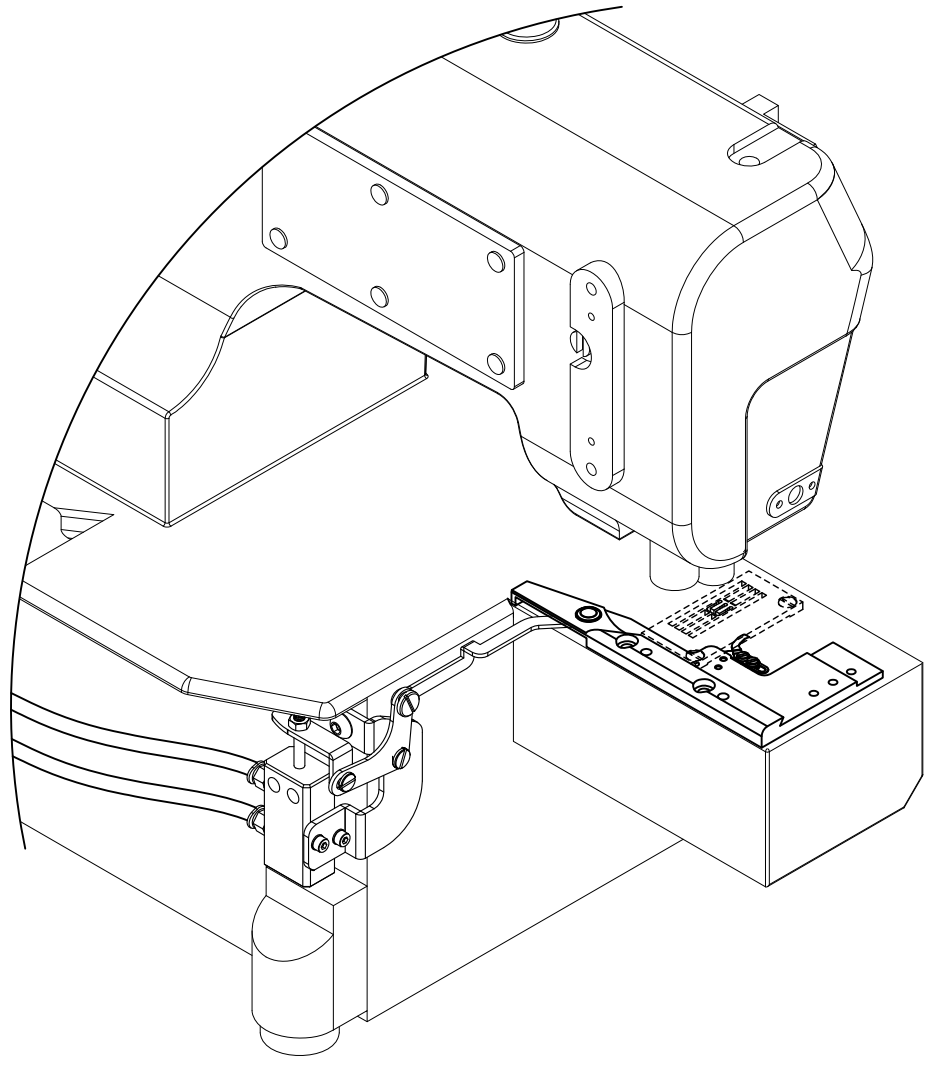


NLK

安裝說明書

W664-34 Installation Instruction

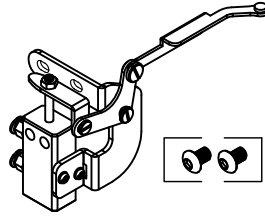


2015.02/Ver:1.2

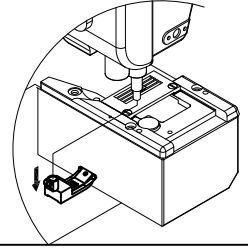
前言 PREFACE:

◎請依本說明書頁次逐項安裝與調整，以確保您可以在最短時間內得到最佳運轉效果。
Please follow this operation instruction to install and adjust in order to get the best efficiency in the short time.

