

C007J.K規格調整

C007J.K Adjustment

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Translator Mo Lin

2014.1.13

1. 針棒高度 The Height of Needle Bar:

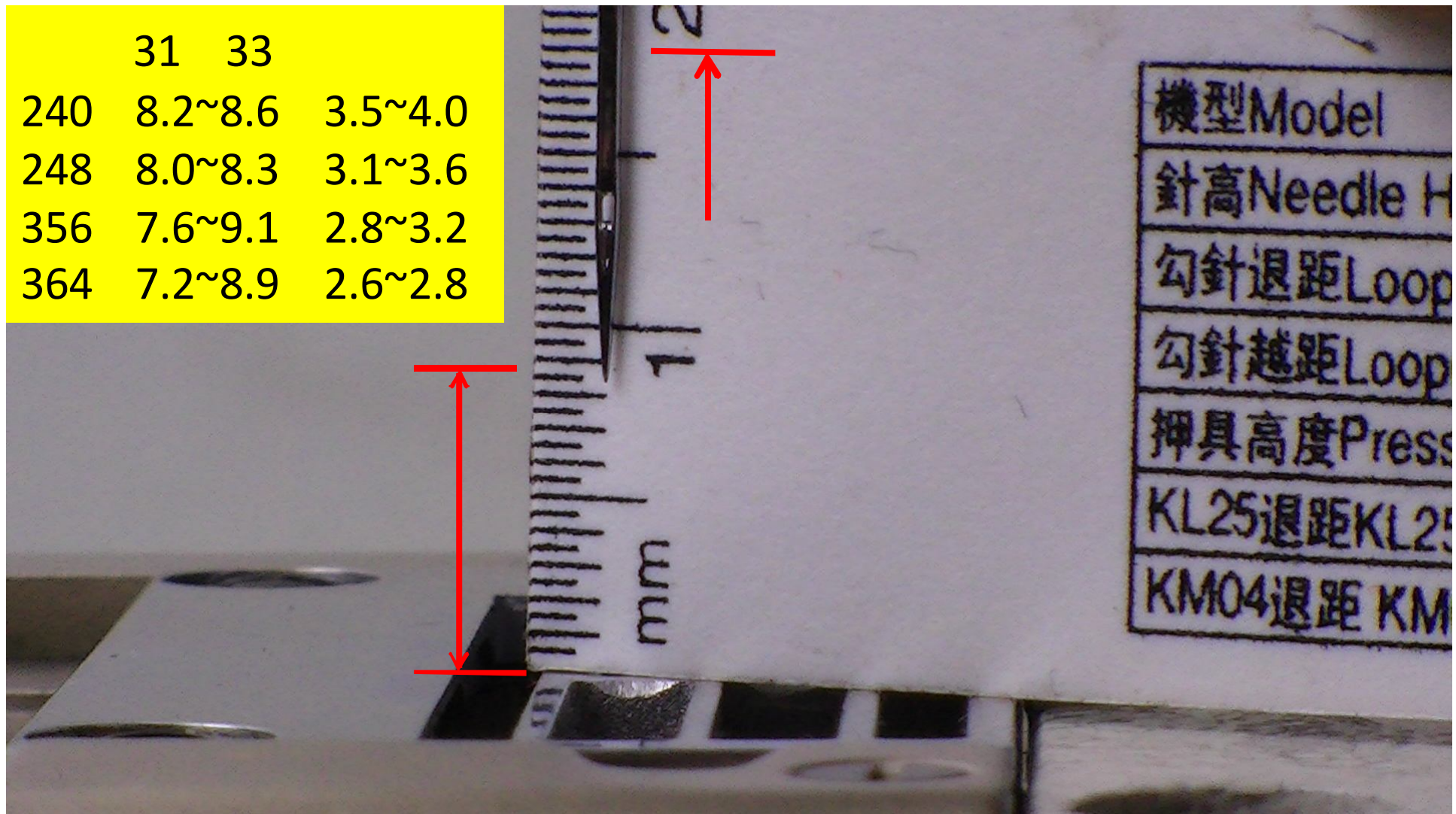
針棒行程:分為2種 31與33

Needle Bar Stroke has two options, one is 31, another is 33.

針棒上始點不動，以第3支針為主，高度為 8.5mm

At top position, the tip of left needle is 8.5mm distance from the plate.

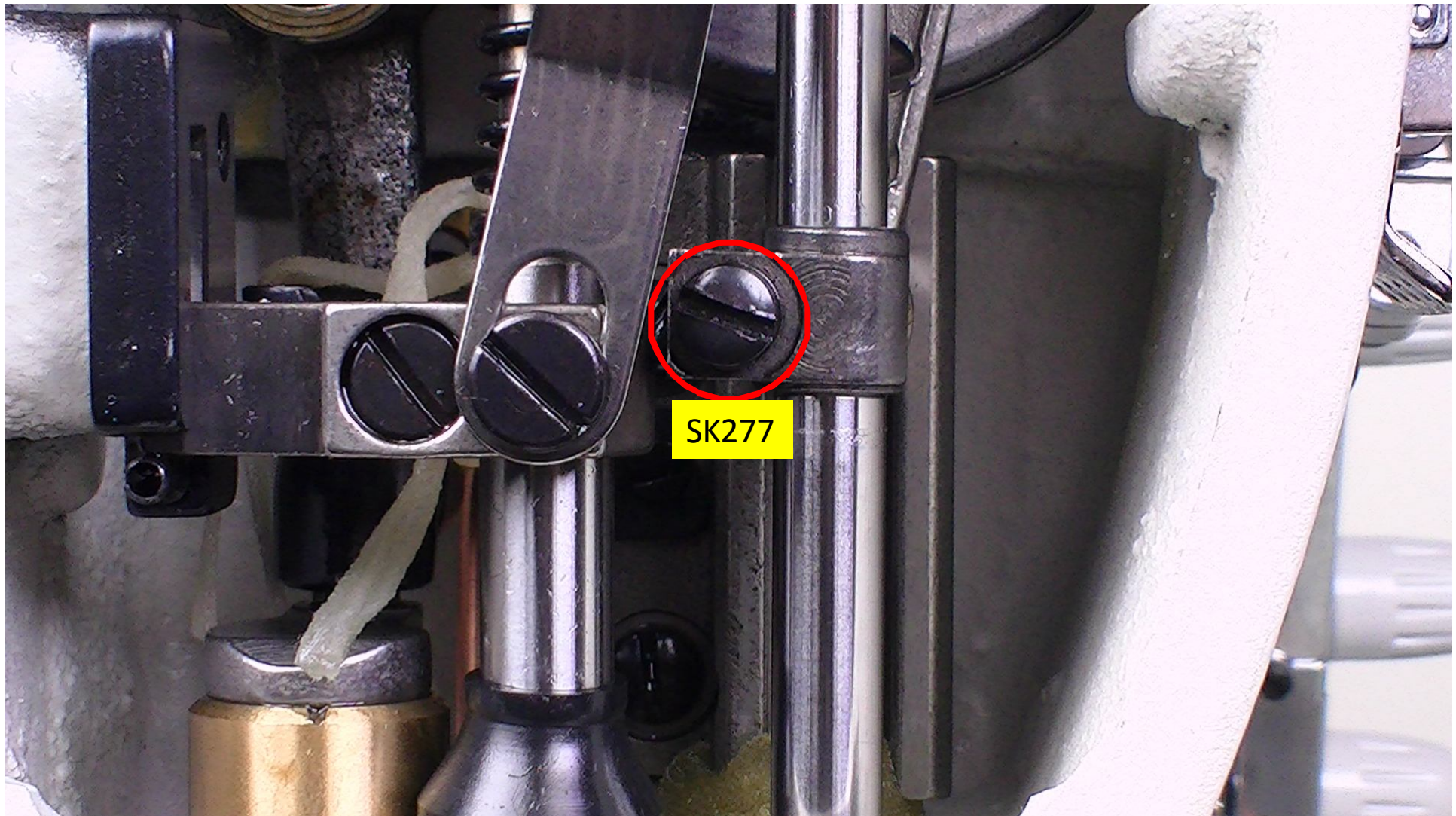
	31	33
240	8.2~8.6	3.5~4.0
248	8.0~8.3	3.1~3.6
356	7.6~9.1	2.8~3.2
364	7.2~8.9	2.6~2.8



1-1

如有誤差放鬆SK277螺絲調整。

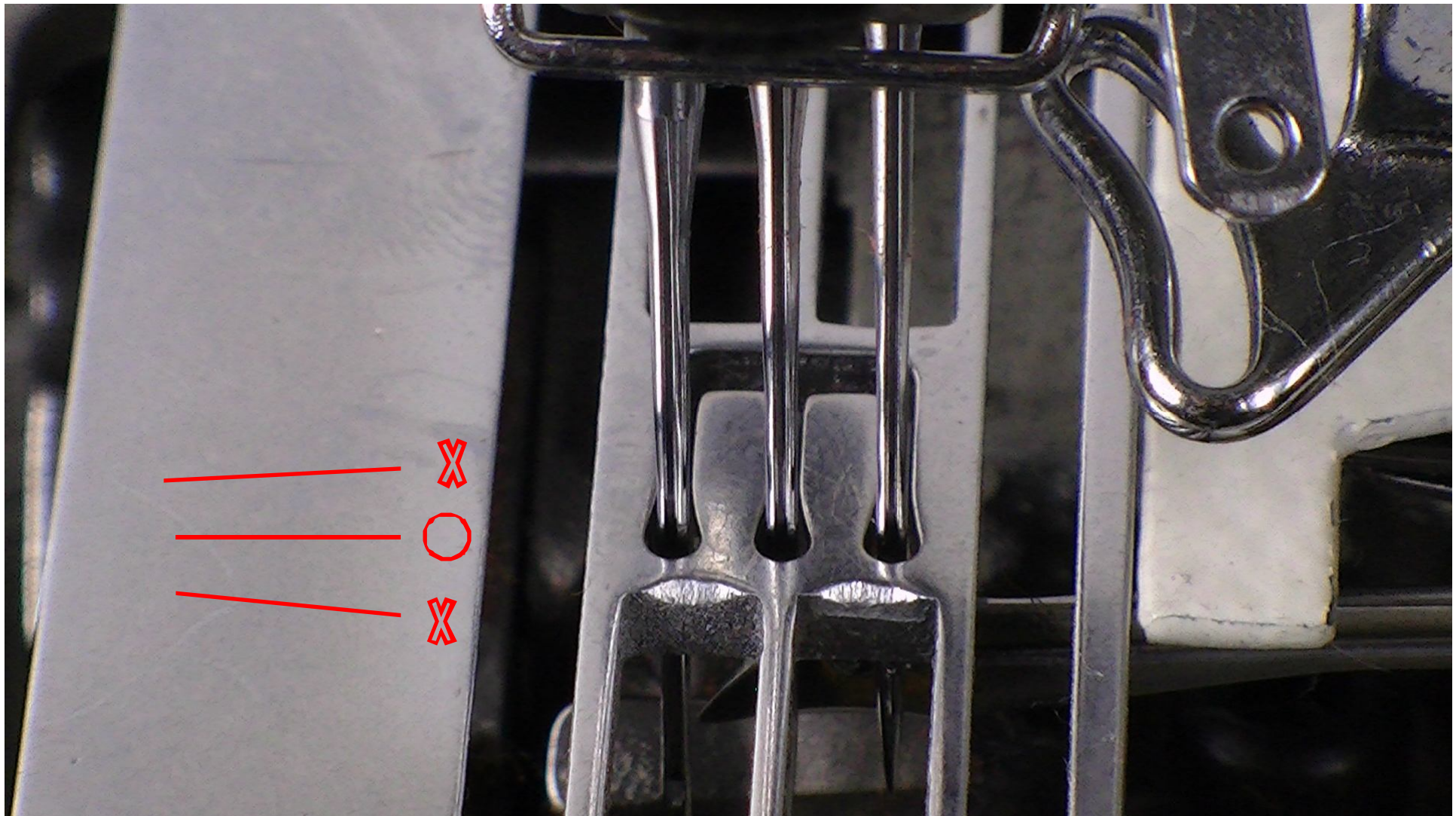
If the height incorrect, loose the screw SK277 for adjustment.



2. 針鉗平行度 The Parallelism of Needle Clamp:

3支針與針板孔前端.間隙要一致。

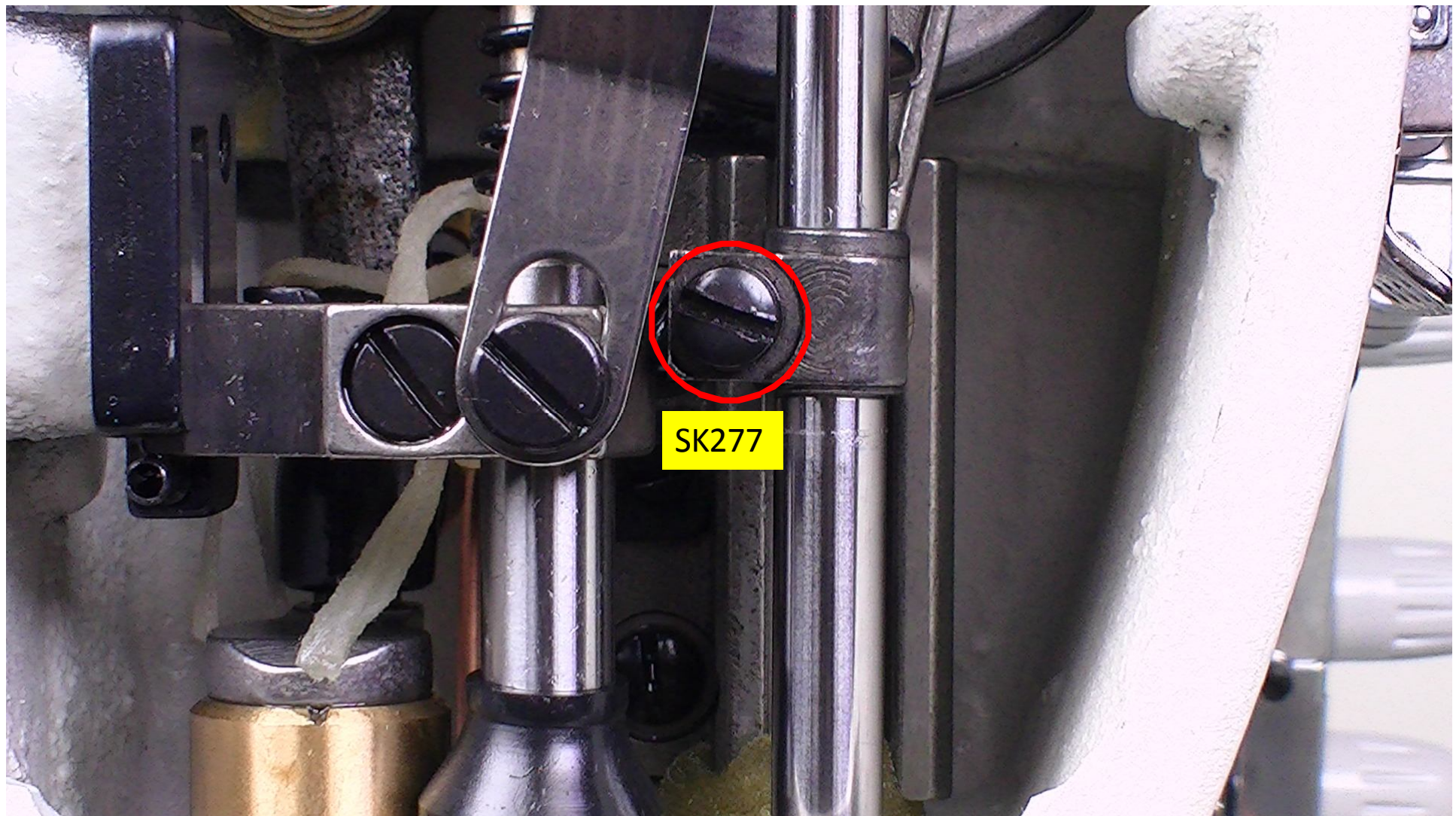
All the needles must be parallel and keep same distance from the front of plate hole



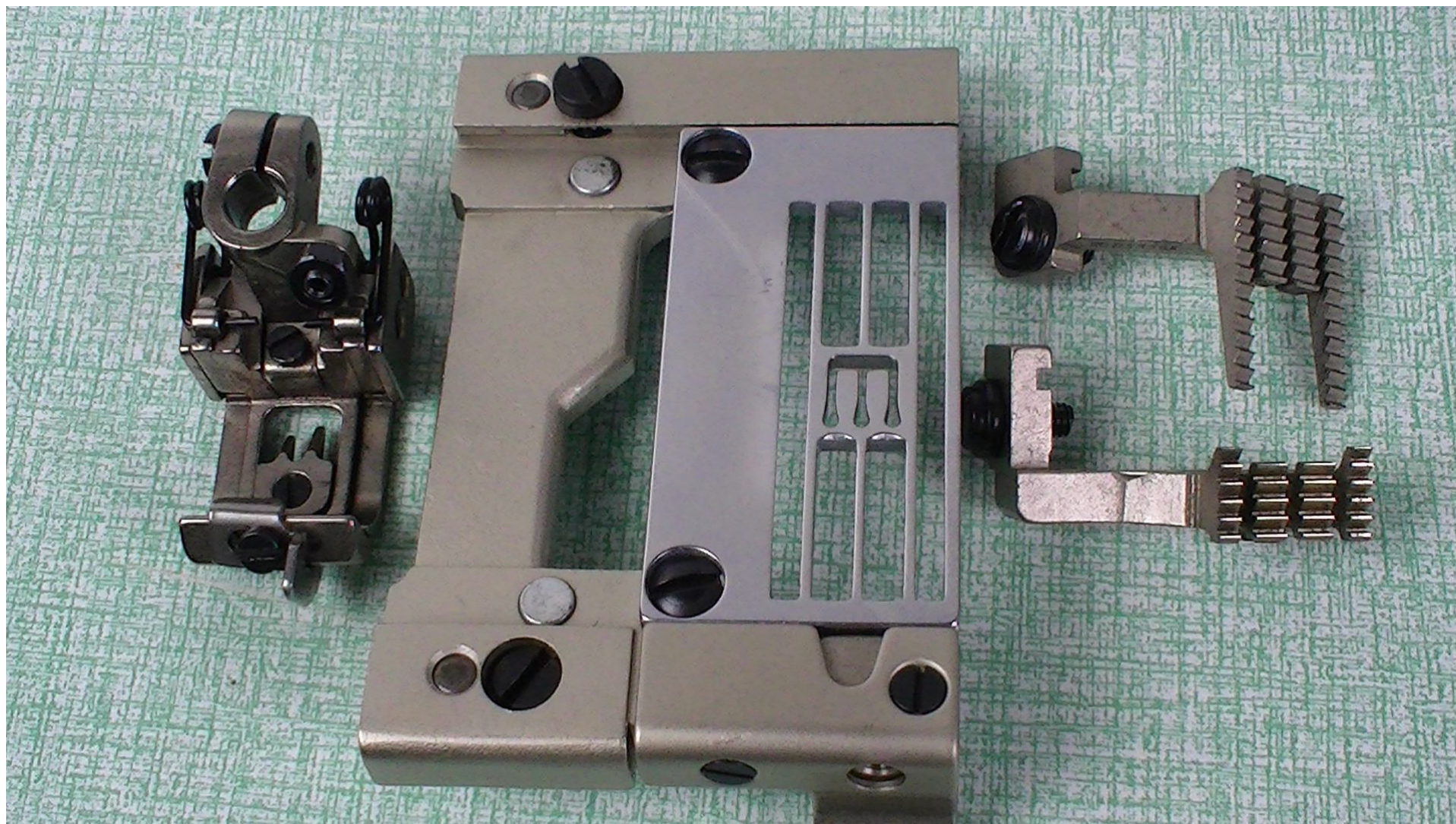
2-1

如有誤差放鬆SK277螺絲調整。

If not parallel, loose screw SK277 for adjustment.



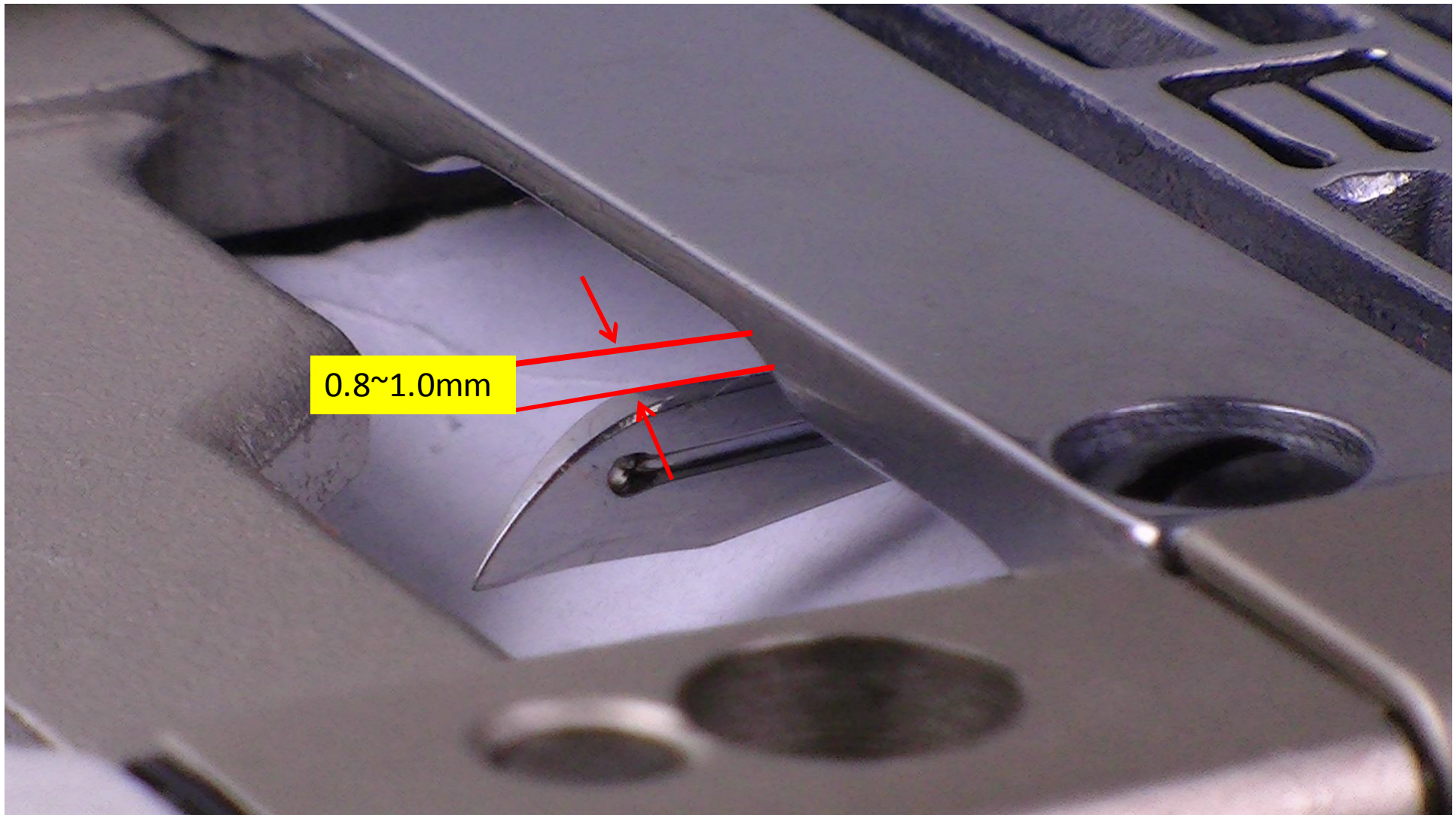
要規格調整前.先拆下壓具.針板座.送具.方可達到更精準調整。
Before adjusting, remove presser foot, plate, feeddog for
accuracy adjustment.



