

INSTRUCTION MANUAL

Tronic 6F

Automatic industrial lockstitch
sewing machine



BEFORE OPERATION:

1. Never operate the machine unless its oil reservoir has been filled with oil.
2. After setting up the machine, check the direction of motor rotation. To check it, turn the hand wheel by hand to bring the needle down, and turn the power switch ON while observing the hand wheel. (The hand-wheel should turn counterclockwise as observed from the hand wheel side)
3. Confirm that the voltage and phase (single or 3-phase) are correct by checking them against the ratings shown on the electronic identification.

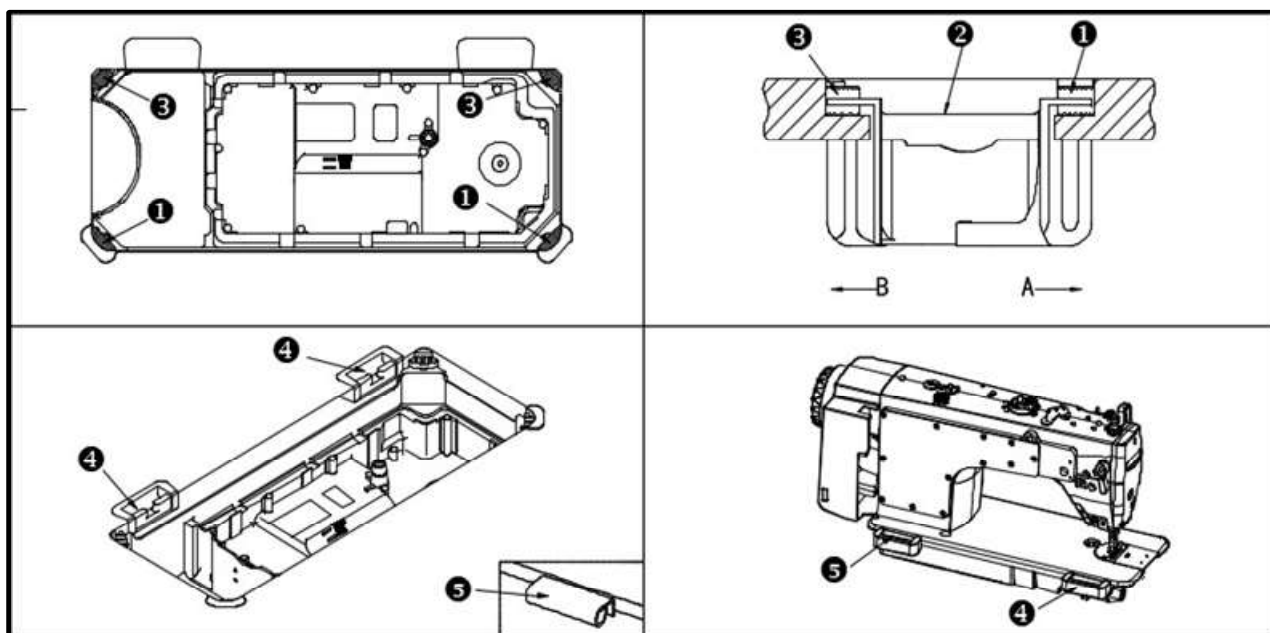
OPERATION PRECAUTIONS:

1. Keep your hands away from the needle when you turn the power switch ON or while the machine is operating.
2. Do not put your finger into the thread take-up-lever while the machine is operating.
3. Be sure to turn the power switch OFF before tilting the machine head.
4. When an operator leaves from the machine, make sure to turn off the power.
5. During operation, be careful not to allow your or any other person's head or hands to come close to the bobbin winder or hand wheel. Also, do not piece anything close to them. Doing so may be dangerous.
6. If your machine is provided with a finger guard or any other protectors, do not operate your machine with any of them removed.
7. Don't clean the face of machine head with thinner.

SPECIFICATIONS

Application	General fabrics, light-weight and medium-weight materials
Sewing speed	4,000rpm (5000rpm max)
Max.Stitch length	5mm
Needle	DPx5 #9~#23
Presser foot lift	9mm (standard) ; 12mm (Max.)
Lubricating oil	Spirit 2

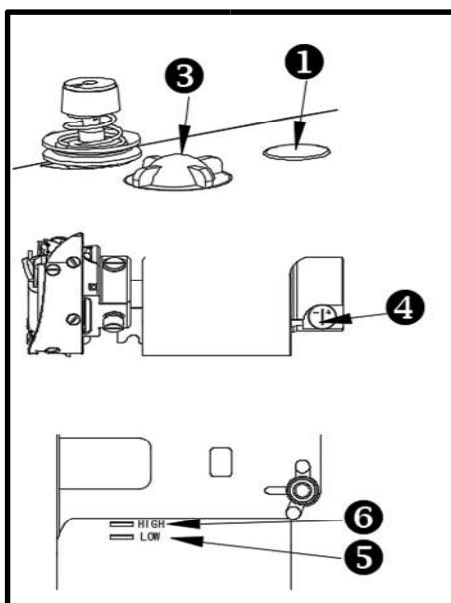
INSTALLATION



Fixing oil tray

1. Put the oil tray ② on the four groove corners on the sewing table.
2. Fix two arm cushion ① to the A side of oil tray ② (facing the operator). Fix the two stand bases ③ to the B side of oil tray ② (hinge side), then fix the oil tray ②.
3. Insert machine head coupling hook ⑤ into the pin holes in the bottom plate such that it is embedded into the coupling hook seat ④, and put the machine head onto the seating washer on four corners of the oil tray.

