

CS-7363-BT  
單針針送高頭車  
CS-7363L-BT  
單針針送高頭車  
CS-7364-BT  
雙針針送高頭車  
CS-7364L-BT  
雙針針送高頭車



# 使用說明書

## INSTRUCTION MANUAL

Read safety Instructions carefully and understand them before using.  
Retain this Instruction Manual for future reference.

爲了安全地使用，請您在使用之前仔細閱讀本使用說明書。  
另外，請您注意保管本使用說明書，以便隨時查閱。



## 金輪牌縫紉機

CS-7363-BT	單針針送高頭車（標準釜）	CS-7363-BFT	F 為自動抬
CS-7363L-BT	單針針送高頭車（大釜）（附自動切線&自動倒縫）	CS-7363L-BFT	押腳
CS-7364-BT	雙針針送高頭車（標準釜）	CS-7364-BFT	
CS-7364L-BT	針送針送高頭車（大釜）（附自動切線&自動倒縫）	CS-7364L-BFT	

使用之前請仔細閱讀本使用操作說明書，爲了確保正確操作機器以及延長機器的使用壽命。

並小心收好本使用說明書，不要遺失。

## Golden-Wheel brand sewing machine

CS-7363-BT	Single Needle, Needle Feed, Postbed Sewing Machine(Standard Hook)	CS-7363-BFT	F means Automatic
CS-7363L-BT	Single Needle, Needle Feed, Postbed Sewing Machine(Large Hook)(With Automatic Undertrimming & Backtacking)	CS-7363L-BFT	Presser Foot Lifting
CS-7364-BT	Double Needle, Needle Feed, Postbed Sewing Machine(Standard Hook)	CS-7364-BFT	
CS-7364L-BT	Double Needle, Needle Feed, Postbed Sewing Machine(Large Hook)(With Automatic Undertrimming & Backtacking)	CS-7364L-BFT	

In order to make sure the right operation and extend the machine's service, read this instruction manual carefully before operation. Retain this manual as your own, do not miss it.

## 操作說明

## OPERATING INSTRUCTIONS

### 操作前的工作:

1. 在機器未進行潤滑之前，請不要嘗試操作或是測試機器的工作
2. 要確保電壓和相位（單相或 3 相電）與刻度在馬達名牌上的額度一致。
3. 第一次轉動機器時，檢查手輪的轉動方向。打開電源開關，讓機器低速運轉，同時檢查手輪的轉動方向。（手輪的運轉方向是逆時針方向運轉的）
4. 在使用機器的第一個月的時候，確保機器不要高於 1800 S. P. M.

### Before you use:

1. Do not try to operate or test the machine before you lubricate it.
2. Make sure the electricity power(volts and phases) is the same with which been printed on the name plate of the motor.
3. Check the rolling direction of the pulley when first time turn on the machine. Power on, run the machine in low speed, check the rotate direction at the same time(the pulley rolling against a clock)
4. Do not make the machine work faster than 1800 spm at the first month.

## 操作時的注意事項

### Caution when operation

1. 當打開電源開關或操作機器時，爲了確保手指不受傷害，請使手指遠離機針。
  2. 操作機器時，請確保不要讓包括你自己在內的任何人的頭或手指靠近手輪，V 型皮帶，卷線器，以及馬達。並且也不要將任何物品放在靠近他們的地方。
  3. 在沒有護手環，皮帶蓋以及其他防護設施的情況下操作機器。
  4. 在移動或更換 V 型皮帶時，請務必確保先關閉電源或是馬達完全停止運轉。
1. Do not place your finger near the needle when you power on or operating in case of finger be hurt.
  2. Do not let anyone including yourself get their head or fingers close to the pulley, V-belt, bobbin winder and motor during operation. Never put anything close to the machine.
  3. Never operate the machine without finger guard, belt cover, and other protect device.
  4. Make sure to turn off the power and the motor stops when you move the machine or change the belt.

### 規格

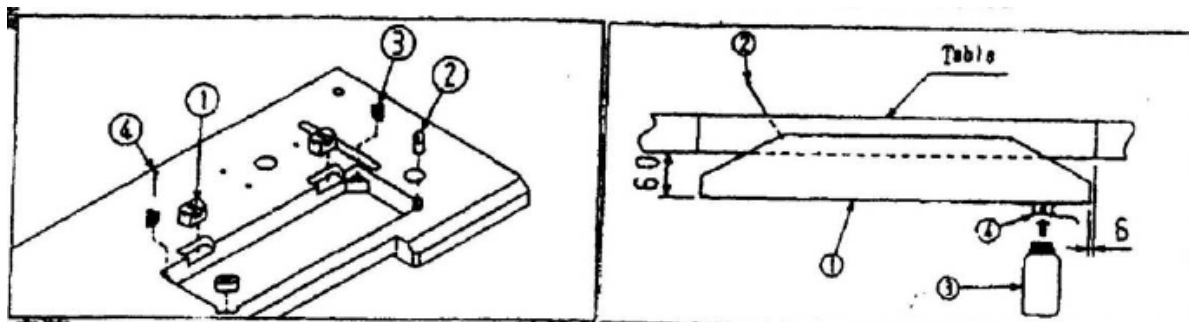
規格 \ 型號		CS-7363-BT	CS-7363L-BT	CS-7364-BT	CS-7364L-BT
適用於					
釜		標準釜	大釜	標準釜	大釜
縫速		2000 (spm)			
縫目長度		0~6 (mm)			
針棒行程		36 (mm)			
壓腳行程	膝動提升器	16 (mm)			
	手動提升器	8 (mm)			
針		DPX17#18			
潤滑油		機油（白色軸油）			

### Spec

Spec \ Model		CS-7363-BT	CS-7363L-BT	CS-7364-BT	CS764L-BT
Application		Standard hook	Large hook	Standard hook	Large hook
Hook					
Sewing speed		2000(spm)			
Stitch length		0~6(mm)			
Needle bar stroke		36(mm)			
Presser foot stroke	Knee lifter	16(mm)			
	Hand lifter	8(mm)			
Needle		DP*17#18			
Lubricating oil		Machine oil (White spindle oil)			

## 1. 機器的安裝

### 1. Installation of the machine



#### (1) 橡膠墊的安裝

先固定橡膠塞子①，用釘子④釘住橡膠墊②, ③。

#### (2) 油槽的安裝

1) 先用釘仔②在四周固定油槽①。  
2) 將油壺③裝到油壺接口④上面。

(1) installation of the rubber mat. First fix the rubber stopper①, use nails④ to nail down rubber mat ② and ③

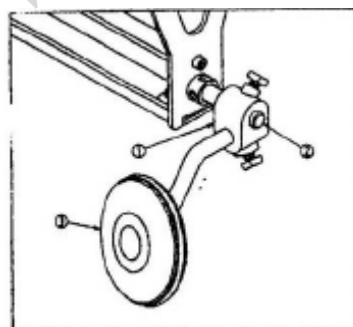
(2) installation of the oil groove.

1) First fix the oil groove① by nails② at the edge.  
2) fix the oil can③ on the oil can connector④.

## 2. 膝動抬押腳的安裝

### 2. installation of the knee lifter

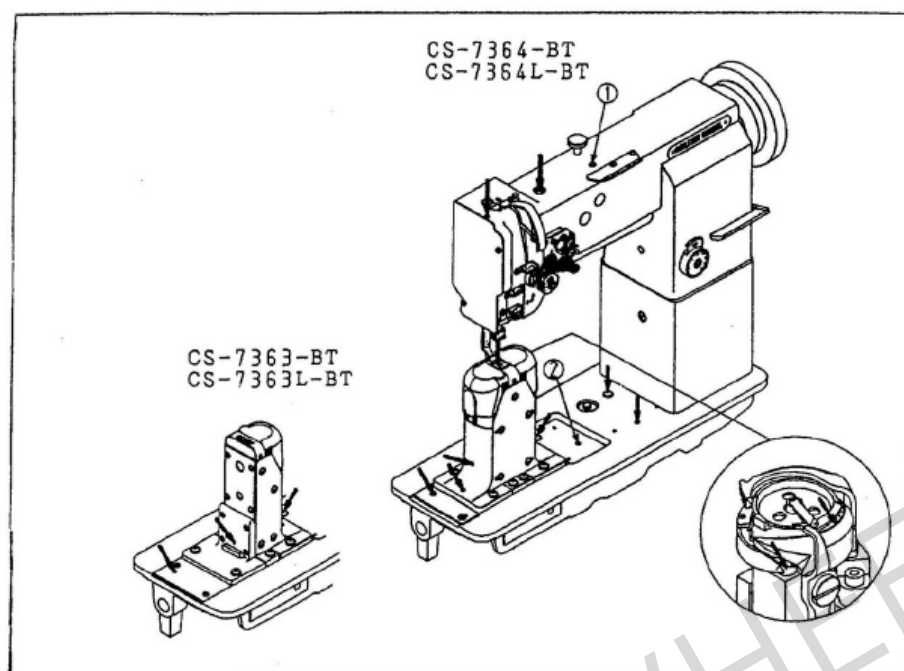
1) 將圖中膝動抬腳的曲柄①插入到位置的②軸中。  
2) 然後將圖中的③圓盤以及組件安裝上去。



(1) insert the crank of the knee lifter ① into the position of shaft②

(2) Then fix the round plate③ and components on it.

3. 潤滑系統
3. Lubricating system.



