



高速包缝机

HIGH-SPEED OVERLOCK SEWING MACHINE

使用说明书 零件手册 OPERATION MANUAL PARTS BOOK

中国·中捷缝纫机股份有限公司
ZOJE SEWING MACHINE CO., LTD.

开头语

为您购买 700 系列缝纫机，我们表示衷心的感谢！

在使用缝纫机之前，请认真阅读此说明书，愿您自始至终爱护并使用敝公司的产品。

另外，为了让您的缝纫机高效率的使用，此说明书登载了有关日常中检查与安全的注意事项。

在平时，除了对缝纫机进行检查之外，也请您多加注意自身的安全，做到安全使用。这是我们的心愿。

INTRODUCTION

Thank you very much for purchasing 700 Series machine.

This instruction manual describes daily routine maintenance and safety precautions to keep the machine in the best possible conditions.

Please study this manual very carefully before operating the machine.



为了安全

对缝纫机本身及各种装置，我们充分考虑到它的安全性。请遵照基本操作方法，安全地进行工作。

●在拆除了为保证安全所设置的装置零件的情况下使用，是非常危险的，请绝对不要拆除后使用。

●缝纫机在使用时，请不要在缝纫机台上放置工具及缝纫时不必要的物品。

●在对缝纫机进行检修、调节、清扫、穿线、换针等工作时，为防止发生事故，请务必切断电源，在确认即使踩下缝纫机踏板，缝纫机也不转动之后，再进行操作。



CAUTION

OBSERVE THESE SAFETY PRECAUTIONS

Though Pegasus takes the utmost care to produce safe sewing machines and devices, operators should follow these basic safety rules.

● To prevent accidents, do not remove safety devices or parts while operating the machine.

● Do not leave tools or other unnecessary objects on the machine table while operating the machine.

● Before maintenance, adjusting, cleaning, threading or replacing the needle, and to prevent accidents, be sure the power is turned off. Check that the machine will not operate when the pedal is pressed.

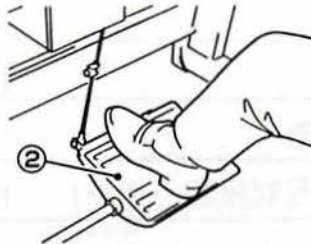
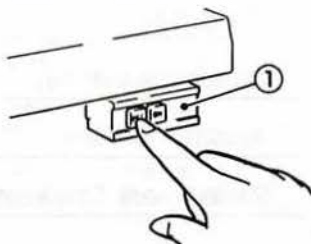
注意

使用离合式马达的情况下，关掉电源①后因惯性作用马达仍会继续旋转，这时如不慎踩动缝纫机踏板②，缝纫机会突然动作，这是很危险的。

请在关掉电源后，仍继续踩动踏板②，直至缝纫机完全停下来为止。

Note

In case a clutch type motor is used, it will keep on rotating by inertia after turning off power supply ①. If the machine pedal ② is stepped on inadvertently, it is dangerous because the machine will move unexpectedly. Keep on stepping on the machine pedal ② until the machine comes to a stop after turning off power supply ①.



●在离开缝纫机时，请务必关掉电源。

●停电时也请务必关掉电源。

●为了安全，运转良好的缝纫机，日常点检是不可缺少的，请予以注意。

● Turn the power off before leaving the machine table.

● In the event of a power failure, be sure to turn the machine off.

● Check that the machine is securely grounded.

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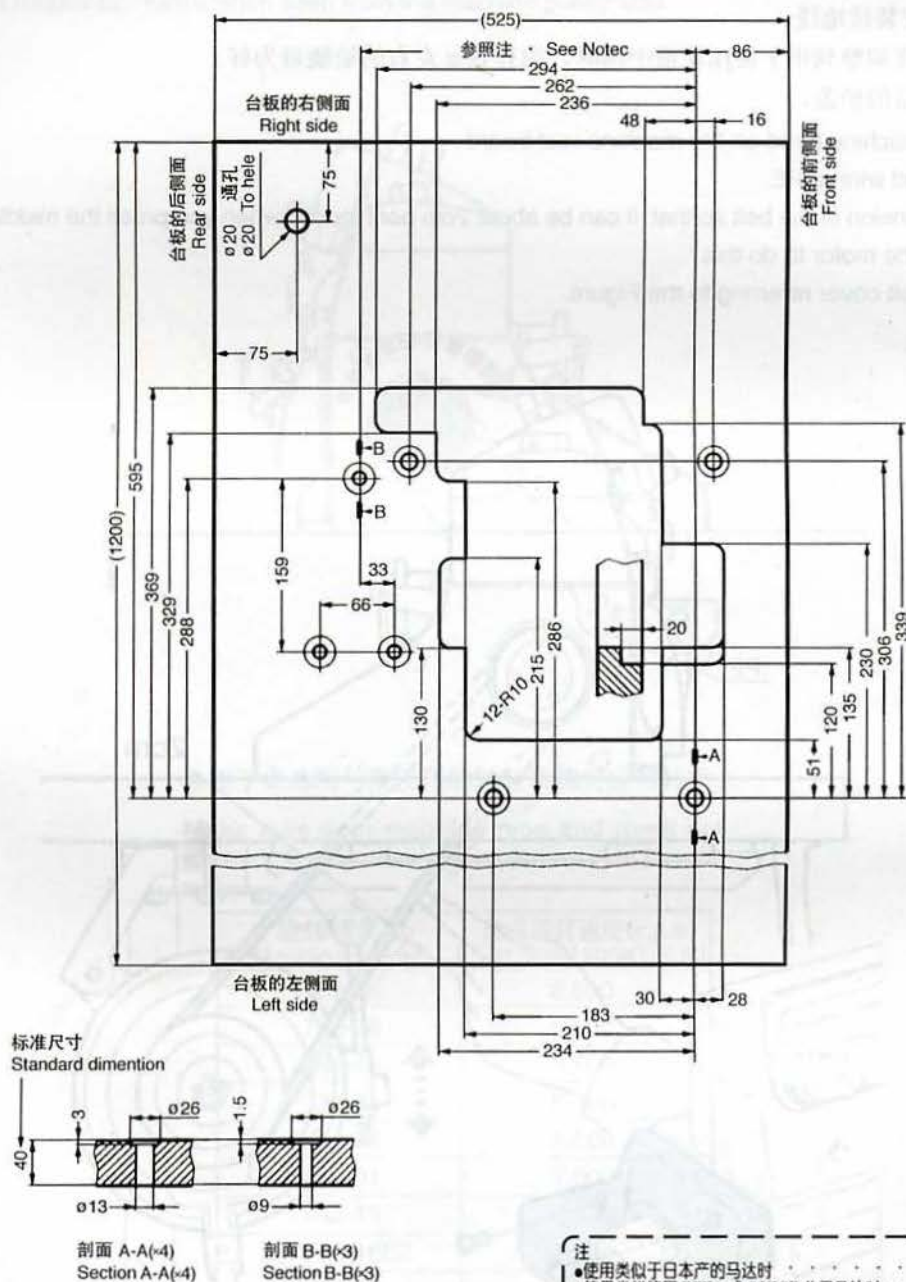
在使用之前
BEFORE
OPERATING

台板加工图

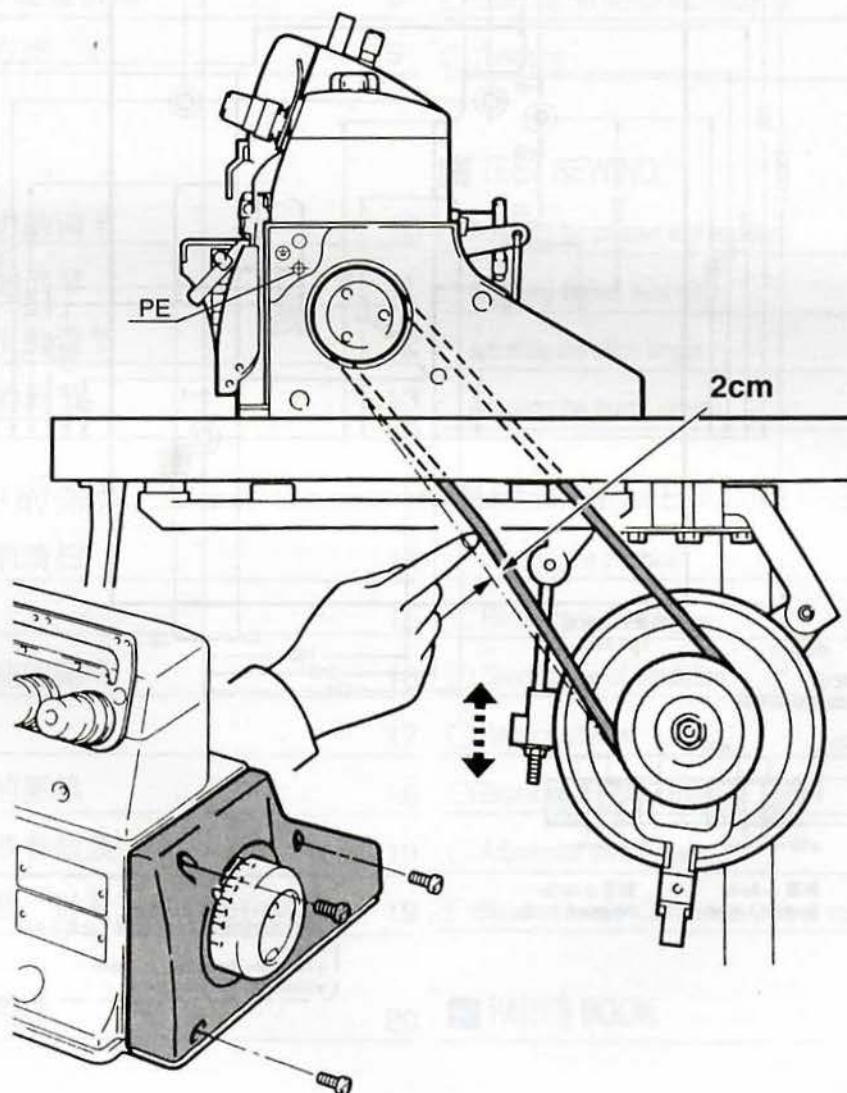
Schematic diagram of the machine table

请参照下图进行台板的加工

Cut the table referring to the diagram



- 1、将缝纫机装于台板之上，给缝纫机侧皮带轮和马达侧皮带轮装上三角胶带。
 - 2、在 PE 处安装接地线。
 - 3、将马达高度调整到用手按压皮带中间时，约有 2cm 左右的松弛量为好。
 - 4、请装好皮带的护盖。
1. Mount the machine head on the machine rest board .
 2. Install ground wire at PE.
 3. Adjust the tension of the belt so that it can be about 2cm bent inward when you press the middle of it. Adjust the height of the motor to do this.
 4. Install the belt cover referring to the Figure.