LUBRICATION



Before the machine operation, please inject 380ml of Spirit 2 industrial sewing machine oil

1. Please keep the sewing machine open, take off the rubber plug on the upper arm, and use a funnel ① to add oil.
2. When the machine oil cannot ensure the normal operation of the machine, please add oil appropriately, and pay attention to the lowest level ⑤ and highest level ⑥. If the oil exceeds the highest level ⑥, there may be oil leakage. Please pay attention.
3. Running the machine after adding oil, if it's normal of lubrication, we can see the oil flow through the window ③.
4. The oil quantity of rotating shuttle decreases when the oil quantity adjusting screw ④ is right-handed. The oil quantity of rotating shuttle increases when the oil quantity adjusting screw is turned left.

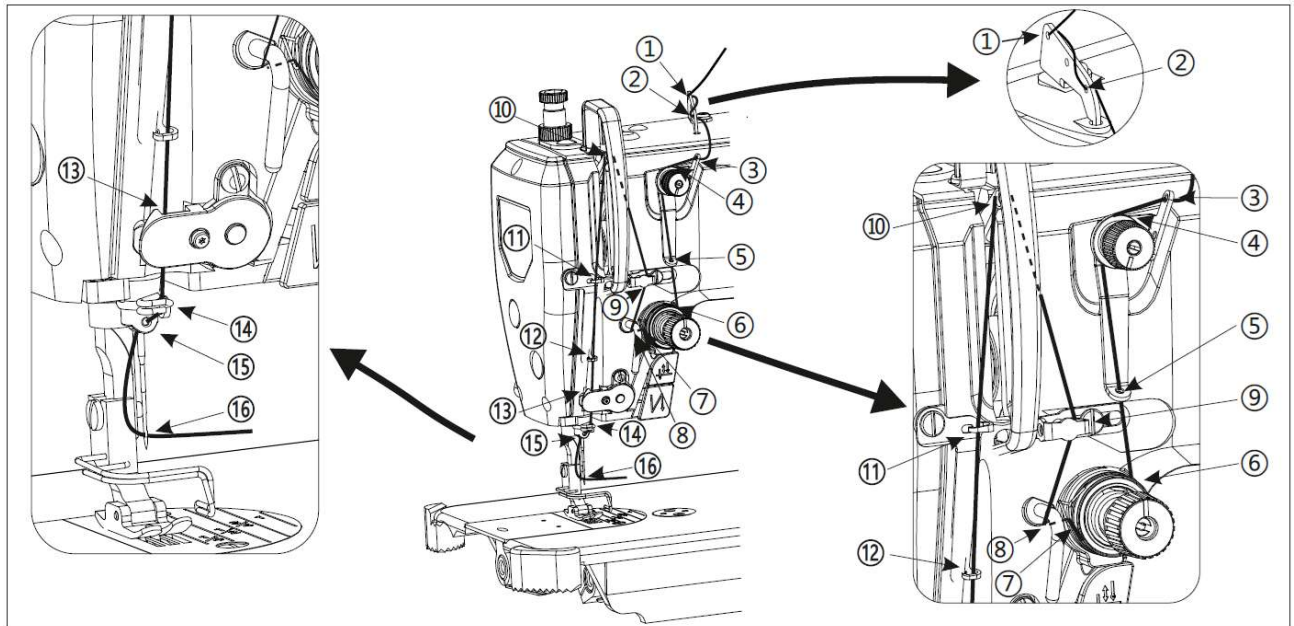
➤ Note that the amount of the splashing oil is unrelated to the amount of the lubricating oil.

- The new machine should be replaced after 1 month, and the oil should be replaced every six months later.
- When you first operate your machine after seter or after an extended period of disuse, run your machine at 2500 to 3000 rpm for about 10 minutes for the purpose of break-in.

