

全自动高速电脑罗拉车系列

**MODERN POST-BED HIGH-SPEED
MACHINE SERIES**

使用说明及零件手册

INSTRUCTION MANUAL

AND

SPARE PARTS LIST

**请在操作使用前仔细阅读此说明书并保留此
说明书以供将来参考**

Please read instructions carefully and understand
then before using

Retain this instruction manual for future reference

第一部分

操作说明

OPERATION DECLARATION

1. 技术数据 Specifications

线迹形式 Stitch type.....	301(锁式线迹 Lockstitch)
在滚轮压脚下通过高度 Clearance under roller presser.....	7mm
空间宽度 Clearance width.....	245mm
空间高度 Clearance height.....	115mm
柱式底板高度 Post height.....	180mm

缝纫机机头尺寸 Sewing head dimensions

长度 Length	大约/approx.615mm
宽度 Width	大约/approx.240mm
高度(台板以上) Height (above table)	大约/approx.500mm
底板尺度 Bedplate dimensions	518X177mm

机型分类 Type

单针和双针 Single needle and double needle

A 型 model A	适用于缝纫轻薄型材料 For sewing lightweight materials
B 型 model B	适用于缝纫中等厚度材料 For sewing medium-weight materials
C 型 model C	适用于缝纫厚材料 For sewing medium-heavy materials

缝纫线规格 Nm (最大) Thread thicknesss Nm(max.synthetic)

A 型 model A.....	60/3
B 型 model B.....	40/3
C 型 model C.....	15/3

机针型号 Needle model

A 型单针 Model A single needle	70/134
B 型单针 Model B single needle	90/134
B 型双针 Model B double needle	90/134-35
C 型单针 Model C single needle	120/134
C 型双针 Model C double needle	120/134-35

最高速度 Max. speed

A、B 型	3000 线迹/分/spm
C 型	2000 线迹/分/spm

2. 安装 Installation

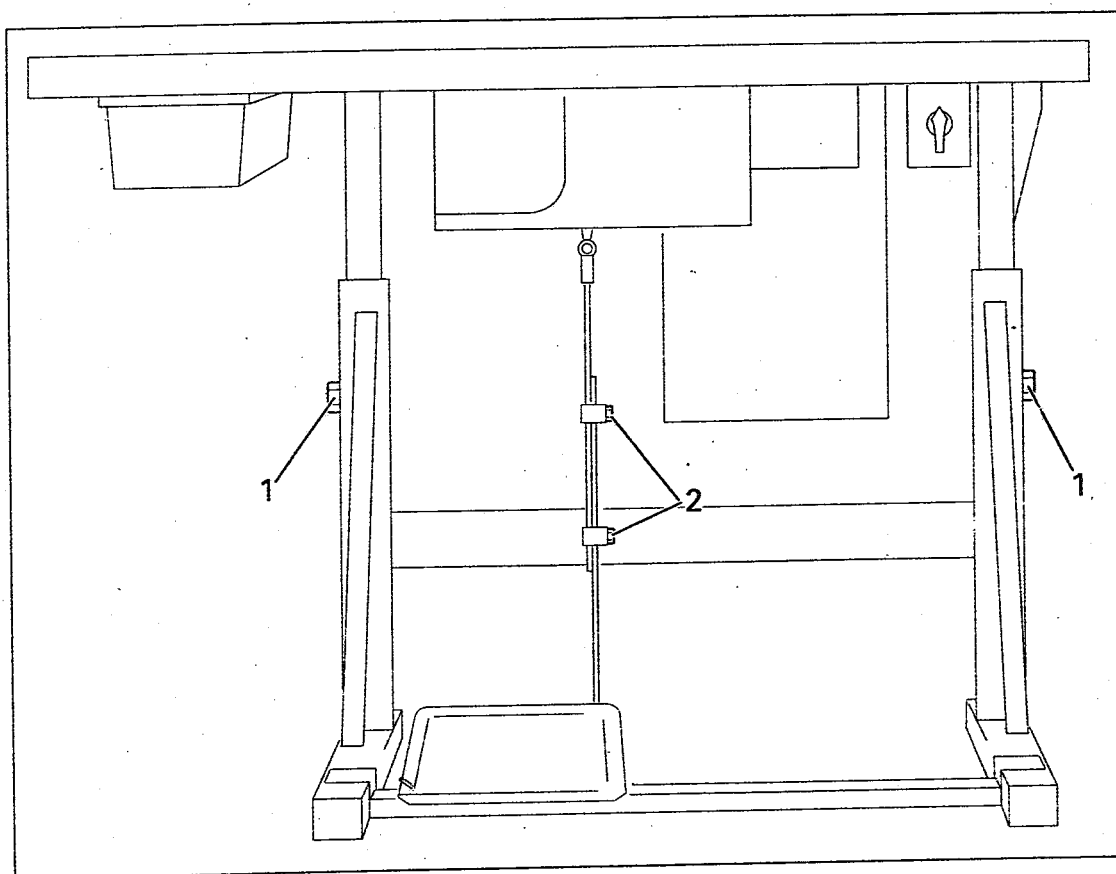
在机器安装地点，必须有与机器相符的电源接口。

在机器安装地点，必须有平整、坚固的地面，以及充分的照明。

The site where the machine is installed must be provided with suitable connections for electric current.

It must be ensured that the standing surface of the machine site is firm and horizontal, and that sufficient lighting is provided for.

2.01 台板高度的调整 Adjust the table height



松开螺钉 1 和 2，并将台板调整至所需的高度；

将螺钉 1 牢固地拧紧；

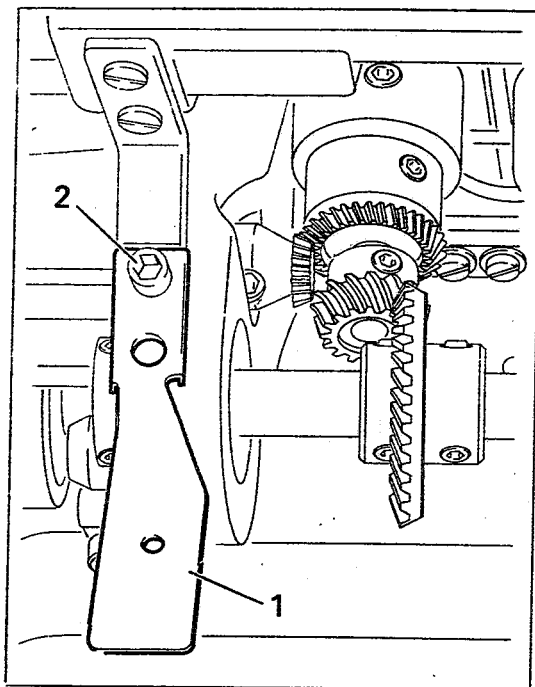
将踏板调至所需的位置，并且将螺钉 2 拧紧。

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

Firmly tighten screw 1;

Set the required pedal position and tighten screw 2.

2.02 安装翻转保险 Fitting the tilt lock



关闭电源总开关；

用螺栓 2 固定翻转保险 1。

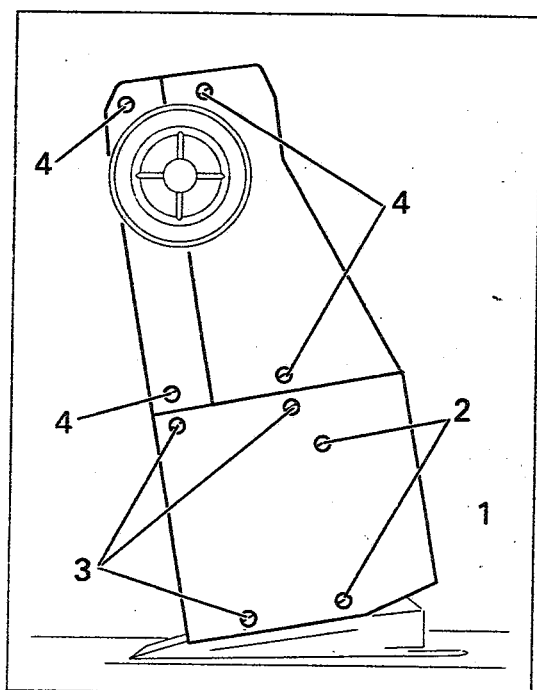
注：不许开动没有翻转保险 1 的机器！
有在机头和台板之间被挤伤的危险！

Switch off the machine;

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

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

2.03 安装机器护罩 Fitting the machine cover



在螺钉 2 的头部后面（螺钉 2 预先拧在机壳上），将护罩 1 沿下部的槽滑入并用螺钉 3 固定，然后通过通孔拧紧螺钉 2；

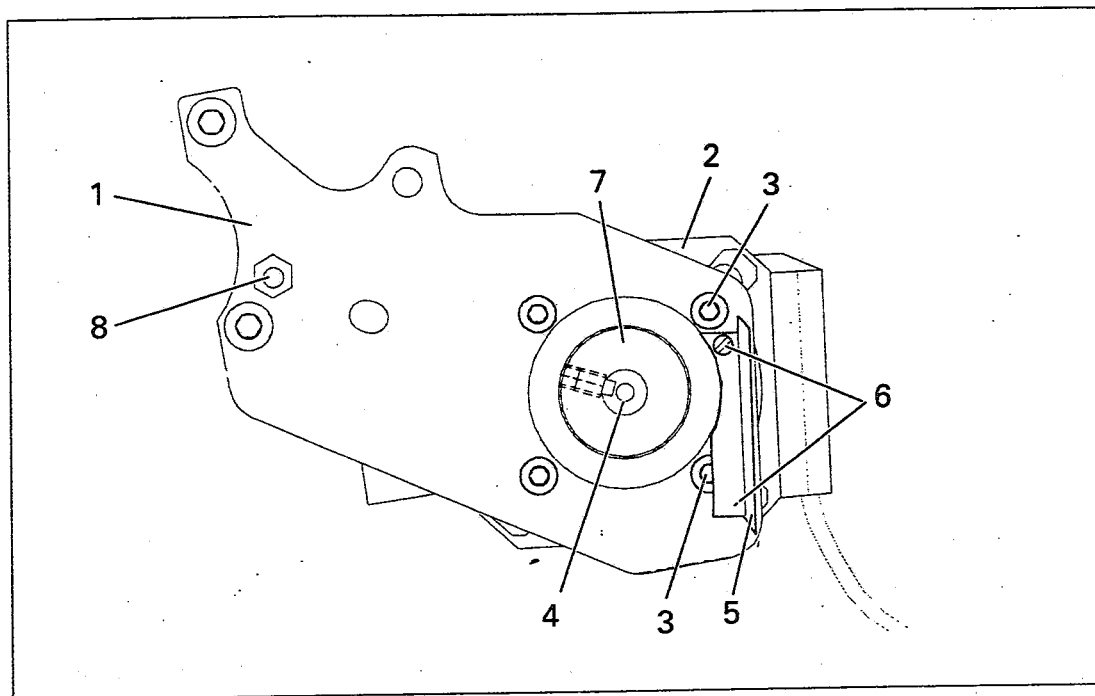
用螺钉 4 固定左右两部分护罩。

Slide the slots of the lower section of the cover 1 behind the heads of screws 2 and attach with screws 3 ,then tighten screws 2 through the holes;

Attach right and left cover sections with screws 4 .

2.04 将带法兰的电机安装到垫板上

Mounting the flange motor



如上图所示，用螺栓 3 将垫板 1 固定到电动机 2 上；
从电动机轴 4 上移去楔键；
用螺栓 6 固定角支座 5；
安装带齿的皮带轮 7 到电动机轴 4 上，螺钉的尖部要定位于电动机轴的凹槽中；
将螺栓 8 拧入到垫板 1 中。

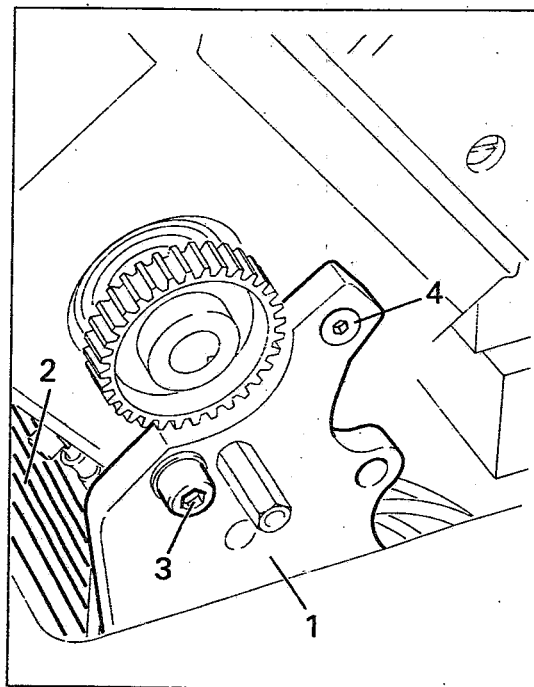
Attach bearing plate 1 to motor 2 with screws 3 as shown in Fig. ;
Remove the wedge from motor shaft 4 ;
Attach angle bracket 5 with screws 6 ;
Fit toothed belt wheel 7 to the motor shaft 4 ,so that the point of the screw is located in the groove of the motor shaft ;
Screw threaded stud 8 into the bearing plate 1 .

2.05 安装带法兰的电动机到机器上

Mounting the flange motor to the machine

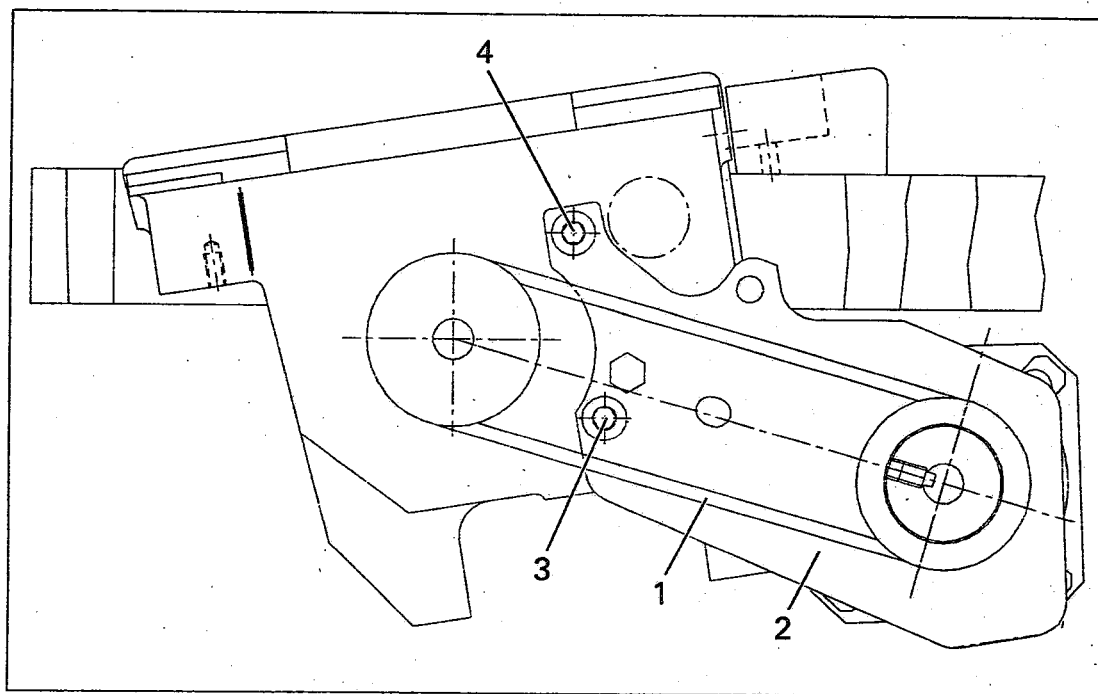
将板 1 固定到机器外壳上（只是轻微地拧紧螺栓 3）。

Attach bearing plate 1 of motor 2 to the machine case with screws 3 (only tighten screws 3 slightly)



2.06 安装齿形皮带并调整皮带张力

Mounting the toothed belt and adjusting the tension



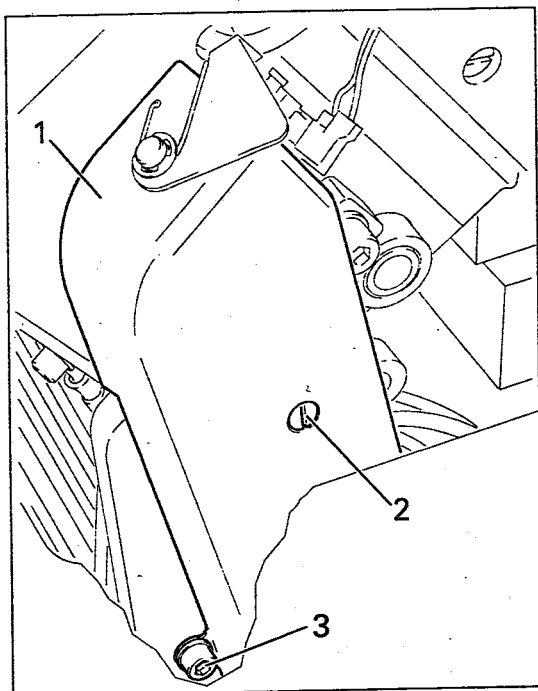
在这个位置安装齿形皮带 1;
摆动电动机的垫板 2, 以张紧齿形皮带;
在这个位置拧紧螺栓 3。

In this position fit toothed belt 1;

Swing the bearing plate 2 of the motor ,so that the toothed belt is tensioned;
In this position tighten screws 3.

2.07 安装带法兰电动机的皮带防护罩

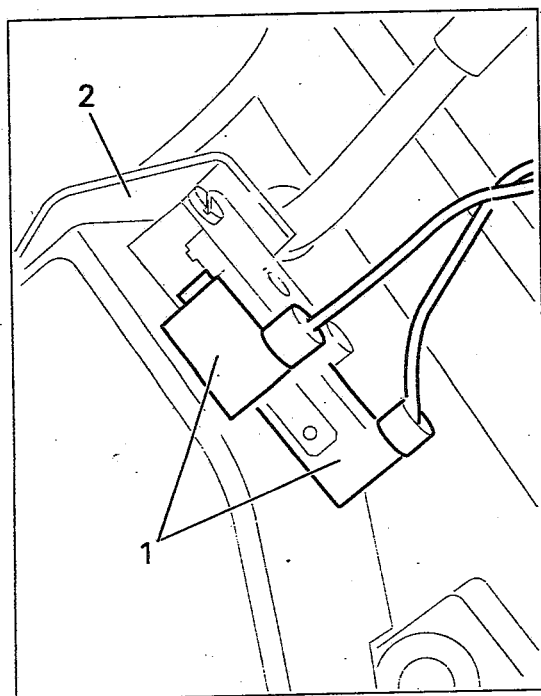
Mounting the belt guard of the flange motor



用螺钉 2 和 3 固定皮带防护罩。

Attach belt guard 1 with screws 2 and 3 .

2.08 连接安全开关 Connecting the safety switch



如图所示，连接安全开关 2 的插头 1。

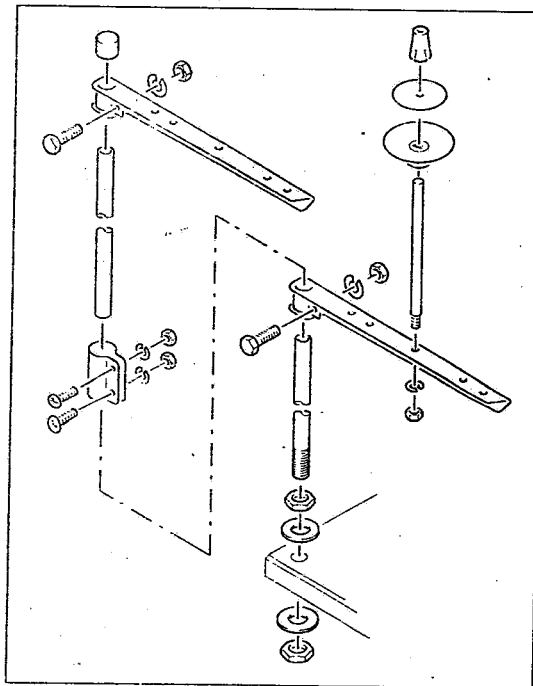
Connect plug 1 of safety switch in Fig..

