



NA-35UT-1

Direct Drive, 1-needle, Post-bed, Top and Bottom Wheel-Feed,
Needle-Feed, Lockstitch Machine with Automatic Thread trimmer

直驱单针柱状上下罗拉送布&针送布平缝自动切线机

NA-35UT-2

Direct Drive, 2-needle, Post-bed, Top and Bottom Wheel-Feed,
Lockstitch Machine with Automatic Thread trimmer

直驱2针柱状上下罗拉送布平缝自动切线机

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。



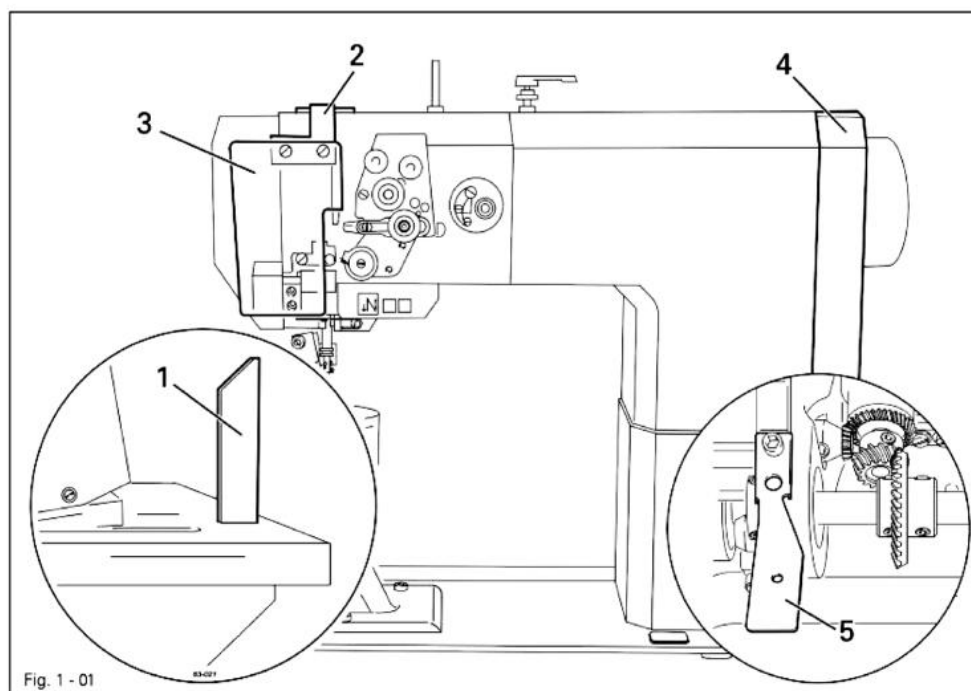
在缝纫过程中，不许在缝纫针区域抓取任何东西！
有被针伤的危险！



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！



带有线润滑器的机器不许在护眼装置 3 放下前开动！护眼装置 3 保护眼睛免受来自线润滑的油微粒伤害。



不许开动没有皮带防护罩 4 的机器！
有被旋转的驱动皮带伤害的危险！



不许开动没有翻转保险 5 的机器！
有在机头和抬板之间被挤伤的危险！

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.



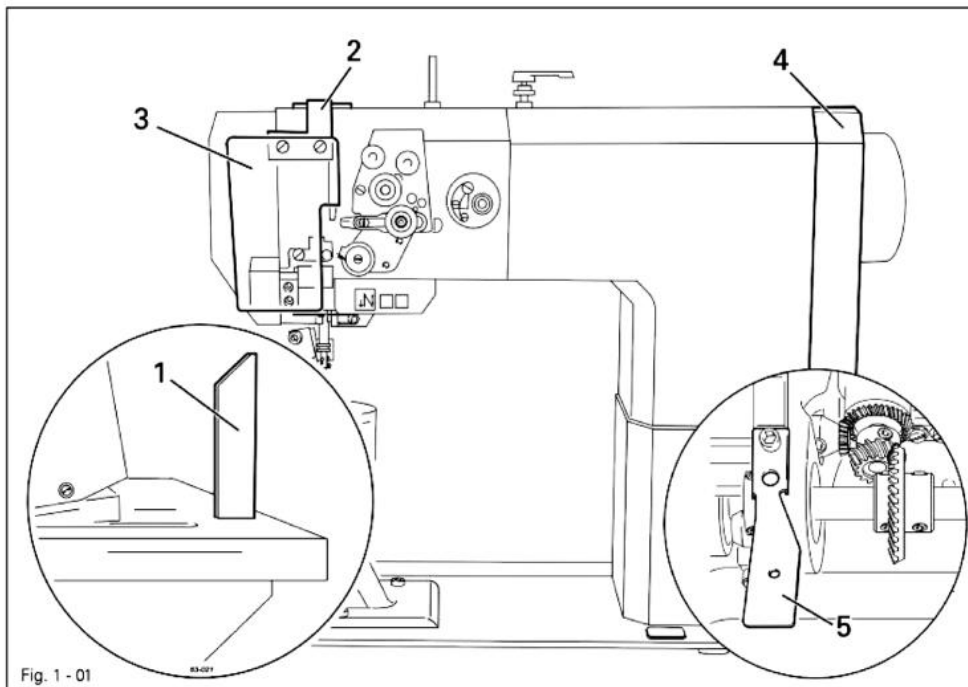
Do not grab anything in the sewing needle area during sewing area!
There is a risk of needle injury!



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!



Machines with line lubricators should not be started before an eye protection device 3 is properly applied! The eye protection device 3 protects the eyes from oil particles against line lubrication.



Do not operate the machine without the belt guard 4!
Risk of injury by rotating drive belt!



Do not operate the machine without the rollover safety device 5!
Risk of injury if caught between the machine head and lift plate!