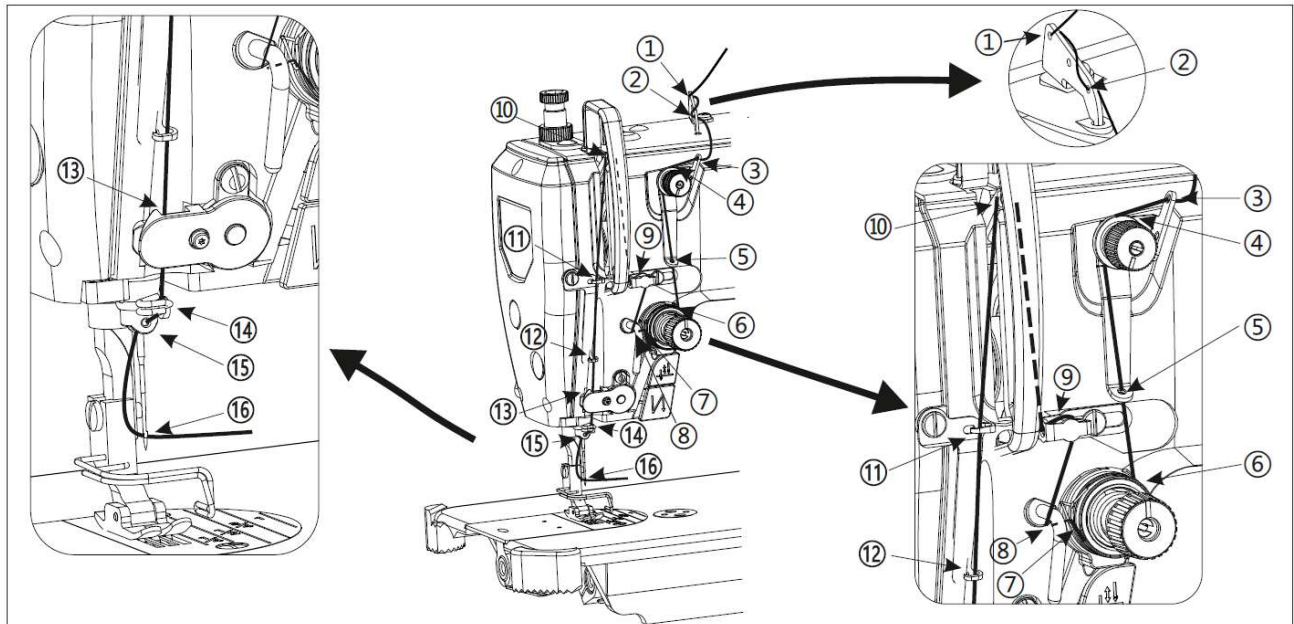
THREADING

Thread the needle thread when needle bar stays in its highest position, lead out the thread end from the thread stand, and conduct threading as per the serial numbers indicated in the figure.

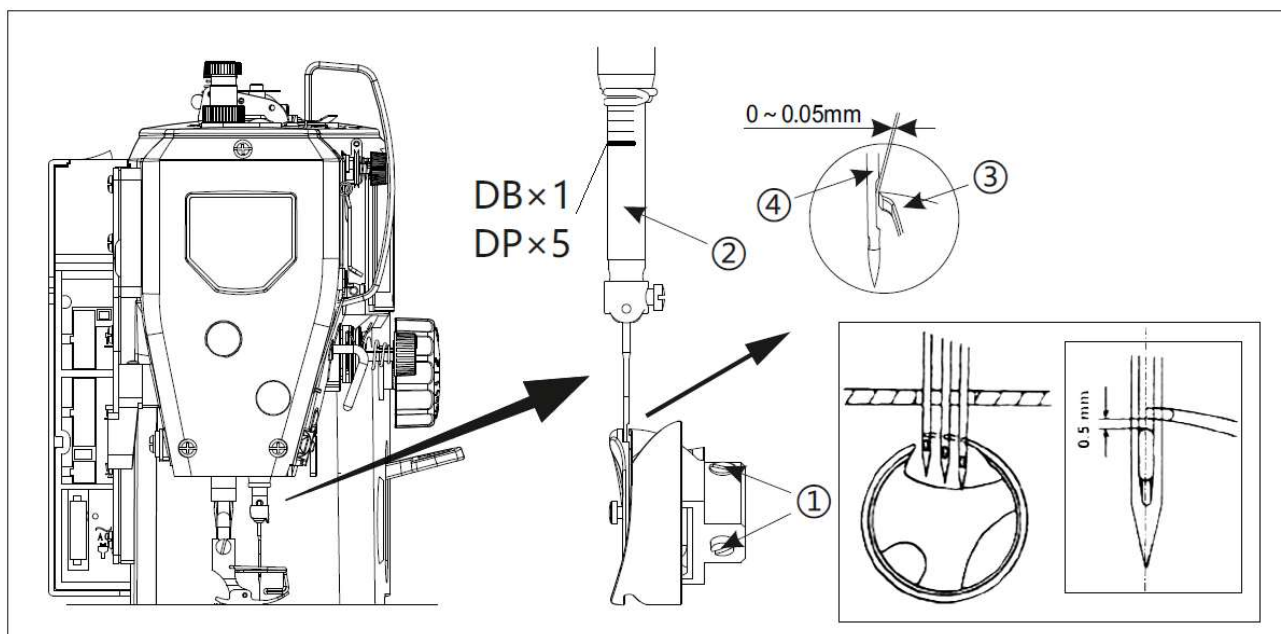
The threading in the is be suitable for thin material sewing sewn thread: thin cotton thread.



The threading in the is be suitable for heavy material sewing sewn thread: coarse cotton thread.



NEEDLE TO HOOK RELATIONSHIP



1. Adjust the timing between the needle and the hook as follow:

1) Turn the hand wheel to bring the needle bar down to the lowest point of its stroke, and loosen setscrew.

➤ Adjusting the needle bar height.

2) Pull the needle bar, you can see the pinhole basset 1/2 level through edge of inside hook (needle must be position). Turn needle cover wire slot left, then tighten set screw.

➤ Adjusting position a of the hook.

3) First move the point of hook in direction, when running strap pulley needle bar risen from the lowest, Observe cooperate relation of the hook and needle. When hook point above Pinhole about top of 1mm to 1.5mm and when plane of the hook point form plane of needle short bar 0.05mm (keep the align hook blade point with the center of needle), tighten the hook set screws.

