



Richpeace®
富怡大旋梭多针电脑绗缝机
使用说明书



富怡集团. 天津宝盈电脑机械有限公司

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Richpeace®
Richpeace Computerized Multi-Need
Rotary hook Quilting machine
User's Manual



Richpeace Group Co., Limited

Tianjin Richpeace Computer & Machinery Co., LTD.

Factory Address: No.6 Baozhong Road, Baodi Economic Development Zone,
Tianjin City China

Website: www.richpeace.com

安装说明书
调整及配件
目录

CE 证书
安装注意
安装环境
工作条件
安全注意事项
针梭调整
压脚高度调整
压脚行程调整
雾化加油装置
机头和旋梭润滑
滚珠丝杠润滑
线性轴承润滑
压脚驱动部分润滑

**Instruction Manual For Erecting
adjustments & Spare Parts
Contents**

CE Certificate
Installation Notice
Environment for machine installation
Working condition
Important Safety Note
Needle & Hooks Adjustments
Presser Feet Height Adjustment
Presser Feet Stroke Adjustment
Atomizing Oiling device
Sewing heads and hooks lubrication
Ball screws greasing
Linear bearings greasing
Presser feet drive greasing

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CERTIFICATE OF CONFORMITY

NAME AND ADDRESS OF THE MANUFACTURER: Tianjin Richpeace Computer & Machinery Co., Ltd
No.6, Baozhong Road, Baodi Economy Zone, Tianjin, China.

PRODUCT DESCRIPTION: RICHPEACE Computerized Quilting Machine
TYPE AND MODEL: Series RPQ (refer detailed models are shown on the supplement)

APPLICABLE STANDARDS: ENISO10821:2005+A1:2009
EN60204-31:1998

APPLICABLE EC DIRECTIVE: 2006/42/EC Machinery Directive

TECHNICAL FILE (TCF) REFERENCE NUMBER: CE-C-1104-09-85-01

Based on the voluntary assessment of the product sample and technical file, we certify that the above-mentioned product meets the requirements of the EC directives.

The manufacturer has the responsibility for ensuring that all serial manufacture of the product is in compliance with the specification of the sample submitted for assessment and detailed in the technical file.

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APPROVED / SIGNED BY PRESIDENT
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安装注意

1. 重量

RPCQ-L1500-(25+26)-105(315)-3-2 -- 5838 kg

RPCQ-L1500-32-210(420)-3-1 – 4610kg

CTM2500 通用裁切机 – 2200kg

2.警告：小心起吊和搬运警示。

起重机或叉车可以用来移动和搬运机器。由于计算机控制单元和组装框架式机器的关键组成部分。请特别小心移动和安装。

安装环境

1.应安放在清洁、通风良好的地方，没有阳光直射；有足够的维修空间。

2.将机器安装在牢固的地面上。地板一定要有足够的强度来支撑机器的重量。硬质地面，附近没有显著震动的地方。

3.防止操作环境中的噪声。通过改善车间的隔音功能也可以降低机器操作中的噪声。在车间的装修材料中使用隔音的墙壁、地板和天花板。

4.避免阳光直射。如果机器长时间暴露在直射的阳光下，机体有可能变色或变形。用窗帘或遮光物遮挡阳光，避免直射。

5.

提供足够的维修空间。为了便于维修，机器的周围（右侧、左侧和后部）至少要留出 50cm 的空间。

INSTALLATION NOTICE

1. Gross weight

RPCQ-L1500-(25+26)-105(315)-3-2 -- 5838 kg

RPCQ-L1500-32-210(420)-3-1 – 4610kg

CTM2500 Universal Cutting Machine – 2200kg

2. Caution: Be careful in lifting and handling CAUTION

Crane and forklift can be used to move and carry the machine. Since the computer control unit,the frame assemblies are key modules of the machine, please take special care when move and install them.

ENVIRONMENT FOR MACHINE

INSTALLATION

1. The machine should be installed in clean and drafty place, no sunlight, and there should be enough space around machine for maintenance.

2. Install the machine on a sturdy floor. The floor structure must be strong enough to bear the machine weight (indicated on the spec. plate. If the floor is supported by steel frames, place the machine stand on the beams as long as possible),in the vicinity had no significant source of vibration are also imported.

3. Prevent the operation noise in the environment. To improve the sound insulation performance of the factory in addition to the operation with reduce noise of this machine,use the interior finish materials which show high sound insulating performance for the walls,ceilings and floor of the factory.

4. Avoid direct sunlight.If the machine exposed to direct sunlight over a extended period,the machine body may be discolored or deformend,put curtains or shades to the site to prevent the machine from direct sunlight.

5.Provide enough space for maintenance. For maintenance purpose, provide at least 50 cm clearance around the machine (at the right, left, and back side

工作条件

- 1.环境温度:5 – 40 °C(操作期间);-19 -- 60°C (储存期间)。湿度:30~90%RH (相对湿度)无冷凝。
- 2.电源: AC 380V/50Hz
- 3.避免灰尘和湿气。灰尘和水分,对导致机器的污垢和锈蚀。安装空调设备,并定期清洁工作区域。
谨慎使用空调,不要让风口直接对准机器,避免把绣线吹得凌乱。
- 4.环境和能源影响。本机器不影响环境。工作噪声低于80 db。

安全注意事项

1. 安全

每一台机器都要通过电介质测试,包括绝缘电阻测试和保护接地测试。所有的地线都要连接到PE点。PE点都连接到机器外壳上。因此,机器的每一部分都和大地连接。所有的富怡电脑绗缝机产品都通过了 CE 认证。控制柜和绗缝机都必须正确接地。不要随意插拔和电连接的零件或电缆。当检查和调整机器时,确保关闭主电源。只有经过培训并授权的员工才可以操作和维护这台机器。遇到紧急情况,按下红色“紧急停车”按钮,立即停止机器。

2. 重要的安全说明

操作机器前要密切注意并确保安全。请阅读本手册中的重要安全说明,在你

of the machine).

WORKING CONDITION

1. Ambient temperature: 5 to 40 °C(during operation),-19 to 60°C (during storage). Humidity: 30 to 95%RH (relative humidity) without condensation
- 2.Power supply: AC 380V/50Hz
3. Avoid dust and moisture. Dust and moisture lead to dirt and rust on the machine. Install air conditioning equipment, and periodically clean the working area. Use caution not to expose the machine to direct wind from the air conditioner so that the embroidery threads do not become disheveled.
- 4.The effect of surroundings and energy. No influencing to surroundings. The working noise is less than 80db.

IMPORTANT SAFETY NOTE

1. Safety

Eve machine has passed dielectric testing,insulation resistance testing and protective bonding testing.All of the earth wire link to the PE point.And the PE point link to the machine crust.So the every part of the machine link to the earth. ALL Richpeace computerized quilting products has passed CE certification. Control cabinet and quilting machine must be properly earthed. Don't plug in and out any parts or cable with electricity. When checking or adjusting the machine, make sure turn off the main power supply. Only trained stuff is authorize to Operate and maintain this machine. Machine must be stopped when people working under needles or with any rotating parts. In case of emergency, press the red “emergency stop” button to stop machine immediately.

2. Important safety instructions

Pay close attention to ensure safety before operating the machine. Please read the IMPORTANT SAFETY INSTRUCTIONS in this manual carefully and do not attempt to operate or maintain the machine before you

彻底了解重要安全说明的内容之前，不要操作和维修机器。操作和维修机器时，需要你特别注意警告标志和警示语。为确保安全操作和维修，这些警示内容必须严格遵守。

3. 警示语定义



表明内容：如果不遵守指令，会造成死亡或受伤危险



表明内容：如果不遵守指令，可能会造成死亡或受伤危险！

表示潜在的危險情况，如不能避免，可能导致轻微或中度受伤和财产损失！

4. 禁止内容

这些措施必须谨慎遵守，确保安全操作。详细情况见下面的注释。

5. 针对安全操作的重要安全项

虽然绗缝机不是易燃品，但绗缝材料都是布、面或类似材料；他们都是易燃物。因此，在车间中配置灭火器或消防水龙头是必要的。

thoroughly understand the items listed under IMPORTANT SAFETY INSTRUCTIONS. Items that require your special attention on operation and maintenance of the machine are specified below with the warning symbol and signal word. These items must be strictly observed to ensure safety during operation and maintenance.

3.Signal word definition



Indicates that there is a lot of danger of death or serious injuries if the instructions is not observed.



Indicates that there is a likelihood of death or serious injuries if the instruction is not observed.



Indicates a potential a hazardous situation which, if not avoided, may result in minor or moderate injury or property damage.

4. Prohibited items

Item that must be followed carefully to ensure safety operation. The information which giving details or supplements the explanation appears under NOTE.

5. Important warning items for safe operation

Though quilting machine is not inflammable, but the quilting material is made up by cloth, cotton and so on. They are inflammable material. So hydrants are necessary put in the work shop.



禁止烟火

6. 警示标签和警示牌（重要）

机器设有警告标签，必须依照标签警告安全操作。不要撕下或涂画这些标签。

注意：如果有警示标签丢失或损坏，请联系生产商富怡。

7. 警示标签模板



NO BURNING

6. Warning labels and spec. plate [IMPORTANT]

The machine has warning labels that bear instructions for safe operation. Machine operators must follow the instructions shown on the warning labels. Do not detach these labels, nor make them illegible by painting, etc.

NOTE: if a warning label is missed or damaged, please contact your

Richpeace distributor.

7. Warning label and specification plate



当心触电
Warning electric shock



当心机械伤人
Warning mechanical injury



当心触电
Warning electric shock



当心机械伤人
Warning mechanical injury



当心夹手
Warning hands pinching



当心碰头
Warning overhead obstacle



当心夹手
Warning hands pinching



当心碰头
Warning overhead obstacle

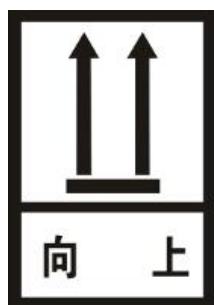


8. 打开包装

当机器交付到客户处时，请确保机器无倾倒反转、包装箱完好！如果没有请让承运人检查损伤并拍照以备将来使用。如果你发现有破损和断裂的地方，请不要做任何事情并马上通知保险公司检查问题。

8. Unpacking

When machine was delivered to customer site,make sure the machine is not inversion the packing material is in good condition,if not,please ask the transporter to check the damage and take photo for future use.If you find something break or



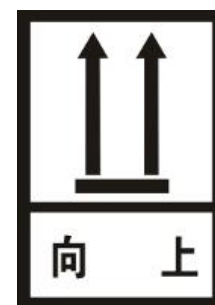
9.检查内容

如果包装完好，请取下装箱单与合同核对。并对着装箱单检查货品。如果有任何问题或疑问，请联系 RP 的经销商或 RP 技术服务人员。

针梭调整

1. 停止机器，选择“设置”按钮，然后点击“刹车”按钮解除刹车。
2. 请确保“选择条”对应的按钮是工作状态绿色；如果不是，需要将红色扭调整到绿色。
3. 取下梭壳和梭芯，面对机针调整。
4. 安装一根新的机针在针杆上。确保机针完全推进到针孔内。检查机针的方向是正确的。拧紧针固定螺钉 [1] 。
5. 转动手轮，让针到达下面的位置。

rupture, please don't do anything and inform the insurer to check the problem.



9.check content

If the packing is good, then tear off the packing list, confirm the packing list with contract, and then check the goods content with packing list. If there's any problem of doubt, please contact RP distributor or RP technician.

Needle & HOOK ADJUSTMENTS

1. Stop the machine and depress the “setting” button and then the “brake” button on the screen.
2. Make sure the “SELECTOR BAR” button corresponding to the bar to be worked on is Green. If not (if it is red), push on this red button to get a green one.
3. Take off the bobbin an bobbin case facing the needle to be controlled.
4. Place a new needle on the needle bar. Make sure the needle is completely pushed inside the needle bar hole. Check the needle orientation is right. Tighten the needle fixation screw [1].
5. Turn the hand wheel to get the needle DOWN position.

6. 将工装[2]插入上针杆导套，确定工装和针杆端头接触：它必须伸出机头端面 8mm。

7. 将带磁座的表盘探针压到工装[2]的顶端。

8. 转动手轮几度在正反方向上，准确的找到底部最下位置（指针指示最小）并停在那儿。

9. 仔细尝试插入工装[3]：它必须进入自由，只是光线和针头接触时把它轻轻取出。

10. 如果不是这样：松开螺钉[4]，调整机针和针杆让针尖和工装[3]有一个“温柔”的接触，注意这时不要让针杆返回，拧紧螺丝[4]。

注意：螺钉[4]可以通过机头盖板的孔进入，不用打开盖板；通畅盖板上有一个孔塞。

11. 取出工装[3]、表盘和工装 2，转动手轮将机针移动到上面位置。

12. 保证机针的安装方向是正确的。如果不对，松开螺钉[1]，重新调整正确并紧固。

重要说明：必须安装上述步骤完成

13. 从机针的最高点，向后（保证机头主轴正向）转动手轮 20°，保证机针到达正确的位置，即针尖到达图示旋梭架表面。松开定位手指的螺钉，足以将定位手指移动到[6]一边。

14. 旋转旋梭壳架开放端接近针板，为旋梭和针留一个清晰的勾线区。

15. 当你慢慢旋转手轮把机针移动到接近下死点的位置时，请一个人保持梭壳不动。操作者的手指 [8]必须呆在梭壳的一端，即远离梭尖路线。

6. Put the “ Needle bar extension [2]” inside the rear needle bar guide, and make sure it is really in contact with the end of the needle bar: it must protrude the sewing head by approximately 8mm only.

7. Fix the “Deep Gauge” with its magnetic foot, as shown on the L2R.RE.3.1 sketch on the opposite page.

8. Turn the hand wheel by a few degrees in both direction to find exactly the needle bottom position (Deep Gauge indicator minimum) and stop there.

9. Carefully try to insert the “needle depth gauge [3]”: It must enter freely, with just a light contact with the needle end when gently pushed to it.

10. If it is not the case (needle too high or too low): loosen the [4] screw, adjust the needle and needle bar high together to get a gentle touch of the needle end on the gauge [3], pay attention do not turn the needle bar while doing this, and tight firmly the [4] screw.

Note: the [4] screw is accessible through a hole in the sewing head cover without taking this cover off: just take the black plug off.

11. Take off the “needle depth gauge [3]”, the Deep Gauge and the “Needle bar extension [2]”, and turn the hand wheel to place again the needles in UP position.

12. Control the needle orientation is right. If not, correct it after loosening the needle fixation screw [1]. Tight again this screw [1].

Important notice: You must install the above steps to complete

13. Starting with needle full up position, turn the hand wheel backwards by 20° approximately, i.e. enough to get the right position of the hooks for the next step, i.e. the position shown on the L2R.RE.3.2 sketch on the opposite page. Loosen the finger position fixation screw enough to be able to push this finger [6] aside.

14. Turn the bobbin holder [7] to place the open side near the sewing plate in order to allow later a clear vision of the hook and needle crossing area.

15. Ask to someone to hold the bobbin case while you turn SLOWLY the hand wheel up to place the needles near their bottom dead position. The

梭壳架必须保持开放的一面在针板侧，以确保良好的视野给这个区域。
如果你在下针的时候，梭壳架没有照顾好而可以自由的旋转，那么针尖很有可能伤害到梭壳架。

16. 当机针到达最低点时，将工装[2]插入上针杆导套，确定工装和针杆端头接触：它必须伸出机头端面 8mm。

17. 将带磁座的表盘探针压到工装[2]的顶端。

18. 转动手轮几度在正反方向上，准确的找到底部最下位置（指针指示最小）并停在那儿。将刻度盘零位对应到针尖位置。

19. 按缝纫正向，慢慢旋转手轮；当看到针杆已经向上移动了正好 3mm 时停下来。如果你移动的太多，需要重新正向旋转并重新到达 3mm 回程的位置上。
得到的这个位置至关重要，是旋梭勾线和调整的最佳位置。

20. 检查梭尖和针的位置

在机针和梭尖之间必须保持 0.05~0.1mm 的空间，并且梭尖必须超出机针 0.1~0.2mm。

如果不是这样，轻微松开螺钉[9]，使旋梭在轴心上能够平顺的转动。如上述，将针移动到正确的位置并紧固螺钉[9]。

仔细检查针和梭的位置！

21. 转动手轮是机针到达最高点，然后回转 20°；即到达勾线位置

22. 紧固螺钉[5]。

operator's fingers [8] must stay on the side of the bobbin case, i.e. away from the hook sharp tip route. The bobbin case holder must stay with its largely open side oriented to the sewing plate to insure a good vision to this area. Take care also that if the bobbin case is let free to turn while you move the needle down, the needle end will almost certainly hurt it.

16. When the needle are near their full down position: put the "Needle bar extension [2]" inside the needle bar guide, and make sure it is really in contact with the end of the needle bar: it must protrude the sewing head by approximately 8mm only.

17. Fix the "Deep Gauge" with its magnetic foot, as shown on the L2R.RE.3.1 sketch on the previous pages.

18. Turn the hand wheel by a few degrees in both direction to find exactly the needle bottom position (Deep Gauge indicator minimum) and stop there. Turn the Deep Gauge clock to place the zero on the gauge needle end.

19. Turn the hand wheel slowly in direct sewing direction, while looking at the deep gauge clock, and stop when the needle bar has been moved up by exactly 3mm. If you moved it a little too much, you may turn backwards, and reach again the 3mm in the direct direction.

Get this position exactly is essential for a good hook position and adjustment.

20. Check the hook tip / needle position

You must have between 0.05 and 0.1mm air between hook and needle, and the hook tip itself must protrude by 0.1 or 0.2 mm above the needle itself.

If it is not the case, loosen the [9] screw slightly, to get a smooth side of the hook on its axle, adjust it according to the needle as explained above, and tighten the [9] screw firmly.

Double-check the needle and hook position.

21. Turn the hand wheel to get the needle full up position, and then backwards by 20° approximately, i.e. enough to get the right position of the hook.

22. Tighten the accessible screw [5] very firmly.

23. 旋转梭壳架到正常的位置，并将定位手指放回左侧并紧固螺钉；需要在定位手指和梭壳架豁口之间保留 0.5mm 的间隙。上下推动定位手指确保定位头和旋梭有一个最大间隙。确保在安全的梭壳架保持位置和线之间得到一个很好的线环。定位手指的螺钉必须拧紧。

24. 仔细检查定位手指和旋梭间 0.5mm 的间隙。并检查定位手指和旋梭外缘是否干涉。

25. 取下表盘和工装 [2]，旋转手轮将针回到高点位置。

26. 放回梭壳。

27. 给针重新穿线。

28. 复位“选择”按钮到合适的位置，即工作按钮必须是绿色，不工作必须是红色。

29. 当你准备重新启动机器时，按下“设置”按钮。

压脚高度调整

1. 保持杆位置

确保压脚和压脚杆完全贴合，如果有必要需要松开螺钉[1]调整。控制压脚和针板之间的距离，它必须是 5mm。机针要对着压脚孔的中心。如果需要调整，松开螺钉[2]调整到正确的位置。

2. 压脚高度调整

a). 旋转手轮到机针最高位，倒转 15°；即：压脚的最高位。

23. Turn the Bobbin case holder to its normal position and the finger also back on the left and tighten its fixation screw, while you hold the 0.5mm spacer between the finger and bobbin case holder slot. The finger must also be pushed vertically to insure a maximum clearance between the finger base and the rotating hook. The air distance between the finger retainer and the bobbin case holder must be 0.5mm. To get a safe bobbin case holder position and a free thread escapement. The finger screw must be tighten very firmly.

24. Double-check the 0.5mm clearance between finger end and hook, and the clearance between finger base and hook outside diameter.

25. Take off the Deep Gauge and the “Needle bar extension [2]”, and turn the hand wheel to place again the needles in Up position.

26. Put back the bobbin case in its place.

27. Re-thread the needle.

28. Reset the “SELECTOR BAR” buttons to return their proper position i.e. the working bars buttons must be green and the eventual non-working one must be red.

29. Depress the “SETTING” button only when you are ready to start again the machines.

PRESSER FEET HEIGHT ADJUSTMENT

1. Position on the holding bar

Make sure the pressure feet are completely pushed in the presser feet bars. Improve if necessary after loosing the [1] foot fixation screw. Control the distance “d” between presser foot and clamp: it must equal 5mm. Control that the pressure foot central hole is perfectly centered on the needle. Improve if necessary after loosing the [2] clamp fixation screw.

2. Individual presser foot height adjustment

a). Turn the hand wheel to get the needle full up position, and then backwards by 15° approximately, i.e. enough to move the presser feet themselves at

b).检查压脚和针板之间的距离 d。如果压脚位置错误大，调整 35mm 摇臂轴到正确位置，注意：不要按[3]所示做轴向旋转。紧固两个 M6 螺钉[4]。

3.球型压脚高度调整

这种调整是必要的，尤其当填充辅料的厚度发生变化时。做厚的或硬质辅料时，压脚不要太低；避免压脚冲击过大。也不要太高，避免压脚和针杆碰撞。压脚高度必须控制在合适的位置上。

a)转到手轮，让压脚到达它的最高位置。15°左右，即足以移动所述压脚本身在其全部向上的位置。d 值必须调整的情况：最轻的辅料（不超过 150 g/m²），6mm 最小；厚料时，最大 11mm。

b)调整所有的压脚，需要做的 4 个步骤：

上针梁左端

上针梁右端

下针梁左端

下针梁右端

c) 每半排

松开锁在摇臂上的两个 M6 螺钉[5]。

将 35mm 轴、摇臂、压脚得到正确的 d 位置。

调整摇臂的端面和 35 轴的尾部平齐。拧紧两个 M6 螺钉[5]。

d)控制和调整压脚板到 16mm 的距离。

压脚行程调整

压脚动态行程调整好后，通常在机器出厂后是不必再调整的。

their full up position.

b).Check the distance “d” between the presser foot and the sewing plate. If some presser feet are wrong compared to the majority, correct the position of 35mm rocking shaft, and moving the lever on the shaft. Pay attention not to move the lever [3] along the shaft not to modify the necessary driving rod play. Tight the two [4] M6 screws.

3. Global presser foot height adjustment

This adjustment is necessary when a major change in wadding thicknesses occurs.It is essential that the presser feet are adjusted: Not too low with thick or hard wadding, to avoid overload in the mechanism. Not too high to avoid collision with needle bar going down. The presser foot height must be controlled at their up position.

a)Turn the hand wheel height must be controlled at their up position: by 15° approximately, i.e. enough to move the presser feet themselves at their full up position. The distance “d” must be adjust at:6mm minimum for very fine wadding (up to 150 g/m²)11mm maximum for the thickest wadding

b)To modify all the presser feet, you have to do that in 4 steps:

Left side, upper needle row

Right side, upper needle row

Left side, lower needle row

Right side, lower needle row

c)For each half row:

Loosen the two [5] M6 screws fixing the main lever on the 35mm shaft.

Control that the main lever is always flush with the end of the 35mm shaft.

Tighten the two [5] M6 screws fixing the main lever on the 35mm shaft.

d)Control and adjust the skis [6] to get the 16mm distance.

PRESSER FEET STROKE ADJUSTMENT

The presser feet dynamic stroke is adjusted before the machines leaves the

下列说明唯一的用处：是在机器出现损伤和需要修复压脚机构的情况下。

按顺序调整所有的 4 个压脚机构：

上针梁左端

上针梁右端

下针梁左端

下针梁右端

1. 准确的测量压脚行程，即在高点和低点高度的区别。这个动态行程必须不超过 4mm。在另一端，最好的缝纫结果是动态行程在 3 到 4mm 之间。

2. 修改动态行程

a) 控制的实际行程和位置，决定于 [1] 和实际高点位置；调整得到 4mm 行程。明白了这点，低点位置就不会发生变化了。

b) 打开针梁盖板，看到驱动机构。

c) 松开 M8 螺钉 [1]，旋转在 25mm 轴上的连接杆，不要轴向移动它。向上得到高位的正确压脚位置。拧紧 M8 螺钉 [1]。复查压脚行程不超过 4mm。

雾化加油装置

factory and must normally not be modified later.

The following instructions are therefore only valuable in case of unexpected damage and repair of the presser feet mechanism.

The procedure must be applied successively on all presser-feet sections:

Remind that the machine has 4 independent presser feet mechanisms:

Left side, upper needle row

Right side, upper needle row

Left side, lower needle row

Right side, lower needle row

1. Measure precisely the presser foot dynamic stroke, i.e. the difference in high between its lower and upper position: This dynamic stroke must not exceed 4mm. On the other end, best sewing results are obtained with dynamic stroke comprised between 3 and 4mm.

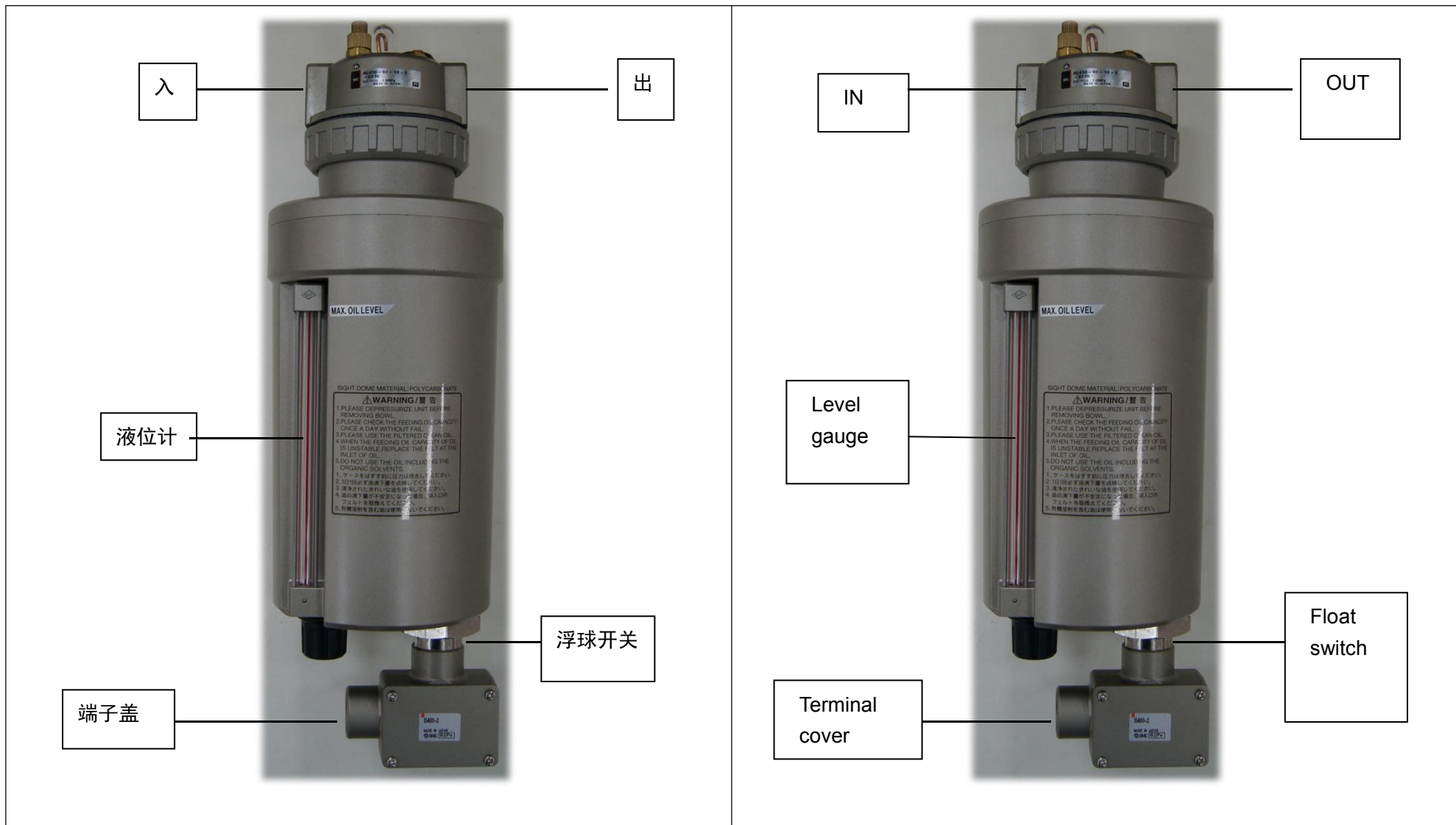
2. To modify the dynamic stroke:

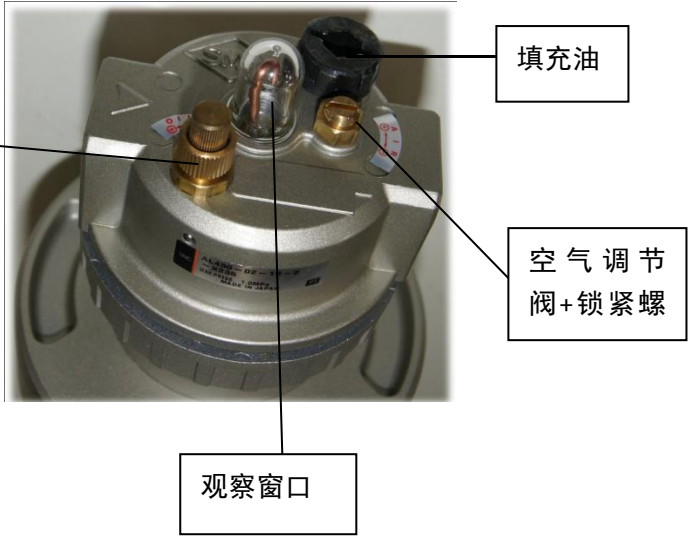
a) Control the actual stroke and position according to 1 and calculate the exact upper position needed to get 4mm stroke, knowing that in the explained procedure, the lower position will not change

b) Open the front needle frame covers, to reach the driving mechanism.

c) Loosen the [1] M8 screw head, and turn the lever on the 25mm shaft end without moving it along the shaft, up to get the right (upper position) of the presser feet. Tighten the [1] M8 screw head Recheck the presser stroke obtained does not exceed 4mm.

Atomizing oiling device





油量调节阀
+锁紧螺母

填充油

空气调节阀
+锁紧螺母

观察窗口

机头和旋梭润滑

1.空气过滤器

空气过滤器每天必须清空，在炎热和潮湿的时段更是必要的。

2. 缝纫机头和旋梭

缝纫机头和旋梭供油是通过两个独立分开的管道，通过雾化喷油机构实现。

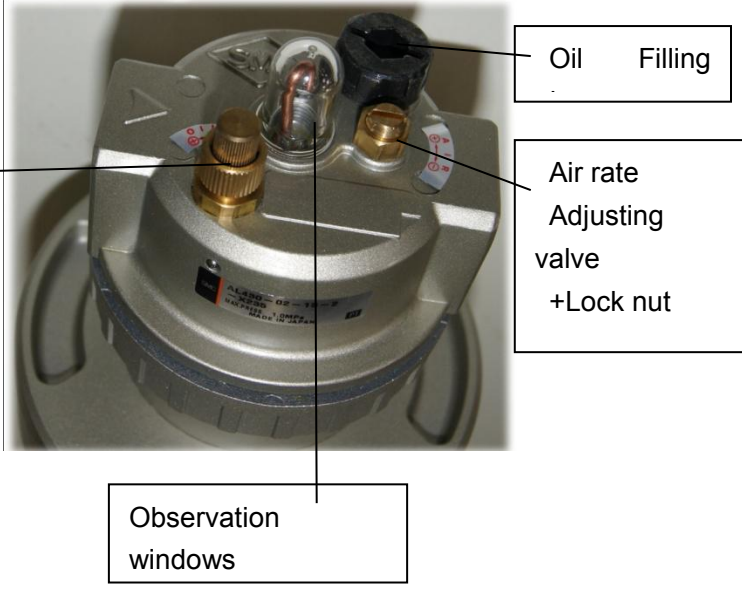
喷油的频率通过电控控制，工作一段时间，提供 15 秒的喷油。

油量调整在油泵顶部。

调整油流，以便清楚的看到每秒喷射一滴。油流和油位每天检查一次。
机器磨合过后，工作约 48 小时油泵会空。

机器正常停止，空气压力下降，油液位会下降。指示灯会显示在控制面板上。

给油泵加白色凡士林油，不含粘稠的添加剂或溶剂。加满油时，油液高度



Oil rate
Adjusting
valve
+Lock
nut

Oil Filling

Air rate
Adjusting
valve
+Lock nut

Observation
windows

SEWING HEADS AND HOOKS LUBRICATION

1.AIR FILTER

The filter placed on air input must be emptied every morning and more often if necessary (during hot and wet weather periods)

2.SEWING HEADS AND HOOKS

Sewing heads and hooks are oiled by two independent distribution pipes, which injects oil mist inside the mechanisms.

The injection frequency is controlled by the computer, During running-in period, it delivers 15 seconds injections

The oil flow is adjusted on the top of the oil reservoir itself.

Adjust oil flow in order to effectively see 1 drop of oil falling each second during injections. Oil flow and oil level must be checked at least once each day.

Once the machine has been run-in, the oiler reservoir empties after 48 hours running time approximately.

到刻度标识顶端距离 20mm。

滚珠丝杠润滑

所有的润滑和维护操作前，必须是电源已经断开或者至少有一个紧急停止按钮被按下。

滚珠丝杠保养

两个滚珠丝杠必须定期清洁，至少每工作 24 小时要清洁一次。在机器运输之前也要做这样的保养用干净的棉类织物，清除丝杠表面的脏物。

积累的灰尘会进入螺母中并很快的损害它。

两个滚珠丝杠螺母必须保持良好的润滑。

每工作 40 个小时（一周）加油一次

每一个月加油一次。用油枪，加润滑脂“黄油”。

线性轴承润滑

所有的润滑和维护操作前，必须是电源已经断开或者至少有一个紧急停止按钮被按下。

线性轴承的保养

线性轴承必须定期清洁，至少每工作 24 小时要清洁一次。在机器运输之前

The machine normally stops automatically in case of air pressure drop, and in case of oil level drop. Indicators light up on the main panel.

Fill the oil reservoir up exclusively with Pure White Vaseline oil (liquid paraffin) without solvent nor additives-viscosity 190 VG 15 (15cst = 15mm²/s)

BALL SCREWS GREASING

ALL GREASING AND MAINTENANCE OPERATIONS MUST IMPERATIVELY BE MADE ONLY AFTER POWER HAS BEEN CUTTED OFF AND AT LEAST ONE EMERGENCY BUTTON BEEN DEPRESSED
BALL SCREW MINTENANCE

The 2 ball screws must be cleaned periodically, at least once each 24 hours of running time AND ALSO BEFORE ANY CHANGE IN CARRIAGE STROKE: Use a clean cotton fabric, to extract call mineral and textile dust.

Accumulation of dust may be pushed inside the ball mechanisms and destroy them quickly.

The 2 ball screws must be lubricated exclusively with the pump and the grease supplied with the machine:

①+② Add some grease each 40 hours of running time (one week when working a single shift pattern).

③+④ Grease once a month (inside the left frame body) 。 Grease gun , grease " butter"

LINEAR BEARINGS GREASING

ALL GREASING AND MAINTENANCE OPERATIONS MUST IMPERATIVELY BE MADE ONLY AFTER POWER HAS BEEN CUTTED OFF AND AT LEAST ONE EMERGENCY BUTTON BEEN DEPRESSED.

LINEAR BEARINGS MAINTENANCE

The linear bearings must be cleaned periodically, at least once each 24

也要做这样的保养，用干净的棉类织物，清除丝杠表面的赃物。

积累的灰尘会进入螺母中并很快的损害它。

线性轴承要保持良好的润滑。

每工作 40 小时（一个月）加油一次。从滑块侧面注入白油。

压脚驱动部分润滑

所有的润滑和维护操作前，必须是电源已经断开或者至少有一个紧急停止按钮被按下。

1. 每日加油

所有和机头连接的压脚机构必须每日加白色的凡士林油。

每个机头有三点需要加油

- a) 连杆后端
- b) 连杆前端
- c) 压脚杆衬套

2. 每月加油

所有的连杆每工作 500 小时必须加油一次（两班制工作，每月一次）

有四个连接杆，两端连接着关节轴承。注意：每个连接杆有两个关节轴承。

有四个连接杆在针梁内部。

保证这些轴承的润滑，必要的需要打开针梁的端盖。4 个连接杆共有 8 个

hours of running time AND ALSO BEFORE ANY CHANGE IN CARRIAGE STROKE: Use a clean cotton fabric, to extract all mineral and textile dust. Accumulation of dust may be pushed inside the ball mechanisms and destroy them quickly.

The Linear ball bearings must be lubricated exclusively with the pump and the grease supplied with the machine:

Add some grease each 40 hours (one week) of running time. White oil injected from the side of the slider.

PRESSER FEET DRIVE GREASING

ALL GREASING AND MAINTENANCE OPERATIONS MUST IMPERATIVELY BE MADE ONLY AFTER POWER HAS BEEN CUTTED OFF AND AT LEAST ONE EMERGENCY BUTTON BEEN DEPRESSESSED

1. DAILY OILING

All the presser feet mechanisms attached to the sewing heads must be oiled daily with pure white Vaseline oil.

On each head, there is 3 points to be oiled:

- a) Connecting rod back end
- b) Connecting rod front end
- c) Presser foot bar bushing

2. MONTHLY GREASING

All the connecting rods must be greased each 500 hours of running type (each month when working a two shifts pattern)

There is 4 connecting rods connected to the eccenters, and situated in the side bodies – Caution: each connecting rod has 2 ball bearings (points 4 and 5)

There is also 4 connecting rods situated inside the needle beams.

To reach them, it is necessary to come apart the covers placed at the front

关节轴承。

of the beams. Again, there is 4 connecting rods, i.e. 8 bearings (points 6 and 7)