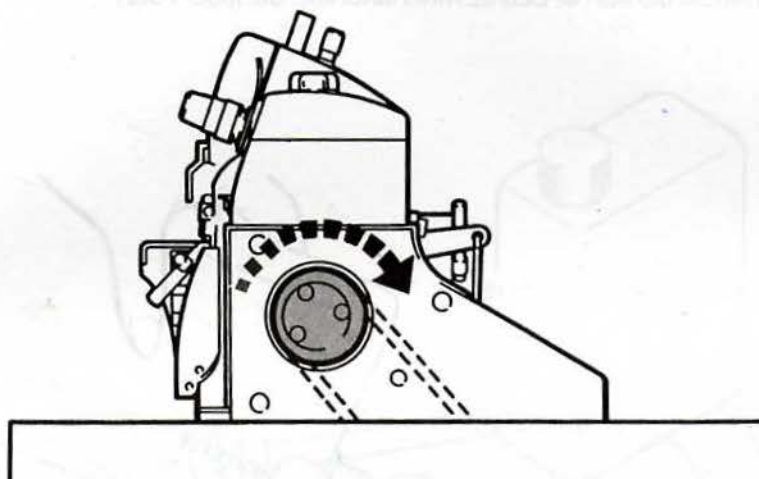


在使用之前
BEFORE
OPERATING

缝纫机的旋转方向及转数 The machine speed and the turning direction

缝纫机的旋转方向，从皮带轮侧看是向右旋转的。

The machine rotates clockwise when seen from the machine pulley side.



参照下表选用与所使用的缝纫机相对应的转数。

Make sure your machine type and run it not exceeding the maximum speed as listed in the table.

缝纫机机型 Machine model	最高旋转速度(r.p.m) The highest speed(r.p.m)
732-36	6,500
732-38	6,500
732-48	5,500
732-70	6,500
732-86	5,500
752-01	7,000
752-13	6,500
752-16S2	6,000
752-17	7,000

在使用之前
BEFORE
OPERATING

供 油 Lubrication

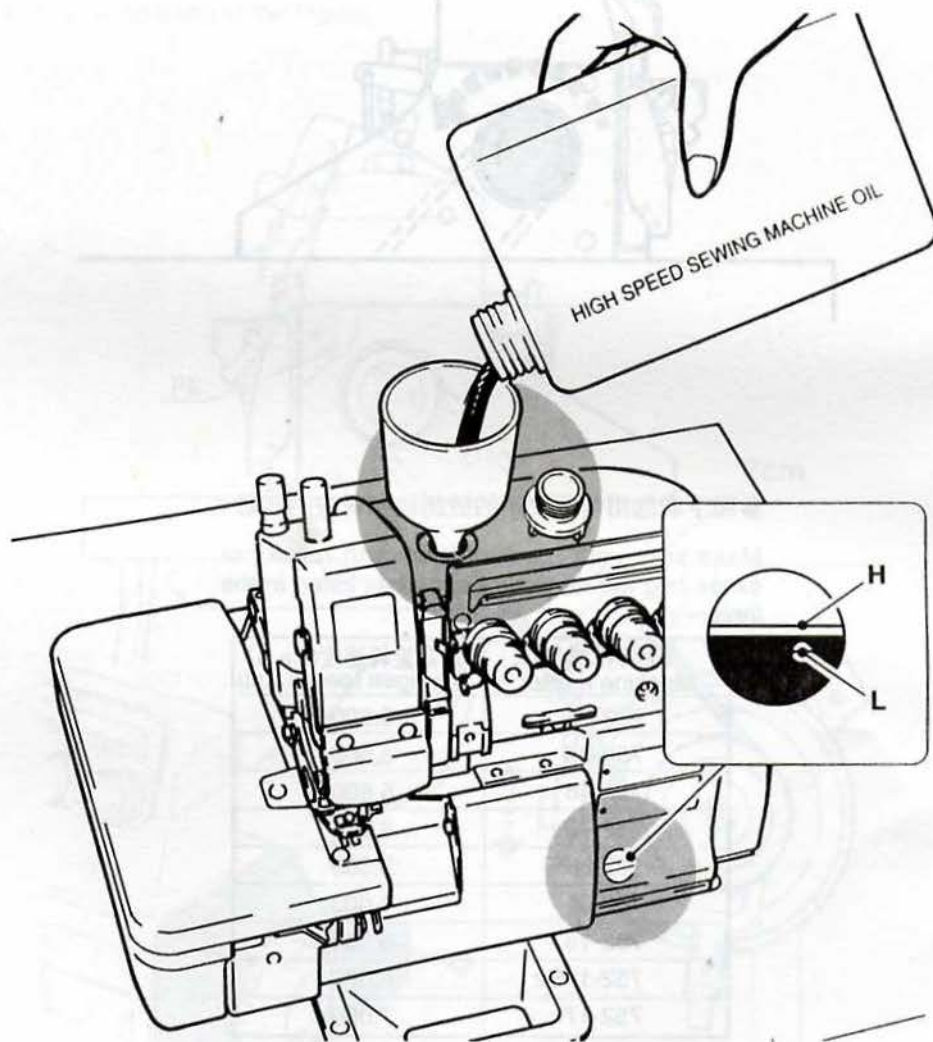
加油量要使油面处于H线与L线之间为好,当油面低于L线时,就要及时补充机油。

注意: 请使用指定的机油(HIGH SPEED SEWING MACHINE OIL)(ISO 粘度与VG22 相同)。

After filling the oil pan, the oil surface should lie between (H) and (L) lines.

Add oil when the oil surface reaches or goes below (L)

Note: Use recommended oil (HIGH SPEED SEWING MACHINE OIL) (ISO VG22)



在使用之前
BEFORE
OPERATING

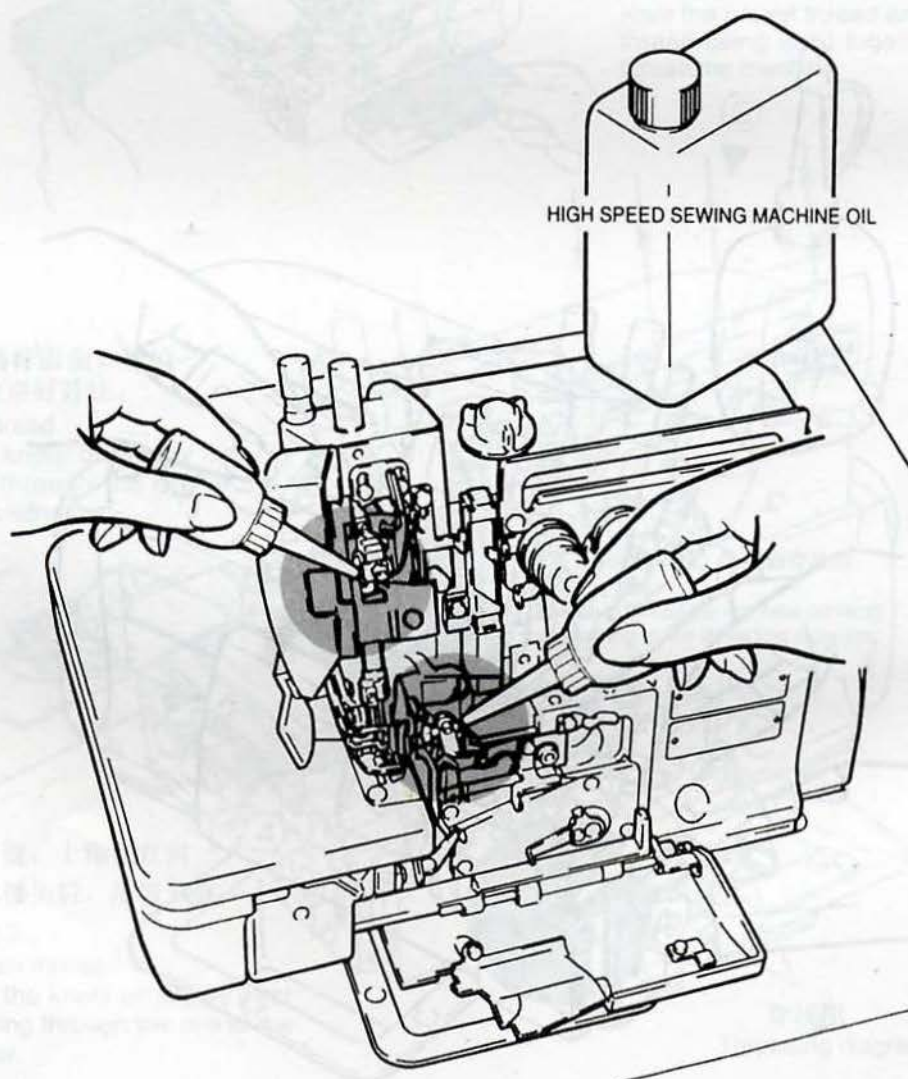
手 动 给 油

Manual lubrication

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

注：请使用指定的机油(HIGH SPEED SEWING MACHINE OIL)(ISO 粘度与 VG22 相同)。

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.
Note: Use recommended oil(HIGH SPEED SEWING MACHINE OIL)(ISO VG22)



