

6000F Mechanical Operation Instruction



Catalogue

1、Brief Instruction

- (1) Basic data
- (2) Instruction of safety device&standard unit
- (3) Parameter
- (4) safety operation & maintenance guide

2、units installation

- (1) package units
- (2) accessory
- (3) voltage feeder & air pressure supply

3、correct application

- (1) start machine/standard original position
- (2) needle installation
- (3) thead installation

4、machine controlling

- (1) procedure of sewing buttonhole
- (2) operation page on display

5、machine adjustment

- (1) standard position
- (2) needle bar
- (3) zig zag
- (4) feeding
- (5) feeder
- (6) adjust loopers
- (7)
- (8) thread clamp
- (9) thread cutting
- (10) adjust presser foot of machine head
- (11) change driving belt

6、machine maintenance

- (1) machine cleaning and maintenace
- (2) regular maintenance
- (3) distribution of lubricated systme
- (4) lubricated system
- (5) machine management

brief introduction

1、basic data

The imitation buttonholes made by 6000F are same in appearance. The normal imitation buttonholes are purly for decorative, but this kind of buttonholes are quite necessary for garments, especially for menswear, lady`s dress, jacket, suit, sporting cost etc. The speed could reach to 380RPM, which is twice to three times faster than the traditional machines

6000F electronically controls the stitches size, distances and length. The numbers, distances angled range(0-30 degredd) of buttoholes can be adjusted also, in this way, it rises both the safety of operation and quality of buttonholes.

Special electronically controls and security system keep operator safe and help the machine running. Adopt special power off shutter to avoid machine accidental starting efficiently and also can prevent machine from accidental starting with cover open by security switch. Equipped with emergency stopping key and low pressure detector to keep machine away accidental starting under low pressure

Don` t remove security labels, if lost, replace it in time

Don` t remove any security labels, Learn how to use the machine correctly before operate it, read the instruction before operate it, or else you might get hurt if you lack in knowledge of operating it.

Danger Might get hurt

warning Might get hurt or machine damaged

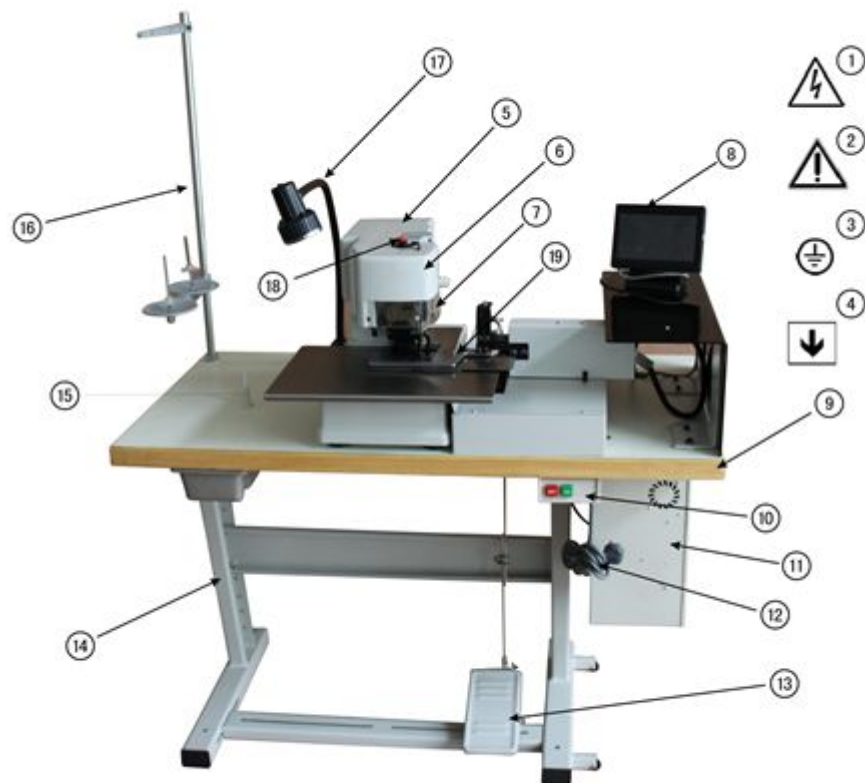
caution Might get hurt or machine damaged

Operate the machine with engineer or technician` s assistance

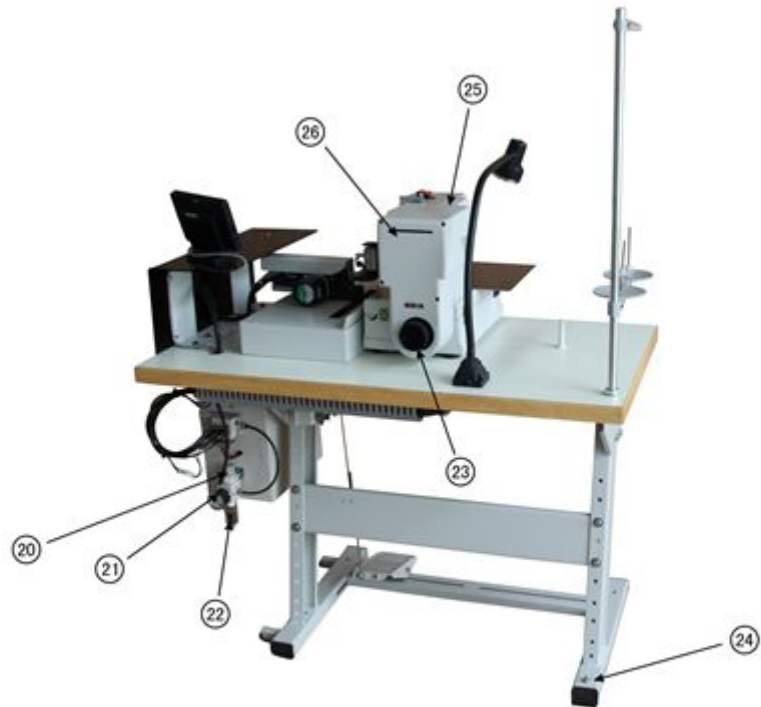
Operate the machine under security system, don` t dismantling security device

Wearing safety goggle when operate or maintain machines

2、 safety device and label



1	warning	11	control box
2	maybe injured if remove it	12	power wire
3	earth wire	13	pedal switch
4	rotate direction	14	machine stand
5	machine head	15	rod of machine head
6	needle bar protector	16	thread stand
7	eye protector	17	LED lamp
8	display	18	emergency stop switch
9	table	19	automatic feeder
10	power switch		



20	pressure adjustor	24	balance adjustment of machine stand
21	pressure connector	25	cover of machine head
22	pressure sensor	26	back lid of machine head
23	hand wheel		

3、parameter

model	6000F
brief	computerized imitation buttonhole sewing machine
speed	1.stitches per min. Driving axis:500-1900rpm
buttonhole length	15.8 - 25mm
instension of stitches	4-12 stitches/cm,=10-30stitches per inch
buttonhole type	sewed by single thread, without cutting the buttonholes.
presser foot height	12.7mm
fabric thickness	4mm
zig-zag range	1.6 - 2.3mm
distance between first and second line	0 - 0.9mm
suggested sewing types	80,100, 120
types of needle	EB750 SC90/14(80/12)
lubrication system	semi-automatic
suggested operation environment	Temperature;+5℃-40℃, moisture:30%-80%
pressure supply	0.55 MPa
no. Of linking	1 - 8
angle of linking	0° - 30°
dimension of machine head	340mm (H) x 470mm (B) x 250mm (L)
weight of machine head	62 kg
dimension of table	700mm (H) x 600mm (B) x 1.100mm (L)
power breaker	10A C (EN60947 - 2)
	16A B (EN60947 - 2)

4、 safety operation&maintenance guides

We suggest that the distance range between machine head and table is 25-30mm, when install the machine. Please read the informations as following:

The operator should understand all installation and operation guides before start the machine.

Dangerous!!

Please confirm all safety devices have been installed before connecting the machine to electronic board

Confirm you have started pressure closer or switch off the voltage supply before remove any safety devices.

Warning!!

Confirm positions of all emergency stop keys and ensure you have totally understand the usage.

Confirm input of pressure supply is stable

Confirm all power supply wire is good without any damage.

If there are any broken of protecting cover, please repair it or change it immediately.

When the machine is working, do not touch any moving units.

Keep the needle clean

Confirm the machine is power off before change the needles.

Before cleaning or making any maintenance for the machine, please turn off power supply.

It could be dangerous when operate the machine improperly

Before operating or maintaining machine, operator must carefully read to understand the instruction of spare parts and service.

Notes!!

Check units installation of the instruction about spare parts and service.

If there are any electric problems, please switch off the power supply first.

Do not remove, cover, break or use any other methods to change the safety label. If the label cannot be read clearly, please change it as soon as possible.

It could be dangerous if you wear the loosen clothes. In case of any accident, please bind up hair and change the loosen clothes.

Do not operate the machine after drinking or taking drugs

If there are any problems during the operation, please ask help from technician.

The normal bright is 750 lux when the surrounding is full of lights.

units installation

1、package units

- (1) Wooden case as the machine package
- (2) The package includes accessories, spare parts, instruction and thread stand.
- (3) Unfold the package according the label out of the



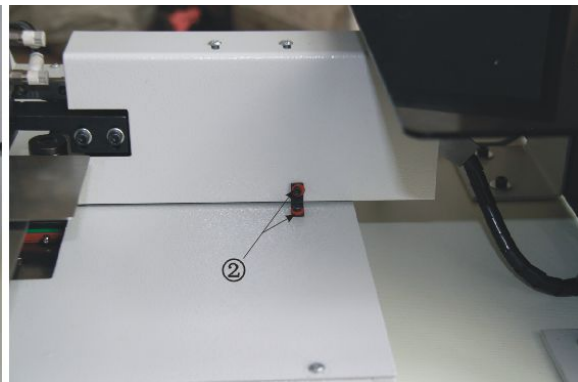
Notes!

If the package is broke during the shippment, please check the accessories in order. If there are any damaged or missing accessories, please contact us immediately. Otherwise, we won't be responsible for it.



2、Accessory

It includes some accessories as the Picture. Please see the attached picture for your reference. The screw on picture 2 could be removed , which could be install back for the second delivery.