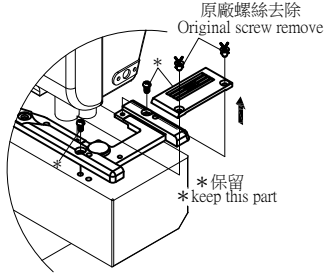
(一).安裝傳動裝置 Installation of Transmission



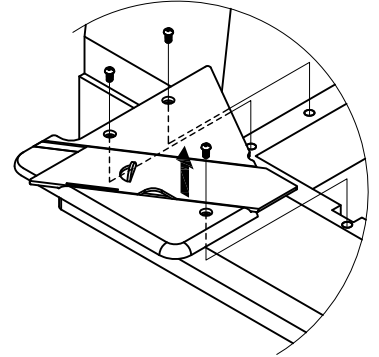
A. 如圖將原廠壓腳拆下。
Disassemble the original presser foot.



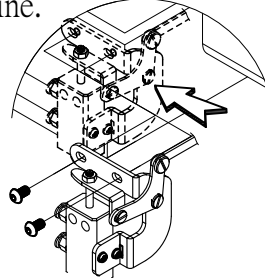
B. 如圖將針板座與原廠零件拆下。
Disassemble the needle plate bracket and original parts.



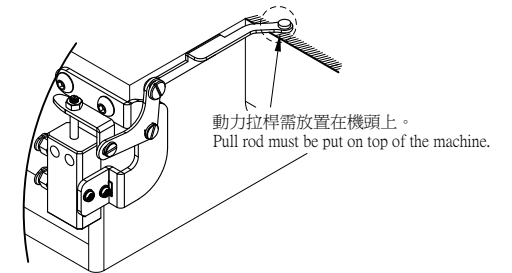
C. 將原有後蓋拆下。
Disassemble the original rear cover.



D. 將傳動座裝上機頭。
Install the transmission on the machine.

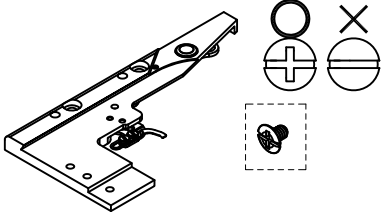


◎傳動裝置完成示意圖 Illustration of installed transmission

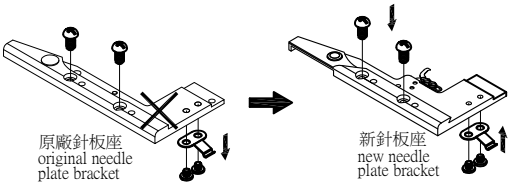


DINO 2

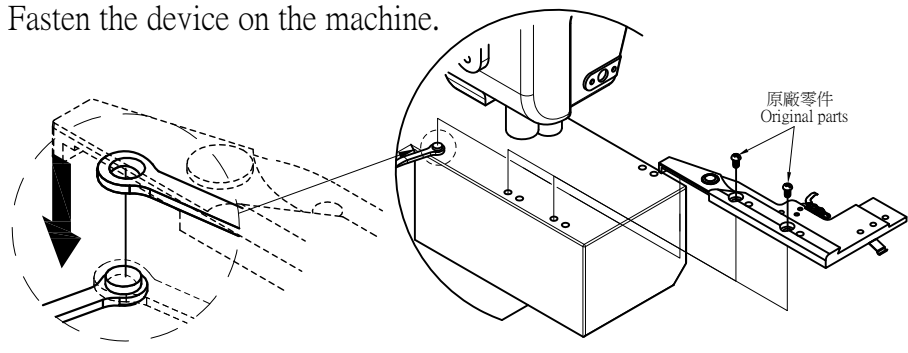
(二).安裝鎖線裝置 Installation of Stitchlock Device



