

# UH SERIES

寶獅牌工業用縫紉機 INDUSTRIAL SEWING MACHINE

MODEL  
UH8000

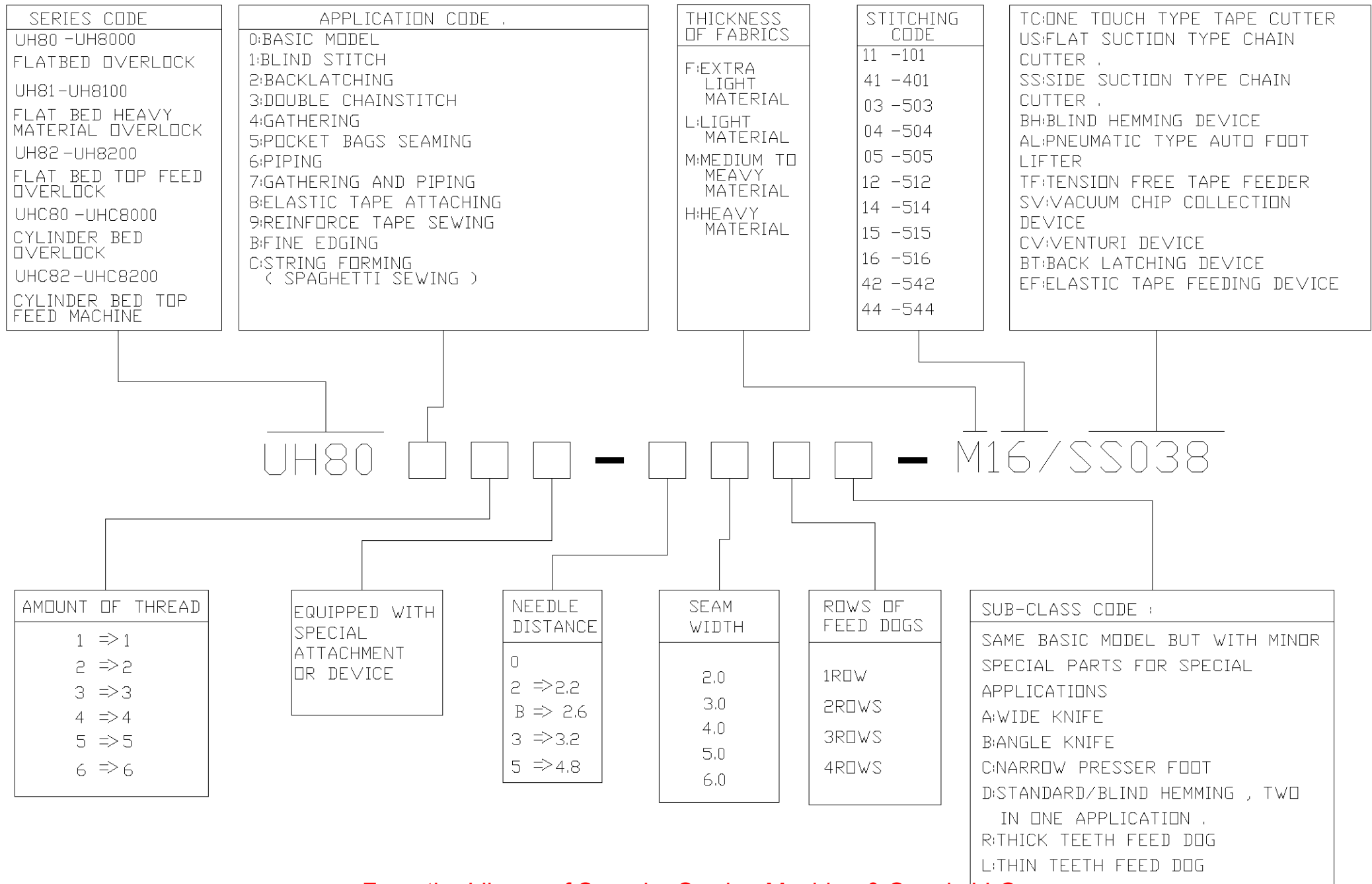


User Manual



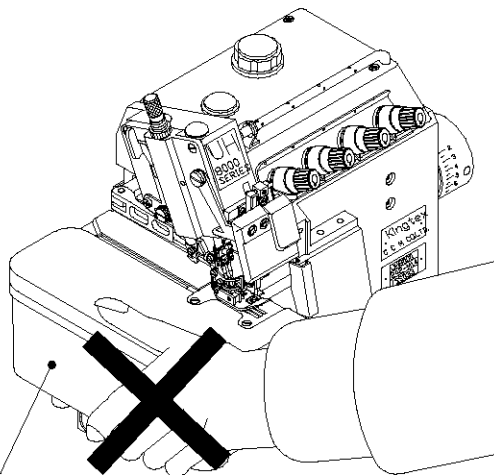
精機機械廠股份有限公司 CHING CHI MACHINE CO., LTD  
<http://www.kingtexsewing.com.tw>

# UH8000 SERIES MACHINE NUMBERING SYSTEM



# 1. INSTALLATION

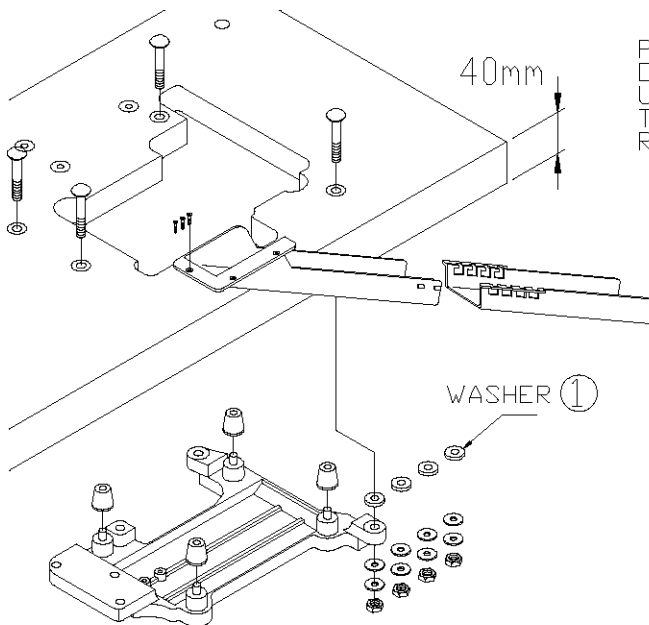
## 1-1 MOVING:



DURING INSTALLATION  
PROCESS, DO NOT MOVE  
SEWING MACHINE BY  
HOLDING CLOTH PLATE.

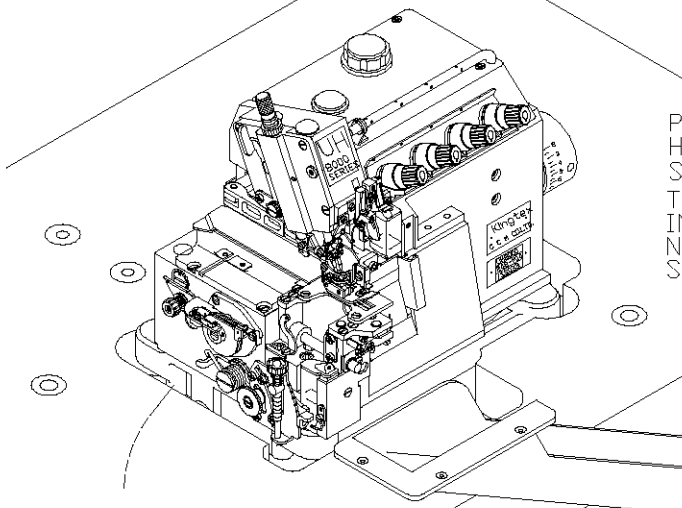
CLOTH PLATE COVER

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



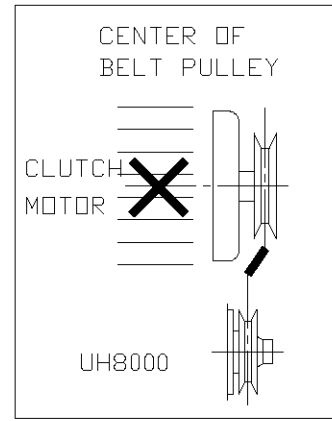
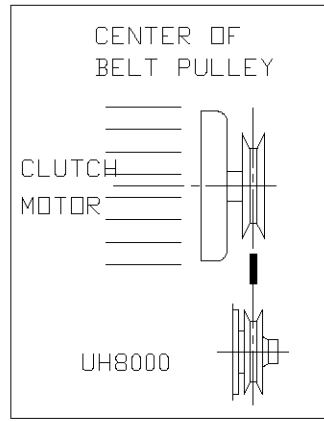
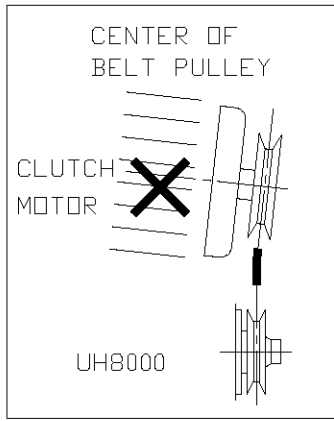
PLEASE USING STANDARD TABLE  
OF 40 mm IN THICKNESS. IF  
USE THE TABLE IN 35 mm IN  
THICKNESS, THEN, PLEASE  
REFER TO INSTALLATION MAP.

## 1-3 INSTALLATION OF SEWING MACHINE :

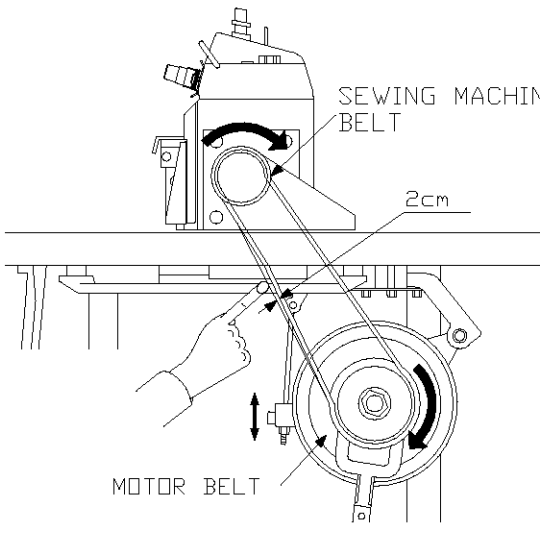


PLEASE MAKE SURE THERE  
HAVE ENOUGH ROOM BETWEEN  
SEWING MACHINE AND THE  
TABLE AROUND IT AFTER  
INSTALLATION, TABLE CAN  
NOT INTERFERENCE WITH THE  
SEWING MACHINE.