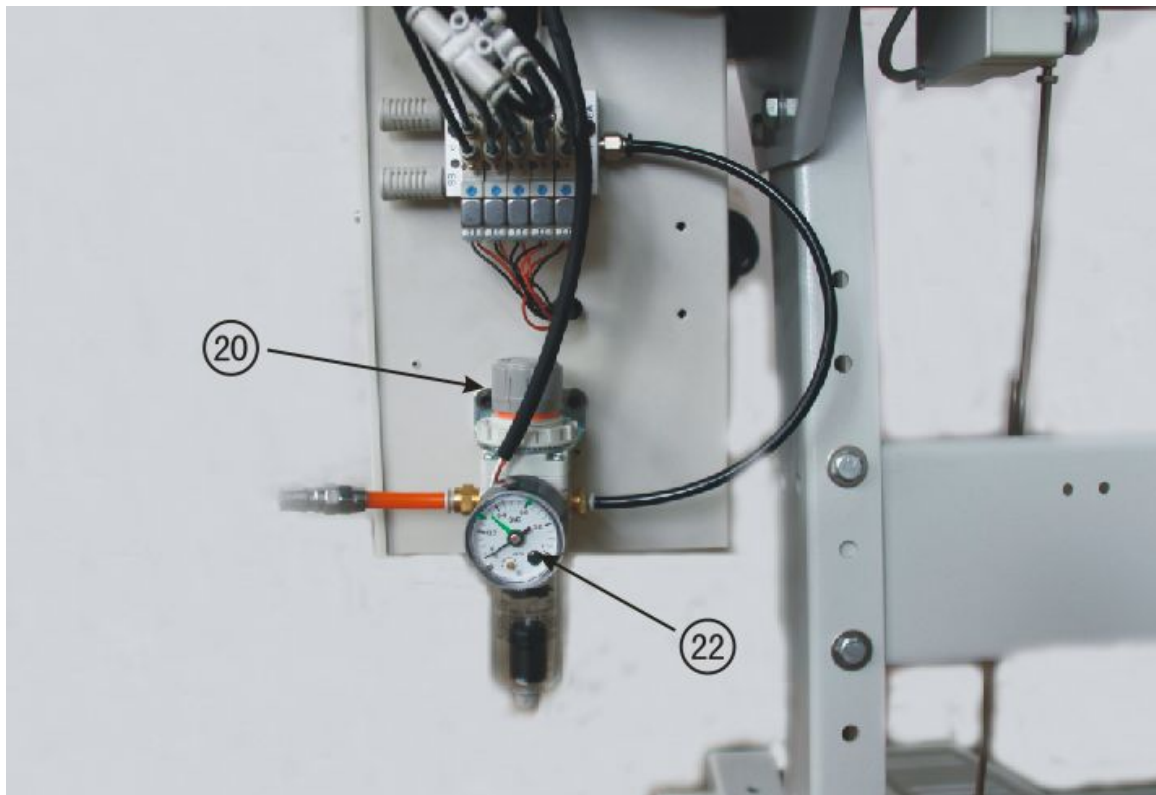


3、voltage feeder & air pressure supply

Check air pressure set(22) after supply the pressure feeder, the standard range is between 0.5-0.6Mpa. Green-the min. Working pressure supply is 0.5Mpa which is set by manufacture. If the pressure supply is lower than 0.5Mpa after the feeder, the red signal light will light up and the display will show some information. To adjust pressure (20),pull up to adjust the barograph, then turn it clockwise to increase the input of pressure.finally press the “confirm” key of barograph. LED light is used to set the minimum operating pressure.

Pressure supply must be 208-230V, single phase,50/60Hz. The connecting socket must meet with the requirements of IEC standard 364-4-4-41, current breaker must be 10A C type according to EN 60947-2(or 16A B type). Except above, the machine cannot connect with other circuit breaker or socket. Running machine has to rotate the hand wheel by clockwise.

As capacitor can produce high current, please use the capacitor with fuse in case of any danger.



correct application

1、 start machine/standard original position

(1) Press green button “ON” (1) to start main power supply, press the red one “OFF” to switch off the power.

Before the start, machine has to reset to the standard original position(press REST on display or push the food pedal switch)

(2) power specification

Power voltage: single phase $220V \pm 15\%$

Working current: average current $< 3A$, current peak value $< 5A$

Customers can purchase power protecting cover.



2、needle installation

Warning!

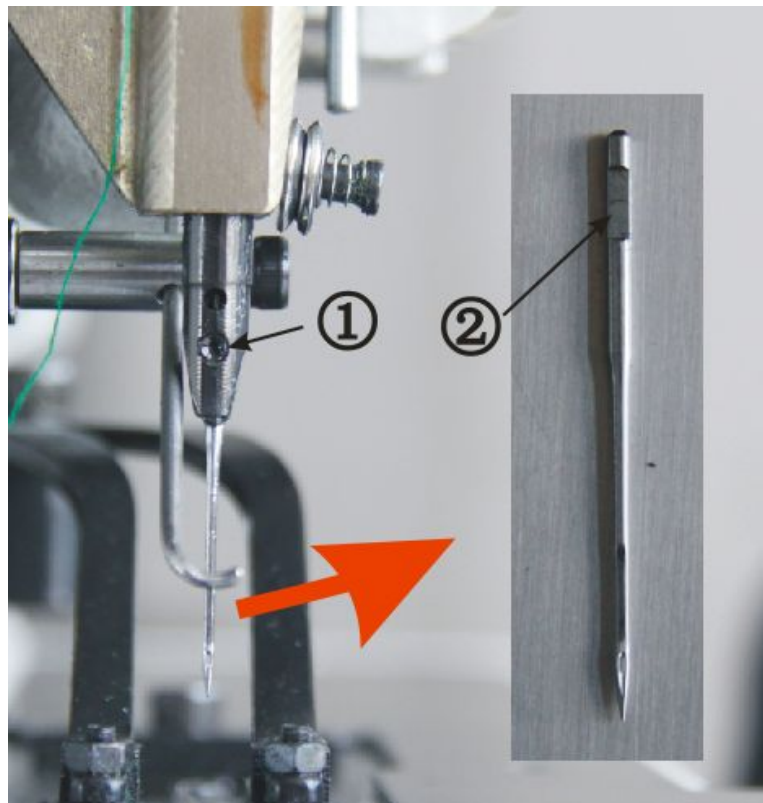
Before start the machine, please turn off the main power supply, in case of any accident. Remove the air pressure supply and release the reserved energy.

The machine only applies to needle (EB750 90/14). For the thin fabric, (EB750 80/12) is suitable, which should be bought separately.

Loose screw 1 and remove the needle

Install new needle to make the concave 2 opposited to clamp screw 1. Do not install the bend or damage needle. Finally check if the needle is vertical by turn it.

Tighten screw 1



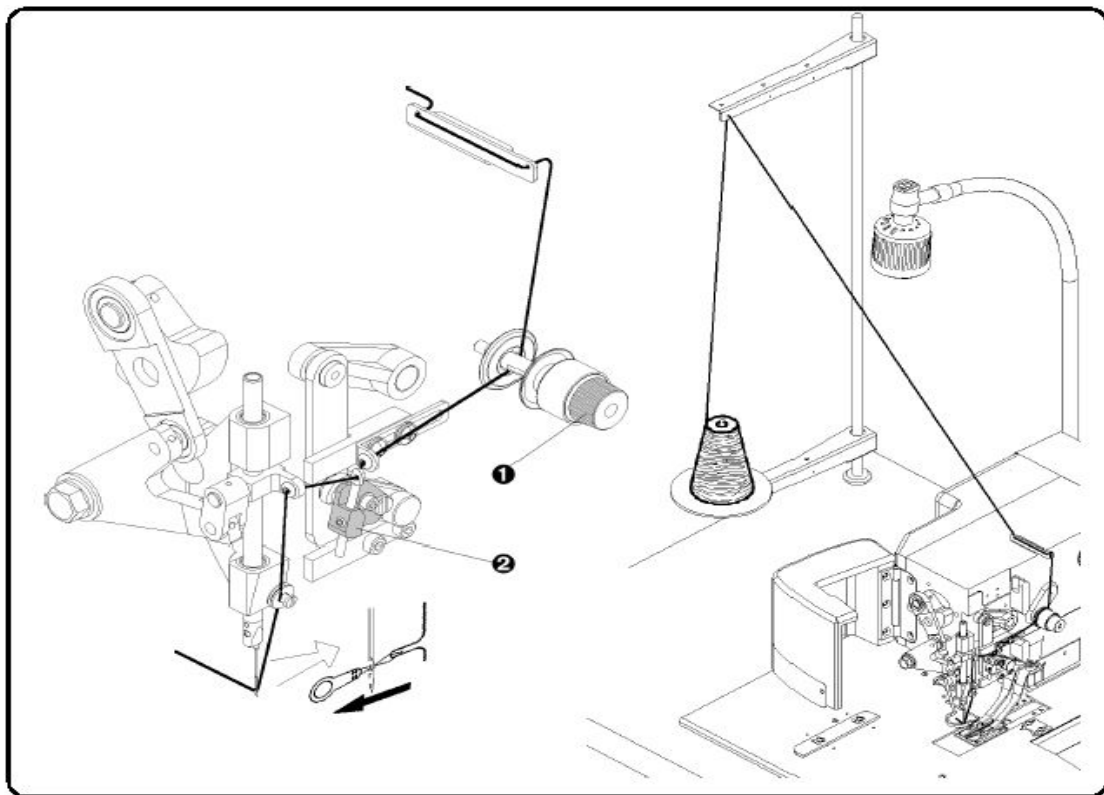
3、 install threading

Warning!!

Before start the machine, please turn off the main power supply, in case of any accident. Remove the air pressure supply and release the reserved energy.

When install threading, please press “threading” button on display. After the installation, please press REST button to exit.

Please threading as the following picture. Loose screw cap1 to change the thread tension. If you need to have longer thread for sewing (eg: on the thin fabric), please adjust the thread of arm lever 2.



the appearance of buttoholes could be influenced by:

- thread tension
- thread type
- thread thickness
- fabric (eg: thickness)

machine control

1、sewing procedure

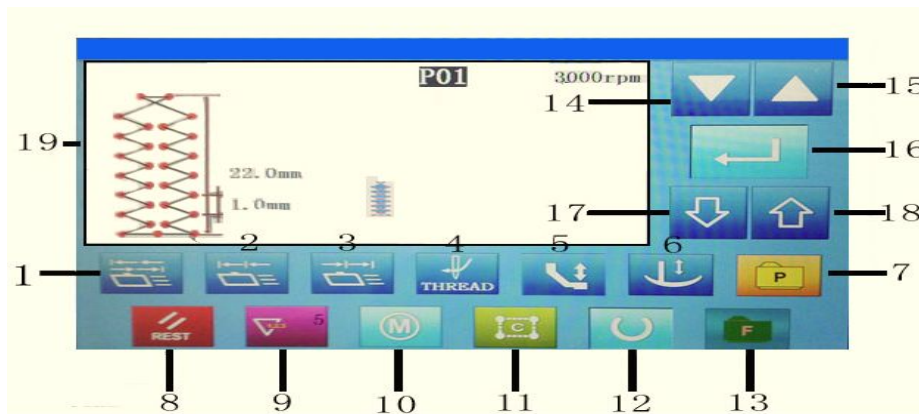
- (1) Power on then press REST key (refers to 3-1)
- (2) Check the threading condition and fabric position (refers 3-3)
- (3) Presser foot moves down and clamp the fabric when pressing foot pedal to first stage (presser foot back to origin position when releasing foot pedal)
- (4) Sewing procedure starts when pressing foot pedal to second stage, machine state and presser foot back to origin position after trimming.
- (5) Set the fabric for next sewing procedure when the presser foot back to original position
- (6) Sewing procedure can be paused during any sewing parts by pressing the emergency stop button(2) on the top of machine. The machine can also continue completing sewing work by pressing foot pedal when the emergency stop button is screwed out.
- (7) Back to original position by pressing REST key.
- (8) Cut the power(key 3) firstly then turn off working lamp to cut the air pressure supply.