2.09 安装线架 Fitting the reel

stand

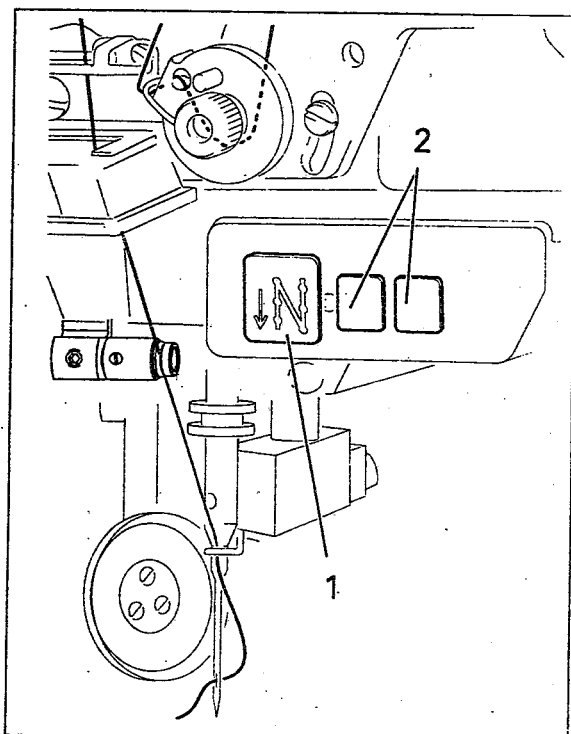
如图所示安装线架：
然后将线架插入台板的孔中并用随带的螺母可靠地固定。

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



3. 操作件 Controls

3.01 机头按键 Keys on the machine head

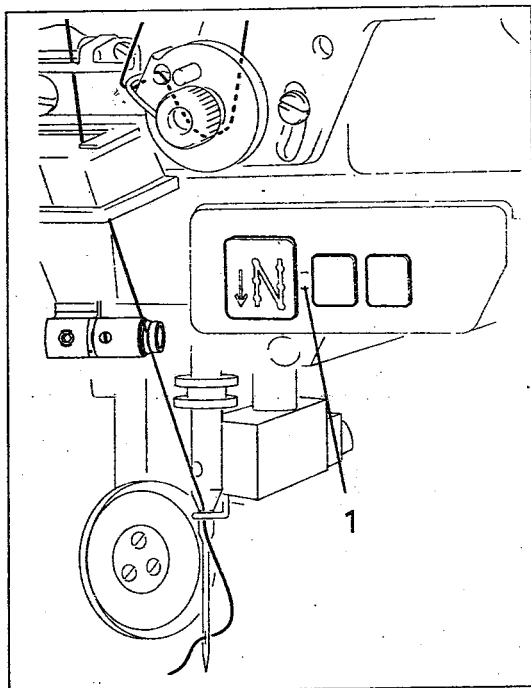


在缝纫过程中，只要按下按键 1，机器的缝纫方向就反转；
按键 2 是用来设置参数的，请详见电控说明书。

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

3.02 有线迹计数功能的梭芯线控制器

Bobbin thread monitoring with stitch counting

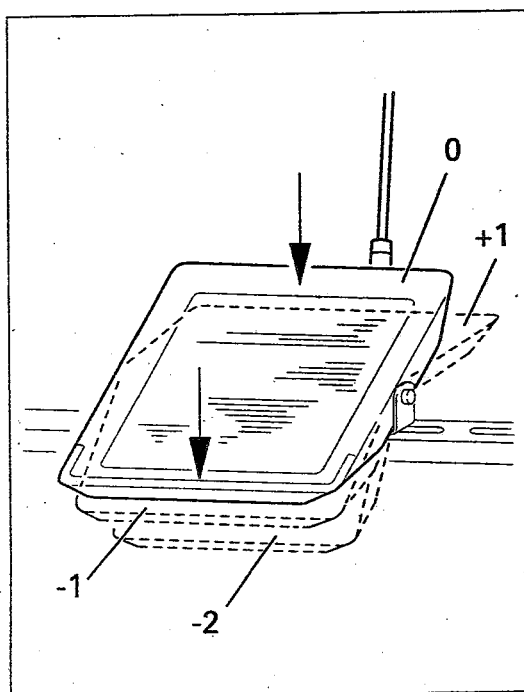


在达到预设线迹数量前大约 100 个线迹，发光二极管 1 开始闪烁；
在剪线后和更换梭芯后，线迹计数器就开始计数。

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

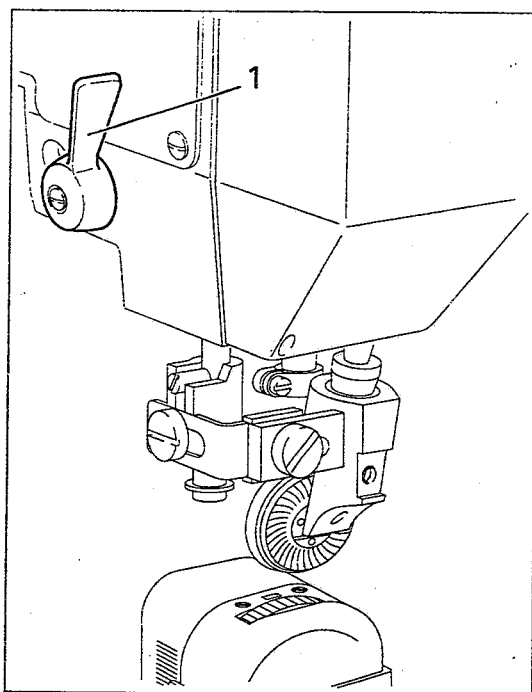
3.03 踏板 Pedal

- 0 = 静止位置 Neutral position
- +1 = 缝纫 Sewing
- 1 = 抬起滚轮压脚 Raise roller presser
- 2 = 剪线 Trim sewing threads



3.04 滚轮压脚扳手

Lever for lifting roller presser



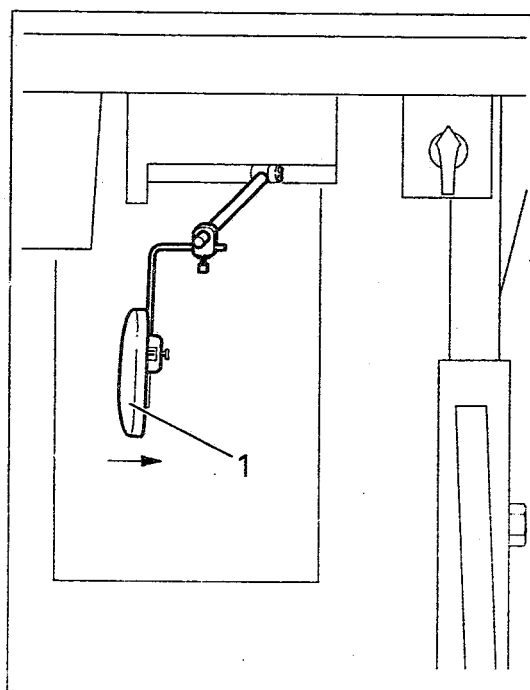
可以通过转动扳手 1 抬起滚轮压脚。

The roller presser can be raised by turning lever 1 .

3.05 膝控 Knee lever

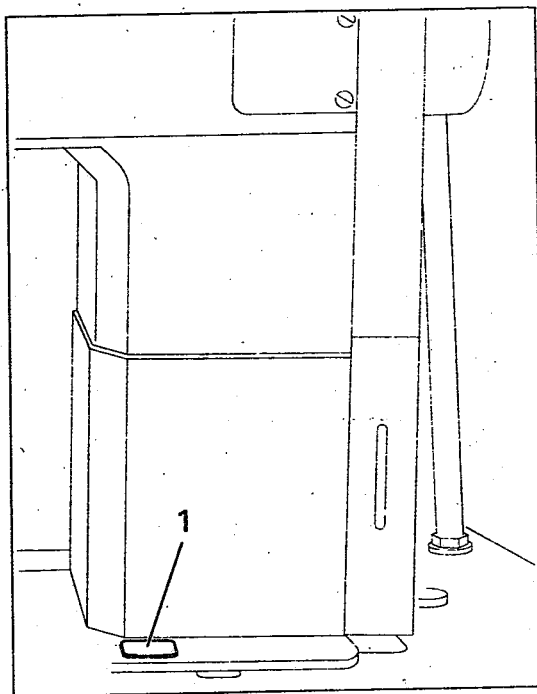
可以通过向箭头所示方向挤压膝控杆 1 来抬起滚轮压脚。

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



3.06 线迹长度设置按键

Key for setting stitch length



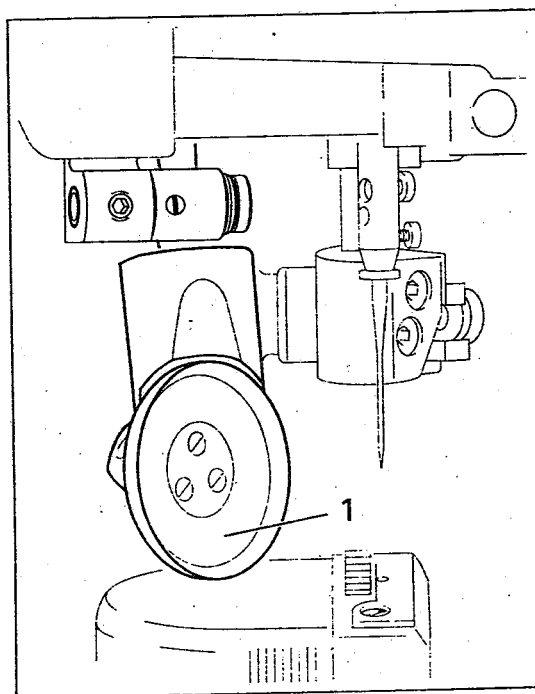
通过按下按键 1 并旋转手轮来设置线迹长度。

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

3.07 滚轮压脚向外摆动 Swing out roller presser

当滚轮压脚抬起后，可以通过向下轻拉它，使其向外摆动。

When the roller presser is raised, it can be swung out by pulling it lightly down-wards.



4. 缝纫操作准备 Preparation

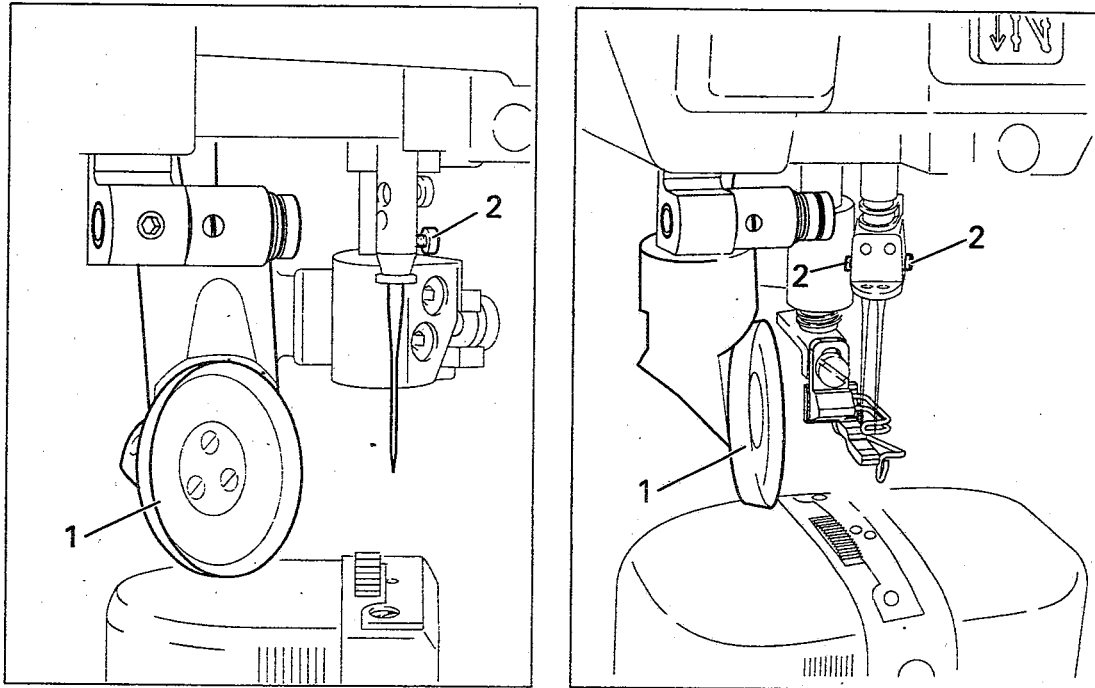
必须遵守本说明书中所有的规定和提示，特别要注意所有的安全规定；
所有机器准备工作只允许由受过相应培训的人员完成；
在所有的机器准备工作时，必须通过关闭总开关或者从电源插座上拔出插头，以使机器断电。

All instructions and regulations in this instruction manual must be observed , special attention must be paid to all safety regulations ;

All setting-up work must only be carried out by personnel with the appropriate training ;

For all setting-up work the machine must be disconnected from its power supply by turning off the on/off switch , or removing the plug from the electric power socket.

4.01 安装机针 Inserting the needle



抬起滚轮压脚 1 并将其向外摆动；
松开螺钉 2 并插入机针，使机针的长槽背对着各自勾线的旋梭（即勾线旋梭在左，长槽就向右；勾线旋梭在右，长槽就向左）；
拧紧螺钉 2 并将滚轮压脚摆回到原位置。

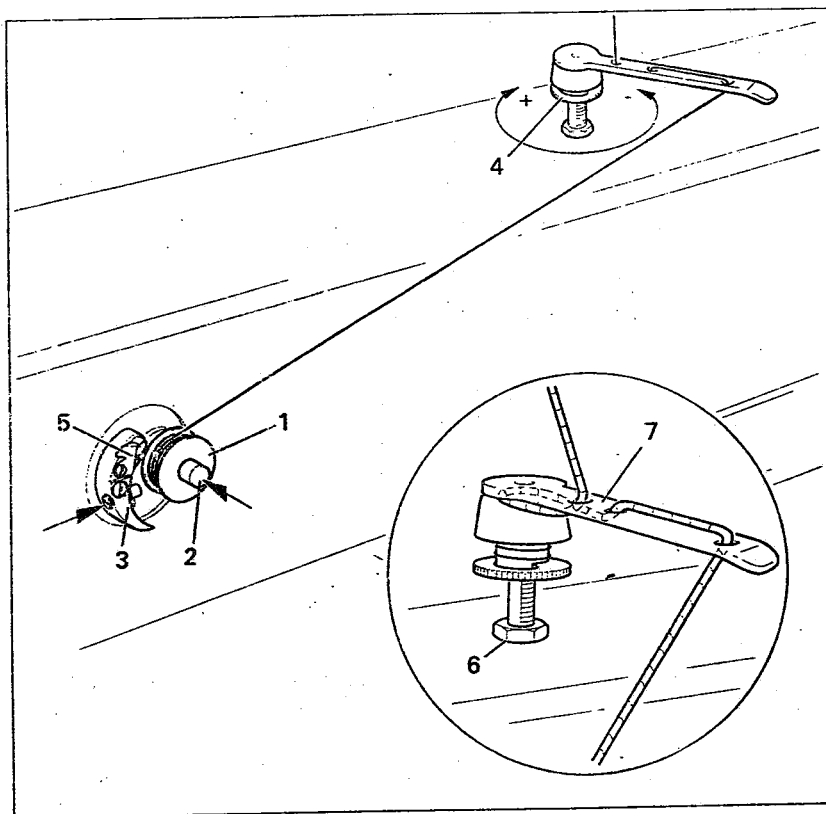
Raise the roller presser 1 and swing it out ;

Loosen screws 2 and insert the needle as far as possible , the long groove must be contrary to the hook (If the hook is on the left, the long groove must be on the right);

Tighten screw 2 and swing roller presser 1 back into position.

4.02 绕梭芯线，调整梭芯线的张力。

Winding the bobbin thread ,adjusting the thread tension.



将一个空的梭芯 1 安装到绕线器轴 2 上；

如图所示，给梭芯穿线，并将线顺时针方向在梭芯上绕几圈；

同时压下绕线器轴 2 和杠杆 3，启动绕线器。

Place an empty bobbin 1 onto bobbin shaft 2;

Thread the bobbin in accordance with Fig. and wind it anti-clockwise around bobbin 1 a few times;

Switch on the bobbin winder while at the same time pressing bobbin winder spindle 2 and lever 3.

缝纫过程中的梭芯绕线

在梭芯 1 上的线张力可以用滚花螺母 4 进行调节；

当梭芯绕满线后，绕线器自动停止；

如果绕线不均匀，可以松开螺母 6，相应转动调整导线板 7 并拧紧螺母 6。

The bobbin fills up during sewing

The tension of the thread on bobbin 1 can be adjusted with knurled nut 4;

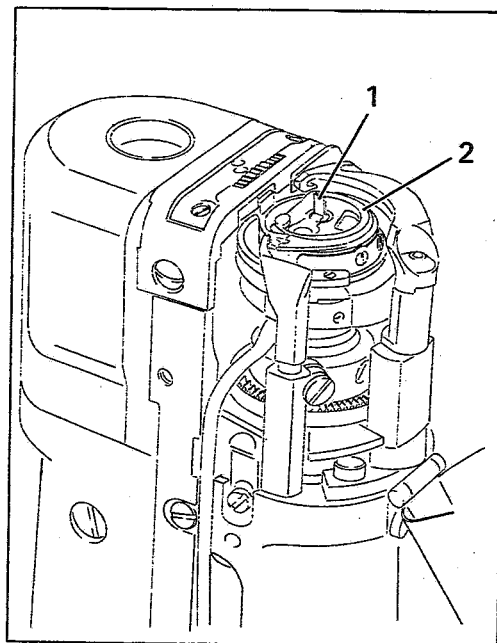
The bobbin winder stops automatically when bobbin 1 is full;

If the thread is wound unevenly , loose nut 6 and turn thread guide 7 accordingly .Retighten nut 6 after the adjustment .

4.03 取出/装入梭壳 Removing/Inserting the bobbin case

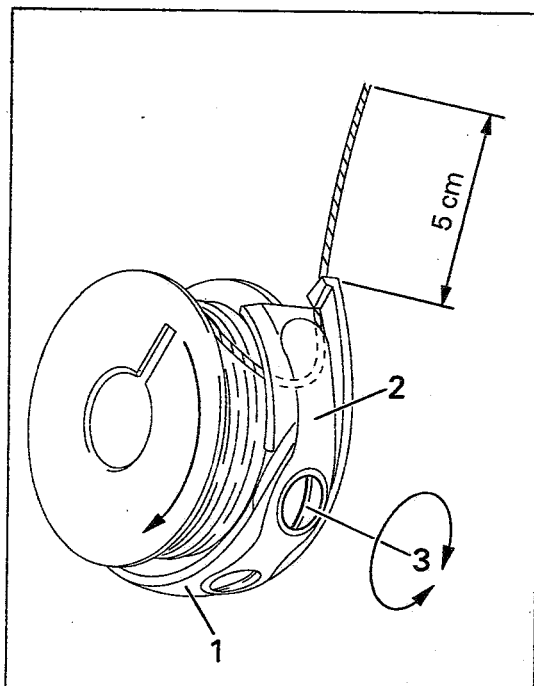
取出梭壳：
打开旋梭盖；
抬起梭门闩 1 并取出梭壳 2 。
装入梭壳：
装入梭壳 2；
关闭梭门闩 1 并重新合上旋梭盖。

Removing the bobbin case :
Open the post cap ;
Raise latch 1 and remove bobbin case 2 .
Inserting the bobbin case :
Insert bobbin case 2 ;
Close the latch 1 and close the post cap .



4.04 梭壳穿线/调节梭芯线的张力

Threading the bobbin case/Adjusting the bobbin thread tension

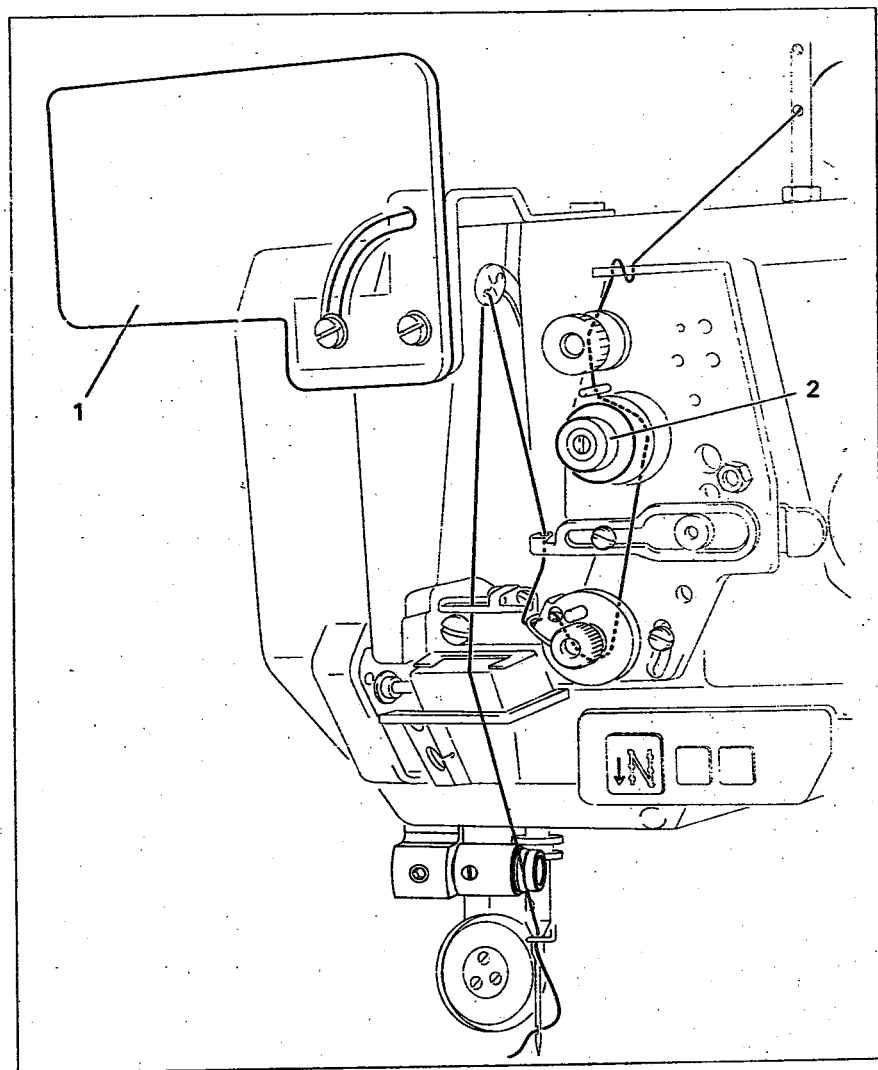


将梭芯装入梭壳 1 中；
将线穿过弹性压板 2 下的狭槽中；
将线穿过凹口处；
通过旋动螺钉 3 调节梭芯线张力。

Insert the bobbin into the bobbin case ;
Pass the thread through the slot under spring 2 ;
Pass the thread through the notch;
Adjust the thread tension by turning screw 3 .

4.05 单针机型上穿针线并调整针线张力

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



向上摆动护眼罩 1;

如图所示穿针线;

在左旋梭机型上, 针线是从右向左穿; 而在右旋梭机型上, 针线是从左向右穿;
通过转动滚花螺母 2 调节针线的张力。

Tilt up the eye guard 1 ;

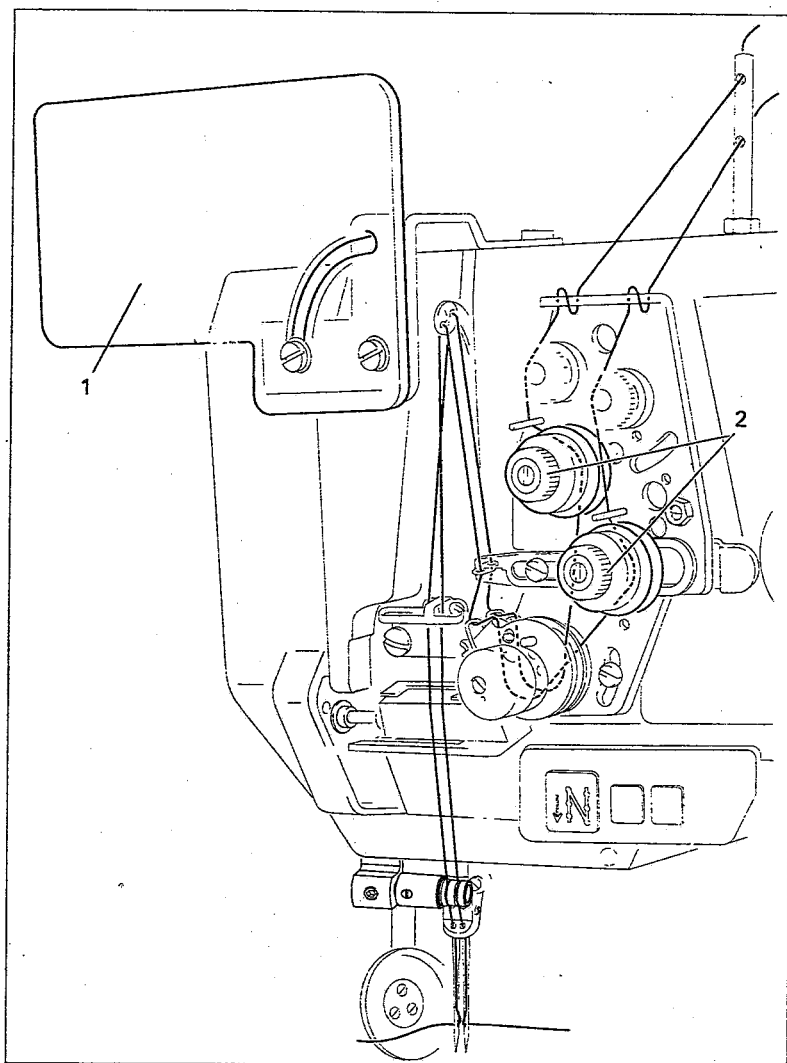
Thread the needle thread as shown in Fig. ;

On model left hook the needle is threaded from the right to the left ,and on model right hook from the left to the right;

Adjust the needle thread tension by turning milled nut 2 .

