VEVOR

Upgrade · The Home Creator Way

Industrial Sewing Machine

MODEL: JK9808

VEVOR Support Center

JK9808

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Upgrade·The Home Creator Way

Industrial Sewing Machine

MODEL: JK9808



This is the original instruction, please read all manual instructions carefully before operating. VEVOR reserves a clear interpretation of our user manual. The appearance of the product shall be subject to the product you received. Please forgive us that we won't inform you again if there are any technology or software updates on our product.

IMPORTANT SAFETY INSTRUCTIONS

To get the most out of the many functions of this machine and operate it in safety. it's necessary to use this machine correctly.
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. Observe the basic safety measures, including, but not limited to the following ones, whenever you use the machine.
2. 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. Use the machine after it has been ascertained that it conforms with safety rules/standards valid in your Country.
4. All safety devices must be in position when the machine is ready for word or in operation.The operation without the specified safety devices is not allowed.
5.This machine shall be operated by appropriately-trained operators.
6. For your personal protection, we recommend that you wear safety glasses.
7.For the following, turn off the power switch or disconnect the power plug of the machine from the receptacle.
7-1 For threading needle(s), looper, spreader etc. and replacing bobbin.
7-2 For replacing part(s) of needle, presser foot, throat plate, looper spreader, feed dog, needle guard, folder, cloth guide etc.
7-3 For repair work
7-4 When leaving the working place or when the working place is unattended.
8. If you should allow oil, grease, etc. used with the machine and devices to come in contact with your eves or skin or swallow any of such liquid by mistake, immediately wash the contacted areas and consult a medical doctor.
9. Tampering with the live parts and devices,regardless of whether the machine is powered,is prohibited

10. Repairremodeling and adjustment works must only be done by appropriately trainde technicians or specially skilled personnel. Only spare parts designated by can be used for repairs.
11. General maintenance and inspection works have to be done by appropriately trained personnel.
12. Repair and maintenance works of electrical components shal 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. Before making repair and maintenance works on the machine equipped with pneumatic parts such as an air cylinder.specially skilled personnel. that is free from strong noise sources such as high-freauency welder the air compressor has to be detached from the machine and the compressed air supply has to be cut of.Existing residual air pressure after disconnecting the air compressor from the machine has to be expelled. Exceptions to this are only adjustments and performance checks done by appropriately trained technicians or.
14. Periodically clean the machine throughout the period of use.
15. 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-freauency welder.
16. An appropriate power plug has to be attached to the machine by eledtric technicians.Power plug has to be commected to a grounded receptacle.
17. The machine is only allowed to be used for the purpose intended.Other used are not allowed.
18. Remodel or modify the machine in accordance with the safely rules/standards while taking all the effective safety measures. Assumes no responsibility for damage by remodeling or modification of the machine.
19. Warning hints are marked with the two shown symbols

 Danger of injury to operator or service staff

 Items requiring special attention

FOR SAFE OPERATION

 DANGER	1.To avoid electrical shock hazards, neither open the cover of the electrical box for nor touch the components mounted inside the electrical box.
 CAUTION	1.To avoid personal injury,never operate the machine with any of the belt cover.Finger guard or safety devices removed. 2.To prevent possible personal injuries caused by being caught in the machine, Keep your fingers, head and clothes away from the handwheel, V belt and the motor while the machine is operation.In addition, place nothing around them. 3. To avoid personal injury, never put your hand under the needle when you turn "ON" the power switch or operate the machine. 4. To avoid personal injury, never put your fingers into the thread take-up cover while the machine is in operation. 5.The hook rotates at a high speed while the machine is in operation. To prevent possible injury to hands, be sure to beep your hands away from the vicinity of the hook during operation, In addition, be sure to turn "OFF" the power to the machine when replacing the bobbin. 6.To avoid possible personal injuries, be careful not to allow your fingers in the machine when tilting/raising the machine head. 7.To avoid possible accidents because of abrupt start of the machine, turn OFF the power to the machine when tilting the machine head. 8. If your machine is equipped with a servo-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.To avoid electrical shock hazards, never operate the sewing machine with the ground wire for the power supply removed. 10.To prevent possible accidents because of electric shock or damaged electrical components(s), turn OFF the power switch in prior to the connection/disconnection of the power plug.

BEFORE OPERATION



CAUTION:
To avoid malfunction and damage of the machine confirm the following.

● Before you put the machine into operation for the first time after the set up, clean it thoroughly.
● Remove all dust gathering during transportation and oil it well.
● Confirm that the power plug has been properly connected to the power supply.
● Never use the machine in the state where the voltage type is different from the designated one.
● The direction of rotation of the sewing machine is counterclockwise as observed from the handwheel side.Be careful not to rotate it in reverse direction.

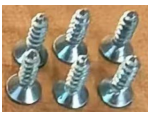
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1. TECHNICAL PARAMETERS AND PARTS LIST

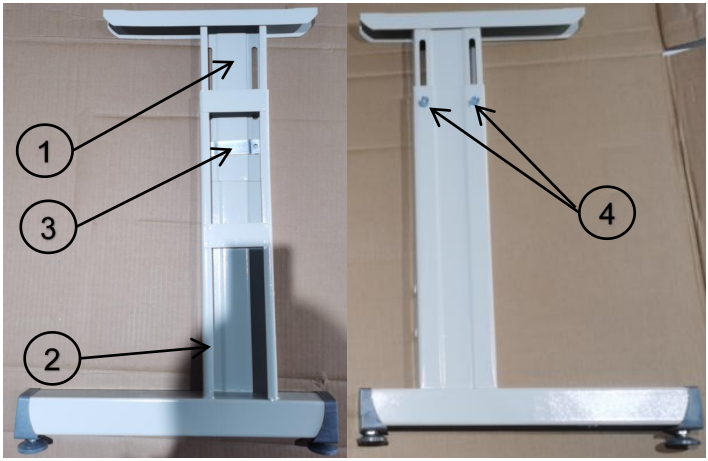
Technical Parameters	
Name	Industrial Sewing Machine
Model	JK9808
Classification 1	Electronic Model
Classification 2	Single-Needle Lockstitch Industrial Sewing Machine
Table	Yes
Needle speed	5000+ stitches per minute
Thread trimming	No
Voltage Frequency	AC110-120V 50/60Hz
Rated Power	300W
Maximum lifting height of manual reverse presser foot	8mm
Lifting Height of Knee-operated Presser Foot	13mm
Maximum Stitch Length	5mm
Fabric Thickness Capacity	9±1mm(15 layers of denim fabric)
Stitch Type	Straight Stitch
LCD Screen	Yes
Electronic Control Speed Adjustment	Yes
Upper/Lower Needle Position	Yes
Equipped with Slow Start	Yes
Table working height adjustment range:	570-740 mm
Number of packages	2

(Head) Parts List			
Name	Specification	Qty(pcs)	Notes
Thread Stand (1 set)	/	1	Upper Connecting Rod
	/	1	Lower Mounting Rod
	/	1	Pipe Clamp
	/	1	Upper Bracket
	/	1	Lower Bracket
	/	2	Spool Pin Assembly
	/	2	Sponge Pad
	/	2	Disc
	/	2	Spool Holder
Power Cord	/	1	
Oil Pan	/	1	
Rubber Pad	Large,	2	For Connecting Hooks
	Medium	2	For Oil Pan
	Small	2	For Oil Pan
Sewing Needle	/	10	
Bobbin	/	3	
Sewing Machine Oil	/	1	Large Oil Can
Knee Lifter	/	1	
Instruction Manual	/	1	
Cross Self-tapping Screw	/	3	
Connecting Hook	/	2	
Head Support Column	/	1	
Ejector Rod	/	1	
Foot Controller	/	1	
Head Cover	/	1	
Screwdriver	Large,	1	
	Medium	1	
	Small	1	
Small Oil Can	/	1	
Pull Rod Assembly	/	1	
Phillips screwdriver	/	1	
Magnet	/	1	

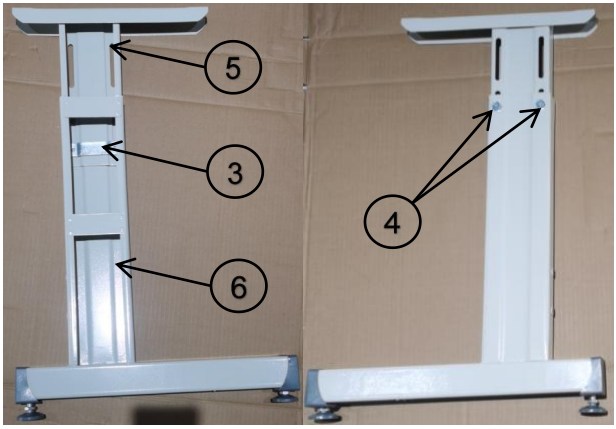
(Table) Parts List			
Name	Specification	Qty（pcs）	Notes
Tabletop	/	1	
Left Leg Bracket	/	1	
Left Leg Adjustment Bracket	/	1	
Right Leg Bracket	/	1	
Right Leg Adjustment Bracket	/	1	
Beam	/	1	
Bottom Beam	/	1	
Foot Pedal	/	1	
Drawer	/	1	
Track	/	2	
Bolt	M8×18	12	
self-tapping screws	M3×12	6	
self-tapping screws	M4×30	4	
Pressure Plate		2	
Foot Pedal Mount		2	

2.INSTALLATION (For reference only)

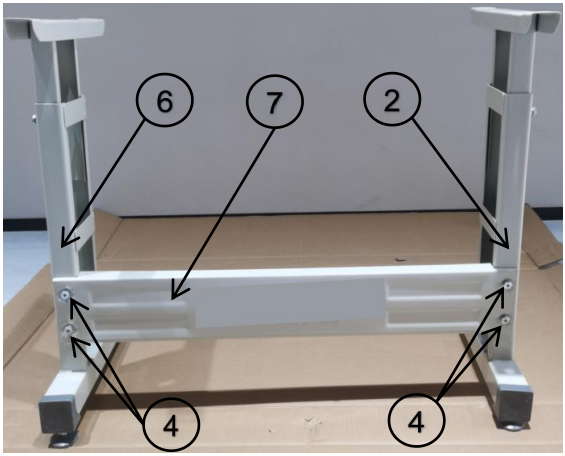
1) Insert **Left Leg Adjustment Bracket** ① into the sliding groove of **Left Leg Bracket** ②. Place **Pressure Plate** ③ on **Left Leg Adjustment Bracket** ①. From one side of **Left Leg Bracket** ②, screw **Bolt** ④ into the threaded hole of **Pressure Plate** ③ and pre-tighten **Bolt** ④. (As shown in the figure below)



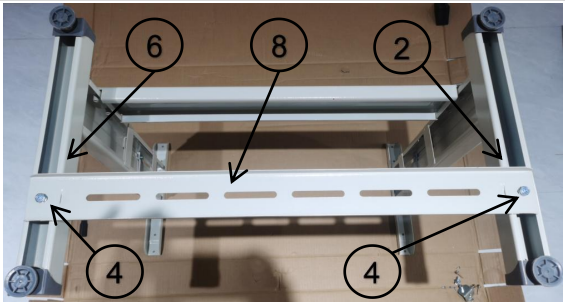
2) Insert **Right Leg Adjustment Bracket** ⑤ into the sliding groove of **Right Leg Bracket** ⑥. Place **Pressure Plate** ③ on **Right Leg Adjustment Bracket** ⑤. From one side of **Right Leg Bracket** ⑥, screw **Bolt** ④ into the threaded hole of **Pressure Plate** ③ and pre-tighten **Bolt** ④.(As shown in the figure below)



