

INSTRUCTION MANUAL

TWIN 1F
TWIN 6HF

Double needle industrial sewing machine





CAUTION

Environmental Requirements

- ! Use the sewing machine in an area free from sources of strong electrical noise such as high-electrical noise may cause problems with correct operation.
- ! Any fluctuations in the power supply voltage should be within $\pm 10\%$ of the rated voltage for the machine. Voltage fluctuations which are greater than this may cause problems with correct operation.
- ! The power supply capacity should be greater than the requirements for the sewing machine's electrical consumption. Insufficient power supply capacity may cause problems with correct operation.
- ! The pneumatic delivery capability should be greater than the requirements for the sewing machine's total air consumption. Insufficient pneumatic delivery capability may cause problems with correct operation.
- ! The ambient should be within the range of 5°C to 35°C during use. Temperatures which are lower or higher than this may cause problems with correct operation.
- ! The relative humidity should be within the range of 45% to 85% during use, and no dew formation should occur in any devices. Excessively dry or humid environments and dew formation may cause problems with correct operation.
- ! Avoid exposure to direct sunlight during use. Exposure to direct sunlight may cause problems with correct operation.
- ! In the event of an electrical storm, turn off the power and disconnect the power cord from the wall outlet. Lightning may cause problems with correct operation.

Sewing

- ! Be sure to wear protective goggles when using the machine. If goggles are not worn, there is the danger that if a needle breaks, parts of the broken needle may enter your eyes and injury may result.

Thank you very much for buying a sewing machine. Before using your new machine please read the safety instructions and the explanations given in the instruction manual.

With industrial sewing machines it is normal to carry out work while positioned directly in front of moving parts such as the needle and thread take-up lever and consequently there is always a danger of injury that can be caused by these parts. Follow the instructions from training personal and instructors regarding safe and correct operation before operating the machine so that you will know how to use it correctly.

SAFETY INSTRUCTIONS

Safety indications and their meanings

This instruction manual and the indications and symbols that are used on the machine itself are provided in order to ensure safe operation of this machine and to prevent accidents and injury to yourself or other people. The meanings of these indications and symbols are given below.

	CAUTION	The instructions which follow this term indicate situations where failure
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This symbol indicates something that you should be careful of. The picture inside the triangle indicated the nature of the caution that must be taken.



This symbol indicated something that you must not do.



This symbol indicated something that you must do. The picture inside the circle indicated the nature of the thing that must be done (e.g. symbol at the left means you must make the ground connection).

 CAUTION	
Installation	
 Machine installation should only be carried out by a qualified technician.  Contact your dealer or a qualified electrician for any electrical work that may need to be done.  The sewing machine weighs more than 65 kg. The installation should be carried out by two or more people.  Do not connect the power cord until installation is complete. Otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury.  Be sure to connect the ground. If the ground connection is not secure, you run the risk of receiving a serious electric shock.	 All cords should be secured at least 25 mm away from any moving parts.  Furthermore do not excessively bend the cords or secure too firmly with staples, otherwise shocks could occur.  Be sure to wear protective goggles and gloves when handling the lubricating oil, so that no oil gets into your eyes or onto your skin, otherwise inflammation can result. Furthermore do not drink the oil under any circumstances as it can cause vomiting and diarrhea. Keep the oil out of the reach of children.

Sewing	
 The sewing machine should only be used by operators who have received the necessary training in safe use beforehand.  The sewing machine should not be used for any applications other than sewing.  Turn off the power switch at the following. The motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work. - When threading the needle - When replacing the needle and bobbin - When not using the machine and when leaving the machine unattended.	 Attach all safety devices before using the sewing machine. If the machine is used without these devices attached, injury may result.  Do not touch any of the moving parts or press any objects against the machine while sewing as this may result in personal injury or damage of the machine.  In an error occurs in machine or if abnormal noises or smells are noticed immediately turn off the power switch. Then contact your nearest sealer or a qualified technician.  If the machine develops a problem contact your nearest dealer or qualified technician.
Cleaning	
 Turn off the power switch before carrying out cleaning. The motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work. The machine may operate if the treadle is pressed by mistake	 Be sure to wear protective goggles and gloves when handling the lubricating oil so that no oil gets into your eyes or onto your skin. Otherwise inflammation can result. Furthermore do not drink oil under any circumstances as it can cause vomiting and diarrhea. Keep the oil of the reach of children.
Maintenance and inspection	
 Maintenance and inspection of machine should only be carried out by a qualified technician.  Ask your dealer or a qualified electrician to carry any maintenance and inspection o electrical system.  Turn off the power switch and disconnect the power cord from the wall outlet at the following times. Otherwise the machine may operate if the treadle is pressed by mistake. The motor will keep turning after the power is switched off as a result of motor's inertia. Wait until motor stops fully before starting work.	 When checking the rotary hook lubrication do not touch moving parts such as the rotary hook, needle and needle bar with your finger or paper. Otherwise injury or damage of machine may result.  In any safety devices have been removed be absolutely sure to re-install them to their original positions and check if they operate correctly.  Any problems in machine operation which result from unauthorized modifications to the machine will not be covered by the warranty.

Warning labels

The following warning labels appear on the sewing machine. Please follow the instructions on the labels at all when using the machine.

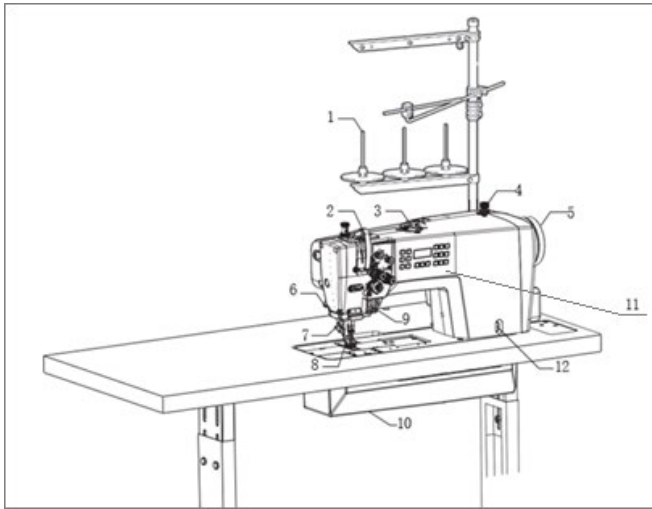
	Moving parts may cause injury. Operate with safety devices. Turn off main switch before threading, changing bobbin and needle, cleaning etc.
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Be sure to connect the ground. If the ground connection is not secure you run the risk of receiving a serious electric shock.

Direction of operation.

1. Components



1. Thread Stand
2. Thread Take-Up Lever Guard
3. Bobbin Winding Device
4. Bobbin Winder Tensioner
5. Handwheel
6. Presser Foot Lifter Wrench
7. Thread Sweeping Device
8. Presser Foot
9. Multi-Function Button
10. Oil Pan
11. Control Panel
12. Oil Level Window

2. Sewing Machine Specifications

2-1. TEXI TWIN 1F / 6HF Model Numbering Rules:

Model type:	1	Only needle positioning function
	6	Full auto
Rotary Hook Size:	—	Standard (21mm) Rotary Hook
	H	Large (28mm) Rotary Hook
Stitching Type:	—	Standard 5mm stitch
	H	Long 7mm with + corner and decorative stitch

F – series type

2-2. Machine Specifications

Model	Max Speed (RPM)	Max Stitch Length (mm)	Presser Foot Height (mm) Manual	Presser Foot Height (mm) Auto	Feed Dog Height (mm)	Needle Type
1F	3000	5	6	12	1	DP×5 (11–18)
6HF	3000	7	6	12	1	DP×5 (14–22)

3. INSTALLATION



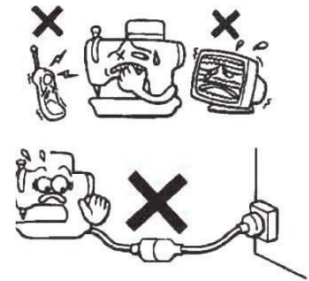
CAUTION

- | | |
|--|--|
| <ul style="list-style-type: none"> ⊘ Machine installation should only be carried out by a qualified technician. ! Contact your dealer or a qualified electrician for any electrical work that may need to be done. ! Installation for sewing machine should be carried out by two or more people. | <ul style="list-style-type: none"> ⊘ Do not connect the power cord until installation is complete. The machine may operate if the treadle is pressed by mistake, which could result in injury. ⚠ Use both hands to hold the machine head when tilting it back or returning it to its original position.
If only one hand is used, the weight of the machine head may cause your hand to slip and your hand may get caught. |
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About the machine set up location

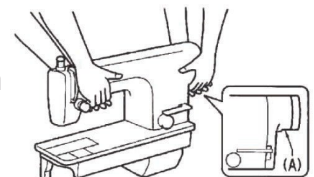
Do not set up this sewing machine near other equipment such as televisions, radios or cordless telephones. Otherwise such equipment may be affected by electronic interference from the sewing machine.

The sewing machine should be plugged directly into an AC wall outlet. Operation problems may result if extension cords are used.



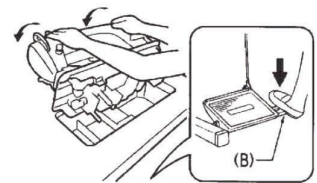
Carrying the machine

The machine should be carried by the arm by two people as shown in the illustration. Hold the motor cover (A) by hand also so that the pulley does not rotate.



Tilting back the machine head

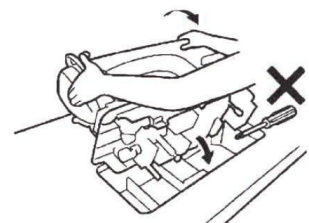
Hold section (B) with your foot so that the table does not move and then push the arm with both hands to tilt back the machine head.



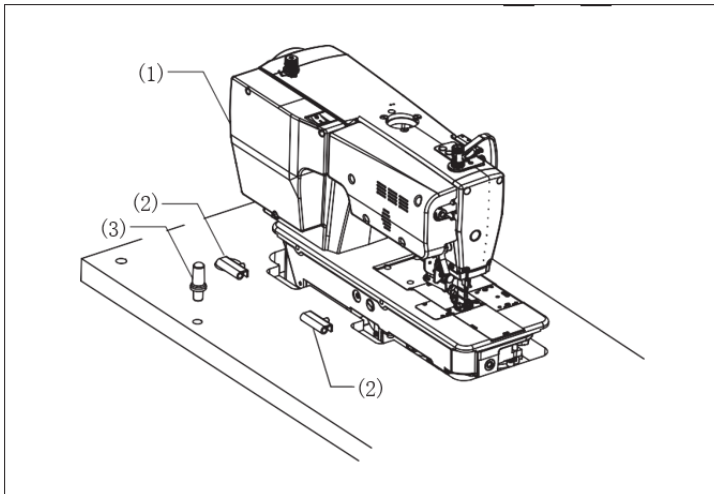
Returning the machine head to the upright position

Clear away any tools etc. Which may be bear the table holes.

While holding the face plate with your left hand, gently return the machine head to the upright position with your right hand,

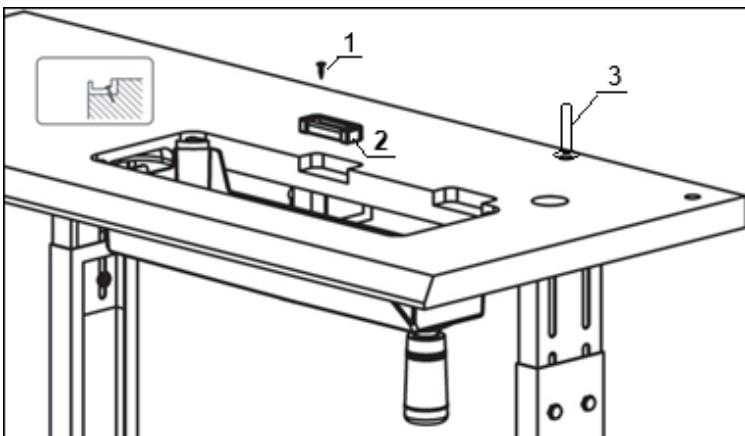


3-1. Machine Head Assembly Components



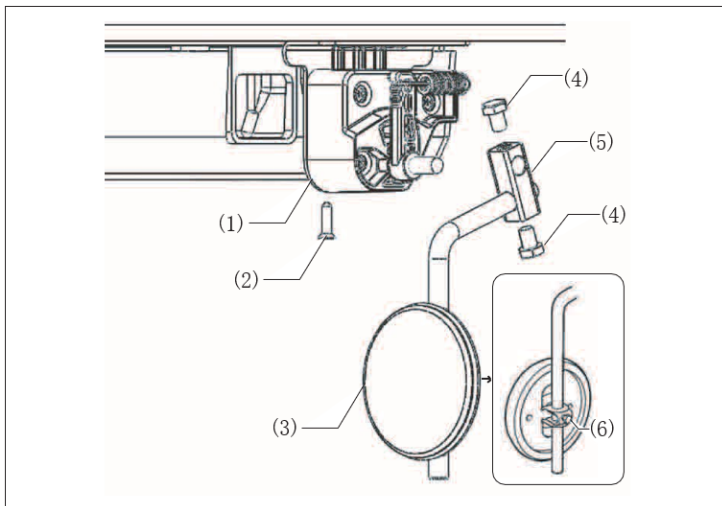
1. Sewing Machine Head [1 pc]
2. Machine Body Hinges [2 pcs]
3. Head Support Rod [1 pc]

3-2. Hinges and Mounts



1. Nails [4 pcs]
2. Hinge Sleeves [2 pcs]
3. Head Support Rod [1 pc]

3-3. Knee Lifter Assembly



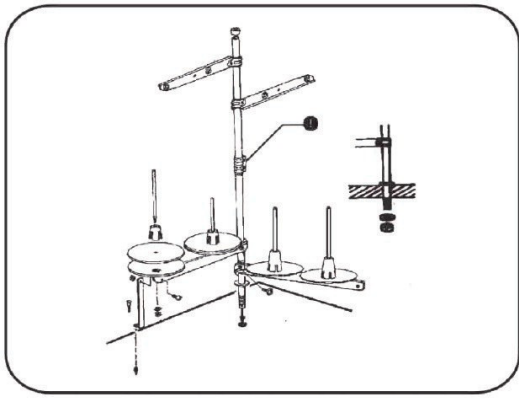
1. Electronic Foot Pedal [1 pc]
2. Screws [4 pcs]
3. Knee Lifter Block [1 pc]
4. Bolts [2 pcs]
5. Block Connector [1 pc]
6. Bolt [1 pc]

Loosen bolts [4] and [6], then move the knee lifter block [3] to the desired operating position.

NOTE: Tap the pillow securely into the table hole. If the pillow is not pushed in as far as it will go the machine head will not be sufficiently stable when it is tilted back.

Remarks: Support pin must be installed reliably, otherwise there is danger when the machine is turned over.

3-4. Installing the thread stand



Assemble the cotton stand (1) while referring to the cotton stand instruction manual and then install the cotton stand to the far right corner of the work table

4. Lubrication



Do not plug in the power before lubrication is complete.

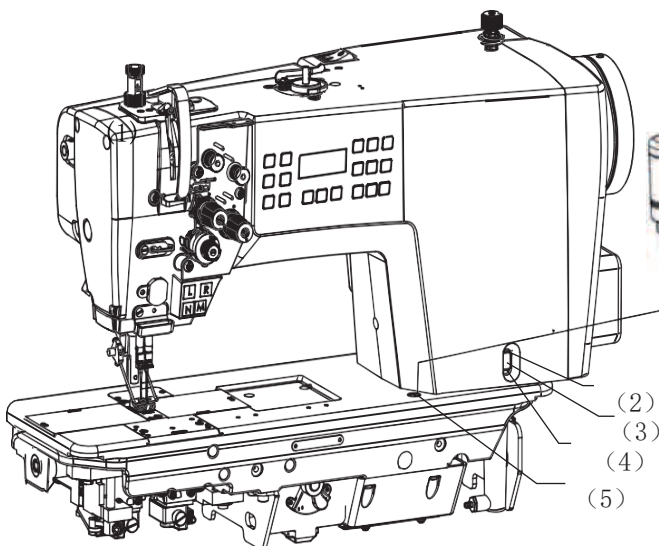
If the start switch is pressed accidentally, the machine may operate and cause personal injury. When using lubricating oil or grease, **always wear protective equipment** such as safety goggles and gloves to prevent the oil from **getting into the eyes or onto the skin**, which may cause inflammation.

Lubricating oil or grease must not be ingested, as it may cause **vomiting or diarrhea**. Keep oil **out of the reach of children**.

It is essential to **regularly lubricate the sewing machine**.

Before the first use or after a long period of inactivity, **replenish the lubricating oil**.

4-1. Filling the Oil Reservoir:



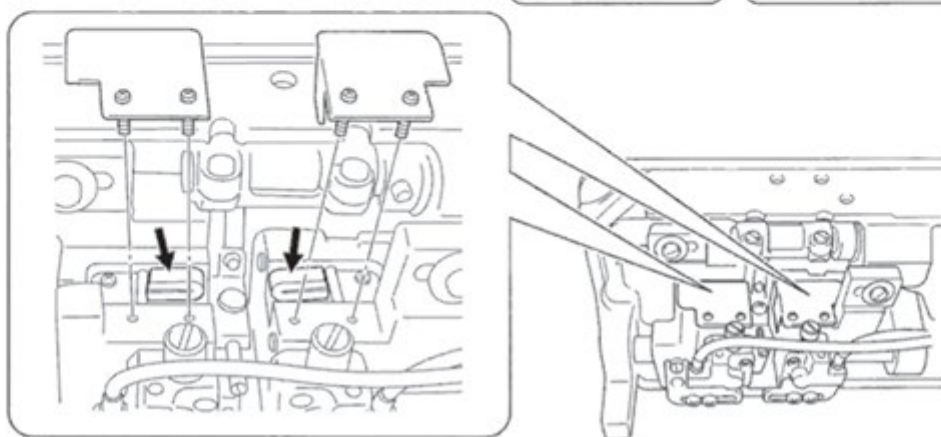
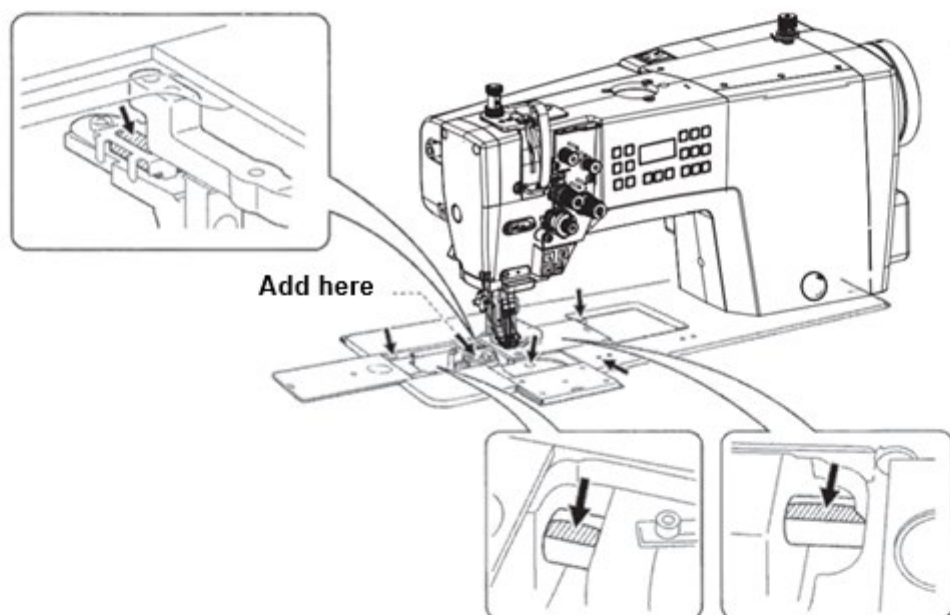
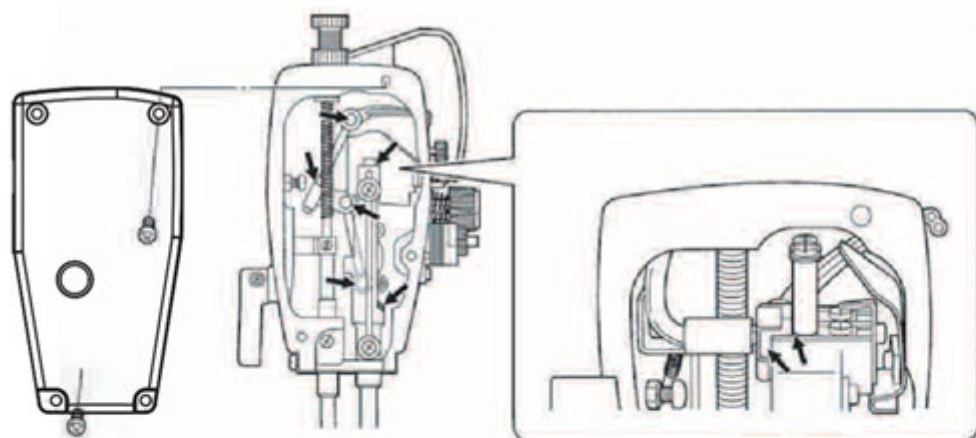
1) Remove the rubber stopper [5], then insert [1] into the oil filling port on the machine housing.

2) Insert part [1] into the **oil filling port** of the machine housing.

3) Pour lubricating oil until it reaches the **top marking** on the oil window [3].

4) Stop filling when it reaches mark [2]. **When the oil level drops to the bottom marking [4] on the oil window [3], be sure to refill the oil immediately.**

Apply 1–2 drops of lubricating oil at each arrow mark.

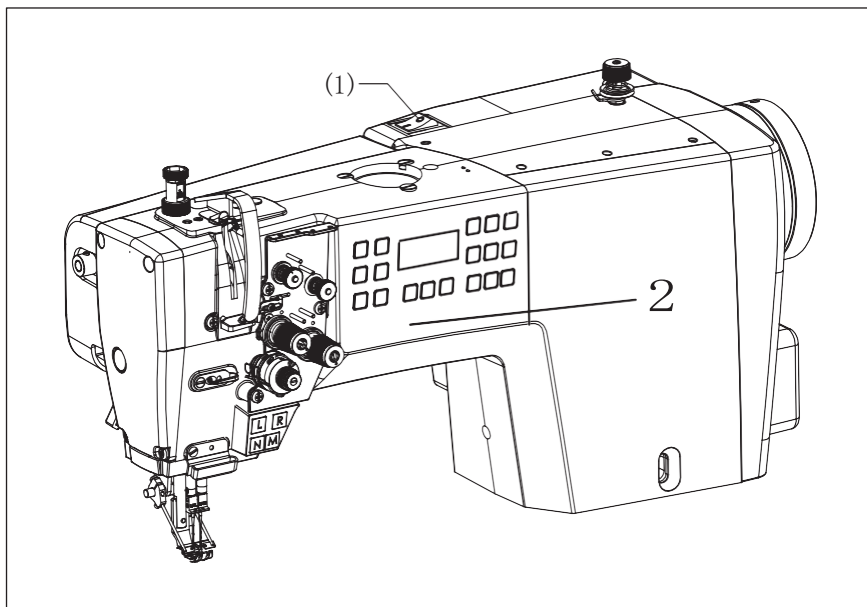


5. Operation Test

Warning

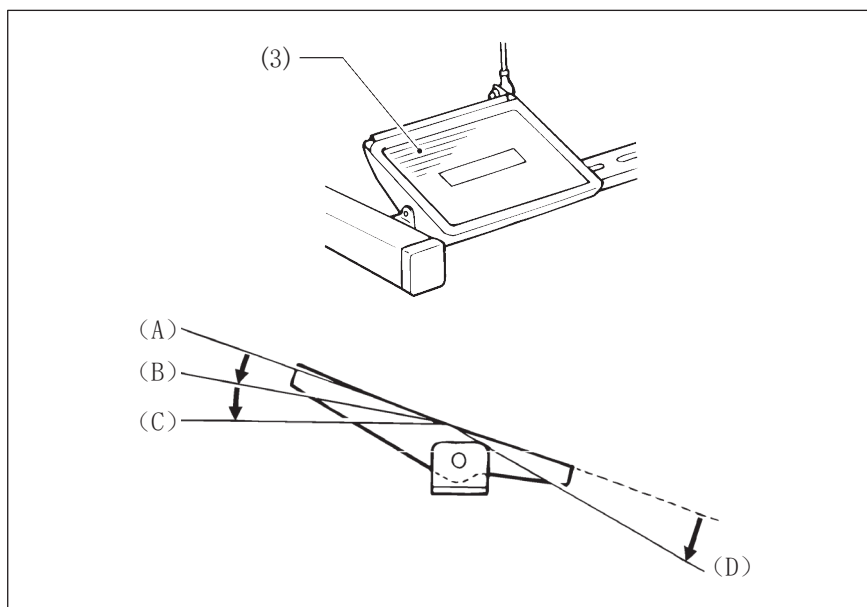
 **Do not touch any moving parts or place objects near them during sewing, as this may cause personal injury or damage to the sewing machine.**

5-1. Power On



1. Press the power switch [1] to turn on the machine.
2. The display screen [2] will light up.
3. Rotate the handwheel — ensure there is no resistance or blockage.

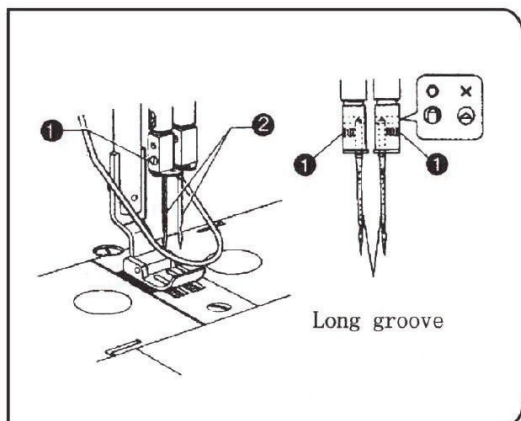
5-2. Operation Test Procedure



1. Gently press the foot pedal [3] to position [B]:
→ Confirm that the sewing machine runs at low speed.
2. Press the foot pedal further to position [C]:
→ The machine should operate at high speed.
3. Press the foot pedal forward [3], then release it to neutral position [A]:
→ Check whether the needle lowers to the needle plate (this applies when the machine is set to stop with the needle down).
4. Press the foot pedal to position [D]:
→ The needle should rise above the needle plate and stop.

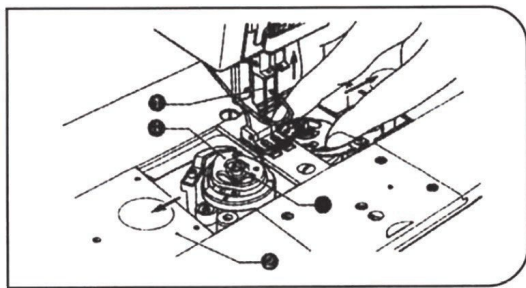
6. PREPARATION BEFORE SEWING

6-1. Installing the needle



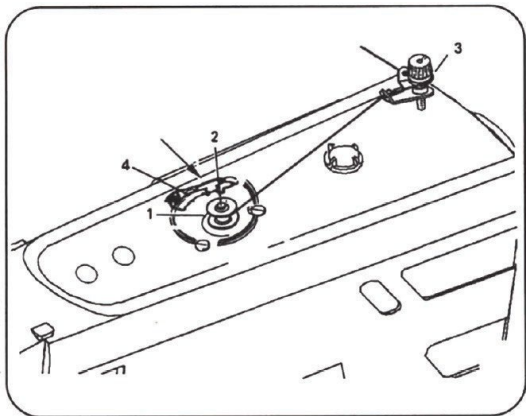
1. Turn the machine pulley to move the needle bar to its highest position.
2. Loosen the screws (1), hold the needles (2) with their long groove facing inward, insert all the way into the needle bars and re-tighten the screws (1).

6-2. Removing the bobbin or cap



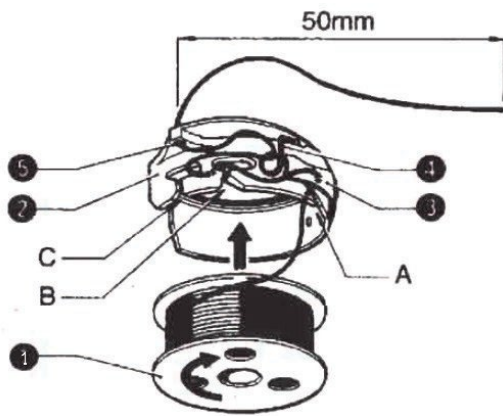
1. Raise the needle (1) to the highest positions and open the side plates (2) by moving them to the right and left.
2. After lifting up the rotary hook latch (3) tilt the corner of the cap (4) to remove the cap (4).

6-3. Winding the lower thread



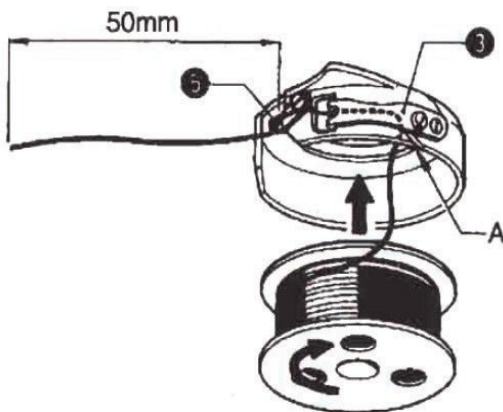
1. Place the empty bobbin (1) on the bobbin winder spindle (2).
2. Thread the thread and wind it round bobbin (1) a few in clockwise direction.
3. Set the preliminary thread tension by turning milled screw (3).
4. Press lever (4) in the direction of the arrow until it clicks into place.

6-4. Installing the bobbin



- Insert the bobbin (1) into the cap (2) so that the winding direction is as shown in the illustration.

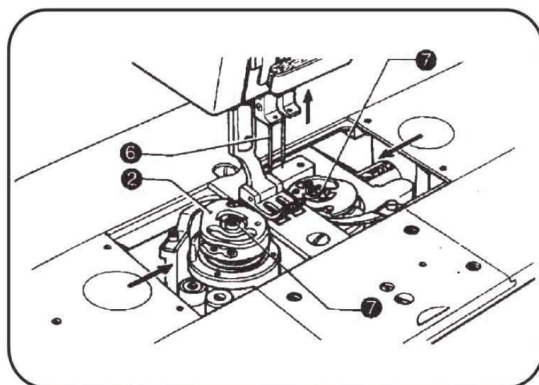
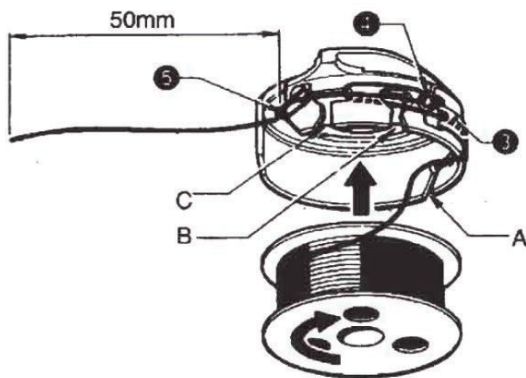
- Thread the thread by one of the following methods in accordance with the shape of the cap being used.



- Pass the thread through slot (A) and under the tension spring (3).

- Pass the thread through slot (B) and (C) and then through the thread loosening prevention spring.

- Pass the thread through the hole (5) and pull out about 50 mm.

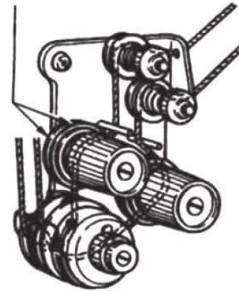
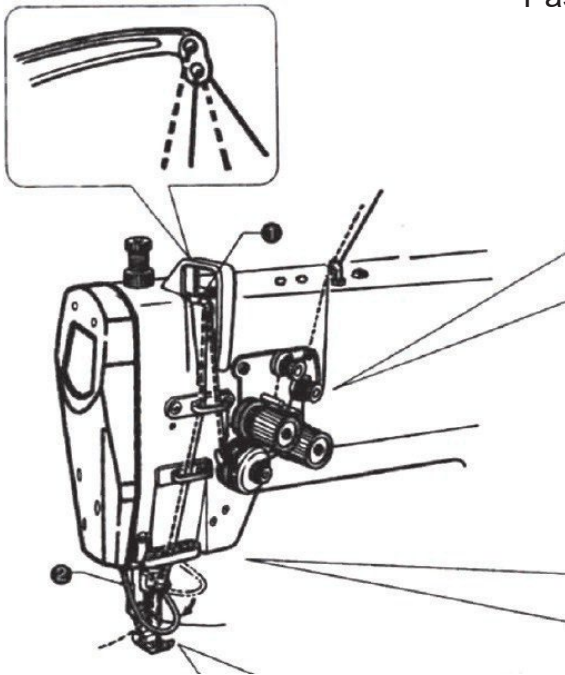


- Turn the machine pulley to raise the needle to its highest position.
- Insert the cap (2) into the rotary hook
- Push latch (7) to the rotary hook flat.
- Close the bed slide.

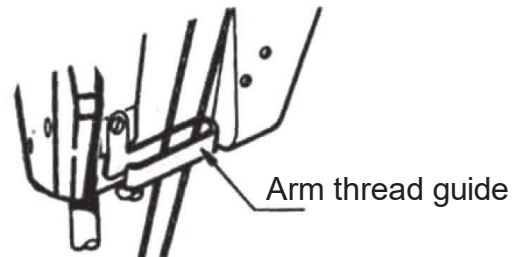
6-5. Threading the upper thread

1. Turn the machine pulley and raise the thread take-up lever before threading the upper thread. This will make threading easier and it will prevent the thread from coming out at the sewing start.
2. Thread the left side thread first.
3. The position of the finger guard is adjustable. Be sure to lower it once threading has been completed.

Pass the thread correctly between the tension discs.



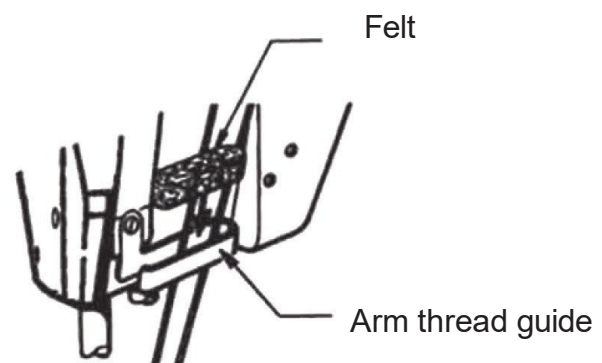
Cotton thread



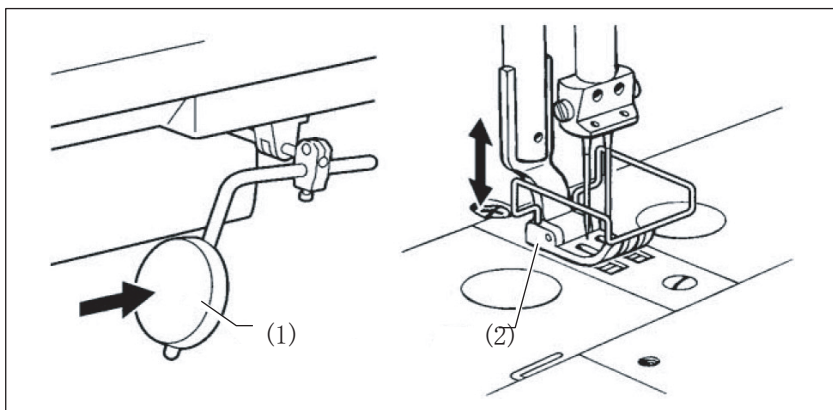
Pass the thread through the needle eyes from inside to outside. Pull out about 50 mm of the thread through each of the needle

If synthetic thread is used, use the felt in the arm thread guide.

Synthetic thread



6-6. Knee Lifter Block Usage



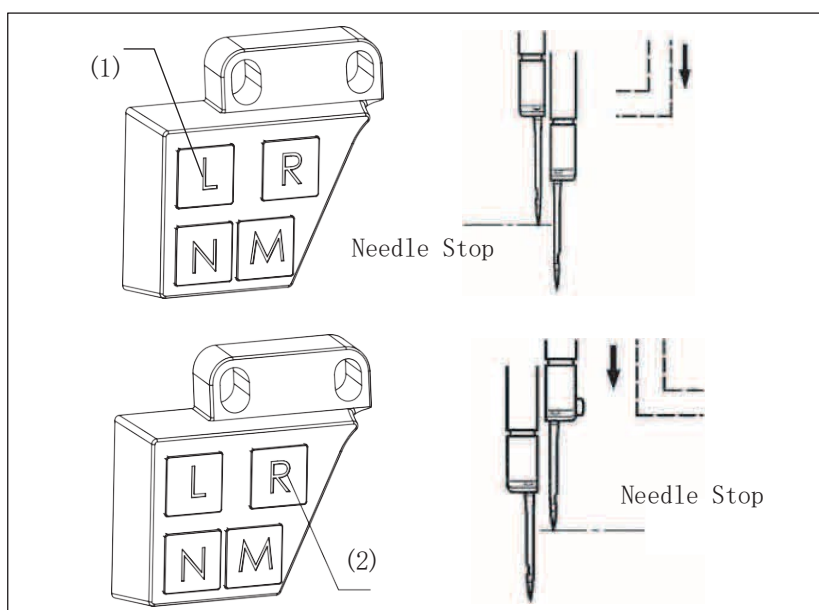
- Press the knee lifter block [1] to automatically raise the presser foot [2].
- The more you press to the right, the higher the presser foot lifts.

6-7. Corner Sewing Method

Note: When using this machine as a single-needle machine, be sure to remove the unused needle before sewing.

Do not use the following needle stop method if the unused needle is not removed, otherwise it may damage the machine.

6-7-1. Needle Bar Stop Method (Left / Right)



Make sure the needle is in the down position before pressing the button.

To stop the left needle bar:
Press button L [1]

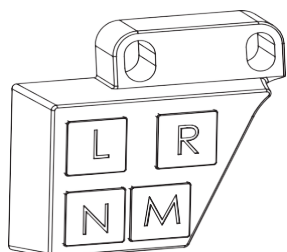
To stop the right needle bar:
Press button R [2]

To restore double-needle sewing:

Press the corresponding button L [1] or R [2] again.

6-7-2. Corner Sewing Method

Sewing Procedure:

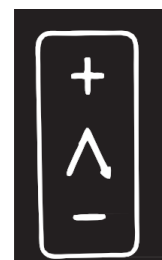


- Set the desired turning angle.
- Start the machine.

When it reaches the turning point, press the corresponding angle key (L or R).

The machine will sew a specified number of stitches, automatically stop, the presser foot will lift, and the fabric will rotate to the set angle.

- Start the machine again to complete the angular sewing operation.

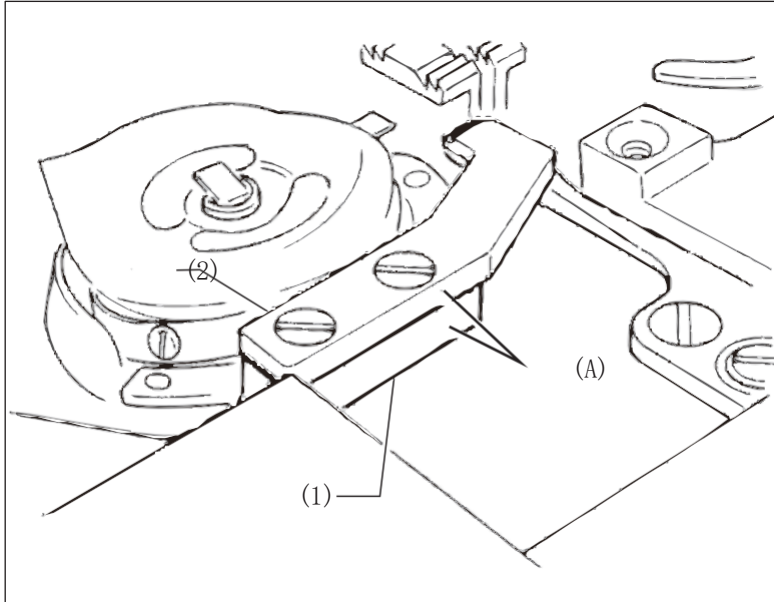


Note: You can adjust angle of corner using “+” / “-” buttons

7. Movable Knife Position Adjustment Method

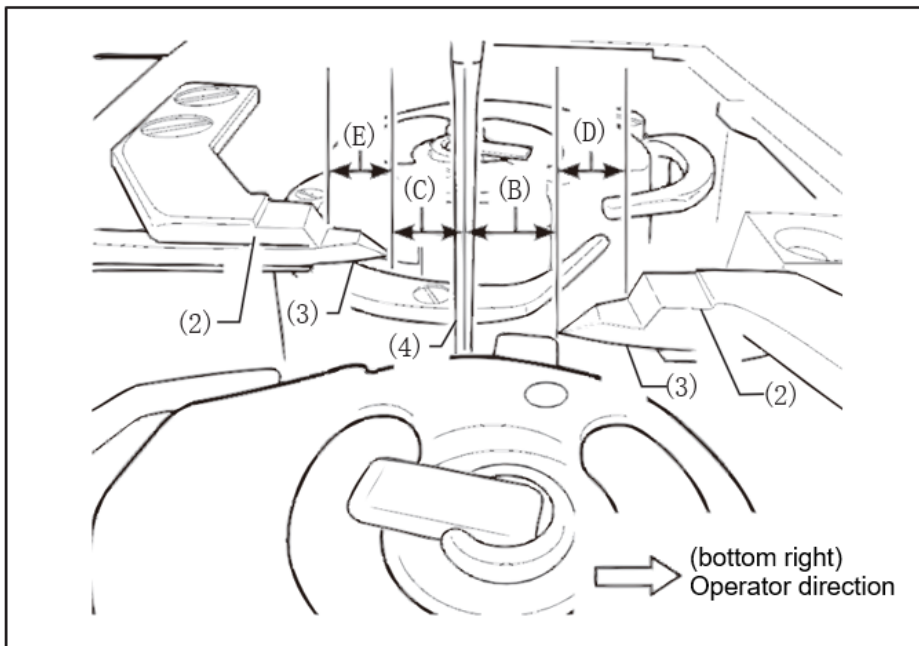
Warning

During adjustment of the movable knife, turn off the power.
Wait until the motor completely stops before operating.



1. Align the fixed knife base [1] and fixed knife [2] at surface [A].

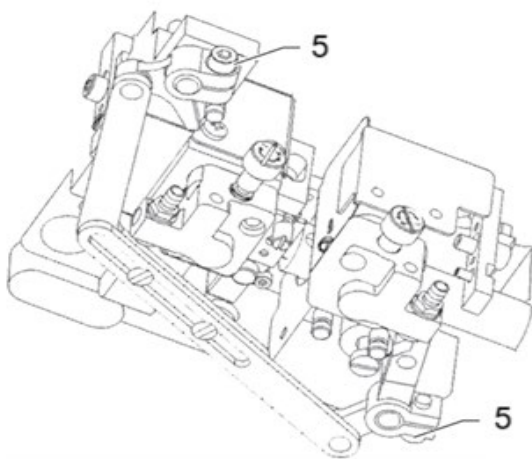
2. Loosen the movable knife crank screw [5], set stitch length to minimum, bring the needle [4] to bottom dead center, and adjust the front edge of the movable knife [3] to match the following values:



Adjustment Reference Table:

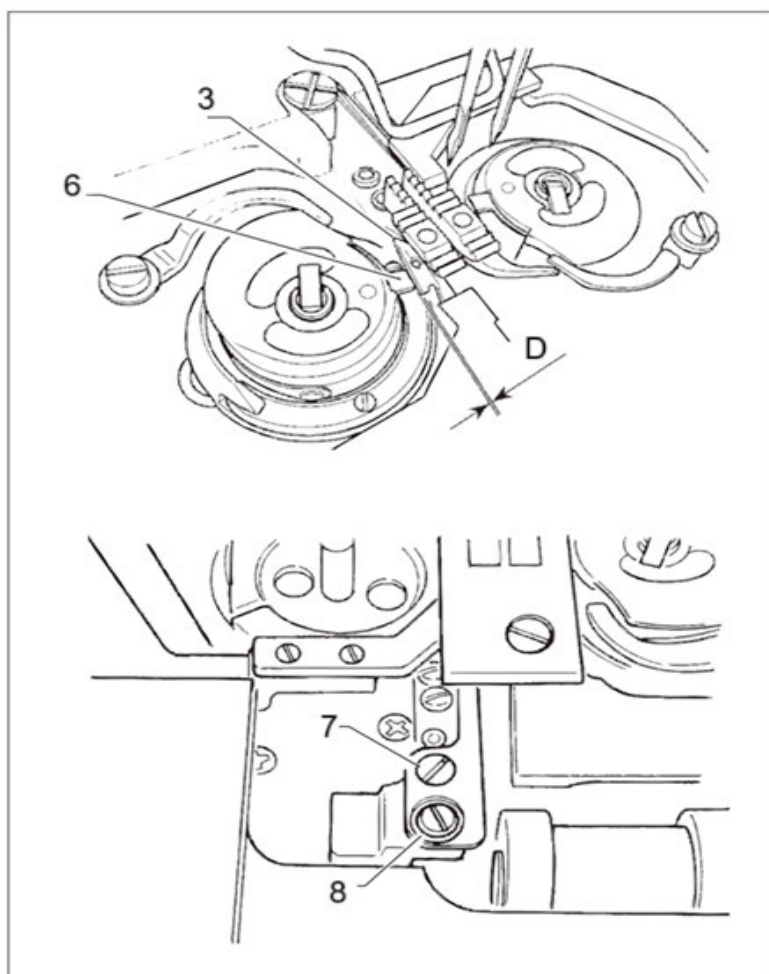
Knife Side	B Distance	D Reference	C Distance	E Reference
Standard hook	6.2 mm	(3.5 mm)	7.5 mm	(2.7 mm)
Large hook (H)	7.3 mm	(4.1 mm)	8.9 mm	(3.1 mm)

Adjust the **[B] and [C] distances** according to the specified sizes depending on the knife position and machine model.



1. Adjust the clearance [D] between the movable knife [3] (during operation) and the raised part of the center rotary hook [6] to 0.3 ± 0.1 mm.

To make this adjustment, loosen the movable knife fixing screws [7] and [8].

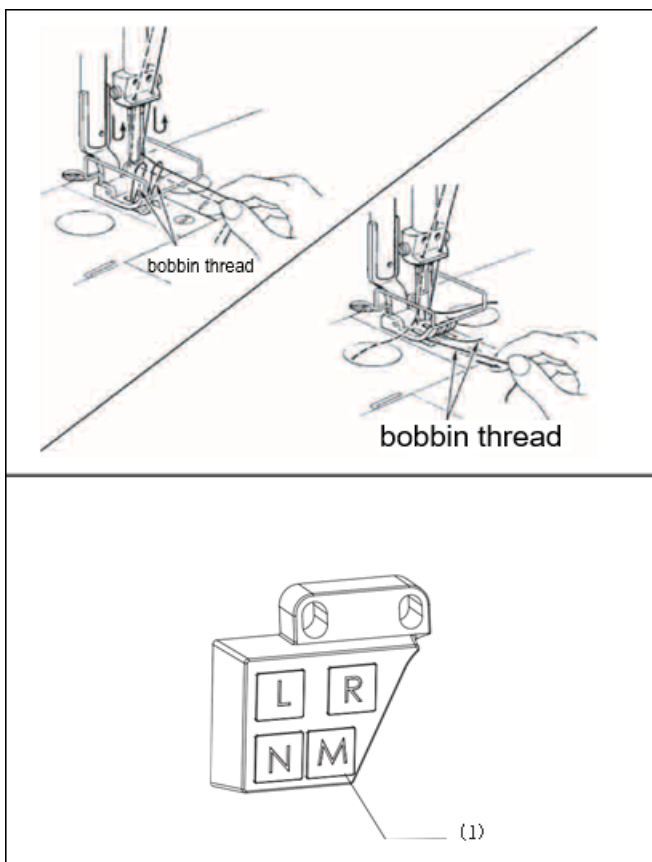


7. Sewing

WARNING

- For safety, please install protective devices before using this sewing machine.
- If you operate the machine without proper safety equipment, it may result in injury or machine damage.
- In the following situations, turn off the power.
 - Wait until the motor comes to a complete stop before operating!
- Accidental pressing of the start switch may result in injury:
- Threading the needle
 - Replacing the needle or bobbin
 - When the machine is not in use, or when leaving the machine unattended
 - During sewing, do not touch any moving parts or place any objects on them, as this can cause injury or damage to the machine.
 - When tilting the machine head, use both hands.
- Tilting with one hand may cause the machine to fall due to its weight and slipperiness, resulting in injury.

7-1. Sewing forward



1. While holding the upper thread (2 strands) with your fingers, turn the handwheel toward yourself to bring the bobbin thread up above the feed dog.
2. Pull the bobbin thread toward yourself and confirm that it feeds out smoothly.
3. Turn on the power.
4. Press the foot pedal to begin sewing.

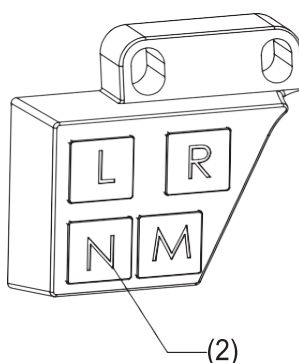
7-2. Reverse Stitch and Reinforcement Method

1. During sewing, press the reverse stitch button [1] — the fabric will be fed in reverse. Releasing the button [1] will resume forward feeding.

7-3. Dense Stitching Method

How to Adjust Supplementary Stitch Length in Settings

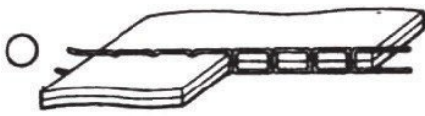
1. **Press and hold the P button** on the control panel until "0000" appears.
2. Enter the password: **2017**
3. The screen will display **P92**.
4. Press the **rightmost ± button** to scroll to item **P71**.
5. Press **S** to enter, and use the **stitch length keys** to adjust the supplementary stitch length.
6. Press **S** to confirm, then **P** to exit.



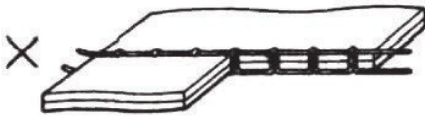
- Set the dense stitch length [1].
- During sewing, press the dense stitch button "N" [2] to sew using the set short stitch length (forward direction).

8. Adjustments

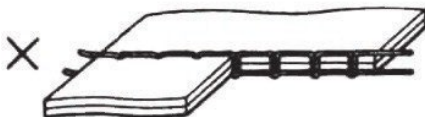
8-1. Adjusting the thread tension



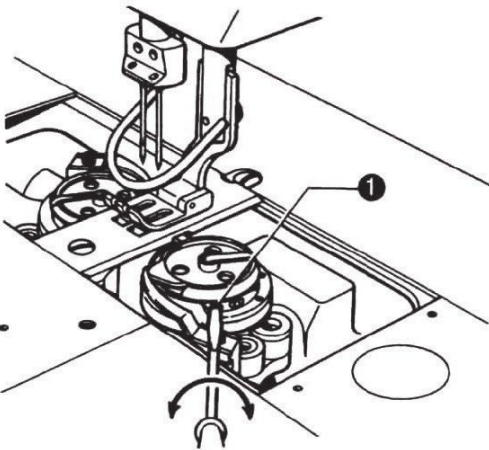
Good, even stitches



Upper thread tension is too strong or lower thread tension is too weak.



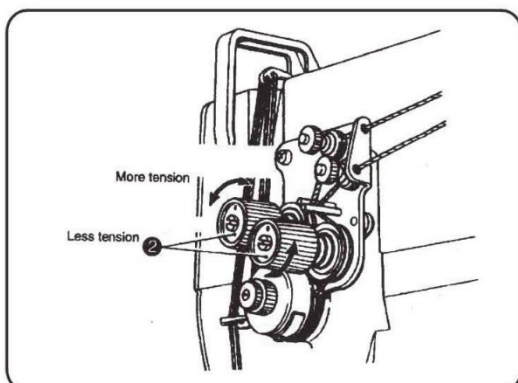
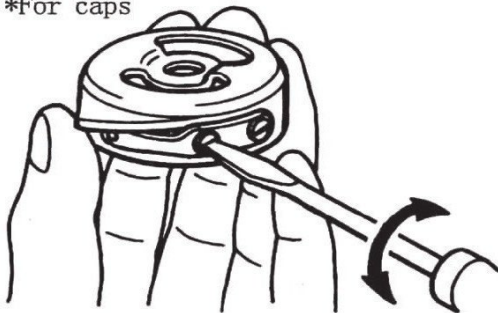
Upper thread tension is too weak or lower thread tension is too strong.



- **Lower thread tension**

The tension of the lower thread varies with the kind of cloth and thread and can be adjusted by turning the lower thread tension adjustment screw (1).

*For caps



- **Upper thread tension**

After the lower thread tension has adjusted, adjust the upper thread tension so that a good, even stitch is obtained.

1. Lower the presser foot
2. Adjust by turning the thread tension nut.



Correct stitch



Skipped stitches occur (Increase the pressure)

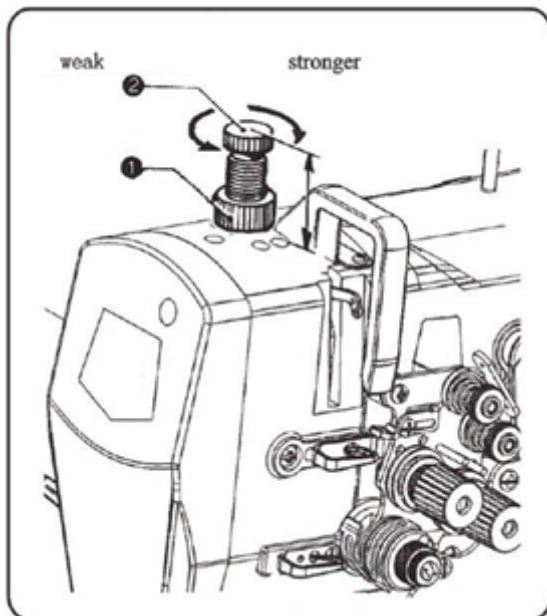


Uneven stitch length (Increase the pressure)



Stitches are puckered (Decrease the pressure)

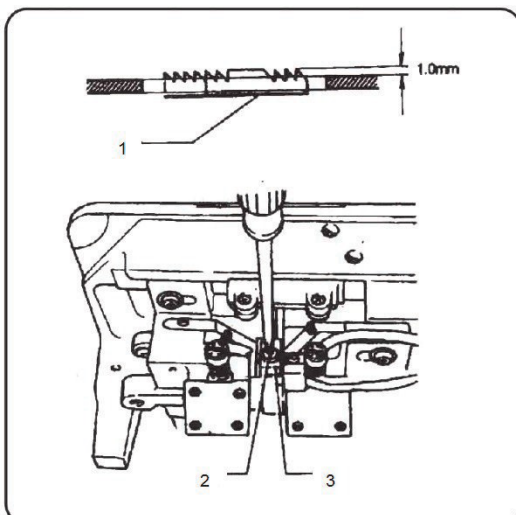
8-2. Adjust the presser foot pressure



The presser foot pressure should be as weak as possible but strong enough so that the material does not slip.

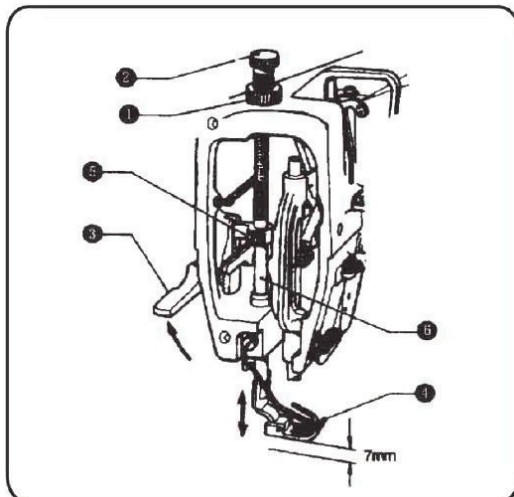
1. Loosen the adjustment nut (1).
2. Turn the adjustment screw (2) to adjust the presser foot pressure.
3. Tighten the adjustment nut (1).

8-3. Adjusting of the feed dog height



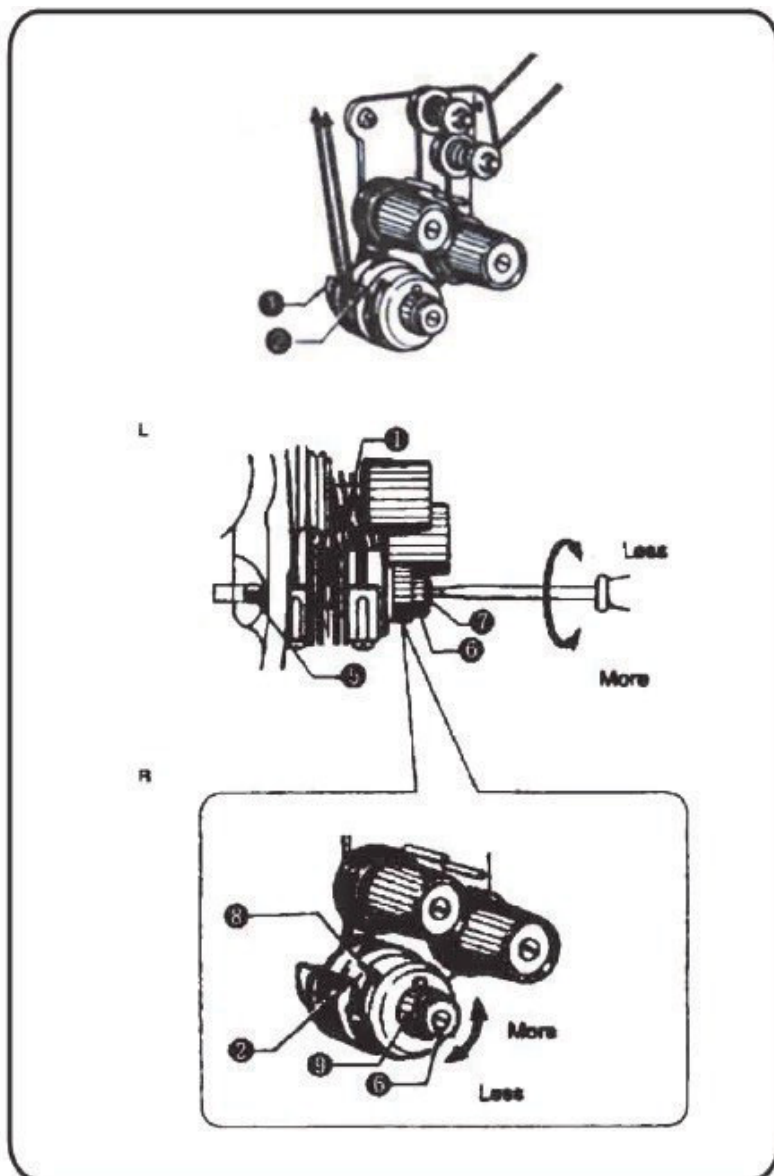
1. Turn the pulley until the feed dog (1) rises to the highest position.
2. Tilt back the machine head.
3. Loosen screw (2) and raise or lower the feed dog holder (3) so that the feed dog (1) will rise to about 1 mm above the needle plate.
4. Tighten the screw (2).

8-4. Adjusting the presser foot height



- Loosen the nut (1) and then loosen the presser foot adjustment screw (2).
- Open the face plate.
- Raise the presser foot (4) with the presser foot lifter (7).
- Loosen the screw (5) and then move the needle bar (6) up or down to adjust so that the presser foot (4) is approximately 7 mm above the top of the needle plate.
- NOTE: Be careful not to rotate the needle bar (6).
- Tighten the screw (5).
- Adjust the presser foot pressure by turning the presser foot adjustment screw (2) and tighten the nut (1).

8-5. Adjusting the thread tension spring

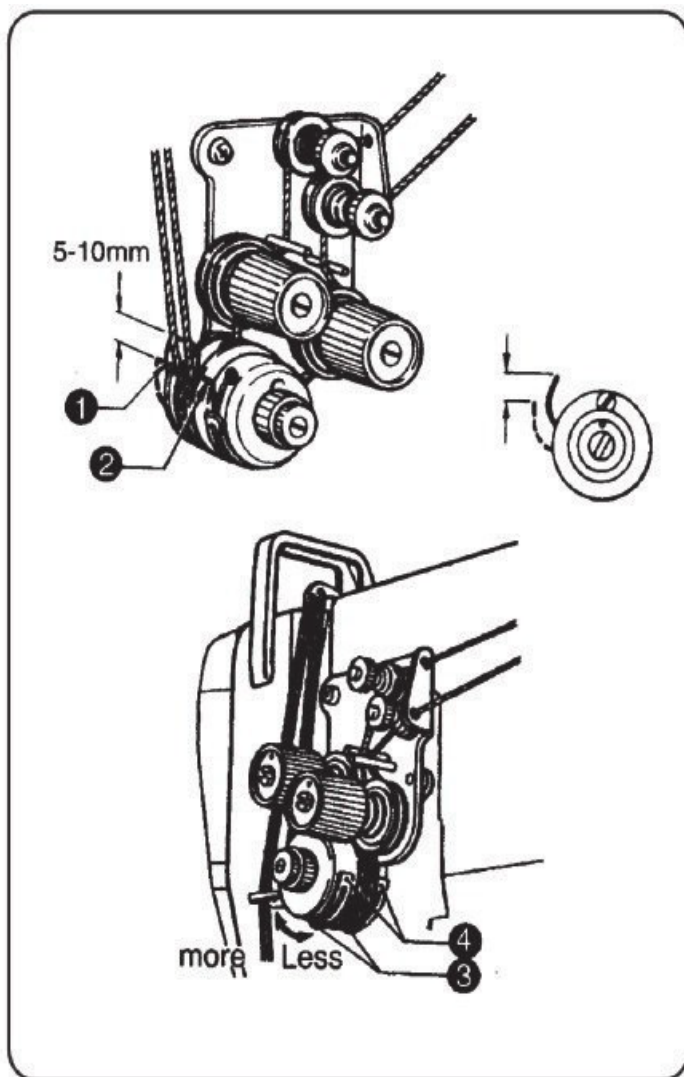


Thread take-up spring tension

1. Open the face plate.
2. Loosen the screw (5).
3. Loosen the knob and then turn the thread tension stud (7) to adjust the tension.
4. Tighten the screw (5) and then tighten the knob (6).

Thread take-up spring R (2)

1. Loosen the set screw (8).
2. Loosen the knob (6) and then turn the adjustment knob (9) to adjust the tension.
3. Tighten the screw (8) and then tighten the knob (6).

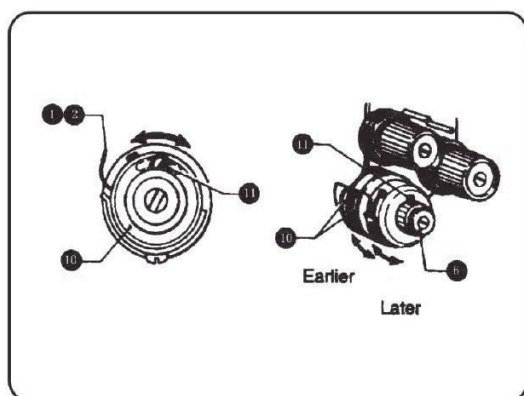


Operating range of thread take-up spring

The standard operating range for thread take-up spring L (1) and thread take-up spring R (2) is 5-10 mm for both springs.

1. Loosen the left and right screws (3) and then turn the right thread take-up spring stoppers (4) to adjust the operating spring.
2. Tighten the screw (3).

Thread take-up spring operation timing

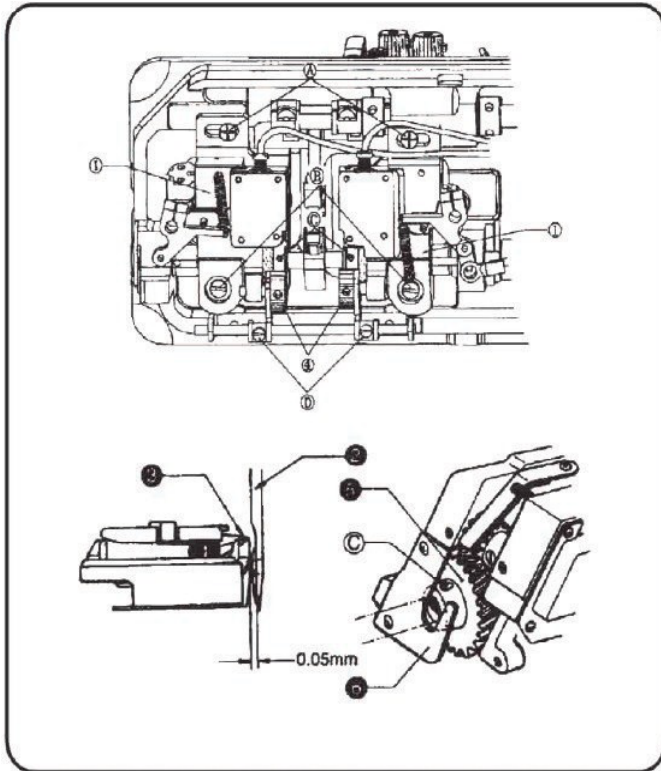


The standard operation take-up spring L (1) and thread take-up spring R (2) in the middle position within the operating range of the thread take-up spring guide (10).

1. Loosen the screw (11).
2. Loosen the knob (6) and then turn the left and right thread take-up spring guided (10) to adjust the tension.
3. Tighten the screw (11) and then tighten the knob (6).

8-6. ADJUSTING THE NEEDLE AND ROTARY HOOK TIMING

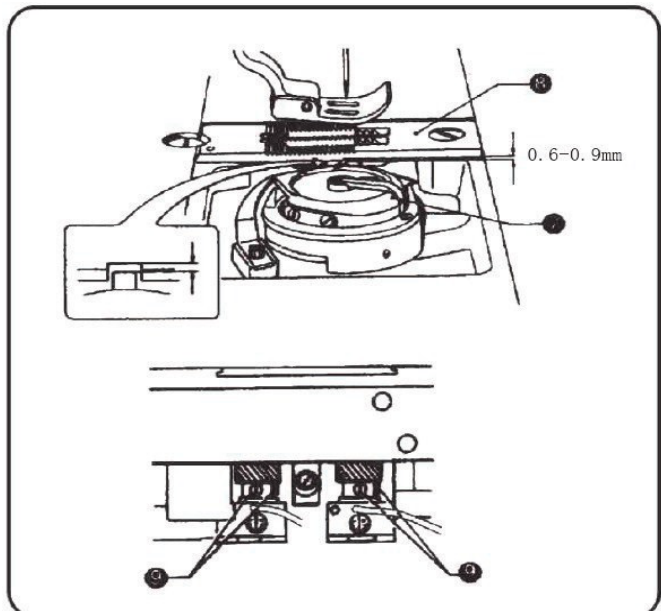
8-6-1. Needle rotary hook point gap



1. Tilt back the machine head.
2. Loosen screws (A), (B), (C) and (D).
3. Move the rotary hook base (1) to the left or right so that the clearance between the needle and rotary hook tip (3) is 1-3 mm.
4. Tighten screw (D) and then turn the adjusting screw (4) to adjust so that the clearance between the needle (2) and the rotary hook tip (7) is 0.05 mm.
5. After adjusting, securely tighten screws (A), (B) and (C).

NOTE: Tighten so that the lever shaft gear (5) is gently touching the thread guide plate (6). Furthermore tighten screw (C) without moving it from its screw stop.

8-6-1. Needle bar height and lift amount

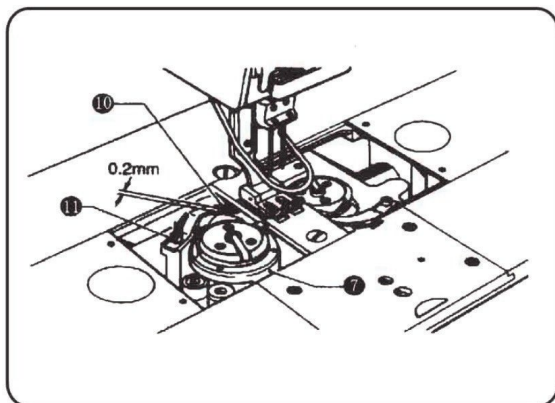


1. Remove the left and the right side plates.
2. Tilt back the machine head.
3. Tilt screw (9) and move rotary hook (7) so that the clearance between the rotary hook (7) and needle plate (8) is 1.3 mm.

NOTE: Loosen screw (9). Rotary hook will cause the position of the needle and rotary hook.

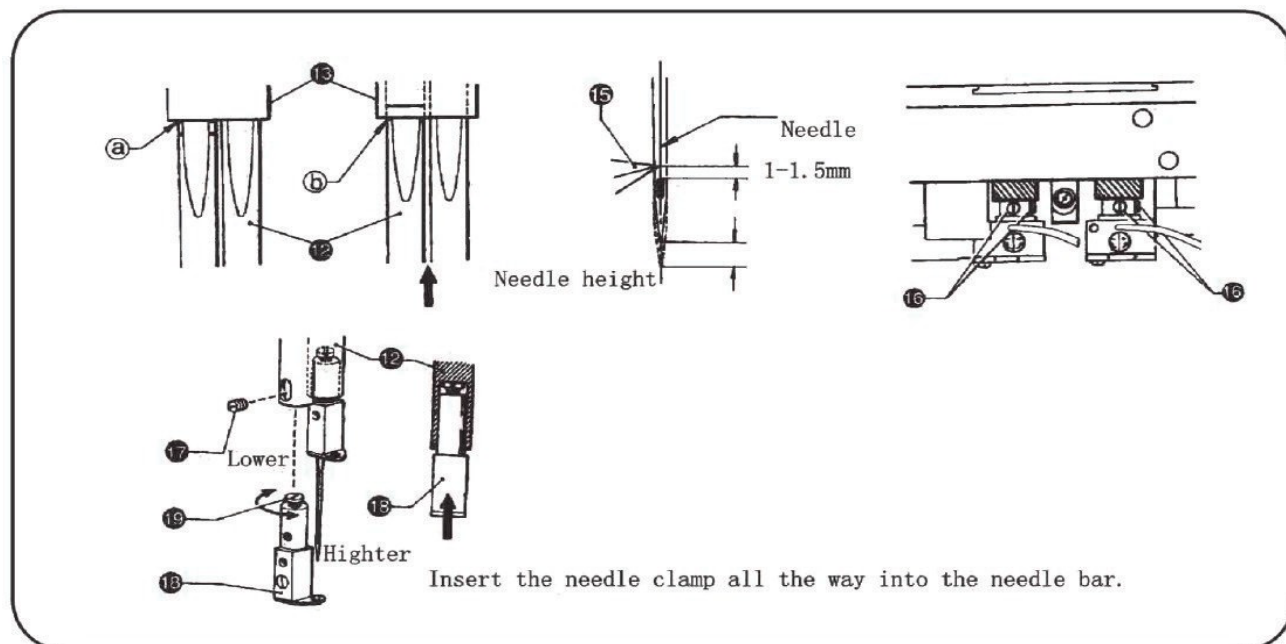
4. Tighten screw (9).

8-6-2. Clearance between rotary hook and opener



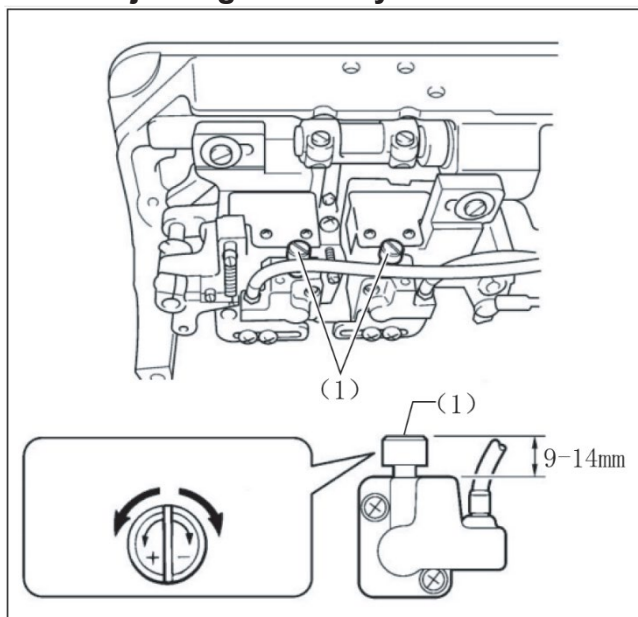
1. Loosen the set screw (11) and move the opener (11) to the left or right to adjust so that the clearance between the rotary hook (7) and the opener (10) is 0.2 mm when the opener (10) is pulled as far as it will go in the direction of the arrow.
2. Tighten the set screw (11).

8-6-3. Needle bar height and lift amount



1. Remove the needle plate.
2. Remove the feed dog
3. Set the stitch length to eighter 2 (approx. 2 mm) or 3 (approx. 3 mm) on the scale, depending on the model and specifications of the machine.
4. Turn the machine pulley to raise the needle bar (12). The reference line (b) on the needle bar (12) will be aligned with the lower edge of the needle bar supporter. The rotary hook tip (15) must be aligned with the center of the needle at this time.
5. Tilt back the machine head, loosen the three screws (16) and then align the rotary hook tip (15) with the center of the needle.
6. Tighten the screws (16).
7. The distance from the upper edge of the needle hole to the rotary hook tip (15) must be 1-1.5 mm when the rotary hook tip (15) is aligned with the center of the needle.
8. Loosen the set screw (17) to adjust so that the upper edge of the needle hole to the rotary, tip (18) is 1-1.5 mm.
9. Turn the screw (19) to adjust so that the distance from the upper edge of the needle hole to the rotary hook tip (15) is 1-1.5 mm.
10. After adjustment is completed, insert the needle bar clamp (18) into the hole of the needle bar (12) as it will go and check that the distance is 1-1.5 mm. Secure it by tightening the set screw (17).
11. Install the feed dog.
12. Install the needle plate.

8-5. Adjusting the rotary hook lubrication amount



Standard Procedure for Oil Supply Adjustment:

Tilt the sewing machine head down.

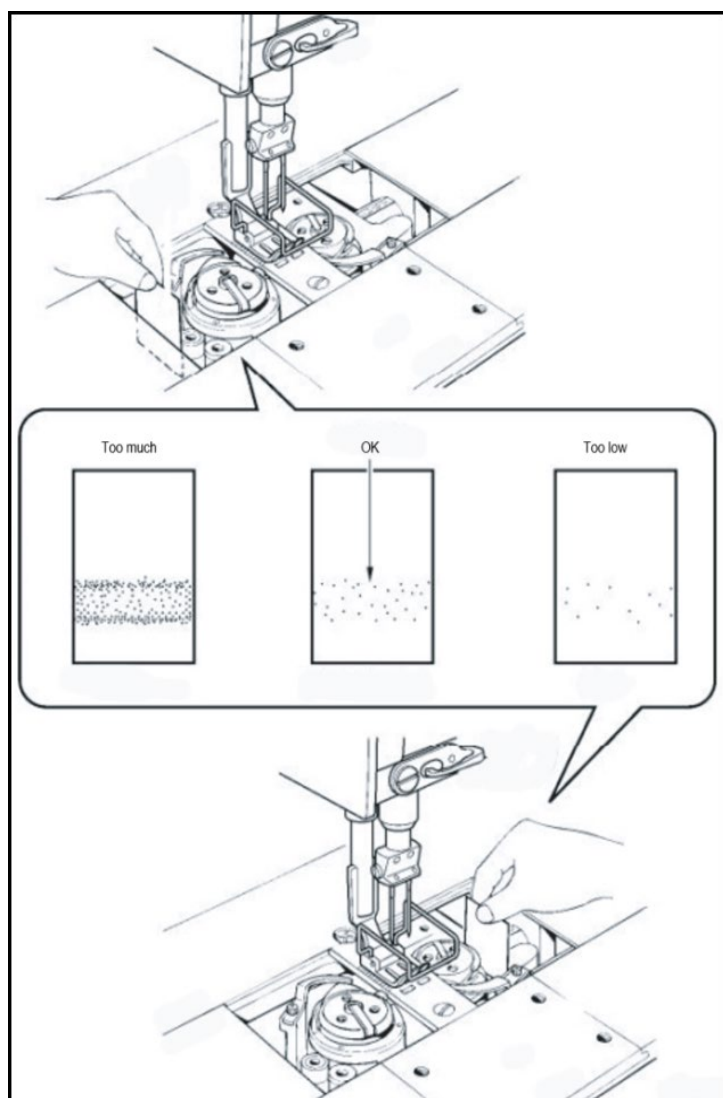
Turn the oil quantity adjustment screw [1], and set its height to 9–14 mm.

Adjust the oil supply adjustment screw [1]:

clockwise → increases oil supply
counterclockwise → decreases oil supply

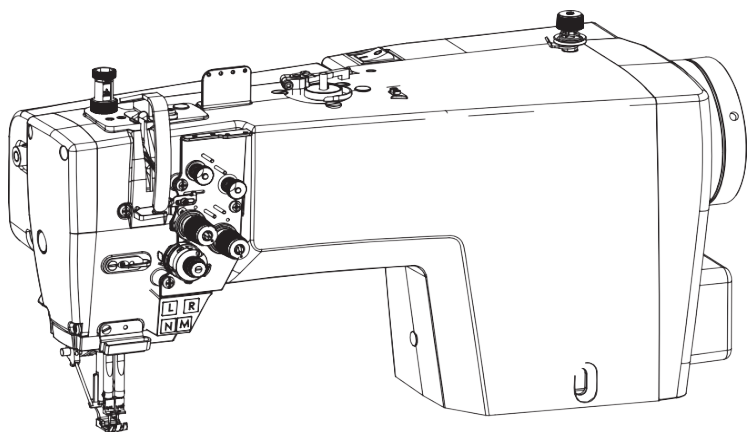
Based on the test paper results, repeat the adjustment as necessary until the appropriate oil level is achieved.

Oil Supply Verification



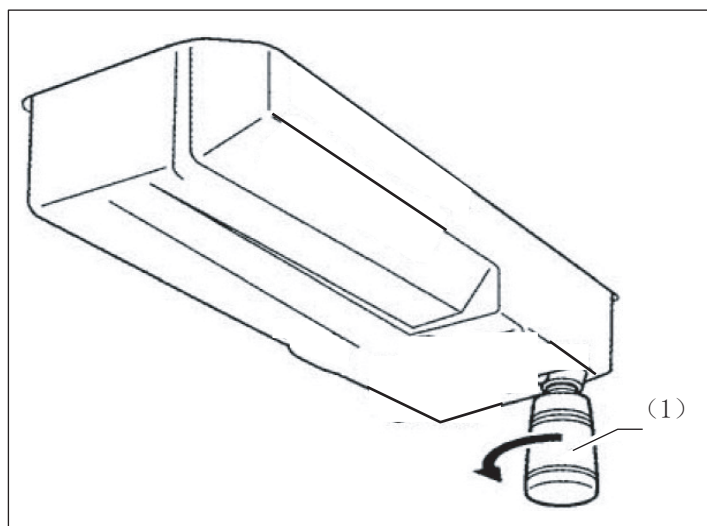
1. Turn off the power switch.
2. Remove the thread from the take-up lever to the needle.
3. Remove the needle and bobbin.
4. Raise the presser foot using the presser foot lifter.
5. Turn the power back on.
6. Run the machine at the actual sewing speed (intermittently if needed) for approximately 1 minute with no thread or fabric (idle rotation).
7. Insert the oil test paper [2] on the left side of the rotary hook (the right side when facing the machine), hold it in place, and allow the machine to rotate at high speed.
→ (There are no strict paper requirements for the test paper [2]).
8. Check the amount of oil splashed on the test paper to evaluate oil supply.

Inspection



1. If the needle is **bent** or the needle tip is **broken**, it should be **replaced**.
2. Check whether the **upper thread is threaded correctly**.
3. Perform a **test stitch**.

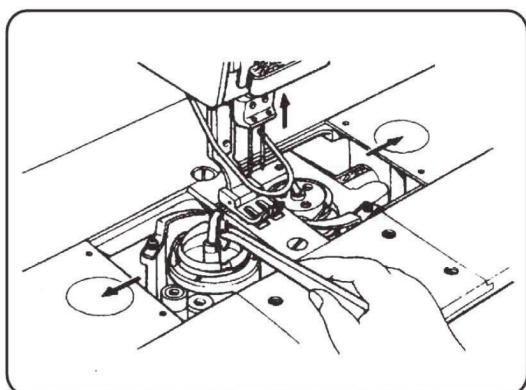
Waste Oil Disposal



1. When the **oil reservoir [1]** becomes full, **loosen and remove** the reservoir [1], then **drain the waste oil**.
2. Screw the **oil reservoir [1]** back into place.

9. CLEANING

The following cleaning operations should be carried out each day in order to maintain the performance of this machine and to ensure a long service life. Furthermore, if the sewing machine has not been used for a long period of time, carry out the following cleaning procedures before using it again.

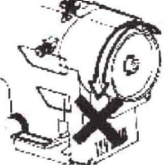
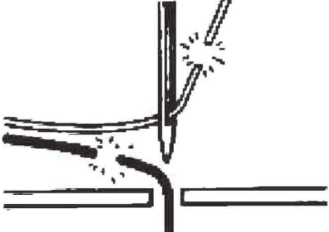


Cleaning the rotary hook.

1. Turn the machine pulley to raise the needle to its highest position.
2. Open the left and slide plates.
3. Remove the bobbin or the cap.
4. Remove all thread scraps from inside the rotary hook.
5. Replace the bobbin or the cap.

10. TROUBLESHOOTING GUIDE

Be sure to check the following before calling an authorized service station.

Problem	Where to check
1. Sewing machine pulley doesn't run. 	• Is a breaker or fuse blown? • Is the power cord disconnected?
2. Needle thread and bobbin thread break. 	• Is the needle top bent? Is the needle tip blunt? If the needle tip is bent or broken, replace the needle. • Is the needle properly installed? If it is incorrect, install the needle correctly. • Is the needle properly threaded? If it is incorrect, thread the thread correctly. • Is the rotary hook properly lubricated? If the oil level is below the lower reference line in the oil sight glass, add more oil. • Is dust or thread in the rotary hook? Clean the rotary hook. • Is the upper thread tension too strong or too weak? Adjust the upper thread tension. • Is the rotary hook, feed dog or other part damaged? If they are damaged, smooth with an oiled grindstone or replace the damaged parts.
3. Seam doesn't match 	• Is the presser foot pressure too weak? Adjust the presser foot pressure. • Is the feed dog too low? Adjust the feed dog height. • Is the bobbin scratched? If the bobbin is damaged, smooth it with an oiled grindstone or replace it.

Problem	Where to check
4. Skipped stitches. 	• Is the needle tip bent? Is the needle tip blunt? If the needle tip is bent or broken, replace the needle. • Is the needle properly installed? If it is incorrect, install the needle correctly. • Is the machine properly threaded? If it is incorrect, thread the thread correctly. • Is the presser foot pressure too weak? Adjust the presser foot pressure. • Is the sewing speed too fast? Check whether the correct motor pulley (with the correct outer diameter) that machines the maximum sewing speed any frequency of your particular model and sewing specifications is being used. If it is not correct, replace the motor pulley. Depending on the type of material, skipped stitches may occur even when sewing at the maximum sewing speed is within the standard rated range. In such cases reduce the operating speed by selecting a motor pulley that is one size smaller.
5. Poor thread tightening 	• Is the machine properly threaded? If it is incorrect, thread the thread correctly. • Is the thread take-up spring operation range too small? Adjust the operation range of the thread take-up spring. • Is the needle thread tension and bobbin thread tension too low? Adjust the upper and lower thread tension. • Is the bobbin scratched? If the bobbin is damaged, smooth it with an oiled grindstone or replace.
6. Broken needles 	• Is the material being pushed with excessive force during sewing? If the needle tip is bent or broken, replace the needle. • Does the needle pass the center of the needle hole in the feed dog? Check the needle down position. If the needle does not drop into the middle of the needle hole in the feed dog, re-install the feed dog. Caution • It is extremely dangerous to leave any pieces of broken needle sticking in the material. If the needle breaks, search for all pieces until the whole of the needle is found again.

CE DECLARATION OF CONFORMITY

Distributor:

Strima Sp. z o.o.

Swadzim, ul. Poznańska 54

62-080 Tarnowo Podgórne, Poland

We declare, that the following product:

High speed two needle lockstitch sewing machine

Model: **TWIN 1F, TWIN 6HF**

was designed and manufactured in compliance with the following directives:

2014/35/EU Low Voltage Directive

2014/30/EU Electromagnetic Compatibility Directive

2006/42/EC Machinery Directive

Harmonized norms used:

EN ISO 12100:2010

EN ISO 10821:2005+A1:2009

EN 60204-1:2006+A1:2009+AC:2010

EN 60204-31:2013

Certificate of conformity number: No.: 2T151222.ZBSQS33

Technical Construction File No.: RVT-BY20151211.003.007.009

Test Report No.: OViS202312065M, OViS202312065E

Strima Sp. z o.o.
Swadzim 15.07.2025

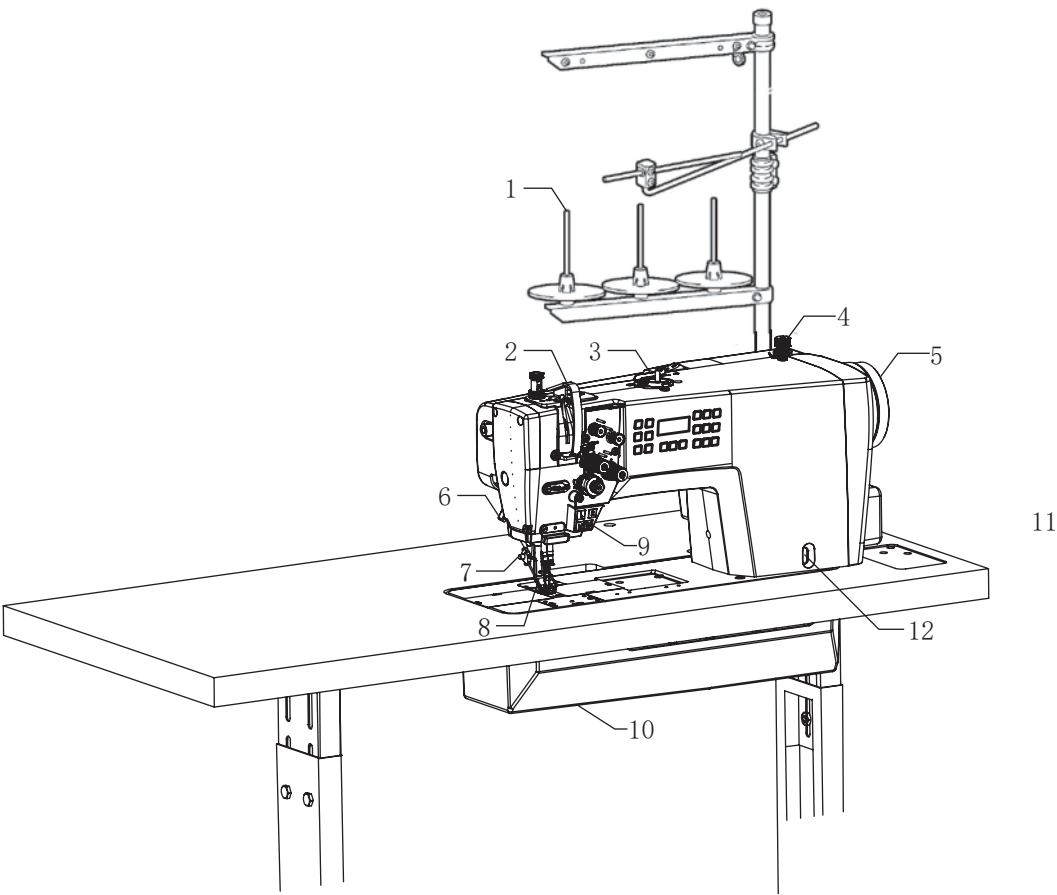
说明书

TWIN 1F
TWIN 6F
TWIN 6HF

双针工业缝纫机

The logo for Texi, featuring a stylized purple icon of three overlapping circles to the left of the word "texi" in a purple, italicized, sans-serif font.

1. 各部件名称



1. 线架

2. 挑线杆防护罩

3. 梭心绕线装置

4. 梭心绕线夹线器

5. 手轮

6. 压脚扳手
7. 扫线装置

8. 压脚

9. 多功能按键

10. 油盘

11. 操作面板

12. 油量视窗

2. 缝纫机规格

2-1. 缝纫机编号规则
TEXI 1F / 6HF

旋梭	1	6
	标准旋梭	大旋梭

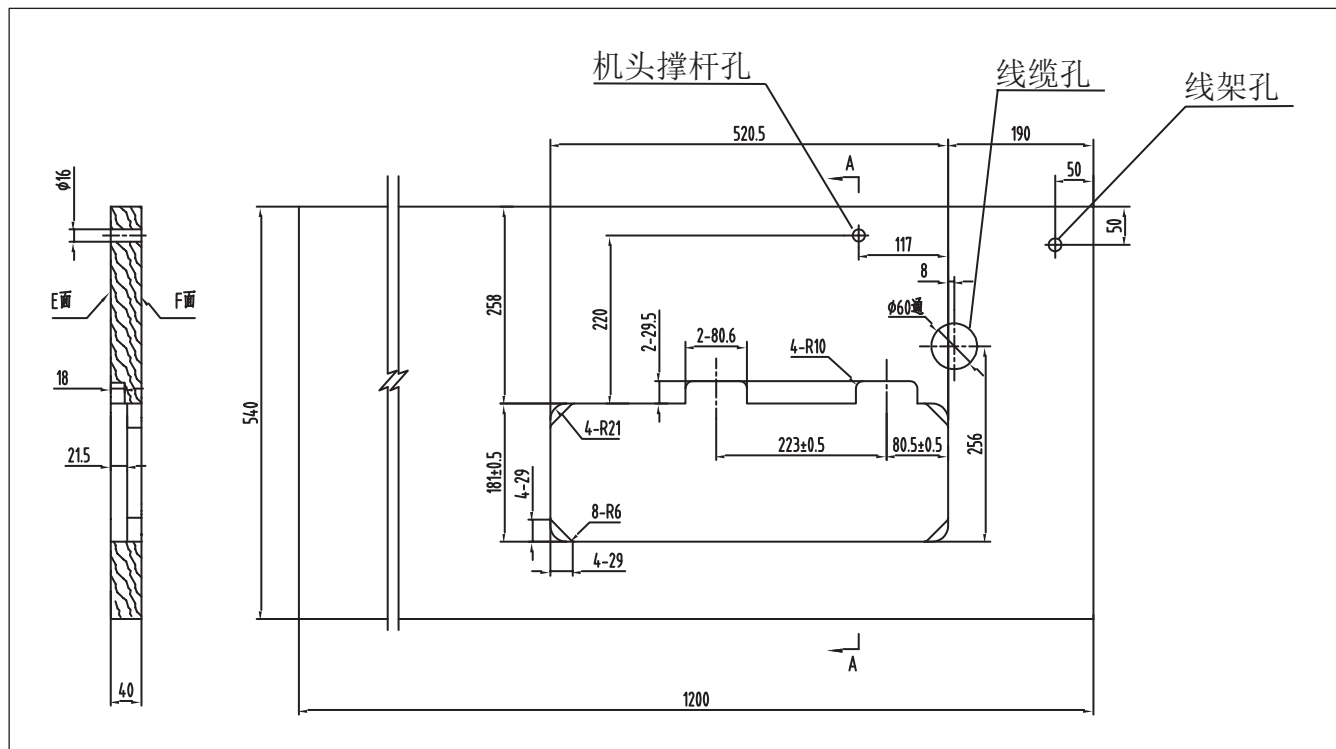
缝制类型	—	H
	标准	角缝

2-2. 机器规格

型号	最高 转速	最大 针距	压脚高度		送布牙 高度	机针 DP×5
			扳手	自动		
1F	3000	5	6	12	1	11-18
6HF	3000	7	6	12	1	14-22

3. 关于台板

- 台板的厚度应达到40mm，能够承受缝纫机的重量，并经得起缝纫机的震动。



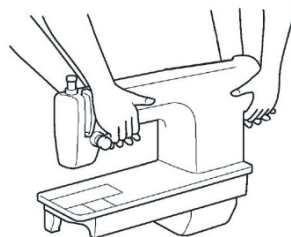
4. 安装方法

! 注意

- ⊘ 请让受过培训的技术人员来安装缝纫机
- ⊘ 安装完成之前，请不要连接电源，如果误按启动开关，缝纫机动作会导致受伤
- ⊘ 缝纫机重量约60Kg，安装工作必须由两人以上来完成
- ⊘ 缝纫机头倒下或竖起时，请用双手进行操作，单手操作时因缝纫机的重量万一滑落易导致受伤。

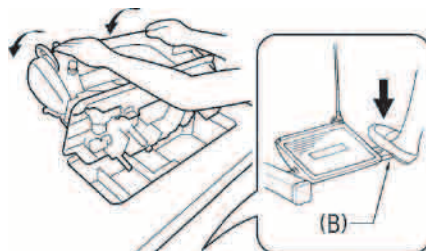
搬运缝纫机

- 用手托住手轮下部马达罩
- * 请注意手轮不要转动



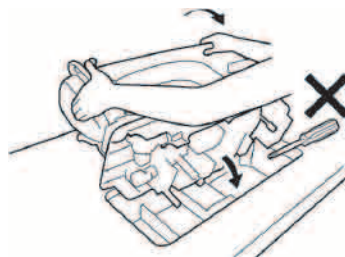
向后倾斜缝纫机头部

- 用脚踏住 (B) 部分，不让台板移动，然后用双手推动机壳本体使缝纫机头部倾斜

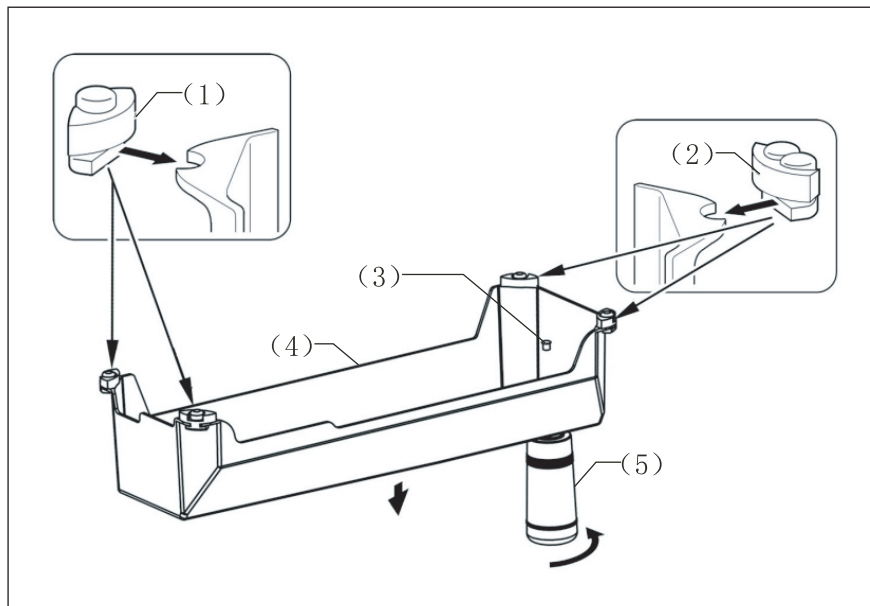


将缝纫机头部返回至直立的位置

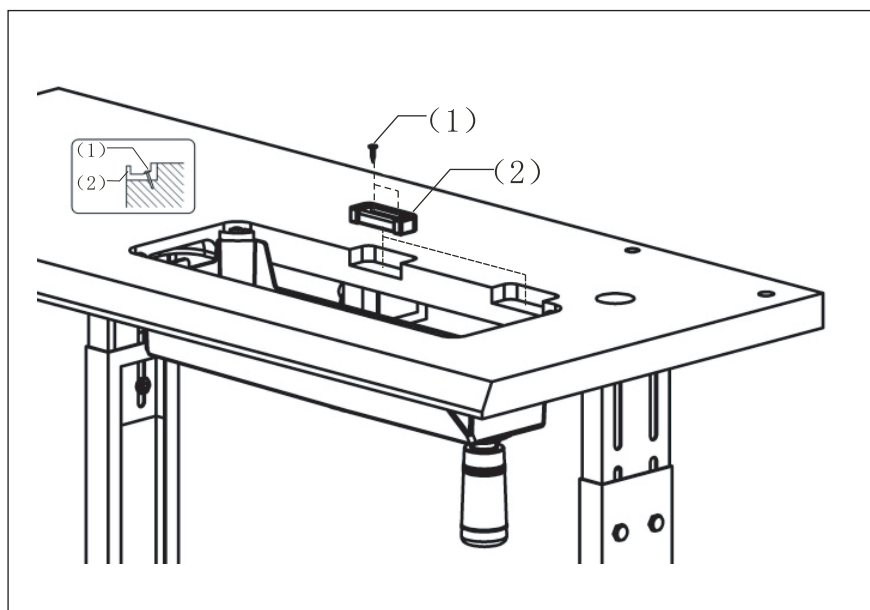
1. 清除台板开孔附件的所有工具等物件
2. 用左手扶住面板，用右手轻轻地将缝纫机头部返回至直立的位置



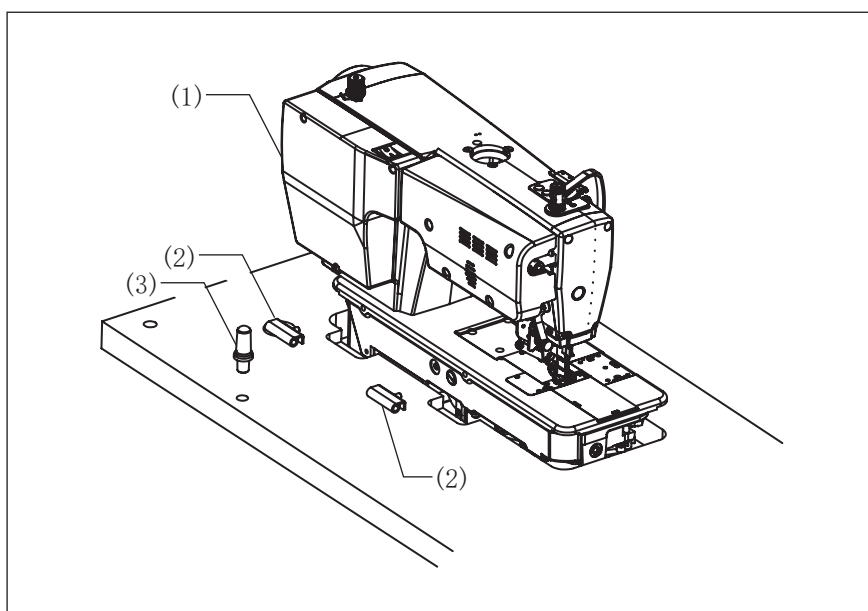
4-1. 安装方法



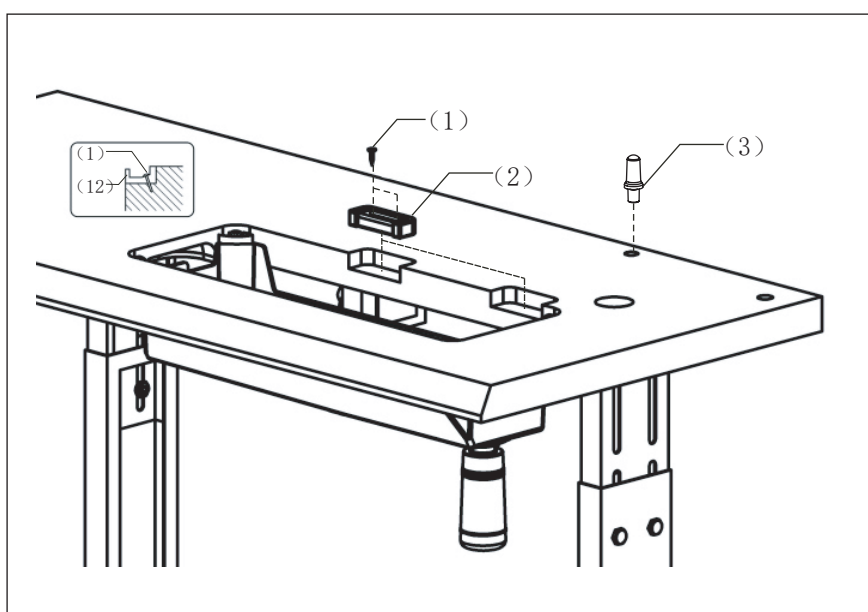
1. 头部防震垫块左[2个]
2. 头部防震垫块右[2个]
3. 放油橡皮塞[1个]
4. 油盘[1个]
5. 油壶[1个]



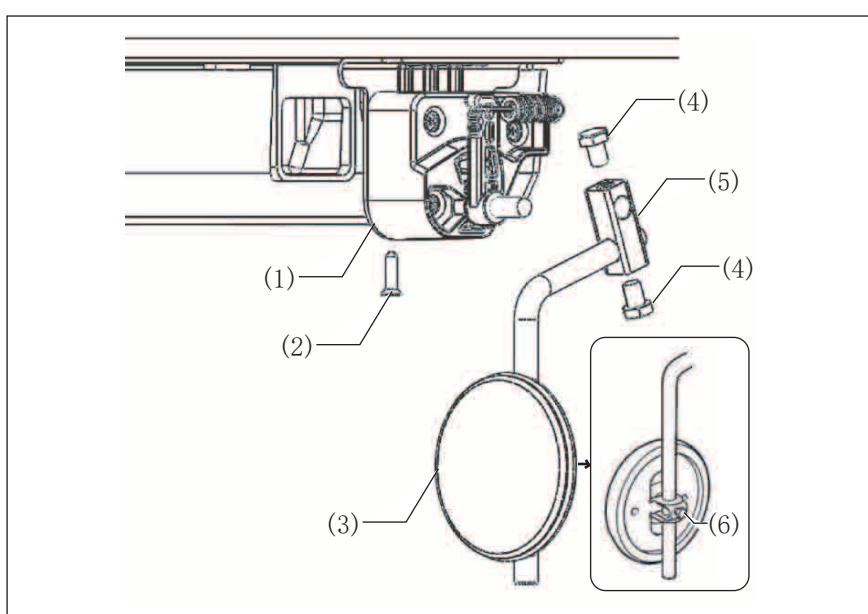
1. 钉[4个]
2. 机壳铰链套[2个]



1. 缝纫机头部[1个]
2. 机壳铰链[2个]
3. 机头撑杆[1个]



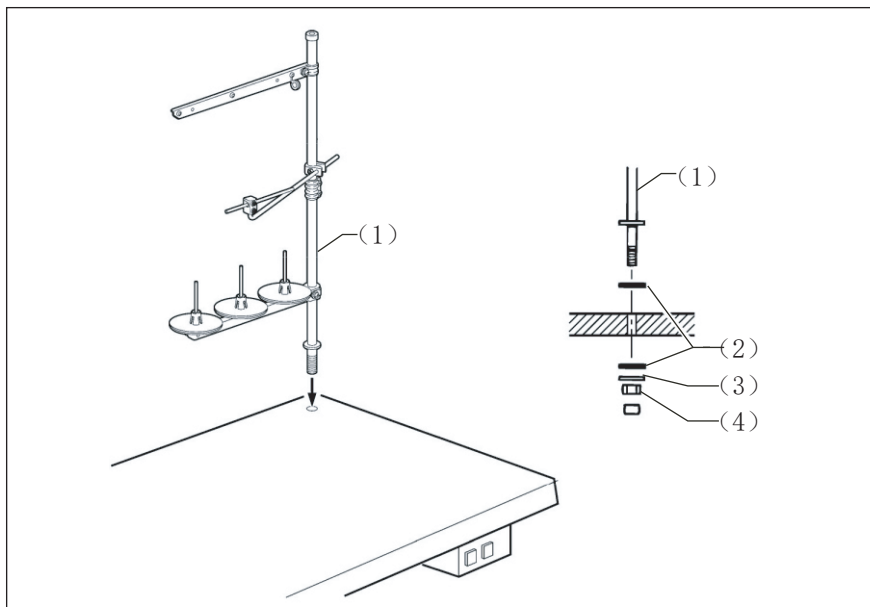
1. 钉[4个]
2. 机壳铰链套[2个]
3. 机头撑杆[1个]



1. 电子脚靠[1个]
2. 螺钉[4个]
3. 膝控碰块[1个]
4. 螺栓[2个]
5. 碰块接头[1个]
6. 螺栓[1个]

* 松开螺栓[4]和[6], 将膝控碰块[3]移至于使用的位置

1. 线架【1个】



*将螺母[4]拧紧以便将垫圈[3]和橡胶垫圈[2]夹紧，使线架[1]不会移动

4-2. 加油方法

⊘



注意

⊘ 加油未完成前，请勿插上电源
当误按启动开关时，缝纫机动作会导致人员受伤

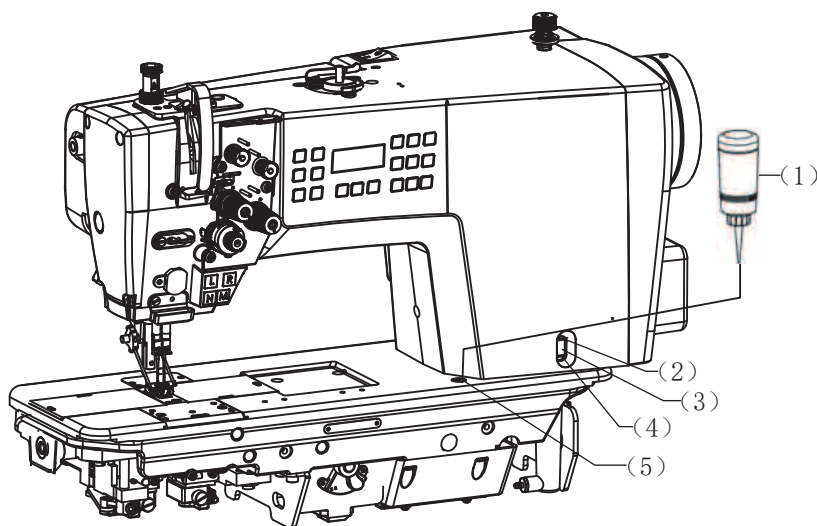
● 使用润滑油和黄油时，务必戴好保护眼睛和保护手套等防护用品，以防润滑油落入眼中或沾在皮肤上，这是引起发炎的原因
另外，润滑油或黄油不能饮用，否则会引起呕吐和腹泻。将油放在小孩拿不到的地方

必须经常润滑缝纫机，第一次使用或长时间未使用缝纫机时，要补充润滑油

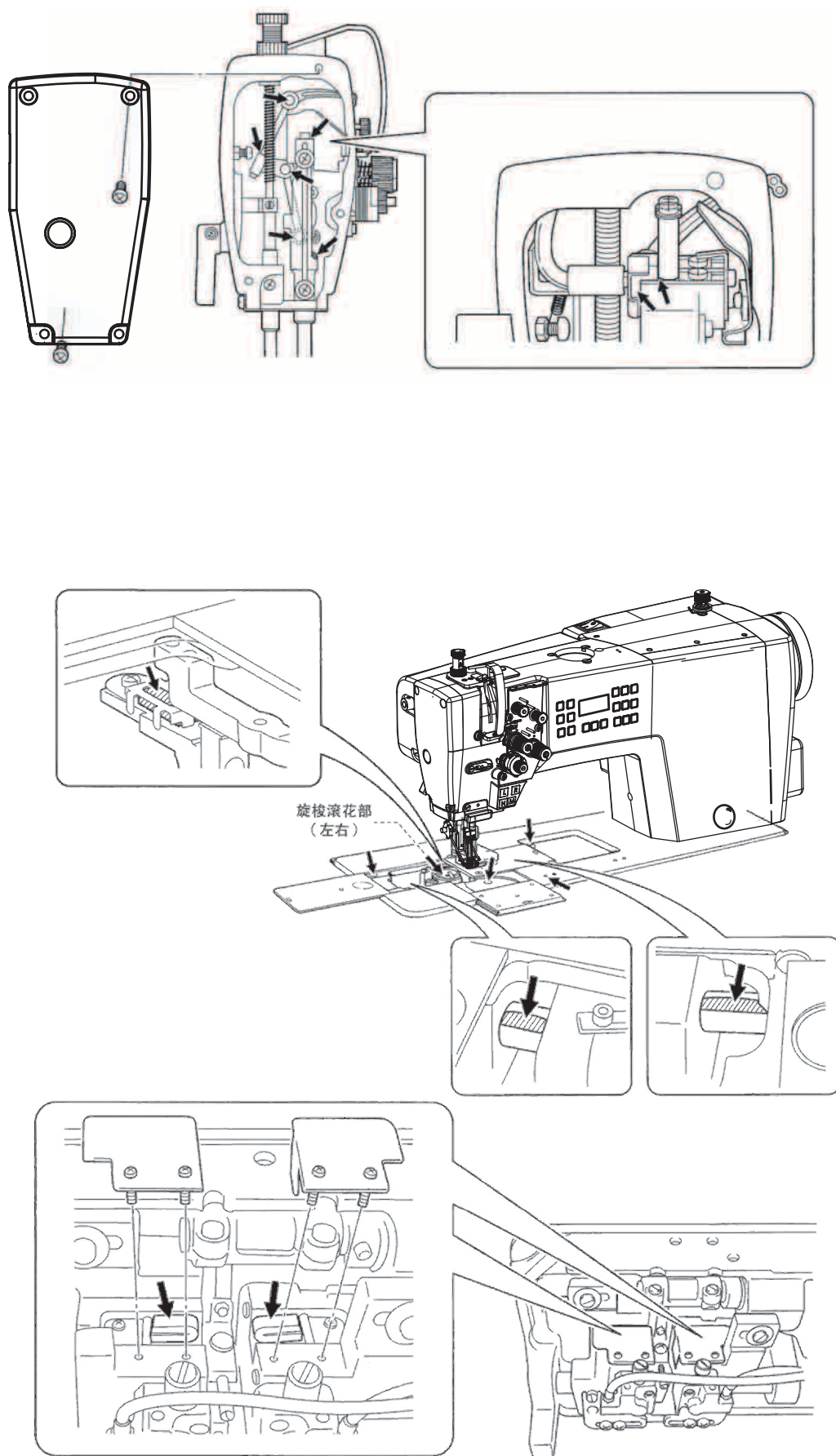
给油箱加油

1. 取出橡皮塞[5]，将[1]插入机壳加油孔内，注入润滑油
2. 注入润滑油到油窗[3]顶部刻线，[2]时停止加油

*当润滑油下降到油窗[3]底部刻线[4]时，请务必补充润滑油



● 在每个箭头标记处注入1-2滴润滑油



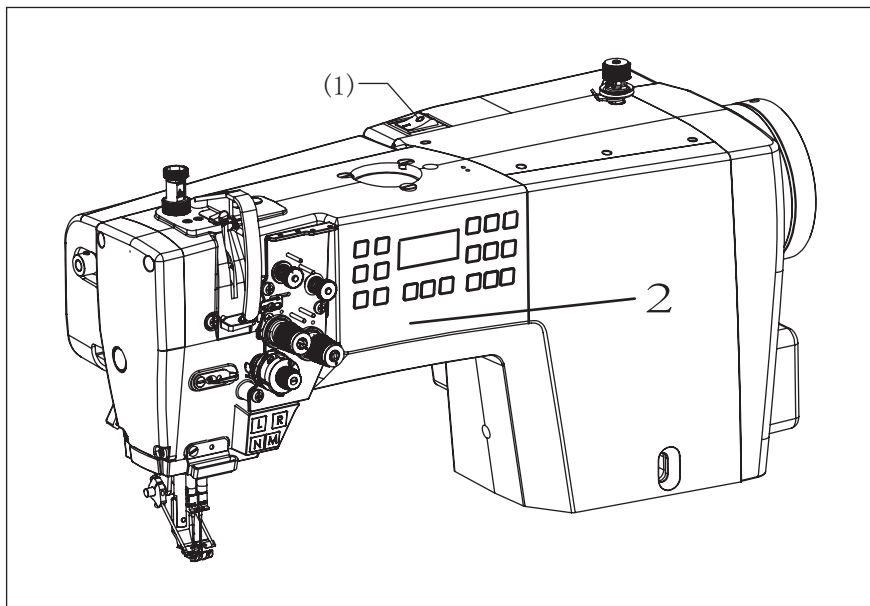
4-3. 操作测试（脚踏板的操作方法）



注意

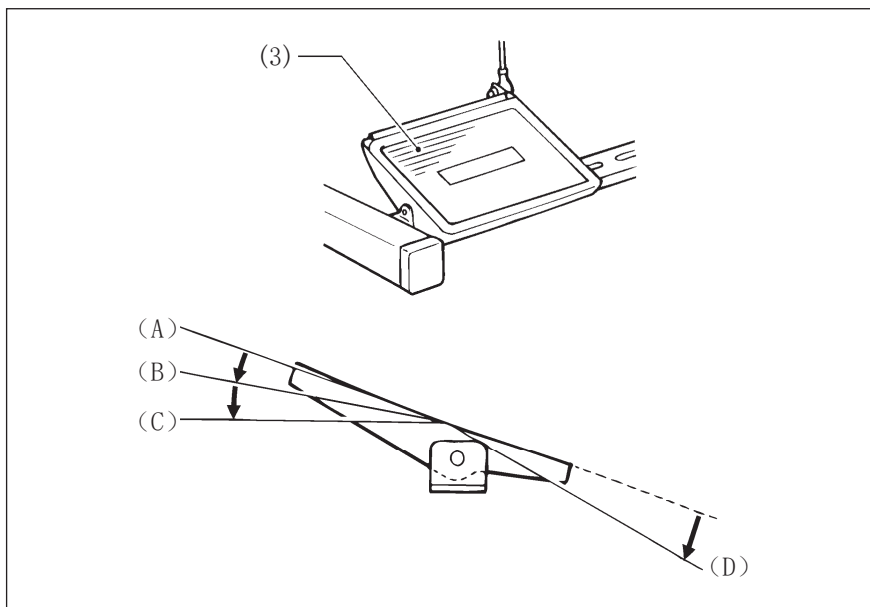


缝纫过程中，不用触摸任何运动部件或将物件靠在运动部件上，因为这会导致人员受伤
缝纫机损坏



打开电源

1. 按电源开关[1]将电源打开，显示屏[2]屏幕亮起，转动手轮无明显卡点



操作测试

1. 检查将脚踏板[3]轻压到位置[B]时缝纫机的低速缝纫状态
2. 更进一步将脚踏板[3]轻压到位置[C]时缝纫机的高速缝纫状态
3. 向前压下脚踏板[3]后，检查在脚踏板[3]返回到空挡位置[A]时机针是否将至针板下（当已设置机针在下停针位时）
4. 如果将脚踏板[3]压到位置[D]随后机针升至针板上方并停止

5. 缝纫前的准备

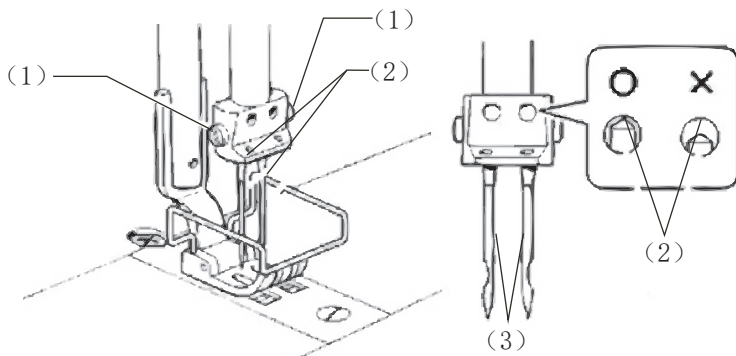
5-1. 机针的安装方法



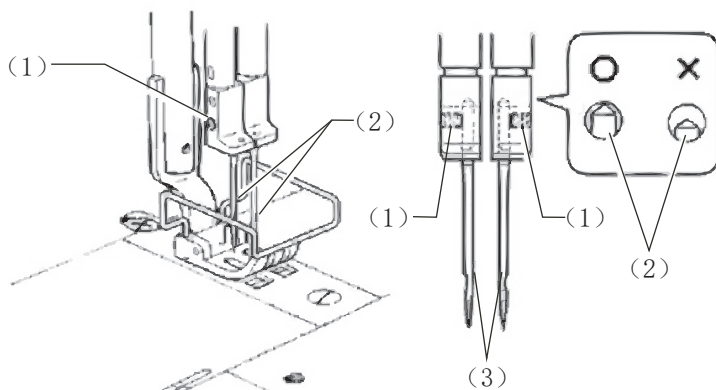
注意



安装机针时，请切断电源。请在马达完全停止后，再进行操作
当误按动启动开关时，缝纫机动作会导致人员受伤



1. 转动缝纫机手轮，将针杆移至最高位置
2. 松开螺钉[1]
3. 将机针[2]上的长槽[3]朝着内侧笔直插到底并拧紧螺钉[1]

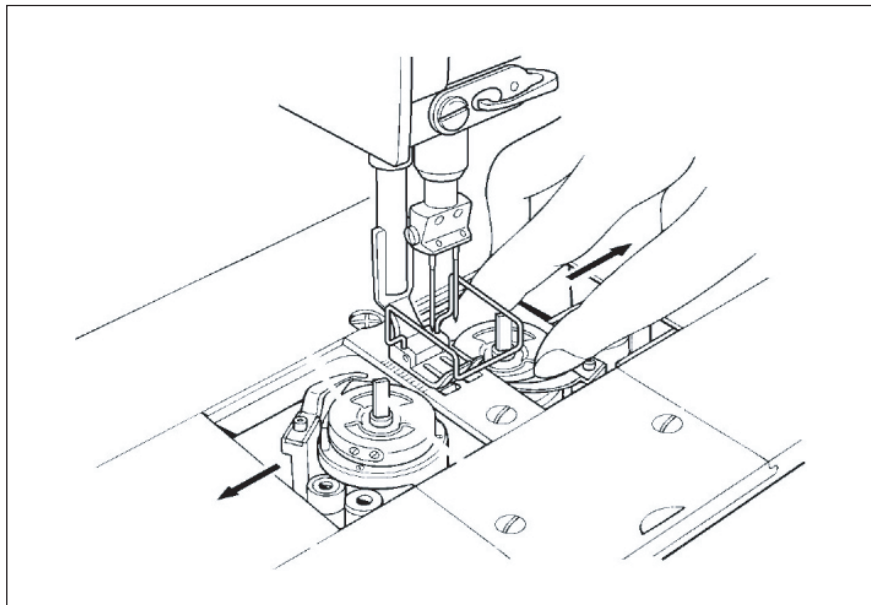


5-2. 梭芯的装拆方法

! 注意



取出梭芯时，请切断电源。请在马达完全停止后，再进行操作
当误按动启动开关时，缝纫机动作会导致人员受伤



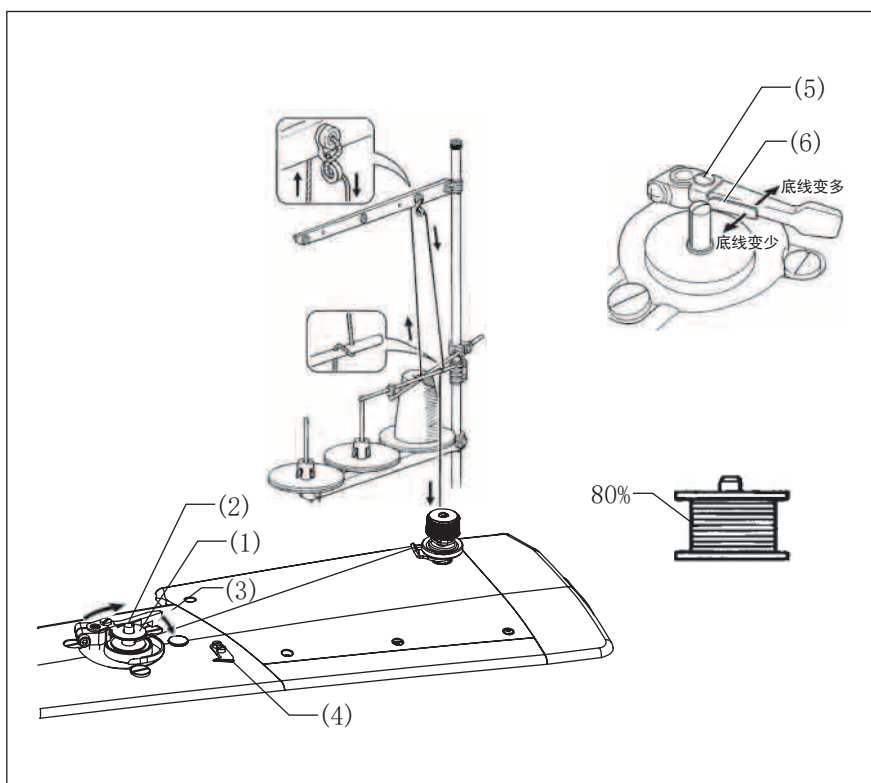
1. 将滑板[1]左右分开
2. 将旋梭的捏手[2]提起之后，取出梭芯套[3]
3. 取出梭芯

5-3. 底线的绕线方法

! 注意



在卷线过程中，不要触摸任何运动部件或将物件靠在运动部件上，因为这会导致人员受伤或缝纫机损坏



1. 打开电源开关
 2. 将梭芯[1]置于梭芯卷线轴[2]上
 3. 按箭头所示的方向将线在梭芯[1]上卷绕几次
- * 请确认各部分的机线应没有松弛
4. 将梭芯压臂柄[3]推向梭芯[1]
 5. 用压脚扳手将压脚抬起
 6. 踏下脚踏板，随即开始卷绕底线
 7. 底线卷绕一旦完成，梭芯压臂柄[3]将自动返回
 8. 底线卷绕之后，将梭芯拆下，用切刀[4]将线剪断
- * 松开螺钉[5]，移动梭芯[6]调节卷绕在梭芯上的底线量
- 注意：卷绕在梭芯上的底线量最多应为梭芯容量的80%

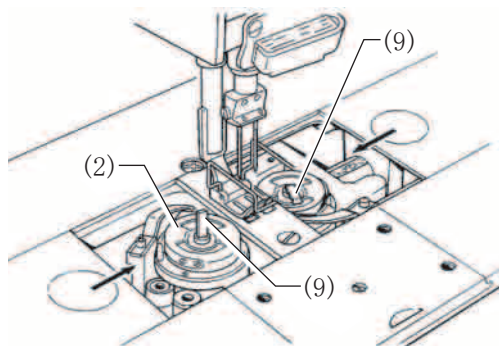
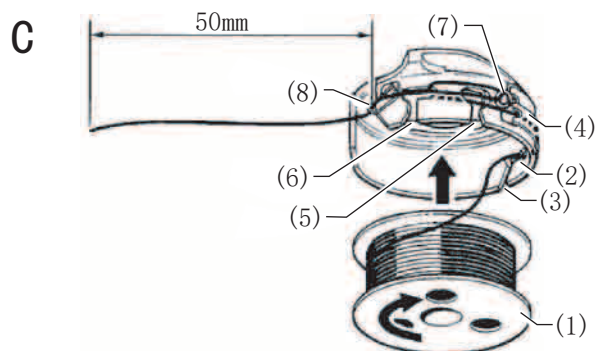
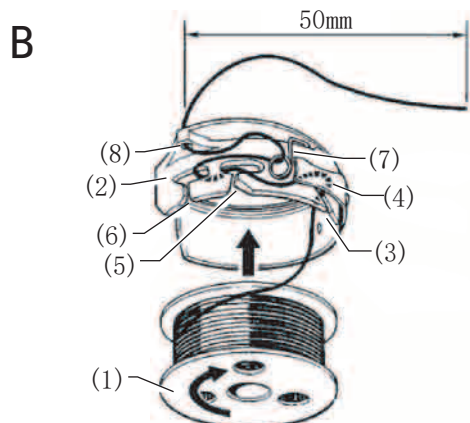
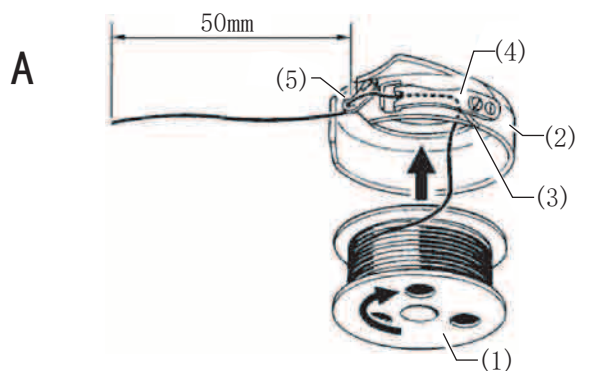
5-4. 梭芯的装取方法



注意



取出梭芯时，请切断电源。请在马达完全停止后，再进行操作
当误按动启动开关时，缝纫机动作会导致人员受伤



1. 将线的绕向置于如图所示的方向
然后将梭芯[1]放入梭芯套[2]内

2. 梭芯套[2]有A、B、C三种
请根据所使用的梭芯套[2]的形
状，按下述进行穿线

A.

1. 将线穿过线槽[3]，使它通过张
力弹簧[4]的下面
2. 将线穿过线孔[8]，并拉出约
50mm

B. C

1. 将线穿过线槽[3]，使它通过张
力弹簧[4]的下面
2. 将线穿过线槽[5]、[6]，使它钩
在底线张力弹簧[7]上
3. 将线穿过线孔[8]，并拉出约
50mm

3. 将梭芯套[2]放入旋梭内

4. 将旋梭的捏手[9]倒下

5. 关闭滑板

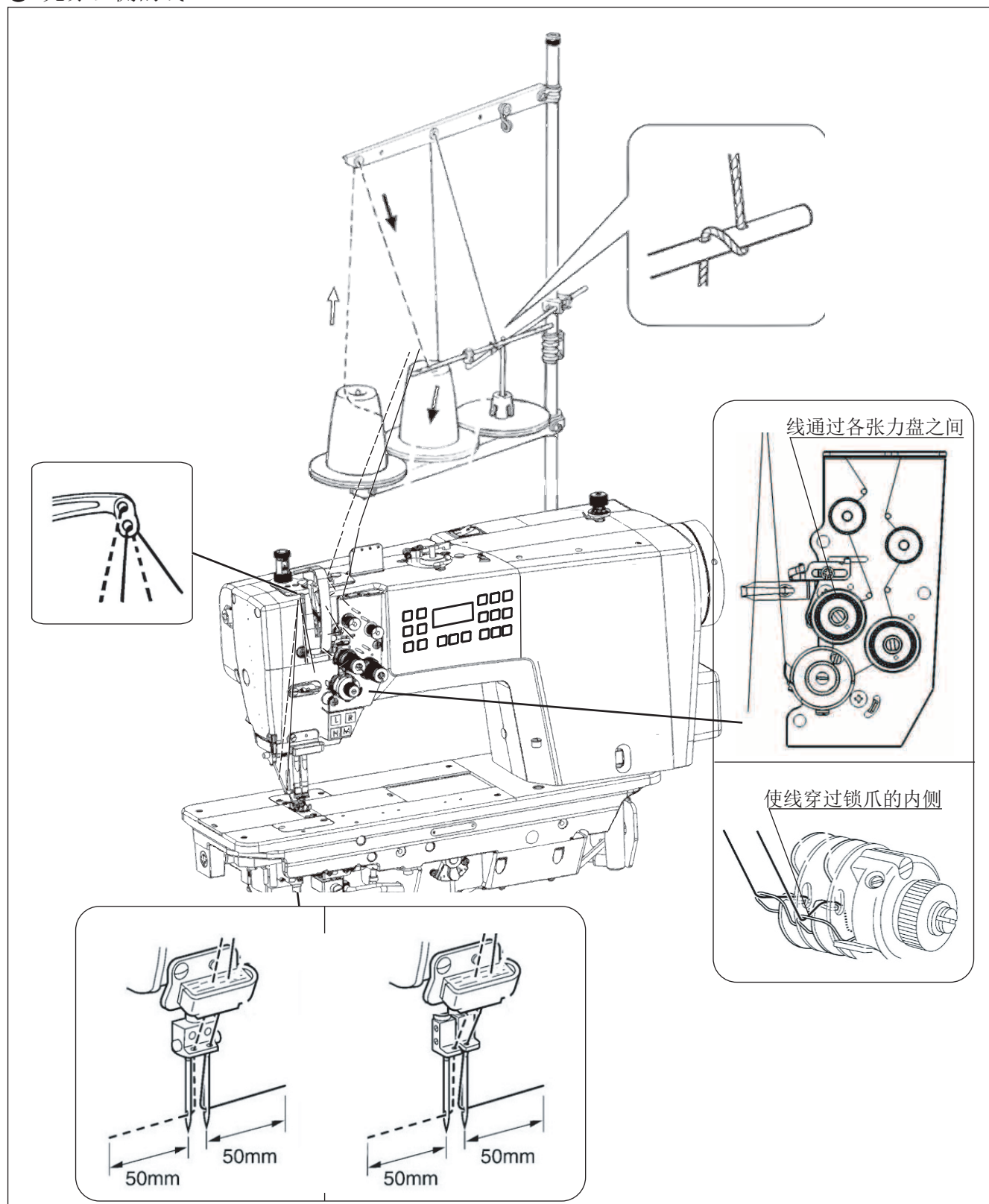
5-5. 面线的穿法

⚠ 注意

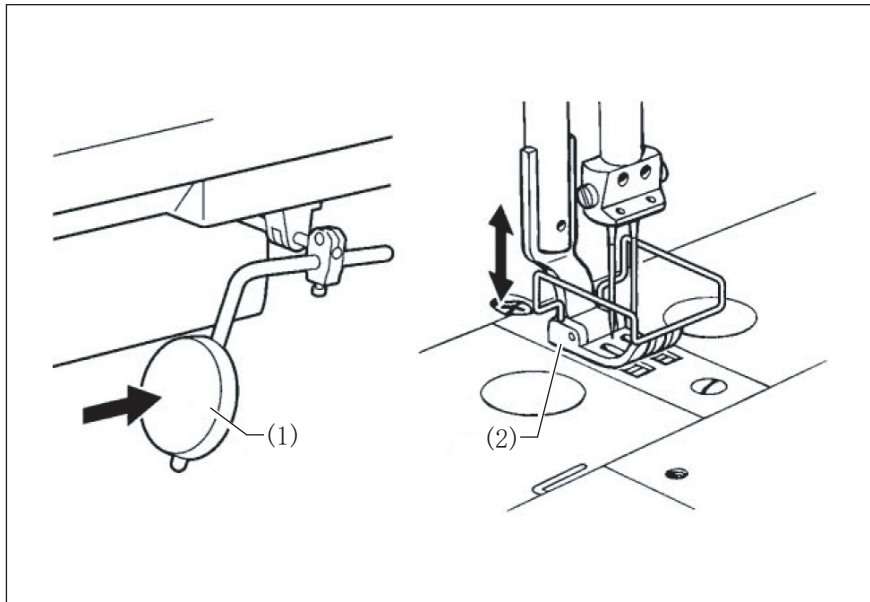


在穿线过程中，请切断电源。请在马达完全停止后，再进行操作
当误按动启动开关时，缝纫机动作会导致人员受伤

- 在穿引面线之前转动手轮，抬高挑线杆[1]，这样会使穿引更加容易，并防止面线在缝纫开始时脱落
- 先穿左侧的线



5-6. 膝控碰块的使用方法

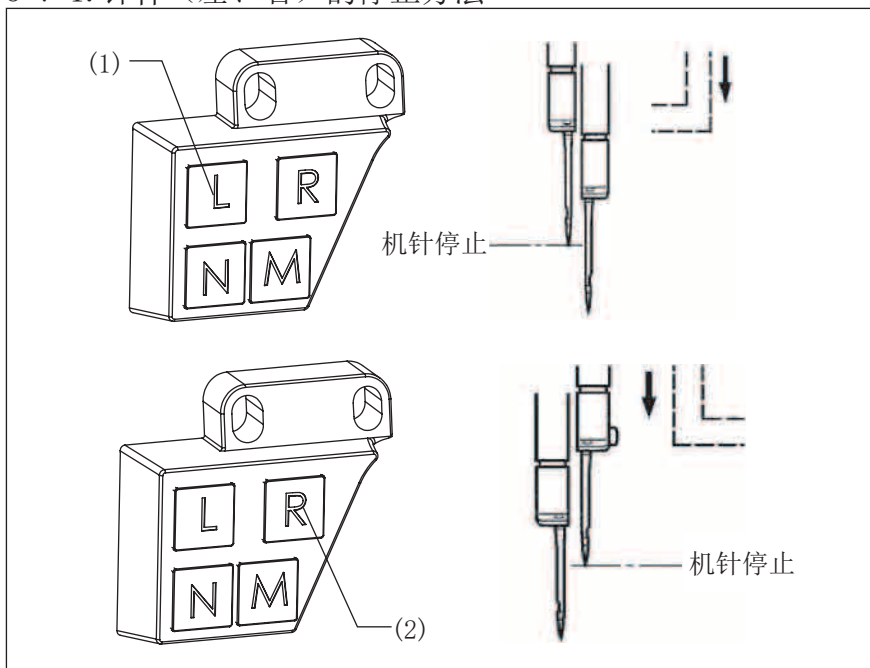


按动膝控碰块[1]，压脚[2]可自动抬起，越向右，压脚抬起高度越高

5-7. 角形缝纫方法（6HF）

注意：要将本缝纫机作为单针缝纫机使用时，请把不使用一侧的机针拆掉后再进行缝纫。请不要使用下述的针杆停止方法。否则可能会导致缝纫机损坏。

5-7-1. 针杆（左、右）的停止方法



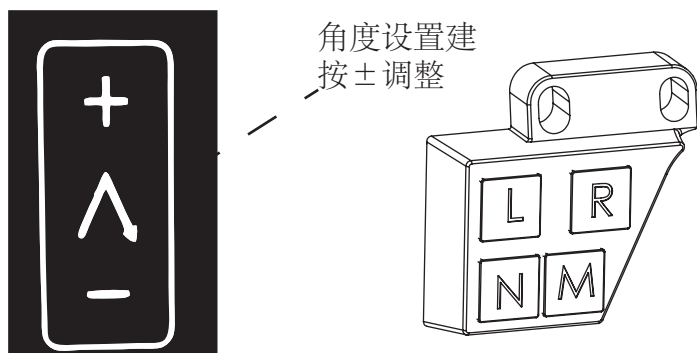
● 请在机针停在下停针位置后再按按钮

左侧针杆的停止操作
按一下按钮开关L[1]

右侧针杆的停止操作
按一下按钮开关R[2]

恢复双针缝纫
再按一下相对应的按钮开关L[1]
或R[2]

5-7-2. 转角缝纫方法

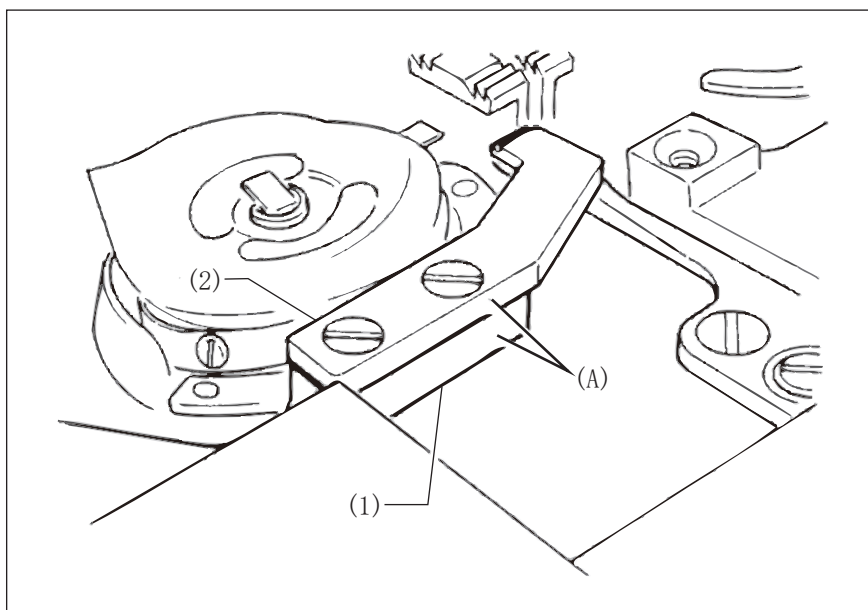


1. 设置好转角角度
2. 启动机器，到达转角位置时，按相对应的转角按键L或R，机器自动运转，运动完指定针数后，机器停止运动，压脚自动抬起，旋转缝料到设定角度
3. 再次启动机器，完成转角缝纫

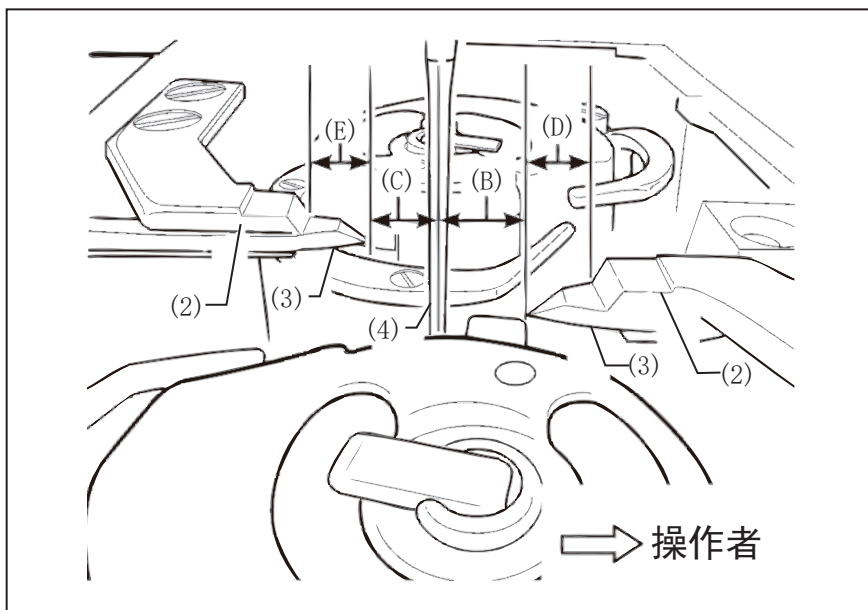
5-8. 活动刀位置的调整方法



在调整活动刀过程中，请切断电源。请在马达完全停止后，再进行操作
当误按动启动开关时，缝纫机动作会导致人员受伤



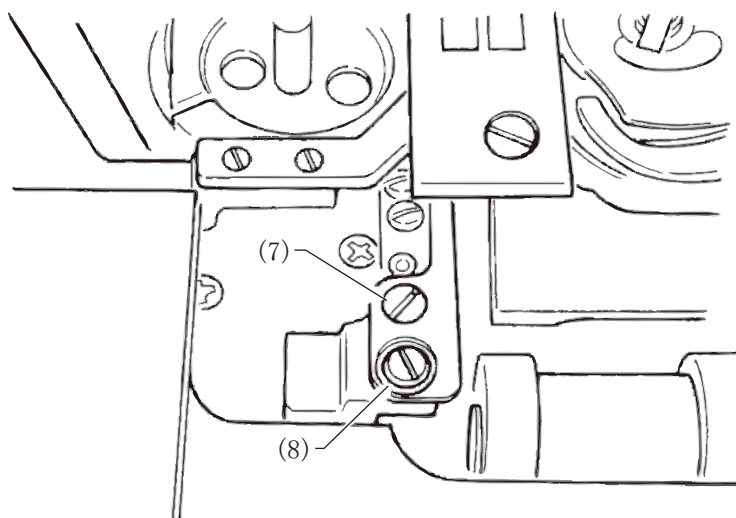
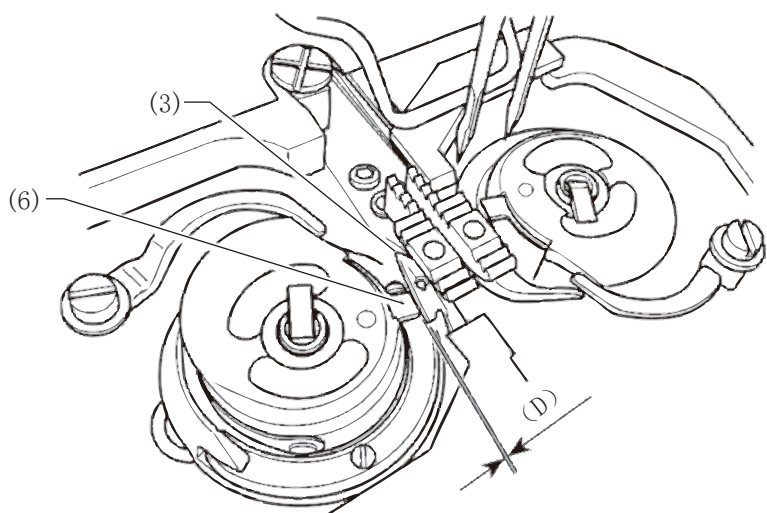
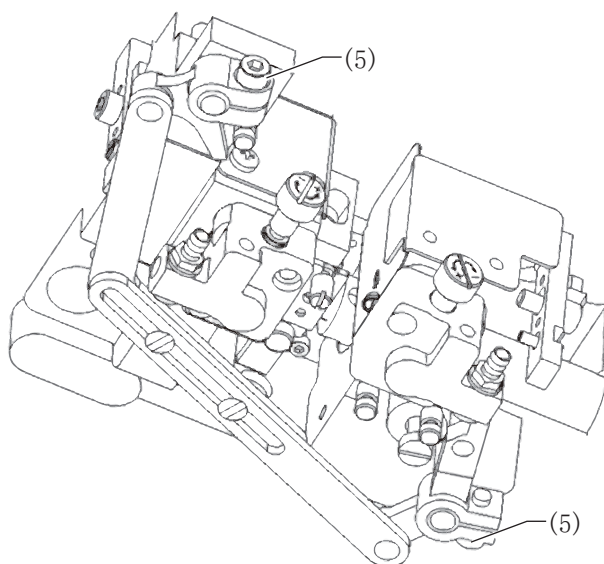
1. 让固定刀座[1]和固定刀[2]的[A]面对齐



2. 拧松切刀曲柄螺钉[5]，针距调到最小，机针[4]在下死点和待机时的活动刀[3]的前端、机针[4]的距离[B]以及[C]调整成下表中的尺寸

	左切刀		右切刀	
	B	D参考值	C	E参考值
1F	6.2	(3.5)	7.5	(2.7)
6HF	7.3	(4.1)	8.9	(3.1)

3. 把动作时的活动刀[3]和中旋梭凸起部[6]的间隙[D]调整为 0.3 ± 0.1 ，请拧松活动刀固定螺丝[7]、[8]进行调整

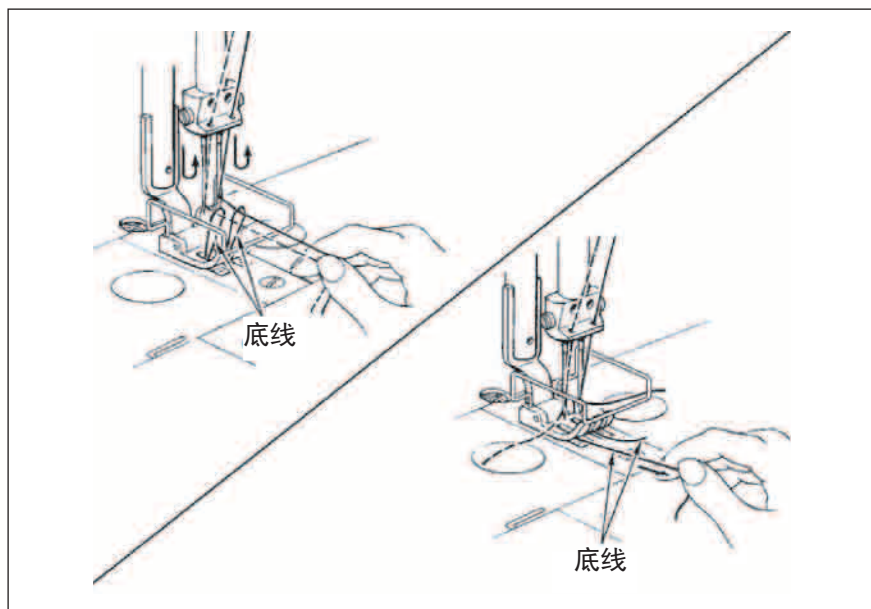


6. 缝纫

⚠ 注意

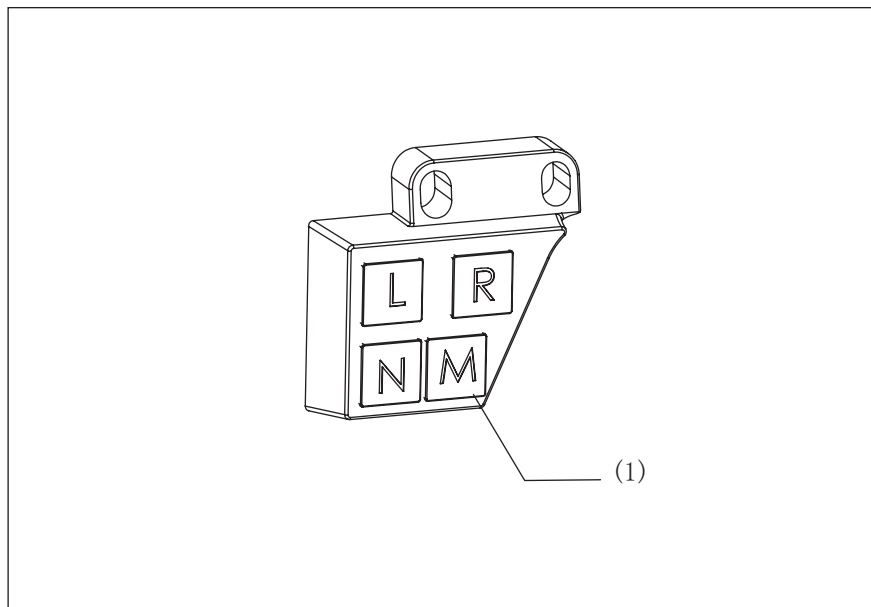
- ⚠ 为了安全起见，在使用本缝纫机之前，请安装保护装置。
如果未安装这些安全装置就使用缝纫机，会造成人身伤害及缝纫机损坏。
- ⚠ 发生下列情况时，请切断电源。在马达完全停止后，再进行作业。
否则误按动启动开关，缝纫机动作会导致受伤。
- 机针穿线时
 - 更换机针或梭芯时
 - 缝纫机不使用，或人离开缝纫机时
- ⚠ 缝纫过程中，不要触摸任何运动部件或将物体靠在运动部件上，因为这会导致人员受伤或缝纫机损坏
- ⚠ 缝纫机头倒下或竖起时，请用双手进行操作。
单手操作时因缝纫机的重量万一滑落易导致受伤。

6-1. 缝纫



1. 一边用手指握住面线[2根]一边用手把缝纫机手轮朝自己身边方向转到，以将底线拉到送布齿的上面
2. 将底线朝自己身边方向拉，确认底线应能平稳地伸出
3. 打开电源
4. 踏下脚踏板开始缝纫

6-2. 倒缝加固的方法



1. 在缝纫中，如果按下倒缝按钮[1]布料就被倒送，放开按钮[1]又恢复正送布状态

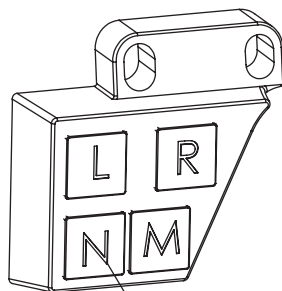
6-3. 缝纫密针的方法

1. 长按操作面板P键, 显示4个0, 输入密码2017, 显示P92, 按液晶屏幕下方最右±键, 选择到P71项, 按S键进去, 用针距调键



调整补针针距

调整好后, 按S键确认, 按P键退出



(2)

1. 设置好密缝针距[1]
2. 在缝纫中, 如果按下密缝按钮N[2]就能以密针的针迹长度进行缝纫(前进方向)

7. 缝纫效果

7-1. 调节线张力



← 面线
← 底线

正确线迹



面线张力过小或底线张力过大



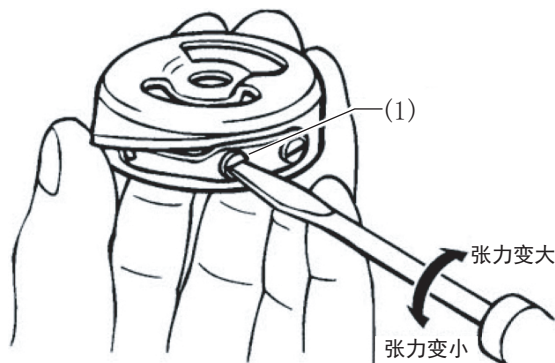
增大面线张力
减小底线张力



面线张力过大或底线张力过小

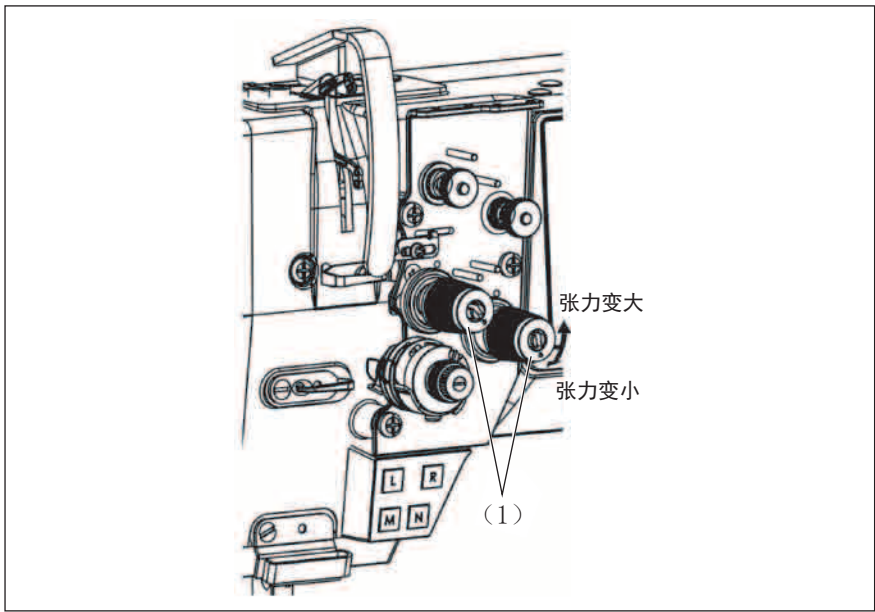


减小面线张力
增大底线张力



底线张力

转动底线张力螺钉[1]进行调节

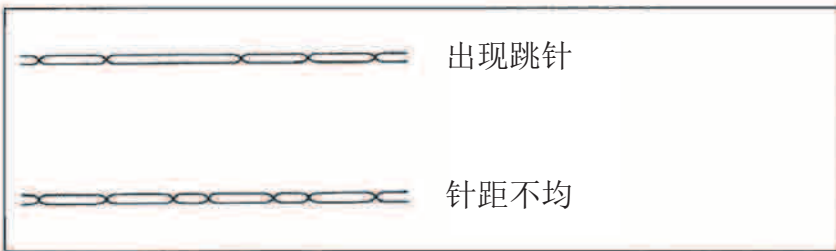
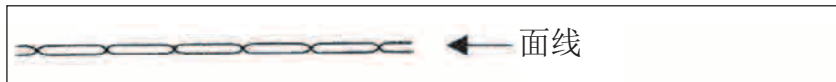


面线张力调整

在底线张力调节后，调节面线张力以使针脚均匀平整

转动夹线螺母[1]进行调节

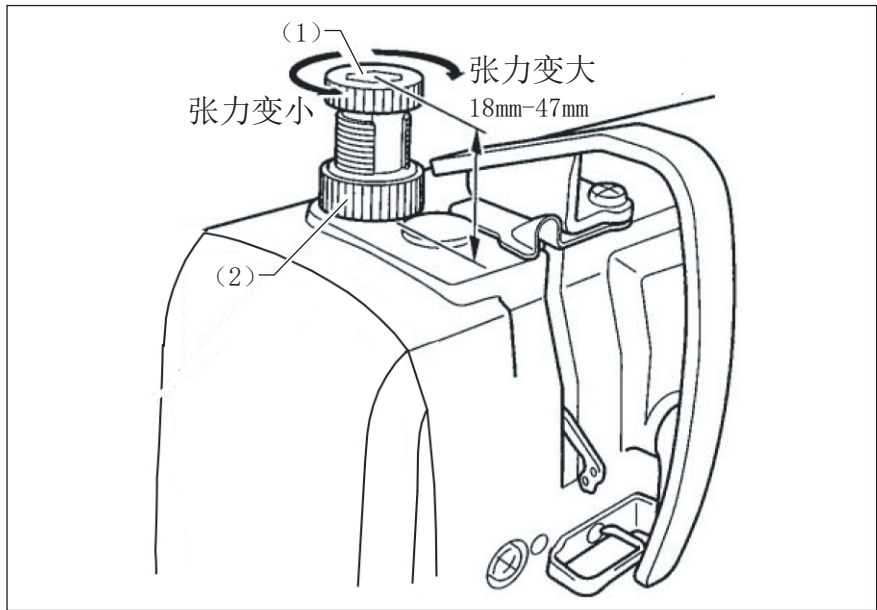
7-2. 调节压脚压力



增加压力



减小压力



应尽可能减小压脚压力，但须有足够压力使面料不致滑动

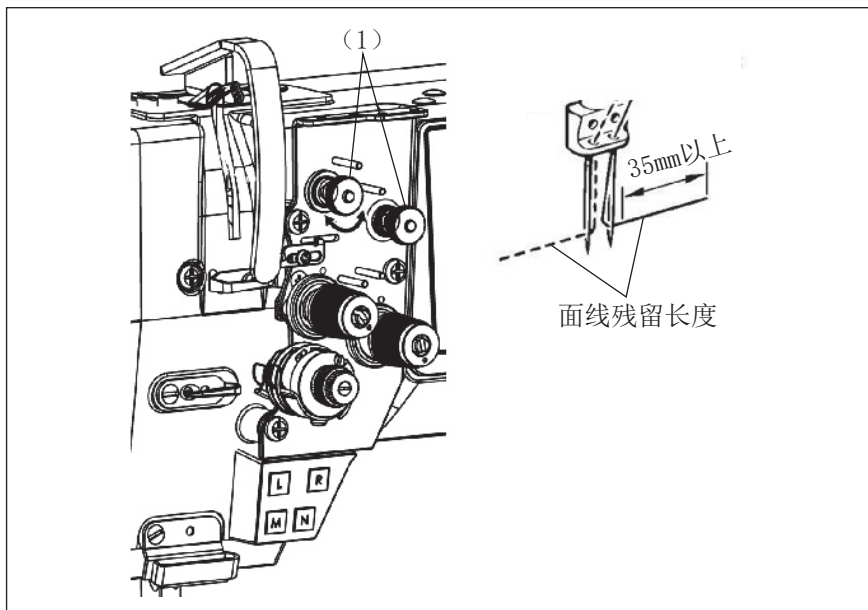
(以下表的“压脚调节螺钉高度”为大致标准进行调节)

1. 松开调节螺母[1]
2. 转动压力调节螺栓[2]以调节压脚压力
3. 拧紧调节螺母[1]

参考值

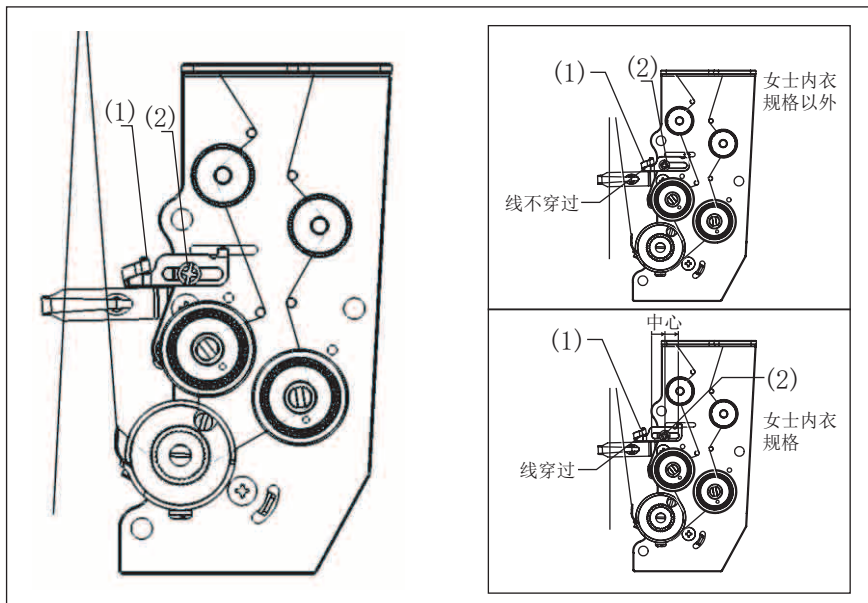
用途	压脚调节螺钉高度
女士内衣用	约34mm
薄料和中厚面料	约34mm
较厚面料	约29mm

7-3. 剪线后面线残留长度的调节



1. 剪线时，线张力松弛，可以用夹线器[1]施加张力
2. 面线的正常残余量为35mm；若增加夹线器[1]的张力，切线后面线残留长度将会减少；减小张力，面线残留长度将会增加
3. 转动夹线器[1]进行调节
顺时针转动，面线残留长度变短
逆时针转动，面线残留长度变长

7-4. 挑线簧的调节



采用向线量调节器[1]穿过线的方法来调节挑线量

标准线量调整器[1]的使用方法
女士内衣规格以外

使线不穿过线量调整器[1]，松开固定螺钉[2]，将线量调整器[1]移向右侧
女士内衣规格

使线穿过线量调整器[1]，固定螺钉[2]被置于调整范围的中间状态时，就是线量调整器[1]的标准位置

挑线量的调节

使线穿过线量调整器[1]进行调节，越将线量调整器[1]向右移则挑线量越少

● 用女士内衣规格的缝纫机缝制厚布料时

● 要加长针迹等而挑线量不够时

使线穿过线量调整器[1]为较好的情况

● 使用帝特纶等易滑的机线时

● 缝制薄的布料时

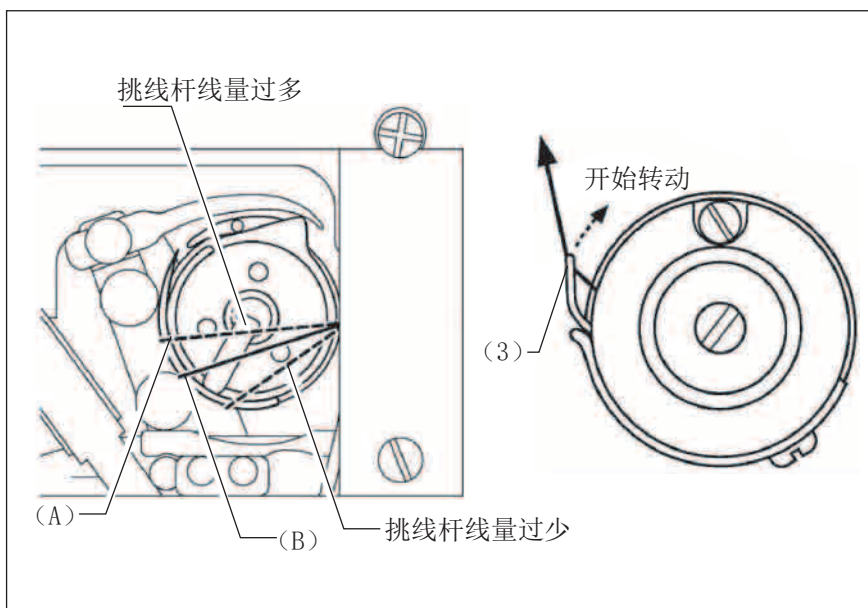
● 以2mm以下的针迹长度进行缝纫时

调整的基准
旋梭尖端补充上线环，使环移动到旋梭线量最大的点[A]的近前方[B]为止时，挑线簧[3]开始转动，这就是标准的挑线杆线量

● 如果挑线杆的线量很多，那么即使经过[A]，挑线簧[3]也不会开始移动，会造成跳针、断线、机线松紧不良

● 如果挑线杆的线量少，挑线簧[3]从[B]跟前开始移动，会造成断线、面线过紧、拉线

由于线的种类、布料的厚度、针迹的长度挑线杆需要的线量会改变，所以请根据缝制条件来进行调整



8. 保养

⚠ 注意



在开始清洁作业前，请切断电源。请在马达完全停止后，再进行操作

当误按动启动开关时，缝纫机动作会导致人员受伤



使用润滑油和黄油时，务必戴好保护眼睛和保护手套等，以防润滑油落入眼中或沾在皮肤上，这是引起发炎的原因

另外，润滑油或黄油不能饮用，否则会引起呕吐和腹泻

将油放在小孩拿不到的地方

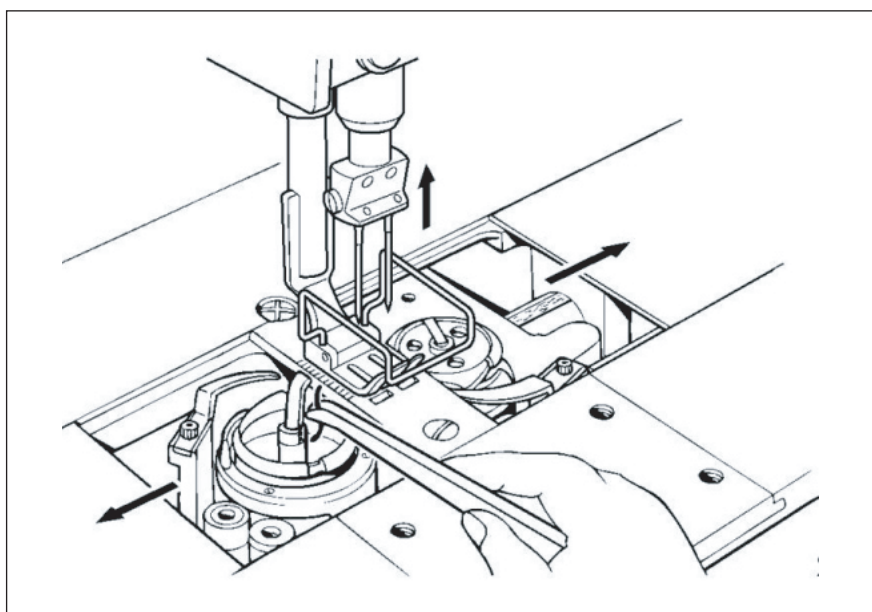


缝纫机头倒下或竖起时，请用双手进行操作

单手操作时因缝纫机的重量万一滑落易导致受伤

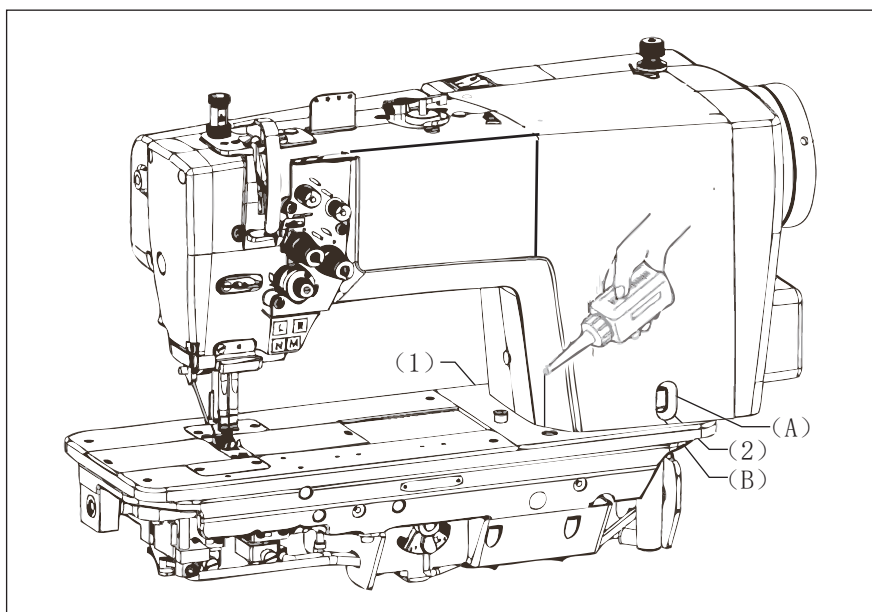
为了保持缝纫机的机能，而且能长久的使用，请每天保养。

另外，缝纫机如果长时间未使用，请在进行了如下的保养后再使用



保养

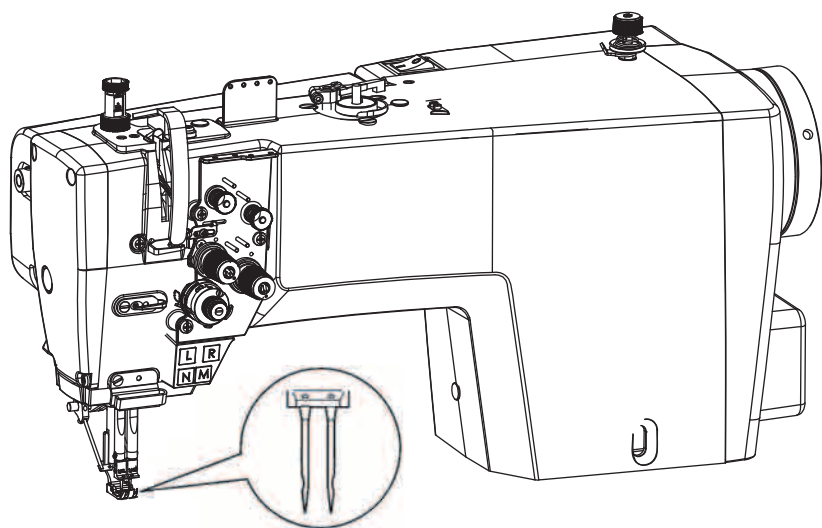
1. 转动手轮，将机针置于最高位置
2. 将左右推板按图示方向打开
3. 取出梭芯
4. 清除旋梭内的线头等杂物
5. 安装好梭芯和梭芯套
6. 左右推板恢复到以前位置



补充机油

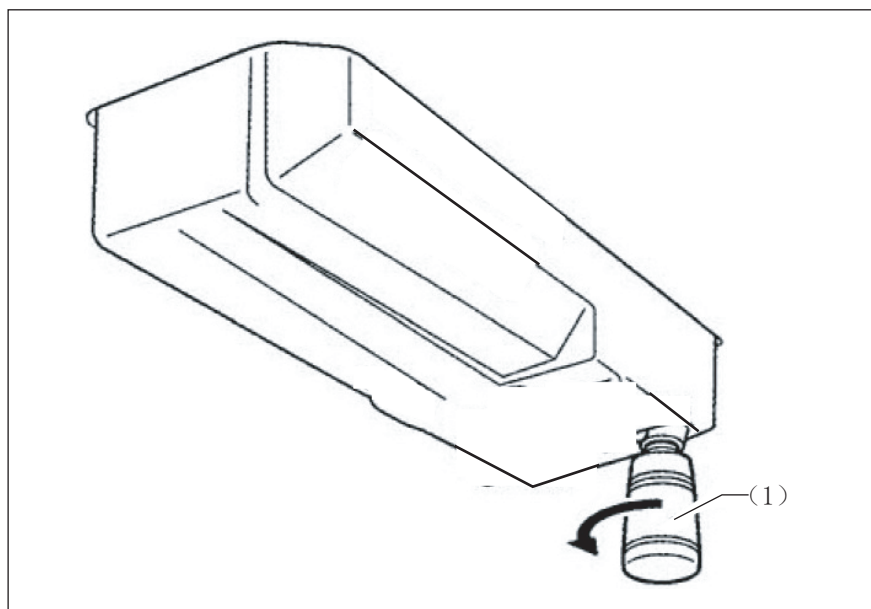
当润滑油的液位下降到油量表视窗[2]的下基线[B]以下时，应添加润滑油

1. 取出橡皮塞[1]
2. 向油盒里面注油，当润滑油的液位到达油量表视窗[2]的上基线[A]时，停止注入润滑油
3. 橡皮塞[1]装回原处



检查

1. 如果机针弯曲或针尖断裂，应予以更换
2. 检查上线是否穿引正确
3. 进行试缝



废油

1. 当集油器[1]内积满润滑油时，请拧松集油器[1]将它拆下，倒掉润滑油
2. 将集油器[1]拧入油盘

9. 旋梭供油量的调整

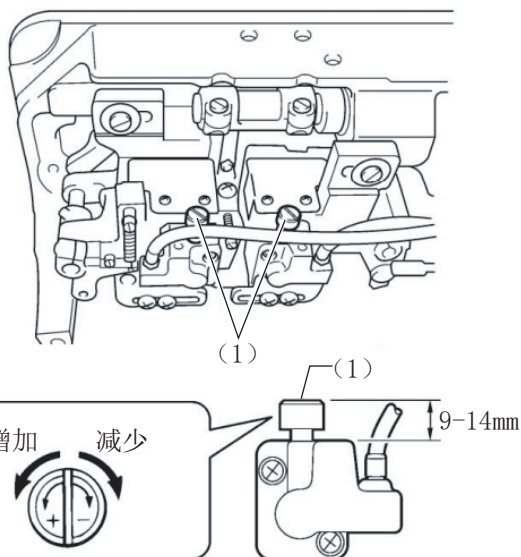


注意



当检查旋梭供油量时，手指和油量测试纸不能碰到旋梭和送布机构等运动零部件。
是导致人员受伤的原因

如更换了旋梭或要变更缝纫速度时，请按下述步骤调整旋梭的供油量



供油量调整的大致标准

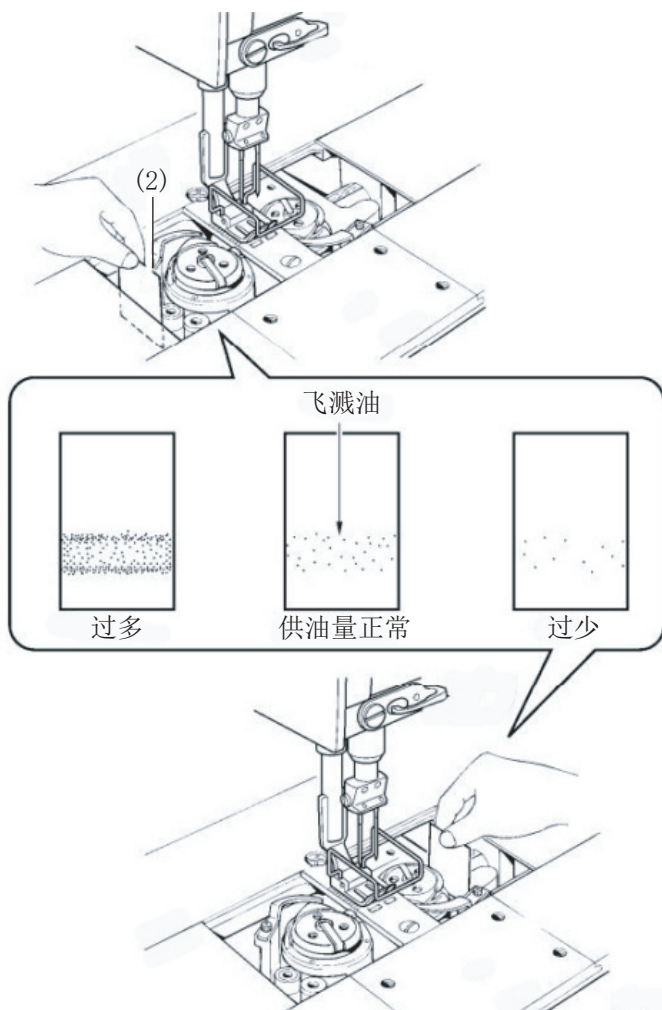
1. 将缝纫机头部倒下
2. 转动油量调节螺钉[1]，将其高度调整到9-14mm

供油量的确认

1. 切断电源开关
2. 拆去挑线杆至机针上的线
3. 取下机针和梭芯
4. 用压脚扳手将压脚抬起
5. 接通电源开关
6. 以缝纫机的实际缝纫时的转速进行约1分钟的空运转(适度的断续运转)
7. 将油量测试纸[2]插入旋梭的左侧(右侧是指旋梭的右侧)并握住以实际缝纫时的缝纫机转速使机器运转8秒(对油量测试纸[2]的纸质没有什么要求)
8. 确认飞溅到测试纸上的油量

供油量的调整

1. 将缝纫机头部倒下
2. 转动油量调整螺钉[1]，调整供油量
 - 向左转动油量调整螺钉[1]，油量增加
 - 向右转动油量调整螺钉[1]，油量减少
3. 参照上述[供油量的确认]所述来检查供油量
 - 请反复进行油量调整螺钉的调整及供油量的确认，直到获得适当的供油量为止
4. 在进行了约2小时的缝纫后，请再次检查供油量



10. 标准调整

! 注意



缝纫机头倒下或竖起时，请用双手进行操作。
万一单手操作时因缝纫机的重量而滑落可能导致受伤。



在必须接上电源开关进行调整时，务必十分小心，
遵守所有的安全注意事项



发生下列情况时，请切断电源，在马达完全停止后，再进行操作

● 进行检查、调整和维修时

● 更换旋梭等消耗零部件时



如果有的安全装置以卸下，务必在使用前重新将它们安装在原来的位置上，并检查是否正常使用



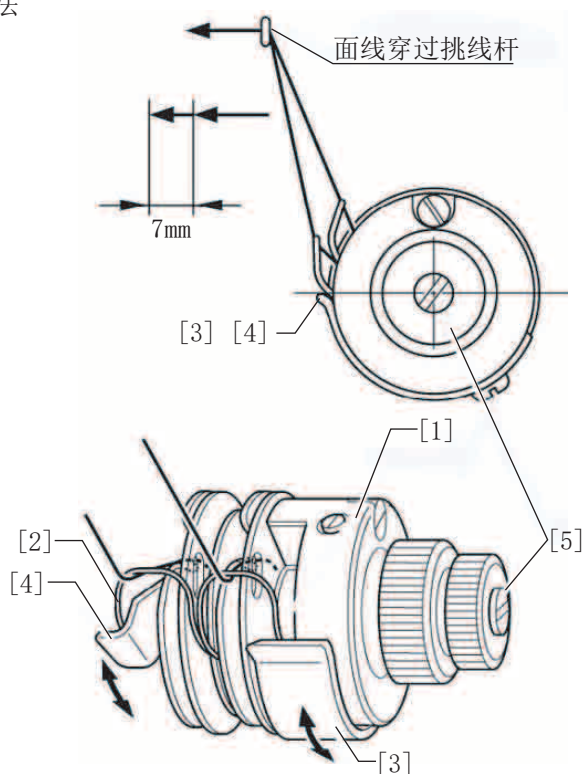
配电作业一定要请专业电工来进行



只有经过训练的技术人员才能进行缝纫机的维护检查

10-1. 挑线簧的挑线量

测试方法



挑线簧R[1]和L[2]的标准挑线量是7mm

挑线簧的调整是改变挑线量限位器油[3]和左[4]的高度在夹线轴[5]的中心状态时就是标准位置

调整方法

挑线簧的挑线量是挑线簧限位器的位置调得越高，挑线量就越少

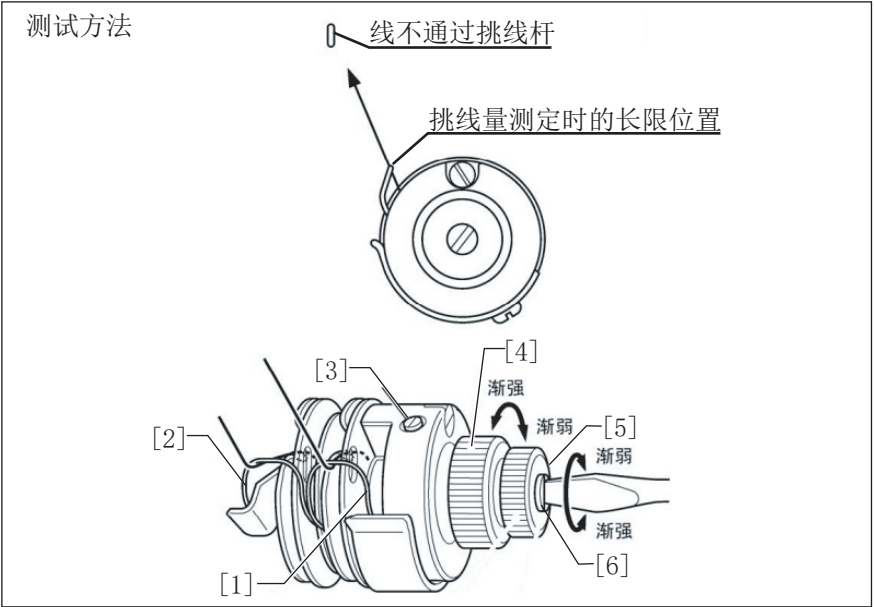
挑线簧限位器右[3]的高度[右线用]

1. 旋松螺钉[6]，滑动挑线簧限位器右[3]提高高度
2. 拧紧螺钉[6]

挑线簧限位器左[4]的高度[左线用]

1. 旋松螺钉[7]，滑动挑线簧限位器左[4]提高高度
2. 拧紧螺钉[7]

10-2. 挑线簧的强度



挑线簧R[1]和L[2]的标准强度规格如下

女士内衣用	0.25N
适用于较薄的和中厚的面料	0.34N
适用于较厚的面料	0.70N

调整方法

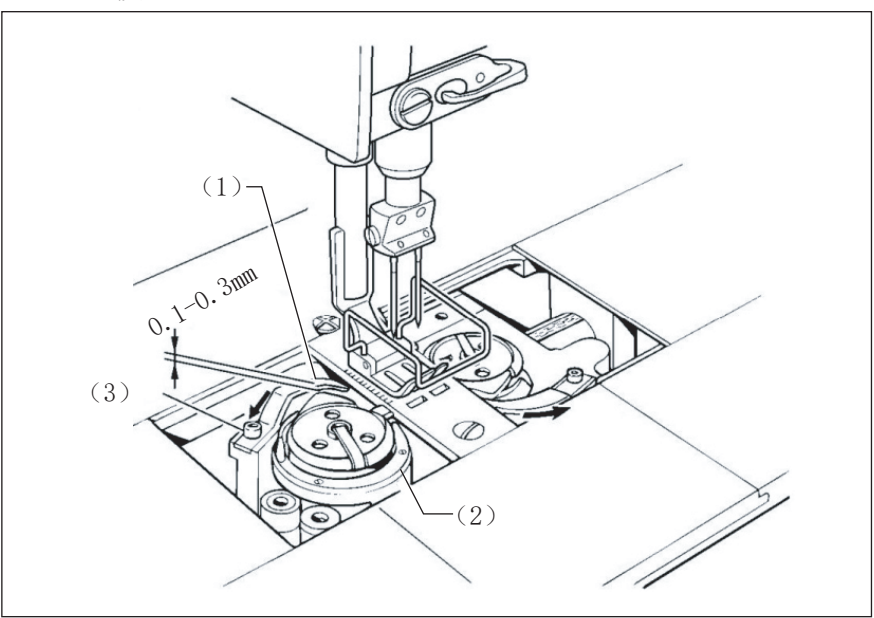
挑线簧R[1][右线用]

1. 旋松固定螺钉[3]，转动调节钮[4]进行调整
2. 拧紧固定螺钉[3]

挑线簧L[2][左线用]

1. 旋松夹线螺钉[5]
2. 用螺丝刀[小]转动夹线轴[6]进行调整
3. 拧紧夹线螺母[5]

10-3. 旋梭与分线勾的间隙



1. 分线勾[1]沿箭头方向拉满的时候，旋松固定螺钉[3]，将分线勾[1]左右调整使旋梭[2]和分线勾[1]的间隙为0.1-0.3mm
2. 拧紧固定螺钉[3]

注意

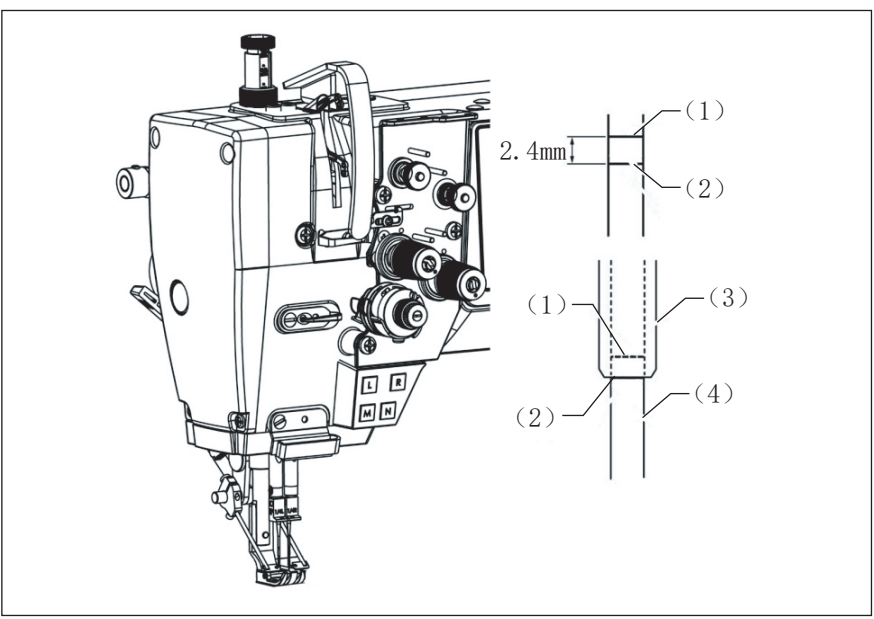
间隙过大的情况

- 可能发生面线切线错误
- 面线可能被切短

间隙过小的情况

- 会造成旋梭破损
- 会造成分线勾[1]的破损

10-4. 旋梭与机针的同步



转动手轮，使针杆[4]从最低点开始上升，直至针杆[4]的基线[2]与针杆支架[3]的下端对齐。此时，针杆上升量为标准位置

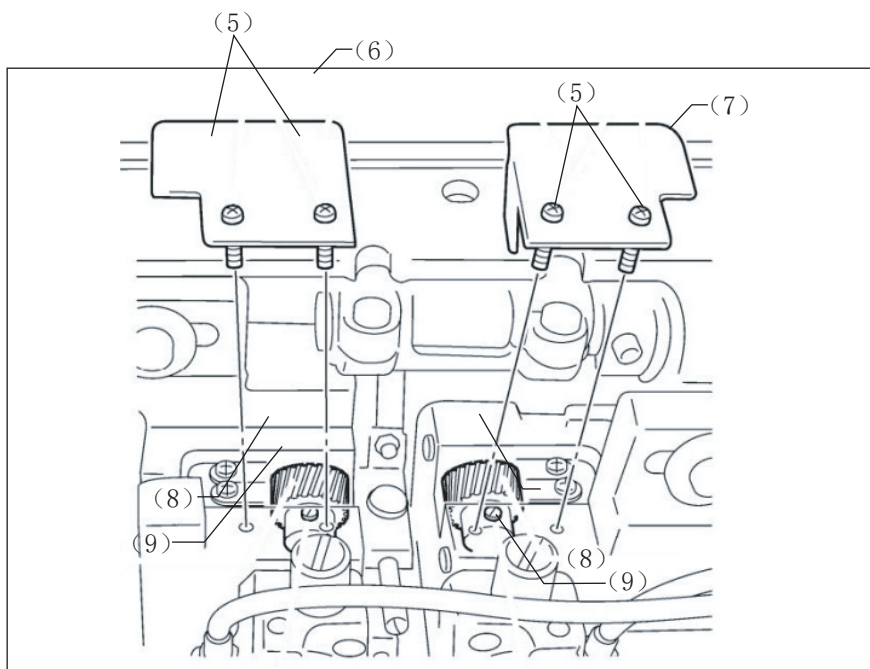
注意

针杆上升量过大会导致以下问题

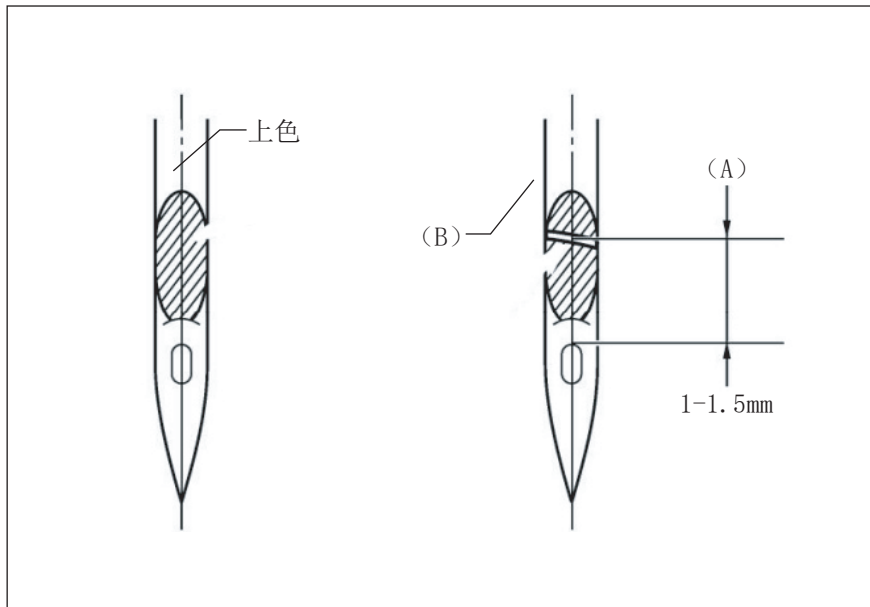
- 右边的线松紧不良
- 左右都会线迹不齐、跳针、断线
- 有时会面线切线错误或面线变短易脱线

针杆上升量过小会导致以下问题

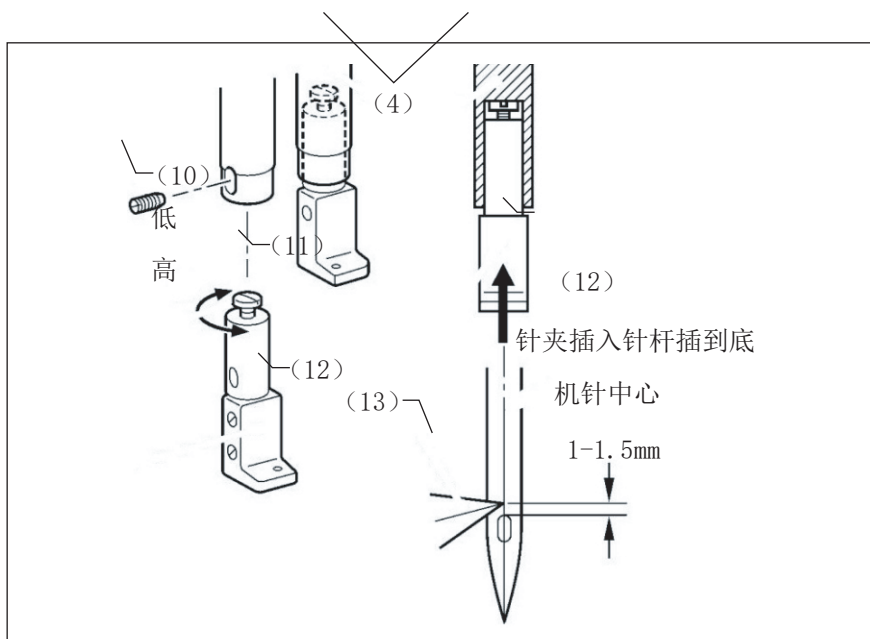
- 跳针、断线
- 切线后面线残留量变短



1. 旋松螺钉[5]，取下旋梭基座盖 FL[6]和FR[7]
2. 旋松固定螺钉[9][左右各3颗]，使小齿轮[8]能转动
3. 用手转动旋梭，使旋梭尖[13]对准机针的中心
4. 依次拧紧固定螺钉[9]

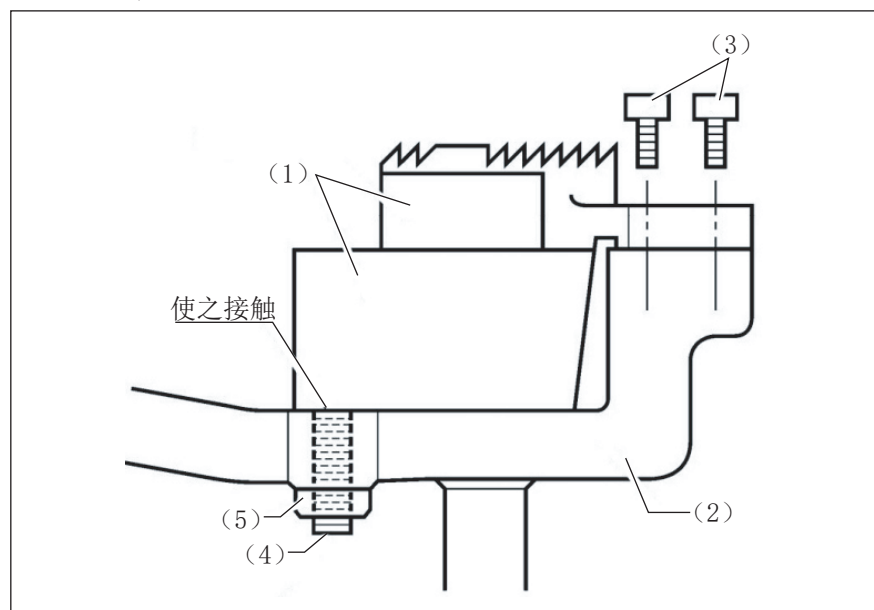


5. 将机针的凹槽处涂上颜色
6. 边转动手轮，边将机针推向旋梭尖[13]，在机针的槽部会留下旋梭尖端[13]痕迹



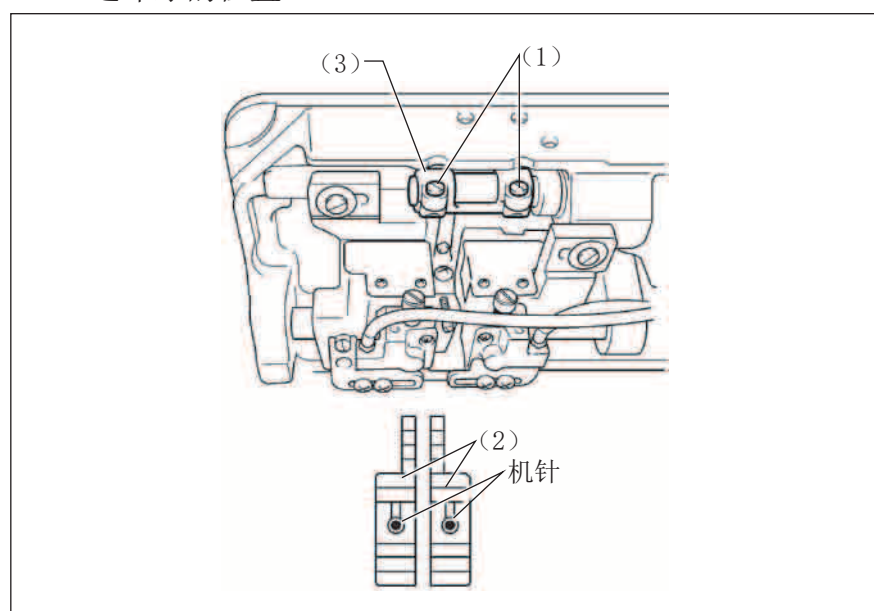
7. 旋梭尖端[13]的痕迹和机针中心线的交点到机针线孔上端的尺寸为1-1.5mm不是1-1.5mm时请旋松螺钉[10]，将针夹[12]拉下，旋转螺钉[11]进行调整。调整完成后，将针夹[12]尽可能深的插入针杆[4]孔内，并确保距离为1-1.5mm拧紧固定螺钉[10]

10-5. 送布牙的安装方法



1. 将送布牙[1]用螺钉[3]安装在送布台[2]上
 2. 拧紧送布牙基座的固定螺钉[4]，使其前端与送布牙[1]的下面接触
 3. 拧紧螺母[5]，固定螺钉[4]
- 不能将送布牙倾斜着用固定螺钉[4]安装

10-6. 送布牙的位置

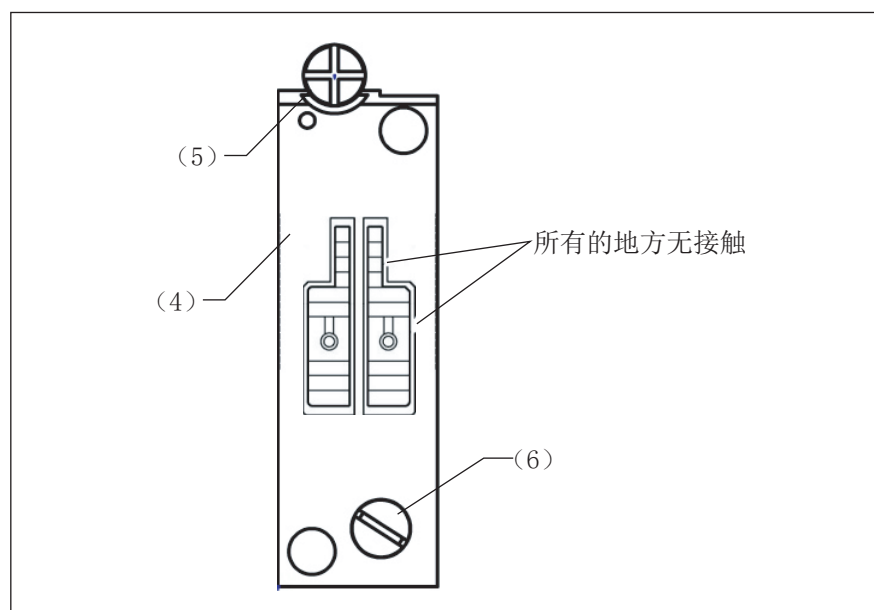


前后位置的调整

1. 旋松螺钉[1]
2. 转动水平送布台臂[3]进行调整，使机针位于送布牙[2]的针孔中心位置
3. 拧紧固定螺钉[1]

注意

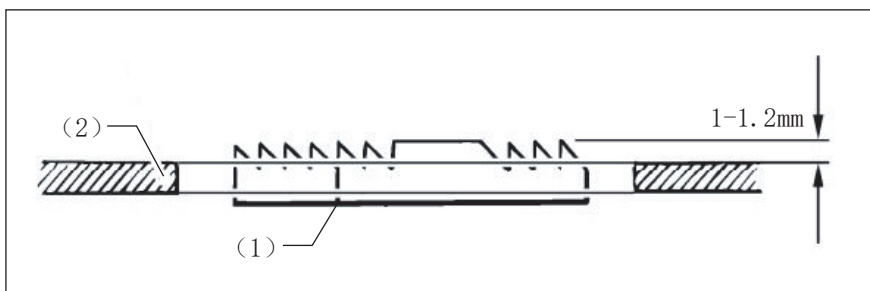
请不要过度拧紧螺钉[1]，会导致水平送布台臂[3]的损坏



左右位置的调整

将针板[4]用螺钉[5]和[6]固定在机壳上，使送布牙的各侧面与针板无接触针板与送布牙接触到的情况下，旋松螺钉[1]，左右移动水平送布台臂[3]进行调整

10-7. 送布牙的高度



转动手轮，送布牙[1]上升到最高位置，此位置进行调整，使送布牙[1]距针板上表面1-1.2mm

调整方法

1. 将缝纫机头部倾倒
2. 将螺钉[3]旋松一点，使送布台[4]能够滑动即可
3. 如图所示转动高度调节螺钉[5]，调节送布牙[1]的高度
4. 将螺钉[3]拧紧
5. 再次确认送布牙[1]的高度

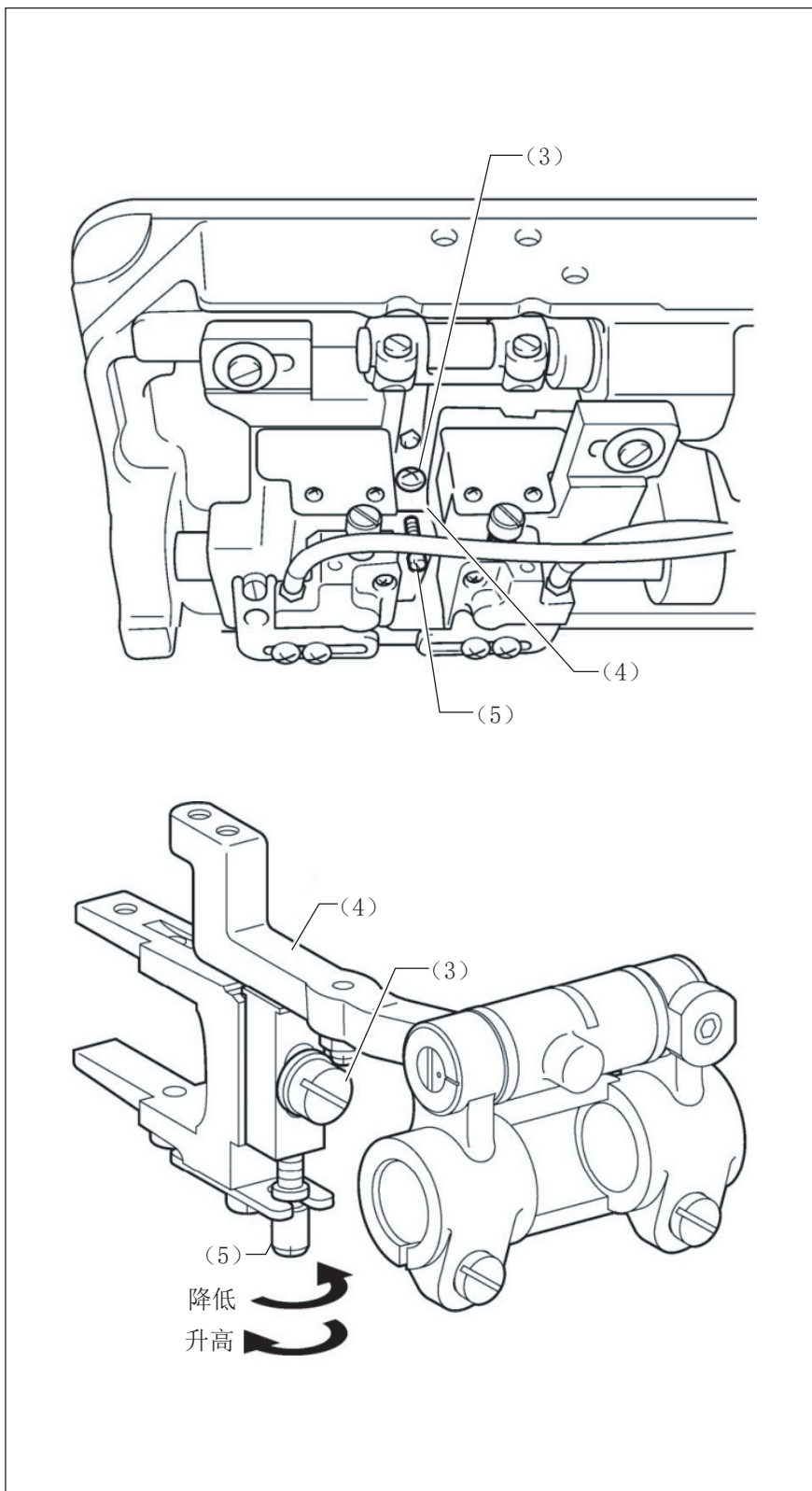
注意

送布牙过高的情况

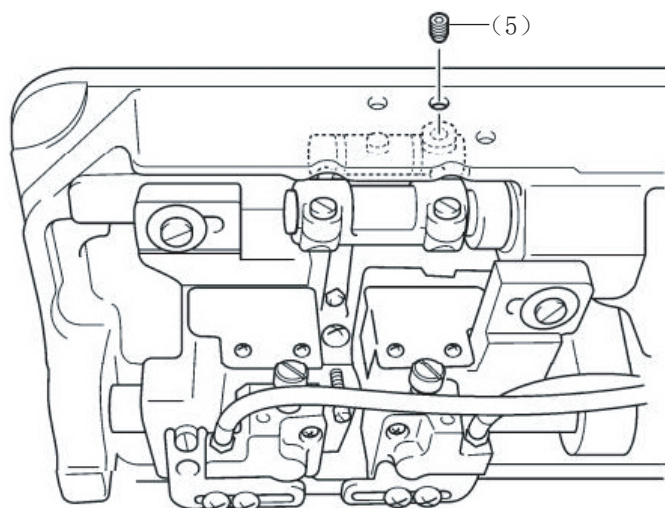
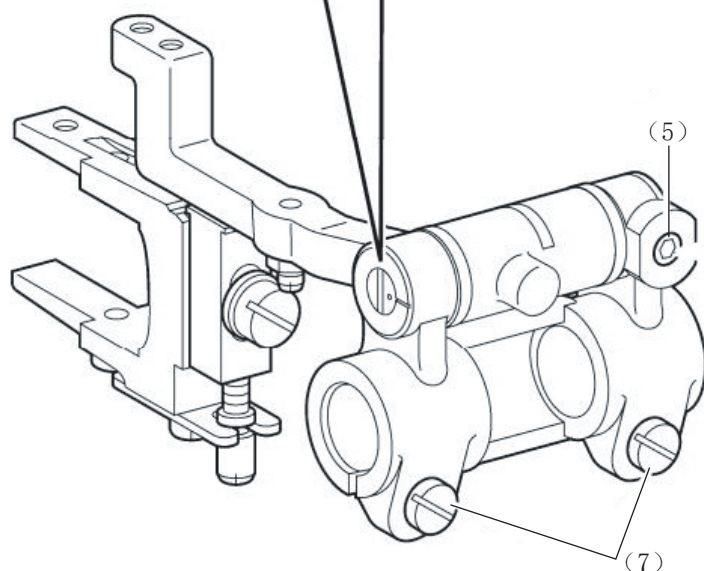
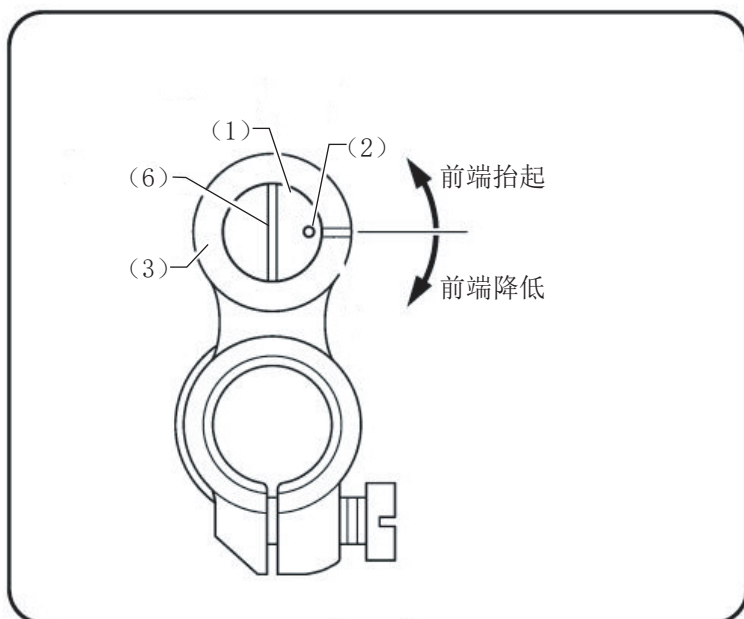
- 送布牙会碰到针板
- 线迹长度比实际针距长度大
- 用粗线时，线松紧不良
- 可能发生底线切线错误

送布牙过低的情况

- 线迹长度比实际针距长度大
- 送布牙和移动刀碰到
- 低速和高速缝纫的线迹长度差变大



10-8. 送布牙的倾斜



送布台安装轴[1]的配合标记[2]和水平送布台臂[3]的基线[4]一致的位置为标准

调整方法

1. 将缝纫机头部倾倒
2. 旋松固定螺钉[5]
3. 将螺丝刀伸入送布牙安装轴[1]的裂缝[6]转动并进行调整
4. 拧紧固定螺钉[5]

- 调整送布牙的倾斜，送布牙的前后位置发生变化，旋松螺钉[7]，将送布牙的前后位置以针位基准进行调整
- 此外，调整送布牙的倾斜的话，送布牙的高度也会发生变化，因此请重新调整送布牙的高度

11. 故障检修

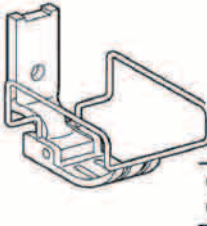
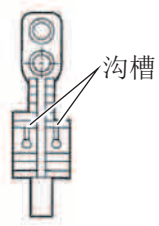
● 在要求维修或服务前，先检查以下各点

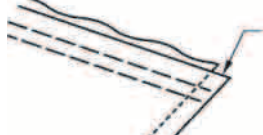
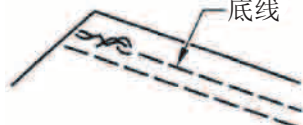
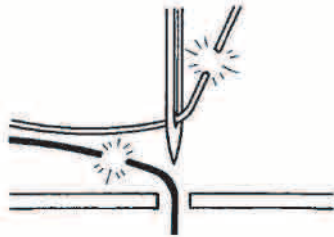
● 如果以下方法仍然不能解决问题，关闭电源开关，向受过训练的技术人员或经销商咨询

! 注意



当进行故障查寻之前，请先关闭电源开关并断开电源线。请在马达完全停止后，再进行作业。否则如果误按启动开关，缝纫机会动作，导致人身伤害

	现象	检查与调整
1	打开电源并踩下脚踏板时缝纫机不工作	• 断路器或保险丝是否已断开 • 电源线是否已脱开
2	面线不够紧密  底线不够紧密 	• 缝纫机线是否穿引正确 如果穿引不正确，应正确穿引机线 • 面线张力或底线张力是否太弱 调节面线张力或底线张力 • 取线弹簧的动作范围是否太小 降低取线弹簧止动器的位置 当使用中厚布料规格的缝纫机时，根据布料种类等的不同可能会出现缝线不够紧密的情况 在此情况下，请换上后面有间隙的压脚，或者换上带沟的送布牙齿  
3	布料下出现环结等不良 	• 线路是否不够光滑 用细粒锉刀或砂纸将线路打磨光滑 • 梭芯是否旋转流畅 拉出底线检查机线张力是否松弛，或更换梭芯或梭芯套 • 挑线量是否过多 调整挑线量
4	缝纫时出现跳针 	• 机针是否弯曲，针尖是否钝化 如果针尖弯曲或断裂，应予以更换 • 机针是否安装正确 如果机针安装不正确，应正确加以安装 • 缝纫机线是否穿引正确 如果穿引不正确，应正确穿引机线 • 压脚压力是否过小 调整压脚压力 • 挑线簧是否太弱 调整挑线簧的张力
5	缝纫开始时出现跳针 缝纫开始时出现脱线 	• 挑线簧张力是否过大 减小挑线簧张力 • 缝纫开始时，挑线杆是否在最高位置 缝纫开始时，请将挑线杆置于最高位置 • 从机针引线孔伸出的线头是否太短 缝纫开始时，请从引线孔将线头拉出约50mm • 挑线簧工作范围是否过大 升高取线弹簧止动器的位置

现象		检查与调整
6	线缝不平整 	• 压脚压力是否过小 调整压脚压力 • 送布牙高度是否太低 调整送布牙高度 • 梭芯是否有划痕 如果梭芯受损，用油磨石打磨光滑，或予以更换
7	大量的褶皱（张力过大） 	• 面线张力是否过大 尽量减小面线压力 • 底线张力是否过大 尽量减小底线压力 • 挑线簧张力是否过大 尽量减小挑线簧张力 • 挑线簧工作范围是否过大 尽量升高取线弹簧止动器的位置 • 压脚压力是否过大 调整压脚压力 • 挑线量是否过少 调整挑线量
8	线缝不合 	• 压脚压力是否过大 调整压脚压力
9	在缝纫开始时 底线纠结缠绕 	• 拉出底线时，梭芯旋转方向是否正确 安装梭芯，使其朝旋梭相反的方向旋转 • 梭芯上卷绕的机线是否过多 梭芯卷绕线量不应超过80% • 梭芯转动是否流畅 如果梭芯转动不流畅，应更换梭芯
10	面线和底线断裂 	• 机针是否弯曲或针尖是否断裂 如果机针弯曲或断裂，应予以更换 • 机针是否安装正确 如果机针安装不正确，应正确加以安装 • 缝纫机线是否穿引正确 如果穿引不正确，应正确穿引机线 • 面线或底线张力是否过小或过大 调整面线或底线张力 • 面线是否因挑线簧工作范围太小而松动 调整取线弹簧止动器的位置 • 旋梭、送布牙或其他部件是否受损 如果这些部件受损，用油磨石打磨光滑，或更换受损部件 • 线路是否受损 如果线路受损，用砂纸打磨光滑或更换受损部件 • 挑线量是否合适 调整挑线量

NOTES

This image shows a blank sheet of white paper with horizontal ruling lines. The lines are evenly spaced and run across the width of the page. There are no margins, text, or other markings on the paper.

Dealer:

The Texi logo, featuring a stylized purple flower icon followed by the word "texi" in a lowercase, italicized, purple serif font.