

YULUN[®]

使用說明與零件圖

INSTRUCTION & MAINTENANCE BOOK

475A-705-M
475A-725-M
475A-735-N



475A-706-M
475A-726-M
475A-736-M

ZIGZAG INDUSTRIAL SEWING MACHINE

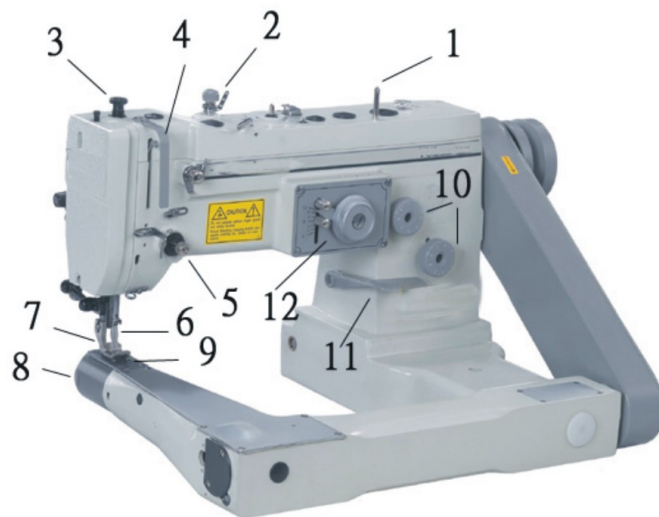
INSTRUCTION MANUEL

PARTS LIST



HOW TO USE MACHINE

1



(Fig.1)

NAMES OF MAIN PARTS

1. Spool pin
2. Thread guide
3. Pressure regulator
4. Take-up lever
5. Tension regulator
6. Needle Bar
7. Presser foot
8. Arm end cap
9. Needle plate
10. Zigzag width regulator

DESCRIPTION:

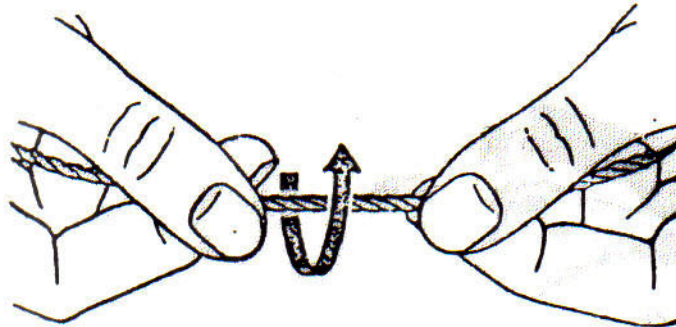
Model is a universal zigzag and straight stitch feed-off-the-Arm sewing machine with a rotary hook producing a lockstitch.

NEEDLES

model use standard needles style 135x5.

THREAD

left twist thread should be used in the needle. Either right or left twist thread can be used in the bobbin.



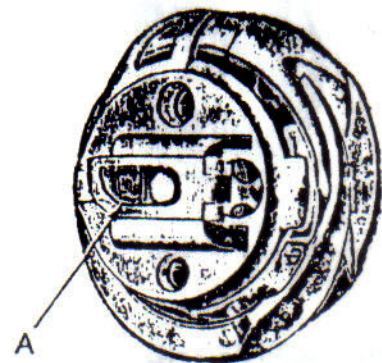
(Fig. 2)

HOW TO DETERMINE THE TWIST OF THE THREAD

Hold the thread as shown above, twist it between the thumb and fore-finger of your hands. If left twist, the strands will wind tighter. If right twist, the strands will unwind.

REMOVING THE BOBBIN CASE

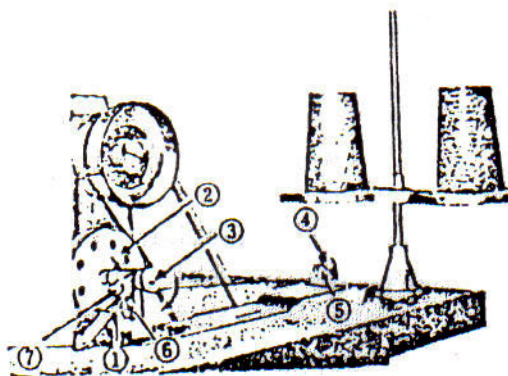
1. Raise the needle bar to its highest point by turning the hand wheel toward you by hand.
2. Pull arm end cap toward rear of machine.
3. With left thumb and fore-finger placed under the bed, open the hinged latch(A) at the front of the bobbin case and by means of this latch remove the bobbin case from the sewing hook.
4. The bobbin falls out of the bobbin case into your hand when you close the bobbin case latch(A)



(Fig. 3)

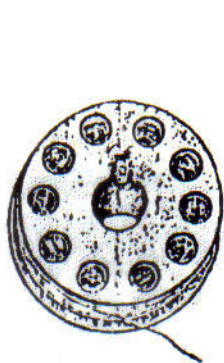
WINDING THE BOBBIN

1. Place the bobbin (3) on winder spindle.
2. Pass the thread through the hole (4) of the bobbin winder thread guide and through the tension discs (5) from the rear.
3. Pull the end of the thread and wind it around the empty bobbin seven or eight times from the bottom up as shown by the arrow in (fig. 4.)

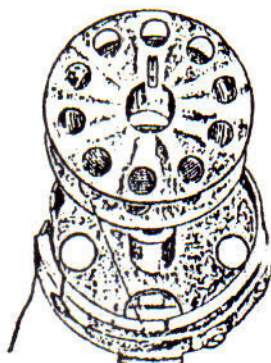


(Fig. 4)

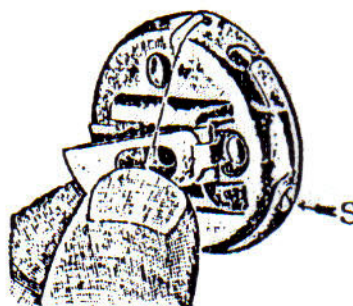
4. Push the bobbin winder lever (1) down until the bobbin winder wheel (2) presses against the drive belt.
5. Start the machine and the thread will be wound up on the bobbin. When the bobbin is full, it will release automatically and stop turning.
6. Cut off the thread and remove the bobbin from the spindle.
7. You can easily adjust the maximum quantity of thread to be wound up on the bobbin by adjusting the screw (7) which controls latch (6).
8. If the thread does not wind evenly on the bobbin, adjust the position of the bobbin winder thread guide (4) by moving it to the right or left after loosening the screw.
9. Loosen the tension for fine thread by by turning the nut in counter-clockwise direction.



(Fig. 5-A)



(Fig. 5-B)



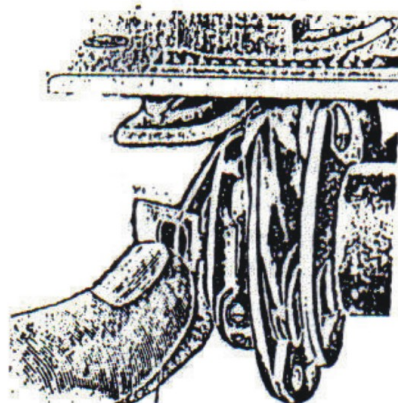
(Fig. 5-C)

THREADING THE BOBBIN CASE

1. Hold the bobbin case between the left thumb and fore-finger as shown above. With about 2 inches of thread trailing, hold the bobbin between the thumb and first two fingers of the right hand as shown in Fig. 5A.
2. Insert the bobbin into bobbin case and pull the trailing thread into the slot, down and to the left, until it enters the grooved eye under the tension spring Fig. 5B, 5C.

INSERTING THE BOBBIN CASE

1. Raise the needle bar to its highest point by turning the hand wheel toward you by hand.
2. After sliding out the arm end cap, hold the bobbin case latch with left thumb and fore-finger to prevent the bobbin from falling out.
3. Press the bobbin case into the post on rotating loop taker until the protruding finger on the bobbin case enters the notch. Push the latch closed until an audible click can be discerned.



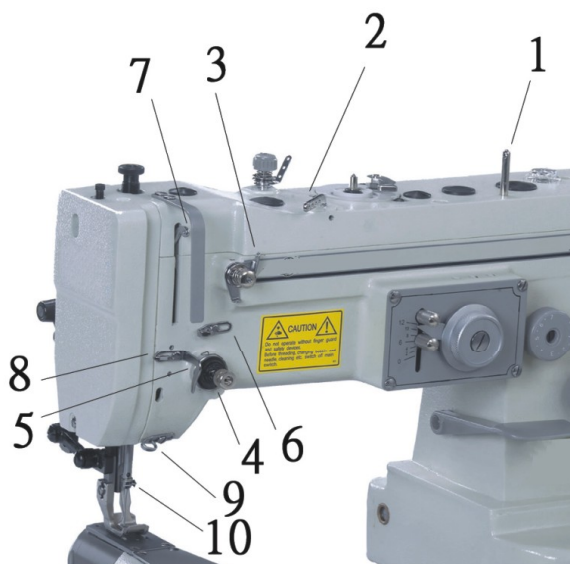
(Fig. 6)

Note:

Be sure that the protruding finger enters the notch properly and in correct position.

THREADING THE MACHINE

1. Raise the thread take-up lever (7) to its highest position by turning the hand wheel toward you.
2. Lead the thread through the hole (1) of the spool pin and the three-hole thread guide (2).
3. Run the thread beneath and around the tension discs (3) from right to left.
4. Bring the thread over the loop of the check spring (4) and down again under the retaining hook (5) from right to left.



(Fig. 7)

5. Draw thread upward toward take-up lever (7) and passing through guide (6) on the way and through the eye at its tip from right to left.
6. Now run the thread down through the thread guides (8) and (9).
7. Lead the thread through the needle bar thread guide (10).
8. Now run the end of the thread through the eye of the needle from front to back, drawing it out about 2 inches.

PREPARATION FOR SEWING

1. Thread the machine.
2. Holding the loose end of the needle thread in your left hand, turn the hand wheel toward you with your right hand until the needle moves down and up again in its highest position.
3. Pull the needle thread gently and the bobbin thread will come up with it through the needle hole in the needle plate.
4. Place both ends of thread beneath and in back of the presser foot.
5. With the needle raised, place the material to be sewn beneath the presser foot and fully lower the presser foot lifter lever.
6. Start sewing.



(Fig. 8)



(Fig. 9-A)



(Fig. 9-B)



(Fig. 9-C)

TENSION

For perfect stitching, the tension of the upper and lower threads should be balanced and just sufficiently tight to lock both threads in the center of the material (Fig. 9-A).

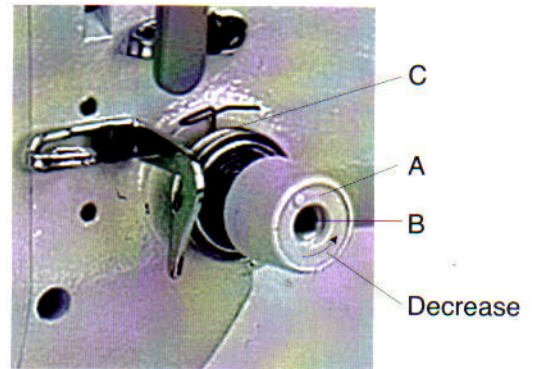
If the tension of the needle thread is too tight, or if that of the bobbin thread is too loose, the needle thread will lie straight along the upper surface of the material, making an imperfect stitch (Fig. 9-B)

If the tension of the bobbin thread is too tight, or if that on the needle thread is too loose, the bobbin thread will lie straight along the underside of the material, also making an imperfect stitch (Fig. 9-C).

REGULATING THE TENSIONS

1. Needle thread tension (Fig. 9-D)

- (A). The tension is increased as the tension nut (A) is turned clock-wise and it is decreased as the nut is turned counter-clockwise.
- (B). The check spring (C) gets more tight as the tension stud(B) is turned clockwise with a screw driver, and the check spring gets more loose as the tension stud is turned counter-clockwise.
- (C). The machine is correctly adjusted before leaving the factory to make a perfect stitch.



(Fig. 9-D)

Note:

All tension adjustment must be made while the presser foot is down.

2. Bobbin thread tension.

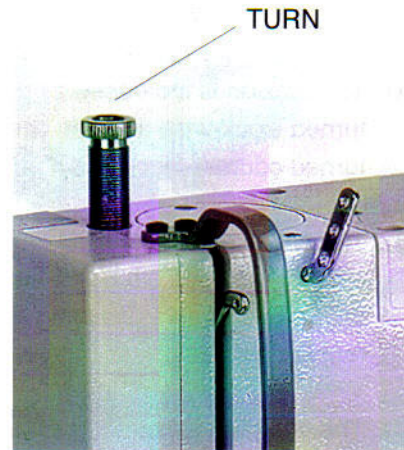
- (A). Ordinarily, a perfect stitch can be obtained by varying the tension of the needle thread only. However, it is sometimes necessary to adjust the bobbin thread tension.
- (B). This tension may be increased by turning the tension screw (S) on the bobbin case to the right and decreased by turning screw to the left. (See Fig. 5-C).

REGULATING THE PRESSURE OF THE PRESSER FOOT

The pressure of the presser foot should be adjusted according to the type of material being sewn. The heavier the material, the heavier the pressure. The lighter the material, the lighter the pressure. The pressure should be only heavy enough to prevent the material from rising with the needle and to enable the feeder to move the work along evenly.

REGULATING THE PRESSURE OF THE PRESSER FOOT (Continued)

The pressure becomes tighter as the regulating thumb screw is turned clockwise, and looser as the thumb screw is turned counter-clockwise. (Fig. 10).



(Fig. 10)

STITCH REGULATOR AND REVERSE SEWING AND TACKING

1. Knurled head screw (A), Fig. 11 controls the stitch length at which the machine operates. To increase stitch length lightly depress lever (L) and turn screw (A) clockwise. Release lever and allow it to come to a stop against the tip of the adjustment screw. Try for results and if further adjustments in stitch length should be desired, turn screw (A) clockwise to further increase to shorten stitch length.
2. For reverse sewing, lower the lever (L) as far as it will go.
3. By moving the lever up and down during sewing, you can easily make forward or reverse stitches continuously and at will, you can make use of this feature for locking the thread at the start or end of sea of seams.

STRAIGHT AND ZIGZAG SEWING

Ascertain that stops (S1) and (S2) (Fig. 12) are set at both extreme ends of their slot. If not, use screwdriver to loosen them about one turn and then tighten them in their extreme positions. Turning the zigzag regulating knob (Z) clockwise as far as it will go, will cause the machine to sew with a straight stitch.

Turning this knob counter-clockwise will produce a zigzag stitch.

Same will become wider the more this knob is turned in counter-clockwise direction.

The widest zigzag stitch is being sewn when knob (Z) cannot be turned any further.

This will occur when the pointer at the under-side of knob (Z) points at the largest number on the dial and is stopped by Stop (S2).



(Fig. 12)

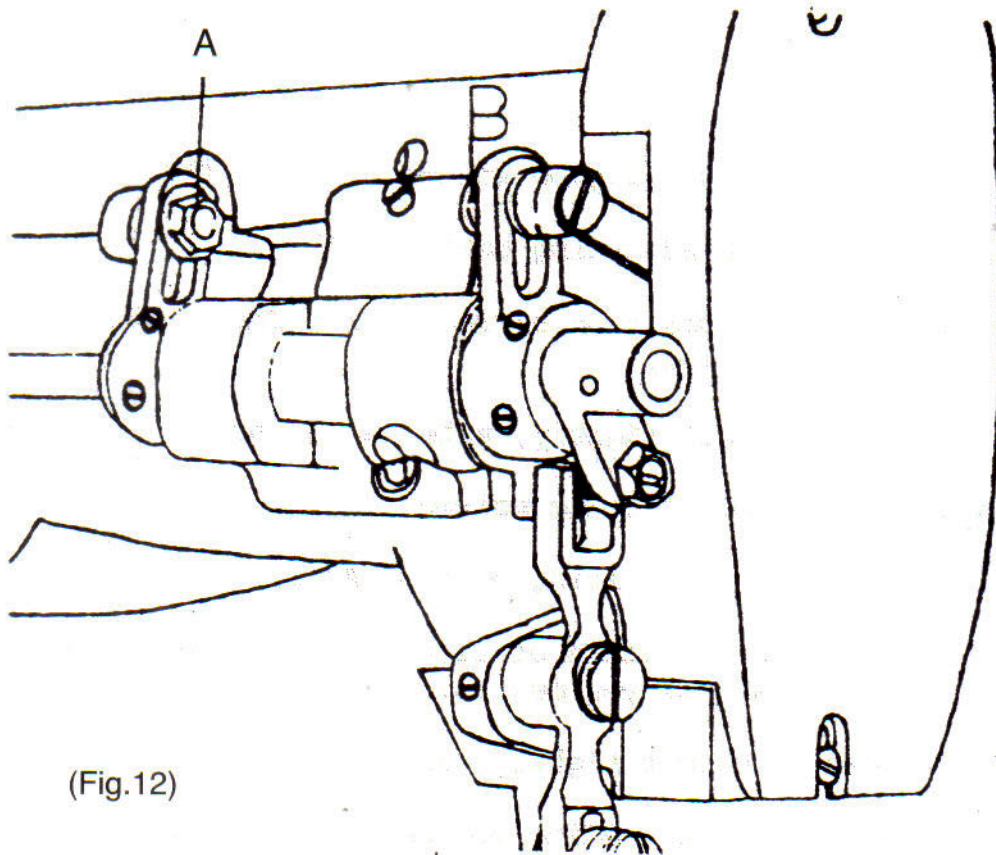
STRAIGHT AND ZIGZAG SEWING (Continued)

When it is desired to control the width of the zigzag between certain minimum and maximum limits between the numbers on the dial, using a screwdriver set stops (S1) and (S2) to the selected widths. Be sure to set stop (S'2) as far downward as possible when a straight stitch is desired.

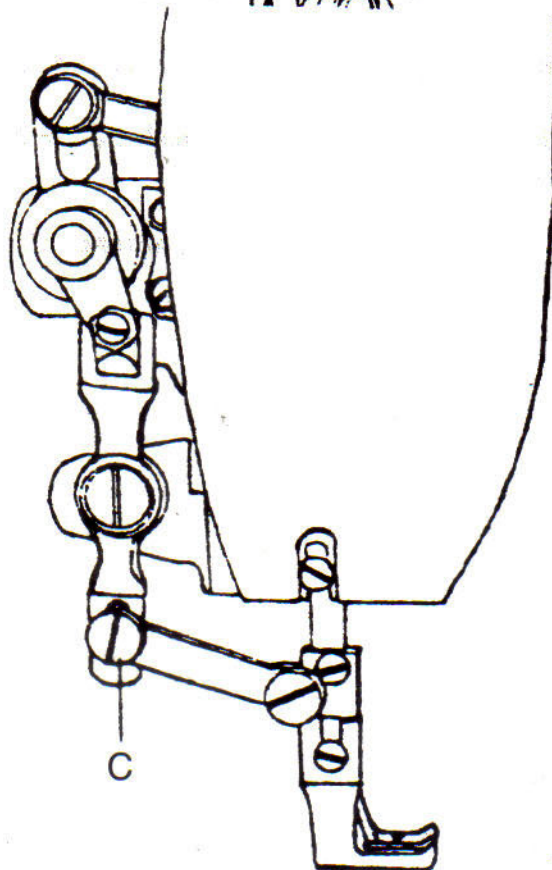
Note:

The zigzag regulating knob can be moved into any desired position while the machine is operating. Do not turn zigzag regulating knob when machine is at rest and needle is in material. Disregarding this advice may have broken or bent needles as a consequence. Turn handwheel toward you to raise needle out of material before operating knob.

ADJUSTMENT OF UPPER FEED MECHANISM



(Fig.12)



ADJUSTMENT OF UPPER FEED MECHANISM. (Ref. Fig.12)
(For the type with upper feed mechanism, 146RB-1A and 146RBL-1A)

A. To increase the lifting volume of outer foot.

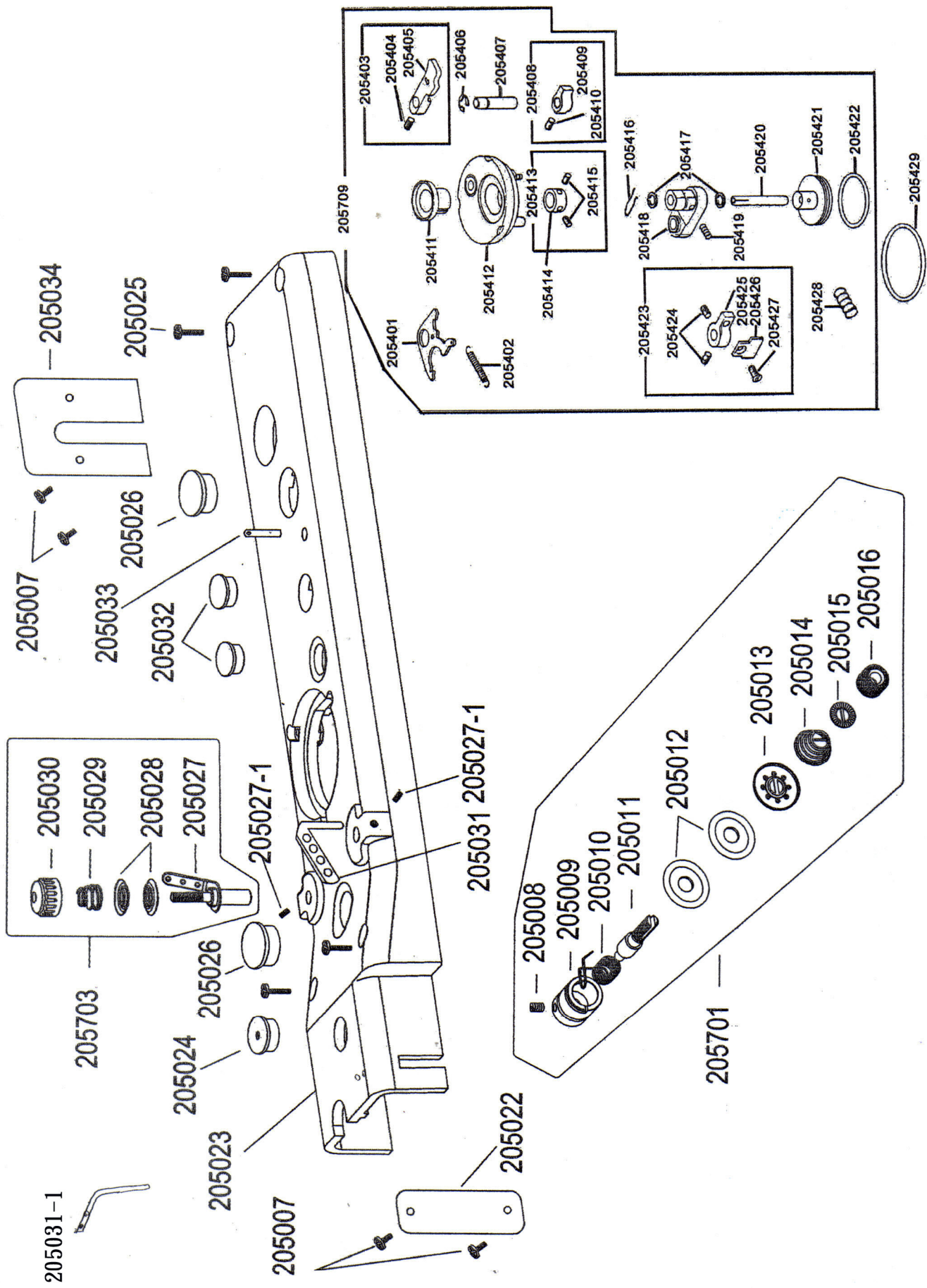
- (1). Loosen the adjusting belt A (#752).
- (2). Raise the position of Rock Shaft crank (#751) as you desire.
- (3). Set the bolt tightly, after adjustment.

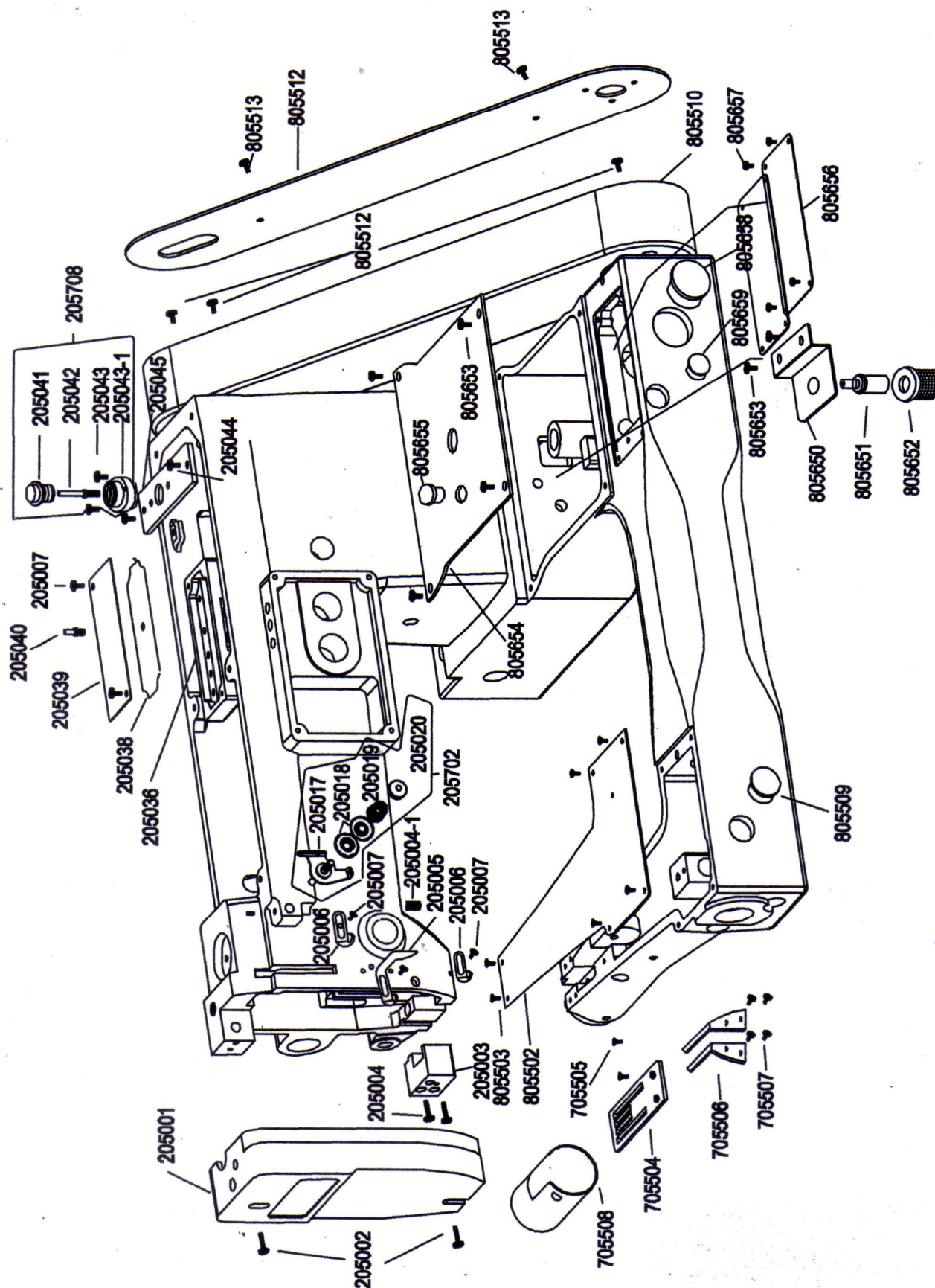
B. To obtain more lifting volume of outer foot.

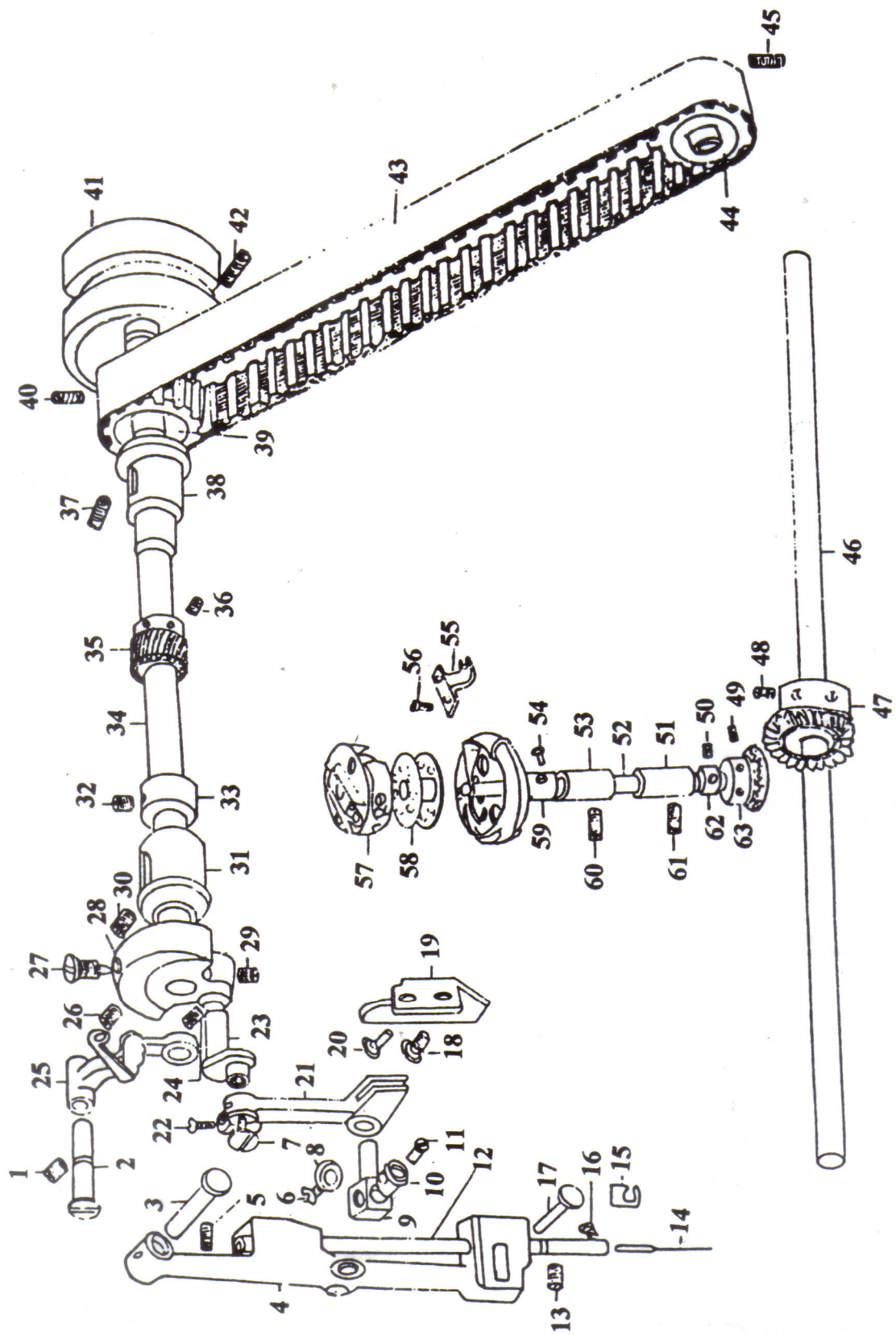
- (1). Loosen the adjusting bolt B (#752)
 - (2). Raise the position of lifting crank connecting line (#748) as you
 - (3). desire.
- Reset the bolt tightly, after adjustment.

C. To increase the feeding volume of order foot.

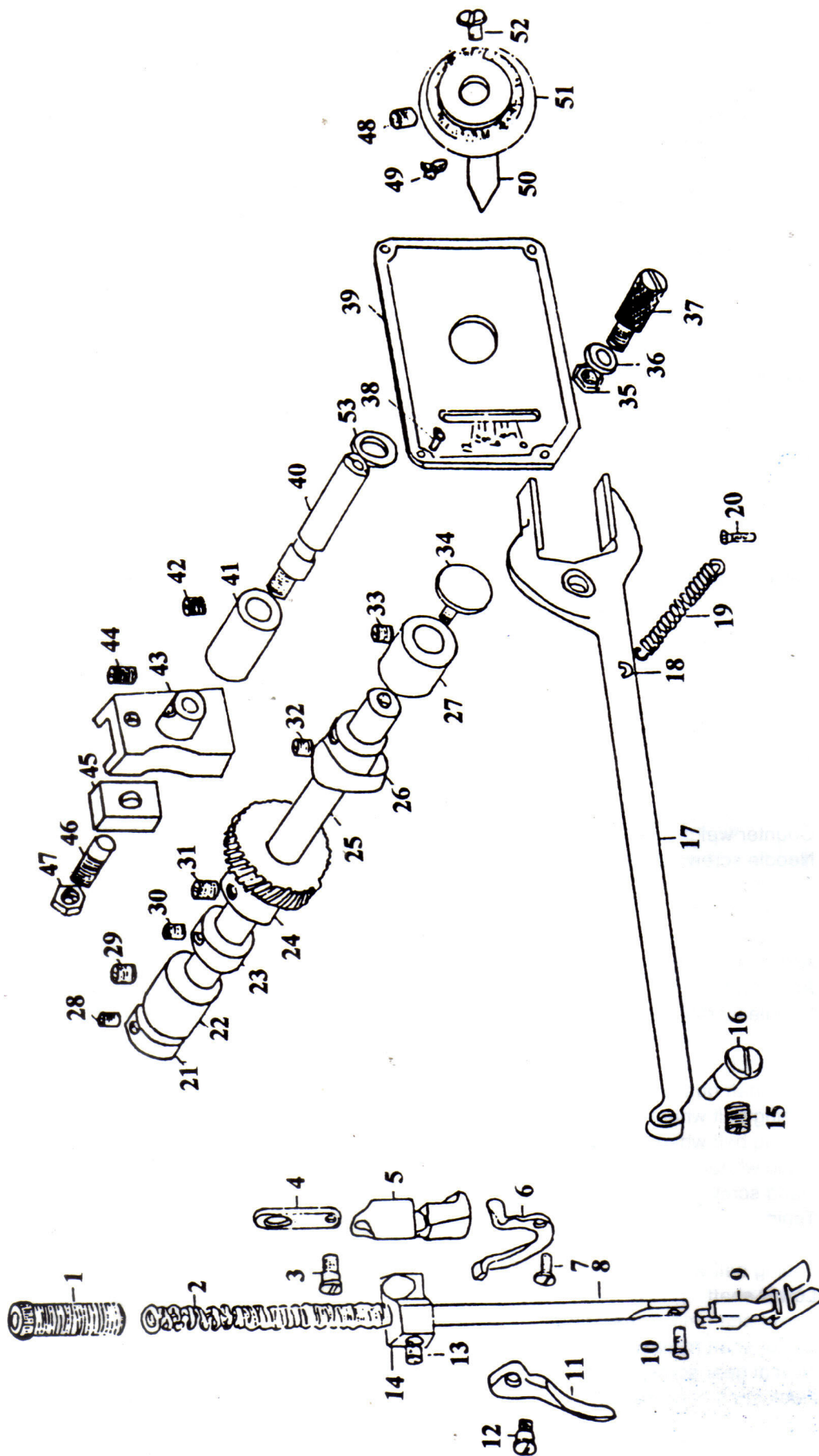
- (1). Loosen the adjusting bolt C. (#733).
- (2). Raise the position of feed correcting link (#732) as you desire.
- (3). Reset the bolt, after adjustment.





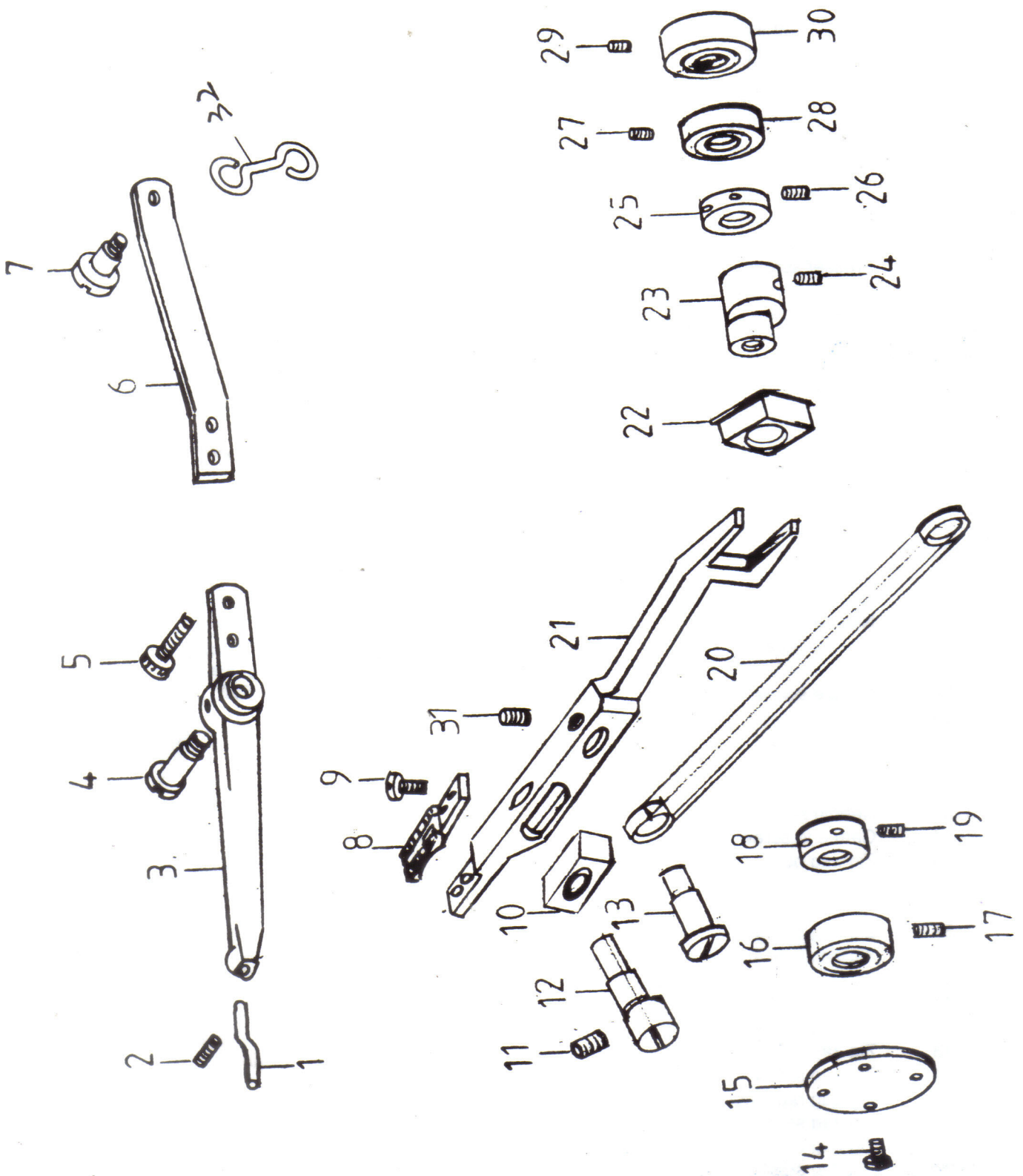


Number	Names	Number	Names
2-1	Take-up lever link hinge pin screw	2-51	Hook shaft bushing (rear)
2-2	Take-up lever link hinge pin	2-52	Hook shaft
2-3	Needle hinge pin	2-53	Hook shaft bushing (front)
2-4	Needle bar frame	2-54	Hook screw
2-5	Needle screw	2-55	Bobbin case position bracket
2-6	Needle screw	2-56	Bobbin case position bracket screw
2-7	Needle screw	2-57	Bobbin case
2-8	Needle washer	2-58	Bobbin
2-9	Needle bushing	2-59	Hook
2-10	Needle bar connecting stud	2-60	Hook shaft bushing (front) screw
2-11	Needle bar set screw	2-61	Hook shaft bushing (rear) screw
2-12	Needle bar	2-62	Hook shaft collar
2-13	Needle screw	2-63	Helical gear
2-14	Needle		
2-15			
2-16	Needle screw		
2-17	Needle bar frame guide pin		
2-18	Needle bar connecting link guide plate screw (lower) (upper)		
2-19	Needle bar connecting link guide plate		
2-20	Needle bar connecting link guide plate screw		
2-21	Needle bar connecting link		
2-22	Needle screw		
2-23	Needle bar crank		
2-24	Needle screw (large)		
2-25	Take up lever		
2-26	Needle screw (small)		
2-27	Needle screw (large)		
2-28	Counter weight		
2-29	Needle screw (small)		
2-30	Arm shaft screw		
2-31	Arm shaft bushing (front)		
2-32	Arm shaft screw		
2-33	Arm shaft collar		
2-34	Arm shaft		
2-35	Needle vibration pinion (spiral)		
2-36	Needle vibration pinion (spiral) screw		
2-37	Arm shaft screw		
2-38	Arm shaft bushing (rear)		
2-39	Timing belt wheel (upper)		
2-40	Timing belt wheel (upper) screw		
2-41	Hand wheel		
2-42	Hand screw		
2-43	Timing belt		
2-44	Timing belt wheel (lower)		
2-45	Timing belt wheel (lower) screw		
2-46	Lower shaft		
2-47	Lower shaft mitre gear (ring)		
2-48	Lower shaft mitre gear (ring) screw		
2-49	Helical gear screw		
2-50	Hook shaft collar screw		

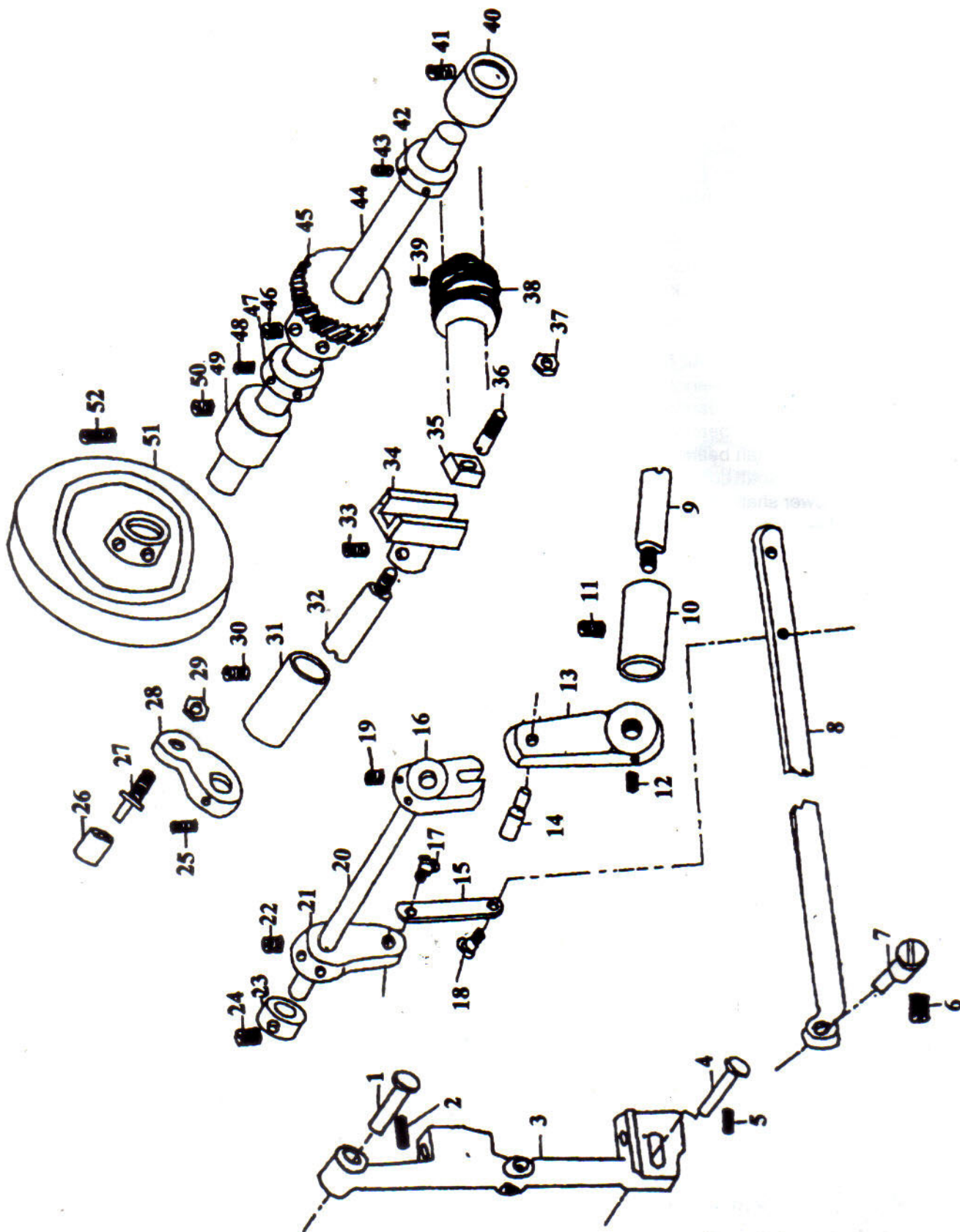


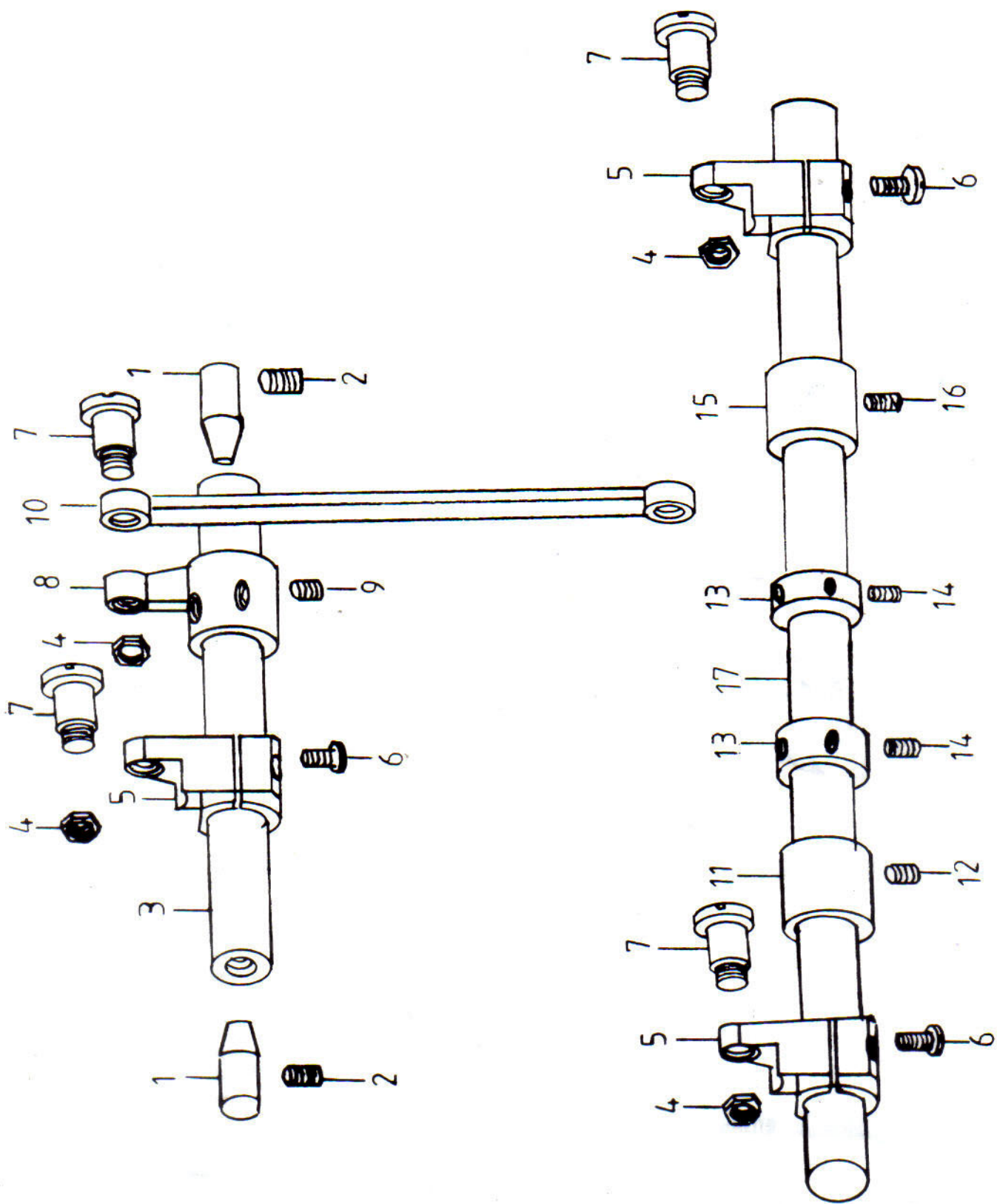
Number	Names
3-1	Presser bar lifter screw
3-2	Presser spring
3-3	Lifting screw
3-4	Lifting lever link
3-5	Presser bar lifting and releasing lever bracket
3-6	Tension releasing lever
3-7	Tension screw
3-8	Presser bar
3-9	Presser foot
3-10	Presser screw
3-11	Presser bar lifter
3-12	Presser screw
3-13	Zig zag screw
3-14	Presser bar guide bracket
3-15	Eccentric screw
3-16	Eccentric stud
3-17	Needle bar frame pitmam
3-18	Needle spring hook
3-19	Needle spring (small)
3-20	Needle screw
3-21	Needle collar (rear)
3-22	Needle bushing (rear)
3-23	Needle collar (front)
3-24	Needle bevel gear (large)
3-25	Needle vibrating cam shaft
3-26	Needle vibrating cam
3-27	Cam shaft bushing (front)
3-28	Needle screw
3-29	Needle screw
3-30	Needle screw
3-31	Needle screw
3-32	Needle screw
3-33	Needle screw
3-34	Cam end screw
3-35	Zig-zag nut
3-36	Zig-zag washer
3-37	Zig-zag stopper
3-38	Zig-zag screw
3-39	Zig-zag indicator plate
3-40	Zig-zag regulator crank shaft
3-41	Zig-zag regulator bushing
3-42	Zig-zag screw
3-43	Zig-zag regulator
3-44	Zig-zag screw
3-45	Zig-zag regulator slide block
3-46	Zig-zag stud
3-47	Zig-zag nut
3-48	Zig-zag screw
3-49	Needle screw
3-50	Needle vibrator stop index finger

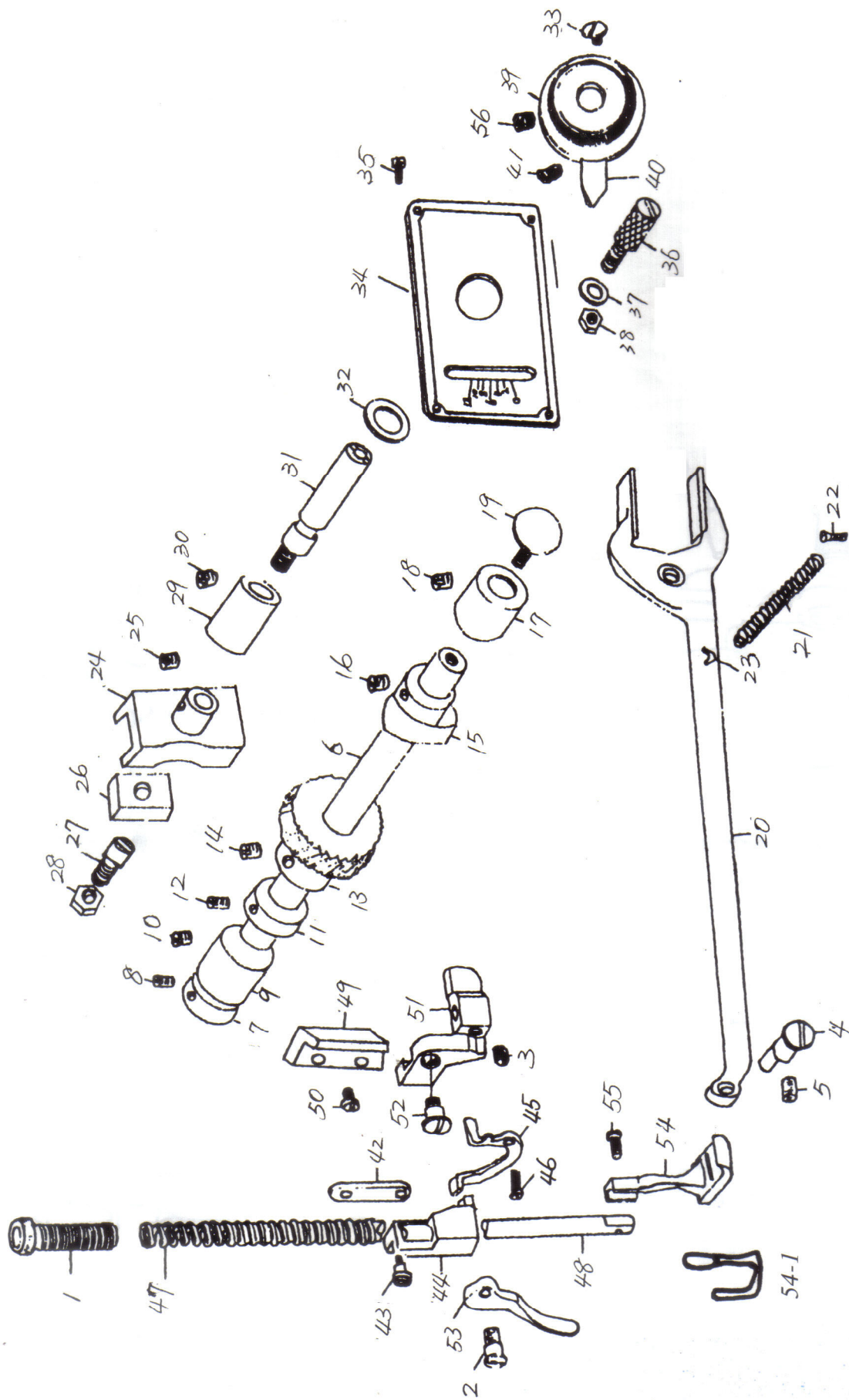
Number	Names
3-51	Dial
3-52	Presser screw
3-53	Zig-zag washer



Number	Names
4-1	Knee lifter lever pin
4-2	Knee screw
4-3	Knee lifter lever
4-4	Knee lifter lever screw
4-5	Spring screw
4-6	Knee lifter lever spring
4-7	Knee lifter chain
4-8	Feed dog
4-9	Feed dog set screw
4-10	Feed reverse black
4-11	Feed screw
4-12	Feed reverse pin
4-13	Tapered screw for 575
4-14	Lower shaft bearing cover screw
4-15	Lower shaft bearing cover
4-16	Lower shaft bearing (A)
4-17	Lower shaft bearing (A) screw
4-18	Lower shaft collar (left)
4-19	Lower shaft collar screw
4-20	Feed forket connection
4-21	Feed crank
4-22	Feed regulating slide block
4-23	Feed cam
4-24	Feed screw
4-25	Lower shaft collar (right)
4-26	Lower shaft collar screw
4-27	Lower shaft collar screw
4-28	Lower shaft bearing (C)
4-29	Lower shaft bearing (C) screw
4-30	Lower shaft bearing (D)
4-31	Nut for 575
4-32	Feed hook

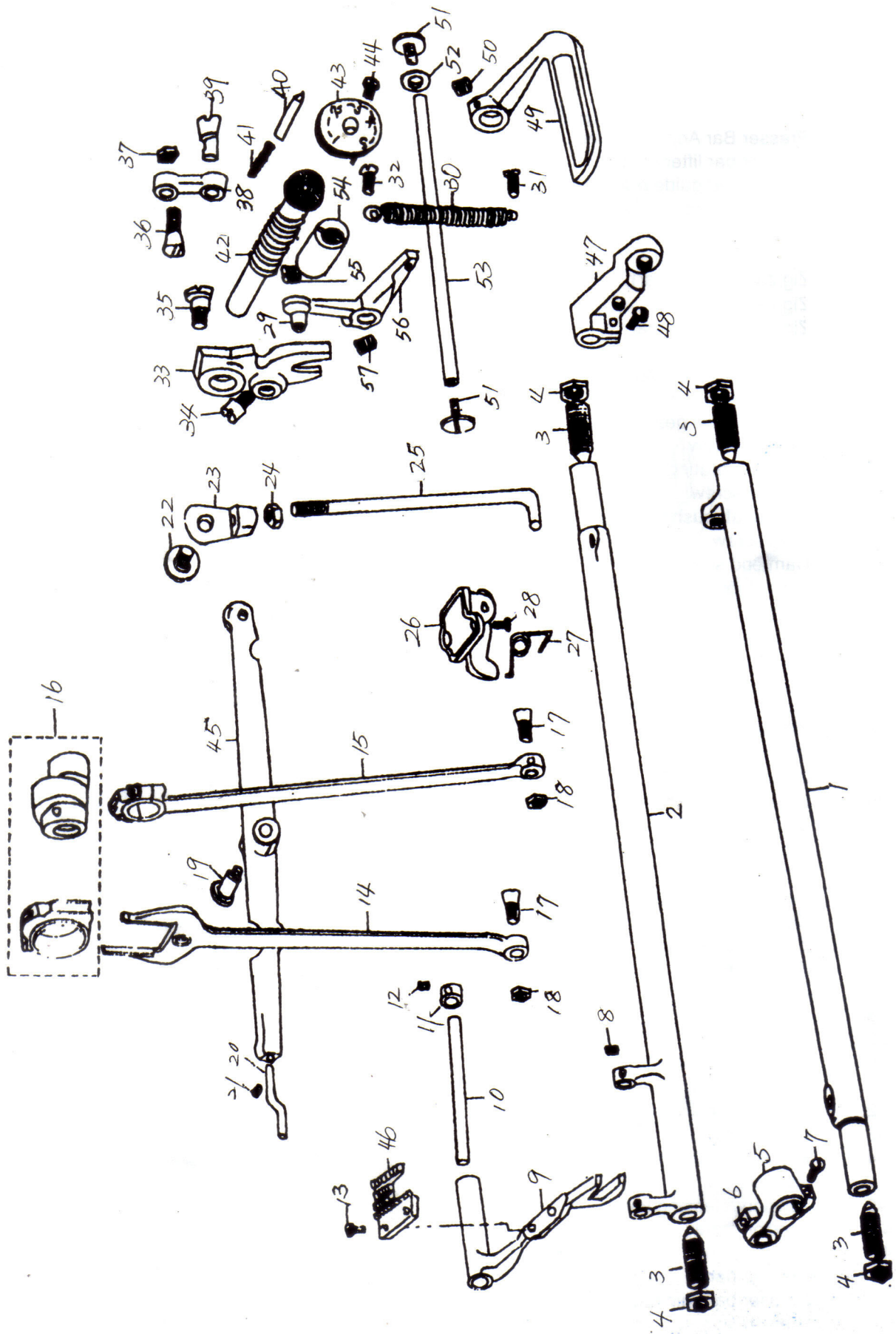




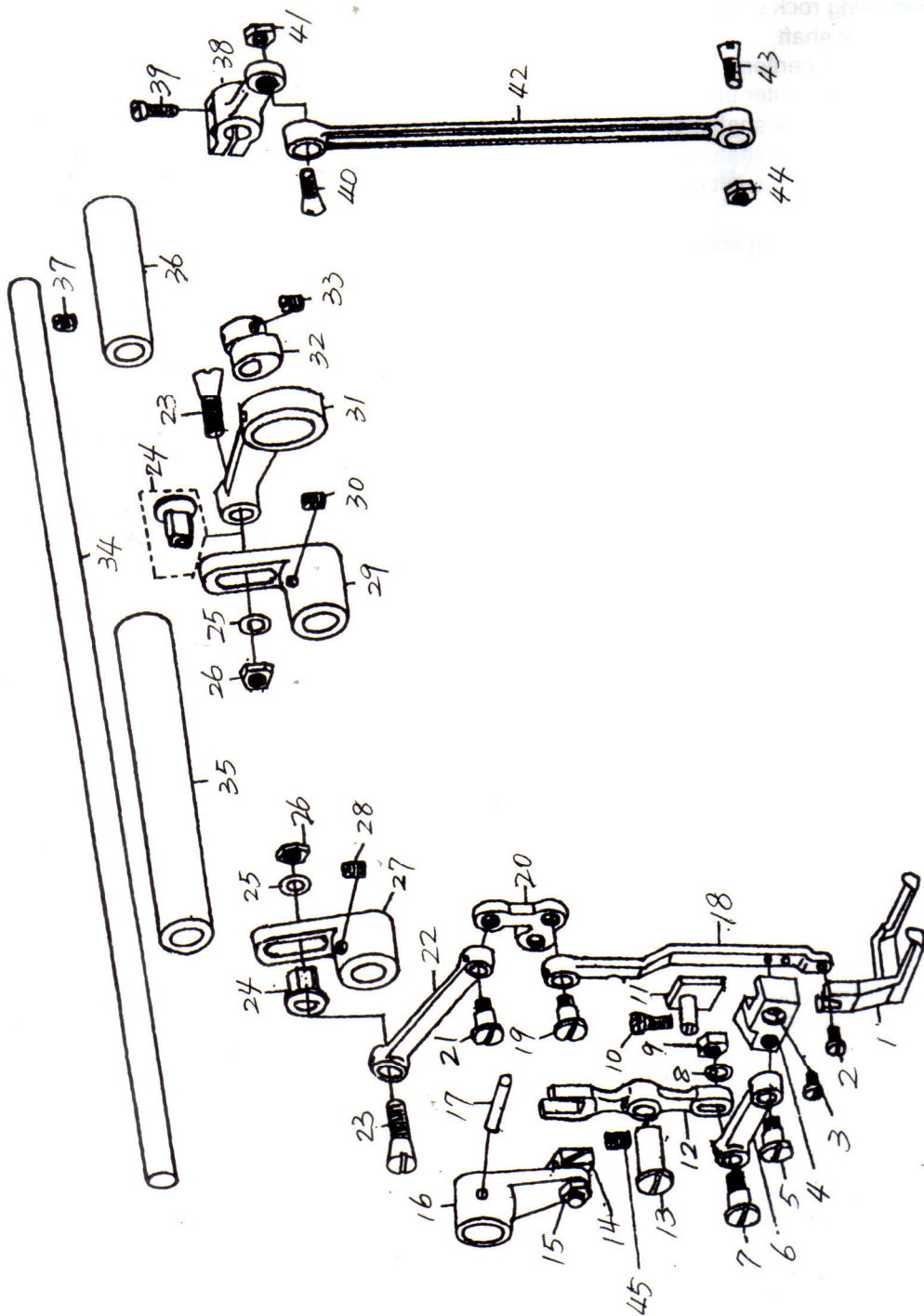


Number	Names
7-1	Presser Bar Adjusting screw
7-2	Presser bar lifter screw
7-3	Presser bar guide bracket screw
7-4	Eccentric stud
7-5	Eccentric screw
7-6	Zig zag drive cam
7-7	Zig zag collar (Rear)
7-8	Zig zag screw
7-9	Zig zag bushing rear
7-10	Zig zag screw
7-11	Zig zag collar (front)
7-12	Zig zag screw
7-13	Zig zag bevel gear (Large)
7-14	Zig zag screw
7-15	Needle vibrating cam
7-16	Needle screw
7-17	Cam shaft bushing (Front)
7-18	Cam screw
7-19	Cam end screw
7-20	Zig zag drive fork
7-21	Zig zag spring (Small)
7-22	Zig zag screw
7-23	Zig zag spring hook
7-24	Zig-zag regulator
7-25	Zig-zag regulator screw
7-26	Zig-zag slide block
7-27	Zig-zag stud
7-28	Zig-zag nut
7-29	Zig-zag regulator bushing
7-30	Zig-zag screw
7-31	Zig-zag regulator crank
7-32	Zig-zag regulator washer
7-33	Zig-zag end screw
7-34	Zig-zag indicator plate
7-35	Zig-zag screw
7-36	Zig-zag stopper
7-37	Zig-zag washer
7-38	Zig-zag nut
7-39	Dial
7-40	Needle vibrator stop index finger
7-41	Needle screw
7-42	Lifting lever link
7-43	Lifting screw
7-44	Presser bar lifting and releasing lever bracket
7-45	Tension releasing lever
7-46	Tension screw
7-47	Tension spring
7-48	Presser bar
7-49	Presser bar guide bracket guide
7-50	Presser screw

Number	Names
7-51	Presser bar guide bracket
7-52	Presser screw
7-53	Presser bar lifter
7-54	Inside presser foot
7-54-1	Protect finger
7-55	Inside screw
7-56	Zig-zag regulator screw

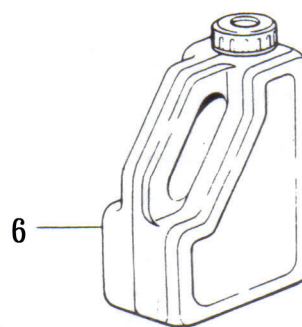
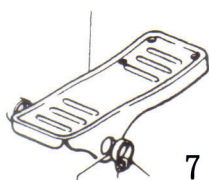
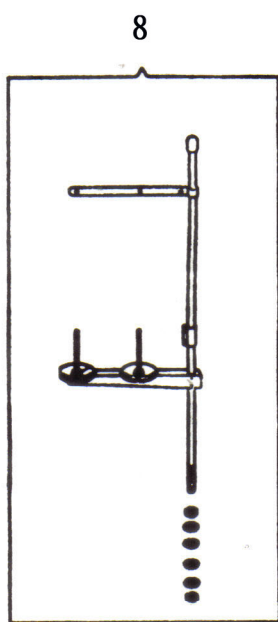
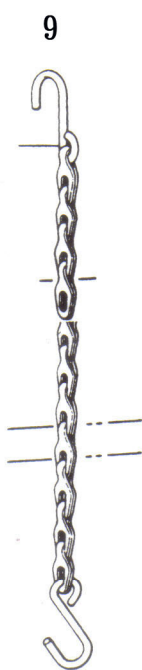
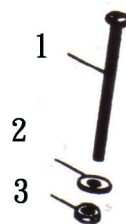
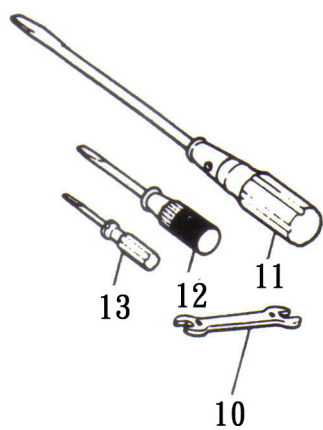


Number	Names	Number	Names
8-1	Feed lifting rock shaft	8-51	Reverse feed control lever
8-2	Feed rock shaft		shaft hinge screw
8-3	Feed screw center	8-52	Reverse feed control lever washer
8-4	Feed screw center unt	8-53	Reverse feed control lever shaft
8-5	Feed lifting rock shaft crank	8-54	Feed regulating stud bushing
8-6	Feed lifting rock shaft roller	8-55	Feed regulating stud bushing screw
8-7	Feed lifting rock shaft crank clamping screw	8-56	Reverse feed control lever crank
8-8	Feed bar shaft set screw	8-57	Reverse feed control lever crank screw
8-9	Feed bar		
8-10	Feed bar shaft		
8-11	Feed bar shaft collar		
8-12	Feed screw		
8-13	Feed dog screw		
8-14	Feed forket connection		
8-15	Feed litting rock shaft connecting rod		
8-16	Feed cam		
8-17	Feed lifting rock shaft connecting rod hinge screw		
8-18	Feed hinge screw nut		
8-19	Knee lifter lifting lever screw		
8-20	Knee lifter lifting lever pin		
8-21	Knee screw		
8-22	Knee lifter lifting lever connecting rod joint hinge screw		
8-23	Knee lifter litting lever connecting rod joint		
8-24	Knee lifter rod lock nut		
8-25	Knee lifter rod		
8-26	Knee lifter bell crank		
8-27	Knee lifter bell crank spring		
8-28	Knee lifter screw		
8-29	Feed reverse lever roller		
8-30	Feed reverse spring		
8-31	Feed screw (lower)		
8-32	Feed screw (upper)		
8-33	Feed regulator (Forked)		
8-34	Feed screw		
8-35	Feed screw		
8-36	Feed connecting lower hinge screw		
8-37	Feed screw nut		
8-38	Feed connecting link		
8-39	Feed connecting link hinge stud		
8-40	Feed regulating stud lock pin		
8-41	Feed spring		
8-42	Feed regulating stud		
8-43	Feed regulating stud head		
8-44	Feed screw		
8-45	Knee lifter lifting lever		
8-46	Feed dog		
8-47	Feed rock shaft crank		
8-48	Feed clamping screw		
8-49	Reverse feed control lever		
8-50	Reverse feed control lever screw		



Number	Names
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9-1	Outside presser foot
9-2	Outside presser foot thumb screw
9-3	Front and Rear presser bar guide bracket set screw
9-4	Front and Rear presser bar guide bracket
9-5	Front and Rear presser bar guide bracket pivot screw
9-6	Front and Rear lifting lever link
9-7	Front and Rear lifting lever link pivot screw
9-8	Front and Rear lifting lever link washer
9-9	Front and Rear lifting lever link nut for pivot screw
9-10	Outside presser bar stop bracket connecting screw
9-11	Outside presser bar stop bracket
9-12	Feed forked connection
9-13	Feed forked connection pin
9-14	Feed forked connection slide block
9-15	Feed forked connection slide block nut
9-16	Feed lifting rock shaft crank complete
9-17	Feed lifting rock shaft crank lock pin
9-18	Outside presser bar
9-19	Outside presser bar guide bracket screw
9-20	Outside presser bar guide bracket
9-21	Needle bar crank connecting rod hinge screw
9-22	Needle bar crank connecting rod
9-23	Feed lifting rock shaft connecting rod hinge screw
9-24	Feed lifting rock shaft connecting rod
9-25	Feed lifting rock shaft connecting rod washer
9-26	Feed lifting rock shaft connecting rod hinge screw nut
9-27	Feed lifting rock shaft crank (small)
9-28	Feed lifting rock shaft (small) stop screw
9-29	Feed lifting rock shaft crank (large)
9-30	Feed lifting rock shaft crank stop screw
9-31	Feed connecting link
9-32	Feed regulator stud
9-33	Feed regulator stud screw
9-34	Feed rock shaft (intermediate)
9-35	Vibrating rock shaft
9-36	Rear feed rock shaft (intermediate)
9-37	Rear feed rock shaft stop screw
9-38	Feed rock shaft crank
9-39	Feed rock shaft crank clamping screw
9-40	Feed rock shaft connecting rod hinge screw
9-41	Feed rock shaft connecting rod hinge screw nut
9-42	Feed lifting rock shaft connecting rod
9-43	Feed lifting rock shaft connecting rod hinge screw
9-44	Feed lifting rock shaft connecting rod hinge screw nut
9-45	Feed forked connection pin screw



705,706,805 車板圖

后成型全包邊台板(白色)

TABLE SIZE FOR CYLINDER BED TYPE ZIG ZAG INDUSTRIAL SEWING MACHINE:

UNIT:mm

車板厚度 : 40mm

1200

