



***Richpeace***<sup>®</sup>

富怡电脑有梭绗缝机用户手册



***Richpeace***<sup>®</sup>

**RICHPEACE COMPUTERIZED  
QUILTING MACHINE Manual  
Book**

目 录

目 录	Directory
<b>第一章 概述</b>	<b>Chapter 1 Overview</b>
1.1 安全注意事项.....1	1.1 Safety precautions..... 1
1.2 机器的叉运.....4	1.2 Machine handling ..... 4
1.3 安装位置.....4	1.3 Place for installation:.....4
1.4 配件的安装.....8	1.4 The installation of the spare parts.....8
1.5 主要功能特色.....14	1.5 Main features ..... 14
1.6 技术规格.....16	1.6 Technical standard..... 16
<b>第二章 开关及操作界面介绍</b>	<b>Chapter 2 Operation panel instruction</b>
2.1 开关按钮介绍.....17	2.1 Switches and buttons..... 17
2.2 显示界面介绍.....18	2.2 User interface..... 18
<b>第三章 V33-F 绗缝机功能介绍</b>	<b>Chapter 3 Introduction to functions of V33-F Quilting Machine</b>
3.1 主轴复位.....20	3.1 Principal axis Rese.....20
3.2 参数设定.....21	3.2 Parameter settings.....21
3.3 辅助功能.....28	3.3 Auxiliary functions.....28
3.4 花样管理.....32	3.4 Manage patterns.....32
3.5 绗缝功能.....39	3.5 Functions of quilting.....39
<b>第四章 绗缝流程介绍</b>	<b>Chapter 4 Quilting procedure</b>
4.1 如何进行第一次绗缝.....41	4.1 How to perform the first quilting with your machine.....41
4.2 如何开机.....41	4.2 How to launch your quilting machine.....41

4.3 绗缝的基本流程.....42	4.3Basic procedure of quilting.....42
<b>第五章 常见故障及处理办法</b>	<b>Chapter 5</b> FAQs and methods of disposition
5.1 绗缝质量问题及解决方法.....43	5.1Quilting quality problems and disposition methods.....43
5.2 系统报错及解决方法.....45	5.2System errors and disposition methods.....45
<b>第六章 机械部分的调整</b>	<b>Chapter 6</b> Adjustment of mechanical parts
6.1 压板的调整.....50	6.1Adjustment of platen.....50
6.2 打线排的调整.....51	6.2Adjustment of line arrangement.....51
6.3 针梭同步、时序的调整.....52	6.3Timing and timing adjustment of needle spindle.....52
<b>第七章 机器的保养</b>	<b>Chapter 7</b> maintenance of machine
7.1 机器工作零件保养.....53	7.1maintenance of machine.....53
<b>第八章 零件图册</b>	<b>Chapter 8</b> Parts Atlas
8.1 零件图册.....54	8.1Parts Atlas.....54

## 第一章 概述

### 1.1 安全注意事项



为避免您受到伤害，并防止对本产品或任何与其相连接的产品造成损坏，请在使用本绗缝机之前仔细阅读以下注意事项，以确保您安全正确的使用机器进行绣作。

- 1、禁止未经接地使用机器。当机器性能下降以及发生故障时，接地能防止触电的危险。
- 2、保护接地导线应该采用黄绿组合颜色铜导线，保护导线的截面积大于等于  $1.5\text{mm}^2$ ；保护接地回路应该有可靠的连续性，采用 PELV（保安特低电压）电源，对应测试电流为 10A。电控箱接地端子和绗缝机机架接地端子对大地接地点的最大实测电压降应小于等于 2.6V。
- 3、在打开电器方面的各种盒箱时，以及在更换盒箱内的电路板时请务必先从电源插座拔出电源插头或关闭外电源开关。
- 4、请不要给绗缝机加电而长时间放置不用。此外，在使用机器后及在清洁机器之前请务必断开机器所连接的电气系统。
- 5、在清扫机台的灰尘和杂物时，一定不要用水擦洗或是用空气压缩

## Chapter 1 Overview

### 1.1 Safety precautions

For your safety, and for the safety of the machine as well as the goods that connect to it, please read the safety cautions below carefully so as to work with the machine safely.

- 1、 Do not use the machine if it does not have ground connection. If performance reduction or malfunction occurred to the machine, ground connection can protect the user from electric shock.
- 2、 Earth lead for ground connection should be green and yellow wire made of copper. The wire's sectional area should be no less than  $1.5\text{mm}^2$ . Ground loop should be very much reliable, and when tested with PELV, the test current should be 10A. The max voltage drops that measured at electric cabinet's ground terminal and that of quilting machine frame should be no more than 2.6V.
- 3、 Please unplug the machine or cut the power supply before you

机的气枪来吹扫，空气压缩机压出的空气带有水雾，容易引起电路系统的短路。

- 6、需要拆下面罩等机械系统的罩盖进行加油或进行其它的调整时，请务必先拔出机器的电源插头或关闭外电源开关。
- 7、穿线、换针和改换梭条等在针的近边操作时，请务必停止绗缝状态下进行。
- 8、电源线和电源插头有损伤、机器不能正常动作、机器出现故障以及出现渗漏时，请勿进行作业。发生这类情况时，请委托厂家的技术人员进行检修。
- 9、作业结束后，请将所有开关都置于“OFF”位置，关断电源后再拔出电源插头。在拔出电源插头时请勿拉着电线拔，请务必握住插头将其拔出。
- 10、电控箱周围不要堆放杂物，以利于散热。
- 11、禁止电控设备超时工作以及工作在尘、腐蚀性气体、易燃易爆气体的场所，否则可能会引起触电或火灾。

## 1.2 机器的叉运

当机器到达客户工厂时，先确认机器有无破损，零件有无丢失，确认完毕后使用合理承重的叉车将机器正确叉放到客户所需位置。

open machine's boxes and cases regarding electricity, and change circuit boards in these boxes and cases.

- 4、 When quilting machine is not used, please cut its power supply. Besides, do cut power supply after use machine or before clean it
- 5、 When cleaning dust and other things of very little size on machine platform, please do not use water or air compressor. Because air from compressor could be moist and could cause short circuit on electrical system.
- 6、 If you need to remove machine's shrouds to perform lubrication or make adjustments, please cut power supply beforehand.
- 7、 When performing threading, needle-changing, shuttle-changing, etc that the operator should stay close to needle, please stop the machine beforehand.
- 8、 When such situations as damages on power line and plug,



### 1.3 安装位置

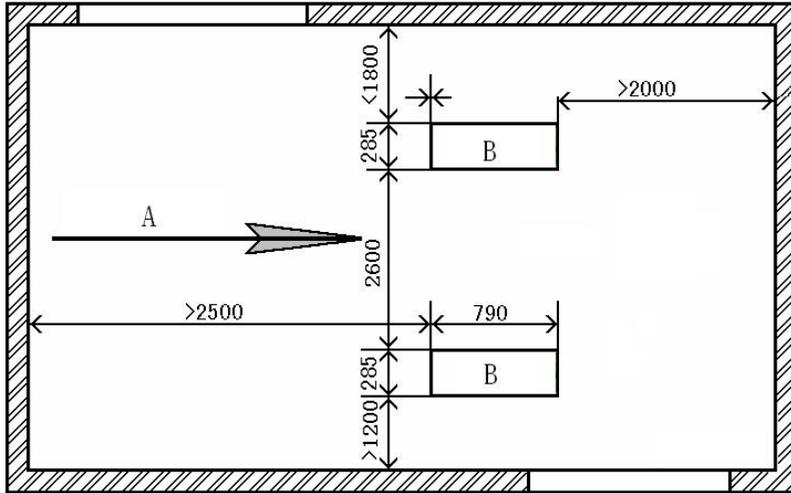
用户应预先按（安装平面图）要求选择好机器安装位置，机墩基础平台必须用九公分厚以上的水泥钢筋混凝土建造，机器放置调整水平后用水泥填补机脚座与机墩之间的空隙，待水泥干透后方可试机。

machine malfunction, leakage of oil or liquid, etc, please do not start machine and ask for technicians from machine's manufacturer for help.

- 9、 Please switch off all the switches and cut power supply, and then pull out the plug. In pulling, please do not pull wire but the plug.
- 10、 For sound heat dissipation, please keep the area electric cabinet clear.
- 11、 Do not make electronic control system work overtime, or work in dust, or corrosive gas, or flammable and combustible gas conditions. Or it may cause electric shock or fire.

### 1.2 Machine handling

When the machine reaches the customer's factory, first need to confirm that the machine has no damage, no missing parts, after the confirmation , use a reasonable bearing of the forklift to take the machine to the the customer's location.



Installation plan

A	布料前进方向	B	机脚位
Unit: mm			

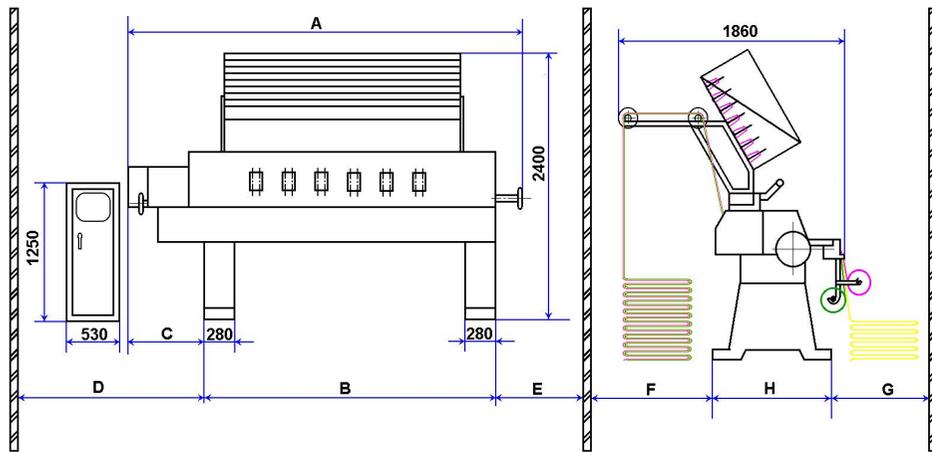
机 型 Mode I	RPQD- RL-642	RPQD- RL-643	RPQD- RL-942	RPQD-R L-943	RPQD-R L-1283
A	3200	3200	4150	4150	5100
B	2410	2410	3330	3330	4150
C	470	470	470	470	470



### 1.3 Place for installation:

The user is required to choose a place for installation preliminarily according to the installation plan. The platform for placing machine should be built by reinforced concrete with its thickness 9cm or more. Commissioning will begin after the concrete, used to bridge the gap between the machine base and the built platform, is dry.

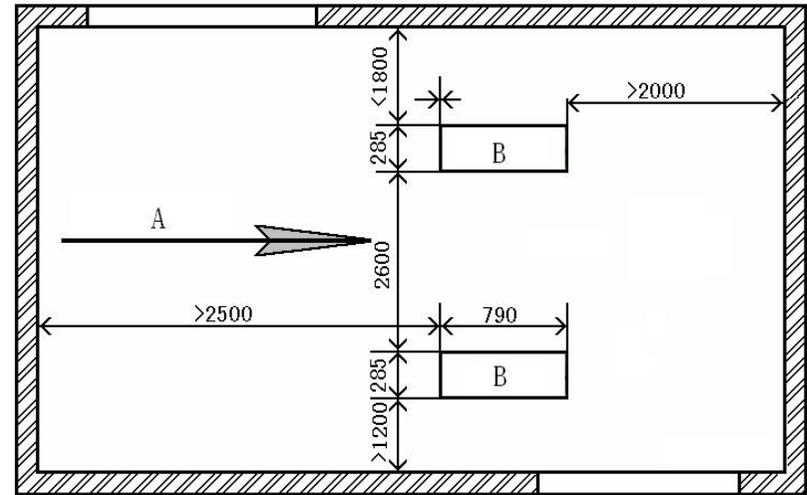
D	>1800	>1800	>1800	>1800	>1800
E	>1200	>1200	>1200	>1200	>1200
F	>2000	>2000	>2000	>2000	>2000
G	>200	>200	>2000	>2000	>2000
H	770	860	770	860	860



注：在机脚位至墙壁尺寸>1200 为通道尺寸，若大修机器，其墙壁要留抽轴用的孔（单位：mm）

**装地线：**在电箱旁插一根 1 米长角钢或水管入地，角钢顶端用螺丝

把电脑箱与主机身地线连接。  接地线符号。



Installation plan

A	fabric forward direction	B	machine base
---	--------------------------	---	--------------

Unit: mm

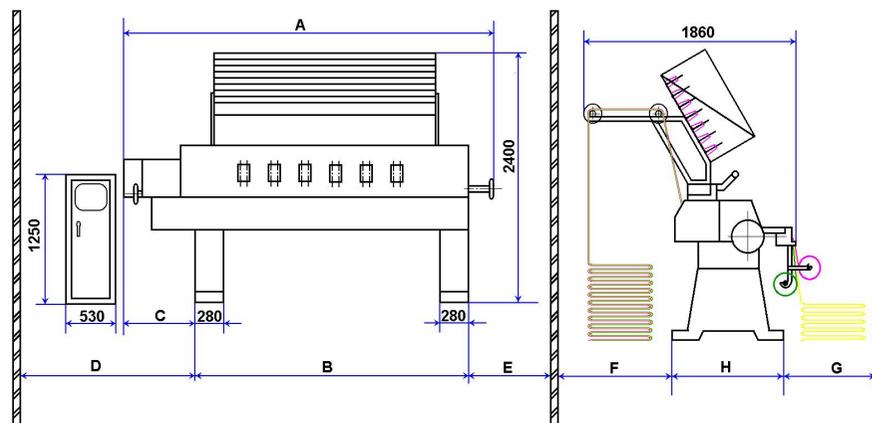
机 型	RPQD-	RPQD-	RPQD-	RPQD-R	RPQD-R
Model	RL-642	RL-643	RL-942	L-943	L-1283
A	3200	3200	4150	4150	5100
B	2410	2410	3330	3330	4150
C	470	470	470	470	470
D	>1800	>1800	>1800	>1800	>1800
E	>1200	>1200	>1200	>1200	>1200

**试运转：**首先确认好机器的电源后通电测试机器的每项动作及信号，如机器运转平稳、无异常响声及震动方可进行编织。

选线	参数
面线材料	尼龙线,涤沦线
面线直径	0.15- 0.2 mm
面线抗拉强度	> 1.5 kg / 线 径 0.2 mm >2.5kg/φ 0.2mm
面线拉断伸长值(线长500mm)	< 10 mm
底线材料	涤沦线, 混纺棉线
底线直径	0.15 mm
底线抗拉强度	> 1kg / 线 径 0.15 mm >1kg/φ0.15mm
底线拉断伸长值(线长500mm)	< 5 mm

## 1.4 配件的安装

F	>2000	>2000	>2000	>2000	>2000
G	>200	>200	>2000	>2000	>2000
H	770	860	770	860	860



Note: The space between the right and the wall is more than 1200. In case of overhaul, there should be a hole on the wall for taking out the shaft.

**Grounding line:** insert beside machine box a one-meter long angle iron or water pipe whose top is connected to mainframe grounding line by screws. The mark  is the signal for grounding line.



(1):料斗的安装

(2):挡料牌的安装

1、后出料辊的安装

**Commissioning**: First confirm the power of the machine, after test machine to test each action and signal, if the machine running smoothly, no abnormal sound and vibration can be woven.

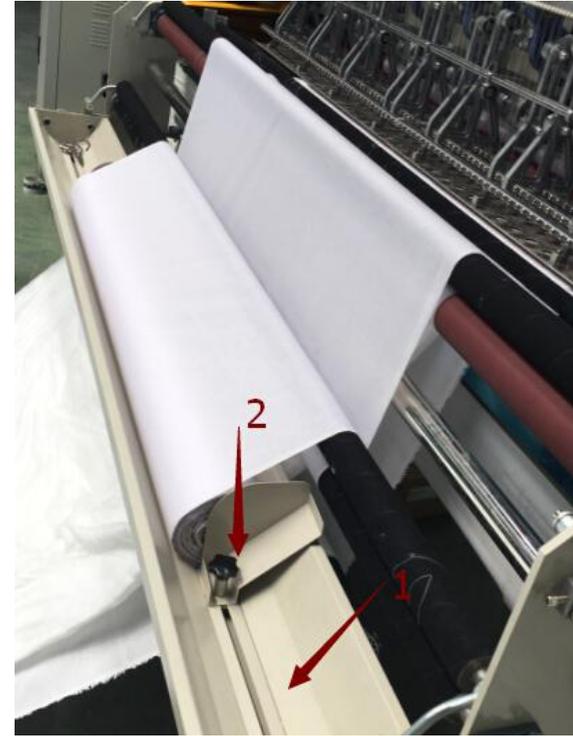
### The requirements of selecting thread

thread-selecting	parameter
material of top thread	nylon/terylene
diameter of top thread	0.15- 0.2 mm
tensility of top thread	> 1.5 kg / 线 径 0.2 mm >2.5kg/φ 0.2mm
snap contractility (500mm in length)	< 10 mm
material of base thread	mixed cotton/terylene
diameter of base thread	0.15 mm
tensility of base thread	> 1kg / 线 径 0.15 mm >1kg/φ0.15mm
snap contractility(500mm in length)	< 5 mm

## 1.4 The installation of the spare parts



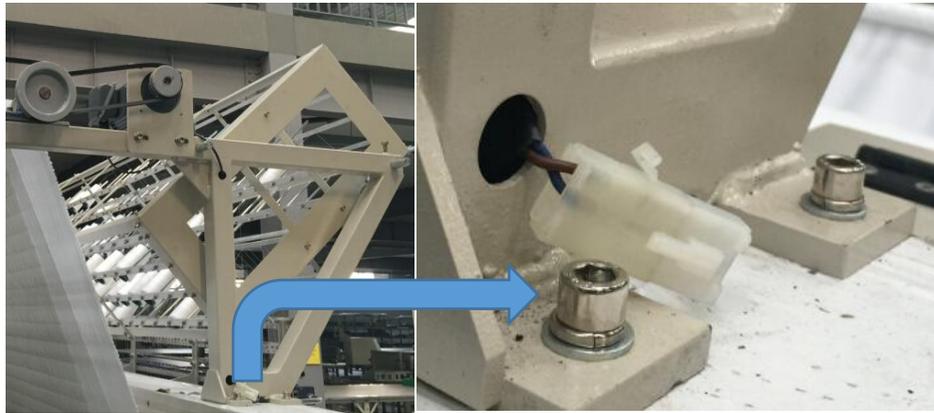
2、线架的安装



(1) :The installation of the hopper

(2):The installation of keep-off device

1、 The installation of the discharging roll



3、机针的正确安装

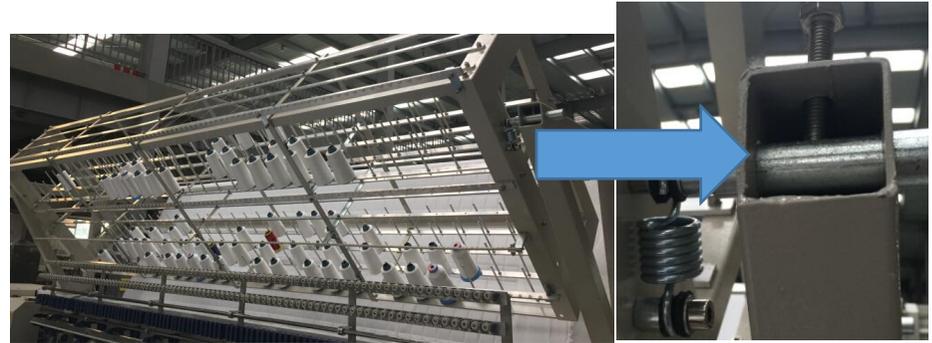


机针的顶端应与机器针排的刻度线平行。针孔凹槽正对机器的右侧。  
固定好螺钉。

4、梭子底线的安装



2、The installation of the thread stand



第一步：将底线出线位置朝上



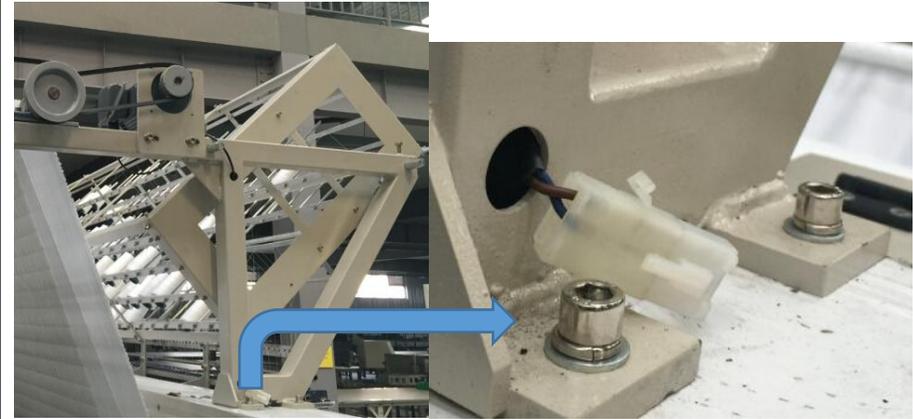
第二步：将底线导入最上端开口



第三步：将底线导入下端开口



第四步：确定上端开口与下端开口的线路需压在压片



3、 Right way of installing needles



The needle Should be installed at the top of the machine needle row parallel scale line. Pinhole grooves are on the right side of the machine. Last ,Fixed the screw.

4、 How to install the bobbin

第五步：将底线压紧



第六步：将底线从过线孔中穿出，压片上的拨片能调解底线松紧



如何安装梭条

How to put the shuttle on the machine

How to install the bobbin

The first step: the bottom line for position up



The second step: will the bottom line into the top openings



Third step: The bottom line into the bottom openings

The fourth step: make sure the upper opening and the bottom opening lines need to pressure in the tablet

根据装针的针排数来确定梭条的安装位置



5、正确的上布方式（底布上布方式与图片一样）

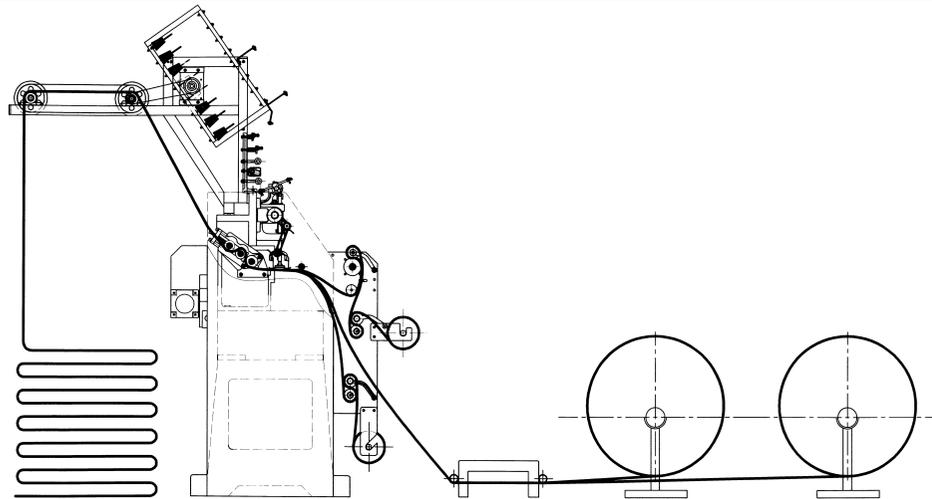


Step 5: the bottom line pressure



Step 6: the bottom line from a line through the hole, dial the patches on the tablet can mediate the tightness of the bottom line





6、穿线方式



1、面线应从旋钮下方孔位进入，在旋钮上缠绕一圈后进入断线检测装置

How to put the shuttle on the machine

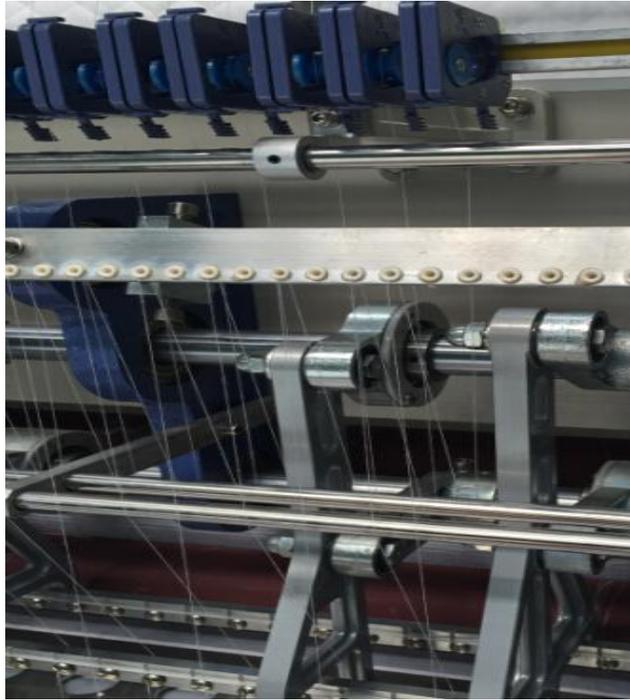
How to put the shuttle on the machine

Set the shuttle and bobbin according the needle you set front

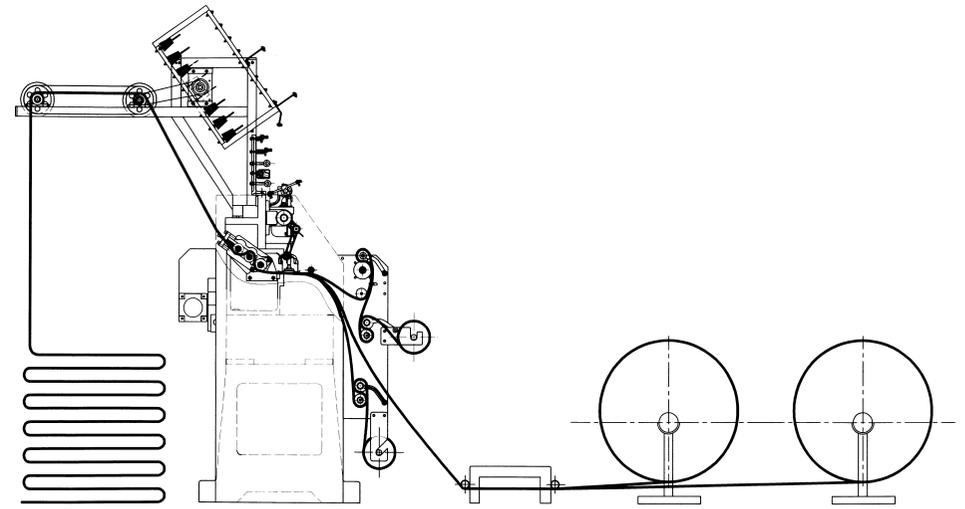


5、 Right way of feeding the fabric.(under fabric is same with it )





2、经过断线检测装置后，进入里面过线杆，翻上来后穿过打线排，从最外端过线杆进入机针



6、 Way of the threading



1、 The number of the line from beneath the knob into, wrapped around a circle on the knob into offline detection device

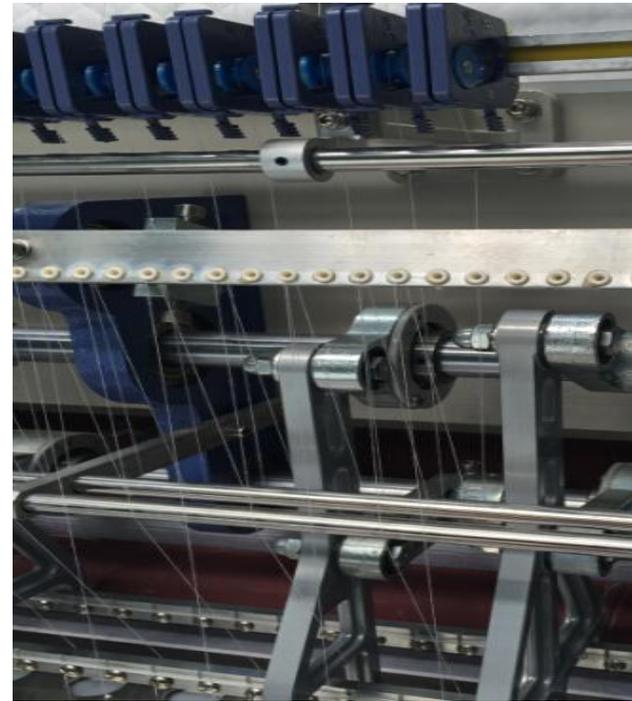


- 3、从针排后侧穿入机针，从左往右穿入机针。
- 4、电控箱线缆的接插



#### 1.4、主要功能特色

- 1、 17 寸大屏幕液晶显示，简单易懂，操作快捷，并且在作业过程



- 2、 After break detection device into a pole, the surface through the lineup row, from the outer side pole into the needle

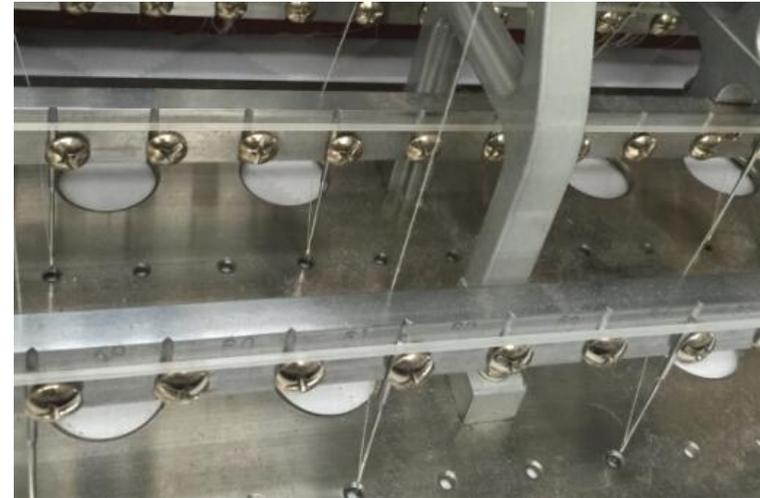
中可实时显示绗缝花样，形象直观。

- 2、增加 U 盘接口，与普通软盘相比，U 盘容量大，读写速度快，携带方便，寿命长。
- 3、直接预览花样的图案信息。选择花样时，可以实时预览花样的实际图案，对所存储的花样一目了然。
- 4、电控支持在最高速为 480rpm 的情况下正常工作。
- 5、电脑上可直接输入和输出花版，更快捷方便。
- 6、断电保护功能。如果在绗缝的中途电源断开，再接通电源可使花样在断电前的状态下继续进行作业。
- 10、断线检测。在绗缝过程中，当面线断线时，机器就会暂停作业，同时屏幕上就会显示相关提示的信息，帮助工人快速分析错误所在。
- 11、统计功能。能自动存储一段时间内的工作信息，可随时查询已绣产量和总产量。

## 1.5、技术规格

表 1.1

序号	内容	技术标准
1	针排间距	多针
2	绗缝针迹	2.0~6.0mm、锁式
3	显示画面	17 寸液晶显示屏



3、 From the back of needle row go through the needle , from left to right into the needle.

4、 electric control box cable plug



## 1.4、 Main features

4	绗缝厚度	≤50mm
5	系统配电	AC380V±10%/50HZ、2.5KVA 3相3线制供电
6	工作环境	5-40℃（工作时）；-10-60℃（存放时） 30-90%RH（相对湿度）
7	工作时间 Working time	24小时连续工作
8	主轴转速	100~500rpm
9	高位停车	有
10	断线自停	有
11	磁盘阅读器	装备USB接口一个

## 第二章 开关及操作界面介绍

### 2.1、开关按钮介绍

启动开关见图 2-1-1。

- 1、 17" display together with graphical user interface make it very easy for users to operate. What is more, quilting patterns can be displayed during quilting.
- 2、 Each machine is designed to have flash disc port. Compared with floppy drive, flash disc has much higher storage capacity, faster read-write speed. It is also easier to carry around and its life span is much longer.
- 3、 Graphic information of pattern can be previewed. You can make real-time preview of actual look of a pattern while you are selecting among patterns stored.
- 4、 electronic control system enables a max. working speed of 480rpm.
- 5、 You can input and output the pattern on the computer directly, it is more simple and convenient.
- 6、 Power-off protection: if a power-off occurs in quilting, rather than

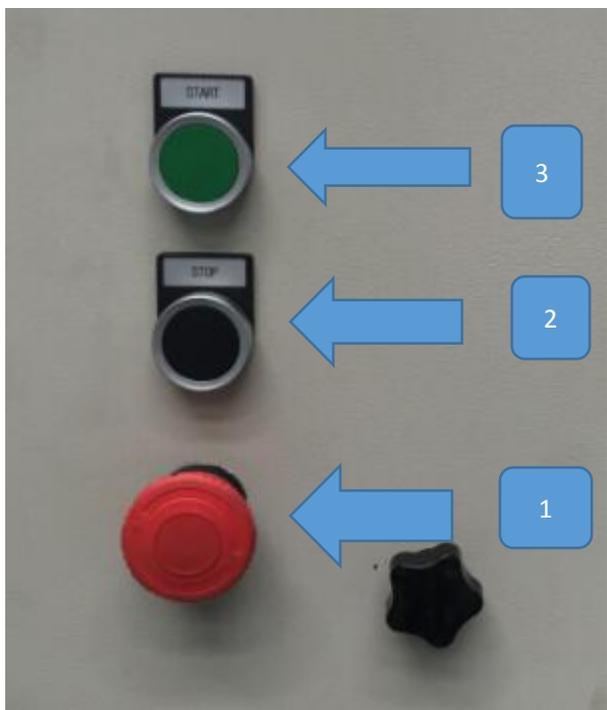


图 Pic 2-1-1

- 1、 红色按钮：急停开关，紧急情况按下可断电。按下后不会自动弹起，若要重新启动机器，需顺时针旋转按钮回复弹起状态后再执行开机流程。
- 2、 黑色按钮：在绗缝过程中短按可暂停，框架停止在当前针迹，主轴停止在零点。
- 3、 绿色按钮：当电控准备就绪，短按绿色按钮则开始绗缝。若在暂停情况下短按可继续绗缝。

return to the start point, machine can continue its work when power is back on.

10、 Thread breakage detection: machine will stop working and LCD will display warning information when upper thread breakage is detected.

11、 Statistic function: machine can automatically store working information data of a period of time for user to see finished production yield and total production yield.

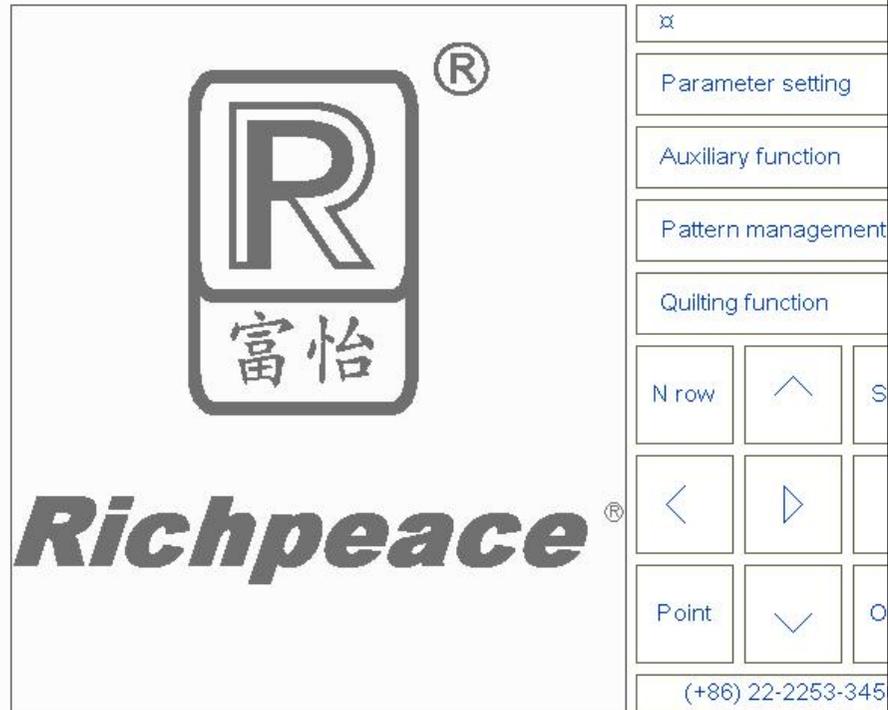
### 1.5、 Technical standard

Table 1.1

Sequenc e number	Content	Technical norms
1	space between needles	Multi needle
2	quilting stitch type	2.0~6.0mm、 locking-type
3	Display resolution	17" LCD display

## 2.2、显示界面介绍

显示屏界面见图



A) : 主轴复位, 详细描述见下文:

A) :

B) : 参数设定: 设置相关的机器参数, 详细描述见下文;

B) :

C) : 辅助功能: 传感器和其他相关状态显示, 详细描述见下文

4	Max. material thickness	≤50mm
5	Input power	AC380V±10%/50HZ、2.5KVA 3-phase 3-wire power
6	Working environment	5-40℃ (working) ; -10-60℃ (storing) 30-90%RH (relative humidity)
7	Working time	24 hours
8	Main shaft speed	100~500rpm
9	High parking	Yes
10	Thread breakage detection	Yes
11	Disk Reader	1 USB port

Chapter 2: Operation panel instruction

### 2.1、Switches and buttons

Start switch is shown in Pic 2-1-1.

- C) :  v
- D) : 花样管理：设置相关功能的程序，详细见下文
- D) :  v ;
- E) : 绗缝功能：设置绗缝相关的功能，详细见下文
- E) :  v
- F) ; 所述针的位置与显示或选择你想使用的针位置；
- F) :
- G) : 显示在显示中显示的图案的大小的比例；
- G) :
- H) : 点动后，机器把主轴停到零位
- H) :
- I) : 收料电机控制键，按下倒带电机运行，绗缝产品整理好

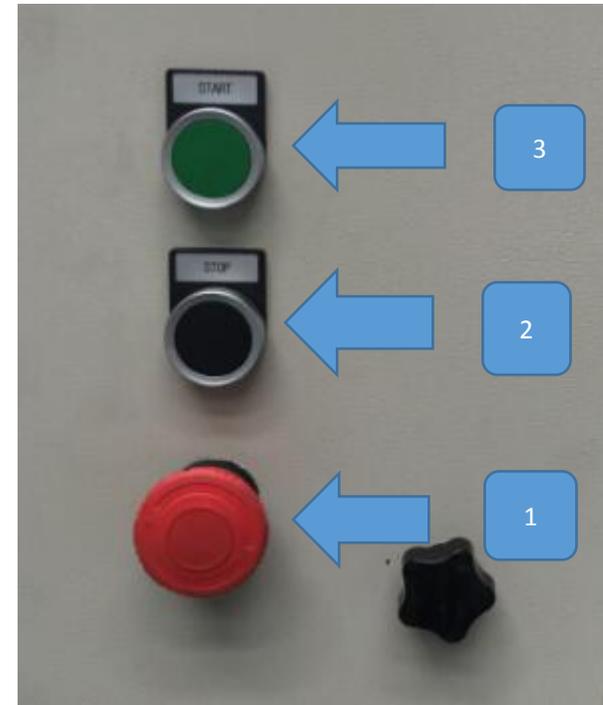


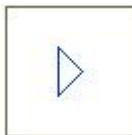
图 Pic 2-1-1

- 1、 Red button: emergency stop. Press it in emergency and it will cut the power. It will not bounce up after press. If you want to restart machine, please rotate it clockwise (as shown by the arrows on the button) to bounce up and perform start procedure.
- 2、 Black button: press it shortly in quilting and machine will stop temporarily (“pause” status), frame will halt at current quilting



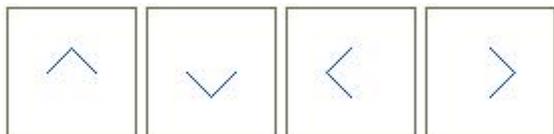
I) :

J) : 在设置减速和调整参数时, 控制增减数字



J) :

K) : 手动控制 X 和 Y 向的移框



K) :

### 第三章 V33-F 绗缝机功能介绍

A) : 主轴复位

☒	
Patten:	170.qui
Step:	2.0 mm
Index:	0 / 80
Bobbit	200.0 m
Output	0.00 m
Area:	20,40

1: 花样: 花样名称显示

position and main shaft halts at zero-point.

- Green button: when electronic control system is ready, press green button shortly and machine will start quilting. If press it shortly at "pause" status, machine will continue quilting.

#### 2.2、ser interface

ser interface is shown



A) :  Principal axis Reset,

Describing in detail below;

- 2: 针步: 当前花样的针步
- 3: 索引: 实时模式引脚数和总数绗缝针数
- 4: 底线检测: 更换底线时使用的停车位长度的底线, 底线设置可以设置基线长度
- 5: 输出: 产量显示
- 6: 区域: X 和 Y 的绗缝区域

## B):参数设置:



### 1、速度设定

B) :  Setting the relevant machine parameters, Describing in detail below;

C) :  Sensors and other related status display, Describing in detail below;

D) :  Setting the Mood for related functions, Describing in detail below;

E) :  Setting functions related to quilting, Describing in detail below;

F) :  Said needle position with the display or select the needle position you want to use;

G) :  The proportion of the size of the pattern shown in the display;

H) :  After jogging the machine to stitch a spindle

## Parameter setting > Speed setting

Main staff speed	280 rpm

Page: 1 / 1

Pgup

Pgdn

OK

Cancel

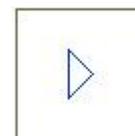
主轴转速设定：设置机器的主轴速度

### 2、检测设定：

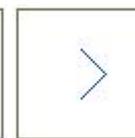
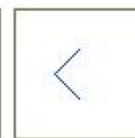
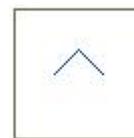
back to zero;



I) : Receipts motor control key, press the rewinding motor operation, the quilted good product collated;



J) : In setting deceleration and adjusting parameters, the control and subtract digits



K) : Manual control under the function of quilting X and Y to mobile

## Chapter 3 Introduction to functions of V33-F Quilting Machine

### A) : Principal axis Reset

## Parameter setting > Detection setting

Break detection	<input type="checkbox"/>
> Break detection Stitches	0
Bobbin thread detection	<input type="checkbox"/>
> Bottom thread	0 m
> Bobbin thread compensation	0.0 ‰
Output compensation	0 ‰
Output alarm	<input checked="" type="checkbox"/>
> Alarm value	100 m
Infrared test	<input type="checkbox"/>

Page: 1 / 1

Pgup

Pgdn

OK

Cancel

- 断线检测：选择此断开检测开关；
- 断线检测针：选择此断开检测功能，使用箭头键来调整检测的灵敏度

- 底线检测：选择此选项开关底线检测；
- 底线：选择要打开的底线检测，并设置量的底线，在结束时，机器检测到的值等于机器的设定值，及时更换底线；
- 底线检测补偿：当开启的底线检测功能，由于不同的需要，织物的厚度设置基线补偿增加的底线检测的准确性，从理论上弥补了织物的厚度

●输出补偿：布可能因测量不准，这是根据生产实际情况做出相应的补偿

●报警输出：多少产品你需要设置一个预定的输出生产

Patten:	170.qui
Step:	2.0 mm
Index:	0 / 80
Bobbi	200.0 m
Outpur	0.00 m
Area:	20,40

- 1: Pattern: pattern name display;;
- 2: Step: Now stitch pattern size settings;
- 3: Index: The real-time pattern pin number and total number of stitches Quilting;
- 4: Bottom line: Replacing baseline used when parking the length of the bottom line, the bottom line settings can be set baseline length XX;
- 5: Output: Yield Display;
- 6: Area: quilting to the range of X to Y;

## B) : Parameter setting

●红外检测：检测是否操作不慎进入工作区，如果有人进入工作区域，然后停止工作，防止人身伤害；

### 3、软件设置

Parameter setting > Software settings

Background color	White
Theme color	Blue
Language selection	English
Clear output	0.00 m
Interface update *	
MCU update *	
Clock management *	
Screen regulation *	
Display LOGO(Restart effect)	<input checked="" type="checkbox"/>
Use the old interface(effect when restart) *	<input checked="" type="checkbox"/>

Page: 1 / 3

Pgup Pgdn OK Cancel

- 背景颜色：设置图形显示界面的背景色
- 主题颜色：主题颜色选择
- 语言选择：选择一个语言，包括汉语、英语、波兰
- 清除产量：机器生产计数输出，如果需要重新计数重置为零
- 界面升级：此功能是用来升级界面，插入 U 盘和遵循选择你需要升级的版本升级提示。（升级过程无法关机，等待机器重新启动本身）；
- 主控升级：此功能是用来更新程序的主版，插入 U 盘和遵循选择你需要升级的版本升级提示。（升级过程无法关机，等待机器重新启动本身）

Parameter setting ^

Speed setting

Detection setting

Action setting

Software settings

System settings

### 1、Speed setting:

Parameter setting > Speed setting

Main staff speed	280 rpm

Page: 1 / 1

Pgup Pgdn OK Cancel

- 时钟管理：调整机器的时间显示
- 屏幕调节：选择要想在屏幕上的操作，如果你点击触摸屏，发生上述所需的行动，在任何功能位置点击箭头，选择你需要的这个功能，屏幕校准，改善情况；
- 显示标识：需要重新启动才能生效；设置图形显示区：显示在图标显示公司标志
- 使用旧界面：生效，需要重新启动；这个新的界面设计界面，有些用户习惯使用旧的界面，你可以选择更换这里

### Parameter setting > Software settings

Size standard	Metric
Boot time *	0 : 0 : 0
Running time *	0 : 0 : 0

Page: 2 / 3

Pgup

Pgdn

OK

Cancel

尺寸标准：选择计量单位的大小

- 开机时间：总开机时间计数；
- 运行时间：机器运行时间计数

- Main staff speed: Sets the rated speed of the machine;

### 2、Detection setting:

#### Parameter setting > Detection setting

Break detection	<input type="checkbox"/>
> Break detection Stitches	0
Bobbin thread detection	<input type="checkbox"/>
> Bottom thread	0 m
> Bobbin thread compensation	0.0 %
Output compensation	0 %
Output alarm	<input checked="" type="checkbox"/>
> Alarm value	100 m
Infrared test	<input type="checkbox"/>

Page: 1 / 1

Pgup

Pgdn

OK

Cancel

- Break detection: Select this disconnection detection switch;

Break detection stitches: Select this to turn disconnection detection function, use the arrow keys to adjust the sensitivity of detection;

- Bottom thread detection: Select this option to switch the bottom line detection;

Bottom thread : Select to open the bottom line detection,

## Parameter setting > Software settings

Super user \*\*



Page: 3 / 3

Pgup

Pgdn

OK

Cancel

超级用户：维修使用，非用户入口

**C) : 辅助功能:**

and set the amount of the bottom line, in the end when the machine detects the line with the value equal to the set value of the machine park, prompt replacement of the bottom line;

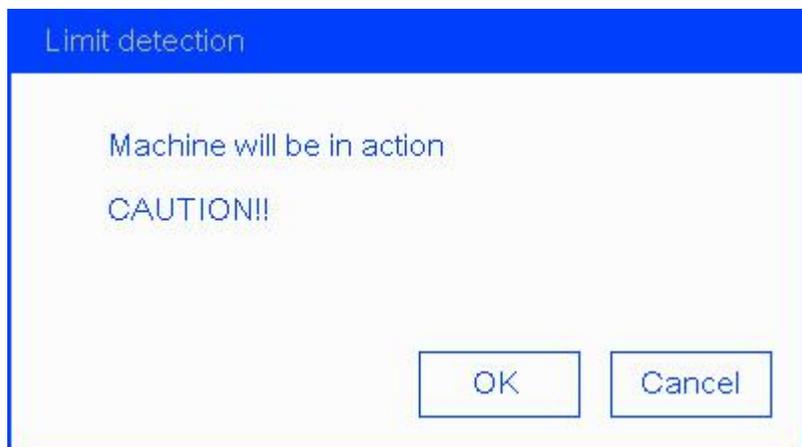
Bottom thread compensation: when opening the bottom line detection function, due to the different needs of the thickness of the fabric to set baseline compensation increase the accuracy of detection of the bottom line, the bottom line is theoretically compensate for the thickness of the fabric;

- Output compensation: the cloth may be because of measurement are not allowed, which is to make the appropriate compensation according to the actual situation set up production;
- Output alarm: how much product you need to be set to a predetermined output after production is not;
- Infrared test :Detecting whether the operator accidentally enter the work area, if someone enters the work area, then stop working, to prevent personal injury;

### 3、Software Settings:



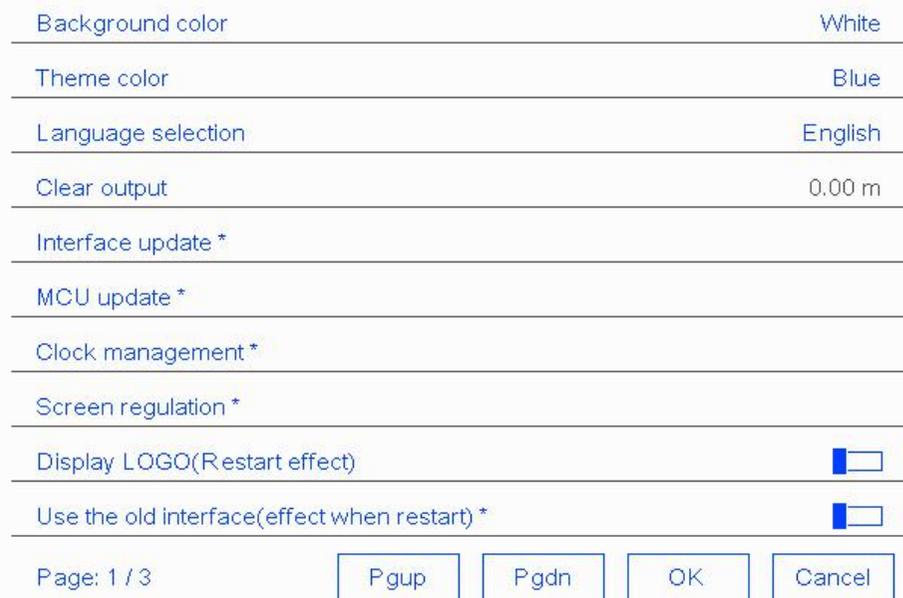
## 1、限位检测



绗缝机自动确定当前位置将达到极限；

## 2、针梭调整

## Parameter setting > Software settings



- Background Color: set the background color of the pattern display interface;
- Theme color : The theme colors to choose;
- Language selection: Choose a language, including Chinese, English, Polish;
- Clear output: machine production output count, if necessary re-count reset to zero;
- Interface Upgrade: This function is used to upgrade the interface, insert U disk and follow the prompts to select the version you need to upgrade, upgrade. (Upgrade process can not power off, wait for the machine to reboot itself);
- MCU Upgrade: This function is used to update the master

## Auxiliary function > Needle&shuttle Adjust

Mainshaft jog

Mainshaft running

Turn mainshaft by hand

Please select the operating button



Exit

主轴点动：机器自动复位并停到高位

主轴运行：主轴会低速转，可调速

主轴的手：此按钮工作可手动转动主轴，不在受主轴电机的锁控

### 3、传感信号：

version of the program, insert U disk and follow the prompts to select the version you need to upgrade, upgrade. (Upgrade process can not power off, wait for the machine to reboot itself)

- Clock Management: adjust the machine time;
- Screen regulation: Select the operation you want to want to on the screen, if you click on the touch screen, the occurrence of said desired action, click on the arrow at no functional location, you need to select this function, a screen calibration, to improve the situation;
- Display LOGO: Requires a reboot to take effect; set the pattern display area when icon shows the company: Showing LOGO;
- Use the old interface: Entry into force requires a reboot; this new interface design interface, some users accustomed to using the old interface, you can then choose to replace here;

## Parameter setting > Software settings

Size standard

Metric

Boot time \*

0:0:0

Running time \*

0:0:0

Page: 2 / 3

Pgup

Pgdn

OK

Cancel

## Auxiliary function > Sensing signal

- Main staff zero
- X Left Limited
- X Right Limited
- Thread break detection
- Start button
- Pause button
- Cutter pause
- Safety input

Exit

如果每个传感器信号接入相应的信号灯前，这个页面很容易查看每个信号的实时状态

### 4、模拟绗缝

选择“绗缝模拟”功能，针梭会保持不动，当前设备会沿花型轨迹空走；

### 5、工作密码

- Size standard: select the size of the units of measurement;
- Boot time: The total boot time count;
- Running time: machine run time count;

## Parameter setting > Software settings

Super user \*\*

Page: 3 / 3

Pgup

Pgdn

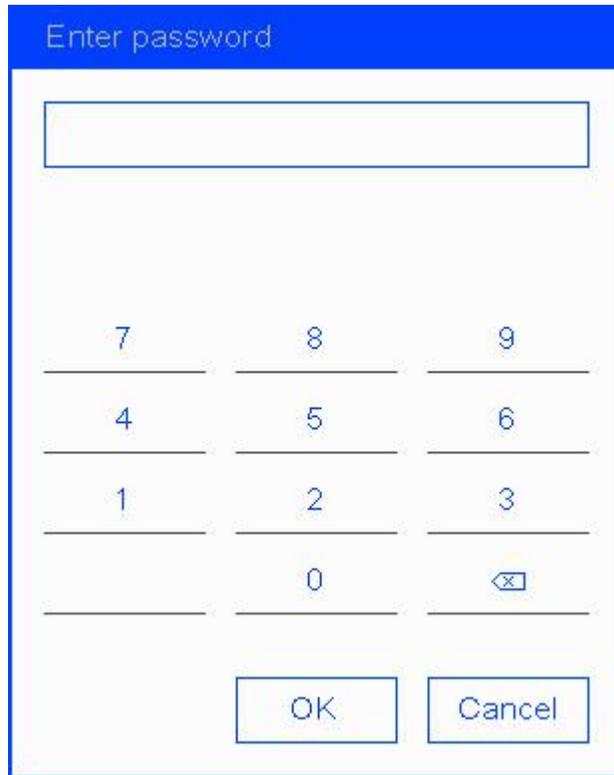
OK

Cancel

- Super User: Repairs to this use, non-user entry;

## C) : Auxiliary function:

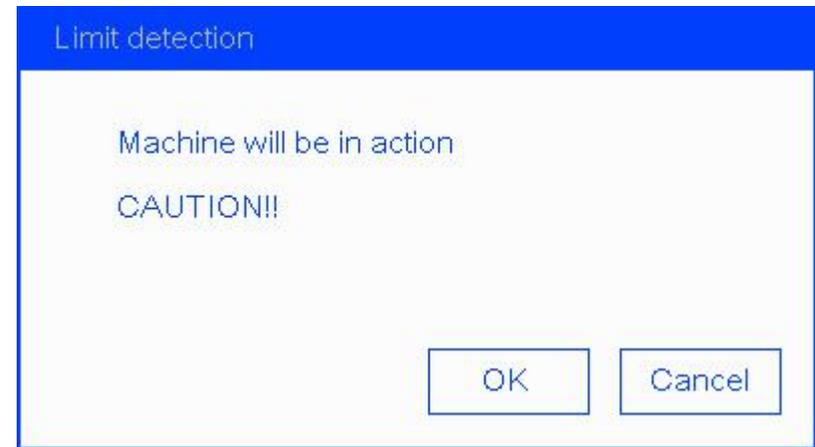




- 设置机器的密码和解密

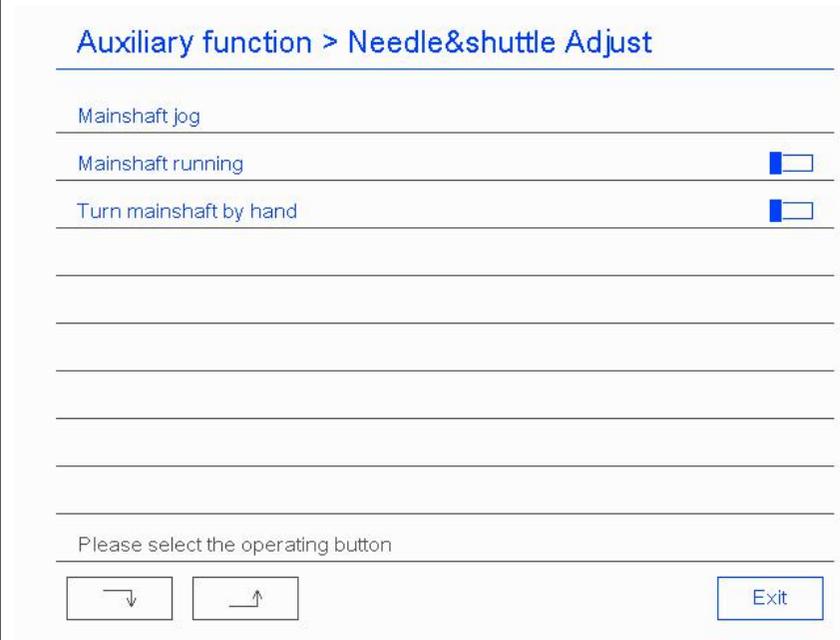
## D) : 花样管理:

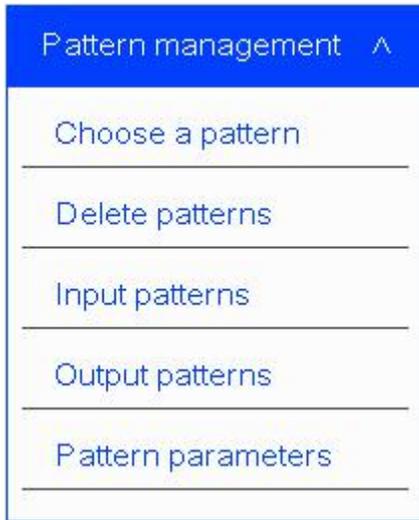
### 1、 Limit Detection :



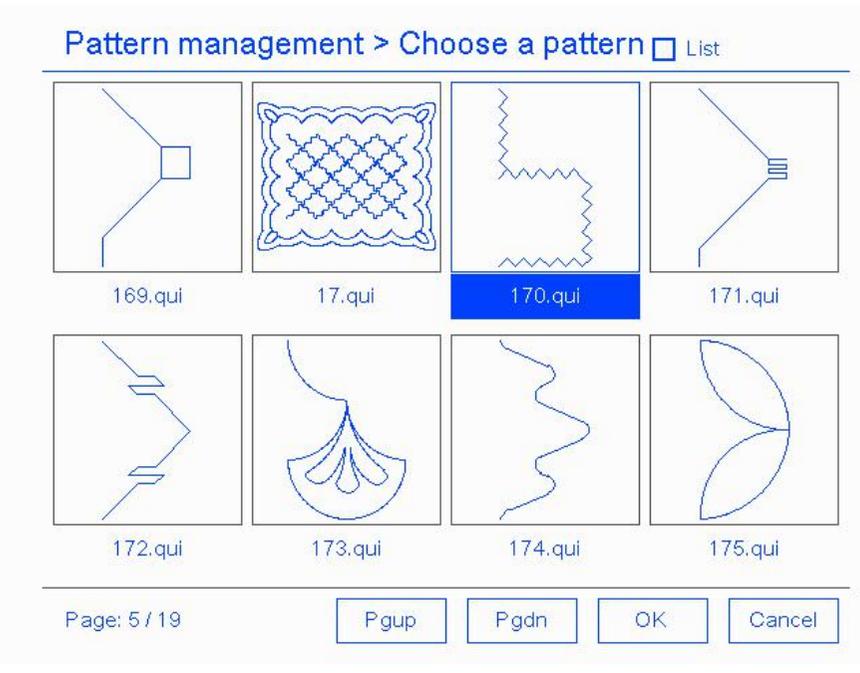
- Quilting machine automatically determines whether the current position will hit the limit;

### 2、 Needle& shuttle Adjust:





### 1、选择花样



Mainshaft Jog: Jog spindle can be used for homing, while controlling the pin; it is divided into its own axis of rotation, and turned by hand two methods;

Mainshaft running: This is used to operate the spindle, execute selection, press the key to accelerate Down key deceleration;

The Mainshaft by hand: Select After performing handwheel adjustment spindle;

### 3、Sensing signal:

#### Auxiliary function > Sensing signal

Main staff zero

---

X Left Limited

---

X Right Limited

---

Thread break detection

---

Start button

---

Pause button

---

Cutter pause

---

Safety input

---



---

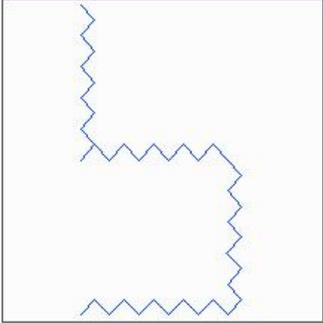


---

- If each sensor signal access the corresponding signal will light before, this page is easy to view real-time status of each signal

## Pattern management > Choose a pattern List

09.qui	10.qui
11.qui	111111.qui
117.qui	118.qui
12.qui	13.qui
14.qui	15.qui
16.qui	168.qui
169.qui	17.qui
170.qui	171.qui
172.qui	173.qui
174.qui	175.qui



Step : 2.0  
size : X:20 , Y:40

Page: 2 / 8

选择模式，你可以选择任何格式和两种 DAT 格式，选择列表后，点击右边的预览将图案的名称，根据需求模式选择。

## 2、删除花样

## 4、Quilting simulation:

- Select "Quilting simulation" function, the shuttle does not move the needle nose do simulate walking in accordance with the currently selected pattern track;

## 5、Working password:

Enter password

7	8	9
4	5	6
1	2	3
	0	<input type="button" value="⌫"/>

- Set the stage for the password and decrypt password;

## D) : Design management:

## Pattern management > Delete patterns USB

0000000.qui	0005a.qui
0006a.qui	004.qui
01.qui	0123wacd.qui
014.qui	02.qui
03.qui	04.qui
05.qui	058.qui
059.qui	06.qui
060.qui	061.qui
062.qui	07.qui
076.qui	08.qui

Select all

preview

Page: 1 / 8

Pgup

Pgdn

OK

Cancel

这个功能可以删除的单元模式，可以选择，选择全部删除，此操作谨慎

### 3、输入花样

## Pattern management ^

Choose a pattern

Delete patterns

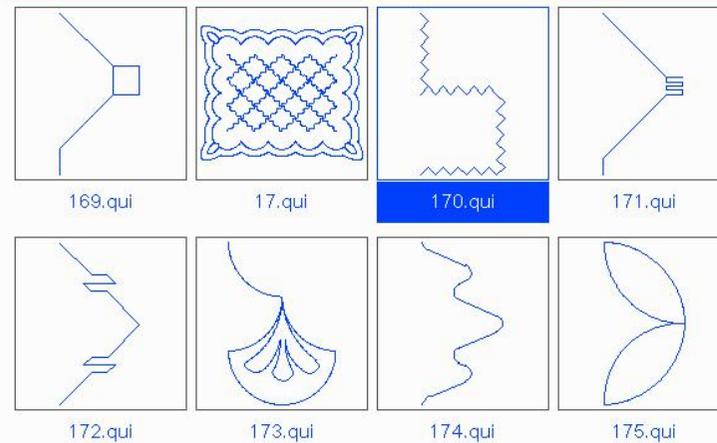
Input patterns

Output patterns

Pattern parameters

### 2、Choose a pattern:

## Pattern management > Choose a pattern List



Page: 5 / 19

Pgup

Pgdn

OK

Cancel

## Pattern management > Input patterns

001.qui	002.qui
003.qui	004.qui
005.qui	006.qui
007.qui	008.qui
009.qui	010.qui
011.qui	012.qui
013.qui	014.qui
015.qui	016.qui
017.qui	018.qui
019.qui	020.qui

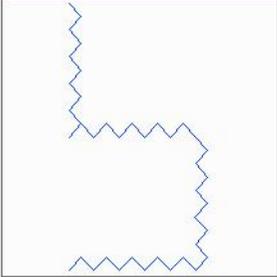
Select all  
 preview

Page: 1 / 10    Pgup    Pgdn    OK    Cancel

- 进入一般选择 USB 存储模式，网络服务器是可选的，U 盘插按照说明书
- 如上图所示，选择所需的图案可以被确定  
4、花样输出

## Pattern management > Choose a pattern List

09.qui	10.qui
11.qui	111111.qui
117.qui	118.qui
12.qui	13.qui
14.qui	15.qui
16.qui	168.qui
169.qui	17.qui
170.qui	171.qui
172.qui	173.qui
174.qui	175.qui



Step : 2.0  
size : X:20 , Y:40

Page: 2 / 8    Pgup    Pgdn    OK    Cancel

- Select the pattern, you can select QUI format and two kinds DAT format, click on the right after the selection list will be the name of the pattern pattern preview, choose according to demand patterns.

## 2、Delete pattern:

### Pattern management > Output patterns

0000000.qui	0005a.qui
0006a.qui	004.qui
01.qui	0123wacd.qui
014.qui	02.qui
03.qui	04.qui
05.qui	058.qui
059.qui	06.qui
060.qui	061.qui
062.qui	07.qui
076.qui	08.qui

Select all

preview

Page: 1 / 8

Pgup

Pgdn

OK

Cancel

插入 U 盘，选择输出模式选项，如上图所示，选择所需的存储模式确定为多项选择，选择所有

#### 5、花样参数：

### Pattern management > Delete patterns USB

0000000.qui	0005a.qui
0006a.qui	004.qui
01.qui	0123wacd.qui
014.qui	02.qui
03.qui	04.qui
05.qui	058.qui
059.qui	06.qui
060.qui	061.qui
062.qui	07.qui
076.qui	08.qui

Select all

preview

Page: 1 / 8

Pgup

Pgdn

OK

Cancel

- This feature can remove the unit pattern, can be selected, select all to delete, this operation with caution

#### 3、Input pattern:

## Set quilting parameters > 170. qui

Step	2.0 mm
Width X	20.0 mm
Length Y	40.0 mm
XY Uniform scale	<input checked="" type="checkbox"/>
Angle amendment X+	0.0 mm
Angle amendment X-	0.0 mm
Angle amendment Y+	0.0 mm
Angle amendment Y-	0.0 mm
Roller compensation	0.0 ‰
Micro-stitch at corner	<input type="checkbox"/>

Page: 1 / 1

Pgup

Pgdn

OK

Cancel

- 针步：选择所需的针步
- X 向宽度：X 向花样的大小
- Y 向长度：Y 向花样的长度
- XY 等比例缩放：花样将成比例变化
- 角度修正：当被发现没有尖角，这些参数的增加，你可以做一个尖锐的角的变化
- 罗拉补偿：当绗缝被发现倒 Y 偏移量是不一样的，导致缝纫圆不圆，封闭图形的接缝密封等问题不能增加或减少的价值，可以补偿画板
- 拐角针布：拐角分割针步降速

### E) : 绗缝功能:

## Pattern management > Input patterns

001. qui	002. qui
003. qui	004. qui
005. qui	006. qui
007. qui	008. qui
009. qui	010. qui
011. qui	012. qui
013. qui	014. qui
015. qui	016. qui
017. qui	018. qui
019. qui	020. qui

Select all

preview

Page: 1 / 10

Pgup

Pgdn

OK

Cancel

- Enter the pattern generally choose USB memory, a network server is optional, U disk is inserted in accordance with the instructions.
- As shown above, select the desired pattern can be determined

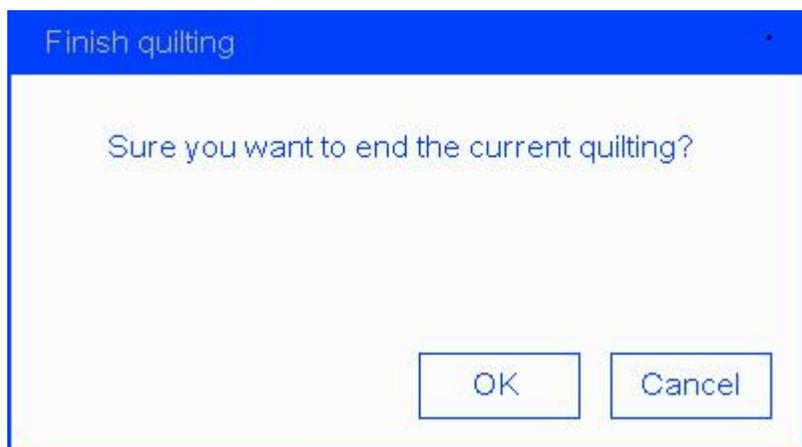
### 4、Output pattern:



### 1、开始绗缝

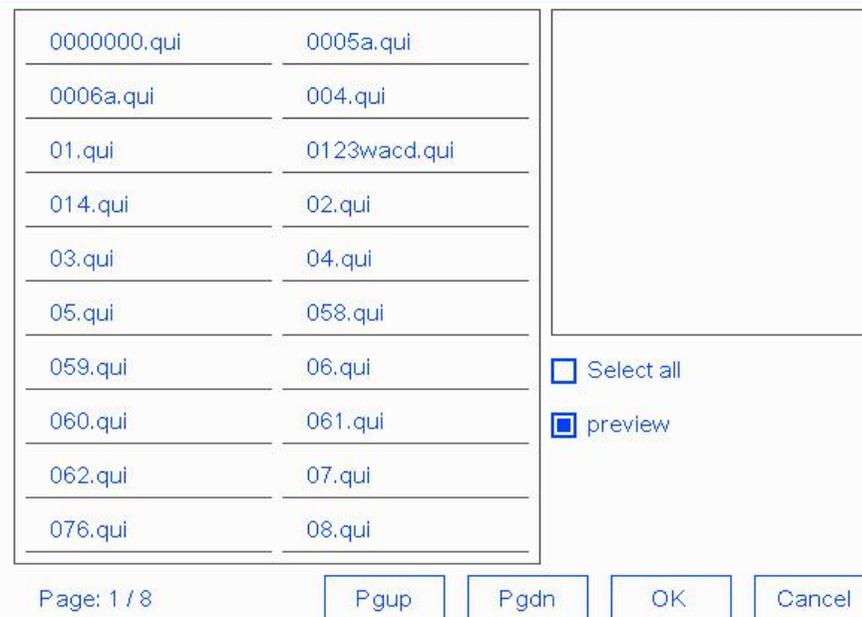
选择开始绗缝后机器开始运转，与启动按钮功能一样。

### 2、结束绗缝



选择结束绗缝后，机器会报警提醒并回到花样的起点

## Pattern management > Output patterns

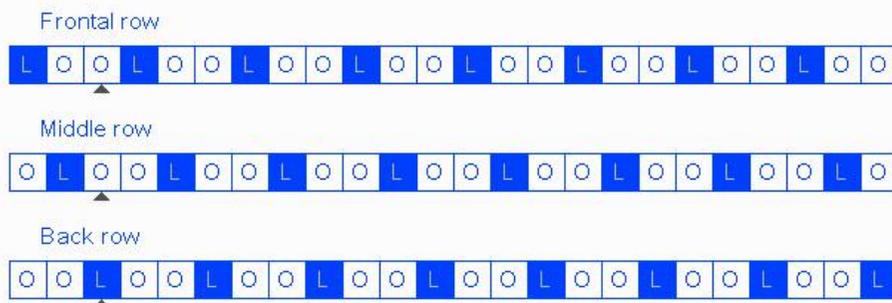


- Insert U disk, select the output pattern option, as shown above to select the desired stored pattern is determined to be multiple choice and select all.

### 5、Pattern parameters:

## F) : 排针

### R/N setting



NOTE:O-No needle,L-Left needle,R-Right needle,X-left needle and right needl

Loop OK Cancel

设置每行的第一针，针的位置点击“循环”，在上面的图中所示位置工作

## 第四章 绗缝流程介绍

### 4.1 、如何进行第一次绗缝

电脑绗缝机的绗缝是基于其内存中存储的花样而进行的，在您第一次正式使用机器之前，应该按照如下步骤进行：

### Set quilting parameters > 170.qui

Step	2.0 mm
Width X	20.0 mm
Length Y	40.0 mm
XY Uniform scale	<input checked="" type="checkbox"/>
Angle amendment X+	0.0 mm
Angle amendment X-	0.0 mm
Angle amendment Y+	0.0 mm
Angle amendment Y-	0.0 mm
Roller compensation	0.0 ‰
Micro-stitch at corner	<input type="checkbox"/>

Page: 1 / 1

Pgup

Pgdn

OK

Cancel

- Step: Set the request Quilting stitches size;
- Width X: X required quilted pattern to size;
- Length Y: Y-pattern quilting required to size;
- XY uniform scale: the pattern is equal proportion to zoom in the display;
- Angle correction X +, X-, Y +, Y-: When quilting found no sharp corners, the increase in these parameters, you can make a sharp angle change.
- Roller compensation: When quilting is found to reversing Y offsets are not the same, resulting in sewing circle is not round, closed graph seam sealing and other problems can not increase or decrease the value, can be compensated Sketchpad.

第一步：用 U 盘输入您需要绗缝的花样到系统内存中；  
第二步：从内存中选择并确定绗缝花样；  
第三步：准备布料，设置机器系统参数；  
第四步：确定机针、梭子和梭条全部安装正确。花样尺寸不宜过

大

第五步：做完上面工作，按启动按钮，开始绗缝。

#### 4.2、如何开机

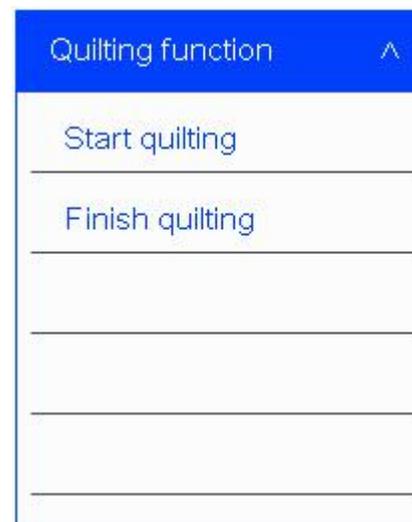
接通电网输入到电控的主电源，然后将大红色开关旋转到 ON；  
按下电控箱前面的绿色 POWER 按钮，操作箱上的显示器就会开始显示，

#### 4.3、绗缝的基本流程

对于初次使用本机器用户，可以参照下面的操作流程指示来操作；而对于已有使用经验的用户来说，也有助于重新确认操作方法。

- Micro-stitch at corner: In the quilting process, encountered corner deceleration machine;

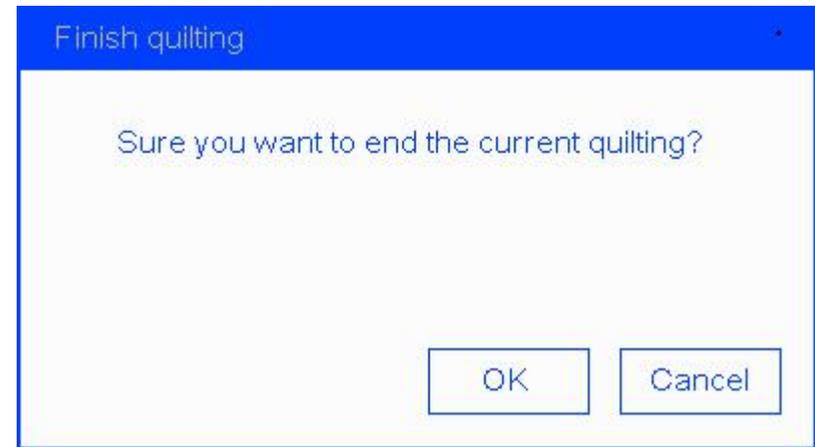
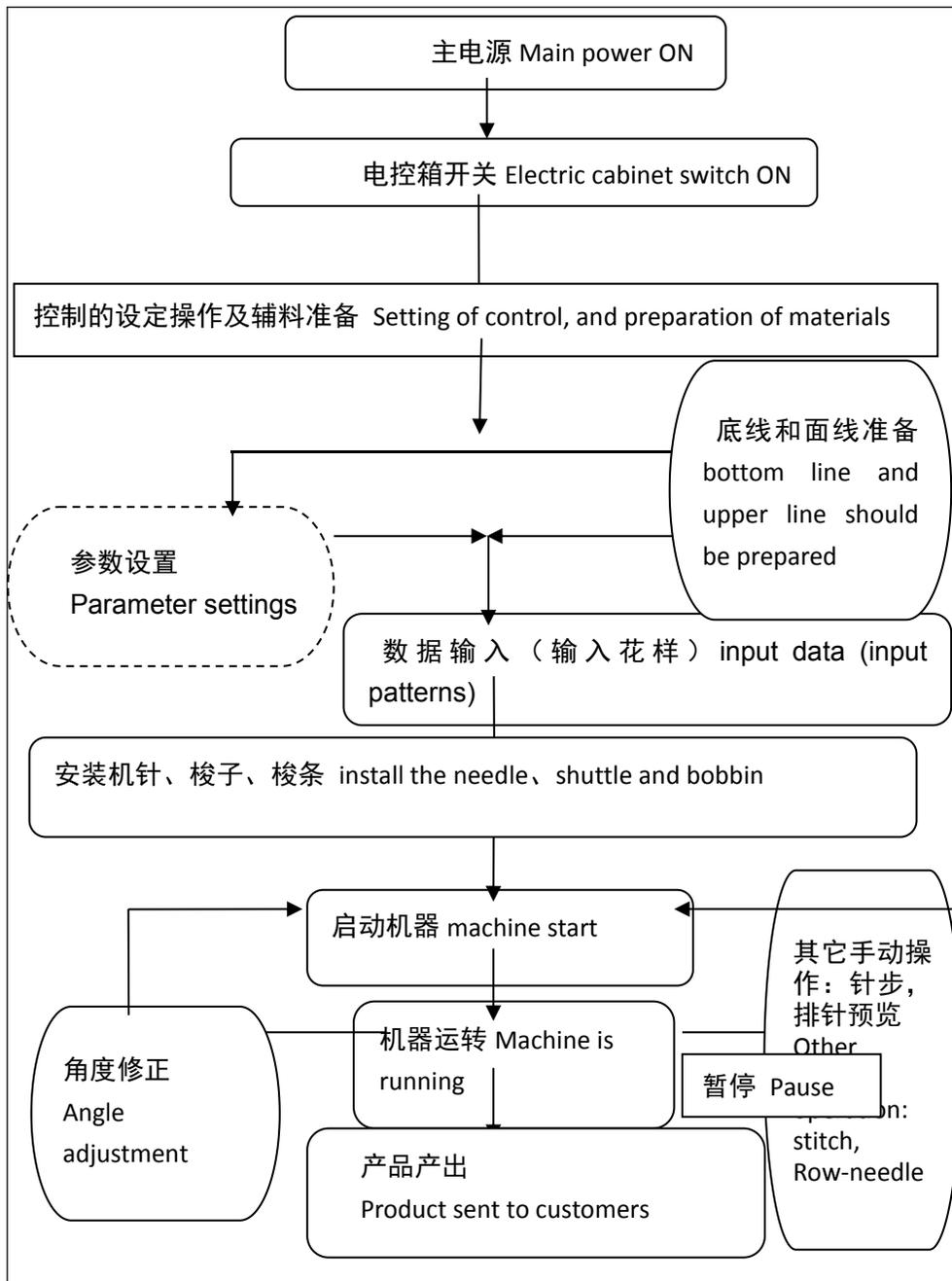
#### E) : Quilting function:



##### 1、 Start quilting:

- Select "Start quilting" function, the machine is running, the same function key to start this function with the green start button on the machine.

##### 1、 Finish quilting:



- Select "Finish quilting" function, the machine will start from the drawing board of the first needle quilting;

### F) : Pin:

R/N setting

Frontal row

L O L O L O L O L O L O L O L O L O L O

Middle row

O L O L O L O L O L O L O L O L O L O

Back row

O O L O L O L O L O L O L O L O L O L

NOTE: O-No needle, L-Left needle, R-Right needle, X-left needle and right needl

Loop OK Cancel

**【说明】**：1、虚线框表示不是每次都要进行的操作，可以跳过，直接进行下一步操作。一次绗缝作业结束后，系统会记住对该花样的参数设置。机器转绗缝其他花样后，再回到已绗缝花样，该花样原有参数设置不变。2、暂停后若要重新启动机器，须启动按钮。

## 第五章 常见故障及处理办法

### 5.1、 绗缝质量问题及解决方法

#### 1、断线

##### Easy break

1、线太脆弱，不符合规格要求,针与梭子尖在相交位置的间隙过小。

2、串错线

3、压线碟调节过紧。

4、线中途被卡死。

5、新梭子有毛刺。

6、底梭条定位销松动。

7、传动机构形位变动。

#### 1、排除方法

1、按上述选线方法挑选合格的线更换之。

2、参看( 穿线图 )将线纠正。

- Set each row of the first needle, the needle position click "loop" as shown in the above figure position to work;

## Chapter 4 Quilting procedure

### 4.1 、 How to perform the first quilting with your machine

Quilting by computerized quilting machine is determined by patterns that stored inside machine. Please follow the precautions and instructions below when conducting your first quilting with this machine.

Step 1: put patterns in flash disc into machine's system.

Step 2: select and confirm the pattern you want to quilt.

Step 3: prepare fabric and set system parameters.

Step 4: Make sure the needle, the shuttle and other all need to be installed correctly. The design size should not be too big

Step 5: all the work above are done, press start button and start quilting.

### 4.2、 How to launch your quilting machine

Connect machine to power, and rotate the red button (No.2 in Pic 2-2-1) to "ON" position. Press the green "POWER" button in the front of electric cabinet and the display on operation box will display

- 3、调节压线碟螺母。
- 4、检查穿线线路
- 5、更换或轻轻打磨
- 6、紧固定位销
- 7、调整底梭与梭床间隙在 1mm 左右。

## 2、跳线

- 1、针与梭子尖在相交位置的间隙过大。
- 2、针高低变了位置。
- 3、针孔凹位方位安装不恰当。
- 4、线的伸缩性太大。
- 5、打包量调整不当。
- 6、底梭条定位销松动。
- 7、梭子质量差。
- 8、传动机构形位变动。
- 9、静电感应。

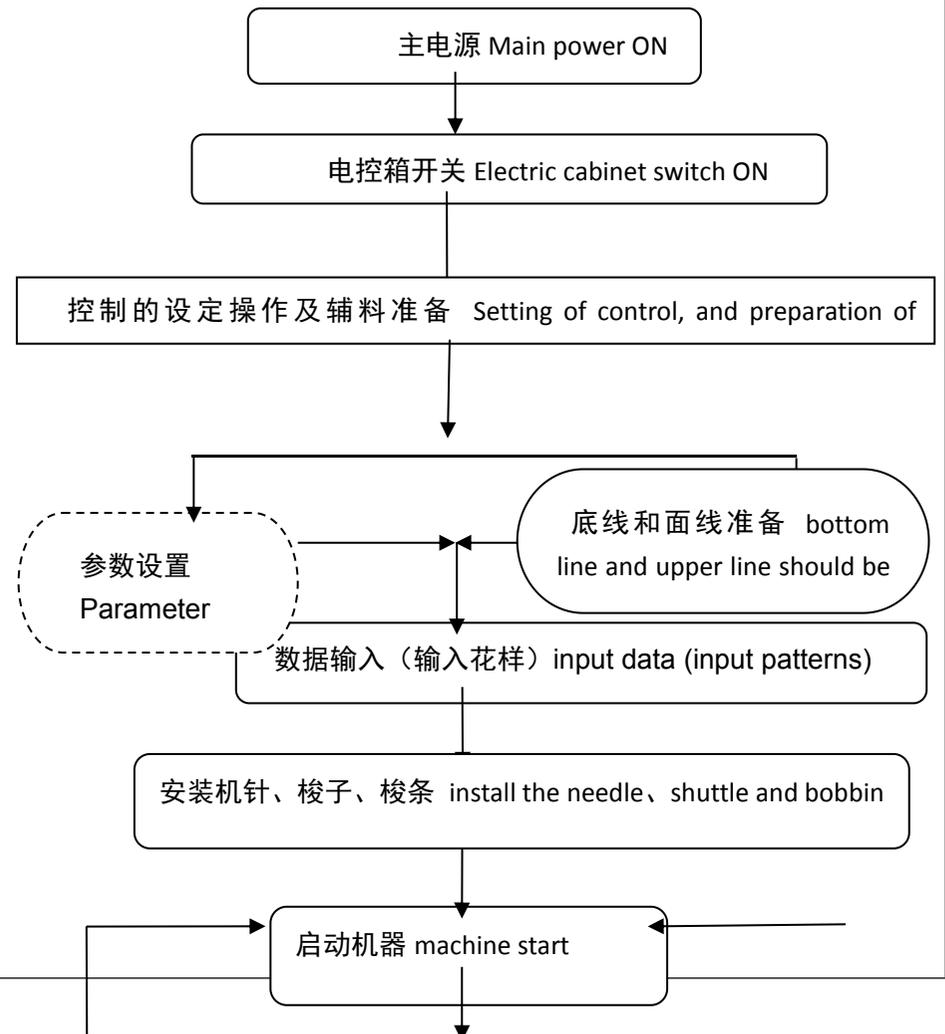
## 2、排除方法

- 1、间隙 0.2 mm ~ 0.3 mm 左右。
- 2、调整机针的位置
- 3、机针凹槽位置应正对机器右侧
- 4、按选线表要求更换伸缩性小的线。

contents.

### 4.3、Basic procedure of quilting

If this is your first time to use our machine, please follow the instructions below to operate the machine. If this is not your first time with our machine, it is good to learn operation method again.



5、打包量为 5mm。

6、更换梭条。

7、更换梭子。

8、请有经验的师傅校正传动机构。下面会说如何调整机械机构

9、在线上泼水，选用无弹性线。

## 5.2、系统报错及解决方法

### 1、主轴不在零位：

(1) 主轴传感器（即主轴零位传感器）没有感应到磁铁。手动转动主轴至零位，观察传感器在传感信号中是否有存在

(2) 若传感器亮，且在传感信号测试里手动用磁钢给主轴传感器信号，检查传感器是否有效，如果无效，说明主板或主轴传感器有问题，更换主板或主轴传感器。

### 2、主轴系统故障：

(1) 检查主轴驱动器有无报错，手动摇动主轴有无卡滞现象；

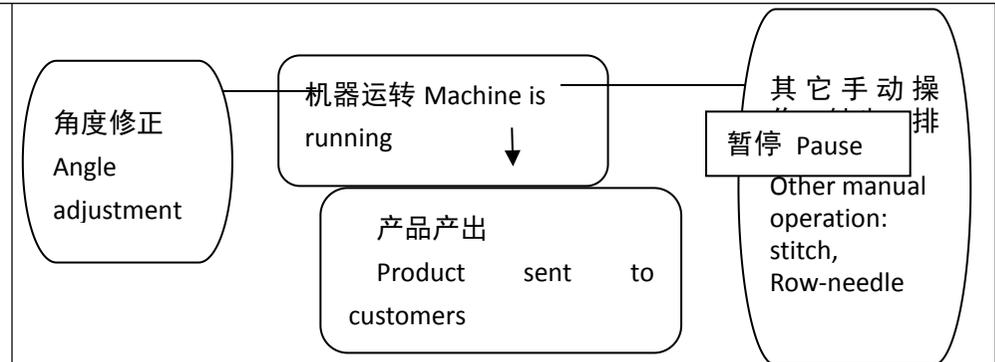
(2) 从控 IO 程序或主板坏，更换 IO 程序或主板。

### 1、CRT 显示 E04

故障原因：PC 机或工控机与 B1 板通讯错。

排除方法：检修或重插通讯电缆。

### 2、CRT 显示左限位或者右限位



**[Note] 1. It is not necessary to follow the instructions in dotted line boxes every time you use your machine, some of them can be skipped to next step. System will remember and store setting for a pattern after quilting, and you do not need to reset parameters again for this pattern after you made other patterns. 2. If you want to restart machine after pause, you will have to press the green button on the machine**

## Chapter 6: FAQs and methods of disposition

### 5.1、 Quilting quality problems and disposition methods

#### 1、 Easy break

1、 The thread is fragile and unqualified. The space between needle and shuttle tip is too small.

2、 The thread skips.

3、 The thread clamp is too tense.

4、 The thread is chucked when quilting.

5、 There are burrs on new shuttles.

6、 The position pin of bottom shuttle bar is loose.

7、 The position of driving device is changed

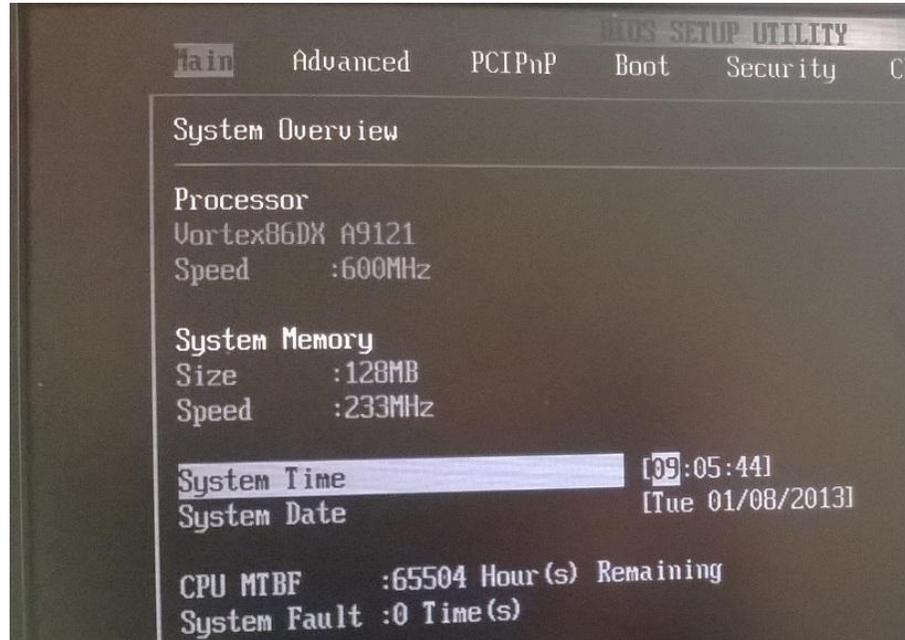
#### 1、 Remedies

### 3、电脑无法识别 USB

第一步:

找一个 PS/2 接口键盘, 接入到工控板的键盘接口上。

第二步: 重启机器, 在启动过程中按键盘【DEL】键进入 BIOS 设置界面 (如下图)



第三步: 按键盘【右】键进入[Advanced]菜单(如下图)

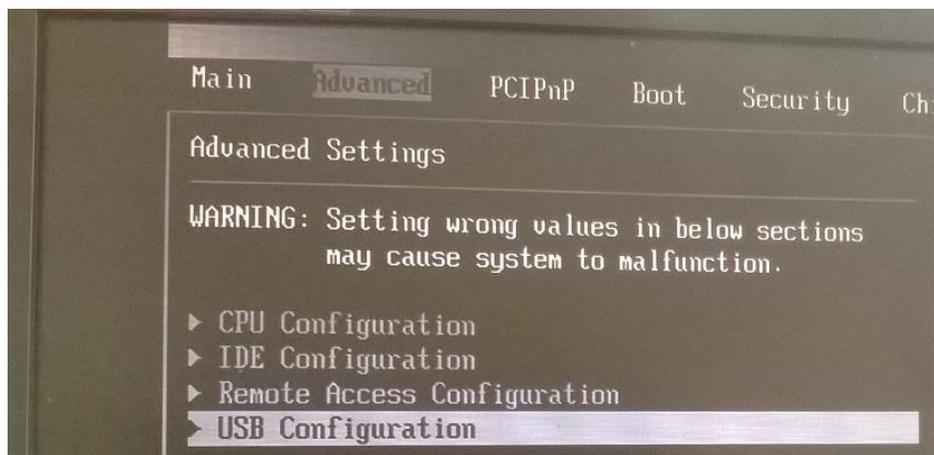
- 1、 Choose qualified thread according to the selecting requirement.
- 2、 Adjust the thread in the right position.
- 3、 Loosen the thread clamp.
- 4、 Check the thread line
- 5、 Replace or gently
- 6、 Fasterning the position pin of bottom shuttle bar
- 7、 Make sure the space between bottom shuttle and shuttle bed should about 1mm.

#### 2、 Skipping

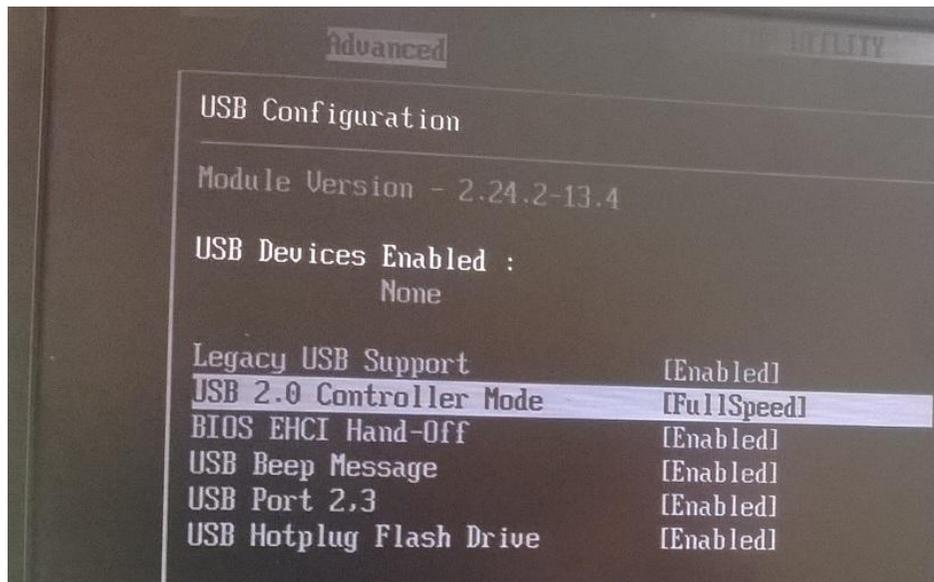
- 1、 The space between needle and shuttle tip is too large.
- 2、 The position of needle is changed.
- 3、 The notch of needle eye is improperly installed.
- 4、 The thread is of too large contractibility.
- 5、 The circle formed between needle eye to fabric is improperly adjusted.
- 6、 The position pin of bottom shuttle bar is loose.
- 7、 The shuttles are of bad quality.
- 8、 The position of driving device is changed.
- 9、 Static reaction

#### 2、 Remedies

- 1、 The space between needle and shuttle tip should be 0.2—0.3mm
- 2、 Adjust the position of the needle
- 3、 The needle Should be installed at the top of the machine needle row parallel scale line. Pinhole grooves are on the right side of the machine.
- 4、 Change for thread of smaller contractibility
- 5、 The circle should be 5mm.
- 6、 Change for a new bar shuttle.
- 7、 Change for new shuttles.



选择第四项[USB Configuration],按【回车键】进入 USB 设置界面  
将[USB 2.0 Controller Mode] 设置为[Fullspeed] (如下图)



将[USB Hotplug Flash Driver] 设置为 [Enabled] (如下图)

8、 Check the driving device by experienced worker .We will teach how to adjust the mechanical mechanism described below

9、 Put some water on the thread. Choose the unelastic thread.

## 5.2、 System errors and disposition methods

1、 Main shaft stays not at zero position.

(1) Main shaft sensor (main shaft zero position sensor) does not detect magnet. Rotate the mainshaft manually till the sensor light ,and check on the computer signal sensor if has this sensor or not .

(2) If sensors light up, use magnet to test main shaft sensors and see if they work. If they do not work, then it means malfunction in mainboard or main shaft sensors, please change mainboard or main shaft sensor.

2、 Main shaft system malfunction

(1) Check whether there is any error on the motor driver, manual shaking spindle without card lag phenomenon;

(2) Slave control IO program or mainboard malfunction, change another IO program or mainboard.

3、 CRT monitor displays E04

Reasons of error: error of communication between PC or IPC and B1 panel.

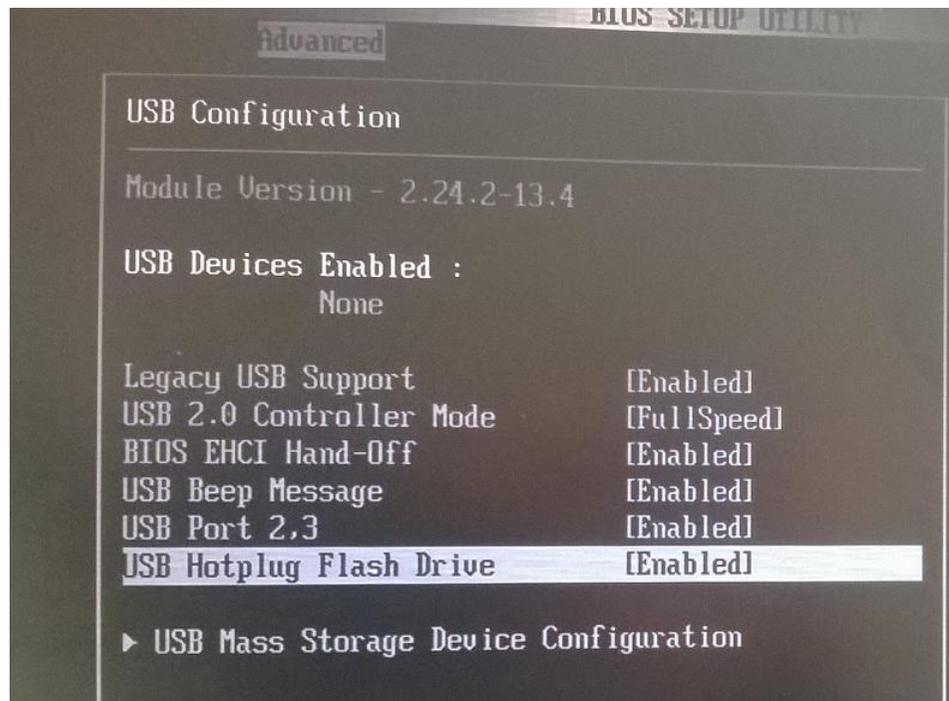
Ways to solution: check or insert cable again.

4、 The left limit and right limit error means left and right limit, move the frame in the opposite direction

5、 the computer doesn't recognize the USB

Step 1: find a PS / 2 keyboard interface, access to the industrial control panel on the keyboard interface

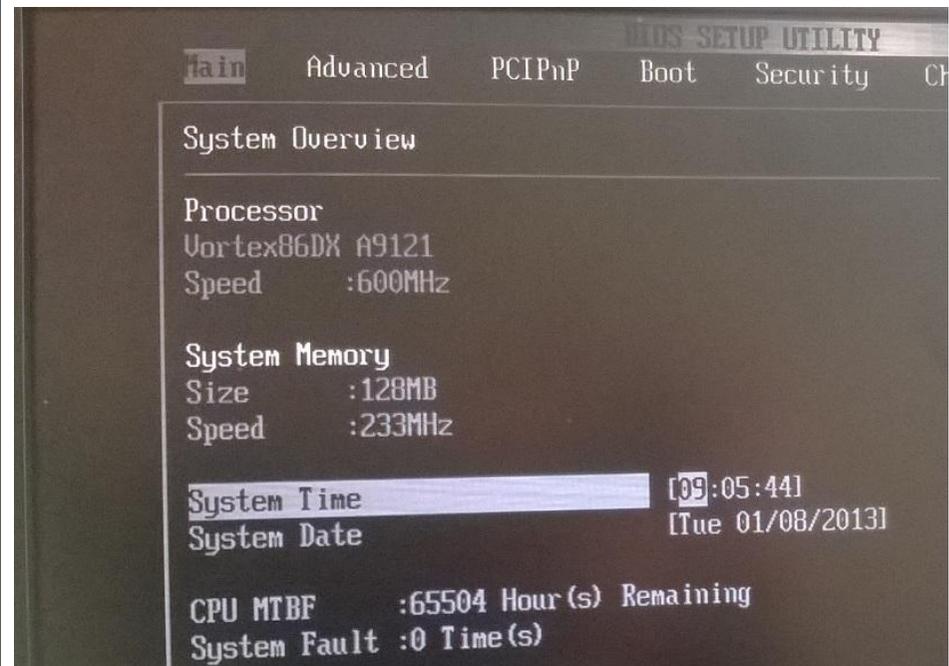
Step 2: Restart the machine, press the keyboard in the boot process



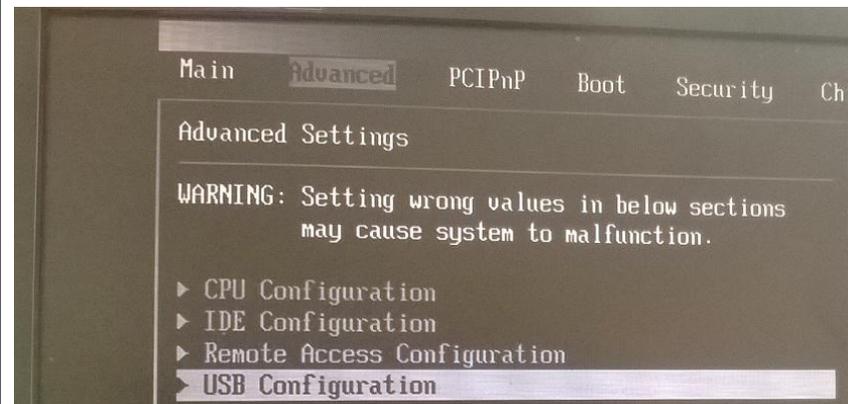
对照此菜单下其他设置是否与上图相同,如不相同按图片中设置.  
 第四步:按【F10】键后,选择[OK]保存更改设置并重启.

若 U 盘依旧无法读取, 请用格式化文件 (U 盘里面自带) 格式化 U 盘

"DEL" button to enter BIOS Settings interface (pictured)



Step 3: Press the keyboard [right] key to enter/Advanced menu (pictured)





双击 makebootfat、exe,等待 30S 直至 U 盘指示灯熄灭

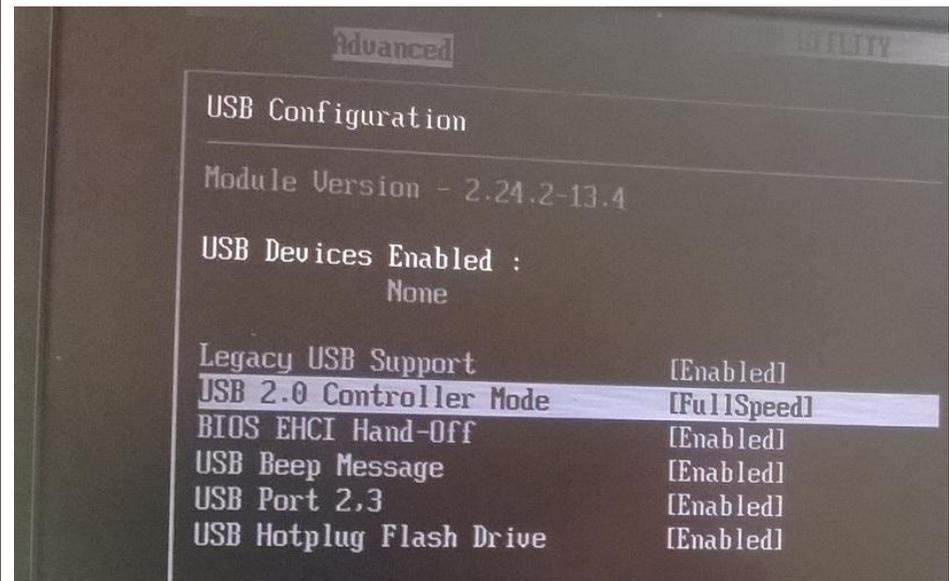
## 第六章 机械部分的调整

### 6.1 压板的调整

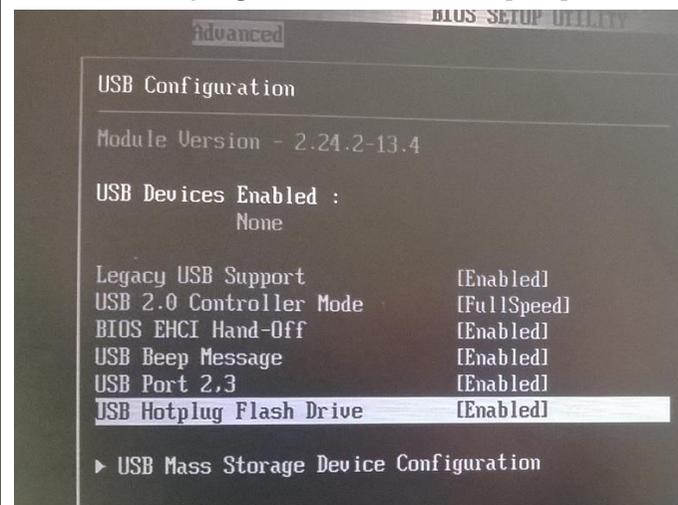
在一些比较厚的面料中会用到压板高低的调整

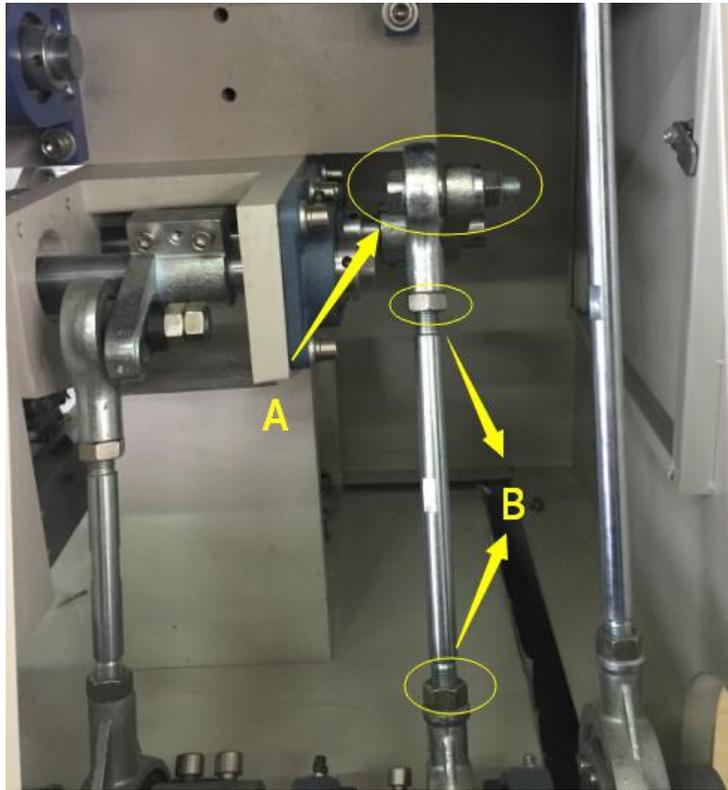
Choose the fourth/USB Configuration, press "enter" to enter the USB interface

Sets the [USB 2.0 Controller Mode] to [Fullspeed] (pictured)



Sets the Hotplug USB Flash Driver] to [Enabled] (pictured)





图中 A 可控制压板的时序，可调整压板与机针的时序和压板的高度，B 处可微调更改压板压倒最下端时候与针板的距离。但要确保机器两侧同步

## 6.2 打线排的调整

在遇到一些底面线无法正常收紧、线迹不工整的时候可尝试调整此处。

Contrast this menu under other Settings are the same as the above, such as different Settings according to the pictures.

Step 4: press "F10" button, select [OK] save category Settings and restart

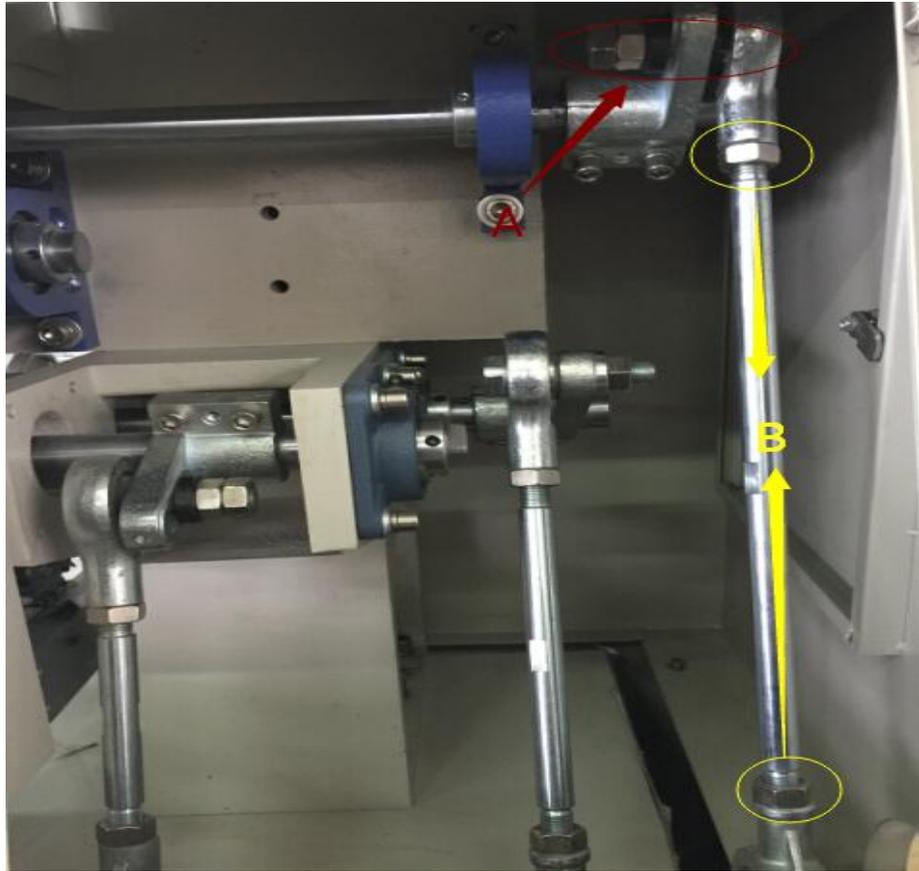
If U disk is still unable to read, please use format file format the U disk (find in the U disk )



Double-click the makebootfat.exe, Wait until 30 s U disk light is put out

**the adjustment of the mechanical parts.**

6.1 In some more thick fabric is used in the pressure plate height adjustment



图中 A 可大幅度调整打线排的时序。正常工作时应与机针同步，B 可微调打线排的时序，但要确保机器两侧同步

### 6.3 针梭同步、时序的调整

工作工程中出现两侧针排不平行，针梭打包量过小或者过大引起断线  
机器整体断线时可调整以下机械。

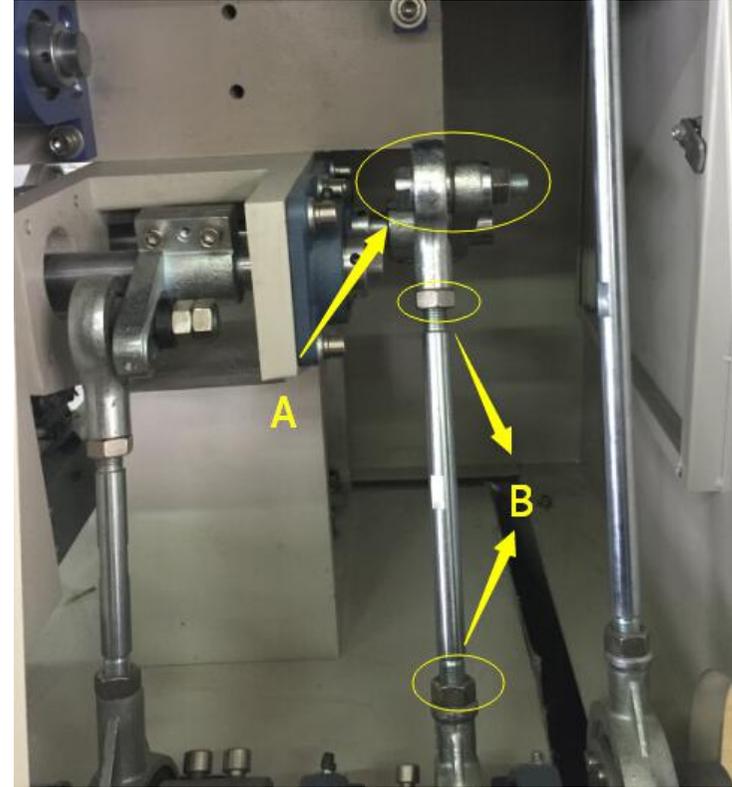
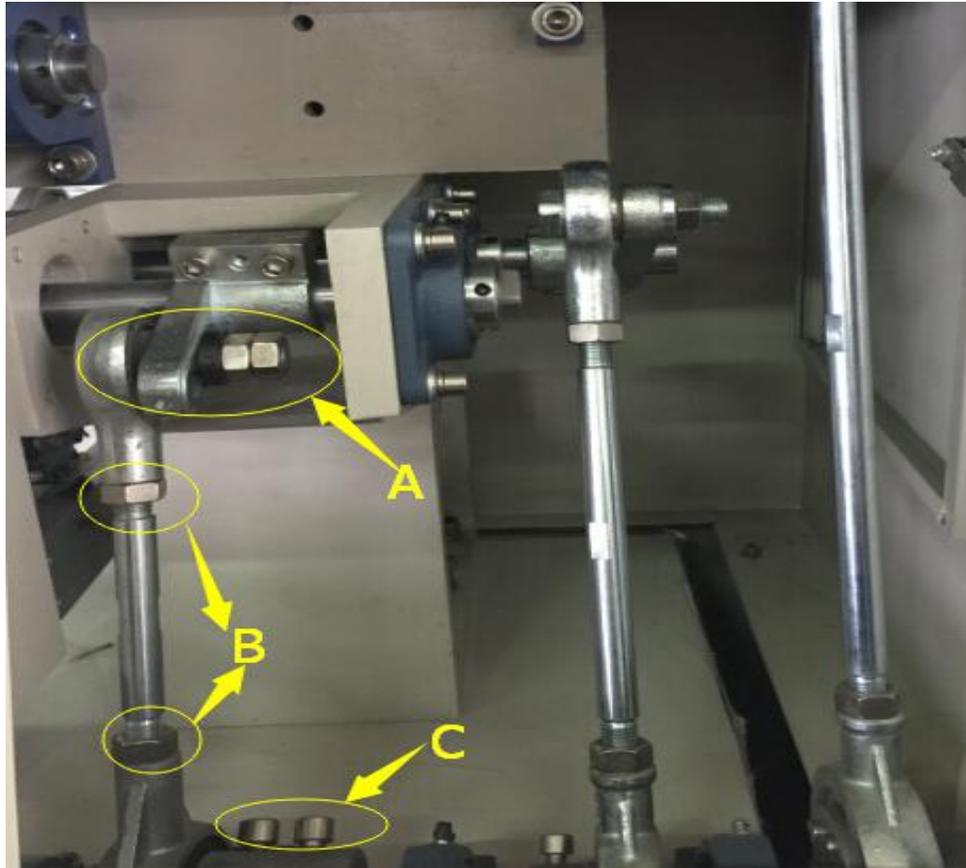


Figure in A to control the sequence of clamp, adjustable clamp with needle sequence and the height of the clamp, B can be fine-tuning changes when linking piece over the bottom and the needle plate. But keep it on both sides of the synchronous machine

### 6.2 Thread Lineup adjustment

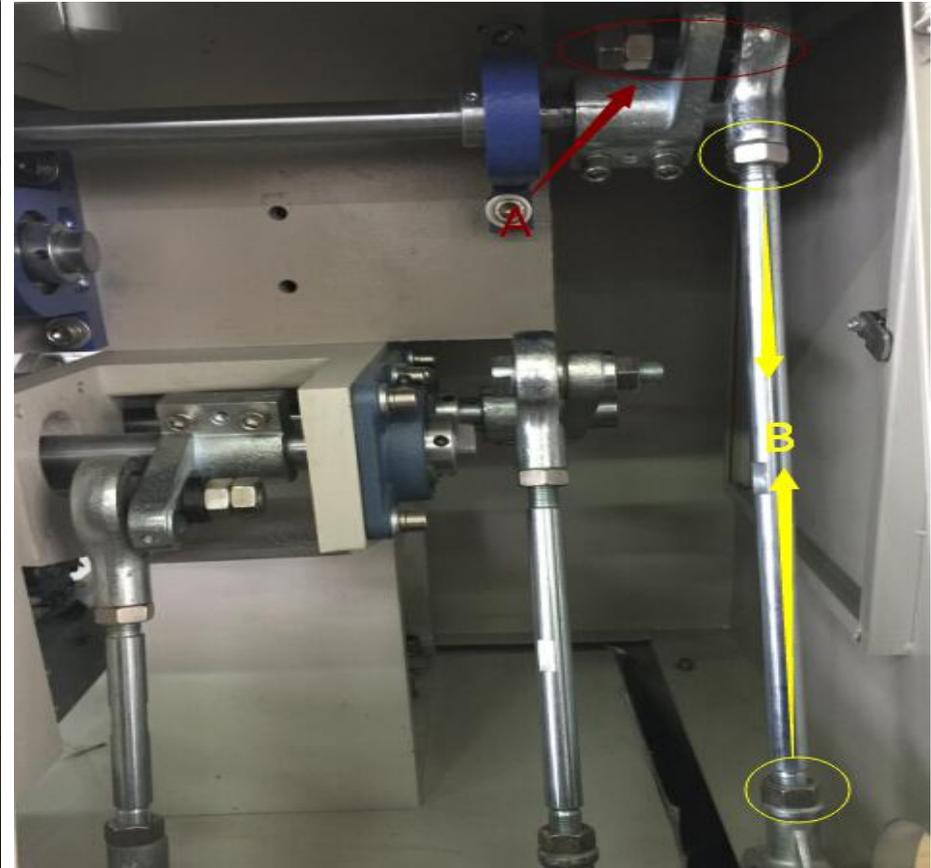
Unable to properly tighten the encountered some bottom line, the stitch is not neat can try to adjust here.



图中 A 可调整机针与梭条的时序，越靠近里面针排时序越快，引起打包量变化。若两侧针排不一致可放松 A 处螺钉，校准后锁死，通过调整 C 解决两侧针排同步。B 处连杆缩短，打包量会变大，行程变小。反之亦然。但要确保机器两侧同步

### 第七章 机器的保养

- 1、 必须防止过多灰尘进入电脑箱内，电脑放置的地方越清洁，电脑的使用寿命就越长，如果发现电路板有灰尘，应请对电气有经验的师傅用清洁的压缩空气吹干净。
- 2、 凡机器滑动地方如导柱.丝杠，操作人员每班应加少量的机油，凡



picture A adjust time sequence can adjust the lineup row significantly. Normal work the Thread Lineup need work together With the needle, during normal working sequence B can fine-tune lineup row 。 But keep it on both sides of the synchronous machine

### 6.3The adjustment of the needle spindle synchronization, timing

标有黄油咀的地方，操作人员应注意补充黄油。同时注意：所有润滑油应选用合格产品。

3、特别指出，拨片架支座等地方应每班加机油 4 次，该机构磨擦副共 18 处，每处每次加机油数滴（太多会流失）务必使之保持润滑良好。

4、张紧机构的离合器磨擦片必须使用质地优良的黄油，使保持适当润滑。

5、要求操作工在每天下班前清洁机器上积下来的灰尘，灰尘太多会导致机器的磨损增加、磨擦增大、启动困难

## 第八章 零件名称及图样

编号	名称	形状	编号	名称	形状 Appearance
1	自制 206 轴承壳		2	加固 206 轴承壳	
3	连杆		4	摆杆	

When working projects appear on both sides of the needle is not parallel, needle shuttle packaging quantity too small or too big lead to break the whole bolt machine can adjust the following machines.

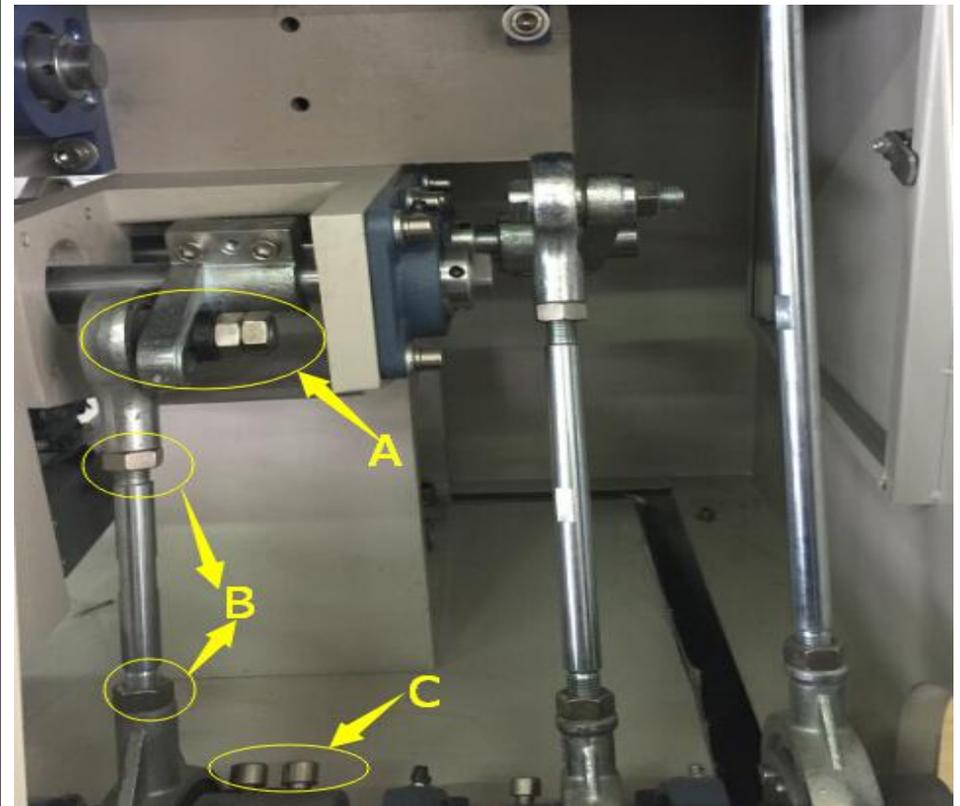


Figure in A adjustable needle with the spindle of the timing, timing the faster the closer the needle inside row, packaging quantity change. If both sides hackle inconsistencies can relax A screw, the lock after calibration, by adjusting the C solution on both sides of the needle row synchronization. B connecting rod shortened, packaging quantity gets bigger and the stroke gets smaller. And vice versa. But keep it on both sides of the synchronous machine

5	偏心轮壳 (钩轴)		6	偏心轮壳 (拨片架)	
7	线夹		8	偏心轮 (摆杆轴)	
9	偏心轮 (钩轴)		10	偏心轮 (拨片架)	
11	梭排连杆 (配 6200 轴承)		12	16 含油轴承	
13	UCFA 205 轴承		14	UCFI 205 轴承	
15	80016 轴 承		16	NCPA 204I 轴 承	

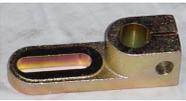
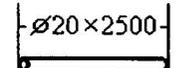
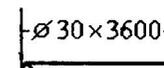
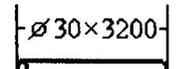
### Maintenance of machine

- 1、 Excess dusts should be prevented from entering the computer cabinet. The satisfactorily sanitary place should be beneficial to the service life of the computer. The experienced technician should be invited to clean the machine with the blast air if the dusts are found in the circuit board.
- 2、 Each shift operator should lubricate such sliding parts of the machine as guide rails and thread bars with butter in the place marked "butter nose". Everyone should pay attention to select the qualified.
- 3、 It is particularly pointed out that the toggle support base and the like need lubricating four times every shift. There are in the part structure 18 attrition subsidiaries which need some drops of machine oil in order to keep them well lubricated.
- 4、 Qualified butter should be used to lubricate the attrition slice of the clutch in the tension mechanism.
- 5、 The operator is required to remove everyday the accumulated dusts which lead to more abrasion and friction and hard activation of the machine.

### Parts Name and Pictures

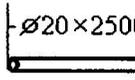
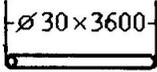
17	NAP 206 轴承		18	NAP 205 轴承	
19	凸轮		20	凸轮盖	
21	杆端关节轴承		22	16# 针、19# 针	
23	6303 轴承		24	滚珠丝杠螺母、滚珠丝杠	
25	导柱 260×M16		26	导柱 280×M14	
27	连杆		28	钩针	
29	左梭条		30	右梭条	

No	Name	Appearance	No	Name	形状 Appearance
1	Self-made 206 bearing case		2	Reinforced 206 bearing case	
3	Connection bar		4	Swinging bar	
5	Eccentric wheel case		6	Eccentric wheel case(toggle slice)	
7	Thread clamp		8	Eccentric wheel case (swing bar axis)	
9	Eccentric wheel		10	Eccentric wheel(toggle slice)	

31	左梭仔		32	右梭仔	
33	左梭斗		34	右梭斗	
35	摆杆 2		36	关节轴承配	
37	钩轴摆杆		38	关节轴承配 6303	
39	偏心轮壳 (摆杆轴)		40	摆杆	
41	钩子轴 Φ20×2500 0		42	主轴 Φ30×3600	
43	摆杆轴 Φ30×3200 0				

11	Conn ection devic e of shuttl e bar with 6200 beari ng		12	16 oil bearing	
13	UCFA 205 beari ng		14	UCFI 205 bearing	
15	8001 6 beari ng		16	NCPA 204I bearing	
17	NAP 206 beari ng		18	NAP 205bearing	
19	cam		20	Cam cover	

21	Joint bearing		22	16# 19# needle	
23	6303 bearing		24	Ball bearing bar	
25	Guiding post 260×M16		26	Guiding post 280×M14	
27	Connection bar		28	Thread hook	
29	Left shuttle bar		30	Right shuttle bar	
31	Left shuttle		32	Right shuttle	
33	Left shuttle holder		34	Right shuttle holder	

35	Swing bar 2		36	Joint bearing device	
37	Swing bar for hook axis		38	Joint bearing device	
39	Eccentric wheel case		40	Swing bar	
41	Hook axis		42	Main shaft	
43	Swing bar axis	