

SIRUBA

使用説明書

INSTRUCTIONS BOOK

DL7200HP



溫馨提醒 A WARM REMINDER

請儘快下載 SIRUBA APP，並將您的機器註冊，以便獲得原廠的保固。APP 還提供多項有用的資訊。

please register your Siruba machine online or through Siruba App at once, as to gain the full warranty protection. You may also acquire more useful information through Siruba APP.



安全警示 GENERAL SAFETY INSTRUCTION

有關於縫紉機、自動化機構，以及其他輔助設備（以下統稱為機器），在工作中無可避免會接近機器移動區域，也就有伴隨著潛在風險。因此，我們強烈要求操作者，維修技師一定要先仔細閱讀並瞭解本操作手冊的內容。安全指示係包含了某些未載於規格書上的加裝配件。現場管理者有責任要求所有操作者要閱讀並瞭解機器的操作與注意事項。未能確實遵守本手冊所記載的事項，將可能導致機器的損害，或是人員的傷亡。

警告標示說明

For the sewing machine, automatic mechanic system, and auxiliary devices (hereinafter referred as "machine"), it is inevitable to conduct work near moving parts of the machine. This means that there is always a potential risk from the moving parts. Operators actually operating the machine and service technicians performing maintenance and repair are strongly advised to read and understand fully the following instructions in advance. The safety instructions include items which are not listed in the specifications of your product. It is the manager/supervisor's responsibility to have their fellow workers fully understand before operation. Fail to follow the instructions may cause damage to properties, severe injury or even death.

Explanation of warning indications and labels.

	<p>高壓電危險 在機器關機後十分鐘內，勿開啟電控箱。</p> <p>HIGH VOLTAGE DANGER Do not open the power cabinet within 10 minutes after the power off.</p>		<p>零部件移動區 勿接近，以避免人員受傷。</p> <p>Machine moving area! Stay away and keep clear to avoid injury.</p>
	<p>零部件高速移動區 勿接近，以避免人員受傷。</p> <p>High speed moving area! Stay away and keep clear to avoid injury.</p>		

標告標示說明 WARNING LABELS		標告標示說明 WARNING LABELS	
	<p>機器零部件移動區，勿接近，以避免人員損傷。 A risk of cut and injury from moving parts. Stay away and keep clear.</p>		<p>請注意，在操作過程中握住縫紉機會傷到您的手。 Be aware that holding the sewing machine during operation can hurt your hands.</p>
	<p>有電，危險。 A risk of electric shock. Stay away and keep clear.</p>		<p>小心被機械捲件受傷！ There is a risk of entanglement in the belt resulting in injury.</p>
	<p>高溫度區！危險，勿靠近。 A risk of burn from the high temperature area. Stay away and keep clear.</p>		<p>如果觸摸按鈕托架，可能會造成人身傷害。 There is a risk of injury if you touch the button carrier.</p>
	<p>強光！勿直視，以避免眼睛受傷。 Avoid direct eye contact with the laser beam or other light source.</p>	一般安全標示 GENERAL SAFETY INDICATIONS	
	<p>小心頭部撞擊！ A risk of injury to head from upper contact. Apply proper protection (helmet) and keep clear.</p>		<p>機器運行方向 The correct direction is indicated.</p>
			<p>電氣接地位置標示 Grounding connection as indicated.</p>

安全須知

SAFETY PRECAUTIONS

危險

意外事件將會導致人員受傷甚至死亡，也會造成財產的損害。當有必要進行電控系統的檢修時，務必要關閉電源，並等候至少5分鐘以上才能打開電控箱 / 操作箱，以避免電擊。

注意

1. 基本預防

- (1) 在操作前務必先閱讀操作手冊與其他機器電件的說明書，請妥善保存操作手冊與說明書以便隨時查閱。
- (2) 這些注意措施包含了機器上加裝，但未列在規格書上的項目。
- (3) 務必要戴護目鏡與手套，以避免破損零件所帶來的傷害。
- (4) 有裝戴心臟調節器的人員，請先詢問醫護人員有關注意事項。

2. 安全裝置與警告標示

- (1) 操作前要檢查，並確認所有的安全設施有妥善安裝且運作正常。
- (2) 若安全設施因維修需要而移動，在機器重新啟動操作前，請確認安全設施有重新安裝回原位，並且運作正常。
- (3) 機器上的安全警告標示要保持完整與可辨視。如果有污損或遺失，請儘以更新。
- (4) 未能確實遵守安全規範，將會導致人員受傷，甚至影響生命安全。

3. 應用與修改

- (1) 嚴格禁止機器使用在非原始設計用途。也禁止以任何不是操作手冊上記載的方式來操作機器。
- (2) 嚴格禁止修改機器。任何未經原廠許可的變動將不在保固範圍內。
- (3) 機台一經修改變動，本公司將不擔負財務損失，人員傷亡的責任。

4. 教育與訓練

- (1) 工廠主管人員有義務提供機台使用人（操作者 / 維修者）相關的教育訓練。良好的教育訓練不僅可以避免造成人員傷害，也可以避免財產的損失。
- (2) 操作人員操作機器之前，都必需接受過良好的訓練。
- (3) 機器的維修保養必須由合格的技師執行。

5. 必須關閉電源的情況：

如何關閉電源：按壓下緊急停止開關（如果機器有配置的話），關閉電源，拔除電源線。

- (1) 當機器出現異常時，按下緊急停止開關（如果有配置），關閉電源。
- (2) 為了避免機器突然起動造成意外，在操作機器前，要先確定機器電源關閉，再行開啟電源。
- (3) 當檢查或清潔機器時，關閉電源，並確定機器已完全停止運作。
- (4) 當維修機器時（如更換或調整零件），要關閉電源，並確定機器已完全停止運作。

6. 拔除電源線時，務必要抓住電源插頭，而非抓住電源線，以避免斷裂，電擊，甚至火災。

7. 當機器停止運作，且無人看管時，要關閉電源。

8. 萬一停電或電力供應出現不穩，關閉電源，以避免意外發生。

Danger

An accident means " to cause personal injury or death, or damage to property. "

When it is necessary to perform service on electrical parts, be sure to turn the power off and wait for 5 minutes or more before opening the power cabinet/box in order to avoid electrical shock.

Caution

1. Basic precaution

- (1) Read the manual and other papers supplied with accessories of the machine before operation. Keep the manual and papers at hand for quick reference.
- (2) The content of this section includes items which are not listed in the specification of your product.
- (3) Always wear safety goggles and gloves to avoid accident caused by parts breakage.
- (4) For those who use a heart pacer, please consult the medical specialist first.

2. Safety devices and warning labels

- (1) Check to ensure all safety devices are correctly installed in place and properly before operation.
- (2) If any of the safety devices is removed for service cause, please be sure to replace it back to position and verify that it works normally before resuming operation.
- (3) Always keep the warning labels adhered on the machine clearly visible. If any of the labels missing or contaminated, replace with a new one at soon.
- (4) Fail to obey instructions above may cause severe injury or death to the operators.

3. Application and modification

- (1) It is prohibited to use the machine for any application other than its original intention, or in any manner other than that prescribed in the instruction manual.
- (2) Never modify or alter the machine. Any unauthorized change of the specification will not be covered by the warranty.
- (3) Our company assumes no responsibility/liability to damages, injuries, or death resulting from the machine which has been modified or altered.

4. Education and training

- (1) The plant managers/supervisors are obliged to provide education and training to operators and service technicians. A good education/training plan not only avoids personal injury but also prevent damage to the property.
- (2) Only a well-trained operator is allowed to operate the machine.
- (3) Only a certified technician is allowed to perform service to the machine.

5. Situations that you must turn off the power

Turning off the power: press EMG Stop (if there is one), switch off the power, and remove the power plug from the outlet.

- (1) When there is a failure or abnormality, press EMG Stop (if there is one), switch off the power.
- (2) To prevent accident resulting from abrupt start of the machine, before operating the machine, always turn off the power and switch on again.
- (3) When cleaning or inspecting the machine, make sure the machine stops completely after turning off the power.
- (4) When performing service (i.e. changing of adjusting any component), make sure the power is off and the machine stops completely.

6. Remove the power plug by holding the plug section instead of the cord to avoid electrical shock, leakage, or fire accident.

7. Turn off the power whenever the machine is left unattended between works.

8. In case of a power failure or black out, turn off the power to avoid damage or accident.

在不同階段的注意事項

PRECAUTIONS TO BE TAKEN IN VARIOUS OPERATION STAGES

1. 運輸

- (1) 當搬運或移動機器時，請考量機器重量，選擇安全合適的方式。請參考機器規格。
- (2) 採取足夠的安全防護，以避免機台在搬運或移動中掉落。
- (3) 為避免意外，運送時不要重覆使用包裝材料。

2. 拆箱

- (1) 在拆箱前，檢查機器是否平穩放置，並採用適當的工具維持拆箱過程的穩定。
- (2) 進行拆箱時，遵循外箱上的指示，小心外箱上的釘子或碎片。

3. 安裝：

3A. 桌板與腳架

- (1) 採用原廠的桌板以確保機器得到足夠的保護與支撐。如果在安裝或維修時，需要暫時將機器置放於物件上，請確定該物件有足夠的支撐力。
- (2) 如果桌板有裝置滾輪，滾輪需要有煞車鎖定機構，而且在操作與維修時，煞車機構必需鎖定。

3B. 電線與管路

- (1) 電線與管路的材質必需符合規範與需求。
- (2) 電線與管路不能夠有折彎或壓迫。移動的零配件上，電線與管路需有至少 30mm 以上的預留量。
- (3) 接線時不能有跳火。
- (4) 所有接頭都必需確實固定。當拆除時，務必要抓住接頭本體。

3C. 接地

- (1) 接地是必需的。且需由合格的技師來施工。
- (2) 在操作前需確認接地有確實。

3D. 馬達

- (1) 馬達的選用，必需符合規範與需求。
- (2) 如果馬達為皮帶傳動，務必要安裝保護措施以避免捲入危險。

4. 在開始操作前

- (1) 在開啟電源前，確認所有接頭，電線，管路都完好無損，確實連結。
- (2) 檢查皮帶輪的轉向與標示為同一方向。
- (3) 確認腳架滾輪都已鎖定。
- (4) 保持作業範圍淨空。

5. 在操作中

1. Transportation

- (1) When lift or move the machine, please take the machine weight into consideration and apply a safe manner. Refer to the specification for the information you need for transportation.
- (2) Apply sufficient safety measures when lifting or moving the machine to avoid falling or dropping.
- (3) To avoid unexpected accident, do not reuse the packing material for transportation.

