

金輪牌工業用縫紉機

GOLDEN WHEEL INDUSTRIAL SEWING MACHINE

CS-8810 系列

Basic Operation Manual

使用說明書

△ 2020.10.29 P12



CS-8820 系列

Basic Operation Manual

使用說明書



啟翔股份有限公司

CHEE SIANG INDUSTRIAL CO., LTD.

IMPORTANT SAFETY INSTRUCTIONS 重要安全事項

1. All safety devices must in position when the machine is ready for work. Operation without the specified safety devices is not allowed.
 2. This machine should be operated by appropriately trained operators.
 3. Wear safety glasses when operating this machine.
 4. Under following circumstances turn off the power switch or disconnect the power plug of the machine from the receptacle.
 - 4-1 Threading needle(s) or replacing bobbin(s).
 - 4-2 Replacing needle(s), throat plate, hook(s) or presser roller etc.
 - 4-3 Maintaining, adjusting, or repairing.
 - 4-4 Leaving the working place.
 5. Do not tampering live parts or devices, regardless of whether the machine is powered.
 6. Repair and adjustment works should only be done by appropriately trained technicians.
 7. Periodically clean and lubricate the machine throughout the time in use.
 8. The power plug should be attached to the machine by electric technicians. The power plug has to be connected to a grounded receptacle.
 9. This machine is only allowed to be used for the purpose intended. Other uses are prohibited.
 10. Modifying or remodeling the machine should be made in accordance with the safety regulations and should apply effective safety measures.
 11. Before starting the machine check that the voltage given on the motor specification plate corresponds with the mains voltage (shown on the mains meter).

If the voltages do not correspond, do not under any circumstances start the machine.
 12. When using clutch motor, please wait for the motor stops completely before threading or replacing parts.
1. 使用此縫紉機之前，所有的安全裝置應安裝到規定的位置。沒有安裝規定的安全裝置禁止使用。
 2. 此縫紉機應由接受過培訓的操作人員來操作。
 3. 操作縫紉機時，應戴安全防護眼鏡。
 4. 發生下列情況時，應立即關掉電源開關，或拔下電源線插頭。
 - 4-1 穿線或更換梭子時。
 - 4-2 更換機針、針板、旋梭、輪錢等零件時。
 - 4-3 保養、調整或修理時。
 - 4-4 離開工作場所時。
 5. 靜止用手觸摸縫紉機通電的零件或裝置，不論電源開關是否打開。
 6. 縫紉機的修理或調整應由受過專門訓練的技術人員來進行。
 7. 縫紉機的使用期間應定期清掃及潤滑。
 8. 電源插頭應由具專門知識的技術人員來安裝。電源插頭必須連接到接地插座上。
 9. 縫紉機指定用途以外不得使用。
 10. 對縫紉機的變更或改造應符合安全規定，並採取有效的安全措施。
 11. 機器啟動前須先檢視馬達規格表上所列電壓與工作場所的電壓是否相符，電壓不一致時請勿開動機器。
 12. 使用離合馬達時，請等待馬達完全停止之後再進行穿線或更換零件等工作。

CONTENTS 目錄

一.	SPECIFICATIONS 規格	1
二.	INSTALLATION 安裝	3
	1. Drawing of the Table 車板圖	3
	2. Installation of Safety Switch 安全開關裝置位置示意圖	4
	3. Installing of the Thread Stand 線架安裝	5
	4. Installing the Bobbin Thread Winder 捲線器安裝	5
三.	PREPARATION AND OPERATION 準備和運轉	6
	1. Lubrication Oil 加油潤滑	6
	2. Inserting the Needle 機針的安裝方法	6
	3. Threading the Needle 穿線方法	7
	4. Threading the Bobbin Case 梭子拉線方法	7
	5. Inserting The Bobbin Case 梭殼安裝	8
	6. Drawing up the Bobbin Threads 底線的拉出整理	8
四.	STANDARD ADJUSTMENT 維修與調整	9
	1. Thread Tension 線跡的調整	9
	Thread Tension 線張力的正確	9
	1). Regulating the Needle Thread Tension 上線張力的調整	9
	2). Regulating the Bobbin Thread Tension 底線張力的調整	9
	2. Regulating the Roller Presser Pressure 輪錢壓力的調整	10
	3. Stitch Length Regulation 縫目長度調整	10
	4. Adjusting the Height of Feed Wheel 送料齒高度的調整	10
	1). Single Needle Type 單針系列	10
	2). Two Needle Type 雙針系列	11
	5. Adjusting Height of Hook 調整旋梭高度	11
	6. Re-engage Safety Clutch 卡線离合器的復歸	12
五.	TROUBLESHOOTING 故障檢修	13

一. SPECIFICATIONS 規格

CS-8810、8820 系列產品規格			
No.	Item 項目	8810 系列(單針)	8820 系列(雙針)
1	Model 型式	Single Needle Type 單針本縫	Two Needle Type 雙針本縫
2	Use 用途	Shoes, Leather Goods 鞋類，皮革類製品	
3	Max. Sewing Speed 最高縫製速度 (SPM)	2500	
4	Max. Stitch Length 最大縫目 (mm)	7	4
5	Needle 使用車針	DPx5#16	DPx5#16x2
6	Needle Bar Stroke 針棒行程	41	41
7	Presser Foot Height 押腳提升量(mm)	15	
8	Feed 送料裝置	Roller Presser and Feed Wheel 輪錢加下送料輪	Roller Presser and Feed Wheel and Presser Foot 輪錢加下送料輪加押腳
9	Applying Grease 潤滑方式	Manual Lubrication 手動給油	
10	Winding a Bobbin (Without Direct Drive) 底線捲線(無直驅) Winding a Bobbin (Direct Drive) 底線捲線(直驅)	Belt Drive 皮帶驅動方式 Upper Shaft Drive 上軸驅動方式	
11	Motor (Without Direct Drive) 馬達(無直驅) Motor (Direct Drive) 馬達(直驅)	Clutch Motor 370W 離合器馬達 370W Direct Drive Motor 600W 直驅馬達 600W	
12	Supply Voltage 電源電壓	Single-Phase:220V 單相:220V	

