

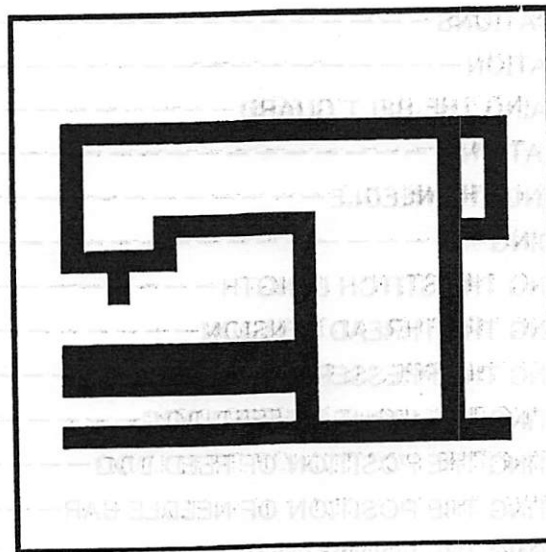
大 目

SEIKO

INSTRUCTION MANUAL

使用说明书

DCN 系列产品



SEIKO SEWING MACHINE CO., LTD.

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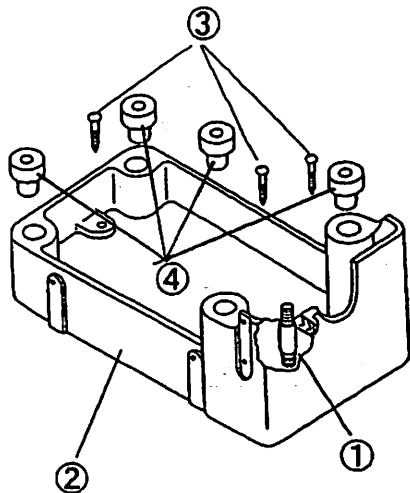
1. 规格

机 种	DCN系列产品
用 途	中厚料工作裤、牛仔裤、各种手袋皮包及松紧带
最高缝速	4,000 s.p.m.
最大针距	6.4mm
针杆行程	31.75mm
押脚高度	8mm
使用缝针	DV×57 #11~#25 标准 #22

1.SPECIFICATIONS

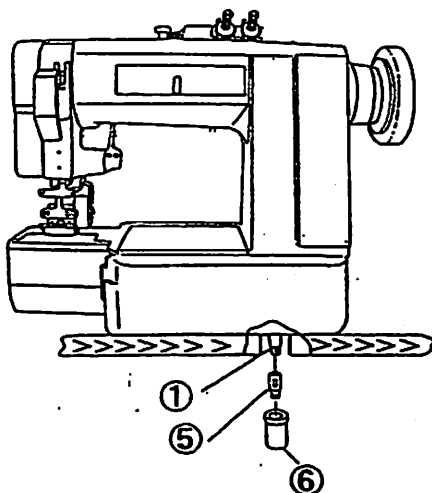
Model	DCN Series
Applications	For sewing heavy weight materials such as jeans, working wear,upholstery,tents,etc.
Sewing speed (max.)	4,000 s.p.m.
Stitch length (max.)	6.4mm
Needle bar stroke	31.75mm
Presser foot lift	8mm
Needle	DV × 57 #11~#25 Standard #22

2. 安装/INSTALLATION

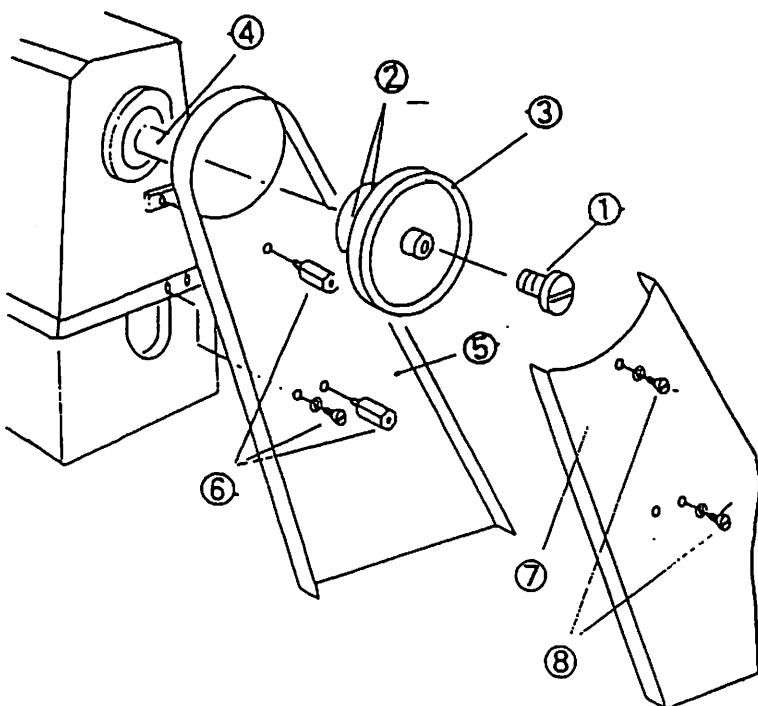


1. 将油管①安装在座架②上。
2. 用三个木螺丝将座架固定于台板上。
3. 座架下侧的四周按上4个橡胶垫子。
4. 将油管①通过接头⑤插入油瓶⑥内。

1. Assemble oil drain jar extension 'male' ① to machine base ② .
2. Place machin base on table with the three wood screws ③ .
3. Attach four machine cushions 'neoprene' ④ .
4. Connect oil drain jar extension 'femare' ⑤ and oiler ⑥ to oil drain jar extension 'male' ① .



3. 皮带罩壳的安装/Installing the belt guard



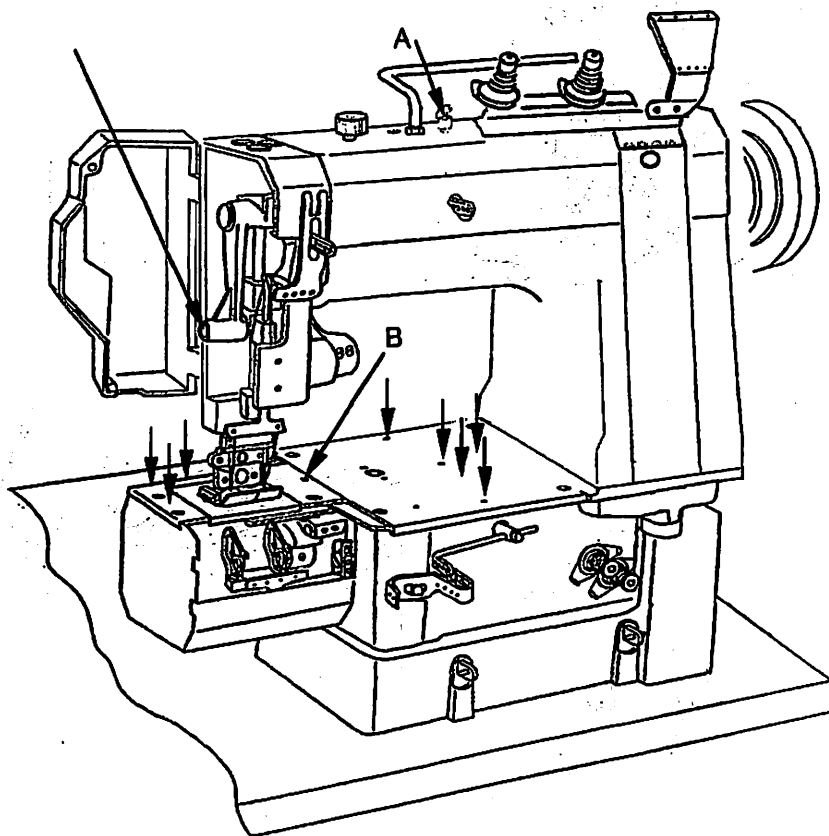
1. 卸下上轮压紧螺丝①。
2. 松开2个上轮固定螺丝②。
3. 从上轴④上卸下上轮③。
4. 将皮带罩装入上轴后、用2个螺丝②将上轮固定于V形槽内。
5. 将V形皮带装入上轮。
6. 用3个螺丝⑥将皮带护栏⑤固定住。
7. 最后用2个固定螺丝⑧将皮带罩⑦固定。

1. Remove screw ① from machine pulley.
2. Loosen two screws ②.
3. Remove the machine pulley ③ from shaft ④.
4. Put belt guard body ⑤ in shaft and then attach machine pulley to shaft by two screws ② at locking point (V groove) in shaft.
5. Place v-belt to machine pulley.
6. Fix belt guard body ⑤ by three screws ⑥.
7. Put belt cover ⑦ on belt guard body and fix it by two screws ⑧.

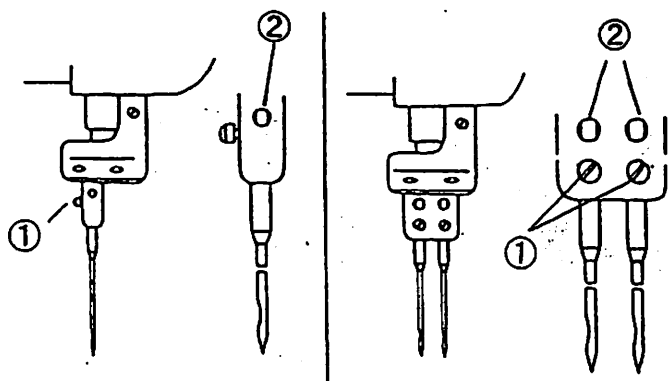
4. 加油/Lubrication

1. 缝纫机开始运转前、或长期闲置后重新使用时、请在各滑动部位加油。
2. 运转前必须按图上箭头所示部位各加上2-3滴润滑油。
3. 上轴的加油部位、请在上轮①的刻印"T"与机头指示点的交合处"A"处注油20-30滴。
4. 下轴的加油部位、使针杆上升至最高点、在基板的"B"处注油20-30滴。

1. The sewing machine should always be lubricated and supply replenished before it is used for the first, and also after long periods of non-use.
2. Add 1-2 drops oil in the indicated by arrows.
3. Lubrications to arm shaft : Supply 20-30 drops in "A" after setting the hallmark "T" of the pulley and point of the arm.
4. Lubrication to bed shaft : Supply also 20-30 drops to "B" after placing the needle at the lowest point.



5. 缝针的安装/Installing the needle

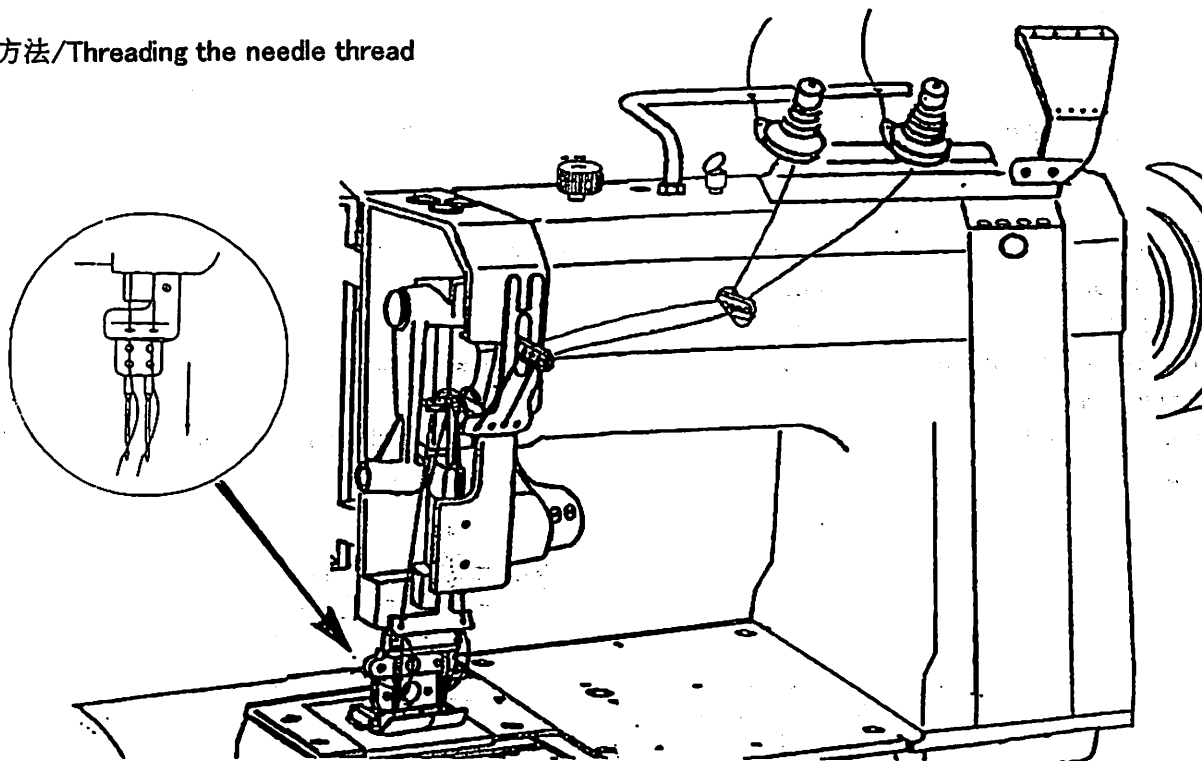


1. 转动上轮使针杆上升至最高点。
2. 松开缝针固定螺丝。
3. 将缝针凹部面向左侧插入针杆至顶部。
4. 拧紧缝针固定螺丝。

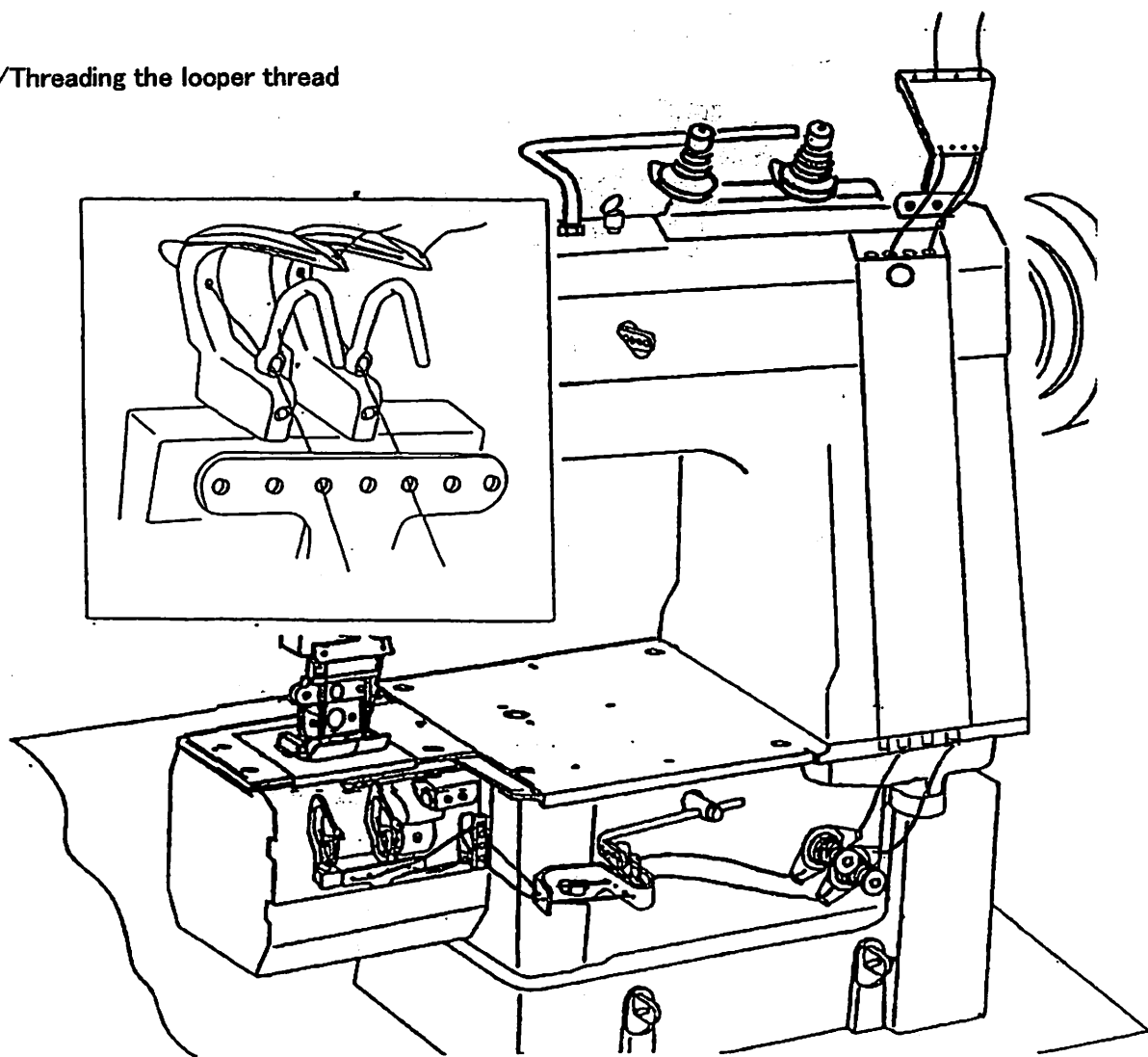
1. Turn machine pulley toward operator until the needle bar is at its highest point.
2. Loosen screw (1)
3. Insert needle into needle bar or clamp with leftward needle groove as far as it will go.
4. Set needle by screw (1).

6. 缝线的穿入方法/THREADING

1. 面线的穿入方法/Threading the needle thread



2. 底线的穿入方法/Threading the looper thread

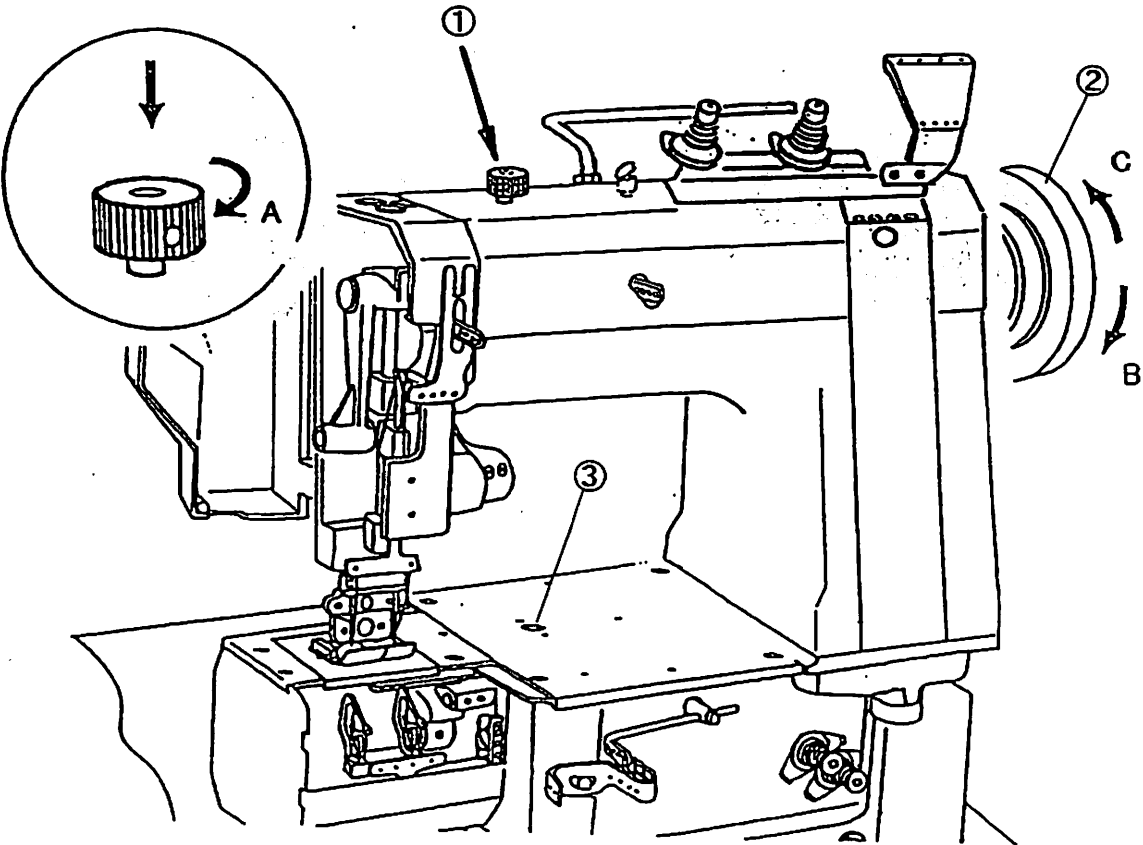


7.针距的调整/Adjusting the stitch length

- 1. 边按下针距调节按钮①、边向作业侧转动上轮②、确认当销子先端进入上送料凸轮槽内后、将调节按钮向"A"方向旋转90°。
 - 2. 按下基板中央部按钮③、确认将销子先端进入下送料凸轮槽内。
 - 3. 在这种状态下、将上轮②向"B"方向旋转时、针距增大;向"C"方向旋转时、针距变小。
 - 4. 当您调出所需之针距时、放开按钮向"A"方向旋转直至上送料调节按钮复归为止。
- (注)在上送料调节按钮①下降的状态下、缝纫机运转时、容易损坏其他的机构、所以必须在上送料调节按钮复归后方能使用。

上轮印记/Pulley mark	A	B	C	D	E	F
针距(mm)/Sutich length	6.4	4.9	3.4	2	1.2	1

- 1. Depress feed regulating plunger ①. Continue to hold plunger down and turn machine pulley ② toward operator until plunger enters notch in arm shaft eccentric. Then turn plungers 90 degrees to direction A. (locking position)
 - 2. Depress button ③ located in the center of machine bed until button enters notch in bed shaft eccentric.
 - 3. Hold down, and turn machine pulley ② toward direction B to increase length of stitch, or toward direction C to decrease length of stitch.
 - 4. When desired length is obtained, release the button and turn plunger ① toward direction A until it springs outward.
- Caution : Never operate machine with plunger ① in depressed position and wait until the depressed button recovers. Otherwise other mechansim will be broken.



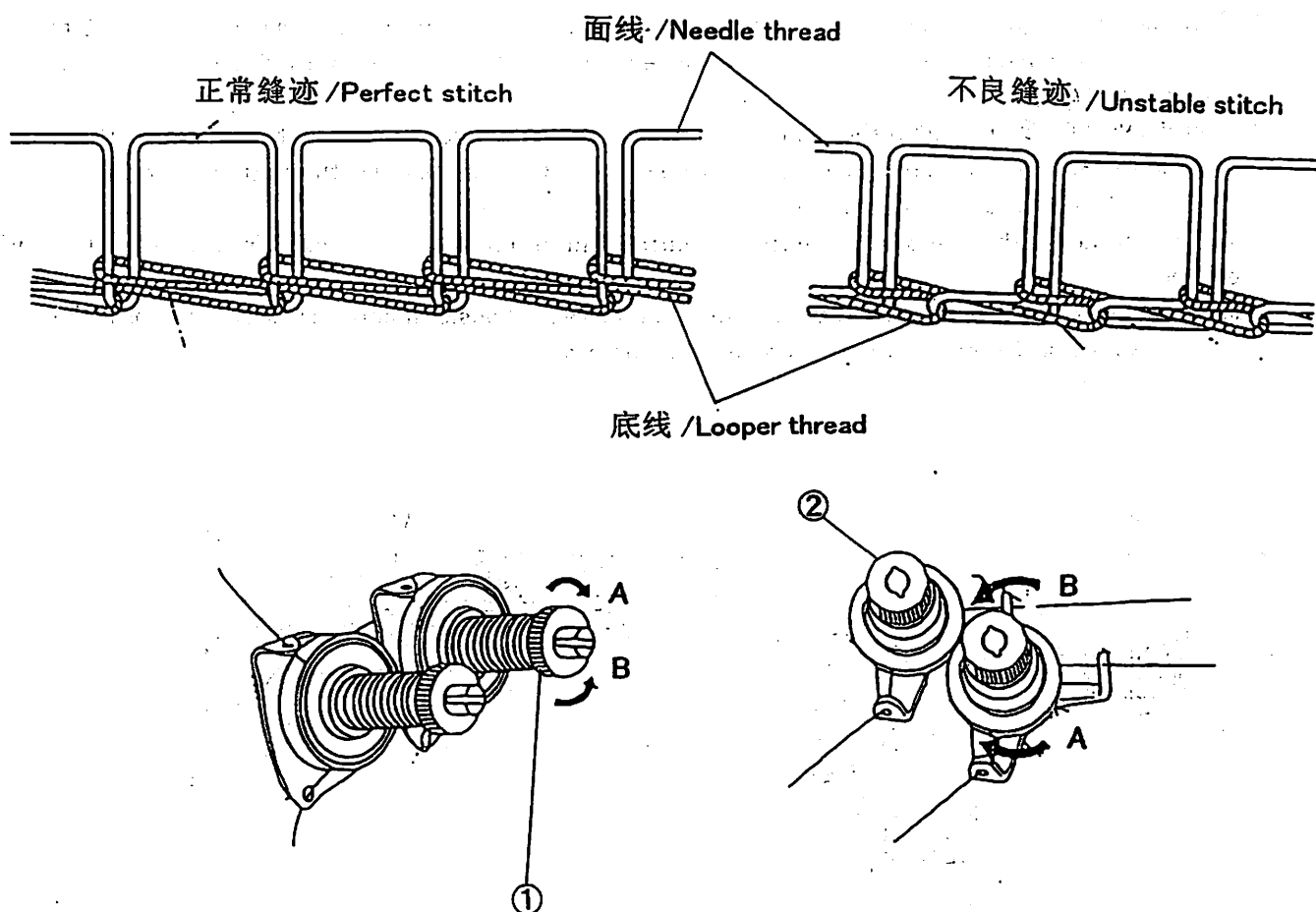
8. 调线板/Adjusting the thread tension

调线板根据缝制物、缝线等缝制条件的不同而有所变化、请根据情况进行调节。

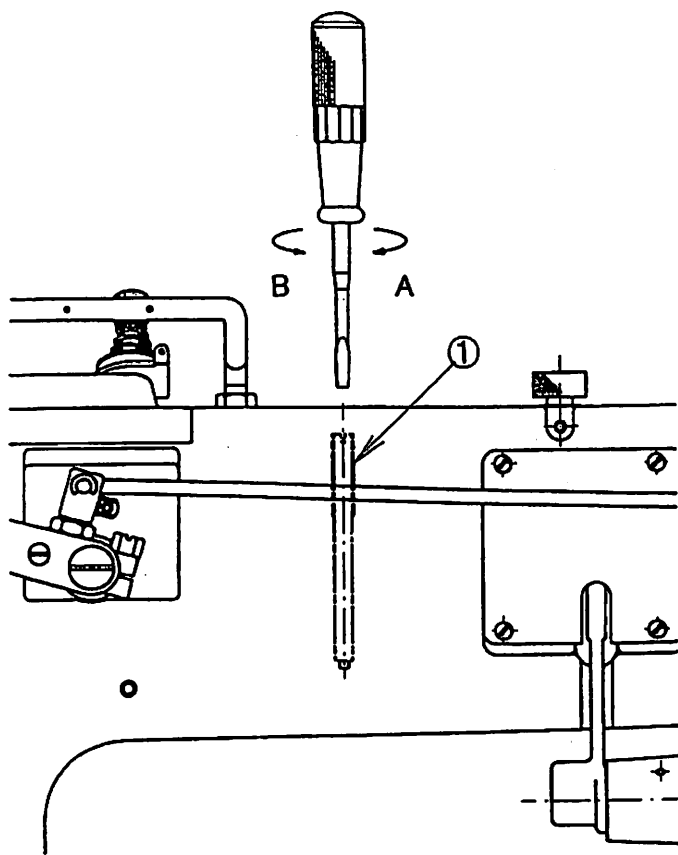
Thread tension should be adjusted at each operation, as it may be changed depending on sewing condition such as thread, material, etc.

1. 调线板用调线板螺母①、②进行调节。
2. 缝线调紧时、用调线板螺母①、②向"A"方向旋转、调松时向"B"方向旋转。

1. To change needle thread tension, turn nut ① and ②, as may be required.
2. Turn nut ① and ② toward direction A to obtain more tension or toward direction B to obtain less tension.



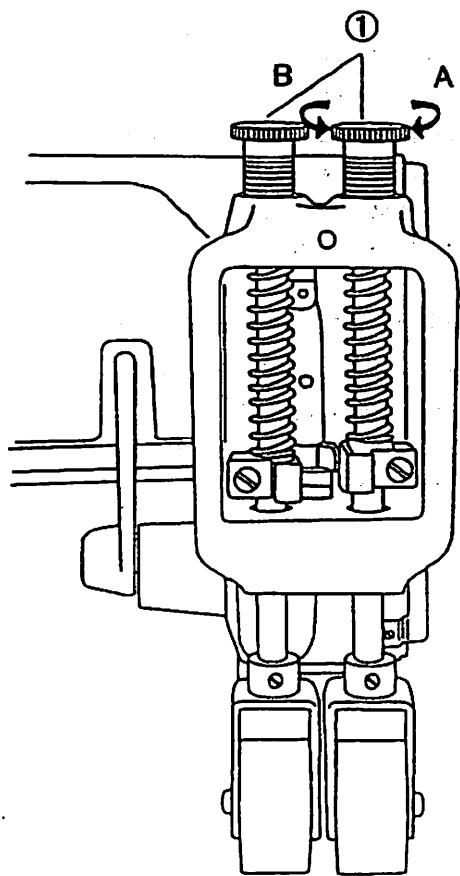
9. 押脚压力的调节/Adjusting the presser foot pressure



- 1. 押脚压力用调节螺丝①进行调节。
- 2. 压力加大时、调节螺丝①向"A"方向旋转、减弱时向"B"方向旋转。

- 1. Presser foot pressure is adjusted by thumb screw.
- 2. Turn adjust screw ① toward direction A to increase pressure and toward direction B to decrease pressure.

押轮压力的调节/Adjusting the roller pressure



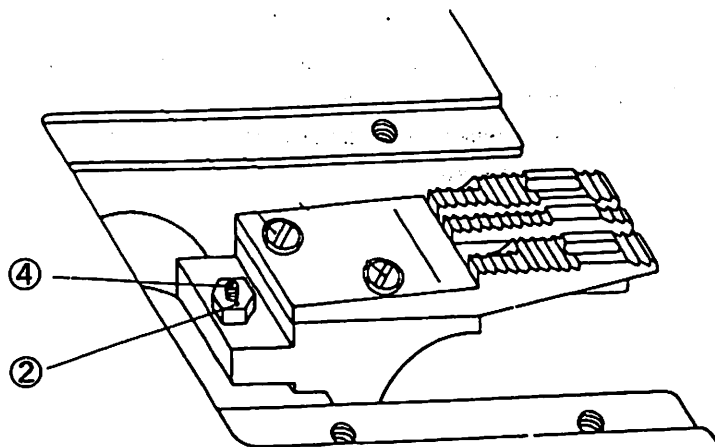
- 1. 押轮压力用调节螺丝①进行调节。
- 2. 压力加大时、调节螺丝①向"A"方向旋转、减弱时向"B"方向旋转。

- 1. Presser foot pressure is adjusted by thumb screw.
- 2. Turn adjust screw ① toward direction A to increase pressure and toward direction B to decrease pressure.

10.送布牙高度调整/Adjusting the height of the feed dog

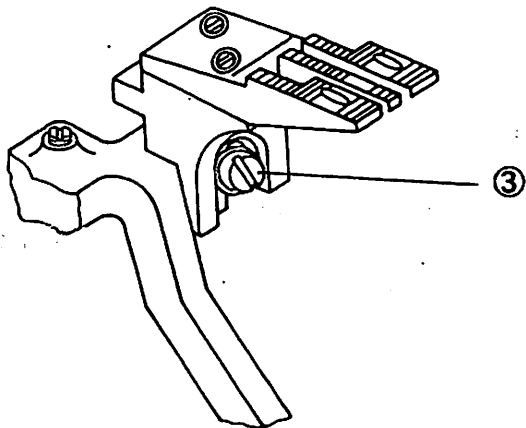
在针杆下降至最低点时、送布牙调整至高出针板1.0mm、并必须使送布牙与针板保持平行。

When the needle bar is at its lowest position, full depth of teeth should project 1.0 mm above upper surface of throat plate, and the top of the teeth should be parallel with throat plate.



■ 送布牙高度调整

1. 卸下针板。
2. 松开送布牙调节螺母②和送布架固定螺丝③
用送布牙调节螺丝④调节送布牙的高度。
如将送布牙向下调节,则可将送布牙向下轻押。
3. 高度调整后请拧紧送布架螺丝③和送布牙
调节螺母②。



■ 送布牙的水平调整

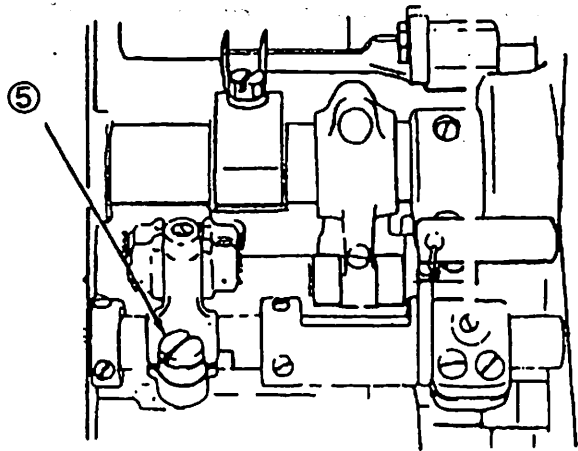
1. 倒下缝纫机头部。
2. 松开送料上下轴的连接螺丝⑤、调节送布牙
的水平位置。
3. 调节后拧紧连接螺丝⑤。

■ Setting the height of feed dog

1. To adjust the height, remove throat plate and
tilt machine back on its hinges.
2. Loosen nut ② and screw ③ and adjust feed dog
height by screw ④.
In lowering feed dog position, depress the
top surface of the teeth downward.
3. When correct height is obtained, tighten screw ③
and nut ② securely.

■ Setting the horizontal of feed dog

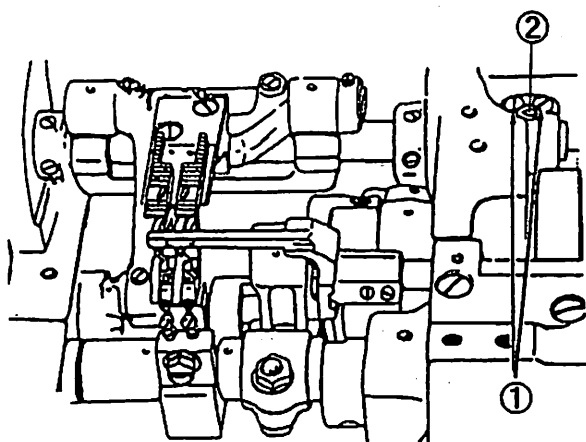
1. To obtain horizontal of feed dog, loosen screw ⑤
and make an adjustment.
2. When the feed dog position is set correctly,
pinch screw ⑤ securely.



11. 送布牙前后位置的调整/Adjusting the position of feed dog

转动上轮、在送布牙移动到最前面时(靠近作业侧)、请将针板和送布牙之间调整至1mm。

Turn the machine pulley, place the feed dog at the nearest position to operator and the clearance between throat plate and feed dog should be set at 1 mm.



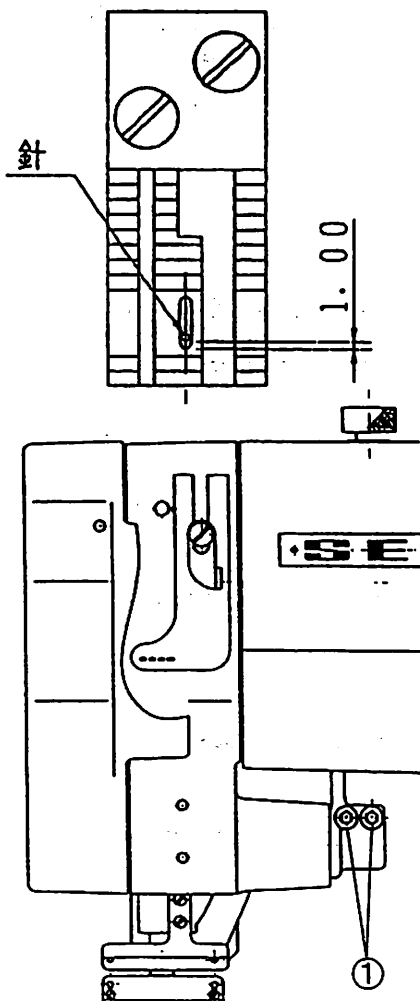
1. 用2个螺丝①和1个固定螺丝②调整针板与送布牙之间的间隙。
2. 调整后请拧紧螺丝①和固定螺丝②。

1. To adjust, move feed dog until it makes correct clearance between throat plate and feed dog by two screws ① and screw ②.
2. After the clearance is fixed, tighten two screws ① and screw ② securely.

12. 针杆前后位置的调整/Adjusting the position of needle bar

使上轮向作业侧转动, 缝针下降, 当针尖到达送布牙面之时、针侧面与送布牙孔(作业侧)之间调整至1mm。

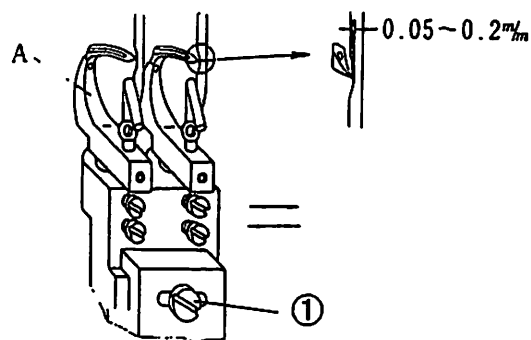
The standard clearance between the side of needle and the front of needle hole of feed dog should be 1 mm when turned machine pulley toward operator and the needle point reached above upper surface of feed dog.



1. 使上轮印记"A"与机头指示点重合(送量最大)。
2. 松开针杆台架固定螺丝①调整前后位置。
3. 调整后拧紧固定螺丝①。

1. Place together the letter "A" on machine pulley and arm point. (the longest stitch length)
2. Loosen screw ① and move needle bar forward or backward until correct position.
3. After the needle bar is fixed, tighten screw ① securely.

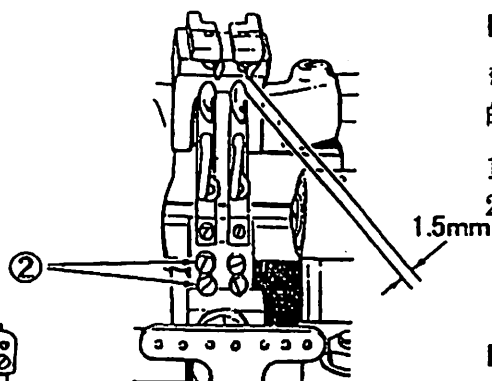
13. 弯针的调整/Adjusting the looper position



■ 弯针与缝针的间歇

弯针与缝针的间歇、从缝针凹部至弯针尖部的间歇调整至0.05~0.2mm为标准。

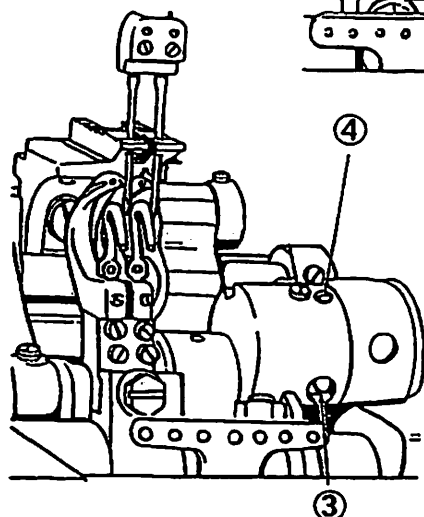
1. 松开弯针固定螺丝①、调整间歇。
2. 调整后、拧紧固定螺丝①。



■ 弯针与制圈架的间歇

弯针在(作业侧)摇动时、弯针的右侧与制圈架的间歇调整至1.5mm为标准。

1. 松开2个弯针固定螺丝②、调整间歇。
2. 调整后、拧紧固定螺丝②。



■ 弯针的摇动位置

弯针的前后运动、位置调整方法、使上轮向作业侧转动、弯针运动至最前方时和复归时、这时缝针与弯针尖的交叉位置正好在缝针凹部通过。

1. 松开弯针凸轮的固定螺丝③、和2个弯针凸轮的调节螺丝④、调整弯针的位置。
2. 调整后拧紧固定螺丝③和④。

■ Clearance between looper and needle

The standard clearance between groove of needle and looper point should be 0.05~0.2mm.

1. To adjust looper position, loosen screw ① and move looper holder to get correct clearance.
2. Tighten the looper holder screw ① securely

■ Clearance between looper and loop deflector

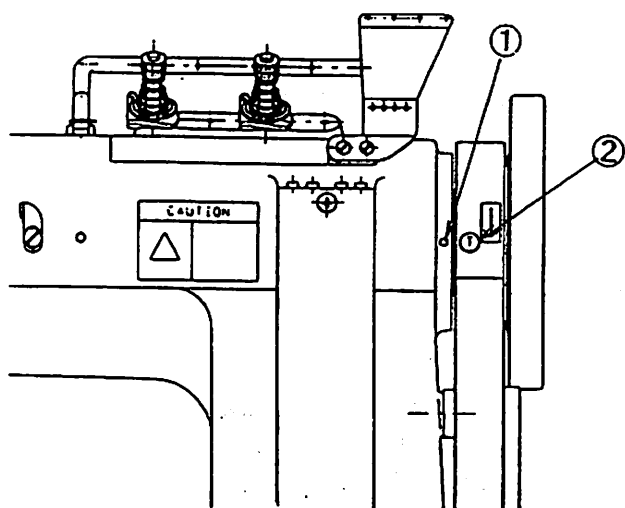
The standard clearance between right side of loopers and loop deflector should be 1.5mm when loopers are in front position.

1. To adjust clearance, loosen two screws ② and move loopers until correct position.
2. After loopers are fixed, tighten two screws ② securely.

■ Looper position for back and forward movements

When pulley is turned toward the operator, looper point should pass the same position in groove of needle during forward and backward movements of looper.

1. To make this adjustment, loosen screw ③ and, then change the position of looper can by adjusting the tightness of two screws ④.
2. Tighten screw ③ and screws ④ securely.



■ 弯针的前后调整

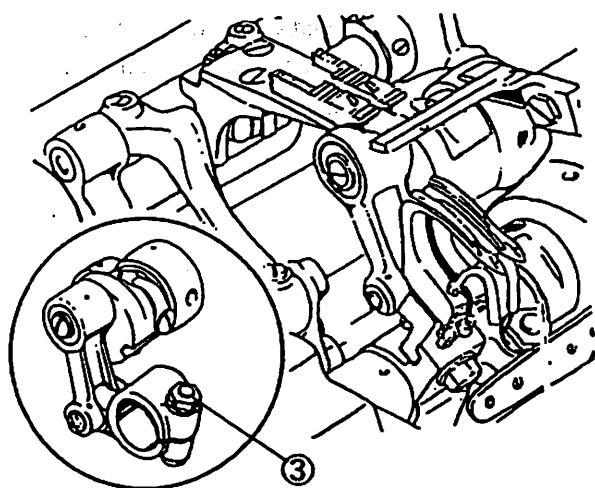
上轮向作业侧转动、当上轮印记"T"②与机头指示点①重合时、弯针尖端正好与缝针中心重合。

1. 松开弯针连结螺丝③、调整弯针尖端的位置。
2. 调整后、拧紧连接螺丝③。

■ 针架的调整

上轮向作业侧转动、弯针尖端在距缝针中心2.5mm位置时、缝针与针架轻触、但调整至缝针碰不上弯针。

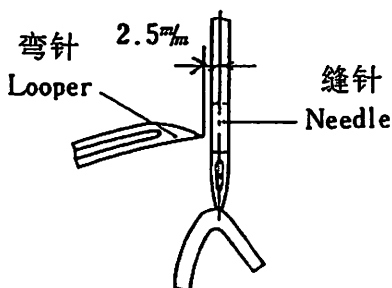
1. 松开针架固定螺丝④、⑤、将缝针与针架调整至轻触位置。
2. 调整后、拧紧针架固定螺丝④、⑤。



■ Lengthwise setting of looper

When timing mark "T" ② on machine pulley and the arm point ① on the arm is placed together the looper point should be directly opposite the center of the needle.

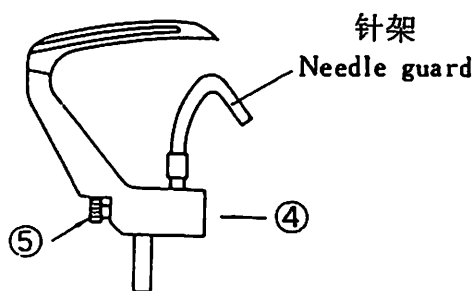
1. To adjust the position, loosen screw ③ and move the looper forward or backward until looper point is directly on the opposite of needle center.
2. Tighten screw ③ securely



■ Setting of needle guard position

When needle guards are properly set, they touch needles slightly at the position of 2.5 mm before looper point reaches the center of the needle on their forward strokes when machine pulley is turned toward operator.

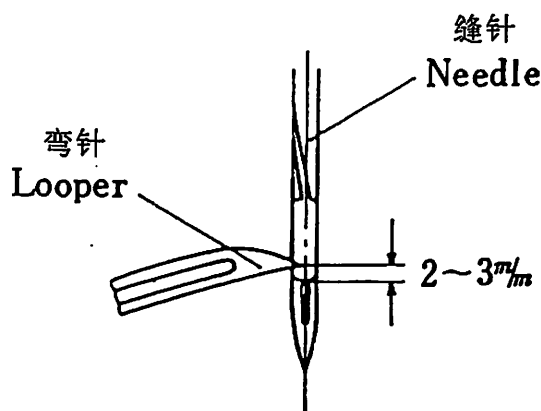
And needles should pass loopers closely, but without touching.



1. To adjust, loosen needle guard set screws ④、⑤ and turn needle guards until correct positions are obtained.
2. Tighten set screws ④、⑤ securely.

14.针杆高度的调整/Adjusting the height of needle bar

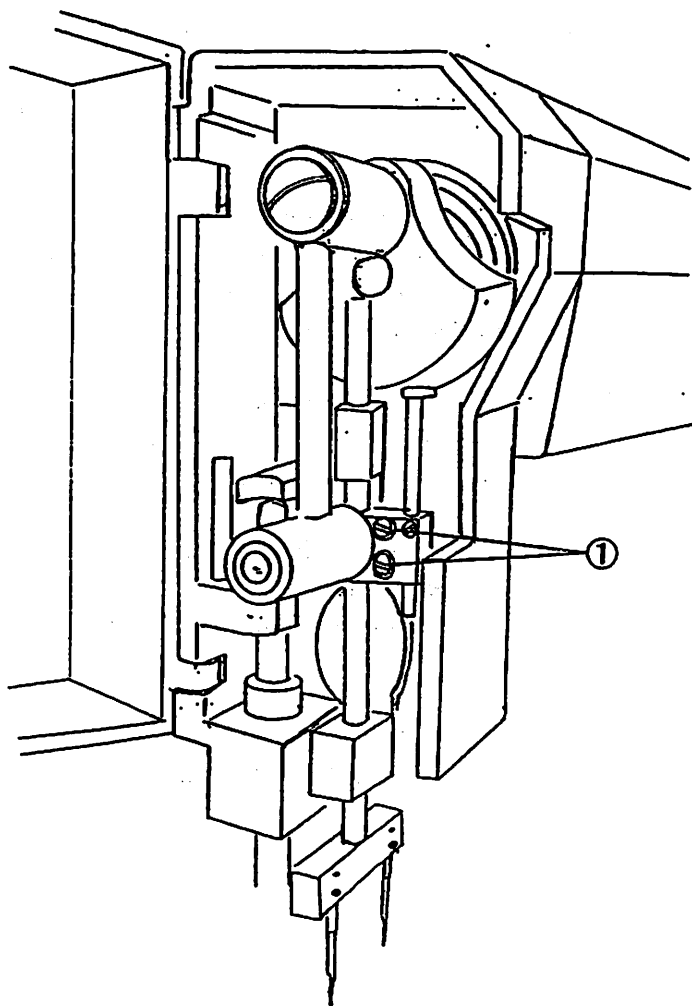
弯针位置决定后、针杆对弯针的高度、掌握在弯针尖端位于缝针针孔上方2~3mm位置。



1. 打开面板、松开2个针杆架固定螺丝①、调整针杆的高度。
2. 调整后、拧紧固定螺丝①。

After looper position is fixed, the height of the needle bar against looper should be positioned so that upper side needle eye comes 2 – 3 mm above looper point.

1. To adjust, open face plate and loosen two screws ① and move needle bar to correct position.
2. Tighten two screws ① securely



15.送布牙制圈架的调整/Adjusting the loop deflector

■ 制圈架左右方向的调整

使上轮向作业侧转动、当弯针运转至前方时按装在送布牙下侧的制圈架左侧面至缝针右侧面的间歇调整至0.5mm~1.0mm。

■ 制圈架前后方向的调整

缝针在最低点时、制圈架尖端应露出缝针0~1.0mm左右。

- 1. 松开2个制圈架固定螺丝①、调整制圈架的前后、左右位置。
- 2. 调整后、拧紧固定螺丝①。

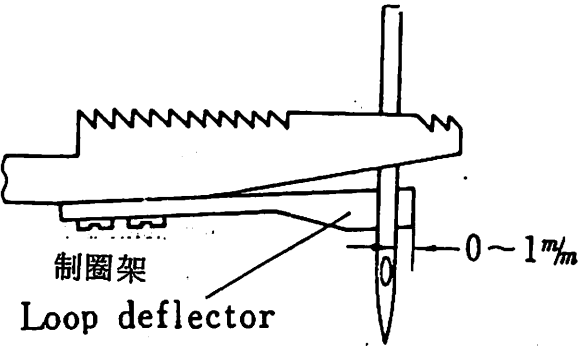
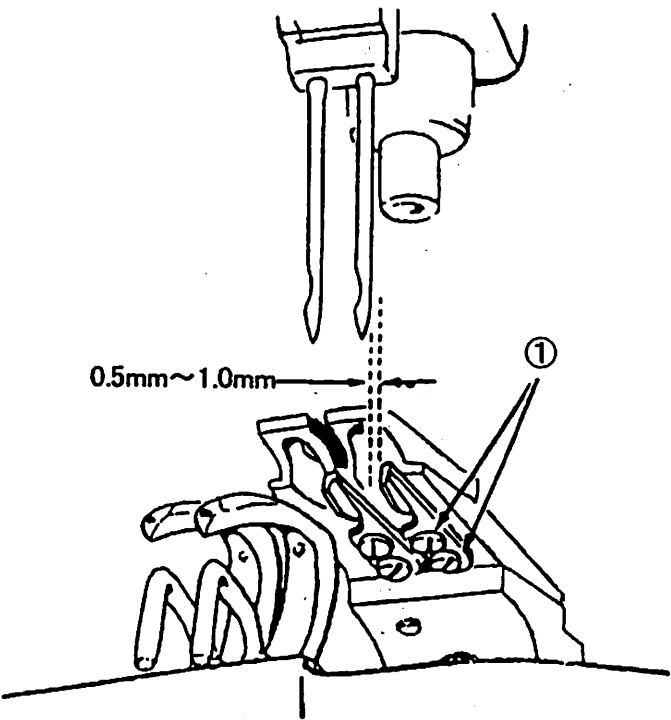
■ Sidewise positioning

When loop deflector is positioned correctly, there should be a clearance of 0.5 – 1.0 mm between the left side of loop deflector, located on underside of feed dog, and right side of needle, when loopers are at their extreme forward positions on their forward strokes.

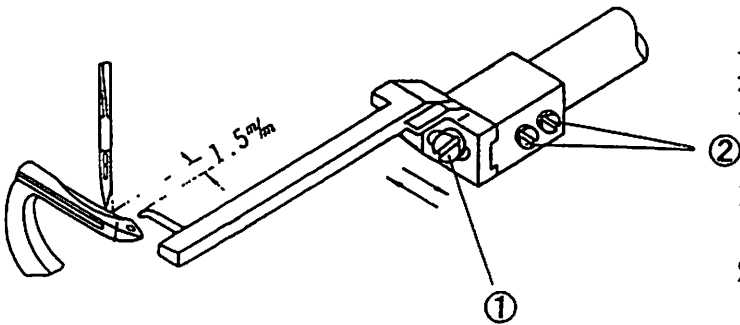
■ Lengthwise positioning

The top of loop deflector should be 0 – 1.0 mm above upper the side of the needle when needle is at its lowest position.

- 1. Loosen two loop deflector screws (1) and move deflectors until correct positioning is obtained.
- 2. Tighten the two screws (1) securely



16.拉线各部的调整/Adjusting the spreader



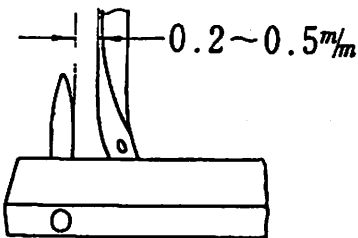
■ 拉线爪的前后方向调整

上轮向作业侧转动,使针尖下降至弯针上面,这时,缝针侧面至拉线爪先端之间的间隙应调整至1.5mm。

1. 松开固定拉线爪的螺丝①,调整其前后位置。
2. 调整后,拧紧固定螺丝①。

■ 拉线爪的左右方向调整

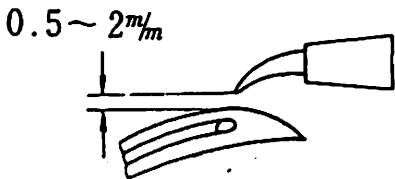
转动上轮,当拉线爪运转至最左侧时,拉线爪与弯针左侧面的间隙应调整为0.2~0.5mm。



■ 拉线爪的上下方向调整

拉线爪通过弯针的间隙调整为0.5~2mm。

1. 松开2个拉线爪座架的固定螺丝②,调整左右的位置。
2. 调整后,拧紧固定螺丝②。



■ Lengthwise positioning

When the point of needle on its downward stroke reaches upper surface of looper, the clearance between side of needle and spreader point should be 1.5 mm.

1. To adjust, loosen set screw ① and move spreader forward or backward to get correct position.
2. Tighten set screw ① securely.

■ Sidewise positioning

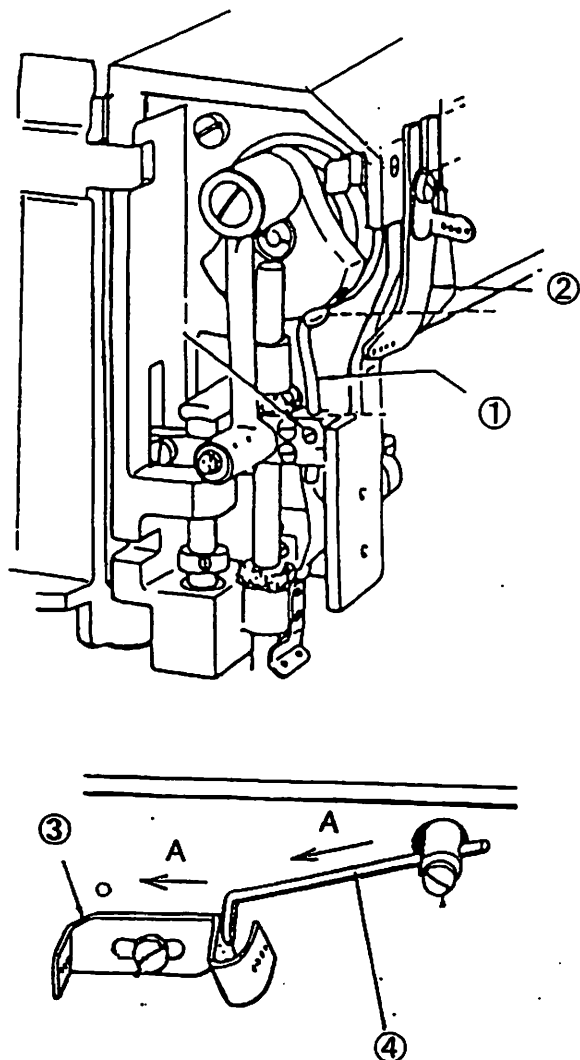
Turn machine pulley and make clearance between spreader point and left side of looper 0.2 - 0.5 mm when spreader point reaches its left side end.

■ Height setting

The spreader point should pass above upper side of looper at the clearance of 0.5 - 2 mm

1. To adjust, loosen two screws ② and move spreader upward or downward to get correct position.
2. Tighten two screws ② securely.

17.穿线架的调整/Adjusting the thread guide



■ 面线穿线架的调整

面线拉出的线量太多时,使天秤①上升,面线穿线架②下降。

面线拉出的线量不够时,则相反。

■ 底线穿线架的调整

底线拉出的线量太多时,使底线道③和底线天秤④向A方向移动。

底线拉出的线量不够时,向相反方向移动。

调整后,拧紧各部螺丝。

■ Adjusting the needle thread guide

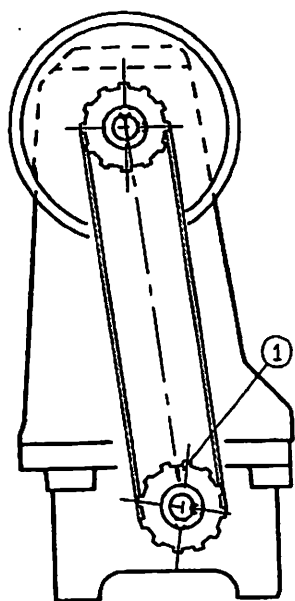
To increase the amount of thread drawn at the top of the needle bar stroke, raise take-up ① or loosen guide screw and lower the guide ②.

To decrease the amount, reverse the adjustment by lowering the take-up or raising the guide.

■ Adjusting the looper thread guide

To increase the amount of thread, loosen looper thread guide screw and looper thread take-up rod screw. And move thread guide ③ and take-up rod ④ to the left. To decrease the amount, reverse the adjustment by moving thread guide and take-up rod to the right.

18.同步皮带的安装/Adjusting the timing belt



1. 将上轮向作业侧转动,使针杆上升至最高点。
2. 转动下轮,将下轮箭头刻印处对准上轴方向。
3. 这时,请将同步皮带套在上轮和下轮上。

1. Turn machine pulley toward operator until needle bar is at its highest point
2. Turn safety clutch pulley toward arm shaft until allow mark on safety clutch pulley is directly opposite the rim on the machine bed.
3. Assemble timing belt to arm and safety clutch pulley.

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