2. Unpacking

- (1) Before proceeding to unpacking, check the balance of the machine and apply necessary tools to hold the proper position.
- (2) When unpacking, follow the instruction printed on the cartoon. Be careful of the nails and chips when unpacking from a wooden rack.

3. Installation:

3A. Table and Stand

- (1) Only adopt a qualified genuine table and stand to assure the holding support. In case you need to leave the machine on a surface temporarily for service, make sure the surface is strong enough to hold the weight.
- (2) If casters are applied to the table stand, adopt casters with a locking mechanism only and lock them well to secure the machine during the operation and service.

3B. Cable and Wire

- (1) The cables and wires must comply with the specification and requirement.
- (2) The cables and wires shall be free from bending or extra force. Reserve a free space of at least 30mm between cables/wires and the moving parts.
- (3) Do not apply starburst connection when wiring.
- (4) All connectors must be fixed securely. And always hold the connector body when removing it.

3C. Grounding

- (1) Grounding is necessary and must be done by a certified technician. (2) Check and ensure the grounding is secured before operation.

3D. Motor

- (1) The motor must comply with the specification and requirement.
- (2) If there is a belt in the motor transmission, adopt or apply a proper protector to avoid entangling.

4. Before Operation

- (1) Before turning on the power, make sure all the connectors, cables, and wires are free from damage, dropout, or looseness.
- (2) Check and make sure the pulley rotation follows the same direction as labels.
- (3) Make sure all the stand casters are locked or fixed in position.
- (4) Keep the working area clean from obstacles.

5. During Operation

- (1) Always keep your fingers, hair, or clothing away from the moving components and moving area. Do not place your personal belongings on the machine.

- (1) 注意手、頭髮、衣服不在機件移動範圍。不要將個人物品置放於機器上。
- (2) 機器會高速運作。保持雙手遠離移動機件範圍。機器完全停止前不要靠近。
- (3) 在移動物件或重新設定機器時，注意不要被機器或零件撞擊。
- (4) 避免突然起動造成意外，在檢查或維修馬達或皮帶時，務必關閉電源並確認機器完全停止。
- (5) 機器停止時，伺服馬達是無聲的。注意要關閉電源以免突然起動。
- (6) 永遠保持電控箱的風扇與氣道淨空。

6. 潤滑

- (1) 請依照說明書指示，選用合格的油脂來潤滑機件。
- (2) 如果油品接觸到眼睛或身體，立即以清水沖洗。如有不適，立即尋求醫護人員協助。
- (3) 如果油品不慎進入身體，立即尋求最近的醫療協助。

7. 維修保養

- (1) 只有合格的技師或工程師能夠進行維修服務，包含機器調整與修理。只採用原廠的零件進行更換。如果採用非原廠零件，或是因不當維修 / 調整所造成的傷害，本公司將不負任何責任。
- (2) 只有合格的技師或認證的工程師才能對電控系統進行維修或保養。
- (3) 當對氣動原件（如氣缸）進行維修保養時，務必先拔除風源，並將氣體完全洩除，以避免突然啟動。
- (4) 在調整或更換部件後，檢查所有螺絲是否鎖固。
- (5) 定期清潔是必需的。在清潔前務必先關閉電源，並確認機台完全停止。
- (6) 如果運作異常或不良，立即停止操作並關閉電源。聯絡授權經銷商或我們公司以尋求技術協助。
- (7) 當保險絲故障，立即關閉電源，找出故障原因並予以排除後，更換同規格的新的保險絲。
- (8) 定期檢查與清潔風道，電線與管路。

8. 工作環境

- (1) 機器必需不用電磁波干擾。
- (2) 電源供應必需良好且穩定。電壓波動不得超過 10%。
- (3) 隨時檢查空壓的壓力與品質。如果氣源不穩定，請安裝合適器材以改善。
- (4) 機器操作環境，室溫 5°C ~ 35°C，相對濕度 35%~85%。
- (5) 為了保護電子元件與安全起見，當有劇烈氣溫變化而導致凝水時，立即關閉並拔除電源，並靜候至完全乾燥為止。
- (6) 為了安全起見，當有打電或閃電時，請停止操作，關閉並拔除電源。
- (7) 勿在機器週遭使用電視或收音機，以避免干擾。
- (8) 依當地法令規範，在操作中採取必要的防護。
- (9) 關於包裝材料、潤滑油品，以及機器（含零配件）的丟棄，請依各地政府法規的規範執行。

- (2) The machine is designed to run at high speed. Always keep your hands away from the moving area. Do not resume the work cycle until the machine stops completely.
- (3) Be careful not to be caught by the machine or components when removing or resetting the machine.
- (4) To avoid accident caused by abrupt start, when performing service on the motor or belt, make sure the power is off and the machine stops completely.
- (5) A servo motor is silent as the machine stops. Be sure to turn off the power to avoid an abrupt start. (6) Always keep the fan and airway of the power cabinet clean from any obstacle.

6. Lubrication

- (1) Apply only qualified oil and grease onto the parts as instructed in the manual.
- (2) If the lubricant contacts your eye or body, wash it off immediately. Consult a medical care if necessary.
- (3) If the lubricant goes into your body accidentally, go to the nearby medical care immediately.

7. Service

- (1) Only a certified engineer/technician is allowed to perform service to the machine, including adjusting and repairing. Use only genuine parts for replacement. Our company assumes no responsibility/liability for any accident caused by improper repair or adjustment, or the use of any parts other than genuine one.
- (2) Only a certified technician or authorized engineer is allowed to repair or maintenance the electric system.
- (3) When performing service to air-driven parts, like an air cylinder, first disconnect the air supply and expel the air completely to avoid abrupt start.
- (4) Check all screws and nut are fixed well after adjusting and replacement.
- (5) A periodical cleaning is necessary. Make sure the power is off and the machine stops completely before cleaning.
- (6) If the machine functions poorly or abnormally, stop the operation and turn off the power. Contact the authorized dealers or us to request for a technical service support.
- (7) When there is a fuse failure, turn off the power, find out the cause of the failure and apply solution to it, then replace with a new one with the same spec.
- (8) Periodically check and clean the fan airway and the cable/wiring.

8. Working Environment

- (1) The machine should be free from the affection of electro-magnetic wave.
- (2) The power supply should be in good and reliable condition, the fluctuation of rated voltage should be less than 10%.
- (3) Always check the air pressure and quality. Some extra device might be needed if the supply is not reliable.
- (4) The machine is designed to be used with ambient temperature 5°C ~ 35°C, relative humidity 35%~85%.
- (5) To protect the electronic components and for safety cause, when there is a frost resulting from a dramatic temperature rise, disconnect the power and wait until it dry completely.
- (6) For safety cause, when there is a thundering or lightening, stop the operation and disconnect the power supply.
- (7) Do not use TV or radio nearby the machine as to avoid interference.
- (8) Apply necessary protection during operation. Follow applicable regulations set by local administration.
- (9) For disposal of packages, lubricant, and product, please follow the applicable regulations set by local administration.

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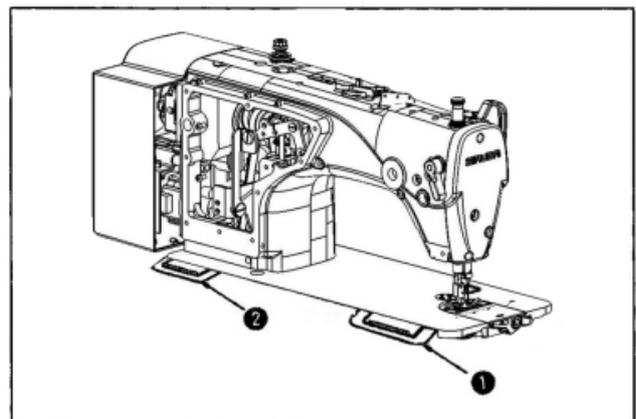
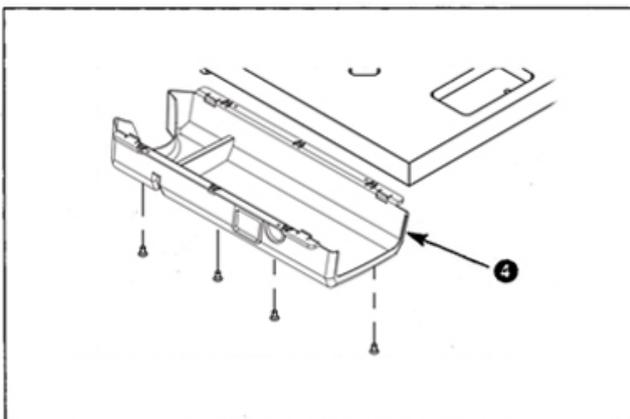
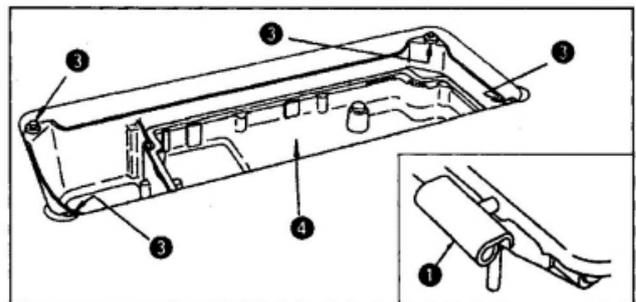
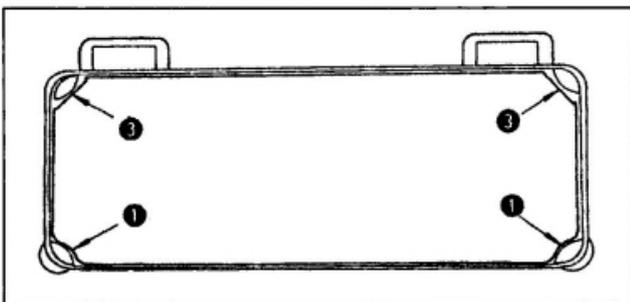
1. 規格 / SPECIFICATIONS

