

**JUKI®**

1-NEEDLE, 3-THREAD OVERLOCK SEWING MACHINE

单针三线包缝机

# MO-623

INSTRUCTION MANUAL

操作指南



**IMPORTANT:**

READ ALL SAFETY REGULATIONS CAREFULLY AND UNDERSTAND THEM BEFORE USING YOUR SEWING MACHINE.

RETAIN THIS INSTRUCTION MANUAL FOR FUTURE REFERENCE.

**要领:**

在您使用缝纫机之前,请仔细阅读并理解所有的安全操作规程。

请妥善保管好本《操作指南》以备后用。

“IMPORTANT SAFETY INSTRUCTIONS”/ “重要的安全操作规则”

When using an electrical appliance, basic safety precautions should always be followed, including the following:Read all instructions before using this sewing machine.

“DANGER— To reduce the risk of electric shock:”

- 1. An appliance should never be left unattended when plugged in.
- 2. Always unplug this appliance from the electric outlet immediately after using and before cleaning.
- 3. Always unplug before re-lamping. Replace bulb with same type rated 10W(220V).

重点安全说明：  
由于本机有电器装置，所以在使用前必须时刻注意最基本的安全规则，阅读所有操作说明。

危险——防电击

- 1、不使用时，请拔去插头。
- 2、用毕和清扫机器时，要拔去插头。
- 3、换灯泡时，要拔去插头，灯泡规格为10W(220V)。

CONTENTS

Details of the machine ..... 1-2

Assembling thread stand ..... 3

Preparing machine..... 4

Operation and function..... 5-9

Threading ..... 10-13

Trial sewing ..... 14

Theead tension dial ..... 15

Adjusting the thread tension ..... 16

Sewing in tape..... 17

Roll hemming ..... 18,19

Thread breakage during sewing ..... 20

Securing seams ..... 21

Maintenance ..... 22

Troubles and corrective measures ..... 23

Specifications ..... 24

Optional accessories ..... 25

目 录

各部位的名称 ..... 1-2

线架装置安装法 ..... 3

运转前准备 ..... 4

操作及功能 ..... 5-9

穿线 ..... 10-13

试缝 ..... 14

线张力调节旋钮 ..... 15

调节线张力 ..... 16

镶带缝 ..... 17

卷边缝 ..... 18, 19

缝纫中的断线 ..... 20

缝口的合拢 ..... 21

保养 ..... 22

报修前 ..... 23

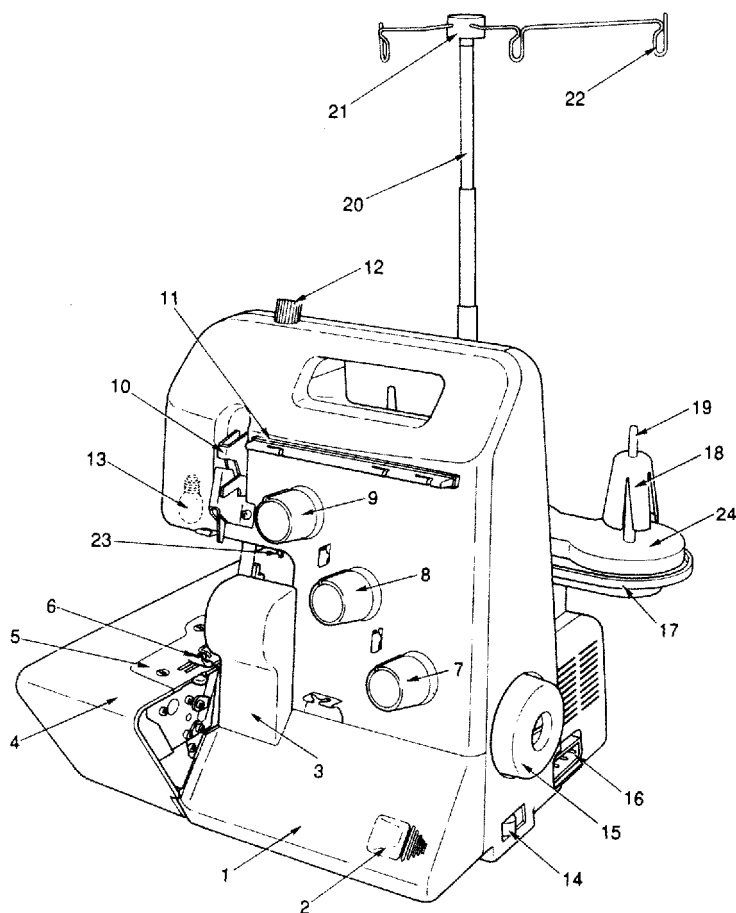
规格 ..... 24

另购附件 ..... 25

## Details of the machine/ 各部位名称

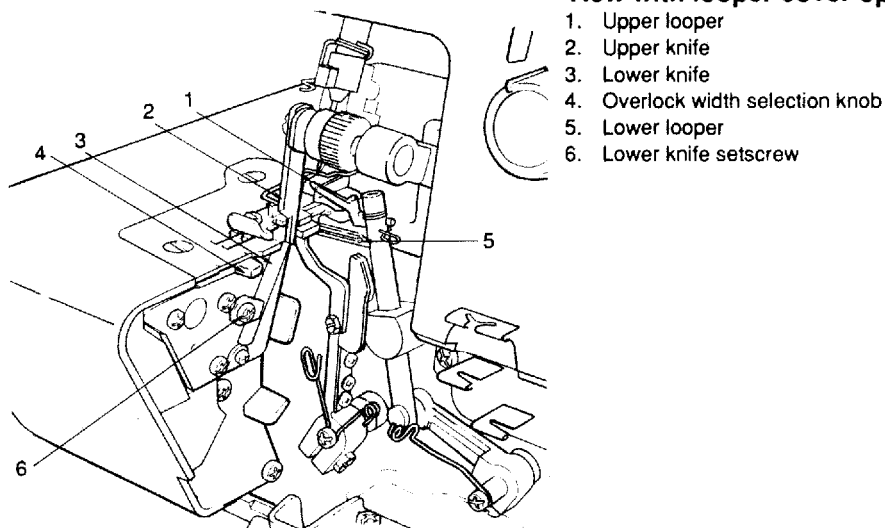
- |                                     |                             |
|-------------------------------------|-----------------------------|
| 1. Looper cover                     | 13. Lamp (located inside)   |
| 2. Looper cover opening handle      | 14. Power/light switch      |
| 3. Chip guard cover                 | 15. Handwheel (pulley)      |
| 4. Cloth plate                      | 16. Machine socket          |
| 5. Throat plate                     | 17. Spool holder            |
| 6. Presser foot                     | 18. Anti-vibration cone     |
| 7. Lower looper thread tension dial | 19. Spool holder pin        |
| 8. Upper looper thread tension dial | 20. Retractable support rod |
| 9. Needle thread tension dial       | 21. Thread guide            |
| 10. Thread take-up cover            | 22. Open thread guide       |
| 11. Thread guide plate              | 23. Presser foot lifter     |
| 12. Presser foot adjusting screw    | 24. Urethane sheets         |

- 1、弯针罩板
- 2、弯针罩板开闭把手
- 3、布屑挡板
- 4、缝合
- 5、针板
- 6、压脚
- 7、下弯针张力调节旋钮
- 8、上弯针张力调节旋钮
- 9、机针张力调节旋钮
- 10、挑线杆护罩
- 11、线导向板
- 12、压脚调压螺钉
- 13、照明灯(内置式)
- 14、电源/照明开关
- 15、飞轮
- 16、插座
- 17、线架座
- 18、防松垫
- 19、插线钉
- 20、线架杆
- 21、线架帽
- 22、挂线导向
- 23、抬压脚扳手
- 24、海棉垫