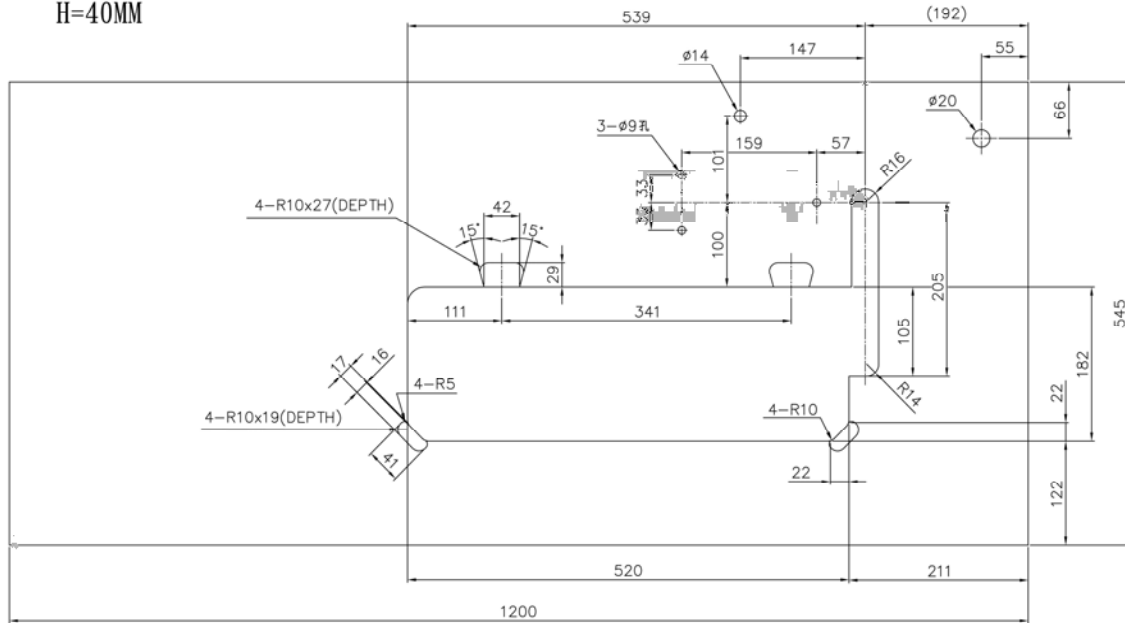
CSA-8810、8820 系列總表

No	Type 機型	Direct Drive 直驅	Large Hook 大釜	Heavy Materials 厚物	加長型
1	CS-8810				
2	CS-8810D	○			
3	CS-8810G		○		
4	CS-8810H			○	
5	CS-8810L				○
6	CS-8810DG	○	○		
7	CS-8810HG		○	○	
8	CS-8820				
9	CS-8820D	○			
10	CS-8820G		○		
11	CS-8820H			○	
12	CS-8820L				○
13	CS-8820DG	○	○		
14	CS-8820HG		○	○	