1-4. INSTALLATION OF MOTOR BELT :

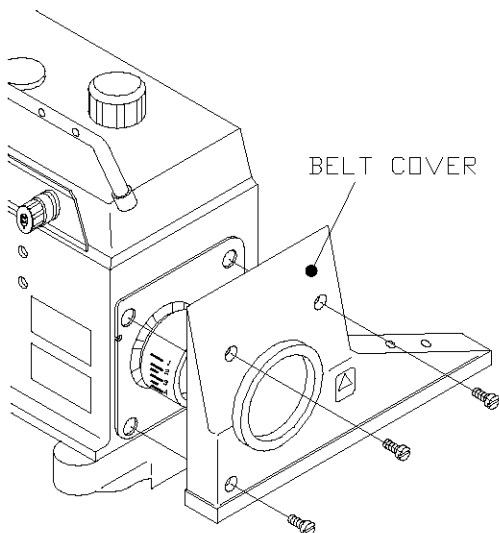


INSTALL MOTOR BELT AND MAKE SURE MOTOR BELT IN PARALLEL WITH BOTH PULLEY OF CLUTCH MOTOR AND SEWING MACHINE BY ADJUSTING CLUTCH MOTOR'S POSITION PROPERLY .



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

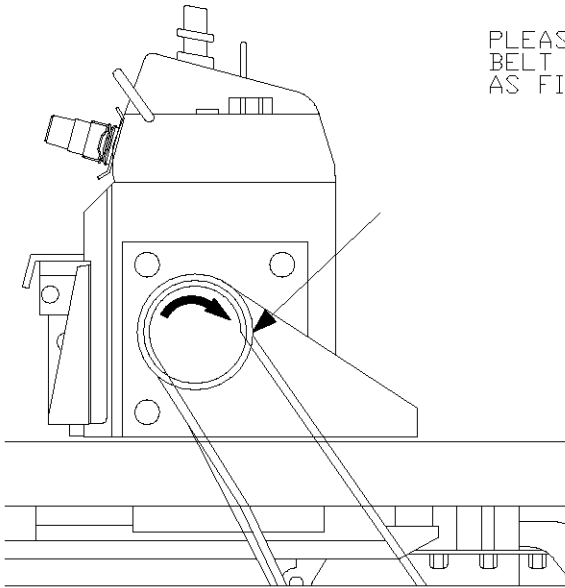
1-5 INSTALLATION OF BELT COVER :



FOR SAFETY REASON , BELT COVER MUST BE INSTALLED .

## 2. BEFORE OPERATION :

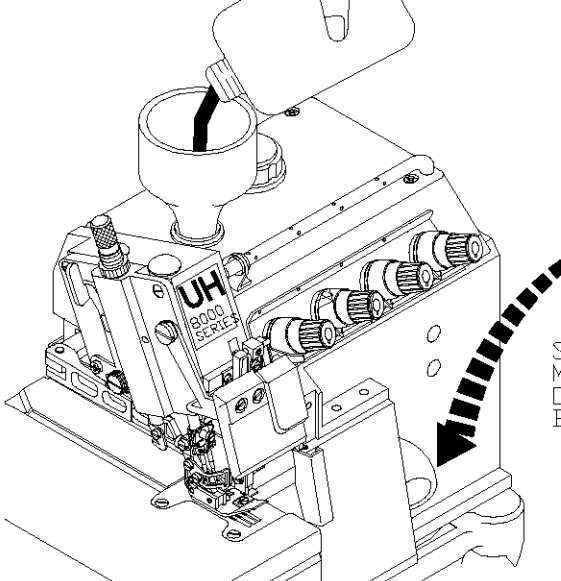
### 2-1 TURNING DIRECTION OF BELT PULLEY:



PLEASE MAKE SURE SEWING MACHINE'S BELT PULLEY IS TURNING CLOCKWISE , AS FIGURE 2-1 .

### 2-2 ADDING LUBRICATION OIL AND SILICON OIL :

#### ADDING LUBRICATION OIL

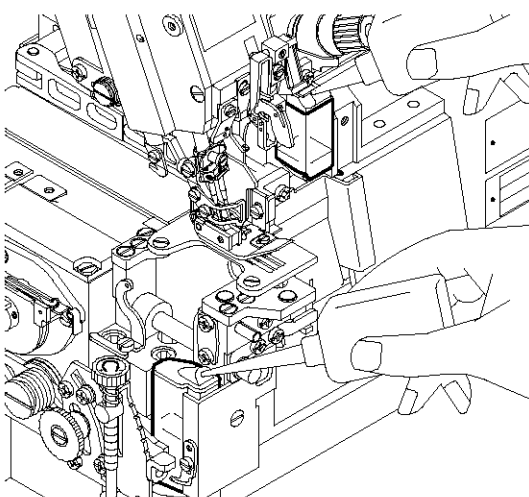


DURING ADDING PROCESS , PLEASE MAKE SURE THE LUBRICATION OIL CAN NOT OVER THE UPPER LIMIT OF OIL GAUGE .



SPECIFICATION OF LUBRICATION OIL:  
MOBIL VELOCTE 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.

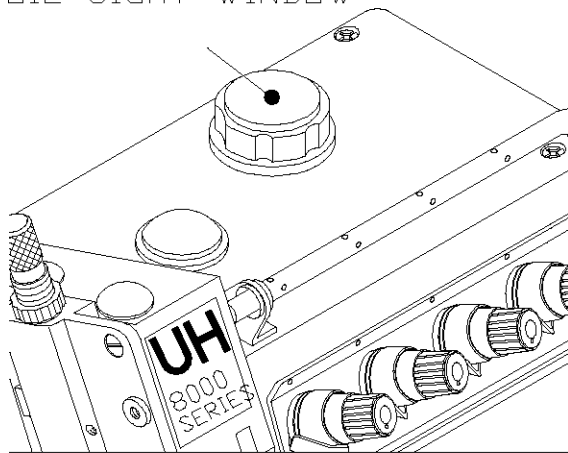
SPECIFICATION OF SILICON OIL:  
UNION CARBIDE CORP. UCC L-45 (10)  
OR SAME SPECIFICATION OF OTHER  
BRAND'S SILICON OIL .

### 3. TEST SEWING AND ADJUSTING :

#### 3-1 DESCRIPTION :

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

#### OIL SIGHT WINDOW

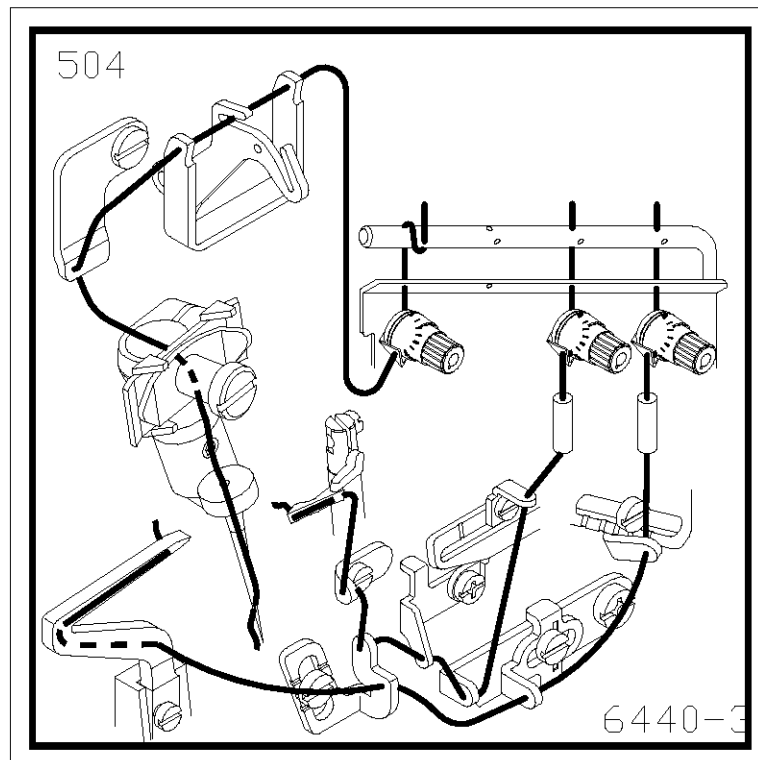


DURING THE FIRST USAGE, PLEASE MAKE SURE LUBRICATION OIL CIRCULATES PROPERLY.

