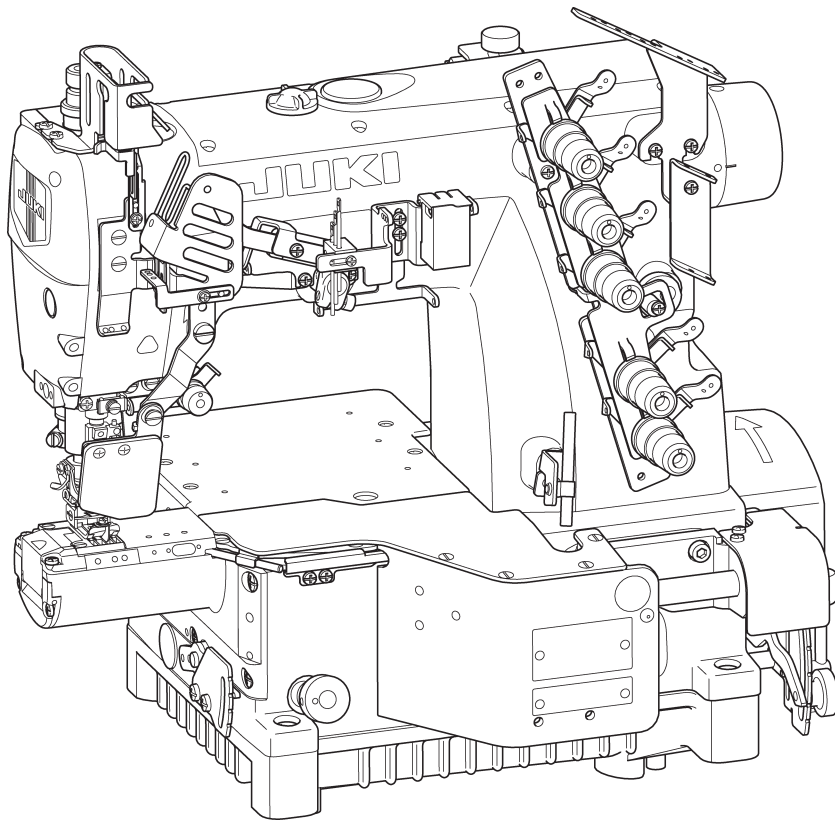


MF-7200D

INSTRUCTION MANUAL 使用说明书



NOTE : Read safety instructions carefully and understand them before using.
Retain this Instruction Manual for future reference.

注意： 为了安全地使用，请您在使用之前一定阅读本使用说明书。
另外，请您注意保管本使用说明书，以便随时查阅。

TO ENSURE SAFE USE OF YOUR SEWING MACHINE

For the sewing machine, automatic machine and ancillary devices (hereinafter collectively referred to as "machine"), it is inevitable to conduct sewing work near moving parts of the machine. This means that there is always a possibility of unintentionally coming in contact with the moving parts. Operators who actually operate the machine and maintenance personnel who are involved in maintenance and repair of the machine are strongly recommended to carefully read to fully understand the following **SAFETY PRECAUTIONS** before using/maintaining the machine. The content of the **SAFETY PRECAUTIONS** includes items which are not contained in the specifications of your product.

The risk indications are classified into the following three different categories to help understand the meaning of the labels. Be sure to fully understand the following description and strictly observe the instructions.

(I) Explanation of risk levels

	DANGER : This indication is given where there is an immediate danger of death or serious injury if the person in charge or any third party mishandles the machine or does not avoid the dangerous situation when operating or maintaining the machine.
	WARNING : This indication is given where there is a potentiality for death or serious injury if the person in charge or any third party mishandles the machine or does not avoid the dangerous situation when operating or maintaining the machine.
	CAUTION : This indication is given where there is a danger of medium to minor injury if the person in charge or any third party mishandles the machine or does not avoid the dangerous situation when operating or maintaining the machine.
	Items requiring special attention.

(II) Explanation of pictorial warning indications and warning labels

Pictorial warning indication		There is a risk of injury if contacting a moving section.	Pictorial warning indication		Be aware that holding the sewing machine during operation can hurt your hands.
		There is a risk of electrical shock if contacting a high-voltage section.			There is a risk of entanglement in the belt resulting in injury.
		There is a risk of a burn if contacting a high-temperature section.			There is a risk of injury if you touch the button carrier.
		Be aware that eye deficiency can be caused by looking directly at the laser beam.	Indication label		The correct direction is indicated.
		There is a risk of contact between your head and the sewing machine.			Connection of a earth cable is indicated.

Warning label			
	<ul style="list-style-type: none"> ① • There is the possibility that slight to serious injury or death may be caused. • There is the possibility that injury may be caused by touching moving part. ② • To perform sewing work with safety guard. • To perform sewing work with safety cover. • To perform sewing work with safety protection device. ③ • Be sure to turn the power OFF before carrying out "machine-head threading", "needle changing", "bobbin changing" or "oiling and cleaning". 		

Electrical-shock danger label		<p>危険</p> <p>高電圧部分に触れて、大けがをすることがある。 電源を切って、5分以上たってからカバーをはずすこと。</p>	<p>DANGER</p> <p>Hazardous voltage will cause injury. Turn off main switch and unplug power cord and wait at least 5 minutes before opening this cover.</p>
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SAFETY PRECAUTIONS

Accident means "to cause personal injury or death or damage to property."



DANGER

1. When it is necessary to open the control box containing electrical parts, be sure to turn the power off and wait for five minutes or more before opening the cover in order to prevent accident leading to electrical shock.



CAUTION

Basic precaution

1. Be sure to read the instruction manual and other explanatory documents supplied with accessories of the machine before using the machine. Carefully keep the instruction manual and the explanatory documents at hand for quick reference.
2. The content of this section includes items which are not contained in the specifications of your product.
3. Be sure to wear safety goggles to protect against accident caused by needle breakage.
4. Those who use a heart pacemaker have to use the machine after consultation with a medical specialist.

Safety devices and warning labels

1. Be sure to operate the machine after verifying that safety device(s) is correctly installed in place and works normally in order to prevent accident caused by lack of the device(s).
2. If any of the safety devices is removed, be sure to replace it and verify that it works normally in order to prevent accident that can result in personal injury or death.
3. Be sure to keep the warning labels adhered on the machine clearly visible in order to prevent accident that can result in personal injury or death. If any of the labels has stained or come unstuck, be sure to change it with a new one.

Application and modification

1. Never use the machine for any application other than its intended one and in any manner other than that prescribed in the instruction manual in order to prevent accident that can result in personal injury or death. JUKI assumes no responsibility for damages or personal injury or death resulting from the use of the machine for any application other than the intended one.
2. Never modify and alter the machine in order to prevent accident that can result in personal injury or death. JUKI assumes no responsibility for damages or personal injury or death resulting from the machine which has been modified or altered.

Education and training

1. In order to prevent accident resulting from unfamiliarity with the machine, the machine has to be used only by the operator who has been trained/educated by the employer with respect to the machine operation and how to operate the machine with safety to acquire adequate knowledge and operation skill. To ensure the above, the employer has to establish an education/training plan for the operators and educate/train them beforehand.

Items for which the power to the machine has to be turned off

Turning the power off: Turning the power switch off, then removing the power plug from the outlet.
This applies to the following.

1. Be sure to immediately turn the power off if any abnormality or failure is found or in the case of power failure in order to protect against accident that can result in personal injury or death.
2. To protect against accident resulting from abrupt start of the machine, be sure to carry out the following operations after turning the power off. For the machine incorporating a clutch motor, in particular, be sure to carry out the following operations after turning the power off and verifying that the machine stops completely.
 - 2-1. For example, threading the parts such as the needle, looper, spreader etc. which have to be threaded, or changing the bobbin.
 - 2-2. For example, changing or adjusting all component parts of the machine.
 - 2-3. For example, when inspecting, repairing or cleaning the machine or leaving the machine.
3. Be sure to remove the power plug by holding the plug section instead of the cord section in order to prevent electrical-shock, earth-leakage or fire accident.
4. Be sure to turn the power off whenever the machine is left unattended between works.
5. Be sure to turn the power off in the case of power failure in order to prevent accident resulting of breakage of electrical components.

PRECAUTIONS TO BE TAKEN IN VARIOUS OPERATION STAGES

Transportation

1. Be sure to lift and move the machine in a safe manner taking the machine weight in consideration. Refer to the text of the instruction manual for the mass of the machine.
2. Be sure to take sufficient safety measures to prevent falling or dropping before lifting or moving the machine in order to protect against accident that can result in personal injury or death.
3. Once the machine has been unpacked, never re-pack it for transportation to protect the machine against breakage resulting from unexpected accident or dropping.

Unpacking

1. Be sure to unpack the machine in the prescribed order in order to prevent accident that can result in personal injury or death. In the case the machine is crated, in particular, be sure to carefully check nails. The nails have to be removed.
2. Be sure to check the machine for the position of its center of gravity and take it out from the package carefully in order to prevent accident that can result in personal injury or death.

Installation

(I) Table and table stand

1. Be sure to use JUKI genuine table and table stand in order to prevent accident that can result in personal injury or death. If it is inevitable to use a table and table stand which are not JUKI genuine ones, select the table and table stand which are able to support the machine weight and reaction force during operation.
2. If casters are fitted to the table stand, be sure to use the casters with a locking mechanism and lock them to secure the machine during the operation, maintenance, inspection and repair in order to prevent accident that can result in personal injury or death.

(II) Cable and wiring

1. Be sure to prevent an extra force from being applied to the cable during the use in order to prevent electrical-shock, earth-leakage or fire accident. In addition, if it is necessary to cable near the operating section such as the V-belt, be sure to provide a space of 30 mm or more between the operating section and the cable.
2. Be sure to avoid starburst connection in order to prevent electrical-shock, earth-leakage or fire accident.
3. Be sure to securely connect the connectors in order to prevent electrical-shock, earth-leakage or fire accident. In addition, be sure to remove the connector while holding its connector section.

(III) Grounding

1. Be sure to have an electrical expert install an appropriate power plug in order to prevent accident caused by earth-leakage or dielectric strength voltage fault. In addition, be sure to connect the power plug to the grounded outlet without exceptions.
2. Be sure to ground the earth cable in order to prevent accident caused by earth leakage.

(IV) Motor

1. Be sure to use the specified rated motor (JUKI genuine product) in order to prevent accident caused by burnout.
2. If a commercially available clutch motor is used with the machine, be sure to select one with an entanglement preventive pulley cover in order to protect against being entangled by the V-belt.

Before operation

1. Be sure to make sure that the connectors and cables are free from damage, dropout and looseness before turning the power on in order to prevent accident resulting in personal injury or death.
2. Never put your hand into the moving sections of the machine in order to prevent accident that can result in personal injury or death.
In addition, check to be sure that the direction of rotation of the pulley agrees with the arrow shown on pulley.
3. If the table stand with casters is used, be sure to secure the table stand by locking the casters or with adjusters, if provided, in order to protect against accident caused by abrupt start of the machine.

During operation

1. Be sure not to put your fingers, hair or clothing close to the moving sections such as the handwheel, hand pulley and motor or place something near those sections while the machine is in operation in order to prevent accident caused by entanglement that can result in personal injury or death.
2. Be sure not to place your fingers near the surround area of the needle or inside the thread take-up lever cover when turning the power on or while the machine is in operation in order to prevent accident that can result in personal injury or death.
3. The machine runs at a high speed. Never bring your hands near the moving sections such as looper, spreader, needle bar, hook and cloth trimming knife during operation in order to protect your hands against injury. In addition, be sure to turn the power off and check to be sure that the machine completely stops before changing the thread.
4. Be careful not to allow your fingers or any other parts of your body to be caught between the machine and table when removing the machine from or replacing it on the table in order to prevent accident that can result in personal injury or death.

5. Be sure to turn the power off and check to be sure that the machine and motor completely stop before removing the belt cover and V-belt in order to prevent accident caused by abrupt start of the machine or motor.
6. If a servomotor is used with the machine, the motor does not produce noise while the machine is at rest. Be sure not to forget to turn the power off in order to prevent accident caused by abrupt start of the motor.
7. Never use the machine with the cooling opening of the motor power box shielded in order to prevent fire accident by overheat.

Lubrication

1. Be sure to use JUKI genuine oil and JUKI genuine grease to the parts to be lubricated.
2. If the oil adheres on your eye or body, be sure to immediately wash it off in order to prevent inflammation or irritation.
3. If the oil is swallowed unintentionally, be sure to immediately consult a medical doctor in order to prevent diarrhea or vomiting.

Maintenance



1. In prevention of accident caused by unfamiliarity with the machine, repair and adjustment has to be carried out by a service technician who is thoroughly familiar with the machine within the scope defined in the instruction manual. Be sure to use JUKI genuine parts when replacing any of the machine parts. JUKI assumes no responsibility for any accident caused by improper repair or adjustment or the use of any part other than JUKI genuine one.
2. In prevention of accident caused by unfamiliarity with the machine or electrical-shock accident, be sure to ask an electrical technician of your company or JUKI or distributor in your area for repair and maintenance (including wiring) of electrical components.
3. When carrying out repair or maintenance of the machine which uses air-driven parts such as an air cylinder, be sure to remove the air supply pipe to expel air remaining in the machine beforehand, in order to prevent accident caused by abrupt start of the air-driven parts.
4. Be sure to check that screws and nuts are free from looseness after completion of repair, adjustment and part replacement.
5. Be sure to periodically clean up the machine during its duration of use. Be sure to turn the power off and verify that the machine and motor stop completely before cleaning the machine in order to prevent accident caused by abrupt start of the machine or motor.
6. Be sure to turn the power off and verify that the machine and motor stop completely before carrying out maintenance, inspection or repair of the machine. (For the machine with a clutch motor, the motor will keep running for a while by inertia even after turning the power off. So, be careful.)
7. If the machine cannot be normally operated after repair or adjustment, immediately stop operation and contact JUKI or the distributor in your area for repair in order to prevent accident that can result in personal injury or death.
8. If the fuse has blown, be sure to turn the power off and eliminate the cause of blowing of the fuse and replace the blown fuse with a new one in order to prevent accident that can result in personal injury or death.
9. Be sure to periodically clean up the air vent of the fan and inspect the area around the wiring in order to prevent fire accident of the motor.

Operating environment

1. Be sure to use the machine under the environment which is not affected by strong noise source (electromagnetic waves) such as a high-frequency welder in order to prevent accident caused by malfunction of the machine.
2. Never operate the machine in any place where the voltage fluctuates by more than "rated voltage $\pm 10\%$ " in order to prevent accident caused by malfunction of the machine.
3. Be sure to verify that the air-driven device such as an air cylinder operates at the specified air pressure before using it in order to prevent accident caused by malfunction of the machine.
4. To use the machine with safety, be sure to use it under the environment which satisfies the following conditions:

Ambient temperature during operation	5°C to 35°C
Relative humidity during operation	35 % to 85 %
5. Dew condensation can occur if bringing the machine suddenly from a cold environment to a warm one. So, be sure to turn the power on after having waited for a sufficient period of time until there is no sign of water droplet in order to prevent accident caused by breakage or malfunction of the electrical components.
6. Be sure to stop operation when lightning flashes for the sake of safety and remove the power plug in order to prevent accident caused by breakage or malfunction of the electrical components.
7. Depending on the radio wave signal condition, the machine may generate noise in the TV or radio. If this occurs, use the TV or radio with kept well away from the machine.
8. In order to ensure the work environment, local laws and regulations in the country where the sewing machine is installed shall be followed.
In the case the noise control is necessary, an ear protector or other protective gear should be worn according to the applicable laws and regulations.
9. Disposal of products and packages and treatment of used lubricating oil should be carried out properly according to the relevant laws of the country in which the sewing machine is used.

FOR SAFE OPERATION

	<ol style="list-style-type: none">1. To prevent accidents caused by electric shock, never open the motor control box cover or touch the components inside the control box while the power switch is ON.
	<ol style="list-style-type: none">1. Never bring your fingers under the needle when the power switch is turned ON or the machine is in operation.2. Never bring your fingers, hair or clothes close to the pulley and needle or place anything on the pulley and under the needle while the machine is in operation.3. Never operate the machine with the safety devices such as belt cover, needle bar thread take-up cover, finger guard, eye guard cover, etc. removed.4. Be sure to turn OFF the power and perform the work after ascertaining that the sewing machine does not run even when the starting pedal is depressed in case of checking, adjusting, cleaning, threading or replacing the needle of the sewing machine.5. Never operate the sewing machine with the ground wire for the power supply removed so as to ensure safety.6. Be sure to turn OFF the power switch in advance in case of inserting/removing the power plug.7. In time of thunder and lightning, stop your work and disconnect the power plug from the receptacle so as to ensure safety.8. When you move the sewing machine from a cold place directly to a warm place, dew condensation may result. Turn ON the power to the machine after you have confirmed that there is no fear of dew condensation.9. In case of maintenance, inspection, or repair, be sure to turn OFF the power switch and confirm that the sewing machine and the motor have completely stopped before starting the work. (In case of the clutch motor, it continues rotating for a while by the inertia even after turning OFF the power switch. So, be careful.)10. Be careful of handling this product so as not to pour water or oil, shock by dropping, and the like since this product is a precision instrument.

CAUTION BEFORE OPERATION



WARNING :

To avoid malfunction and damage of the machine, confirm the following.

- Be sure to fill the oil hole with oil designated by JUKI before use.
- Clean the sewing machine thoroughly before using it for the first time.
- Remove all dust collected on the sewing machine during the transportation.
- Confirm that the voltage and phase are correct.
- Confirm that the power plug is properly connected.
- Never use the sewing machine in the state where the voltage type is different from the designated one.
- The direction of rotation of the sewing machine is clockwise as observed from the pulley side. Be careful not to rotate it in reverse direction.
- When operating the sewing machine, turn ON the power switch after properly setting the head on the table.
- For the first month after set-up, use the machine at a reduced sewing speed of 3,500 sti/min or less.
- Operate the pulley after the sewing machine has totally stopped.



CAUTION




In addition, be aware that the safety devices such as the "eye protection cover" and "finger guard" are sometimes omitted in the sketches, illustrations and figures included in the Instruction Manual for the explanation's sake. In the practical use, never remove those safety devices.

为了安全地使用缝纫机



由于缝制作业的具体情况，有时不得不靠近机器转动的零部件进行操作而有可能接触到转动零部件，因此实际操作机器的操作员和维修保养的维修人员，必须在事前仔细阅读 **有关安全的注意事项**，充分理解内容之后再进行操作。此 **有关安全的注意事项** 中记述的内容有的不是用户购买的商品规格的内容。

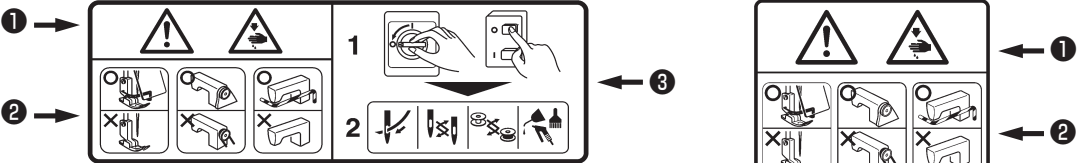



另外，为了能让用户充分地理解使用说明书以及产品的警报标签，特将警报表示分为如下种类。请充分了解这些内容，并遵守指示的要求。

(I) 危险等级的说明

 危険	操作或维修保养机器时，如果当事人、第 3 者操作错误或没有避免该情况，有发生死亡或造成重伤的危险。
 警告	操作或维修保养机器时，如果当事人、第 3 者操作错误或没有避免该情况，有发生死亡或造成重伤的潜在可能。
 注意	操作或维修保养机器时，如果当事人、第 3 者操作错误或没有避免该情况，有造成中轻伤的可能。

(II) 警告图标表示和指示标签的说明

警告图标表示		有接触转动部，造成负伤的危险。	警告图标表示		作业时拿缝纫机的话，有让手受伤的危险。
		有接触高电压部，造成触电的危险。			有卷入皮带，造成负伤的危险。
		有接触高温部，造成烫伤的危险。			触摸了纽扣传送器，有受伤的危险。
		如果直接目视激光的话，有伤害眼睛的危险。	指示标签		指示正确的转动方向。
		有头部接触到缝纫机的危险。			指示地线的连接。

警告标签					
	<p>① ・有发生中轻度伤害、重伤、死亡的危险。 ・触摸了活动部分的话，有发生负伤的危险。</p> <p>② ・应安装安全防护器，然后再进行缝制。 ・应安装安全护罩，然后再进行缝制。 ・应安装保护装置，然后再进行缝制。</p> <p>③ ・必须切断电源之后，再进行「穿线」、「换针」、「更换梭心」以及「加油、清扫」的操作。</p>				
触电危险标签	<table border="1"> <tr> <td></td> <td> <p>危険</p> <p>高電圧部分に触れて、大けがをすることがある。 電源を切って、5分以上たってからカバーをはずすこと。</p> </td> <td> <p>DANGER</p> <p>Hazardous voltage will cause injury. Turn off main switch and unplug power cord and wait at least 5 minutes before opening this cover.</p> </td> </tr> </table>			<p>危険</p> <p>高電圧部分に触れて、大けがをすることがある。 電源を切って、5分以上たってからカバーをはずすこと。</p>	<p>DANGER</p> <p>Hazardous voltage will cause injury. Turn off main switch and unplug power cord and wait at least 5 minutes before opening this cover.</p>
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有关安全的注意事项

事故：是指给与人身以及财产带来损害。

⚠危险

1. 需要打开电气箱时，为了防止触电事故，请关闭电源，经过 5 分钟以上的时间之后再打开电气箱盖。

⚠注意

基本注意事项

1. 使用之前，请您一定阅读使用说明书以及附属的所有说明资料。
另外，请您妥善保管本使用说明书，以便随时可以立即查阅。
2. 本注意事项中有部分内容可能不是您所购买的机器规格的内容。
3. 为了防止断针造成的事故，请戴上安全防护眼镜进行操作。
4. 使用心脏起搏器的人，请一定与专门医生咨询之后再使用。

安全装置、警告标签

1. 为了防止由于没有安装安全装置而造成的事故，操作本机器时，请确认安全装置是否正确地安装到规定位置之后再进行操作。
2. 为了防止人身事故，卸下了安全装置后，请一定再安装到原来的位置，并确认功能是否正常。
3. 为了防止人身事故，请把警告标签时常地粘贴到可以明显看到的机器上。如果脱落或发生污损，请立即更换成新的标签。

用途、改装

1. 为了防止人身事故，请不要将本机器使用于本来的用途和使用说明书规定的使用方法以外的用处。如果使用于规定用途以外时，本公司一概不负任何责任。
2. 为了防止人身事故，请不要改装机器。对于因改装而发生的事故，本公司一概不负任何责任。

教育培训

1. 为了防止由于不熟练而造成的事故，雇用单位应就有关本机器的操作和安全注意事项，对操作人员进行教育，而且只让具有专业知识和操作技能的操作人员使用本机器。同时，雇用单位一定事前编制操作人员的教育培训计划，并切实地实施。

必须关闭电源的事项

关闭电源：是指关闭电源开关之后，并且把电源插头从电源插座上拔下来。以下相同。

1. 为了防止人身事故，当确认了异常、故障后以及停电时，请立即关闭电源。
2. 为了防止因机器突然起动作造成的事故，在如下情况时，请一定关闭电源之后再进行操作。特别是使用离合马达时，关闭电源后，一定确认了缝纫机完全停止转动之后再进行操作。
 - 2-1. 例如，向机针、弯针、分线器等需要穿线的零件进行穿线或更换梭心时。
 - 2-2. 例如，更换或调整组成机器的所有零部件时。
 - 2-3. 例如，检查、修理、清扫机器时，或离开机器时。
3. 为了防止触电、漏电、火灾事故，拔电源插头时，一定要手持插头拔电线，而不能拉着电线拔。
4. 不使用缝纫机闲放时，一定要关闭电源。
5. 为了防止因电气零部件的损坏造成的事故，停电后请一定关闭电源。

在各使用阶段的注意事项

搬 运

1. 为了防止人身事故，抬起缝纫机移动时，请一定根据机器的重量采用确保安全的方法进行搬运。另外，有关机器重量，请确认使用说明书的说明。
2. 为了防止人身事故，抬起缝纫机移动时，请采取确保安全的措施防止翻倒、掉落。
3. 为了防止不可预想事故、掉落事故、机器损坏，请不要再包装已经开箱的机器进行搬运。

开 箱

1. 为了防止人身事故，开箱时请按照从上方开始的顺序进行开箱。木框包装时，请一定要小心不要被钉子扎破。请把钉子从木板上拔下来。
2. 为了防止人身事故，取出机器时，请一定首先确认机器的重心位置然后小心地取出。

安 装

(I) 机台、台脚

1. 为了防止人身事故，请一定使用纯正的机台、台脚。不得以使用非纯正的零件时，请一定使用可以充分承受机器重量、运转时的反作用力的机台、台脚。
2. 为了防止人身事故，在台脚上安装脚轮时，请使用具有充分强度的带锁定装置脚轮，操作机器时、维修保养、检查、修理时进行锁定不要机器晃动。

(II) 电缆、布线

1. 为了防止触电、漏电、火灾事故，使用电缆时请不要向电缆施加过大的力量。另外，在 V 形皮带等转动零部件附近布设电缆时，已经让电缆距离它们 30mm 以上。
2. 为了防止触电、漏电、火灾事故，请不要进行分岔布线。
3. 为了防止触电、漏电、火灾事故，请一定牢固地固定连接器。另外，拔连接器时，请一定手持连接器拔线。

(III) 接地

1. 为了防止因漏电、绝缘耐压而造成的事故，一定请具有电气专门知识的人安装电源插头。另外，请一定把电源插头连接到接地的电源插座上。
2. 为了防止因漏电造成的事故，请一定把地线接地。

(IV) 马达

1. 为了防止马达烧毁而造成的事故，请一定使用规定的额定马达（纯正品）。
2. 使用市场出售的离合马达时，因被卷入 V 形皮带而造成的事故，请一定选用安装有防止卷入功能的皮带护罩的离合马达。

操作前

1. 为了防止人身事故，接通电源之前，请一定确认连接器、电缆等确实没有损伤、脱落、松动。
2. 为了防止人身事故，请不要把手伸到活动的部位。另外，请确认皮带轮的转动方向是否与箭头标记一致。
3. 使用带脚轮的机台脚时，为了防止突然的起动造成的事故，请一定锁定脚轮，带有调节器时，请调节台脚把脚固定好。

操作中

1. 为了防止卷入而造成的事故，操作机器时，请注意不要让手指、头发、衣服靠近皮带轮、手动飞轮、马达等转动部位，也不要把手指伸到上面。
2. 为了防止人身事故，接通电源时或机器操作中，请不要把手指靠近机针，也不要把手指伸到挑线杆护罩里。
3. 缝纫机以高速在进行转动。为了防止弄伤手，操作中绝对不能让手靠近弯针、分线器、针杆、旋梭、布切刀等活动部位。另外，更换缝纫机机线时，请关闭电源，确认了缝纫机和马达均完全停止之后再行更换。
4. 为了防止人身事故，从机台上拆卸缝纫机时，或者返回安装到原来的位置时，请注意不要夹到手指。
5. 为了防止因突然的起动造成的事故，拆卸皮带护罩以及 V 形皮带时，请一定关闭电源，确认了缝纫机和马达均完全停止之后再行拆卸。
6. 使用伺服马达时，机器停止时马达不发出声音。为了防止因突然的起动造成的事故，请注意不要忘记关闭电源。
7. 为了防止因过热造成的火灾事故，使用时请不要堵住马达电源箱的冷却口。

加 油

1. 请使用 JUKI 纯正的机油和 JUKI 纯正的润滑脂向规定部位进行加油和涂抹润滑脂。
2. 为了防止炎症和脓肿，眼睛、身体上粘附了油时，请立即进行清洗。
3. 为了防止腹泻、呕吐，如果误饮了机油，请立即让医生治疗。



维修保养

1. 为了防止因不熟练而造成的事故，有关修理、调整，请一定让熟悉机器的维修保养技术人员按照使用说明书的说明进行修理和调整。另外，更换零部件时，请一定使用本公司的纯正零部件。对于不适当的修理和调整以及使用非纯正零部件造成的事故，本公司一概不负任何责任。
2. 为了防止因不熟练而造成的事故以及防止触电事故，请一定让具有电气专门知识的人或委托本公司、代理店的技术人员进行有关电气的修理和维修（包括布线）。
3. 为了防止因突然的起动造成的事故，修理和维修保养使用气缸等高压空气的机器时，请一定卸下空气供给源的管子，排放出残留的空气之后再行修理和维修保养。
4. 为了防止人身事故，修理调整和更换零部件后，请一定确认螺丝螺母等没有松动。
5. 机器的使用期间中，请一定定期地进行清扫。此时，为了防止因突然的起动而造成的事故，请一定关闭电源，确认了缝纫机和马达均完全停止之后再行清扫。
6. 进行维修保养、检查、修理时，请一定关闭电源，确认了缝纫机和马达均完全停止之后再行操作。（离合马达时，请注意关闭电源后马达由于惯性仍然回继续转动一定时间。）
7. 为了防止人身事故，经过修理调整，机器不能正常操作时，请立即停止操作，与本公司或代理店联系，委托有关技术人员修理。
8. 为了防止人身事故，保险丝熔断后，请一定切断电源，排除了保险丝熔断的原因之后，更换相同规格的新保险丝。
9. 为了防止马达的火灾事故，请定期地进行风扇通气口的清扫和配线四周的检查。

使用环境

1. 为了防止因误动作造成的事故，请在没有高频电焊机等强噪音源（电磁波）影响的环境下使用缝纫机。
2. 为了防止因误动作造成的事故，在超过额定电压 $\pm 10\%$ 的地方，请不要使用缝纫机。
3. 为了防止因误动作造成的事故，对于使用气缸等高压空气的装置，请确认了压力符合规定之后再行使用。
4. 为了安全地使用缝纫机，请一定在下列环境下进行使用。
动作时的周围温度 $5^{\circ}\text{C} \sim 35^{\circ}\text{C}$
动作时的相对湿度 $35\% \sim 85\%$
5. 为了防止因电气零部件的损坏和误动作造成的事故，从寒冷的环境急速地变到温暖的地方后容易产生结露现象，请等待水滴完全干燥之后再接通电源。
6. 为了防止因电气零部件的损坏和误动作造成的事故，打雷时为了安全，请停止操作，并拔下电源插头。
7. 有的电波状态下，可能会给予附近的电视机、收音机带来噪音。此时，请在稍稍离开缝纫机的地方使用电视机、收音机。
8. 为了确保作业环境，请遵守各国的有关法令。
需要对应噪音时，请穿戴有关法令规定的防音防护用具等。
9. 有关产品、包装的废弃，使用完的润滑油等的处理，请按照各国的法律法规进行适当的处理。

为了安全地使用 MF-7200D 系列的缝纫机的注意事项

 危险	<ol style="list-style-type: none">1. 为了防止因触电造成的事故，请不要在打开电源的状态下触摸马达电气箱的盖子、电气箱内的零件。
 注意	<ol style="list-style-type: none">1. 打开电源开关时和缝纫机运转中，请不要把手指放到机针下附近。2. 缝纫机运转中，请不要把手指、头发、衣服靠皮带轮和机针下附近，也不要将物体放到上面。3. 请不要在卸下皮带罩、手指防护罩和眼睛防护罩等安全装置的状态运转缝纫机。4. 检查、调整、清扫缝纫机，穿线，更换机针等时，请一定关闭电源，确认了踩踏起动踏板缝纫机也不动作后再进行操作。5. 为了确保安全，请在卸下电源地线的状态不要运转缝纫机。6. 插拔电源插头时，请一定事先关掉电源开关。7. 打雷时，为了确保安全，请停止作业，拔掉电源插头。8. 从寒冷的地方移动到温暖的地方后等时，有可能发生结露，所以请等水滴完全干燥后再打开电源。9. 进行保养、检查、修理作业时，请一定关闭电源，确认缝纫机和马达完全停止之后再进行操作。（使用离合马达时，请注意关闭电源后马达由于惯性仍然会继续转动一段时间。）10. 因为本产品属于精密机器，所以操作时请充分注意，不要把水、油溅到机器上面，也不要让机器掉落给与机器冲击。

运转缝纫机前的注意事项



注意

为了避免机械的错误动作或损伤，请确认如下项目内容。

- 使用缝纫机之前，请一定向加油口加入 JUKI 指定机油。
- 第一次使用缝纫机之前，请把缝纫机打扫干净。
- 请把运送中积的灰尘打扫干净。
- 请确认设定的电压是否正确。
- 请确认电源插头是否正确地插好。
- 电源规格不同的情况时，请绝对不要使用缝纫机。
- 缝纫机的转动方向从皮带轮侧看为顺时针方向转动。请注意不要让缝纫机倒转。
- 运转缝纫机时，请正确地设置到机台之后再打开电源开关。
- 最初的第 1 个月，请降低缝纫速度，在转速 3,500sti/min 以下使用。
- 待缝纫机确实停止之后再操作飞轮。缝纫机确实地停止之后，再转动皮带轮。



注意

另外，在使用说明书中为了突出说明的重点，有的地方省略显示了「眼睛防护罩」、「手指防护器」等安全装置，请了解。

但是实际使用时，请绝对不要卸下这些安全装置。

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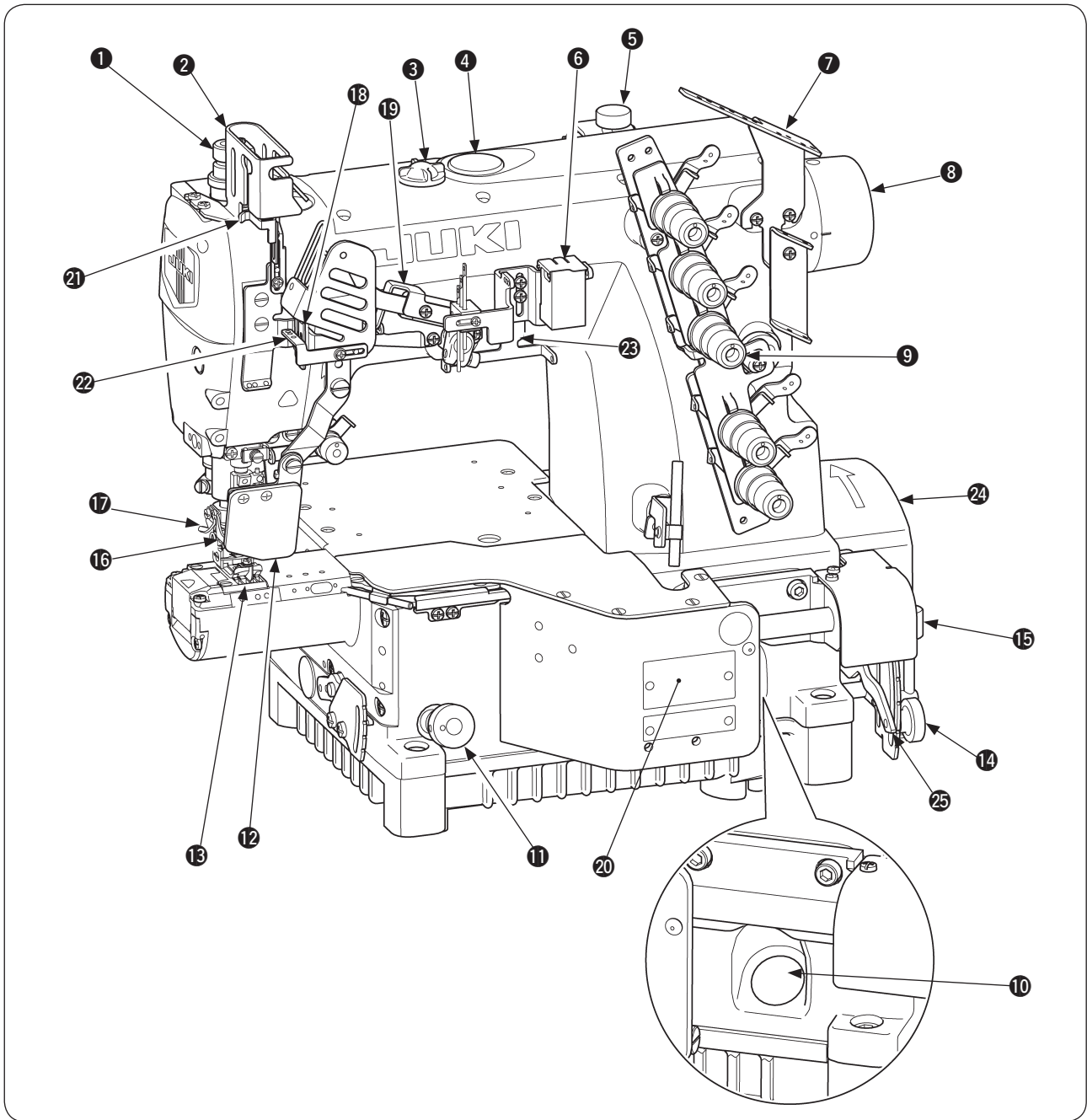
I . SPECIFICATIONS

Model name	Semi-dry head high-speed, small cylinder-bed coverstitch machine
Model	MF-7200D series
Stitch type	ISO standard 406, 407, 602, and 605
Example of application	Hemming and covering for knits and general knitted fabrics
Max. speed of stitch	Max. 4,000 sti/min (at the time of intermittent operation)
Needle gauge	3-needle ... 5.6 mm and 6.4 mm 2-needle ... 3.2 mm, 4.0 mm and 4.8 mm
Differential feed ratio	1 : 0.8 to 1 : 1.8 (stitch length : less than 3.2 mm) Micro-differential feed adjustment mechanism is provided. (Micro-adjustment)
Stitch length	1.4 mm to 3.2 mm (can be adjusted up to 4.2 mm)
Needle	UY128GAS #9S to #12S (standard #10S)
Needle bar stroke	31mm
Dimensions	(Height) 450 x (Width) 444 x (Length) 285
Weight	42 kg
Lift of presser foot	6 mm (needle gauge : 5.6 mm without top covering), and 5 mm (with top covering) Micro-lifter mechanism is provided.
Feed adjustment method	Main feed ... dial type stitch pitch adjustment method Differential feed ... lever adjustment method (micro-adjustment mechanism is provided.)
Looper mechanism	Spherical rod drive method
Lubricating system	Forced lubrication method by gear pump
Lubricating oil	JUKI MACHINE OIL 18
Oil reservoir capacity	Oil gauge lower line : 600 cc to upper line : 900 cc
Installation	Top mount type, Semi-submerged type
Noise	<ul style="list-style-type: none"> - Equivalent continuous emission sound pressure level (L_{pA}) at the workstation : A-weighted value of 80.5 dB; (Includes $K_{pA} = 2.5$ dB); according to ISO 10821- C.6.2 -ISO 11204 GR2 at 4,000 sti/min. - Sound power level (L_{WA}) ; A-weighted value of 86.0 dB; (Includes $K_{WA} = 2.5$ dB); according to ISO 10821- C.6.2 -ISO 3744 GR2 at 4,000 sti/min.

I. 规格

机种名称	半干式机头细筒型双面装饰 扁平缝缝纫机
型式	MF-7200D 系列
缝迹形式	ISO 规格 406、407、602、605
用途例	针织、编织产品的包边缝、包布缝
最高缝纫速度	最高缝纫速度 4,000 sti/min (间歇运转时)
针幅	3 根针 ----5.6mm、6.4mm 2 根针 ----3.2mm、4.0mm、4.8mm
差动送布比	1 : 0.8 ~ 1 : 1.8 (缝迹长度 3.2mm 以下) 装备有微量差动送布调节机构 (微调)
缝迹长度	1.4mm ~ 3.2mm (经调整可至 4.2mm)
使用机针	UY128GAS #9S ~ #12S (标准 #10S)
针杆行程	31mm
外观尺寸	高度 : 450 左右 : 444 前后 : 285
质量	42kg
压脚上升量	6mm (针幅 5.6mm 无上装饰)、5mm (有上装饰) 装备有微量压脚提升机构
送布调节方法	主送布 ----- 拨盘式缝迹间距调节方式 差动送布 ---- 拨杆调节方式 (装备有微调机构)
弯针机构	球面杆驱动方式
润滑方法	齿轮泵强制润滑加油方式
润滑油	JUKI MACHINE OIL 18
贮油量	油尺下线 600cc ~ 上线 900cc
安装方法	上部安装式、半落地式

II. CONFIGURATION OF THE MACHINE COMPONENTS / 各部分的名称



- | | | |
|--|-----------------------------------|---|
| ① Presser spring regulator | ⑩ Oil gauge | ⑲ Rocking thread take-up |
| ② Needle bar thread take-up cover | ⑪ Feed regulating knob | ⑳ Front cover |
| ③ Oil circulation inspection windows | ⑫ Eye guard cover | ㉑ Needle bar thread take-up thread receiver |
| ④ Oil hole cap | ⑬ Throat plate | ㉒ Rocking thread take-up thread guide |
| ⑤ Micro-lifter | ⑭ Differential lock nut | ㉓ Silicon container thread guide |
| ⑥ Needle thread silicon oil lubricating unit | ⑮ Micro-adjustment knob | ㉔ Belt cover |
| ⑦ Thread guide No. 1 | ⑯ Finger guard | ㉕ Differential feed regulating lever |
| ⑧ Upper pulley | ⑰ Thread trimming knife | |
| ⑨ Thread tension nut | ⑱ Rocking thread take-up receiver | |
| ① 压脚调节螺丝 | ⑩ 机油尺 | ⑲ 摆动挑线杆 |
| ② 针杆挑线杆护罩 | ⑪ 送布调节旋钮 | ⑳ 前护罩 |
| ③ 机油循环确认窗 | ⑫ 眼睛防护罩 | ㉑ 针杆挑线杆线座 |
| ④ 加油口盖 | ⑬ 针板 | ㉒ 摆动挑线导线器 |
| ⑤ 微量压脚提升 | ⑭ 差动锁定螺母 | ㉓ 冷却槽导线器 |
| ⑥ 机线冷却装置 | ⑮ 微调旋钮 | ㉔ 皮带防护罩 |
| ⑦ 第一导线器 | ⑯ 手指防护器 | ㉕ 差动调节拨杆 |
| ⑧ 上弯针 | ⑰ 切线刀刃 | |
| ⑨ 线张力器旋钮 | ⑱ 摆动挑线杆线座 | |

III. INSTALLATION / 安装方法



WARNING :

Do not insert the power plug of the motor into the receptacle until all works have been completed. There is a danger of injury by being caught in the machine.

注意：

所有的操作完了之前，请不要把马达的电源插头插到电源插座上。以防止被卷入机器里，造成负伤的危险。

1. Installing the machine head onto the table / 缝纫机机头往机台上的安装



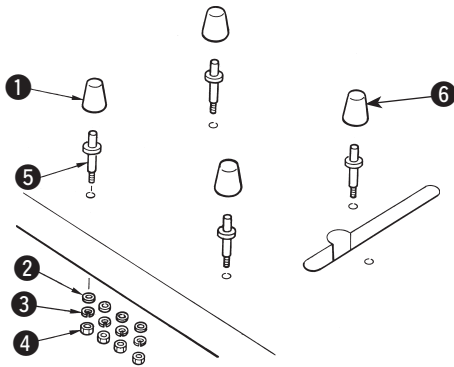
WARNING :

The weight of the sewing machine is more than 42 kg. Be sure to perform the work with two persons or more in case of unpacking, transportation or installation.

注意：

本缝纫机的质量有 42kg。因此，开箱、搬运、安装时，请务必 2 人以上来操作。

Top mount type / 上部安装式



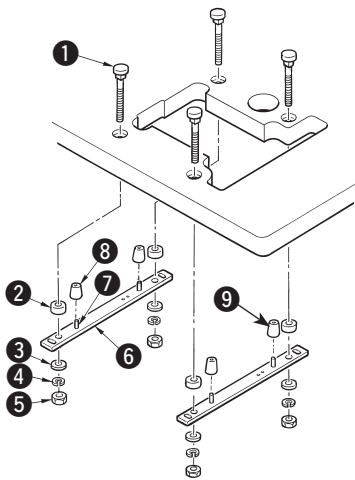
Attach the pins and the rubber cushions as shown in the illustration and properly install the sewing machine.

- ① Rubber cushion (Black) x 3
- ② Washer
- ③ Spring washer
- ④ Nut
- ⑤ Pin
- ⑥ Rubber cushion (Gray) x 1

如图所示安装销子和橡胶垫，然后正确地安装缝纫机。

- ① 橡胶座 (黑) x 3
- ② 垫片
- ③ 弹簧垫
- ④ 螺母
- ⑤ 销子
- ⑥ 橡胶座 (灰) x 1

Semi-submerged type / 半落地式



Attach the supporting board and the rubber seats as shown in the illustration and properly install the sewing machine.

- ① Bolt
- ② Spacer
- ③ Washer
- ④ Spring washer
- ⑤ Nut
- ⑥ Supporting board
- ⑦ Spring pin
- ⑧ Rubber cushion (Black) x 3
- ⑨ Rubber cushion (Gray) x 1

如图所示安装底板和橡胶座，然后正确地安装缝纫机。

- ① 螺栓
- ② 底座
- ③ 垫片
- ④ 弹簧垫
- ⑤ 螺母
- ⑥ 底板
- ⑦ 弹簧销
- ⑧ 橡胶座 (黑) x 3
- ⑨ 橡胶座 (灰) x 1

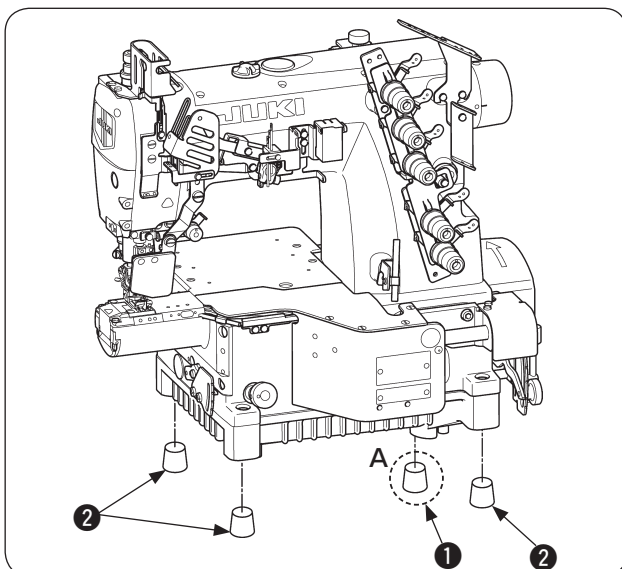
■ Installing the rubber cushion / 防震橡胶的安装

Install the gray dust-proof rubber to section A only.

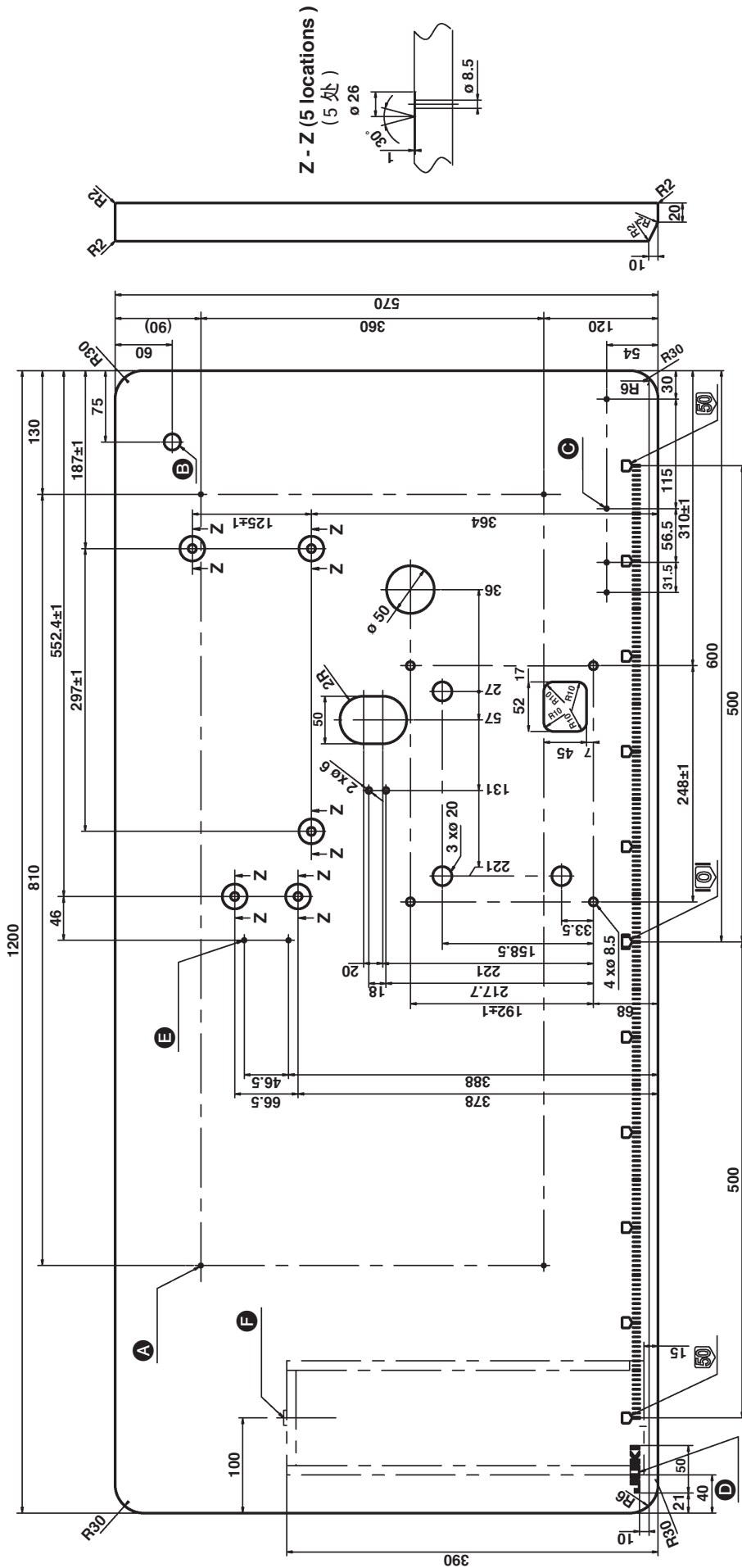
	Part No.	Part name	Q'ty
①	40072505	Dust-proof rubber (Gray)	1
②	13155403	Dust-proof rubber (Black)	3

请仅在 A 部安装灰色的防震橡胶。

	货号	品名	数量
①	40072505	防震橡胶 (灰色)	1
②	13155403	防震橡胶 (黑色)	3



DRAWING OF TABLE (TOP MOUNT TYPE) FOR TIMING-BELT DRIVE / 机台图纸 (上面安装式) 同步皮带驱动



- Ⓐ 4-φ 3.4 背面深度 20 (安装时应钻孔)
- Ⓑ 17 钻控
- Ⓒ 4-φ 3.4 背面深度 20 (安装时应钻孔)
- Ⓓ JUKI 商标图案
- Ⓔ 2-φ 3.4 背面深度 20 (安装时应钻孔)
- Ⓕ 抽屉止动器安装位置 (背面)

- Ⓐ 4-φ 3.4 on the bottom surface, depth 20
(Drill a hole at the time of set-up.)
- Ⓑ Drilled hole 17
- Ⓒ 4-φ 3.4 on the bottom surface, depth 20
(Drill a hole at the time of set-up.)
- Ⓓ JUKI logotype
- Ⓔ 2-φ 3.4 on the bottom surface, depth 20
(Drill a hole at the time of set-up.)
- Ⓕ Installing position of drawer stopper
(on the reverse side)

2. Selecting the motor pulley and the belt / 马达皮带轮、皮带的选定方法

Motor pulley and belt

Speed of stitch (sti/min)	MF-7200D			
	50Hz		60Hz	
	Pulley size	Belt size	Pulley size	Belt size
3500	ø80	M-38	ø65	M-37
4000	ø90	M-38	ø75	M-37

* The table shows the numbers when a 3-phase 2-pole 400 W clutch motor (1 / 2 HP) is used.

* The commercially-available motor pulley near to the counted value is designated since the outside diameter of the commercially-available motor pulley counts by 5 mm.



Use a motor pulley which is adaptable to this sewing machine. The sewing speed exceeds the max. sewing speed of this sewing machine and machine trouble will be caused unless a motor pulley which is adaptable to this sewing machine is used.

马达皮带轮和皮带

缝纫机的缝纫速度 (sti/min)	MF-7200D			
	50Hz		60Hz	
	马达皮带轮尺寸	皮带尺寸	马达皮带轮尺寸	皮带尺寸
3500	ø80	M-38	ø65	M-37
4000	ø90	M-38	ø75	M-37

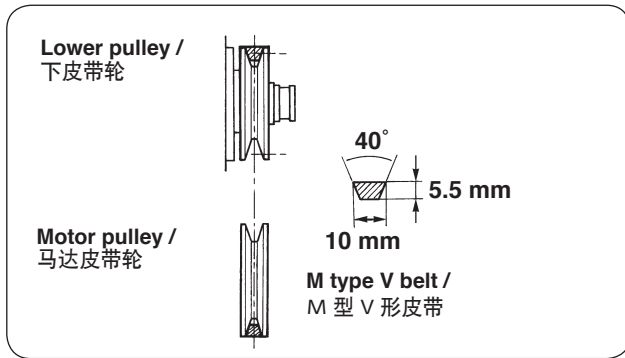
※ 此表是使用 3 相 2 极 400 瓦 (1/2HP) 的离合马达时的数值。

※ 市面销售的皮带轮外径为 5mm 单位，因此请指定接近计算值的市面销售的皮带轮。



请使用适合本产品的马达皮带轮。如果没有使用适合的皮带轮的话，超过缝纫机的最高转速，缝纫机就会发生故障。

3. Installing the motor / 马达的安装



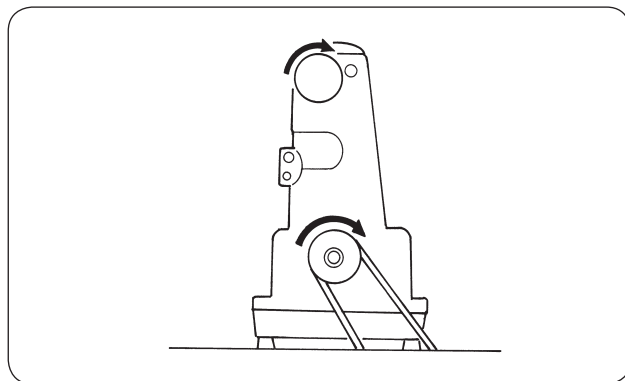
Use a clutch motor of 3-phase, 2-pole, 400 W (1/2HP).
Use the M type V belt.

- 1) The motor pulley shifts to the left-hand side when depressing the pedal. At this time, install the motor so that the centers of motor pulley and lower pulley align with each other.

* For the installing procedure of the motor pulley, refer to the Instruction Manual for motor.

请使用 3 相 2 极 400 瓦 (1/2HP) 的离合马达, 并使用 M 型 V 形皮带。

- 1) 踩了踏板之后, 马达皮带轮向左靠紧。此状态时, 请调整马达让马达皮带轮和下皮带轮的中心对齐。
※ 马达皮带轮的安装方法, 请参照马达使用说明书。



- 2) Install the motor so that the pulley rotates clockwise.



If the machine pulley rotates in the reverse direction, normal lubrication cannot be performed. As a result, machine trouble will be caused.

- 2) 安装马达时, 请让缝纫机皮带轮向顺时针方向转动。



缝纫机皮带轮反转的话, 就不能正常加油, 造成缝纫机故障。

4. Setting the belt / 皮带的挂法

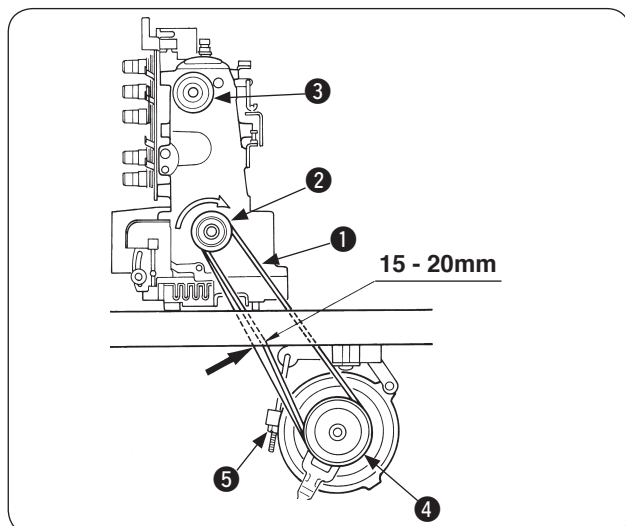


WARNING :

When replacing the belt, be sure to turn OFF the power to the motor and ascertain that the motor has totally stopped rotating before starting the work. There is a danger of injury since hands or clothes may be caught in the belt.

注意 :

更换皮带时, 请一定关掉马达的电源, 确认马达停止转动之后再进行更换作业。否则, 有发生手、衣服卷进缝纫机, 发生负伤的事故的危险。



- 1) Fit belt ① to lower pulley ②.
- 2) Turning upper pulley ③, set the other side of the belt to motor pulley ④.
- 3) Adjust the belt tension so that the belt sags 15 to 20 mm when the center of the belt is pressed with an approximate 10N (1.02 kgf) load.
- 4) Securely fix the belt with lock nut ⑤ when the belt has been set.



If the deflection of the belt is excessive when the sewing machine is operated, check again the belt tension.

- 1) 请把皮带 ① 挂到下皮带轮 ② 上。
- 2) 一边转动上皮带轮 ③, 一边把皮带的一头挂到马达皮带轮 ④ 上。
- 3) 用约 10N (1.02kgf) 的力量按压皮带的中央部后, 松弛量应为 15 ~ 20mm, 请按此标准进行调整。
- 4) 调整好皮带张力之后, 请把固定螺母 ⑤ 确实地拧紧固定。



运转缝纫机皮带摆动过大时, 请重新调整皮带张力。

5. Installing the belt cover / 皮带罩的安装

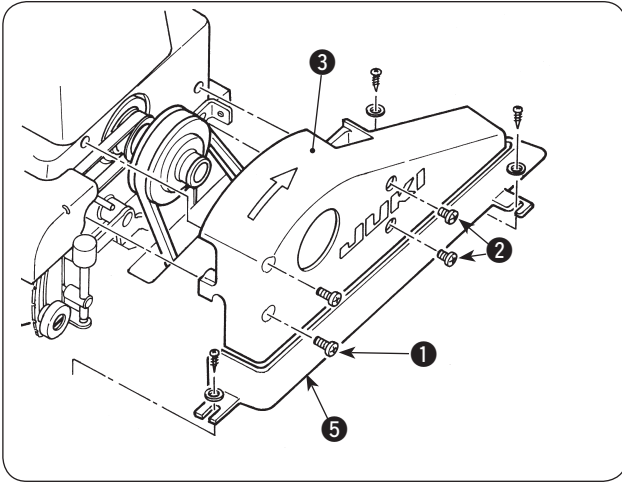


WARNING :

Be sure to install the belt cover. If it is not installed, there is a danger of injury since hands or clothes may be caught in the machine or a danger of damage of the machine since sewing products may be caught in the machine.

注意：

请一定安装皮带罩。如果没有安装，就有把手、衣服卷入机器内，或把缝制物卷入机器内的危险。



Install belt cover ③ as shown in the illustration.

① and ② are the fixing screws for belt cover ③.

* ② has a shorter shank than ① has.

* When the semi-submerged type table is used with the machine, cover ⑤ is not used.

* When the desktop type table is used, set up the machine head after having fixed cover ⑤.

请按照图示那样安装好皮带护罩 ③。

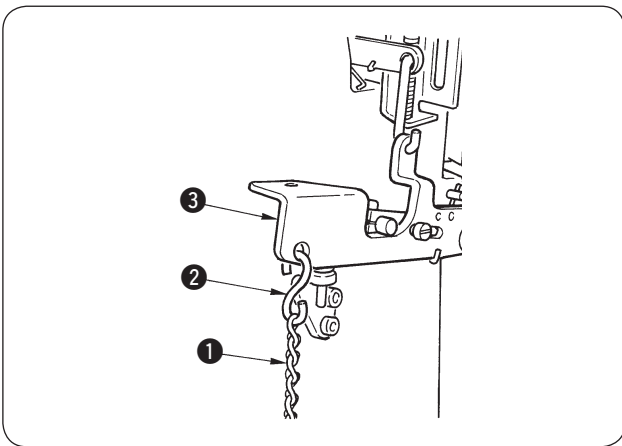
①、② 是皮带护罩 ③ 的固定螺丝。

※ 螺丝 ② 螺丝头下面的长度比螺丝 ① 螺丝头下面的长度短。

※ 使用半落地式的机台时，不能使用护罩 ⑤。

※ 使用台式机台时，请固定了护罩 ⑤ 之后，再装设机头。

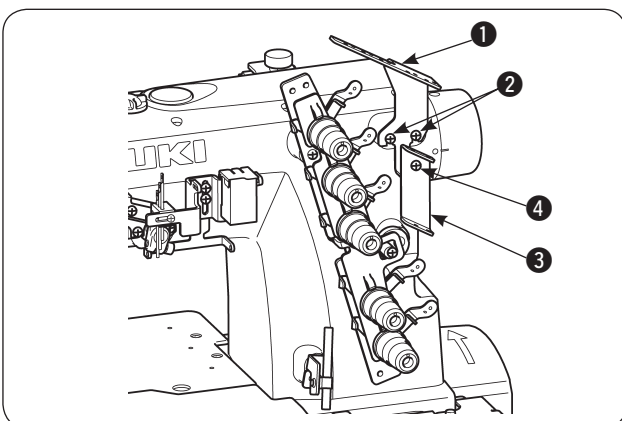
6. Installing the chain / 链条的安装



- 1) Hang hook ② of chain ① to presser bar lifting lever ③.
- 2) Hook the other side of the chain ① to the pedal.

- 1) 请把链条 ① 的钩 ② 挂到压脚提升拨杆 ③ 上。
- 2) 请把链条 ① 另一侧的钩挂到踏板上。

7. Installing the thread guide / 导线器的安装

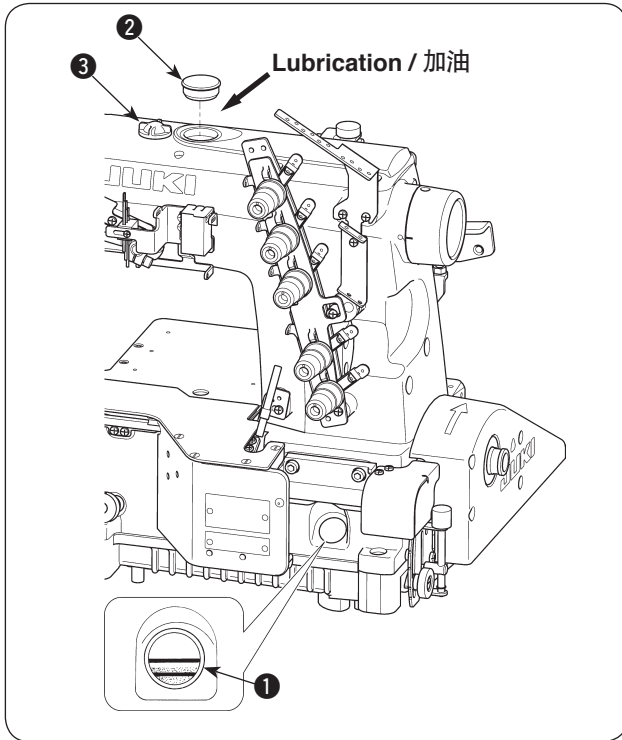


- 1) Install thread guide No. 1 ① supplied as accessories on the machine arm with screws ②.
- 2) Install thread guide ③ on thread guide No. 1 ① with screw ④.

- 1) 把附属的第 1 导线器 ① 用螺丝 ② 安装到机臂上。
- 2) 把导线器 ③ 用螺丝 ④ 安装到第 1 导线器 ①。

IV. LUBRICATION AND OILING / 关于加油、注油

1. Lubricating oil / 关于机油



<When using the sewing machine for the first time>
Lubricating oil has been taken out at the time of delivery. Be sure to supply lubricating oil before using the sewing machine for the first time.

• Oil used : JUKI MACHINE OIL 18



Do not use oil addition agent since deterioration of lubricating oil or machine trouble will be caused.

Remove oil hole cap ② on which "OIL" is indicated and fill the oil reservoir with lubricating oil up to the level between the upper and lower engraved marker lines.

<Checking before using the sewing machine>

- 1) Check oil gauge ① and make sure that lubricating oil level is between the upper and lower two lines. When lubricating oil level lowers below the lower line, supply lubricating oil.
- 2) Make sure that lubricating oil comes out from the nozzle of oil circulation identification window ③ when rotating the sewing machine. When lubricating oil does not come out, perform "Inspecting and replacing the oil filter". (See page 28.)

〈初次使用缝纫机时〉

出货时，机油均被排放。因此初次使用缝纫机之前，请一定加入机油。

· 使用机油：JUKI MACHINE OIL 18



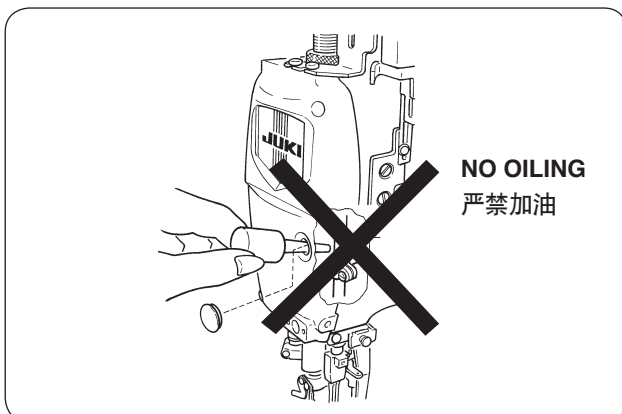
机油添加剂会造成机油的劣化或造成缝纫机的故障，因此请不要使用。

加油时，请卸下标有「OIL」的加油口盖子 ②，把机油加到油尺 ① 的上下刻线之间。

〈使用缝纫机前的检查〉

- 1) 请用检查油尺 ①，确认油量是否在上下 2 条刻线之间。如果油量比下线还低时，请补加机油。
- 2) 转动缝纫机，请从机油循环确认窗 ③ 确认是否机油从喷嘴喷出来。如果没有机油喷出时，请进行「滤油器的检查、更换」(参照 28 页)。

2. Oiling / 关于加油



The mechanisms inside the frame such as the needle bar, presser lift and spreader components are lubricated with grease. Never add oil inside the frame.



If inside of the frame is oiled, the grease will be expelled, resulting in mechanical failure.

针杆、压脚提升以及分布器等有关零部件全部采用润滑脂润滑结构。因此，请不要向里面加油。



加油之后，会使润滑脂流失，因而造成机器故障。

3. Replacing the lubricating oil / 缝纫机油的更换

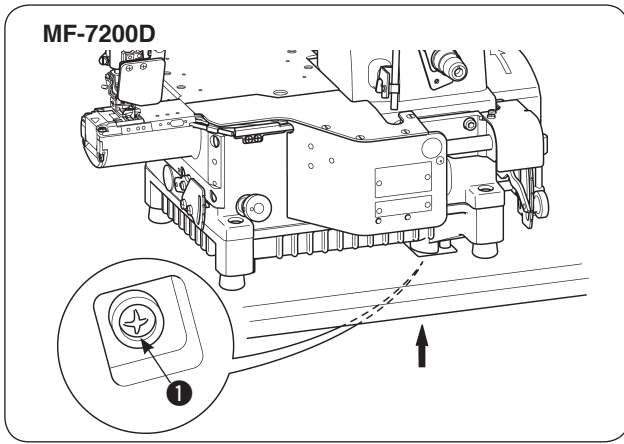


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动能造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



In case of the new sewing machine, replace the lubricating oil (JUKI MACHINE OIL 18) with new one after using it for approximately one month. Then replace the lubricating oil every six months.

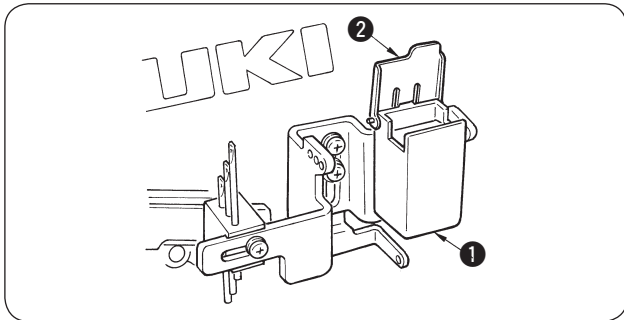
- 1) Set a container to receive the lubricating oil under drain screw ①.
- 2) Remove drain screw ①. The lubrication oil is drained.
- 3) After the drain, wipe out the oil and attach the drain screw ①.

新缝纫机时，约使用1个月之后，请更换机油（JUKI MACHINE OIL 18）。

以后，请每6个月更换1次机油。

- 1) 请把接油容器安装到排油螺丝 ① 的下面。
- 2) 请卸下排油螺丝 ①。让机油排放出来。
- 3) 排放后，请擦干净机油，然后安装上排油螺丝 ①。

4. Silicon oil lubricating unit / 线冷却装置



This sewing machine is provided with the silicon oil lubricating unit as standard. In case of sewing at a high speed, or using chemical thread or chemical fabric, use the silicon oil lubricating unit to prevent thread breakage or stitch skipping.

Oil used is silicon oil (dimethyl silicon).

Open cover ② of silicon oil reservoir ①. Check to be sure that silicon oil reservoir for the needle thread is filled with silicon oil.

If silicon oil is insufficient there, supply it (dimethyl silicon).



When silicon oil adhered to the components other than the silicon oil lubricating unit, be sure to wipe it out. If the components to which silicon oil adhered are kept without wiping out the oil, sewing machine trouble will be caused.

本产品标准装备有线冷却装置。高速缝制以及使用化纤线、化纤布料时，为防止断线、跳线，请使用线冷却装置。使用的油是硅油（二甲基硅）。

请打开线冷却槽 ① 的盖子 ②，确认缝纫机线上、线冷却装置里是否有硅油。

如果油不够时，请补加硅油（二甲基硅）。



硅油如果沾附到线冷却装置以外的零件上，请一定擦干净。如果不擦干净，就会使缝纫机发生故障。

V. OPERATION / 缝纫机的使用方法

1. Needle / 关于缝纫机针

Japan No.	9	10	11	12	14
German No.	65	70	75	80	90

日本针号	9	10	11	12	14
德国针号	65	70	75	80	90

The needle used for this sewing machine is UY128GAS. For the needle No., select a proper needle in accordance with the sewing conditions.

本产品使用的缝纫机针是 UY128GAS。

机针的针号应根据缝制条件来适当地选择。

2. Attaching the needle / 机针的安装方法

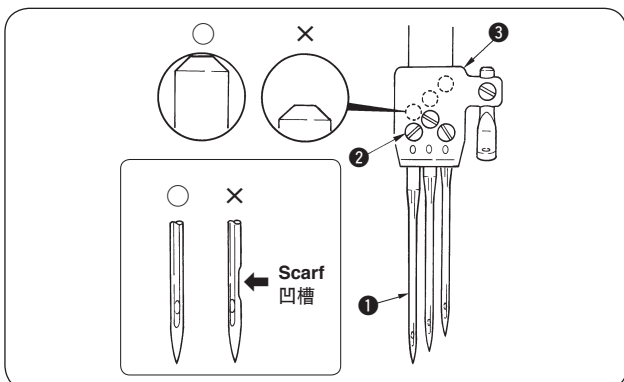


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



- 1) Loosen setscrew ② of needle ① with a screwdriver.
- 2) Hold the new needle with indented part facing to the rear and insert it into the hole in needle clamp ③ until the end of hole is reached.
- 3) Securely tighten setscrew ② of the needle.

- 1) 用螺丝刀拧松机针 ① 的固定螺丝 ②。
- 2) 把新缝纫机针的凹部朝向里侧，然后深深地插进针座 ③ 的孔里。
- 3) 然后请拧紧机针固定螺丝 ②。

3. Threading the machine head / 穿线方法



WARNING :

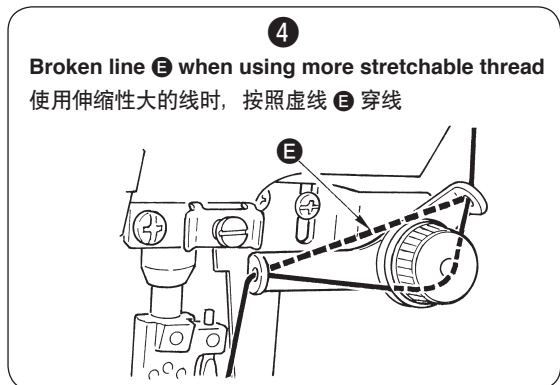
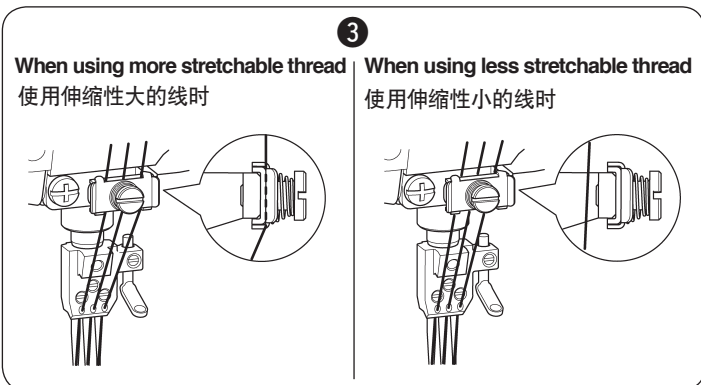
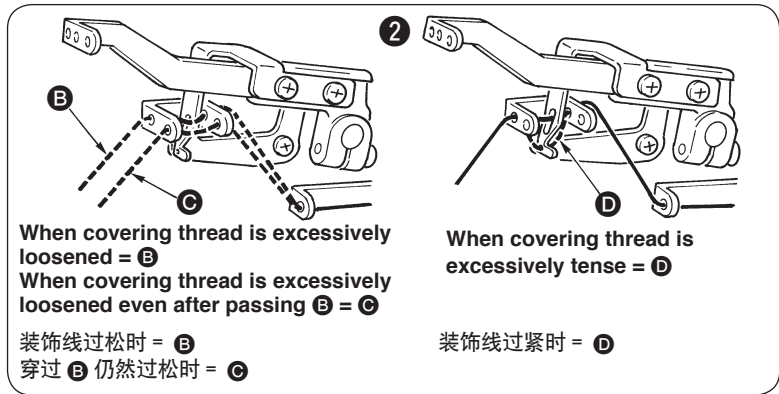
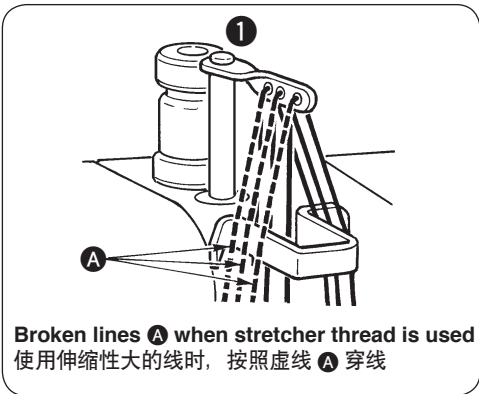
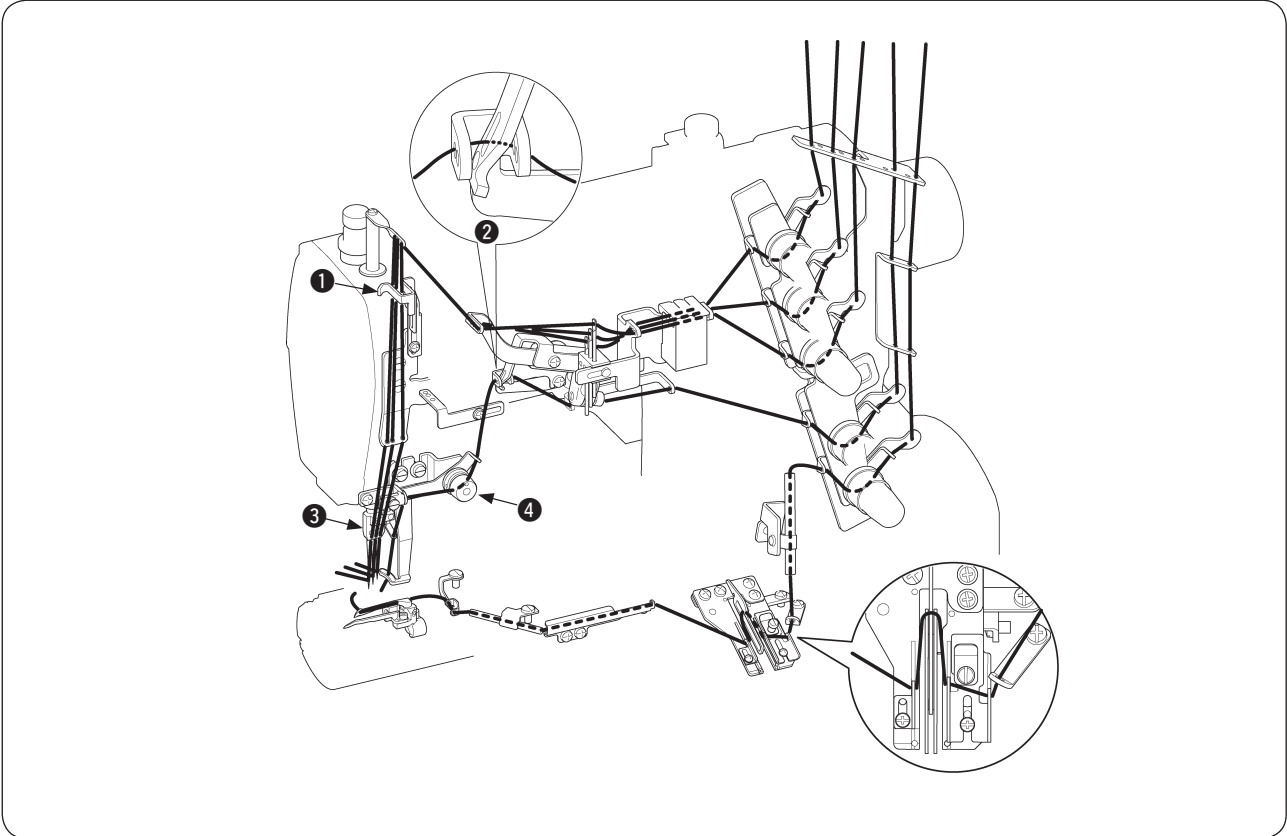
To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest. If threading is wrong, stitch skipping, thread breakage, needle breakage or irregular stitches will be caused. So, be careful.

注意：

为了防止突然的起动造成人身事故，请关掉电源，确认马达确实停止后再进行操作。穿线方法不正确，会造成跳针、断线、断针、张力不好等故障。

(1) Standard threading / 标准的穿线方法

Thread the machine head according to the following threading illustrations. / 请按照图示的要领进行穿线。



4. Adjusting the stitch length / 缝迹长度的调节

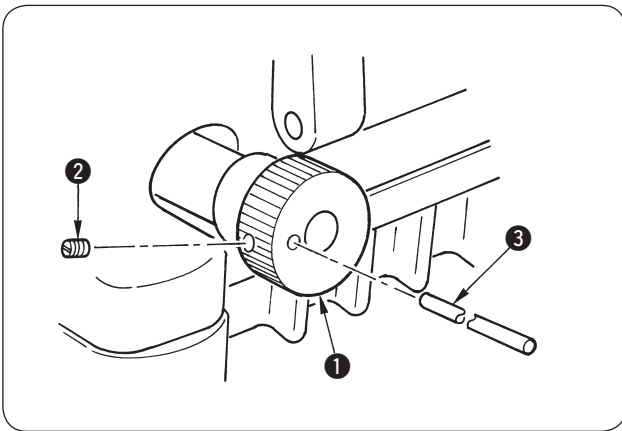


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



The stitch length can be infinitely adjusted from 0.8 mm to 3.2 mm.

* The actually sewn stitch length varies in accordance with kind and thickness of the materials.

[How to change the stitch length]

Turn clockwise feed regulating knob ① to increase the stitch length.

Turn it counterclockwise to decrease the stitch length.

• When making the stitch length 3.2 mm or more

Loosen screw ② and turn clockwise feed regulating knob ① to regulate the stitch length.

Push pin ③ until it goes to the end, and fix it with screw ②.

Use the machine within the range where feed dogs or feed dog and throat plate do not come in contact with each other.

缝迹长度可以在 0.8mm 到 3.2mm 的范围任意地调整。

※ 实际缝制后的缝迹长度，随布料的种类和厚度而有所不同。

[改变缝迹长度的方法]

向右转动送布调节旋钮 ①，缝迹变大。向左转动，则缝迹变小。

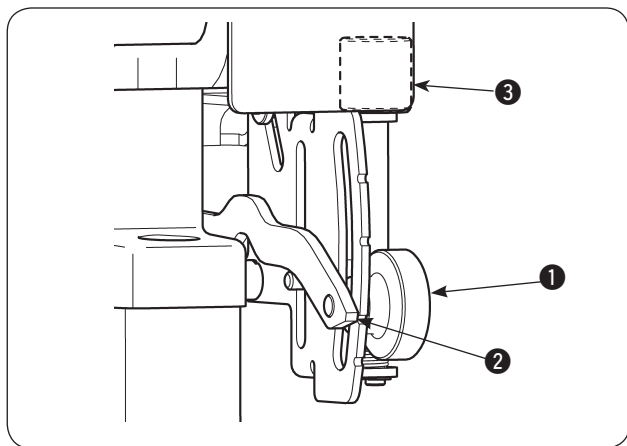
· 把缝迹长度设定到 3.2mm 以上时

拧松螺丝 ②，向右转动送布调节旋钮 ①，调节缝迹长度。

最后，把销子 ③ 插到深处，再用螺丝 ② 拧紧固定。

请在送布牙与送布牙，送布牙与针板不相接触的范围进行使用。

5. Adjusting the differential feed ratio / 差动比的调节



Loosen differential lock nut ① and move lever ② up to increase the differential feed ratio. Then the sewn material is gathered. Move lever ② down to decrease the differential feed ratio. Then the sewn material is stretched. Fine adjustment of the differential feed ratio can be performed with micro-adjustment knob ③.



There is a case where feed dogs or feed dog and throat plate come in contact with each other by the aforementioned adjustment according to the relation between the stitch length and the differential feed ratio. So, be very careful.

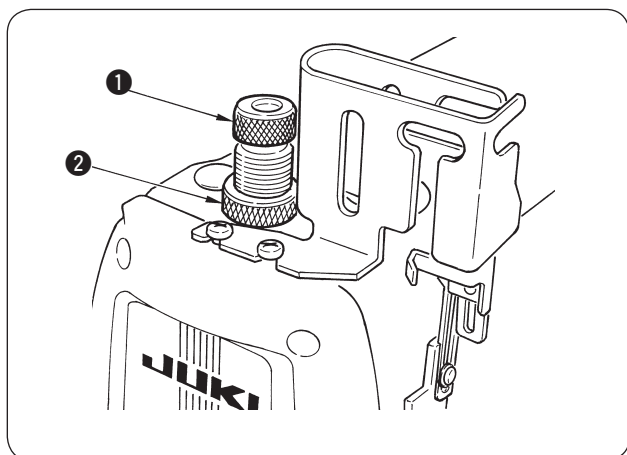
拧松差动锁定螺母 ①，提升拨杆 ② 之后，差动比变大，缝制的布料会皱缩。

下降拨杆 ② 之后，差动比变小，缝制的布料会伸长。可以用微调旋钮 ③ 进行差动比的微调。



调整缝迹长度和差动比的关系时，送布牙和送布牙相碰，或送布牙与针板相碰，有可能造成零部件损坏，请充分注意。

6. Adjusting the presser foot pressure / 压脚压力的调节



Decrease the presser foot pressure as low as possible to such an extent that stitches are stabilized.

To adjust the pressure, loosen lock nut ② of presser spring regulator ① and turn presser spring regulator ①. After the adjustment, tighten lock nut ②.

Turning it clockwise to increase the pressure.

Turning it counterclockwise to decrease the pressure.

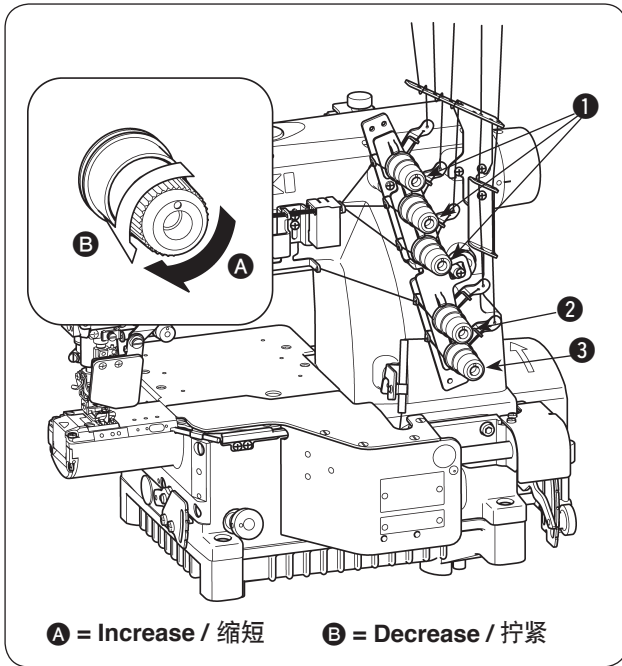
请把压脚压力在缝迹稳定的范围内尽量调弱。

调节压力时，拧松压脚调节螺丝 ① 的锁定螺母 ②，转动压脚调节螺丝 ①。调节后，请拧紧锁定螺母 ②。

向右转动之后，压力变强。

向左转动之后，压力变弱。

7. Adjusting the thread tension / 线张力的调节



Adjust the thread tension with the following thread tension nuts.

- ① Needle thread tension nut
- ② Top covering thread tension nut
- ③ Looper thread tension nut

Turn clockwise to increase the thread tension.

Turn counterclockwise to decrease the thread tension.

调节线张力时请用以下零件进行调节。

- ① 线张力器旋钮
- ② 上装饰线张力器旋钮
- ③ 弯针线张力器旋钮

向右转动之后，紧线力变强。

向左转动之后，紧线力变弱。

VI. ADJUSTING THE SEWING MACHINE / 缝纫机的调整

1. Adjusting the silicon container thread guide / 冷却器导线器的调整

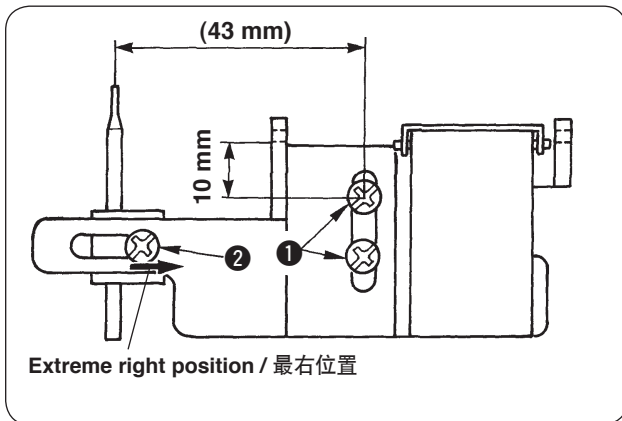


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

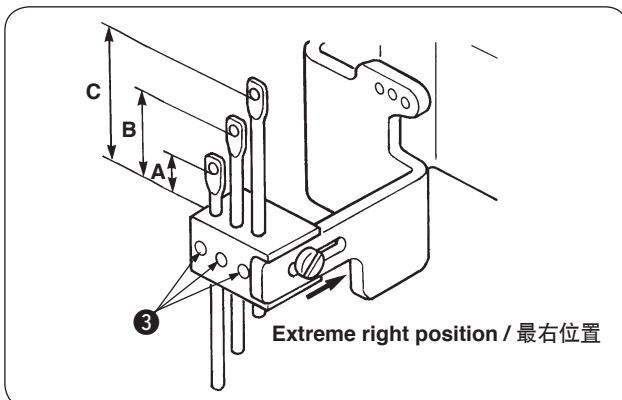
注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



- 1) Loosen setscrews ① and adjust so that the distance from the center of the setscrew on the upper side to the bottom end of the thread hole is 10 mm. Then tighten setscrews ① to fix the thread guide.
- 2) Loosen setscrew ② and adjust the position from the center of screws ① to the center of needle thread guide rod to the extreme right position (43 mm). Then tighten screw ② to fix the thread guide rod.

- 1) 拧松固定螺丝 ①，把上侧固定螺丝中心到线孔中心的距离调整为 10mm，然后拧紧固定螺丝 ①。
- 2) 拧松固定螺丝 ②，把螺丝 ① 的中心到机线导线杆中心的距离调节到最右位置（43mm），然后用螺丝 ② 固定。



- 3) Loosen setscrews ③ and adjust so that the heights of the respective needle thread guide rods are the dimensions as shown in the illustration. Then tighten screws ③ to fix the thread guide rods.
- 3) 拧松固定螺丝 ③，把各导线杆高度调整为图示的尺寸，然后用固定螺丝 ③ 进行固定。

	A	B	C
Adjustment value / 调整值	13mm	16mm	19mm

2. Adjusting the needle bar thread take-up thread receiver / 针杆挑线器线座的调整

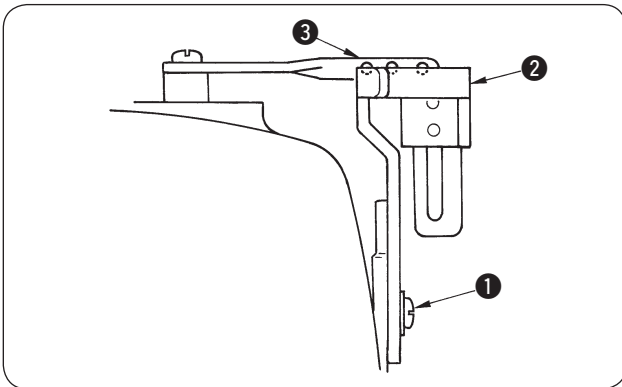


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



Loosen setscrew ① and adjust so that the bottom end to the center of the thread hole of needle bar thread take-up ③ aligns with the top end of needle bar thread take-up thread receiver ② when the needle bar is in its lowest position. Then tighten screw ① to fix the needle bar thread take-up thread receiver.

拧松固定螺丝 ①，让针杆到最下点，把针杆挑线杆 ③ 的线孔下端到中心的距离和到针杆挑线杆线座 ② 上端调整成一样，然后拧紧固定螺丝 ①。

3. Adjusting the rocking thread take-up / 摆动挑线杆的调整

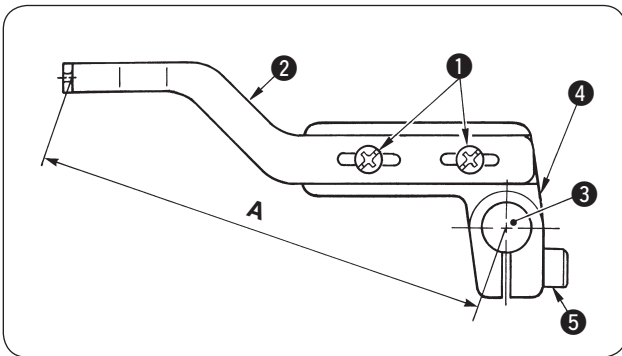


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



- 1) Loosen setscrews ①, move rocking thread take-up ② to the right or left and adjust so that the distance from the thread hole to the center of rocking thread take-up shaft ③ is dimension A as shown in the illustration. Retighten screws ① to fix the rocking thread take-up.
- 2) Adjust so that rocking thread take-up base ④ is level when the rocking thread take-up is in its lowest position. Retighten screw ⑤ to fix the rocking thread take-up base.

1) 拧松固定螺丝 ①，左右移动摆动挑线杆 ②，如图所示把从线孔到摆动挑线杆轴 ③ 的中心调整为 A 尺寸，然后固定螺丝 ①。

2) 摆动挑线杆在最下点时，把摆动挑线杆座 ④ 调整为水平，然后用螺丝 ⑤ 进行固定。

Adjustment value / 调整值	A
	90mm

4. Adjusting the rocking thread take-up thread receiver / 摆动挑线杆线座的调整

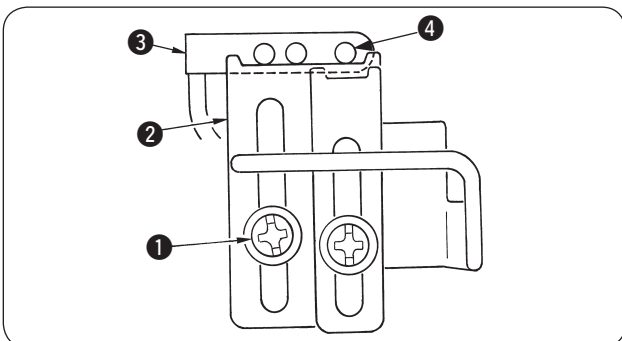


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



Adjust so that the top end of rocking thread take-up thread receiver ② aligns with the bottom end of thread hole ④ of rocking thread take-up ③ when rocking thread take-up ③ is in its lowest position, and fix it with screw ①.

摆动挑线杆 ③ 在最下点时，把摆动挑线杆线座 ② 的上端对准摆动挑线杆 ③ 的线孔 ④ 下端，然后用螺丝 ① 固定。

5. Adjusting the spreader thread guide / 分布导线器的调整

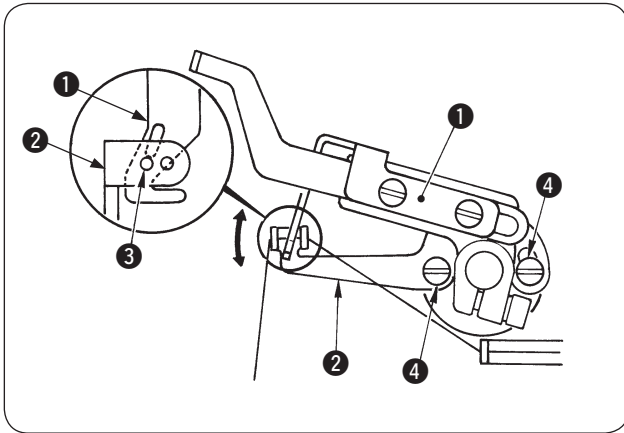


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



Adjust so that the top end of thread guide thread path (rear) ③ of spreader thread guide ② aligns with the bottom surface of slot of spreader thread take-up ① when spreader thread take-up ① is in its highest position. Then tighten screw ④ to fix the spreader thread guide.

分布挑线杆 ① 在最上点时，分布导线器 ② 的导线线道(里侧) ③ 的上端调整成与分布挑线杆 ① 的长孔下端一致，然后拧紧固定螺丝 ④。

6. Adjusting the looper thread cam thread guide and the looper thread cam / 底线凸轮导线器的调整

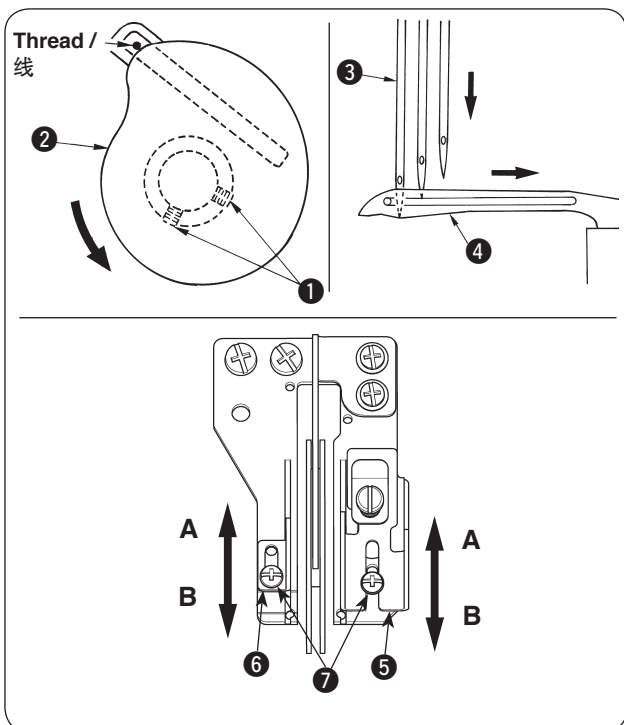


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



[Adjusting the looper thread cam]

Adjust so that thread comes off from the highest place of looper thread cam ② when needles come down and the top end of left needle ③ aligns with the bottom surface of looper ④. Then tighten screws ① to fix the looper thread cam.

[底线凸轮导线器的调整]

机针下降，在左针 ③ 的尖端与弯针 ④ 下面一致时进行调整，让机线从底线凸轮 ② 最高处脱离，然后拧紧固定螺丝 ①。

[Adjusting the looper thread cam thread guide]

When the thread drawing amount is desired to be decreased in case of 2-needle machine or the like, loosen screws ⑦, move upward thread guides ⑤ and ⑥ and tighten screws ⑦ to fix them.

A = Decrease

B = Increase

[底线凸轮的调整]

想让 2 根机针的拉线量变少时，请拧松螺丝 ⑦，向上方移动导线器 ⑤、⑥，然后拧紧固定螺丝 ⑦。

A = 少

B = 多

7. Adjusting the looper thread winding prevention plate / 带绕底线的防止板的调整

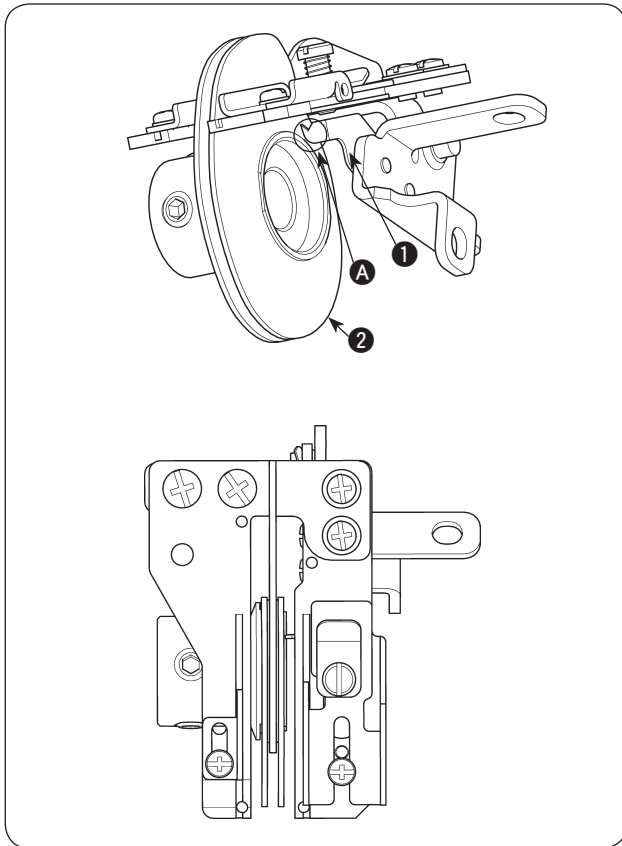


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



Adjust so that a clearance of approximately 0 to 0.3 mm is provided between the top end of section **A** of looper thread winding prevention plate **1** and the end face of looper thread cam **2**.

请把绕底线防止板 **1** 的 **A** 部前端和底线凸轮 **2** 的端面之间的间隙调整为 0 ~ 0.3mm 左右。

8. Adjusting the looper / 弯针的调整方法

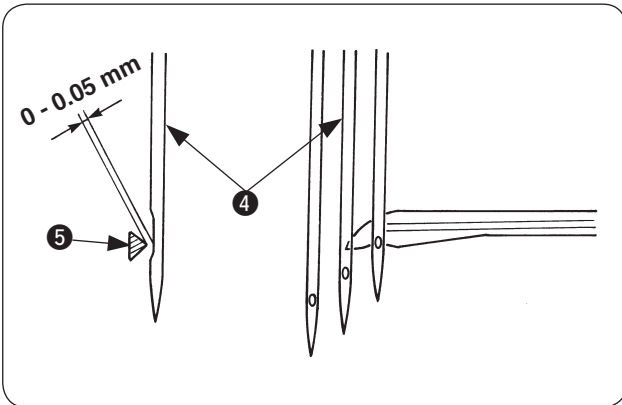
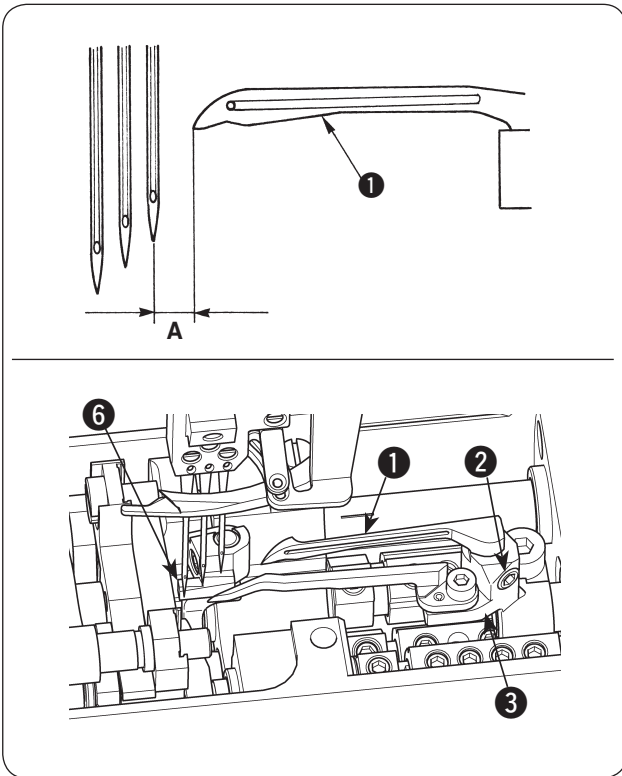


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



[Lateral position]

The relation between clearance **A** between looper **1** and the center of right-hand needle and the needle gauge is as shown in the table.

Unit : mm

2-needle		3-needle	
Needle gauge	Return amount A	Needle gauge	Return amount A
3.2	4.3		
4.0	3.9		
4.8	3.5		
5.6	3.1	5.6	3.1
6.4	2.7	6.4	2.7

Loosen clamp screw **2** and laterally adjust looper holder **3** in accordance with the table.

[Longitudinal position]

Adjust so that the clearance between blade point **5** of the looper and medium needle **4** is 0 to 0.05 mm when the top end of the looper comes from the extreme right position to the center of the medium needle. After the adjustment, tighten clamp screw **2** to fix the looper.

* The blade point of the looper comes in contact with the right-hand needle when rear needle guard **6** does not work. So, be careful.

[左右位置]

弯针 **1** 和右针中心的间隙 **A** (弯针倒回量) 和针幅的关系如下表所示。

单位：mm

2 针		3 针	
针幅	倒回量 A	针幅	倒回量 A
3.2	4.3		
4.0	3.9		
4.8	3.5		
5.6	3.1	5.6	3.1
6.4	2.7	6.4	2.7

请拧松螺丝 **2**，根据表中的数值，左右移动调整弯针支撑曲柄 **3**。

[前后位置]

弯针前端从最右点来到中针中心后，请把弯针尖 **5** 和中针 **4** 的间隙调整为 0 ~ 0.05mm。

调整后，请拧紧固定螺丝 **2**。

※ 请注意后针座 **6** 不起作用时，弯针和右针相接触。

9. Adjusting the height of the needle / 机针高度的调整

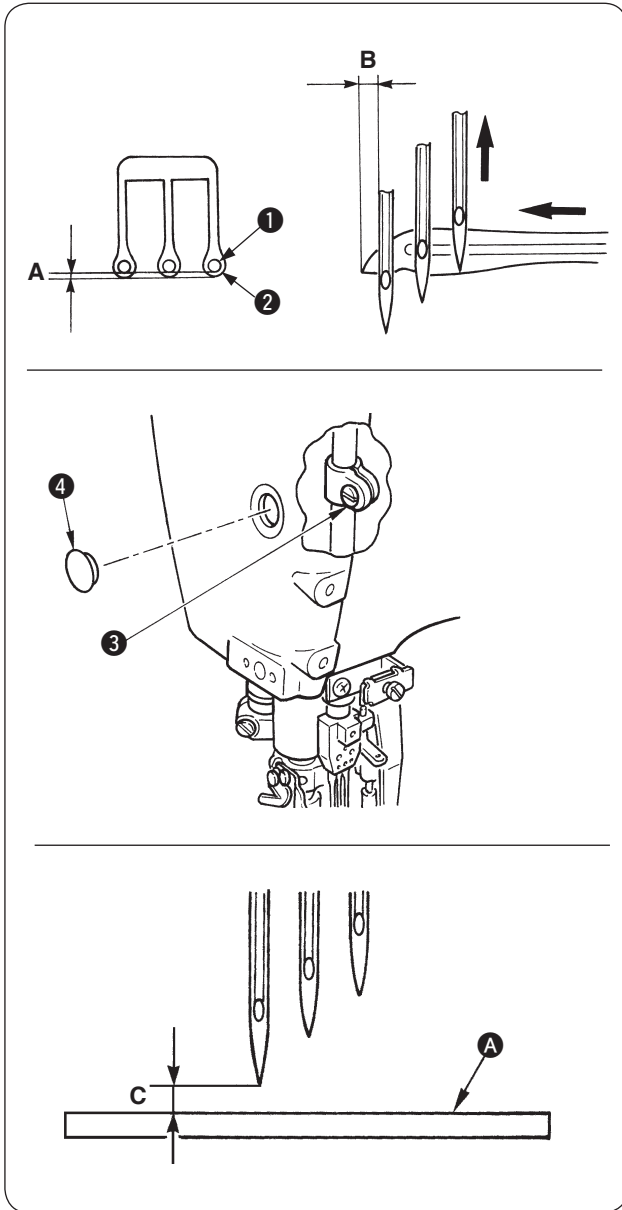


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



- 1) Equally adjust clearance **A** between needles **①** and needle holes **②** in the throat plate.
- 2) Adjust the height of the needle bar so that the top end of the needle hole of left-hand needle aligns with the bottom end section of the looper when the looper travels to the extreme right end and top end **B** of the looper protrudes by approximately 1.1 mm from the left end of the left-hand needle, remove the rubber cap **④** in the face plate, and tighten needle bar bracket setscrew **③** to fix the needle bar.

Reference : Height from the top surface of the throat plate **A** to the top end of left-hand needle, **C** when the needle is in the higher dead point is as shown in the table.

Unit : mm

2-needle		3-needle	
Needle gauge	Height of left-hand needle, C	Needle gauge	Height of left-hand needle, C
3.2	8.9		
4.0	8.6		
4.8	8.1		
5.6	7.8	5.6	7.8
6.4	7.3	6.4	7.3

- 1) 请把机针 **①** 和针板的针孔 **②** 的间隙 **A** 调整为均等。
- 2) 弯针从最右点向左移动，弯针前端 **B** 约突出左针的左端 1.1mm 后，调整针杆高度让左针的针孔上端和弯针下端部对齐，然后卸下面板的橡胶盖 **④**，用针杆套固定螺丝 **③** 拧紧固定。

参考：机针在最上位置时，针板上面 **A** 到左针前端的高度 **C** 如下表所示。

单位：mm

2 针		3 针	
针幅	左针高度 C	针幅	左针高度 C
3.2	8.9		
4.0	8.6		
4.8	8.1		
5.6	7.8	5.6	7.8
6.4	7.3	6.4	7.3

10. Adjusting the rear needle guard / 后针座的调整

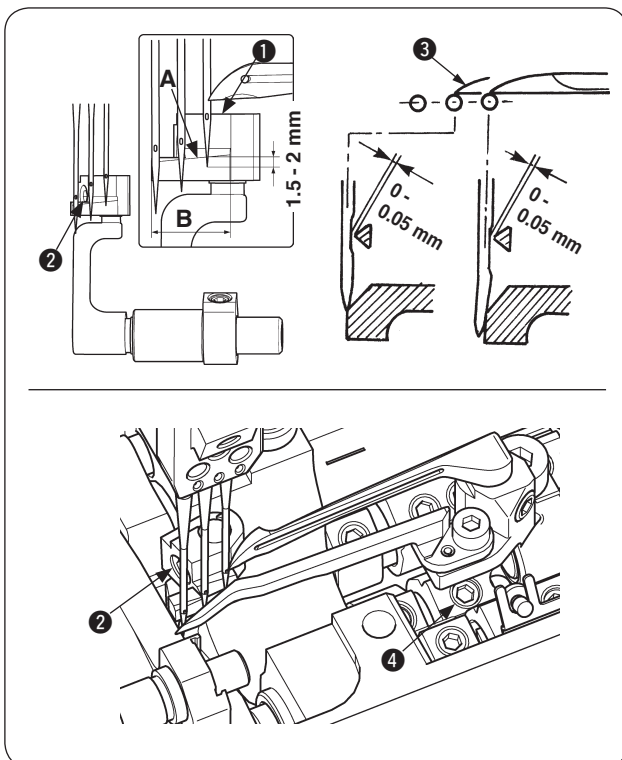


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



Adjust the lateral position of rear needle guard ① so that it receives the needle within the range of B when the needle is in its lowest position.

- 1) Adjust the height with setscrew ② so that the distance from edge line A of rear needle guard ① to the top end of right-hand needle is 1.5 to 2 mm when the top end ③ of the looper comes from the extreme right end to the center of right-hand needle.
- 2) Make rear needle guard ① slightly come in contact with the right-hand needle so that the clearance between right-hand needle and top end ③ of the looper is 0 to 0.05 mm when top end ③ of the looper comes from the extreme right end to the center of right-hand needle.

In addition, make rear needle guard ① slightly come in contact with the medium needle so that the clearance between the medium needle and top end ③ of the looper keeps 0 to 0.05 mm when top end ③ of the looper comes to the center of medium needle.

Perform the adjustment with setscrews ② and ④.

机针在最下点时，后针座 ① 的左右位置在 B 的范围内进行调节以准确落针。

- 1) 弯针前端 ③ 从最右点来到右针中心后，用固定螺丝 ② 把后针座 ① 的棱线 A 和弯针前端的高度调整为 1.5mm ~ 2mm。
- 2) 弯针前端 ③ 从最右位置来到右针中心后，请让后针座 ① 轻轻接触，把右针和弯针前端 ③ 的间隙调整为 0 ~ 0.05mm。另外，弯针前端 ③ 来到中针中心后，请让后针座 ① 轻轻接触，把中针和弯针前端 ③ 的间隙调整为 0 ~ 0.05mm。调节时，请用固定螺丝 ②、④ 进行调节。

11. Relation between the rocking thread take-up timing and the needle thread loop / 摆动挑线杆的同步和线环的关系

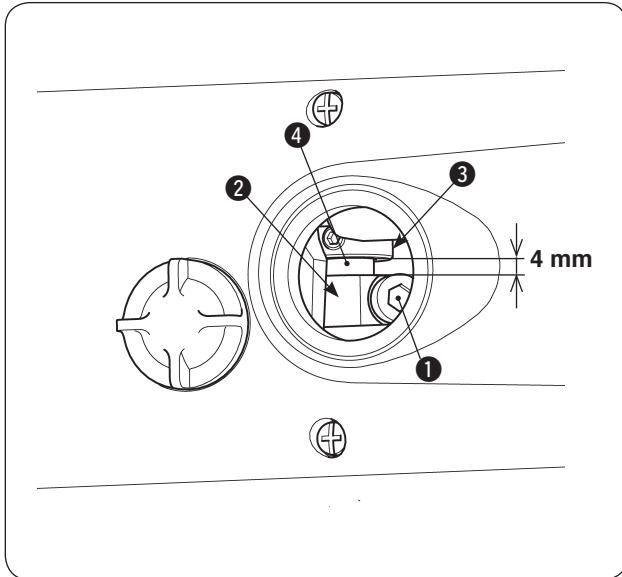


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



In case stitch skipping or thread breakage occurs due to excessive large or small needle thread loop even when performing threading in case of using stretchable threads or less stretchable threads described in "Standard threading", change the needle thread drawing timing of the rocking thread take-up and adjust the size of needle thread loop.

- 1) Loosen screw ①.
 - 2) Move ② forward or backward. The relation between the moving direction and the size of needle thread loop is as shown in the table below.
 - 3) After the adjustment, securely tighten screw ①.
- * Clearance between crank ② and thrust collar ③ has been factory-adjusted to 4 mm at the time of delivery. (Engraved marker line on rocking thread take-up shaft ④ aligns with the edge of crank ②.)

● Size of needle thread loop

Position of crank ②	Move forward	Move backward
In case of threading for standard seams	Loop becomes smaller.	Loop becomes larger.
In case of threading for soft seams	Loop becomes larger.	Loop becomes smaller.

Note : The adjusting direction becomes reverse by way of threading. So, be careful.



1. When screw ① is loosened, the rocking thread take-up rotates due to the light weight. So, be careful. If it rotates, refer to the item "Adjusting the rocking thread take-up".

2. Do not change the timing other than the aforementioned one since the sewing trouble will be caused.

使用在「标准的穿线方法」中说明的容易伸缩或不容易伸缩的线，由于线环过大或过小等原因发生跳针、断线时，请变更摆动挑线杆的挑线同步时间，调整线环的大小。

1) 拧松螺丝 ①。

2) 请把 ② 移动到前侧或里侧。移动方向和线环的大小关系如下表所示。

3) 调整后，请拧紧固定螺丝 ①。

※ 工厂出货时的夹子 ② 和推力环 ③ 的间隙调整值为 4mm。(摆动挑线杆轴 ④ 的刻线和夹子 ② 的端面对齐。)

● 线环的大小

夹子 ② 的位置	向前侧移动	向里侧移动
标准缝迹的穿线方法时	变小	变大
柔软缝迹的穿线方法时	变大	变小

注) 穿线方法不同，调整方向相反，务请注意。



1. 拧松了螺丝 ① 后，摆动挑线杆会因自重发生转动。如果转动了，请参照「摆动挑线杆的调整」的有关内容进行调整。

2. 上述情况以外请不要变更同步关系，否则会发生缝制不良。

12. Adjusting the height of the feed dog / 送布牙高度的调整

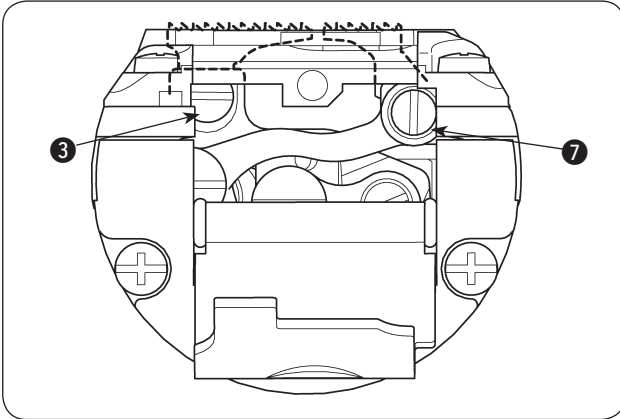


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



Adjust the height from the top surface of throat plate ① to the rear end of main feed dog ② to 1 mm when the feed dog comes to its highest position and tighten setscrew ③ to fix the feed dog.

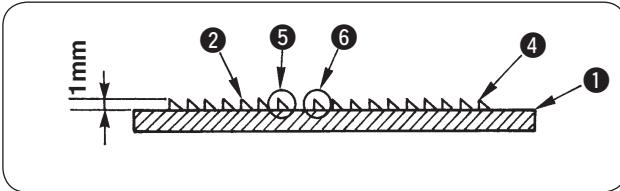
For the height of differential feed dog ④, adjust the height of front end ⑤ of main feed dog ② to that of rear end ⑥ of differential feed dog ④, and tighten setscrew ⑦ to fix the differential feed dog.

It is the standard that throat plate ① is flush with the feed dog when the feed dog is in its highest position.

送布牙来到最高点后，把针板 ① 的上面和主送布牙 ② 后端的高度调整为 1mm，然后拧紧固定螺丝 ③。

移动主送布牙 ② 的前端 ⑤ 和差动送布牙 ④ 的后端 ⑥ 的高度来调整差动送布牙 ④ 的高度，然后拧紧固定螺丝 ⑦。

标准是送布牙在最高点时，针板 ① 和送布牙呈水平状态。



13. Installing position of the spreader / 分布器的安装位置

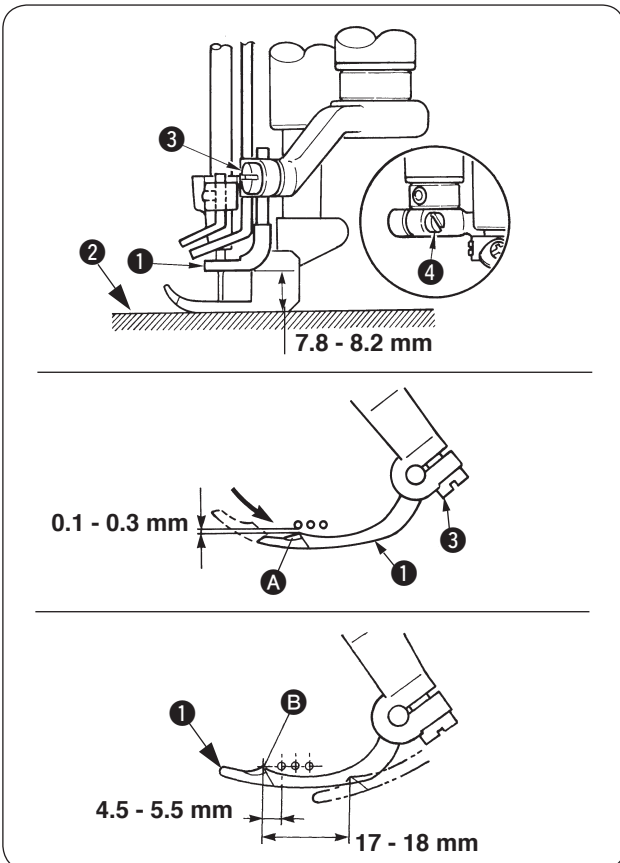


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



[Adjusting the height]

The height of spreader ① is 7.8 to 8.2 mm from the top surface of throat plate ② to the bottom surface of the spreader.

Adjust the height with clamp screw ③ and fix the spreader.

[Adjusting the longitudinal position]

Adjust so that the clearance between the spreader and left-hand needle is 0.1 to 0.3 mm when spreader ① travels from the extreme left position to the right and section A comes to the front of left-hand needle. Then fix the spreader with clamp screw ③.

[Adjusting the lateral position]

Adjust so that the distance from the center of left-hand needle to section B of the spreader ① is 4.5 to 5.5 mm when the spreader ① is in the extreme left position. Then fix the spreader with clamp screw ④.

[高度调整]

分布器 ① 的高度是针板 ② 的上面到分布器下面的距离为 7.8 ~ 8.2mm。

暂时拧紧固定螺丝 ③，调整后正式拧紧。

[前后位置的调整]

分布器 ① 从最右点向左移动，A 部来到前侧后，把与左针的间隙调整为 0.1 ~ 0.3mm，然后拧紧固定螺丝 ③。

[左右位置的调整]

分布器 ① 在最左的位置时，把从左针中心到分布器 ① B 部位置的距离调整为 4.5 ~ 5.5mm，然后拧紧固定螺丝 ④。

14. Adjusting the spreader thread guide and the needle clamp thread guide / 分布导线器、针夹导线器的调整

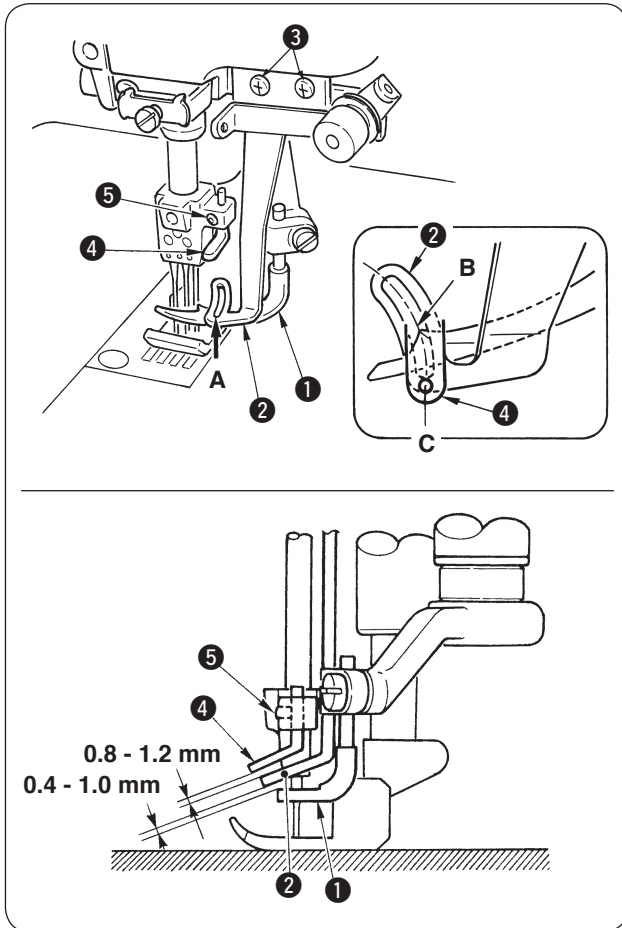


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



[Spreader thread guide]

Adjust so that the clearance between spreader thread guide ② and spreader ① is 0.4 to 1.0 mm. Then fix the spreader thread guide with setscrews ③.

- * Adjust so that the center of slot A of spreader thread guide ② aligns with blade point B of spreader ① when spreader ① is in the extreme right position. In addition, allow the spreader thread guide ② to come near the needle clamp to such an extent that the spreader thread guide does not interfere with the needle clamp.

[Needle clamp thread guide]

Adjust so that the center of thread hole of needle clamp thread guide ④ aligns with center C of slot A when the needle is in the lowest position.

- * At this time, adjust so that the clearance between needle clamp thread guide ④ and spreader thread guide ② is 0.8 to 1.2 mm. Then fix the needle clamp thread guide with setscrew ⑤.

[分布导线器]

把分布导线器 ② 和分布器 ① 的间隙调整为 0.4 ~ 1.0mm, 然后用固定螺丝 ③ 进行固定。

- ※ 分布器 ① 在最右点时，请把分布器 ① 的尖部 B 调整到与分布导线器 ② 的长槽 A 的中心一致。另外，分线导线器 ② 应不与针座相碰而尽量靠近。

[针夹导线器]

机针在最下点时，请把针夹导线器 ④ 的线孔中心和分布导线器 ② 的长槽 A 的中心 C 调整成一致。

- ※ 此时，请把针夹导线器 ④ 和分布导线器 ② 的间隙调整为 0.8 ~ 1.2mm, 然后用固定螺丝 ⑤ 进行固定。

15. Adjusting the front needle guard / 前针座的调整

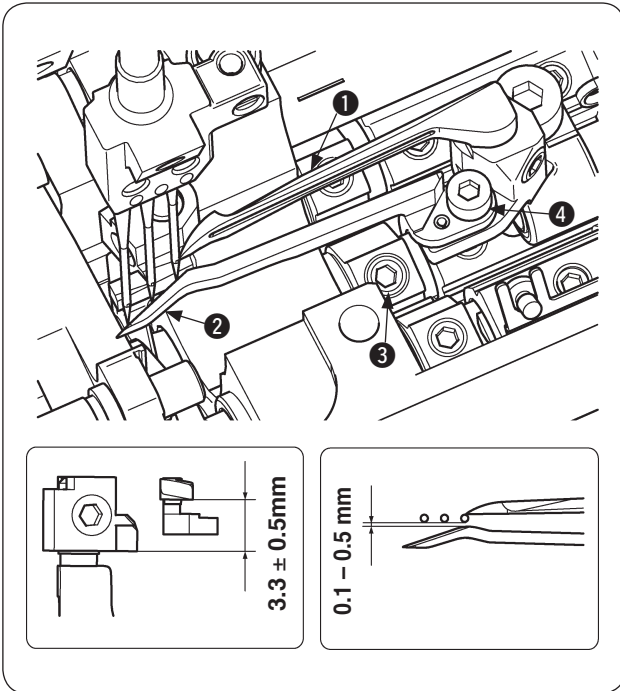


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



Adjust the height of front needle guard ② with setscrew ④ so that it is higher by 3.3 ± 0.5 mm than the rear needle guard.

Adjust with setscrew ③ so that the clearance between the needle and front needle guard ② is 0.1 to 0.5 mm when looper ① travels from the extreme right position to the left and passes the rear side of the respective needles.

* Allow front needle guard ② to come to the needle as near as possible within the range where needle thread smoothly passes in accordance with the kind or thickness of thread.

用固定螺丝 ④，把前针座 ② 的高度调整为比后针座高 3.3 ± 0.5 mm 的位置。

弯针 ① 从最右点向左移动，通过各针的里侧时，请用固定螺丝 ③ 把机针和前针座 ② 的间隙调整为 0.1 ~ 0.5mm。

※ 请根据机线的种类和粗细，在机线能通过的范围，尽量让前针座 ② 靠近机针。

16. Adjusting the presser foot lift / 压脚提升量的调整

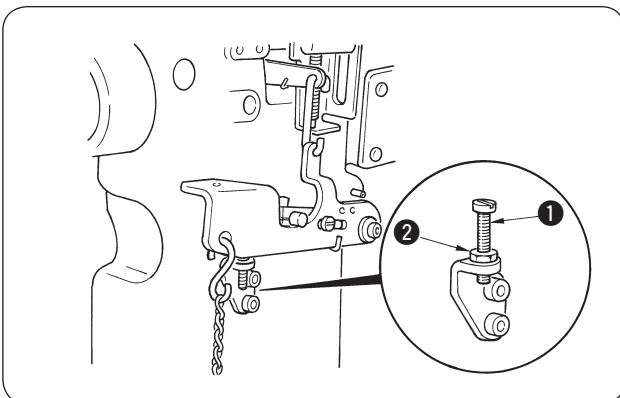


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。

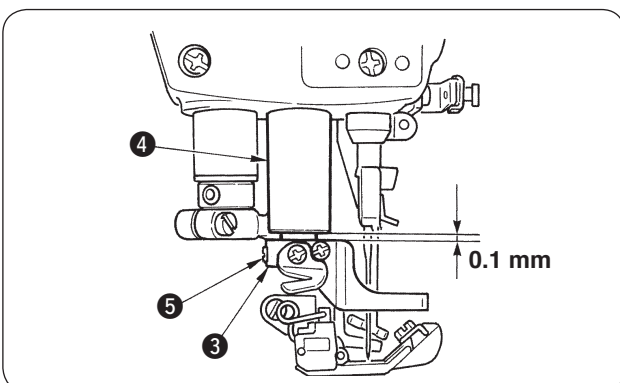


1) To adjust the height of the presser foot, adjust the height of screw ① so that the presser foot does not come in contact with other components and fix the presser foot with nut ②.

2) Adjust the position of the thrust collar so that the clearance between thrust collar ③ and presser bar bushing ④ is 0.1 mm when the presser foot is lifted. Then fix the thrust collar with setscrew ⑤.

1) 调整压脚高度时，请调整螺丝 ① 的高度，不让压脚和其他零件相接触，然后用螺母 ② 进行固定。

2) 提升了压脚后，请调整套环位置，让套环 ③ 和压脚杆金属件 ④ 的间隙为 0.1mm，然后用固定螺丝 ⑤ 进行固定。



17. Adjusting the micro-lifter / 微量压脚提升的调节

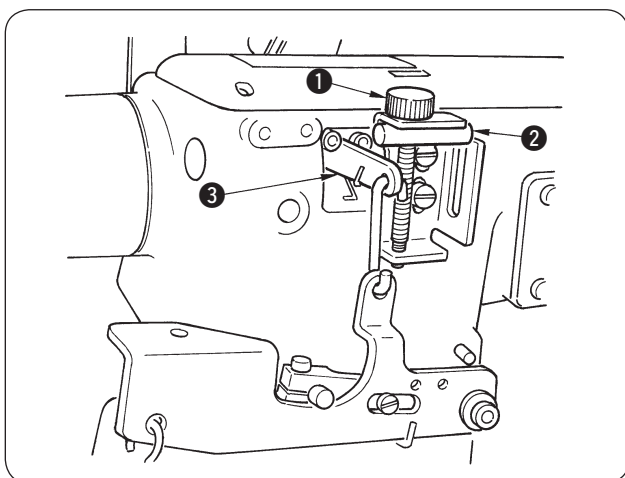


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



When micro-lifter knob ① is turned counterclockwise, micro-lifter stopper ② lowers and comes in contact with presser lifting lever ③. Then the presser foot goes up. Adjust the height in accordance with the sewing conditions.



When the micro-lifter is not used, turn clockwise micro-lifter knob ① and fix micro-lifter stopper ② at the highest position.

向左转动微量压脚提升旋钮 ① 之后，微量压脚提升止动器 ② 下降，接触压脚提升拨杆 ③，压脚上升。请根据缝制条件调整高度。



不使用微量压脚提升功能时，请向右转动微量压脚提升旋钮 ①，把微量压脚提升止动器 ② 固定到最高点。

VII. MAINTENANCE / 维修保养

1. Cleaning the sewing machine / 缝纫机的清扫

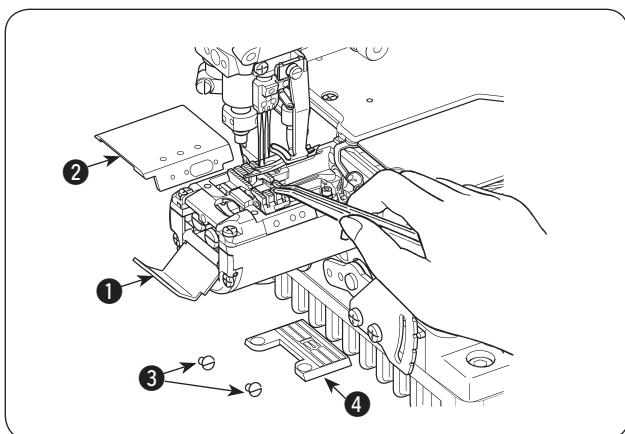


WARNING :

When cleaning, be sure to turn OFF the power and ascertain that the motor has totally stopped rotating before starting the work. There is a danger of injury since hands or clothes may be caught in the machine.

注意：

需要清扫时，请一定关掉马达的电源，确认了马达停止转动之后再进行操作。以免发生把手指、衣服卷进机器造成负伤的危險。



Open side cover ① and cylinder cover, right ②. Remove screws ③ and then throat plate ④. Then, clean up the throat plate slits, feed dog teeth and the area surrounding them. After cleaning, fix throat plate ④ with setscrews ③.

打开侧面护罩 ① 和右缸筒护罩 ②，卸下螺丝 ③ 再卸下针板 ④，清扫针板槽和送布牙槽以及四周。清扫之后，用固定螺丝 ③ 固定针板 ④。

2. Replacing the lubricating oil / 缝纫机油的更换

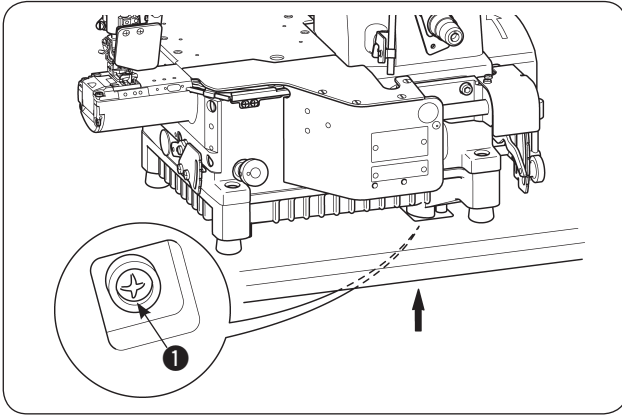


WARNING :

To protect against possible personal injury due to abrupt start of the machine, be sure to start the following work after turning the power off and ascertaining that the motor is at rest.

注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



In case of the new sewing machine, replace the lubricating oil (JUKI MACHINE OIL 18) with new one after using it for approximately one month. Then replace the lubricating oil every six months.

- 1) Set a container to receive the lubricating oil under drain screw ①.
- 2) Remove drain screw ①. The lubrication oil is drained.
- 3) After the drain, wipe out the oil and attach the drain screw ①.

新缝纫机时，约使用1个月之后，请更换机油（JUKI MACHINE OIL 18）。

以后，请每6个月更换1次机油。

- 1) 请把接油容器安装到排油螺丝 ① 的下面。
- 2) 请卸下排油螺丝 ①。让机油排放出来。
- 3) 排放后，请擦干净机油，然后安装上排油螺丝 ①。

3. Inspecting and replacing the oil filter / 滤油器的检查、更换

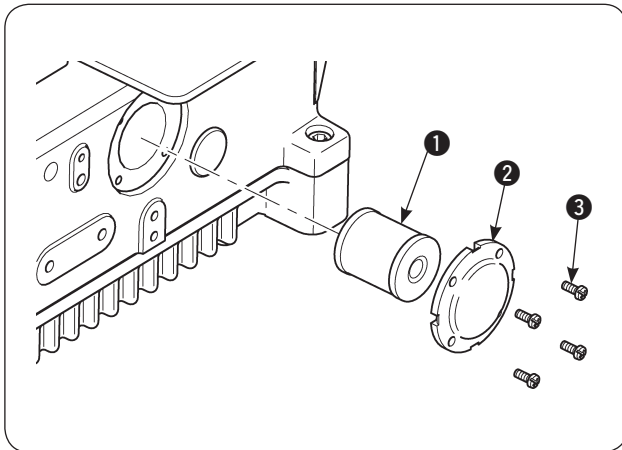


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注意：

为了防止突然起动造成人身事故，请关掉电源，确认马达确实停止转动后再进行操作。



Normal lubrication cannot be performed if dust collects in oil filter ①. Inspect it every 6 months.

- 1) Remove filter cap ②, and draw out oil filter ① to inspect it.
- 2) When oil filter ① is clogged with dust, replace it with a new one.
- 3) After the replacement, fix the filter cap ② with screws ③.



When removing the oil filter cap, lubricating oil collected in the filter will leak out. So, be careful.

机油过滤器 ① 如果积满了脏污就不能正常地供油。因此，请每6个月检查1次。

- 1) 卸下机油过滤器盖子 ②，拔出机油过滤器 ①，进行检查。
- 2) 如果过滤器 ① 积满了脏污，请更换成新的过滤器。
- 3) 更换后，用螺丝 ③ 固定过滤器盖子 ②。



卸下滤油器盖后，请注意积存在滤油器上的机油有可能漏出来。

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Please do not hesitate to contact our distributors or agents in your area for further information when necessary.

*** The description covered in this instruction manual is subject to change for improvement of the commodity without notice.**

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※ 本使用说明书中的规格因改良而发生变更，请订货时确认。