



ZOJE

中捷

多针绷缝机系列 ZJ1414

HIGH-SPEED MULTI-NEEDLE INTERLOCK SEWING MACHINE SERIES

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.

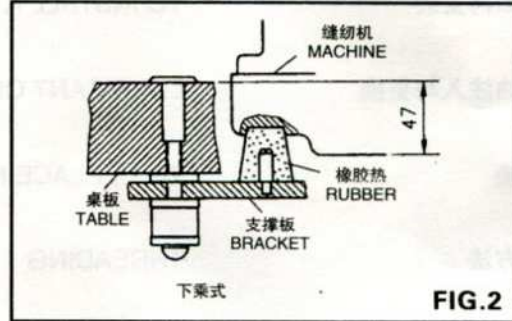
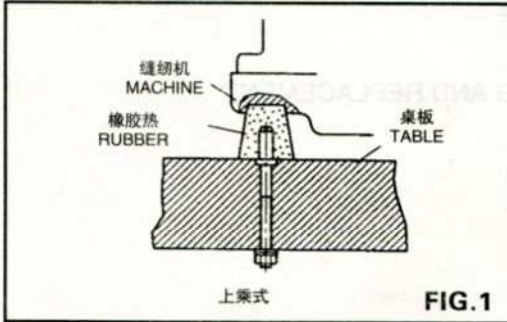
本使用说明书和零件手册内容，为了改良不经预告随时会更改，请谅解为盼。

The description covered in this operation manual and parts book is subject to change for improvement of the commodity without notice.

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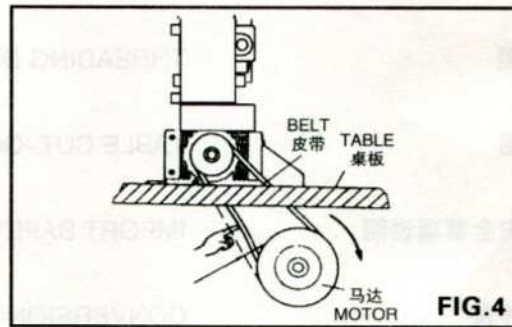
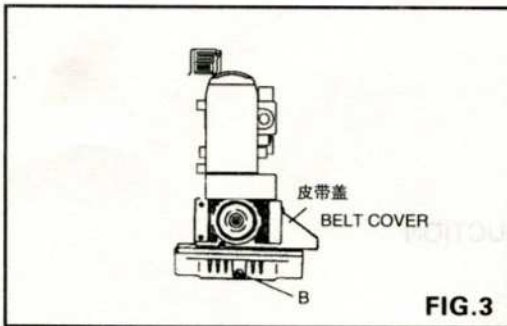
1. 依本机器所附桌板裁制图及零件组合图所列之配件, 依序安装防震机座, 及线架(图 1&2)。

1. With reference to diagrams for tablecutting and mounting parts list, install vibration-reducing base and thread stand in sequence. (Fig. 1 & 2)



2. 马达之转向为顺时针方向, 皮带之松紧度以用手指能向内压20mm为宜, 同时为安全起见请皮带盖必须锁上。(图 3 & 4)

2. Motor should run clockwise with proper tension for driving belt. It can be checked by pushing belt inward for 20mm. Please install belt cover properly for safety purpose. (Fig. 3 & 4)



3. 皮带输及缝合转速, 请参照(表1)。

3. Motor pulley size and sewing speed, please refer to Table No.1

注意:

Remarks:

1. 使用新机器最初一个月运转速度约为最高速(表2)之80%, 并请选择正确的马达皮带输尺寸(表1)
2. 桌板厚度约50mm。
3. 马达规格: 离合器马达, 3相2极400瓦(1/2HP)
4. 皮带规格: M型V字皮带。

1. New machines run a speed at approximately 80% of the Maximum speed in the first Month (Tab.1) Be sure to choose proper motor pulley For your machine
2. Thickness of Table Top is about 50mm.
3. Specification of motor: Clutch motor 3 Phase, 2 poles, 400W (1/2 HP).
4. Driving Belt: M type, V belt.

润滑油之注入与更换

LUBRICANT OIL FITTING AND REPLACEMENT

新机器运转前均已将油倒尽，因此机器使用前必须加入润滑油

Machine chamber is empty with no oil.
Please fill lubricant oil into new machines before running

1. 润滑油之注入(图5—6):

将(A)旋开，以包装箱内所附之超高速润滑油或选用MOBIL#10或ESSO#32 等级之润滑油加入，直至油窗(C)内之油标线间即可，然后再锁紧(A)。

1. To fill lubricant oil: (Fig. 5 &6)

* Loosen Knob (A), fill in with lubricant oil or its equivalent such as Mobil # 10 or Esso #32. Please fill the oil up between two level lines on oil Indicator (C) and tighten knob up.

2. 润滑油之更换: (图3)

- * 将螺丝(B)松开，使油槽之油完全排出后再锁紧。
- * 为延长本机器之寿命，请于开始使用四星期后更换新油，此后约每四个月更换一次。

2. To replace lubricant oil: (Fig.3)

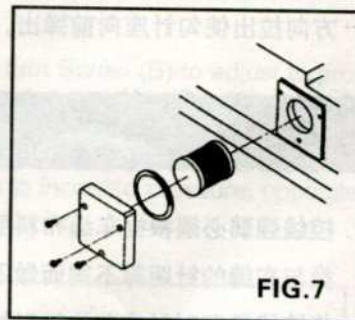
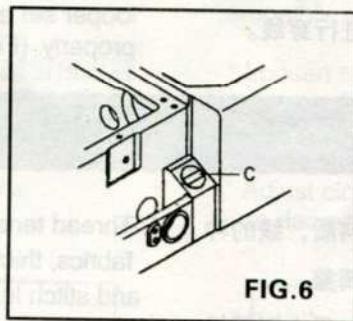
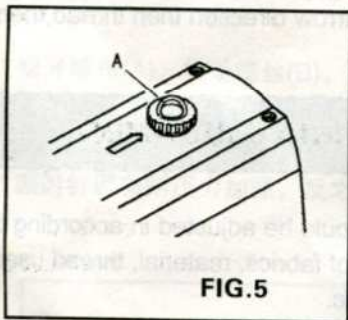
- * Loosen Knob (B), drain oil from the oil tank And tighten it up.
- * For smoothing machine, please replace lubricant oil after the first 4 weeks operation. There-after, replace oil every 4 months.

3. 滤油器之更换(图7)

本机器特别装有滤油器，约每使用一个月后应卸下清洗，必要时得更换新品。

3. To replace oil filter: (Fig.7)

- * Take filter out and clean up every month. Replace with new filters if necessary.



针之更换

TO REPLACE NEEDLES

* 选用针之规格兴尺寸请参照(表2)

* Please refer to Table 2 for proper needle sizes.

1. 旋松螺丝(D)并取下针。(图8)

1. Loosen Screw (D) and take out the used needle. (Fig.8)

2. 将新针插入针座之针孔至最底端，并使针之凹弧向左。
3. 重新锁紧螺丝(D)。
4. 如果针安装不正确，不但会引起跳针断线，还会损坏勾针，务必注意。

2. Put new needle into the needle clamp holes as far as they can go. The scarf of needle should be on left side.
3. Tighten Screw (D).
4. Improper needle setting will cause skipping stitches, breaking threads, and damaging loopers. Please pay attention to needle installation.

Table(表 1)		
转速/分 S.P.M	M/C Pulley Size (mm)	
	60Hz	50Hz
4500	90	105
4000	80	95
3500	70	85

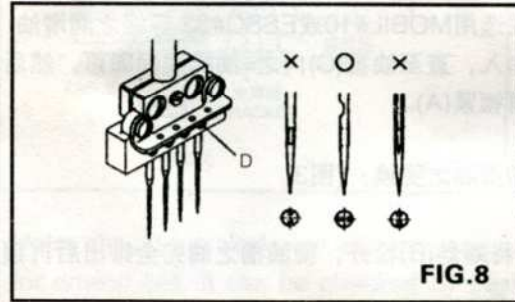


FIG. 8

穿线之方法

THREADING

1. 请确实按照图示做好针之穿线，错误之穿线将引起断线，跳针或车缝不平坦等现象，请参照线图第5页。
2. 在穿勾针线时，应将勾针座引出轴(图10)沿箭头方向拉出使勾针座向前弹出，然后进行穿线。

1. For needle threading, please thread carefully as threading illustration page 5, Please note: improper threading will cause breaking threads, skipping stitches, and / or undesired sewings.
2. For looper threading, pull out the lever "P" of looper set as the arrow direction then thread them properly. (Fig. 10)

控线之调整

THREAD TENSION ADJUSTMENT

1. 控线强弱必须根据车缝布料层数，料质，线的种类与车缝的针距等不同而做不同之调整。
将控线钮顺时针方向旋转时线越紧，反之则越松。
2. 针控线杆之调整(图 11)
针线控线杆(B) 依缝线使用种类来选择使用状态，放松螺丝(A)将(B)上下移动调整，在使用伸展性大的缝线时将(B)上移，反之下移

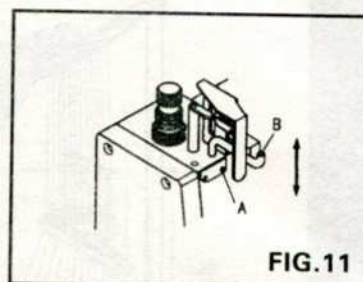
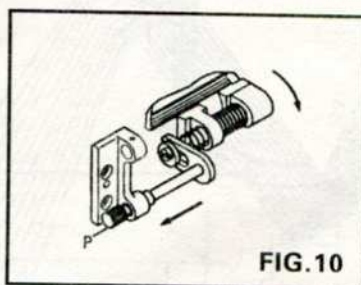
1. Thread tension should be adjusted in according to fabrics, thickness of fabrics, material, thread used and stitch length etc.

Turn thread-knob clockwise for Tighter tension and vice versa.
2. Take-up lever adjustment (Fig.11)
The position of Needle Thread Take-up Lever (B) is adjustable according to thread used. Loosen Screw (A) ,move Lever (B) up and down for the optimum position. For instance,

Table 2 (表 2)

Needle System 针规格	Needle Size 针号
ORGAN UO113	# 11-#18 #17-#160
ORGAN DV57	#11-18

When using high extension thread,
move Lever(B) upward and vice versa.



缝距之调整

STITCH LENGTH ADJUSTMENT

首先确认马达需关掉, 然后压下缝距调整按钮(A), 并转动皮带输, 会感觉卡一声, 即按钮卡住针距调整组, 再转动皮带输至所需之缝距欲调长缝距时, 将皮带输往顺时针方向旋转, 反之则小, 再放开此按钮, 针距调节范围1.4 ~ 5.0mm(图 12)。

Be sure to turn off motor before adjust, Push stitch length Regulator Button (A) and turn pulley until the button lock in the stitch regulator. Then, turn pulley again to reach desired stitch length. Turn pulley clockwise for longer stitch length, vice versa. Then, release the Button. (Fig. 12)

压脚压力强度之调整

ADJUSTING THE PRESSURE OF PRESSER FOOT

在布料推送顺畅且缝合完美之情况下, 压脚压力尽量轻些。

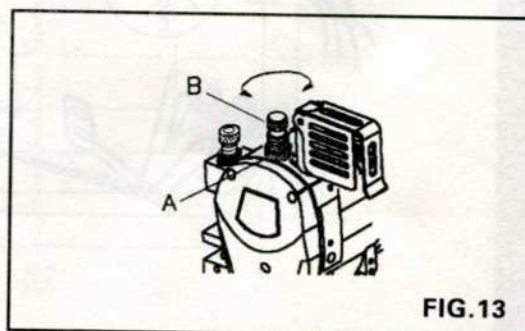
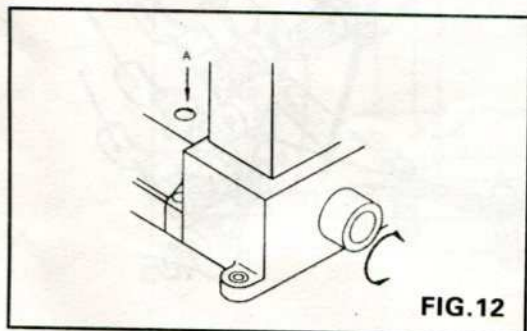
Pressure of the Presser Foot should be as light as possible, in case of cloth can be feeded and sewed smoothly.

