

INSTRUCTION MANUAL

TRECCIA 1F
TRECCIA-C 3F

Industrial interlock sewing machine



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1. IMPORT SAFETY INSTRUCTIONS

1. Transportation

- (1). The machine packed with machine cover.
- (2). Put the machine into a carton.
- (3). Use a cart or two men's hands to move it.

2. Storage

- (1). Use duster-cover to cover the machine when it doesn't work.
- (2). Avoid to storage the machine in the temperature more than 45°C

3. Working

The machine doesn't work over 40°C.

4. Warning

1) Pay attention to this warning advice as follow

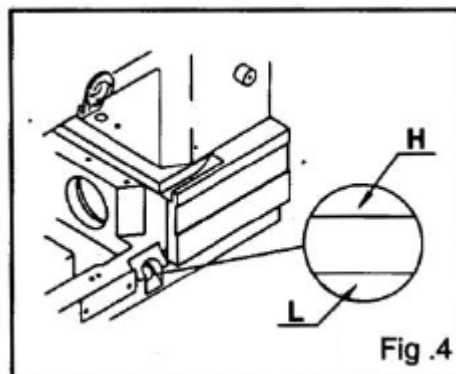
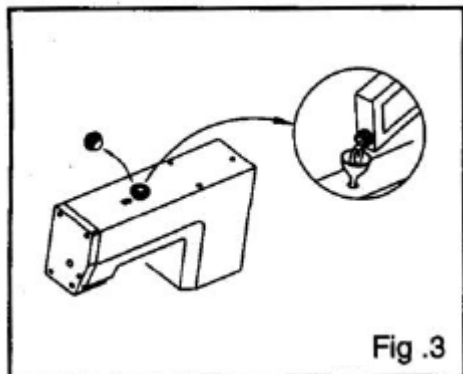
- a. Working area is dangerous.
- b. Never touch the needle if the machine is still running.
- c. Be Careful if you feed fabric.
- d. Do not insert your finger between needle and roller for transportation on fabric.

2) Pay attention to the warning sticker

- a. Movable parts must be enclosed was guard when you operate.
- b. Put out the plug from socket when you adjust thread.

2. LUBRICATION

1. Please oil with TERESSTIC T32 oil or its equivalent.
2. The lubricating oil has been drained from the machine before delivery. Remove screw (A), and fill the oil until the oil level reaches between lines H and L of oil level gauge (Fig. 3, 4).
3. Be sure to check every day and refill the oil, if oil level is lower than line L of oil level gauge. When you begin operating the machine, please check whether all the lubricating system is at normal condition.



* Before starting a brand-new machine or a machine which has not been used for more than a couple of week oiling the needle bar.

3. HOW TO CHANGE OIL

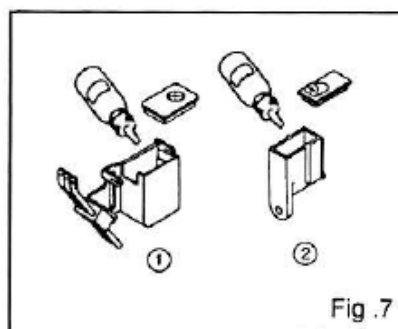
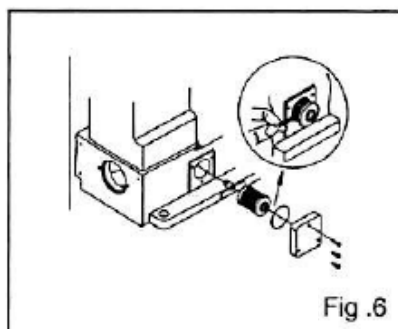
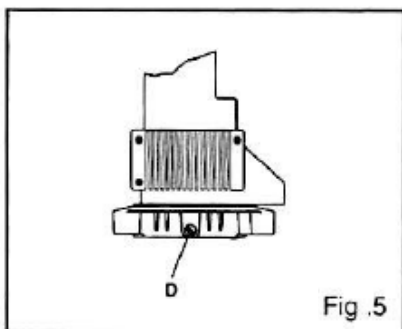
1. Loosen Screw (1), drain all the oil from the tank, then fasten the screw (Fig. 5).
2. For extending life of the machine, change oil after the initial 4-week operation. After that, change oil every four months.

