



NA-35DUT-1

Direct Drive, 1-needle, Post-bed, Top and Bottom Wheel-Feed and Needle-Feed,
Lockstitch Machine with Automatic Thread trimmer (Digital Stitch Length Control)

直驱单针柱状上下罗拉送布&针送布平缝自动切线机(数码针距设定)

INSTRUCTION MANUAL (Mechanical)

使用说明书 (机械)

危险警告



机器运作过程中，必须在机器的前后各保留1 m 的自由工作范围，以保证人员能够随时地、不受阻地接近机器。



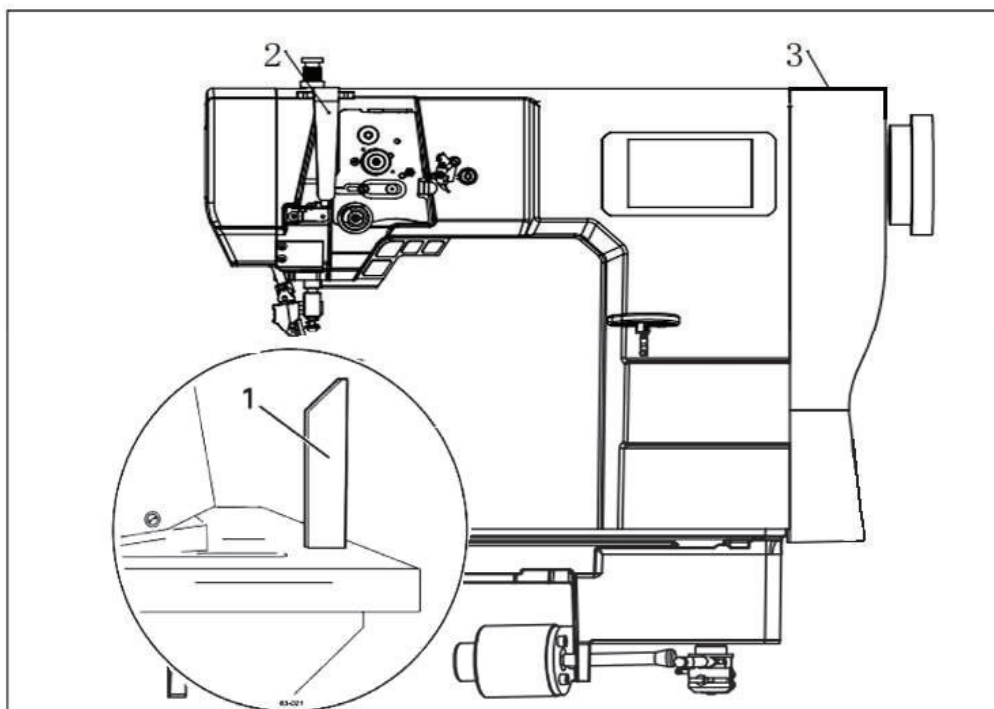
在缝纫过程中，不许在缝纫针区域抓取任何东西！
有被针伤的危险！



调整工作过程中，不许在工作台上放任何物品！
物品有被卡住或者被甩走的可能！有被四下乱飞的物品伤害的危险！



不许开动没有支承件 1 的机器！因为机头非常重，当向后倾斜时，机器有向后翻倒的危险！



在向后倾斜机器前关闭总开关！
有被机器意外地起动伤害的危险！



不许开动没有挑线杆护罩 2 的机器！
有被挑线杆的动作伤害的危险！

Warning Against Danger



During machine operation, a free working range of 1 m must be reserved at the front and rear of the machine to ensure that personnel can approach the machine at any time without obstruction.



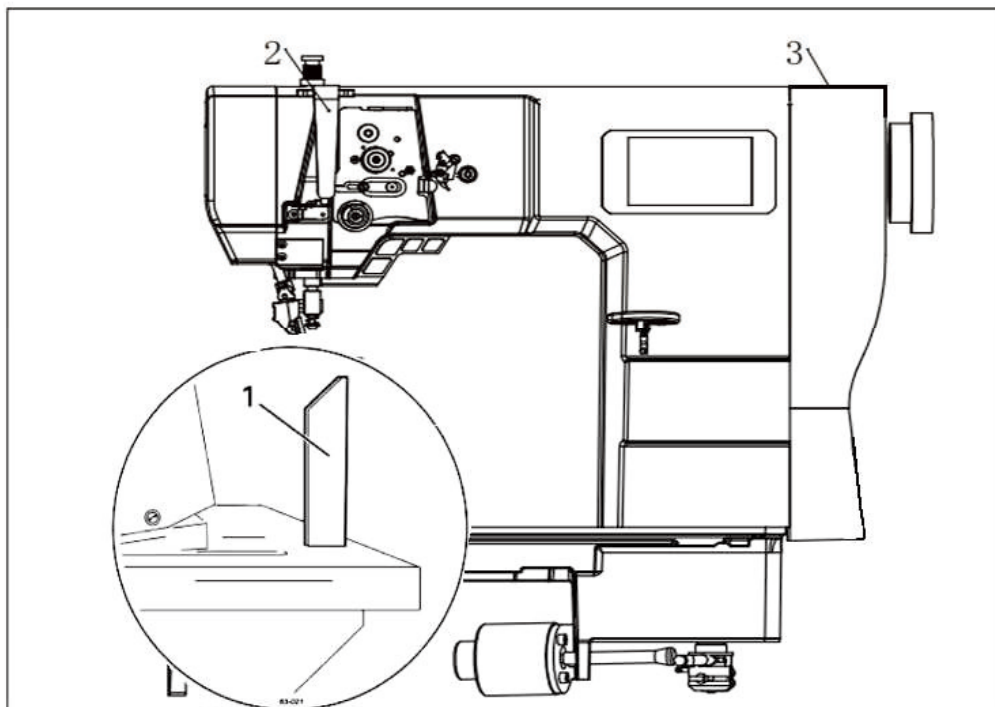
Do not grab anything in the sewing needle area during sewing area!
There is a risk of needle injury!