* 松开螺母(A), 转动螺丝(B), 调整其适当压力后在锁紧螺母(A)。(图 13)

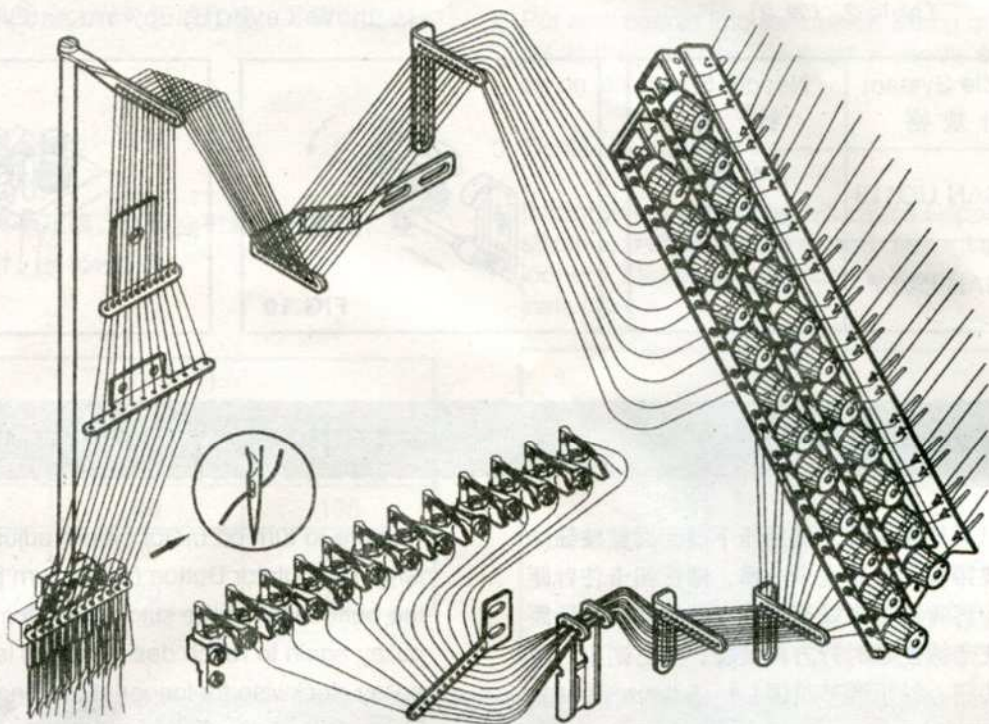
* Loosen Nut (A), turn Screw (B) to adjust to proper pressure, then tighten Nut (A). (Fig 13)

* 顺时针调整则压力加强, 反之则减少。

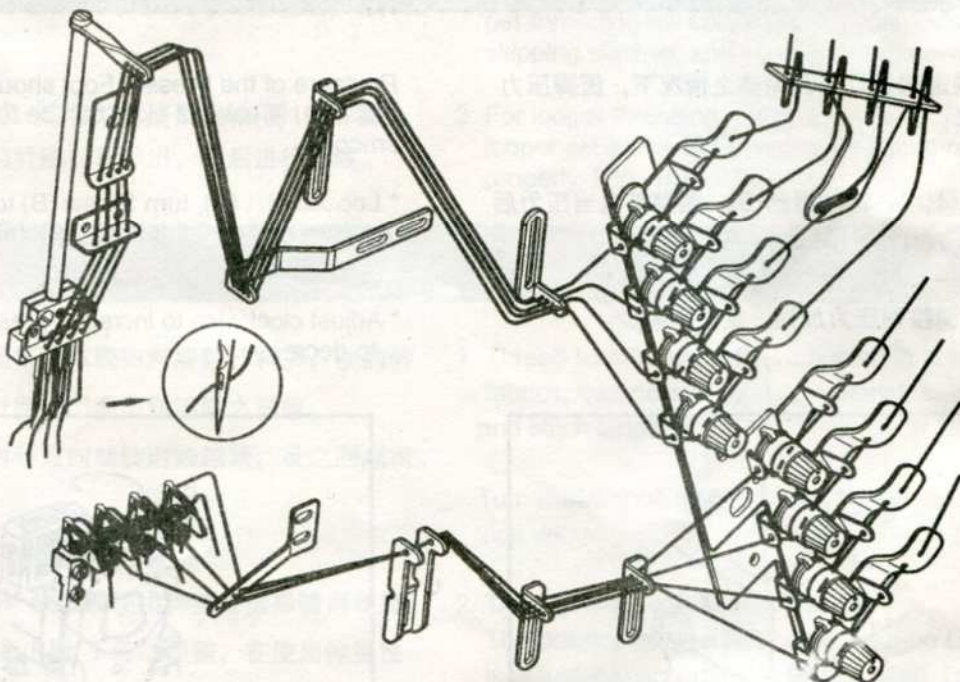
* Adjust clockwise to increase pressure, opposite to decrease.



THREADING DIAGRAM FOR 12 Needles



THREADING DIAGRAM FOR 4 Needles



单位/UNIT : MM

所有尺寸公差 / DIFFERENCE : ± 2

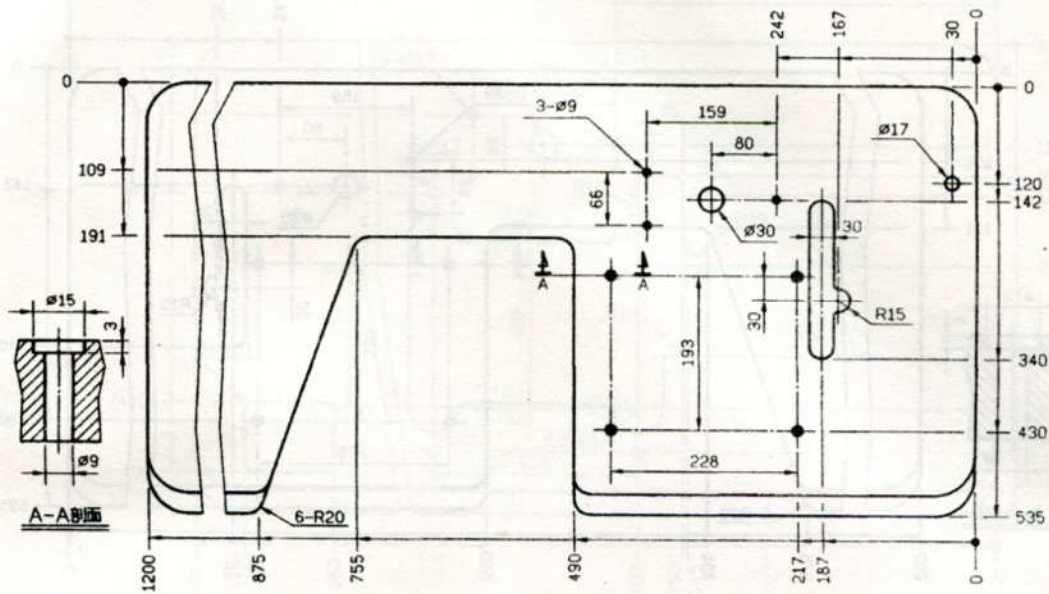


TABLE CUT - OUT ZJ1414-T2

单位/UNIT : MM

所有尺寸公差 / DIFFERENCE : ± 2

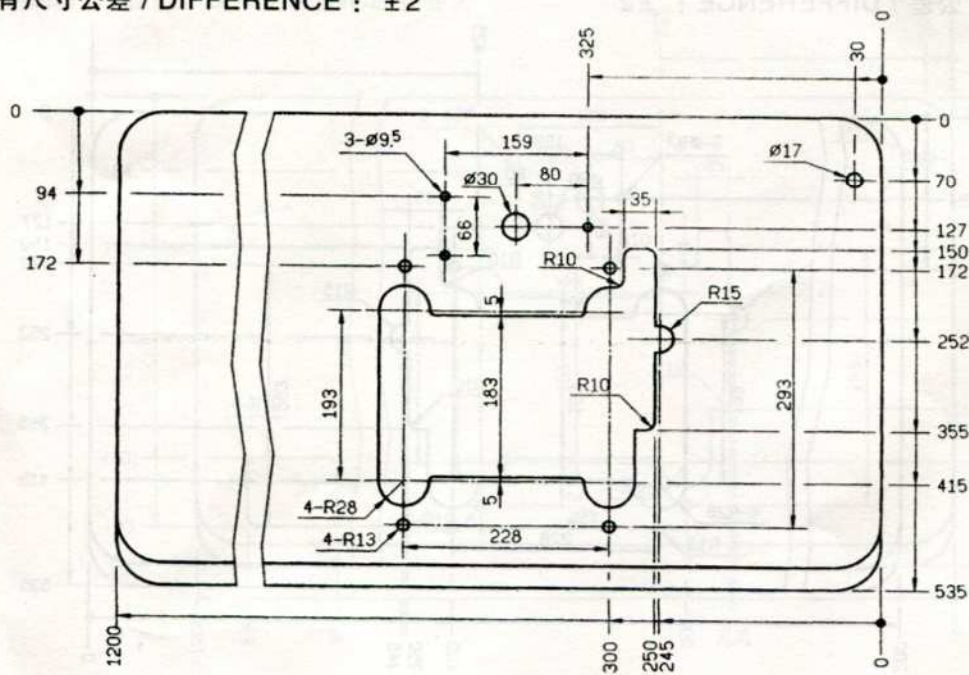


TABLE CUT - OUT ZJ1414-T1

TABLE CUT - OUT ZJ1414-T4

单位/UNIT : MM

所有尺寸公差 / DIFFERENCE : ± 2

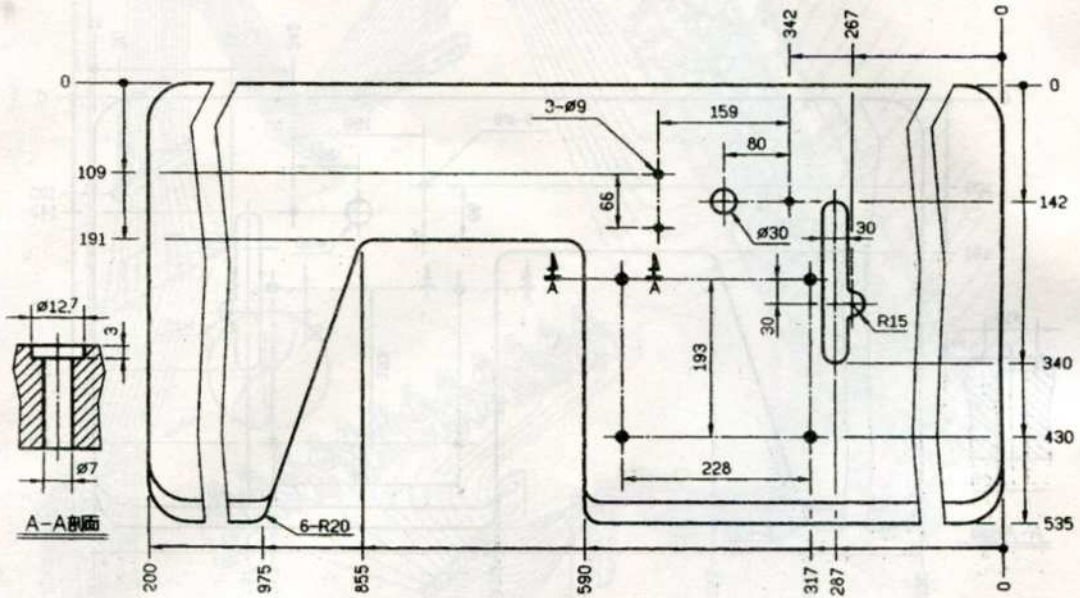
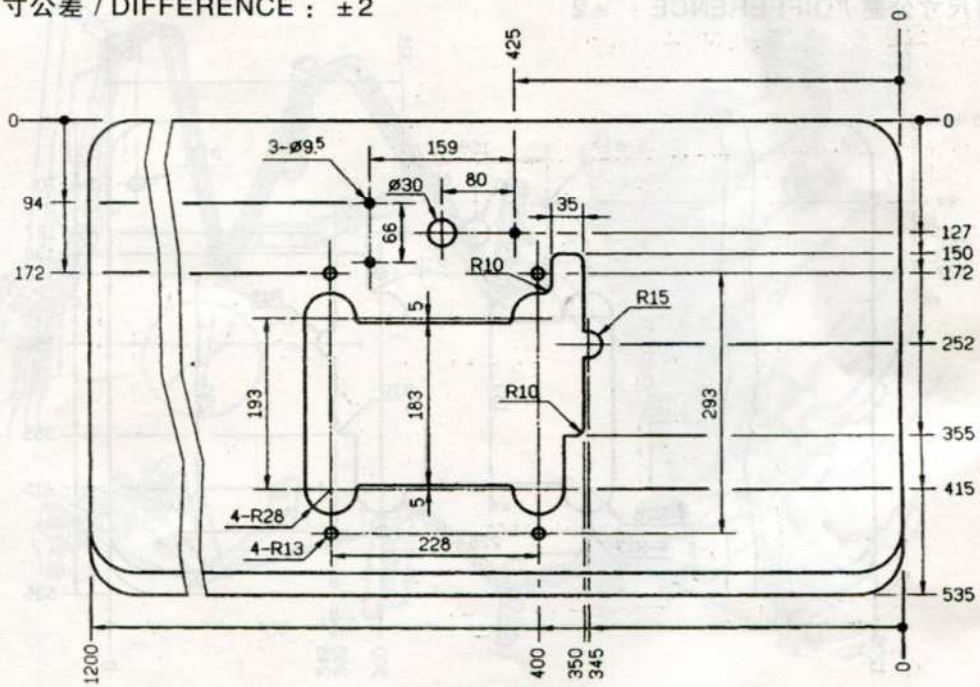


TABLE CUT - OUT ZJ1414-T3

单位/UNIT : MM

所有尺寸公差 / DIFFERENCE : ± 2



单位/UNIT : MM

所有尺寸公差 / DIFFERENCE : ± 2

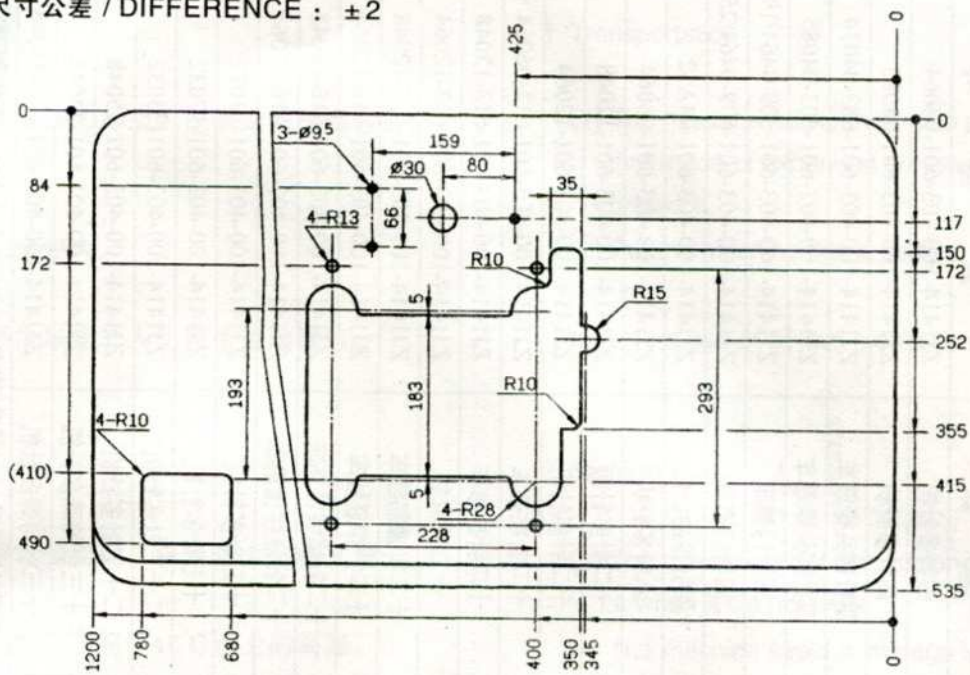


TABLE CUT - OUT ZJ1414-T6

单位/UNIT : MM

所有尺寸公差 / DIFFERENCE : ± 2

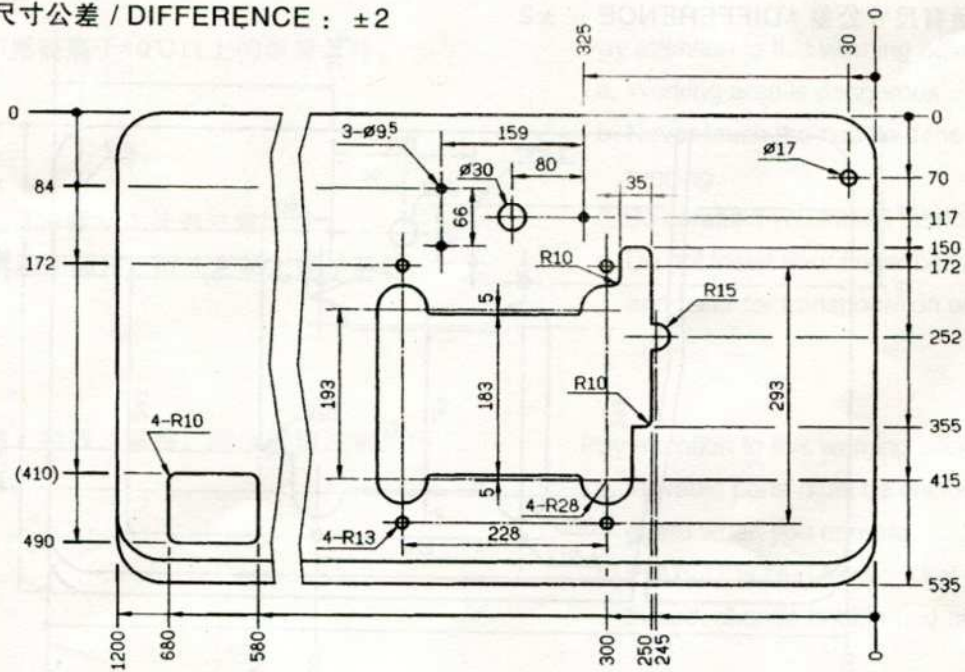


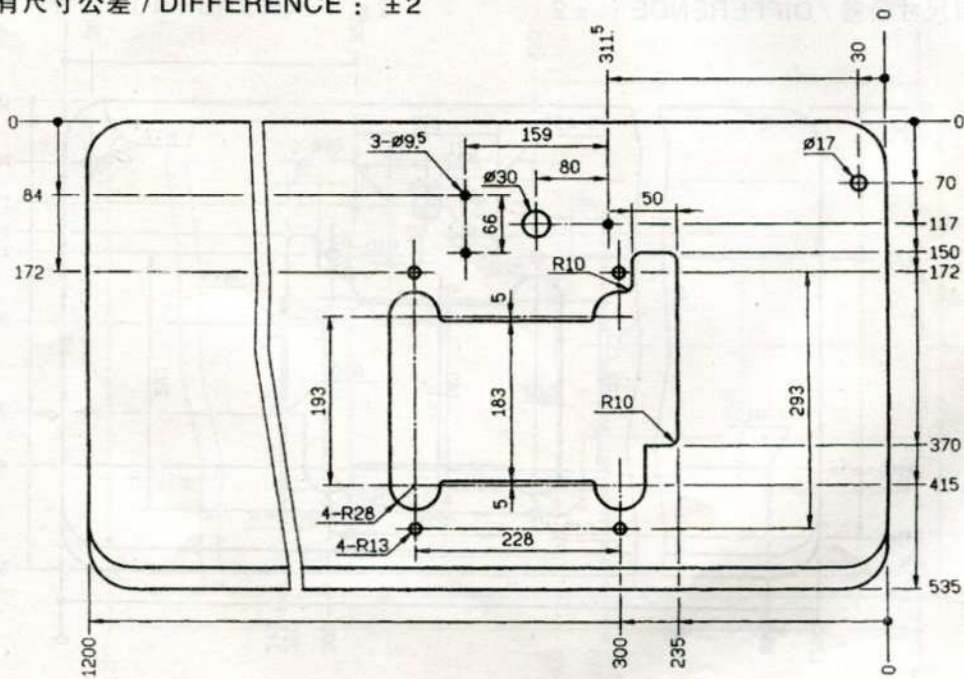
TABLE CUT - OUT ZJ1414-T5

名称	新 型 号
四针多针机	ZJ1414-100-403-601-04064
四针多针机	ZJ1414-100-403-601-04085
四针裤头橡筋车	ZJ1414-100-403-601-603-04034
四针裤头橡筋车	ZJ1414-100-403-601-603-04085
四针门襟车	ZJ1414-100-403-601-609-0464/191
四针门襟车	ZJ1414-100-403-601-609-0464/254
四针自由针位	ZJ1414-100-403-601-04A32
八针多针机	ZJ1414-100-403-601-08064
十二针多针机	ZJ1414-100-403-601-12048
十二针多针机	ZJ1414-100-403-601-12064
十二针贴条车	ZJ1414-100-403-601-612-06064
十二针折布车	ZJ1414-100-403-601-613-12048
十二折布车	ZJ1414-100-403-601-613-12064
十二针橡筋线车	ZJ1414-100-403-601-615-12048
十二针橡筋线车	ZJ1414-100-403-601-615-12064
十二针底线橡筋车	ZJ1414-100-403-601-616-12048
十二针底线橡筋车	ZJ1414-100-403-601-616-12064
十三针多针机	ZJ1414-100-403-601-13032
十七针多针机	ZJ1414-100-403-601-17032
二十三针多针机	ZJ1414-100-403-601-23032
二十五针多针机	ZJ1414-100-403-601-25048
三十三针特殊多针机	ZJ1414-100-403-601-33048
三十三针特殊多针机	ZJ1414-100-403-601-614-33048

1、型号补充说明：601代表后拖轮、603代表前送料轮、609代表门襟拉筒、611代表橡筋送料盘612代表贴条装置、613代表折布车缝、613代表折布车缝、614代表花样打拦车、615代表单根橡筋车、616代表底线橡筋。

单位/UNIT : MM

所有尺寸公差 / DIFFERENCE : ±2



1. 搬运作业

- (1) 使用全罩二片式的保丽龙将机器包装防护。
- (2) 放入纸箱内。
- (3) 用手推车或二人用双手抬动搬运。

2. 储存作业

- (1) 机器不使用时, 应用防尘盖将其罩上。
- (2) 避免储存于高于45℃以上的高温。

3. 作业中

机器不要在高于40℃以上的温度工作。

4. 警告

在贴有警告标示之处请注意。

1. 机械动作部分, 请注意装上保护装置。

2. 穿线、换线、调整、清洁时请注意关闭电源。

1. Transportation

- (1) The machine packed with two piece covers that made of expanded polystyrene to protect it.
- (2) Put the machine into a carton.
- (3) Use a cart or by two men's hands to move it.

2. Storage

- (1) The machine must use duster-cover to cover it when it did not work.
- (2) The machine avoid to storage in the temperature more than 45℃

3. Working

Pay attention to this warning advice as follow:

- a. Working area is dangerous.
- b. Never touch the needle if the machine is still running.
- c. Be careful if you infeed fabric.
- d. Do not insert your finger between needle and roller for transportation on fabric.

Pay attention to this warning sticker:

- a. Movable parts must be enclosed with guard when you operate.
- b. Pull out the plug from socket when you adjust, thread, change bobbin and needle clean.

规格件表 · CONVERSION CHART

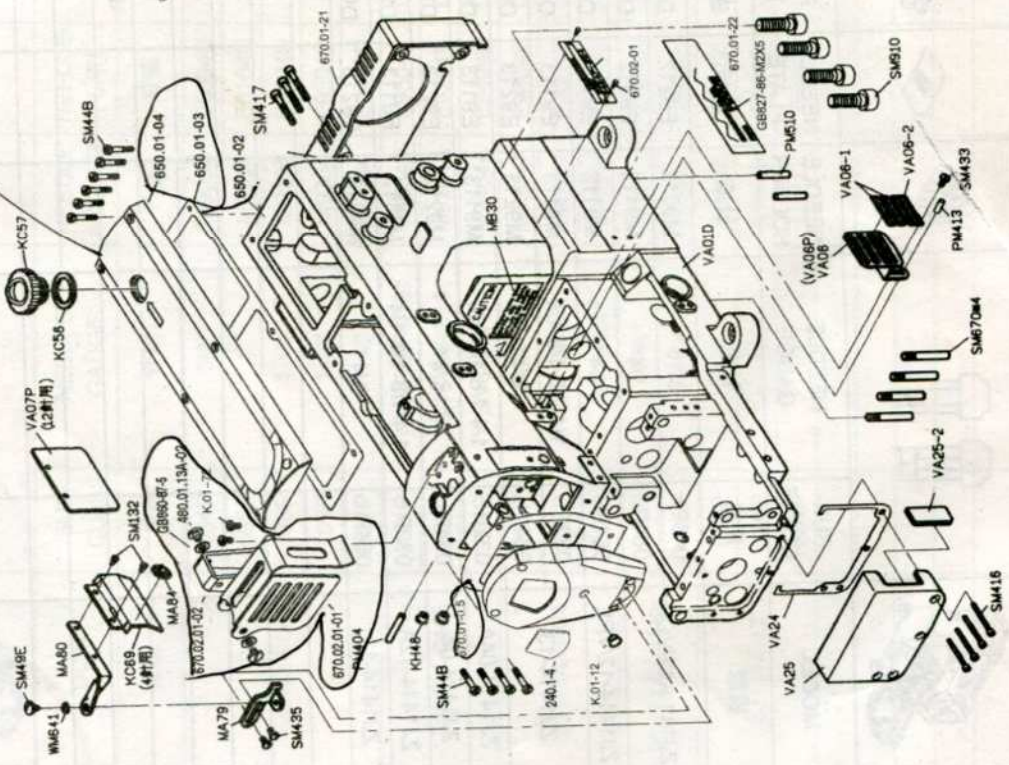
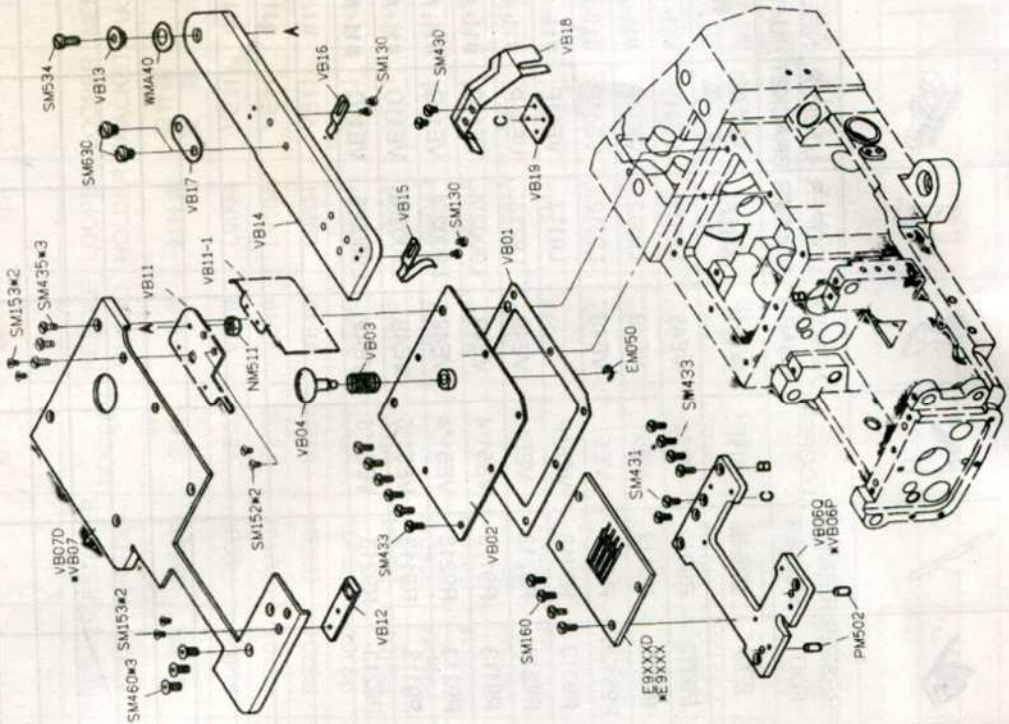
MODEL	SUB-CLASS	NEEDLE GAUGE	NEEDLE HOLDER	NEEDLE PLATE	FEED DOG	PRESSER FOOT	RETAINER HOLDER	LOOPER	NEEDLE GUARD	LOOPER HOLDER	LOOPER BRACKET	NEEDLE
模型	规格	针距	针座	针板	送料牙	压脚	拔线轴	勾针	护针片	勾针座	勾针座架	针
ZJ1414-04	064P	3/4"	M9004	E6004D	D9004	P9004	R9004	VE51	VE49	L9004	VE11	#11-#14
	085P	1"	M9104	E6104D	D9104	P9104	R9104	VE51	VE49	L9104	VE11	#11-#14
	095P	1-1/8"	M9204	E9204D	D9204	P9204	R9204	VE51	VE49	L9204	VE11	#11-#14
	106P	1-1/4"	M9304	E9304D	D9304	P9304	R9304	VE51	VE49	L9304	VE11	#11-#14
	127P	1-1/2"	M9404	E9404D	D9404	P9404	R9404	VE51	VE49	L9404	VE11	#11-#14
	191P	3/16-3/4-3/16"	M9504A	E9504E	D9504A	P9504A	R9504A	VE51	VE49	L9504A	VE11	#11-#14
ZJ1414-0448	222P	3/16-7/8-3/16"	M9204A	E9204E	D9204A	P9204A	R9204A	VE51	VE49	L9204A	VE11	#11-#14
	254P	3/16-1-3/16"	M9404A	E9404E	D9404A	P9404A	R9404A	VE51	VE49	L9404A	VE11	#11-#14
	191P	1/4-3/4-1/4"	M9304A	E9304E	D9304A	P9304A	R9304A	VE51	VE49	L9304A	VE11	#11-#14
	127P	1/4-1/2-1/4"	M9004A	E9004E	D9004A	P9004A	R9004A	VE51	VE49	L9004A	VE11	#11-#14
ZJ1414-0464	254P	1/4-1-1/4"	M9104A	E9104E	D9104A	P9104A	R9104A	VE51	VE49	L9104A	VE11	#11-#14
	048P	3/16"	M9012	E9012	D9012	P9412	R9012	VE51	VE49	L9012	VE11P	#11-#14P
	064P	1/4"	M9112	E9112	D9112	P9512 P9512A	R9112	VE51	VE49	L9112	VE11P	#11-#14P
	048P	3/16"	M9012	E9012	D9012	P9012	R9012	VE51	VE49	L9012	VE11P	#11-#14P
ZJ1414-12	050P	5mm	M9612	E9612	D9612	P9612	R9612	VE51	VE49	L9612	VE11P	#11-#14P
	064P	1/4"	M9112	E9112	D9112	P9112	R9112	VE51	VE49	L9112	VE11P	#11-#14P

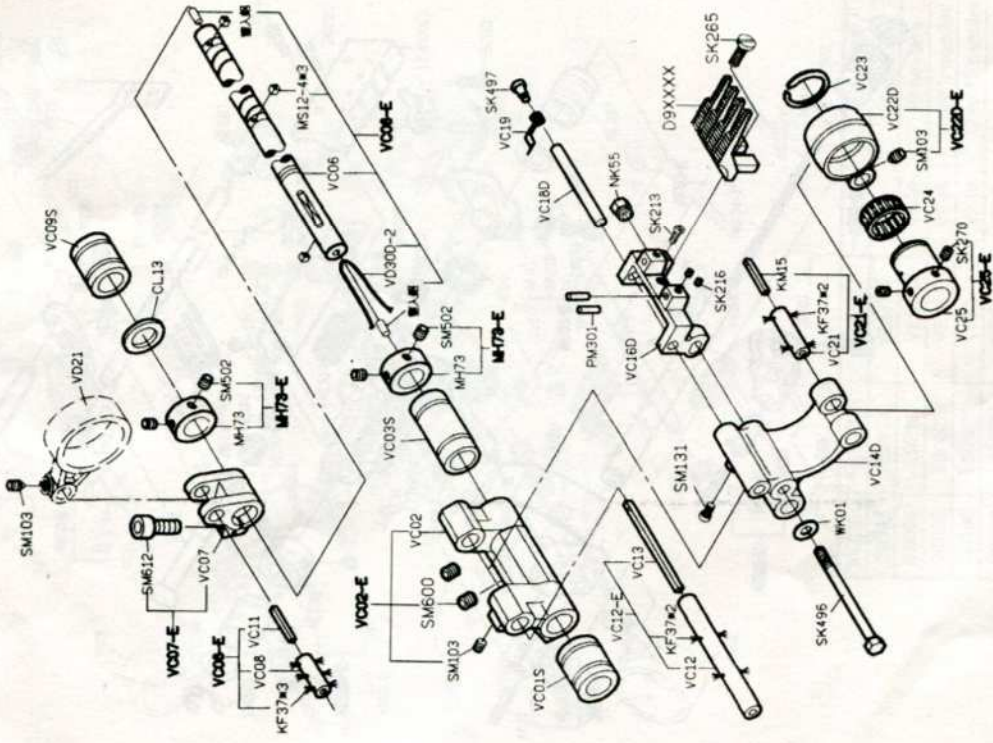
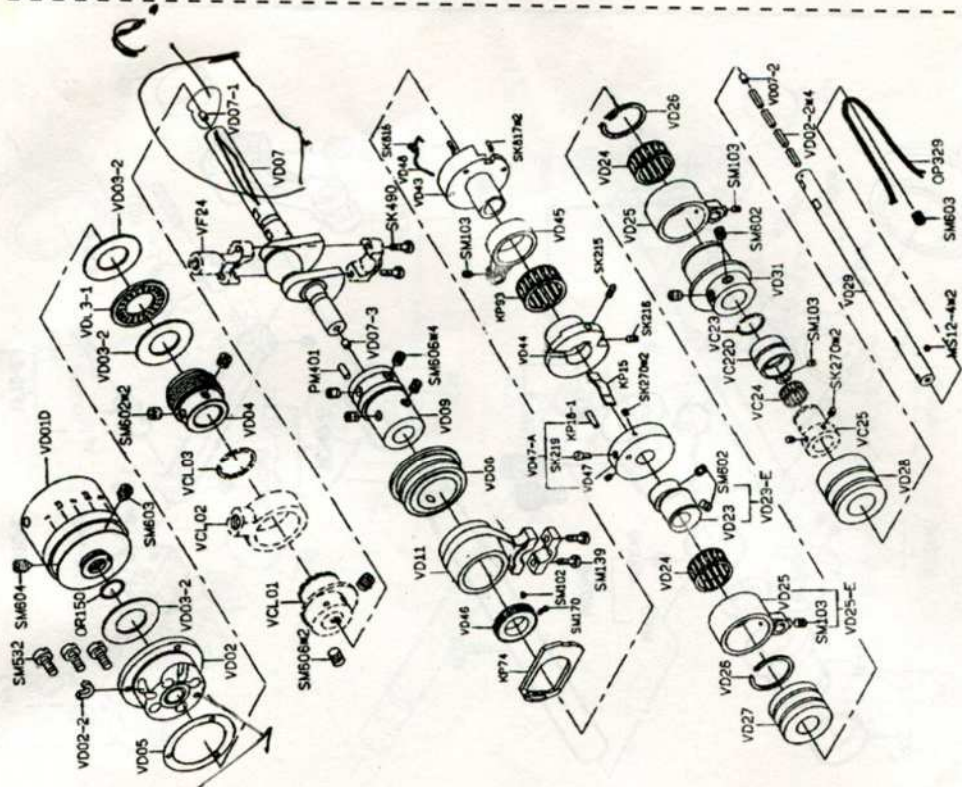
规格件表 · CONVERSION CHART

MODEL	SUB-CLASS	NEEDLE GAUGE	NEEDLE HOLDER	NEEDLE PLATE	FEED DOG	PRESSER FOOT	RETAINER HOLDER	LOOPER	NEEDLE GUARD	LOOPER HOLDER	LOOPER BRACKET	NEEDLE
模型	规格	针距	针座	针板	送料牙	压脚	拔线轴	勾针	护针片	勾针座	勾针座支架	针
ZJ1414-12/VQP	048P	3/16"	M9012	E9212	D9012	P9212	R9012	VE51	VE49	L9012	VE11P	#11-#14
	064P	1/4"	M9112	E9312	D9312	P9312	R9112	VE51	VE49	L9112	VE11P	#11-#14
ZJ1414-12/VPL	064P	1/4"	M9112	E9112	D9112	P9512B	R9112	VE51	VE49	L9112	VE11P	#11-#14
ZJ1414-13	032P	1/4-1/8-1/8-1/4"	M9113	E9113	D9113	P9113	R9113	VE51P		L9113	VE11P	#11-#14
	064P	1/4"	M9213	E9213	D9213	P9213	R9213	VE51	VE49	L9213	VE11P	#11-#14
ZJ1414-04A	032P	1/4-1/8-1/8-1/4"	M9113	E9113	D9113	P9113	R9113	VE51*4	VE49	L9002*4	VE11Q	#11-#14
ZJ1414-04	064P	1/4"	M9213	E9213	D9213	P9213	R9213	VE51*4	VE49	L9002*4	VE11Q	#11-#14
ZJ1414-12A	032P	1/4-1/8-1/8-1/4"	M9113	E9113	D9113	P9113	R9113	VE51*6	VE49	L9002*6	VE11Q	#11-#14
ZJ1414-12	064P	1/4"	M9213	E9213	D9213	P9213	R9213	VE51*6	VE49	L9002*6	VE11Q	#11-#14

PARTS LIST FOR VB GROUP

PARTS LIST FOR VA GROUP

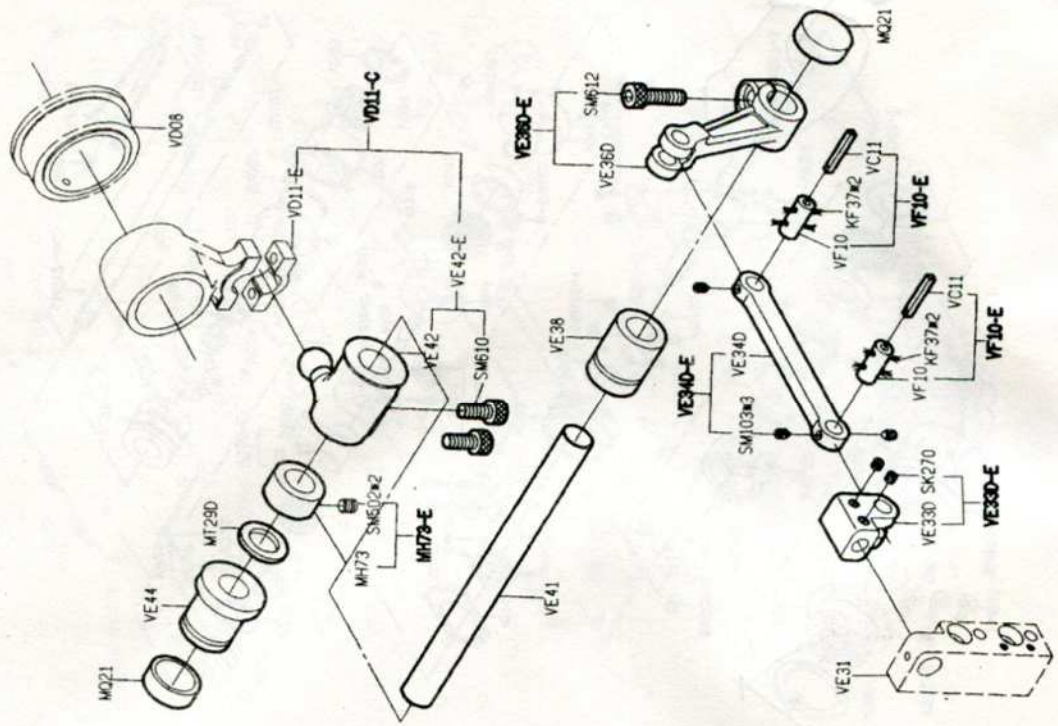




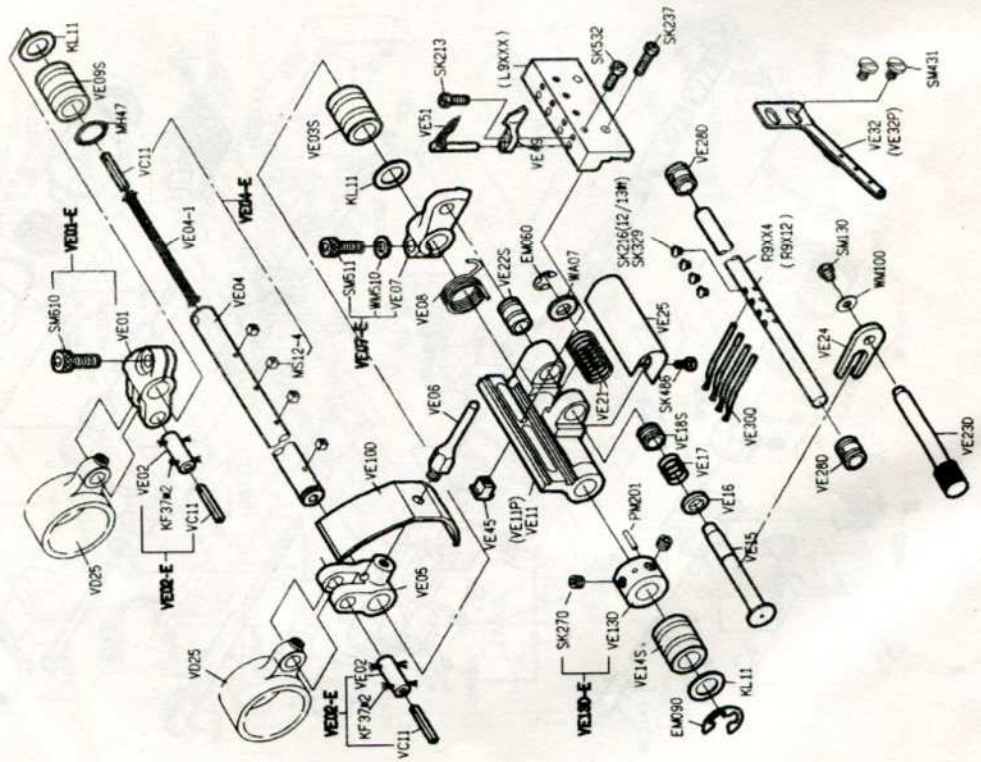
PARTS LIST FOR VD GROUP

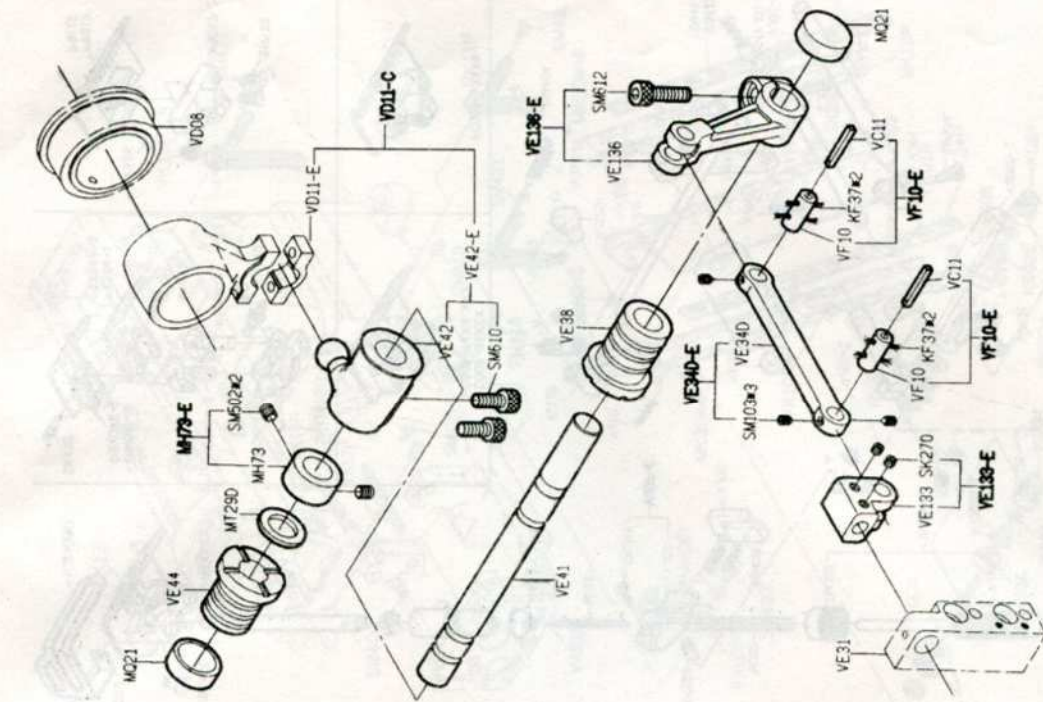
PARTS LIST FOR VC GROUP

PARTS LIST FOR VE(2) GROUP

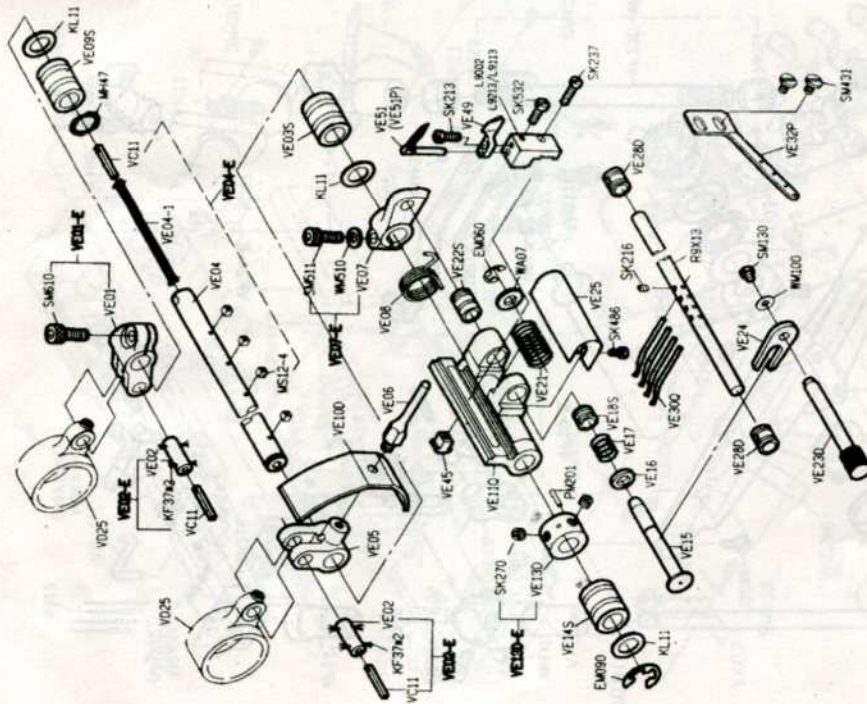


PARTS LIST FOR VE(1) GROUP



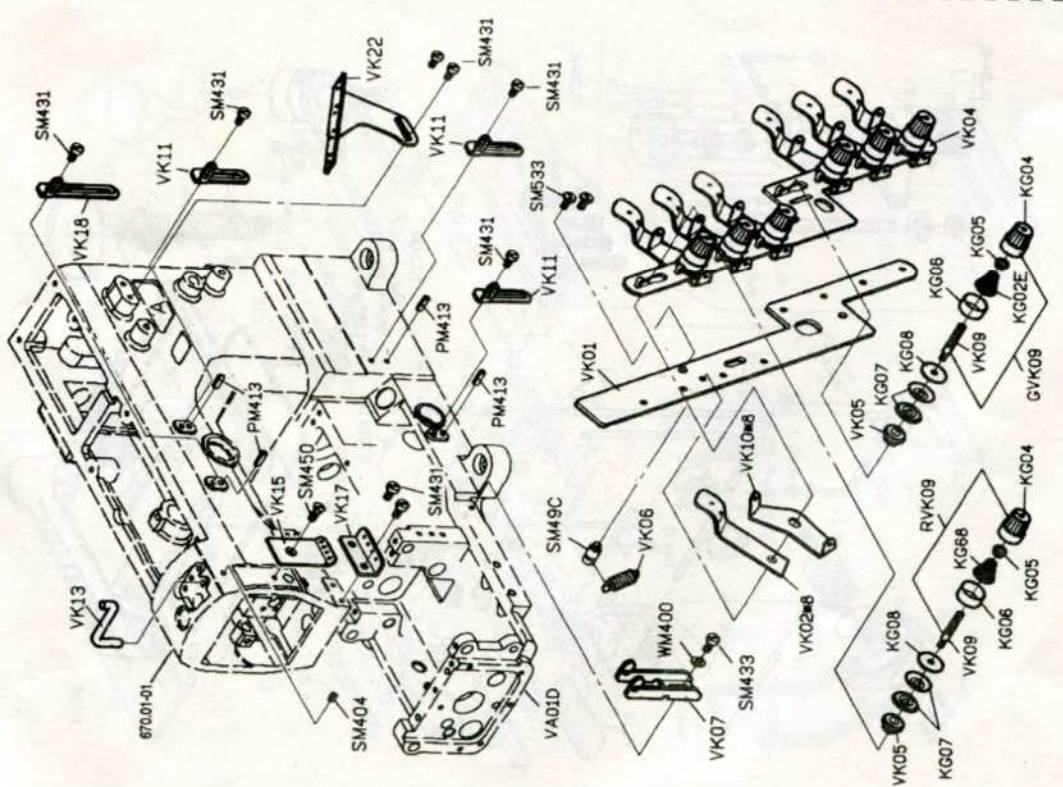


PARTS LIST FOR VE(4) GROUP - 13 Needles

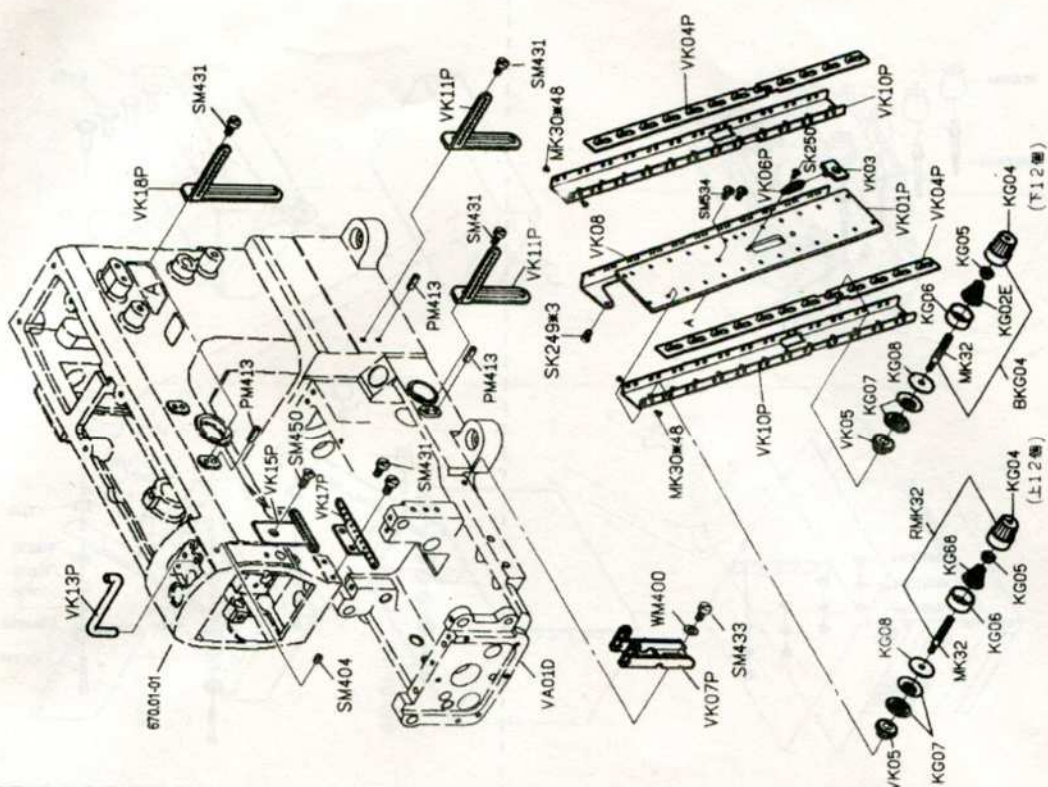


MODEL	HOLDER	LOOPER	GUARD	REMARK
13032	L9113	VE51P	X	13 needles
13064	L9213	VE51	VE49	13 needles
04A32	L9002*4	VE51	VE49	4 to 13 needles
12A32	L9002*6	VE51	VE49	12 to 13 needles
04A64	L9002*4	VE51	VE49	4 to 13 needles
12A64	L9002*6	VE51	VE49	12 to 13 needles

PARTS LIST FOR VE(3) GROUP - 13 Needles

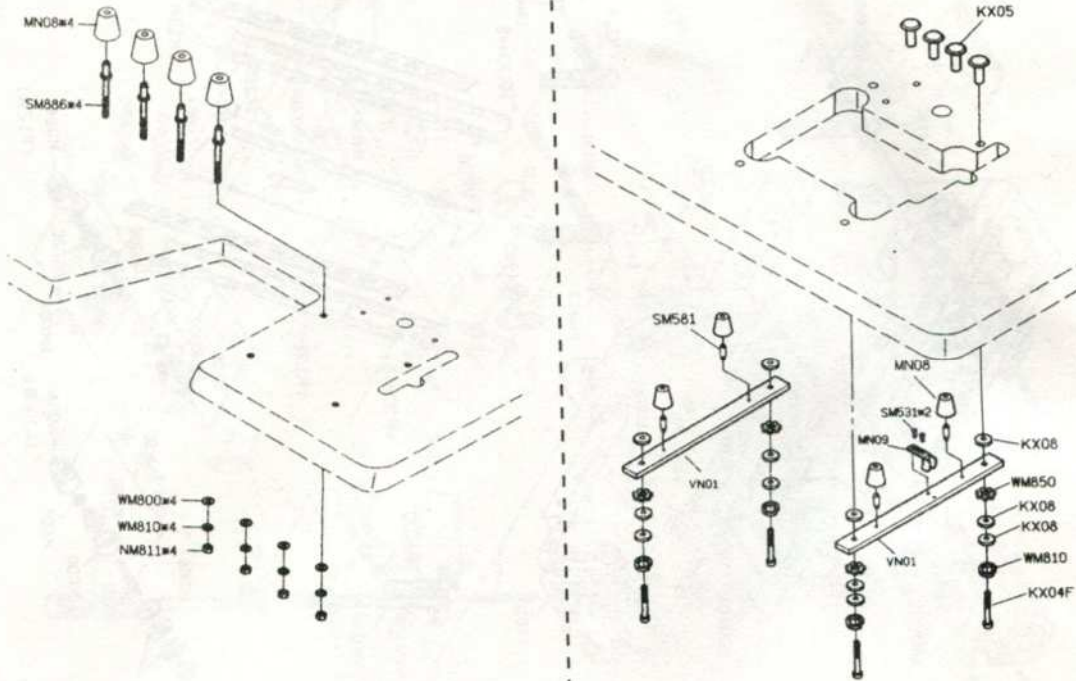


PARTS LIST FOR VK(1) GROUP . 4 Needles

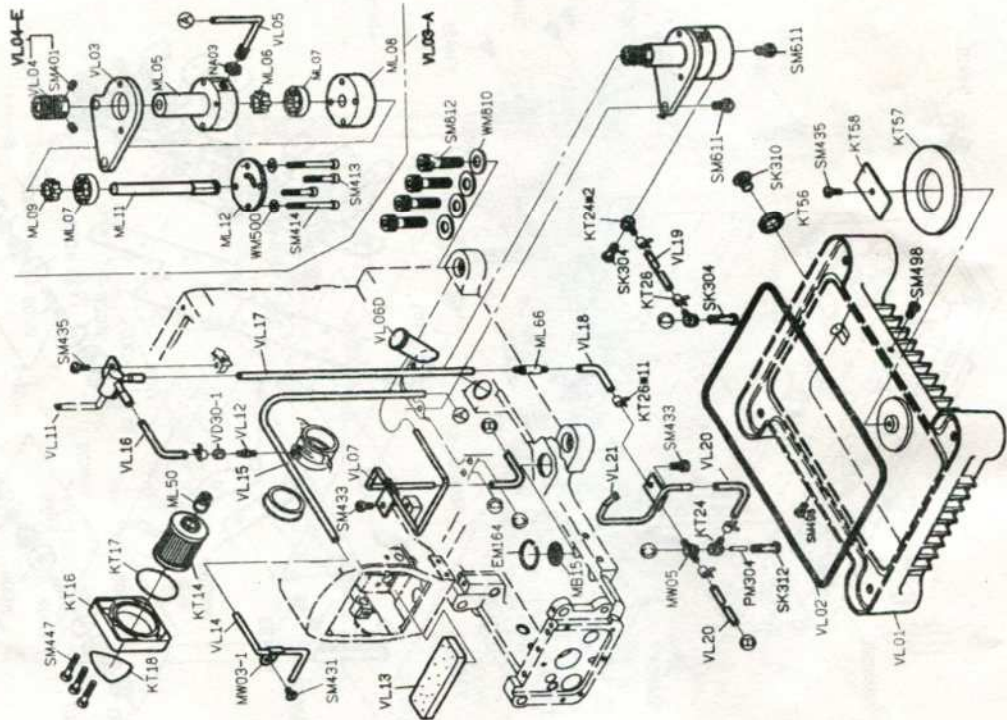


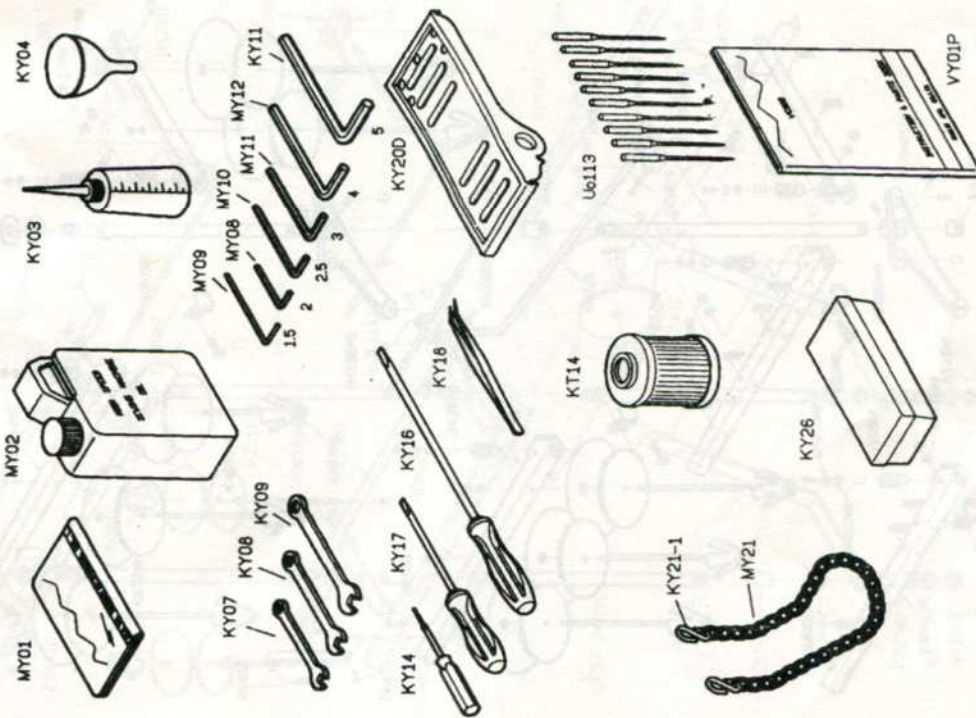
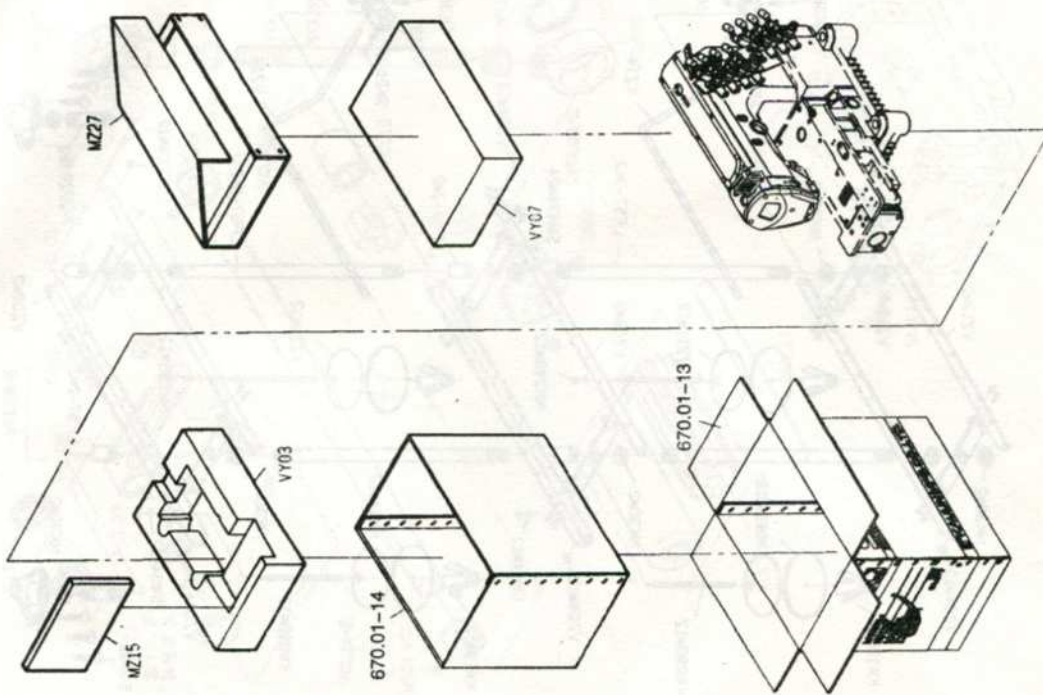
PARTS LIST FOR VK(2) GROUP . 12 Needles

PARTS LIST FOR VN GROUP



PARTS LIST FOR VL GROUP



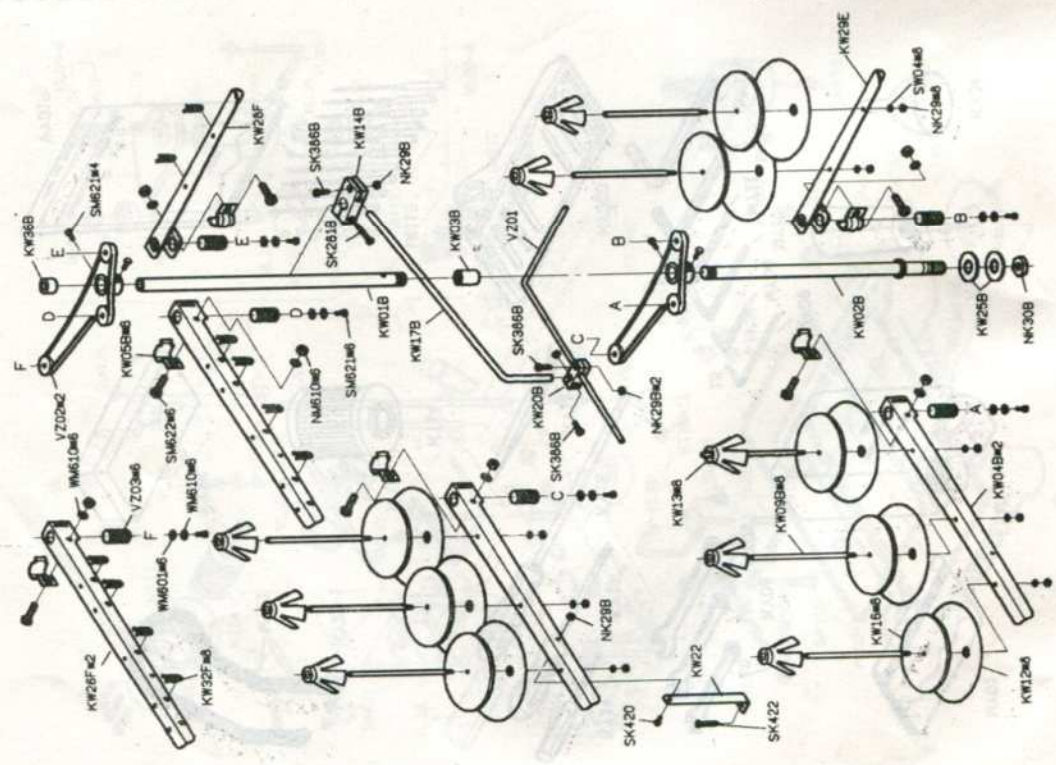
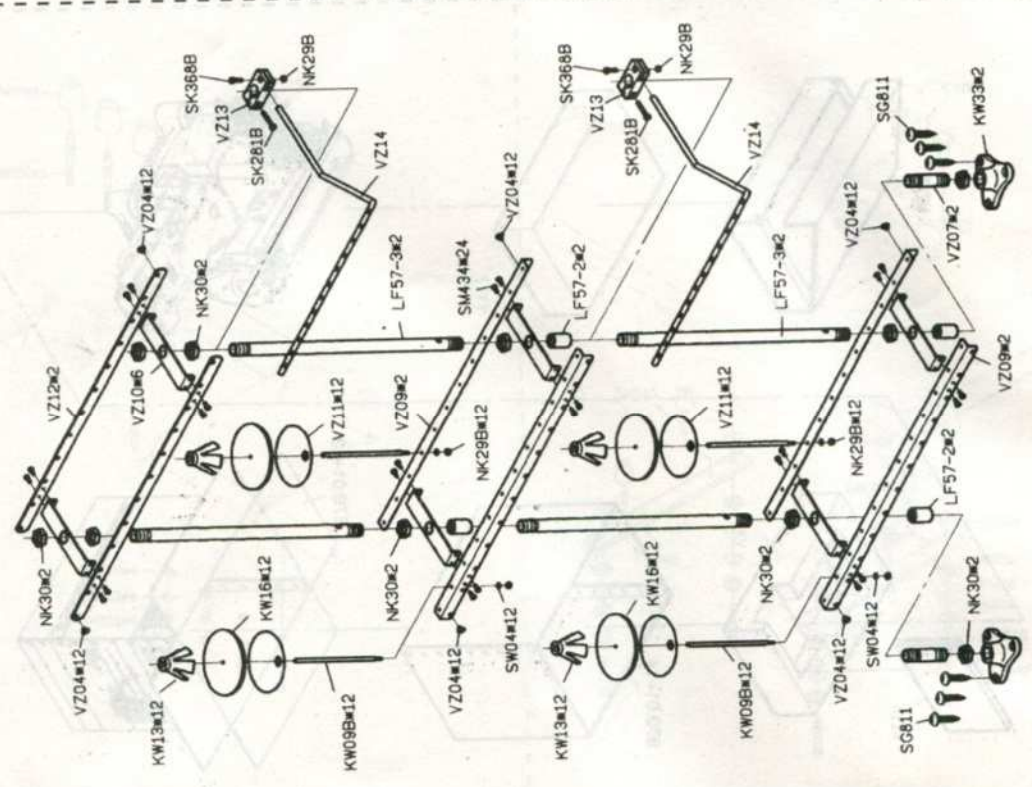


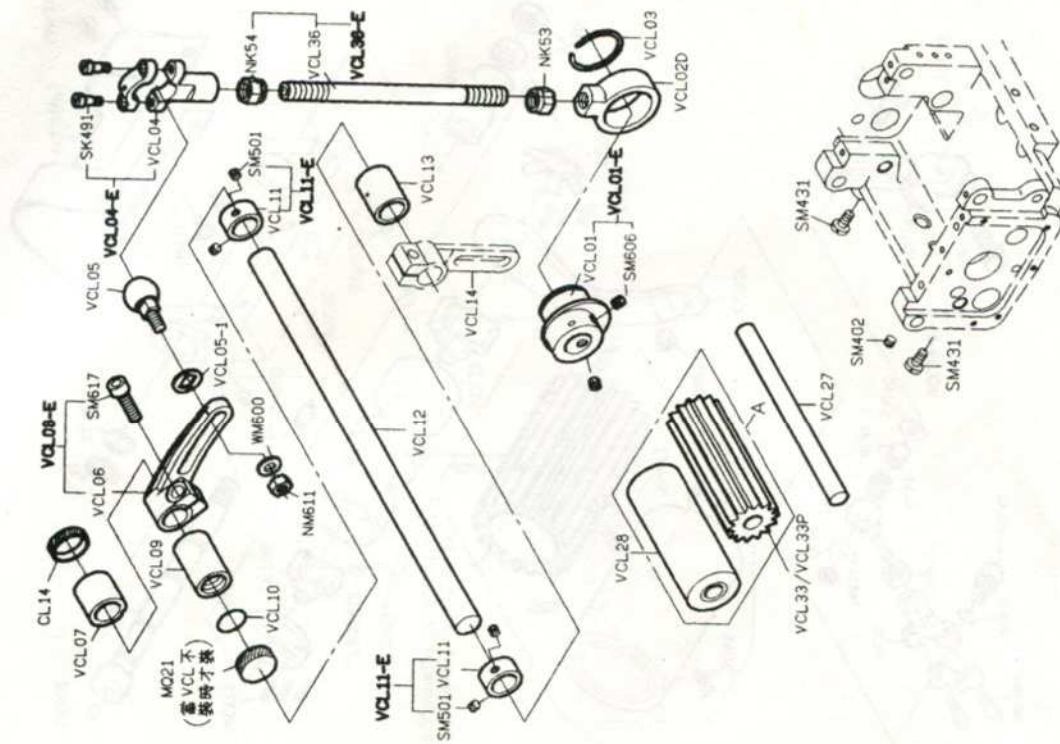
PARTS LIST FOR VY(2) GROUP - 12 Needles

PARTS LIST FOR VY(1) GROUP - 4 Needles

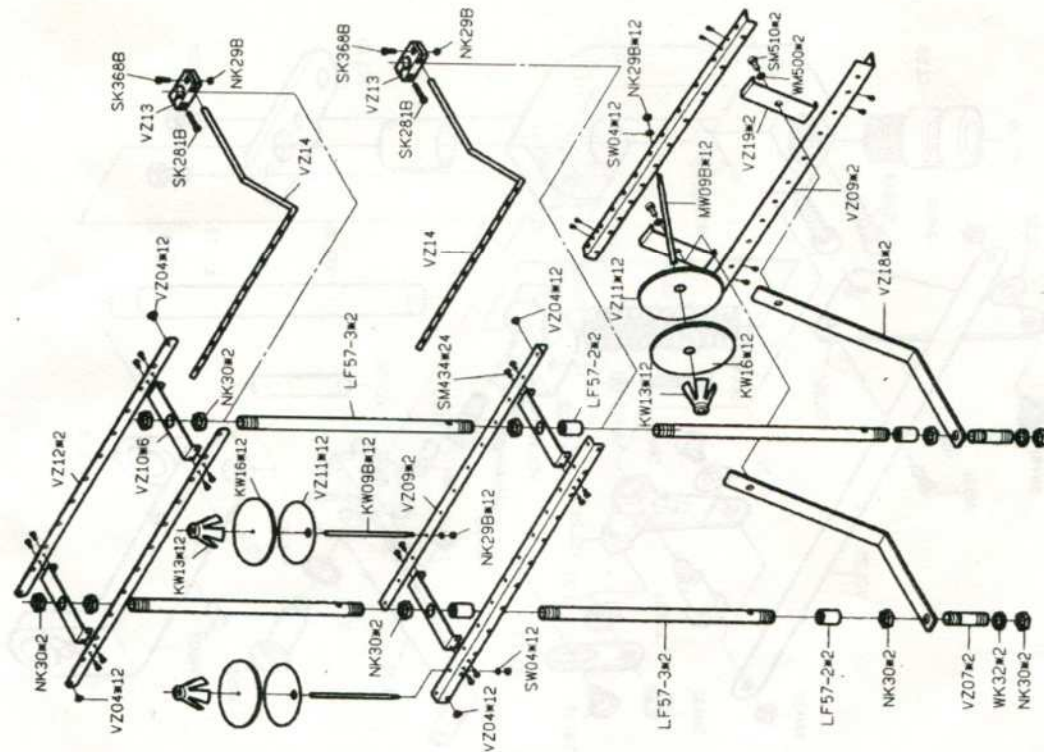
PARTS LIST FOR VZ(2) GROUP - 12 Needles

PARTS LIST FOR VZ(1) GROUP - 4 Needles



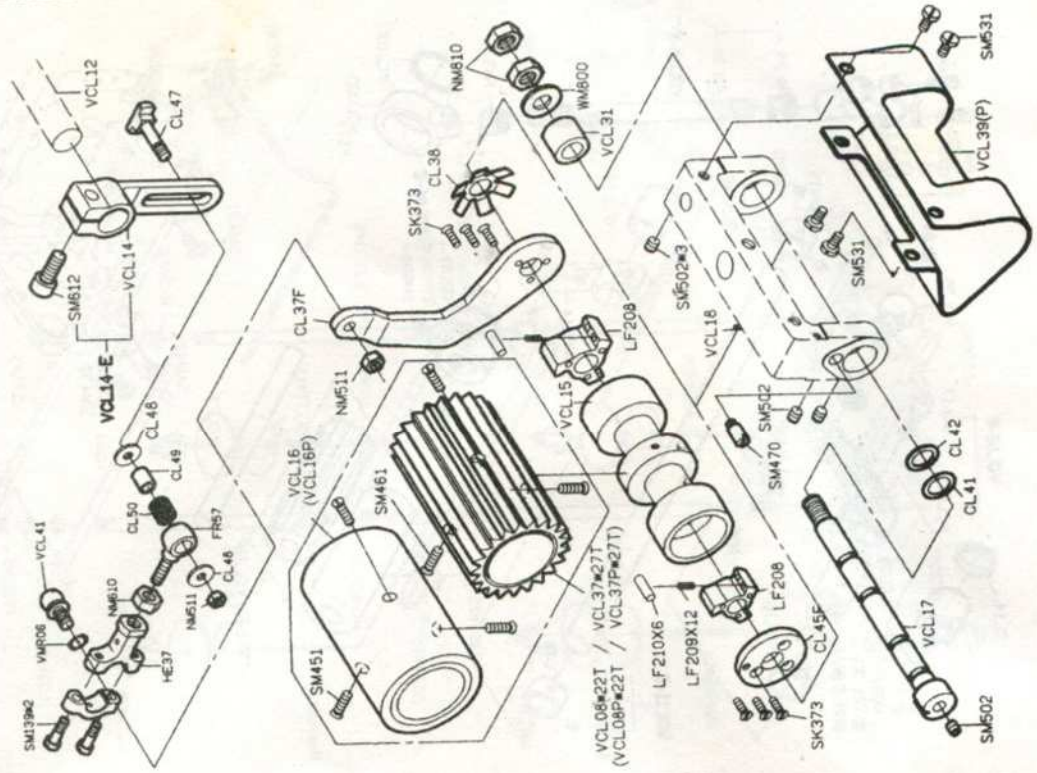


PARTS LIST FOR VCL(1) GROUP

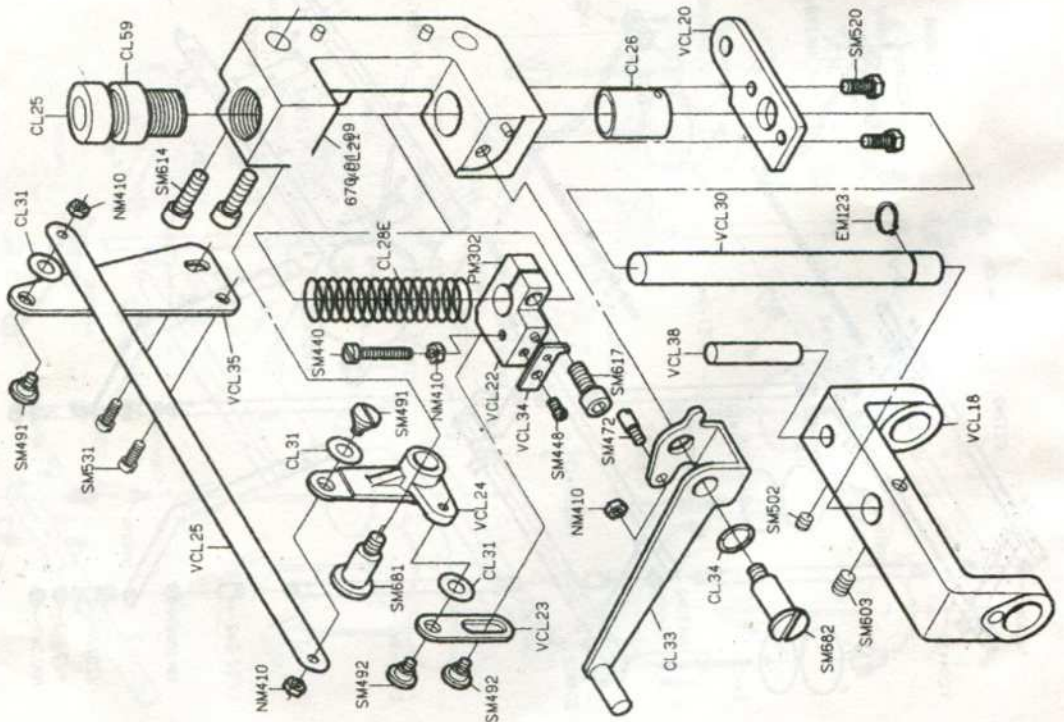


PARTS LIST FOR VZ(3) GROUP - VPK

PARTS LIST FOR VCL(4) GROUP



PARTS LIST FOR VCL(2) GROUP





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