

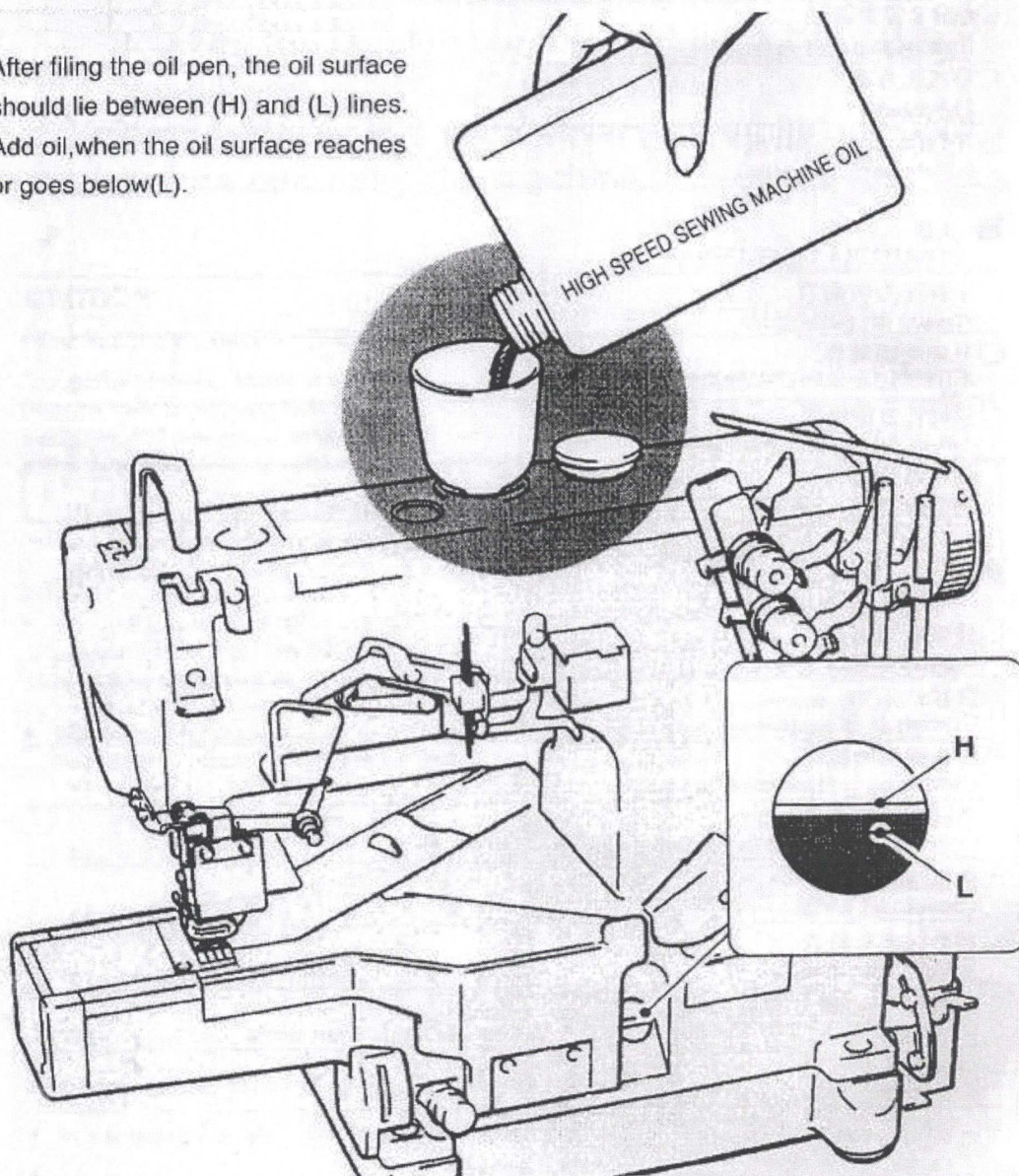
High-speed Stretch Sewing Machine

**Operation Manual
Parts Book**

**BEFORE
OPERATING**

Lubrication

After filling the oil pen, the oil surface should lie between (H) and (L) lines. Add oil, when the oil surface reaches or goes below (L).

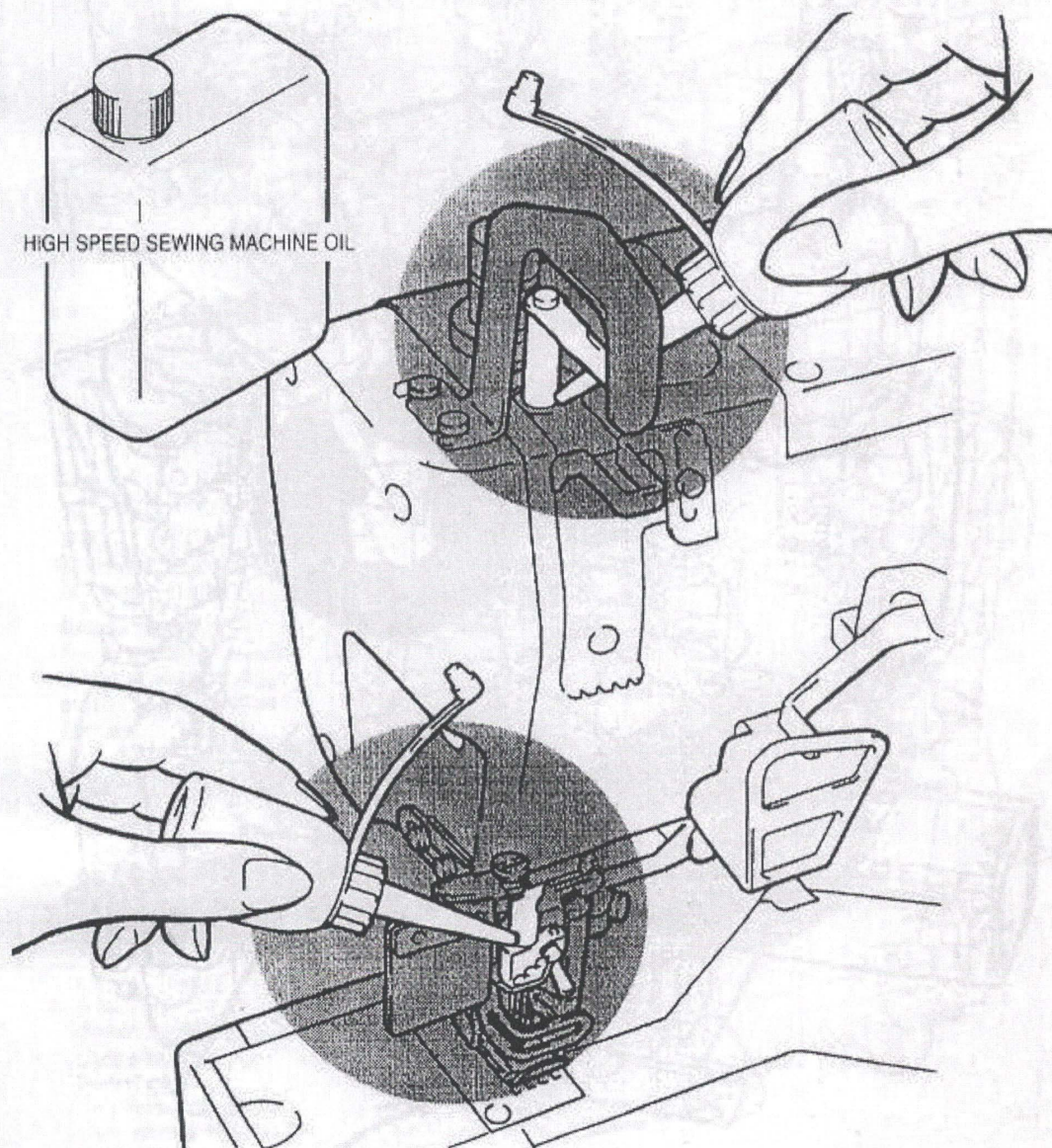


在使用之前
BEFORE
OPERATING

手动给油 Manual lubrication

手动给油是在缝纫机最初开始使用时，或停用一段时间重新开始使用时，请供给2~3滴油。

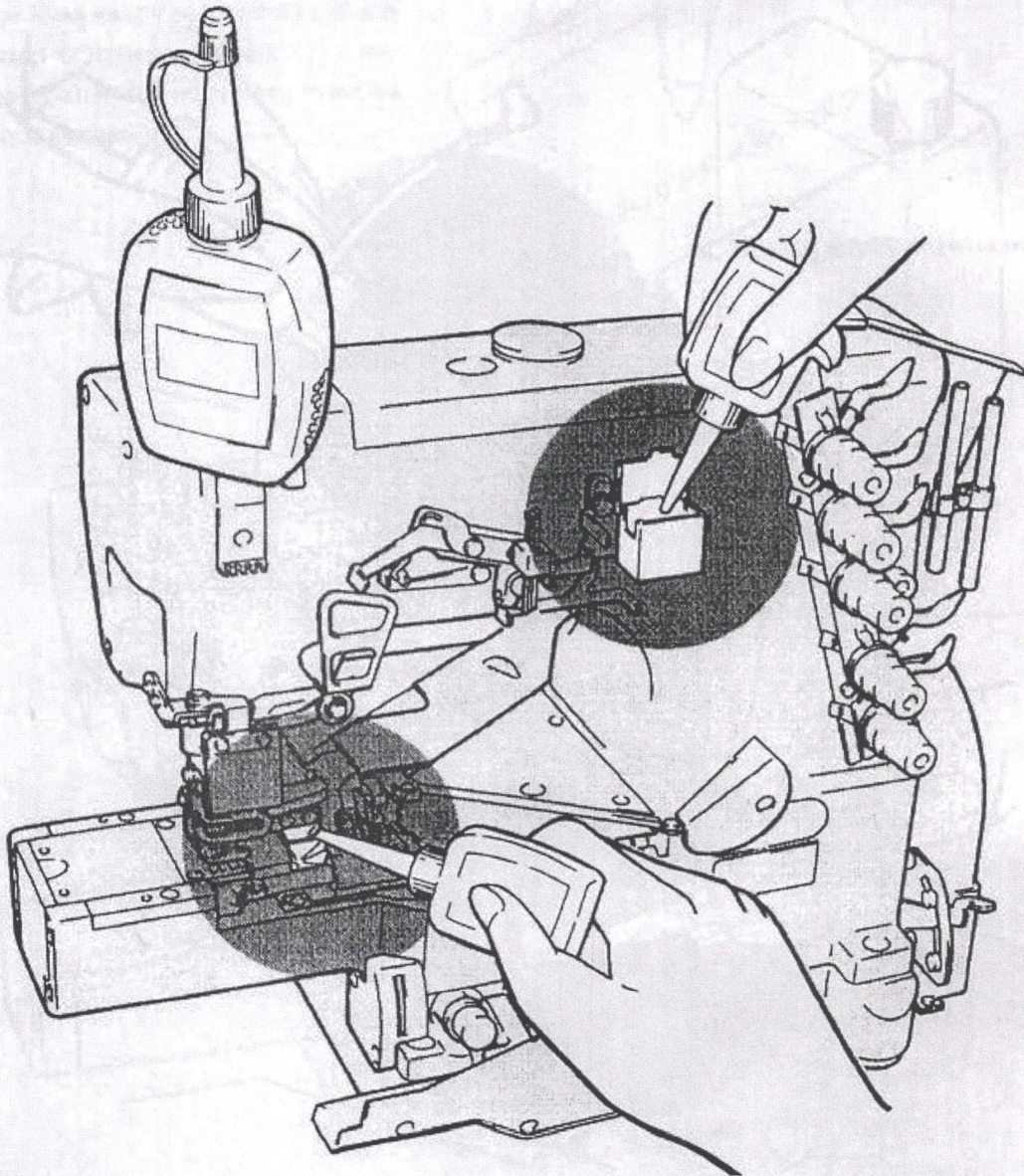
Apply 2 or 3 drops of oil by hand when the machine is used for the first time or has been left unused for some time.



**BEFORE
OPERATING**

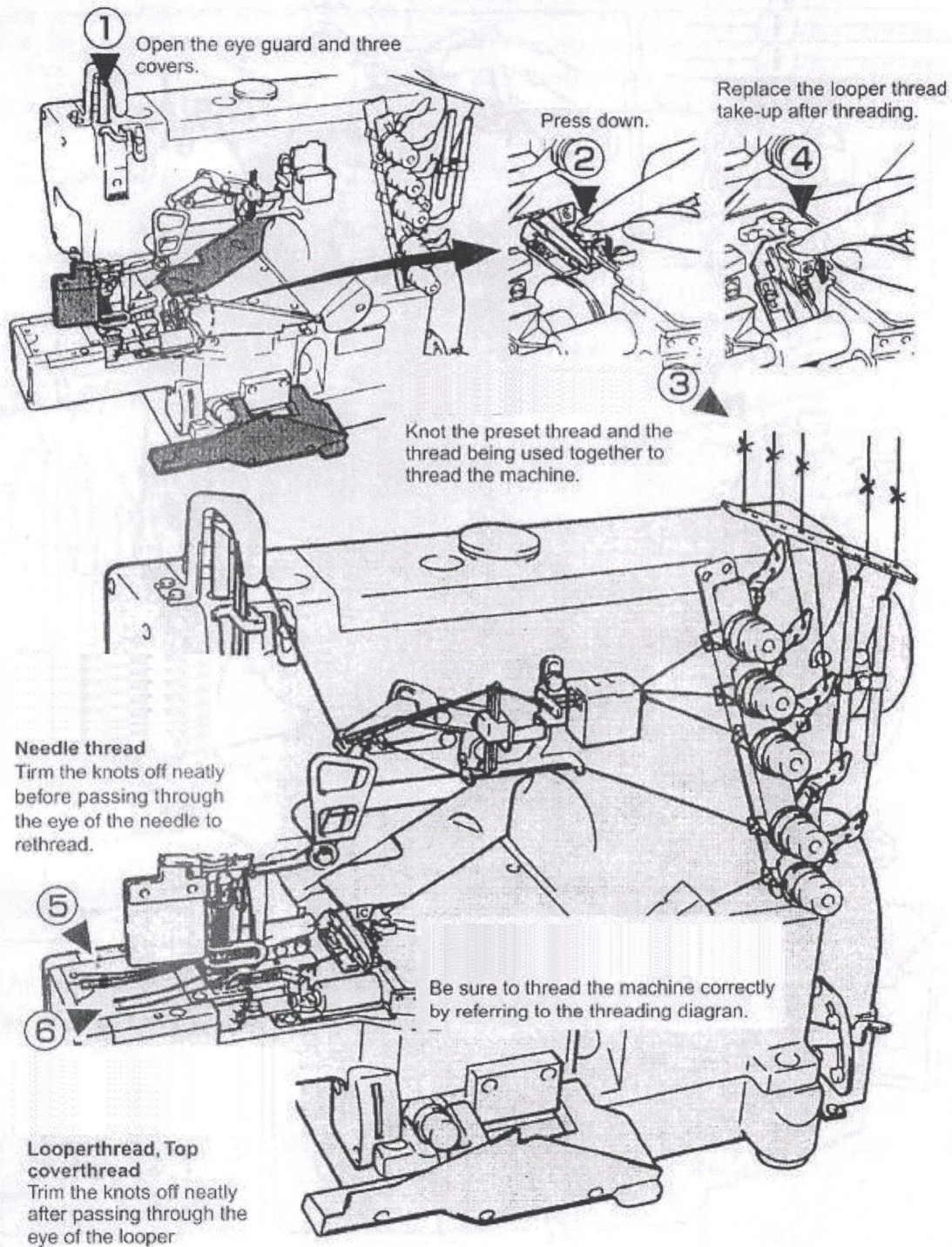
Filling the HR device with silicon oil

Fill the device with oil before it is too low in order to prevent needle thread breakage and fabric damage.



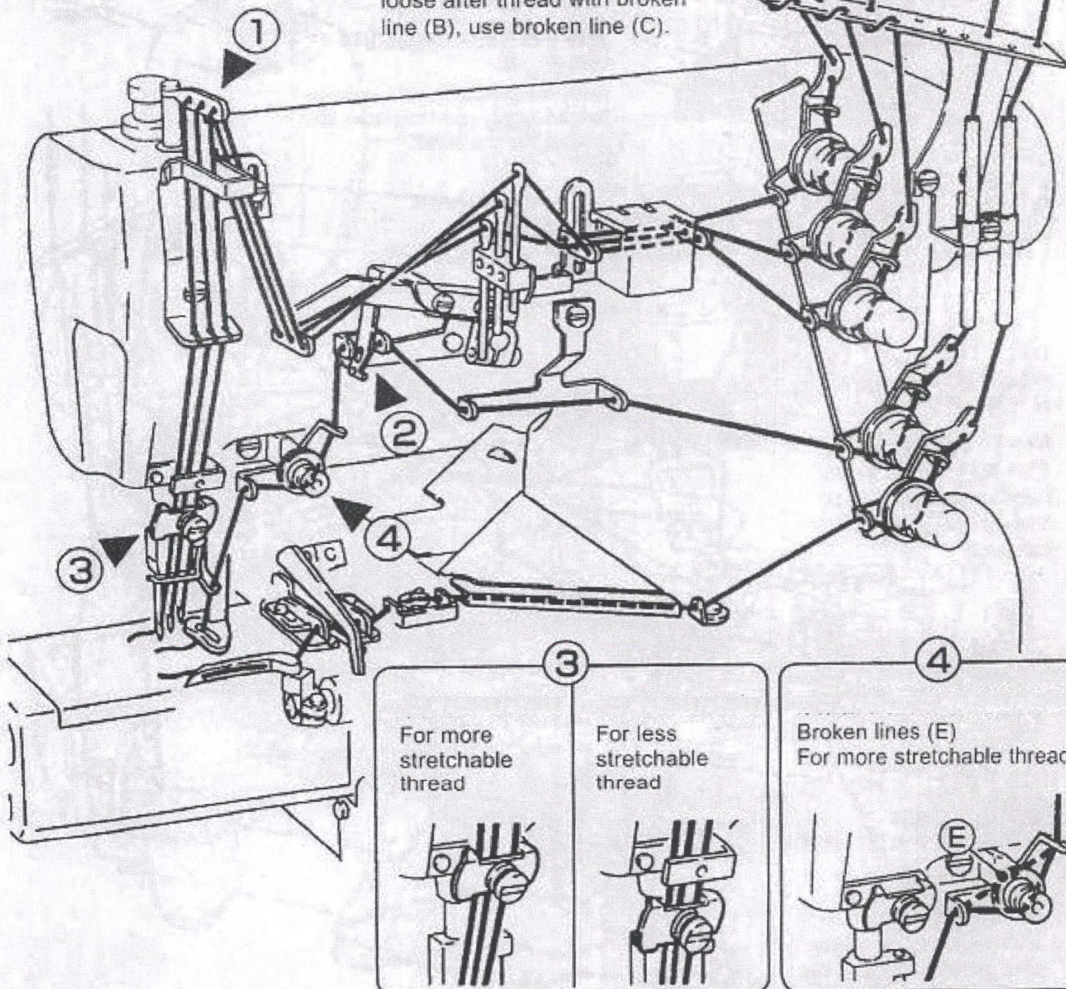
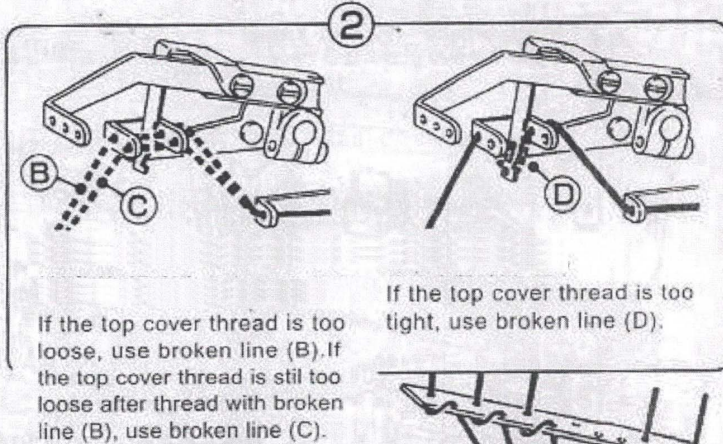
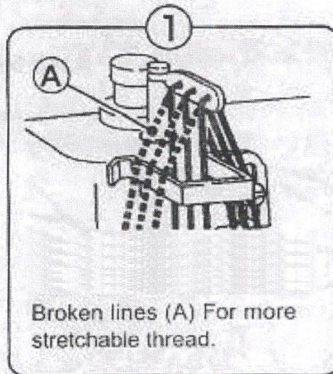
**BEFORE
OPERATING**

Lubrication



**BEFORE
OPERATING**

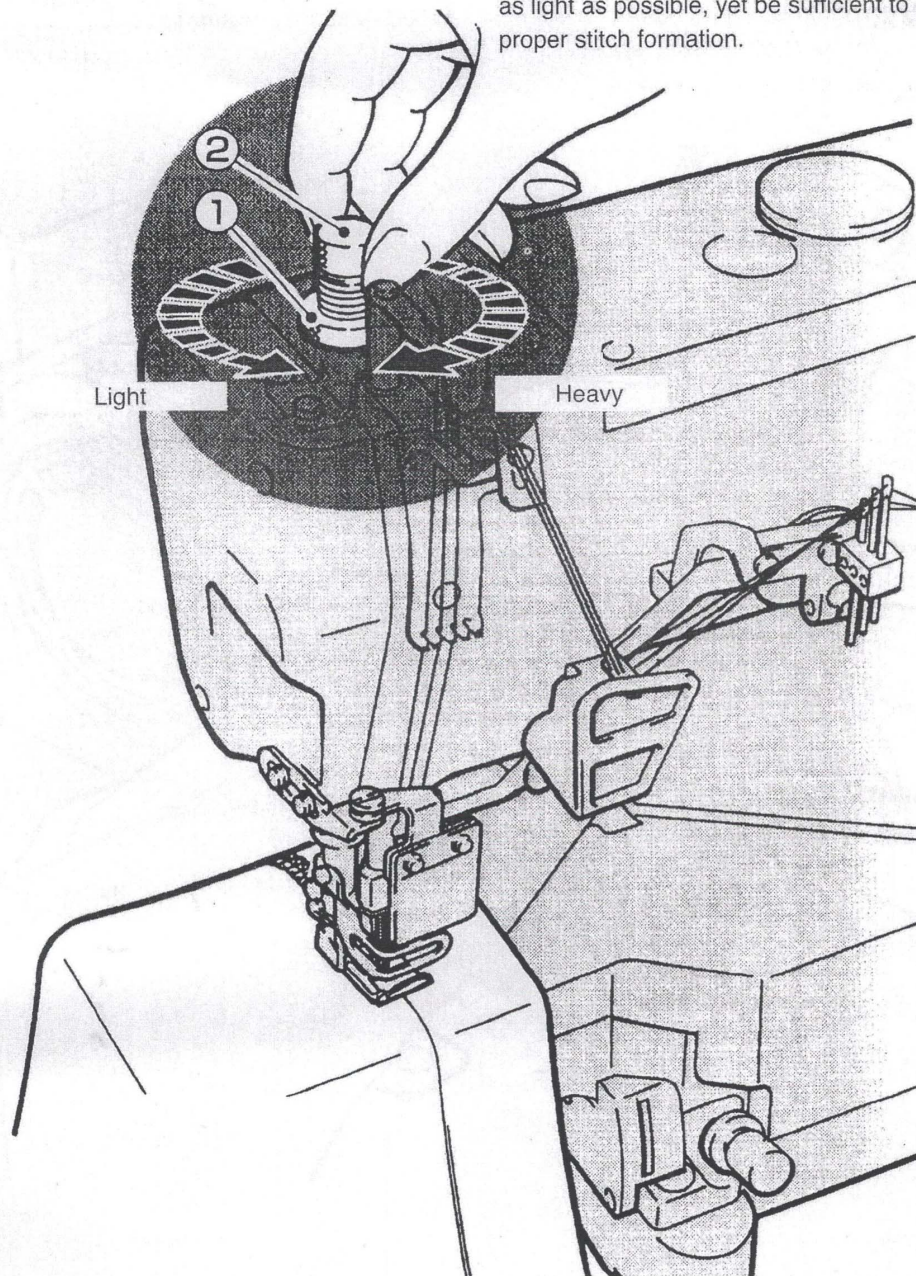
Threading diagram



TEST SEWING

Presser foot pressure

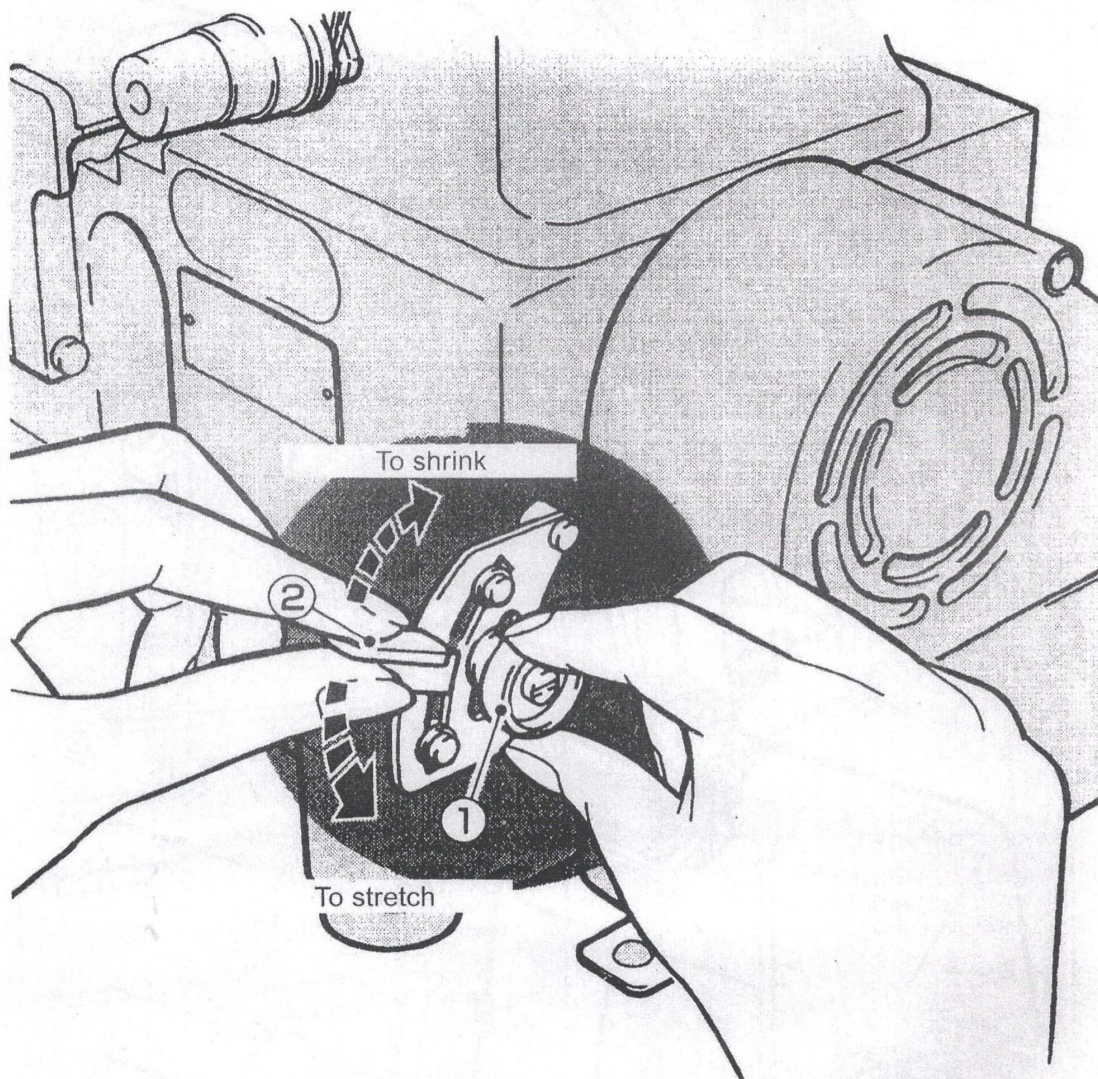
Loosen adjusting (1) nut and turn adjusting screw (2) to adjust the presser foot pressure. It should be as light as possible, yet be sufficient to obtain the proper stitch formation.



TEST SEWING

Diff. feed ratio adjustment

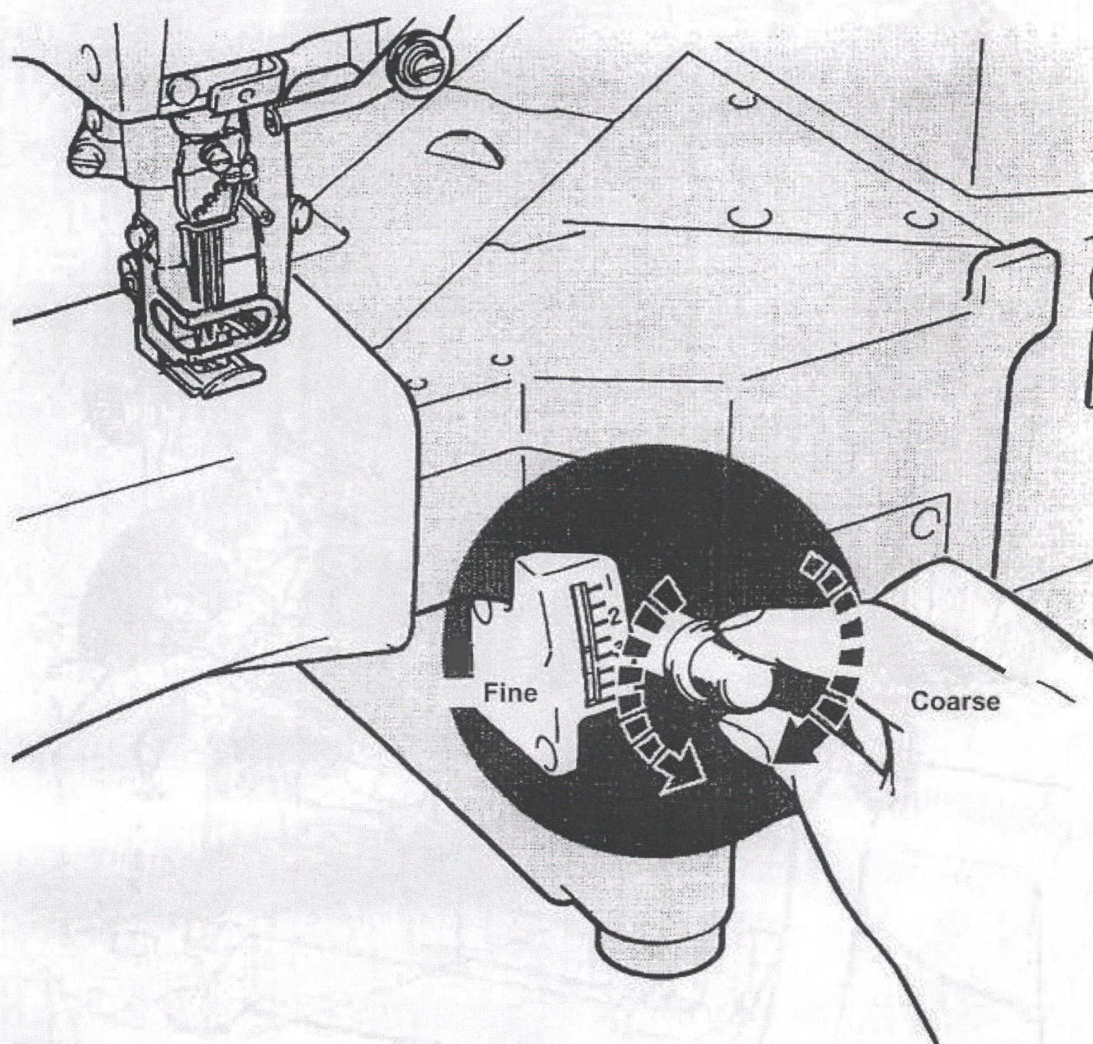
Loosen nut (1) and move the lever up (2) and down to obtain the correct differential feed ratio. then tighten nut (1).



Stitch length adjustment

Loosen adjusting nut (1) and turn adjusting screw (2) to adjust the stitch length.

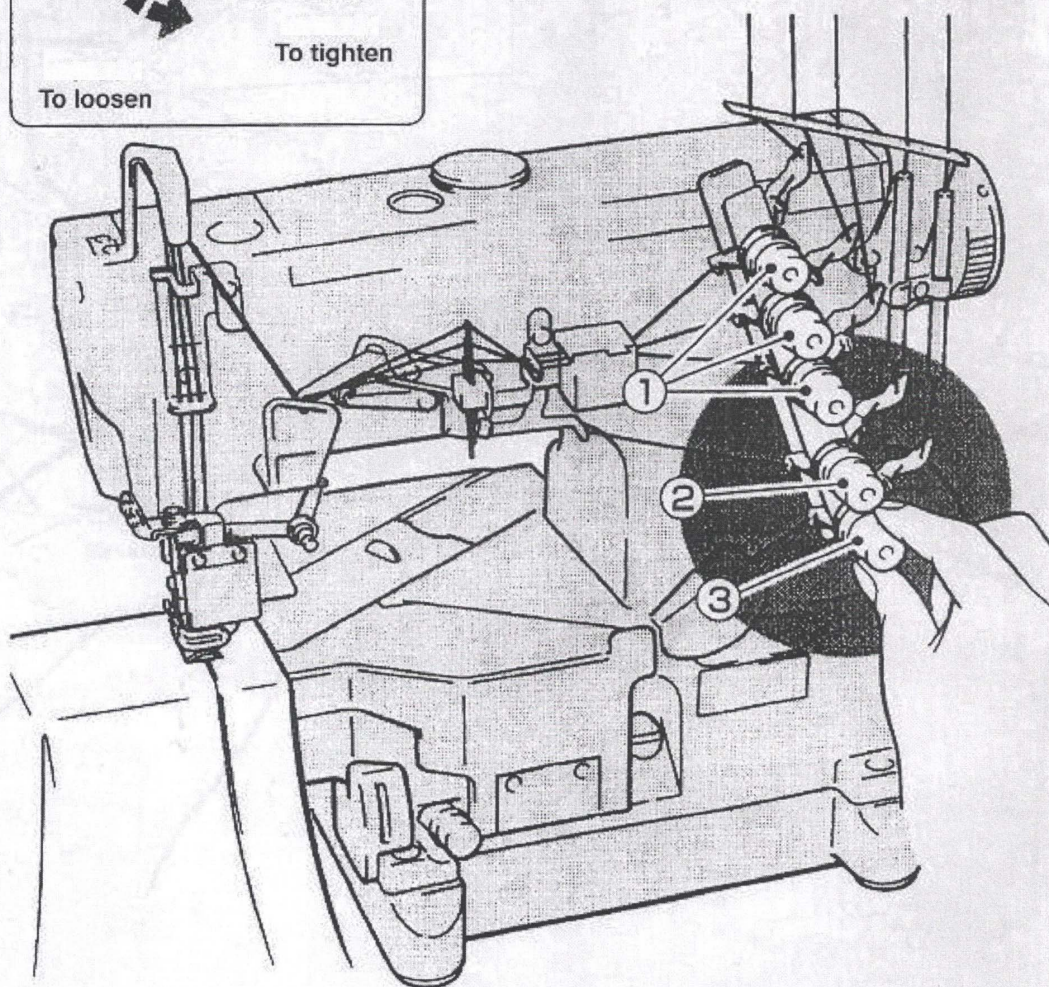
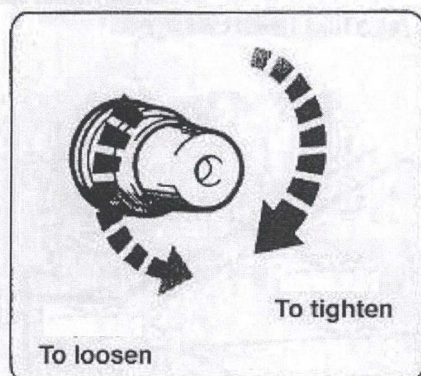
Note: Stitch length adjustment must only be made after the differential feed ratio has been changed.



TEST SEWING

Thread tension

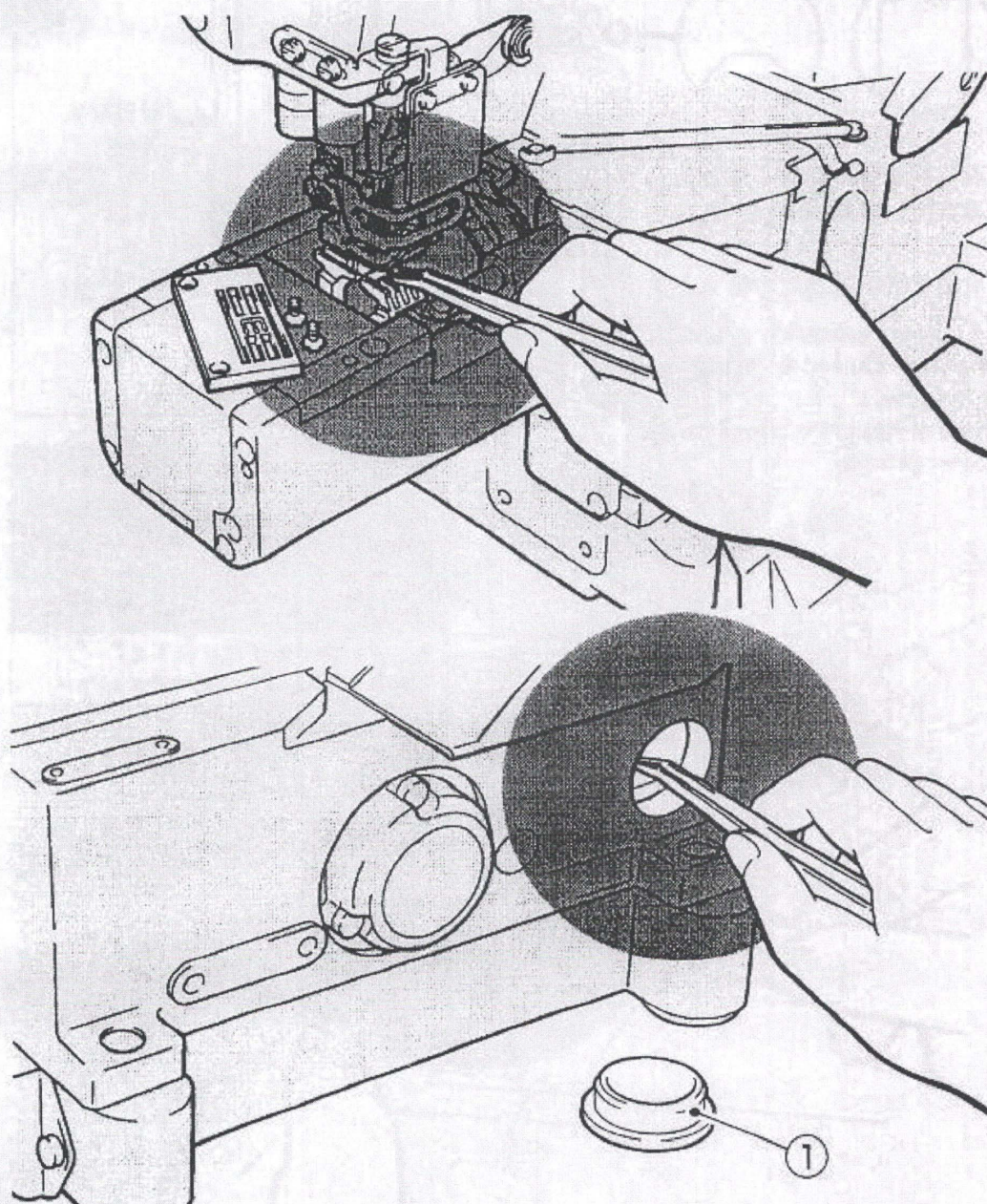
Make tension adjustments with the needle thread knob (1), top cover thread knob (2), and looper thread knob (3).



**MAINTENANCE
DURING USE**

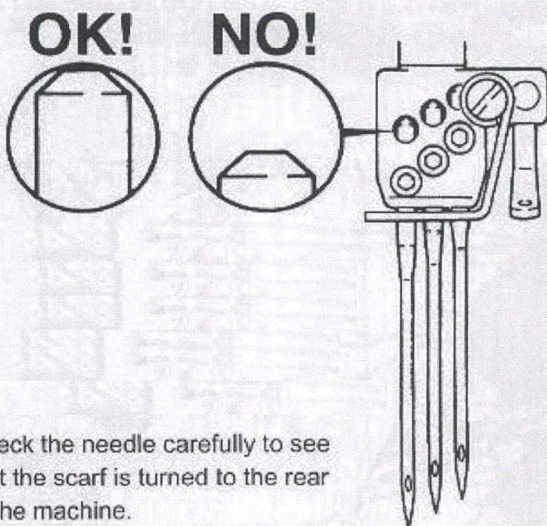
Cleaning the machine

Mainly the slots of the needle plate and the feed rows should be cleaned.

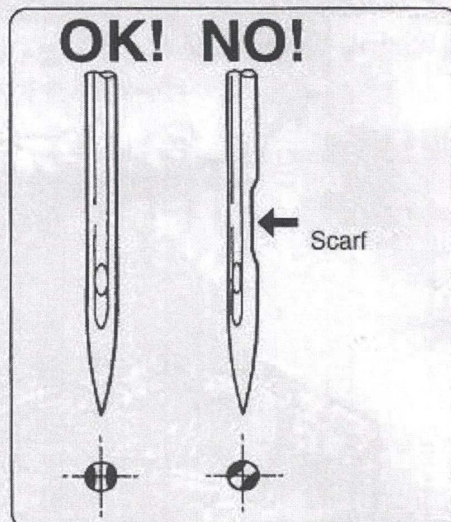


**MAINTENANCE
DURING USE**

Replacing the needle

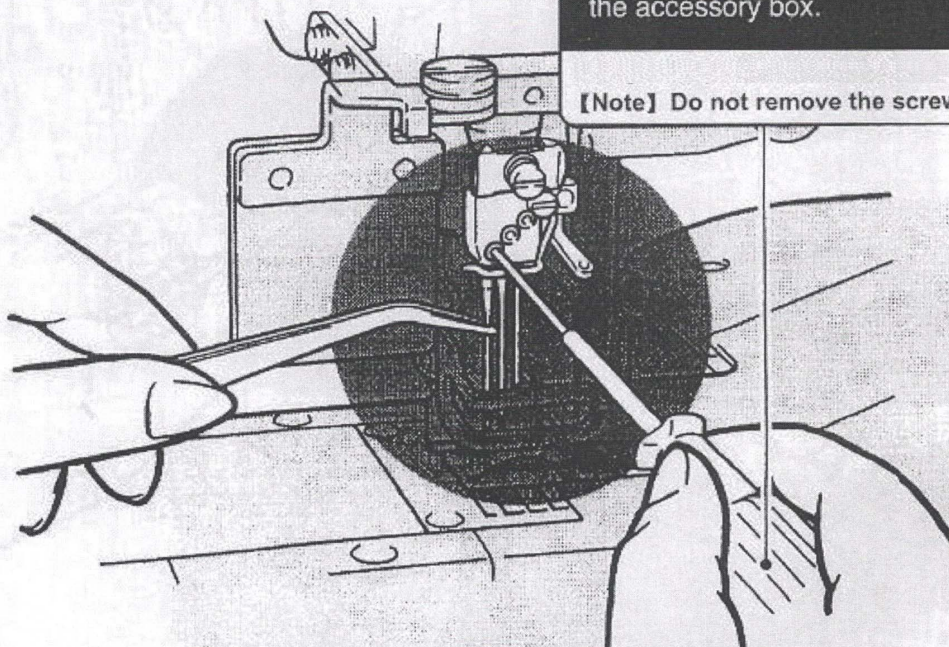


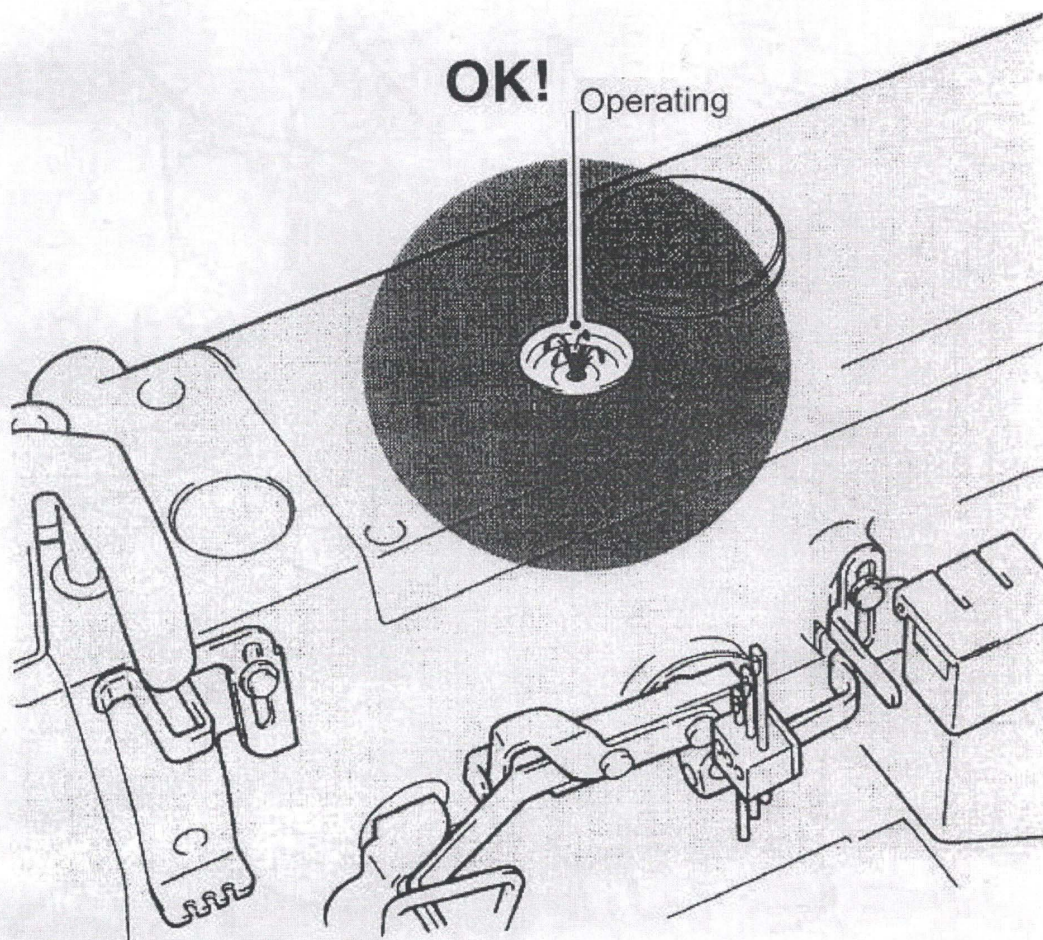
Check the needle carefully to see that the scarf is turned to the rear of the machine.
Insert the needle to the proper depth, and fasten securely.



Be sure to use the red-handled allen key wrench packaged in the accessory box.

[Note] Do not remove the screw.