3) Install **Beam** ⑦ on the sides of **Left Leg Bracket** ② and **Right Leg Bracket** ⑥ using **Bolt** ④.(As shown in the figure below)



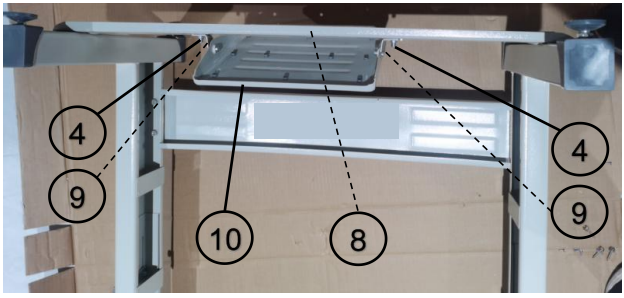
4) Install **Bottom Beam** ⑧ at the bottom of **Left Leg Bracket** ② and **Right Leg Bracket** ⑥ using **Bolt** ④ .(As shown in the figure below)



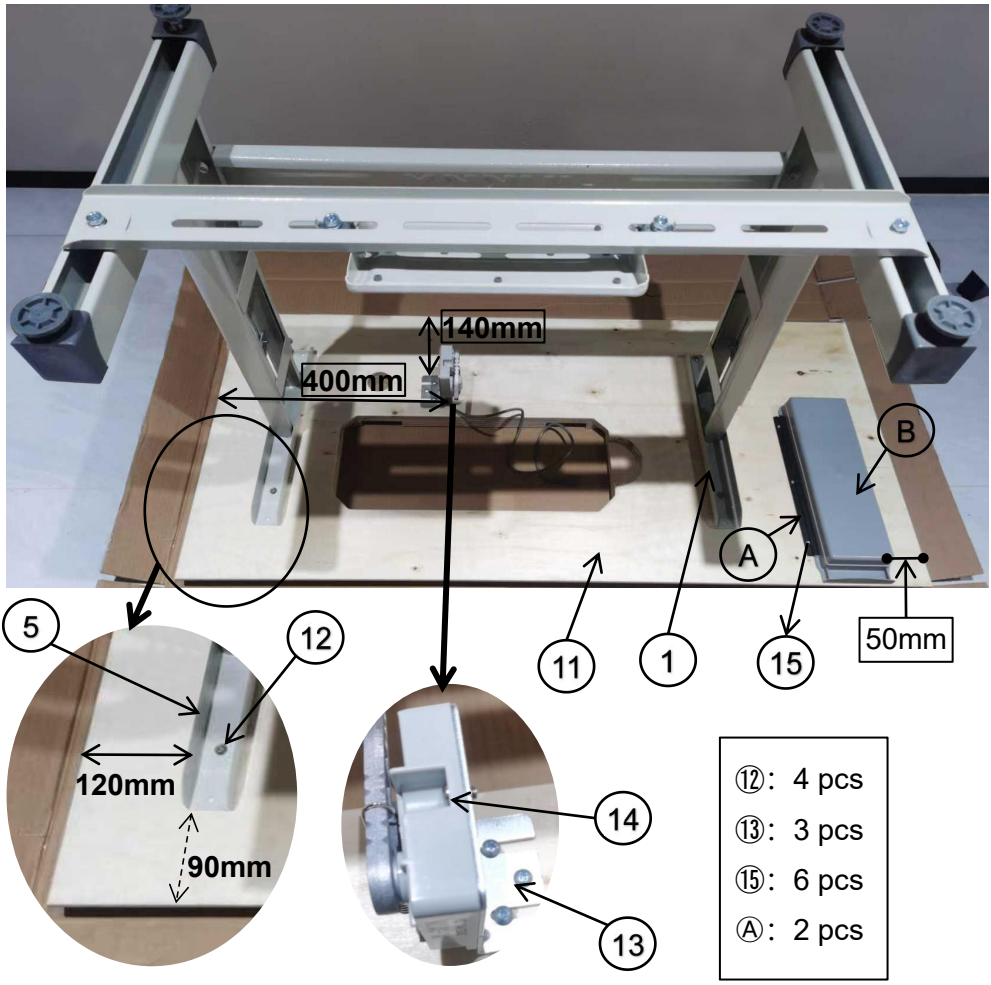
5) Insert the cylindrical heads on **Foot Pedal Mount** ⑨ into the mounting holes on both sides of **Foot Pedal** ⑩, then secure **Foot Pedal Mount** ⑨ to **Bottom Beam** ⑧ using **Bolt** ④ .(As shown in the figure below)



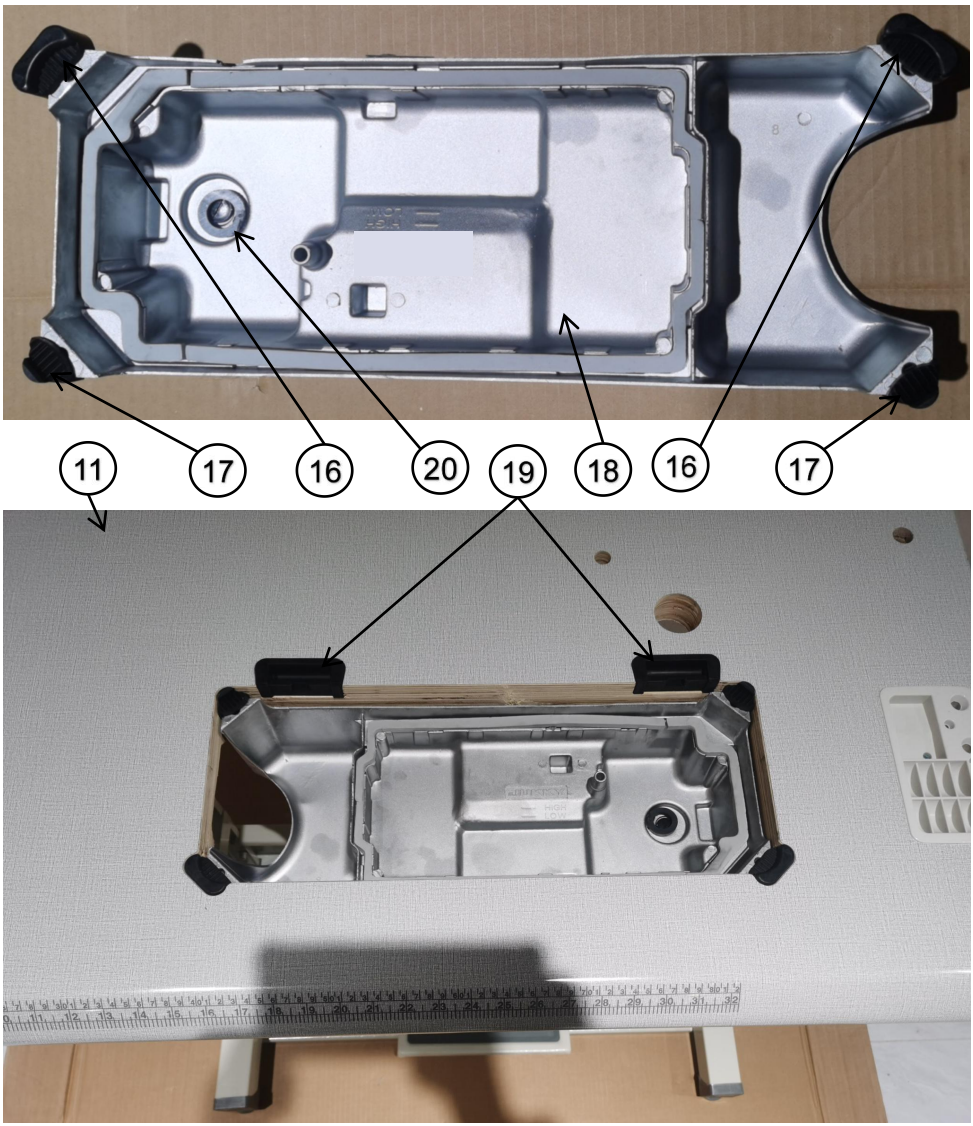




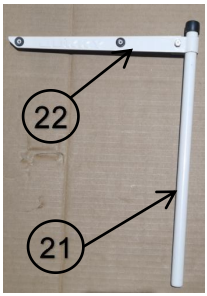
6) 1.Place **Tabletop** ⑪ face down, and fasten **Left Leg Adjustment Bracket** ① and **Right Leg Adjustment Bracket** ⑤ to the back of **Tabletop** ⑪ using **Self-tapping Screws** ⑫.
(As shown in the figure below)
2.Secure **Foot Controller** ⑭ to the back of **Tabletop** ⑪ using **Self-tapping Screws** ⑬. (As shown in the figure below)
3.Fix the **Track** Ⓐ and **Drawer** Ⓑ assembly to the back of **Tabletop** ⑪ using **Self-tapping Screws** ⑮. (As shown in the figure below)

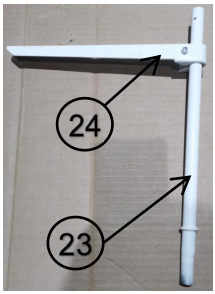


7) Install **Middle Shock Absorber** ⑯ and **Small Shock Absorber** ⑰ in their respective positions on **Oil Pan** ⑱ respectively. Then place the assembly into the corresponding groove of **Tabletop** ⑪, and fit **Large Shock Absorber** ⑲ into its matching groove of **Tabletop** ⑪ ;position **Magnet** ⑳ at the oil drain bolt of **Oil Pan** ⑱.(as shown in the figure).