2、screen operation










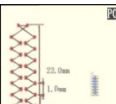
(1) names and specifications of main interface

Machine starting automatically when the controller is on, after initialization it shows the operation interface (see picture below)



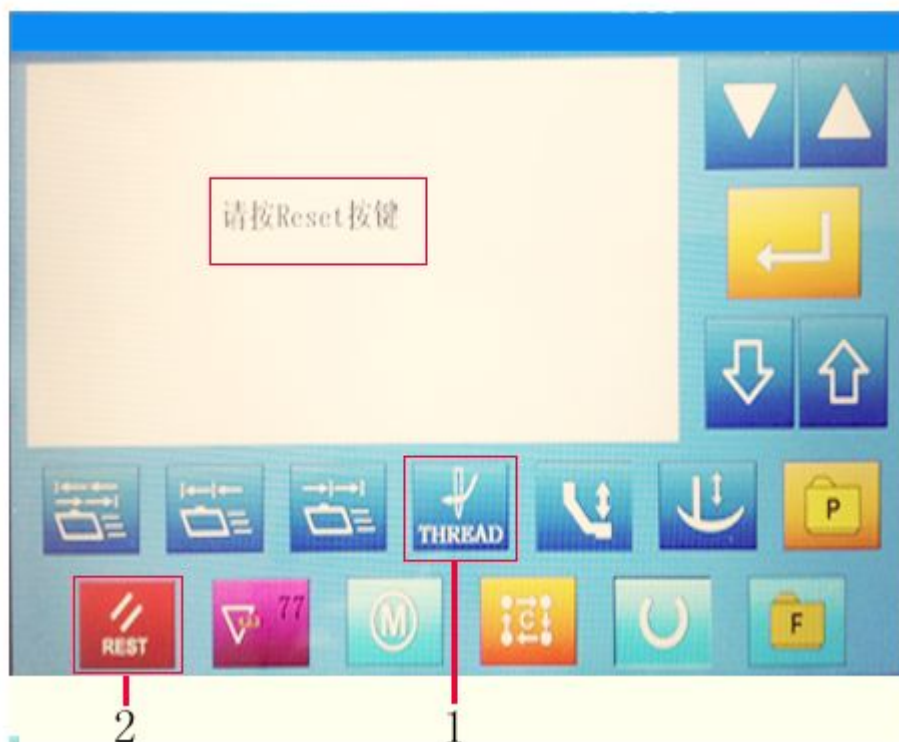
Sheet 1: Instruction of Icons

No.	Icons	Identification of icons	Functions
1		Left Edge / Right Edge.	Automatically moves left edge/right edge after pressing it
2		Moving Left	Move to left in one unit, under the recycled mode.
3		Moving Right	Move to right in one unit, under the recycle mode.
4		Threading	Threading by press once. After threading, press icon 8 (REST) to exit.
5		Main Presser Foot	Main presser foot. Lift up / down by pressing.
6		Small Presser Foot	Small presser foot. Lift up / down by pressing.
7		Parameter Adjusting	The parameters can be readjusted by Icon 17&18 after pressing. Exit by pressing Icon 12.
8		(REST) Reset	Mainly used to clear or remove faults.
9		Counting.	Come to counting page by pressing.

No.	Icons	Identification of icons	Functions
10		Manual	Turn the wheel by manual, feeding device moves forward stitch by stitch. Press Key 12 to exit.
11		Automatic Shift	It's used to shift between automatic recycle mode and semi-automatic recycle mode.
12		Sewing start.	Come to Sewing Mode by pressing it.
13		Functions.	Adjust the functions by pressing.
14		Patterns (backward)	Change Patterns
15		Patterns (forward)	Change patterns
16		ENTER	Confirm the parameter setting
17		Parameter Adjusting (DOWN)	Adjust parameters
18		Parameter Adjusting (UP)	Adjust parameters
19		Menu display.	all your selected patterns, sizes, speed etc are showed in this area.

Functions on the main panel under threading

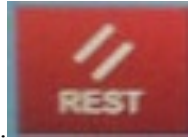
Threading Mode: Come to Threading Mode by pressing Icon 1 (Threading). After the threading, exit it by pressing Icon 2 (REST).



Main presser foot. Lift up / down by pressing.



Small presser foot. Lift up / down by pressing

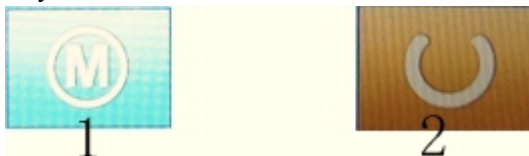


Reset. Mainly used to clear or remove faults.

Counting. The figure on the up right is the production value. Come to the Setting Page by pressing it. The page will be showed as below:



Manual (Icon 1). Turn the wheel by manual, feeding device moves forward stitch by stitch. Press Key 12 to exit.



Automatic shift. It's used to shift between automatic recycle mode (Picture 2) and semi-automatic recycle mode (Picture 1)



图1



图2

Sewing Start. Come to Sewing Mode by pressing it, and push the foot pedal to start sewing.



Modification of Eyelet Parameters



Come to the setting page of Parameter values by pressing Icon 6. Press Icon 1 or 2 as the above picture to choose the parameters, then adjust the parameter values through Icon 4 or 5. Confirm the modification by pressing Icon 3.

No. 01 Parameter: Buttonhole length (Unit 0.5mm). Adjust the length through Icon 4 or 5, range from 15.0-25.0mm. Confirm all modification by pressing Icon 3. The previous value will be kept without confirm by Icon 3.

Exit the Setting of Parameters by Icon 7.

Please adjust the detail setting of parameters according to the sheet as below:

Parameter Setting Table

No.	Parameter	Setting Range	Initial Value	Setting Unit	Detail setting
P01	Buttonhole Length	15.0--25.0	22.0	0.5mm	Adjusting the Length of Buttonholes
P02	Stitches distance of buttonhole	0.5--2.5	1.0	0.1mm	Adjusting Distance of each stitches
P03	Space of buttonhole	0.1—1.5	1.0	0.1mm	Adjusting Width of the Buttonhole
P04	No.s of buttonholes	2--8	4	1	Setting of Buttonhole numbers
P05	Distance between buttonholes	8.0—32.0	16.0	1.0mm	Setting of Distance between each two Buttonholes
P06	Max. speed	1500--3800	3000	100rpm	Setting Maximum speed of Main Axis Motor
P07	Rotation Angle of Bevel Motor	0-30	0	1 度	Setting the Ratation Angle
P08	Round Stitches Distance	0.5—2.5	1.0	0.1mm	Adjusting Round Stitches Distance
P09	Knotting Pattern	0/1	0	1	0 flat head, 1 round head
P10	Knoting Stitches	1X,2X,3X	1	1	Setting the stitches of knot.
P11	Equal Distance between Buttonholes	0/1	0	1	Setting the EQUAL Stitches Distance between Buttonholes
P12	Distance between No. 1 & 2	4.0-32.0	4.0	1	Setting the Distance between No. 1 & 2 Buttonholes
P13	Distance between No. 2 & 3	4.0-32.0	4.0	1	Setting the Distance between No. 2 & 3 Buttonholes
P14	Distance between No. 3 & 4	4.0-32.0	4.0	1	Setting the Distance between No. 3 & 4 Buttonholes
P15	Distance between No. 4 & 5	4.0-32.0	4.0	1	Setting the Distance between No. 4& 5 Buttonholes
P16	Distance between No. 5 & 6	4.0-32.0	4.0	1	Setting the Distance between No. 5 & 6 Buttonholes
P17		4.0-32.0	4.0	1	Setting the Distance between No.6 & 7 Buttonholes

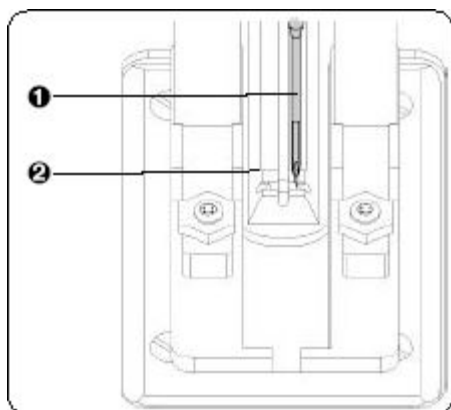
	Distance between No. 6 & 7				
P18	Distance between No. 7 & 8	4.0-32.0	4.0	1	Setting the Distance between No. 7 & 8 Buttonholes

machine readjustment

(1) machine standard position

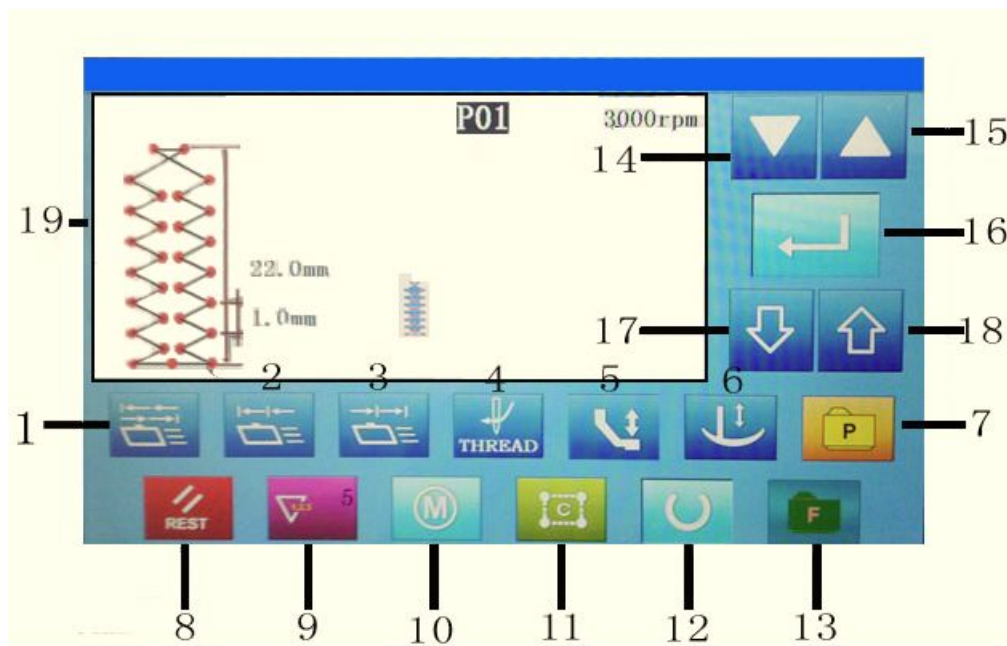
When needle bar is in the rising position, needle (1) is located in the right of needle plate (2) of the first line.

Set the stopping position of machine according to the display operation instruction 4-4



Warning: before adjust the machine, you have to make the machine under "manual mode".

Press manual icon (10), push foot pedal switch, and rotate the wheel by hand, then the feeding device will move forward step by step, press sewing icon (12) to exit.



2、needle bar

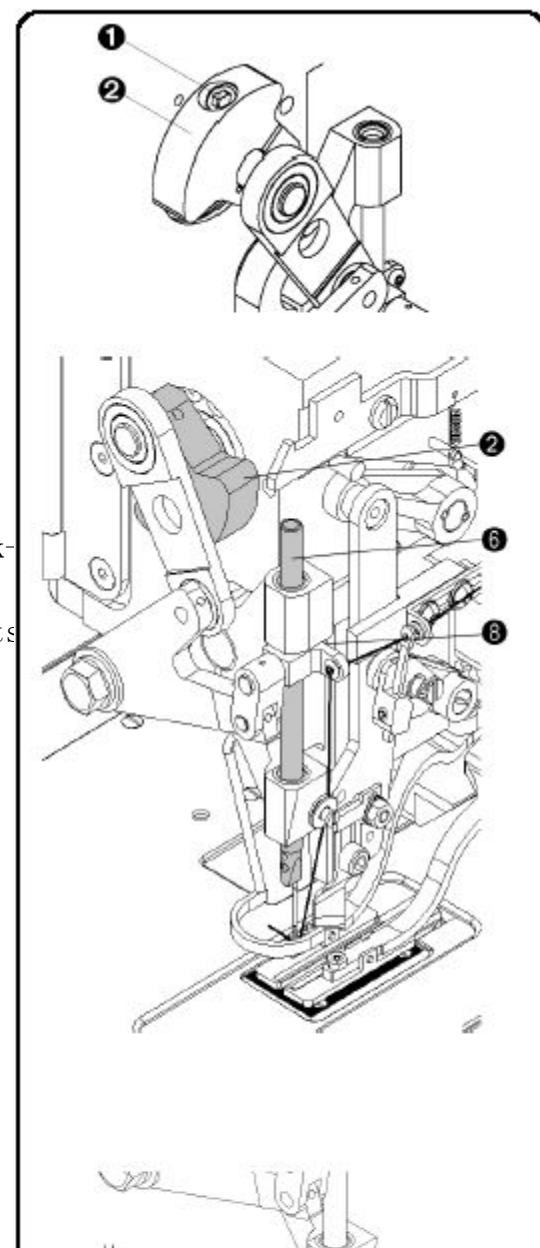
Rotate hand wheel (5) and loose the screw(1)
On the dent position of needle bar (2). Turn
Wheel until the bar reach to the highest point.
Roller screw (3) of the main wheel should be in
One line with screw (4). Then tighten the screw
(1).

