

KLD SERIES

寶獅牌工業用縫紉機 INDUSTRIAL SEWING MACHINE

MODEL KLD8530M/Q



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

使用說明 Operation Manual

开车前的注意事项 BEFORE OPERATION

1. 油盘内未加油绝不能开车。
2. 机器运转时，从上轮外侧看转向应为逆时针方向。注意，不能倒转。
3. 确认电动机标牌上标电压及相位是否正确。
1. Never operate the machine unless its oil pan has been filled with oil.
2. After setting up the machine, check the direction of motor rotation. To check it, turn the handwheel by hand to bring the needle down, and turn the power switch ON while observing the handwheel. (The handwheel should turn counterclockwise as observed from the handwheel side.)
3. Confirm that the voltage and phase (single or 3-phase) are correct by checking them against the ratings shown on the motor nameplate.

使用注意事项 OPERATION PRECAUTIONS

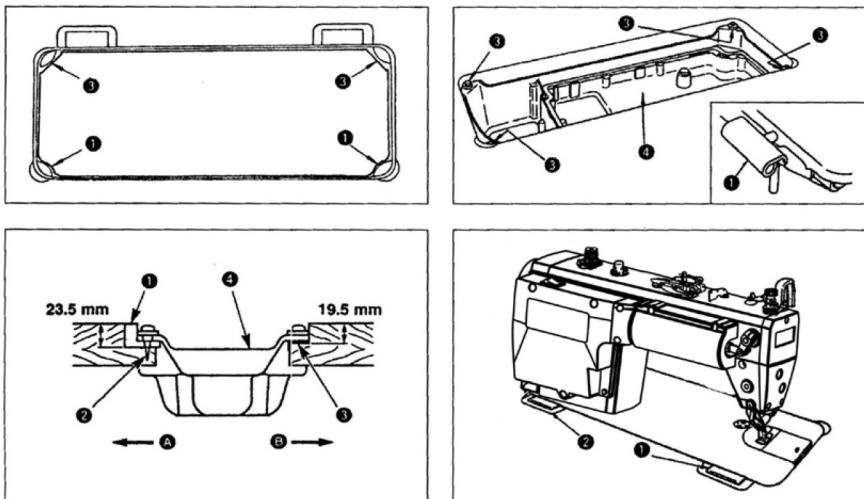
1. 接通电源开关或机器运转时，请勿将手放到针的下部。
2. 机器运转时，请勿将手指伸入挑线杆护罩内。
3. 机头翻动时，一定要切断电机开关。
4. 操作者离开机器时，必须切断电源。
5. 机器运转期间，注意不允许任何人的头或手以及任何东西靠近绕线轮和电动机。
6. 装拆防护罩、或者其它保护装置时，请勿开动机器。
7. 不要用香水等油漆稀释剂擦洗机头表面。
1. Keep your hands away from the needle when you turn the power switch ON or while the machine is operating.
2. Do not put your fingers into the thread take-up cover while the machine is operating.
3. Be sure to turn the power switch OFF before tilting the machine head or removing the V belt.
4. When an operator leaves from the machine, make sure to turn off the power.
5. During operation, be careful not to allow your or any other person's head or hands to come close to the handwheel, V belt, bobbin winder or motor. Also, do not place anything close to them. Doing so may be dangerous.
6. If your machine is provided with a belt cover, finger guard or any other protectors, do not operate your machine with any of them removed.
7. Don't clean the face of machine head with thinner.

-1-

1. 规格 / SPECIFICATIONS

用途	薄料、中厚料	厚料
缝纫速度	4000rpm	3500rpm
最大针距长度	5mm	7mm
压脚高度	手动 5.5mm 膝动 15mm 自动抬压脚 8-12mm (可调)	
机针	DB×1 #9~#18	DP×5 #19~#22
使用机油	0号白油	
Application	General fabrics, light-weight and medium-weight materials	Heavy-weight materials
Sewing speed	Max. 4,000rpm	Max. 3,500rpm
Max. Stitch length	5mm	7mm
Presser foot lift	Manual operation 5.5mm Knee-action 15mm Automatism 8-12mm	
Needle	DB×1 #9~#18	DP×5 #19~#22
Lubricating	White Oil 0	