3.針板與勾針間隙 The Gap Between Looper and Plate:

針板與勾針間隙為 0.8~1.0 mm。

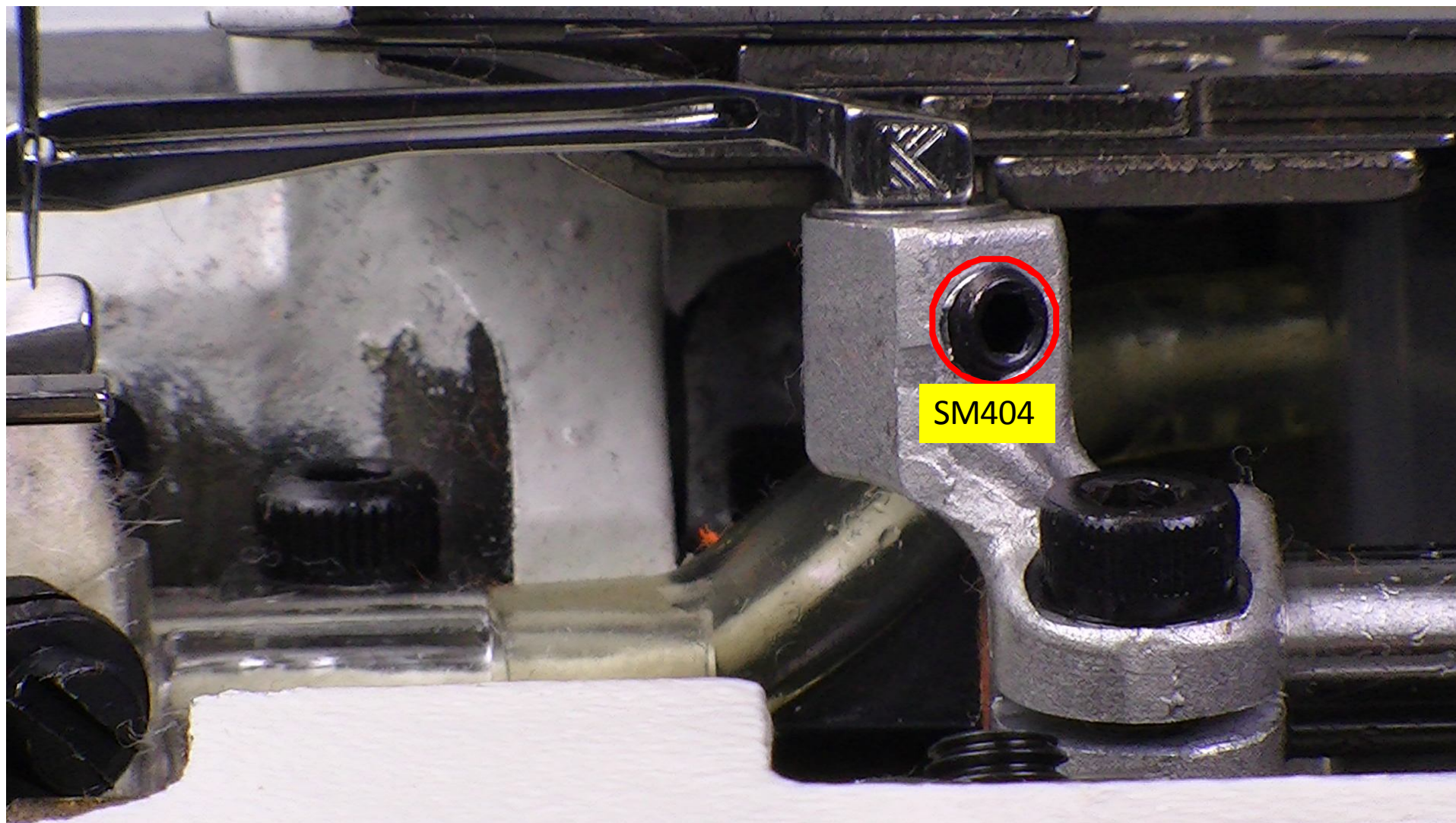
The gap is 0.8~1.0mm.



3-1

如有誤差放鬆SM404螺絲，調整勾針高度或加墊片。

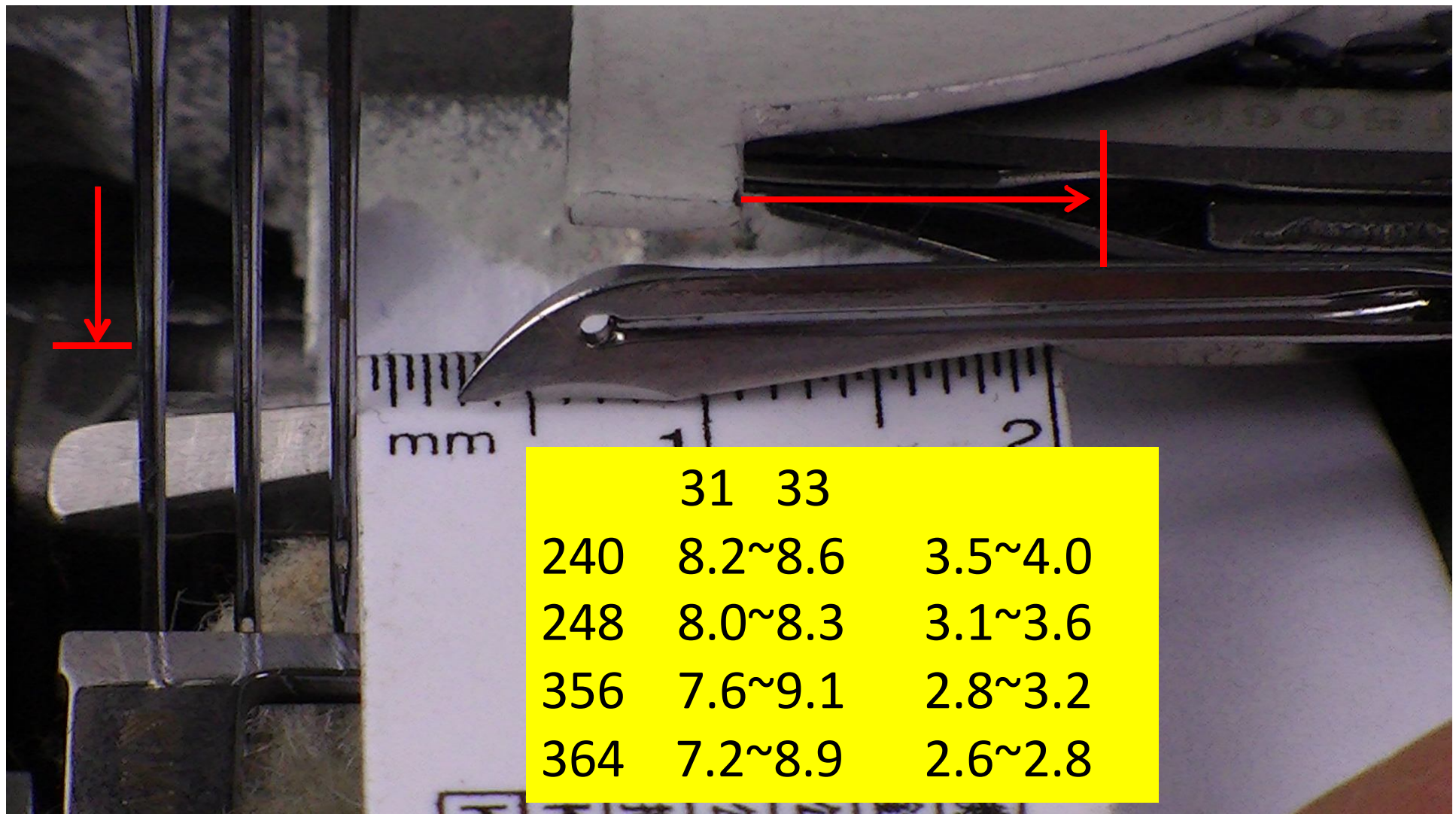
If incorrect, loose screw SM404 to adjust the height, or add spacer.



4. 勾針退距 Looper Start Position:

勾針走至右始點不動，勾針退距為 2.8 – 3.2mm

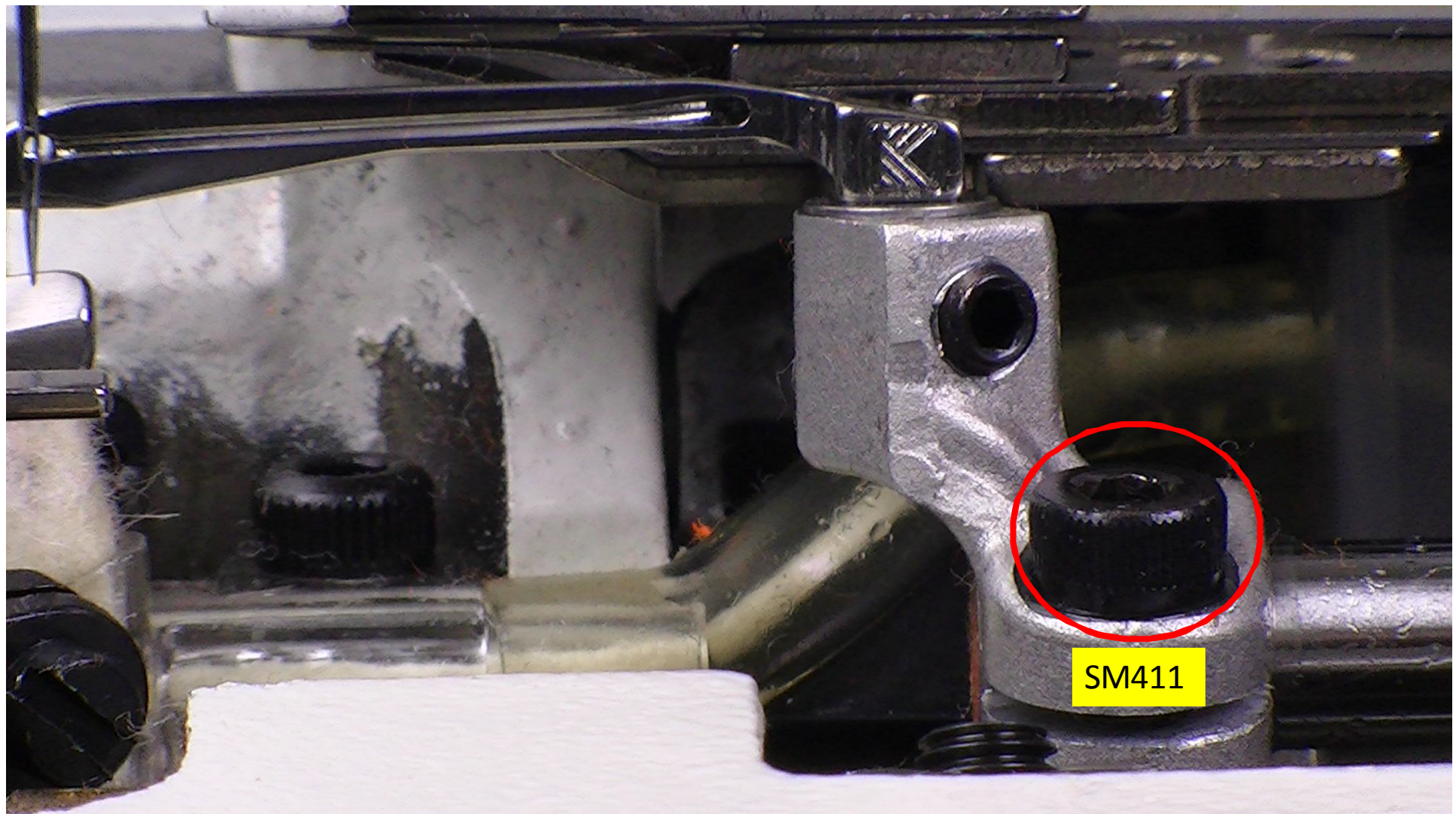
The looper is 2.8-3.2 mm distance from right needle when return to right end point.



4-1

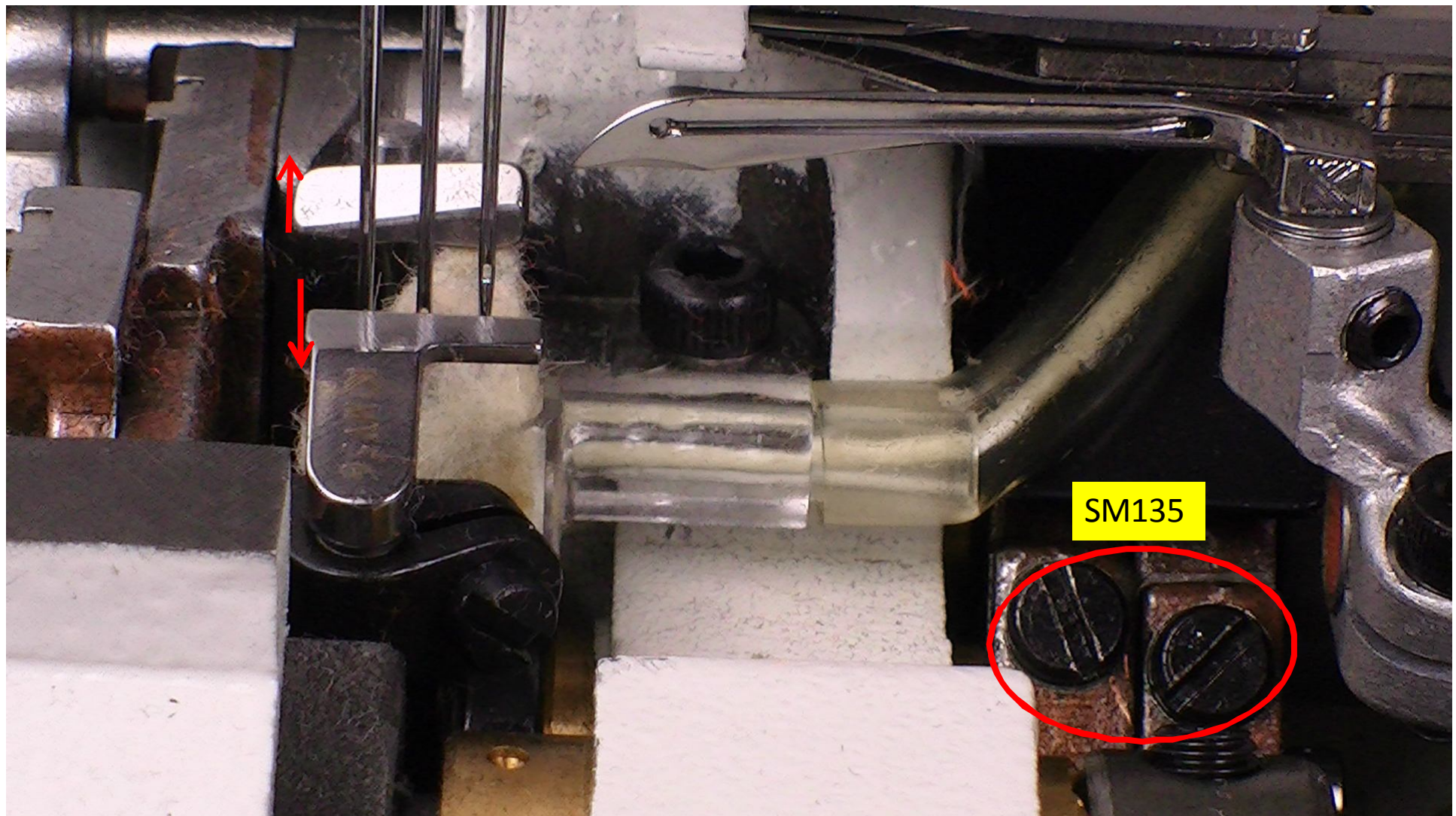
如有誤差放鬆SM411螺絲調整。

If timing incorrect, loose screw SM411 for adjustment.



5. 勾針量 The gap Between Looper and Needles:

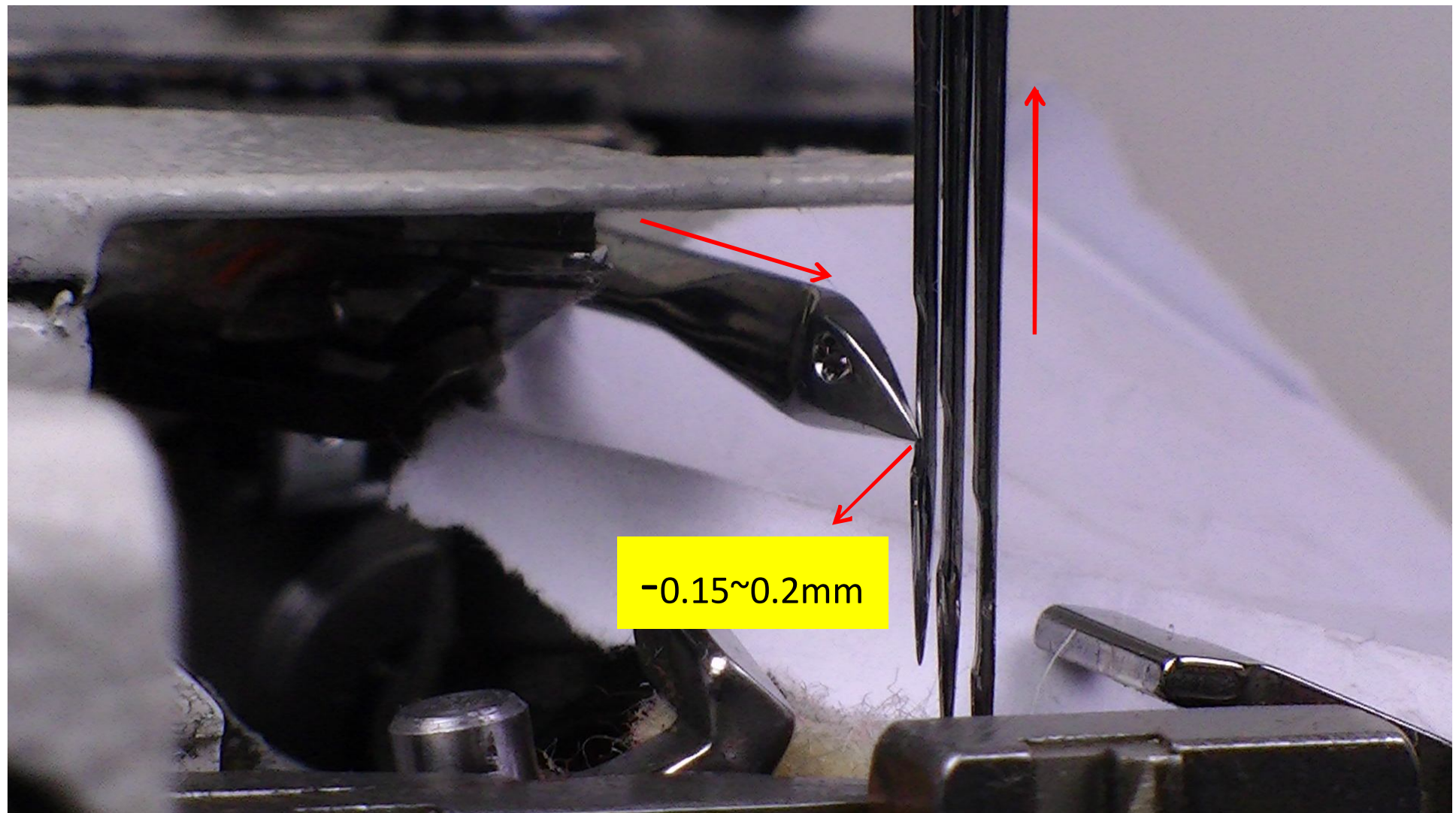
要調整勾針與針的間隙時，一定要先放鬆SM135螺絲，方可更精準調整。
First, loose screw SM135 for adjustment.