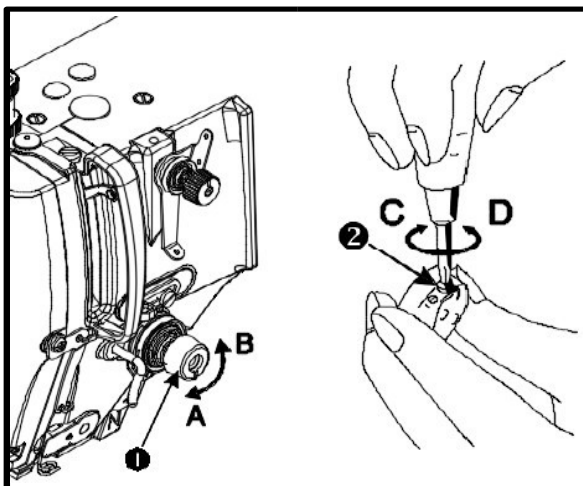
➤ Precaution

1. If the clearance is too small, the tip of the hook will be abraded. If it is too big, it will lead to skip over.

2. Note that the type of hook to be substituted for, when replacing the hook. Shall be in conformity with the very type of the hook installed in the sewing machine of original assemblage.

3. After replacing the needle the needle must be same type and install right position. If the needle is different type need check match with relation.

THREAD TENSION



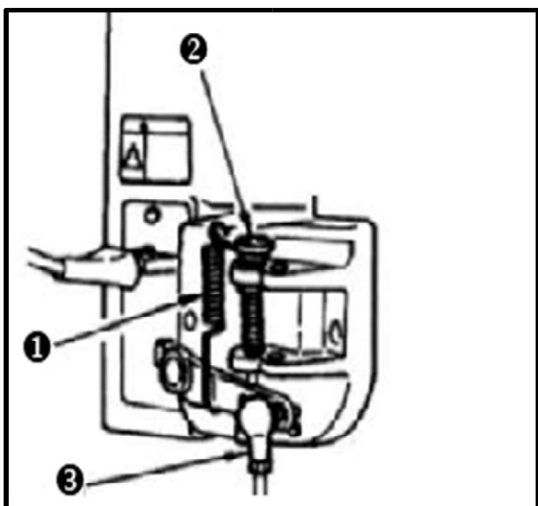
1. Adjusting the needle thread tension

- 1) Adjust the needle thread tension using tension adjust nut ① according to the sewing specifications.
- 2) As you turn nut ① clockwise (in direction A), the needle thread tension will increase.
- 3) As you turn nut ① counterclockwise (in direction B), the tension will decrease.

2. Adjusting the bobbin thread tension

- 1) As you turn tension adjust screw ② clockwise (in direction C), the bobbin thread tension will increase.
- 2) As you turn screw ② counterclockwise (in direction D), the bobbin thread tension will decrease.

PEDAL PRESSURE AND PEDAL STROKE



1. Adjusting the pressure required to depress the front part of pedal

- 1) This pressure can be changed by changing the mounting position of pedaling pressure adjust spring ①.
- 2) The pressure decreases when you hook the spring on the left side.
- 3) The pressure increases when you hook the spring on the right side.

2. Adjusting the pressure required to depress the back part of the pedal

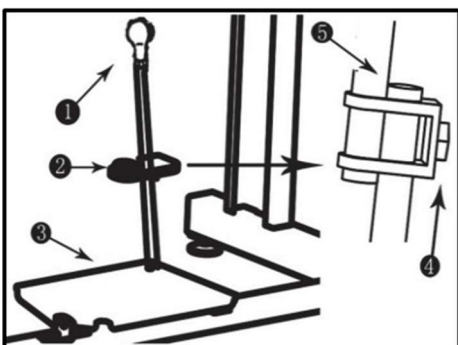
- 1) This pressure can be adjusted using regulator screw ②.

- 2) The pressure increases as you turn the regulator screw in.
- 3) The pressure decreases as you turn the screw out.

3. Adjusting the pedal stroke

- 1) The pedal stroke increases when you insert connecting rod ③ into the right hole.

ADJUSTMENT OF THE PEDAL



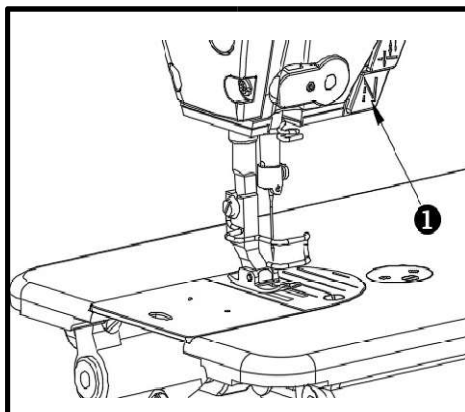
1. Installing the connecting rod

- 1) Move pedal ③ to the right or left as illustrated by the arrow so that spherical head (1) and connecting rod (2) are straightened.