2. 安装 Installation

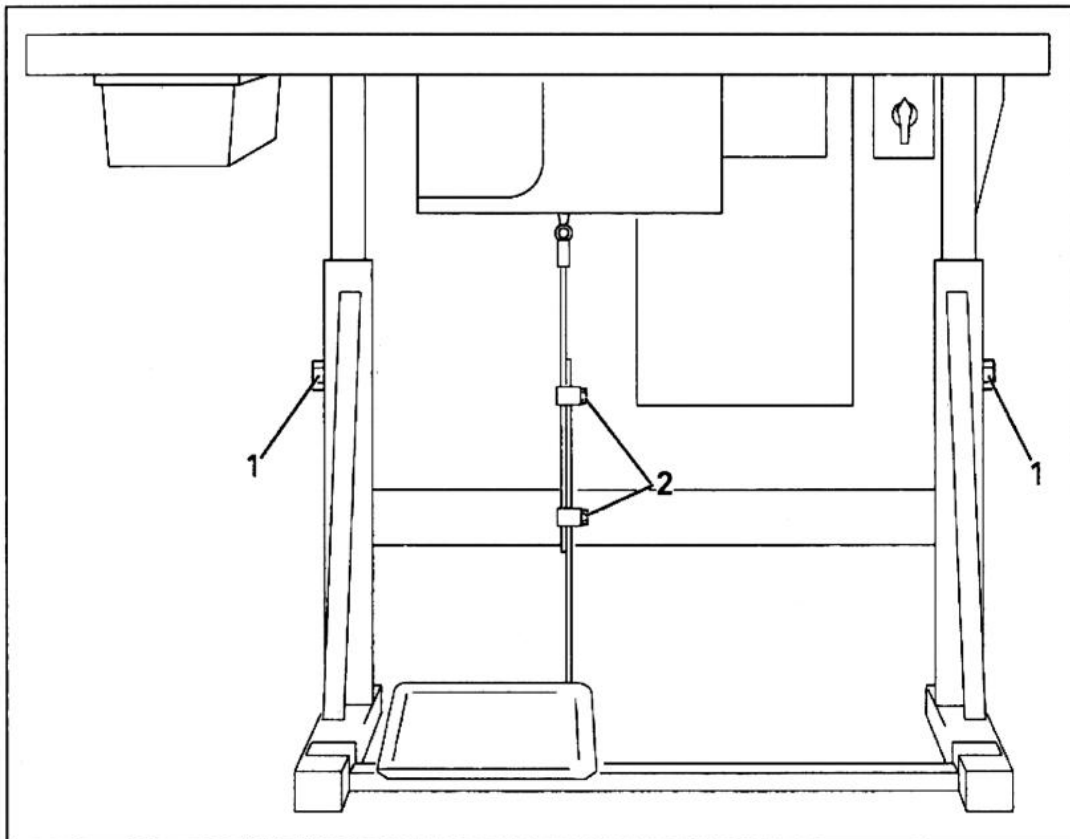
在机器安装地点，必须有与机器相符的电源接口。

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；

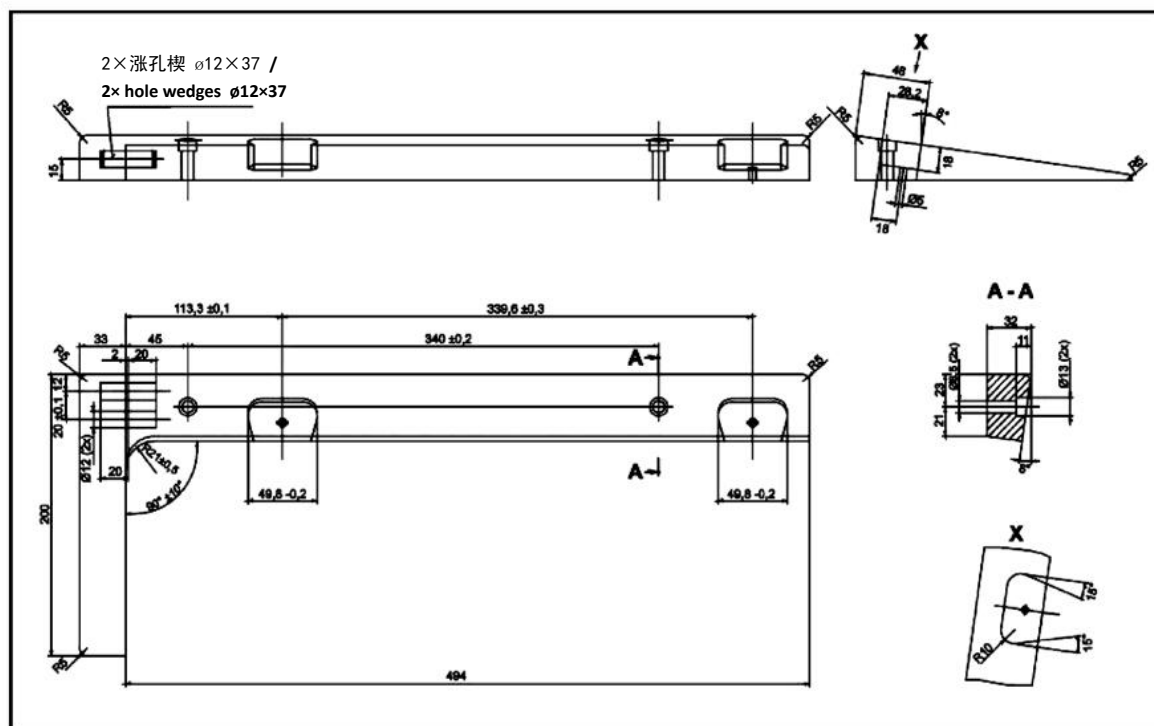
将踏板调至所需的位置，并且将螺钉 2 拧紧。

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

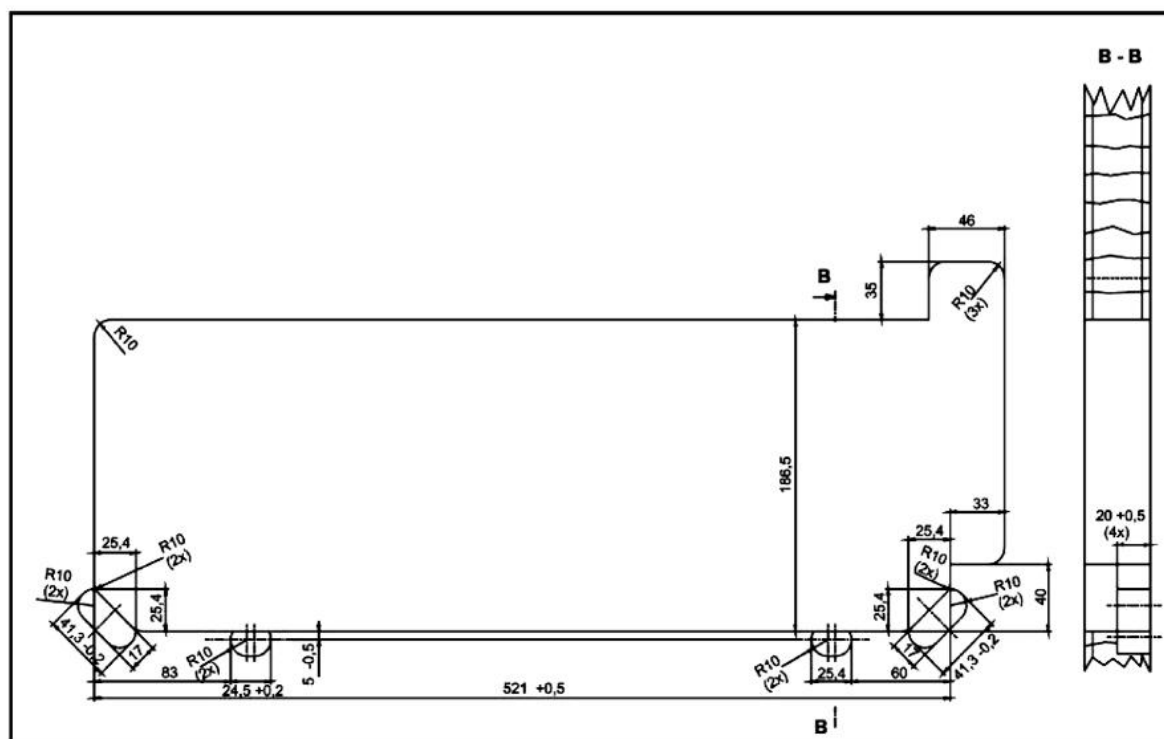
Firmly tighten screw 1;

