

JUKI®

2-NEEDLE, 3/4-THREAD OVERLOCK SEWING MACHINE

双针三/四线包缝机

MO-644D/644

INSTRUCTION MANUAL

操作指南



IMPORTANT:
READ ALL SAFETY REGULATIONS CAREFULLY
AND UNDERSTAND THEM BEFORE USING YOUR
SEWING MACHINE.
RETAIN THIS INSTRUCTION MANUAL FOR FUTURE
REFERENCE.

要领:
在您使用缝纫机之前, 请仔细阅读并理解所有的安
全操作规程。
请保存好该《操作指南》以备后用。

“IMPORTANT SAFETY INSTRUCTIONS”/ “重要的安全操作规则”

When using an electrical appliance, basic safety precautions should always be followed, including the following: Read all instructions before using this sewing machine.

“DANGER-To reduce the risk of electric shock:”

1. An appliance should never be left unattended when plugged in.
2. Always unplug this appliance from the electric outlet immediately after using and before cleaning.
3. Always unplug before re-lamping. Replace bulb with same type rated 10W(220V).

重点安全说明:

由于本机有电器装置,所以在使用前必须时刻注意最基本的安全规则,阅读所有操作说明。

危险——防电击

- 1、不使用时,请拔去插头。
- 2、用毕和清扫机器时,要拔去插头。
- 3、换灯泡时,要拔去插头,灯泡规格为10W(220V)。

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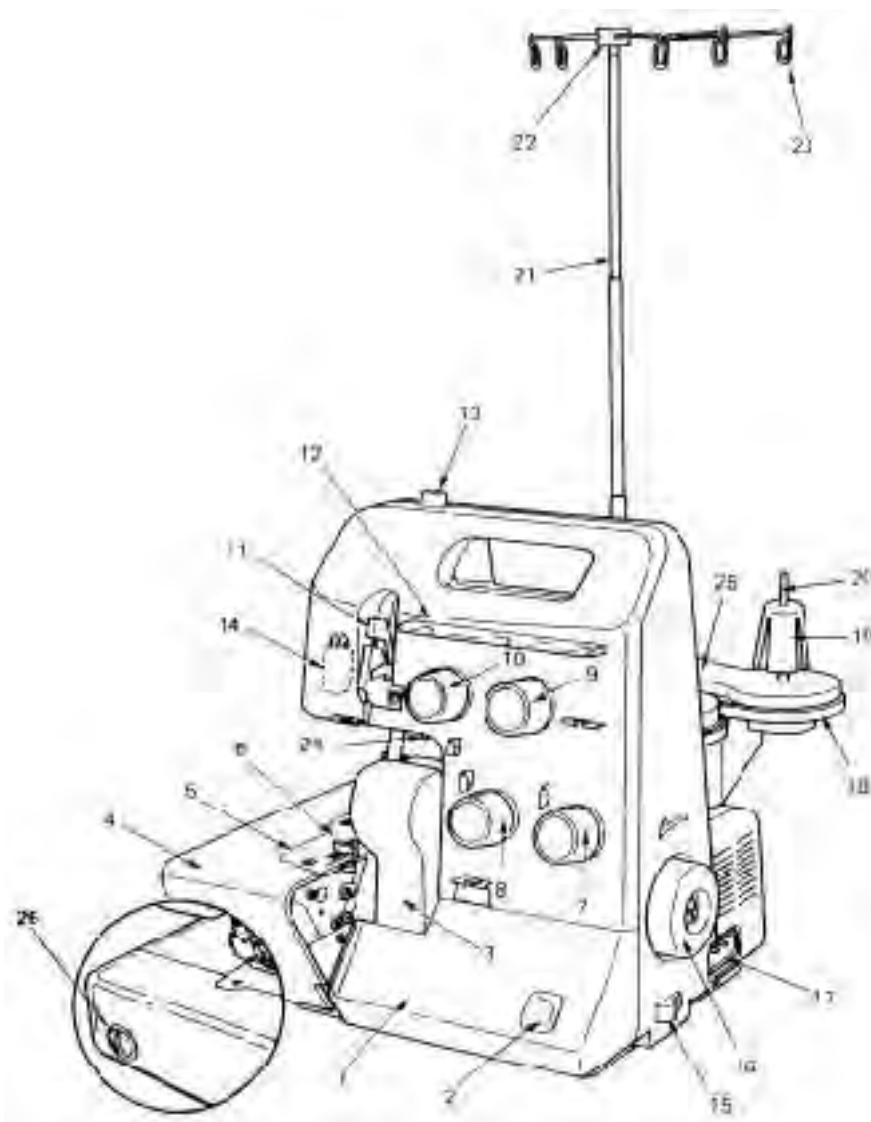
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Details of the machine/各部位的名称

- | | |
|--|---------------------------------------|
| 1. Looper cover | 14. Lamp (located inside) |
| 2. Looper cover opening handle | 15. Power/light switch |
| 3. Chip guard cover | 16. Handwheel (pulley) |
| 4. Cloth plate | 17. Machine socket |
| 5. Throat plate | 18. Spool holders |
| 6. Presser foot | 19. Anti-vibration cone |
| 7. Lower looper thread tension dial | 20. Spool holder pin |
| 8. Upper looper thread tension dial | 21. Retractable support rod |
| 9. Right-hand needle thread tension dial | 22. Thread guide |
| 10. Left-hand needle thread tension dial | 23. Open thread guide |
| 11. Thread take-up cover | 24. Presser foot lifter |
| 12. Thread guide plate | 25. Urethane sheets |
| 13. Presser foot adjusting screw | *26. Differential feed adjusting knob |

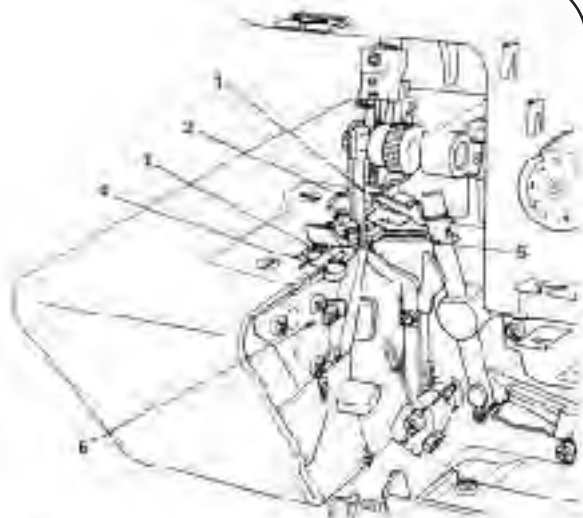
- | |
|--------------|
| 1、弯针罩板 |
| 2、弯针罩板开闭把手 |
| 3、布屑挡板 |
| 4、缝台 |
| 5、针板 |
| 6、压脚 |
| 7、下弯针夹线旋钮 |
| 8、上弯针夹线旋钮 |
| 9、右针夹线旋钮 |
| 10、左针夹线旋钮 |
| 11、挑线杆护罩 |
| 12、线导向板 |
| 13、调压螺钉 |
| 14、照明灯 |
| 15、电源开关 |
| 16、飞轮 |
| 17、插座 |
| 18、线架座 |
| 19、防松垫 |
| 20、插线钉 |
| 21、线架杆 |
| 22、线架帽 |
| 23、挂线导向 |
| 24、抬压脚扳手 |
| 25、海绵垫 |
| *26、差动送料调节旋钮 |



