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I、规格

I. Specifications

1	缝制范围 Sewing range	ZJ-AM-5770A-410: Y 向 410mm, X 向无限制 (出厂 2000mm) ZJ-AM-5770A-410: 410mm to direction Y and unlimited to direction X (factory-setup 2000mm)
2	最高缝纫速度 Max. sewing speed	2500rpm (间距在 3.5mm 以内) 2500rpm (spacing within 3.5mm)
3	缝迹长度 Stitching length	0.1-12.7mm
4	压脚模板送布 Presser-foot template cloth feeding	间断送布(脉冲马达双轴驱动方式) Intermittent cloth feeding (double-shaft drive mode by pulse motor)
5	针杆行程 Need bar stroke	38mm
6	使用机针 Needle used	DP×5 10#
7	压框上升量 Ascent of pressure frame	10mm
8	辅助压脚上升量 Ascent of auxiliary presser foot	10mm
9	中压脚上升量 Ascent of middle presser foot	20mm
10	可以变更中压脚上下位置 Adjustment of up/down position of middle presser foot	最大 0-7mm Maximum 0-7mm
11	旋梭 Rotating shuttle	整倍旋梭 Integer-multiple rotating hook
12	使用机油 Oil used	旋梭: 10 号白油, 齿轮箱: 壳牌 22 号液压油 Rotating shuttle: #10 white oil, gearbox: Shell hydraulic oil #22
13	花样数据记忆 Pattern data memory	最大可存储 999 图案 Capable of storing 999 patterns at most
14	暂停功能 Pause function	在缝制过程中可以让缝纫机停止 Stop the sewing machine in process of sewing
15	模板识别功能 Template recognition function	最多可以识别 31 个模板 Capable of recognizing 31 template at most
16	缝纫速度限制 Sewing speed limitation	200-2500rpm
17	花样选择功能 Pattern selection function	图案 NO.选择方式 (1~999) Pattern-number selection mode (1~ 999)
18	底线计数器 Bottom thread counter	加数计数/减数计数方式 (0-9999) Count-up/down mode (0-9999)
19	缝制计数器	加数计数/减数计数方式 (0-9999)

	Sewing counter	Count-up/down mode (0-9999)
20	存储器后备 Memory back-up	切断电源时,自动地记忆使用的图案 Capable of store the patterns used in case of power cut
21	缝纫机马达 Sewing machine motor	550 W 伺服马达 550W servomotor
22	外形尺寸 Overall dimensions	1530×1250×1150
23	重量 Weight	300Kg
24	消费电力 Power consumption	0.5KW
25	使用温度范围 Operation temperature range	5°C-40°C
26	使用湿度范围 Operation moisture range	20%~80% (无结露) 20%~80% (without moisture condensation)
27	电源电压 Supply voltage	额定电压±10% 50 / 60 Hz Rated voltage ±10% 50 / 60 Hz
28	使用空气压力 Air pressure	0.5~0.55 MPa
29	空气消费量 Air consumption	1.8dm ³ /min
30	针杆上死点停止功能 Top-dead-center needle-rod stopping function	缝制结束后,可以让针杆回到上死点位置 Capable enabling the needle rod to return to its top dead center position when sewing is over