	標準型	厚料型	厚料型 (雙倍旋梭)
用途	一般布料、中厚料	中厚料、厚料	中厚料、厚料
縫紉速度	最高 5000 rpm	最高 3500 rpm	最高 3500 rpm
最大針腳長度	5 mm	7 mm	7 mm
機針	DBx1 #11-#18	DPx5 #18~#23	DPx5 #18~#23
壓腳高度 (膝動提升)	10mm (標準) 13mm (最大)	10mm (標準) 13mm (最大)	10mm (標準) 13mm (最大)
使用機油	NO.10 白油		

	Medium-weight model	Heavy-weight model	Heavy-weight model (Double rotating shuttle)
Application	General fabrics, light-weight and medium-weight materials.	Medium-weight materials, heavy-weight materials.	Medium-weight materials, heavy-weight materials.
Sewing speed	Max. 5000 rpm	Max. 3500 rpm	Max. 3500 rpm
Max. stitch length	5 mm	7 mm	7 mm
Needle	DBx1 #11-#18	DPx5 #18~#23	DPx5 #18~#23
Presser foot lift	10mm(standard) 13mm(Max.)	10mm(standard) 13mm(Max.)	Wmm(standard) 13mm(Max.)
Lubricating oil	Defrix Oil NO.10		

2. 縫紉機的安裝 / INSTALLATION

(1) 底槽的安裝



- 1) 把底槽支到機台溝的四角上。
- 2) 用螺釘④把前側的□2個頭部橡膠支座③釘到機台的伸出部，再用螺釘④把鉸鏈側□的2個頭部膠墊座⑤釘好固定，然後把底槽①放上去。
- 3) 把鉸鏈①放到機台的孔上，對準台板橡膠支座②，把頭部放到四角的機頭膠墊⑤上。

(1) Installing the under cover

- 1) The oil pan should rest on the four corners of the machine table groove.
- 2) Fix two rubber seats ● on side □(operator's side) using nails● as illustrated above. Fix two cushion seats ● on side □(hinged side) using a rubber-based adhesive. Then place oil pan● on the fixed seats.
- 3) Fit hinge ● into the opening in the machine bed, and fit the machine head to table rubber hinge● before placing the machine head on cushions ● on the four corners.

3. 膝動提升高度的調整 / ADJUSTING THE HEIGHT OF THE KNEE LIFTER

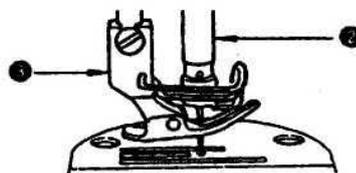
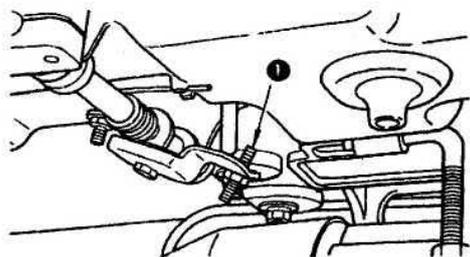


注意

為了防止意外的起動造成的事故，請關掉電源後進行。

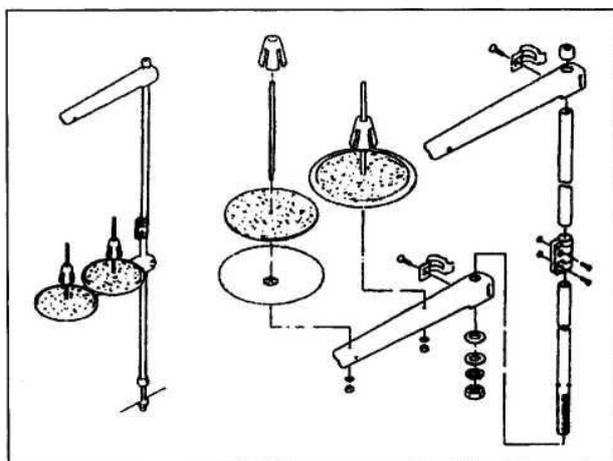
WARNING:

Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



- 1) 膝動提升的壓腳標準高度為 10mm。
 - 2) 調節膝動提升調節螺絲● 可以把壓腳高度最大調整到 13mm。(A 型時最大為 9mm。)
 - 3) 壓腳提升到 10 mm 以上時，請注意針杆● 的前端下降到最底下時，不能碰到壓腳●。
- 1) The standard height of the presser foot lifted using the knee lifter is 10 mm.
 - 2) You can adjust the presser foot lift up to 13 mm using knee lifter adjust screw-. (Max. 9 mm for A type)2)
 - 3) When you have adjusted the presser foot lift to over 10 mm, be sure that the bottom end of needle bar ● in its lowest position does not hit presser foot ● .

4. 線架裝置的安裝 / INSTALLING THE THREAD STAND



5. 加潤滑脂/LIPIN

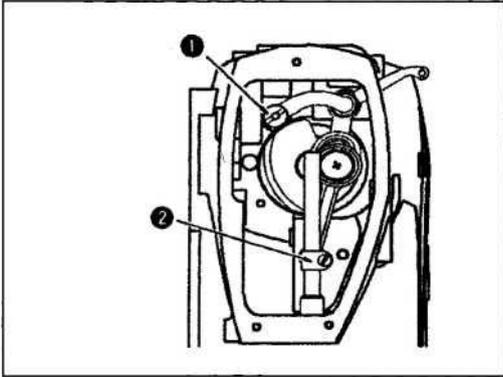


注意

為了防止意外的起動造成的事故，請關掉電源後進行。

WARNING:

Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



1) 請先卸下挑線連杆銷①上的小螺釘後，將潤滑脂注滿挑線連杆銷①的小孔內。

2) 請先拆下針杆連接柱元件後卸下針杆連接柱②上的小螺釘，將潤滑脂注滿針杆連接柱②的小孔內。

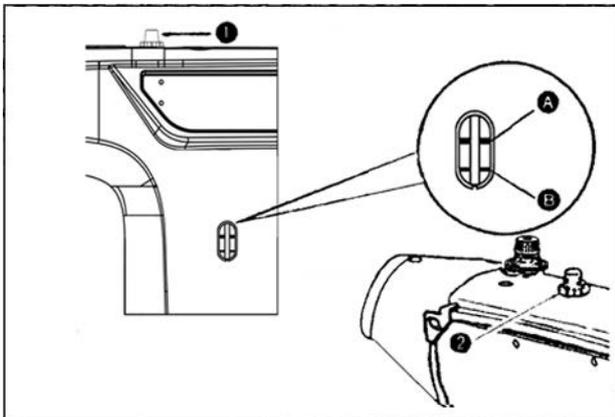
1) Full pore of the thread take-up crank shaft ① with lipin before disassembly small screw of the thread take-up crank shaft ①.

2) Disassembly small screw before Disassembly the needle rod holder ASM, then full pore of the needle bar connection ASM ② with lipin.



新縫紉機或較長時間沒有使用的縫紉機在使用之前，應進行 10 分鐘 3,000~3,500 rpm 的磨合運轉。

6. 加油/LUBRICATION



運轉縫紉機前

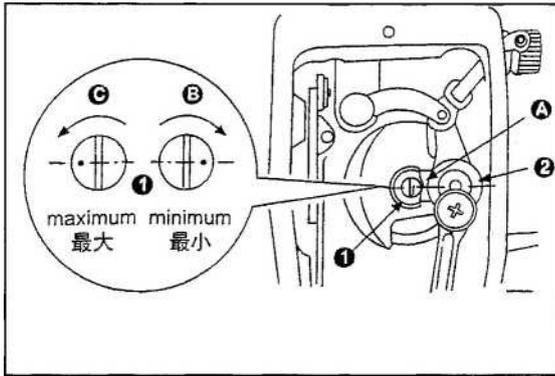
- 1) 請把機油倒進油槽●裡，一直加到 HIGH 標記□的位置。
- 2) 油槽的油面降到 LOW 標記□以下時，請再次補充機油。
- 3) 加油後運轉縫紉機，如果潤滑正常時，可以通過油窗●看到油的流動。
- 4) 油流動量的多少，與油量的多少無關。

Information on lubrication

- 1) Fill oil pan ● with Machine Oil up to HIGH mark ①.
- 2) When the oil level lowers below LOW mark ②, refill the oil pan with the specified oil.
- 3) When you operate the machine after lubrication, you will see splashing oil through oil sight window ● if the lubrication is adequate.
- 4) Note that the amount of the splashing oil is unrelated to the amount of the lubricating oil.



When you first operate your machine after setup or after an extended period of disuse, run your machine at 3,000 to 3,500 rpm. for about 10 minutes for the purpose of break-in.



面部油量的調整

- 1) 調整挑線杆和針杆曲柄●的油量時，轉動油量調整銷●進行調整。
- 2) 調整銷刻點□從圖的位置向□方向轉動，轉動到接近針杆曲柄●時，油量最小。
- 3) 從圖上所示的位置向□方向轉動，當轉到與針杆曲柄的正對面的位置時，油量最大。

Adjusting the amount of oil supplied to the face plate parts

- 1) Adjust the amount of oil supplied to the thread take-up and needle bar crank ● by turning adjust pin ●.
- 2) The minimum amount of oil is reached when marker dot □ is brought close to needle bar crank ● by turning the adjust pin in direction B.
- 3) The maximum amount of oil is reached when marker dot A is brought to the position just opposite from the needle bar crank by turning the adjust pin in direction C.

7.關於旋梭部油量（跡）調整方法/

ADJUSTING THE AMOUNT OF OIL (OIL SPLASHES) IN THE HOOK



注意

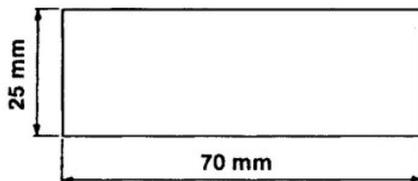
旋梭是以高速運轉。為了防止人身事故，調整油量時，請加以充分的注意。

WARNING:

Be extremely careful about the operation of the machine since the amount of oil has to be checked by turning the hook at a high speed.

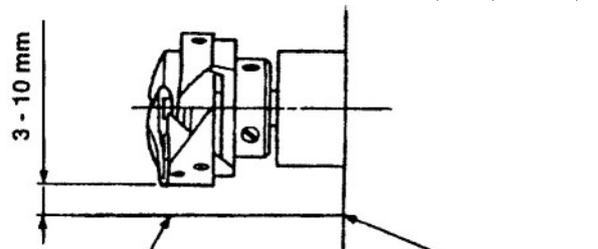
①油量（跡）確認專用紙

Amount of oil (oil splashes) confirmation paper



②油量（跡）確認位置

Position to confirm the amount of oil (oil splashes)



油迹确认专用纸
Oil splashes
confirmation paper

应顶到接油槽壁
Closely fit the paper
against the wall
surface of the bed.

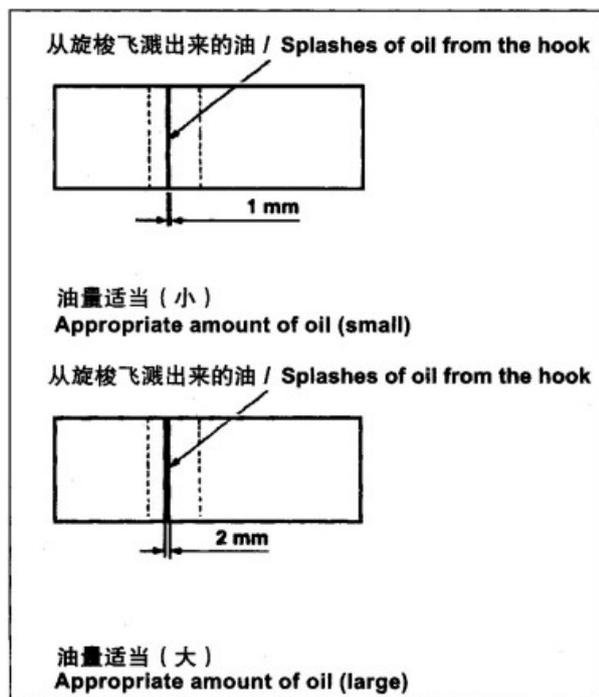
*進行下列 2) 的作業時，請卸下滑板，同時要充分注意手指不要碰到旋梭。

- 1) 冷機頭時，請進行 3 分鐘左右的空運轉。(適當的斷續運轉)
- 2) 油量(跡)確認專用紙在縫紉機轉動後的狀態下插進去。
- 3) 請確認油量的油面高度應在 HIGH 和 LOW 的範圍之內。
- 4) 確認油量(跡)所需要的時間為 5 秒鐘。(應看著表)

* When carrying out the procedure described below in 2, remove the slide plate and take extreme caution not to allow your fingers to come in contact with the hook.

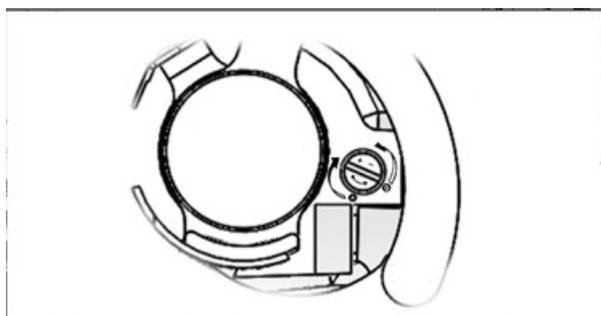
- 1) If the machine has not been sufficiently warmed up for operation, make the machine run idle for approximately three minutes. (Moderate intermittent operation)
- 2) Place the amount of oil (oil splashes) confirmation paper under the hook while the sewing machine is in operation.
- 3) Confirm the height of the oil surface in the oil reservoir is within the range between "HIGH" and "LOW".
- 4) Confirmation of the amount of oil should be completed in five seconds. (Check the period of time with a watch.)

● 油量（油蹟）適合標準 / Sample showing the appropriate amount of oil



- 1) 左圖示樣根據縫製供需需要微調增減，但注意不要過大增加或減少。
（油量過少時，會燒壞旋梭（發熱）。油量過多時，會髒汗縫製品。）
- 2) 油量（油蹟）應確認 3 次（3 張）均無變化。
 - 1) The amount of oil shown in the samples on the left should be finely adjusted in accordance with sewing processes. Be careful not to excessively increase/decrease the amount of oil in the hook. (If the amount of oil is too small, the hook will be seized (the hook will be hot). If the amount of oil is too much, the sewing product may be stained with oil.)
 - 2) Adjust the amount of oil in the hook so that the oil amount (oil splashes) should not change while checking the oil amount three times (on the three sheets of paper)

● 旋梭油量（跡）調整 / Adjusting the amount of oil

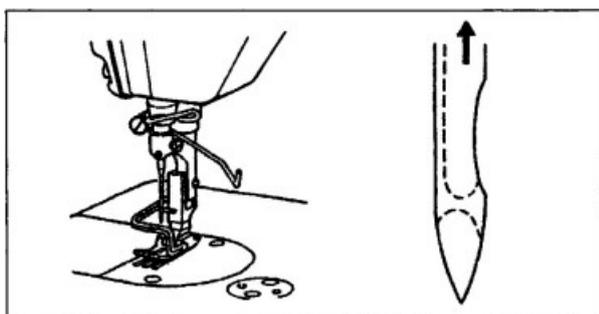


- 1) 把下軸前端金屬部件上的油量調節螺絲向“+”的方向（□方向）轉動，油量（跡）變多，向“-”的方向（□方向）轉動，油量（跡）變少。
- 2) 油量調節螺絲調整後的油蹟，應空運轉 30 秒鐘左右進行油量（跡）的確認。
 - 1) Turning the oil amount adjustment screw attached on the hook driving shaft front bushing in the direction (in direction A) will increase the amount of oil (oil spots) in the hook, or in the direction (in direction B) will decrease it.
 - 2) After the amount of oil in the hook has been properly adjusted with the oil amount adjustment screw, make the sewing machine run idle for approximately 30 seconds to check the amount of oil in the hook.

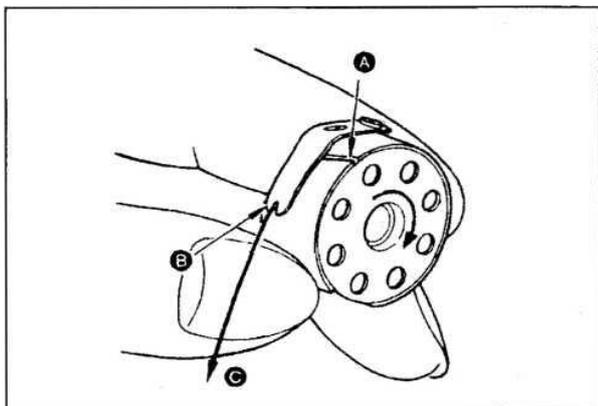
8. 機針的安裝 / ATTACHING THE NEEDLE



注意
為了防止意外的起動造成的事故，請關掉電源後進行。
WARNING:
Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

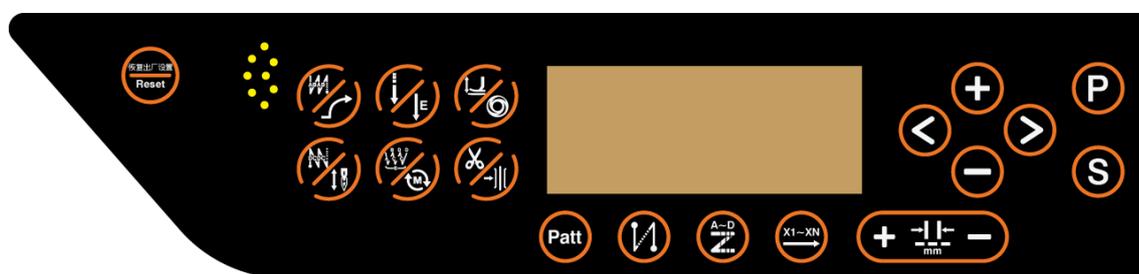


9. 梭心的安裝方法 / SETTING THE BOBBIN INTO THE BOBBIN CASE

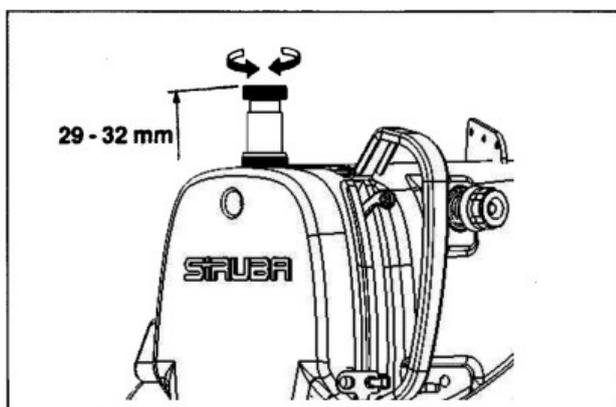


- 1) 把線穿過梭殼的穿線口Ⓐ，然後把線往Ⓑ方向拉，從線張力彈簧下面的穿線口拉出來。
 - 2) 拉底線口，確認梭心是否按箭頭方向轉動。
- 1) Pass the thread through thread slitⒶ, and pull the thread in direction Ⓑ.
By so doing, the thread will pass under the tension spring and come out from notchⒷ.
 - 2) Check that the bobbin rotates in the direction of the arrow when thread Ⓒ is pulled.

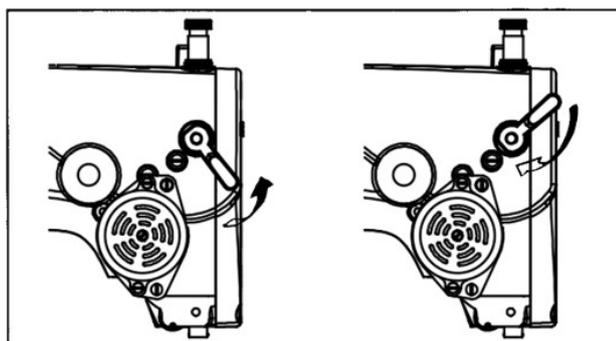
10. 線跡長度的調節 / ADJUSTING THE STITCH LENGTH



↑ ↑
線跡長度調節
Stitch length adjustment



11. 壓腳壓力的調節 / PRESSER FOOT PRESSURE



12. 關於壓腳提升/ HAND LIFTER

13. 壓腳杆高度的調整 / ADJUSTING THE HEIGHT OF THE PRESSER BAR

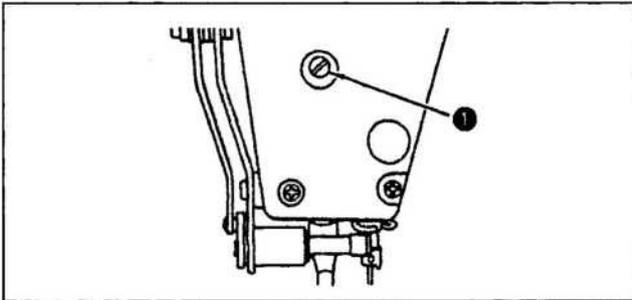


注意

為了防止意外的起動造成的事故，請關掉電源後進行。

WARNING:

Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



1) 變更壓腳杆的高度或壓腳的角度時，請擰松壓腳杆套管固定螺絲**1**進行調整。

2) 調整後，擰緊固定螺絲**1**。

1) Loosen setscrew **1** and adjust the presser bar height or the angle of the presser foot.

2) After adjustment, securely tighten the setscrew **1**.

14. 上線的穿線方法 / THREADING THE MACHINE HEAD

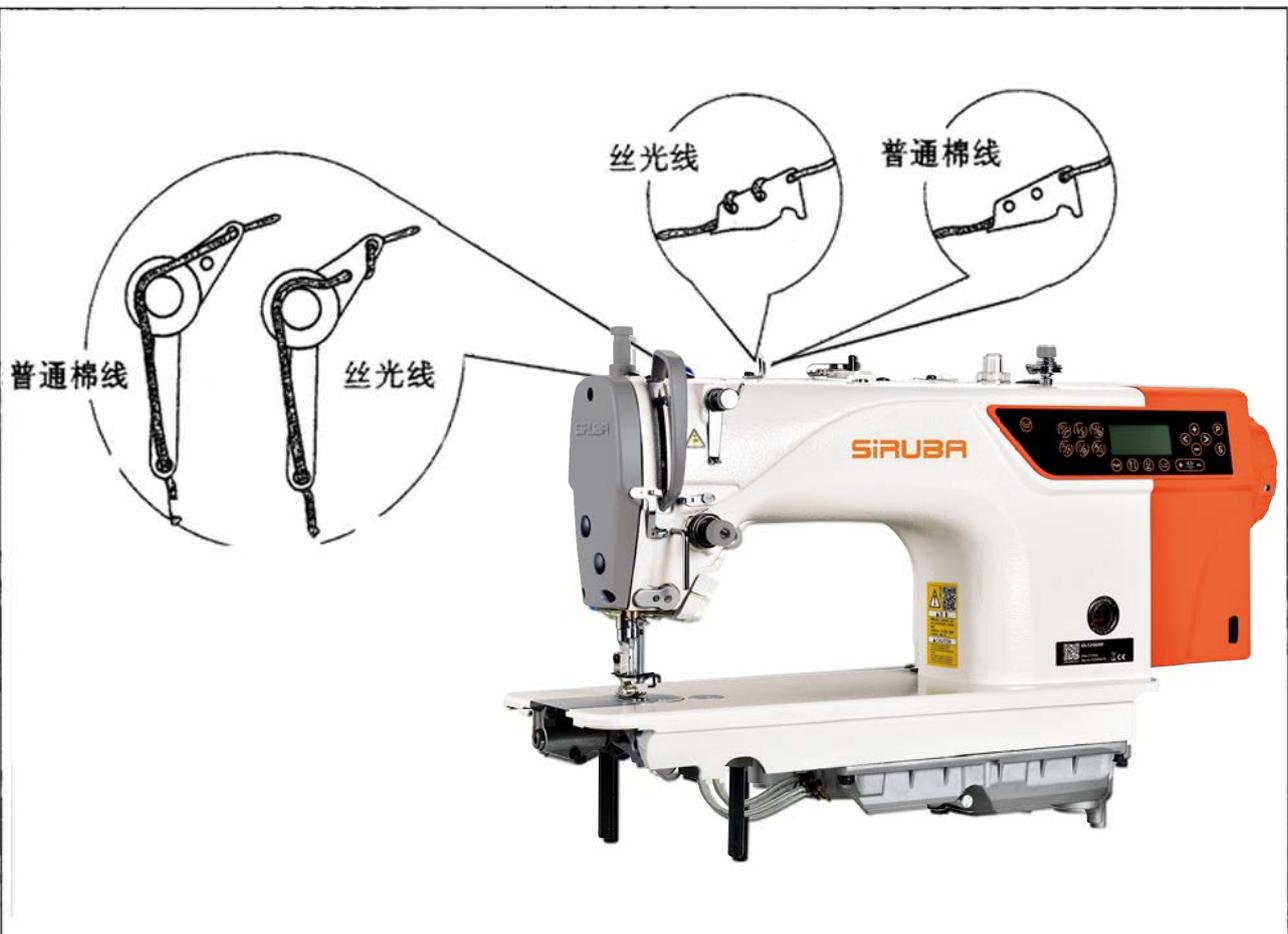


注意

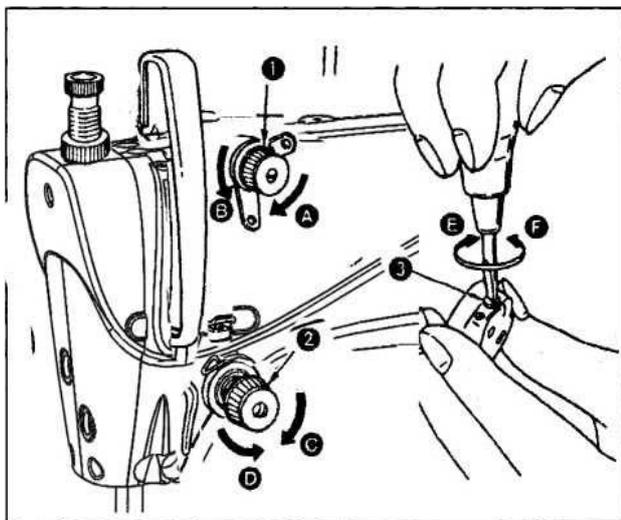
為了防止意外的起動造成的事故，請關掉電源後進行。

WARNING:

Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



15. 線張力器 / THREAD TENSION



(1) 上線張力的調整

- 1) 向右☐的方向轉動第一線張力螺母①，切線後殘留在機針上的線長度變短。
- 2) 向左☐的方向轉動，則長度變長。
- 3) 向右☐的方向轉動第二線張力螺母②，上線張力變強。
- 4) 向左☐的方向轉動，則上線張力變弱。

(2) 底線張力的調整

- 1) 向右☐的方向轉動線張力螺絲③，底線張力變強。
- 2) 向左☐的方向轉動線張力螺絲，則底線張力變弱。

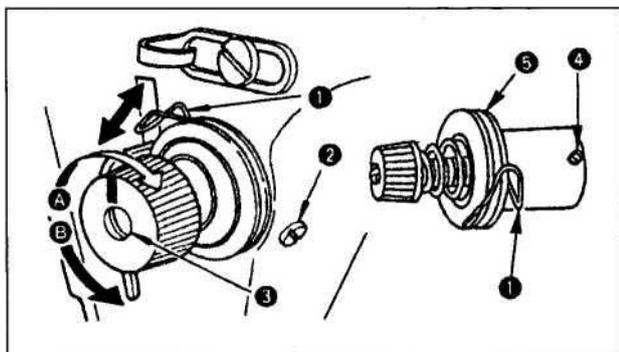
(1) Adjusting the needle thread tension

- 1) As you turn thread tension No.1 nut ① clockwise (in direction ①), the thread remaining on the needle after thread trimming will be shorter.
- 2) As you turn nut ① counterclockwise (in direction ②), the thread length will be longer.
- 3) As you turn thread tension No.2 nut ② clockwise (in direction ③), the needle thread tension will be increased.
- 4) As you turn nut ② counterclockwise (in direction ④), the needle thread tension will be decreased.

(2) Adjusting the bobbin thread tension

- 1) As you turn tension adjust screw ③ clockwise (in direction ⑤), the bobbin thread tension will be increased.
- 2) As you turn screw ③ counterclockwise (in direction ⑥), the bobbin thread tension will be decreased.

16. 調線線彈簧 / THREAD TAKE-UP SPRING



(1) 挑線彈簧●的行程量調整

- 1) 擰松線張力台的固定螺絲②。
- 2) 向右☐的方向轉動線張力杆③，則行程量變大。
- 3) 向左☐☐ 為了防止布的跑偏，需要提早。

(2) 挑線彈簧●的壓力調整

- 1) 擰松固定螺絲②，卸下線張力杆③。
- 2) 擰松線張力杆固定螺絲④進行調整。
- 3) 向右☐的方向轉動線張力杆③則壓力變強。
- 4) 向左☐☐ 的方向轉動壓力則壓力變弱。

(1) Changing the stroke of thread take-up spring●

- 1) Loosen setscrew ②.
- 2) As you turn tension post ③ clockwise (in direction A), the stroke of the thread take-up spring will be increased.
- 3) As you turn the knob counterclockwise (in direction B), the stroke will be decreased.

(2) Changing the pressure of thread take-up spring●

- 1) Loosen setscrew ②, and remove thread tension (asm) 5.
- 2) Loosen setscrew 4.
- 3) As you turn tension post ③ clockwise (in direction A), the pressure will be increased.
- 4) As you turn the post ③ counterclockwise (in direction B), the pressure will be decreased.

5) 挑線杆挑線量的調整 / ADJUSTING THE THREAD TAKE-UP STROKE

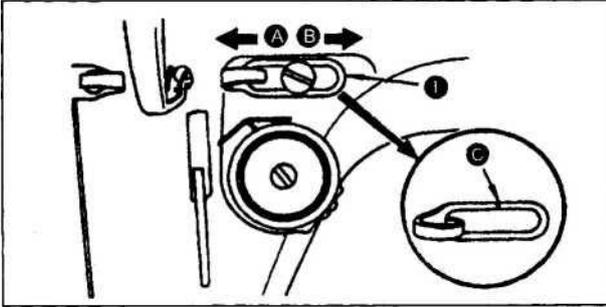


注意

為了防止意外的起動造成的事故，請關掉電源後進行。

WARNING:

Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



- 1) 縫製厚料時，向左□的方向移動線導向器①，則挑線量變多。
 - 2) 縫製薄料時，向右□的方向移動線導向器①，則挑線量變少。
 - 3) 線導向器①在刻線 C 對準螺絲的中心時是標準位置。
- 1) When sewing heavy-weight materials, move thread guide ① to the left (in direction □) to increase the length of thread pulled out by the thread take-up.
 - 2) When sewing light-weight materials, move thread guide ① to the right (in direction □) to decrease the length of thread pulled out by the thread take-up.
 - 3) Normally, thread guide ① is positioned in a way that marker line C is aligned with the center of the screw.

18.機針與旋梭的關係 / NEEDLE-TO-HOOK RELATIONSHIP

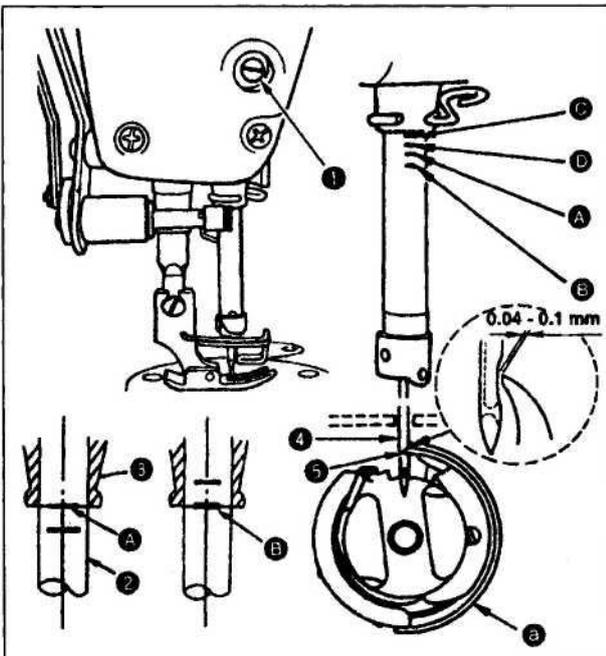


注意

為了防止意外的起動造成的事故，請關掉電源後進行，確認馬達確實停止轉動後再進行。

WARNING:

To avoid possible personal injury due to abrupt start of the machine, turn off the power to the machine and check to be sure that the motor has totally stopped rotating in prior.



(1) 請按如下方法調整機針和旋梭。

- 1) 轉動飛輪，讓針杆降到最下點，然後擰松針杆 套管固定螺絲①。

(決定針杆高度)

2) [DB 針時]

- 把針杆②的刻線□對準針杆下套筒③的下端，然後擰緊針杆套管固定螺絲①。

3) [DP 針時]

- 擰松 3 根旋梭固定螺絲，轉動飛輪在針杆②上升的方向，把刻線□對準針杆下套筒下端。

(決定旋梭口的安裝位置)

- 4) 在此狀態下，讓旋梭尖⑤對準機針④的中心，把機針與旋梭的間隙調整為 0.04 ~ 0.1mm (大致) 然後擰緊螺絲。

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

1) Turn the handwheel to bring the needle bar down to the lowest point of its stroke, and loosen setscrew ❶.

(Adjusting the needle bar height)

2) **(For a DB needle)** Align marker line ㉑ on needle bar ㉒ with the bottom end of needle bar lower bushing ㉓, then tighten setscrew ❶.

(For a DA needle) Align marker line ㉔ on needle bar ㉒ with the bottom end of needle bar lower bushing ㉓, then tighten setscrew ❶.

(Adjusting position of the hook ㉕)

3) **(For a DB needle)** Loosen the three hook setscrews, turn the handwheel and align marker line ㉖ on ascending needle bar

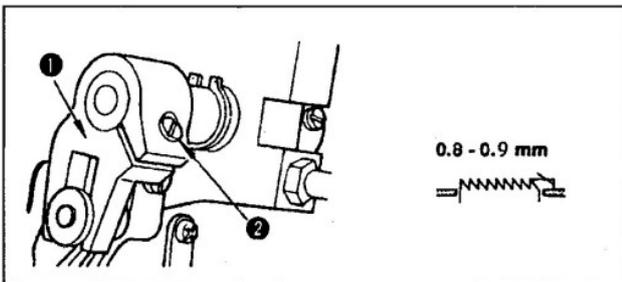
with the bottom end of needle bar lower bushing ㉓.

(For a DA needle) Loosen the three hook setscrews, turn the handwheel and align marker line ㉗ on ascending needle bar with

the bottom end of needle bar lower bushing ㉓.

4) After making the adjustments mentioned in the above steps, align hook blade point ㉘ with the center of needle 4. Provide a clearance of 0.04 mm to 0.1mm (reference value) between the needle and the hook, then securely tighten setscrews in the hook.

19.送布牙的高度/ HEIGHT OF THE FEED DOG



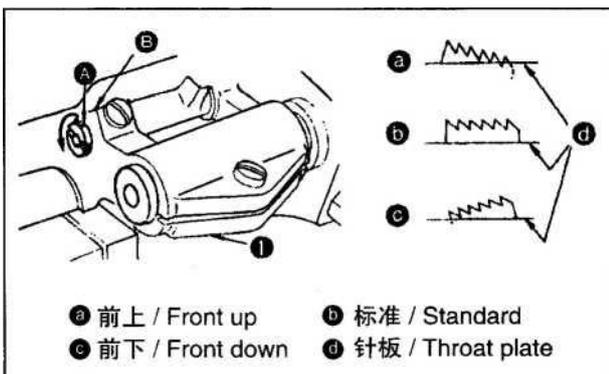
調節送布牙的高度時

- ❶ 擰松上下送布雙叉 ❶ 的緊固螺絲 ❷。
- ❷ 上下移動送布台進行調節。
- ❸ 擰緊固定螺絲 ❷。

To adjust the height of the feed dog:

- ❶ Loosen screw ❷ of crank ❶
- ❷ Move the feed bar up or down to make adjustment.
- ❸ Securely tighten screw ❷

20 .送布牙的傾斜 / TILT OF THE FEED DOG

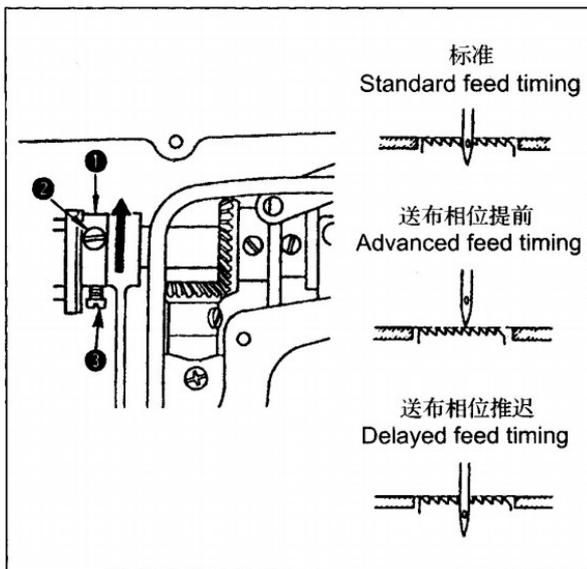


- 1) 標準傾斜（水準）度是送布台軸的刻點口和送布台曲柄 ❶ 的口部一致時的位置。（的標準傾斜是對口部呈 90 度水準送布面向軸側的位置。）
- 2) 為了防止縫製皺摺，向前抬起送布牙時，請擰松固定螺絲，把螺絲刀插入送布台軸，然後沿箭頭方向轉 90 度。
- 3) 為了減少布的偏斜，向前下降送布牙時，請沿與箭頭方向相反方向轉 90 度。

- ❶ 前上 / Front up
- ❷ 标准 / Standard
- ❸ 前下 / Front down
- ❹ 针板 / Throat plate

-
- 1) The standard tilt (horizontal) of the feed dog is obtained when marker dot ① on the feed bar shaft is aligned with marker dot ② on feed rocker ③. (the marker dot ② inclines forward the feed rocker shaft by 90°, as standard).
 - 2) To tilt the feed dog with its front up in order to prevent puckering, loosen the setscrew, and turn the feed bar shaft 90° in the direction of the arrow, using a screwdriver.
 - 3) To tilt the feed dog with its front down in order to prevent uneven material feed, turn the feed bar shaft 90° in the opposite direction from the arrow. (The standard tilt for.)
-

21. 送布相位的調節 / ADJUSTING THE FEED TIMING

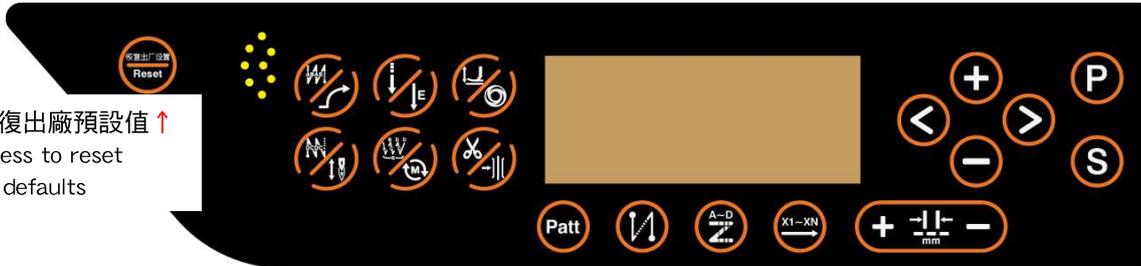


- 1) 擰松送布偏心凸輪①的固定螺絲②、③，朝箭頭方向或反箭頭方向移動送布偏心凸輪，然後擰緊固定螺絲。
 - 2) 標準調節位置是送布牙從針板下落時，送布牙上面與針孔上端對準針板上面的位置。
 - 3) 提早送布相位以防止布偏斜時，請向箭頭方向移動送布偏心凸輪。
 - 4) 為了良好的緊線而推遲相位時，請逆箭頭方向移動偏心凸輪。
-

- 1) Loosen screws ② and ③ in feed eccentric cam ①, move the feed eccentric cam in the direction of the arrow or opposite direction of the arrow, and firmly tighten the screws.
 - 2) For the standard adjustment, adjust so that the top surface of feed dog and the top end of needle eyelet are flush with the top surface of throat plate when the feed dog descends below the throat plate.
 - 3) To advance the feed timing in order to prevent uneven material feed, move the feed eccentric cam in the direction of the arrow.
 - 4) To delay the feed timing in order to increase stitch tightness, move the feed eccentric cam in the opposite, direction from the arrow.
-

22. 機針停止位置的調整/ADJUSTING THE NEEDLE STOP POSITION

長按恢復出廠預設值 ↑
Long press to reset
factory defaults



挑線桿標定位置
Take-up lever position



挑線桿位置示意圖
Schematic diagram of thread
take-up lever

1) 電機電角度校正：

長按，同開啟電源，螢幕顯示[P-92]。長按 P 鍵進入參數項再按鍵，然電機會自動運轉並計算電機電角度，等電機停下來後；參數值將自動變化，按 P 鍵保存即可。再按 P 鍵返回操作模式。

2) 機頭標定挑線杆位置（按鍵操作面板）：

按住 P 鍵開機，進入 [P-72] 項上針位校正參數。長按 P 鍵進入參數內容，將手輪調整至上針位（參數會隨著手輪位置而變化），按 P 鍵可保存參數（保存後，下針位會自動進行相應調整），若不保存則按 P 鍵退出參數。

1) Motor - angle correction :

Long press button, turn on the power at the same time, screen shows P-92, long press P button visit parameter. Then press button again, the motor will run automatically and calculate the motor angle. When the motor stop, the parameter values will change automatically, press P button to save. Press P button to turn on the machine

2) Head calibration take-up lever position (Press key action panel) :

Long P res P button to turn on the machine. Visit [P-72] the needle position to adjust the parameter. In the parameter, the handwheel adjust the upper needle position (the parameter will change according to the handwheel position), press P button to save (after saving, the lower needle position will adjust automatically), if not save, please press P button to exit parameter.

23 固定刀 /COUNTER KNIFE

(1) 割線刀凸輪位置的調節

轉動縫紉機的皮帶輪，當針棒從最低位置上升 5 毫米時，用手壓割線螺旋管使滾輪軸接觸割線凸輪①的凹部，然後用定位螺絲②臨時固緊，然後把割線螺旋管③返回到原來的位置(離開位置)，同時放鬆定位螺絲②調節割線凸輪①，使凸輪端面 and 滾輪軸端面之間間隙為 0.5 毫米。(以 40 公斤一釐米的扭矩擰緊定位螺絲②)。

(2) 移動刀片、固定刀片位置的調整

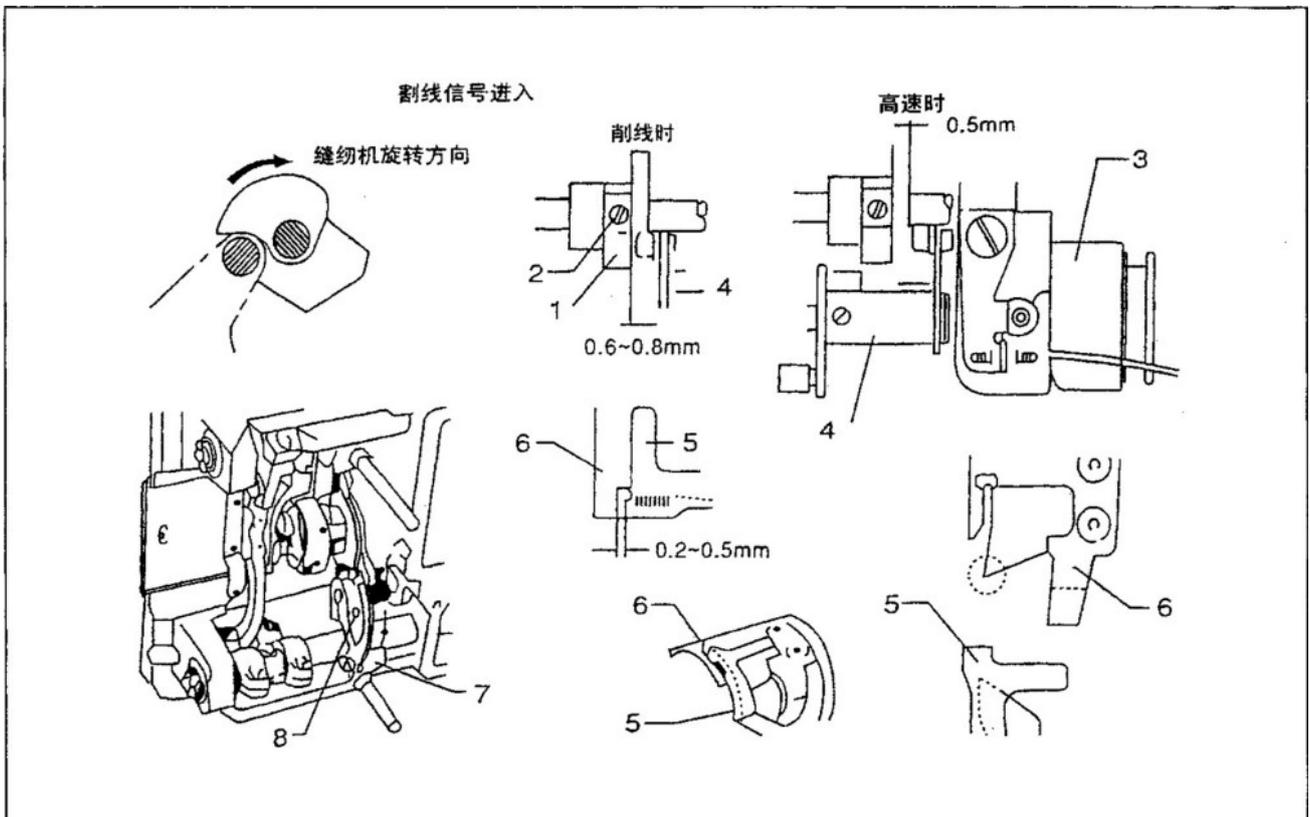
當割線凸輪控制杆④的頭部超過割線凸輪時，固定刀片⑤的前端和轉移刀片⑥的刀刃部應當嚙合 0.2-0.5 毫米。當不嚙合時，在滾輪軸超過割線凸輪的情況下移動割線控制杆④，使固定刀片⑤的前端和移動刀片⑥刀刃部相嚙合，然後擰緊螺絲⑧。

(1) Adjusting the position of thread cutting cam

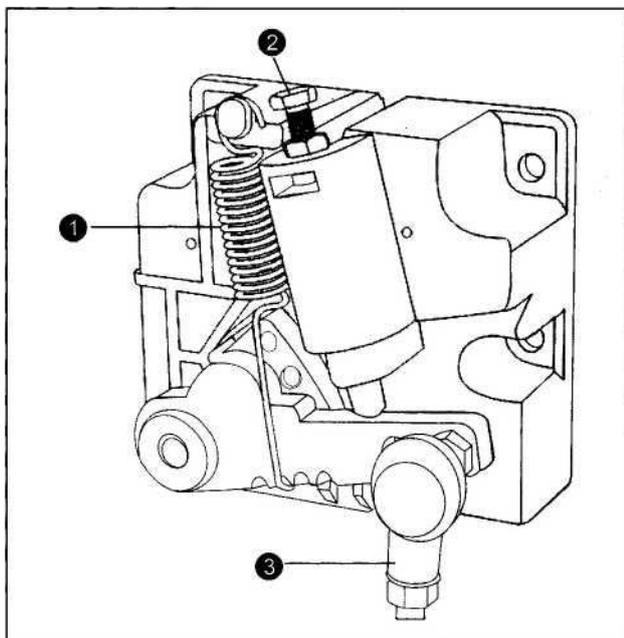
Tun the wheel of sewing machine. When the needle bar rise by 5mm form the lowest position, press the thread cutting serpentine pipe to make the roller shaft contaction the rabbet of the thread cutting cam ①and the fix with the positioning screw ②temporarily, after that adjust the thread cutting serpentine pipe ③to the original place. At the same time, loose the positioning screw ②to adjust the thread cutting wheel ②,keeping the clearance between the head face of the cam and the roller shaft to 0.5mm (Fix the positioning screw ②at a torque moment of 40kg/cm).

(2) Adjusting the place of movingknife and fixed knife

When the head of thread cutting cam controlling lever ④surpasses the thread cutting cam, the front part of the fixed knife ⑤should mesh with the edge of the moving knife ⑥in 0.2-0.5mm. When failed to mesh, move the moving thread cutting conrtrolling lever ④under the condition that roller shaft surpasses the thread cutting cam, making the front of the fixed knife ⑤to mesh with the edge of the moving knife and then fixed the screw ⑧.



24. 踏板壓力和行程/ PEDAL PRESSURE AND PEDAL STROKE



- (1) 踏板踩踏壓力的調整
 - 1) 換成前踩踏彈簧❶可以調整。
 - 2) 把彈簧掛到左側之後，壓力變輕。
 - 3) 掛到右側之後變重。
 - (2) 踏板回踩力的調整
 - 1) 用踏板回踩壓力調節彈簧❷可以調整。
 - 2) 擰進調節螺絲則壓力變大。
 - 3) 擰松調節螺絲則壓力變小。
 - (3) 踏板踩踏行程的調整
 - 1) 把連杆❸插到右側的孔裡之後行程變大。
- (1) Adjusting the pressure required to depress the front part of pedal
- 1) This pressure can be changed by changing the mounting position of pedaling pressure adjust spring ❶.
 - 2) The pressure decreases when you hook the spring on the left side.
 - 3) The pressure increases when you hook the spring on the right side.

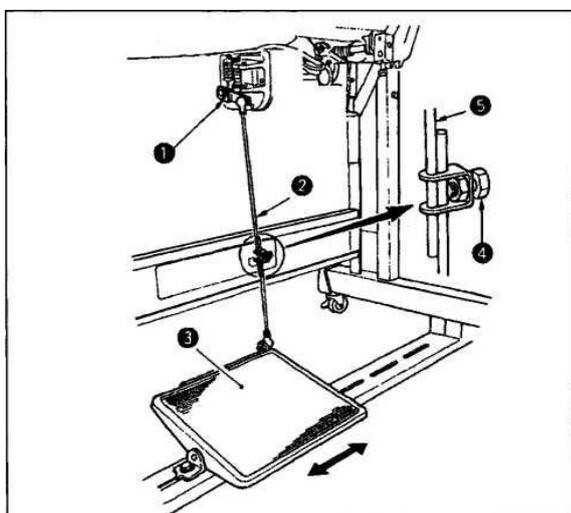
(2) Adjusting the pressure required to depress the back part of pedal

- 1) This pressure can be adjusted using regulator screw ❷.
- 2) The pressure increases as you turn the regulator screw in.
- 2) The pressure decreases as you turn the screw out.

(3) Adjusting the pedal stroke

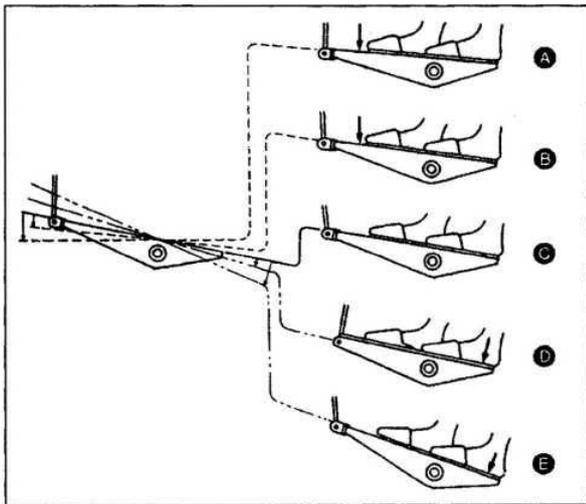
- 1) The pedal stroke increases when you insert connecting rod ❸ into the right hole.

25. 踏板的調整/ ADJUSTMENT OF THE PEDAL



- (1) 連接杆的安裝
 - 1) 向箭頭方向移動踏板調節板❸，讓踏板撥杆❶和連接杆❷呈一直線。
 - (2) 踏板的角度
 - 1) 調節連接杆的長度就可以自由地改變踏板的傾斜度。
 - 2) 擰松調節螺絲❹，拉出插入連接杆❷進行調整。
- (1) Installing the connecting rod
- 1) Move pedal ❸ to the right or left as illustrated by the arrow so that motor control lever ❶ and connecting rod ❷ are straightened.
- (2) Adjusting the pedal angle
- 1) The pedal tilt can be freely adjusted by changing the length of the connecting rod.
 - 2) Loosen adjust screw ❹, and adjust the length of connecting rod ❷.

26. 踏板操作 / PEDAL OPERATION



(1) The pedal is operated in the following four step

- 1) The machine runs at low sewing speed when you lightly depress the front part of the pedal. B
- 2) The machine runs at high sewing speed when you further depress the front part of the pedal. A
(If the automatic reverse feed stitching has been preset, the machine runs at high speed after it completes reverse feed stitching)
- 3) The machine stops (with its needle up or down) when you reset the pedal to its original position. C
- 4) The machine trims threads when you fully depress the back part of the pedal. E

*If your machine is provided with the Auto-lifter an addition step is given between the machine stop and thread trimming step. The presser foot goes up when you lightly depress the back part of the pedal D, and if you further depress the back part, the thread trimmer is actuated.

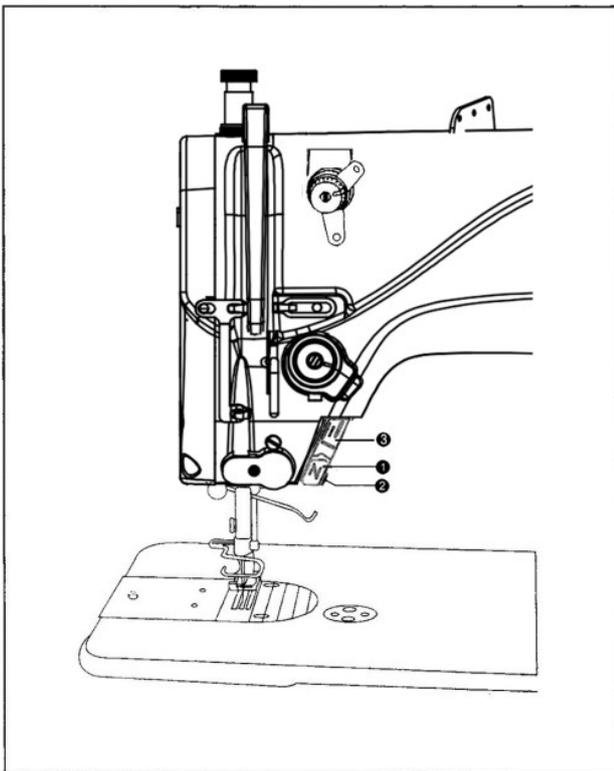
(1) 踏板按 4 個階段進行操作。

- 1) 向前輕輕踩踏板為低速縫製□。
- 2) 再用力向前踩踏板則變為高速縫製□。
(但是, 開關設定為自動倒縫時, 倒縫結束後 進行高速縫製)
- 3) 把踏板返回到腳輕輕地放到踏板上的位置縫 紉機停止□。(機針上停止或下停止位置)
- 4) 用力向後踩踏板則為切線動作□。

*使用自動壓腳提升裝置時, 在停止和切線之間增加 1 級開關。向後輕輕的踩踏板為壓腳提升動作□, 再往後用力踩踏板為切線動作。

27. 觸鍵手動倒縫/ LED 照明燈

ONE-TOUCH TYPE REVERSE FEED STITCHING MECHANISM



(1) 倒回縫鍵● 使用方法：

- 1) 按開關按鈕①, 縫紉機立即變為倒送, 進行倒縫。
- 2) 按下按鈕的時間, 可以進行倒縫。
- 3) 放開按鈕, 則立刻返回到正縫。

(1) How to operate●

- 1) The moment button ① is pressed, the machine performs reverse feed stitching.
- 2) The machine performs reverse feed stitching as long as the button is held pressed.
- 3) The machine resumes normal feed stitching the moment the button is released.

(2) LED 照明燈鍵● 使用方法：

LED 照明燈鍵②有三檔, 根據需求調節各檔亮度。

(2) How to operate Led light button ②:

According to the requirements to adjust the light. The Led light button ② has three gears.

(3) 補針縫● 使用方法：

車縫中途停止時, 按一下鍵③, 可作提針或往前補半針。

- (3) How to operate the compensation needle button. When the sewing stop, press ● button to lift the needle or forward half needle.



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