Details of the machine/各部位的名称

View with looper cover open

1. Upper looper
2. Upper knife
3. Lower knife
4. Overlock width selection knob
5. Lower looper
6. Lower knife setscrew



打开弯针罩板所见

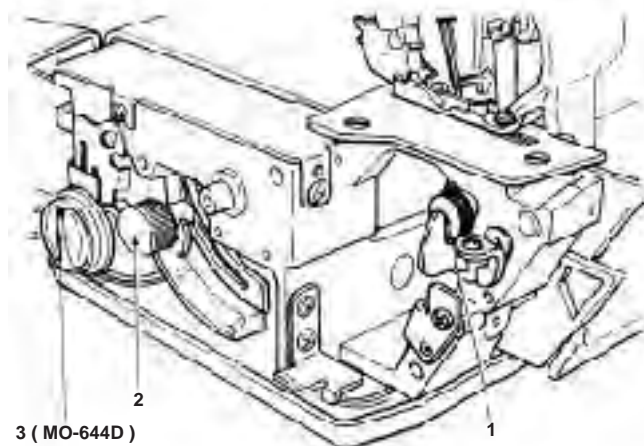
- 1、上弯针
- 2、上刀
- 3、下刀
- 4、包缝宽度选择扳手
- 5、下弯针
- 6、下刀压板螺钉

View with cloth plate open

1. Lower knife adjusting knob
2. Stitch length adjusting knob
- *3. Differential feed adjusting knob

打开缝台

- 1、下刀调节旋钮
- 2、送料距调节旋钮
- *3、差动送料调节旋钮

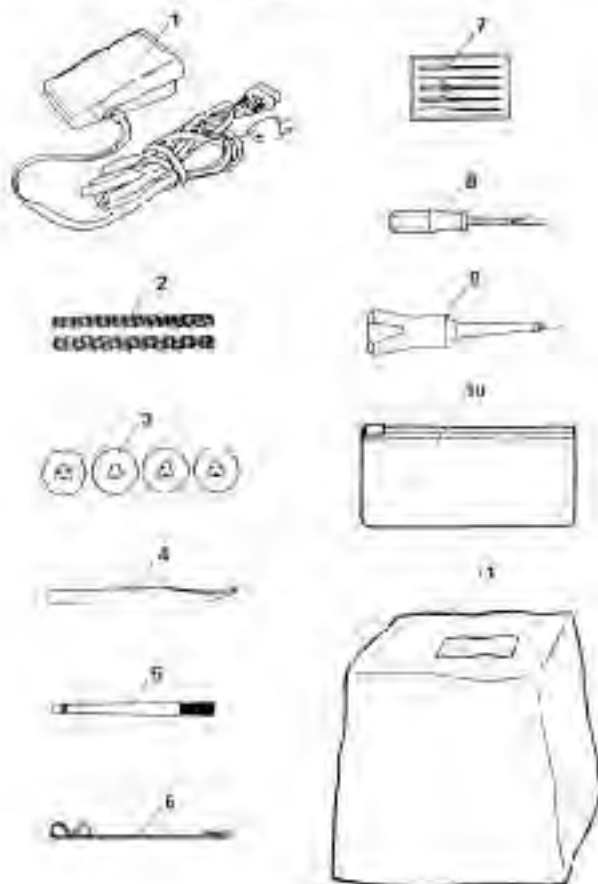


Accessories

1. Foot controller
2. Nets
3. Spool caps
4. Tweezers
5. Cleaning brush
6. Looper threader
7. Needles in the needle box
8. Small screwdriver
9. Oiler
10. Accessory bag
11. Dust cover

附件

- 1、脚踏控速器
- 2、线团网
- 3、线团座
- 4、镊子
- 5、除尘刷
- 6、弯针线穿线勾
- 7、机针盒
- 8、小螺丝刀
- 9、油壶
- 10、附件袋
- 11、机头罩



Assembling thread stand/线架装置安装法



Raise the support rod fully

Turn the thread stand until it engages the positioning stopper (A) with a click.

抽出线架杆

转动线架杆直至听到“卡搭”时,即A处的两球卡入孔中,表明线架杆与止动球啮合。



Put the thread guide on the support rod.

Insert the thread guide into the tip of the support rod so that the arrow in the thread guide comes in front of you.

将线架帽插入线架杆顶部

注意线架帽上的箭头朝您。



Attaching the spool holders

Attach the separately packed spool holder (equipped with two spool holders) to the fixed spool holder.

装入线架座

将另外包装的线架座(配有一付)与已固定在机器上的线架座相连,注意要插足。



For overlock spools

包缝用线及线团防松垫



For large spools

For spools of large inside diameter, position the anti-vibration cone upside down.

大号线团

对于大内径的线团,请将线团防松垫倒置插紧。



For small house-use spools

When using house-use spools, remove the anti-vibration cones.

Place a spool on the spool holder with its notch downward and push the spool caps on with the rounded outside edge at the bottom.

小号家庭用线团

在使用该线团时,去掉线团防松垫,将线团插入插线钉,注意线团缺口朝下,然后按上线团座、并使其凸出部分向上。

Notch/缺口

Preparing machine/运转前准备

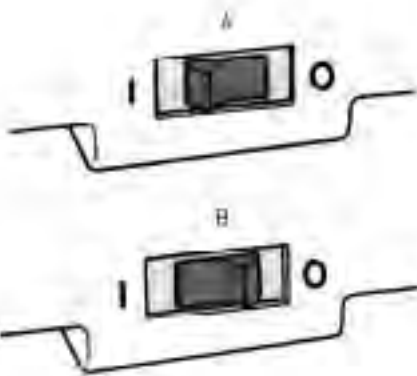


Attaching the foot controller

1. Plug foot controller into machine socket.
2. Plug foot controller into power supply socket.
3. Lay your foot on the foot controller.
Step on the foot controller strongly (deeply), and the sewing speed increases.
Step on the foot controller lightly (shallowly), and the sewing speed decreases.

脚踏控速器的连接

- 1、将脚踏控速器的插头插入机器上的插座。
- 2、将控速器的另一头插头插入电源插座。
- 3、用脚控制速度, 踩浅为慢速, 踩深为快速。



On/Off of the power/light switch

- A: Off
B: On with light

电源开关/照明灯开关

- A: 关
B: 打开照明灯

When you do not use the sewing machine:

1. Turn the power/light switch off. (Press O side.)
2. Pull the machine plug out from the power supply socket.
3. Never place anything on the foot controller.

当您不使用本机时:

- 1、关闭电源开关(为0挡)。
- 2、拔去插头。
- 3、不在控速器上放置任何东西。

Operation and function/操作及功能



Handwheel (pulley)

The handwheel turns toward you.

*Upon completion of threading, at sewing start or sewing end, be sure to turn the handwheel toward you.

飞轮（皮带轮）

飞轮要正转，在侧盖板上箭头指示

* 穿线结束后，开始缝纫时，必须使飞轮沿箭头方向转动。



Opening and closing the looper cover

Opening: To open the looper cover, pull the looper cover opening handle to the right, and tilt the looper cover toward you.

Closing: To close the looper cover, push up the looper cover, press it lightly to the right. The looper cover closes automatically.

弯针罩板的开闭

打开：将弯针罩板向右拉，并沿自己方向旋转。

关闭：将弯针罩板向上翻，并轻轻向右一按，弯针罩板即自动关闭。



Opening and closing the cloth plate

Opening: Press the cloth plate toward the outside.

Closing: Push the cloth plate toward the sewing machine.