II、 各部的名称

II. Names of parts

CONFIGURATION

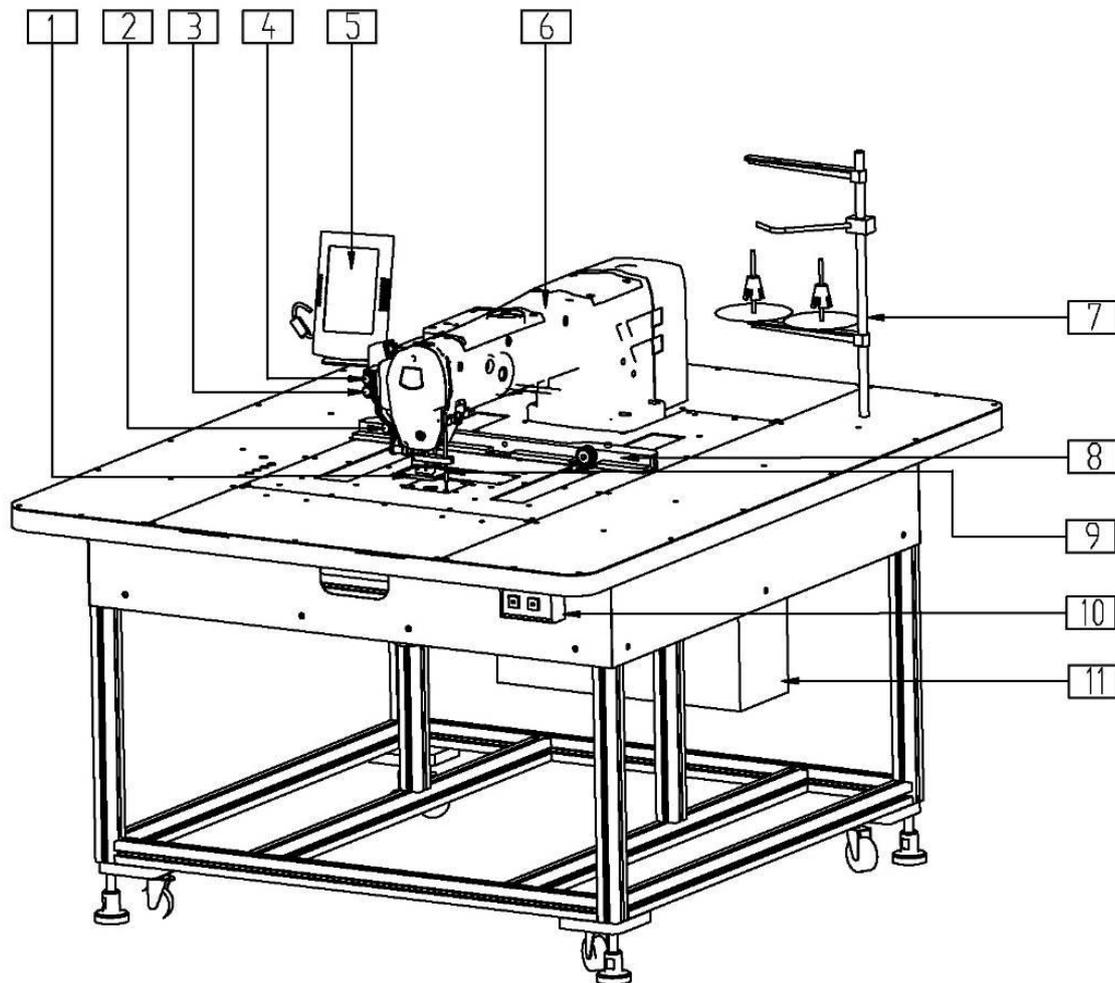


图 1

Figure 1

1、 辅助压脚

1. Auxiliary presser foot

2、 急停开关

2. Emergency stop switch

3、 启动按钮

3. Start button

4、 压框按钮

4. Pressure frame button

5、 操作屏

5. Operation panel

6、缝纫机机头

6. Sewing machine head

7、二线架及辅助线架

7. Two-thread stand and auxiliary thread stand

8、压框

8. Pressure frame

9、记号笔

9. Marking pen

10、电源开关

10. Power switch

11、电控箱

11. Electric cabinet

III、拆箱、安装

III. Unpacking and Installation

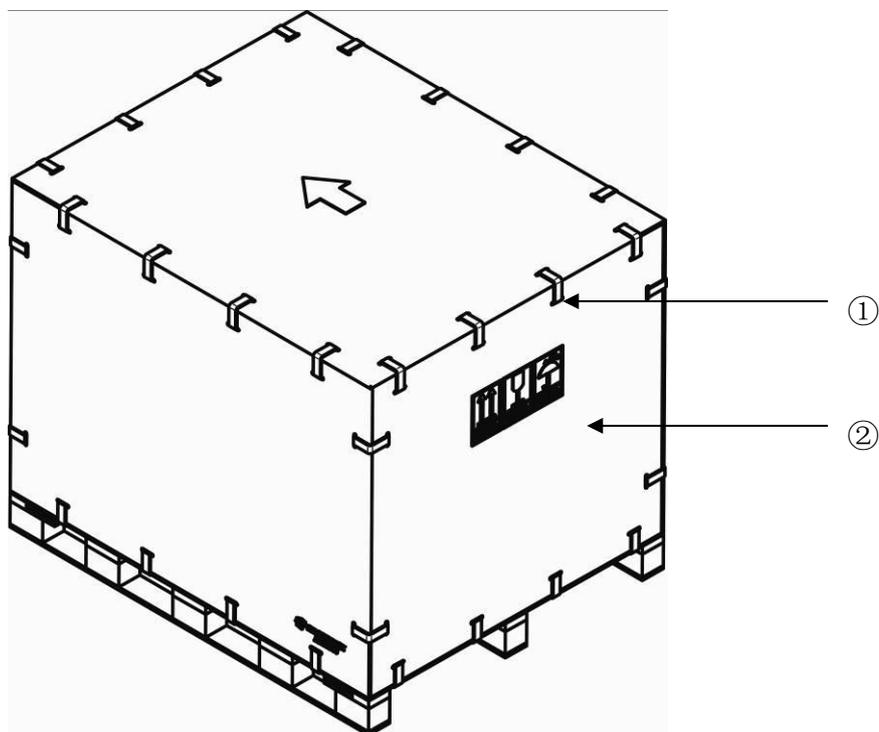


图 2

Fig. 2

步骤 1、撬开板扣①，卸下 4 块围板②；

Step 1: pry open board buckle ①, and remove 4 lateral plates ②;

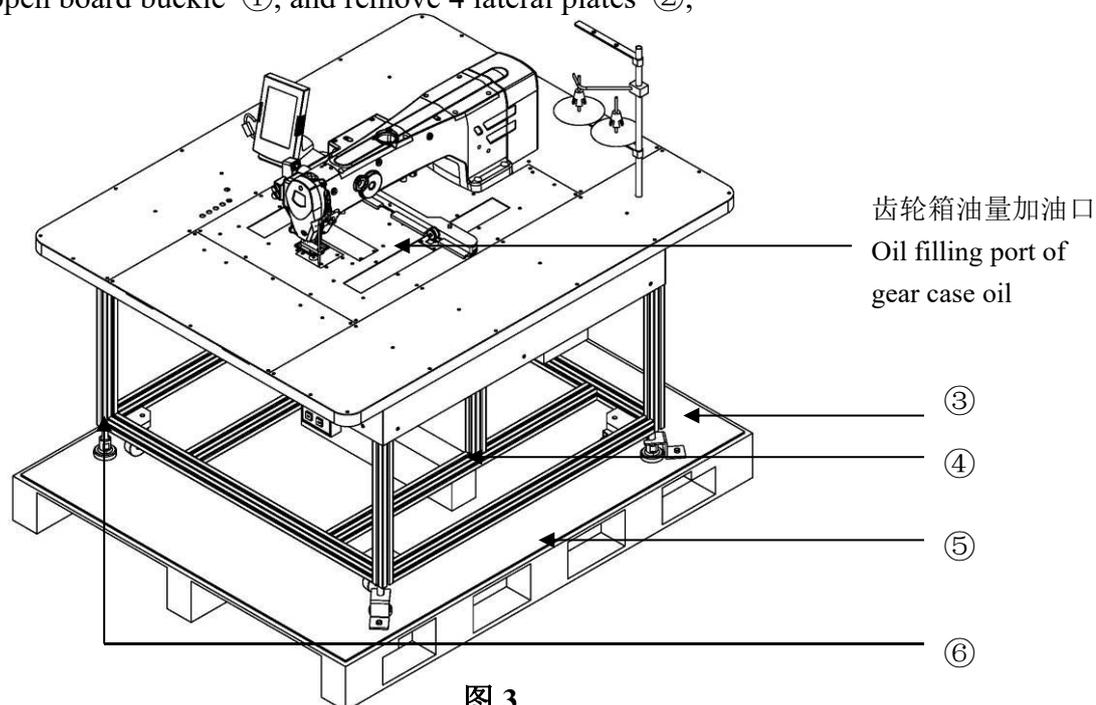


图 3

Figure 3

步骤 2、松开固定板③，敲出支撑条④；

Step 2: unclamp retaining plate ③, and knock out support rod ④;

步骤 3、将脚座⑥拧离托盘⑤，然后将机器推下托盘；

Step 3: Screw off foot stand ⑥ on pallet ⑤, and move the machine out of the pallet;

步骤 4、安装操作屏 5 和二线架及辅助线架 7，如图 1。

Step 4: Mount the operation panel 5, 2-thread stand and auxiliary thread stand 7, as shown in Fig.1.