5-1

第1支碰針為 $-0.15\sim 0.2\text{mm}$

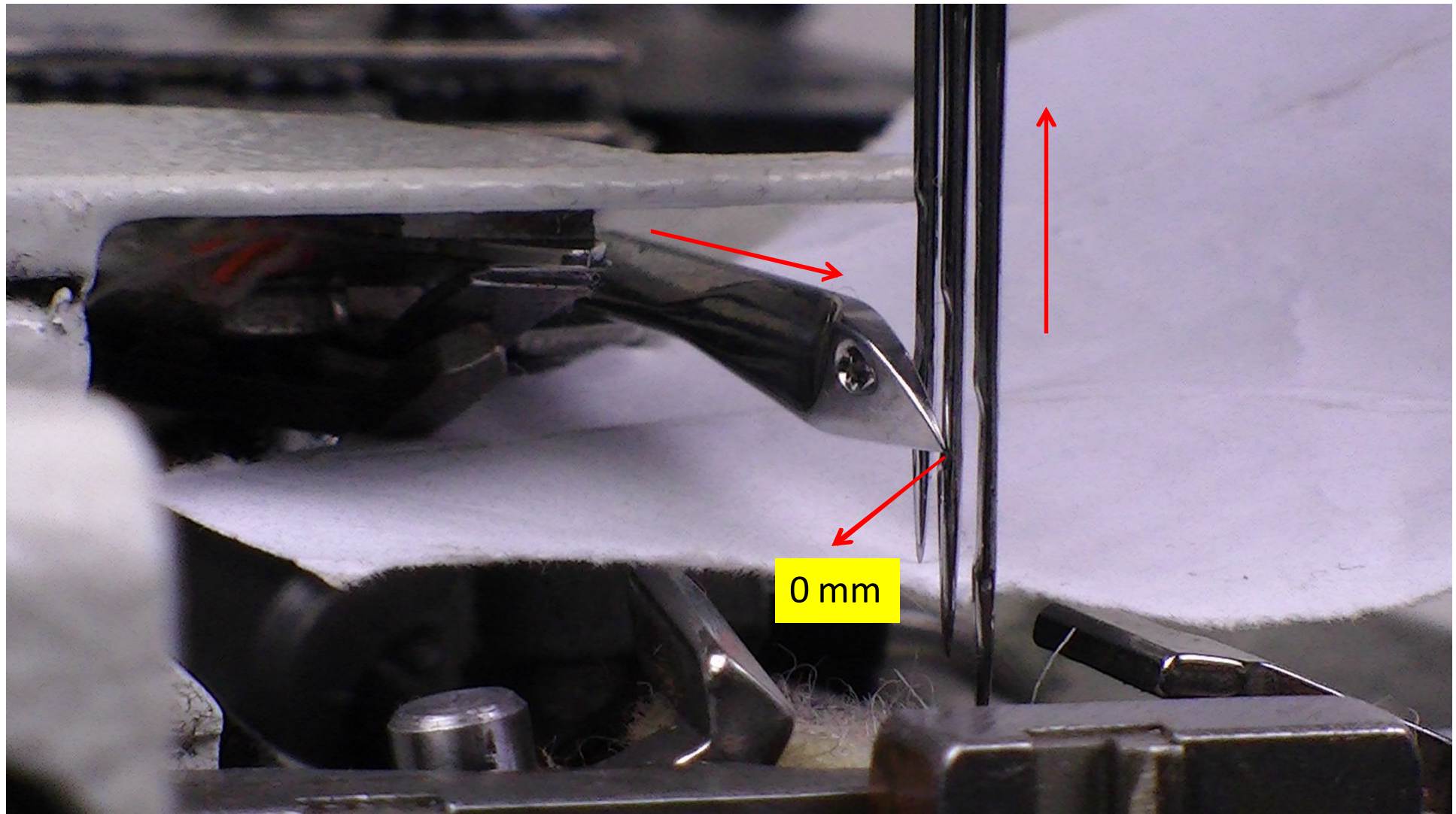
The first needle is $-0.15\sim 0.2\text{mm}$ distance from looper.



5-2

第2支針間隙為 0mm。

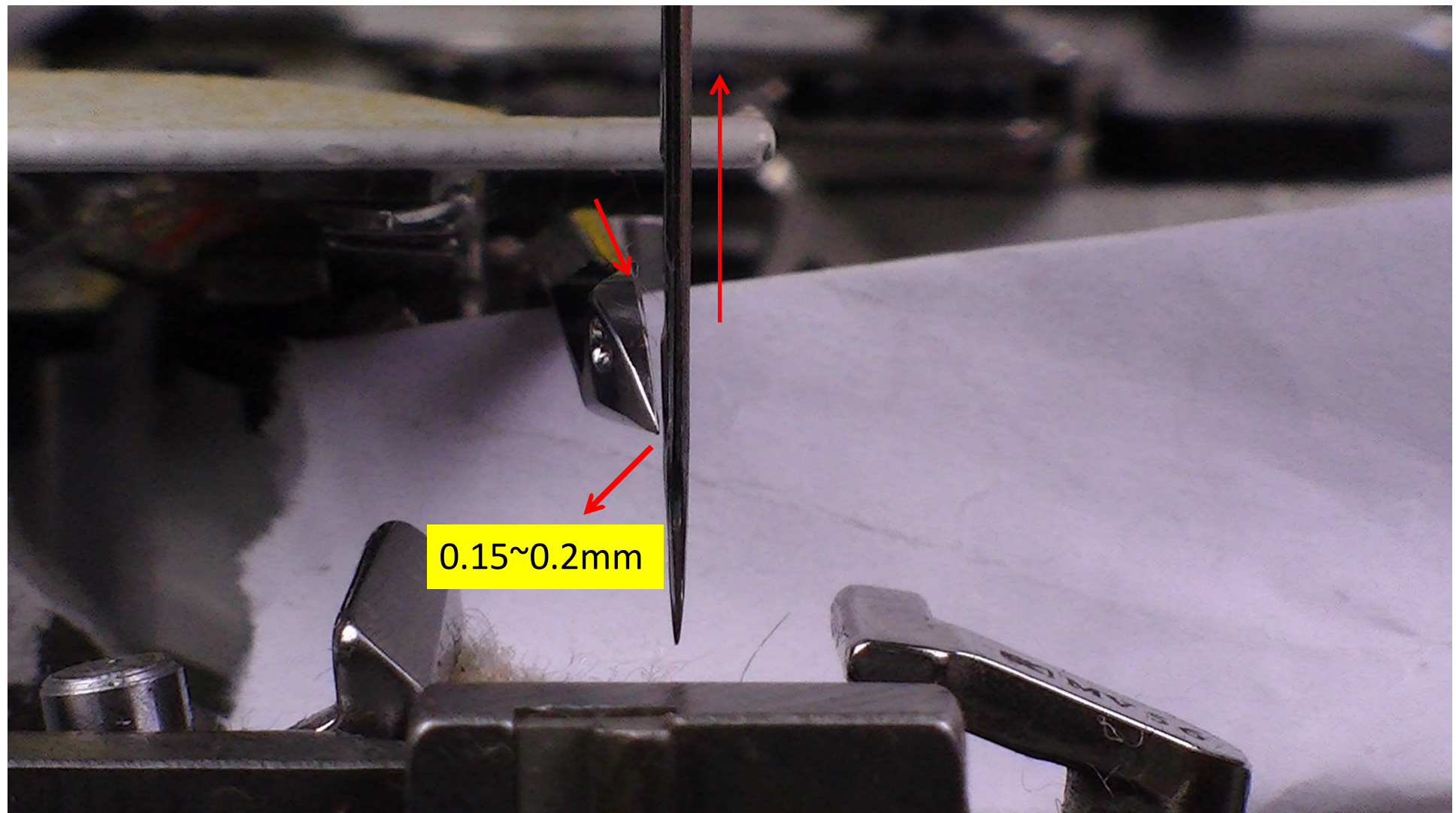
The middle needle is 0mm distance from looper.



5-3

第3支針間隙為 0.15~0.2mm。

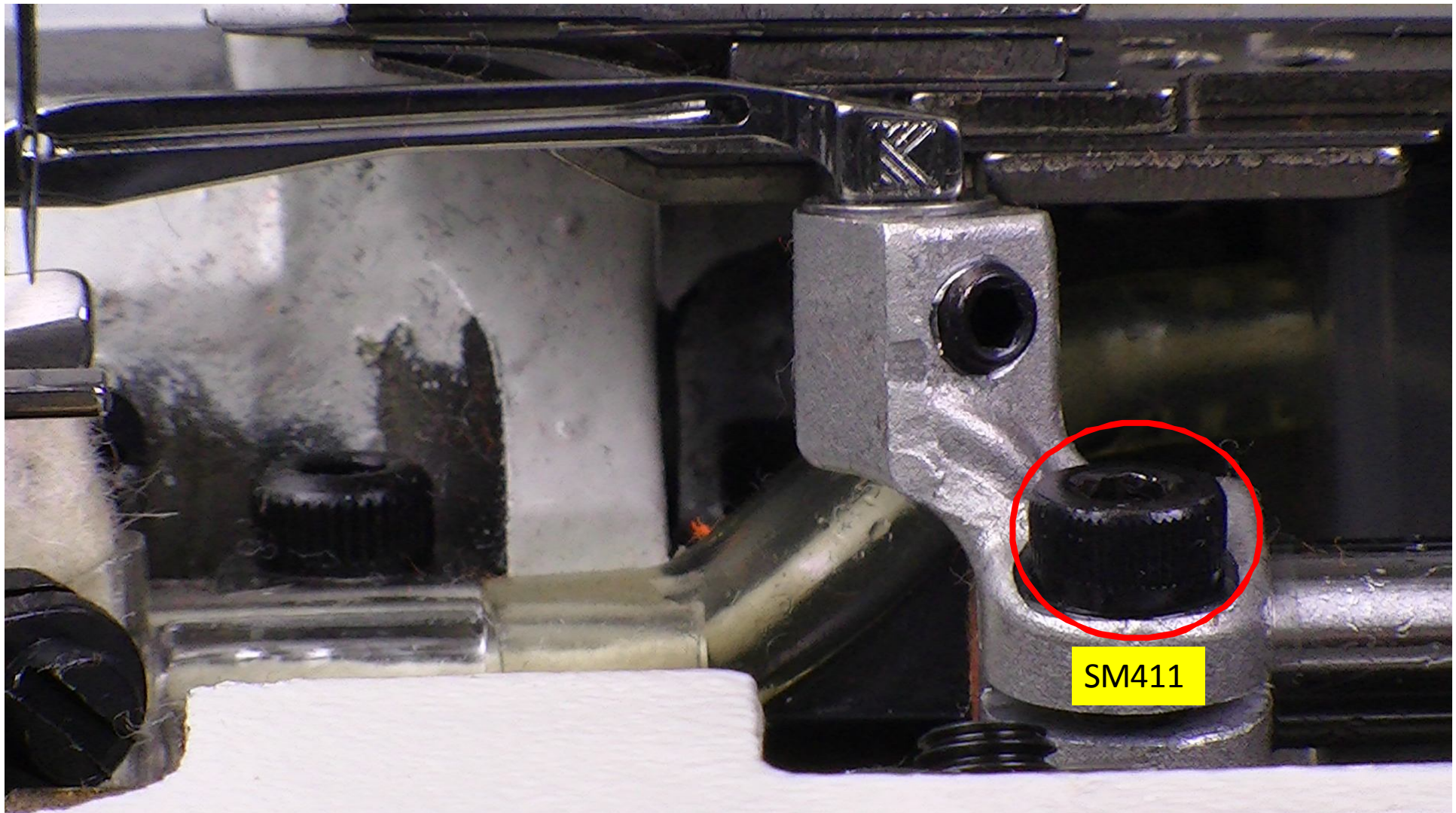
The third needle is 0.15~0.2mm distance from looper.



5-4

如有誤差放鬆SM411螺絲調整。

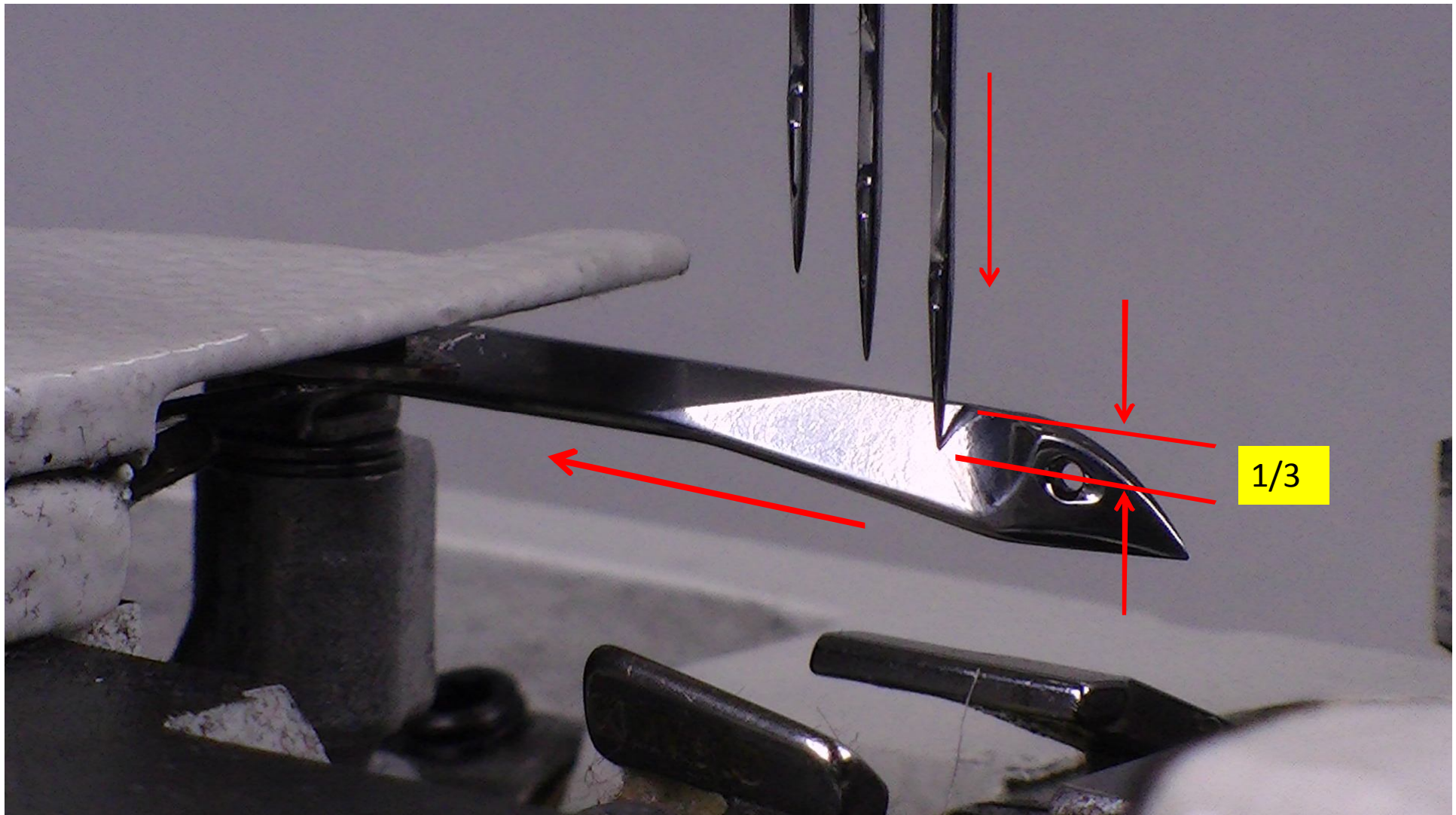
If incorrect, loose screw SM411 for adjustment.



6. 叉背點 Tip, Looper Encounter Position:

第3支針，針尾接觸勾針背1/3。

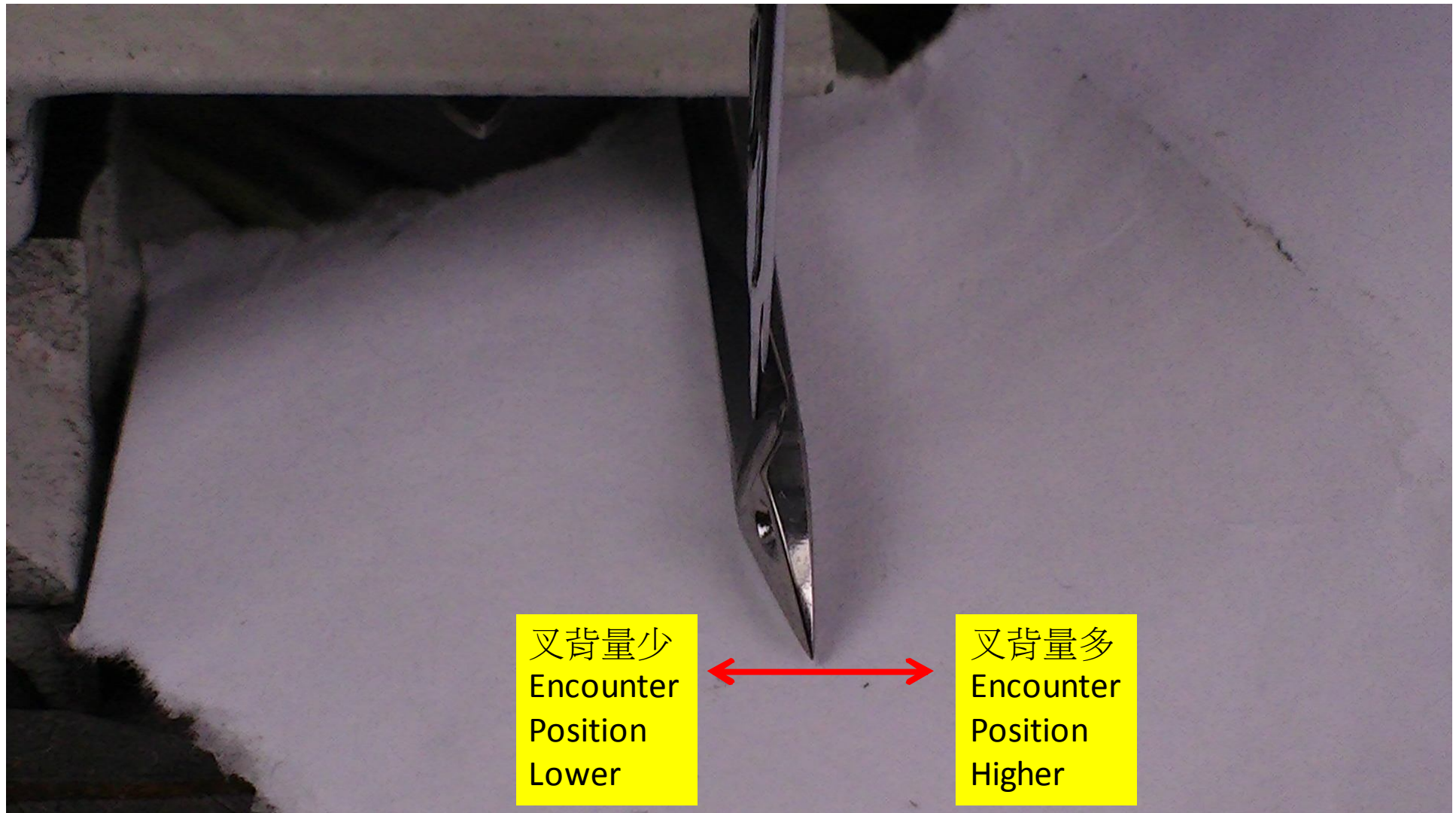
The position of third needle is just at the 1/3 of looper when needle tip encounter the back.



6-1

可放鬆SM404螺絲，調整勾針角度，在鎖緊螺絲。

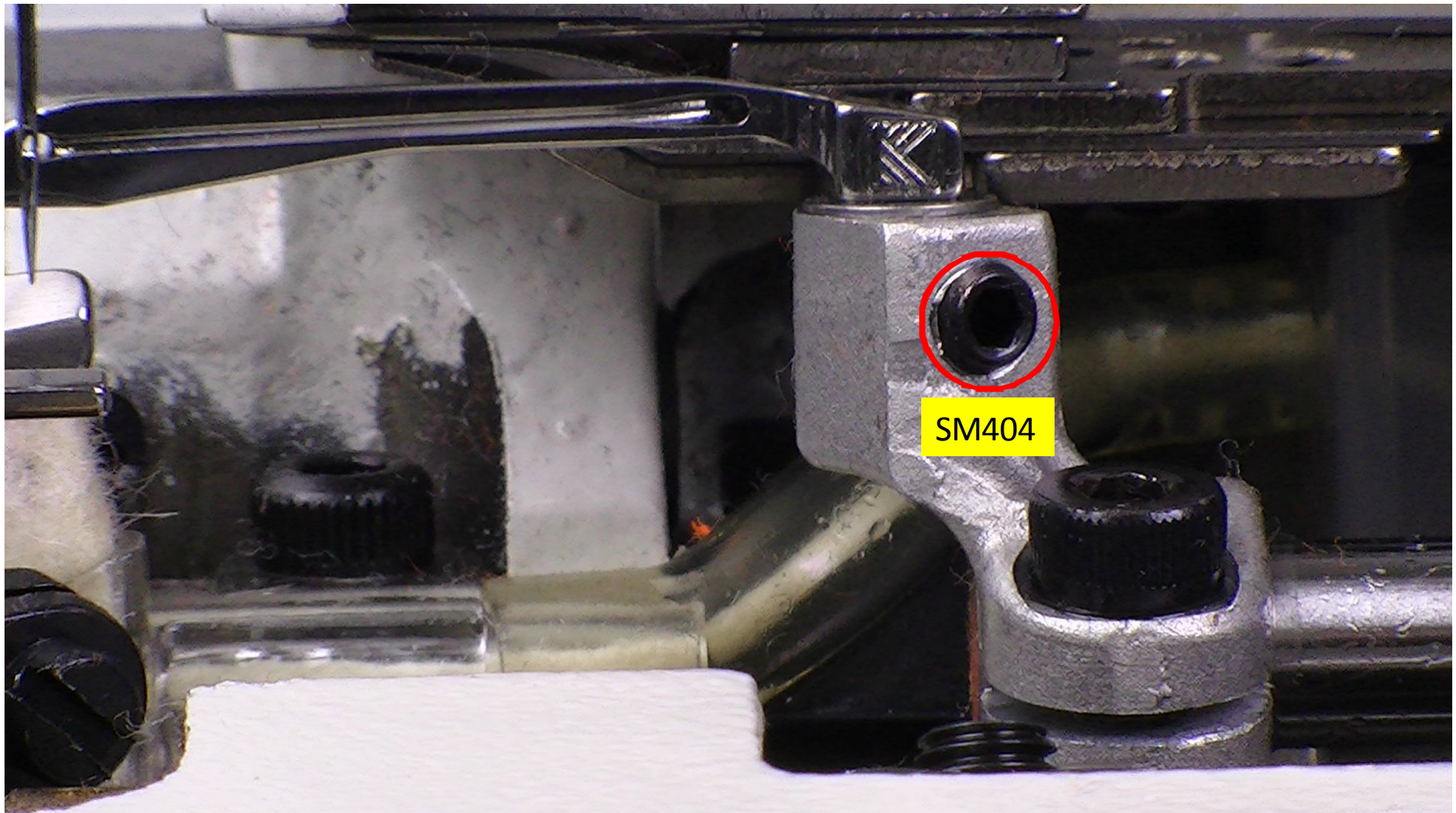
If position incorrect, loose screw SM404 to adjust the angle.



