

SEWSTRONG F007 系 列
Series

高速绷缝机

**HIGH-SPEED STRETCH
SEWING MACHINE**

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安装

INSTALLATION

1. 依本机器附有台板裁制图及零件组合图所列之配件, 依序安装防震机座、线架等。(及废料槽 -FR 机种)
2. 马达之转向为顺时针方向, 皮带之松紧度以用手指向内压下2cm为宜, 同时为了安全起见, 请将皮带防护罩盖上, 并旋紧螺钉。(图2)
3. 皮带轮与缝纫速度参照表1。

1. Before installing machine, please refer to table cut-out drawing, and the necessary attachment as enclosed, according to the sequence of installation, to fix cushion base, thread stand, (and the cloth waste chute for FR model)
2. Be sure that the motor turning direction is clockwise, and the motor belt tension can be pressed with finger inward about 2cm. For safety reason, please fasten the belt cover. (Fig 2)
3. Regarding machine speed and motor pulley diameter, please refer to Table 1.

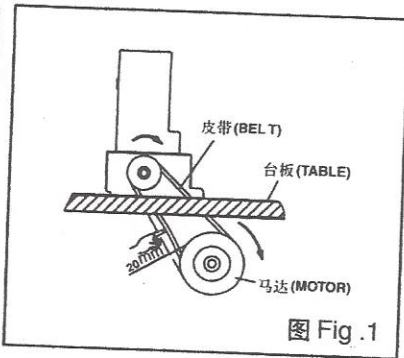


图 Fig. 1

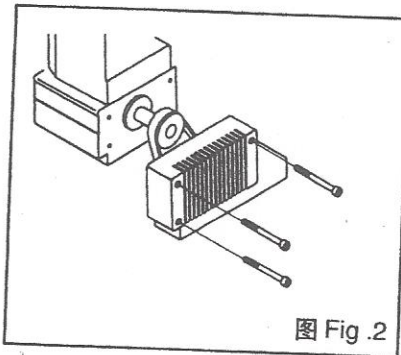


图 Fig. 2

S.P.M 转速	MOTOR PULLEY SIZE 皮带轮尺寸		BELT 皮带 尺寸
	60HZ	50HZ	
6000	105	125	36"
5500	95	115	↑ 35"
5000	85	105	↓ 35"
4500	80	90	↓ 34"
4000	70	85	↓ 34"

注意:

1. 使用新机器最初一个月运转速度约为最高转速的80%, 并请选择正确的马达带轮尺寸(如表1)。

2. 台板厚度约50mm。

Remarks:

1. During the first month of using the machine, the maximum speed shouldn't exceed 80% of the speed listed in Table 1. Make sure to choose the correct size of motor pulley.

2. The standard thickness of Table is about 50mm.

马达与皮带

MOTOR AND BELT

1. 离合器马达1/2马力(或400瓦), 3相2极M番V型皮带。

1. Clutch Motor, 1/2HP(400W), 3 phase, 2 pole M type V belt.

2. 马达的安装位置必须是机器皮带轮与马达皮带轮的中线必须一直线。

2. The center line of both motor's and machine's pulley must be aligned each other, when installing the motor.

润滑

LUBRICATION

1. 请选用 MOBIL #10 或 ESSO #32 或同级的润滑油。
2. 由于新机器在装运前已将油倒尽, 因此新机器在使用前必须注入新油。转开上盖喷油窗(A)将油注入机器中, 待油量满至油标指示上下线之间即可。(图 3、4)
3. 每天必须检视, 如果油已低于油标指示窗之下限, 必须加注新油, 当机器开始运转, 操用前, 检视必须整个润滑系统是否畅顺。

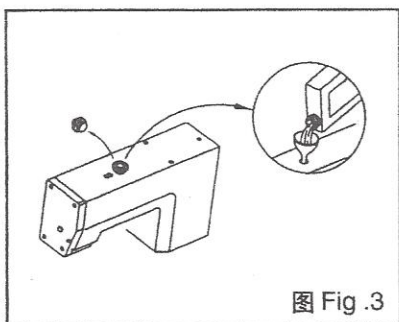


图 Fig .3

* 新机器或久未使用的机器重新使用时, 请先在针杆上下部加油润滑。

1. Please oil Mobil #10 or Esso #32 or its equivalent.
2. The lubricating oil has been drained from the machine before delivery, to remove screw (A), and fill the oil until the oil level reaches between lines H and L of oil level gauge. (Fig. 3, 4)
3. Be sure to check every day and refill the oil, if oil level is lower than line L of oil level gauge. When you begin operating the machine. Please check whether all the lubricating system is at normal condition.

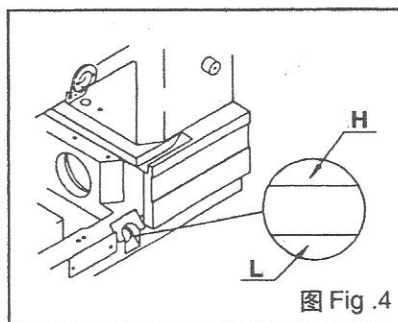


图 Fig .4

* Before starting a brand-new machine or a machine which has not been used for more than a couple of week, oiling the needle bar.

润滑油更换

HOW TO CHANGE OIL

1. 将螺丝(D)松开, 使油槽之油完全排出后再锁紧。(图 5)
2. 为延长本机器寿命, 请于开始使用四星期更新油, 尔后约每四个月更换一次。

1. Loosen Screw (1), drain all the oil from the tank, then fasten the screw. (Fig 5)
2. For extending the life of the machine, change oil after the initial 4-week operation. After that, change oil every four months.

滤油器更换

HOW TO CHANGE OIL FILTER

本机器特别装有滤油器, 约每使用一个月后应卸下清洗, 必要时得换新品。(图 6)

This machine is equipped with an oil filter, and the filter must be cleaned every month, replace the filter if necessary. (Fig 6)

机针与线冷却润滑

LUBRICATE AND THE LOOLING OF NEEDLES AND THREADS

使用硅油满(1)(2)油槽以防止断线。(图 7)

Fill reservoir (1) and (2) with silicone oil to prevent the thread from breaking.(Fig 7)

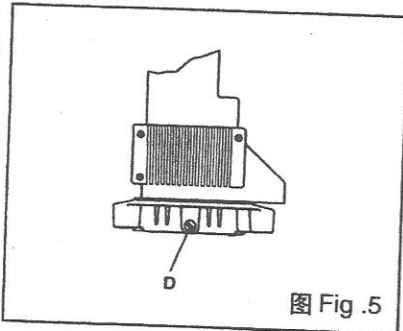


图 Fig .5

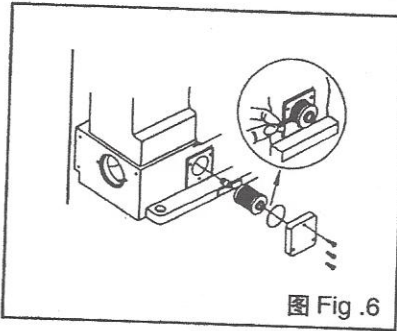


图 Fig .6

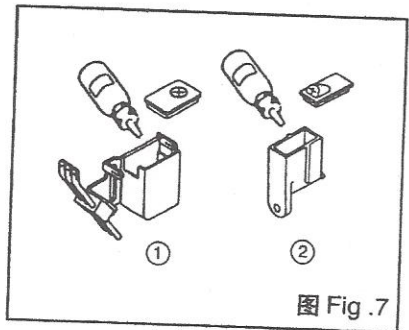


图 Fig .7

机针更换

HOW TO REPLACE THE NEEDLES

1. 选用机针的规格与尺寸请参照(表 2)

1. See Table 2 of the sizes and the specifications of the needles.

2. 旋转螺丝(1)并取下针, 将新针插至针座最底端, 并使针之长沟面向自己。(图 8)

2. Loosen Screw (1), then pull out the used needles. Insert the new needles into the holder holes as far as they can go, and let the long groove of the needle face you.(Fig 8)

3. 重新锁紧螺丝(1)。

3. Fasten Screw (1)

Table (表 2)		
Needle System 针代号	Needle Size/ 针尺寸	
	2 Needles	3 Needles
SCHMETZ UY128GAS	#70	#75
ORGAN 128GAS	#10	#11

* 特殊机种针的代号请参考规格表。

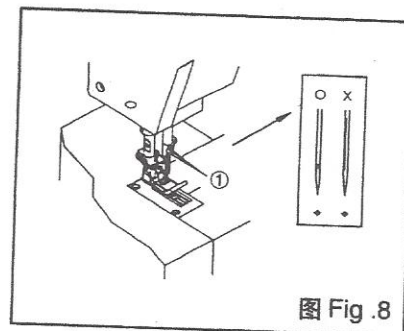


图 Fig .8

*Needle size of special model, please refer to conversion chart.

穿线方法

THREADING

应按照不同缝合情况穿线,错误的穿线方法将引起断线、跳针或缝样不平等现象。必须参照第七页穿线图。

Follow the procedures shown in (Fig 9)for threading. Wrong threading may cause thread breaking, skipping stitch, puckering or unexpected sewing .Please refer to Page 7.

压线松紧度调整

ADJUSTING THREAD TENSION

线的拉力强度必须根据缝料的材质厚薄。线与针距不同而调整,将调节旋钮(1)顺时针方向旋转,线压的越紧;向逆时针方向旋转,线压力越轻。(图 10)

The tension of the thread should be adjusted according to:

- 1.The material and the thickness of the fabric being sewed;
- 2.The thread;
- 3.The needle gauge.

If you turn thread tension knob clockwise,thread will be tighter.(Fig 10)

If you turn it counter-clockwise,will be looser.

针线挑线杆调整

ADJUSTING NEEDLE THREAD TAKE-UP

- 1.转动手轮使针杆下降至最低位置时,挑线杆座(1)的上边必须成水平,必要时放松螺钉(4)调整之。(图 11)

- 1.When the needle bar is in the lowest position,z,the top edge of the Needle Thread Take-up should remain horizontal.To adjust the position of the Take-up,loosen the Screw (4) first.(Fig 11)

- 2.将螺钉(2)松开,调整 A B 两点的距离约 75mm 再锁紧。

- 2.Loosen Screw (2)and adjust the length between point A and B to about 75mm,then fasten Screw (2) tightly.

注:

欲将针线调松时,将挑线杆(3)向左边方向移动。

欲将针线调紧时,将挑线杆(3)向右边方向移动。

Note:

To loosen the Needle Thread,turn the Needle Thread Take Up (3) toward the left.To tighten turn it toward the right.

- 3.上叉挑线杆(5)不要调动。

- 3.Do not move the Spreader Thread Take-up (5) when making above adjustments.

上叉挑线杆调整

ADJUSTING SPREADER THREAD TAKE-UP

- 1.当上叉挑线杆(1)摆至最高点时,张线杆(2)上的小孔(A)必须与张线杆(1)上之长沟底同高。

- 1.When the Spreader Thread Take-up (1) is adjusted to the top ,the small hole (A) of the other Spreader Thread Take-up must be at the same level with the long groove of the Spreader Thread.

2.必要调整时,先松开螺丝(3)及(4),上下摆动上叉挑线杆(2),调整后锁紧之。

2.To adjust,loosen Screw (3) and (4),and move the Spreader Thread Take-up (2) up or down,and then tighten screw again.

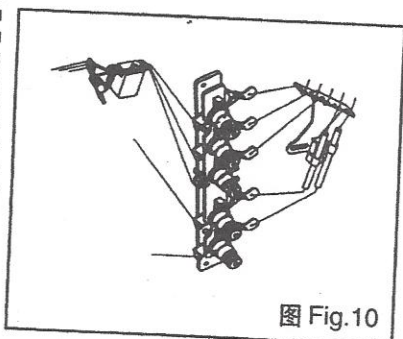


图 Fig.10

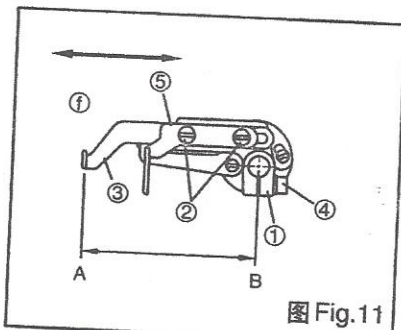


图 Fig.11

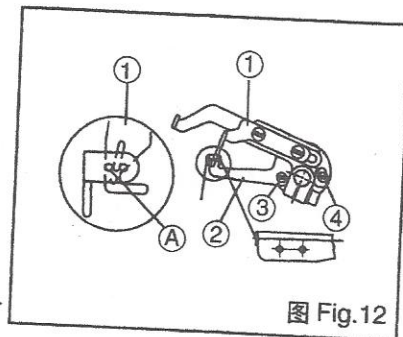


图 Fig.12

压脚调整

ADJUSTING PRESSER FOOT

松开螺钉(1);左右摇动以调整压脚(2);使针尖端刚好位于如示之中心点。调整后,再锁紧螺钉(1)。(图13)

Loosen Screw (1) and adjust Presser Foot (2) left and right to a proper position to let the needle may get into the centre of Presser Foot 's eyelet.After adjusting, tighten screw (1) .(Fig.13)

线迹长度调整

ADJUSTING STITCH LENGTH

线迹长度由 1.2 至 4.0mm 或 6-18 针 / 寸无阶段性调整。

Stitch length can be adjusted variably in range from 1.2mm-4.0mm,or 6-18 stitches per inch.

1、用手压下按钮(A);再以右手转动手轮直到左手手指感觉按钮嵌入到机器内部卡内。

1.Keep pressing the push button (A) with your left hand,then turn the hand-wheel with your right hand until your left hand finger feels the push button lock in.(Fig 14)

2、持续转动手轮,选择所需之缝目长度对准(B)然后放开按钮。(图 15)

2.Keep turning hand-wheel for an inquired stitch length, whose scale indicated on the hand-wheel must be aligned with,then stop pressing the button.(Fig 15)

3、欲调长针距时,将手轮逆时针方向旋转;反之则小。

3.Rotate the hand-wheel counter clock-wide to increase the stitch length,and clockwise to decrease.

4、针距之调整会使差动比改变,故针距调整后,需接着调整差动比。

4.After adjusting stitch length the differential ratio will usually be changed too.So adjustment of differential ratio is required.

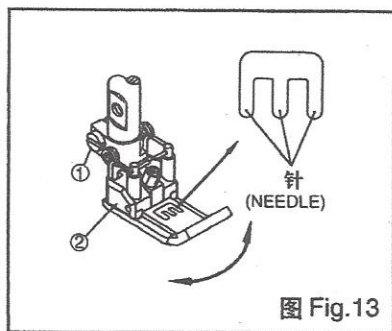


图 Fig.13

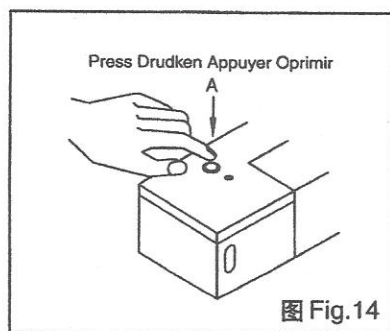


图 Fig.14

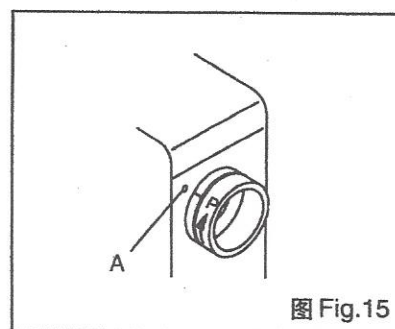


图 Fig.15

差动比调整

ADJUSTING DIFFERENTIAL FEED RATIO

本机器之差动比可从 1:0.5 调整至 1:1.3 松开螺母 (2), 上下移动可调整。(图 16)

The differential Feed Ratio of this machine is adjustable from 1:0.5 to 1:1.3 (Fig 16)

To adjust the ratio,loosen the nut (2),move the indicator (1)up or down.

* 要伸张布料车缝时, 则将调整杆(1)往上移。

*To stitch the cloth,move the indicator (1) upward;

* 需要折景车缝时, 则将调整杆(1)往下移。

*To gather the cloth,move the indicator (1) downward;

压脚压力强度调整

ADJUSTING THE PRESSURE OF PRESSER FOOT

在布料推送顺畅且缝合完美之情况下, 压脚压力尽量轻些。

Pressure of the Presser Foot should be as light as possible,so that cloth can be fed and sewed smoothly.

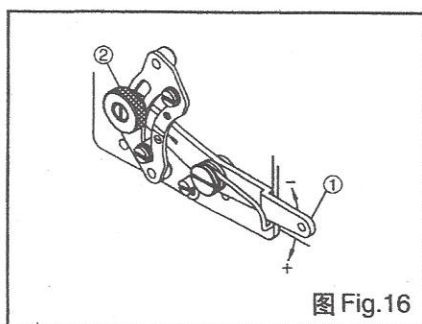


图 Fig.16

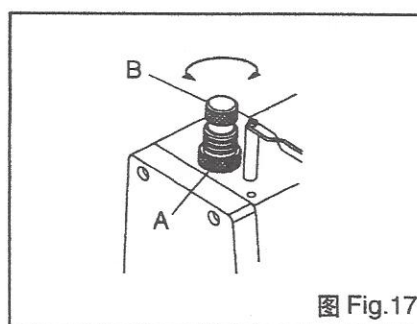
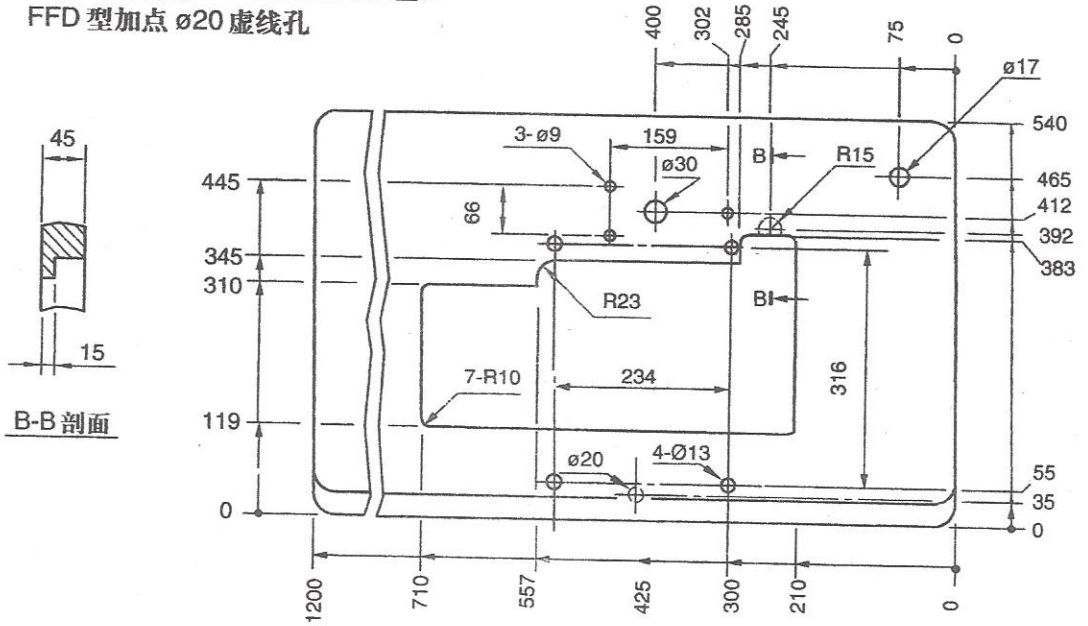


图 Fig.17

TABLE CUT-OUT - E007-T

单位 /UNIT:MM
 所有尺寸公差 /DIFFERENCE:±2
 FFD 型加点 $\phi 20$ 虚线孔



THREADING DIAGRAM FOR E007H

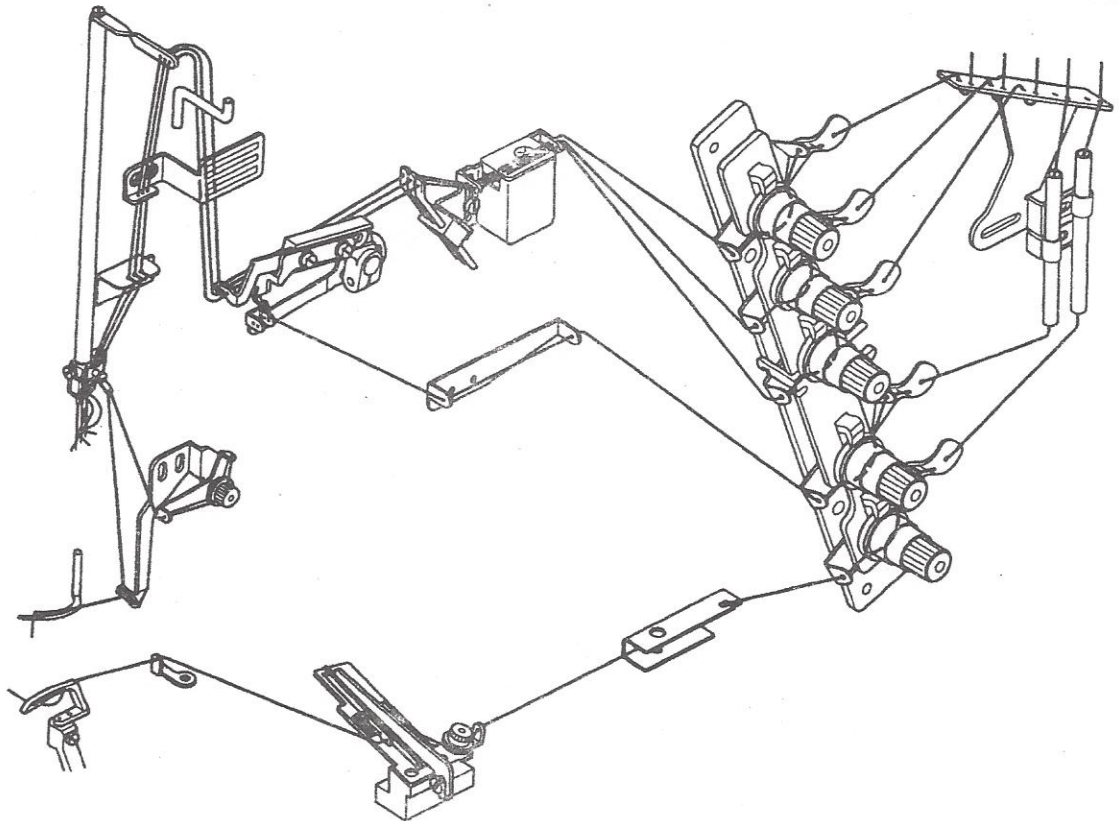


TABLE CUT-OUT - E007-T2

FOR FR
 单位 /UNIT:MM
 所有尺寸公差 /DIFFERENCE:±2

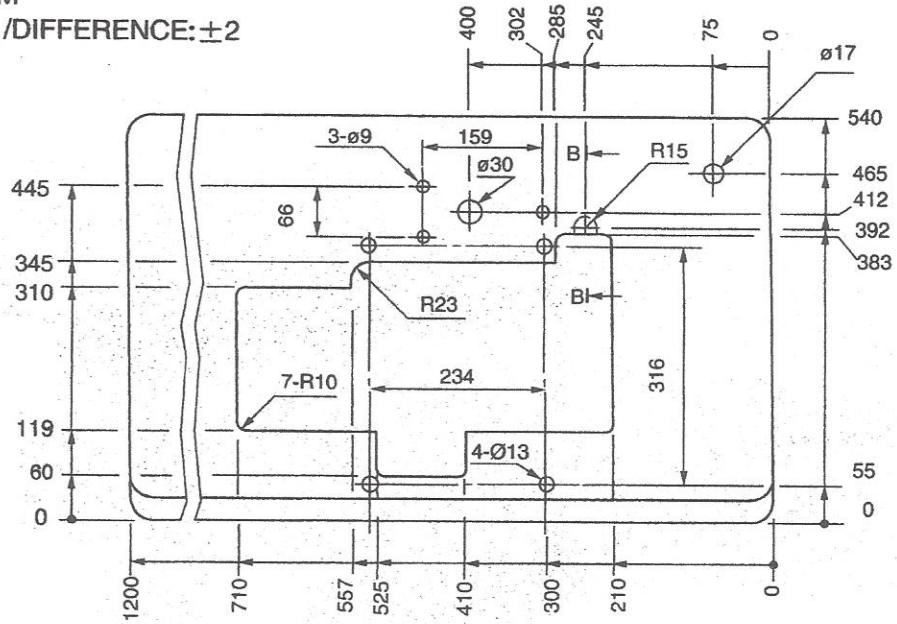
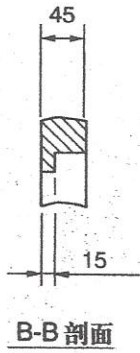


TABLE CUT-OUT - E007-T1

FOR FR
 单位 /UNIT:MM
 所有尺寸公差 /DIFFERENCE:±2

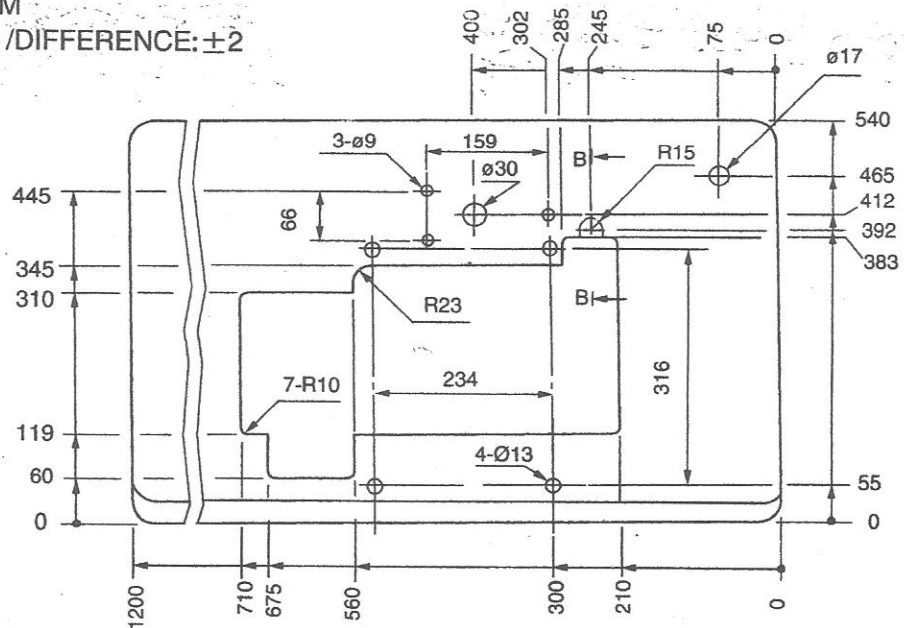
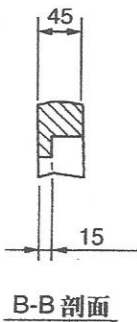


TABLE CUT-OUT - E007-T4-1

单位 /UNIT:MM

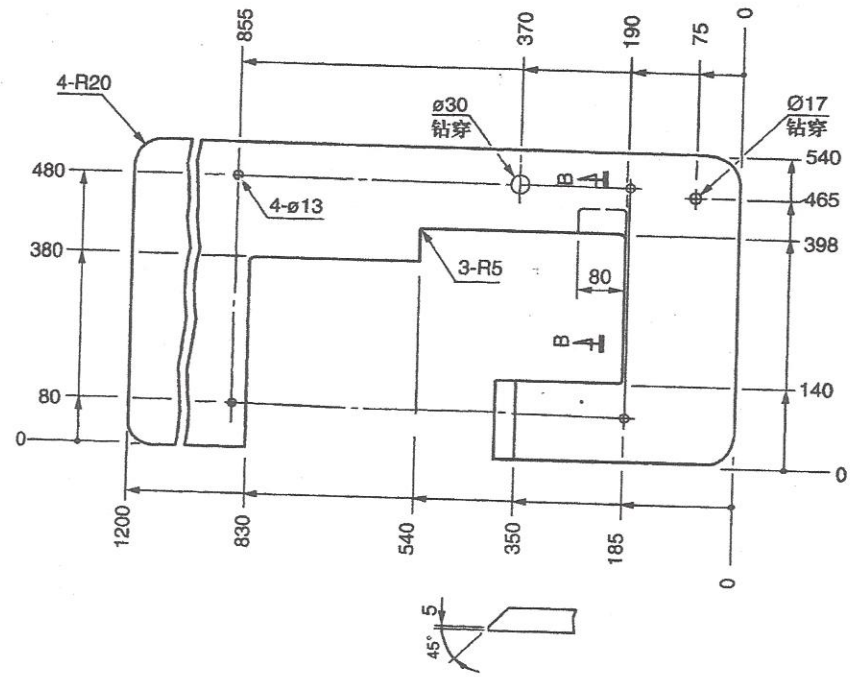
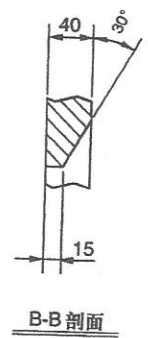
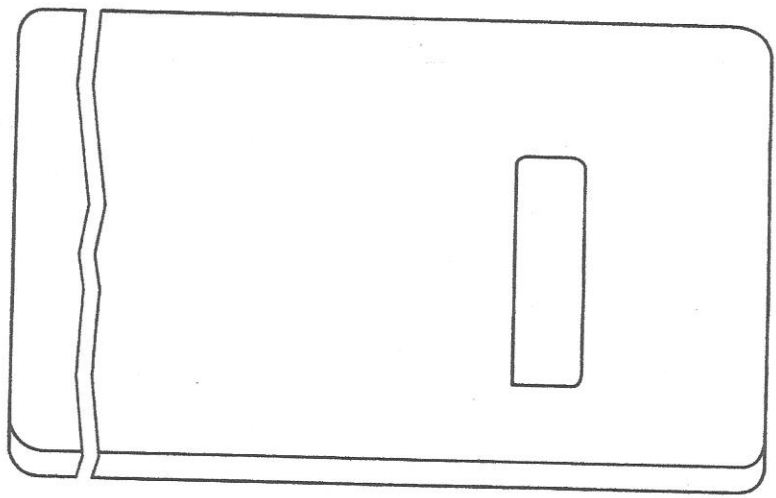


TABLE CUT-OUT - E007-T3



重要安全事项说明

IMPORT SAFETY INSTRUCTION

1.搬运作业

- (1)、使用全罩二片式的保丽龙将机器包装防护。
- (2)、放入纸箱内。
- (3)、用手推车或二人用双手抬动搬运。

2.储存作业

- (1)、机器不使用时,应用防尘罩将其罩上。
- (2)、避免储存于高于 45℃ 以上的高温。

3.作业中

机器不要在高于 40℃ 以上的温度工作。

4.警告

在贴有警告标示之处请注意。

- 1.机械运动部份, 请注意装上保护装置。

- 2.穿线、换线、调整、清洁时请注意关闭电源。

1. Transportation

- (1).The machine packed with two piece covers that made of expanded polystyrene to protect it.
- (2).Put the machine into a carton.
- (3).Use a cart or by two men's hands to move it.

2.Storage

- (1).The machine must use duster-cover to cover it when it does not work.
- (2).The machine avoid to storage in the temperature more than 45℃.

3.Working

The machine dosen't work over 40℃.

4.Warning

Pay attention to this warning advice as follows:

- a.Working area is dangerous.
- b.Never touch the needle if the machine is still running.
- c.Be careful if you infeed fabric.
- d.Do not insert your finger between needle and roller for transportation on fabric.

Pay attention to the warning sticker.

- a.Movable parts must be enclosed with guard when you operate.
- b.Pull out the plug from socket when you adjust, thread,change bobbin and needle clean.

规格件表 · CONVERSION CHART

MODEL 机型	SUP-CLASS 规格	NEEDLE CLAMP 针 轧	NEEDLE CLAMP 针 板	MAINFEED DOG 主送料牙	DIFF.FEED DOG 差动送料牙	PRESSER FOOT 压 脚	LOOPER 弯 针	SPREADER 绷 针	NEEDLE 针 号
E007H-W122	240	M5240	E1524	D1206	H1258	P0024	ME28	MH41E	UY128GAS#11
	248	M5248	E1525	D1206	H1258	P0025			
	256	M5356	E1826	D1207	H1259	P0216			
	364	M5364	E1827	D1207	H1259	P0217			
E007H-W122 /UTG(UTJ)	240	M5240	E1524	D1206	H1258	P0024	ME28	MH41E	UY128GAS#11
	248	M5248	E1525	D1206	H1258	P0025			
	356	M5356	E1826	D1207	H1259	P0216			
	364	M5364	E1827	D1207	H1259	P0217			
E007H-U122	240	M5240	E1524	D1206	H1258	P0314	ME28	-	UY128GAS#11
	248	M5248	E1525	D1206	H1258	P0315			
	356	M5356	E1826	D1207	H1259	P0416			
	364	M5364	E1827	D1207	H1259	P0417			
E007H-U122 /UTH(UTK)	240	M5240	E1524	D1206	H1258	P0314	ME28	-	UY128GAS#11
	248	M5248	E1525	D1206	H1258	P0315			
	356	M5356	E1826	D1207	H1259	P0416			
	364	M5364	E1827	D1207	H1259	P0417			
E007H-U122/FP	232	M5232	E1623	D1206	H1257	P4011	ME28P	-	UY128GAS#11
	240	M5240	E1534	D1206	H1258	P0024	ME28	MH41E	UY128GAS#11
	248	M5248	E1835	D1206	H1258	P0025			
	356	M5356	E1836	D1207	H1259	P0216			
364	M5364	E1837	D1207	H1259	P0217				

规格件表 · CONVERSION CHART

MODEL 机型	SUP-CLASS 规格	NEEDLE CLAMP 针 轧	NEEDLE CLAMP 针 板	MAINFEED DOG 主送料牙	DIFF. FEED DOG 差动送料牙	PRESSER FOOT 压 脚	LOOPER 弯 针	SPREADER 绷 针	NEEDLE 针 号
E007H-W123 /UTG(UTJ)	240	M5240	E1534	D1206	H1258	P0024			
	248	M5248	E1535	D1206	H1258	P0025	ME28	MH41E	UY128GAS#11
	356	M5356	E1836	D1207	H1259	P0216			
	364	M5364	E1837	D1207	H1259	P0217			
E007H-W162	356	M5356	E1846	D1207	H1259	P0226	ME28A	MH41E	UY128GAS#14-16
	364	M5364	E1847	D1207	H1259	P0227	ME28A	-	UY128GAS#14-16
E007H-W162 /UTG(UTJ)	356	M5356	E1846	D1207	H1259	P0226	ME28A	MH41E	UY128GAS#14-16
	364	M5364	E1847	D1207	H1259	P0227	ME28A	-	UY128GAS#14-16
E007H-W222 /FQ	240	M5240	E3024	D1215	H1261	P1814			
	248	M5248	E3025	D1215	H1261	P1815	ME28	MH41E	UY128GAS#11
	356	M5356	E3326	D1216	H1262	P2116			
	364	M5364	E3327	D1216	H1262	P2117			
E007H-W222 /FQ/FEC(FAC)	240	M5240	E3024	D1215	H1261	P1814			
	248	M5248	E3025	D1215	H1261	P1815	ME28	MH41E	UY128GAS#11
E007H-U222 /FQ	356	M5356	E3326	D1216	H1262	P2116			
	364	M5364	E3327	D1216	H1262	P2117			
	240	M5240	E3024	D1215	H1261	P2314			
	248	M5248	E3025	D1215	H1261	P2315	ME28	-	UY128GAS#11

规格件表 · CONVERSION CHART

MODEL 机型	SUP-CLASS 规格	NEEDLE CLAMP 针板	NEEDLE CLAMP 针轧	MAINFEED DOG 主送料牙	DIFF.FEED DOG 差动送料牙	PRESSER FOOT 压脚	LOOPER 弯针	SPREADER 绷针	NEEDLE 针号
E007H-U322 /FDC	356	M5356	E4826	D1207	H1359	P1606	ME28	---	UY128 GAS#11
	364	M5364	E4827	D1207	H1359	P1607	ME28	---	UY128 GAS#11
E007H-U322 /UTH(UTK)/FDC	356	M5356	E4826	D1207	H1359	P1606	ME28	---	UY128 GAS#11
	364	M5364	E4827	D1207	H1359	P1607	ME28	---	UY128 GAS#11
E007H-W322 /FDE	356	M5356	E4836M	D1207	H1459	P2406	ME28	MH41E	UY128 GAS#11
	364	M5364	E4837M	D1207	H1459	P2407	ME28	MH41E	UY128 GAS#11
E007H-W322 /UTH(UTK)/FDE	356	M5356	E4836M	D1207	H1459	P2406	ME28	---	UY128 GAS#11
	364	M5364	E4837M	D1207	H1459	P2607	ME28	---	UY128 GAS#11
E007H-U322 /FDE	356	M5356	E4836M	D1207	H1459	P2606	ME28	---	UY128 GAS#11
	364	M5364	E4837M	D1207	H1459	P2607	ME28	---	UY128 GAS#11
E007H-U322 /UTH(UTK)/FDE	240	M5240	E6024	D2221	H2267	P2814	ME28	MH41E	UY128 GAS#11
	248	M5248	E6025	D2221	H2267	P2815	ME28	MH41E	UY128 GAS#11
E007H-W522 /FE(FFC)/FR	356	M5356	E6326	D2222	H2268	P3116	ME28	---	UY128 GAS#11
	364	M5364	E6327	D2222	H2268	P3117	ME28	---	UY128 GAS#11
E007H-W522 /FE(FFC)/FR	240	M5240	E6024	D2221	H2267	P3314	ME28	---	UY128 GAS#11
	248	M5248	E6025	D2221	H2267	P3315	ME28	---	UY128 GAS#11
E007H-W522 /FE(FFC)/FR	356	M5356	E6326	D2222	H2268	P3616	ME28	---	UY128 GAS#11
	364	M5364	E6327	D2222	H2268	P3617	ME28	---	UY128 GAS#11
E007H-W512 /FE(FFC)	240	M5240	E1524	D1206	H1258	P2914	ME28	---	UY128 GAS#11
	248	M5248	E1525	D1206	H1258	P2915	ME28	---	UY128 GAS#11
E007H-W512 /FE(FFC)	356	M5356	E1826	D1207	H1259	P3216	ME28	MH41E	UY128 GAS#11
	364	M5364	E1827	D1207	H1259	P3217	ME28	MH41E	UY128 GAS#11

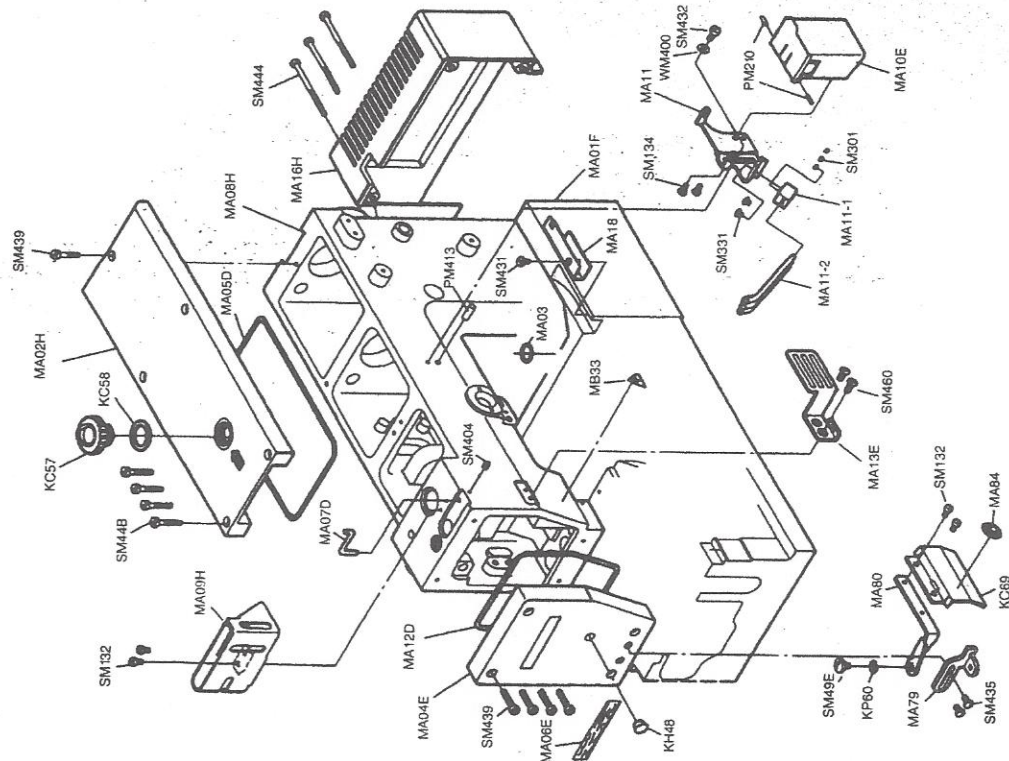
规格件表 · CONVERSION CHART

MODEL	SUP-CLASS	NEEDLE CLAMP	NEEDLE CLAMP	NEEDLE CLAMP	NEEDLE CLAMP	MAINFEED DOG	DIFF.FEED DOG	PRESSER FOOT	LOOPER	SPREADER	NEEDLE
机型	规格	针 轧	针 板	主送料牙	差送料牙	压 脚	弯 针	绷 针	针 号		
E007H-U512 /FE(FFC)	240	M5240	E1524	D1206	H1258	P3414	ME28	---	UY128 GAS#11		
	248	M5248	E1525	D1206	H1258	P3415					
	256	M5356	E1826	D1207	H1259	P3716					
	364	M5364	E1827	D1207	H1259	P3717					
E007H-W922 /FW(FWP)	460	M5460	E1828	D1207	H1259	P2408	ME28	MH41E	SM1014B#10 (MY1014B#70, SY7256)		

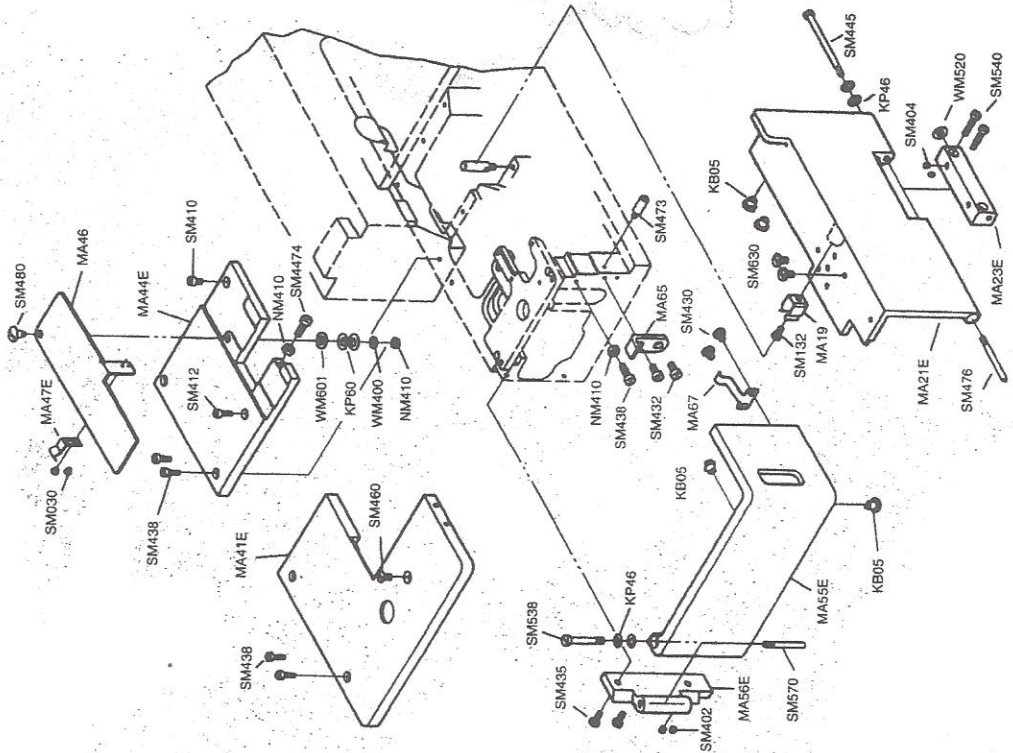
备注/REMARK: 1. E007H-W/U 122A-356/P2406 2. W222A/FAC(FEC) 短切刀 SHORT KNIFE
 364/P2407 W222/FAC(FEC) 长切刀 LONG KNIFE

3. E007H-W/U 322A-356/FDC E1826/D1207/H1259
 364/FDC E1827/D1207/H1259

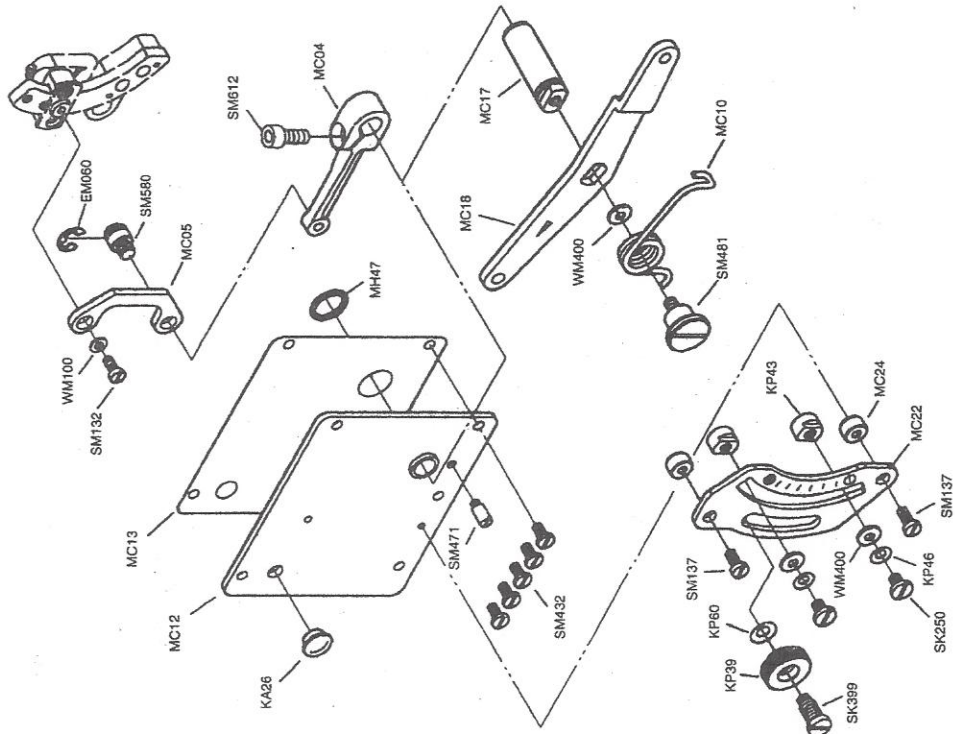
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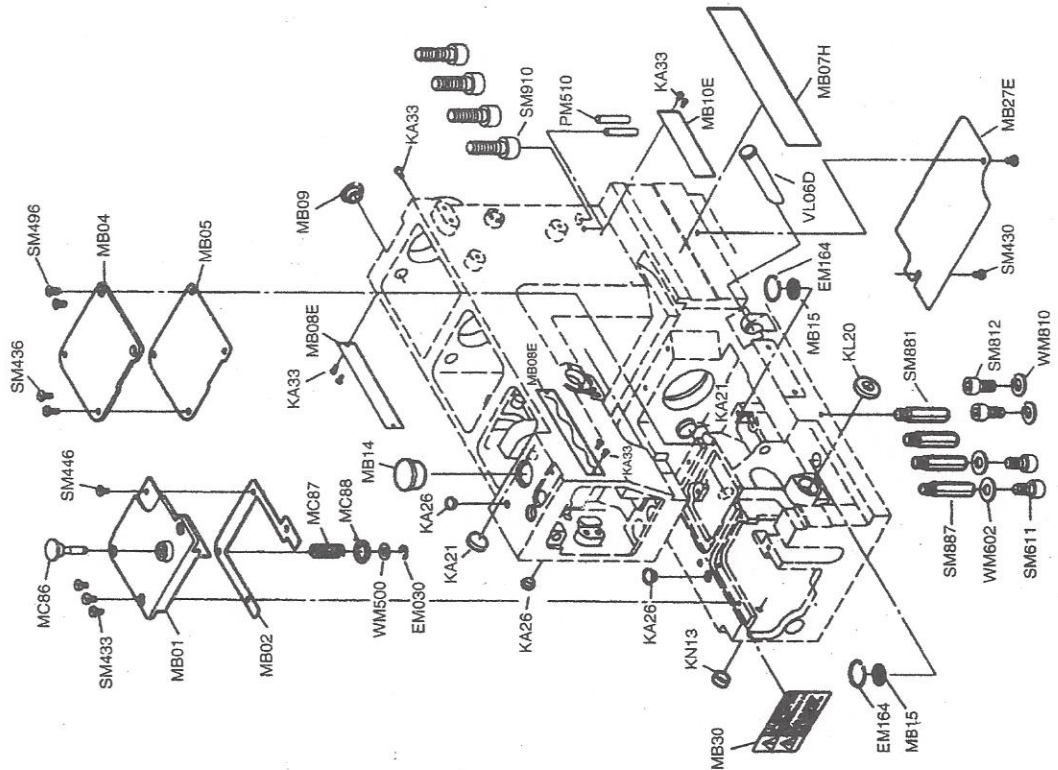
PARTS LIST FOR MA(2) GROUP



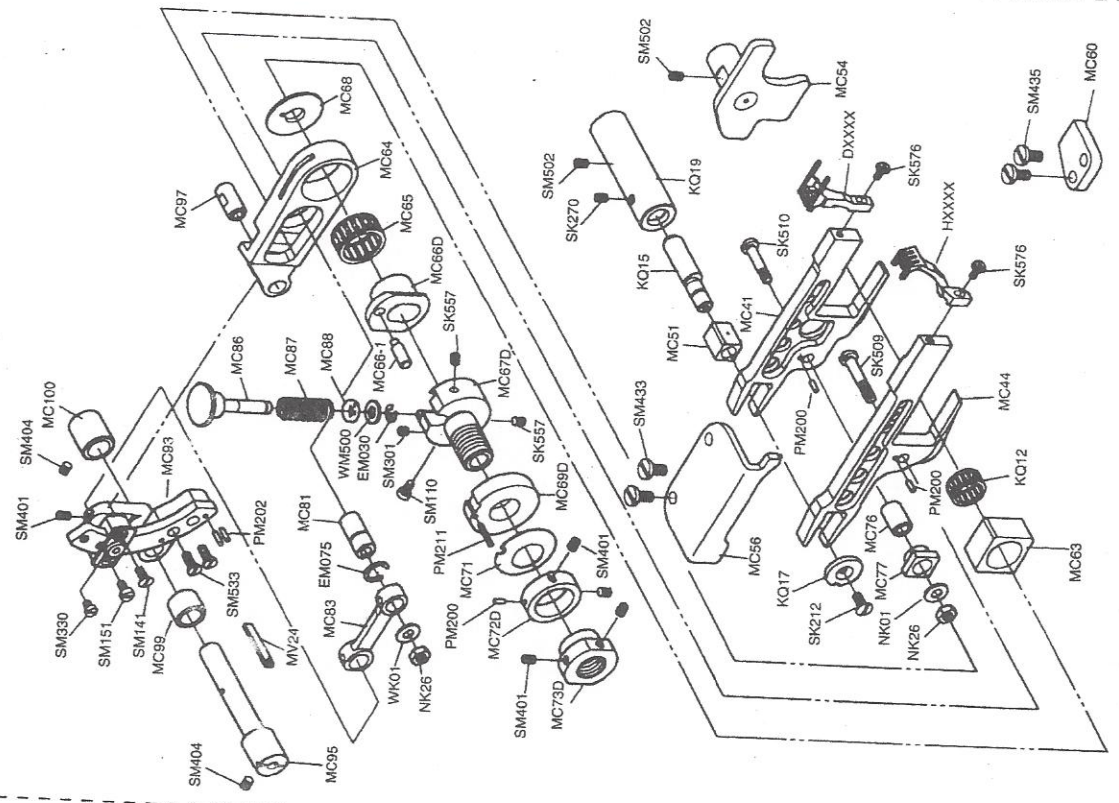
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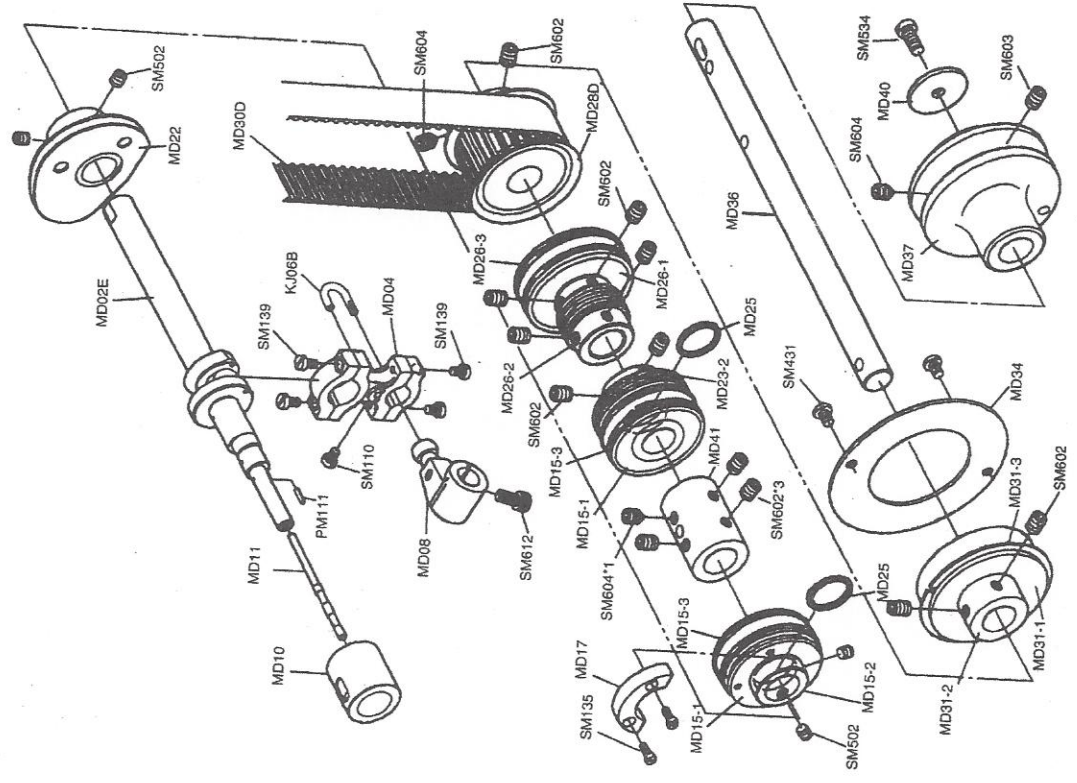
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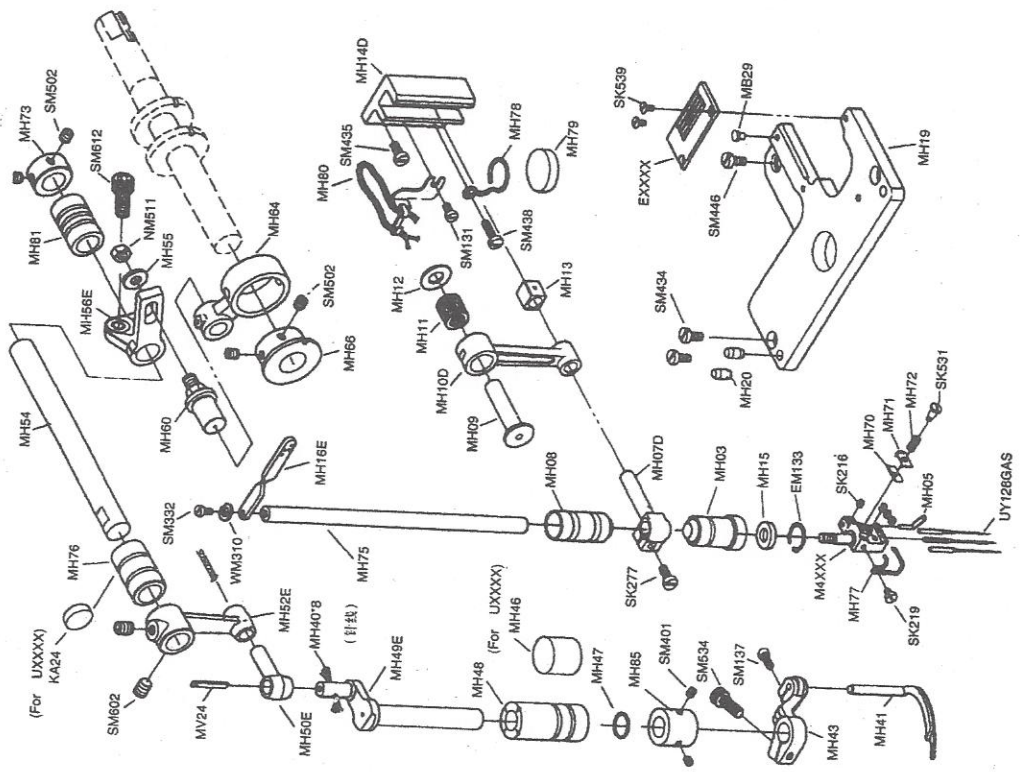
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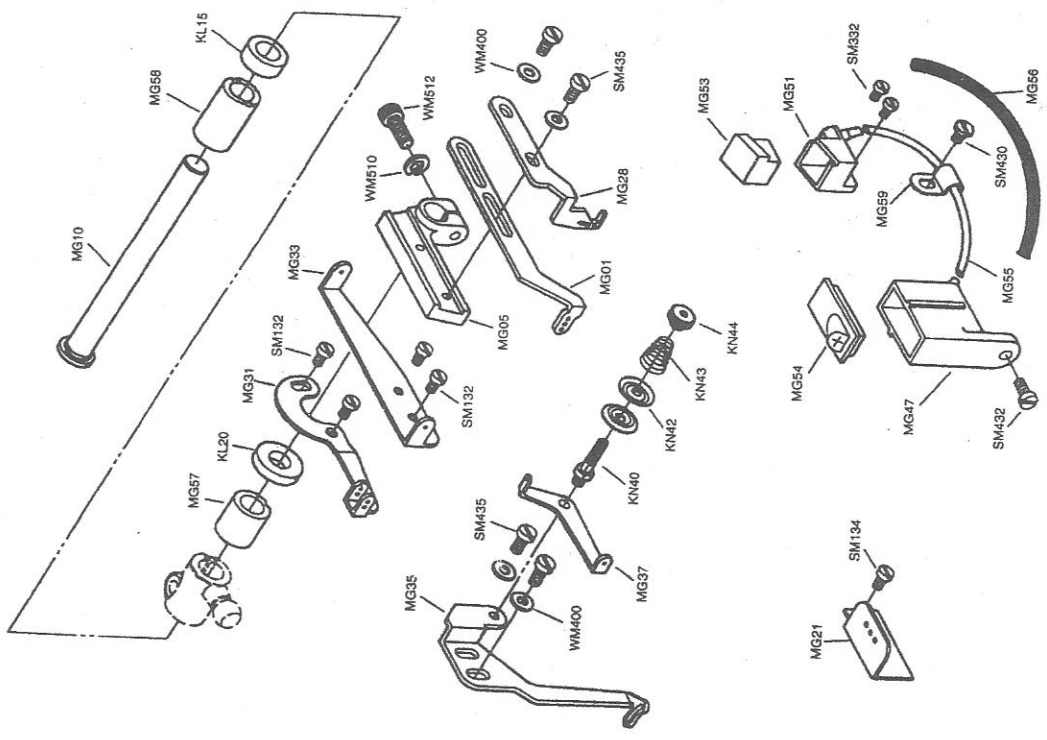
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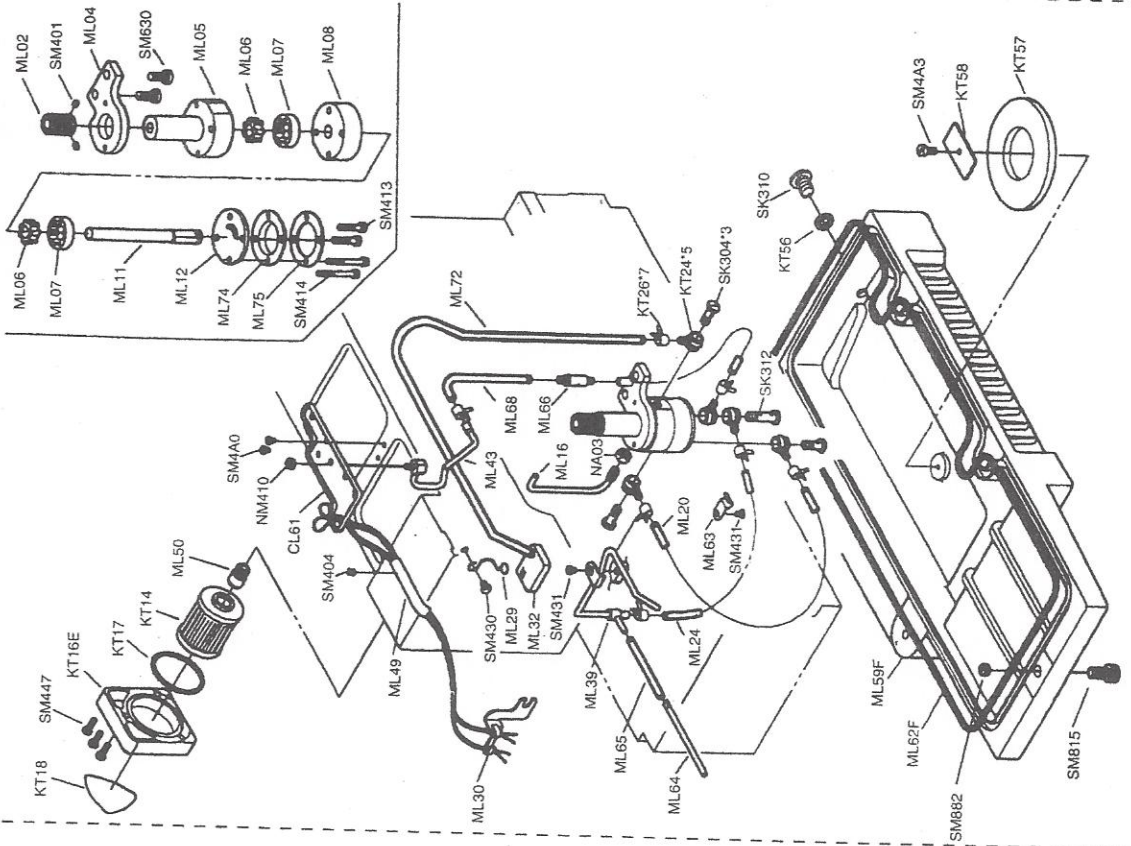
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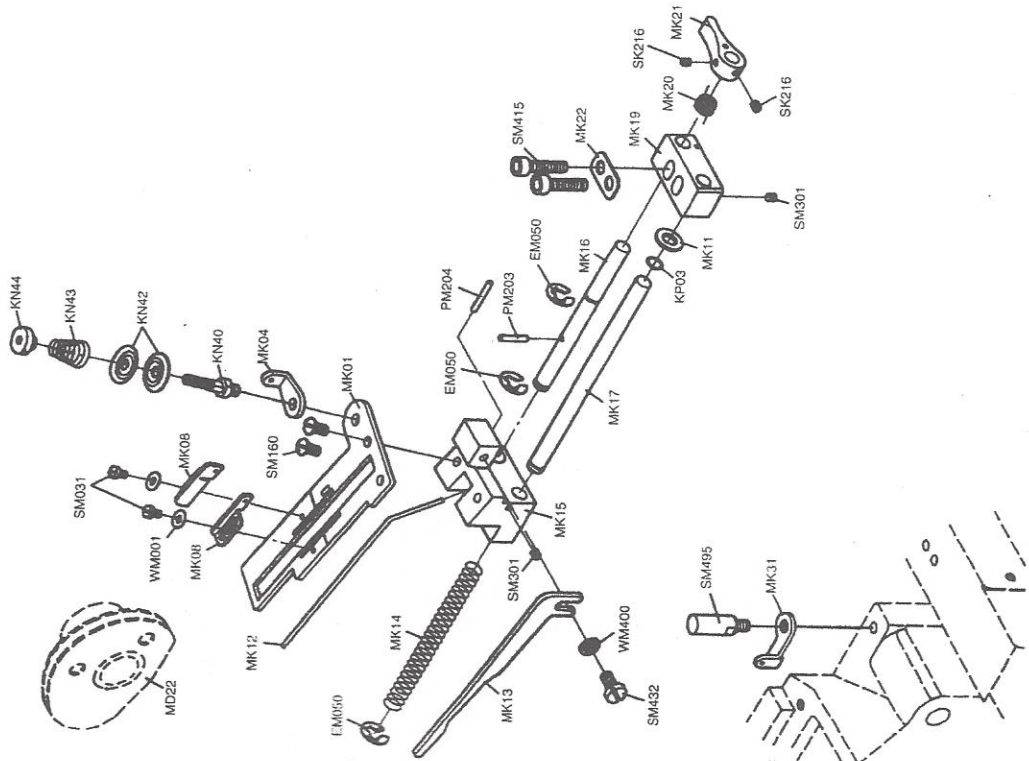
PARTS LIST FOR MG GROUP



PARTS LIST FOR ML GROUP

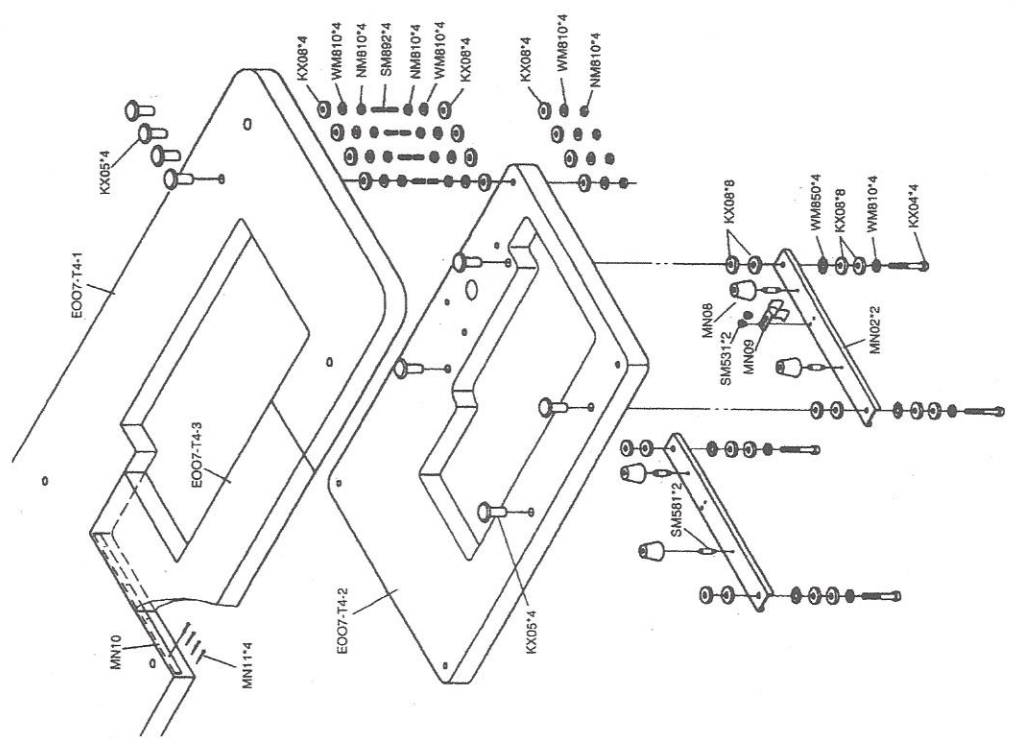
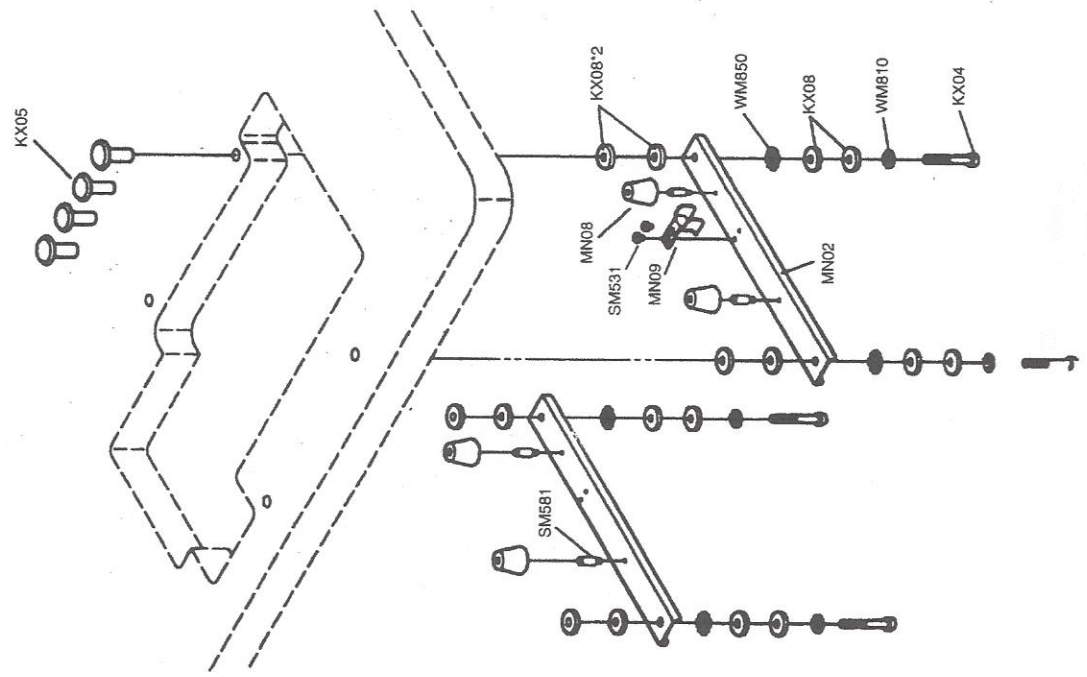


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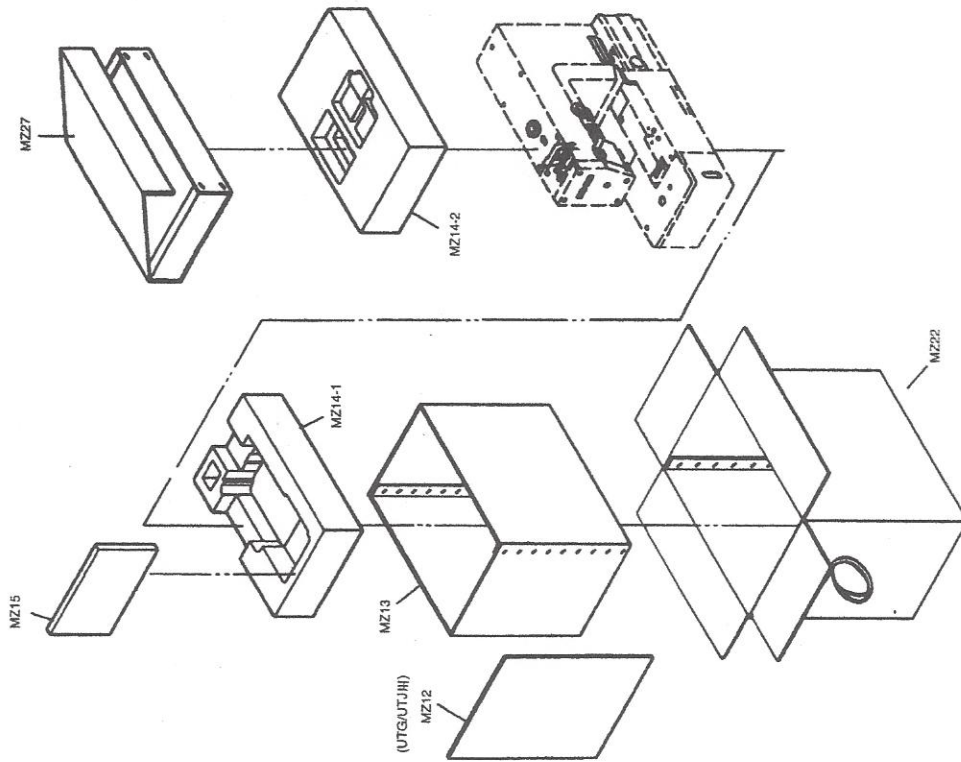


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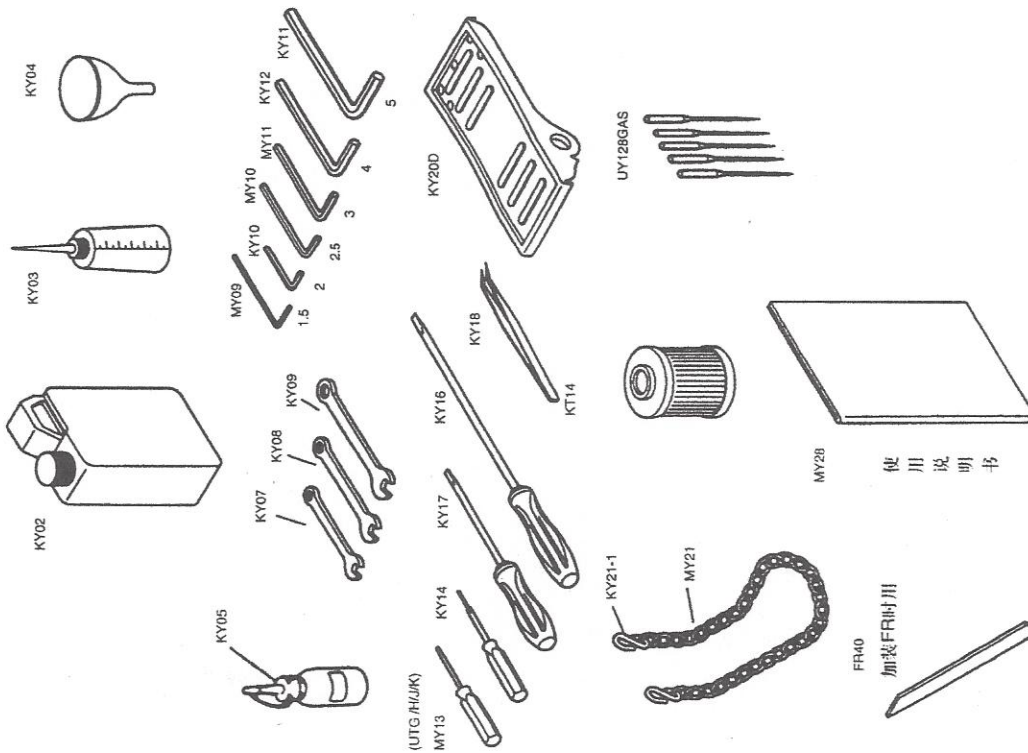
PARTS LIST FOR MN(2) GROUP



PARTS LIST FOR MZ GROUP



PARTS LIST FOR MY GROUP



PARTS LIST FOR KW GROUP