Warning:when screw (3) is on 12 o'clock, needle
Bar should be on the highest point.if need any
Check, turn hand wheel by clockwise and anticlock-
Wise direction. Needle bar will move down when
Turned in one of the directions. Needle (10)starts
From the right of needle plate.

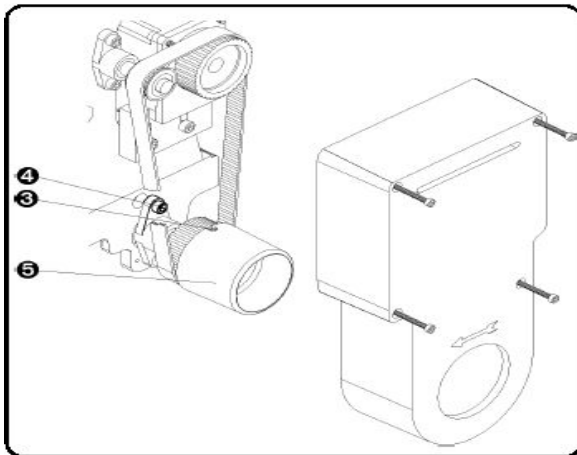
adjust height of needle bar

Adjust the height of needle bar(8) by (9). The
Distance from needle plate (7) to the point of
Needle is 16mm (5/8").

Loose screw (8) and adjust the height of needle



Bar according to your needs.



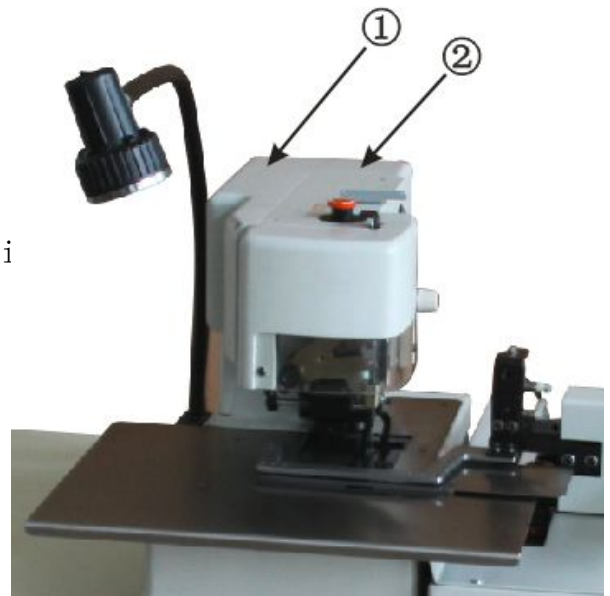
3、zin-zag

Remove pulley cover (2) and head cover (1)
Before adjust the machine.

(1) zig zag

Check if the machine is on the standard origi
position

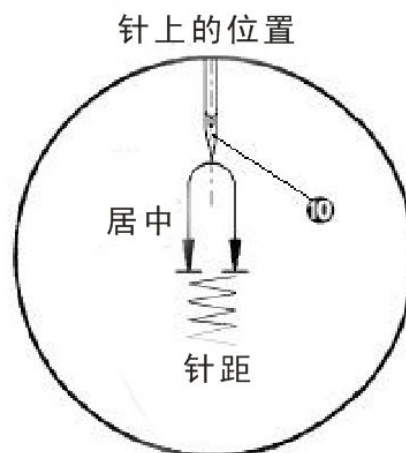
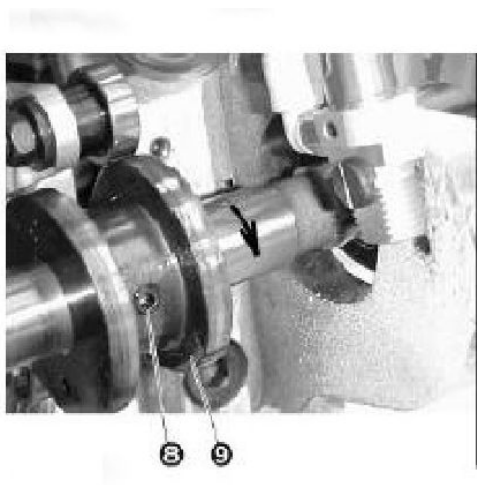
Incline position pin (7). If the adjustment
Is correct, the fixing screw (8) of second
Cam would be verticle to the machine cover.
(turn the cam by anticlockwise.



Adjust zigzag cam to make all zigzag moving same with the up-down move of
needle.

Warning: before the needle (10) show out the fabric, the needle have to be

without any zigzag moving--see the picture. Fasten the fixing screw (8)



(2) adjust width of zigzag

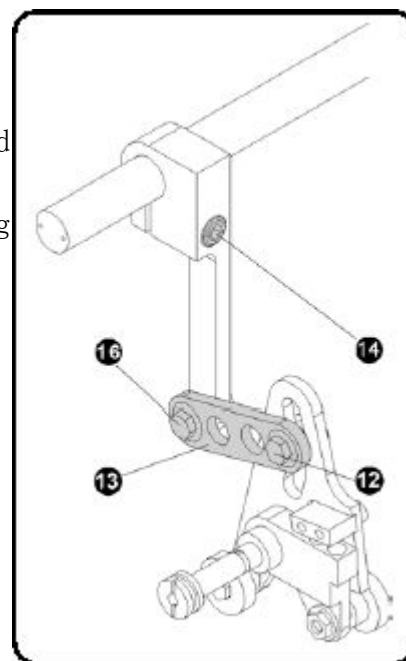
Remove the head cover before adjust zigzag width

6000F is suitable for standard plate (11), zigzag Range is from 1.5mm (1/16") to 2.3mm (3/32"

Increase the width of zigzag by rising (13)

Decrease the width of zigzag by lowering (13)

Fasten adjusting screw (12)



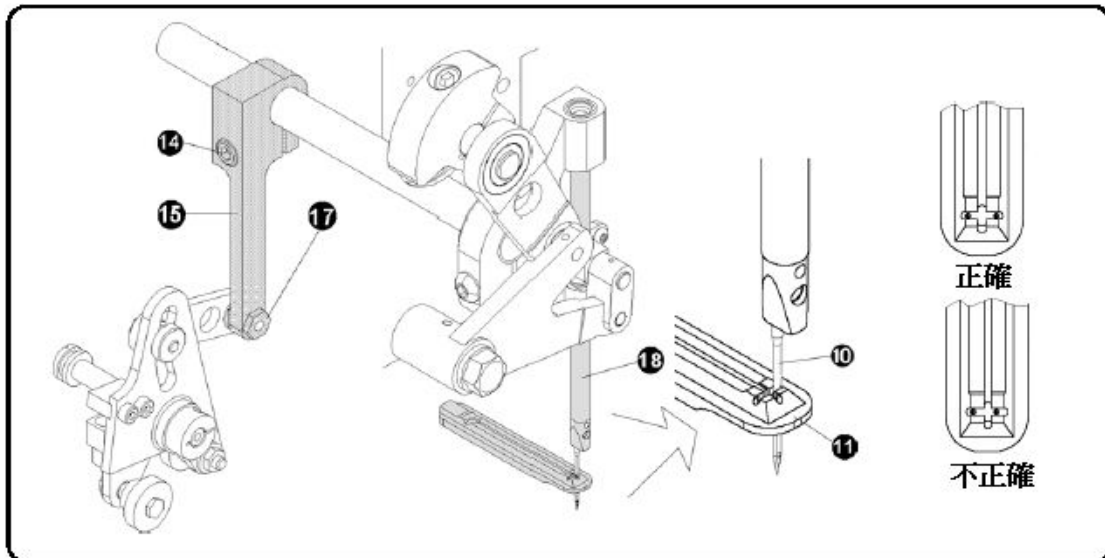
(3) needle throat adjustment of zig zag

When the machine is in the standard original position, loose the clamp screw(14) of zigzag pull rod (15)

If need a rough adjustment, turn needle bar to the lowest position by hand wheel and move to the right of needle plate. Turn hand wheel to the second needle (10)

Fasten clamp screw (14)

Loose screw (16) and turn adjusting nut (17), then fasten screw (16)

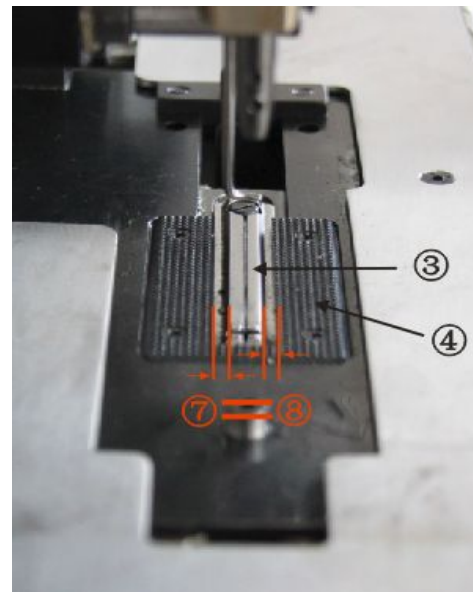
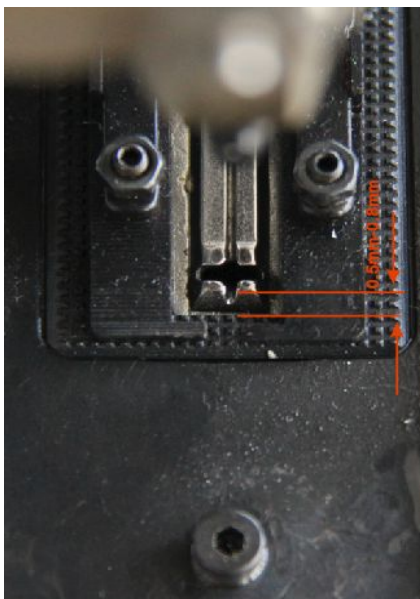


4.back to zero position

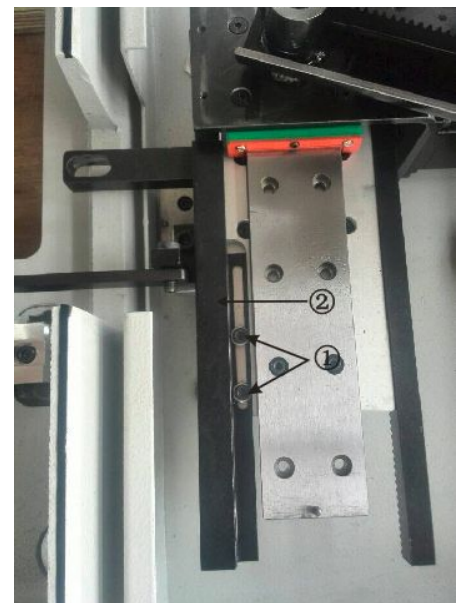
Warning: press the icon on display” zero position. Read the display operation instruction 3.1

Zero position adjust on Y axis. See picture (1) to loose screw left and right. Approach switch stand, adjust the distance between fixing plate (3) and needle plate (4). The correct distance is 0.5mm - 0.8mm.