6-2

如有誤差放鬆SM404螺絲，調整勾針角度。

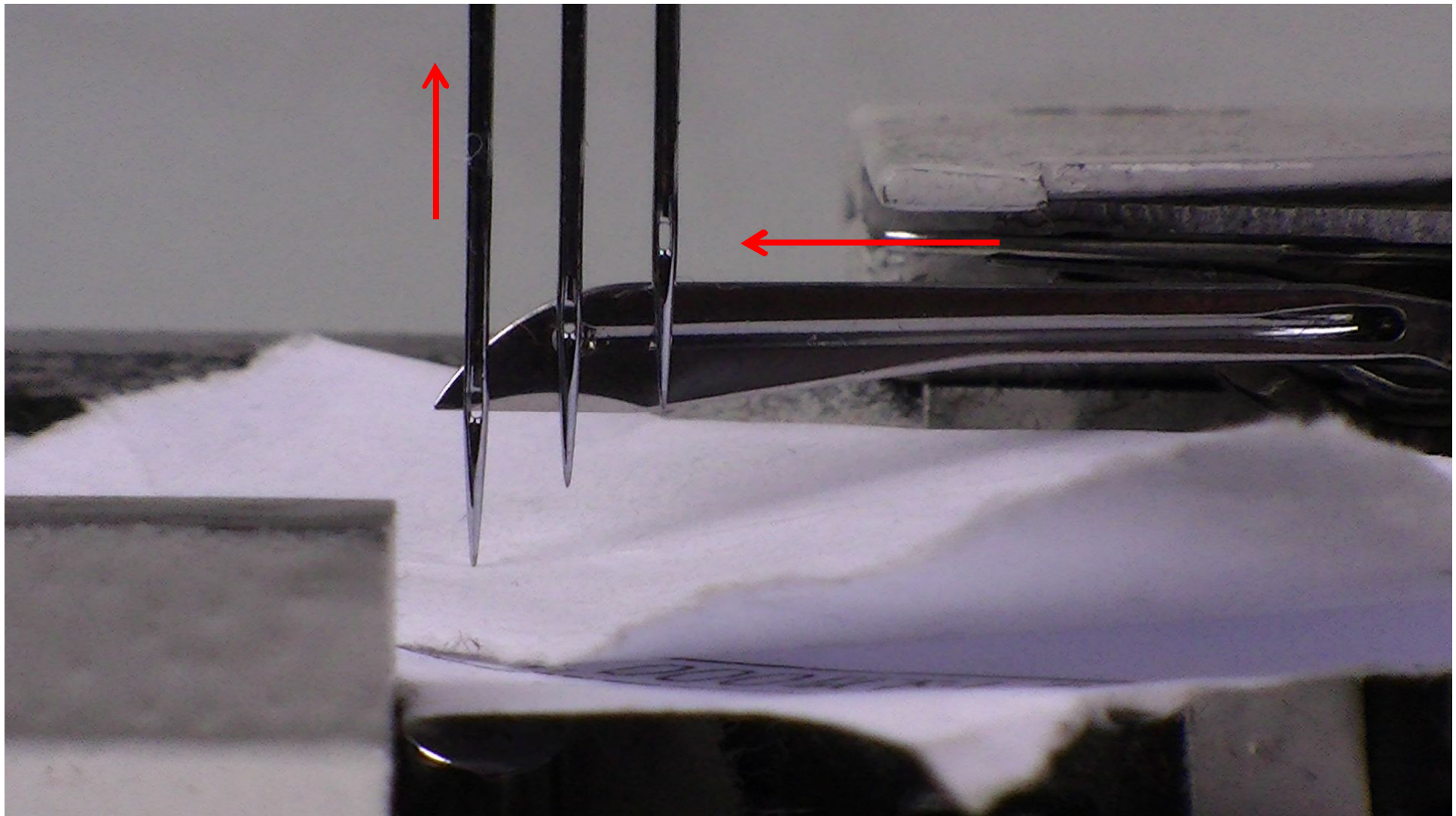
If position incorrect, loose screw SM404 to adjust the angle.



7. 勾針同步 The Synchronal of Needle and Looper :

當勾針走至第2支針時，勾針孔與針孔，孔對孔。

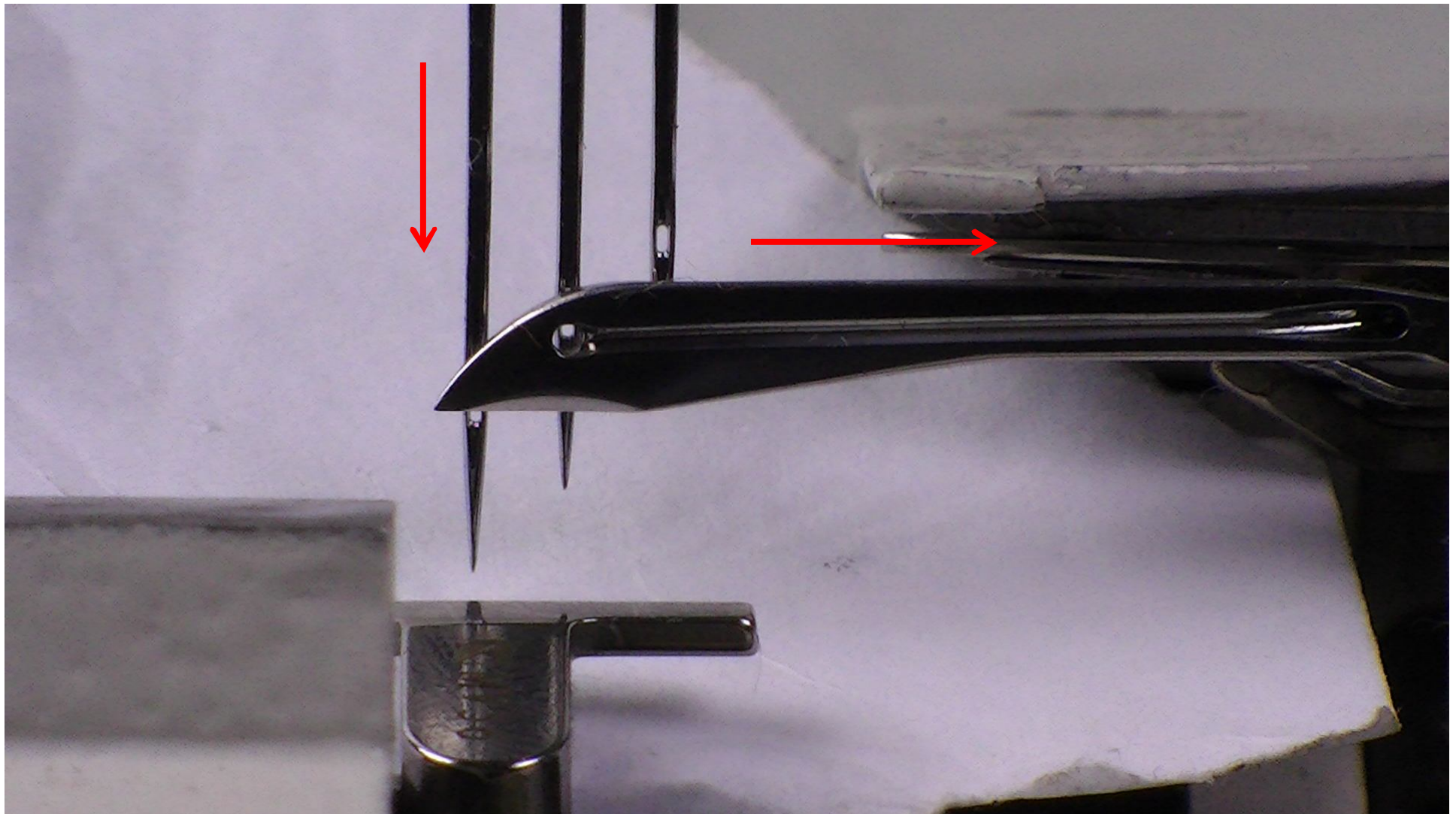
The looper eye overlaps middle needle eye when forward.



7-1

當勾針叉背時，勾針孔與針孔，孔對孔。

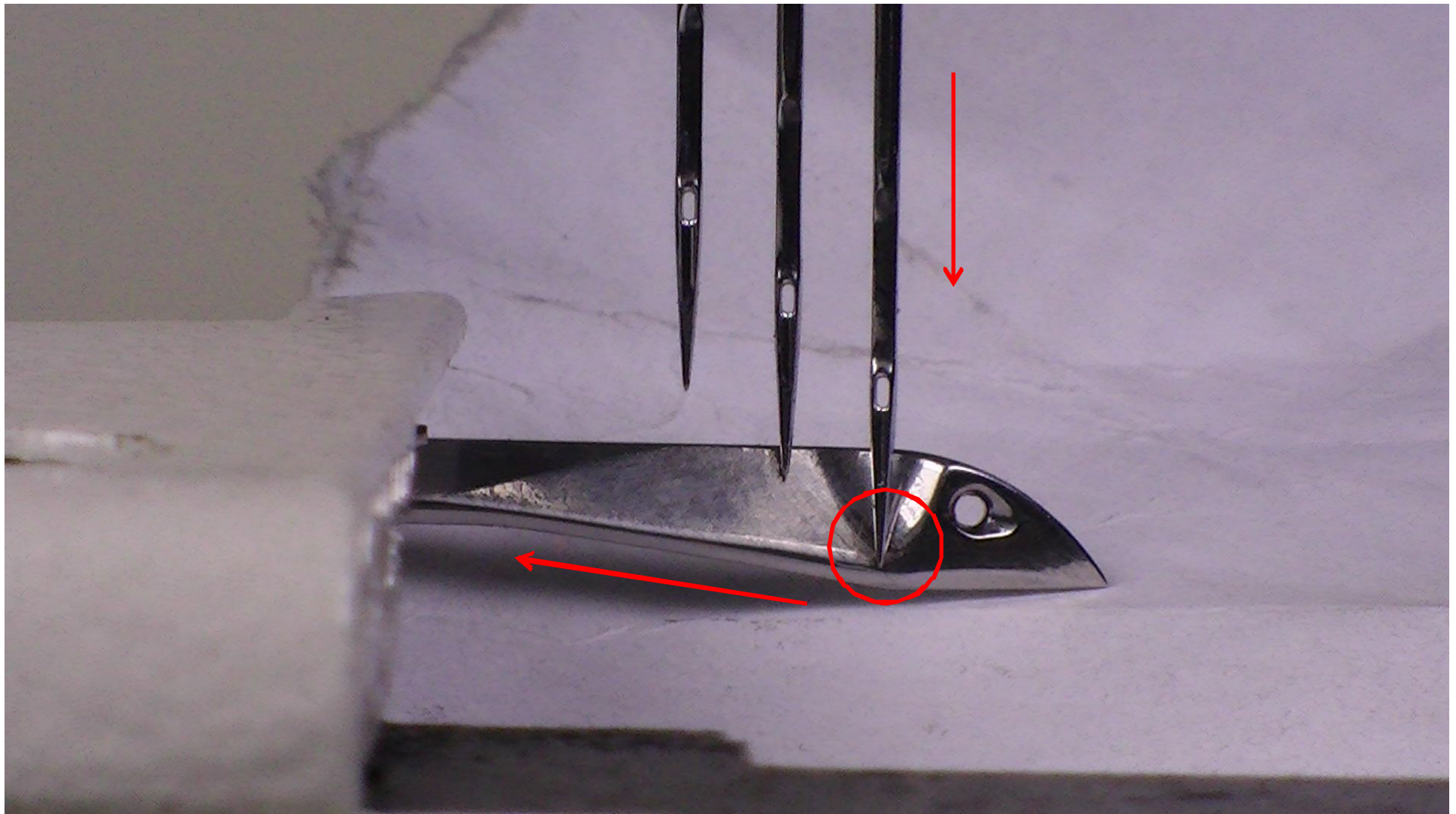
The looper eye overlaps the middle needle eye when backward.



7-2

雙重確認，第3支針，針尾要在勾針的斜線上。

Double check, the third needle tip encounters the arris.



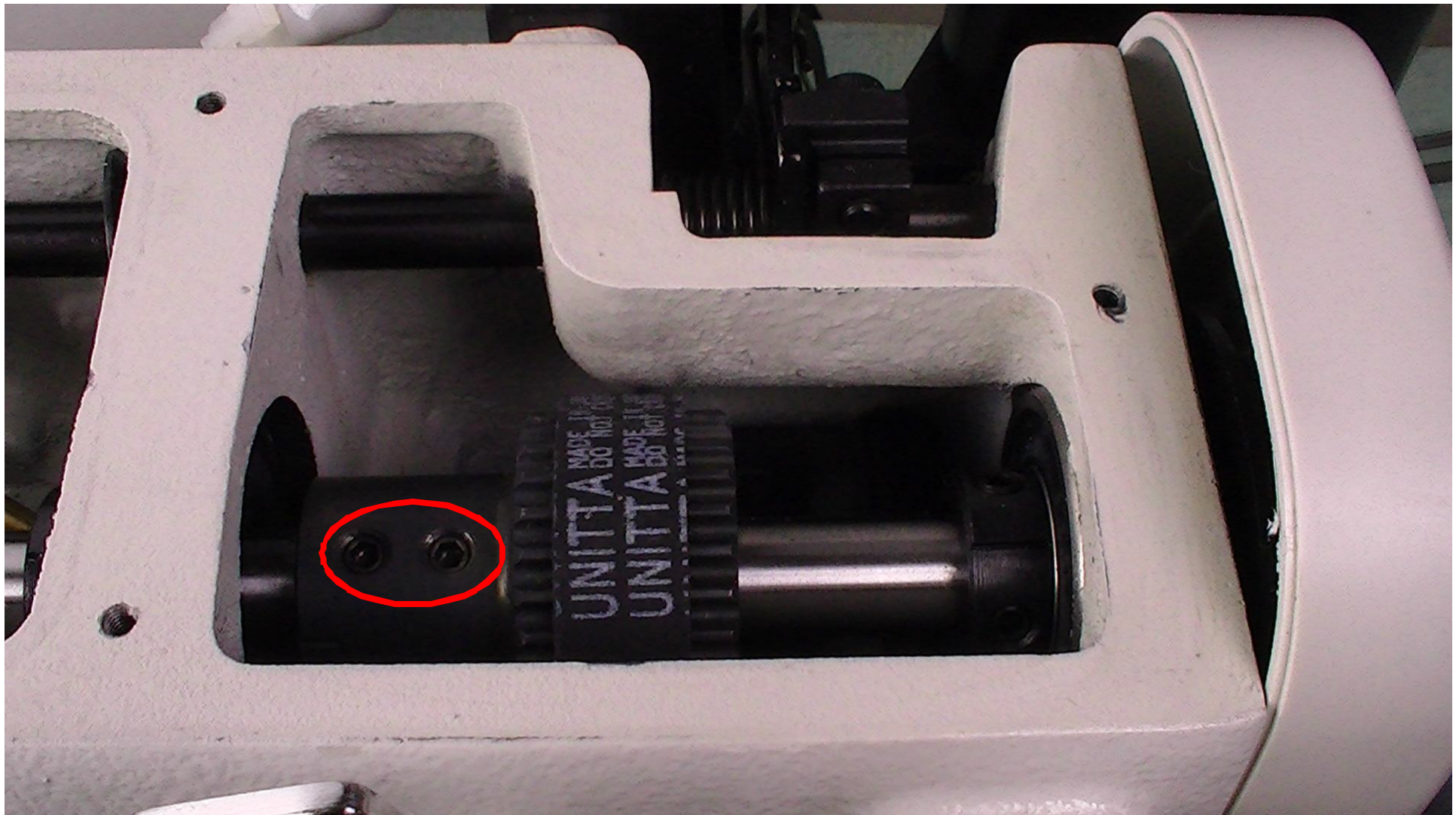
7-3

如有誤差放鬆SM602調整。

If asynchronous, loose screw SM602 for adjustment.

注意!如要調整同步，針高與勾針退距先定好，方可調整同步。

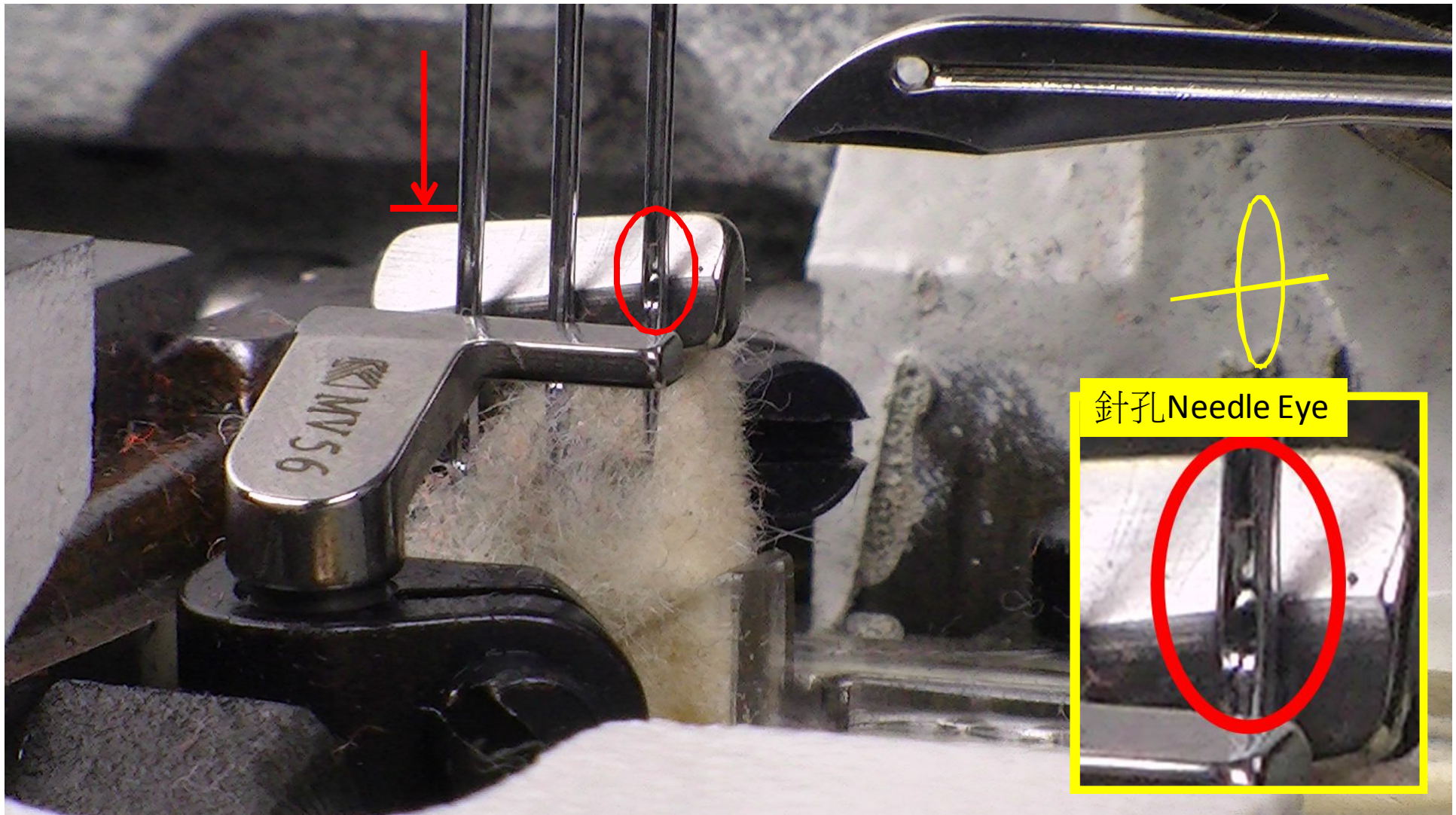
Attention! Before adjustment, make sure the needle height and looper timing are correct.



8. 護針片高度 The Height of Needle Guard:

針棒下始點不動，針孔在MV60D(護針片)斜線一半。

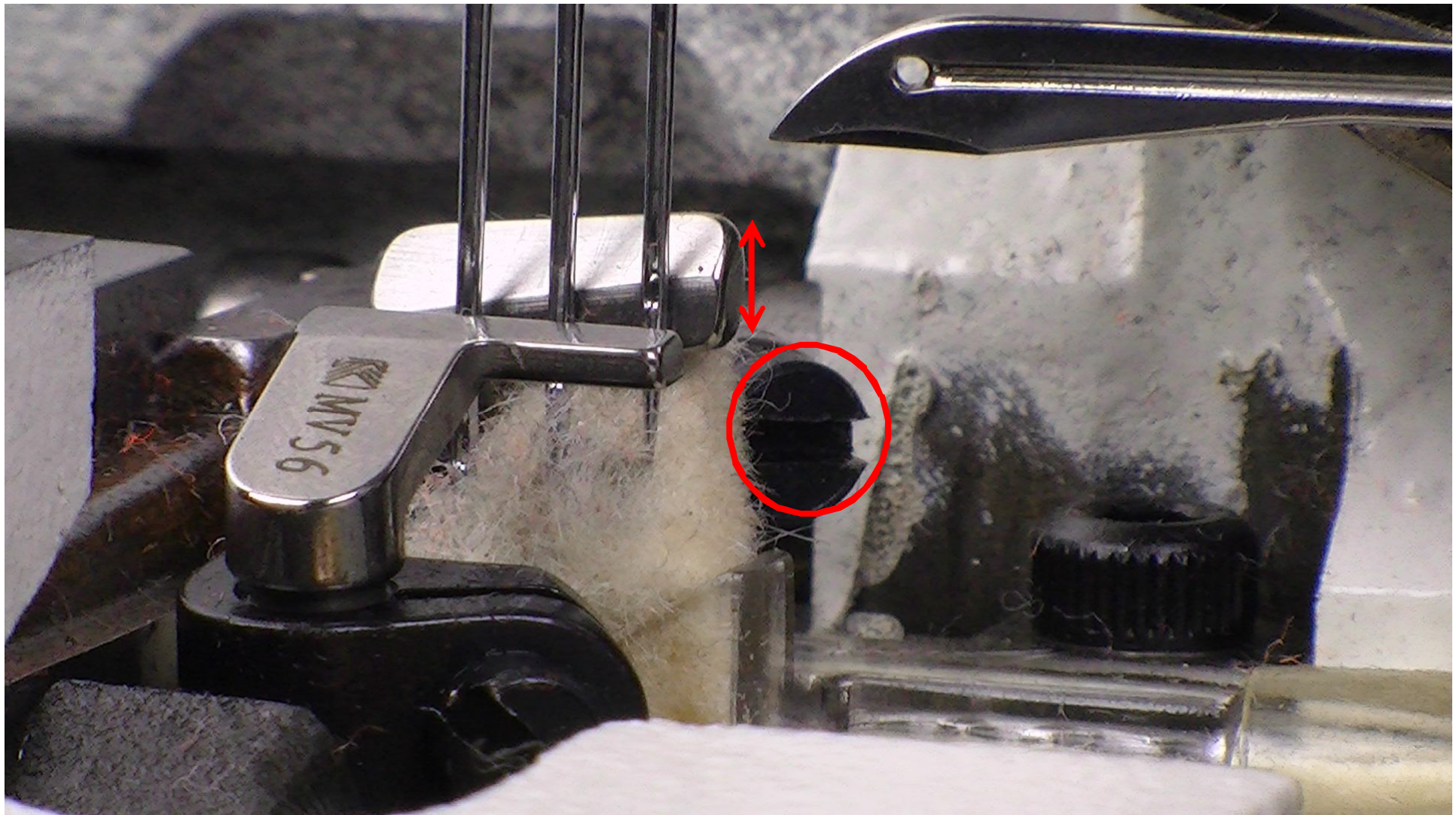
At bottom position, the arris is just in the middle of needle eye.