4. HOW TO CHANGE OIL FILTER

This machine is equipped with an oil filter, and the filter must be cleaned every month, replace the filter if necessary (Fig. 6).

5. LUBRICATE AND COOLING OF NEEDLES AND THREADS

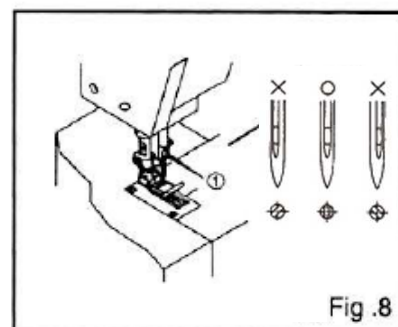
Fill reservoir (1) and (2) with silicone oil to prevent the thread from breaking (Fig. 7).



6. HOW TO REPLACE THE NEEDLES

1. See specifications of the needles.
2. Loosen Screw (1), then pull out the used needles.
Insert the new needles into the holder holes as far as they can go, and let the long groove of the needle face you (Fig. 8).
3. Fasten Screw (1).

Needle system: UY 128 GAS



7. THREADING

Follow the procedures shown in (Fig. 9) for threading. Wrong threading may cause thread breaking, skipping stitch, puckering or unexpected sewing.

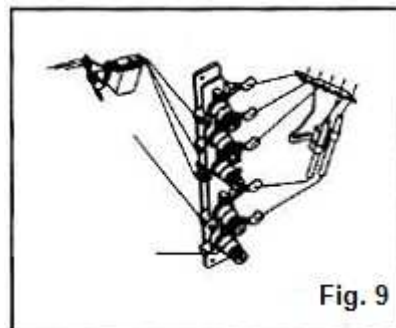
8. ADJUSTING THREAD TENSION

The tension of the thread should be adjusted according to:

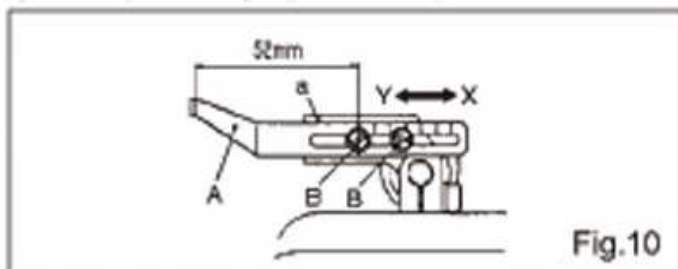
1. The material and the thickness of the fabric being sewed;
2. The thread;
3. The needle gauge.

If you turn thread tension knob clockwise, thread will be tighter (Fig. 10).

If you turn it counter-clockwise. It will tie looser.

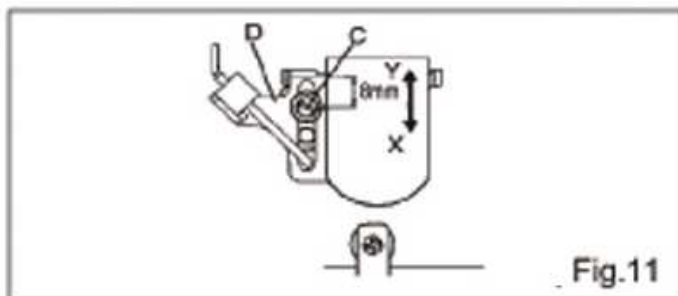


9. ADJUSTING NEEDLE THREAD TAKE-UP



When the needle bar is in the highest position, the top edge of the Needle Thread Take-up (A) should remain horizontal (Tip of part (a) of Needle Thread Take-up should be 52mm from the center of screw (B)).