2. 缝纫机的安装 / INSTALLATION



(1) 底槽的安装

- 1) 把底槽支到机台沟的四角上。
- 2) 用螺钉②把前侧的A 2个头部橡胶支座①钉到机台的伸出部，再用螺钉②把铰链侧B的2个头部橡胶支座①钉好固定，然后把底槽④放上去。
- 3) 把铰链①放到机台的孔上，对准板橡胶支座②，把头部放到四角的机头胶垫③上。

(1) Installing the under cover

- 1) The oil pan should rest on the four corners of the machine table groove.
- 2) Fix two rubber seats ① on side A (operator's side) using nails ② as illustrated above. Fix two cushion seats ③ on side B (hinged side) using a rubber-based adhesive. Then place oil pan ④ on the fixed seats.
- 3) Fit hinge ① into the opening in the machine bed, and fit the machine head to table rubber hinge ② before placing the machine head on cushions ③ on the four corners.

3. 膝动提升高度的调整 / ADJUSTING THE HEIGHT OF THE KNEE LIFTER

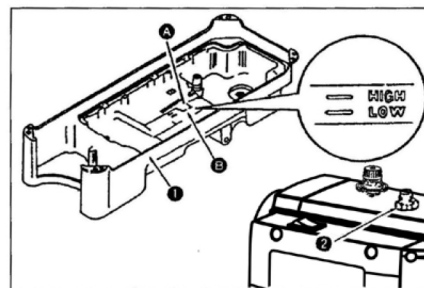
注意
为了防止意外的启动造成的事故，请关掉电源后进行。
WARNING:
Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



- 1) 膝动提升的压脚标准高度为10mm。
- 2) 调节膝动提升调节螺丝①可以把压脚高度最大调整到13mm。(A型时最大为9mm。)
- 3) 压脚提升到10mm以上时，请注意针杆②的前端下降到最低下时，不能碰到压脚③。
- 1) The standard height of the presser foot lifted using the knee lifter is 10 mm.
- 2) You can adjust the presser foot lift up to 13 mm using knee lifter adjust screw ①. (Max. 9 mm for A type)
- 3) When you have adjusted the presser foot lift to over 10 mm, be sure that the bottom end of needle bar ② in its lowest position does not hit presser foot ③.

4. 加油 / LUBRICATION

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运转缝纫机前

- 1) 请把机油倒进油槽①里，一直加到HIGH标记②的位置。
- 2) 油槽的油面降到LOW标记③以下时，请再次补充机油。
- 3) 加油后运转缝纫机，如果润滑正常时，可以通过油窗④看到油的流动。
- 4) 油流动量的多少，与油量的多少无关。

注意 新缝纫机或较长时间没有使用的缝纫机在使用之前，应进行10分钟3,000~3,500 rpm的磨合运转。

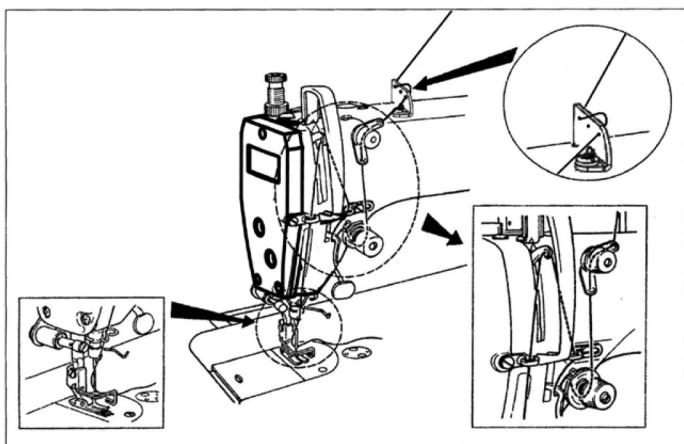
Information on lubrication

- 1) Fill oil pan ① with Machine Oil up to HIGH mark ②.
- 2) When the oil level lowers below LOW mark ③, refill the oil pan with the specified oil.
- 3) When you operate the machine after lubrication, you will see splashing oil through oil sight window ④ if the lubrication is adequate.
- 4) Note that the amount of the splashing oil is unrelated to the amount of the lubricating oil.

注意 When you first operate your machine after setup or after an extended period of disuse, run your machine at 3,000 to 3,500 rpm. for about 10 minutes for the purpose of break-in.