8-1

如有誤差放鬆SM133螺絲調整。

If position incorrect, loose screw SM133 for adjustment.



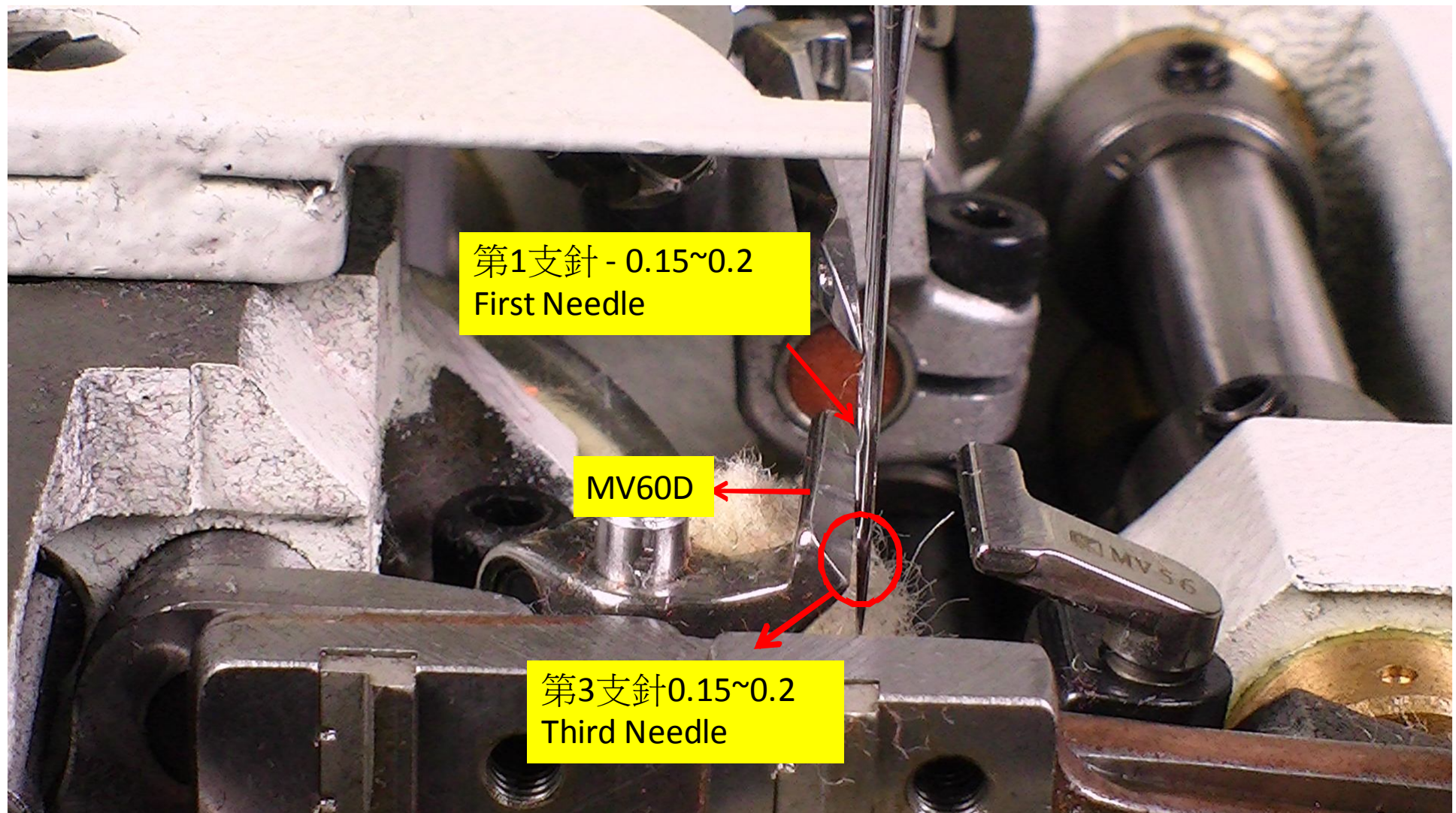
9.護針片(MV60D)角度The Angle of Rear Needle Guard:

第1支針碰(MV60)D0.15~0.2 mm

The guard is -0.15~0.2mm distance from first needle.

第3支針與(MV60D)間隙為0.15~0.2mm

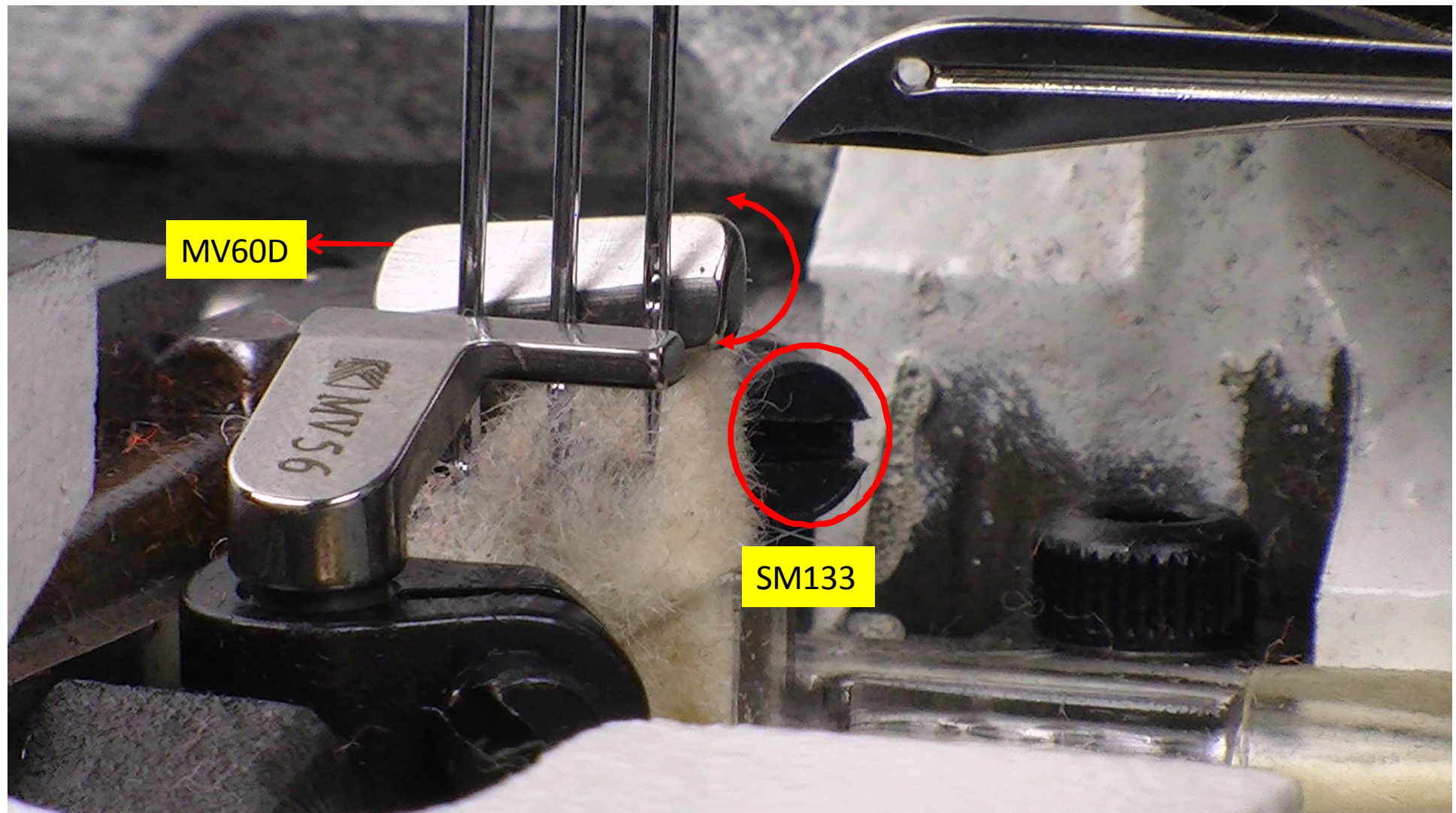
The guard is 0.15~0.2mm distance from third needle.



9-1

如有誤差放鬆SM133螺絲調整MV60D角度。

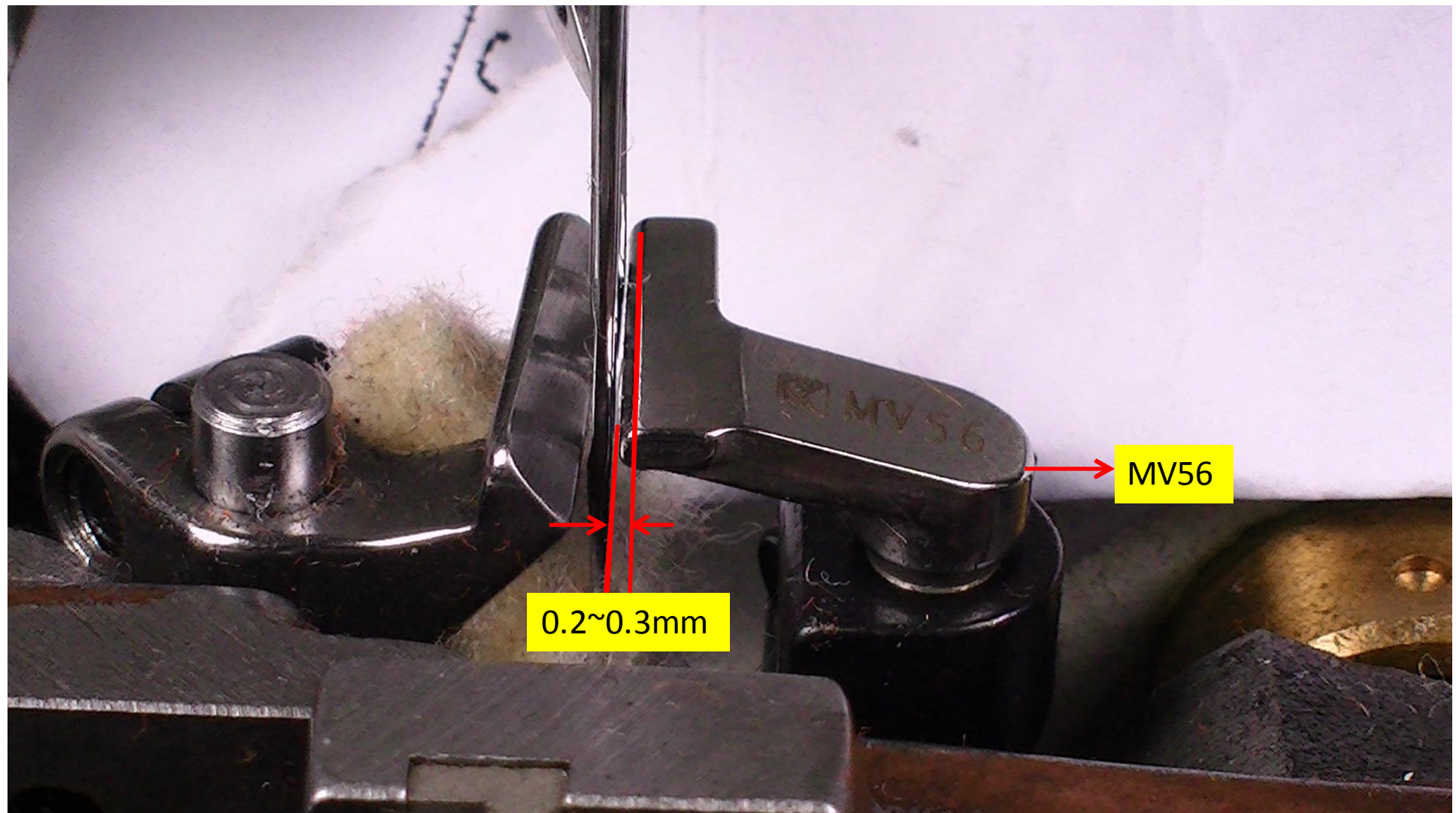
If incorrect, loose screw SM133 to adjust the angle of MV60D.



9-2

前護針片(MV56)與 3支針多要有0.2~0.3mm間隙。

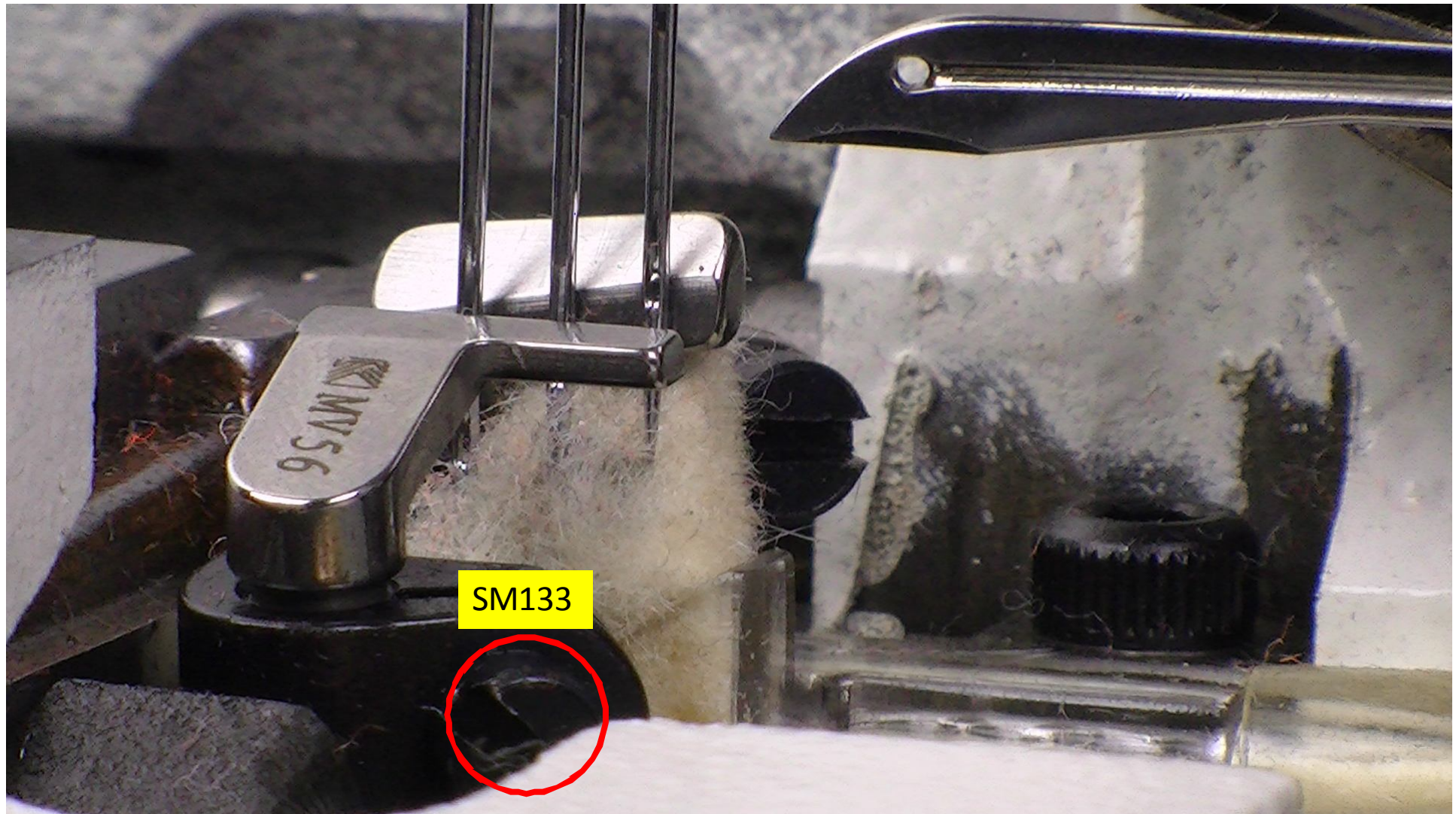
The front needle guard, MV56, is 0.2~0.3mm distance from all needles.



9-3

如有誤差放鬆SM133螺絲調整。

If incorrect, loose screw SM133 for adjustment.



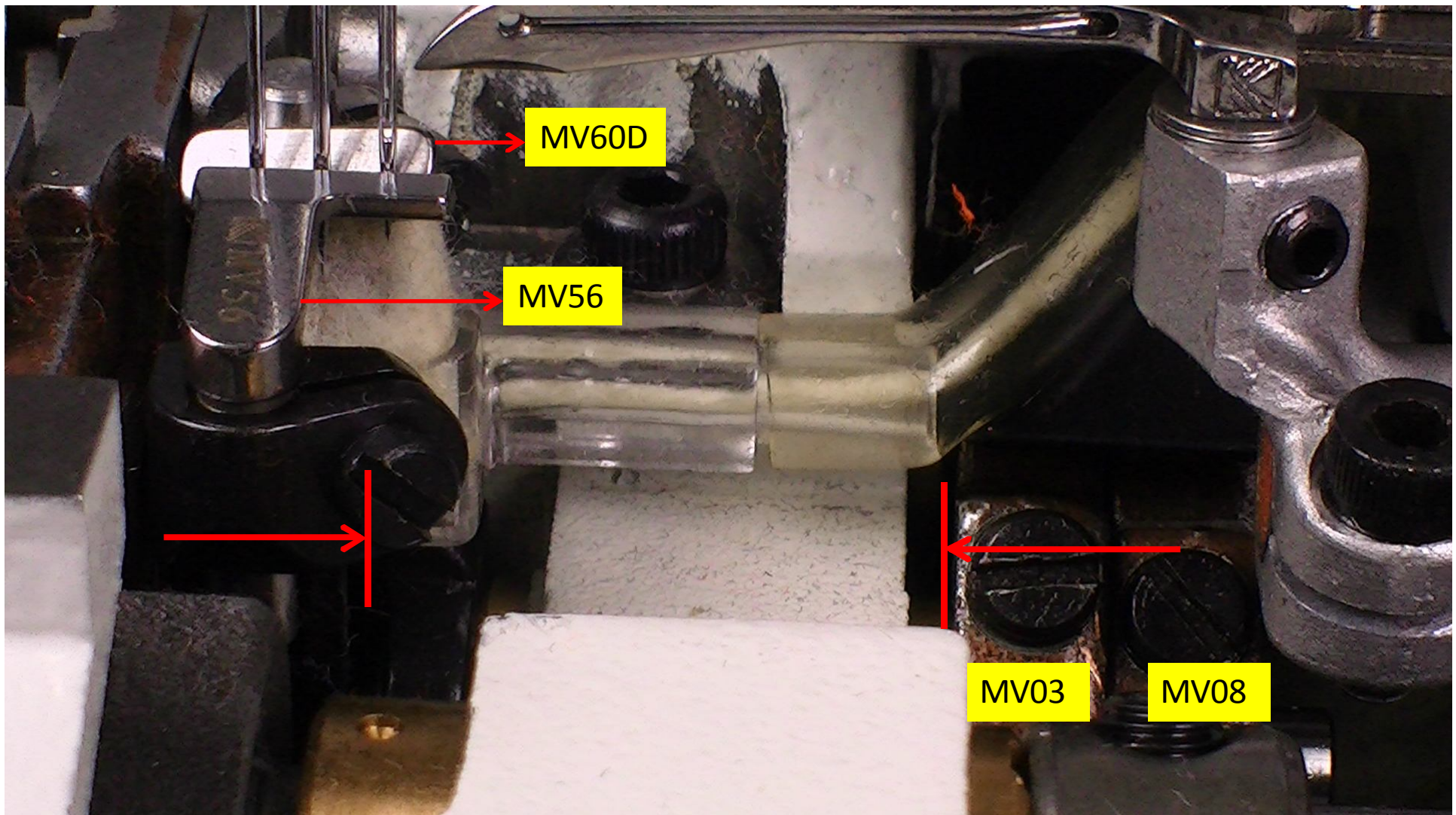
9-4

前護針(MV60D).後護針片 (MV56)不能有左右鬆動。

Make sure the front and back needle guard, MV60D, MV56, are steady.