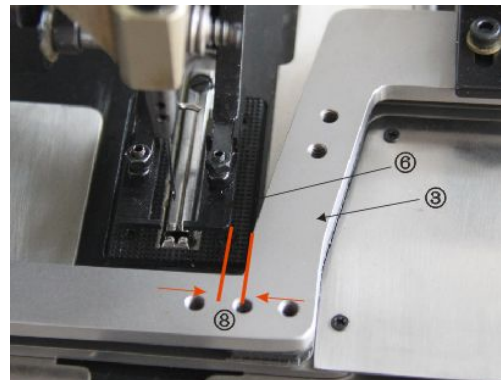
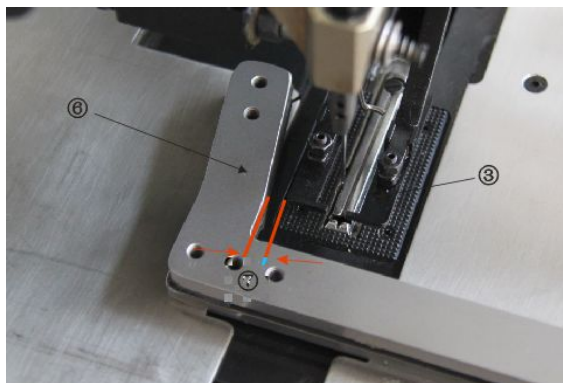
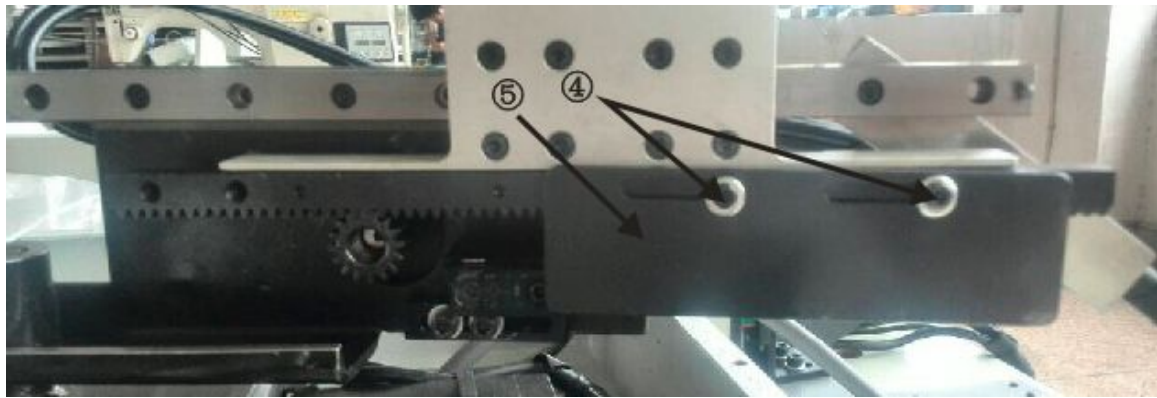
Zero position adjust on X axis. Loose screw (5), move approach switch stand (6) left&right, adjust the distance between fixing plate (3) and needle plate (4). The correct is that the distance between both side is equal (7) (8).



Zero position adjust on U axis. See picture. move the screw (1) to adjust the stand (2), move feeder (3) left and right to adjust the balance.



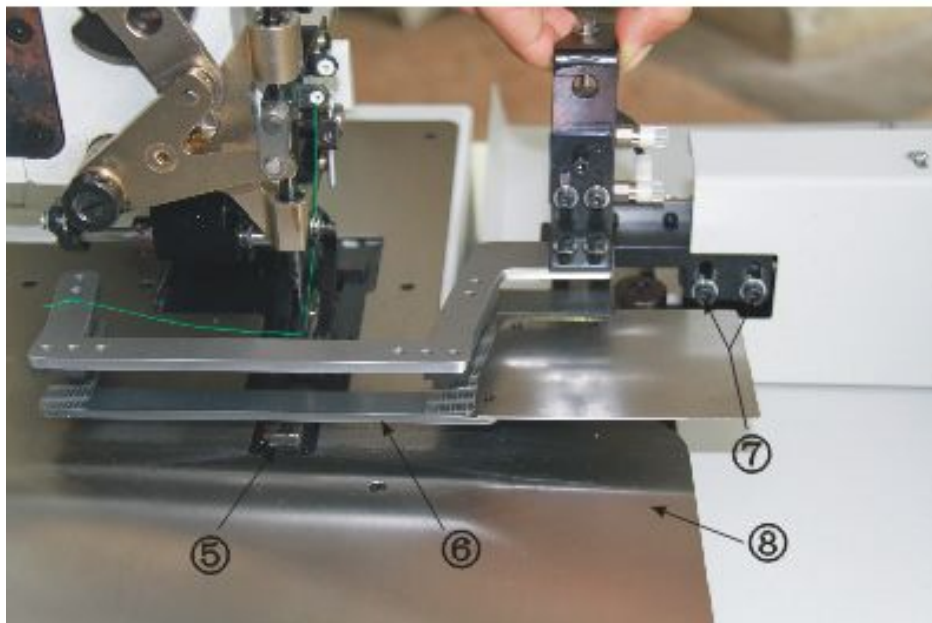
Zero position adjust on Z axis, See picture. Move screw(4) left and right to adjust (5), the both side distances of feeder (3) and small presser foot (6) is equal.



5、feeder

Incline the machine head, align screw bolt (1) to rubber sleeve of positioner(2), roller bearing (3) can be inserted to the automatic feeder stand(4).

Installation of automatic feeder frame. Align slider (5) to (6), keep it parallel with cover (8) and fasten it.
screw



6、looper

Turn hand wheel and observe the position of (1) and (2). Angle (3) has to be equal to angle B (4).

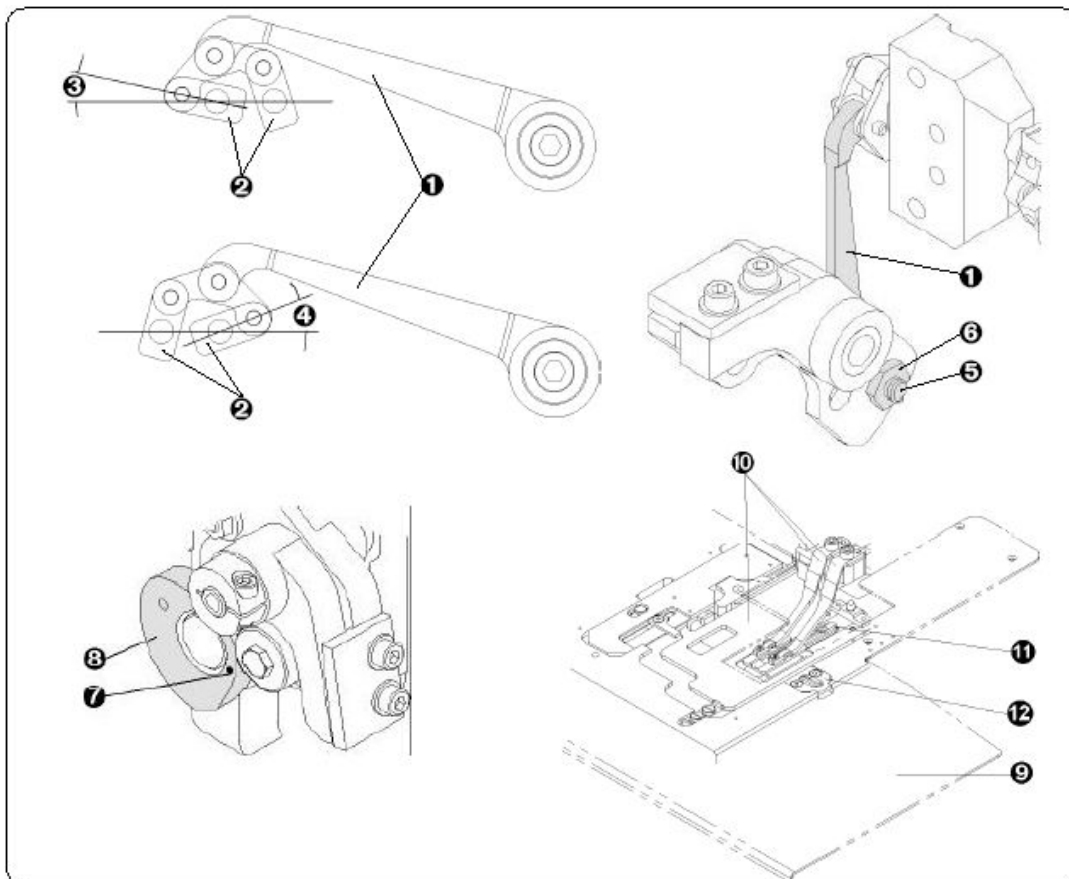
If not correct-loose hexagonal screw (5) and turn adjust nut (6) according to your needs. Fasten hex. screw (5).

Turn hand wheel to rise needle bar to the highest position.

Check if the needle is vertical

Incline machine head to the stopping rod and check the mark (7) on the left of looper cam (8). If the mark is on right, remove and install it again. Make the machine head to the original position.

Remove cover (9), remove air pipe from air cylinder of presser foot and (10), remove needle plate (11), cutting hook cover (12) and the hook. Remove the fixer of looper

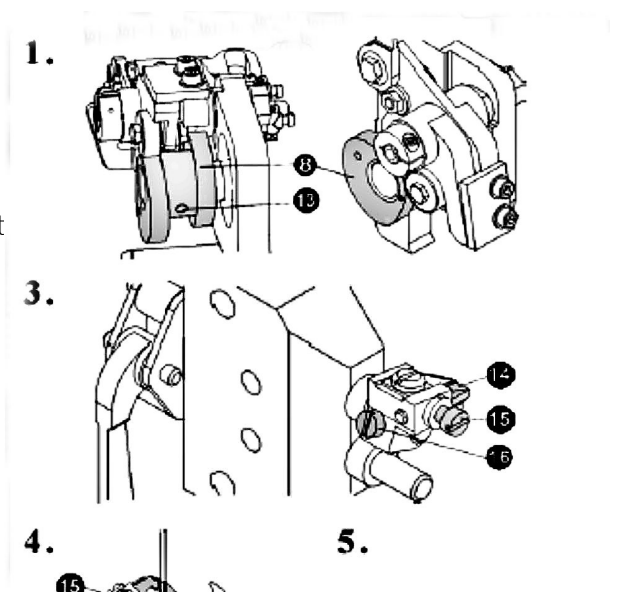


First looper adjustment

Make machine back to standard original Position and loose screw(13)on looper cam (8),adjust the cam to the lowest.

Loose screw(15) and turn looper to make it Be verticle to the hole of stand.

Install first looper(14) and the stand on



The axis.

Loose screw (16) on the stand and move the Stand to make needle through the middle of Denk of the looper. The distance between Needle and the denk must be 0.4mm. Fasten Screw (16).

Loose looper screw(15) and move looper(14) To make the distance between needle and Point of looper to be 0.1mm.