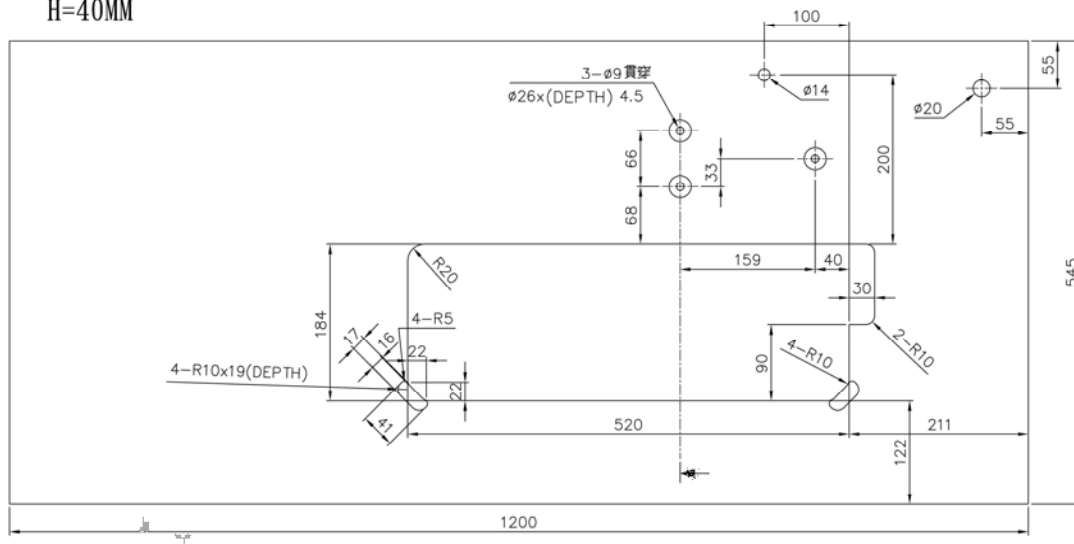
二. INSTALLATION 安裝

1. Drawing of the Table 車板圖

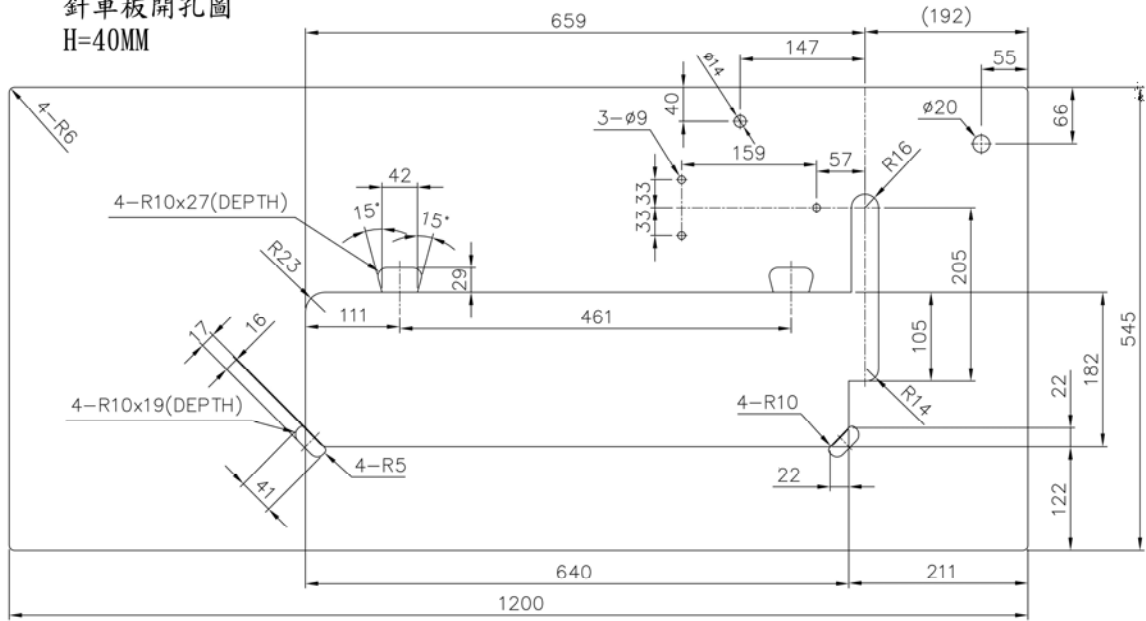
CS-8810 系列
 SKETCH OF TABLE HOLE
 針車板開孔圖
 H=40MM



CS-8810D (直驅) 系列
 SKETCH OF TABLE HOLE
 針車板開孔圖
 H=40MM

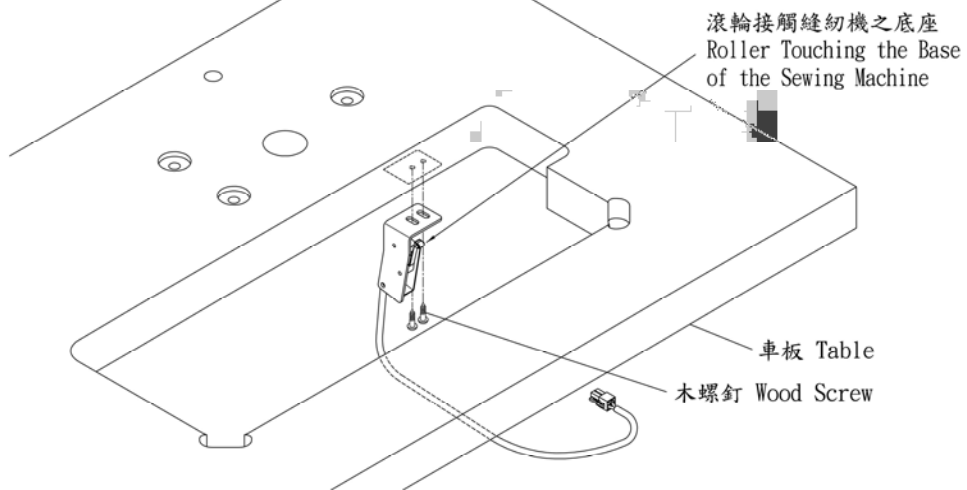


CS-8810L (加長型) 系列
 SKETCH OF TABLE HOLE
 針車板開孔圖
 H=40MM

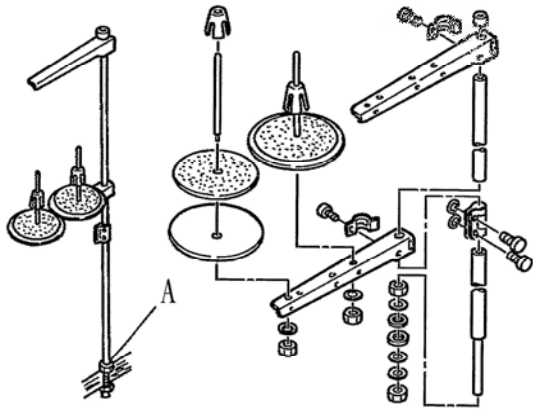


2. Installation of Safety Switch 安全開關裝置位置示意圖

CS-8810D
 安全開關裝置位置示意圖
 Installation of Safety Switch



3. Installation of the Thread Stand 線架安裝



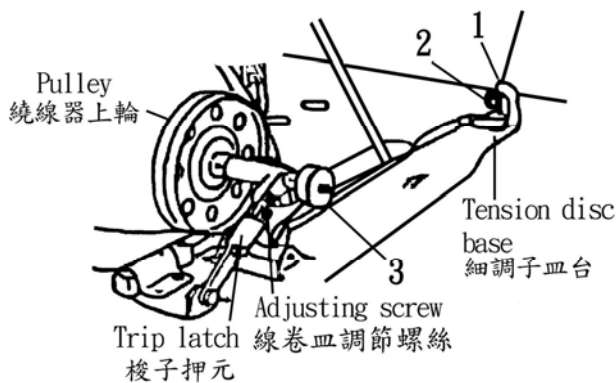
1) Assemble the thread stand and set it to the hole of the table.

2) Tighten locknut (A) to fix the thread stand.

1) 請組裝線架裝置，然後在安裝到台板的孔上。

2) 擰緊固定螺母(A)，不讓線架裝置鬆動。

4. Winding the Bobbin Thread 捲線器安裝



Fasten the bobbin winder base with wood screws where the bobbin winding wheel contacts correctly with belt. Pass thread in the order from 1 to 3 and wind the thread around the bobbin a few turns.

When the thread is wound unevenly on the bobbin, adjust it by sliding the thread tension disc base the left or right. Adjust to bobbin winder adjusting screw so that the thread is wound around the bobbin by about 80%.

