

UH SERIES

寶獅牌工業用縫紉機 INDUSTRIAL SEWING MACHINE

MODEL

UH9303

UH9304

UHD9303

UHD9304



**SUPER HIGH SPEED CYLINDER
BED OVERLOCK MACHINE**

User Manual



精機機械廠股份有限公司 CHING CHI MACHINE CO., LTD
<http://www.kingtexsewing.com.tw>

Ver 5.0 2019.10
NO. UH9300-5-10-03
6UH9300-2

前 言

UH9300 系列是筒型鎖邊的拷克機。

- 各種不同性質厚薄的布料都能縫製出完美的線跡。
- 調整容易維修簡單充分表現優越的效率。
- 零件製作精良，安靜平穩，持久耐用。

為了使愛用者能充分掌握本機型系列，說明書裡特別列舉出安裝、保養、調整、使用方法及注意事項，請多參考。

安全注意事項：

1. 皮帶護蓋一定要裝上。
2. 馬達電源接線一定要確認。
3. 無論是作業開始前的檢查，使用後的清掃、或是使用中必須停機、穿線換針等，一定要切斷電源，馬達完全停止後再做後續工作。
4. 新機器在開始使用的第一個月，請以 6000RPM 以下的轉速使用。
5. 添加潤滑油的時候請注意油面鏡的刻線，切勿超過上限。
6. 使用前請用油壺在上彎針軸即針棒上稍微加一點油。
7. 使用前請注意縫針有沒有彎曲，針尖有沒有折斷，針窩的方向是否正確。
8. 參照穿線圖確認穿線是否正確。
9. 作業結束的時候，縫機一定要清掃，套上防塵套。

PREFACE :

UH-9300 SERIES IS A CYLINDER BED OVERLOCK MACHINE .

ABLE TO PERFORM PERFECT SEWING STITCHES EVEN USING
DIFFERENT KINDS OF HEAVY OR LIGHT MATERIALS ,
EASY MAINTENANCE AND REPAIRING , ALSO CAN PERFORMS HIGH EFFICIENCY .

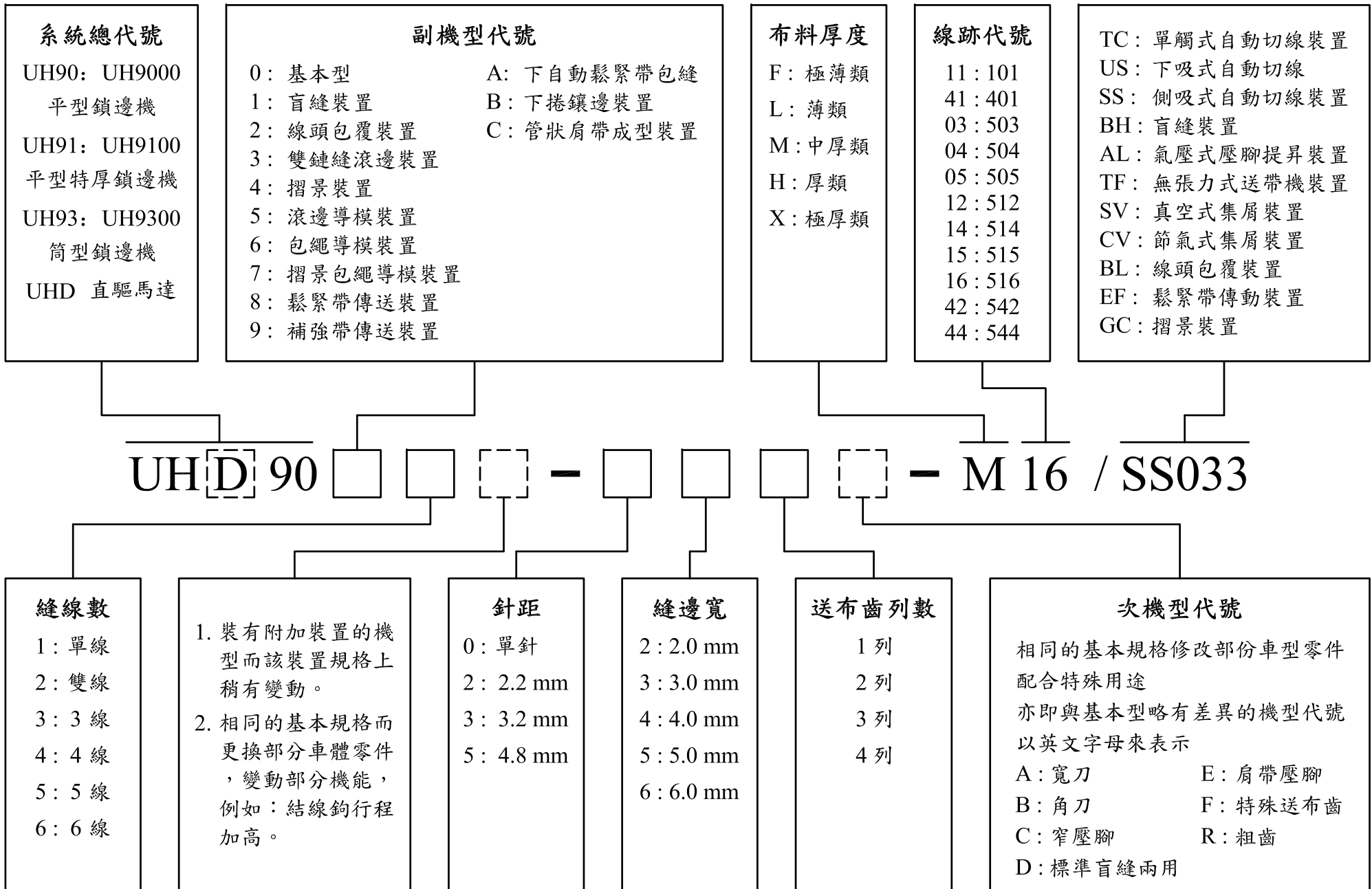
WITH PRECISION PARTS , MACHINES CAN BE PERFORMED QUIET
STABLE , DURABLE CHARACTERS .

FOR OPERATOR TO MASTER THIS MACHINE , THIS INSTRUCTION
MANUEL HAVE LISTED FEW BASIC ITEMS WHICH SHOWING HOW
TO INSTALL , MAINTENANCE , ADJUSTING AND SAFETY PRECAUTIONS
IN ORDER TO KEEP THE MACHINE IN THE BEST POSSIBLE CONDITIONS .

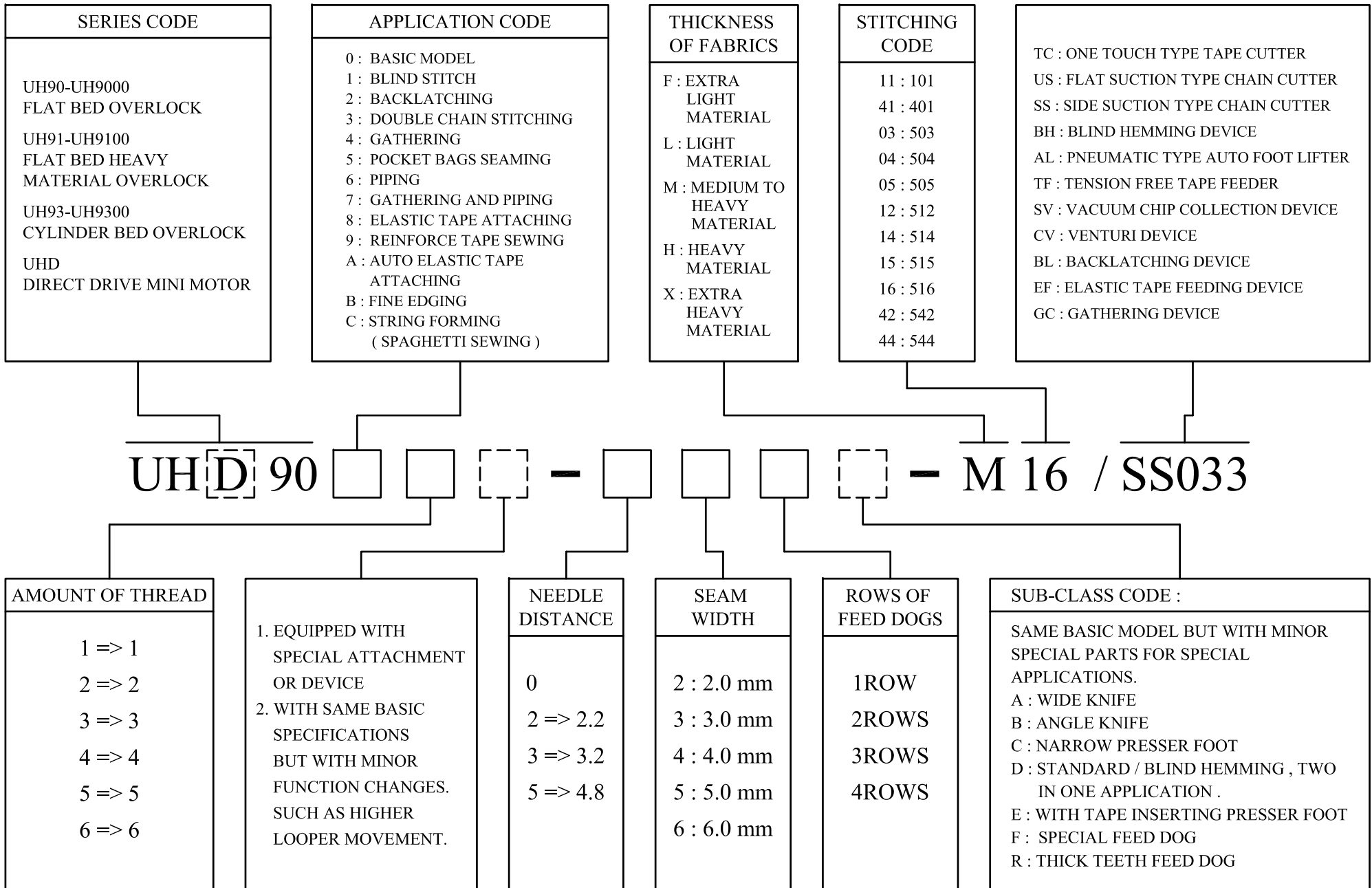
SAFETY PRECAUTIONS :

1. BELT COVER MUST BE INSTALLED .
2. MAKE SURE MOTOR POWER BEEN WIRED PROPERLY .
3. BEFORE MAINTENANCE , ADJUSTING , REPAIRING , CLEANING , THREADING OR
REPLACING NEEDLES , MUST MAKE SURE TO TURN OFF THE ELECTRICITY POWER
AND THE MOTOR STOPPED COMPLETELY .
4. PLEASE OPERATE THE MACHINES AT THE SPEED UNDER 6000 RPM. FOR THE
FIRST MONTH USAGE FOR NEW MACHINE .
5. WHEN ADDING LUBRICATION OIL , PLEASE MAKE SURE NOT TO OVER THE UPPER
LIMIT MARK OF OIL WINDOW .
6. BEFORE OPERATING THE NEW MACHINE , PLEASE ADD ONE DROP OF LUBRICATION
OIL ON THE UPPER LOOPER DRIVING ROD .
7. BEFORE OPERATING , PLEASE MAKE SURE SEWING NEEDLES DID NOT BENT NEEDLE
POINT DID NOT BREAK AND NEEDLES FACE THE CORRECT DIRECTION .
8. PLEASE MAKE SURE THE THREADING IS CORRECT .
9. AFTER SEWING OPERATION , MUST CLEAN THE MACHINE AND PUT ON DUST COVER .

UH9000 系列機型車型編號系統 Description of the UH9000 series code



UH9000 SERIES MACHINE NUMBERING SYSTEM



UH9300 系列機型規格表 UH9300 SUBCLASS SPECIFICATIONS

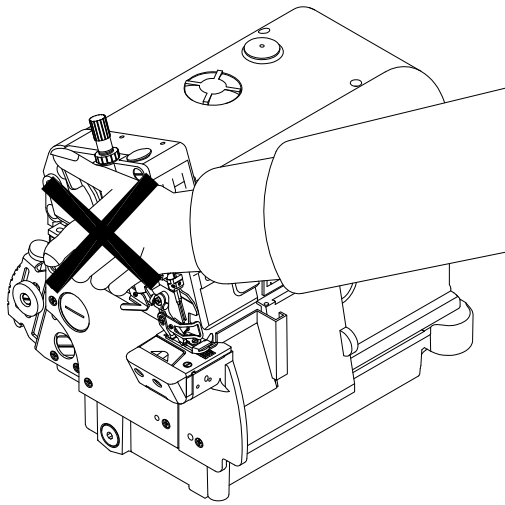
| 適用範圍 Application | 機型 Subclass | 縫針數 Number Of Needles | 縫線數 Number Of Threads | 針距 Needle Distance (mm) | 包邊寬 Overedge Width (mm) | 齒列數 Feed Dog Rows | 縫距 Stitch Length Max (mm) | 差動比 Diff. Feed Ratio | 壓腳提昇 Presserfoot Lift | 轉數 Max Speed (s.p.m) | 縫針 Needle Size | 標準配備 |
|------------------------------------|-----------------|--------------------------------|--------------------------------|----------------------------------|----------------------------------|-------------------------|------------------------------------|-------------------------------|-----------------------------|-------------------------------|----------------------|------|
| 一般包縫 Plain Seaming | UH9303-032-M04 | 1 | 3 | - | 3 | 2 | 3.8 | 0.8~1.8 | 6 | 7000 | DC*27#11 | |
| | UH9303-053-M04 | 1 | 3 | - | 5 | 3 | 3.8 | 0.8~1.8 | 6 | 7000 | DC*27#11 | |
| 盲縫 Blind Hemming | UH9313-032-L05 | 1 | 3 | - | 3 | 2 | 3.8 | 0.8~1.8 | 5 | 7000 | DC*27#9 | |
| 一般包縫 Plain Seaming | UH9304-233-M14 | 2 | 4 | 2.2 | 3 5 | 3 | 3.8 | 0.8~1.8 | 5.5 | 7000 | DC*27#11 | |
| | UH9304-243-M14 | 2 | 4 | 2.2 | 4 6 | 3 | 3.8 | 0.8~1.8 | 5.5 | 7000 | DC*27#11 | |
| | UH9304-253-M14 | 2 | 4 | 2.2 | 5 7 | 3 | 3.8 | 0.8~1.8 | 5.5 | 7000 | DC*27#11 | |
| 鬆緊帶包縫 Elastic Tape Attaching | UHD93A3-053-M04 | 1 | 3 | - | 5 | 3 | 3.8 | 0.8~1.8 | 6 | 7000 | DC*27#11 | |
| | UHD93A4-243-M14 | 2 | 4 | 2.2 | 4 6 | 3 | 3.8 | 0.8~1.8 | 5.5 | 7000 | DC*27#11 | |
| 接合 Butt-End Sewing | UH9302-032-M02 | 1 | 2 | - | 3 | 2 | 3.8 | 0.8~1.8 | 6 | 7000 | DC*27#11 | |
| | UH9302-053-M02 | 1 | 2 | - | 5 | 3 | 3.8 | 0.8~1.8 | 6 | 7000 | DC*27#11 | |

目 錄 CONTENTS

| | |
|--|----|
| 1. 安裝說明 | 2 |
| 1. INSTALLATION | 2 |
| 1-1 運搬 | 2 |
| 1-1 : MOVING | 2 |
| 1-2 架設托底板與導布屑 | 2 |
| 1-2 : INSTALLATION OF FRAME SUPPORT PLATE AND WASTE CHUTE | 2 |
| 1-3 安裝縫機本體 | 2 |
| 1-3 : INSTALLATION OF SEWING MACHINE | 2 |
| 1-4 安裝三角皮帶 | 4 |
| 1-4 : INSTALLATION OF MOTOR BELT | 4 |
| 1-5 安裝皮帶護蓋 | 4 |
| 1-5 : INSTALLATION OF BELT COVER | 4 |
| 2. 使用前注意事項 | 6 |
| 2. BEFORE OPERATION | 6 |
| 2-1 皮帶輪旋向 | 6 |
| 2-1 : TURNING DIRECTION OF BELT PULLEY | 6 |
| 2-2 添加潤滑油與矽油 | 6 |
| 2-2 : ADDING LUBRICATION OIL AND SILICON OIL | 6 |
| 3. 試縫及調整 | 8 |
| 3. TEST SEWING AND ADJUSTING | 8 |
| 3-1 穿線圖 | 8 |
| 3-1 : THREADING MAP | 8 |
| 3-2 說明 | 10 |
| 3-2 : DESCRIPTION | 10 |
| 3-3 開閉面蓋 | 10 |
| 3-3 : OPEN AND CLOSE FRONT COVER | 10 |
| 3-4 開閉壓腳臂及調整壓力 | 10 |
| 3-4 : OPEN AND CLOSE THE PRESSER FOOT ARM AND ADJUSTING PRESSURE | 10 |
| 3-5 調整縫目節距及差動量 | 12 |
| 3-5 : ADJUSTING STITCH LENGTH AND DIFFERENTIAL RATIO | 12 |
| 3-6 調整縫線張力與收放線量 | 14 |
| 3-6 : ADJUSTING THREAD TENSION AND THREAD TENSION AMOUNT | 14 |
| 4. 維修與保養 | 16 |
| 4. REPAIRING AND MAINTENANCE | 16 |
| 4-1 更換潤滑油, 濾清器與縫針 | 16 |
| 4-1 : CHANGING LUBRICATION OIL , OIL FILTER AND NEEDLES | 16 |
| 4-2 更換上, 下刀片 | 18 |
| 4-2 : CHANGING UPPER KNIFE AND LOWER KNIFE | 18 |
| 4-3 更換送布齒與調整 | 20 |
| 4-3 : CHANGING AND ADJUSTING FEED DOGS | 20 |
| 4-4 更換壓腳組與調整 | 22 |
| 4-4 : CHANGING AND ADJUSTING PRESSER FOOT SET | 22 |
| 4-5 調整壓腳提昇量 | 24 |
| 4-5 : ADJUSTING THE LIFTING HEIGHT OF PRESSER FOOT | 24 |
| 4-6 調整縫針針尖高度 | 24 |
| 4-6 : ADJUSTING THE HEIGHT OF NEEDLE | 24 |
| 4-7 更換結線鈎 | 26 |
| 4-7 : CHANGING LOOPERS | 26 |
| 4-7-1 更換下結線鈎 | 26 |
| 4-7-1 : CHANGING LOWER LOOPER | 26 |
| 4-7-2 更換上結線鈎 | 26 |
| 4-7-2 : CHANGING UPPER LOOPER | 26 |
| 4-8 更換導針器 | 26 |
| 4-8 : CHANGING NEEDLE GUARD | 26 |
| 4-9 設定結線鈎與導針器 | 28 |
| 4-9 : SETTING UP LOOPER AND NEEDLE GUARD | 28 |
| 4-9-1 設定下結線鈎 | 28 |
| 4-9-1 : SETTING UP LOWER LOOPER | 28 |
| 4-9-2 設定鎖邊用針導針器 | 28 |
| 4-9-2 : SETTING UP NEEDLE GUARD OF EDGING NEEDLE | 28 |
| 4-9-3 設定上結線鈎 | 30 |
| 4-9-3 : SETTING UP UPPER LOOPER | 30 |

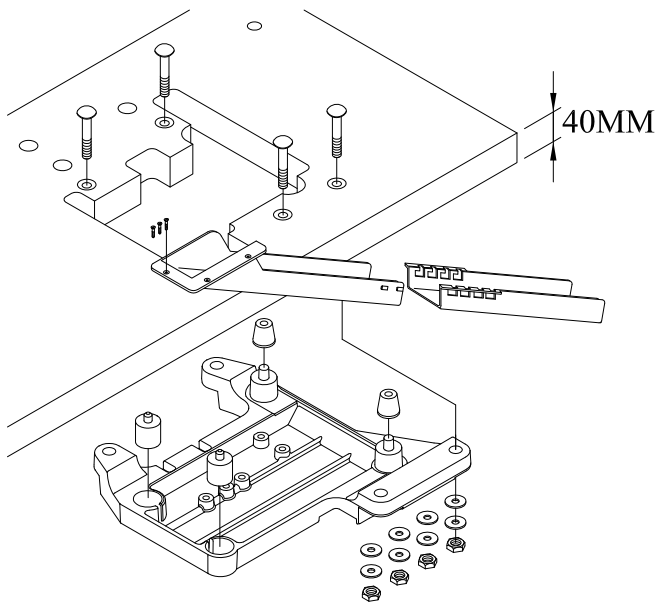
1. 安裝說明

1-1 運搬



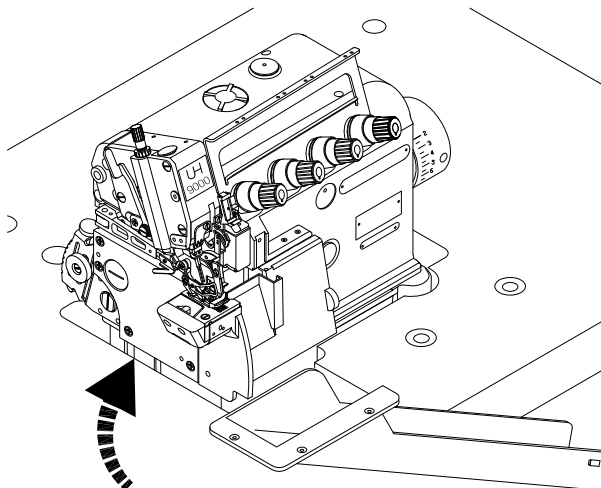
縫機拆箱運搬過程裡, 切不可扶持壓腳臂下方。

1-2 架設托底板與導布屑



請使用厚度為 40MM 的標準車板

1-3 安裝縫機本體

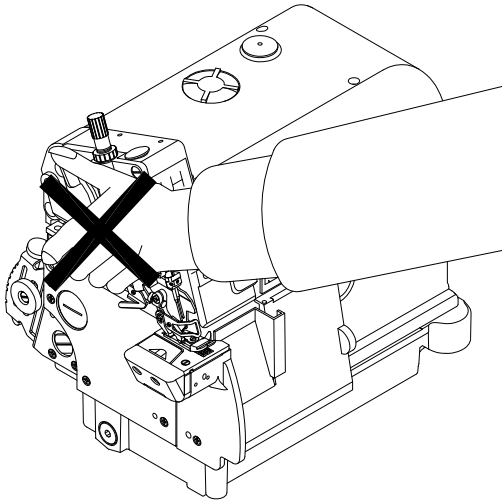


縫機本體架上車板上後必須再確認, 本體與車板四周要有足夠的間隙。

本體與車板不得干涉

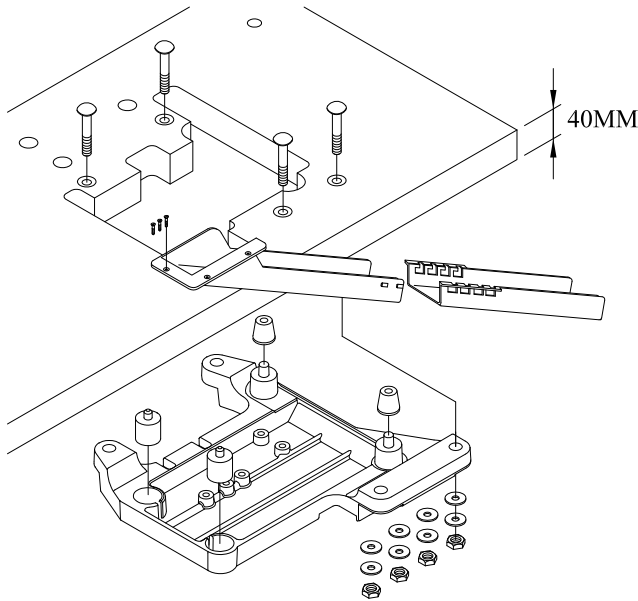
1. INSTALLATION

1-1 MOVING :



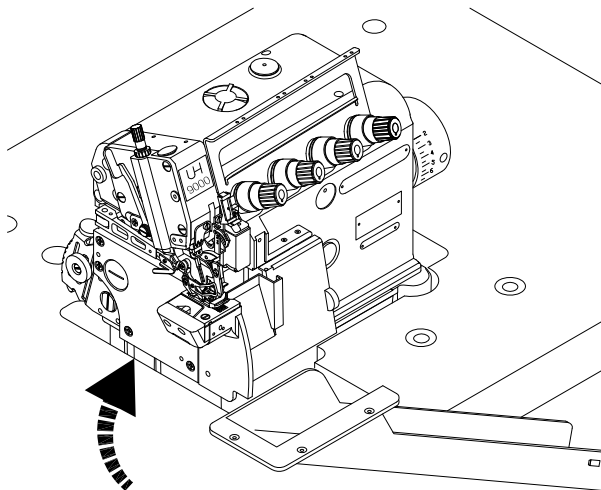
DURING INSTALLATION PROCESS , DO NOT MOVE SEWING MACHINE BY HOLDING PRESSER ARM .

1-2 INSTALLATION OF FRAME SUPPORT PLATE AND WASTE CHUTE :



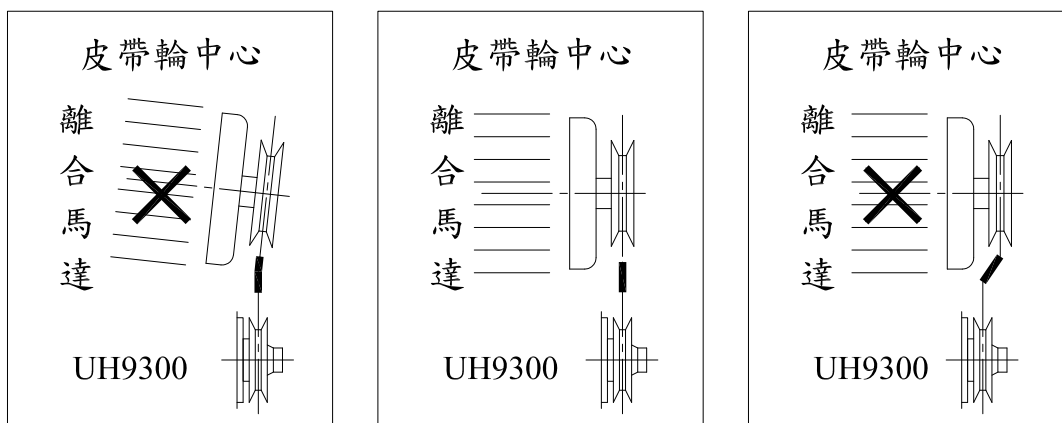
PLEASE USING STANDARD TABLE OF 40MM IN THICKNESS .

1-3 INSTALLATION OF SEWING MACHINE :

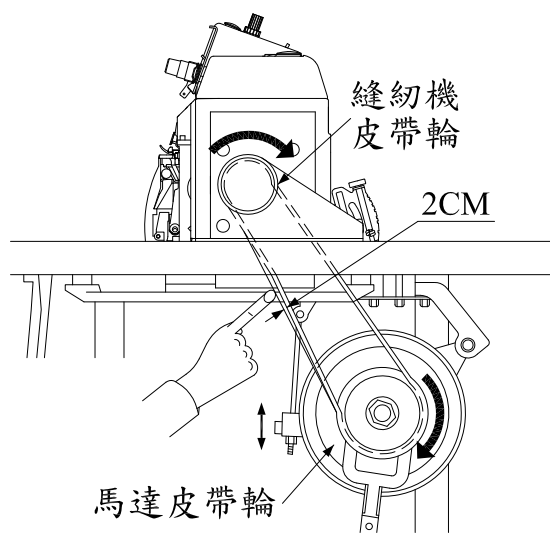


PLEASE MAKE SURE THERE HAVE ENOUGH ROOM BETWEEN SEWING MACHINE AND THE TABLE AROUND IT AFTER INSTALLATION . TABLE CAN NOT INTERFERENCE WITH THE SEWING MACHINE .

1-4 安裝三角皮帶

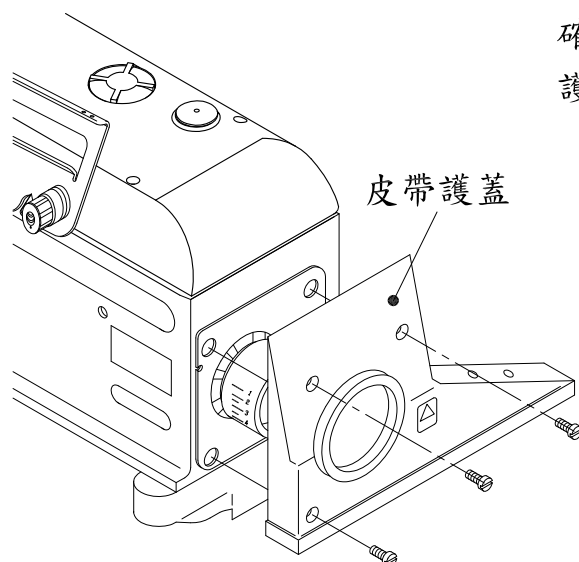


調整馬達的位置，使馬達上的皮帶輪平行，同時對正縫機本體上的皮帶輪。注意踩下踏板啟動馬達時，皮帶輪會向左移動。



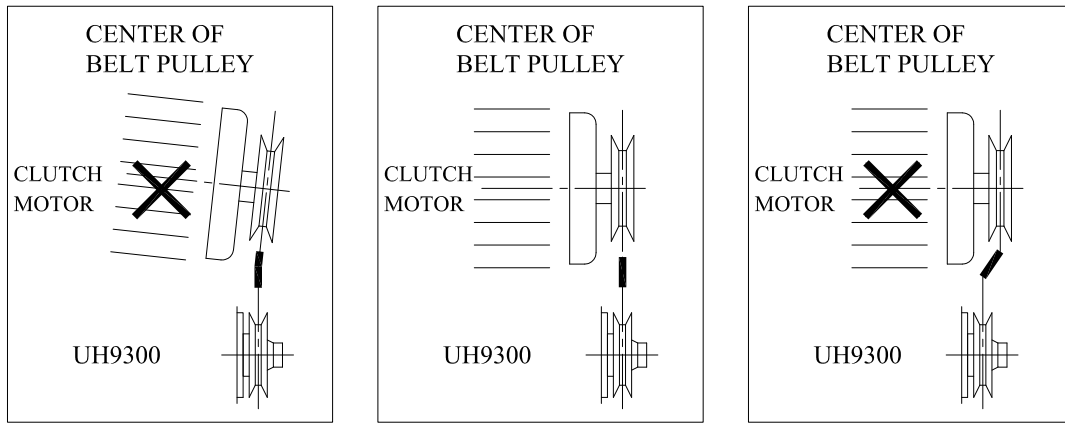
掛上傳動三角皮帶調整其鬆緊度，用手輕壓皮帶，約有 2CM 的鬆弛量。

1-5 安裝皮帶護蓋

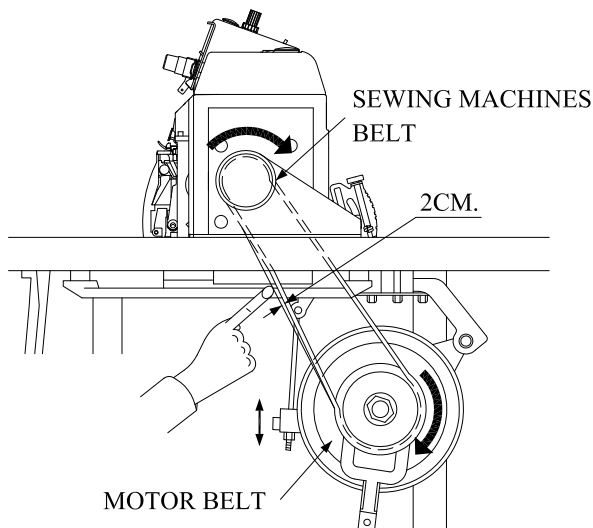


確保使用者的安全一定要鎖上皮帶護蓋。

1-4 INSTALLATION OF MOTOR BELT :

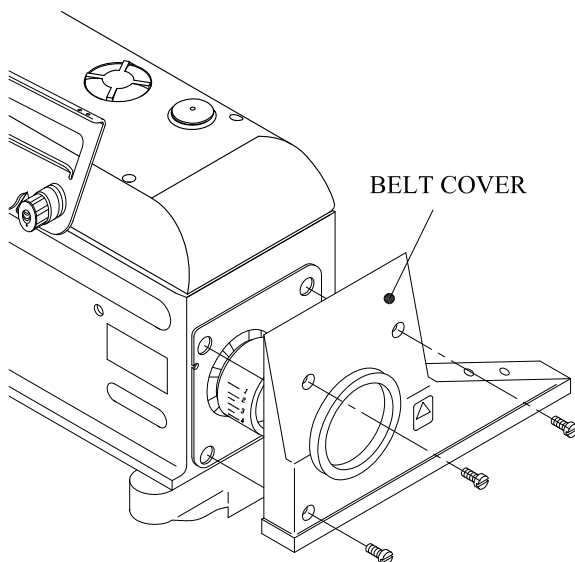


INSTALL MOTOR BELT AND MAKE SURE MOTOR BELT IN PARALLEL WITH BOTH PULLEY OF CLUTCH MOTOR AND SEWING MACHINE BY ADJUSTING CLUTCH MOTOR'S POSITION PROPERLY .



INSTALL MOTOR BELT AND MAKE SURE THERE HAVE 2CM. TOLERANCE BY PRESS THE MOTOR BELT .

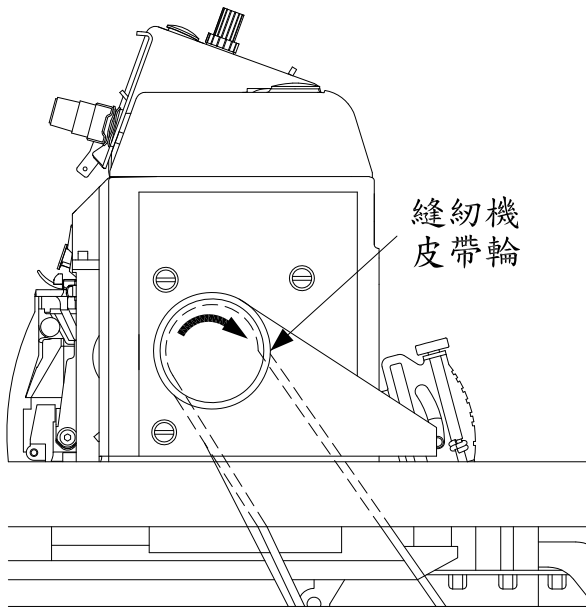
1-5 INSTALLATION OF BELT COVER :



FOR SAFTY REASON , BELT COVER MUST BE INSTALLED .

2. 使用前注意事項

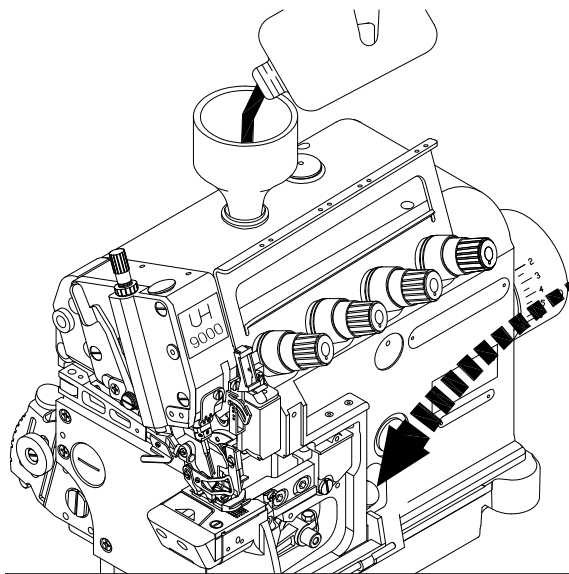
2-1 皮帶輪旋向



確認縫機的旋向如圖：2-1 箭頭所示，順時針方向。

2-2 添加潤滑油與矽油

添加潤滑油



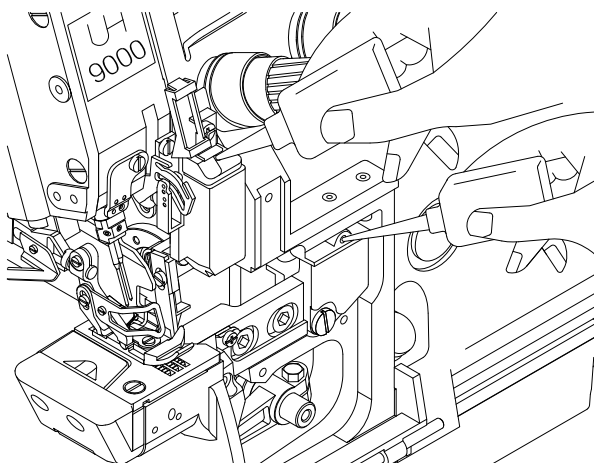
一面注入潤滑油，一面注意縫機本體上的油面鏡，切不可使油面超出上限。

潤滑油規格

Mobil velocte oil NO.10
(ISO/VG22)

或同等級的油品

添加矽油



為防止斷線，在矽油壺內加注適量的矽油。

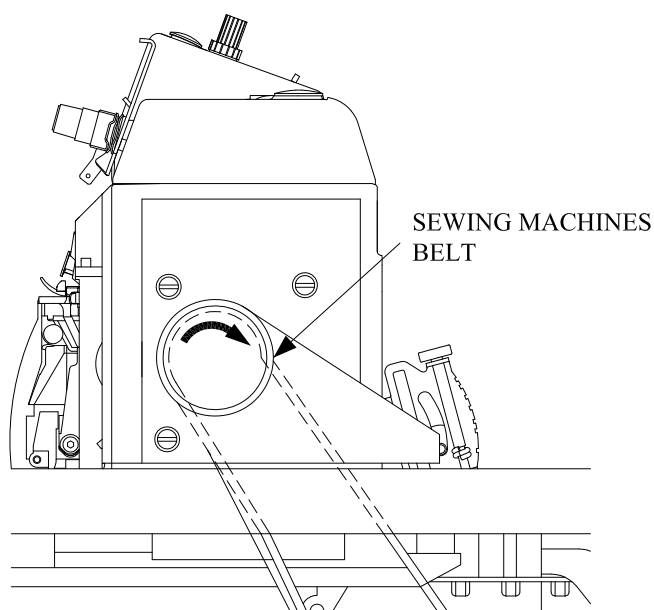
矽油規格

UNION CARBIDE CORP
UCCL-45(10)

或同等級的油品

2. BEFORE OPERATION

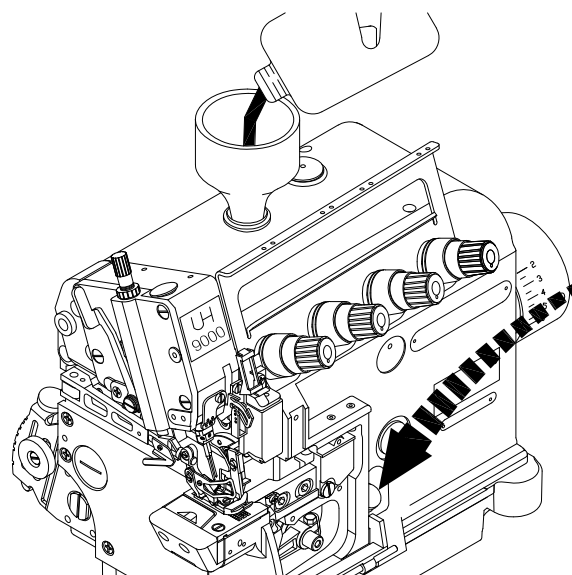
2-1 TURNING DIRECTION OF BELT PULLEY :



PLEASE MAKE SURE SEWING MACHINES BELT PULLEY IS TURNING CLOCKWISE . AS FIGURE 2-1 .

2-2 ADDING LUBRICATION OIL AND SILICON OIL :

ADDING LUBRICATION OIL

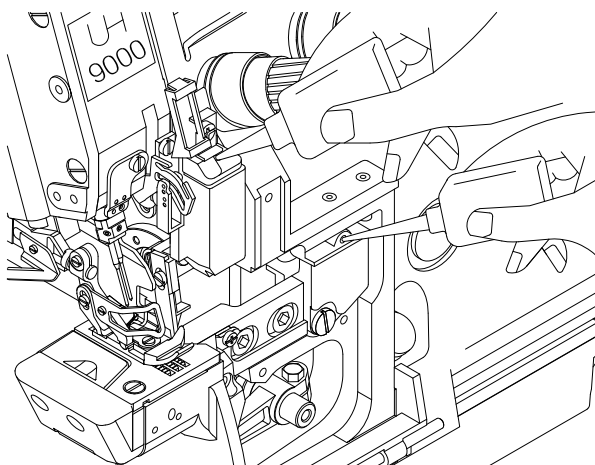


DURING ADDING PROCESS , PLEASE MAKE SURE THE LUBRICATION OIL CAN NOT OVER THE UPPER LIMIT OF OIL GAUGE .



SPECIFICATION OF LUBRICATION OIL : MOBIL VELOCITE OIL NO.10 (ISO/VG22) . OR SAME SPECIFICATION OF OTHER BRAND'S OIL .

ADDING SILICON OIL



PLEASE ADD PROPER SILICON OIL INTO SILICON OIL RESERVOIRS IN ORDER TO PREVENT THREAD BREAKAGE .

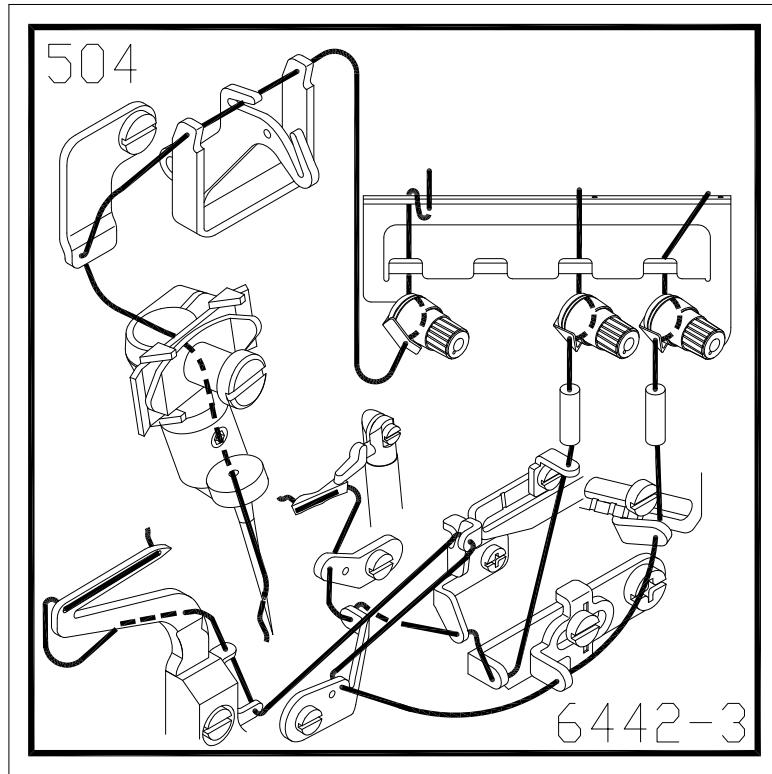
SPECIFICATION OF SILICON OIL : UNION CARBIDE CORP . UCCL-45 (10) OR SAME SPECIFICATION OF OTHER BRAND'S SILICON OIL .

3. 試縫及調整

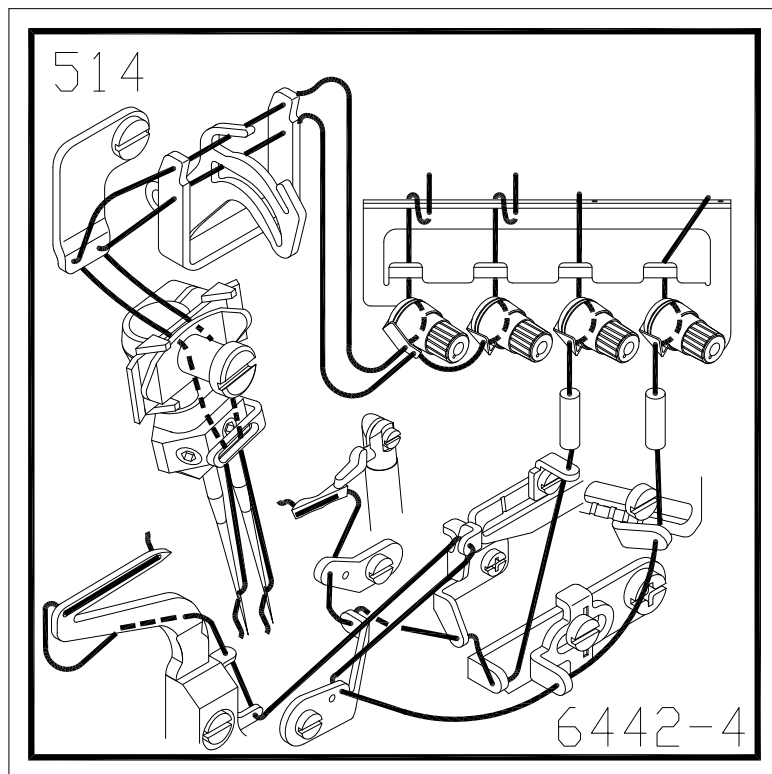
3-1 穿線圖

穿線錯誤會造成斷線跳針或是縫製瑕疵,務必參照附圖正確穿線。

UH9303 線跡形式 504



UH9304 線跡形式 514

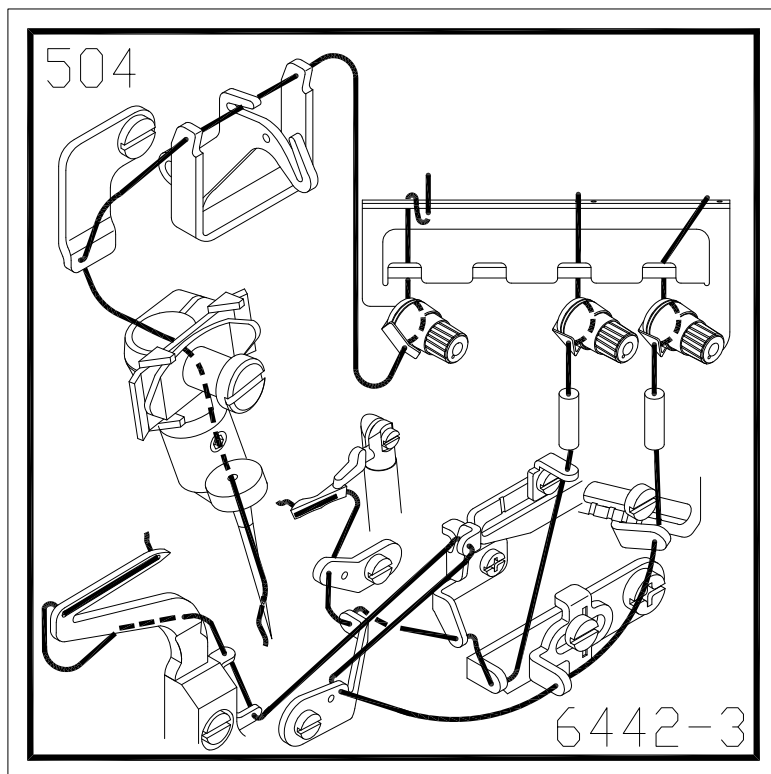


3. TEST SEWING AND ADJUSTING

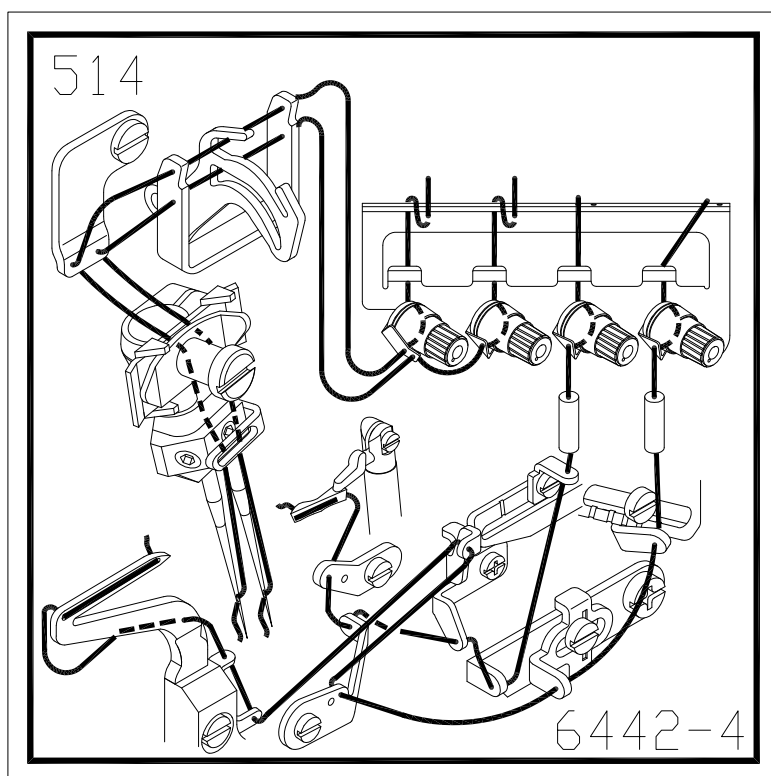
3-1 THREADING MAP :

MISTREADING WILL CAUSE THREAD BREAKAGE , SKIP STITCH OR OTHER SEWING DEFECTS , THUS , PLEASE MAKE SURE FOLLOW THE THREADING MAP AND THREADING PROPERLY .

UH9303 . STITCH TYPE 504 .

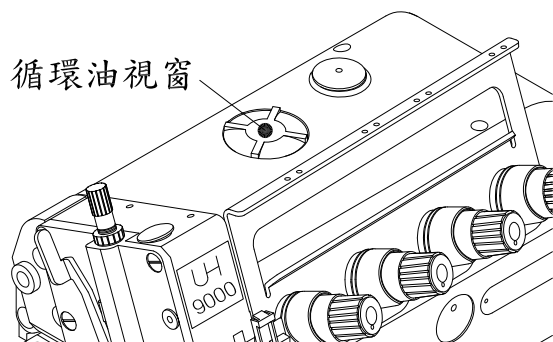


UH9304 . STITCH TYPE 514 .



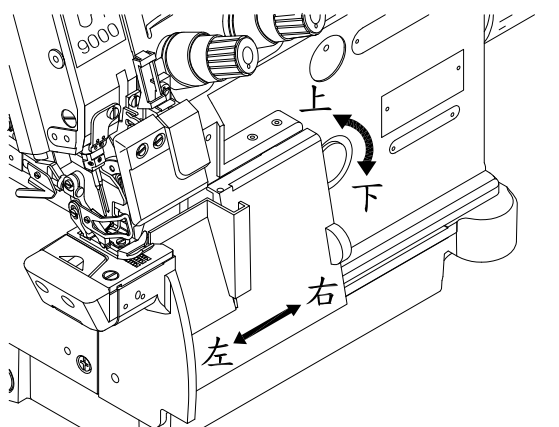
3-2 說明

在出廠時本縫機即以一般常用的縫製條件下做最佳化的調整，但是各個使用者不同的縫製條件，例如：裁片、縫線等，對縫機可能要做少許的調整，請依下述方法來進行。



第一次啟動縫機時，請先確認潤滑油在迴路中是否確實循環。

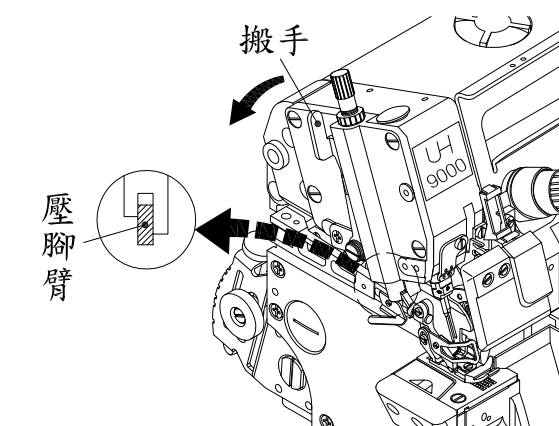
3-3 開閉面蓋



將面蓋向右推到定位後，即可向下打開。反之向上掀起面蓋到定位後，即可向左閉合。

注意確定面蓋閉合後，不會與其它活動件干涉。

3-4 開閉壓腳臂及調整壓力

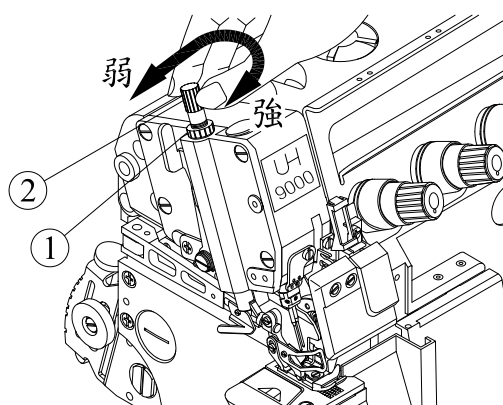


開閉壓腳臂

將搬手依箭頭方向壓到定位，即可取出壓腳臂。

反之將搬手壓到定位後，放進壓腳臂再放鬆搬手。

注意必須再確認壓腳臂進入定位。



放鬆固定螺帽 ① 調整壓力

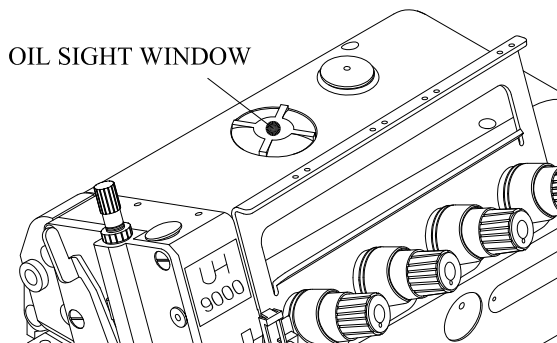
順時鐘方向旋轉螺樁 ②，加大壓力。

逆時鐘方向旋轉螺樁 ②，減小壓力。

調整後必須確認鎖緊固定螺帽 ①

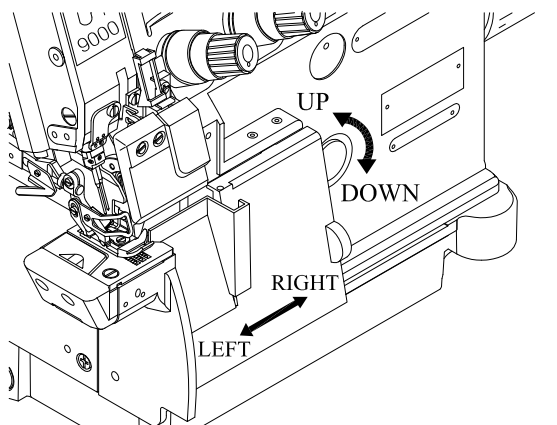
3-2 DESCRIPTION :

EVEN THOUGH THE MACHINE IS UNDER ITS BEST NORMAL SEWING CONDITION WHEN OUT OF THE FACTORY , HOWEVER , DUE TO DIFFERENT SEWING REQUIREMENT , SUCH AS SEWING FABRICS , SEWING THREADS , IT MAY REQUIRED MINOR ADJUSTMENTS ON SEWING MACHINES AS FOLLOWS :



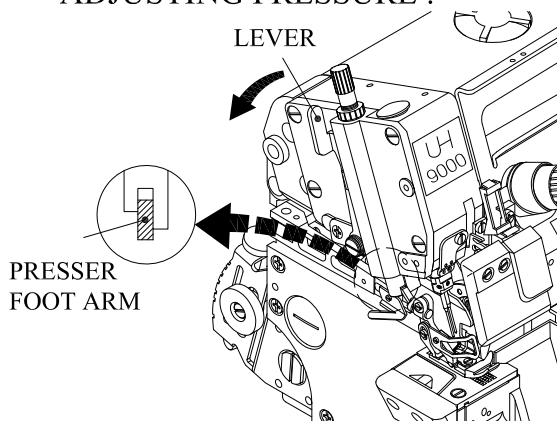
DURING THE FIRST USAGE , PLEASE MAKE SURE LUBRICATION OIL CIRCULATES PROPERLY .

3-3 OPEN AND CLOSE FRONT COVER :

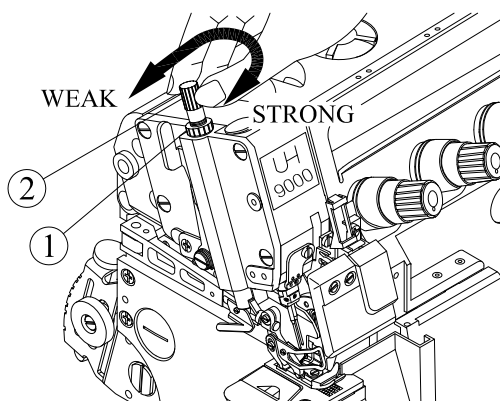


PUSHING FRONT COVER TO RIGHT SET POSITION AND PULL DOWN TO OPEN IT . AND ON THE OTHER HAND , PULL UP TO ITS SET POSITION AND TO LEFT IN ORDER TO CLOSE FRONT COVER . AFTER CLOSING FRONT COVER , PLEASE MAKE SURE THERE IS NO INTERFERENCE BETWEEN FRONT COVER AND OTHER PARTS .

3-4 OPEN AND CLOSE THE PRESSER FOOT ARM AND ADJUSTING PRESSURE :



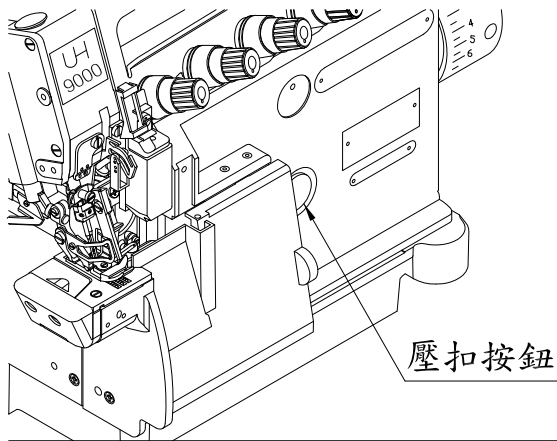
OPEN AND CLOSE THE PRESSER FOOT ARM : PUSH LEVER DOWN TO ITS SET POSITION THEN TAKE OUT PRESSER FOOT ARM . VICE VERSA , PUSH DOWN LEVER TO ITS SET POSITION , CAN PUT PRESSER FOOT ARM BACK . WHEN PUT PRESSER FOOT ARM BACK , PLEASE MAKE SURE IT WILL BE BACK TO ITS SET POSITION .



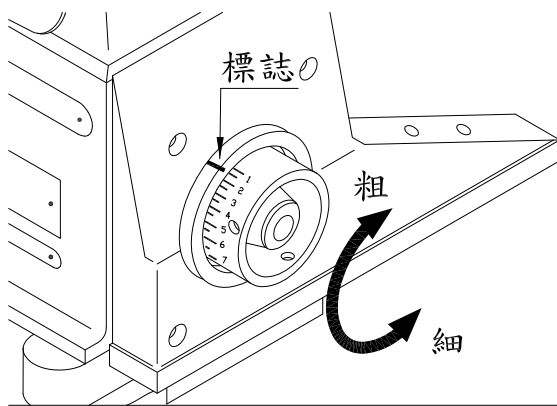
ADJUSTING PRESSURE : TURNING ADJUSTING SCREW CLOCKWISE IN ORDER TO INCREASE PRESSURE . TURNING ADJUSTING SCREW COUNTERCLOCKWISE IN ORDER TO DECREASE PRESSURE .

3-5 調整縫目節距及差動量

調整縫目節距

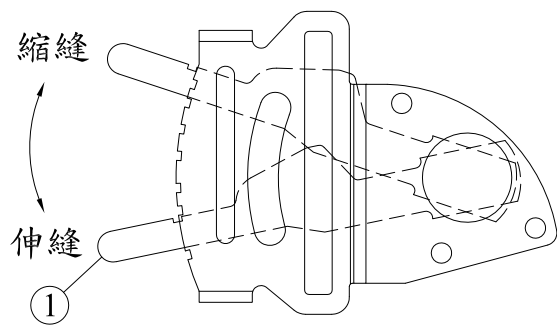


左手輕輕壓下壓扣按鈕，右手一面旋轉手輪，在某一個部位上可將壓扣按鈕壓入卡榫槽內，用力壓著壓扣按鈕，同時參照下圖旋轉手輪，調整縫目節距的粗細。

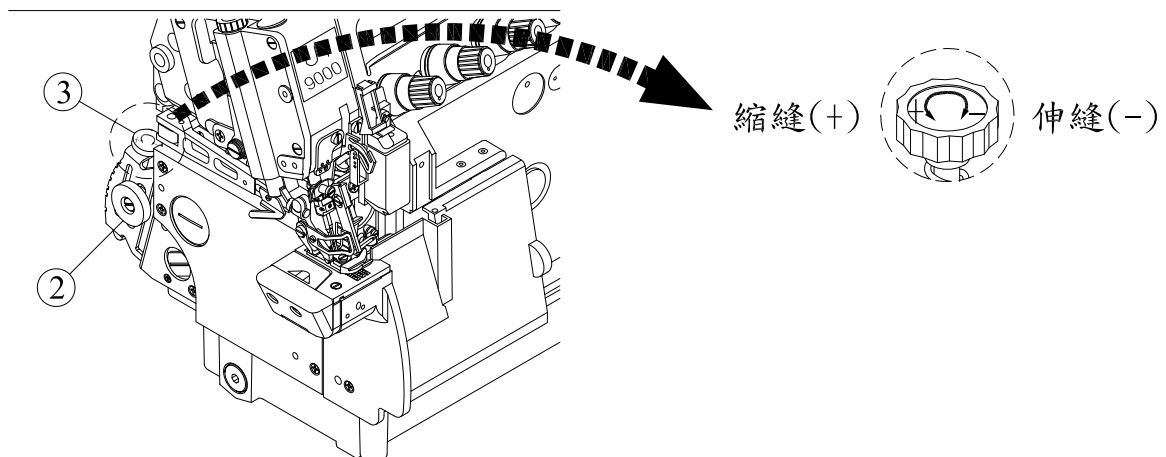


註：手輪上的刻線僅代表縫目節距的大約長度，必須經過試縫後才能找到最適當的縫目節距。

調整差動量

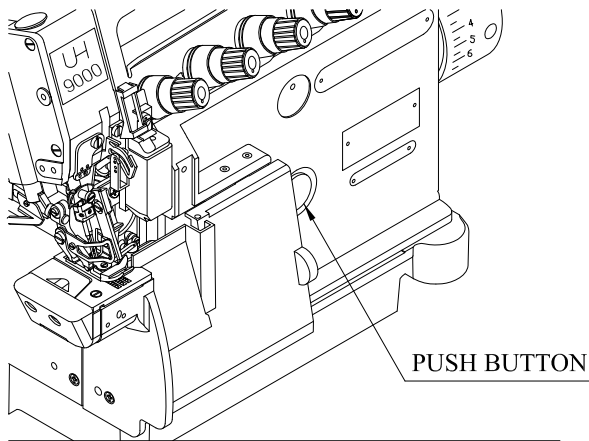


出廠時本縫機設定差動比為 1:1，有必要調整時請參照前節說明。放鬆螺帽 ②，上下移動調整搬手 ①，到適當位置再鎖緊螺帽 ②。需要做微量調整時可旋轉調整旋鈕 ③。

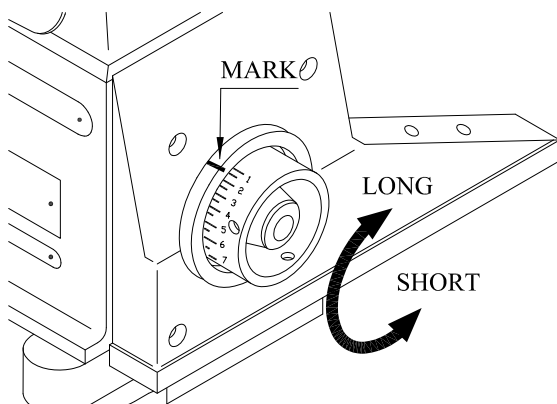


3-5 ADJUSTING STITCH LENGTH AND DIFFERENTIAL RATIO :

ADJUSTING STITCH LENGTH :

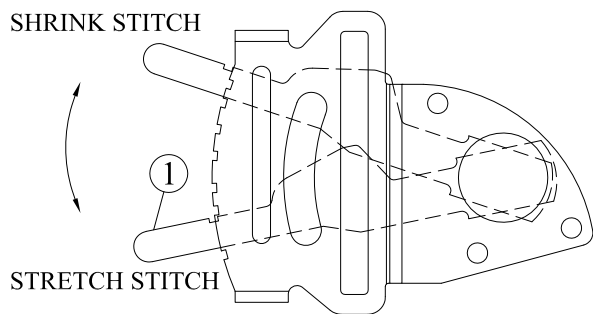


PUSHING THE PUSH BUTTON LIGHTLY FIRST AND TURNING PULLEY TO SET POSITION THEN PUSHING DOWN THE PUSH BUTTON INTO ITS SET POSITION AND ADJUST THE LENGTH OF STITCH .

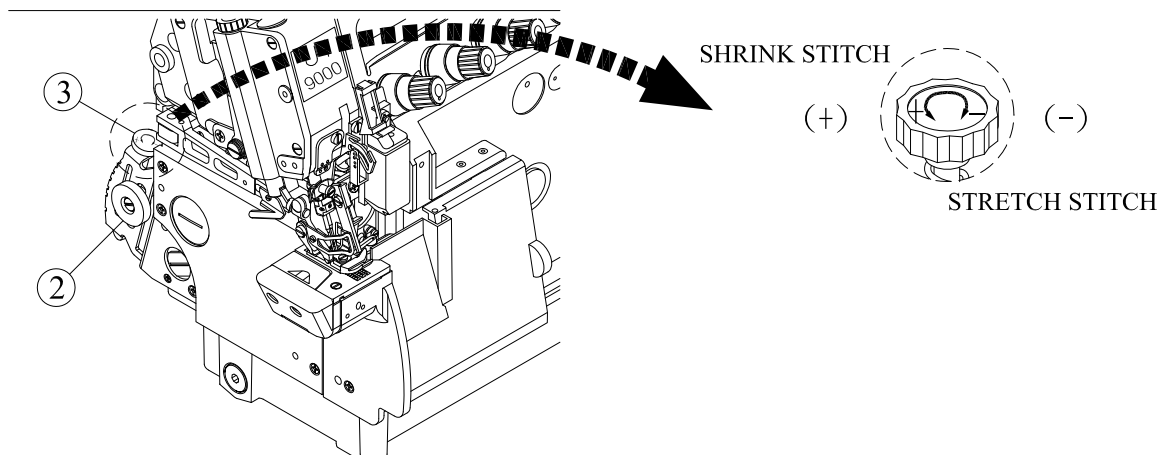


REMARK : THE DISTANCE MARK ON THE PULLEY ONLY REPRESENT APPROX LENGTH OF STITCH AND ACTUAL STITCH LENGTH NEEDED SHOULD GET FROM TEST SEWING .

ADJUSTING DIFFERENTIAL RATIO :

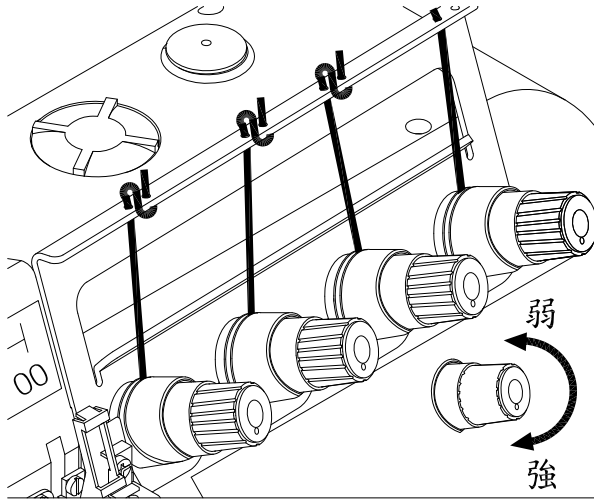


DIFFERENTIAL RATIO WAS SET AT 1 : 1 WHEN MACHINES WERE OUT OF FACTORY . ADJUST DIFFERENTIAL RATIO AS NEEDED . LOOSEN NUT (2) MOVE LEVEL (1) UPWARD OR DOWNWARD TO THE POSITION NEEDED . THEN TIGHTEN NUT (2) . FOR MICRO-ADJUSTMENT PLEASE TURN ADJUSTING SCREW (3) .



3-6 調整縫線張力與收放量

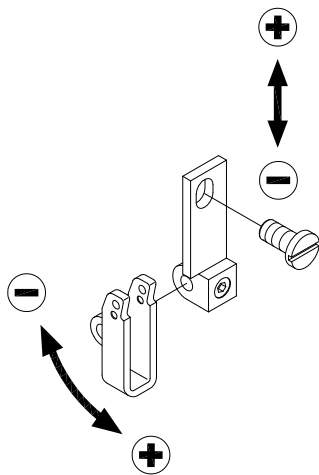
調整縫線張力



縫線的張力與縫線的收放量息息相關，請同時參照本項與下一項，縫線收放量調整，來做最適當的設定

順時針旋轉張力控制螺帽，縫線張力加大，反之減弱。

針線收放量

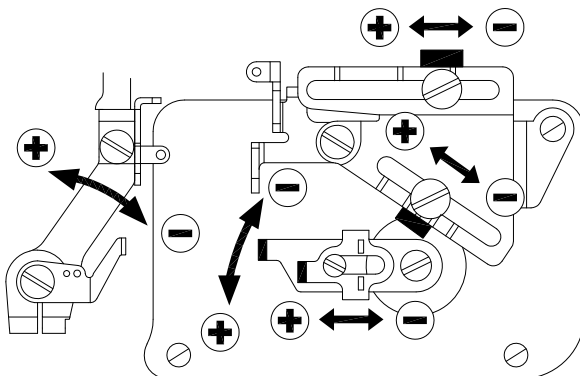


為 UH9303, UH9304 用。

向 ⊕ 方向調整放線量加大。

向 ⊖ 方向調整放線量縮小。

上下結線鉤縫線收放量



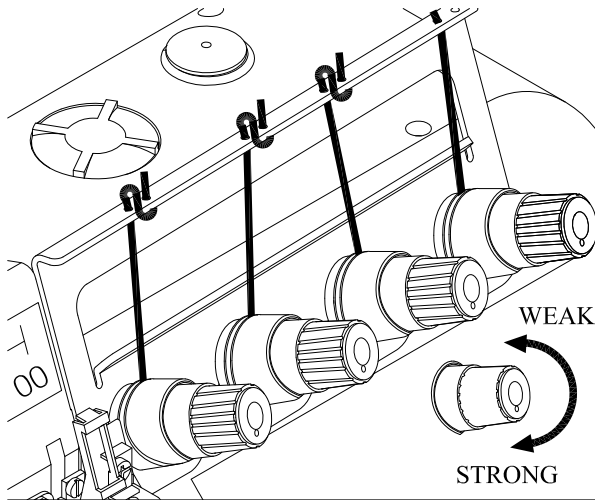
依照箭頭指示方向增減收放量。

⊕ 增加收放量。

⊖ 減少收放量。

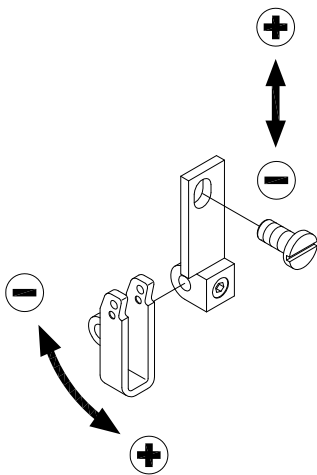
3-6 ADJUSTING THREAD TENSION AND THREAD TENSION AMOUNT :

ADJUSTING THREAD TENSION :



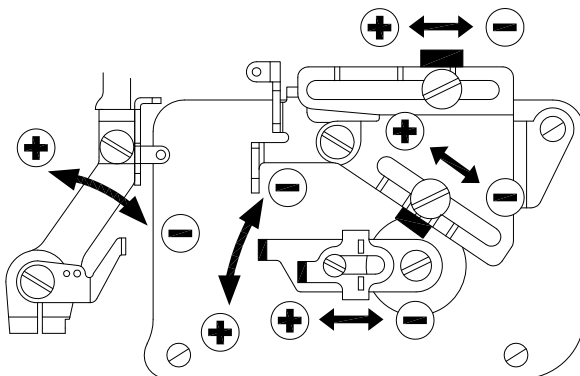
THREAD TENSION CORRELATE WITH THREAD TENSION AMOUNT . PLEASE REFER TO THIS ITEM AND NEXT ITEM TO ADJUST THREAD TENSION AMOUNT IN ORDER TO GET BEST RESULT .
TURNING CLOCKWISE IN ORDER TO GET STRONG THREAD TENSION .
TURNING COUNTERCLOCKWISE IN ORDER TO GET WEAK THREAD TENSION .

NEEDLE THREAD TENSION AMOUNT :



FOR UH9303 , UH9304 USAGE .
TOWARD (+) DIRECTION GET BIGGER THREAD TENSION AMOUNT .
TOWARD (-) DIRECTION GET SMALLER THREAD TENSION AMOUNT .

UPPER / LOWER LOOPER THREAD TENSION AMOUNT :

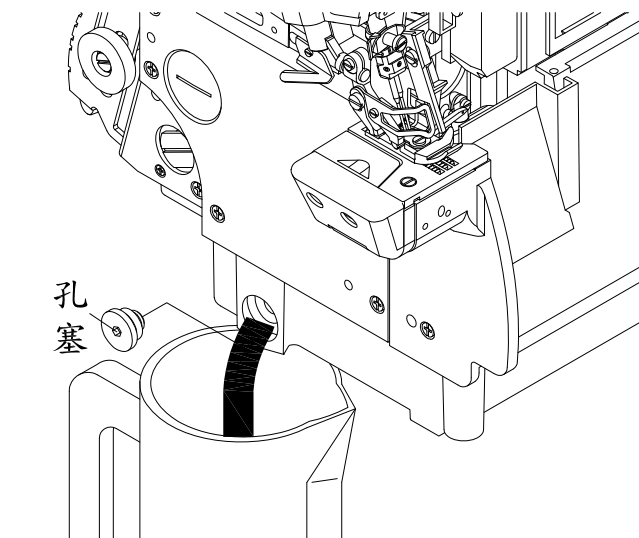


PLEASE ADJUST TENSION AMOUNT ACCORDING TO ARROW DIRECTION
(+) INCREASE LOOPER THREAD TENSION AMOUNT .
(-) DECREASE LOOPER THREAD TENSION AMOUNT .

4. 維修與保養

4-1 更換潤滑油, 濾清器與縫針

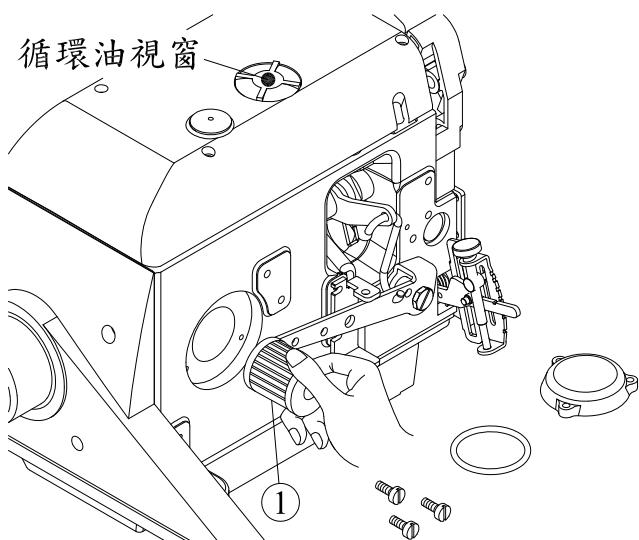
更換潤滑油



縫機開始使用後 160-200 小時, 約一個月必須更換潤滑油, 此後每六個月必須更換潤滑油。如果長期停機, 再次使用時必須更換潤滑油。

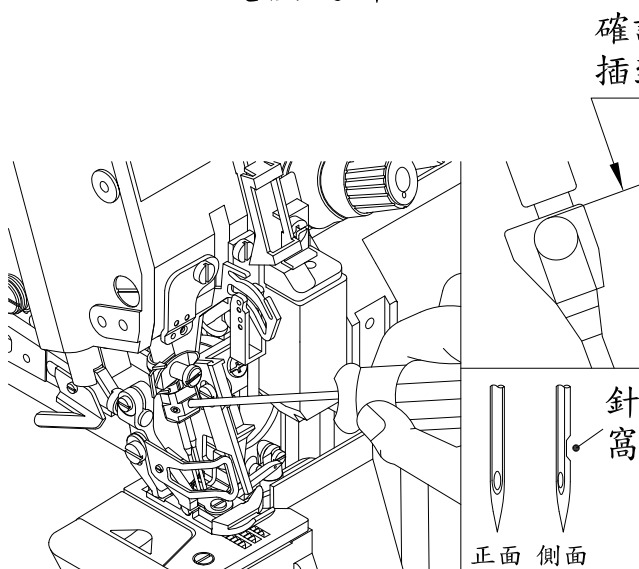
打開孔塞即可排放潤滑油。

更換濾清器



縫機使用約六個月後, 或是由循環油視窗發現噴油量不正常, 請立即更換濾清器 ①。

更換縫針



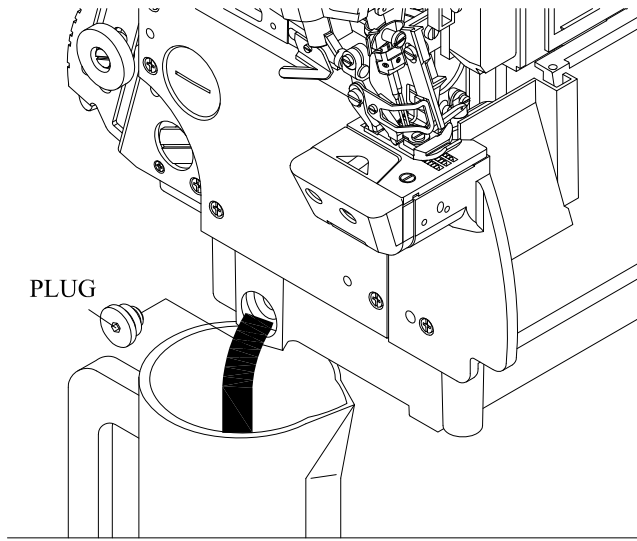
確認縫針
插到孔底

更換縫針時, 必須確認針窩在正後方, 同時確認縫針的針頭, 完全的進到針孔的底部。

4. REPAIRING AND MAINTENANCE

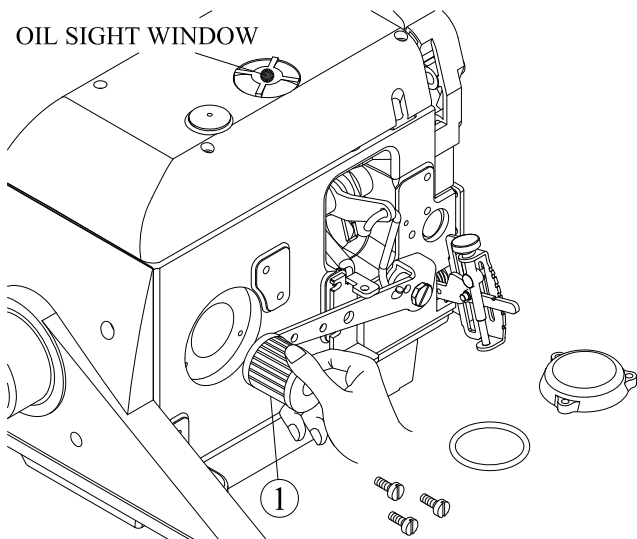
4-1 CHANGING LUBRICATION OIL , OIL FILTER AND NEEDLES :

CHANGE LUBRICATION OIL :



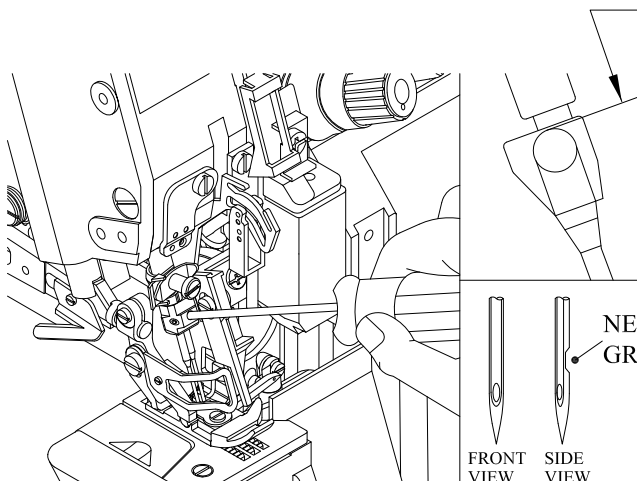
AFTER OPERATING SEWING MACHINE FOR 160-200 HOURS (APPROX ONE MONTH .) PLEASE CHANGE LUBRICATION OIL AND CHANGE LUBRICATION OIL EVERY 6 MONTHS THEREAFTER . IF STOP USING SEWING MACHINE FOR A LONG TIME , PLEASE CHANGE LUBRICATION OIL BEFORE OPERATE AGAIN . CHANGE LUBRICATION OIL BY TAKE OFF PLUG .

CHANGE OIL FILTER :



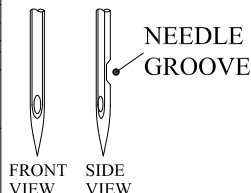
PLEASE CHANGE OIL FILTER AFTER APPROX 6 MONTHS USAGE OR FOUND OUT OIL CIRCULATION WAS NOT NORMAL FROM OIL SIGHT WINDOW .

CHANGE NEEDLES :



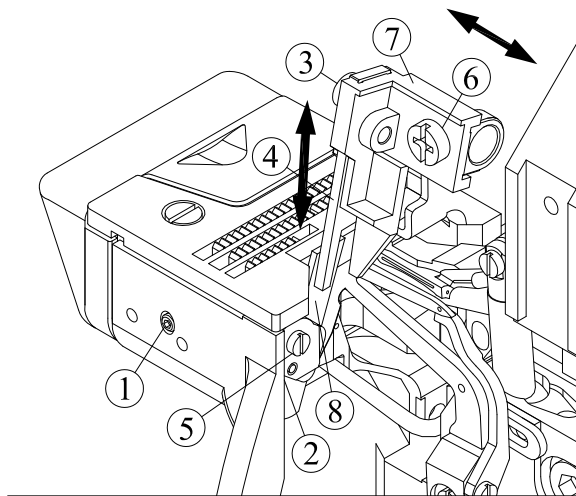
MAKE SURE TO INSERT NEEDLES ALL THE WAY TO THE BOTTOM OF NEEDLE HOLES .

WHEN CHANGING NEEDLES , PLEASE MAKE SURE NEEDLE GROOVE IS IN ITS CORRENT POSITION AND ALSO MAKE SURE NEEDLES BE INSERTED ALL THE WAY TO THE BOTTOM OF NEEDLE HOLES .



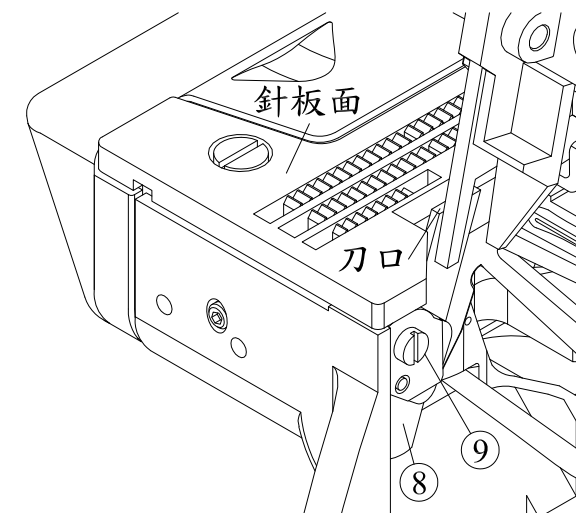
4-2 更換上,下刀片

更換上刀片

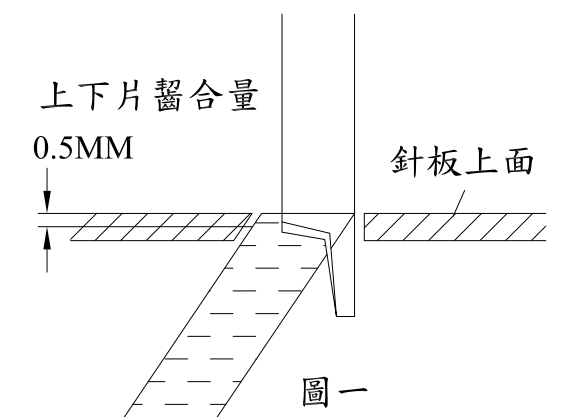


- 放鬆螺絲 ① 將下刀架 ② 推向左邊輕輕鎖緊螺絲。
- 取下螺絲 ③ 換上新刀片 ④ 後, 輕輕鎖緊螺絲。
- 放鬆螺絲 ① 使下刀片 ⑧ 貼緊上刀片 ④。
- 旋轉手輪降下上刀架 ⑦ 到最低點上下調整上刀片 ④ 的位置, 使上下刀片齧合量為 0.5MM。
- 鎖緊螺絲 ③, ①。參照圖一

更換下刀片

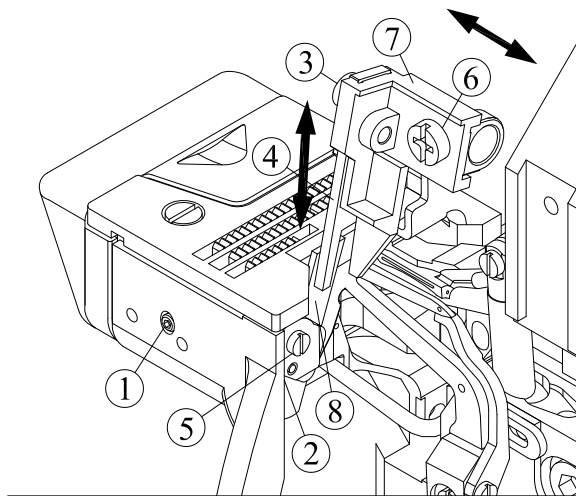


- 放鬆螺絲 ① 將下刀架 ② 推向左邊輕輕鎖緊螺絲。
- 放鬆螺絲 ⑨ 向下抽出下刀片 ⑧, 換上新刀片。
- 設定下刀刀口與針板上表面平齊後, 鎖緊螺絲 ⑨。
- 放鬆螺絲 ① 使下刀片 ⑧ 貼緊上刀片 ④ 後, 鎖緊螺絲 ①。參照圖一



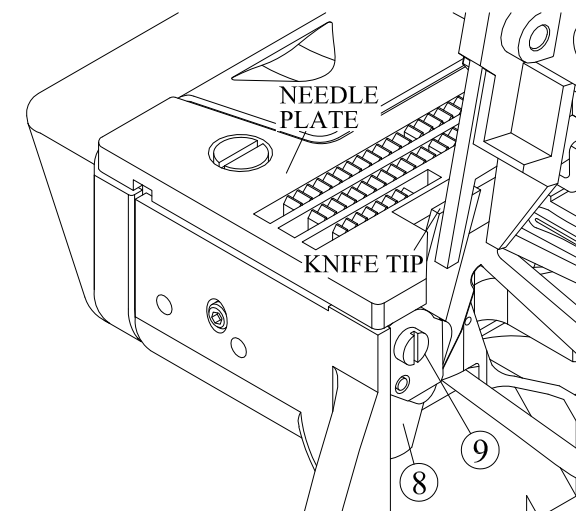
4-2 CHANGING UPPER KNIFE AND LOWER KNIFE :

CHANGING UPPER KNIFE :

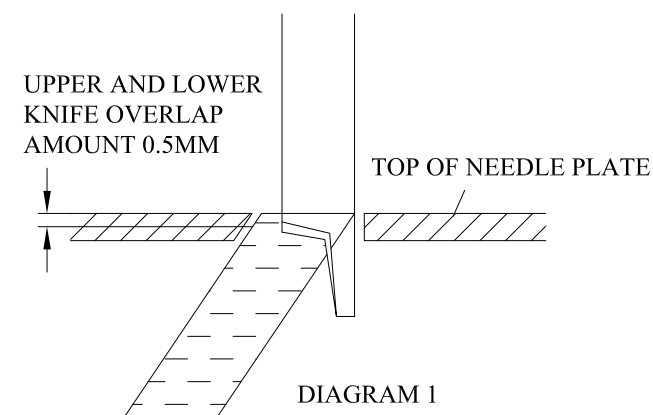


- A . LOOSEN SCREW (1) PUSH LOWER KNIFE HOLDER (2) TO LEFT , THEN , TIGHTEN SCREW (1) LIGHTLY .
- B . TAKE OFF SCREW (3) CHANGE NEW UPPER KNIFE (4) . THEN , TIGHTEN SCREW (3) LIGHTLY .
- C . LOOSEN SCREW (1) MAKE SURE LOWER KNIFE (8) TOUCH UPPER KNIFE CLOSELY .
- D . TURNING HAND WHEEL TILL UPPER KNIFE CLAMP REACH ITS LOWEST POSITION . THEN , ADJUSTING THE POSITION OF UPPER KNIFE IN ORDER TO MAKE SURE UPPER KNIFE AND LOWER KNIFE OVERLAP BY 0.5MM .
- E . TIGHTEN SCREW (3) , (1) .

CHANGING LOWER KNIFE :

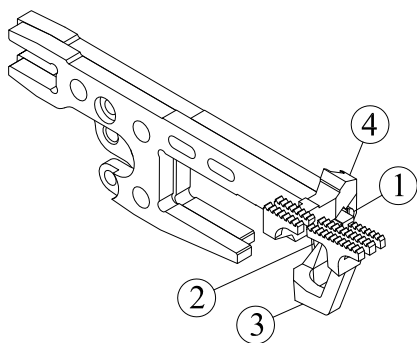


- A . LOOSEN SCREW (1) PUSH LOWER KNIFE HOLDER (2) TO LEFT , THEN , TIGHTEN SCREW (1) LIGHTLY .
- B . LOOSEN SCREW (9) TAKE OFF OLD LOWER KNIFE (8) AND CHANGE NEW LOWER KNIFE .
- C . MAKE SURE THE TIP OF LOWER KNIFE LINE EVEN WITH THE TOP OF NEEDLE PLATE . THEN , TIGHTEN SCREW (9) .
- D . LOOSEN SCREW (1) MAKE SURE LOWER KNIFE TOUCH UPPER KNIFE (4) CLOSELY . THEN , TIGHTEN SCREW (1) .



4-3 更換送布齒與調整

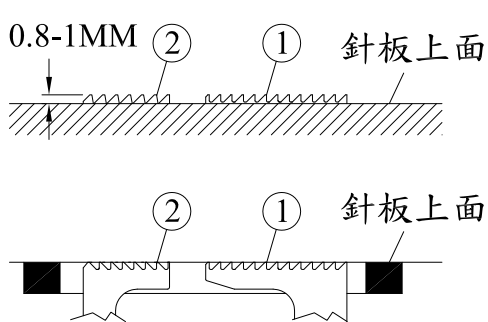
更換送布齒



鬆開螺絲①，即可更換主送布齒④，
鬆開螺絲②，即可更換差動送布齒③。
更換送布齒後輕輕鎖緊螺絲。
參照下項說明設定，送布齒面在針板上
的浮凸量後，再鎖緊固定螺絲。

更換後調整

更換送布齒後，必須重新設定送布齒在針板上面的浮凸量。

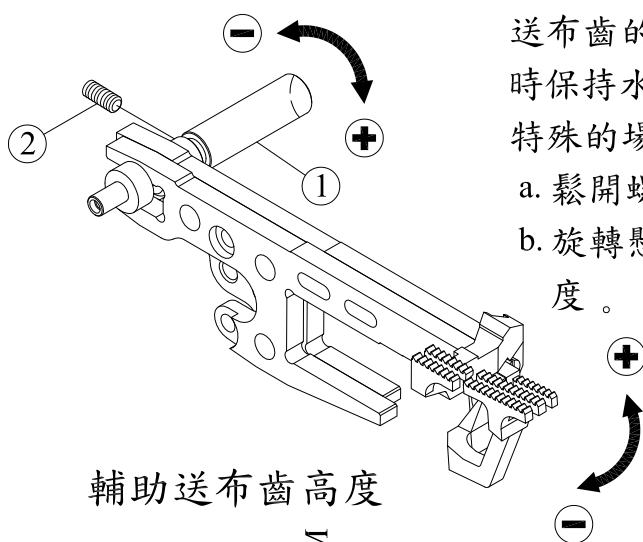


旋轉皮帶輪，使主送布齒②上昇到最高
點，設定其齒尖浮出針板面 0.8-1MM (標
準設定值)，再旋轉皮帶輪降下主送布齒
使其齒尖與針板面平齊，設定差動送布
齒的高度，使其齒尖同樣與針板面平齊。

設定完成後鎖緊螺絲①，②同時再次確認。

- 旋轉皮帶輪上昇送布齒，是否浮出凸針板面 0.8-1MM。
- 繼續旋轉皮帶輪，降下送布齒到最低點，是否完全沒入針板下方。

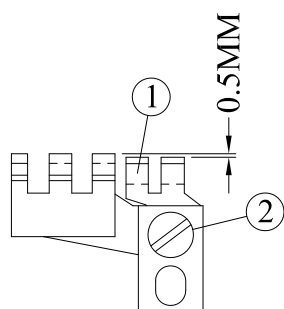
齒面水平(傾斜量)調整



送布齒的齒面，在運動的循環中，必須隨
時保持水平修正其水平度，或是在某些
特殊的場合齒面必須前傾或上仰時

- 鬆開螺絲②
- 旋轉懸臂軸①調整送布齒面的水平
度。

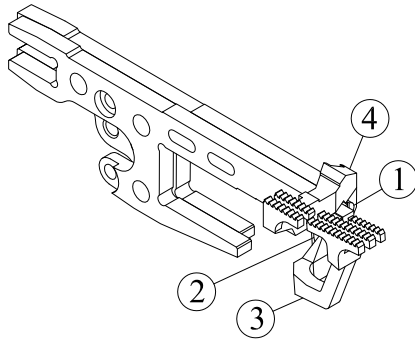
輔助送布齒高度



輔助送布齒①，其齒面比主送布齒齒面
低 0.5MM (標準設定值)，可放鬆螺絲②
來調整。

4-3 CHANGING AND ADJUSTING FEED DOGS :

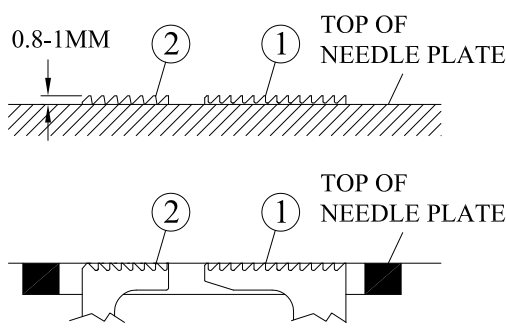
CHANGING FEED DOGS :



LOOSEN SCREW (1) CAN CHANGE MAIN FEED DOG (4) ,
LOOSEN SCREW (2) CAN CHANGE DIFFERENTIAL
FEED DOG (3) .

AFTER CHANGED FEED DOGS , TIGHTEN SCREWS
LIGHTLY . PLEASE REFER TO FOLLOWING ITEMS IN
ORDER TO SET UP CORRECT POSITION OF FEED DOGS .
THEN , TIGHTEN SET SCREWS .

ADJUSTING FEED DOGS AFTER CHANGED :

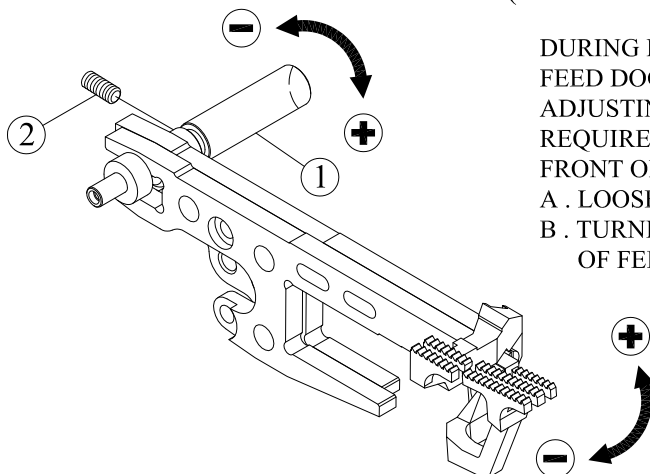


AFTER CHANGE FEED DOGS , MUST ADJUST FEED DOGS
TO ITS CORRECT POSITION . TURNING BELT PULLEY ,
MAKE SURE MAIN FEED DOG (2) TO ITS HIGHEST
POSITION , MAKE SURE THE TIP OF FEED DOG
TEETH HIGHER THAN TOP OF NEEDLE PLATE BY
0.8-1MM . (STANDARD SETTING VALUE)
THEN , TURNING BELT PULLEY , LOWERING
MAIN FEED DOG , MAKE SURE THE TIP OF
TEETH LINE EVEN WITH TOP OF NEEDLE PLATE ,
THEN , ADJUSTING THE TIP OF TEETH OF
DIFFERENTIAL FEED DOGS LINE EVEN WITH TOP OF
NEEDLE PLATE .
AFTER SET UP , TIGHTEN SCREW (1) , (2) AND
MAKE SURE FEED DOGS ARE AT ITS CORRECT
POSITION AGAIN .

AFTER ADJUSTING , PLEASE TIGHTEN SCREW (1) , (2)
AND IN THE SAME TIME , PLEASE MAKE SURE

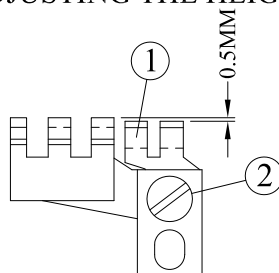
- a. IF FEED DOGS WILL RAISE 0.8-1MM . ABOVE
THE TOP OF NEEDLE PLATE BY TURNING BELT PULLEY
AND MOVING FEED DOG UP .
- b. IF FEED DOGS WILL HIDE UNDERNEATH THE NEEDLE
PLATE BY KEEP TURNING BELT PULLEY .

ADJUSTING FEED DOGS LEVEL (TILT AMOUNT) :



DURING FEED DOGS MOVEMENT , THE TEETH OF
FEED DOGS MUST BE LEVEL OFF ALWAYS .
ADJUSTING ITS LEVEL OR DURING SOME SPECIAL
REQUIREMENTS , FEED DOG TEETH MUST TILT TO
FRONT OR REAR .
A . LOOSEN SCREW (2) .
B . TURNING SHAFT (1) IN ORDER TO ADJUST LEVEL
OF FEED DOGS .

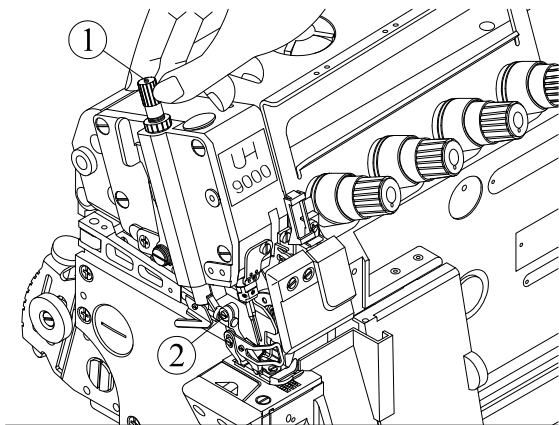
ADJUSTING THE HEIGHT OF AUXILIARY FEED DOG :



THE HEIGHT OF AUXILIARY FEED DOG SHOULD BE
0.5MM LOWER THAN MAIN FEED DOG (STANDARD
SETTING VALUE) AND ADJUSTMENT CAN BE MADE
BY LOOSEN SCREW (2) .

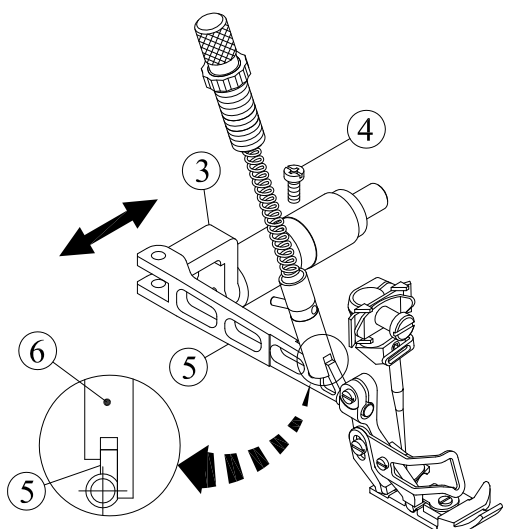
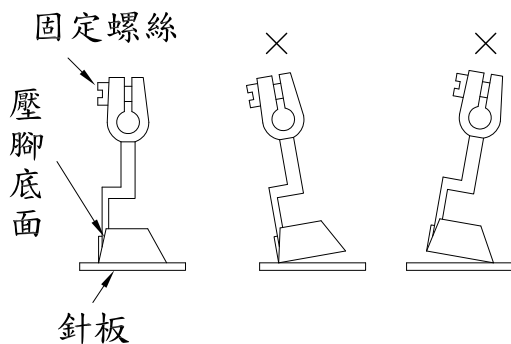
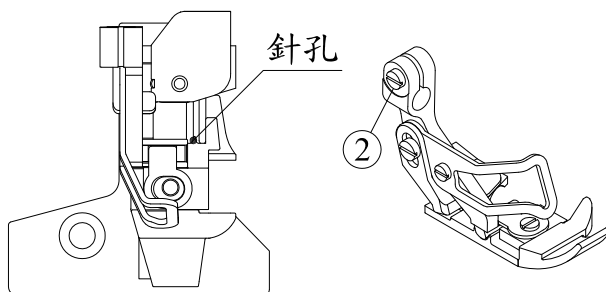
4-4 更換壓腳組與調整

更換壓腳組



調整

UH9303 UH9304



逆時針旋轉調節螺樁 ①，完全放鬆壓力彈簧。

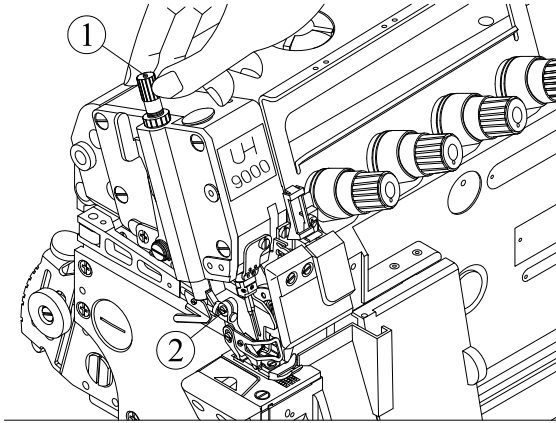
放鬆螺絲 ②，即可取下壓腳組。

壓腳組必須正確的安裝，才能得到最佳的縫製效果。

1. 旋轉手輪，將針棒降到最低點，縫針進入針孔內。
2. 將壓腳的針孔，對正針板的針孔，確認縫針在針孔的正中間，同時壓腳底面必須平貼在針板面上(左圖)。
3. 鎖緊螺絲 ②。
4. 壓桿 ⑥ 的底部，必須很穩固的夾持著壓腳臂 ⑤，同時壓腳臂也必須能順利的取出，調整時可放鬆螺絲 ④ 將組件 ③ 左右移動，再設定正確的位置。

4-4 CHANGING AND ADJUSTING PRESSER FOOT SET :

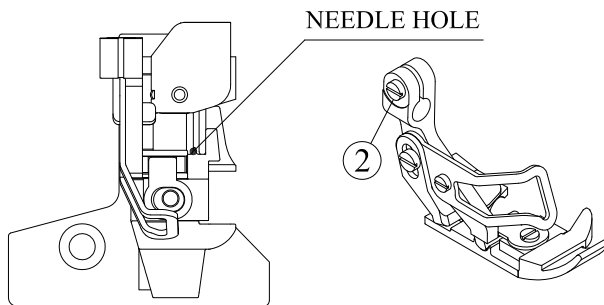
CHANGE PRESSER FOOT SET :



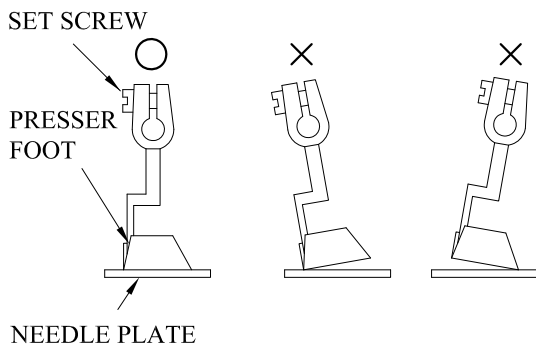
TURNING ADJUSTING SCREW (1) COUNTERCLOCKWISE IN ORDER TO LOOSE PRESSURE SPRING .
LOOSEN SCREW (2) CAN TAKE OFF PRESSER FOOT SET .

ADJUSTING :

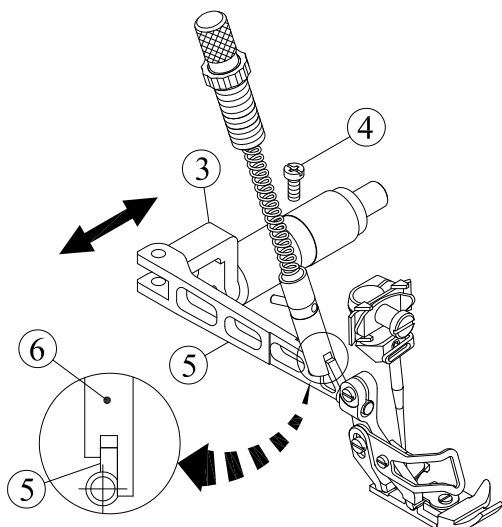
UH9303 UH9304



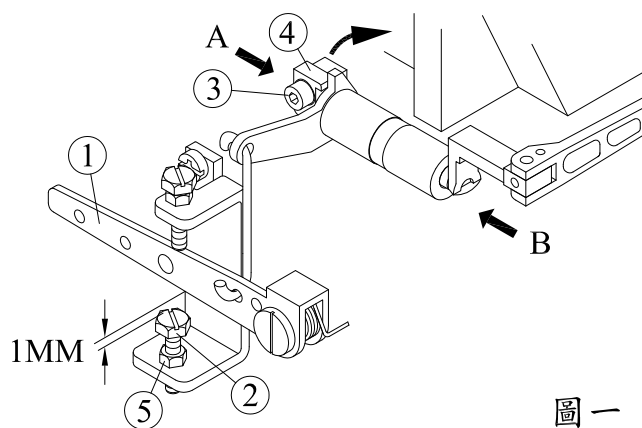
PRESSER FOOT MUST BE INSTALLED CORRECTLY IN ORDER TO OBTAIN BEST SEWING EFFECTS .



1. TURNING HAND WHEEL IN ORDER TO LOWER THE NEEDLE BAR TO ITS LOWEST SET POSITION AND NEEDLE CAN BE MOVED INTO NEEDLE HOLE .
2. MAKE SURE THE NEEDLE HOLE OF PRESSER FOOT IN LINE WITH THE NEEDLE HOLE OF NEEDLE PLATE AND SEWING NEEDLE IS IN THE CENTER OF NEEDLE HOLE . IN THE MEANTIME , THE BOTTOM OF PRESSER FOOT SHOULD LAY FLAT ON THE TOP OF NEEDLE PLATE (LEFT DIAGRAM)
3. TIGHTEN SCREW (2)
4. THE BOTTOM OF PRESSER BAR SHOULD HOLD PRESSER ARM PROPERLY . SO , PRESSER ARM CAN BE HELD AND RELEASED EASILY , WHILE ADJUSTING , LOOSEN SCREW (4) MOVE SHAFT (3) TO RIGHT OR LEFT IN ORDER TO SET UP CORRECT POSITION .



4-5 調整壓腳提昇量



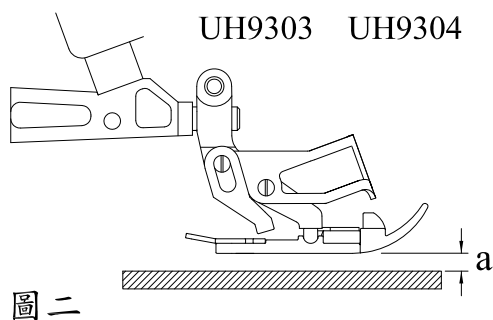
圖一

設定間隙

拉桿①與螺絲②其間隙為1MM。

1. 旋轉手輪使送布齒降到針板面下。
2. 放鬆螺絲③。
(注意不可完全放鬆)
3. 由A, B兩方向夾持著同時轉動束圈④設定拉桿①與螺絲②之間的間隙為1MM。
4. 鎖緊螺絲③。

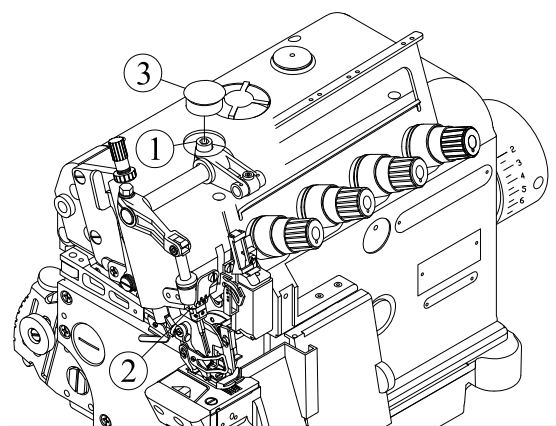
設定壓腳提昇量



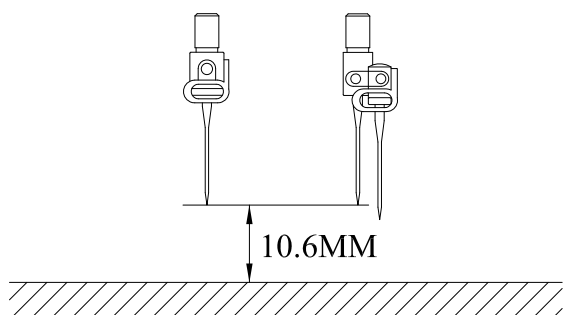
圖二

如圖二 (UH9303 UH9304) 所示。壓腳提昇量 a 最大為 7MM。調整時可放鬆螺帽⑤，調整螺絲②與拉桿①的間隙到適當位置。

4-6 調整縫針針尖高度



UH9303 UH9304



縫針針尖與針板距離為10.6MM。
(標準設定)

參照左圖：

1. 旋轉皮帶輪使針棒上昇至最高點。
2. 打開孔塞③放鬆螺絲①。
3. 調整針棒的高度②。
4. 完成後再確實鎖緊螺絲①。

4-5 ADJUSTING THE LIFTING HEIGHT OF PRESSER FOOT :

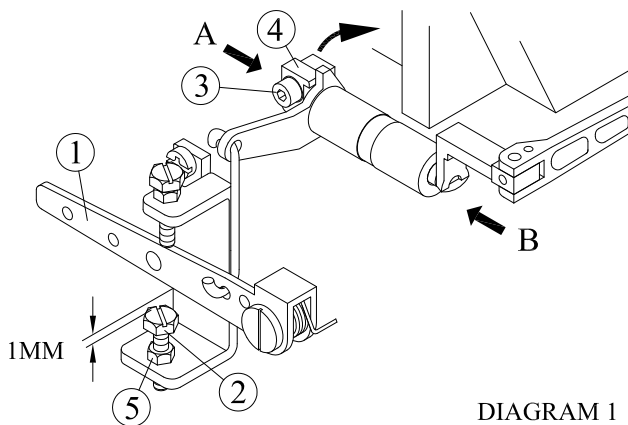


DIAGRAM 1

SETTING TOLERANCE UP :

THE TOLERANCE BETWEEN LEVEL (1) AND SCREW (2) SHOULD BE 1MM .

1. LOWER FEED DOGS UNDER NEEDLE PLATE BY TURNING HAND WHEEL .
2. LOOSEN SCREW (3) LIGHTLY (CAN NOT LOOSEN SCREW COMPLETELY .)
3. HOLDING BUSHING FROM A AND B SIDES TURNING COLLAR (4) IN ORDER TO SET UP 1MM TOLERANCE BETWEEN LEVEL (1) AND SCREW (2)
4. TIGHTEN SCREW (3) .

SETTING UP PRESSER FOOT LIFTING AMOUNT :

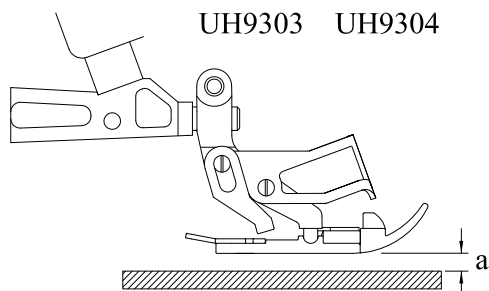


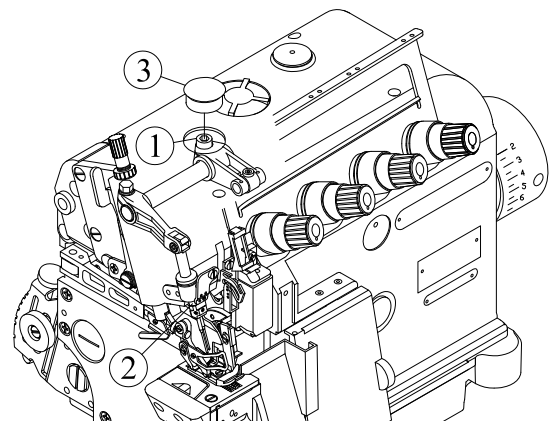
DIAGRAM 2

AS SHOWN ON DIAGRAM 2

(UH9303 , UH9304) MAX . PRESSER FOOT LIFTING AMOUNT "a" IS 7MM .

WHEN ADJUSTING , LOOSEN NUT (5) AND ADJUST THE TOLERANCE TO DESIRED POSITION BETWEEN SCREW (2) AND LEVEL (1) .

4-6 ADJUSTING THE HEIGHT OF NEEDLE :

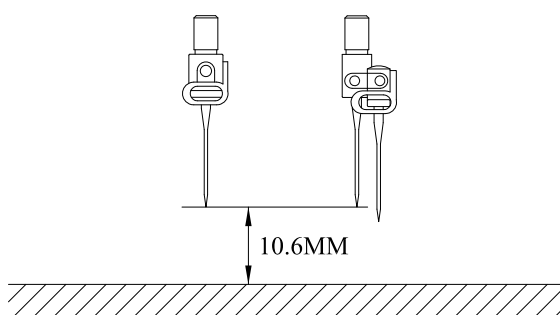


THE DISTANCE BETWEEN NEEDLE TIP TO TOP OF NEEDLE PLATE SHOULD BE 10.6MM (STANDARD SETTING) .

PLEASE REFER TO LEFT DIAGRAM :

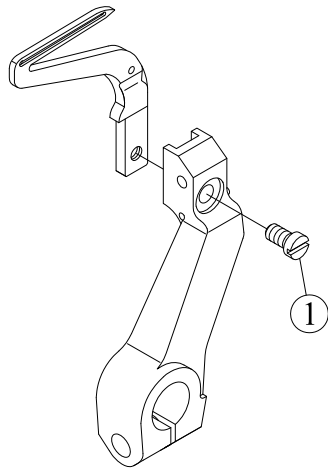
1. TURNING BELT PULLEY IN ORDER TO RAISE NEEDLE BAR TO ITS HIGHEST POSITION .
2. OPEN UP PLUG (3) AND LOOSEN SCREW (1) .
3. ADJUST THE HEIGHT OF NEEDLE BAR .
4. AFTER ADJUSTMENT PLEASE MAKE SURE TIGHTEN SCREW (1) .

UH9303 UH9304



4-7 更換結線鉤

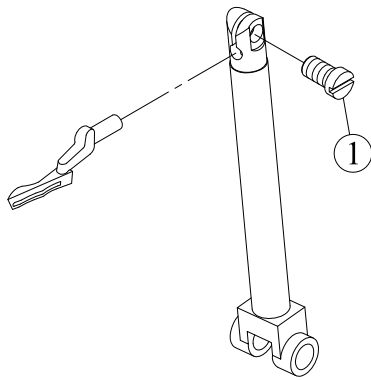
4-7-1 更換下結線鉤



取下螺絲 ① 即可更換下結線鉤。

安裝結線鉤時，必須確認結線鉤的柄部，貼緊槽底部。

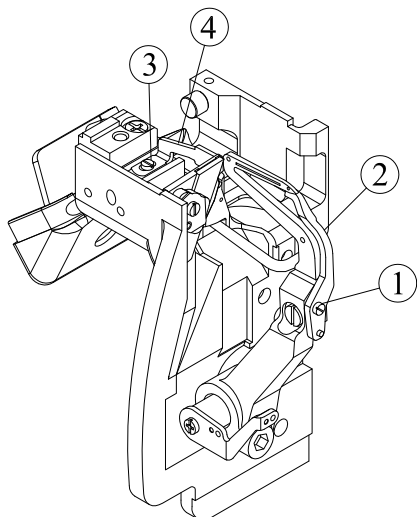
4-7-2 更換上結線鉤



放鬆螺絲 ① 即可抽出上結線鉤。

4-8 更換導針器

UH9303 UH9304

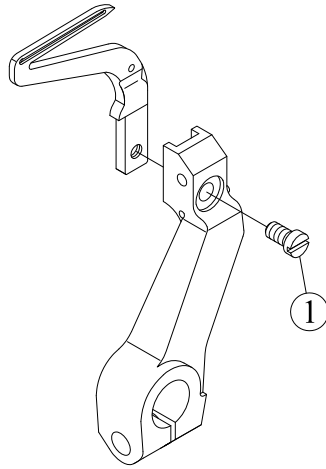


放鬆固定螺絲 ① 即可取下活動導針器 ②。

放鬆固定螺絲 ③ 即可取下前導針器 ④。

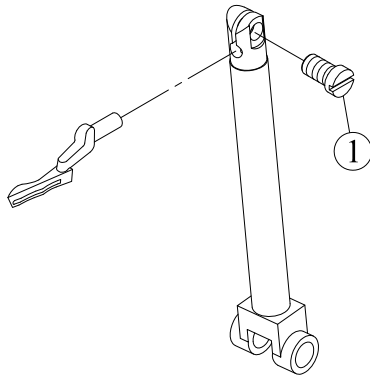
4-7 CHANGING LOOPERS :

4-7-1 CHANGING LOWER LOOPER :



CHANGING LOWER LOOPER BY TAKE OFF SCREW (1) . WHEN INSTALLING , PLEASE MAKE SURE THE CRANK OF LOWER LOOPER MUST ATTACH TO THE BOTTOM OF GROOVE OF LOWER LOOPER ARM CLOSELY .

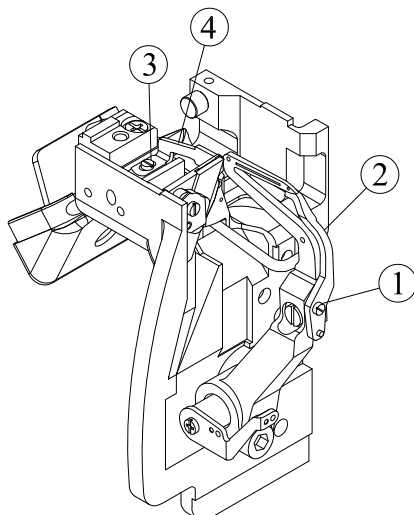
4-7-2 CHANGING UPPER LOOPER :



CHANGING UPPER LOOPER BY TAKE OFF SCREW (1) .

4-8 CHANGING NEEDLE GUARD :

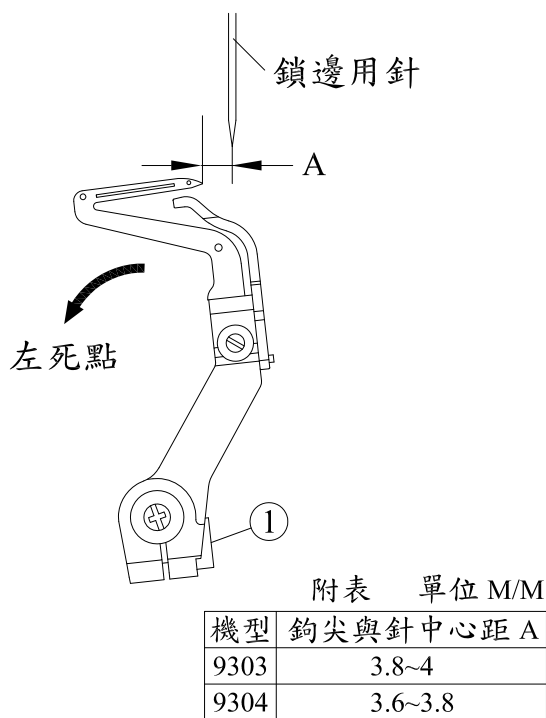
UH9303 UH9304



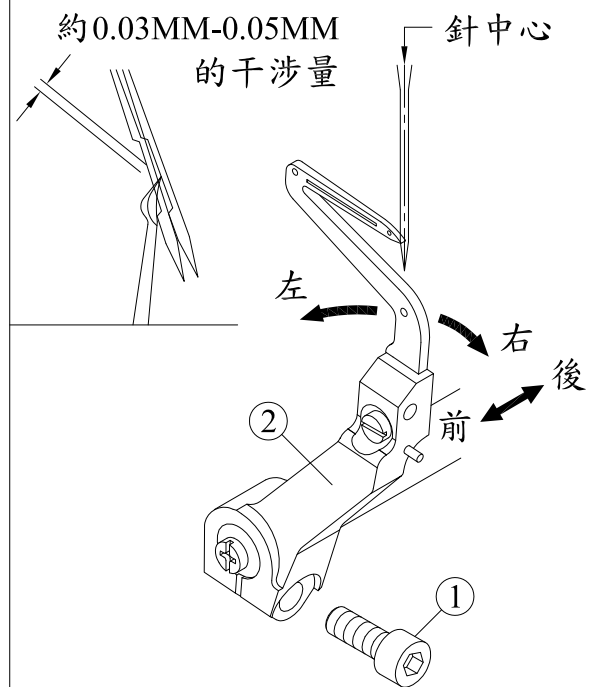
CAN TAKE OFF REAR NEEDLE GUARD (2) BY LOOSEN SCREW (1) . LOOSEN SCREW (3) CAN TAKE OFF FRONT NEEDLE GUARD (4) .

4-9 設定結線鉤與導針器

4-9-1 設定下結線鉤



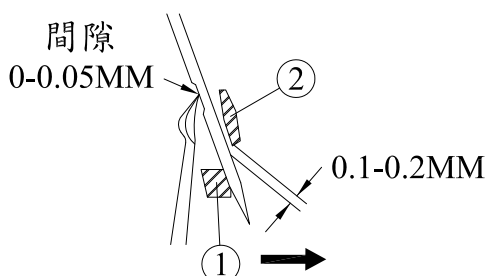
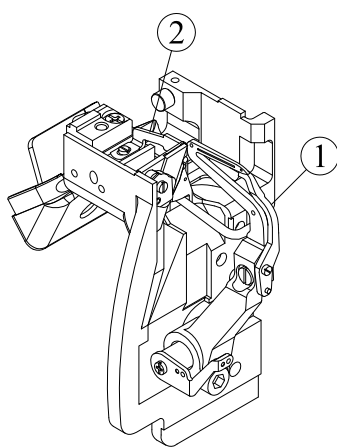
下結線鉤擺動到運動路徑的左死點時，其鉤尖與鎖邊用針中心距為 A 請參照附表
放鬆螺絲 ① 即可調整。



下結線鉤從右向左擺動，當鉤尖擺動到鎖邊用針中心時，兩者之間約 0.03MM-0.05MM 的干涉量。
放鬆螺絲 ① 前後調整擺動臂 ② 即可。

4-9-2 設定鎖邊用針導針器

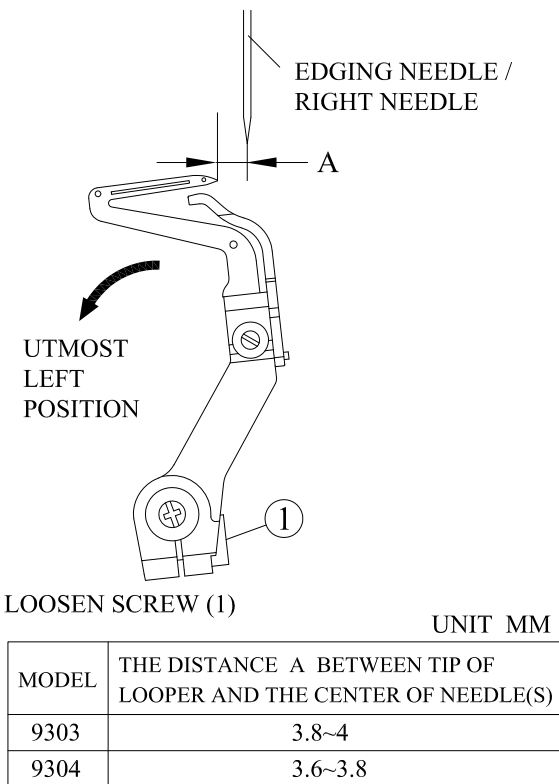
UH9303 UH9304



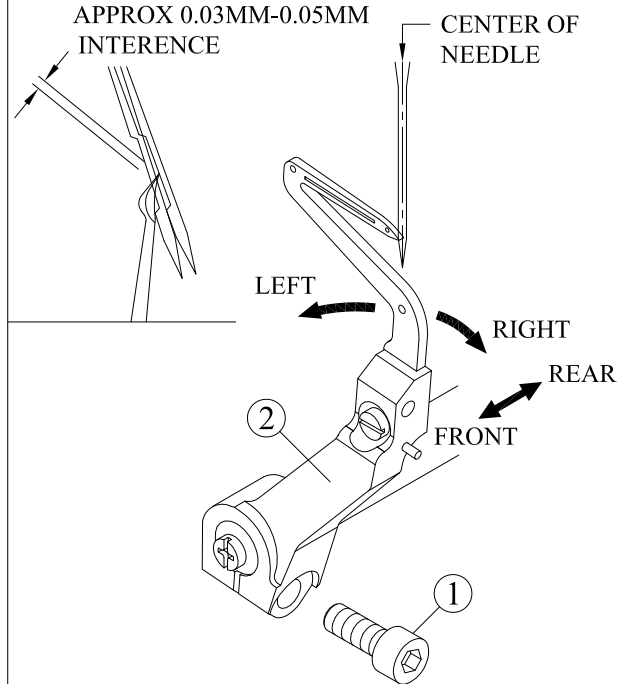
1. 上節所述下結線鉤擺動到鎖邊用針中心時與針有 0.03MM-0.05MM 的干涉量。
2. 在此同時調整活動導針器 ① 與針接觸將針向箭頭方向推開，使針與鉤尖產生間隙 0-0.05MM (參照左圖)。
3. 調整前導針 ② (UH9303 UH9304) 與針的間隙為 0.1-0.2MM。

4-9 SETTING UP LOOPER AND NEEDLE GUARD :

4-9-1 SETTING UP LOWER LOOPER :



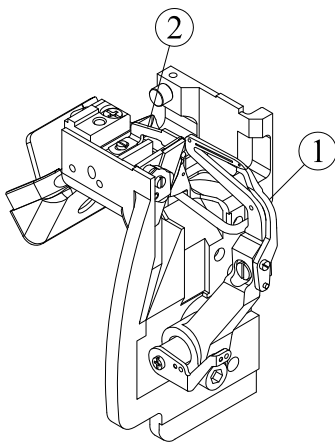
WHEN LOWER LOOPER MOVES TO ITS UTMOST LEFT POSITION , PLEASE REFER TO THE CHART ABOVE FOR THE DISTANCE A BETWEEN THE TIP OF LOWER LOOPER AND THE CENTER OF EDGING NEEDLE .



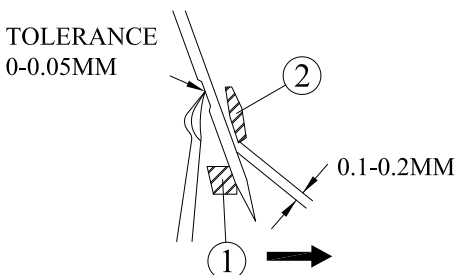
WHEN LOWER LOOPER MOVES FROM RIGHT TO LEFT AND THE TIP OF LOOPER MOVES TO EDGING NEEDLE / RIGHT NEEDLE , THERE WILL HAVE A INTERFERENCE APPROX 0.03MM TO 0.05MM . LOOSEN SCREW (1) AND ADJUSTMENT CAN BE MADE BY MOVING LOOPER ARM (2) FORWARD OR BACKWARD .

4-9-2 SETTING UP NEEDLE GUARD OF EDGING NEEDLE :

UH9303 UH9304

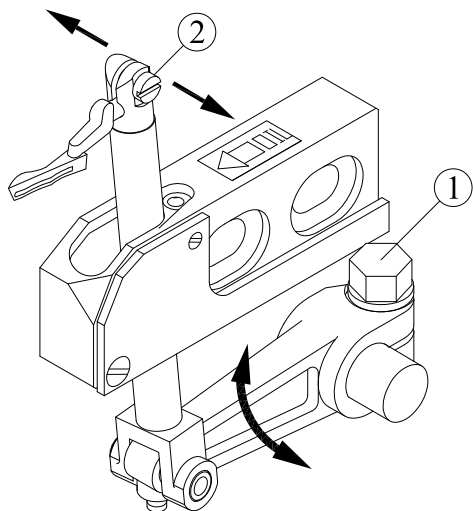


1. AS MENTIONED ABOVE , WHEN LOWER LOOPER MOVES TO THE CENTER OF EDGING NEEDLE , THERE WILL HAVE APPROX 0.03MM-0.05MM INTERFERENCE .
2. IN THE SAME TIME , ADJUSTING REAR NEEDLE GUARD (1) IN ORDER TO PUSH NEEDLE FORWARD AND CREATE A TOLERANCE OF 0-0.05MM BETWEEN NEEDLE AND THE TIP OF LOWER LOOPER .
3. IN THE SAME TIME , ALSO ADJUSTING FRONT NEEDLE GUARD (2) (UH9303 , UH9304) TO CREATE A TOLERANCE OF 0.1-0.2MM BETWEEN FRONT NEEDLE GUARD AND NEEDLE .



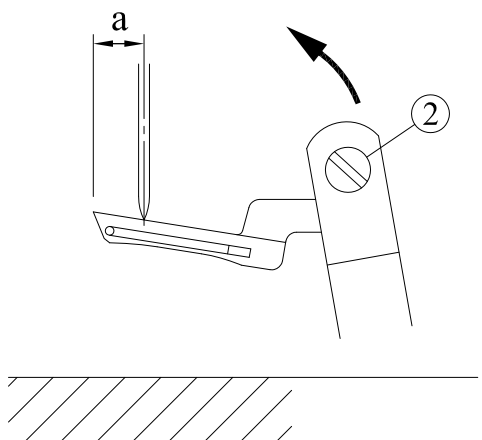
4-9-3 設定上結線鉤

圖一

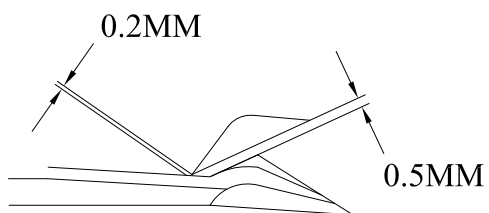


1. 上結線鉤運動到上死點時，其鉤尖與針中心距離 a ，參照附表及圖二。
2. 上結線鉤與下結線鉤背面交會時，其間隙參照圖三。
3. 參照圖一放鬆螺絲 ①，② 同時設定圖二及圖三的尺寸後，確實鎖緊螺絲 ①，②。

圖二



圖三

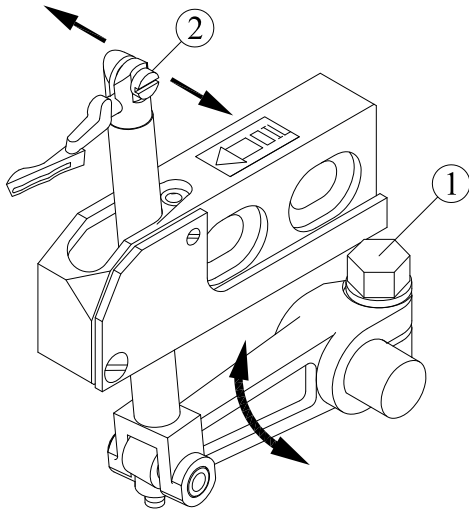


附表

| 機型 | a |
|-----------|---------|
| UH9303(L) | 4.5~5.0 |
| UH9303 | 4.3~4.8 |
| UH9304 | 4.5~5.0 |

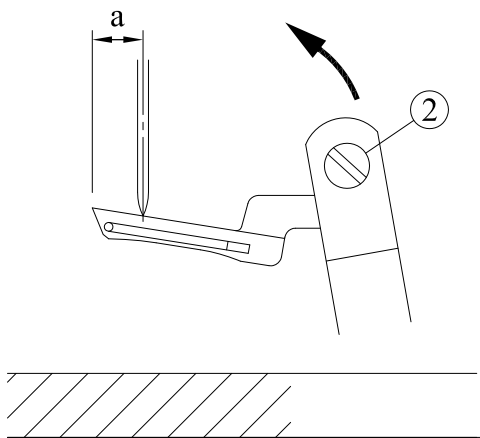
4-9-3 SETTING UP UPPER LOOPER :

DIAGRAM 1.



1. WHEN UPPER LOOPER MOVES TO ITS HIGHEST POSITION , THE DISTANCE BETWEEN TIP OF LOOPER AND CENTER OF NEEDLE SHOULD BE AS SPECIFICATION CHART LISTED BELOW AND ALSO PLEASE REFER TO DIAGRAM 2.
2. WHEN UPPER LOOPER PASSING THROUGH THE BACK OF LOWER LOOPER. PLEASE REFER TO DIAGRAM 3. FOR CORRECT TOLERANCE BETWEEN UPPER LOOPER AND LOWER LOOPER .
3. WHEN SETTING , PLEASE LOOSEN SCREW (1) , (2) AS PER DIAGRAM 1. AND SET UP THE TOLERANCES BETWEEN UPPER LOOPER AND NEEDLE , UPPER LOOPER AND LOWER LOOPER AS PER SPECIFICATION CHART . THEN , TIGHTEN SCREW (1) , (2) .

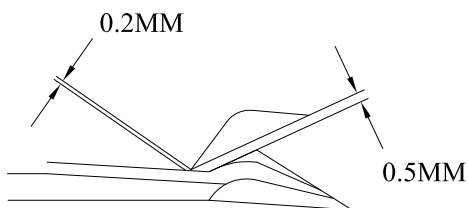
DIAGRAM 2.



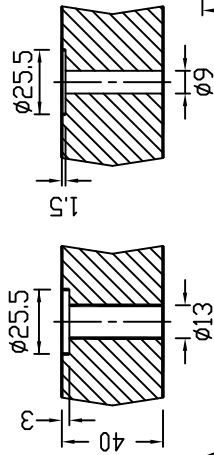
SPECIFICATION CHART

| MODEL | a |
|-----------|---------|
| UH9303(L) | 4.5~5.0 |
| UH9303 | 4.3~4.8 |
| UH9304 | 4.5~5.0 |

DIAGRAM 3.

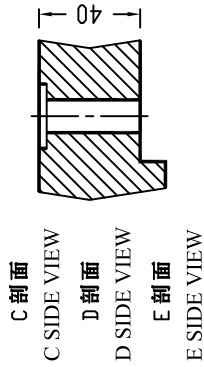


1 UH-9300
(66814-4)



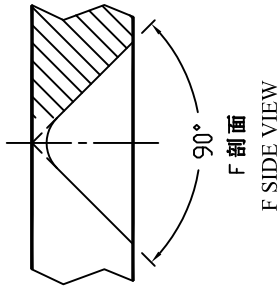
A-A剖面共4處
A-A SIDE VIEW
TOTPH 4 PLACES

B-B剖面共3處
B-B SIDE VIEW
TOTPH 3 PLACES



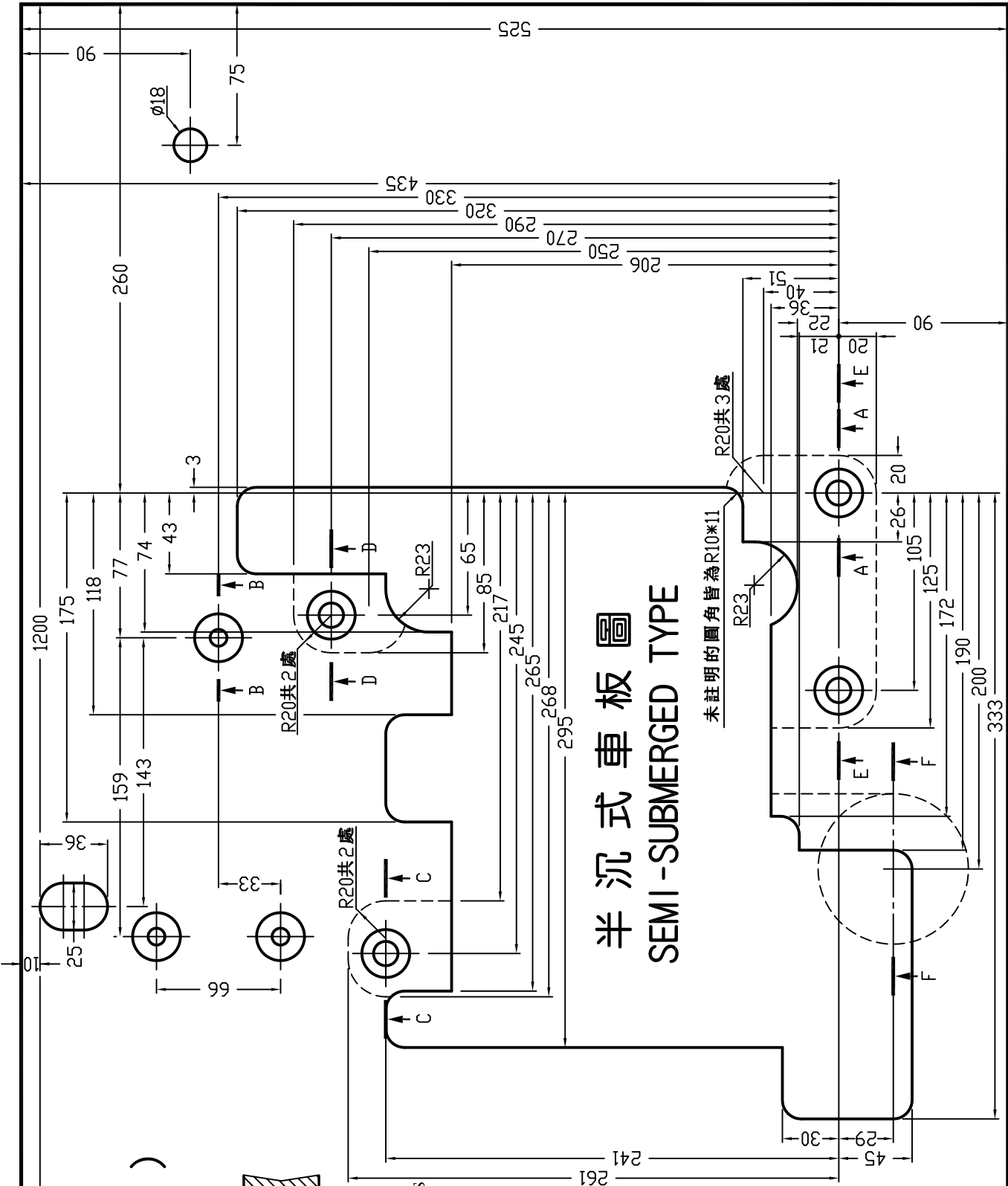
超過40MM厚度的車板
請將C,D,E剖面處
加工成40MM厚

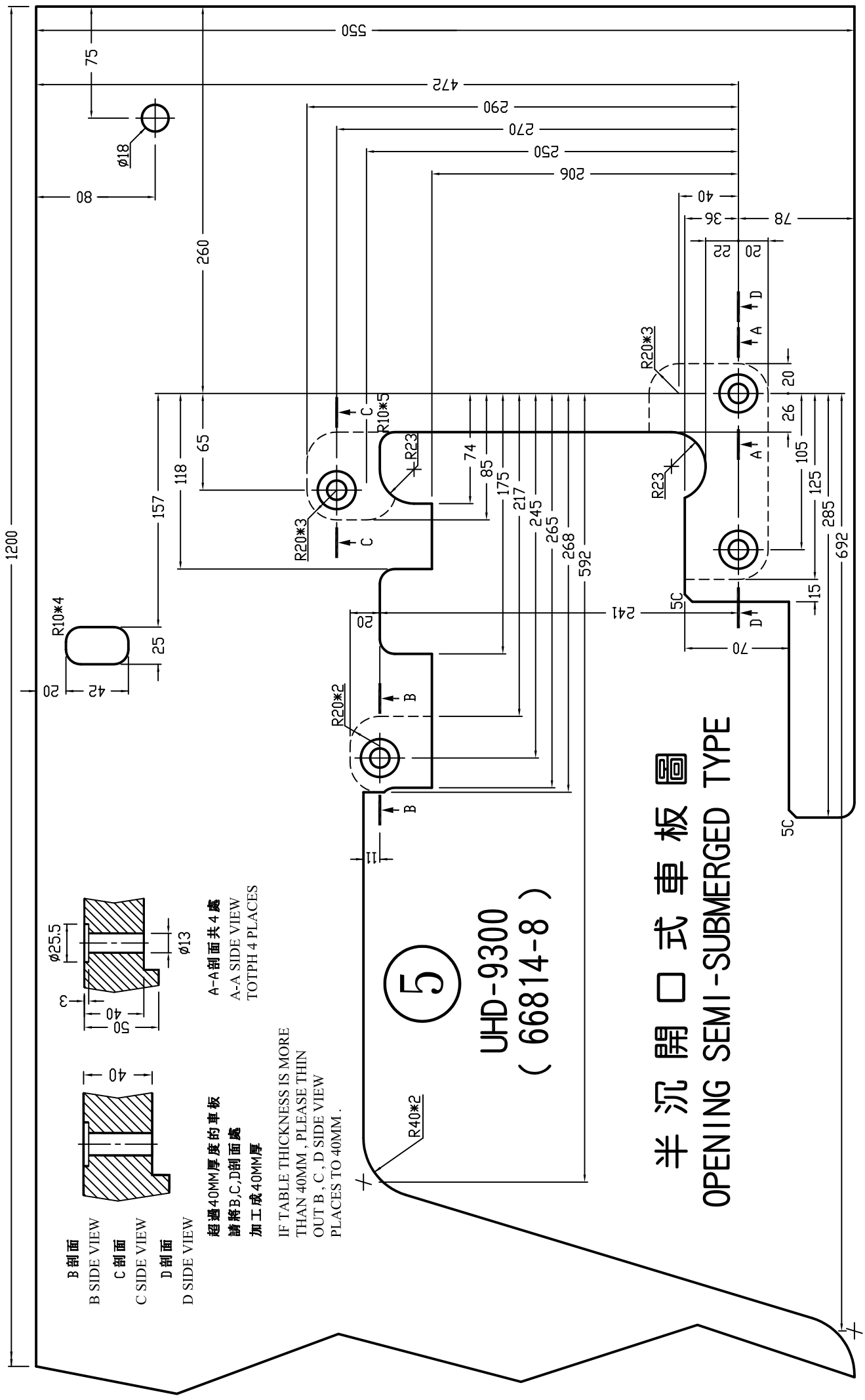
IF TABLE THICKNESS IS MORE
THAN 40MM , PLEASE THIN
OUT C , D , E SIDE VIEW
PLACES TO 40MM .



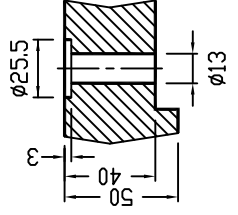
半沉式車板圖 SEMI-SUBMERGED TYPE

未註明的圓角皆為R10*11





B 剖面
B SIDE VIEW
C 剖面
C SIDE VIEW
D 剖面
D SIDE VIEW



超過40MM厚度的車板
請將B,C,D剖面處
加工成40MM厚

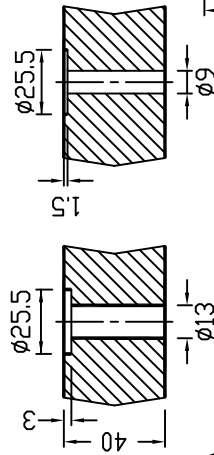
IF TABLE THICKNESS IS MORE
THAN 40MM, PLEASE THIN
OUT B, C, D SIDE VIEW
PLACES TO 40MM.

5

UHD-9300
(66814-8)

半沉開口式車板圖
OPENING SEMI-SUBMERGED TYPE

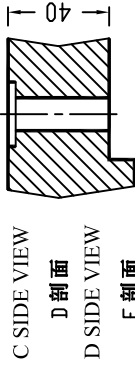
6 (UHD-9300
66814-10)



A-A剖面共4處
A-A SIDE VIEW
TOTPH 4 PLACES

B-B剖面共3處
B-B SIDE VIEW
TOTPH 3 PLACES

C剖面



C SIDE VIEW

D剖面

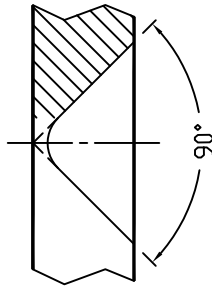
D SIDE VIEW

E剖面

E SIDE VIEW

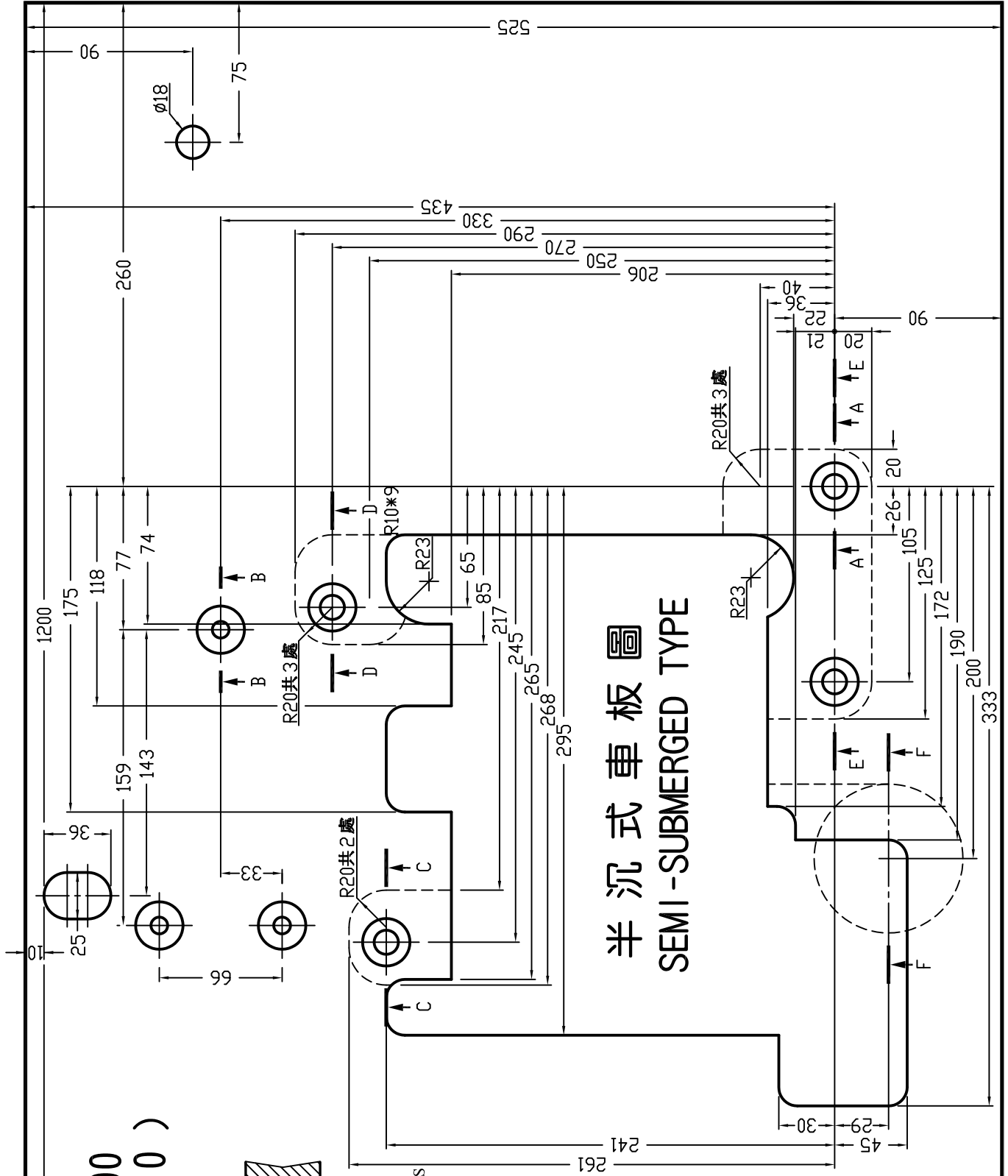
超過40MM厚度的車板
請將C,D,E剖面處
加工成40MM厚

IF TABLE THICKNESS IS MORE
THAN 40MM , PLEASE THIN
OUT C , D , E SIDE VIEW
PLACES TO 40MM .

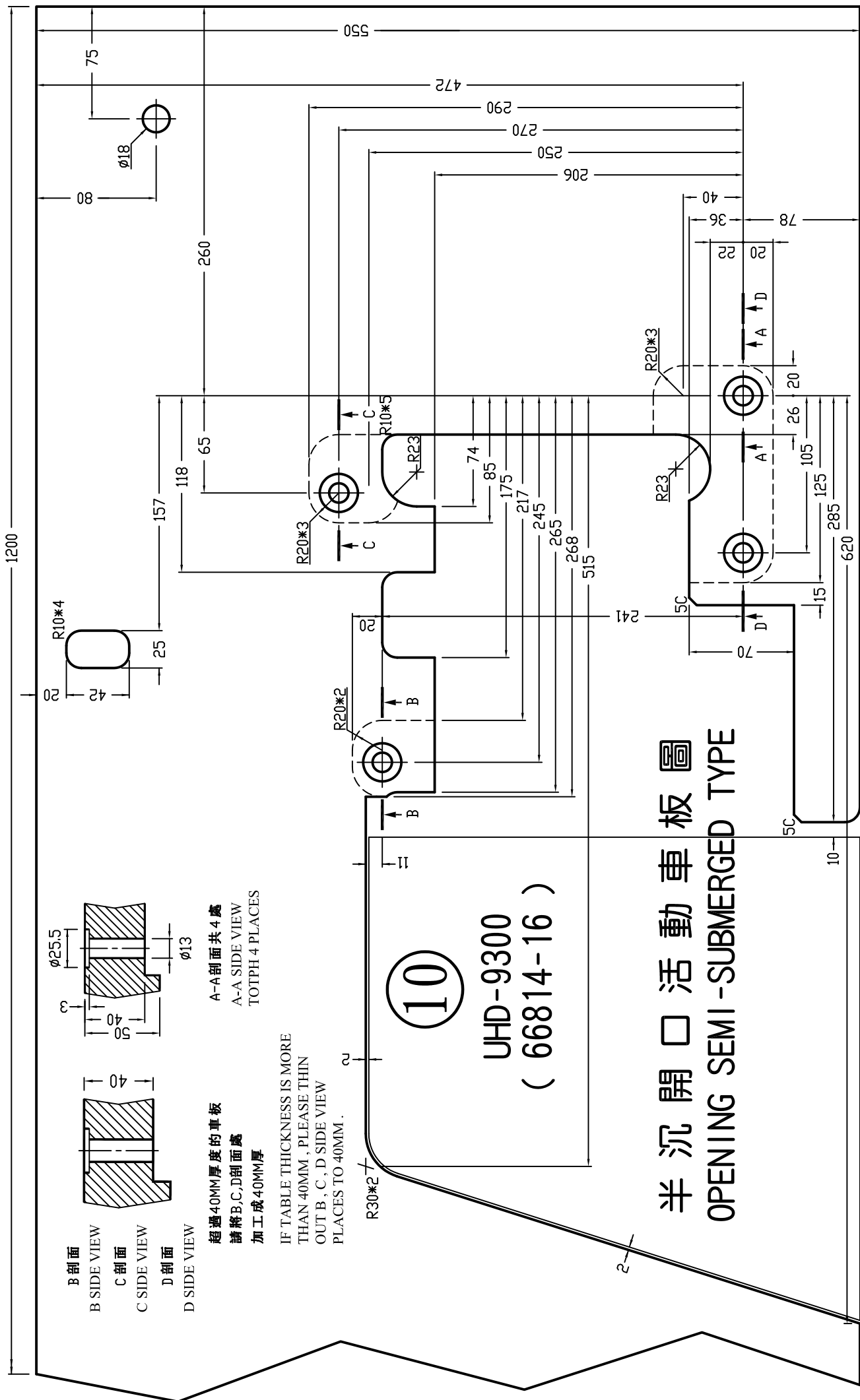


F剖面

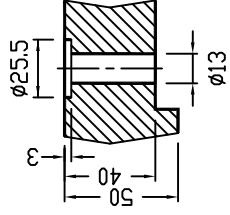
F SIDE VIEW



半沉式車板圖
SEMI-SUBMERGED TYPE



B 剖面
B SIDE VIEW
C 剖面
C SIDE VIEW
D 剖面
D SIDE VIEW



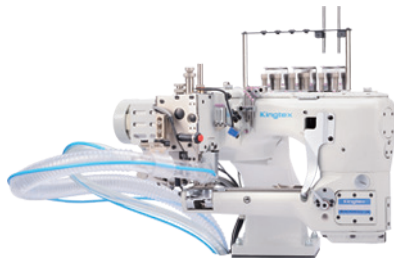
超過40MM厚度的車板
請將B,C,D剖面處
加工成40MM厚
A-A剖面共4處
A-A SIDE VIEW
TOTPH 4 PLACES

IF TABLE THICKNESS IS MORE
THAN 40MM, PLEASE THIN
OUT B, C, D SIDE VIEW
PLACES TO 40MM.

10

UHD-9300
(66814-16)

半沉開口活動車板圖
OPENING SEMI-SUBMERGED TYPE



NTD67 / TC024S
FEED-OFF-THE-ARM
MACHINE FOR FLAT SEAMING



MT4512P-050 / PMD / FR01
12-Needle Double Chain Stitch Machine
(Lower Feed Metering Device \ Elastic hemmer)



UHU9304-243-M14 / TR025
Automatic chain cutter device direct-drive
cylinder bed top feed overlock fitted with
labor-saving rib folder



CXM2085-0-356M
Attaching Pre-Closed Flat Knit Elastic Band Onto
Waists Of Tubular Goods
(With Right Knife, Rear Puller & Chips Suction Pipe)



精機機械廠股份有限公司
CHING CHI MACHINE CO., LTD
<http://www.kingtexsewing.com.tw>

The specifications and / or appearances of the equipments described in
this catalogue are subject to change without further notice.

本目錄所述產品, 因更新或改良, 可能不經事前預告, 而對產品之外觀, 規格, 內容進行修改, 特此聲明敬請鑒諒。