



ZOJE

中捷

高速裤襻缝纫机^{VF.}

ZJ2479A

HIGH SPEED BELT LOOP MAKING MACHINE

使用说明书 零件手册

OPERATION MANUAL
PARTS BOOK

中国·中捷缝纫机股份有限公司
ZOJE SEWING MACHINE CO., LTD.

卷用

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1. 机型和缝纫速度

ZJ2479A 针间距: 4.8, 5.6, 6.4 mm

卷边器宽度: 8, 9, 10, 12, 15, 20mm

最高转速: 4000转/分

常用转速: 3000转/分

本机标准安装10mm卷边器, 针距5.6mm,
如需其他规格, 请在定货时指定。

1. Models and sewing speed

ZJ2479A needle distance: 4.8,5.6,6.4mm

Folder width:8、9、10、12、15、20mm

Max.Sewing speed:4,000 s.p.m

Ordinary sewing speed:3,000 s.p.m

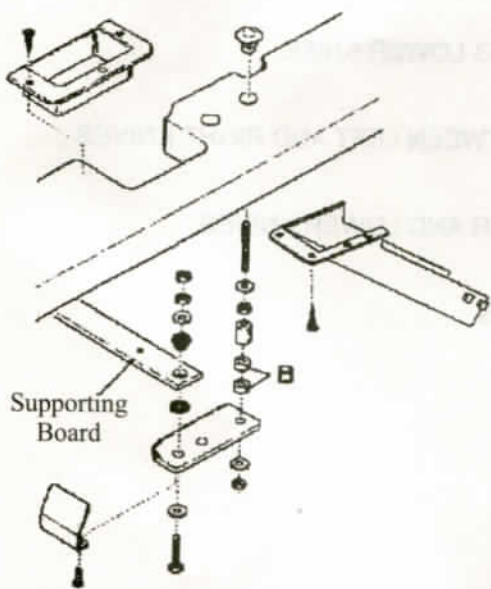
The standard install 10mm Folder,needle
guage 5.6mm,any special request ,please be
advised before order.

2. 安装

2-1 支撑板的安装(半沉式)

按图所示正确安装。

先将螺钉装在支撑板上, 再将支撑板装到
台板上, 然后将橡皮垫套在螺钉上以保证机器
安全。

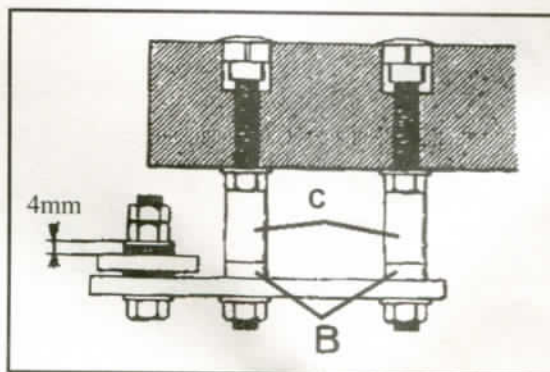
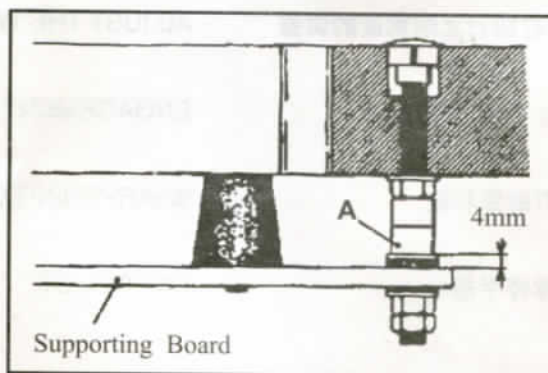


2. Installation

2-1 Installation of Supporting Board (Semi-submerged type)

Install the machine correctly referring to the
illustration.

