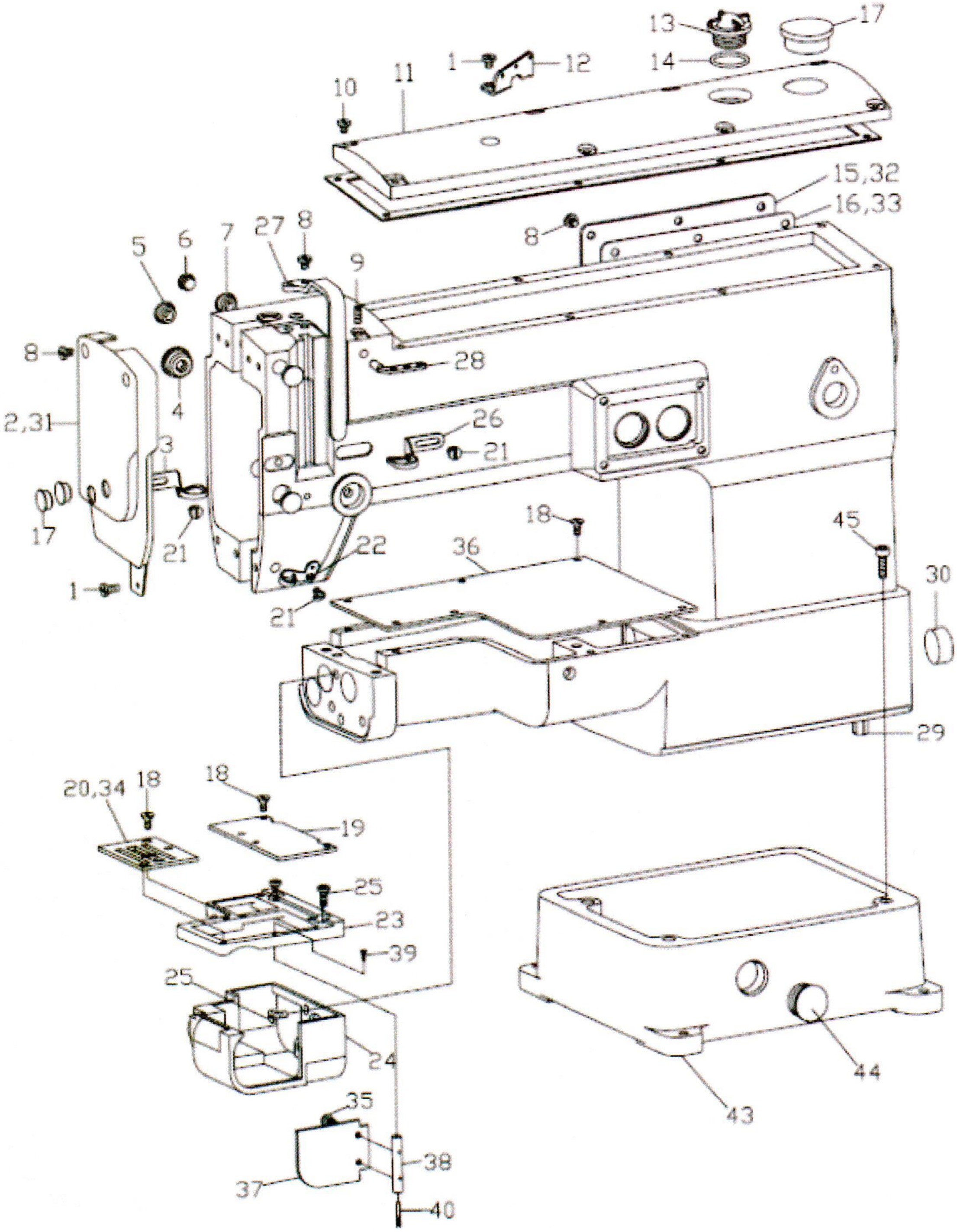
GLOBAL
CBZ 530
SERIES

SINGLE NEEDLE, CYLINDER-BED LOCKSTITCH
ZIG-ZAG SEWING MACHINE

Instruction & Parts Manual

A.Machine body/本體外觀

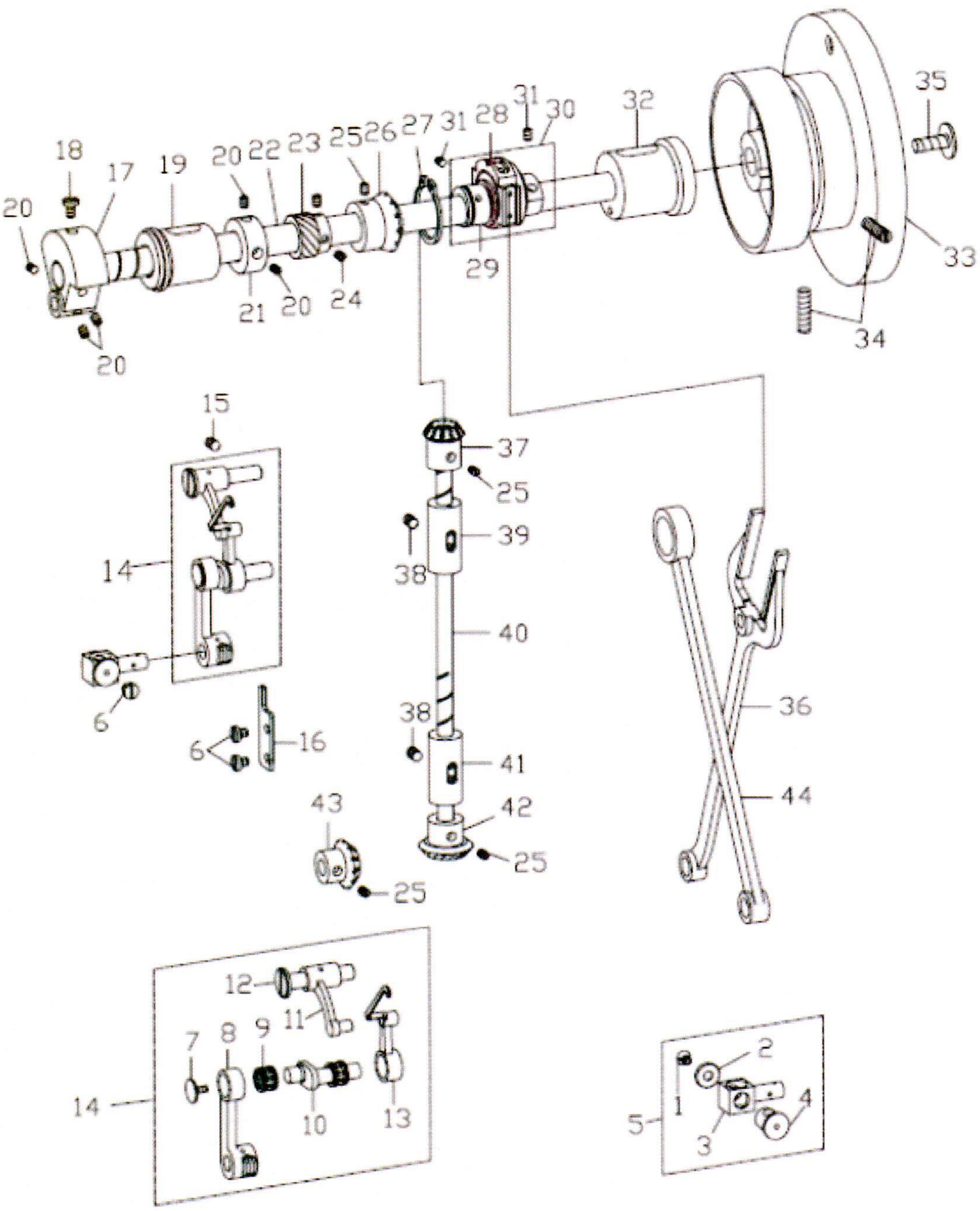


A.Machine body/本體外觀

NO.	P/N	DESCRIPTION	Q'TY
1	Y43-D8X6	screw 11/64-40x5	3
2	1530A-2	1312 front plate	1
3	1530A-3	arm thread guide (left)	1
4	P11. 8X5	rubber cap (D=11)	2
5	P10. 8X4	rubber cap (D=10)	1
6	P15. 8X6	rubber cap (D=14.5)	2
7	P8. 8X5	rubber cap (D=8)	2
8	Y43-D7X7	screw 11/64-40x7	8
9	Y43-D0X6	screw 11/64-40x7	1
10	Y43-D7X9	screw 11/64-40x7	8
11	1530A-11	top cover	1
12	1530A-12	thread guide (top cover)	1
13	1530A-13	oil window	1
14	OR20X2.5	O ring (OR-20x2.5)	1
15	1530A-15	1312 rear plate	1
16	1530A-16	1312 oil pad (rear plate)	1
17	P18.5	rubber cap (top cover)	1
18	42A-12	screw 9/64-40x7	11
19	1312A-19	right needle side plate	1
20	1321A-20	needle plate	1
21	Y35-D7X7	screw 9/64-40x7	3
22	#28S	lower thread guide (upper base)	1
23	1312A-23	stand (needle plate)	1

NO.	P/N	DESCRIPTION	Q'TY
24	1312A-24	stand (hook)	1
25	LT-M6X12	screw M6x1.0x12	3
26	1530A-26	right thread guide (upper base)	1
27	1530A-27	thread take-up cover	1
28	#19	3 holes thread guide	1
29	1530A-29	bed leg	3
30	P24X7	rubber cap	1
31	2530A-31	2312 front plate	1
32	2530A-32	2312 rear plate	1
33	2530A-33	2312 oil pad (rear plate)	1
34	2312A-34	2312 needle plate	1
35	Y3144-D5X6	screw 1/8-44x6	2
36	1312A-36	upper plate (hook cylinder	1
37	1312A-37	front plate (hook cylinder)	
38	1321A-38	post (front plate)	
39	45C-1-19	screw SM1/8-40	1
40	42A-2	pin	1
41	244E-69	spring	1
42	Y23-D4X3	screw SM3/32x56 (L=3)	
43	1312A-43	oil pan	1
44	1126A-41	oil window (oil pan)	1
45	LT-M8X16	8MX1.25X16	3

B.Upper, Vertical shaft & Thread take-up mechanism/上軸、豎軸、挑線機構

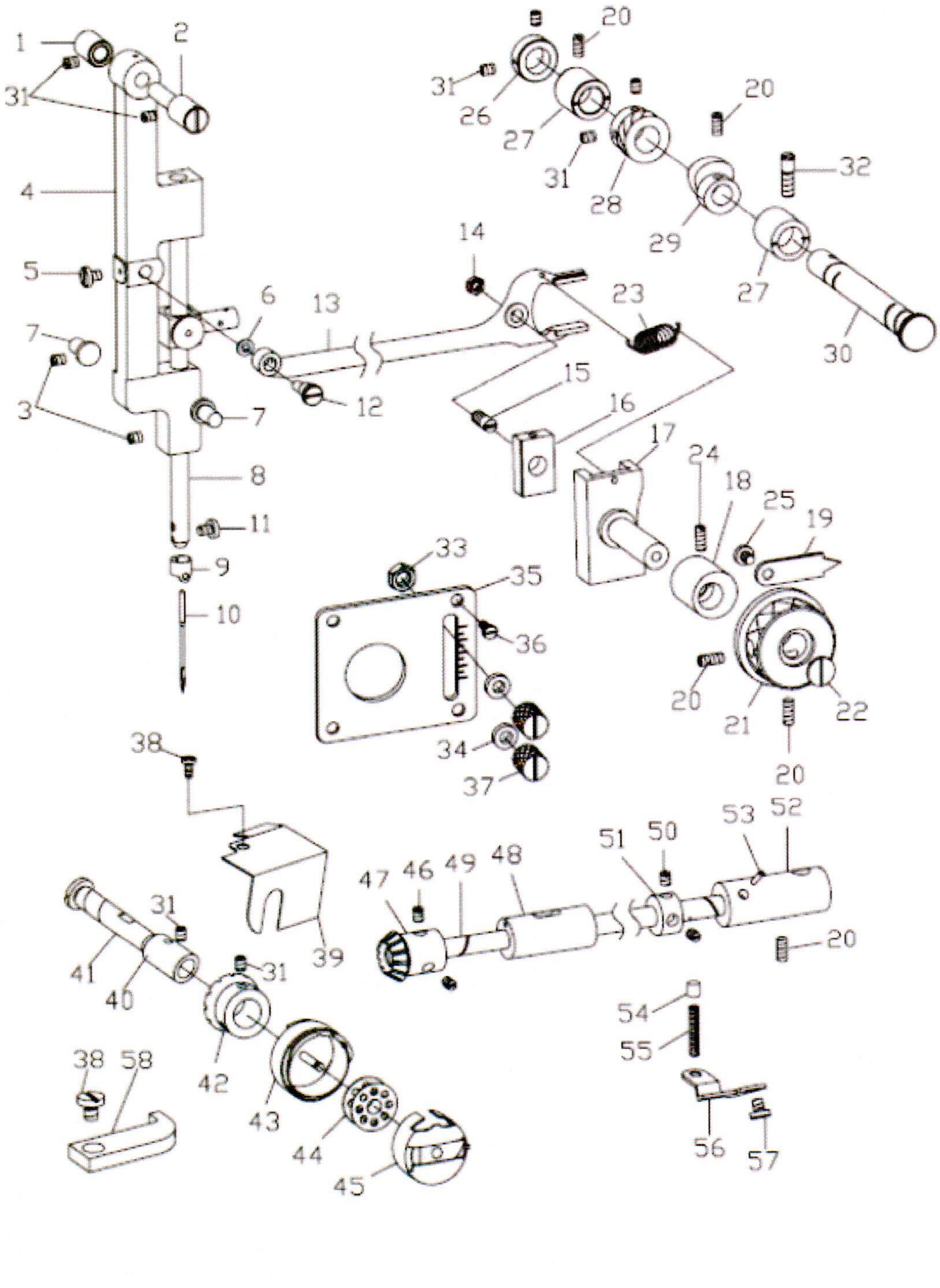


B.Upper, Vertical shaft & Thread take-up mechanism/上軸 · 豎軸 · 挑線機構

NO.	P/N	DESCRIPTION	QTY
1	1530B-1	screw 11/64-40x3.5	1
2	1530B-2	washer	1
3	1530B-3	needle bar connector 1	1
4	1530B-4	needle bar connector 2	1
5	1530B-5	needle bar connector assembly	(1)
6	Y43-D8X6	screw 11/64-40x6	3
7	1530B-7	anti-thread screw	1
8	1530B-8	rod (needle bar)	1
9	08X12X08	needle bearing	2
10	1530B-10	crank (thread take-up)	1
11	1530B-11	rod (thread take-up)	1
12	1530B-12	shaft (thread take-up)	1
13	1530B-13	bar (thread take-up)	1
14	1530B-14	thread take-up assembly	(1)
15	Y59-D0X15	screw 15/64-28x15	1
16	1530B-16	guiding ingot (rod of needle bar)	1
17	1530B-17	crank (needle bar)	1
18	#105	screw 9/32-28x10	1
19	#103	left bush (upper shaft)	1
20	Y63-D0X6	screw 1/4x40x5	3
21	#102	collar (upper shaft)	1
22	1530B-22	upper shaft	1

NO.	P/N	DESCRIPTION	QTY
23	1530B-23	upper gear (rocking needle)	1
24	Y43-SD0X4	screw 11/63x40x4	2
25	Y63-SD0X6	screw 1/4-40x6	10
26	#116	gear (upper shaft)	1
27	S-26	C shape collar	1
28	#129	sliding ingot	1
29	1530B-29	eccentric wheel	1
30	1530B-30	eccentric wheel assembly	(1)
31	Y59-D0X7	screw 15/64-28x7	1
32	#133	right bush (upper shaft)	1
33	1530B-33	pully	1
34	Y59-D0X15	screw 15/64-28x15	2
35	#136	screw 11/32-28x5	1
36	1530B-36	feed fork	1
37	#117	upper gear (vertical shaft)	1
38	Y59-D0X7	screw 15/64-28x5	2
39	#119	upper bush (vertical shaft)	1
40	1530B-40	vertical shaft	1
41	#120A	lower bush (D=17.5)	1
42	#124	lower gear (vertical shaft)	1
43	#125	right gear (vertical shaft)	1
44	1530B-44	rod (feed dog lifter)	1

C.Rocking needle, Lower & Hook shaft mechanism/擺針、下軸、梭軸機構

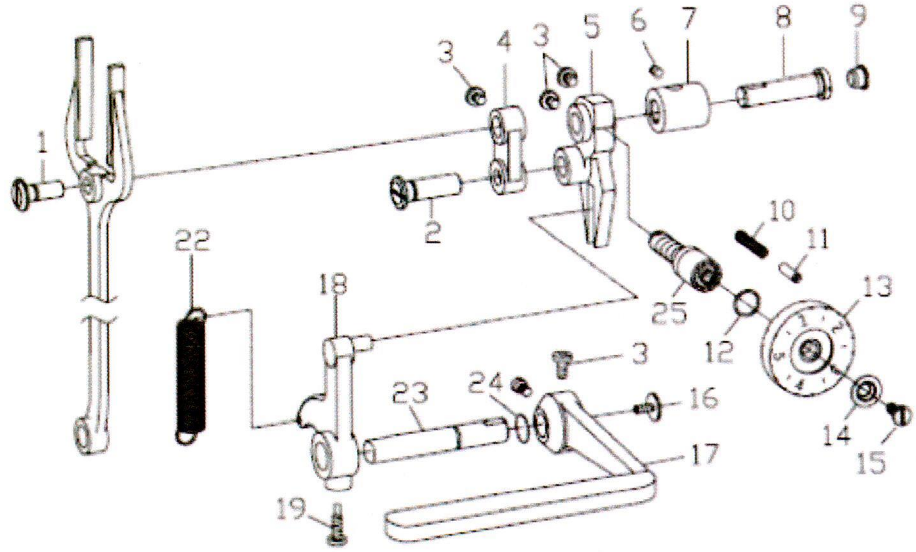


C.Rocking needle, Lower & Hook shaft mechanism/擺針．下軸．梭軸機構

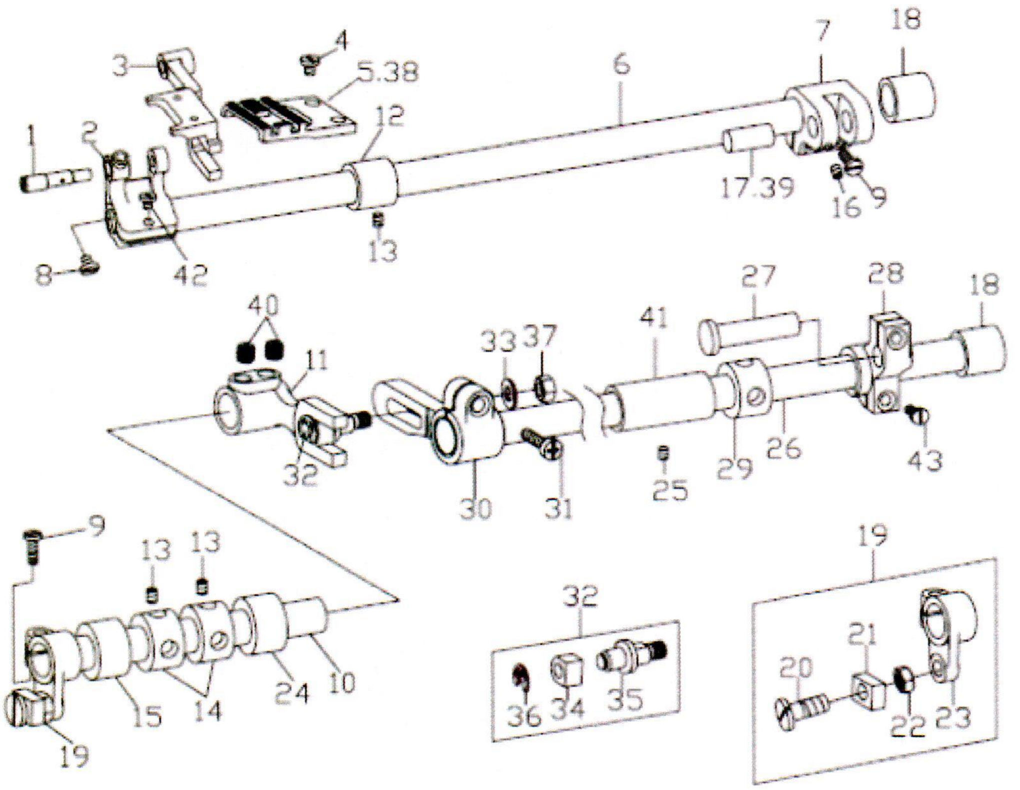
NO.	P/N	DESCRIPTION	Q'TY
1	1530C-1	bush (rocking needle shaft)	1
2	1530C-2	shaft (rocking needle)	1
3	Y43-SD0X4	screw SM11/64-40X6	2
4	1530C-4	rocking needle stand	1
5	Y43-D8X6	screw 11/64-40x6	1
6	W5X10X1	washer W5*10*1	1
7	1530C-7	lower set pin	2
8	1530C-8	needle bar	1
9	1530C-9	guiding thread (needle bar)	1
10	DPX17	needle	1
11	Y3144-D4X4.5	screw 1/8-44x4.5	1
12	1530C-12	eccentric pin	1
13	1530C-13	forked rod	1
14	Y7128-LM11X4	nut 9/32-28x4	1
15	1530C-15	shaft (sliding ingot)	1
16	1530C-16	sliding ingot (forked rod)	1
17	1530C-17	stand (forked rod)	1
18	1530C-18S	bush (stand of forked rod)	1
19	1530C-19	pointer (zig-zag width)	1
20	Y59-D0X7	screw 15/64-28x7	1
21	1530C-21	regular dial	4
22	Y4728-D14X8	screw 3/16-28x8	1
23	1530C-23	spring (forked rod)	1
24	Y59-D0X11	screw 15/64-28x11	1
25	#263	screw 11/64-40x7	1
26	1530C-26	collar (rocking shaft)	1
27	1530C-27	bush (rocking shaft)	2
28	1530C-28	lower gear	1
29	1530C-29	eccentric wheel	1

NO.	P/N	DESCRIPTION	Q'TY
30	1530C-30	shaft (rocking needle)	1
31	Y43-SD0X4	screw 11/64x4 (341C-60)	7
32	1530C-32	screw 15/64-28	4
33	1530C-33	nut 11/64-40x3.5	2
34	W4.5X8	washer W4.5x8	2
35	1530C-35	indicator (zig-zag width)	1
36	Y43-D7X7	screw 11/64-40x7	2
37	1530C-37	knurling screw 11/64-40	2
38	Y35-D7X7	screw 9/61-40x7	2
39	1312C-39	oil box	1
40	1312C-40	bush (hook shaft)	1
41	1312C-41	hook shaft	1
42	1530C-63	gear (hook shaft)	1
43	1312C-43	hook	1
44	1312C-44	bobbin	1
45	1312C-45	bobbin case	1
46	Y63-SD0X6	screw (gear of lower shaft)	2
47	1530C-47	gear (lower shaft)	1
48	#119	left bush (lower shaft)	1
49	1530C-49	lower shaft	1
50	Y59-D0X5	screw 15/64-28x5	2
51	#122	collar (lower shaft)	1
52	1530C-52	right bush (lower shaft)	1
53	1530C-53	oil tube (right bush of lower shaft)	1
54	1530C-54	stopper	1
55	#160	spring	1
56	1530C-56	retainer plate	1
57	Y59-D8X10	screw 15/64-28x10	1
58	1312C-58	locating stand	1

D.Stitch pattern adjustment mechanism/縫目調整機構



E.Lower feed mechanism/下送布機構



D.Stitch pattern adjustment mechanism/縫目調整機構

NO.	P/N	DESCRIPTION	Q'TY
1	1530D-1	shaft (forked rod)	1
2	#152	shaft (stitch length rod)	1
3	Y59-D8X10	screw 15/64-28x10	5
4	1530D-4	rod (stitch length)	1
5	1312D-5	rocking bar (stitch length)	1
6	Y59-D0X11	screw 15/64-28x11	1
7	#1585	bush (rocking bar)	1
8	#159	rocking bar	1
9	P20X4	rubber cap	1
10	#160	set spring	1
11	#162	set pin	1
12	ORIN-14X2.5	O shape ring	1
13	1530D-13	dial (stitch length)	1

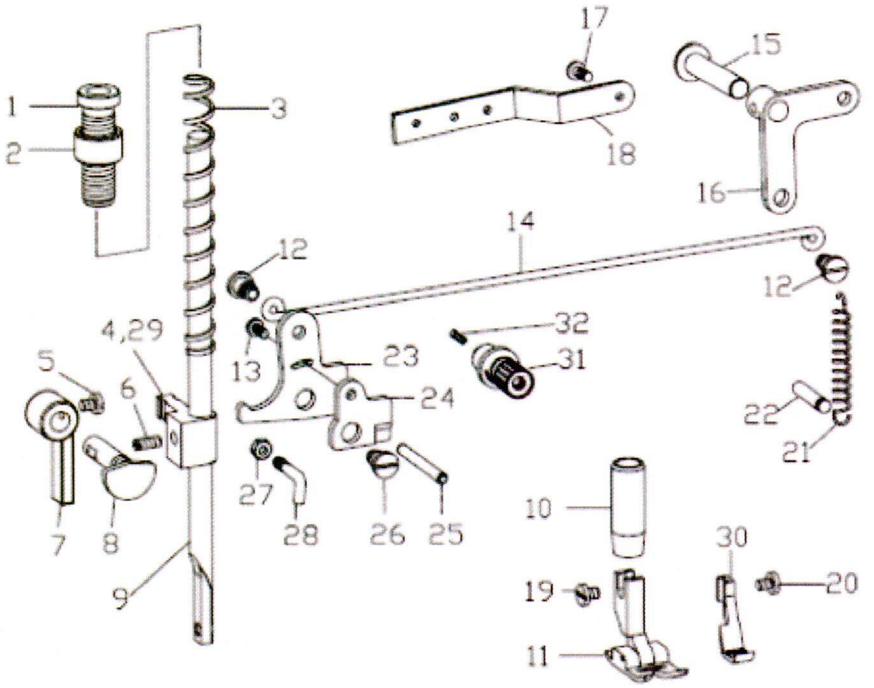
NO.	P/N	DESCRIPTION	Q'TY
14	1530D-14	washer	1
15	Y4728-D8X15	screw 3/16-28x15	5
16	Y4728-D14X8	screw 3/16-28x7	5
17	#167	stitch reverse lever	1
18	#906	crank (stitch reverse)	1
19	#171	screw 15/64-28x10	5
20			
21			
22	640D-54	spring	1
23	#169	shaft (stitch reverse)	1
24	OR-10X2	O shape ring	1
25	1530D-9	screw (stitch length adjustment)	1

E.Lower feed mechanism/下送布機構

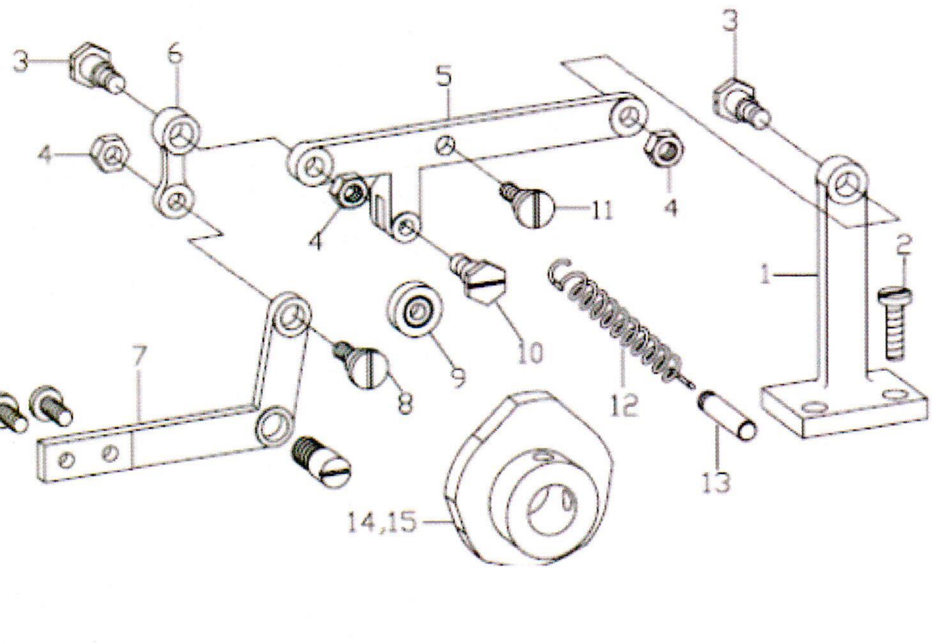
NO.	P/N	DESCRIPTION	Q'TY
1	1530E-1	eccentric shaft (feed bar)	1
2	1312E-2	crank (feed bar)	1
3	1312E-3	feed bar	1
4	Y3144-D5X6	screw 1/8-44x6	2
5	1312E-5	1312 feed dog	1
6	1312E-6	feed shaft	1
7	#222	right crank (feed shaft)	1
8	Y43-D7X7	screw 11/64-40x7	1
9	Y43-D8X13	screw 11/64-40x13	4
10	1312E-10	sub-shaft (feed dod lifter)	1
11	1312E-11	right crank (sub-shaft)	1
12	11530E-12	left bush (feed shaft)	1
13	Y59-D0X5	screw 15/64-28x5	5
14	1312E-14	collar (sub-shaft)	2
15	1312E-15	left bush D=18 (sub-shaft)	
16	Y43-D0X6	screw SM11/64-40x7	1
17	#226	hinge shaft (crank of feed shaft)	1
18	1530E-12	right bush D=21 (feed shaft)	2
19	1312E-19	left crank assy.	(1)
20	1312E-20	screw (sliding ingot)	1
21	42D-1-3	sliding ingot	1
22	Y63-LM10X4	nut SM1/4-4x40	1

NO.	P/N	DESCRIPTION	Q'TY
23	2126C-52	left crank (sub-shaft)	1
24	1312E-24	right bush D=17.5 (sub-shaft)	1
25	Y59-D0X11	screw 15/64-28x11	1
26	1312E-26	main shaft (feed dog lifter)	1
27	1530E-27	hinge shaft	1
28	1530E-28	right crank (main shaft)	1
29	#211	collar (main shaft)	1
30	640E-57	left crank (main shaft)	1
31	YT-M6X18	screw M6x1.0x18	1
32	2530G-28	adjustment assembly	(1)
33	W6.5X13	washer W6.5	2
34	2530G-30	sliding ingot (adjust assy.)	1
35	2530G-29	shaft (adjustment assy.)	1
36	E-4	C shape clip	1
37	Y6324-LM10X5	nut SM1/4-24x5	1
38	2312E-38	2312 feed dog	1
39	640C-17	hinge shaft (crank of feed shaft)	1
40	Y63-SD0X6	screw SM1/4-40x6	2
41	1530E-18	left bush D=20 (main shaft of feed dog lifter)	1
42	LT-M4X10	screw M4x10	1
43	Y4728-D8X15	screw SM3/16-28x15	2

F.Presser foot mechanism/抬押機構



G.Multi-stitch mechanism/多點擺針機構



F.Presser foot mechanism/抬押機構

NO.	P/N	DESCRIPTION	Q'TY
1	#184	screw (adjust pressure)	1
2	42C-4	nut (adjust pressure)	1
3	#187	spring	1
4	1530F-4	guiding ingot (pressure bar)	1
5	Y43-D7X7	screw 11/64-40x7	1
6	Y59-D0X7	screw 15/64-28x7	5
7	1530F-7	lever (pressure foot lifter)	1
8	640F-8	eccentric shaft	1
9	1530F-9	bar (pressrue foot)	1
10	#202	lower bush	1
11	1530F-11	1312 pressure foot	1
12	1530F-12	half-thread 3/16-28x8.5 (341F-25)	2
13	Y43-D9X7	screw 11/64-40x6.5	1
14	1530F-14	guiding bar (knee controller of pressure foot)	1
15	1126D-15	shaft (knee controller)	1
16	1126D-16	plate (knee controller)	1

NO.	P/N	DESCRIPTION	Q'TY
17	Y59-D8X10	screw 15/64-28x10	2
18	1312F-18	plate (chain)	1
19	Y35-D7X7	screw 9/64-40x7	1
20	LT-M4X10	screw M4-0.75x10	1
21	1530F-21	spring	1
22	1530F-22	pin	1
23	1530F-23	left ingot (pressure foot knee controller)	1
24	1530F-24	tention release plate	1
25	1530F-25	tention release bar	1
26	1530F-26S	half-thread screw 15/64-28	1
27	Y35-LM6X3	nut 9/64-40x3	1
28	1530F-28	thread guide	1
29	2530F-29	guiding ingot (2312 bar of pressure foot)	1
30	2530F-30	2312 internal pressure foot	1
31	1530A-24	thread tention assy.	1
32	Y59-D0X7	screw 15/64-28x7	3

PS. 1530F-4 & 1530F-11 for TC-1312/1313/1314
2530F-29 & 2530F-30 for TC-2312/2313/2314

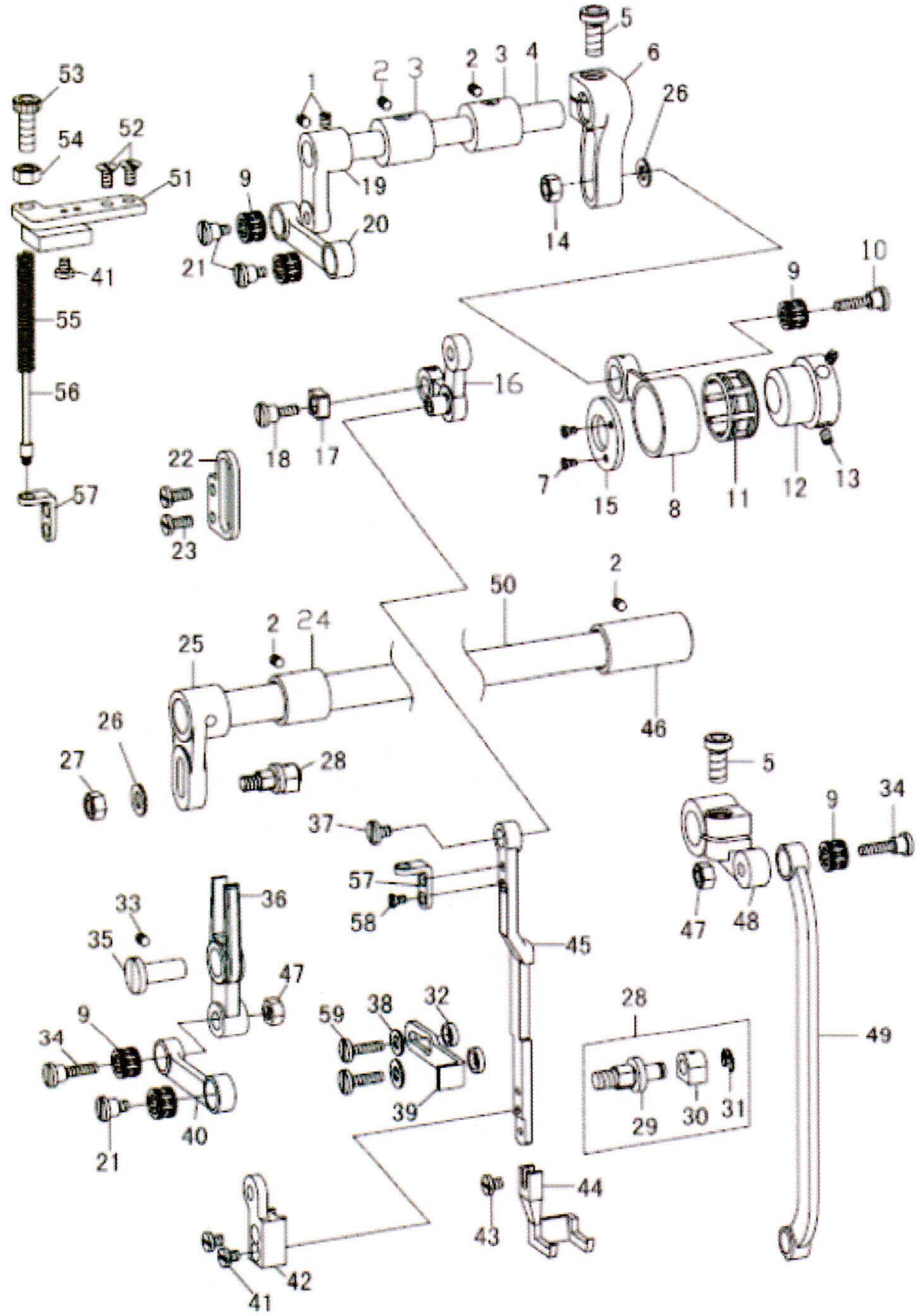
G.Multi-stitch mechanism/多點擺針機構

NO.	P/N	DESCRIPTION	Q'TY
1	1534H-1	stand (wheel bar) (1534C-1)	1
2	LT-M6X12	M6-1.0x12	2
3	1534H-5	half-thread screw SM3/16-32	2
4	Y4732-LM8X4	nut SM3/16-32	3
5	1534H-2	wheel bar (1530C-2)	1
6	1534H-13	connection bar	1
7	1534H-3	rod (rocking needle)	1
8	#267	half-thread screw SM3/16-32	1

NO.	P/N	DESCRIPTION	Q'TY
9	624ZZ	bearing	1
10	91C-9	half-thread screw M4-0.75x6	1
11	#188-1	half-thread screw SM3/16-28	1
12	1533H-8	spring	1
13	1530F-22	pin	1
14	1533H-11	eccentric cam for 3 stitch	1
15	1534H-12	eccentric cam for 4 stitch	1

PS. 1533H-11 for 3 stitch
1534H-12 for 4 stitch

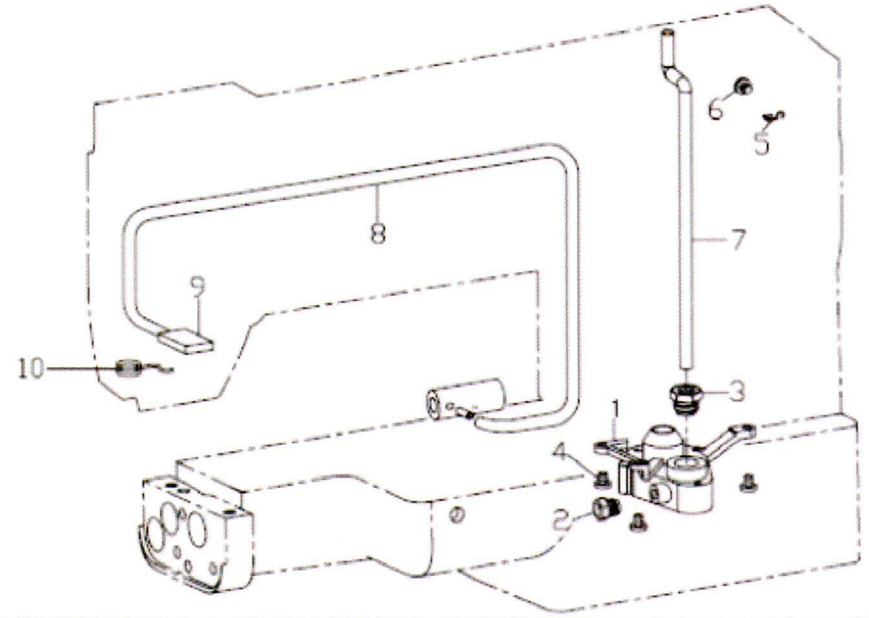
H.Upper feed mechanism/上送布機構



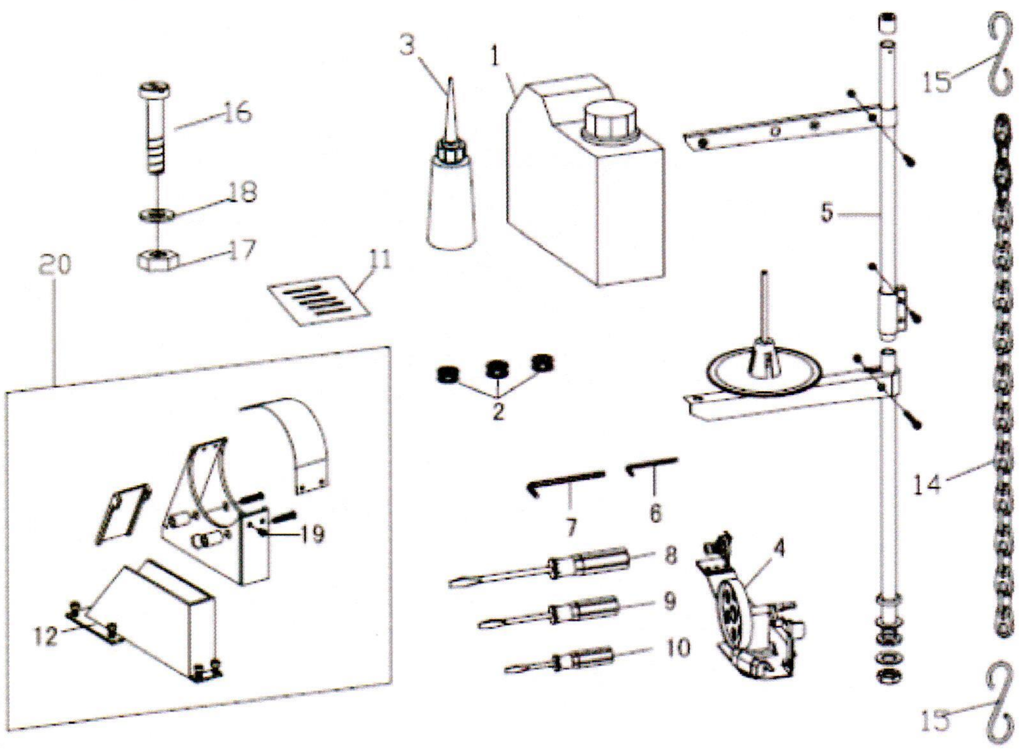
H.Upper feed mechanism/上送布機構

NO.	P/N	DESCRIPTION	Q'TY
1	LM-M5X6	screw M5x6	2
2	Y43-D0X6	screw 11/64-40x6	4
3	2530G-3	bush (shaft of foot lifter)	2
4	2530G-4	shaft (foot lifter)	1
5	LT-M6X20	screw M6x20	2
6	2530G-6	adjustable crank (foot lifter)	1
7	42A-12	screw SM9/64-40x6	2
8	2530G-8	rod (eccentric wheel)	1
9	8X12X8	needle bearing	6
10	2530G-10	screw M6	1
11	24X28X13	needle bearing	1
12	2530G-12	eccentric (foot lifter)	1
13	Y63-D0X6	screw 1/4-40x6	2
14	M6-LM10X4	nut M6	1
15	2530G-15	plate (eccentric wheel)	1
16	2530G-16	rod (external foot)	1
17	2530G-17	sliding ingot	1
18	2530G-18	screw 3/16-28x7	1
19	2530G-19	crank (external foot lifter)	1
20	2530G-20	rod (external foot lifter)	1
21	2530G-21	screw 1/4-40x6	3
22	2530G-22	guiding plate (bar of foot lifter)	1
23	Y43-D9X7	screw 11/64-40x7	2
24	2530G-24	left bush (external shaft)	1
25	640E-57	Left rocking crank	1
26	W6.5X13	W6.5 washer	1
27	Y6324-LM10X5	nut 1/4-24x5	1
28	2530G-28	sync adjustable screw (external foot)	(1)
29	2530G-29	shaft (adjustable screw)	1
30	2530G-30	sliding ingot (adjustable screw)	1
31	E-4	C shape clip	1
32	2530G-32	washer	2
33	Y59-D0X7	screw 15/64-28x7	1
34	2530G-34	screw 1/4-40x16	2
35	2530G-35	guiding shaft (variable feed crank)	1
36	640E-63	variable feed crank (external presser foot)	1
37	Y4728-D12X7	screw 3/16-28x7	1
38	W4.5X10	washer	2
39	2530G-39	presser plate (external foot)	1
40	2530G-40	feeding rod (external foot)	1
41	Y35-D6X6	screw 9/64-40x6	2
42	2530G-42	stand (feeding rod)	1
43	Y35-D7X7	screw 9/64-40x8	1
44	2530G-44	external presser foot	1
45	2530G-45	plate (external foot)	1
46	640E-46	right bush (external shaft)	1
47	Y63-LM10X5	nut 1/4-40x5	2
48	2530G-48	right rocking crank	1
49	2530G-49	rod (rocking crank)	1
50	640E-43	external shaft	1
51	2530G-51	stand (external presser foot)	1
52	#263	screw 11/64-40x7	2
53	2530G-53	adjustable screw (external presser foot)	1
54	Y7128-LM11X4	nut 9/32-28	1
55	2530G-55	spring (external presser foot)	1
56	2530G-56	sub-shaft (external presser foot)	1
57	2530G-57	spring stand	1
58	Y35-D7X7	screw 9/64-40x7	2
59	Y43-D7X12	screw SM11/64-40X12	2

J.Lubrication mechanism/供油機構



K.Accessory/配件



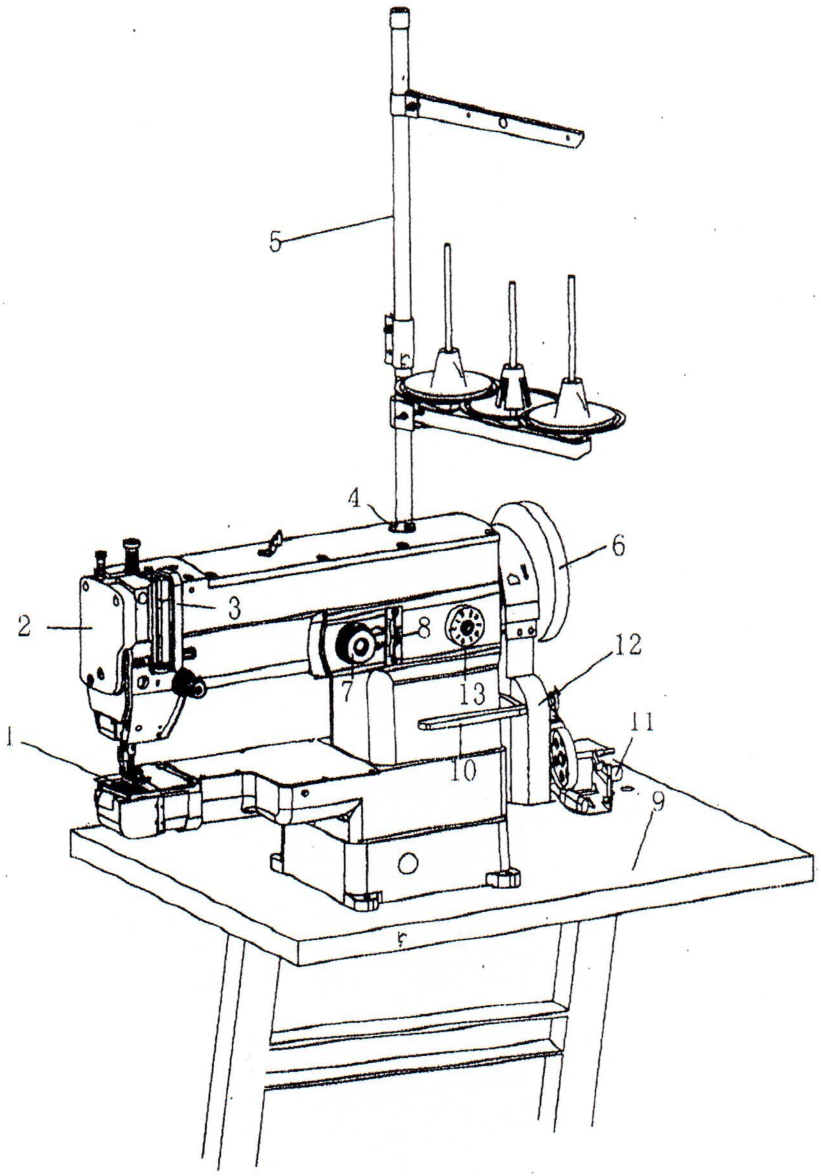
J.Lubrication mechanism/供油機構

NO.	P/N	DESCRIPTION	QTY
1	1530J-1	oil pump assy.	1
2	1530J-2	screw 11/32-28x5	1
3	1530J-3	screw 11/32-28x5	3
4	Y43-D8X13	screw 11/64-40x13	1
5	1530J-5	spring (oil spring)	1
6	Y43-D7X7	screw 11/64-40x7	1
7	1530J-7	aluminum oil tube	1
8	1530J-8	plastic oil tube	1
9		oil cotton	1
10	1530J-100	cotton spring	1

K.Accessory/附件

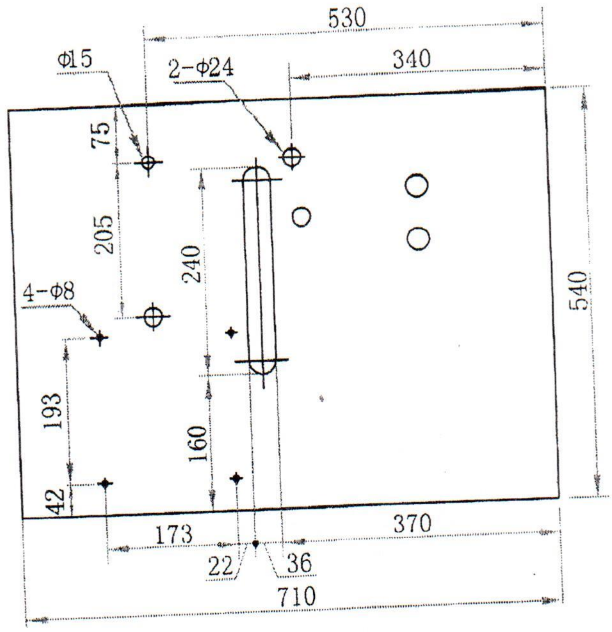
NO.	P/N	DESCRIPTION	QTY
1	1530K-1	oil tank	1
2	1530K-2	bobbin	3
3	1530K-3	oiler assy.	1
4	1530K-4	thread winder	1
5	1530K-5	thread stand assy.	1
6	1530K-6	hexagonal wrench (2mm)	1
7	1530K-7	hexagonal wrench (5mm)	1
8	1530K-8	screw driver-large	1
9	1530K-9	screw driver-medium	1
10	1530K-10	screw driver-small	1
11	1530K	DPX5 needle	4
12	1531K	taping screw	4
13	1532K	nut	1
14		chain	1
15		S shape hook	2
16	M6X1.0	screw	4
17	M6X1.0	nut	4
18	W6X12	washer	4
19	1530K-11	screw (belt cover assy.)	7
20	2312K-20	belt cover assembly	1

一. 各部件名称 <NAMES OF MAJOR PARTS>

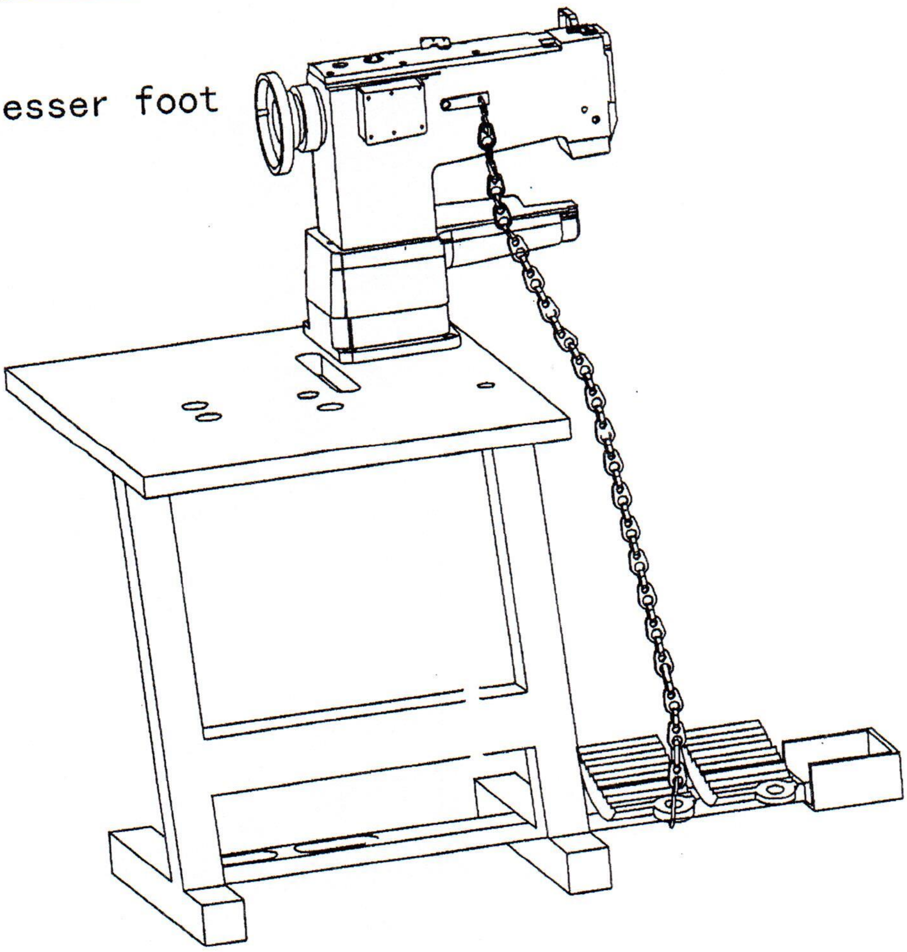


1. 针板<Needle Plate>
2. 面板<Face Plate>
3. 挑线杆防护罩
   <THRED TAKE-UP LEVER COVER>
4. 油窗<Oil Window>
5. 线架<Cctconstand Assy>
6. 手轮<Pully>
7. 摆幅手转轮<Hand Trun Wheel>
8. 摆幅指示板<Indicating Board>
9. 台板<Rubber Hinge Assy>
10. 倒缝把手<Reverse Lever>
11. 绕线器 <Bobbin Winder Assy>
12. 皮带罩 <Belt covr>
13. 针距标盘 <Feed Adjusting Dial>

台板规格 Working Table



脚链安装方式
Under the presser foot



二、缝纫机规格<MACHINE SPECIFICATIONS>

Item \ Model	TC-1312/TC-1313/TC-1314	TC-2312/TC-2313/TC-2314
Speed 速度	1600spm	1600spm
Zigzag width 摆幅	2points/3points/4points	2points/3points/4points
Needle size 机针	DPx17	DPx17
Thead take-up capacity 挑线杆活动量	73mm	73mm
Needle bar capacity 针杆活动量	34mm	34mm
Presser foot operating 压脚差动量		3~7mm
Presser foot tising rate 压脚上升量	7mm	7mm
Shuttle 旋梭	Rotary Hook(DB TYPE) 卧式旋梭	Rotary Hook(DB TYPE) 卧式旋梭
Usage 用途	Light-weight materials 薄料	Medium-weight materials 中料

三. 安装<INSTALLATION>

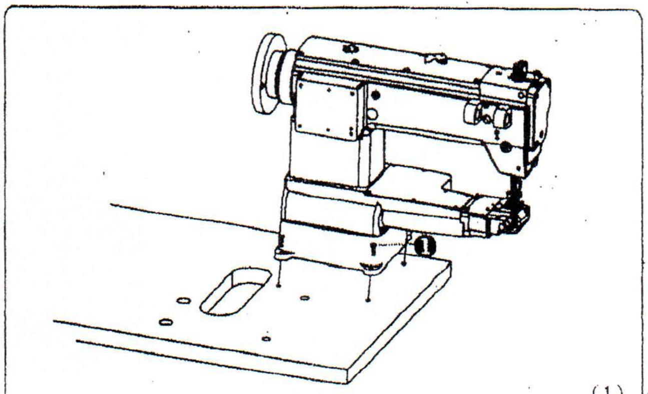
缝纫机机身<Sewing machine body>

As figure (1) shown:

Apply screw❶to mount sewing machine body and plate.

如图（1）所示：

用螺钉❶将缝纫机机身与台板固定好。



(1)

As figure (2) shown:

Apply screw❷to tighten belt cover U ❶ to machine cover.

Apply screw❹to tighten belt cover C ❸ and cover U ❶.

Apply screw❻to tighten belt cover D ❺ on the table.

如图（2）所示：

U型皮带罩

用螺钉❷将U型皮带罩❶装入机壳.

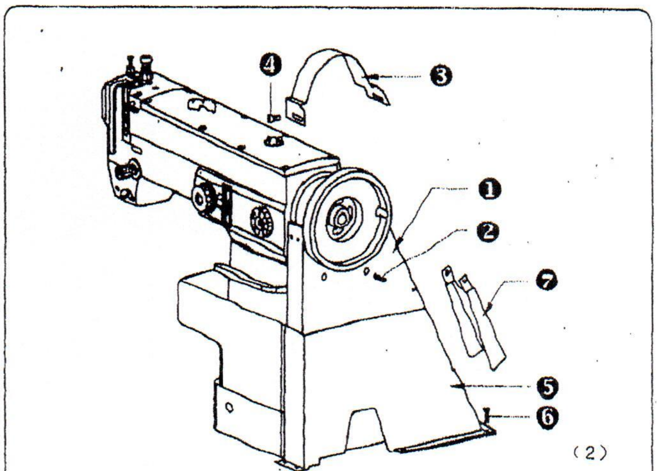
C型皮带罩

用螺钉❹将C型皮带罩❸与U型皮带罩❶锁紧.

D型皮带罩

用螺钉❻将D型皮带罩❺锁紧.

将D型皮带罩盖❼扣入U型皮带罩❶。



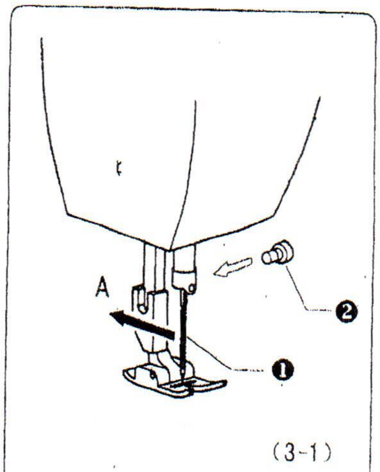
(2)

K. Adjustment / 缝纫机的调整

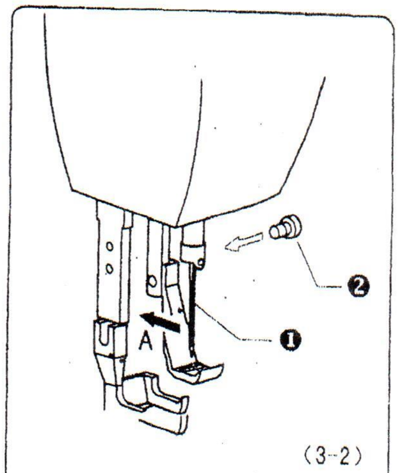
Installing the needle

As figure (3-1 3-2) shown:
Rotate handwheel to make needle bar rise to the meximumhigh,loosen tighten screw ❷ plug needle ❶ to the top needle's groove side face to A then fsten screw ❷.

如图(6-1)(6-2)所示，转动手轮使针杆上升到最高位置，松开机针紧固螺钉❷，将机针❶插到顶，长槽面向A方向，然后拧紧螺钉❷。



(3-1)

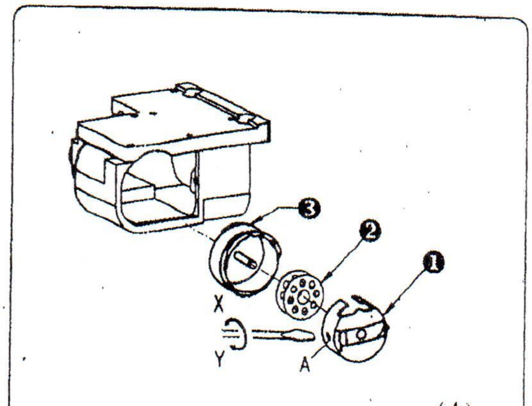


(3-2)

As figure (7) shown:
<1> Open the case cover, then take out the bobbin case ❶。 Instell bobbin ❷ into bobbin case ❶, open the case cover, snap bobbin case ❶ into shuttle ❸ then assemble together。
<2> Tuen tension adjustment screw (A) clockwise Y to increse the bobbin thread ten sion, or counterclockwise X to decrease it。

梭壳拆装及张力调整

<1> 梭壳的拆装 掰开梭壳盖A，即可取出梭壳❶。将梭芯❷装入梭壳❶后，掰开梭壳盖A，将梭壳扣入旋梭❸，并与之结合即可。
<2> 张力的调节 如图，用螺丝刀转动螺钉A，X方向底线张力变小，Y方向张力变大。

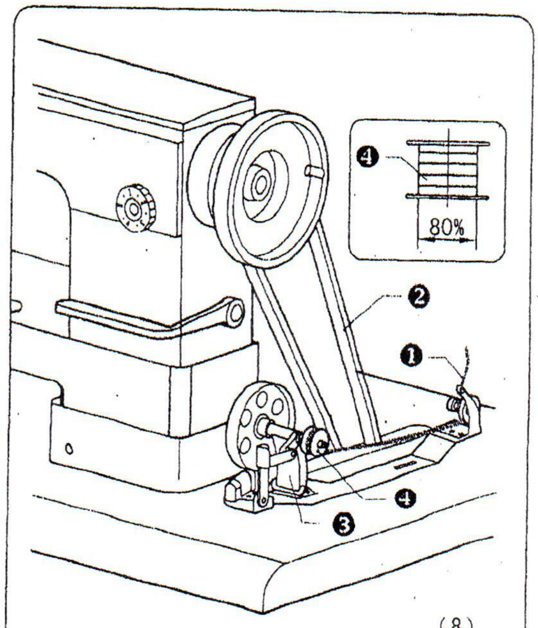


(4)

As figure (8)show : connect lower thread ❶ move handle of the winding shaft ❸ to snap the wheel to beit ❷ and rotate it 80% of the winding amount in bobbin ❹ will be best.

绕底线

底线❶按图(8)所示连接好之后，推动绕线器❸的扳手使转轮贴到皮带轮❷上，并随之转动。
梭芯❹上的绕线量约80%时为最好。



(8)

As figure (9) shown:

<1>Threading the upper thread

Insent the upper thread ❶ as figure shown.

<2> Face line tension adjustment

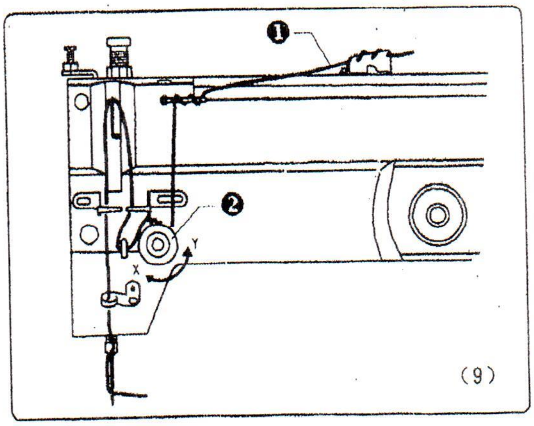
Rotate clipper ❷, the upperline tension in direction Xincrease and Y direction decrease.

穿面线及调整

如图 (9) 所示

<1> 穿面线，面线❶按图依次穿过。

<2> 面线的调整，转动夹线器❷，X方向面线张力变大，
Y方向张力变小。



(9)

Presser foot pressure adjustment

As figure (10) shown:

Rotate screw ❶, the outer pressure in A direction increase B direction decrease adjustment fix the nut ❷.

Rotate screw ❸, the inner pressure in C direction increase D direction decrease after adjustment fix the nut ❹.

压脚压力调整

如图 (10) 所示

外压脚压力调整

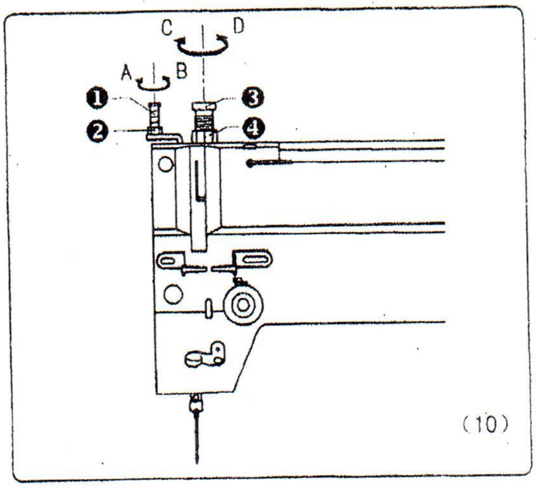
旋转螺丝❶，A方向外压脚压力变大，

B方向压力变小。调整后必须固好螺母❷。

内压脚压力调整

旋转螺丝❸，C方向内压脚压力变大，

D方向压力变小。调整后必须固好螺母❹。



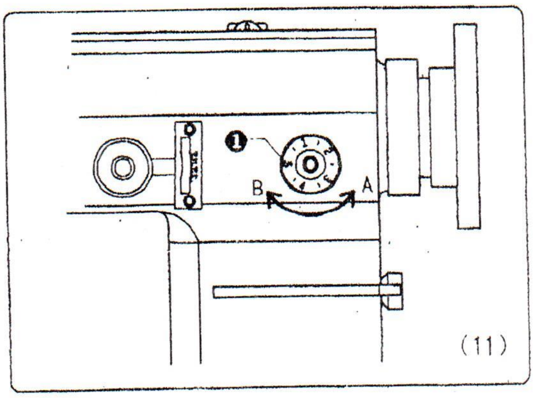
(10)

As figure (11) shown:

Rotate the stitch length dial assy ❶ to adjust the swing span in A direction decrease and B direction increase.

针距调整

如图 (11) 所示，针距调节盘❶上表示的是针距mm的数值，左右转动调整到自己需要的数值上。



(11)

Span adjustment

As figure (13) shown:

Macro adjustment

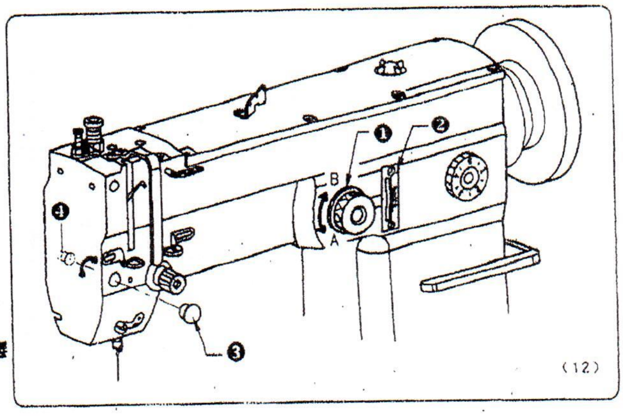
The swing indicator ❷ indicate the span number in mm rotate the swing handwheel ❶, toadjust the swing span in A direction decrease and B direction increase.

Micro adjustment

Open the rubber cork ❸ apply screwdriver to rotate eccentric bar ❹ to adjust the swing span.

摆幅调整

如图 (13) 所示，摆幅指示板❷上表示的是摆幅mm的数值，转动摆幅手转轮❶，A方向摆幅减小，B方向摆幅增大。



(12)

P. TROUBLESHOOT

NO	Trouble	What to do when	Trouble parse	Corrective measures
1	Breaking needle	Direction and height of needle	Wrong direction of upper needle	Correct direction from high to maximum high
		needle	Bend needle	Change needle
		Feed dog travel	Mismatch of needle bar movement feed dog travel	Adjust travel of needle and shuttle
		Needle bar rising	Wrong travel of needle and shuttle	Adjust travel of needle and shuttle
		Needle bar height	Wrong travel of needle and shuttle	Adjust travel of needle and shuttle
		Maim distance between needle and shuttl	Wrong traveled needle and shuttle	Correct threading
2	Breaking thread	Ways of threading	Improper threading	Correct threading
		needle	Bent needle or broken needle tip	Change needle
		Direction and height of needle	Upper needle problem	Correct upper needle
		Upper thread tension	Upper thread tension too strong	Adjust upper thread tension
		Lower thread tension	Lower thread tension too strong	Adjust lower thread tension
		Thread take-up spring rate	Rate too big	Adjust spring rate
		Thread take-up spring tension	Thread take-up spring tension too weak	Adjust thread take-up spring tension
3	Wire problem	Thread tension	Shuttle upper thread tension problem	Adjust shuttle and upper thread tension
		Thread take up spring tension	Thread take-up spring tension problem	Adjust thread take-up spring tension
		Presser foot	Presser foot too high	Adjust presser foot height
		Presser foot pressure	Presser foot presser too small	Adjust presser foot pressure
4	Wrinkly of fabric	Feed dog height	Feed dog height too low	Adjust feed dog height
		Presser foot pressure	Presser foot pressure too small	Adjust presser foot pressure
		bobbin	Scratch bobbin	Polish or change
		V belt tension	Belt tension too small	Adjust belt tension
5	Tangled thread	Upper thread tension	Upper thread tension too strong	Adjust upper thread tension
		Lower upper thread tension	Lower thread tension too strong	Adjust lower and upper thread tension
		Thread take-up spring tension	Thread take-up spring tension too problem	Adjust thread take-up spring tension
		Thread take-up spring rate	Rate too big	Adjust thread take-up spring rate
		Presser foot pressure	Presser foot pressure too small	Adjust presser foot pressure
6	Tangled thread	bobbin	When pulling lower thread bobbin reverse	Reverse bobbin
		bobbin	Bobbin does not rotate smoothly	Chang bobbin
		Bobbin winding amount	Too much winding amount	Winding amount should not be more than 80%