Turn hand wheel and (17) in anticlockwise, When the needle back to standard original Position, there should be a mark 1 between The fixer of needle bar and the clamp. (the Broader side)

Check and confirm the point of looper is

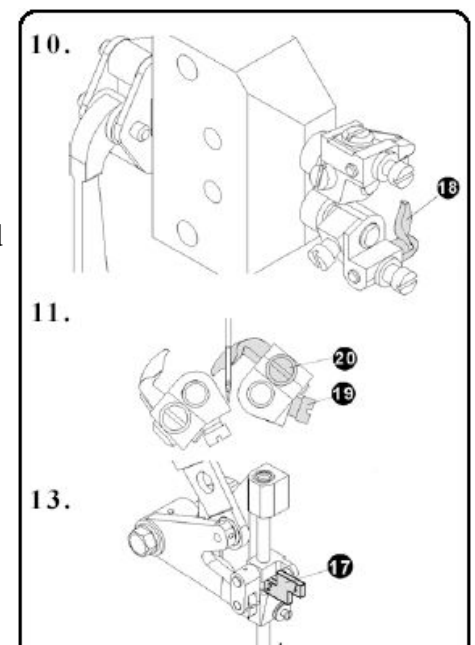
If not correct—loose the screw(13) on looper cam and fix it. Turn handwheel (in anticlockwise way, if the looper point is more than 1mm above; turn it clockwise way, if the looper point is less than 1mm above).

If need another adjustment to looper cam, check the distance between the needle and looper denk is 0.4mm.

second looper adjustment

Install second looper(18) on the axis

Loose screw(19) on looper stand and move the stand T make the needle through the middle of the denk. The distance between the needle and looper denk Should be 0.1mm. Fasten screw.

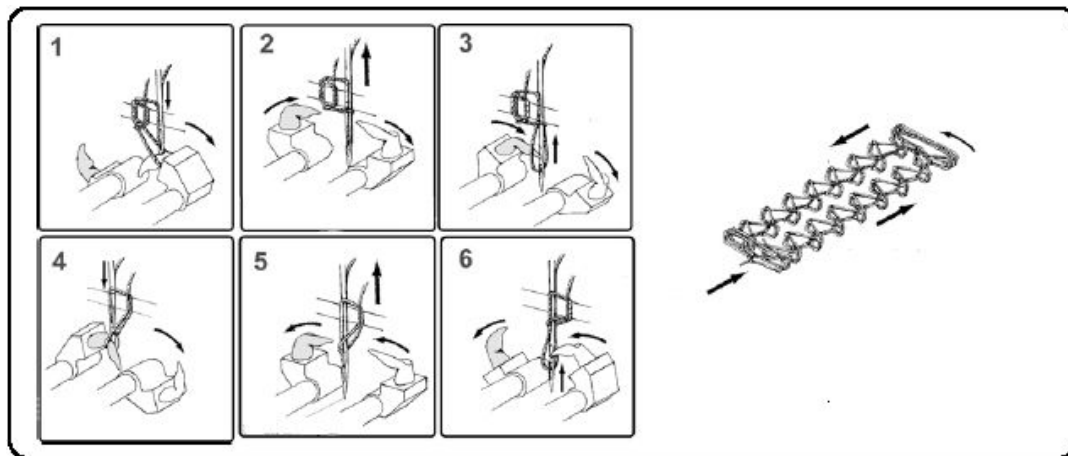


Loose screw(20) and turn looper(14) to make the Distance between needle and looper be 0.1mm.

Turn handwheel and (17) in anticlockwise way,
There is a mark 2 between the fixer of needle bar
And clamp. (the shallow side)

Check and confirm the point of looper is 1mm
above the needle hole.

If need another adjustment for looper cam, check the method of first looper.



7、 rest line

(1) adjustm the position of the rest line rod

Adjust correctly to ensure that there is enough line rested to make the next buttohole. The adjustment device is on the back of the machine head, which should remove the back cover before adjusting. The air pressure is needed during the adjustment.

Loose screw (6)

The plunger(7) of cylinder(8) is on standard original position. Move draw bar(9) to (10) and the distance would be 0.1mm. Fasten screw(6)

Rotate cylinder (11) (YV1) and check the distance.

(2) adjustment of the rest line

If the first thread can't make the buttonholes, please adjust as the following procedures:

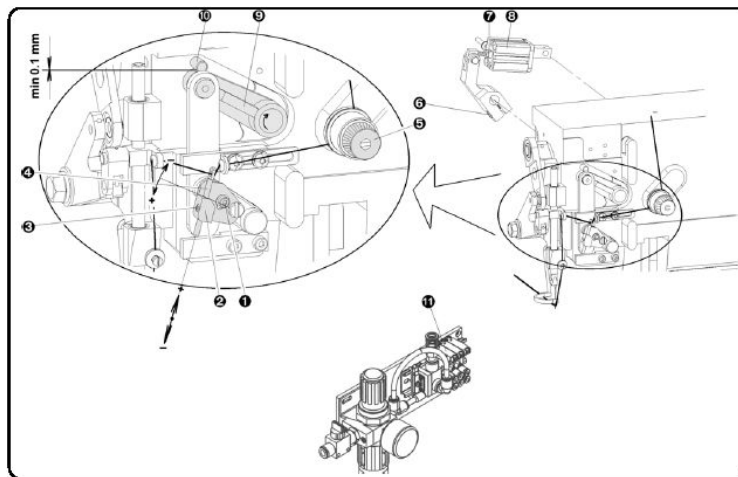
Turn the rod of rest line (2) in anticlockwise way to increase the length of the rested line. (anticlockwise way is decrease the length).

(3) fixing stitches

If there are stitches jump during the sewing, please adjust as the following procedures:

Loose screw (3)

Move the thread holder to increase the size of thread cycle.



8、thread clamp

The tension of thread effect the quality of buttonholes directly. If change the thread or fabric, the sewing tension should be changed also. Check the related thread sewing devices and confirm the thread is smooth without burrs.

Turn tension key clockwise to increase the tension of thread.

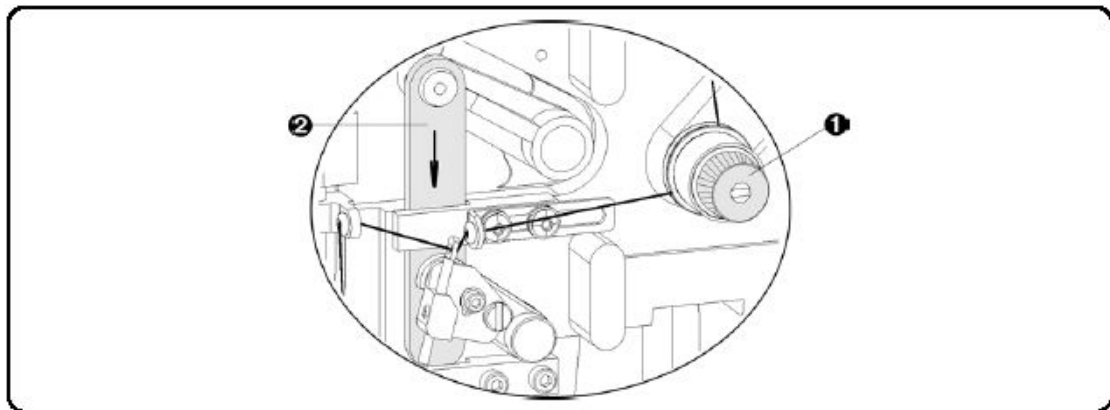
Turn tension key anticlockwise to decrease the tension of thread.

Warning: when the fabric is thin or elastic, it would effect the quality of buttonholes if the adjustment of sewing tension is too big.

(1) adjust the pull plate to open

The pull plate open means the machine is ready for sewing the second stitch line. The following would be possible when the plate is open:
When the rest line rod (2) receive the control attack, machine sews in the axis line.

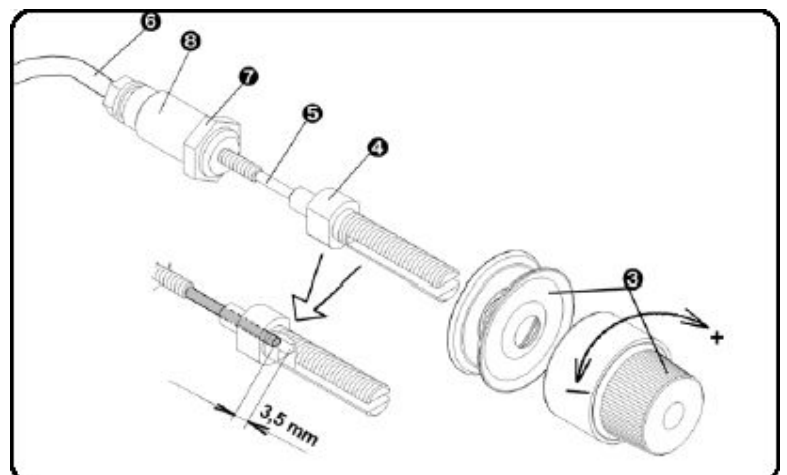
Decrease or increase the air may leads to the last line cycle of the buttonhole over loosen.



(2) Correct position of pull group

Remove pull group (3) from axis (4)

Check the distance between plug And the bar is 3.5mm. If the Distance is not correct, please Readjust the position of the bar. Remove pulley cover and machine head cover to adjustment. Cancel



the air supply.

Remove the air supply of cylinder pipe(6)

Loose nut (7) and turn cyliner (8)as you need. Rotate the bar in clockwise way to increase the length until to the correct length, after that, fasten the screw.

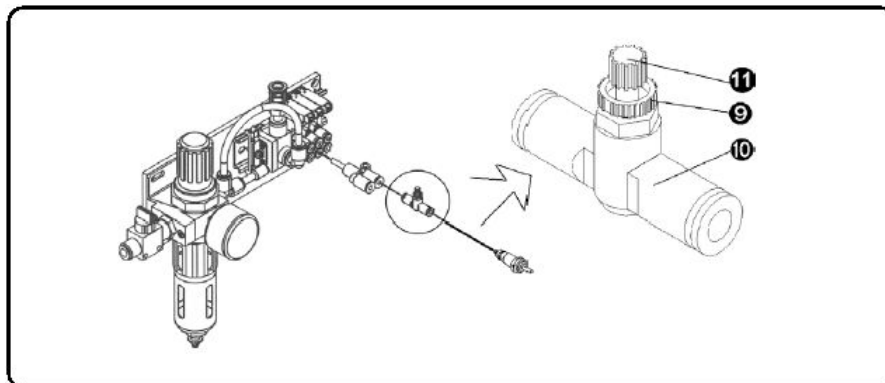
Connect pipe (6) correctly to cyliner, and connect the air supply and install the cover again.

(3) adjust the open status of the pull plate

if the last stitch is too loose, please adjust as the following procedures:

Loose the nut (9) on the speed controller (10)

If need to readjust the tention of the last stitches, fasten screw(11) and nut (9) .



9、 thread cutting

The cutting group ensure the correct threading after the last stitch sewing. The cutting hook moves according to the arrow by pulling forward two thread cycles A and B. When the thread hook reaches to the end, A touch the cutter for threading.

(1) adjust the cutting cylinder

Incline machine head to the position bar and close the air supply. stretch piston (1) of cyliner(2) to the end.

Check that cylinder doesn` t push connected rod(3) too high, touching to the cover (4) of machine board. If there`s no distance, please adjust as the following procedures

c. d. e

Loose screw (6)

If need to reach the correct position of pull rod(3), loose nut(5) and turn the cylinder piston(1) as you need.

Fasten nut(5) and screw (6). After the adjustment, check there`s no distance on the axis(7).

if there`s distance on the axis, loose screw(6), move axis (7) to the end left to fix(8) on the denk of touching board (3).move the rod to the end right and fasten screw(6).