捲線器上的飛輪對準皮帶，並用木螺絲將捲線器固定，按照如圖所示 1~3 的順序穿線並繞一線在梭子上，如果梭子繞線不均，調整線調子皿台左右移動即可，梭子繞線量多寡由線卷量調節螺絲調整。

三. PREPARATION AND OPERATION 準備和運轉

1. Lubrication Oil 加油潤滑

Clean the machine thoroughly at least once a week.

- 1). The sewing hook and its vicinity should be cleaned every day. Apply one or two drops of oil to the sewing hook (oil hole in hook gibe).
- 2). The needle bar (above and below the needle bar bushing) must be oiled once a week.
The following parts should be oiled once every two weeks: bobbin case opener (oil felt accessible under hook when take-up lever is raised), top and bottom ball joints of feed driving mechanism (felt washer at the back of the ball joints).

每星期定期清潔機頭。

- 1). 大釜及其周邊位置每天清潔，滴 1~2 滴油至大釜油孔。
- 2). 針棒套管上下端每星期加一次油。
牛角組、送料帶動部位每兩星期加一次油。

2. Inserting the Needle 機針的安裝方法

Use System 134 or DPx5 needles.

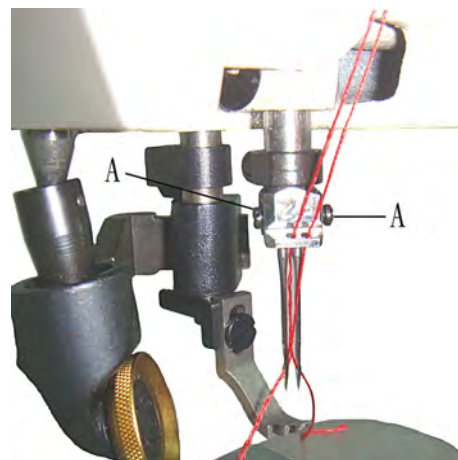
The needle size depends on the machine type and the material to be sewn.

Raise the roller presser, pull it downwards a little and swing it out to the left. Loosen needle set screws A and insert the needles, pushing them up as far as they will go. The long groove of the needle should face towards to the left. Tighten needle set screw (A) and return the roller presser to its original position.

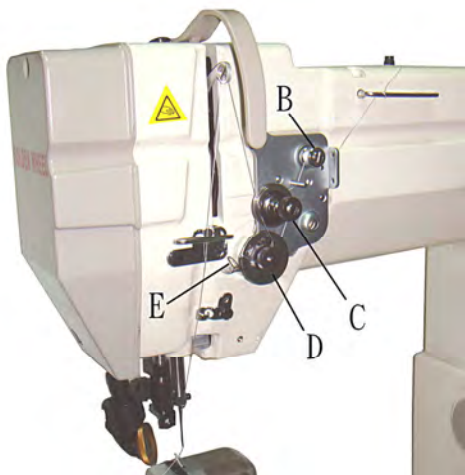
CS-8820: The long groove of the left needle should face towards to the right and that of the right needle towards to the left.

使用 134 或 DPx5 規格的針，針的規格視機器種類及縫製物種類不同而定。

使輪錢提升稍壓一下輪錢座將輪錢朝左扳開，鬆開鎖針螺絲(A)，將針插入，使其插至盡頭針長溝槽面朝左(單針)，將螺絲(A)鎖緊，輪錢回歸原位，雙針 CS-8820 的針長溝槽面，左方的針朝右，右方的針朝左。



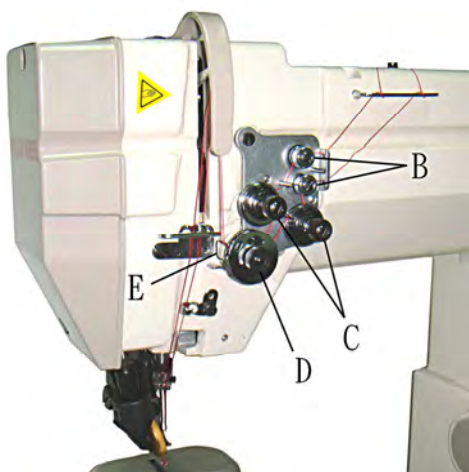
3. Threading the Needle 穿線方法



CS-8810: Thread the needle as shown in the illustration. Make sure that the thread is passed through thread retainer (B), counterclockwise around and between the discs of thread tension (C), clockwise around and between thread controller discs (D), below thread check spring (E), and up to the take-up lever. Thread the needle from left to right.

CS-8810: 穿線方法

線穿過沙拉組的(B)處，反時鐘方向纏繞過(C)在順時鐘方向繞過(D)，穿過調線彈簧(E)再穿過天秤即是。線從針的左方朝右穿過。



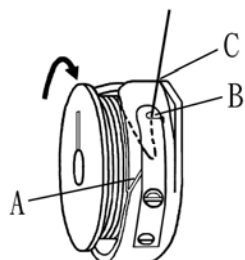
CS-8820: Thread the needles, as illustrated to make sure both threads are passed through thread retainer (B), counterclockwise around and between the discs of the left tension (C) and clockwise around and between the discs of the right tension (C), clockwise around and between thread controller discs (D), below thread check spring (E), and up to the take-up lever.

Thread the left needle from the right, and the right needle from the left.

CS-8820: 穿線方法

2 條線分別穿過沙拉組的(B)處，反時鐘方向繞過左方的(C)處，順時鐘方向繞過右方的(C)處順時鐘方向繞過(D)處，再穿過調線彈簧(E)處及穿過天秤。左針的線從右方穿過，右針的線從左方穿過。

4. Threading the Bobbin case 梭子拉線方法



First open the post cap(s), lift up latch L and take out the bobbin case. Insert a full bobbin in the bobbin case and thread it as shown. Hold the bobbin and pull the thread into slot 1 and under the tension spring until it emerges at its rear tip (B). Now draw the thread into slot (C) in the projecting flange. When you pull the thread, the bobbin should turn in the direction indicated by the arrow.

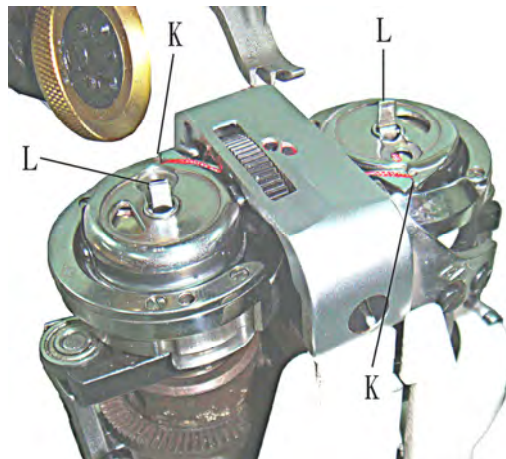
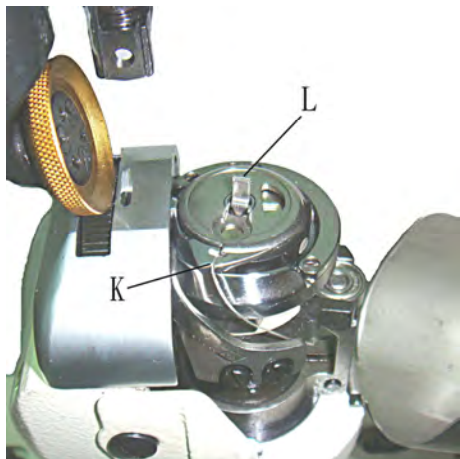
打開釜蓋，將釜栓扳起，取出梭殼，將纏滿線的梭子裝入梭殼，並將底線按圖所示順序穿出來，握住梭子將線拉出穿過溝槽(A)處，繞過夾線片，線從控制底線鬆緊的夾線片後面尖端出現，線勾過溝槽(C)在突出的凸緣上拉線時，梭子轉動方向如所示箭頭方向。

5. Inserting the Bobbin Case 梭殼安裝

Insert the bobbin case with the full bobbin into the right or left sewing hook, and close latch (L), making sure the bobbin thread is positioned in slot (K).

Then close the respective post cap.

將已裝好梭子的梭殼放入大釜中，將釜栓(L)按下，檢視底線是否確實自溝槽(K)處拉出，將釜蓋復回原位。



6. Drawing up the Bobbin Threads 底線的拉出整理

Hold the end of the right or left needle thread and turn the balance wheel in sewing direction until the respective bobbin thread comes up through the needle hole in a loop. Draw the bobbin thread(s) out of the needle hole. Lay the needle and bobbin threads back under the presser foot.

握住上線的底端，轉動車頭飛輪直到下線從針孔穿出成一圈，將下線從針孔拉出放下針，底線拉至押腳後方下端。



四. STANDARD ADJUSTMENT 維修與調整

1. Thread Tension 線跡的調整



Regulate both tensions so that the threads interlock in the center of the material and the stitches are tightly set.

調整上、下線張力使其在縫製物上的縫目緊密連結為正確張力。



Upper tension too weak or lower tension too tight.

如左圖所示，上線張力太弱，下線張力太緊。



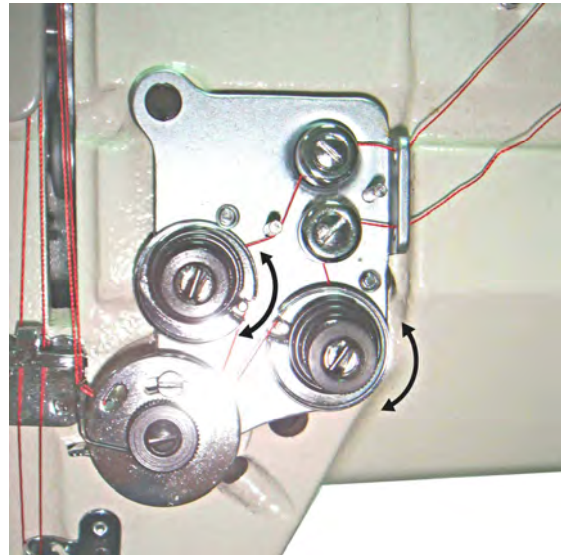
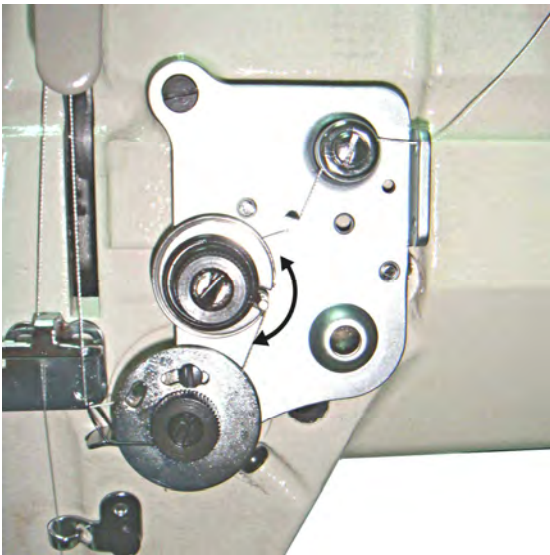
Upper tension too tight or lower tension too weak.

如左圖所示，上線張力太緊，下線張力太鬆。

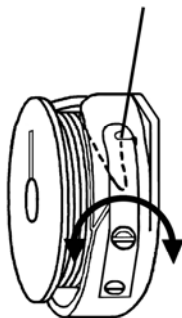
1). Regulating the needle thread tension 上線張力的調整

Turn thumb nut clockwise for a tighter tension, or counterclockwise for a weaker tension.

轉動螺母，順時鐘方向，張力變緊，反時鐘方向，張力變鬆。



2). Regulating the bobbin thread tension 底線張力的調整



Turn the screw clockwise for a tighter tension, or counter-clockwise for a weaker tension.

轉動如圖所示螺絲，順時鐘方向旋轉，張力變緊，反時鐘方向，張力變鬆。

2. Regulating the Roller Presser Pressure 輪錢壓力的調整



Regulate the pressure of the roller presser so that the work piece is fed perfectly and is not damaged by the teeth of the feed wheel. Turn the screw clockwise to increase the roller presser pressure. Turn the screw counter-clockwise to reduce the roller presser pressure.

調整輪錢壓力以使縫製件送料順利，並且不被送料齒輪所傷，轉動如圖所示螺絲，順時針方向即增加輪錢壓力，逆時針方向即減輕輪錢壓力。

3. Stitch Length Regulation 縫目長度調整



Press the push button on the bed top (see black arrow), at the same time turning the balance wheel until you feel the push button snap in place. Keep the button depressed and turn the balance wheel forward or backward until the number denoting the desired stitch length is opposite the mark on the belt guard (see white arrow).

壓下如圖黑色箭頭所示按鈕，同時轉動車頭飛輪直到你感覺到按鈕已在適當位置咬合，繼續按住按鈕，並使車頭飛輪前、後轉動直到所要的縫目長度顯示在皮帶蓋旁數字輪上的記號(白色箭頭所示)。

4. Adjusting the Height of Feed Wheel 送料齒高度的調整

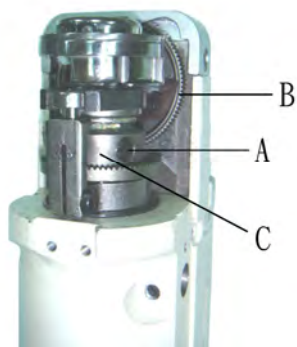
1). Single Needle Type 單針系列



Turn the eccentric pin (A) and then move up or down to adjust the height of feed wheel, clockwise for up, counterclockwise for down.

轉動偏心銷(A)，即可調整送料齒高度，順時鐘向上，逆時鐘向下。

2). Two Needle Type 雙針系列



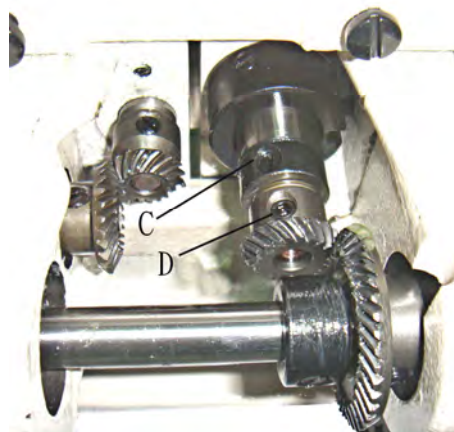
Loosen the screw (A) and (B) and then move gear (C) up or down to adjust the height of wheel feed.

將螺絲(A)和(B)旋鬆，上下移動齒輪(C)即可調整送料齒高度。

5. Adjust Height of Hook 調整旋梭高度

Set the height of the hook to allow the needle thread to go through the gap between the bobbin case stop and the niche beneath the needle plate, while maintaining the bobbin case stop remained in the niche when the hook rotates either forward or backward. Loosen the set screw (A) of eccentric pin (B), and screw (C) of collar, and screw (D) of bevel gear to turn the eccentric pin (B) in order to adjust the height of hook and the bushing simultaneously.

調整旋梭的高度以使針線可通過內釜止與針板下方凹槽之間間隙，並在旋梭正轉或逆轉時使內釜止不致脫離針板下方凹槽。鬆開偏心銷(B)的固定螺絲(A)，固定環的固定螺絲(C)，以及傘齒輪的固定螺絲(D)，轉動偏心銷(B)以便調整旋梭與套管的整體高度。



⚠ 6. Re-engage Safety Clutch 卡線離合器的復歸

When the hook is jammed with thread, the lower shaft may encounter excessive torque and trigger the safety clutch to disengage. In this case, please remove the jammed thread first and follow the steps below to re-engage the clutch.

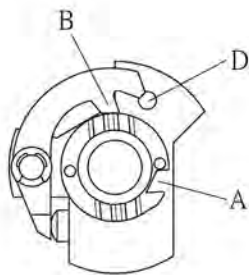
當旋梭卡線時，下軸的扭力負荷過大會導致卡線離合器脫離。此時請先清理旋梭內的殘線，再依照以下步驟將卡線離合器復歸

1). Rotate the coupling ring to align its notch (A) with the claw (B) of the lever. (You may insert a hex wrench into the setscrew (C) to turn the left section of lower shaft while keeping the right section of lower shaft stationary by holding the hand wheel.)

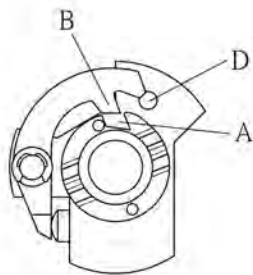
2). Using a tool to push the stop pin (D) and force it to retract back to the hole so the claw (B) will snap into the notch (A) automatically.

1). 轉動聯軸器使其凹槽(A)對準槓桿端的勾爪(B)。(可利用一六角扳手插入固定螺絲(C)來轉動下軸的左側段，並握住手輪使下軸的右側段保持不動)

2). 使用一工具將擋銷(D)壓入縮回孔內，勾爪(B)即可自動卡入凹槽(A)



Not Aligned 無對準



Aligned 對準







五. TROUBLESHOOTING 故障檢修


·Please check the following points before calling for repairs or service.

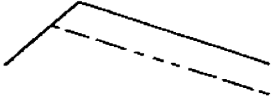

·If the following remedies do not fix the problem, turn off the power switch and consult a qualified technician or the place of purchase.