To tighten needle thread, move Needle Thread Take-up (A) in the direction of (Y), and to release, move it in direction of (X).



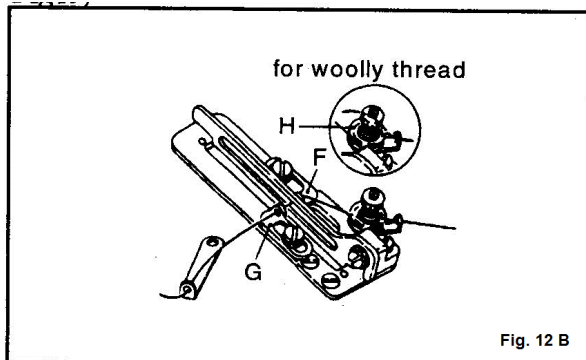
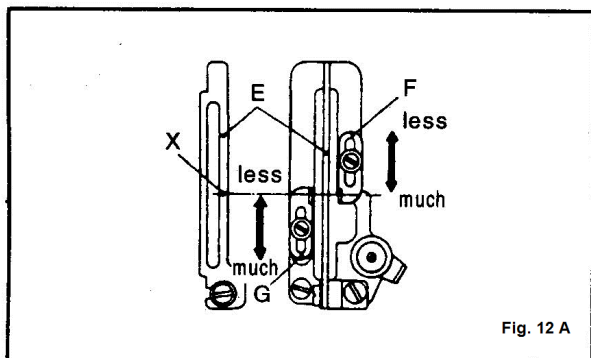
To adjust the position of the Take-up, loosen the Screw (B) first (Fig. 10).

When this adjustments is not sufficient check thread tension by moving Thread Eyelet (D) after loosing screw (C), When is moved in the (Y) direction, thread is tighten and in (X) direction, thread is loosened. The upper end of Eyelet is 8 mm above the center screw (C). (Fig. 11)

10. LOOPER THREAD TENSION

To increas running out of thread, loosen screws of Eyelet (F) and (G) and move Eyelets forward, to decrease move them backward. (Fig. 12 A)

When using woolly thread , move Eyelet (F) and (G) all the way to the front and do not pass the thread through Supplementary Tension Disc (Fig. 12 B)



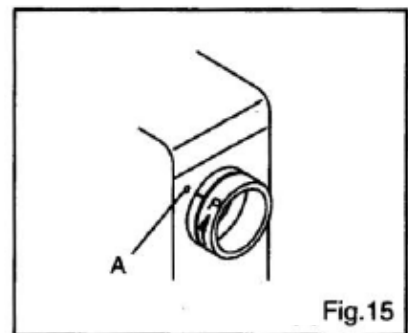
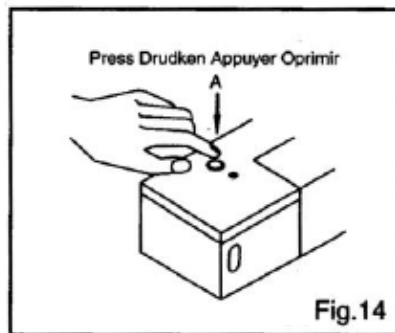
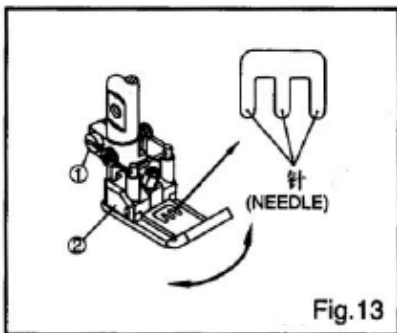
11. ADJUSTING PRESSER FOOT

Loosen Screw (1) and adjust Presser Foot (2) left and right to a proper position to let the needle may get into the center of Presser Foot 's eyelet. After adjusting, tighten screw (1). (Fig. 13)

12. ADJUSTING STITCH LENGTH

Stitch length can be adjusted variably in range from 1.2 mm - 4.0 mm, or 6 - 18 stitches per inch.