4.06 双针机型上穿针线并调整针线张力

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



向上摆动护眼罩 1;

如图所示穿两个针线;

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

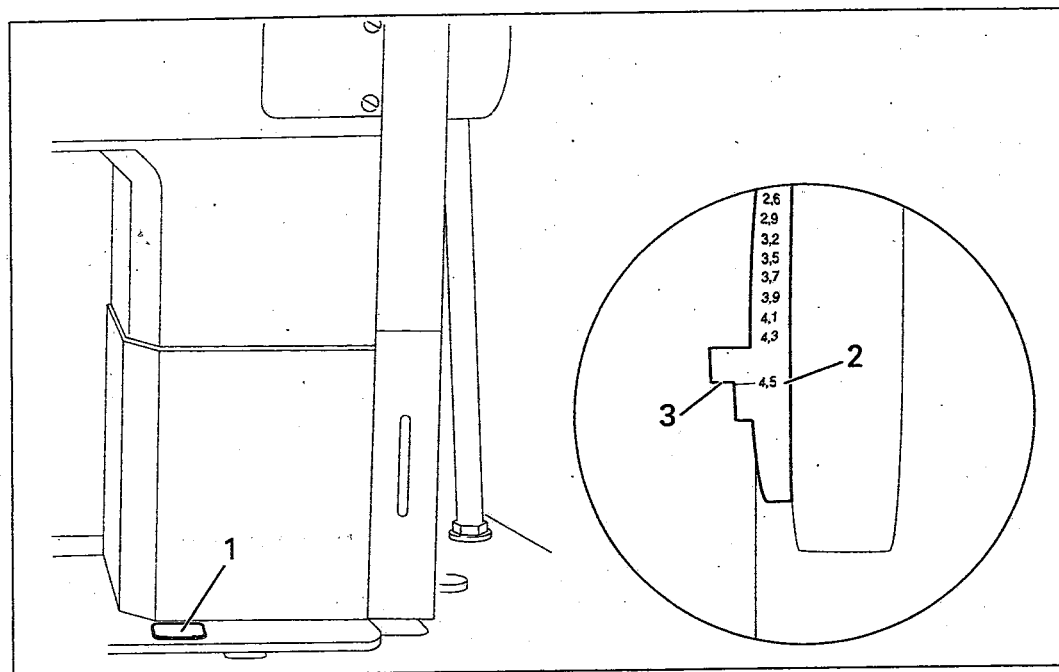
Tilt up the eye guard 1 ;

Thread the needle thread as shown in Fig. ;

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

Adjust the needle thread tension by turning milled nut 2 .

4.07 设置线迹长度 Setting the stitch length



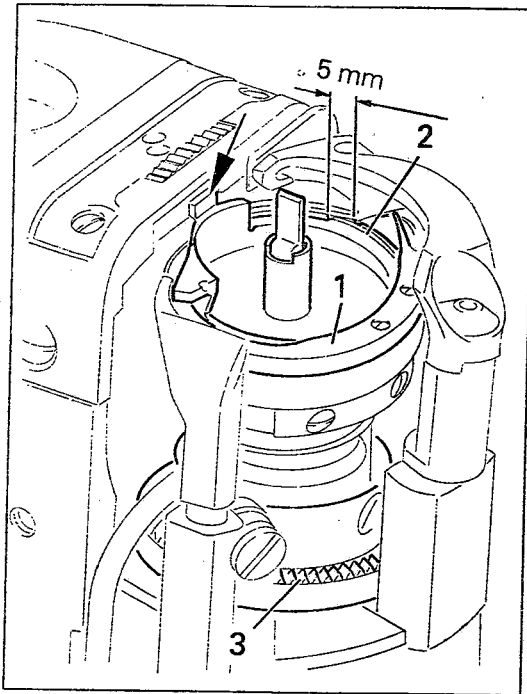
按下键 1 并同时转动手轮直到线迹调节器吻合嵌入定位位置；
保持按下键 1 并来回地转动手轮，直到在刻度盘 2 上所需要设置的线迹长度数字
与皮带护罩凹槽的下边缘 3 处对齐。

Press key 1 and at the same time turn the balance wheel until the stitch setter clicks
into position ;
Hold down key 1 and turn the balance wheel to and fro until the stitch length
required is shown on the scale 2 opposite the bottom edge 3 of the belt guard
recess .

5. 维护与保养 Care and maintenance

清洁.....	每天，如果持续运转时，每天多次
油量检查（线润滑/旋梭润滑）.....	每天，开机之前
给旋梭加油.....	每天，开机之前
伞齿轮副润滑.....	每年一次
检查/调节空气压力.....	每天，开机之前
清洁空气滤清器/润滑器的过滤网.....	在需要时
Clean.....	daily , more frequently if in continuous operation
Oil level (thread lubrication/hook lubrication).....	daily , before use
Oil the hook.....	daily , before use
Lubricate the level gears.....	once a year
Check/adjust air pressure.....	daily , before use
Clean air filter of air filter/lubricator.....	when required

5.01. 清洁 Cleaning



每天清洁旋梭，旋梭腔和齿轮 3，如果持续运行时，每天清洁多次。

Clean the hook ,hook compartment and toothed wheel 3 every day , several times if in continuous use .

关闭机器电源；

将针杆升到最高位置；

打开旋梭盖，取出梭壳和梭芯；

拧松内梭头舌 1 的螺钉；

转动手轮，直到梭壳 2 的尖端进入旋梭的导槽内大约 5mm；

取出梭壳 2；

用石蜡清洁旋梭槽；

当放入梭壳 2 时，要确信梭壳 2 的凸出鼻端部分啮合入针板的凹槽中；

拧紧内梭头舌 1 的螺钉并盖上旋梭盖。

Bring the needle bar to its highest position ;

Open the post cap and remove the bobbin case cap and the bobbin ;

Unscrew hook gib 1 ;

Turn the hand wheel until the point of bobbin case 2 penetrates into the groove of the hook race approx.5mm ;

Remove bobbin case 2 ;

Clean the hook race with paraffin ;

When inserting the bobbin case 2 , ensure that the horn of the bobbin case 2 engages in the groove of the needle plate ;

Screw hook gib 1 back on and close the post cap .

5.02 给旋梭加油 Oiling the hook

关闭机器电源；

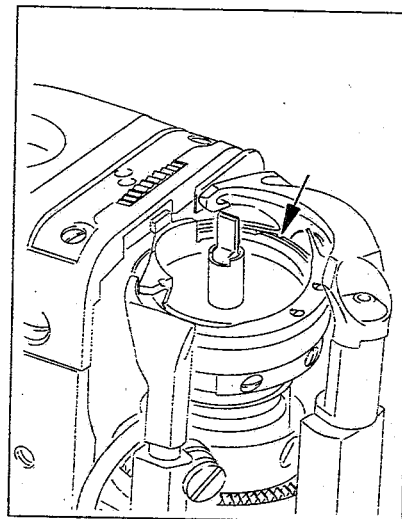
每天注 1-2 滴油到内梭头舌的孔 1 中；

在机器试车前及在长期停机后，注入几滴油到旋梭的槽中（参见箭头所示）。

Switch the machine off ;

Pour 1-2 drops of oil into hole 1 of the hook gib daily ;

Before commissioning the machine , and after long periods out of operation , pour a few drops of oil into the hook race (see arrow) .



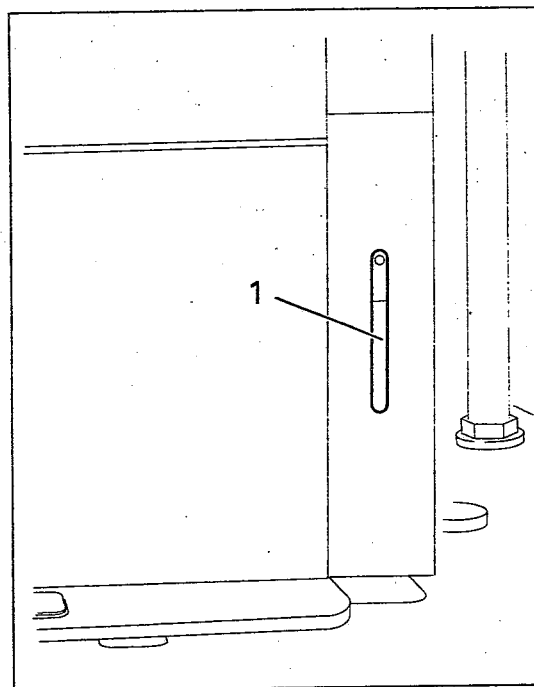
5.03 旋梭润滑油盒 Oil bowl for hook lubrication

在每次开机前检查油量，必须始终保持油盒1中有油。如果需要可通过加油孔加油。

只允许使用在 40℃时平均粘度为 22.0mm²/s 和在 15℃时密度为 0.865g/cm³ 的润滑油。

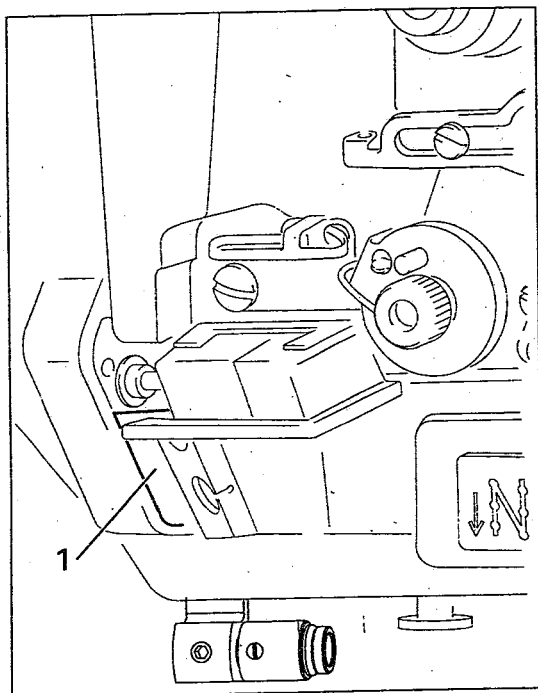
Check the oil level before each use ,there must always be oil in reservoir 1 .If required refill oil through hole.

Use only oil with a mean viscosity of 22.0mm²/s at 40℃ and a density of 0.865 g/cm³ at 15℃



5.04 给线润滑系统的油盒加油

Filling the oil reservoir of the thread lubrication unit



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

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

5.05 给伞齿轮副润滑 Lubricating the bevel gears

关闭机器电源！

所有伞齿轮副每年必须加一次新油脂。

向后翻转机头到支撑件上。

Switch the machine off !

All bevel gears must be supplied with new grease once a year.

Tilt the sewing head back onto the support.

如图所示双针机型的伞齿轮副。

涂油脂到齿轮的全部齿侧面（见箭头所示）。

在将机头放回垂直位置时，先向后按翻转保险 1，并用双手将机头放回垂直位置。

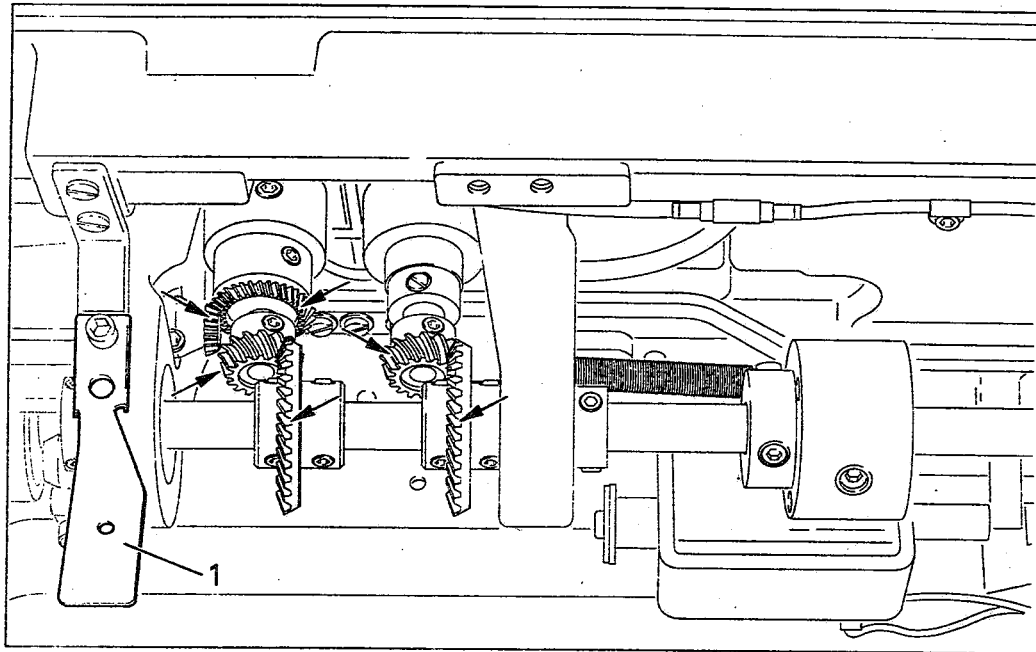
Fig. shows the bevel gears of the double needle machine .

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

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

我们推荐使用滴点大约为 150° C 含钠油脂。

We recommend sodium grease with a dripping point of approx.150° C .



警告：必须用双手将机头放回垂直位置

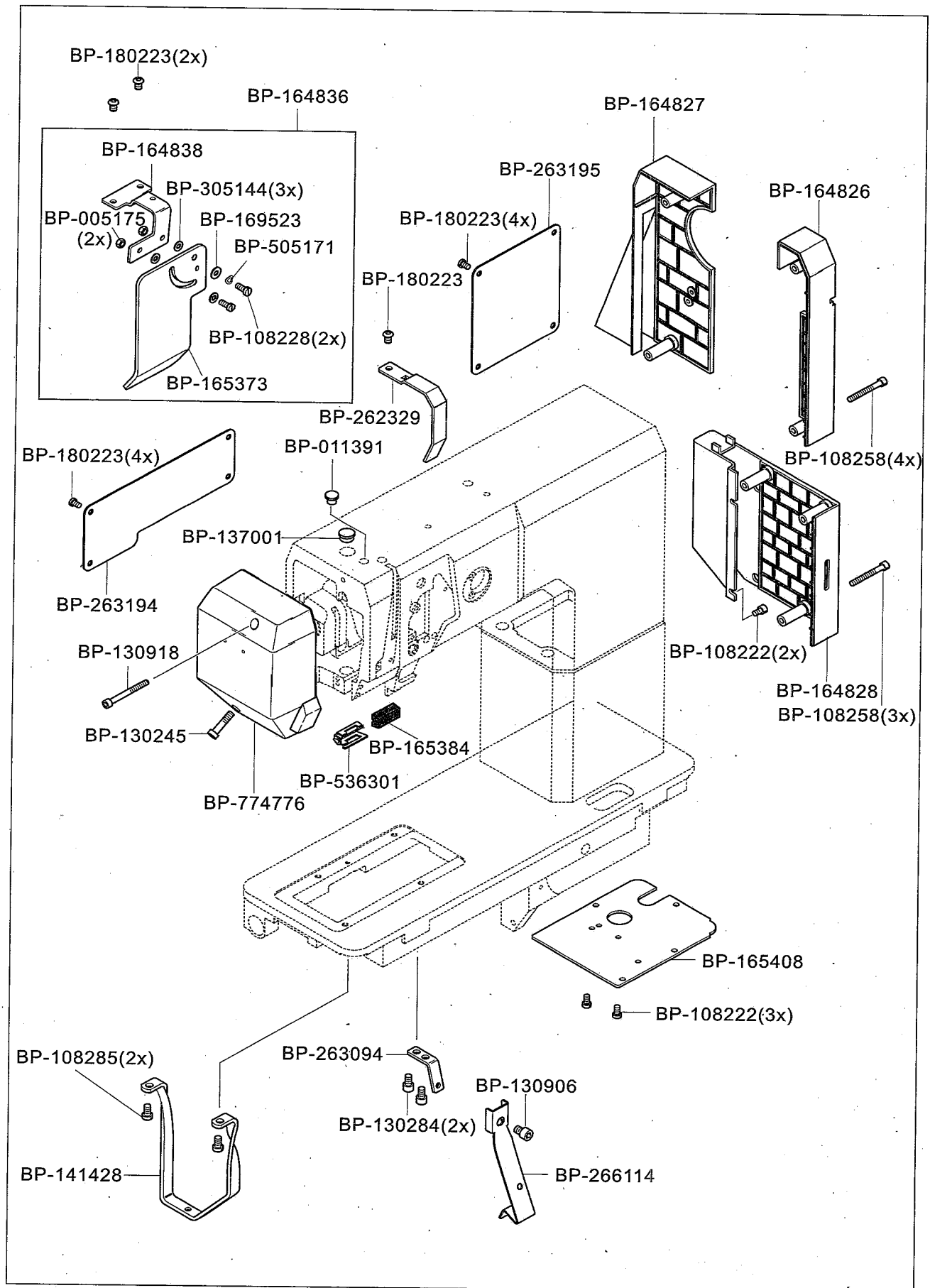
有在机头和台板之间被挤伤的危险！

Warning :Use both hands to set the sewing head upright .

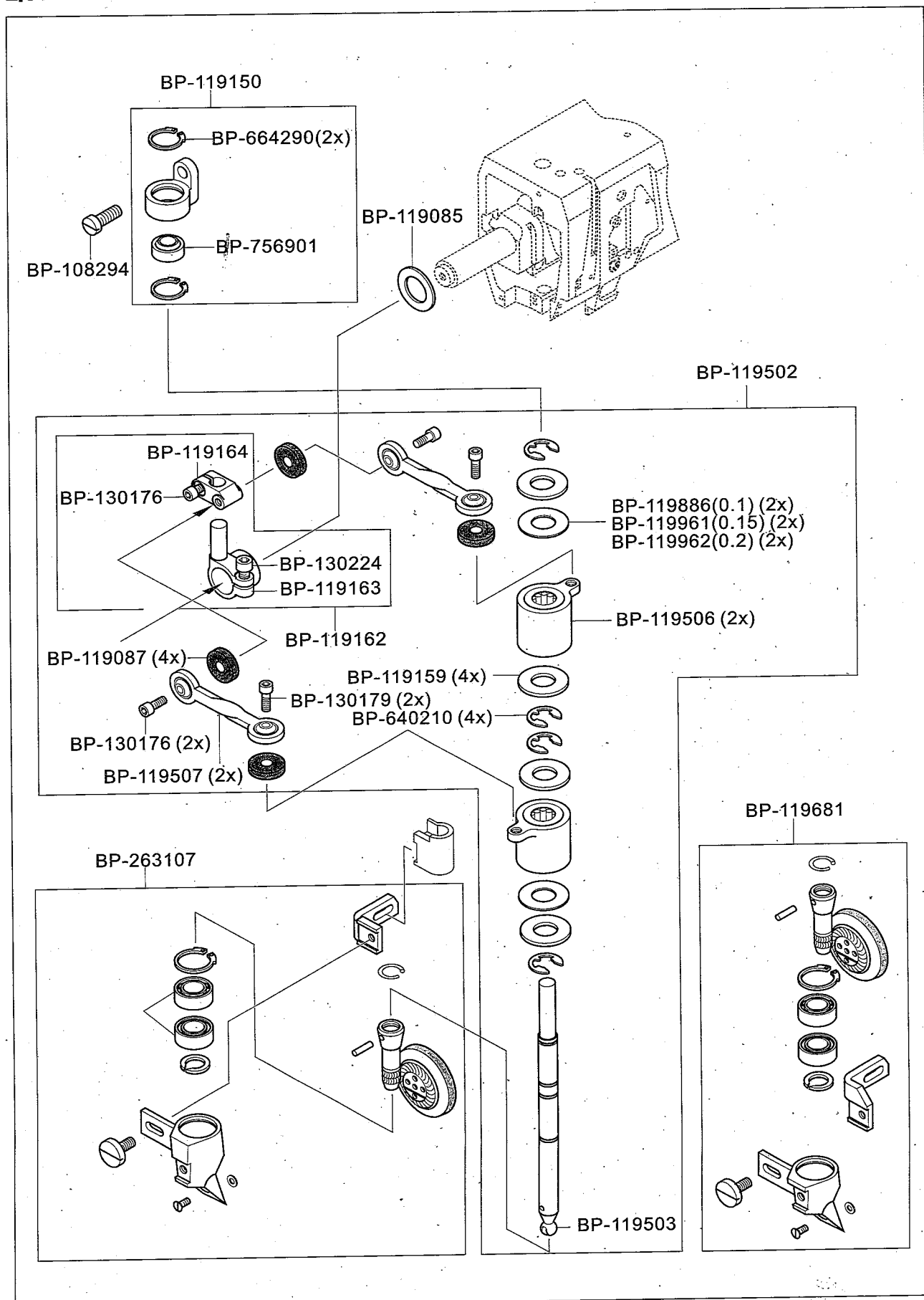
Danger of crushing between the sewing head and the table top !

第二部分
零件图册
PARTS BOOK

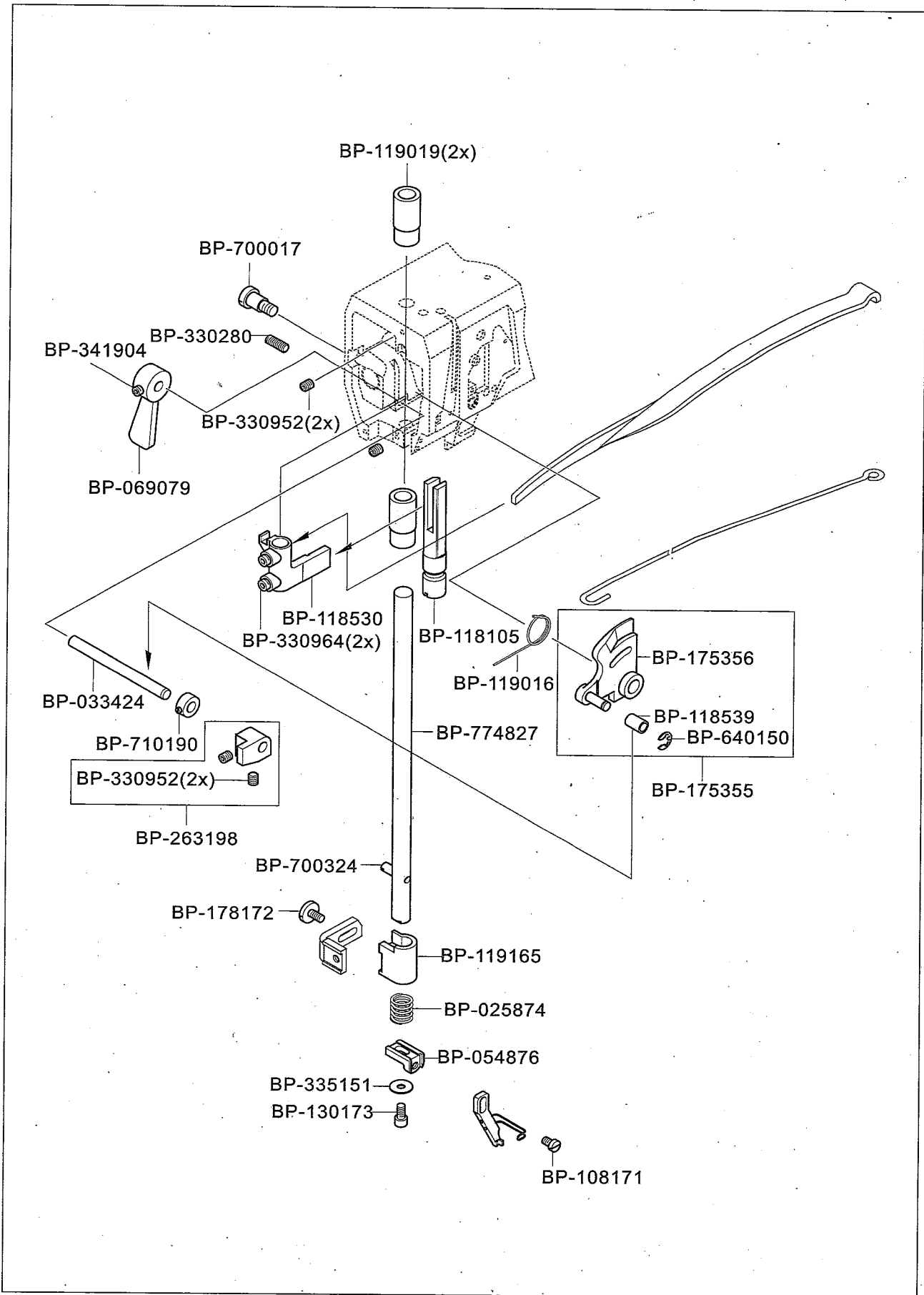
机身零件
1. HOUSING SECTIONS



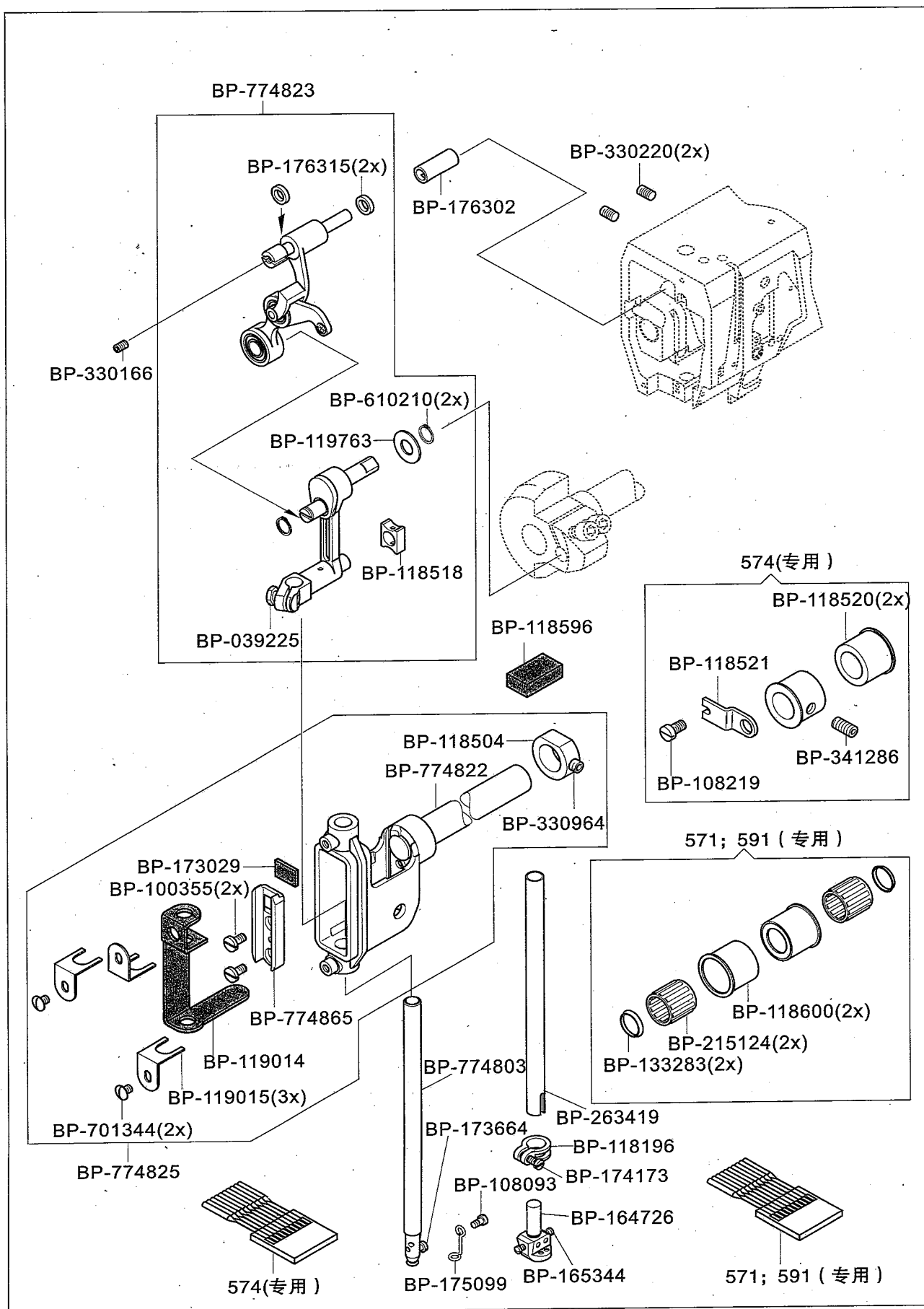
2.01 机头零件
NEEDLE HEAD PARTS



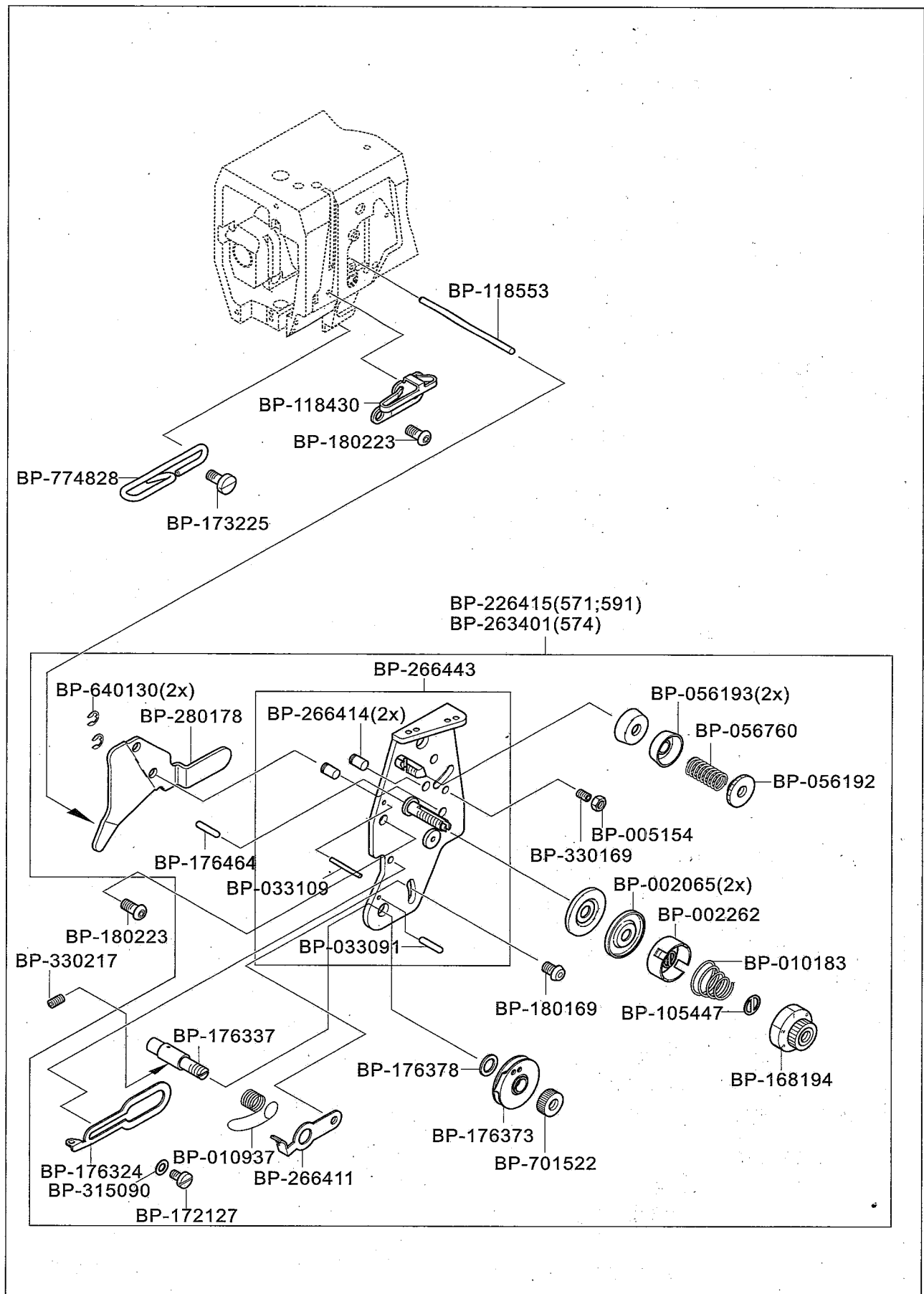
2.02 机头零件
NEEDLE HEAD PARTS



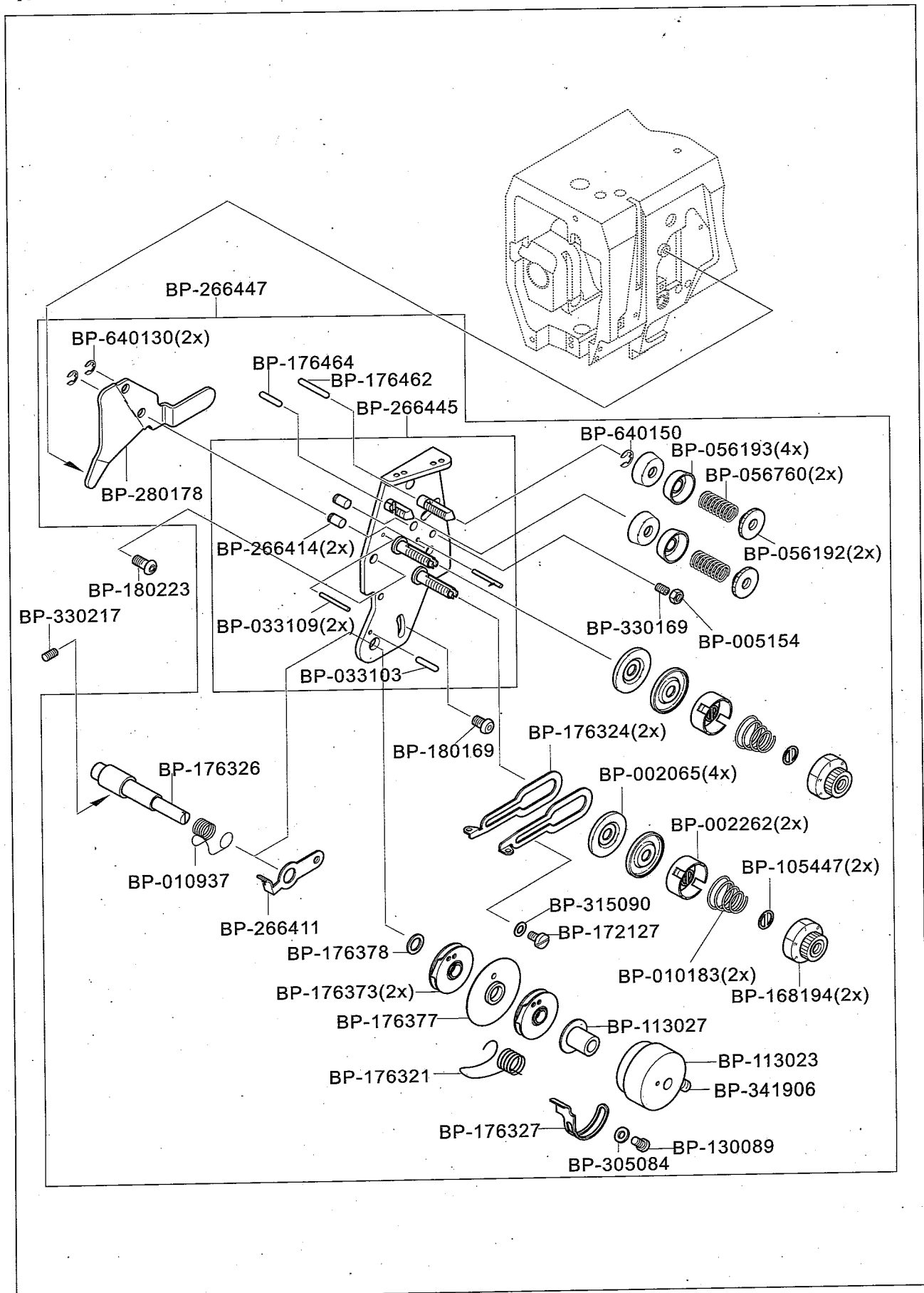
2.03 机头零件
NEEDLE HEAD PARTS



2.04 机头零件
NEEDLE HEAD PARTS



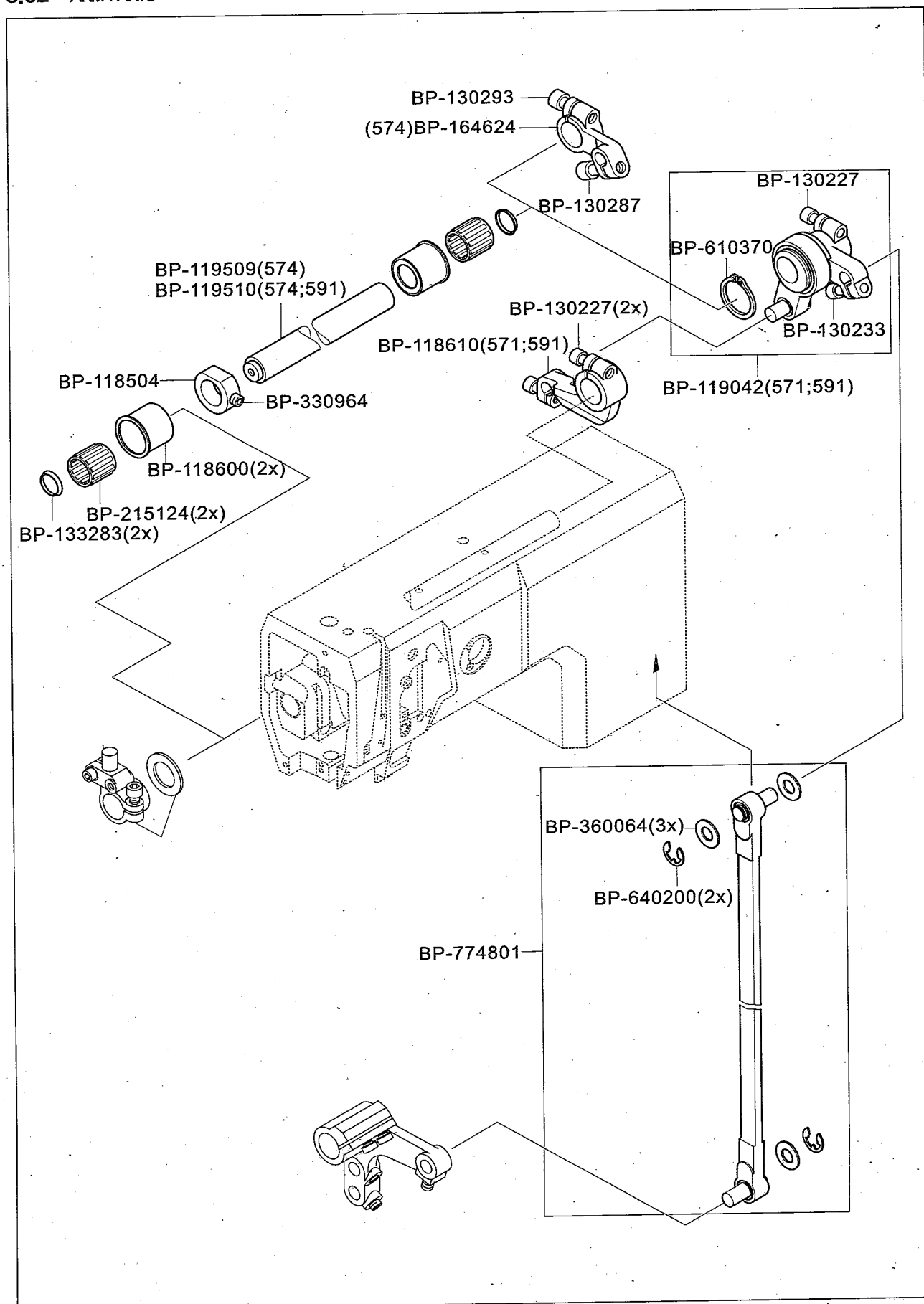
2.05 机头零件
NEEDLE HEAD PARTS



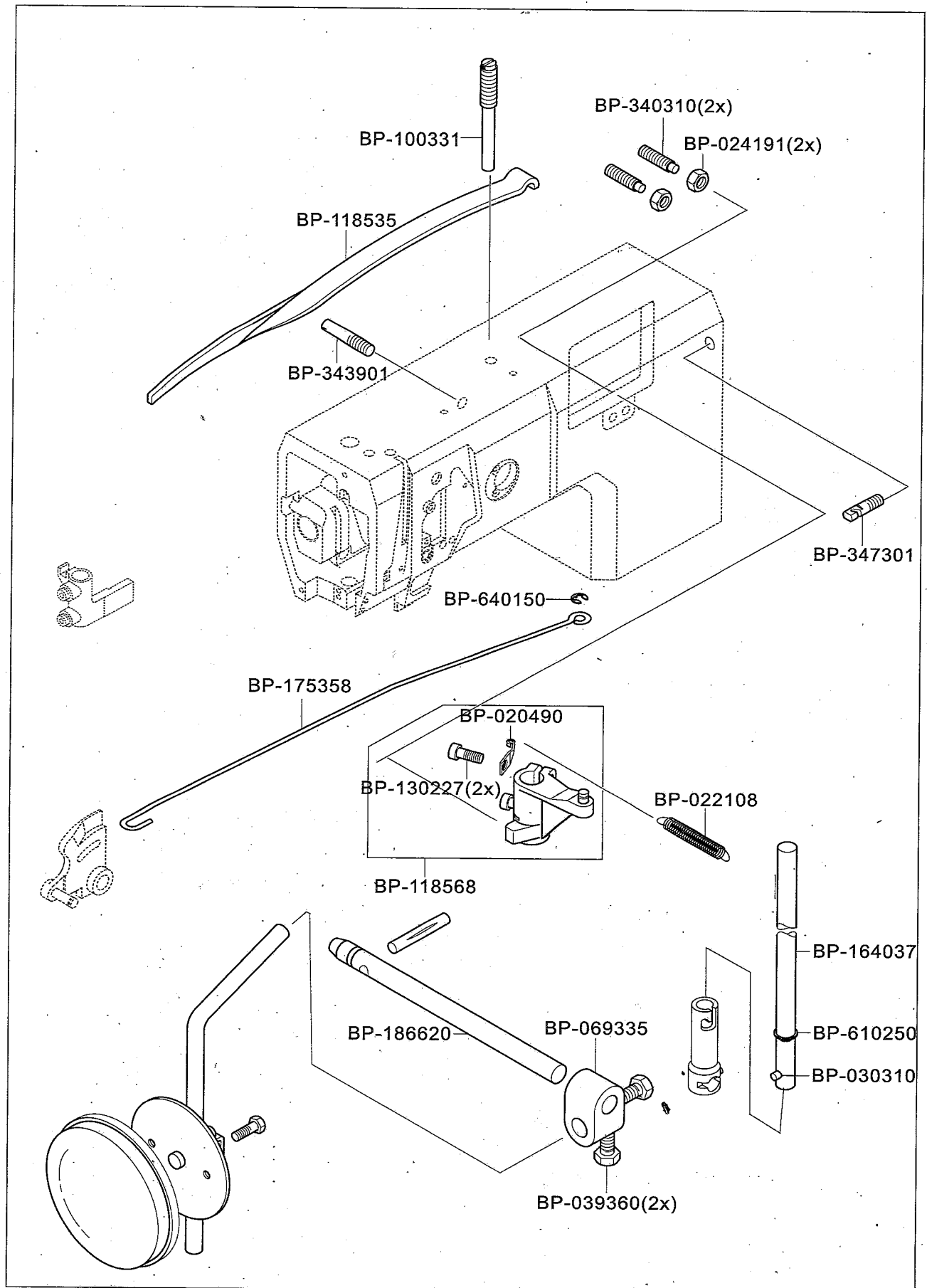
3.01



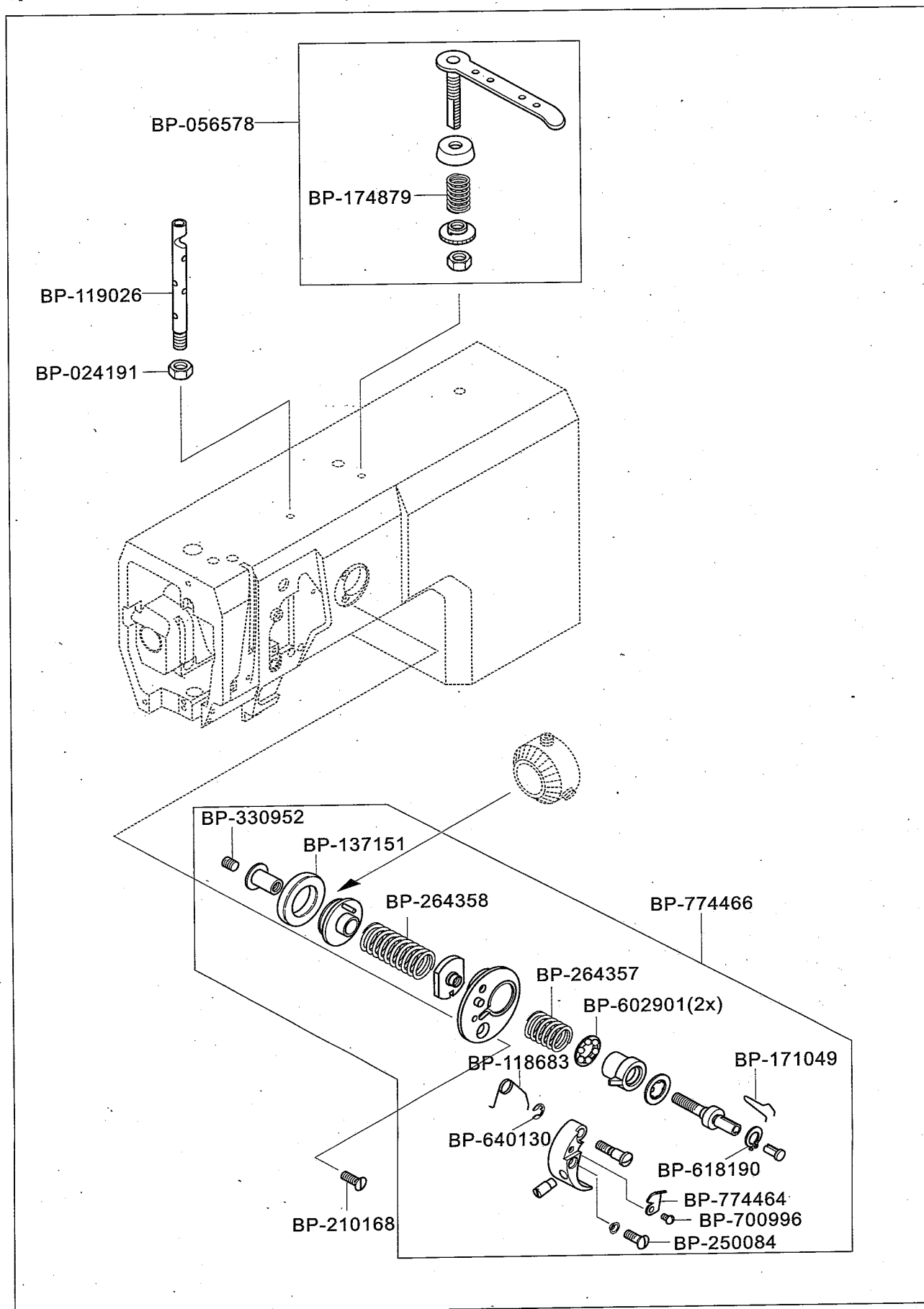
机臂零件
3.02 ARM PARTS



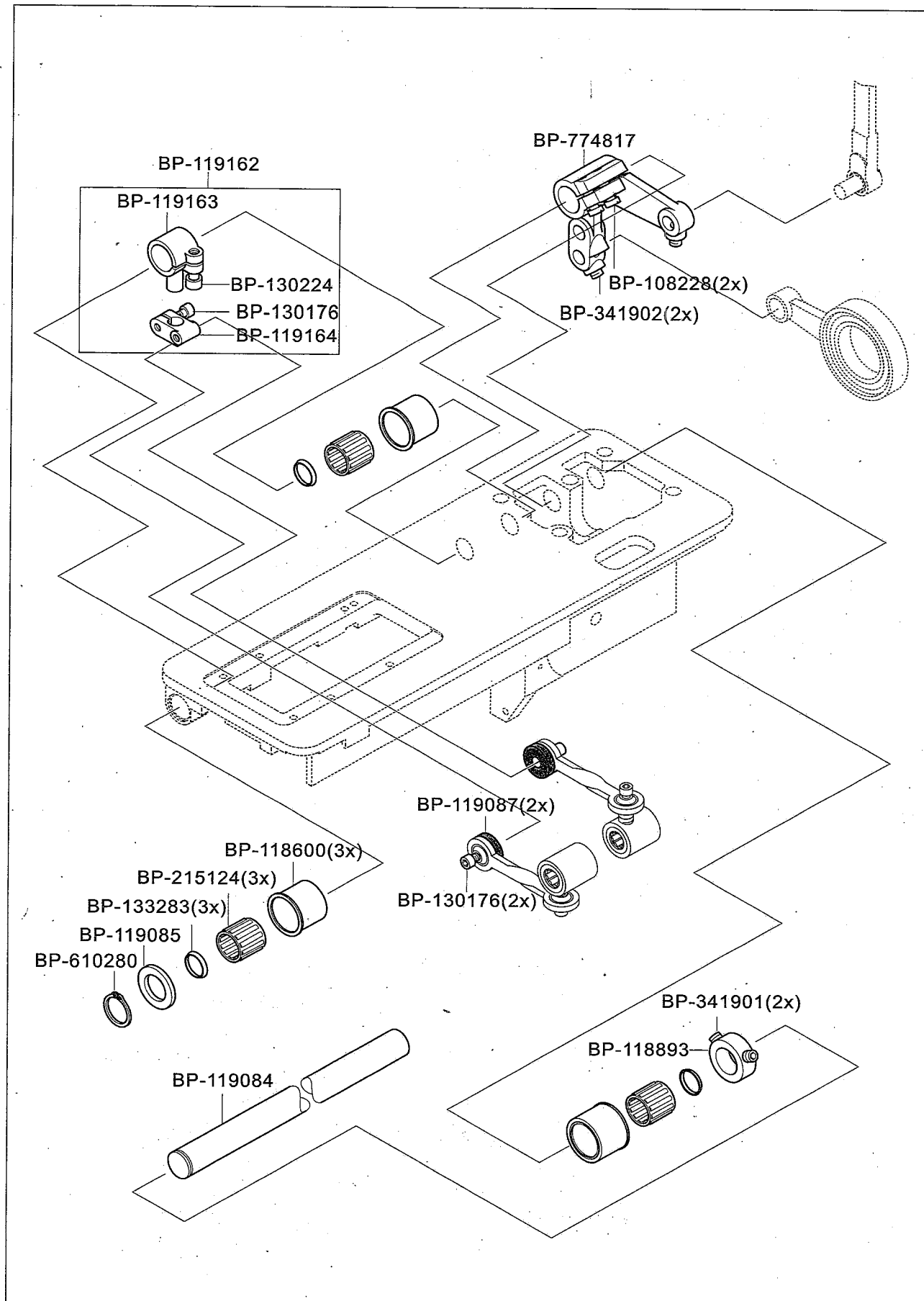
机臂零件
3.03 ARM PARTS



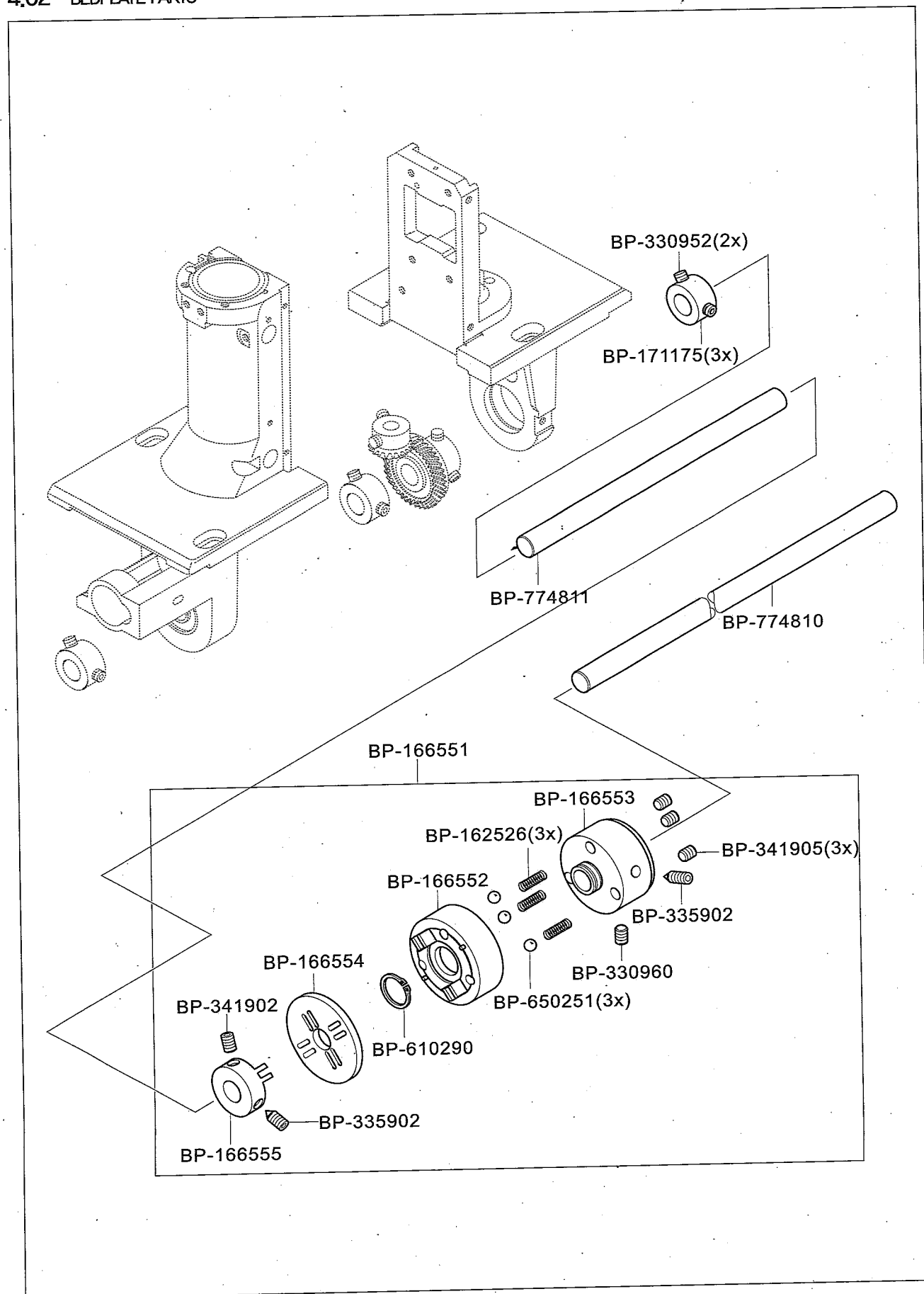
机臂零件
3.04 ARM PARTS



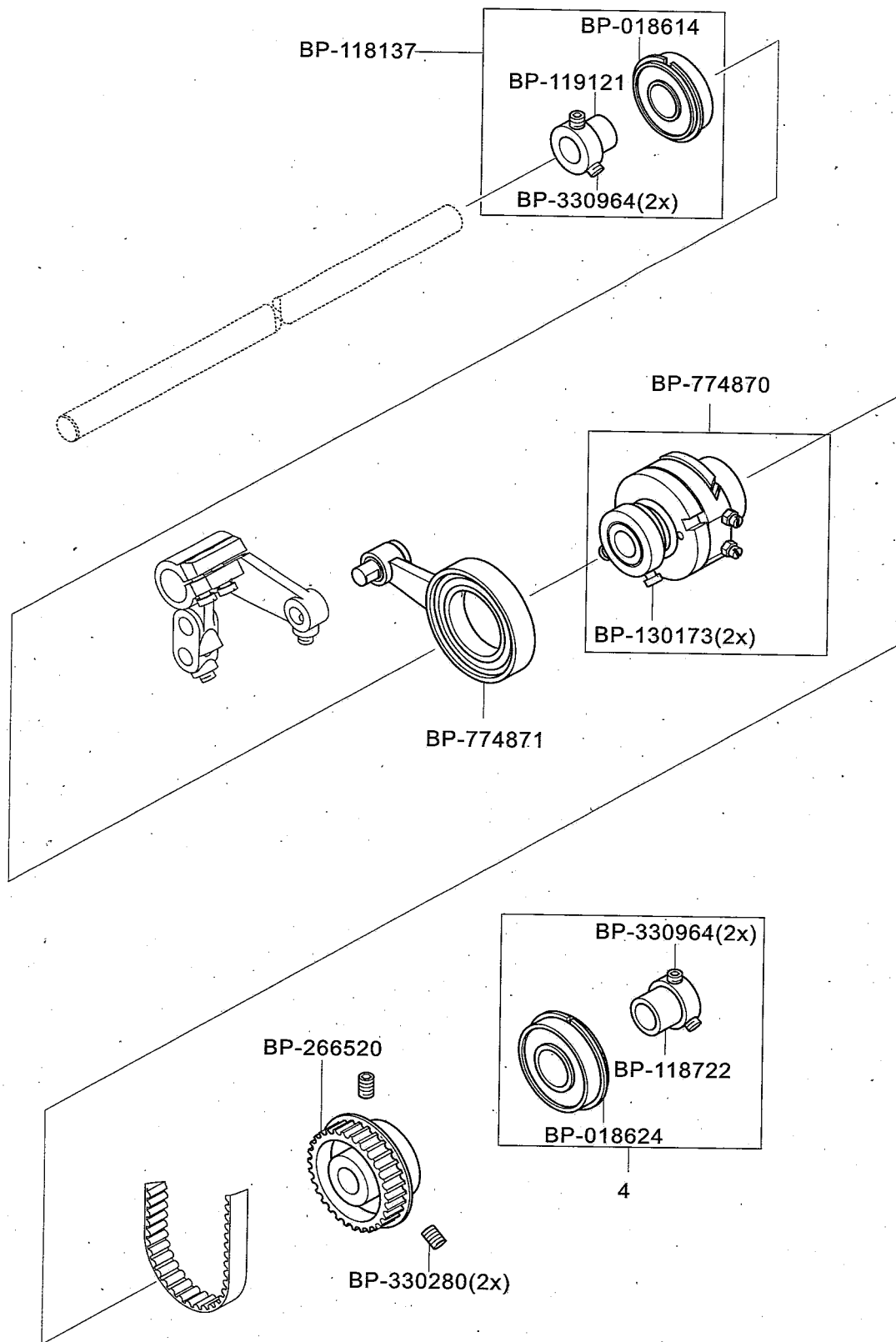
底板零件
4.01 BEDPLATE PARTS



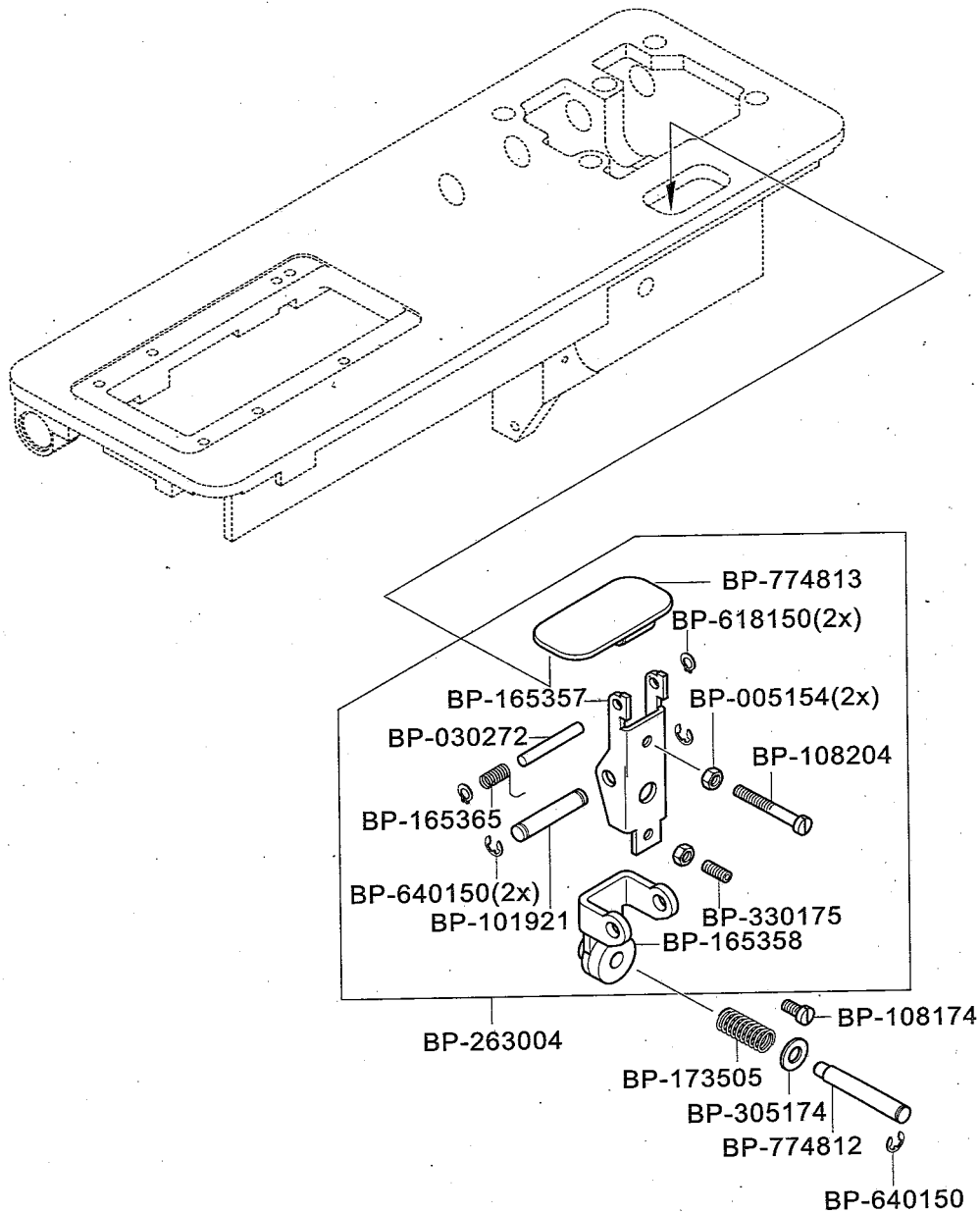
底板零件
4.02 BEDPLATE PARTS

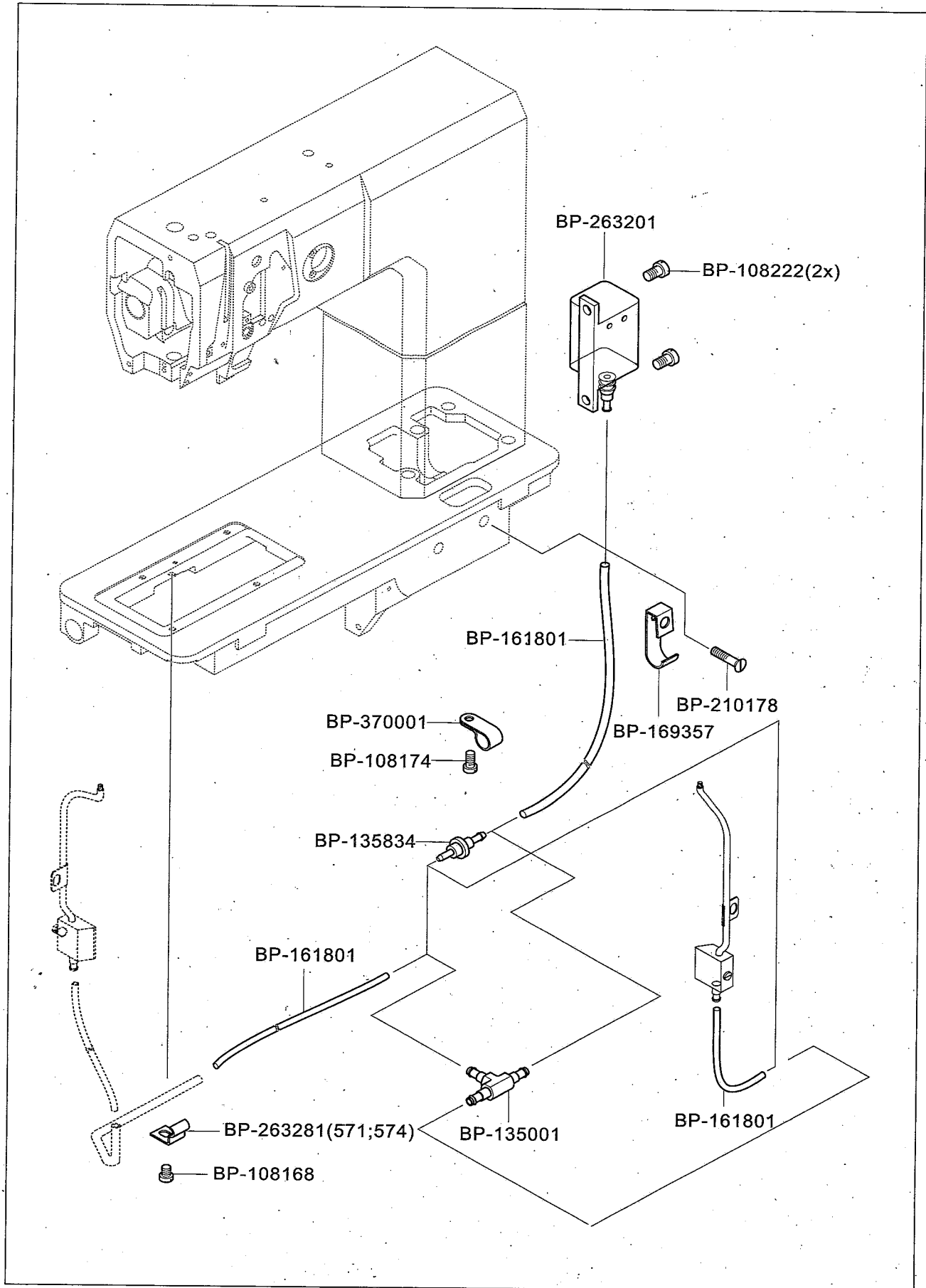


底板零件
4.03 BEDPLATE PARTS

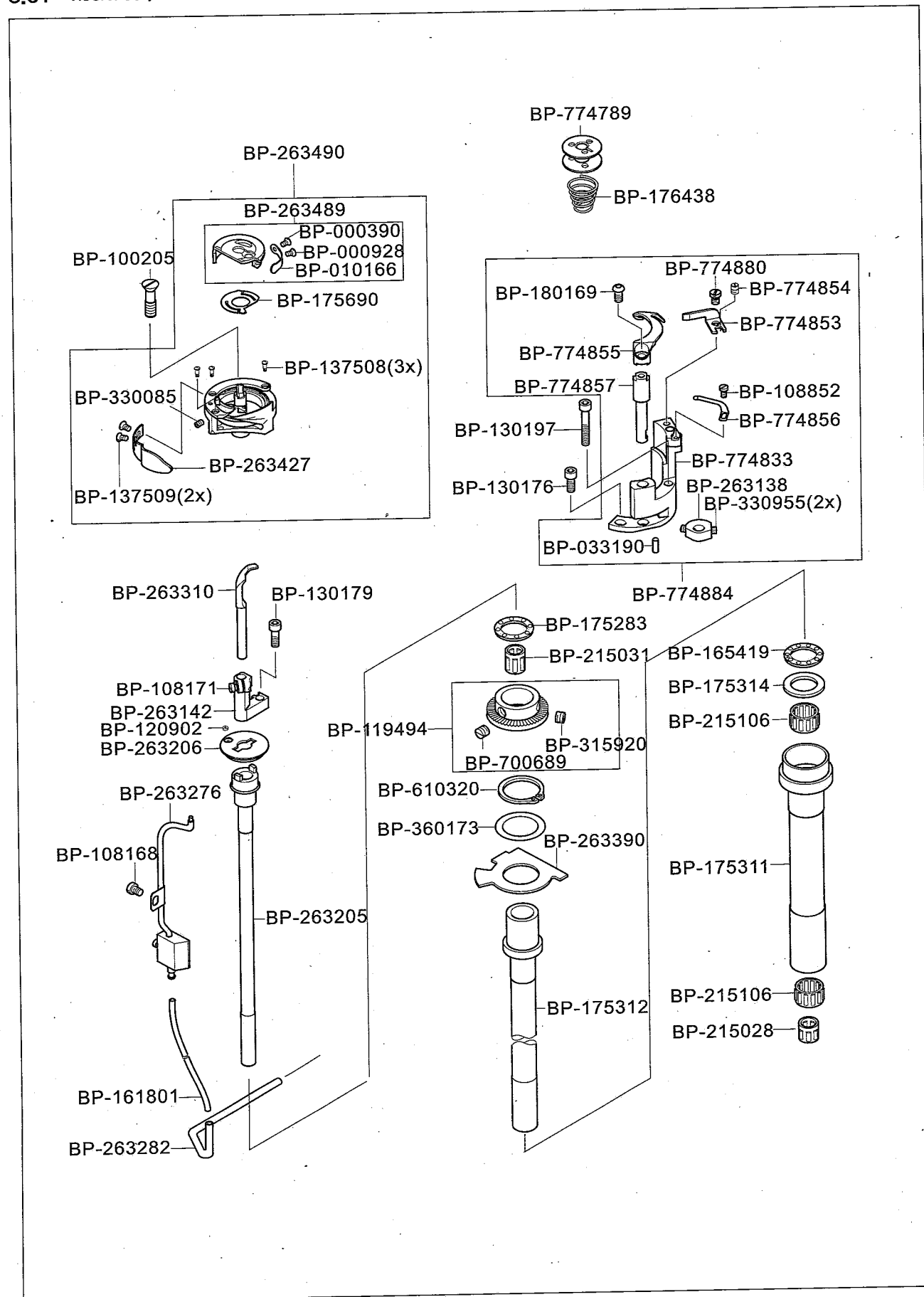


底板零件
4.04 BEDPLATE PARTS

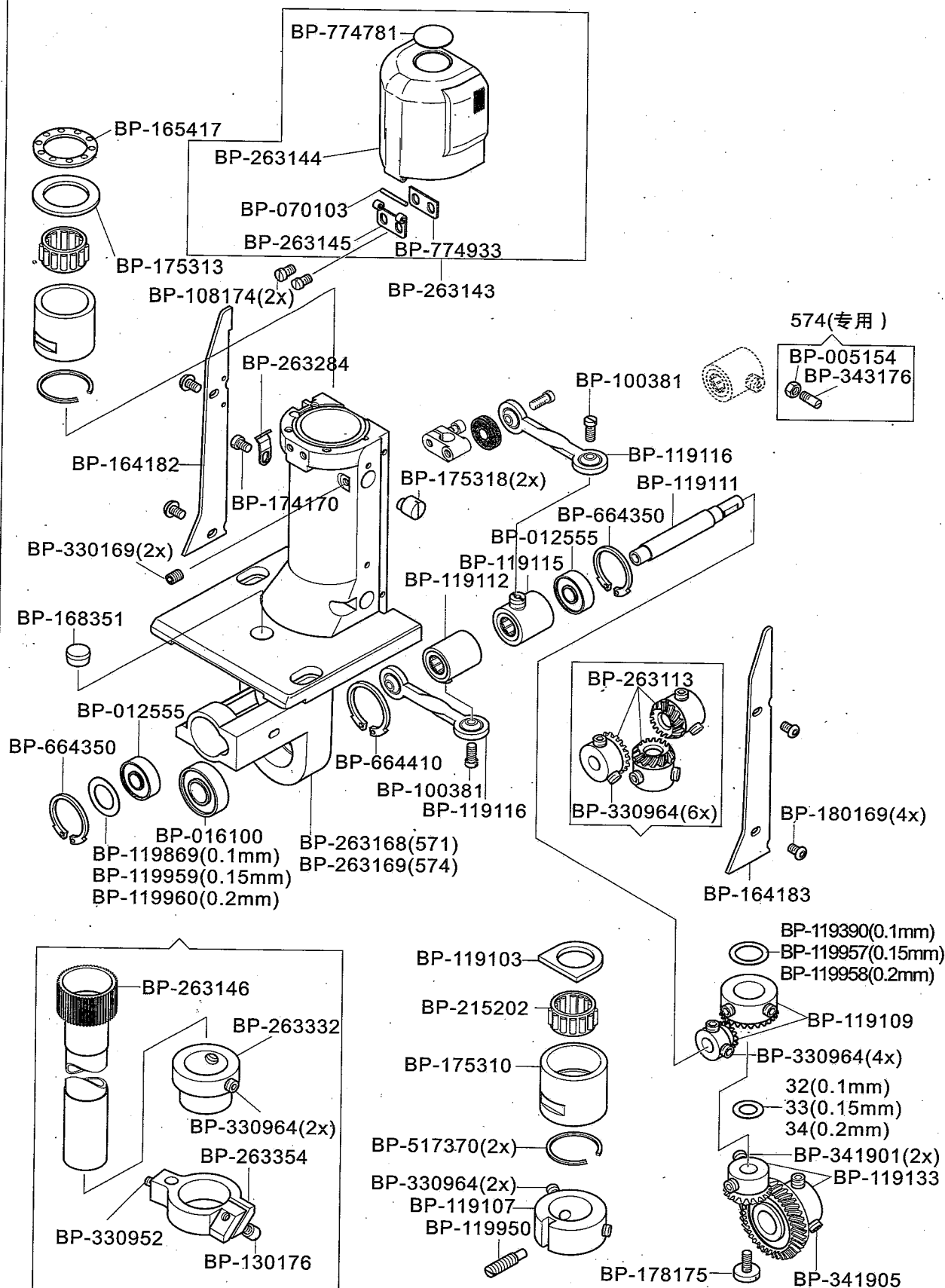




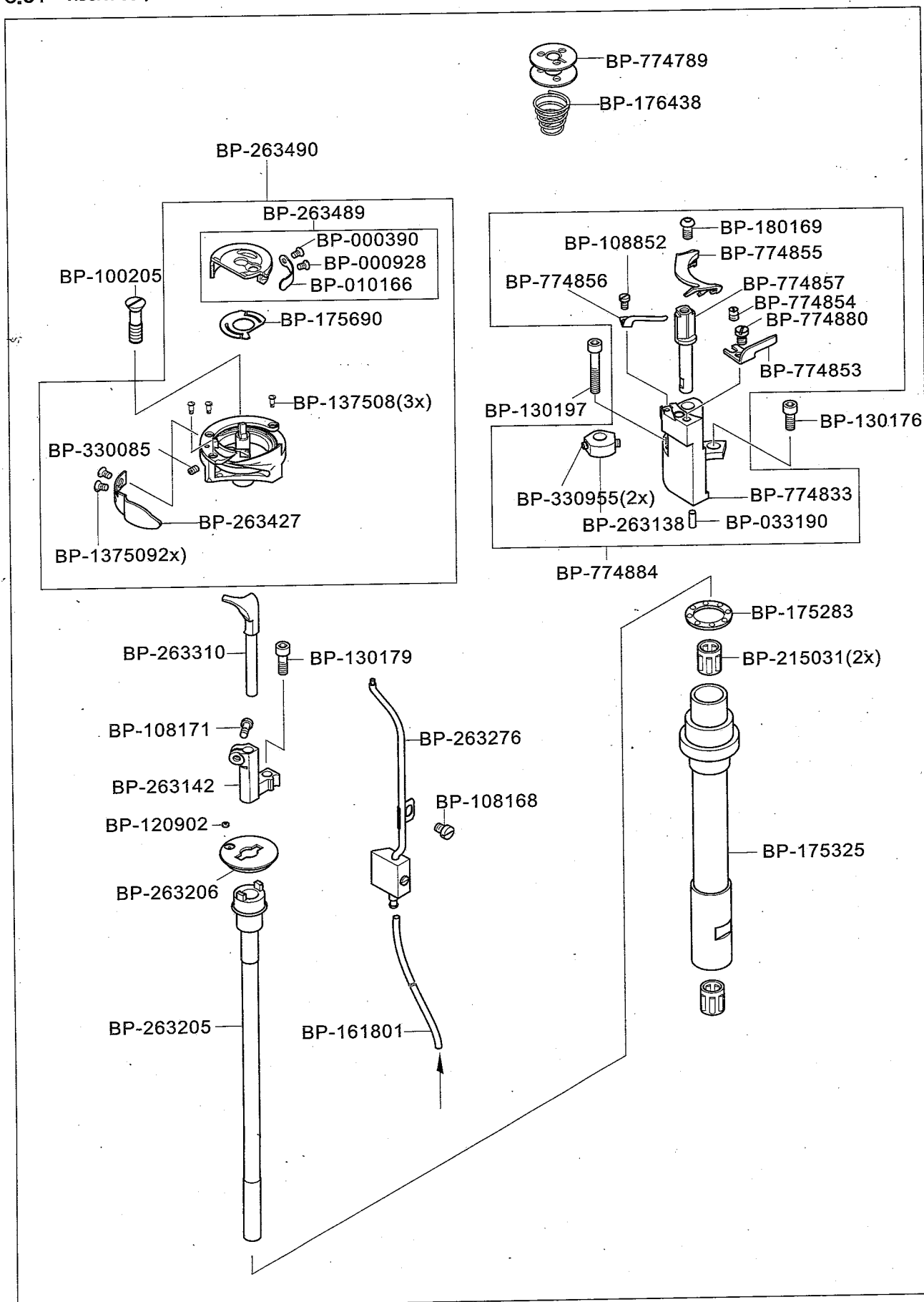
5.01 旋梭柱, 左
HOOK POST, LEFT



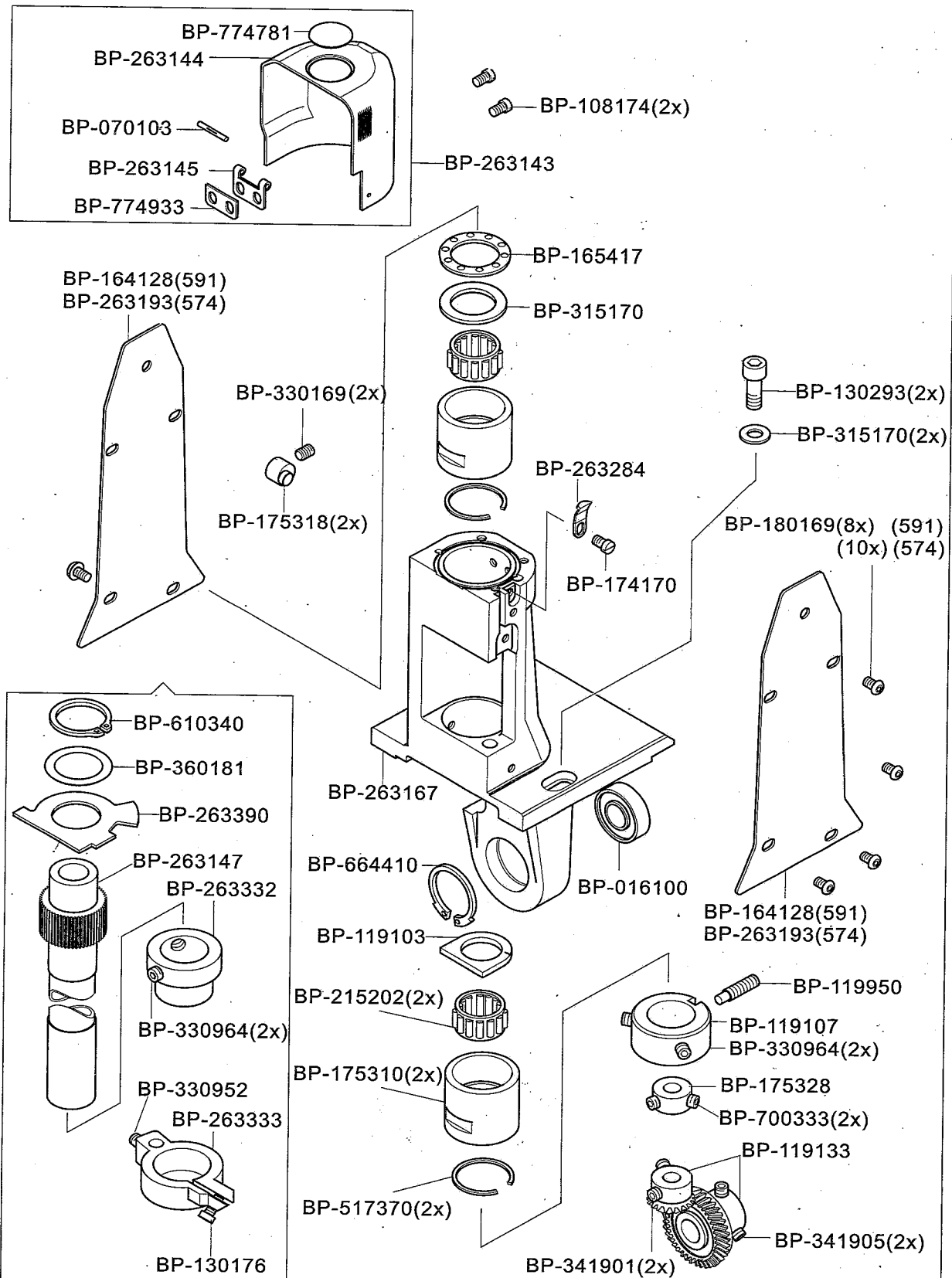
旋梭柱, 左
5.02 HOOK POST, LEFT

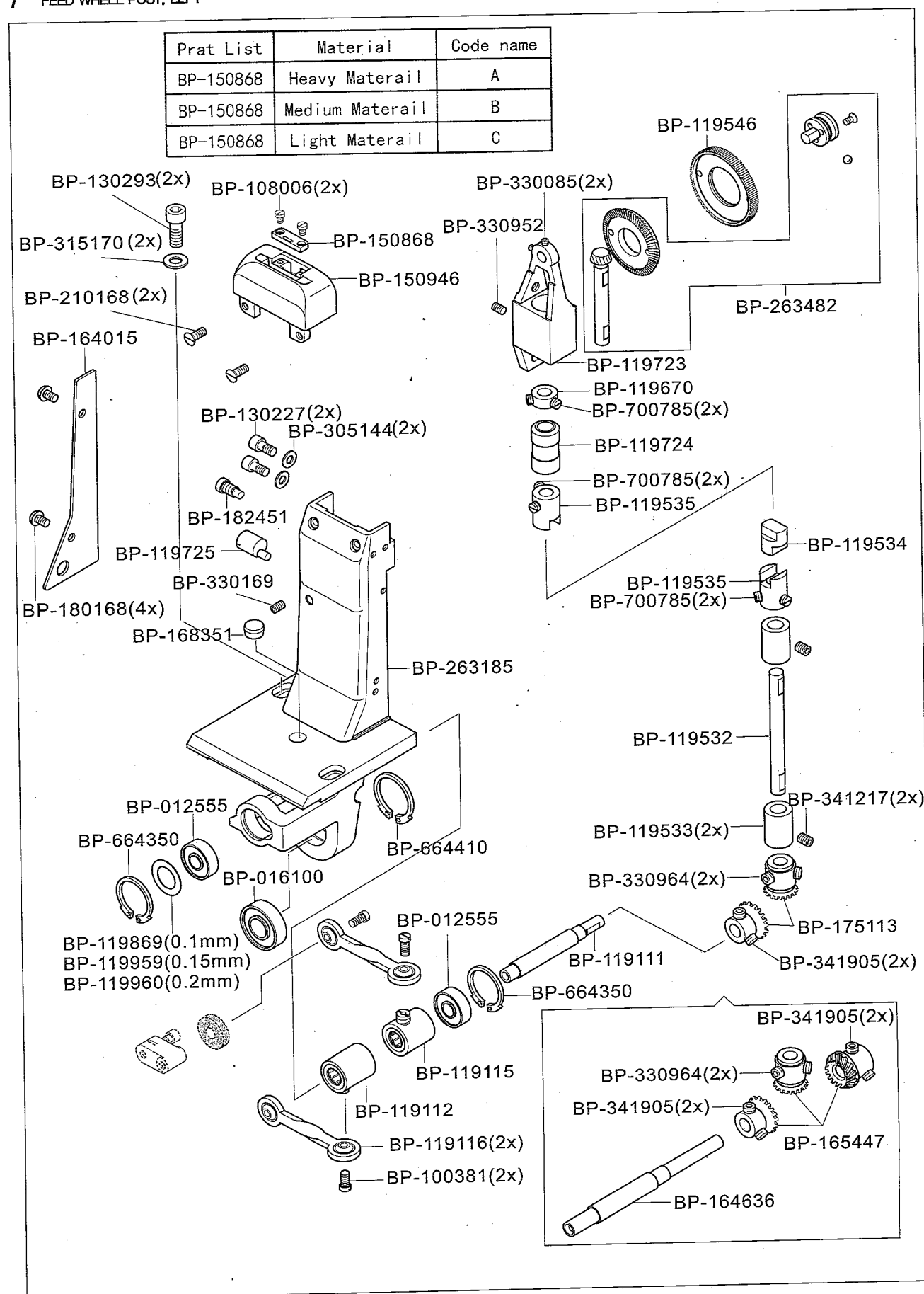


6.01 旋梭柱, 右
HOOK POST, RIGHT

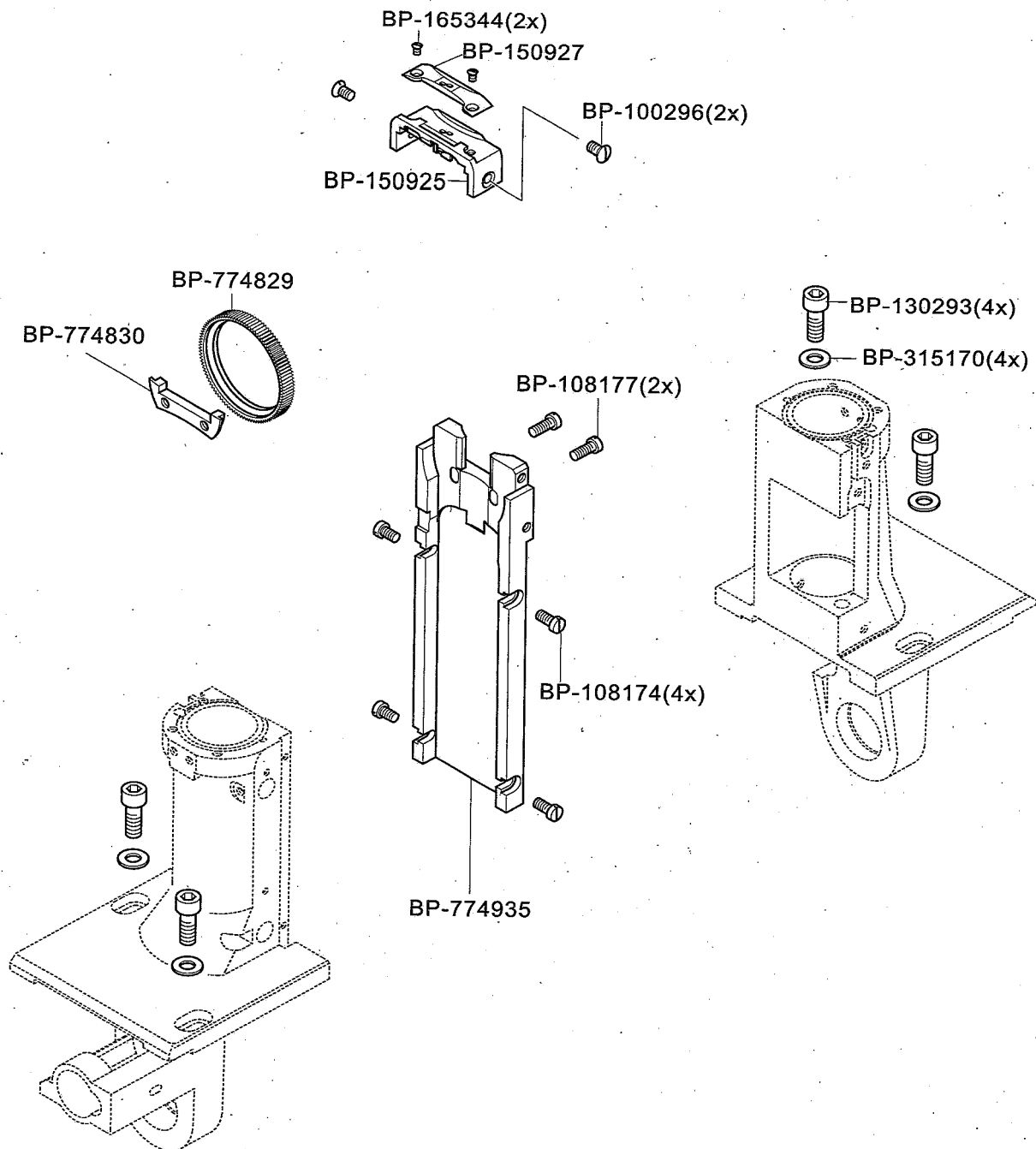


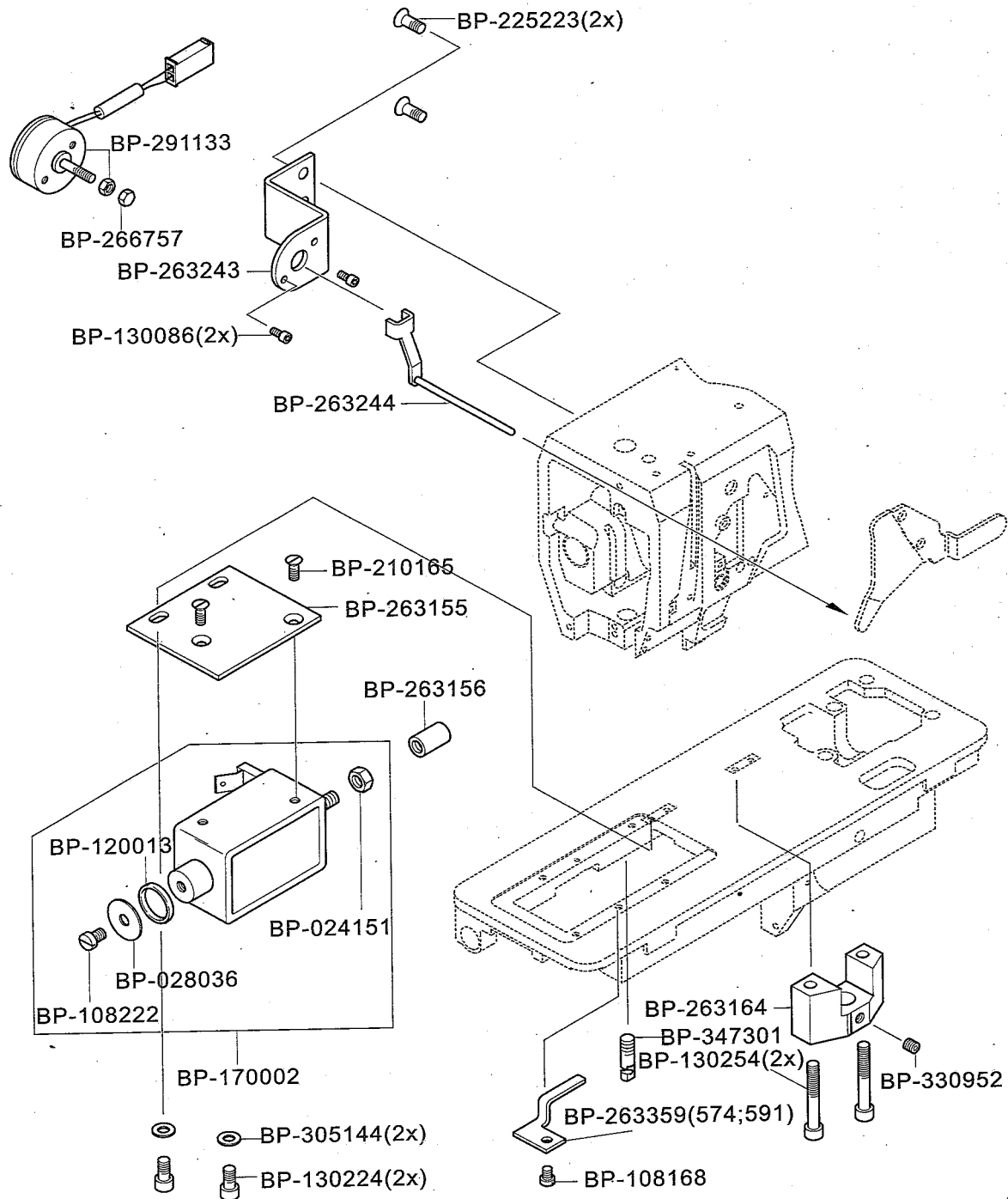
6.02 旋梭柱, 右
HOOK POST, RIGHT



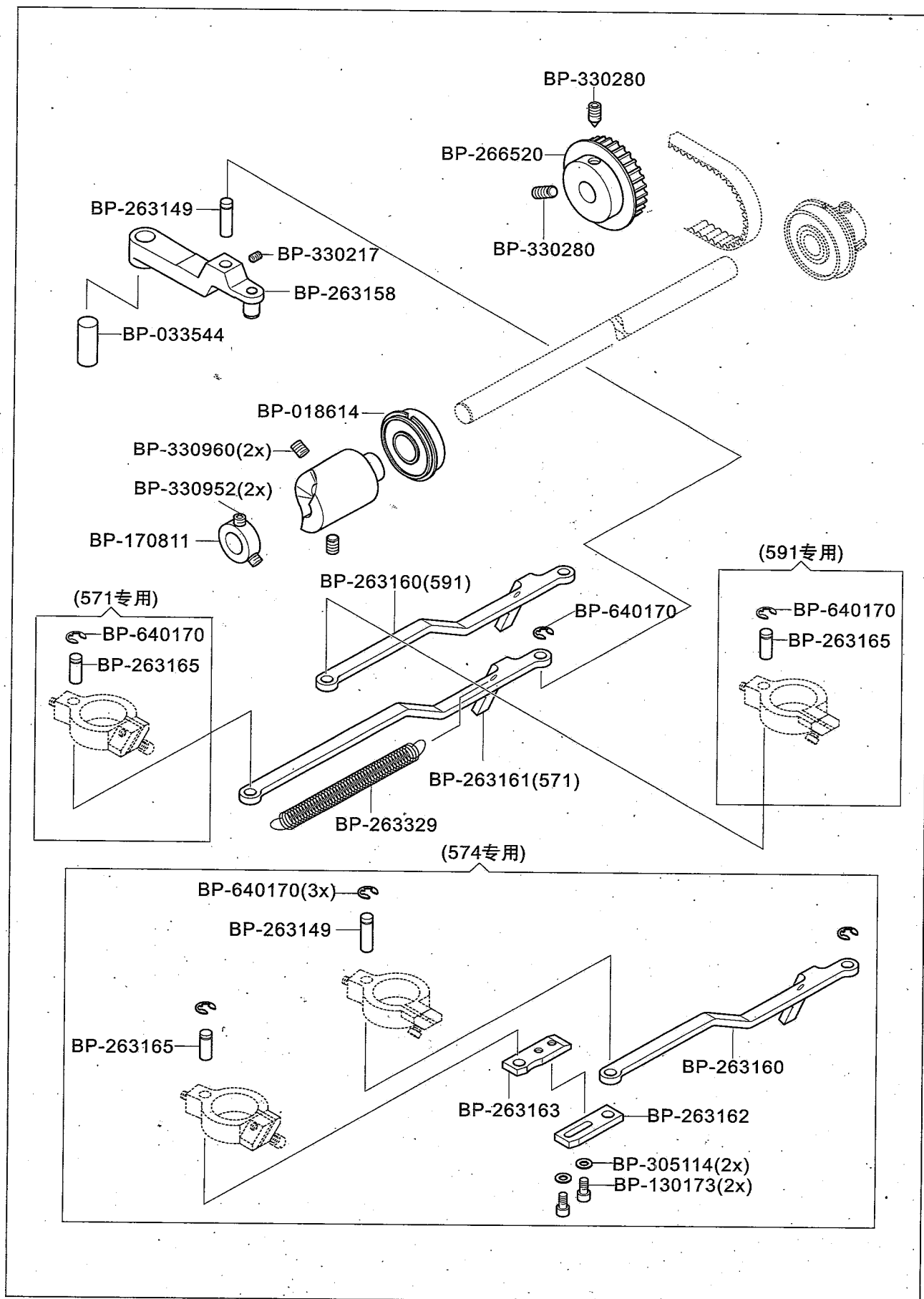


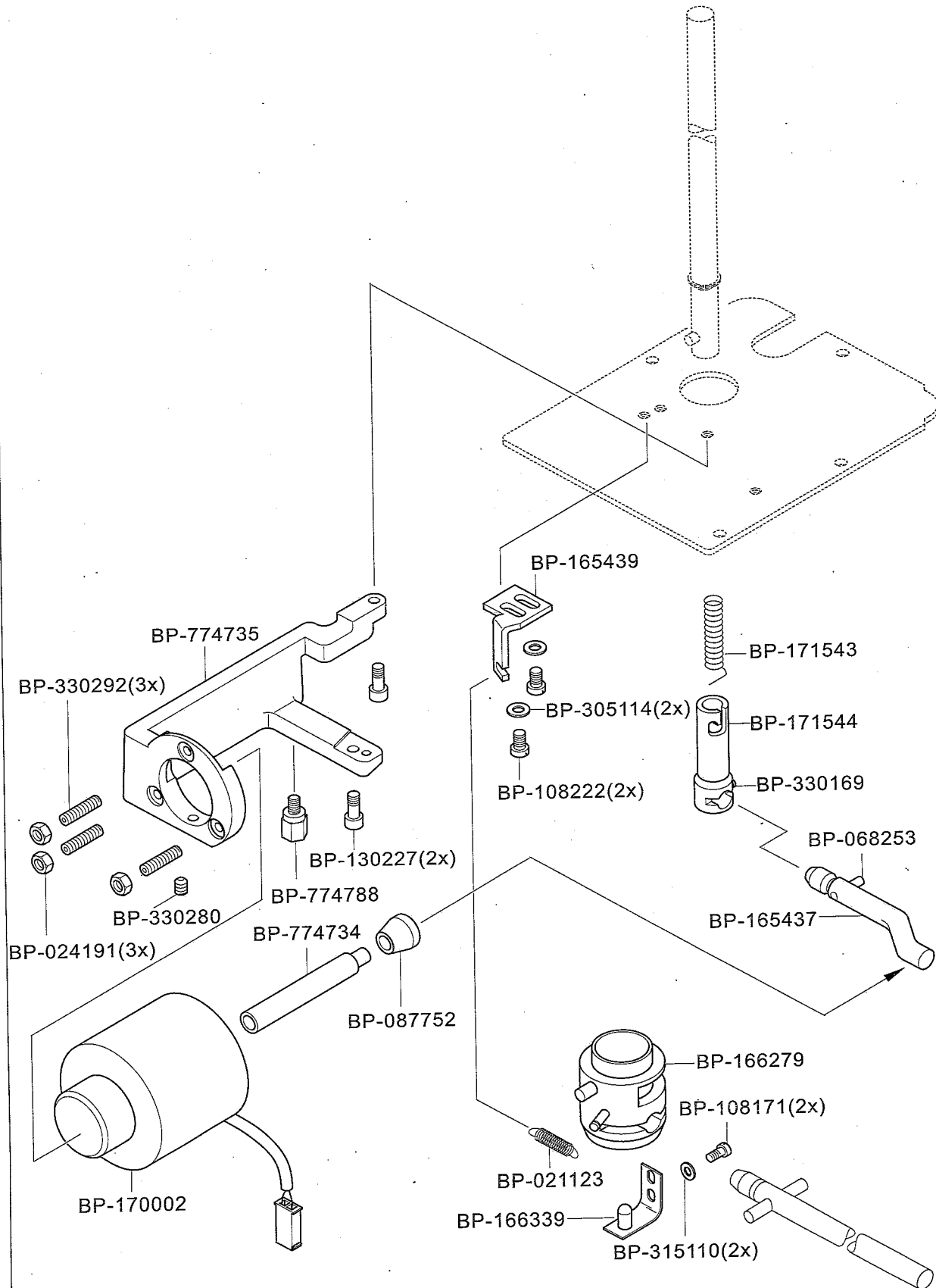