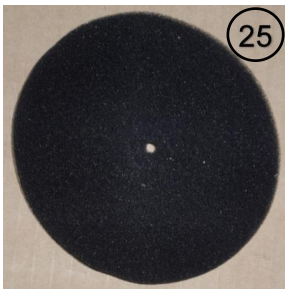


8) 1.First, assemble **Upper Connecting Rod** ㉑ with **Upper Bracket** ㉒. Then, assemble **Lower Mounting Rod** ㉓ with **Lower Bracket** ㉔. Finally, fasten **Upper Connecting Rod** ㉑ and **Lower Mounting Rod** ㉓ together using a **Pipe Clamp** ㉚ . (as shown in the figure).
2.**Sponge Pad** ㉕ and **Disc** ㉖ onto **Spool Pin** ㉗ from the threaded end in sequence, then insert **Spool Pin** ㉗ into the mounting hole on **Lower Bracket** ㉔. Finally, fit **Flat Washer** ㉘ and tighten **Nut** ㉙,Install **Spool Holder** ㉛ onto **Spool Pin** ㉗.
(as shown in the figure)

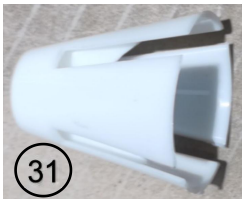










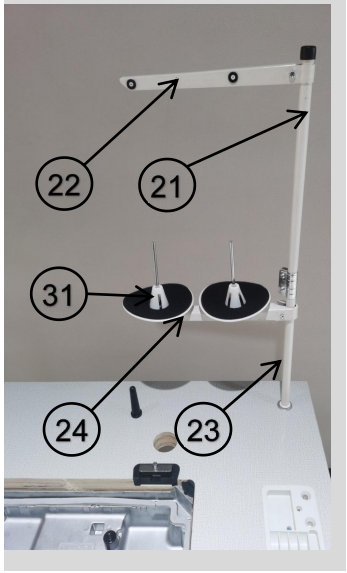




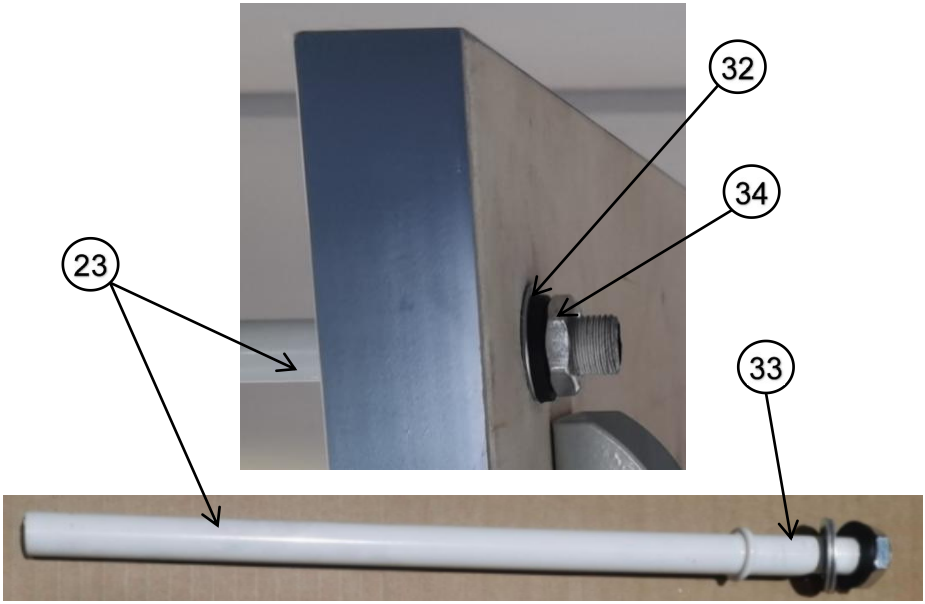




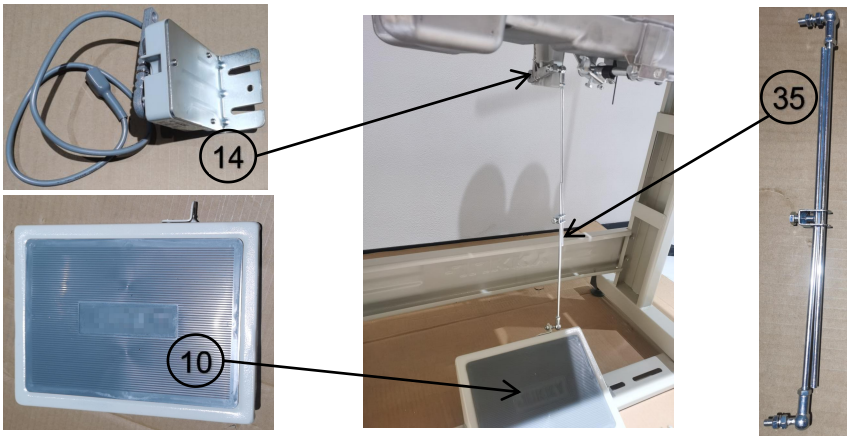




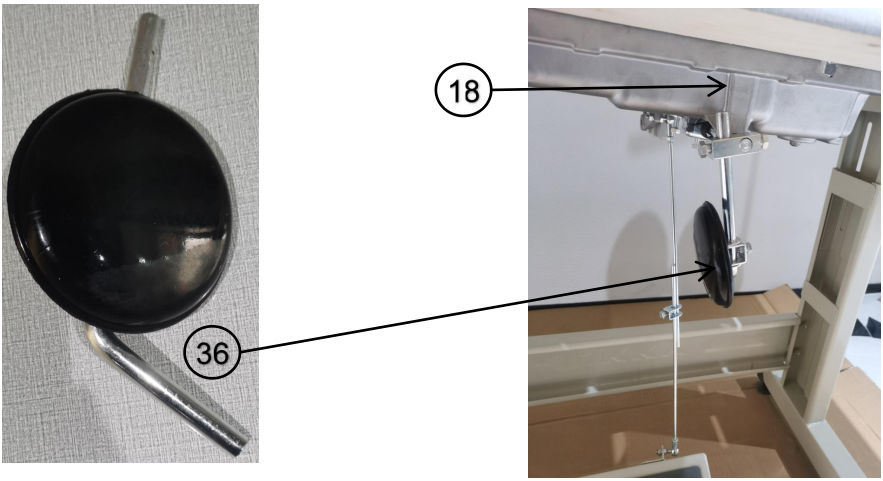
9) Slide **Lower Mounting Rod** ㉓, **Flat Washer** ㉜ and **Rubber Pad** ㉝ through the mounting hole of **Tabletop** ⑪ in sequence, then slide **Flat Washer** ㉜ onto the rod and tighten **Nut** ㉞.(as shown in the figure)



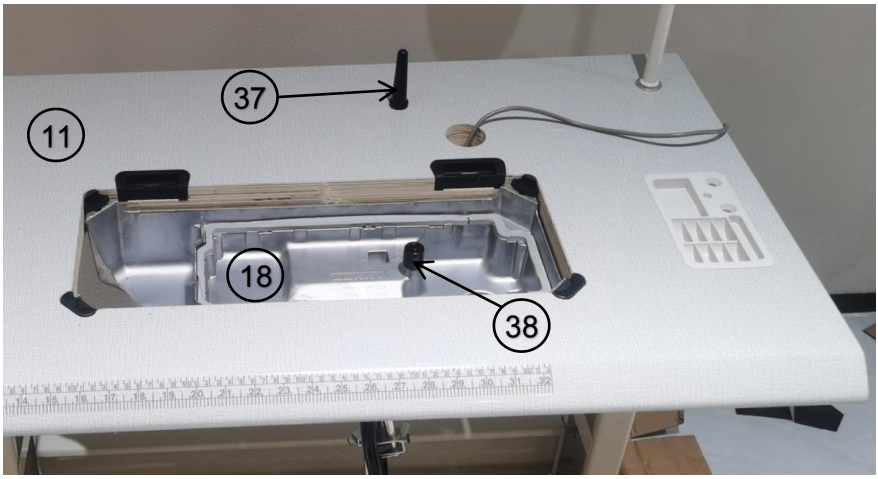
10) Connect the **Foot Controller** ⑭ to the **Foot Pedal** ⑩ using the **Pull Rod Assembly** ㉟. Adjust the position, then tighten all the nuts on the **Pull Rod Assembly** ㉟.(as shown in the figure)



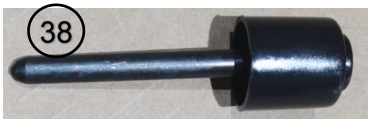
11) Connect the round rod on the **Knee Lifter** ㊱ to the swing block on the **Oil Pan** ⑱. Adjust the position properly, then tighten all the nuts on the assembly.(as shown in the figure)



12) Insert the **Head Support Column** ㊲ into the hole on the **Tabletop** ⑪; place the **Ejector Rod** ㊳ into the hole on the **Oil Pan** ⑱ .

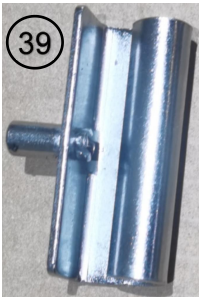


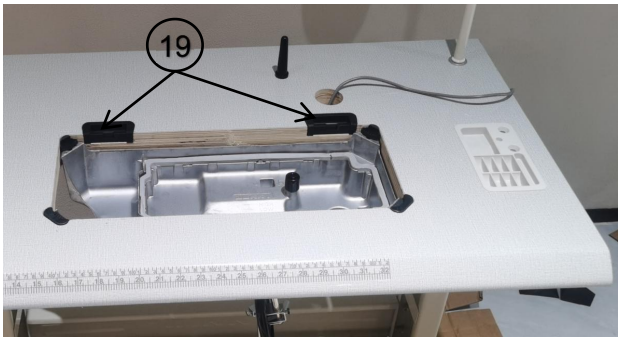




13) First, insert the **Connecting Hook** ㊴ into the mounting hole on the main unit. Then, place the **Connecting Hook** ㊴ together with the main unit into the **Rubber Pad** ⑲ .(as shown in the figure)





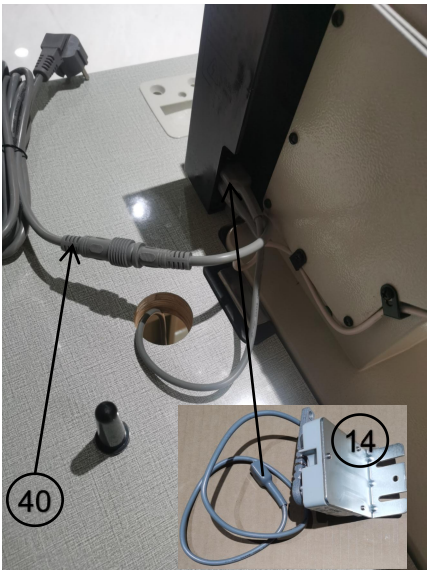


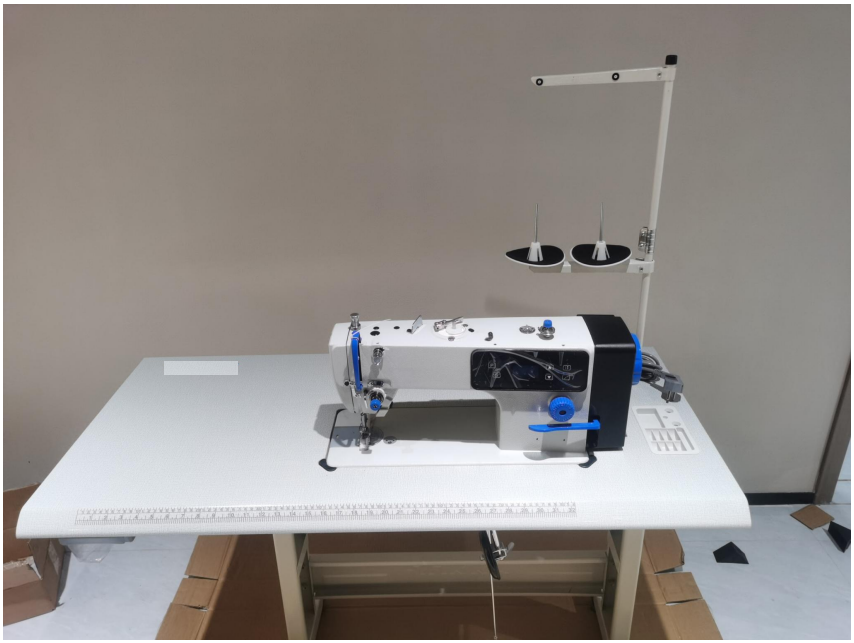




14) Connect one end of the **Power Cord** ㊵ to the power connector on the main unit, Insert the connector of **Foot Controller** ⑭ into its matching portand this completes the entire assembly of the machine .
(as shown in the figure)