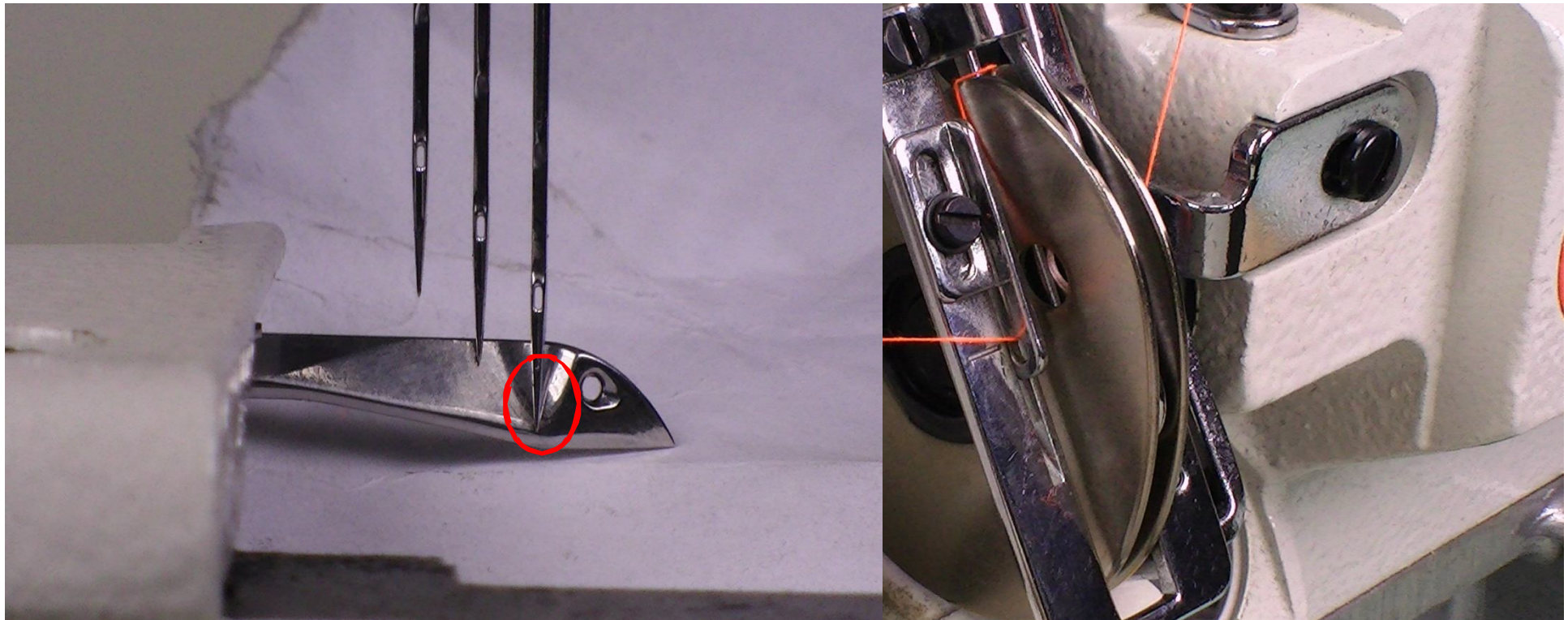
如有誤差.將前後護針片.往右推到底不動，再將MV03.MV08往左推到底鎖緊螺絲。

If not, loose screw on MV03, MV08 and tight screw after push them and guard fast.



10.放線時間 The Thread Taken-up Cam Timing:

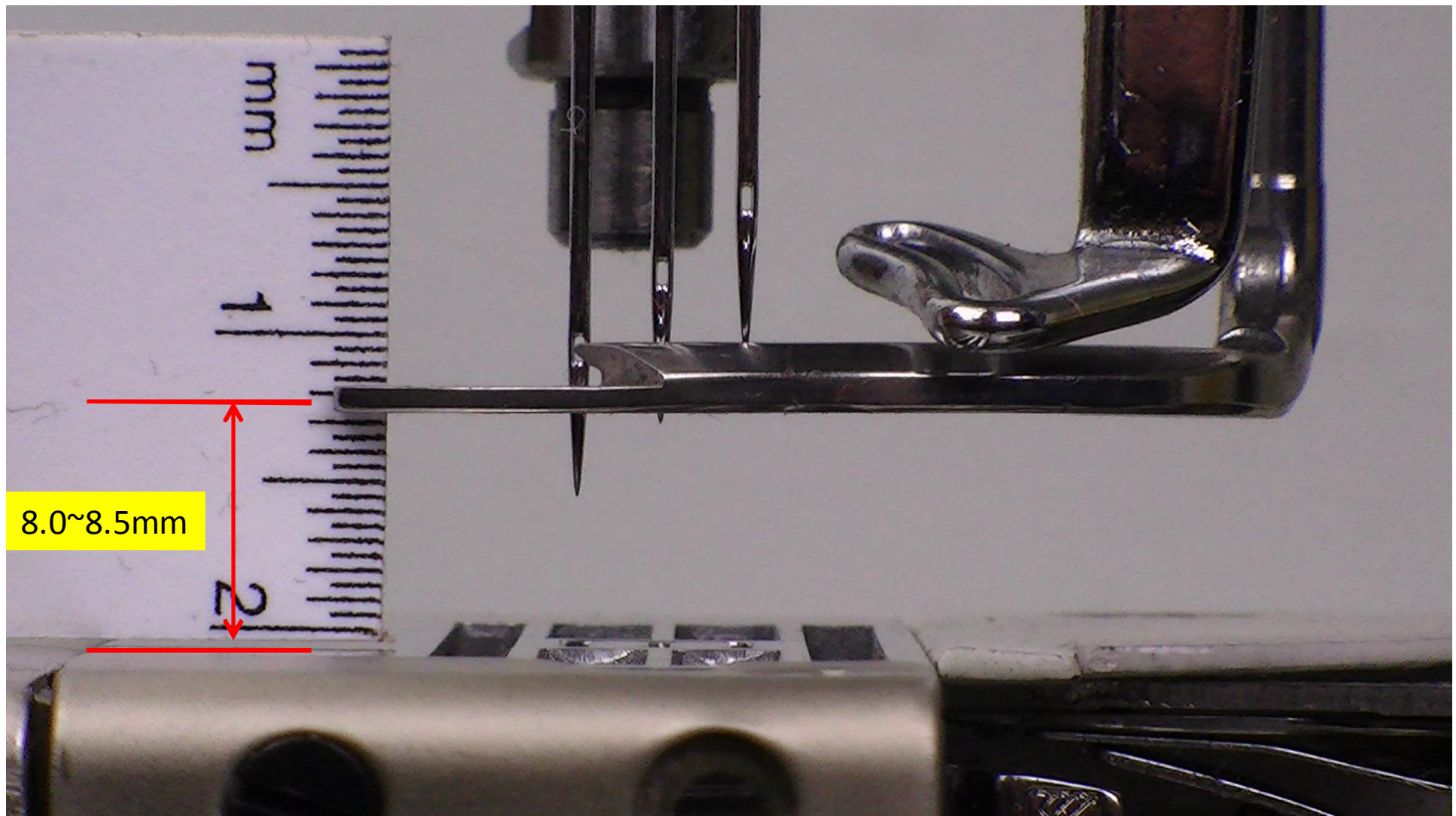
當第3支針，碰到勾針上的斜線時，也就是放線時間SQ06(放線凸輪。
The timing of looper thread is loosing from cam
when the third needle encounter the looper arris.



11. 上勾針高度 The Height of Upper Looper:

上勾針(MH41)與針板高度為 8.0~8.5

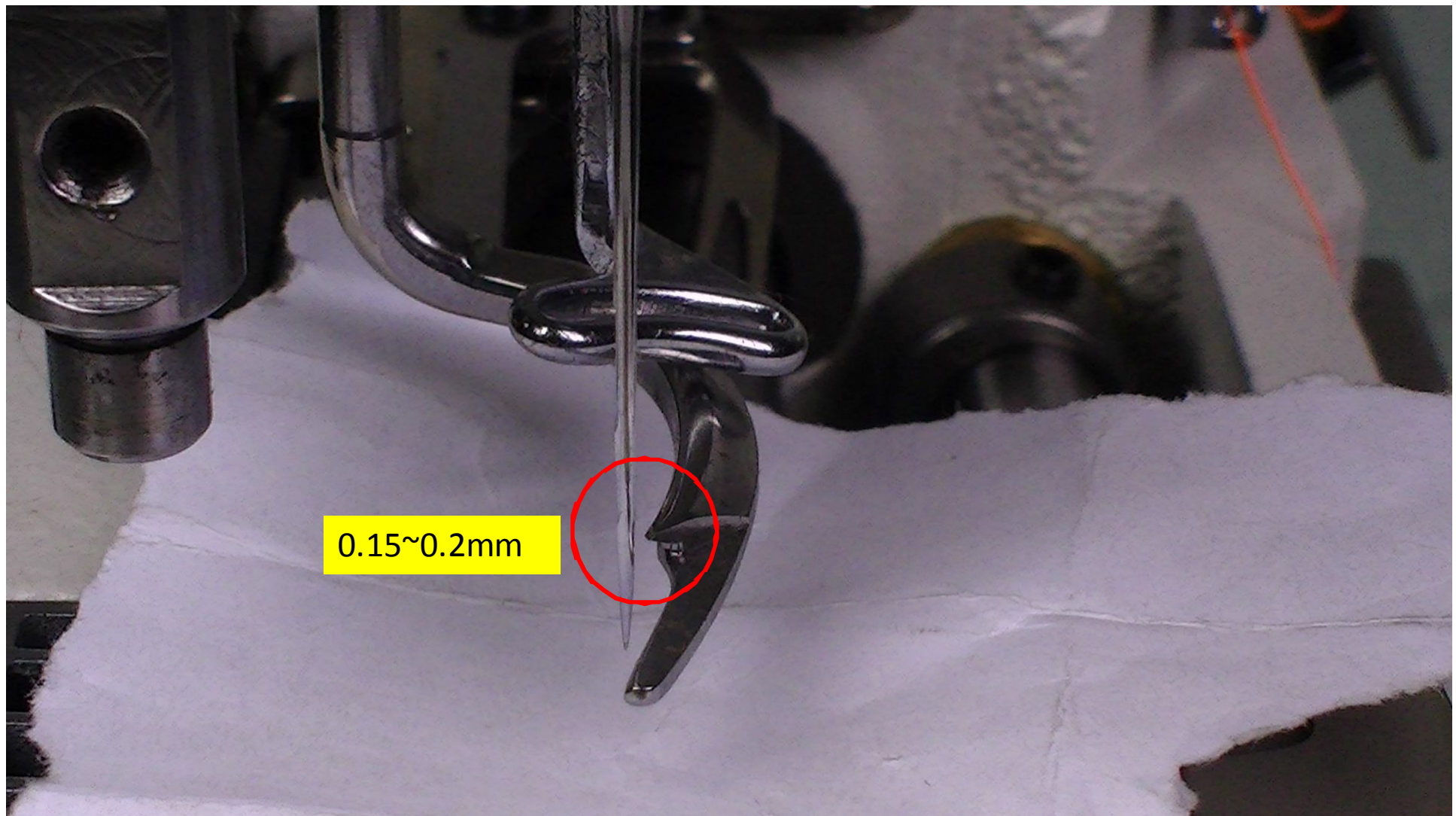
The upper looper, MH41, is 8.0~8.5mm distance from plate.



11-1

上勾針(MH41)與第3支針的間隙為0.15~0.2mm。

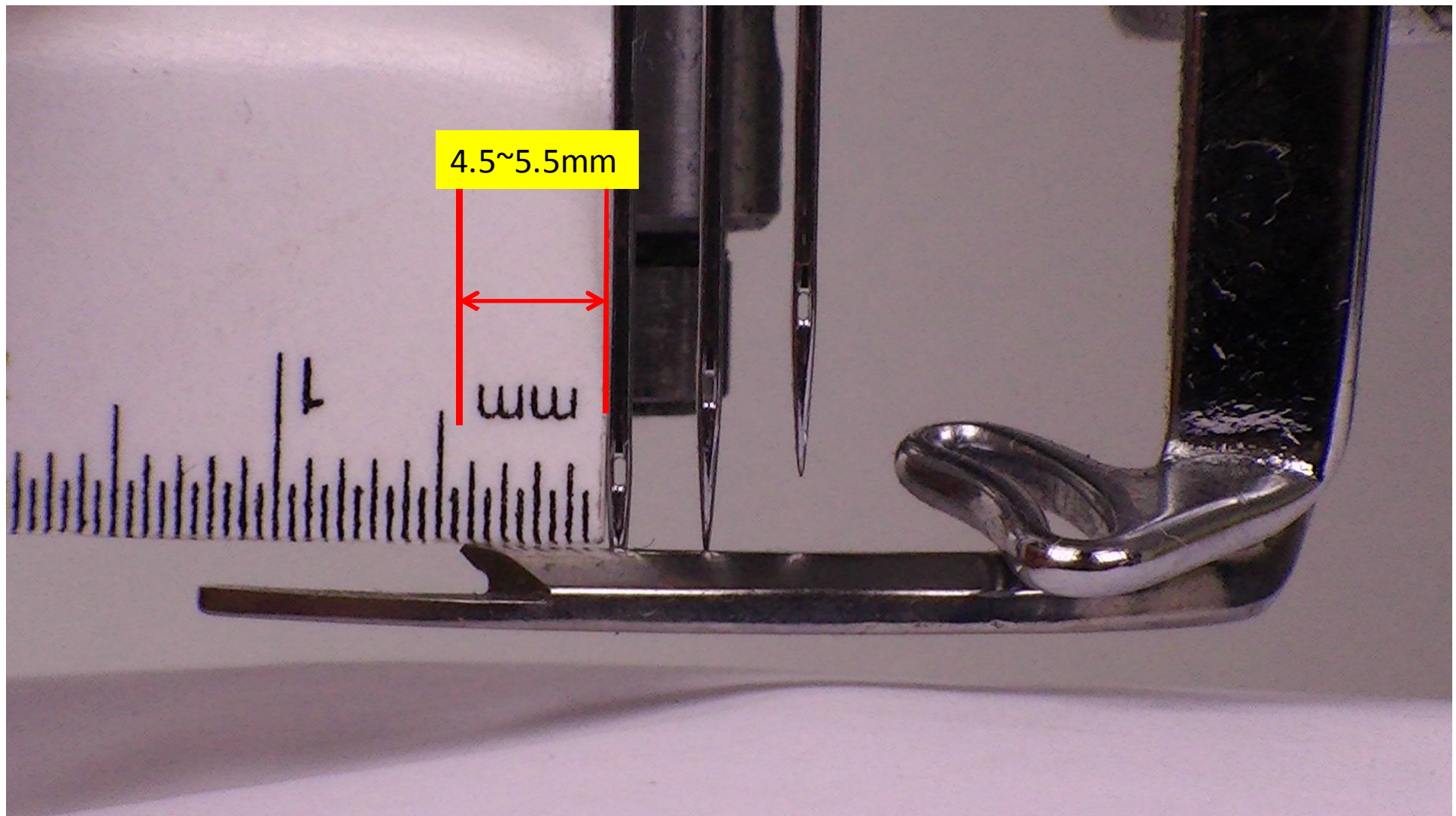
The gap is 0.15~0.2mm between upper looper and third needle.



11-2

上勾針走至最左不動與第3支針距離為4.5~5.5mm。

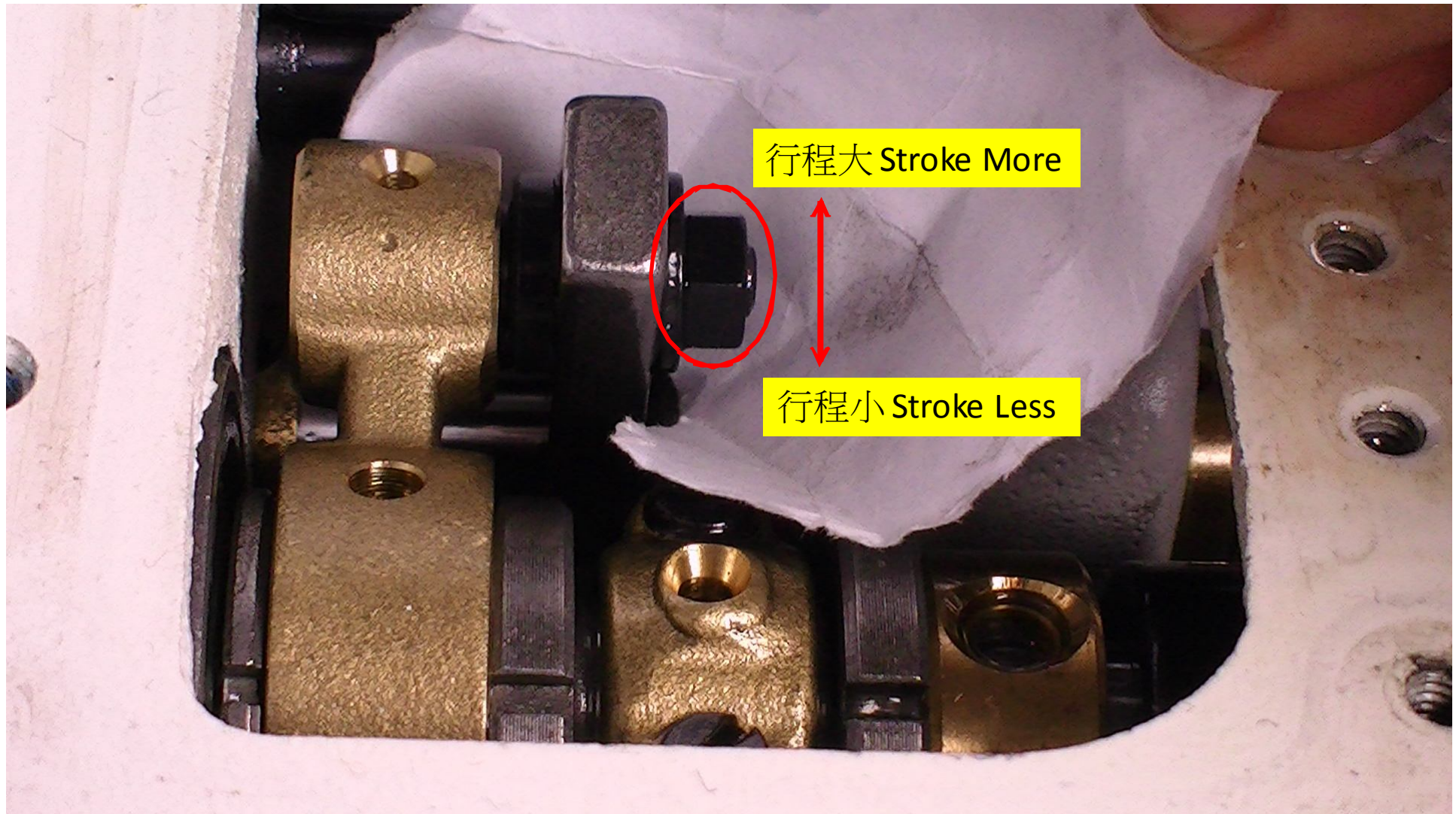
When moving to left end point, the upper looper is 4.5~5.5mm distance from third needle.



11-3

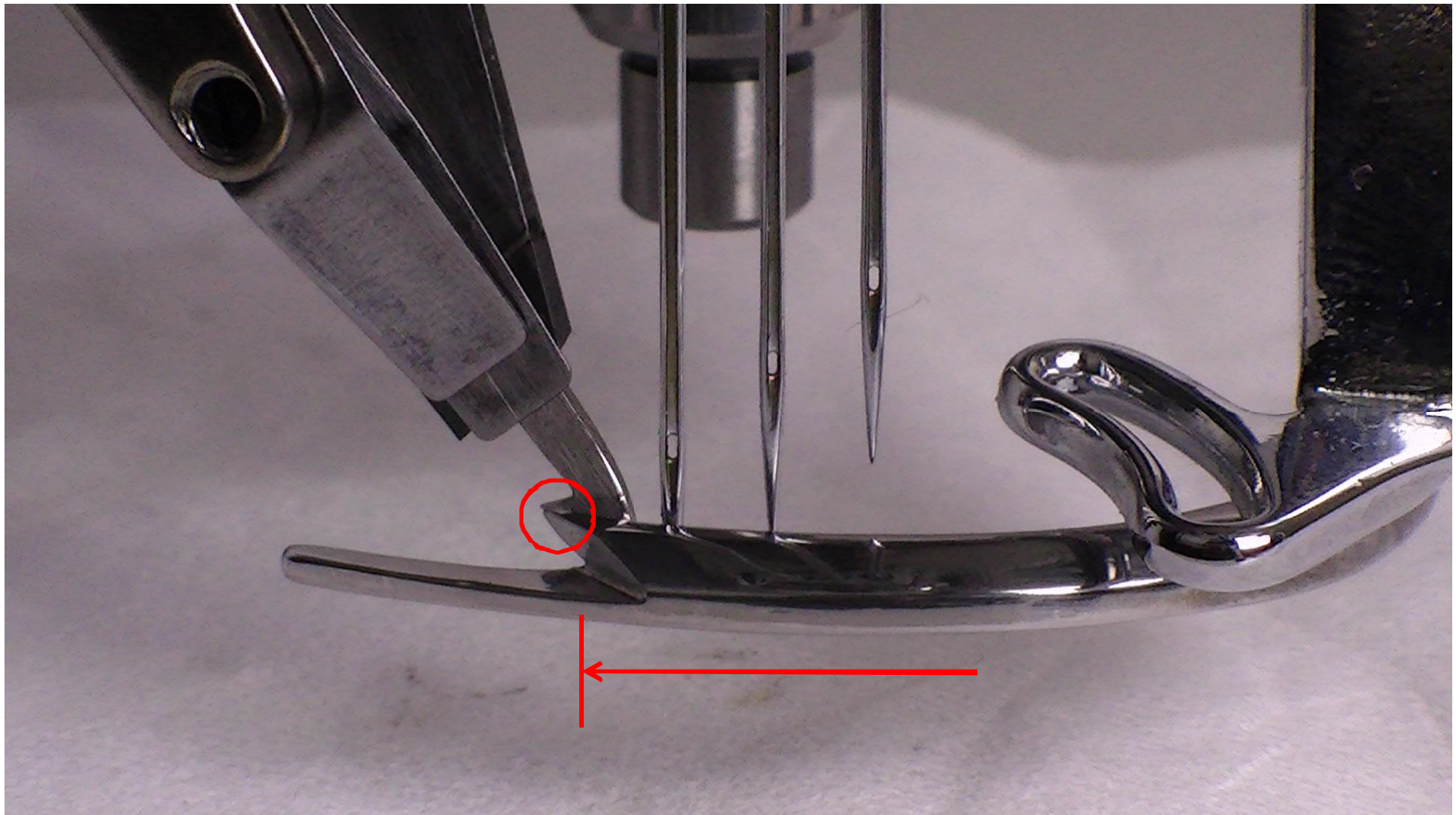
如有誤差放鬆NM511螺絲母調整上勾針行程。

If timing incorrect, loose screw NM511 to adjust the stroke.