1. Keep pressing the push button (A) with your left hand, then turn the hand-wheel with your right hand until your left hand finger feels the push button lock in (Fig. 14).
2. Keep turning hand-wheel for an inquired stitch length, whose scale indicated on the hand-wheel must be aligned with, then stop pressing the button (Fig. 15).
3. Rotate the hand-wheel counter clock-wise to increase the stitch length, and clockwise to decrease.
4. After adjusting stitch length the differential ratio will usually be changed too. So adjustment of differential ratio is required.



13. ADJUSTING DIFFERENTIAL FEED RATIO

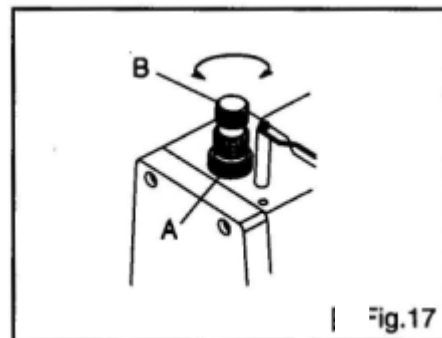
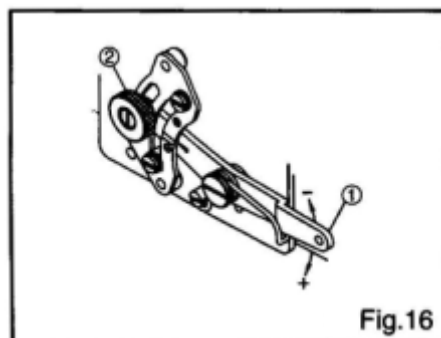
The differential Feed Ratio of this machine is adjustable from 1:0.5 to 1:1.3 (Fig. 16).

To adjust the ratio, loosen the nut (2), move the indicator (1) up or down.

- * To stitch the cloth, move the indicator (1) upward;
- * To gather the cloth, move the indicator (1) downward;

14. ADJUSTING THE PRESSURE OF PRESSER FOOT

Pressure of the Presser Foot should be as light as possible, so that cloth can be fed and sewed smoothly.



15. POSITION OF THE LOOPER THREAD TAKE-UP

Lower the needle from the highest position and adjust, so that the thread comes off from the highest point of the looper Thread Take-up (I) when left needle reaches to the middle part of the looper.

The adjustment is made by loosening screw (j) (Fig. 18 & 19)

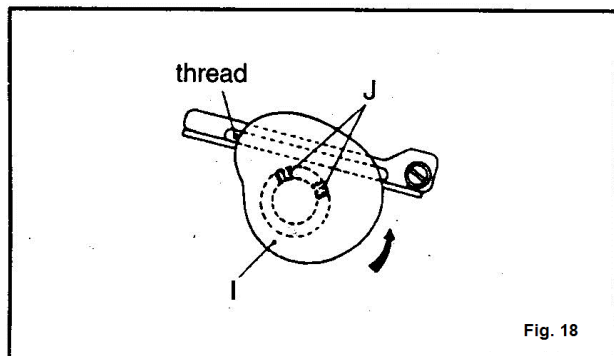


Fig. 18

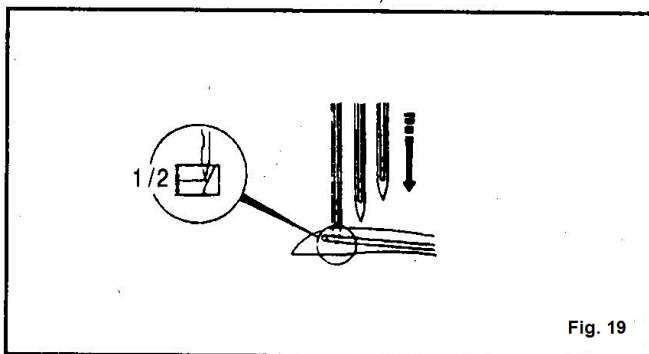


Fig. 19

16. ADJUSTMENT OF THE LOOPER *

Please refer to the below table and Fig. 20.