A. 將原廠零件裝上鎖線裝置。
Install original parts on stitchlock device.

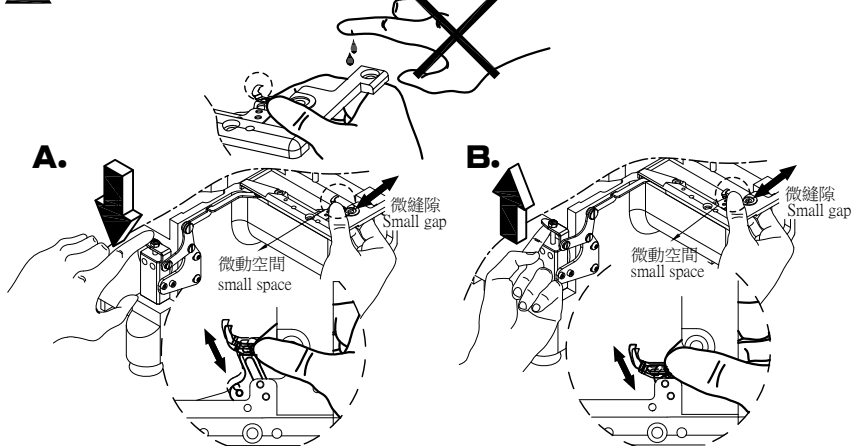


B. 將鎖線裝置鎖上機頭。
Fasten the device on the machine.



C. 檢測刀座有無晃動空間：
Inspection knife whether it can be movable :

⚠ 測試時，請小心刀頭鋒利。
Please be careful of the sharp blade during testing.



※刀座若無搖晃空間需重新校正。
※Notice: Please do well correction again if the knife is unmovable.

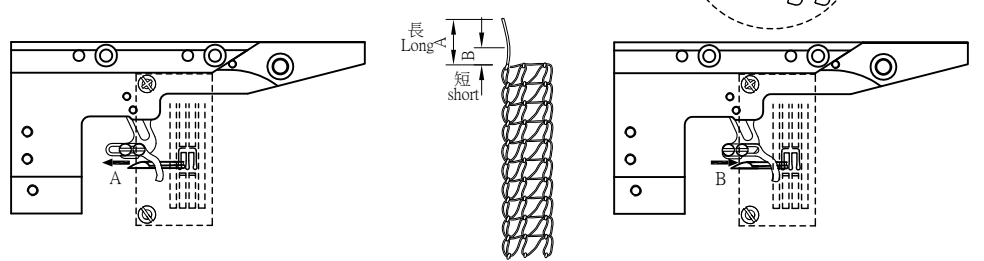
3 4

附錄：

1. 活動刀長條孔可調整，活動刀距離針越近，底線線頭越短，越遠則越長。

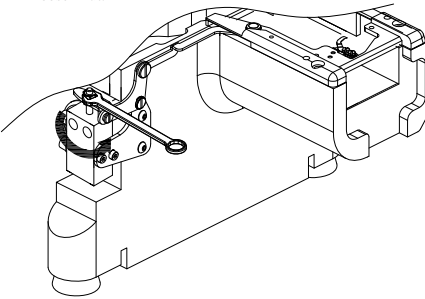
Appendix :

1. If the distance of movable knife is close to needle, the under remains thread will be shorter.

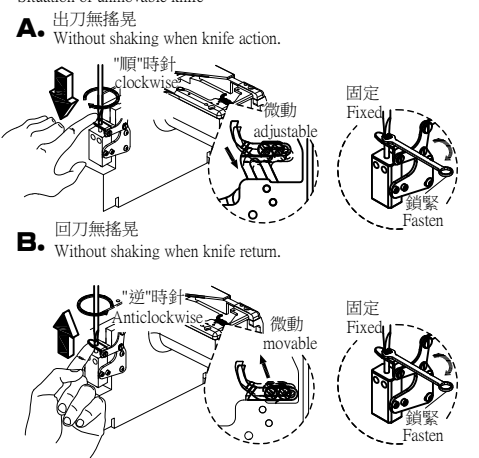


◎校正方法 Adjustment measure

1. 將螺帽轉鬆。
Loosen nut.