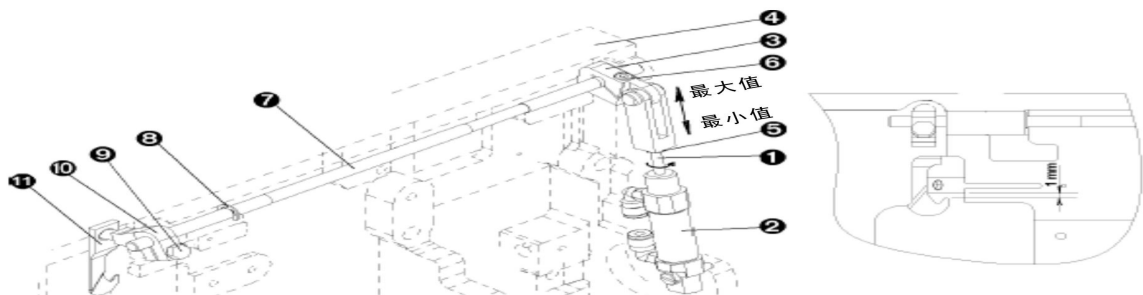
(2) adjustment of cutting hook (11)

Push the piston(1) of cutting cylinder(2) to the end and loose the screw(9) of threading adjustor(10).

Turn threading adjustor(10) and set the distance between needle plaet and threading hook as 1.0mm

Fasten screw (9) of threading adjustor(10)

Start pressure supply and check the keys of threading cylinder to confirm the threading adjustor (10) doesn`t touch the cover of machine board.



10、adjust the presser foot of machine head

(1) adjust the height of presser foot

Start pressure supplier and open the presser foot.

a、Turn nut (1) b、Turn screw (2) by clockwise way to decrease presser foot group (3) to presser plate (4).

c、Tighten nut(1).

Notes: the correct height is that presser foot is lower than needle, when the needle is on the original position.

(2) adjust the height of presser foot

Confirm the presser foot is closed. If it's still open, please press the UP/DOWN key of presser foot.

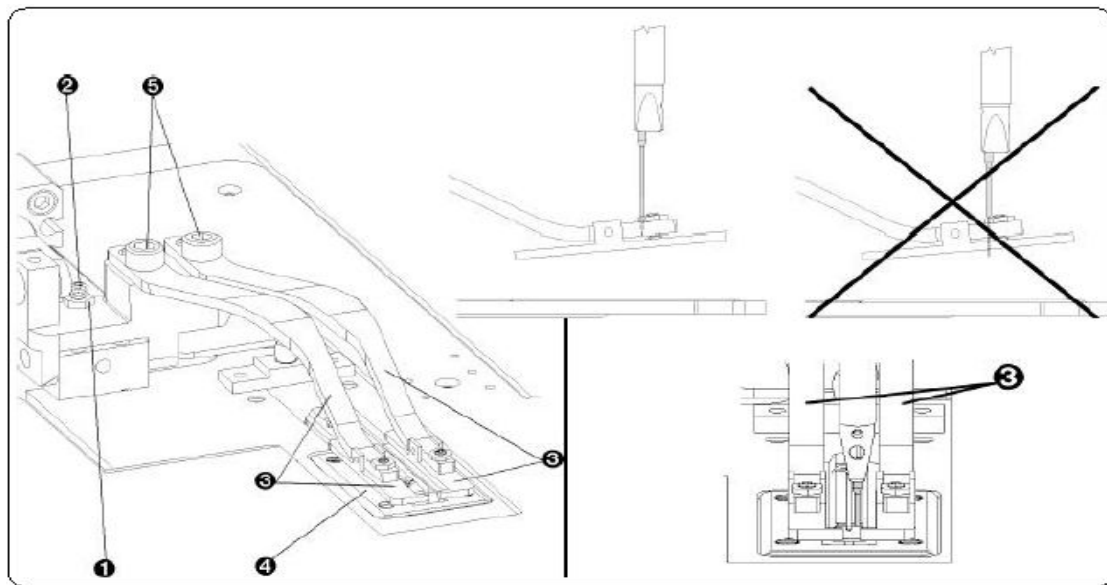
turn hand wheel to confirm the needle doesn't touch the presser foot.

Press UP/DOWN key to open presser foot.

Loose screw (5), move the hand of presser foot to leave needle and fasten the screw.

If need to check the adjustment, turn hand wheel after the presser foot is closed. Needle mustn't touch presser foot.

Notes: before the adjustment, keep the distance between needle bar and presser foot as short as possible. The over distance may leads to the stitch-jumping when sewing on the thin or elastic material.



(3) adjust the pressure

The pressure of

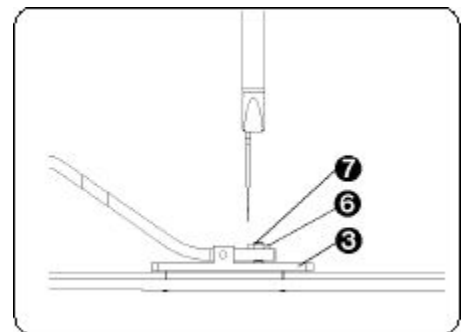
The whole presser foot should be equal

Press UP/DOWN key to close presser foot(3)

Adjust presser foot to the correct position, loose

Nut(8) and screw (7)

Fasten nut(6)



11、change driving belt

(1) Loose M4 screw(2) and remove pulley cover(1)

(2) Turn hand wheel (3) to adjust the position of axis to make the thread (4) of pulley(5) opposite to the screw (6).

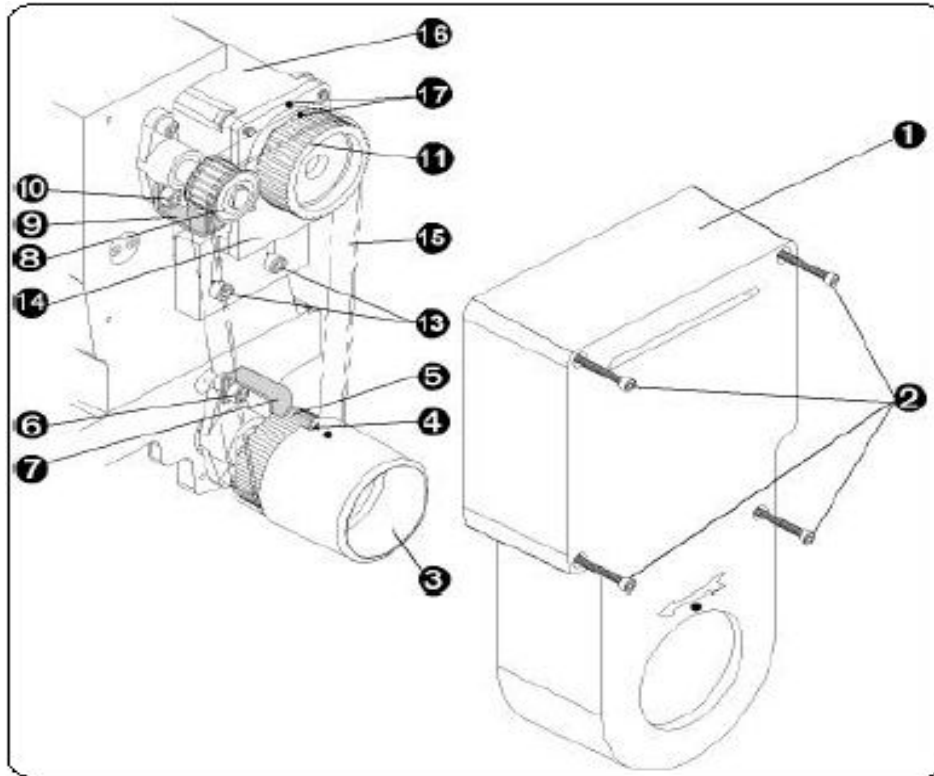
(3) Fix position through fixer 7 (mode:24.0030.0.000) of the accessories. Fix the fixing stand by screw (10)to the screw of bearing driver.

(4) Turn pulley(8) of neele bar bearing until the needle bar to the highest.

(5) Fix position through fixer 9 (mode:24.0024.0.000) of the accessories. Fix the fixing stand by screw (10)to the screw of bearing driver.

(6) Turn motor pulley (11) to the mark (17) on the pulley and keep the stand of motor opposited.

- (7) Loose screw (13) on motor stand (14) and move motor down and stand to fit the belt.
- (8) Install belt (15) to pulley (5), (8) and motor pulley (11), if need to adjust the belt, move motor stand (14) up together with motor (16). Fasten screw (13) to fix motor stand. Confirm the mark (17) is opposited.
- (9) Remove pulley fixer (97)
- (10) Push foot pedal to check the adjusting position. Needle bar should be on the rising position.
- (11) It is possible to slightly adjust the details of needle bar on the program parameter



maintenance

Warning!!

Check if power wire is broken

Check if safety cover is perfect. If there`s any broken, change it immediately

Do not be close to the operation position of needle

Do not change any parts of machine, the safety group may be effected.

Do not add lights or any other electronic system.

Notes!!

Do not forget to maintain machine as scheduled

If there are any power problems, switch off power supply(circuit breaker) immediately.

Do not break, change or remove the safety label.

Do not operate the machine after alcohol or medicine.

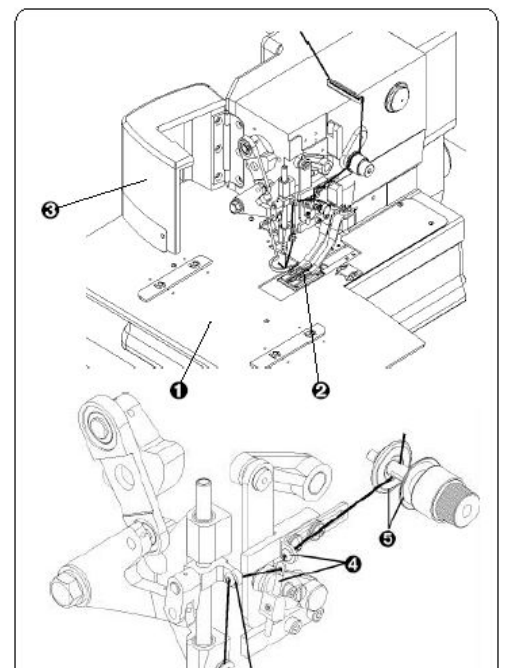
Confirm the working position is 750Luxes at lease

1、 machine clean&maitainance

Close power supply and remove pressure supply

If need to clean and maitain machine, remove Cover(1) and presser foot group(2). Clean the Remains on the position of presser foot.

Open needle cover(3) and clean the remains



from guiding tube(4) to pull plate(5)

Clean the remains on the sewing group(eg:
needle plate, loopers)

Properly lubricate machine according G4

Maintenance of filter and voltage regulator

Check if the voltage is higher than the setting range of the regulator

Check if the valve is clean

Check if the membrane or spring is broken.

Check if the airflow direction is correct

the following situation for changing the filter

- low current
- air pressure decreased largely
- air pressure decreased to 0.7pa
- filter has been used

For more than one year

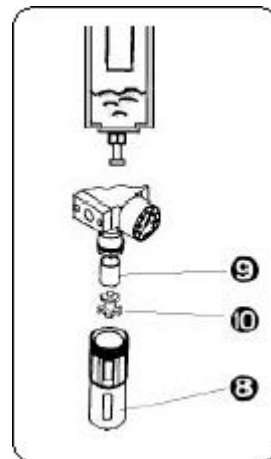
a、 loose regulator cover(8)

remove filter(9)and membrane

b、 change new filter

Install membrane(10) to the new filter(9)

c、 install the cover of regulator back.



Check the group, especially the sewing position

After the maintenace and cheking, install the presser foot group back to machine, then the machine could be back to work.

2、 scheduled maintenance

1time/day(8hrs)

Clean sewing group and
machine inner stand

- add lubrication-see F4

1time/week(40hrs)




- Check inner/out group by eyes

- Add lubrication on
needle bar and sewing group

- Fill up the tank and oil

1time/month(160hrs)

- indicator
- Check distance of the driver of sewing group
- check if the screw is fastened including the valve key
- Check the compressor of the Voltage regulator
- Check remained oil plate

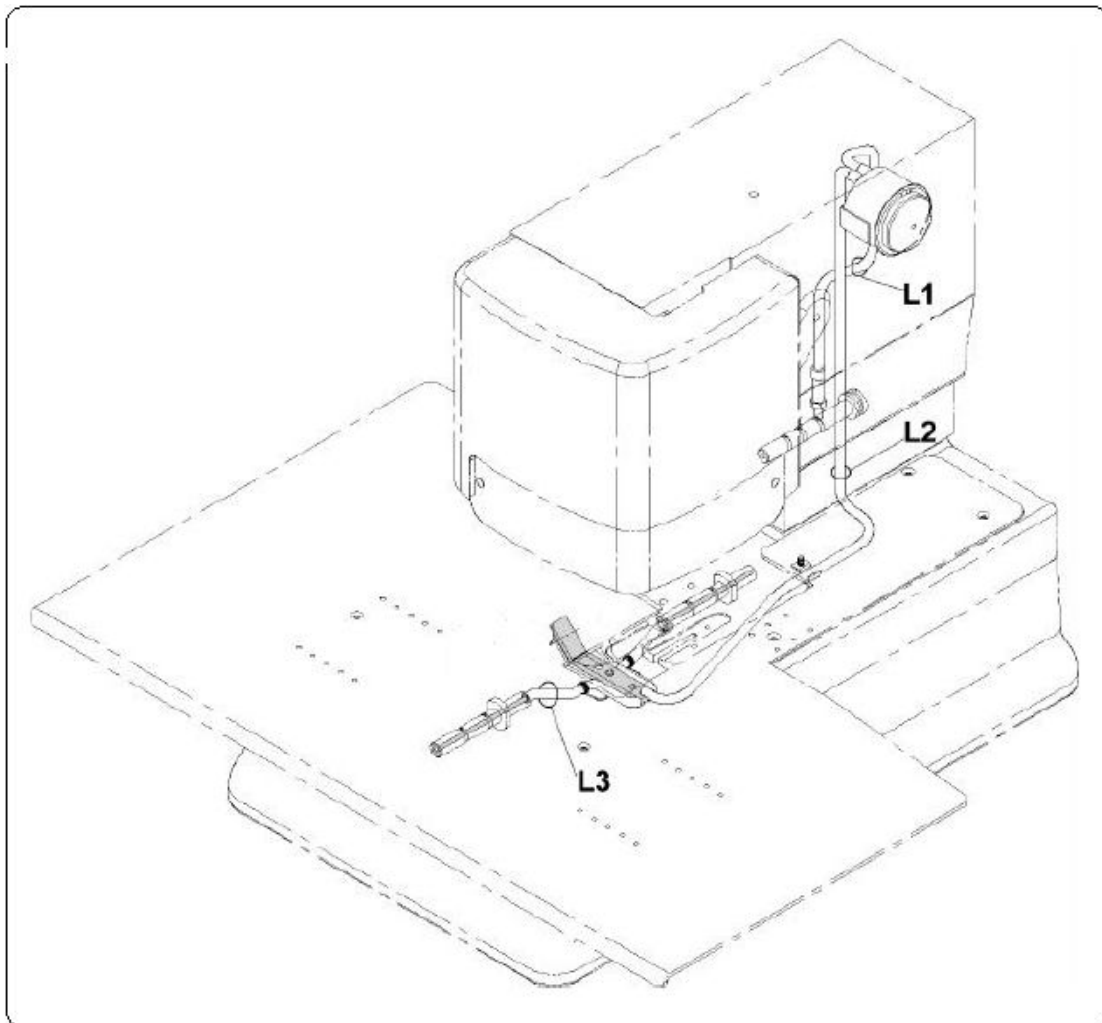
推荐标准紧固件螺丝			
			
M3	0,5	0,6	0,8
M4	1,2	1,5	2,0
M5	2,5	3,0	4,0
M6	4,0	5,0	7,0
M8		8,0	16,0
M10		10,0	30,0

3 distribution of lubrication system

As the needle and bearing are easy to break, there two lubricating systems for oiling recycly to decrease the maintenance
lubrication system—the hand of lubrication reserves oil for lubricating zigzag, feeding,

looper and cam. If need to change the spare parts, it should purchage oil tube and oil line core. If need to connect the oil tube, please see the picture

as below:



4、 machine lubricating system

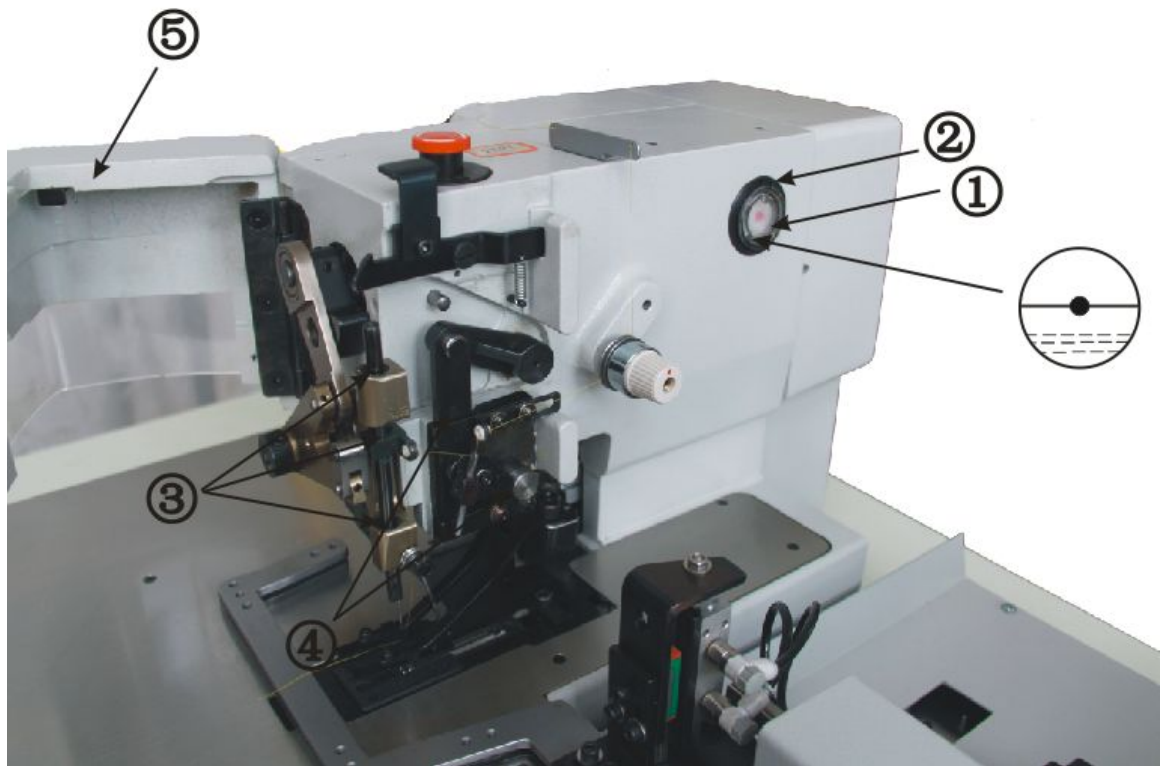
(1) Lubricate the position as below with ESSOTERESS0 32 or similar products before running the machine

(2) Red paint sign on point 1. Too much lubricating oil may cause overflow

(3) Add lubricating oil through point 2

(4) See picture below Lubrication positions of parts 3 and part 4 (remove

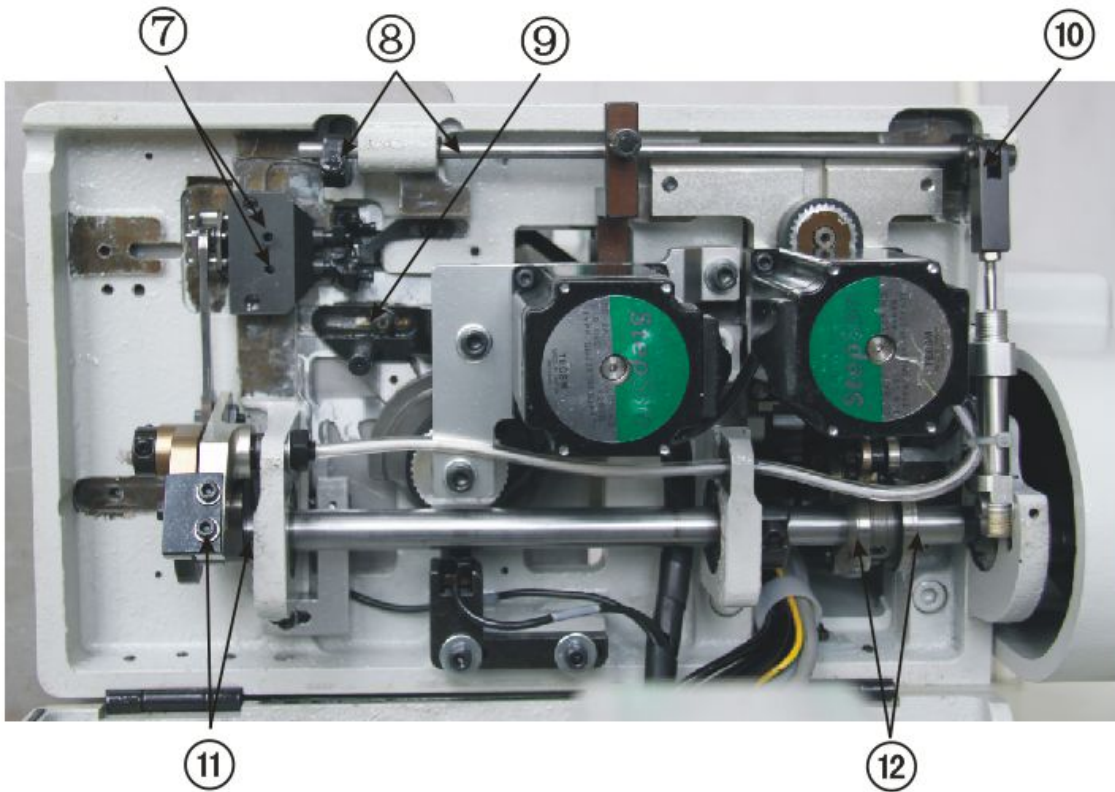
needle bar cover (part 5) firstly). Add lubricating oil for main CAM helical gear through point 6. Lubricating every 8 hours.



5、 See picture below slanting machine head positioning pin and lubricating

- | | | | |
|-----|---------------|------|-------------------------|
| (7) | looper shaft | (10) | adjusting clamping seat |
| (8) | trimmer shaft | (11) | looper CAM surface |
| (9) | sliding block | (12) | herringbone CAM surface |

6、 Sew more than 10 buttonholes on waste fabric to avoid oil spilling after lubricating.



- aluminum parts
- ● nonferrous metal parts
- ● ● plastic and non metallic parts