2. Adjusting the pedal angle

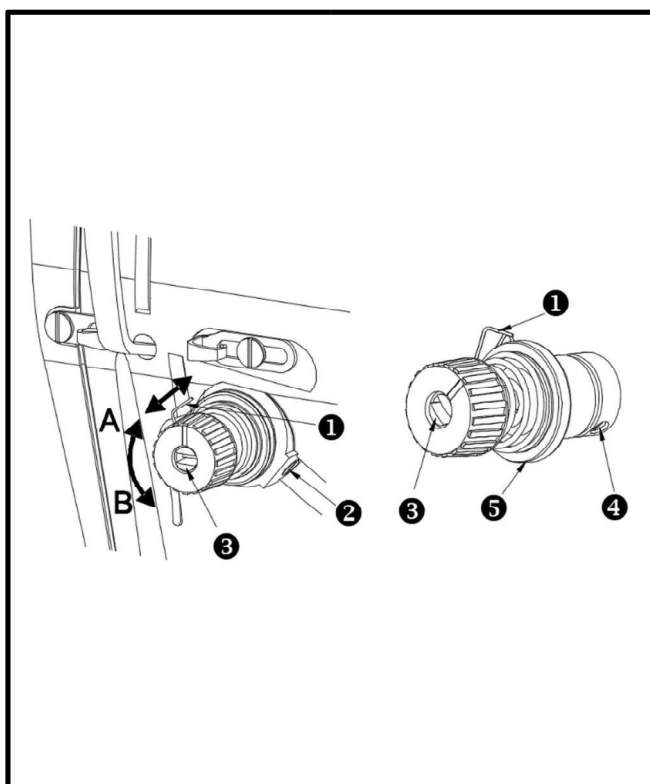
- 1) The pedal tilt can be freely adjusted by changing the length of the connecting rod.
- 2) Loosen adjust screw ④, and adjust the length of connecting rod ⑤.

ONE-TOUCH TYPE REVERSE FEED STITCHING MECHANISM



1.How to operate

- 1) The moment switch button ① is pressed, the machine performs reverse feed stitching.
- 2) The machine performs reverse feed stitching as long as the switch lever is held depressed.
- 3) The machine resumes normal feed stitching the moment the switch lever is released.



THREAD TAKE UP SPRING

1. Changing the stroke of thread take-up spring ① by Loosen set screw ②.

- 1) As you turn tension post ③ clockwise (in direction A), the stroke of thread take-up spring will be increased.
- 2) As you turn the knob counterclockwise (in direction B), the stroke will be decreased.

2. Changing the pressure of threads take-up spring ①.

- 1) Loosen setscrew ②, and take out tension arm ⑤.
- 2) Loosen setscrew ④, and remove tension post ③.
- 3) As you turn tension post ③ clockwise (in direction A), the pressure will be increased.
- 4) As you turn the post ③ counterclockwise (in direction B), the pressure will be decreased.

Notes for safe use of industrial sewing machines :

1. Basic measures must be observed.
2. Pass the specialized training and master sewing machine equipment performance.
3. All safety devices should be checked before use.
4. When installing needle and changing needle, presser foot, plate, feed dog, bent needle, hook or repairing, the power supply should be turned off immediately.
5. Power should be turned off when leaving the sewing machine or workplace.
6. When using the clutch motor, please wait until the motor stops completely.
7. The machine oil and other liquids used in sewing machines and ancillary devices should be cleaned immediately when they are put into eyes or touch skin.
8. Do not touch the parts or devices when the machine is powered by hand.

9. The repair, renovation and adjustment of the main mechanisms of the relevant industrial sewing machines and overseers shall be carried out by specialized technicians.
10. General maintenance is carried out by specially-assigned persons.
11. Electrical repairs should be performed under the supervision and direction of the electrical technician.
12. The machine should be cleaned regularly during operation.
13. In order to operate normally and safely, ground lines should be installed and they should be used in an environment free from strong noise sources such as high frequency welding machine.
14. Power plug should be installed by specially-assigned person.
15. Industrial lockstitch sewing machine and overlock sewing machine can not be used except the designated use.

Environmental requirements :

1. Please dispose the waste oil and other waste products properly according to local environmental protection requirements.
2. Please turn off the power after use to reduce power consumption.
3. Please use under the voltage and environment required in the manual to extend the service life of the product and reduce waste generation.
4. Do not treat the machine and its accessories as ordinary household garbage after being scrapped. Please comply with local laws governing the disposal of the equipment and its accessories and support recycling operations.

使用说明

开车前的注意事项:

1. 油盘内未加油绝不能开车。
2. 机器运转时，从手轮外侧看转向应为逆时针方向。注意，不能倒转。
3. 确认电控标识上的电压及相位是否正确。

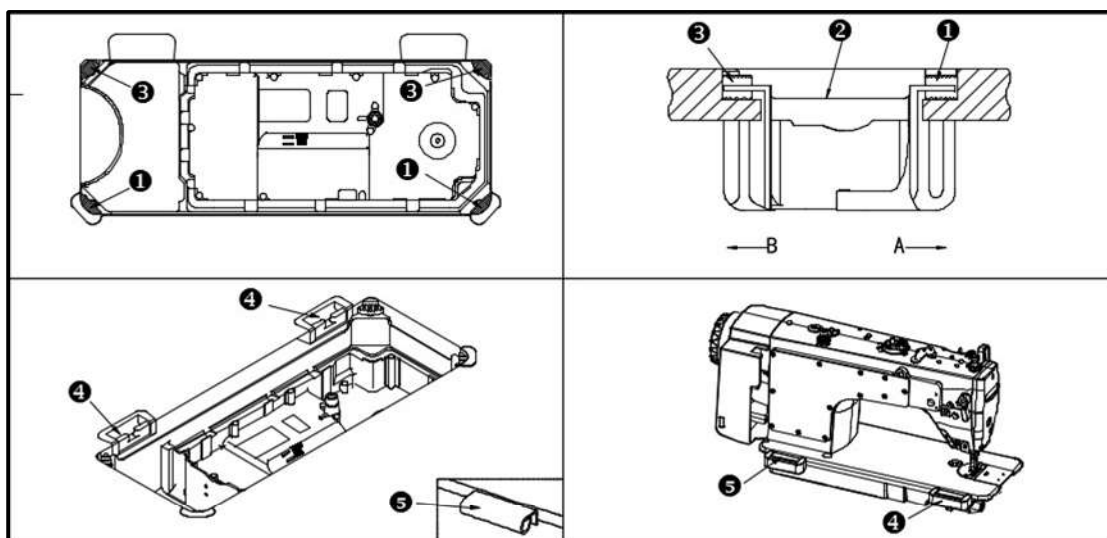
使用注意事项:

1. 接通电源开关或机器运转时，请勿将手放到针的下部。
2. 机器运转时，请勿将手指伸入挑线杆护罩内。
3. 机头翻倒时，一定要切断电机开关。
4. 操作者离开机器时，必须切断电源。
5. 机器运转期间，不允许任何人的头或手及任何东西靠近绕线轮和手轮。
6. 装拆防护罩，或者其他保护装置时，请勿开动机器。

一、规格

用途	一般布料、薄料、中厚料
缝纫速度	4,000rpm (5000rpm 最高)
最大针脚长度	5mm
机针	DPx5 #9-#23
压脚高度（自动抬压脚）	9mm（标准）12mm（最大）
使用机油	Spirit2 机油

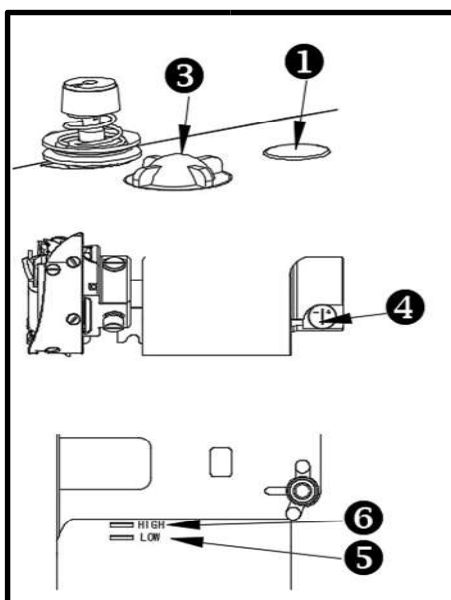
二、缝纫机的安装



油盘的安装

1. 油盘②应放置在台板上的凹槽四角上。
2. 将两个机头座垫①安装在油盘②的 A 边（朝操作者一边），将两个油盘支座 ③安装在油盘②的 B 边（机头连接钩接合一边），然后放上油盘②。
3. 将机头连接钩⑤插入底板销孔内，与台板的机头连接钩座④相嵌合再把机头放到油盘的四只角的机头座垫上。

三、加油



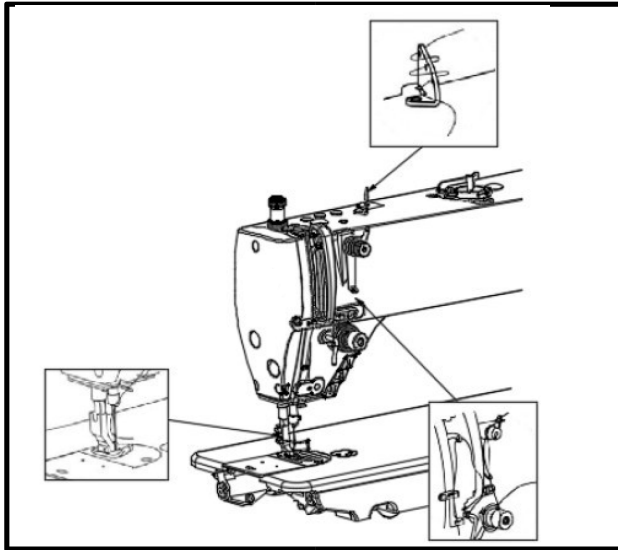
运转缝纫机之前，请注入 **380ml Spirit 2 No.10** 机油。

1. 请保持缝纫机为开机状态，取下机臂上部的橡胶栓，利用漏斗①进行加油。
2. 当油箱内机油不够正常运行时，请适当加油，注意最低位⑤最高位⑥，过最高位⑥有可能出现漏油现象，请加以注意。
3. 加油后运转缝纫机，如果润滑正常，可通过油窗③看到油的流动。
4. 油量调节螺钉④左旋，旋梭油量减少；右旋，旋梭油量增加。

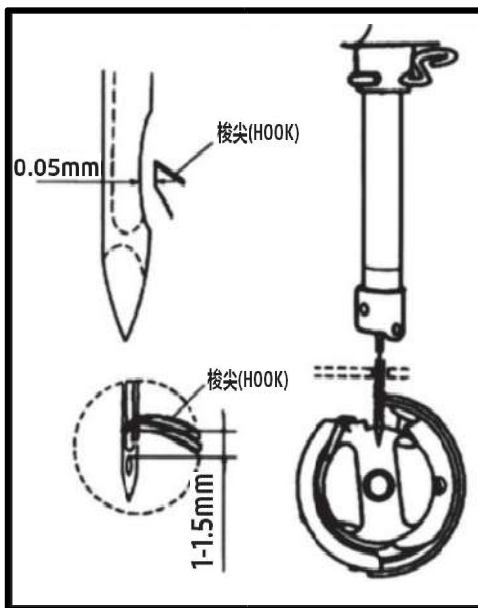
➤油流动量的多少，与油量的多少无关。 ➤新机器使用一个月后请更换机油，后期每六个月更换一次机油。