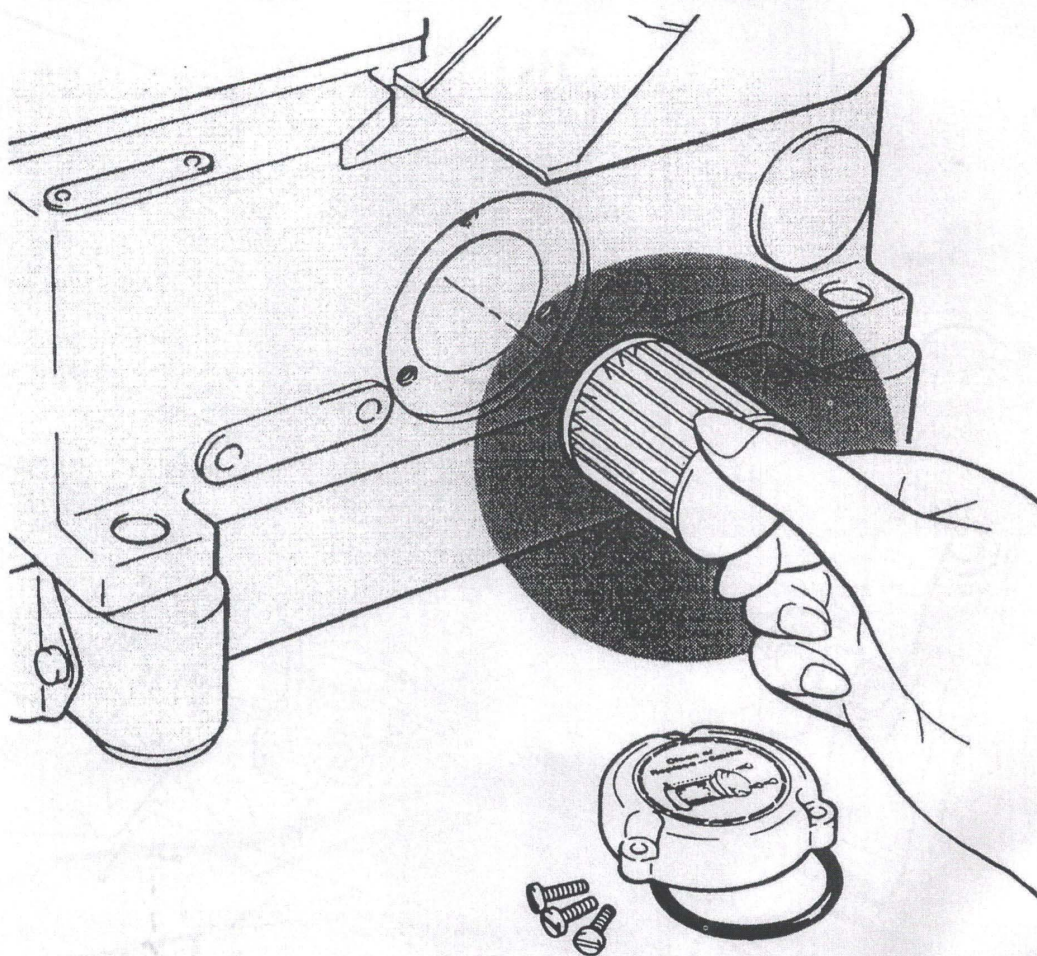




**MAINTENANCE
DURING USE**

Checking and replacing the oil filter

Check and replace the oil filter every six months.

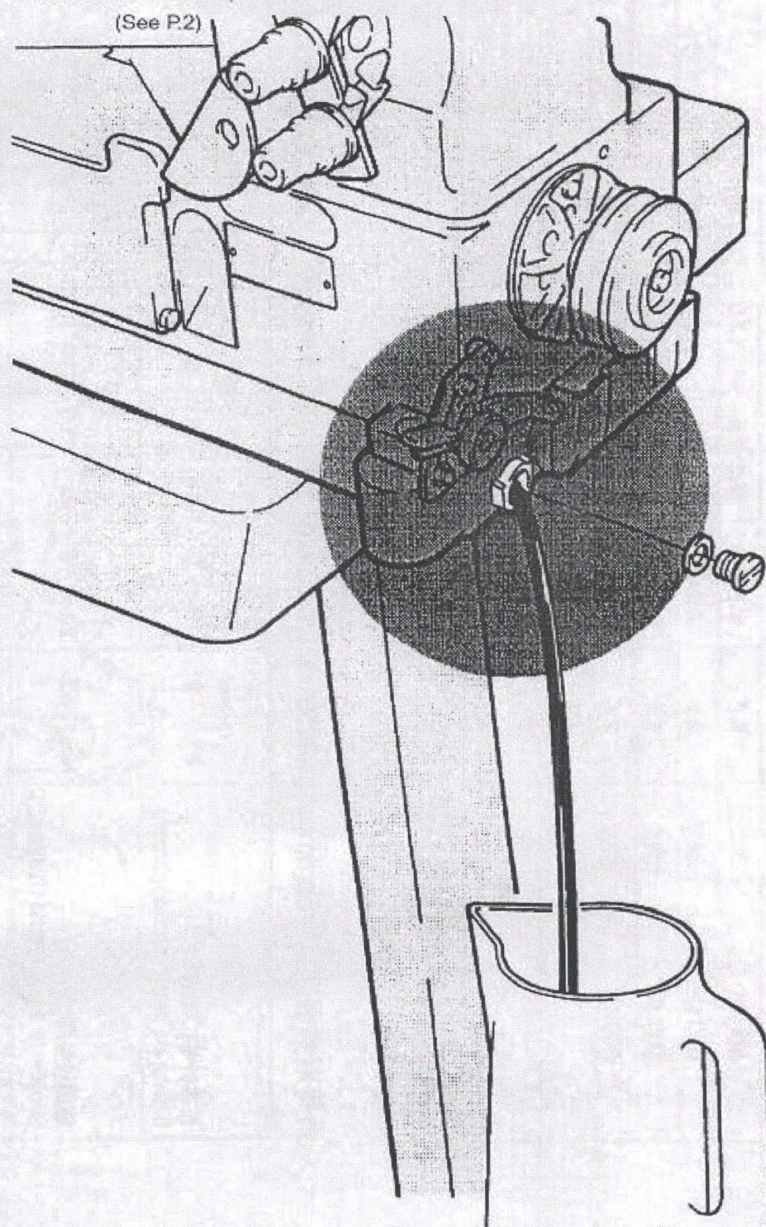


**CHECK AND REPLACE
EVERY 6 MONTHS!**

**MAINTENANCE
DURING USE**

Replacing the oil

Replace the oil one month after the first use and every six months thereafter.



VALORES DE AJUSTE

(mm)

	X□□□						
600-01	232	8.8	4.7~5.0	7.5~7.9	17.0	0.8~1.2	
600-02	240	8.3	4.3~4.6	7.5~7.9	17.0	0.8~1.2	
600-03	248	7.9	3.9~4.2	7.5~7.9	17.0	0.8~1.2	
600-08	256	7.5	3.5~3.8	7.5~7.9	17.0	0.8~1.2	
	264	7.1	3.1~3.4	7.5~7.9	17.0	0.8~1.2	
	356	7.5	3.5~3.8	7.5~7.9	17.0	0.8~1.2	
	364	7.1	3.1~3.4	7.5~7.9	17.0	0.8~1.2	

Tabla de comparación de grosores de aguja equivalentes

(Organ)	#	9	10	11	14	16	18	21
Grosor de aguja japonés (Organ)								
(Schmetz)	Nm	65	70	75	90	100	110	130
Grosor de aguja metrio (Schmetz)								

Aguja estándar

X□□□	DCx27
232	9S
240	9S
248	9S
256	9S
356	10S
364	10S

Exploded view diagram of the front panel assembly. The diagram shows the following components and their part numbers:

- 210679
- 240228
- 004541
- 240127
- 240110
- 240052
- 240227
- 209084
- 007018A
- 303448
- 210586
- 207358
- 255108
- 240001
- 250148
- 210003
- 206590
- 210679
- 250117
- 250157
- 250020
- 007017A
- 240226
- 240045
- 004522
- 205088
- 206590
- 250158-91

Exploded view diagram of a mechanical assembly. The diagram shows various components and their assembly relationships, indicated by leader lines and part numbers. The parts are labeled as follows:

- 007052
- 250154
- 250155
- 240226
- 179107-05
- 007021A
- 250150-YD
- 250019
- 附件 Put in accessory
- 250156-1B
- 007075
- 007019A
- 250021
- 250153
- 250151DYD
- 007021A
- 240263
- 005242
- 007066
- 210307
- 250255
- 303448
- 007020A
- 250256
- 250257
- 202875
- 007009
- 250023
- 303335
- 007052
- 250234-YD
- 007019A
- 007079
- 250159
- 004543
- 250181
- 210025
- 007022A

[illegible]

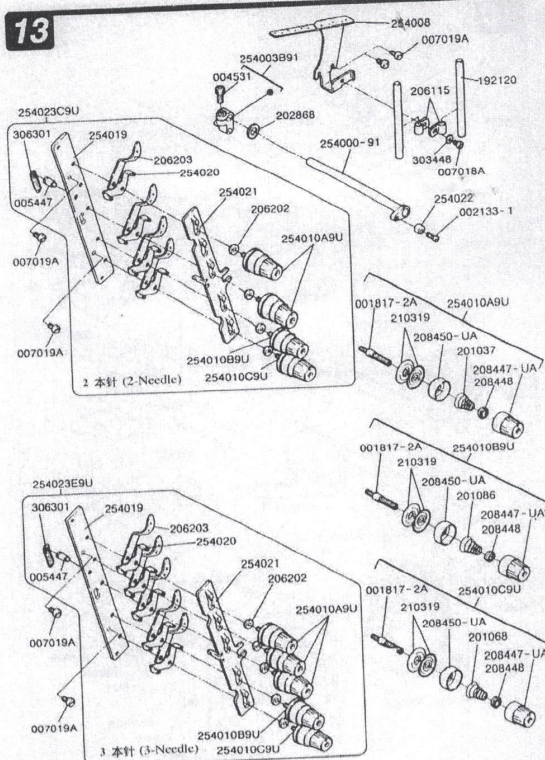
G 参照标准度量表
Refer to the gauge parts list.



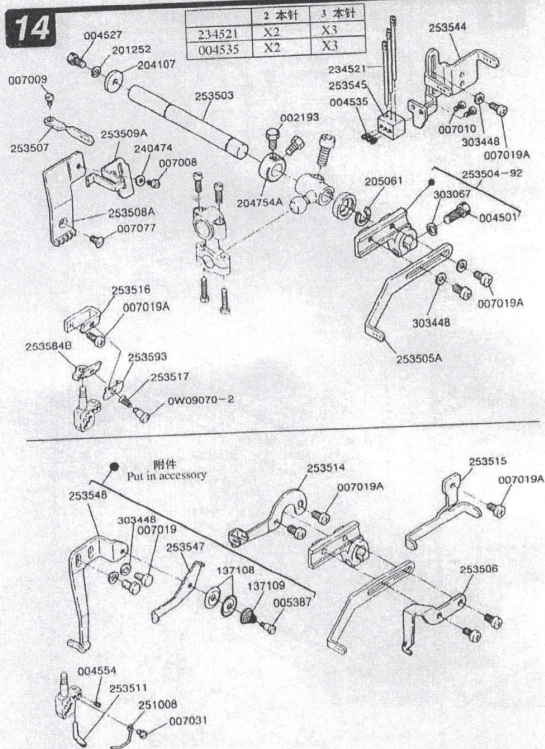
G 参照标准度量表
Refer to the gauge parts list



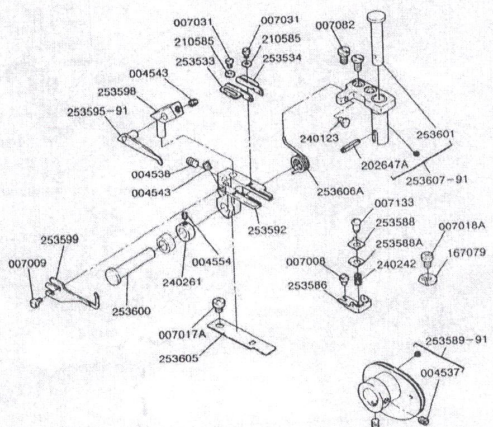
13



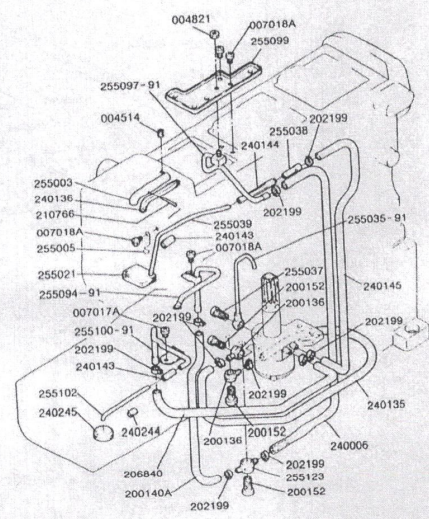
14



15



16



[illegible]

Exploded view diagram of a vehicle interior trim assembly. The diagram shows the installation of a side trim piece (206338) and a rear trim piece (259003-TB) onto a main trim panel (206336). The assembly includes various fasteners and clips labeled with part numbers.

Part numbers shown in the diagram:

- 009016-206338 x 4
- 206336
- 007093
- 206336
- 007027
- 206329
- 205467
- 206337
- 205765
- 205764
- 206337
- 004512
- 259000
- 009016-206338 x 4
- 004906
- 303335
- 259003-TB
- 009032
- 206338
- 207074
- 207073
- 200728
- 202045
- 005020

20

4 本針 (4-Needle)
000293B

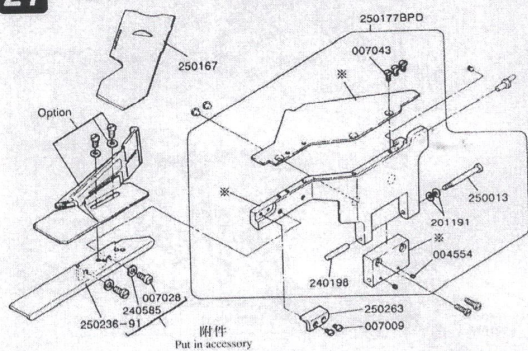
4 卷盘 (4-Spool)
000486B9S

5 卷盘 (5-Spool)
000486B9S

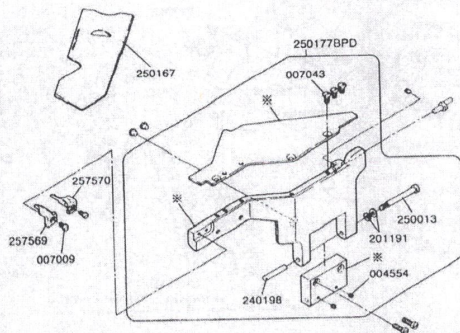
000527-SA
004805
004021
000506
000502-SA
004803
004021
000506
004805
004012
000383-SA
004803
000527ASA
004014
000384
004805
004012
000504-SA
004021
000293A
000382-SA
000380A
000507
000381-SA
000505-SA
201252
004803
004022
000503-SA
000509
004835
007102
000512
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000380A
000507
000381-SA
000505ASA
201252
004803

21

600-01

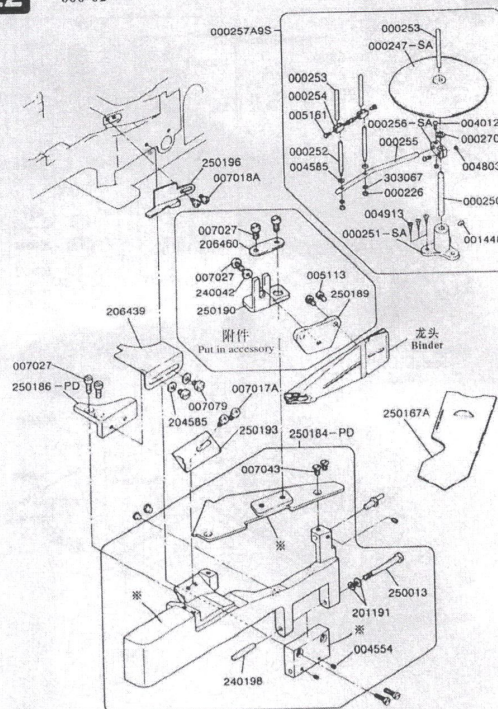


600-03



22

600-02



23

600-08

