting Lever Hinge Stud	1
63	13A-40	228661	面板垫 Face Plate Cushion	2
64	13A-42	268033	锁紧钉 Face Plate Lock Stud	1
65	14A-65	CAT.4112	机针 Needle DV×59	1
66	3C-14	545174-452	紧定螺钉 Set Screw 11/64-40×2.8	2
67	14A-67a		垫圈 Washer 9.6×14.5	1
68	13D-13	32825	油绳 Oil Packing (wick)	1
70	14A-70		过线眼 Thread Guide	6
71	14A-71		下门销 Face Plate Hinge Stud	1



# 上轴部件 TOP SHAFT ASSEMBLY

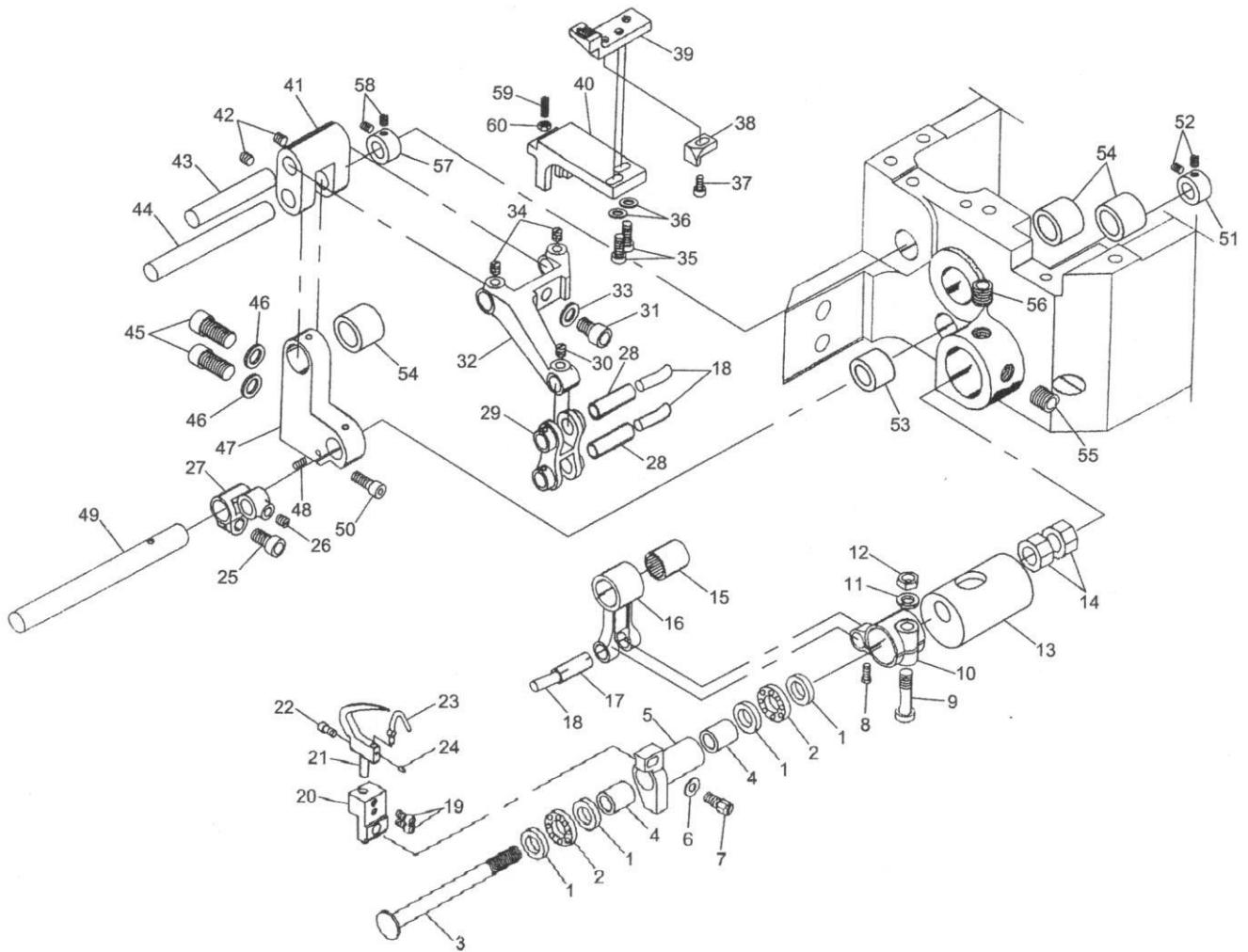


序号 Ref.-No	图号 Symbol	件号 Part.-No	零件名称 Description	数量 Amt. Req.
1	13B-1	545297	有头螺钉 Cap Screw 3/16-32×6.6	1
2	13B-7	415092	连接铰链轴 Hinge Stud	1
3	13B-6	268258	油绳 Oil Packing (wick)	1
4	14B-4	415094	针杆摇架传动杆 Needle Bar Rock Frame Driving Arm	1
5	8C-30	541197	螺母 Nut 1/4-24	1
6	13B-4a	414790	夹紧螺钉 Pinch Screw M5×12	2
7	2F-3	141424	紧定螺钉 Set Screw 1/8-44×4.5	1
8	14B-8	32788	提升摆轴曲柄 Lifting Rock Shaft Crank	1
9	14B-9	548035	销 Lifting Rock Shaft Crank pin	1
10	14B-10H		轴套 Sleeve	2
11	13C-3	415065	挡圈 Collar	1
12	8D-29	504020	紧定螺钉 Set Screw 3/16-32×4.8	2
13	14B-13		提升摆轴 Lifting Rock Shaft	1
14	14A-14	141509	夹紧螺钉 Pinch Screw M5×11	2
15	9E-72		螺钉 Screw 1/8-44×9	1



序号 Ref.-No	图号 Symbol	件号 Part.-No	零件名称 Description	数量 Amt.Req.
16	14B-16	415069	抬牙凸轮曲柄 Lifting Eccentric Connection Crank	1
17	7B-23		螺钉 Screw M5×14	2
18	14B-18	415071	提升摆轴支架 Lifting Rock Shaft Bracket	1
19	9B-24a	543841-001	定位销 Lifting Rock Shaft Bracket Position Pin 3×16.5	2
20	13B-27	414526	上轮定位螺钉 Pulley Position Screw 1/4-24×19.2	1
21	13B-25	415154	上轮 Machine Pulley	1
22	8C-31	414525	紧定螺钉 Set Screw 1/4-24×19.5	1
23	13B-24	272142	球轴承 Ball Bearing	1
24	13B-40	544336	螺钉 Screw 3/16-32×13.2	3
25	13B-23	268004	轴承座 Arm Shaft Ball Bearing (back) Housing	1
26	13B-22	414546	紧定螺钉 Set Screw 1/4-28×10.2	2
27	13B-21	202253	上同步带轮挡圈 Belt Pulley Spring Flange	2
28	14B-28		上轴同步带轮 Arm Shaft Connection Belt Pulley	1
29	14B-29		平衡块 Balance Weight	1
30	14A-56a	267617	铰链销 Hinge Pin	1
31	14A-55	244071	铰链销油绳 Hinge Pin Oil Packing (wick)	1
32	3C-14		紧定螺钉 Set Screw 11/64-40×4.5	4
33	13B-41		挡圈 Collar	1
34	14B-34	268492	升降偏心轮连杆 Lifting Eccentric Connection	1
35	14B-35		滚针轴承 Needle Bearing	2
36	14B-36	268064	偏心轮组件 Eccentric	2
37	13B-10	414557	紧定螺钉 Set Screw 11/64-40×6.5	4
38	13B-11	241763	黄铜垫 Packing (brass)	4
39	13B-14	414555	紧定螺钉 Set Screw 3/16-32×14.4	4
40	13B-13	544286	夹紧螺钉 Screw 3/16-32×10.5	4
41	13B-12	267623	偏心轮夹板 Driving Eccentric Friction Plate	2
42	14B-42	415077	偏心法兰 Lifting Eccentric Frange	1
43	13B-16	268065	偏心调节盘 Driving Eccentric Adjusting Disc	2
44	14B-44	267618	调节盘弹簧 Lifting Eccentric Adjusting Disc Spring	1
45	14B-45	415079	偏心法兰 Needle Bar Rock Frame Driving Eccentric Frange	1
46	14B-46	268060	送料传动连杆 Feed Driving Connection	1
47	13B-41	415308	偏心轮隔圈 Lifting Eccentric Spacing Collar	1
48	13B-28	414578	油量调节螺钉 M8-0.75	2
49	B-33	268214	油量调节球 Oil Stop Ball	2
50	13B-30	268044	油量调节弹簧(后) Arm Shaft Oil Stop Ball (rear)	1
51	14B-51	415128	上轴 Arm Shaft	1
52	13B-33	268264	油量控制杆 Arm Shaft Oil Control Rod	1
53	13B-34	268270	梯形齿同步带 Arm Shaft Connection Belt	1
54	13B-32	268009	油量调节弹簧(前) Arm Shaft Oil Stop Ball (front)	1
55	13B-35	32848	上轴球轴承(前) Arm Shaft Ball Bearing (front)	1
56	14B-56	415133	挑线凸轮 Needle Bar Crank	1
57	13B-37a	500272-833	紧定螺钉 Set Screw 1/4-28×12	1
58	14B-58		定位螺钉 Position Screw 1/4-28×6	1
59	13B-37a		紧定螺钉 Check Screw 1/4-28×12	1
60	C-22-3		紧定螺钉 Set Screw M5×6	2
61	10C-39a		紧定螺钉 Set Screw 1/4-40×5	2

# 送料部件 FEEDING ASSEMBLY



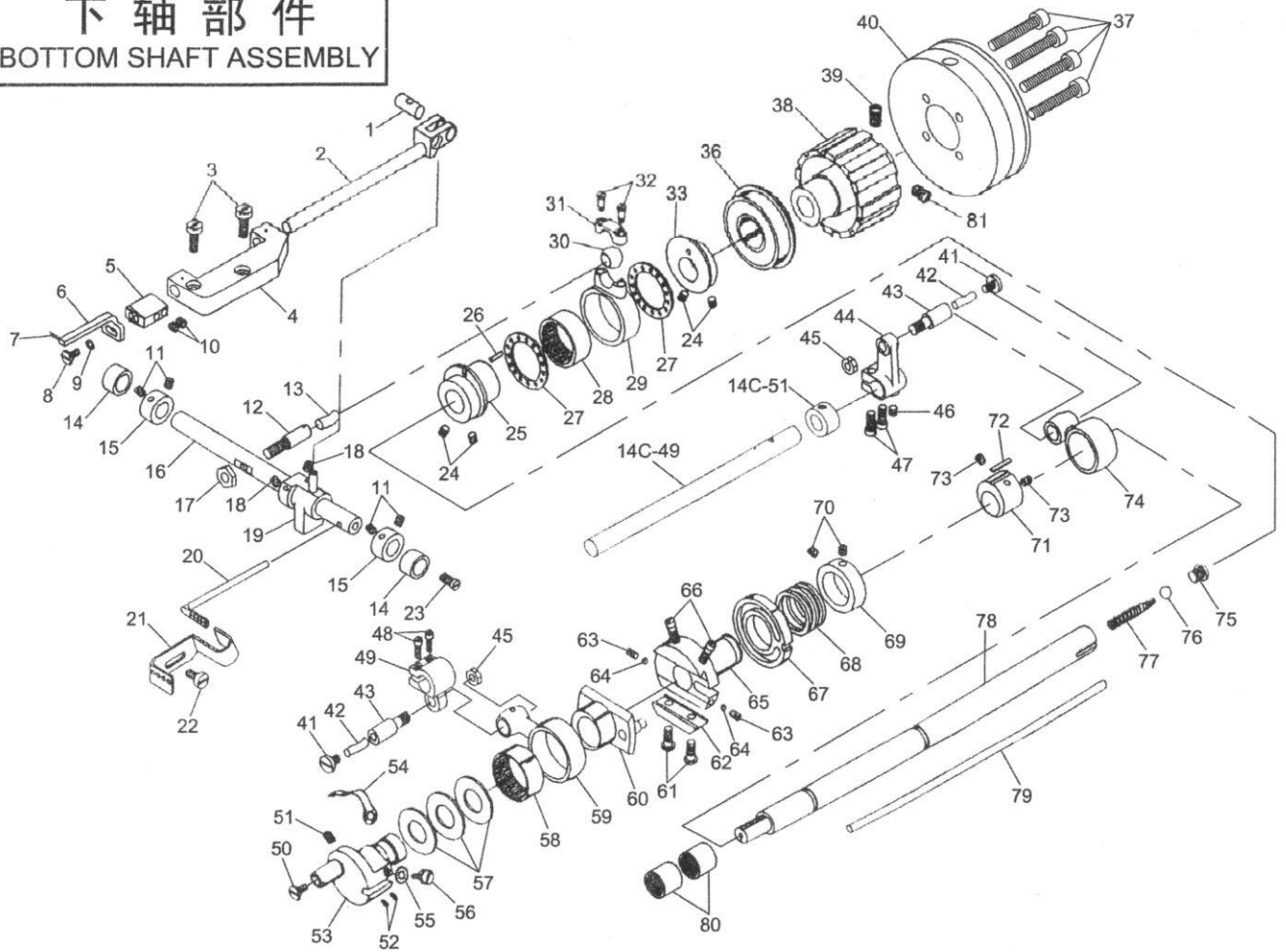
序号 Ref.-No	图号 Symbol	件号 Part.-No	零件名称 Description	数量 Amt. Req.
1	14C-1		球轴承垫圈 Ball Bearing washer	4
2	8C-35		球轴承组件 Ball Bearing	2
3	14C-3		弯针轴 Looper Shaft	1
4	14C-4H		轴套 Bushing	2
5	14C-5	268367	弯针导架 Looper Carrier	1
6	8B-24	543804-004	垫圈 Washer 5.6×9.5×0.8	1
7	13C-43	414553	螺钉 Screw M5×14	1
8	2E-6	414516	螺钉 Screw 9/64-40×7.5	1
9	13C-40	415292	夹紧螺栓 Clamping Stud 1/4-28	1
10	13C-39	415174	弯针导架曲柄 Looper Carrier Crank	1
11	13C-44	548459	弹簧垫圈 Spring Washer	1
12	13C-45	541198	螺母 Nut 1/4-28	1
13	14C-13	415170	轴套 Looper Carrier Shaft Bushing (right)	1
14	14C-14		螺母 Nut 3/8-28	2
15	13C-36	268099	滚针轴承 Needle Bearing	1



序号 Ref.-No	图号 Symbol	件号 Part.-No	零件名称 Description	数量 Amt.Req.
16	14C-16		弯针连杆 Looper Driving Connection	1
17	14C-17		铰链销 Hinge Pin	1
18	13B-6	268258	油绳 Oil Packing (wick)	3
19	13C-48	414558	弯针紧定螺钉 Looper Set Screw M3×7	2
20	14C-20	268602	弯针夹 Looper Holder	1
21	14C-21	268382	弯针 Looper	1
22	13C-49-3	141478	紧定螺钉 Set Screw 29/256-40×12.2	1
23	13C-49-1	268310	护针板 Needle Guard	1
24	13C-49-4a	141494	紧定螺钉 Set Screw 29/256-40×3.4	1
25	8G-14	414501	夹紧螺钉 Pinch Screw 1/4-28×15.4	1
26	8B-20	545213	紧定螺钉 Set Screw 7/32-32×6.5	1
27	13C-34	415204	抬牙曲柄 Feed Lifting Crank	1
28	14C-28		铰链销 Hinge Pin	2
29	14C-29		抬牙小连杆 Feed Lifting Link	1
30	8B-20	545213	紧定螺钉 Set Screw 7/32-32×6.5	1
31	9G-19a		螺钉 Screw M5×8	1
32	14C-32		送料架 Feed Bar	1
33	10A-6		垫圈 Washer 5×10.5×1	1
34	13D-18		紧定螺钉 Set Screw M5×5	2
35	14C-35		螺钉 Screw 3/16-32×10.8	2
36	C-51		垫圈 Washer 4.8×8.4×1.1	2
37	14C-37		螺钉 Screw M4×8	1
38	14C-38		护针板 Needle Deflector Plate	1
39	14C-39		送料牙 Feed Dog	1
40	14C-40		送料牙架 Feed Dog Mounting Bracket	1
41	14C-41		送料牙转动架 Feed Dog Swivel Bracket	1
42	13B-39a		紧定螺钉 Set Screw 1/4-28×5.7	2
43	14C-43		送料杆铰链轴 Feed Bar Hinge Pin	1
44	14C-44		针距座轴 Feed Driving Rock Shaft	1
45	JGA-59		螺钉 Screw M6×18	2
46	8E-43		垫圈 Washer 6.2×9.5×1	2
47	14C-47		送料牙轴承座 Feed Dog Bearing Support	1
48	B-40		紧定螺钉 Set Screw M4×4	1
49	14C-49		抬牙轴 Feed Lifting Rock Shaft	1
50	B-42		夹紧螺钉 Pinch Screw M4×12	1
51	3C-13		挡圈 Collar	1
52	3C-14		紧定螺钉 Set Screw 3/16-32×4.8	2
53	14B-10H		轴套 Sleeve	1
54	13C-1H		轴套 Bushing	3
55	7E-54	549024	紧定螺钉 Set Screw M8×8	1
56	14C-56		螺钉 Screw M8×12.7	1
57	13C-3		挡圈 Collar	1
58	8D-29		紧定螺钉 Set Screw 3/16-32×4.8	2
59	13C-18		调节螺钉 Adjusting Screw 9/64-40×11.1	1
60	3E-24		螺母 Nut 9/64-40	1



# 下轴部件 BOTTOM SHAFT ASSEMBLY

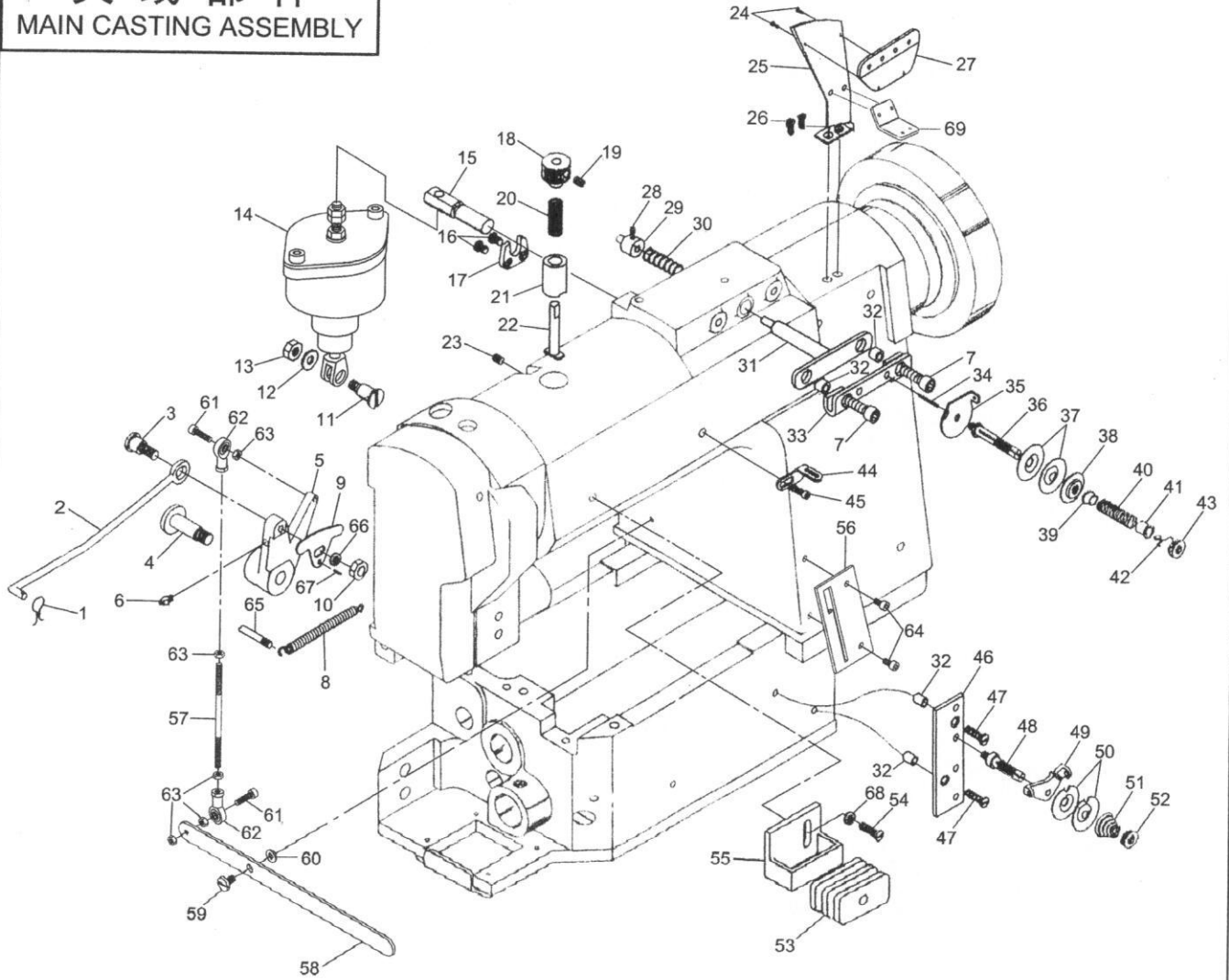


序号 Ref.-No	图号 Symbol	件号 Part.-No	零件名称 Description	数量 Amt. Req.
1	13D-1	268190	叉针销 Spreader Driving Pin	1
2	13D-2	268499	叉针杆组件 Spreader Bar complete	1
3	7B-23		螺钉 Screw M5×14	2
4	13D-4	268184	叉针杆支架 Spreader Bar Bracket	1
5	13D-5	415196	叉针夹 Spreader Holder	1
6	14D-6	268638	叉针 Spreader	1
7	13D-7	268162	叉针尖 Spreader Point	1
8	13D-8	414552	叉针螺钉 Spreader Screw 11/64-40×7.5	1
9	C-51	547670	垫圈 Washer 4.5×9×1	1
10	3C-14		紧定螺钉 Set Screw 11/64-40×4.5	2
11	8D-29	504020	紧定螺钉 Set Screw 3/16-32×4.8	4
12	13D-12	414575	叉针轴螺栓 Spreader Driving Rock Shaft Stud 9/32-28	1
13	13D-13	32825	油绳 Oil Packing (wick)	1
14	13C-1H		轴套 Bushing	2
15	13C-3	415065	挡圈 Collar	2
16	13D-16	415192	叉针轴 Spreader Driving Rock Shaft	1
17	2D-15	545424	螺母 Nut 9/32-28	1
18	13D-18	544204-001	紧定螺钉 Set Screw M5×5	2
19	13D-19	415194	叉针曲柄 Spreader Driving Crank	1
20	14D-20		弯针挑线杆 Looper Thread take-up Rod	1
21	14D-21		弯针导线板 Looper Thread Guide	1
22	13F-29	414510	螺钉 Screw M5×10	1
23	2F-6	504019	螺钉 Screw 11/64-40×10	1
24	8B-20	414528	紧定螺钉 Set Screw 7/32-32×6.5	4

序号 Ref.-No	图号 Symbol	件号 Part.-No	零件名称 Description	数量 Amt.Req.
25	13D-25a	415187	叉针偏心轮 Spreader Driving Eccentric	1
26	13D-26a	543808-002	弹性圆柱销 Spreader Driving Eccentric Pin	1
27	13D-27a	268220	轴承止推垫圈 Thrust Washer	2
28	9D-18-3a	415368	滚针轴承 Needle Bearing	1
29	13D-29a		叉针连杆 Spreader Driving Connection	1
30	13D-30	351876	球体 Ball Roller	1
31	13D-31		叉针连杆盖 Spreader Driving Connection Cap	1
32	13D-32	414569	螺钉 Screw 9/64-40	2
33	13D-33	415190	偏心轮平衡块 Spreader Driving Eccentric Counterbalance	1
36	13B-24		球轴承 Ball Bearing	1
37	9C-33a		螺钉 Screw M5×30	4
38	14D-38		下轴同步带轮 Bed Shaft Connection Belt Pulley	1
39	13B-39a		紧定螺钉 Set Screw 1/4-28×5.7	1
40	14D-40		下轴皮带轮 Lower Drive Pulley	1
41	13B-1		有头螺钉 Cap Screw 3/16-32×6.6	2
42	13B-6		油绳 Oil Packing (wick)	2
43	13B-7		连接铰链轴 Hinge Stud	2
44	13C-27		抬牙轴曲柄 Feed Lifting Rock Shaft Crank	1
45	8C-30		螺母 Nut 1/4-24	2
46	C-22-3		螺钉 Screw M5×6	1
47	13A-24		螺钉 Pinch Screw 3/16-32×10.5	2
48	13A-24	414511	螺钉 Pinch Screw 3/16-32×10.5	2
49	13D-42	415213	送料摆轴曲柄 Feed Driving Rock Shaft Crank	1
50	13D-55	414536	油量调节螺钉 Looper Driving Crank Oil Stop Screw M5	1
51	13B-39a		紧定螺钉 Set Screw 1/4-28×5.7	1
52	13D-58	545103	曲柄定位螺钉 Crank Position Screw 11/64-40×11	2
53	14D-53	415176	弯针曲柄 Looper Driving Crank	1
54	13D-60	268102	弯针曲柄油孔盖 Looper Driving Crank Oil Hole Cover	1
55	C-51	204925	垫圈 Washer 4.5×9×1	1
56	C-20	414563	螺钉 Screw 9/64-40×8	1
57	14D-57		垫圈 Driving Crank Spacers	3
58	14B-35		滚针轴承 Needle Bearing	1
59	14B-46		送料传动连杆 Feed Driving Connection	1
60	14B-36a	268064	偏心轮组件 Eccentric	1
61	13B-13	544286	夹紧螺钉 Screw 3/16-32×10.5	2
62	13B-12	267623	偏心轮夹板 Driving Eccentric Friction Plate	1
63	13B-10	414557	紧定螺钉 Set Screw 11/64-40×6.5	2
64	13B-11	241763	黄铜垫 Packing (brass)	2
65	13B-15	415074	偏心法兰 Driving Eccentric Flange	1
66	13B-14	414555	紧定螺钉 Set Screw 3/16-32×14.4	2
67	13B-16	268065	偏心调节盘 Driving Eccentric Adjusting Disc	1
68	13B-17	268066	调节盘弹簧 Driving Eccentric Adjusting Disc Spring	1
69	13B-18	412011	挡圈 Driving Eccentric Adjusting Disc Spring Collar	1
70	13B-39a		紧定螺钉 Set Screw 1/4-28×5.7	2
71	13D-62	415210	抬牙凸轮 Feed Lifting Eccentric	1
72	13D-64	268077	抬牙凸轮润滑棍 Feed Lifting Eccentric Lubricating Pad	1
73	B-47	544204-001	紧定螺钉 Set Screw M4×6	2
74	13D-63	268074	抬牙连杆 Feed Lifting Connection	1
75	13B-28	414578	油量调节螺钉 Oil Stop Ball Screw M8-0.75	1
76	B-33	268214	油量调节球 Oil Stop Ball	1
77	13B-30	268044	油量调节弹簧(后) Arm Shaft Oil Stop Ball (rear)	1
78	14D-78A		下轴 Bed Shaft	1
79	13D-69	268265	下轴油量控制杆 Bed Shaft Oil Control Rod	1
80	13A-2		滚针轴承 Needle Bearing	2
81	14B-58		紧定螺钉 Set Screw 1/4-28×6	1



# 夹线部件 MAIN CASTING ASSEMBLY

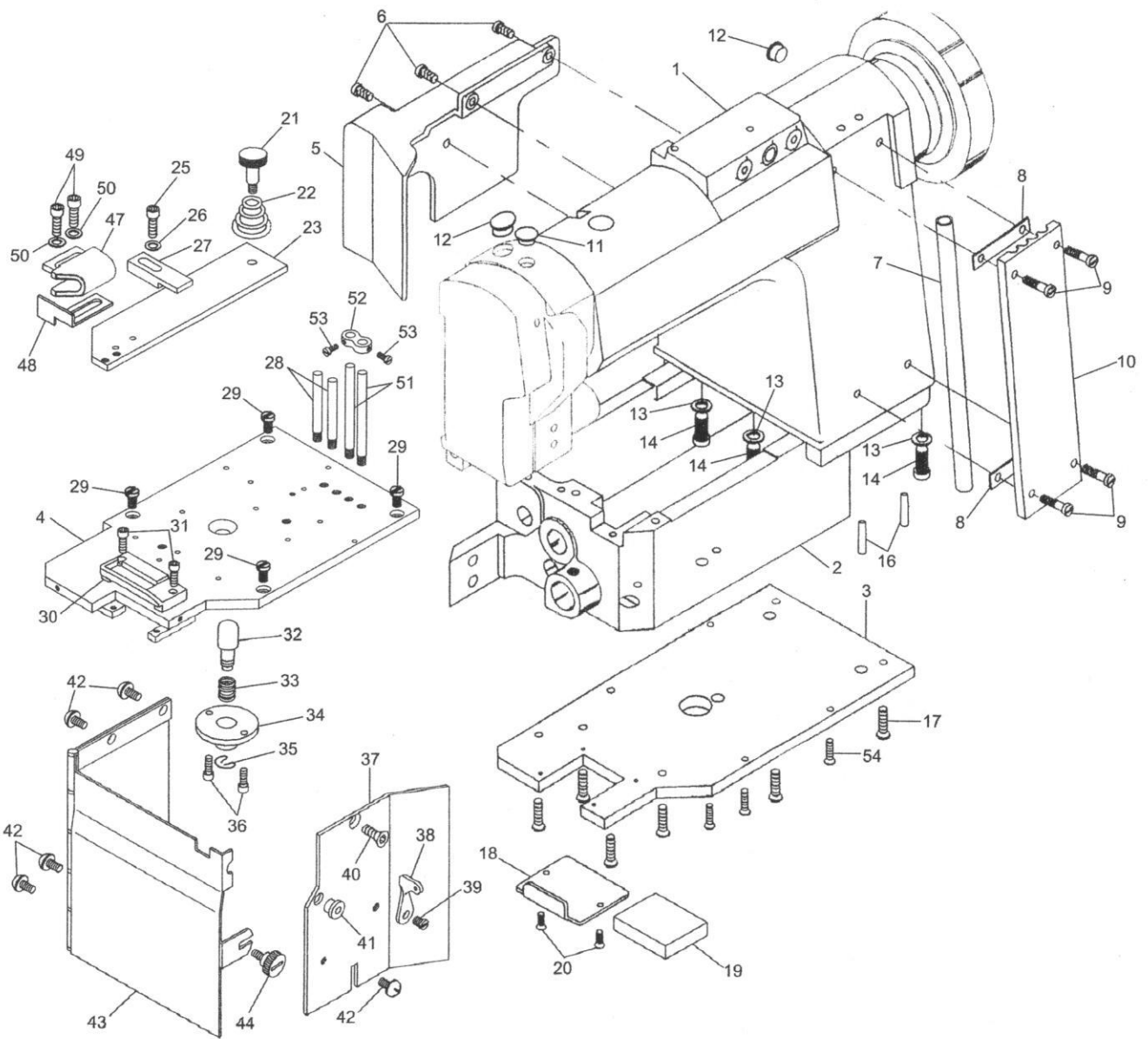


序号 Ref.-No	图号 Symbol	件号 Part.-No	零件名称 Description	数量 Amt.Req.
1	13E-10	248423	开口销 Foot Lifter Lever Rod Cotter Pin	1
2	14E-2	267615	压脚提升杠杆 Foot Lifter Lever Rod	1
3	14E-3	414577	铰链螺钉 Hinge Screw M5	1
4	13E-14	201363	铰链螺钉 Hinge Screw 5/16-24	1
5	14E-5	415104	压脚提升杆 Foot Lifter Lever	1
6	13E-13	414570	弹簧挂销 Foot Lifter Lever Spring Screw Eye	1
7	10F-45		螺钉 Screw 11/64-40×14	2
8	13E-12	204348	压脚提升连杆弹簧 Foot Lifter Lever Spring	1
9	14E-9	268171	机针可调松线板 Needle Thread Tension Releasing Plate	1
10	7A-26	541166-003	螺母 Nut M5	1
11	14E-11	414567	铰链螺钉 Hinge Screw 1/4-24	1
12	A-36	548154	垫圈 Washer 6.1×13×1.6	1
13	10D-33	545405	螺母 Nut 1/4-24	1
14	14E-14		气缸组件 Presser Bar Spring Housing Complete	1
15	14E-15	415111	气缸支柱 Presser Bar Spring Housing Support	1
16	10B-54	545205-451	螺钉 Screw 11/64-40×7	2
17	14E-17	267650	支柱止动片 Presser Bar Pressure Cylinder Support Retainer	1
18	13E-20	415099	针杆摇架调节螺母 Needle Bar Rock Frame Regulating Stud Cap	1
19	8B-20	414528	紧定螺钉 Set Screw 7/32-32×6.5	1



序号 Ref.-No	图号 Symbol	件号 Part.-No	零件名称 Description	数量 Amt. Req.
20	13E-22	214529	针杆摇架调节弹簧 Needle Bar Rock Frame Regulating Stud Spring	1
21	13E-23	268149	调节螺套 Needle Bar Rock Frame Regulating Stud Sleeve	1
22	13E-24	268148	调节杆 Needle Bar Rock Frame Regulating Stud	1
23	13E-25	414527	紧定螺钉 Set Screw 3/16-32×14.2	1
24	2C-22	50169	螺钉 Screw 3/32-56×3.3	2
25	13E-27a	268111	弯针导线板架 Looper Thread Guide Bracket	1
26	2F-26	414537	螺钉 Screw 11/64-40×10	2
27	13E-29	268505	弯针导线板 Looper Thread Guide	1
28	2C-6	504048	螺钉 Screw 11/64-40×4.5	1
29	14E-29A		机针夹线调节套 Needle Thread Tension Releaser Cap	1
30	13E-32	204365	机针松线簧 Needle Thread Tension Releaser Spring	1
31	13E-33	415357	机针松线器 Needle Thread Tension Releaser	1
32	13E-34	268121	隔圈 Spacing Collar	4
33	13E-35	268167	机针夹线器支架 Needle Thread Tension Bracket	1
34	13E-37	226206	机针松线销 Needle Thread Tension Releasing Pin	1
35	13E-38a	54279	针线过线板 Needle Thread Tension Thread Guide	1
36	13E-39	50326	机针夹线螺杆 Needle Thread Tension Stud	1
37	13E-40a	2102	机针夹线板 Needle Thread Tension Disc	2
38	10D-29	32572	机针松线板 Needle Thread Tension Releasing Disc	1
39	13E-42	59538	机针后夹线套 Needle Thread Tension Spring Bushing (back)	1
40	14E-40		机针夹线簧 Needle Thread Tension Spring	1
41	13E-44	143657	机针前夹线套 Needle Thread Tension Spring Bushing (front)	1
42	13E-45	143658	蝶形螺母锁紧簧 Thumb Nut Locking Spring	1
43	13E-61	51570	蝶形螺母 Thumb Nut 1/4-40	1
44	14E-44		过线板 Needle Thread Guide	1
45	3C-2	414514	螺钉 Screw 11/64-40×10	1
46	14E-46	415255	弯针夹线器支承板 Looper Thread Tension Bracket	1
47	13E-50	414532	螺钉 Screw M5×15.3	2
48	13E-51a	415291	弯针夹线螺杆 Looper Thread Tension Stud	1
49	13E-52a	268333	弯针线过线板 Looper Thread Tension Thread Guide	1
50	13E-53	412203	弯针夹线板 Looper Thread Tension Disc	2
51	8F-40	10148	弯针夹线簧 Looper Thread Tension Spring	1
52	13E-55	541452	蝶形螺母 Thumb Nut 7/32-32	1
53	14E-53	236957	油毡 Oil Pad (felt)	2
54	3C-2	504019	螺钉 Screw 11/64-40×10	1
55	14E-55	267656	油毡箱 Thread Lubricator	1
56	14E-56		限位板 Stopping Plate	1
57	14E-57		拉杆 Connecting Stud	1
58	14E-58		限位板 Connecting Plate	1
59	12A-12a		螺钉 Screw 1/4-28	1
60	A-36		垫圈 Washer 6.1×13×1.6	1
61	JGA-89		螺钉 Screw M5×20	2
62	10F-31		调节接头 Adjusting Joint	2
63	7A-26		螺母 Nut M5	5
64	9G-19a		螺钉 Screw M5×10	2
65	14E-65		挂弹簧螺钉 Screw 3/16-32	1
66	10A-6	543804-004	垫圈 Washer 5×10.5×1	1
67	13E-19	543850-001	松线板销 Tension Releasing Plate Pin	1
68	10A-6	543804-004	垫圈 Washer 5×10.5×1	1
69	14E-69		导线板 Thread Guide	1

# 机壳及面板部件 CASTING COVER ASSEMBLY

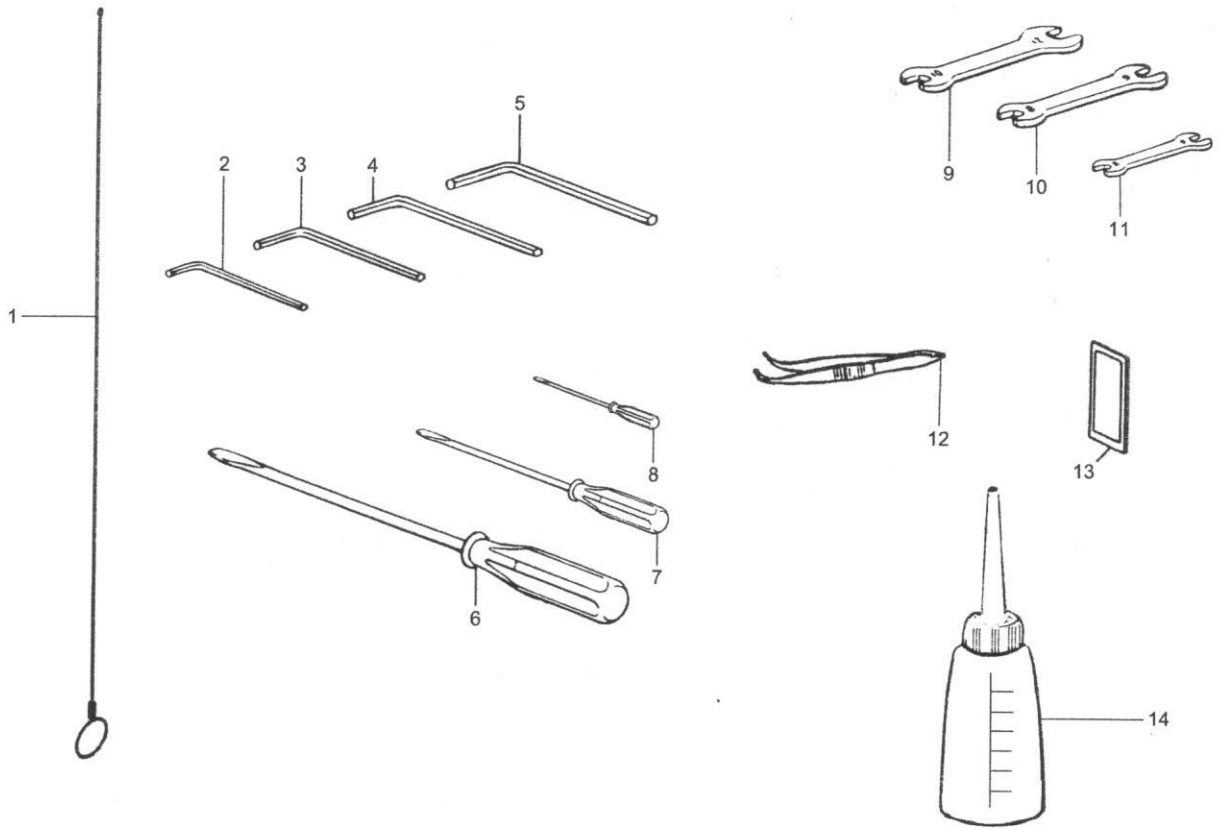




序号 Ref.-No	图号 Symbol	件号 Part.-No	零件名称 Description	数量 Amt.Req.
1	14F-1		机壳 Arm	1
2	14F-2		底板 Bed	1
3	14F-3		底板垫板 Bottom Base Plate	1
4	14F-4		底板面板 Top Base Plate	1
5	14F-5	267604	后侧盖 Arm Side Cover	1
6	10B-2	545246-452	螺钉 Screw 3/16-28×9	3
7	13F-17	268123	弯针线导管 Looper Thread Tube	1
8	13F-18	268500	导管垫片 Looper Thread Tube Gasket	2
9	13F-19	414639	螺钉 Screw 11/64-40×18	4
10	13F-20	415342	导管盖板 Looper Thread Tube Cover	1
11	13F-15	502986	机头胶塞 Arm Head Plug	1
12	13F-16	544875	机壳胶塞 Arm Plug	2
13	A-36	543804-007	垫圈 Washer 6.1×13×1.6	4
14	13F-22	415361	螺钉（内六角头） Arm Screw M10×30	4
16	13F-42	415295	机壳定位销 Arm position pin	2
17	JGA-91		螺钉 Screw M5×12	6
18	14F-18		油毡托板 Bottom Access Plate	1
19	14F-19		油毡 Oil Pad (felt)	1
20	14F-20		螺钉 Screw M5×8	2
21	14F-21		指旋螺钉 Swing Base Thumb Screw M6	1
22	14F-22		滚边板夹紧弹簧 Binder Plate Tension Spring	1
23	14F-23		缝纫台板 Swing Base	1
25	JGA-59		螺钉 Screw M6×18	1
26	A-36		垫圈 Washer 6.1×13×1.6	1
27	14F-27		滚边定位板 Binder Stop Plate	1
28	14F-28		螺柱 Stud	2
29	13F-29		螺钉 Screw M5×10	4
30	14F-30		针板 Throat Plate	1
31	14C-37		螺钉 Screw M4×8	2
32	13F-25	268081	调节销 Feed Regulating Stud	1
33	13F-26	270026	弹簧 Feed Regulating Stud Spring	1
34	13F-27	268082	调节销座 Feed Regulating Stud Socket	1
35	13F-28	240245	限位簧 Stud Retaining Spring	1
36	2F-6	545249-452	螺钉 Screw 11/64-40×10	2
37	14F-37		底板侧盖 Bed Side Cover	1
38	14F-38		过线板 Thread Guide	1
39	2D-6		螺钉 Screw 11/64-40×5	1
40	7F-11		螺钉 Screw M4×10	1
41	14F-41		过线眼 Thread Guide	1
42	4D-37		螺钉 Screw 9/64-40×6.5	5
43	14F-43		底板前盖 Front Housing	1
44	10A-12		指旋螺钉 Thumb Screw 9/64-40	1
47	14F-47		拉筒 Binder	1
48	14F-48		拉筒挡板 Binder Stop Guide	1
49	9G-19a		螺钉 Screw M5×10	2
50	8B-24		垫圈 Washer	2
51	14F-51		螺柱 Stud	2
52	14F-52		连接套 Connection Bushing	1
53	10C-27		螺钉 Screw 9/64-40×6	2
54	B-42		螺钉 Screw M4×12	3



附件  
ACCESSORY



序号 Ref.-No	图号 Symbol	件号 Part.-No	零件名称 Description	数量 Amt.Req.
1	13H-33		引线杆 Threader	1
2	D-6		内六角扳手 Hexagonal Wrench 2	1
3	D-6-1		内六角扳手 Hexagonal Wrench 2.5	1
4	D-4-1		内六角扳手 Hexagonal Wrench 3	1
5	D-5		内六角扳手 Hexagonal Wrench 4	1
6	3H-8		大螺丝批 Screw-driver, L	1
7	3H-7		中螺丝批 Screw-driver, M	1
8	3H-6		小螺丝批 Screw-driver, S	1
9	10-3		双头扳手 Wrench 12×14	1
10	8H-2		双头扳手 Wrench 8×10	1
11	8H-1		双头扳手 Wrench 6×7	1
12	D-8		镊子 Tweezers	1
13	14H-13		机针 Needle DV×59 24#	1
14	D-10		油壶 Oiler	1

# 300U 围边机

High Speed Flat Bed Chainstitch Machines

## 使用说明书

INSTRUCTION MANUAL



# 目 录

机器的种类 .....	4
安装 .....	6
润滑 .....	7
机针 .....	8
安装机针 .....	8
缝线 .....	8
缝纫机的穿线 .....	9
夹线 .....	10
速度 .....	10
压脚 .....	11
针距 .....	13
压紧杆提升 .....	14
牙架安装高度 .....	15
送料牙 .....	15
送料牙的正确安装高度 .....	16
抬牙凸轮的同步 .....	16
针杆位置 .....	16
弯针与机针的正确间隙的调整 .....	17
弯针传动曲柄的同步 .....	18
安装线环导向装置 .....	19
安装护针板 .....	19
安装叉针 .....	20
叉针的可变运动 .....	21
弯针挑线的调节 .....	21
针线挑线的调节 .....	22
针线松线的调节 .....	22

# CONTENTS

DESCRIPTON .....	5
INSTALLATION .....	6
LUBRICATION .....	7
NEEDLES .....	8
TO SET THE NEEDLE .....	8
THREAD .....	8
THREADING THE MACHINE .....	9
TENSION .....	10
SPEED .....	10
PRESSURE .....	11
STITCH LENGTH .....	13
PRESSER BAR LIFT .....	14
TO SET FEED BAR AT CORRECT NELGHT .....	15
CENTRALIZING FEED DOG .....	15
SETTING FEED DOG AT CORRECT HEIGHT .....	16
TIMING FEED LIFT ECCENTRIC .....	16
NEEDLE BAR POSITIONING .....	16
SETTING THE LOOPER AT CORRECT DISTANCE FROM NEEDLE .....	17
TIMING LOOPER DRIVING CRANK .....	18
POSITIONING LOOP DEFLECTORS .....	19
SETTING THE NEEDLE GUARDS .....	19
POSITIONING SPREADER .....	20
CHANGING MOVEMENT OF SPREADER .....	21
ADJUSTING LOOPER THREAD TAKE-UP .....	21
ADJUSTING NEEDLE NEEDLE THREAD TAKE-UP .....	22
ADJUSTING NEEDLE THREAD TENSION RELEASER .....	22

300U194缝纫机装配有防倒缝装置。

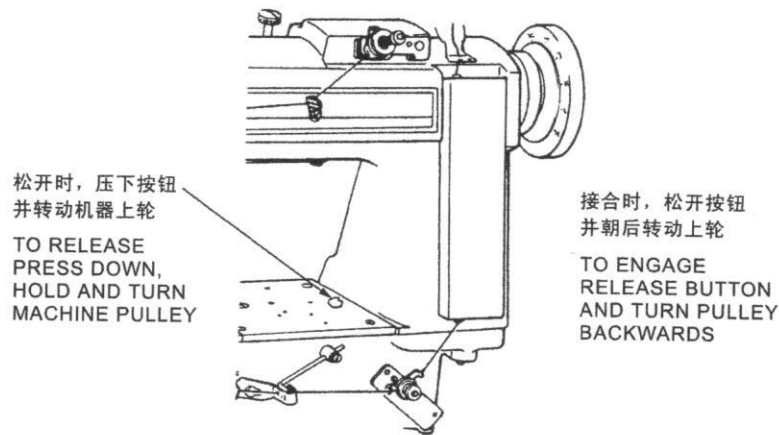
需要松开装置时，可压下位于底板上面靠右边的按钮，压住并前后转动机器上轮。

需要接合装置时，松开按钮并朝机器背后转动机器上轮直到装置“啮合”进入位置。

Machine 300U194, are equipped with an ANTI-REVEERSING device.

To release the device, depress button located on right side of bed plate, hold down and turn machine pulley either forward or backward.

To engage the device, release button and turn machine pulley toward rear of machine until device "snaps" into place.



### 300U缝纫机针送料和下送料的送料运动调节

针送料和下送料不仅要同时运动，而且送料距离必须一样。如果下送料的送料距离比针送料的送料距离大或小，可按下针距按钮并转动机器上轮，使下送料运动与针送料运动一致。两种送料的针距都可以重新调整，请参看第13页。

#### EQUALIZING THE FEEDING MOVEMENT OF THE NEEDLE FEED AND DROP FEED ON MACHINES OF CLASSE 300U

The needle feed and drop feed should not only be timed to move simultaneously, but should also move the same distance during feeding. If the drop feed moves a greater or lesser distance than the needle feed, depress the stitch length button and turn the machine pulley, as required, to cause the drop feed movement to equal the needle feed movement. The stitch length of both feeds can then be reset simultaneously, as described on page 13.



## 机器的种类

300U型缝纫机是一种高速、复合送料、双线链式线迹的缝纫机，适用于缝制中厚料及厚料。

这些缝纫机可用于如接缝、滚边、折边、搭接折缝等单线或多线的缝纫。适用于缝制裤、衣服、汽车装饰、帐篷、防水油布、椅套及多种其它产品上的凸边。

### 普通特征

由皮带传动的上轴前后装有滚珠轴承。

皮带传动下轴。

上下轴内带有大容量油池的半润滑系统润滑所有的主要轴承。

通过踏板操纵压脚杆升起压脚并释放针线张力。

机针右侧空位为10吋。

### 独有特征

#### 300U 101 缝纫机

单针和单弯针。

针距：4~12针/吋。

针杆行程：1-1/4吋。

压脚下空间：5/16吋。

#### 300U 103 缝纫机

单针和单弯针。

交替压脚。

针距：4~12针/吋。

针杆行程：1-1/4吋。

压脚下空间：1/4吋。

#### 300U 105 缝纫机

单针和单弯针。

由齿轮传动的牵拉送料。

针距：4~12针/吋。

针杆行程：1-1/4吋。

压脚下空间：5/16吋。

#### 300U 201 缝纫机

双针和双弯针。

针距：4~12针/吋。

针杆行程：1-1/4吋。

压脚下空间：5/16吋。

机针隔距：3/16~2吋，位移量是1/32吋。

标准隔距：3/16吋，1/4吋。

#### 300U 203 缝纫机

双针和双弯针。

交替压脚。

针杆行程：1-1/4吋。

针距：4~12针/吋。

压脚下空间：1/4吋。

机针隔距：3/16~1吋，位移量是1/32吋。

标准隔距：1/4吋。

#### 300U 205 缝纫机

双针和双弯针。

由齿轮传动的牵拉送料。

针距：4~12针/吋。

针杆行程：1-1/4吋。

压脚下空间：5/16吋。

机针隔距：3/4~2吋，位移量是1/32吋。

标准隔距：3/16吋，1/4吋。

#### 300U 401 缝纫机

四针和四弯针。

针距：4~12针/吋。

针杆行程：1-1/4吋。

压脚下空间：5/16吋。

机针隔距：3/4~2吋(机针外侧之间)。

标准隔距：1/4吋，1吋，1/4吋。

#### 300U 405 缝纫机

四针和四弯针。

由齿轮传动的牵拉送料。

针距：4~12针/吋。

针杆行程：1-1/4吋。

压脚下空间：5/16吋。

机针隔距：3/4~2吋(机针外侧之间)。

标准隔距：1/4吋，1吋，1/4吋。

#### 300U 194 缝纫机

单针和单弯针。

带气压控制的交替压脚。

针距：3-1/3~12针/吋。

针杆行程：1-7/16吋。

压脚下空间：7/16吋。

## DESCRIPTON

Machines of Class 300U ARE high speed, compound feed, two thread chainstitch machines designed for general stitching operations on materials of materials of medium and heavy weight.

These machines are available for single and multiple stitching operations such as seaming, binding, welting, lap seam felling, etc. They perform outstanding work on trousers, work clothing, automotive upholstery, tents, tarpaulins, seat covers and a variety of other products.

### General Characteristics

Belt driven arm shaft mounted in front and rear ball bearings.  
Belt driven bed shaft.

Semi-automatic lubricating system with large capacity oil reservoir in upper and lower shafts lubricates all principal bearings.

Presser foot is raised by a treadle operated foot lifter which also release the needle thread tension.

Space at right of needle, 10 inches.

### Special Features

#### Machine 300U 101

One needle and one looper.

Stitch length, 4 to 12 per inch.

Needle bar stroke, 1-1/4 inches.

Clearance under presser foot, 5/16 inch.

#### Machine 300U 103

One needle and one looper.

Alternating pressers.

Stitch length, 4 to 12 per inch.

Needle bar stroke, 1-1/4 inches.

Clearance under presser foot, 1/4 inch.

#### Machine 300U 105

One needle and one looper.

Gear driven Puller Feed.

Stitch length, 4 to 12 per inch.

Needle bar stroke, 1-1/4 inches.

Clearance under presser foot, 5/16 inch.

#### Machine 300U 201

Tow needles and tow loopers.

Stitch length, 4 to 12 per inch.

Needle bar stroke, 1-1/4 inches.

Clearance under presser foot, 5/16 inch.

Gauges (Needle Spacing): 3/16 inch to 2 inches in steps of 1/32 inch.

Satandard gauges, 3/16 inch, 1/4 inch

#### Machine 300U203

Tow needles and tow loopers.

Alternating presser.

Needle bar stroke, 1-1/4 inches.

Stitch length, 4 to 12 per inch.

Needle bar stroke, 1-1/4 inches.

Clearance under presser foot, 1/4inch.

Gauges (Needle Spacing): 3/16 inch to 1 inches in steps of 1/32 inch.

Standard gauges, 1/4 inch.

#### Machine 300U205

Tow needles and tow loopers.

Gear driven Puller Feed.

Needle bar stroke, 1-1/4 inches.

Clearance under presser foot, 5/16 inch.

Gauges (Needle Spacing): 3/16 inch to 2 inches in steps of 1/32.

Standard gauges, 3/16 inch , 1/4 inch.

#### Machine 300U401

Four needles and four loopers.

Stitch length, 4 to 12 per inch.

Needle bar stroke, 1-1/4 inches.

Clearance under presser foot, 5/16 inch.

Gauges (Needle Spacing): 3/16 inch to 2 inches between outside needles.

Standard gauges, 1/4 inch-1 inch - 1/4 inch.

#### Machine 300U405

Four needles and four loopers.

Gear driven Puller Feed.

Stitch length, 4 to 12 per inch.

Needle bar stroke, 1-1/4 inches.

Clearance under presser foot, 5/16 inch.

Gauges (Needle Spacing): 3/16 inch to 2 inches between outside needles.

Standard gauges, 1/4 inch-1 inch - 1/4 inch.

#### Machine 300U194

One needle and one looper.

Alternating presser with pneumatic pressure control.

Stitch length, 3 - 1/3 to 12.

Needle bar stroke, 1-7/16 inches.

Clearance under presser foot, 7/16 inch.

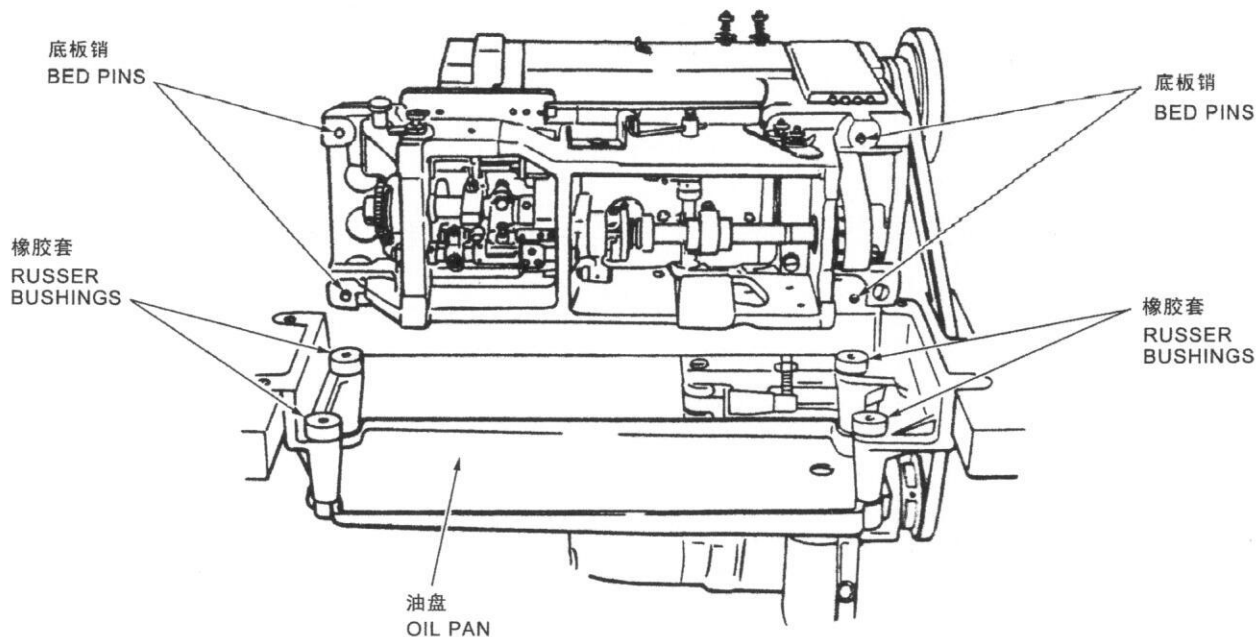


图 2 / Fig.2

### 安装 / INSTALLATION

将油盘装在支承架上，放进机器工作抬板的开口处，在支承架的孔内放置四个橡胶套(图2)。在油盘上装上滴油瓶(图3)。

将缝纫机置于油盘上，四个底板销插进四个橡胶套(图2)。

用配备的链条连接压脚提升杆与压脚提升踏板。

Assemble oil pan to hangers. Insert assembled oil pan into machine cut-out of table placing four rubber bushings in hanger holes as shown in Fig. 2. Attach oil drain jar to oil pan as shown in Fig. 3.

Place machine on oil pan assembly with the four bed pins passing through the four rubber bushings shown in Fig. 2.

Connect foot lifter treadle to foot lifter lever, Fig. 4, at back of machine by chain furnished for this purpose.

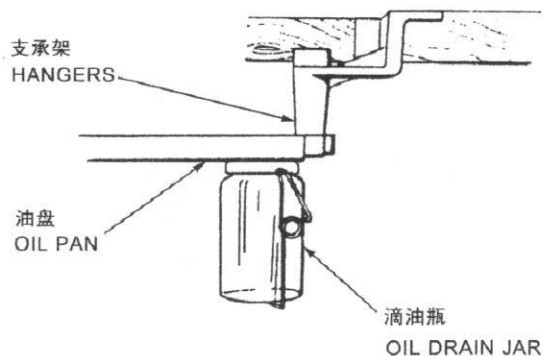


图 3 / Fig.3

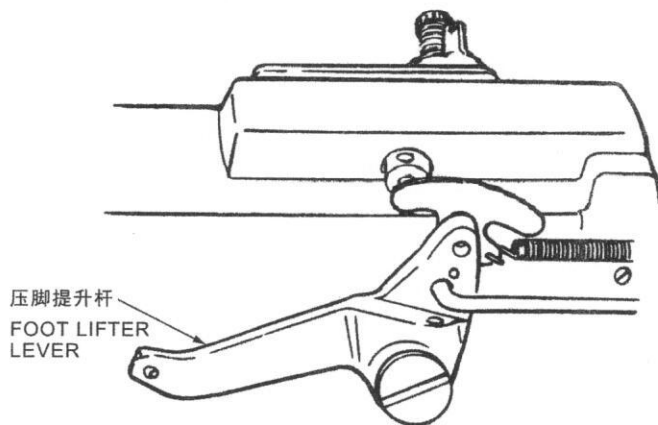


图 4 / Fig.4



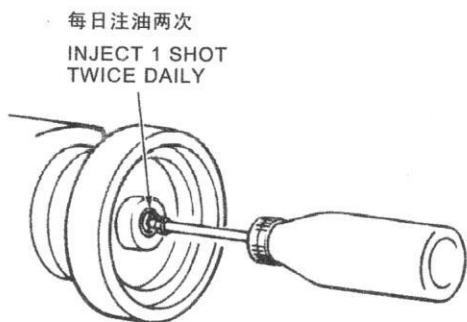


图 5 / Fig.5

**CAUTION:** Use stainless water-white straight mineral oil.

Do not use additives in sewing machine oil as they may cause a reduction in the normal flow of oil that can result in damage to the machine.

**BEFORE STARTING** machine, the machine must be oiled as instructed. Failure to do this will result in damage to the machine.

Pressure Oil Can, furnished with the machine, is to be used to oil all points requiring lubrication.

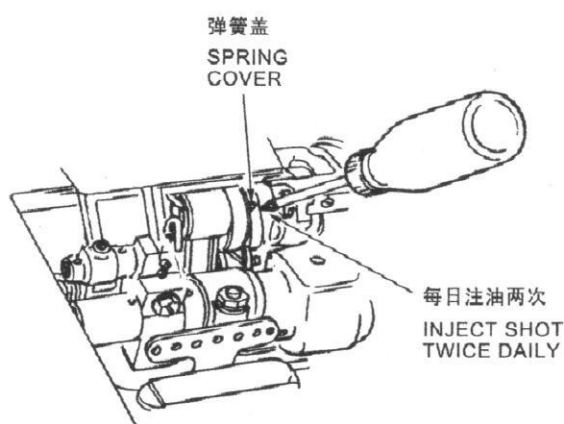


图 6 / Fig.6

Apply oil to all work plate and arm oil holes, needle bar bearings and connections, needle bar rock frame bearings, looper rocker sleeve and presser lifting mechanism.

**CAUTION:** For machines in continuous use, all oiling points must be oiled daily. Occasionally oil tension release mechanism and looper pull-out rack.

## 润滑 / LUBRICATION

300U 缝纫机具有一套由空心上轴和空心下轴组成的自动润滑系统，两空心轴的作用是担当油池。机器开动时，润滑油通过轴上的小喷口在离心力的作用下分散到各个主要轴承。一些自动润滑系统润滑不到的运动部件可用手工注油。

请使用优质白矿油。

缝纫机润滑油里请不要使用添加剂，因为添加剂可能引起润滑油标准流量的减少，导致机器的损坏。

开机前，缝纫机必须加油，否则会导致机器的损坏。

随机配有压力油壶，可用于所有需要润滑的位置。

Machines of Class 300U have a semi-automatic lubricating system comprising a hollow arm shaft and a hollow bed shaft which act as oil reservoirs. The oil is distributed to all of the principal bearings by centrifugal force through small jets in the shafts when the machine is in operation. Provision is also made for hand lubricating other movable parts which are not lubricated from the reservoirs.

### 上轴的润滑 / TO OIL ARM SHAFT

每日两次在上轴孔插入压力油壶喷嘴，向上轴油池注油。

To fill bed shaft reservoir, insert spout of pressure oil can in hole, Fig. 5, and inject 1 shot of oil into shaft twice daily.

### 下轴的润滑 / TO OIL BED SHAFT

向左推开弹簧盖(图6)，每日两次在下轴孔插入压力油壶喷嘴，向下轴油池注油。关闭油孔弹簧盖。

注：也可以从机器的右手边向下轴加油。

To fill bed shaft reservoir, push spring cover, Fig 6, to the left, insert spout of pressure oil can into hole and inject 1 shot of oil into shaft twice daily. Close oil hole spring cover.

**NOTE:** Bed shaft may also be oiled from right hand end of machine.

### 其它的润滑点 / OTHER OILING POINTS

需加油到工作面板和机壳上的所有油孔、针杆轴承和各个连接点、针杆摇架轴承、弯针摇杆轴套和压脚提升机构。

注意：一台连续使用的缝纫机，每天必须对各个加油点加油。松线机构和弯针摆动架只需偶尔加油。

## 机针 / NEEDLES

300U101、300U105、300U201、300U205、300401  
和300U405缝纫机：

使用CAT.3260 (62×57) 机针

厚重缝料也可使用CAT.4112 (62×59) 机针，但针杆必须调整 (13页)。

300U103、300U203和300U194缝纫机：

中厚缝料使用CAT.4112 (62×59) 机针

中薄缝料使用CAT.3260 (62×57) 机针

所用机针的规格由缝线的粗细确定，缝线必须自由地通过机针针眼。

机针的订购应详细说明所需数量、规格号以及机针件号。

## 安装机针 / TO SET THE NEEDLE

向操作者方向转动上轮直到针杆移动到最高点。(图7)

单针缝纫机松开机针紧定螺钉，双针缝纫机松开针夹螺钉。(图7)

将机针向上插入针杆或针夹，使各针的缺口朝向左。(图7)

Turn machine pulley over toward the operator until the needle bar is at its highest point, as shown in Fig. 7.

Loosen needle set screw on single needle machines or needle clamping screws on multiple needle machines, as shown in Fig. 7.

Insert needle into needle bar or clamp as far as it will go making certain that the scarf of each needle faces toward the left, as shown in Fig. 7.

Machines 300U101, 300U105, 300U201, 300U205, 300U401 and 300U405:

Use SINGER\*Needles, Catalog 3260 (62X57)

For heavier weight material, needle Catalog 4112 (62X59) may also be used. In this case, the needle bar must be adjust as insructed on page 13.

Machines 300U103, 300U203 and 300U194:

Use SINGER\* Needles, Catalog 4112 (62X59) for medium heavy work or Catalog 3260 (62X57) for medium light work.

The size of the needle to be used is determined by the size of the thread which must pass freely through the eye of the needle.

Orders for needles should specify quantity required, size number and catalog number.

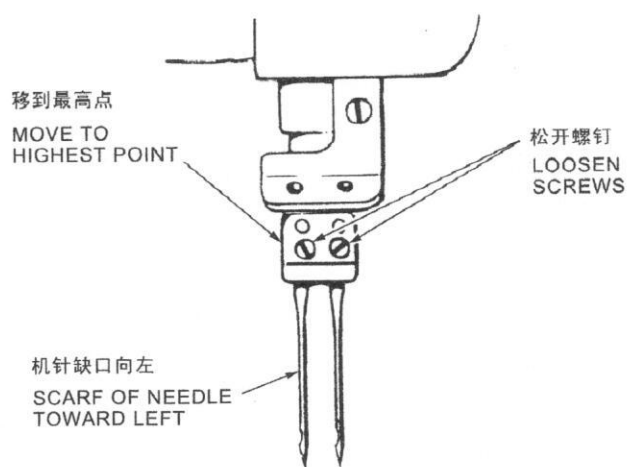
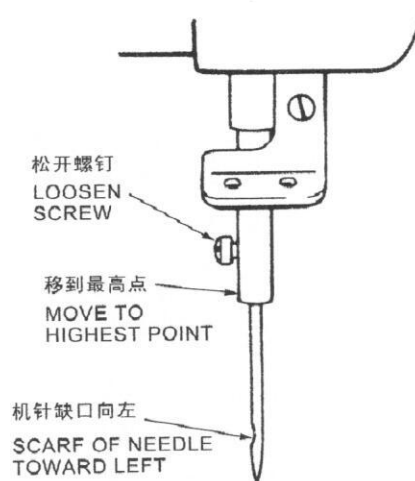


图 7 / Fig.7

## 缝线 / THREAD

机针和弯针可任意使用左旋或右旋的缝线。

粗糙和不均匀的缝线难于通过机针针眼，干扰了缝纫机的正常运转。

Either left twist or right twist thread may be used in the needles and loopers.

Rough or uneven thread, or thread which passes through the needle eye with difficulty will interfere with successful operation of the machine.



## 缝纫机的穿线 / THREADING THE MACHINE

### 穿面线 / Upper threading

向操作者方向转动上轮直到针杆在最高位置。

按图8所示的穿线点穿线。

穿过针眼的缝线拉出大约2吋，开始缝纫。

单针和双针缝纫机的穿线都按图8所示，每条线都要通过夹线装置。

300U缝纫机装有交替压脚，机壳的前面带有缝线润滑器，面线必须通过润滑器。

Turn machine pulley over toward operator until needle bar is at its highest point.

Pass thread from unwinder through threading points indicated in Fig. 8. for correct threading of needle.

Draw approximately two inches of thread through needle eye which to start sewing.

Single and multiple needle machines are all threaded as shown in Fig. 8. Make certain that each thread passes through thread tension device.

Machines of Class 300U having Alternating Pressers are equipped with a thread lubricator on front of the arm. The needle thread must pass through the lubricator.

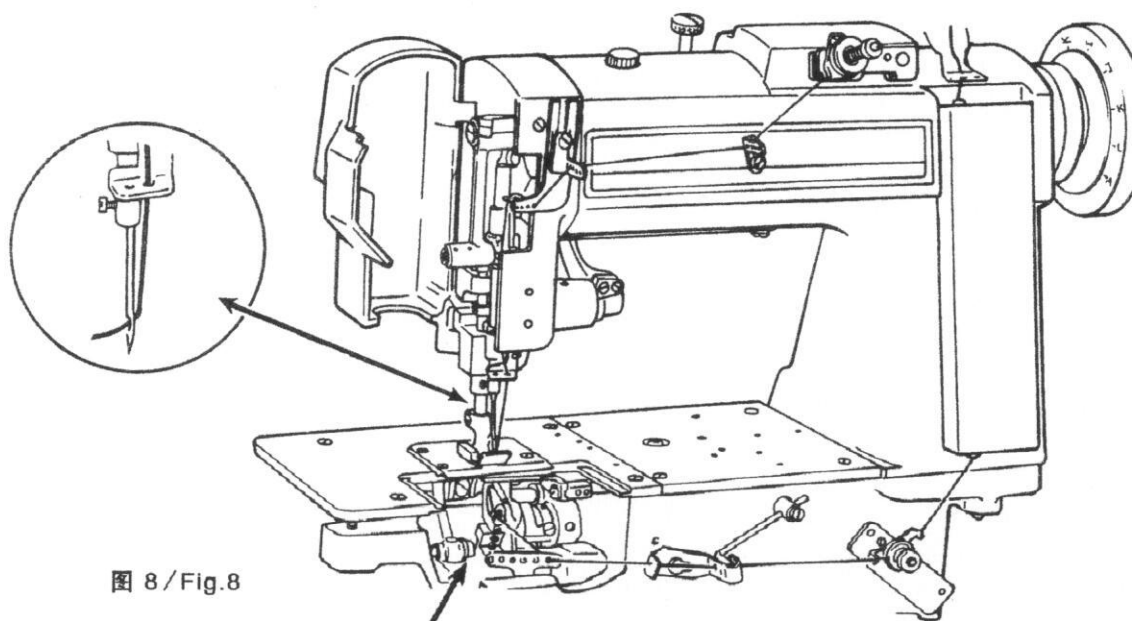
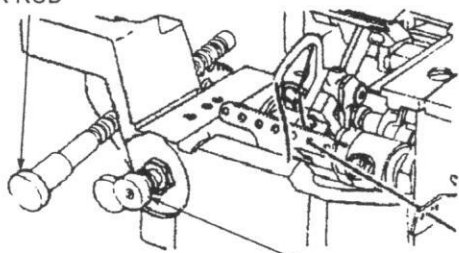


图 8 / Fig.8

弯针摆动架螺杆

LOOPER THROW-OUT  
RACK ROD



弯针摆动机构锁紧销

LOOPER THROW-OUT  
GEAR LOCKING PLUNGER ROD

### 穿底线 / Lower Threading

打开前面板缺口，移开推板并朝操作者转动上轮，直到针杆移到最高点。

通过拉开弯针摆动机构锁紧销和弯针摆动架螺杆把弯针移出缝纫位置之外，越远越好。这样才能更容易穿线并防止发生意外。

Open front table section, remove bed slide and turn machine pulley over toward operator until needle bar is at its highest point.

Move loopers out of sewing position by pulling looper throw-out gear locking plunger rod and looper throw-out rack rod, Fig. 8, out as far as possible. This will place loopers in position for easier threading and prevent accidental operation of machine until loopers are returned to sewing position.

### 弯针穿线 / Threading The loopers

按图示的穿线点穿线。穿过弯针眼的缝线拉出大约2吋，开始缝纫。

Pass thread from unwinder through threading points as indicated. Draw approximately two inches of thread through looper eye with which to start sewing.



## 夹线 / TENSION

在保证缝料上的线迹恰当的前提下，缝线的张力应尽可能小。

Tension on thread should be light as possible while still sufficient to set the stitch correctly in material.

### 面线张力 / Needle Thread Tension

需要调整面线张力时，可参照图9所示按需要转动指旋螺母。

**注意：**只能当压脚在下面时，才能调整面线张力。

To regulate needle thread tension, turn thumb screw, indicated in Fig. 9, as may be required.

**IMPORTANT:** Regulate needle thread tension only when presser foot is down.

### 弯针线张力 / Looper Thread Tension

需要调整弯针线张力时，可参照图10所示按需要转动指旋螺母。

To regulate looper thread tension, turn thumb screws, as indicated in Fig. 10, as may be required.

## 速度 / SPEED

300U103、300U194和300U203缝纫机的最高缝速是4000针/分钟。

一台新的缝纫机开机头100小时可选用比最高缝速少500针/分钟的缝速。

最高的经济缝速取决于作业的种类、操作者的能力、缝料的类型。

300U101、300U105、300U201、300U205、300U401和300U405缝纫机的最高缝速是4500针/分钟。

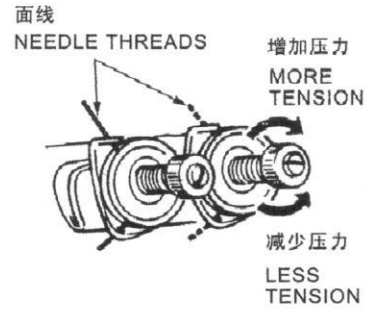


图 9 / Fig.9

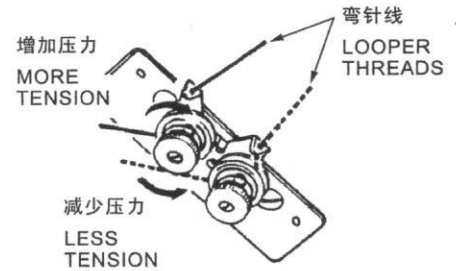


图 10 / Fig.10

Maximum speed for machines 300U103, 300U194 and 300U203 is 4000 stitches per minute.

It is advisable to operate new machines at a speed of 500 stitches less than maximum for the first 100 hours of operation.

Maximum efficient speed is determined upon the nature of the operation, the ability of the operator and the type of material being sewn.

Maximum speed for Mahines 300U101, 300U105, 300U201, 300U205, 300U401 and 300U405 is 4500 stitches per minute.

## 压脚 / PRESSURE

在确保正常送料的前提下，缝料的压力应尽可能轻。

Pressure on material should be as light as possible while still sufficient to insure correct feeding.

### 压脚压力 / Pressure Foot Pressure

为了调节压脚压力，如图11所示松开锁紧螺钉，向里旋转指旋螺钉增加压力；向外旋转指旋螺钉减少压力，调节完毕后重新拧紧锁紧螺钉。

To regulate presser foot pressure, loosen lock screw, Fig. 11, at rear of machine. Tighten thumb screw to increase pressure; loosen to decrease pressure. When correct feeding pressure is attained, tighten lock screw.

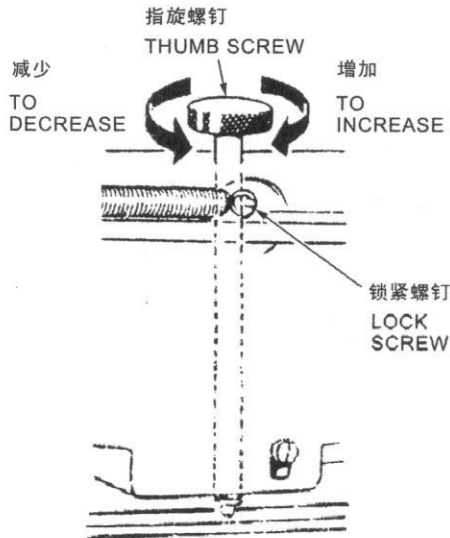


图 11 / Fig.11

### 交替压脚 / Alternating Pressers:

需要增加压力时，松开下锁紧螺母和锁紧螺钉，然后拧紧上锁紧螺母，调整完毕后拧紧锁紧螺钉，然后拧紧下锁紧螺母。需要减少压力时，松开上锁紧螺母和锁紧螺钉，然后拧紧下锁紧螺母，调整完毕后拧紧锁紧螺钉，然后拧紧上锁紧螺母。

To increase pressure, loosen lower lock nut and loosen lock screw, then tighten upper lock nut, see Fig. 12. When correct pressure is attained, tighten lock screw. Then tighten the lower lock nut. To decrease pressure, loosen upper lock nut and loosen lock screw, then tighten lower lock nut. When correct pressure is attained, tighten lock screw. Then tighten the upper lock nut.

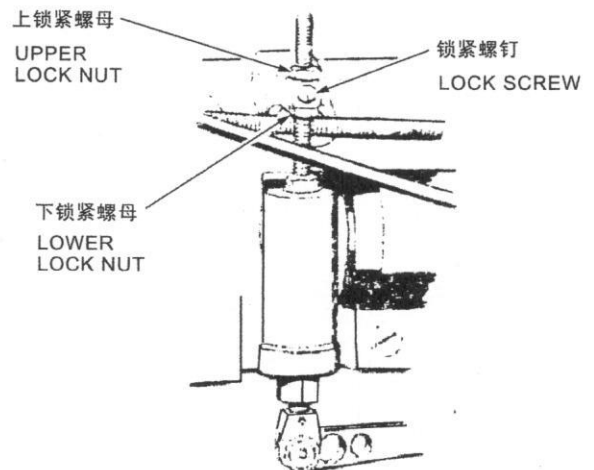


图 12 / Fig.12

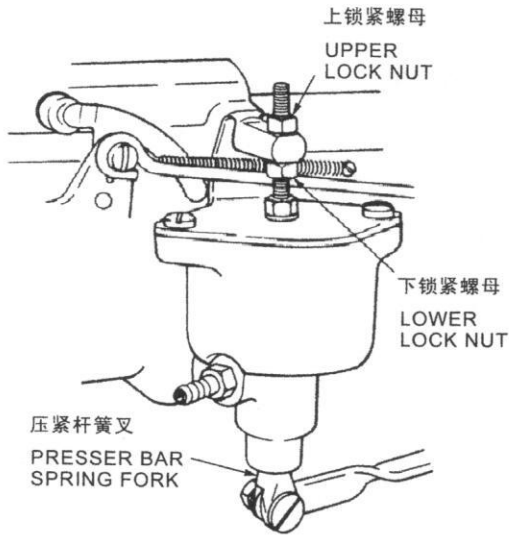


图 13 / Fig.13

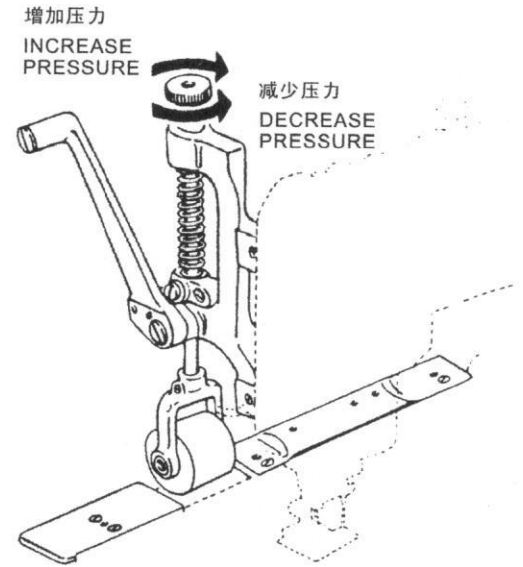


图 14 / Fig.14

#### 带气压控制器的交替压脚

#### Alternating Presser with Pneumatic Pressure Control:

当压脚搁在针板上时才可以调节压力气缸的高度。压紧杆簧叉和气缸底部要有1/4吋的间隙。需要升高气缸可松开下锁紧螺母并拧紧上锁紧螺母(图13)；需要降低气缸可松开上锁紧螺母并拧紧下锁紧螺母。调整完毕，拧紧两锁紧螺母。

当压紧杆簧叉升起离气缸底部1/16吋时，正确的空气压力应使送料均匀。

Adjust height of Pressure Cylinder with presser feet resting on throat plate. There should be a clearance of 1/4 inch between the Presser Bar Spring Fork and the bottom of the cylinder. To raise cylinder, loosen lower lock nut and tighten upper lock nut, see Fig. 13. To lower cylinder, loosen upper lock nut and tighten lower lock nut. When correct adjustment is attained, tighten both lock nuts.

Regulate air pressure. The correct air pressure is set for average feeding when the Presser Bar Spring Fork rises to approximately 1/16 inch from the bottom of the cylinder.

#### 上送料滚轮的压力 / Upper Feed Roll Pressure

上送料滚轮的压力调节可转动指旋螺钉(图14)。

To regulate pressure of the upper feed roll, turn thumb screw as shown in Fig. 14.



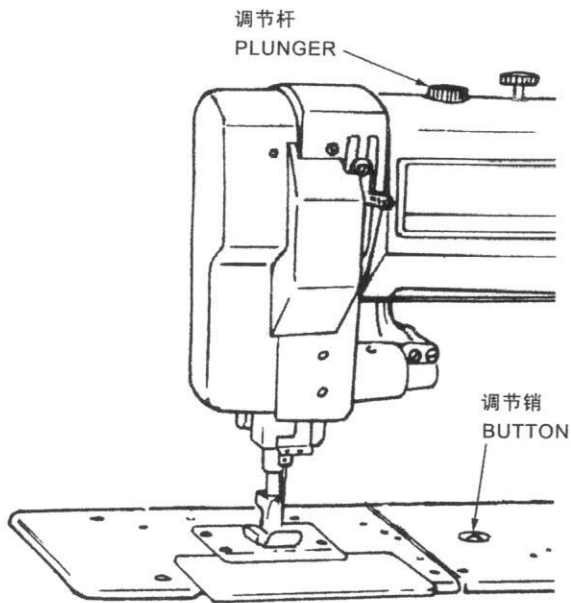


图 15 / Fig.15

**CAUTION:** Never turn machine pulley with plunger in locked position until button on machine bed is depressed.

## 针距 / STITCH LENGTH

需要调节针距时，可压下位于机壳顶部的调节杆(图 15)，用手继续压住调节杆并向操作者方向转动缝纫机上轮，直到调节杆落入装在上轴的偏心调节盘的凹槽内，然后将调节杆转到锁紧位置。压下位于底板面上的调节销，用手压住并向操作者方向转动上轮增加针距；背向操作者方向转动上轮减少针距。上轮上的字母“A”代表针距最长，所需的针距都用字母表示。缝纫机前面的箭头指向所需字母时，放开调节销，左右转动调节杆直到调节销弹出。

**注意：**当调节杆在锁紧位置时，千万不要转动上轮，直到压下底板面板上的调节销。

To adjust the stitch length, depress plunger, Fig. 16, located on top of arm. Continue to hold plunger down and turn machine pulley toward operator until plunger enters notch in arm shaft eccentric. Then turn plunger to lock in position. Depress button, Fig. 15, located on machine bed. Hold down, and turn machine pulley toward operator to increase length of stitch, or away from operator to decrease length of stitch. Letter "A" on machine pulley indicates the longest stitch. When desired length, indicated by letter, is opposite arrow on front of machine, release button and turn plunger to right or left until it springs outward.

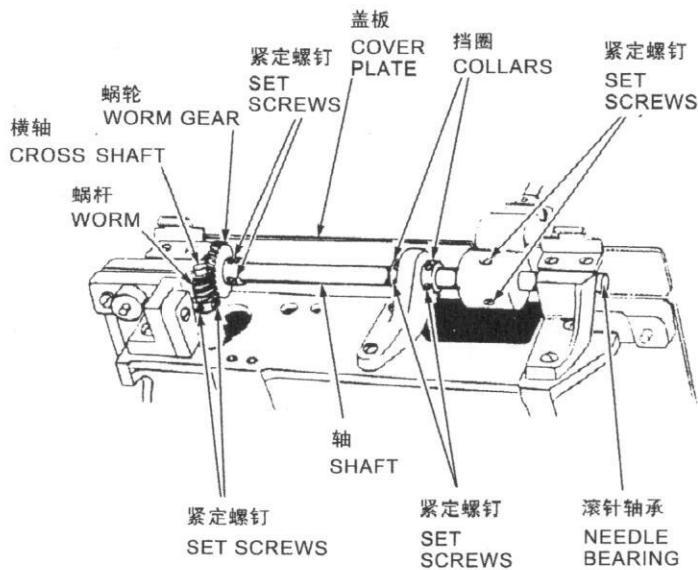


图 16 / Fig.16

The length of the stitch is determined by the stitch gears in the puller feed mechanism. The compound feed stitch length should be set slightly shorter than the stitch length of the puller feed.

To change Puller Feed gears for adjusting stitch length, remove the two cover plate screws and remove cover plate, Fig. 16. Loosen set screws. Slide puller feed shaft to the right far enough to allow removal of worm and worm gear. Place the new worm on cross shaft. Turn worm in the operating direction and tighten the first set screw into the

## 后拖辘送料缝纫机 / Machine with Puller Feed

针距由后拖辘送料机构内的线迹齿轮决定。复合送料的针距比后拖辘送料的针距稍短。

调节针距需更换后拖辘送料齿轮，拧下两颗盖板螺钉拆下盖板(图16)。松开紧定螺钉，将后拖辘送料轴往右移到足以卸下蜗杆和蜗轮。将新的蜗杆装到横轴上，按运转方向转动蜗杆并将第一颗螺钉拧进轴的扁位，然后小心地拧紧两颗螺钉并控制端部间隙。将新的蜗轮与蜗杆啮合并把后拖辘送料轴滑进蜗轮直到轴端与滚针轴承平齐。通过紧靠支架安装两个挡圈来消除轴向窜动，拧紧四颗紧定螺钉。对齐上、下送料滚轮并拧紧两颗紧定螺钉。蜗杆的中心在蜗轮中心线上，拧紧两颗紧定螺钉并使第一颗紧定螺钉落入轴的键槽内。重新装上盖板并调整复合送料。

flat of the shaft. then securely tighten both set screws, checking for excessive end play. Engage the new worm gear with the worm and slide puller feed shaft through the worm gear until the end of the shaft is flush with the needle bearing. Remove end play in the shaft by setting the two collars against the bracket and tightening the four set screws. Align the lower feed roll with the upper feed roll and tighten the two set screws. Center the worm gear on the center of the worm. Tighten the two set screws with the first screw in the spline of the shaft. Replace cover plate and adjust the compound feed.

## 压紧杆提升 / PRESSER BAR LIFT

当压脚通过压脚提升杆抬起时，针杆在最高位置，针尖应不会突出压脚底面。

调整时，向操作者方向转动上轮直到机针在最高位置，松开紧定螺钉(图17)，将压脚升起到正确高度。紧靠上支承装上限位挡圈并拧紧螺钉。

When the presser foot is raised by the presser bar lifter and the needle is at its highest position, the point of the needle should not protrude below the presser foot.

To adjust, turn machine pulley over toward operator until needle is at its highest position. Loosen set screw, Fig. 17. Raise presser foot to the correct height, place stop collar against upper bracket, and tighten the set screw.

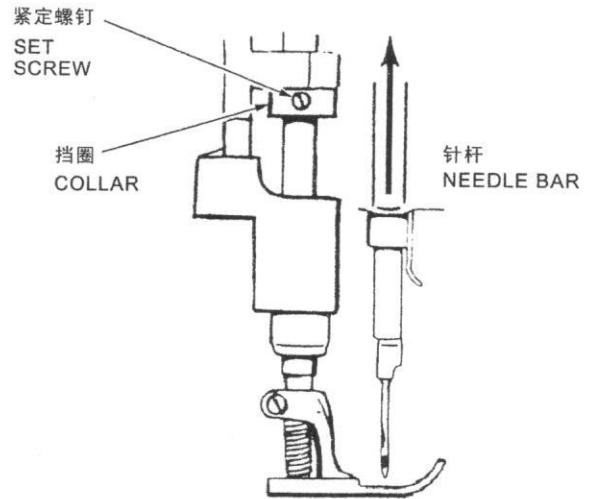


图 17 / Fig.17

## 带交替压脚的缝纫机

### Machines with Alternating pressers

摆动压脚和提升压脚的升降由一个可调偏心轮来控制。需要调整时，拆下缝纫机背后的机壳盖板，朝操作者方向转动机器上轮直到压紧升降杆下降，松开两颗锁紧螺钉(图18)和两颗夹紧螺钉，插入螺丝刀到调节盘凹槽内并如图示转动机器上轮。拧紧两颗夹紧螺钉和两颗锁紧螺钉。

当需要一只压脚比另一只压脚升高点时，可朝操作者方向转动机器上轮直到提升压脚在最高点，松开两颗夹紧螺钉(图19)，并上下转动提升摆轴曲柄直到每只压脚达到所需要求。然后拧紧两颗夹紧螺钉。

注意：在适合产品所需的前提下限制压脚的升降量最小，这样有利于缝速的提高。

The lift of the vibrating and lifting pressers is controlled by an adjustable eccentric. To adjust, remove arm cover at rear of machine. Turn machine pulley over toward operator until feeding presser is down. Loosen the two lock screws, Fig. 18, and the two clamp screws. Insert screw driver into notch of adjusting disc, and turn machine pulley as indicated in Fig. 18. Then tighten the two clamp screws and the two lock screws.

When it is desirable to have either one of the pressers lift higher than the other, turn machine pulley over toward operator until the lifting presser is at its highest position. Loosen the two clamp screws, Fig. 19, and turn lifting rock shaft crank up or down until desired lift of each presser is attained. Then tighten the two clamp screws.

**CAUTION:** Limit lift of pressers to minimum required for the work, as this permits higher speeds.

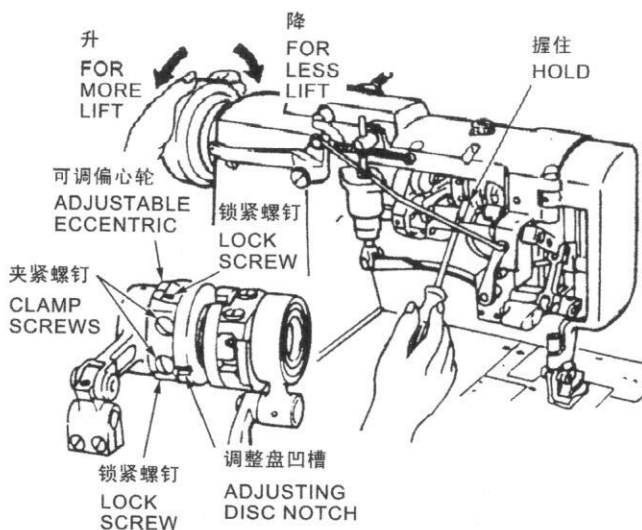


图 18 / Fig.18

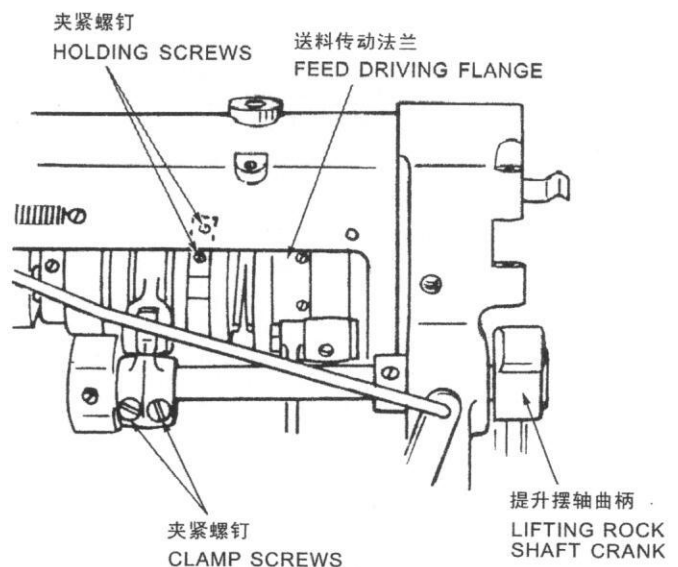


图 19 / Fig.19



The vibrating presser should be timed so that under normal sewing conditions, the presser foot will seat on the material at approximately the same time the needle enters material. This timing can be advanced or retarded slightly depending on the type of operation being performed, such as sewing over seams. To adjust, loosen two holding screws, Fig. 19, not more than one half turn. Then turn the adjustable eccentric, Fig. 18, until the vibrating presser seats at the correct time. Securely tighten the two holding screws after adjustment is made.

在正常缝纫条件下摆动压脚的同步应是：大约压脚压住缝料的同时机针插入缝料，这个时间因操作类型的不同可能会稍微提前或延迟，如包缝。调整时，松开两颗夹紧螺钉(图19)，至多转动一半，然后转动可调偏心轮(图18)，直到摆动压脚正确同步。调整后小心地拧紧两颗夹紧螺钉。

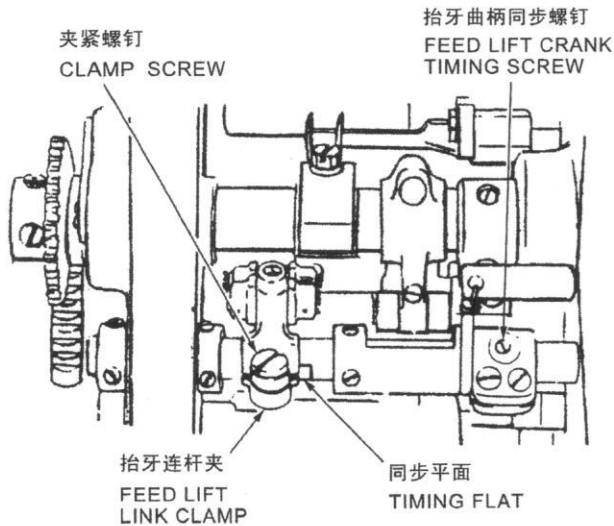


图 20 / Fig.20

### 牙架安装高度

#### TO SET FEED BAR AT CORRECT HEIGHT

送料杆安装高度正确时，抬牙连杆夹与摆轴上的同步扁位同一直线。调整时，先确认抬牙曲柄同步螺钉(图20)接合位置正确，然后松开夹紧螺钉并将抬牙连杆夹移至正确位置，锁紧夹紧螺钉。

When the feed bar is set at the correct height, the feed lift link clamp will be aligned with the rock shaft timing flat. To adjust, make certain that the feed lifting crank timing screw, Fig. 20, engages shaft spot correctly. Loosen clamp screw and move the feed lift clamp link to correct position. Then tighten clamp screw.

### 送料牙 / CENTRALIZING FEED DOG

#### 横向调整 / Sidewise Setting

机针进入送料牙的机针孔时与孔的左右两边之间的间隙应该一样。需要调整时，松开送料牙螺钉(图21)，移动送料牙直到机针在孔中的间隙正确，然后锁紧送料牙螺钉。

如果需要作另外的调整，可松开4个摆轴挡圈螺钉、2个摆轴曲柄夹紧螺钉(图21)和抬牙夹紧螺钉(图20)，移动全部组件到需要的位置并锁紧各个螺钉。

Needle should enter needle hole of feed dog with the same clearance between the needle and left or right side of hole. To adjust, loosen feed dog screws, Fig. 21. Move feed dog until correct clearance is attained. Hold in position, and tighten feed dog screws.

Additional adjustment, if necessary, may be attained by loosening the four rock shaft collar set screws, the two rock shaft crank clamp screws, Fig. 21, and feed lifting clamp screw, Fig. 20. Move complete assembly to required position and tighten screws.

#### 纵向调整 / Lengthwise Setting

送料牙在送料行程的两个端点与针板上的送料槽的两端的空隙应相等。需要调整时，确定所需的针距，松开2个摆轴曲柄夹紧螺钉(图21)，向前或向后移动送料摇杆直到获得正确的位置，然后锁紧2个夹紧螺钉。

The feed dog should clear the ends of the feed slots in the throat plate equally at both ends feed travel. To adjust, set feed for desired stitch length. Loosen the two rock shaft crank clamp screws, Fig. 21. Move feed rocker forward or backward until correct positioning is attained. Then tighten the two clamp screws.

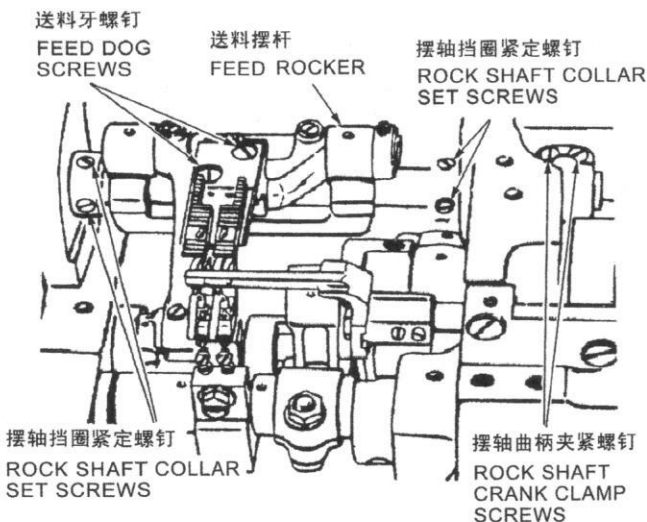


图 21 / Fig.21



### 送料牙的正确安装高度

#### SETTING FEED DOG AT CORRECT HEIGHT

当送料牙的高度安装正确时，送料牙的牙齿大约全部凸出针板上面。需要调整时，松开锁紧螺母(图22)，稍拧松送料牙夹紧螺钉。顺时针转动调节螺钉升高送料牙；逆时针转动调节螺钉并轻打送料牙使之降低。调整正确后拧紧夹紧螺钉和锁紧螺母。

When the feed dog height is set correctly, approximately the full depth of the teeth will show above the throat plate. To adjust, loosen lock nuts, Fig. 22, and slightly loosen feed dog clamping screw. To raise feed dog turn jack screw clockwise; to lower turn jack screw counter-clockwise and tap feed dog down. When correct setting is attained, tighten the clamping screws and lock nuts.

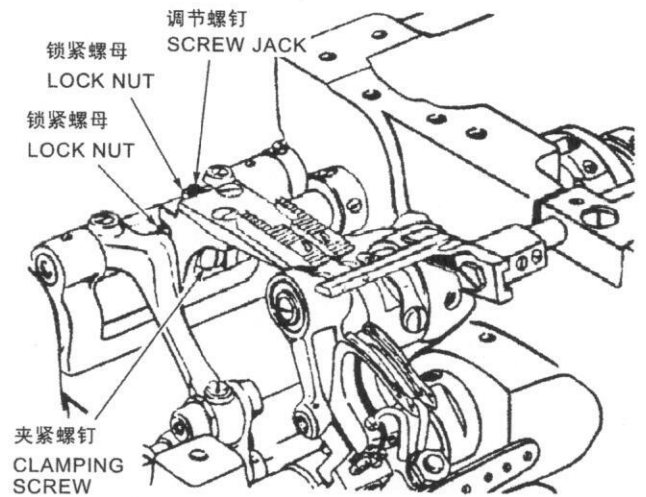


图 22 / Fig.22

### 抬牙凸轮的同步 / TIMING FEED LIFT ECCENTRIC

送料牙在最高位置时，牙齿的顶面与针板面平行，整个牙齿凸出针板表面上方。需要调节时，从抬牙连杆上的孔插入螺丝刀，松开2个紧定螺钉(图23)，向前移动抬牙凸轮使之比送料牙早升高，向后移动抬牙凸轮使之比送料牙迟升高。然后拧紧2个紧定螺钉。

When the feed dog is at its highest position, the top of the teeth should be parallel with, and project full depth of teeth above upper surface of throat plate. To adjust, insert screwdriver in hole in feed strap and loosen the two set screws, Fig. 23. Move feed lift eccentric forward for earlier rise of feed dog, or backwards for later rise. Then tighten the two screws.

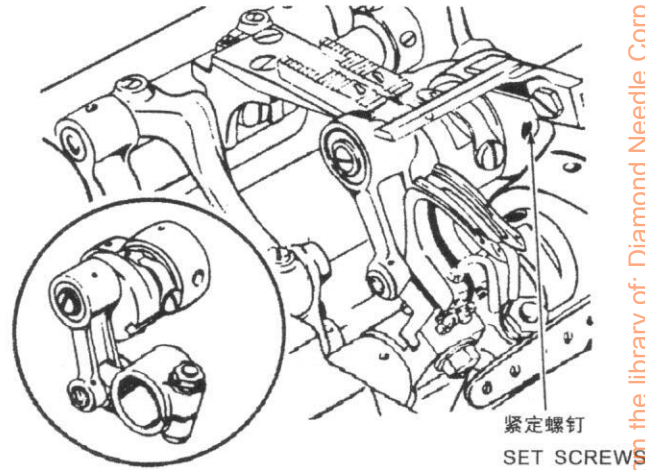


图 23 / Fig.23

### 针杆位置 / NEEDLE BAR POSITIONING

机针向前进入送料牙针孔时，机针的前端与针孔周边的间隙大约相等。需要调整时，将针杆摇架(图24)压靠在传动杆上，同时松开2个传动杆夹紧螺钉，继续保持摇杆靠着传动杆，移动针杆到正确位置并锁紧2个夹紧螺钉。

Needles should enter needle holes of feed dog toward the front with approximately the same clearance between the front of the needles and the needle holes as at the side. To adjust, press needle bar rock frame, Fig. 24, against drive arm, and at the same time loosen the two driving arm clamp screws. Continue holding the rock frame against the drive arm, move needle bar to correct position and tighten the two clamp screws.

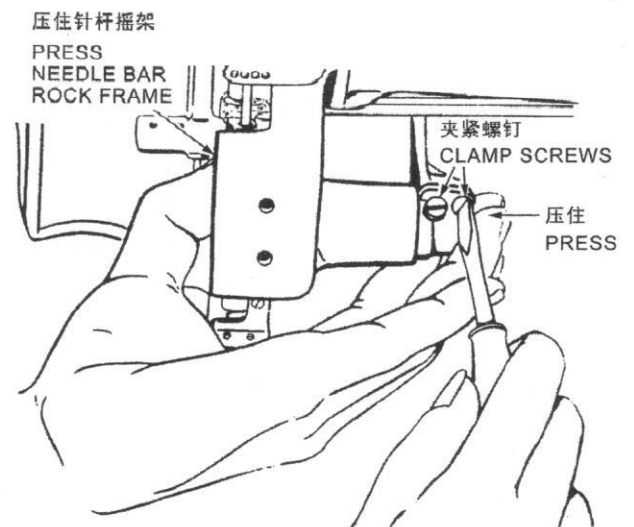


图 24 / Fig.24

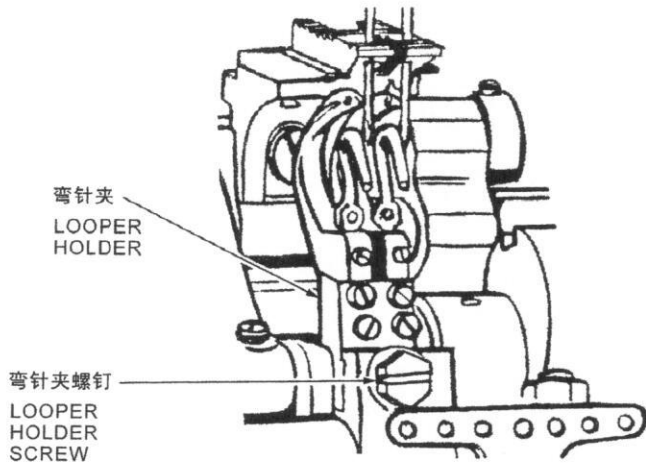


图 25 / Fig.25

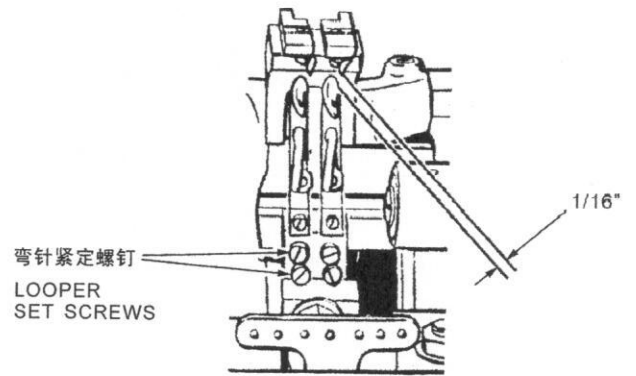


图 26 / Fig.26

### 弯针与机针的正确间隙的调整 SETTING THE LOOPER AT CORRECT DISTANCE FROM NEEDLE

#### 横向调整 / Sidewise Setting

弯针位置正确时，在弯针向前行程弯针尖刚好掠过针槽。需要调整时，转动机器上轮直到弯针尖到达机针中心，松开弯针夹螺钉(图25)并左右轻打弯针夹直到获得正确地间隙。然后锁紧弯针夹螺钉。

将弯针移到最前位置，检测弯针后根与线环导向装置之间的间隙应为约1/16吋。需要调整时，松开2个弯针紧定螺钉，左右转动弯针直到获得正确的间隙，保持在这一位置小心的锁紧2个紧定螺钉。

**注意：**在单针和多针缝纫机上，必须使每一个弯针尖都刚好掠过其各自的机针针槽。需要调整时，使弯针转到机针中心，松开2个紧定螺钉(图26)，稍微左右转动弯针，然后锁紧紧定螺钉。

When the looper is correctly positioned, the point of the looper just clears the scarf of the needle on the forward stroke of the looper. To adjust, turn machine pulley until the looper point is directly opposite the center of the needle. Loosen looper holder screw, Fig. 25, and tap holder to left or right until correct clearance is attained. Then securely tighten the looper holder screw.

Move looper to extreme forward position. Check clearance between heel of looper and loop deflector, Fig. 26, which should be approximately 1/16 inch. To adjust, loosen the two looper set screws. Turn looper to left or right until correct clearance is attained. Hold in position and securely tighten the two set screws.

**CAUTION:** on single and multiple needle machines, make certain that the point of each looper just clears the scarf of its respective needle. To adjust, with looper point directly opposite center of needle, loosen the two set screws, Fig. 26, and turn looper slightly to left or right. Then tighten the set screws.



## 纵向调整和针杆高度调整

### Lengthwise Setting and Setting Height of Needle Bar

正确安装时，弯针尖对应于机针的中心，位于针眼上面空隙的中间。这时机器上轮上的弯针同步标记 LT 应对准机壳上的同步箭头。

调整弯针时，松开弯针导架夹紧螺母(图27)，前后移动导架直到弯针尖对准机针中心，然后锁紧夹紧螺母。

调整针杆时，先拆下装在针杆上的机针或针夹，松开2个针杆夹紧螺钉(图28)，升高或降低针杆到正确位置，然后小心地锁紧2个夹紧螺钉。

When correctly set, the point of the looper should be directly opposite the center of the needle, and at the center of the clearance above the eye of the needle when the looper timing mark LT on machine pulley is opposite the timing arrow on the arm.

To adjust the looper, loosen looper carrier clamping nut, Fig. 27. Move carrier forward or backward until looper point is directly opposite center of needle. Then tighten clamping nut.

To adjust needle bar, first make certain that needle is inserted up into the needle bar or clamp as far as possible. Loosen the two needle bar clamping screws, Fig. 28, and raise or lower needle bar to correct position. Then securely tighten the two clamping screws.

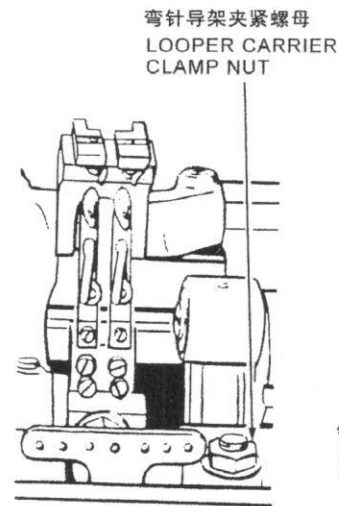


图 27 / Fig.27

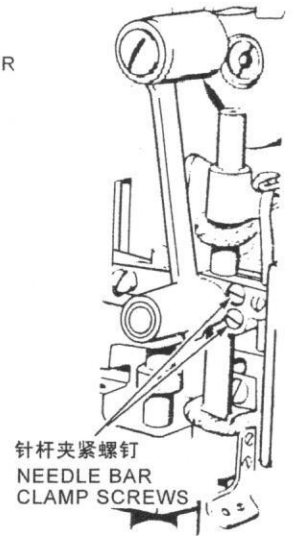


图 28 / Fig.28

## 弯针传动曲柄的同步

### TIMING LOOPER DRIVING CRANK

当弯针传动曲柄完全同步时，在弯针向前和向后行程中弯针尖通过机针针眼上面的距离相等。

如果在向前行程中弯针尖高了，松开弯针传动曲柄紧定螺钉(图29)，拧松弯针曲柄同步螺钉(左)大约1/8圈，拧紧弯针曲柄同步螺钉(右)，继续这样的调整直到获得正确的调整，然后小心地锁紧紧定螺钉。

如果在向后行程中弯针尖高了，松开同步螺钉(右)和拧紧同步螺钉(左)，进行相反的调整。

When the looper driving crank is properly timed, the point of the looper will pass above the eye of the needle at the same distance on both the forward and backward strokes of the looper.

To adjust when point of looper passes higher on forward stroke, loosen looper driving crank set screw, Fig. 29. Loosen looper crank timing screw (left) approximately 1/8 turn, and tighten looper crank timing screw (right). Continue to adjust correct adjustment is made. Then securely tighten set screw.

When point of looper passes higher on backward stroke, reverse the adjustment by loosening timing screw (right) and tightening timing screw (left).

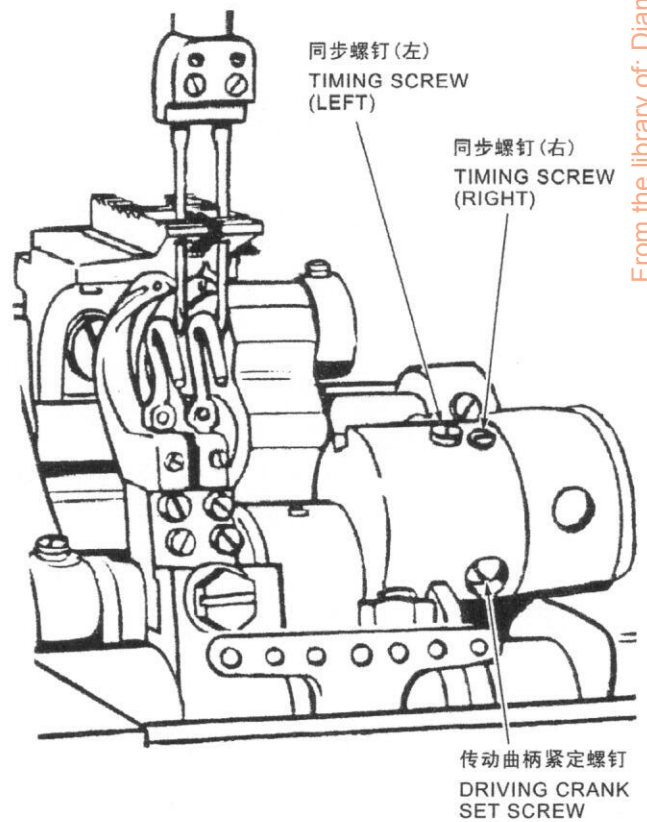


图 29 / Fig.29



## 安装线环导向装置

### POSITIONING LOOP DEFLECTORS

线环导向装置的正确位置是位于送料牙的下面，与机针右边有大约1/32吋的间隙。需要调整时，将弯针移出缝纫位置，背靠铰链倾斜机器，松开线环导向装置螺钉(图30)，沿螺钉槽把导向装置朝送料牙的后面尽量移，稍拧紧但允许进一步的调整。将弯针移回缝纫位置并转动机器上轮直到针杆下降到针杆行程的底部，左右轻打导向装置直到获得正确的间隙。把弯针移出缝纫位置并锁紧线环导向装置螺钉。

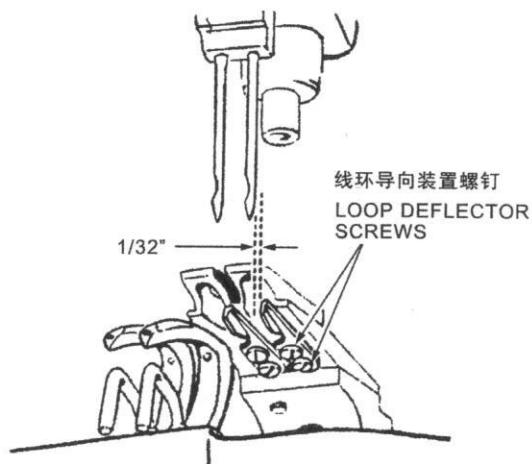


图 30 / Fig.30

When loop deflector, located on underside of feed dog, is positioned correctly, there should be a clearance of approximately 1/32 inch between the right side of the needle and the loop deflector. To adjust, move looper out of sewing position and tilt machine back on its hinges. Loosen loop deflector screws, Fig. 30. Move deflectors toward rear of feed dog as far as the screw slots allow. Tighten slightly to allow for further adjustment. Return looper to sewing position and turn machine pulley until needle bar descended to bottom of the needle bar stroke. Tap deflector to left or right until correct clearance is attained. Move looper out of sewing position and tighten loop deflector screws.

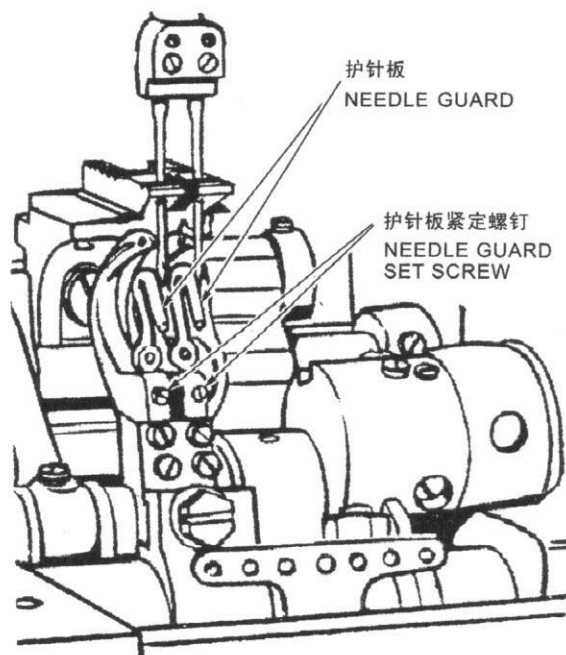


图 31 / Fig.31

## 安装护针板 / SETTING THE NEEDLE GUARDS

护针板安装正确时，它们应该尽可能地靠近机针经过而不与机针触碰。需要调整时，转动上轮直到弯针尖在其向前行程到达机针附近，在这一点，上轮的LT弯针同步标记应在机头箭头上大约1/8吋处。松开护针板紧定螺钉(图31)，转动护针板尽可能地靠近机针而不与机针触碰，锁紧紧定螺钉。将机针弹向左边，转动上轮检查弯针尖和机针不会碰撞。

When needle guards are properly set, they should pass as close as possible to the needles without touching. To adjust, turn machine pulley over toward operator until the points of the loopers are about to pass the needles on their forward strokes. At this point, the looper timing mark LT on the machine pulley should be approximately 1/8 inch above the arrow on machine arm. Loosen needle guard set screws, Fig. 31. Turn needle guards as close to the needles as possible without touching. Tighten set screws. Check by springing the needles to the left and turning the machine pulley to make certain that the looper points do not stroke the needles.

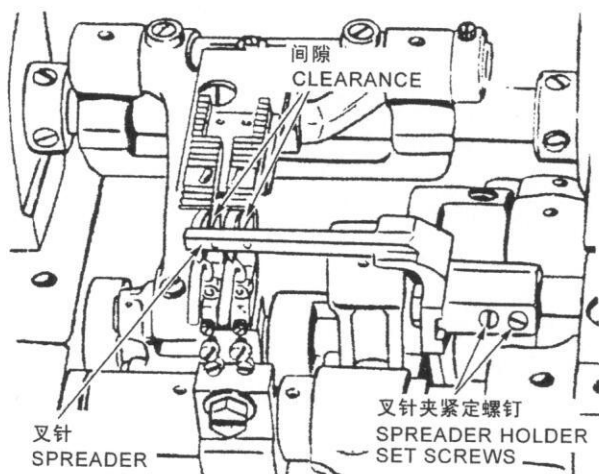


图 32 / Fig.32

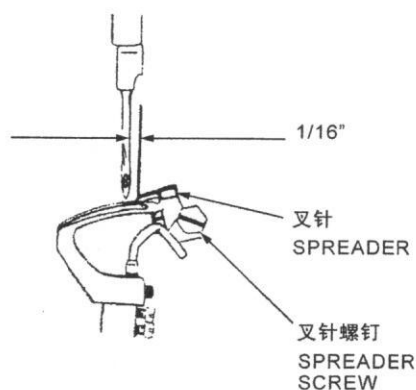


图 33 / Fig.33

### 安装叉针 / POSITIONING SPREADER

#### 横向和高度的调整 / Sidewise and Height Setting

弯针在其向前行程经叉针时……

叉针尖对着弯针左边线槽的顶部。

叉针尖与弯针之间的间隙大约是双层普通纸的厚度。

需要调整时，松开2个叉针夹紧固螺钉(图32)。移动叉针和夹到正确位置，保持在这位置并锁紧紧定螺钉。

When looper on its forward stroke is passing spreader...

The point of the spreader should be exactly opposite top of thread groove at left side of looper.

The clearance between spreader point and looper should be approximately the double thickness of ordinary paper.

To adjust, loosen the two spreader holder set screws, Fig. 32. Move spreader and holder to correct position. Hold in position and tighten the set screws.

#### 纵向调整 / Lengthwise Setting

机针尖在其向下行程中与叉针尖之间的间隙是均等的，大约是1/16吋。需要调整时，松开叉针螺钉(图33)前或后移动叉针到正确位置，然后锁紧叉针螺钉。

When the point of the needle on its downward stroke is even with the point of the spreader, the clearance between the two points should be approximately 1/16 inch. To adjust, loosen spreader screw, Fig. 33, and move spreader forward or backward to correct position. Then tighten spreader screw.



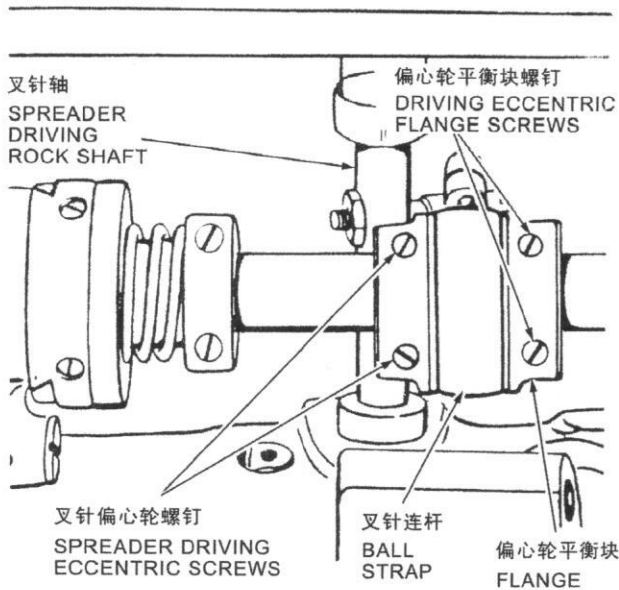


图 34 / Fig.34

**CAUTION:** When increasing sidewise movement, allow sufficient clearance between spreader driving rock shaft, Fig. 34, and left side of eccentric ball strap. They should not touch when eccentric ball stud is in its highest position.

## 叉针的可变运动 CHANGING MOVEMENT OF SPREADER

叉针的横向运动在异常缝纫条件下可以调整。在正常条件下，通常使用最大的叉针运动。需要调整时，将机器向后倾斜在其铰链上，松开2个叉针偏心轮螺钉(图34)和2个偏心轮平衡块螺钉。向左移动偏心轮增大运动，或向右移动偏心轮减小运动。位置正确后，先锁紧2个叉针偏心轮螺钉，保持平衡块紧靠叉针连杆并锁紧平衡块螺钉。可查阅前面所述关于叉针安装的资料。

**注意：**增大叉针横向运动时，叉针轴(图34)与叉针连杆右边之间要有足够的间隙，保证叉针连杆在最高位置时，它们不会碰撞。

The sidewise movement of the spreader may be adjusted for sewing under abnormal conditions. Under normal conditions, maximum spreader movement is generally used. To adjust, tilt machine back on its hinges, loosen the two spreader driving eccentric screws, Fig. 34, and the two spreader driving eccentric flange screws. Move eccentric to left to increase movement, or to right to decrease movement. When correctly positioned, tighten the two spreader driving eccentric screws first, hold flange against strap and tighten flange screws. Then refer to preceding information regarding positioning of spreader.

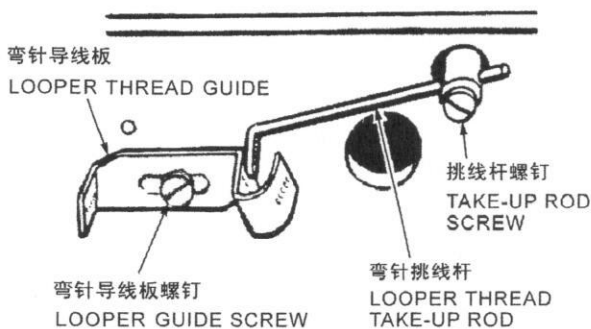


图 35 / Fig.35

To change ratio of looper thread in finished stitch, loosen looper thread guide screw, Fig. 35, and lower the yoke or right end of thread guide for more thread. For less thread, raise end of guide. Hold in position and tighten guide screw.

## 弯针挑线的调节 ADJUSTING LOOPER THREAD TAKE-UP

可根据缝料的厚度和针距通过调节弯针挑线杆和导线板来控制线量的多少，改变成品线迹里弯针线的比率。

需要改变送线量时，松开弯针导线板螺钉(图35)和松开弯针挑线杆螺钉，向左移动导线板和挑线杆增加挑线量；向右移动减少挑线量，锁紧2个螺钉并使挑线杆在导线板轭位通过。

需要改变成品线迹里弯针线的比率时，松开弯针导线板螺钉(图35)，降低导线板轭位或导线板右端增加挑线量。减少挑线量时可升高导线板端部。保持这一位置并锁紧导线板螺钉。

The looper thread take-up and guide may be adjusted for handling more or less thread, according to thickness of material and length of stitch, and to change the ratio of looper thread in the finished stitch.

To change the amount of thread handled, loosen looper thread guide screw, Fig. 35, and looper thread take-up rod screw. Move thread guide and take-up rod to the left for more thread or to the right for less thread. Tighten the two screws making certain that take-up rod passes through the center of the guide yoke.



## 针线挑线的调节

### ADJUSTING NEEDLE THREAD TAKE-UP

可以通过调节针线挑线杆和过线板来增加或减少在针杆行程顶端时拉住的线量。需要增加线量时，可松开挑线杆螺钉(图36)升高挑线杆或松开过线板螺钉降低过线板。需要减少线量时，可进行相反的调整，降低挑线杆或升高过线板。

在通常的缝纫中，过线板安装在其上边缘位于导向螺钉上方5/8吋处，挑线杆安装时其下边缘与挑线杆夹底面的距离为1.378吋。

The needle thread take-up and thread guide may be adjusted to increase or decrease the amount of thread drawn at the top of the needle bar stroke. To increase the amount, loosen thread take-up set screw, Fig. 36, and raise take-up or loosen guide screw and lower the guide. To decrease the amount, reverse the adjustment by lowering the take-up or raising the guide.

For average sewing conditions, the guide should be set with upper end 5/8 inch above the guide screw. The thread take-up should be set with the lower end 1.378 inch below the bottom of its holder.

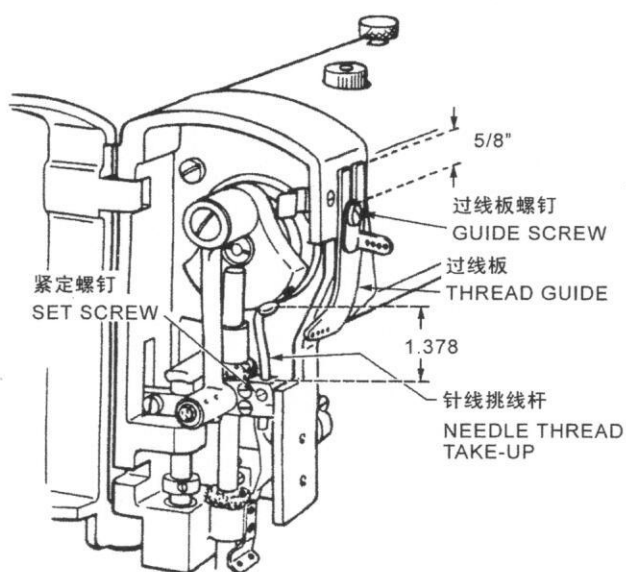


图 36 / Fig.36

## 针线松线的调节

### ADJUSTING NEEDLE THREAD TENSION RELEASER

调整正确时，松线器在压脚升起时释放针线拉力，在压脚下降时使线拉力充分调节。需要调整时，松开紧定螺钉(图37)，将松线盖往外移提早松线或往内移延迟松线。保持这一位置并锁紧紧定螺钉。如果经过上面的调整后松线器还不能在正确时间里松线，松开松线板螺钉并横向移动松线板到正确位置，然后锁紧螺钉。

When correctly adjusted, the tension releaser should release tension on the needle thread when the presser foot is raised and allow full adjusted tension when presser foot is down. To adjust, loosen set screw, Fig. 37, and move tension releaser cap out for earlier release of tension or in for later release. Hold in position and tighten set screw. Should the tension releaser not release tension at the correct time after making the above adjustments, loosen the tension releaser plate screw and move plate sidwise to correct position. Then tighten screw.

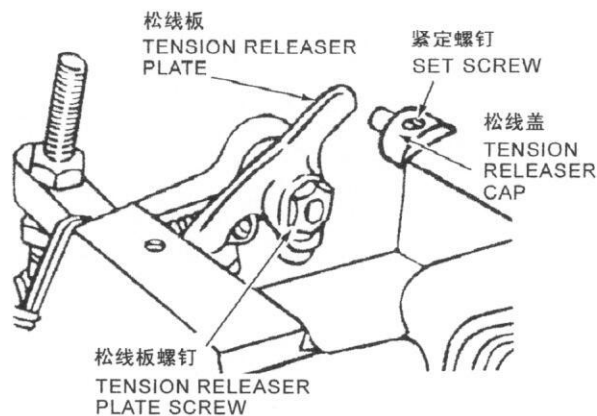


图 37 / Fig.37