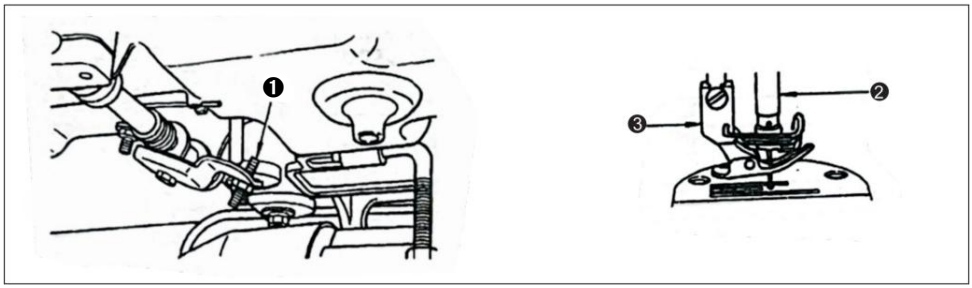




3.ADJUSTING THE HEIGHT OF THE KNEE LIFTER

WARNING:

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

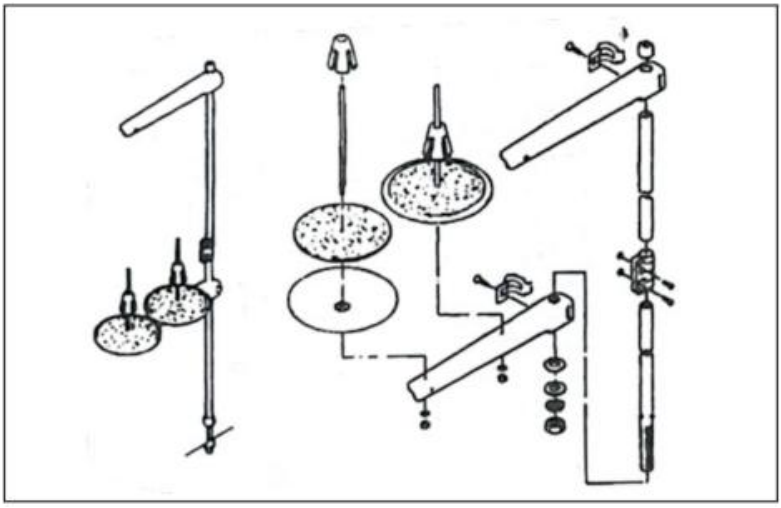


1) The standard height of the presser foot lifted using the knee lifter is 10 mm.

2) You can adjust the presser foot lift up to 13 mm using knee lifter adjust screw ❶.(Max. 9 mm for A type)

3) When you have adjusted the presser foot lift to over 10 mm, be sure that the bottom end of needle bar ❷in its lowest position does not hit presser ❸ foot.

4.INSTALLING THE THREAD STAND

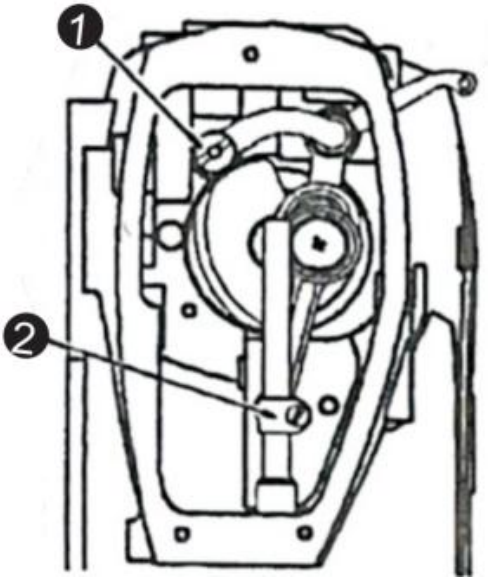


See (2. INSTALLATION 8), 9) for details

5.LIPIN

WARNING:

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



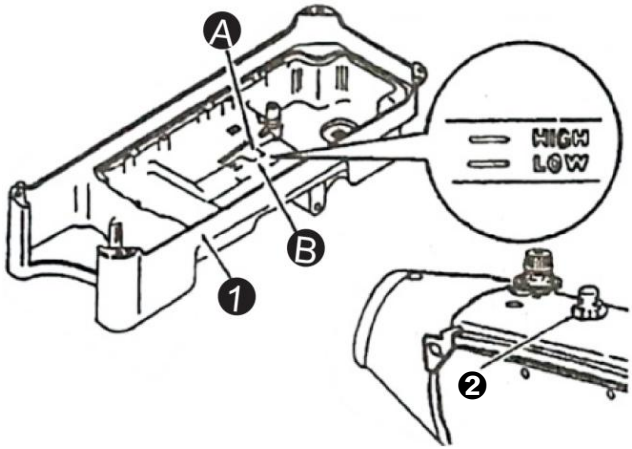
1) Full pore of the thread take-up crank shaft ❶ with lipin before disassembly small screw of the thread take-up crank shaft❶.

2)Disassembly small screw before Disassembly the needle rod holder ASM, then full pore of the needle bar connection ASM ❷ with lipin.

6.LUBRICATION

WARNING:

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



Information on lubrication

1)Fill oil pan ❶ with Machine Oil up to HIGH mark Ⓐ.

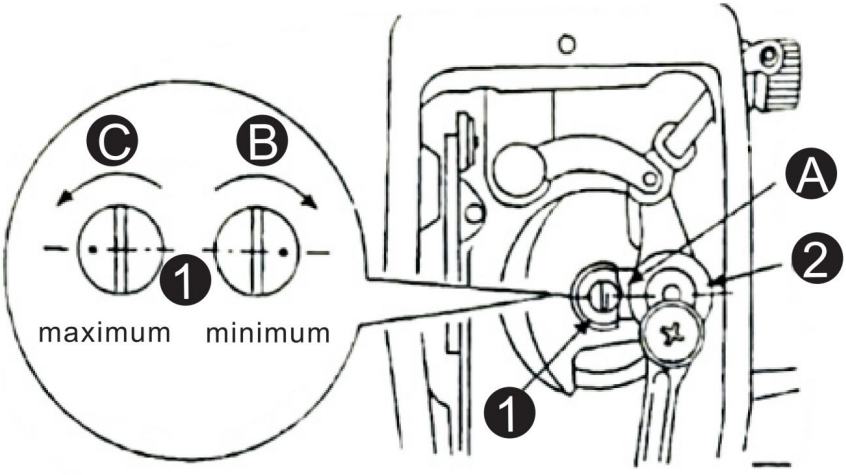
2)When the oil level lowers below LOW mark Ⓑ refill the oil pan with the specified oil.

3)When you operate the machine after lubrication,you will see splashing oil through oil sight window ❷ if the lubrication is adequate.

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



When you first operate your machine after setup or after an extended period of disuse,run your machine at 3,000 to 3,500 rpm,for about 10 minutes for the purpose of break- in.



Adjusting the amount of oil supplied to the face plate parts

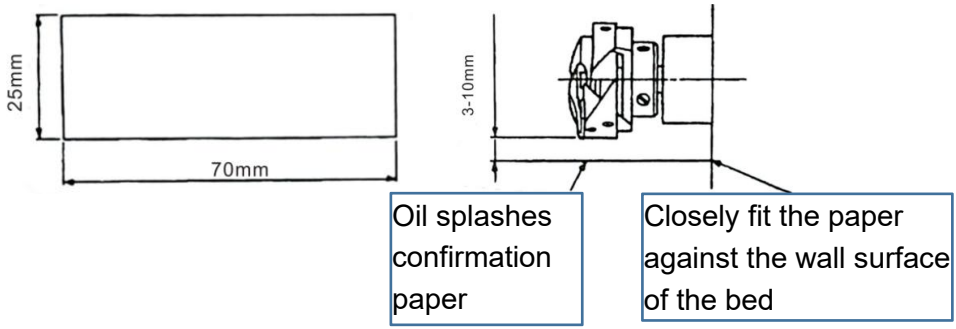
1) Adjust the amount of oil supplied to the thread take upand needle bar crank ❷ by turning adjust pin ❶ .
2) The minimum amount of oil is reached when marker dot Ⓐ is brought close to needle bar crank ❷by turning the adjust pin in direction Ⓑ.
3) The maximum amount of oil is reached when marker dot Ⓐ is brought to the position just opposite from the needle bar crank by turning the adjust pin in direction Ⓒ .

7.ADJUSTING THE AMOUNT OF OIL(OIL SPLASHES) IN THE HOOK

WARNING:

Be extremely careful about the operation of the machine since the amount of oil has to be checked by turning the hook at a high speed.

① Amount of oil (oil splashes)confirmation paper.
② Position to confirm the amount of oil (oil splashes).

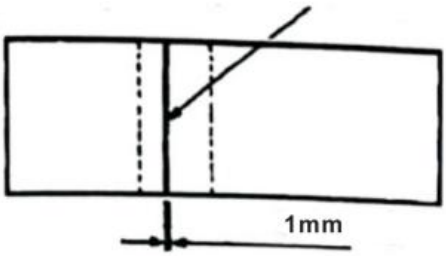


Ж When carrying out the procedure described below in 2, remove the slide plate and take extreme caution not to allow your fingers to come in contact with the hook.

1) If the machine has not been sufficiently warmed up for operation make the machine run idle for approximately three minutes.(Moderate intermittent operation)
2) Place the amount of oil (oil splashes)confirmation paper under the hook while the sewing machine is in operation.
3) Confirm the height of the oil surface in the oil reservoir is within the range between"HIGH"and "LOW".
4) Confirmation of the amount of oil should be completed in five seconds.(Check the period of time with a watch.)

Sample showing the appropriate amount of oil

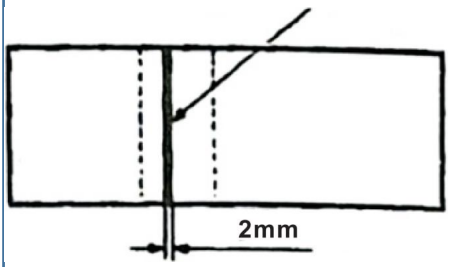
Splashes of oil from the hook oil



Appropriate amount of oil(small)

1) The amount of oil shown in the samples on the left1 mm should be finely adjusted in accordance with sewing processes.Be careful not to excessively increase/decrease the amount of oil in the hook(If the amount of oil is too small, the hook will be seized (the hook will be hot). If the amount of oil is too much, the sewing product may be stained with.

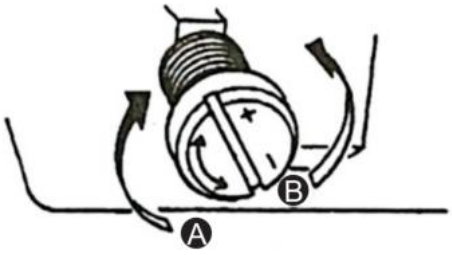
Splashes of oil from the hook



Appropriate amount of oil

2)Adjust the amount of oil in the hook so that the oil amount (oil splashes)should not change while checking the oil amount three times (on the three sheets of paper).

Adjusting the amount of oil



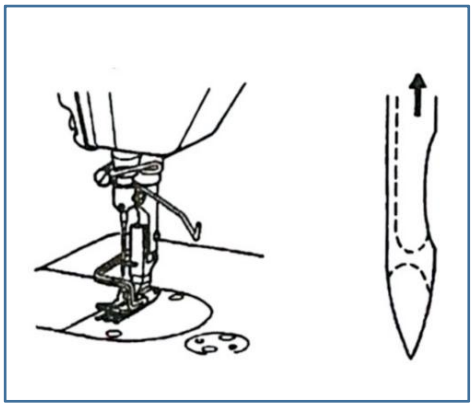
2 mm Appropriate amount of oil (large)

1) Turning the oil mount adjustment screw attached on the hook driving shaft front bushing in the "+" direction (in direction Ⓐ) will increase the amount of oil (oil spots) in the hook, or in the "-" direction (in direction Ⓑ will decrease it.
2) After the amount of oil in the hook has been property adjusted with the oil amount adjustment screw, make the sewing machine run idle for approximately 30 seconds to check the amount of oil in the hook.

8.ATTACHING THE NEEDLE

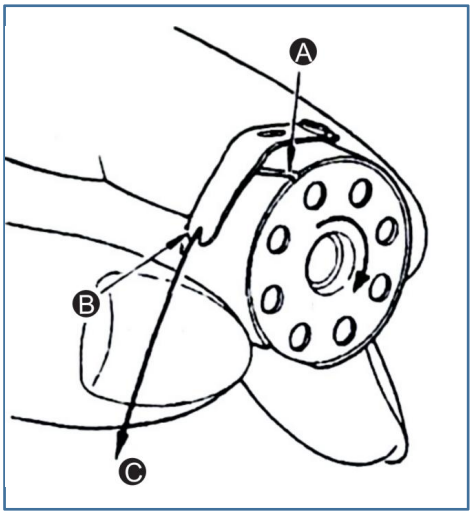


WARNING:
Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



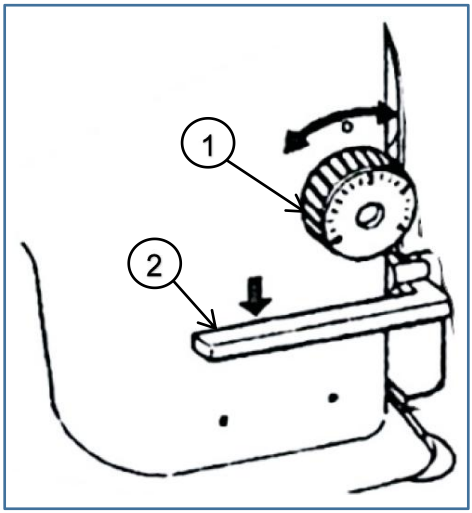
How to use needle
The needle handle is facing upwards, and the direction where the needle has a groove is to the right

9. SETTING THE BOBBIN INTO THE BOBBIN CASE



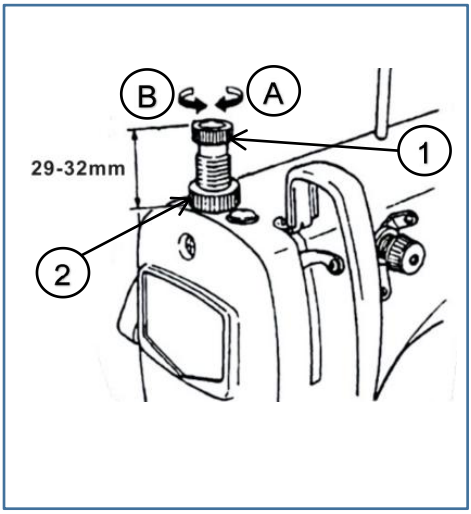
1) Pass the thread through thread slit Ⓐ . and pull the thread in direction Ⓑ . By so doing, the thread will pass under the tension spring and come out from notch Ⓑ .
2) Check that the bobbin rotates in the direction of the arrow when thread Ⓒ is pulled.

10.ADJUSTING THE STITCH LENGTH



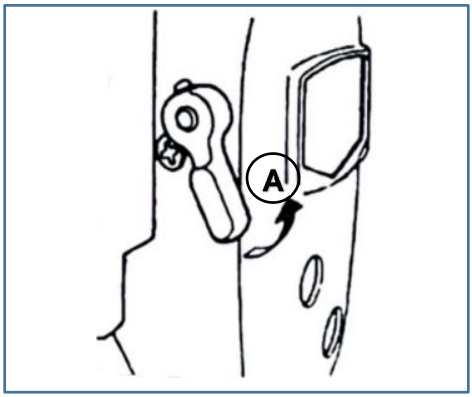
1) Turn stitch length dial ① in the direction of the arrow and align the desired number to marker above on the machine arm .
2) The dial calibration is in millimeters
3) When you want to decrease the stitch length, turn stitch length dial① while pressing feed lever② in the direction of the arrow.

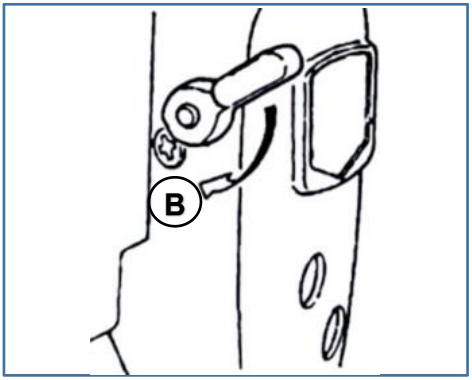
11.PRESSER FOOT PRESSURE



1) Loosen nut ②.As you turn presser spring regulator ① clockwise (in direction Ⓐ) ,the Presser foot pressure will be increased.
2) As you turn the presser spring regulator counterclockwise (in direction Ⓑ),the pressure will be decreased.
3) After adjustment, tighten nut ② . spring regulator is 33 to 36 mm (5kg) .
4) For general fabrics,the standard height of the presser.

12.HAND LIFTER





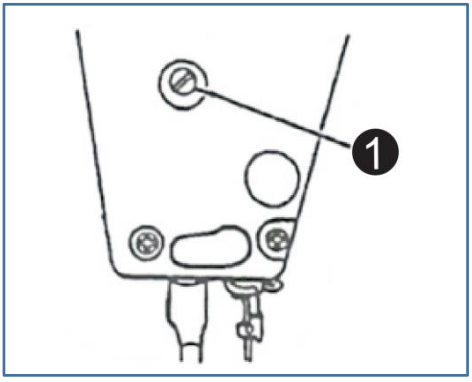
1) To stop the machine with its presser foot up , turn hand lifter lever Din direction Ⓐ .
2) The presser foot will go up about 55mm and stop . The presser foot will go back to its original position when hand lifter lever is turned down indirection Ⓑ .
3) Using the knee lifter you can get the standard presser foot lift of about 10mm and a maximum lift about 13mm .

13.ADJUSTING THE HEIGHT OF THE PRESSER BAR



WARNING:

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



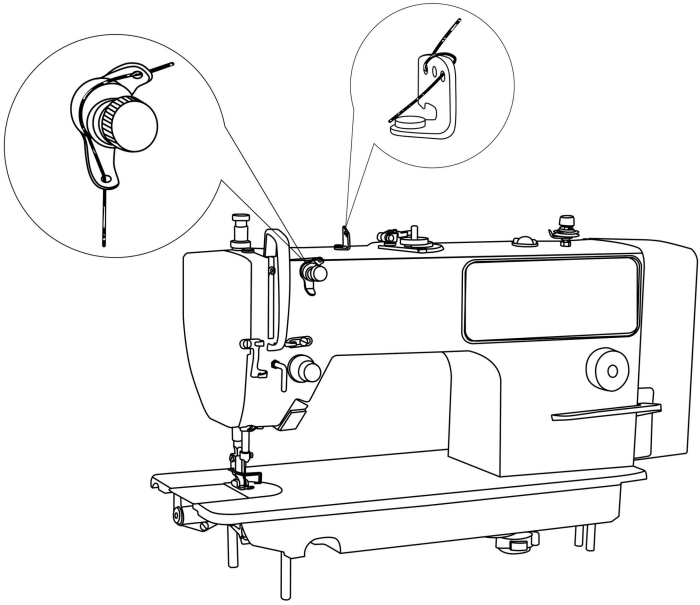
1) Loosen setscrew ❶ and adjust the presser bar height or the angle of the presser foot .
2) After adjustment securely tighten the setscrew ❶ .

14. THREADING THE MACHINE HEAD



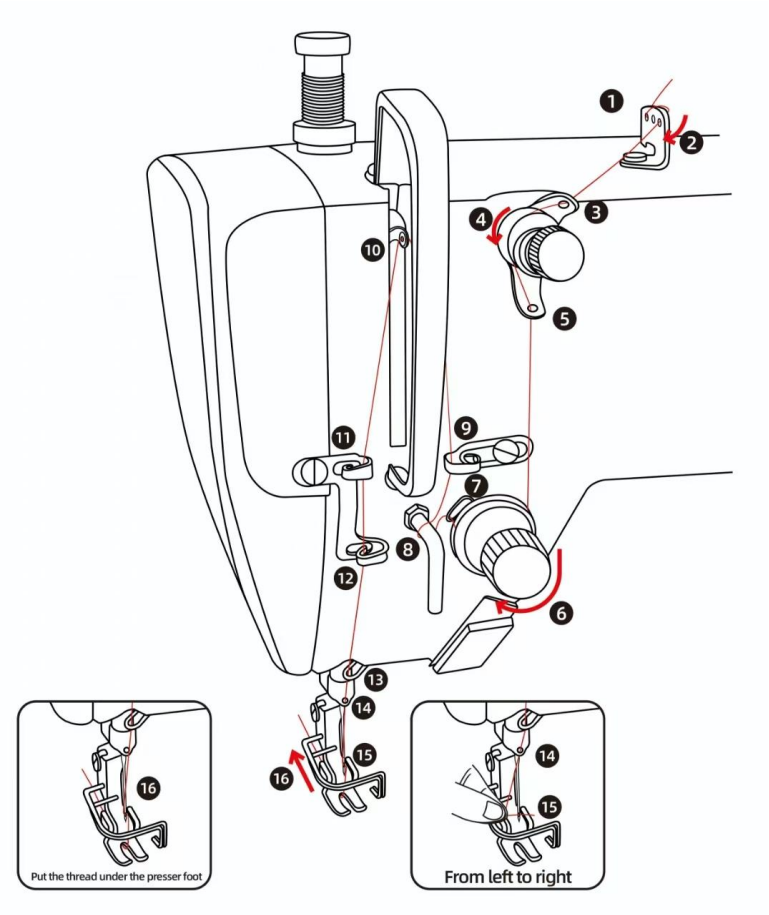
WARNING:

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



Threading diagram : (as shown in the figure)

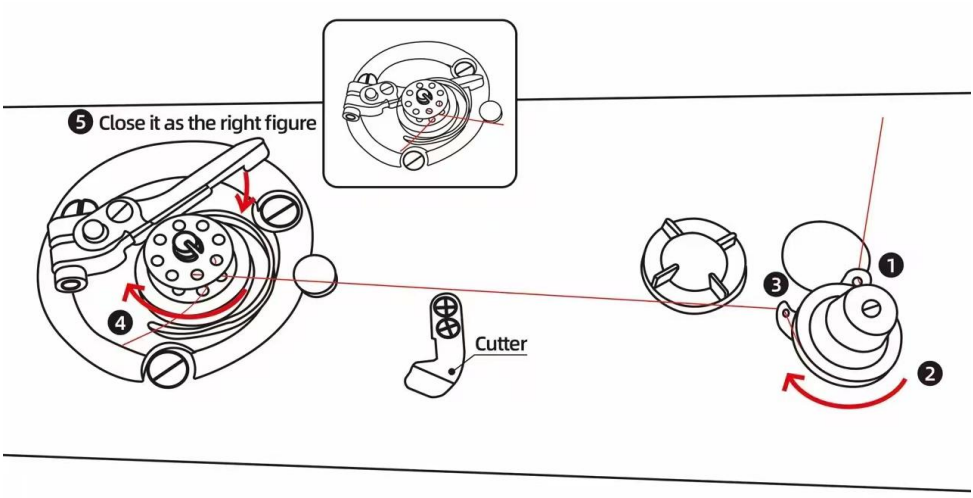
1. Guide the thread through the thread guide (1) and wrap it around the tension disc (2) as indicated by the arrow.
2. Pass the thread through the upper thread guide (3) and wrap it around the thread tension regulator (4) following the arrow direction, then go through the small thread guide (5).
3. Loop the thread around the thread take-up lever (6) along the red arrow path.
4. Thread through the thread guides (7, 8, 9) in sequence.
5. Pass the thread through the vertical thread guides (10, 11, 12) one by one.
6. Guide the thread through the thread guide above the needle (13), then the thread guide on the needle bar (14) and needle threader (15).
7. Thread the needle from left to right (as shown in the inset), then pull the thread under the presser foot (16) as indicated.



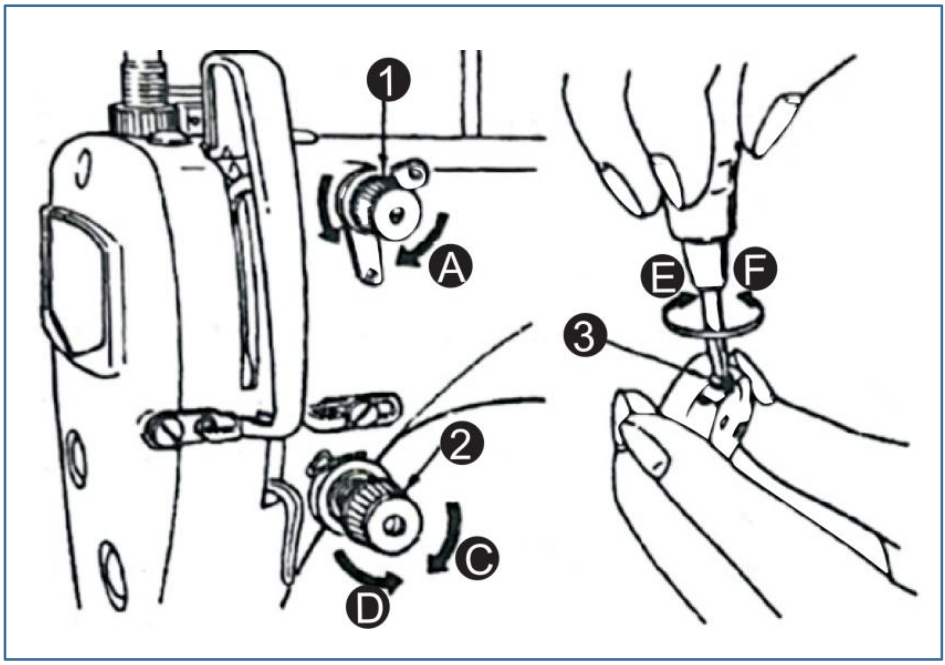
Bobbin winding threading diagram : (as shown in the figure)

1. Mount the bobbin: Place the bobbin onto the bobbin spindle (4) securely.
2. Put the wire through position (1) of the wire clamp, then follow the arrow (2) direction to position (3).
3. Secure the thread end: Wind the thread around the spindle in the direction of the red arrow (4) to fasten the loose thread end.
4. Close the bar: close the bar as shown in the reference figure (5).

Additionally, the "Cutter" (labeled in the middle) refers to the thread cutter for trimming excess thread.



15.THREAD TENSION



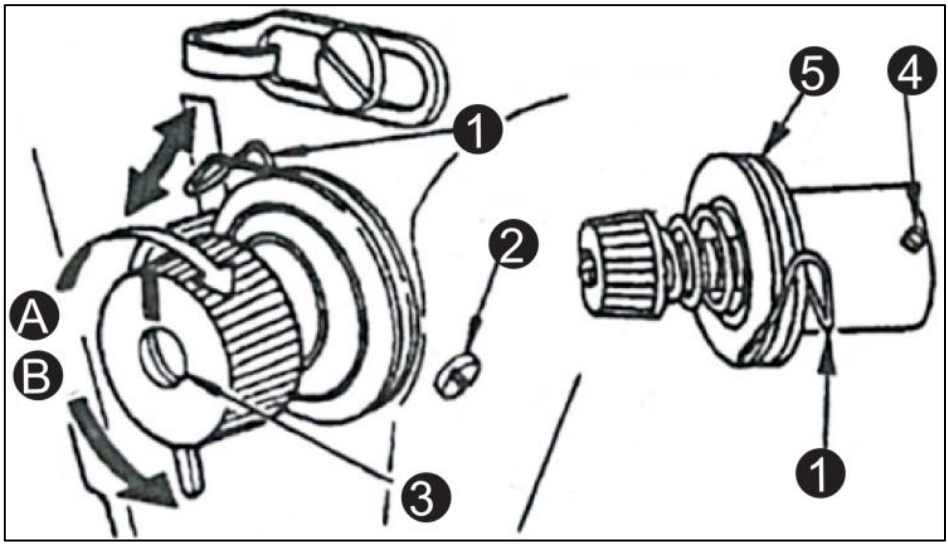
(1) Adjusting the needle thread tension

1) As you turn thread tension No.1 nut ❶ clockwise (in direction Ⓐ), the thread remaining on the needle after thread trimming will be shorter .
2) As you turn nut ❶ counterclockwise (in direction Ⓑ) the thread length will be longer.
3) As you turn thread tension No.2 nut ❷ clockwise (in direction Ⓒ)the needle thread tension will be increased .
4) As you turn nut ❷ counterclockwise (in direction Ⓓ) the needle thread tension will be decreased .

(2) **Adjusting the bobbin thread tension**

1) As you turn tension adjust screw ❸ clockwise (in direction Ⓔ) , the bobbin thread tension will be increased .
2) As you turn screw ❸ counter clock wise (in direction Ⓕ). he bobbin thread tension will be decreased.

16. THREAD TAKE-UP SPRING



(1) Changing the stroke of thread take-up spring ❶

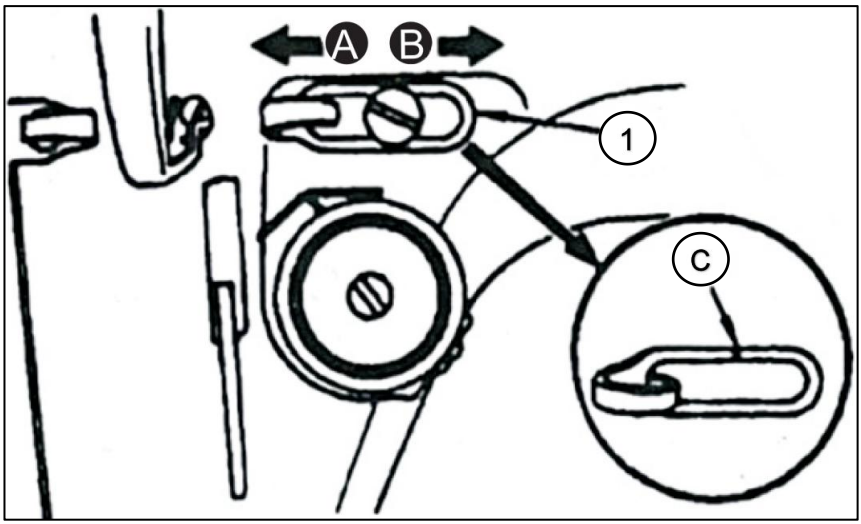
1) Loosen setscrew ❷.
2) As you tun tension post ❸ clockwise (in direction Ⓐ) , the stroke of the thread take-up spring will be increased.
3) As you turn the knob counterclockwise (in direction Ⓑ) , the stroke will be decreased.

(2) **Changing the pressure of thread take-up spring ❶**

1) Loosen setscrew ❷ , and remove thread tension (asm) ❺ .
2) Loosen setscrew ❹ .
3) As you turn tension post ❸ clockwise (in direction Ⓐ) the pressure will be increased.
4) As you turn the post ❸ counter clockwise (in direction Ⓑ) , the pressure will be decreased.

17.ADJUSTING THE THREAD TAKE-UP STROKE

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

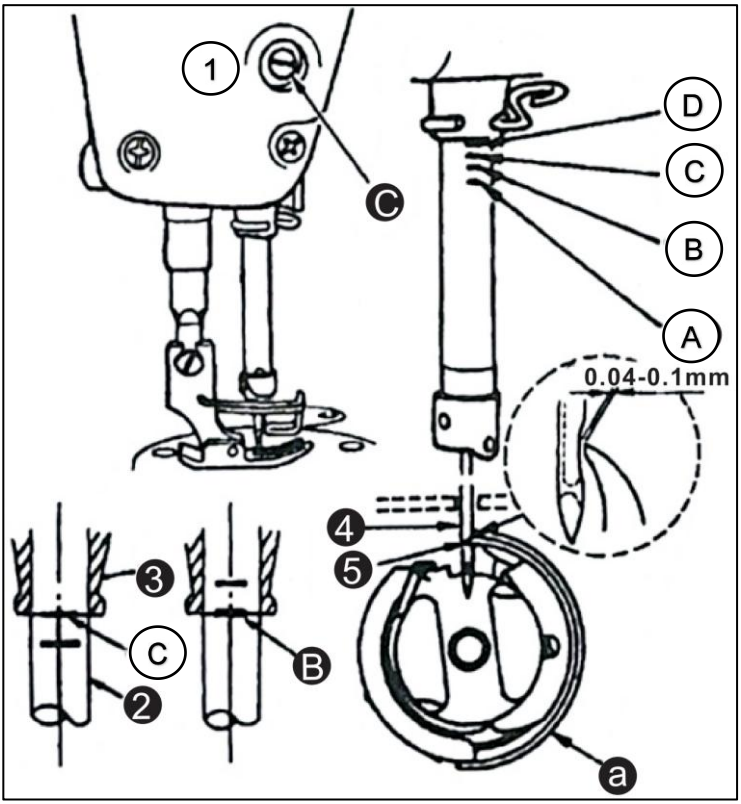


1) When sewing heavy-weight materials, move thread guide ❶ to the left (in direction Ⓐ) to increase the length of thread pulled out by the thread take-up.
2) When sewing light-weight materials . move thread guide ❶ to the right (in direction Ⓑ) to decrease the length of thread pulled out by the thread take-up .
3) Normally,thread guide ❶ is positioned in a way that marker line Ⓒ is aligned with the center of the screw .



WARNING:
To avoid possible personal injury due to abrupt start of the machine , turn off the power to the machine and check to be sure that the motor has totally stopped rotating in prior.

18.NEEDLE-TO-HOOK RELATIONSHIP



Adjust the timing between the needle and the hook as follows:

1) Turn the handwheel to bright the needle bar down to the lowest point of its stroke, and loosen setscrew ❶ .
2) Adjusting the needle bar height
   (For a DB needle) Align marker line C on needle bar ❷ with the bottom end of needle bar lower bushing ❸ then tighten setscrew ❶ .
   (For a DA needle) Align marker line D on needle bar ❷ with the bottom end of needle bar lower bushing ❶ thentighten setscrew ❶.
3) Adjusting position ofthe hook ⓐ
   (For a DB needle) Loosen the three hook setscrews, turn the handwheel and align marker line A on ascending needle bar with the bottom end of needle bar lower bushing ❸ .
   (For a DA needle) Loosen the three hook setscrews, turn the handwheel and align marker line C on ascending needle bar with the bottom end of needle bar lower bushing ❸ .
4) After making the adjustments mentioned in the above steps, align hook blade point ❺ with the center of needle ❹ .Provide a clearance of 0.04 mm to 0.1 mm (reference value) between the needle and the the hook,then securely tighten setscrews in the hook.

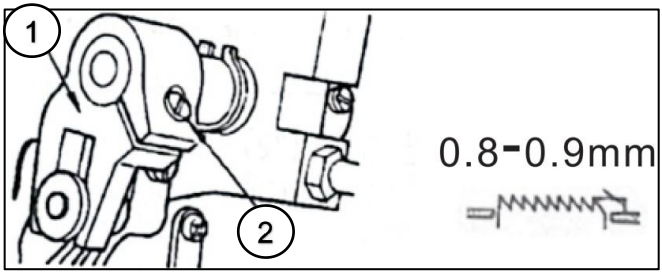


If the clearance between the blade point of hook and the needle is smaller than the specified value, the blade point of hook will be damaged. If the clearance is larger, stitch skipping will result.

19.HEIGHT OF THE FEED DOG



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



To adjust the height of the feed dog :

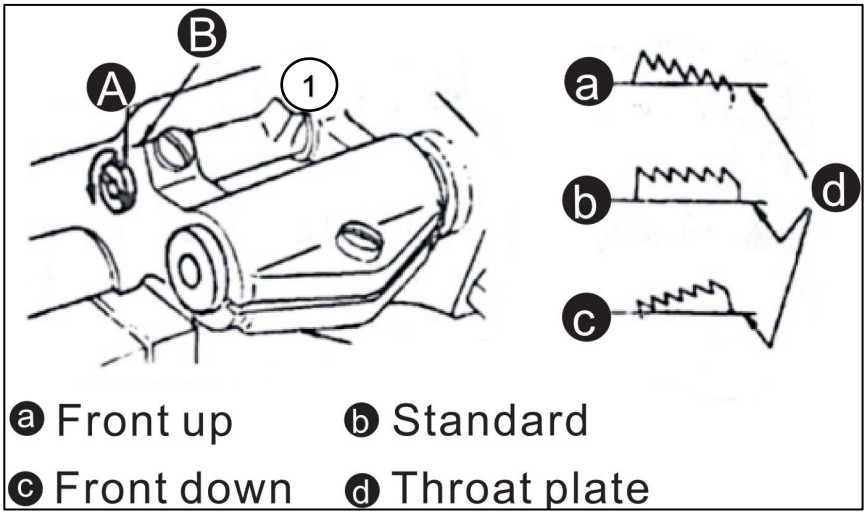
1) Loosen screw ❷ of crank ❶ .
2) Move the feed bar up or down to make adjustment .
3) Securely tighten screw ❷ .

If the calmping pressure is insufficient , the motion of the forked portion becomes heavy .

20.TILT OF THE FEED DOG

WARNING:

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



1) The standard tilt (horizontal) of the feed dog is obtained when marker dot Ⓐ on the feed bar shaft is aligned with marker dot Ⓑ on feed rocker ❶ . (the marker dot Ⓑ inclines forward the feed rocker shaft by 90° as standard) .
2) To tilt the feed dog with its front up in order to prevent puckering,loosen the setscrew, and turn the feed bar shaft 90° in the direction of the arrow using a screwdriver .
3) To tilt the feed dog with its front down in order to prevent uneven material feed, turn the feed bar shaft 90° in the opposite direction from

the arrow (The standard tilt for) .



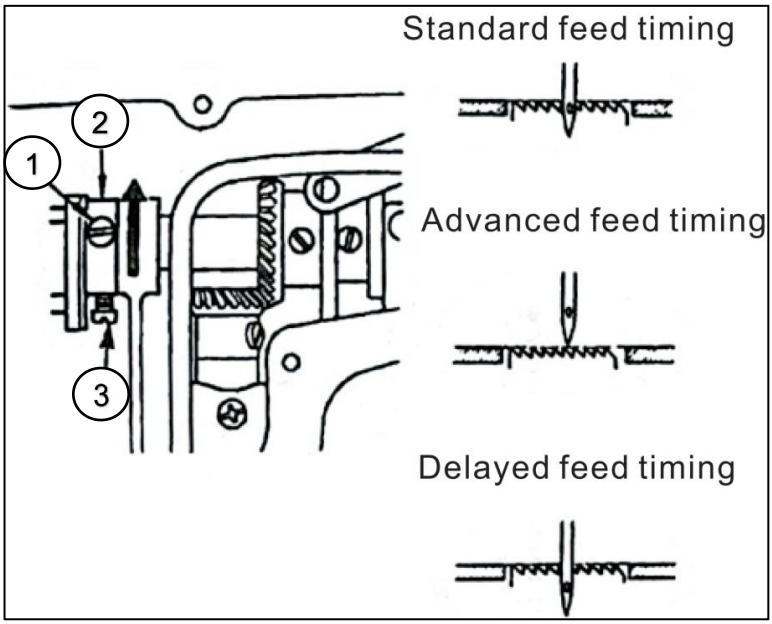
Whenever the feed dog tilt is adjusted, the feed dog height will be changed. So, it is necessary to check the height after tilt adjustment.

21.ADJUSTING THE FEED TIMING

WARNING:



To avoid possible personal injury due to abrupt start of the machine, turn off the power to the machine and chock to be sure that the motor has totally stopped rotating in prior.



1) Loosen screws ❷ and ❸ in feed eccentric cam ❶ .move the feed eccentric cam in the direction of the arrow or opposite direction of the arrow and firmly tighten the screws .
2) For the standard adjustment, adjust so that the top surface of feed dog and the top end of needle eyelet are flush with the top surface of throat plate when the feed dog descends below the throat plate.
3) To advance the feed timing in order to prevent uneven material feed,move the feed eccentric cam in the direction of the arrow .

4) To delay the feed timing in order to increase stitch tightness. move the feed eccentric cam in the opposite, direction from the arrow .



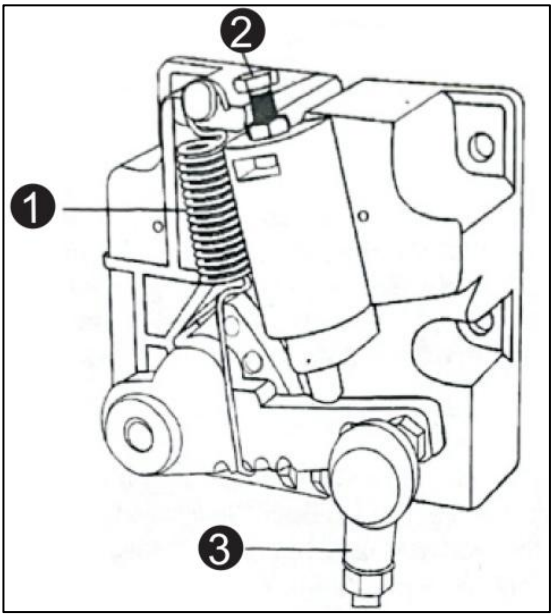
Be careful not to move the feed eccentric cam too far, or else needle breakage may result .

22.PEDAL PRESSURE AND PEDAL STOKE



WARNING:

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



(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 ❶ .

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 pedal

1)This pressure can be adjusted using regulator screw ❷ .

2)The pressure increases as you turn the regulator screw in .

3)The pressure decreases as you turn the screw out .

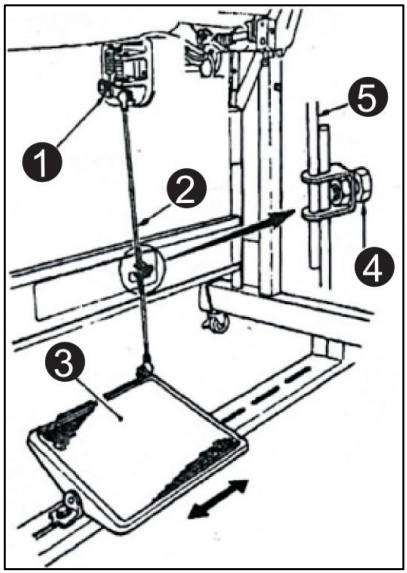
(3)Adjusting the pedal stroke

The pedal stroke increases when you insert connecting rod ❸ into the right hole.

23.ADJUSTMENT OF THE PEDAL

WARNING:

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



(1) Installing the connecting rod

Move pedal ❸ to the right or left as illustrated by the arrow so that motor control lever ❶ and connecting rod ❷ are straightened .

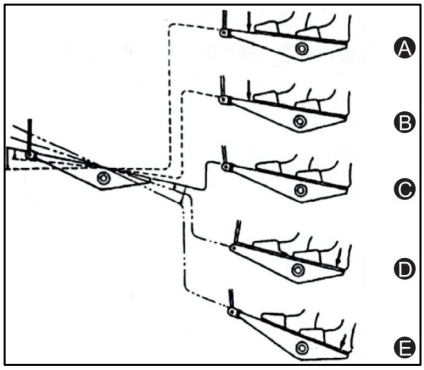
(2) Adjusting the pedal angle

1) The pedal tilt can be freely adjusted by changing the length of the connecting rod.

2) Loosen adjust screw ❹ , and adjust the length of connecting rod ❺ .

See (2. INSTALLATION 10) for details

24.PEDAL OPERATION



The pedal is operated in the following four steps:

1) The machine runs at low sewing speed when you lightly depress the

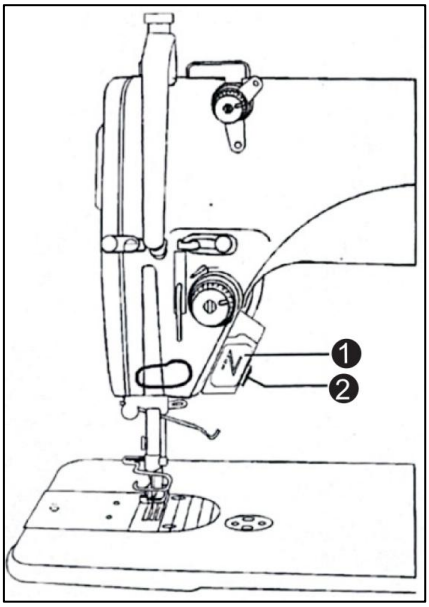
front part of the pedal Ⓑ .

2) The machine runs at high sewing speed when you further depress the front part of the pedal Ⓐ . (If the automatic reverse feed stitching has been preset,the machine runs at high speed after it completes reverse feed stitching) .
3) The machine stops (with its needle up or down) when you reset the pedal to its original position Ⓒ .
4) The machine trims threads when you fully depress the back part of the pedal Ⓔ .If your machine is provided with the Auto-lifter an addition step is given between the machine stop and thread trimming step. The presser foot goes up when you lightly depress the back part of the pedal Ⓓ and if you further depress the back part, the thread trimmer is actuated .

25.ONE-TOUCH TYPE REVERSE FEED.STITCHING MECHANISM



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



(1)How to operate

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

(2)How to operate the LED light

1) Push the button❷ ,LED light be bright.
2) Pull the button❷ ,LED light be power off.

26.MANUAL OF SIMPLE INTEGRATED SYSTEM FOR LOCKSTITCH SEWING MACHINE V1.1

Safety precautions

Before use, please read this manual and lockstitch machine's manual at the same time, thanks for your cooperation.

1.1 (1) The voltage and working frequency: please according the name plate of motor and contorlling box.
(2)Electromagnetic interference:Please stay away from high-frequency magnetic wave machines or Radio wave transmitter etc.In order to prevent the generated electromagnetic waves from interfering with the drive device and causing wrong action.
(3)Grounded:To prevent noise interference or leakage accidents,Please do grounding works including sewing machine, motor and control box.
1.2 If Disassemble motor and controlling box,please Turn off the power in advance.Dangerous high voltage electricity in the electric control box, so please waiting more than 1 mins after Turn off the power, then to disassemble the control box

1.3 When reinstalling the motor,Note that there is a certain gap between the stator and the rotor, it's untouchable.

1.4 To ensure the safety of life,Please turn off the power when repair the machine or threading needles.

1.5 This symbol indicates when the machine is installed,if made a mistake,the human body or the machine may be damaged,Therefore, there will be this mark in the dangerous place of the machine.
This symbol indicates that there is high voltage, etc.Electrically dangerous places have this mark.

1.6 This products guarantees a one-year warranty under normal working conditions and no-one error operation

2.Instructions

2.1 Reset

In the shutdown state, press ▲▼ at the same time to turn on, then press the "S" key to confirm to recover

2.2 Monitoring mode

Press the S key for 2 seconds to enter the monitoring state, press ▲▼ to change the monitoring serial number, the monitoring value cannot be modified. The specific monitoring interface is shown in the table below.

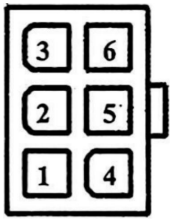
Display No.	Item number	unit
SPd	Speed	10rpm
CUr	Current	0.1A
UdC	Voltage	V
PdL	Pedal	/

Display No.	Item number	unit
HAL	HAL	/
id	Model	/
vEr	Version	/

3. Key Description

Function parameter Edit key		Enter or exit the editing of function parameters
Parameter view save key		View and save the content of the selected parameter number: After selecting the parameter number, press this key to view and modify the operation, after modifying the parameter value, press this key to exit and save the parameter
Up selection key		1.Increment key for parameter item in parameter selection area 2.Set the value increment key in the parameter content area
Down Select key		1.Decrease key of parameter item in parameter selection area 2.Set the value decreasing key in the parameter content area
Slow start key		1.To setting open or cancel the slow start sewing function 2.If this key and the 'down selection key' are combination to one key, press and hold for 1 second to turn on or cancel the slow start sewing function
Stop needle position selection key		1.Switch the stop position of the needle after sewing (upper position / down position) 2.If this key and the 'up selection key' are combination to one key, press it for 1 second to switch the needle position

4. Electrical control interface definition



Definition	Model (Jog needle)	Reserved	5V (Sewing lights)
Foot position	6PIN	5PIN	4PIN
Definition	Ground wire (Jog needle)	Reserved	Ground wire (Sewing lights)
Foot position	3PIN	2PIN	1PIN

5. Failure description

Error code	Fault content	Reason	Inspection items and how to fix
E-01	System voltage is too high	Actual voltage is too high Incorrect voltage detection	Whether the incoming line voltage of the system is too high Whether the braking resistor is working properly Whether the system voltage detection circuit works normally
E-02	System voltage is too low	Actual voltage is low Incorrect voltage detection	Whether the incoming line voltage of the system is too low Whether the system voltage detection circuit works normally
E-03	Operation box communication is poor	The communication data of the head operation box is lost	Whether the operation box plug is in good contact Whether the operation box device is damaged Whether the operation box program has been burned
E-05	Pedal ID failure	Pedal recognition failure	Loose pedal joint
E-07	Motor overload	Motor blocked, Motor overload	Whether the motor plug is in good contact Whether the machine bead or trimming mechanism is stuck Whether to sew fabrics above the specification thickness Whether the current detection signal is normal
E-09 / E-11	Motor signal failure	Motor positioning signal failure	Whether the motor encoder interface is in good contact Whether the needle stop substrate is installed in place

E-14	Encoder signal is abnormal	Motor sensor signal failure Motor power cable is damaged	Whether the motor encoder interface is in good contact Whether the motor interface is in good contact
E-15	Motor current is too large	Current detection is abnormal The motor is running abnormally	Whether the system current detection circuit is working normally Whether the motor signal is normal
E-17	Flip switch failure	Flip switch effective	Put down the machine head or check the flip switch
E-22	OZ loop failure	OZ loop detection abnormal	Check whether the OZ circuit is normal

Note: If the above faults cannot be eliminated according to the inspection items, please apply for technical support.

6. Parameter list

Parameter	Description	Range	Initial value	Content value name description and remarks
P-01	Maximum speed	200~3700	3700	Maximum speed setting during sewing
P-02	Synchronizer selection	0~2	1	"0" mean Needle up, "1" mean Needle down, "2" mean without signal
P-03	Soft start switch	0~1	1	"0" mean open, "1" mean turn off
P-04	Soft start Speed	200~1500	400	Soft start speed function setting
P-05	Number of soft start stitches	1~15	1	1-15 Number of soft start stitches
P-06	Minimum speed	200~500	200	Minimum speed setting during sewing
P-07	Upper needle position adjustment	0~23	0	machine head position adjustment
P-08	Down needle position adjustment	0~23	12	Position adjustment of lower needle stop
P-09	Automatically find the needle position when starting up	0~1	0	"0" mean can't find upper needle position adjustment, "1" mean find upper needle position adjustment
P-10	machine bead protection switch detection	0~2	1	"0" mean no detection, "1"Detect zero signal, "2" mean Detect positive signal

P-11	Acceleration curve adjustment	0~100	32	Speed controller acceleration and climb slope setting
P-15	Needle supplement method	0~3	3	"0" mean Half stitch, "1" mean One stitch, "2" mean Continuous half stitch, "3"Continuous one stitch
P-21	Motor running direction	0~1	1	"0" mean Clockwise, "1" mean Counterclockwise
P-22	Automatically running speed	200~3700	3500	Setting automatically check speed
P-23	Automatic running time	1~250	20	Automatic running-in time setting
P-24	Automatic stop time	1~250	20	Automatically check in pause time setting
P-25	Continuous running test	0~1	0	Speed continuous operation "0" mean turn off, "1" open
P-26	Intermittent running and testing	0~1	0	Perform positioning cycle operation, "0" mean turn off, "1" open
P-36	Model selection	1	1	Model replacement

Note: If the above parameters do not match the actual parameters, please refer to the machine parameters.

Product Application

An industrial sewing machine is a type of sewing equipment specifically designed for large-scale, high-efficiency, and long-duration continuous production. It is essentially different from a household sewing machine, with its core positioning as a production tool rather than a household consumer product.

Its main characteristics are as follows:

High Speed: It usually operates at a speed of 3,000–5,500 revolutions per minute (RPM) or even higher, far exceeding that of household sewing machines.

High Durability: Featuring a robust frame structure and wear-resistant materials, it can withstand continuous high-intensity operation for over ten hours a day.

Specialization: Each model is typically dedicated to one or a limited number of specific sewing processes (e.g., lockstitching, overlocking,

coverstitching), pursuing optimal efficiency and quality for its designated functions.
High Stability: It ensures consistent stitch formation and stable quality during long hours of operation, thereby reducing the defective rate.
Integration with Workbench: It usually needs to be mounted on a dedicated industrial table to form a complete workstation.

Product Usage Environments and Target Users

Application Scenarios:

1. Small individual workshops
2. Small and medium-sized clothing factories

Applicable to heavy-duty sewing tasks:

Leather, waterproof fabric, canvas, denim, bags, wallets, belts, dog collars, etc.

FCC Information:

CAUTION: Changes or modifications not expressly approved by the party responsible for compliance could void the user's authority to operate the equipment!
This device complies with Part 15 of the FCC Rules. Operation is subject to the following two conditions:
1) This product may cause harmful interference.
2)This product must accept any interference received, including interference that may cause undesired operation.
WARNING: Changes or modifications to this product not expressly approved by the party.responsible for compliance could void the user's authority to operate the product.
Note: This product has been tested and found to comply with the limits for a Class B digital device pursuant to Part 15 of the FCC Rules, These limits are designed to provide reasonable protection against harmful interference in a residential installation.
This product generates, uses and can radiate radio frequency energy, and if not installed and used in accordance with the instructions, may cause

harmful interference to radio communications. However, there is no guarantee that interference will not occur in a particular installation. If this product does cause harmful interference to radio or television reception,which can be determined by turning the product off and on, the user is encouraged to try to correct the interference by one or more of the following measures.

· Reorient or relocate the receiving antenna.

· Increase the distance between the product and receiver.

· Connect the product to an outlet on a circuit different from that to which the receiver is connected.

· Consult the dealer or an experienced radio/TV technician for assistance.

Shipping Notice: Your sewing machine (Head & Table) are in separate boxes and may arrive at different times. Please expect both packages.