

KONWA®

高速包缝机

HIGH-SPEED OVERLOCK SEWING MACHINE

KW-1816D

Instruction Manual

目 录

CONTENTS

■ 在使用之前

○ 台板加工图	3
○ 缝纫机的安装方法	4
○ 缝纫机的旋转方向及转数	5
○ 供油	6
○ 手动给油	7
○ 给 H R 装置供油	8
○ 穿线的方法	9

■ 试缝

○ 压脚压力的调节	10
○ 差动比的调节	11
○ 针脚长度的调节	12
○ 线状态的调节	13

■ 使用中的保养

○ 缝纫机的清扫	14
○ 换针	15
○ 检查机油的循环	16
○ 换机油	17
○ 下刀片的更换	18
○ 调整标准参数表 机针标准 针号对照表	I
○ 专用件目录表	II

■ 零件手册

19

■ BEFORE OPERATING

○ Schematic diagram of the machine table	3
○ Installing the machine head	4
○ The machine speed and the turning direction	5
○ Lubrication	6
○ Manual lubrication	7
○ Filling the HR device with silicon oil	8
○ Threading	9

■ TEST SEWING

○ Adjusting the presser foot pressure	10
○ Adjusting the diff. feed ratio	11
○ Adjusting the stitch length	12
○ Adjusting the thread tension	13

■ MAINTENANCE DURING USE

○ Cleaning the machine	14
○ Replacing the needle	15
○ Checking the oil circulation	16
○ Replacing the oil	17
○ Replacing the lower knife	18
○ Adjustment dimensions Standard needle comparison table of equivalent sizes	I
○ Gauge parts list	II

■ PARTS BOOK

19

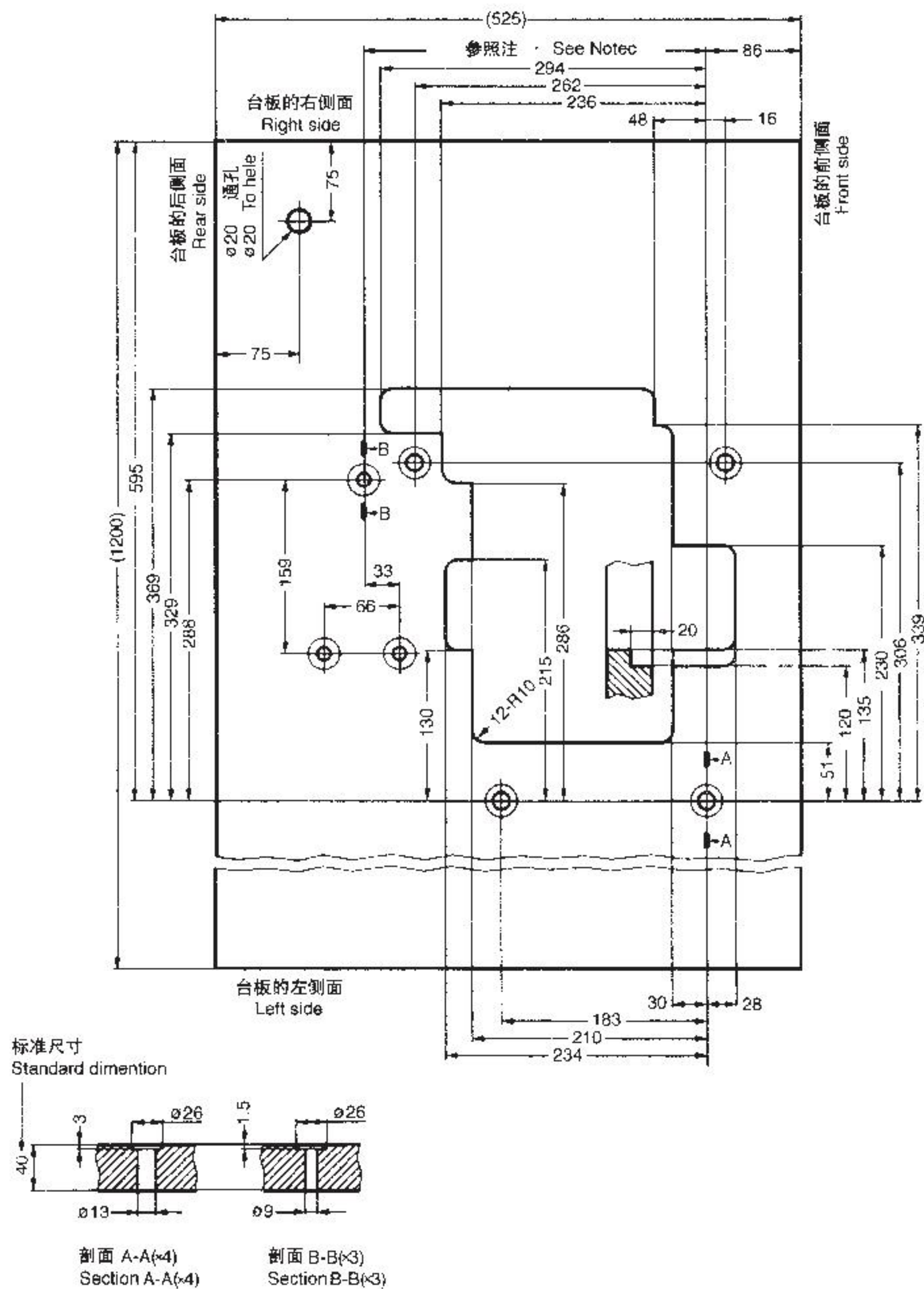
在使用之前
BEFORE
OPERATING

台板加工图

Schematic diagram of the machine table

请参照下图进行台板的加工

Cut the table referring to the diagram

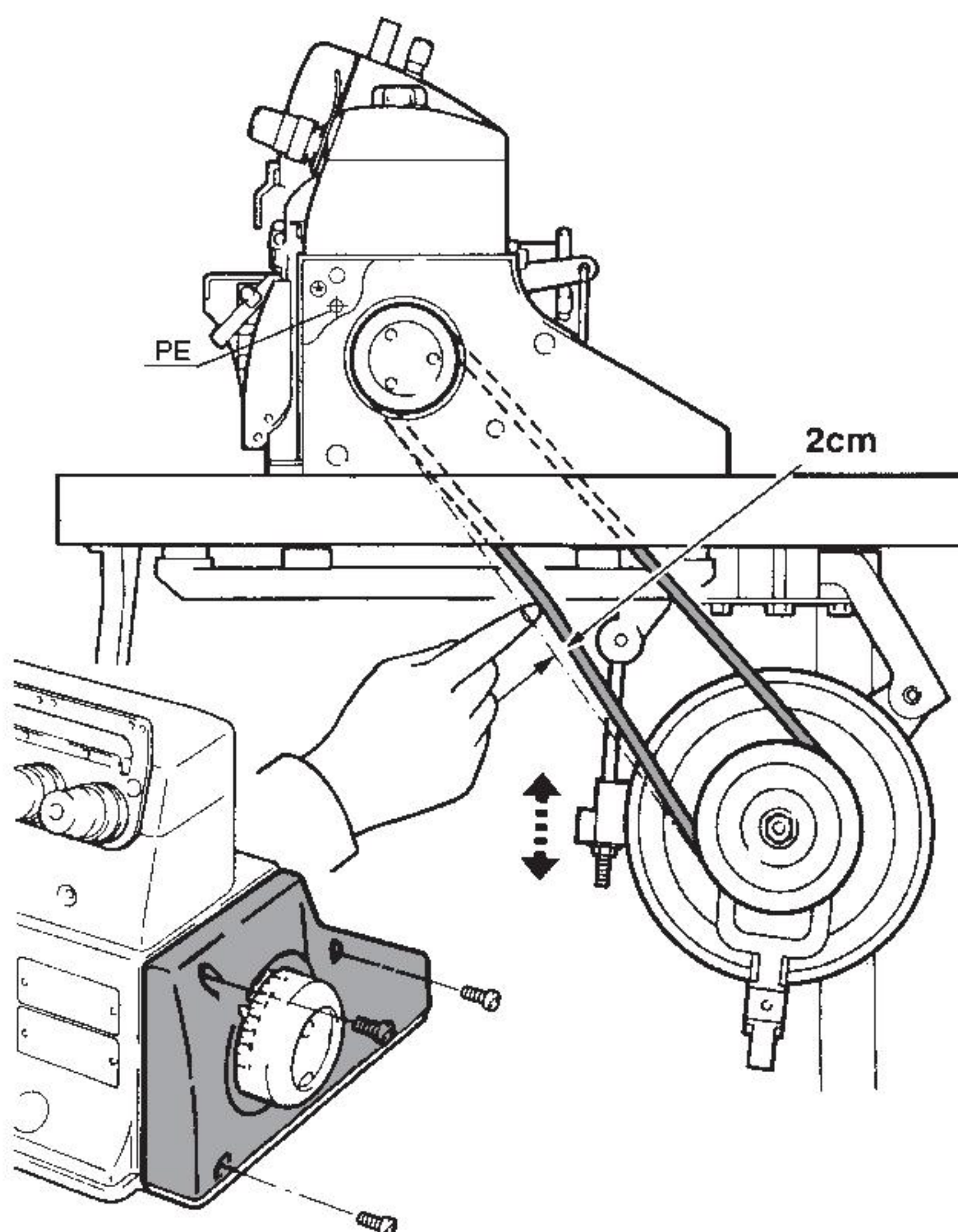


在使用之前
BEFORE
OPERATING

缝纫机的安装方法

Installing the machine head

1. 将缝纫机装于台板之上，给缝纫机侧皮带轮和马达侧皮带轮装上三角胶带。
 2. 在 PE 处安装接地线。
 3. 将马达高度调整到用手按压皮带中间时，约有 2cm 左右的松弛量为好。
 4. 请装好皮带的护盖。
1. Mount the machine head on the machine rest board .
 2. Install **ground** wire at PE.
 3. Adjust the belt tension so that there is gap of about 2cm when the center of belt is pressed.
 4. Install the belt cover referring to the Figure.

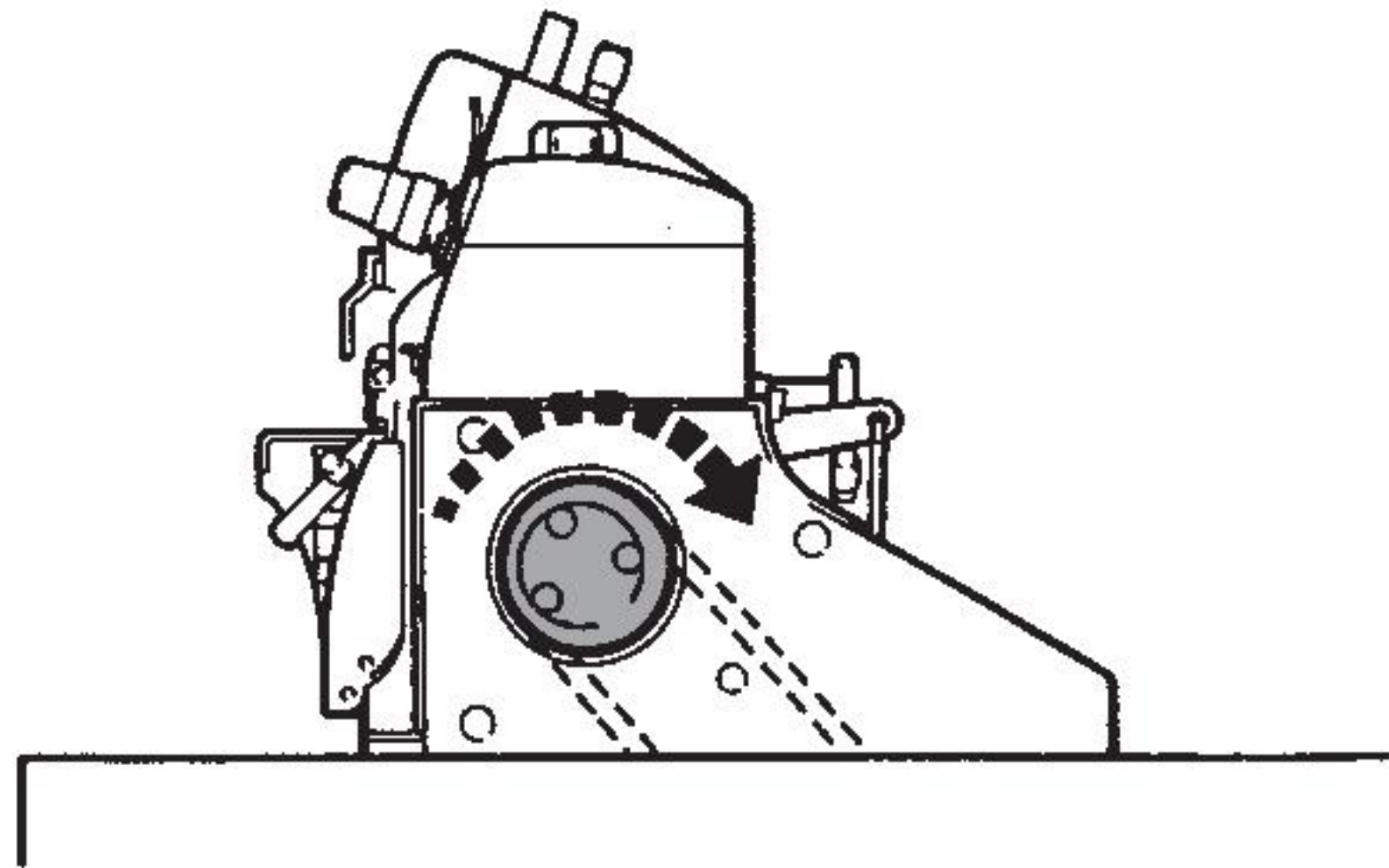


在使用之前
BEFORE
OPERATING

缝纫机的旋转方向及转数 The machine speed and the turning direction

缝纫机的旋转方向，从皮带轮侧看是向右旋转的。

The machine rotates clockwise when **see from the machine pulley side**.



在使用之前
BEFORE
OPERATING

供 油 Lubrication

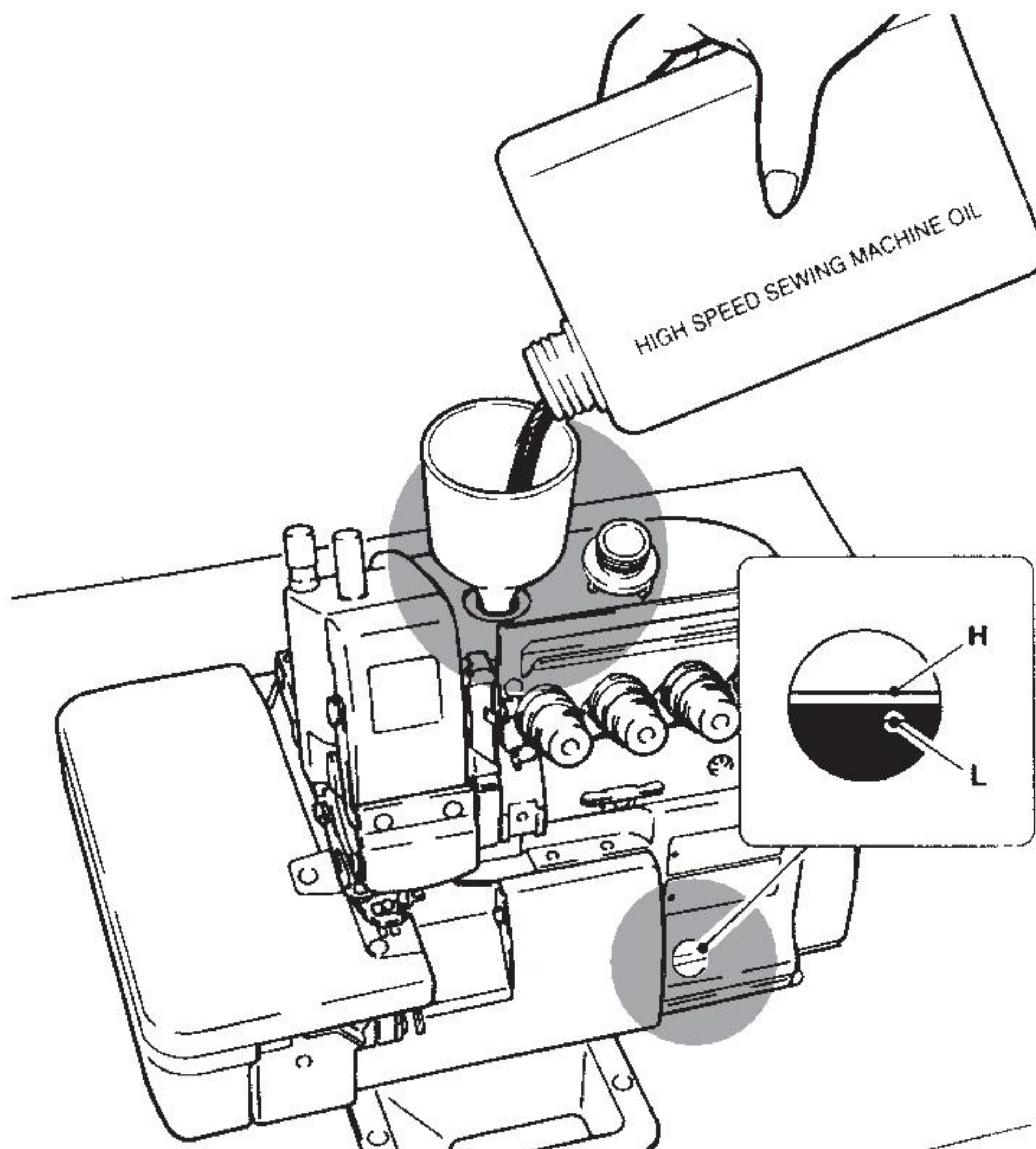
加油量要使油面处于H线与L线之间为好，当油面低于L线时，就要及时补充机油。

注意：请使用指定的机油(HIGH SPEED SEWING MACHINE OIL)(ISO 粘度与 VG22 相同)。

After filling the oil pan, the oil surface should lie between (H) and (L) lines.

Add oil when the oil surface reaches or goes below (L)

Note: Use recommended oil (HIGH SPEED SEWING MACHINE OIL) (ISO VG22)



在使用之前
BEFORE
OPERATING

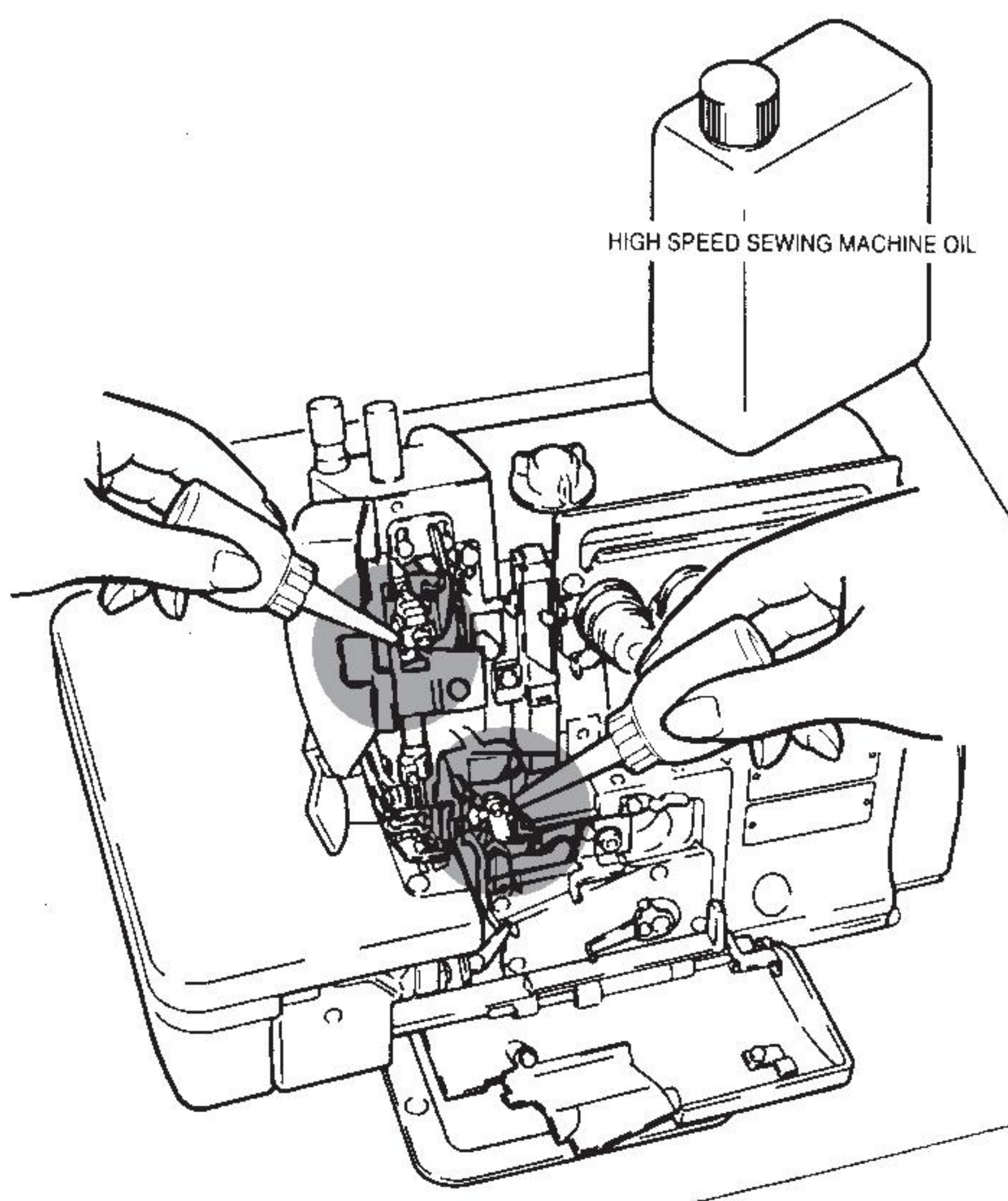
手 动 给 油

Manual lubrication

手动给油是在缝纫最初开始使用时，或停用一段时间重新开始使用时，请供给 2-3 滴油。

注：请使用指定的机油(HIGH SPEED SEWING MACHINE OIL)(ISO 粘度与 VG22 相同)。

Apply 2 or 3 drops of oil by hand when the machine is used for the first time or has been left unused for some time.
Note: Use recommended oil (HIGH SPEED SEWING MACHINE OIL) (ISO VG22)



在使用之前
BEFORE
OPERATING

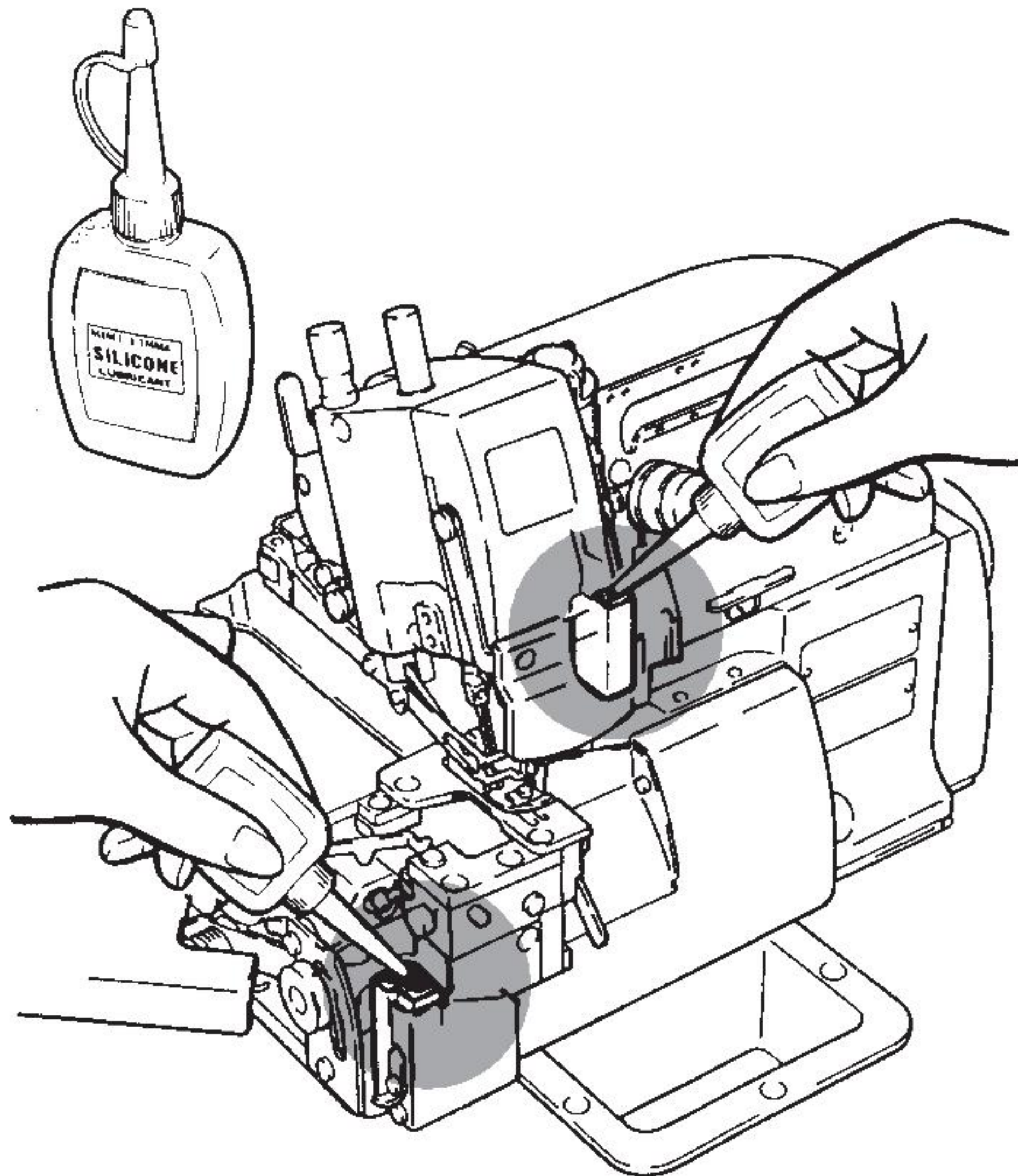
给 H R 装置供油

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。

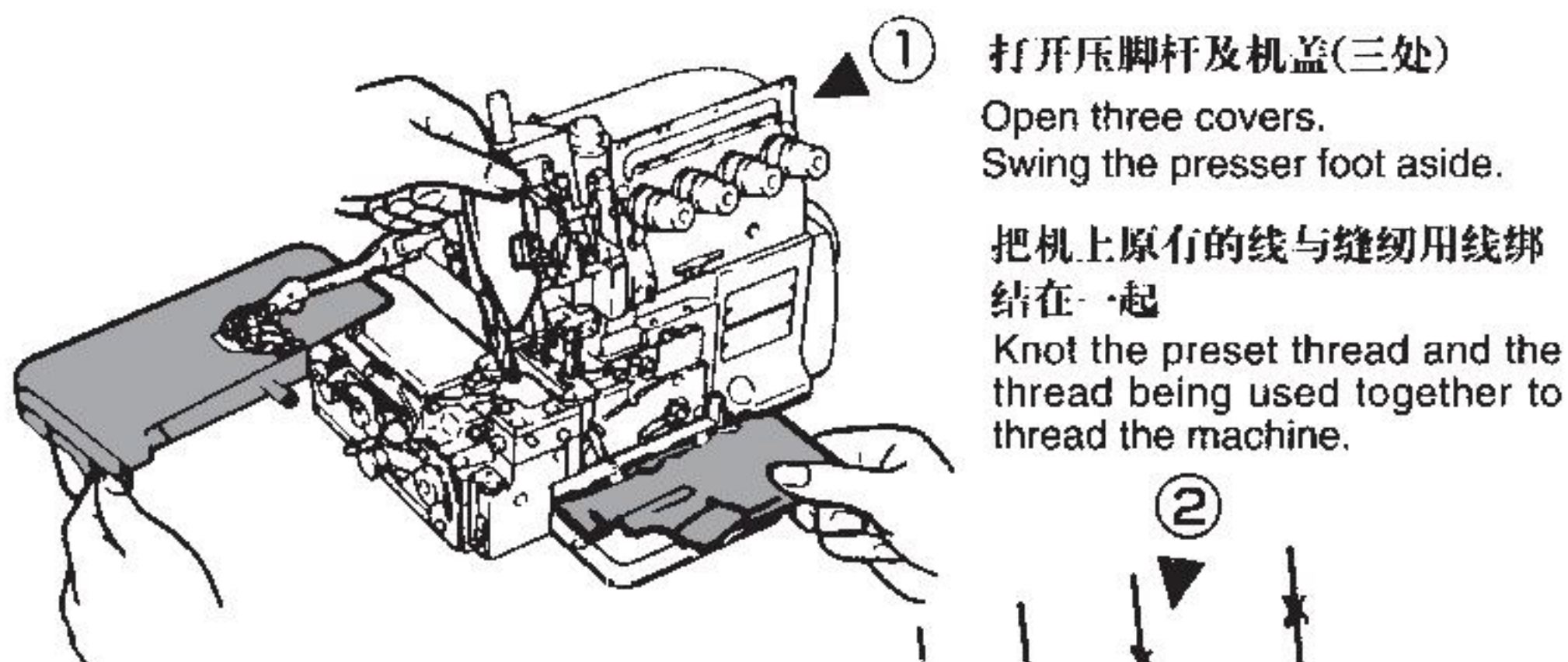
注：硅油请使用指定的冷却油。

Fill the HR device with oil **before** it is too low in order to prevent needle thread breakage and fabric damage.
Note: Use recommended silicon oil

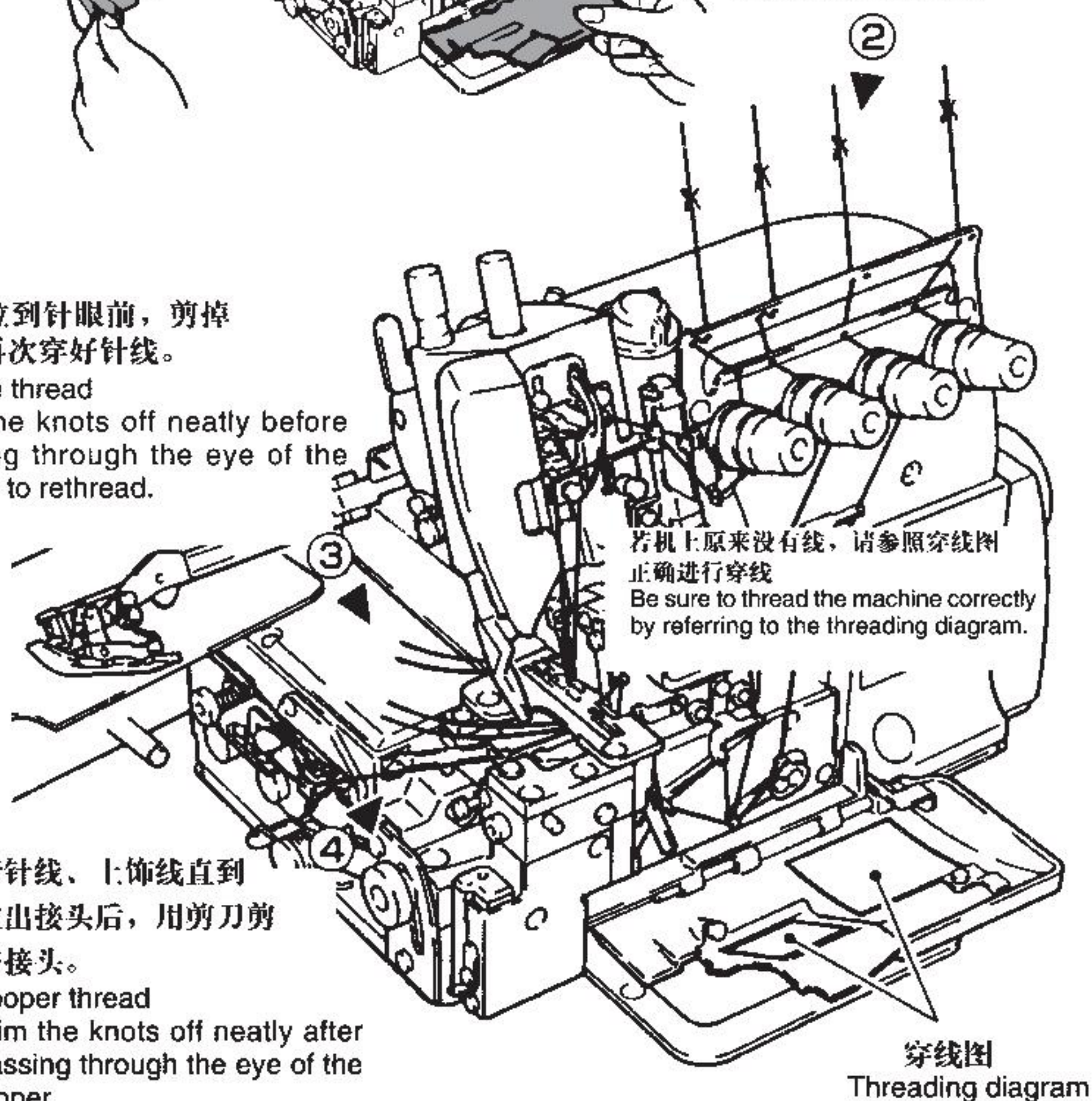


在使用之前
BEFORE
OPERATING

穿线的方法 Threading



针线
将线拉到针眼前，剪掉
结头再次穿好针线。
Needle thread
Trim the knots off neatly before
passing through the eye of the
needle to rethread.



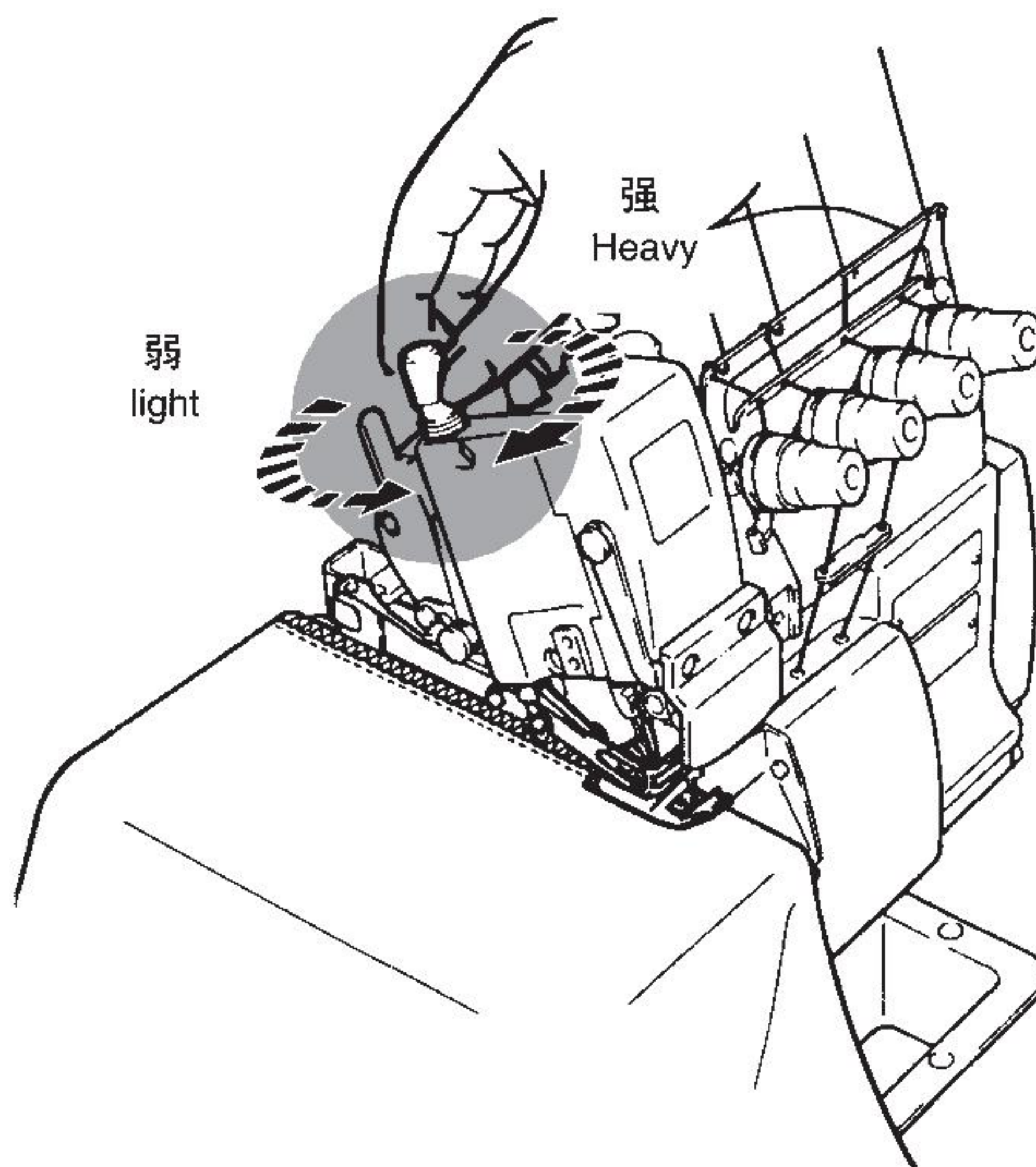
试缝
TEST SEWING

压脚压力的调节

Adjusting the presser foot pressure

压脚压力的调节可旋转螺帽进行调节。在送布状态良好并能取得均匀针脚的范围内,尽可能使用较弱的压力为好。

Turn adjusting screw to adjust the presser foot pressure. It should be as light as possible, yet be sufficient to obtain the proper stitch formation.

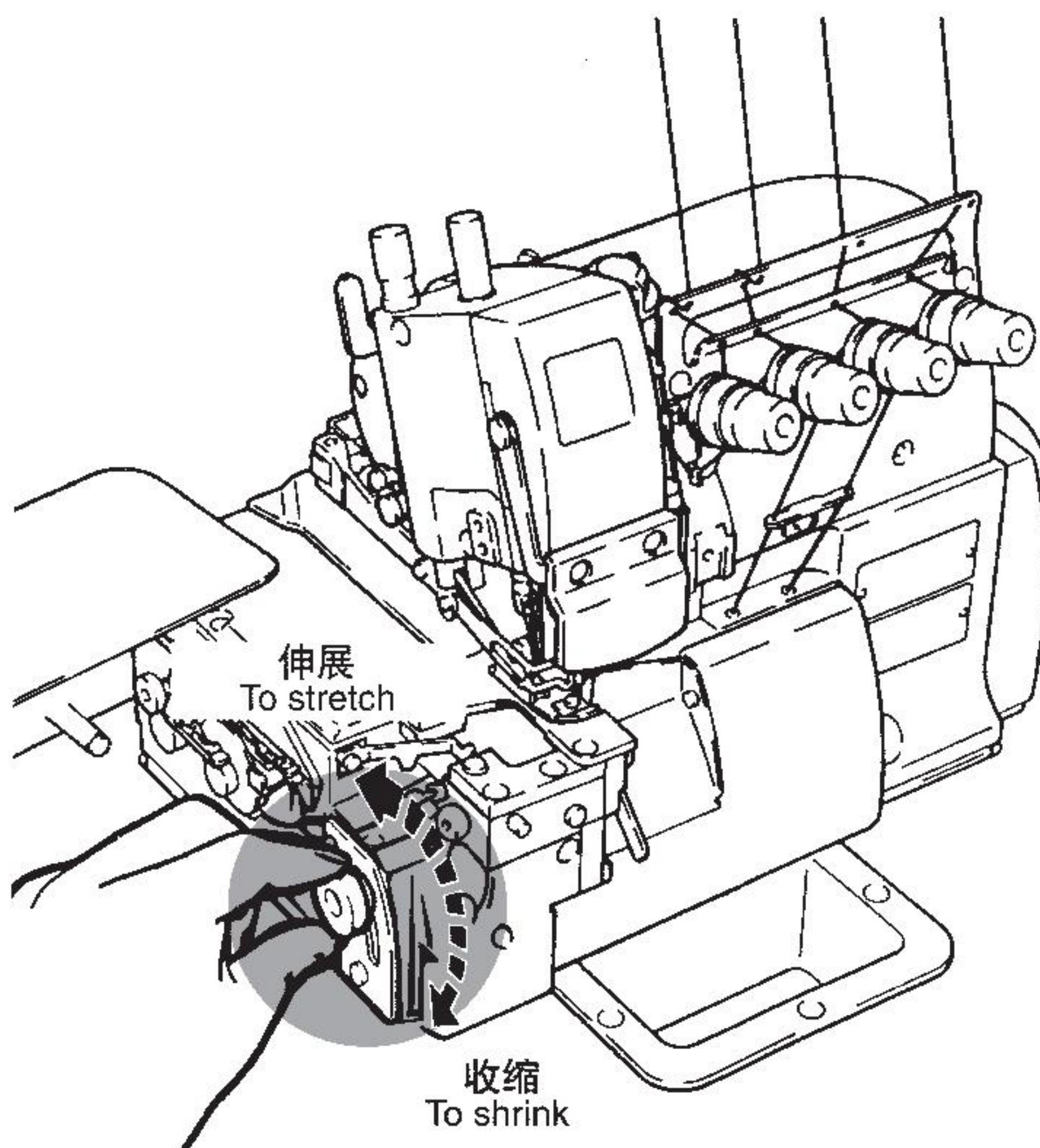


试缝
TEST SEWING

差动比的调节

Adjusting the diff.feed ratio

差动比的调节是松开螺母后，上下移动来进行调节，调节完后，将螺母拧紧。
Loosen the nut and move the lever up and down to obtain the correct differential feed ratio.
Tighten the nut after positioning the lever as desired.

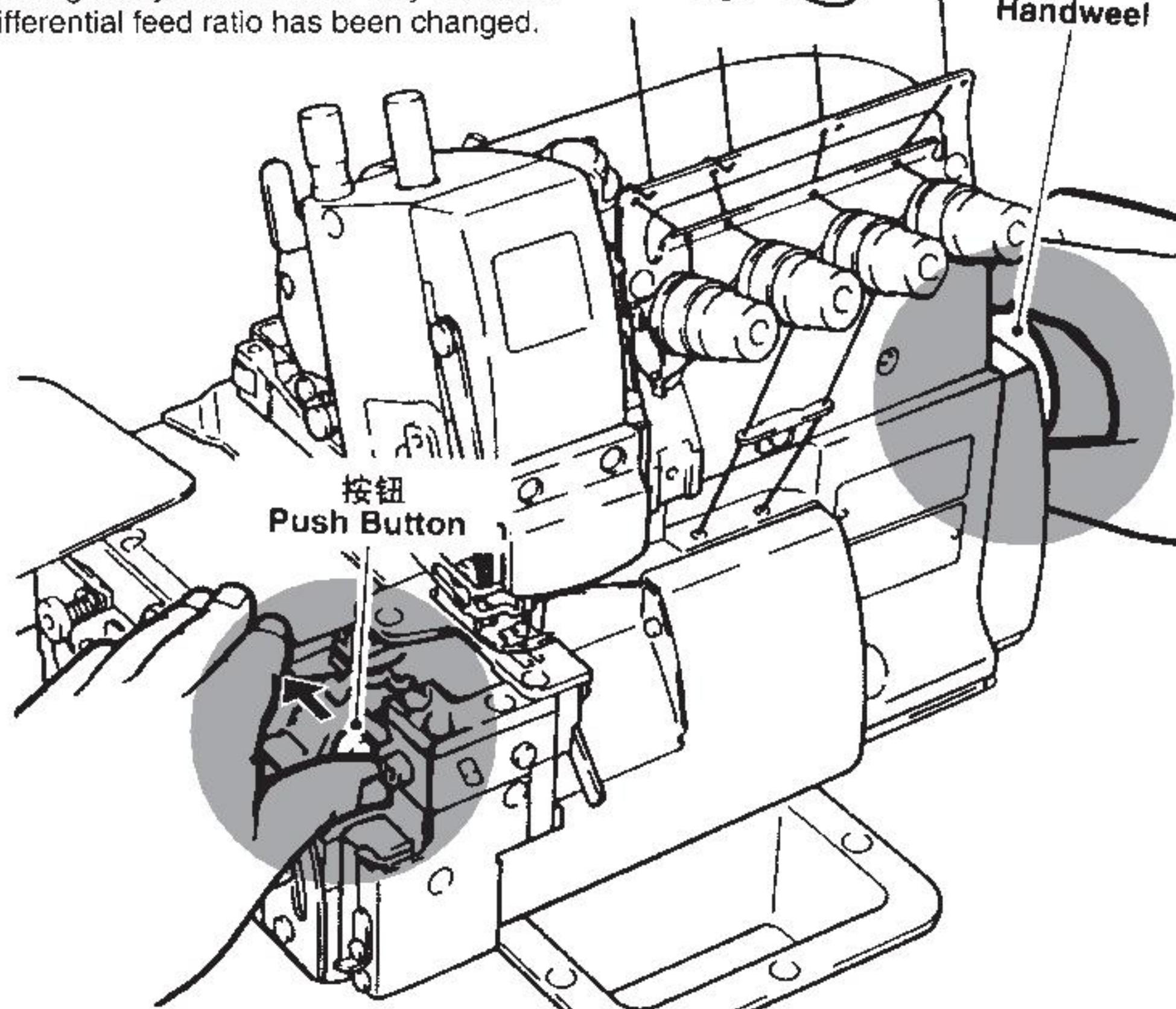
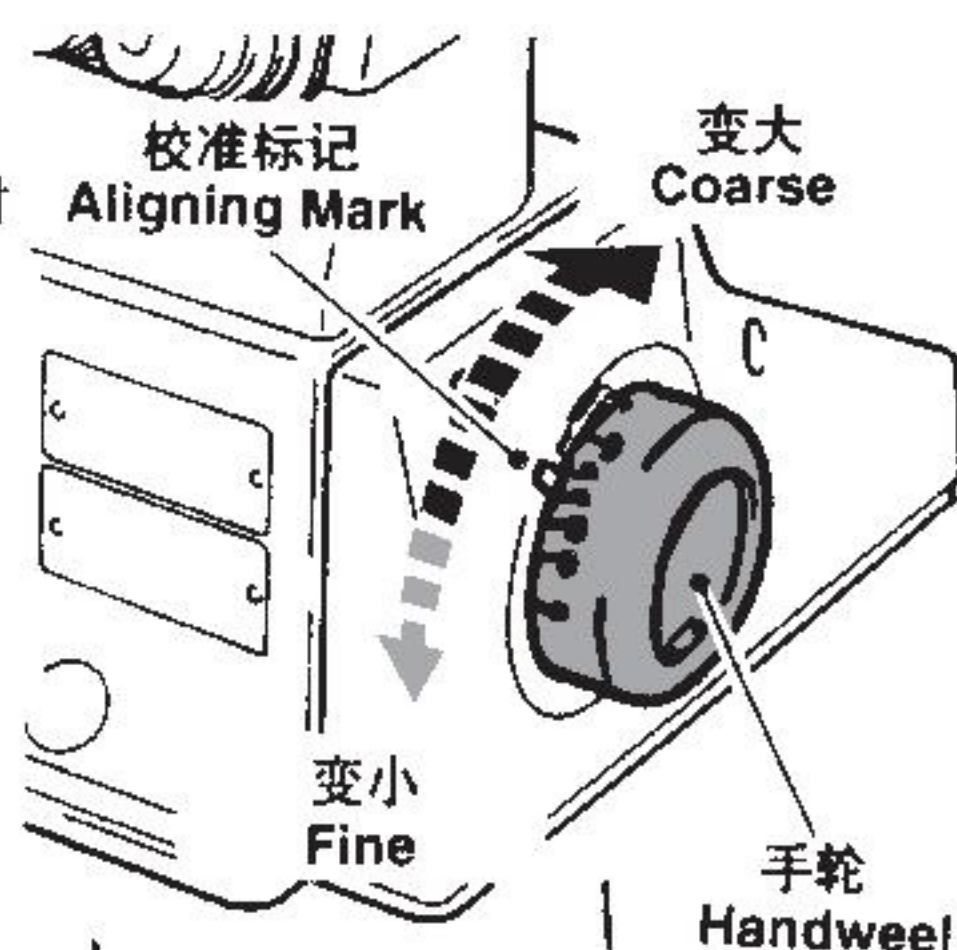


1. 摁住按钮，旋转手轮，按钮会陷进更深处。
2. 这时边摁住按钮，边转动手轮，使校准标记号对准所希望的数值。

① While pressing the push button, turn the handwheel to seek the position at which the push button goes further into the depth.

② Then, keep the push button pressed, turn the handwheel until we have the desired stitch length.

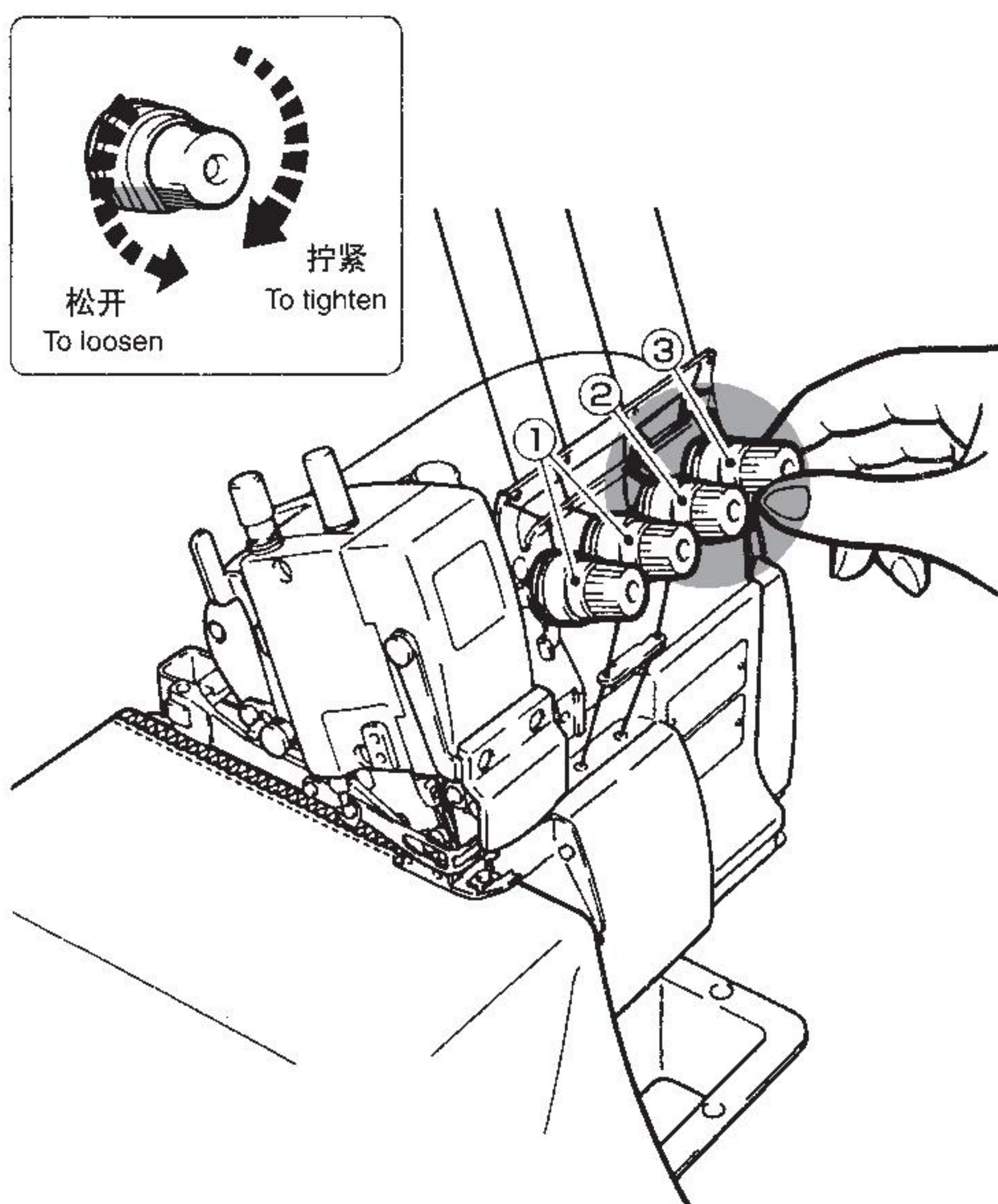
注：针脚长度调节务必请在调节差动比之后进行。
Note: Stitch length adjustment must only be made after the differential feed ratio has been changed.



试缝
TEST SEWING

线状态的调节 Adjusting the thread tension

线张力状态的调节，请用针线调节螺帽①、上弯针线调节螺帽②、弯针线调节螺帽③来进行调节。
Make tension adjustments with the needle thread knob ①, the upper looper knob ②, and the lower looper knob ③.

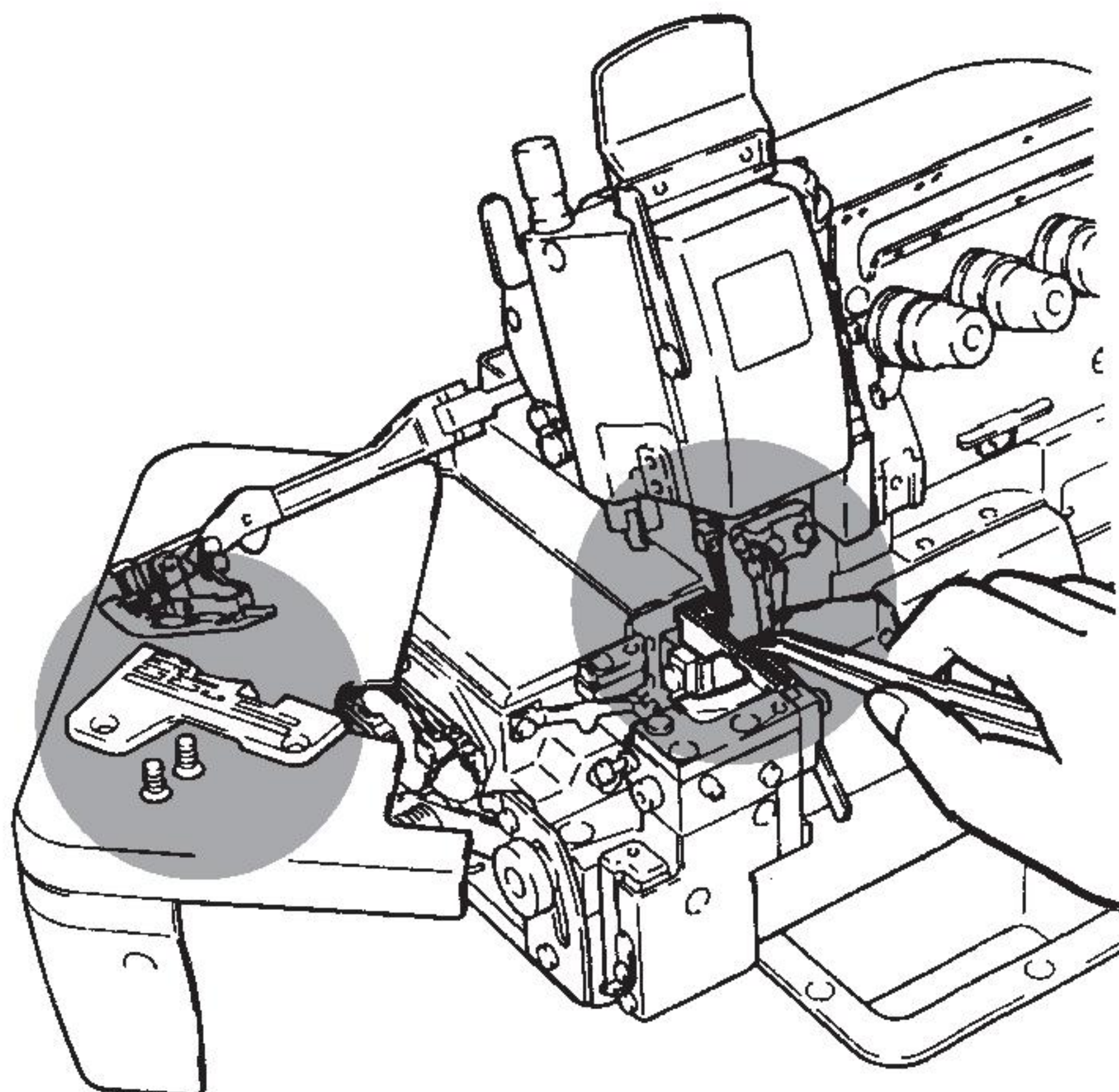


使用中的保养
MAINTENANCE
DURING USE

缝纫机的清扫

Cleaning the machine

缝纫机的清扫，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 cleaned.



使用中的保养
MAINTENANCE
DURING USE

换 针
Replacing the needle

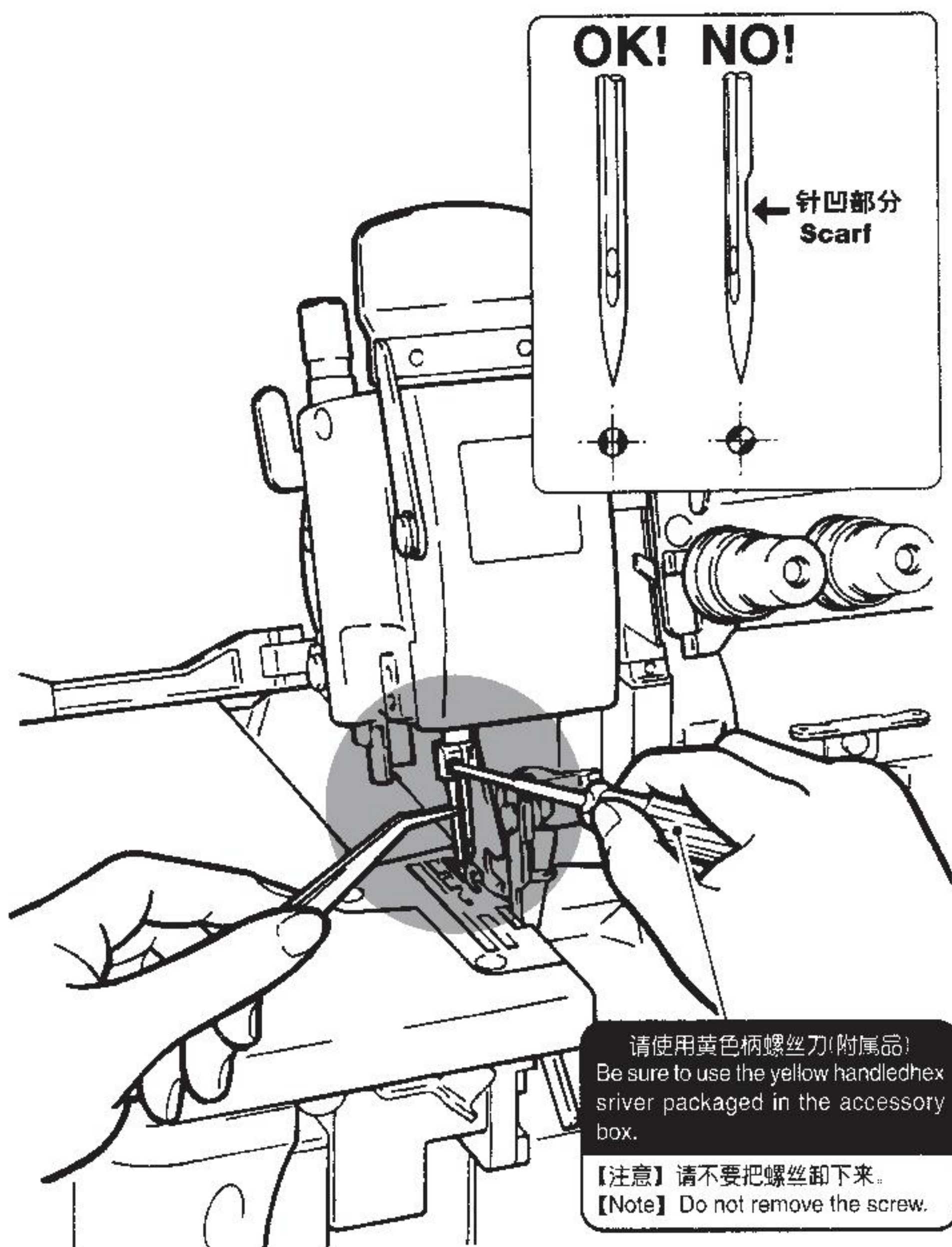
准确辨认针的前后，请将针凹向着后方，即背向操作者进行安装。

针要牢固的插到孔的最深处。

- Check the needle carefully to see that the **scarf turned to the rear of the machine.**
- Insert the needle to the proper depth, and fasten securely.

标准使用的缝纫针，请参照卷末附有的“调整标准表”

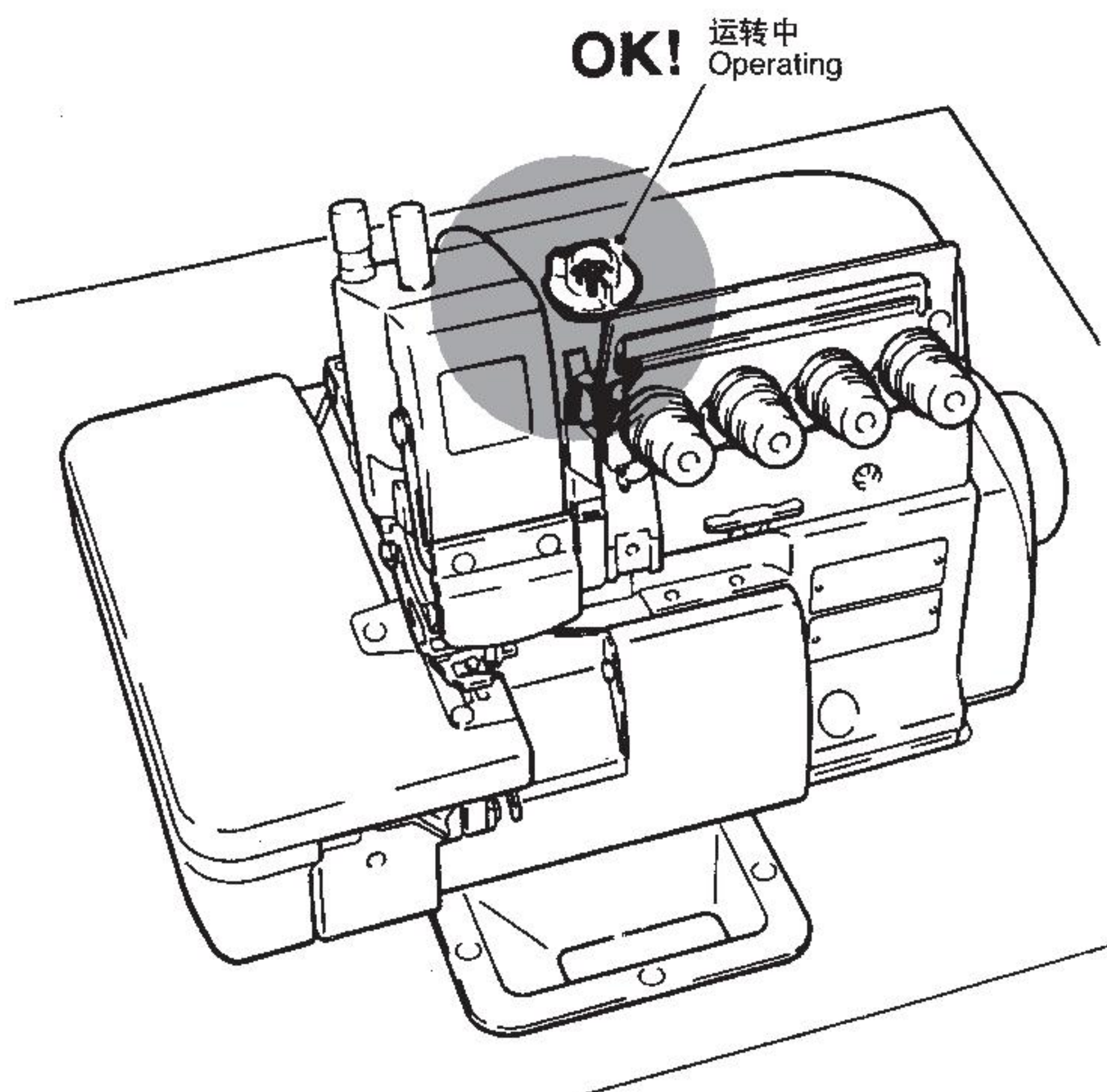
Be sure to use standard needle. Refer to ADJUSTMENT DIMENSIONS on the end of instructions.



使用中的保养
MAINTENANCE
DURING USE

检查机油的循环

Checking the oil circulation



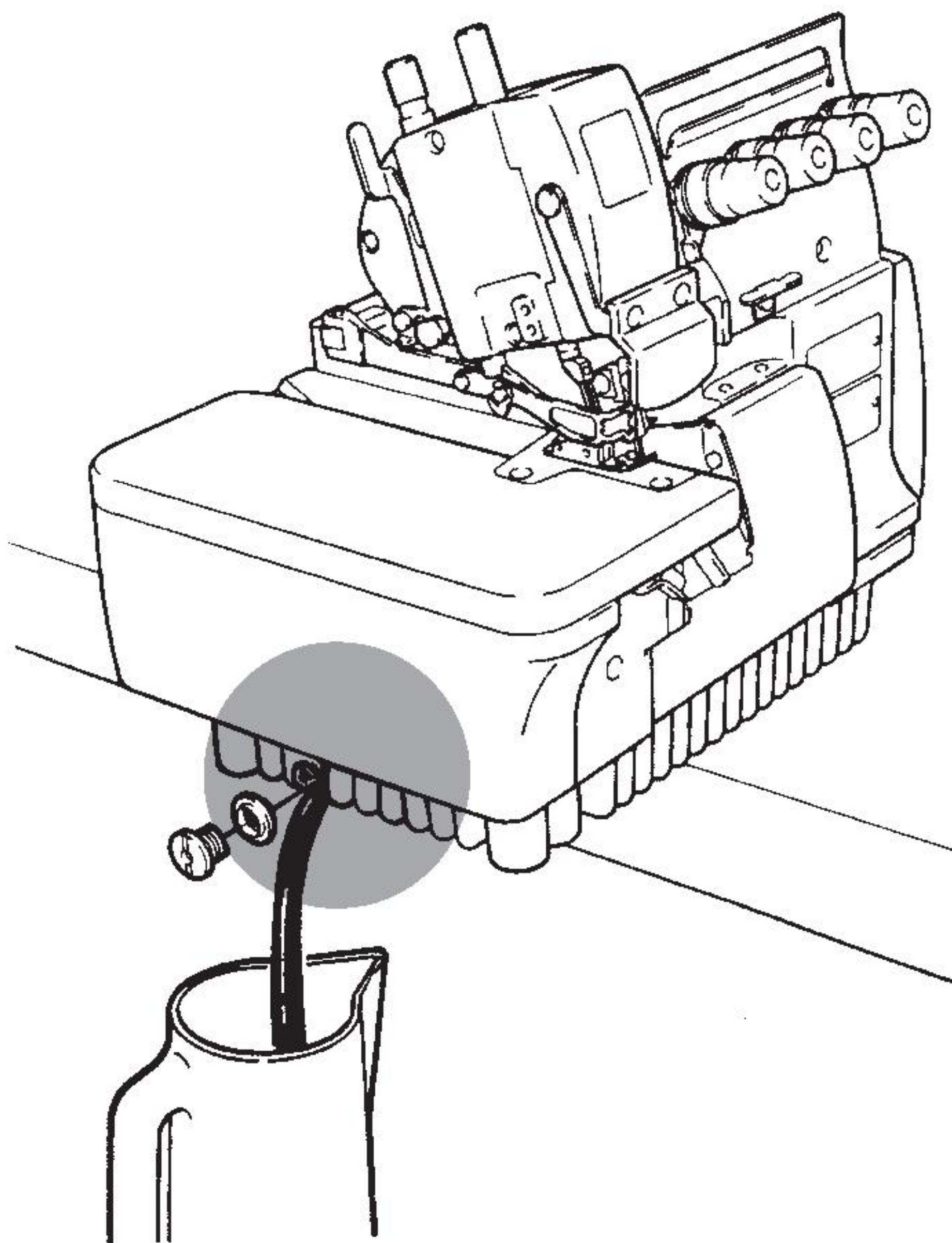
使用中的保养
MAINTENACE
DURING USE

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，每6个月更换一次。
Replace the oil one month after the first use and every six months thereafter.(See P7.)

供油请参见第7页。



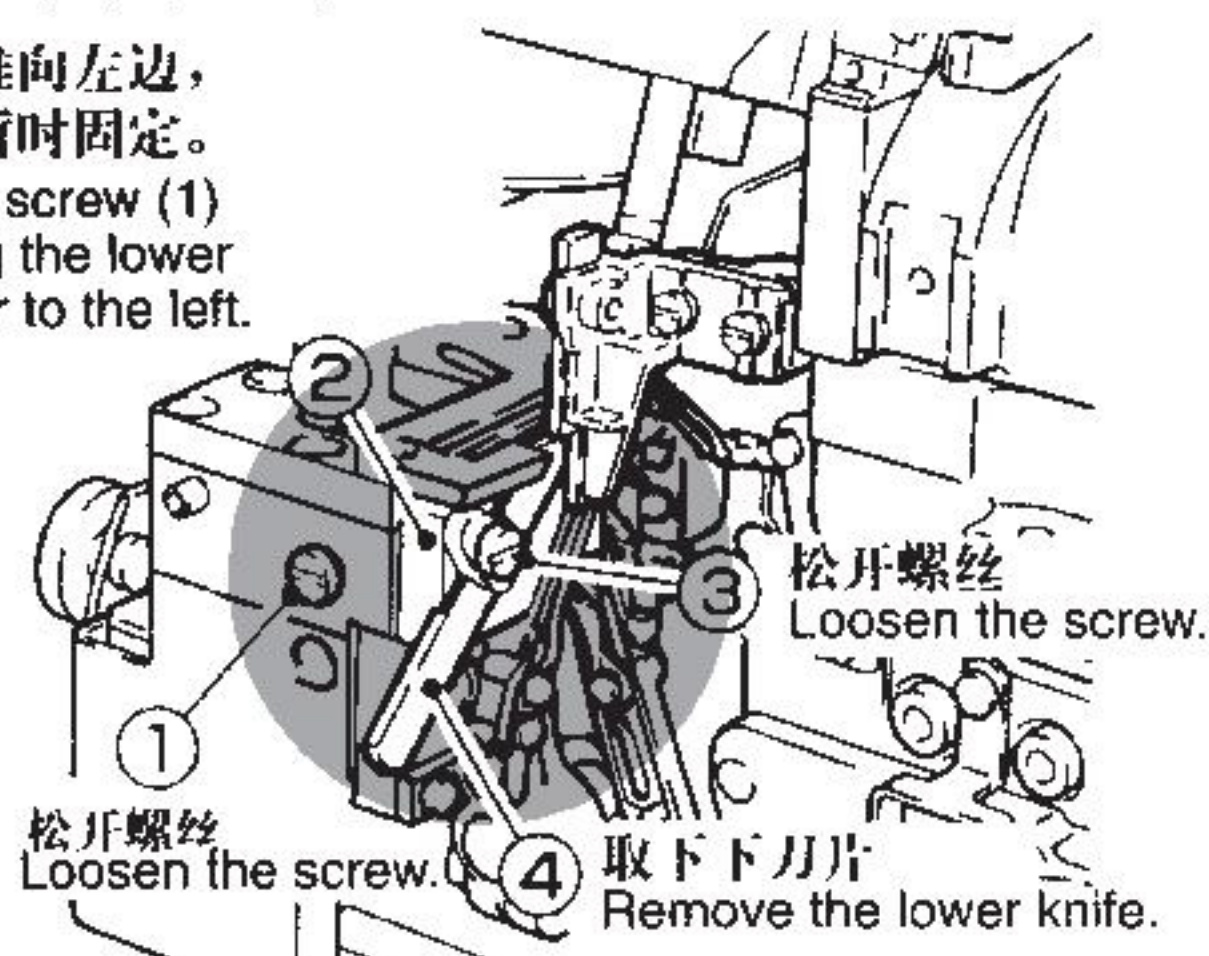
下刀片的更换 Replacing the lower knife

卸下下刀片

To remove the lower knife

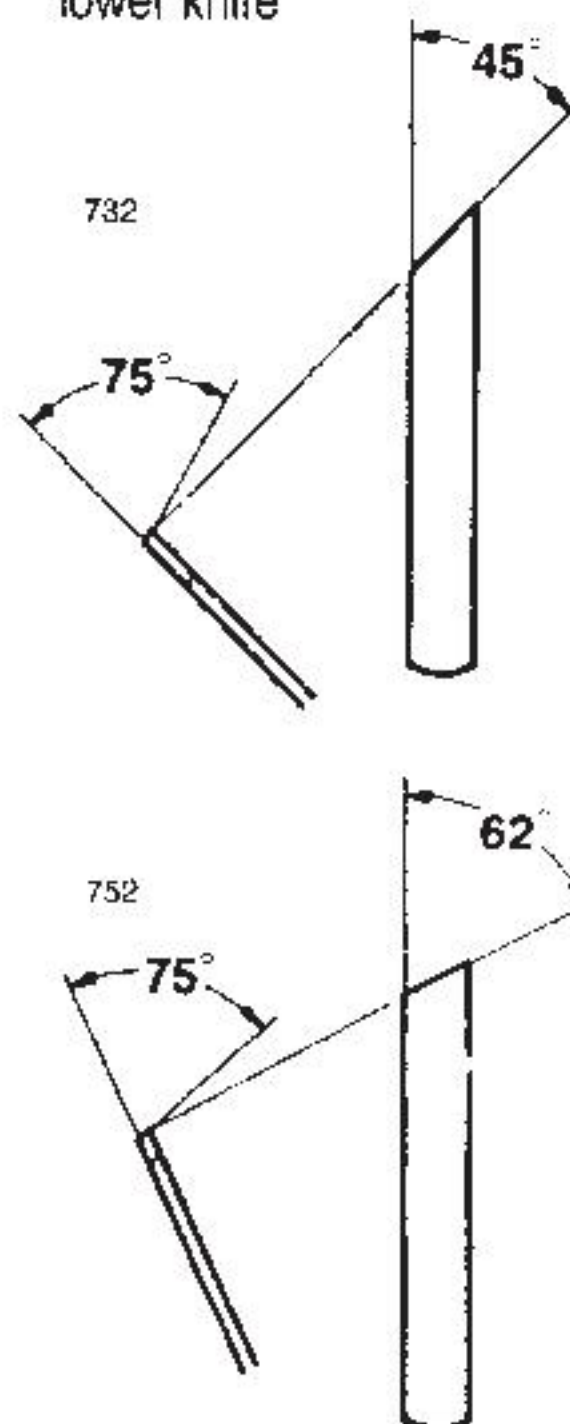
把下刀架推向左边，
用螺丝①暂时固定。

Temporarily screw (1)
after sliding the lower
knife holder to the left.



下刀片正确的研磨角度

Correct angles to sharpen the
lower knife



安装下刀片

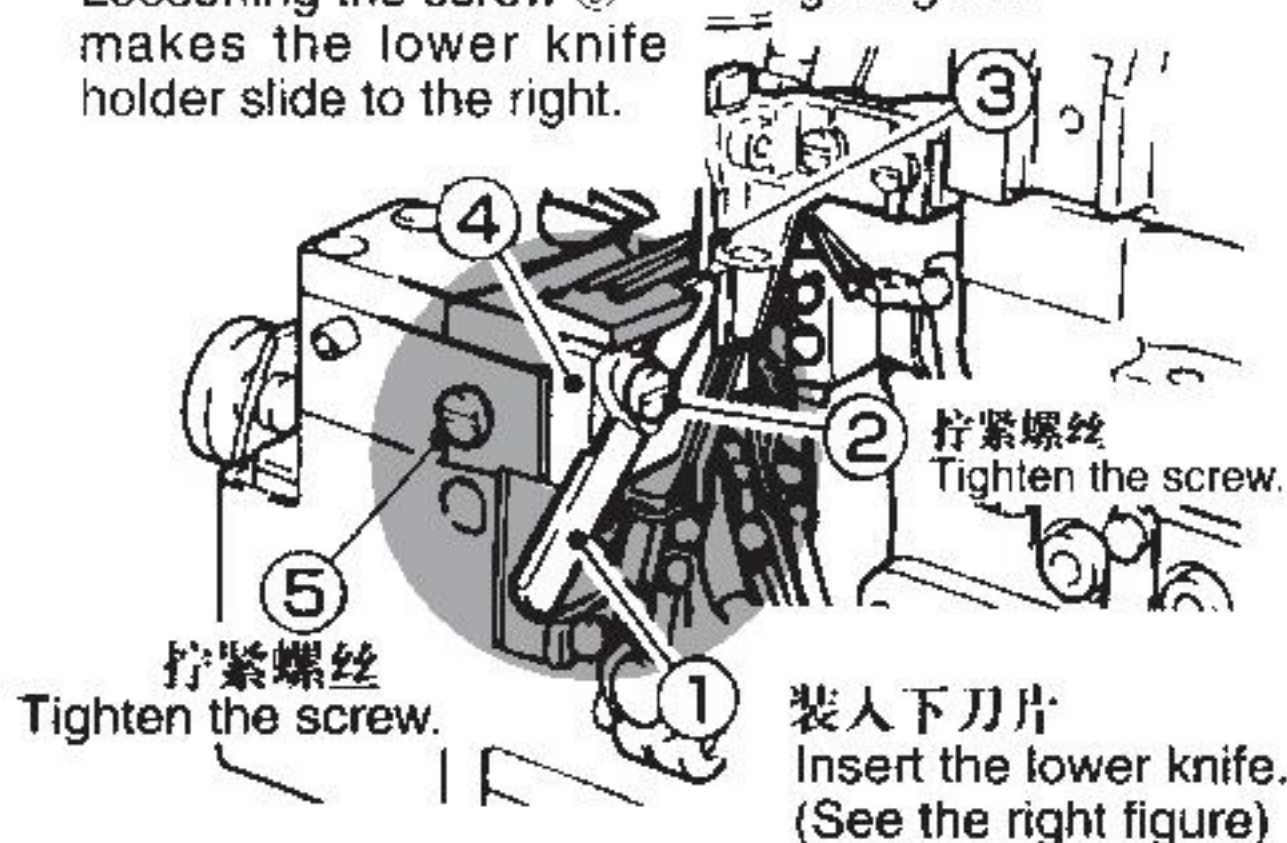
To replace the lower knife

松开螺丝⑤，下刀架
则向右移动。

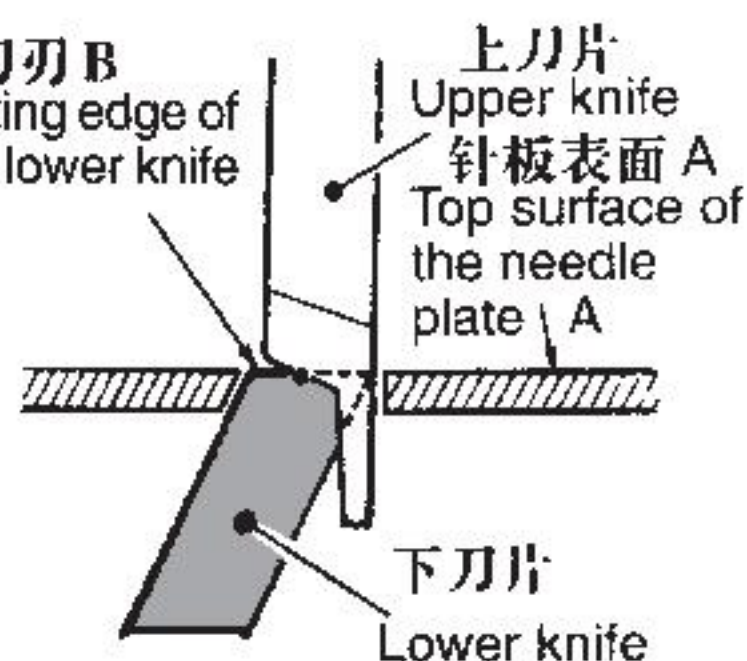
Loosening the screw ⑤
makes the lower knife
holder slide to the right.

转动手轮将上刀移动对准
如右图所示位置。

Turn the handwheel
as the drawing on the
right figure.



下刀刃 B
Cutting edge of
the lower knife
B



使针板表面 A 与下刀刃 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，确认剪切状况。

Check cutting action of knives.

零件手册

PARTS BOOK

Exploded view diagram of a mechanical assembly. The diagram shows the following components and their assembly relationships:

- 10009008**: Four screws at the top of the main housing.
- 2003248**: A bracket or cover plate on the left side.
- 10009101**: A screw securing the bracket.
- 10009104**: A small component, possibly a pin or washer, near the bracket.
- 10003489**: A central vertical component, possibly a shaft or pin.
- 10009452**: A small component on the right side.
- 100028400**: A long, thin component, possibly a rod or pin, on the right side.
- 10009065**: A small component at the bottom right.
- 10012906**: A small component at the bottom right.
- 10033784**: Four screws at the bottom left.
- 10009171**: A small component in the bottom center.
- 10033783** and **10012906**: Two small components at the bottom center.
- 10033784** and **10012906**: Two small components at the bottom right.
- 5.6mm** and **5.5 threads**: A dimension and thread specification for a hole in the bottom center.
- 3.4mm** and **3.4 threads**: A dimension and thread specification for a hole in the bottom right.

Exploded view diagram of the front of a 1987-1990 Ford Bronco. The diagram shows the front end assembly including the hood, grille, headlights, bumper, and various structural components. Numerous parts are labeled with their Ford part numbers. Key components shown include the hood (10008101), grille (10008967), headlights (10008988), bumper (10008988), and various structural members like the front crossmember (10008967) and front end rails (10008988). The diagram is a technical drawing with lines indicating the assembly sequence and fit of the parts.

Exploded view diagram of a mechanical assembly. The diagram shows the following components and their specifications:

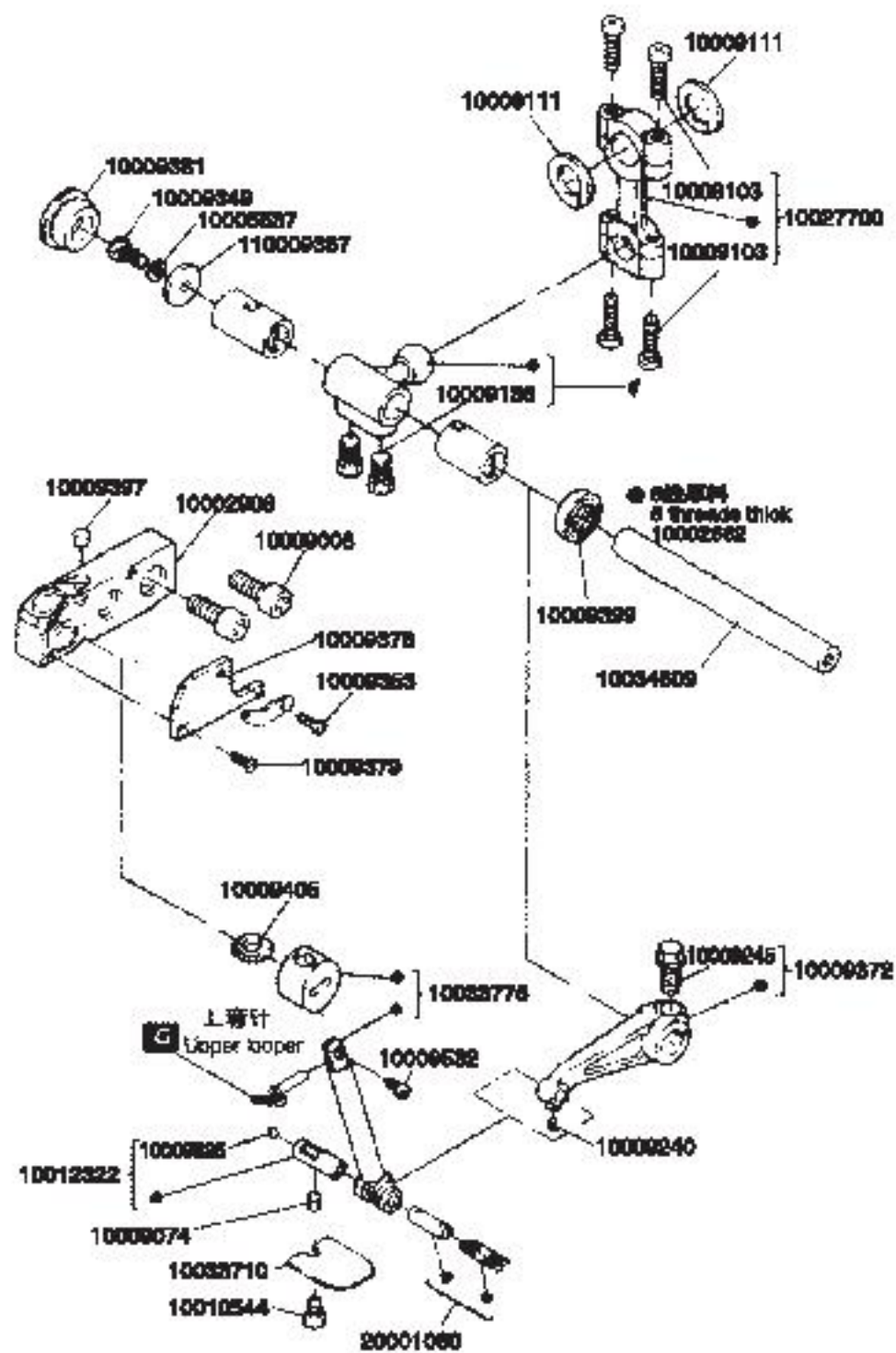
- Top Left Assembly:**
 - 10008185, 10008104, 10003705
 - 5.6mm 5.6 threads
 - 10010585, 10003747
 - 3.4mm 3.4 threads
- Central Shaft Assembly:**
 - 10008226
 - 10008167
 - 10012182
 - 20000862
 - 10008215
 - 10008204
 - 10008202
 - 10008201
 - 10008188
 - 10008703
 - 10009227
 - 10012182
 - 10008138
 - 10008218
 - 10008217
 - 10008220
 - 10008137
 - 10008788
- Right Side Assembly:**
 - 10022051
 - 10008115
 - 10008104
 - 10000198
 - 10008225
 - 20008800
 - 10009008
 - 10003704
- Bottom Left Assembly:**
 - 3.4mm 3.4 threads 10008187
 - 5.6mm 5.6 threads 100084821

5



请参照标准零件表

Please confirm the correct part by the gauge parts lists.

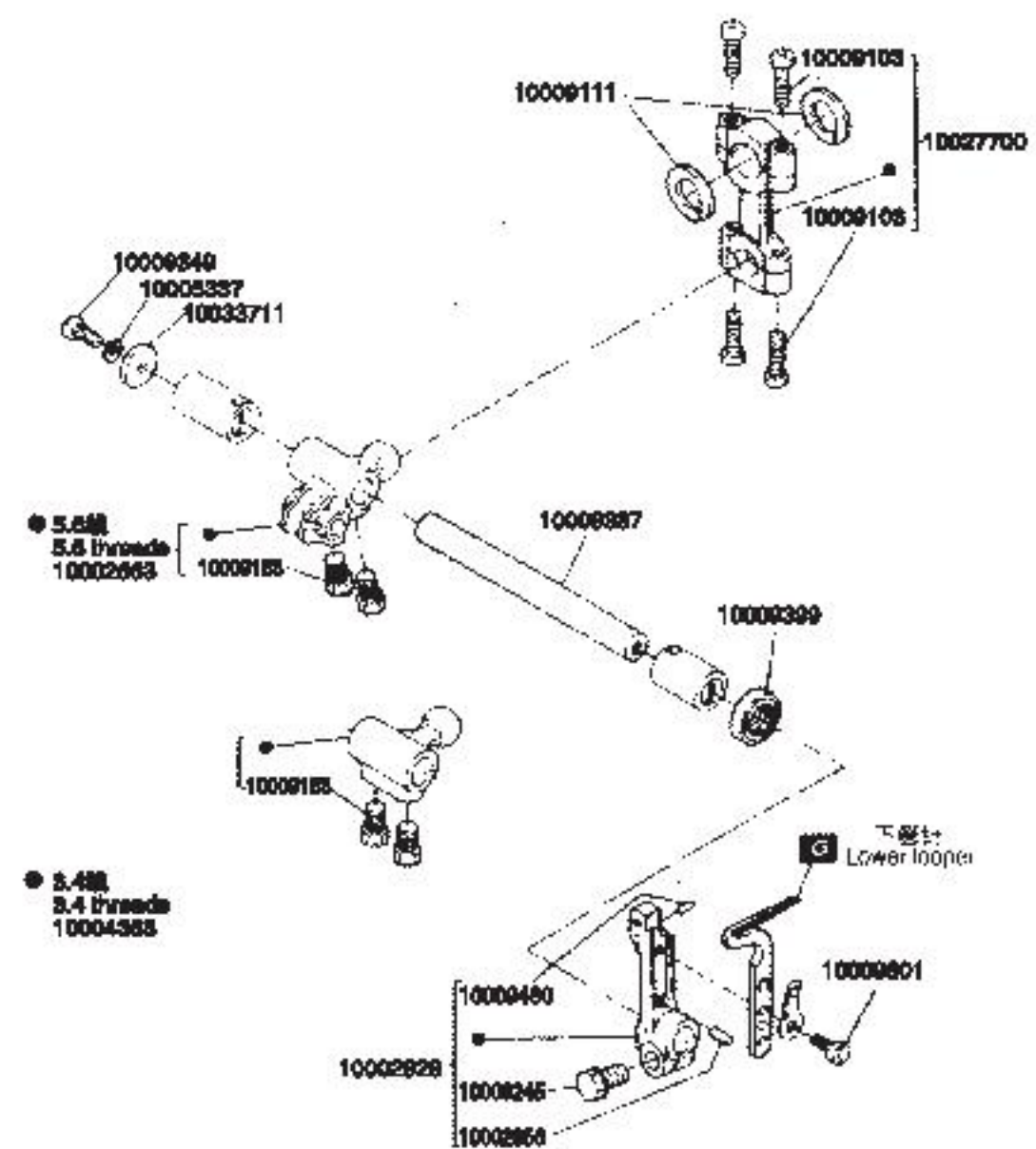


6



请参照标准零件表

Please confirm the correct part by the gauge parts lists.

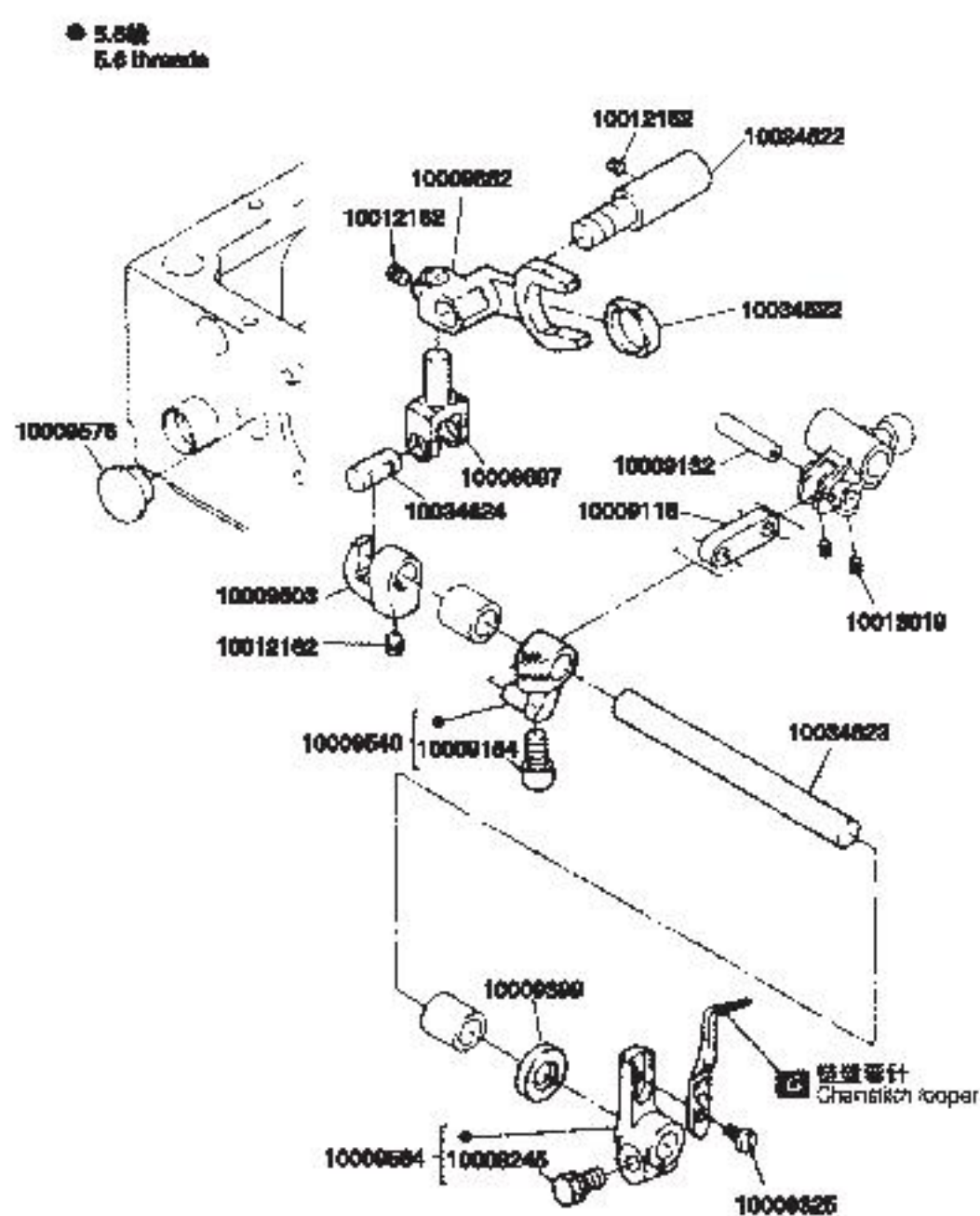


7



请参照标准零件表

Please confirm the correct part by the gauge parts lists.

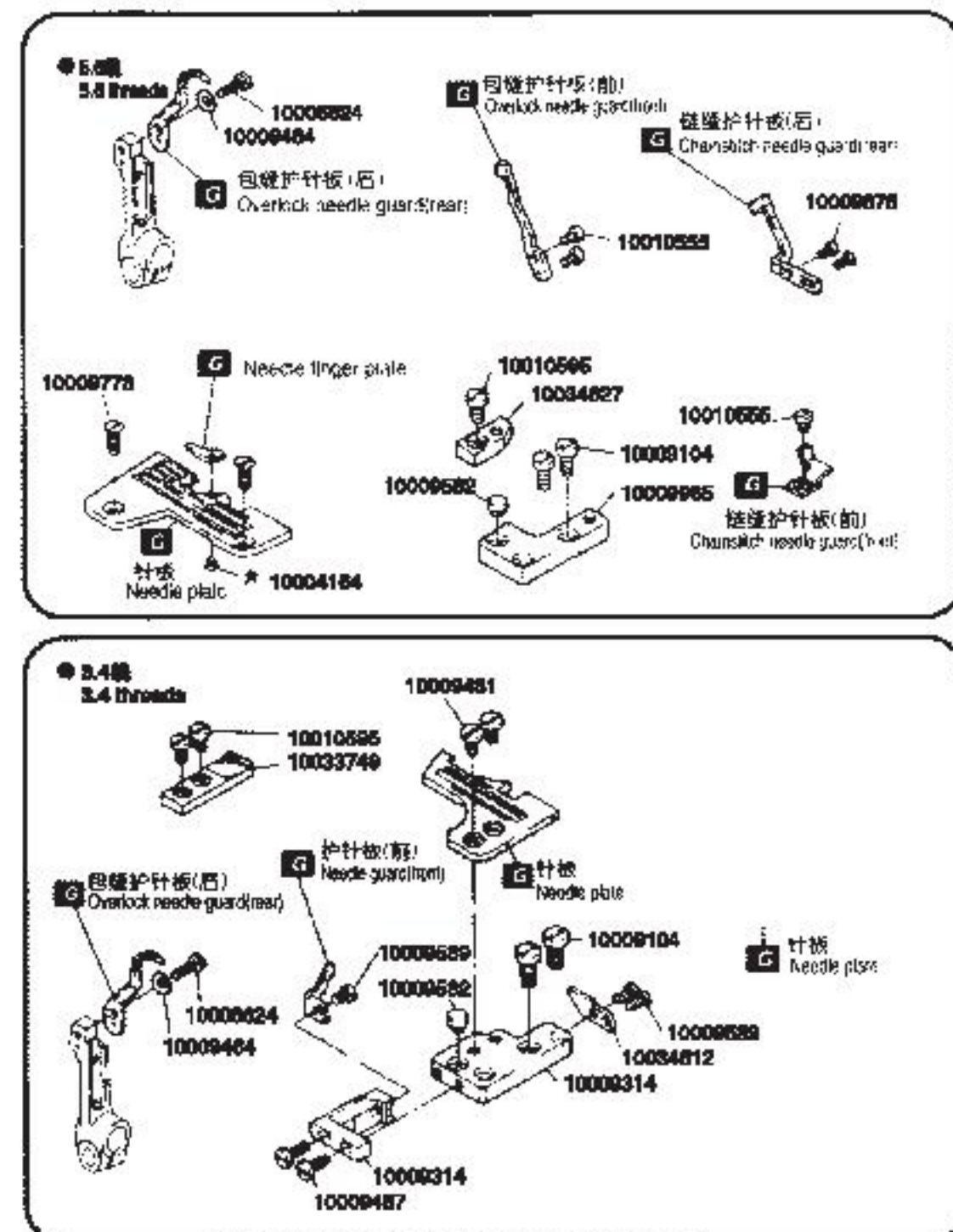


8



请参照标准零件表

Please confirm the correct part by the gauge parts lists.

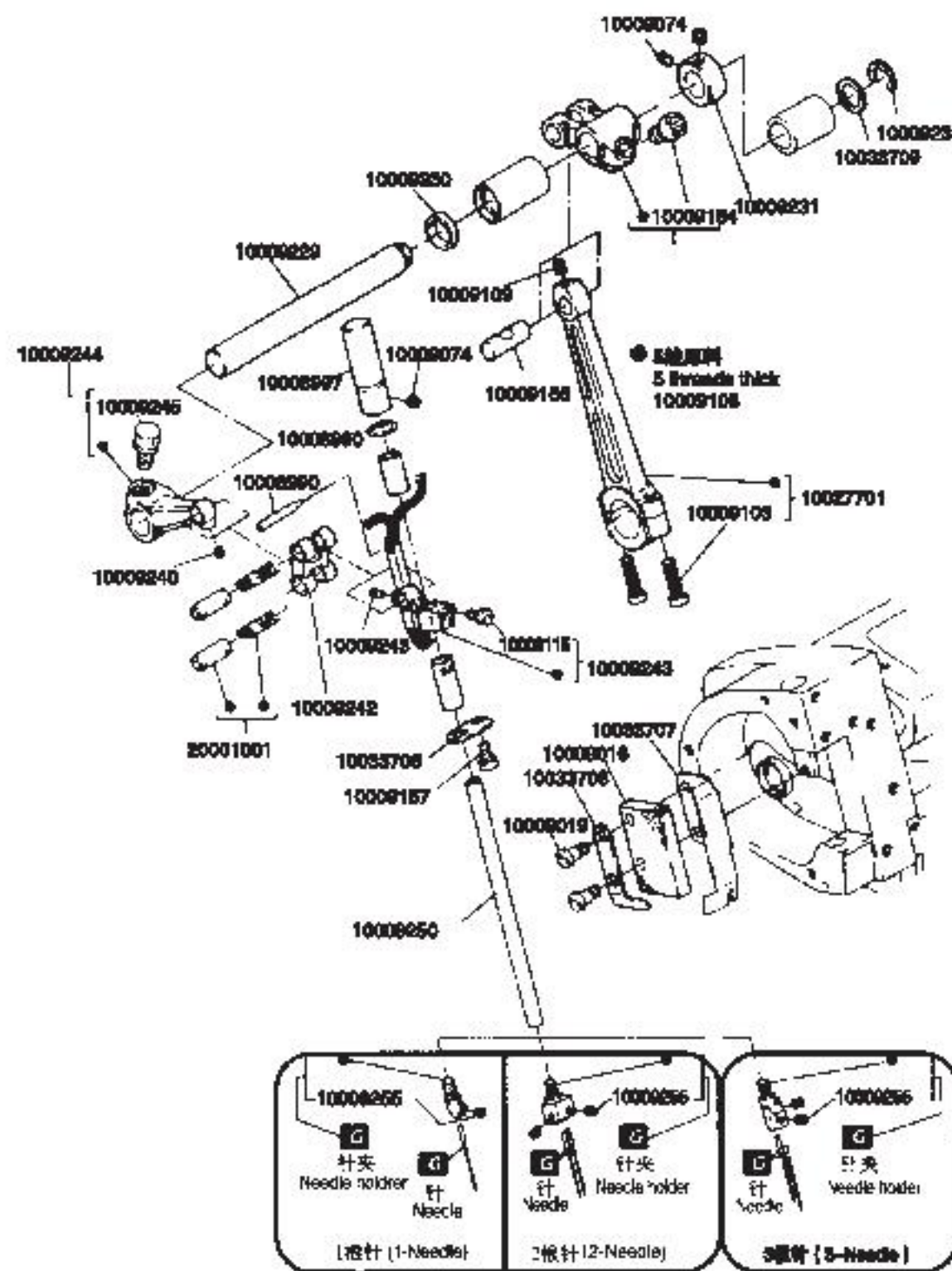


9



请参照标准零件表

Please confirm the correct part by the gauge parts lists.

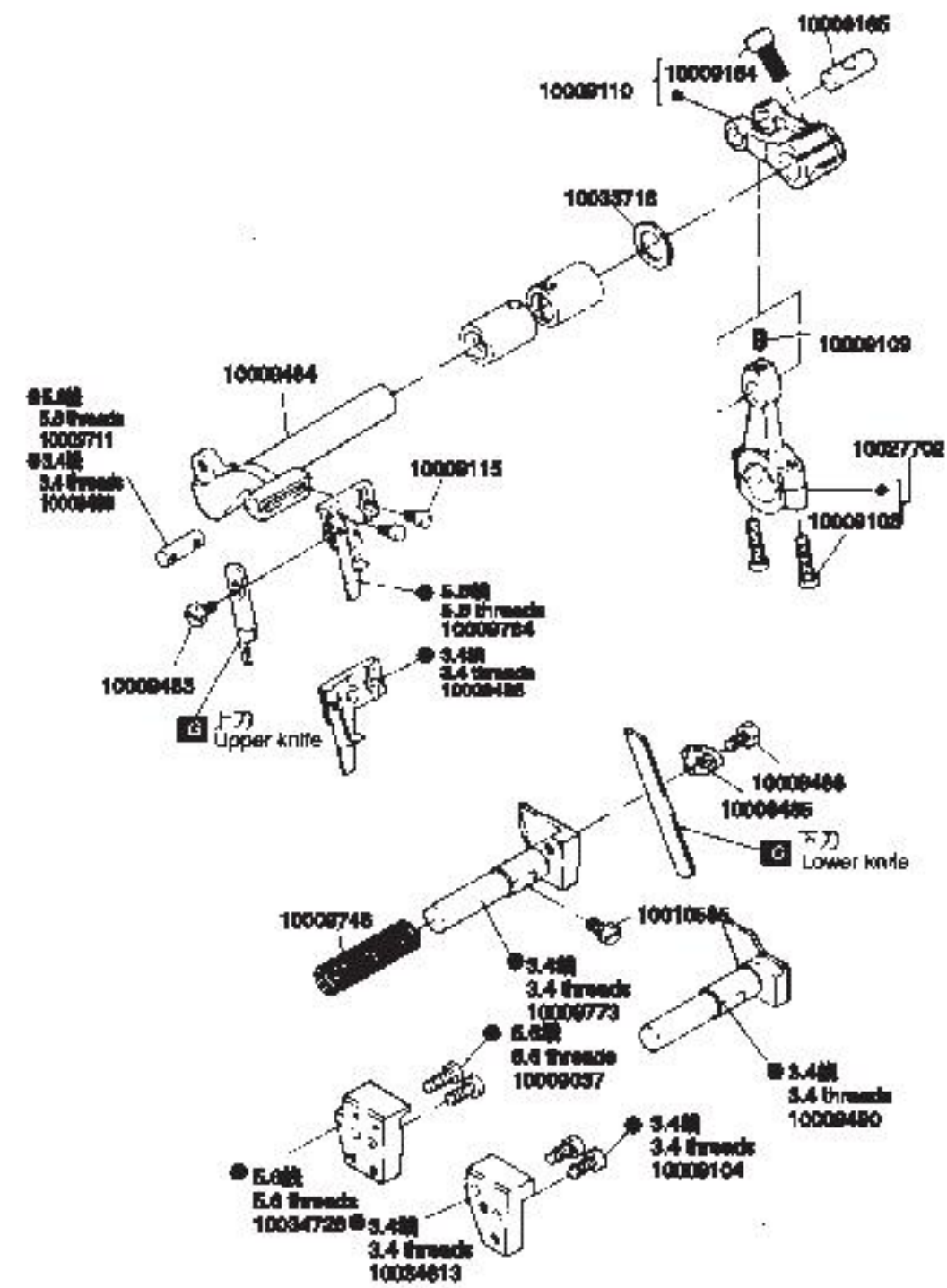


10



请参照标准零件表

Please confirm the correct part by the gauge parts lists.

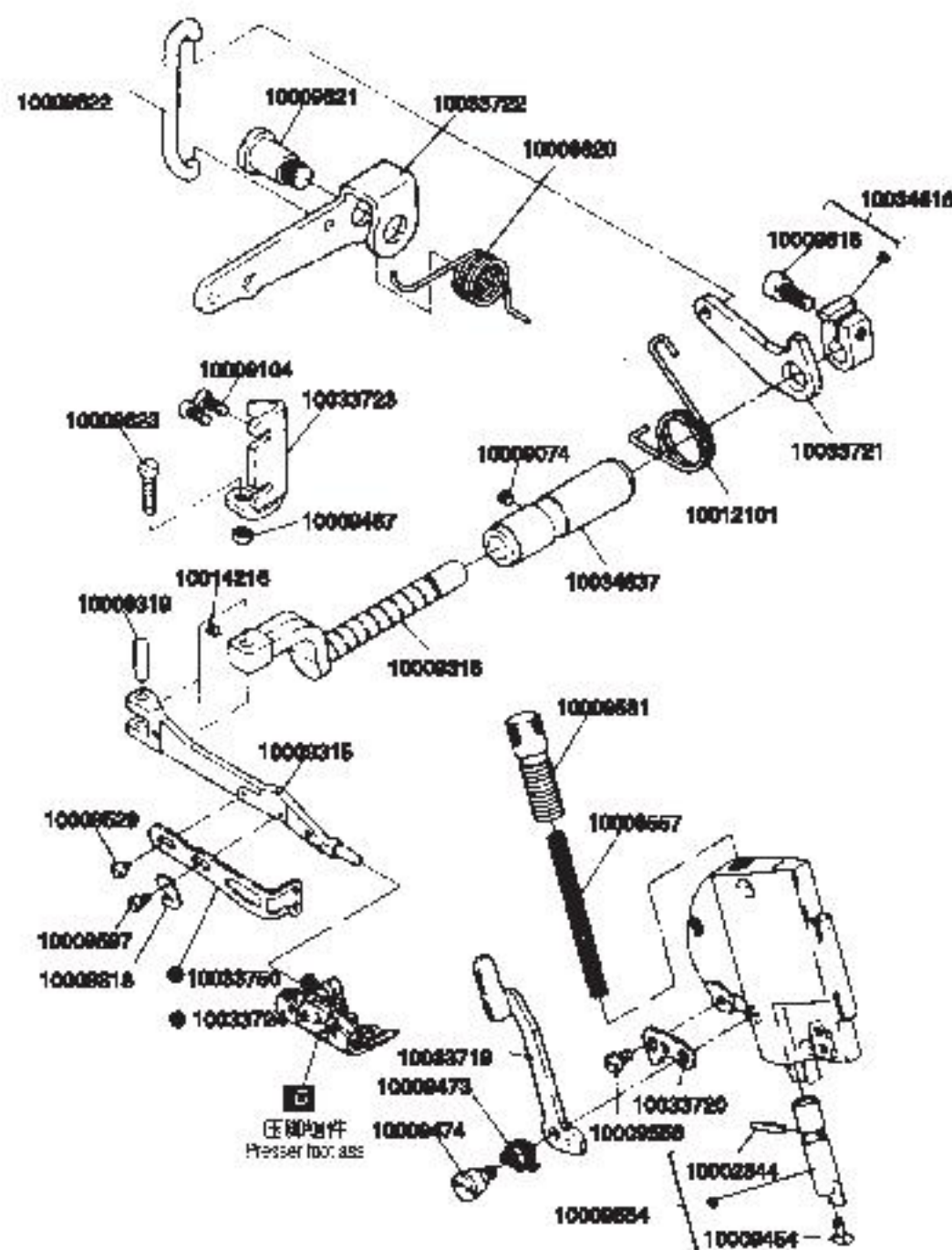


11



请参照标准零件表

Please confirm the correct part by the gauge parts lists.

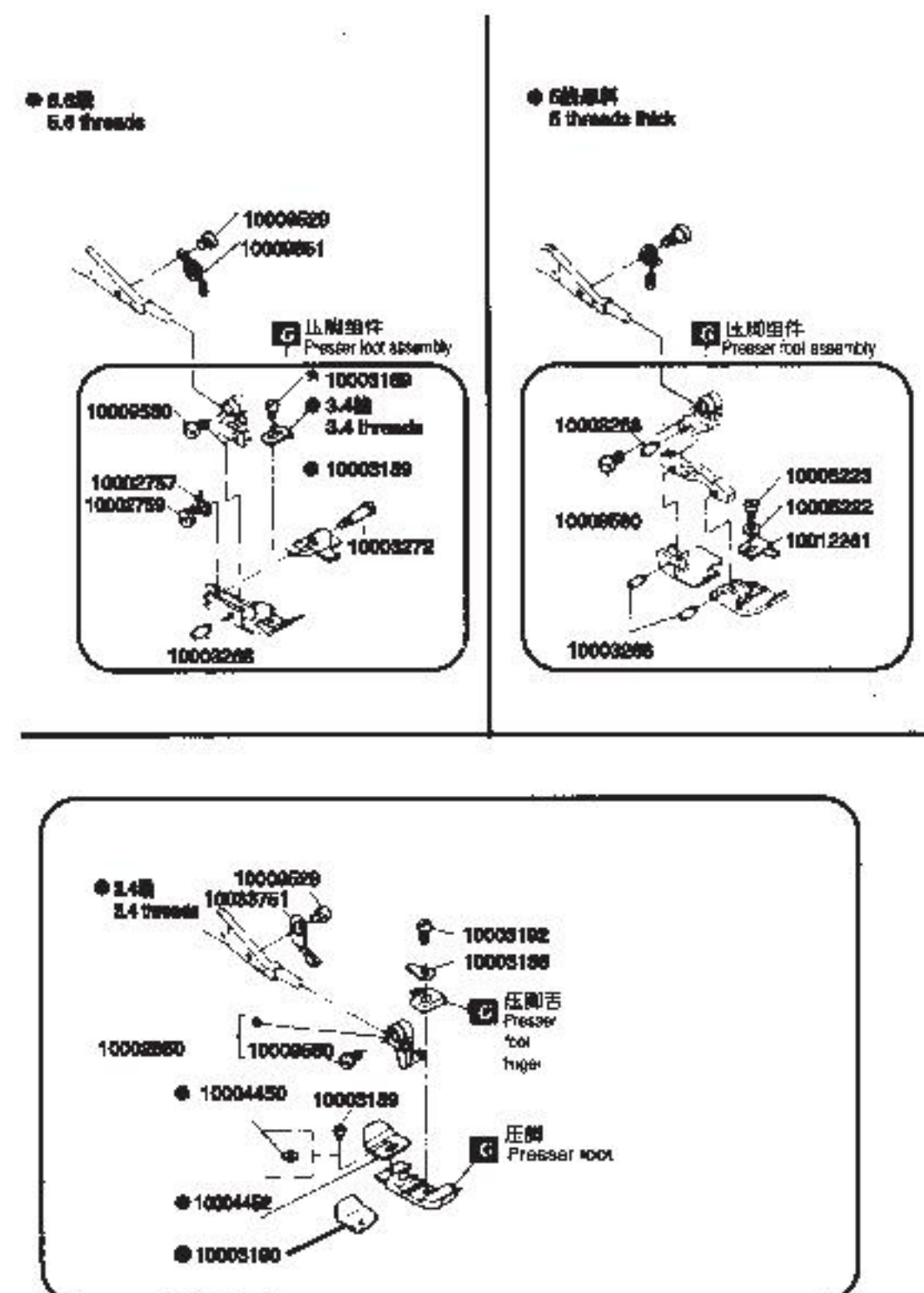


12



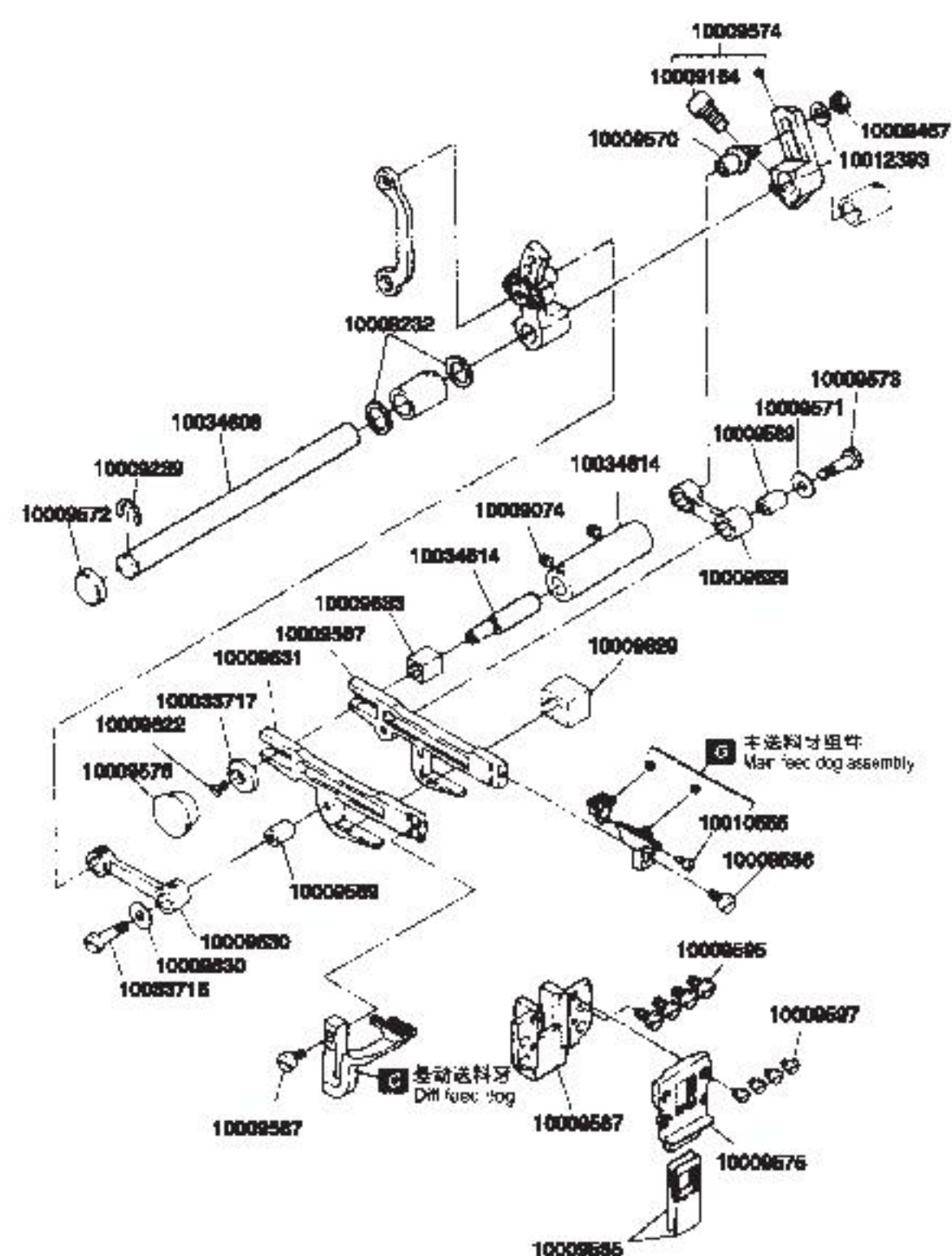
请参照标准零件表

Please confirm the correct part by the gauge parts lists.



[illegible]

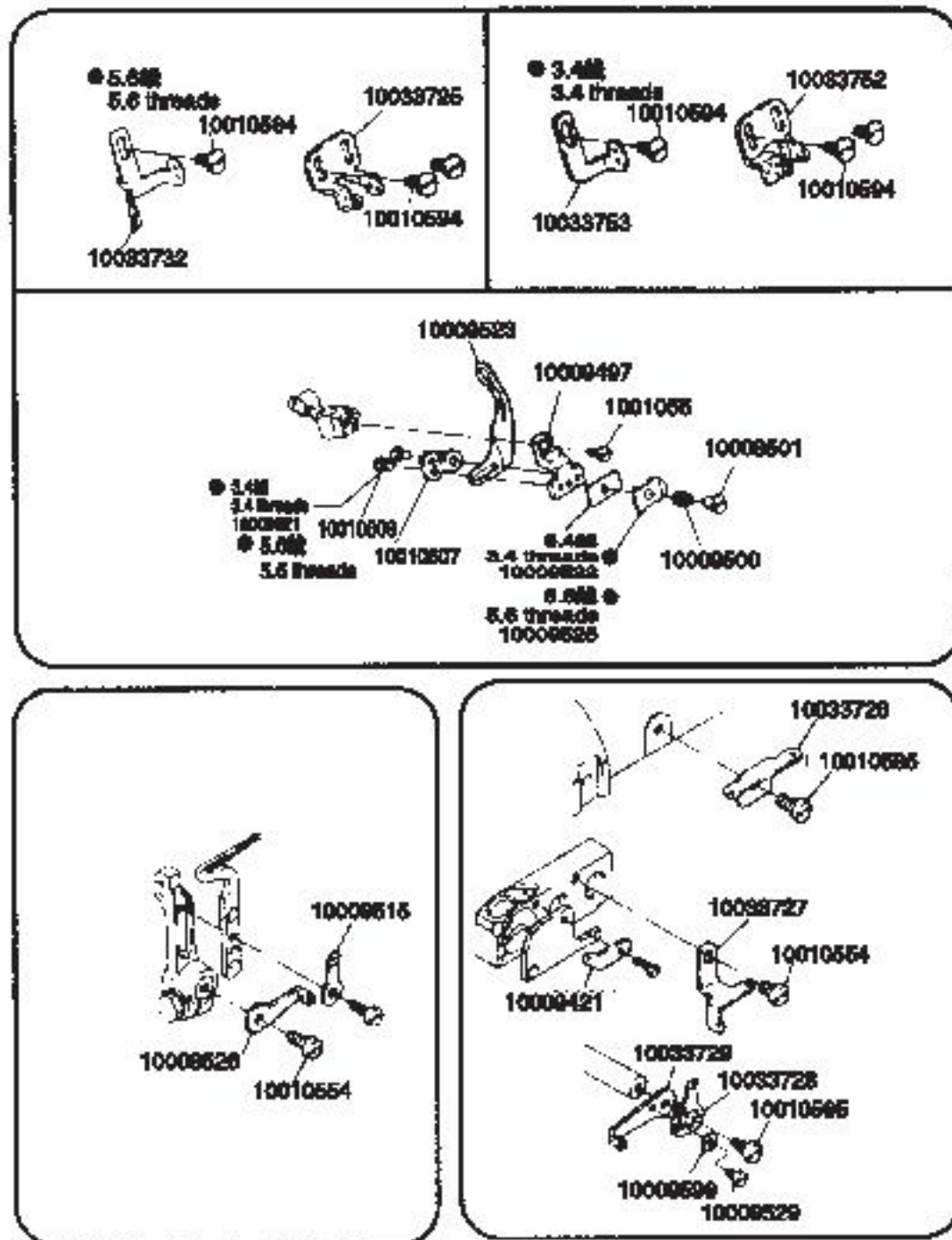
请参照标准零件表
Please confirm the correct part by the gauge parts lists.



Exploded view diagram of the front suspension assembly, showing various components and their part numbers:

- 10033744
- 10033783
- 10009636
- 10033743
- 10009104
- 100010472 (3mm)
- 100010474 (2mm)
- 10008484
- 70000622
- 10010595
- 3.4mm
- 3.4 threads
- 10000498
- 10009325
- 70000622
- 10010471 (NG 3 mm)
- 10010473 (NG 5 mm)
- 10010595
- 10009628
- 10009422
- 10003068
- 10010471
- 10009104

17

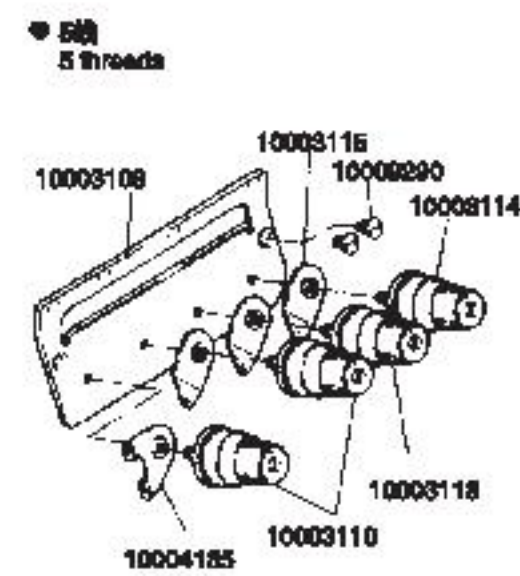
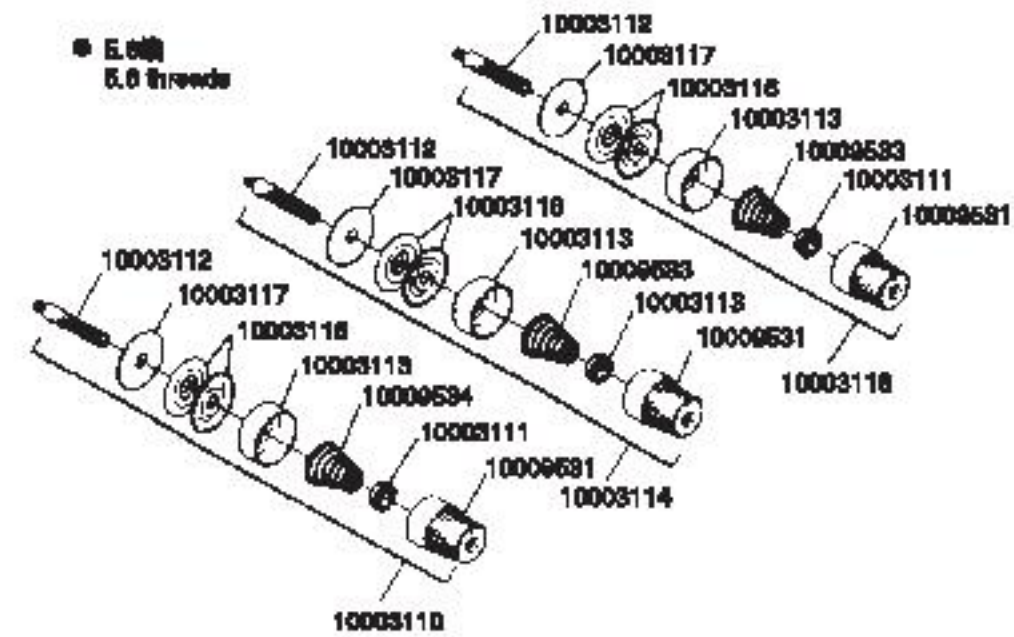


18

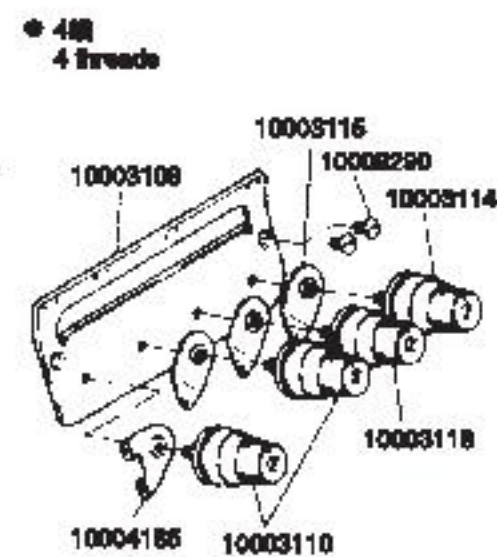
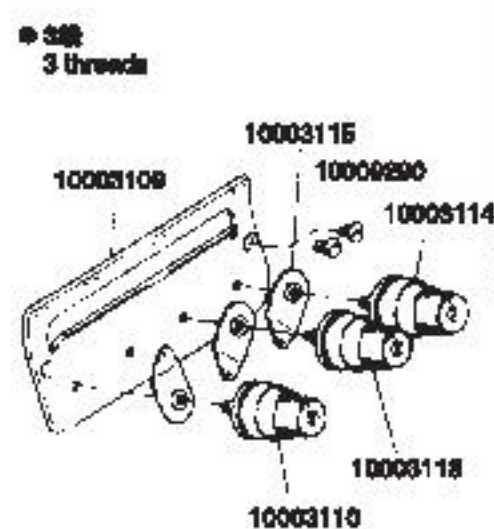
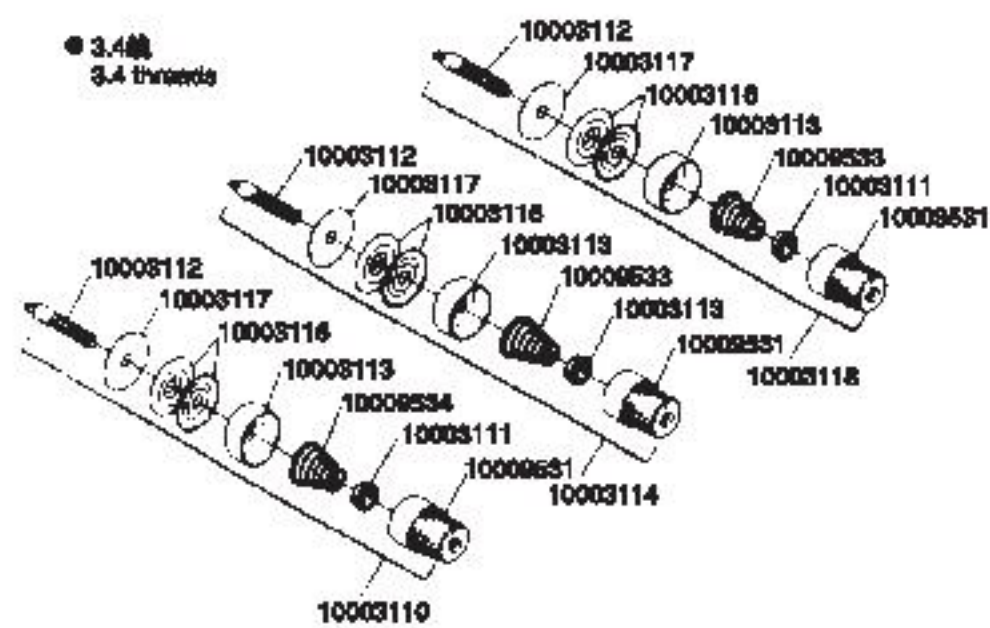
G

请参照标准零件表

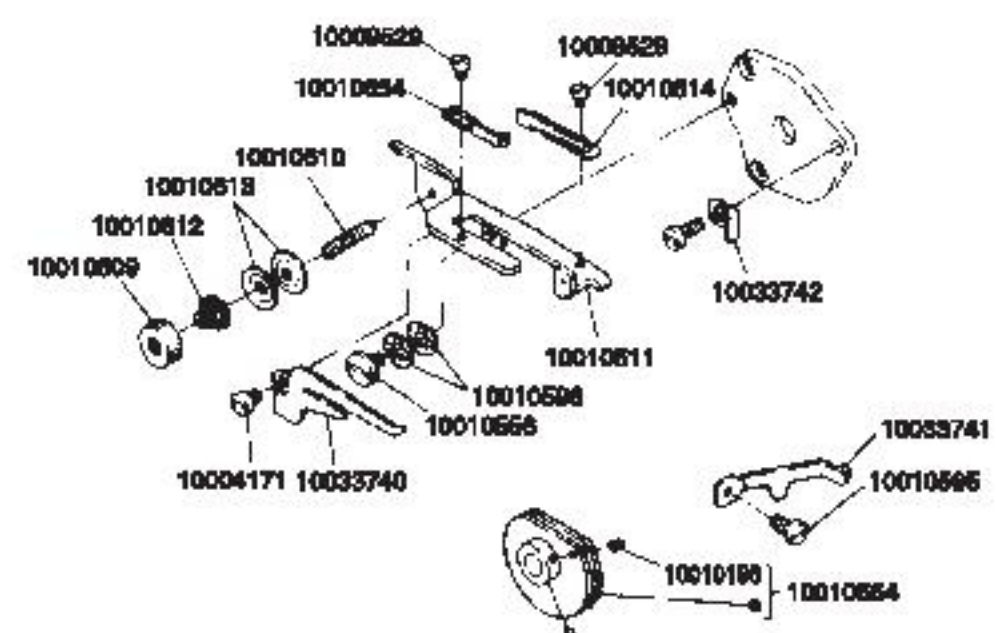
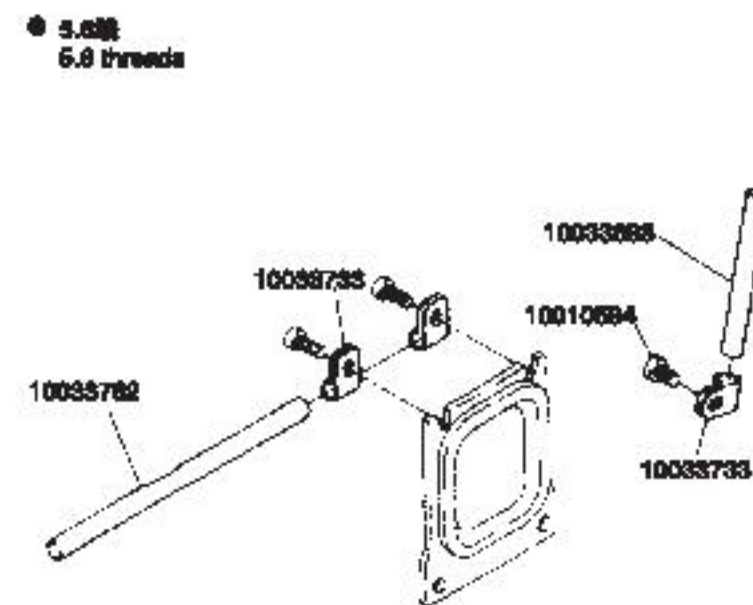
Please confirm the correct part by the gauge parts lists.



19

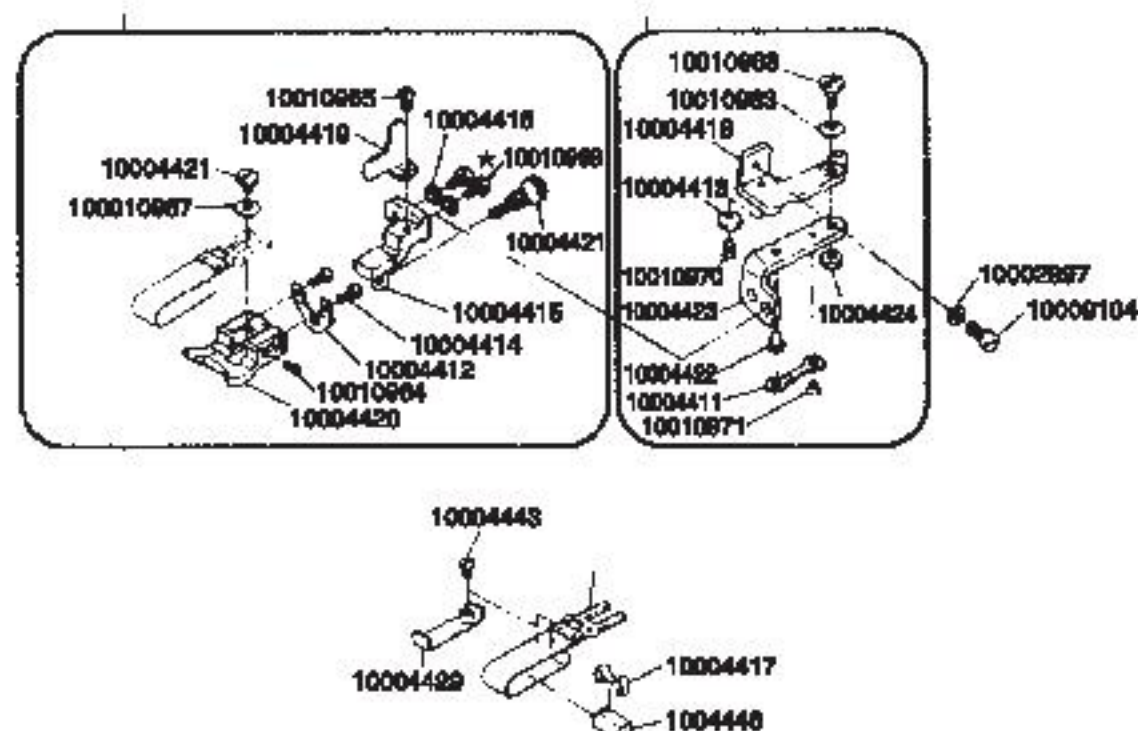


20

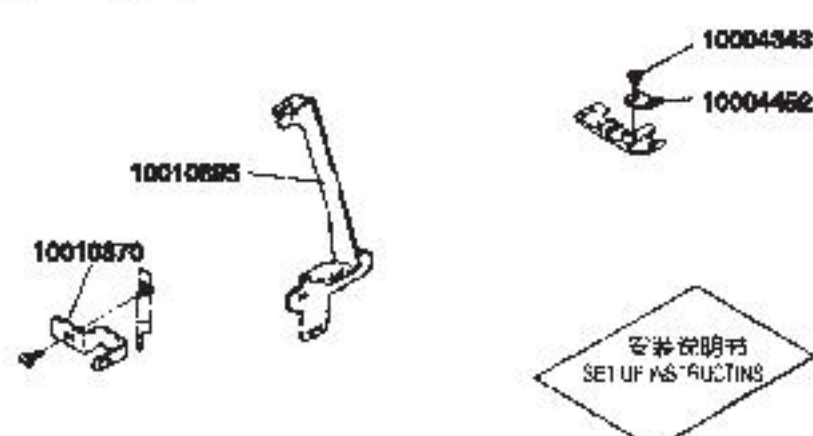


21

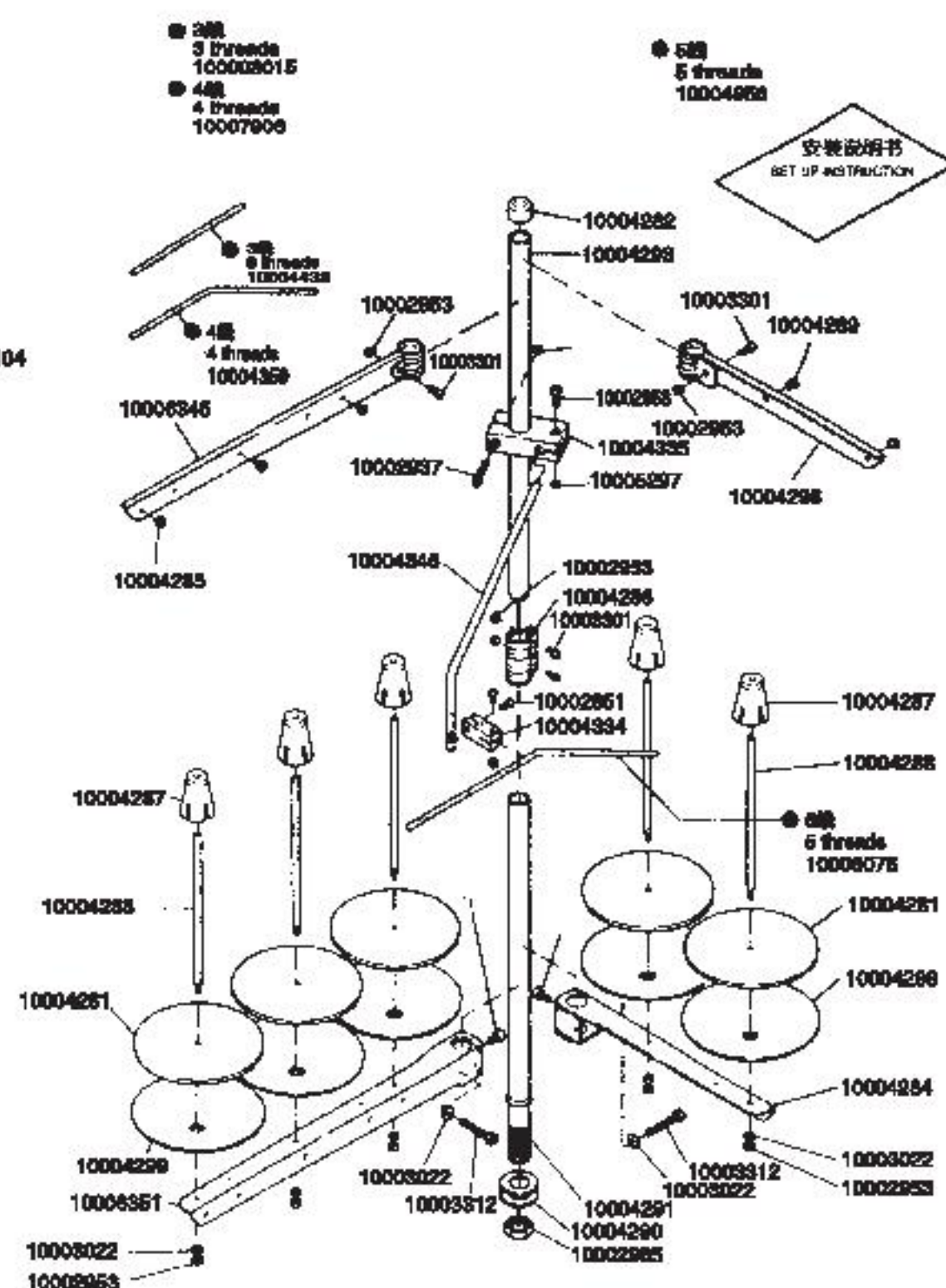
● 盲点: Blind hemming.



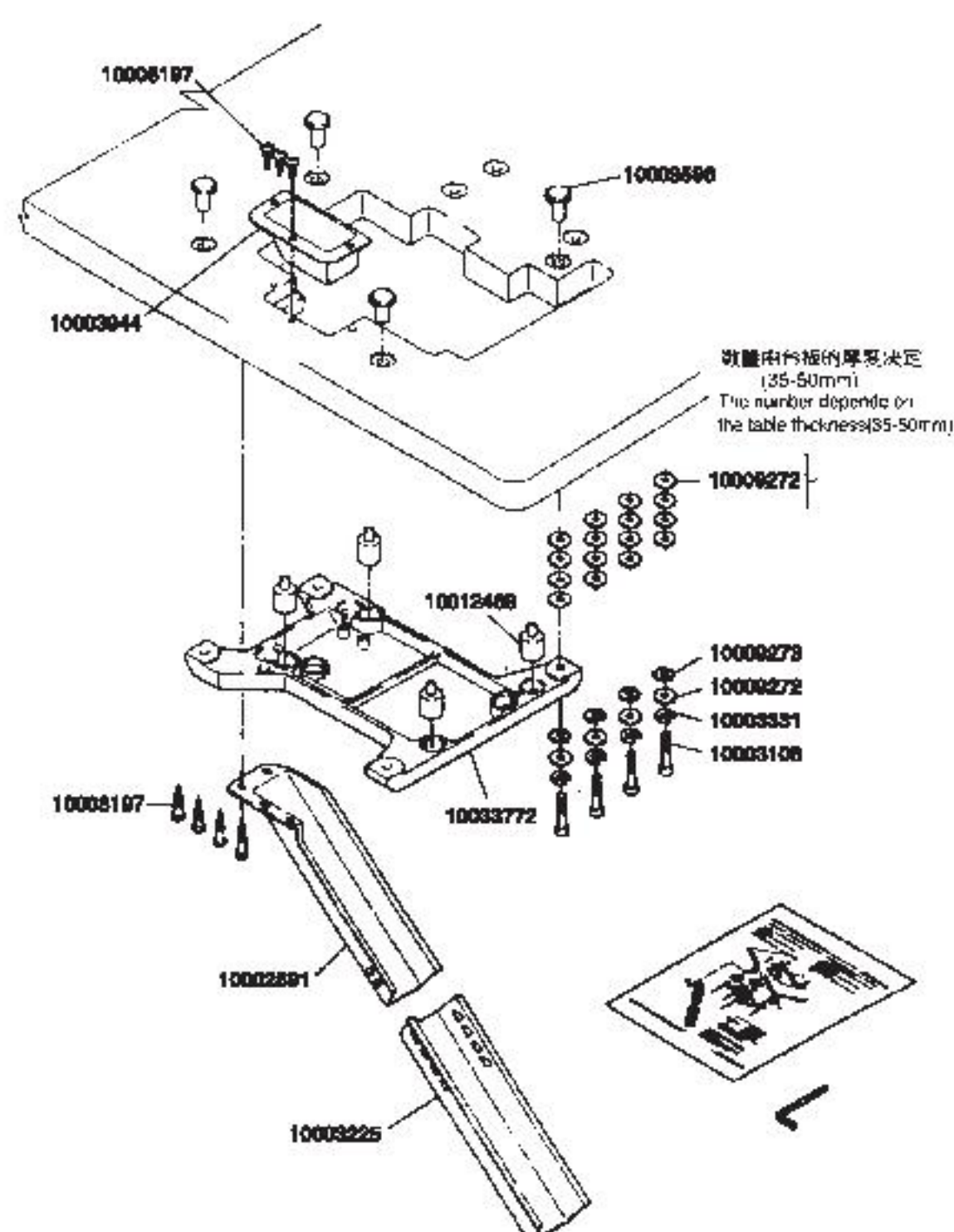
卷边附件(Attaching tape)



22

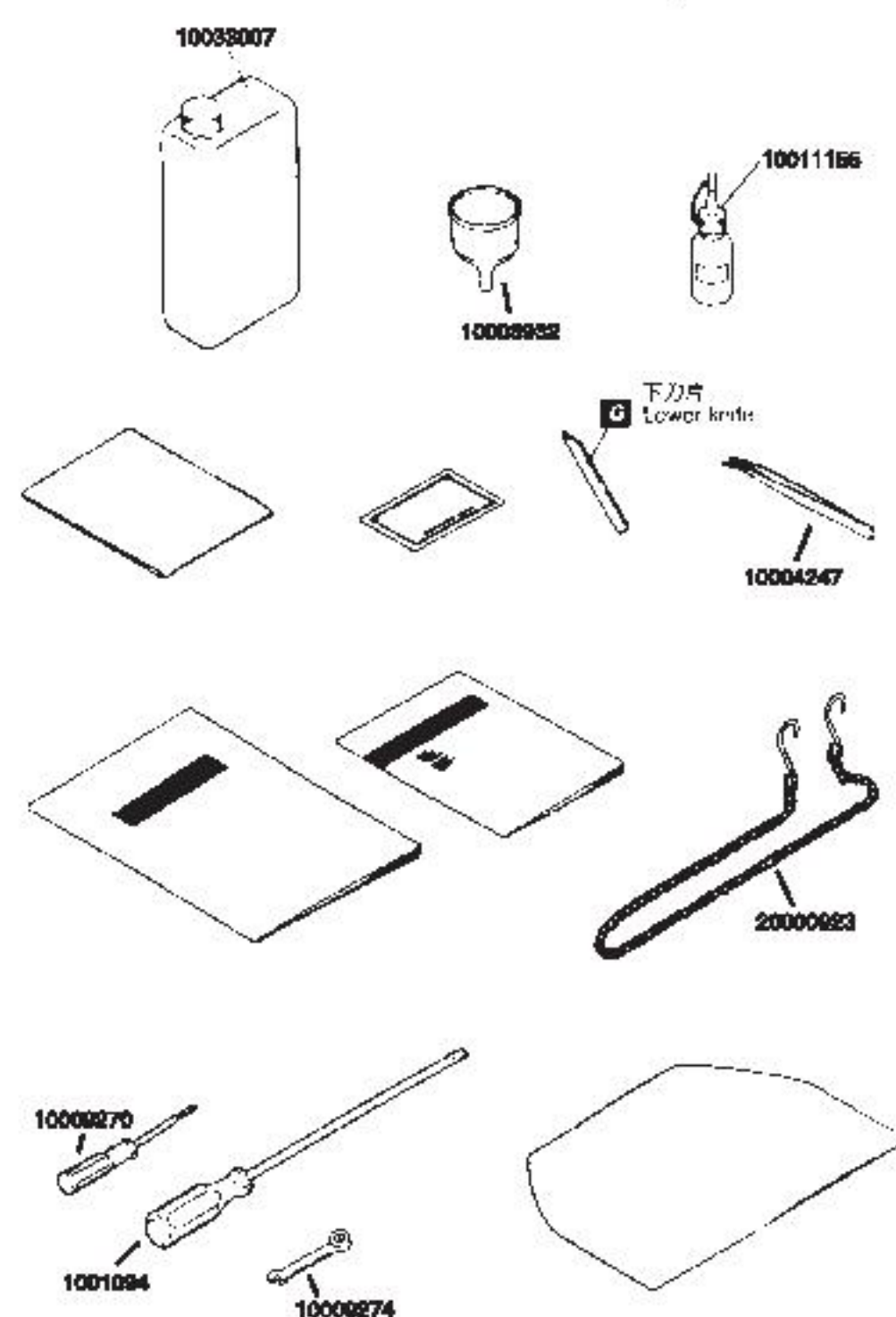


23

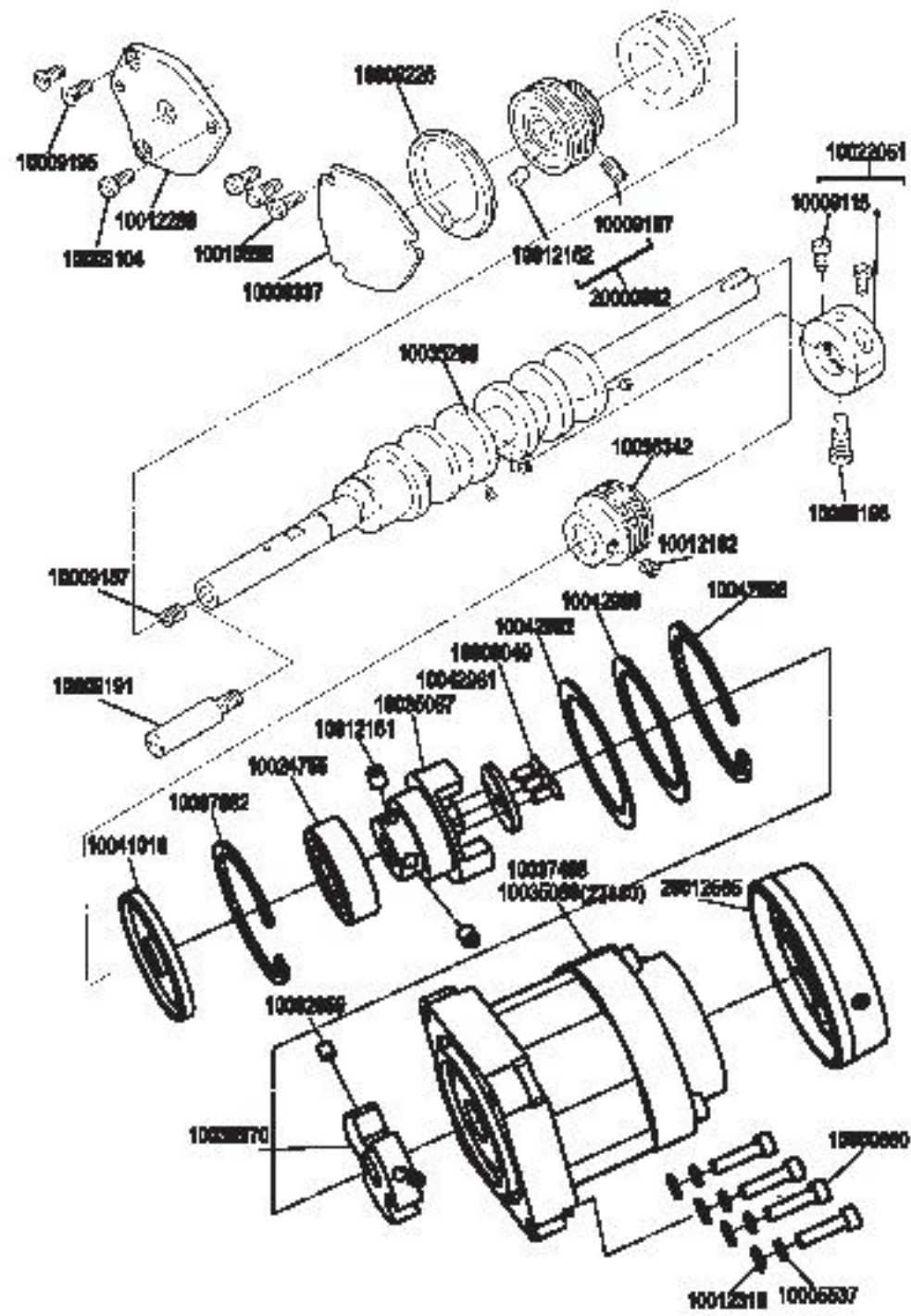


24

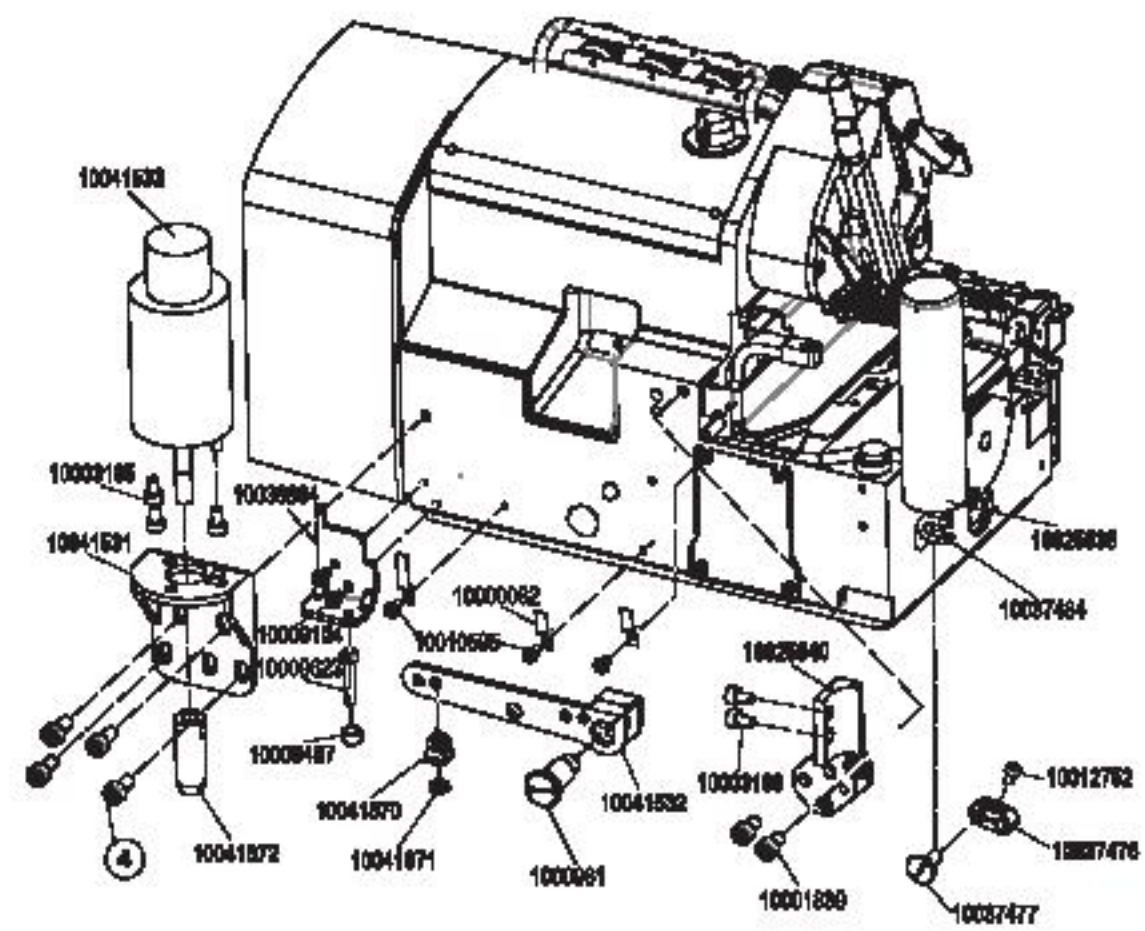
G 请参照标准零件表
Please confirm the correct part by the gauge parts lists.



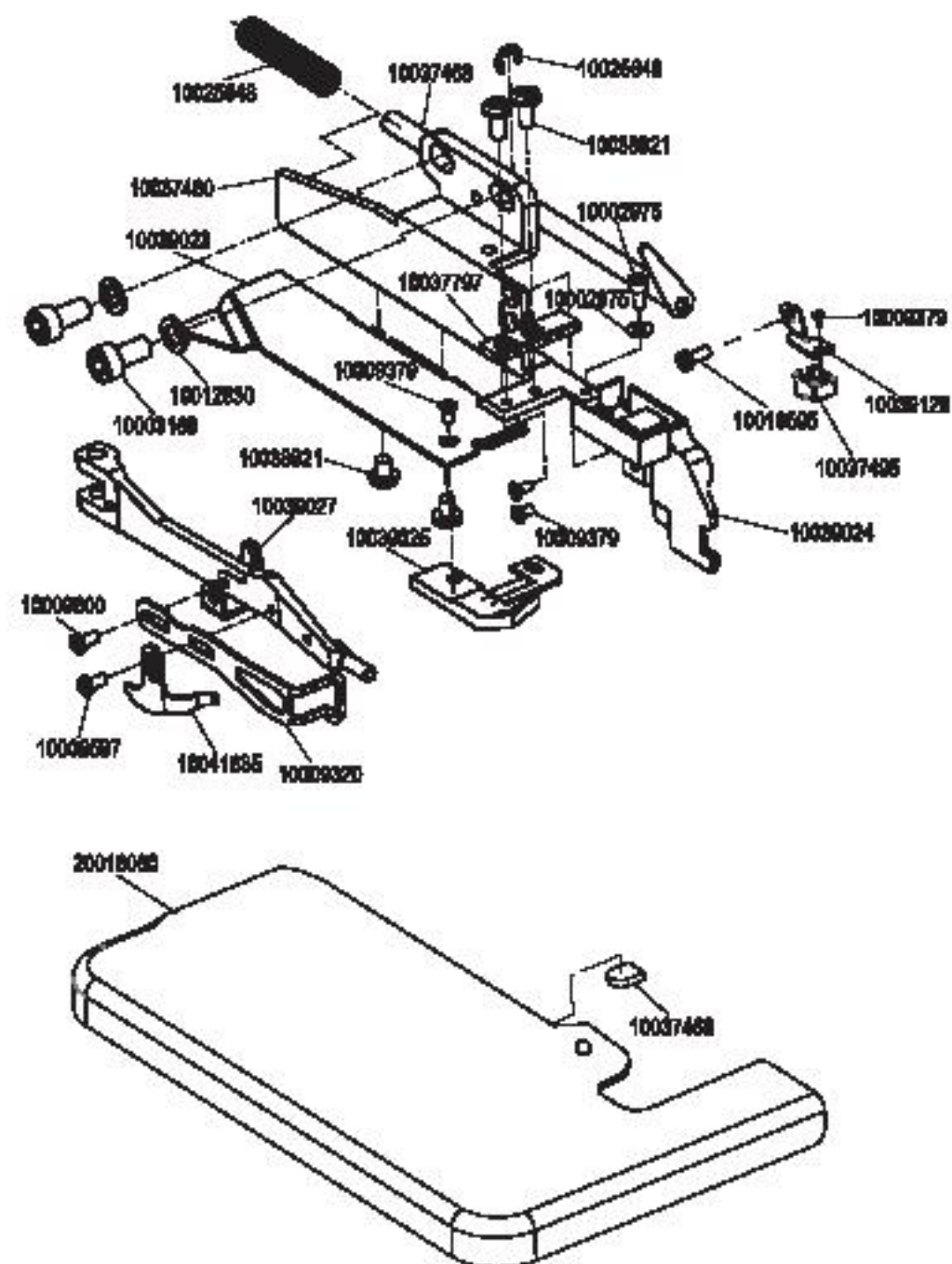
25



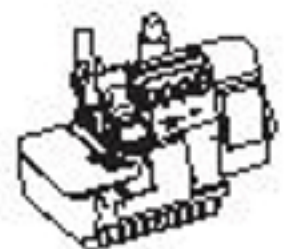
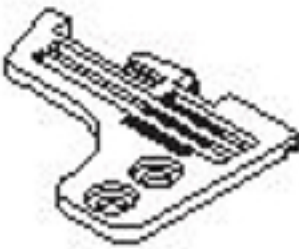
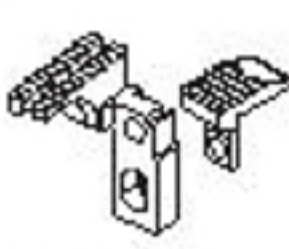
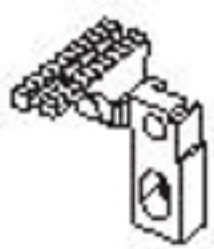
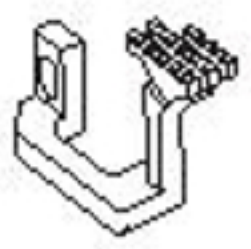
26



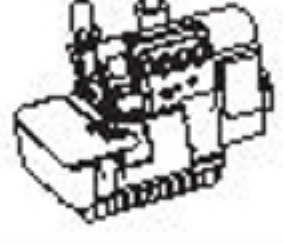
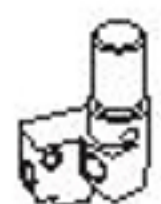
27



专用件目录表 GAUGE PARTS LIST

													
机型	针板	主送料牙 组件	主送料牙	辅助送料牙	差动送料牙	压脚	吐线舌	上弯针	下弯针	上刀	下刀	包缝护针板	
												前	后
MODEL	NEEDLE PLATE	MAIN FEED DOG ASSY.	MAIN FEED DOG	AUX FEED DOG	DIFF FEED DOG	PRESSER FOOT	PRESSER FOOT FINGER	UPPER LOOPER	LOWER LOOPER	UPPER KNIFE	LOWER KNIFE	OVERLOCK NEEDLE GUARD	
												FRONT	REAR
ZJ880-3-17	10009578	10033777	10003209	10003208	10033778	10002849	10004564	10009609	10009516	10009611	10010866	10009313	10009517

专用件目录表 GAUGE PARTS LIST

										
机型	针夹	机针	直针夹线器 组件	上弯针夹线 器组件	下弯针夹线 器组件	手轮	直驱手轮	电机罩	皮带轮罩	线架
MODEL	NEEDLE HOLDER	NEEDLE	TENSION SPRING ASSY	TENSION SPRING ASSY	TENSION SPRING ASSY	HAND WHEEL	HAND WHEEL	COVER	BELT COVER ASSY	THREAD STAND ASSY
ZJ880-3-17	10009296	10021310	10006902	10006751	10006879	10033769	10036967	10035092	10008968	10008015