2. 若刀子無法晃動情況如下：
Situation of unmovable knife :

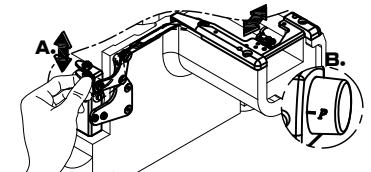


⚠故障排除 Trouble Shooting

◎車縫完成後，若無鎖線效果，請逐一檢查找尋問題點。
Please following steps for inspection once there is no stitchlock efficiency.

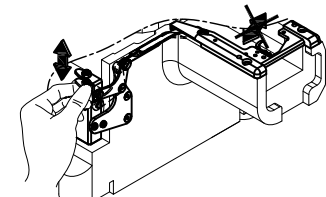
狀況一. Status one.

活動刀有動作，依步驟修正刀具。
A. The movable knife can move, and please following steps to correction knife.



狀況二. Status two.

活動刀無動作，依步驟檢查。
A. The movable knife can not move, and please following steps to inspection.

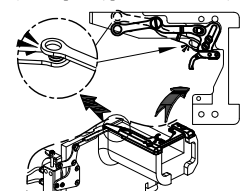


B. 轉至P點，並出刀檢查刀與彎針的關係。
B. Turn to P position and inspect knife and looper position.

1. 出刀後，底線必須在刀上方。
The knife have to be under threads during cutting.
2. 底線若是在刀片下方，將刀片向下折彎即可。
Notice: The knife can be bended down if the thread is under the blade 1~1.5mm

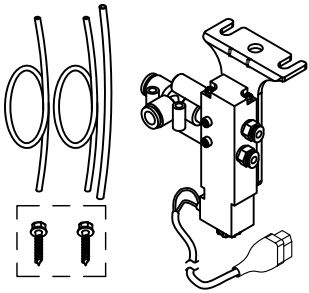
勿使用工具
Do NOT use tool.

B. 將針板座取下查看機構有無脫離。(若脫離將其裝回即可。)
Disassemble the needle plate bracket and inspect whether it is setting well. (If it separate, please set it back.)

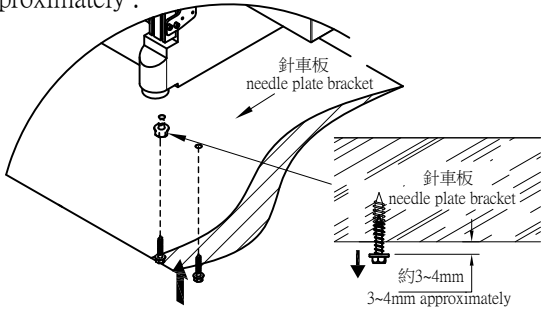


(三).安裝氣動裝置

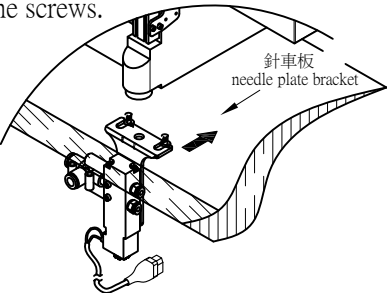
Installation of Pneumatic Device.



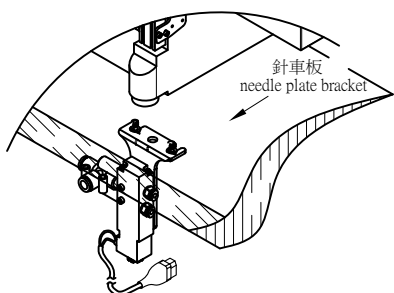
A. 把兩顆螺絲裝上，使螺絲與針車板保持約3~4mm。
Fasten two screws. The distance between screw and needle plate bracket is 3~4mm approximately.



