ARTiSAN®

Model 196 R-2
Single Needle Lockstitch
Medium Speed Sewing Machine
With Automatic Lubrication

Instruction Manual
&
Spare Parts List
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1. INTRODUCTION

This single needle machine is manufactured for artisan lockstitch sewing machine and is suited for sewing light weight and medium weight material, which equipped with automatic oil system, including the automatic oil of the rotating hook and also equipped with control valve. For adopting high speed sewing machine feeding structure, the durability is greatly increase and the stitch is exquisite. It is the ideal sewing equipment used in the trade of garment, shoes and hats, which is suitable for knitting, cotton, wool, fabric and light leather.

2. MAIN TECHNICAL SPECIFICATIONS

| 1 | Max. needle length | 4mm |
| 2 | Presser lifting amount | 6mm (10mm by knee lifting) |
| 3 | Sewing ability of max. thickness | 5mm (free state) |
| 4 | Needle | Model GV3, #65～#110 |
| 5 | Lubricating oil | #10 white oil |
| 6 | Power of electric machine | 380V/370W |
3. INSTALLATION OF MACHINE AND OPERATION PREPARATION

1. Installation:
   (1) Place of installation:
   The machine should be installed on a strong base to ensure the machine to have a steady running and minimum vibration at high speed. If the four rubber mats on the feet of the sewing machine stand have a good connection with ground, it results in lower noise in operation.

   (2) Fitting oil pan:
   Put the oil rubber cushions (1) and oil pan felt cushions (3) separately on four corners of notch of the table, fix them with the screw of oil pan (2). Then install the oil pan (4). (Fig. 1, 2)

   (3) Fitting machine head:
   Put the machine head connecting hooks (1) into the bed holes to engage respectively two hinges (2) stated in the table, then place the machine on the four cushions (3). (Fig. 3)
(4) Thread winder's fittings:

After fitting the machine head and the belt, the thread winder can be fitted. In Fig. 5 when fitting the winder, the winder wheel 1 should face the outside of belt 2. Between winder wheel and belt should have a certain clearance. If push down winder wheel stand 3, the winder wheel should touch the belt. And when balance wheel running, the belt can make the winder wheel run together, then tighten screw 4 to set the thread winder on the table.

(5) Guard of the winder: (Fig 5)

Fit the thread winder, then can be fitted the guard on the winder. First, put safety screw 1 using nut 2 fixed in the machine head, then put up the safety plate 3 to install the safety nut 4, pay attention to the plate not rub with screw 4 stopper.

Then turn the safety screw 5 using nut 6 to install in the table plate, pay attention to the machine head nut on the head plate 6 not rub with transmission plate 5.
(5) Installing the belt cover: (Fig. 5)

After installing the bobbin winder, it can be installed the belt cover.

Fix the balance wheel cover (1) on the machine head with screw (2), then you may install the belt cover lid (3) on the belt cover, but you must be sure that the balance wheel cover not hit the bobbin winder (4). After finishing this, fix the belt cover (5) on the collar with wooden screws (6). Note: the balance wheel cover can not hit the belt cover.

(6) Sketch map of machine stand installation: (Fig. 6)

a. Position of machine stand.
b. Position of drawer.

2. 操作准备:

(1) 清洗油污:

机器在装箱前为了防止机件生锈而涂有防锈油脂，装箱后可能有较长时间的贮藏和长途运输阶段会造成油脂硬化或积聚灰尘，所以新机器在使用前，必须将涂在机器各部位的防锈油脂用汽油和洁净的软布擦洗干净。

(2) 机器检查:

机头可能因在运输中受到强烈振动而使机件松动，所以在清除油污以后，应对机器作一次周密检查。检查时用手转动上轮，观察机件有无转动困难、碰擦、不均匀及其他不正常现象和声响等。如有上述情况应进行适当调整。

(3) 机器润滑:

a. 润滑须知：（图 7）
2. Operation preparation:

(a) Cleaning:

Before packing each part of the machine, should be covered with anti-rust grease. And before operation new machine, anti-rust grease on each part of machine should be cleaned out with gasoline and clean with soft cloth.

(b) Inspection:

Some parts of machine head may get loose due to vibration incurred in transit of rough handling, so after cleaning, the machine should be thoroughly inspected. To check the machine head by means of turning balance wheel. The machine head must be regulated in the case of conditions such as abnormal noise from the compact of moving
parts. the difficulty of the machine head to run. running into each other of moving parts.

(3) Lubrications.

a. Information for lubrication: (Fig.7)

Before starting the machine, fill oil pan with sewing machine (10# white oil) up to HIGH mark A. When you operate the machine after lubrication, you will see splashing oil through oil sight window. Note that the amount the splashing oil is unrelated to the amount of the lubrication oil, But if the oil level is lower than LOW mark B, always refill the oil.

* Note: New machine(or those who have not been used for a long time) must be operated at a speed of 1500 s.p.m off and on for 10 minutes at first.

b. Adjusting the amount of oil supplied in the front of head(Fig.8):

The amount of oil supplied in the oil reservoir in the front of head can be adjusted by regulating valve of amount of oil(1): turn the regulating valve of amount of oil(1), when dot A on the regulating valve is parallel to oil inlet tube(2), the amount of oil is maximum, when rotating the regulating valve, the amount of oil will be reduced gradually all the dot on the regulating valve is vertical to the oil inlet pipe, the oil flow regulator is closed.

c. Adjusting the oil of rotary hook (Fig.9)

While turing the adjusting screw on the lower shaft bush to "+", the amount of oil will increase; while turing the adjusting screw to "-" the amount of oil will decrease.

(4) Testing:

a. When machine running, the balance wheel should be counter clockwise.

b. The machine can not run without materials after threading.

c. At the beginning of operating, the speed of machine can be over 2500 s.p.m. Only after one or two months of running, the speed of the machine can be increased as per nature of fabrics.

4. 机器的操作
4. Operation

1. 机线的选法:

机线应采用左旋线。底线轴左。右旋线均可使用。缝线旋向的鉴别，可按图10所示把缝线提起，以右手法按前轴头方向接转缝线，若线股越接越紧，则是左旋线，反之即为右旋线。

1. Selection of sewing threat:

Needle thread should be left twisting. (Fig. 10)
2. Coordination of needle thread and material:

DP: 5 needles chosen in preference. The number of needle can be selected in line with the material and thread used (See the following table)

<table>
<thead>
<tr>
<th>Needle No.</th>
<th>Thread No.</th>
<th>Gauze, light silk and thin haircords</th>
</tr>
</thead>
<tbody>
<tr>
<td>#9</td>
<td>100-120</td>
<td></td>
</tr>
<tr>
<td>#11</td>
<td>80-100</td>
<td></td>
</tr>
<tr>
<td>#14</td>
<td>60-80</td>
<td></td>
</tr>
<tr>
<td>#16</td>
<td>40-60</td>
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</tr>
<tr>
<td>#18</td>
<td>30-40</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Needle No.</th>
<th>Thread No.</th>
<th>Heavy flannelette, thin canvas and heavy woolen cloth</th>
</tr>
</thead>
<tbody>
<tr>
<td>#9</td>
<td>100-120</td>
<td></td>
</tr>
<tr>
<td>#11</td>
<td>80-100</td>
<td></td>
</tr>
<tr>
<td>#14</td>
<td>60-80</td>
<td></td>
</tr>
<tr>
<td>#16</td>
<td>40-60</td>
<td></td>
</tr>
<tr>
<td>#18</td>
<td>30-40</td>
<td></td>
</tr>
</tbody>
</table>
3. 装置机针

转动上轮，使针杆上升到最高位置，旋转支针螺钉 1 (见图11)，注意机针的长槽应位于操作者的左面，然后插入钢水平针杆下部的针孔内，使其碰到钢杆孔的底部为宜，再旋转支针螺钉固定机针。

3. Fitting needle:

Turning balance wheel to make the needle bar in the highest position and loosen the screw 1 (Fig. 11). Long groove of needle should face the left of the operator, then insert the needle into the hole of the needle bar, tighten the screw.

4. 穿底线和引底线

穿底线的顺序表示在图12中，自线圈出来的线从先穿入顶部的过线板 1 的右孔中，经过夹线板 2，自左孔中引出。再经过三眼挑线嘴 3 的三个线眼，向下嵌入夹线器 4 的夹线板之间，再勾进挑线袋 5。绕过底线调节轴 6 向上勾进右线嘴 7，再穿过挑线杆 8 的线孔，然后向下勾进左线嘴 9。针杆套筒线钩 10。针杆线钩 11。最后将底线自左向右穿过机针 12 的针孔内，并引出 100 毫米左右的线备用。

引底线时，先将底线捏住，转动上轮，使针杆向下运动，并回升到最高位置，然后拉起捏住的底线线头，底线即被牵引上来，最后把底、面二根线头，一起置于压脚下面。

4. Threading:

As per Fig. 12, when threading needle thread, first put the thread through thread guide 1 and tension plate 2 and thread retainer 3, down through tensioner 4 and thread take up spring 5 and thread releasing hook 6, then up through right thread hook 7 and thread taking up level 8. Again down through left thread hook 9 and needle bar sleeve thread hook 10 and needle bar thread hook 11. Finally pull the thread needle hole 12 from left to right with thread tail 100mm.

When threading bobbin thread, hold the needle thread while turning balance wheel to make the needle bar move down and then to make it rise in the highest position. Then the bobbin thread is pulled out with the needle thread. Finally put the two threads under the presser foot.

5. 绕底线

把滚心 5 (图4) 插入绕线器轴 6 的顶端上。自线圈出来的线，先穿入过线架 7 的线孔中，再夹入二块夹线板 8 的中间，然后把线头在梭心上绕上几匝，把夹线跳板 9 向下拨压，绕线轮 1 即压向压脚，在绕线过程中就能自动绕线。绕心绕满后能自动跳开并停止。

绕底线时应排列整齐而紧密。如松懈不紧，可以加大夹线板 8 的压力；如排列不齐，则要移动过线架 7 的位置进行调整。调整时，先松开紧固螺钉，然后左右移动过线架，使之能自动排列整齐后再紧固之。绕心线不要绕得过满，否则容易散落，一般绕到小于梭心外径 0.5～1 毫米，绕线量可以用夹线跳板的螺钉加以调节。

5. Winding bobbin:

Insert bobbin 5 (Fig. 4) into the winder shaft 6. Put the needle thread through hole of
thread guide bracket 7 and insert it between two plates 8. Then the needle thread is winded several rings on the bobbin, pull down the full-thread plate 9, thus the winding wheel can press the belt, in the process of sewing, the winder can work automatically. When the bobbin is full, the winder will stop automatically.

Thread on bobbin should be arranged in good order and tight. Increasing pressure on the tension plate 8 can regulate thread tension, moving thread guide bracket 7 can regulate thread arrangement. When adjusting, first loose the fixed screw, then move thread stand in the left and right, make it to arrange in good order automatically, then fix it. Generally, bobbin can not be winded overfull. It should be lower 0.5-1mm than outer diameter of the bobbin. Amount of winding can be controlled by full-thread plate.

6. Threading bobbin case:
   Put the full bobbin 1 (Fig. 13a) into the case 2;
   Insert thread into slot 3 (Fig. 13b);
   Through the spring 4, the thread is pulled out of the hole 5 about 100mm. (Fig. 13c)
7. Loading and unloading bobbin:

Hold bobbin case lid 1 and insert bobbin case 2 into the shaft 3 of rotary hook (Fig. 14). Turn the balance wheel and check whether the bobbin is set or not (Fig. 15).

When unloading bobbin case, turn balance wheel to raise the needle bar in the highest position. Then open the bobbin case lid and take out the bobbin case (Fig. 16).
8. Regulating needle gauge and feeding:

Turning the rotary button can regulate the width of needle gauge (Fig. 17). If turning counter clockwise, the needle gauge is wide. If turning clockwise, the needle gauge is narrow. If it is necessary to back tack, just put down the lever under the rotary button.

9. Tension of thread:

Tension of thread is changed as per sewing materials thread size. In Fig. 18, there are various stitches which often appear.

a. Normal. Two threads lock in the middle of the material.

b. Needle thread tension is too high. Two threads lock on the surface of the material.

c. Needle thread tension is too low. Two threads lock under the material.

d. The two threads tension are both low. They are floating on the surface of the material.

e. The two threads tension are both high. They are locking tightly in the material.
(1) Regulating take-up spring:

In general, the tension of take-up spring is about 25–35g and the range of swinging is 5–8mm. When sewing special light material (narrow needle gauge), the tension should be reduced and the range should be broadened. Adversely for special heavy material.

When regulating the range of swinging, first loose the fixed screw (Fig. 19), then turn the tensioner to regulate the range of swinging. If turn the tensioner clockwise, the range is broadened. If turn it anti-clockwise, the range is narrowed. Then tighten the
When adjusting the tension of take-up spring, first loosen set screw 1, and take out the tensioner, then loosen set screw 2, so the tension screw can be turned. TURNING CLOCKWISE CAN INCREASE TENSION, TURNING ANTI-CLOCKWISE CAN REDUCE TENSION.

Generally, the take-up spring has been adjusted before ex-factory.

(2) 底面线张力的调整:

缝纫机的线迹应该如图18(a)。如果线迹不正时，应对底、面线的张力加以调整，使之达到正常的线迹。

如果面线太紧、底线太松，则应逆时针旋转夹线螺母，以放松面线的张力，并用螺丝刀旋紧梭皮螺钉，加大底线的压力（图20）。

如果面线太松、底线太紧，则应顺时针旋转夹线螺母，以加大面线的压力，并用螺丝刀旋松梭皮螺钉，减小底线的压力（图21）。

如出现图18 (d)，(e) 的线迹，也可参照上述方法加以调整。

(2) Regulating thread tension:

The stitch on sewing material should be shown be Fig. 18a. If needle thread is too tight while bobbin thread is loose, the tension nut should be turned anti-clockwise to loosen the needle thread pressure and tighten the screw of bobbin spring to increase the bobbin thread pressure (Fig. 20). Adversely in previous case (Fig. 21).
10. Regulating pressure of presser:

Pressure of presser should be regulated as per sewing materials. When sewing heavy materials, the pressure should be increased. Just turn the screw on top of the machine head (Fig. 22) (Heavy). Adversely when sewing light materials (Fig. 22) (Light).

Pressure of presser should be properly regulated so that it can feed material without a hitch.

11. Thread hook:

In order to make the stitches moving beautifully, the position of thread hook should be regulated as per materials and the gauge of the needles.

When sewing heavy materials, first loosen the screw 2 (Fig. 23) and move the thread hook 1 to left to increase the thread amount. Adversely when sewing light materials.
1. Adjustment of looping time of rotary hook:

The moving relationship between rotary hook and needle will affect the functions of sewing greatly. The standard rotary hook looping time of is:

After the needle moves down in the lowest position, it will rise to 2.2mm, at this time:

(1) Looper point of rotary hook should be in with the midline of needle;
(2) Looper point should be 2mm higher than the hole of needle (Fig.24)

Method of regulation:
(1) Loosen the three set screw of rotary hook.
(2) Turn balance wheel to lower than the needle in the lowest position and then raise it 2.2mm.
(3) Turn the rotary hook to make the looping point on the position of the midline of needle.
(4) Loosen the set screw of needle bar link shaft (Fig.25)
(5) Regulate the height of needle bar to make the looping point 2mm higher than the hole of needle.

When regulating looping time of rotary hook, always be careful of the side clearance between looping time and needle.

The gap between the level of looping point and the bottom of needle should be regulated in 0.1 mm (Fig. 26).
2. Regulating the length of feed dogs.

The top of feed dogs should be 0.8 - 1 mm higher than the level of needle plate when the feed dogs rise in the highest position. If sewing special heavy or light materials, the gauge of feed dogs should be regulated. When adjusting, first loosen the fixed screw 1 (Fig. 24) of lifting belt crank.