8 FEED WHEEL MOUNTING PLATE



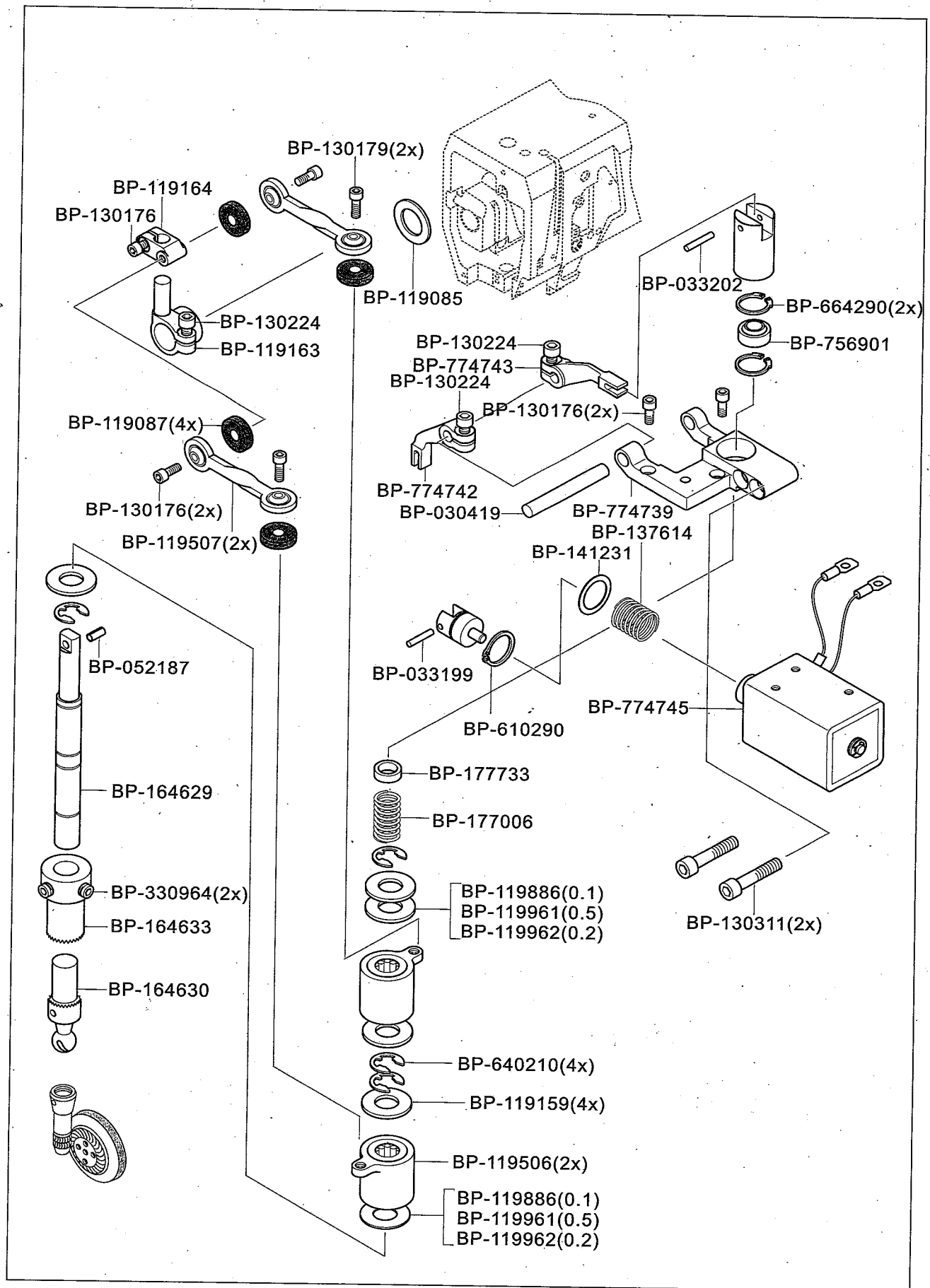


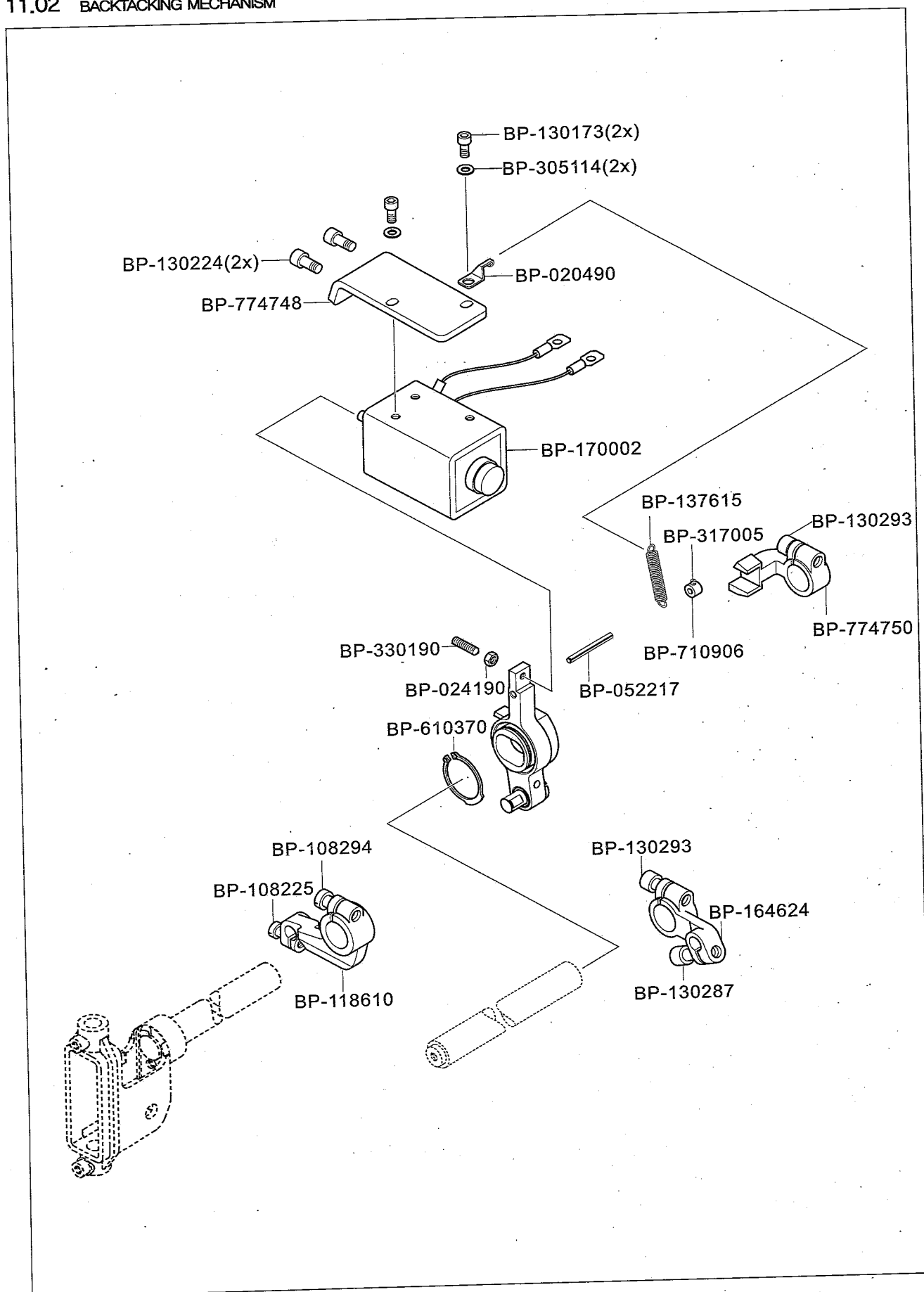
切线器
9.02 THREAD TRIMMER





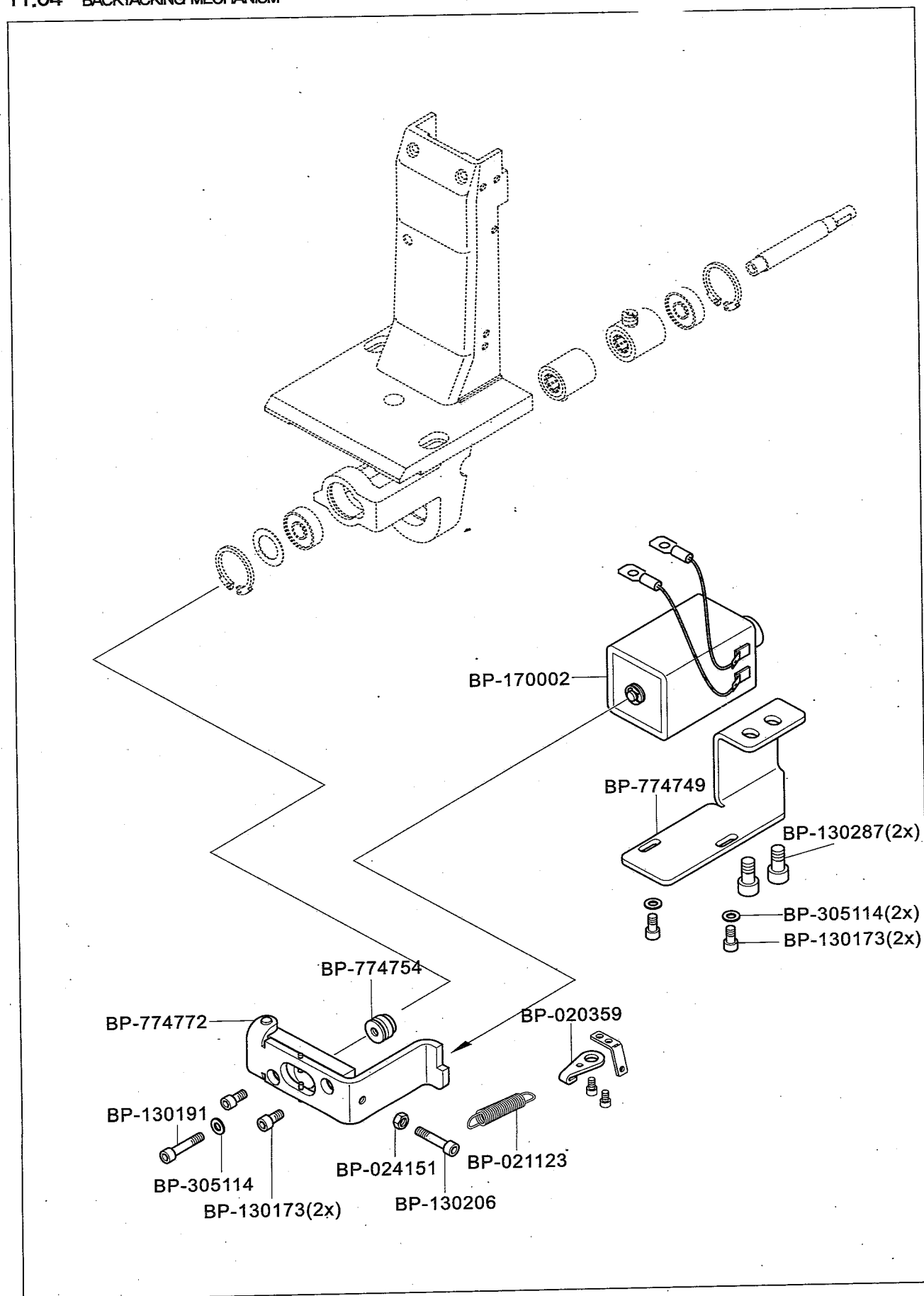
锁紧装置
11.01 BACKTACKING MECHANISM



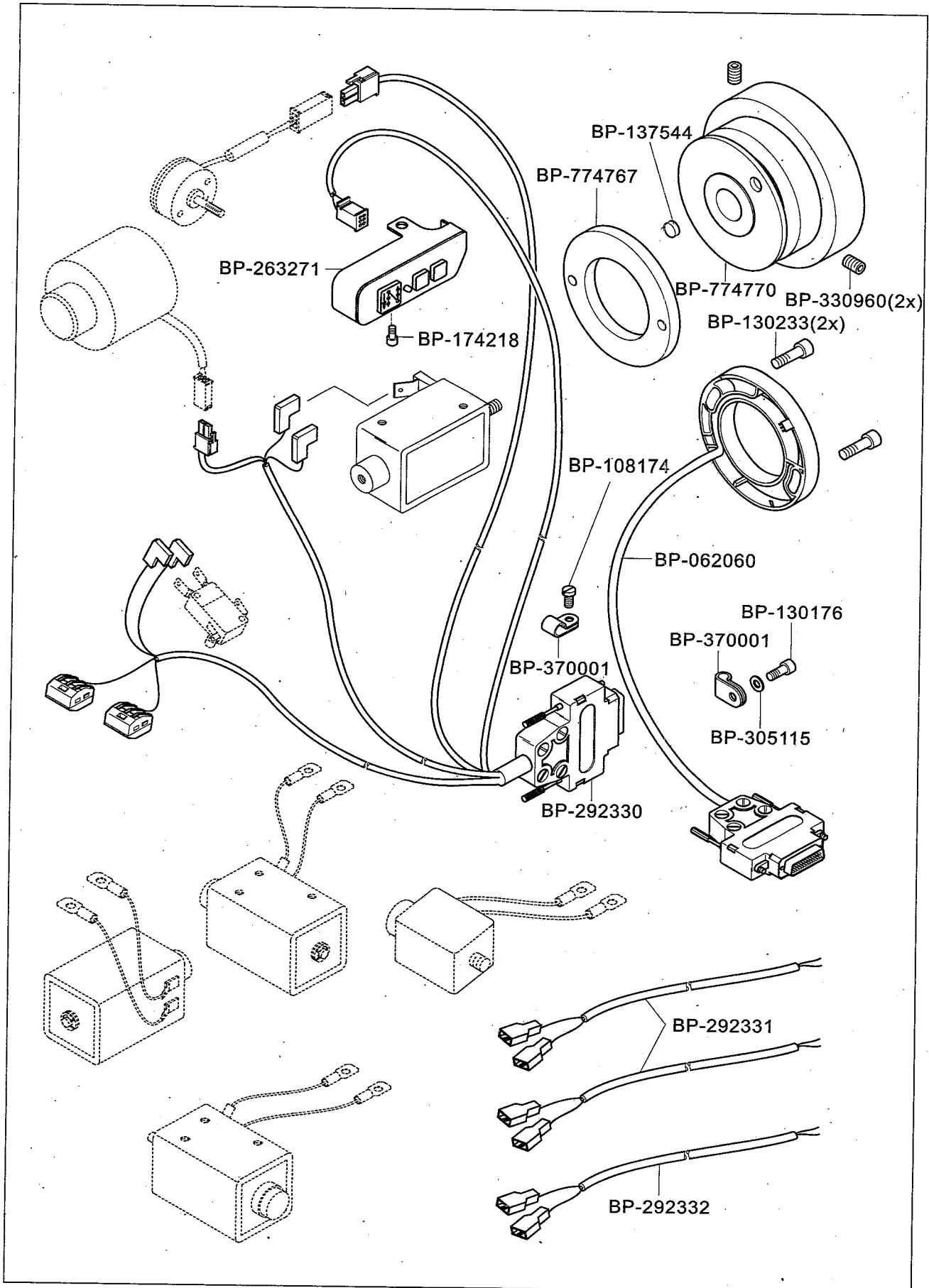




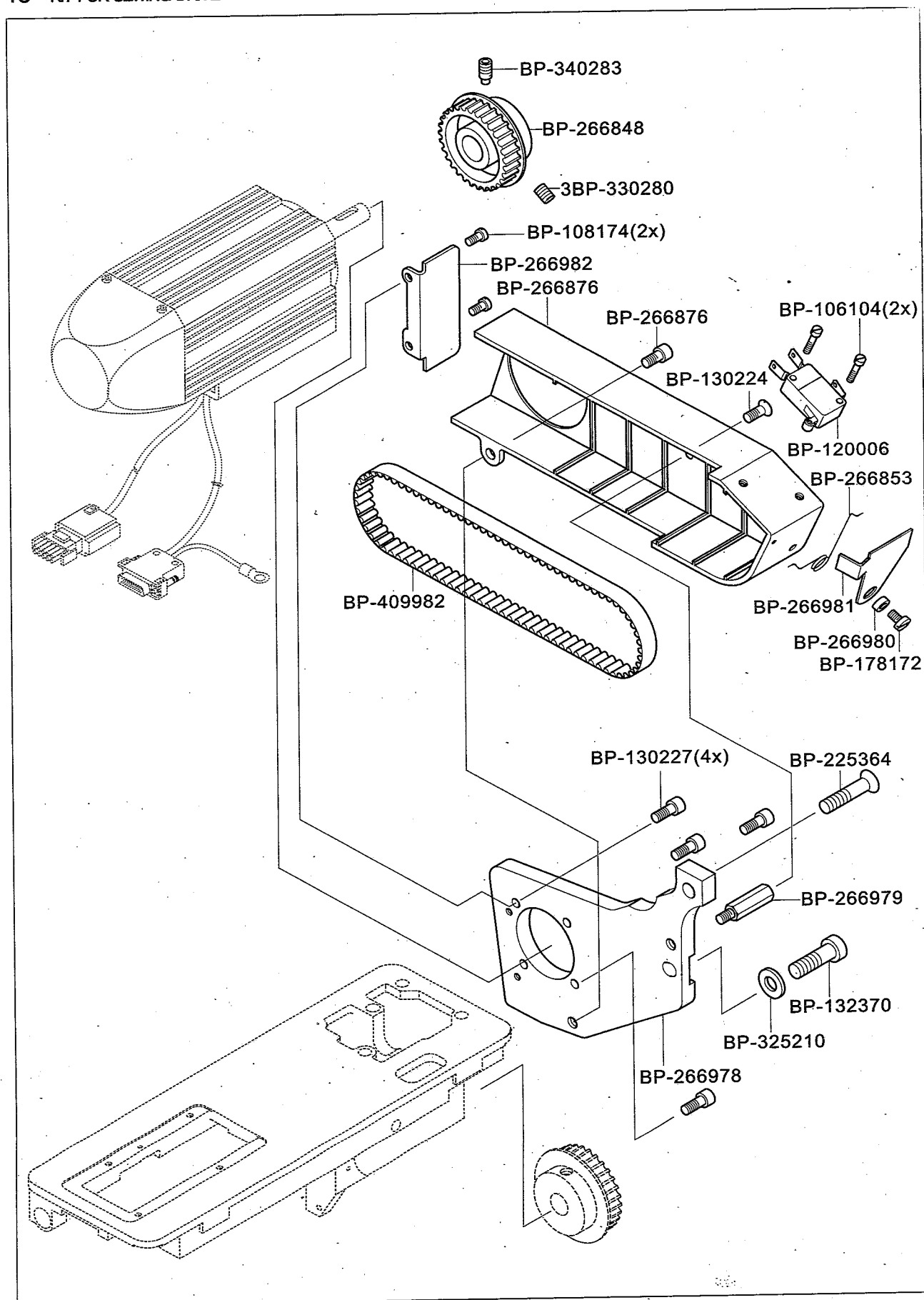
锁紧装置
11.04 BACKTACKING MECHANISM



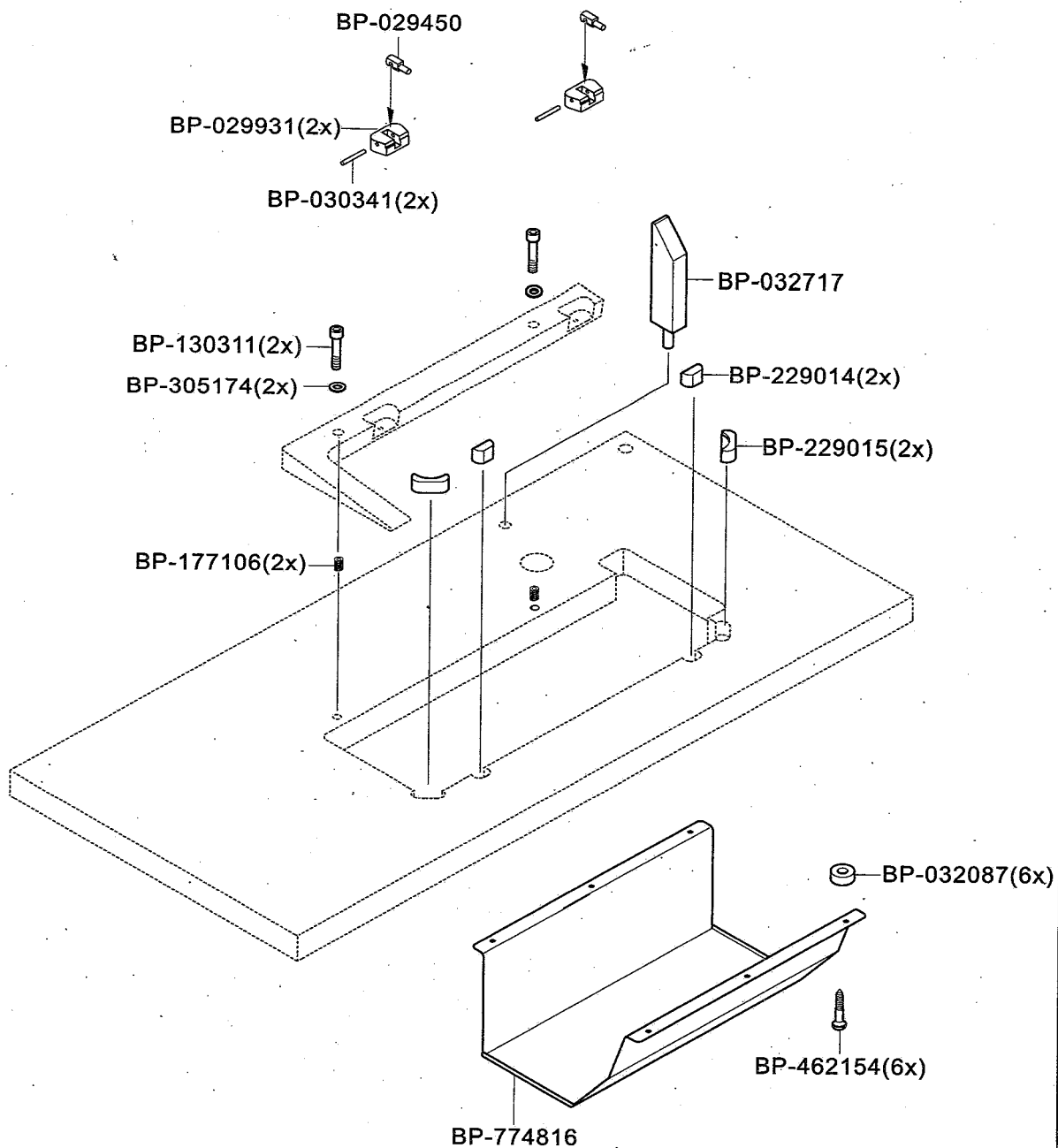
上部机器电缆束
12 CABLE TREE TO SEWING HEAD

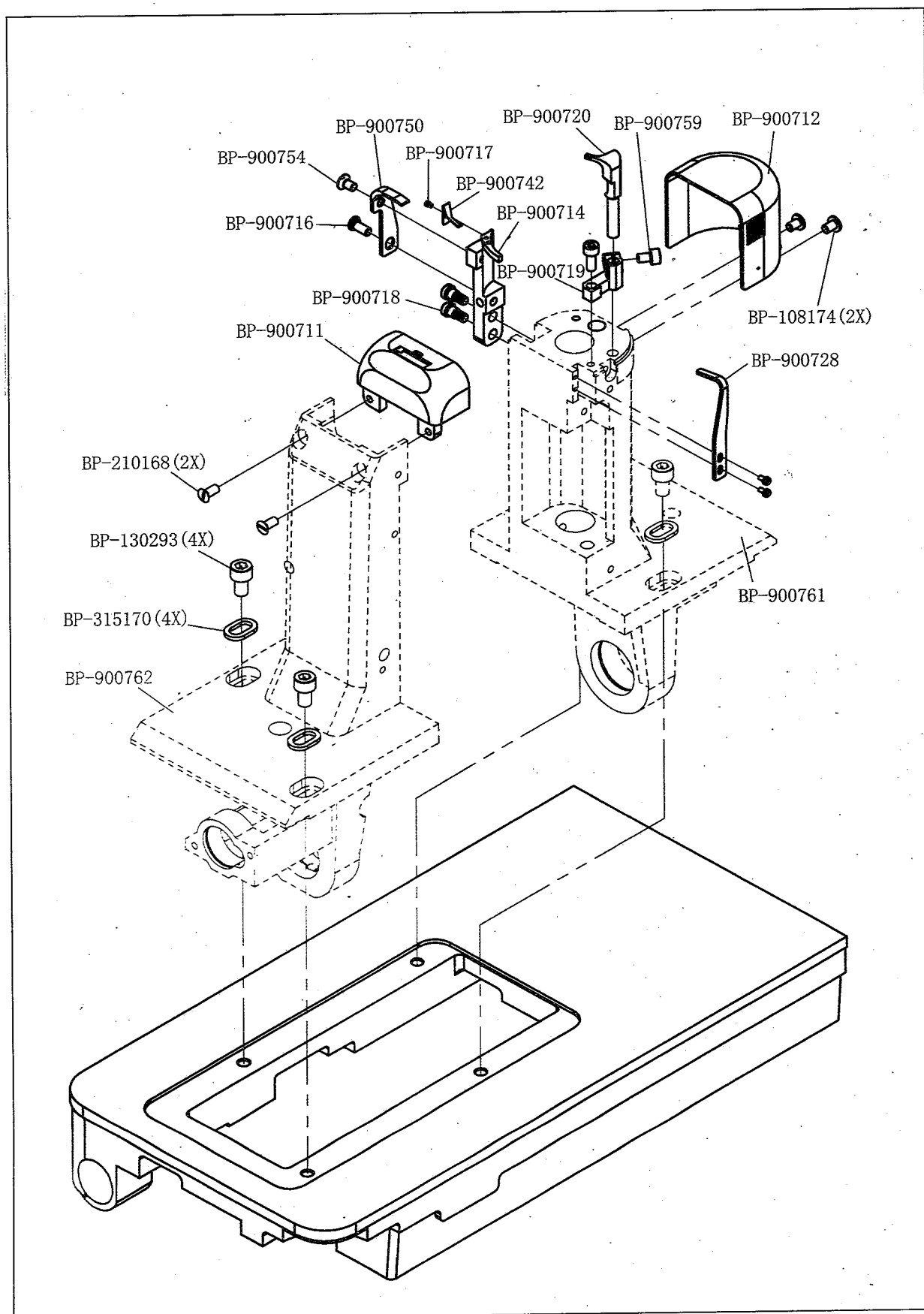


上部机器电缆束
13 KIT FOR SEWING DRIVE



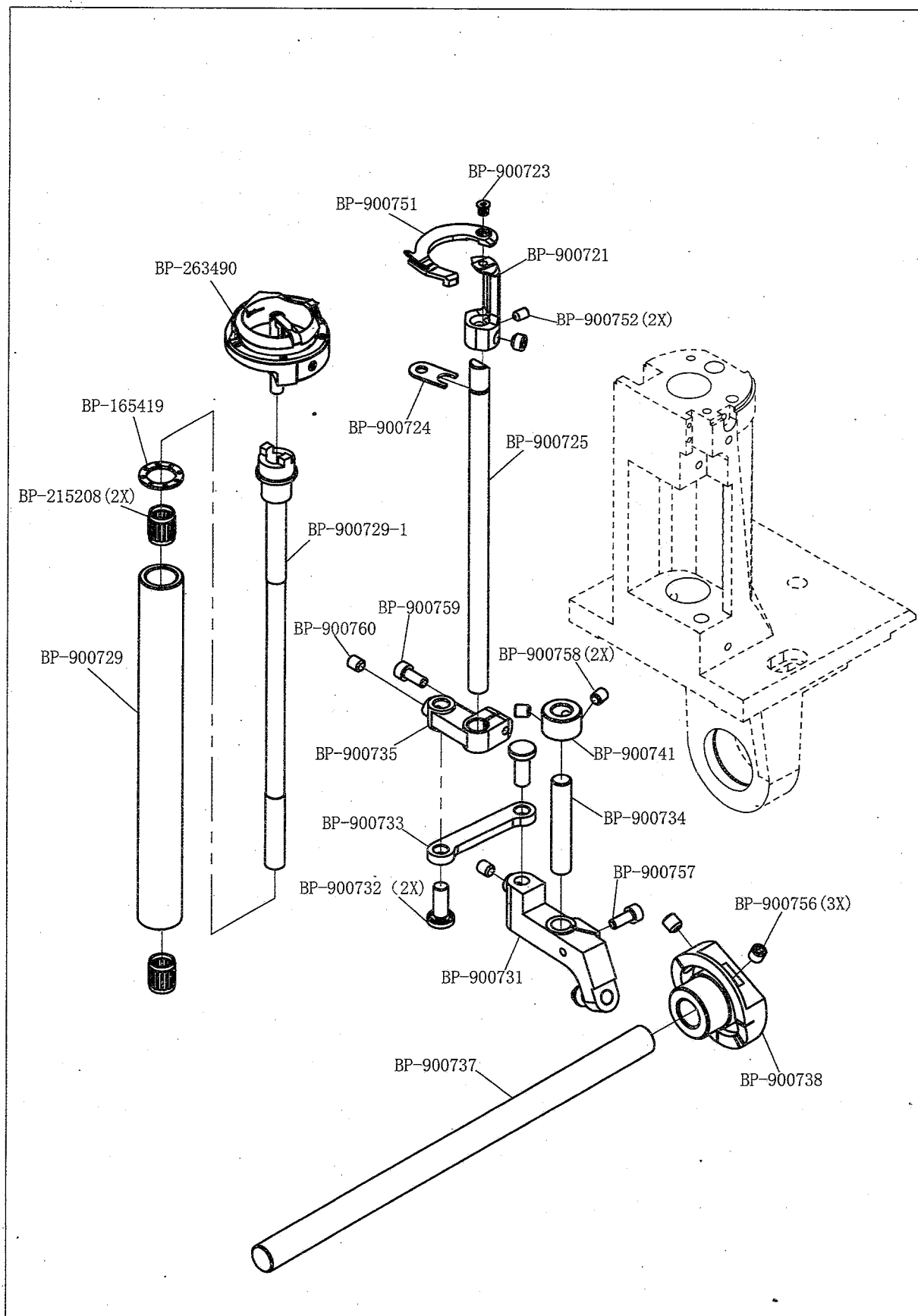
14 PARTS FOR TABLE TOP





BP-1591T(旋梭柱. 右/底板零件)

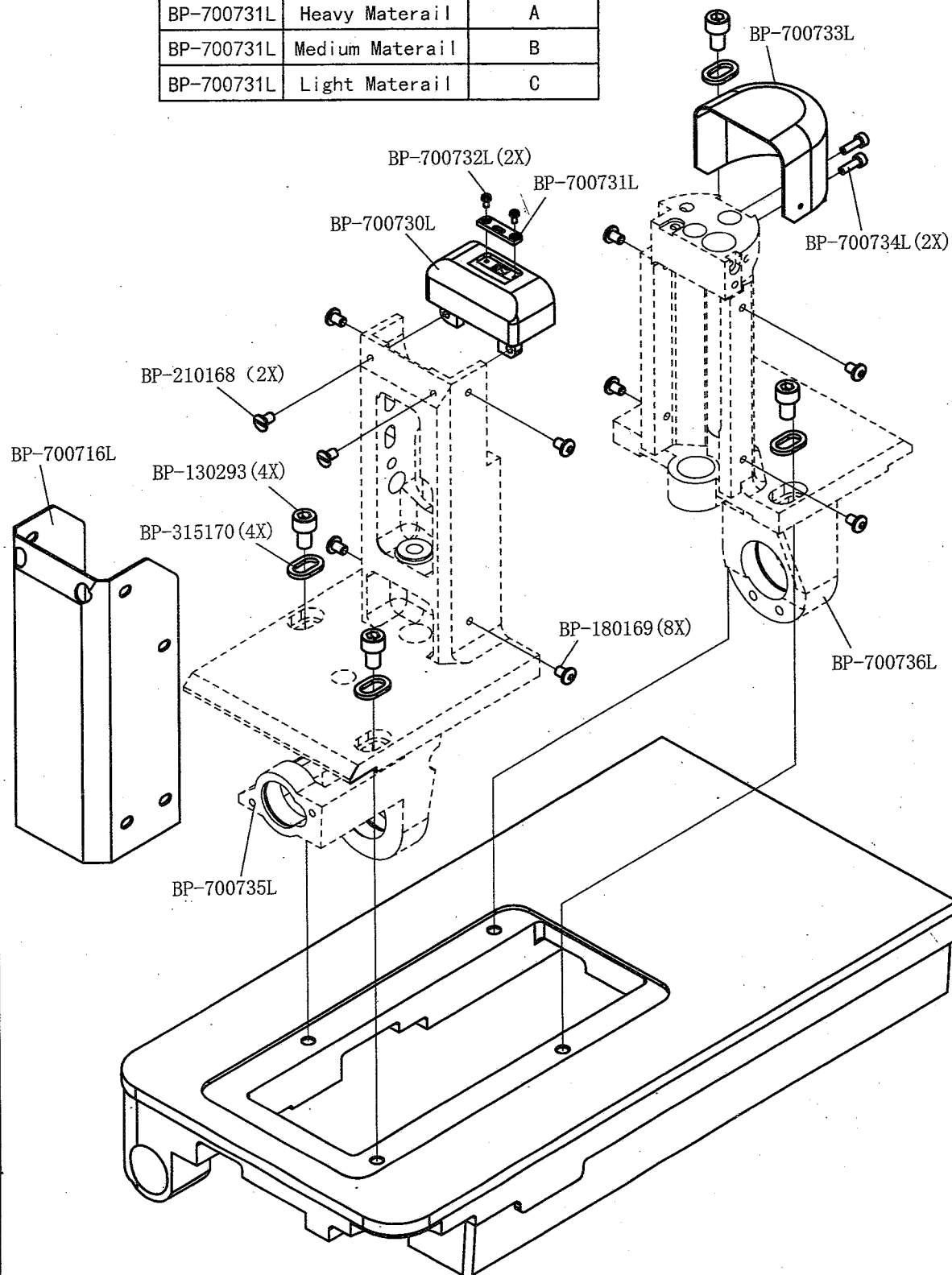
HOOK POST. RIGHT / BEDPLATE PARTS



BP-1591L(旋梭柱. 左/旋梭柱. 右)

HOOK POST. LEFT / HOOK POST. RIGHT

Prat List	Material	Code name
BP-700731L	Heavy Materail	A
BP-700731L	Medium Materail	B
BP-700731L	Light Materail	C



BP-1591L (旋梭柱. 右/底板零件)
HOOK POST. RIGHT / BEDPLATE PARTS