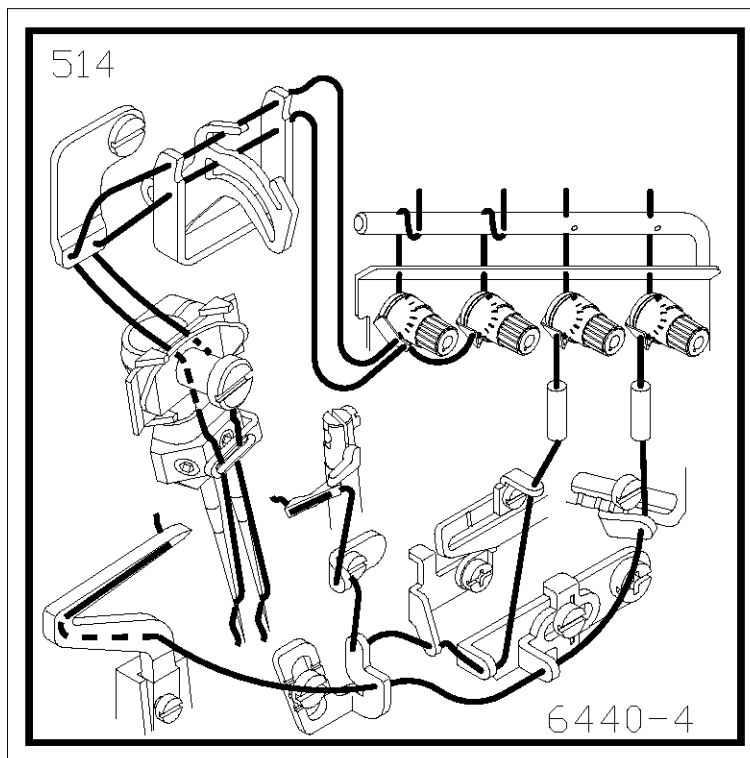
#### 3-2 THREADING MAP :

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

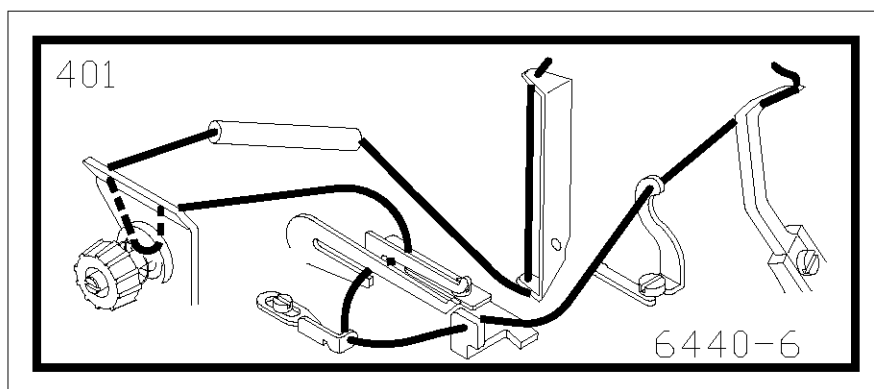
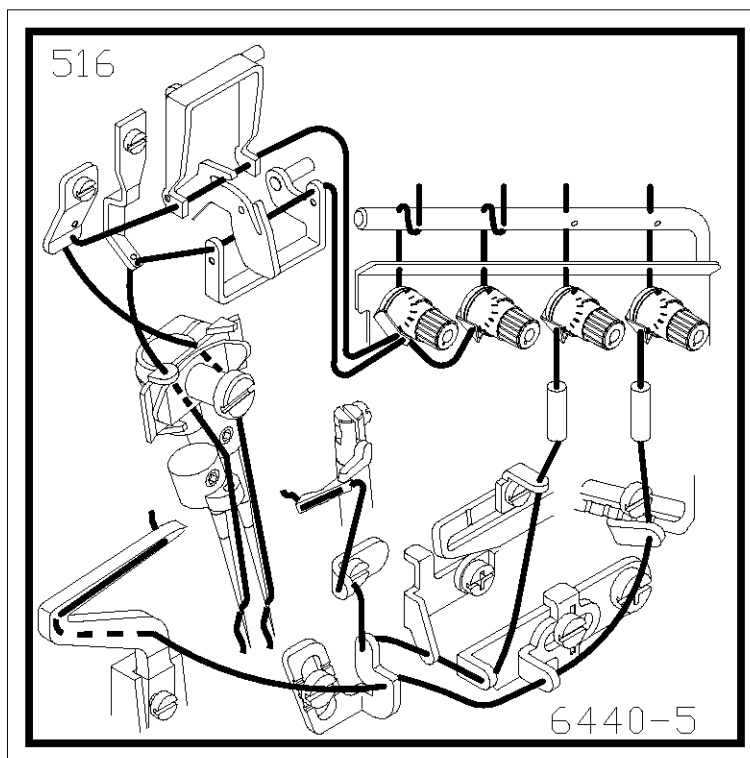
UH8003, STITCH TYPE 504,



UH8004 , STITCH TYPE 514 ,

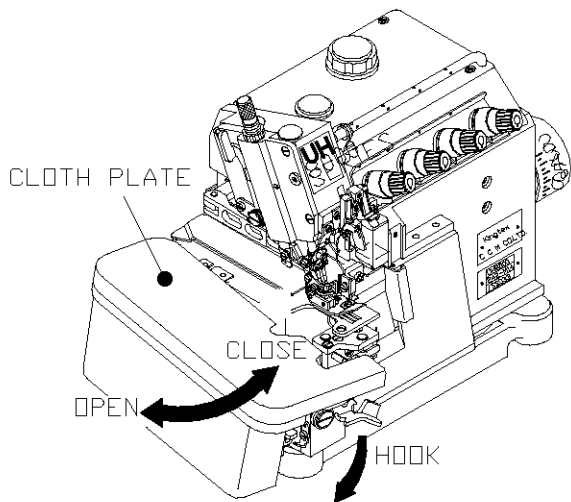


UH8005 , STITCH TYPE 516 ,

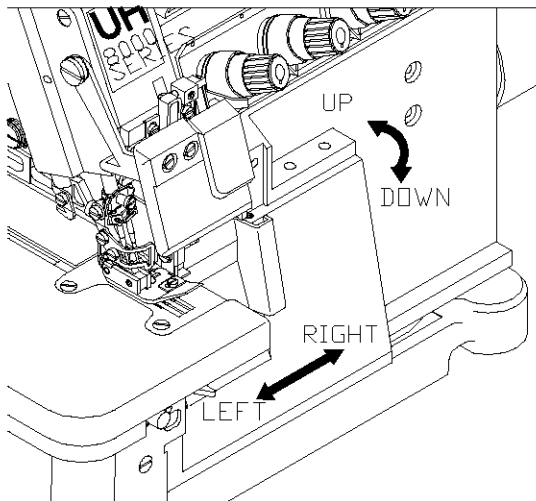




### 3-3 OPEN AND CLOSE THE CLOTH PLATE AND FRONT COVER :

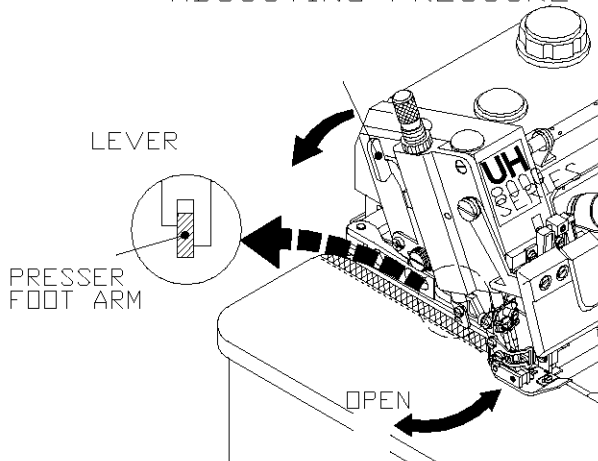


PRESS DOWN HOOK AND PUSH TO LEFT IN ORDER TO OPEN CLOTH PLATE , PUSHING RIGHT TO ITS HOOK SET POSITION , THE CLOTH PLATE WILL BE CLOSED .

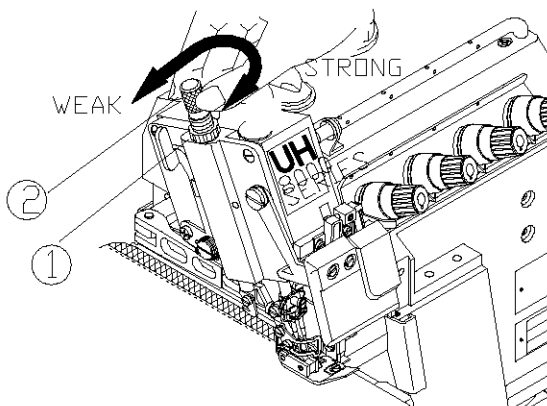


OPEN AND CLOSE FRONT COVER : PUSHING FRONT COVER TO RIGHT SET POSITION AND PULL DOWN TO OPEN IT . AND ON THE OTHER HAND , PULL UP TO ITS SET POSITION AND TO LEFT IN ORDER TO CLOSE FRONT COVER . AFTER CLOSING FRONT COVER , PLEASE MAKE SURE THERE IS NO INTERFERENCE BETWEEN FRONT COVER AND OTHER PARTS .

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



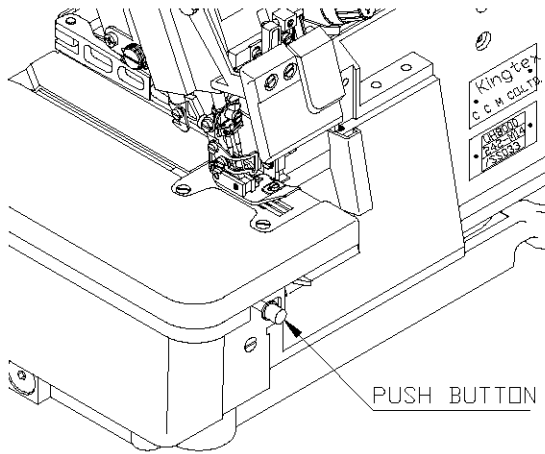
OPEN AND CLOSE THE PRESSER FOOT ARM : PUSH LEVER DOWN TO ITS SET POSITION THEN TAKE OUT PRESSER FOOT ARM . VICE VERSA , PUSH DOWN LEVER TO ITS SET POSITION , CAN PUT PRESSER FOOT ARM BACK . WHEN PUT PRESSER FOOT ARM BACK , PLEASE MAKE SURE IT WILL BE BACK TO ITS SET POSITION .



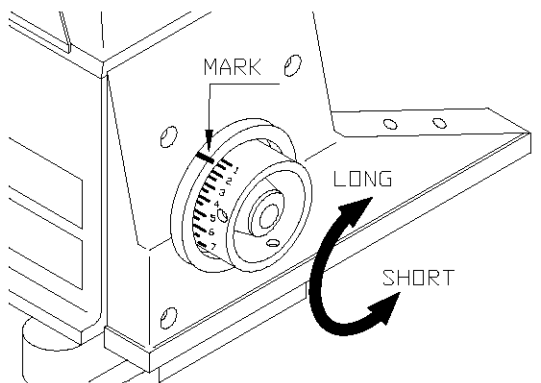
ADJUSTING PRESSURE  
TURNING ADJUSTING SCREW  
CLOCKWISE IN ORDER TO INCREASE PRESSURE  
TURNING ADJUSTING SCREW  
COUNTERCLOCKWISE IN ORDER TO  
DECREASE PRESSURE .



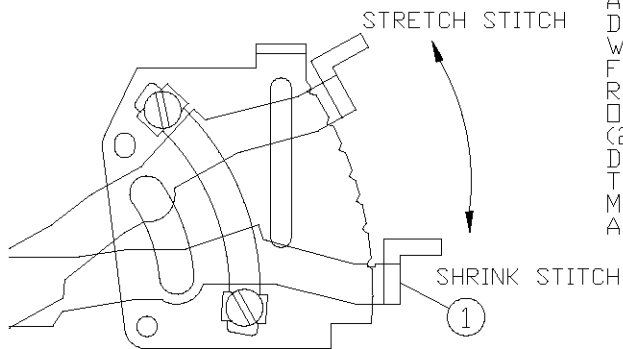
### 3-5 ADJUSTING STITCH LENGTH AND DIFFERENTIAL RATIO :



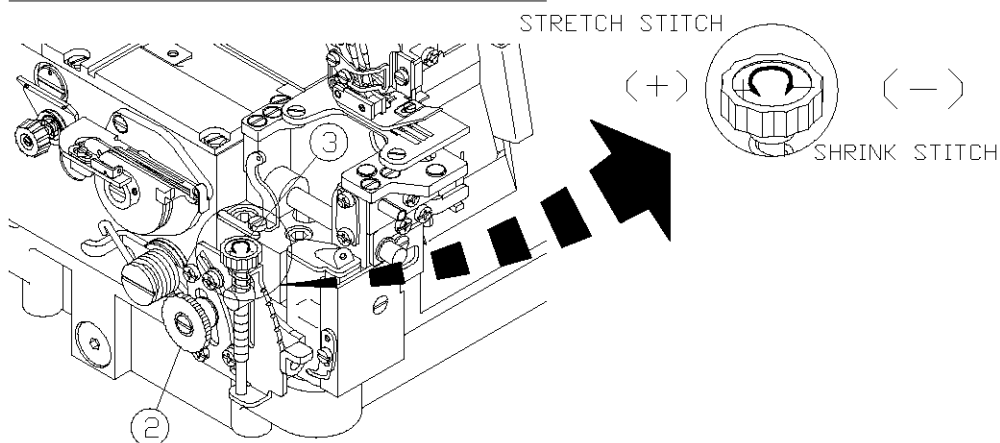
ADJUSTING STITCH LENGTH :  
 PUSHING THE PUSH BUTTON  
 LIGHTLY FIRST AND TURNING  
 PULLEY TO SET POSITION THEN  
 PUSHING DOWN THE PUSH BUTTON  
 INTO ITS SET POSITION AND ADJUST  
 THE LENGTH OF STITCH .



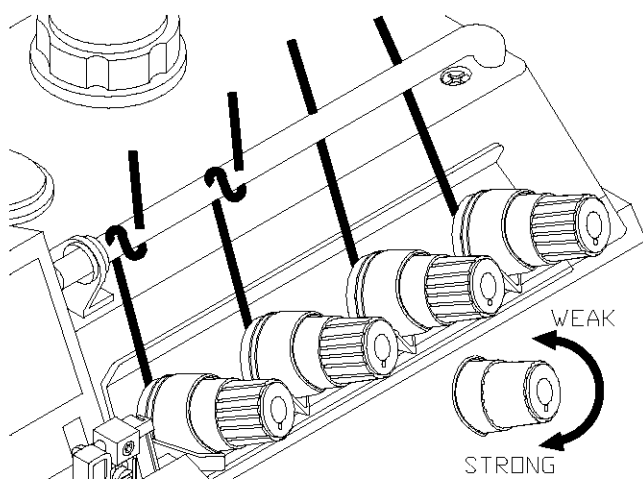
REMARK : THE DISTANCE MARK ON  
 THE PULLEY ONLY REPRESENT  
 APPROX LENGTH OF STITCH AND  
 ACTUAL STITCH LENGTH NEEDED  
 SHOULD GET FROM TEST SEWING .



ADJUSTING DIFFERENTIAL RATIO :  
 DIFFERENTIAL RATIO WAS SET AT 1 : 1  
 WHEN MACHINES WERE OUT OF  
 FACTORY . ADJUST DIFFERENTIAL  
 RATIO AS NEEDED .  
 OPEN UP CLOTH PLATE , 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) .

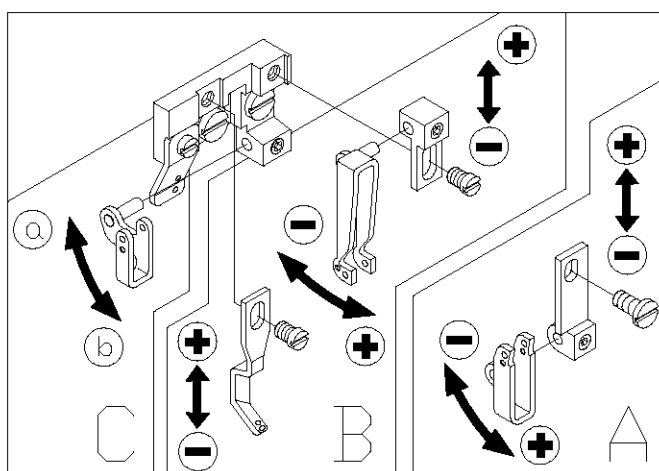


### 3-6 ADJUSTING THREAD TENSION AND TENSION AMOUNT :



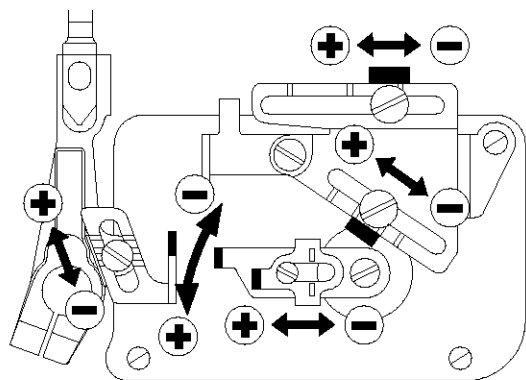
ADJUSTING THREAD TENSION  
 THREAD TENSION CORRELATE WITH  
 THREAD TENSION AMOUNT . PLEASE  
 REFER TO THIS ITEM AND NEXT ITEM  
 TO ADJUST THREAD TENSION  
 AMOUNT IN ORDER TO GET BEST  
 RESULT .  
 TURNING CLOCKWISE IN ORDER TO  
 GET STRONG THREAD TENSION .  
 TURNING COUNTERCLOCKWISE IN  
 ORDER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

#### NEEDLE THREAD TENSION AMOUNT :



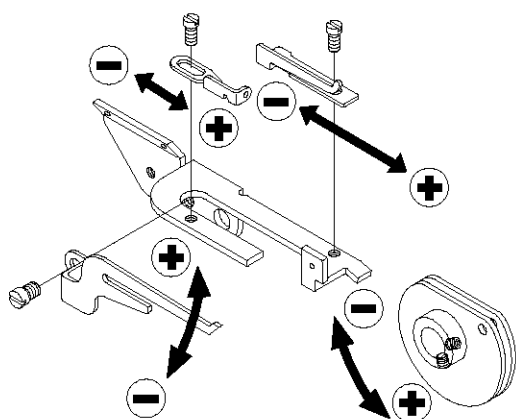
A : FOR UH-8003 , UH-8004 USAGE ,  
 TOWARD (+) DIRECTION GET  
 BIGGER THREAD TENSION AMOUNT .  
 TOWARD (-) DIRECTION GET  
 SMALLER THREAD TENSION AMOUNT .  
 B : FOR UH-8005 USAGE ,  
 TOWARD (+) DIRECTION IN ORDER  
 TO GET BIGGER THREAD TENSION AMOUNT  
 TOWARD (-) DIRECTION IN  
 ORDER TO GET SMALLER THREAD  
 TENSION AMOUNT .  
 C : IF CHAIN STITCH NEEDLE THREAD  
 LOOP FORMED TOO EARLY , PLEASE  
 ADJUST THREAD GUIDE TO @  
 DIRECTION .

#### UPPER / LOWER LOOPER THREAD TENSION AMOUNT :



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

#### CHAINSTITCH LOOPER THREAD TENSION AMOUNT :

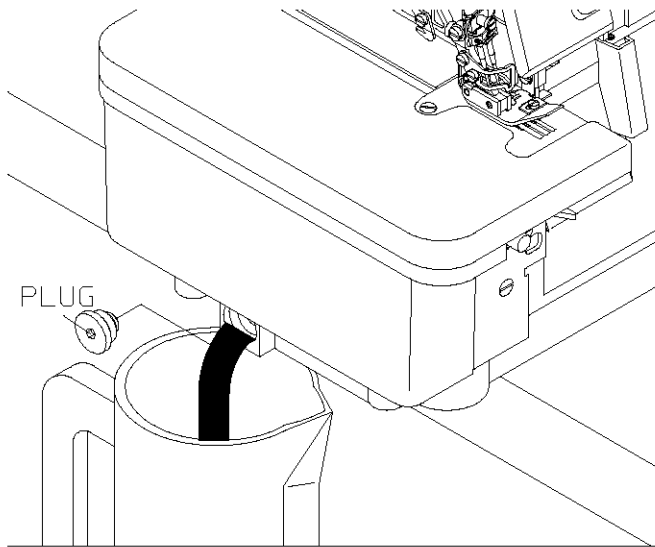


WHEN ADJUSTING CHAINSTITCH  
 LOOPER THREAD , IF THREAD LOOP  
 COLLAPSE , UNSTABLE OR CAN NOT  
 FORM THREAD LOOP , PLEASE ADJUST  
 THREAD TENSION AMOUNT  
 ACCORDING TO ARROW DIRECTION  
 (+) INCREASE .  
 (-) DECREASE .