6. COMMON TROUBLES AND METHODS OF TREATMENT
<table>
<thead>
<tr>
<th>故障类型</th>
<th>发生原因</th>
<th>处理方法</th>
</tr>
</thead>
</table>
| 断针 | 1. 针迹太短或机针弯曲
2. 针迹装入弯伤
3. 针迹时用手推拉梭条
4. 梭条过紧或过紧 | 调换机针。参看第 11 页图十一。 稍加加力推持，不可推拉。按技术规格安装使用。 |
| 断针 | 1. 针迹太长或机针粗细和梭料厚薄不相称
2. 针迹装入弯伤 | 调换机针。参看第 11 页图十一。 |
| 弯曲 | 1. 空隙过窄
2. 面线太紧
3. 针迹的线质差
4. 针迹太细，针迹较细 | 调换梭线
调换机针 |
| 断线 | 1. 底线太紧
2. 按心线线太紧，不匀
3. 针板孔毛边或有凹
4. 针板孔毛边或有凹
5. 针板孔毛边或有凹
6. 针板孔毛边或有凹
7. 针板孔毛边或有凹 | 减小底线张力 重新绕线 更换针板或用“0”纱布砂光 |
| 断线 | 1. 底线线没有调好
2. 挑线轮过偏
3. 调整底线轮 | 调整底线、底线。参看第 14 页图十九，调节挑线轮张力。 |
| 断线 | 1. 缝料过宽而针距过大
2. 底、面线张力过紧
3. 压脚压力过强 | 适当调整
调节夹线螺母、挑线轮和调压螺钉
旋转调压螺钉，减轻压脚的压力 |
<table>
<thead>
<tr>
<th>Fault</th>
<th>Probable cause</th>
<th>Solving method</th>
</tr>
</thead>
<tbody>
<tr>
<td>Needle breaking</td>
<td>1. Needle too thin or sewing materials too heavy.</td>
<td>1. Reference to the part of needle, thread, and sewing materials.</td>
</tr>
<tr>
<td></td>
<td>2. Needle bent.</td>
<td>2. Change the bent needle.</td>
</tr>
<tr>
<td></td>
<td>4. Strongly pull the sewing materials when sewing.</td>
<td>4. Properly sewing</td>
</tr>
<tr>
<td></td>
<td>1. The side clearance and position between needle and rotary hook badly adjusted.</td>
<td>1. Regulating as per instruction book.</td>
</tr>
<tr>
<td></td>
<td>2. Looper bent.</td>
<td>2. Change the bent looper.</td>
</tr>
<tr>
<td></td>
<td>3. Needles and materials unfit. Hollow on the needle plate too large.</td>
<td>3. Reference to the part of needle and to increase return amount of rotary sewing material. Lower the needle a littke hook (for light materials).</td>
</tr>
<tr>
<td></td>
<td>4. Bobbin thread tension and presser pressure is to weak.</td>
<td>4. Increase them.</td>
</tr>
<tr>
<td></td>
<td>1. Thread quality.</td>
<td>1. Use high quality thread.</td>
</tr>
<tr>
<td></td>
<td>2. Needle and thread unfit.</td>
<td>2. Reference to the part of needle and thread.</td>
</tr>
<tr>
<td></td>
<td>3. Rough surface of thread guide.</td>
<td>3. Polishing, or change a new one.</td>
</tr>
<tr>
<td></td>
<td>4. Tension is too tight.</td>
<td>4. Loosen the tension nut.</td>
</tr>
<tr>
<td></td>
<td>5. Needle position badly fitted.</td>
<td>5. Regulating it.</td>
</tr>
<tr>
<td></td>
<td>7. Weak bobbin thread tension.</td>
<td>7. Regulating it.</td>
</tr>
<tr>
<td>Thread floating</td>
<td>1. Rotary hook is bad quality and badly fitted.</td>
<td>1. Change a new one and increase return amount of rotary hook.</td>
</tr>
<tr>
<td></td>
<td>2. Needle too thin.</td>
<td>2. Change a thick one.</td>
</tr>
<tr>
<td></td>
<td>3. Feed dogs too low.</td>
<td>3. Raise them.</td>
</tr>
<tr>
<td></td>
<td>4. Weak needle thread tension.</td>
<td>4. Increase it.</td>
</tr>
<tr>
<td></td>
<td>5. Problem of presser foot.</td>
<td>5. Narrow the distance between bottom of the presser slot and needle. Change a new presser foot.</td>
</tr>
<tr>
<td></td>
<td>6. Weak take up spring</td>
<td>6. Increase it.</td>
</tr>
</tbody>
</table>

- 21 -
1. Machine head accessories

<table>
<thead>
<tr>
<th>Ref.No.</th>
<th>Part No.</th>
<th>Description</th>
<th>Quantity</th>
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<tbody>
<tr>
<td>1</td>
<td>GR1604/3</td>
<td>Oil reservoir asm.</td>
<td>1</td>
</tr>
<tr>
<td>2</td>
<td>GF141-8</td>
<td>Cover of machine head</td>
<td>1</td>
</tr>
<tr>
<td>3</td>
<td>GF141-8</td>
<td>Screw driver (L)</td>
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### 2. Components of Case

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### 4. Component of presser bar

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