## Details of the machine/ 各部位名称

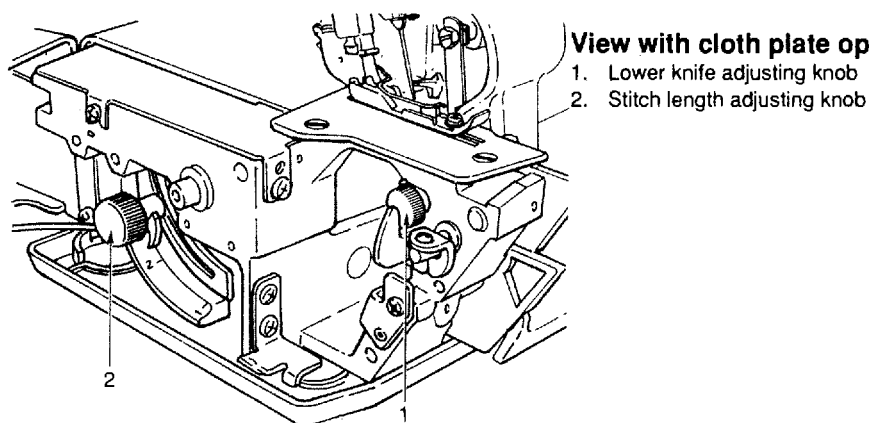
### View with looper cover open



### 打开弯针罩板所见

- 1、上弯针
- 2、上刀
- 3、下刀
- 4、包缝宽度选择扳手
- 5、下弯针
- 6、下刀压板螺钉

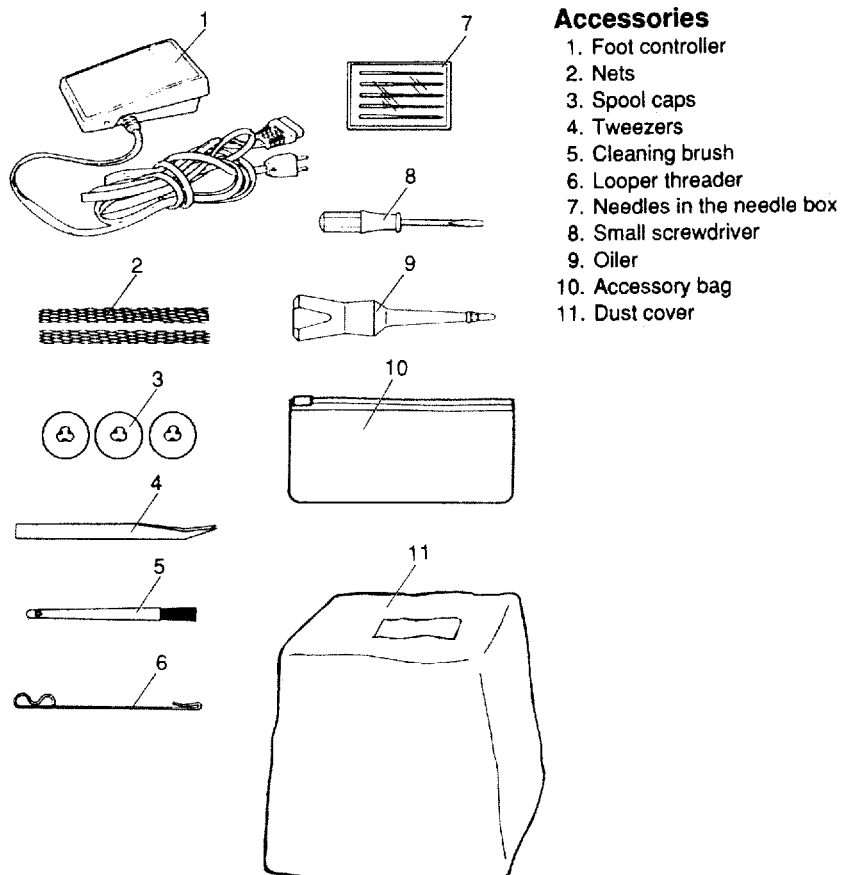
### View with cloth plate open



### 打开缝台所见

- 1、下刀调节旋钮
- 2、送料距调节旋钮

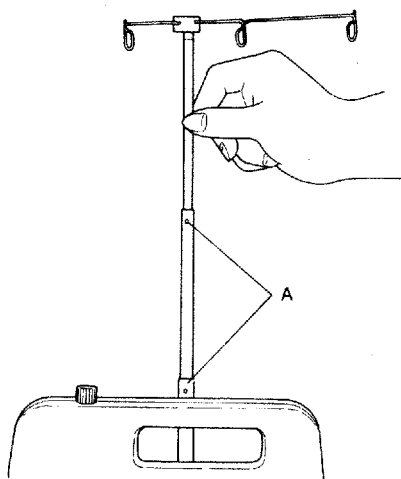
### Accessories



### 附件:

- 1、脚踏控速器
- 2、线团网
- 3、线团座
- 4、镊子
- 5、除尘刷
- 6、弯针线穿线勾
- 7、机针盒
- 8、小螺丝刀
- 9、油壶
- 10、附件袋
- 11、机头罩

## Assembling thread stand/ 线架装置安装法

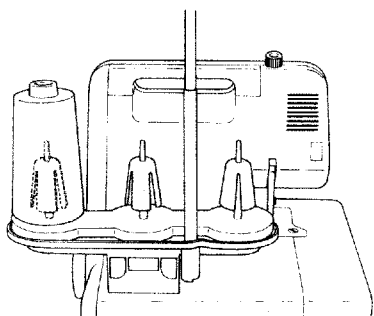


### Raise the support rod fully.

Turn the thread stand until it engages the positioning stopper (A) with a click.

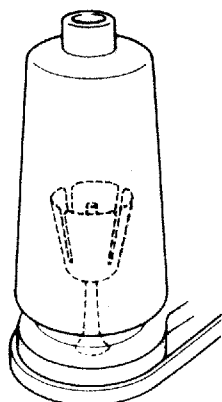
#### 抽出线架杆

转动线架杆直至听到“卡搭”时，即 A 处的两球卡入孔中，表明线架杆与止动球已啮合。



### For overlock spools

包缝用线及线团防松垫

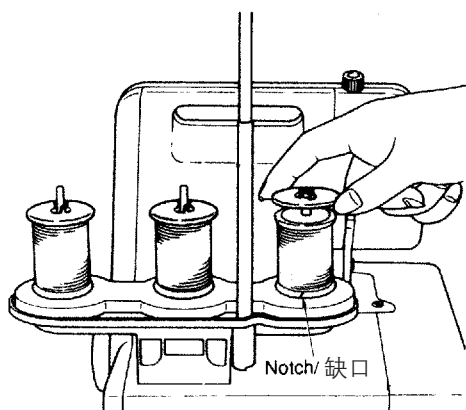


### For large spools

If large industrial spools are used, position the anti-vibration cone upside down on the spool holder pin, i.e. with the wider edge at the top.

#### 大号线团

当使用大号工业线团时，请将线团防松垫倒置插入插线钉，其底部与插线钉顶部并齐。



### For small house-use spools

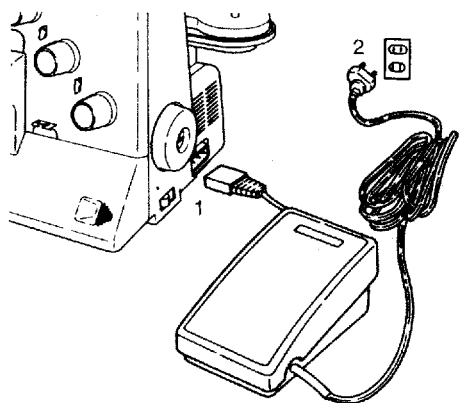
When using house-use spools, remove the anti-vibration cones.

Place a spool on the spool holder with its notch downward and push the spool caps on with the rounded outside edge at the bottom.

#### 小号家庭用线团

在使用家庭用线团时，去掉线团防松垫，将线团插入插线钉，注意线团的缺口朝下，然后按上线团座，并使其凸出部分向上。

## Preparing machine/ 运转前准备

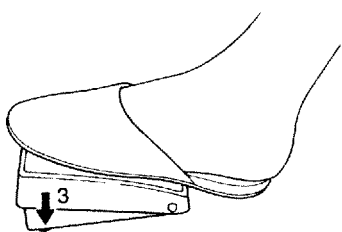


### Attaching the foot controller

1. Plug foot controller into machine socket.
2. Plug foot controller into power supply socket.
3. Lay your foot on the foot controller.  
Step on the foot controller strongly (deeply), and the sewing speed increases.  
Step on the foot controller lightly (shallowly), and the sewing speed decreases.

### 脚踏控速器的连接

- 1、将脚踏控速器的插头插入机器上的插座。
- 2、将控速器的另一头插头插入电源插座。
- 3、用脚来控制脚踏控速器。  
踩深缝纫速度变快。  
踩浅缝纫速度变慢。



### On/Off of the power/light switch

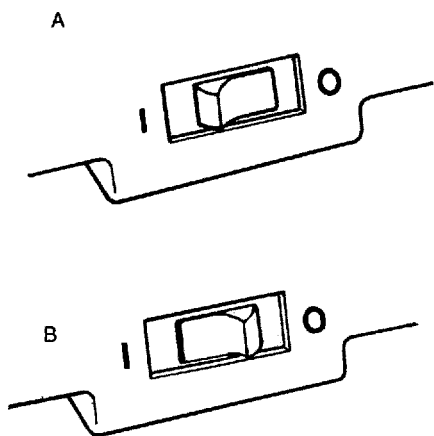
The power/light switch is conveniently placed on the handwheel side of the machine in front of the socket.

- Off (A)
- On with light (B)

### 电源开关/照明灯开关

电源/照明灯开关位于飞轮侧的插座前方。

- A: 关(A)
- B: 打开照明灯(B)

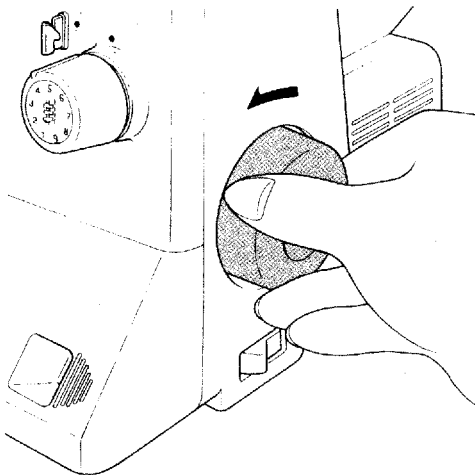


### • When you do not use the sewing machine:

1. Turn the power/light switch off. (Press O side)
2. Pull the machine plug out from the power supply socket.
3. Never place anything on the foot controller.

### 当您不使用缝纫机时:

- 1、关闭电源开关（为O档）。
- 2、拔去插头。
- 3、不在脚踏控速器上放置任何东西。



### Handwheel (Pulley)

The handwheel turns toward you.

- \* Upon completion of threading, at sewing start or sewing end, be sure to turn the handwheel toward you.

### 飞轮（皮带轮）

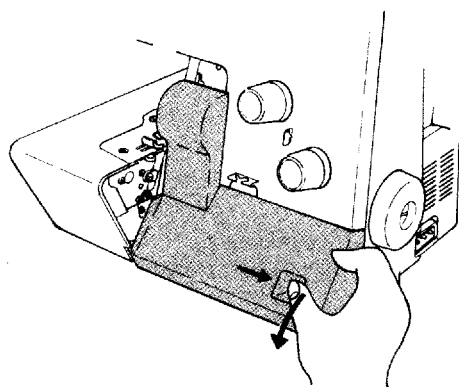
飞轮要正转，在侧盖板上上有箭头指示。

- \* 穿线结束后，开始缝纫或结束时，必须使飞轮沿箭头方向转动。

### Opening and closing the looper cover

Opening : To open the looper cover, pull the looper cover opening handle to the right, and tilt the looper cover toward you.

Closing : To close the looper cover, push up the looper cover, press it lightly to the right. The looper cover closes automatically.



### 弯针罩板的开闭

打开：将弯针罩板向右拉，并沿自己方向旋转。

关闭：将弯针罩板向上翻，并轻轻向右一按，弯针罩板即自动关闭。

**⚠ CAUTION!** Moving parts – To reduce risk of injury, switch machine off ("0") before servicing and when opening looper cover, cloth plate, close before using.

**⚠ 注意！** 以上弯针罩板及缝台的开闭，都必须在开关处于关闭（“0”）状态下进行。

### Opening and closing the cloth plate

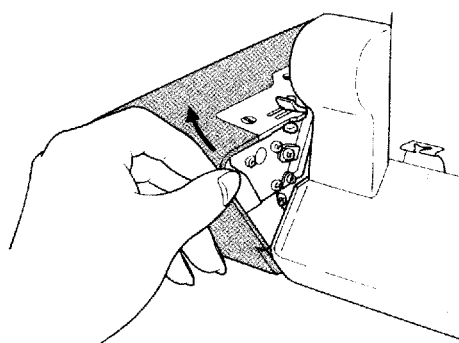
Opening: Press the cloth plate toward outside.

Closing: Push the cloth plate toward the sewing machine.

### 缝台的开闭

打开：将缝台沿箭头方向推。

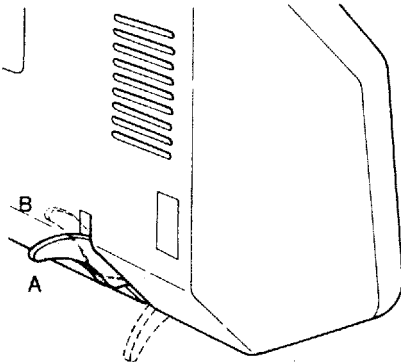
关闭：将缝台沿打开的相反方向推。





### Presser foot lifter (To raise the presser foot by the presser foot lifter)

- A For regular sewing operation (sewing a medium-weight material), raise the presser foot to position (A) illustrated in the figure.
- B When you sew a heavy-weight material, raise the presser foot to position (B) illustrated in the figure, to provide more space between presser foot and throat plate.



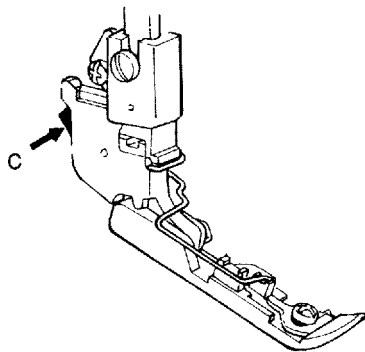
### 抬压脚扳手（可抬起压脚）

- A、常规缝纫时（即缝中等厚度的面料）将压脚抬至 A 位置。
- B、在缝制较厚面料时，将压脚抬至 B 位置。

### Changing the presser foot

⚠ Be sure to turn the power switch OFF.

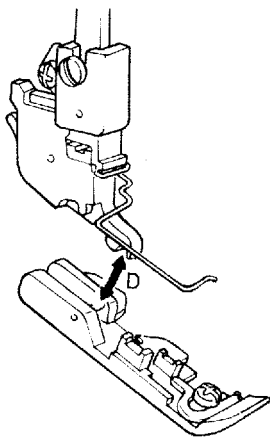
1. Raise the presser foot.
2. Turn the handwheel until the needle is fully raised.
3. Press point (C) illustrated in the figure, and the presser foot will be released.
4. To release the presser foot, raise the presser foot lifting lever to its highest position (B). Then you can release the presser foot easily.
5. To attach the presser foot, place it so that the presser foot pin (D) comes exactly under the groove in the holder. Lower the presser foot lifting lever and the presser foot will engage automatically.



### 更换压脚

⚠ 请切断电源

- 1、抬起压脚。
- 2、转动飞轮，使机针转至最高点。
- 3、沿箭头方向，按 C 便可卸下压脚。
- 4、将压脚扳手抬至最高位置，便可轻而易举地取下压脚。
- 5、换上所需的压脚，使压脚销（D）正好卡在压脚架的凹槽内，放下压脚扳手，压脚便会自动卡住到位。



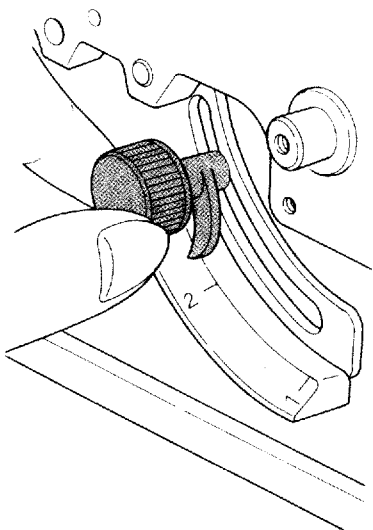


### Stitch length adjusting knob (to adjust the stitch length)

Stitch length is adjustable within the range from 1 to 4 while sewing.

To adjust the stitch length, turn the stitch length adjusting knob and move the knob upwards or downwards.

- For normal overlocking stitches set the stitch length adjusting knob at 2 to 3.



### 送料距调节旋钮（以调节送料距长度）

线迹长度可调范围为 1—4cm。

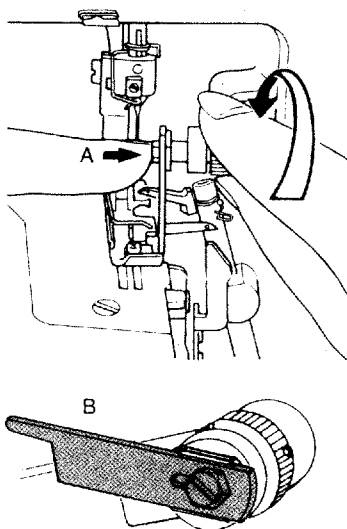
通过调节送料调节旋钮，可调节线迹的长短。

- 通常的包缝线迹长度，设定在送料距调节旋钮 2—3 位置。

### Releasing the upper knife

⚠ Be sure to turn the power switch OFF.

1. Turn the handwheel until the upper knife is fully raised. Open the looper cover.
2. Press the part indicated as (A) in the figure toward the right until it will go no further.
3. Keep pressing (A) and turn the knob on the right side in the direction of the arrow.
4. Turn the knob until the knife reaches position (B).



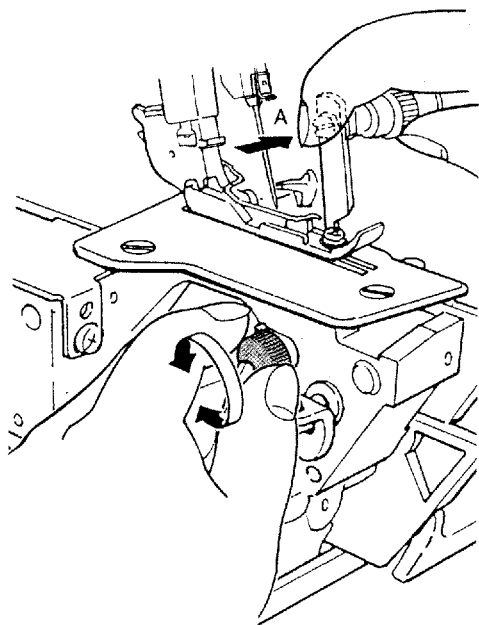
### 上刀的解除

⚠ 请切断电源

- 1、转动飞轮，使上刀处于最高位置，然后打开弯针罩板。
- 2、如图所示，用左手沿箭头 A 方向，将上刀向右按到底。
- 3、左手按住不放，右手沿箭头方向旋转。
- 4、将旋钮转至 B 位置。

### Lower knife adjusting knob (adjusting the lower knife position for cutting width)

- ⚠ Be sure to turn the power switch OFF.
- Turn the lower knife adjusting knob by pressing part (A) in the figure.
- Reduce cutting width (knife moves to the left) if the edges of fabrics curl up
- Increase the cutting width (knife moves to the right) if the loops are too loose



### 下刀调节旋钮（通过调节下刀，来确定切边宽度）

- ⚠ 请切断电源
- 按住零件（A）至所需状态，旋转下刀调节旋钮。
- 如果布边卷曲，说明切边宽度过宽，将刀向左移，以减小切边宽度。
- 如果线环蓬松，说明切边宽度过窄，将刀向右移，以增大切边宽度。

### Overlocking width selection knob (For overlocking or roll hemming)

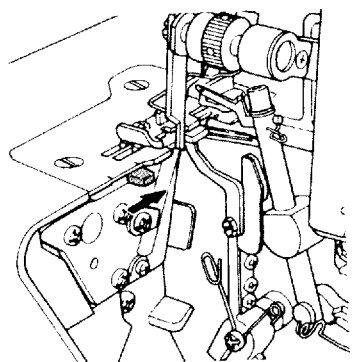
Turn the handwheel until the needles are fully raised

For overlocking

Push the overlocking width selection knob back so that it aligns with the rear red marking on the throat plate.

For roll hemming

1. Pull the overlocking width selection knob forward so that it aligns with the front red marking on the throat plate.
2. Set the lower knife adjusting knob at "1 ~ 2".



### 包缝宽度选择扳手（用于包缝或卷边缝）

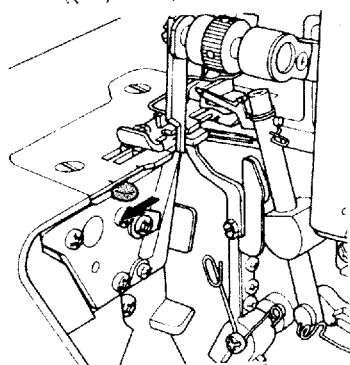
转动飞轮，使机针升至最高位置。

包缝时：

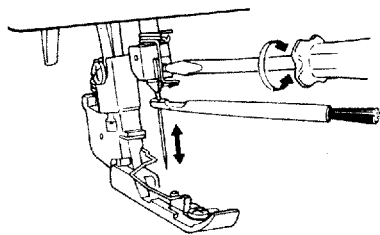
将包缝宽度选择扳手朝后推，使其与针板后面的红色标记对齐。

卷边缝时：

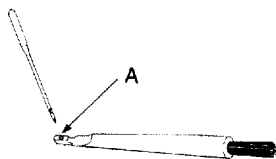
- 1、将包缝宽度选择扳手朝前拉，使其与针板前面的红色标记对齐。
- 2、将下刀调节旋钮设定在“1-2”的位置。



Operation and function/ 操作及功能



Flat side of a needle  
机针扁平部分



Applying the needle attaching hole (A) of the cleaning brush will help replace the needle ease.  
借助除尘刷上的 A 孔，可以方便您更换机针。

Changing the needle ⚠ Be sure to turn the power switch OFF.

1. Turn the handwheel until the needle is fully raised.
2. Before changing the needle, lower or remove the presser foot.
3. Using a small screwdriver, loosen the needle setscrew and remove the needle.
4. Insert the needle with the flat side away from you into the needle clamp, making sure it is inserted as far up as possible. Tighten the needle clamp setscrew securely.

	Types of needle	Thickness
Needle used:	130/705H	No. 75/11 or 90/14

\* When you buy the needles for the sewing machine, select the above type of the needles.

更换机针 ⚠ 请切断电源

- 1、转动飞轮，使机针升至最高位置。
- 2、换机针前放下或卸下压脚。
- 3、用小螺丝刀松掉支针螺钉，取下被换的机针。
- 4、机针扁平部分朝后，插入针夹，确认插足后，拧紧针夹上的支针螺钉。

	型 号	编 号
使用机针	130/705H	No.75/11 或 90/14

\* 购买机针时，请选择相关型号的机针。

Presser foot pressure adjusting screw

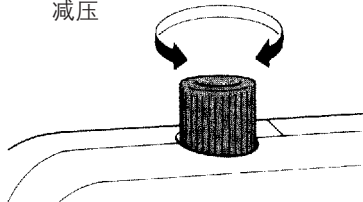
Pressure of the presser foot has been factory-adjusted properly. Therefore you do not need to adjust it except when sewing a special material.

- To increase the pressure of the presser foot: For heavy-weight materials such as denim, tweed, or hard linen
- To decrease the pressure of the presser foot: For light-weight materials such as georgette, lawn, or tricot

(B): The place where the lower part of control cap aligns with the upper face of cover.

Increase  
增压

Decrease  
减压



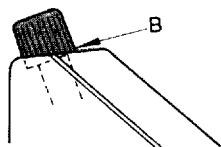
调压螺钉

调压螺钉已由厂方调试适当。

除缝制特殊面料，无需再调整。

- 若遇粗棉布、粗花呢等厚料织物时，必须增加压脚压力。
- 若遇乔其纱、细麻布、针织面料等薄型织物时，必须减小压脚压力。

(B)：使调压螺钉下部与机壳的表面对齐。



# Threading/ 穿线

Thread the machine carefully in the correct sequence.  
This is important for making beautiful seams.

## Preparation

1. Retractable support rod with thread guide must be fully raised.
2. Open the looper cover and cloth plate.
3. Turn the handwheel toward you until the needles are fully raised.
4. Release the upper knife.

## Threading sequence

Colored threading illustrations affixed clearly show the threading sequence.

Thread the machine in the following sequence:

1. Upper looper thread (Blue)
2. Lower looper thread (Red)
3. Needle thread (Green)

Threading aids such as tweezers, needle threader, and looper threader which are provided as accessories will be very useful in threading work.

为了缝制出漂亮的线迹，请正确穿线。

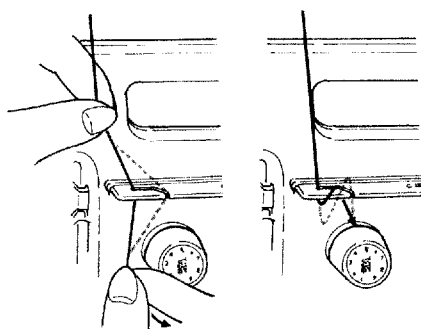
## 准备

- 1、将线架帽拉至最高点。
- 2、打开弯针罩板和缝台。
- 3、正转飞轮转至最高点。
- 4、解除上刀。

## 穿线顺序

为了明确穿线顺序，请按穿线图进行。

- 1、上弯针线（蓝色）
- 2、下弯针线（红色）
- 3、机针线（绿色）

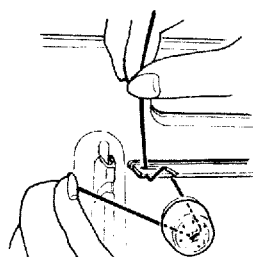


## Thread guide plate

Slide thread into the two slits to form an S-loop.

## 过线导向板

将线通过两槽口，使之呈“S”状的环。



## Threading the tension dials

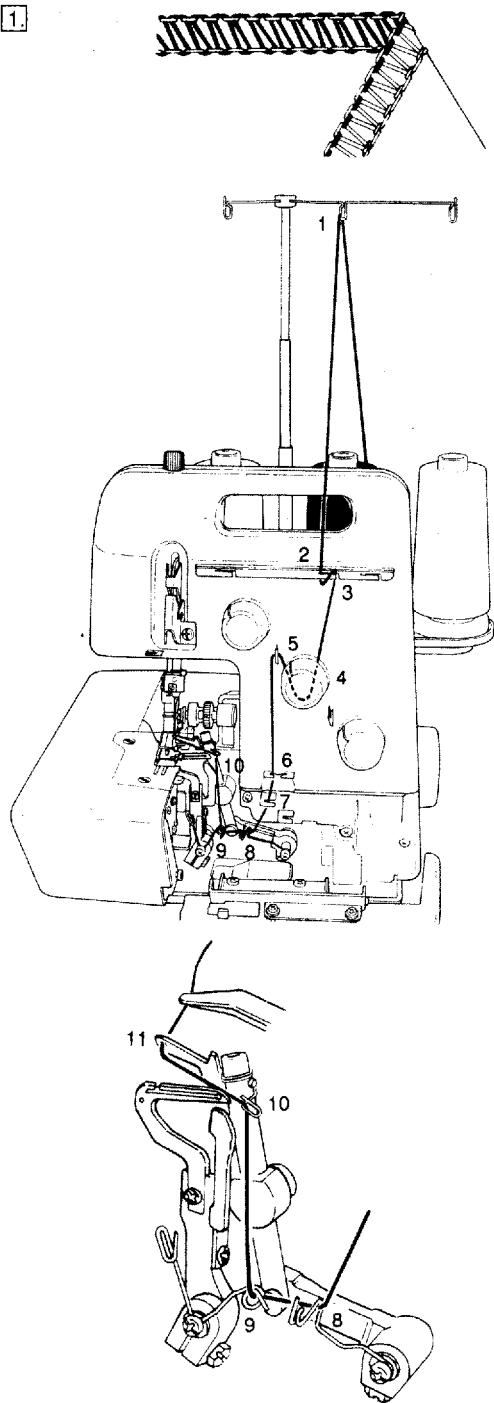
To lay the thread correctly between the tension discs, pull the thread lightly with both hands.

## 通过夹线板

按图正确地将线通过夹线板，用两手轻拉，使线处于夹住状态。

## Threading (1)/ 穿线 (1)

1.



### 1. Upper looper thread (Blue)

Place the spool on the spool holder pin right under blue marking on the retractable support rod thread guide.

- (1) Bring thread up to the retractable support rod thread guide.
- (2, 3) Pass the thread through the thread guide plate.
- (4) Lay the thread between the thread tension dial discs.
- (5, 6, 7, 8, 9, 10) Thread the thread guides.
- (11) Turn the handwheel until the upper looper is fully raised.  
Thread upper looper eye.
- (12) Pull about 10 cm of the thread out.  
Place the thread under the presser foot, and pull the thread from behind the presser foot.

### 1、上弯针线（蓝色）

将线团插入带有蓝色标记的导线勾所对应的插线钉上。

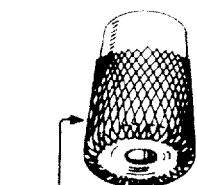
- (1) 将线挂在带有蓝色标记的线勾上。
- (2, 3) 将线通过过线导向板。
- (4) 将线嵌入夹线板之间。
- (5, 6, 7, 8, 9, 10) 将线通过各线导向。
- (11) 转动飞轮，使上弯针升至最高位置，将线穿入上弯针针孔。
- (12) 将线拉出约 10cm 长，抬起压脚，把线放在压脚板下面。

### Use a net for a hard twisted thread.

When a thread coils around the thread guide due to its hard twist, cover the spools of upper looper and lower looper with attached nets.

遇高捻度的线时，请用线团网。

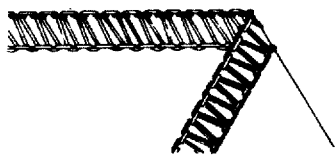
捻度高的线，易缠绕在过线勾上，这时，可用线团网套在上、下弯针线的线团上。



Net  
线团网

## Threading (2)/ 穿线 (2)

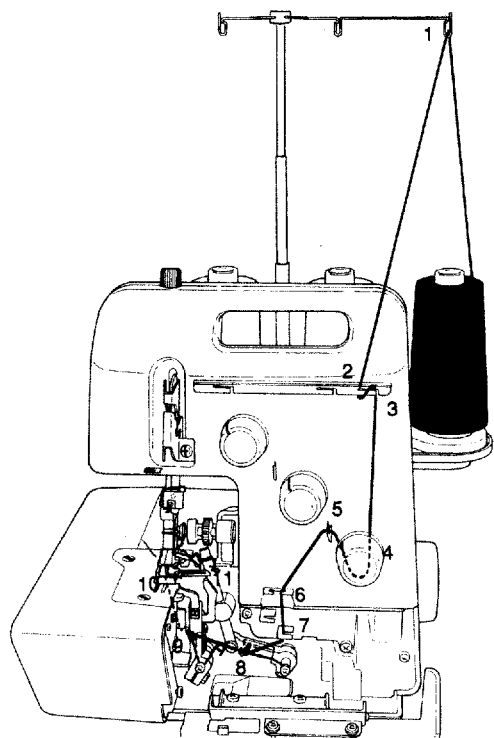
2.



### 2. Lower looper thread (Red)

Place the spool on the spool holder pin right under red marking on the retractable support rod thread guide.

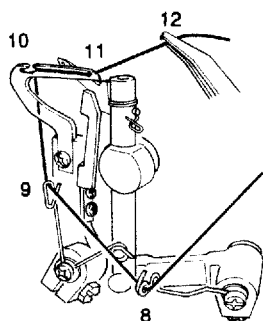
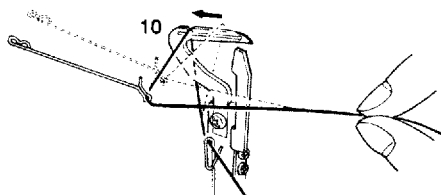
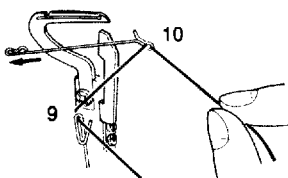
- (1) Bring the thread up to the retractable support rod thread guide.
- (2, 3) Pass the thread through the thread guide plate.
- (4) Thread the thread tension dial.
- (5, 6, 7, 8, 9) Thread the thread guides.
- (10) Using the looper threader, pass the thread from the right through to the left of the sewing machine. Turn the handwheel toward you until the lower looper is in the left-most position. Insert the thread into the slit on the lower looper.
- (11) Using the looper threader, pull the thread through to the right side again. Turn the handwheel toward you until the lower looper is in the right-most position, and thread the looper eye. Pull the thread up until it lies in the long groove on the lower looper.
- (12) Pull about 10 cm of the thread out through the upper looper. Raise the presser foot, place the thread under it and then lower the presser foot. If the lower looper thread is broken or slipped, cut the right-hand needle thread off at the needle. Then remove the thread. Thread the looper and then the needle.



### 2. 下弯针线 (红色)

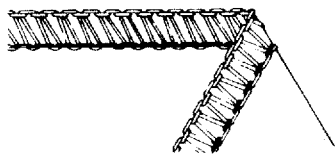
将线团插入带有红色标记的导线勾所对应的插线钉上。

- (1) 将线挂在带有红色标记的线勾上。
  - (2, 3) 将线通过过线导向板。
  - (4) 将线嵌入夹线板之间。
  - (5, 6, 7, 8, 9) 将线通过各线导向。
  - (10) 用弯针线穿线勾将线挂在其弯勾上，转动飞轮，使下弯针至最左点，将线挂在下弯针的后槽。
  - (11) 将弯针线穿线勾向右移，移动飞轮，使下弯针至最右点，将线穿入下弯针针孔，然后拉出足够长的余线。
  - (12) 当余线拉至约 10cm 长时，将线与上弯针线一道向后拉，抬起压脚，把线放在压脚板的下面，然后放下压脚。
- 如果下弯针断线或缝线脱落，则先将机针线剪断，并拉掉缝线，待穿好下弯针线后，再穿机针线。



## Threading (3)/ 穿线 (3)

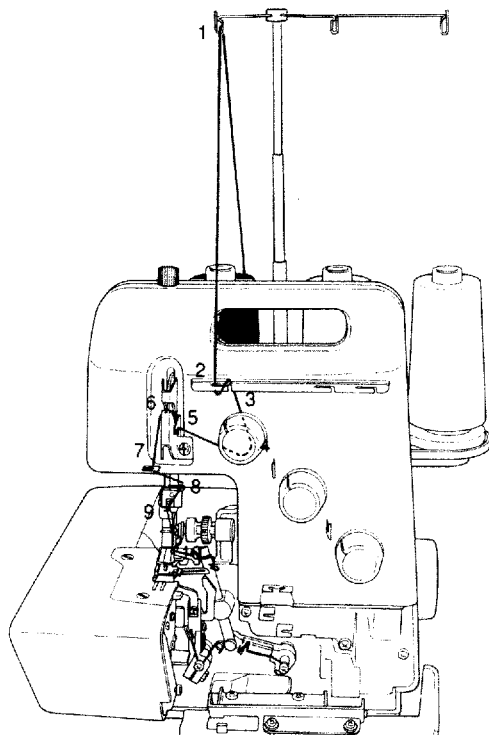
3.



### 3. Needle thread (Green)

Place the spool on the spool holder pin right under the green marking on the retractable support rod thread guide.

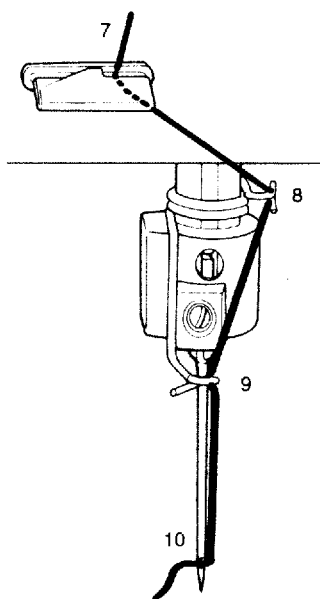
- (1) Bring the thread up from the spool to the thread guide the green thread guide.
- (2, 3) Thread the thread guide plate.
- (4) Thread the thread tension dial.
- (5) Thread the thread guide.
- (6) Lay the thread in the notch on the thread take-up lever.
- (7) Thread the thread guide.
- (8, 9) Thread the needle thread guides.
- (10) Thread the needle. Pull about 10 cm of the thread out from the needle eye. When threading is completed, lower the upper knife and close the looper cover and cloth plate.



### 3 机针线 (绿色)

将线团插入带有绿色标记的导线勾所对应的插线钉上。

- (1) 将线挂在带有绿色标记的线勾上。
- (2, 3) 将线通过过线导向板。
- (4) 将线嵌入夹线板之间。
- (5) 将线通过线导向板。
- (6) 将线挂在挑线杆护罩的缺口处。
- (7) 将线穿过线导向板。
- (8, 9) 将线穿过机针线导向。
- (10) 将线穿过机针孔，在穿过针孔约 10 厘米左右时，将余线放在压脚板下面，并将上刀复原，并关闭缝台和弯针罩板。

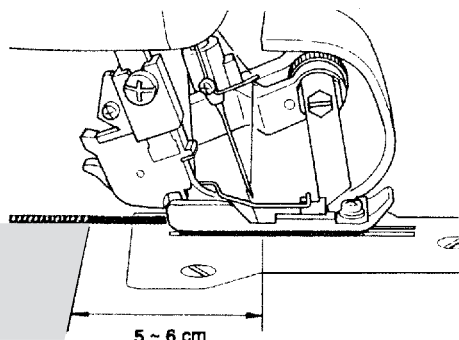




### After threading, make a trial sewing.

Be sure to use a double layer of fabric in order to check whether the seam and thread tension are adequate.

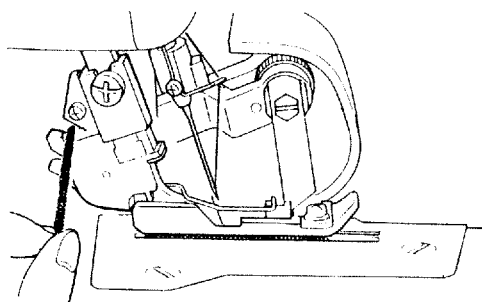
1. Set all of the thread tension dials at "4".
  2. Make sure that the upper knife is lowered (in the cutting position).
  3. Raise the presser foot.
  4. Place the fabric under the presser foot.
  5. Lower the presser foot and sew.
  6. At the end of the seam, continue sewing to form a 5 to 6 cm long thread chain.
  7. Holding the fabric with one hand, pull the thread chain over the thread cutter on the presser foot shank.
- \* Thread tension dial should be properly adjusted according to the types of fabrics and threads to be used.



### 穿线完成后，便可进行试缝

请将面料对折成两层后缝纫，以确认缝迹和张力的调节是否最佳。

- 1、将各线的张力刻度都调为“4”。
  - 2、放下上刀，使其处于切布状态。
  - 3、抬起压脚。
  - 4、将面料放在压脚下。
  - 5、放下压脚，并开始试缝。
  - 6、缝至面料末端后，继续空缝 5—6 厘米。
  - 7、一手拉面料，同时将空缝线拉至压脚后的切刀上，将线环切断。
- \* 张力旋钮应根据缝料与缝线的规格而异，相应进行调节。



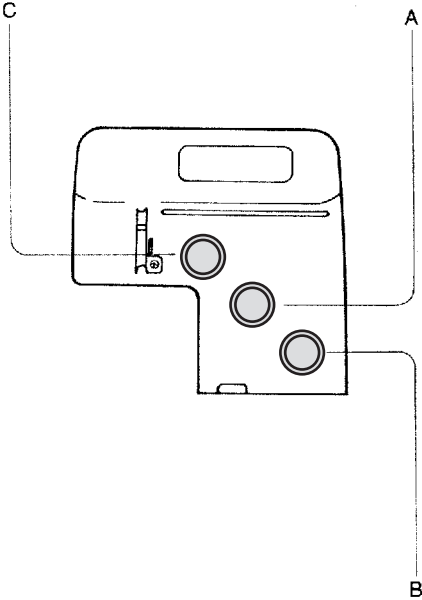
Thread tension dial/ 线张力调节旋钮

Adjusting the thread tension

Imperfect stitch formation can be corrected by adjusting the set value (1 to 9) on the thread tension dial.

		Standard of the thread tensioner dial
A	Upper looper thread tension adjusting dial	3 ~ 5
B	Lower looper thread tension adjusting dial	3 ~ 5
C	Needle thread tension adjusting dial	3 ~ 5

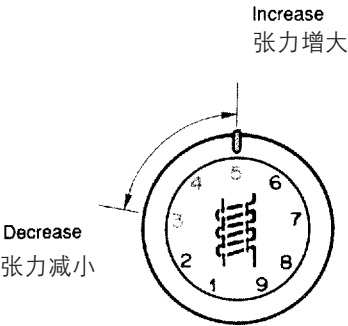
Turning to the right increases the thread tension.  
Turning to the left decreases the thread tension.  
When using filament thread or woolly nylon thread, adjust the thread tension accordingly.



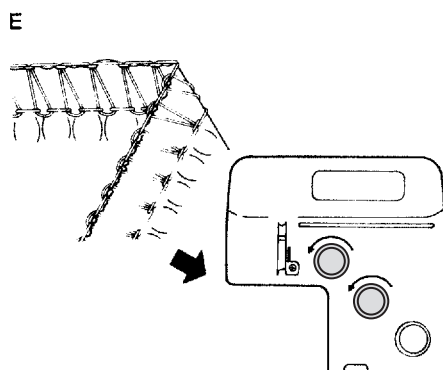
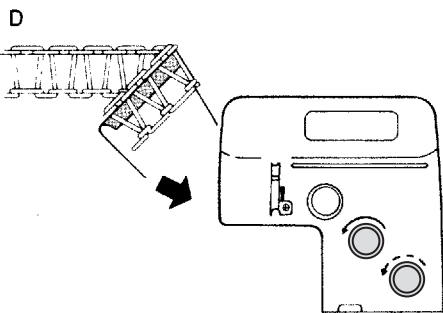
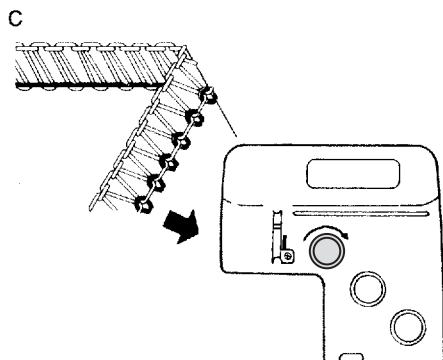
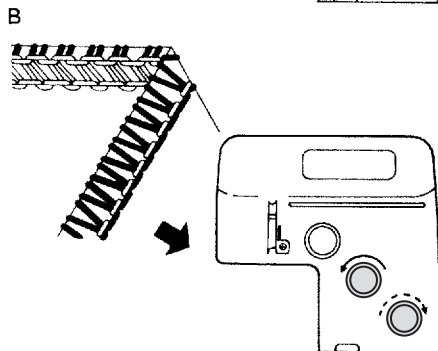
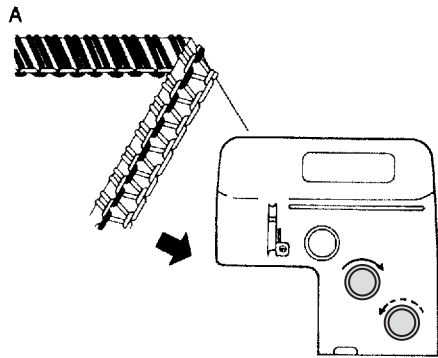
调节线张力

当线迹不良时，可以对线张力旋钮进行调节，调节范围为 1—9。

		标准位置
A	上弯针张力调节旋钮	3—5
B	下弯针张力调节旋钮	3—5
C	机针张力调节旋钮	3—5



## Adjusting the thread tension/ 调节线张力



### Adjusting the thread tension

Turn the thread tension dial in the direction of the arrow, and make a trial sewing.

A – If the upper looper threads meet on the underside of the fabric:

B – If the lower looper thread meet on the upper side of the fabric:

C – If the overlock needle thread forms loops on the underside of the fabric:

D – The edge of the fabric curls when both upper looper and lower looper thread tension is too high:

\* Adjustment can be made by setting the lower knife adjusting knob to the smaller value on the scale.

E – If the fabric puckers during sewing:

### 调节线张力

根据箭头方向转动旋钮，并试缝。

A— 如果上弯针线翻向面料的下面；

B— 如果下弯针线翻向面料的上面；

C— 如果机针线在面料的下面呈环状；

D— 当上、下弯针线张力过强，会产生布边被折叠；

\* 调节时，请将下刀调节旋钮调到较小数值范围内。

E— 遇面料起皱时；

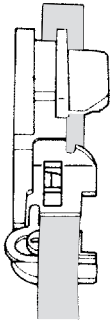
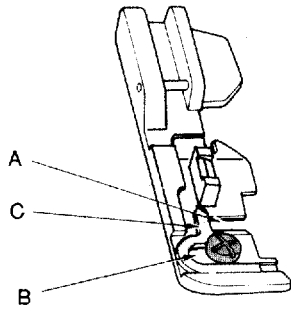
## Sewing in tape/ 镶带缝



### Sewing in tape

The standard presser foot is equipped with a tape guide. When sewing shoulders or side seams of stretchy fabrics as a knitted fabric, a tape works effectively to prevent undesirable stretch of the fabric.

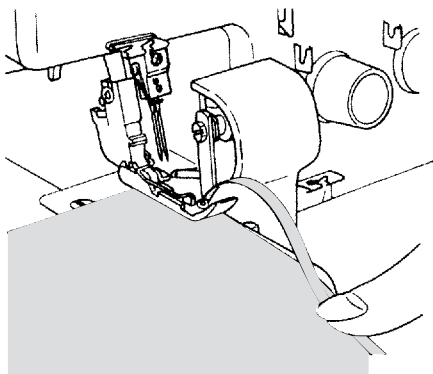
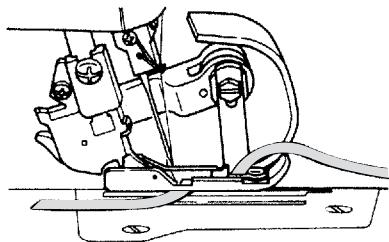
1. Turn the handwheel toward you until the needles are fully raised.
2. Raise the presser foot, place the tape in the groove (A) on the presser foot, and lower the presser foot.
3. Loosen the guide adjusting screw (B) to fit the tape guide (C) to the tape width, then tighten the screw.
4. Turn the handwheel manually to make two or three stitches in the tape.
5. Place the fabric to be sewn under the presser foot.
6. Sew, guiding the tape lightly.



### 镶带缝

标准压脚上备有镶带导向装置，在缝制上衣肩部或延伸性织物的边缘时用，以防止面料的伸展。

- 1、正转飞轮，使机针转至最高点。
- 2、抬起压脚，将镶带放入压脚槽（A）内，放下压脚。
- 3、旋松导向装置的调节螺钉（B），使得导向板（C）的宽度与镶带宽度相等时，再旋紧螺钉。
- 4、用手转动飞轮，使线在镶带上缝制2—3针。
- 5、将面料放在压脚下面。
- 6、缝制开始，镶带会随同面料一同行进。



## Roll hemming/ 卷边缝

### Roll hemmer

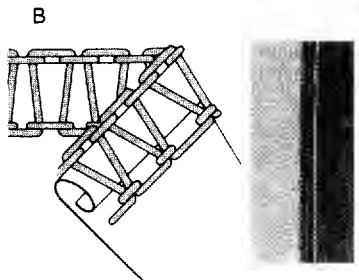
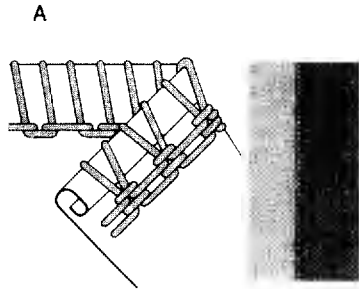
The roll hemmer is built-in to the sewing machine. The fabric edge is automatically rolled and oversewn. The result is a very fine and narrow edge finishing.

- Turn the overlocking width selection knob toward you to align with the red marking in front of the throat plate.

- Set the stitch length adjusting knob (stitch length) at "1 ~ 1.5".

A – For roll hemming, pull the selection lever back to the red marking on the stitch plate furthest from the presser foot

B – For overlocking, push the selection lever forwards to the red marking on the stitch plate nearest the presser foot



### 卷边缝

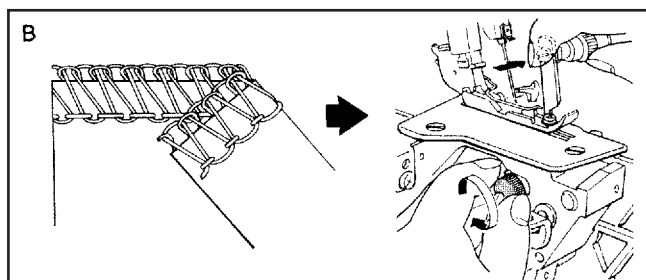
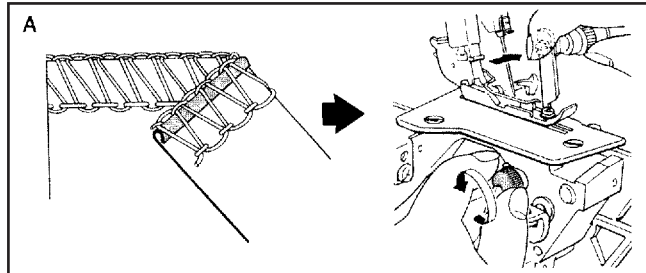
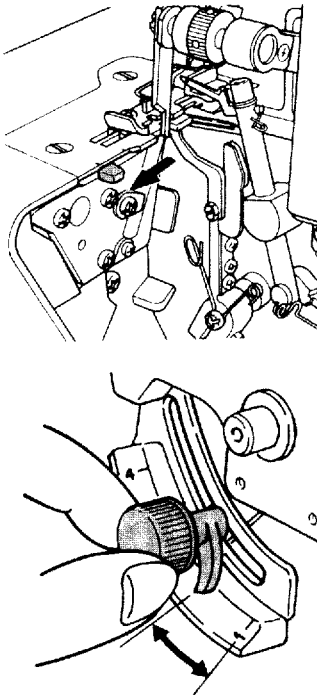
卷边装置镶嵌在机器内部，面料边缘可被自动卷起并包缝，效果很佳，边缘窄且光滑。

1、将包缝宽度选择扳手朝自己方向的红色标记处拉。

2、将送料距调节旋钮调至 1-1.5。

A—卷边缝，是用上弯针线包住面料边的。

B—窄边缝，是用一般包缝线迹缝制的，但切割宽度要窄一些。



### Cutting width

⚠ Be sure to turn the power switch OFF.

- Open the cloth plate. Raise presser foot.
- Turn the lower knife adjusting knob by pressing part in the figure.
- Close cloth plate cover and lower presser foot.

Reduce cutting width (knife moves to the left) if the edges of fabrics curl up (A). Increase the cutting width (knife moves to the right) if the loops are too loose (B).

Note: The red line on the stitch plate indicates the basic knife position.

If the lower knife comes in contact with the throat plate after you have decreased the cutting width, do not turn the lower knife adjusting knob any further.

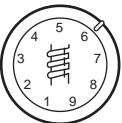


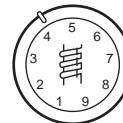
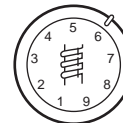
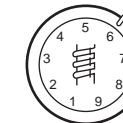
## Standard thread tension list for roll hemming (rolled hem, narrow overlock stitch)

1. Thread tension slightly differs depending on the types of the fabric and thread
2. Use the woolly nylon thread or thinner thread for roll hemming to attain the beautiful finish.
3. Use the thin spun thread thinner than #80.
4. Woolly nylon thread can be used only for the upper looper.

### 卷边缝线张力调节表

(用于卷边缝和窄边缝)

- 1、根据面料和缝线情况不同，缝线张力也稍有不同。
- 2、用毛状尼龙线或较细的线卷边，缝迹会显得较漂亮。
- 3、用比 80# 还细的精纺线。
- 4、毛状尼龙线只能用在上下弯针上。

Thread tension dial value 线张力旋钮刻度	For rolled hem 卷边缝			For narrow overlock stitch 窄边缝		
	Needle thread 机针	Upper looper 上弯针	Lower looper 下弯针	Needle thread 机针	Upper looper 上弯针	Lower looper 下弯针
Thread to be used 缝线型号						
Spun thread #80 精纺线 80#	4 ~ 6	3 ~ 5	7 ~ 9	4 ~ 6	5 ~ 7	4 ~ 6
Filament thread #80 锦纶线 80#	3 ~ 5	3 ~ 5	6 ~ 8	3 ~ 5	3 ~ 5	3 ~ 5
Woolly nylon thread 毛状尼龙线		3 ~ 5			3 ~ 5	

### 切边宽度

⚠ 必须切断电源

- 打开缝台，抬起压脚。
- 旋转下刀调节旋钮，直至所需状态。
- 关闭缝台，放下压脚。

如遇 A 状态时，表示切刀宽度过宽。

如遇 B 状态时，表示切刀宽度过窄。

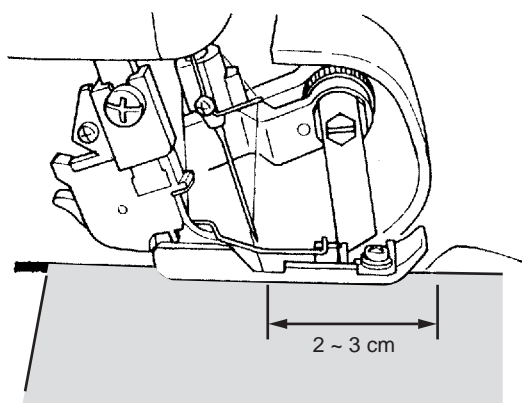
注意：红线为切刀宽度的基本位置。

如下刀与针板相碰，说明切刀宽度已最窄，这时，您无须再调节下刀调节旋钮。

## Thread breakage during sewing/ 缝纫中的断线

### Thread breakage during sewing

1. Turn the workpiece at a right angle direction and stop sewing immediately. Then remove the workpiece.
2. Rethread.
  - \* If the lower looper thread is broken, cut the both needle threads off at the needle. Then remove the threads. Thread the lower looper and then the needles.
  - \* If the upper looper thread is broken, remove the looper to lowest position. Then thread the looper thread.Bring the thread through under the presser foot and pull about 10 cm of the thread out behind the presser foot.
3. Raise the presser foot, and place the workpiece under the presser foot. Sew about 2 to 3 cm over the seam which has already been sewn before the thread breakage.

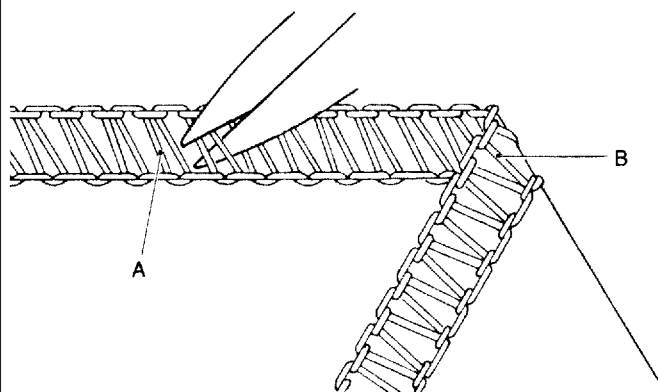


### 缝纫时遇断线

- 1、马上停止缝纫，取出面料。
- 2、重新穿线
  - \* 如下弯针断线。则要剪断机针线并拉掉，待下弯针线穿好后，再穿上机针线。
  - \* 如上弯针断线，则要将上弯针转至最低位置，便于弯针线重穿。
- 3、抬起压脚，将面料放在其下面，在断线处前面约2—3厘米处开始重新缝纫。

### Unpicking seams

Unpicking the seams of the 3-thread overlock  
Cut the thread at (A) with scissors and pull needle thread (B).  
The stitches will come undone.



### 缝口的拆法

将3线包缝拆开

用剪刀在 (A) 处将线剪断，在 (B) 处将线拉掉，缝迹就会脱开。



## Securing seams/ 缝口的合拢

### Securing seams

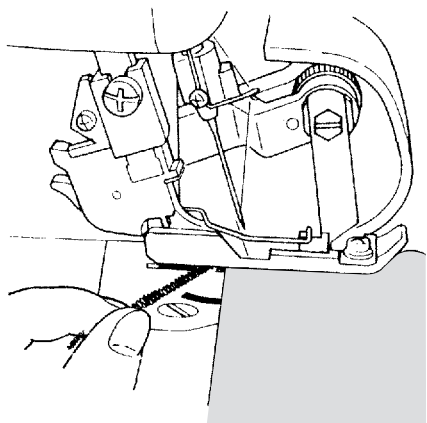
1. Sew about 3 to 4 cm of the thread chain at the beginning of seams.
  2. Sew 2 to 3 stitches on the fabric.
  3. Lower the needle and raise the presser foot.
  4. Stretch the thread chain and lay it between the presser foot and the fabric from the left.
  5. Lower the presser foot and sew over the thread chain.
- If you do not sew over the thread chain, be sure to leave enough thread chain at the beginning and end of a seam so that it can be knotted or pulled through the stitches with a darning needle.
- \* When seams cross over one another, the thread chain is automatically closed.

### 缝口的合拢

- 1、先缝 3—4 厘米空环。
- 2、在面料上缝制 2—3 针。
- 3、放下机针，抬起压脚。
- 4、拉长空环，并从左面把它放入压脚与面料之间。
- 5、放下压脚，将空环与面料一起缝纫。

如果空环不缝入，就必须在缝口的始末处留以足够的空环，以便打结或用织补针穿入缝口。

\* 当缝口互相交叉时，缝迹便会自动闭合。



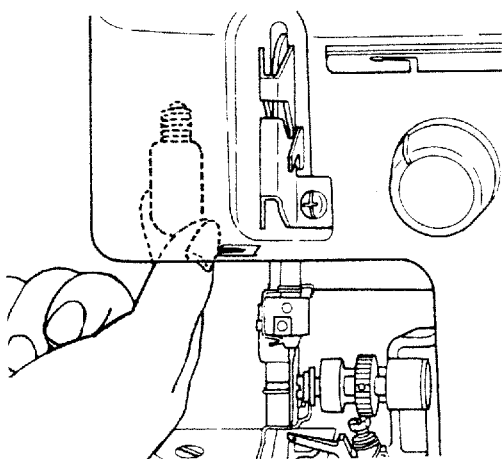
### Replacing the knives

请与购买店联系

### Replacing the bulb

⚠ Be sure to turn the power switch OFF.

Unscrew the bulb and replace it with a new one. The power consumption of the bulb is 10W(220V). The bulbs are available from your local dealer.



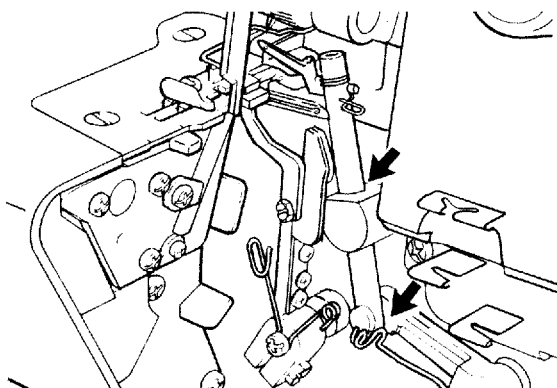
### 更换灯泡

⚠ 注意请关闭电源！

旋下灯泡，换上新的，灯泡规格为 10W（220V），灯泡一定要旋紧。

### Cleaning and lubrication

During sewing, dust and fluff collects in and on the machine. Remove the dust and fluff regularly. Your sewing machine requires a little lubrication as the main components of the sewing machine are made from special materials. Apply a few drops of oil to the parts illustrated in the figure.



### 清洁注油

在缝纫过程中，布屑和绒毛会散落在机器的表面和内部，所以，必须经常清理。由于机器的一些重要零件制作工艺特殊，故需要注油润滑，如图所示的部位注上数滴油即可。

## Troubles and corrective measures: Before you call for help

The following problems should not be regarded as the machine trouble. Check the following table before you call for help from us.

Trouble	Cause (reason)	Corrective measures	Page for reference
Fabric does not feed	1. Presser foot pressure is too low.	Increase the presser foot pressure by turning the presser foot pressure adjusting screw to the right.	9
Needle break	1. Needle is bent, or the needle point is blunt.	Replace the needles.	9
	2. Needle is incorrectly attached.	Attach the needle correctly.	9
	3. The material cloth is excessively stretched.	Hold the edge of the material cloth lightly with your hand when sewing.	—
Thread breaks	1. The machine is incorrectly threaded.	Rethread the machine correctly	10 – 13
	2. Thread tension is too high.	Adjust the thread tension properly.	15,16
	3. Needle is incorrectly attached.	Attach the needle correctly.	9
Stitch skips	1. Needle is bent or needle point is blunt.	Replace the needle.	9
	2. Needle is incorrectly attached.	Attach the needle correctly.	9
	3. The machine is incorrectly threaded.	Rethread the machine correctly.	10 – 13
Poor stitches are formed	1. Thread tension is not proper.	Adjust the thread tension properly.	15,16
Seams pucker	1. Thread tension is too high.	Set the thread tension adjusting dial to the smaller value.	15,16
	2. The machine is threaded incorrectly, or threads are caught in the points other than the normal thread path.	Rethread the thread correctly.	10 – 14
Motor trouble	1. The motor makes noise.	Replace the carbon brush.	—
	2. The motor will not rotate.		
	3. Unusually large sparks are emitted.		

When the trouble is not corrected by the above measures, contact your local dealer.

### 报修前：故障及处理方法

下列故障并非机械故障，请先查阅下表，再向我们提出报修。

故障	原因	处理方法	参考页次
面料不行进	1、压脚压力太小	将调压螺钉向右旋，以增加压脚压力	9
断针	1、机针弯曲或针尖磨损	换针	9
	2、机针装错	正确装针	9
	3、缝料拉得过长	缝制时用手轻拉布边	—
断线	1、穿线错误	重新正确穿线	10–13
	2、线张力过强	适当调节线张力	15, 16
	3、机针装错	正确装针	9
跳针	1、机针弯曲或针尖磨损	换针	9
	2、机针装错	正确装针	9
	3、穿线错误	重新正确穿线	10–13
线迹成形不良	1、线张力不当	适当调节线张力	15, 16
缝口起皱	1、线张力过强	将线张力调至较小值	15, 16
	2、穿线不正确	重新正确穿线	10–14
马达故障	1、马达噪音	更换电机碳刷	—
	2、马达不转		
	3、出现罕见的火花		

如还不能排除故障，则与购买商联系

Specifications/ 规格

• Specifications

Item	Specifications
Number of threads	3 threads
Needle	130/705H
Overlocking width	Standard 4.0 mm (for roll hemming: 2 mm)
Stitch length (feeding amount)	1 to 4 mm (standard stitch length: 2.5 mm)
Presser foot lift	5 mm
Sewing speed	Max. 1,500 s.p.m.
Dimensions	270 (W) x 260 (D) x 295 (H) mm
Weight	6.8 Kg

规格

项 目	规 格
缝线数	3 线
机针	130/705H
包缝宽度	标准宽度 4.0mm
针迹长度（送料量）	1-4mm（标准长度 2.5mm）
压脚升降高度	5mm
缝速	最大 1500 针 / 分
外形尺寸	270 (W) × 260 (D) × 295 (H) mm
重量	6.8kg

## Optional accessories/另购附件

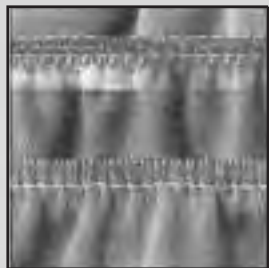
- Blind stitch presser foot
- 暗缝压脚



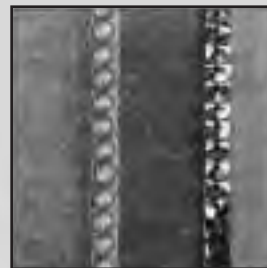
- Piping presser foot
- 滚带压脚



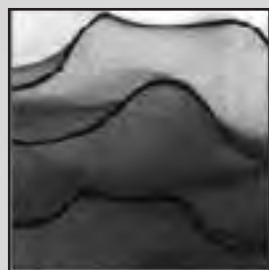
- Elasticator
- 弹簧压脚



- Beading presser foot
- 珍珠压脚



- Cording presser foot
- 花边压脚



- 2/3 Thread Conveter
- 2/3切换器



- Gathering presser foot
- 聚裊压脚



Contact your local dealer.  
如需上述附件, 请与购买店联系



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