啟動機器前：

- 1) 縫製前，要確保潤滑機油適量，不能過多或過少，與機器上標刻的油量一致。
- 2) 同時將油注到圖上的①、②中。

當所有需要潤滑的部位都已經潤滑后，並且在機器被安裝好之後，等上一會（大約 10 分鐘），目的是為了讓潤滑油能充分滲透到潤滑的每個部位，因此保證機器能達到連續的縫製作業。

在最初使用機器的時候或是在機器很久沒有使用后重新使用時，就需要在圖上的需要加油的標刻部位加上 2~3 滴的油。同時，為了機器能持續不斷的正常作業，在每天的早上和晚上在需要加油的部位加上 2~3 滴油。

Before start the machine:

- 1) Before sewing works, make sure there are suitable amount of oil, no more and no less, should be at the same position with which indicated on the machine.
- 2) Fill in the oil into the position ①②

After all of the lubricating work been finished and the machine been assembled completely, wait for about 10 minutes before you operate in order to guarantee every place which need to lubricate is well lubricated, then the machine can work continuously.

When a sewing machine is used for the first time or sewing machine left out use for considerably long time is used again, replenish a suitable amount of oil to the positions indicated by 2~3 drops. By the way, fill in 2~3 drops of oil where need to be lubricated every morning and every night so that the machine can work normally and continuously.

#### 4. 梭子線的繞線方法

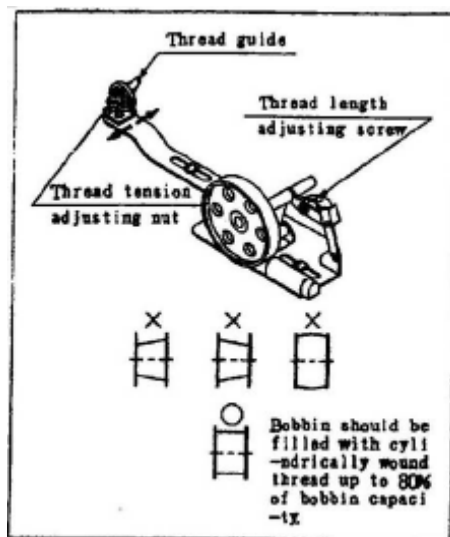
#### 4. WINDING OF BOBBIN THREAD

△注意

在進行此項作業時，請關閉電源以防止意外的人身傷害。並確保馬達是完全停止的。

CAUTION

Turn off the power supply to prevent from unexpected injury. Be sure to confirm completely stop of the rotation of the motor before operation.



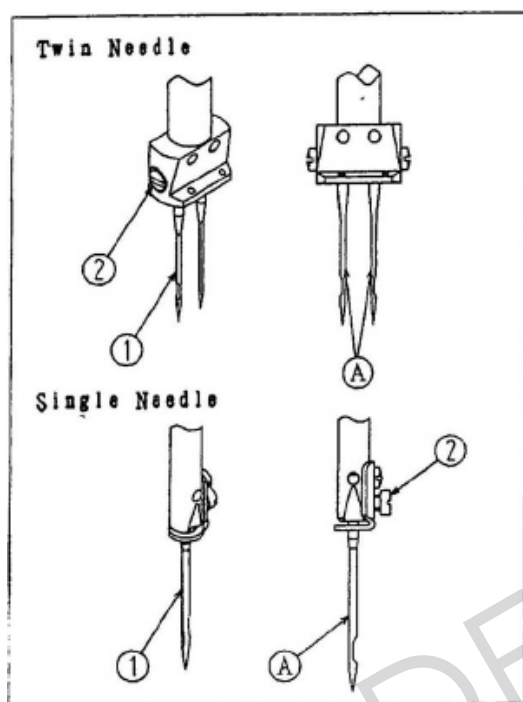
- 繞線的張力調節機構  
聚酯線和尼龍線，需是鬆弛的繞線。
- 筒狀的繞線  
將導線器向繞線層的較小直徑來移動。
- 繞線圈的線的長度調節  
鬆開縫線調節之螺絲，以增加線的長度。  
擰緊縫線調節之螺絲，以減少線的長度。
- regulating mechanism of the tension of the winding.  
slack winding is recommended for Polyester thread and nylon thread.
- conically wound thread  
move the thread guide toward smaller diameter of wound thread layer.
- Length of wound thread  
Loosen the thread length adjusting screw to increase length of thread  
Tighten the screw to decrease length of thread.

## 5. 機針的安裝

### 5. INSTALLATION OF NEEDLES

△注意	先關閉電源開關以防止意外的人身傷害。並確定馬達是確實完全停止運轉的。
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CAUTION	Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.
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- 1) 旋轉手輪，使針棒升到最高位置。
- 2) 擰松鎖針螺絲②，握住針①，以使針的長凹槽A，面對面的相互對應。（對兩針而言）以及長凹槽A的左邊。
- 3) 將針插入針榴，直至針無法再往上移動為止。
- 4) 將鎖針螺絲②確實鎖緊。

- 1) Turn the hand wheel to move the needle bar up to its highest position.
- 2) Loosen needle-set screw ②, hold the needle① so that long groove A face oppositely to each other. And the left side of the long grooveA
- 3) Insert the needle into the needle bar untill it will go no further.
- 4) Securely tighten the needle-set screw②.

## 6. 梭子線之穿線方法

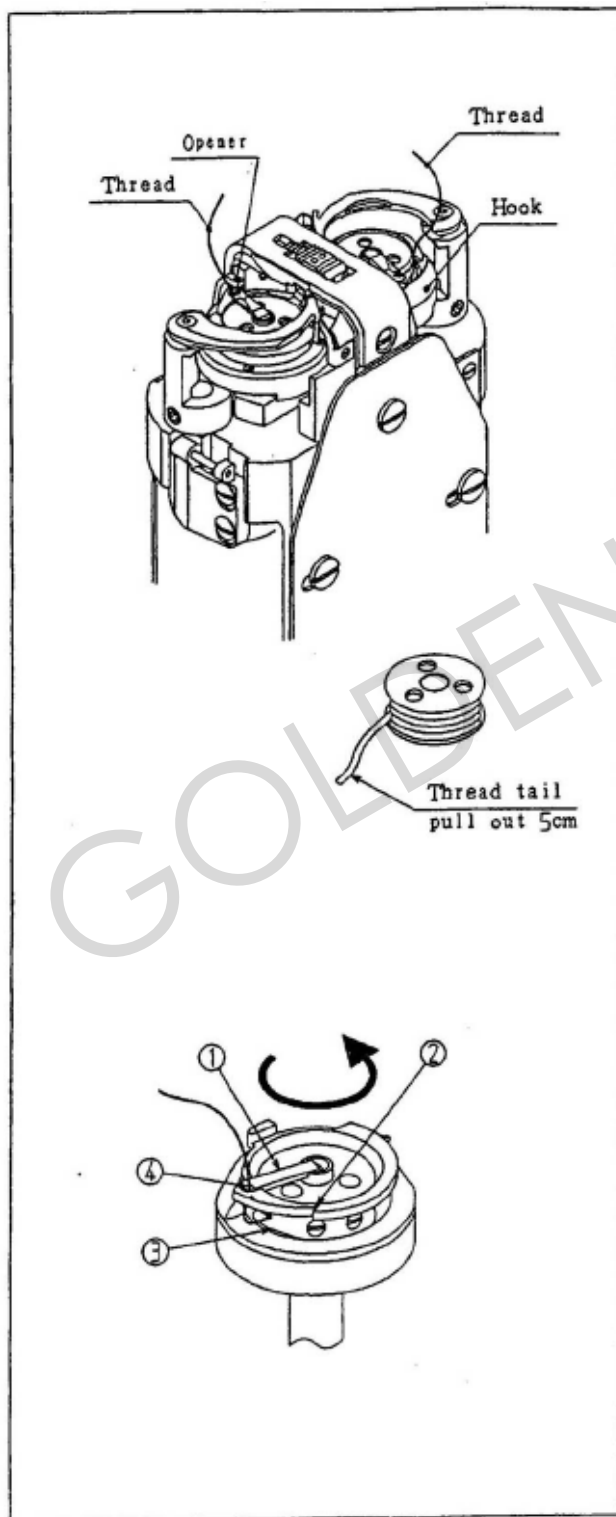
### 6. THREADING OF BOBBIN THREADS

△注意:

請先關閉電源開關，以防止意外的人身傷害。並確保在進行操作之前馬達是確實停止轉動的。

CAUTION

Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.



- 移取旋梭。

打開梭殼①，取出梭子。

- 握住梭子，以便使梭線朝向右方，將其放在釜座中，靠近梭子受柄的位置①。

- 梭仔線的穿線方法

先將拉出的線從狹槽②穿進去，再經過張力彈片③之下穿過，后將線穿過梭殼上的空隙①。

備注：將梭芯放於梭殼中，以便梭子在被拉動時能按照如箭頭標識的方向轉動。

- Open the bobbin case, take out the bobbin

- hold the bobbin and make the bobbin thread face the right direction, put it into the hook and near the handle① of the bobbin.

- Threading of bobbin threads

Pass bobbin thread into the slit②, then through under the tension clips③ and then go through the gap① of the bobbin case.

NOTE: fit the bobbin in the bobbin case so that the bobbin turns in the direction of the arrow when the bobbin thread is pulled.



7. 機頭上的穿線方法

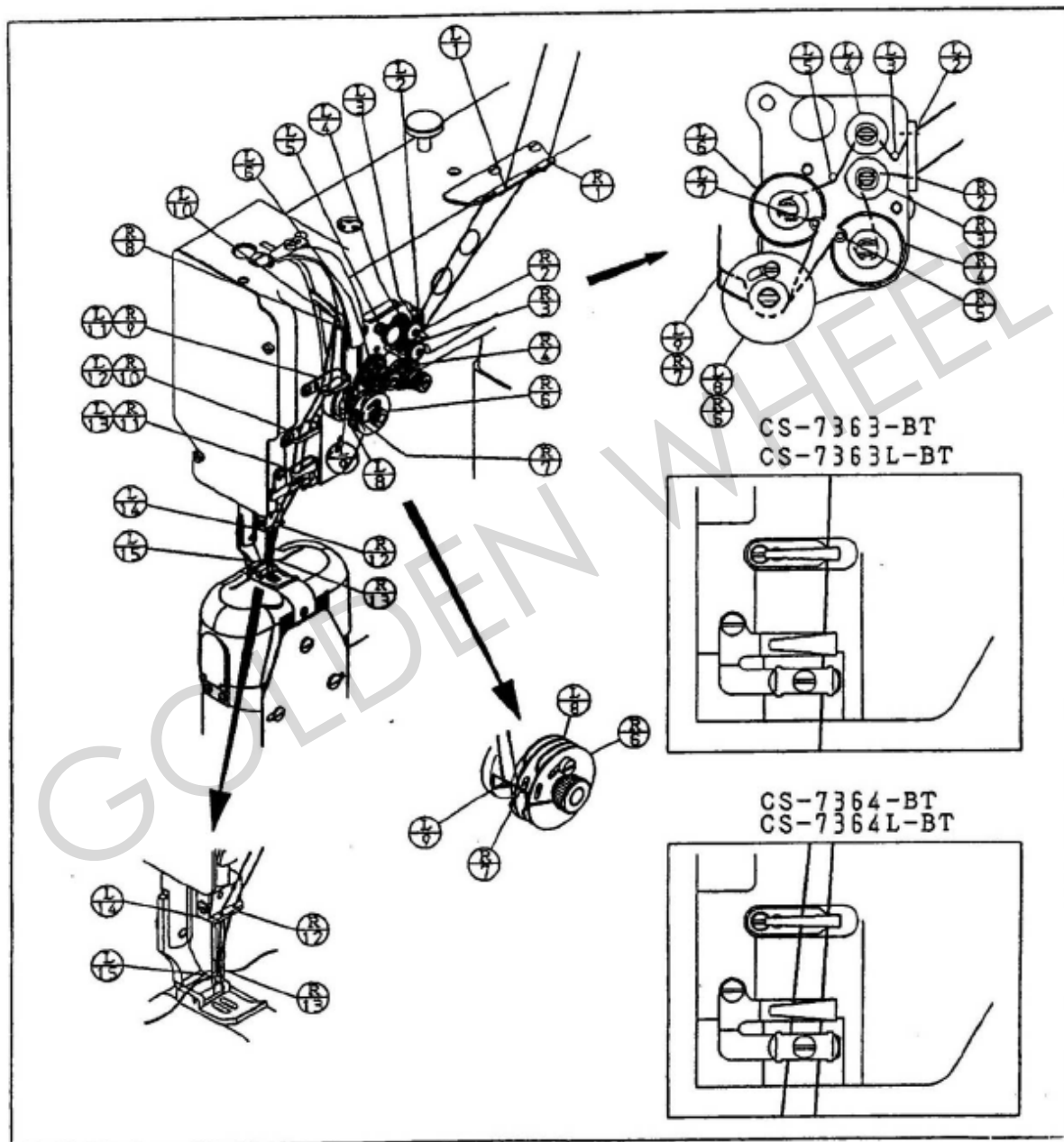
7. THREADING ON THE MACHINE HEAD

△注意

請先關閉電源開關，以防意外的人身傷害。  
操作之前，請確保馬達是確實停止轉動的。

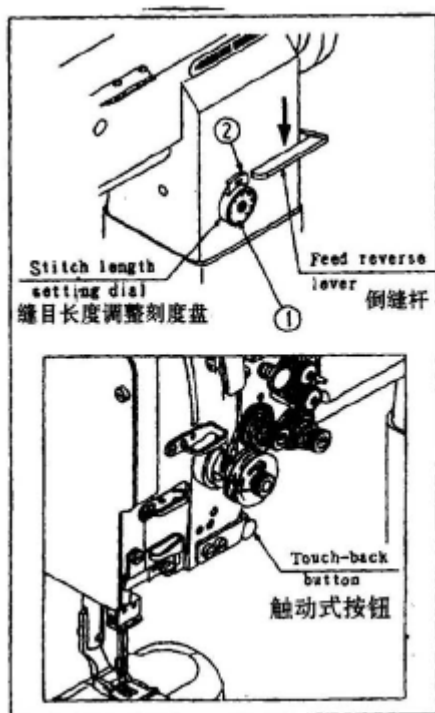
CAUTION

Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.



8. 調整縫目長度與倒縫（觸動式倒縫）

8. ADJUSTMENT OF STITCH LENGTH AND STITCH REVERSING.(TOUCH BACK)



○ 縫目長度之設定轉盤

押下制動板②，轉動轉盤①。

○ 倒縫桿

操作方法：

- 1) 押下倒縫桿。
- 2) 只要持續地押下倒縫桿，機器是一直處於倒縫狀態下的。
- 3) 鬆開倒縫桿時，機器會立即恢復正常的縫紉狀態。

○ 觸動式倒縫之按鈕

操作方法：

- 1) 押下觸動式倒縫按鈕時，機器即處於倒縫狀態。
- 2) 只要持續地押下倒縫桿，機器是一直處於倒縫狀態下的。
- 3) 鬆開倒縫桿時，機器會立即恢復正常的縫紉狀態。

○ Stitch length setting dial.

Press the stopping plate②, turn the dial①

○ Backtacking bar

Operation:

- 1) Press backtack bar down
- 2) the machine performs reverse feed stitching as long as the bar is pressed.
- 3) The moment you release to press the lever, the machine resumes the normal stitching mode.

○ Touch-back button

how to operate:

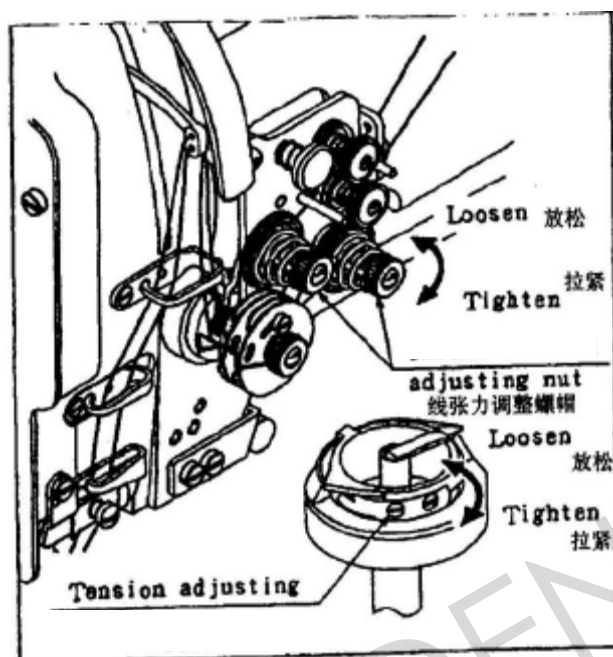
- 1) The moment you press touch-back button, the sewing machine performs reverse feed stitching.
- 2) The machine continues reverse feed stitching as long as the touch-back button is held pressed.
- 3) When you release the switch, the machine resumes normal stitching.

## 9. 縫線之張力

## 9. THREAD TENSION

△注意	請先關閉電源開關，以防意外的人身傷害。 操作之前，請確保馬達是確實停止轉動的。
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CAUTION	Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.
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### 1) 調整針的縫線之張力

轉動上線張力之調整螺帽，順時針方向轉動，可以增加張力，反時針轉動，可以減少張力。

### 2) 調整梭子底線之張力

轉動底線張力之調整螺絲，順時針轉動，可以增加張力，逆時針轉動，可以減少張力。

### 1) Adjusting the needle thread tension

Turn the thread tension adjusting nut clockwise to increase or counterclockwise to decrease the needle thread tension.

### 2) Adjusting the bobbin thread tension

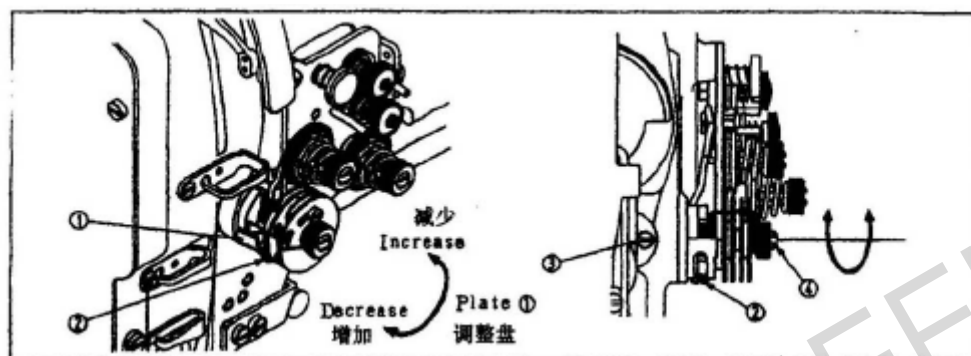
Turn the tension adjusting screw clockwise to increase or counterclockwise to decrease the bobbin thread tension.

## 10. 松線彈簧的調整

### 10. ADJUSTING THE THREAD TAKE-UP SPRING

△注意	請先關閉電源開關，以防意外的人身傷害。 操作之前，請確保馬達是確實停止轉動的。
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CAUTION	Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.
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#### ◇ 調整松線彈簧器

1. 擰松如圖上螺絲②，之後打開調整盤①。
2. 將調整盤①轉向右邊，來增加移動範圍。
3. 將調整盤①轉向左邊，來縮小移動範圍。

#### ◇ 松線彈簧之張力調節

1. 擰松如圖上螺絲③，向左轉動張力調整螺帽④，以增加張力。
2. 向右轉動張力調整螺帽④，以減小張力。
3. 調整后，再鎖緊剛擰松之螺絲。

#### ◇ Thread Take-Up spring adjustment

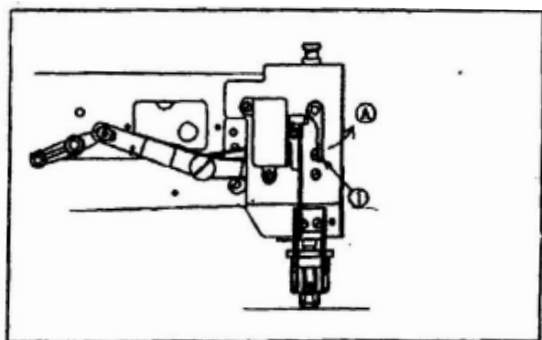
1. Loosen the screw② and then open the adjusting plate①
2. Turn the adjusting plate① clockwise to increase the moving range
3. Turn the adjusting plate① counterclockwise to decrease the moving range

#### ◇ Tension adjustment of the Spring

1. Loosen the screw③, Turn the tension-adjustment nut counterclockwise to increase the tension.
2. Turn the tension-adjustment nut clockwise to decrease the tension
3. After adjustment, tighten the screw③.

## 11. 壓腳的提升

### 11. PRESSER FOOT LIFTING



1) 用手將手動押腳提升器從圖上的①位置移動到Ⓐ位置，壓腳會被提升為 8mm。

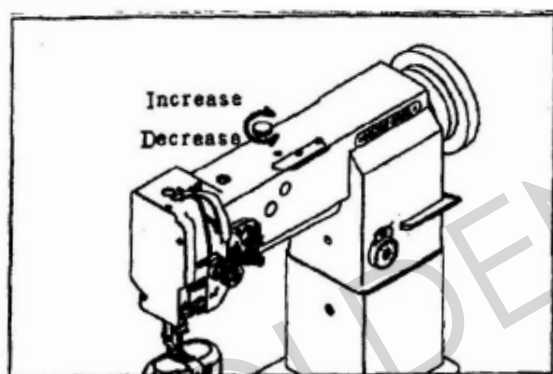
2) 如使用膝動押腳提升器，壓腳會被提升為 16mm。

1) Use your hand to move the manual presser foot lifter from position ① to position Ⓐ, the presser foot lifter will be 8mm higher.

2) Presser foot will be 16mm higher if you use knee presser foot lifter.

## 12. 押腳壓力之調節

### 12. ADJUSTMENT OF PRESSER FOOT PRESSURE



1) 向右方旋轉壓力彈簧調整器，以增加壓力。

2) 向左方旋轉壓力彈簧調整器，以減少壓力。

1) Turn the pressure spring controller clockwise to increase the pressure.

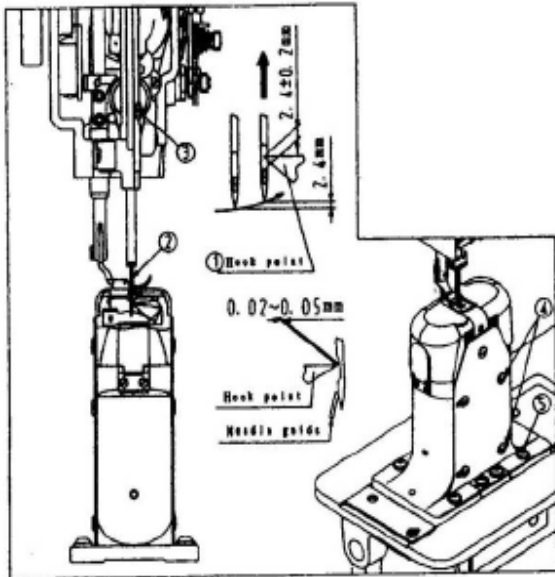
2) Turn the pressure spring controller counterclockwise to decrease the pressure.

### 13. 針與旋梭之關係

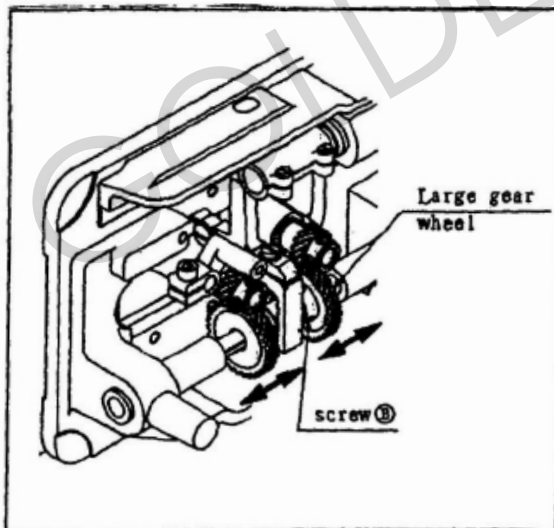
#### 13. RELATIONSHIP BETWEEN NEEDLE AND SHUTTLE

△注意	請先關閉電源開關，以防意外的人身傷害。 操作之前，請確保馬達是確實停止轉動的。
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CAUTION	Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.
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注意：在調整中，請不要過度擰松螺絲⑧且須保持旋梭軸之齒輪與下軸之齒輪是咬合的



NOTE: Please do not lose the screw ⑧ too much, and you should insure the engagement of between the shuttle shaft gear and the lower shaft gear.

- 1) 在縫目長度刻度盤上設定縫目長度到“6”。
- 2) 將針棒降到最低點。
- 3) 旋轉手輪，使針棒從最低點升到 2.4mm。
- 4) 調整上針眼與大釜尖①的距離到 2.4mm，即當大釜釜尖接近針中心的時候，然後擰緊針棒鎖緊螺絲③。

#### ◇ 針與大釜之間隙

- 5) 旋轉手輪，使針棒從最低點升到 2.4mm。
- 6) 調整針②與大釜釜尖①之間隙到 0.02mm~0.05mm 之間。調整釜座，擰送釜座螺絲④（8 處）和⑤（4 處），而後鎖緊螺絲。

#### ○ 釜尖的調整位置

為了更精確的調整針與大釜之間的時效設置，請擰松大齒輪螺絲並且將齒輪向軸方向移動 1~2mm。

- 1) Set the stitch length at 6mm on the stitch-length dial.
- 2) Low down the needle bar to its lowest position
- 3) Roll the hand wheel to make the needle bar go up at 2.4mm height.
- 4) Adjust to make the upper needle eye 2.4mm away from the point of the large hook①, in this case, when the point of the large hook is near the center of the needle, tighten the screw③ to lock the needle bar.

#### ◇ Gap between needle and large hook

- 5) Roll the handwheel to make the needle bar go up to 2.4mm height.
- 6) Adjust to make the upper needle eye 0.02~0.05mm away from the large hook point. Adjust the hook, loosen the screw ④(8 screws) and ⑤(4 screws).

#### ○ Adjust the position of the hook point.

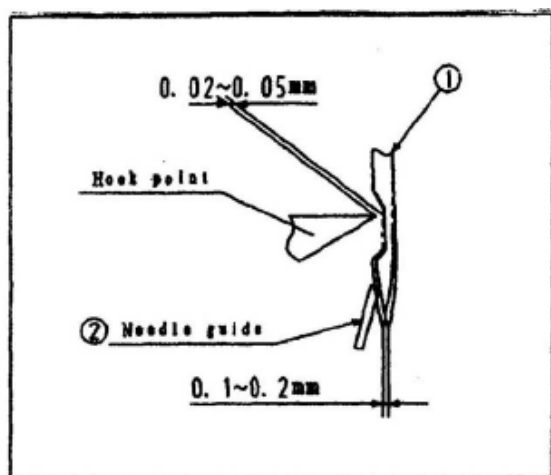
In order to adjust the aged setting between the needle and the large hook, please loosen the screw on the big gear wheel and then move it toward the shaft 1-2mm

#### 14. 針導向器之調節

#### 14. ADJUSTMENT OF THE NEEDLE GUIDE

△注意	請先關閉電源開關，以防意外的人身傷害。 操作之前，請確保馬達是確實停止轉動的。
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CAUTION	Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.
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☆ 當想改變大釜的時候，請確認針導向器在大釜中的位置。

針①的彎度是從 0.1~0.2mm。

使用螺絲起子調整針導向器位置到向內合向外的位置。

☆ Please confirm the position of the guide in the large hook first before you want to change the large hook.

Camber of the Needle① 0.1~0.2mm

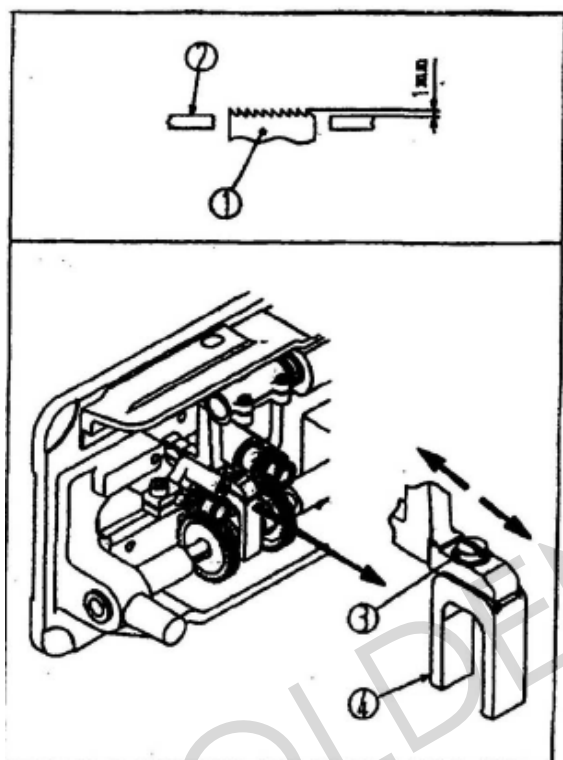
Use screwdriver to adjust the needle guide position to innerside and outside direction.

## 15. 送料齒高度的調節

### 15. ADJUSTMENT OF THE HEIGHT OF THE FEED DOG

△注意	請先關閉電源開關，以防意外的人身傷害。 操作之前，請確保馬達是確實停止轉動的。
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CAUTION	Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.
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送料齒①出廠調節時，送料齒距離針板②上表層的距離為 1.0mm。送料齒的高度調節，需依個別不同的縫製材料或者是需要更換送料齒的情況，依照以下操作事項：

- 1) 鬆開螺絲③。
- 2) 上下移動送料桿進行調整，然後擰緊螺絲。

The feed dog is factory-adjusted as 1.0mm higher than the surface of the needle plate. For adjusting the feed dog height, you should refer to different sewing materials or if you need to change the feed dog,. Follow the below steps.

- 1) loosen the screw③
- 2) adjust the feeding rod by move it up and down, then tighten the screw.

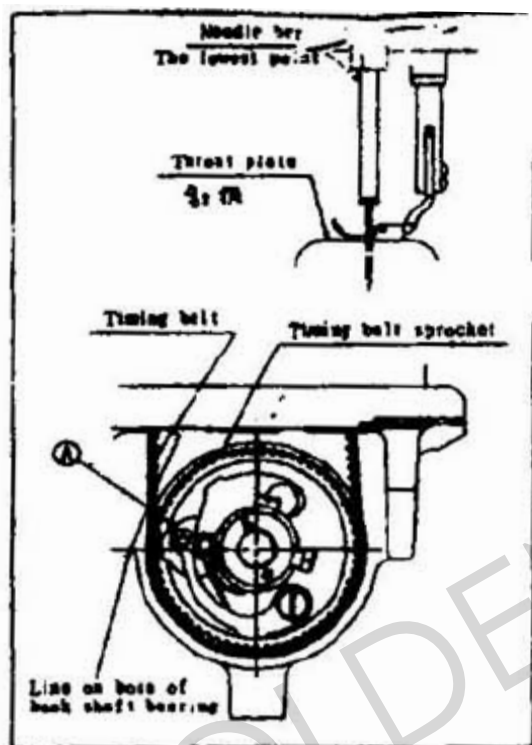


## 16. 旋梭作動與針作動之關係

### 16. REALTIONSHIP BETWEEN SHUTTLE MOTION AND THE NEEDLE MOTION

△注意	請先關閉電源開關，以防意外的人身傷害。 操作之前，請確保馬達是確實停止轉動的。
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CAUTION	Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.
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當調速帶更換時，舉例說，旋梭作動與針棒作動之關係就要依如下所示之調節：

- (1) 在縫目長度刻度盤上設定縫目長度為“6”。
- (2) 將針棒降到最低點。
- (3) 將機頭向後傾斜，並確保Ⓐ(鏈輪齒孔中心)與釜軸之突起線在同一條線上。
- (4) 如Ⓐ所在的位置不對，重新移動定時皮帶並安裝調試之。

when you need to change the speed belt, Take a example, you should change as the indication below about the relationship between the shuttle motion and the needle bar motion:

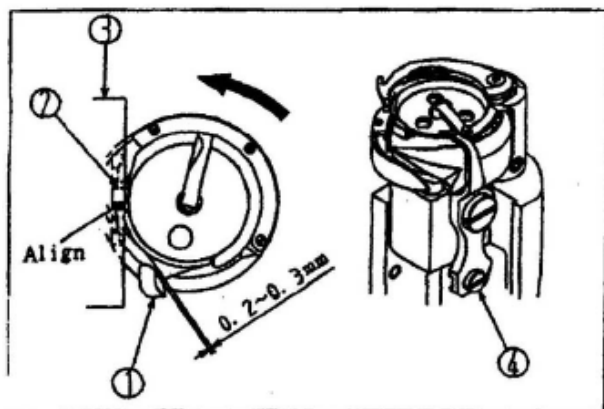
- (1) set the stitch length at “6” in the stitch length setting dial.
- (2) lower the needle bar to its lowest position.
- (3) lean the machine head backward, make sure Ⓐ (the center of the sprocket hole) locate in the same direct line with the flash line of hook shaft.
- (4) If the position of Ⓐ is not correct, then move again the timing belt and install it.

## 17. 梭殼開啟桿之調整

### 17. ADJUSTMENT OF THE HOOK OPENER

△注意	請先關閉電源開關，以防意外的人身傷害。 操作之前，請確保馬達是確實停止轉動的。
-----	--

CAUTION	Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.
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1) 用手轉動手輪，直至①梭殼開啟桿不再轉動。

2) 使針板③與內旋梭②在一條線上，用手逆時針轉動內旋梭②

3) 鬆開螺絲④，調整①梭殼開啟桿與梭殼蓋之距離為 0.2~0.3mm，然後擰緊螺絲。

1) Rotate the hand wheel until ① hook opener can not rotate any more.

2) Make the needle plate align with the inner hook ②, use your hand to turn the inner hook ② counterclockwise

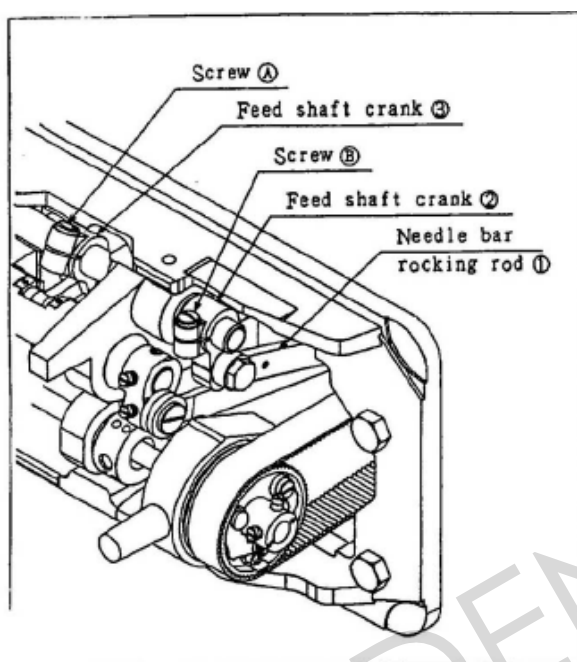
3) Loosen screw ④, adjust the distance between ① hook opener and hook cover to be 0.2~0.3mm, then tighten the screw.

## 18. 針的作動與送料齒作動之關係

### 18. RELATIONSHIP BETWEEN NEEDLE MOTION AND FEED DOG

△注意	請先關閉電源開關，以防意外的人身傷害。 操作之前，請確保馬達是確實停止轉動的。
-----	--

CAUTION	Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.
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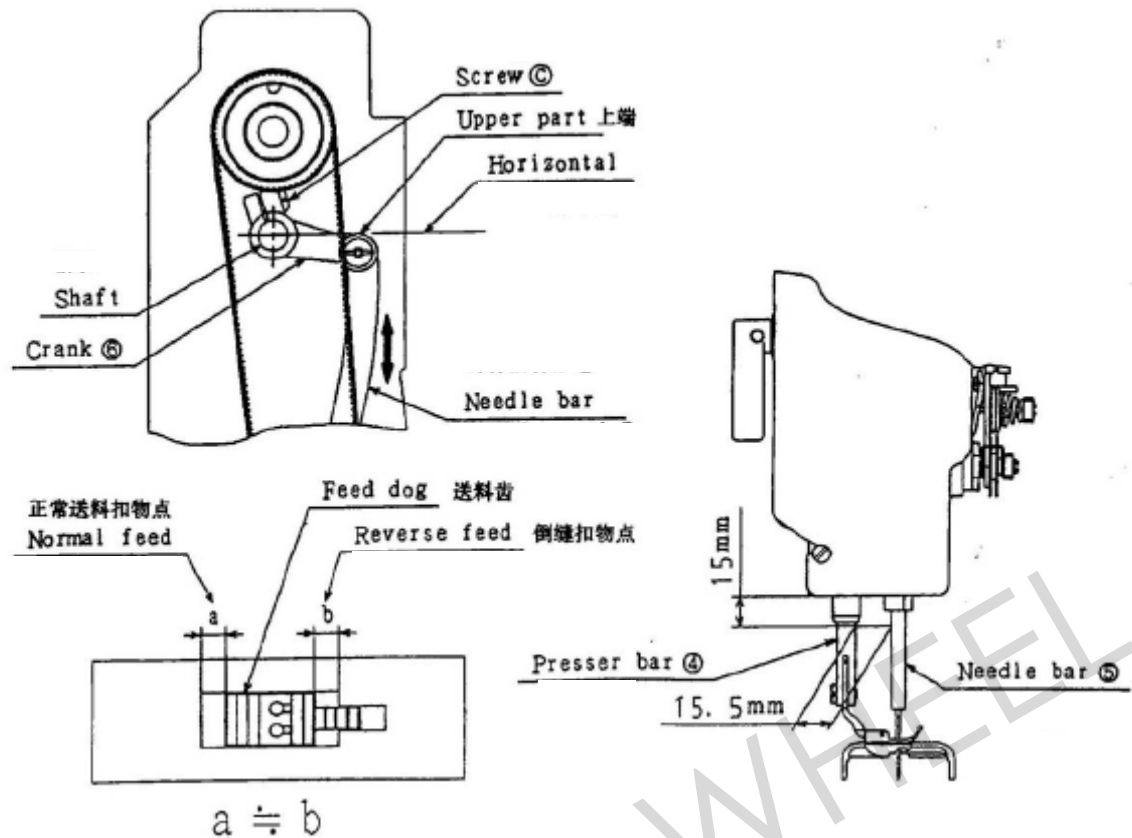
送料齒需被調整為：針可以陷入送料齒之針孔的中央。

- 1) 將縫目設定長度之轉盤，設定於縫目長度為“0”之位置。
- 2) 將機頭向後傾倒。
- 3) 鬆開送料軸曲柄之螺絲A和B。
- 4) 將針降到最低點。
- 5) 將押腳棒E與針D之間的距離，調整為15.5mm。且暫時將送料曲柄的螺絲A和B鎖緊。
- 6) 設定縫目長度為“0”。轉動手輪使旋轉，到針棒在最低點時，確保曲柄C上端與釜軸的底線在同一水平線上。
- 檢查並確認圖上 a 送料機構與 b 倒縫機構在縫目長度為 6mm 的同一水平線上。
- 如連接桿不在正確的位置，移開後蓋，鬆開螺絲C並按照箭頭的方向移動針棒搖動桿E，調試之。
- 7) 完成以上的調整后，請鎖緊螺絲A和B以及C。

The feed dog should be adjusted as: The needle can low down the center of the feed dog needle hole.

- 1) Set the stitch length to be “0” on the stitch length setting dial plate.
- 2) lean the machine head backward
- 3) loosen the screw A B of the feed shaft crank
- 4) low down the needle to its lowest position.
- 5) adjust the distance between presser foot barE and needleD to be 15.5mm, and tighten the feed crank screw A and B temporary.
- 6) set the stitch length to be “0”, turn the hand wheel to make the needle bar stay at its lowest position, at the same time, top of crankC should align with the bottom line of hook shaft in horizontal direction.

- check and confirm a (feeding mechanism) and b (backtacking mechanism) are at the same horizontal line where the stitch length is 6mm.
  - If the connecting rod is not at the correct position, take away the back cover, loosen screw C and move the needle bar rocking lever toward the arrow direction.
- 7) Tighten screw A, B and C after those adjustment upside have been finished.

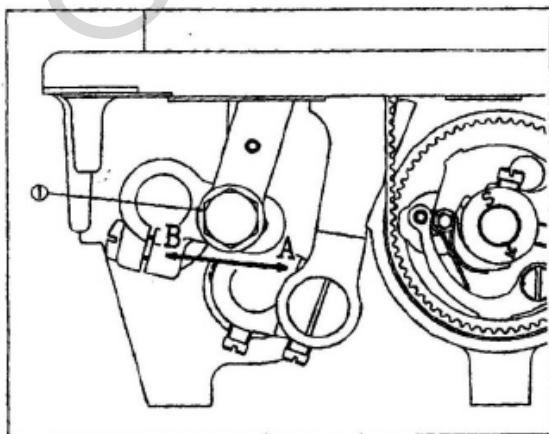


19. 針棒機構之差動送料作動

#### 19. RATIO FEED MOTION OF NEEDLE BAR MECHANISM

△注意	請先關閉電源開關，以防意外的人身傷害。 操作之前，請確保馬達是確實停止轉動的。
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CAUTION	Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.
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- 1) 鬆開鉸鏈螺絲①，當你將其往 A 方向移動時，針棒架的衝力就會增加，並且送料齒之差動送料也會開始作業，如果往 B 方向移動時，針棒作動的衝力就會減小。

提示：

做此調整時，請確保調整是在送料齒之針孔之小範圍內完成。

- 1) Loosen the gemel screw①, The needle bar frame's impulse will be increased when you move the screw toward A, and feed dog's ratio feed will start, if toward B, the impulse will be decreased.

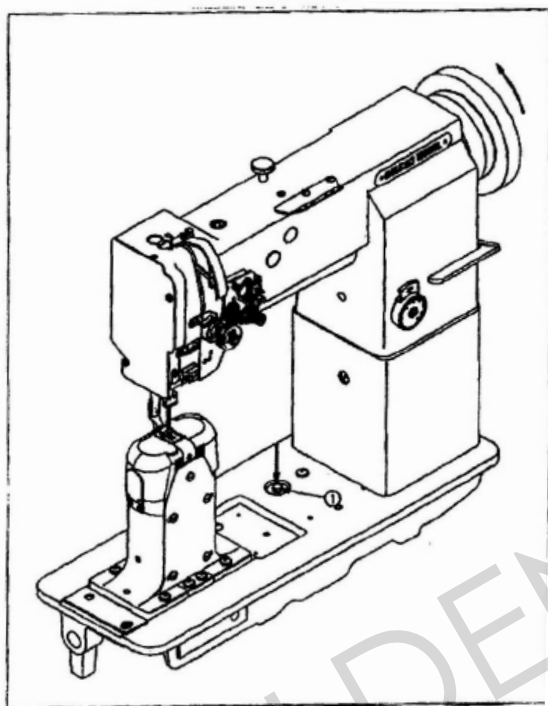
NOTE: when you do this adjustment, please make sure it is in the range of the needle hole.

## 20. 安全離合器之嚙合

## 20. THE ENGAGE OF THE SAFE CLUTCH

△注意	請先關閉電源開關，以防意外的人身傷害。 操作之前，請確保馬達是確實停止轉動的。
-----	--

CAUTION	Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.
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- 1) 經常要清理大釜內雜物，並確保不要讓雜物落入大釜內，並請莫使用任何尖銳工具。
- 2) 按下按鈕①並且慢慢往後轉動手輪重新嚙合安全離合器。

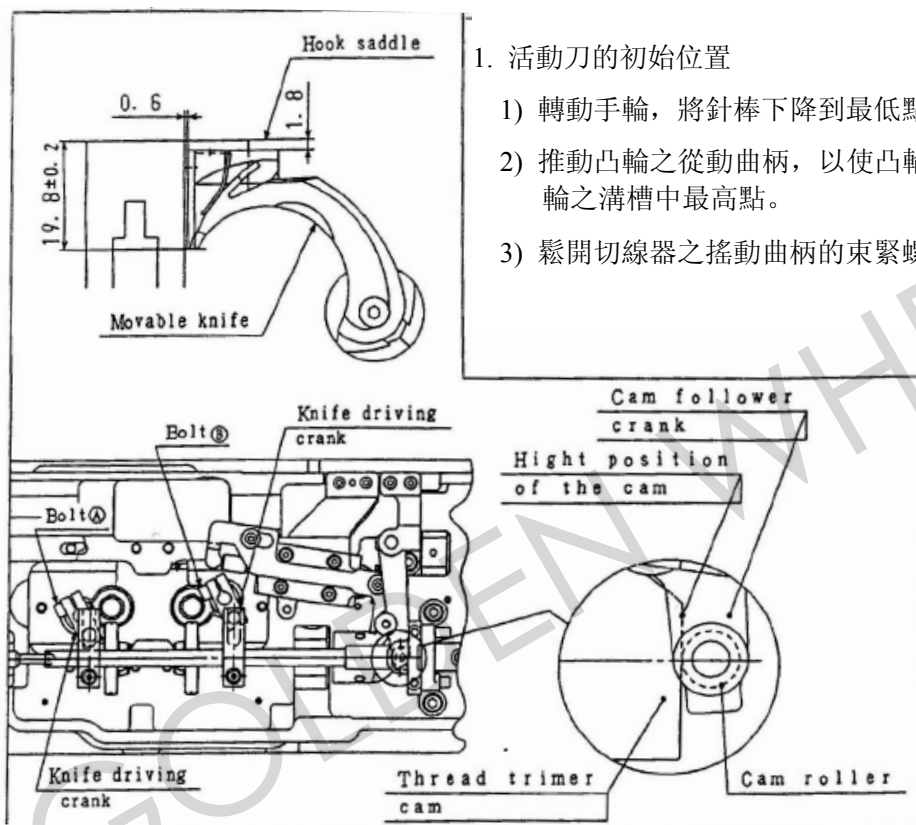
- 1) Clean the sundries inside the large hook, and make sure no sundries can fall down in the hook, please do not use any sharp tools.
- 2) Press the button ① and turn the hand wheel backward slowly, reengage the safe clutch.

## 21. 活動刀和固定刀的安裝方法

## 21. INSTALLATION OF THE MOVABLE KNIFE AND THE FIXED KNIFE

△注意	請先關閉電源開關，以防意外的人身傷害。 操作之前，請確保馬達是確實停止轉動的。
-----	--

CAUTION	Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.
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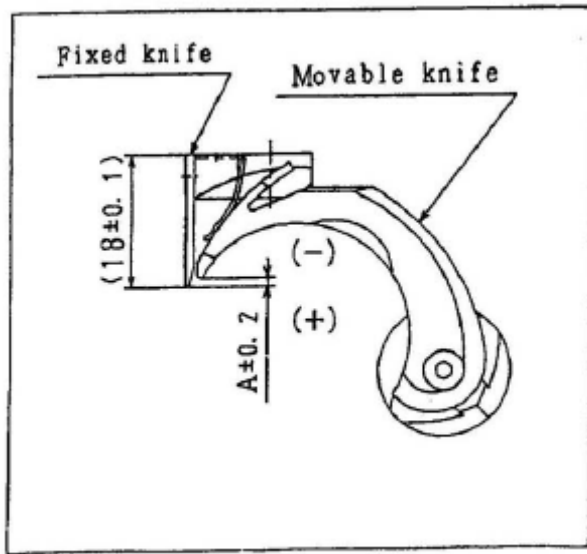


### 1. 活動刀的初始位置

- 1) 轉動手輪，將針棒下降到最低點。
- 2) 推動凸輪之從動曲柄，以使凸輪之珠子進入切線器凸輪之溝槽中最高點。
- 3) 鬆開切線器之搖動曲柄的束緊螺栓①和②。

### 1. The original position of the movable knife.

- 1) Turn the hand wheel, low down the needle bar to its lowest position.
- 2) Push the driven crank of the cam to make its beads go up to the top position in the groove of the thread cutter cam.
- 3) Loosen the screw bolt ① ② of the shaking crank of the thread cutter.



## 2. 活動刀之位置

調節活動刀時，請依據如下所列之固定刀活動度之標準。

- 1) 鬆開固定刀之束緊螺栓Ⓐ。
- 2) 調整固定刀，按照圖上所示，往Ⓑ和Ⓒ方向移動，然後鎖緊螺栓。

## 2. Adjust the position of the movable knife.

Please refer to the moving range standard of the fixed knife when you adjust the movable knife.

- 1) Loosen the tighten screw bolt Ⓐ of the fixed knife.
- 2) Adjust the fixed knife moving toward Ⓑ and Ⓒ direction under the suggestion of the blank below, then tighten the screw bolt.

Model	Moving range A	
	Left	Right
7363-BT 7364-BT	0	0
7363L-BT 7364L-BT	0	+0.5

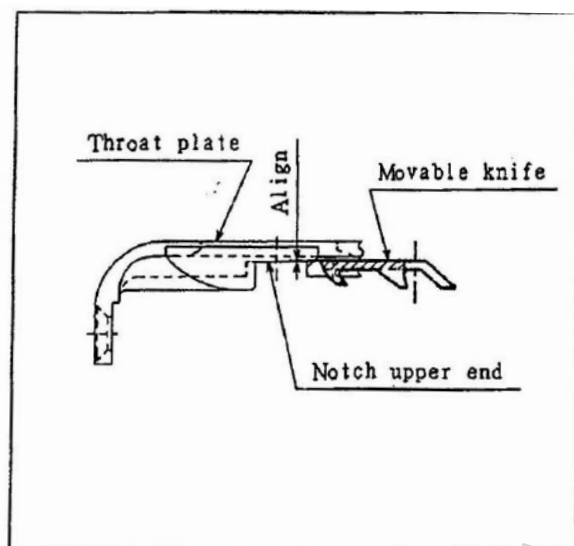
型號	活動度 A	
	左邊	右邊
7363-BT 7364-BT	0	0
7363L-BT 7364L-BT	0	+0.5

## 22. 活動刀和固定刀之高度調節

### 22. ADJUSTMENT OF THE HEIGHT OF THE FIXED KNIFE AND THE MOVABLE KNIFE

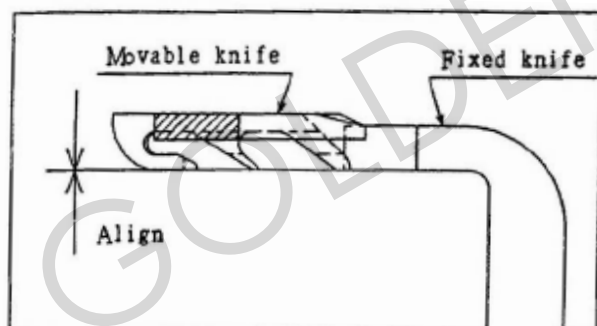
△注意	請先關閉電源開關，以防意外的人身傷害。 操作之前，請確保馬達是確實停止轉動的。
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CAUTION	Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.
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活動刀之高度，針板之上槽口與活動刀之端的是是一致的。

Height of the movable knife, the upper rabbet of the needle plate align with the notch upper end.



固定刀之高度，活動刀之底部與固定刀之底部是一致的。

Height of the fixed knife, the bottom of the movable knife align with the fixed knife's bottom.

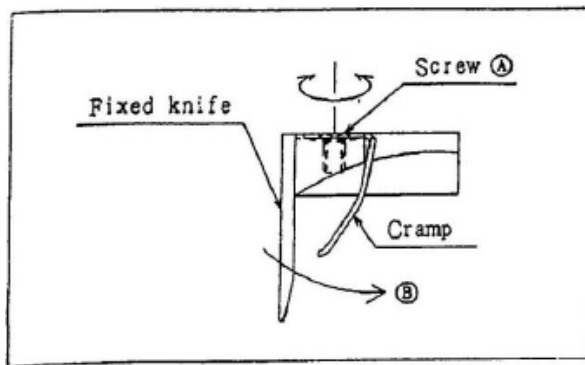


### 23. 鐵棒之調節方法

#### 23. ADJUSTMENT OF THE IRON BAR

△注意	請先關閉電源開關，以防意外的人身傷害。 操作之前，請確保馬達是確實停止轉動的。
-----	--

CAUTION	Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.
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往右轉動螺絲Ⓐ，鐵棒會向圖上之Ⓑ方向移動。

情形之一種為其離活動刀很近，這是很正常的。

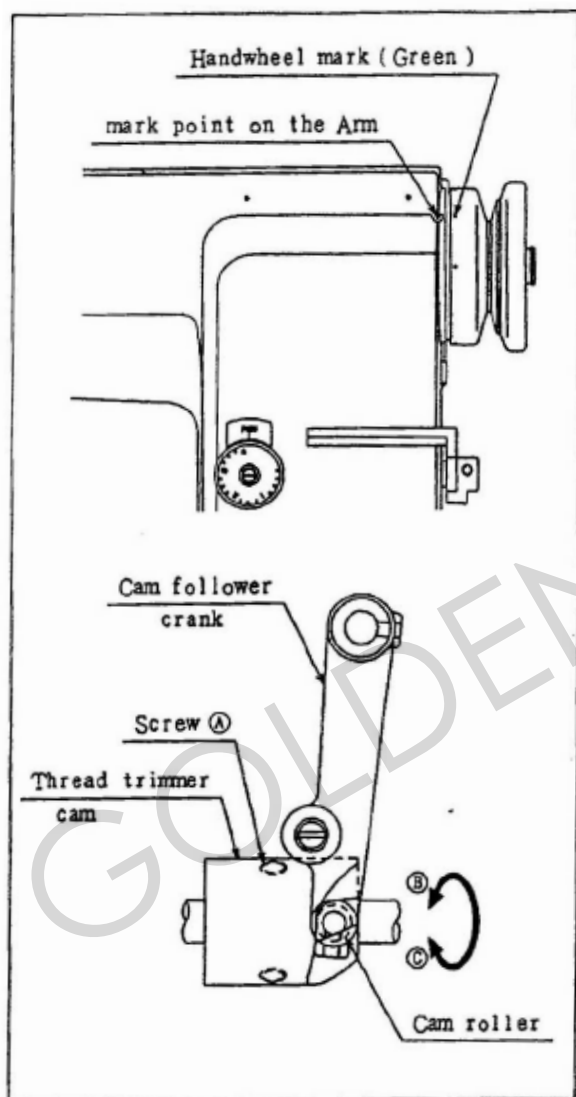
Turn the screw to the right side, the iron rod will move to the Ⓑside, there is one situation that the iron rod will be near the movable knife, this is normal.

## 24. 切線器之凸輪之調整

### 24. ADJUSTMENT OF THE THREAD CUTTER'S CAM

△注意	請先關閉電源開關，以防意外的人身傷害。 操作之前，請確保馬達是確實停止轉動的。
-----	--

CAUTION	Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.
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- 1) 用手轉動手輪，直至針下降到最低點的位置。
- 2) 維持住針的位置，壓下凸輪之從動曲柄，且將凸輪之珠子置入切線器的溝槽中。
- 3) 用手轉動皮帶輪，以使當皮帶輪之切線器之記號（綠色點）移動到Ⓑ和Ⓒ的位置時，與曲臂上的記號點在一條線上。  
調節時，鬆開切線器之凸輪之螺絲Ⓐ（2處）

- 1) Turn the hand wheel until the needle arrives at its lowest position.
- 2) Hold the needle to its position, press down the driven crank of the cam, fill the beads of the cam into the thread cutter's groove.
- 3) Use your hand to turn the belt wheel, when the mark point(green point) on the thread cutter of the belt wheel arrives at the position Ⓑ and Ⓒ. Then it turn to be at the same line with the mark point on the crank arm. Loosen the cam's screw Ⓐ of the thread cutter.

## 25. 更換針位組之調節

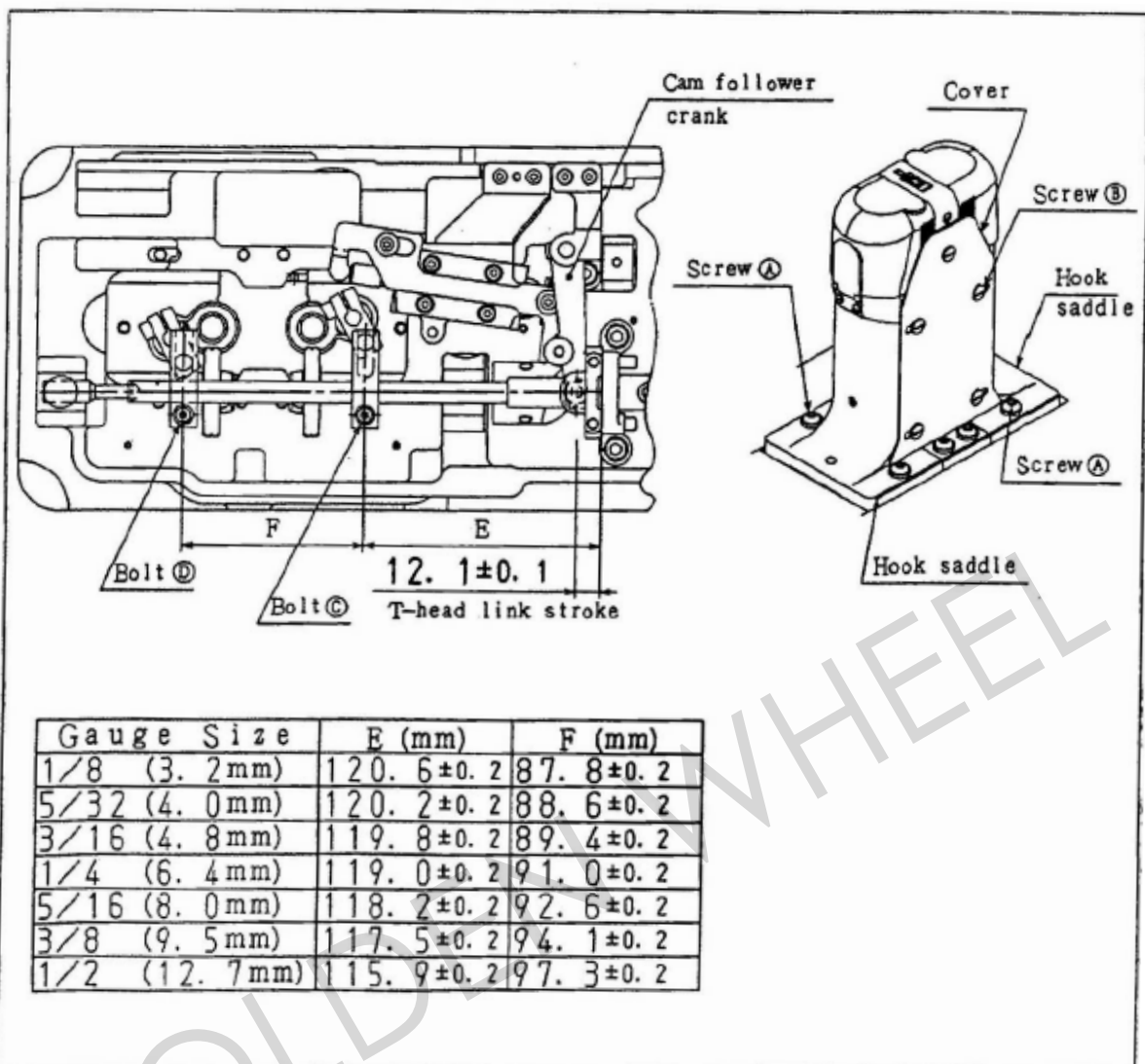
### 25. ADJUSTMENT FOR CHANGE OF THE NEEDLE GAUGE

△注意	請先關閉電源開關，以防意外的人身傷害。 操作之前，請確保馬達是確實停止轉動的。
-----	--


CAUTION	Turn of the power supply to prevent from unexpected injury. Be sure to confirm the stop of rotation of the motor before operation.
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- 1) 更換針板、送料齒、以及針榴。(由於針板和送料齒，是針對切線器而特殊設計的。請確認當使用這些特殊的零件時)
- 2) 將機頭向后傾倒。
- 3) 鬆開兩個連接桿的束緊螺栓◎和◎。
- 4) 鬆開旋梭座的束緊螺絲◎和◎。然後調整針與旋梭之間距。最後再鎖緊束緊螺絲◎和◎。
- 5) 按照下圖所示，在連接桿 E (mm) 和 F (mm) 之間調整。
- 6) 鎖緊連接桿之束緊螺母◎和◎。

- 1) Replace the thread plate, feed dog and needle clamp.(Since the thread plate and feed dog are special parts designed for thread trimming machine, be sure to use those specified by us.)
- 2) Lean the machine head backward.
- 3) Loosen two connecting link clamp bolts ◎◎
- 4) Loosen screw ◎ and ◎, then adjust the gap between the needle and hook, after that you can tighten screw ◎ and ◎.
- 5) Do the adjustment between connecting bar E and F according to the picture hereunder.
- 6) Tighten the nut◎ and ◎.



## 26. 常見問題與解決方法

常見問題	原因	解決方法
1. 斷線(線磨斷或磨損)  (針的縫線(上線)仍然有 2~3 公分留在物料的錯誤邊之上)	(1) 線道、針尖、旋梭尖端或梭子定位器，有損傷。 (2) 針的縫線(上線)之張力太高。 (3) 梭殼開口過大。 (4) 針撞擊到旋梭尖端。 (5) 針的縫線(上線)張力太低。 (6) 吊線彈簧的衝程太小，以至於吊線彈簧的張力過高。 (7) 針與旋梭之定時，太早或太晚。	○ 用細砂紙將旋梭尖端之損傷，予以磨除，將梭殼定位器予以拋光處理。 ○ 適當調整縫線(上線)之張力。 ○ 請參照“17.梭殼開口之調節方法”，以及“13.針與旋梭之相對關係” ○ 適當調整針的縫線(上線)之張力 ○ 請參照“13.針與旋梭之相對關係”
2. 跳針	(1) 針與旋梭尖端之間距過大。 (2) 針與旋梭之定時，太早或太晚。 (3) 押腳的壓力太低。 (4) 針孔頂端與旋梭尖端之間距不正確。 (5) 旋梭開口過大。 (6) 針的尺寸大小錯誤。 (7) 使用合成線或細線。	○ 請參照“13.針與旋梭之相對關係” ○ 請參照“13.針與旋梭之相對關係” ○ 增加押腳的壓力。 ○ 請參照“13.針與旋梭之相對關係” ○ 請參照“17.梭殼之開口調節方法” ○ 將針換成大一號的針。 ○ 如圖所示，將線繞於針之上 
3. 縫日鬆弛	(1) 縫線(底線)未穿過梭殼的張力彈簧槽口之中。 (2) 線道的磨光處理不良。 (3) 旋梭的旋轉不夠平順。 (4) 旋轉開口過大。 (5) 梭子底線的張力過低。 (6) 梭子底線繞的太緊。	○ 需正確的穿線 ○ 用細砂紙予以拋光處理。 ○ 更換梭子或旋梭。 ○ 請參照“17.梭殼之開口調節方法”。 ○ 適當的調整線的張力。 ○ 減少梭子底線的繞線之張力。
4. 切線之後，線從針孔滑落出來。	(1) 輔助之線張力控制器的張力太高。 (2) 切線之定時太早。 (3) 吊線彈簧的回復力量太高。	○ 減少張力。 ○ 請參考“24.切線器之凸輪之調整” ○ 請調整吊線彈簧之高度。

常見問題	原因	解決方法
5. 上線無法被切斷，下線可以被切斷。	(1) 最後一針跳針了(針與旋梭之間距過大)。	○ 請參照“13.針與旋梭之相對關係”。
6. 上線，下線都無法切斷。	(1) 切線時間不對。 (2) 切線刀受損。 (3) 切線刀的壓力不適當。 (4) 切線刀的原點位置不正確。 (5) 活動刀無法有效的作動。 (6) 切線器的電池閥無法有效的作動。	○ 請參照“24.調節切線器之凸輪”。 ○ 請更換切刀。 ○ 增加切線刀之壓力。 ○ 請參照“24.調節切線器之凸輪”。 ○ 用手使之作動並檢查是否正確。 ○ 檢查馬達的電池閥是否能有效作動。
7. 線無法被及時，鋒利的切斷。	(1) 切線時間不對。 (2) 切線刀的壓力不適當。 (3) 刀片的刀鋒變鈍。	○ 請參照“24.調節切線器之凸輪”。 ○ 增加切線刀的壓力。 ○ 更換切線刀。

## 26. FREQUENTLY ASKED QUESTIONS AND SOLUTIONS

Frequently asked questions	reason	solutions
1. broken line (line is rubbing off or wear down)  (needle thread remains 2 to 3 cm on the wrong side of the cloth)	① the thread path, needle point, hook point or bobbin case positioning finger has scratches. ② the needle thread tension is too high. ③ the opening of the bobbin case is too large. ④ the needle hits the hook point ⑤ the sewn thread tension is too low. ⑥ the thread take-up spring has an excessively high tension while it has an excessively short stroke. ⑦ the timing between the needle and hook is too early or too late.	○ remove the scratches on the hook point using a fine sand paper. buff the bobbin case positioning finger ○ adjust the needle thread tension properly ○ see 17 adjustment of the bobbin case's opening and 13 needle to hook relation ○ adjust the needle thread tension properly ○ see 13 needle to hook relation.
2. stitch skipping	① clearance between needle and hook point is too large. ② the timing between needle and hook is too late or too early ③ the pressure of the presser foot is too low. ④ the clearance between the top edge of the needle eyelet and the hook point is not correct. ⑤ opening of the hook is too large ⑥ the size of the needle is incorrect. ⑦ a synthetic fiber thread or thin thread is used.	○ see 13 needle to hook relation ○ see 13 needle to hook relation ○ increase the pressure of the presser foot ○ see 13 needle to hook relation ○ see 17 adjustment of opening of the bobbin case ○ change the needle to a larger size ○ wind the thread round the needle as illustrated.
3. Loose stitches	① the thread has not been passed through the notch of the bobbin case tension spring ② the thread path is poorly finished ③ the bobbin does not rotate smoothly ④ the opening of the hook is too large ⑤ the bobbin thread tension is too low. ⑥ the bobbin thread has been wound tight.	○ properly thread the bobbin case ○ grind it using a fine sand paper of a buff ○ replace the bobbin or hook ○ see 17 the adjustment of the opening of the hook cover ○ properly adjust the thread tension ○ decrease the bobbin thread winding tension.
4. The thread slips off the needle after being trimmed.	① the tension of the auxiliary thread tension controller is too high. ② the thread trimming timing is too early ③ the returning force of the thread take-up spring is too high.	○ decrease the tension ○ see 24 the adjustment of the cam of the thread cutter ○ adjust the height of the thread take-up spring

5. The needle thread can not be trimmed while the bobbin thread can be trimmed	① The last stitch has been skipped(the clearance between the needle and the hook is too large)	○See 13 needle to hook relationship
6.Both needle thread and bobbin thread cannot be trimmed	① The thread trimming timing is wrong ② the knife has been damaged ③ the knife pressure is inadequate ④ the original point of the knife is incorrect ⑤ the movable knife fails to work ⑥ the thread trimming solenoid fails to work	○ see 24 to adjust the thread trimmer cam ○replace the knife ○increase the knife pressure ○see 24 adjust the trimmer cam ○check it by actuating it by hand ○ check the motor solenoid for proper operation
7.Thread cannot be trimmed sharply in time	① the thread trimming timing is wrong ② the knife pressure is inadequate ③ the knife blade is blunt	○see 24 adjustment of the thread trimmer cam ○increase the knife pressure ○replace the knife



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