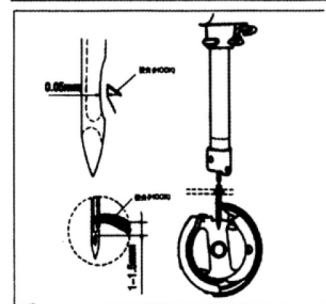
5. 上线的穿线方法 / THREADING THE MACHINE HEAD

注意
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6. 机针与旋梭的关系 / NEEDLE-TO-HOOK RELATIONSHIP

注意
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1. 针与旋梭的关系应配合如下:
- 1) 转动上轮，使针杆位于最低点，再旋松针杆连接柱定位螺钉。
 - * 针杆高度的确定
 - 2) 拉动针杆，水平透过内梭内边缘可看到针孔有1/2下露(机针必须安装到位)，机针埋线槽朝左，然后旋紧针杆连接柱螺钉。
 - * 旋梭位置的确定
 - 3) 先将旋梭梭尖朝上，转动上轮，针杆从最低点回升时，观察旋梭与机针配合关系。当旋梭梭尖位于机针孔边上端1~1.5mm时且梭尖平面距机针短槽平面0.05mm时(保证梭尖位于机针的中心线部位)，旋紧旋梭螺钉。

注意
若间隙太小，会磨损梭尖，若间隙太大，则会引起跳针。
旋梭原来用什么型号，调换后，也请使用原来的型号；
更换机针后注意机针必须安装到位且类型相同。如不同类型机针须检查配合关系。

1. Adjust the timing between the needle and the hook as follows:

- 1) Turn the handwheel to bring the needle bar down to the lowest point of its stroke, and loosen sntscrow.

-4-

* Adjusting the needle bar height

- 2) Pull the needle bar, you can see the pinhle basset 1/2 level through edge of inside hook (needle must be position). Turn needle cover wire slot left, then tighten setscrew.

* Adjusting position a of the hook

- 3) First move the point of hook in the direction, when running strap pulley needle bar risen from the lowest. Observe cooperate relation of the hook and needl. When hook point above Pinhole about top of 1mm to 1.5mm and when plane of the hook point form plane of needle short bar 0.05mm (keep the align hook blade point with the center of needle), tighten the hook setscrews.



* Precaution

If the clearance is too small, the tip of the hook will be abraded.
If it is too big, it will lead to skip over.

*Note that the type of hook to be substituted for, when replacing the hook, shall be in conformity with the very type of the hook installed in the sewing machine of original assemblge.

After replacing the needle, the needle must be same type and install right position. If the needle is different type need check match with relation.

7. 机针停止位置的调整 / ADJUSTING THE NEEDLE STOP POSITION

注意
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接通电源开关，在踏板从前踩踏变为中立时，机针为下停止位置，此时从针板上平面到针固定螺钉下端的距离应在18~22mm范围内(如图1所示)。在接通电源或切线后停止位置既为上停针位置，此时从针板上平面到针尖的距离为薄料、中厚料10~12mm，厚料10~14mm范围内(如图2所示)。

如需调整时，请参照机型配套电控系统说明书进行调整。

Turn on the power, when the pedal is returned to the neutral position, for lower stop position, the distance from the throat plate to the end of the needle fixing screw at the range of 18~22mm. (As picture 1). Turn on the power, the highest stop position is after thread trimming, the distance from the throat to the tip of the needle at the range of 10~12mm for light and medium material, the range of 10~14mm for heavy material. (As picture 2).
If need to adjust the needle stop position, please refer to the control box operation manual.

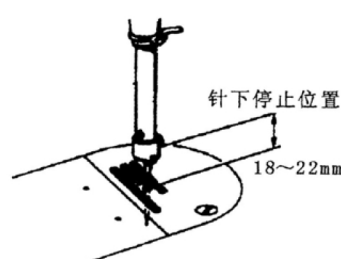


图1

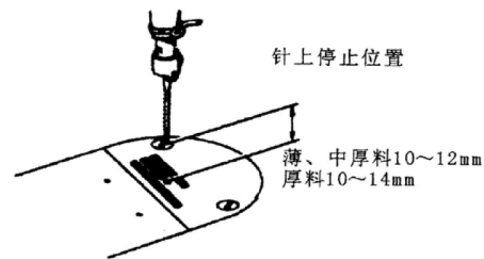
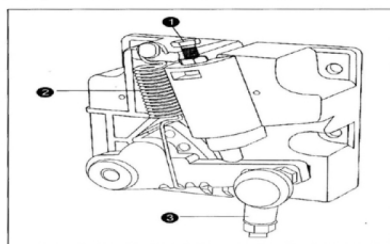


图2

-5-

8. 踏板压力和行程 / PEDAL PRESSURE AND PEDAL STROKE

注意
为了防止意外的启动造成的事故，请关掉电源后进行。
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- (1) 踏板踩踏压力的调整
- 1) 换成前脚踏弹簧①可以调整。
 - 2) 把弹簧挂到左侧之后，压力变轻。
 - 3) 挂到右侧之后变重。
- (2) 踏板回弹力的调整
- 1) 用踏板回弹压力调节弹簧②可以调整。
 - 2) 拧进调节螺丝则压力变大。
 - 3) 拧松调节螺丝则压力变小。
- (3) 踏板踩踏行程的调整
- 1) 把连杆杆③插到右侧的孔里之后行程变大。

(1) Adjusting the pressure required to depress the front part of the pedal

- 1) This pressure can be changed by changing the mounting position of pedaling pressure adjust spring ①.
- 2) The pressure decreases when you hook the spring on the left side.
- 3) The pressure increases when you hook the spring on the right side.

(2) Adjusting the pressure required to depress the back part of the pedal

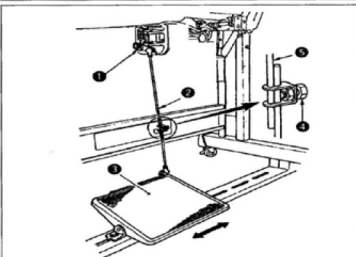
- 1) This pressure can be adjusted using regulator screw ②.
- 2) The pressure increases as you turn the regulator screw in.
- 3) The pressure decreases as you turn the screw out.

(3) Adjusting the pedal stroke

- 1) The pedal stroke increases when you insert connecting rod ③ into the right hole.

9. 踏板的调整 / ADJUSTMENT OF THE PEDAL

注意
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- (1) 连接杆的安装
- 1) 向箭头方向移动踏板调节板③，让踏板拨杆①和连接杆②呈一直线。
- (2) 踏板的角度
- 1) 调节连接杆的长度就可以自由地改变踏板的倾斜度。
 - 2) 拧松调节螺丝④，拉出插入连接杆⑤进行调整。

(1) Installing the connecting rod

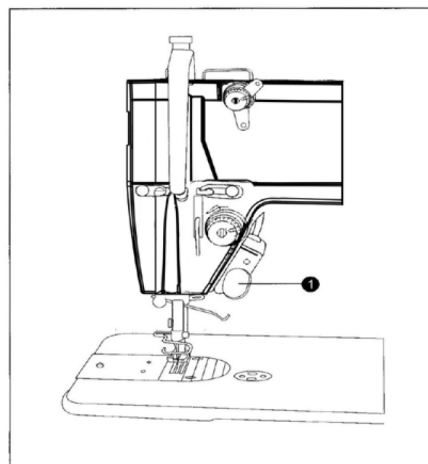
- 1) Move pedal ③ to the right or left as illustrated by the arrow so that motor control lever ① and connecting rod ② are straightened.

(2) Adjusting the pedal angle

- 1) The pedal tilt can be freely adjusted by changing the length of the connecting rod.
- 2) Loosen adjust screw ④, and adjust the length of connecting rod ⑤.

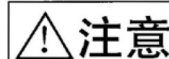
-6-

10. 触键手动倒缝 / ONE-TOUCH TYPE REVERSE FEED STITCHING MECHANISM



(1) 使用方法

- 1) 按开关拨杆①，缝纫机立即变为倒送，进行倒缝。
- 2) 按下拨杆的时间，可以进行倒缝。
- 3) 放开拨杆，则立即返回到正缝。



注意
为了防止意外的启动造成的事故，请关掉电源后进行。

(1) How to operate

- 1) The moment switch lever ① is pressed, the machine performs reverse feed stitching.
- 2) The machine performs reverse feed stitching as long as the switch lever is held pressed.
- 3) The machine resumes normal feed stitching the moment the switch lever is released.



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11. 挑线簧

THREAD TAKE UP SPRING

1. 改变挑线簧①的摆动量:

- 1) 旋松定位螺钉②。
- 2) 把夹线螺钉③朝顺时针方向(即A方向)转动时，挑线簧的摆动量将增大。
- 3) 把夹线螺钉朝逆时针方向(即B方向)转动时，挑线簧的摆动量将减小。

2. 改变挑线簧①的张力:

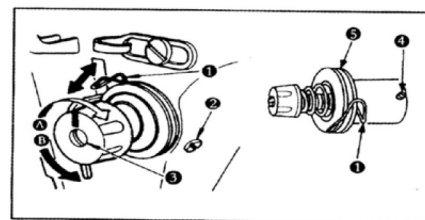
- 1) 旋松定位螺钉②，取出夹线器(组件)⑤。
- 2) 旋送定位螺钉④，并转动夹线螺钉③。
- 3) 把夹线螺钉③朝顺时针方向(即A方向)转动时，挑线簧的张力将增大。
- 4) 把夹线螺钉朝逆时针方向(即B方向)转动时，挑线簧的张力将减小。

1. Changing the stroke of thread take-up spring ①

- 1) Loosen setscrew ②.
- 2) As you turn tension post ③ clockwise (in direction A), the stroke of the thread take-up spring will be increased.
- 3) As you turn the knob counterclockwise (in direction B), the stroke will be decreased.

2. Changing the pressure of thread take-up spring ①

- 1) Loosen setscrew ②, and take out tension asm ⑤.
- 2) Loosen setscrew ④, and remove tension post ③.
- 3) As you turn tension post ③ clockwise (in direction A), the pressure will be increased.
- 4) As you turn the post counterclockwise (in direction B), the pressure will be decreased.



-7-

11. 切刀部件/ Knife Assembly



1.切刀的操作：

1) 要使切刀动作时，请把机头上的切刀开关①向下旋转；

2) 要使切刀停止动作时，请把切刀开关①向上抬起，切刀上升，停止动作；

3) 切刀的操作，务必在缝纫机停止运转之后再行。

2.切刀的安装：

1) 如图所示安装切刀，切刀下降到最低点时，上下移动切刀，让切刀的A部比针板面低0-0.5mm；

2) 更换切刀时，请拧松2个切刀固定螺钉①后进行更换。

3.切断宽度的变更：

切断宽度有3.2、4、4.8、6.4四种规格。

1) 卸下针板挡板①（带针板导屑罩②），压脚③，针板④，送布牙⑤；

2) 拧松刀架固定螺钉⑥；

3) 安装上适合切断宽度的送布牙、针板、压脚、针板导屑罩；

4) 转动手轮，使切刀⑦降到最低点；

5) 将切刀⑦的前端部轻轻地顶到针板A面，然后拧紧切刀支架固定螺钉⑥。（另外，用手指把针板固定螺钉⑧按压到切刀侧，然后拧紧，就可以使切刀锋利地切断布）。

6) 拧松针板导屑罩螺钉⑨，针板导屑罩内侧B面在针板A面的左侧0-0.5mm位置；

7) 拧紧针板导屑罩螺钉⑨。

1.Operation the cloth cutting knife

1) To actuate the cloth cutting knife, lower the knife knob ① mounted on the machine head. If the cloth cutting knife is lowered, it will be actuated while the machine is being driven.

2) To stop the cloth cutting knife, raise the knife knob ①. The cloth cutting knife will then be raised and stopped.

3) When raising or lowering the cloth cutting knife, make sure that the machine stopped.

2.Attaching the cloth cutting knife

1) Raise or lower the cloth cutting knife so that section A of the cloth cutting knife is positioned 0 to 0.5mm below the top face of the gauge when the knife is in its lowest position.

2) Loosen two knife set screws ①, and replace the cloth cutting knife.

3.Changing the cutting width

Four different cutting widths can be selected: 3.2, 4, 4.8, 6.4 .

1) Remove throat plate ① (with waste cloth cover② of the throat plate), presser foot ③, gauge ④ and feed dog⑤.

2) Loosen knife support set screw ⑥.