B. 將氣動組裝上後，再將螺絲鎖緊。
B. Install pneumatic device and fasten the screws.



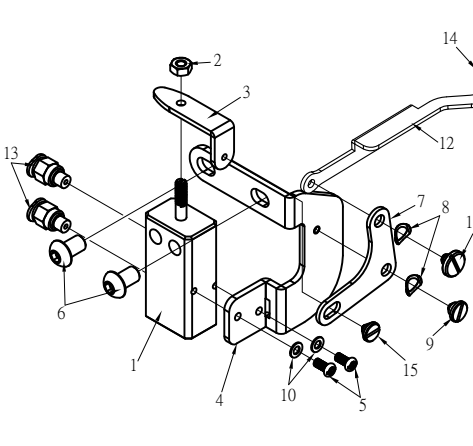
完成如圖。
Illustration of completed installation.



5

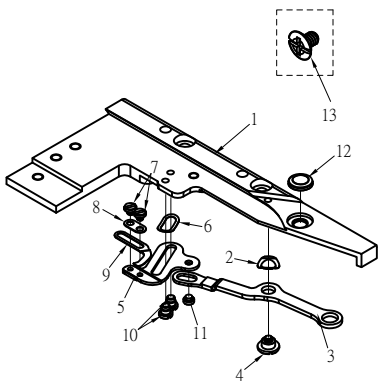
零件分析圖表
COMPONENT ANALYSIS CHART

W664-01/34、W1662-01/35傳動機構零件分析圖
The section of Transmission W664-01/34 and W1662-01/35



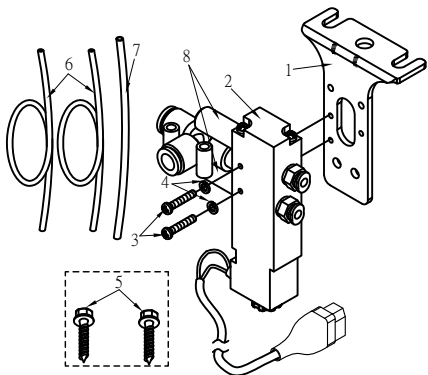
序號 Ref.No.	物料編號 Part. No.	名稱 Description	單位用量 Amt. Req.
1	CR-12	汽缸 Cylinder	- 1
2	SW0602	六角螺帽 Hex nut	M4 1
3	NLK-10	連桿 Lever	- 1
4	NLK-05	汽缸固定座 Bracket	- 1
5	SW0916	一般螺絲 Screw	M3x8 2
6	SW0215	半圓圓內六角螺絲 Semi-Round Inner Hex screw	M6x10 2
7	LKA-03-5	角度拉桿 Angle pull rod	- 1
8	LK-16	墊片 Washer	- 2
9	CB003-2-C	特殊螺絲 Special screw	M3 1
10	SW0701	盤形墊片 Oval washer	M3 2
11	CB003-3-B	特殊螺絲 Special screw	M4 1
12	NLK-04	動力拉桿 Power pull rod	- 1
13	VG2700A-DVC31	風管插頭 Plug of air tube	- 2
14	VC2700E-UT02-1	定位套環 Adjusting Ring	- 1
15	CB003-2-B	特殊螺絲 Special screw	M3 1

鎖線機構零件分析圖
The section of Stitchlock Device.



序號 Ref.No.	物料編號 Part. No.	名稱 Description	單位用量 Amt. Req.
1	NLK-W664-34	針板座 Needle plate	- 1
2	LK-16	墊圈 Washer	- 1
3	NLK-03	拉桿 Pull-rod	- 1
4	CB003-2-C	特製螺絲 Special screws	M3 1
5	NLK-02	活動刀座 Movable Knife Carrier	- 1
6	LK-29	墊圈 Washer	- 1
7	SW0801	一字頭螺絲 Flat head slot screw	3/32-56x2 2
8	LK-14	墊圈 Washer	- 1
9	NLK-01-B	活動刀 Movable knife	- 1
10	CB024	特製螺絲 Special screws	M3 2
11	VC2700E-UT16-2	定位套環 Adjusting Ring	- 1
12	NLK-09	橡膠 Rubber	- 1
13	CB033	盤頭螺絲 Plate head screws	M3 1