Do not place anything on the work table during adjustment!
Objects may be caught or thrown away! Danger of injury from flying objects!



Do not operate a machine without support 1! Because the head is so heavy, and the machine is in danger of tipping over backwards when tilted back!



Turn off the main switch before tilting the machine backwards!
Risk of injury by accidental start of the machine!



Do not operate the machine without rod guard 2!
Risk of injury from rod movements!

2. 安装 Installation

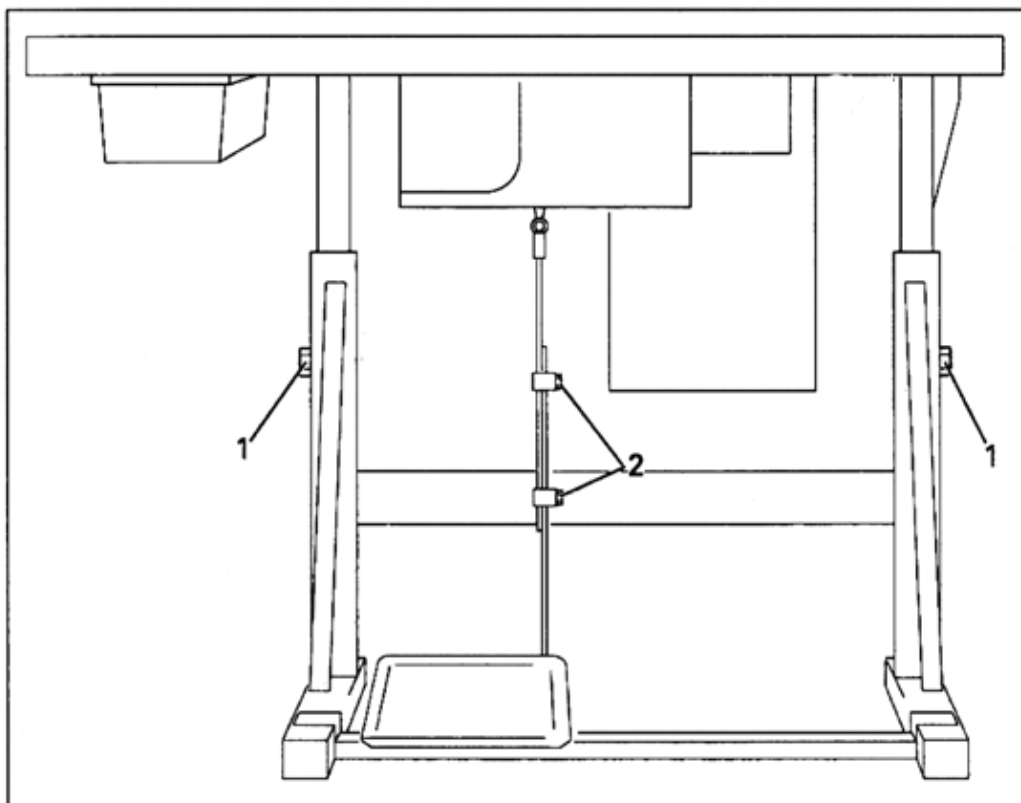
在机器安装地点，必须有与机器相符的电源接口。

在机器安装地点，必须有平整、坚固的地面，以及充分的照明。

The site where the machine is installed must be provided with suitable connections for electric current.

It must be ensured that the standing surface of the machine site is firm and horizontal, and that sufficient lighting is provided for.