➤ 新缝纫机或较长时间没有使用的缝纫机在使用之前，应进行 10 分钟 2500-3000rpm 的磨合运转。

四、 上线的穿线方法



五、 机针与旋梭关系



1. 针与旋梭的配合关系应如下： 1) 转动手轮，使针杆位于最低点，在旋松针杆连接柱定位螺钉。

➤ 针杆高度的确定。

2) 拉动针杆，水平透过内梭内边缘可看到针孔有 1/2 下露（机针必须安装到位）。机针埋线槽朝左，然后旋紧针杆连接柱螺钉。

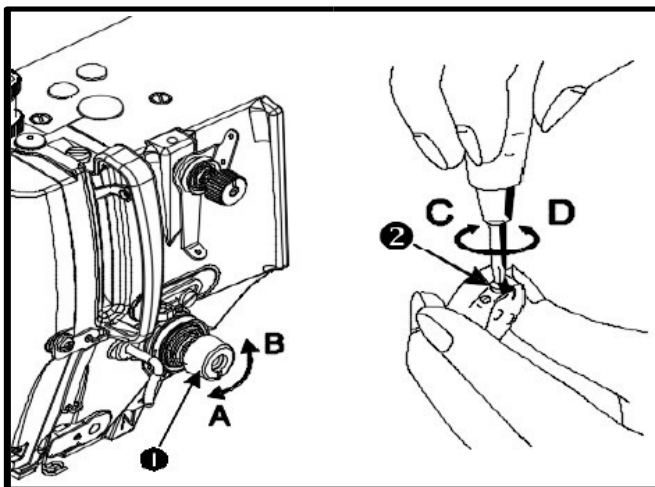
➤ 旋梭位置的确定。

3) 先将旋梭梭尖朝上，转动手轮，针杆从最低点回升时，观察旋梭与机针配合关系。当旋梭梭尖位于机针孔边上端 1-1.5mm 时且梭尖平面距机针短槽平面 0.05mm 时（保证梭尖位于机针的中心线部位），旋紧旋锁螺钉。

➤ 注意

1. 若间隙太小，会磨损梭尖，若间隙太大，则会引起跳针；
2. 旋梭原来用的什么型号，调换后，也请使用原来的型号；
3. 更换机针后注意机针必须安装到位且类型相同，如不同类型机针须检查配合关系。

六、缝线张力



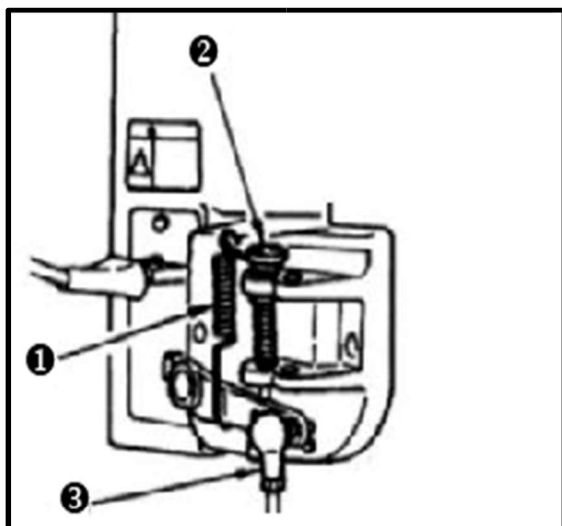
1.面线张力的调节:

- 1) 根据不同的缝制条件,用螺母①来调整面线张力。
- 2) 若把螺母①按顺时针方向(即 A 方向)转动时,面线张力将增大。
- 3) 若把螺母①按逆时针方向(即 B 方向)转动时,面线张力将减小。

2.底线张力的调

- 节:
- 1) 将夹线螺钉②朝顺时针方向(即 C 方向)转动时,底线张力将增大。
 - 2) 将夹线螺钉②按逆时针方向(即 D 方向)转动时,面线张力将减小。

