

全自动模板机

AUTOMATIC MOLD SEWING MACHINE

使用说明书

OPERATION MANUAL

浙江中捷缝纫科技有限公司
ZOJE SEWING MACHINE CO., LTD.

使用 说 明

INSTRUCTION MANUAL

为使您正确使用本机,须对本机的各种功能充分了解,以便安全操作。

To get the most out of the many functions of this machine and operate it in safety,it is necessary to use this machine correctly.

使用前请仔细阅读使用说明书,我们希望您能长期愉快地使用本机,请保存好说明书,以备查阅。

Please read this Instruction Manual carefully before use.We hope you will

enjoy the use of your machine for a long time.Please remember to keep this

manual in a safe place.

1. 无论您何时使用本机,须了解基本的安全事项,包括但不限于下列事项。

Observe the basic safety measures,including,but not limited to the following ones, whenever you use the machine.

2. 通读所有说明,并保存好使用说明书。如果需要,请随时翻阅。

Read all the instructions, including, but not limited to this Instruction Manual before you use the machine,in addition, keep this Instruction Manual so that you may read it at anytime when necessary.

3. 使用本机前,必须弄清与本机有关安全规定、标准在您的国家是否适用。

Use the machine after it has been ascertained that it conforms with safety rules/standards valid in your country.

4. 使用本机前或使用本机时,所有安全装置必须配备齐全。机器运转时,无安全装置属违章操作,决不允许。

All safety devices must be in position when the machine is ready for work or in operation The operation without the specified safety devices is not allowed.

5. 操作人员必须经过适当的培训。

This machine shall be operated by appropriately-trained operators.

6. 为了您的人身安全，我们建议您戴上防护上镜。

For your personal protection,we recommend that you wear safety glasses.

7. 下列情况下，请关闭电源开关或拔下电源插头：

For the following, turn off the power switch of disconnect the power plug of the machine from the receptacle.

7-1 机针穿线和换梭心；

For threading needle(s) and replacing bobbin.

7-2 更换机针、压脚、针板、送料牙、布料导板等；

For replacing part(s) of needle, presser foot, throat plate, feed dog, cloth guide etc.

7-3 进行维修时；

For repair work.

7-4 操作区无人时。

For when leaving the working place of when the working place is unattended.

8. 在机器加油润滑时，若不小心让油接触眼睛、皮肤或咽下机油或润滑油，请立即清洗被沾染部位或去医院检查。

If you should allow oil, grease, etc. used with the machine and devices to come in contact with your eyes or skin or swallow any of such liquid by mistake, immediately wash the contacted areas and consult a medical doctor.

9. 无论机器运转与否，严禁乱动机器零部件和配套装置。

Tampering with the live parts and devices, regardless of whether the machine is powered, is prohibited.

10. 机器的维修、改造和调整等工作必须由专业技术人员进行。

Repairing,remodeing and adjustment works must only be done by appropriately trained technicians or specially skilled personnel.

11. 应由专业受训人员进行一般的维修和检查工作。

General maintenance and inspection works have to be done by appropriately trained personnel.

12. 必须在专业电器人员或专业技术人员的指导下进行有关电器部件的维修，任何电器部件一经发现受损，立即停止机器运转。

Repair and maintenance works of electrical components shall be conducted by qualified electric technicians or under the audit and guidance of specially skilled personnel. Whenever you find a failure of any of electrical components, immediately stop the machine.

13. 使用期间要定期全面彻底清洗机器。

Periodically clean the machine throughout the period of use.

14. 正常操作本机时，必须进行试运转，工作环境远离强噪音源，如高频电焊机等等。

Grounding the machine is always necessary for the normal operation of the machine. The machine has to be operated in an environment that is free from strong noise sources such as high-frequency welder.

15. 由电气人员选择合适的插头和有地线的插座。

An appropriate power plug has to be attached to the machine by electric technicians, Power plug has to be connected to grounded receptacle.

16. 若需要改造或改进本机，请采用有效可行的安全措施。本公司对由此而产生的伤害不承担责任。

Remodel or modify the machine in accordance with the safety rules/standards while taking all the effective safety measures. We assume no responsibility for damage caused by remodeling or modification of the machine.

17. 本机只适用于专业缝纫。

The machine is only allowed to be used for the purpose intended. Other uses are

not allowed.

18. 两种警告提示符:

Warning hints are marked with the two shown symbols.



操作人员或维修人员请注意

Danger of injury to operator or service staff





特别注意事项

Items requiring special attention

安全操作事项

FOR SAFE OPERATION

	<p>为避免触电, 请不要打开电机的电箱盖, 也不要触摸电箱内部组件。</p> <p>To avoid electrical shock hazards, neither open the cover of the electrical box for the motor nor touch the components mounted inside the electrical box.</p>
	<p>1. 为避免人身伤害, 移动防护罩、护手挡或安全装置时, 请不要开动机器。</p> <p>To avoid personal injury, never operate the machine with any of the belt cover, finger guard of safety devices removed.</p> <p>2. 为尽可能避免机器运转造成的人身伤害, 手指、头部和衣服应远离上轮, 上轮周围不要放置任何物品。</p> <p>To prevent possible personal injuries caused by being caught in the machine. Keep your fingers, head and</p>

clothes away from the hand wheel, cover and the motor while the machine is in operation. In addition, place nothing around them.

3. 为避免人身伤害, 当您打开电源开关或操作机器时, 切勿将手放在机针下方。

To avoid personal injury, never put your hand under the needle when you turn ON the power switch or operate the machine.

4. 为避免人身伤害, 机器运转时, 切勿将手放入挑线杆防护罩内。

To avoid personal injury, never put your fingers into the thread take-up cover while the machine is in operation.

5. 旋梭运转时, 勿将手指放在旋梭附近。另外, 换梭芯时, 请关掉机器电源开关。

The hook rotates at a high speed while the machine is in operation. To prevent possible injury to hands, be sure to keep your hands away from the vicinity of the hook during operation.

6. 为尽可能避免人身伤害, 当翘起或抬起机头时, 勿将手指放入机器内部。

To avoid possible personal injuries, be careful not to allow your fingers in the machine when tilting/raising the machine head.

7. 为尽可能避免机器的突然启动所造成的事故, 抬起机头时, 请关掉机器的电源。

To avoid possible accidents because of abrupt start of the machine, turn OFF the power to the machine when

tiling the machine head.

8. 机器配有伺服电机，机器未运转时，电机无噪音；为避免机器的突然启动所先造成的事故，请关掉机器的电源开关。

If your machine is equipped with a serve-motor, the motor does not produce noise while the machine is at rest. To avoid possible accidents due to abrupt start of the machine, be sure to turn OFF the power to the machine.

9. 为避免触电，移动电源地线时，请勿让机器运转。

To avoid electrical shock hazards, never operate the sewing machine with the ground wire for the power supply removed.

10. 为尽可能避免触电或电器组件受损，在插上或拔下插头之前，请关掉电源开关。

To prevent possible accidents because of electric shock or damaged electrical component(s), turn OFF the power switch in prior to the connection/disconnection of the power plug.26

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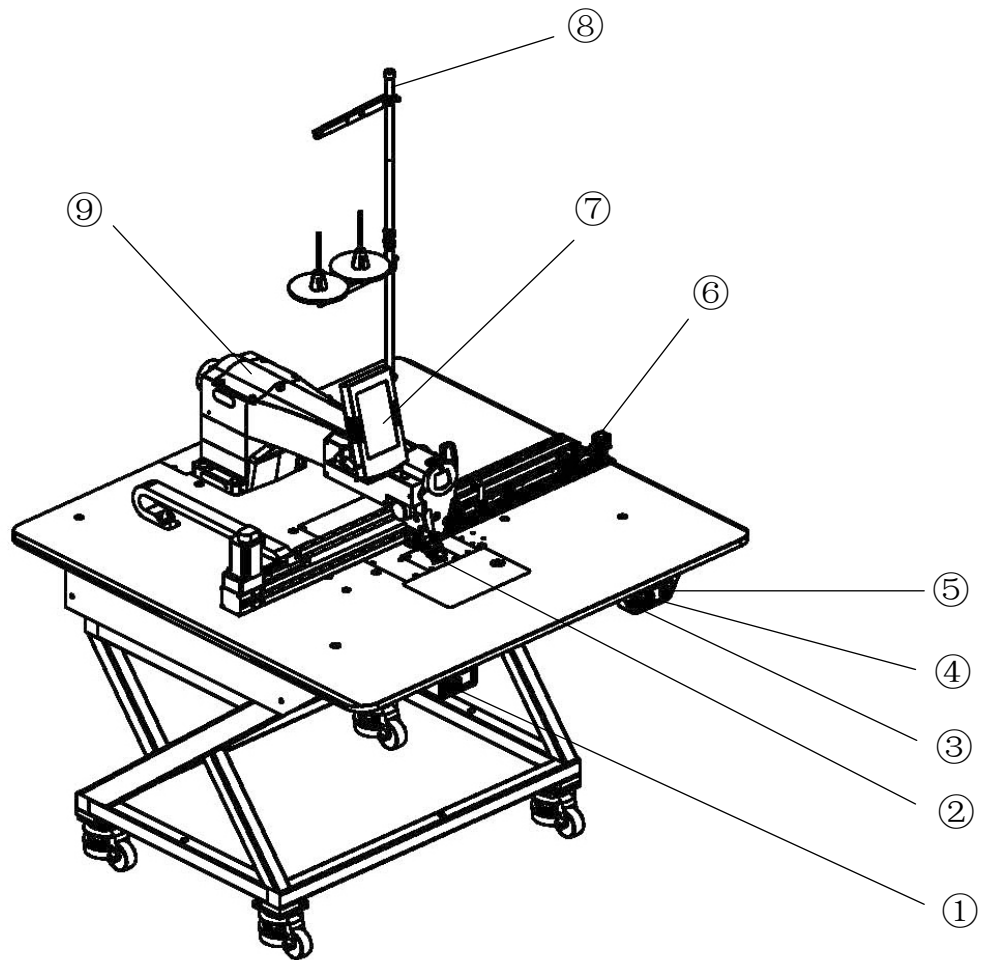
I、规格

规格	ZJ-M3-S350-SF
缝制范围	X 向 600mm, Y 向 370mm
最高缝纫速度	3200 转/分 (间距在 3.5mm 以内)
缝迹长度	0.1~12.7mm
压脚模板送布	间断送布(脉冲马达双轴驱动方式)
针杆行程	40mm
旋梭	1.6 倍旋梭
机针	DP×5 7#~10#
压框高度	10mm
辅助压脚高度	10mm
中压脚行程	标准 4mm (0~10mm)
中压脚上升量	17mm
可以变更中压脚上下位置	0~7mm
供油方式	面部: 润滑脂 旋梭: 10 号白油微量供油 齿轮箱: 壳牌 22 号液压油
花样存储	最大存储 999 个花样
模板识别功能	可识别 999 个模板
暂停功能	可以在缝纫途中停止
缝纫速度	200~3200rpm
花样选择功能	图案 NO.选择方式 (1~999)
底线计数器	加数计数/减数计数方式 (0-9999)
缝制计数器	加数计数/减数计数方式 (0-9999)
存储器后备	切断电源时, 自动地记忆使用的图案
主轴电机	550W 伺服电机
外形尺寸	2100mm×1172mm×1329mm
重量	685kg
消费电力	0.6KW
使用温度/湿度范围	温度: 5℃~40℃ 湿度: 20%~80% (无结露)
电源电压	额定电压±10% 50 / 60 Hz
使用气压压力	0.5~0.55 MPa
气压消耗量	1.8dm ³ /min
针杆上死点停止功能	缝制结束后, 可以让针杆回到上死点位置

Specifications

Specifications	ZJ-M3-S350-SF
Sewing range	X direction 600mm , Y direction 370mm
Max. sewing speed	3200rpm (spacing within 3.5mm)
Stitching length	0.1~12.7mm
Presser-foot template cloth feeding	Intermittent cloth feeding (double-shaft drive mode by pulse motor)
Need bar stroke	40mm
Shuttle	1.6 times the hook
Needle used	DP×5 7#~10#
Ascent of pressure frame	10mm
Ascent of auxiliary presser foot	10mm
Intermediate presser stroke	4 mm (Standard) (0~10mm)
Lift of intermediate presser	17mm
Intermediate presser down position variable	0~7mm
Oil used	Appearance: Lubricating grease Hook: 10#while oil Gear Box:Shell 22#
Pattern data memory	Capable of storing 999 patterns at most
Template recognition function	Capable of recognizing 999 template at most
Pause function	Stop the sewing machine in process of sewing
Sewing speed limitation	200~3200rpm
Pattern selection function	Pattern-number selection mode (1~ 999)
Bottom thread counter	Count-up/down mode (0-9999)
Sewing counter	Count-up/down mode (0-9999)
Memory back-up	Capable of store the patterns used in case of power cut
Sewing machine motor	550W servomotor
Overall dimensions	2000mm×1200mm×1290mm
Weight	685kg
Power consumption	0.6KW
Operating temperature/humidity range	Temperature: 5°C~40°C Humidity: 20%~80% ((No dew condensation)
Line voltage	Rated voltage ±10% 50 / 60 Hz
Air pressure	0.5~0.55 MPa
Air consumption	1.8dm ³ /min
Top-dead-center needle-rod stopping function	Capable enabling the needle rod to return to its top dead center position when sewing is over

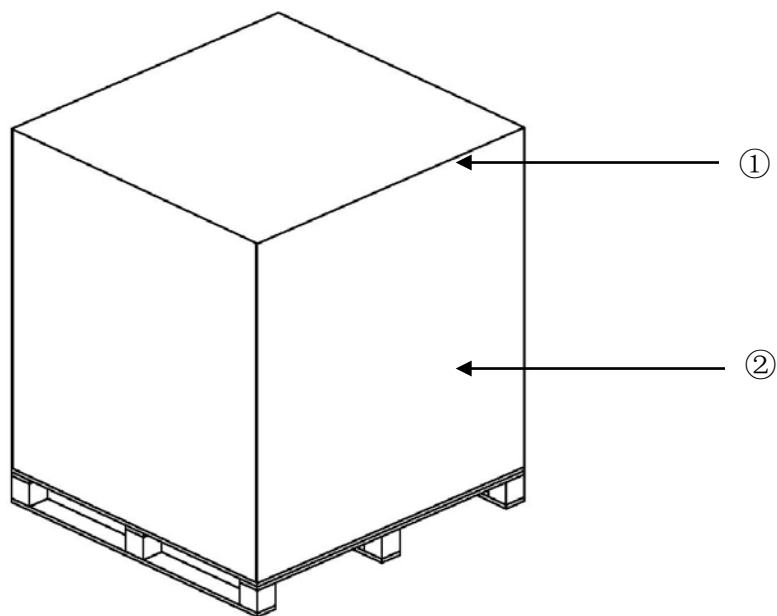
II、 各部的名称 Names of parts



①	电源开关 Power switch
②	辅助压脚 Auxiliary presser foot
③	压框按钮 Pressure frame button
④	启动按钮 Start button
⑤	急停开关 Emergency stop switch
⑥	压框 Pressure frame
⑦	操作屏 Operation panel
⑧	线架 Stand
⑨	缝纫机机头 Sewing machine head

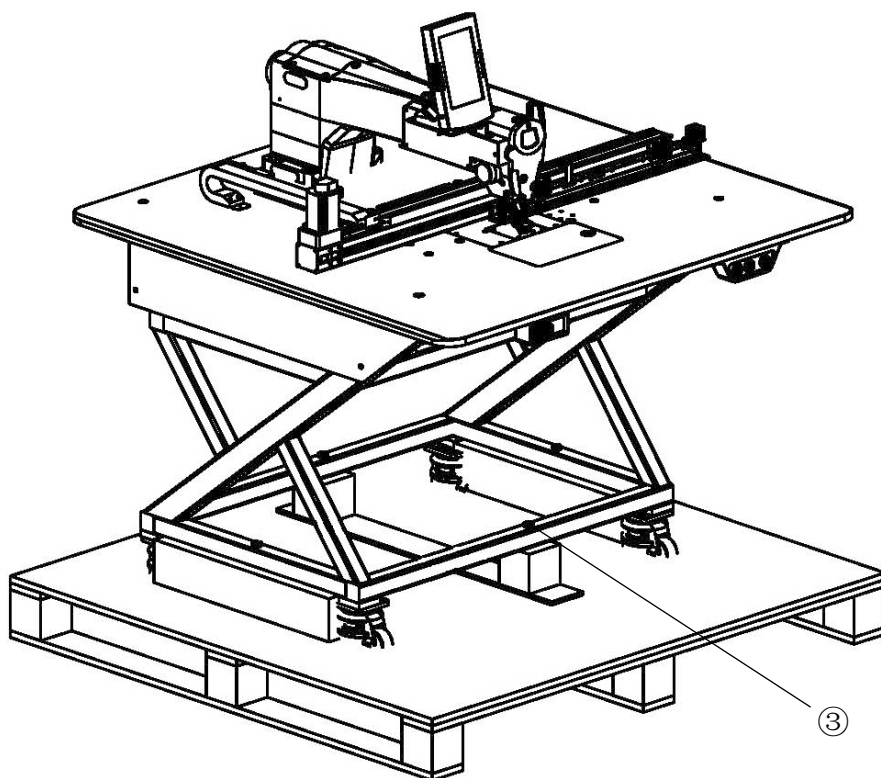
III、拆箱

Unpacking



步骤 1、撬开边缘板扣①，卸下 4 块围板②；

Step 1: pry open board buckle ①, and remove 4 lateral plates ②;



步骤 2、松开螺栓③，将机器推下托盘。

Step 2: Unclasp screw ③, and move the machine out of the pallet.

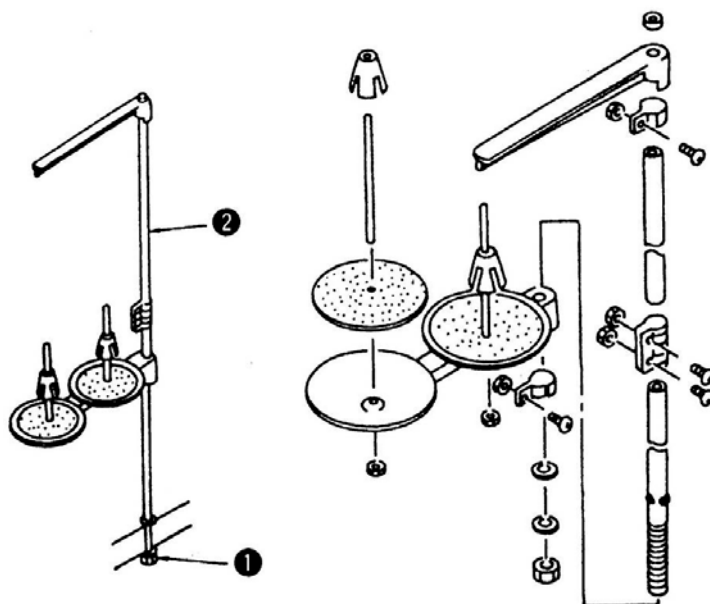
IV、 安装

Installation

1. 线架装置的安装方法/Installing the thread stand

组装线架装置，将它安装在台板的右上方的孔内。

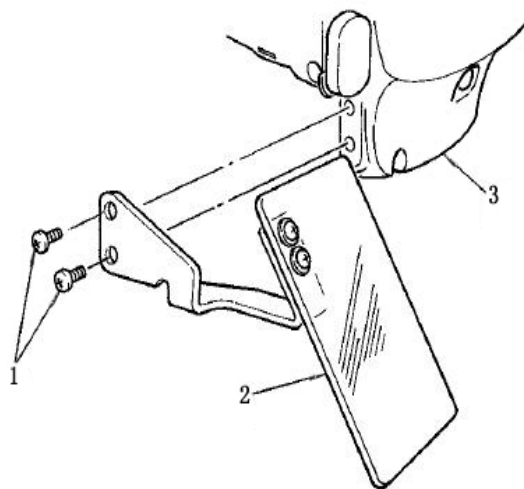
Assemble the thread stand, and put it in the hole in the top left corner of the machine table.



2. 眼睛防护罩的安装/Installing the eye protection cover

请一定要用螺钉 1 将眼睛防护罩 2 安装到缝纫机面板 3 之后再使用缝纫机。

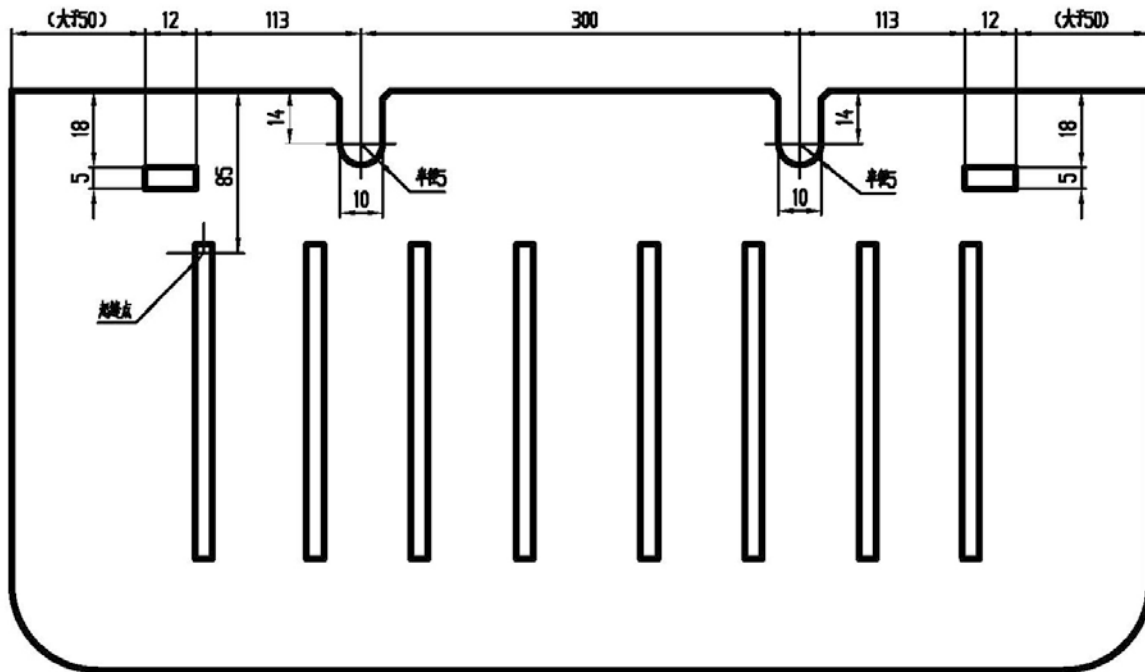
Use eye protection cover 2 after securely attaching it on face plate cover 3 with screw 1.



V、模板的制作

Making of Template

1、模板的制作尺寸/Template making size



VI、缝纫准备

Sewing Preparation

1、机针的安装方法/ Attaching the needle



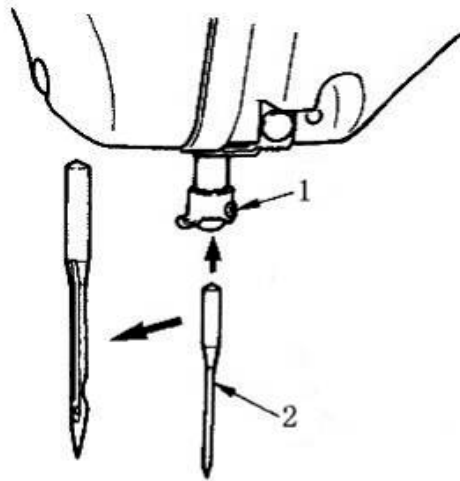
注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

松开螺钉 1，把机针 2 的长沟朝向面前，放进针杆的深处，然后拧紧固定螺钉 1。

Loosen setscrew 1 and hold needle 2 with the long groove facing toward you. Then fully insert it into the hole in the needle bar, and tighten setscrew 1.



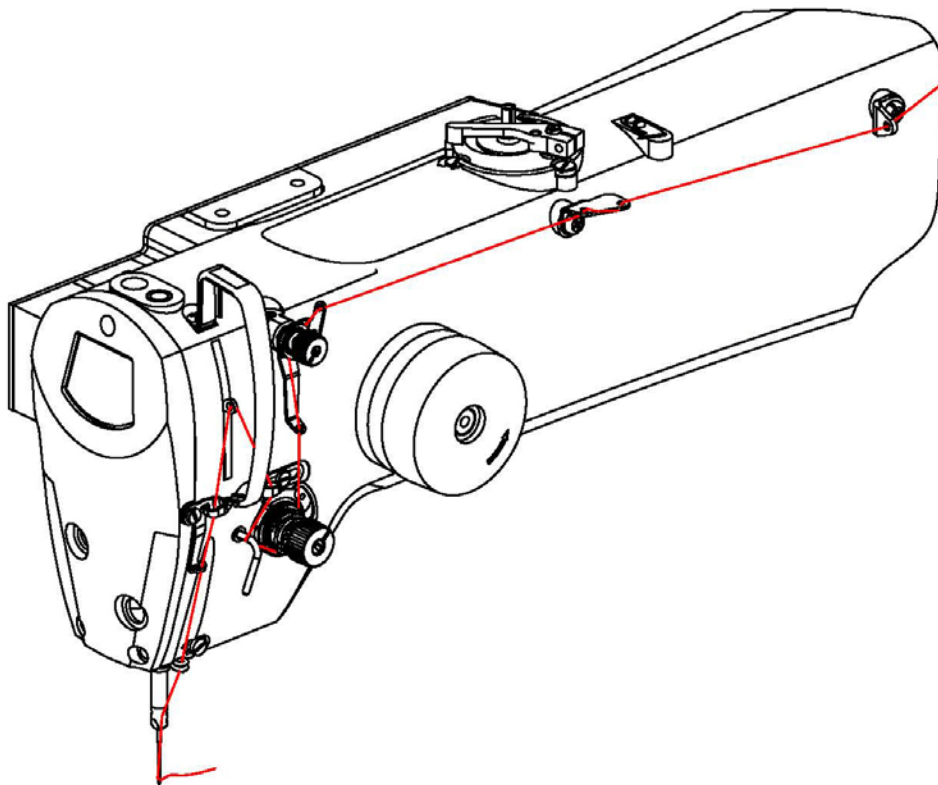
*注意：为了防止机器突然启动造成人身事故，请一定关掉电源后进行操作。

***WARNING: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.**

2、上线的穿线方法/ Threading the machine head

缝纫前请按图所示穿好线。

Before the machine work thread the machine head as shown in the figure.



*注意：为了防止机器突然启动造成人身事故，请一定关掉电源后进行操作。

***WARNING: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.**

3、 梭芯的安装方式/ Installing the bobbin



注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

1) 把梭心 1 按图示的方向装入梭壳 3 中。

Set the bobbin 1 into bobbin case 3 in the direction shown in the figure.

2) 把线穿过梭壳 3 的穿线口 2，然后拉线，把线从线张力弹簧下面的过线口 4 穿出来。

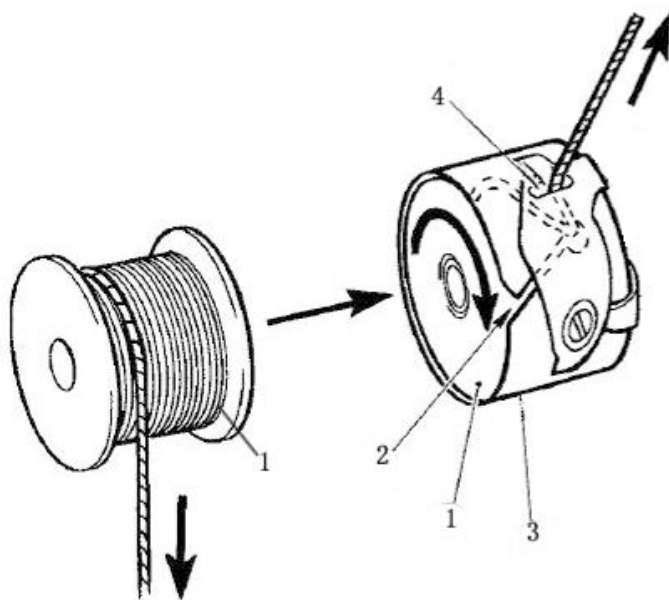
Pass the thread through thread slit 2 of the bobbin case 3, and pull the thread as it is. By so doing, the thread will pass under the tension spring and be pulled out from thread hole 4.

3) 拉底线时，梭芯应按箭头向转动。

Check that the bobbin rotates in the direction of the arrow when thread is pulled.

***注意：若梭心装入的方向相反，缝制过程中底线会不稳定。**

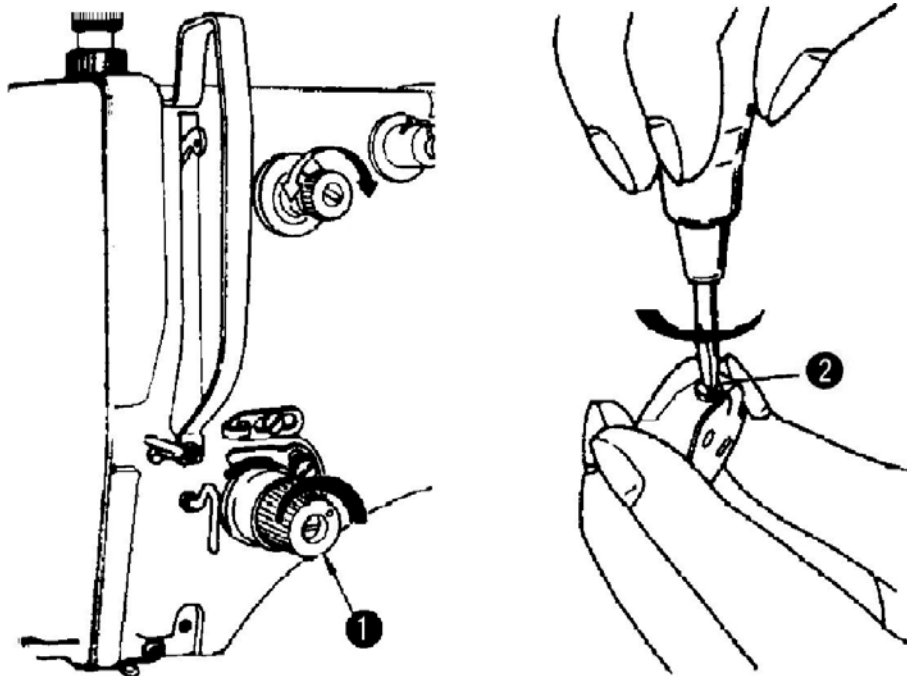
***Caution: If the bobbin is installed in the bobbin case orienting the reverse direction, the bobbin thread pulling out will result in an inconsistent state.**



4、 线张力的调整方法/ Adjusting the thread tension

用 1 调节面线张力，用 2 调节底线张力。

Adjust needle thread tension with 1 and bobbin thread tension with 2.



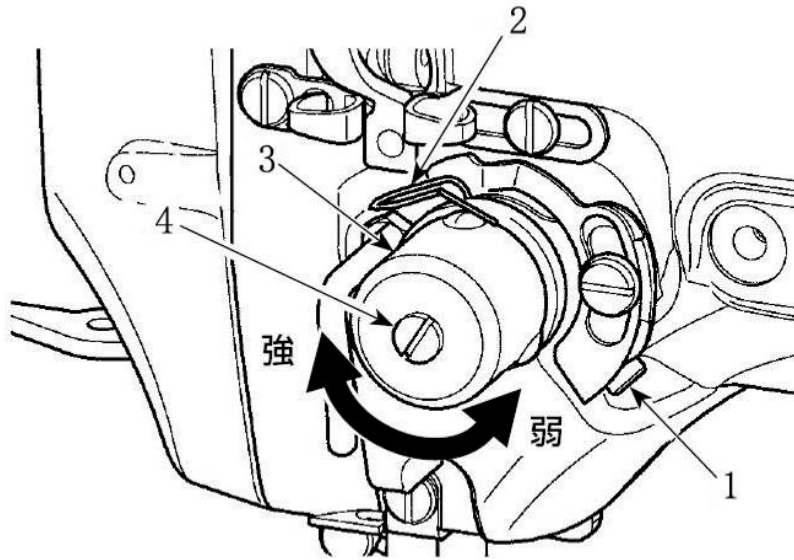
5、 挑线弹簧的调节/ Adjusting the thread take-up spring

- 1) 移动量的调节松开螺钉 1，转动夹线器向右转动，动作量变大，拉线量变多。


Adjusting the stroke loosen setscrew 1, and turn thread tension asm 2. Turning it clockwise will increase the moving amount and the thread drawing amount will increase.


- 2) 强度的调节改变挑线弹簧 3 的强度时，请在螺钉 1 在锁紧的状态下，用螺丝刀调节线张力杆 4，向右转动，挑线簧强度变强，向左转动之后，强度变弱。

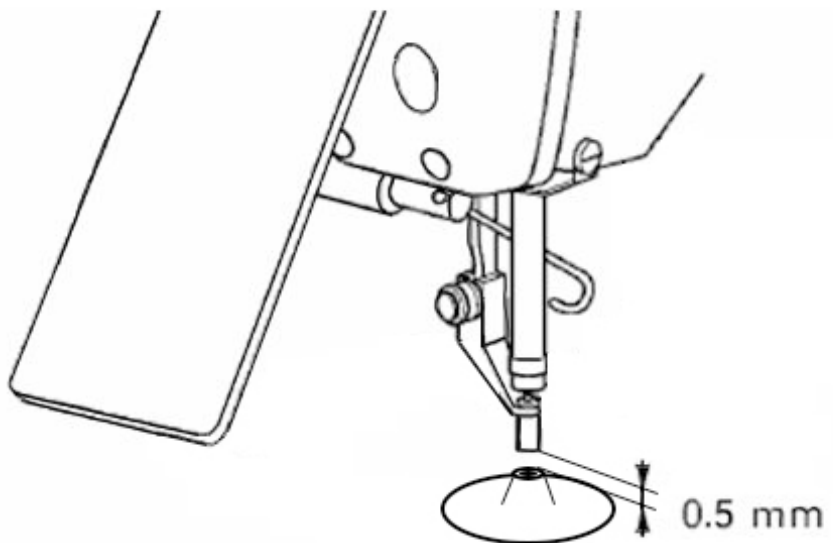
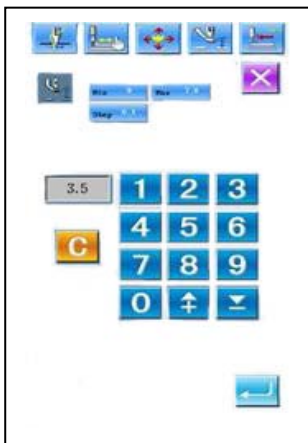
Adjusting the pressure to change the pressure of the thread take-up spring 3, insert a thin screwdriver into the slot of thread tension post 4 while screw 1 is tightened, and turn it. Turning it clockwise will increase the pressure of the thread take-up spring. Turning it counterclockwise will decrease the pressure.



6、中压脚高度的设置/Intermediate presser height

按中压脚设定按钮，使机针到达最低点时，请用十数字键把中压脚下端与布料的间隙调整为0.5mm。(中压脚的设定最大范围标准为7mm。)

Press **INTERMEDIATE PRESSER SETTING** button and adjust with **TEN** keys so that the clearance between the button end of intermediate presser and the cloth is **0.5 mm (max. 7 mm)**.



7、辅助压脚的调节

Adjusting the auxiliary presser foot

将辅助压脚的底部调整到能把夹有缝料的模板压实为宜。辅助压脚的气压调整到 0.2Mpa。
Adjust the bottom of auxiliary presser foot such that the template with clamped sewing materials may be held down securely. Adjust the air pressure of auxiliary presser foot to 0.2Mpa.

VII、保养方法

Maintenance Method

请定期（建议不超过 2 个月）向指定部位补充润滑脂。由于清扫缝纫机等原因造成润滑脂减少时，请立即加以补充。

Regularly add grease to the designated site (usually no more than three months). Reduced grease which is caused by cleaning sewing machines, please supplemented immediately.

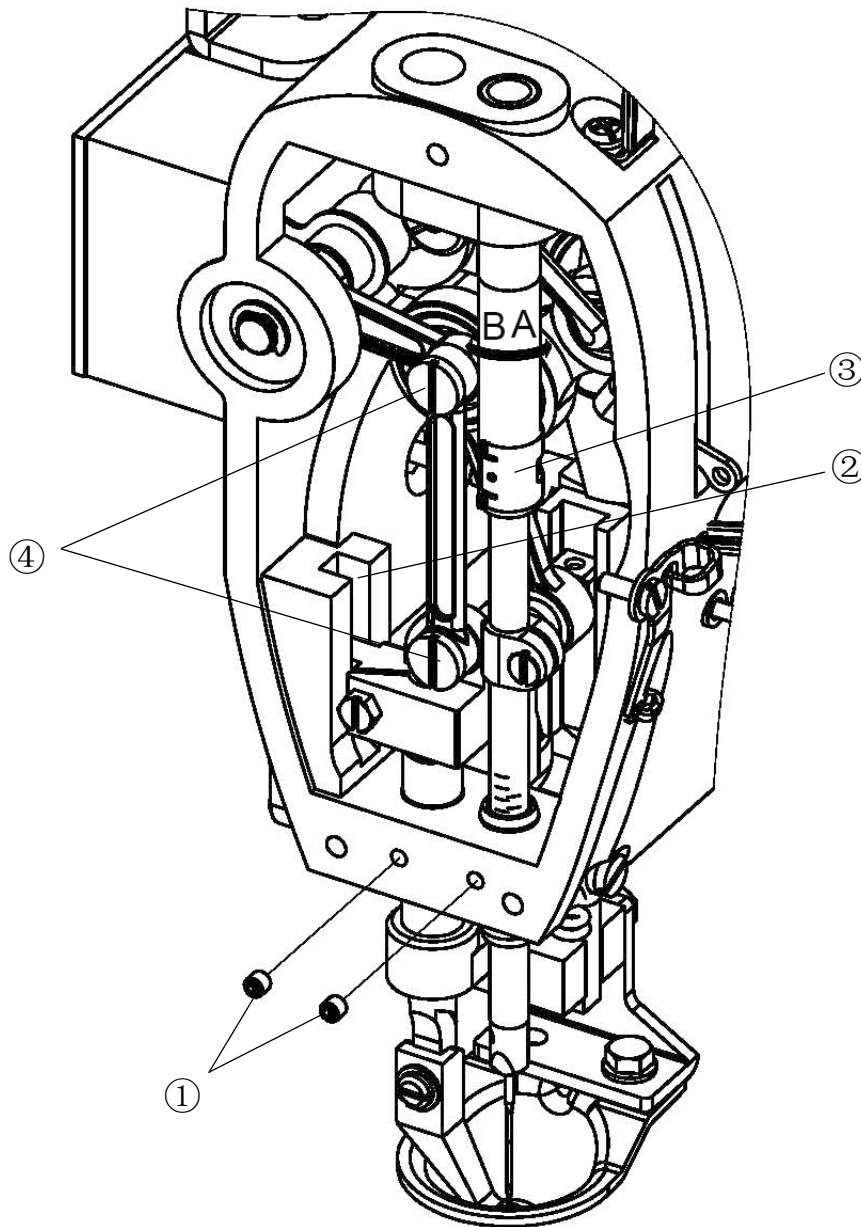
1、针杆、压杆部润滑脂补充\Needle bar, pressure lever grease replenishing

打开面板，向针杆四周涂抹润滑脂。然后请用手转动手轮让润滑脂涂满整个针杆四周。向箭头 A 方向转动针杆上轴套润滑脂护罩③，从注入口充填润滑脂。充填完毕后，向箭头 B 方向转动针杆上金属部润滑脂护罩，返回到原来的位置。

卸下针杆下轴套润滑脂孔固定螺丝①，向孔里注入润滑脂，然后拧紧固定螺丝①，让润滑脂充填到轴套内。向针杆滑块槽②涂抹润滑脂，也向压杆四周上也涂抹润滑脂。

Open the machine head plate ,Daub grease around the needle bar. Then turn the handwheel by hand to make the grease painted around the needle bar. Turning the needle bar shaft sleeve grease shield ③ in the direction of the A ,Filling the grease from the sprue .After the completion of the filling .turning the needle bar shaft sleeve grease shield in the direction of the B ,Return back to original position.

Remove the screw ① of the needle bar shaft sleeve grease shield. filling the grease into the sprue ,then fixed the screw ①, Let the grease filling inside the shaft sleeve. Needle bar slider slot ②also need painted the grease.painted the grease around the presser foot bar.



2、中压脚提升部润滑脂补充\Presser foot lifting parts grease replenishing

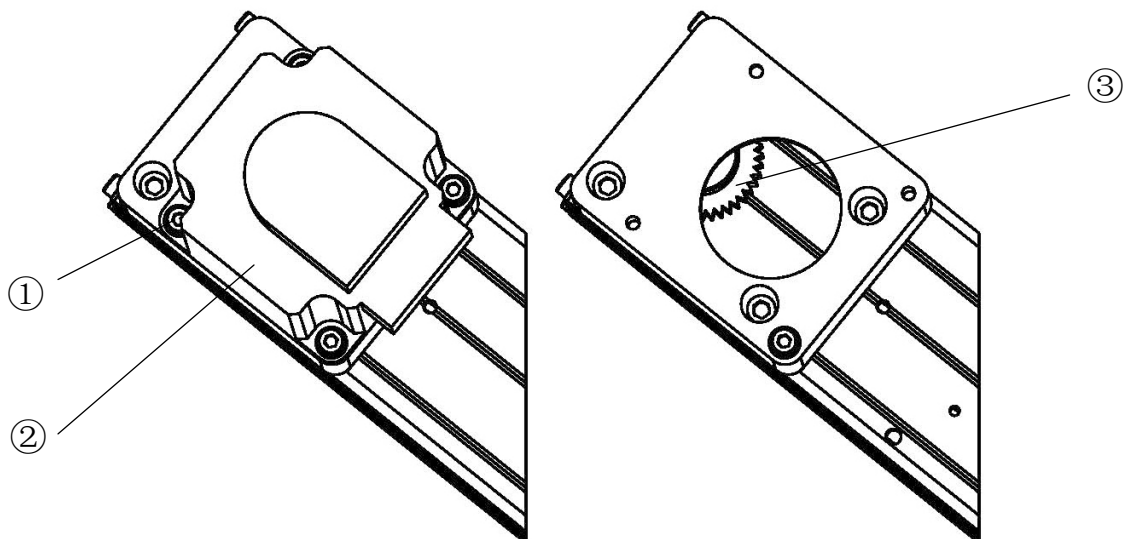
打开机头面板，请向毡垫部④(2处)及其四周的平头螺丝、支点里补充润滑脂。

Open head panel, add grease to the felt pad ④(2 part), the grub screws around and fulcrum.

3、X向齿轮部润滑脂补充\Adding grease to gears (directions X)

拧松 X 向电机螺钉①，卸掉 X 向电机②，用针筒将润滑脂补充在 X 向齿轮③上，保证 X 向电机齿轮③与油脂接触，转动 X 向传动齿轮③时该齿轮齿形上有均匀的油脂。

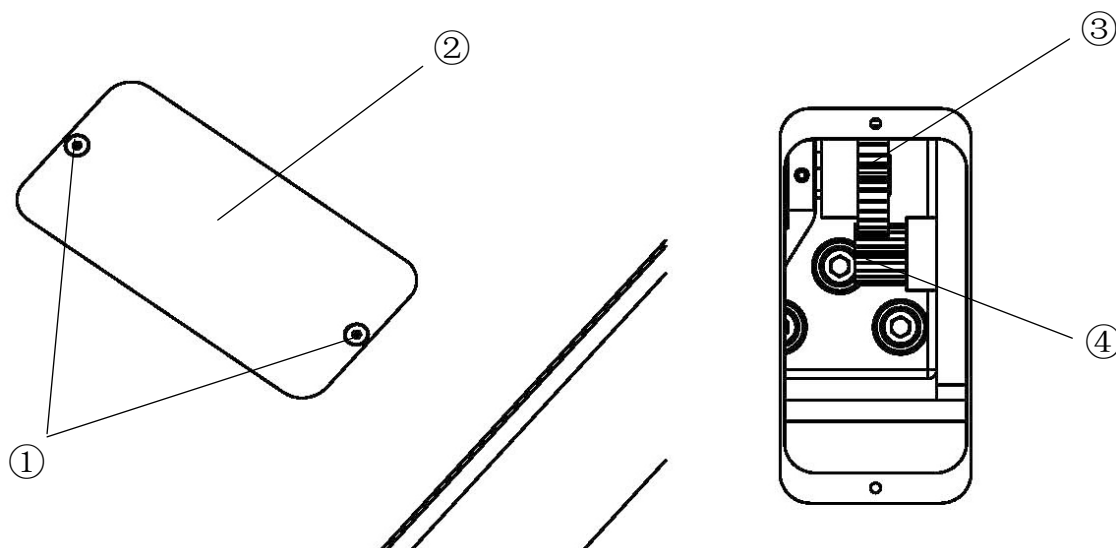
Remove the screw ①, remove the X-side motor ②, add the grease into the X-side gear oil groove ③ by cylinder, to keep the X-side motor gear ③ connect with the grease, until rounding the X-side transmission gear ③, there have grease on the gear .



4、Y 向齿轮部润滑脂补充\Adding grease to gears (directions Y)

拧松螺钉①，卸掉挡板②，用针筒将润滑脂补充在 Y 向齿轮③④上，前后移动送料座时 Y 向电机齿轮③④齿形上有均匀的油脂。

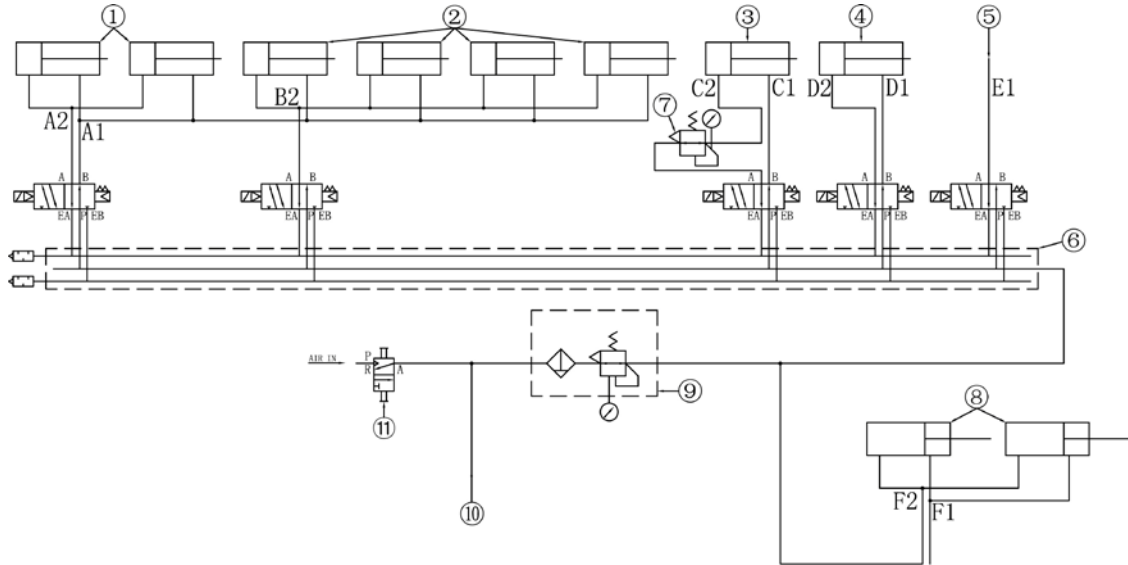
Remove the screw ①, remove the baffle ②, adding the grease in Y-side gear ③ ④ by cylinder, when move the feeding seat, Y-side motor gear and motor gear ③ ④ all have grease.



VIII、气路及机头扩展板图

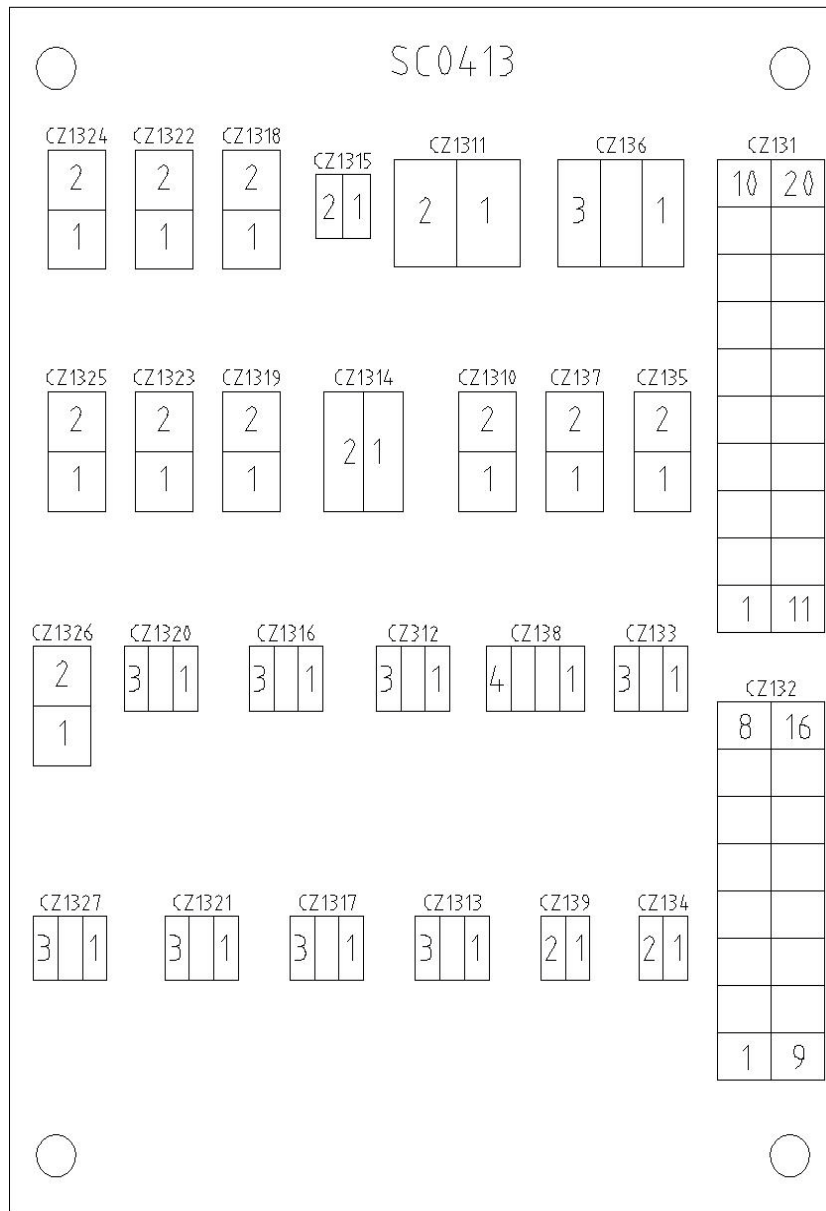
Air circuit and machine head extend PCB board diagram

1、气路图 Air circuit diagram



①	模板抓钩气缸 Template clamp cylinder
②	模板压紧气缸 Template compaction cylinder
③	辅助压脚气缸 Auxiliary presser foot cylinder
④	剪线气缸 Trimming cylinder
⑤	吹气管 Blow pipe
⑥	五联电磁阀组件 Quintuplet solenoid valve components
⑦	减压阀 Pressure reducing valve
⑧	导轨压紧气缸 Guide compaction cylinder
⑨	过滤减压阀组件 Filter pressure reducing valve components
⑩	吹尘枪 Air gun
⑪	手滑阀 Hand slide valve

2、机头扩展板图 Machine head extend PCB board diagram



插座号 Plug	标号 Grade	用途 Use	备注 Remark
CZ131	20P 白色插头 20pin white plug	电控箱与机头板线缆 Control box and machine head PCB board cable	
CZ132	16P 白色插头 16 pin white plug	连接 X9 信号线缆 Connect X9 signal cable	
CZ133	X 原点 (白色 3 针) Origin of the X (white 3 pin)	X 原点传感器 X origin sensor	1 蓝 2 黑 3 褐 1 blue 2 black 3 brown
CZ134	急停 (黄色 2 针) Stop(yellow 2 pin)	急停 Stop	1 红 2 褐 1 red 2 brown
CZ135	外压脚(白色 2p) Presser foot (white 2 pin)	外压框电磁阀 (第二路电磁阀) External pressure solenoid valve (second solenoid valves)	1 红 2 黑 1 red 2 black
CZ136	拨线 (白色 3 针) Wiper (white 3pin)	小电子夹线器 (拨线电磁铁) Small electronic thread tension (wiper electromagnet)	1 蓝 3 红 1 blue 3 red
CZ137	中压脚 (黄色 2p) Middle presser foot (yellow 2pin)	吹气电磁阀 (第五路电磁阀) Blow air solenoid valve (fifth solenoid valves)	1 红 2 黑 1 red 2 black
CZ138	Y 原点 (白色 4 针) Y original (white 4pin)	Y 原点传感器 Y origin sensor	1 蓝 3 黑 4 褐 1 blue 3 black 4 brown
CZ139	安全 (红色 2 针) Safe switch (red 2 pin)	气压检测 Pressure testing	1 红 2 黑 1 red 2 black
CZ1310	气剪线 (蓝色 2p) Air trimming (blue 2 pin)		
CZ1311	松线 (蓝色 2 针) Loose line (blue 2 pin)	松线电磁铁 Loose thread electromagnet	1 褐 2 红 1 brown 2 red
CZ1312	Z 原点 (黄色 3 针) Z original (yellow 3pin)	中压脚原点传感器 Medium pressure foot origin sensor	1 黑 2 白 3 红 1 black 2 white 3 red
CZ1313	断线 (紫色 3 针) break line (Purple 3 pin)	断线检测 Thread break	2 黑 2 black
CZ1314	电剪线 (蓝色 2 针) Electricity trimming (blue 2 pin)	辅助压框电磁阀 (第三路电磁阀) Auxiliary pressure foot solenoid valve(third solenoid valves)	1 红 2 黑 1 red 2 black
CZ1315	LED 灯 (蓝色 2 针) LED light (blue 2 pin)		
CZ1316	输入 4 (红色 3 针) Input 4 (red 3 pin)	电控柜散热风扇 Control box cooling fan	1 红 3 黑 1 red 3 black
CZ1317	输入 1 (黑色 3 针) Input 1 (black 3 pin)		
CZ1318	气阀 4 (白色 2p) Air valve 4 (white 2 pin)		

插座号 Plug	标号 Grade	用途 Use	备注 Remark
CZ1319	气阀 1 (白色 2P) Air valve 1 (white 2 pin)	抓紧电磁阀 (第一路电磁阀) Clamp solenoid valves(first solenoid valves)	1 红 2 黑 1 red 2 black
CZ1320	输入 5 (绿色 3 针) Input 5 (green 3 pin)	抓线原点传感器 Clamp thread origin sensor	1 蓝 2 黑 3 褐 1 blue 2 black 3 brown
CZ1321	输入 2 (红色 3 针) Input 2 (red 3 pin)	抓线位置传感器 Clamp thread position sensor	1 蓝 2 黑 3 褐 1 blue 2 black 3 brown
CZ1322	气阀 5 (白色 2p) Air valve 5(white 2 pin)		
CZ1323	气阀 2 (白色 2P) Air valve 2(white 2 pin)	油路电磁阀 Oil solenoid valves	1 红 2 黑 1 red 2 black
CZ1324	气阀 6 (白色 2p) Air valve 5(white 2 pin)		
CZ1325	气阀 3 (白色 2P) Air valve 3(white 2 pin)	剪线电磁阀 (第四路电磁阀) Trimming solenoid valves(fourth solenoid valves)	1 红 2 黑 1 red 2 black
CZ1326	辅助气阀 (红色 2p) Auxiliary valve (red 2 pin)		
CZ1327	输入 3 (蓝色 3 针) Input 3 (blue 3pin)	油盒油量报警 Oil case oil Alarm device	1 黑 2 黄 3 红 1 black 2 yellow 3 red