2.01 台板高度的调整 Adjust the table height



松开螺钉 1 和 2，并将台板调整至所需的高度；

将螺钉 1 牢固地拧紧；

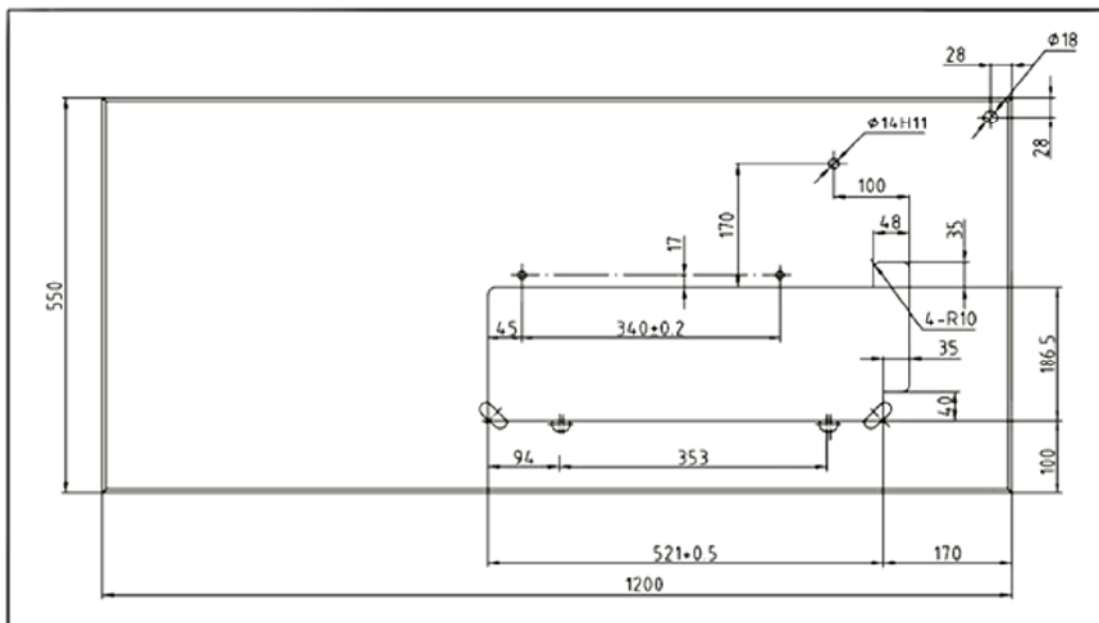
将踏板调至所需的位置，并且将螺钉 2 拧紧。

Loosen screws 1 and 2 ,and set the table height as required;

Firmly tighten screw 1;

Set the required pedal position and tighten screw 2.

2.04 安装台板 Install the platen

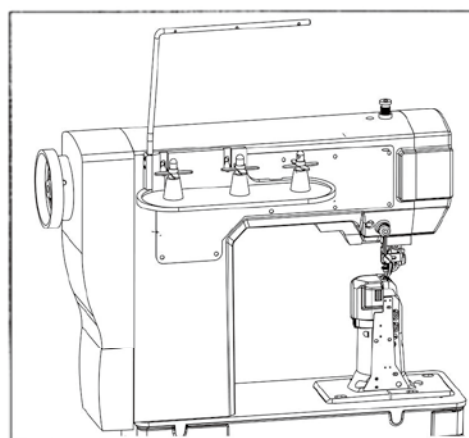


2.05 安装线架 Fitting the reel

stand

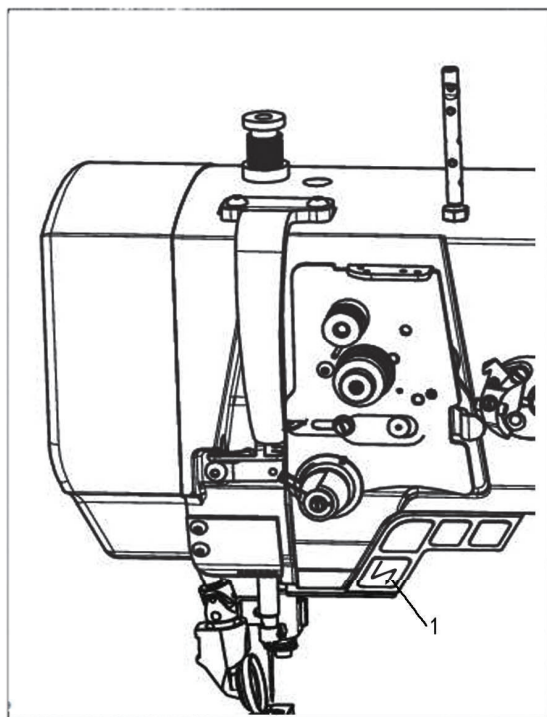
如图所示安装线架；
然后将线架插入机壳的孔中并用随带的螺钉可靠地固定。

Fit the reel stand as shown in Fig.;
Afterwards insert the stand in the hole of
the chassis top and secure it with the screw
provided.



3. 操作件 Controls

3.01 机头按键 Keys on the machine head



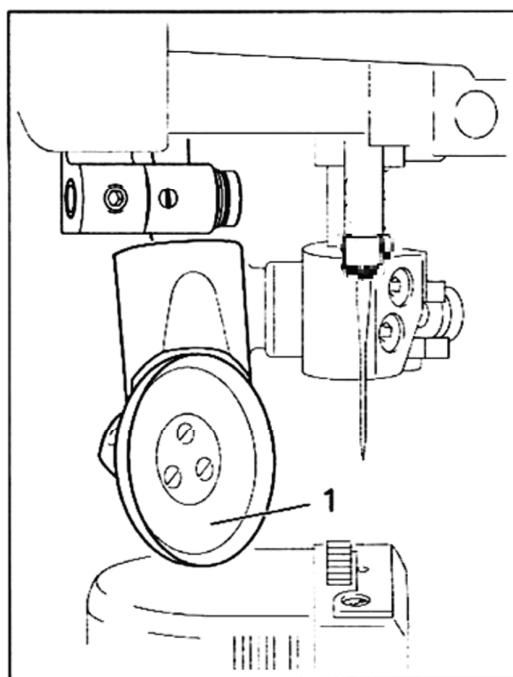
在缝纫过程中，只要按下按键 1，机器的缝纫方向就反转；
其他按键请详见电控说明书。

As long as key 1 is pressed during sewing ,the machine sews in reverse ;
Other keys Instruction Manual of Electronic Control .

3.02 滚轮压脚向外摆动 Swing out roller presser

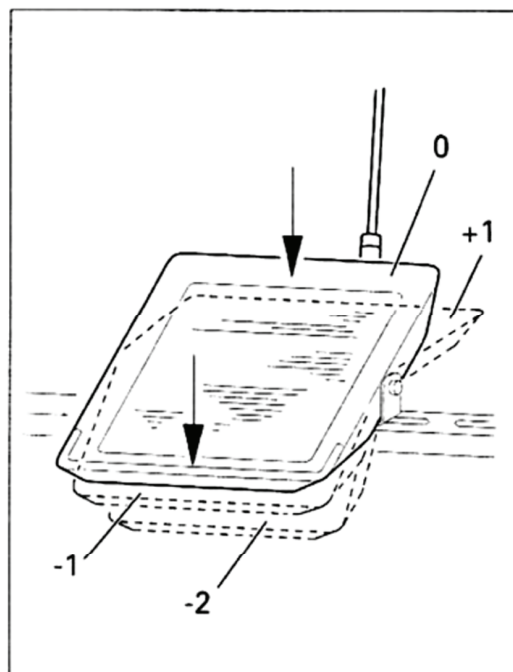
当滚轮压脚抬起后，可以通过向下轻拉它，使其向外摆动。

When the roller presser is raised , it can be swung out by pulling it lightly down-wards.



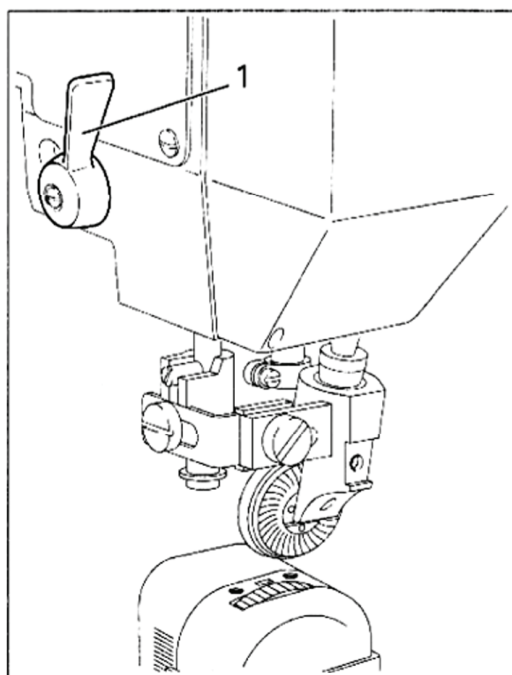
3.03 踏板 Pedal

- 0 = 静止位置 Neutral position
- +1 = 缝纫 Sewing
- 1 = 抬起滚轮压脚 Raise roller presser
- 2 = 剪线 Trim sewing threads



3.04 滚轮压脚扳手

Lever for lifting roller presser



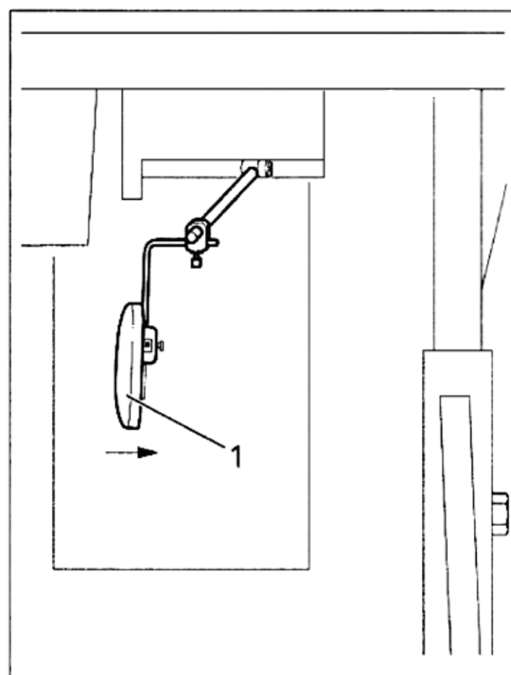
可以通过转动扳手 1 抬起滚轮压脚。

The roller presser can be raised by turning lever 1 .

3.05 膝控 Knee lever

可以通过向箭头所示方向挤压膝控杆 1 来抬起滚轮压脚。

The roller presser can be raised by pressing the knee lever 1 in the direction of the arrow.



4. 缝纫操作准备 Preparation

必须遵守本说明书中所有的规定和提示，特别要注意所有的安全规定；

所有机器准备工作只允许由受过相应培训的人员完成；

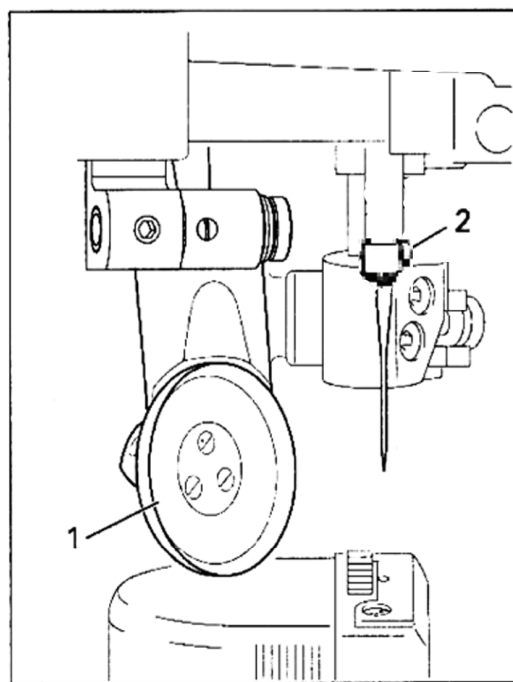
在所有的机器准备工作时，必须通过关闭总开关或者从电源插座上拔出插头，以使机器断电。

All instructions and regulations in this instruction manual must be observed , special attention must be paid to all safety regulations ;

All setting-up work must only be carried out by personnel with the appropriate training ;

For all setting-up work the machine must be disconnected from its power supply by turning off the on/off switch , or removing the plug from the electric power socket.

4.01 安装机针 Inserting the needle



抬起滚轮压脚 1 并将其向外摆动；

松开螺钉 2 并插入机针，使机针的长槽背对着各自勾线的旋梭（即勾线旋梭在左，长槽就向右；勾线旋梭在右，长槽就向左）；

拧紧螺钉 2 并将滚轮压脚摆回到原位置。

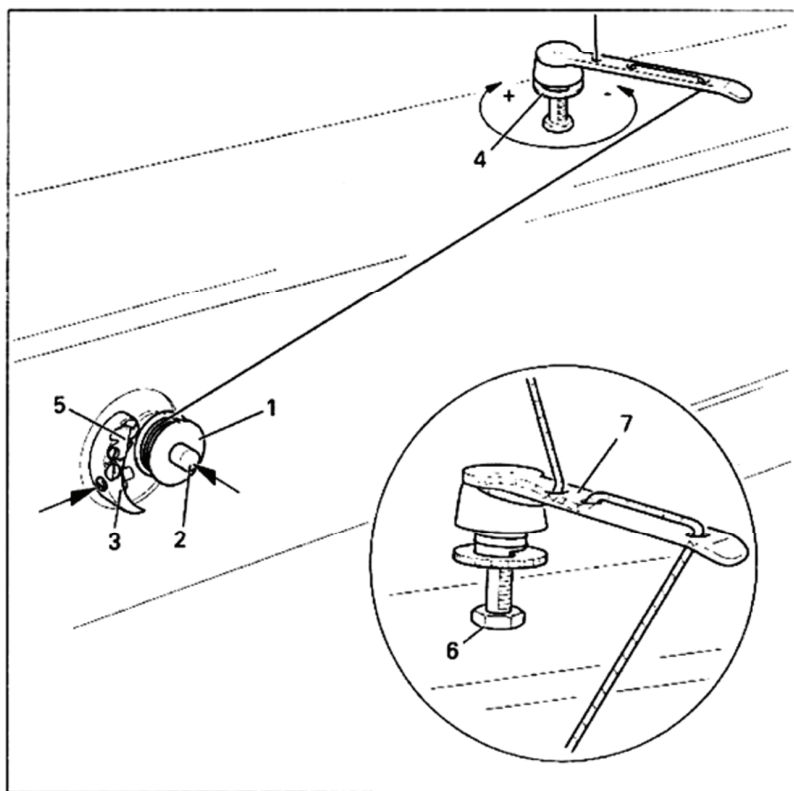
Raise the roller presser 1 and swing it out ;

Loosen screws 2 and insert the needle as far as possible , the long groove must be contrary to the hook (If the hook is on the left, the long groove must be on the right);

Tighten screw 2 and swing roller presser 1 back into position.

4.02 绕梭芯线，调整梭芯线的张力。

Winding the bobbin thread ,adjusting the thread tension.



将一个空的梭芯 1 安装到绕线器轴 2 上；

如图所示，给梭芯穿线，并将线顺时针方向在梭芯上绕几圈；

同时压下绕线器轴 2 和杠杆 3，启动绕线器。

Place an empty bobbin 1 onto bobbin shaft 2;

Thread the bobbin in accordance with Fig. and wind it anti-clockwise around bobbin 1 a few times;

Switch on the bobbin winder while at the same time pressing bobbin winder spindle 2 and lever 3.

缝纫过程中的梭芯绕线

在梭芯 1 上的线张力可以用滚花螺母 4 进行调节；

当梭芯绕满线后，绕线器自动停止；

如果绕线不均匀，可以松开螺母 6，相应转动调整导线板 7 并拧紧螺母 6。

The bobbin fills up during sewing

The tension of the thread on bobbin 1 can be adjusted with knurled nut 4;

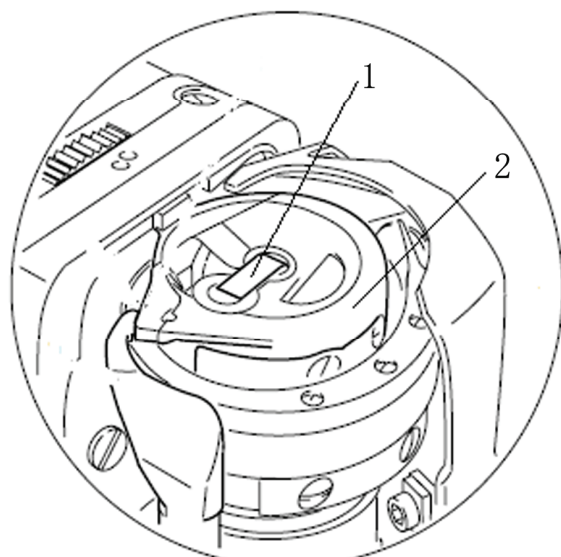
The bobbin winder stops automatically when bobbin 1 is full;

If the thread is wound unevenly , loose nut 6 and turn thread guide 7 accordingly .Retighten nut 6 after the adjustment .

4.03 取出/装入梭壳 Removing/Inserting the bobbin case

取出梭壳：
打开旋梭盖；
抬起梭门闩 1 并取出梭壳 2。
装入梭壳：
装入梭壳 2；
关闭梭门闩 1 并重新合上旋梭盖。

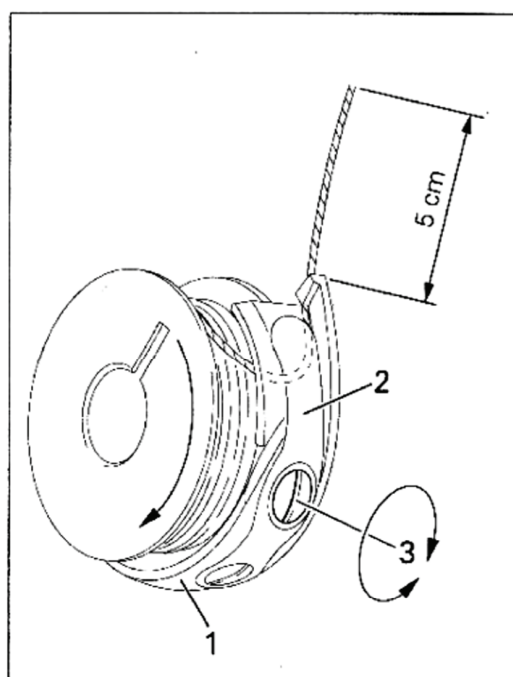
Removing the bobbin case :
Open the post cap ;
Raise latch 1 and remove bobbin case 2 .
Inserting the bobbin case :
Insert bobbin case 2 ;
Close the latch 1 and close the post cap .



4.04 梭壳穿线/调节梭芯线的张力

Threading the bobbin case/Adjusting the bobbin thread

tension

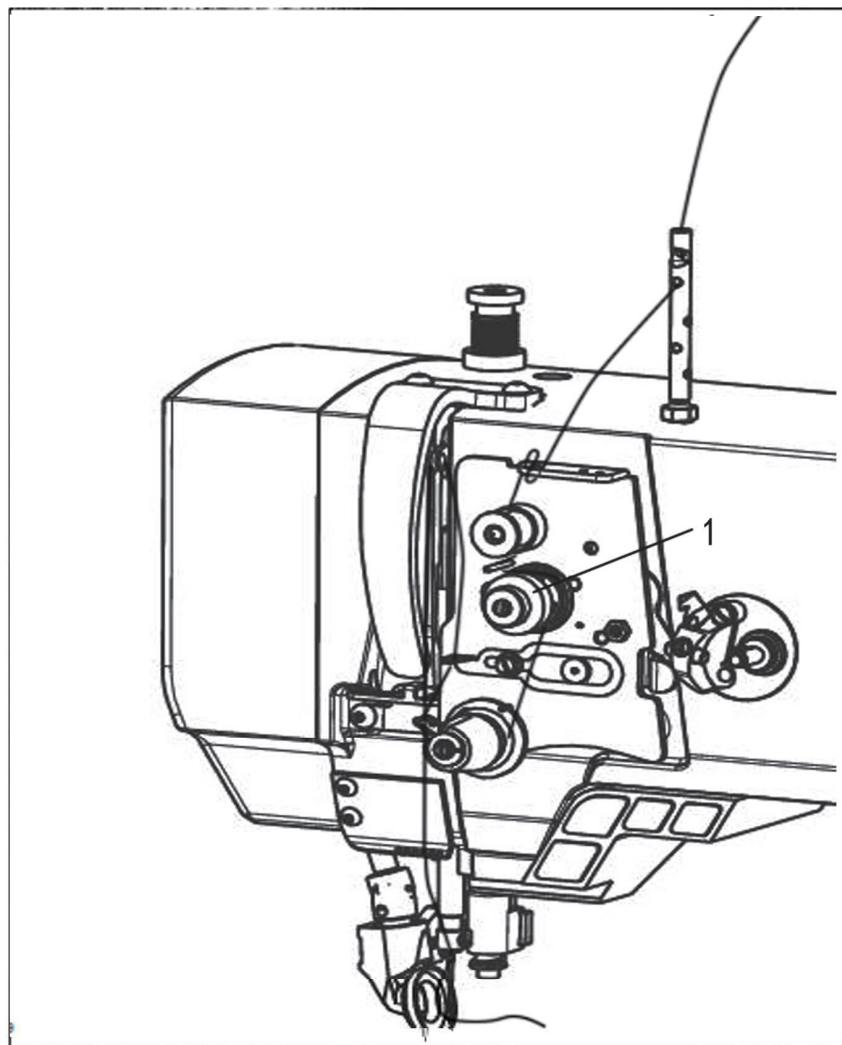


将梭芯装入梭壳 1 中；
将线穿过弹性压板 2 下的狭槽中；
将线穿过凹口处；
通过旋动螺钉 3 调节梭芯线张力。

Insert the bobbin into the bobbin case ;
Pass the thread through the slot under spring 2 ;
Pass the thread through the notch;
Adjust the thread tension by turning screw 3 .

4.05 单针机型上穿针线并调整针线张力

Threading the needle thread and regulating its tension on the single needle machine on model single needle.



如图所示穿针线；

在左旋梭机型上，针线是从右向左穿；而在右旋梭机型上，针线是从左向右穿；
通过转动滚花螺母 1 调节针线的张力。

Thread the needle thread as shown in Fig. ;

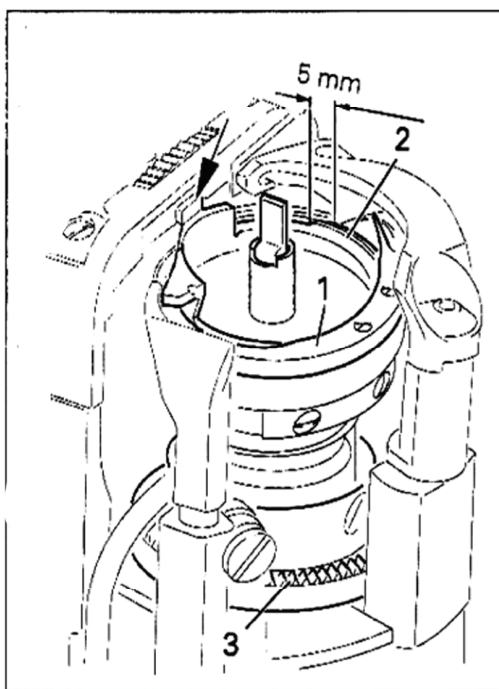
On model left hook the needle is threaded from the right to the left ,and on model right hook from the left to the right;

Adjust the needle thread tension by turning milled nut 1 .

5. 维护与保养 Care and maintenance

清洁.....	每天, 如果持续运转时, 每天多次
油量检查 (线润滑/旋梭润滑)	每天, 开机之前
给旋梭加油.....	每天, 开机之前
伞齿轮副润滑.....	每年一次
检查/调节空气压力.....	每天, 开机之前
清洁空气滤清器/润滑器的过滤网.....	在需要时
Clean.....	daily , more frequently if in continuous operation
Oil level (thread lubrication/hook lubrication).....	daily , before use
Oil the hook.....	daily , before use
Lubricate the level gears.....	once a year
Check/adjust air pressure.....	daily , before use
Clean air filter of air filter/lubricator.....	when required

5.01. 清洁 Cleaning



每天清洁旋梭, 旋梭腔和齿轮 3, 如果持续运行时, 每天清洁多次。

Clean the hook ,hook compartment and toothed wheel 3 every day , several times if in continuous use .

关闭机器电源;

将针杆升到最高位置;

打开旋梭盖, 取出梭壳和梭芯;

拧松内梭头舌 1 的螺钉;

转动手轮, 直到梭壳 2 的尖端进入旋梭的导槽内大约 5mm;

取出梭壳 2;

用石蜡清洁旋梭槽;

当放入梭壳 2 时, 要确信梭壳 2 的凸出鼻端部分啮合入针板的凹槽中;

拧紧内梭头舌 1 的螺钉并盖上旋梭盖。

Bring the needle bar to its highest position ;

Open the post cap and remove the bobbin case cap and the bobbin ;

Unscrew hook gib 1 ;

Turn the hand wheel until the point of bobbin case 2 penetrates into the groove of the hook race approx.5mm ;

Remove bobbin case 2 ;

Clean the hook race with paraffin ;

When inserting the bobbin case 2 , ensure that the horn of the bobbin case 2 engages in the groove of the needle plate ;

Screw hook gib 1 back on and close the post cap .

5.02 给旋梭加油 Oiling the hook

关闭机器电源；

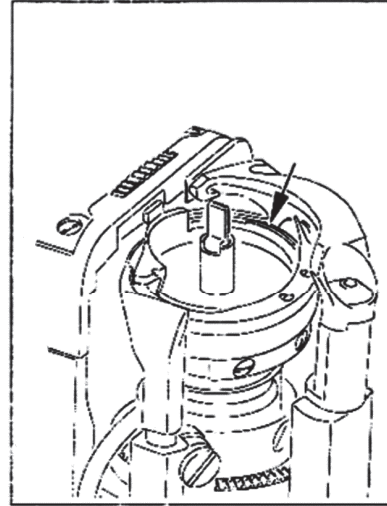
每天注 1-2 滴油到内梭头舌的孔 1 中；

在机器试车前及在长期停机后，注入几滴油到旋梭的槽中（参见箭头所示）。

Switch the machine off ;

Pour 1-2 drops of oil into hole 1 of the hook gib daily ;

Before commissioning the machine , and after long periods out of operation , pour a few drops of oil into the hook race (see arrow) .



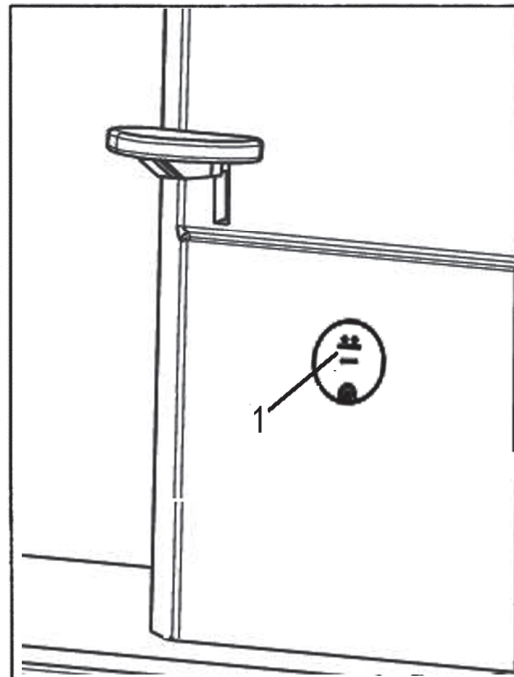
5.03 旋梭润滑油盒 Oil bowl for hook lubrication

在每次开机前检查油量，必须始终保持油盒 1 中有油。如果需要可通过加油孔加油。

只允许使用在 40℃ 时平均粘度为 22.0mm²/s 和在 15℃ 时密度为 0.865g/cm³ 的润滑油。

Check the oil level before each use ,there must always be oil in reservoir 1 .If required refill oil through hole.

Use only oil with a mean viscosity of 22.0mm²/s at 40℃ and a density of 0.865 g/cm³ at 15℃ .



5.04 给伞齿轮副润滑 Lubricating the bevel gears

关闭机器电源！

所有伞齿轮副每年必须加一次新油脂。

向后翻转机头到支撑件上。

Switch the machine off !

All bevel gears must be supplied with new grease once a year.

Tilt the sewing head back onto the support.

如图所示机型的伞齿轮副。

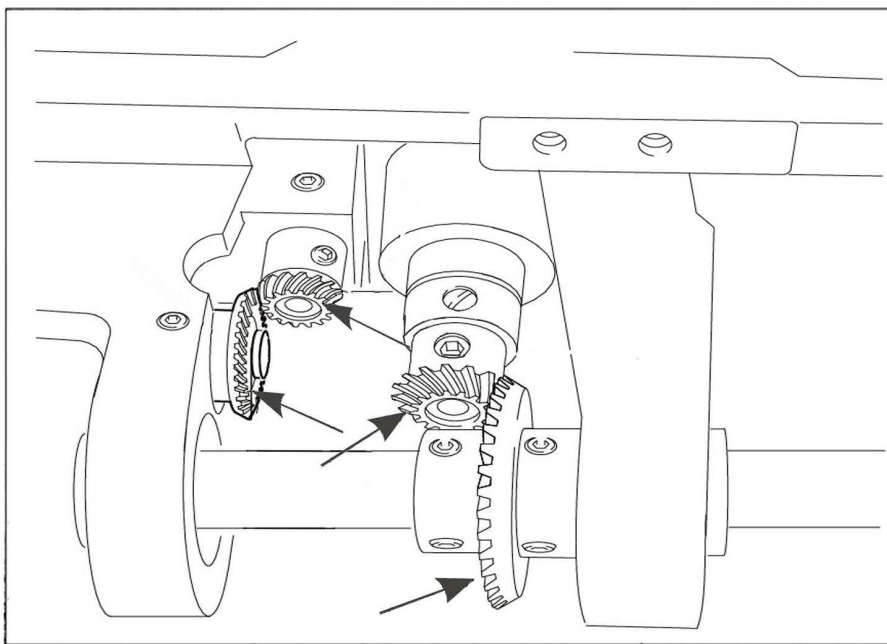
涂油脂到齿轮的全部齿侧面（见箭头所示）。

Fig. shows the bevel gears of the machine .

Apply grease to all the tooth flanks and the rack (see arrows) .

我们推荐使用滴点大约为 150° C 含钠油脂。

We recommend sodium grease with a dripping point of approx.150° C .



警告：必须用双手将机头放回垂直位置

有在机头和台板之间被挤伤的危险！

Warning :Use both hands to set the sewing head upright .

Danger of crushing between the sewing head and the table top !