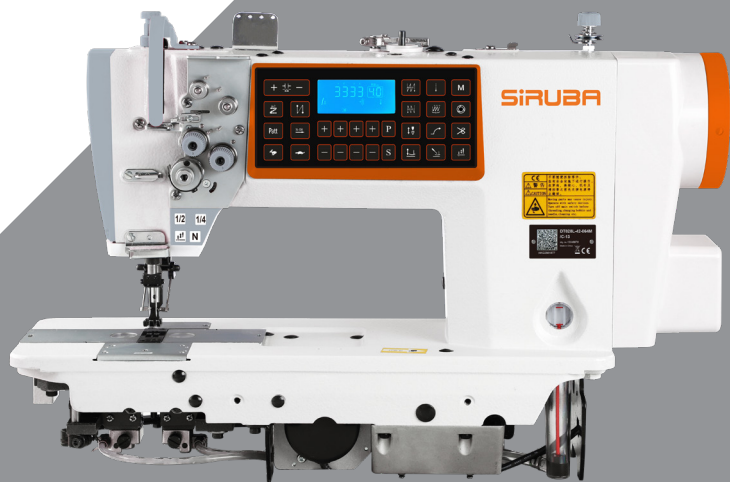


SIRUBA

使用說明書與零件圖

INSTRUCTIONS BOOK & PARTS LIST

■ DT828L



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。

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.

警告標示說明

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>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>		<p>Machine 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>	<p>一般安全標示 GENERAL SAFETY INDICATIONS</p> <p>機器運行方向 The correct direction is indicated.</p>
<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>電氣接地位置標示 Grounding connection as indicated.</p>

安全須知

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) 為了避免機器突然啟動造成意外，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。

SAFETY PRECAUTIONS

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 or 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) 所有接頭都必需要確實固定。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.

索引 INDEX

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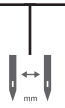
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規格

SPECIFICATION

DT828L - 4 2 - 064 M / C

A B



064 1/4"
C

自動切線
Auto thread trimmer

A		4	7
	旋梭	標準旋梭	大旋梭
	Rotary hook	Standard hook	Large hook

B		2	5
	縫製類型	標準 (固定針桿)	角縫
	Stitch function	Fixed needle bar	Split needle bar

C		M	H
	用途	薄料、中厚料	厚料
	Use	Light-weight and medium-weight materials	Heavy-weight materials

各機型參數表

MACHINE SPECIFICATIONS

		42		45		72	75
		M	H	M	H	H	H
最高縫紉速度 Max.sewing speed		3000 sti / min		3000 sti / min		3000 sti / min	3000 sti / min
最大針距 Max.stitch length		4mm	5mm	4mm	5mm	7mm	7mm
壓腳 高度 Presser foot height	壓腳扳手 Lifting lever	7mm	7mm	7mm	7mm	7mm	7mm
	自動 Automatic	8-12mm (可調)		8-12mm (可調)		8-12mm (可調)	8-12mm (可調)
		8-12mm (Adjustable)		8-12mm (Adjustable)		8-12mm (Adjustable)	8-12mm (Adjustable)
送布牙高度 Feed dog height		1mm		1mm		1mm	1mm
機針 (DP×5) Needle (DP×5)		#11-#16		#11-#16		#14-#22	#14-#22

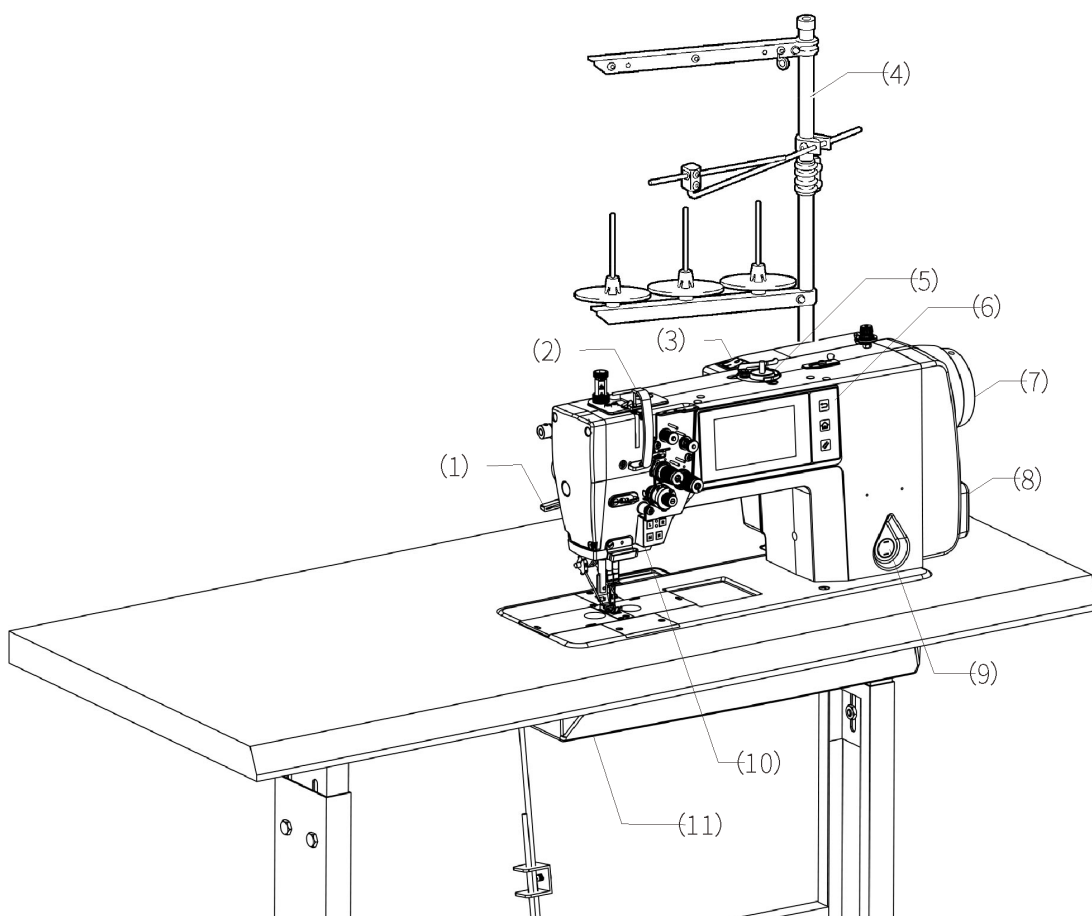
各部件名稱

- (1) 壓腳扳手
- (2) 挑線桿防護罩
- (5) 梭芯繞線裝置
- (4) 線架
- (3) 電源開關
- (6) 操作盒
- (7) 手輪
- (8) 電機罩
- (9) 油標
- (10) 倒縫開關按鈕 針桿分離按鈕 (245,275)
- (11) 油盤

NAMES OF MAJOR PARTS

NAMES OF MAJOR PARTS

- (1) Lifting lever
- (2) Thread take-up cover
- (5) Bobbin winder
- (4) Cotton stand
- (3) Power switch
- (6) Operation panel
- (7) Machine pulley
- (8) Motor cover
- (9) Oil gage window
- (10) Reverse seam switch button Needle lever release button(245,275)
- (11) Oil pan



安裝方法

INSTALLATION

請讓受過培訓的技術人員來安裝縫紉機。縫紉機安裝時必須由兩人以上來完成。在安裝完成前，請不要連接電源，如果誤踩下啟動開關時，縫紉機動作會導致受傷。縫紉機頭倒下時，請一定要固定工作台，不可使其隨意移動。工作台移動易發生腳等被夾住等事故。縫紉機頭倒下或豎起時，請雙手操作。

①關於縫紉機的安裝位置

勿將該縫紉機置於其他設備附件，如電視機、收音機或無線電話等，否則這些設備可能會被縫紉機的電子工序所影響。應將縫紉機直接插入 AC 電源插座。如果使用延長線可能會造成操作故障。

②搬運縫紉機

應按圖示由兩人用手托住機殼本體進行搬運。

③向後傾斜縫紉機頭部

用腳踏住 (B) 部分，不讓台板移動，然後用雙手推動機殼本體使縫紉機頭部後傾。

④將縫紉機頭部返回到工作時的位置

1. 清除油盤開口處附近的所有工具等物件。
2. 用左手扶住面板，用右手輕輕地將機頭返回到工作時的位置。

Machine installation should only be carried out by a qualified technician.

The installation should be carried out by two or more people.

Do not connect the power cord until installation is complete. The machine may operate if the treadle is depressed by mistake, which could result in injury.

Secure the table so that it will not move when tilting back the machine head.

If the table moves, it may crush your feet or cause other injuries.

Use both hands to hold the machine head when tilting it back or returning it to its original position.

① About the machine set-up location

Do not set up this sewing machine near other equipment such as televisions, radios or cordless telephones, otherwise such equipment may be affected by electronic interference from the sewing machine.

The sewing machine should be plugged directly into an AC wall outlet.

Operation problems may result if extension cords are used.

② Carrying the sewing machine

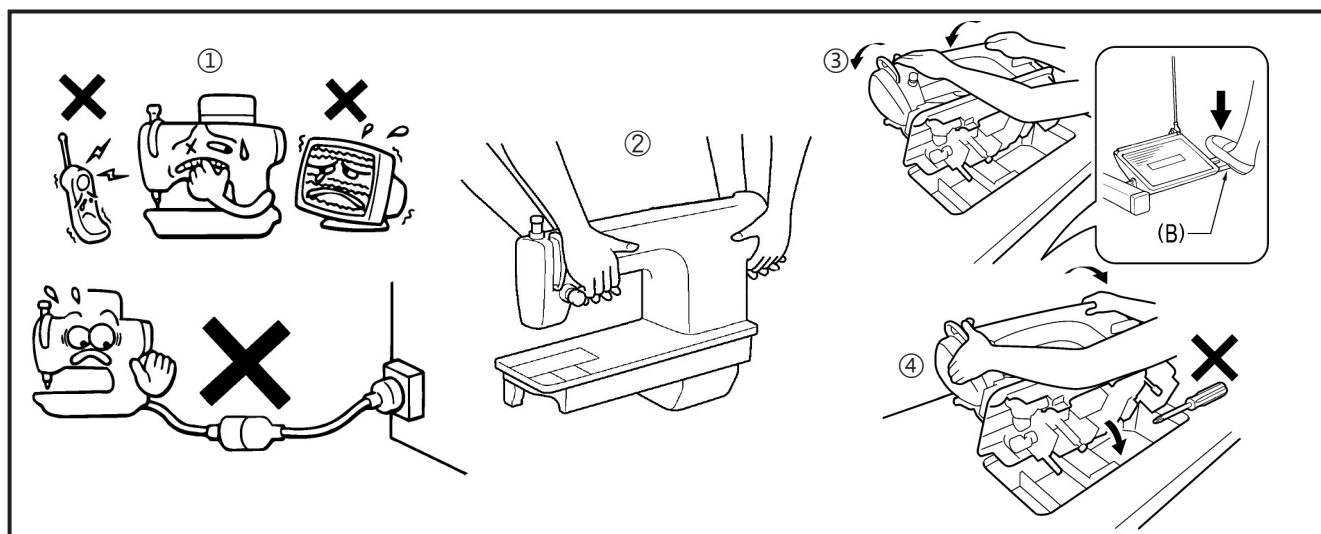
The machine should be carried by the arm by two people as shown in the illustration.

③ Tilting back the machine head

Hold section (B) with your foot so that the table does not move, and then push the arm with both hands to tilt back the machine head.

④ Returning the machine head to the upright position

1. Clear away any tools, etc. which may be near the table holes.
2. While holding the face plate with your left hand, gently return the machine head to the upright position with your right hand.

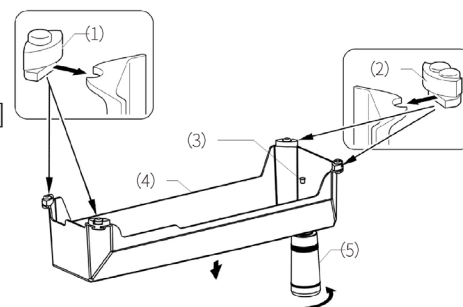


油盤

- (1) 頭部防震墊塊左 [2 個]
- (2) 頭部防震墊塊右 [2 個]
- (3) 放油橡皮塞
- (4) 油盤
- (5) 油壺

Oil

- (1) Head cushions(left) [2 pcs]
- (2) Head cushions(right) [2 pcs]
- (3) Rubber cap
- (4) Oil pan
- (5) Oiler

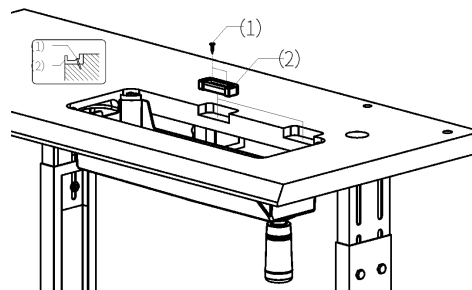


機殼鉸鏈

- (1) 釘 [4 個]
- (2) 機殼鉸鏈套 [2 個]

Rubber cushions

- (1) Nails [4pcs]
- (2) Rubber cushions [2pcs]



縫紉機頭部

- (1) 縫紉機頭部
- (2) 縫紉機鉸鏈 [2 個]
- (3) 機頭撐桿

MACHINE HEAD

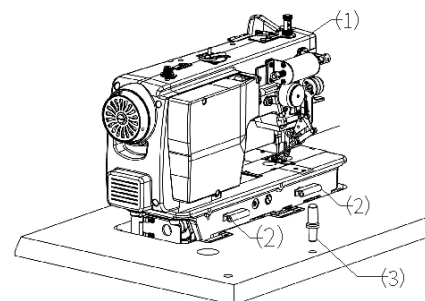
- (1) Machine head
- (2) Hinges [2pcs]
- (3) Head rest

注意

將機頭撐桿 (3) 安全、穩定地插入台板機頭撐桿孔內。
如果機頭撐桿 (3) 未插入到位則縫紉機頭部在向後傾斜時，會因為不夠穩定而發生危險。

NOTE

Tap the head rest (3) securely into the table hole.
If the head rest (3) is not pushed in as far as it will go, the machine head will not be sufficiently stable when it is tilted back.



- (1) 線架

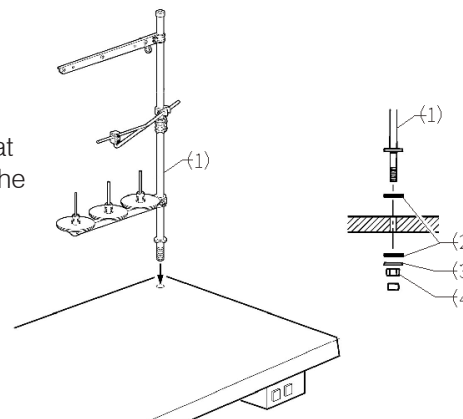
注意

將螺母 (4) 擰緊以便將兩個防震墊 (2) 和墊圈 (3) 夾緊，使線架 (1) 不會移動。

- (1) Cotton stand

NOTE

Securely tighten the nut (4) so that the two rubber cushions (2) and the washer (3) are securely clamped and so that the cotton stand (1) does not move.



加油方法

在加油未完成前，請勿插上電源。

當勿按到啟動開關時，縫紉機動作會導致人員受傷。

使用潤滑油和黃油時，務必戴好保護眼睛和保護手套等，以防潤滑油落入眼中或沾在皮膚上，會引起發炎。

將油放在孩童拿不到的地方。

潤滑油或黃油不能飲用，否則會引起嘔吐和腹瀉。

在剪去油壺的油嘴口時，請一定要拿住油壺的根部。

如果拿住油嘴口，剪刀容易傷到手，成為受傷的原因。

①必須經常潤滑縫紉機，第一次使用縫紉機或長時間未使用縫紉機時，要補充機油。

1. 握住油壺 (1) 油嘴基座，並用剪刀沿油嘴的直線段 (A) 剪下一半左右。
2. 擰鬆並移除油嘴，然後移除油封 (2) 。
3. 擰緊油嘴。

②給油盒加油

1. 油壺 (1) 的油嘴插入加油橡皮塞 (5) 孔內，注入潤滑油，直到潤滑油的液位到達油標 (3) 的頂部基線 (2) 處。

* 當潤滑油的液位下降到基準線 (4) 以下時，請務必補充潤滑油。

Lubrication

Do not connect the power cord until lubrication has been completed, otherwise the machine may operate if the treadle is depressed by mistake, which could result in injury.

Be sure to wear protective goggles and gloves when handling the lubricating oil and grease, so that they do not get into your eyes or onto your skin, otherwise inflammation can result. Keep the oil out of the reach of children.

Do not drink the oil or eat the grease under any circumstances, as they can cause vomiting and diarrhea.

When cutting the nozzle of the oil tank, hold the base of the nozzle securely.

If you hold the end of the nozzle, injury from the scissors may result.

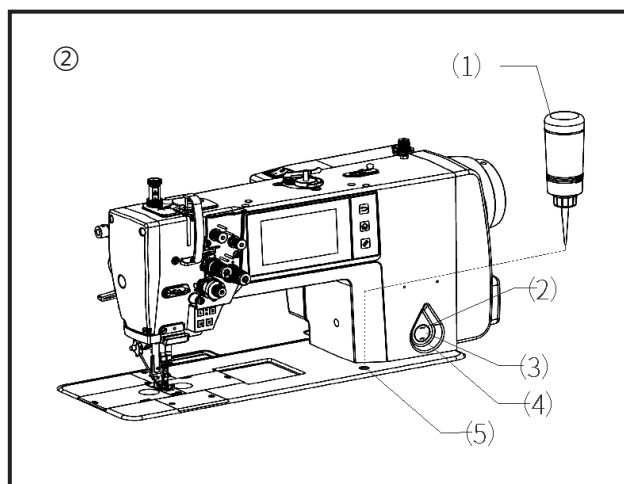
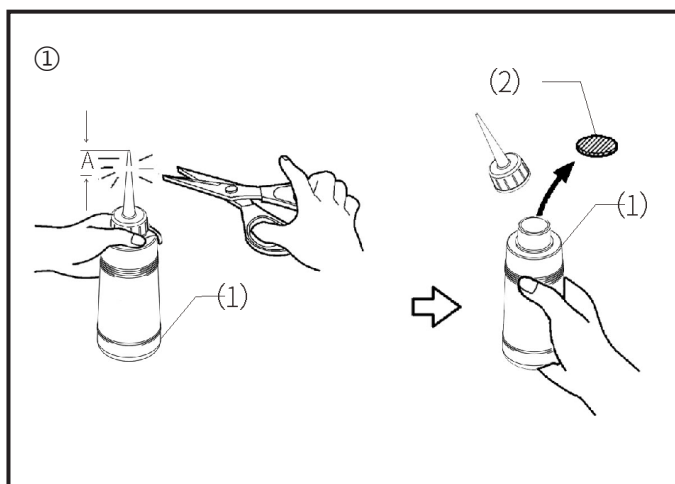
① The sewing machine should always be lubricated and the oil supply replenished before it is used for the first time, and also after long periods of non-use.

1. Hold the base of the nozzle of the accessory oil tank (1) and use scissors to cut about half-way along the straight section (A) of the nozzle.
2. Loosen and remove the nozzle, and then remove the seal (2).
3. Tighten the nozzle.

② Oil box refueling

1. Insert the nozzle hole filling rubber oil. use the accessory oil tank (1) to pour in lubricating oil until the oil level reaches the top reference line (2) of the oil gauge window (3).

* If the lubricating oil level drops below the bottom reference line (4), be sure to add more oil.



縫紉前的準備

PREPARATION BEFORE SEWING

機針的安裝方法

安裝機針時，請切斷電源。

當誤按動開關時，縫紉機動作會導致人群受傷。

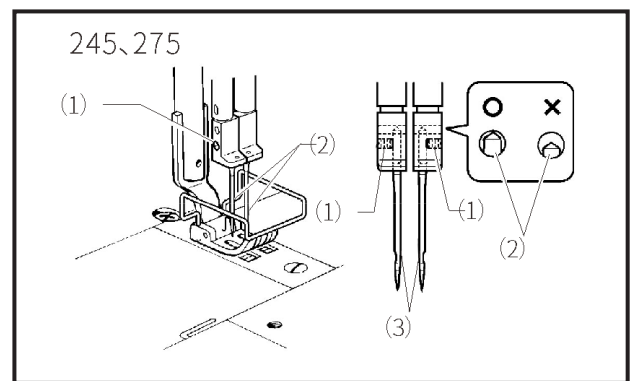
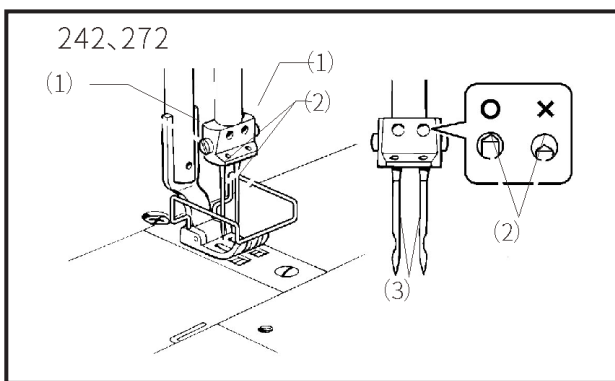
1. 轉動縫紉機上輪，將針桿移動到最高位置。
2. 鬆開螺釘 (1)。
3. 將機針 (2) 上的長槽 (3) 朝著內側，筆直插到底並擰緊止動螺釘 (1)。

Installing the needle

Turn off the power switch before installing the needle.

The machine may operate if the treadle is depressed by mistake, which could result in injury.

1. Turn the machine pulley to move the needle bar to its highest position.
2. Loosen the screws (1).
3. Insert the needle (2) straight in as it will go so that the long groove is facing inward, and then securely tighten the screws (1).



梭芯的裝拆方法

取出梭芯時，請切斷電源。

當誤按動開關時，縫紉機動作會導致人員受傷。

Removing the bobbin

Turn off the power switch before removing the bobbin.

The machine may operate if the treadle is depressed by mistake, which could result in injury.

① 掛鉤式

1. 將推板 (1) 左右分開。
2. 將旋鎖的捏手 (2) 提起之後，取出梭芯 (3)。

① Latch type

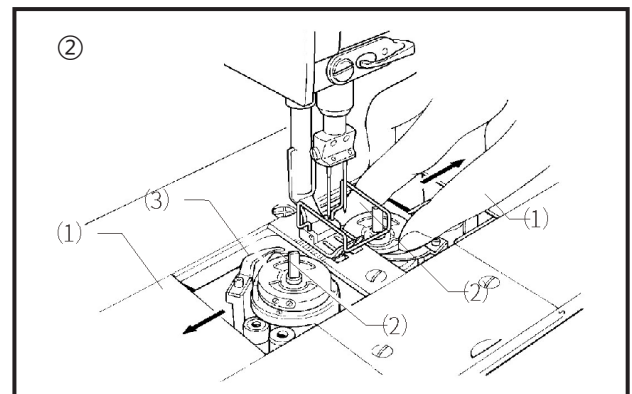
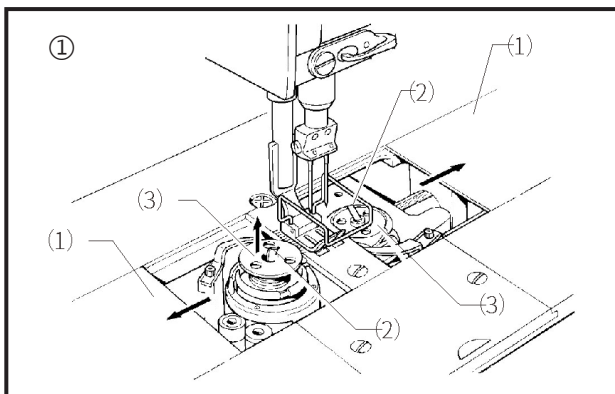
1. Open the slide plates (1) by moving them to the right and left.
2. Pull the rotary hook latches (2) upward, and then remove the bobbins (3).

② 梭芯套式

1. 將推板 (1) 左右分開。
2. 將旋鎖的捏手 (2) 提起之後，取出梭芯套 (3)。
3. 取出梭芯。

② Bobbin case type

1. Open the slide plates (1) by moving them to the right and left.
2. Lift up the latch (2) of the rotary hook, and then remove the bobbin case (3).
3. Remove the bobbin.



在繞線過程中，不用觸摸任何運動部件或將物件靠在運動部件上，以為這會導致人員受傷或縫紉機損壞。

1. 打開電源開關。
2. 將梭芯 (1) 置於梭芯卷線軸 (2) 上。
3. 按箭頭所示的方向將線在梭芯 (1) 上捲繞幾圈。* 請確認各部分的機線應沒有鬆弛。
4. 將梭芯壓臂柄 (3) 推向梭芯 (1)。
5. 用壓腳扳手腳壓腳抬起。
6. 踏下腳踏板，隨即開始捲繞底線。
7. 底線繞線一旦完成，梭芯壓臂柄 (3) 將自動返回。
8. 底線繞線之後，將梭芯拆下，用切刀 (4) 將線剪斷。

* 鬆開螺釘 (5)，移動梭芯壓桿 (6) 調節繞線在梭芯上的底線量。

注意：

繞線在梭芯上的底線量最多應為梭芯容量的 80%。

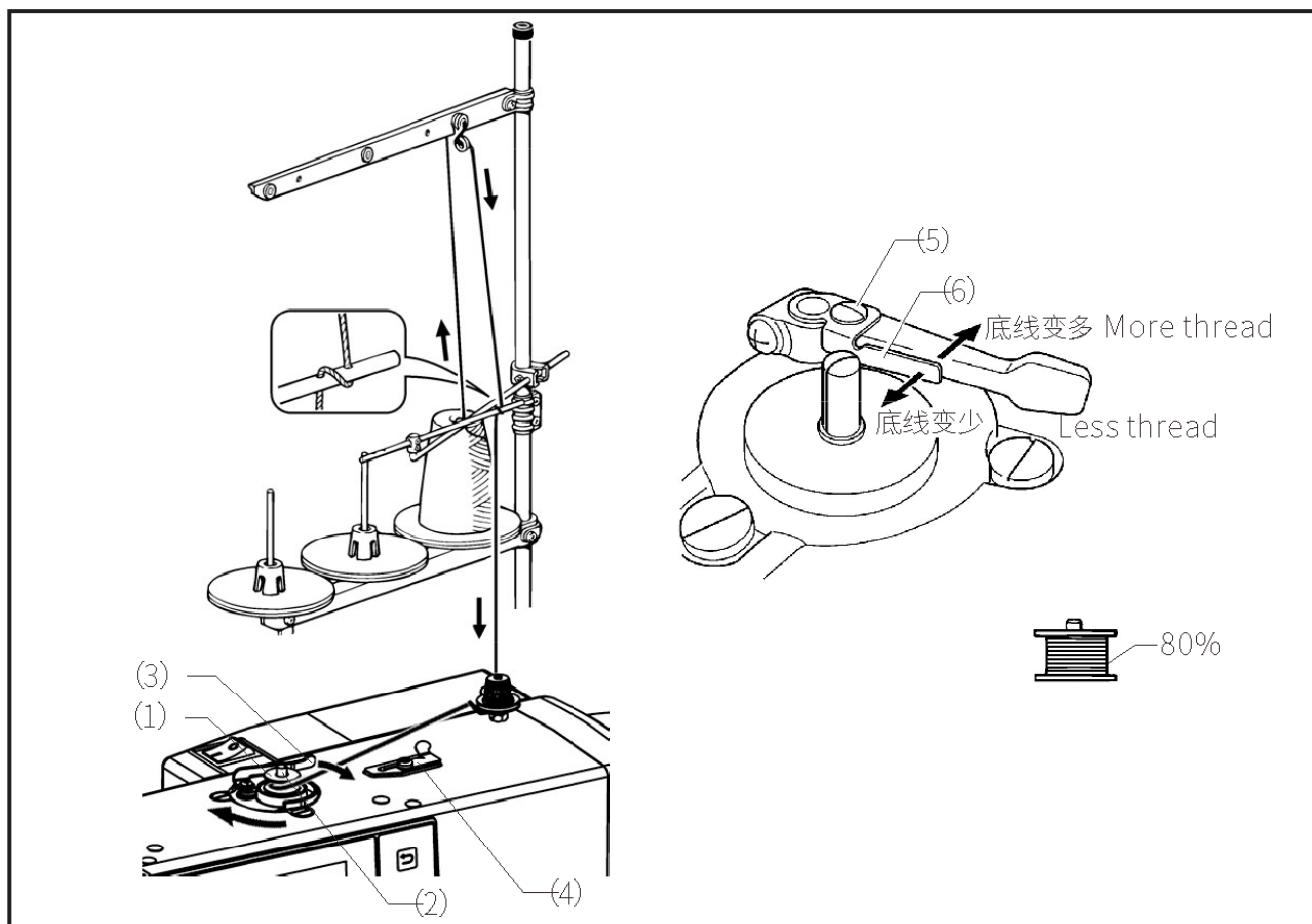
Do not touch any of the moving parts or press any objects against the machine while winding the lower thread, as this may result in personal injury or damage to the machine.

1. Turn on the power switch.
2. Place the bobbin (1) onto the bobbin winder shaft (2).
3. Wind the thread several times around the bobbin (1) in the direction indicated by the arrow.
* Check that the thread is not loose anywhere along the thread path.
4. Push the bobbin presser arm (3) toward the bobbin (1).
5. Raise the presser foot with the lifting lever.
6. Depress the treadle. Lower thread winding will then start.
7. Once winding of the lower thread is completed, the bobbin presser arm (3) will return automatically.
8. After the thread has been wound on, remove the bobbin and cut the thread with the knife (4).

* Loosen the screw (5) and move the bobbin presser (6) to adjust the amount of thread wound onto the bobbin.

NOTE :

The amount of thread wound onto the bobbin should be a maximum of 80% of the bobbin capacity.



梭芯的裝取方法

取出梭芯時，請切斷電源。

當誤按動開關時，縫紉機動作會導致人員受傷。

掛鉤式

1. 將線的繞向置於如圖所示的方向，然後將梭芯 (1) 放入旋鎖 (2) 內。
2. 將旋鎖的捏手 (3) 倒下。
3. 轉動縫紉機手輪，使旋鎖 (2) 轉到能見到張力彈簧 (4) 的位置。
4. 將線穿過旋鎖的線槽 (5)，使它通過張力彈簧 (4) 的下面。
5. 將線拉出約 50mm。
6. 關閉左右推板。

旋鎖中有旋鎖空轉防止簧 (6)。旋鎖空轉防止簧 (6) 可防止梭芯在剪線等情況下空轉。

Installing the bobbin

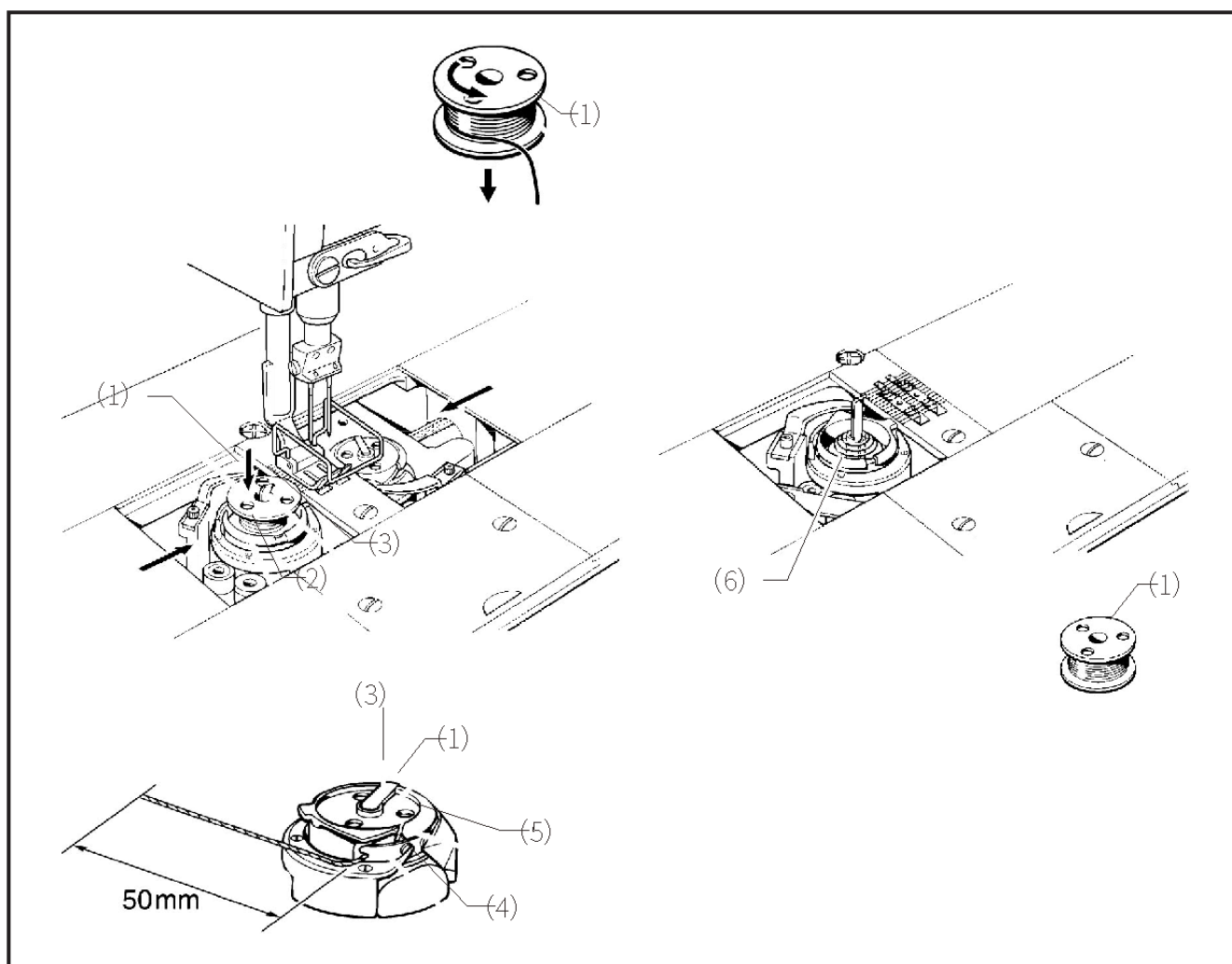
Turn off the power switch before removing the bobbin.

The machine may operate if the treadle is depressed by mistake, which could result in injury.

Latch type

1. Insert the bobbin (1) into the rotary hook (2) so that the winding direction is as shown in the illustration.
2. Return the rotary hook latch (3) to its original position.
3. Turn the machine pulley to rotate the rotary hook (2) until the tension spring (4) is visible.
4. Pass the thread through slit (5) in the rotary hook and then pass it under the thread tension spring.
5. Pull out the thread to a length of approximately 50 mm.
6. Close the slide plates.

There is an anti-spin spring (6) inside the rotary hook. The anti-spin spring (6) prevents the bobbin from racing at times such as during thread trimming.



梭芯套式

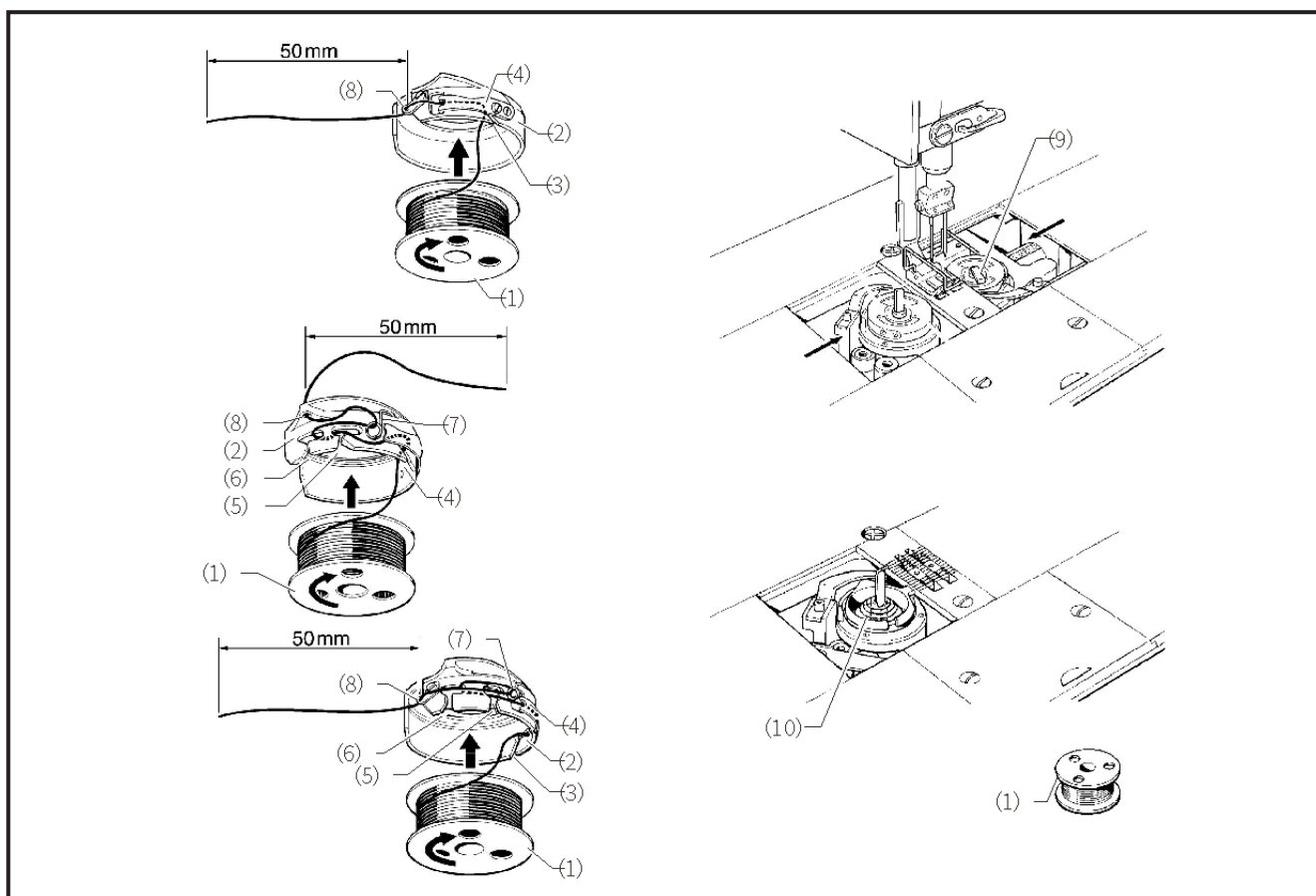
1. 將線的繞向置於如圖所示的方向，然後將梭芯 (1) 放入梭芯套 (2) 內。
2. 梭芯套 (2) 有 A、B、C 三種。請根據所使用的梭芯套 (2) 的形狀，按下述方式進行穿線。
 - A. <1> 將線穿過線槽 (3)，使它通過張力彈簧 (4) 的下面。
<2> 將線穿過線孔 (8)，並拉出約 50mm。
 - B. C.
 - <1> 將線穿過線槽 (3)，使它通過張力彈簧 (4) 的下面。
 - <2> 將線穿過線槽 (5)、(6)，使它鉤在底線張力彈簧 (7) 上。
 - <3> 將線穿過線孔 (8)，並拉出約 50mm。
3. 將梭芯套 (2) 放入旋梭內。
4. 將旋梭的捏手 (9) 倒下。
5. 關閉左右推板。

旋梭中有防梭芯空轉彈簧 (10)。防空轉彈簧 (10) 可防止梭芯在剪線等情況下空轉。

Bobbin case type

1. Insert the bobbin (1) into the bobbin case (2) so that the winding direction is as shown in the illustration.
2. There are three types of cap (2) A,B,C. Thread the thread by one of the following methods in accordance with the shape of the bobbin case (2) being used.
 - A. <1> Pass the thread through slot (3) and under the thread tension spring (4).
 - <2> Pass the thread through the thread hole (8) and pull out about 50 mm.
- B. C.
 - <1> Pass the thread through slot (3) and under the thread tension spring (4).
 - <2> Pass the thread through slots (5) and (6), and then through the spring (7).
 - <3> Pass the thread through the thread hole (8) and pull out about 50 mm.
3. Insert the bobbin case (2) into the rotary hook.
4. Push latch (9) of the rotary hook flat.
5. Close the slide plates.

There is an anti-spin spring (10) inside the rotary hook. The anti-spin spring (10) prevents the bobbin from racing at times such as during thread trimming.



面線的穿法

在穿線過程中，請切斷電源。

當誤按動開關時，縫紉機動作會導致人員受傷。

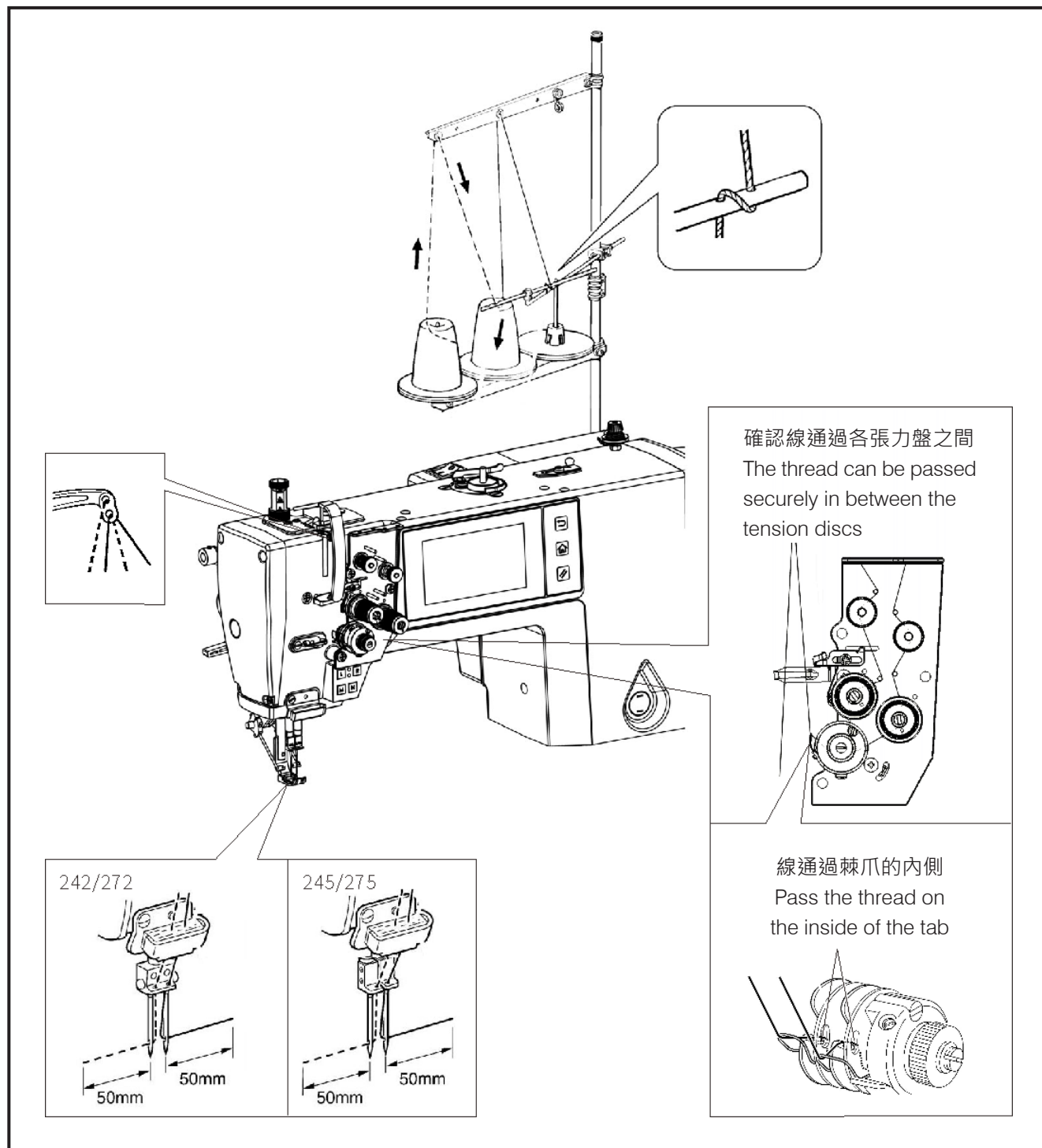
1. 在穿面線之前轉動上輪，抬高挑線桿。
這樣會使穿線更加容易，並防止面線在縫紉開始時脫落。
2. 先穿左側的面線。

Threading the upper thread

Turn off the power switch before threading the upper thread.

The machine may operate if the treadle is depressed by mistake, which could result in injury.

1. Turn the machine pulley and raise the thread take-UP (1) before threading the upper thread. This will make threading easier and it will prevent the thread from coming out at the sewing start.
2. Thread the left-side thread first.

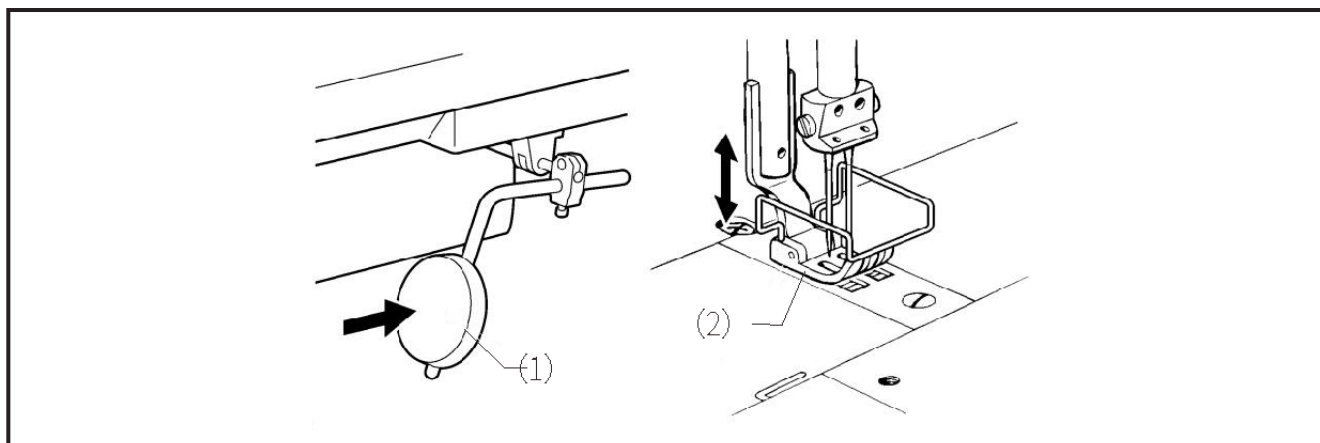


膝控碰塊的使用方法

按動膝控碰塊 (1) 可抬高壓腳 (2) 。

Using the knee lifter

The presser foot (2) can be raised by pressing the knee lifter plate (1).



角形縫製方法

注意：要將本縫紉機作為單針縫紉機使用時，請把不使用一側的機針拆掉後再進行縫紉。請使用下述的針桿停止方法，否則可能會導致縫紉機損壞。

針桿 (左、右) 的停止方法

請在機針扎在布上且機器停止後再按按鈕 L 或 R 。

① < 左側針桿的停止操作 >

按下按鈕 L

② < 右側針桿的停止操作 >

按下按鈕 R

角形縫製方法

1. 在操作盒上設置好轉角角度。
2. 機針扎在布上且機器停止，確認好轉角縫製的方向，按下相對應的針桿停止控制按鈕 L 或 R。
3. 踏下啟動踏板，開始縫製一段距離，機器停止且壓腳抬起，手動將縫料轉動到預設置的角度。
4. 踏下啟動踏板，機器開始運動，針桿自動恢復到雙針桿縫製。

Corner sewing method

NOTE: If using this machine in place of a single-needle machine, remove the needle which is not being used. In such cases, do not use the procedures given below to stop the unused needle bar from moving, otherwise damage to the machine may result.

TO stop the needle bars

Press the button L or R after the needle has penetrated the material and has stopped moving.

① < To stop operation of the left needle bar >

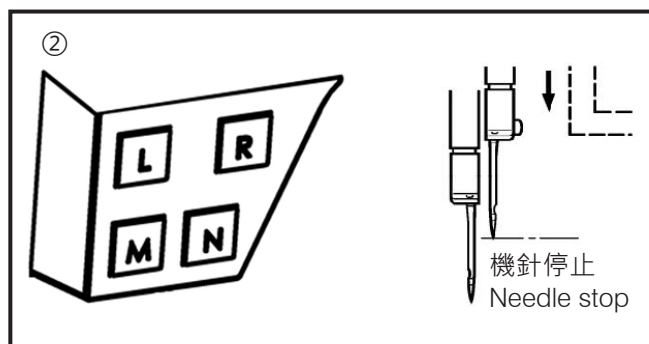
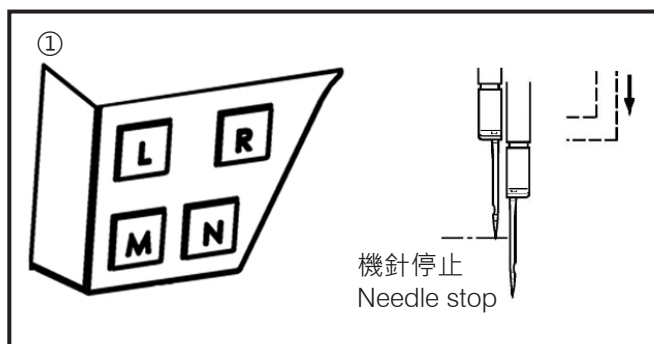
Press the button L

② < To stop operation of the right needle bar >

Press the button R

Angle sewing method

1. Set the corner angle on the operating box
2. The needle has penetrated the material and has stopped moving. Confirm the direction of corner sewing, press the corresponding stop control button L or R of needle bar.
3. Step on the starting pedal, start sewing a distance, the machine stops and presser feet lift, manually turn the seam to the pre-set angle.
4. Step on the starting pedal, the machine starts to move, the needle bar automatically restores to the double needle rod to sew.



縫紉

SEWING

為了安全起見，在使用本縫紉機之前，請安裝保護裝置。

如果未安裝這些安全裝置就使用縫紉機，會造成人身傷害及縫紉機損壞，發生下列情況時，請切斷電源，否則誤踩下啟動踏板時，縫紉機動作會導致受傷。

- 機針穿線時
- 更換機針或梭芯時
- 縫紉機不使用或人離開縫紉機時

縫紉過程中，不要觸摸任何運動部件或將物件靠在運動部件上，因為會導致人員受傷或縫紉機損壞。

縫紉機頭倒下時，請一定要固定工作台，不可使其隨意移動，工作台移動易發生腳等被夾住等事故。

縫紉機頭倒下或豎起時，請用雙手進行操作，單手操作時因縫紉機自身的重量，萬一滑落易導致受傷。

Attach all safety devices before using the sewing machine. If the machine is used without these devices attached, injury may result.

Turn off the power switch at the following times, The machine may operate if the treadle is depressed by mistake, which could result in injury.

- When threading the needle
- When replacing the bobbin and needle
- When not using the machine and when leaving the machine unattended

Do not touch any of the moving parts or press any objects against the machine while sewing, as this may result in personal injury or damage to the machine.

Secure the table so that it will not move when tilting back the machine head. If the table moves, it may crush your feet or cause other injuries.

Use both hands to hold the machine head when tilting it back or returning it to its original. If only one hand is used, the weight of the machine head may cause your hand to slip, and your hand may get caught.

①縫紉

1. 一邊用手握住面線，一邊用手逆時針轉動手輪，以將底線拉到送布齒上面。
2. 將底線朝自己身邊方向拉，底線應能平穩地伸出。
3. 踏下啟動踏板開始縫紉。

① Sewing

1. While holding the two upper threads with your fingers, turn the machine pulley by hand toward you until the lower threads come out onto the feed dog.
2. Pull the lower threads toward you and check that they pull out smoothly.
3. Step on the starter and start sewing.

②倒縫加固的方法

按下倒縫裝置按鈕開關 N (1) 時，送料方向將會方向，實現倒縫功能。釋放時，送料方向恢復正常。

② Backtacking

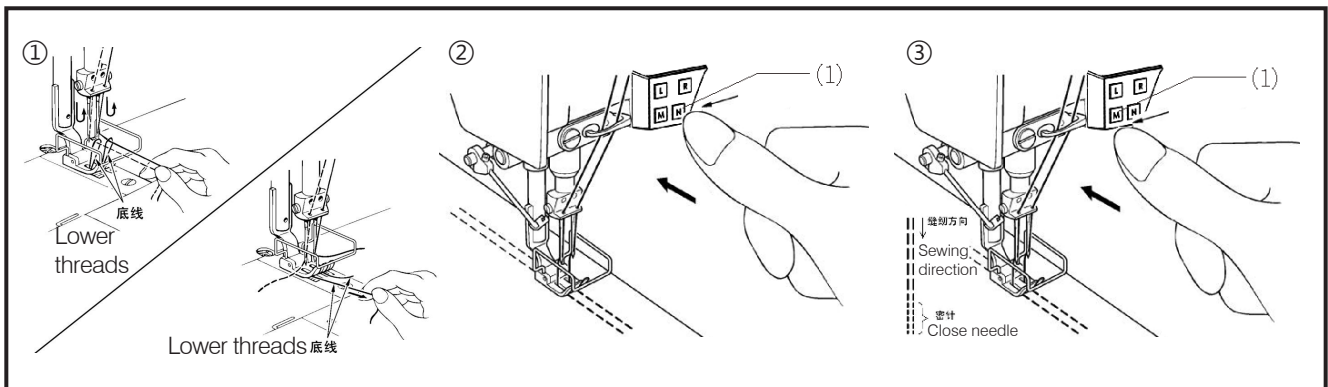
When the actuator switch N (1) is pressed during sewing, the feed direction will be reversed. When it is released, the feed direction will return to normal.

③密縫的方法

1. 在操作盒上設置好密封針距長度。
2. 按下密縫裝置按鈕開關 M (1) 時，可以用小的針距進行縫紉。釋放時，針距大小恢復正常縫紉。

③ Sewing condensed stitches

1. In the operating box set close needle length.
2. Press the close seam device button, switch M (1), you can use small. Sewing the needle spacing. When released, the distance between the needles is restored Ordinary sewing.

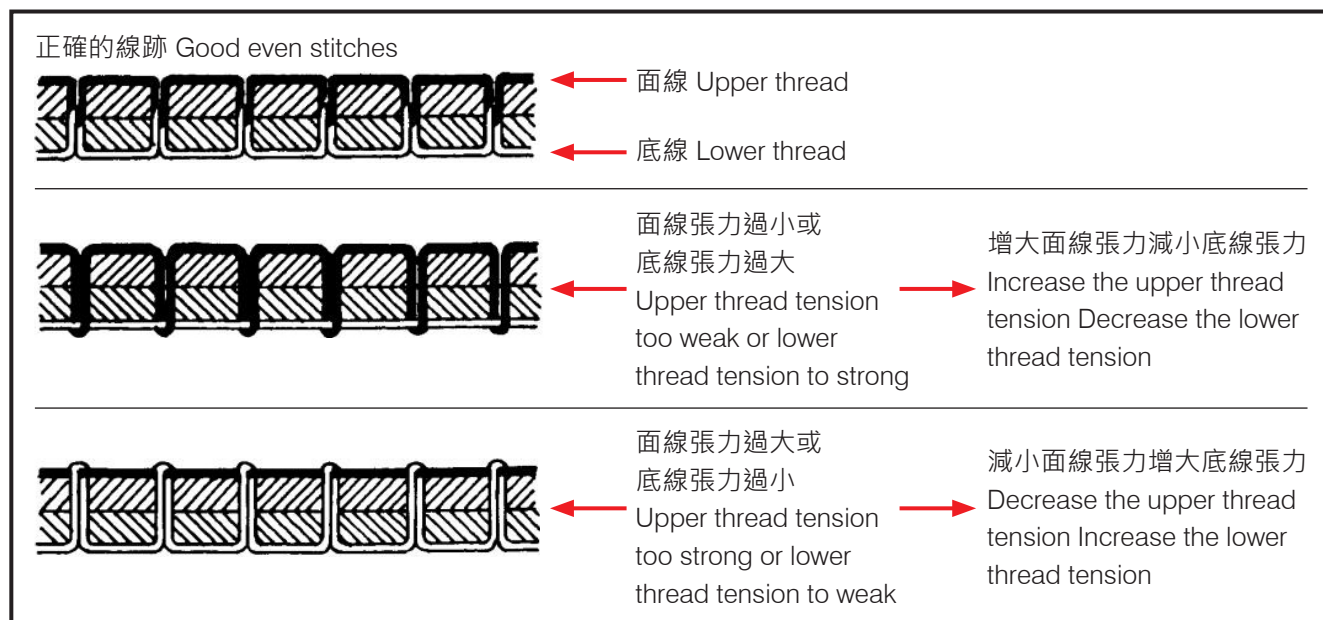


縫紉效果

THREAD TENSION

調節線張力

Adjusting the thread tension



底線張力調節

在進行底線張力調整前先關閉電源開關如果誤踩下啟動踏板，縫紉機動作會導致人員受傷。

轉動底線張力。螺釘（1）進行調節。

Lower thread tension

Turn off the power switch before adjusting the lower thread tension. The machine may operate if the treadle is depressed by mistake, which could result in injury.

Turn the adjusting screw (1) to adjust.

面線張力調節

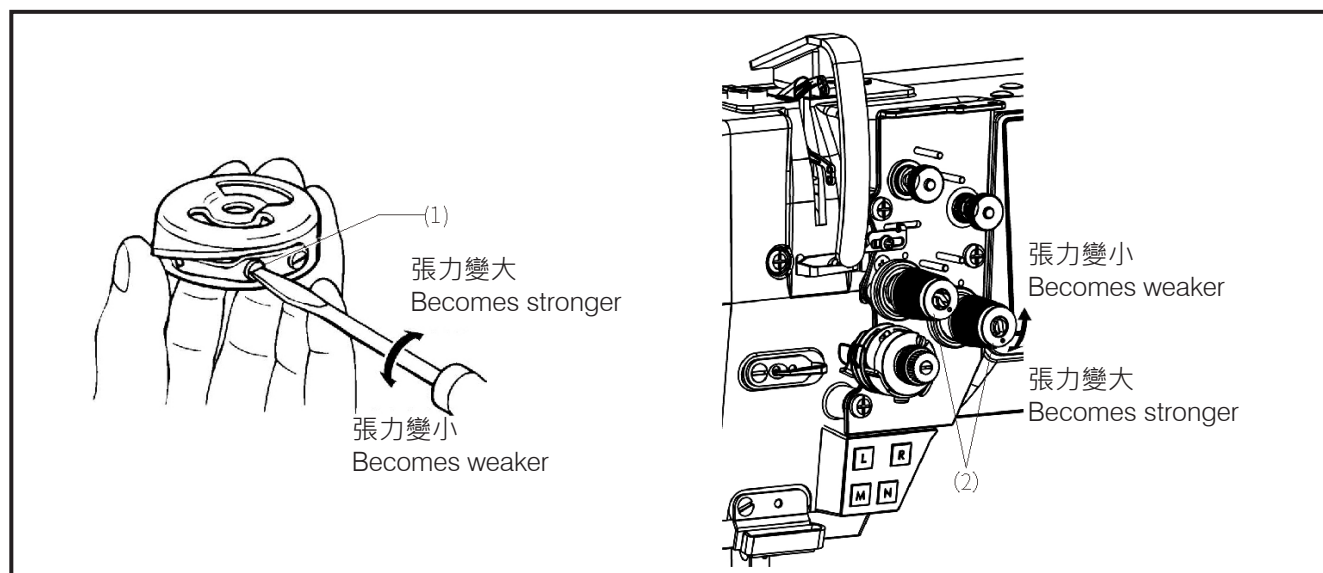
在底線張力調節之後，調節面線張力使線跡均勻平整。

1. 壓腳放下。
2. 轉動夾線螺母（2）進行調節。

Upper thread tension

After the lower thread tension has been adjusted, adjust the upper thread tension so that a good, even stitch is obtained.

1. Lower the presser foot.
2. Adjust by turning the tension nut (2).



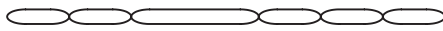
調節壓腳壓力

Adjusting the presser foot pressure



正確縫紉

Correct Stitches



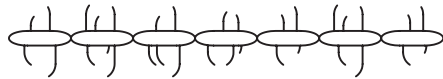
跳針

Skipped Stitches



縫距不平均→押腳壓力增強

Uneven stitch → Increase the pressure of the presser foot



產生縐折→押腳壓力減弱

Wrinkles occurred → Reduce the pressure of the presser foot

①應盡可能減小壓腳壓力，但需有足夠壓力使布料不致滑動。（以下表的“壓腳調節螺栓高度”為大致標準進行調節）。

1. 鬆開調節螺母（1）。
2. 轉動壓腳調節螺栓（2）以調節壓腳壓力。
3. 擰緊調節螺母（1）。

① The presser foot pressure should be as weak as possible, but strong enough so that the material does not slip. (Refer to "Adjusting screw height" in the table below as a guide to adjustment).

1. Loosen the adjusting nut (1).
2. Turn the presser adjusting screw (2) to adjust the presser foot pressure.
3. Tighten the adjusting nut (1).

參考值 Reference values

用途	Use	壓腳調節螺栓高度	Adjusting screw height
女士內衣用	FOR Foundation	約 34mm	Approx 34mm
薄料和中厚料	Light-weight and medium-weight	約 34mm	Approx 34mm
厚料	Heavy-weight materials	約 29mm	Approx 29mm

②剪線後面線殘留長度的調節

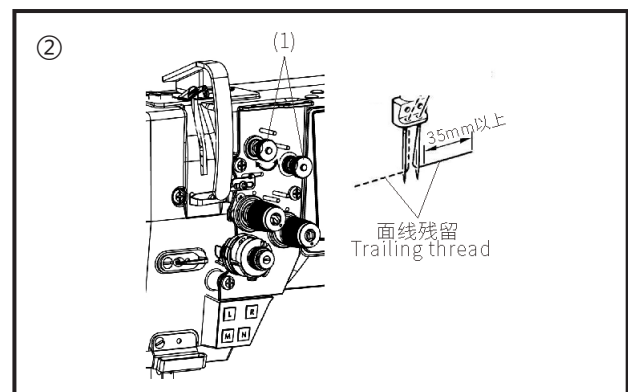
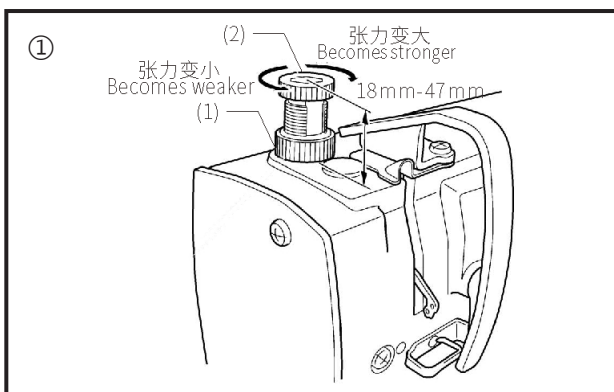
剪線時，線張力鬆弛，可以用夾線器（1）施加張力，面線的正常殘餘量為35mm。

如果增加夾線器（1）的張力，切線後面線殘留長度將會減少；減小張力，面線殘留長度將轉會動增夾加線器（1）進行調節，順時針轉動（1），面線殘留長度變短；逆時針轉動（1），面線殘留長度變長。

② Adjusting the trailing length after thread trimming

At the time of thread trimmind, the thread tension is loosened and tension is applied by the pretension (1) only. The normal trailing length for the upper thread is 35 mm.

If the tension of the pretension (1) is increased, the lengths of the threads trailing from the needle tips will be reduced; If the tension is reduced, the lengths will be increased. Adjust by turning the pretension (1). Turn clockwise (1), and the length of the residual length of the surface is shortened, otherwise, the length becomes longer.



挑線量的調節

採用向線量調整器 (1) 穿過線的方法來調節挑線量

標準線量調整器 (1) 的使用方法

- 線不穿過線量調整器 (1)，鬆開固定螺釘 (2)，將線量調整器 (1) 移向右側
- 線穿過線量調整器 (1)，固定螺釘 (2) 被置於調整範圍的中間狀態時，就是線量調整器 (1) 的標準位置

挑線量的調節

線穿過線量調整器 (1) 進行調節，越將線量調整器 (1) 向右移則挑線量越少

線不穿過線量調整器 (1) 適用於下列情況

- 用女士內衣規格的縫紉機縫製厚布料時
- 要加長針距等而挑線量不夠時

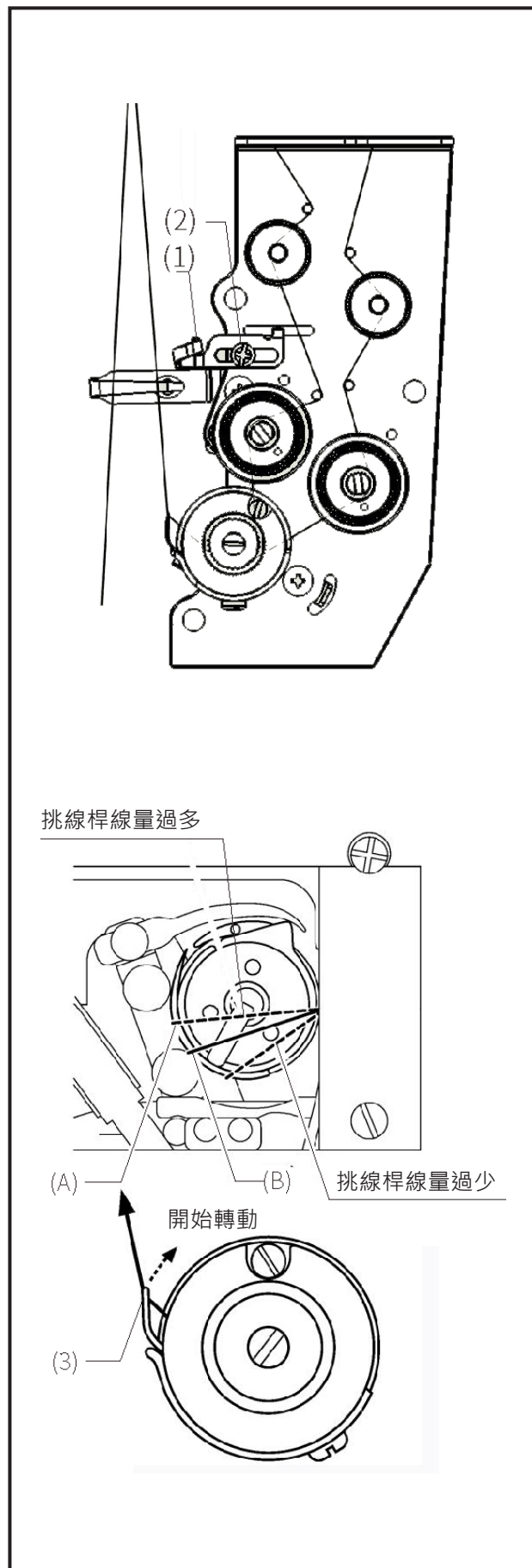
線穿過線量調整器 (1) 適用於下列情況

- 使用易滑的機針線時
- 縫製薄的布料時
- 以 2mm 以下的針距進行縫紉時

調整基準

旋梭尖端補充上線環，使環移動到旋梭線量最大的點 (A) 的近前方 (B) 為止時，挑線簧 (3) 開始運動，這就是標準的挑線桿線量

- 如果挑線桿的線量很多，那麼即使經過了 (A)，挑線簧 (3) 也不會開始移動，會造成跳針、機線鬆緊如不果良挑、線斷桿線的線量少，挑線簧 (3) 從 (B) 跟前開始移動，會造成斷線、面線過緊、拉線
- 由於線的種類、布料的厚度、針距的大小的不同，挑線桿需要的線量會改變，所以請根據縫製條件來進行調整。



Adjusting the thread take-up amount

Using the standard thread amount adjuster (1)

- Do not pass the thread through the thread amount adjuster (1), Loosen the screw (2) and slide the thread amount adjuster (1) to the right-side position.
- Pass the thread through the thread amount adjuster (1). The standard position of the thread amount adjuster (1) is when the screw (2) is in the center of the adjustment range.

Adjusting the thread take-up amount

When the thread has been passed through the thread amount adjuster (1), the thread take-up amount becomes less when the thread amount adjuster (1) is moved to the right.

It is better not to pass the thread through the thread amount adjuster

- When sewing heavy materials using a sewing machine with foundation specifications.
- When the thread take-up amount is not enough, such as when the stitch length is increased.

It is better to pass the thread through the thread amount adjuster

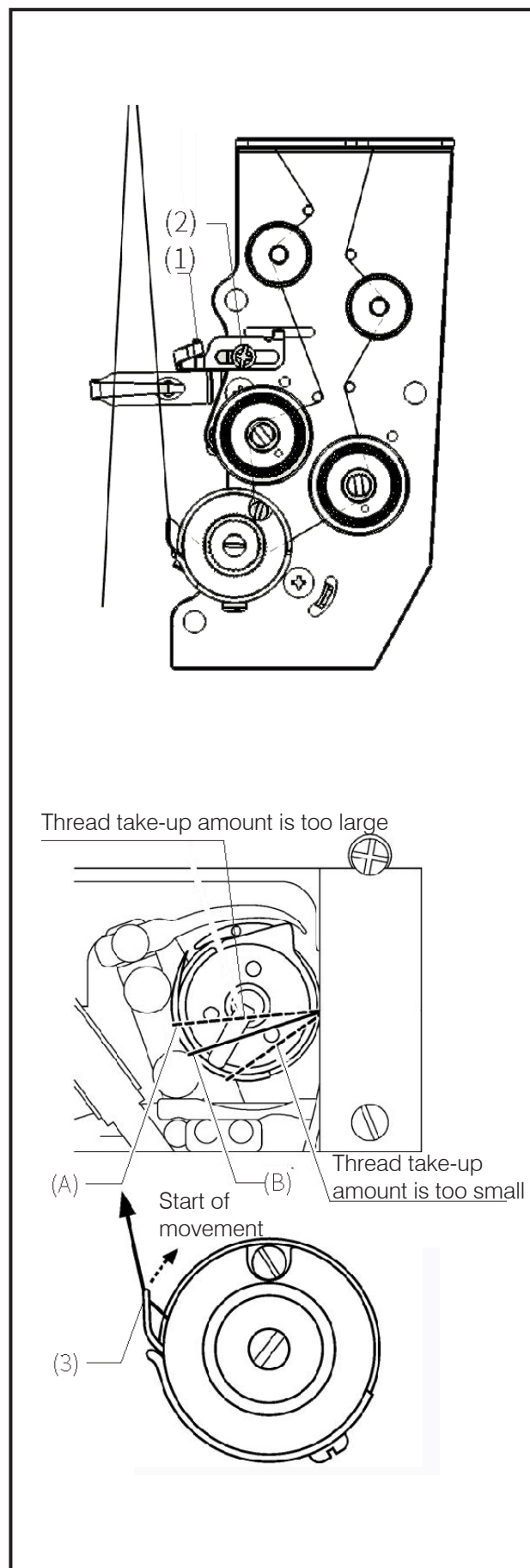
- When sewing with slippery threads such as synthetic yarns
- When sewing light materials
- When sewing with a stitch length of 2 mm or less

Guide to adjustment

The standard thread take-up amount is when the thread tension spring (3) starts to move when the loop is moved to point (B) which is slightly in front of point (A) where the rotary hook tip catches the upper thread loop and the rotary hook thread amount is at its aximum.

- If the thread take -up amount is too large, the thread tension spring (3) will not start to move even after point (A) is passed This can cause skipped stitches, poor thread tightening and thread breakages.
- If the thread take -up amount is too small, the thread take-up spring (3) will start moving before point (B) This can cause thread breakages, overtightening of the upper thread and pulling of the seam.

The thread take-up amount required will vary depending on the type of thread, the thickness of the material and the stitch length, so adjust the thread take-up amount to suit the sewing conditions.



保養

CLEANING

注意

在開始清潔作業前，請切斷電源。

當誤按動開關時，縫紉機動作會導致人員受傷。

使用潤滑油和黃油時，務必戴好保護眼睛和保護手套等，以防潤滑油落入眼中或沾在皮膚上，會引起發炎。

縫紉機頭倒下時，請一定要固定工作台，不可使其隨意移動。

工作台移動易發生腳等被夾住等事故。

縫紉機頭倒下或豎起時，請用雙手進行操作。

單手操作時因縫紉機自身的重量，萬一滑落易導致受傷。

日常清潔

為了保持縫紉機的機能，而且能長久的使用，請每天進行日常保養。

另外，縫紉機如果長時間未使用，請在進行瞭如下的保養後在使用。

保養

1. 轉動手輪，將機針置於最高位置
2. 將左右推板按圖示方向打開
3. 取出梭芯
4. 清除旋梭內的線頭等雜物
5. 安裝好梭芯
6. 左右推板恢復到以前位置

補充機油

當潤滑油的液位下降到油量計視窗 (1) 的下基線 (2) 以下時，應添加潤滑油。

CAUTION

Turn off the power switch before carrying out cleaning

The machine may operate if the treadle is depressed by mistake, which could result in injury.

Be sure to wear protective goggles and gloves when handling the lubricating oil and grease, so that they do not get into your eyes or onto your skin, otherwise inflammation can result.

Secure the table so that it will not move when tilting back the machine head.

If the table moves, it may crush your feet or cause other injuries.

Use both hands to hold the machine head when tilting it back to its original position.

If only one hand is used, the weight of the machine head may cause your hand to slip, and your hand may get caught.

Daily cleaning procedures

The following cleaning operations should be carried out each day in order to maintain the performance of this machine and to ensure a long service life.

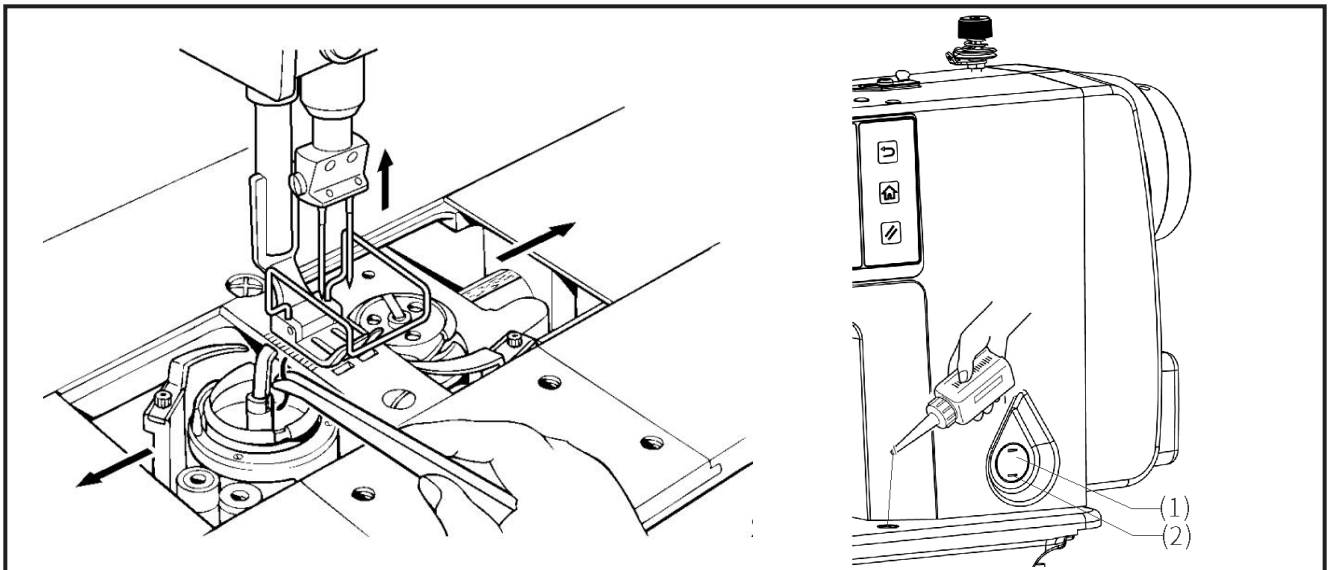
Furthermore, if the sewing machine has not been used for a long period of time, carry out the following cleaning procedures before using it again.

Cleaning

1. Turn the machine pulley to move the needle to the needle up position
2. Open the slide plates at the left and right
3. Remove the bobbin
4. Clean the thread scraps from the rotary hook
5. Install the bobbin and the bobbin case
6. The left and right push plates return to their former position

Filling the oil tank

If the lubricating oil level drops below the bottom reference line (2) of the oil gauge window (1), be sure to add more oil.



旋梭供油量的調整

ADJUSTING THE ROTARY HOOK LUBRICATION AMOUNT

注意

在檢查旋梭供油量時，手指和油量測試紙不能碰到旋梭和送布機構等運動零部件。如更換了旋梭或要變更縫紉速度時，請按下述步驟調整旋梭的供油量。

供油量調整的大致標準

1. 將縫紉機頭部倒下
2. 轉動油量調節螺釘 (1)，將其高度調整到 10~15mm

供油量的確認

1. 拆去挑線桿至機針上的線
2. 取下機針和梭芯
3. 將壓腳抬起
4. 以縫紉機實際縫紉時的轉速進行約 1 分鐘的空轉 (適度的斷續運轉)
5. 將油量測試紙 (2) 插入旋梭的左側 (左側是指旋梭的左側) 並握住，以實際縫紉時的縫紉機轉速使縫紉機運轉 8 秒鐘。(對油量測試紙 (2) 的紙質沒有什麼要求)
6. 確認飛濺到測試紙上的油量

供油量的調整

1. 將縫紉機頭部倒下
2. 轉動油量調整螺釘 (1)，調整供油量
 - 逆時針轉動油量調整螺釘 (1)，供油量增加
 - 順時針轉動油量調整螺釘 (1)，供油量減少
3. 參照上述 [供油量的確認] 所述來檢查供油量

請反復進行油量調整螺釘的調整及供油量的確認，直到獲得適當的供油量為止。
4. 在進行了約 2 小時的縫紉後，請再次檢查供油量

CAUTION

Guide to lubrication adjustment

1. Tilt back the machine head
2. Turn the oil adjusting screw (1) to adjust the height to within 10-15 mm

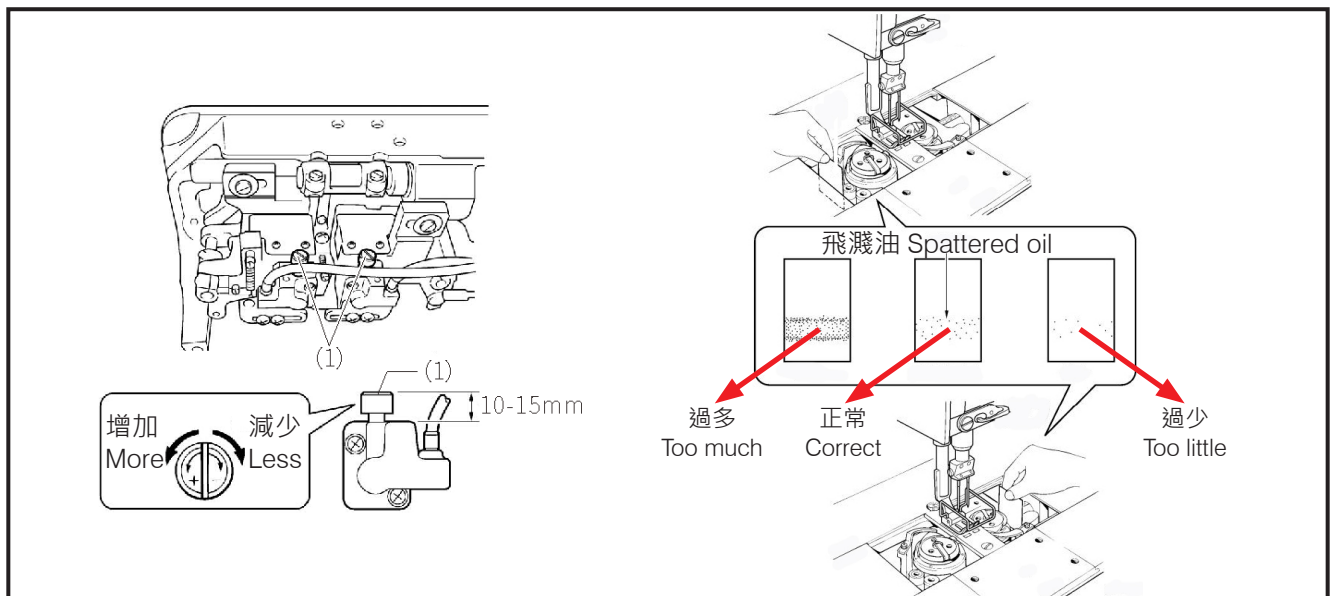
Checking the lubrication amount

1. Remove the thread from all points from the thread take-up to the needle
2. Remove the needle and the bobbin
3. Use the lifting lever to lift the presser foot
4. Run the machine at the normal sewing speed for approximately 1 minute without sewing any material (following the same start/stop pattern as when actually sewing)
5. Place the lubrication amount check sheet (2) to the left of the rotary hook (the right is the right side of the rotary hook), and hold it in place while running the sewing machine at the normal sewing speed for approximately 8 seconds. (Any type of paper can be used as the lubrication amount check sheet 2)
6. Check the amount of oil which has splattered onto the sheet

Adjusting the lubrication amount

1. Tilt back the machine head
2. Turn the adjusting screw (1) to adjust the lubrication amount
 - If the rotary hook adjusting screw (1) is turned counterclockwise, the lubrication amount becomes greater
 - If the rotary hook adjusting screw (1) is turned clockwise, the lubrication amount becomes smaller
3. Check the lubrication amount again according to the procedure given in "Checking the lubrication amount" above

Turn the adjusting screw (1) and check the lubrication amount repeatedly until the lubrication amount is correct
4. Check the lubrication amount again after the sewing machine has been used for approximately two hours



標準調整

STANDARD ADJUSTMENT

注意

只有經過培訓的技術人員才能進行縫紉機的檢查和維修。

若有安全裝置已拆下，務必在使用前將它們安裝在原來的位置上，並檢查是否正常使用。

縫紉機頭倒下或豎起時，請用雙手進行操作。單手操作時因縫紉機自身的重量萬一滑落易導致受傷。

發生下列情況時，請切斷電源。否則誤踩下啟動踏板，縫紉機動作會導致受傷。

- 進行檢查、調整和維修時。
- 更換旋梭等消耗部件時。

在務必接上電源開關進行調整時，務必十分小心遵守所以得安全注意事項。

① 挑線簧的挑線量

挑線簧 R (1) 和 L (2) 的標準挑線量是 7mm。

挑線量的調整是改變挑線量限位器 [右] (3) 和 [左] (4) 的高度。

- * 挑線量限位器 [右] (3) 和 [左] (4) 的高度在夾線軸 (5) 的中心狀態時就是標準位置。

調整方法

挑線簧的挑線量是挑線簧限位器的位置調的越高，挑線量就越少。

CAUTION

Maintenance and inspection of the sewing machine should only be carried out by a qualified technician.

If any safety devices have been removed, be absolutely sure to re-install them to their original positions and check that they operate correctly before using the machine.

Use both hands to hold the machine head when tilting it back or returning it to its original position. If only one hand is used, the weight of the machine head may cause your hand to slip, and your hand may get caught.

Turn off the power switch and disconnect the power cord from the wall outlet at the following times, otherwise the machine may operate if the treadle is depressed by mistake, which could result in injury.

- When carrying out inspection, adjustment and maintenance.
- When replacing consumable parts such as the rotary hook and knife.

If the power switch needs to be left on when carrying out some adjustment, be extremely careful to observe all safety precautions.

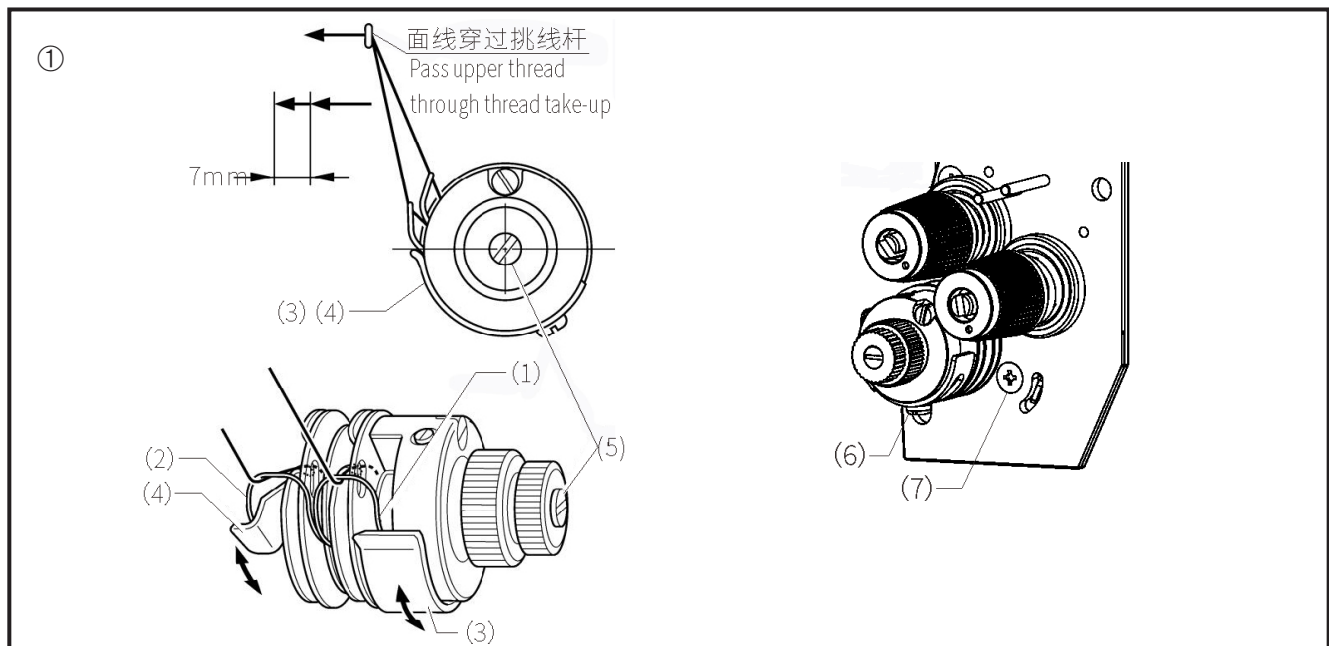
① Thread take-up amount for thread take-up spring

The standard thread take-up length for thread take-up springs R (1) and L (1) is 7 mm. You can adjust the thread take-up amounts by changing the heights of the stopper [right] (3) and the stopper [left] (4).

- * The standard heights of the stopper [right] (3) and the stopper [left] (4) are when they are aligned with the tension stud (5).

Adjustment method

The thread take-up amount for a thread take-up spring decreases when the height of the stopper is increased.



①挑線簧限位器 [右] (3) 的高度 [右線用]

1. 旋松螺釘 (6) · 滑動挑線簧限位器 [右] (3) · 提高高度。

2. 擰緊螺釘 (6)

挑線簧限位器 [左] (4) 的高度 [左線用]

1. 旋松螺釘 (7) · 滑動挑線簧限位器 [左] (4) · 提高高度

2. 擰緊螺釘 (7)

注意

使用切線縫紉機時，切線後的左側的面線殘留量會因為撚線的複位而變短。

從針孔中拉緊面線時若有 35mm 以上則為正常。若短於 35mm，請將挑線簧的挑線量減少。

②挑線簧的強度

挑線簧 R (1) 和 L (2) 的標準強度根據規格如下所示

薄料和中厚料 0.34N · 厚料 0.70N

調整方法

挑線簧 R (1) [右線用]

1. 旋松固定螺釘 (3) · 轉動調節鈕 (4) 進行調整

2. 擰緊固定螺釘 (3)

挑線簧 L (2) [右線用]

1. 旋松夾線螺母 (5)
2. 用螺絲刀 (小) 轉動夾線軸 (6) 進行調整
3. 擰緊夾線螺母 (5)

① Height of stopper [right] (3) [for right thread]

1. Loosen the screw (6), and then slide the stopper [right] (3) to adjust the thread take-up amount

2. Tighten the screw (6)

Height of stopper [left] (4) [for left thread]

1. Loosen the screw (7), and then slide the stopper [left] (4) to adjust the thread take-up amount

2. Tighten the screw (7)

NOTE

If using a thread trimming sewing machine, the trailing length for the upper thread may become shorter after thread trimming because

of the twist in the thread.

The trailing length is normal if the upper thread length is 35 mm when the thread is pulled from the needle hole. IF the thread length is shorter than this, reduce the thread take-up.

② Thread take-up spring tension

The standard tensions for the thread take-up spring R (1) and thread take-up spring L (2) are as follows depending on sewing machine specifications Light-weight and Medium-weight materials 0.34N, Heavy-weight materials 0.70N

Adjustment method

1. Loosen the set screw (3), and turn the adjusting thumb (4) to adjust the tension

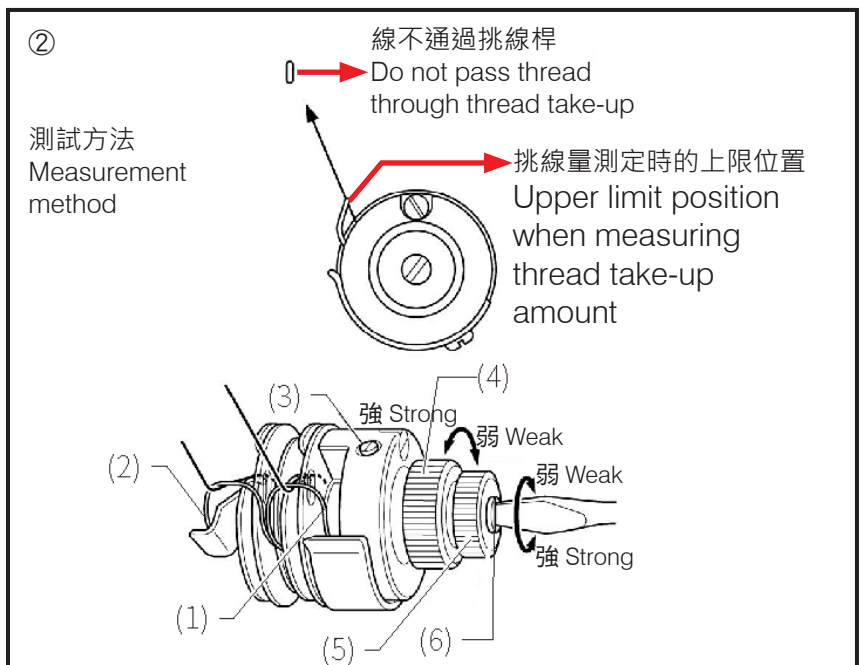
2. Tighten the set screw (3) Thread take-up spring R (1) [for right thread]

Thread take-up spring L (2) [for left thread]

1. Loosen the tension nut (5)

2. Use a small screwdriver to turn the tension stud (6) to adjust the tension

3. Tighten the tension nut (5)



旋梭和針板的間隙

出廠時，旋梭（1）和針板（2）的間隙（A）的尺寸為 1.4-1.7mm。

- 在更換旋梭（1）和針板（2）等對間隙（A）有影響的部件時，請確認間隙（A）
- 要調整間隙（A），需要更換旋梭（1）和旋梭底座（3）之間的軸向墊圈（4）
- 軸向墊圈（4）有四種，請在測定現在的軸向墊圈（4）的厚度之後，更換厚度合適的軸向墊圈（4）

軸向墊圈編碼	厚度
124090901	0.8mm
124090901-1	1.0mm
124090901-2	1.2mm
124090901-3	1.4mm

- 更換旋梭（1）的時候，旋松固定螺釘（5）[3 個]，此時，請不要取下軸向墊圈（4）。

注意

將供油用的油氈（7）放在旋梭軸（6）的底部。將旋梭（1）向下輕壓，用固定螺釘（5）固定好，使旋梭（1）沒有浮動。間隙過大的情況

- 中旋梭可能離開針板（2）

間隙過小的情況

- 線鬆緊不良不好
- 可能發生剪線錯誤
- 右面線可能被切短

Clearance between rotary hook and needle plate

The clearance (A) between the rotary hook (1) and the needle plate (2) is 1.4-1.7 mm.

- Check clearance (A) each time parts such as the rotary hook (1) and the needle plate (2) that affect clearance (A) are replaced
- To adjust clearance (A), replace the thrust ring (4) that is in between the rotary hook (1) and the rotary hook base (3)
- Three types of thrust ring (4) are available. Measure the thickness of the thrust ring (4) that is currently being used, and replace it with a thrust ring (4) of the appropriate width

Part code	Thickness
124090901	0.8mm
124090901-1	1.0mm
124090901-2	1.2mm
124090901-3	1.4mm

- When replacing the rotary hook (1), loosen the three set screws (5). Be careful not to lose the thrust ring (4) at this time.

NOTE

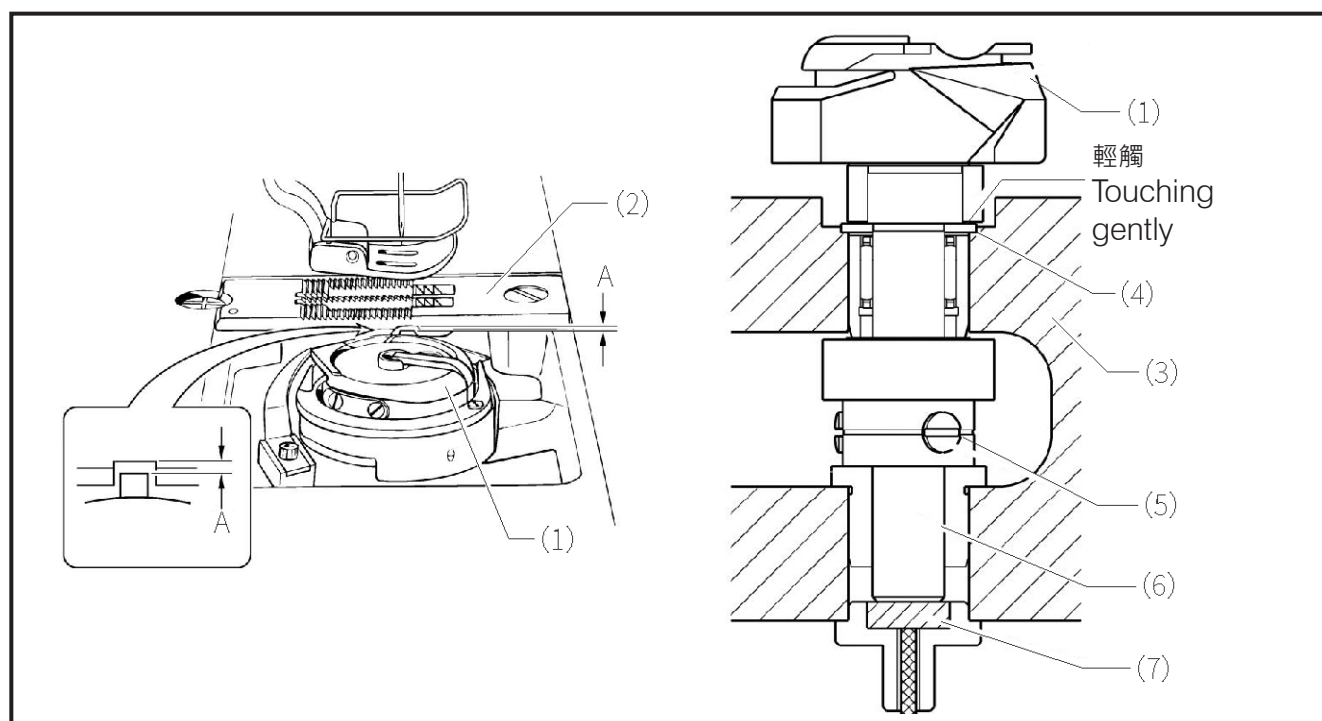
There is a piece of felt (7) for lubrication at the base of the rotary hook shaft (6). Gently press down on the rotary hook (1) when tightening the set screws (5) so that the rotary hook (1) does not lift up.

If the clearance is too large

- The inner rotary hook may come out from the needle plate (2)

If the clearance is too small

- Poor thread tightening may occur
- Lower thread trimming errors may occur (models with thread trimmer)
- The right upper thread may be cut too short (models with thread trimmer)



① 旋梭與分線勾的間隙

1. 分線勾 (1) 沿箭頭方向拉滿的時候，旋松固定螺釘 (3)，將分線勾 (1) 左右調整，使旋梭 (2) 和分線勾 (1) 的間隙為 0.1-0.3mm
2. 擰緊固定螺釘 (3)

注意

間隙過大的情況

- 可能發生面線切線錯誤
- 面線可能被切短

間隙過小的情況

- 會造成旋梭破損
- 會造成開松機 (1) 的破損

② 壓腳高度

1. 取下面板 (1) 上的橡皮塞 (2)
 2. 旋松螺母 (3)，鬆開壓腳調節螺釘 (4)
 3. 通用壓腳扳手 (5) 抬高壓腳 (6)
 4. 旋松螺釘 (7)，上下移動壓腳桿 (8) 進行調整，使壓腳 (6) 上升至針板上面 7mm
- ※ 請不要旋轉壓腳桿 (8)
5. 擰緊螺釘 (7)
 6. 通過壓腳調節螺釘 (4) 調節壓腳壓力，擰緊螺母 (3)
 7. 將橡皮塞 (2) 塞入面板 (1) 橡皮塞孔內

① Clearance between rotary hook and opener

1. Loosen the set screw (3) and move the opener (1) to the left or right to adjust so that the clearance between the rotary hook (2) and the opener (1) is 0.1-0.3 mm when the opener (1) is pulled as it will go in the direction of the arrow
2. Tighten the set screw (3)

NOTE

If the clearance is too large

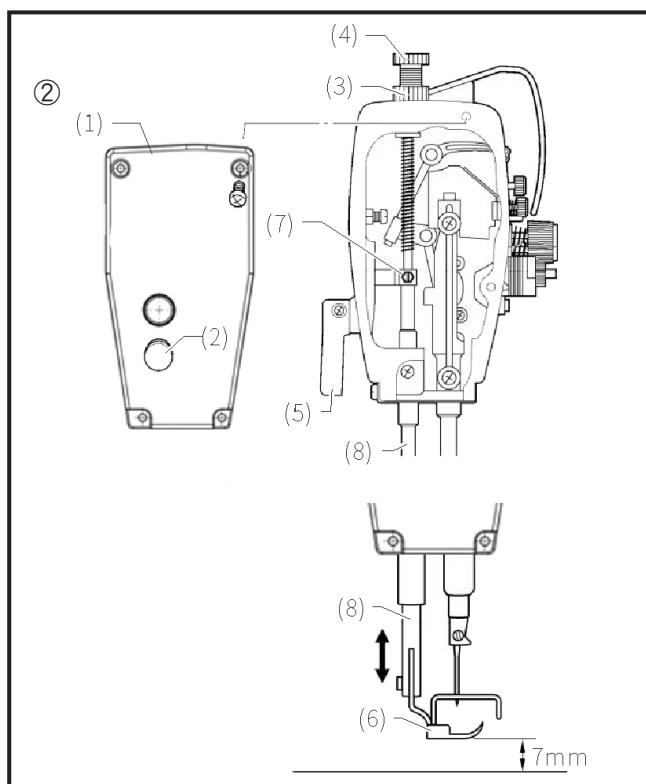
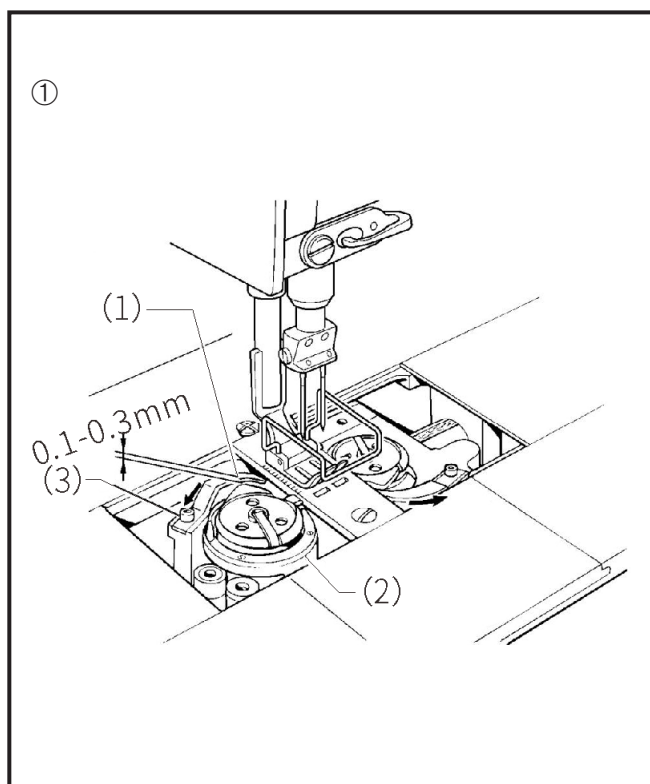
- Upper thread trimming errors may occur (models with thread trimmer)
- The right upper thread may be cut may be cut too short (models with thread trimmer)

If the clearance is too small

- The rotary hook may become damaged
- The opener (1) may become damaged

② Presser foot height

1. Remove the rear cover (1) and remove the rubber cap (2)
 2. Loosen the nut (3) and loosen the presser adjusting screw (4)
 3. Use the lifting lever (5) to raise the presser foot (6)
 4. Loosen the screw (7) and move the presser bar (8) up or down to adjust so that the presser foot (6) is approximately 7 mm above the top of the needle plate
- ※ Do not turn the presser bar (8) at this time
5. Tighten the screw (7)
 6. Turn the presser adjusting screw (4) to adjust the presser foot pressure, and then tighten the nut (3)
 7. Insert the rubber plug (2) into the rubber plug hole of the panel (1)



機針與旋梭的同步

1. 將針距調整到 0
2. 逆時針轉動手動輪，使針桿（4）上升，直至針桿（4）的基線（2）與針桿支架（3）的下端對齊
3. 在此狀態下，固定好手輪，使針桿（4）不能移動
此時，針桿上升量為標準位置

注意

針桿上升量過大會導致一下問題

- 右邊的線鬆緊不良
- 左右都會線跡不齊、跳針、斷線
- 有時會面線切線錯誤或面線變短易脫線

針桿上升量過小會導致一下問題

- 跳針、斷線
- 切線後面線殘留量變短

4. 旋松螺釘（5），取下旋梭基座蓋 FL(6) 和 FR（7）
5. 旋松固定螺釘（9）[左右各 3 個]，使小齒輪（8）能轉動
6. 用手轉動旋梭，使旋梭尖（13）對準機針的中心
7. 依次擰緊固定螺釘（9）

Needle and rotary hook timing

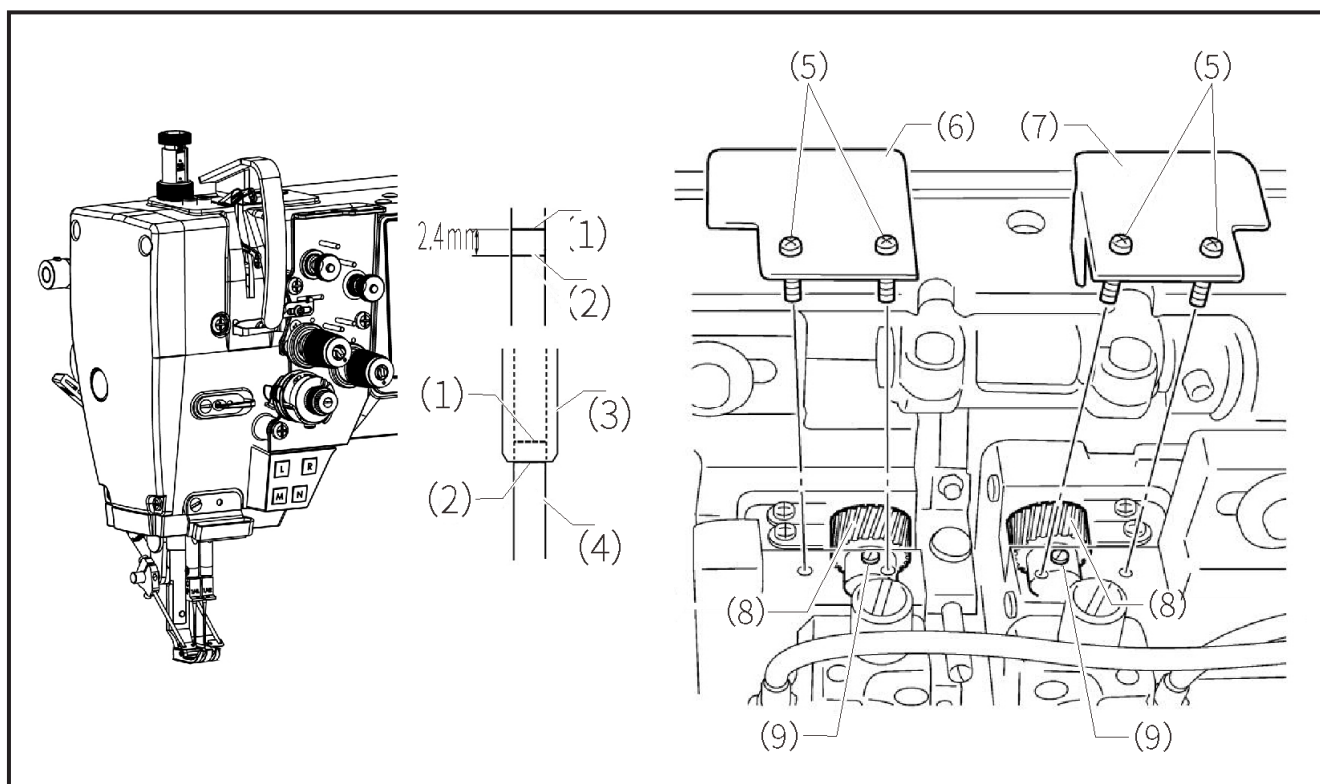
1. Adjust the needle distance to 0
2. Turn the manual wheel counter clockwise so that the needle bar (4) rises until the needle bar (4) the baseline (2) is aligned with the lower end of the needle bar support (3)
3. In this condition, the handwheel is fixed so that the needle bar (4) can not be moved
At this point, the needle bar rise is the standard position

NOTE

If the needle bar lift amount is too large

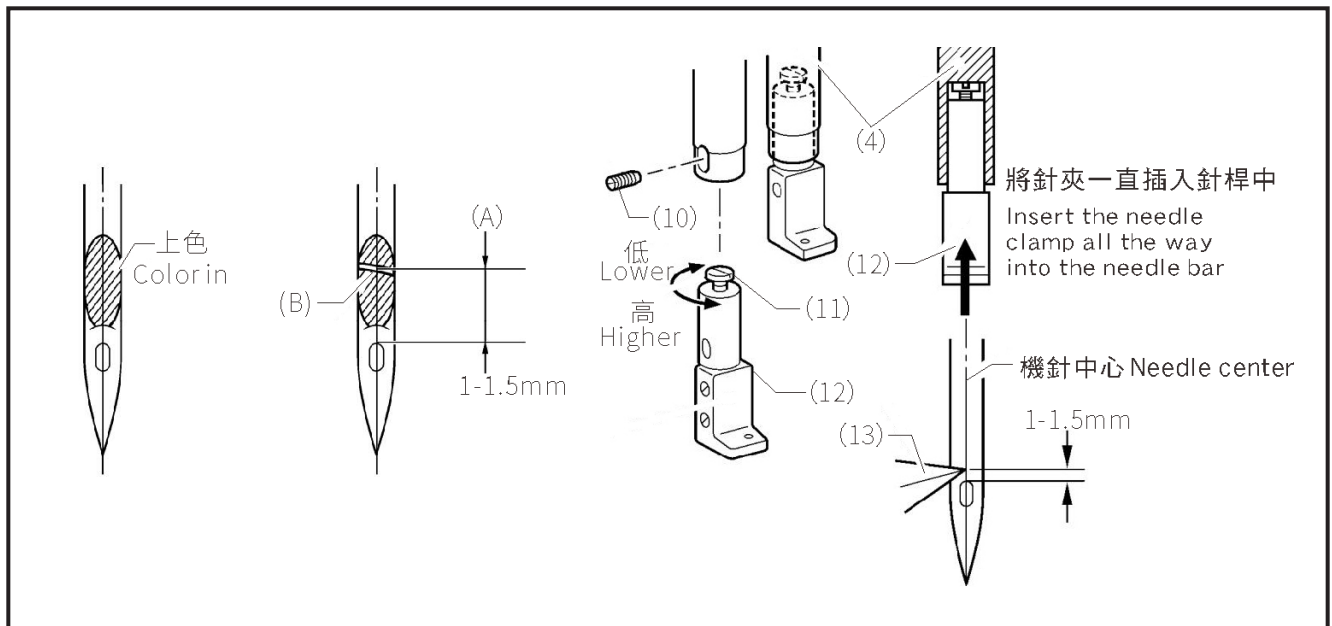
- It will cause poor tightening in the right thread
- Both the left and right seans will become uneven, and skipped stitches or thread breakages will occur
- Upper thread trimming errors may occur, or the upper thread may be cut too short. If the needle bar lift amount is too small
- Skipped stitches and thread breakages will occur
- The upper thread trailing length will be too short

4. Loosen the screw (5), and then remove rotary hook base cover FL (6) and FR (7)
5. Loosen the set screws (9) [three each at left and right]
6. Turn the rotary hook by hand to align the rotary hook tip (13) with the middle of the needle
7. Tighten the set screws (9)



8. 在機針的槽部塗上油墨
9. 邊轉動手輪，邊將機針推向旋梭尖端 (13)，在機針的槽部會留下旋梭尖端 (13) 的痕跡
10. 旋梭尖端 (13) 的痕跡和機針中心線的交點到機針線孔上端的尺寸為 1-1.5mm
不是 1-1.5mm 時，請旋松螺釘 (10)，將針夾 (12) 拉下，旋轉螺釘 (11) 進行調整。調整完成後，將針夾 (12) 盡可能深的插入針桿 (4) 孔內，並確保距離為 1-1.5mm。擰緊固定螺釘 (10)

8. Use an oil-based marker pen to color in the hollow of the needle
9. With the needle raised, turn the machine pulley forward while pushing the needle against the rotary hook tip (13) with your finger to make from the rotary hook tip (13) in the hollow of the needle
10. Check that the distance from the intersection between the mark from the rotary hook tip and the center line of the needle to the top edge of the needle hole is 1-1.5 mm
If the distance is not 1-1.5 mm, loosen the set screw (10) and then pull the needle bar clamp (12) downward to remove it. Turn the screw (11) to adjust so that the distance from the upper edge of the needle hole to the rotary hook tip (4) is 1-1.5 mm. After adjustment is completed, insert the needle bar clamp (12) into the hole of the needle bar (4) as far as it will go, and check that the distance is 1-1.5 mm. Secure it by tightening the set screw (10)



① 送布牙的安裝方法

1. 將送布牙 (1) 用螺釘 (3) 安裝在牙架叉組件 (2) 上
2. 擰緊送布牙叉組件的固定螺釘 (4) , 使其前端與送布牙 (1) 的下面接觸
3. 擰緊螺母 (5) , 固定螺釘 (4) 不能將送布牙傾斜著固定在牙架叉組件 (2) 上

② 送布牙的位置

前後位置調整

就算針桿和壓腳桿的間隔 (13.3-13.7mm) 正確, 針和送布牙針孔的位置關係不好時, 也需進行調整

1. 旋松螺釘 (1)
2. 轉動水平送布台臂進行調整, 使機針在送布牙 (2) 的針孔中心位置。
3. 擰緊螺釘 (1)

※ 請不要過度擰緊螺釘 (1), 會導致水平送布台臂 (3) 的破損。

左右位置的調整

用螺釘 (5) 和 (6) 將針板 (4) 固定在底板上, 以此時針板的位置為基準, 調整送布牙左右位置, 使送布牙各側面與針板無接觸

針板與送布牙接觸時, 旋松螺釘 (1), 左右移動水平送布台臂 (3) 進行調整

① Installing the feed dog

1. Install the feed dog (1) to the feed bar (2) with the two screws (3)
2. Tighten the feed dog support set screw (4) so that the tip of the set screw (4) touches the bottom of the feed dog (1)
3. Tighten the nut (5) to secure the set screw (4). The set screw (2) is not used for installing the feed dog at an angle

② Feed dog position

Forward-back position adjustment

Carry out this adjustment if the needle and the needle hole in the feed dog are not positioned correctly even though the clearance between the needle bar and the presser bar (13.3-13.7 mm) is correct

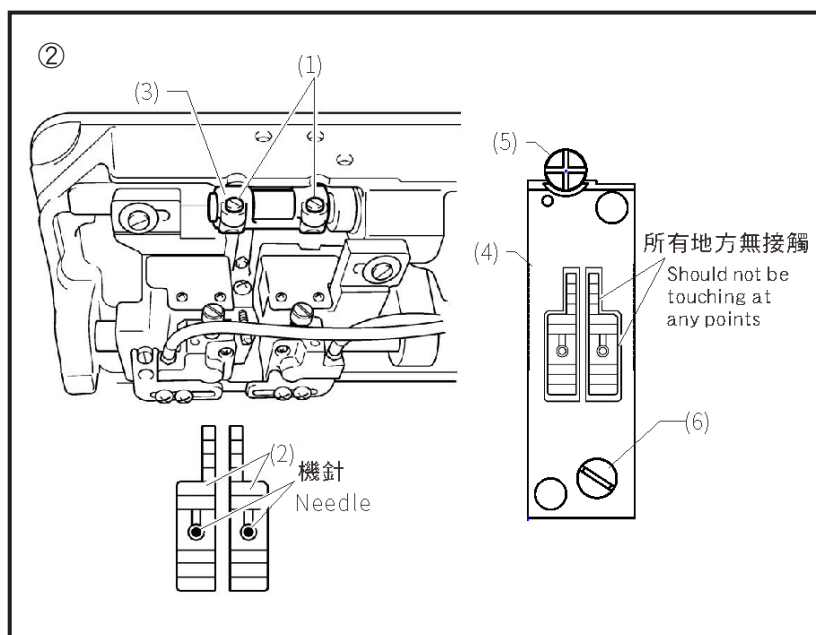
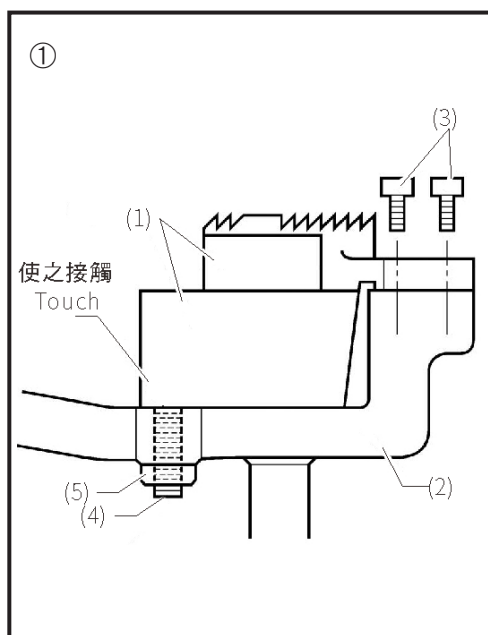
1. Loosen the two screws (1)
2. Turn the feed rocker base arm (3) to adjust so that the needle drops into the middle of the needle hole in the feed dog (2)
3. Tighten the screw (1)

※ Do not overtighten the screw (1), otherwise it will damage the feed rocker base arm (3)

Left-right position adjustment

Adjust so that neither side of the feed dog touches the needle plate (4) when the needle plate (4) is secured to the bed with the screws (5) and (6)

If the needle plate and the feed dog are touching, loosen the screw (1) and move the feed rocker base arm (3) sideways to adjust



送布牙的高度

轉動手動輪，送布牙 (1) 上升到最高位置，此位置進行調整，使送布牙 (1) 距針板 (2) 上面 0.9-1.1mm

1. 放下縫紉機頭
2. 將螺釘 (3) 旋松一點，使送布台 (4) 能滑動即可
3. 轉動高度調節螺釘 (5)，調節送布牙 (1) 的高度
4. 將螺釘 (3) 擰緊
5. 再次確認送布牙 (1) 的高度

※ 送布牙過高的情況

- 送布牙會碰到針板
- 針跡長度會比實際針距大
- 用粗線時，線鬆緊不良
- 正送布與倒送布的線跡長度難能一致
- 可能發生底線切線錯誤

※ 送布牙過低的情況

- 針跡長度會比實際針距小
- 正送布與倒送布的線跡長度難能一致
- 送布牙碰動刀
- 低速和高速縫紉的線跡長度差變大

Feed dog height

Turn the machine pulley forward until the feed dog (1) is at its highest position, and then adjust so that the feed dog (1) protrudes 0.9-1.1 mm from the top of the needle plate (2)

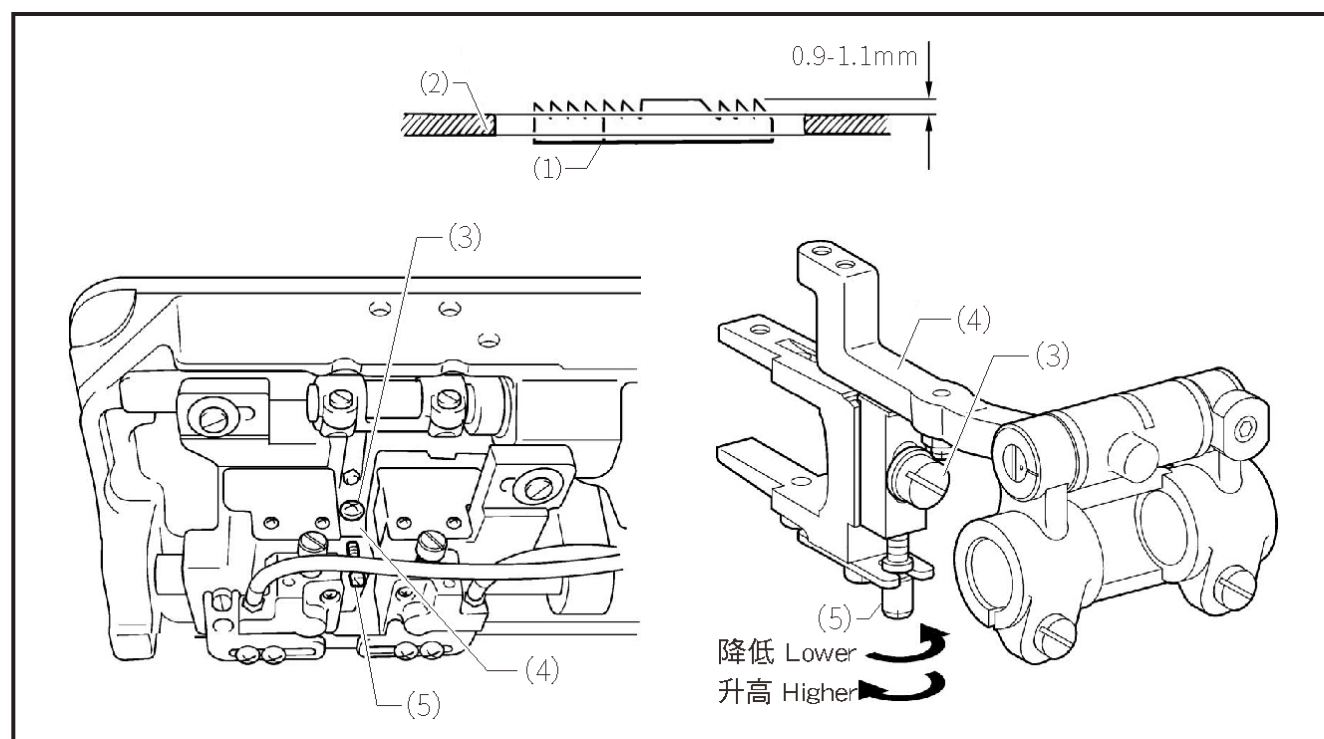
1. Tilt back the machine head
2. Loosen the screw (3) just enough so that the feed bar (4) can slide
3. Turn the height adjustment screw (5) as shown in the illustration to adjust the height of the feed dog (1)
4. Securely tighten the screw (3)
5. Recheck the height of the feed dog (1)

※ If the feed is too high

- The feed dog may touch the needle plate
- The stitch length may become longer than the stitch length dial setting
- Thread tightening may be poor when using thick threads
- It may be difficult to obtain uniform stitch lengths for normal feed and reverse feed
- Lower thread trimming errors may occur

※ If the feed is too low

- The stitch length may become shorter than the stitch length dial setting
- It may be difficult to obtain uniform stitch lengths for normal feed and reverse feed
- The feed dog may touch the movable knife
- Large variations in stitch length may occur at slow and fast sewing speeds



送布牙的傾斜

牙架軸 (1) 與水平送布台臂 (3) 的標準為：牙架軸 (1) 的配合標記 (2) 與水平送布台臂 (3) 的基線 (4) 一致

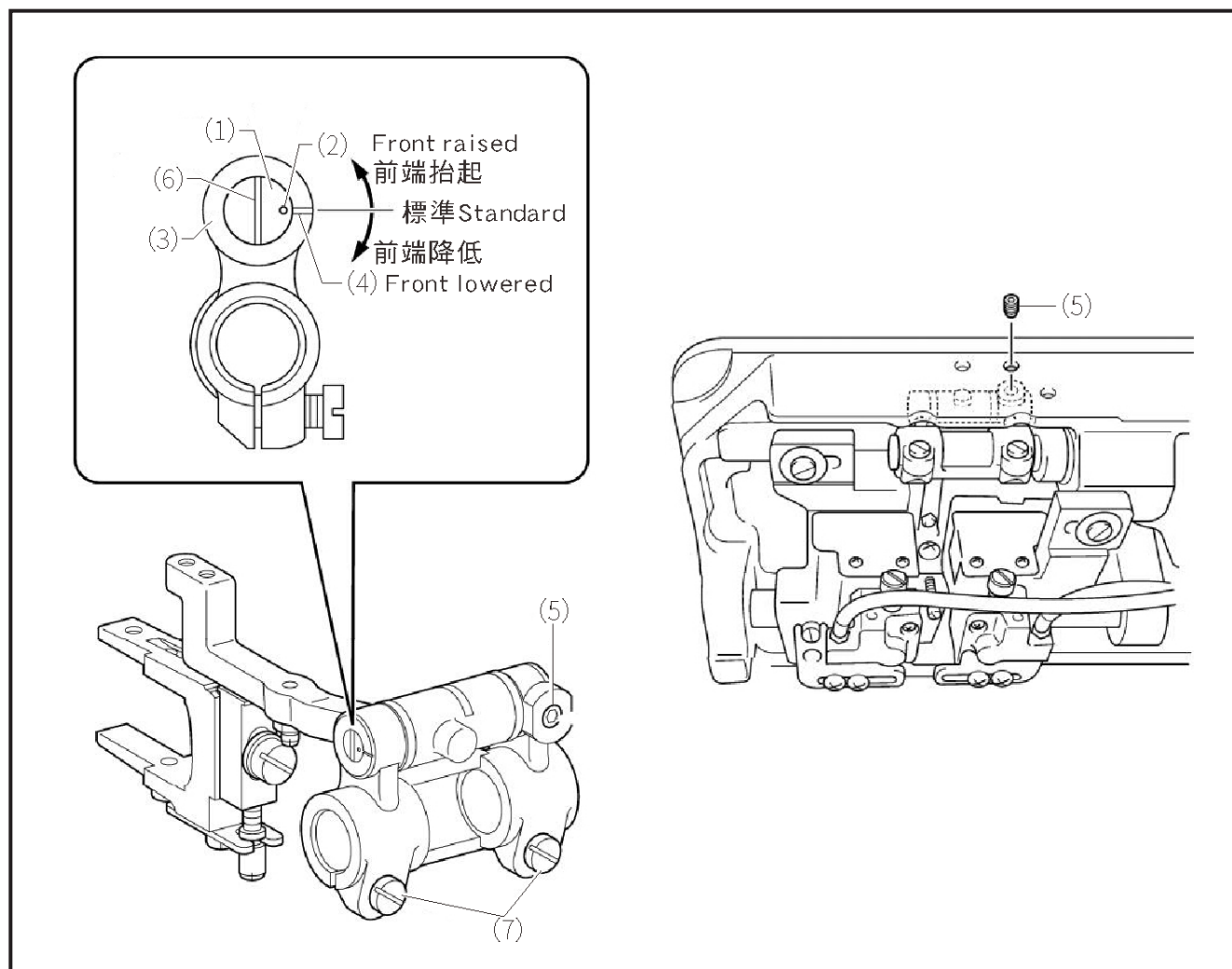
1. 放下縫紉機頭
2. 旋松固定螺釘 (5)
3. 將螺絲刀伸入牙架軸 (1) 的槽 (6) 內，轉動並進行調整
4. 擰緊固定螺釘 (5)

- 根據布料的不同需調整送布牙的傾斜時，調整好送布牙的傾斜後，送布牙前後位置會發生變化，旋松螺釘 (7) 以機針為基準針調節送布牙前後位置
- 調整送布牙的傾斜，送布牙的高度會發生變化，請重新調整送布牙的高度

Feed dog angle

1. The standard angle for the feed dog is when the mark (2) on the feed bar shaft (1) is aligned with the reference line (4) on the feed rocker base arm (3).
2. Loosen the set screw (5).
3. Insert a screwdriver into the slit (6) in the feed bar shaft (1), and turn it to make the adjustment.
4. Tighten the set screw (5).

- When the angle of the feed dog is adjusted, the forward-back position of the feed dog will change. Loosen the two screws (7) and adjust the forward-back position of the feed dog in accordance with the needle.
- In addition, when the angle of the feed dog is adjusted, the height of the feed dog will also change, so readjust the height of the feed dog.



SERVICE PARTS POLICY

To ensure the quality and safety of machine, all SIRUBA parts pass the highest quality inspection and test. For any case of adopting non-genuine SIRUBA parts for replacement and service, it may cause not only losing the warranty coverage, but also the unexpected damage to the operator and property.

In some cases, issues such as difficulty of obtaining parts might make it impossible for us to repair or replace malfunctioning items even if the service period has not yet ended. We ask for your understanding on this matter

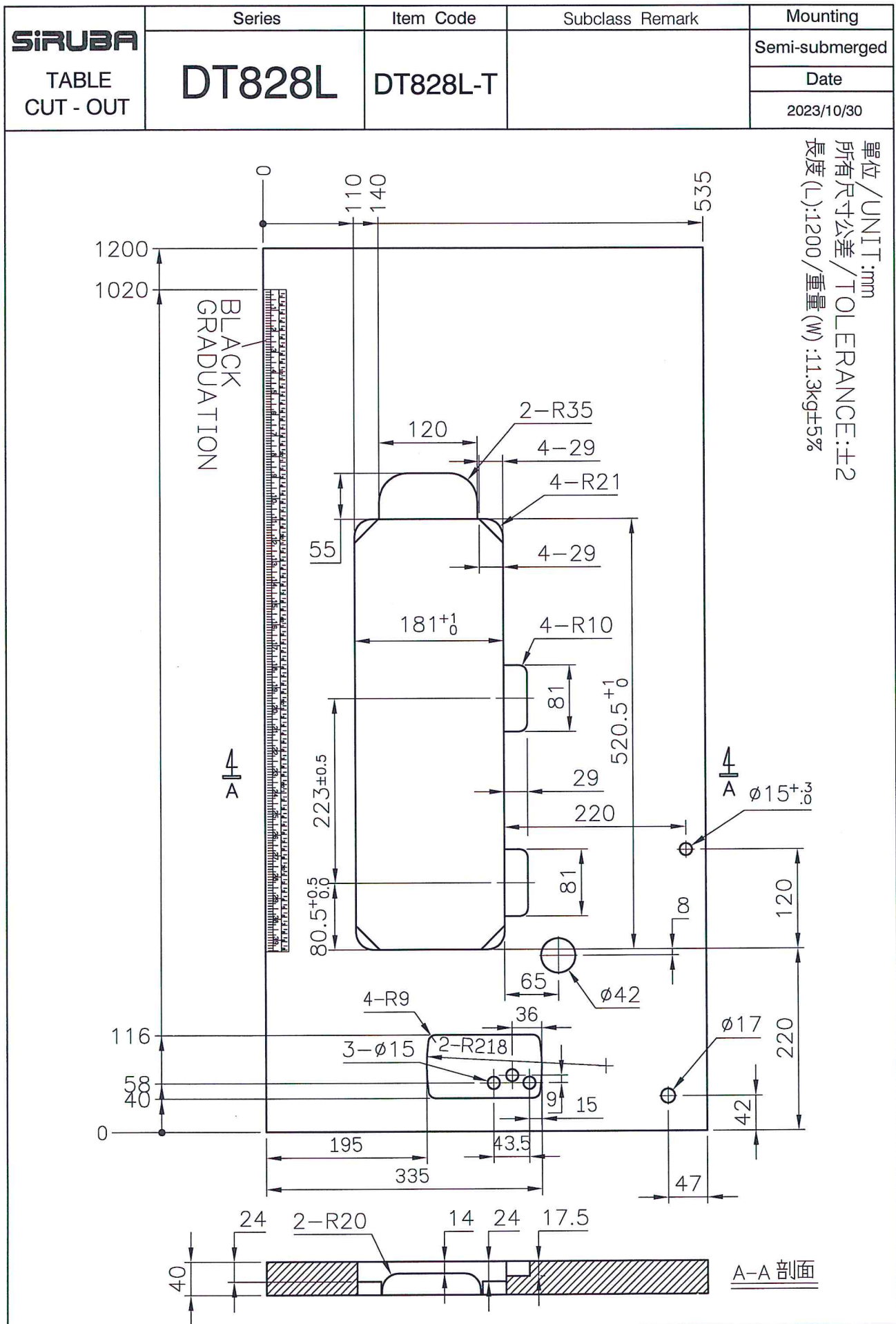
To continuously provide our customers the high quality machines and service, we do not guarantee the parts supply service for the discontinued models after 5 years since the production stops.

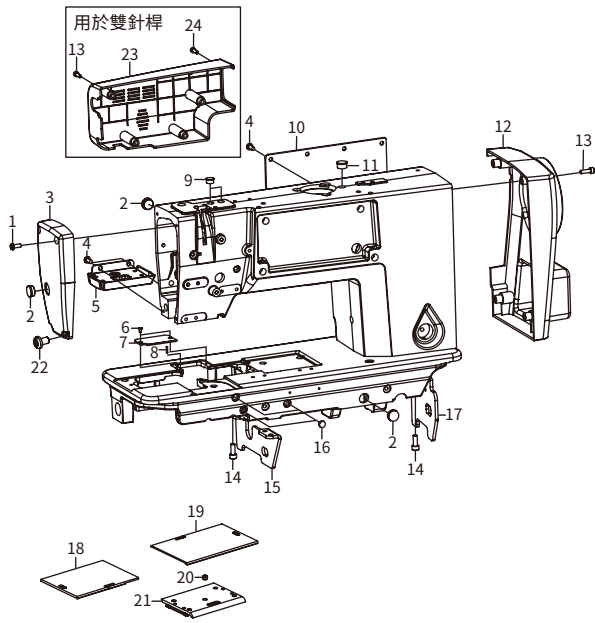
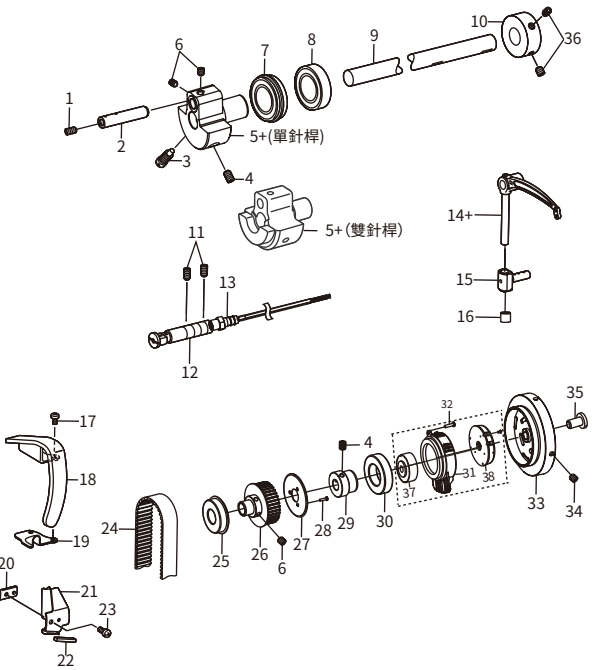
服務部分政策

為確保機器的質量和安全，所有 SIRUBA 部件均通過了最高質量的檢驗和測試。對於任何採用非正品 SIRUBA 部件進行更換和維修的情況，不僅可能導致保修範圍的損失，還可能導致對操作員和財產的意外損壞。

在某些情況下，即使服務期尚未結束，諸如難以獲得零件等問題也可能使我們無法修理或更換故障物品。我們要求您就此事達成諒解

為了不斷為客戶提供高質量的機器和服務，我們不保證自生產停止 5 年後停產的型號的零件供應服務。



<div>SIRUBA</div> <div>PARTS LIST</div>	Series	Parts Group	Subclass Remark		Page	
	DT828L				1 / 1	
					Date	
					2022/10/18	
1.機體部分/Machine body		序號	圖 號	數量	零 件 名 稱	NAME OF PARTS
		1	062351212	3	螺釘M3.5×12	SCREW PAN M3.5×12
		2	115010701	3	橡皮塞 15.5	RUBBER CAP 15.5
		3	124010301-5	1	面板	FACE PLATE
		4	062501016	11	螺釘M5×10	SCREW PAN M5×10
		5	124010402	1	機頭燈組件	HEAD LAMP ASSY
		6	125080401	2	螺釘M3×5	SCREW PAN M3×5
		7	124012501	1	后推板	SLIDE PLATE
		8	124011301	1	針板定位銷	POSITIONING PIN
		9	115011001	2	橡皮塞 10.5	RUBBER CAP 10.5
		10	115010401	1	后蓋板	REAR COVER
		11	101011001	1	橡皮塞 12.5	RUBBER CAP 12.5
		12	124011202	1	電機罩	MOTOR COVER
		13	018502032	7	螺釘M5×20	SCREW PAN M5×20
		14	018061232	5	螺釘M6×12	SCREW PAN M6×12
		15	124011902	1	左支撐板	SUPORRT PLATE L
		16	115012701	3	橡皮塞 8	RUBBER CAP 8
		17	124012001	1	右支撐板	SUPORRT PLATE R
		18	124011401	1	推板L	SLIDE PLATE L
		19	124011501	1	推板R	SLIDE PLATE R
		20	012500536	1	螺釘M5	SCREW PAN M5
		21	124013001	1	推板F	SLIDE PLATE F
		22	062710812	1	螺釘SM4.76×32	SCREW PAN SM4.76×32
		23	124012201	1	電磁鐵罩	ELECTROMAGNET COVER
		24	018501632	1	螺釘M5×16	SCREW PAN M5×16
2.上軸裝置/Shaft mechanism		序號	圖 號	數量	零 件 名 稱	NAME OF PARTS
		1	012500536	1	螺釘M5×5	SCREW PAN M5×5
		2	124020201	1	針杆曲柄軸	CRANK SHAFT
		3	124020301	1	針杆曲柄螺釘M8	SCREW PAN M8
		4	014601016	3	螺釘M6×0.75-10	SCREW PAN M6×0.75-10
		5+	124020502	1	針杆曲柄(單針杆)	THREAD TAKE-UP CRANK
		5+	125020502	1	針杆曲柄(雙針杆)	THREAD TAKE-UP CRANK
		6	012600636	4	螺釘M6×0.75-6	SET SCREW PAN M6×0.75-6
		7	115024501	1	軸承6004ZZNR	BALL BEARING 6004ZZNR
		8	124020801	1	軸承6004ZZ	BALL BEARING 6004ZZ
		9	124020903	1	上軸DD	UPPER SHAFT DD
		10	115021201	1	卷線驅動輪	BOBBIN WINDER DRIVING WHEEL
		11	012061032	2	螺釘M6×10	SCREW PAN M6×10
		12	124021301	1	挑線杆支撐軸	THREAD TAKE-UP S-SHAFT UNIT
		13	124024001	1	油嘴	NOZZLE
		14+	124021401-1	1	挑線杆S5-L(小梭)	T-TAKE-UP LEVER S5-L
		14+	125021401	1	挑線杆R(大梭)	T-TAKE-UP LEVER R
		15	124021501	1	挑線杆滑塊	T-TAKE-UP SLIDE BLOCK
		16	115022801	1	橡皮塞4.2	CAP 4.2
		17	062500816	2	螺釘M5×8	SCREW PAN M5×8
		18	124021704	1	挑線杆防護罩	THREAD TAKE-UP LEVER COVER
		19	124021801	1	防塵蓋	DUST COVER
		20	124021901	1	遮掩板支座	HOLDER, SHELTER PLATE
		21	124022001	1	遮掩板	SHELTER PLATE
		22	124022101	1	油氈	FELT
		23	062501016	1	螺釘M5×10	SCREW PAN M5×10
		24	124022301	1	同步皮帶	TIMING BELT
		25	124022401	1	軸承6204ZZNR	BALL BEARING 6204ZZNR
		26	124022601	1	同步輪U	TIMING PULLEY U
		27	124022701	1	同步輪U法蘭	PULLEY U FLANGE
		28	062400612	3	螺釘M4×6	SCREW PAN M4×6
		29	124022901	1	軸承套	BEARING SLEEVE
		30	124023001	1	軸承6006ZZ	BALL BEARING 6006ZZ
		31	124025102	1	主軸編碼器	Spindle encoder
		32	018501432	3	螺釘M5×14	SCREW PAN M5×14
		33	124025204	1	手輪	HAND WHEEL ASSY
		34	014760832	2	螺釘SM5.95×28-8	SCREW PAN SM5.95×28-8
		35	115025401	1	螺釘SM8.37	SCREW PAN SM8.37
		36	012501032	2	螺釘M5×10	SCREW PAN M5×10
37	124025102-1	1	電機轉子	motor rotor		
38	124025102-2	1	電機定子	Motor stator		

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3.針桿擺動裝置/Needle bar rocking mechanism		序號	圖 號	數量	零件名稱	NAME OF PARTS
	1	062500616	2	螺釘M5×6	SCREW PAN M5×6	
	2	124030301	1	擺動軸軸套R	BUSH R	
	3	124030401	1	針桿擺動大組件	NEEDLE BAR ROCKER LEVER	
	4	124031501	1	軸套L	BUSH L	
	5	012600636	2	螺釘M6×0.75-6	SCREW PAN M6×0.75-6	
	6	124031701	1	緊圈	SET SCREW COLLAR	
	7	124031901	1	油氈上支架U	LINOLEVM BRACKET U	
	8	124032001	1	油氈下支架D	LINOLEVM BRACKET D	
	9	124032101	1	油氈	FELT	
	10+	124031801	1	針桿支架組件(單針桿)	NEEDLE BAR ROCKER SHAFT UNIT	
	10+	125031801	1	針桿支架組件(雙針桿)	NEEDLE BAR ROCKER SHAFT UNIT	
	11	014080832	2	螺釘M8×8(雙針桿)	SCREW PAN M8×8	
	12	124032201	1	針桿支架油氈U	FELT	
	13	124032401	2	針桿支架油氈塞	FELT	
	14	124031601	1	針桿支架油氈	FELT	
15	124032301	1	針桿支架油氈D	FELT		
	1	124050102	1	調節螺柱M14	PESSER ADJUSTING SCREW M14	
	2	115030401	1	彈簧導桿	SPRING GUIDE	
	3	125050401	1	壓緊彈簧	PRESSER BAR SPRING	
	4	124050501	1	壓緊緊導架	GUIDE BRACKET P-BAR	
	5	124050601	1	螺柱M6	BOLT (CP) M6	
	6	062501016	2	螺釘M5×10	SCREW PAN M5×10	
	7	124050801	1	壓桿軸套	PRESSER BAR BUSH	
	8	124050901	1	壓緊桿	PRESSER BAR	
	9	021500106	1	螺母M5	NUT M5	
	10	124051301	1	彈簧	SPRING	
	11	152201701	2	螺釘SM4.37×40	SCREW PAN SM4.37×40	
	12	124051102	1	緊圈	SET SCREW COLLAR	
	13	124051801	1	墊圈	WASHER PLAIN	
	14	115032001	1	螺釘M3.5×12	LIFTING LEVER	
	15	115031901	1	抬壓腳扳手	PRESSER BAR LIFTING CRANK	
	16	124051701	1	壓桿提升曲柄	WASHER PLAIN	
	17	115034301	5	段螺釘SM4.76	SHOULDER SCREW SM4.76	
	18	115034501	2	段螺釘SM6.35×28	SHOULDER SCREW SM6.35×28	
	19	124052201	1	膝控連桿	KNEE LIFTER CONNECTING ROD	
	20	169032101	2	膝控提升杠桿	KNEE LIFTER LEVER	
	21	124052001	1	抬壓腳連桿	PRESSER BAR LIFTING LEVER	
	22	124052101	1	提升杠桿銷	P-BAR LIFTING LEVER SHAFT	
	23	124052601	1	膝控提升拉桿	KNEE LIFTER BAR	
	24	124052902	1	抬牙曲柄連桿銷	PIN	
	25	124052701	1	膝控提升短連桿	KNEE LIFTER SHORT BAR	
	26	124052802	1	抬牙曲柄連桿組件	P-BAR LIFTER CRANK LEVER	
	27	115072001	1	緊圈	SET SCREW COLLAR	
	28	014770632	2	螺釘SM6.35×40-6	SCREW SM6.35	
	29	124051901	1	段螺釘M5	SHOULDER SCREW M5	

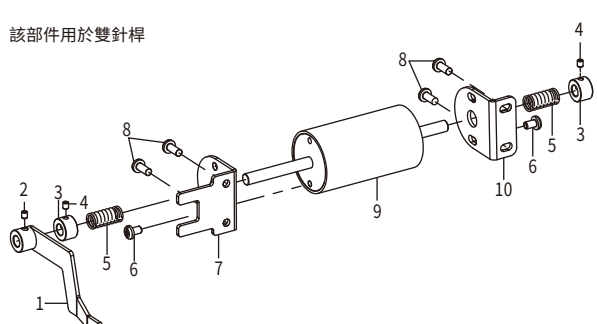
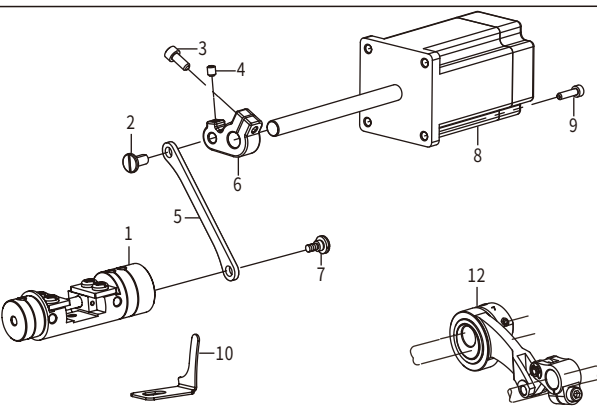
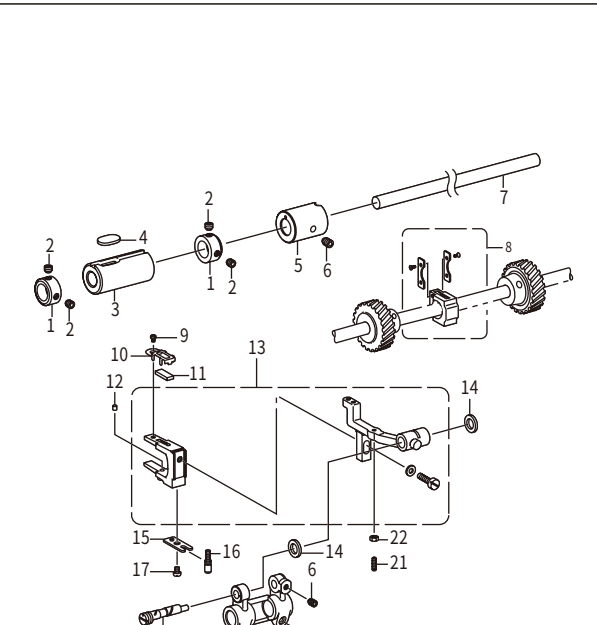
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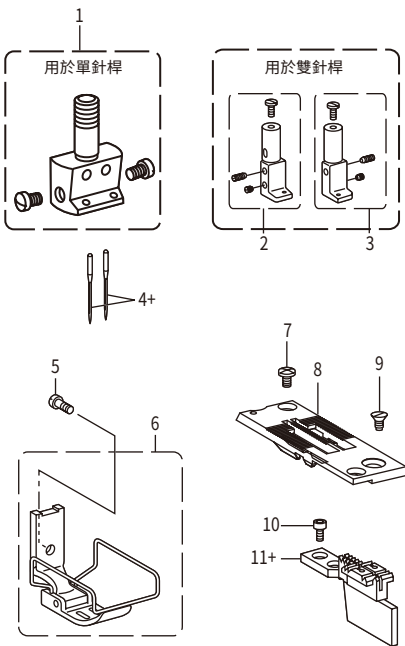
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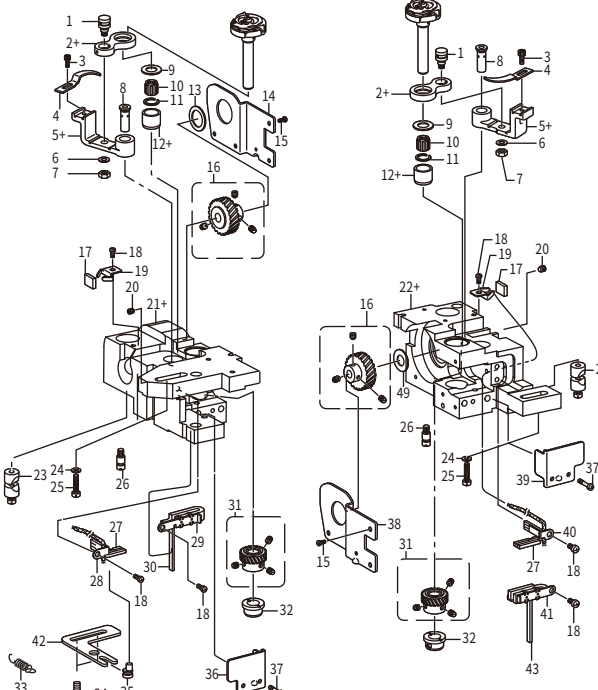
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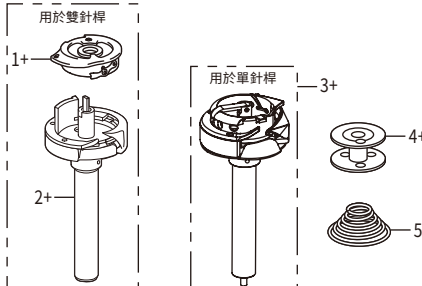
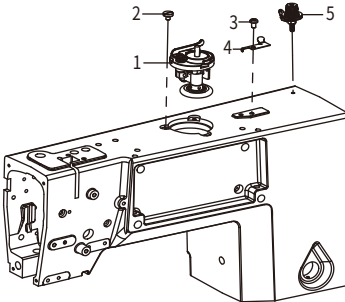
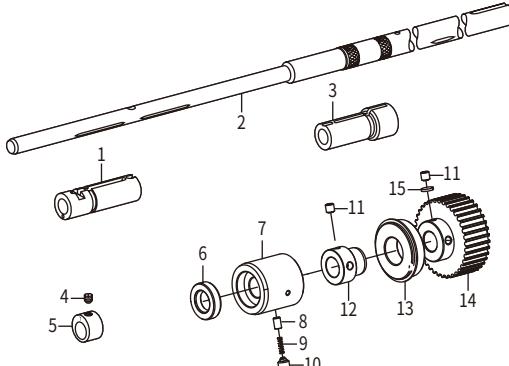
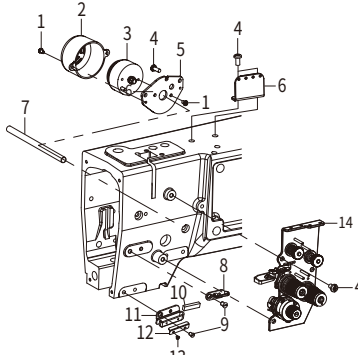
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5.針桿切換操作裝置/Needle bar rocking mechanism		序號	圖 號	數量	零 件 名 稱	NAME OF PARTS
<div>該部件用於雙針桿</div> 	1	125040101	1	分离板	SEPARATION PLATE	
	2	012500536	2	螺钉 M5×5	SCREW PAN M5×5	
	3	125040301	2	緊圈	SET SCREW COLLAR	
	4	152201701	4	螺钉SM4.37×40-4	SCREW 螺钉SM4.37×40-4	
	5	125040401	2	彈簧	SPRING	
	6	062500616	4	螺钉 M5×6	SCREW PAN M5×6	
	7	125040501	1	電磁鐵安裝板左	SOLENOID SETTING PLATE L	
	8	062501016	4	螺钉 M5×10	SCREW PAN M5×10	
	9	125040801	1	分离電磁鐵組件	SEPARATING ELECTROMAGNET	
	10	125040901	1	電磁鐵安裝板右	SOLENOID SETTING PLATE R	
6.送布裝置/ Feed mechanism		序號	圖 號	數量	零 件 名 稱	NAME OF PARTS
	1	124061101	1	切換器組件	FEED REGULATOR ASSY	
	2	124061201	1	偏心軸	ECCENTRIC SHAFT	
	3	018501236	1	螺钉M5×12	SCREW PAN M5×12	
	4	012500632	1	螺钉M5×5	SCREW PAN M5×5	
	5	124061301	1	切換器連桿	CONNECTING ROD	
	6	124061501	1	送料調節曲柄	FEED REGULATOR	
	7	124061401	1	軸位螺钉M6	SHOULDER SCREW M6	
	8	124061803	1	倒縫電機	REVERSE SWITCH MOTOR	
	9	018401632	4	螺钉M4×16	SCREW PAN M4×16	
	10	124062001	1	切換器定位	STOPPER	
	11	062500616	1	螺钉M5×6	SCREW PAN M5×6	
	12	124061601	1	送布大組件	DISTRIBUTION MODULE	
7.送布軸裝置/Feed shaft mechanism		序號	圖 號	數量	零 件 名 稱	NAME OF PARTS
	1	124070101	2	緊圈	SET SCREW COLLAR	
	2	012600636	4	螺钉M6×0.75-6	SCREW PAN M6×0.75-6	
	3	124070301	1	送布軸套L	BUSH L F-ROCKER SHAFT	
	4	124070401	1	油氈	FELT	
	5	124070501	1	送布軸套R	FEED ROCKER SHAFT BUSH R	
	6	012600632	3	螺钉M6×6	SCREW PAN M6×6	
	7	124070801	1	送布軸	FEED ROCKER SHAFT	
	8	124070901	1	滑塊組件	FEED BAR SLIDE BLOCK ASSY	
	9	062300416	1	螺钉M3×4	SCREW PAN M3×4	
	10	124071201	1	油氈壓架	FELT HOLDER	
	11	124071301	1	油氈	FELT	
	12	124071401	1	油氈	FELT	
	13	125071501	1	牙架叉組件TR	FEED BAR TR FORK ASSY	
	14	124071601	2	軸向墊圈	THRUST RING	
	15	124071901	1	開叉板	FORKED PLATE	
	16	124072001	1	調整螺栓	ADJUSTING SCREW	
	17	062400616	1	螺钉M4×6	SCREW PAN M4×6	
	18	124072201	1	牙架軸	FEED BAR SHAFT	
	19	124072301	1	水平送布台臂	FEED ROCKER BASE ARM	
	20	124072401	2	螺钉M5×12	SCREW PAN M5×12	
	21	124072601	1	螺钉M3.5	SCREW PAN M3.5	
	22	021350106	1	螺母M3.5	NUT M3.5	

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8.定規部件/Gauge parts		序號	圖 號	數量	零件名稱	NAME OF PARTS
		1	124081401	1	針夾組件 1/4	NEEDLE CLAMP ASSY 1/4
		2	124081601	1	左針夾組件 1/4	NEEDLE CLAMP ASSY 1/4
		3	124081701	1	右針夾組件 1/4	NEEDLE CLAMP ASSY 1/4
		4+	115024106	2	機針DP×5 (#14小梭)	NEEDLE DPX5(#14)
		4+	115024102	2	機針DP×5 (#20大梭)	NEEDLE DPX5(#20)
		5	124080701	1	壓腳螺釘M3.5	SCREW M3.5
		6	125080801	1	壓腳組件 1/4	PRESSER FOOT ASSY
		7	124080901	1	針板固定螺釘SM4.37	SCREW SM4.37
		8	125081001	1	針板-5 1/4	NEEDLE PLATE 5
		9	124081101	1	針板螺釘SM4.37×40-8	SCREW FLAT SM4.37×40-8
		10	124081201	2	送布牙螺釘SM3.18	SCREW W/SOCKET SM3.18
11+	125081302	1	送布牙2.2 (1/4小梭)	FEED DOG 2.2 1/4		
11+	125081303	1	送布牙 2.4 (1/4大梭)	FEED DOG 2.4 1/4		

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9. 鍍梭部件/Rotary hookj mechanism		序號	圖 號	數量	零件 名稱	NAME OF PARTS
	1	124090101	2	分線鉤連桿軸	SHAFT O-LINK	
	2+	124090201	2	分線鉤連桿 (小梭)	OPENER LINK	
	2+	125090201	2	分線鉤連桿 (大梭)	OPENER LINK	
	3	124090301	2	螺釘SM3.57×40	SCREW SM3.57×40	
	4	124090401	4	分線鉤	OPENER	
	5+	124090501	2	分線鉤桿 (小梭)	OPENER LEVER	
	5+	125090501	2	分線鉤桿 (大梭)	OPENER LEVER	
	6	025050132	2	墊圈M5	WASHER M5	
	7	021500106	2	螺母M5	NUT M5	
	8	124090801	2	分線鉤桿短軸	O-LEVER SHAFT	
	9	124090901	2	軸向墊圈	THRUST RING	
	10	124091001	2	滾針軸承	NEEDLE BEARING	
	11	124091101	2	止動圈	RETAINING RING	
	12+	124091201	2	鍍梭軸套U (小梭)	ROTARY BUSH U	
	12+	125091201	2	鍍梭軸套U (大梭)	ROTARY BUSH U	
	13	124091301	1	墊圈L	THRUST WASHER L	
	14	124091401	1	鍍梭底座蓋L	ROTARY HOOK BASE COVER L	
	15	062300516	8	螺釘M3×5	SCREW M3×5	
	16	124091602	2	大齒輪組件	SPIRAL GEAR SCREW ASSY	
	17	124091801	2	油氈	FELT	
	18	062400616	6	螺釘M4×6	SCREW M4×6	
	19	124091901	2	油氈架	FELT SUPPORT	
	20	012501032	2	螺釘M5×10	SCREW M5×10	
	21+	124095701-2	1	左鍍梭支架 (小梭)	LEFT-HANDED SHUTTLE BRACKET	
	21+	125095701-2	1	左鍍梭支架 (大梭)	LEFT-HANDED SHUTTLE BRACKET	
	22+	124095801-2	1	右鍍梭支架 (小梭)	RIGHT-HANDED SHUTTLE SUPPORT	
	22+	125095801-2	1	右鍍梭支架 (大梭)	RIGHT-HANDED SHUTTLE SUPPORT	
	23	124092701	2	套管組件	PINCH SLEEVE ASSY	
	24	124154501	2	墊圈 6	WASHER 6	
	25	018062532	2	螺釘M6×25	SCREW M6×25	
	26	124093301	3	定位螺釘	STOPPER SCREW	
	27	124093701	2	油氈	FELT	
	28	124093601	1	油氈支架DL	FELT SUPPORT DL	
	29	124093801	1	油氈支架UL	FELT SUPPORT UL	
	30	124095901	2	油氈	FELT	
	31	124094002	2	小齒輪組件	PINION GEAR SCREW ASSY	
	32	124094101	2	鍍梭軸套D	ROTARY HOOK SHAFT BUSH	
	33	124094303	1	彈簧	SPRING	
	34	062061016	2	螺釘M6×10	SCREW M6×10	
	35	124094601	1	調節軸	NEEDLE UPPER POSITIONING SHAFT	
	36	124094701	1	鍍梭底座蓋FL	ROTARY HOOK BASE COVER FL	
	37	062401216	4	螺釘M4×12	SCREW M4×12	
	38	124095002	1	鍍梭底座蓋R	ROTARY HOOK BASE COVER R	
39	124095201	1	鍍梭底座蓋FR	ROTARY HOOK BASE COVER FR		
40	124095301	1	油氈支架DR	FELT SUPPORT DR		
41	124095401	1	油氈支架UR	FELT SUPPORT UR		
42	124094201	1	調節板	NEEDLE UPPER POSITIONING PLATE		
43	124096101	1	支架UL油氈	FELT SUPPORT UL		

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10. 鍍梭裝置/Rotary hook mechanism	序號	圖 號	數量	零件名稱	NAME OF PARTS
	1+	124100201-2	2	梭芯套組件(小梭)	GAP ASSY
	1+	125100201	2	梭芯套組件(大梭)	GAP ASSY
	2+	124100101	2	鍍梭組件(小梭)	ROTARY HOOK BOX ASYY
	2+	125100101	2	鍍梭組件(大梭)	ROTARY HOOK BOX ASYY
	3+	124100106	2	鍍梭組件(小梭)	ROTARY HOOK BOX ASYY
	3+	125100105	2	鍍梭組件(大梭)	ROTARY HOOK BOX ASYY
	4+	124095501	2	梭芯(小梭)	BOBBIN (S)
	4+	125095501	2	梭芯(大梭)	BOBBIN (B)
	5	124095601	2	彈簧	ANTI-SPIN SPRING
	11. 繞線裝置/Bobbin winder mechanism	序號	圖 號	數量	零件名稱
	1	115100101	1	繞線器組件	BOBBIN WINDER UNIT
	2	115100501	3	固定螺釘M5	BOBBIN WINDER FIXED SCREW
	3	062500616	1	螺釘M5×6	SCREW PAN M5×6
	4	115100301	1	切刀	KNIFE
	5	124140501	1	繞線器夾線組件	BOBBIN WINDER TENSION ASSY
12. 下軸裝置/Lower shaft mechanism	序號	圖 號	數量	零件名稱	NAME OF PARTS
	1	124110101	1	鍍梭底座軸套L	ROTARY HOOK BASE BUSH L
	2	124110201	1	下軸	LOWER SHAFT
	3	124110402	1	鍍梭底座軸套R	ROTARY HOOK BASE BUSH R
	4	124110601	1	螺釘M6	SCREW PAN M6
	5	124110501	1	上下偏心輪	F-LIFTING ECCENTRIC WHEEL
	6	115024001	1	油封	OIL SEAL
	7	124110801	1	下軸中套	LOWER SHAFT MIDDLE SLEEVE
	8	115083001	1	柱塞	RUBBER PRESSER
	9	115083301	1	柱塞彈簧	RUBBER PRESSER SPRING
	10	115083501	1	泵蓋螺釘	SCREW
	11	012600636	6	螺釘M6×0.75-6	SCREW PAN M6×0.75-6
	12	128131401	1	軸承套	BALL BEARING BUSH
	13	115024501	1	軸承6004ZZNR	BALL BEARING 6004ZZNR
	14	124111501	1	同步輪U	TIMING PULLEY U
	15	124111701	2	墊片4.8	WASHER 4.8
13. 穿線裝置/Threading mechanism	序號	圖 號	數量	零件名稱	NAME OF PARTS
	1	062400616	4	螺釘M4×6	SCREW PAN M5×6
	2	168070201	1	電磁鐵罩(單針桿)	SOLENOID COVER
	3	691220000	1	松線電磁鐵	TENSION RELEASE SOLENOID
	4	062501016	7	螺釘M5×10	SCREW PAN M5×10
	5	168070802	1	電磁鐵安裝板	SOLENOID SETTING PLATE
	6	124132501	1	過線板	SPOOL PLATE
	7	127130302	1	松線軸	TENSION RELEASE CRANK
	8	124131301	1	線導向 M	THREAD GUIDE M ARM
	9	124131401	2	螺釘M5×8	SCREW PAN M5×8
	10	124131601	1	油氈	FELT
	11	124131501	1	線導向 D	THREAD GUIDE D ARM
	12	124132601	1	下過線油氈壓板	WIRE PLATE
	13	124132701	2	螺釘SM2.38×56	SCREW PAN SM2.38×56
	14	124130102	1	夾線器組件	UPPER THREAD TENSION ASSY

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18.附件/Accessories		序號	圖號	數量	零件名稱	NAME OF PARTS
<div> <div>A</div> <div>B</div> <div>C</div> </div>		1	115150401	2	機頭鉸鏈	HEAD HINGE
		2	115151701	6	釘	NAIL
		3	115150501	2	機頭鉸鏈套	RUBBER CUSHION
		4	115150601	2	頭部防震墊 L	HEAD CUSHION L
		5	115150801	2	頭部防震墊 R	HEAD CUSHION R
		6	115151601	1	螺絲刀 (小)	SCREW DIRVER S
		7	115151701	1	螺絲刀 (中)	SCREW DIRVER M
		8	115151801	1	螺絲刀 (大)	SCREW DIRVER B
		9+	115024106	4枚	機針DP×5 14	NEEDLE DP×5 14
		9+	115024102	4枚	機針DP×5 20	NEEDLE DP×5 20
		10+	124095501	2	梭芯(小)	BOBBIN S
		10+	125095501	2	梭芯(大)	BOBBIN B
		11	124181101	1	油壺	OILER
		12	115151001	1	中號油壺	OIL TANK ASSY
		13	115152001	1	調速器	GOVERNOR
		14	169140901	1	機頭撐桿	HEAD REST
		15	115151901	1	連桿組件	CONNECTING ROD ASSY
		16	124170401	1	橡皮塞7	RUBBER CAP 7
		17	124181801	1	油盤	OIL PAN
		18	124181901	1	放油口	DRAIN
		19	168110302	4	自攻螺釘M3×6	SCREW ST M3×6
		20	124182801	1	線架3DR	THREAD STAND ASM 3DR
		21	125104001	1	膝控組件	KNEE LIFTER ASSY
		22	125104101	1	膝控接頭	KNEE JOINT
		23	169050101	1	電子膝靠組件	ELECTRONIC
		24	062350616	1	螺釘 M3.5×6	SCREW PAN M3.5×6
		25	025350132	1	墊片	WASHER
		26	124180201	1	護罩座	GUARD SEAT
		27	103010801	1	面板固定螺柱	PANEL STUD
		28	188021001	1	護目罩支架段螺釘	SCREW
		29	188021101	2	波形墊片	WASHER
		30	124180101	1	護罩架	GUARD FRAME
		31	124180301	1	觀察鏡	OBSERVATION MIRROR
		32	101080701	2	螺釘	SCREW
		33	081022870	1	O型圈 S22	O RING
		34	124121201	1	副油罐	SUB TANK

針位對照表/Needle position comparison table							
針寬 Needle gauge	針夾複合件 (雙針桿) Needle clamp set		針夾組件 (單針桿) Needle clamp assy	針板 Needle plate	送布牙 Feed dog		壓腳組件 Presser foot assy
					用於中厚料 For medium materials	用於厚料 For heavy materials	
1/.8 (3.2mm)	L:124081603	R:124081703	124081402	124083202	124083302	125083302	124083102
3/.16 (4.8mm)	L:124081602	R:124081702	124081403	124083201	124083301	125083301	124083101
1/.4 (6.4mm)	L:124081601	R:124081701	124081401	125081001	125081302	125081303	125080801
3/.8 (9.5mm)	L:124081604	R:124081704	124081404	124083203	124083303	125083303	124083103
1/.2 (12.7mm)	L:124081606	R:124081706	124081406	124083205	124083305	125083305	124083105
5/.8 (15.9mm)	L:124081605	R:124081705	124081405	124083204	124083304	125083304	124083104
3/.4 (19.1mm)			124081409	124083207	124083307	125083307	124083108

鉤梭對照表 HOOK TABLE						
機型	DT828L-42-M	DT828L-42-H	DT828L-72-H	DT828L-45-M	DT828L-45-H	DT828L-75-H
鉤梭組件	124100106	124100106	125100105	124100101	124100101	125100101
梭芯套組件				124100201-2	124100201-2	125100201



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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.
DML-13P01.OCT.2023