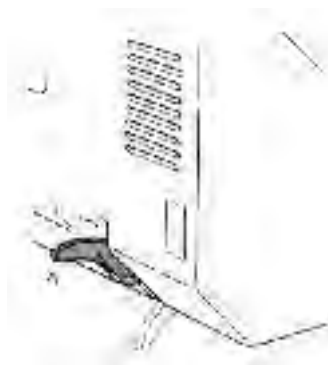
缝台的开闭

打开：将缝台沿箭头方向推。

关闭：将缝台沿打开的相反方向推。

⚠ CAUTION! Moving parts- To reduce risk of injury, switch machine off ("0") before servicing and when opening looper cover, cloth plate, close before using.

⚠ 注意! 以上弯针罩板及缝台的开闭，都必须在开关处于关闭的状态下进行。



Presser foot lifter (To raise the presser foot by the presser foot lifter)

A For regular sewing operation (sewing a medium-weight material), raise the presser foot to position (A) illustrated in the figure.

B When you sew a heavy-weight material, raise the presser foot to position (B) illustrated in the figure, to provide more space between presser foot and throat plate.

抬压脚扳手（可抬起压脚）

A、通常缝纫时(即缝中等厚度的面料)将压脚抬至A位置。

B、在缝制较厚面料时将压脚抬至B位置。

Operation and function/操作及功能

Changing the presser foot

▲ Be sure to turn the power switch OFF.

1. Raise the presser foot.
2. Turn the handwheel until the needles are fully raised.
3. Press point (C) illustrated in the figure, and the presser foot will be released.
4. To release the presser foot, raise the presser foot lifting lever to its highest position (B). Then you can release the presser foot easily.
5. To attach the presser foot, place it so that the presser foot pin (D) comes exactly under the groove in the holder. Lower the presser foot lifting lever and the presser foot will engage automatically.

更换压脚

▲ 请切断电源

- 1、抬起压脚。
- 2、转动飞轮,使机针转至最高点。
- 3、沿箭头按C便可取下压脚。
- 4、将压脚扳手抬至最高位置便可取下压脚。
- 5、换上所需的压脚,使压脚销正好卡在压脚架的凹槽内,放下压脚扳手,压脚便会自动到位。

Releasing the upper knife ▲ Be sure to turn the power switch OFF.

1. Turn the handwheel until the upper knife is fully raised. Open the looper cover.
2. Press the part indicated as (A) in the figure toward the right until it will go no further.
3. Keep pressing (A) and turn the knob on the right side in the direction of the arrow.
4. Turn the knob until the knife reaches position (B).

上刀的解除 ▲ 切断电源

- 1、转动飞轮,使上刀处于最高位置,再打开弯针罩板。
- 2、如图所示,用左手沿箭头A方向将上刀向右按到底。
- 3、左手按着不放,右手沿箭头方向转。
- 4、将旋钮转至B位。

Lower knife adjusting knob (adjusting the lower knife position for cutting width)

▲ Be sure to turn the power switch OFF.

- Open the cloth plate. Raise presser foot.
- Turn the lower knife adjusting knob by pressing part in the figure.
- Close cloth plate cover and lower presser foot.

Reduce cutting width (knife moves to the left) if the edges of fabrics curl up (C).

Increase the cutting width (knife moves to the right) if the loops are too loose (D).

下刀调节旋钮(调节切刀宽度)

▲ 注意切断电源

- 打开缝台,抬起压脚。
- 旋转下刀调节旋钮至所需状态。
- 关闭缝台和放下压脚。

如遇C状态时,表示切刀宽度过宽。

如遇D状态时,表示切刀宽度过窄。

Operation and function/操作及功能



Stitch length adjusting knob (to adjust the stitch length)

Stitch length is adjustable within the range from 1 to 4.

To adjust the stitch length, turn the stitch length adjusting knob and move the knob upwards or downwards.

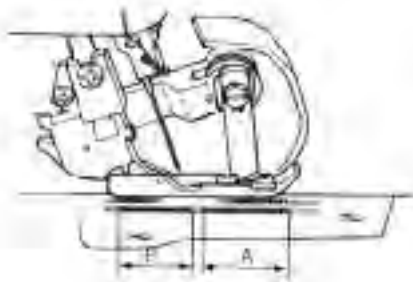
- For normal overlocking stitches set the stitch length adjusting knob at 2 to 3.

送料距调节旋钮

线迹长度可调范围1~4mm。

通过调节送料距调节旋钮,可调线迹的长短。

- 通常包缝设定长度为2~3mm。



*MO-644D

Differential feed adjusting knob (To adjust the feeding for gathering or stretching)

To adjust feeding for gathering or stretching, turn the differential feed adjusting knob upward or downward.

The differential feed prevents fluting or waving in seams in stretchy materials by differentiating the feed of the front feed dog (A) and rear feed dog (B).

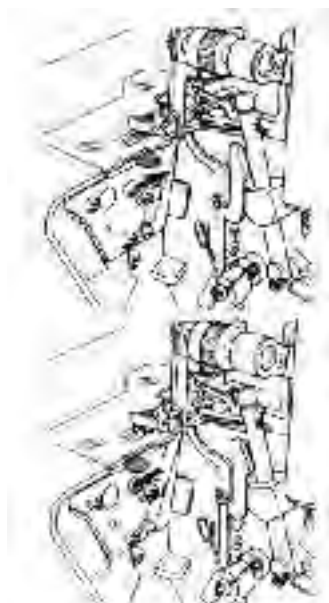


*MO-644D

差动送料调节旋钮(根据收缩或拉伸需要,调节送布量)

要镶面料收缩或拉伸,可旋转差动送料旋钮。

转动差动送料调节旋钮,以调节送布前牙(A)和送布后牙(B)的送料速比,可避免弹性面料的缝口出现缺口或波浪状。



Overlocking width selection knob (For overlocking or roll hemming)

* Turn the handwheel until the needles are fully raised

- For overlocking

Push the overlocking width selection knob back so that it aligns with the rear red marking on the throat plate.

- For roll hemming

- Pull the overlocking width selection knob forward so that it aligns with the front red marking on the throat plate.

切刀宽度调节(用于包缝或卷边)

* 转动飞轮,使机针至最高点。

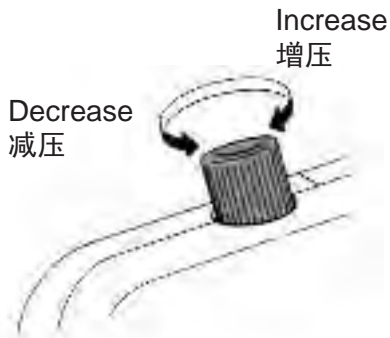
- 包缝时

将包缝宽度选择扳手朝后推,使其与针板后面红色标记对齐。

- 卷缝时

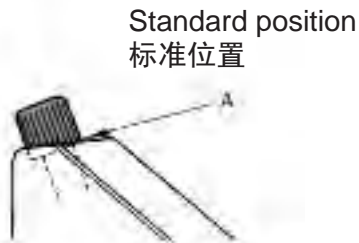
- 将包缝宽度扳手向前拉,使其与针板前面的红色标记对齐。

Operation and function/操作及功能



Increase
增压

Decrease
减压



Standard position
标准位置

Presser foot pressure adjusting screw

Pressure of the presser foot has been factory-adjusted properly.

Therefore you do not need to adjust it except when sewing a special material.

- To increase the pressure of the presser foot: For heavy-weight materials such as denim, tweed, or hard linen.
- To decrease the pressure of the presser foot: For light-weight materials such as georgette, lawn, or tricot.

(A): Standard position: The place where the lower part of control cap aligns with the upper face of cover.

调压螺钉

调压螺钉已由厂方调试适当。

除缝制特殊面料时, 无需再调整。

- 若遇粗棉布、粗花呢等厚料时, 增压。
- 若遇乔其纱、细麻布、针织物时, 减压。

(A): 标准位置: 使压脚调压螺钉下部与机壳的表面相对。



Changing the needles ▲ Be sure to turn the power switch OFF.

- Applying the needle attaching hole (A) of the cleaning brush will help replace the needle ease.

1. Turn the handwheel until the needle are fully raised.
2. Before changing the needles, lower or remove the presser foot.
3. Using a small screwdriver, loosen the needle setscrews and remove the needles.
4. First insert the right-hand needle with the flat side away from you into the needle clamp, making sure it is inserted as far up as possible. Tighten the needle clamp setscrews securely. Insert the left-hand needle in the same way.

Needles used:	Types of needles	Thickness
Right-hand needle	Household type 130/705H	No. 75/11
Left-hand needle	130/705H (JL × 2)	

* When you buy the needles for the sewing machine, select the above type of the needles.

* Apply a JL × 2 needle when sewing heavy-weight materials.



换针 ▲ 请切断电源

- 将所需换的针插入除尘刷柄的A处。

- 1、转动飞轮, 使机针转至最高点。
- 2、换机针前放下或卸下压脚。
- 3、用小螺丝刀松掉支针螺钉, 取下被换机针。
- 4、将右针柄平面向后, 插足, 然后拧紧支针螺钉, 用同样方法换左针。



选取型号	型号	编号
右针	家用 130/705H	No. 75/11
左针	130/705H (JL × 2)	

* 购买机针时, 请选择上面表格的一类型号。

* 缝制厚料时, 左针请购买 JL × 2 型。

Threading/穿线

Thread the machine carefully in the correct sequence.
This is important for making beautiful seams.

Preparation

1. Retractable support rod with thread guide must be fully raised.
2. Open the looper cover and cloth plate.
3. Turn the handwheel toward you until the needles are fully raised.
4. Release the upper knife.

Threading sequence

Clored threading illustrations affixed clearly show the threading sequence.

Thread the machine in the following sequence:

1. Upper looper thread (Blue)
2. Lower looper thread (Red)
3. Right hand needle thread (Green)
4. Left hand needle thread (Yellow)

Theading aids such as tweezers, needle threader, and looper threader which are provided as accessories will be very useful in threading work.

为了缝制出漂亮的线迹,请正确穿线

准备

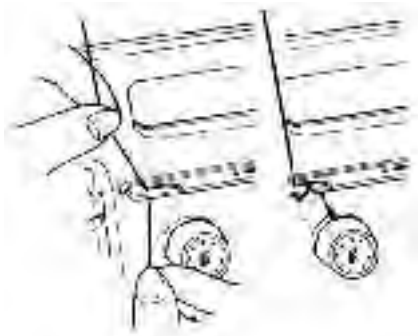
- 1、将线架帽拉至最高点。
- 2、打开弯针罩板和缝台。
- 3、正转飞轮至最高点。
- 4、解除上刀。

穿线顺序

为了明确穿线顺序请按穿线图进行

- 1、上弯针线(蓝色)
- 2、下弯针线(红色)
- 3、右机针线(绿色)
- 4、左机针线(黄色)

为了方便穿线,请使用镊子和机针穿线器,弯针穿线器等附件。

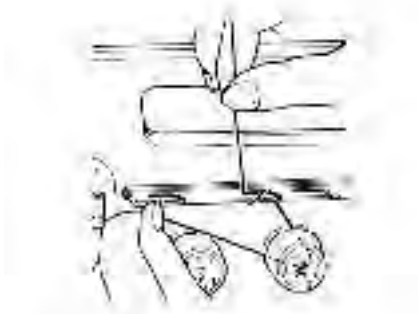


Thread guide plate

Slide thread into the two slits to form an S-loop.

过线板

将线通过两槽口,呈S状挂悬。



Theading the tension dials

To lay the thread correctly between the tension discs, pull the thread lightly with both hands.

通过夹线板

按图正确地将线穿入夹线板,用两手轻拉,使之进入夹入状态。

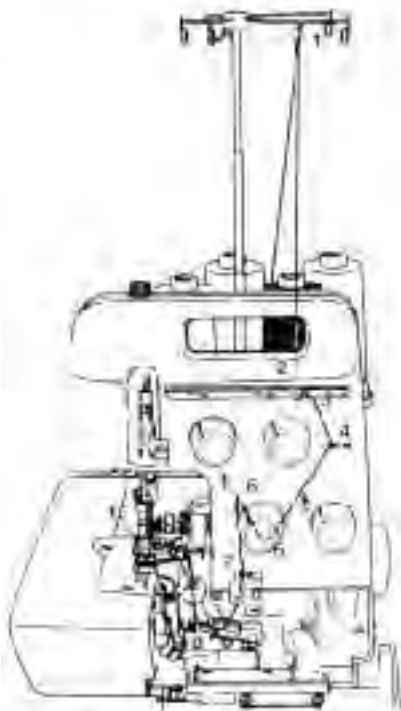
Threading(1)/穿线(1)



1. Upper looper thread (Blue)

Place the spool on the spool holder pin right under blue marking on the retractable support rod thread guide.

- (1) Bring thread up from the rear of the retractable support rod thread guide with blue marking.
- (2,3) Pass the thread through the thread guide plate.
- (4) Bring the thread on to the thread guide.
- (5) Lay the thread between the thread tension dial discs.
- (6, 7, 8, 9, 10, 11) Thread the thread guides
- (12) Turn the handwheel until the upper looper is fully raised.
Thread upper looper eye.
- (13) Pull about 10 cm of the thread out.
Place the thread under the presser foot, and pull the thread from behind the presser foot.



1. 上弯针线(蓝)

将线团插入带有蓝色记号导线勾下面的插线钉上。

- (1)将线挂在有蓝色标记的线勾上。
- (2,3)将线通过导线板。
- (4)将线通过线导向。
- (5)将线嵌入夹线板间。
- (6,7,8,9,10,11)将线通过线导向。
- (12)转动飞轮,使上弯针转至最高点,将线穿入上弯针孔。
- (13)将线拉出约10cm长。
抬起压脚,把线放在压脚下。



Use a net for a hard twisted thread.

When a thread coils around the thread guide due to its hard twist, cover the spools of upper looper and lower looper with attached nets.

遇高捻度的线时,请用线团网。

捻度高的线,易缠绕在过线勾上,这时可用线团网套在上、下弯针线团上。

Threading(2)/穿线(2)



2. Lower looper thread (Red)

Place the spool on the spool holder pin right under red marking on the retractable support rod thread guide.

- (1, 2) Bring thread up from the rear of the retractable support rod thread guide to the front of it.
 - (3, 4) Pass the thread through the thread guide plate.
 - (5) Bring the thread on to the thread guide.
 - (6) Thread the thread tension dial.
 - (7, 8, 9, 10, 11, 12) Thread the thread guides.
 - (13) Using the looper threader, pass the thread from the right through to the left of the sewing machine.
Turn the handwheel toward you until the lower looper is in the left-most position. Insert the thread into the slit on the lower looper.
 - (14) Using the looper threader, pull thread through to the right side again. Turn the handwheel toward you until the lower looper is in the right-most position, and thread the looper eye. Pull the thread up until it lies in the long groove on the lower looper.
 - (15) Pull about 10 cm of the thread out through the upper looper. Raise the presser foot, place the thread under it and then lower the presser foot.
- * If the lower looper thread is broken or slipped, cut the right and left-hand needle threads off at the needle. Then remove the threads.
Thread the lower looper and then the needles.



2、下弯针线(红)

将线团插入带有红色记号导线勾下面的插线钉上。

- (1, 2) 将线挂在有红色标记的线勾上。
 - (3, 4) 将线通过导线板。
 - (5) 将线通过线导向。
 - (6) 将线通过夹线板之间。
 - (7, 8, 9, 10, 11, 12) 将线通过线导向。
 - (13) 用弯针穿线器将线挂在穿线器的弯勾上,转动飞轮使下弯针至最左点,将线挂在下弯针的后槽。
 - (14) 将弯针穿线器向右推,转动飞轮,使下弯针至最右点,将线穿入下弯针孔,然后,拉出足够长的余线。
 - (15) 余线拉至约10cm时,将线与上弯针一道向后拉,抬起压脚,把它们放在针板与压脚板之间,然后放下压脚。
- * 如果下弯针断线或缝线脱落,先剪断左右两机针的缝线,并拉掉缝线。穿好下弯针线,再穿机针线。

Threading(3)(4)/穿线(3)(4)



3. Right-hand needle thread (Green)

Place the spool on the spool holder pin right under the green marking on the retractable support rod thread guide.

- (1, 2) Bring thread up from the rear of the retractable support rod thread guide with the green marking to the front of it.
- (3, 4) Pass the thread through the thread guide plate.
- (5) Thread the thread tension dial.
- (6, 7) Thread the thread tension dial.
- (8) Lay the thread in the notch on the thread take-up lever.
- (9) Thread the thread guide.
- (10, 11) Thread the thread guides on the needle bar.
- (12) Turn the handwheel toward you until the needles are fully raised. Thread the right-hand needle.
- (13) Bring the thread through under the presser foot and pull about 10 cm of the thread out behind the presser foot.

3.右机针线(绿)

将线团插入带有绿色记号导线勾下面的插线钉上。

- (1,2) 将线挂在带有绿色标记的线勾上。
- (3,4) 将线通过导线板。
- (5) 将线通过夹线板之间。
- (6,7) 将线通过线导向。
- (8) 将线通过挑线板护罩。
- (9) 将线通过线导向。
- (10,11) 将线通过机针线导向。
- (12) 转动飞轮,使机针上升至最高,将线穿过右机针孔。
- (13) 拉余线长度约10cm长,并将之放在压脚下。



4. Left-hand thread needle (Yellow)

Place the spool on the spool stand pin right under the yellow marking on retractable support rod thread guide.

- (1) Bring the thread up from the spool to the thread guide and take it through the yellow thread guide.
- (2, 3) Thread the thread guide.
- (4) Thread the thread tension dial.
- (5) Thread the thread guide.
- (6) Lay the thread in the notch on the thread take-up lever.
- (7, 8, 9) Thread the thread guides.
- (10) Thread the left-hand needle. Pull about 10 cm of the thread out from the needle eye.

When threading is completed, lower the upper knife and close the looper cover and cloth plate.

4.左机针线(黄)

将线团插入带有黄色记号导线勾下面的插线钉上。

- (1) 将线挂在带有黄色标记的线勾上。
- (2,3) 将线通过导线板。
- (4) 将线通过夹线板之间。
- (5) 将线通过线导向。
- (6) 将线挂在挑线板护罩上。
- (7,8,9) 将线通过线导向。
- (10) 将线穿过左机针孔,拉余线10cm。

穿线结束,使上、下刀处于啮合位置,并关闭弯针盖和缝台。

3-thread overlocking/3线包缝



4 mm wide 3-thread overlocking (Right-hand needle) (Blue, red, and green)

* Remove the left-hand needle.
Thread in the following order.
(1) Upper looper thread (Blue)
(2) Lower looper thread (Red)
(3) Right-hand needle thread (Green)
* If the machine is already threaded with the left-hand needle cut off and remove the thread.

4mm宽3针包缝(右机针)、(蓝红绿)

* 去掉左针
穿线顺序如下
(1)上弯针线(蓝)
(2)下弯针线(红)
(3)右机针线(绿)
* 当使用该功能时,将左机针拆下。



6 mm wide 3-thread overlocking (Left-hand needle) (Blue, red, and yellow)

* Remove the right-hand needle.
Thread in the following order.
(1) Upper looper thread (Blue)
(2) Lower looper thread (Red)
(3) Left-hand needle thread (Yellow)
* If the machine is already threaded with the right-hand needle thread, cut off and remove the thread.

6mm宽3针包缝(左机针)、(蓝红黄)

* 去掉右针
穿线顺序如下
(1)上弯针线(蓝)
(2)下弯针线(红)
(3)左机针线(黄)
* 当使用该功能时,将右机针拆下。

Trial sewing/试缝



After threading, make a trial sewing.

Be sure to use a double layer of fabric in order to check whether the seam and thread tension are adequate.

1. Set the lower/upper looper, left-hand/right hand needle thread tension dial "4".
2. Make sure that the upper knife is lowered (in the cutting position).
3. Raise the presser foot.
4. Place the fabric under the presser foot.
5. Lower the presser foot and sew.
6. At the end of the seam, continue sewing to form a 5 to 6 cm long thread chain.
7. Holding the fabric with one hand, pull the thread chain over the thread cutter on the presser foot shank.

* Thread tension dial should be properly adjusted according to the types of fabrics and threads to be used.

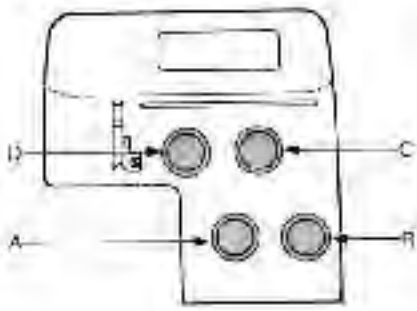
穿线后可进行试缝

注意请用二层面料缝纫,并检查一下,缝口及线是否调整适当。

- 1、将上下弯针,左右机针的线张力都调为“4”。
 - 2、放下上刀,使其处于切布状态。
 - 3、抬起压脚。
 - 4、将面料放在压脚下。
 - 5、放下压脚,开始缝纫。
 - 6、缝至面料末端继续空缝5~6厘米。
 - 7、一手拉面料,同时将要缝线环拉至压脚后的切刀上,将线环拉断。
- * 张力旋钮应根据缝料与缝线的规格进行适当调节。



Thead tension dial/线张力调节旋钮



Adjusting the thread tension

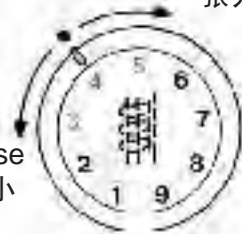
Imperfect stitch formation can be corrected by adjusting the set value (1 to 9) on the thread tension dial.

		Standard of the thread tensioner dial
A	Upper looper thread tension adjusting dial	3~5
B	Lower looper thread tension adjusting dial	3~5
C	Right-hand needle thread tension adjusting dial	3~5
D	Left-hand needle thread tension adjusting dial	3~5

* When using filament thread or wooly nylon thread, adjust the thread tension accordingly.

Increase
张力增大

Decrease
张力减小



调节线张力

线迹不良,可调节旋钮,范围为1~9。

		标准位置
A	上弯针张力调节旋钮	3~5
B	下弯针张力调节旋钮	3~5
C	右机针张力调节旋钮	3~5
D	左机针张力调节旋钮	3~5

当使用锦纶线或尼龙线时,应相应调整张力。

Adjusting the thread tension/调节线张力



Adjusting the thread tension

Turn the thread tension dial in the direction of the arrow, and make a trial sewing.

- A- If the upper looper threads meet on the underside of the fabric:
- B- If the lower looper thread meet on the upper side of the fabric:
- C- If the right-hand needle thread forms loops on the underside of the fabric:
- D- If the left-hand needle thread forms loops on the underside of the fabric:

E- If the fabric puckers during sewing:

* Adjustment can be made by setting the lower knife adjusting knob to the smaller value on the scale.

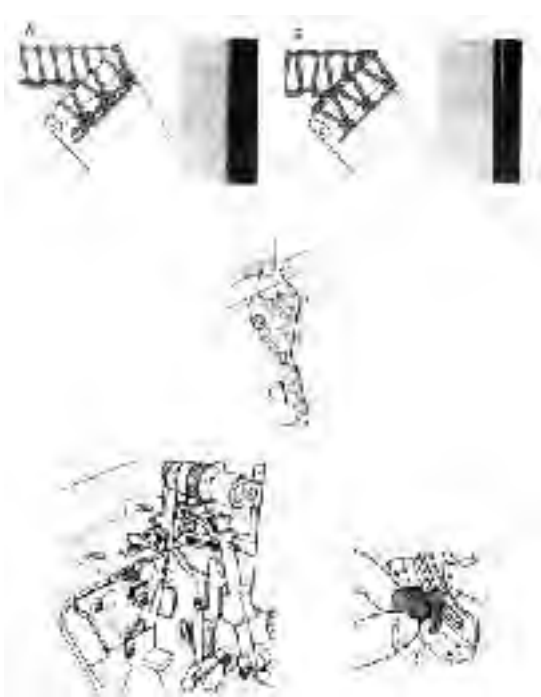
调节线张力

根据箭头方向转动旋钮,并试缝

- A、如果上下弯针线的接点在面料之下:
- B、如果上下弯针线的接点在面料之上:
- C、遇右机针线在面料下面呈环状:
- D、遇左机针线在面料下面呈环状:
- E、遇面料起皱:

* 调节时,请将下刀调节旋钮调到较小数值范围。

Roll hemming/卷边缝



Roll hemmer

The roll hemmer is built-in to the sewing machine. The fabric edge is automatically roled and oversewn. The result is a very fine and narrow edge finishing.

Preparation for roll hemming

1. Remove the left-hand needle and thread the machine as for 3-thread overlocking.
 2. Turn the overlocking width selection knob toward you to align with the red marking in front of the throat plate.
 3. Set the stitch length adjusting knob at "1-1.5".
- * Adjust the thread tensions as desired.

(A): Rolled hem

Rolled hemming stitch sews the fabric edge with the upper looper thread.

(B): Narrow overlock stitch

Narrow overlock stitch is to sew normal overlock stitches of which cutting width is narrower than usual.

卷边缝

卷边装置镶嵌在机器内部,面料边缘可被自动卷起并包缝,效果很好,边缘窄且光滑。

卷边缝准备

- 1、取下左针,使机器呈三线缝纫状。
- 2、将包缝宽度选择扳手朝自己方向拉。
- 3、将送料距调节旋钮调至1-1.5。

*注意须调节线张力

(A): 卷边缝

卷边缝是使上弯针线全部覆盖在卷边面料下方。

(B): 窄边缝

是使卷边面料呈包缝状,但宽度窄于切刀宽度。

Standard thread tension list for roll hemming (rolled hem, narrow overlock stitch)

- Thread tension slightly differs depending on the types of the fabric and thread.
- Use the woolly nylon thread or thinner thread for roll hemming to attain the beautiful finish.
- Use the thin spun thread thinner than #80.
- Woolly nylon thread can be used only for the upper looper.

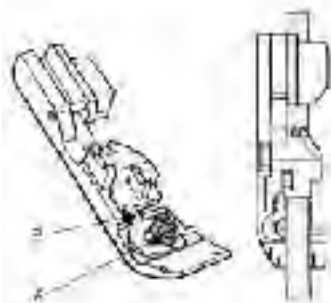
卷边缝线张力调节表

(用于卷边缝和窄边缝)

- 根据面料和缝线情况不同,缝线张力也稍有不同。
- 用毛状尼龙线或较细的线卷边,缝迹会显得较漂亮。
- 用比80#还细的精纺线。
- 毛状尼龙线只能用在在上弯针。

● Thread tension dial value ● 线张力旋钮刻度	● For rolled hem ● 卷边缝			● For narrow overlock stitch ● 窄边缝		
	Right-hand needle 右机针	Upper looper 上弯针	Lower looper 下弯针	Right-hand needle 右机针	Upper looper 上弯针	Lower looper 下弯针
● Thread to be used ● 缝线型号						
● Spun thread #80 ● 精纺线80#	4~6	3~5	7~9	4~6	5~7	4~6
● Filament thread #80 ● 锦纶线80#	3~5	3~5	6~8	3~5	3~5	3~5
● Woolly nylon thread ● 毛状尼龙线		3~5			3~5	

Sewing in tape/镶带缝



Sewing in tape

The standard presser foot is equipped with a tape guide. When sewing shoulders or side seams of stretchy fabrics as a knitted fabric, a tape works effectively to prevent undesirable stretch of the fabric.

1. Turn the handwheel toward you until the needles are fully raised.
2. Raise the presser foot, place the tape in the groove on the presser foot, and lower the presser foot.
3. Loosen the guide adjusting screw (A) to fit the tape guide (B) to the tape width, then tighten the screw.
4. Turn the handwheel manually to make two or three stitches in the tape.
5. Place the fabric to be sewn under the presser foot.
6. Sew, guiding the tape lightly.

镶带缝

标准压脚上备有镶带导向装置,在缝制上衣肩部或延伸性织物边缘时用,可防止面料的伸展。

- 1、正转飞轮,使机针转至最高点。
- 2、抬起压脚,将镶带放入压脚槽,再放下压脚。
- 3、旋松导向装置的调节螺钉,使其与带子宽度相同时再旋紧螺钉。
- 4、用手转动飞轮,使线在带子上缝制2-3针。
- 5、将面料放在压脚下面。
- 6、缝制开始,带子会随面料一同行进。

Unpicking seams

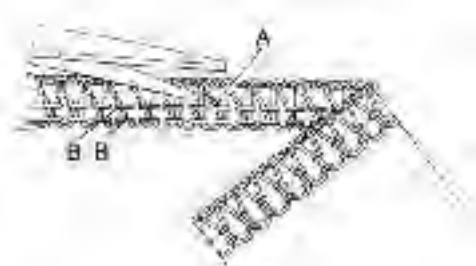
unpicking the seams of the 4 or 3-thread overlock cut the thread at (A) with scissors, and pull needle thread (B).

The stitches will come undeone.

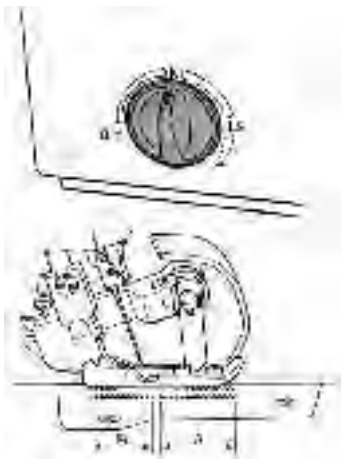
缝口的拆法

将3线或4线包缝拆开

用剪刀在(A)处将线剪断,在(B)处将线拉掉,缝迹就会脱开。



* Differential feed (MO-644D)/差动送料 (MO-644D)



* Differential feed

Gathering and stretching of the fabric can be adjusted by adjusting the differential feed adjusting knob (differentiate the feeding amount of front feed dog (A) or rear feed dog (B)). After adjusted, be sure to sew on trial.

* 差动送料

布料需要打褶或伸展, 可以通过差动送料调节旋钮来调节 (调节送布前牙A和送布后牙B的送布量)。调节后须试缝。

	Sewn with waves 缝口出现波浪		Sewn with puckerings 缝口起皱	
Fabric/面料	<ul style="list-style-type: none"> • Wool knits, thick handknitted garments, and other stretchy fabrics • 毛织物, 手编织物, 其他延伸性面料, 针织面料 	<ul style="list-style-type: none"> • Thin knitted fabric, knitted garments, and jersey • 薄型编织物, 手编织物, 平针织物 	<ul style="list-style-type: none"> • Woven fabrics • 针织面料 	<ul style="list-style-type: none"> • Georgette, linen, satin, poplin • 乔其纱, 亚麻布, 缎子, 毛葛
Set value of the differential feed adjusting knob 可通过调节差动送料调节旋钮实现				
N → 1.5~2		N → 1.5		N

* Gathering (MO-644D)/打褶 (MO-644D)



4-thread gathering
4-线迹缝



3-thread gathering
3-线迹缝



Gathering

1. A single layer of light-weight fabric can be gathered.
2. Set the stitch length adjusting knob at max. "4".
3. Set the differential feed adjusting knob at "1.5-2".

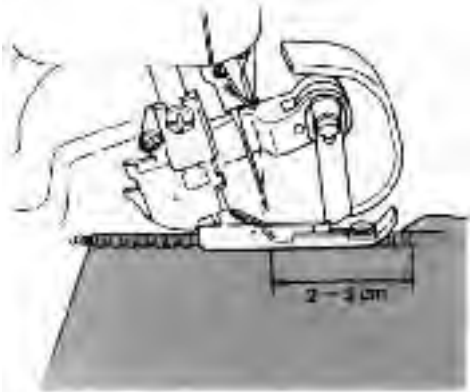
* When sewing without differential feed, set the differential feed adjusting knob at "N".

打褶

1. 单层薄型面料可进行打褶。
2. 将送料调节旋钮调至最大位置“4”。
3. 将差动送料调节旋钮调至“1.5-2”。

* 当无须差动送料, 可将差动送料旋钮调至“N”。

Thread breakage during sewing/缝纫中的断线、缝口合拢



Thread breakage during sewing

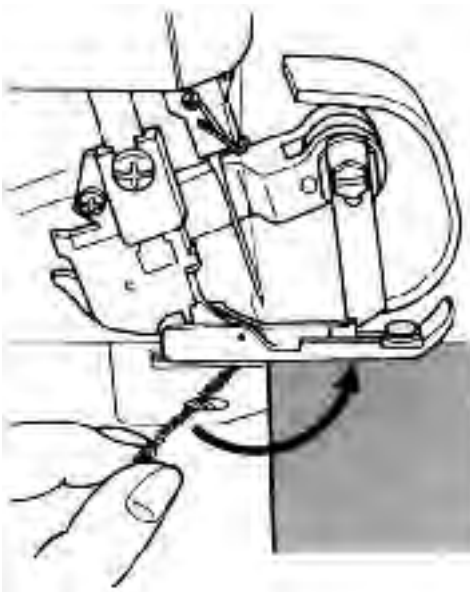
1. Turn the workpiece at a right angle direction and stop sewing immediately. Then remove the workpiece.
2. Rethread
 - * If the lower looper thread is broken, cut the both needle threads off at the needle. Then remove the threads. Thread the lower looper and then the needles.
 - * If the upper looper thread is broken, remove the looper to lowest position. Then thread the looper thread. Bring the thread through under the presser foot and pull about 10 cm of the thread out behind the presser foot.
3. Raise the presser foot, and place the workpiece under the presser foot. Sew about 2 to 3 cm over the seam which has already been sewn before the thread breakage.

缝纫时遇断线

- 1、马上停止缝纫，取出面料。
- 2、重新穿线
 - *如下弯针断线，则要剪断左、右机针线，并拉掉，待下弯针线穿好后，再穿左、右机针线。
 - *如上弯针断线，将弯针转至最下位置，便于弯针重穿。
- 3、抬起压脚放入面料在断线处前面2-3厘米处开始重新缝纫。

Securing seams

1. Sew about 3 to 4 cm of the thread chain at the beginning of seams.
 2. Sew 2 to 3 stitches on the fabric.
 3. Lower the needle and raise the presser foot.
 4. Stretch the thread chain and lay it between the presser foot and the fabric from the left.
 5. Lower the presser foot and sew over the thread chain.
If you do not sew over the thread chain, be sure to leave enough thread chain at the beginning and end of a seam so that it can be knotted or pulled through the stitches with a darning needle.
- * When seams cross over one another, the thread chain is automatically closed.



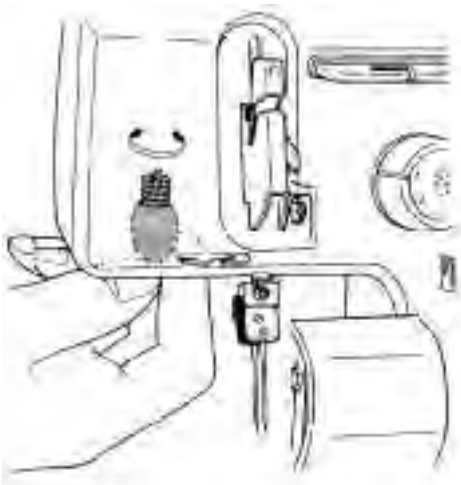
缝口的合拢

- 1、先缝3-4厘米的空环。
 - 2、在面料上缝制2-3针。
 - 3、放下机针，抬起压脚。
 - 4、拉长空环，并从左面把它放入压脚与面料间。
 - 5、放下压脚，将空环与面料一起缝纫。
- 如果空环不缝入，就必须在缝口的始末处留以足够的空环，以便打结或用织补针穿入缝口。
- *当缝口互相交叉时，缝迹便自动闭合。

Maintenance/保养

Replacing the knives

请与购买店联系

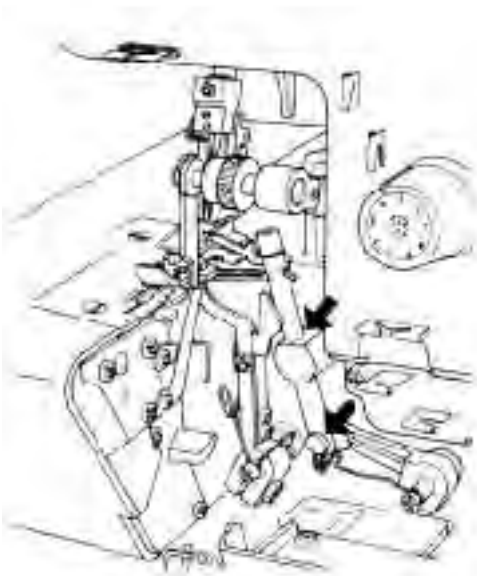


Replacing the bulb

▲ Be sure to turn the power switch OFF.
Unscrew the bulb and replace it with a new one. The power consumption of the bulb is 10W (220V).

更换灯泡

▲ 注意关闭电源。
旋下灯泡, 换上新的, 灯泡的规格10W(220V)。



Cleaning and lubrication

During sewing, dust and fluff collects in and on the machine. Remove the dust and fluff regularly. Your sewing machine requires a little lubrication as the main components of the sewing machine are made from special materials. Apply a few drops of oil to the part illustrated in the figure.

清洁注油

在缝纫过程中, 布屑和绒毛会散落在机器表面和内部, 所以必须经常清理。由于机器的一些重要零件制作工艺特殊, 故需要注油润滑, 如图所示部位注上数滴油即可。

Before you call for help: Troubles and corrective measures

The following problems should not be regarded as the machine trouble. Check the following table before you call for help from us.

Trouble	Cause (reason)	Corrective measures	Page for reference
Fabric does not feed.	<ul style="list-style-type: none"> ● Presser foot pressure is too low. 	Increase the presser foot pressure by turning the presser foot pressure adjusting screw to the right.	8
Needles break	<ul style="list-style-type: none"> ● Needles are bent, or the needle point is blunt. ● Needles are incorrectly attached. ● The material cloth is excessively stretched. 	Replace the needles. Attach the needle correctly. Hold the edge of the material cloth lightly with your hand when sewing.	8 8 -
Thread breaks	<ul style="list-style-type: none"> ● The machine is incorrectly threaded. ● Thread tension is too high. ● Needles are incorrectly attached. 	Rethread the machine correctly. Attach the thread tension properly. Attach the needles correctly.	9-12 14 8
Stitch skips	<ul style="list-style-type: none"> ● Needles are bent or needle point is blunt. ● Needles are incorrectly attached. ● The machine is incorrectly threaded. 	Replace the needles. Attach the needles correctly. Retread the machine correctly.	8 8 9-12
Poor stitches are formed	<ul style="list-style-type: none"> ● Thread tension is not proper. 	Adjust the thread tension properly.	14
Seams flute or wave, especially when sewing knits	<ul style="list-style-type: none"> ● Presser foot pressure is too high. * Differential feed is set incorrectly. 	Reduce presser foot pressure. * Adjust differential feed to N-2.	8 17
Seams pucker	<ul style="list-style-type: none"> ● Thread tension is too high. * Differential feed is set incorrectly. 	Set the thread tension adjusting dial to the smaller value. * Adjust differential feed to 0.7-N.	14 17
Motor trouble	<ul style="list-style-type: none"> ● The motor makes noise. ● The motor will not rotate. ● Unusually large sparks are emitted. 	Replace the carbon brush.	-

When the trouble is not corrected by the above measures, contact your local dealer.

在报修前:故障及处理方法

下列故障并非机械故障, 请先查阅下表, 再向我们提出报修






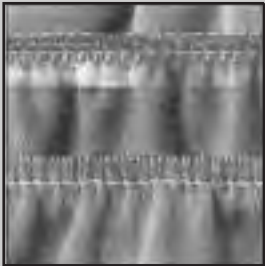

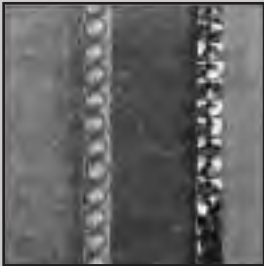

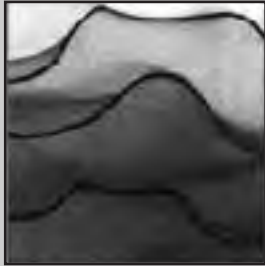

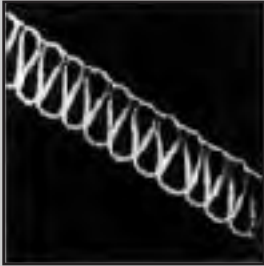


故障	原因	处理方法	参考页次
面料不行进	<ul style="list-style-type: none"> ● 压脚压力太小 	将调压螺钉向右旋, 以增加压脚压力	8
断针	<ul style="list-style-type: none"> ● 机针弯曲或针尖磨损 ● 机针装错 ● 缝料拉得过长 	换针 正确装针 缝制时用手轻拉布边	8 8 -
断线	<ul style="list-style-type: none"> ● 穿线错误 ● 线张力过强 ● 机针装错 	重新正确穿线 适当调节线张力 正确装针	9-12 14 8
跳针	<ul style="list-style-type: none"> ● 机针弯曲或针尖磨损 ● 机针装错 ● 穿线有误 	换针 正确装针 重新正确穿线	8 8 9-12
线迹成形不好	<ul style="list-style-type: none"> ● 线张力不当 	合适调节线张力	14
缝口凹陷波状 尤以针织物常见	<ul style="list-style-type: none"> ● 压脚压力太大 * 差动送料调节旋钮位置不对 	减小压脚压力 * 将差动旋钮调至N-2	8 17
缝口起皱	<ul style="list-style-type: none"> ● 线张力过强 * 差动旋钮位置不对 	将线张力调至较小值 * 将差动旋钮调至0.7-N	14 17
马达故障	<ul style="list-style-type: none"> ● 马达噪音 ● 马达不转 ● 出现罕见的火花 	更换电机碳刷	-

如还不能排除故障, 则与购买商联系

Specifications/规格

Item	Specifications	项 目	规 格
Number of threads	4 threads, 3 threads	缝线数	4线, 3线
Needles	Right-hand needle 130/705H Left-hand needle 130/705H (JL×2)	机针	右:130/705H 左:130/705H(JL×2)
Overlocking width	Left-hand needle: 6 mm Right-hand needle: 4 mm (for roll hemming: 2 mm)	包缝宽度	左针:6mm 右针:4mm (卷边2mm)
Stitch length (feeding amount)	1 to 4 mm (standard stitch length: 2.5 mm)	针迹长度(送料量)	1-4mm(标准长2.5mm)
* Differential feed	No waving or fluting in knits N-2. No puckering 0.7-N	差动送料	针织品无波纹;延伸N-2 无起皱0.7-N
Presser foot lift	5 mm	压脚升降高度	5mm
Sewing speed	Max. 1,500 s.p.m.	缝速	最大1500针/分
Dimensions	270 (W)×345 (D)×295 (H) mm	外形尺寸	270 (W)×345 (D)×295 (H) mm
Weight	7.0kg	重量	7.0kg
Foot controller	220V..... MODEL YC-483N	脚踏控速器	220V..... MODEL YC-483N

Optional accessories/另购附件

<ul style="list-style-type: none"> ● Blind stitch presser foot ● 暗缝压脚  	<ul style="list-style-type: none"> ● Piping presser foot ● 滚带压脚  
<ul style="list-style-type: none"> ● Elasticator ● 弹簧压脚  	<ul style="list-style-type: none"> ● Beading presser foot ● 珍珠压脚  
<ul style="list-style-type: none"> ● Cording presser foot ● 花边压脚  	<ul style="list-style-type: none"> ● 2/3 Thread Converter ● 2/3切换器  
<ul style="list-style-type: none"> ● Gathering presser foot ● 聚裊压脚  	<p>Contact your local dealer. 如需上述附件, 请与购买店联系</p>

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