IV、模板的制作

IV. Making of Template

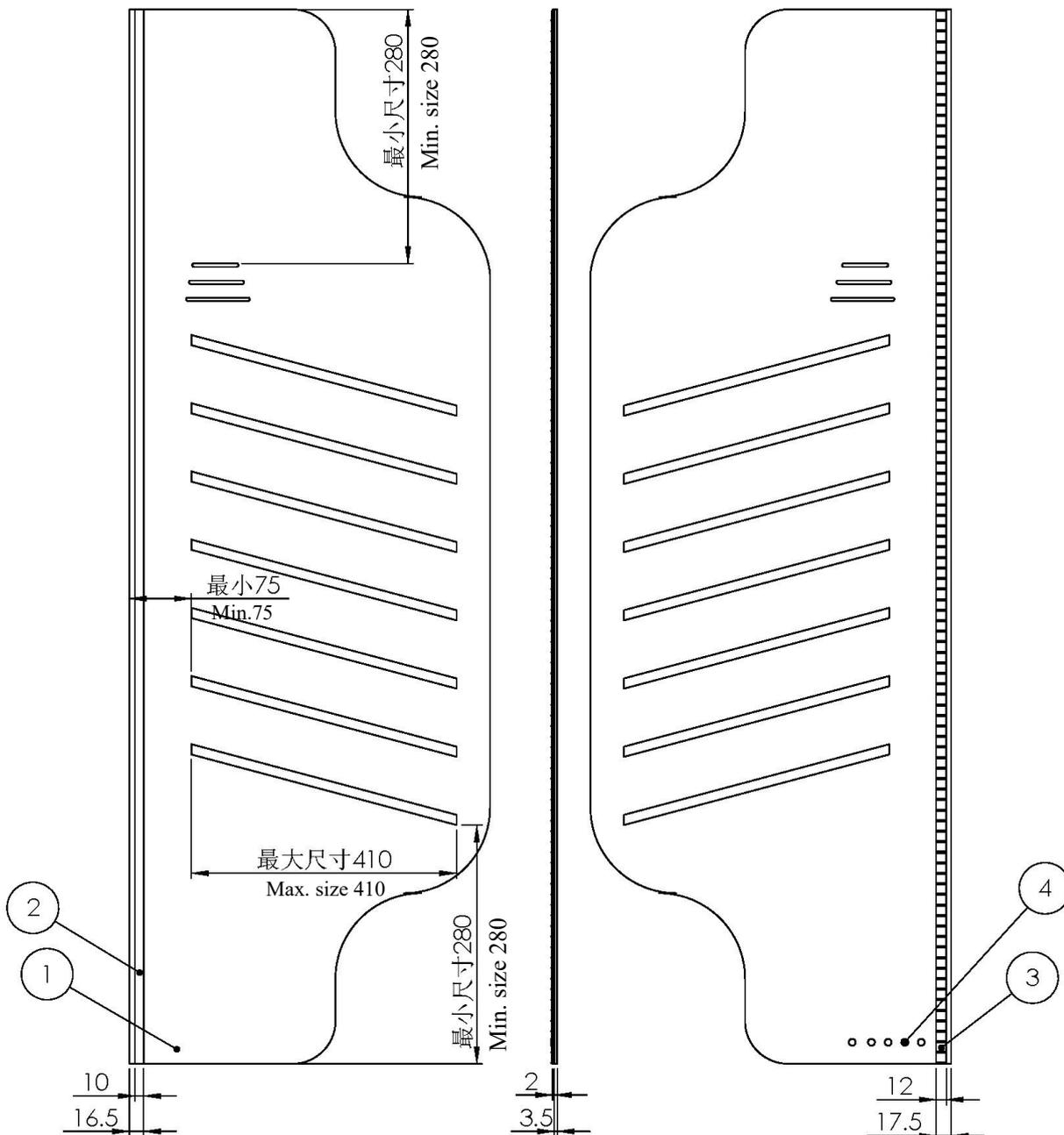


图 4

Figure 4

1. 模板，厚度 1.5mm;
1. Template, thickness 1.5mm;
2. 固定条，宽度 10mm，小 0.1mm,厚度 3mm;
2. Fixed strip, 10mm in width ,minus 0.1mm, and 3mm in thickness;
3. S2M 同步带，宽度 12mm;
3. Timing belt S2M, 12mm in width;
4. 磁铁。
4. Magnet

注意：距离 16.5 划线，保证尺寸 10 小 0.1。

Notice: Mark off at a distance of 16.5, and ensure dimension 10 minus 0.1.

V、花样的编辑和导入

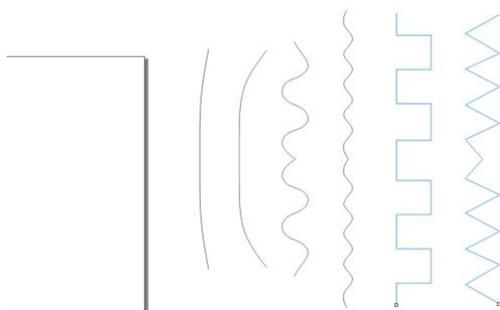
V. Editing and Import of Patterns

步骤一：

Step 1:

用 CorelDRAWX3 软件打开服装软件生成的 plt 文件，删掉不需要的图形并对不同功能的线条使用不同的颜色。例如，缝制线迹用黑色，点画记号笔用蓝色（如下图），再将图形保存为 plt 格式，如下图。

Use software CorelDRAWX3 to open the plt document generated by apparel software, delete unwanted graphic, and apply different colors to the lines provided with different functions. For example, set the sewing stitch to black, set the stippling marking pen to blue (as shown in the figure below), and save the graphics in plt format as shown in figure below.

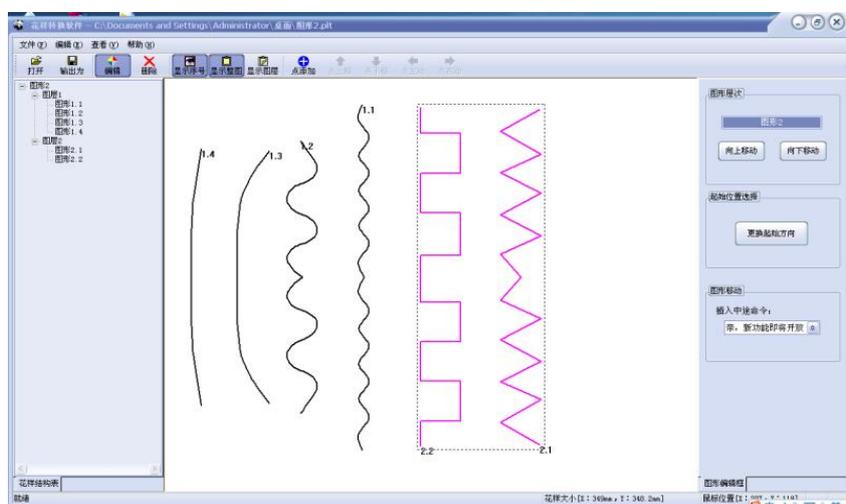


步骤二：

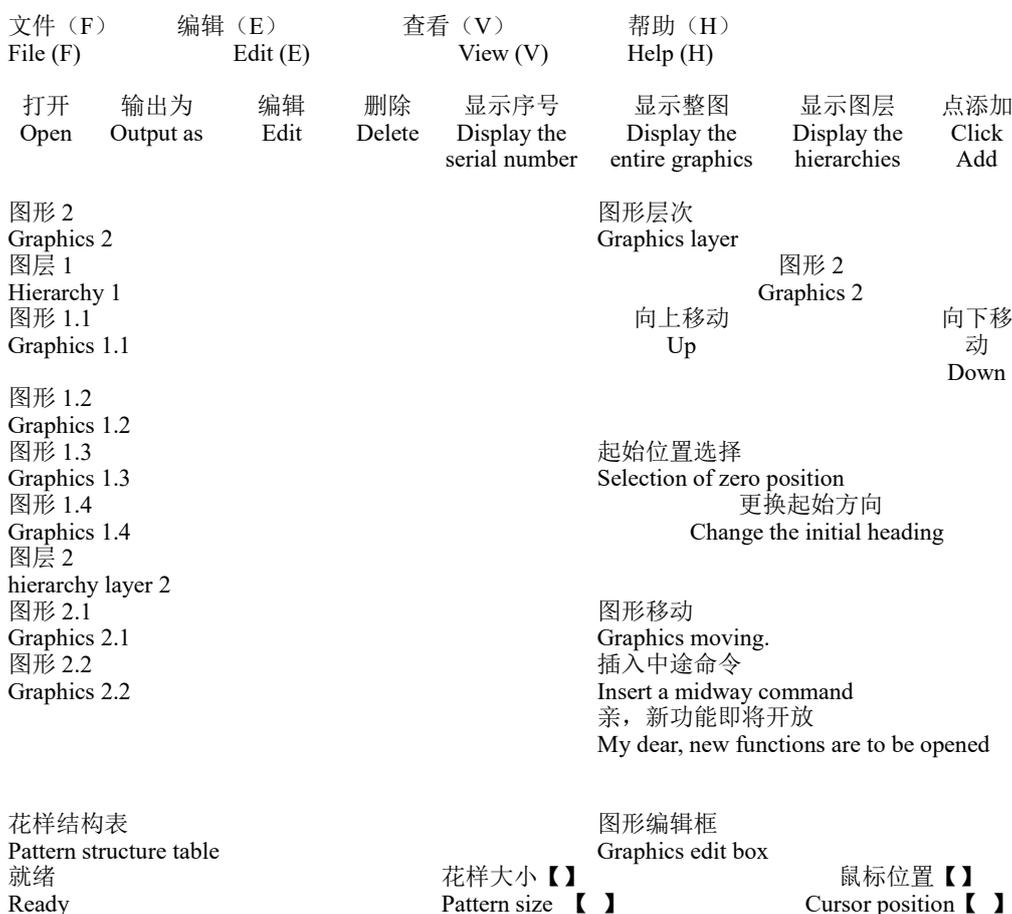
Step 2:

用花样转换软件打开步骤一保存的 plt 文件，在软件左侧可以看到花样的图层与图形树状图，选中不同的图层与图形软件右侧会出现不同的对话框中间可以看到图形，如下图。

Use a pattern conversion software to open the plt document saved in Step 1. A layer and graphics tree is shown of the patterns on the near side of the software. If different hierarchies and graphics are selected, different dialog boxes may appear on the right side of the software, and the graphics are shown therein (as shown in the figure below).



花样转换软件 C:\Documents and Settings\Administrator\桌面\图形 2.plt
 Pattern conversion software C:\Documents and Settings\Administrator\desktop\graphics 2.plt



步骤三: Step 3:

选中图层 1，软件右侧弹出图层编辑对话框，如右图所示。您可以通过“向上移动”和“向下移动”改变图层的顺序。可以通过<图层输出选项>改变图层需要输出的类型。由于机械暂时不支持“输出为切布刀”，所以该功能暂时无效果。如果该图层设置为“输出为线迹”需要再<基本设置栏中>输入正确的针距，中压脚高度和最高速度，如右图。

Select hierarchy 1, and the layer editing dialog box pops up on the right side of the software, as shown in right-hand figure. You may change the sequence of the layers by shifting “Up” and “Down”. You may change the desired type of layer output by 〈Layer output option〉. The said function is unavailable for the moment since the machine does not support “Output as cloth cutting knife” for the time being. Is the layer is set to “Output as stitch”, correct needle pitches, height of middle presser foot and maximum speed shall be input into 〈Basic settings〉 (as shown in the right-hand figure).

注意:

Notice:

1, 如果仅仅是缝制普通布料, 中压脚高度使用默认值 2.0。

1. If only ordinary cloth is to be sewn, the height of middle presser foot may be the default 2.0.

2, 实际缝制中的最高速度还与机器中设置的最高速度有关, 此处建议暂不修改。

2. The maximum speed occurring in process of actual sewing is also related to the preset maximum speed of the machine. we recommend here that the preset maximum speed may not be changed for the time being.

3, <输出设置>和<基本设置>中内容修改后需要点击“确定修改”数据才会保存。否则以默认参数转出图形。

3. Any modified items in the <Output settings> and <Basic settings> may be saved only when "Confirm the modification" is clicked; if not, the graphics may be output as per the default parameters.



图形 2
Graphics 2
向上移动 向下移动
Up Down
输出设置
Output Setup...
本图层输出选项:
Output option for this hierarchy:
输出为线迹
Output as stitch
基本设置
Basic settings
针距: 2.5mm
Needle space: 2.5mm
中压脚高度: 2.0mm
Height of middle presser foot: 2.0mm
最高速度: 2500r/s
Max. speed: 2500r/s
确定修改 还原默认
Confirm the modification Restore the default

步骤四:

Step 4:

分别选中图形 1.2-1.4 软件右侧弹出图形编辑对话框。通过“向上移动”按钮和“向下移动”按钮改变图形的顺序, 通过“更换起始方向”按钮改变图形的起始方向。使得图 1 中的顺序为你希望的缝制顺序, 如右图。

Select graphics 1.2-1.4 respectively, a graphics edition dialog box pops up on the right side of the software. Use buttons “Up” and “Down” to change the sequence of graphics, and use button “Change initial heading” to change the initial heading of the graphics such that the sequence in layer 1 is exactly the sewing sequence you desire (as shown in the right-hand figure).

步骤五:

Step 5:

对图层 2 和图层 2 里面的图形执行步骤三和步骤四的内容。

Operate on layer 2 and the graphics in layer 2 as described in Step 3 and Step 4.

步骤六:

Step 6:



图形层次
Graphics layer
图形 1.1
Graphics 1.1
向上移动 向下移动
Up Down
起始位置选择
Select the initial position
更改起始方向
Change the initial heading
图形移动
Graphic moving
插入中途命令:
Insert a midway command:
亲, 新功能即将开放
My dear, new functions are to be opened

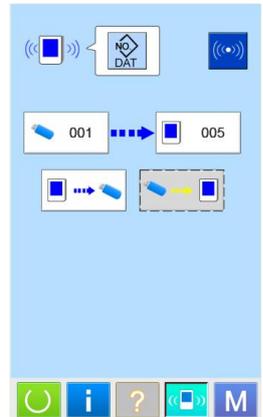
记录整个图案的第一针的位置（在步骤十中用到）。点击工具栏中的<输出为>，将图案保存为以**数字**命名的 dat 文件。

Record the position of stitch 1 of the entire pattern (which may be used in Step 10). Point and click <output as> in the toolbar, and save the pattern as a dat file titled by numerals.

**步骤七：
Step 7:**

将步骤六中生成的 dat 文件拷贝到 U 盘中的**根目录**下，然后将 U 盘插在手控盒上面，如右图。

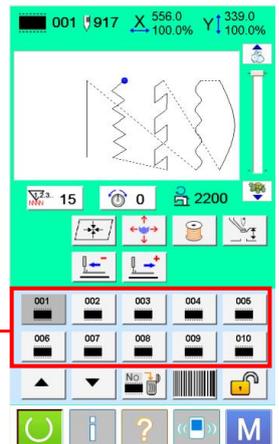
Copy the dat file generated in Step 6 to the root directory of a USB disk, plug a USB disk into the manual control box (as shown in the right-hand figure).



**步骤八：
Step 8:**

打开运模机，按  键，输入密码“84515780”，进入模式界面。然后再按  键进入通信界面（如右图所示）。按按钮  显示将数据从 U 盘媒介通讯到手控盒的界面。点击  输入步骤六中保存的 dat 文件的名称。点击  输入需要再手控盒中保存的名字。

Turn on the template sewing machine, push the button  , and input a password “84515780” to access the mode interface. Push button  to access the communication interface (as shown in the right-hand figure). Push button  to display an interface in which data stored on the U disk may be linked to the manual control box. Point and click  , and input the title of dat file saved in Step 6. Point and click  , and enter the title to be saved on the manual control box.



**步骤九：
Step 9:**

按  键，进入缝制界面（如右图所示）。控制机头按钮将压框压脚抬起，放置与图案相对应的模板，压下压框压脚。在 **A** 处找到步骤八中输入的名字。

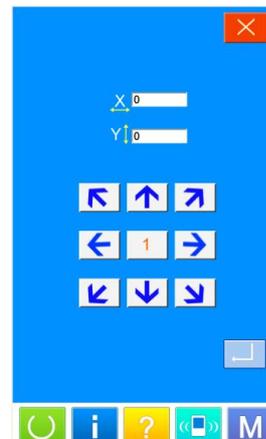
Push button  to access the sewing interface (as shown in the right-hand figure). Control the machine head

button, raise the pressure frame, place a template corresponding to the pattern, and depress the presser foot of pressure frame. Find in place A the title entered in Step 8.

注意:

Notice:

- 1, 如果图形超过缝制范围则无法选中。
1. If graphics exceed the sewing range, no selection can be made.
- 2, 如果图形需要调整基准值后才能全部进入缝制范围, 则选中图形后直接进入步骤十中的界面, 供用户调整基准值。
2. If the graphics cannot fall within the sewing range completely before the reference values are adjusted, the user has to select graphics, directly access the interface given in Step 10, and adjust the reference values.



步骤十:

Step 10:

按  进入基准值设置界面 (如右图), 把机针移动到模板所对应的第一针 (步骤六中记录的位置)。然后按  键, 保存基准值并回到缝制界面。

Push  to access the baseline value setting interface (as shown in the right-hand figure), and move the needle to the first stitch corresponding to the template (namely the position recorded in Step 6). Push button  to save the reference value and return to the sewing interface.

步骤十一:

Step 11:

将相对应的模板放到指定位置, 通过机头上面的两个按钮将压框压脚压下, 并开始缝制。

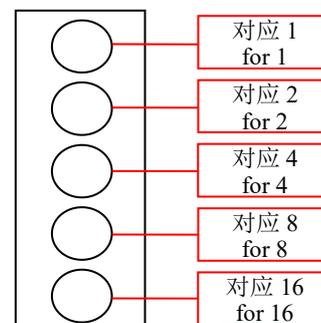
Put a correspondent template in its designated position, depress the presser foot of pressure frame by the 2 buttons on the machine head, and start sewing.

必看 (模板对应说明):

Must-follow (description of template corresponding):

在台板上面有 5 个圆形的感应器, 每个感应器分别对应着一个数字 (如右图所示)。不同的组合对应的编号是对应数字的相加。例如: 在一个模板对应 2 和对应 8 的感应器上面贴了感应片, 有 $2+8=10$ 则该模板的编号为 10。

The table is equipped with 5 round inductors, and each inductor corresponds to one numeral (as shown in the right-hand figure). The number corresponding to different combinations is exactly the addition of corresponding numerals. For example: If induction chip is mounted on an inductor whose template is for 2 and 8, then $2+8=10$, the number of the template is 10.



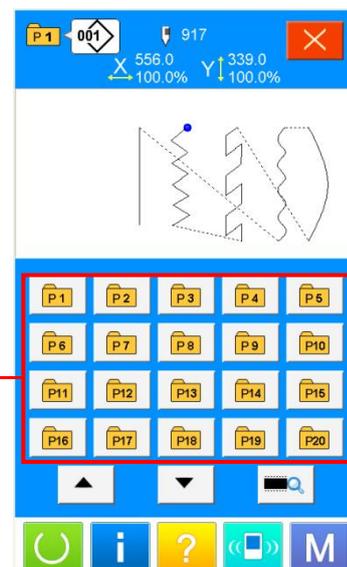
机器前方, 操作人员位置
Foreside of the machine,
operating station

步骤十二:

Step 12:

按  键，进入模板识别设置界面（如右图所示）。选中与模板编号所对应的文件夹。例如：模板编号为 7（1+2+4），则选中 P7 文件夹。可以查看 P7 对应的图案，如果没有对应的图案，则屏幕上方 001 处显示为<无>。

Push button  to access the template recognition and setting interface (as shown in the right-hand figure). Select a file folder corresponding to the template number. For example: If the template number is (1+2+4), then select file folder P7. Find and view the pattern corresponding to P7. If no corresponding pattern is available, <nil> may be displayed in place 001 on the screen.



步骤十三:

Step 13:

按  键，进入花样选择界面（如右图所示）。在 **B** 处选择模板对应的图案，按  键确认保存，回到模板识别设置界面。

Push button  to access the pattern selection interface (as shown in the right-hand figure). Select a pattern corresponding to the template in place B, push button  for confirmation and saving, and return to the template recognition and setting interface.

步骤十四:

Step 14:

重复步骤十二和步骤十三，为不同的模板设置相对应的图案。设置完成后在模板识别模板设置界面按  键。回到缝制界面。

Repeat Step 12 and Step 13 to set correspondent patterns for different templates. When setting is over, push button  in the template recognition and setting interface to return to the sewing interface.

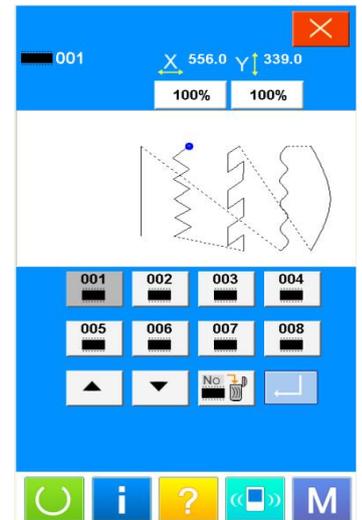
注意:

Notice:

在缝制界面中需要若花样锁按钮显示为 ，表示花样锁定，此时无法进入模板识别设置界面，需要解除锁定才可以进入。解锁方式：按  键输入密码 123，确认。退回到缝制界面后花样所按钮变为 。表示花样未锁定，可以进入模板设置界面。

In the sewing interface, pattern lock-up button displayed as  indicates that the pattern is locked up, and the template recognition and setting interface cannot be accessed before the button is unlocked.

Unlocking method: Push button  , enter and confirm a password "123" to allow the system to return to its sewing interface, and the pattern lockup button is displayed as  , which indicates that the pattern is



步骤十五:

Step 15:

在缝制界面按  键，进入花样锁状态。将不同编号的模板放到指定位置，查看屏幕显示图案是否正确，如果不正确重新解锁花样，进入模板自动识别界面设置该模板所对应的花样。

In the sewing interface, push button to access the pattern lock-up mode. Put templates with different numbers in their designated positions, and check whether the patterns displayed on the screen are correct; if not, unlock the patterns again, and access the template automatic identification interface and set the patterns corresponding to the templates.

步骤十六:

Step 16:

放置模板，通过机头上面的两个按钮将压框压脚压下，并开始缝制。

Place a template, depress the presser foot of pressure frame by the 2 buttons on the machine head, and start sewing.

VI、 缝纫准备

VI. Sewing Preparation

1. 供油检测及废油处理

1. Oil supply inspection and waste oil disposal

在缝纫前请确认旋梭供油油壶含油量一半以上，齿轮箱油量深度 18mm 左右。

Prior to sewing, confirm that the oil level in the oil can of rotating shuttle reaches or exceeds half the total oil level, and that the depth of gearbox oil is of approximately 18mm.

2. 机针的安装方法

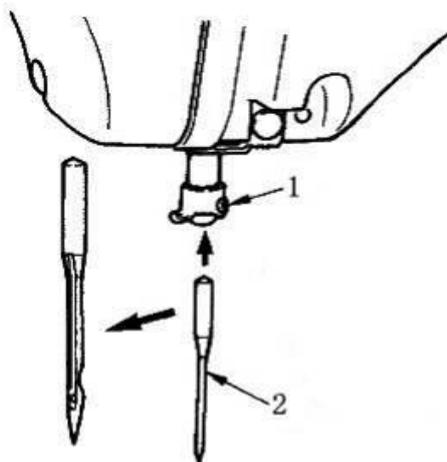
2. Mounting the needles

松开螺钉 1，把机针 2 的长沟朝向面前，放进针杆的深处，然后拧紧固定螺钉 1。

Unscrew screw 1, allow the long groove in needle 2 to face the operator, push it into the depth of needle rod, and tighten set screw 1.

注意拧螺钉力度要轻，否则后续更换时机针会打转。

Notice that the screw shall be tightened gently; otherwise the needles may be rotated when replacement is conducted next time.



*注意：为了防止机器突然启动造成人身事故，请一定关掉电源后进行操作。

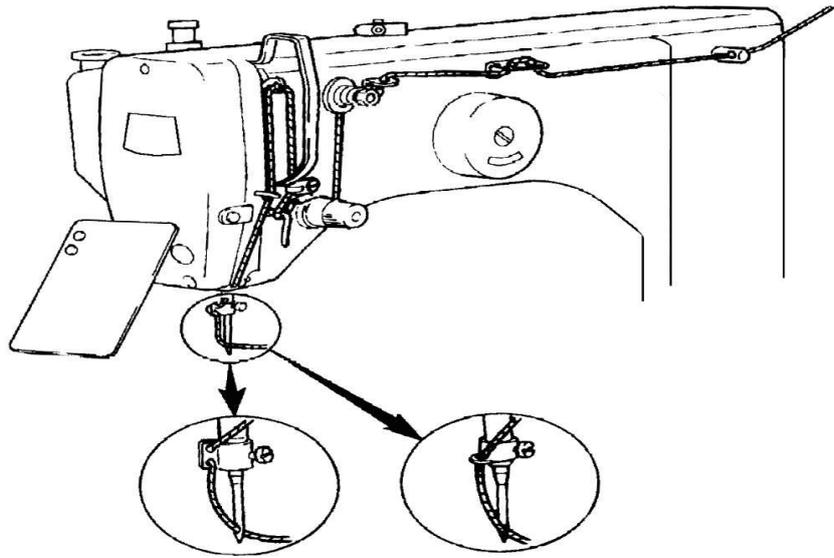
***Notice: Do turn off the power supply before operation to prevent any unexpected startup of the machine, which may result in human injury.**

3、上线的穿线方法

3. Threading the machine head

缝纫前请按图所示穿好线。

Before the machine work thread the machine head as shown in the figure.



4、挑线弹簧的调节

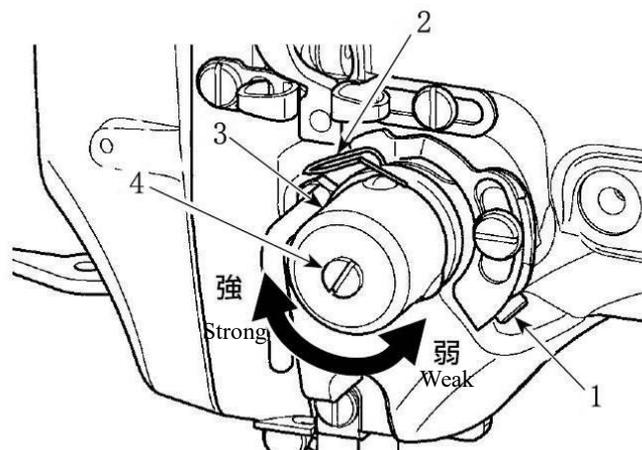
4. Adjusting the take-up spring

1) 移动量的调节 松开螺钉 1，转动夹线器向右转动，动作量变大，拉线量变多。

1) Adjustment of stroke: Unscrew screw 1, and turn the tension disco rightward to increase the stroke and the thread feeding.

2) 强度的调节 改变挑线弹簧 3 的强度时，请在螺钉 1 在锁紧的状态下，用螺丝刀调节线张力杆 4，向右转动，挑线簧强度变强，向左转动之后，强度变弱。

2) Adjustment of strength: To change the strength of take-up spring 3, just use a screwdriver to adjust the thread tension bar 4 rightward to increase the strength of thread take-up spring, or leftward to reduce its strength (screw 1 shall be securely tightened first).



5、断线检测板

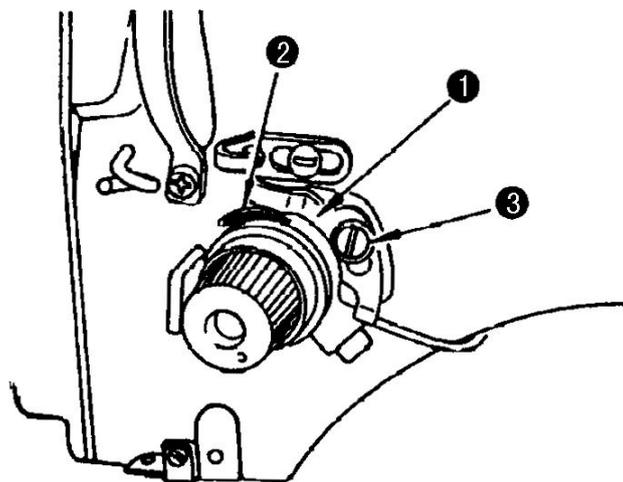
5. Broken stitching pickup plate

没有穿线时，把断线检测板①和挑线弹簧②调整成相接触。改变了挑线弹簧②的行程后，请拧松螺丝③，再次调整断线检测板①。

When no threading is conducted, adjust the broken stitching pickup plate ① and take-up spring ② such that the both touch each other. After the stroke of take-up spring ② is changed, unscrew screw ③, and adjust the broken stitching pickup plate ① over again.

注意：断线检测板①除挑线弹簧②以外不能与其他金属部件相接触。

Notice: The broken stitching pickup plate ① must not be contacted by any metal components except for the take-up spring ②.



6、辅助压脚的调节

6. Adjusting the auxiliary presser foot

将辅助压脚的底部调整到能把夹有缝料的模板压实为宜。辅助压脚的气压调整到 0.2Mpa。

Adjust the bottom of auxiliary presser foot such that the template with clamped sewing materials may be held down securely. Adjust the air pressure of auxiliary presser foot to 0.2Mpa.

7、中压脚高度的设置

7. Setting up the height of middle presser foot

按中压脚设定按钮，使机针到达下死点时，拧松螺钉把中压脚下端与布料的间隙调整为0.5mm。

Push the setup button  of middle presser foot; when the needle reach their lower dead point, unscrew the screw, and adjust the clearance between lower end of the middle presser foot and cloth to 0.5mm.

注：中压脚参数出厂值为2mm。

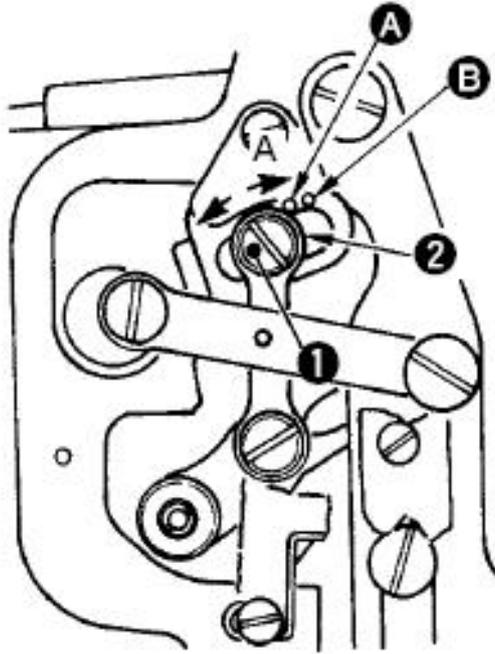
Note: The ex-works value of middle presser foot is 2mm.

8、中压脚的上下行程调节

8. Adjusting the up/down strokes of middle presser foot

- 1) 取下面罩。
- 2) 转动皮带轮，把针杆移动到下死点。
- 3) 拧松平头螺丝①，把平头螺丝①的位置向 A 方向移动，行程变大。
- 4) 刻点A与垫片②的外周右侧一致时行程为4mm，与刻点B一致时行程为7mm。
(工厂出货时调节为3mm。)

- 1) Remove face cover.
- 2) Turn handwheel to make the needle bar come down to its lowest point.
- 3) Loosen hinge screw ① and move it to the direction A to increase the stroke.
- 4) When marker dot A is aligned with the right side of the outer periphery of washer ②, the vertical stroke of the intermediate presser becomes 4 mm. And, when marker dot B is aligned with the right side of the outer periphery of the washer, it becomes 7 mm.
(The vertical stroke of the intermediate presser is factory-set to 4 mm at the time of delivery.)



VII、 保养方法

VII. Maintenance Method

请定期（建议不超过 2 个月）向指定部位补充润滑脂。由于清扫缝纫机等原因造成润滑脂减少时，请立即加以补充。

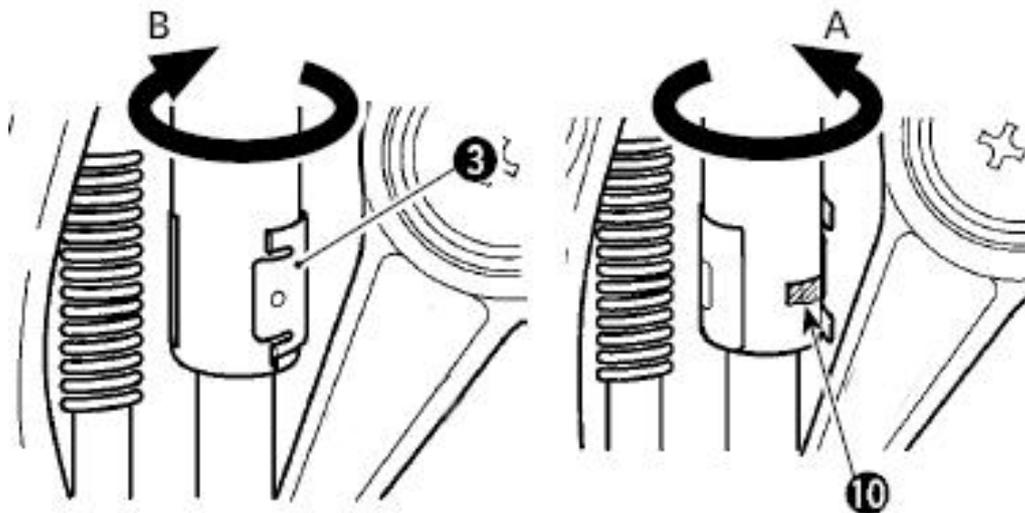
Regularly add grease to the designated site (usually no more than three months). Reduced grease which is caused by cleaning sewing machines, please supplemented immediately.

1、 针杆、压杆部润滑脂补充

1. Needle bar, pressure lever grease replenishing

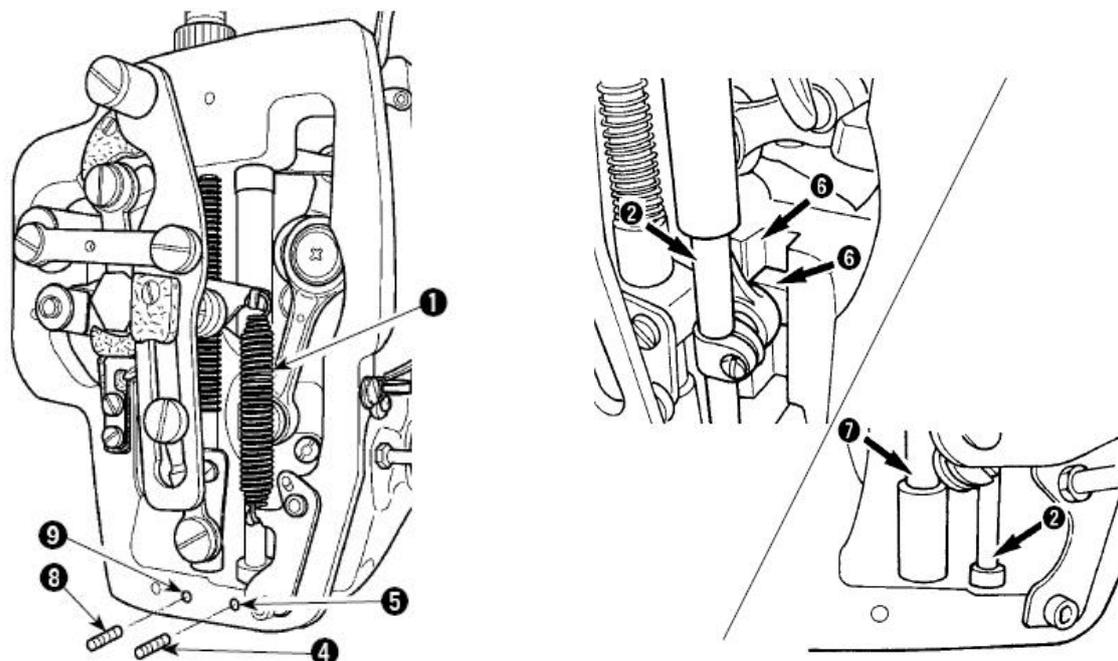
打开面板，拆下中压脚辅助弹簧 1。向针杆 2 四周涂抹润滑脂。然后请用手转动手轮让润滑脂涂满整个针杆四周。向箭头 A 方向转动针杆上轴套润滑脂护罩 3，从注入口充填润滑脂。充填完毕后，向箭头 B 方向转动针杆上金属部润滑脂护罩，返回到原来的位置。

Open the panel; remove the medium presser foot auxiliary spring 1. Apply grease to the needle bar 2. Then please turn the hand-wheel to grease all the needle bar. Roll the cover 3 on needle bar axis guide in the direction A, filling grease from the sprue. After the completion of filling, Roll the cover on needle bar axis guide in the direction B, returning to its original position.



卸下针杆下轴套润滑脂孔固定螺丝 4，向孔 5 里注入润滑脂，然后拧紧固定螺丝 4，让润滑脂充填到轴套内。向针杆滑块槽 6 也涂抹润滑脂。向压杆四周 7 上也涂抹润滑脂。卸下压杆轴套润滑脂孔固定螺丝 8，向孔 9 里注入润滑脂。然后拧紧固定螺丝 8，让润滑脂充分填到轴套内。

Unload screw 4 on needle bar lower axis guide, injected grease to hole 5, then tighten the screw 4, let the grease filling in the sleeve. Apply grease to the needle bar slip plate slot 6 and also the pressure lever 7; Unload screw 8, injected grease to hole 9. Then tighten the screw 8, let the grease full fill in the sleeve.

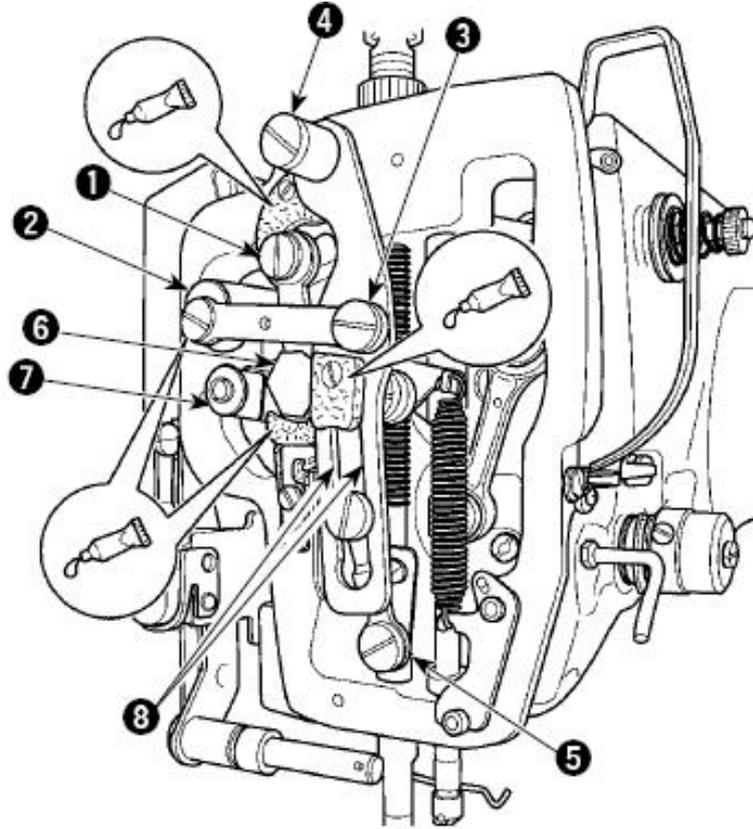


2、中压脚提升部润滑脂补充

2. Presser foot lifting parts grease replenishing

打开机头面板，请向毡垫部(3 处) 及其四周的平头螺丝、支点 1 ~ 7 和导向槽 8 里补充润滑脂。

Open head panel, add grease to the felt pad (3 part), the grub screws around, fulcrum 1 to 7 and the guide slot 8.

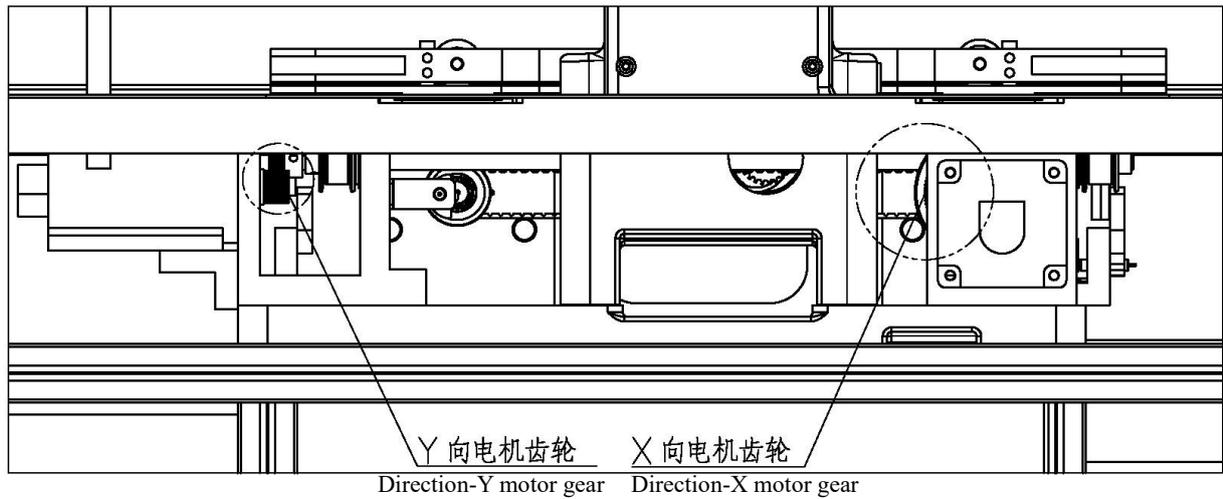


3、X、Y 向齿轮部润滑脂补充

3. Adding grease to gears (directions X, Y)

打开后挡板，用针筒将润滑脂打入齿轮处，并轻轻转动，保证能够均匀的涂在齿轮表面。

Open the back board, use a needle cylinder to inject grease onto the gears, and turn the gears gently to guarantee that the grease may be applied onto the gears evenly.



4、花键轴、导向轴润滑脂补充

4. Adding grease to the spline shaft and guiding axle

打开黑色滑移板，在花键轴沟槽及导向轴表面涂上适量润滑脂，同时前后拉动送料组件，保证能够均匀的涂在轴的表面。

Open a black sliding board, apply right amount of grease into the groove of the spline shaft and onto the surface of guiding axle, and push the material feeding subassembly backwards and forwards simultaneously to guarantee uniform application.

注：分布在机头对称的两边。

Note: It is symmetrically distributed on both sides of the machine head.

