

INSTRUCTION MANUAL

781F

Automatic industrial buttonhole sewing
machine



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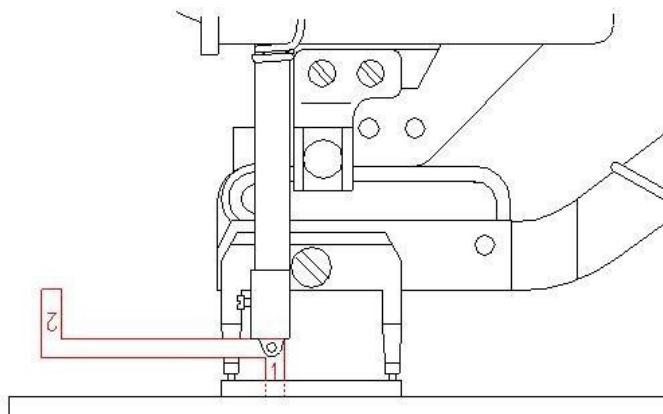
The adjustment of other parts

1. Adjust the position of the left and right stitches according to the width of the hole:
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1. The height of the needle bar:

Adjustment requirements:

When the needle bar is at the lowest point, the distance between the lower end surface of the needle bar and the upper plane of the needle plate is 11.9 mm.



Adjustment method:

(1) Insert the positioning ruler between the needle bar and the needle plate, loosen the needle bar, and tighten the screws to adjust.

Note: the needle should fall in the center of the needle plate.

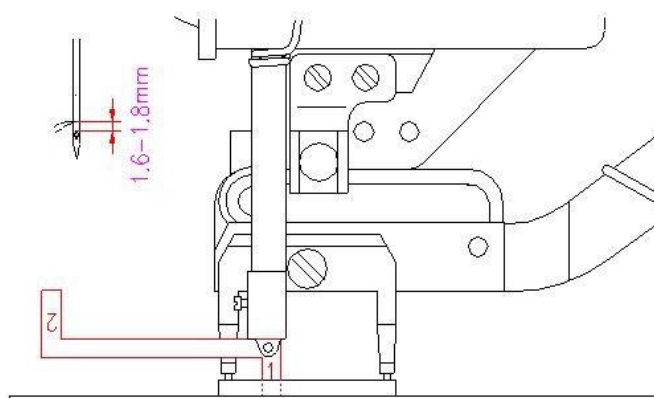
The phenomenon when the adjustment value changes:

When sewing elastic fabric, the needle bar is lowered a little more than the standard value, and the effect is better.

2. The cooperation of the needle and the hook:

Adjustment requirements:

When the needle bar is lifted by 2.3mm from the lowest point, the center of the hook tip and the needle should be the same, and the upper end of the needle eye is 1.6~1.8mm; the lateral gap between the needle and the hook tip is about 0.05mm.



Adjustment method:

(1) With the needle bar rising from the lowest point, place the positioning scale 2 between the needle bar and the needle plate, and then loosen the set screw of the hook sleeve to adjust.

(2) At this time, adjust the lateral clearance of the needle and the hook tip to about 0.05 mm, and swing it to the left and right to check and not touch.

(3) At this time, adjust the gap between

the hook positioning hook and the hook to 0.5mm, and loosen the screw of the hook positioning hook to adjust. (Keep the line pass smoothly)

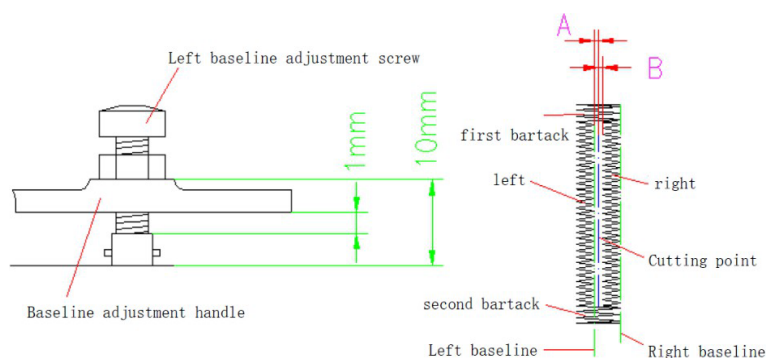
The phenomenon when the adjustment value changes:

(1) When sewing elastic fabric, slow down the cooperation time of the hook to the needle, and the effect is better. (The distance between the tip of the hook and the upper end of the needle eye is about 1.0mm)

3. Matching of the baseline adjustment handle (adjusting the parallel gap between the cutter and the left and right amplitudes)

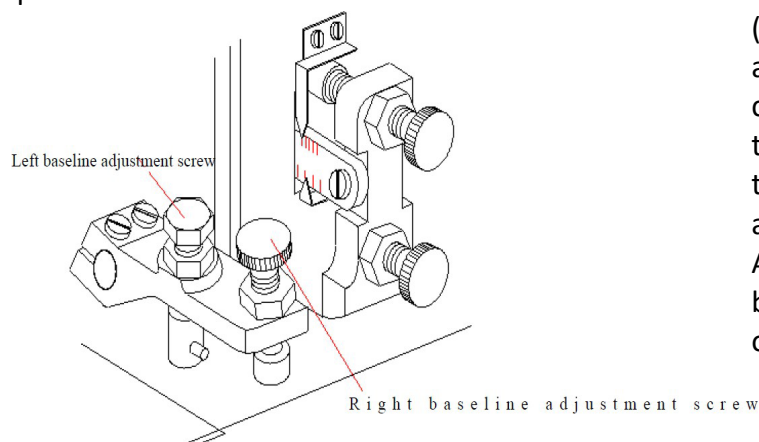
Adjustment requirements:

- (1) Position of the parallel portion on the left side: The lower end of the left baseline adjustment screw is 10 mm from the upper plane of the baseline adjustment handle, and the lower plane of the baseline adjustment handle is exposed to be about 1 mm.
- (2) Position of the right parallel portion: The adjustment of the right baseline should be adjusted to the A=B position according to the amplitude of the parallel portion.



Adjustment method:

- (1) Adjustment of the left baseline should be performed when the needle falls in the center of the needle plate hole. The distance between the lower end of the left baseline adjustment screw and the plane above the baseline adjustment handle is approximately 10 mm, which is adjusted by the left baseline adjustment screw (see figure).
- (2) The adjustment of the right baseline is performed with the right baseline adjustment screw.
- (3) Adjust the left and right baselines so that the cutter falls in the center of the parallel portion.



- (4) Adjustment order of amplitude and baseline: 1 change of course amplitude 2 Observation of the distance between the inside of the amplitude of the right course and the falling point of the cutter 3 Adjusting the position of the right baseline 4 Adjusting the amplitude of the reinforcement

The phenomenon when the adjustment value changes:

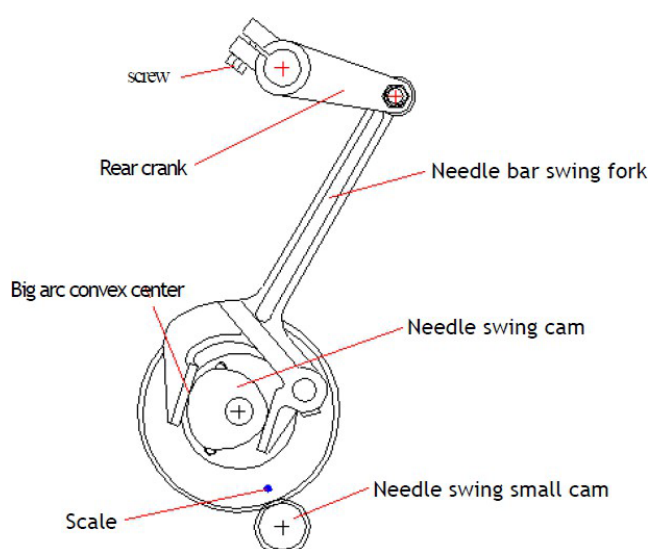
When adjusting the left and right baselines, it is biased toward either side, and the stitches

adjacent to the parallel portion of the cutter may be biased to the inner side.
When the amplitude is increased, the left parallel portion is individually biased to the left.

4. The needle bar cooperation:

Adjustment requirements:

- (1) When the needle is at the top center, the engraved line of the pinion gear should be aligned with the center of the lower shaft.
- (2) If there is no engraving on the pinion gear, when the needle bar is at the lowest point, the center of the oil hole on the convex arc of the large arc of the needle pendulum (ie the center of the convex arc of the cam) is aligned with the needle bar. Swing the left side of the plane (viewed from the front).



Adjustment method:

Loosen the fixing screw of the pinion gear to adjust the above standard adjustment value.

Pay attention to the axial movement of the lower shaft when adjusting. Confirmation method after adjustment: pad the paper at the needle drop and turn the pulley by hand to observe whether there is a lateral flow needle phenomenon on the needle drop point on the paper, that is, to ensure that the swing of the needle before the needle bar is lowered to the front of the puncturing cloth should end.

The phenomenon when the adjustment value changes:

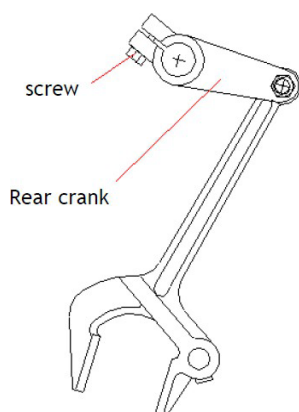
When the reticle is missed, it will cause the needle to flow, the needle to break, and the needle to jump.

5. The adjustment of the needle drop (for the needle board)

Adjustment requirements:

When sewing the parallel portion on the left side, the swing fork is at the leftmost end when the needle is lowered to the middle portion of the needle plate hole.

Adjustment method:



When the position of the needle bar swing fork is normal, and the needle drop point is not correct, the tightening screw of the crank shaft after the swing shaft can be loosened to be corrected.

The phenomenon when the adjustment value changes:

If the needle drop point is wrong, it will increase the needle swing

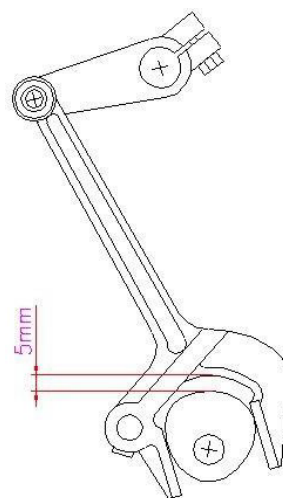
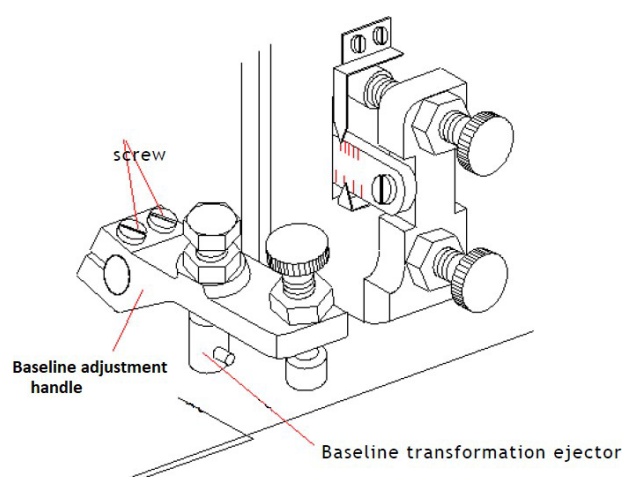
amplitude, and the inaccurate one will hit the needle plate hole and cause the needle break or thread break.

6. The height of the needle bar swing fork

Adjustment requirements:

When the machine is in the parking position (the needle is in the left needle position), the distance from the large arc of the needle cam to the top of the needle bar swing fork is about 5 mm.

Adjustment method:



When the machine is in the parking position (the needle is in the left needle position), loosen the fastening screw on the baseline adjustment handle, push down the needle bar swing fork, so that the large arc of the needle swing cam is convex to the top of the needle bar swing fork. About 5mm, adjust the shank to the baseline adjustment shank, and then tighten the baseline adjustment shank.

Note: When making this adjustment, please remove the spring of this mechanism and adjust it. Check if the needle-swing cam of the needle-spindle gear rotates smoothly.

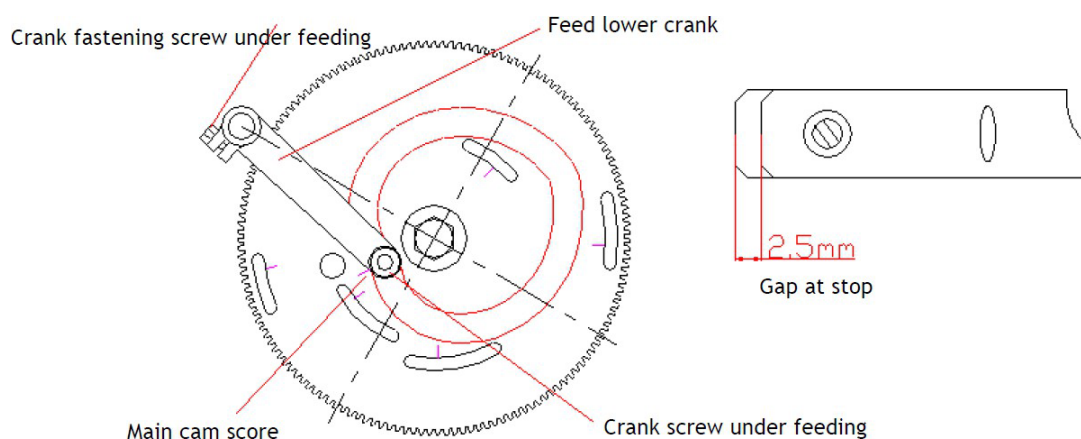
The phenomenon when the adjustment value changes:

If the height of the needle bar swing fork is not accurate, the width of the left and right courses will be different.

7. The position of the under feeding crank

Adjustment requirements:

Even if the sewing size (adjustment button hole length) is changed, the position of the presser foot does not change during parking, and the position of the feed carriage does not change.



Adjustment method:

Rotate the main cam with the manual feed handle. When the main cam engraving line is aligned with the center of the roller pin screw of the feeding lower crank, loosen the fastening screw of the lower crank and then loosen the button hole length nut. When the plate moves to a distance of 2.5mm from the needle plate (see picture), move the button hole length adjustment screw in the arc groove of the feed crank body. If the presser foot does not move back and forth, the position of the crank under the feed is correct. When the crank body does not move, tighten the fastening screw of the lower crank.

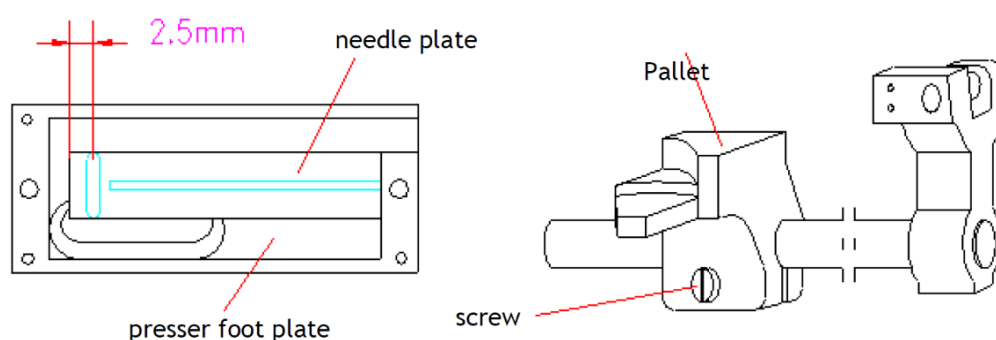
The phenomenon when the adjustment value changes:

If the position is wrong, whenever the sewing size is changed, the action of the scissors will fail, and the position of the presser foot will also change, causing a broken needle or thread broken.

8. Front and rear position of the presser foot

Adjustment requirements:

The gap between the center of the needle drop hole and the inner end surface of the presser foot is 2.5 mm (when the vehicle is parked), and the presser foot plate is located at the same position on both sides of the needle blade slot.



Adjustment method:

When the machine is in the parking position, loosen the fastening screws of the pallet to adjust.

Confirmation after adjustment:

Please confirm that the lifting arm is perpendicular to the bottom plate.

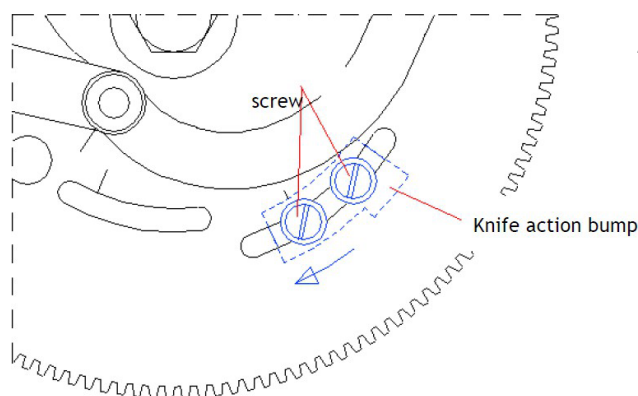
The phenomenon when the adjustment value changes:

- (1) If the position of the presser foot is not accurate, the front and rear positions of the presser foot are not accurate, and the opening and closing action of the upper scissors action plate is affected.
- (2) When the parking is stopped, the gap between the center of the needle hole and the presser foot is too small. When the sewing machine is in contact with the presser foot during sewing, the thread is broken and the needle is broken.

9. Cutter falling time

Adjustment requirements:

After the sewing machine is completely decelerated, it will fall 2~3 before the stop (1 2 3 pin is the reference).



Adjustment method:

Move the cutter action bump position and adjust the cutter fall time to 2~3 stitches before the sewing machine stops.

Moving in the direction of the mark, the cutter falls early.

Note: When the number of stitches is adjusted to 93 or less, adjust the low speed bumps.

The phenomenon when the adjustment value changes:

When the cutter is operated during high-speed operation, the cutter will not fall, and the cutter will be accelerated.

10. The position of the cutter falls

Adjustment requirements:

Should fall in the middle of the needle plate slot.

Adjustment method:

Loosen the needle plate seat fastening screw and move the needle plate seat position to adjust.

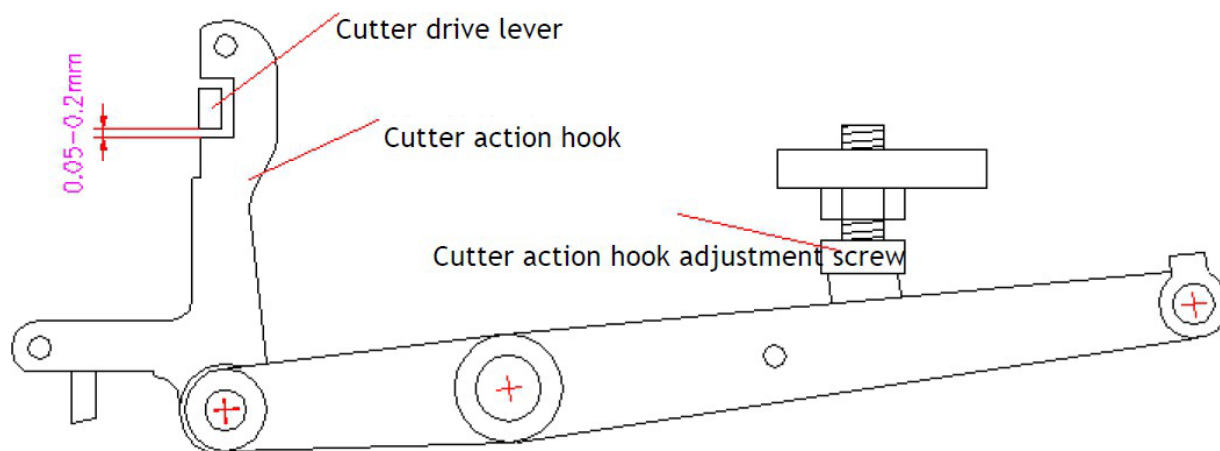
The phenomenon when the adjustment value changes:

When the position is wrong, the cutter hits the needle plate.

11. Knife of action hook position

Adjustment requirements:

The clearance between the cutter drive lever and the knife of action hook at the lowest point is 0.05~0.2mm.



Adjustment method:

Use the knife of the drive hook adjustment screw to adjust.

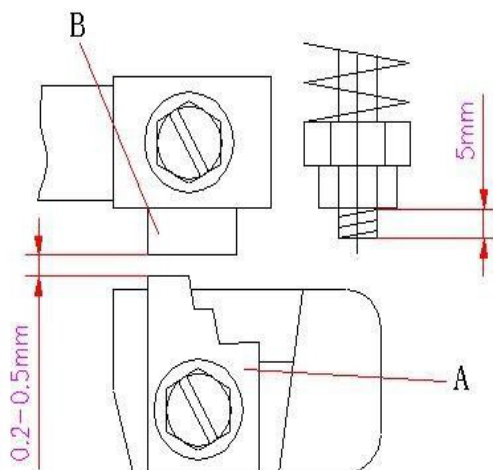
The phenomenon when the adjustment value changes:

- (1) When the cutter does not return or continuously falls, check the gap between the cutter drive lever and the cutter action hook, or change the cutter drive lever tension spring.
- (2) The cutter often does not fall down, and it is not possible to drop the knife at a low speed. It may be that the tension spring of the cutter driving claw is insufficient. (replace the tension spring)

12. Adjustment of the stop device

Adjustment requirements:

The clearance between the stop sub-block A and the stop lever block B is 0.2 to 0.5 mm (when parked).



Adjustment method:

- (1) Move the stop block A up and down to adjust.
- (2) Adjustment of the stop buffer rod spring: When the hex nut is adjusted to the stop buffer rod to expose 5mm, tighten it.

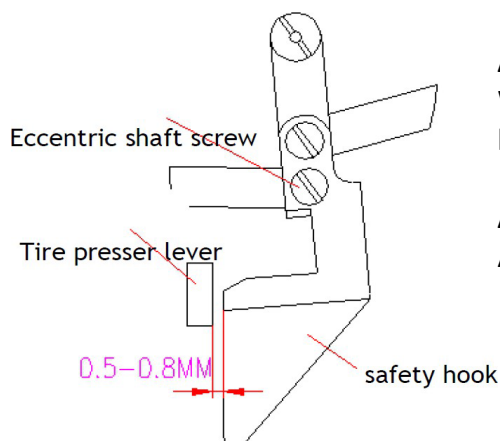
Adjusted confirmation method:

The stop frame is adjusted to a high speed running state, and the manual stop handle is rotated, the stop block must release a first gear, enter a low speed state, and then release the second gear to enter a stop state.

The phenomenon when the adjustment value changes:

- (1) At the parking position, the clearance between the stop sub-block A and the stop lever block B is too small, and there is no stopping.
- (2) When the hex nut loosens and the sewing machine stops, the height of the needle changes.

13. Start the position of the security hook



Adjustment requirements:

When parking, the distance between the start safety hook and the lifter lever is 0.5~0.8mm.

Adjustment method:

Adjust with the rotating eccentric shaft screw.

The phenomenon when the adjustment value changes:

If there is no gap, it will be in a state of conflict, causing the presser foot not to return. On the contrary, if the gap is too large, it will not stop.

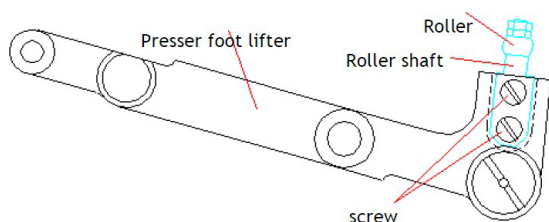
14. The amount of back and forth movement of the upper knife

Adjustment requirements:

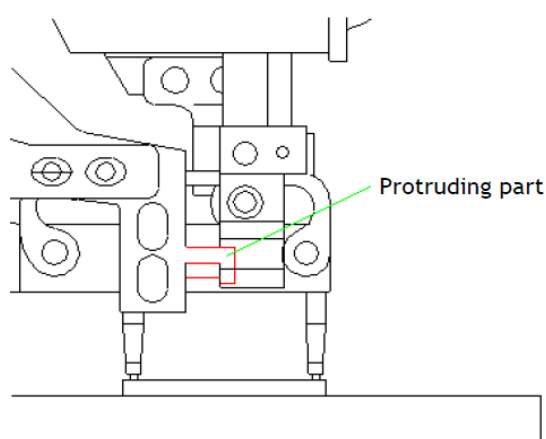
The amount of back and forth movement is 4~5mm.

Adjustment method:

- (1) Loosen the roller shaft fixing screw in front of the presser foot connecting rod, adjust the amount of back and forth movement of the upper knife, move to the right to increase the amount of movement, and shift to the left to decrease.



- (2) Note: The adjustment of this part is a slight adjustment, please do not adjust excessively

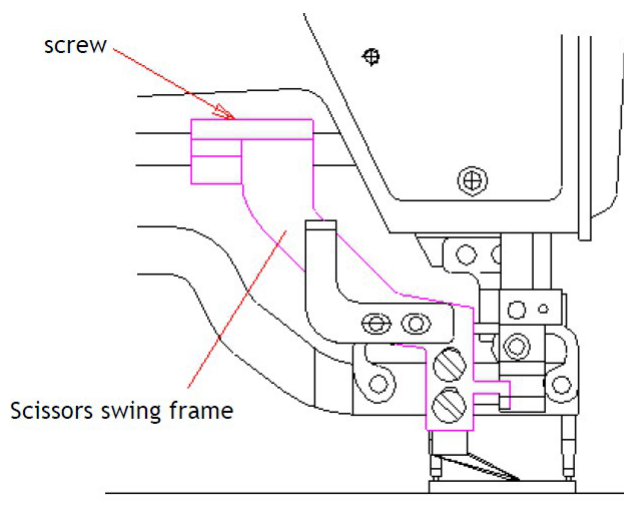
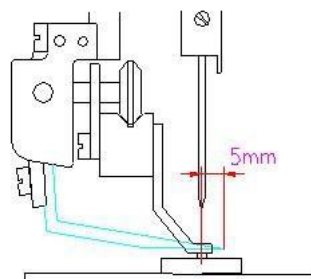
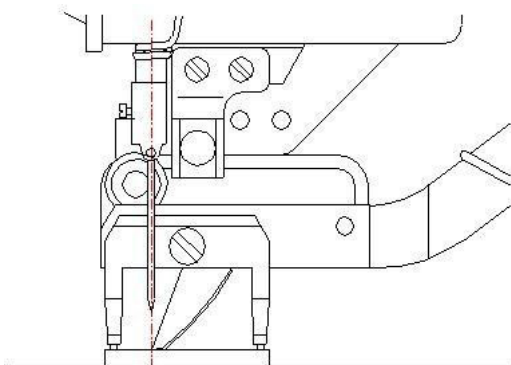


The phenomenon when the adjustment value changes:

When the amount of front and rear movement is excessively adjusted, the protruding portion of the scissor swing frame will slide out from the groove of the presser roller frame. Once it is slipped out, the presser foot cannot be lifted and the feeding becomes heavy.

15. Left and right position of the upper knife Adjustment requirements:

- (1) The upper scissors is aligned with the center of the needle when it advances to the foremost end; and the front end of the scissors protrudes 5 mm to the right from the center of the cutter groove.
- (2) When the upper scissors is closed, the overlap between the upper knife and the lower knife is 0.5~0.8mm. Please note that there is still a gap even if it is closed.



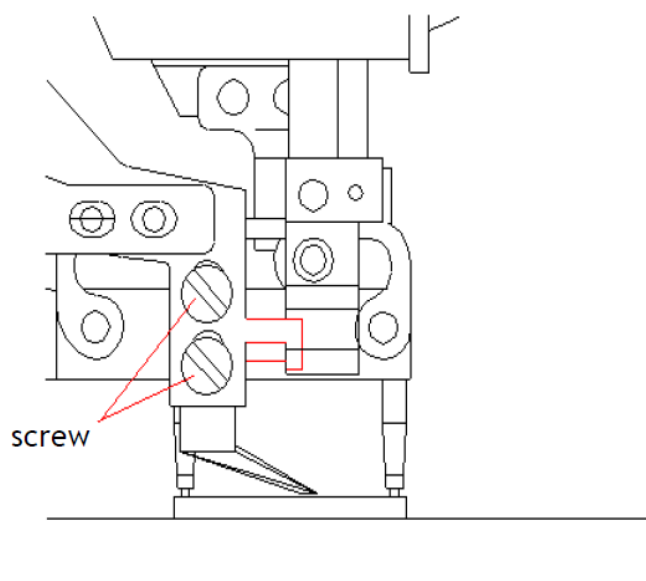
Adjustment method:

- (1) Step on the presser foot pedal. When the upper thread scissors move to the apex, use a hex wrench to loosen the fixing screws of the scissors pendulum and adjust the position of the front, back, left and right.
- (2) Loosen the fixing screw of the upper scissors action plate A and adjust the amount of overlap between the upper knife and the lower knife.

The phenomenon when the adjustment value changes:

- (1) When the front, back, and left and right positions are not good, when the presser foot is raised, the scissors swing frame is caught and cannot move smoothly.
- (2) The position of the scissors action board A is too far forward to produce the upper line cut continuously. (scissors are not close together)
- (3) When the position of the scissors action board A is too backward, the scissors will be closed when the line is not clamped.

16. Height of the upper scissors



Adjustment requirements:

Install the scissors as low as possible, but do not touch the presser foot.

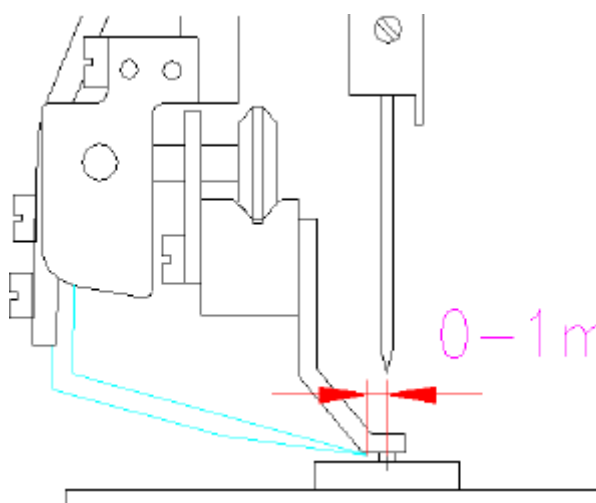
Adjustment method:

Loosen the fixing screws of the upper scissors and adjust them up and down. Confirmation method after adjustment: Place a gasket with a thickness of about 4 mm under the presser foot. When moving the presser foot lever up and down, the presser foot and the scissors should not touch each other.

The phenomenon when the adjustment value changes:

The position of the scissors is too high, and sometimes the thread will remain on the knot.

17. The position of the roll into the upper thread at the start of sewing



Adjustment requirements:

At the beginning of the sewing, the top end of the upper scissors leaves the center of the needle cutter slot 0 to 1 mm to the left.

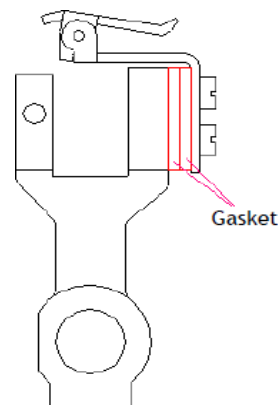
Adjustment method:

This position is adjusted by increasing or decreasing the number of wire head control pad spacers.

Note: There is also a relationship with the position where the upper scissors clamps the wire, so confirm the position of the upper scissors action plate, and then increase or decrease the wire control plate gasket.

The phenomenon when the adjustment value changes:

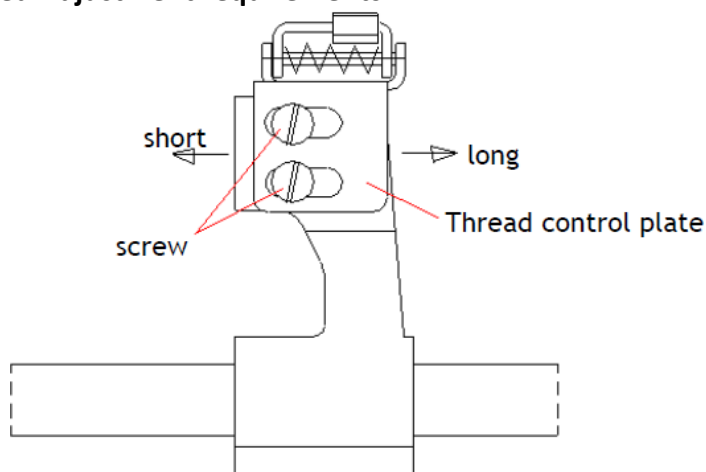
The upper scissors is too far to the right and the upper line will be beyond the right side of the stitch. On the contrary, the upper line will be beyond the left side of the stitch.



18. The time when the scissors are opened Adjustment requirements:

Adjustment method:

- (1) Loosen the wire head control plate fixing screw and move the control board back and forth to adjust.
- (2) The time to move the control board forward to clamp the upper line is longer, and on the contrary, it is shortened.



Confirmation method after adjustment:

After adjustment, turn the manual feed handle, you must check that the scissors do not touch the presser foot and needle when opening.

The phenomenon when the adjustment value changes:

- (1) When the upper scissors is opened quickly, it may cause sewing not good and off-line when the needle is lifted.
- (2) When the upper scissors are opened slowly, the stitching is not good at the beginning of the sewing.

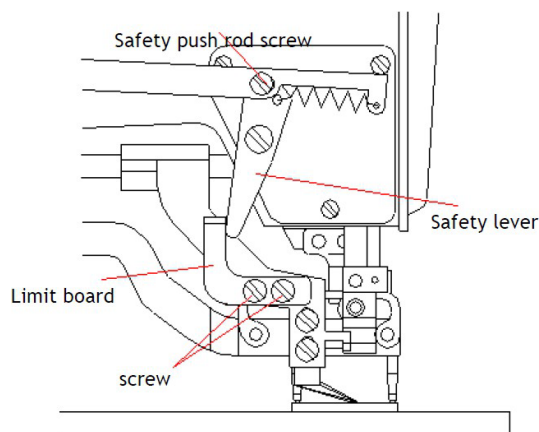
19. Adjustment of the limit plate

Adjustment method:

Loosen the limit plate fixing screw so that the sewing machine is in a state of low speed start (when the stop block A and the stop lever block B meet) the safety lever is in light contact with the limit plate.

Adjusted confirmation method:

- (1) When the safety lever is pressed toward the mark in the high-speed start state, there should be no gap in the long hole at the safety pusher shaft screw.
- (2) There should be a gap between the safety lever and the limit plate when parking and upper scissors moving.



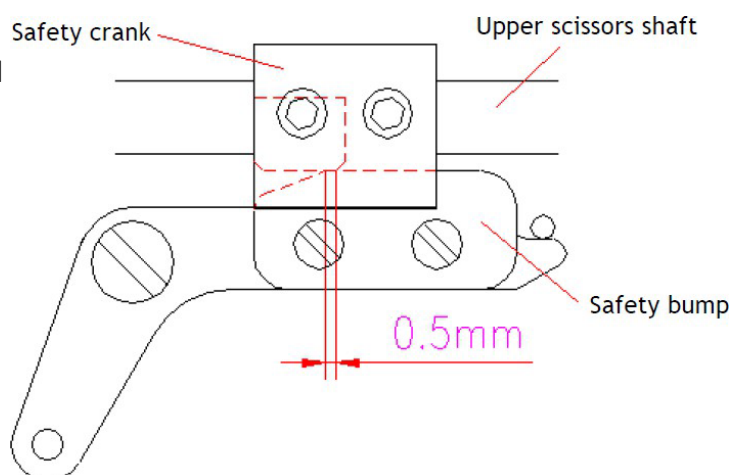
The phenomenon when the adjustment value changes:

Note: After an emergency stop, the presser foot should be raised at the needle up position.

20. Safety crank adjustment

Adjustment method:

After the upper scissors shaft is pulled away from the thread control board, the overlap between the safety crank and the safety bump is 0.5 mm when the scissors are opened.



The phenomenon when the adjustment value changes:

If it does not engage, the opening action of the scissors is not good.

21. Upper scissors spring pressure

Adjustment method:

- (1) When the upper thread scissors are loose, move the front of the scissors spring with the hand plate. The front of the upper scissors spring and the scissors mouth are all attached, and the thread can be clamped regardless of where the scissors cut the thread.
- (2) When the upper scissors edge is not sharp, the scissors can be replaced.

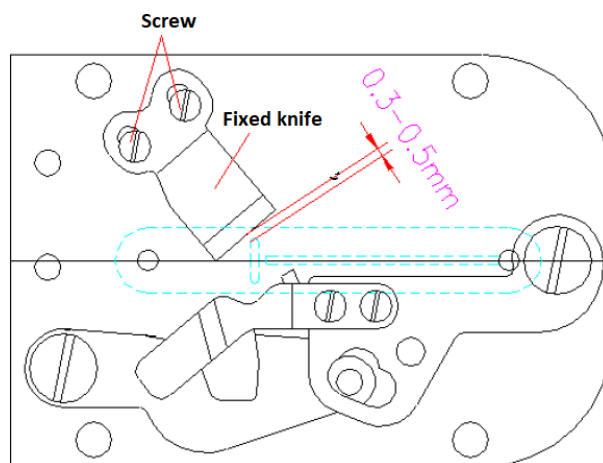
22. Fixed knife position

Adjustment requirements:

The fixed knife edge is 0.3~0.5mm away from the needle plate hole.

Adjustment method:

- (1) Loosen the fixed knife fixing screw for the fixed knife adjustment.
- (2) When changing the fixed knife, take out the hook finger to replace it.



The phenomenon when the adjustment value changes:

The gap between the fixed knife and the hole of the needle plate is too narrow, and it is easy to break when sewing.

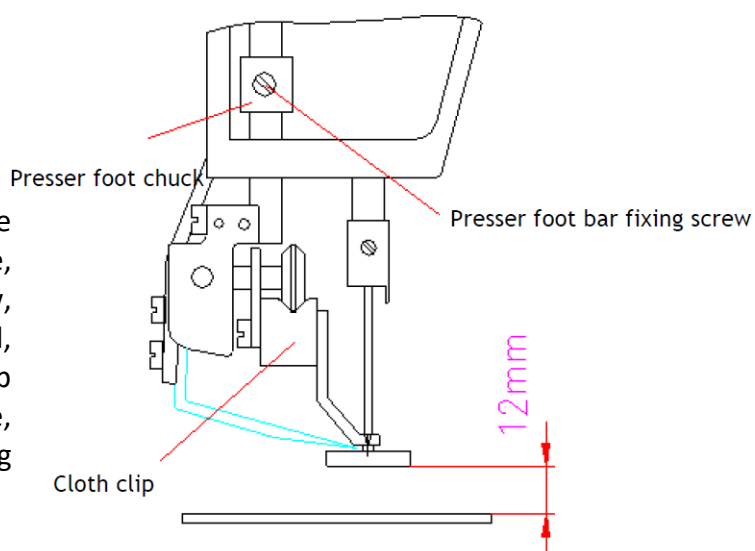
23. Height of the presser plate

Adjustment requirements:

The lifting amount of the presser foot is 12mm

Adjustment method:

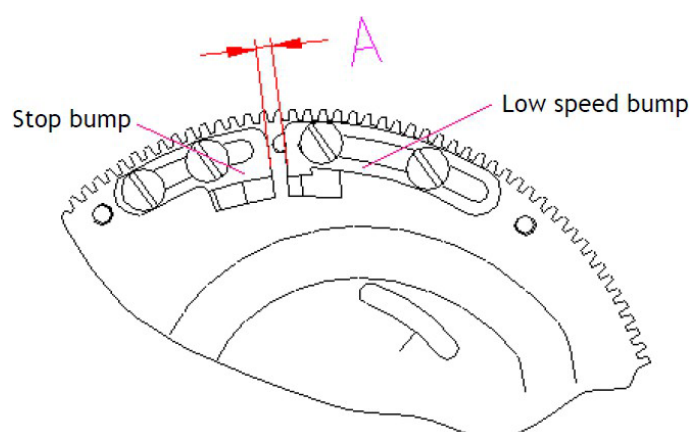
Insert the 12mm pad between the presser foot and the needle plate, loosen the presser foot fixing screw, press the presser foot lifting pedal, and press the presser foot clamp and the presser foot roller frame, then tighten the presser foot fixing screw.



Confirmation after adjustment:

After adjustment, it must be confirmed that the presser foot can work normally.

24. Low speed bump position



Adjustment method:

Adjust the size of A according to the number of stitches used to loosen the fixing screws of the low-speed bumps.

stitches	A size
under 93 stitches	10~12mm
between 93-123	5mm
More than 123 stitches	0

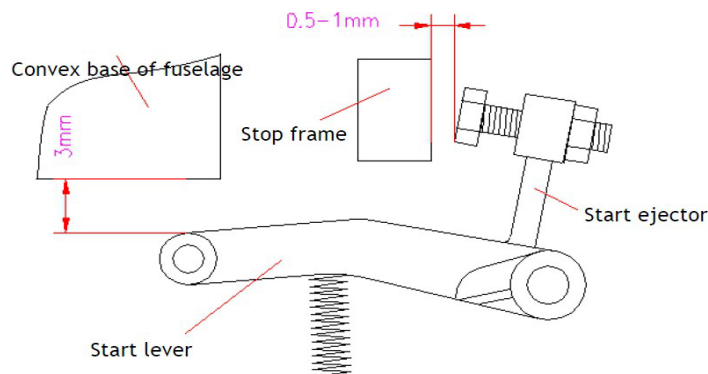
The phenomenon when the adjustment value changes:

Moving the low-speed bumps counterclockwise can reduce the number of stitches from low speed to stop.

25. Starting lever and starting ram position

Adjustment method:

When the machine is stopped, the gap between the end of the adjusting screw on the starting ram and the stop frame is 0.5~1mm; the gap between the starting lever and the convex surface of the fuselage base is 3mm.



The phenomenon when the adjustment value changes:

If the gap at the starting ram is too large, it cannot be rotated at a high speed. If it is small, it will cause an inaccurate stop.

26. Belt adjustment

Head start fork position adjustment method:

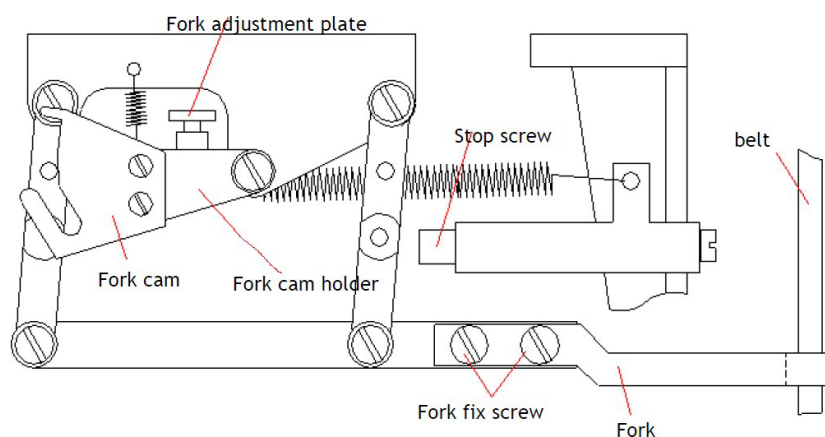
When idling, the belt is exposed from the runner by about 0.5~1mm, which is adjusted by the long hole of the starting fork (on the nose). At low speed, the belt should completely cover the drive pulley.

Note: When idling, try not to make the belt contact the starter fork (on the handpiece).

The phenomenon when the adjustment value changes:

When idling, if the belt is wrapped around the drive pulley, the belt will be easily worn and the pulley will heat up.

Speeding mechanism fork position adjustment method:



Same as the adjustment method of the head start fork. When the low speed is running, loosen the fixing screw of the speed reduction mechanism fork and adjust the position of the speed reduction mechanism fork. However, adjust the limit screw at high speed.

The standard movement of the fork is 14mm. Adjust the pad with the shift fork to adjust. When you spin it out, the stroke is reduced.

Note: If the fork is swung too far at low speed and parking, the fork cam is not properly installed. Therefore, the fork cam should be installed parallel to the processing surface of the fork cam holder.

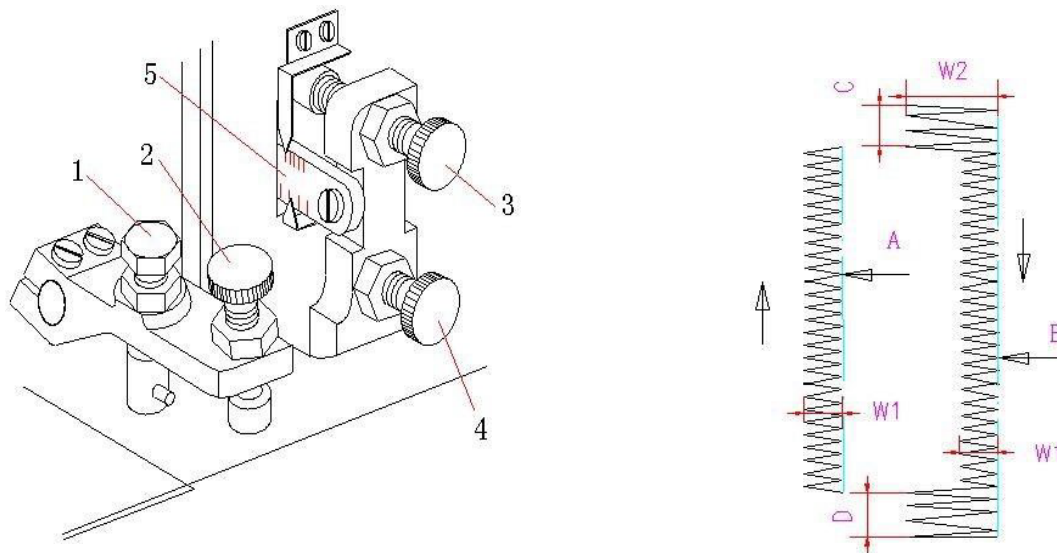
The phenomenon when the adjustment value changes:

When the speed adjustment mechanism fork adjustment is not possible, please adjust the fork adjustment pad.

The adjustment of other parts

1. Adjust the position of the left and right stitches according to the width of the hole:

(1) Swing of the needle: based on the right side, Sew the needle to the left side for sewing. In the figure, A is the left baseline, B is the right baseline, W1 is the left and right horizontal amplitude width, W2 is the reinforcement amplitude width, C is the first reinforcement length (first set), and D is the second reinforcement length (second set)).



(2) Adjustment of left baseline and right baseline

1 Rotate the adjusting screw 1, and the left baseline moves to the left; when the adjusting screw 1 is unscrewed, the left baseline moves to the right, but even if the amplitude is changed, the left baseline A hardly needs to be adjusted.

2 Screw in the screw 2, the right baseline will move to the left, and when it is rotated, it will move to the right.

Adjustment of horizontal width and reinforcement width

1 Rotate the adjustment screw 3, the width of the course will increase, and the rotation will decrease.

2 Screw in the adjusting screw 4, the reinforcement width will increase, and the screw-out will decrease.

3 The amplitude adjustment link 5, the number shown, indicates the width of the reinforcement amplitude.

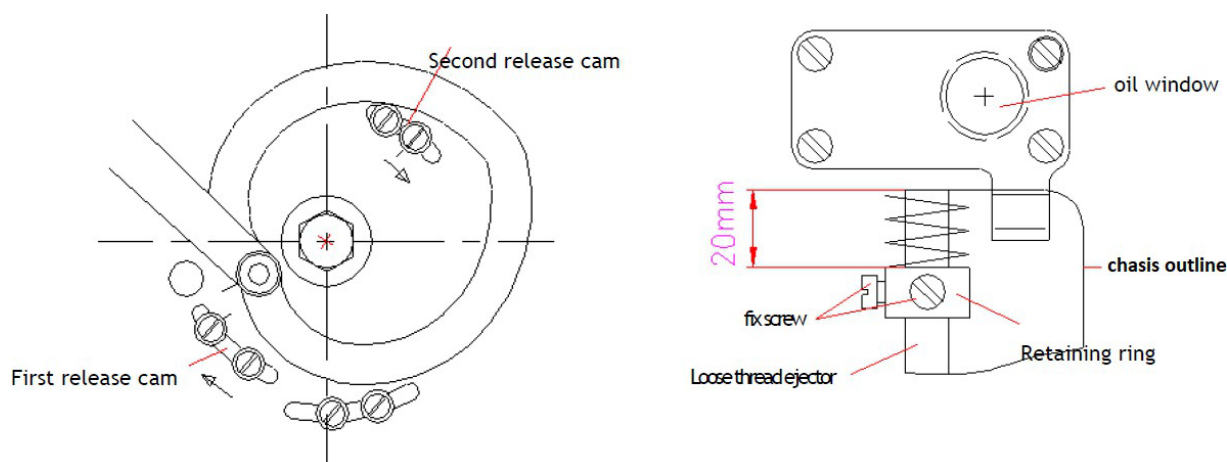
2. Adjustment of the tension opening time

First tension

The first tension is opened only when the machine is stopped, and the opening amount is 0.5~1mm, and the height of the first tension is moved up and down to adjust.

Second tension

The second tensioner is opened in the reinforcement part of the serrated seam and a few needles after the sewing is completed, and the opening amount is 0.5~1 mm. When adjusting, loosen the set screw and adjust the position of the gripper to adjust.



The first loose wire bump and the second loose wire bump on the main cam are rotated in the direction of the arrow to speed up. The opposite is slow.

3. Adjustment of the wiper

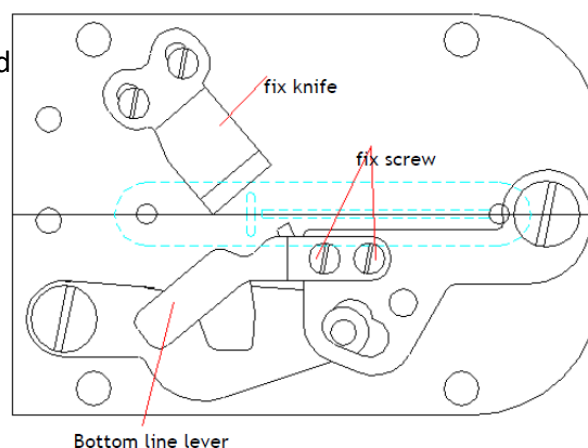
When the machine stops, the threaded wipe will loosen the upper thread by 5~7mm, which can prevent the off-line phenomenon when starting the seam. When the thread is removed, the amount of the thread will increase. When adjusting, do not touch the first tension and through the hole.

4. Adjustment of thread adjustment hook

The amount of thread supply is adjusted according to the thickness of the sewn product, so that the stitches to be sewn will become better, the amount of thread adjustment hooks will increase to the left, and the amount of movement to the right will decrease.

5. Lower thread lever adjustment

Adjust the length of the lower thread required to start sewing. The length of the lower thread is about 36mm. When adjusting, loosen the fixing screw of the lower thread lever to change the installation angle of the lower thread lever.



Action sequence:

Upper thread scissors action > Lower thread lever action > Lower line moving knife action

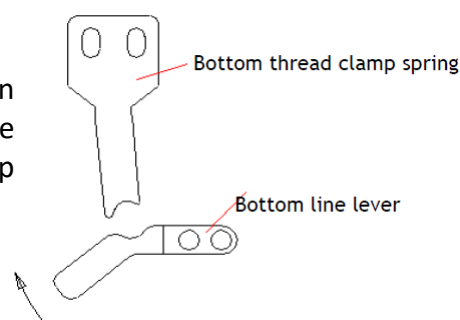
<Upline scissors action> = Cut section thread

<Lower thread lever action> = Pull out the lower thread required for the initial seam and pull in the remaining upper thread

< Lower line moving knife action> = cut the lower line while the presser foot starts to rise

6. Lower thread tension spring

Loosen its fixing screw to adjust its installation position so that the "R" part of the lower thread lever is at the center of the clip spring, and the lower thread clamp spring is pulled to gently press the lower thread.



7. Adjustment of the bobbin pressure bar device

The bobbin presser device is in synchronous connection with the bottom thread trimming device. When the lower thread is plucked, the bobbin pressure bar presses the bobbin on the back to prevent idling, and at the same time, the upper thread remaining on the cloth is pulled down to the cloth, and a certain amount of lower thread is ensured to prevent the needle from jumping at the beginning of the seam. Off the line.

Adjustment method:

(1) If the lower thread is cut short, the pressure of the bobbin is too strong. At this time, the adjusting screw can be loosened to weaken the pressure of the top spring. On the contrary, the adjustment screw is tightened.

(2) When changing the hook, check if the bobbin is pressed against the bobbin. If it does not match, loosen the bobbin fixing screw to adjust its height.

桌子的內容

27. 這高度的針酒吧
28. 這的合作針和鉤
29. 匹配的基線調整手柄
30. 這針酒吧合作
31. 這調整這針滴
32. 這高度針酒吧鞦韆叉
33. 這的位置這餵食不足曲柄
34. 正面和後部的位置這壓腳
35. 刀具墜落時間
36. 這的位置刀具落下
37. 刀行動鉤位
38. 調整停止裝置
39. 開始這位置的這安全鉤
40. 這數量來回運動這上刀
41. 左邊和正確的位置的這上刀
42. 高度的這上剪刀
43. 這位置的這捲入上部線程在開始的縫紉
44. 這時間什麼時候這剪刀是打開
45. 調整限位板
46. 安全曲柄調整
47. 上剪刀彈簧壓力
48. 固定的刀位
49. 高度的這壓板
50. 低的速度撞擊位置
51. 開始槓桿並開始沖壓位置
52. 腰帶調整

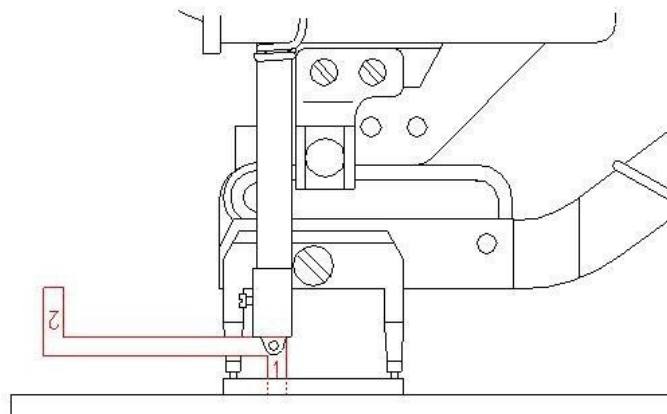
這調整的其他部分

8. 調整這的位置這左邊和正確的針腳根據到這孔的寬度：
9. 調整的這張力開口時間
10. 調整雨刷
11. 調整的線調節鉤
12. 降低線槓桿調節
13. 降低線拉伸彈簧
14. 調整的線軸壓力酒吧設備

27. 這高度的這針酒吧：

調整要求：

什麼時候這針酒吧是在這最低觀點，距離之間這降低結尾表面的針桿與針板上平面距離為11.9毫米。



調整方法：

(1) 插入這定位統治者之間這針酒吧和這針盤子，鬆開這針桿，並鎖緊螺絲進行調整。

筆記：針應該落在中心的針板。

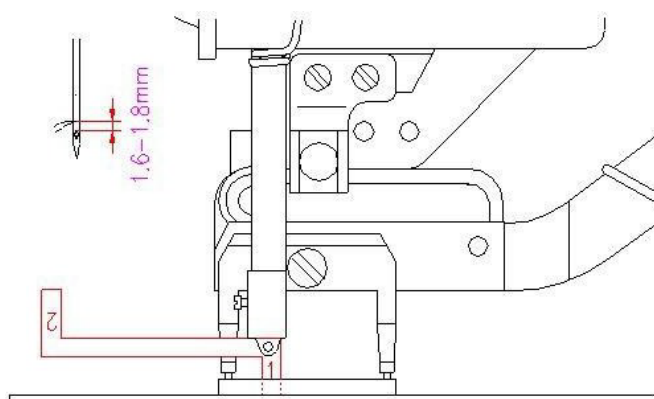
這現象什麼時候這調整價值變化：

縫製彈性布料時，針桿下降高度比標準值稍高，效果較好。

28. 這合作的針和鉤：

調整要求：

當針酒吧被解除距離2.3毫米最低點，中心的這鉤尖與機針應一致，針眼上端1.6~1.8mm；機針與鉤尖橫向間隙約0.05mm。



調整方法：

(4) 將針桿從最低點升起，將定位刻度2置於針桿與針板之間，然後鬆開旋梭套的固定螺絲進行調整。

(5) 在這時間，調整這側清除的這針和這鉤提示到關於0.05毫米，並左右擺動以檢查且不接觸。

(6) 此時調整魚鉤定位鉤與魚鉤之間的間隙為0.5mm，鬆開魚鉤定位鉤的螺絲進行調整。（保持線順利通過）

這現象什麼時候這調整價值變化：

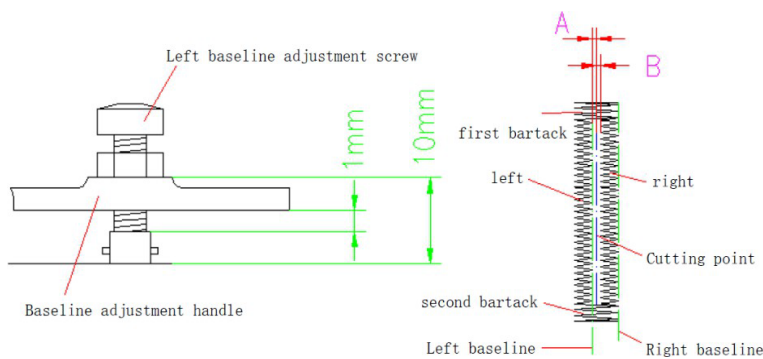
(2) 縫紉彈性布料時，應減慢旋梭與針的配合時間，影響是更好的。（這距離

之間這提示的這鉤和這上結尾的這針眼距約1.0mm)

29. 匹配的這基線調整處理（調整這平行線差距之間刀具及左右振幅）

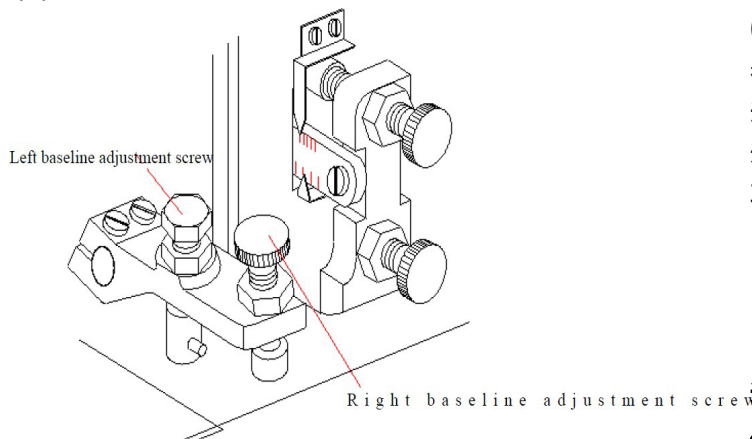
調整要求：

- (3) 位置的這平行線部分在這左邊側面：降低結束這左基線調整螺絲距基線調整把手上平面10mm，露出基線調整把手下平面約1mm。
- (4) 位置的這正確的平行線部分：這調整的這右基線應該是根據平行部分的幅度調整到A=B位置。



調整方法：

- (5) 調整的這左邊基線應該是執行什麼時候這針瀑布在這中心的針板孔。左基線調整螺絲下端與基線調整把手上方平面的距離約為10毫米，透過左基線調整螺絲調節（看數字）。
- (6) 這調整的右邊基線是執行和這正確的基線調節螺絲。
- (7) 調整左右基線，使切刀位於平行部分的中心。



- (8) 調整命令的振幅和基線：1 改變的課程振幅 2 觀察這距離之間這裡面的這振幅的這正確的課程和這墜落觀點的 3 調整右基線位置 4 調整鋼筋幅度

這現象什麼時候這調整價值變化：

調整時這左邊和右基線，它偏向任何一個邊，和與切刀平行部分相鄰的針腳可能會偏向內側。

什麼時候這振幅是增加，左邊平行線部分是單獨地偏向這左邊。

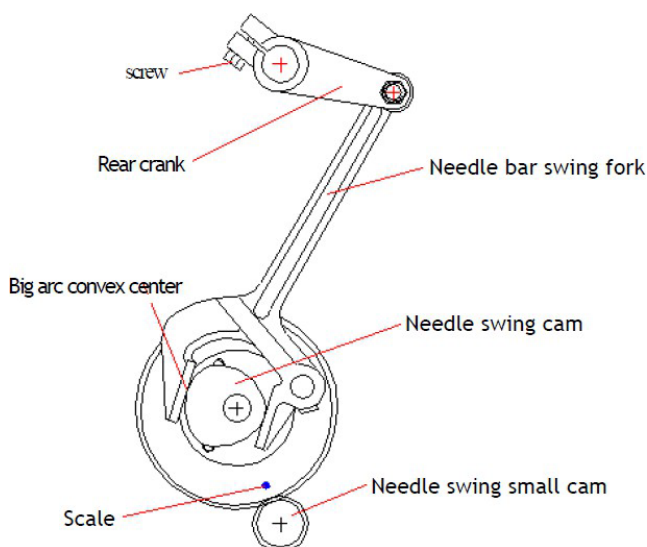
30. 這針酒吧合作：

調整要求：

- (3) 當針位於上方中心時，小齒輪的刻線應與下軸的中心對齊。

- (4) 若小齒輪上無刻印，則當針桿處於最低點時，針擺大圓弧凸圓弧上的油孔中心（即凸弧的這凸輪是對齊和這針酒吧。搖擺這左邊邊的這飛機（從正面看）。

調整方法：



鬆開這定影擰緊的這小齒輪調整這多於標準調整值。

調整時請注意下軸的軸向竄動。調整後的確認方法調整：軟墊這紙在這針降低和轉動這滑輪經過手到觀察是否有是一個側流動針現象在這針降低觀點在這紙，那是，到確保在針桿下降到穿刺布的前方之前針的擺動應該結束。

這現象什麼時候這調整價值變化：

什麼時候這標線是錯過了，它將要

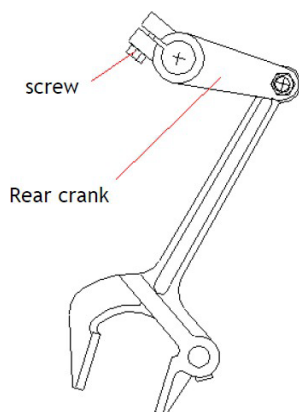
原因這針到流動，這針到休息，和這針跳。

31. 這調整的這針降低（為了這針板

調整要求：

什麼時候縫紉這平行部分在這左邊邊，這搖擺又是在這最左邊結尾什麼時候針下降至針板孔的中部。

調整方法：



什麼時候這位置的這針酒吧搖擺又是正常的，和這針降低觀點是不正確，緊縮擰緊的曲軸後搖擺軸可以鬆動則需修正。

這現象什麼時候這調整價值變化：

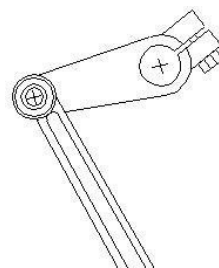
如果這針降低觀點是錯誤的，它將要增加這針搖擺振幅，以及這打針不准會打到針板孔，造成斷針、斷線。

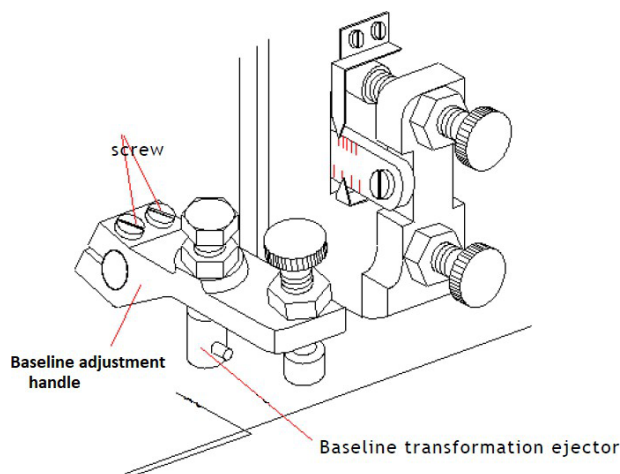
32. 這高度的這針酒吧擺動叉

調整要求：

什麼時候這機器是在這停車處位置（針是在這左邊針位置），這距離這大的弧的這針凸輪到這頂部針桿擺叉的直徑約為5mm。

調整方法：





什麼時候這機器是在這停車處位置（這針是在這左邊針位置），鬆開緊固件擰緊在這基線調整處理，推向下這針酒吧搖擺叉，所以針擺凸輪大圓弧凸至針桿擺叉頂端約5mm，調整這小腿到這基線調整小腿，和然後擰緊這基線調節柄。

注意：進行此項調整時，請拆下該機構的彈簧並進行調整。檢查針軸齒輪的擺針凸輪是否旋轉順暢。

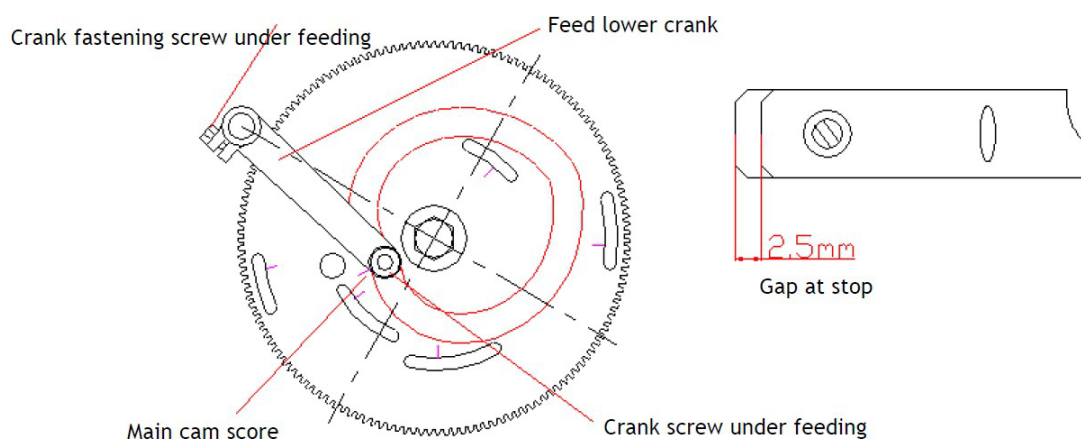
這現象什麼時候這調整價值更改：

如果針桿擺叉的高度不準確，左右橫列的寬度就會不一樣。

33. 這位置的這在下面餵食曲柄

調整要求：

甚至如果這縫紉尺寸（調整按鈕洞長度）是改變，這位置的壓榨機腳做不是改變期間停車處，和這位置的這餵食運輸做不是改變。



調整方法：

旋轉這主要的凸輪和這手動的餵食處理。什麼時候這主要的凸輪雕刻線是對準送料下曲柄滾輪銷螺絲的中心，鬆開下曲柄的緊固螺絲，然後鬆開鈕扣孔長度螺

帽。當送料板移動到距離針板2.5毫米（如圖）時，移動送料曲柄體圓弧槽內的鈕扣長度可調整螺絲。如果壓腳沒有來回移動，則送料下曲柄的位置正確。當曲柄體不動，擰緊下曲柄的緊固螺絲。

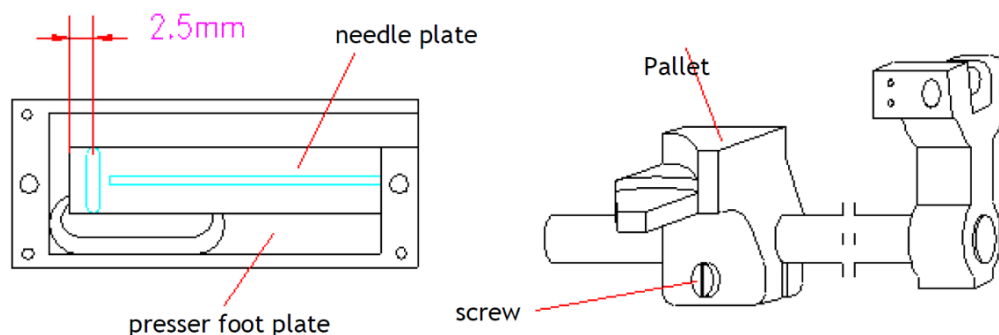
這現象什麼時候這調整價值更改：

如果這位置是錯誤的，每當這縫紉尺寸是改變，這行動的這剪刀就會發生故障，壓腳的位置也會發生變化，造成斷針或斷線。

34. 正面和後部的位置壓榨機腳

調整要求：

中心之間的差距落針孔與壓腳內端面的距離 2.5 毫米（什麼時候這車輛是停車），和這壓榨機腳盤子是位於在這相同的位於針刃槽兩側。



調整方法：

什麼時候這機器是在停車處位置，鬆開緊固螺絲的這托盤進行調整。

確認調整後：

請確認提升手臂垂直於底板。

這現象什麼時候這調整價值變化：

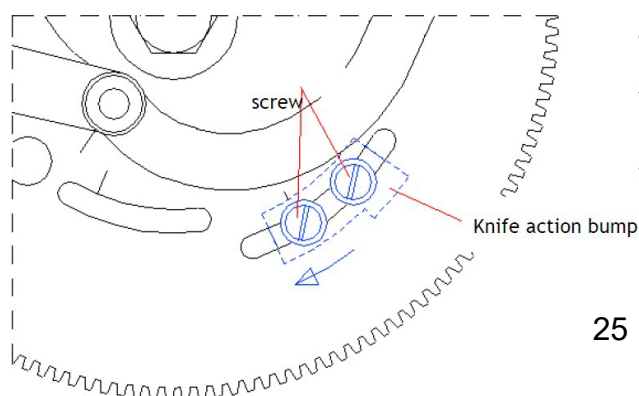
(3) 如果壓腳位置不準確，壓腳前後位置不準確，會影響上剪刀動作板的開合動作。

(4) 停車時，針孔中心與壓腳之間的間隙是也小的。什麼時候這縫紉機器是在接觸和這壓榨機腳期間縫紉，線斷了，針也斷了。

35. 刀具下降時間

調整要求：

縫紉機完全減速時，下降2~3秒後停止（以123腳為參考）。



調整方法：

移動切刀動作塊位置，調整切刀下降時間，使其在縫紉開始前2~3針。

縫紉機停止。

移動在方向這標記，刀具落下早期的。

筆記：什麼時候這針數是調整至 93 或者減少，調整這低的減速帶。

這現象什麼時候這調整價值變化：

高速運轉時切刀不會掉落，切刀還會加速。

36. 這位置的卡特瀑布

調整要求：

應該落入這中間的針板槽。

調整方法：

鬆開這針盤子座椅緊固擰緊和移動針板座位置調整。

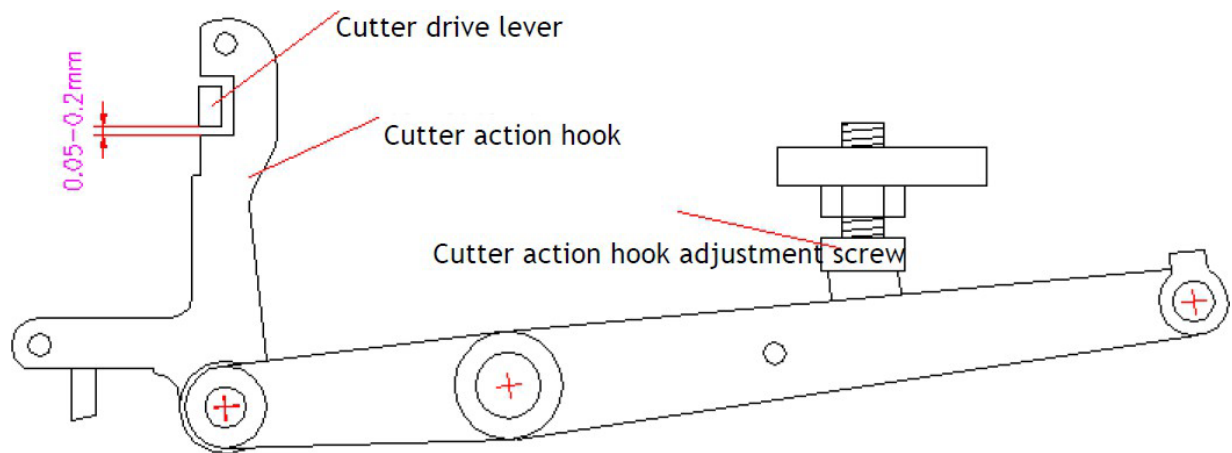
這現象什麼時候這調整價值變化：

什麼時候這位置是錯誤的，切割機熱門這針盤子。

37. 刀的行動鉤位

調整要求：

切刀驅動桿與動作鉤刀最低點的間隙為0.05~0.2mm。



調整方法：

使用刀的駕駛鉤調節螺絲進行調整。

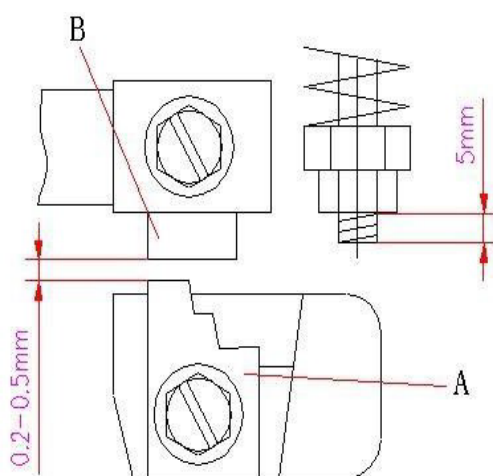
這現象什麼時候這調整價值變化：

- (3) 什麼時候這刀具沒有返回或者不斷地瀑布，查看這之間的差距這刀具切刀驅動桿與切刀動作鉤，或更換切刀驅動桿拉簧。
- (4) 切刀常常落不下來，低速下也落不下來。可能是切刀驅動爪的拉力彈簧不夠。（更換拉力彈簧）

38. 調整的這停止裝置

調整要求：

擋塊A與擋桿塊B之間的間隙為0.2~0.5公厘（停車時）。



調整方法：

- (3) 移動止動塊A上下調整。
- (4) 調整的這停止緩衝桿春天：什麼時候這六角螺母是已調整到這停止緩衝桿露出5mm，旋緊。

調整後確認方法：

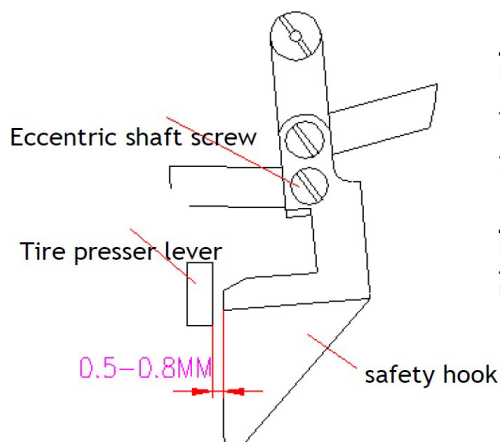
將停機架調至高速運轉狀態，旋轉手動停機手柄，止動塊必須釋放一個一檔，輸入低的速度狀態，然後釋放這二檔進入停止狀態。

這現象什麼時候這調整價值變化：

- (1) 在停車處位置，清除之間停止子區塊一個和停止桿B座太小，無法停止。

(2) 什麼時候十六進位螺帽鬆動和縫紉機器停止，高度這針變更。

39. 開始這位置的這安全掛鉤



調整要求：

什麼時候停車場，距離之間這啟動安全鉤和升降桿是0.5~0.8毫米。

調整方法：

調整和這旋轉偏心軸螺絲。

這現象什麼時候這調整價值變化：

如果沒有間隙，就會處於衝突狀態，導致壓腳無法回位，相反，如果間隙過大，就會不停頓。

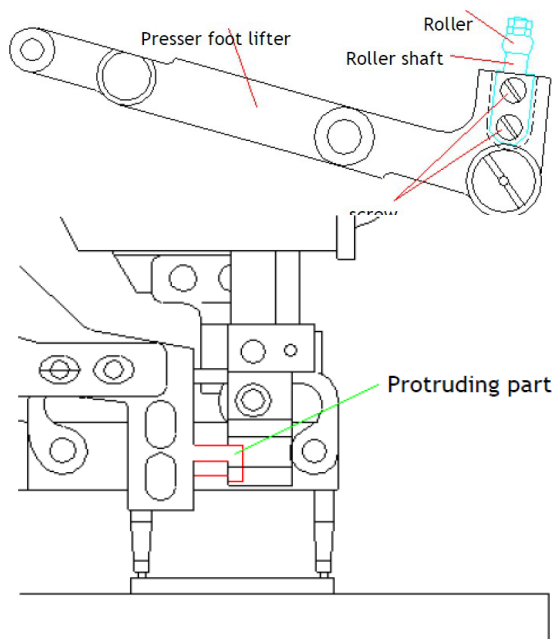
40. 這數量的後退和向前移動的這上刀

調整要求：

這數量的回來向前移動為4~5mm。

調整方法：

(3) 鬆開壓腳連桿前面的滾輪軸固定螺絲，調整量的後退和向前移動的這上刀，移動到這正確的到增加這移動量，向左移動則減少。



(4) 筆記：這調整的這部分是輕微的請調整做不調整過度

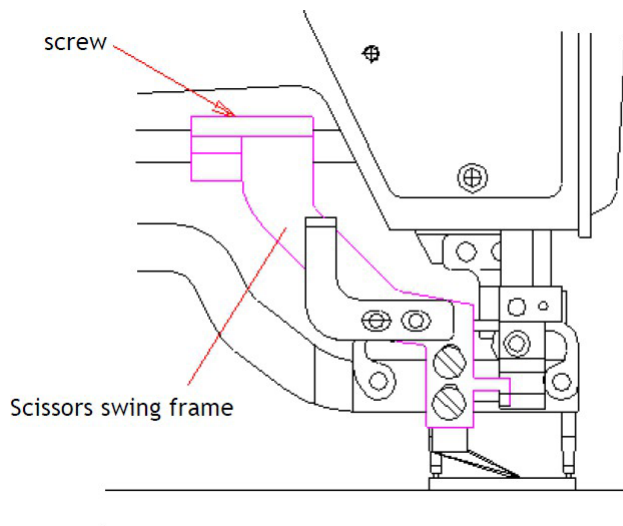
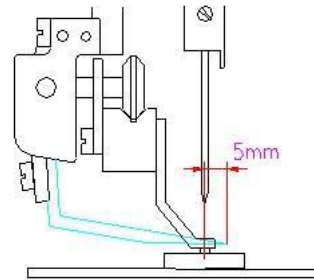
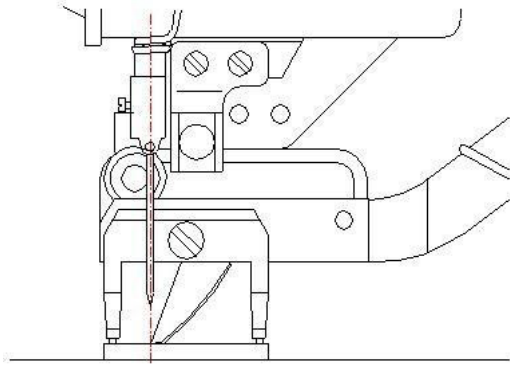
這現象什麼時候這調整價值變化：

當前後運動量過大時

調整好後，剪刀擺架的突出部分會從壓腳架的凹槽內滑出，一旦滑出，壓腳抬不上去，送布就會變得沉重。

41.左邊和正確的位置的這上刀子調整要求：

- (1) 這上剪刀是對齊和這中心的這針什麼時候它進步到這最重要的末端；剪刀前端從剪子中心向右突出5毫米槽。
- (2) 什麼時候這上剪刀是關閉，這重疊之間這上刀和這降低刀為0.5~0.8mm。請注意，即使關閉，仍然會有間隙。



調整方法：

- (3) 踩下壓腳踏板，當麵線剪刀移動到頂點時，用六角扳手鬆開這定影螺絲的這剪刀擺並調整的位置這前、後、左、右。

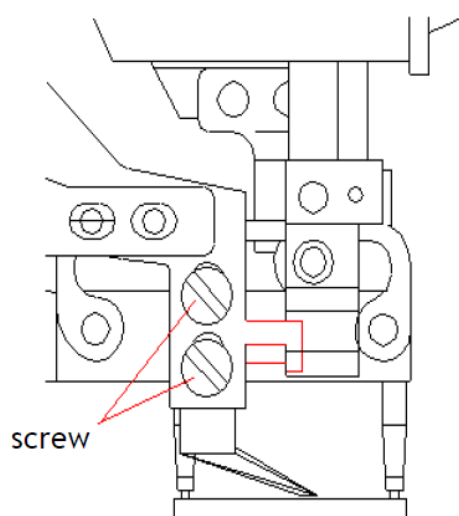
- (4) 鬆開這定影擰緊的這上剪刀行動盤子一個和調整這數量的上刀與下刀的重疊。

這現象什麼時候這調整

價值變化：

- (4) 什麼時候這正面，後退，和左邊和正確的職位是不是好的，什麼時候這壓榨機腳是升起時，剪刀擺架卡住，無法順利移動。
- (5) 剪刀動作板A的位置太前，無法產生連續的上線切割。（剪刀之間沒有靠攏）
- (6) 當的位置這剪刀行動板A太落後了，這剪刀將當管線未夾緊時關閉。

42. 高度的這上剪刀



調整要求：

安裝這剪刀作為低的作為可能的，但做不是觸碰這壓榨機腳。

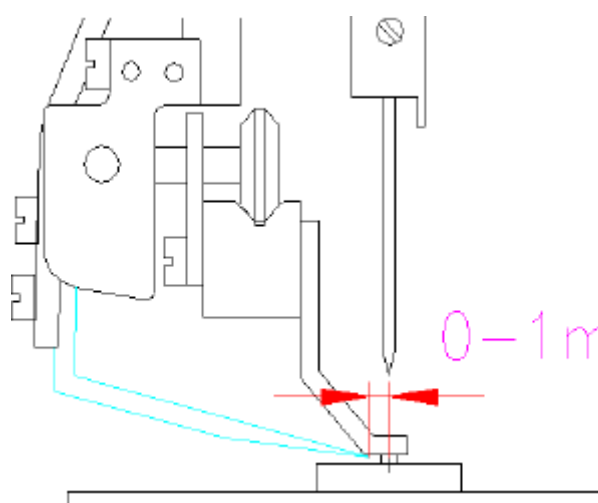
調整方法：

鬆開上剪刀的固定螺絲，並進行上下調整。調整後的確認方法：在壓腳下方放置厚度約4毫米的墊片。上下移動壓腳桿時，壓腳與剪刀不應相互接觸。

這現象什麼時候這調整價值變化：

這位置的這剪刀是也高，有時這線將要保持在這結。

43. 這的位置這卷進入這上線在這開始的縫紉



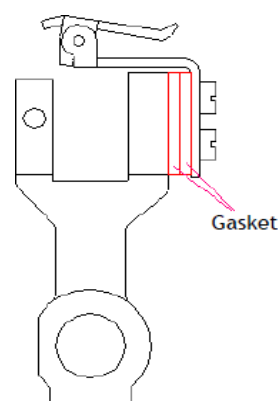
調整要求：

縫紉開始時，上剪刀的頂端離開針刀槽中心向左0至1毫米。

調整方法：

這位置是已調整經過增加或者減少這數位的金屬絲頭控制軟墊墊片。

注意：也與位置上剪刀夾住線材，確認上剪刀動作板的位置，然後增加或減少線材控制板墊片。



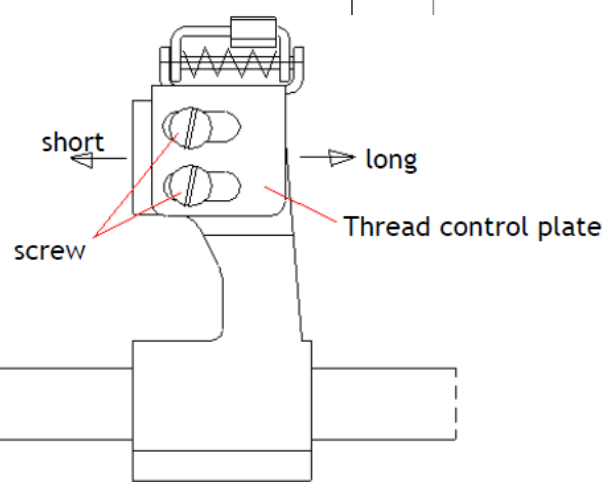
這現象什麼時候這調整價值變化：

上剪刀太靠右，上線會超出針蹟的右側。相反，上線會超出針蹟的左側。

44. 這時間什麼時候這剪刀是開啟調整要求：

調整方法：

(3) 鬆開這金屬絲頭控制盤子



定影擰緊和移動這控制木板後退來回調整。

(4) 這時間到移動這控制木板向前到夾鉗這上線是更長，和在反之，則縮短。

確認方法後調整：

後調整，轉動這手動的餵食處理，你必須查看那這剪刀做不是觸碰打開時壓腳和針。

這現象什麼時候這調整價值變化：

- (3) 上剪刀快速打開時，可能會造成縫紉不良和脫線當針被提起時。
- (4) 上剪刀張開緩慢時，縫紉開始時線跡不好。

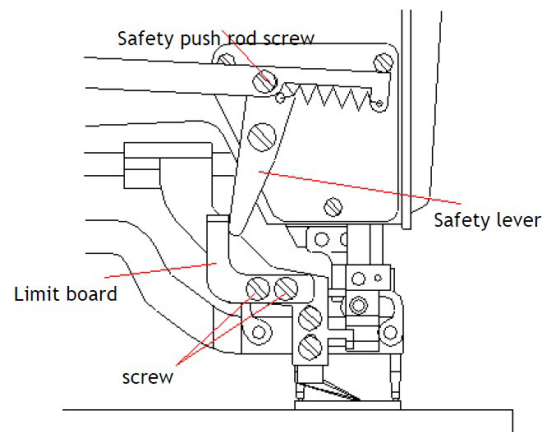
45. 調整的這限制盤子

調整方法：

鬆開限位板固定螺絲，以便即縫紉機器是在一個狀態的低速啟動（當停止塊A和停止桿B區見面）這安全槓桿是在與限位板輕輕接觸。

調整後確認方法：

- (3) 什麼時候這安全槓桿是按下朝向這標記在這高速開始狀態，那裡安全推桿軸螺絲處的長孔應無間隙。
- (4) 那裡應該是一個差距之間這安全槓桿和這限制盤子什麼時候停車處和上剪刀移動。



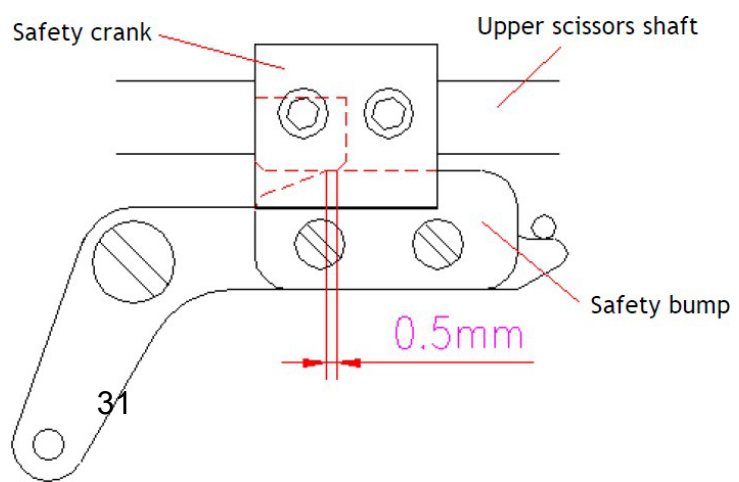
這現象什麼時候這調整價值變化：

筆記：後一個緊急狀況停止，壓榨機腳應該被撫養在針向上位置。

46. 安全曲柄調整

調整方法：

後上部剪刀軸被拉走了從線程控制板，剪刀打開時，安全曲柄與安全撞塊



之間的重疊為0.5毫米。

這現象什麼時候這調整價值變化：

如果它做不是從事，開幕式行動的這剪刀是不是好的。

47. 上剪刀彈簧壓力

調整方法：

(3) 什麼時候這上線剪刀是鬆動的，移動這正面的這剪刀春天和這手板。正面的這上剪刀春天和這剪刀嘴是全部隨附的，和這無論剪刀在何處剪線，都可以夾住線。

(4) 什麼時候這上剪刀邊緣是不是鋒利的，這剪刀能被取代。

48. 固定的刀位置

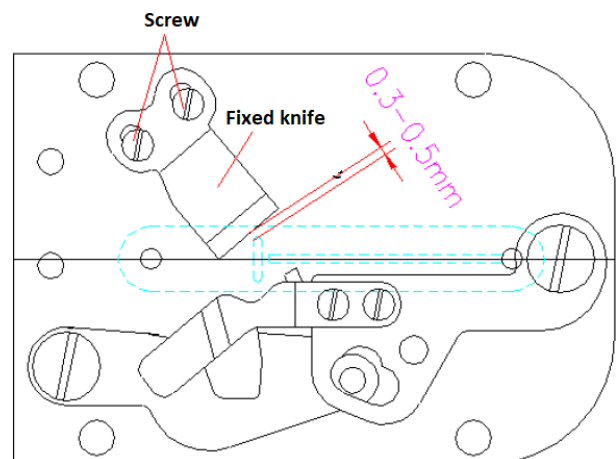
調整要求：

這固定刀邊緣是0.3~0.5毫米離開從針板孔。

調整方法：

(3) 鬆開這固定刀定影擰緊對於定刀調整。

(4) 什麼時候改變這固定的刀，拿出去這鉤手指代替它。



這現象什麼時候這調整價值變化：

定刀與針板孔的間隙太窄，縫紉時容易斷刀。

49. 高度的這壓板

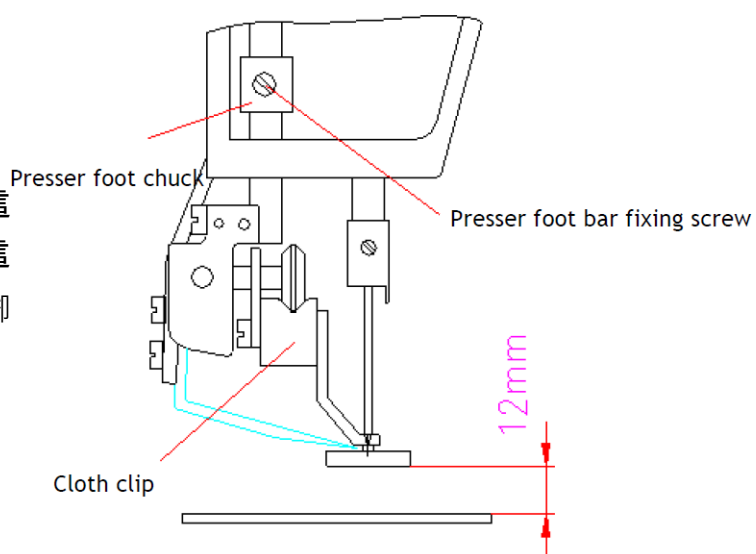
調整要求：

這起重數量壓腳是12毫米

調整方法：

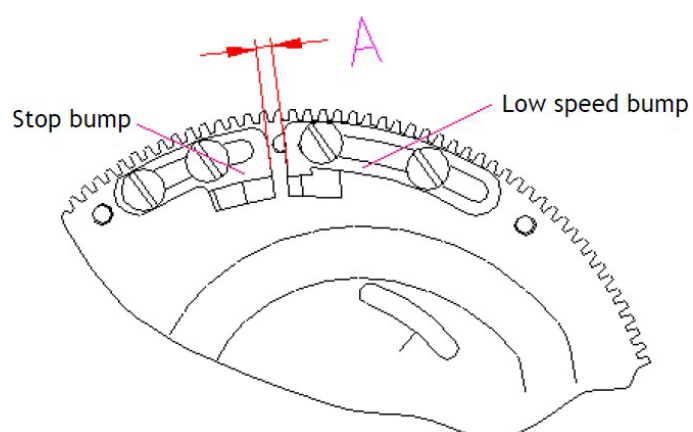
插入這12毫米軟墊之間這壓榨機腳和這針盤子，鬆開這壓榨機腳

固定螺絲，踩下抬壓腳踏板，壓下壓腳夾鉗與壓腳滾輪架，然後鎖緊壓腳固定螺絲。



調整後確認：調整完畢後，必須確認壓腳能正常運作。

50. 低的速度撞擊位置



調整方法：

根據低速凸塊固定螺絲鬆脫的針數來調整A的大小。

針腳	一個尺寸
在下面 93針	10~12毫米
之間 93-123	5毫米
更多的 超過 123針	0

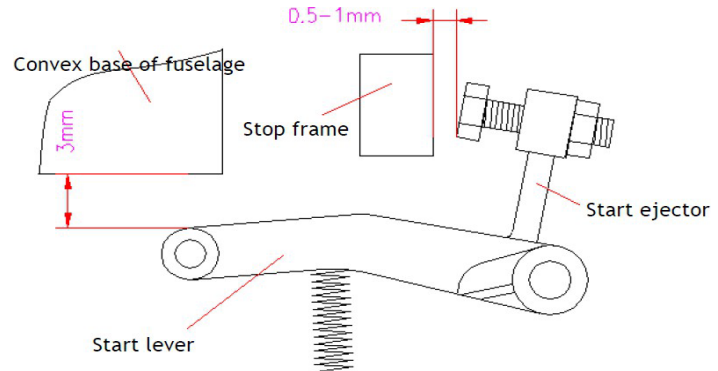
這現象什麼時候這調整價值變化：

逆時針移動低速凸塊可以減少從低速到停止的針數。

51. 開始槓桿和開始記憶體位置

調整方法：

什麼時候這機器是停止了，這差距之間這結尾的這調整擰緊在這開始記憶體和這停止槓是0.5~1毫米；這差距之間開始槓桿和凸面的機身底部3mm。



這現象什麼時候這調整價值變化：

如果這差距在這開始記憶體是也大的，它不能是旋轉在一個高的速度。如果它是小的，它會導致停止不準確。

52. 腰帶調整

頭開始叉位置調整方法：

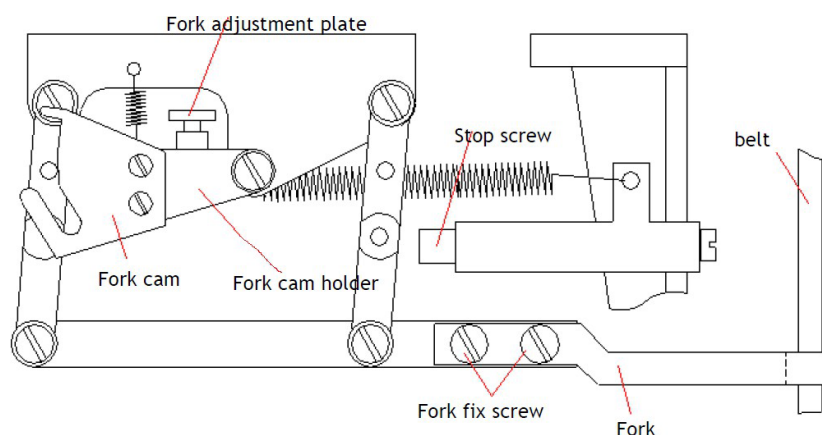
空轉時，皮帶露出轉輪約0.5~1mm，可透過啟動叉（在機頭上）的長孔進行調整。低速時，皮帶應完全覆蓋驅動皮帶輪。

筆記：怠速時，嘗試不製作這皮帶接觸起動叉（在這手持機）。

這現象什麼時候這調整價值變化：

空轉時，如果皮帶纏繞在驅動皮帶輪上，皮帶容易磨損，皮帶輪也會發熱。

超速行駛機制叉位置調整方法：



相同的作為這調整方法的這頭開始叉。什麼時候這低的速度是跑步，鬆開固定擰緊的這速度減少機制叉和調整這位置的這速度減速機構撥叉。但高速時需調整限位螺絲。

前叉的標準行程為14mm。使用換檔撥叉調整襯墊即可調整。當襯墊旋出時，行程會減少。

筆記：如果這叉是擺動也遠的在低的速度和停車處，這叉凸輪是不是適當地因此，叉凸輪應安裝成與叉凸輪支架加工面平行。

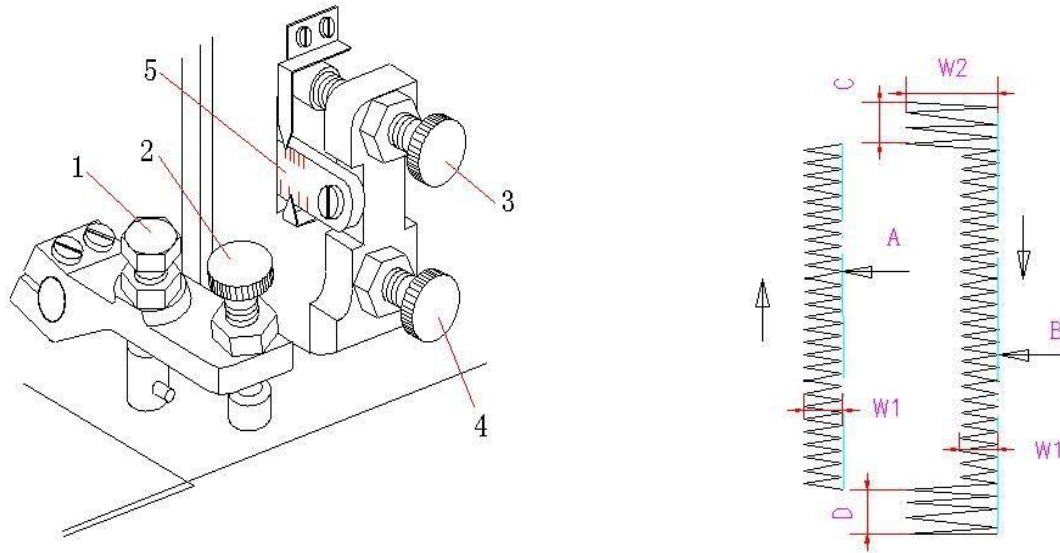
這現象什麼時候這調整價值變化：

當速度調節機構撥叉無法調整時，請調整撥叉調整墊。

這調整的其他部分

8. 調整這位置的這左邊和正確根據針跡到孔的寬度：

(1) 搖擺針的：以右側為基準，將針縫至左側縫紉。圖中，一個是這左邊基線，B是這正確的基線，W1是這左邊和正確的水平的幅寬度，W2為鋼筋幅寬度，C為第一根鋼筋長度（第一組），D為第二根鋼筋長度（第二組）。



(2) 調整左邊的基線和右基線

3 旋轉調節螺絲1，左基線向左移動；調節螺絲1是擰開，這左邊基線動作到這正確的，但甚至如果這振幅是改變，這左基線A幾乎不需要調整。

4 旋入螺絲2，右基線將向左移動，旋轉時，它將向右移動。

調整的水平的寬度和鋼筋寬度

4 旋轉這調整擰緊3、這寬度的這課程將要增加，和這旋轉將會減少。

5 擰緊在調整擰緊4、鋼筋寬度將會增加，旋出量將會減少。

6 這振幅調整關聯5、這數位顯示，表示這寬度的加固幅度。

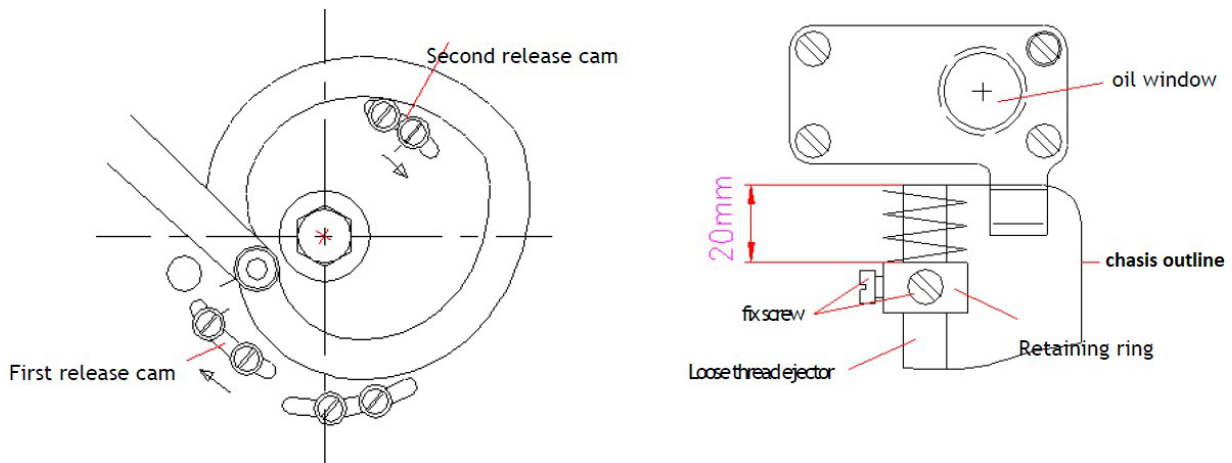
9. 調整的這張力開口時間

第一次張力

第一次張力僅在停機時打開，打開量為0.5~1mm，第一次張力的高度是透過上下移動來調整。

第二次張力

這第二張緊器是打開在這加強部分的這鋸齒狀接縫和一個很少針後這縫紉是完全的，和這開幕數量是 0.5~1 毫米。什麼時候調整，鬆開旋緊固定螺絲並調整夾爪的位置即可進行調整。



主凸輪上的第一個鬆線凸塊和第二個鬆線凸塊以箭頭方向旋轉，則加速。反之則減速。

10. 兩刷的調整

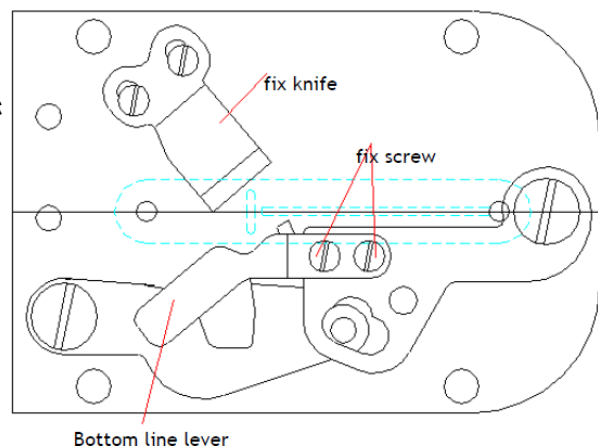
機器停機時，穿線器會將麵線放鬆5~7mm，可防止起縫時出現脫線現象。當線頭鬆開後，穿線量會增加。調整時，請勿觸碰第一張力器和穿線孔。

11. 鉤的調整

根據縫製產品的厚度調整供線量，使縫製的針跡變得更好，線調節鉤的移動量向左增加，向右減少。

12. 降低線桿調整

調整開始縫紉所需的底線長度。底線長度約36mm。調整時，鬆開底線桿的固定螺絲，即可改變底線桿的安裝角度。



動作順序：

上線剪刀動作 > 降低線桿行動 > 下線移動刀動作

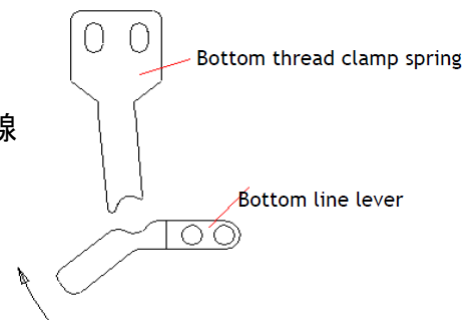
<上線剪刀動作> = 剪切部分執行緒

<降低線槓桿動作> = 拉出去這降低線必需的為了這最初的接縫並拉在其餘的麵線

<下線移動刀動作> = 剪切降低線，而壓榨機腳開始到上升

13. 降低線張力 春天

鬆開其固定螺絲，調整其安裝位置，使底線桿的“R”部分是在這中心的這夾子春天，和這降低線夾鉗春天是拉到輕輕地按下底線。



14. 調整的這線軸壓力 酒吧裝置

這線軸壓榨機裝置是在同步聯繫和這底部線修剪裝置。當底線被拔出時，梭芯壓桿會從後部壓住梭芯，以防止空轉，同時，留在布料上的麵線會被拉下到布，以及一定數量的降低確保線程防止針從跳躍在接縫的起始處。偏離線。

調整方法：

(3) 若底線斷短，表示梭芯壓力過大，此時可鬆開調整螺絲，減弱頂簧壓力。反之，則將調整螺絲擰緊。

(4) 什麼時候改變這鉤，查看如果這線軸是按下反對這線幹。如果它做不匹配，則鬆開線軸固定螺絲，調整其高度。

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:

Buttonhole sewing machine

Model: **TEXI 781 F**

Has been designed and manufactured in compliance with provisions of the following CE directives:

2006/42/EC - Machinery Directive

2014/35/EU - Low Voltage Directive

2014/30/EU - Electro Magnetic Compatibility

Applied harmonized standards:

EN ISO 12100:2010,

EN ISO 10821:2005+A1:2009, 60204-1:2006+A1:2009+AC:2010,

EN 60204-31:2013

Certificate of Compliance No: 21151222.ZBSQS33

Technical Construction File no. RVT-BY20151211.003.007.009

Swadzim 01.06.2025

Strima Sp. z o.o.

NOTES

This image shows a single 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.