Set the required pedal position and tighten screw 2.

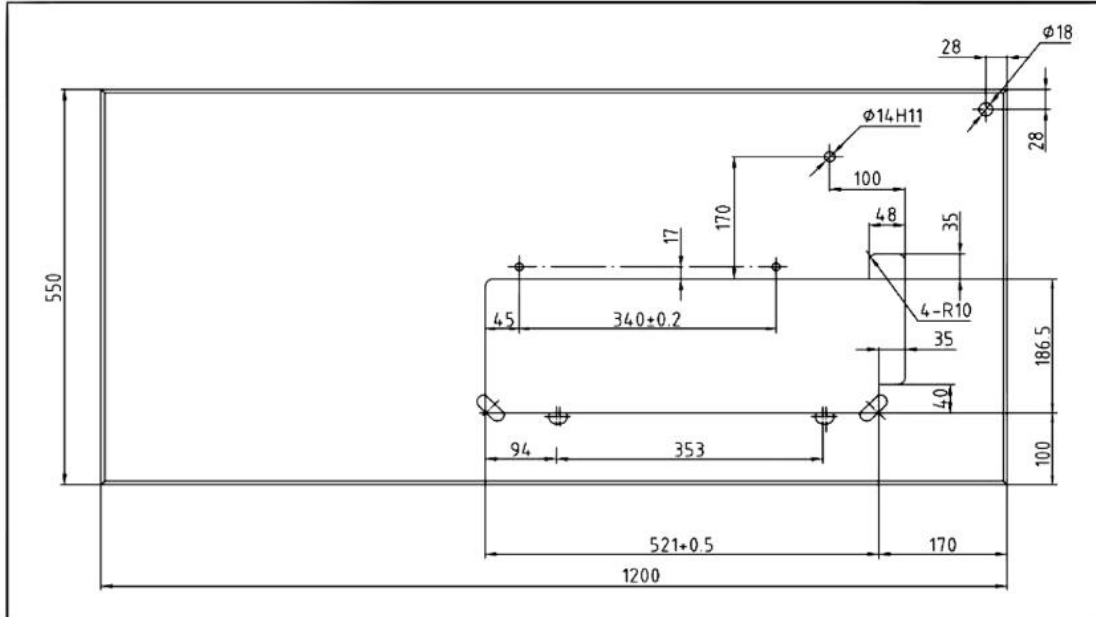
2.02 安装倾斜支撑块 **Install the inclined support block**