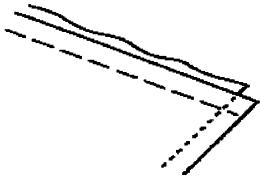


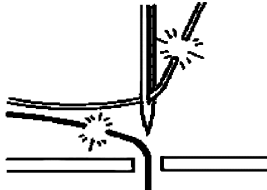
·請你在要求維修或服務前，先檢查以下各點。

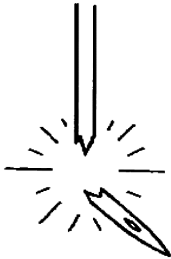
·如果以下方法仍然不能解決問題，向受過訓練的技術人員或經銷商諮詢。

	Problem / 現象	Possible cause / 檢查及調整
1	Upper thread not tight. 面線不夠緊密 	<ul style="list-style-type: none"> ·Is the upper thread tension too weak, or is the lower thread tension too strong? Adjust the upper thread tension or lower thread tension. ·Is the needle and feed timing correct? Advance the needle timing. ·面線張力是否過小，或底線張力是否過大? 調節面線張力或底線張力。 ·機針和送布的同步是否正合適? 請將機針的時序調早些。
2	Lower thread is not tight 底線不夠緊密 	<ul style="list-style-type: none"> ·Is the lower thread tension too weak, or is the upper thread tension too strong? Adjust the lower thread tension or upper thread tension. ·底線張力是否過小，或面線張力是否過大? 調節底線張力或面線張力。
3	Loops appear in seam 布料下出現環結等 不良 	<ul style="list-style-type: none"> ·Is the thread path not smooth enough? Use a file with a fine grain or sandpaper to polish smooth the thread path. ·Is the bobbin not turning smoothly? Pull out the lower thread to check that there is no slackness in the thread tension, or replace the bobbin or bobbin case. ·線路是否不夠光滑? 用細粒銼刀或砂紙將線路打磨光滑。 ·梭芯是否旋轉流暢? 拉出底線檢查基線張力是否鬆弛，或更換梭芯或梭芯套。
4	Skipped stitches occur while sewing 縫紉時出現跳針 	<ul style="list-style-type: none"> ·Is the needle tip bent? Is the needle tip blunt? If the needle tip is bent or broken, replace the needle. ·Is the needle properly installed? If it is incorrect, install the needle correctly. ·Is the machine properly threaded? If it is incorrect, thread the thread correctly. ·Is the presser foot pressure too weak? Adjust the presser foot pressure. ·Is the needle too thin? Replace the needle with a needle that is one rank thicker. ·Is the presser foot too height? Adjust the height of the presser foot. ·Is the thread take-up spring too weak? Adjust the tension of the thread take-up spring. ·Is the needle and rotary hook timing correct? Adjust the height of the needle bar. Adjust the clearance between the needle and the tip of the rotary hook.

		<ul style="list-style-type: none"> ·針尖是否彎曲?針尖是否鈍化? 如果針尖彎曲或斷裂，應予以更換。 ·機針是否安裝正確? 如果機針安裝不正確，應正確加以安裝。 ·縫紉機線是否穿引正確? 如果穿引不正確，應正確穿引機線。 ·壓腳壓力是否過小? 請調整壓腳壓力。 ·機針是否太細? 更換大一號的機針。 ·壓腳是否太高? 調整壓腳高度。 ·挑線簧是否太弱? 調整挑線簧的張力。 ·機針和旋梭的同步是否正合適? 請調整針桿的高度。 請調整機針與旋梭尖之間的間隙。
5	<p>Skipped stitches at sewing start Thread unraveling at sewing start 縫紉開始時出現跳針 縫紉開始時出現脫線</p> 	<ul style="list-style-type: none"> ·Is the thread rake-up spring tension too strong? Reduce the tension of the thread take-up spring. ·Is the thread take-up spring operating range too large? Lower the position of the thread take-up spring. ·Are the trailing lengths of the upper threads too short after thread trimming? Adjust the pretension. ·Are the threads not being trimmed cleanly? Sharpen the fixed knives, or replace the fixed and movable knives if necessary. ·Is the needle too wide? Try using a needle with a count that is one lower than the current needle. ·Is the length of thread trailing out from the bobbin case after thread trimming too short? If the bobbin is spinning loosely, replace the anti-spin spring in the bobbin case. ·Is the sewing speed too fast at the sewing start? Use the slow start feature. ·Is the needle up stop position too high? Adjust the needle up stop position. ·挑線簧張力是否過大? 減少挑線簧張力。 ·挑線簧工作範圍是否過大? 降低挑線簧的位置。 ·剪線後，面線殘留量是否過短? 調整張力。 ·機線是否剪切不齊整? 將定刀磨快，或視需要更換定刀和動力。 ·機針是否過粗? 使用比現有機針小一號的機針。 ·剪線後，梭芯套拖出的底線是否過短?

		<p>如果梭芯發生空轉，更換梭芯套中的旋梭空轉防止簧。</p> <ul style="list-style-type: none"> ·縫紉開始時，縫紉速度是否過快？ 使用慢起動功能。 ·針上停止位置是否過高？ 請調整針上停止位置。
6	<p>Uneven seam 線縫不平整</p> 	<ul style="list-style-type: none"> ·Is the presser foot pressure too weak? Adjust the presser foot presser. ·Is the feed dog too low? Adjust the feed dog height. ·Is the bobbin scratched? If the bobbin is damaged, smooth it with an oiled grindstone or replace it. ·壓腳壓力是否過小？ 調整壓腳壓力。 ·送布牙高度是否太低？ 調整送布牙高度。 ·梭芯是否有刮痕？ 如果梭芯受損，用油磨石打磨光滑，或予以更換。
7	<p>Large degree of puckering (excess tension) 大量的縐褶（張力過大）</p> 	<ul style="list-style-type: none"> ·Is the upper thread tension too strong? Make the upper thread tension as weak as possible. ·Is the lower thread tension too strong? Make the lower thread tension as weak as possible. ·Is the needle tip blunt? Replace the needle if it is blunt. ·Is the needle too thick? Replace with as thin a needle as possible. ·Are the thread take-up spring tensions too strong? Make the thread take-up spring tension as weak as possible. ·Is the thread take-up spring operating range too large? Lower the position of the thread take-up spring to as low a position as possible. ·Is the presser foot pressure too strong? Adjust the presser foot pressure. ·Is the sewing speed too fast? Use the sewing speed control keys to gradually reduce the sewing speed. ·Is the angle of the feed dog correct? Tilt the front of the feed dog down slightly. ·面線張力是否過大？ 盡量減少面線張力。 ·底線張力是否過大？ 盡量減少底線張力。 ·針尖是否鈍化？ 如果針尖鈍化了，請予以更換。 ·機針是否過粗？ 儘可能更換細一些的機針。 ·挑線簧張力是否過大？ 盡量減少挑線簧張力。 ·挑線簧工作範圍是否過大？ 盡量降低挑線簧的位置。

