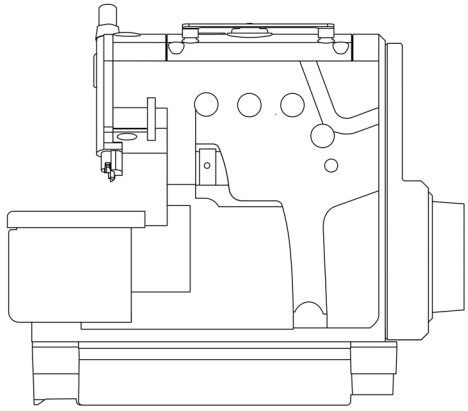


产品使用说明书

User's manual

X3节能包缝机

X3 POWER SAVING OVERLOCK SEWING MACHINE



怕跳针 · 怕断线 · 就用布鲁斯
NO BREAK, NO SKIP

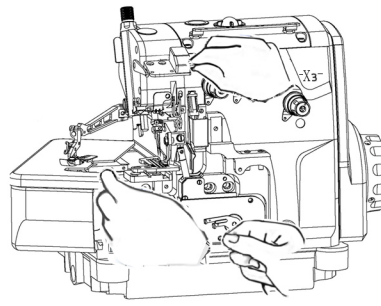
台州市布鲁斯缝制设备有限公司
浙江省台州市椒江区东海大道东段1008号2号楼
电话: 4008890100

TaiZhou Bruce Sewing Machine Co.,Ltd.
No.2 building No.1008 Eastern Section East Sea Road Jiaojiang District Taizhou, Zhejiang
TEL: 4008890100
2018年1月版

穿线的方法 Threading

打开压脚杆及机盖（三处），把机上原有的线与缝绉用线绑在一起

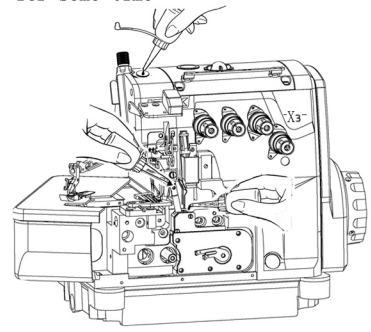
Open three covers, Sewing the presser foot aside kont the preset thread and the thread being used together to thread the machine



手动供油 Manual Lubrication

手动供油是在缝绉机最初开始使用时，或者相当一段时间未使用时，请供给2-3滴油

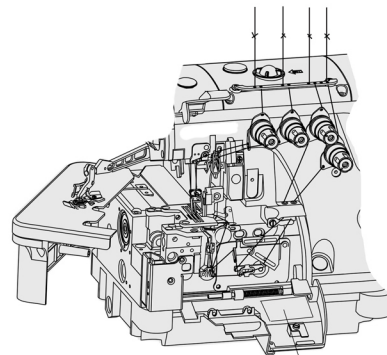
Apply 2 or 3 drops of oil by hand when the machine is used for the first time or has been left unuse for some time



针线 Needle thread

将线拉到针眼前，剪掉结头再次穿好针线，若机上原来没有线请参照穿线图正确进行穿线，弯针线，线拉出接头后，用剪刀剪齐接头

Trim the knots off neatly before passing through the needle to rethread, Make sure the machine is thraded correctly by referring to threading digram, looper thread Trim the knots off neatly after passing through the eye of the looper



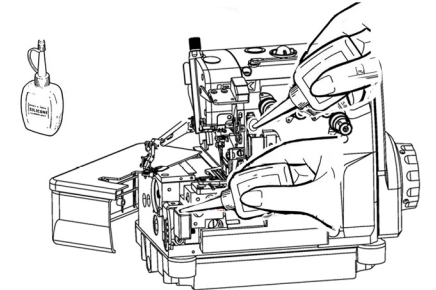
过线图 Threading diagram

给HR装置供油

Filling the HR device with silicon oil 为了防止布纤维或线被切断，请尽早给HR装置供油

注：关于购买硅脂油，请咨询缝绉机代销店或本公司营业厅

Filling the device with oil before it is too low in order prevent needle thead breakage and fabric dama; Note: Use recomended silicon oil

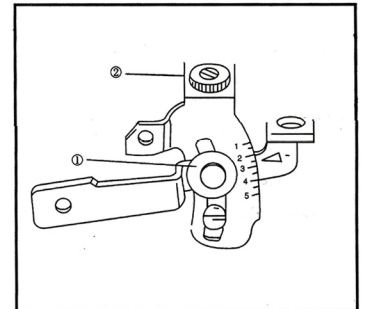


差动比的调节

Adjusting the differential feed ratio

差动比的调节，松开螺母①，调节螺母②

Loosen the adjusting nut① and turn the adjusti nut② to adjusting the differntial feed ratio

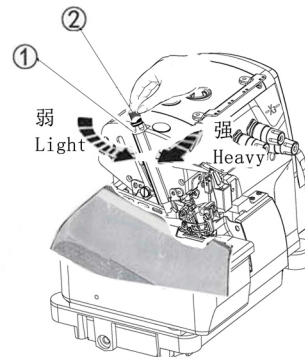


压脚压力的调节

Adjusting the presser foot pressure

压脚压力的调节，松开螺母①，调节螺母②

Loosen adjusting nut① and then turn adjusting nut② to adjusting the presser foot pressure, It should be as light as possible in the feed situation when the steady state was obtained



针脚长度的调节

Adjusting the thread tension

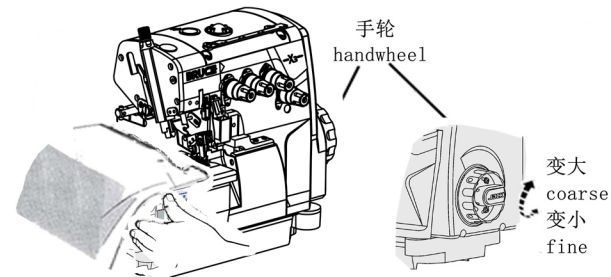
1. 摁住按钮，旋转手轮，按钮会陷入更深
2. 这时边摁住按钮边转动手轮，使校准标记对准所希望的数值

1. While pressing the push button, turn the hangwheel to seek the position at which the hangwheel and set the desired scale to push button goes further into the depth

2. Then, keeping the push button pressed turn the aligning mark

注：针脚长度的调节务必请在调节差动比之后进行

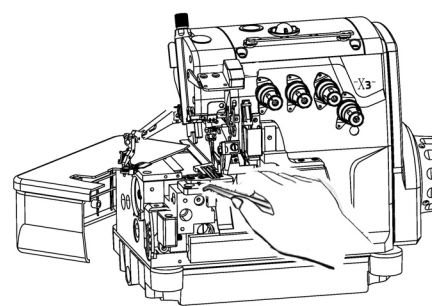
Note: Stitch length adjusting must only be made after the differntail feed ratio has been changed



缝绉机的清扫 Cleaning the machine

缝绉机的清扫，以针板槽及送布牙周围为主

Mainly the slots of the needle plate and the feed rows should be of cleaned



换针

Replacing the needle

准确辨认针的前后，请将针凹向着后方，即背向操作者进行安装，针要牢固的插到最深处

Check the needle carefully to see that the scarf is turned to the rear of the machine and fasten securely

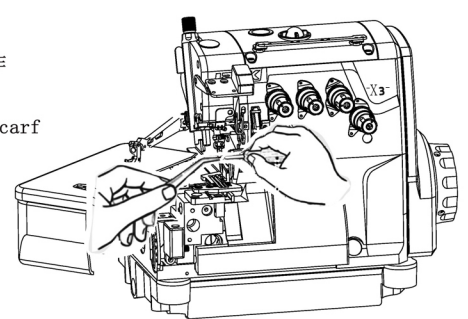
Insert the needle to the proper depth and fasten securely

标准使用针：

风琴DCX27

Standard needle

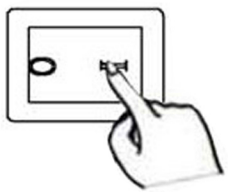
Organ DCX27



为了安全

对于缝绉机本身各种重量，我们充分考虑到它的安全性，请遵照基本的操作方法，安全的进行工作

- 拆除为保证安全设置的装置的零件的情况下使用，是非常危险的，请绝对不要拆除后使用
- 缝绉机在使用时，请不要在缝绉机台板上放置工具及缝绉时不必要的物品
- 在缝绉机进行检修、调节、清扫、穿线换针等工作时为防止发生事故，务必切断电源，在确认即使踩下缝绉机踏板，缝绉机也不转动后，再进行操作



OBSERVE THESE SAFETY PRECAUTIONS

Though Our takes the utmost care to produce safe sewing machines and devices, operstors should follow these basic safety rules

- To prevent accident, do not remove safety devices or parts while operating the machine
- Do not leave tools or other unnecessary objects on the machine table while operating the machine
- Before maintenance, adjusting, cleaning, thrsheding or replacing the needle, and to prevent accidents be sure the power is the power is turned off, Check that the machine will not operate the pedal is pressed

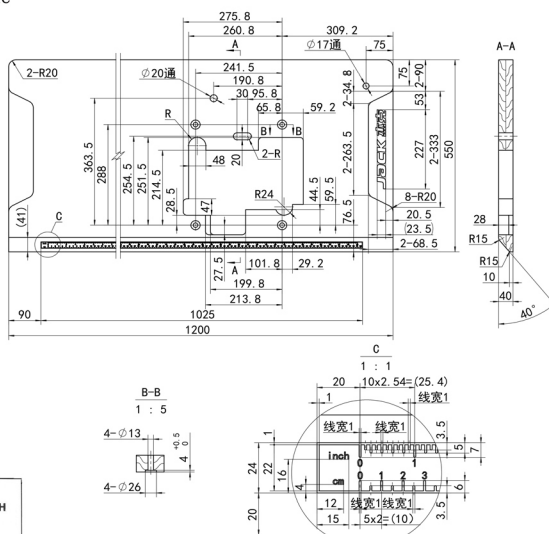
- 在离开缝绉机台时，务必关掉电源
- 停电时请务必关掉电源
- 为了总是安全的使缝绉机运转良好，日常的检点是不可缺少的，请予以注意
- Turn the power off before leaving machine table
- In the event of a power failure, be sure to turn the machine off
- To guarantee the machine always works well and safety, pay more attention to the daily spot check

台板加工图

Schematic digram of the machine table

请参照下图进行台板加工

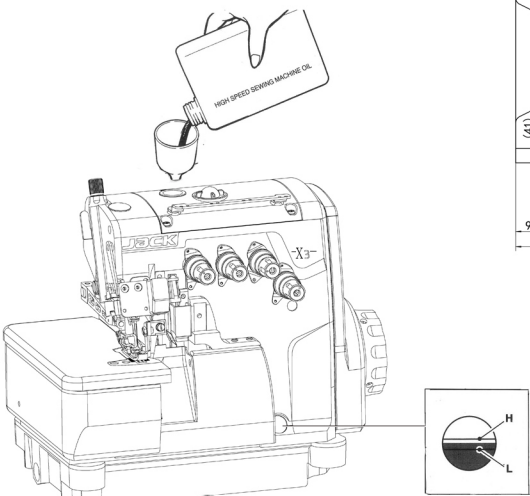
Cut the table referring to the diagram



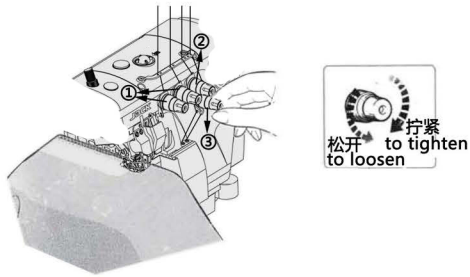
供油 Lubrication

加油时油量使油面处于H线与L线之间为好，当油面低于L线时，就要及时补充机油

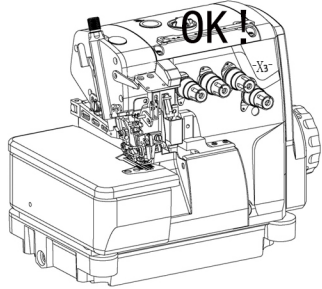
After filling the oil pan, the top of and indicator should lie between (H) and (L) line add oil, when the oil level indicators reaches or goes below (L)



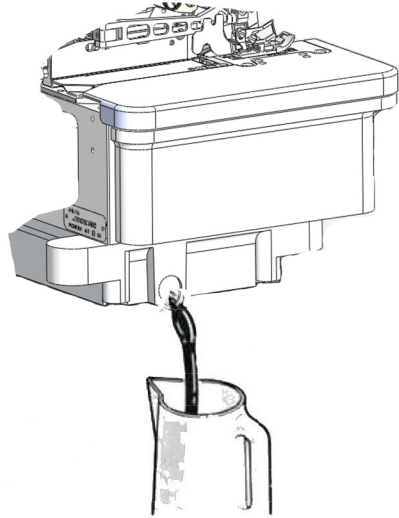
线状态的调节
Adjusting the thread tension
线张力状态的调节, 针线调节请用螺帽①, 上弯针线调节
请用螺帽②, 下弯针线调节螺帽请用螺帽
③进行调节
Make tension adjustments with the
needle thread knob①, the upper looper
knob② and the lower looper knob③



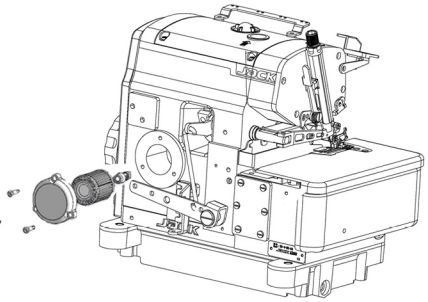
检查机油的循环
Checking the oil circulation



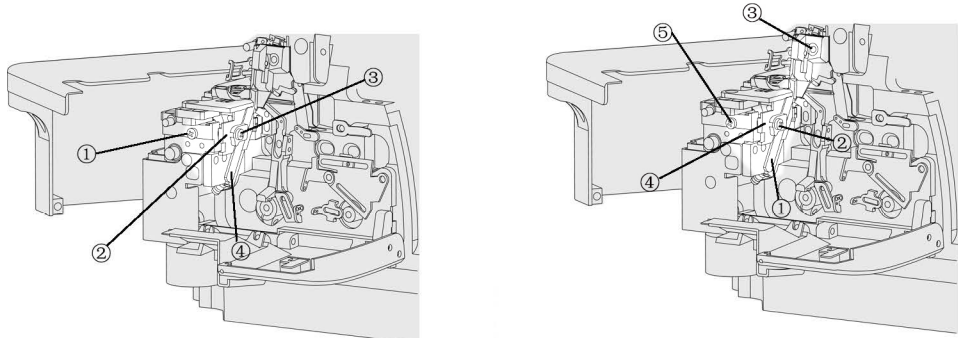
换机油 Replacing the oil
机油的更换, 请在使用开始1个月后更换一次, 然后,
请6个月更换一次
Replacing the oil one month after the first use
and every six months thereafter



检查油质量, 更换油芯
Checking and replacing the oil filler
机油每6个月检查并更换
Check and replace the oil filler every six
months



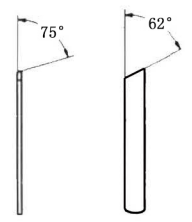
下刀片的更换 Replacing the lower knife 安装下刀片 Install the lower knife



① 松开螺丝 Loosen the screw
② 把下刀架推向左边, 用螺丝①暂时固定
Temporarily screw ① after sliding the lower
holder to the left
③ 松开螺丝 Loosen the screw
④ 取下下刀片 Remove the lower knife

① 装入下刀片 Insert the lower knife
② 拧紧螺丝 Tighten the screw
③ 转动手轮将上刀移动对准如图所示位置
Turn the hand wheel as the drawing on
the right figure
④ 松开螺丝⑤, 下刀架则向右移动
Loosening the screw ⑤ makes the lower knife
holder slide to the right
⑤ 拧紧螺丝 Tighten the screw

下刀片正确的研磨角度
Correct angles to resharpen
the lower knife



上刀片 Upper knife
针板表面A
Top surface of the needle
A plate
下刀架 Lower knife
使针板表面A与下刀架B处于相同水平位置
Level of [A]=Level of [B]
装好下刀片后进行剪线, 确认剪线情况
Checking cutting action of knife

X3调整基准表

机型	机针高度	下弯针引量	上弯针引量	二重环引量	送布 Feed dog			转速 Speed	
					送齿倾斜度	送齿高度	辅助送齿高度差	出厂默认	最高转速
Subclass	Needle height	Lower looper-needle setting distance	Upper looper-needle setting distance	Double chainstitch looper-needle setting distance	Feed dog Inclination	Feed dog height	Auxiliary feed dog height	Factory default speed	Maximum speed
X3-3-M1-15	10.4	3.7-3.9	5.0-5.5	—	针板上面水平	0.8	0.5	4900	5500
X3-3-M2-04	10.4	3.7-3.9	5.0-5.5	—	针板上面水平	0.8	0.5	4900	5000
X3-3-M5-04/BK	10.4	3.7-3.9	5.0-5.5	—	针板上面水平	0.8	0.5	4900	5500
X3-4-M2-24	10.4	3.7-3.9	5.5-6.0	—	针板上面水平	0.8	0.5	4900	5500
X3-4-M5-23/BK	10.4	3.7-3.9	5.5-6.0	—	针板上面水平	0.8	0.5	4900	5500
X3-5-M2-35	10.8	3.7-3.9	5.0-5.5	1.5	针板上面水平	0.8	0.5	4900	5000
X3-5-M2-55	10.8	3.7-3.9	5.0-5.5	1.5	针板上面水平	0.8	0.5	4900	5000
X3-5×2-56	11.9	3.7-3.9	5.0-5.5	1.7	针板上面水平	1.2	0.5	4900	5500

1. 开机显示界面
2. Power-on display interface



图1 用户参数界面 (正常开机显示界面)
Figure 1: User parameter interface (normal power-on display interface)

2. 操作参数说明
2. Operating parameter description

进入用户参数设置界面后, 短按左键P变更参数项, 按右键S后, 显示对应参数
值, 继续按S键可调节数值, 调节数值时, 右侧数码管处小圆点闪烁; 如果参数
修改, 短按左键P保存, 显示“OK”(如图3), 并回到下序一个列号显示界面,
如果参数值没有修改则直接回到下一个序列号显示界面。在设置界面内电机运行
将退出到待机界面。P界面序列号按下面表格循环:
After entering the user parameter setting interface, short press the left
key P to change the parameter item. Press the right key S to display the
corresponding parameter value, and continue to press the S key to adjust
the value. When the value is adjusted, the small dot at the right nixie
tube flashes; if the parameter.Modify, press the left button P to save,
display “OK” (as shown in figure 3), and return to the display interface
of a column number in the next sequence. If the parameter value is not
modified, it will directly return to the next serial number display
interface. Motor operation will exit to the standby interface in the
setting interface.

用户参数 User parameters		
参数 parameter	参数作用 Parameter effect	参数说明 Parameter Description
V	速度参数 Speed parameter	速度=显示值 x100 (转/分) Speed = display value x100 (r/min)
M	自动停针功能 开关 Automatic stop function switch	0: 关闭自动停针功能 1: 打开自动停针功能 0: Turn off the automatic pin stop function 1: open automatic pin stop function
Y	自动停针 Automatic needle stop	右数码管上横亮表示上针位; 右数码管下横亮表示下针位。 注意: 当M参数设置为0时, Y参数将不显示。 The right digital tube shows the needle position on the horizontal line; the lower digital tube indicates the lower needle position. Note: When the M parameter is set to 0, the Y parameter will not be displayed.

3. 恢复出厂设置
3. Factory reset

在待机界面, 长按右键S键3s, 所有的参数恢复为用户保存的值, 数码管
显示“OK”。
In the standby interface, press and hold the right button S for 3 seconds. All the
parameters are restored to the values saved by the user. The digital tube displays
“OK”.

4. 数码管显示说明
4. Digital tube display instructions

数字部分:
Numerical part:

实际数值 Actual value	0	1	2	3	4	5	6	7	8	9
数码管 显示 Digital tube display										

英文字母部分:
English alphabet part:

英文字母 English alphabet	A	B	C	D	E	F	G	H	I	J
数码管 显示 Digital tube display										
英文字母 English alphabet	K	L	M	N	O	P	Q	R	S	T
数码管 显示 Digital tube display										
英文字母 English alphabet	U	V	W	X	Y	Z				
数码管 显示 Digital tube display										

5. 错误码说明表
5. Error code description table

错误码 Error code	内容 Content	对策 Solution
E1	电机堵转 Motor stuck	请转动手轮检查机头是否卡住或者干涩转动困难; Please turn the hand wheel to check if the machine head is stuck or dry and difficult to turn; 检查电机插件是否松动或者脱落; Check if the motor plug is loose or comes off; 检查加工物料是否过厚, 电机因扭力不足而无法贯穿。 Check if the fabric is too thick, and the motor cannot pass through due to insufficient torque.
E2	过流 Overcurrent	请关机后重新上电, 如果不能消除报警, 若以上不能解决问题 请联系维修人员。 Please turn off the power and re-power, if you can't eliminate the alarm, please contact with service engineer.
E3	参数保存异常 Parameter save abnormal	出现此种状况, 需要关闭电源, 稍后再打开电源开关即可; If this happens, turn off the power and turn on the power switch later; 恢复出厂设置 (长按右键S键约3s不松开); Factory reset (press and hold the right key S for 3 seconds without releasing) 若重启或者恢复出厂设置后也不能解决, 建议联系经销商解 决。 If restart or factory reset can't solve the problem, please contact with JACK agents to solve it.
E4	电机霍尔信号异常 Motor hall signal abnormal	请检查电机编码器插头连接是否可靠, 编码器信号线是否有断 线, 插针是否退出或者变形。 Check whether the motor encoder plug connection is reliable, whether the encoder signal line is broken, whether the pin is ejected or deformed.
E5	定位器信号异常 Positioner signal abnormal	请转动手轮, 如果不能消除报警, 关机后重新上电, 如果还不 能消除报警, 请检查编码器/定位器插头连接是否可靠; Please turn the hand wheel. If the alarm can't be eliminated, turn it on again and power it on again. If you still can't eliminate the alarm, please check whether the encoder/positioner plug connection is reliable; 电机定位器霍尔异常; Motor positioner hall abnormal; (如果定位器损坏或者不需要定位功能时, 当报E5后, 长按右 键S键约3s关闭停针位功能)。 (If the positioner is damaged or does not require the positioning function, after pressing E5, press and hold the right key S for 3 seconds to turn off the needle position function).
Eb	系统过电压 System overvoltage	立即切断电源, 并检查供电电压是否超过额定电压范围, 如果 是, 请调整供电电压到额定电压后再开机工作。 Immediately cut off the power supply and check if the power supply voltage exceeds the rated voltage range. If so, adjust the power supply voltage to the rated voltage before starting the work.

注: 如果根据错误处理对策仍然不能消除错误报警, 请及时联系厂家处理。
Note: If you still can't eliminate the error alarm according to the error handling
solution, please contact with manufacturer timely.