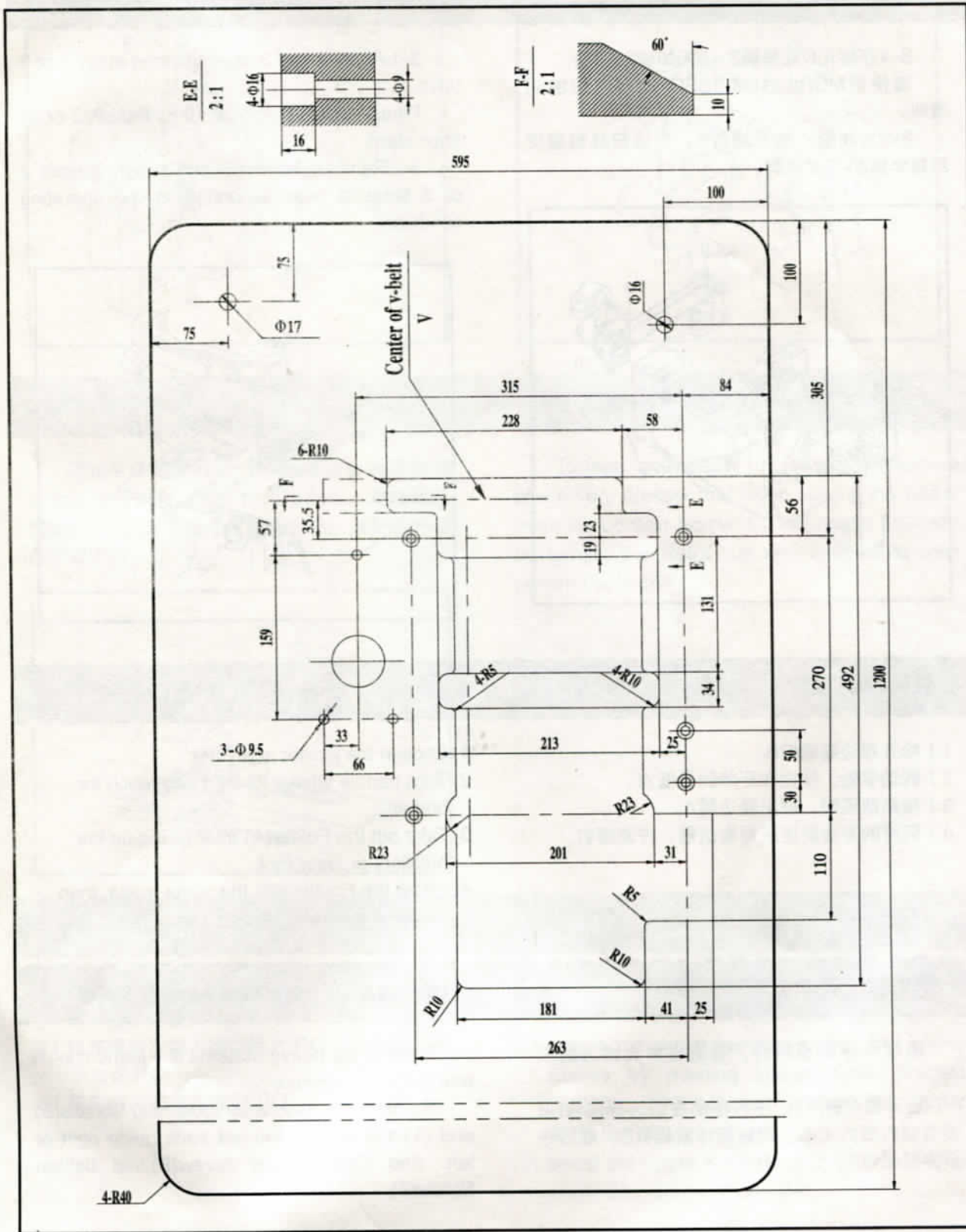
Set Screws on Supporting Board and install
the Board to Machine Table. Then put Rubber
Cushions on Screws and mount the machine on
them securely.



Thickness of Table 台板高度	Pcs. of A 数量A	Pcs. of B 数量B
40mm	2pcs.×3=6	1pcs.×2=2
45mm	1pcs.×3=3	0
50mm	0	2pcs.×2=4 不装长垫块C

2-2. 台板尺寸

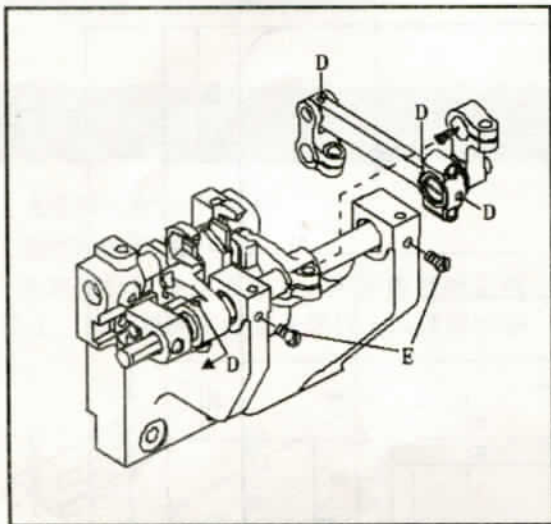
2-2. Drawing of table top cut-out



3. 手动给油

3-1在标记D处每隔2~3天加油2~3滴。
请使用MOBIL#10或ESSO#32或同级的润滑油。

3-2加油脂：松开螺钉E，在标记处根据使用每年加2~3次油脂。

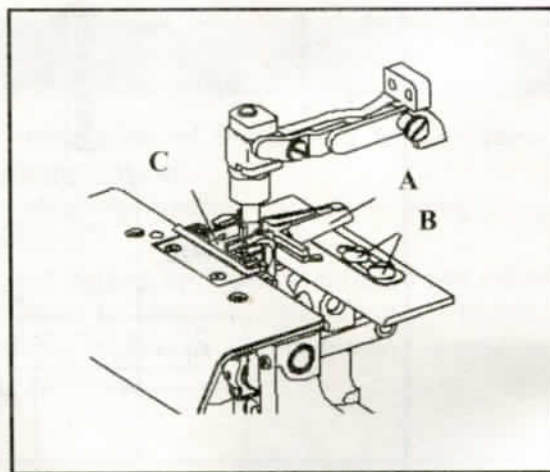


3. Manual Lubrication

3-1.Apply 2 and 3 of oil by hand every 2 or 3 days.

Please use oil Mobit # 10 or Esso#32 or its equivalent.

3-2.Remove Screw(E),and supply grease 2 or 3 times a year according to the operating condition.



4. 卷边器的拆装

- 1) 松开卷边器螺钉B。
- 2) 转动手轮，使送布牙降到最低点。
- 3) 抬起前压脚，取出卷边器A。
- 4) 同样的方法装进所需卷边器，拧紧螺钉。

4. Setting and removing Folder

- 1) Loosen the Folder screw(B).
- 2) Turn handle wheel, till feed dog reach the bottom.
- 3) Take out the Folder(A) after taking up the Auxiliary presser foot.
- 4) Install the Folder with the same mode, then tighten the screw.

5. 切刀压力调节

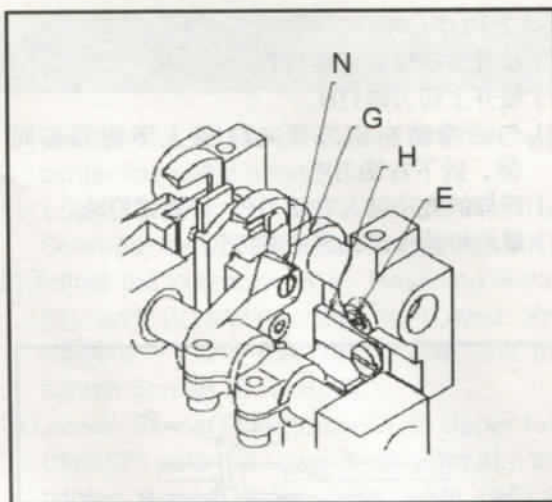
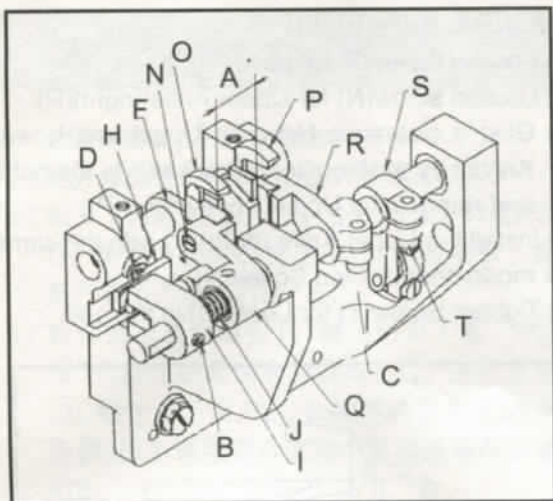
缝制牛仔等厚料时，需适当加大切刀的壓力。

松开螺钉B、T，左右移动左切刀导向块I来调节切刀压力大小，调好后拧紧螺钉B，最后拧紧夹紧螺钉T。

5. Pressure of upper and lower knives

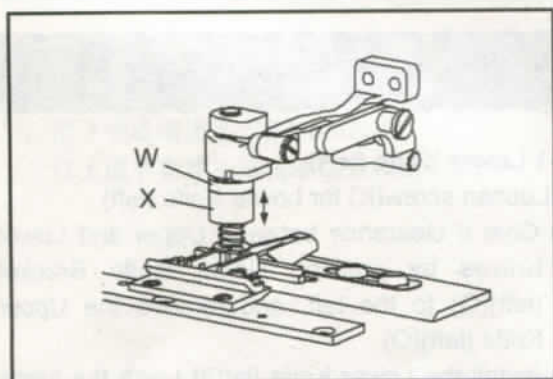
Sewing the heavy material like jeans should add the knife pressure

Adjust the pressure by loosening Screws(B) and (T),and moving the left knife guide right or left. And then tighten Screw(B),and tighten Screw(T).



6. 辅压脚压力调节

缝制牛仔等厚料时，需要适当加大前压脚压力，方便送布。旋松锁紧螺母W，旋转调压螺套X上下，调节前压脚压力大小。调好后拧紧锁紧螺母W。



6. Pressure of Auxiliary Presser Foot

To feed cloth easily, increase the pressure of auxiliary presser foot when sewing the heavy material. Loosen Screw(W). Adjust the pressure by turning the Nut(X) up and down. And then tighten the Nut(W).

7. 上切刀的拆下和安装

7-1. 上切刀 (左)

- 1) 松开上切刀螺钉N。
- 2) 往左推动左切刀座Q使上下切刀有间隙，拆下左切刀O。
- 3) 同样的方法装入左切刀O，拧紧螺钉N。

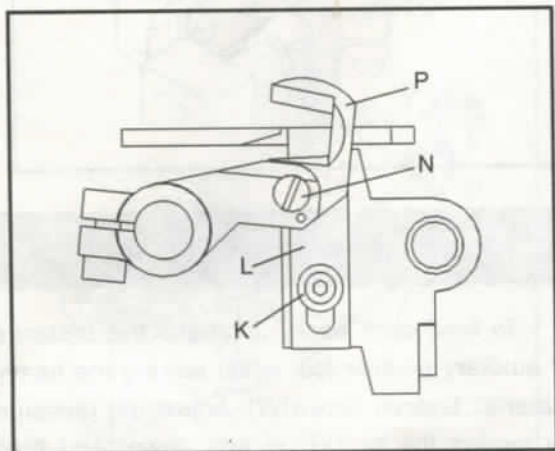
7. Setting and removing Upper Knife

7-1. Upper Knife (left)

- 1) Loosen Screw(N) for Upper Knife (left)(N).
- 2) Give a clearance between Upper and Lower Knives by pushing Upper Knife Bracket (left)(Q) to the left, and remove the Upper Knife (left)(O).
- 3) Install the Upper Knife (left)(O) with the same mode, then tighten Screw(N).

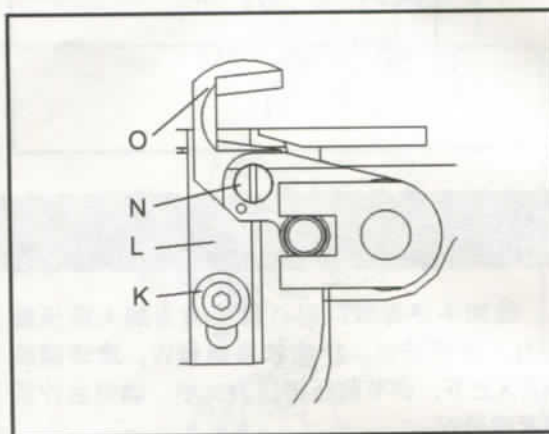
7-2.上切刀(右)

- 1) 松开传动轴曲柄螺钉T。
- 2) 松开上切刀螺钉N。
- 3) 向右推动左切刀导向块I使上下切刀有间隙, 拆下右切刀P。
- 4) 同样的方法装入右切刀P, 拧紧螺钉N。
- 5) 最后拧紧传动轴曲柄螺钉T。



7-2.Upper Knife (right)

- 1) Loosen screw(T) for Lever(S).
- 2) Loosen screw(N) for Upper Knife (right)(R).
- 3) Give a clearance between Upper and Lower Knives by pushing Joint Bracket(I) to the right, and remove the Upper Knife (right)(P).
- 4) Install the Upper Knife (right)(P) with the same mode, then tighten Screw(N).
- 5) Tighten Screw(T) for Lever(S) in the end.



8. 下切刀的拆下和安装

8.Setting and removing Lower Knife

8-1.下切刀(左)

- 1) 松开下切刀螺钉K。
- 2) 往左推动左切刀座Q使上下切刀有间隙, 拆下下切刀L。
- 3) 同样的方法装入下切刀L, 拧紧螺钉K。

8-1.Lower Knife (left)

- 1) Loosen screw(K) for Lower Knife (left)
- 2) Give a clearance between Upper and Lower Knives by pushing Upper Knife Bracket (left)(Q) to the left, and remove the Upper Knife (left)(O).
- 3) Install the Lower Knife (left)(L) with the same mode, then tighten screw(K).

8-2.下切刀(右)

- 1) 松开传动轴曲柄螺钉T。
- 2) 松开下切刀螺钉K。
- 3) 向右推动左切刀导向块I使上下切刀有间隙, 拆下下切刀L。
- 4) 同样的方法装入下切刀L, 拧紧螺钉K。
- 5) 最后拧紧传动轴曲柄螺钉T。

8-2.Lower Knife (right)

- 1) Loosen Screw(T) for Lever(S).
- 2) Loosen Screw(K) for Lower Knife (right).
- 3) Give a clearance between Upper and Lower Knives by pushing Joint Bracket(I) to the right, and remove the Lower Knife (right) (L).
- 4) Install the Lower Knife (right)(L) with the same mode, then tighten Screw(K).
- 5) Tighten Screw(T) for Lever(S) in the end.

9. 左右切刀之间宽度的调整

9. Adjust the width between left and right knives.

间距A是以针杆中心对称分布。

Clearance A should be divided into half by the center line of the needle bar.

- 1) 松开导向块螺钉B, 右切刀座螺钉C。
- 2) 松开下刀座螺钉D、E, 左右调节下刀座F、G, 使两刀之间的宽度A达到所要求, 然后拧紧下刀座螺钉D、E。
- 3) 松开曲柄夹紧螺钉T, 将上切刀(右)P贴住下切刀L后紧固右刀座螺钉C, 将左上切刀O贴住左下切刀L, 向右推动导向块I使调压簧J压力调整到合适大小后紧固导向块螺钉B。
- 4) 最后拧紧曲柄夹紧螺钉T。

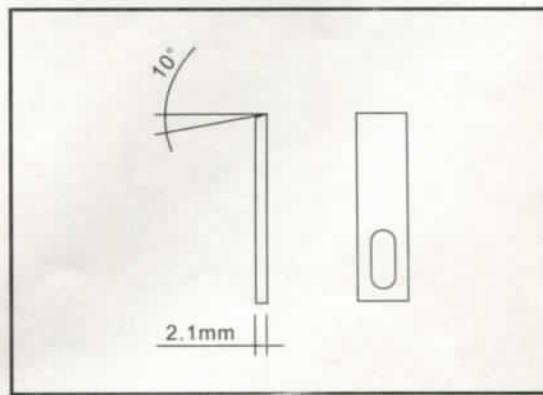
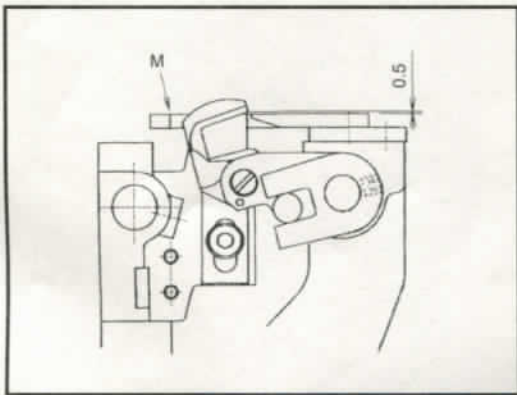
- 1) Loosen Screw(B) for Joint Bracket(I), and Screw(C) for Upper Knife Bracket (right)(R).
- 2) Adjust the clearance A by loosening Screws (D) and (E), and moving the Lower Knife Holders (F) and (G) right or left. And then tighten Screws (D) and (E).
- 3) Loosen Screw(T) for Lever(S), fit Upper Knife (right)(P) onto the Lower Knife (right)(L), then tighten Screw(C). Fit Upper Knife (left) (O) onto the Lower Knife (left)(L). Move Joint Bracket (I) to the right to press spring (J). Then tighten Screw(B) while pressing them to the flat spot.
- 4) Tighten Screw(T) for Lever(S) in the end.

10. 上下切刀的配合

10. Engagement of upper and lower Knife

- 1) 下刀的刃口与针板M面平齐。
- 2) 上切刀摆动到最低点时, 此时上刀尖与下刀面平齐或高出下刀0.5mm以内。
以上调节需要松掉传动轴曲柄螺钉T。

- 1) Lower knife edge in the same level with the Needle Plate(M).
- 2) When Upper Knives(O) and (P) are at the bottom of their stroke, there should be a clearance of 0.5mm between the points of the cutting edges of the upper knives and those of the lower knives.
Adjustment is made by loosening Screw(T) on Upper Knife Drive Lever(S)



11. 刀的锋利度

11. Sharpening of knives

上刀是硬质合金制成，在一年内无需重新磨刀。

如果使用一段时间后下切刀变钝，需要重新磨下切刀。磨刀时要用水不断地冷却刀片。

上切刀不能用普通的工具来磨。一般需要备用几把上切刀，如需重磨，请与我公司经销商或直接跟我们联系。

Upper Knife is made of super hard alloy and there is no need to re-sharpening for about a year.

If the sharpness is deteriorated during this period, re-sharpen Lower Knife. At the time of sharpening, cool the knife with water without fail.

Upper knife cannot be sharpened by an ordinary grinder. Always keep several spare Upper Knives and request the re-sharpening to the agent who sold you the machine or directly to us.