2.03 台板开槽部位尺寸 Size of slotting part of the platen



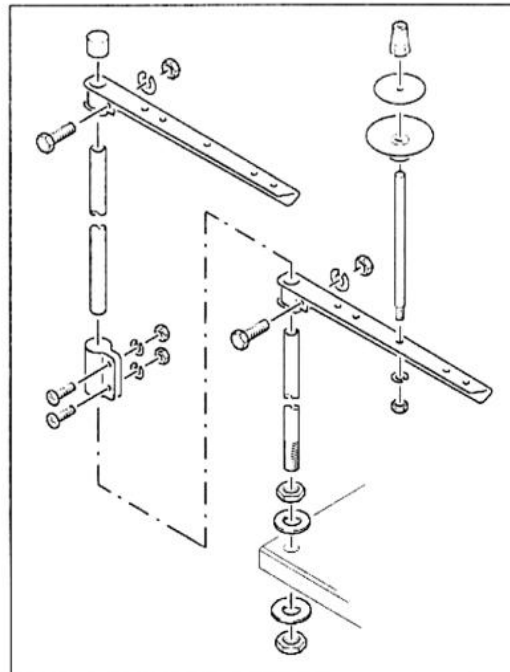
2.04 安装台板 Install the platen



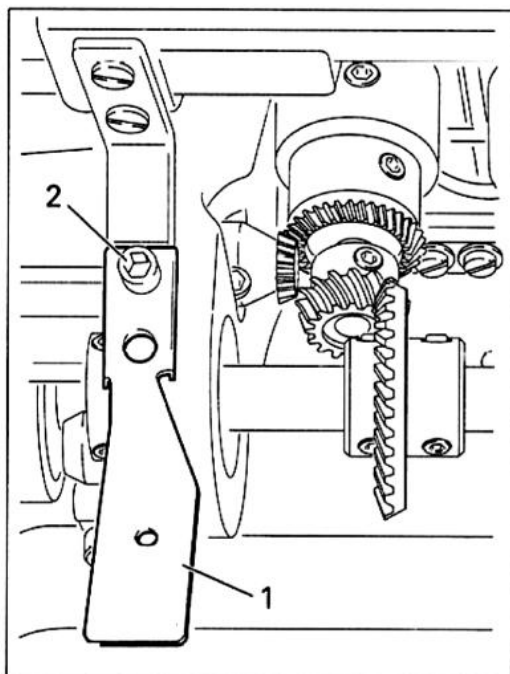
2.05 安装线架 Fitting the reel stand

如图所示安装线架；
然后将线架插入台板的孔中并用随带的螺母可靠地固定。

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



2.06 安装翻转保险 Fitting the tilt lock



关闭电源总开关；

用螺栓 2 固定翻转保险 1。

注：不许开动没有翻转保险 1 的机器！
有在机头和台板之间被挤伤的危险！

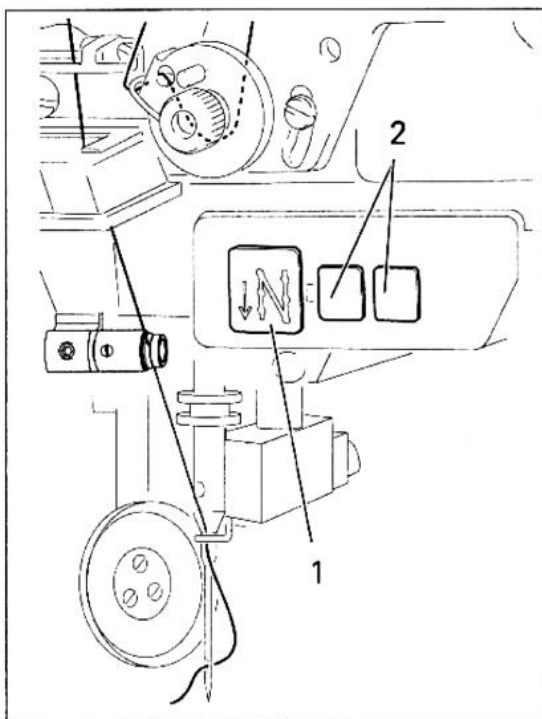
Switch off the machine;

Screw on the tilt lock 1 ,provided in the accessories,using screw 2 .

Note:Do not operate the machine without tilt lock 1! Danger of crushing between sewing head and table top!

3. 操作件 Controls

3.01 机头按键 Keys on the machine head

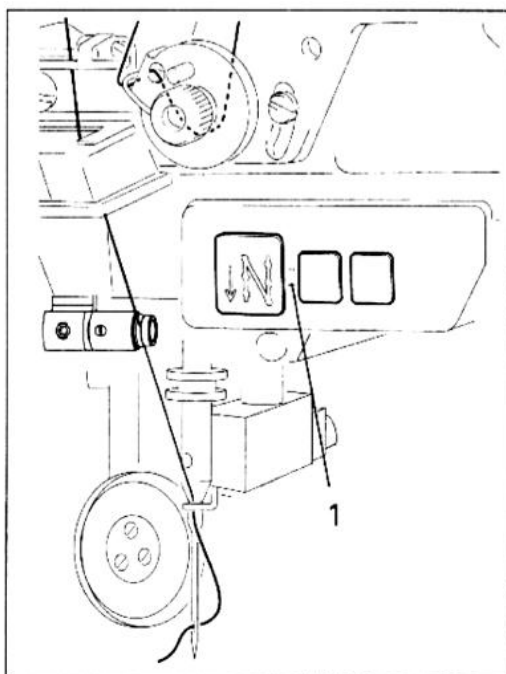


在缝纫过程中，只要按下按键 1，机器的缝纫方向就反转；
按键 2 是用来设置参数的，请详见电控说明书。

As long as key 1 is pressed during sewing ,the machine sews in reverse ;
Keys 2 can be used for parameter settings , Instruction Manual of Electronic Control .

3.02 有线迹计数功能的梭芯线控制器

Bobbin thread monitoring with stitch counting

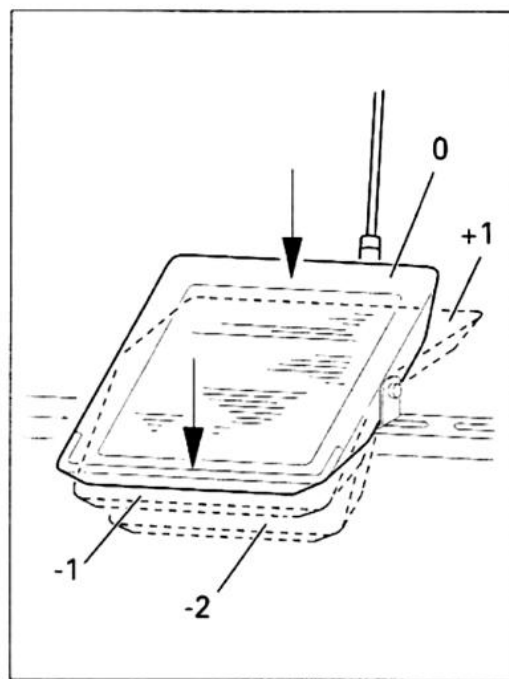


在达到预设线迹数量前大约 100 个线迹，发光二极管 1 开始闪烁；
在剪线后和更换梭芯后，线迹计数器就开始计数。

About 100 stitches before reaching the preset number of stitches , diode 1 flashes ;
After the thread has been trimmed and the bobbin changed , the stitch counting begins anew .

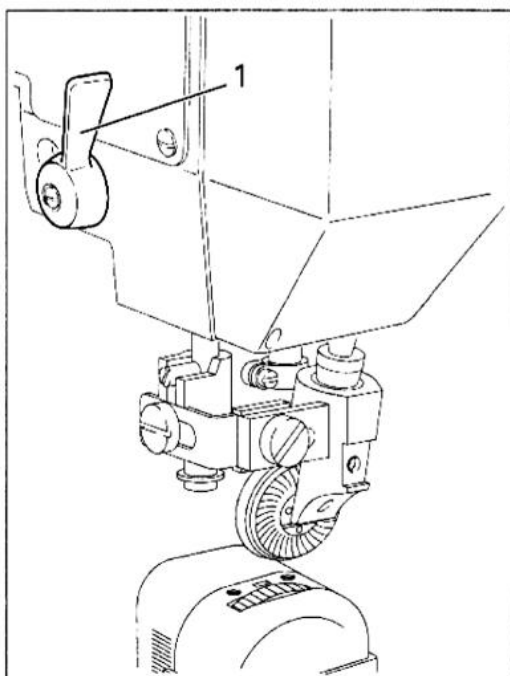
3.03 踏板 Pedal

- 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



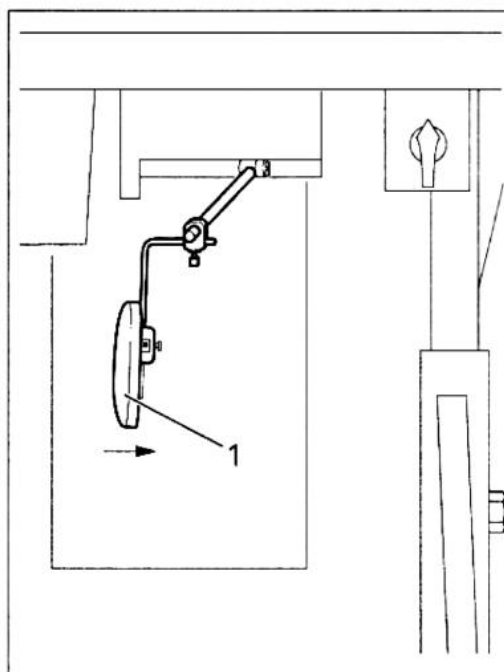
可以通过转动扳手 1 抬起滚轮压脚。

The roller presser can be raised by turning lever 1 .

3.05 膝控 Knee lever

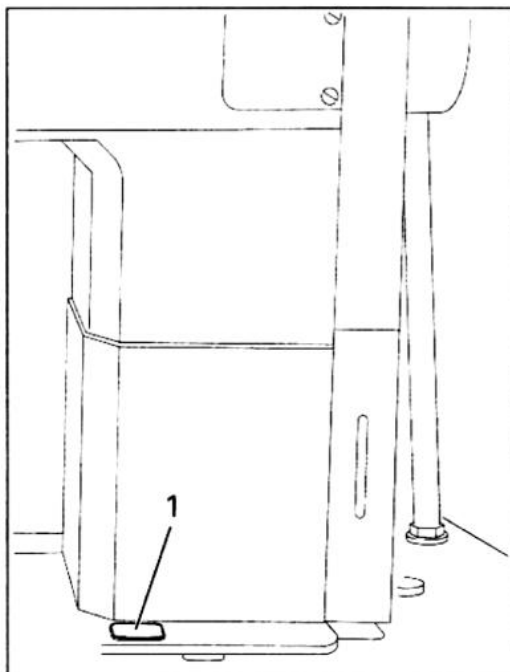
可以通过向箭头所示方向挤压膝控杆 1 来抬起滚轮压脚。

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



3.06 线迹长度设置按键

Key for setting stitch length



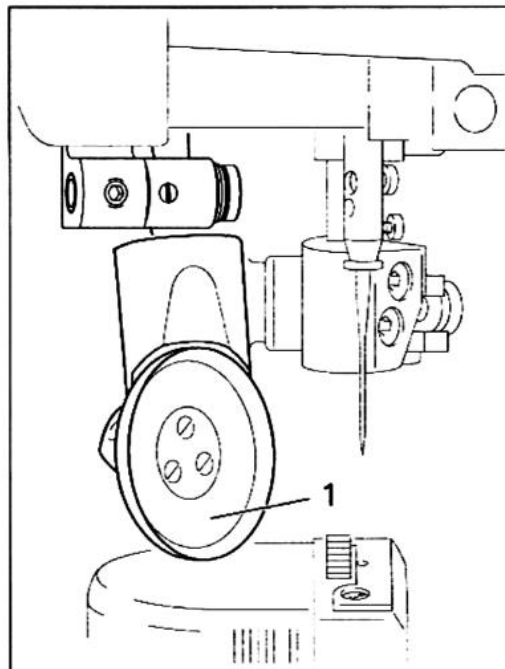
通过按下按键 1 并旋转手轮来设置线迹长度。

The stitch length is set by pressing key 1 and turning the balance wheel.

3.07 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.



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；

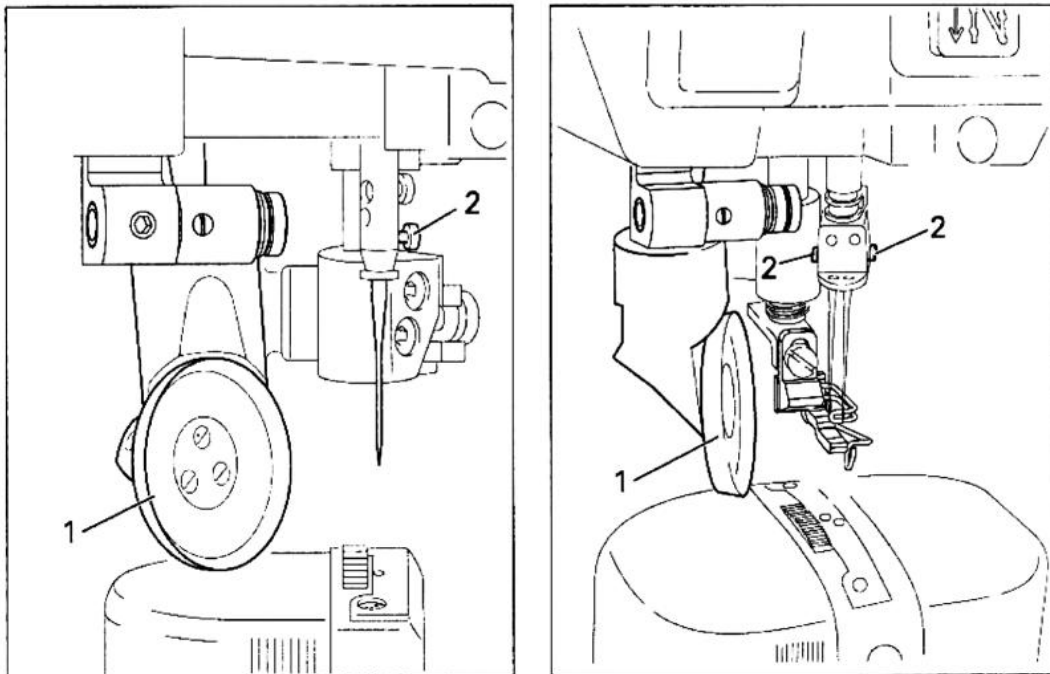
在所有的机器准备工作时，必须通过关闭总开关或者从电源插座上拔出插头，以使机器断电。

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。

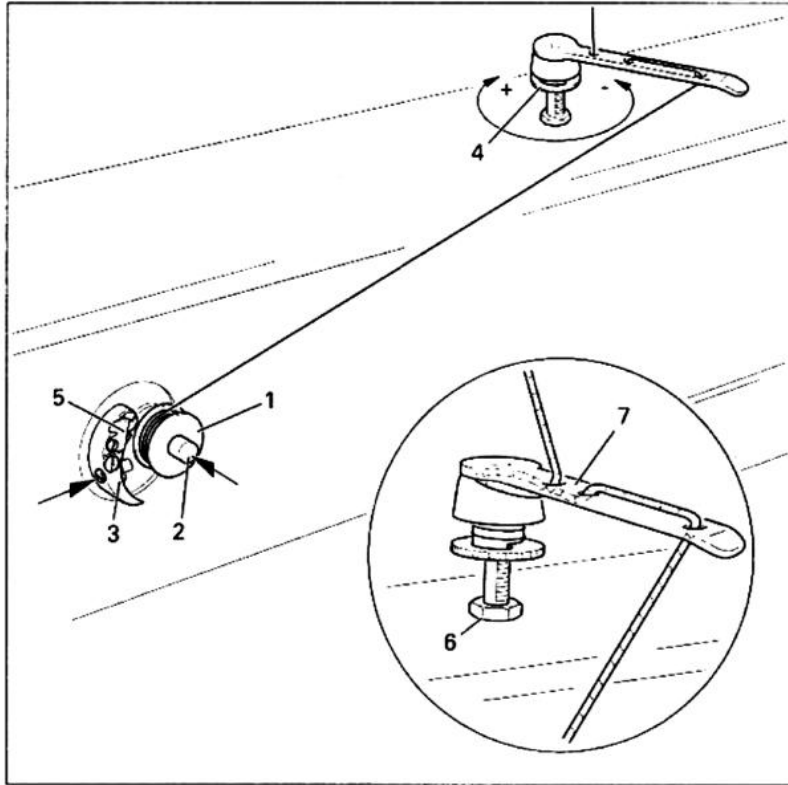
Raise the roller presser 1 and swing it out ;

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;

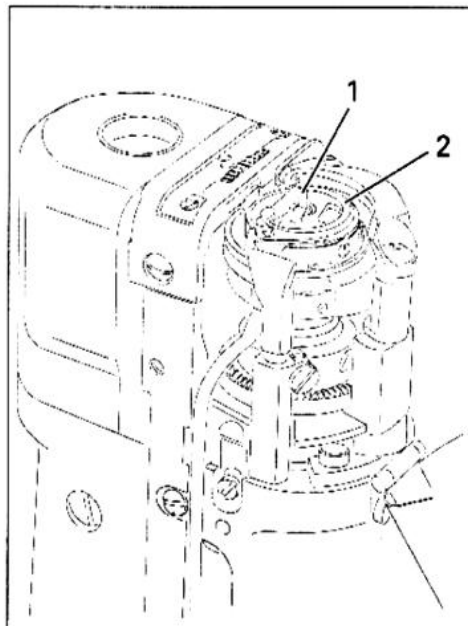
The bobbin winder stops automatically when bobbin 1 is full;

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

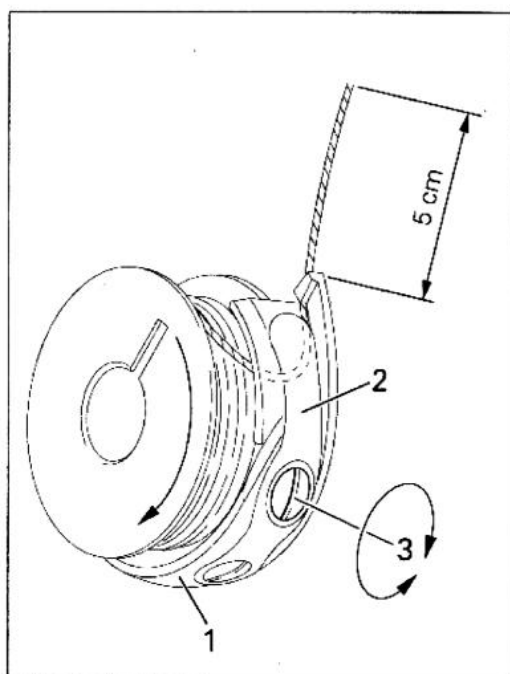
取出梭壳：
打开旋梭盖；
抬起梭门闩 1 并取出梭壳 2 。
装入梭壳：
装入梭壳 2；
关闭梭门闩 1 并重新合上旋梭盖。

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

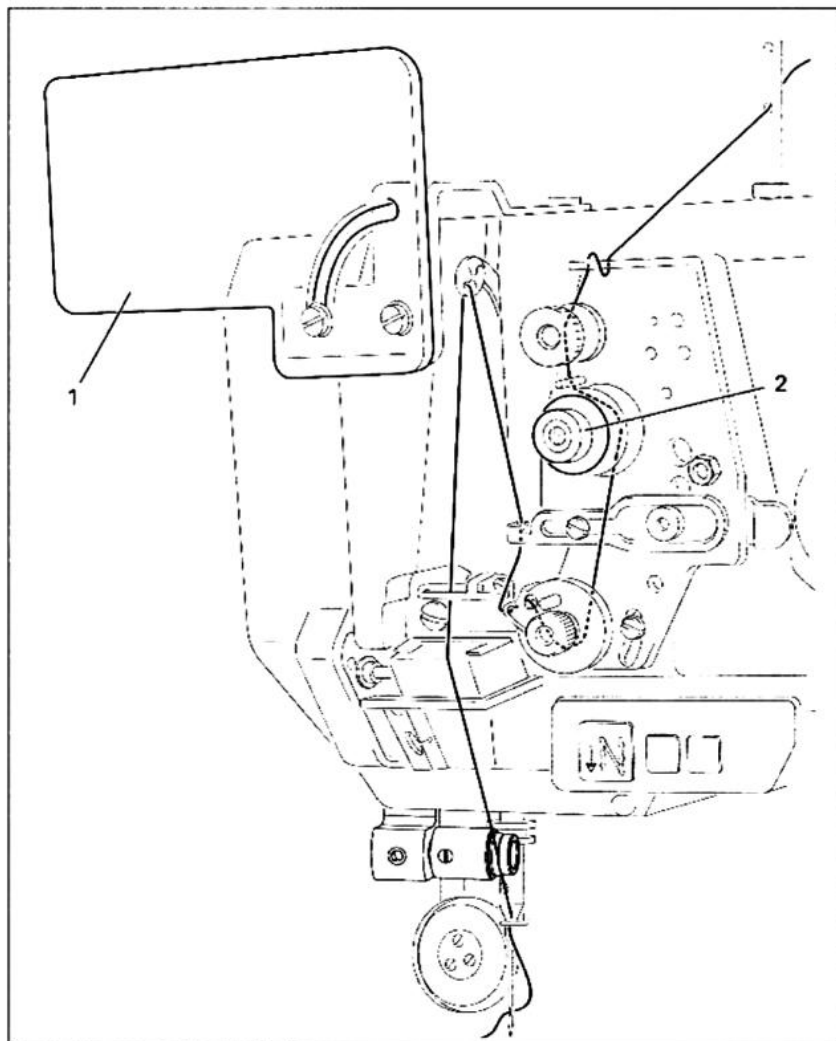


将梭芯装入梭壳 1 中；
将线穿过弹性压板 2 下的狭槽中；
将线穿过凹口处；
通过旋动螺钉 3 调节梭芯线张力。

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.



向上摆动护眼罩 1;

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 2 调节针线的张力。

Tilt up the eye guard 1 ;

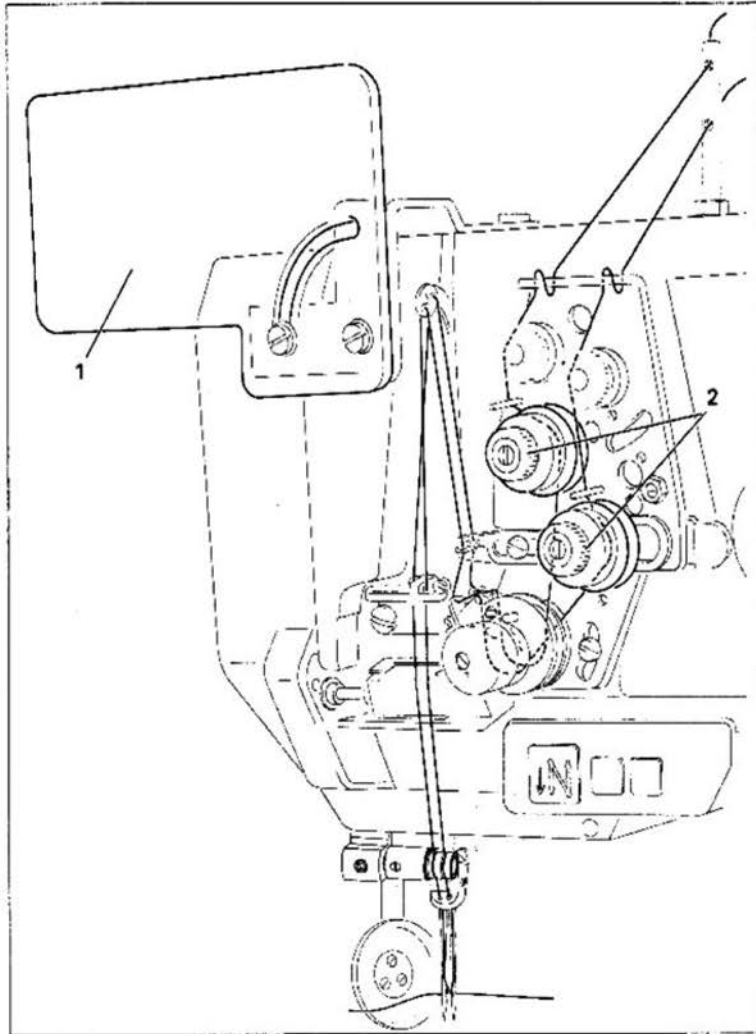
Thread the needle thread as shown in Fig. ;

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 2 .

4.06 双针机型上穿针线并调整针线张力

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



向上摆动护眼罩 1；

如图所示穿两个针线；

在左边的机针上，针线是从右向左穿；而在右边的机针上，针线是从左向右穿；
通过转动滚花螺母 2 调节针线的张力。

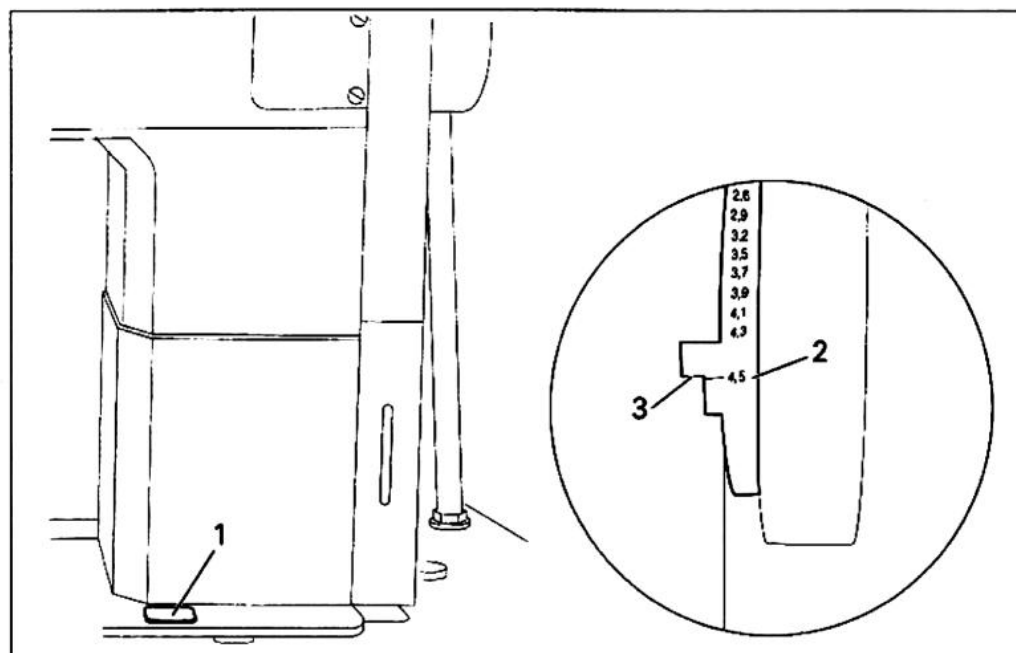
Tilt up the eye guard 1 ;

Thread the needle thread as shown in Fig. ;

The left needle is threaded from the right to the left ,and the right needle from the left to the right;

Adjust the needle thread tension by turning milled nut 2 .

4.07 设置线迹长度 Setting the stitch length



按下键 1 并同时转动手轮直到线迹调节器吻合嵌入定位位置；
保持按下键 1 并来回地转动手轮，直到在刻度盘 2 上所需要设置的线迹长度数字
与皮带护罩凹槽的下边缘 3 处对齐。

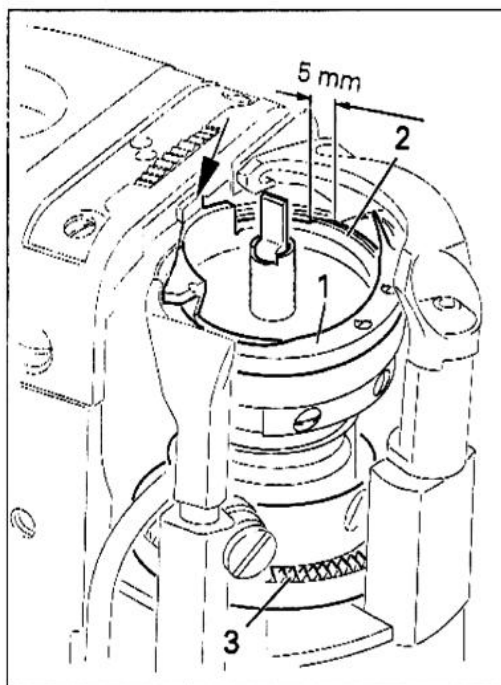
Press key 1 and at the same time turn the balance wheel until the stitch setter clicks
into position ;

Hold down key 1 and turn the balance wheel to and fro until the stitch length
required is shown on the scale 2 opposite the bottom edge 3 of the belt guard
recess .

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；

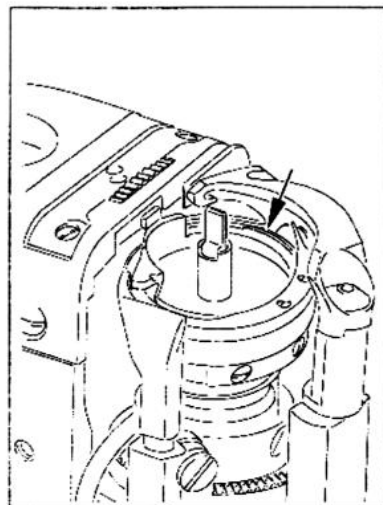
每天注 1-2 滴油到内梭头舌的孔 1 中；

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) .



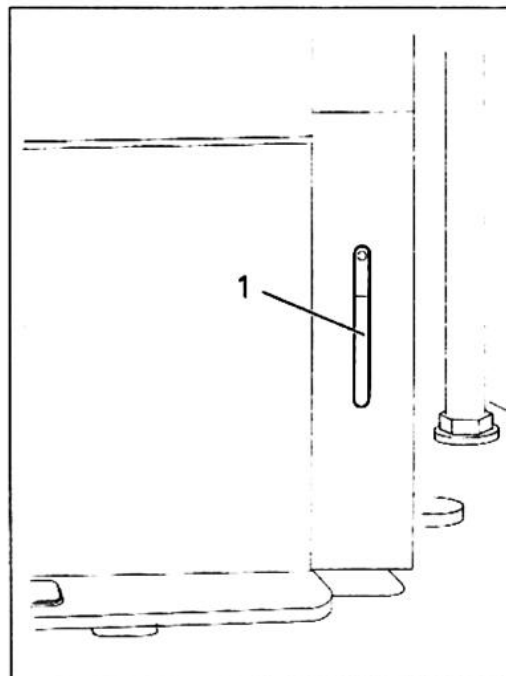
5.03 旋梭润滑油盒 Oil bowl for hook lubrication

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。

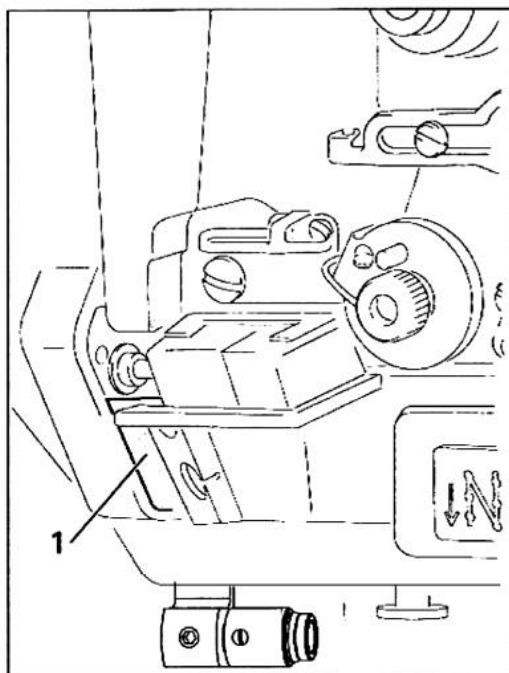
Check the oil level before each use ,there must always be oil in reservoir 1 .If required refill oil through hole.

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 给线润滑系统的油盒加油

Filling the oil reservoir of the thread lubrication unit



在每天开机前检查油量，如有需要，可通过加油孔加油到标记处。
我们推荐使用线润滑油。

Control the oil level before each use .
If necessary ,fill oil up to mark through hole .
We recommend thread lubrication oil .

5.05 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.

如图所示双针机型的伞齿轮副。

涂油脂到齿轮的全部齿侧面（见箭头所示）。

在将机头放回垂直位置时，先向后按翻转保险 1，并用双手将机头放回垂直位置。

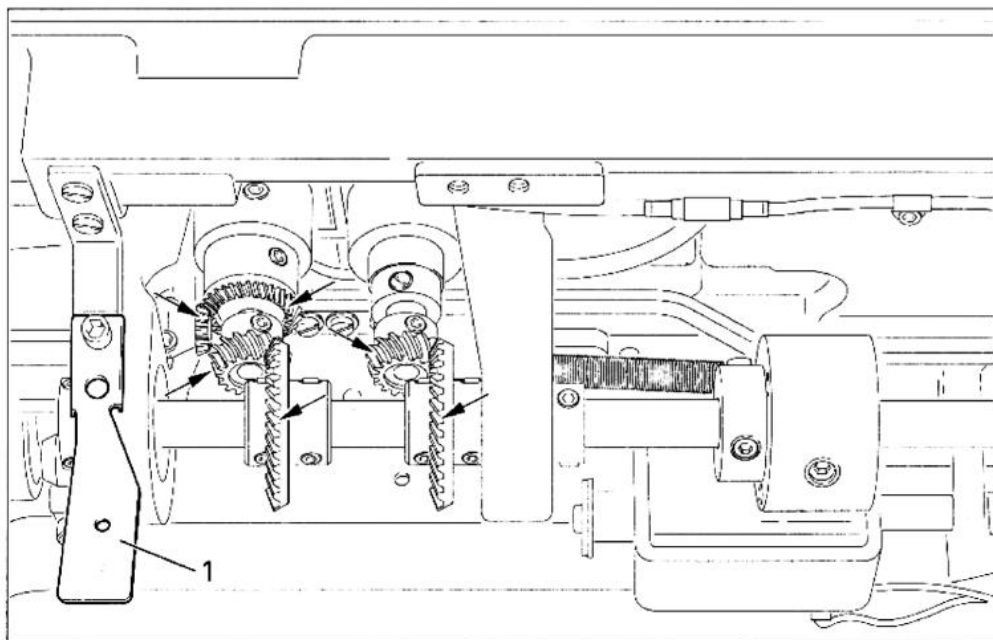
Fig. shows the bevel gears of the double needle machine .

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

To set the sewing head upright , press tilt lock 1 backwards and set the sewing head upright using both hands .

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 !