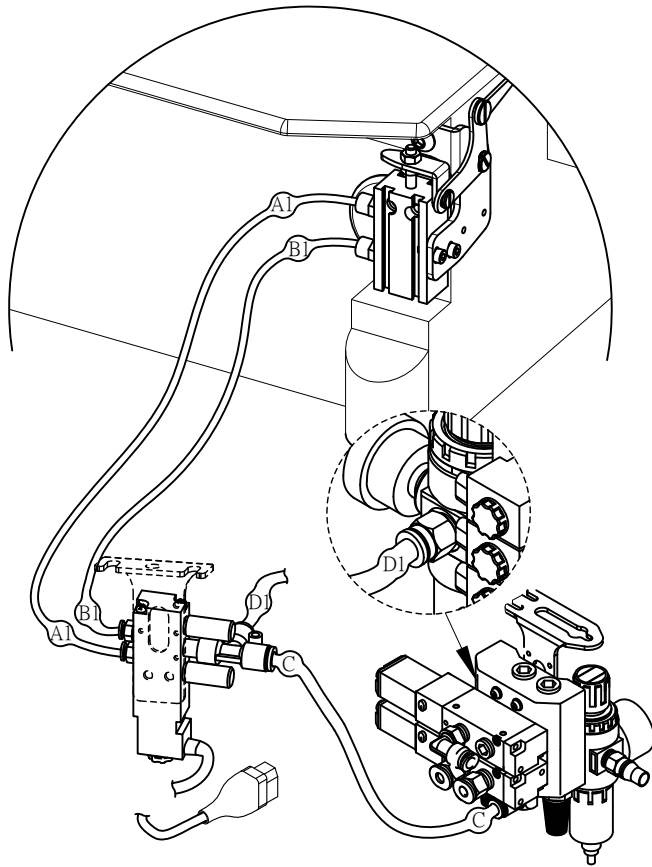
LKA-W1662氣動裝置零件分析圖
The Section of LKA-W1662 Pneumatic Device



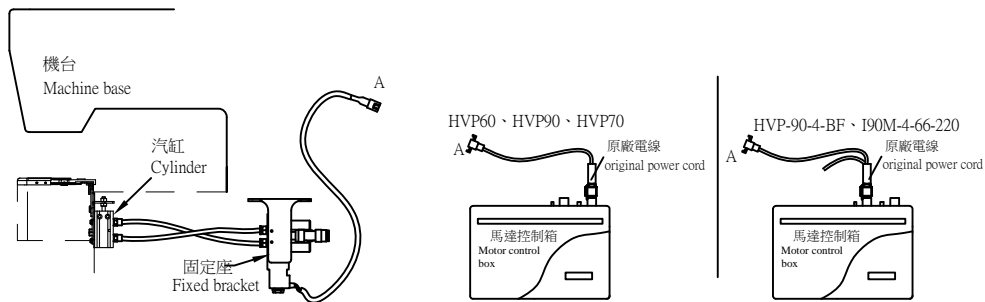
序號 Ref.No.	物料編號 Part. No.	名稱 Description	單位用量 Amt. Req.
1	VG2700A-DVC39	固定座 Bracket	- 1
2	EV-01	電池閥 Solenoid	- 1
3	SW0908	一般螺絲 Normal Screw	M3x25 2
4	SW0736	彈簧墊圈 Spring washer	M3 2
5	SW0909	六角頭木螺釘 Wooden Hex screw	10#x1 2
6	Tube-01-750	氣閥軟管 Valves hose	ø4,L=750mm 2
7	Tube-02-300	氣閥軟管 Valves hose	ø6,L=300mm 1
8	DVC-01	消音器 Silencer	- 2

汽缸氣壓管連接圖

The Connection of Air Tube.



6



馬達鎖線參數參考表：

賀欣馬達
鎖線功能參考表 (HVP60、HVP90、HVP70均相同)
參數 內容 設定
05 鎖線速度 4000
020 模式選擇 SU
021 鎖線選擇 ON
022 鎖線後針數 1
023 針數設定 0
027 段落停止時間 80
鎖線電源、控制箱 (OPTION) 15PIN端子，4及9孔位置。
HVP-90-4-BF、190M-4-66-220:
鎖線電源、控制箱 (OPTION) 12PIN端子，2及5孔位置。

Motor Parameters Table of Stitch-lock Device

Model : Ho Hsing Motor
Stitch-lock function reference table (applicable to HVP60, HVP90, and HVP70)
Parameter Content Setting
05 Stitch-lock speed 4000
020 Mode selection SU
021 Stitch-lock selection ON
022 Stitch count after stitch-lock 1
023 Stitch count setting 0
027 Stitch pause time 80
power of stitch-lock, control box (Option), 15 PIN plug, upon positions of 4th and 9th holes.
HVP-90-4-BF、190M-4-66-220:
power of stitch-lock, control box (Option), 12 PIN plug, upon positions of 2th and 5th holes.

永輝馬達 SV-520、SV-550

開啟鎖線裝置：
1. 車頭選項設定LK-0，開啟鎖線功能。
按(+) 電源 → 按一下() → 按() 選擇LK-0 →
長按() (燈號閃爍完成) → 重開電源 → 完成

ISM MOTOR SV-520, SV-550

Unlock stitch-lock device：
1. Set LK-0 at machine head when stitch-lock function required.
Press(+) + Power → Press once() → Press() Select LK-0 →
Long press() (Flash light is finished.) → Restart power → Finished

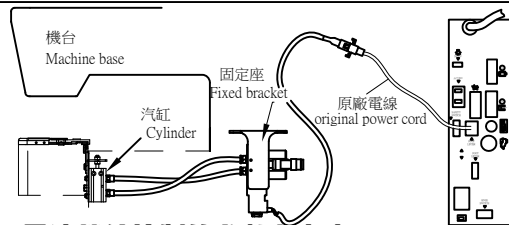
參數	內容	設定
10	鎖線後針數	0 (0為一針，1為兩針...)
156	鎖線裝置開或關	OFF / ON

※SV-550 控制箱參數 91 裡的數值設定 TL1

Parameter	Description	Setting
10	Stitches after stitch-lock	0 (0 for 1 stitch, 1 for 2 stitches)
156	Switch of stitch-lock device	OFF / ON

※Setting value TL1 of parameter 91 for SV-550 control box.

鎖線電源、控制箱 (OPTION) 12PIN端子，2及5孔位置。
power of stitch-lock, control box (Option), 12 PIN plug, upon positions of 2th and 5th holes.



S-380/KE521馬達鎖線控制箱參數參考表：

1. 按住 ↑ 鍵，開啟電源，顯示 A 1。
2. 在同時按 ↑ 跟 E 鍵，顯示 S ---。
3. 按 ▶ 鍵進入，顯示 C - 2 0 5，同時按 ↑ 跟 + 鍵至 C - 2 1 2。
4. 按 E 鍵開始恢復，完畢後顯示 P o F F。※恢復參數中請勿切斷電源！
5. 關閉電源。
6. 按住 ↑ 鍵，開啟電源，顯示 A 1。
7. 按住 + 鍵到 A 3 5
8. 按 ▶ 鍵進入 (返回)，更改為 4 0 0，按 E 鍵儲存。
A35 = 400
A127 = 2 (鎖線針數)
A128 = 0 (鎖線入刀角度)
A129 = 180 (鎖線動作時間)
重開電源即可正常使用。

S-380/KE521 Motor Parameters Table of Stitch-lock control box:

1. Press ↑, turn on power, show A 1.
2. Press at the same time ↑ and E, show S ---.
3. Press ▶ enter, show C - 2 0 5, press at the same time ↑ and + into C - 2 1 2.
4. Press E to recover, show P o F F after finished. Noticed: Please do not turn off power during recover parameter setting.
5. Turn off power.
6. Press ↑, turn on power, show A 1.
7. Press + into A 3 5.
8. Press ▶ into (return), Revise 4 0 0, press E to save.
A35 = 400
A127 = 2 (Stitch-lock stitches)
A128 = 0 (Stitch-lock angle)
A129 = 180 (Stitch-lock action time)
Restart power to be finished.