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十分感谢您购买重工牌工业缝纫机。
在使用缝纫机之前，请仔细阅读<为了您的安全使用>和使用说明书。

工业缝纫机的特性之一，因为要在机针和弯针等运动另部件附近进行操作，而这些另部件很容易引起受伤的危险，所以请在受过培训的人或熟练人员的安全操作知识的指导下，正确地使用本缝纫机。

为了您的安全使用

1. 安全使用的标记及其意义

本使用说明书及产品所使用的标记和图案记号是为了您的安全而正确地使用产品，防止您及其他人受到危害和损害。

表示方法及含意如下：

标 记



危 险 如果忽视此标记而进行了错误的操作，肯定会引起人员死亡或重伤。



注 意 如果忽视此标记而进行了错误的操作，有可能会引起人员受伤及造成设备损坏。

图案和符号



· · · · 该符号表示"应该注意事项"。
三角中的图案表示必须要注意的实质内容。
(例如，左边的图案表示"当心受伤")



· · · · 该符号表示"禁止"。



· · · · 该符号表示"必须"。
圆圈中的图案表示必须要做的事情的实质内容。
(例如，左边的图案表示"必须接地")

2. 安全注意事项

注意

使用环境

- ❗ 应避免在强电气干扰源(如高频焊机)的附近使用本缝纫机。
强电气干扰源可能会影响缝纫机的正确操作。
- ❗ 电源电压的波动应该在额定电压的 $\pm 10\%$ 以内的环境下使用。
电压大幅度的波动会影响缝纫机的正确操作。
- ❗ 电源容量应大于缝纫机的消耗电量。电源容量不足会影响缝纫机的正确操作。
- ❗ 环境温度应在 $5^{\circ}\text{C}\sim 35^{\circ}\text{C}$ 的范围内使用。
低温或高温会影响缝纫机的正确操作。
- ❗ 相对温度应在 $45\%\sim 85\%$ 的范围内，并且设备内不会形成结露的环境下使用。
干燥或多湿的环境和结露会影响缝纫机的正确操作。
- ❗ 使用时应避免暴露于直射的阳光下。
直射的阳光下会影响缝纫机的正确操作。
- ❗ 万一发生雷电暴风雨时，关闭电源开关，并将电源插头从插座上拔下。雷电可能会影响缝纫机的正确操作。

安 装

- ⊘ 请让受过培训的技术人员来安装缝纫机。
- ❗ 请委托购买商店或电气专业人员进行电气配线。
- ❗ 缝纫机重49公斤，安装工作必须由两人以上来完成。
- ⊘ 在安装完成前，请不要连接电源，如果误按起动开关，缝纫机动作会导致受伤。
- ❗ 请在切断电源后，再拔掉电插头。
不然易成为控制箱发生故障的原因。
- ⊕ 必须接地。
接驳地线不牢固，是造成触电或误动作的原因。
- ❗ 固定电缆时，不要过度弯曲电缆或用卡钉固定得过紧，会引起火灾或触电的危险。
- ❗ 如果使用带小脚轮的工作台，则应该固定小脚轮，使其不能移动。
- ⚠ 缝纫机头倒下或竖起时，请用双手进行操作。单手操作时因缝纫机的重量万一滑落易导致受伤。
- ⊘ 使用润滑油和黄油时，务必戴好护眼镜和保护手套等，以防润滑油落入眼中或沾在皮肤上，这是引起发炎的原因。
另外，润滑油或黄油不能饮用，否则会引起呕吐和腹泻。
将油放在小孩拿不到的地方。

注意

缝 纫

- ⊘ 本缝纫机仅限于接受过安全操作培训的人员使用。
- ⊘ 本缝纫机不能用于除缝纫外的任何其他用途。
- ❗ 使用缝纫机时必须戴上保护眼镜。如果不戴保护眼镜，断针时就会有危险，机针的折断部分可能会弹入眼睛并造成伤害。
- ⚠ 发生下列情况时，请切断电源。否则误按动起动开关，缝纫机动作会导致受伤。
 - 机针穿线时
 - 更换机针或梭芯时
 - 缝纫机不使用，或人离开缝纫机时。
- ❗ 如果使用带小脚轮的工作台，则应该固定小脚轮使其不能移动。
- ⚠ 为了安全起见，在使用本缝纫机之前，请安装保护装置。如果未安装这些安全装置就使用缝纫机，会造成人身伤害及缝纫机损坏。
- ⚠ 缝纫过程中，不要触摸任何运动部件或将物件靠在运动部件上，因为这会导致人员受作或缝纫机损坏。
- ⚠ 缝纫机头倒下或竖起时，请用双手进行操作。单手操作时因缝纫机的重量万一滑落易导致受伤。
- ❗ 如果缝纫机操作中发生误动作，或听到异常的噪音或闻到异常的气味，应立即切断电。然后请与购买商店或受过培训的技术人员联系。
- ❗ 如果缝纫机出现故障，请与购买商店或受过培训的技术人员联系。

清 洁

- ⚠ 在开始清洁作业前，请切断电源。如果当误按动起动开关时，缝纫机动作会导致人员受伤。
- ⚠ 缝纫机头倒下或竖起时，请用双手进行操作。单手操作时因缝纫机的重量万一滑落易导致受伤。
- ⊘ 使用润滑油和黄油时，务必戴好保护眼镜和保护手套等，以防润滑油落入眼中或沾在皮肤上，这是引起发炎的原因。另处，润滑油或黄油不能饮用，否则会引起呕吐和腹泻。将油放在小孩拿不到的地方。
- ❗ 请使用杰克公司指定更换的零部件。

Thank you very much for buying a JUGO sewing machine. Before using your new machine, please read the safety instructions below and the explanations given in the instruction manual.

With industrial sewing machines, it is normal to carry out work while positioned directly in front of moving parts such as the needle and thread take-up and thread take-up lever, and consequently there is always a danger of injury that can be caused by these parts. Follow the instructions from training personnel and instructors regarding safe and correct operation before operating the machine so that you will know how to use it correctly.

SAFETY INSTRUCTIONS

1. Safety instructions and their meanings

This instruction manual and the indications and symbols that are used on the machine itself are provided in order to ensure safe operation of this machine and to prevent accidents and injury to yourself or other people.

The meanings of these indications and symbols are given below.

Indications

 CAUTION	The instructions which follow this term indicate situations where failure to follow the instructions could cause injury when using the machine or physical damage to equipment and surroundings.
---	--

Symbols



- • • • This symbol indicates something that you should be careful of. The picture inside the triangle indicates the nature of the caution that must be taken.
(For example, the symbol at left means "beware of injury".)



- • • • This symbol indicates something that you must not do.



- • • • This symbol indicates something that you must do. The picture inside the circle indicates the nature of the thing that must be done.
(For example, the symbol at left means "you must make the ground connection".)

CAUTION

Sewing

-  This sewing machine should only be used by operators who have received the necessary training in safe use before-hand.
-  The sewing machine should not be used for any applications other than sewing.
-  Attach all safety devices before using the sewing machine. If the machine is used without these devices attached, injury may result.
-  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.
-  Turn off the power switch at the following times, the machine may operate if the treadle is pressed by mistake, which could result in injury.
 - When threading the needle
 - When replacing the needle
 - When not using the machine and
 - When leaving the machine unattended
-  If using a work table which has casters, the casters should be secured in such a way so that they cannot move.
-  If an error occurs in machine, or if abnormal noises or smells are noticed, immediately turn off the power switch. Then contact your nearest Brother dealer or a qualified technician.

Cleaning

-  Turn off the power switch before carrying out cleaning. The motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work.
The machine may operate if the treadle is pressed by mistake, which could result in injury.
-  Be sure to wear protective goggles and gloves when handling the lubricating oil, so that no oil gets into your eyes or onto your skin, otherwise inflammation can result.
Furthermore, do not drink the oil under any circumstances, as it can cause vomiting and diarrhoea.
Keep the oil out of the reach of children.

Maintenance and inspection

- Maintenance and inspection of the sewing machine should only be carried out by a qualified technician.
-  Ask your **JUGO** dealer or a qualified electrician to carry out any maintenance and inspection of the electrical system.
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 pressed by mistake, which could result in injury.
-  However, the motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work.
When carrying out inspection, adjustment and maintenance.
When replacing consumable parts such as the looper
-  If the power switch needs to be left on when carrying out some adjustment, be extremely careful to observe all safety precautions.
-  Use only the proper replacement parts as specified by **JUGO**.
-  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.
-  Any problems in machine operation which result from unauthorized modifications to the machine will not be covered by the warranty.

警告标签 / WARNING LABELS

缝纫机上有列警告标签。

当使用缝纫机时，请遵守标签上的说明。如果标签脱落或模糊不清，请与经销商联系。

The following warning labels appear on the sewing machine.

Please following the instions on the labels at all times when using the machine. If the labels have been rMOVED or are difficult to read, please contact your nearest Brother dealer.

(1)



(2)



必须接地!

接驳地线不牢固，是造成触电或误动作的原因。

Be sure to connect the ground. If the ground connection is not secure, you run the risk of receiving a serious electric shock.

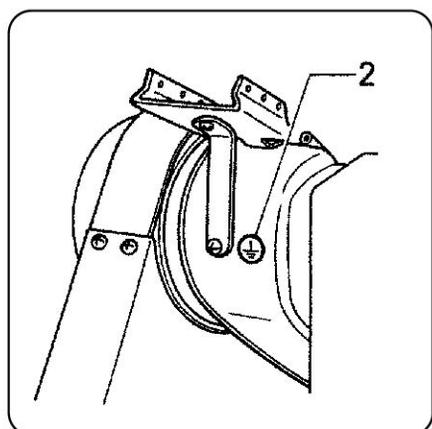
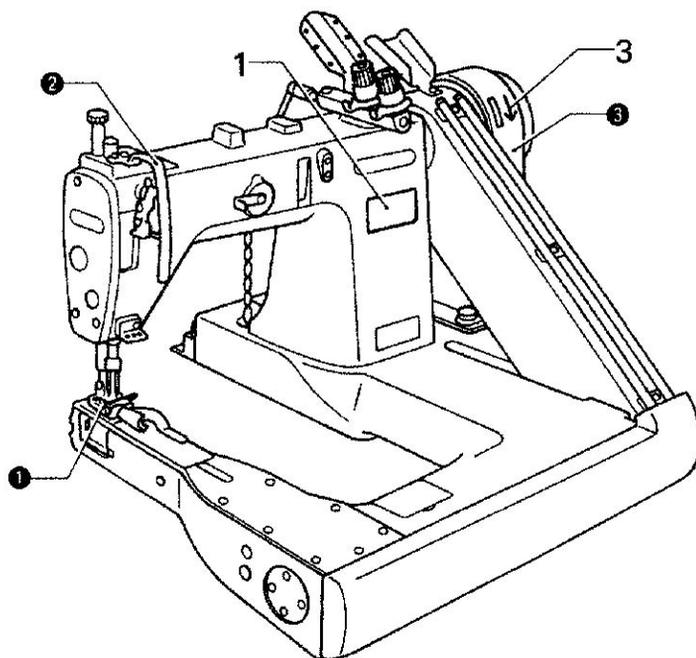
(3)



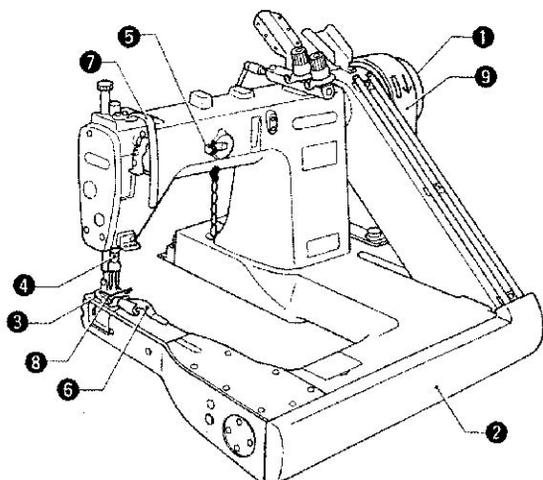
表示转动方向。

Direction of operation.

- ① 护指器 Finger guard
- ② 防护罩 Thread take-up cover
- ③ 皮带罩 Pulley cover, etc.



1. 各部件名称 / NAMES OF MAJOR PARTS



- | | |
|-----------|---------------------------|
| 1. 皮带轮 | 1. Machine pulley |
| 2. 前导壳 | 2. Front cover |
| 3. 压脚 | 3. Presser |
| 4. 针夹头 | 4. Needle bar |
| 5. 面线过线勾 | 5. Upper thread arm guide |
| 6. 送布导架 | 6. Lapper |
| | |
| 安全保护装置 | SAFETY DEVICE |
| 7. 挑线杆防护罩 | 7. Thread take-up cover |
| 8. 护指口 | 8. Finger guard |
| 9. 皮带轮罩 | 9. Pulley cover |

2. 缝纫机规格 / MACHINE SPECIFICATIONS



规格
Specifications

规格 Specifications	-1	-2	-3	-A	
用途 Applications	薄料 Light materials	中厚面料 Light-medium materials	一般面料 Medium materials	薄料, 针织料 Light materials, with puller	
针数 NO.of needles	2	2	2	2	3
机针型号 Needle TVX64	#12	#14	#16	#11PSU	
针距 Needle gauge	4.8mm (3/16) 6.4mm (1/4)	3.2mm (1/8) 4.0mm (5/32) 4.8mm (3/16)	6.4 mm (1/4)	4.8 mm (3/16) 6.4mm (1/4)	6.4mm (1/4)
最大线迹长度 Max. stitch length	3.0 mm		3.5 mm	3.0mm	
最小悬臂长度 Min. arm size	171 mm				
最大缝纫速度 Max. sewing speed	4,000 rpm			3,600 rpm	

3. 工作台板和马达 / WORK TABLE AND MOTOR

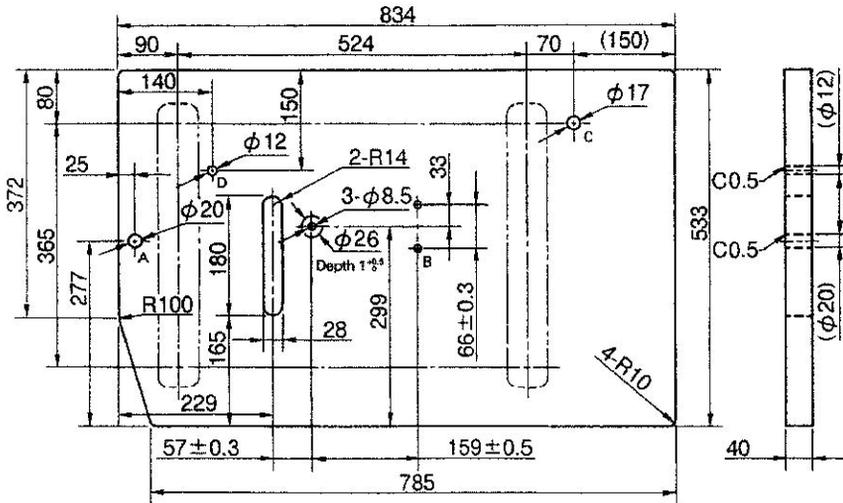
■ 工作台 / Work Table

台板的厚度应达40mm能够承受缝纫机的重量，并经得起缝纫机的震动。

请在如图指示位置钻孔。

The top of the table should be 40mm in thickness and should be strong enough to hold the weight and withstand the vibration of the sewing machine.

Drill holes as indicated in the illustration below.



- A. 链条过孔
Chain hole
- B. 电机安装孔
Motor mounting holes
- C. 线螺孔
Cotton stand hole
- D. 地线过孔
Ground hole

⚠ 注意 CAUTION



连接到电机的所有电线必须离电机运转部分25mm以上。

All cords which are connected to the motor should be secured at least 25mm away from any moving parts. Furthermore, do not excessively bend the cords or secure them too firmly with staples, otherwise there is the danger that fire or electric shocks could occur.



电机运转时应正确安装皮带轮罩。

Install the correct belt cover which corresponds to the motor being used.

选择正确的电机并安装。

Select the correct motor from those listed in the above table. Refer to the instruction manual for the motor for details on installing and using the motor

电源 Power	马达 Motor
单相 Single-phase	2-pole, 400 W motor
三相 Three-phase	2-pole, 400 W motor

选择正确的皮带和合适的缝速 < Motor pulley and V-belt >

Refer to the table below to select the motor pulley and belt combination.

The belt should be an M-type V-belt.

Pulley O.D.	65	70	75	80	85	90	95	100
皮带尺寸 Belt size (inches)	M42	←		M43	←		M44	→
	50Hz			3100		3600		4000
缝纫速度 Sewing speed (rpm)	60Hz	3100		3600		4000		

4. 安装方法 / INSTALLATION

⚠ 注意 CAUTION



请让受过培训的技术人员来安装缝纫机。



请委托购买商店或电气专业人员进行电气配线。



缝纫机重49公斤，安装工作必须由两人以上来完成。



在安装完成前，请不要连接电源，如果误按起动开关，缝纫机动作会导致受伤。



缝纫机头倒下或竖起时，请用双手进行操作。

单手操作时，因缝纫机的重量，万一滑落易致受伤。



The sewing machine should only be installed by a qualified technician.



Ask your **JUGO** dealer or a qualified electrician for any electrical work that may need to be done.



The sewing machine weighs more than 49kg. The installation should be carried out by two or more people.



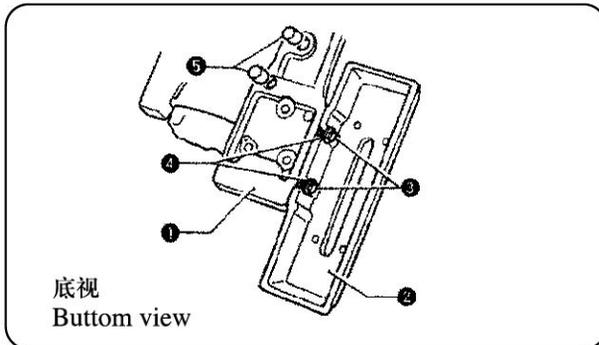
Do not connect the power cord until installation is complete., otherwise the machine will operate if the treadle is pressed by mistake, which could result in injury.



Be sure to connect the ground. If the ground connection is not secure, serious electric shocks will result.

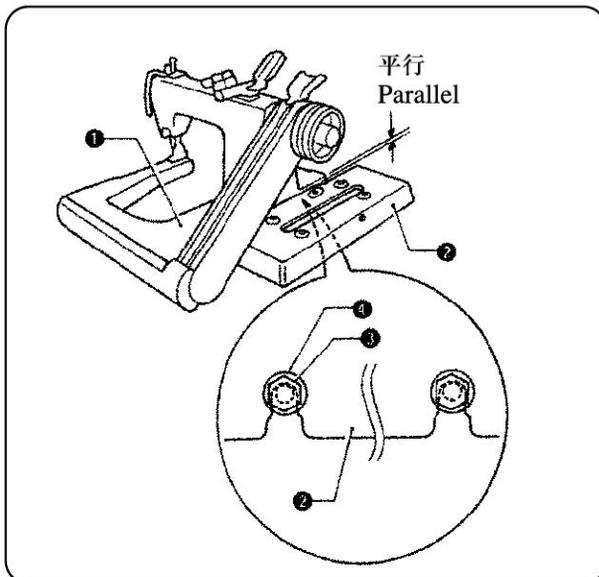
Install the pulley cover to the machine head.

4-1. 机头安装 / Installing the machine head



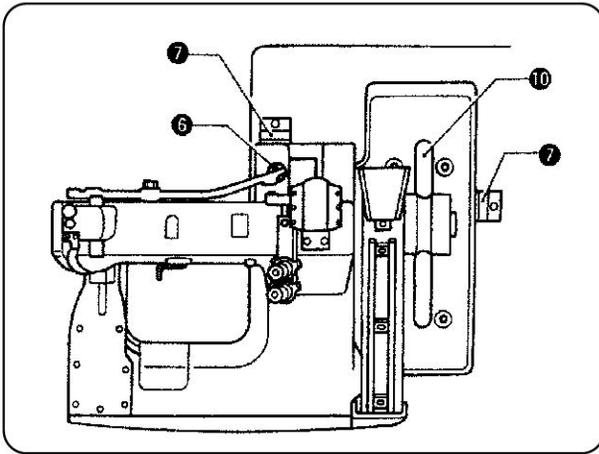
1. 用两个六角螺钉③和垫片④把底座②安装在机器。
2. 把两个橡皮垫⑤安放在机器和台板之间。

1. Install pulley cover base ② on machine bed ① with two hexagonal bolts ③ and two washers ④.
2. Insert two bar cushions ⑤ into the holes in the bottom of the bed.

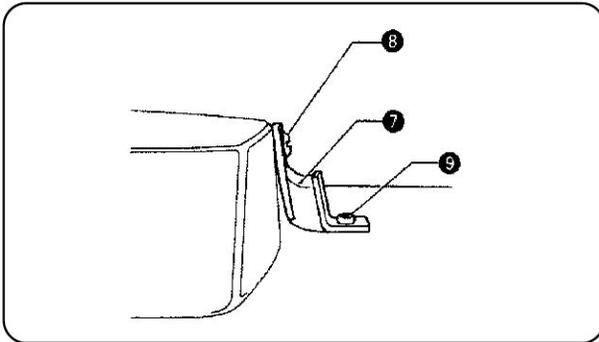


1. 用两个六角螺钉③把底座②固定在机器上。
2. 此外，检查机器底座②是否水平放置在台板上。（如果不水平，带轮罩可能会碰到机器上）。

1. At this time, install the two hexagonal bolts ③ so that they go as far as possible into the notches in the pulley cover base ②.
2. Furthermore, check that the pulley cover base ② is parallel to the bed. (If it is not parallel, the pulley cover may touch the machine pulley.)



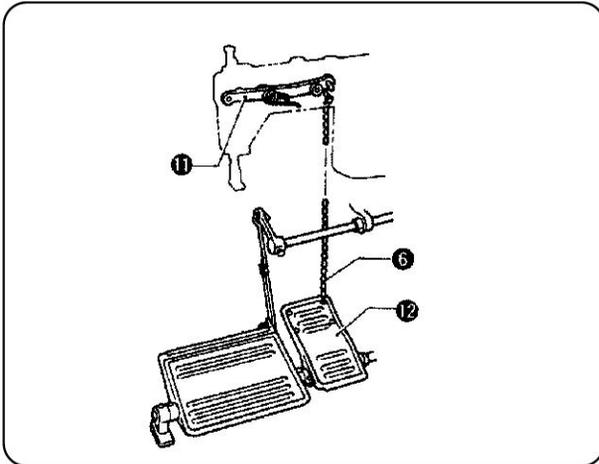
3. 将机头放在台板上用压脚链的孔来调节其前后方向用皮带槽来横向调节。
3. Place the machine head on the table, adjust its position in forward and backward directions by aligning it with the hole for presser bar lifter chain ⑥, and in sidewise directions by aligning it with belt hole ⑩.



4. 用螺钉把垫片固定在机座和滑轮盖底部之间用螺丝把它们固定在台板上。放置好台板,这样机头才是水平的,如果机头不水平,那么润滑油就无法正常流出。
4. After fastening cushions ⑦ to the machine bed and pulley cover base with set screws ⑧, fix them to the table with screws ⑨.

*Place the work table so that the machine head is horizontal.

If the machine head is not horizontal, lubrication will not be carried out correctly.



5. 把踏脚链同膝控抬压杆和压脚踏板相连。
5. Connect the presser bar lifter chain ⑥ to the knee lifter lever ⑪ and the presser lifter pedal ⑫.

把地线同机头和电机相连。
使用合适的地线和垫圈。

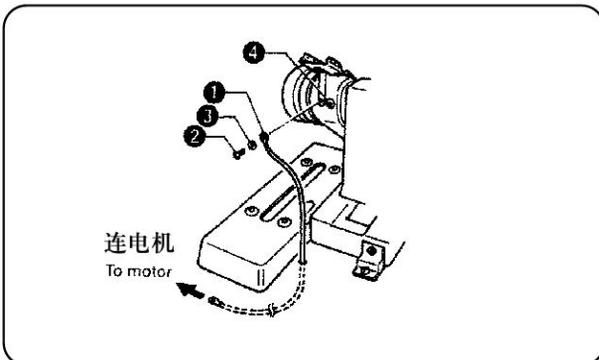
1. 拿掉引线器螺丝。
2. 用螺丝承垫圈把地线固定住。
(触点由一个地面符号标出)
3. 把地线从台板的孔中穿过。
4. 根据电机说明手册中的说明把地线连到电机上。

Connect the ground wire to the sewing machine head and motor.

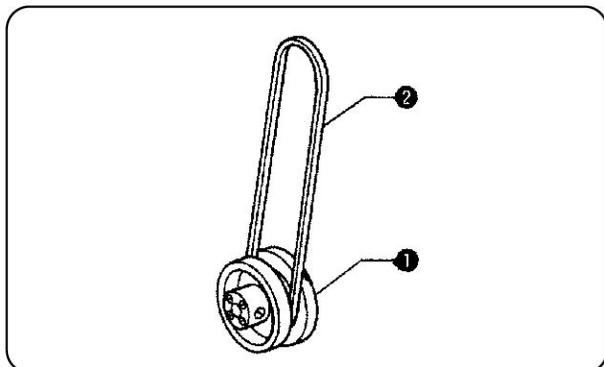
(Use the correct type of ground wire and washer.)

1. Remove lower thread guide holder screw ②.
2. Secure the ground wire ① to the sewing machine head with screw ② and washer ③.
3. Pass the ground wire ① through the hole in the table.
4. Connect the ground wire ① to the motor in accordance with the instructions in this instructing manual for the motor.

4-2. 地线连接 / Ground wire connections

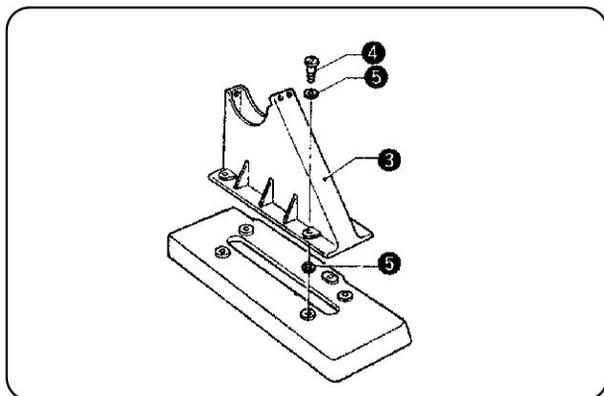


4-3. 安装滑轮盖 / Installing the pulley cover



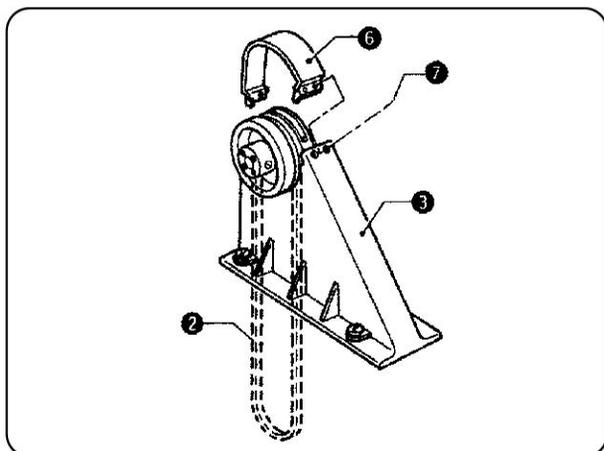
1. 把皮带安在机器滑轮上, 当安装滑轮盖A ③ 时, 把皮带向上拉。

1. Place the belt ② onto the machine pulley ①. Pull the belt ② upward when installing pulley cover A ③.



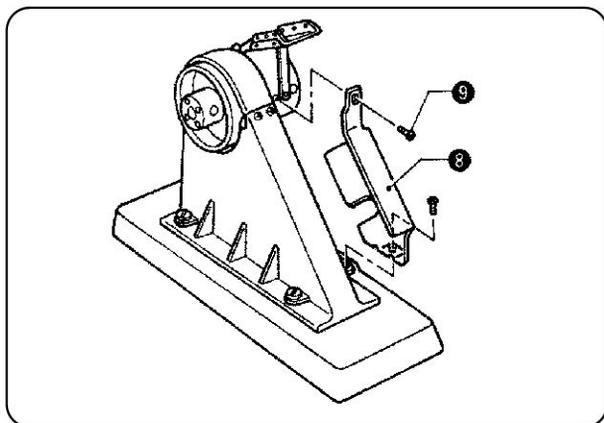
2. 安放好滑轮盖A ③ 使其处于八个滑轮盖位之间然后用4个螺丝把它固定在滑轮盖底座上。

2. Place pulley cover A ③ so that it is in between the eight pulley cover seats ⑤, and then secure it to the pulley cover base with the four screws ④.



3. 向下推动皮带, 然后用三个螺丝把滑轮盖B安装在滑轮盖A ③ 上。

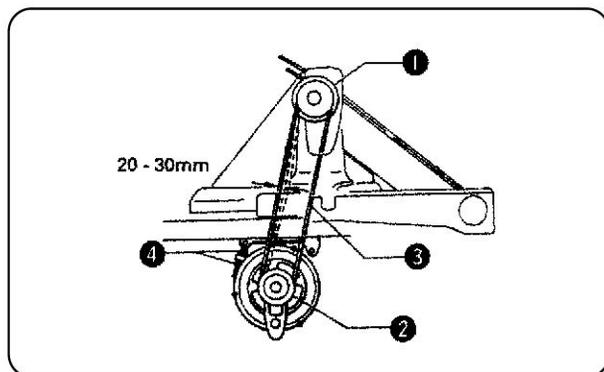
3. Push the belt ② downward, and then install pulley cover B ⑥ to pulley cover A ③ with the three screws ⑦.



4. If the machine is being used with the puller attached install the puller belt cover ⑧ with the two screws ⑨.

4. 如果机器是用接触式带动的, 就用两个螺丝把牵引皮带安装好。

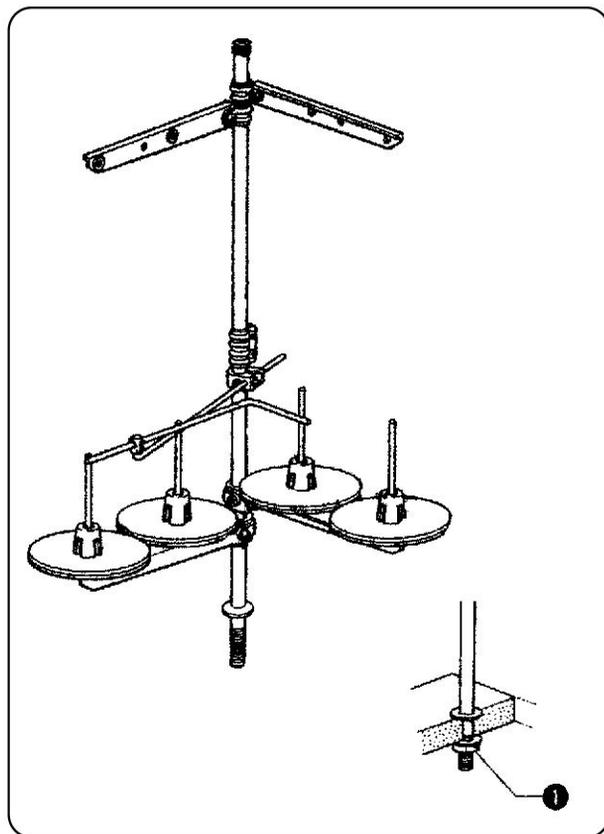
4-4. 皮带松紧带 / Belt tension adjustment



1. 把V型皮带安装在电机滑轮上。
2. 旋转螺丝加以调节当使用9.8牛的力在中点压皮带时，有一个20到30毫米的偏转。

1. Place the V-belt **3** onto the motor pulley **2**.
2. Turn the two nuts **4** to adjust so there is 20-30mm of deflection in the V-belt **3** when it is pressed at the midway point with a force of 9.8 N.

4-5. 线团架 / Cotton stand



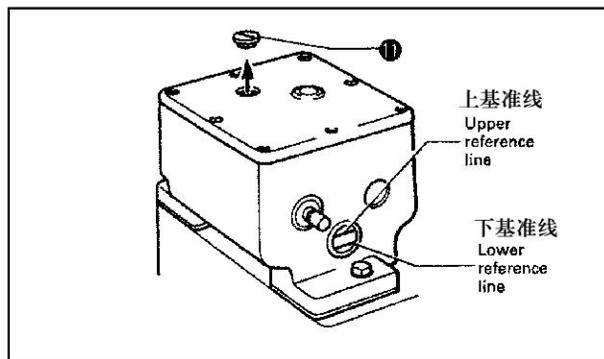
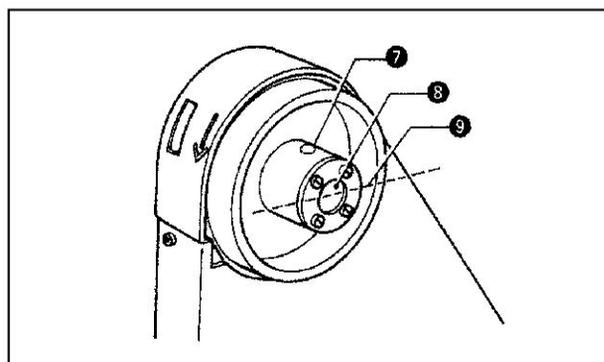
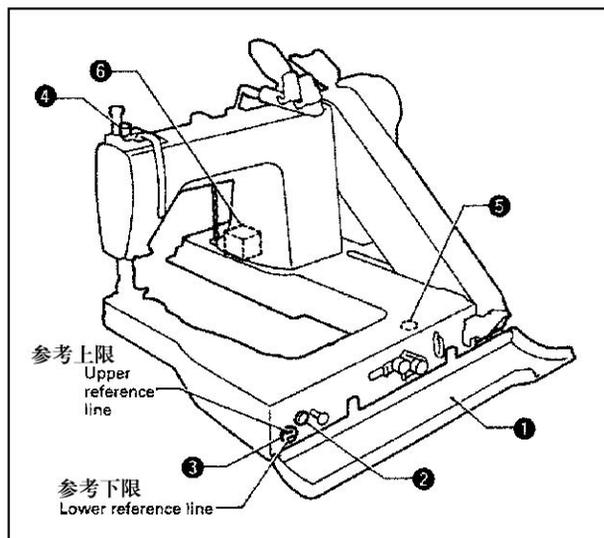
1. 参照线团架说明手册来安装线团架。
2. 用螺母把线团架安装到台板线团架。

1. Assemble the cotton stand while referring to the cotton stand instruction manual.
2. Install the cotton stand to the cotton stand mounting hole in the work table with the nut **1**.

4-6. 润滑油 / Lubrication

注意 CAUTION

-  使用润滑油和黄油时，务必戴好保护眼镜和保护手套等，以防润滑油落入眼中或沾在皮肤上，这是引起发炎的原因。
另处，润滑油或黄油不能饮用，否则会引起呕吐和腹泻。
-  Be sure to wear protective goggles and gloves when handling the lubricating oil, so that no oil gets into your eyes or onto your skin, otherwise inflammation can result.
Furthermore, do not drink the oil under any circumstances, as it can cause vomiting and diarrhoea.
Keep the oil out of the reach of children.



· 机器应经常润滑，在第一次用之前和长期未用之后油都要补充，只能使用重工指定的润滑油。

1. 打开前盖拿掉橡皮塞然后往里加油直至油量线达到油量参考线之间。
2. 插入橡皮塞然后关掉前盖。
3. 每周往针架润滑孔内加倒2滴油。
4. 定期松开油槽螺丝放开积存在机座前部油箱里的积油排开剩油后旋紧放油螺丝。
5. 定期用布擦除积存在机座后部油箱里的积油。
6. 旋转机器滑轮使油孔盖朝上然后拿掉油孔盖，往油箱里加满油。如果润滑油量低于油箱上的参考限度的中点那么上部的杆就没有油流入了，这样就不能得到充分的润滑。确保使得润滑油保持在参考线的中部以上。
7. 旋紧油孔盖。

* 如果机器是由附带的马达带动的则拿掉盖子上的螺丝，加油直至油量达到油箱上的参考上限；如果油量降至参考下限，务必要加油润滑完成后，旋紧盖面螺丝。

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.

Use only the lubricating oil (Nisseki Mitsubishi sewing Lube 15N; VG15) specified by JUGO.

1. Open the front cover **1**, remove the rubber plug **2**, and then fill with oil until the oil level reaches the point in between the reference lines on the oil gauge **3**. If the oil level drops to the lower reference line, be sure to add more oil.
2. Insert the rubber plug **2** and then close the front cover **1**.
3. Add 1-2 drops of oil once a week to needle bar bracket lubrication hole **4**.
4. Periodically loosen the oil drain screw **5** to drain out any oil which collects in the front bed oil sump.

After draining the oil, tighten the oil drain screw ⑤.

5. Periodically wipe away any oil which collects in the rear bed oil sump ⑥ with a cloth.

6. Turn the machine pulley, so that the oil hole cover ⑦ is facing upward, and then remove the oil hole cover ⑦ and fill the oil tank ⑧ with oil.

If the level of lubricating oil drops below the middle reference line ⑨ on the oil tank, no oil will thus not be lubricated sufficiently. Be sure to maintain the lubricating oil level at a level above the center reference line.

7. Attach the oil hole cover ⑦.

* If the machine is being used with the puller attached remove the cover screws ⑩ and fill with oil until the level reaches the upper reference line in the oil sight glass.

If the oil level drops to the lower reference line, be sure to add more oil.

After lubrication is completed, tighten the cover screw ⑪.

4-7. 检查机器的运转方向 / Checking the machine pulley rotating direction

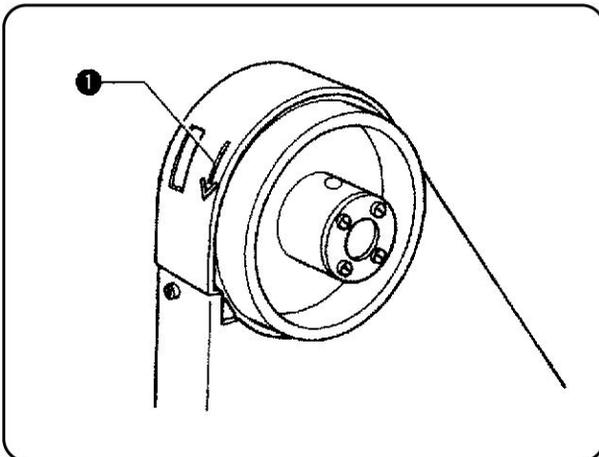
注意 CAUTION



缝纫过程中，不要触摸任何运动部件或物体靠在运动部件上，因为这会导致人员受伤或缝纫机损坏。



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



1. 把电源插入壁装电源插座然后打开动力开关。

2. 轻轻压下踏板检查机器滑轮能以箭头方向转动。若运转方向反了，根据电机说明手册把转动方向调整正确。在开始用的3,4天，要以500rpm的速度运转，低于正常的速度，这将有助于延长机器寿命。

1. Insert the power cord plug into the wall outlet, and then turn on the power switch.

2. Depress the treadle slightly and check that the machine pulley starts to turn in the direction of the arrow ①.

* If the direction of rotation is reversed, change the direction of rotation to the correct direction while referring to the instruction manual for the motor.

* For the first 3-4 days of use, run the machine at 500 rpm lower than the usual speed, This will help contribute t a longer service life for the machine.

5. 缝纫前的准备 / PREPARATION BEFORE SEWING

5-1. 针和线 / Needle and threads

使用的针线要根据缝纫面料线而异，参照以下表格选择正确的针线。

The needle and threads to be used vary depending on sewing conditions. Select the correct ones by referring to the able below.

针 Needle	线 Thread	
	Upper thread	Lower thread
DRGAN TVX64 #11 #12	80号纺纱 spun yarn #80	80号纺纱 spun yarn #80
#14	60号纺纱 spun yarn #60	60号纺纱 spun yarn #60
#16	50号纺纱 spun yarn #50	50号纺纱 spun yarn #50

5-2. 机针的安装方法 / Installing the needles

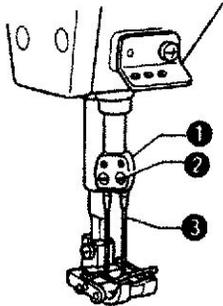
注意 CAUTION



在调整机针时，请先切断电源，当误按起动开关时，缝纫机动作会导致人员受伤。



Turn off the power switch before installing the needle, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury.



1. 转动滑轮直至最高位置。
 2. 放松针固定螺丝，使针有长槽的一面面向前把它们插入针座，旋紧螺丝。
1. Turn the pulley until needle holder ① is raised to the highest position.
 2. Loosen needle set screws ②, hold needles ③ with their long grooved side facing front, insert them into needle holder ① all the way, and fasten the needle with needle set screws ②.

5-3. 下线的安装 / Threading the lower threads

注意 CAUTION



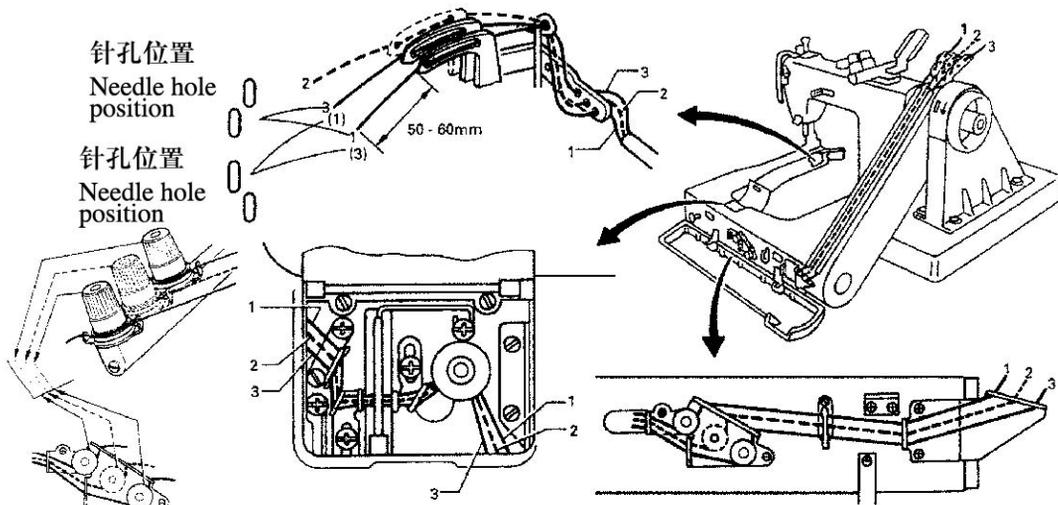
在穿线以前先切断电源，当误按动起动开关时缝纫机动作会导致人员受伤。



Turn off the power switch before threading the upper thread, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury.

按下图穿底线。

Pass the lower threads as shown in the figure below.



5-4. 上线的穿法 / Threading the upper threads

注意 CAUTION



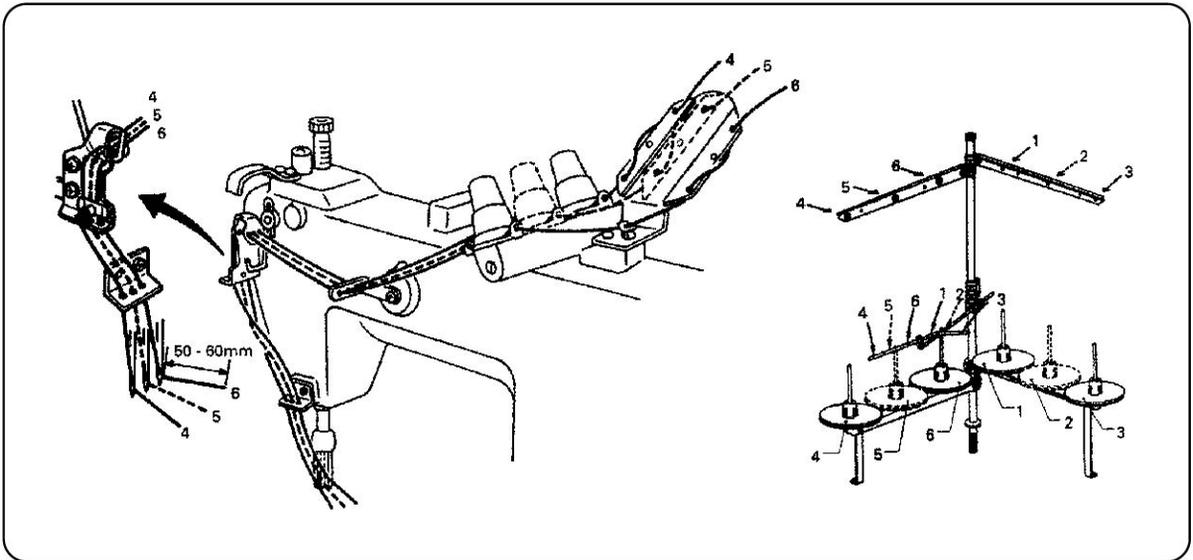
在穿线以前先切断电源，当误按动起动开关时缝纫机动作会导致人员受伤。



Turn off the power switch before threading the upper thread, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury.

按下图穿上位线。

Pass the upper threads as shown in the figure below.



6. 缝纫 / SEWING

注意 CAUTION



•为了安全起见，在使用本缝纫机之前，请安装保护装置。如果未安装这些安全装置就使用缝纫机，会造成人身伤害及缝纫机损坏。

•发生下列情况时，请切断电源。

否则误按动起动开关，缝纫机动作会导致受伤。

· 机针穿线时

· 更换机针或梭芯时

· 缝纫机不使用，或人离开缝纫机时。

• 缝纫过程中，不要触摸任何运动部件或将物件靠在运动部件上，因为这会导致人员受伤或缝纫机损坏。



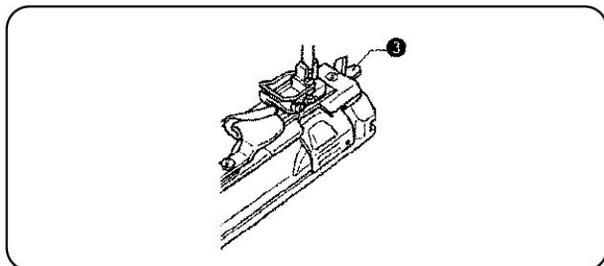
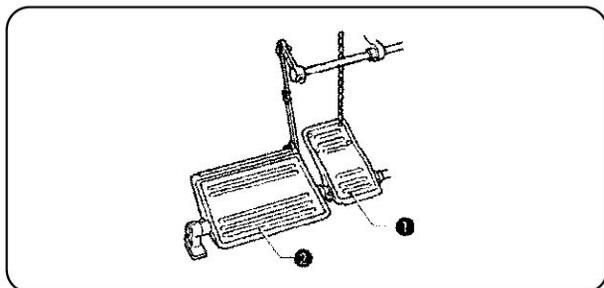
Attach all safety devices before using the sewing machine. If the machine is used without these devices attached, injury may result.

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

1. When threading the needle. 2. When replacing the needle. 3. When not using the machine and when leaving the machine unattended.

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

6-1. 缝纫 / Sewing

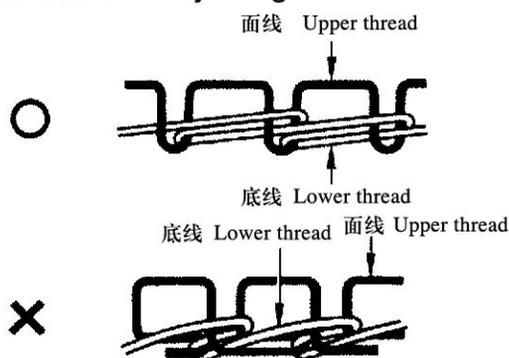


1. 打开电源。
2. 用脚压升降踏板 ①，让技工来完成工作。
3. 放开升降踏板。
4. 当踏下踏板时 ②，机器开始运转。
5. 当工作结束后将线剪断。

1. Switch the power on.
2. Depress presser lifter pedal ① and place the work under the presser foot.
3. Release the presser lifter pedal.
4. The machine starts running when treadle ② is stepped down.
5. After sewing the work, move the work to thread cutter ③ to make blank stitches, and cut the thread with it.

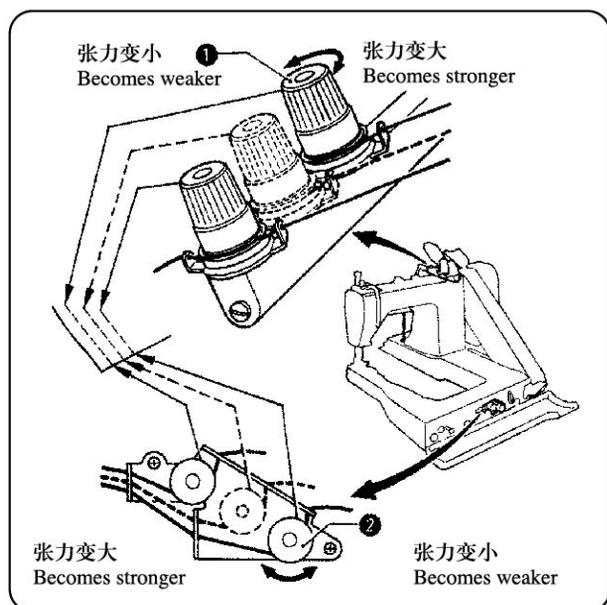
7. 缝纫效果 / THREAD TENSION

7-1. 调节线张力 / Adjusting the thread tension



好的线迹
Good stitches

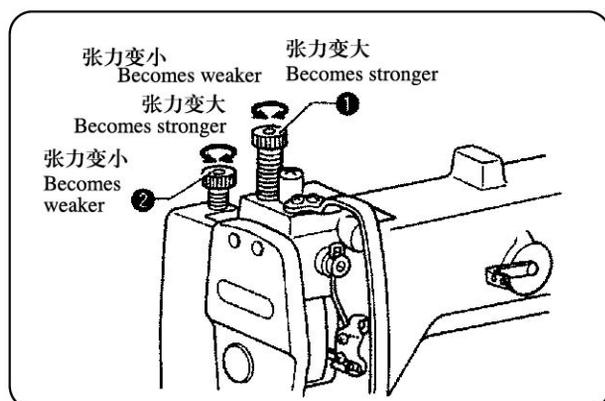
差的线迹
Loose, bad stitches
Apperance of seam when upper thread
tension is too weak
当线夹夹线张力太弱时，就会露出接缝。



1. 通过旋转上部调节螺母 ① 缝地调节上部线的张力。
2. 通过转动底线调节螺母 ② 调节底线的张力。

1. Adjust the upper thread tension properly by turning upper thread adjusting screw ① .
2. Adjust the lower thread tension properly by turning lower thread adjusting screw ② .

7-2. 调节压脚压力 / Presser foot pressure adjustment



通过转动压脚调节螺丝 ① 调节压脚压力，使得压力正好能使布料顺利滑动。对于用电机带动的机器，可以通过转动压脚调节螺丝 ② 来合适地调整牵引压力。

Adjust the presser foot pressure by turning presser adjusting screw ① so that the pressure is just enough to feed the work positively and keep the work from slipping.

* In case of Machines with puller the puller pressure can be adjusted as appropriate to the work by turning presser adjusting screw ② .

7-3. 调节针距 / Adjusting the stitch length

! 注意 CAUTION

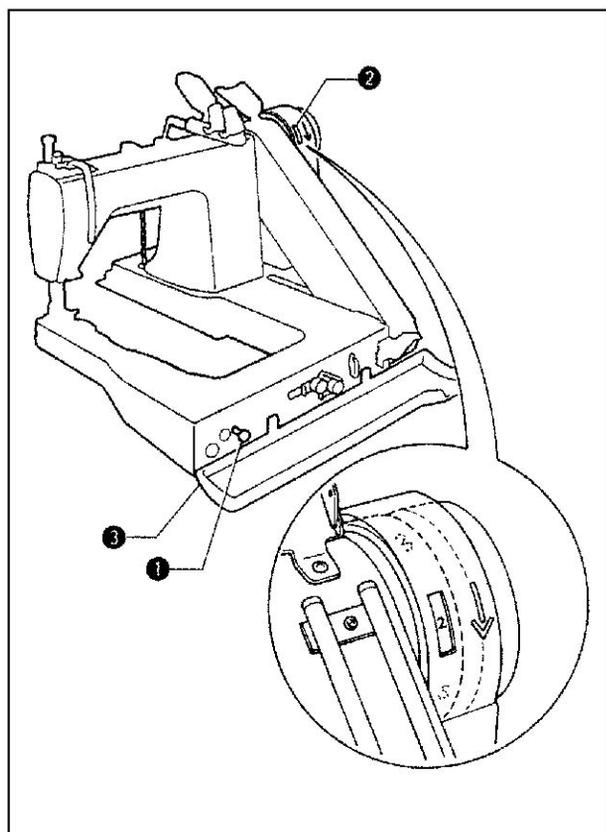


在调节针距以前，请切断电源，当误起功开关时，缝纫机动作会导致人员受伤，然后等电机停止转动后才可以工作。



Turn off the power supply before adjusting the stitch length, otherwise the machine will operate if the treadle is pressed by mistake, which could result in injury.

However, the motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work.



机器滑轮上的数字表示缝距但实际缝距则根据使用材料的类型和厚度而异，数值越高则缝距越大。放开调节按钮(检查调节按钮，使其调回)。

1. 打开前盖 ③。
2. 在压下调节按钮 ① 时，慢慢朝自己转动滑轮，调节按钮 ② 会向里运动。
3. 继续压住调节按钮，继续轻动滑轮直至所需的数字出现在滑轮盖窗口的中心。
4. 关掉前盖 ③。

说明:

不要在机器运转时压调节按钮 ①，因为这样可能严重损害机器零件，当用接近最大长度的缝制时，需要根据所用的线料类型来调节针距。

The numerals on the machine pulley scale represent the stitch length (mm), however the actual stitch length will vary depending on the type and thickness of material being used.

1. Open the front cover ③ .
2. While pressing the feed adjustment button ① , turn the machine pulley toward you slowly. (The feed adjustment button ① will move further inward.)
3. While still pressing the feed adjustment button ① , keep turning the machine pulley until the desired numeral appears in the center of the pulley cover

windows ② .

The higher the value of the numeral, the larger the stitch length becomes. Release the feed adjustment button ①. (Check that the feed adjustment button ① pops back out again.)

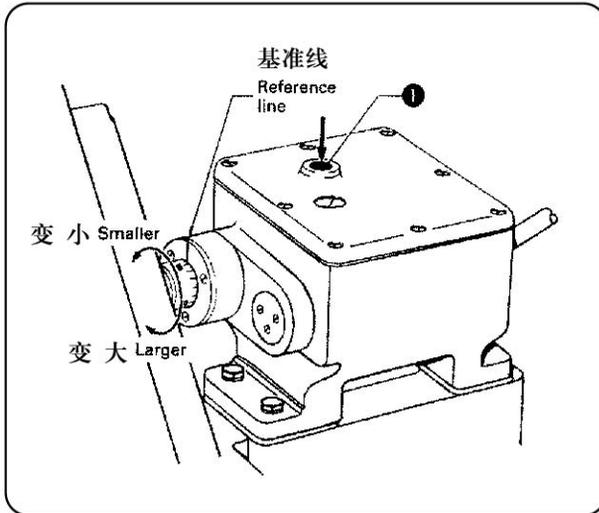
4. Close the front cover ③ .

NOTE:

Do not press the feed adjustment button ① while the machine is operating, as doing so may damage the machine parts.

When sewing with the stith length set close to the maximum length, you will need to adjust the needle guard in accordance with the type of material and the type of thread being used.

7-4. 调节滑轮 / Puller feed adjustment (Machines with puller)



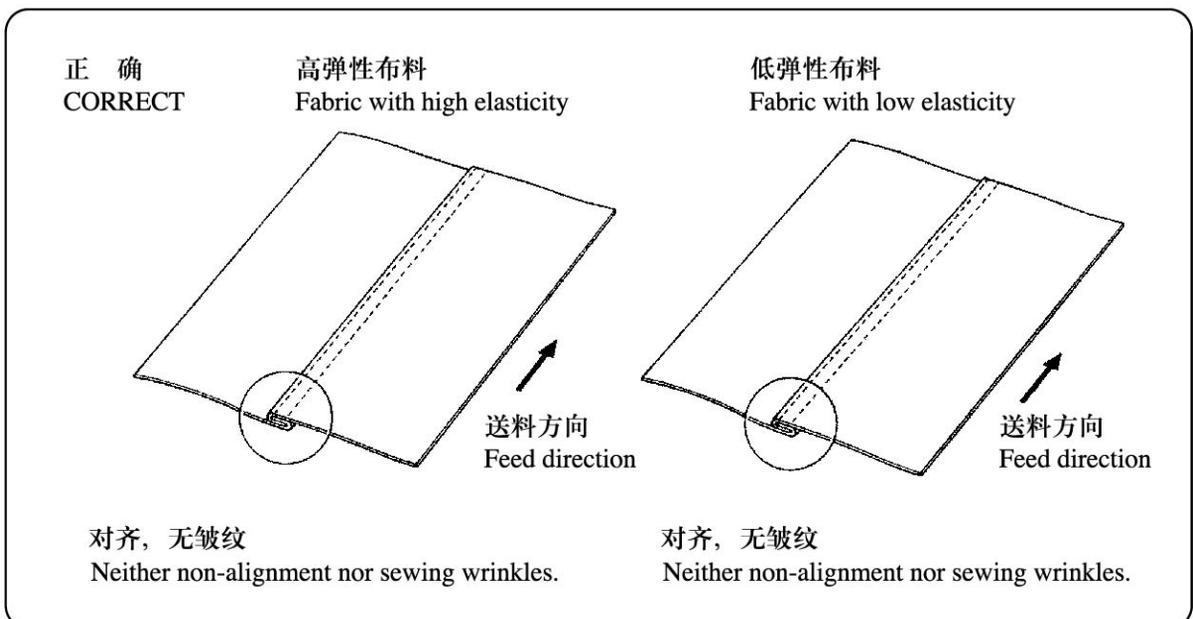
1. 用手指轻压调节按钮 ①，同时朝自己转动滑轮，直至调节按钮更进一步。
2. 继续压住调节按钮，转动滑轮直至所需的参考线上的位置，滑轮朝自己转得越多缝制就越小。
*根据14页，在看过所形成的线迹后再调节牵引装置。

1. With feed adjusting button ① lightly pressed with your finger, turn the pulley toward yourself until feed adjusting button ① goes in one step deeper.
2. Keep pressing feed adjusting button ①, and turn the pulley to set your desired feed position on the scale to the reference line.

The more you turn the pulley toward yourself, the smaller will be the feed.

*Adjust the puller feed after seeing the finished stitches of the work (Refer to page 14).

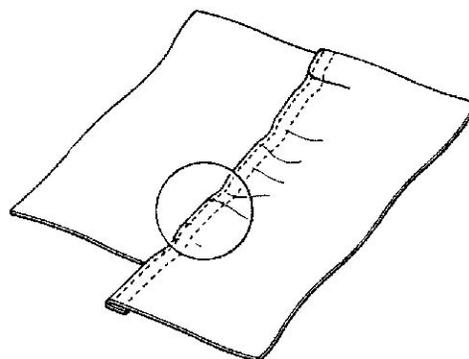
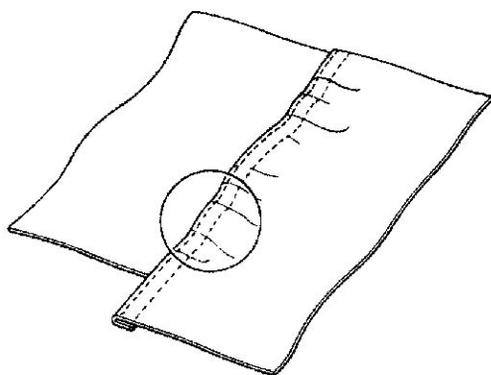
* The table below shows samples of stitches made with a highly elastic fabric and a fabric which is not so elastic. Adjust the puller feed by referring to this table



不充分
INSUFFICIENT

高弹性布料
Fabric with high elasticity

低弹性布料
Fabric with low elasticity



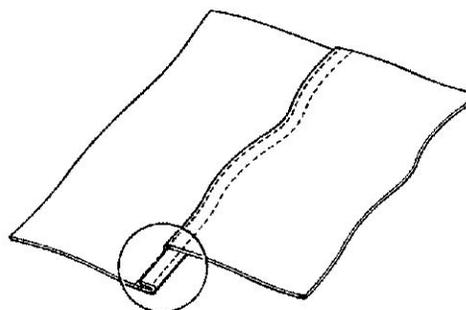
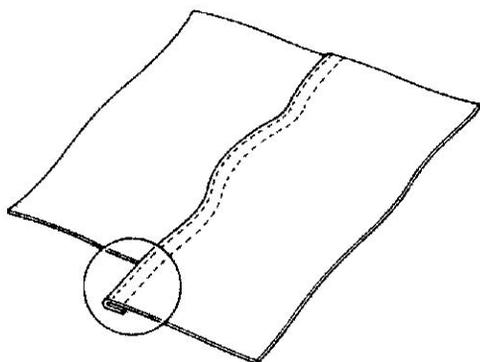
不整齐所有产生皱纹
Non-aligned, and wrinkled.

不整齐所有产生皱纹
Non-aligned, and wrinkled.

过度
EXCESSIVE

高弹性布料
Fabric with high elasticity

低弹性布料
Fabric with low elasticity



不整齐，波浪型明显
Non-aligned, and very wavy.

不整齐，波浪型明显
Non-aligned, and very wavy.

8. 保养 / CLEANING

为了保持缝纫机的机能，而且能长久的使用，请每天保养。

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



注意 CAUTION



在开始清洁作业前，请切断电源。如果当误按动起动开关时，缝纫机动作会导致人员受伤。

使用润滑油和黄油时，务必戴好保护眼镜和保护手套等，以防润滑油落入眼中或沾在皮肤上，这是引起发炎的原因。

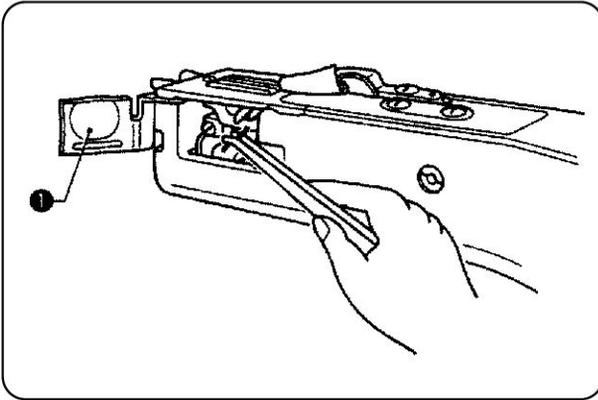
另外，润滑油或黄油不能饮用，否者会引起呕吐和腹泻。将油放在小孩拿不到的地方，缝纫机头倒下或竖起时，请用双手进行操作。单手操作时因缝纫机的重量万一滑落易导致受作。

为了保持缝纫机的机能，而且能长久的使用，请每天保养。另外，缝如果才时间未使用，请在进行了如下的保养后再使用。



Turn off the power switch before carrying out cleaning. The motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work. The machine may operate if the treadle is pressed by mistake, which could result in injury. Be sure to wear protective goggles and gloves when handling the lubricating oil, so that no oil gets into your eyes or onto your skin, otherwise inflammation can result. Furthermore, do not drink the oil under any circumstances, as it can cause vomiting and diarrhoeas. Keep the oil out of the reach of children.

8-1. 清洗 / Daily cleaning



清洗机器

1. 打开绕线侧盖清理线料和其它废物。
2. 清洗完毕后，关上车盘。

润滑根据4~6润滑,第七页

1. 检查线穿的是否正确 (参照第10页)。
2. 若针尖断了要换掉。
3. 试缝。

Cleaning the machine

1. Open the looper side plate ❶ and clean away any thread scraps and other rubbish.
2. After cleaning, close the looper side plate ❶.

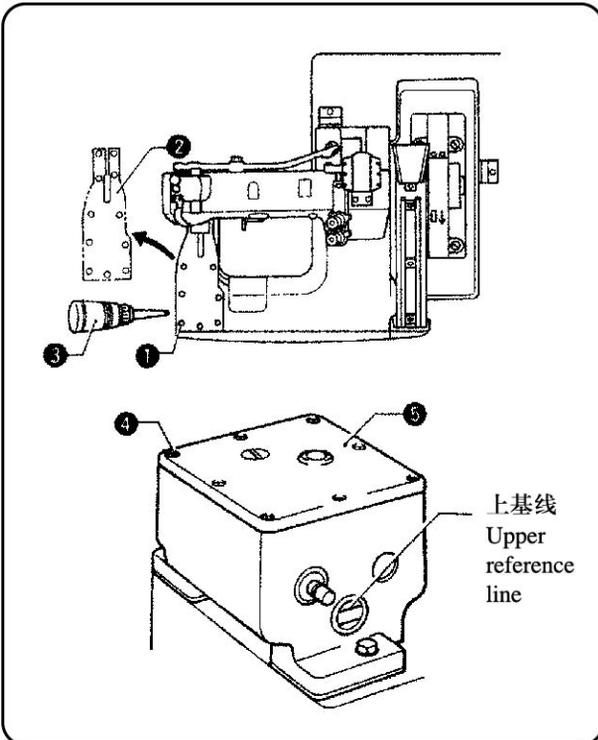
Lubrication

Refer to "4-6. Lubrication on page 7.

Checking

1. Check that the threads are threaded correctly. (Refer to page 10.)
2. If the tips of the needles are broken, replace the broken needles.
3. Carry out a trial sewing.

8-2. 更换润滑油(每三个月) / Changing the lubricating oil (every three months)



润滑油至少每3月换1次。旋开螺丝之后打开前盖把机器里所有的润滑油都倒入油瓶中，给机器加油直至油量线达到油箱上各参照线之间(参里第7页) 关上前臂盖，用11螺丝固定住。

1. 松开螺丝，然后打开顶部盖。
2. 把机器里所有的润滑油都倒入油瓶中。
3. 往里加油直至油量达到油箱上参照线(参第七)。
4. 关上顶部盖用螺丝固定住。

The lubricating oil should be changed at least once every three months.

1. Remove the 11 screws ❶, and then open the forward feed arm cover ❷.
2. Draw up all of the lubricating oil inside the machine into the oil bottle ❸.
3. Fill the machine with oil until the oil level reaches the point in between the reference lines on the oil gauge. (Refer to page 7.)
4. Close the forward feed arm cover ❷ and secure it with the 11 screws ❶.

[Machine with puller]

1. Remove the eight screws ④, and then open the puller top cover ⑤.
2. Draw up all of the lubricating oil inside the machine into the oil bottle ③.
3. Fill the machine with oil until the oil level reaches the top reference line on the oil gauge. (Refer to page 7.)
4. Close the puller top cover ⑤ and secure it with the eight screws ④.

9. 标准调节 / STANDARD ADJUSTMENTS

! 注意 CAUTION



只能由专业的服务人员来维护和检修叫一些重工的经销商或受过专业培训的技术员进行检修。

在进行检修时,请先切断电源,因为误按到开关,机子的运动会使人员受伤,马达被关闭后会保持运动一段时间,所以必须等马达完全停止后才能开始检修工作。



当需要维护和检修时,当更换易损件时。如果进行些必须使用电源来调整时请要特别注意安全如果一些安全装置还没有被装上,请将其装回原位并确保其正常使用。



Maintenance and inspection of the sewing machine should only be carried out by qualified personnel. Ask your JUGO dealer or a qualified electrician to carry out any maintenance and inspection of the electrical system.

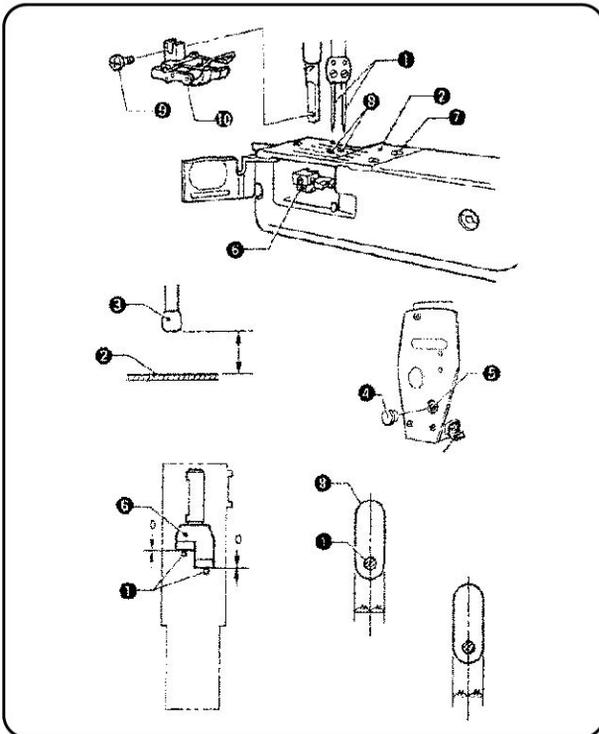


Turn off the power switch and disconnect the power cord from the wall outlet at the following times, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury. However, the motor will keep turning even after the power is switched off as a result of the motor's inertia, Wait until the motor stops fully before starting work. When carrying out inspection, adjustment and maintenance. When replacing consumable parts such as the looper.

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

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.

9-1. 针杆高度的调节 / Needle bar height adjustment



调整针的高度,同时,调整使得每根针都处于针板上的针孔中心拿橡皮塞松开针杆紧螺丝并调整使得针底部和针板距离为11.3mm(对薄料)或10.1mm(对一般原料)。

如果针夹头按上述方式安装针夹抬至最高时,针尖的距离和针板顶部距离会是8.5mm(对于薄料)10.3mm(对于中等厚度的料)。

松开3个螺丝,之后拿开针板。

转动滑轮,使得针和护针排列起来。之后调节针板的斜度使得针左右和护针之间无间隙,用3个螺丝安装好针板,检查务必使得针处于针孔中心,拧紧护针螺丝。

插入橡皮塞,用螺丝安装好压脚。

Adjust the heights of the needles ①.

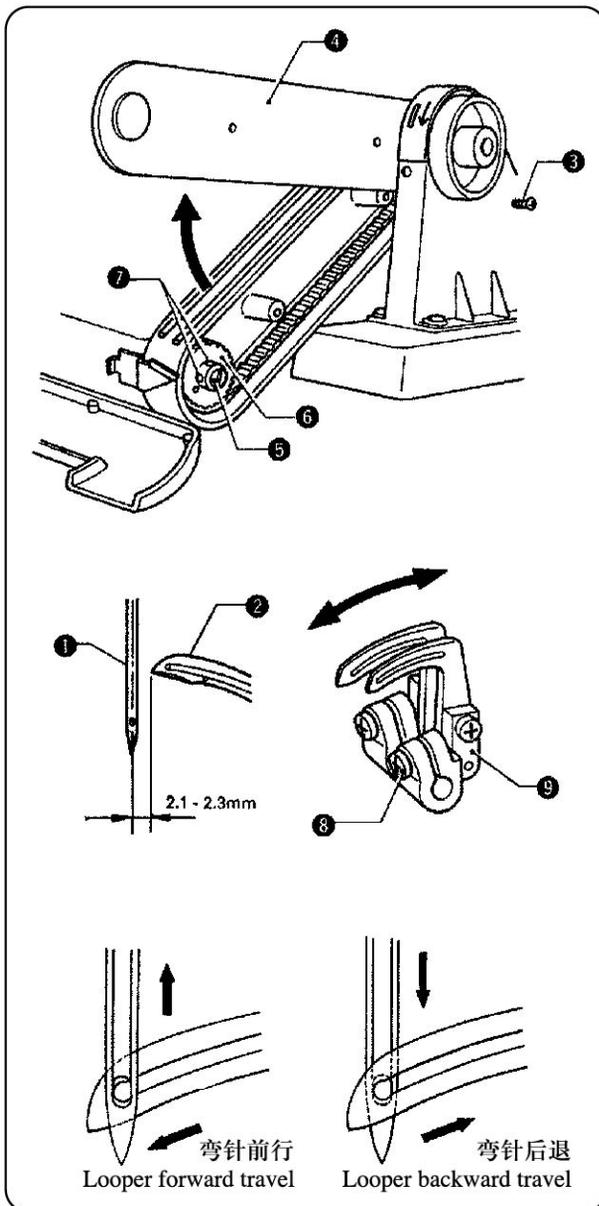
At this time, adjust so that each needle ① is in the center of the needle hole ⑧ in the needle plate ②.

1. Remove the screw ⑨, and then remove the presser foot ⑩.
2. Turn the machine pulley to drop the needle bar to its lowest position.
3. Remove the rubber plug ④, loosen the needle

bar clamp screw ⑤ and adjust so that the distance between the bottom of the needle clamp ③ and the top of the needle bottom of the needle clamp and the top of the needle plate ② is 11.3mm (for thin materials) or 10. *If the needle clamp is set in the way described above, the distance between the points of the needles ① and the top of the needle plate ② will be 8.5mm (for thin materials) or 10.3mm (for medium thick materials) when the needle clamp ③ is raised to its highest position.

4. Remove the three screws ⑦, and then remove the needle plate ②.
5. Turn the machine pulley so that the needle ① and the needle guard ⑥ are aligned, and then adjust the tilt of the needle clamp ③ so that there is no space between the left and right needles ① and the needle guard ⑥ at this time.
Install the needle plate with the three screws ②, and after checking that the needles ⑦ are in the centers ① of the needle holes ⑧, tighten the needle bar clamp screw ⑤.
6. Insert the rubber plug ④.
7. Install the presser foot ⑩ with the screw ⑨.

9-2. 弯针和针的调整 / Needle and looper timing adjustment



调节使得当针最低的时候，弯针处于最后端（右端）从针中心到弯针顶端距离为2.1-2.3mm.

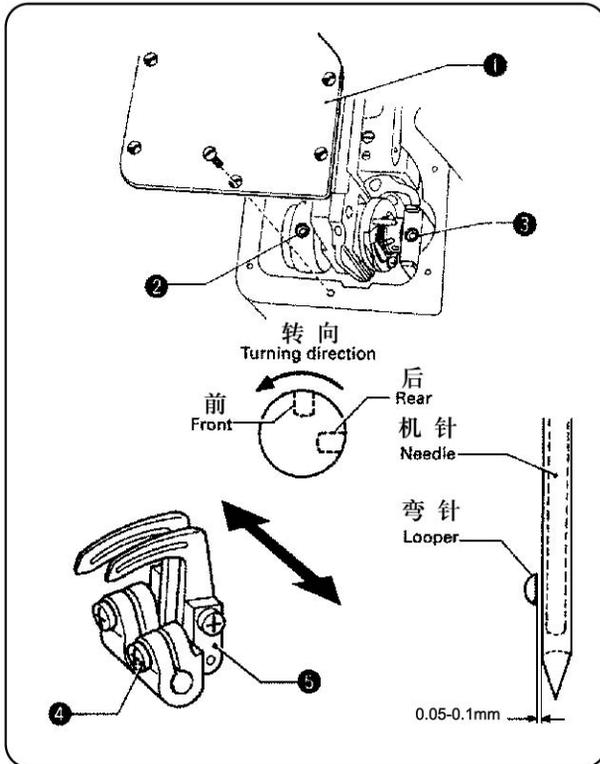
1. 拿掉压脚针板和牙齿。
2. 松开2个螺丝，之后打开皮带盖板。
3. 朝自己的方向转动滑轮直至弯针到达其最后部圈的末端。
4. 松开帽螺钉之后松开下面皮带轮上的2个螺丝。
5. 朝自己的方向转动滑轮，直至针下降至最低位置。
6. 拧紧定位螺丝，再拧紧帽螺钉。
7. 松开螺钉按箭头方向移开弯针直至针中心和弯针面端距离为2.1-2.3mm。
8. 务必使弯针过线孔和针眼在弯针前后圈上都对齐。
9. 关上皮带盖板，之后拧紧2个螺钉。
10. 安上压脚针板和牙齿。

Make an adjustment so that, when needles ① are down lowest loopers ② reach the end of their backward travel and the distance from the needle center to the looper tip is 2.1 to 2.3mm.

1. Remove the presser foot, needle plate and feed dogs (Refer to page 15)
2. Remove the two screws ③, and then open the belt cover plate ④.
3. Turn the pulley toward yourself until loopers ② reach the end of their backward travel.
4. Loosen cap screw ⑤, and then loosen two set screws ⑦ on lower belt wheel ⑥.
5. Turn the pulley toward yourself until needles ① come down to the lowest position.
6. Tighten set screw ⑦, securely, and then tighten cap screw ⑤.

7. loosen set screw ⑧, move looper holder ⑨ in the arrow direction until the distance between the needle center and the looper tip is 2.1 to 2.3mm, and retighten set screw ⑧ securely.
8. Make sure that the looper thread eyes match the needle eyes in the forward and backward travels of the loopers.
9. Close the belt cover plate ④, and then tighten the two screws ③.
10. Install the presser foot, needle plate and feed dogs.

9-3. 调整弯针勾线 / Timing of loopers running clear of needles



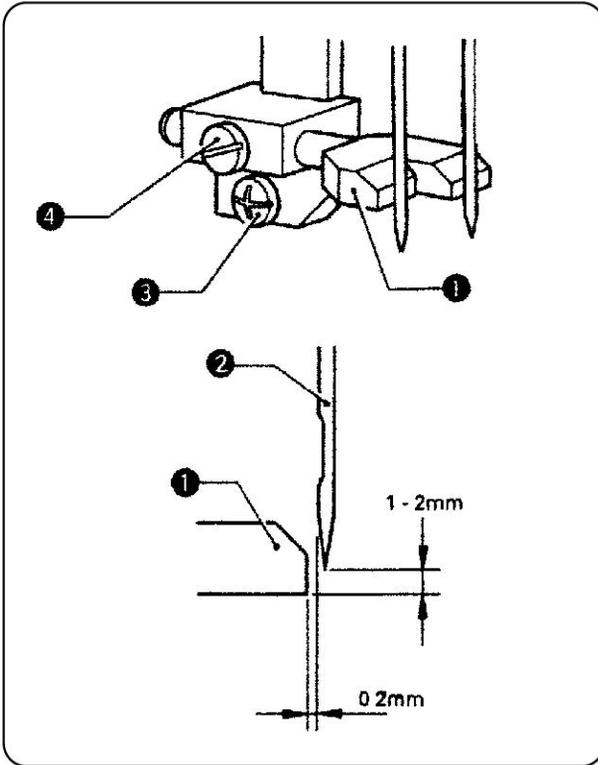
弯针不论向前、向后运转，弯针与机针的间距从0.05mm调至0.1mm。

1. 首先拿掉送料臂盖。
2. 调节前后绕线调速器使得前面与前后凸轮相连的螺钉同螺钉调节孔相一致。当前面的与上下凸轮相连的螺钉向绕线器相一致，而绕线器连接着杆调节孔松开后部与前后凸轮相连的螺钉之后松开前面的则螺钉使得前后凸轮可以调节，结束后拧紧2个螺钉。
3. 松开弯针架螺钉之后按箭头方向移动弯针架进行调节，使得弯针顶端和针中心与二者一致时距离为0.05-0.1mm同时，除了箭头所指示方向不要向其它方向移动弯针如果朝其它方向移动按照9-2进行调节调节针和线线调速器(按17页)。
4. 安上送料臂盖。

The loopers run in back of the needles in their forward travel and in front of the needles in their backward travel. Adjust the clearance between the needles and the loopers to anywhere from 0.05 to 0.1 mm in the forward travel.

1. Remove forward feed arm cover ②.
2. The forward/back looper timing should be adjusted so that the set screw which is at the front relative to the forward/back cam turning direction is aligned with the screw adjustment hole ③ when the set screw which is at the front relative to the up/down cam turning direction is aligned with the looper connecting rod adjustment hole ②.
To adjust, loosen the set screw which is at the rear relative to the forward/back cam turning direction, and then loosen the set screw at the front just enough so that the forward/back cam can be adjusted.
After adjusting, tighten the two set screws.
3. Loosen the looper holder screw ④, and then move the looper holder ⑤ in the direction of the arrow to adjust so that the clearance between the tip of the looper and the center of the needle is 0.05-0.1mm when the two are aligned.
At this time, do not move the looper holder ⑤ in any direction except the direction indicated by the arrow. If it is moved in another direction, carry out the adjustments given in "9-2. Adjusting the needle and looper timing" on page 16.
4. Install the forward feed arm cover ①.

9-4. 调整护针架 / Needle guard adjustment



当缝距最小且弯针朝针运动时，护针架和针之间的距离应当是0.2mm，应将高度调节至使弯针不断，高度应尽量最低。

1. 将缝距调到最小。
2. 朝自己方转动滑轮使弯针与针中心平行。
3. 松开螺钉③之后调高或降低针护架，使得从护针架底部到针尖距离为1-2mm。
4. 拧紧螺钉。
5. 松开螺钉④之后向左或右移动护针架进行调节使得针护和针之间的距离为0.26mm。
6. 拧紧螺钉。

说明：

对一些料、线如果缝距调至实际缝距时可以得到最好效果。

[For movable needle guard]

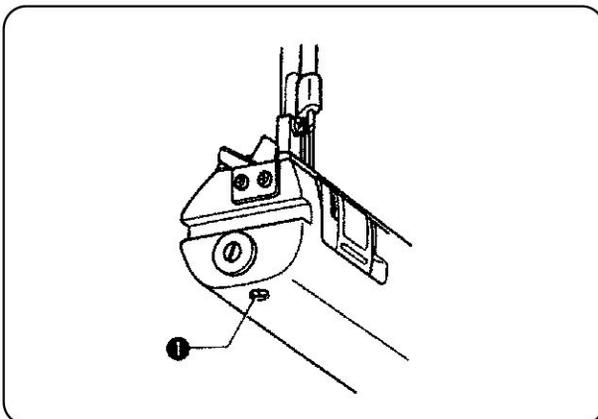
The clearance between the needle guard ① and the needles ② should be 0.2 mm when the stitch length is at the minimum setting and the loopers are moving toward the needles.

The heights should be adjusted to as low a setting as possible without the loopers breaking.

1. Adjust the stitch length to the minimum setting. (Refer to page 12.)
2. Turn the machine pulley toward yourself to align the loopers with the centers of the needles.
3. Loosen the set screw ③, and then raise or lower the needle guard ① so that the distance from the bottom of the needle guard ① to the points of the needles is 1-2 mm.
4. Tighten the set screw ③.
5. Loosen the set screw ④, and then move the needle guard ① to the left or right to adjust so that the clearance between the needle guard ① and the needles is 0.2 mm.
6. Tighten the set screw ④.

NOTE:

For some materials and threads, the best results can be obtained if the needle guard and the needle are touching slightly when the stitch length is adjusted to the actual stitch length.

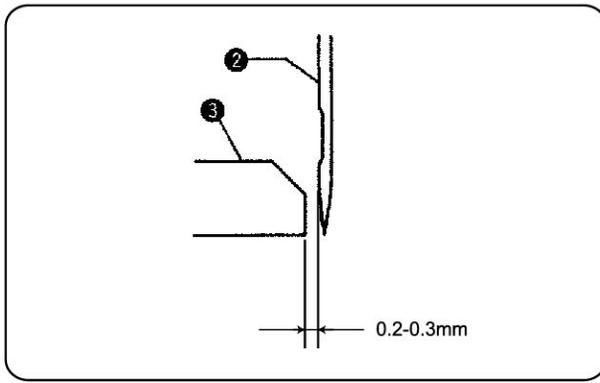


护针架使得针不与弯针在前圈接触，尽可能地使护针架接近针，但不能相互碰到。

1. 朝自己轻动滑轮直至针至最低位。
2. 松开护针支架螺钉。
3. 调节针和护针架之间的距离，通过移动护针架将其调至0.2-0.3mm。
4. 调节完后重新拧紧螺钉。

[For fixed needle guard]

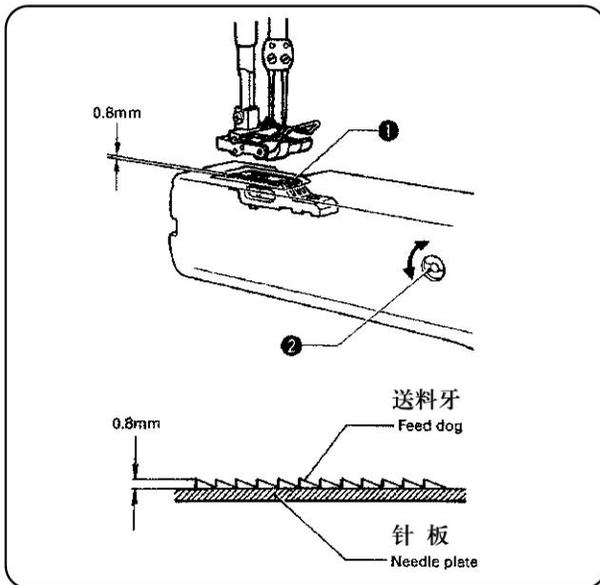
The needle guard prevents the needles from contacting the loopers in their forward travel. Position the needle guard as close to the needles as possible but



make sure that it is clear of the needles.

1. Turn the pulley toward yourself until the needles come down to the lowest position.
2. Loosen lower set screw ① at the end of the forward feed arm.
3. Adjust the clearance between needles ② and needle guard ③ to anywhere from 0.2 to 0.3 mm by moving needle guard ③.
4. After the adjustment, retighten set screw ① securely.

9-5. 送料牙的高度调节 / Feed dog height adjustment

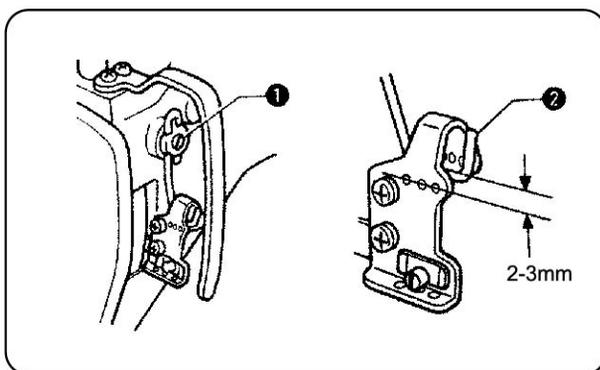


调节送料齿高度使得当送料齿处于最高处时，与针板顶部相距0.8mm。转动送料杆偏心轴来调节送料齿的高度。

Adjust the height of feed dog ① so it is 0.8 mm above the top of the needle plate when feed dog ① is at the highest position.

Adjust the height of feed dog ① by turning feed bar eccentric shaft ②.

9-6. 上过线的调节 / Upper thread take-up thread guide adjustment



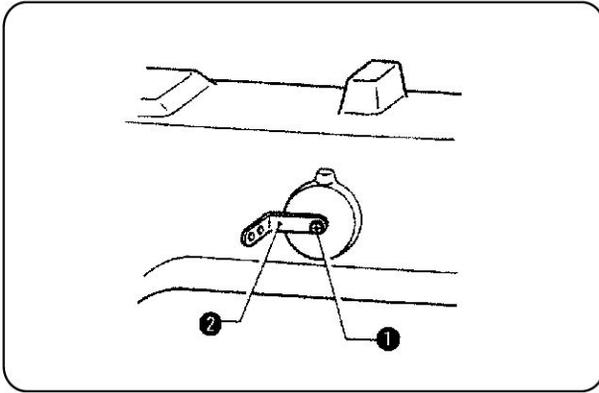
调节上紧线器孔的中心和引线器的顶部距离为2-3mm。

1. 朝自己轻动滑轮直至针杆处于最低位。
2. 松开螺钉之后上下调节上紧线器使得从紧线器至紧线器孔距离为2-3mm上紧线器越高面线圈越大。
3. 拧紧螺钉。

Adjust the distance between the center of the upper thread take-up and the top of the thread guide will be 2~3mm.

1. Turn the pulley toward yourself until the needle bar is down at the lowest position.
 2. Loosen the screw ①, and then move the upper thread take-up thread guide ② up or down to adjust so that the distance from the top of the upper thread take-up thread guide ② to the center of the upper thread take-up hole is 2-3 mm.
- * The higher the upper thread take-up thread guide ②, the greater will be the upper thread loops.
3. Tighten the screw ①.

9-7. 上线引导器的调节 / Upper thread arm thread guide adjustment



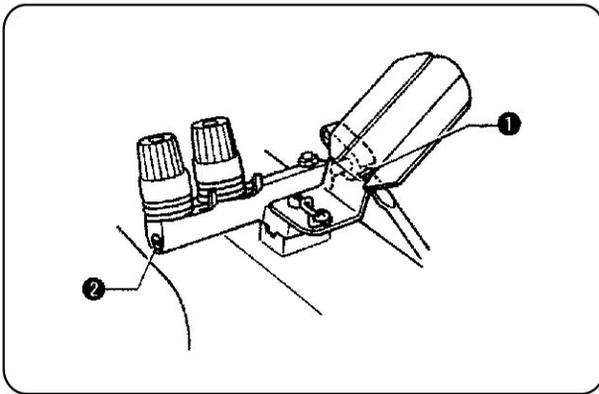
调节上线引导器使得上线当绕线器转完线圈时，有少许张力。

1. 松开螺钉，之后调节使得上线引导器几乎水平。
2. 调节完后，拧紧螺钉。

Adjust the upper thread arm thread guide so that the upper thread has a slight tension when the loopers run out of upper thread loops.

1. Loosen the screw ①, and then adjust so that the upper thread arm thread guide ② is nearly horizontal.
2. After the adjustment, retighten the screw ①.

9-8. 松线杆的调节 / Thread release shaft adjustment



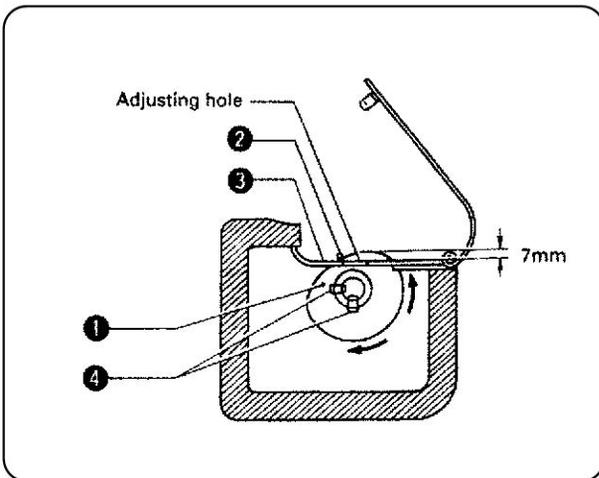
调节松线杆使得当压脚上升时，线张力小；压脚下降时，线张力大。

1. 松开帽螺钉。
2. 转动松线杆调节使得当压脚比针板顶部高4mm时线开始松弛。
3. 调整后拧紧螺丝。

Adjust the thread release shaft so that the thread tension discs loosen when the presser foot is raised and tighten when the presser foot is lowered.

1. Loosen set screw ①.
2. Make an adjustment by turning thread release shaft ② so that the thread tension discs begin to loosen when the presser foot rises 4mm above the top of the needle plate.
3. After the adjustment, retighten set screw ① securely.

9-9. 底线打线器的调节 / Lower thread take-up timing adjustment



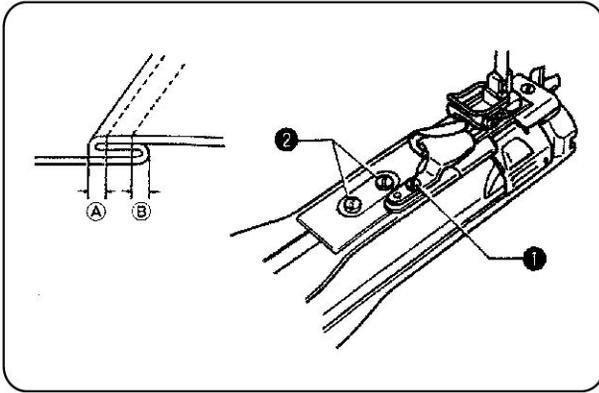
调节使得当绕线器开始向后移动时，低线紧线器与线接触，并比低线紧线器座高7mm。

1. 将螺丝起子插入低线紧线器底座的调节孔松开2个螺钉。
2. 升高底线紧线器直至比其低部高7mm。
3. 调完后拧紧2个帽螺钉。

Make an adjustment so that, when the loopers begin moving backward, lower thread take-up ② contacts thread ②, and is 7 mm up from lower thread take-up base ③.

1. Insert screwdriver through the adjusting hole in the lower thread take-up base, and loosen two set screws ④.
2. Raise lower thread take-up ① until it is 7 mm up from thread take-up base ③.
3. After the adjustment, retighten two set screws ④ securely.

9-10. 引导板的安装 / Installing the lapper



从前面将引导板插入送料臂盖前部椭圆形槽中，使得其末端与压脚留有空隙。松开帽螺钉调节下降距离点A，松开帽螺钉调节下降距离点B。调完后，重新拧紧帽螺钉。

Insert the lapper guide plate from the front into the oval slot in the forward feed arm cover, making sure that the end of lapper is clear of the presser foot.

■ Lapper adjustment

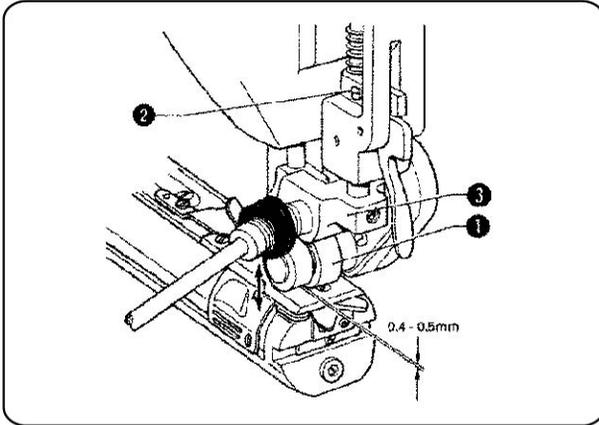
Adjust feeling distance of point **A** by loosening set screw **1**.

After the adjustment, retighten set screw **1**.

Adjust feeling distance of point **B** by loosening set screw **2**.

After the adjustment, retighten set screws **2**.

9-11. 滑轮的调节 / Puller height adjustment (Machines with puller)



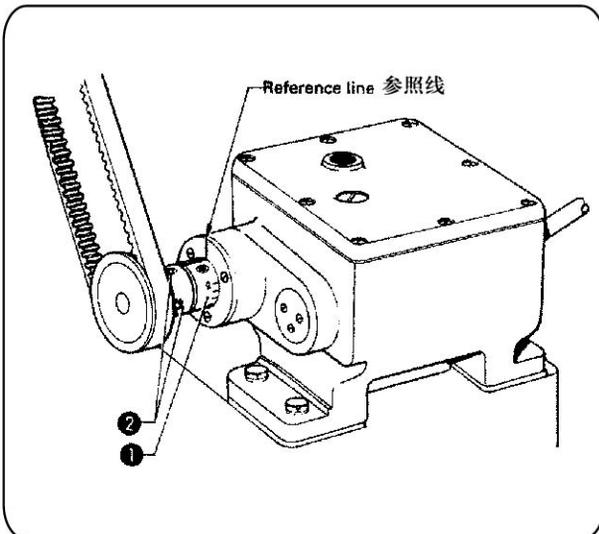
调节滑轮高度使得从针板顶部的距离为0.4至0.5 mm。松开螺钉上下移动滑轮支架直至滑轮比针板顶部高0.4mm到0.5mm调完后重新拧紧螺钉。

Adjust the height of puller **1** so that it is 0.4 to 0.5 mm high from the top of the needle plate.

Loosen set screw **2**, and move puller support **3** up or down until puller **1** is 0.4 to 0.5mm above the top of the needle plate.

After the adjustment, retighten set screw **2**.

9-12. 调速器的调节 / Puller timing adjustment (Machines with puller)



调节当针杆处于最低位时调速器上的标记处于参照线内：

1. 朝自己转动滑轮直至调速器上的标记处于参照线内。

2. 松开帽螺钉朝自己转动滑轮直至针杆一直下调。

3. 重新拧紧帽螺钉。

Make an adjust so that, when the needle bar is down at the lowest position, the mark on timing collar **1** is in line with the reference line.

1. Turn the pulley toward yourself until the mark on timing collar **1** meets the reference line.

2. Loosen two set screws **2**, and turn the pulley toward yourself until the needle bar is lowered all the way down.

3. Retighten set screws **2**.

10. 故障维修 / TROUBLESHOOTING

*请在你要求维修和服务前先检查以下几点。

*如果以下方法仍然不能解决问题关闭电源开关,向受过培训的技术人员经销商咨询。

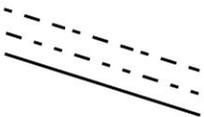
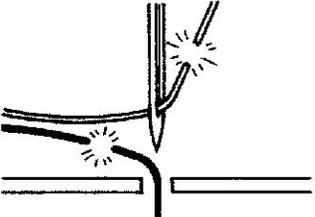


注意



在检查以前请先切断电源缝纫机的动作会导致人员受伤。

然后必须等电机停机转动以后,才能进行检查工作。

问 题	可能的原因	页
1. 上线不紧	上线张力太小或是下线张力太大。 调节上线张力或下线张力。 上紧线器位置不正确吗?	
2. 当缝纫时, 有跳线迹。 	针安装是否合适? 正确调节上紧线器 若不正解则正确安装 绕线点迟缓? 用好的更换针和绕线调速器是否正确? 调节针和绕线调速器 针和弯针空隙不合适?	
3. 缝位不正确 (带滑轮机器)	底线调速器不正确? 调节滑轮调速器不正确? 调节滑轮送料器不正确? 压脚压力不正确? 调节压脚压力。 送料齿高度不正确?	
4. 机器无法送料	机器无法送料, 送料齿太低? 调高。 压脚压力太小? 增加压力。 送料齿磨损, 让维修工检查一下。 压脚浮动不能安全工作? 让维修工检查一下。 送料齿和压脚只有有一个工作。	
5. 上线或下线断裂 	针弯了或针尖断了? 若是则换针。 针安装是否合适? 若不合适则正确安装。 线穿的合适吗? 若不合适则正确穿线。 上线下线张力太弱或太强, 调节上线或下线张力。 松线杆位置合适吗? 调节。 针眼对线的太小吗? 参照针线选择。 绕线器损坏? 更换。	

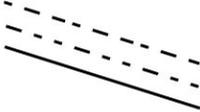
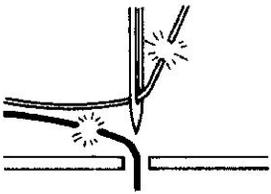
- Please check the following points before colling for repairs or service.
- If the following suggestion do not solve the problem, turn off the machine power supply and contace your nearest Brother service center.



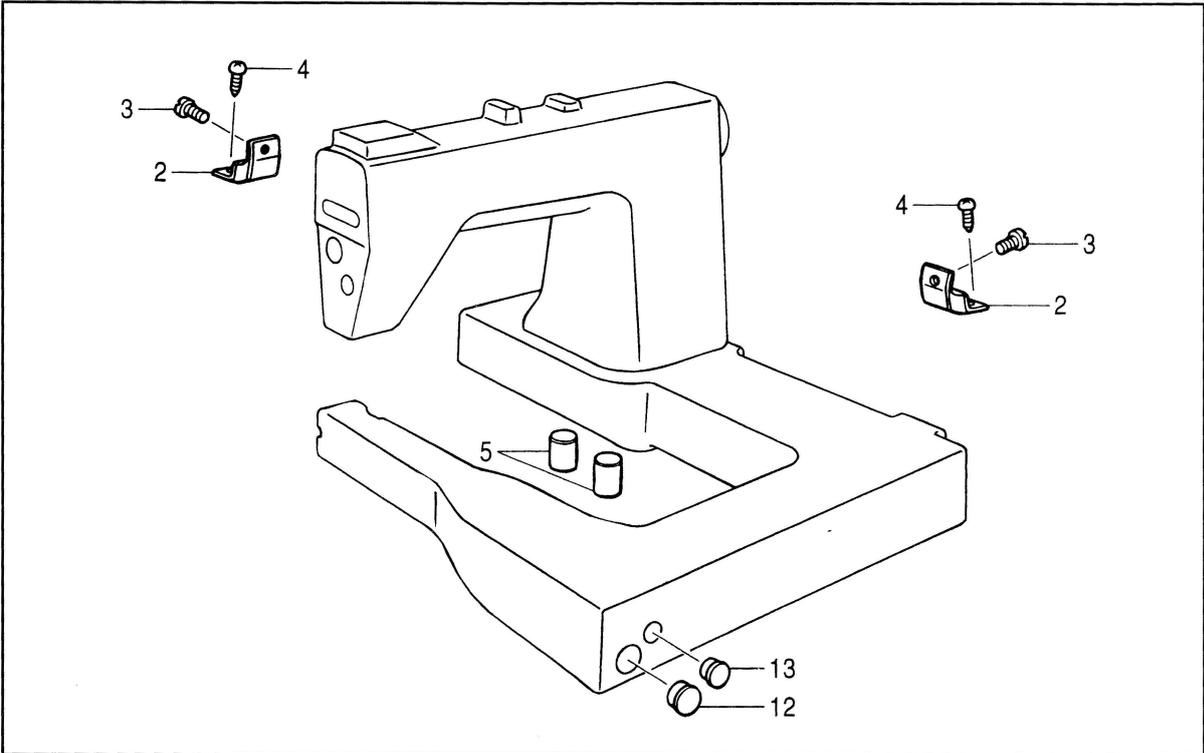
CAUTION



Turn off the power supply before adjusting the stitch length, otherwise the machine will operate if the treadle is pressed by mistake, which could result in injury.
However, the motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work.

PROBLEM	POSSIBLE CAUSE	PAGE
1. Uper thread is not tight.	<ul style="list-style-type: none"> • Is the upper thread tension too weak, or is the lower thread tension too strong? Adjust the upper thread tension or lower thread tension. • Is the position of the upper thread take-up thread guide incorrect? Adjust the upper thread take-up thread guide position correctly. 	
2. Skipped stitches occur while sewing. 	<ul style="list-style-type: none"> • Is the needle properly installed? If it is incorrect, install the needle correctly. • Are the looper points dull? Replace looper with good ones. • Is the needle and looper timing incorrect? Adjust the needle and looper timing correctly. • Is the clearance between needles and loopers incorrect? Adjust the clearance between needles and loopers correctly. • Is the lower thread take-up timing incorrect? Adjust the lower thread take-up timing correctly. 	
3. Seam position is incorrect. (Machines with puller)	<ul style="list-style-type: none"> • Is the puller timing incorrect? Adjust the puller timing. • Is the puller feed incorrect? Adjust the puller feed. • Is the presser foot pressure incorrect? Adjust the presser foor pressure. • Is the feed dog height incorrect? Adjust the feed dog height. 	
4. Machine does not feed work.	<ul style="list-style-type: none"> • Is the feed dog too low? Adjust the feed dog height. • Is the presser foot pressure too small? Adjust the presser foot pressure. • Is the feed dog worn out? Have serviceman check it. • Presser foot floats and does not fully press work. Have serviveman check it. • Feed dog and presser foot work on one side only. 	
5. Upper and lower threads are breaking. 	<ul style="list-style-type: none"> • Is the needle bent or is the needle tip broken? Replace the needle if it is bent or broken. • Is the needle properly installed? If it is incorrect, install the needle correctly. • Is the needle properly threaded? If it is incorrect thread the needle correctly. • Is the upper or lower thread tension too weak or too strong? Adjust the upper thread or lower thread tension. • Is the thread release shaft position incorrect? Adjust the thread release shaft position correctly. • Are the needle eyes too small for threads? Refer to the section on "Needles and threads". • Are the loopers damaged? Replace loopers with good ones. 	

A. 主体部件 / Machine body

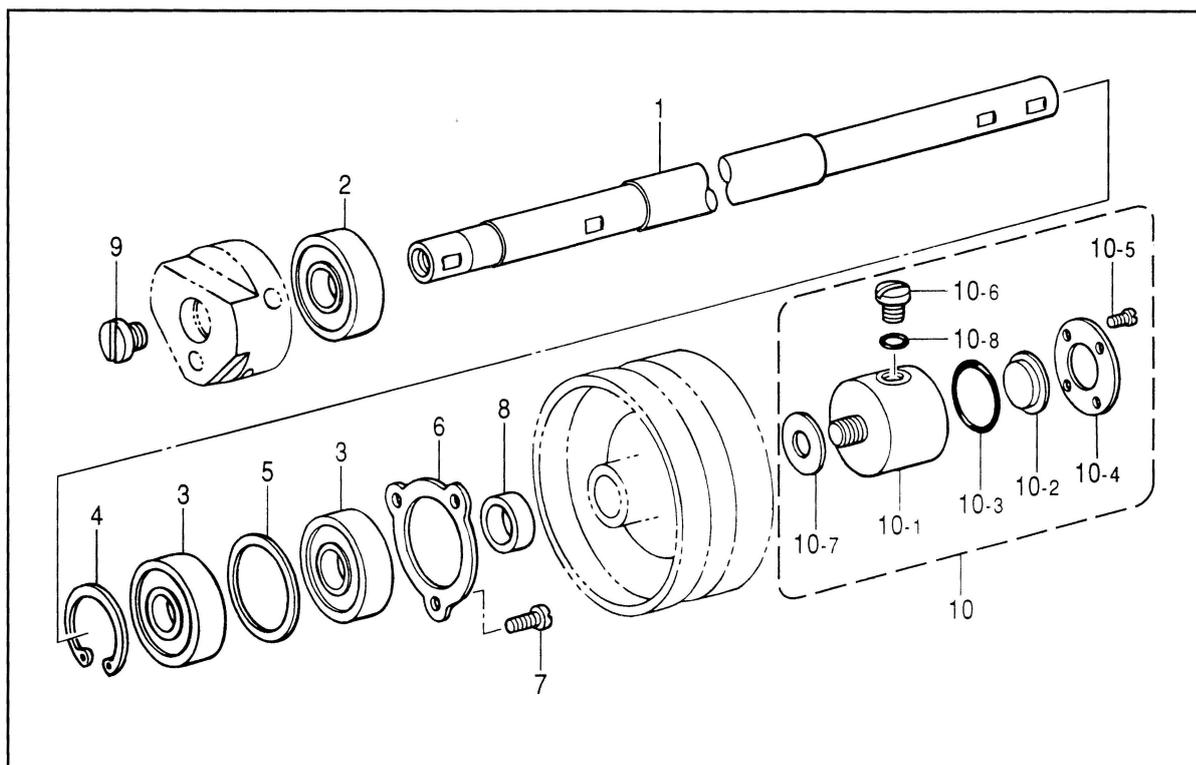


118-927-050

A、机壳部件

序号	图号	件号	名称	件数	同类产品编号	Name of parts
1	JK-T9270-A02	40612001	底座固定板	2	105337001	Cushion assy
2	JK-T9270-A03	201S11029	螺钉, SM6. 35	2	105146001	Screw , SM6. 35
3	JK-T9270-A04	406S30001	木螺钉M6. 2X25	2	0B0622502	Wood screw, round, M6. 2×2. 5
5	JK-T9270-A04-02	40603001	垫套	2	-----	Matress Protector
6	JK-T9270-A04-03	40622001	橡胶垫	4	-----	Rubber pad
7	JK-T9270-A05	40622002	防震垫	2	105341051	Base cushion
8	JK-T9270-A12	20911003	油 窗	1	150697001	Oil gauge window
9	JK-T9270-A12	20922003	油窗套	1	-----	Oil gauge window bush
10	JK-T9270-A13	40622003	油封	1	104449009	Oil line
11	JK-T9270-A14	40623003	回油线	1	-----	Oil line

B. 上轴部件 / Upper shaft mechanism

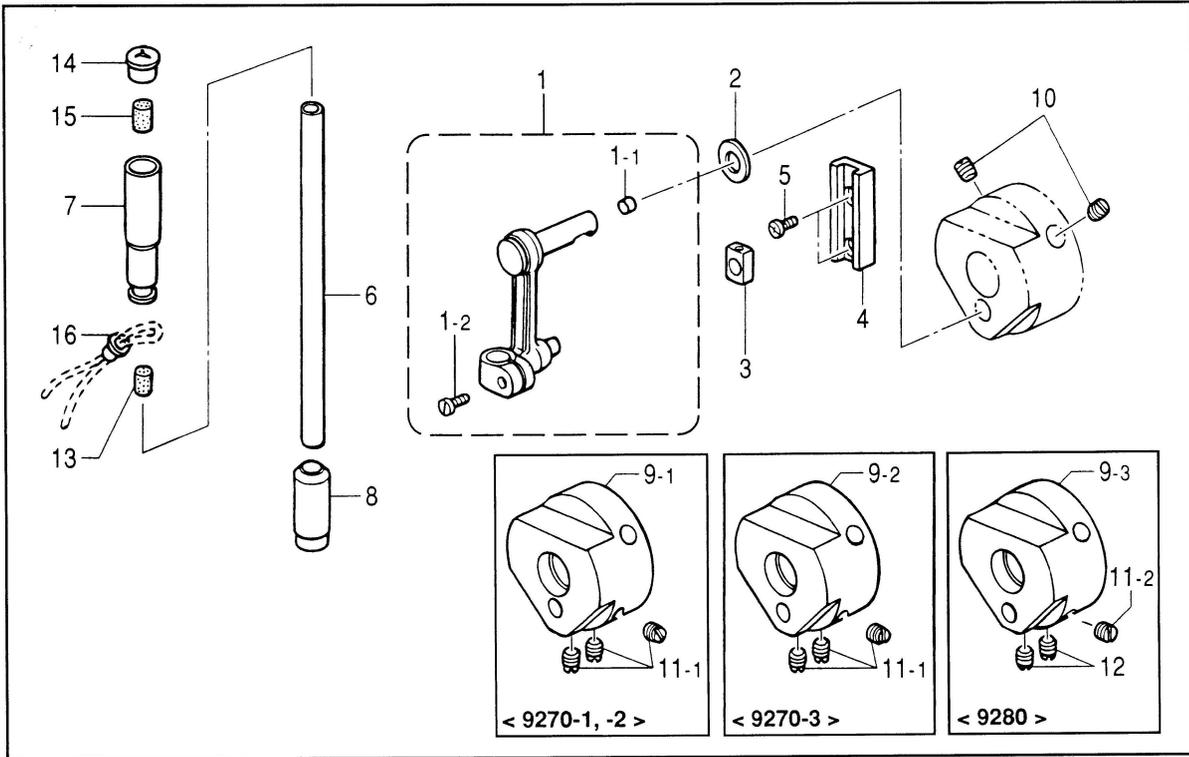


118-927-109

B、上轴部件

序号	图号	件号	名称	件数	同类产品编号	Name of parts
1	JK-T9270-B01	40602001	上轴	1	S40314001	Upper shaft
2	JK-T9270-B02	B04002	轴承, 6302ZZ	1	076302850	Ball bearing, 6302ZZ
3	JK-T9270-B03	B06001	轴承6302VV	2	072630260	Ball bearing, 6303VV
4	JK-T9270-B04	H01004	卡簧42	1	048420242	Retaining ring, C42
5	JK-T9270-B05	40128004	垫片	1	S40315051	Brearing spacer
6	JK-T9270-B06	40612002	轴承盖	1	S40316051	Brearing presser
7	JK-T9270-B07	115S11010	螺钉SM4.76-32X10	3	062711012	Screw, SM4.76-32×10
8	JK-T9270-B08	40608001	轴环	1	S40318051	Upper shaft collar
9	JK-T9270-B09	301S11015	螺钉	1	S40317001	Screw SM9.53
10	JK-T9270-B10	4060100100	上轮油盒组件	1	S40812001	Oil tank assy
11	JK-T9270-B10-01	40601001	油盒	1	S40383001	Oil tank
12	JK-T9270-B10-02	40611001	油窗	1	104547001	Oil gauge window
13	JK-T9270-B10-03	10122019	O型圈	1	081014670	O ring pw 14
14	JK-T9270-B10-04	40612003	油窗盖	1	151074009	Oil gauge cover
15	JK-T9270-B10-05	101S11005	螺钉	4	100257010	Screw ,SM3.57
16	JK-T9270-B10-06	406S11001	加油螺钉	1	111193001	Oil feeding pipe cap
17	JK-T9270-B10-07	40622004	垫片	1	105071001	Oil tank packing
18	JK-T9270-B10-08	10122010	O型圈	1	111194001	O ring

C. 针杆部件 / Needle bar mechanism

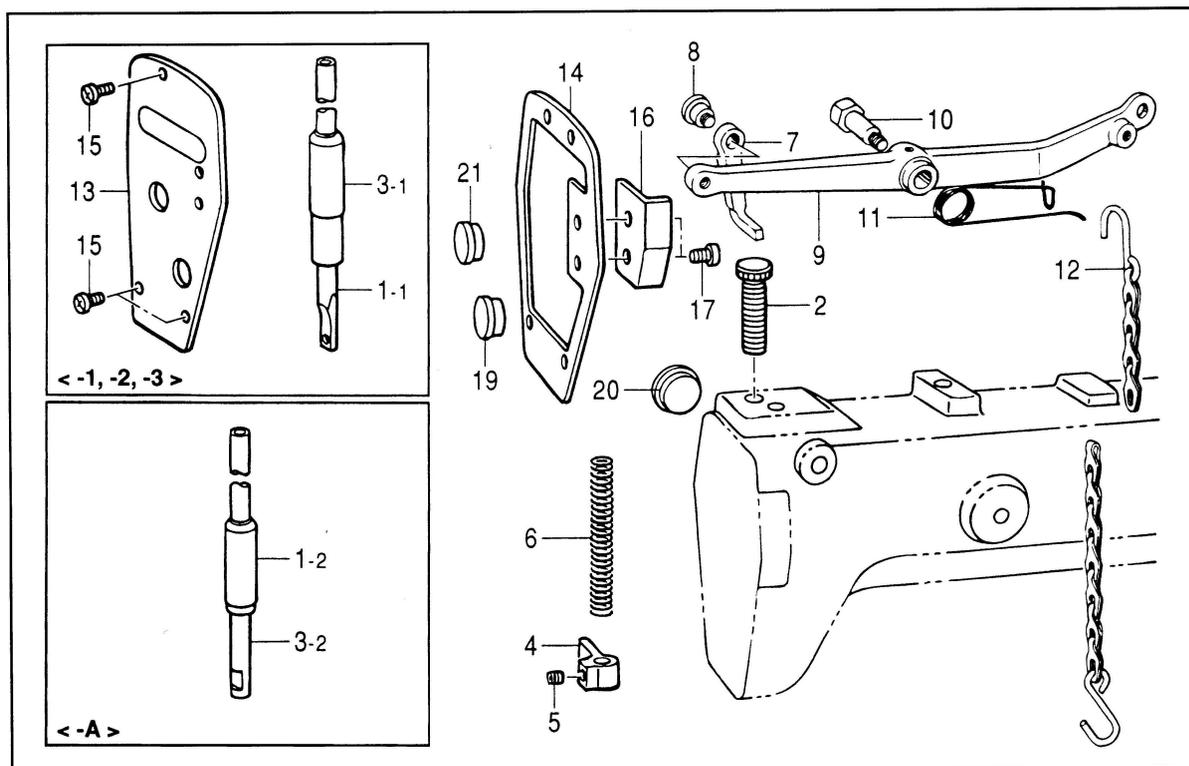


118-927-118

C、针棒部件

序号	图号	件号	名称	件数	同类产品编号	Name of parts
1	JK-T9270-C01	4060500100	针杆连杆组件	1	S40268001	Thread take-up lever assy
2	JK-T9270-C01-01	40622005	防震橡胶垫	1	142274009	Rubber cap4.2
3	JK-T9270-C01-02	101S11005	螺钉	1	140004001	Screw , SM3. 57
4	JK-T9270-C01-03	40626001	挑线连杆销	1	-----	Thread take-up lever pin
5	JK-T9270-C01-04	40605002	挑线连杆	1	-----	Thread take-up lever
6	JK-T9270-C01-05	40626002	针杆连接轴	1	-----	Needle bar connecting shaft
7	JK-T9270-C01-06	10124001	滚针轴承	1	-----	Needle bearing
8	JK-T9270-C02	10112003	针杆曲柄护板	1	107153001	Washer
9	JK-T9270-C03	400134	针杆滑块	1	102630001	Needle bar guide slide block
10	JK-T9270-C04	40601002	针杆滑块座	1	145688000	Needle bar guide
11	JK-T9270-C05	201S11009	螺钉	2	062670612	Screw pan SM3. 57-40×6
12	JK-T9270-C06	40602009	针杆	1	113605051	Needle bar
13	JK-T9270-C07	40603002	针杆上套	1	S18874001	Needle bar bush, U
14	JK-T9270-C08	40603003	针杆下套	1	111024101	Needle bar bush, D
15	JK-T9270-C09-01	40604001	针杆曲柄	1	S40271051	Thread take-up crank, MH
16	JK-T9270-C10	116S14005	螺钉	2	014771022	Screw , SM6. 35
17	JK-T9270-C11-01	116S14005	螺钉	3	100251001	Screw SM6. 35
18	JK-T9270-C13	40622006	橡皮塞	1	111863001	Needle bar cork
19	JK-T9270-C14	40622014	油封	1	140890009	Oil cup
20	JK-T9270-C15	10123002	油棉	1	151927001	Oil cotton
21	JK-T9270-C16	10112053	油线夹	1	109993001	Clutch felt wick nipper
22	JK-T9270-C17	40623002	回油线	1	-----	Oil line
23	JK-T9270-C18	10127015	油线压紧簧	1	-----	Ring

D1. 抬压脚部件(9270) / Presser bar mechanism(9270)

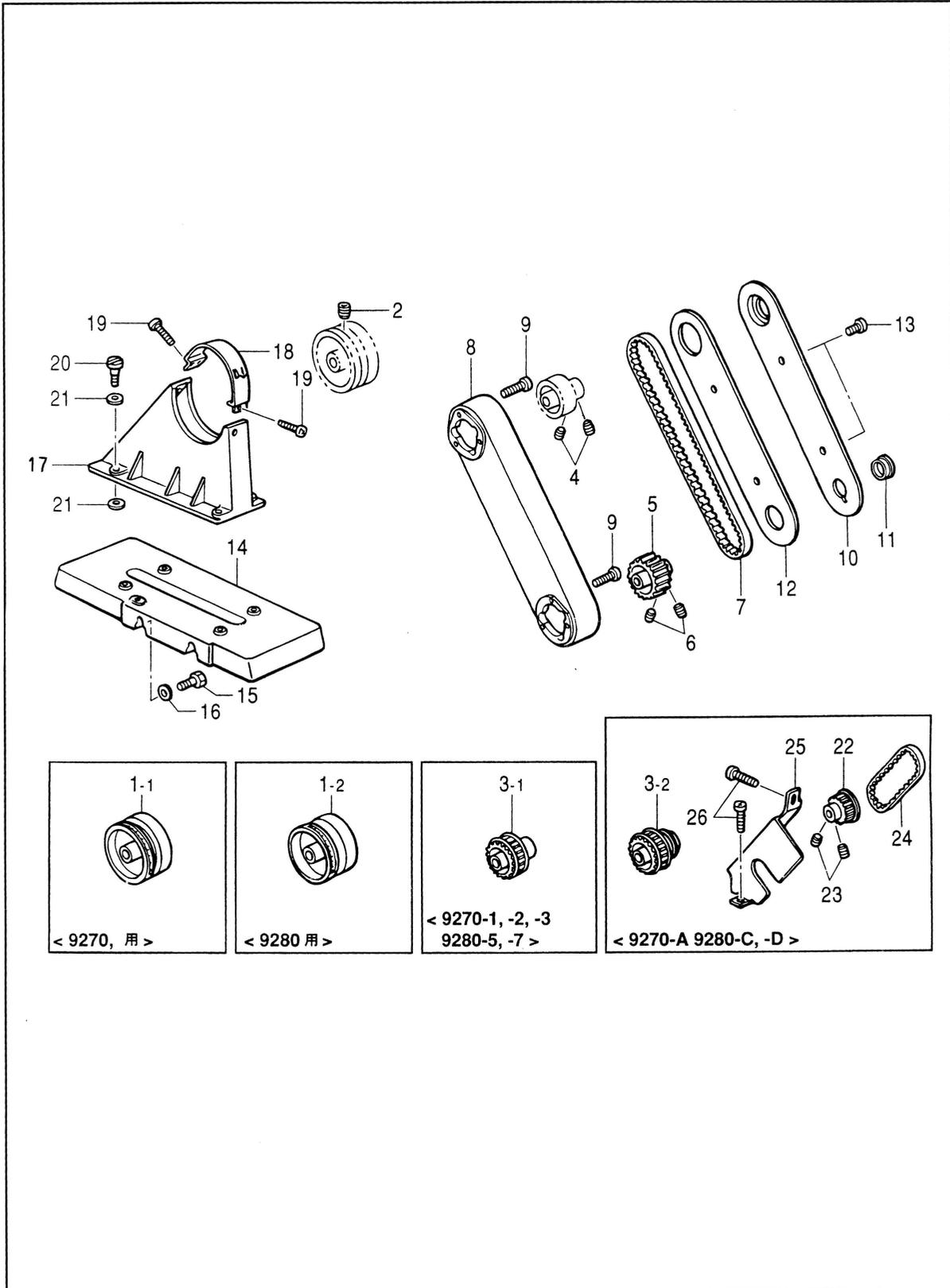


118-927-210

D1、 拾牙脚部件

序号	图号	件号	名称	件数	同类产品编号	Name of parts
1	JK-T9270-D01-01	40602002	压脚轴	1	S06259001	Presser bar
2	JK-T9270-D02	406S30002	压脚螺母	1	S40299001	Adjust screw
3	JK-T9270-D03-01	40603004	压脚轴套	1	111025001	Adjust screw bar
4	JK-T9270-D04	40609002	压杆导架	1	S40798050	Adjust screw bar clamp
5	JK-T9270-D05	101S15007	压杆导架螺钉	1	014760622	SET SCREW, SOCKET, SM5. 95
6	JK-T9270-D06	40627001	弹簧	1	S40298051	Spring
7	JK-T9270-D07	40612004	拾压脚架	1	105103001	Presser bar lifter
8	JK-T9270-D08	406S20001	轴位螺钉	1	105104001	Shoulder screw , SM7. 95
9	JK-T9270-D09	300258	拾压脚杠杆	1	105105009	Knee lifter lever
10	JK-T9270-D10	406S20002	轴位螺钉	1	102921002	Shoulder screw , SM7. 94
11	JK-T9270-D11	40627002	杠杆弹簧	1	105106001	Twist spring
12	JK-T9270-D12	30131018	拾压脚拉链	1	105333001	Presser foot lifter chain assy
13	JK-T9270-D13	300259	面板	1	S40300001	Pace plate
14	JK-T9270-D14	40622007	面板垫	1	S40301001	Packing
15	JK-T9270-D15	406S11009	螺钉	4	151927001	Screw, , pan SM4. 37-40×10
16	JK-T9270-D16	40611002	挡板	1	S40279001	Front lid
17	JK-T9270-D17	101S11007	螺钉	2	062680512	Screw, pan SM4. 37-40×5
18	JK-T9270-D19	40122017	油封	1	117934009	Rubber cap, 13. 5
19	JK-T9270-D20	40122005	油封	1	15915009	Rubber cap, 20. 5
20	JK-T9270-D21	40122005	油封	1	15915009	Rubber cap, 20. 5

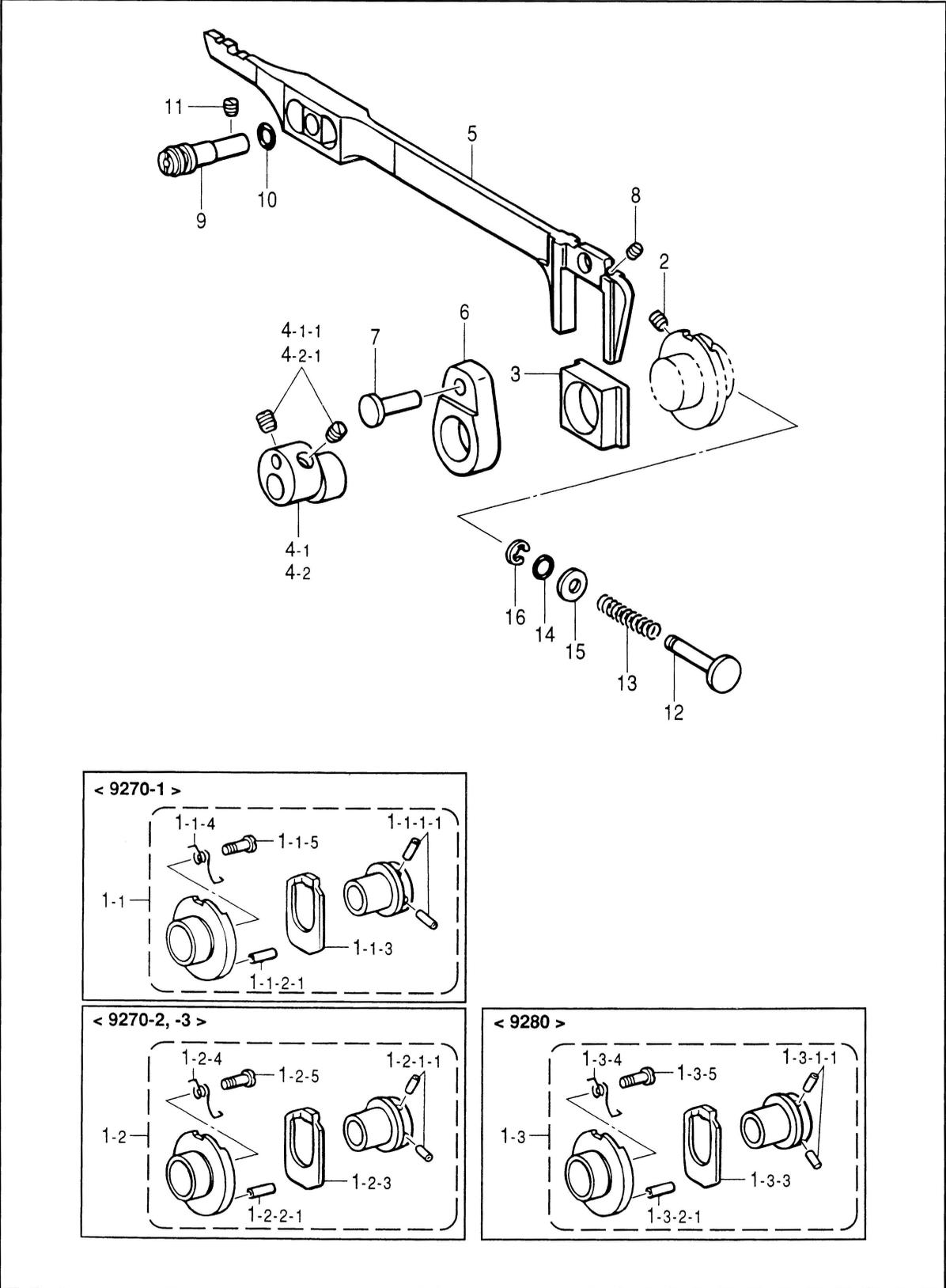
E. 带轮部件 / Pulley mechanism



E、带轮部件

序号	图号	件号	名称	件数	同类产品编号	Name of parts
1	JK-T9270-E01-01	300260	上轮	1	S40280001	Pulley assy.M
2	JK-T9270-E02	101S15001	上轮螺钉	2	014781032	Set screw, socket SM6.35
3	JK-T9270-E03-01	4063500400	上轴同步带轮	1	S40265001	Timing belt wheel assy, upper
4	JK-T9270-E04	116S14004	上轴带轮螺钉	2	014770622	Set screw, socket SM6.35
5	JK-T9270-E05	40635001	下轴同步带轮	1	S40818001	Timing belt wheel assy, lower
6	JK-T9270-E06	116S14004	下轮螺钉	2	014770622	Set screw, socket SM6.35
7	JK-T9270-E07	40635002	传动带	1	S40819000	Timing belt
8	JK-T9270-E08	300256	带轮箱	1	S40258001	Belt cover
9	JK-T9270-E09	101S11016	螺钉	6	062711612	Screw pan SM4.76-32×16
10	JK-T9270-E10	300261	带轮箱盖	1	S40259001	Belt cover plate
11	JK-T9270-E11	40611003	下带轮罩	1	116577051	Rotary hook shaft cover
12	JK-T9270-E12	40622008	带轮箱垫	1	105141001	Packing
13	JK-T9270-E13	115S11010	螺钉	2	062710812	Screw pan SM4.76-32×8
14	JK-T9270-E14	300257	底座	1	S40796001	Pulley cover base
15	JK-T9270-E15	S01037	螺钉M12×30	2	105144001	Bolt
16	JK-T9270-E16	W01016	垫片12	2	142627001	Washer
17	JK-T9270-E17	40611004	上轮罩壳	1	S40261001	Pulley cover ,A
18	JK-T9270-E18	40612010	上轮顶盖	1	S40262001	Pulley cover ,B
19	JK-T9270-E19	105S11015	顶盖螺钉	3	062680712	Screw pan SM4.37-40×7
20	JK-T9270-E20	406S20003	上轮罩壳螺钉	4	155558001	Stud screw, SM6.35
21	JK-T9270-E21	40622009	垫片	8	S40797000	Pulley cover sheet
22	JK-T9270-E22	4063501100	同步带轮	1	150659001	Timing pulley assy, B
23	JK-T9270-E23	116S14004	螺钉	2	14760622	Set screw, socket SM5.95
24	JK-T9270-E24	40635016	同步带轮	1	150661001	Pulley timing belt, A
25	JK-T9270-E25	××××	盖板	1	S40264001	Pulley belt cover
26	JK-T9270-E26	××××	螺钉	2	62680812	Screw, pan SM4.37-40×8

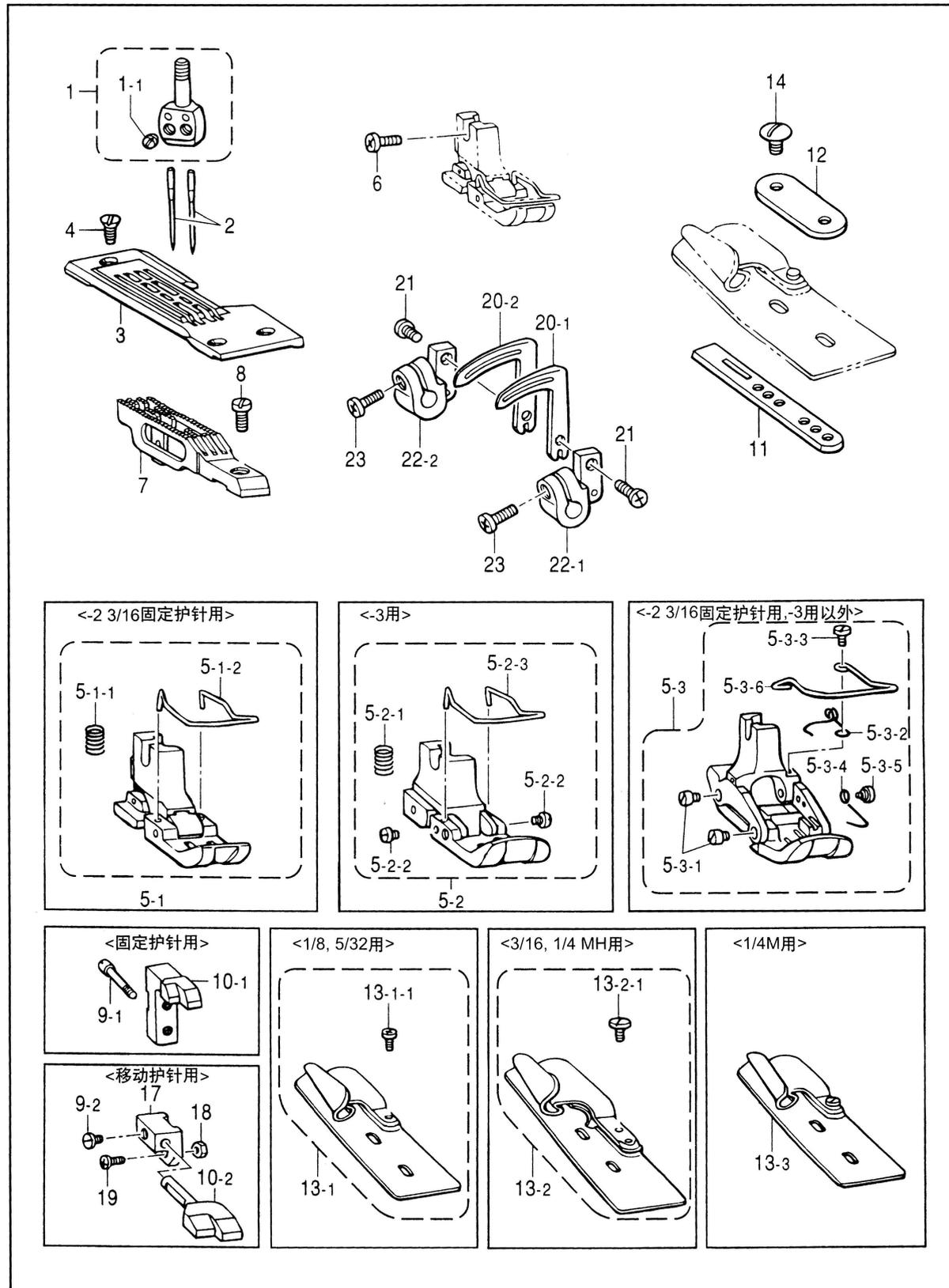
F. 送料部件 / Feed mechanism



F、送料机构

序号	图号	件号	名称	件数	同类产品编号	Name of parts
1	JK-T9270-F01-01	4061000100	送料凸轮组件	1	S40274001	Eccentric wheel assy, M
2	JK-T9270-F01-0101	40610002	止动凸轮	1	----	Pin, spring AW3
3	JK-T9270-F01-0102	40610003	针距调节凸轮	1	----	Pin, spring AW3
6	JK-T9270-F01-0103	40625001	止动板	1	S38309001	Rachter stopper
7	JK-T9270-F01-0104	40627003	弹簧	1	S39585001	Twist spring
8	JK-T9270-F01-0105	303S20002	螺钉	1	S39586001	Screw, M3
14	JK-T9270-F02	403s14004	螺钉	2	012060632	Set screw, socket M6×6
15	JK-T9270-F03	400133	送料滑块	1	S40282000	Eccentric wheel sleeve
11	JK-T9270-F04-01	400135	送料偏心轮	1	183949001	Eccentric wheel with screw, M
12	JK-T9270-F04-02	400098	送料偏心轮		183950001	Eccentric wheel with screw, H
13	JK-T9270-F04-0101	116S14004	螺钉	2	014770622	Set screw, socket SM6.35
16	JK-T9270-F05	400136	送料牙架	1	S40285001	Feed bar slide block assy
17	JK-T9270-F05-01	××××	牙架滑块	1	----	Feed bar slider
18	JK-T9270-F06	40604004	送料曲柄	1	S40288000	Feed lifting connencting shaft
19	JK-T9270-F07	40626004	曲柄销	1	S40289051	Feed lifting rock shaft
20	JK-T9270-F08	101S15007	螺钉	1	014760622	Set screw socket SM5.95
21	JK-T9270-F09	40626005	送料偏心销	1	S41311051	Feed bar eccentrics shaft
22	JK-T9270-F10	10122010	O型圈	1	081006070	O ring, P6
23	JK-T9270-F11	101S15010	螺钉	1	014761030	Set screw, socket SM5.95
24	JK-T9270-F12	40626006	针距调节销	1	S40290051	Push button
25	JK-T9270-F13	40627004	弹簧	1	S40800001	Spring
26	JK-T9270-F14	10122010	O型圈	1	081005070	O ring, P5
27	JK-T9270-F15	W01004	垫片5	1	025710132	Washer, plain S4.76
28	JK-T9270-F16	H05012	卡簧4	1	048040342	Retaining ring, E4

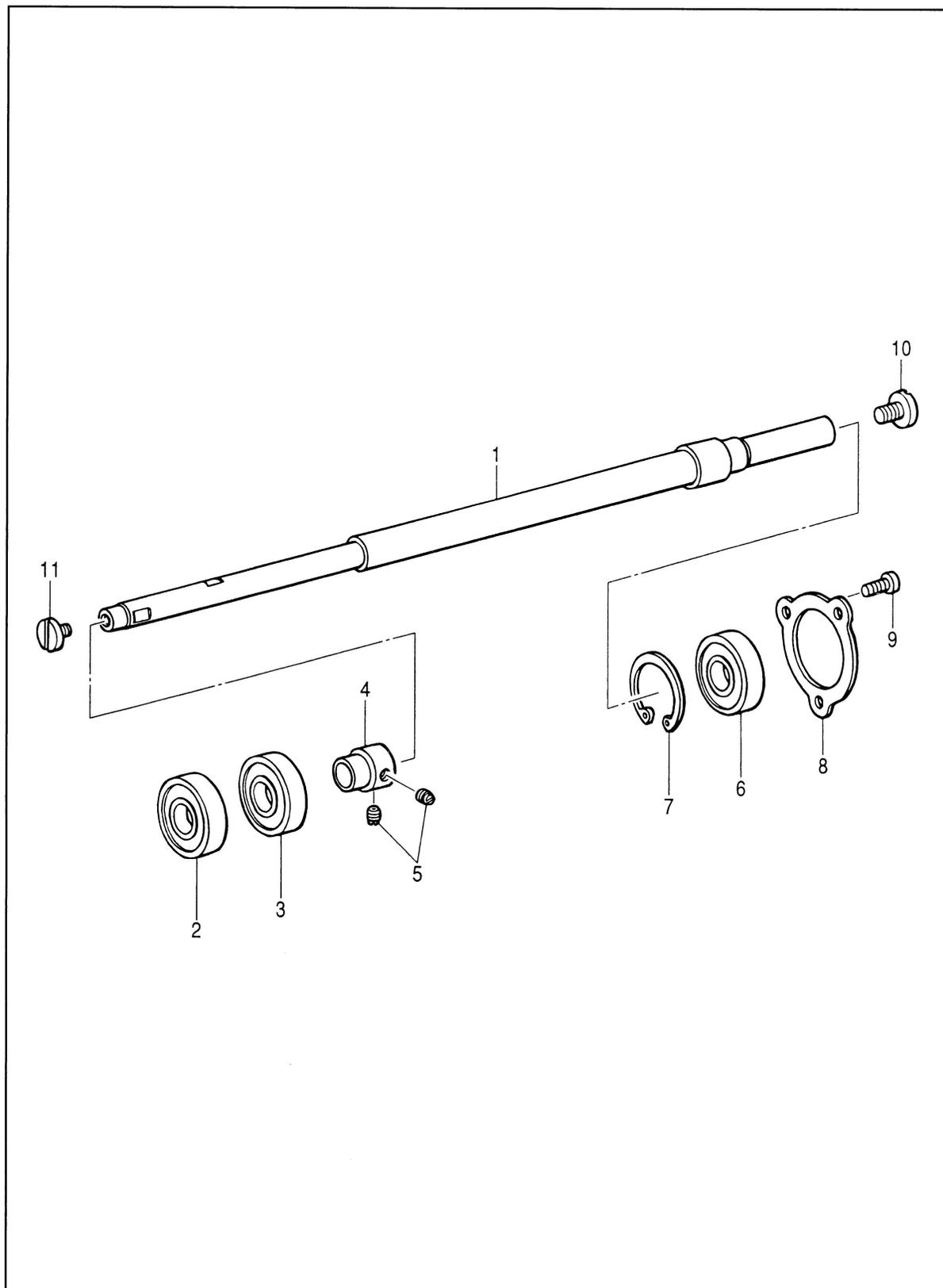
G1. 零件关系 / Gauge parts (9270 Standard)



G1、送料部件

序号	图号	件号	名称	件数	同类产品编号	Name of parts
1	JK-T9270-1 (1/4)	4063401400	针位组件	1	----	Needle asm.
2	JK-T9270-G01	40634002	针夹头	1	183978-001	Needle calmpassy w/s
3	JK-T9270-G01-01	209S14003	机针螺钉	2	103408002	Set cscrew, SM4.37
4	JK-T9270-G02	40617001	机针	2	S36861-012	Needle
5	JK-T9270-G03	40615002	针板	1	S11508-101	Needle plate
6	JK-T9270-G04	101S17002	针板螺钉	3	100032004	Screw flat SM4.37
20	JK-T9270-G05-03	40616002	压脚组件	1	S40363-001	Presser foot assy
21	JK-T9270-G05-0301	406S20005	螺钉	4	147871001	Pin
22	JK-T9270-G05-0302	40627005	弹簧	1	S40358001	Spring
23	JK-T9270-G05-0303	406S15001	螺钉	1	111105002	Screw SM2.38
24	JK-T9270-G05-0304	40627006	弹簧	1	S40360001	Spring
25	JK-T9270-G05-0305	406S20006	螺钉	1	147932001	Shoulder screw, SM2.38
7	JK-T9270-G06	101S11010	压脚螺钉	1	060670812	Screw bind SM3.57-40×8
8	JK-T9270-G07	40614002	送料牙齿	1	S40370-001	Feed dog
9	JK-T9270-G08	402S11023	送料牙螺钉	1	105173004	Screw, SM4.76
26	JK-T9270-G09-02	201S11011	护针固定螺钉	1	111443003	Set screw, SM3.57
27	JK-T9270-G10-02	40617008	护针	1	148973-001	Needle guard
10	JK-T9270-G11	40609005	滑块	1	S40399001	Lapper guide plate
11	JK-T9270-G12	40612011	安装板	1	105129001	Lapper guide plate washer
31	JK-T9270-G13-03	40615021	卷边器	1	S09679-001	Lapper assy
12	JK-T9270-G14	406S11002	安装板螺钉	2	105130001	Screw, SM3.57
28	JK-T9270-G17	40604007	护针架	1	148876001	Needle guard bracket
29	JK-T9270-G18	201S16001	螺母	1	021670102	Nut, SM3.57
30	JK-T9270-G19	101S11010	螺钉	1	062671012	Screw pan SM3.57-40×10
13	JK-T9270-G20-01	40617011	前弯针	1	S40393-001	Lopper, S
14	JK-T9270-G20-02	40617017	后弯针	1	S40394-001	Looper, L
15	JK-T9270-G21	101S11007	弯针螺钉	2	062680612	Screw, pan SM4.37-40×6
16	JK-T9270-G22-01	40604005	前弯针架	1	S06315001	Looper holder, S
17	JK-T9270-G22-0102	40626007	弯针架销	2	----	Pin
18	JK-T9270-G22-02	40604006	后弯针架	1	S06314001	Looper holder, L
19	JK-T9270-G23	105S11015	螺钉	2	062681012	Screw pan SM4.37-40×10

J. 下轴部件 / Lower shaft mechanism

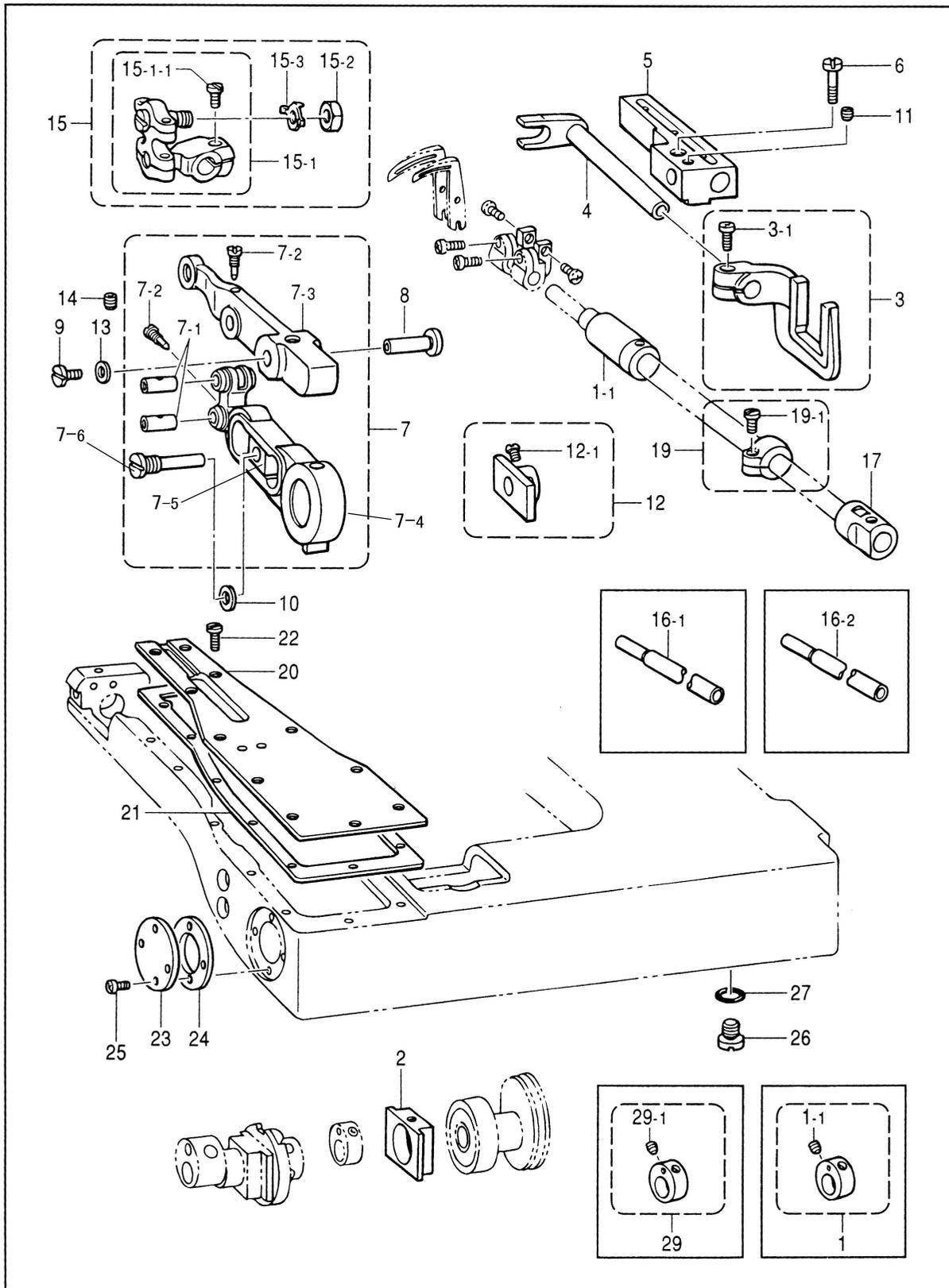


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J、下轴部件

序号	图号	件号	名称	件数	同类产品编号	Name of parts
1	JK-T9270-J01	40602004	下轴	1	105147101	Lower shaft
2	JK-T9270-J02	B03003	轴承6200Z	1	072620070	Ball bearing, 6200Z
3	JK-T9270-J03	40608005	轴套	1	072620180	Shaft sleeve
4	JK-T9270-J04	40608002	下轴挡圈	1	105150000	Lower shaft collar
5	JK-T9270-J05	209S14003	挡圈螺钉	2	102716004	Set screw, SM4. 37
6	JK-T9270-J06	B06007	6302VV	1	072630260	Ball bearing, 6320VV
7	JK-T9270-J07	H01004	卡簧42	1	048420242	Retaining rig, C42
8	JK-T9270-J08	40612002	轴承盖	1	S40316051	Bearing presser
9	JK-T9270-J09	115S11010	轴承盖螺钉	3	062711012	Screw , pan SM4. 76-32×10
10	JK-T9270-J10	406S11003	螺钉	1	105155001	Screw, SM6. 35
11	JK-T9270-J11	101S11023	螺钉	1	105156002	Screw, SM4. 37