12 上剪刀(UT766-A)固定位 The Position of Upper Trimmer:

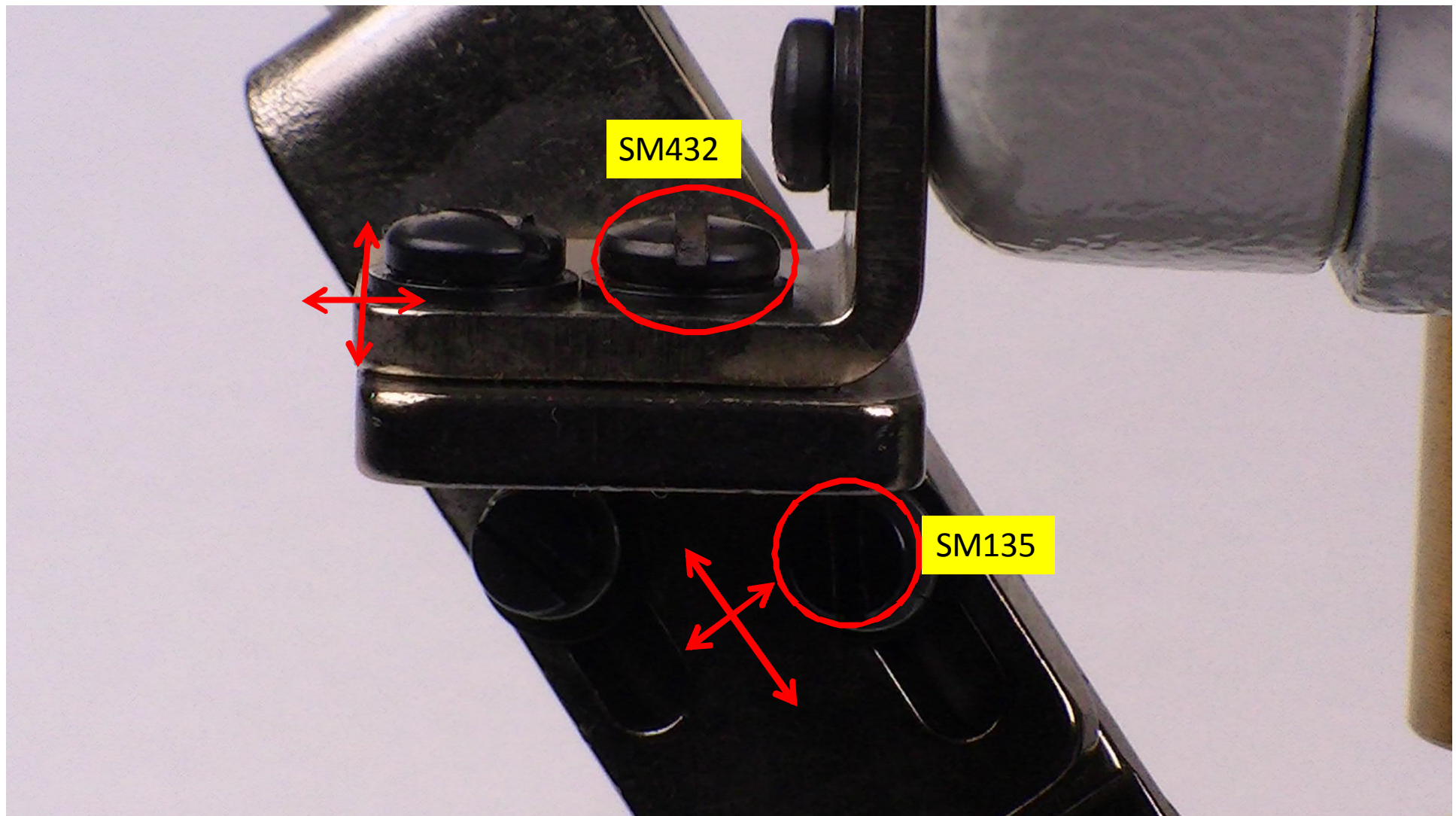
上勾針(MH41)定位之後，活動刀(UT758)的勾尖對準上勾針的勾尖。
After upper looper in position, the hook, on movable knife, UT758,
align with the tip of looper.



12-1

如有誤差調整SM432,SM135螺絲角度。

If position incorrect, loose screw SM432, SM135 to adjust the angle.

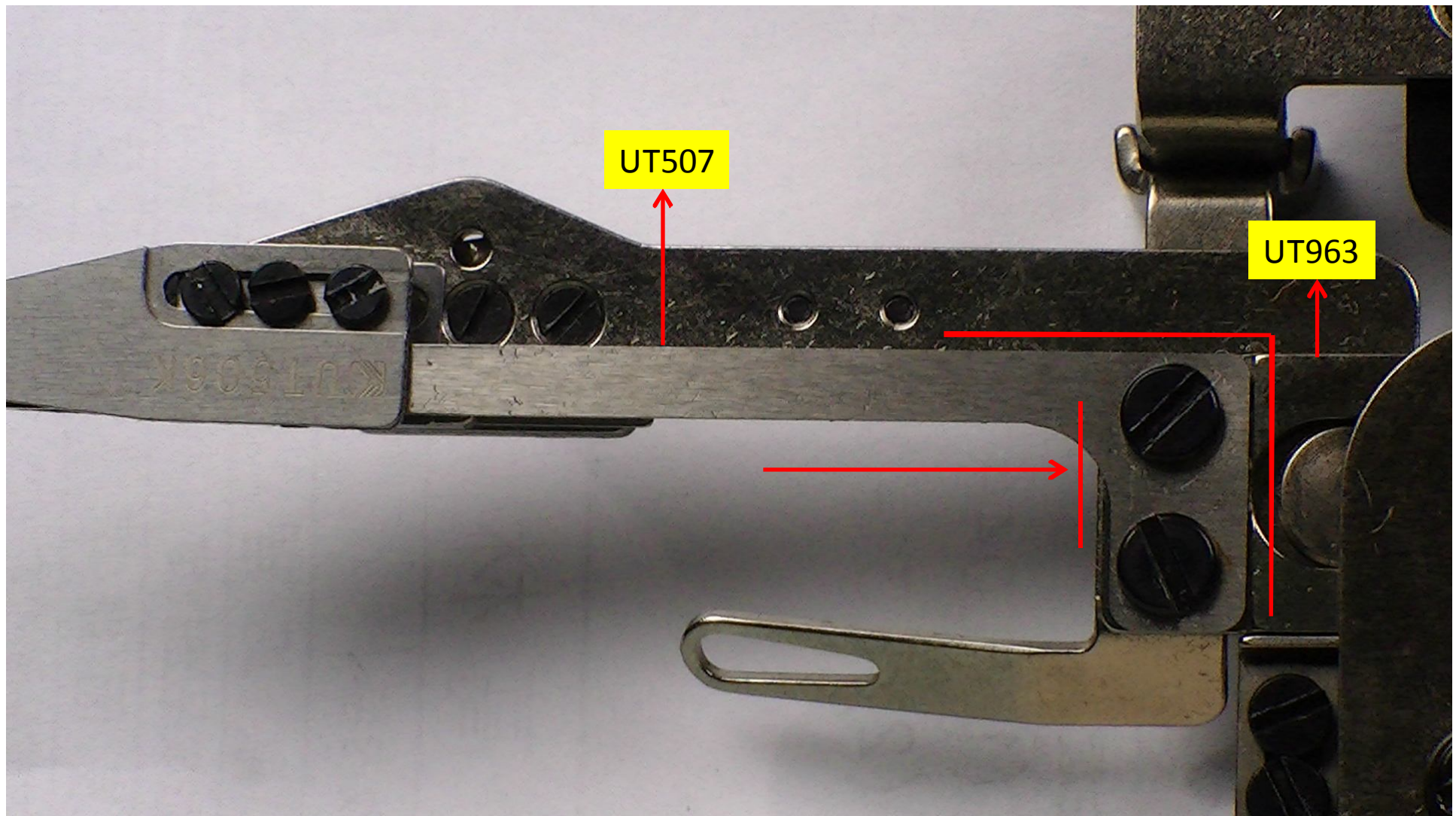


13.活動刀(UT507)定位點

The Angle of Movable Knife:

將活動刀(UT507)往右退到底，要與活動刀座(UT963)平行90度。

The movable knife must be vertical with knife bed, UT963, when moves to right end point.

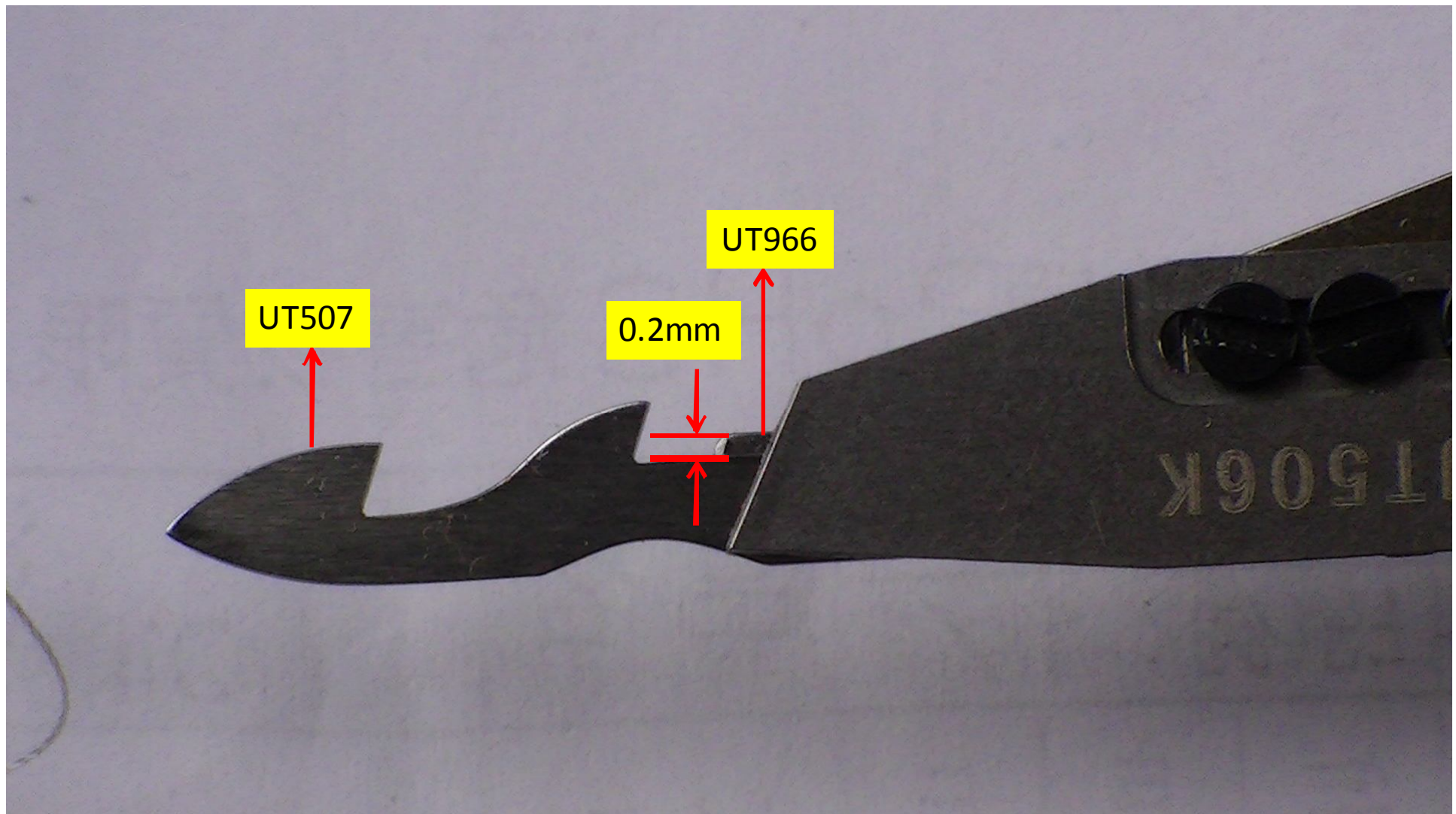


13-1 夾線片 (UT966) 與活動刀 (UT507) 時位

The Position of Thread Holder and Movable Knife:

夾線片 (UT966) 與活動刀 (UT507) 距離為 0.2mm。

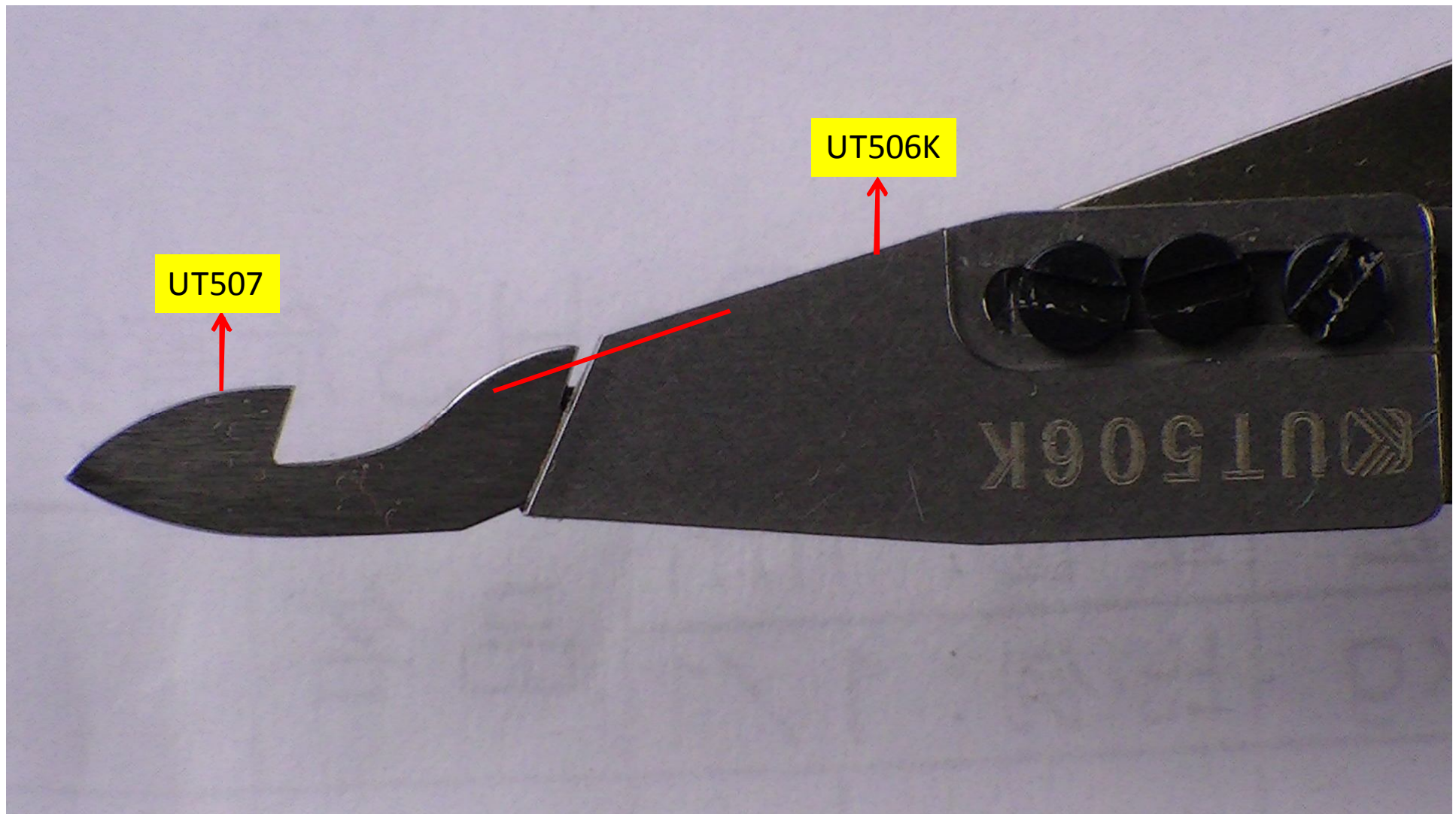
The thread holder is 0.2 distance from movable knife.



13-2 固定刀(UT506K)角度定位點 The Angle of Fix Knife:

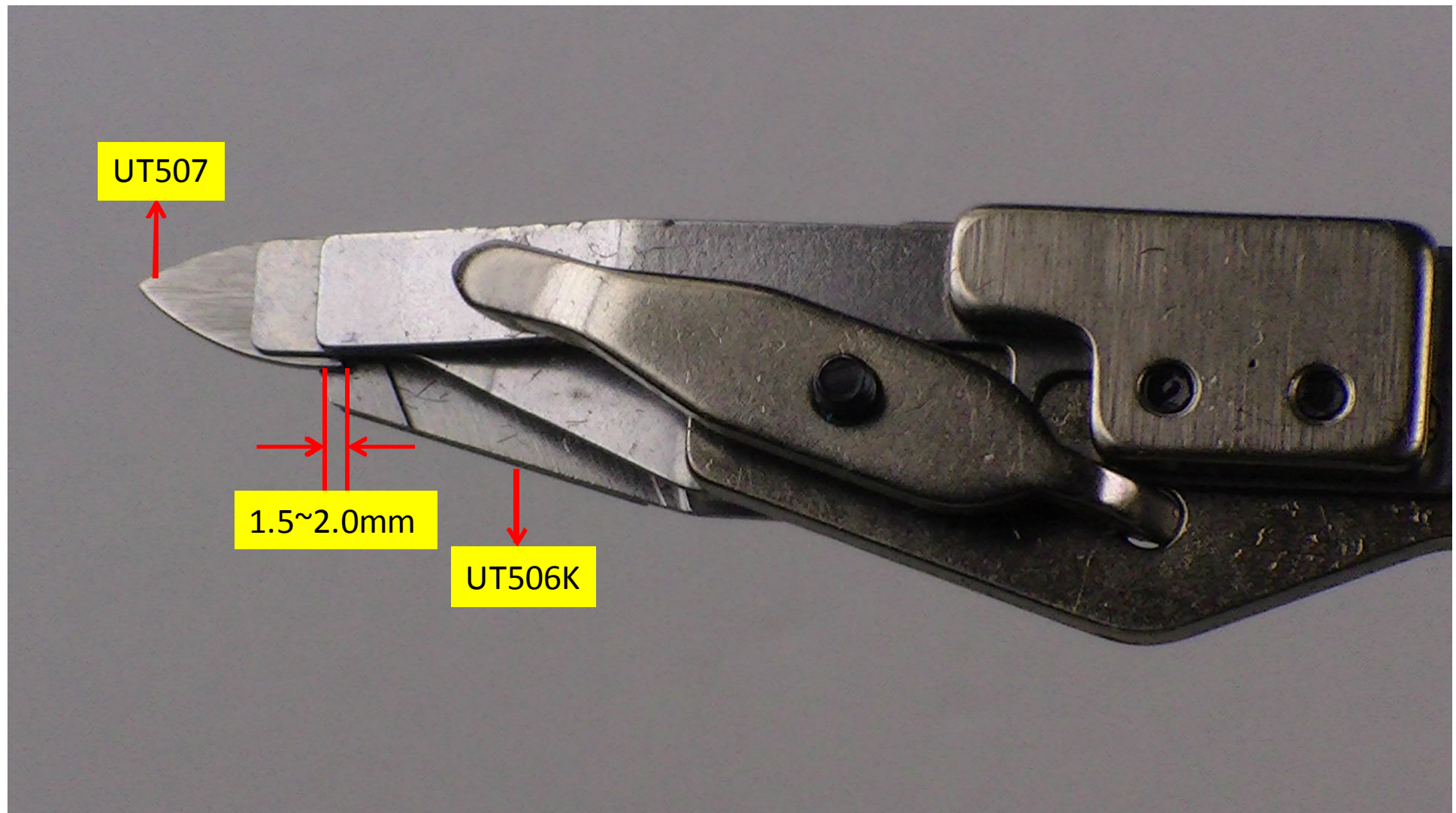
固定刀(UT506K)口尖要與活動刀(UT507)口尖角對角。

The edge of fix knife is align with the hook of movable knife.



13-3 固定刀(UT506K)前後位子 The Front and Rear Position of Fix Knife:

活動刀(UT507)退到底，固定刀(UT506K)與活動刀(UT507)為 1.5~2.0mm。
The movable knife overlaps the edge of fix knife with 1.5~2.0mm
when return to end point.

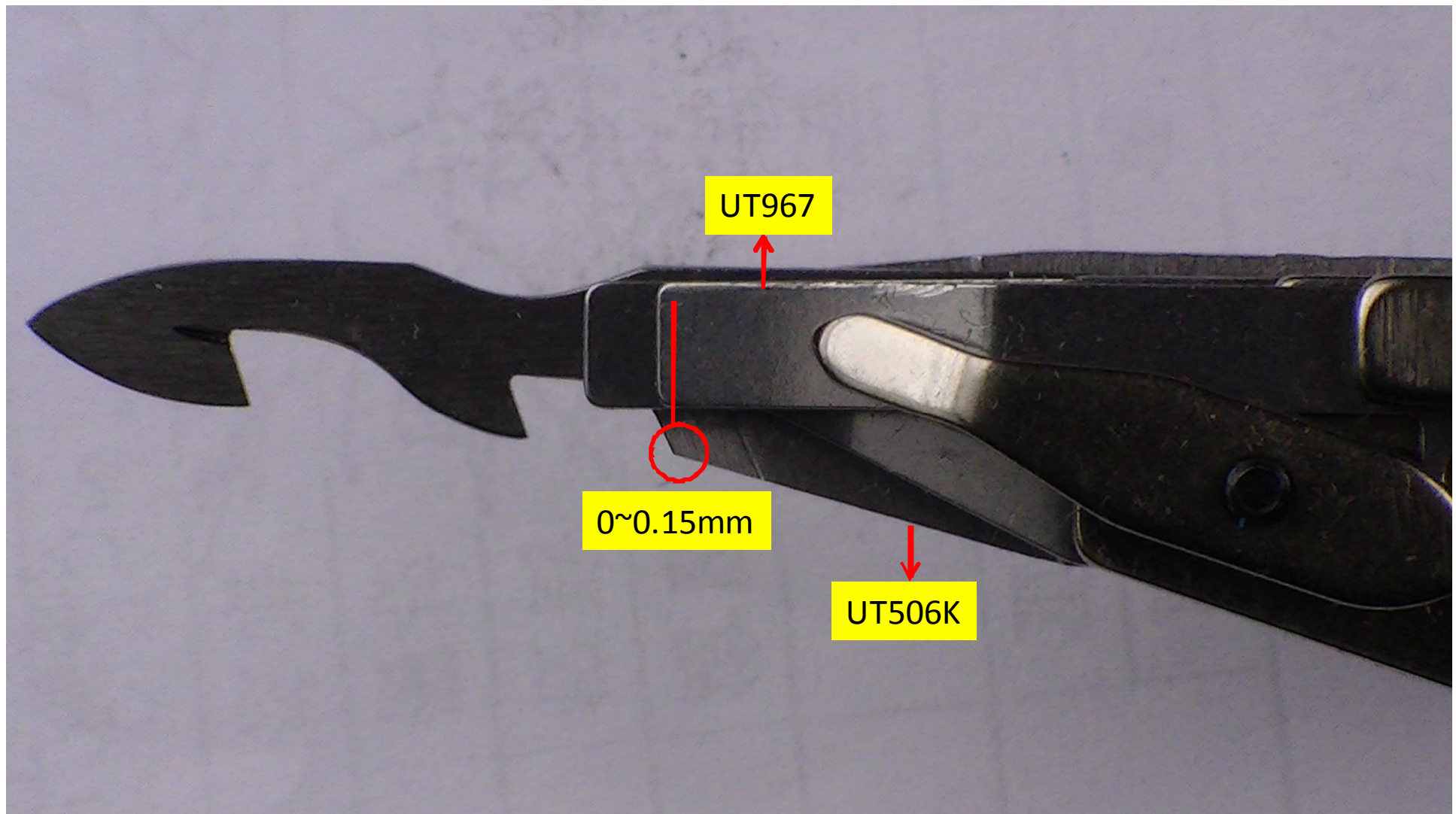


13-4 壓力鋼片 (UT967) 前後位子

The Position of Leaf Spring:

壓力鋼片 (UT967) 要與固定刀斜口 (UT506K) 距離為 $0 \sim 0.15\text{mm}$ 。

The leaf spring, UT967, overlaps $0 \sim 0.15\text{mm}$ distance from the edge of fix knife, UT506K.

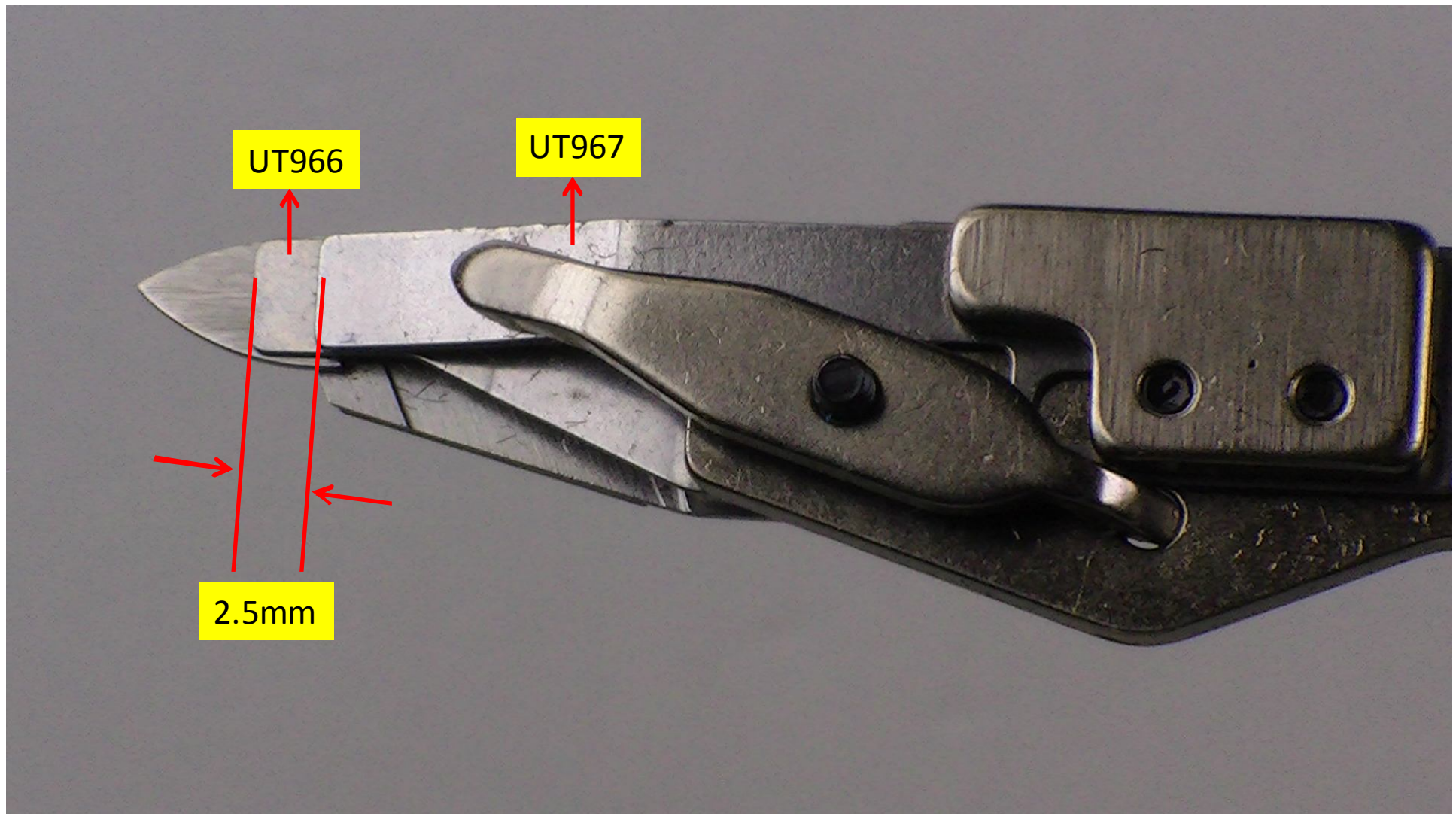


13-5 夾線片 (UT966) 與壓力鋼片 (UT967) 前後位子

The Position of Leaf Spring and Thread Holder:

夾線片 (UT966) 與壓力鋼片 (UT967) 距離為 2.5mm。

The thread holder, UT966, is 2.5mm distance from leaf spring, UT967.



14.活動刀(UT507)行程與勾針間隙

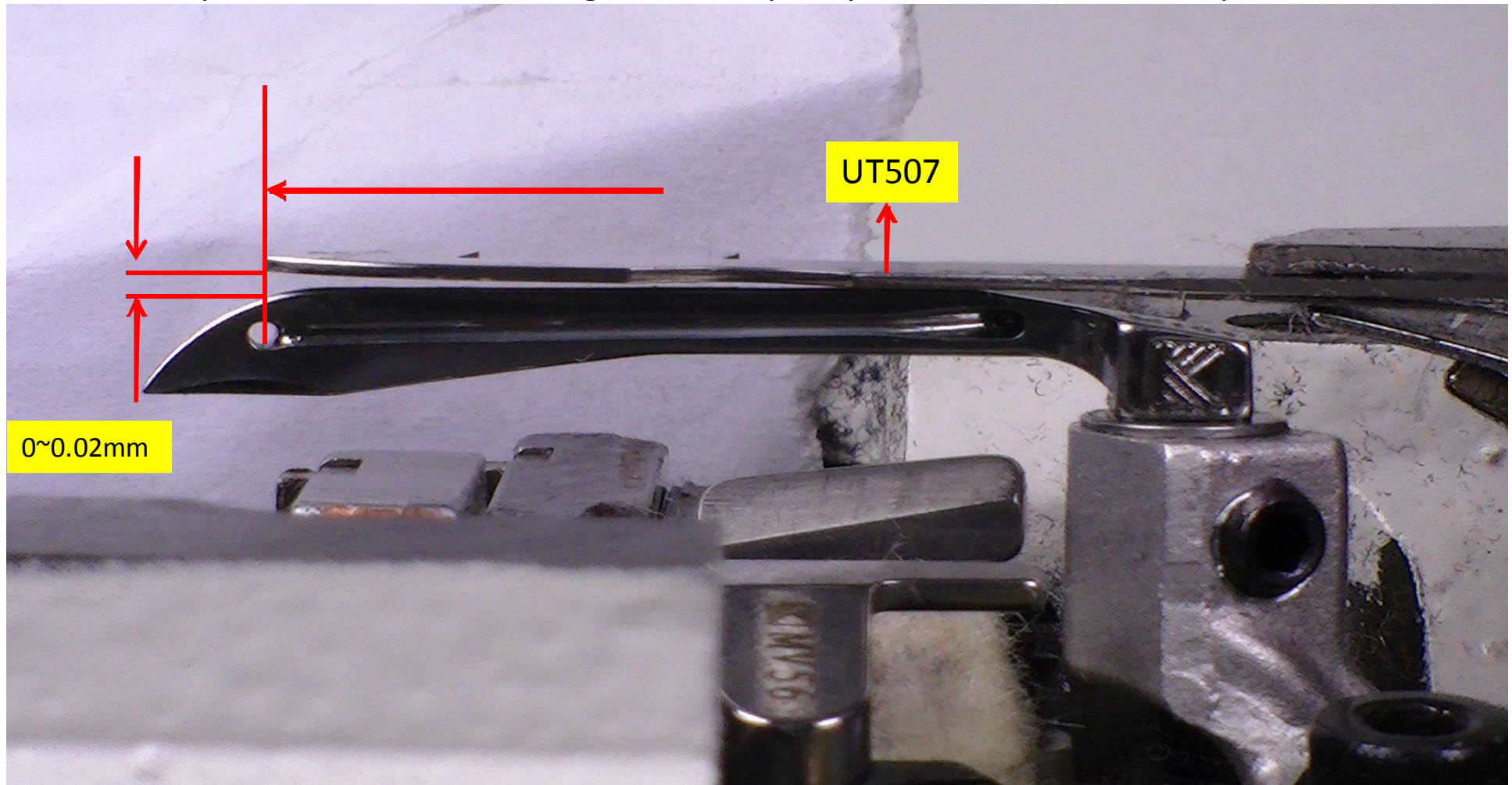
The Gap Between Movable Knife and Looper:

活動刀(UT507)與勾針間隙為 0~0.02mm。

The gap is 0~0.02mm.

活動刀(UT507)走至左始點不動，刀尖與勾針孔對齊。

The peak of movable knife aligns with looper eye when forward to end point.



14-1

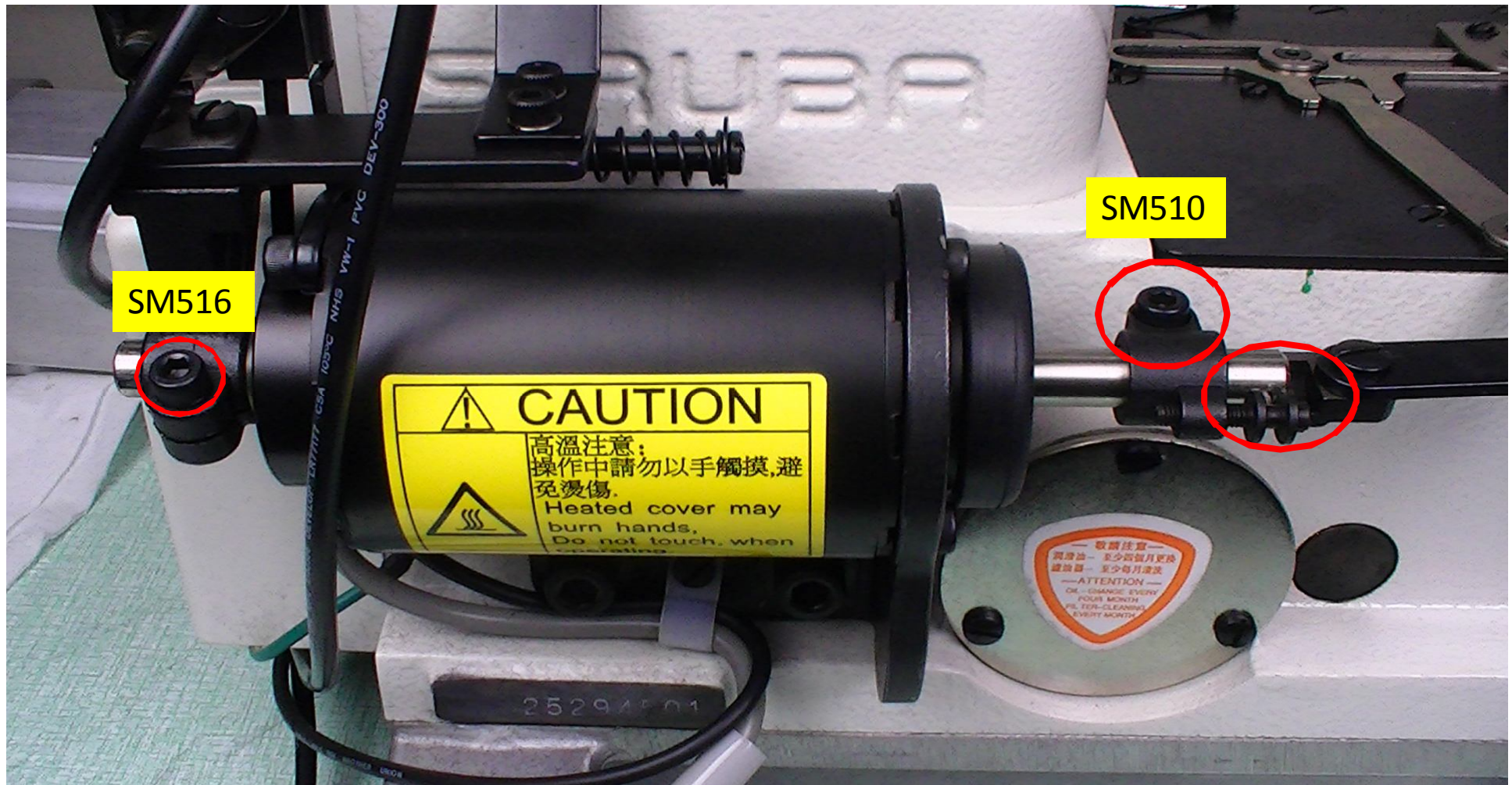
如有誤差放鬆螺絲調整。 If incorrect, loose screw for adjustment.

1. SM516是控制活動刀總行程 SM516 controls the stroke of movable knife.

2. SM510是控制活動刀前進量或後退量單向調整。 SM510 controls the stroke of movable knife forward or backward.

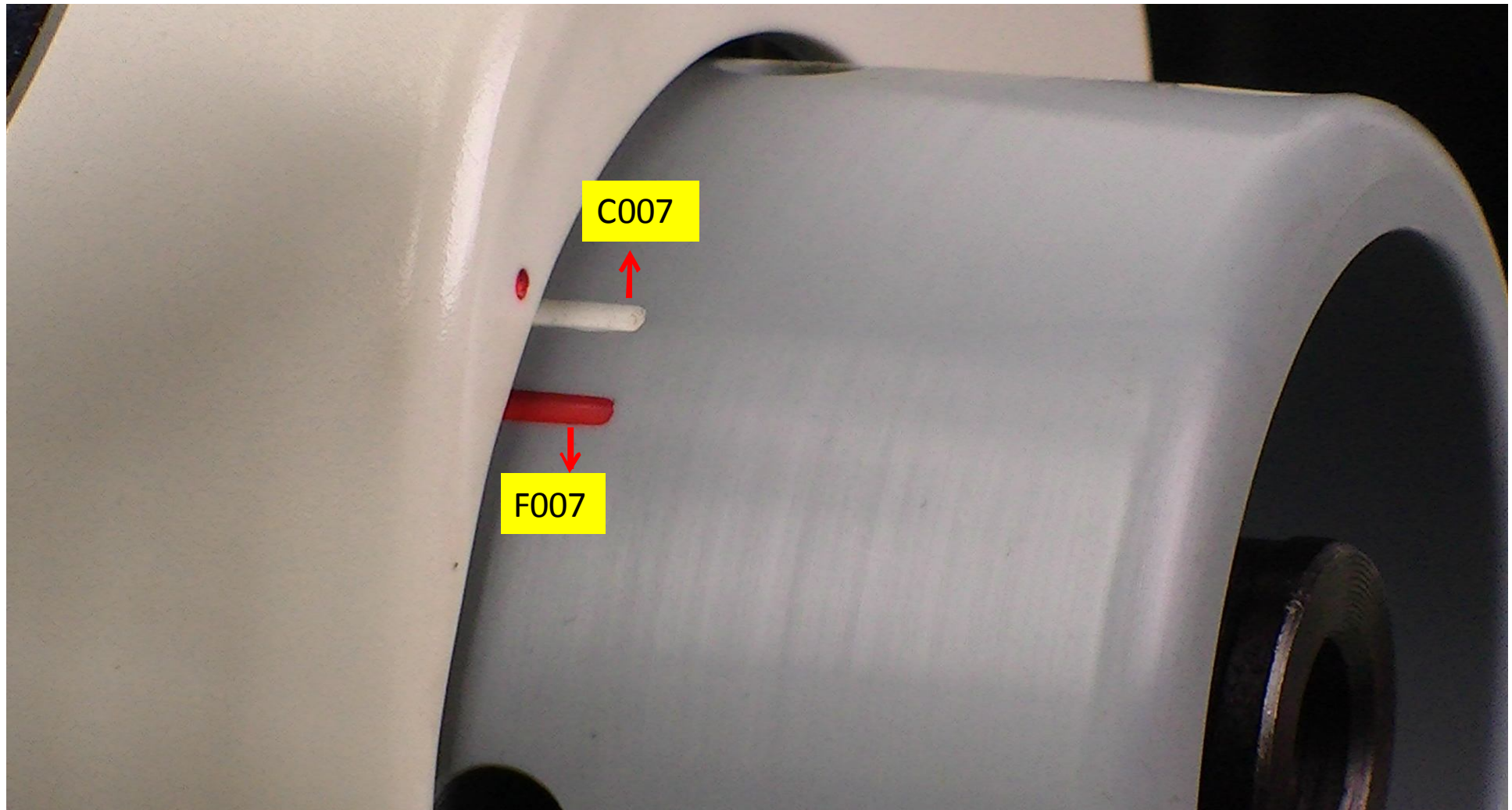
!! 退刀量要以，活動刀口進入固定刀口1.5~2.0mm為基礎。

Attention! The return position is basic on fix knife when overlaps 1.5~2mm.



15停針點 The Original Position in Hand Wheel:

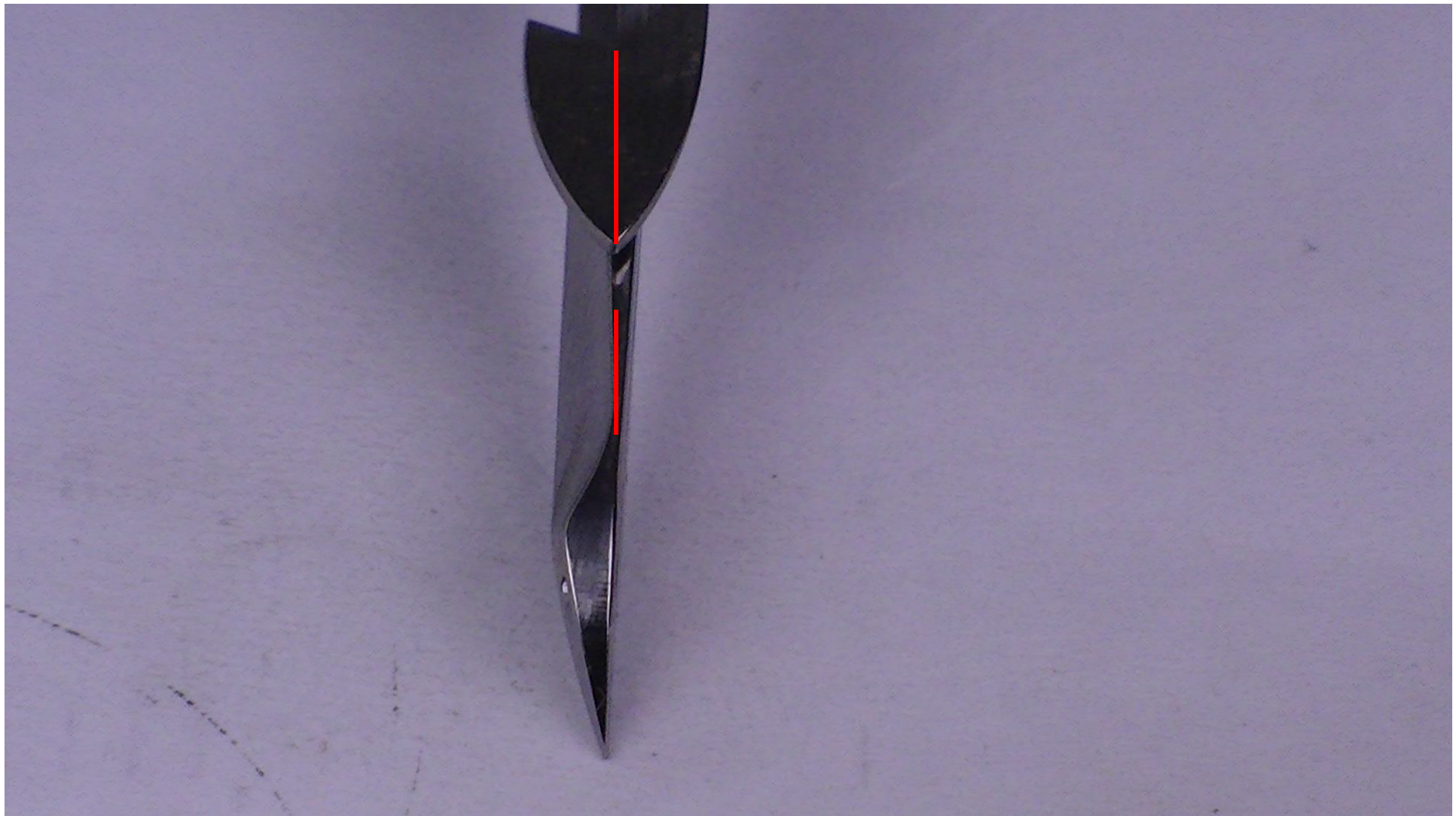
1. 白色是C007停針點。 The white dot for C007 model.
 2. 紅色是F007停針點。 The Red dot for F007 model.
- 如有誤差調整電控參數 If incorrect, set the parameter value.
113. 下停角度 Parameter 113 is needle down position setting.
114. 上停角度 Parameter 114 is needle up position setting.



15-1活動刀(UT507)左右時位 The Position of Movable Knife :

活動刀(UT507)與勾針角度，活動刀的尖端對準勾針針上的斜線。

The peak of movable knife aligns with the arris of looper.



15-2

如有誤差放鬆sm4553調整。

If position incorrect, loose screw SM4543 for adjustment.