在使用之前
BEFORE
OPERATING

给 H R 装置供油

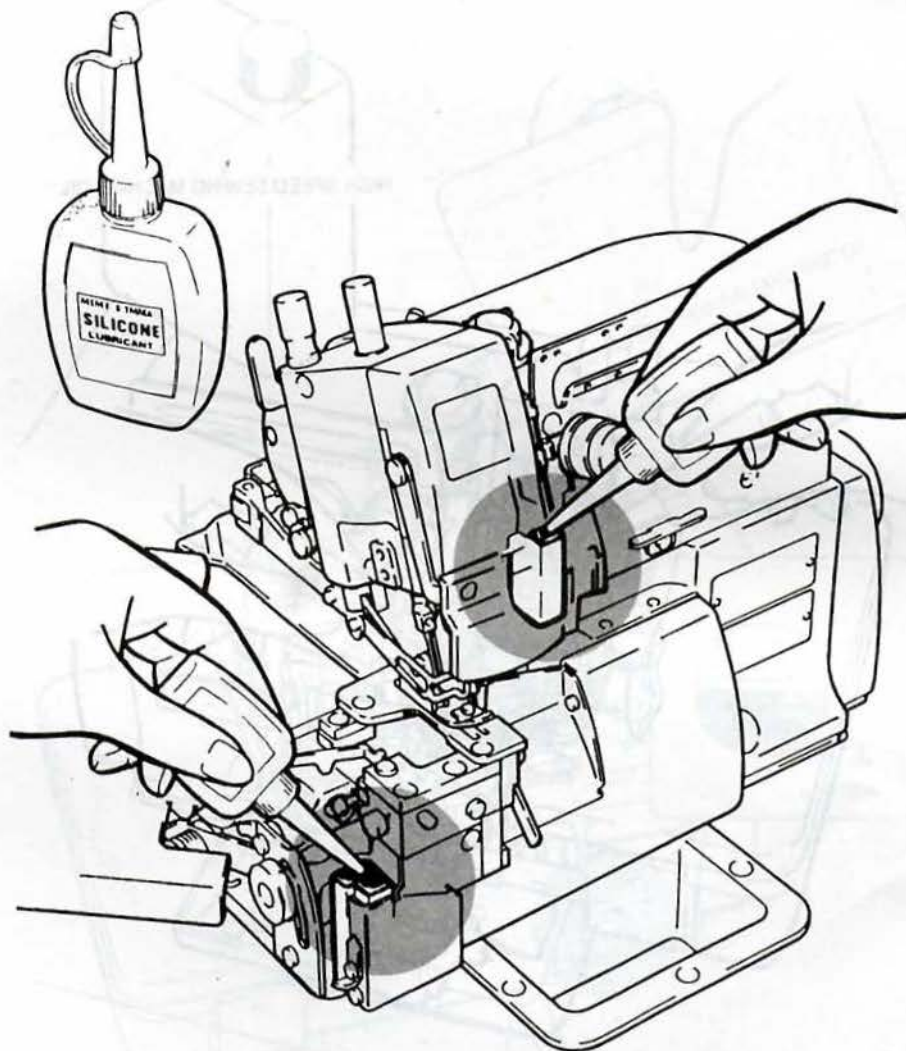
Filling the HR device with silicon oil

为了防止布纤维或线被切断，请尽早给 HR 装置供油。

注：硅油请使用指定的冷却油。

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

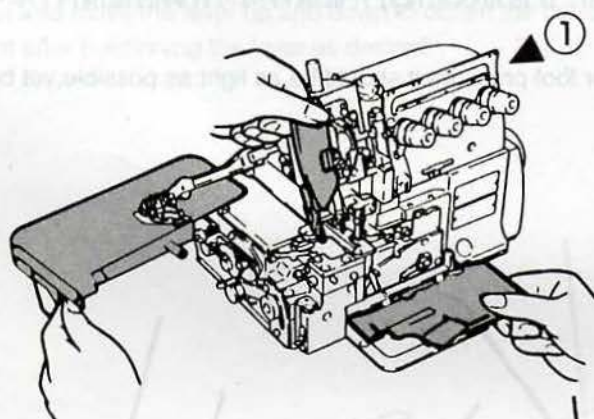
Note: Use recommended silicon oil



在使用之前
BEFORE
OPERATING

穿线的方法

Threading



① 打开压脚杆及机盖(三处)

Open three covers.
Swing the presser foot aside.

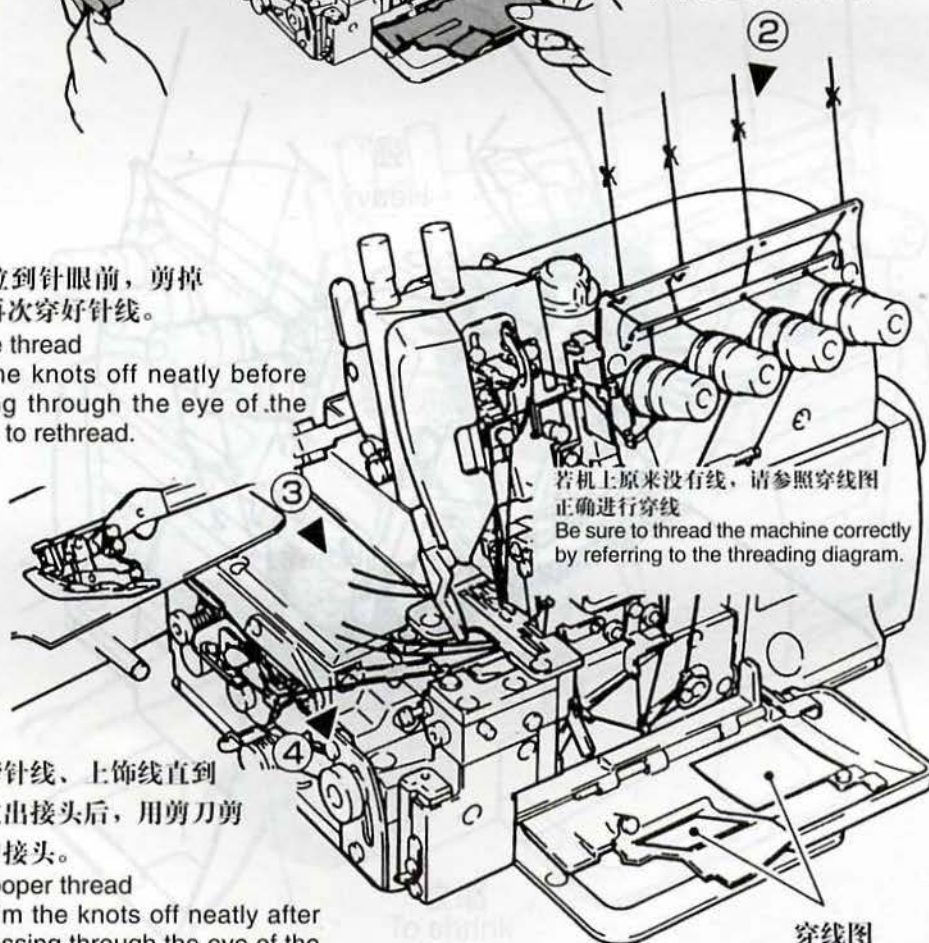
把机上原有的线与缝纫用线绑
结在一起

Knot the preset thread and the
thread being used together to
thread the machine.

针线
将线拉到针眼前, 剪掉
结头再次穿好针线。

Needle thread

Trim the knots off neatly before
passing through the eye of the
needle to rethread.



②

若机上原来没有线, 请参照穿线图
正确进行穿线
Be sure to thread the machine correctly
by referring to the threading diagram.

弯针线、上饰线直到
拉出接头后, 用剪刀剪
齐接头。

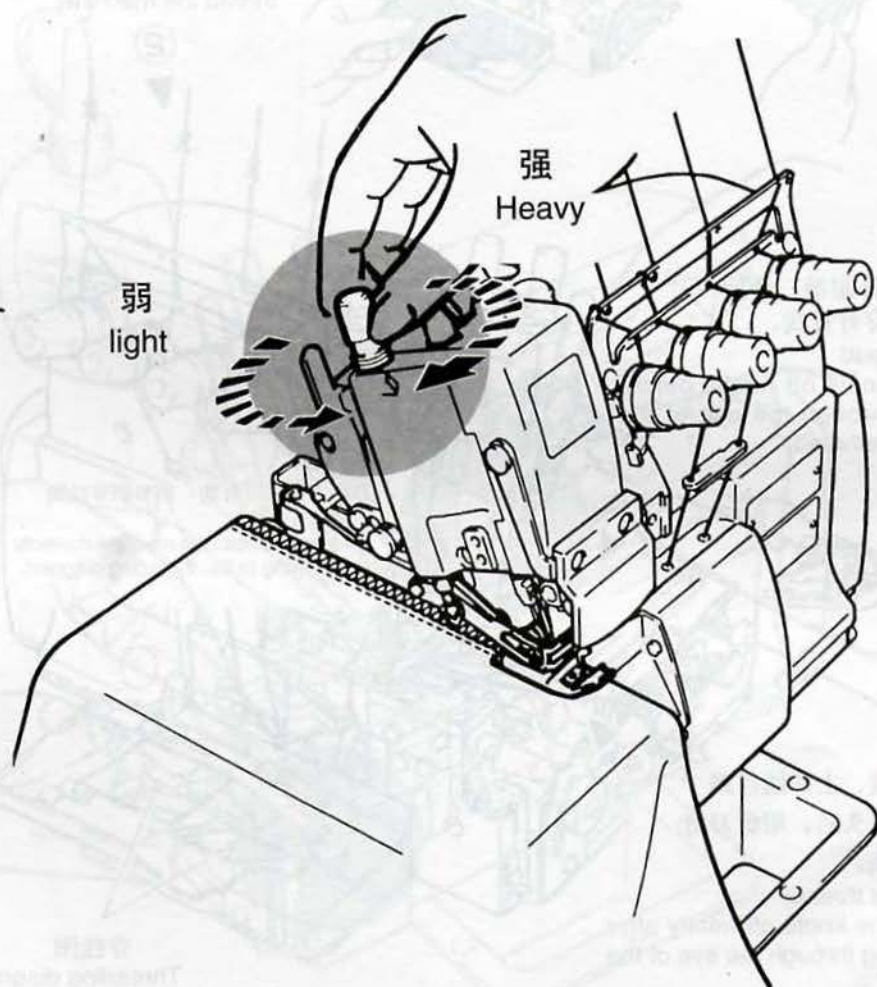
Looper thread

Trim the knots off neatly after
passing through the eye of the
looper.

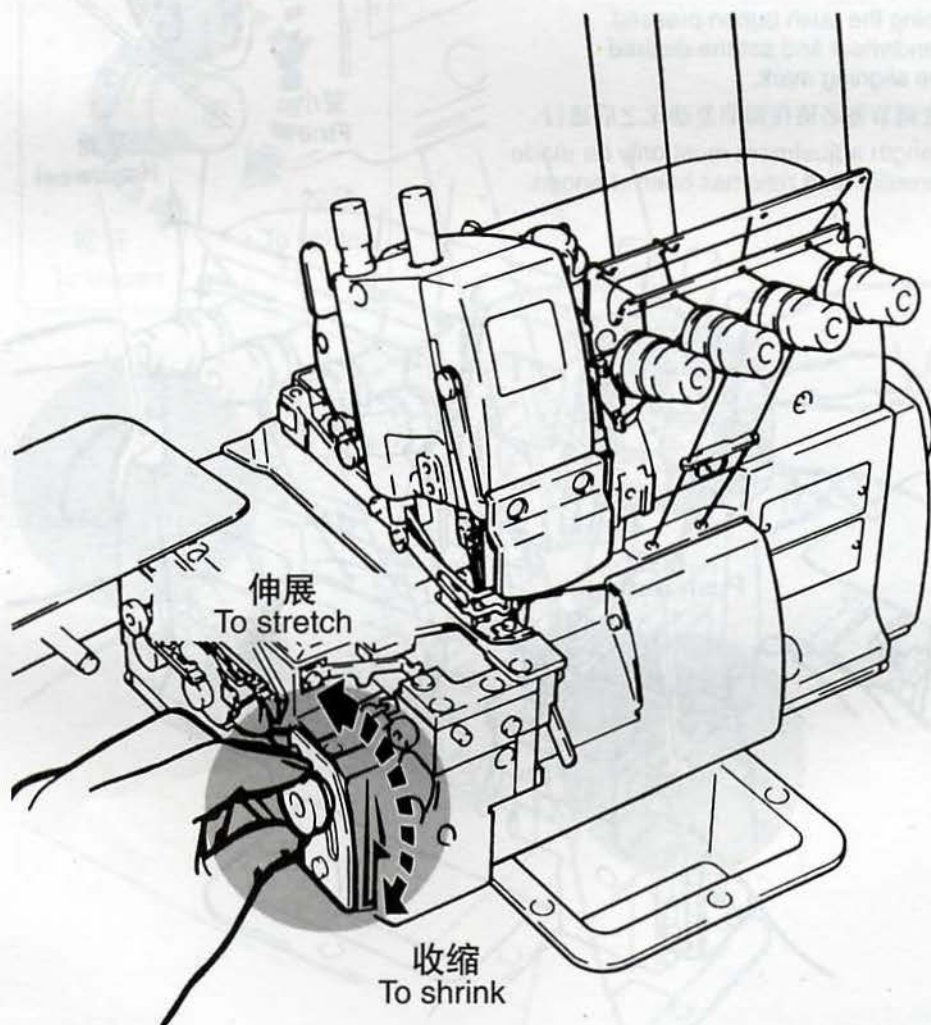
穿线图
Threading diagram

压脚压力的调节可旋转螺帽进行调节。在送布状态良好并能取得均匀针脚的范围内,尽可能使用较弱的压力为好。

Turn adjusting screw to adjust the presser foot pressure. It should be as light as possible, yet be sufficient to obtain the proper stitch formation.



差动比的调节是松开螺母后，上下移动来进行调节，调节完后，将螺母拧紧。
Loosen the nut and move the lever up and down to obtain the correct differential feed ratio.
Tighten the nut after positioning the lever as desired.

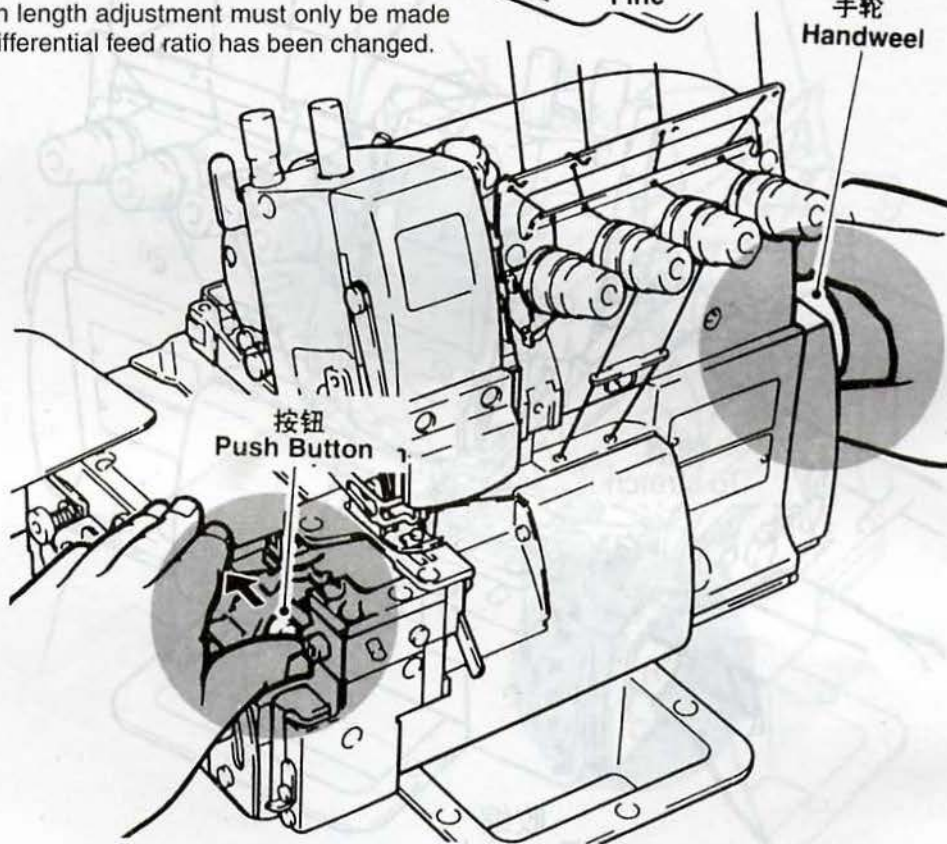
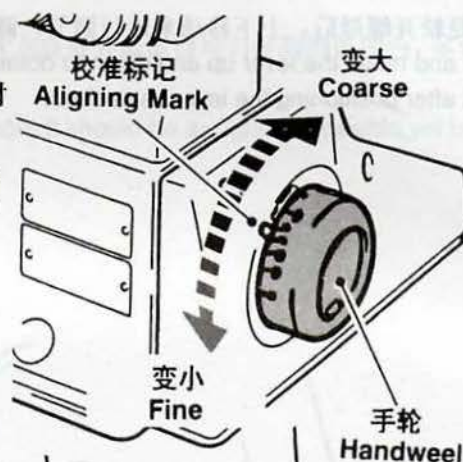


1. 摁住按钮，旋转手轮，按钮会陷进更深处。
2. 这时边摁住按钮，边转动手轮，使校准标记对准所希望的数值。

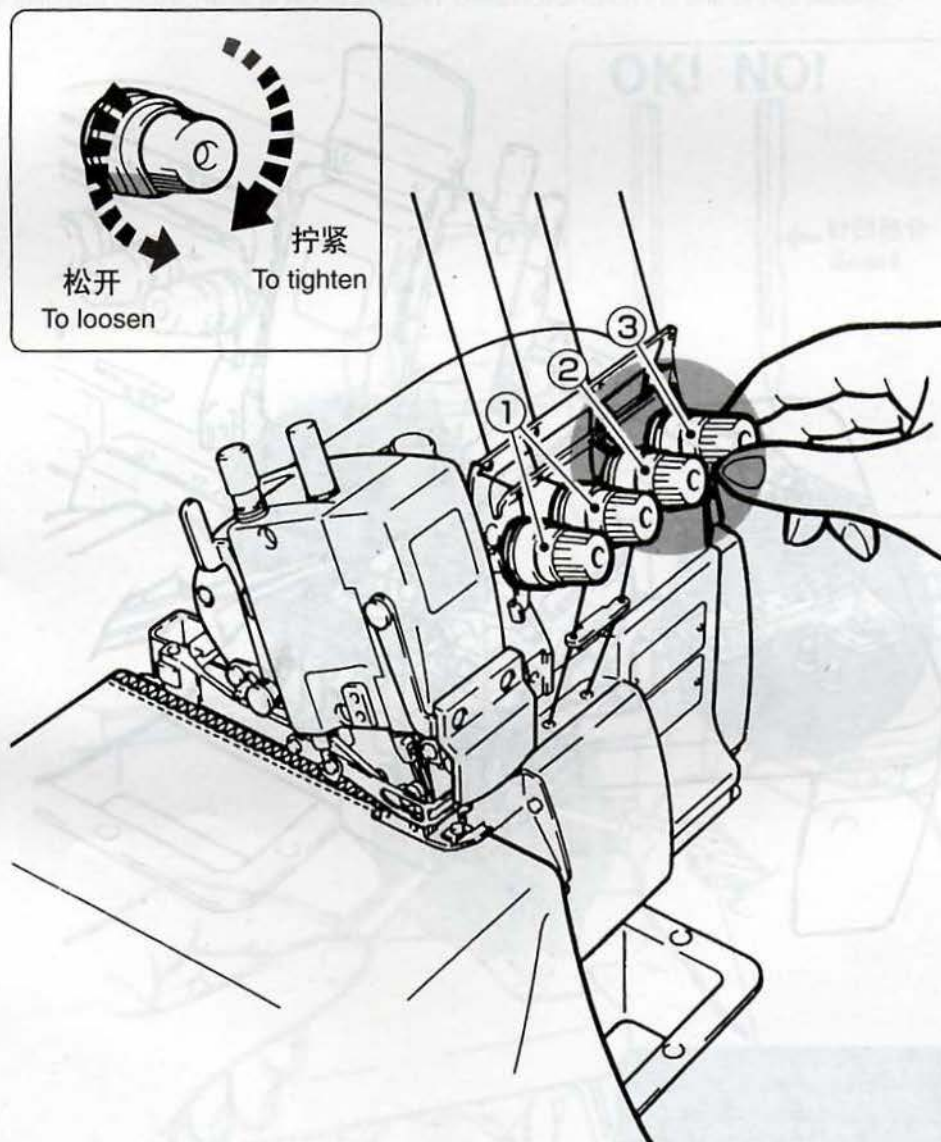
① While pressing the push button, turn the handwheel to seek the position at which the push button goes further into the depth.

② Then, keeping the push button pressed, turn the handwheel and, set the desired scale to the aligning mark.

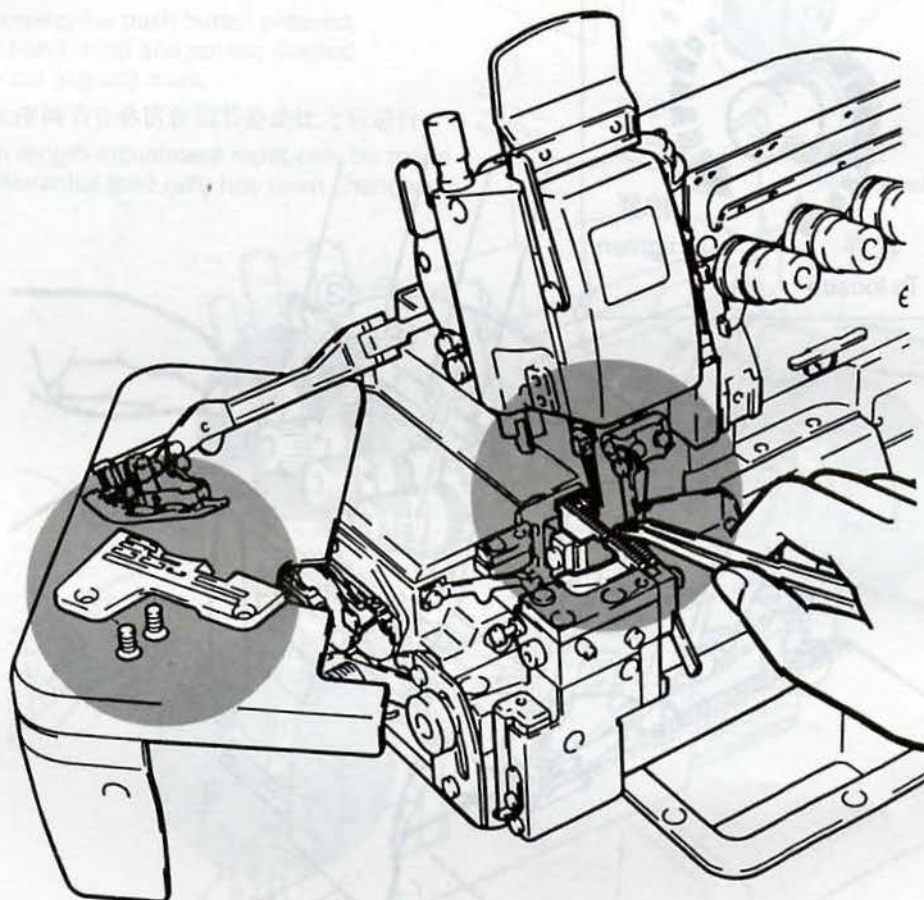
注：针脚长度调节务必请在调节差动比之后进行。
Note: Stitch length adjustment must only be made after the differential feed ratio has been changed.



线张力状态的调节，请用针线调节螺帽①、上弯针线调节螺帽②、弯针线调节螺帽③来进行调节。
Make tension adjustments with the needle thread knob ①, the upper looper knob ②, and the lower looper knob ③.



缝纫机的清扫，以针板槽及送布牙周围为主。
Mainly the slots of the needle plate and the feed rows should be cleaned.



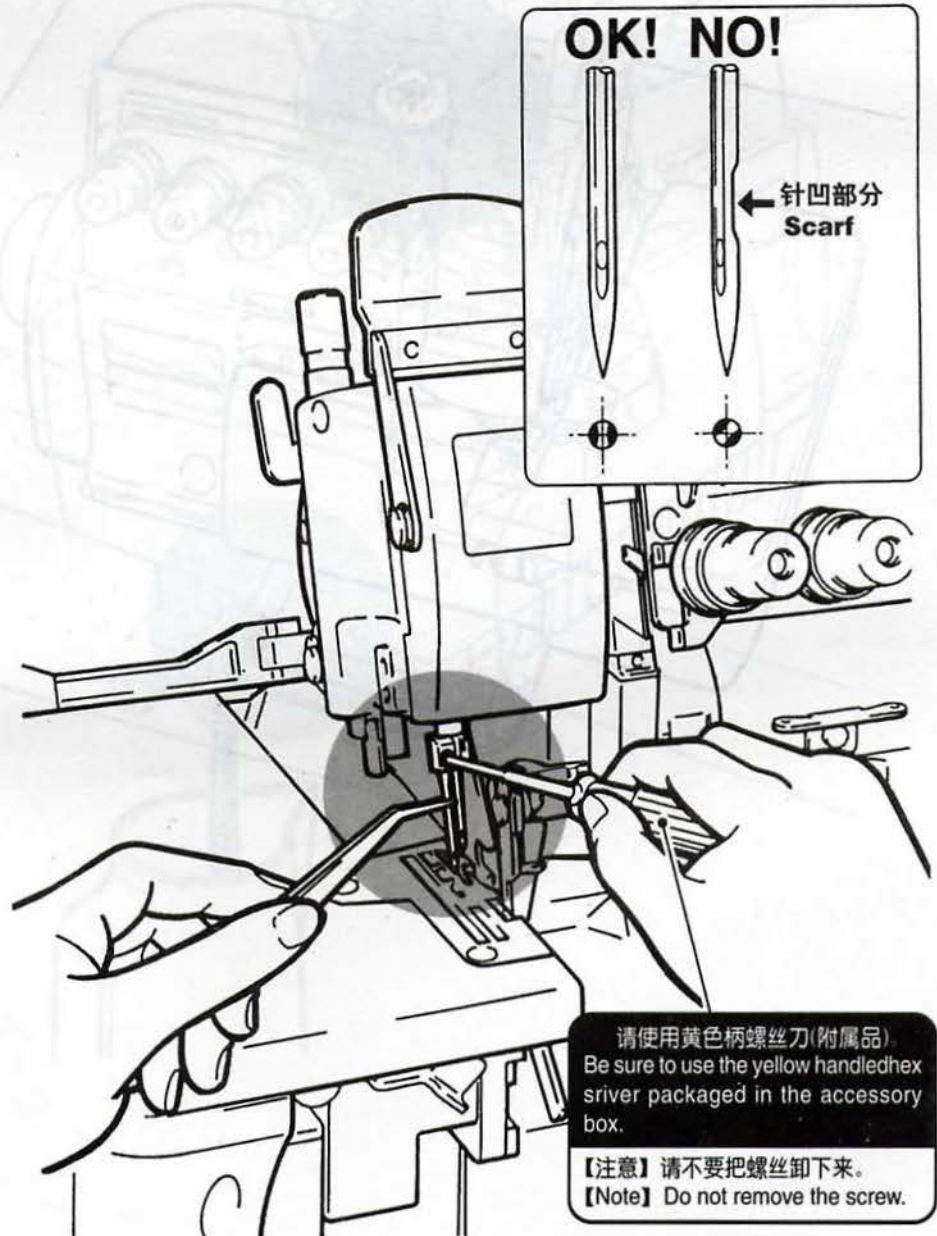
准确辨认针的前后，请将针凹向着后方，即背向操作者进行安装。

针要牢固的插到孔的最深处。

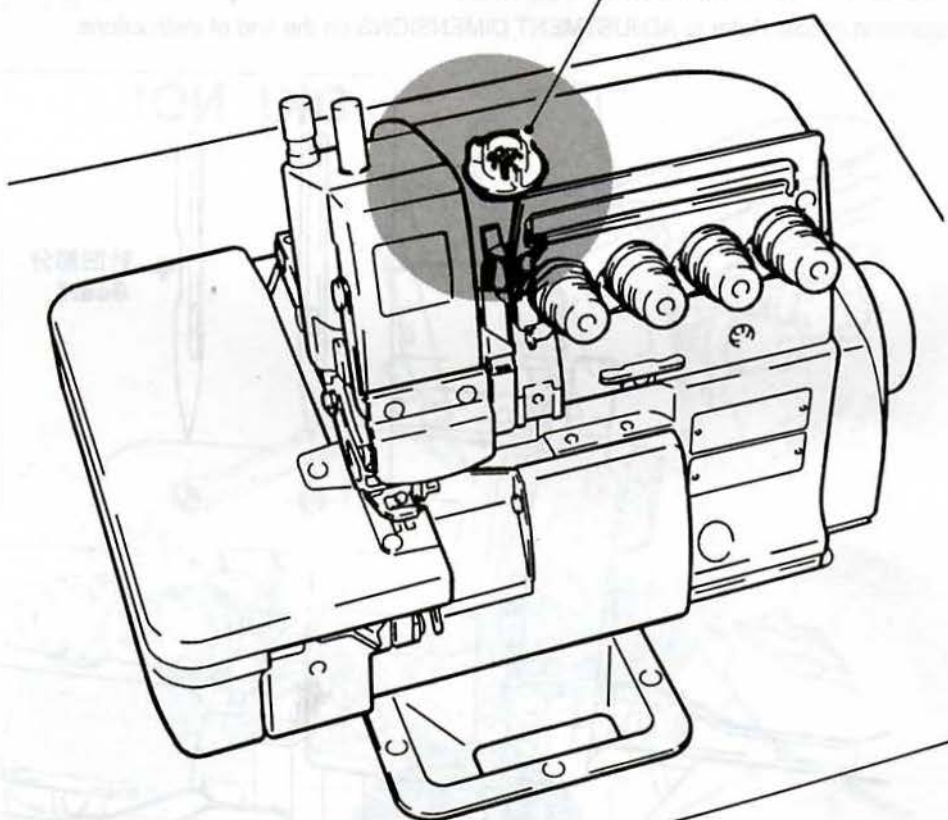
- Check the needle carefully to see that the scarf is turned to the rear of the machine.
- Insert the needle to the proper depth, and fasten securely.

标准使用的缝纫针，请参照卷末附有的“调整标准表”

Be sure to use standard needle. Refer to ADJUSTMENT DIMENSIONS on the end of instructions.

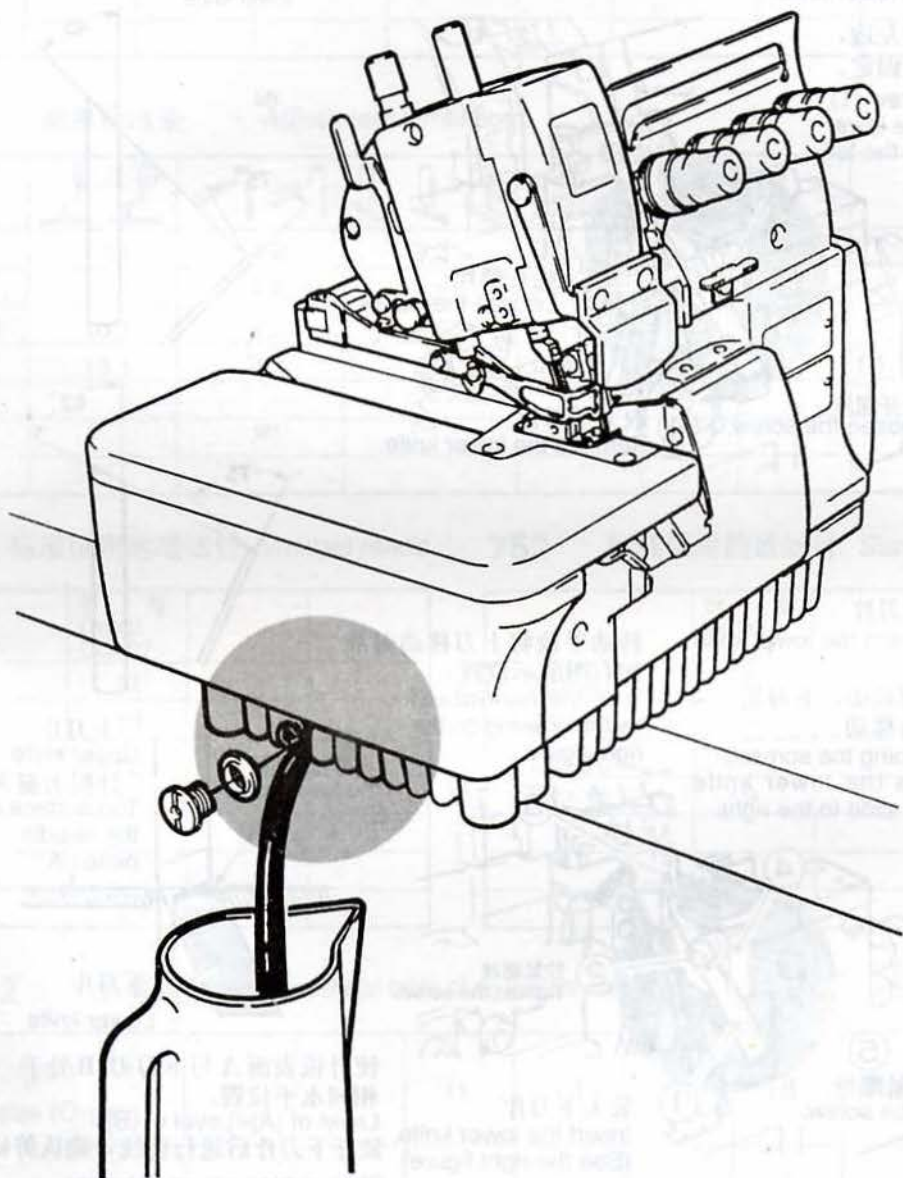


OK! 运转中
Operating



机油的更换，请在使用开始1个月后更换一次，然后，每6个月更换一次。
Replace the oil one month after the first use and every six months thereafter.(See P7.)

供油请参见第7页。

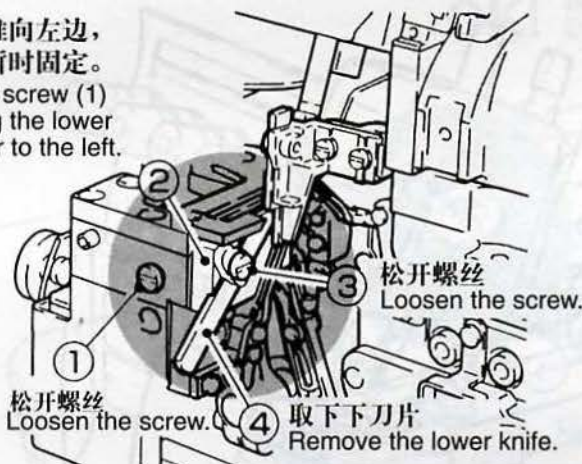


卸下下刀片

To remove the lower knife

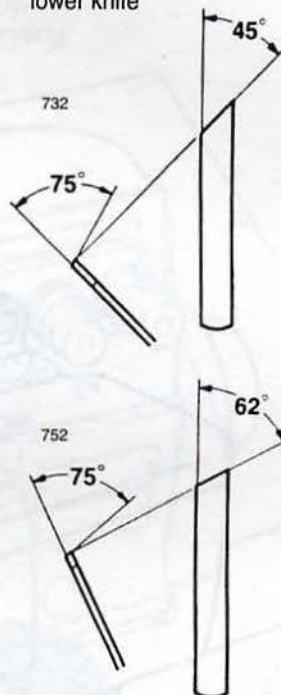
把下刀架推向左边，
用螺丝①暂时固定。

Temporarily screw (1)
after sliding the lower
knife holder to the left.



下刀片正确的研磨角度

Correct angles to resharpen the
lower knife



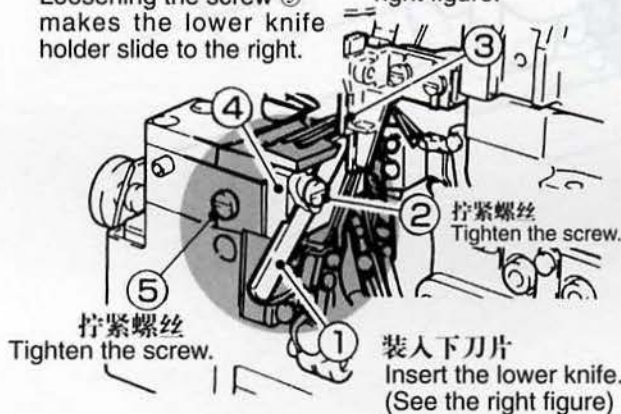
安装下刀片

To replace the lower knife

松开螺丝⑤，下刀架
则向右移动。

Loosening the screw ⑤
makes the lower knife
holder slide to the right.

转动手轮将上刀移动对准
如右图所示位置。
Turn the handwheel
as the drawing on the
right figure.

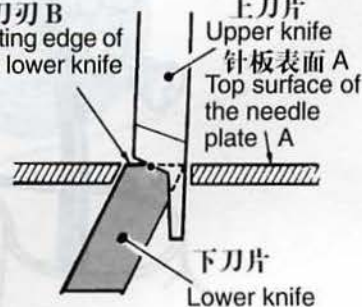


下刀刃 B

Cutting edge of
the lower knife
B

上刀片

Upper knife
针板表面 A
Top surface of
the needle
plate A



使针板表面 A 与下刀刃 B 处于
相同水平位置。

Level of (A)=Level of (B)

装好下刀片后进行剪线，确认剪切状况。

Check cutting action of knives.

732

调整标准表

Adjustment dimentions

(mm)

									
732-36	10.6	3.9	3.3	0.9~1.1	5.5	1.5			
732-38	10.6	3.9	3.3	0.9~1.1	5.5	1.5			
732-48	10.1	3.9	3.3	0.9~1.1	5.5	1.5			
732-70	10.6	3.9	3.3	0.9~1.1	5.5	1.5			
732-86	12.0	3.4	3.3	0.9~1.1	5.5	1.5			

752

调整标准表

Adjustment dimentions

(mm)

								
752-01	10.1	4.2	3.3	0.9~1.1	5.5			
752-13	10.1	4.6	4.0	0.9~1.1	5.5			
752-16S2	10.1	4.2	3.3	0.9~1.1	6.0			
752-17	10.1	4.2	3.3	0.9~1.1	5.5			

732

标准使用的缝纫针 Standard needle

752

标准使用的缝纫针 Standard needle

	针号 Organ DCX27		
732-36	11		
732-38	14		
732-48	14		
732-70	14		
732-86	21		

	针号 Organ DCX27		
752-01	9		
752-13	9		
752-16S2	11		
752-17	9		

732 · 752

针号对照表 Comparison table of equivalent sizes

日本针号 (Organ) Japanese size (Organ)	#	9	11	14	16	18	21	
中国针号 Chinese size (Organ)	Nm	65	75	90	100	110	130	

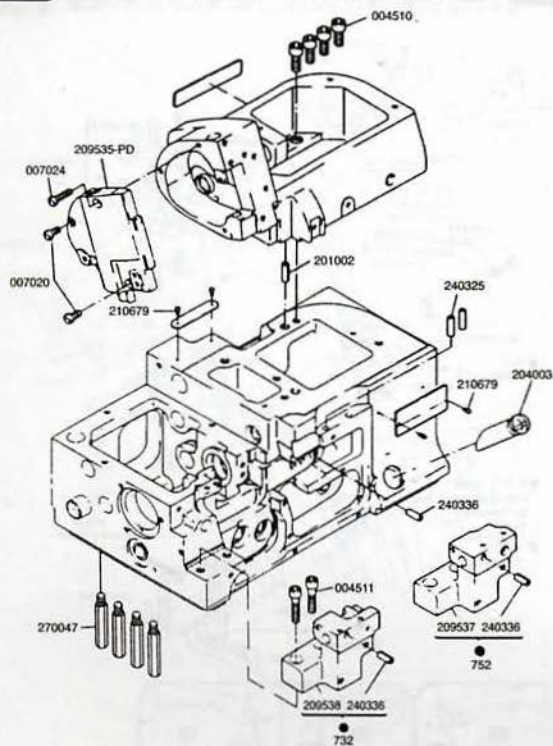
高速包缝机

HIGH-SPEED OVERLOCK SEWING MACHINE

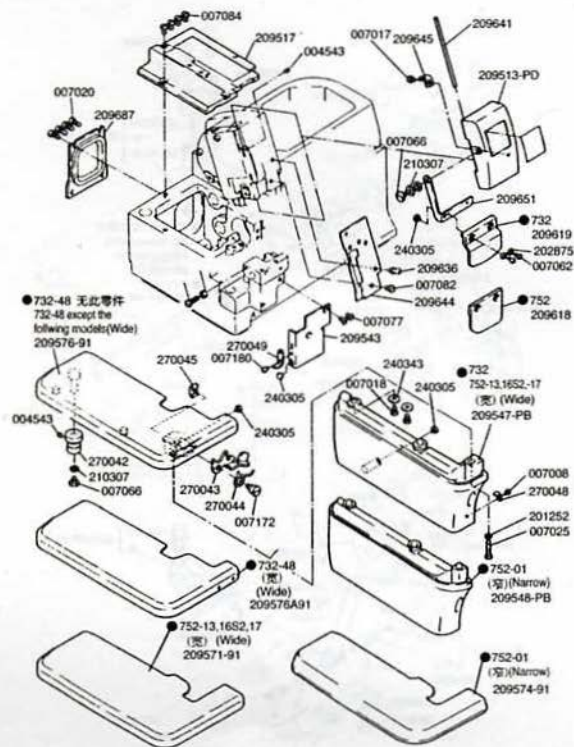
零件手册

PARTS BOOK

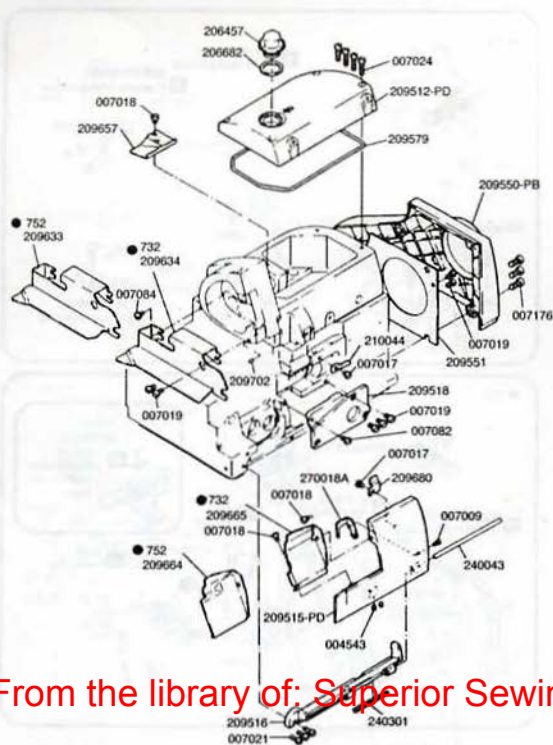
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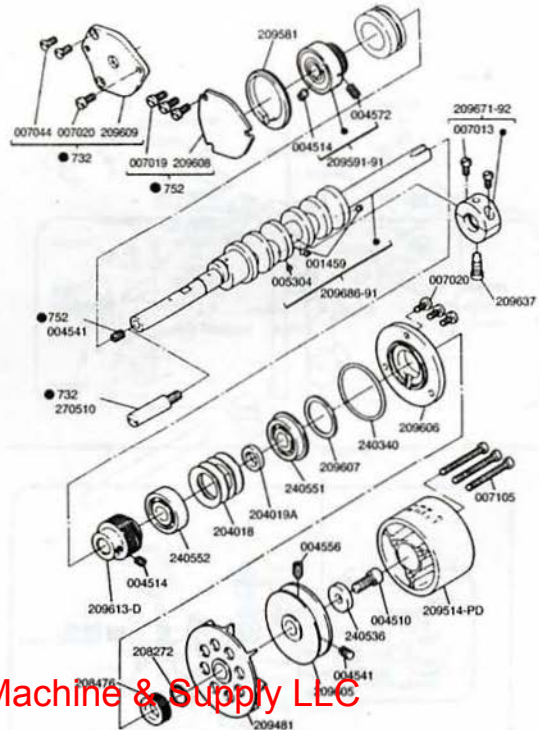
2



3



4



G

Please confirm the correct part by the gauge parts lists.



Please confirm the correct part by the gauge parts lists.



Please confirm the correct part by the gauge parts lists.



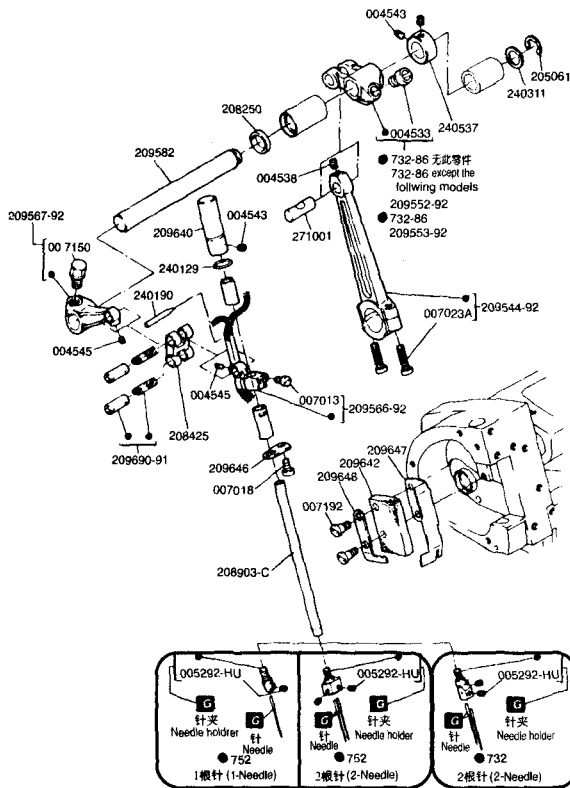
Please confirm the correct part by the gauge parts lists.

9



请参照标准零件表

Please confirm the correct part by the gauge parts lists.

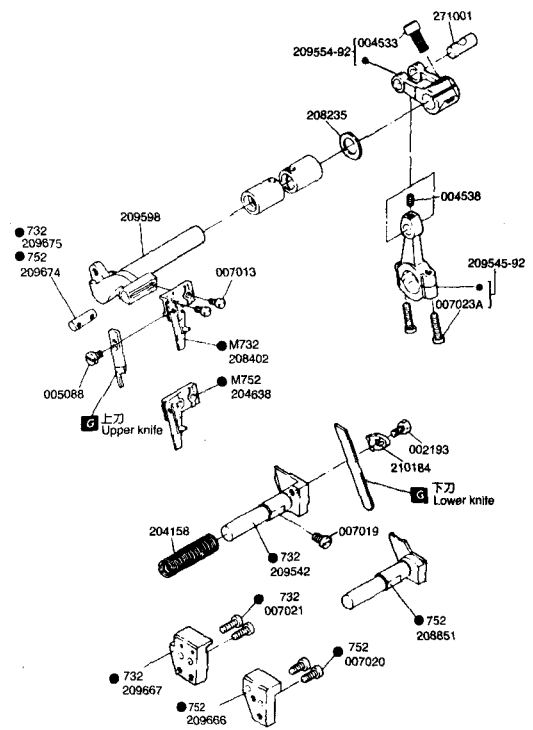


10



请参照标准零件表

Please confirm the correct part by the gauge parts lists.

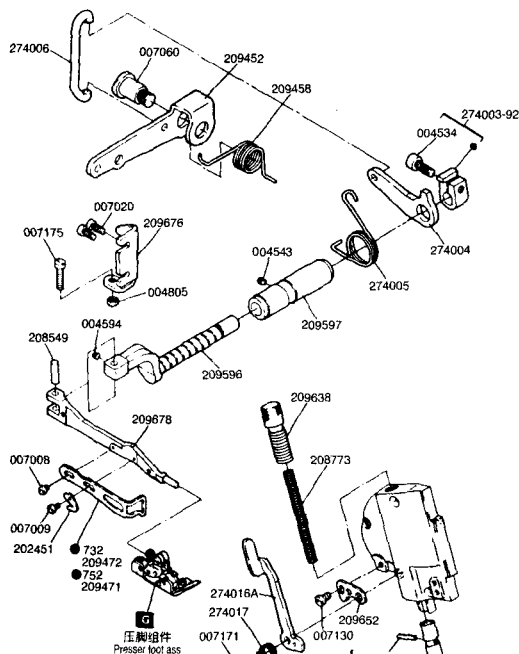


11



请参照标准零件表

Please confirm the correct part by the gauge parts lists.



12

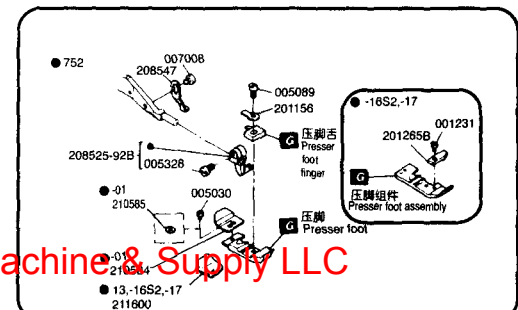
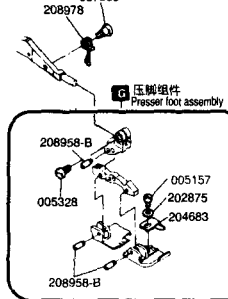
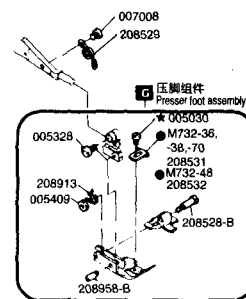


请参照标准零件表

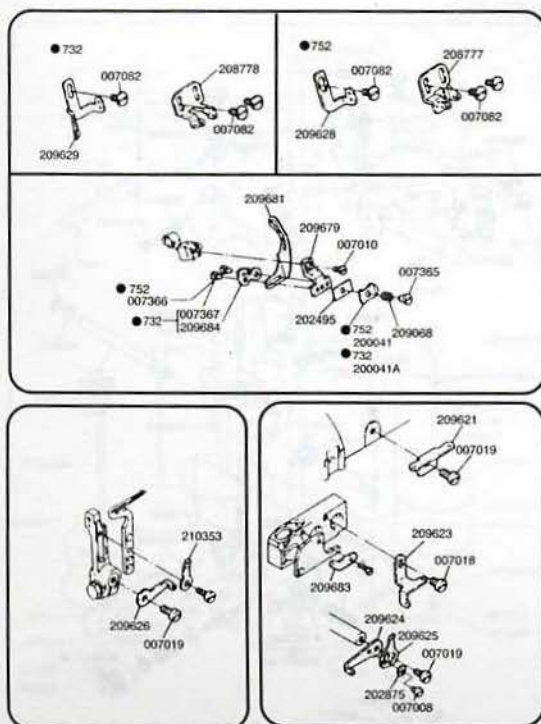
Please confirm the correct part by the gauge parts lists.

● 732-36, -38, -48, -70

● 732-86



17

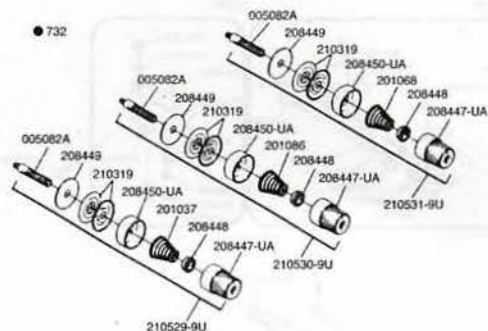


18

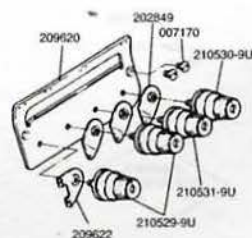
G

请参照标准零件表

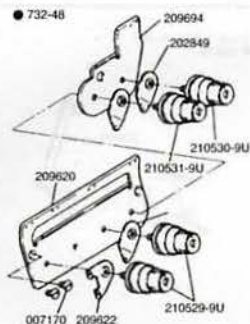
Please confirm the correct part by the gauge parts lists.



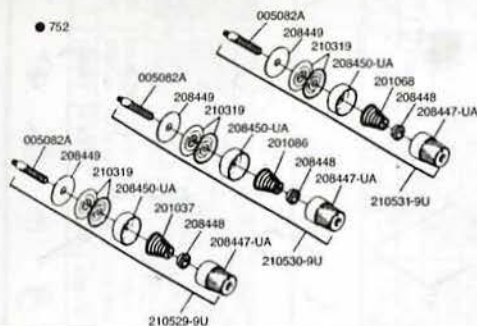
● 732-36,-38,-70,-86



● 732-48

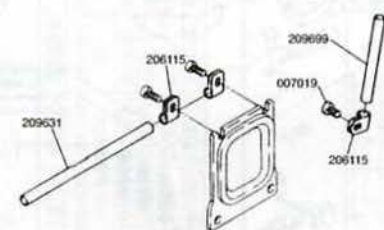


19

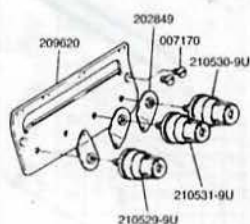


20

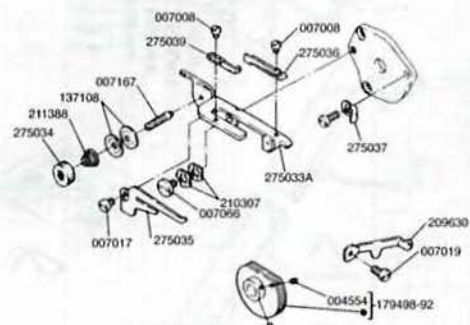
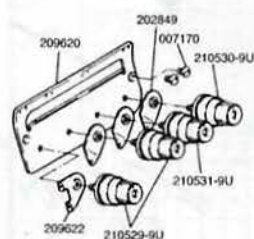
● 732



● 752-01,-1652,-17



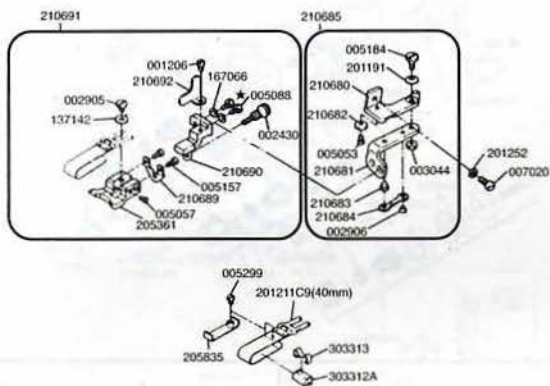
● 752-13



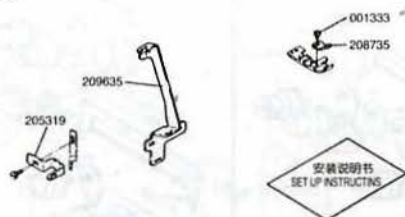
From the library of: Superior Sewing Machine & Supply LLC

21

卷边 (Bind hemming)
● 752-01

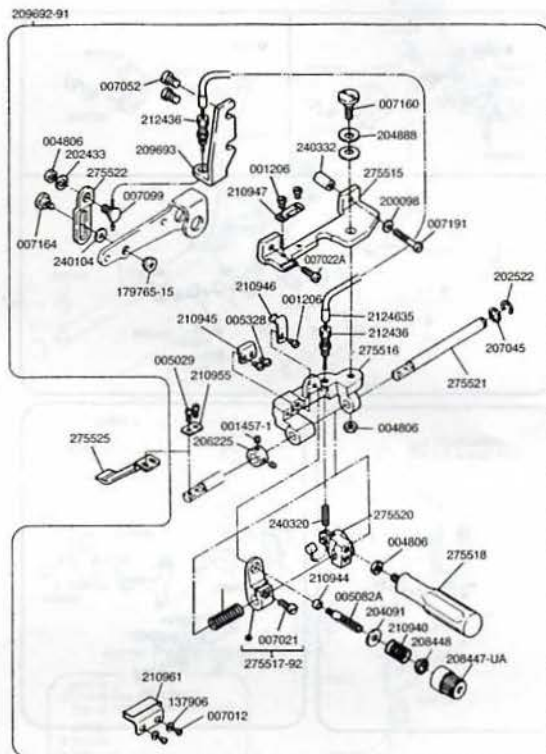


卷边附件 (Attaching tape)
● 752-13

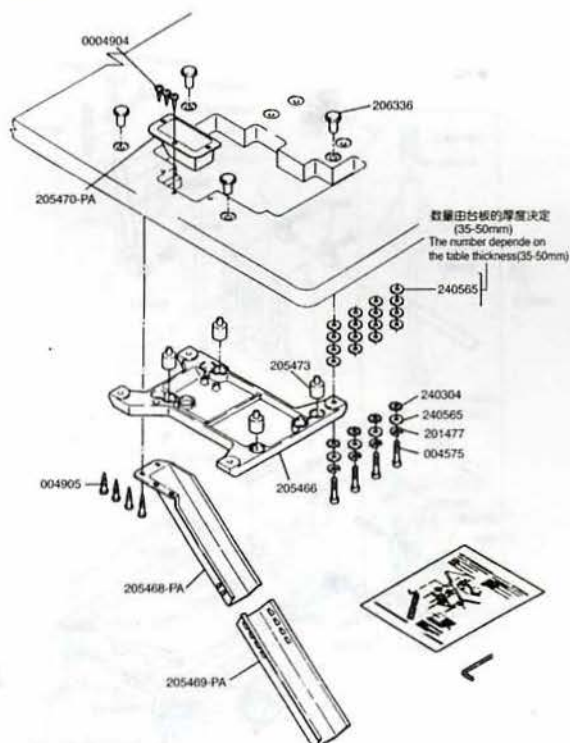


22

抽褶 (Shirring)
● 732-48



23

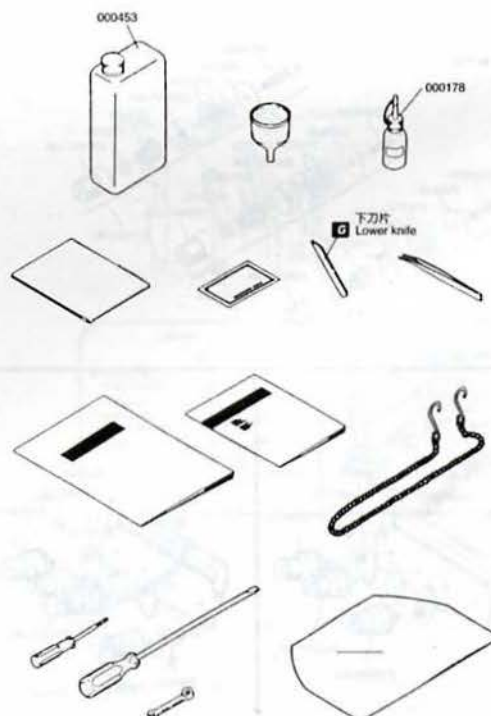


24

G

请参照标准零件表

Please confirm the correct part by the gauge parts lists.



732 标准零件表

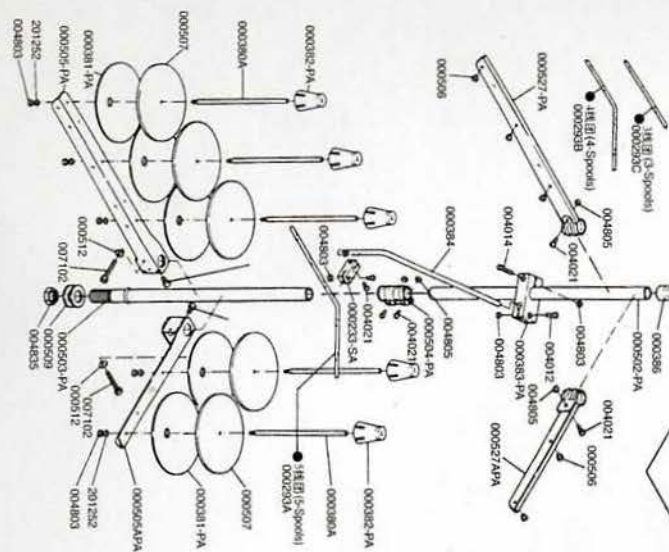
732 GAUGE PARTS LIST

型 号 MACHINE TYPE /SPEC.	包边宽度 GAUGE		针 板 NEEDLE PLATE	吐 线 舌 NEEDLE FINGER PLATE	主送料牙组件 MAIN FEED DOG ASS.	主送料牙 MAIN FEED DOG	辅助送料牙 AUX. FEED DOG	差动送料牙 DIFF. FEED DOG	压脚组件 PRESSER FOOT ASS.	上弯针 UPPER LOOPER	下弯针 LOWER LOOPER	跳线弯针 CHAINSTITCH LOOPER
	NG	SW										
732-36	3	4	204367	210505	208065	(204395)	(204425)	208218	208501	204062	204072	209685
732-38	3	4	204367	210505	208066	(204396)	(208060)	208219	208501	204702	204072	209685
732-48	3	4	204940	210505	208074	(204931)	(208061)	204420	208508	204702	204072	209685
732-70	5	5	204360A	210506	208063	(204385)	(208059)	208215	208502	204702	204072	209685
732-86	5	6	204529	210509	208064	(204394)	(208059)	208217	208955	204703	204072	209685-HC

										
型 号 MACHINE TYPE /SPEC.	包边宽度 GAUGE		上刀片 UPPER KNIFE	下刀片 LOWER KNIFE	包缝针护板 OVERLOCK NEEDLE GUARD		链缝针护板 CHAINSTITCH NEEDLE GUARD		针夹 NEEDLE HOLDER	针 NEEDLE
	NG	SW			前 后 FRONT REAR		前 后 FRONT REAR			
					FRONT	REAR	FRONT	REAR		
732-36	3	4	201121A	204161	209668	209009	204536	209669	208909B92	DCX27#11
732-38	3	4	201121A	204161	209668	209009	204536	209669	208909B92	DCX27#14
732-48	3	4	201121A	204161	209668	209009	204536	209669	208909B92	DCX27#14
732-70	5	5	201121A	204161	209668	209009	204042	209669A	208910B92	DCX27#14
732-86	5	6	201121A	204161	209668	209009	204042	209669A	208910B92	DCX27#21

752 标准零件表

型 号 MACHINE TYPE /SPEC.	包边宽度 GAUGE		针 板 NEEDLE PLATE	吐 线 舌 NEEDLE FINGER PLATE	主送料牙组件 MAIN FEED DOG ASS.	主送料牙 MAIN FEED DOG	辅助送料牙 AUX. FEED DOG	差动送料牙 DIFF. FEED DOG	压脚 PRESSER FOOT	压脚舌 PRESSER FOOT FINGER	上弯针 UPPER LOOPER	下弯针 LOWER LOOPER
	NG	SW										
752-01	-	4	205773	-	208090-BF	(204729ABF)	(204674)	204730-BF	201152E	201155C	204062	204072
752-13	2	4	202554E	(202791A)	208078-BF	(204675ABF)	(204674)	204676-BF	208730	208732	204949	204072
752-16S2	-	1.5	205465	-	208911	(204729A)	(208912)	204730	201230C	205525	204062	204072
752-17	-	4	202546E	-	208078-BF	(204675ABF)	(204674)	204676-BF	201230C	210371	204062	204072



732-01, 16S2, 17
1.6mm (5/16")
1.6mm (5/16")
1.6mm (5/16")
1.6mm (5/16")
1.6mm (5/16")

732
1.6mm (5/16")
1.6mm (5/16")
1.6mm (5/16")
1.6mm (5/16")

安装说明书
SEE INSTRUCTION