		<ul style="list-style-type: none"> ·壓腳壓力是否過大? 調整壓腳壓力。 ·縫紉速度是否過快? 使用縫紉速度控制鍵逐漸減低縫紉速度。 ·送布牙的傾斜度是否恰當? 請稍稍降低送布牙的前端。
8	<p>Material slippage 線縫不合</p> 	<ul style="list-style-type: none"> ·Is the presser foot pressure too strong? Adjust the presser foot pressure. ·壓腳壓力是否過大? 調整壓腳壓力。
9	<p>Lower thread is tangled at the sewing start. Spinning of bobbin during thread trimming. 在縫紉開始時底線糾結纏繞 剪線時梭芯空轉</p> 	<ul style="list-style-type: none"> ·Is the bobbin spinning direction correct when the lower thread is being pulled? Set the bobbin so that it turns in the opposite direction to the rotary hook. ·Is there too much thread wound onto the bobbin? The bobbin winding amount should not be more than 80%. ·Is the anti-spin spring attached? Attach the anti-spin spring. ·Is the bobbin turning smoothly? If the bobbin is not turning smoothly, replace the bobbin. ·Is a bobbin other than the light-alloy bobbins specified by Golden Wheel being used? Use only bobbins which are specified by Golden Wheel. ·拉出底線時，梭芯旋轉方向是否正確? 安裝梭芯，使其朝旋梭相反的方向旋轉。 ·梭芯上卷線的線量是否過多? 梭芯卷線量不應超過 80%。 ·是否已加裝旋梭空轉防止簧? 加裝旋梭空轉防止簧。 ·梭芯轉動是否流暢? 如果梭芯轉動不流暢，應更換梭芯。 ·是否使用除 Golden Wheel 規定的輕合金梭芯以外的其他梭芯? 僅使用 Golden Wheel 規定的梭芯。 
10	<p>Upper and lower threads are breading. 面線和底線斷線</p> 	<ul style="list-style-type: none"> ·Is the needle bent or is the needle tip broken? Replace the needle if it is bent or broken. ·Is the needle properly installed? If it is incorrect, install the needle correctly. ·Is the machine properly threaded? If it is incorrect, thread the thread correctly. ·Is the upper or lower thread tension too weak or too strong? Adjust the upper thread or lower thread tension. ·Is the upper thread may be loose because the thread take-up spring operating range is too small? Adjust the position of the thread take-up spring. ·Is the rotary hook, feed dog or other part damaged? If they are damaged, smooth them with an oiled grindstone or replace the damaged parts.

		<ul style="list-style-type: none"> ·Is the thread path damaged? If the thread path is damaged, smooth it with sandpaper or replace the damaged part. ·針尖是否彎曲？針尖是否鈍化？ 如果針尖彎曲或斷裂，應予以更換。 ·機針是否安裝正確？ 如果針尖安裝不正確，應正確加以安裝。 ·縫紉機線是否穿引正確？ 如果穿引不正確，應正確穿引機線。 ·面線或底線張力是否過小或過大？ 調整面線或底線張力。 ·面線是否因挑線簧工作範圍太小而鬆動？ 調整挑線簧的位置。 ·旋梭、送布牙或其他零部件是否受損？ 如果這些零部件受損，用油磨石打磨光滑，或更換受損的零部件。 ·線路是否受損？ 如果線路受損，用砂紙打磨光滑或更換受損零部件。
11	<p>Broken needles 斷針</p> 	<ul style="list-style-type: none"> ·Is the material being pushed or pulled with excessive force during sewing? ·Is the needle properly installed? If it is incorrect, install the needle correctly. ·Is the needle bent, is the needle tip broken, or is the needle hole blocked? Replace the needle. ·Is the needle and rotary hook timing correct? Adjust the height of the needle bar. Adjust the clearance between the needle and the tip of the rotary hook. ·Is the needle timing too advanced with respect to the dog/ Retard the needle timing. <p>“Caution”</p> <ul style="list-style-type: none"> ·It is extremely dangerous to leave any pieces of broken needle sticking in the material. If the needle breaks, search for all pieces until the whole of the needle is found again. ·Furthermore, we recommend we recommend that through steps be taken to account for such needles to comply with product liability regulations. ·縫紉過程中是否再送入或拉出面料時用力過度？ ·機針是否安裝正確？ 如果機針安裝不正確，應正確加以安裝。 ·針尖是否彎曲？針尖是否斷裂或針孔是否被堵住？ 請更換機針。 ·機針和旋梭的同步是否正合適？ 請調整針桿的高度。 請調整機針與旋梭尖之間的間隙。 ·對送布牙來說，機針的時序是否過早了些？ 請將機針的時序調晚一些。

		<p>“ 注意”</p> <ul style="list-style-type: none">·如果斷針不慎掉入縫紉衣物中，會有很大的危險。·請必須找出機針的殘骸，直至找齊整枚機針為止。·另外，請保留機針的紀錄，我們推薦以製造者責任法進行機針管理。
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