#### 4. REPAIRING AND MAINTENANCE :

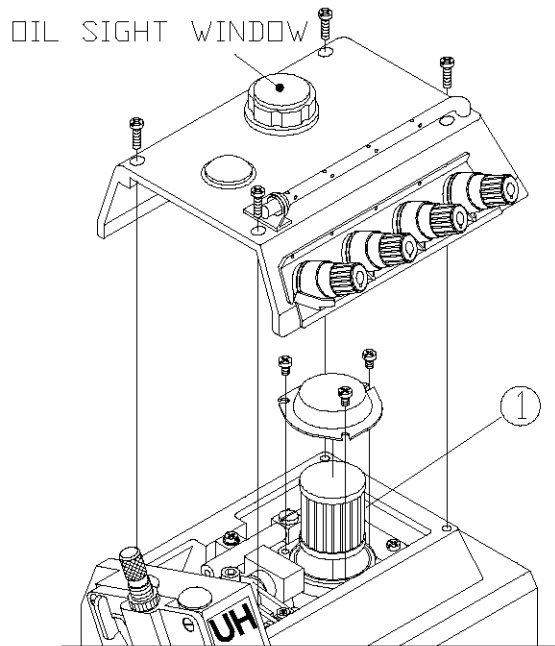
##### 4-1 CHANGING LUBRICATION OIL , OIL FILTER AND NEEDLES

###### CHANGE LUBRICATION OIL .



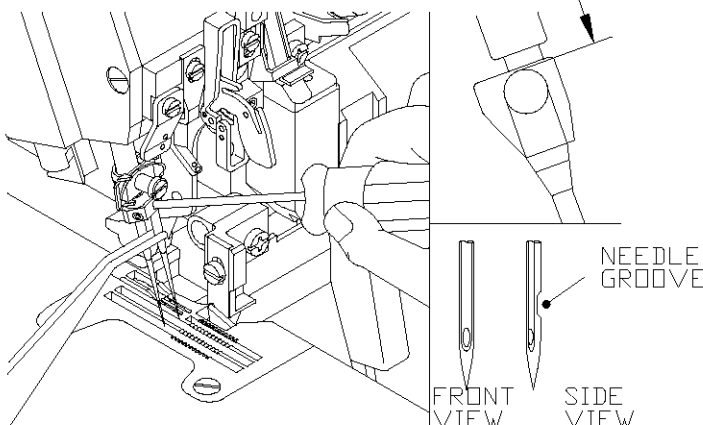
AFTER OPERATING SEWING MACHINE FOR 160-200 HOURS ( APPROX ONE MONTH ) PLEASE CHANGE LUBRICATION OIL AND CHANGE LUBRICATION OIL EVERY 6 MONTHS THEREAFTER . IF STOP USING SEWING MACHINE FOR A LONG TIME , PLEASE CHANGE LUBRICATION OIL BEFORE OPERATE AGAIN . CHANGE LUBRICATION OIL BY TAKE OFF PLUG .

###### 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

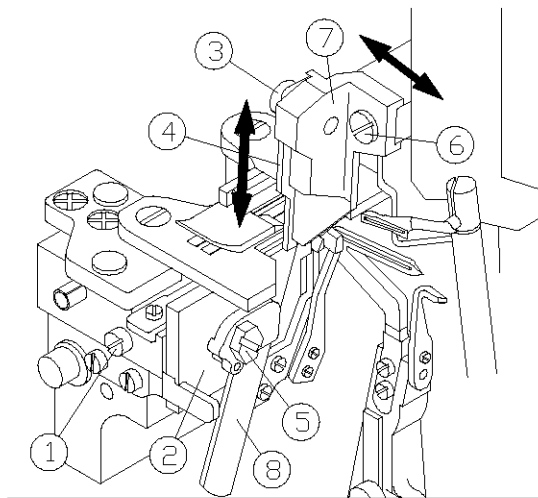


MAKE SURE TO INSERT NEEDLES ALL THE WAY TO THE BOTTOM OF NEEDLE HOLES .

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

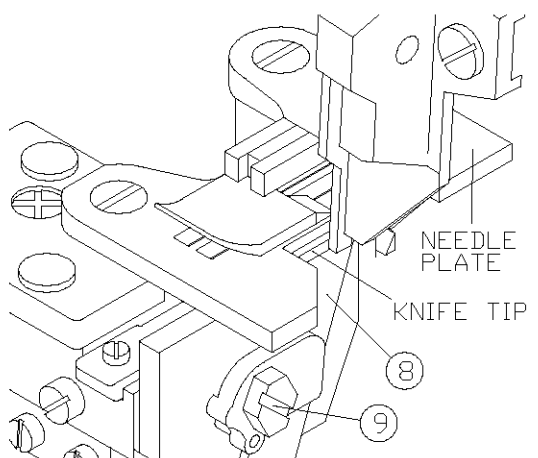
## 4-2 CHANGING UPPER , LOWER KNIFE :

### CHANGING UPPER KNIFE:

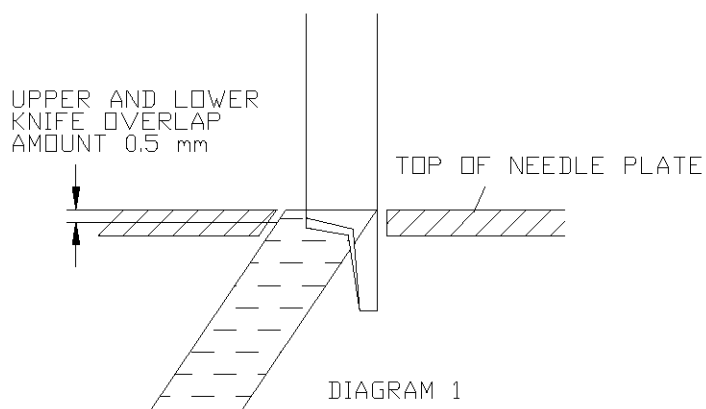


- A . LOOSEN SCREW (1) PUSH LOWER KNIFE HOLDER (2) TO LEFT , THEN , TIGHTEN SCREW (1) LIGHTLY .
- B . TAKE OFF SCREW (3) CHANGE NEW UPPER KNIFE (4) . THEN , TIGHTEN SCREW (3) LIGHTLY .
- C . LOOSEN SCREW (1) MAKE SURE LOWER KNIFE (8) TOUCH UPPER KNIFE CLOSELY .
- D . TURNING HAND WHEEL TILL UPPER KNIFE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

### CHANGING LOWER KNIFE

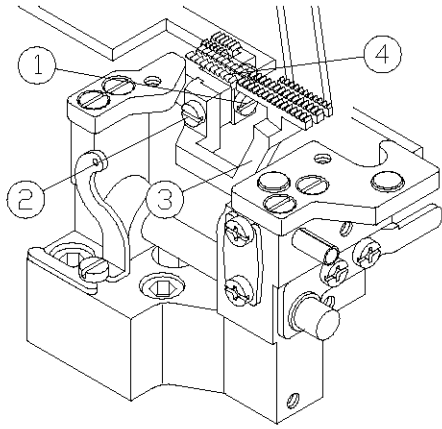


- A . LOOSEN SCREW (1) PUSH LOWER KNIFE HOLDER (2) TO LEFT , THEN , TIGHTEN SCREW (1) LIGHTLY .
- B . LOOSEN SCREW (9) TAKE OFF OLD LOWER KNIFE (8) AND CHANGE NEW LOWER KNIFE .
- C . MAKE SURE THE TIP OF LOWER KNIFE LINE EVEN WITH THE TOP OF NEEDLE PLATE , THEN , TIGHTEN SCREW (9) .
- D . LOOSEN SCREW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



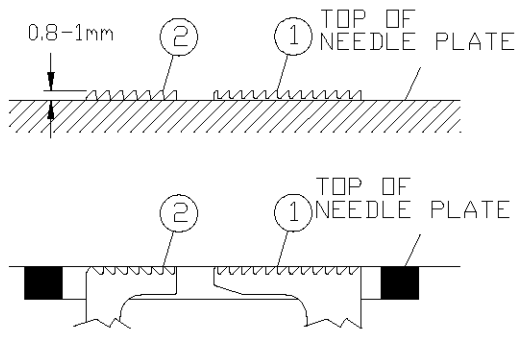
## 4-3 CHANGING AND ADJUSTING FEED DOGS .

### 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.

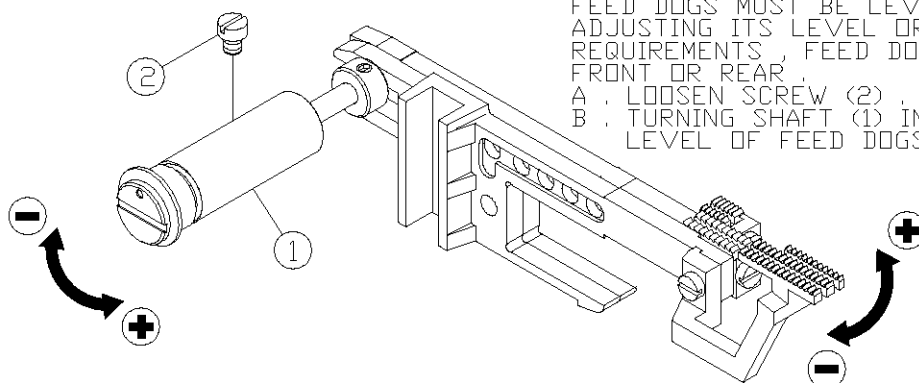
### ADJUSTING FEED DOGS AFTER CHANGED :



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 0.8-1 mm. ( 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.

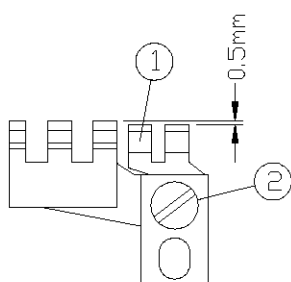
AFTER ADJUSTING, PLEASE TIGHTEN SCREW (1), (2) AND IN THE SAME TIME, PLEASE MAKE SURE  
 a. IF FEED DOGS WILL RAISE 0.8~1 mm, ABOVE THE TOP OF NEEDLE PLATE BY TURNING BELT PULLEY AND MOVING FEED DOG UP,  
 b. IF FEED DOGS WILL HIDE UNDERNEATH THE NEEDLE PLATE BY KEEP TURNING BELT PULLEY.

### 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.

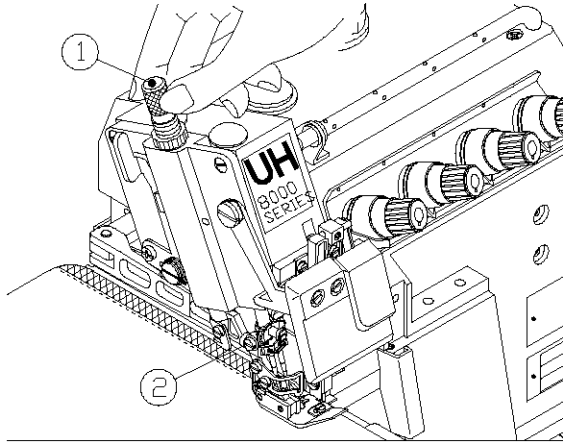
### ADJUSTING THE HEIGHT OF AUXILIARY FEED DOG:



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

## 4-4 CHANGING AND ADJUSTING PRESSER FOOT SET

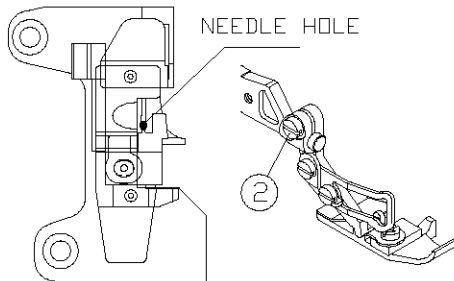
CHANGE PRESSER FOOT SET :



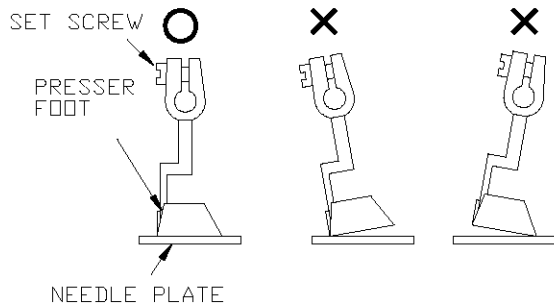
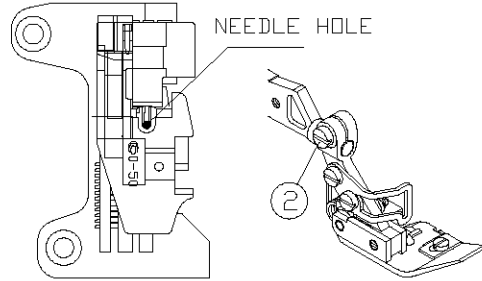
TURNING ADJUSTING SCREW (1) COUNTERCLOCKWISE IN ORDER TO LOOSE PRESSURE SPRING , LOOSEN SCREW (2) CAN TAKE OFF PRESSER FOOT SET .

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

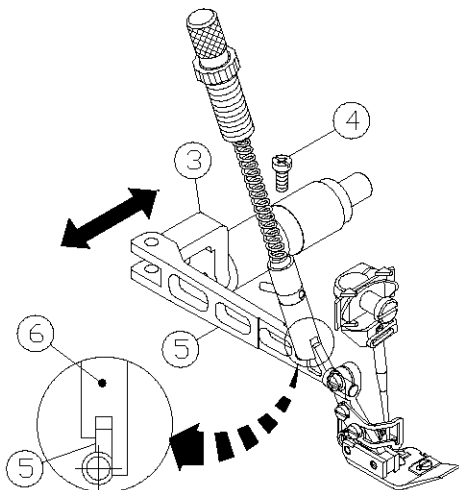
UH8003 UH8004



UH8005



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 NEEELE 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 ADJUSTING THE LIFTING HEIGHT OF PRESSER FOOT :

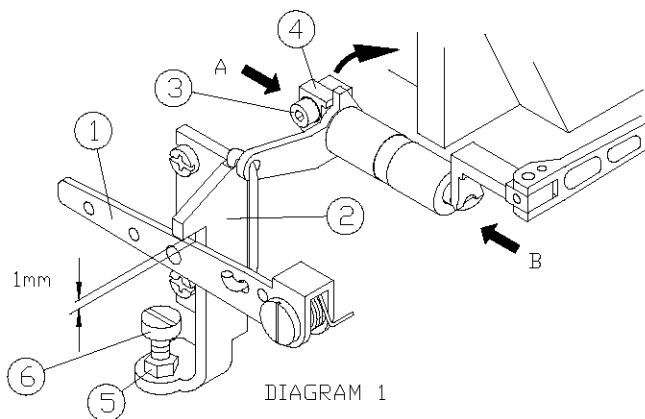


DIAGRAM 1

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

SETTING UP PRESSER FOOT LIFTING AMOUNT :  
AS SHOWN ON DIAGRAM 2 (UH8003,UH8004) AND DIAGRAM 3 (UH-8005)  
MAX . PRESSER FOOT LIFTING AMOUNT "a" IS 7 mm .  
WHEN ADJUSTING , LOOSEN NUT (5) AND ADJUST THE  
TOLERANCE TO DESIRED POSITION BETWEEN SCREW (6) AND  
LEVEL (1) .

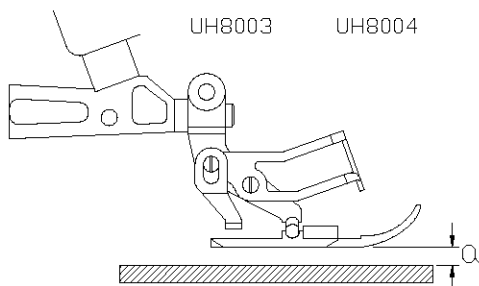


DIAGRAM 2

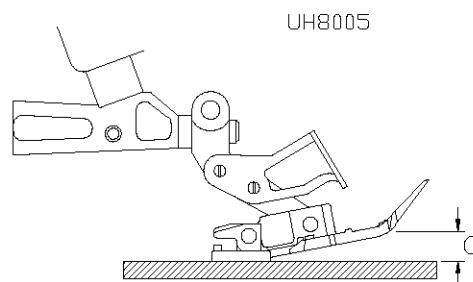
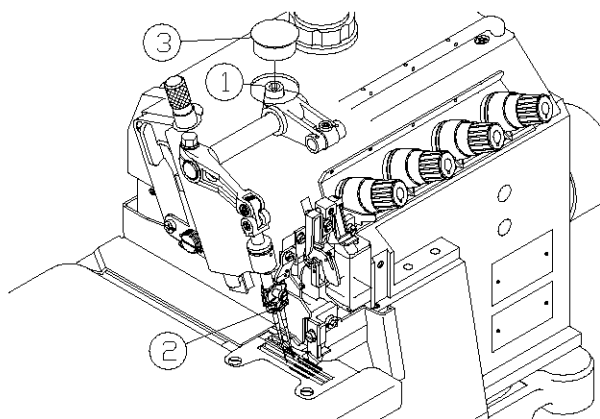


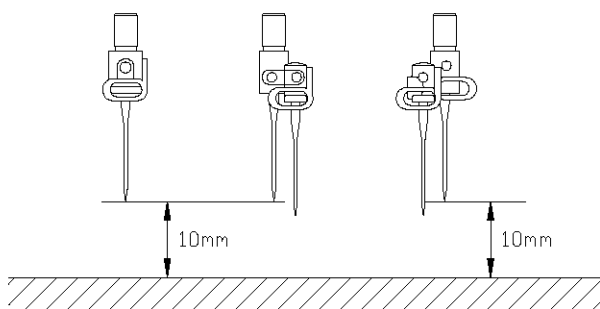
DIAGRAM 3

#### 4-6. ADJUSTING THE HEIGHT OF NEEDLE .



- THE DISTANCE BETWEEN NEEDLE TIP  
TO TOP OF NEEDLE PLATE SHOULD BE  
10 mm ( 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) .

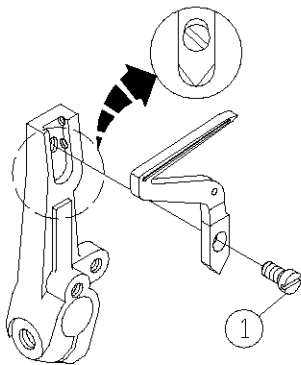
UH8003 UH8004 UH8005





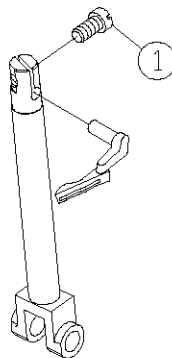
## 4-7. CHANGING LOOPERS.

### 4-7-1. CHANGING LOWER LOOPER:



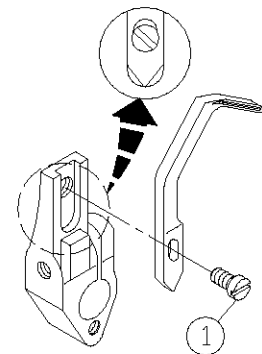
CHANGING LOWER LOOPER BY TAKE OFF SCREW (1) WHEN INSTALLING, PLEASE MAKE SURE THE CRANK OF LOWER LOOPER MUST ATTACH TO THE BOTTOM OF GROOVE OF LOWER LOOPER ARM CLOSELY.

### 4-7-2. CHANGING UPPER LOOPER:



CHANGING LOWER LOOPER BY TAKE OFF SCREW (1)

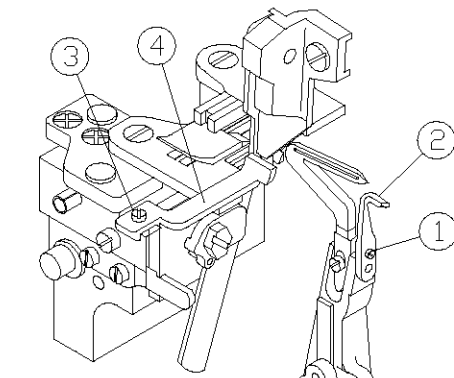
### 4-7-3. CHANGING CHAIN LOOPER:



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

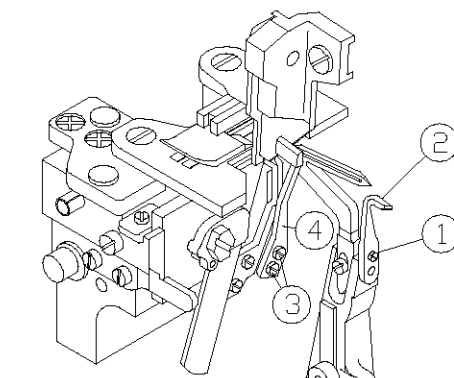
## 4-8. CHANGING NEEDLE GUARD:

### 4-8-1. CHANGING NEEDLE GUARD OF UH-8003, UH-8004

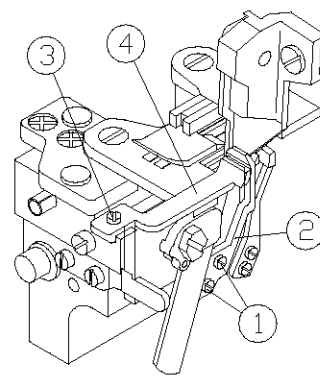


CAN TAKE OFF REAR NEEDLE GUARD (2) BY LOOSEN SCREW (1) . LOOSEN SCREW (3) CAN TAKE OFF FRONT NEEDLE GUARD (4)

### 4-8-2. CHANGING NEEDLE GUARD OF UH-8005



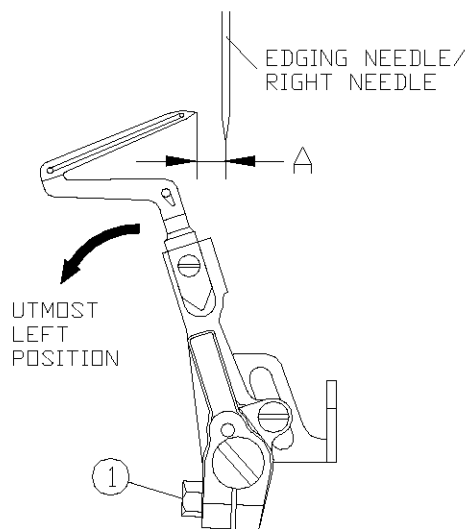
PLEASE TAKE OFF REAR NEEDLE GUARD (2) BY LOOSEN SET SCREW (1) . LOOSEN SET SCREW (3) CAN TAKE OFF FRONT NEEDLE GUARD.



LOOSEN SET SCREW (1) CAN TAKE OFF REAR CHAINSTITCH NEEDLE GUARD . LOOSEN SET SCREW (3) CAN TAKE OFF FRONT CHAINSTITCH NEEDLE GUARD,

## 4-9. SETTING UP LOOPER AND NEEDLE GUARD

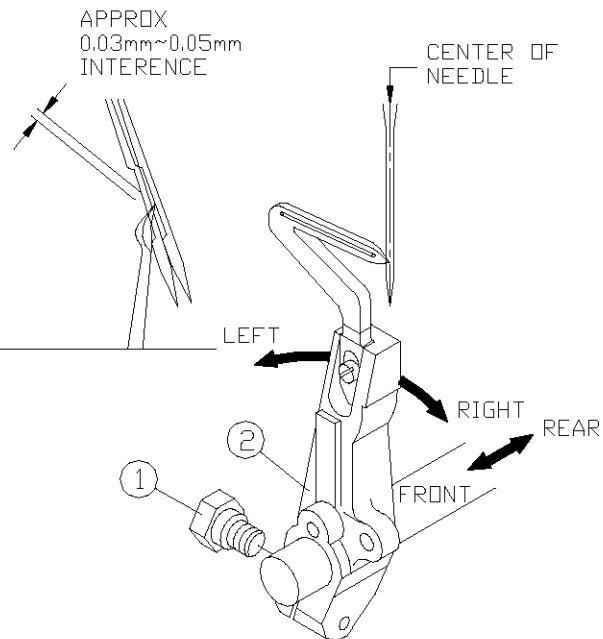
### 4-9-1. SETTING UP LOWER LOOPER



LOOSEN SCREW (1)

UNIT mm

MODEL	THE DISTANCE A BETWEEN TIP OF LOOPER AND THE CENTER OF NEEDLE(S)
8003	3.8~4
8004	3.6~3.8
8005	3.8~4

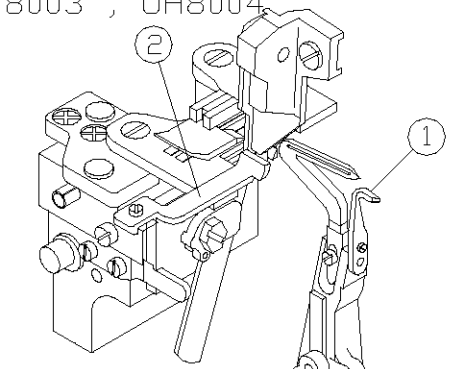


WHEN LOWER LOOPER MOVES FROM RIGHT TO LEFT AND THE TIP OF LOOPER MOVES TO EDGING NEEDLE/RIGHT NEEDLE, THERE WILL HAVE A INTERFERENCE APPROX 0.03mm TO 0.05 mm . LOOSEN SCREW (1) AND ADJUSTMENT CAN BE MADE BY MOVING LOOPER ARM FORWARD OR BACKWARD.

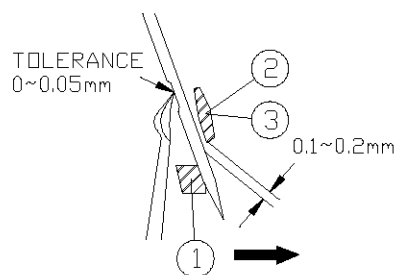
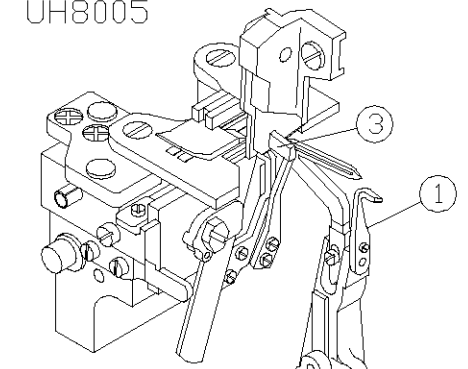
WHEN LOWER LOOPER MOVES TO ITS UTMOST LEFT POSITION , PLEASE REFER TO THE CHART ABOVE FOR THE DISTANCE A BETWEEN THE TIP OF LOWER LOOPER AND THE CENTER OF EDGING NEEDLE .

### 4-9-2. SETTING UP NEEDLE GUARD OF EDGING NEEDLE

UH8003 , UH8004



UH8005

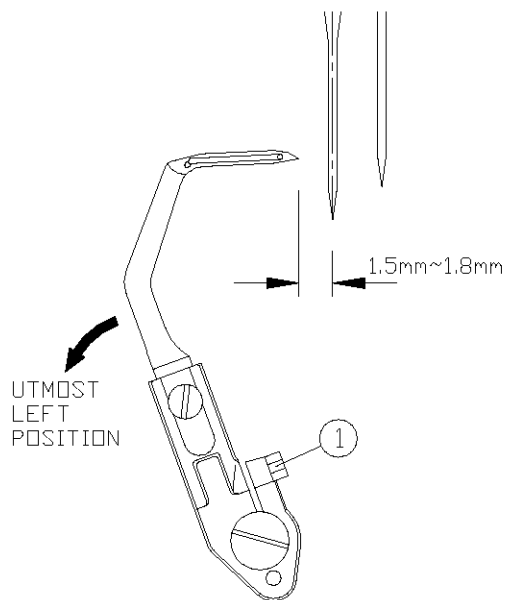


1.AS MENTIONED ABOVE, WHEN LOWER LOOPER MOVES TO THE CENTER OF EDGING NEEDLE, THERE WILL HAVE APPROX 0.03mm~0.05mm INTERFERENCE.

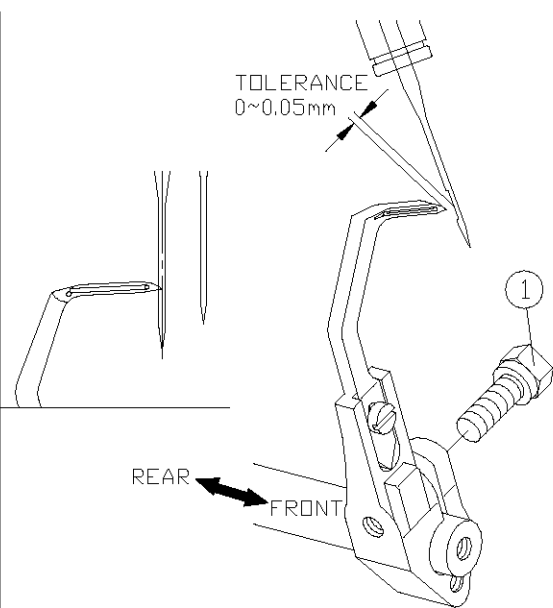
2.IN THE SAME TIME, ADJUSTING REAR NEEDLE GUARD (1) IN ORDER TO PUSH NEEDLE FORWARD AND CREATE A TOLERANCE OF 0~0.05mm BETWEEN NEEDLE AND THE TIP OF LOWER LOOPER.

3.IN THE SAME TIME, ALSO ADJUSTING FRONT NEEDLE GUARD (2) (UH-8003,UH-8004) (3) (UH-8005) TO CREATE A TOLERANCE OF 0.1mm~0.2mm BETWEEN FRONT NEEDLE GUARD AND NEEDLE.

## 4-9-3. SETTING UP CHAINSTITCH LOOPER



WHEN CHAINSTITCH LOOPER MOVES TO ITS UTMOST LEFT POSITION, THE DISTANCE BETWEEN TIP OF CHAINSTITCH LOOPER AND THE CENTER OF CHAINSTITCH NEEDLE SHOULD BE 1.5 mm . ADJUSTMENT CAN BE MADE BY LOOSEN SCREW(1).



WHEN TIP OF LOOPER MOVES TO THE CENTER OF CHAINSTITCH NEEDLE, THE TOLERANCE BETWEEN LOOPER TIP AND NEEDLE GROOVE SHOULD BE 0~0.05mm. ADJUSTMENT CAN BE MADE BY LOOSEN SCREW(1).

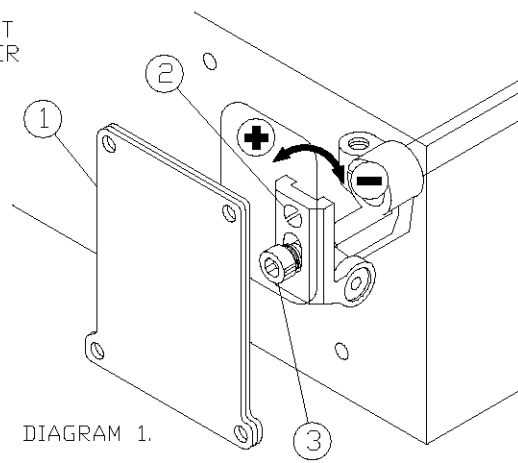
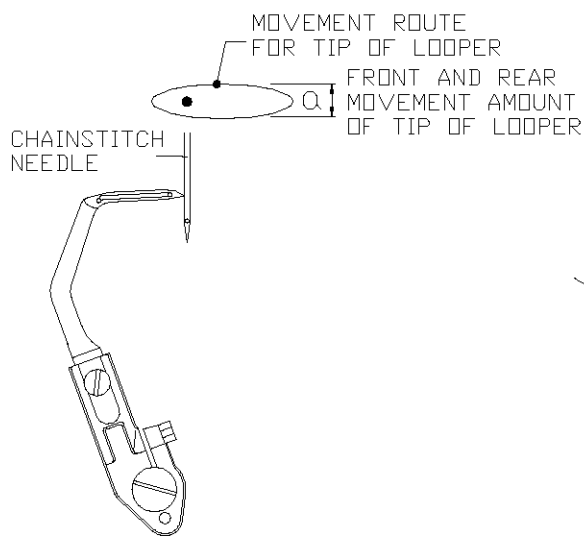


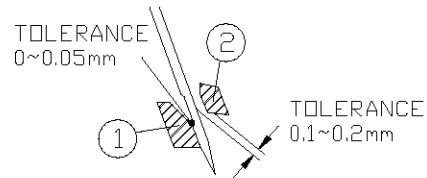
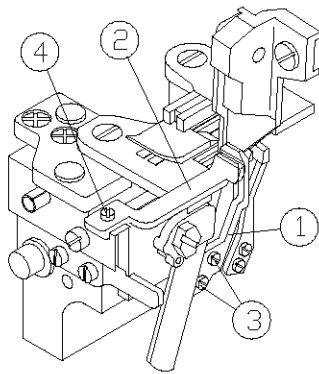
DIAGRAM 1.

WHEN CHANGING THE SIZE OF NEEDLE OR WHEN ADJUSTING THE FRONT AND REAR MOVEMENT AMOUNT OF TIP OF LOOPER.

PLEASE REFER TO DIAGRAM 1.

1. PLEASE OPEN UP BACK COVER (1) OF SEWING MACHINE.
2. LOOSEN SCREW (3) A LITTLE BIT (PLEASE DO NOT LOOSEN SCREW (3) COMPLETELY.)
3. TURNING ADJUSTING SCREW (2).
4. TURNING TOWARD (+) DIRECTION IN ORDER TO OBTAIN BIGGER MOVEMENT,  
TURNING TOWARD (-) DIRECTION IN ORDER TO OBTAIN SMALLER MOVEMENT.
5. AFTER ADJUSTMENT, PLEASE MAKE SURE TIGHTEN SCREW (3) AND BACK COVER (1).

#### 4-9-4. SETTING UP NEEDLE GUARD OF CHAINSTITCH LOOPER.

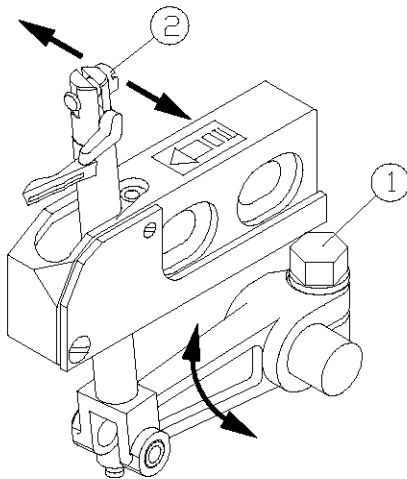


WHEN CHAINSTITCH NEEDLE REACHED LOWEST POINT OF ITS STROKE, THE TOLERANCE BETWEEN REAR NEEDLE GUARD AND NEEDLE IS 0~0.05mm AND THE TOLERANCE BETWEEN FRONT NEEDLE GUARD AND NEEDLE IS 0.1~0.2mm.

ADJUSTMENT CAN BE MADE BY LOOSEN SCREW (3),(4) AND AFTER ADJUSTMENT, MUST MAKE SURE TIGHTEN SCREWS.

#### 4-9-5. SETTING UP UPPER LOOPER

DIAGRAM 1.

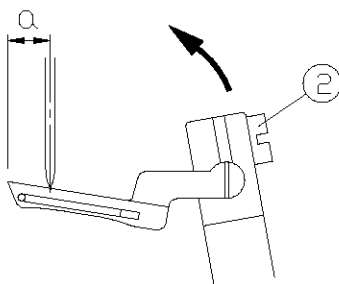


1.WHEN UPPER LOOPER MOVES TO ITS HIGHEST POSITION, THE DISTANCE BETWEEN TIP OF LOOPER AND CENTER OF NEEDLE SHOULD BE AS SPECIFICATION CHART LISTED BELOW AND ALSO PLEASE REFER TO DIAGRAM 2.

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).

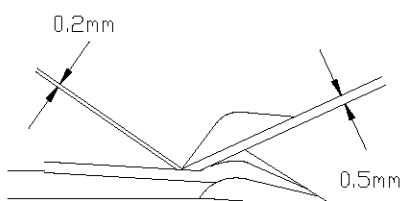
DIAGRAM 2.

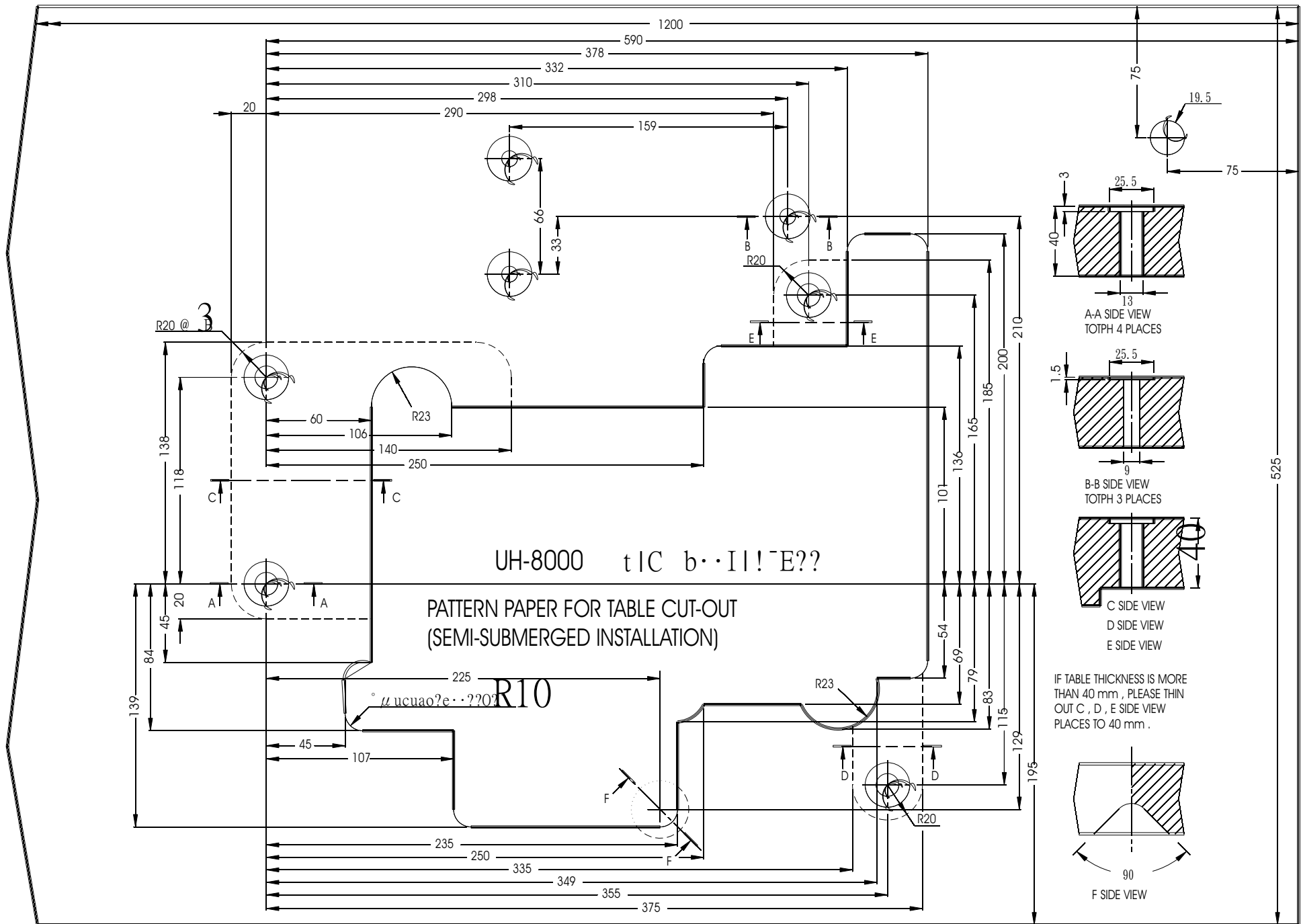


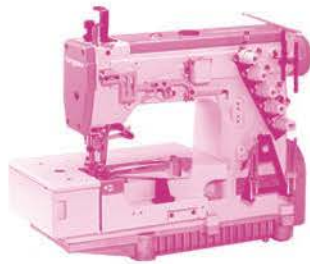
#### SPECIFICATION CHART

MODEL	$\alpha$	MODEL	$\alpha$
UH8003-032	4.0~4.5	UH8005-232	3.8~4.2
UH8003-042	4.0~4.5	UH8005-332	3.8~4.2
UH8013-032	3.8~4.2	UH8005-353	3.8~4.2
UH8023-032	3.8~4.2	UH8005-553	4.0~4.5
UH8004-233	4.5~5.0	UH8005-553R	4.0~4.5
UH8004-243	4.5~5.0	UH8045-553L	3.8~4.2
UH8024-242	4.0~4.5	UH8055-353	3.8~4.2
UH8094-243	4.0~4.5		

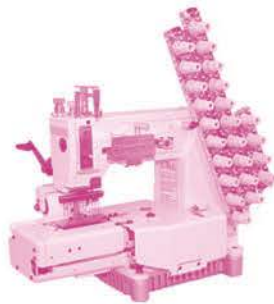
DIAGRAM 3.







FT6503-0-56M  
Tape Binding



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



UH8005-332-M16  
2-Needle, 5-Thread Safety Stitch Overlock  
(General Plain Seaming )



KL500  
High-Speed, Single-Needle Lockstitch Machines



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