七、踏板压力和行程



1.踏板踩踏压力的调整

- 1) 更换踩踏弹簧①的位置,可调整踩踏压力。
- 2) 把弹簧挂到左侧之后,压力变轻。
- 3) 挂到右侧之后变重。

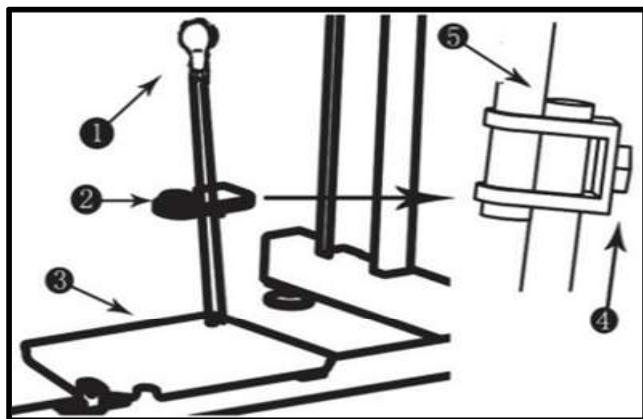
2.踏板回踩力的调整

- 1) 用踏板回踩压力调节弹簧②可以调整。
- 2) 拧进调节螺丝则压力变大。
- 3) 拧松调节螺丝则压力变小。

3.踏板踩踏行程的调整

- 1) 把连接杆③插到右侧的孔里之后行程变大。

八、踏板的调整



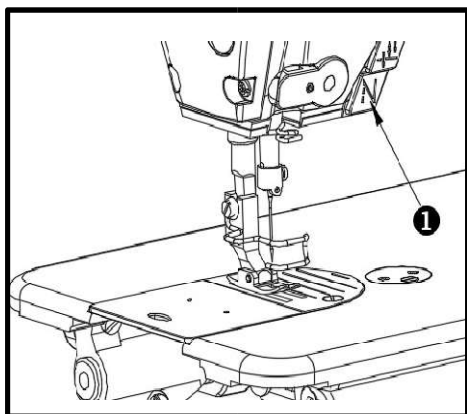
1.连接杆的使用

- 1) 向箭头方向移动踏板调节板③,让连接杆球形头①和连接杆②成一直线。

2.踏板的角度

- 1) 调节连杆的长度就可以自由的改变踏板的倾斜度。
- 2) 拧松调节螺丝④,拉出插入连接杆⑤进行调整。

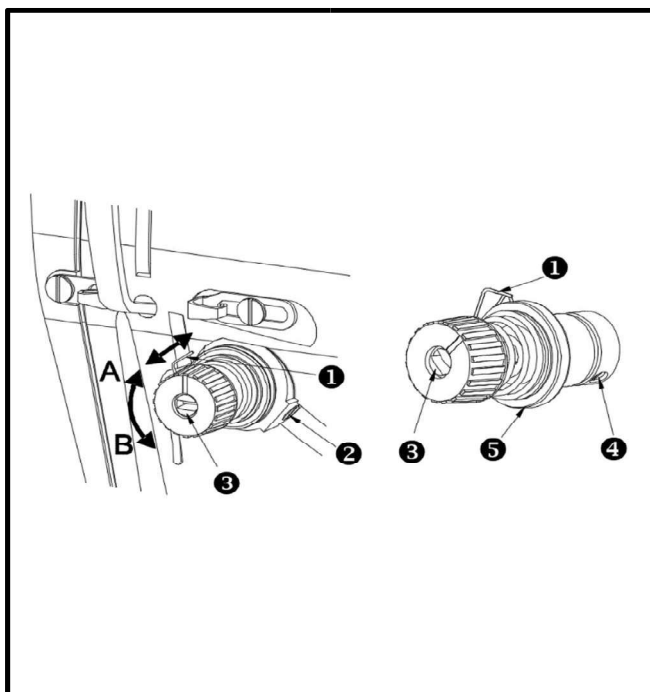
九、触键手动倒缝（盒式）



1.使用方法

- 1) 按下开关按钮①，缝纫机立即倒缝。
- 2) 在按下的时间内进行倒缝。
- 3) 手一松开立即变为正向缝纫。

十、挑线簧



1.改变挑线簧①的摆动量：

- 1) 旋松定位螺钉②。
- 2) 把夹线螺钉③朝②顺时针方向（即 A 方向）转动时，挑线簧的摆动量将增大。
- 3) 把夹线螺钉朝逆时针方向（即 B 方向）转动时，挑簧的摆动量将减小。

2.改变挑线簧①的张力： 1)旋松定位螺钉②，取出夹线器（组件）⑤。

- 2)旋松定位螺钉④，并转动夹线螺钉③。
- 3)把夹线螺钉③朝顺时针方向（即 A 方向）转动时，挑线簧张力将增大。 4)把夹线螺钉③朝逆时针方向（即 B 方向）转动时，挑线簧张力将减小。

工业缝纫机安全使用注意事项：

1. 必须遵守基本措施；
2. 必须经过专业培训，对缝纫机设备性能有所了解；
3. 使用前应检查所有安全装置；
4. 在安装机针、更换机针、压脚、针板、送布牙、弯针、旋梭或修理时，应立即关闭电源；
5. 离开缝纫机或工作场所时应关闭电源；
6. 使用离合马达时，要等待马达完全停止后再进行；
7. 缝纫机及附属装置使用的机油，润滑油等液体流入眼睛或沾到皮肤上应立即清洗；
8. 禁止用手触摸缝纫机通电时的零件或装置；
9. 有关工业用平缝机与包缝机的修理、改造、主要机构的调整由专门技术人员来进行；
10. 一般的维修保养由专人进行；

11. 在电气方面的修理应在电气技术员的监督和指导下进行；
12. 缝纫机使用期间应定期清扫；
13. 为了正常安全运转，应安装地线，同时应在不受高频焊接机等强噪声源影响环境下使用；
14. 电源插头应由专人安装；
15. 工业用平缝机、包缝机在指定用途以外不能使用。

环保要求

1. 使用过程中产生的废油及其他废弃物请根据当地环保的要求进行合理的处置。
2. 请在使用完后及时关闭电源，减少电能的消耗。
3. 请在说明书要求的电压及环境下使用，已延长产品的使用寿命，减少废弃物的产生。
4. 机器报废后请勿将本机器及其附件作为普通的生活垃圾处理。请遵守本设备及其附件处理。

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:

