

2-NEEDLE, 2/3/4/5-THREAD OVERLOCK SEWING MACHINE**双针二/三/四/五线包缝机**

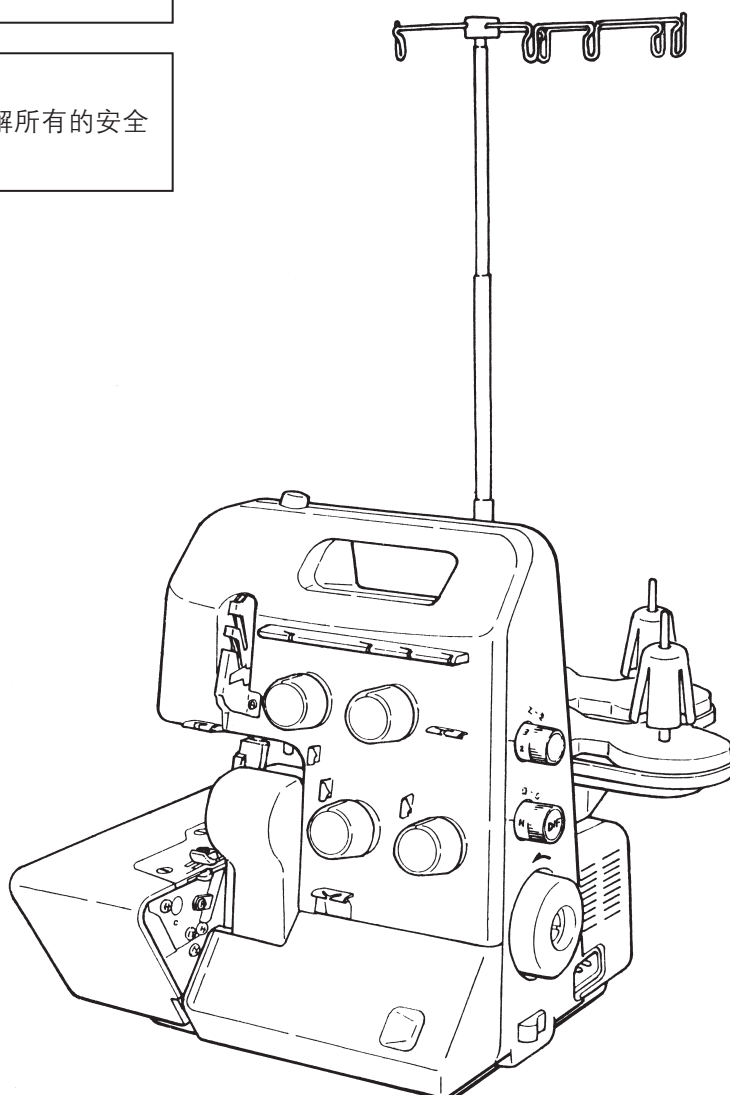
MO-655N

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。



“IMPORTANT SAFETY INSTRUCTIONS”

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. The appliance should never be left unattended when plugged in.
2. Always unplug this appliance from the electric outlet immediately after using and before cleaning.

“WARNING ____ To reduce the risk of burns, fire, electric shock, or injury to persons:”

1. Do not use the appliance as a toy. Caution is advised when the appliance is used by children, or near children. This sewing machine can be used by children aged from 8 years and above and persons with reduced physical, sensory or mental capabilities or lack of experience and knowledge if they have been given supervision or instruction concerning use of the sewing machine in a safe way and understand the hazards involved. Children shall not play with the sewing machine. Cleaning and user maintenance shall not be made by children without supervision.
2. Use this appliance only for its intended use as described in this manual. Use only attachments recommended by the manufacturer as contained in this manual.
3. Never operate this appliance if it has a damaged cord or plug, if it is not working properly, if it has been dropped or damaged, or dropped into water. Return the appliance to the nearest authorized dealer or service center for examination, repair, electrical or mechanical adjustment.
4. Never operate the appliance with any air openings blocked. Keep ventilation openings of the sewing machine and foot control free from the accumulation of lint, dust, and loose cloth.
5. Keep fingers away from all moving parts. Special care is required around the sewing machine needle and knife.
6. Always use the proper throat plate. The wrong plate can cause the needle to break.
7. Do not use bent needles.
8. Do not pull or push fabric while stitching. It may deflect the needle causing it to break.
9. Do not carry out sewing with a marking pin stuck in the material since doing so can cause knife/needle breakage. In addition, do not attempt to cut anything other than fabric and thread with the upper/lower knives.
10. Switch the sewing machine off “O” when making any adjustments in the needle area, such as threading needle, changing needle, threading looper, or changing presser foot and the like.
11. Always unplug the machine from the electrical outlet when removing covers, when covers are opened to thread the loopers, when lubricating or when making any other user servicing adjustments mentioned in the instruction manual.
12. Never drop or insert any object into any opening.
13. Do not use outdoors.
14. Do not operate where aerosol (spray) products are being used or where oxygen is being administered.
15. To disconnect, turn all controls to the off “O” position, then remove plug from outlet.
16. Do not unplug by pulling on cord. To unplug, grasp the plug, not the cord.
17. Basically, the machine should be disconnected from the electricity supply when not in use.
18. If the supply cord is damaged, it must be replaced by the manufacturer, its service agent or similarly qualified persons in order to avoid a hazard.
19. (Except USA/Canada) This machine is provided with double insulation.
Use only identical replacement parts. See instructions for servicing Double-Insulated machine.

“SERVICING DOUBLE-INSULATED PRODUCTS (Except USA / Canada)”

In a double-insulated product, two systems of insulation are provided instead of grounding. No grounding means is provided on a double-insulated product nor should a means for grounding be added to the product. Servicing a double-insulated product requires extreme care and knowledge of the system and should only be done by qualified service personnel. Replacement parts for a double-insulated product must be identical to those parts in the product. A double-insulated product is marked with the words DOUBLE INSULATION or DOUBLE INSULATED.

The symbol  may also be marked on the product.

“SAVE THESE INSTRUCTIONS”

“This overlock sewing machine is intended for household use only.”

Congratulations on your purchase of a JUKI sewing machine.

Please be sure to read safety precautions in “To use the sewing machine safely” in the Instruction Manual before use to fully understand the functions and operating procedures of the sewing machine so as to use the sewing machine for a long time.

After you have read the Instruction Manual, please be sure to keep it together with the warranty so that you can read it whenever necessary.

The warranty does not apply to any failures under conditions other than normal state use (failures that occur in the case the sewing machine is used without following the Instruction Manual or precautions given on the labels attached to the main body), and consumable parts (such as needles and knives). For warranty information, check the contents of the separate warranty.

To use the sewing machine safely

Marks and pictographs included in the Instruction Manual and shown on the sewing machine are used so as to ensure safe operation of the sewing machine and to prevent possible risk of injury to the user and other people.

Warning marks are used for different purposes as described below.

 WARNING	Indicates that there is a possible risk of death or serious injury if this mark is ignored and the sewing machine is used in a wrong manner.
 CAUTION	Indicates the operation, etc. which can cause a possible risk of personal injury and/or physical damage if this mark is ignored and the sewing machine is used in a wrong manner.

Pictographs mean the following:

	Danger warning which is not specified		There is a risk of electrical shock		There is a risk of fire		There is a risk of injury to hands, etc.
	Prohibited matter which is not specified		Disassembly/alteration is prohibited		Do not place fingers under the needle		Do not pour oil, etc.
	Generally required behavior		Disconnect the power plug				

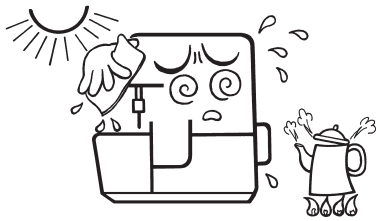
⚠ WARNING

For the combination of the material and the thread and needle, in particular, refer to the explanation table in “Replacement of the needle”.

If the needle or thread does not match the material used such as in the case that an extra heavy-weight material (e.g., denim) is sewn with a thin needle (#11 or higher), the needle can break resulting in an unexpected personal injury.

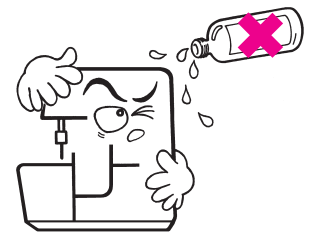
Other precautions

- Do not put the sewing machine under the direct sunlight or in a humid place.



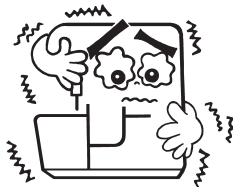
- Do not wipe the sewing machine with solvent such as thinner.

When the sewing machine is soiled, put a small quantity of neutral detergent on a piece of soft cloth and carefully wipe off the sewing machine with it.



Be aware that the following state can take place since the sewing machine incorporates semi-conductor electronic parts and precise electronic circuits.

- Be sure to use the sewing machine in the temperature range from 5°C to 40°C. If the temperature is excessively low, the machine can fail to operate normally.



* The operating temperature of the sewing machine is between 5°C and 40°C. Do not use the sewing machine under the direct sunlight, near the burning things such as a stove and candle, or in a humid place. By so doing, the temperature in the interior portion of the sewing machine can rise or the coating of the power cord can melt, causing fire or electrical shock.

LED light

- Rated Voltage: 9V
- Maximum power consumption: 1.3W

重要安全注意事项

使用缝纫机前请详细阅读本说明书，务必遵循以下要点

危险—为了减少触电的危险：

1. 当缝纫机接上电源后，请勿离开。
2. 机器使用后或清洁前请拔下电源插头。

警告—为了防止触电、受伤、火警的发生，务必遵循以下要点：

1. 勿将缝纫机充当玩具使用，当儿童接近时需特别注意。8 岁以上的儿童及精神状况不佳或是缺乏使用缝纫机经验与常识的人，需有人监督或指导安全地使用缝纫机的方法，并了解相关的危险。儿童勿用缝纫机玩耍，有人监督时也勿由儿童清洁及保养缝纫机。
2. 请依说明书指示操作缝纫机，并使用说明书上建议使用的附属品。
3. 当电线或插头损坏、动作不良、摔落受损或掉落水中，请即刻将缝纫机送至最近的授权经销商或维修中心做维修检查。
4. 缝纫机及脚踏控制器之通风口应保持畅通清洁，如有杂物应先清除才可使用。
5. 勿让手指接触转动的零件，尤其是缝纫机的各种针和刀。
6. 使用合适的针板，错误的针板会导致车针折断。
7. 勿使用弯曲、受损的车针。
8. 缝纫时请勿拉扯或推挤布料，以免车针偏移折断。
9. 不要在有记号笔或粘性物质附着的布料上缝纫，会引起机针和切线器的断裂。不要试图用上/下切刀切割除织物和缝线的其它物质。
10. 调整机针任何部位前，如机针穿线、换机针、穿线环或换压脚等类似动作时，请将缝纫机电源关闭。
11. 当拆卸外盖，加润滑油或执行本说明书所提到的任何其它维修调整时，务必拔去电源插头。
12. 缝纫机任何开启部位，绝不可放入任何异物。
13. 本缝纫机仅供室内使用。
14. 请勿使用液化气体（喷雾）产品或供给氧气的地方使用缝纫机。
15. 拔下电源插头前，请先将电源关闭，再拔下插头。
16. 请握住插头将电源线拔离插座，切勿直接拉扯电线将插头拔下。
17. 基本上，不使用缝纫机时，请不要连接电源线。
18. 如果电源线损坏，必须由制造商，服务代理或类似的合格人员更换，以避免危险。
19. （除美国/加拿大）本缝纫机具有双重绝缘。更换时需要使用使用相同的零件。维修双重绝缘机时，请参见双重绝缘产品服务的内容。

维修双重绝缘产品（除美国/ 加拿大）

采用双重绝缘的产品可不使用接地，否则应在产品中加入接地维修。在双重绝缘的产品中，采用两套绝缘系统取代接地。采用双重绝缘的产品需特别小心且对系统有高度的了解，并仅可由合格的维修人员执行双重绝缘产品的替换，零件需完全采用原厂零件，双重绝缘产品会标记以下字样：“DOUBLE INSULATION”或“DOUBLE INSULATED”产品上可能会标示有符号“”

本说明书请妥善保管：

本缝纫机仅供家庭使用。

感谢您购买了JUKI缝纫机。

在您使用本机器前，请务必阅读本说明书中“安全地使用缝纫机”的安全注意事项。充分地了解缝纫机的功能和操作程序，可使缝纫机长久使用。

当您阅读完本说明书，请与保证卡放在一起，以便您需要时可阅读。

在正常使用状态以外的情况下产生的故障（不按照使用说明书或者粘贴在主机上的标签等注意事项使用时而产生的故障）以及消耗品（机针、切刀等）不属于保修对象。

关于保修，请另行确认保修书上的内容。

由于产品改良，主机的颜色、设计、规格等可能会在没有预告的情况下进行变更，敬请谅解。

服务手册会有为了进行改善而有变更的情况存在。

安全地使用缝纫机

缝纫机上及本说明书上所标示的符号、图示。是要确保缝纫机的操作安全及防止造成使用者及他人损伤的可能风险。如下所述，警告符号各有不同的目的。

 警告	如果忽视此符号及错误地使用缝纫机，会有死亡或严重伤害的可能风险。
 注意	如果忽视此符号及错误地使用缝纫机，操作时会引起人生伤害的可能风险。

如下所示图示的含义：

	无明确规定的危险警告		有触电危险		有火灾危险		有手受伤的危险
	无明确规定的禁止事项		禁止拆装 / 改造		手指切忌放在机针下方		不要加油
	一般规范行为		请拔去插头				

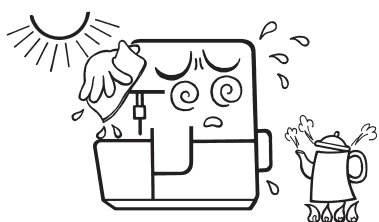
! 警告

材料、线及针的各项组合，请特别要参照“交换针”的说明表。

如果针或线不适合布料时，例如使用细针（11 号针或更细）缝制厚料（如：劳动布）时，针可能会折断并造成伤害的意外。

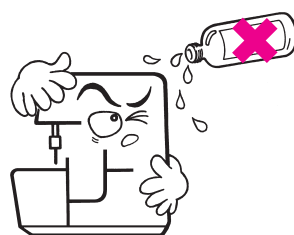
其它安全注意

- 不要将缝纫机直接暴露在阳光或潮湿的环境中。



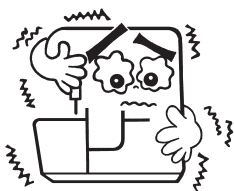
- 不要使用稀释剂或类似溶剂清洁缝纫机。

当缝纫机有脏污时，请使用软布沾上少量中性清洁剂，小心地擦拭缝纫机。



由于本机内装有半导体电子元件和精密电路板，请注意下列情况的发生。

- 请在 5-40° 的环境中使用本产品。如果温度过低，本缝纫机可能无法正常使用。



※ 缝纫机的正常操作温度是在5-40°，不要将缝纫机直接暴露在阳光、靠近火源（如火炉）或潮湿环境中。如果不注意，缝纫机内部温度上升会融化电源线的涂层，引起火灾或触电。

LED照明

- 额定电压：9V
- 最大耗电量：1.3W

Contents / 内容

IMPORTANT SAFETY INSTRUCTIONS	• Overlocking width selection knob..... 10	Trial sewing
Details of the machine..... 1,2	• Presser foot pressure adjusting screw..... 10	• After threading, make a trial sewing..... 28
• Accessories..... 2	• Changing the needles..... 11	Adjusting the thread tension..... 29,30
Assembling thread stand..... 3,4	Stitch chart..... 12	Sewing in tape..... 31
Preparing machine	Threading	Roll hemming..... 32,33
• Attaching the foot control..... 5	• Preparation..... 14	Differential feed..... 34
• On/Off of the power/light switch..... 5	Threading: 5-thread overlock	Gathering..... 35
Operation and function	(chainstitch & 3-thread overlock)..... 15-19	Unpicking seams..... 35
• Handwheel (Pulley)..... 6	Chainstitch & wide 3-thread overlock..... 20	Thread breakage during sewing..... 36
• Opening and closing the looper cover..... 6	2-thread chainstitch..... 21	Securing seams..... 37
• Opening and closing the cloth plate..... 6	Threading: 4-thread overlock..... 22-25	Maintenance
• Presser foot lifter..... 7	3-thread overlocking	• Replacing the upper knife..... 38
• Changing the presser foot..... 7	• 4mm wide 3-thread overlocking..... 26	• Cleaning and lubrication..... 39
• Releasing the upper knife..... 8	• 6mm wide 3-thread overlocking..... 26	Troubles and corrective measures..... 40
• Lower knife adjusting knob..... 8	How to use the 2/3 thread converter..... 27	Specifications..... 42
• Stitch length adjusting knob..... 9		Optional Accessories..... 43
• Differential feed adjusting knob..... 9		

重要的安全操作规则	• 包缝宽度选择扳手..... 10	试缝
各部位的名称..... 1,2	• 压脚压力调节旋钮..... 10	• 穿线后, 进行试缝..... 28
• 附件..... 2	• 更换机针..... 11	调节线张力..... 29,30
组装线架..... 3,4	针迹对照表..... 13	镶带缝..... 31
运转前准备	穿线	卷缝..... 32,33
• 脚踏控速器的连接..... 5	• 准备工作..... 14	差动送料..... 34
• 主电源/照明灯开关..... 5	穿线: 5线包缝	打裱..... 35
操作及功能	(链缝&3线包缝)..... 15-19	缝口的拆法..... 35
• 飞轮 (皮带轮)..... 6	链缝&3线宽包缝..... 20	缝纫中断线..... 36
• 弯针罩板的开闭..... 6	2线链缝..... 21	缝口的收拢..... 37
• 缝台的开闭..... 6	穿线: 4线包缝..... 22-25	保养
• 压脚扳手..... 7	3线包缝	• 更换上刀..... 38
• 更换压脚..... 7	• 4 mm 宽3线包缝..... 26	• 清洁注油..... 39
• 翻转上刀..... 8	• 6 mm 宽3线包缝..... 26	故障排除指南..... 41
• 下刀调节旋钮..... 8	2/3线转换器..... 27	规格..... 42
• 针距调节旋钮..... 9		另购附件..... 43
• 差动送料调节旋钮..... 9		

Details of the machine

各部位的名称

1. Looper cover

2. Looper cover opening handle

3. Chip guard cover

4. Cloth plate

5. Throat plate

6. Presser foot

7. Lower looper thread tension dial

8. Upper looper thread tension dial

9. Right-hand needle thread tension dial

10. Left-hand needle thread tension dial

11. Thread take-up cover

12. Thread guide plate

13. Presser foot adjusting screw
14. LED light

15. Power/light switch

16. Handwheel (pulley)

17. Machine socket

18. Spool holders

19. Anti-vibration cone

20. Spool pin

21. Retractable support rod

22. Thread guide

23. Open thread guide

24. Presser foot lifter

25. Anti-vibration pad

26. Stitch length adjusting knob

27. Differential feed adjusting knob

1. 弯针罩板

2. 弯针罩板开关凹槽

3. 布屑挡板

4. 缝台

5. 针板

6. 压脚

7. 下弯针线张力调节旋钮

8. 上弯针线张力调节旋钮

9. 右机针线张力调节旋钮

10. 左机针线张力调节旋钮

11. 挑线杆护罩

12. 线导向板

13. 压脚调节旋钮

14. LED照明

15. 电源/照明开关

16. 飞轮

17. 插座

18. 线架座

19. 防松垫

20. 插线钉

21. 线架棒

22. 线架帽

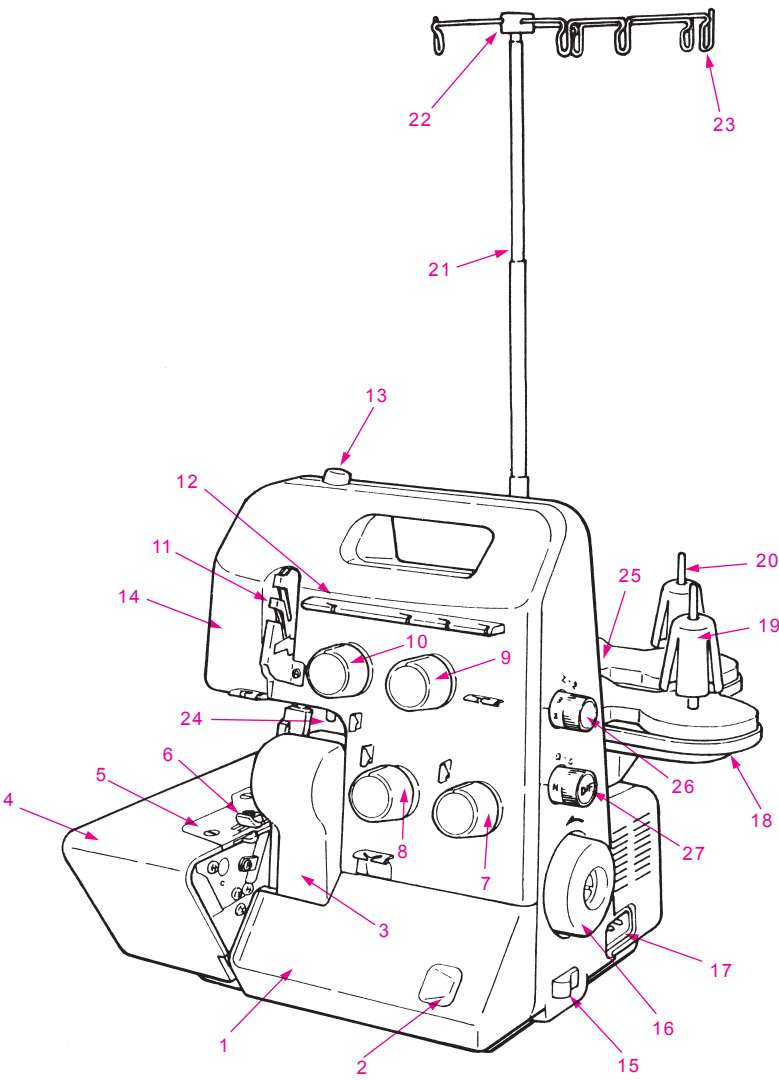
23. 挂线导向

24. 抬压脚扳手

25. 防震垫

26. 针距调节旋钮

27. 差动送料调节旋钮



Details of the machine

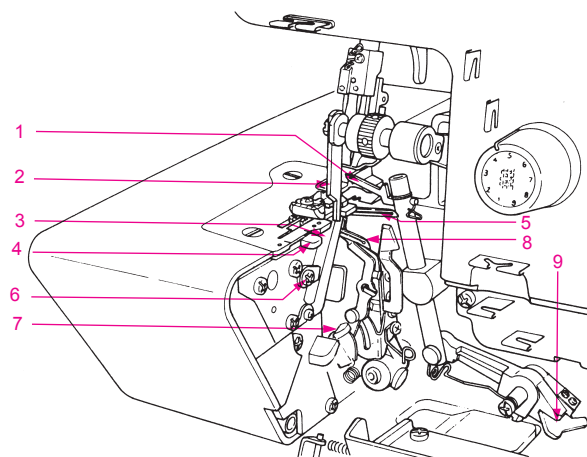
各部位名称

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
7. Lower looper threader
8. Chainstitch looper
9. Upper looper release

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
7. 下弯针穿线扳手
8. 链缝弯针
9. 上弯针切换扳手



CAUTION:

Be sure to turn off the power switch before opening the looper cover.



注意:

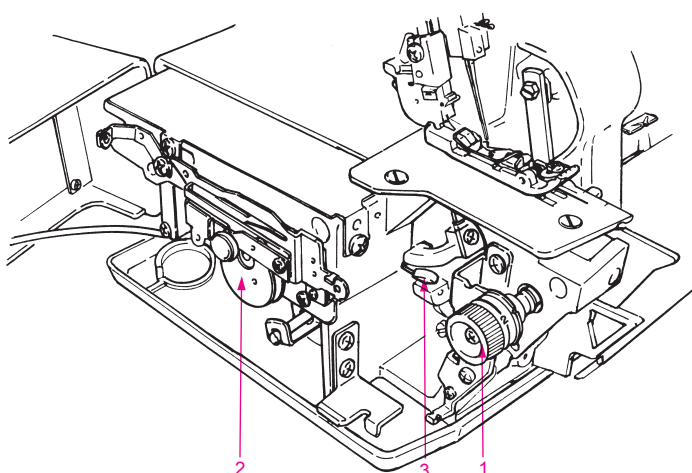
在打开缝台时，请务必关闭电源。

View with cloth plate open

1. Knife adjusting knob
2. Chainstitch looper thread take-up
3. Chainstitch looper threader

打开缝台所见

1. 下刀调节旋钮
2. 链缝弯针天秤
3. 链缝弯针穿线扳手

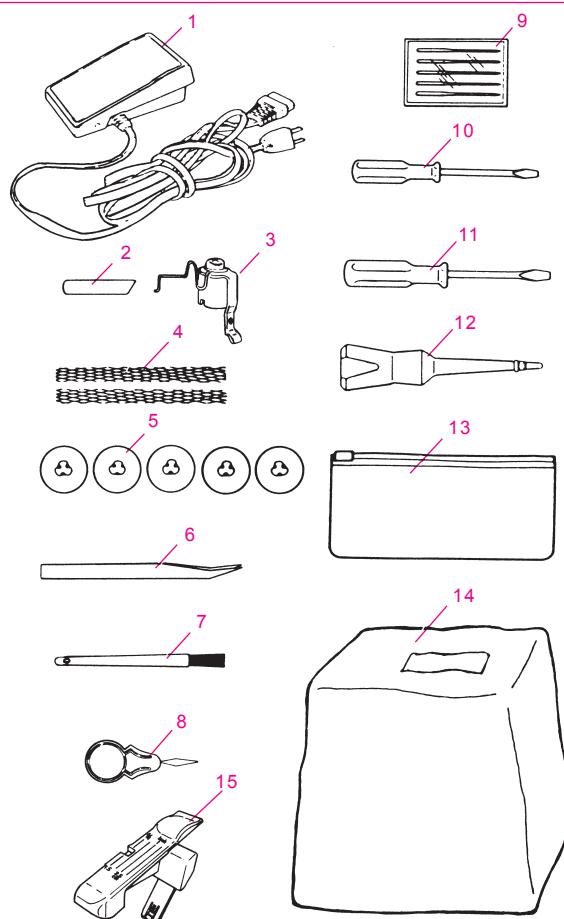


Accessories

1. Foot control
2. Lower knife blade
3. 2/3 thread converter
4. Nets
5. Spool caps
6. Tweezers
7. Cleaning brush
8. Needle threader
9. Needles in the needle box
10. Small screwdriver
11. Large screwdriver
12. Oiler
13. Accessory bag
14. Dust cover
15. Chainstitch seam guide plate

附件:

1. 脚踏控速器
2. 下刀
3. 2/3线转换器
4. 线团网
5. 线团座
6. 镊子
7. 除尘刷
8. 机针穿线器
9. 机针盒
10. 小螺丝刀
11. 大螺丝刀
12. 油壶
13. 附件袋
14. 机头罩
15. 链缝导向台

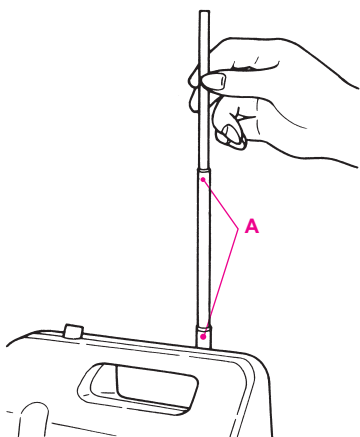


Assembling thread stand

组装线架

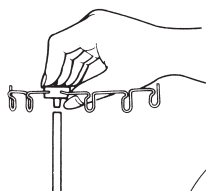
Raise the support rod fully

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



抽出线架杆

转动线架棒直到听到“咔哒”时，即A处的两定位珠卡入孔中，表明线架棒中的定位珠已啮合。

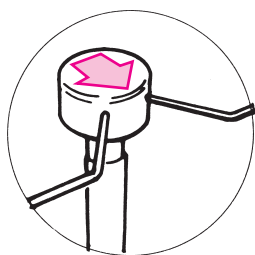


Put the thread guide on the support rod.

Insert the thread guide into the tip of the support rod so that the arrow in the thread guide points toward you.

将线架帽插入线架棒顶部

注意使线架帽上的箭头朝向自己。

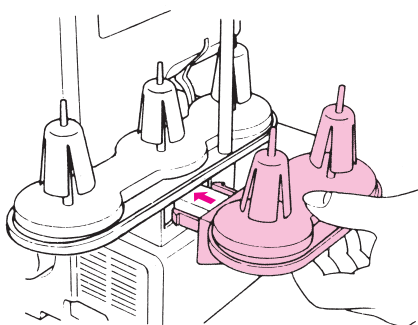


Attaching the spool holders

Attach the separately packed spool holder (equipped with two spool holders pins) to the fixed spool holder, by pushing until it snaps in place.

装入线架座

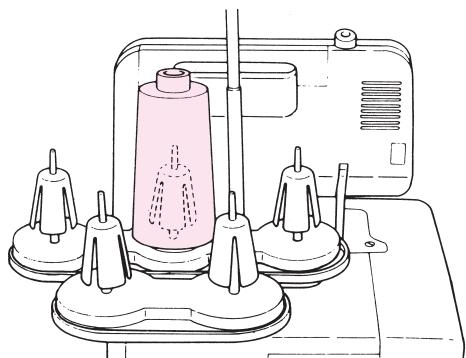
将辅助的线架座（随机配有一副）与已固定在机器上的线架座相连，注意要插到底。



Assembling the thread stand 组装线架

For overlock spools

包缝用线团

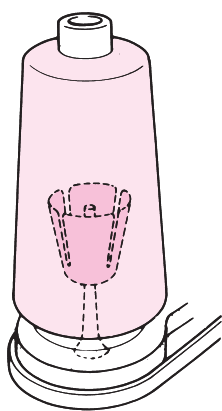


For large spools

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。



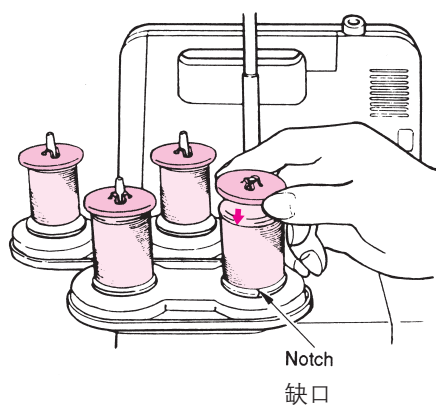
For home sewing spools

When using home sewing 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.

家用缝纫线团

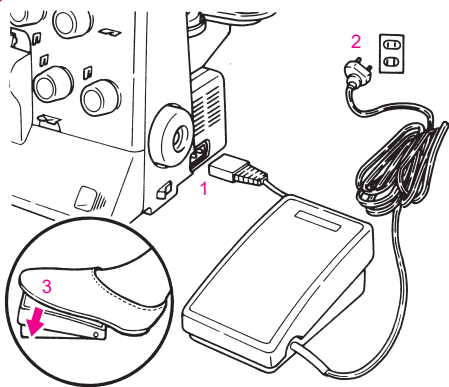
使用家庭缝纫线团时，去掉线团防松垫。

将线团插入插线钉，注意线团座缺口朝下，然后按上、并使其凸出的面向上。



Preparing machine

运转前准备



Attaching the foot control

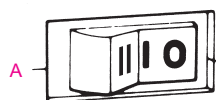
1. Plug foot control into machine socket.
2. Plug foot control into power supply socket.
3. Lay your foot on the foot control.
Press firmly on the foot control to increase sewing speed.
Press lightly on the foot control to decrease sewing speed.

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. 将脚踏控速器的另一头插头插入电源插座。
3. 用脚控制速度。用力踩速度提高，轻踩速度降低。

Power/light switch

The power/light switch is conveniently placed on the handwheel side of the machine in front of the socket.



- O** = Off
I = Power on
II = Power on and light on

主电源/照明灯开关

主电源/照明灯开关位于飞轮下方。

- O** = 关
I = 打开电源
II = 打开电源和LED照明



CAUTION:

Perform these following steps when you are not using your sewing machine.

1. Turn the power/light switch off. (Press side).
2. Be sure to remove the power plug from the wall outlet.
3. Do not place a thing on the foot controller.



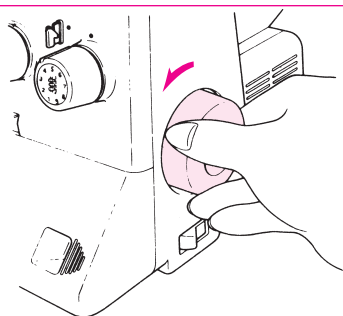
警告:

不使用本机时，请按下列步骤进行操作。

1. 必须关闭电源开关。
2. 必须把壁装电源插座中的插头拔出。
3. 勿在控速器上放置物品。

Operation and function

操作及功能



Handwheel (Pulley)

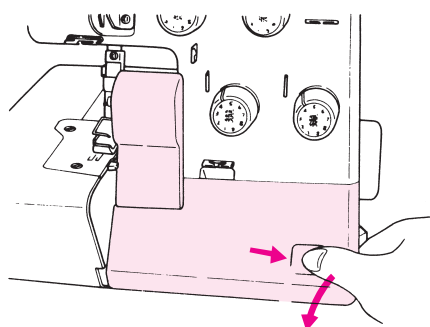
The handwheel turns toward you.

- * 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。

- * 穿线结束后，开始缝纫或结束缝纫时，必须正转飞轮。



Opening and closing the looper cover

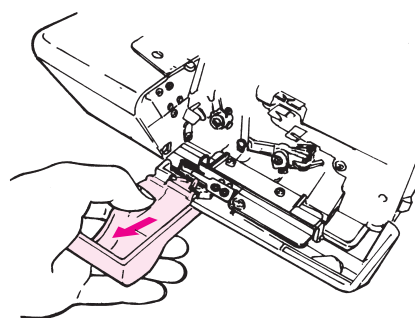
Opening: To open the looper cover, pull the looper cover opening handle to the right, and tilt the looper cover toward you.

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，并朝自己方向打开。

关闭：将弯针罩板向上翻起，并轻轻向右一按，弯针罩板即自动关闭。



Removing and attaching the chip guard cover

Removing the chip guard cover:

To remove the chip guard cover, open the looper cover and draw the chip guard cover toward you until it comes off.

Attaching the chip guard cover:

To install the chip guard cover, open the looper cover and attach the chip guard cover in position while fitting its top end in the slit on the looper cover.

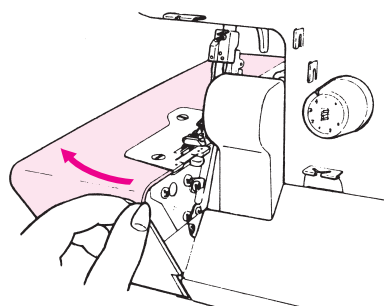
取下和安装布屑挡板

取下布屑挡板：

如需取出布屑挡板，请打开弯针罩板并向自己的方向拉出。

安装布屑挡板：

如需安装布屑挡板，请打开弯针罩板并安装布屑挡板，使其顶端插入弯针罩内槽口，至完全嵌合。



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：向外推缝台。

关闭：将缝台向打开的相反方向推。

⚠ Caution For safety, the power is automatically cut off when you open the looper cover or the cloth plate or remove the chip guard cover.

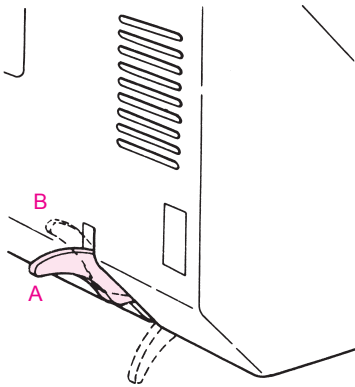
⚠ 注意：为了安全起见，当打开弯针罩板和缝台时，机器将自动切断电源。

Operation and function

操作及功能

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.



压脚扳手 (可抬起压脚)

- A 通常缝纫时 (即缝纫中等厚度的面料) 将压脚扳手抬至A位置, 放入面料。
- B 在缝纫较厚面料时, 按图示将压脚抬至B位置, 以在压脚和针板间留出更多的间隙。



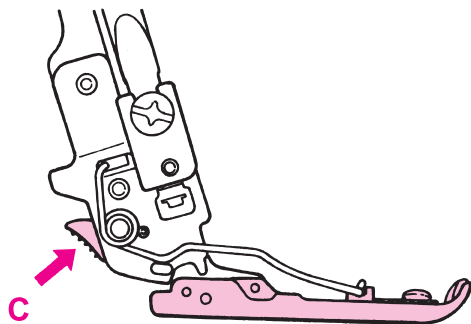
WARNING:

When using the extra lift (B), do not run the machine or turn the handwheel.



警告:

提升到B位置时, 请不要转动手轮和转动缝纫机。

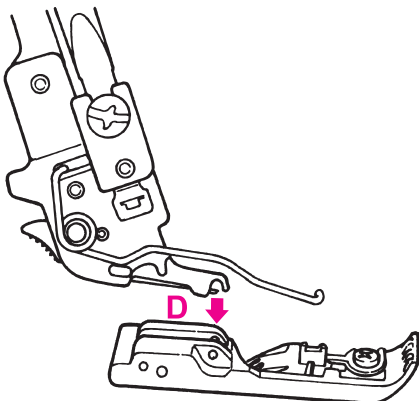


Changing the presser foot

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

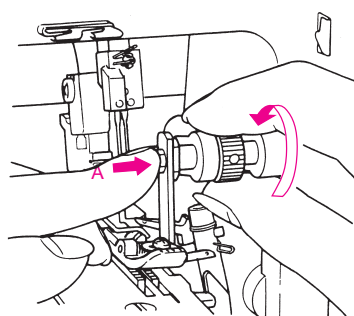
更换压脚

- ⚠ 必须切断电源。
1. 抬起压脚。
 2. 转动飞轮, 使机针转至最高点。
 3. 如须取下压脚, 请将压脚扳手抬至最高位置 (B), 使压脚更易取下。
 4. 按下图示C点, 便可取下压脚。
 5. 装上压脚, 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 (D)。



Operation and function

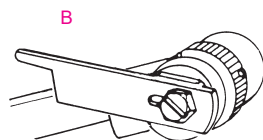
操作及功能



Releasing the upper knife

⚠ Be sure to turn the power switch OFF.

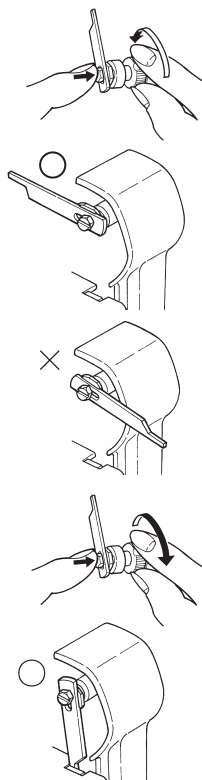
1. Turn the handwheel until the upper knife is fully raised. Open the looper cover.
2. Press the part indicated as (A) in the figure toward the right until it will go no further.
3. Keep pressing (A) and turn the knob on the right side in the direction of the arrow.
4. Turn the knob until the knife reaches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



翻转上刀

⚠ 注意要切断电源。

1. 转动飞轮，使上刀处于最高位置，再打开弯针罩板。
2. 向右按下图中所示的A部分，直到完全按入。
3. 按着A点不放，按箭头所示转动右边的止动轮。
4. 转动止动轮到B点，并转到死点位置。



Caution, Raising and lowering the upper knife.

注意：抬起并放下上刀

⚠ **Caution** Make sure to set the upper knife at a prescribed position.
注意： 将上刀设定到规定的位置。

- 1 Raising the upper knife. Turn the knob clockwise until the knife reaches a prescribed position. Don't set the knife on the halfway position.
抬起上刀。顺时针转动止动轮直到上刀位于规定的位置。

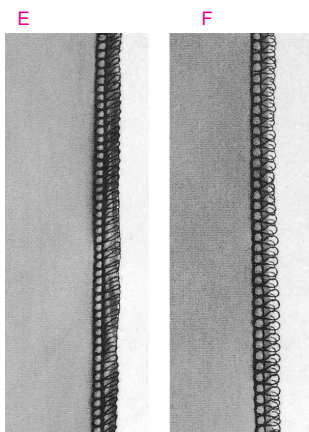
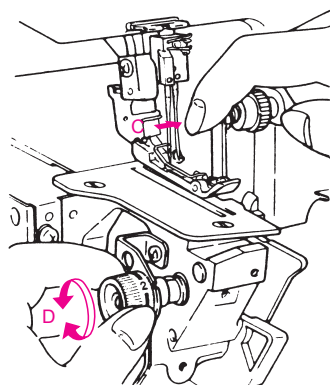
- 2 Lowering the upper knife. Turn the knob counterclockwise until the knife reaches a prescribed position. Don't set the knife on the halfway position.
放下上刀。逆时针转动止动轮直到上刀位于规定的位置。
中途禁止使用上刀。

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

⚠ Be sure to turn the power switch OFF.

Turn the lower knife adjusting knob by pressing part (C) in the figure.

- (E): If the edge of the sewing material curls, set the lower knife adjusting knob (D) to a lower number setting.
- (F): If the thread is loosely looping on the outer edge of the material, set the lower knife adjusting knob, to a larger number setting.



下刀调节旋钮（调节切刀宽度）

⚠ 注意要切断电源。

按下图中所示C点后再转动下刀调节旋钮。

- (E)：如果面料边卷起，将下刀调节旋钮 (D) 数值刻度调小。
- (F)：如果线在面料边外松散成圈，将下刀调节旋钮刻度调大。

Operation and function

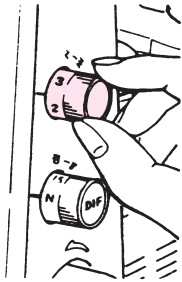
操作及功能

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.

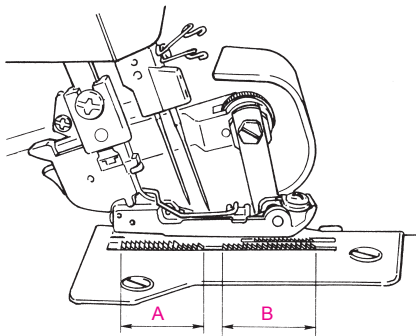


针距调节旋钮（调节针距）

针距长度的可调范围1~4 mm。

通过转动针距调节旋钮来调节针距。

- 通常包缝设定长度值为2~3 mm。



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.

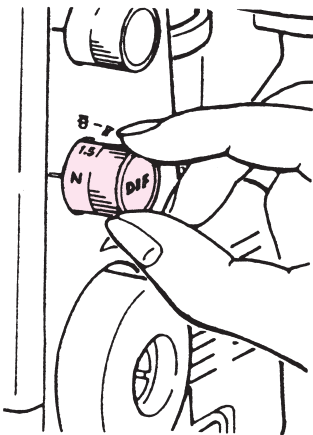
The differential feed prevents fluting or waving in seams in stretchy materials by differentiating the feed of the front feed dog (A) and rear feed dog (B).

For more application, information, see page 34.

差动送料调节旋钮（根据收缩或拉伸的需要调节送布量）

向前或向后转动差动送料调节旋钮来调节送布量

转动差动送料调节旋钮，以调节前送布牙（A）和后送布牙（B）的送料速比，可避免弹性面料的缝口出现缺口或波浪状（参考34页）。

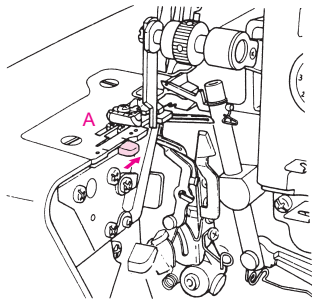


Operation and function

操作及功能

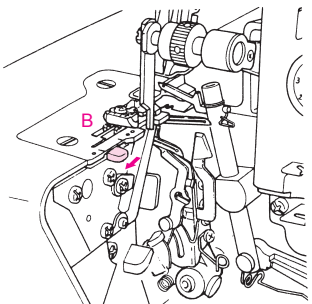
Overlocking width selection knob (For overlocking or roll hemming)

- * Turn the handwheel until the needles are fully raised
- A For overlocking
Push the overlocking width selection knob should align with the rear red marking on the throat plate.
- B For roll hemming
1. Pull the overlocking width selection knob should align with the front red marking on the throat plate.
2. Set the lower knife adjusting knob at "1 ~ 2".



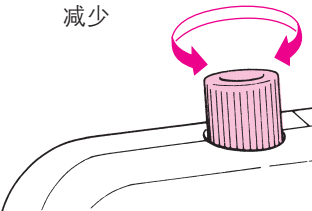
包缝宽度选择扳手（用于包缝或卷边）

- * 转动飞轮，使机针至最高点。
- A 包缝时
将包缝宽度选择扳手朝前推，使其与针板后面红色标记对齐。
- B 卷边时
1. 将包缝宽度选择扳手朝后拉，使其与针板前面红色标记对齐。
2. 将下刀调节旋钮调至“1~2”。



Increase
增加

Decrease
减少



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.

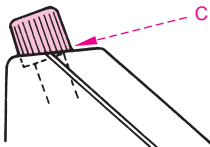
- To increase the pressure of the presser foot: For heavy-weight materials such as denim, tweed, or heavy linen.
- To decrease the pressure of the presser foot: For light-weight materials such as georgette, lace, or tricot.

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

压脚压力调节旋钮

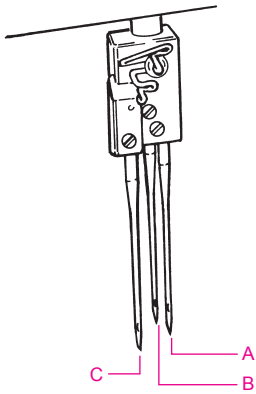
压脚压力调节旋钮已由厂方在出厂时调试适当。
因此，除缝纫特殊面料之外，无需再调节

- 增加压脚压力：用于厚质面料，如粗斜纹棉布、斜纹软呢或粗亚麻布。
 - 减小压脚压力：用于轻质面料，如乔其纱、蕾丝或针织织物。
- (C) 标准位置：使压脚调节帽下部与机壳的表面相对齐。



Operation and function

操作及功能



Changing the needles

- ⚠** Be sure to turn the power switch OFF.
- Using the needle inserter (D) on the cleaning brush will help replace the needle easily.
1. Turn the handwheel until the needles are fully raised.
 2. Before changing the needles, lower or remove the presser foot.
 3. Using a small screwdriver, loosen the needle setscrew and remove the needle.
 4. Insert the 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.

Needles used:		Types of needles	Size
A	Right-hand needle	Household type 130/705H	No. 75/11 or 90/14
B	Left-hand needle		
C	Chainstitch needle		

* Needle with No. 75/11 is intended for light-weight materials and general fabric.
Needle with No. 90/14 is intended for heavy-weight materials.

Note: To insert the needle into the needle clamp, loosen the needle clamp screw until flush with the clamp and insert the needle as far as possible into the clamp.

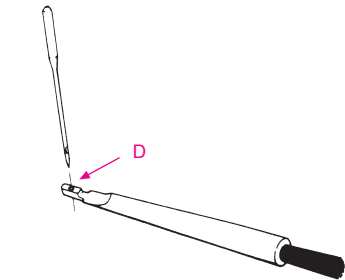
更换机针

- ⚠** 注意要切断电源
- 使用除尘刷柄部的机针插入器 (D) 将很容易的换下机针。
1. 转动飞轮直到机针上升至最高点。
 2. 换机针前，取下或放低压力脚。
 3. 用小螺栓刀松掉支针螺钉取下被换机针。
 4. 将右针柄平面向后，机针充分插入针夹，然后拧紧支针螺钉。

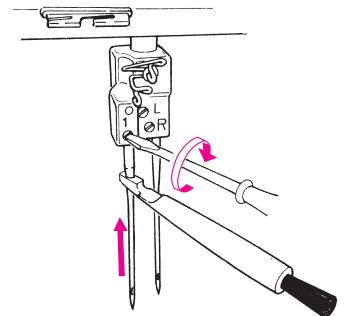
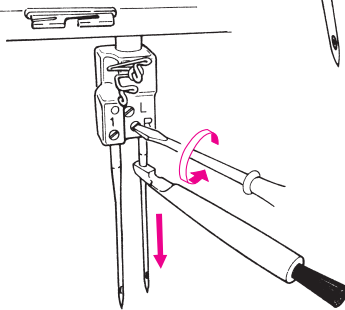
所用机针	机针型号	规格
A 右机针	家用型 130/705H	No. 75/11 或 90/14
B 左机针		
C 链缝机针		

* No. 75/11 机针适用于轻质面料和乔其纱面料。
No. 90/14 机针适用于厚质面料。

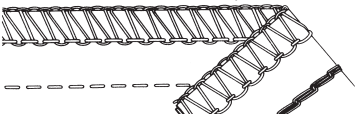
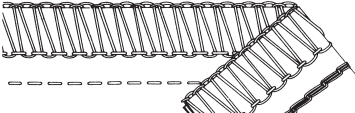
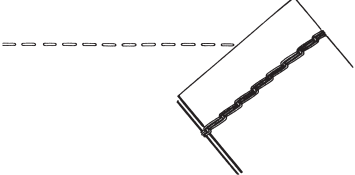
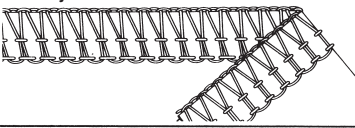
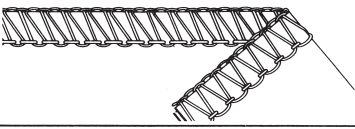
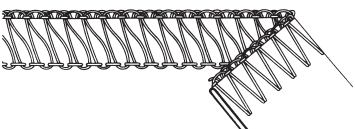
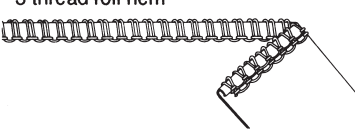
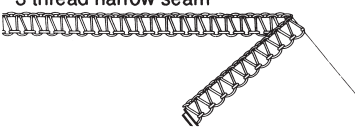
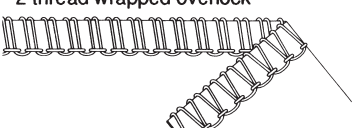
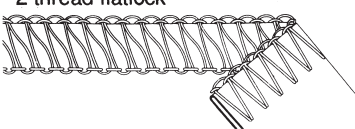
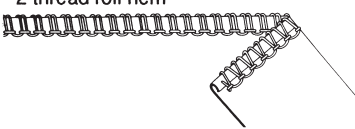
注意：将机针插入针夹时，拧开机针支针螺钉，然后将机针充分插入针夹里拧紧支针螺钉。



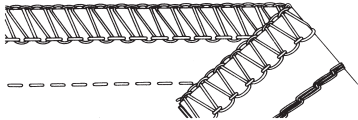
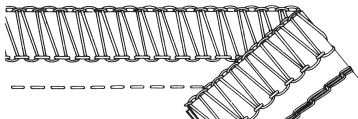
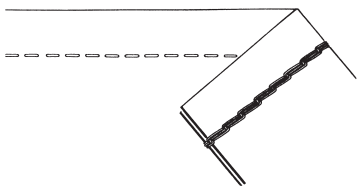
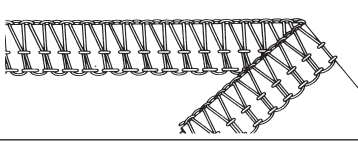
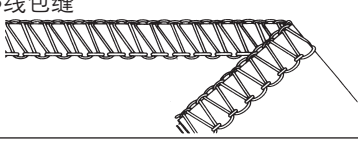
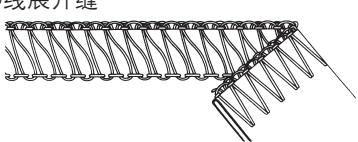
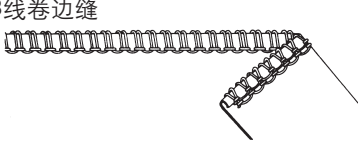
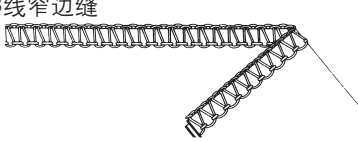
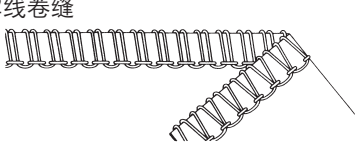
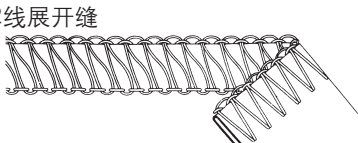
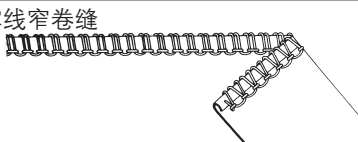
Flat side of a needle
机针平面



Stitch Chart

Stitch	Stitch width	Tension settings	Basic settings
5 thread overlock (chainstitch and narrow 3 thread overlock) 	3 – 5 mm, right needle Chainstitch needle 10 mm	Right needle green 3 – 5 Upper looper blue 3 – 5 Lower looper red 3 – 5 Chainstitch needle purple 3 – 4 Chainstitch looper purple	Stitch length: 2, 5 Cutting width: 2 Differential: N
5 thread overlock (chainstitch and wide 3 thread overlock) 	5 – 7 mm, left needle Chainstitch needle 10 mm	Left needle brown 6 – 7 Upper looper blue 3 – 5 Lower looper red 3 – 5 Chainstitch needle purple 3 – 4 Chainstitch looper purple –	Stitch length: 2, 5 Cutting width: 2 Differential: N
2 thread chainstitch 	—	Chainstitch needle purple 3 – 4 Chainstitch looper purple –	Stitch length 2, 5 Knife: Raised, chainstitch seam guide plate used Differential: N – 2 (knits), N – 0,7 (wovens)
4 thread overlock, with integrated safety seam 	5 – 7 mm, right and left needles	Left needle yellow 3 – 5 Right needle green 3 – 5 Upper looper blue 3 – 5 Lower looper red 3 – 5	Stitch length: 2, 5 Cutting width: 2 Differential: N – 2 (knits), N – 0,7 (wovens)
3 thread overlock 	3 – 5 mm, right needle 5 – 7 mm, left needle	Left needle yellow 3 – 5 Right needle green 3 – 5 Upper looper blue 3 – 5 Lower looper red 3 – 5	Stitch length: 2, 5 Cutting width: 2 Differential: N – 1,5 (knits), N – 0,7 (wovens)
3 thread flatlock 	3 – 5 mm, right needle 5 – 7 mm, left needle	Left needle yellow 1 – 2 Right needle green 1 – 2 Upper looper blue 3 – 5 Lower looper red 7 – 9	Stitch length: min. 2, 5 Cutting width: 2 Differential: N
3 thread roll hem 	2 mm, right needle	Right needle green 4 – 6 Upper looper blue 3 – 5 Lower looper red 5 – 7	Stitch length: 1 – 1.8 Cutting width: 1 – 1.5 Differential: N – 0.7 Stitch lever: roll hem
3 thread narrow seam 	2 mm, right needle	Right needle green 4 – 6 Upper looper blue 5 – 7 Lower looper red 3 – 5	Stitch length: 1 – 1.8 Cutting width: 1 – 1.5 Differential: N – 0.7 Stitch lever: roll hem
2 thread wrapped overlock 	3 – 5 mm, right needle 5 – 7 mm, left needle	Left needle yellow 3 – 5 Right needle green 3 – 5 Lower looper red 2 – 4	Stitch length: 2.5 Cutting width: 2 Differential: N – 1,5 (knits), N – 0,7 (wovens) 2/3 thread converter
2 thread flatlock 	3 – 5 mm, right needle 5 – 7 mm, left needle	Left needle yellow 1 – 2 Right needle green 1 – 2 Lower looper red 4 – 6	Stitch length: min. 2, 5 Cutting width: 2 Differential: N 2/3 thread converter
2 thread roll hem 	1,5 mm, right needle	Right needle green 3 – 5 Lower looper red 2 – 4	Stitch length: 1 – 1.8 Cutting width: 1 – 1.5 Differential: N – 0.7 Stitch lever: roll hem 2/3 thread converter

针迹对照表

针迹	针迹宽度	线的张力	基本设置
5线包缝(链缝+右机针3线包缝) 	3-5 mm 右机针 链缝机针10 mm	右机针绿色3-5 上弯针蓝色3-5 下弯针红色3-5 链缝机针紫色3-4 链缝弯针紫色	针距: 2.5 切刀宽度: 2 差动: N
5线包缝(链缝+左机针3线包缝) 	5-7 mm 左机针 链缝机针10 mm	左机针褐色6-7 上弯针蓝色3-5 下弯针红色3-5 链缝机针紫色3-4 链缝弯针紫色	针距: 2.5 切刀宽度: 2 差动: N
2线链缝 	-----	链缝机针紫色3-4 链缝弯针紫色	针距: 2.5 刀: 抬起, 使用链缝导向台 差动: N-2 (针织织物), N-0.7 (平织织物)
4线完整标准包缝 	5-7 mm, 左右机针	左机针黄色3-5 右机针绿色3-5 上弯针蓝色3-5 下弯针红色3-5	针距: 2.5 切刀宽度: 2 差动: N-2 (针织织物), N-0.7 (平织织物)
3线包缝 	3-5 mm, 右机针 或 5-7 mm, 左机针	左机针黄色3-5或 右机针绿色3-5 上弯针蓝色3-5 下弯针红色3-5	针距: 2.5 切刀宽度: 2 差动: N-2 (针织织物), N-0.7 (平织织物)
3线展开缝 	3-5 mm, 右机针 或 5-7 mm, 左机针	左机针黄色1-2或 右机针绿色1-2 上弯针蓝色3-5 下弯针红色7-9	针距: 2.5 切刀宽度: 2 差动: N
3线卷边缝 	2 mm, 右机针	右机针绿色4-6 上弯针蓝色3-5 下弯针红色5-7	针距: 1-1.8 切刀宽度: 1-1.5 差动: N-0.7 包缝宽度选择扳手: 卷边
3线窄边缝 	2 mm, 右机针	右机针绿色4-6 上弯针蓝色5-7 下弯针红色3-5	针距: 1-1.8 切刀宽度: 1-1.5 差动: N-0.7 包缝宽度选择扳手: 卷边
2线卷缝 	3-5 mm, 右机针 或 5-7 mm, 左机针	左机针黄色3-5或 右机针绿色3-5 下弯针红色2-4	针距: 2.5 切刀宽度: 2 差动: N-1.5 (针织织物), N-0.7 (平织织物) 2/3线转换器
2线展开缝 	3-5 mm, 右机针 或 5-7 mm, 左机针	左机针黄色1-2或 右机针绿色1-2 下弯针红色4-6	针距: 最小2.5 切刀宽度: 2 差动: N 2/3线转换器
2线窄卷缝 	1.5mm, 右机针线	右机针绿色3-5 下弯针红色2-4	针距: 1-1.8 切刀宽度: 1-1.5 差动: N-0.7 包缝宽度选择扳手: 卷边 2/3线转换器

Threading / 穿线

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

Preparation

- ⚠ Be sure to turn the power switch OFF.
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.

Thread the machine carefully and in the correct sequence.

Invaluable threading aids simplify threading:

- colored threading illustration
- color coded thread path on the machine.
- threading accessories.

按正确顺序仔细对机器穿线，以缝纫出漂亮的针迹。

准备工作

- ⚠ 请切断电源开关。
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，直至机针上升到最高点。
 4. 解除上刀。

按正确顺序仔细穿线。

有效的穿线辅助手段可以使穿线更简便：

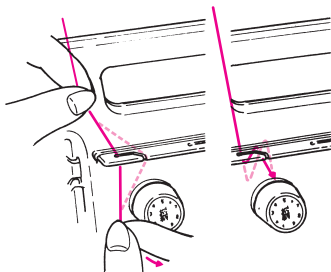
- *彩色穿线图。
- *机器上的彩色穿线通道。
- *穿线附属品。

Thread guide plate

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

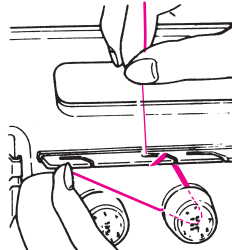
线导向板

将线滑进导向板槽，呈S型状态。



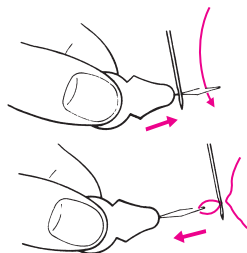
Threading the tension dials

线张力刻度盘



Needle threader

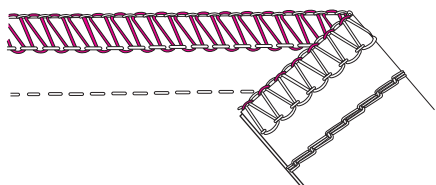
Insert the needle threader through the back of the needle eye or the looper eye then thread the needle threader. Pull the needle threader back until it pulls through the eyelet.



机针穿线器

从机针针孔或弯针针孔后面插入机针穿线器，然后线穿进穿线器，向后拉出机针穿线器，将线引出针孔。

穿线：5线包缝（链缝&3线包缝）



1. Upper looper thread (Blue)

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

(1, 2) Bring thread up from the rear of the retractable support rod thread guide with blue marking, to the front of it.

(3, 4) Pass the thread through the thread guide plate. Looping as shown.

(5) Snap the thread into the thread guide.

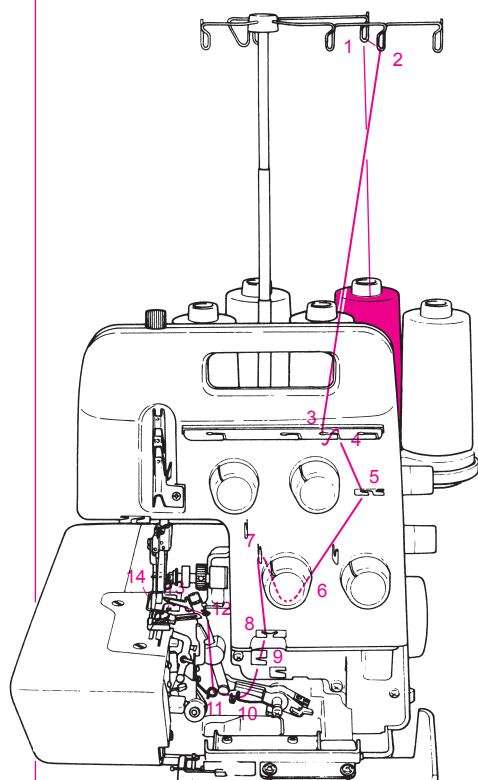
(6) Lay the thread between the thread tension dial discs.

(7, 8, 9, 10, 11, 12) Thread the thread guides

(13) Turn the handwheel until the upper looper is fully raised. Thread upper looper eye.

(14) 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（蓝色）

将线团插入带有蓝色色标的挂线导向下面的插线钉上。

(1, 2) 将线挂在有蓝色色标的挂线导向上。

(3, 4) 将线通过线导向板。如图所示。

(5) 将线通过线导向。

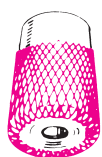
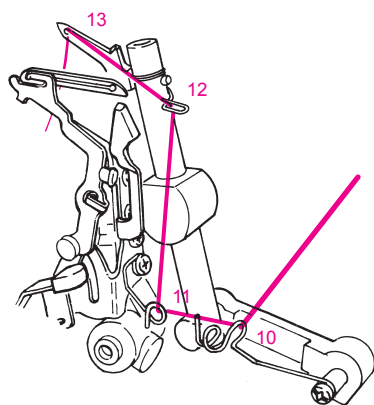
(6) 将线嵌入上弯针线张力调节旋钮的夹线片中。

(7, 8, 9, 10, 11, 12) 将线依次通过各线导向。

(13) 转动飞轮将上弯针转至最高点，线穿进上弯针针孔。

(14) 将线拉出大约10 cm。

将线从压脚下面通过，从压脚后面拉出线端。



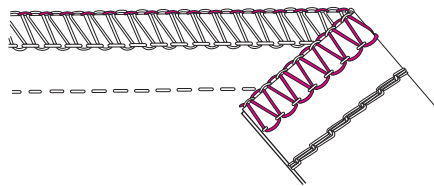
Use a net for a hard twisted thread.

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

防止打圈的线团网

当线团的线滑落或打圈，可用线团网罩住上弯针和下弯针线团。

穿线：5线包缝（链缝&3线包缝）



2. Lower looper thread (Red)

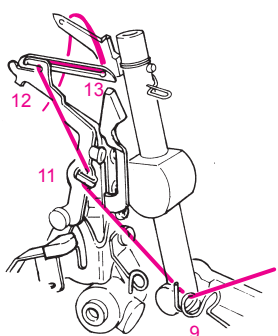
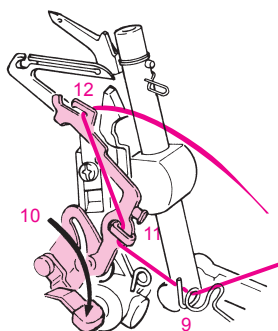
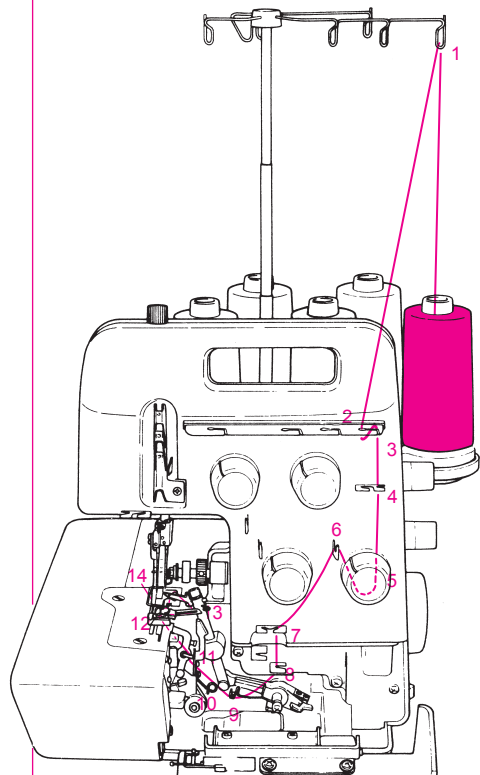
Place the spool on the spool pin right under red marking on the retractable support rod thread guide.

- (1) Bring thread up from the rear of the retractable support rod thread guide.
- (2, 3) Pass the thread through the thread guide plate. Snapping into place.
- (4) Snap the thread in to the thread guide.
- (5) Thread the thread tension dial.
- (6, 7, 8, 9) Thread the thread guides.
- (10) Raise the needles fully and press the lever of the threading device down.
- (11, 12) Thread the guide and then the slit on the device.
Holding the thread loosely with the left hand, turn the hand wheel until upper and lower loopers just cross.
The threading device will automatically return to the normal position.
- (13) Thread the lower looper eye and place thread under the presser foot.
* If rethreading the lower looper thread, cut the needle threads at the needle. And rethread needle threads.
Thread the lower looper and then the needles.

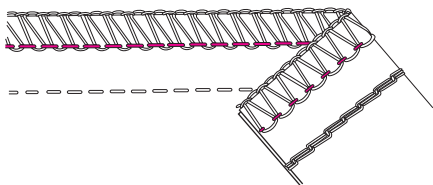
2. 下弯针线（红色）

将线团插入带有红色色标的挂线导向下面的插线钉上。

- (1) 将线挂在红色色标的挂线导向上。
- (2, 3) 将线通过导线板。
- (4) 将线通过线导向。
- (5) 将线嵌入下弯针线张力调节旋钮的夹线片中。
- (6, 7, 8, 9) 将线依次通过线导向。
- (10) 将机针转至最高点，按下下弯针穿线扳手。
- (11, 12) 将线穿入。
左手轻拿线头，正转飞轮直到上下弯针互相交叉，
穿线装置将自动回复到正常位置。
- (13) 将线穿进下弯针，将线放在压脚下方。
* 如需重新给下弯针穿线时，剪断左右机针线，给下弯针穿线后，再重新给机针穿线。



穿线：5线包缝（链缝&3线包缝）



3. Right-hand needle thread (Green)

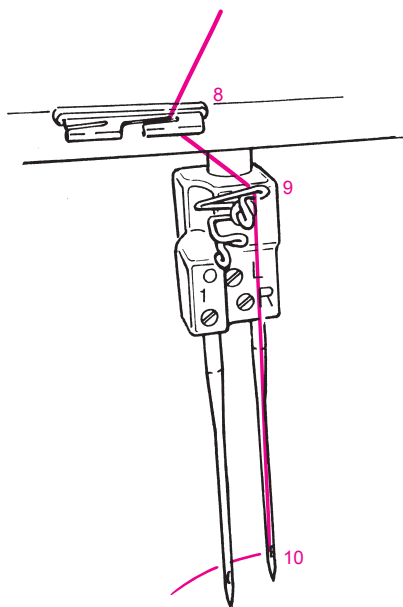
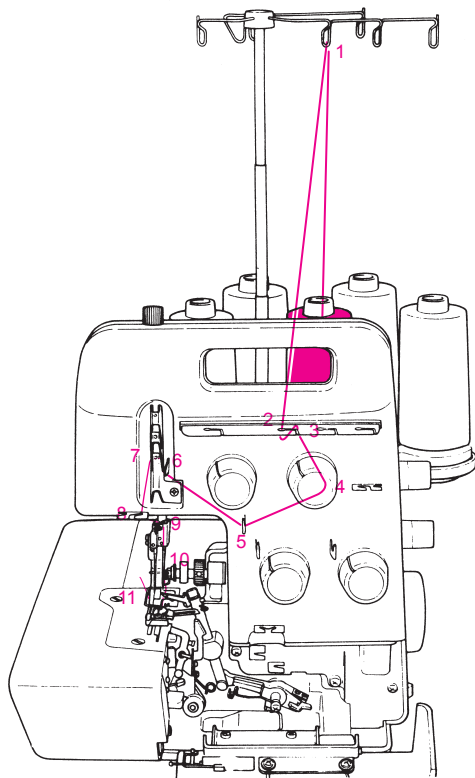
Place the spool on the spool pin right under the green marking on the retractable support rod thread guide.

- (1) Bring thread up from the rear of the retractable support rod thread guide with the green marking.
- (2, 3) Pass the thread through the thread guide plate. Looping as shown.
- (4) Snap thread the thread tension dial.
- (5, 6) Thread the thread guide.
- (7) Lay the thread in the under notch on the thread take-up cover.
- (8) Thread the thread guide.
- (9) Thread the thread guide on the needle clamp.
- (10) Turn the handwheel toward you until the needles are fully raised. Thread the right-hand needle.
- (11) 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（绿色）

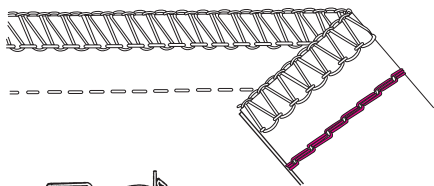
将线团插入带有绿色色标的挂线导向下面的插线钉上。

- (1) 将线挂在带有绿色色标的挂线导向上。
- (2, 3) 将线通过线导向。如图所示打圈
- (4) 将线嵌入右机针线张力调节旋钮的夹线片中。
- (5, 6) 将线通过线导向。
- (7) 将线穿过挑线杆护罩上的下方的过线槽（绿色）。
- (8) 将线通过线导向。
- (9) 将线通过针夹上的穿线钩。
- (10) 正转飞轮直到机针位于最高点。把线穿过针机孔。
- (11) 将线通过压脚下面，并在压脚后面拉出大约10 cm。



Threading: 5-thread overlock (chainstitch & 3-thread overlock)

穿线：5线包缝（链缝&3线包缝）



4. Chainstitch looper thread (Purple)

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

- (1, 2) Bring the thread up from the spool and take it from back to front through the purple guides.
- (3, 4) Thread guides on back of machine and inside the cloth plate.
- (5, 6) Thread the tension.
- (7) Place the thread horizontally in the guide.
- (8) Thread the guide.
- (9, 10) Push the chainstitch looper auto-threader up towards the chainstitch looper and press them down together.
- (11) Thread the auto-threader.
- (12) Thread the looper eye from front to back and cut thread back to about 8 cm (3").
- (13) Press the looper to the right and it will return to its normal position.

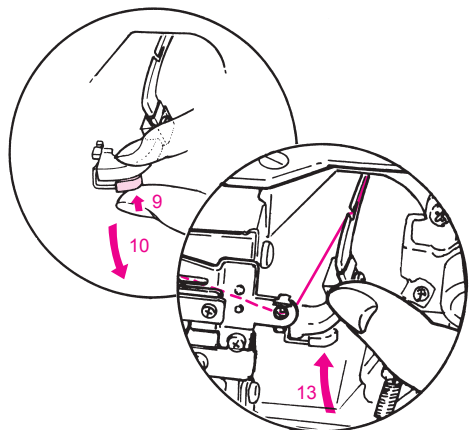
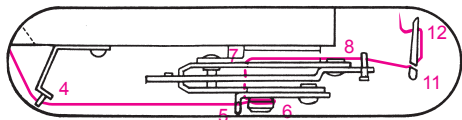
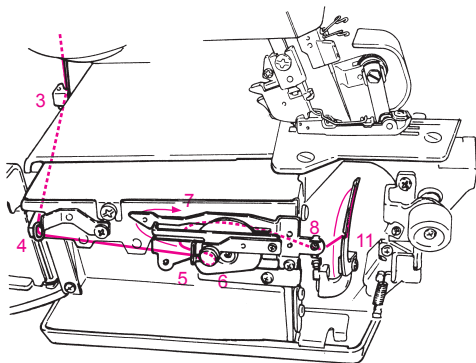
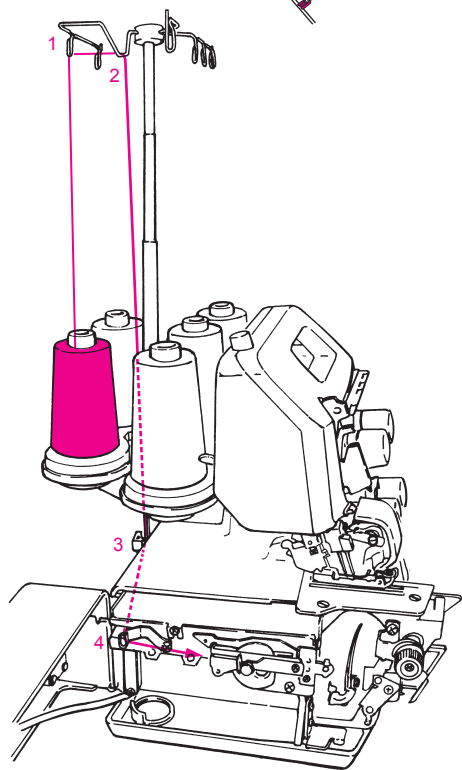
Note: If the chainstitch looper thread has to be rethreaded, cut the chainstitch needle thread at the eye and remove. Thread the looper first and then the needle.

4. 链缝弯针线（紫色）

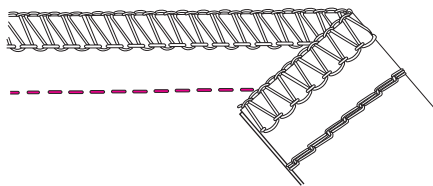
将线团插入带有紫色色标的挂线导向下面的插线钉上。

- (1, 2) 将线从线团上拉出，从后向前通过紫色导向。
- (3, 4) 通过机器后部的导向以及缝台内的导向。
- (5, 6) 将线张力调节器穿线。
- (7) 将线水平绕入导向板上。
- (8) 线通过导向。
- (9, 10) 把链缝弯针自动穿线扳手向上推起，并将链缝弯针往下倒。
- (11) 将线通过自动穿线器。
- (12) 从前向后将线穿过弯针孔，在大约8 cm (3") 处将线剪断。
- (13) 将弯针向右边推，它将恢复到缝纫位置。

注意：如果需要重新给链缝弯针线，在针孔上方剪断机针线并除去链缝机针线。然后先给弯针穿线，再给机针穿线。



穿线：5线包缝（链缝&3线包缝）



5. Chainstitch needle thread (purple)

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

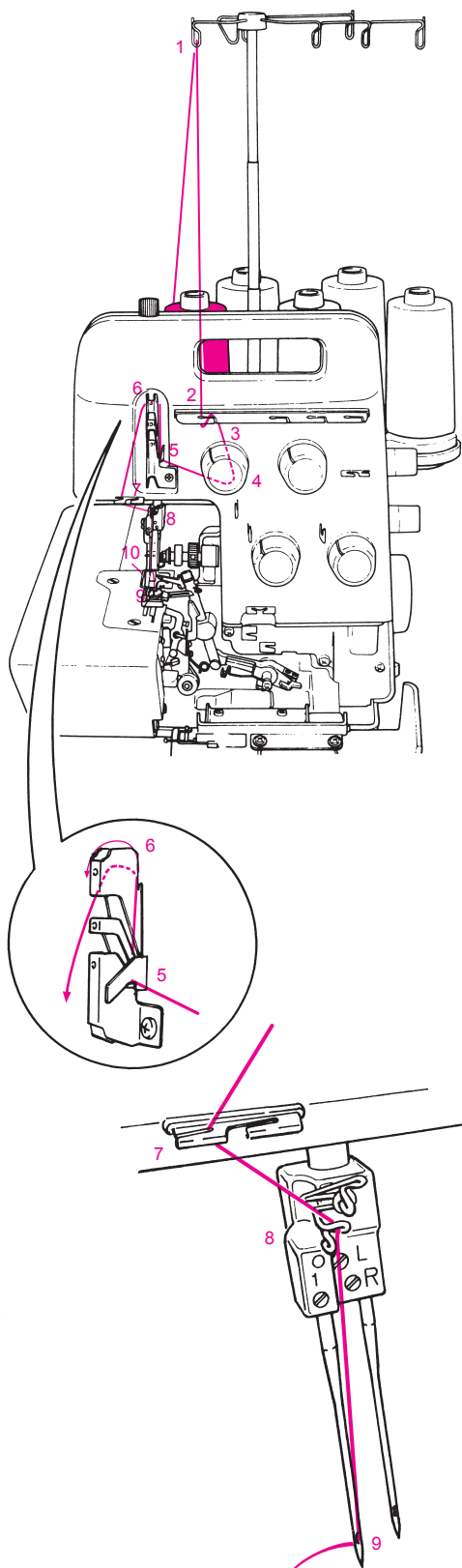
- (1) Bring the thread up from the spool to the thread guide and take it through the purple thread guide.
- (2, 3) Thread the thread guide.
- (4) Thread the thread tension dial.
- (5) Thread the thread guide.
- (6) Lay the thread in the up side notch on the thread take-up cover.
- (7, 8, 9) Thread the thread guides.
- (10) Thread the chainstitch 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. Switch the machine on.

5. 链缝机针线（紫色）

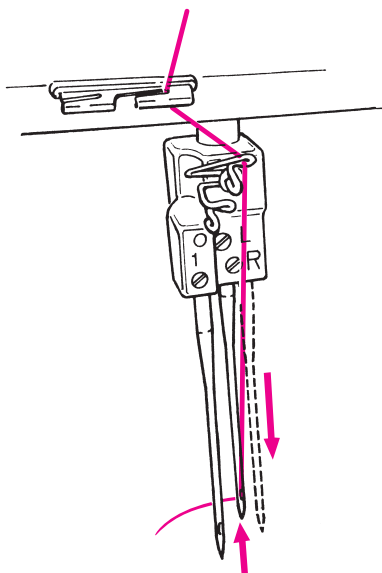
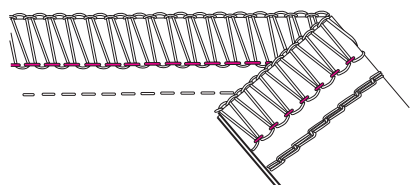
将线团插入带有紫色色标的挂线导向下面的插线钉上。

- (1) 将线从线团上拉出，挂在带有紫色色标的挂线导向上。
 - (2, 3) 将线通过导向。如图示打圈。
 - (4) 将线嵌入左机针线张力调节旋钮的夹线片中。
 - (5) 将线通过线导向。
 - (6) 将线穿过挑线杆护罩上的上方的过线槽（紫色）。
 - (7, 8, 9) 将线通过线导向。
 - (10) 将线穿过链缝机针孔。并在机针孔处拉出大约10 cm。
- 穿线完毕后，放下上刀，关闭弯针罩板和缝台。 打开电源开关。



Threading: 5-thread overlock (chainstich & wide 3-thread overlock)

穿线：5线包缝（链缝&3线宽包缝）



Left-hand needle (brown)

If chainstich is sewn with a wide 3 thread overlock, use the left-hand needle and follow the brown markings. Place the spool on the spool pin under the brown markings on the thread guide.

- (1) Bring the thread up from the spool and take it from back to front through the brown guide.
- (2, 3) Pass the thread through the thread guide bar.
- (4) Thread the thread tension dial.
- (5, 6) Thread the thread guides.
- (7) Thread the center notch of the take-up cover.
- (8) Thread the guide.
- (9) Thread the guide on the needle clamp.
- (10) Thread the left-hand needle from front to back and lay the thread to the left under the presser foot.

- Chainstich needle thread tension: 2.5 – 4.5 (A)
- Left-hand needle thread tension: 6 – 7 (B)
- Upper and lower looper thread tension: 3 – 5

When threading is complete
After threading, lower the foot and upper knife (if raised).
Close the looper and cloth plate covers.
Switch the machine on.

左机针线（褐色）

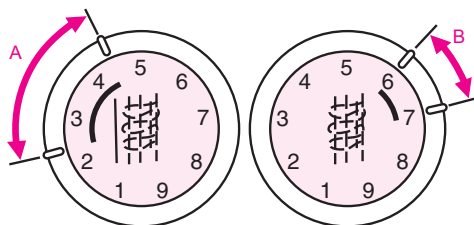
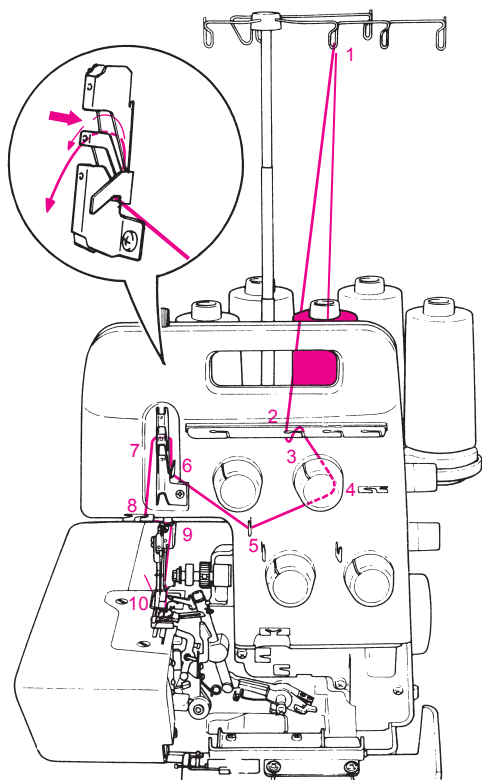
如果用宽3线包缝链缝，请使用左机针线并沿褐色标志操作。将线团放在有褐色色标的挂线导向下面的插线钉上。

- (1) 将线从线团上拉出，从后向前通过褐色线导向。
- (2, 3) 将线通过线导向。如图所示打圈。
- (4) 将线嵌入右机针线张力调节旋钮的夹线片中。
- (5, 6) 将线通过线导向。
- (7) 将线穿过挑线杆护罩上的上方的过线槽（紫色）。
- (8) 将线通过线导向。
- (9) 将线通过针夹上的穿线钩。
- (10) 从前向后把线穿过左机针孔。将线放在压脚的左边。

- * 链行缝机针线张力：2.5—4.5 (A)
- * 左机针线张力：6—7 (B)
- * 上下弯针线张力：3—5

穿线完毕

穿线完毕后，放下压脚和上刀（如果抬起）。
关闭弯针罩板。
打开机器电源。



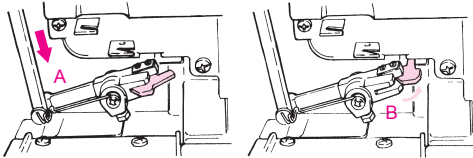
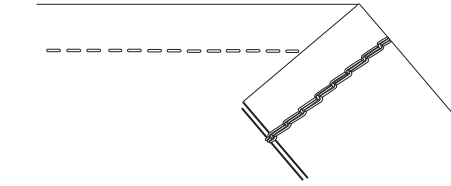
2-thread chainstitch

2线链缝

2-thread chainstitch (Purple)

- (1) Raise the upper knife.
- (2) Remove the right and left-hand needles.
- (3) Thread the chainstitch looper and needle.
- (4) Open the looper cover and turn the handwheel towards you until the upper looper is in its lowest position (A).
- (5) Push the upper looper release back to disengage the looper (B).
- (6) Remove the knife guard (C) and attach the chainstitch seam guide plate (D).
- (7) Close the looper cover.

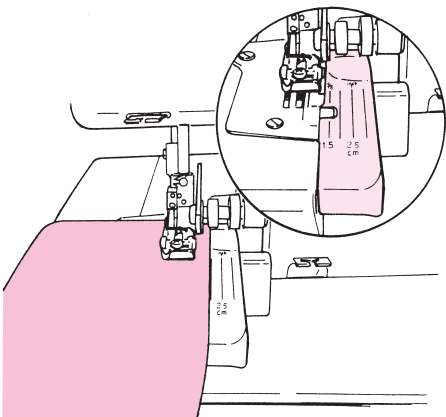
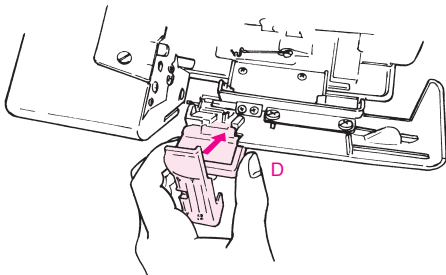
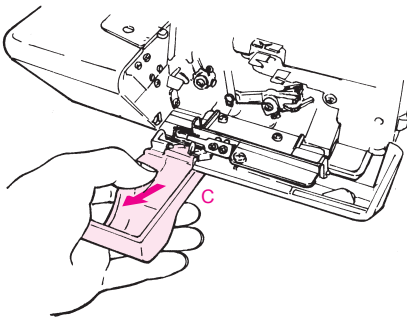
Important : When you have finished chainstitch sewing, remove the seam guide plate and replace the knife guard, lock the upper looper, lower the knife and close the looper cover.



2线链缝（紫色）

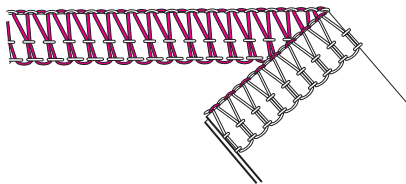
- (1) 抬起上刀。
- (2) 取下左右机针。
- (3) 给链缝机针和弯针穿线。
- (4) 打开弯针罩板并转动飞轮直到上弯针处于其最低点 (A)。
- (5) 向后推上弯针切换扳手，使其与弯针分离 (B)。
- (6) 取下布屑挡板 (C)，并安装上链缝导向台 (D)。
- (7) 关上弯针罩板。

注意：如果链缝缝纫完毕，取下链缝导向台并更换布屑挡板，锁住上弯针并关上弯针罩板。



Threading: 4 thread overlook

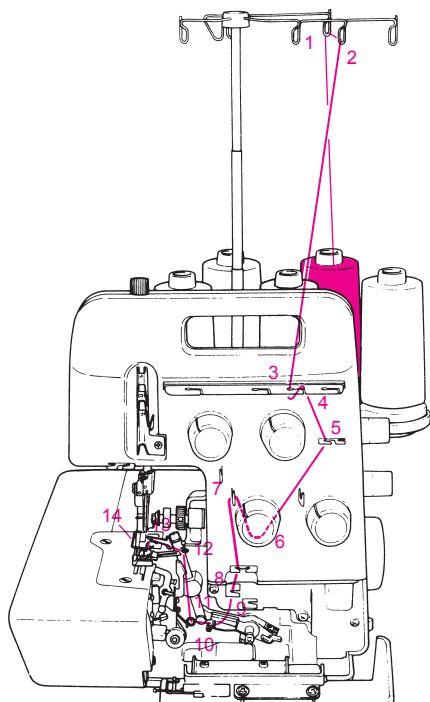
穿线：4线包缝



1. Upper looper thread (Blue)

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

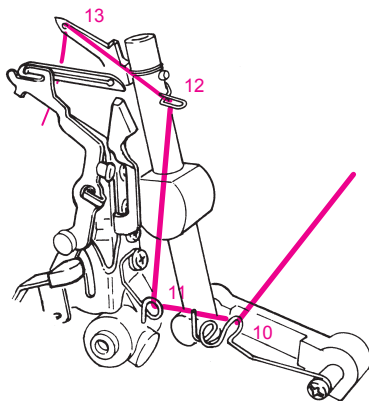
- (1, 2) Bring thread up from the rear of the retractable support rod thread guide with blue marking to the front of it.
- (3, 4) Pass the thread through the thread guide plate. Looping as shown.
- (5) Bring the thread on to the thread guide.
- (6) Snap the thread into the thread tension dial discs.
- (7, 8, 9, 10, 11, 12) Thread the thread guides
- (13) Turn the handwheel until the upper looper is fully raised. Thread upper looper eye.
- (14) 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（蓝色）

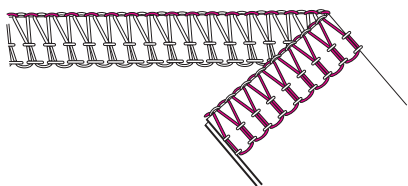
将线团插入带有蓝色色标的挂线导向下方的插线钉上。

- (1, 2) 将线挂在有蓝色色标的挂线导向上。
- (3, 4) 将线通过线导向板。如图所示。
- (5) 将线通过线导向。
- (6) 将线嵌入上弯针线张力调节旋钮的夹线片中。
- (7, 8, 9, 10, 11, 12) 将线依次通过线导向。
- (13) 转动飞轮直到上弯针处于最高点。线穿进上弯针针孔。
- (14) 将线拉出大约10 cm。将线从压脚下面通过，并从后面拉出线端。



Threading: 4 thread overlook

穿线：4线包缝



2. Lower looper thread (Red)

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

- (1) Bring thread up from the rear of the retractable support rod thread guide.
 - (2, 3) Pass the thread through the thread guide plate. Looping as shown.
 - (4) Bring the thread on to the thread guide.
 - (5) Thread the thread tension dial.
 - (6, 7, 8, 9) Thread the thread guides.
 - (10) Raise the needles fully and press the lever of the threading device down.
 - (11, 12) Thread the guide and then the slit on the device.
- Holding the thread loosely with the left hand, turn the hand wheel until upper and lower loopers just cross.

The threading device will automatically return to the normal position.

- (13) Thread the lower looper eye and place thread under the presser foot.
- * If rethreading the lower looper, cut the both needle threads off at the needles, and rethread the needles.

Thread the lower looper and then the needles.

2. 下弯针线（红色）

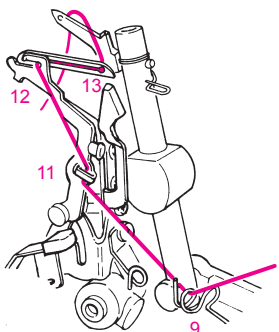
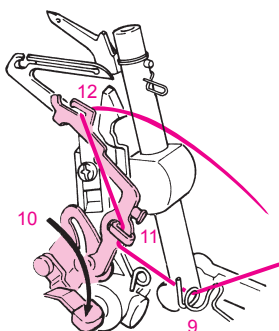
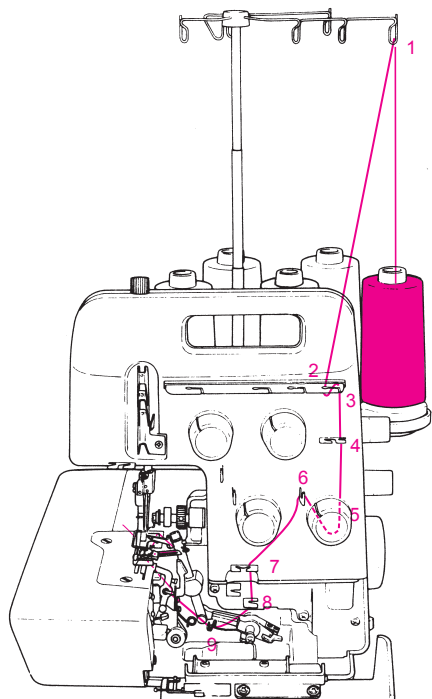
将线团插入带有红色色标的挂线导向下面的插线钉上。

- (1) 将线从线团上拉出，从后向前通过线导向。
- (2, 3) 将线通过线导向板。如图示打圈。
- (4) 将线通过线导向。
- (5) 将线嵌入下弯针线张力调节旋钮的夹线片中。
- (6, 7, 8, 9) 将线依次通过各线导向。
- (10) 将机针位于最高点。
- (11, 12) 将线穿入。

左手轻拿线头，转动飞轮直到上下弯针互相交叉。

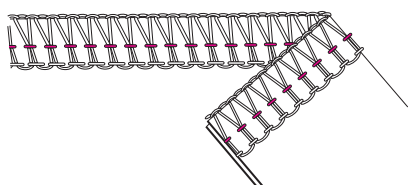
穿线装置将自动回复到正常位置。

- (13) 将线穿过下弯针孔，并将线放在压脚下方。
- 如需重新给下弯针穿线时，剪断左右机针线。
先给下弯针穿线，再重新给机针穿线。



Threading: 4 thread overlook

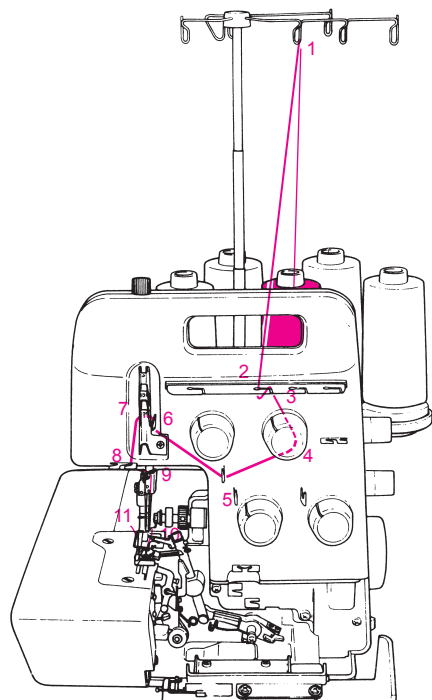
穿线：4线包缝



3. Right-hand needle thread (Green)

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

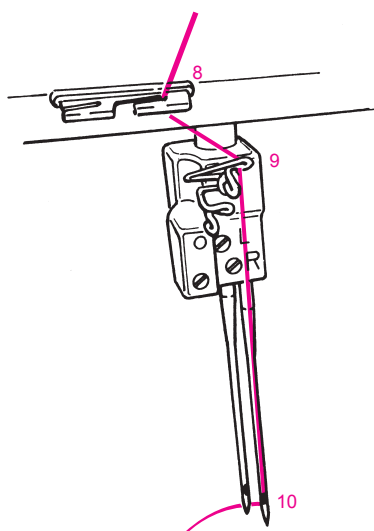
- (1) Bring thread up from the rear of the retractable support rod thread guide with the green marking.
- (2, 3) Pass the thread through the thread guide plate. Looping as shown.
- (4) Thread the thread tension dial.
- (5, 6) Thread the thread guide.
- (7) Lay the thread in the under notch on the thread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



3.右机针线（绿色）

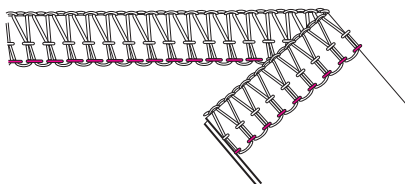
将线团放在有绿色色标的挂线导向下面的插线钉上。

- (1) 将线从线团上拉出，挂在带有绿色色标的挂线导向上。
- (2, 3) 将线通过线导向。如图所示打圈。
- (4) 将线嵌入右机针线张力调节旋钮的夹线片中。
- (5, 6) 将线通过线导向。
- (7) 将线穿过挑线杆护罩上的下方的过线槽（绿色）。
- (8) 将线通过线导向。
- (9) 将线通过机针夹上的穿线钩。
- (10) 正转飞轮使机针升至最高点。把线穿过右针针孔。
- (11) 将线通过压脚下面，并从压脚后面拉出大约10 cm。



Threading: 4 thread overlock

穿线：4线包缝



4. Left-hand thread needle (Yellow)

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

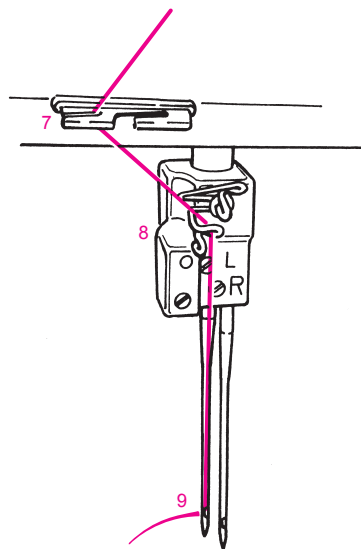
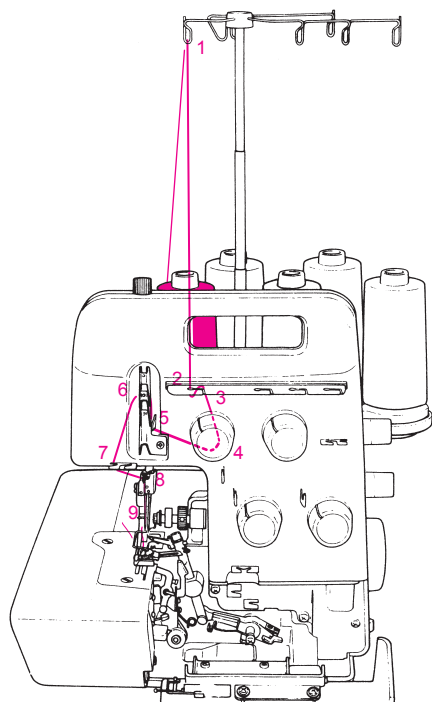
- (1) Bring the thread up from the spool to the thread guide and take it through the yellow thread guide.
- (2, 3) Thread the thread guide. Looping as shown.
- (4) Thread the thread tension dial.
- (5) Thread the thread guide.
- (6) Lay the thread in the center notch on the thread take-up cover.
- (7, 8) Thread the thread guides.
- (9) 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（黄色）

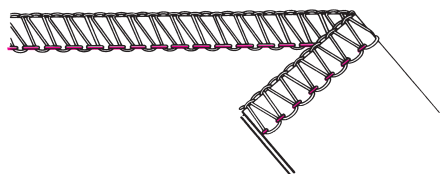
将线团放在有黄色色标的挂线导向下面的插线钉上。

- (1) 将线从线团上拉出，挂在带有黄色色标的挂线导向上。
 - (2, 3) 将线通过线导向。如图示打圈。
 - (4) 将线嵌入左机针线张力调节旋钮的夹线片中。
 - (5) 将线通过线导向。
 - (6) 将线穿过挑线杆护罩上的上方的过线槽（黄色）。
 - (7, 8) 将线通过线导向。
 - (9) 穿左机针线，并从机针孔拉出大约10 cm。
- 穿线完毕后，放下上刀并关闭弯针罩板和缝台。



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.

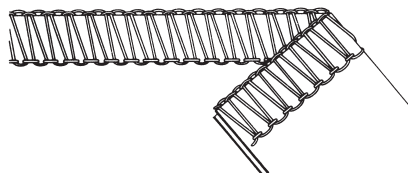
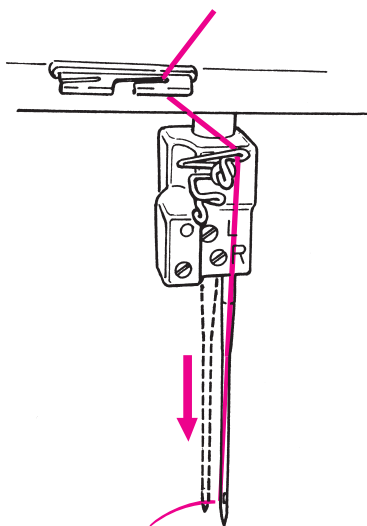
4 mm宽3线包缝（右机针线）（蓝色、红色、绿色）

* 取下左机针。

按如下顺序穿线。

- (1) 上弯针线（蓝色）
- (2) 下弯针线（红色）
- (3) 右机针线（绿色）

* 如果机器左机针线已经穿线完毕，剪下并除去多余的线。



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 right-hand needle thread, cut off and remove the thread.

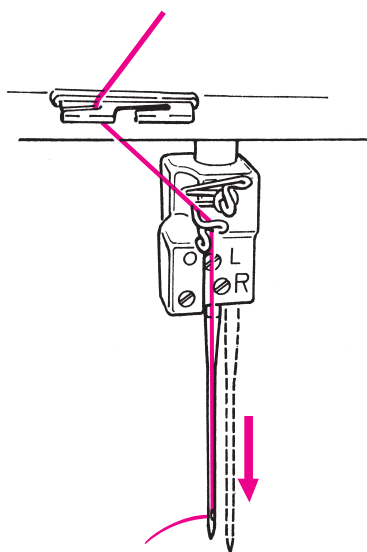
6 mm宽3线包缝（左机针线）（蓝色、红色、黄色）

* 取下右机针。

按如下顺序穿线。

- (1) 上弯针线（蓝色）
- (2) 下弯针线（红色）
- (3) 左机针线（黄色）

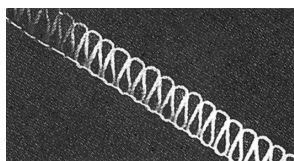
* 如果机器右机针线已经穿线完毕，剪下并除去多余的线。



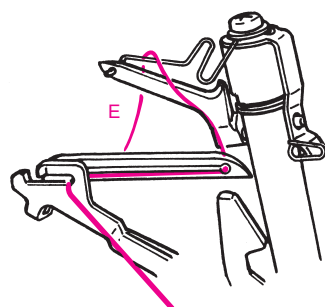
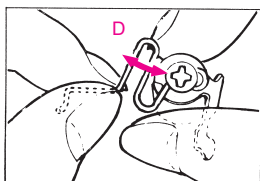
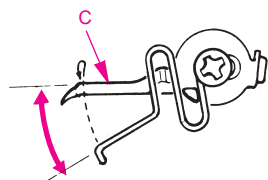
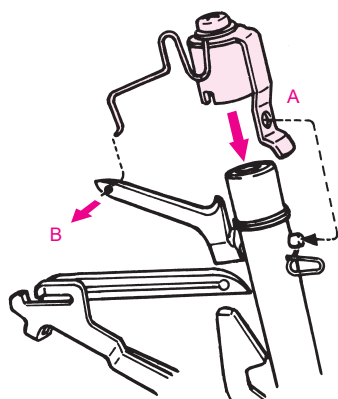
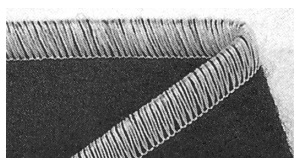
2/3 thread converter

2/3线转换器

2-thread flatlock



2-thread wrapped overlock



How to use the 2/3 thread converter



Switch the machine off (power switch “0”)

* This attachment enables the machine to perform 2 thread overedging or decorative-stitching, using 2 needles to perform 3-thread super stretch stitching.

- ① Remove the upper looper thread, and insert the 2/3 thread converter into the top section (A) of the upper looper shaft and fit wire (B) into the hole in the upper looper.

Upper looper (C):
Push the wire behind looper and into the eye of the looper.

(D): If the wire is not sufficiently springy or it cannot be fitted in the hole in the upper looper smoothly, adjust the curved section of the wire.

- ② Pass the lower looper thread above the wire of the 2/3 thread converter and route it down under the presser foot (E).

如何使用2/3线转换器



关闭机器电源（电源开关到“0”）

* 此配件可以使机器进行2线包缝或装饰包缝，用2机针来进行3线超级弹力伸缩缝。

- ①取下上弯针线，在上弯针轴的顶部（A）装入上弯针转换器，并将线钩（B）插入上弯针针孔里。

上弯针(C):
将线钩插入弯针针孔。

(D): 如果线钩的弹性不够，或不能顺利的插进上弯针孔，请调整线钩的弯曲部分。

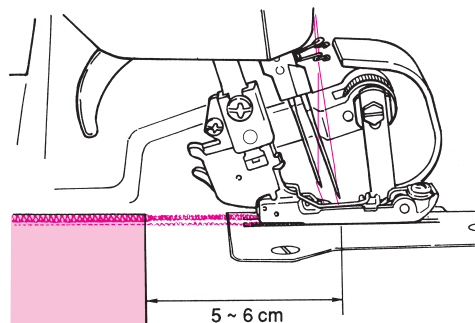
- ②将下弯针线穿过2/3线转换器的线钩的上方，然后放在压脚下面（E）。

After threading, make a sample stitch.

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

Chainstitch sewing test:

1. Set the thread tension dials.
2. Lower the upper knife, depending on stitch choice.
3. Lower the presser foot.
4. When starting to sew chainstitch, place the fabric under the presser foot (chainstitch can only be sewn in fabric). Sew.
5. At the end of the seam, continue sewing to form a 5 to 6 cm long thread chain.
6. Holding the fabric with one hand, pull the thread chain over the thread cutter on the presser foot shank.

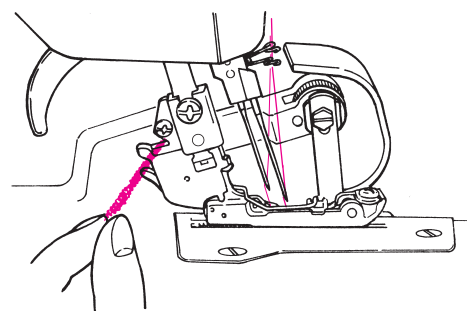


穿线后，进行试缝。

请使用双层面料以检查缝口以及线的张力是否合适。

链缝试缝：

1. 设定线张力刻度。
2. 放下上刀，取决于选择的针迹。
3. 放下压脚。
4. 开始进行链缝时，将面料放在压脚下面（仅在面料上进行链行缝）。开始缝纫。
5. 在缝口的结束时，继续空缝5—6 cm。
6. 一手持面料，将线放在压脚切线器上切断线。



Overlock sewing test:

1. Set the thread tension dials.
2. Make sure that the upper knife is lowered, (in the cutting position).
3. Lower the presser foot.
4. Raise the tip of the presser foot with your thumb and place the fabric under the foot up to the knife. Let go of the foot and sew.
5. At the end of the seam, continue sewing to form a 5 to 6 cm long thread chain.
6. Holding the fabric with one hand, pull the thread chain over the thread cutter on the presser foot shank.

包缝试缝

1. 设定线张力刻度。
2. 确保放下上刀。（在切的位置）。
3. 放下压脚。
4. 抬起压脚前端，将面料放在压脚下面正对刀，用脚踩，开始缝纫。
5. 在缝口的结束时，继续空缝5—6 cm。
6. 一手持面料，将线放在压脚切线器上切断线。

Thread tension dial

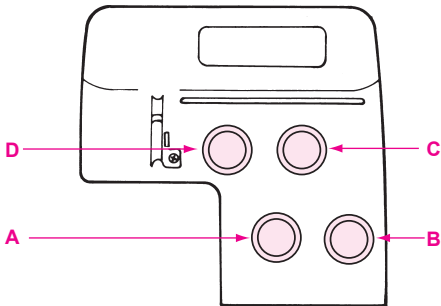
调节线张力

Adjusting the thread tension

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

Adjusting thread tension dial		Standard of the thread tensioner dial
A	Upper looper thread tension	3 ~ 5
B	Lower looper thread tension	3 ~ 5
C	Right-hand needle thread tension	3 ~ 5
	Left-hand needle thread tension (for chainstitch and wide 3-thread overlock)	6 ~ 7
D	Chainstitch needle thread tension	2.5 ~ 4.5
	Left-hand needle thread tension	3 ~ 5

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

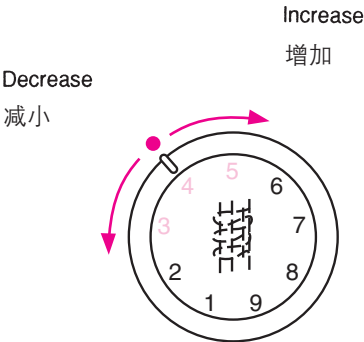


调节线张力

通过调节线张力值（1-9），可以修正不美观的针迹。

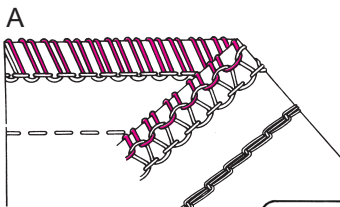
调整线张力调节旋钮		线张力调节旋钮刻度
A	上弯针旋钮	3~5
B	下弯针旋钮	3~5
C	右针旋钮	3~5
	左针旋钮（用于宽幅3-线包缝）	6~7
D	链缝机针旋钮	2.5~4.5
	左针旋钮	3~5

*当使用丝线或羊毛线时，请调整相应的线张力。



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 thread meet on the underside of the fabric:

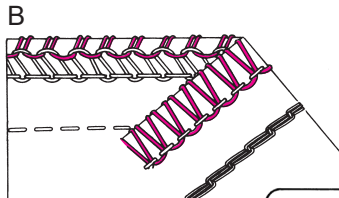
B – If the lower looper thread meet on the upper side of the fabric:

C – If the right-hand needle thread forms loops on the underside of the fabric:

D – If the chainstitch 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

按箭头所示调整线张力调节旋钮，然后试缝。

A—上弯针线环偏向面料反面。

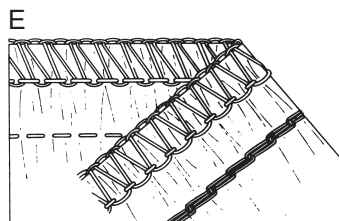
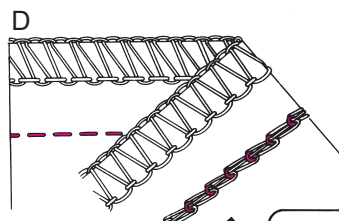
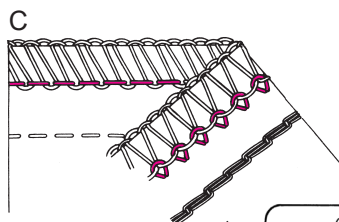
B—下弯针线环偏向面料正面。

C—右针线针脚，在面料反面浮起。

D—链缝机针在面料反面权松垮。

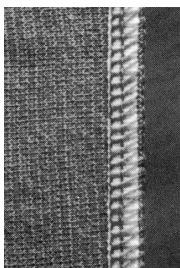
E—面料被包在线环中起皱。

*调低下刀调节旋钮刻度，减少切刀宽度。



Sewing in tape

镶带缝



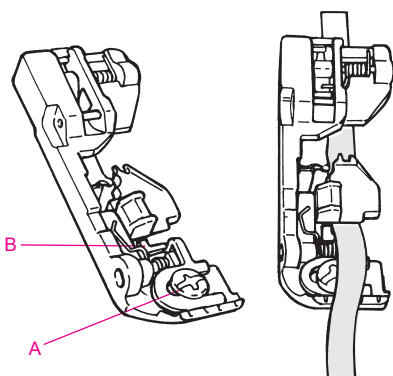
Sewing in tape



Switch the machine off (power switch “0”)

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 stabilize the seam.

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.



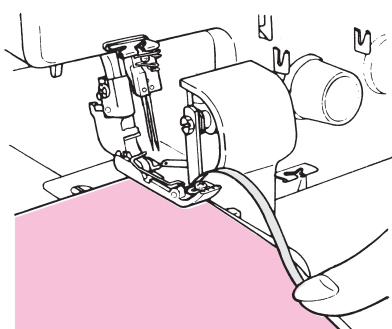
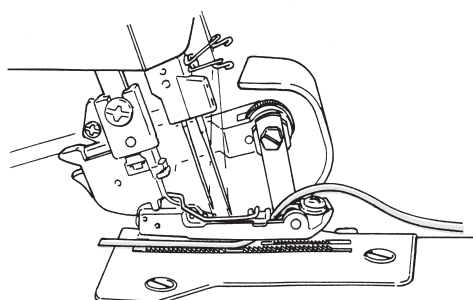
镶带缝



关闭机器电源（电源开关到“0”）

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。

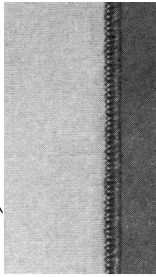
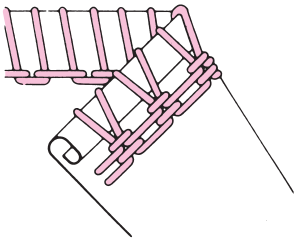
1. 正转飞轮，使机针转至最高点。
2. 抬起压脚，将镶带放入压脚槽，再放下压脚。
3. 拧松导向装置的调节螺钉（A），按镶带的宽度调节镶带导向装置（B）。
4. 用手正转飞轮，使线在带子上缝制2—3针。
5. 将面料放在压脚下面。
6. 缝制开始，带子会随面料一同行进。



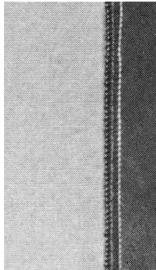
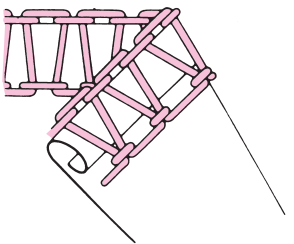
Roll hemming

卷缝

A



B



Roll hemmer



Switch the machine off (power switch “0”)

The roll hemmer is built-in to the sewing machine. The fabric edge is automatically rolled 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. Set the lower knife adjusting knob at “1 ~ 2”.
 3. Turn the overlocking width selection knob toward you to align with the red marking in front of the throat plate.
 4. Set the stitch length adjusting knob at “1 ~ 1.5”.
- * Adjust the thread tensions as desired. Tighten the lower looper tension.

(A): Rolled hem

Roll 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.

卷缝



关闭机器电源（电源开关到“0”）

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

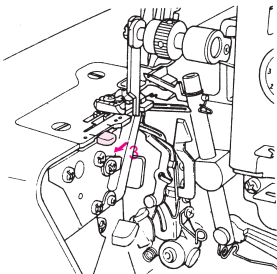
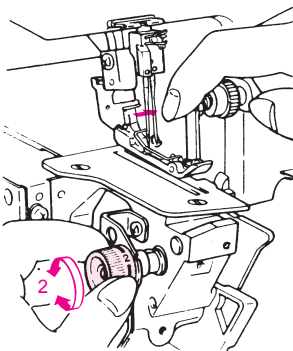
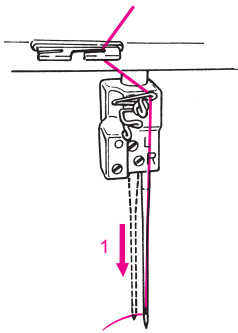
1. 取下左机针，使机器呈三线缝纫状。
 2. 将下刀调节旋钮调至“1-2”。
 3. 将包缝宽度选择扳手朝自己方向拉。
 4. 将针距调节旋钮调至“1-1.5”。
- * 按需要调节线张力。增加下弯针张力。

(A): 卷边缝

卷边缝是使上弯针线全部覆盖在被卷面料下方。

(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)

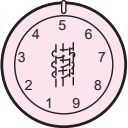
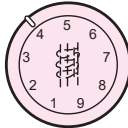
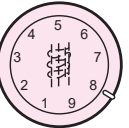
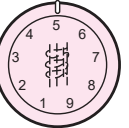
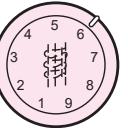
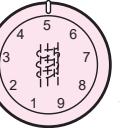
- Thread tension slightly differs depending on the types of the fabric and thread.
- Use the woolly nylon thread or thinner thread for roll hemming to attain the beautiful finish.
- Use the thin polyester spun thread thinner than Tex No.21
- Woolly nylon thread can be used only for the upper looper.

卷缝标准张力对照表（用于卷边缝和窄边缝）

- 根据面料和线情况不同，线张力也稍有不同。
- 用毛状尼龙或较细的线卷边，缝迹会显的更漂亮。
- 用比Tex No.21还细的精纺线。
- 毛状尼龙线只能用于弯针。

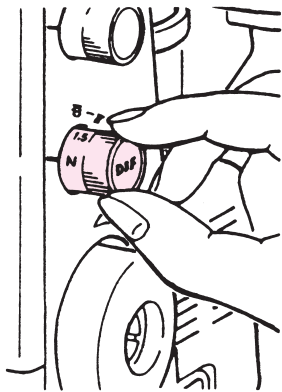
* Adjust the thread tensions as desired.

* 调节合适的线张力

• Thread tension dial value • 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 • 线型号						
• Polyester spun Tex No. 21 (Japanese system No:80) • 精纺线 Tex No.21	4 ~ 6	3 ~ 5	7 ~ 9	4 ~ 6	5 ~ 7	4 ~ 6
• Polyester filament Tex No. 12 • 棉线 Tex No.12	3 ~ 5	3 ~ 5	6 ~ 8	3 ~ 5	3 ~ 5	3 ~ 5
• Woolly nylon Tex No. 26 • 毛状尼龙线 Tex No.26		3 ~ 5			3 ~ 5	

Differential feed

差动送料

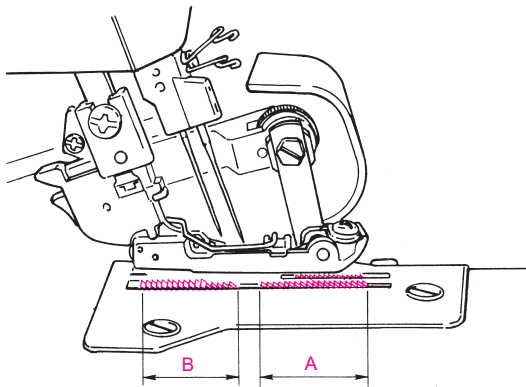


Differential feed

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

布料需打褶或伸展时，可以通过差动送料调节旋钮来调节（调节送布牙前牙A和送布牙后牙B的送料比）。调节后须试缝。



Sewn with waves

缝口出现波浪

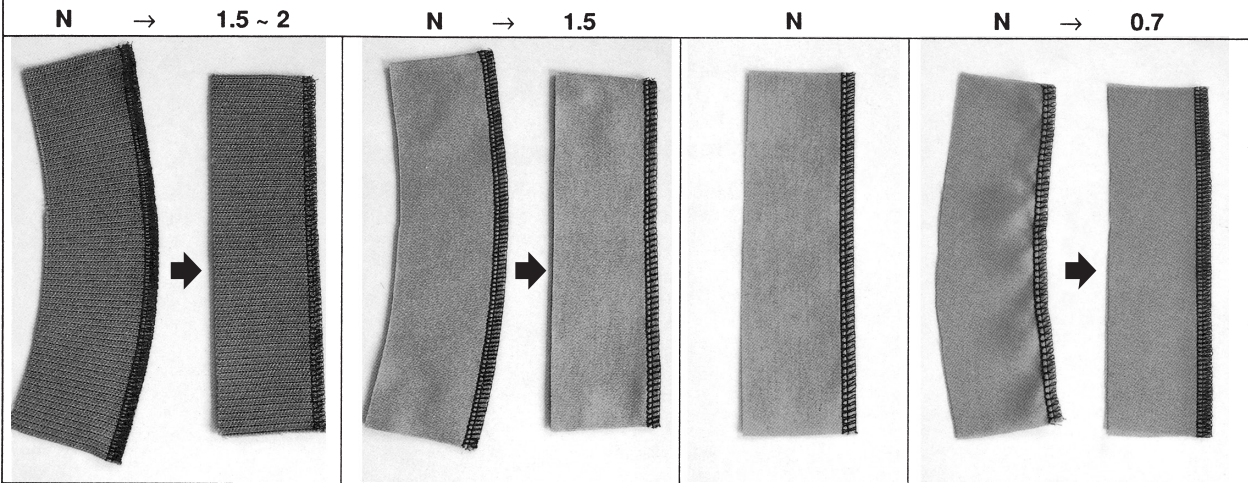
Sewn with puckerings

缝口起皱

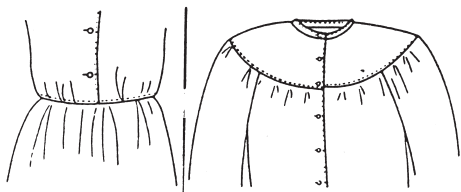
Fabric / 面料	• Wool knit, thick hand-knitted garments, and other stretchy fabrics · 毛织物、手编织物、其他延伸性面料、针织面料	• Thin knitted fabric, knitted garments, and jersey · 薄型编织物、手编织物、平针织物	• Woven fabrics · 针织面料	• Georgette, linen, satin, poplin · 乔其纱、亚麻布、缎子、毛革

Set value of the differential feed adjusting knob/Ajuste el valor

可通过调节差动送料调节旋钮实现

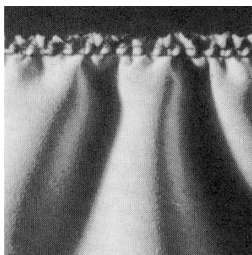


Gathering / 打裱



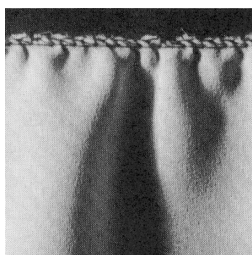
4-thread gathering

4线打裱



3-thread gathering

3线打裱



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".

For examples: Sleeve heads, lower edges, yokes, lace edging or frills

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

打裱

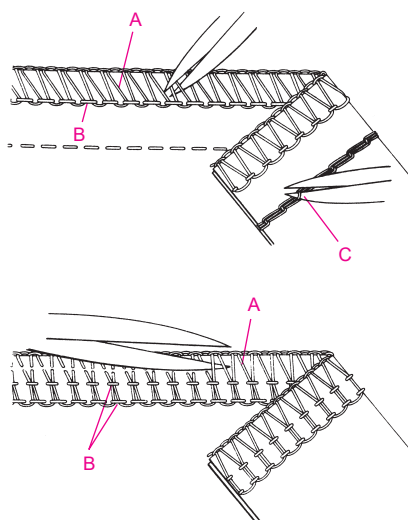
1. 单层薄型面料可以进行打裱。
 2. 将送料调节旋钮调至最大位置 "4" 。
 3. 将差动送料调节旋钮调至 "1.5-2" 。
- * 当无须差动送料，可将差动送料旋钮调至 "N" 。

Unpicking seams

Unpicking the seams of the 4 or 3-thread overlock
Cut the thread at (A), (C) with scissors, and pull needle thread (B).
The stitches will come undone.

缝口的拆法

拆开4线或3线包缝缝口
在 (A) 点处用剪刀 (C) 剪断线环，拉出机针线 (B) 。
针脚就会被拆开。



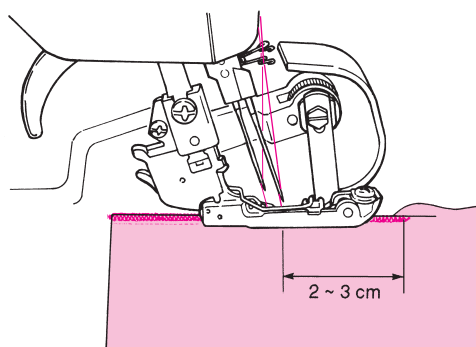
Thread breakage during sewing

缝纫中断线

Thread breakage during sewing

 **Switch the machine off (power switch “0”)**

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.



缝纫中断线

 **关闭机器电源（电源开关到“0”）**

1. 马上停止缝纫，取出面料。
2. 重新穿线。
 - * 如果下弯针断线，则剪断左、右机针线，并抽掉余线，待下弯针线穿好后，再穿左、右机针线。
 - * 如果上弯针断线，则剪断左右机针线，并抽掉余线，将上弯针转至最下位置，然后给上弯针穿线。
将线放在压脚下并从后拉出大约 10 cm。
3. 抬起压脚，将面料放在压脚下。在断线前面2—3 cm开始重新缝纫。

Securing seams

缝口的收拢

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.

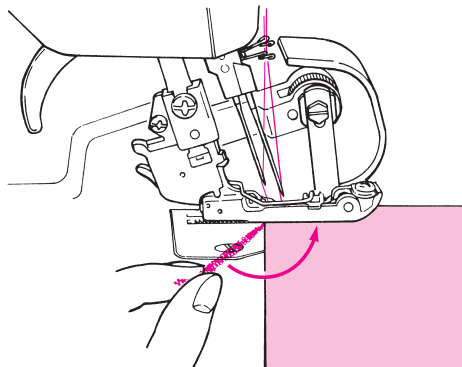
* When seams cross over one another, the thread chain is automatically closed.

缝口的收拢

1. 先缝3—4 cm 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。

如果不在空环上缝，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。



Replacing the upper knife

The upper knife is made of special extra-hard steel and does not need to be replaced.

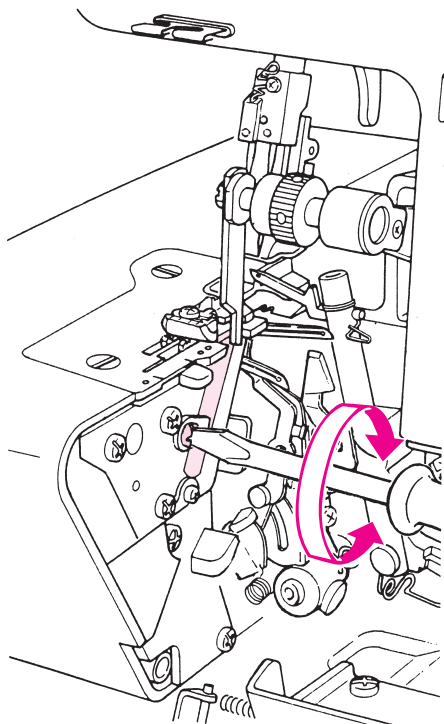
Replace the upper knife only when the knife blade tip is damaged.

For a replacement, contact your local dealer.

Replacing the lower knife

⚠ Always must be disconnected plug from socket-outlet.

1. Turn the handwheel toward you until the needles are fully raised.
2. Release the upper knife.
3. Loosen the setscrews on the lower knife retaining plate with the large screwdriver. Then remove the lower knife.
4. Fit the replacement knife (spare lower knife) into the groove and attach the lower knife to the knife vertical motion adjuster.
(The tip of the lower knife blade aligns with the upper surface of the throat plate.)
5. Tighten the setscrews on the lower knife retaining plate securely.



更换上刀

⚠ 警告：
请参阅安全使用说明。

上刀是由特殊的超硬钢制成，无须更换。

仅在刀刃损坏时更换上刀。

更换时，联系当地经销商。

更换下刀

⚠ 注意切断电源。

1. 正转飞轮使机针处于最高点。
2. 翻起上刀。
3. 用大螺丝刀拧开下刀固定的螺丝，取下下刀。
4. 将置换的刀（配置的下刀）插入下刀槽里，并将下刀后端紧靠在下刀高度调节台上。（下刀刃端与针板的上表面平齐）。
5. 拧紧下刀固定板螺丝。

Maintenance / 保养

Cleaning and lubricating



Main switch off "0". Disconnect machine from electricity supply.

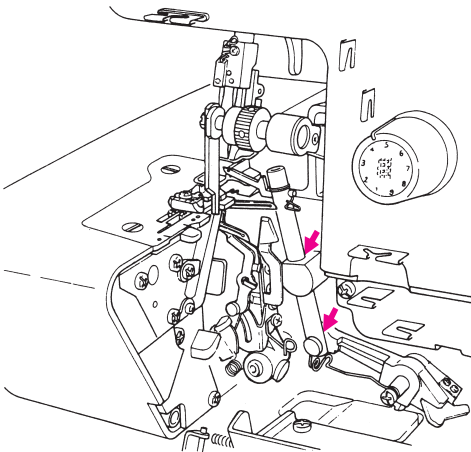
During sewing, dust and fluff collect in and on the machine. This should be removed regularly. Your overlock machine requires very little lubrication. Now and then, lubricate only the points illustrated.

Please refer to safety instructions.



Precautions to be taken when handling oil

- * In the event the oil gets in the eye or adheres on skin, immediately wash it off in order to prevent irritation and rash.
- * If swallowed accidentally, immediately seek for medical advice in order to prevent diarrhea and vomiting.
- * Keep the oil away from children.
- * Oil disposal is obliged by legislation. Dispose of the oil properly in compliance with the relevant legislation.



清洁和润滑



关闭机器电源（电源开关置于“0”）不要连接电源线

缝纫时，灰尘和绒毛会被缝纫机收集，需要定期清除。

您的包缝机只需少量润滑。通常，润滑只需在图示的点位置。请参考安全用法说明。



处理油渍的预防措施

- * 当发生润滑油进入眼睛或附着在皮肤上时，请立刻清洗以防刺激或更严重后果
- * 当发生意外吞食，请立刻寻求医学帮助以防腹泻和呕吐。
- * 使润滑油远离儿童
- * 油品处理是法律规定。处理油品需服从相关法律。

How to use an accessory oiler



CAUTION: Be careful not to hurt your hands while working.

When you use the oiler for the first time, remove the cap and cut the tip of the oiler spout slightly with a pair of scissors. Then, make a hole in the tip with a pushpin or the like.

- * Be aware that, if you cut the tip of the oiler spout excessively, the hole will become larger to make it hard to supply a constant amount of oil.

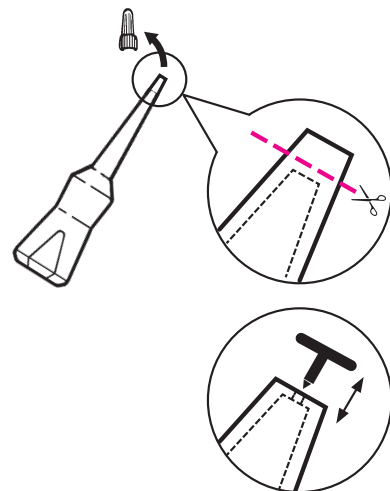
附件油壶的相关使用方法



注意：操作中请务必小心谨防误伤手指。

第一次使用时请先取下油壶瓶盖，然后用剪刀将油壶嘴的前端剪掉一截，再用图钉等将油壶嘴的前端戳出一个洞后再使用。

- * 如果剪刀将油壶前端剪得过多的话，会造成油壶嘴前端的孔变大，从而会导致在加油时无法很好的掌控加油量，因此请特别注意。



1. Cut the tip with a pair of scissors.

- * It is important to leave the resin-sealed portion (approximately 0.5 mm) instead of cutting the tip until the penetrated portion is reached.

2. Make a hole with a pushpin or the like.

1 先用剪刀将油壶嘴的前端剪去

- * 大概以未剪漏前端为准(0.5mm左右)
剪的时候千万注意不要将油壶嘴前端密封用的树脂部分全部剪掉。

2 然后用图钉(钉子)等将油壶嘴前端戳出一个洞。

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.	● Presser foot pressure is too low.	Increase the presser foot pressure by turning the presser foot pressure adjusting screw to the right.	10
Needles break	● Needles are bent, or the needle point is blunt. ● Needles are incorrectly inserted. ● The fabric cloth is excessively stretched.	Replace the needles.	11
		Insert the needle correctly. Hold the edge of the material cloth lightly with your hand when sewing.	11 —
Thread breaks	● The machine is incorrectly threaded. ● Thread tension is too high. ● Needles are incorrectly inserted.	Rethread the machine correctly. Adjust the thread tension properly. Insert the needles correctly.	14~26 29, 30 11
Stitch skips	● Needles are bent or needle point is blunt. ● Needles are incorrectly inserted. ● The machine is incorrectly threaded.	Replace the needles. Insert the needles correctly. Rethread the machine correctly.	11 11 14~26
Poor stitches are formed	● Thread tension is not proper.	Adjust the thread tension properly.	29, 30
Seams flute or wave, especially when sewing knits	● Presser foot pressure is too high. ● Differential feed is set incorrectly.	Reduce presser foot pressure. Adjust differential feed to N-2.	10 34
Seams pucker	● Thread tension is too high. ● Differential feed is set incorrectly.	Set the thread tension adjusting dial to the smaller value.	29, 30
		Adjust differential feed to 0.7-N.	34
Motor trouble	● The motor makes noise. ● The motor will not rotate. ● Unusually large sparks are emitted.	Dealer should the carbon brush.	—

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

故障排除指南

下列故障并非机器故障，请线查阅报表，在向我们提出维修。

故障	原因	处理方法	参考页次
面料不行进	• 压脚压力太低	将调压螺钉顺时针旋，以增加压脚压力	10
断针	• 机针弯曲或针尖磨损 • 机针装错 • 面料过度拉长	换针 正确装针 缝制时用手轻拉面料	11 11 —
断线	• 穿线错误 • 线张力过大 • 机针装错	重新正确穿线 适当调节线张力 正确装针	14–26 29、30 11
跳针	• 机针弯曲或针尖磨损 • 机针装错 • 穿线错误	换针 正确装针 重新正确穿线	11 11 14–26
线迹成形不好	• 线张力不当	调节合适的线张力	29、30
缝口凹陷波状，尤以针织物常见	• 压脚压力太大 • 差动送料调节旋钮位置错误	减小压脚压力 将差动旋钮调至N–2	10 34
缝口起皱	• 线张力过高 • 差动旋钮位置不对	减小线张力 将差动旋钮调整为0.7–N	29、30 34
马达故障	• 马达噪音 • 马达不转 • 出现罕见火花	更换电机碳刷	—

如故障仍不能排除，请联系当地经销商。

Specifications

规格

Specifications

Item	Specifications
Number of threads	5 threads, 4 threads, 3 threads, 2 threads
Needles	130/705H
Overlocking width	Left-hand needle : 6 mm Right-hand needle : 4 mm (for roll hemming : 2 mm) Chainstitch needle : 10 mm
Stitch length (feeding amount)	1 to 4 mm (standard stitch length : 2.5 mm)
Differential feed	No waving or fluting in knits N-2. No puckering 0.7-N
Presser foot lift	5 mm
Sewing speed	Max. 1,500 sti/min
Dimensions	315 (W) × 345 (D) × 295 (H) mm
Weight	7.4 kg
Foot control	230VModel YC483N

规格

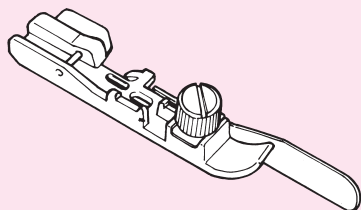
项目	规格
用线数	5线、4线、3线、2线
机针	130/705H
包缝宽度	左机针：6 mm 右机针：4 mm (卷缝：2 mm) 链缝机针：10 mm
针距（送料量）	1—4 mm (标准针距：2.5 mm)
差动送料	针织品无波纹或延伸：N—2 无起皱：0.7—N
压脚升降高度	5 mm
缝速	最大1500针/分
外形尺寸	315 (W) *345 (D) *295 (H) mm
重量	7.4 kg
脚踏控速器	230V...Model YC483N

Optional accessories

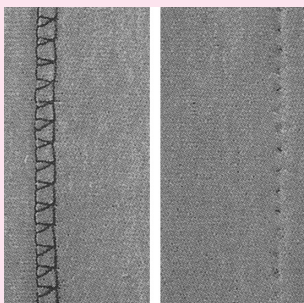
另购附件

- Blind stitch presser foot

- 暗缝压脚

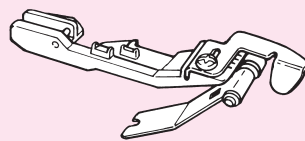


A9810 634 0A0

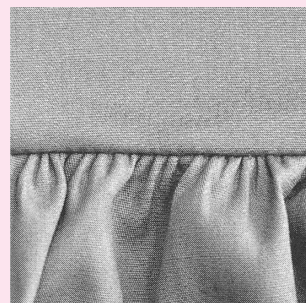


- Gathering presser foot

- 聚裊压脚

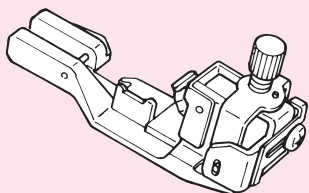


A9860 634 0A0

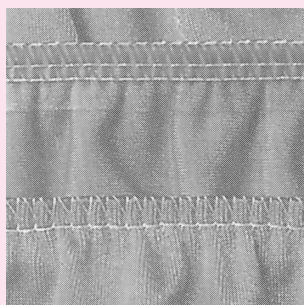


- Elasticator

- 弹簧压脚

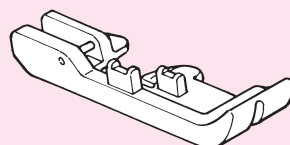


A9815 634 0A0

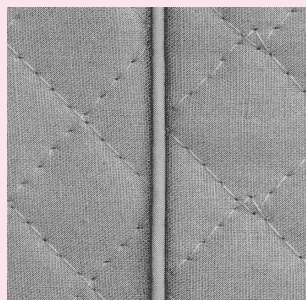


- Piping presser foot

- 滚带压脚

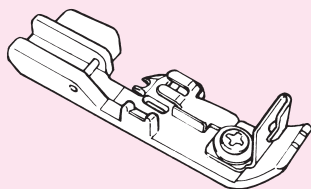


A9865 634 0A0

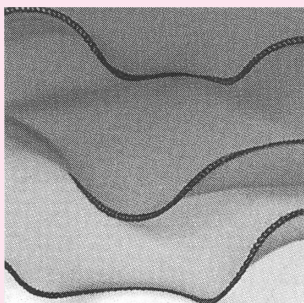


- Cording presser foot

- 花边压脚

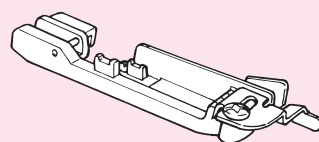


A9820 634 0A0

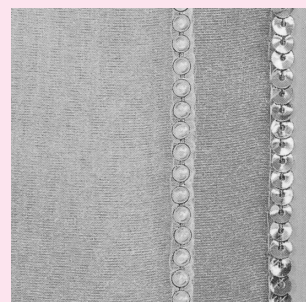


- Beading presser foot

- 珍珠压脚



A9870 634 0A0



Contact your local dealer.

如需上述附件，请与当地购买店联系。



重机(中国)投资有限公司

地址:上海市普陀区中江路118弄22号

海亮大厦A座901~903室

电话:021-62368888