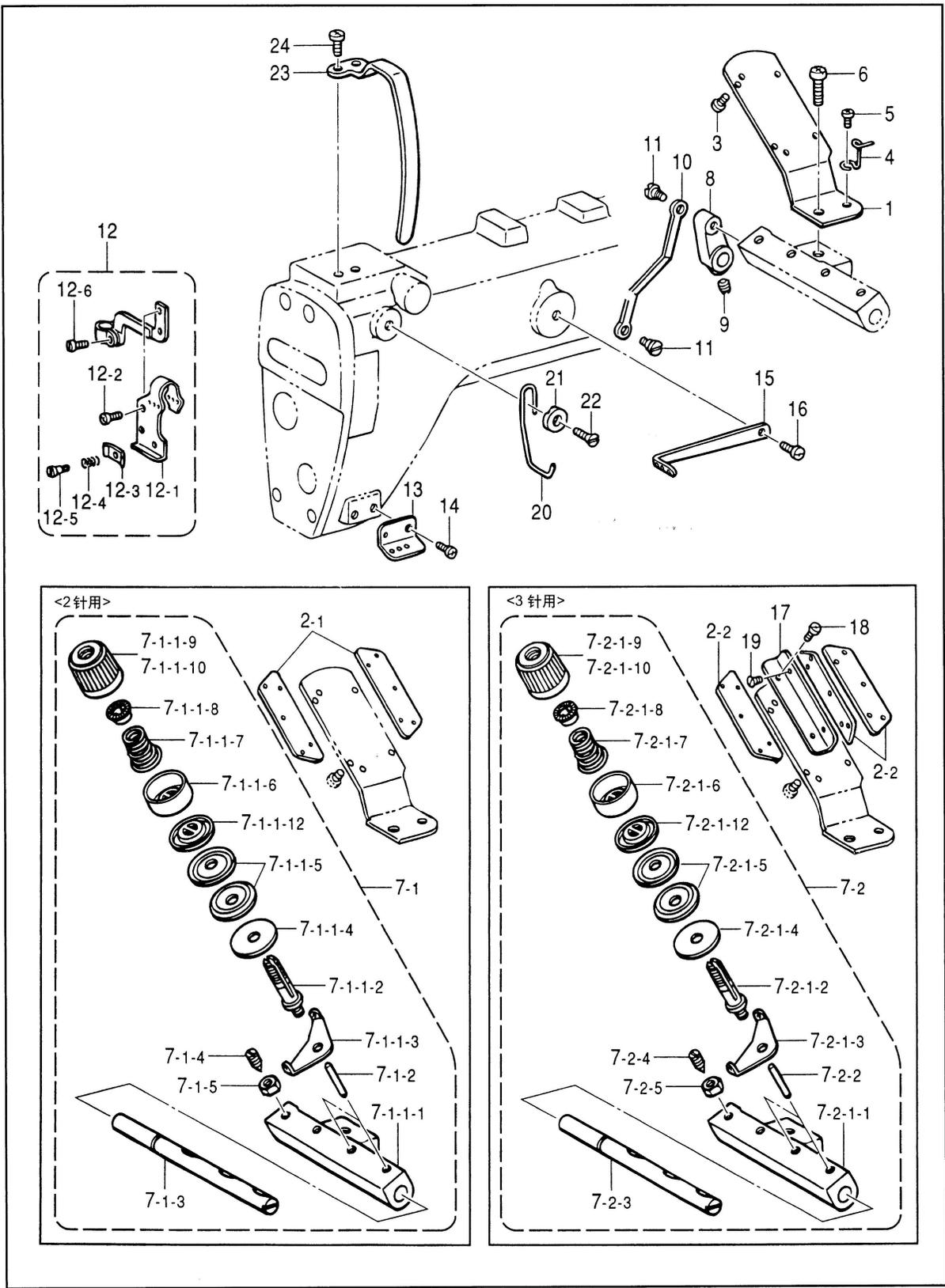
K. 弯针轴部件 / Looper mechanism



K、弯针轴部件

序号	图号	件号	名称	件数	同类产品编号	Name of parts
2	JK-T9270-K02	400138	离合滑块	1	S40302000	Slidee
3	JK-T9270-K03	40605003	弯针离合叉	1	181993101	Lopper feeding fork assy
4	JK-T9270-K03-01	201S11020	螺钉	1	105176001	Screw, SM4. 37
5	JK-T9270-K04	40602005	弯针离合轴	1	105177001	Lopper feeding fork shaft
6	JK-T9270-K05	40601006	弯针离合轴座	1	105178100	Lopper fork shaft bracket
7	JK-T9270-K06	101S11020	螺钉	1	105179001	Screw, SM4. 76
8	JK-T9270-K07	4060401100	离合架部件	1	S40303001	Looper connecting rod assy
9	JK-T9270-K07-01	40626008	曲柄连接销	2	105183001	Looper link shaft
10	JK-T9270-K07-02	406S30004	螺钉	2	105184000	Screw, SM2. 38
11	JK-T9270-K07-03	40604012	离合曲柄	1	S40792001	Looper lever
12	JK-T9270-K07-04	400139	离合架	1	-----	Looper holder
13	JK-T9270-K07-05	40609004	滑块	1	-----	Slider
14	JK-T9270-K07-06	40626009	销子	1	-----	Pin
15	JK-T9270-K07-07	400141	曲柄	1	-----	Lever
16	JK-T9270-K07-08	400637	曲柄滑块		-----	Lever slider
17	JK-T9270-K08	40626010	销子	1	S140793051	Pin
18	JK-T9270-K09	406S11004	螺钉	1	105191001	Screw, SM4. 37
19	JK-T9270-K10	10122010	O型垫圈	1	081010870	O ring, S10
20	JK-T9270-K11	406S11005	螺钉	1	100260001	Set screw, SM5. 95
21	JK-T9270-K12	40608003	离合架销挡圈	1	181987001	Block plate
22	JK-T9270-K12-01	209S14003	螺钉	2	100366001	Screw
23	JK-T9270-K13	O01004	O形圈4×1.8	1	081003670	O ring
24	JK-T9270-K14	101S15007	螺钉	1	014761030	Screw SM5. 95
25	JK-T9270-K15	4060401400	弯针摆杆部件	1	105193101	Ball link assy
26	JK-T9270-K15-01	40604015	弯针摆杆	1	183185101	
27	JK-T9270-K15-0101	201S11020	螺钉	1	105176001	Set screw
28	JK-T9270-K15-02	401S16002	螺母	1	100022004	Nut, SM5. 95
29	JK-T9270-K15-03	20128015	垫片	1	105198000	Washer
30	JK-T9270-K17	40603007	弯针轴后套	1	105201000	Looper shaft bush, F
31	JK-T9270-K18	40603008	弯针轴前套	1	148877100	Looper shaft bush, B
32	JK-T9270-K19	40608004	挡圈	1	181971001	Looper shaft set collar
33	JK-T9270-K19-01	201S11020	螺钉	1	062680812	Screw , pan SM4. 37-40×8
34	JK-T9270-K20	40612012	下仓盖	1	S40306001	Front feed arm cap
35	JK-T9270-K21	40622010	下仓盖垫	1	S40307001	Packing
36	JK-T9270-K22	101S11010	螺钉	11	105216001	Screw, SM3. 57
37	JK-T9270-K23	40612013	下轴前盖	1	105217059	Ball bearing
38	JK-T9270-K24	40622011	垫片	1	S40308001	Packing
39	JK-T9270-K25	201S12001	螺钉	4	062670512	Screw, pan SM3. 57-40×5
40	JK-T9270-K26	401S11029	螺钉	1	140518001	Screw, SM7. 94
41	JK-T9270-K27	10122010	O型圈	1	081007070	O ring , P7

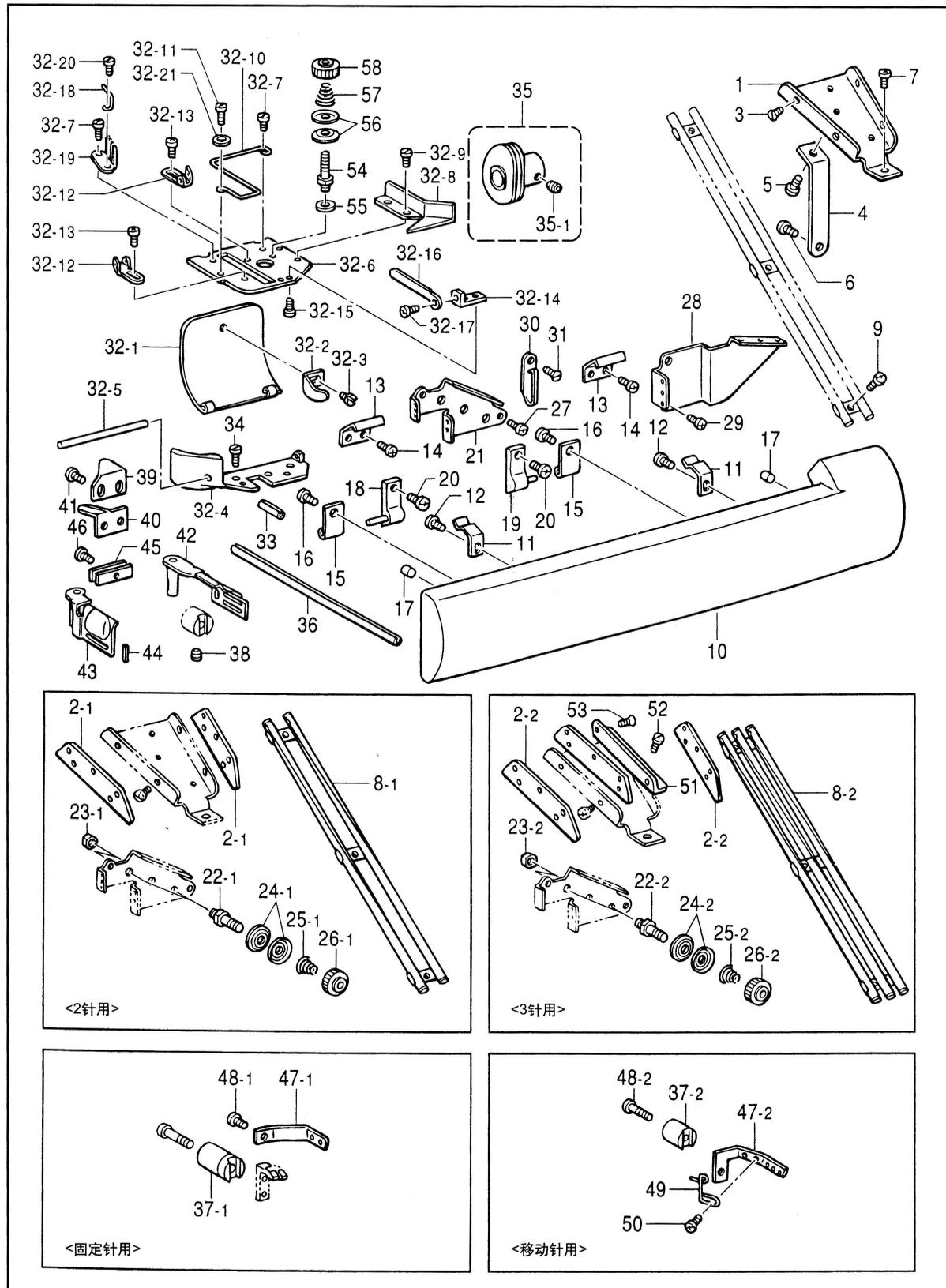
L1. 上线过线部件 (9270) / Upper threading mechanism (9270)



L1、面线过线部件

序号	图号	件号	名称	件数	同类产品编号	Name of parts
1	JK-T9270-L01	40612014	面线导线支架板	1	111070109	Upper thread guide
2	JK-T9270-L02-01	40613027	导线板	2	105221001	Thread retainer
3	JK-T9270-L03	101S11019	螺钉	4	062630412	Screw pan SM2.35-56×4
4	JK-T9270-L04	40613001	过线勾	1	105222001	Thread guide
5	JK-T9270-L05	201S11010	螺钉	1	062670512	Screw, pan SM3.57-40×5
6	JK-T9270-L06	101S11016	螺钉	1	062712012	Screw, pan SM4.76-32×20
7	JK-T9270-L07	4061303100	面线夹线器部件	1	----	Upper thread regulator assy
8	JK-T9270-L07-0101	300264	面线松线器座	1	111075059	Upper thread tension bracket
9	JK-T9270-L07-0101	406S30006	夹线器螺钉	2	145440001	Tension stup
10	JK-T9270-L07-0101	40613008	夹线导线板	2	110813001	Needle thread guide
11	JK-T9270-L07-0101	40628004	垫片	2	110832009	Tension disc felt
12	JK-T9270-L07-0101	40613009	夹线板	4	145446001	Tension disc
13	JK-T9270-L07-0101	40612017	松线座	2	144103009	Tension disc presser
14	JK-T9270-L07-0101	40627007	夹线簧	2	144104001	Thread tension adjust spring
15	JK-T9270-L07-0101	40611008	转动套	2	S30564000	Tension spring washer
16	JK-T9270-L07-0101	40611009	夹线调节螺母(绿)	1	S30565002	Tension nut, green
17	JK-T9270-L07-0101	40611010	夹线调节螺母(红)	1	S30565003	Tension nut, red
18	JK-T9270-L07-0101	40612018	松线座	2	159805001	Tension disc presser
19	JK-T9270-L07-0102	40626011	顶针	2	105231000	Pin
20	JK-T9270-L07-0103	40602007	松线轴	1	111076151	Tension release shaft
21	JK-T9270-L07-0104	406S30007	螺钉	1	105233002	Set screw, SM4.37
22	JK-T9270-L07-0105	201S16003	螺母	1	105234003	Nut, SM4.37
23	JK-T9270-L08	40604016	松线曲柄	1	105235251	Tension release crank
24	JK-T9270-L09	209S14003	螺钉	1	151601002	Set screw, SM4.37
25	JK-T9270-L10	40612015	连接板	1	105236001	Tension release connecting rod
26	JK-T9270-L11	406S20007	螺钉	2	105237002	Shoulder screw, SM3.57
27	JK-T9270-L12	40605005	挑线杆部件	1	S40310001	Upper thread take-up assy
28	JK-T9270-L12-01	40613002	挑线过线板	1	S40312001	Upper thread guide
29	JK-T9270-L12-02	201S11005	螺钉	2	062660512	Screw, pan SM3.18×5
30	JK-T9270-L12-03	40613003	过线压板	1	105243001	Upper thread take-up holder
31	JK-T9270-L12-04	20727002	弹簧	1	105244000	Spring
32	JK-T9270-L12-05	207S20003	轴位螺钉	1	105245001	Shoulder screw, SM2.38
33	JK-T9270-L12-06	201S11008	螺钉	1	100064005	Screw, SM3.57
34	JK-T9270-L13	40613004	过线板	1	S40313051	Upper thread guide
35	JK-T9270-L14	101S11010	螺钉	1	062670712	Screw pan SM3.57-40×7
36	JK-T9270-L15	40613005	张力缓线勾	1	111077001	Tension release lever
37	JK-T9270-L16	101S11010	螺钉	1	060670812	Screw bind SM3.57-40×8
38	JK-T9270-L17	××××	导线板	1	----	Thread guide set plate
39	JK-T9270-L18	××××	螺钉	1	----	Screw pan SM2.38-56×4
40	JK-T9270-L19	××××	螺钉	1	----	Screw, flat SM2.38

M1. 下线过线部件 (9270) / Lower threading mechanism (9270)



M1、下线过线部件

序号	图号	件号	名称	件数	同类产品编号	Name of parts
1	JK-T9270-M01	40612021	底线导线安装板	1	111095009	Lower thread guide retainer
2	JK-T9270-M03	101S11019	螺钉	4	111073001	Screw flat SM2.38
3	JK-T9270-M04	40602021	支撑板	1	111096009	Lower thread guide support
4	JK-T9270-M05	305S11005	螺钉	1	062670412	Screw pan SM3.57-40×4
5	JK-T9270-M06	201S11010	螺钉	1	062670512	Screw pan SM3.57-40×5
6	JK-T9270-M07	201S11010	螺钉	1	062671012	Screw pan SM3.57-40×10
7	JK-T9270-M8-1	300265	过线管(喷漆)		----	Inglide guide tube assy
8	JK-T9270-M09	201S11009	螺钉	1	062670812	Screw pan SM3.57-40×8
9	JK-T9270-M10	300266	底线外盖	1	S40319001	Front cover
10	JK-T9270-M11	40627012	底线外盖卡簧	2	S40320051	Front cover spring
11	JK-T9270-M12	201S11009	螺钉	2	060670512	Screw pan SM3.57-40×5
12	JK-T9270-M13	40612022	盖板固定板	2	S40321051	Front cover hook
13	JK-T9270-M14	201S11010	螺钉	4	062670612	Screw pan SM3.57-40×6
14	JK-T9270-M15	40612023	转动架	2	S40322051	Hing
15	JK-T9270-M16	201S11009	螺钉	2	062670612	Screw pan SM3.57-40×6
16	JK-T9270-M17	40622005	缓冲垫	2	142274009	Rubber cap 4.2
17	JK-T9270-M18	40601009	左转动架	1	105257009	Thread guide hing assy,L
18	JK-T9270-M18-02	40626014	转动架销	2	----	Pin
19	JK-T9270-M19	40601010	右转动架	1	105260009	Thread guide hing assy,R
20	JK-T9270-M20	201S11009	螺钉	2	062671012	Screw pan SM3.57-40×6
21	JK-T9270-M21	40613012	夹线器安装板	1	S40323001	Lower thread guide
22	JK-T9270-M27	201S11010	螺钉	2	062670612	Screw pan SM3.57-40×6
23	JK-T9270-M28	40613013	过线板	1	S40325001	Lower thread guide
24	JK-T9270-M29	201S11010	螺钉	2	062670612	Screw pan SM3.57-40×6
25	JK-T9270-M30	11613010	过线钩	1	112658001	Arm thread guide M
26	JK-T9270-M31	11613012	螺钉	1	108960002	Screw flat SM3.57
27	JK-T9270-M32	4061301400	打线凸轮架部件	1	S40266051	Lower thread take-up bracket
28	JK-T9270-M32-01	300267	打线凸轮盖	1	105280009	Thread take-up lever cover
29	JK-T9270-M32-02	40627009	卡簧	1	105281001	Spring,plate
30	JK-T9270-M32-03	101S11019	螺钉	1	122771002	Screw,SM2.38
31	JK-T9270-M32-04	40601011	底线转向过线板	1	105284101	Take-up lever bracket
32	JK-T9270-M32-05	40626015	打线凸轮盖销	1	105285000	Take-up lever cov. Shaft
33	JK-T9270-M32-06	40612025	凸轮导线架	1	S40326051	Take-up lever bracket
34	JK-T9270-M32-07	101S11005	螺钉	2	062670612	Screw pan SM3.57-40×6
35	JK-T9270-M32-08	40612026	底线转向导板	1	105287001	Guide plate
36	JK-T9270-M32-09	101S11019	螺钉	2	105288001	Screw SM2.38
37	JK-T9270-M32-10	40627010	导线钢丝	1	S40327051	Lower thread guide
38	JK-T9270-M32-11	409S11011	螺钉	1	060660416	Screw bind SM3.18-40×4
39	JK-T9270-M32-12	40613015	导线架	1	S40795101	Lower thread guide
40	JK-T9270-M32-1201	40613016	导线架	1	----	Screw bind SM3.18-40×4

51	JK-T9270-M34	301S11007	螺钉	2	100064005	Screw SM3.57
52	JK-T9270-M35	4061301900	打线凸轮	1	S40330051	Lower thread take-up W/S,M
53	JK-T9270-M35-01	209S14003	凸轮紧固螺钉	2	014680422	Set screw, socket SM4.37
54	JK-T9270-M36	40613020	底线过线管	1	105300101	Lower thread feed bar guide
55	JK-T9270-M38	101S15007	螺钉	1	013760610	Set screw, SM5.95
101	JK-T9270-M39-1	40619005	切线刀	1		Thread trimmer guide plate
58	JK-T9270-M41	201S11010	螺钉	1	062670612	Screw , pan SM3.57-40×6
59	JK-T9270-M42	40612028	右弯针盖	1	S40335051	Looper cover, RA
60	JK-T9270-M43	40612029	左弯针盖	1	S40338051	Looper cover, LA
61	GB/T879-1986	P03015	销2×8.5	1	047200842	Pin, spring roll AW2
62	JK-T9270-M45	40612030	弯针盖压板	2	S40799051	Spring
63	JK-T9270-M46	101S11010	螺钉	1	062670712	Screw , pan SM3.57-40×7
64	JK-T9270-M54	406S30008	夹线螺钉	1	S08987001	Thread tension control stud
65	JK-T9270-M56	40613023	夹线板	2	144504001	Thread guide disc
66	JK-T9270-M57	40627011	弹簧	1	S40324001	Thread guide spring
67	JK-T9270-M58	406S16002	夹线螺母	1	155510001	Tension nut
68	JK-T9270-M02-01	40613027	导线板	2	105221001	Thread retainer
69	JK-T9270-M08-01	40613021	过线管	1	105251009	Inglide guide tube assy
70	JK-T9270-M22-01	406S30008	夹线螺钉	2	S08987001	Thread tension control stud
71	JK-T9270-M23-01	201S16003	螺母	2	021680202	Nut, SM4.37
72	JK-T9270-M24-01	40613023	夹线板	4	144504001	Thread guide disc
73	JK-T9270-M25-01	40627011	弹簧	2	S40324001	Thread guide spring
74	JK-T9270-M26-01	406S16002	夹线螺母	2	155510001	Tension nut
75	JK-T9270-M37-02	40601012	护针支架	1	147291001	Looper thread guide bracket
76	JK-T9270-M47-02	40613024	导线架	1	S16487151	Looper thread guide
77	JK-T9270-M48-02	201S11037	螺钉	1	062671412	Screw pan SM3.57-40×14
78	JK-T9270-M49	40613025	导线勾	1	S40341001	Looper thread guide
79	JK-T9270-M50	101S11019	螺钉	1	062630412	Screw pan SM2.38-56×4