* Only for Treccia (flat bed)

Needle Distance(Mark)	Movement of looper to the Right
3.2mm (A)	4.4mm
4.0mm (B)	4.0mm
4.8mm (C)	3.6mm
5.6mm (D)	3.2mm
6.4mm (E)	2.8mm

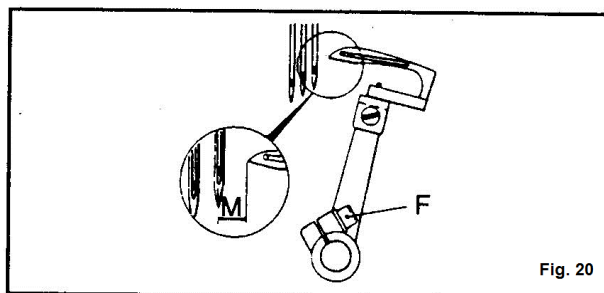


Fig. 20

17. HEIGHT OF THE NEEDLES

When the tip of the looper comes to the center of the left needle, the looper must pass 0.5~1.0 mm above the upper end of the eye—that is—the height of the needle is set on the basis of the looper. Both—needles and looper should be properly fixed.

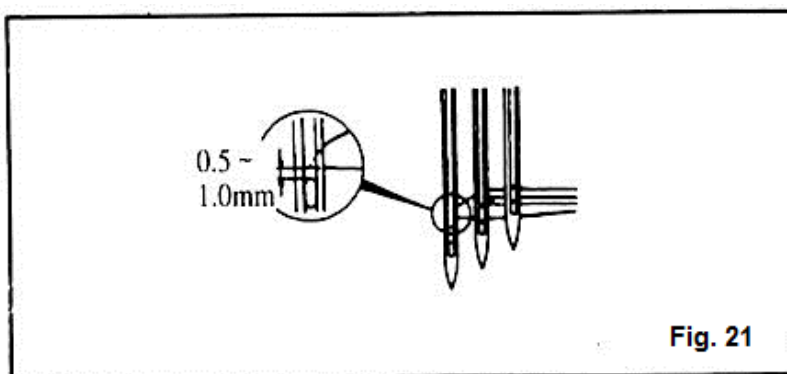


Fig. 21

18. SPREADER

When Spreader (A) moves from right to the left, clearance should be about 0,5 ~0,8 mm between left needle and tip (a) of thread hooking point. When it comes to the extreme left, the clearance between the center of the left needle and tip (a) of thread hooking point should be 4,5 ~5,5 mm (Fig. 22).

Adjust the height of Spreader (A) above the stitch palte to 9 ~11 mm (Fig. 23).

To adjust the Spreader loose screw (B) and (C) (Fig. 24).

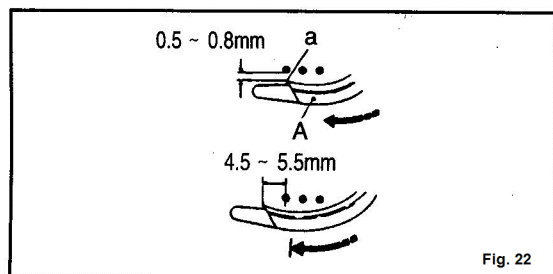


Fig. 22

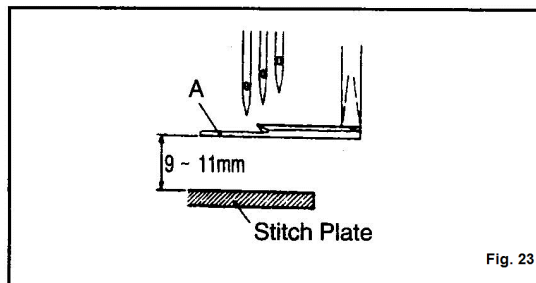


Fig. 23

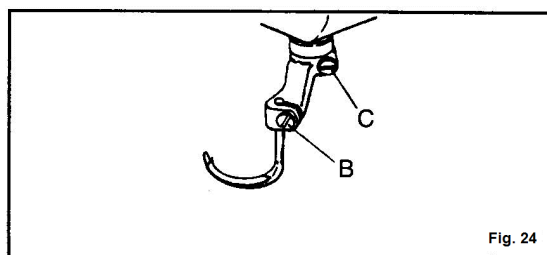
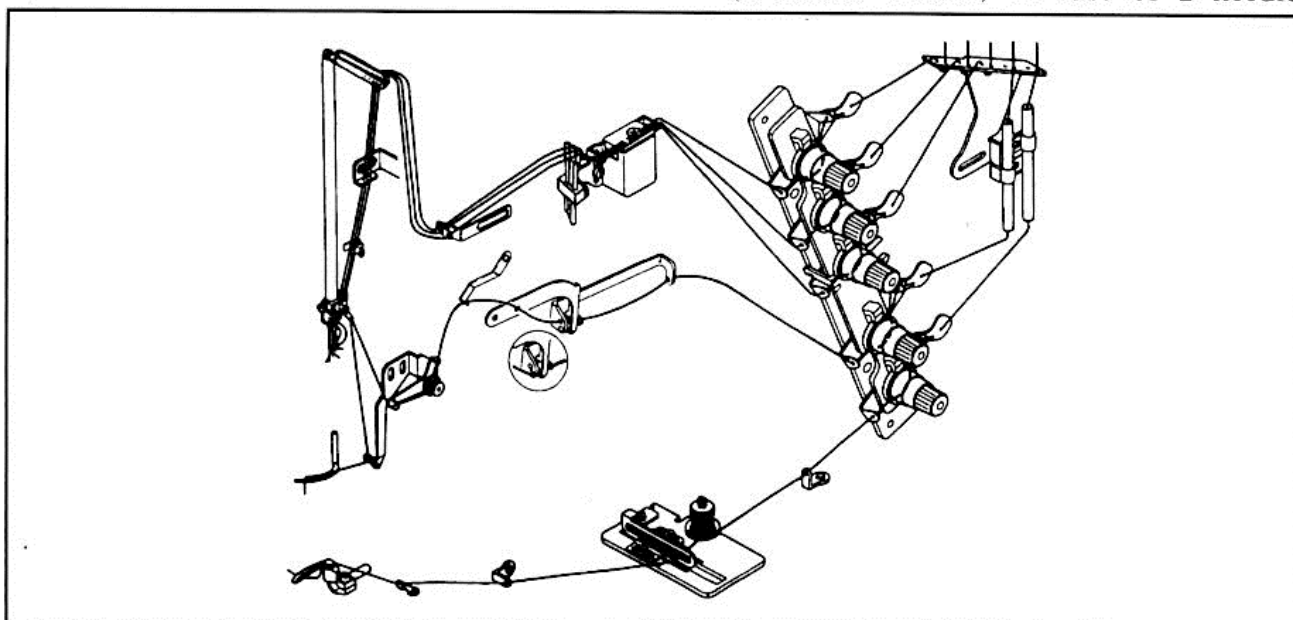


Fig. 24

19. THREADING DIAGRAM



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 interlock sewing machine

Model: **TRECCIA 1F, TRECCIA-C 3F**

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 60204-1:2018

EN 60204-31:2013

Certificate of conformity number: No.: CE-1891-01-150424

Test Report No.: OViS202312065M, OViS202312065E

Strima Sp. z o.o.
Swadzim 15.07.2025

NOTES

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Dealer:

