

# SIMAC

## 691-32 / 691-42

# INSTRUCTION MANUAL

Read safety Instructions carefully and understand them before using.  
Retain this Instruction Manual for future reference.

为了安全地使用，请您在使用之前仔细阅读本使用说明书。  
另外，请您注意保管本使用说明书，以便随时查阅。

## 操作手册 / INSTRUCTION MANUAL

### 操作前 / BEFORE OPERATION

1. 在加润滑油前请不要操作机器甚至是试用。
  2. 通过检查马达上的标识牌上的转速确保电压准确。
  3. 在安装机器后第一次试用时，检查手轮的旋转方向。★打开开关.让机器低速运转来检查手轮的旋转方向。  
(从手轮一侧观察应以逆时针的方向旋转)
  4. 第一个月机器应以每分钟1600转左右的速度运转。
1. Do not operate the machine even for trial before lubrication it .
  2. Confirm that the voltage and phase (single or 3-phase) are correct by checking them against the ratings shown on the motor nameplate .
  3. When running your machine for the first time after the set-up , check the rotational direction of the handwheel . ★ Turn on the power switch . Run the machine at a low speed while checking the rotational direction of the handwheel . ( The handwheel should turn counterclockwise as observed from the handwheel side . )
  4. For the first month , run the machine at speed of 1600 r / min or less .

### 注意操作事项 / CAUTIONS IN OPERATION

1. 当打开开关或机器运转时，请将手远离缝纫针。
  2. 操作时，注意请不要将自己或他人的头部或手指接近手轮，皮带，旋梭或马达,同样不要将任何物品接近。
  3. 不要用手套，皮带盖或任何保护装置操作机器。
  4. 移动皮带前请确保马达完全停止及关掉电源开关。
1. Keep your hands away from the needle when you turn on the power switch or while the machine is operating .
  2. During operation , be careful not to allow your or any other person's head or fingers to come close the handwheel , V-belt , bobbin winder or motor . Also do not place anything close to them .
  3. Do not turn the machine with the finger guard , beltcover or any other protectors removed .
  4. Be sure to turn off the power switch and confirm that the motor is completely stopped before removing the V-belt .

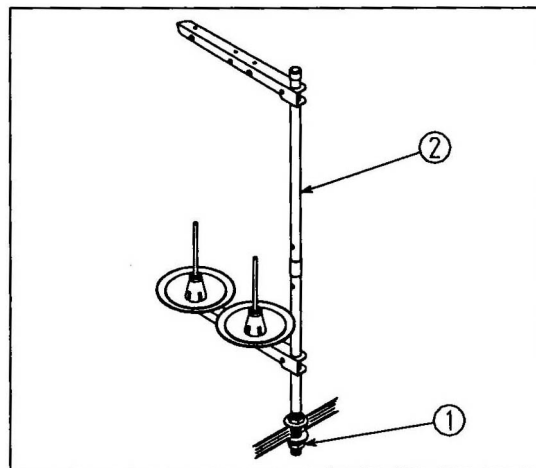
### 规格 / SPECIFICATIONS

规格/Spec		型号/Model	691-32 / 691-42
使用料 / Application		鞋类,箱包等中厚料/Bags,Shoes,Medium-weightmaterials	
缝速 (最大) / Sewing speed (Max)		2500 ( s / min )	
缝目 / Stitch length		0~7 ( mm )	
针棒冲程 / Needle bar stroke		38 ( mm )	
押脚行程 Presser foot stroke	膝抬 / Knee lifter	15 ( mm )	
	手抬 / Hand lifter	8 ( mm )	
针 / Needle		DP X 5 #16	
润滑油 / Lubricating oil		使用油 (白轴油) / Machine oil (white spindle oil)	

## 1. 线架安装 / INSTALLING THE THREAD STAND

将整组线架装好，并插入车板孔中，再将①螺帽固定。  
上线支架依图示固定于线架②上。

Assemble the Thread stand, and insert it in the hole in the machine table, and fix in by tightening nut ①.  
For ceiling wiring pass the power cord through spool rest rod ②.



## 2. 机针的安装 / INSTALLATION OF NEEDLE



注意

进行此操作时，务必关掉电源开关避免意外伤害。操作前确保马达停止工作。

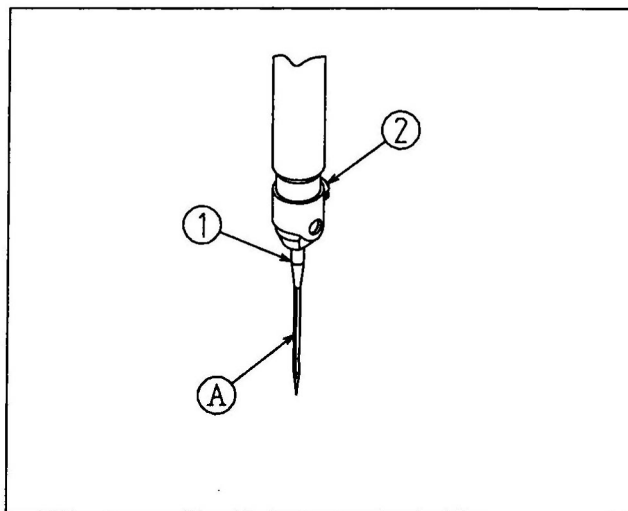


**CAUTION**

**TURN THE SWITCH OFF THE POWER SUPPLY TO PREVENT FROM UNEXPECTED INJURY. BE SURE TO CONFIRM THE STOP OF ROTATION OF THE MOTOR BEFORE OPERATIONS.**

- 1) 转动手轮，将针棒提升之最高点。
- 2) 如图所示，松开锁针螺丝②，用手抓住机针①，注意针的长槽面亦须向左。
- 3) 将机针插入针孔内最底端。
- 4) 最后将锁针螺丝锁死即可。

- 1) Turn the handwheel to move the needle bar up to its highest position.
- 2) Loosen needle setscrew ②, and hold needle ① so that long groove A left side.
- 3) Insert the needle into the needle bar until it will go no further.
- 4) Securely tighten the needle set screws ②.



### 3. 绕底线 / WINDING OF BOBBIN THREAD



注意

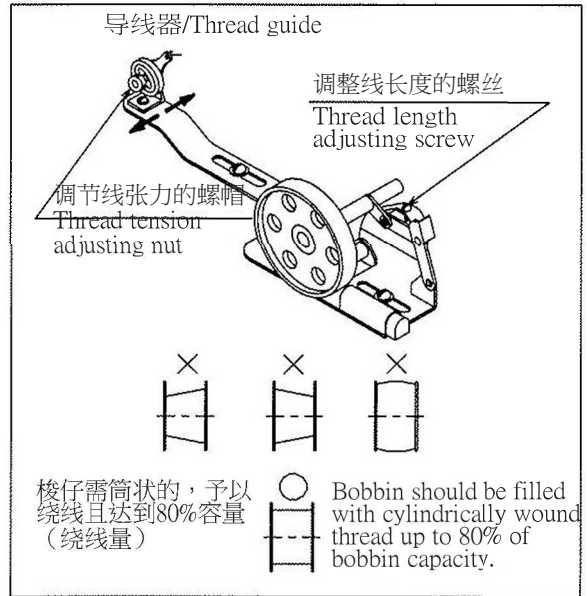
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- 线的松紧度  
散线圈使用聚酯线和尼龙线
- 圆锥形线  
移动线导装置避开更小的线层
- 线长  
松开螺丝增加线长拧紧螺丝减少线长
- Tension of wound thread  
Slack winding is recommended for polyester thread and nylon thread.
- Conically wound thread  
Move the thread guide to ward smaller diameter of wound thread layer.
- Length of wound thread  
Loosen the thread length adjusting screw to increase length of thread and tighten the screw to decrease length of thread.



### 4. 上线的穿法 / THREADING THE MACHINE HEAD



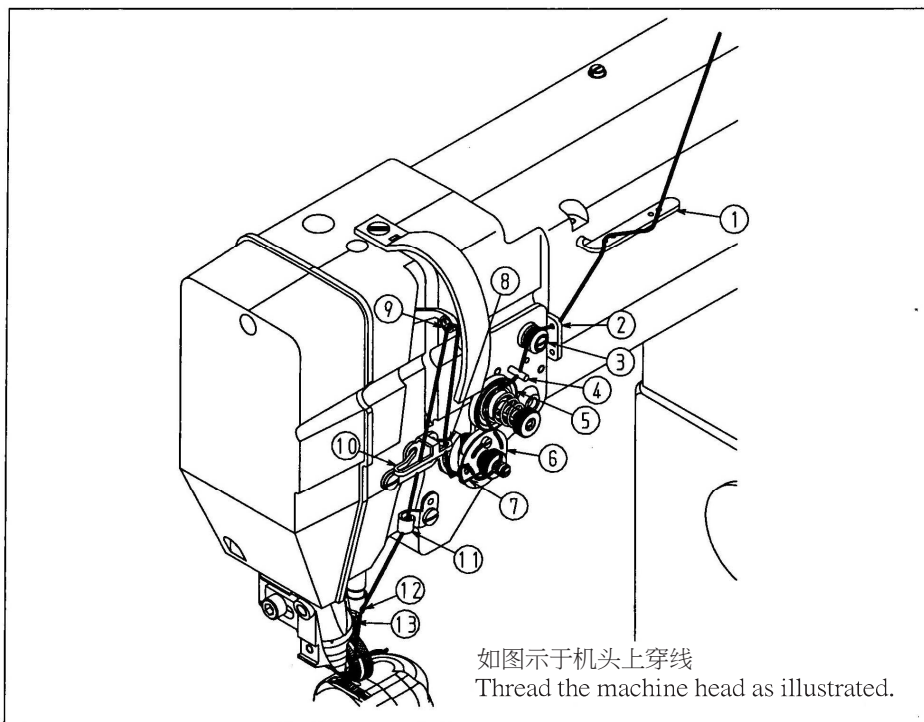
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**CAUTION**

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如图示于机头上穿线  
Thread the machine head as illustrated.

## 5. 调整缝目长度 / ADJUSTING THE STITCH LENGTH



注意

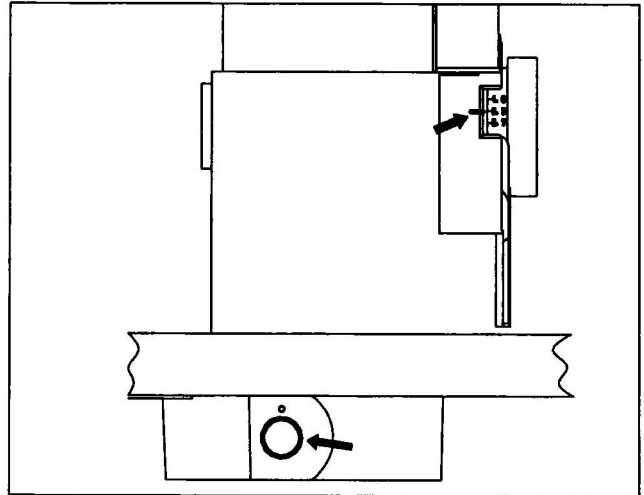
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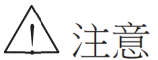
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- 1) 压下黑箭头所示锁合板，同时转动刻度盘。
  - 2) 按住锁合板，以所需缝目长度转动刻度盘至如图黑箭头所示中心直线。
- 1) Press the push button beneath the tabletop (see black arrow), at same time turning the balance wheel until you feel the push button snap in place.
  - 2) Keep the button depressed and turn the balance wheel forward and backward until the number denoting the desired stitch length is opposite the mark on the belt guard (see black arrow).



## 6. 如何安装锁芯 / HOW TO INSTALL THE BOBBIN



注意

进行此操作时，务必关掉电源开关避免意外伤害。操作前确保马达停止工作。



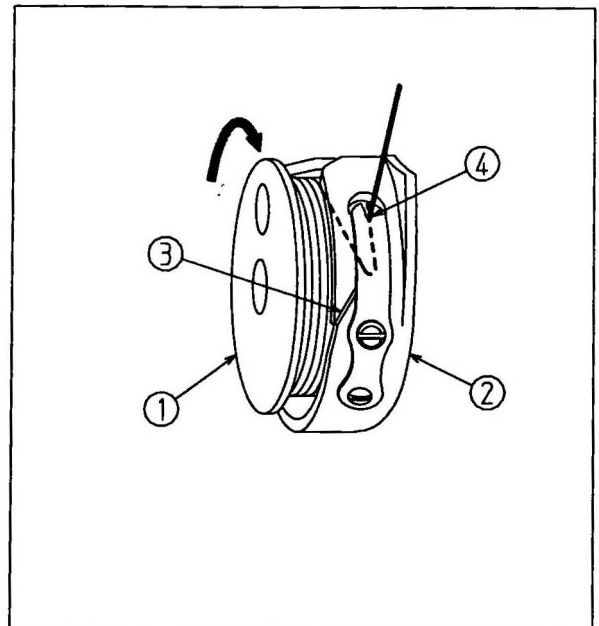
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- 1) 将梭芯①放入梭壳②。
  - 2) 将梭子线拉过螺纹槽③并绕过弹簧夹线片的凹槽④。
- 注意：将梭子置入梭壳后，当梭心线被拉出时，梭芯如箭头所示方向转动。

- 1) Put the bobbin① into the bobbin case②.
- 2) Pass the thread through the threading groove③ and the notch④ of tension spring in the bobbin case.

**CAUTION:** Fit the bobbin in the bobbin case so that the bobbin turns in the direction of the arrow when the bobbin thread is pulled.





## 7. 线张力的调节 / THREAD TENSION



注意

进行此操作时，务必关掉电源开关避免意外伤害。操作前确保马达停止工作。



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上线张力的调节：转动线张力调节螺帽

①，依顺时针旋转，上线张力增加；反之，以逆时针旋转，则上线张力减少。

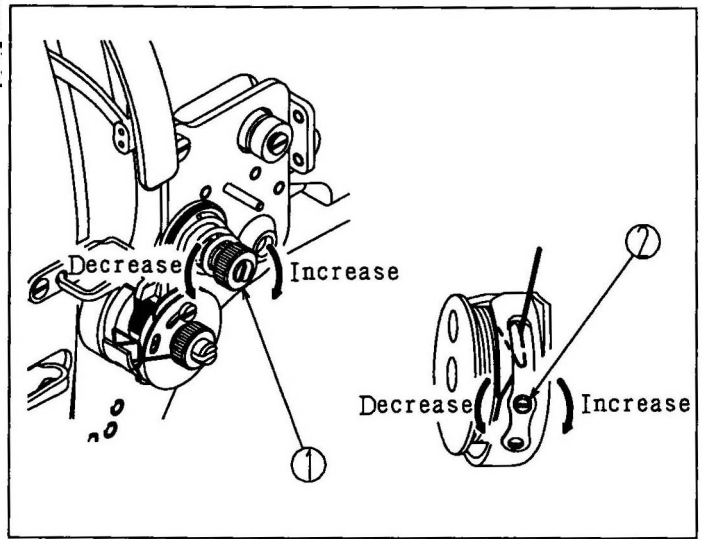
- ◇ 底线张力调整：转动线张力调节螺丝 ②，依顺时针旋转，底线张力增加；反之以逆时针旋转，则底线张力减少。

### ◇ Adjusting the needle thread tension

Turn the thread tension nut ① clockwise to increase or counterclockwise to decrease the needle thread tension.

### ◇ Adjusting the bobbin thread tension

Turn the tension screw ② clockwise to increase or counterclockwise to decrease the bobbin thread tension.



## 8. 针与旋梭的关系 / NEEDLE-TO-HOOK RELATIONSHIP



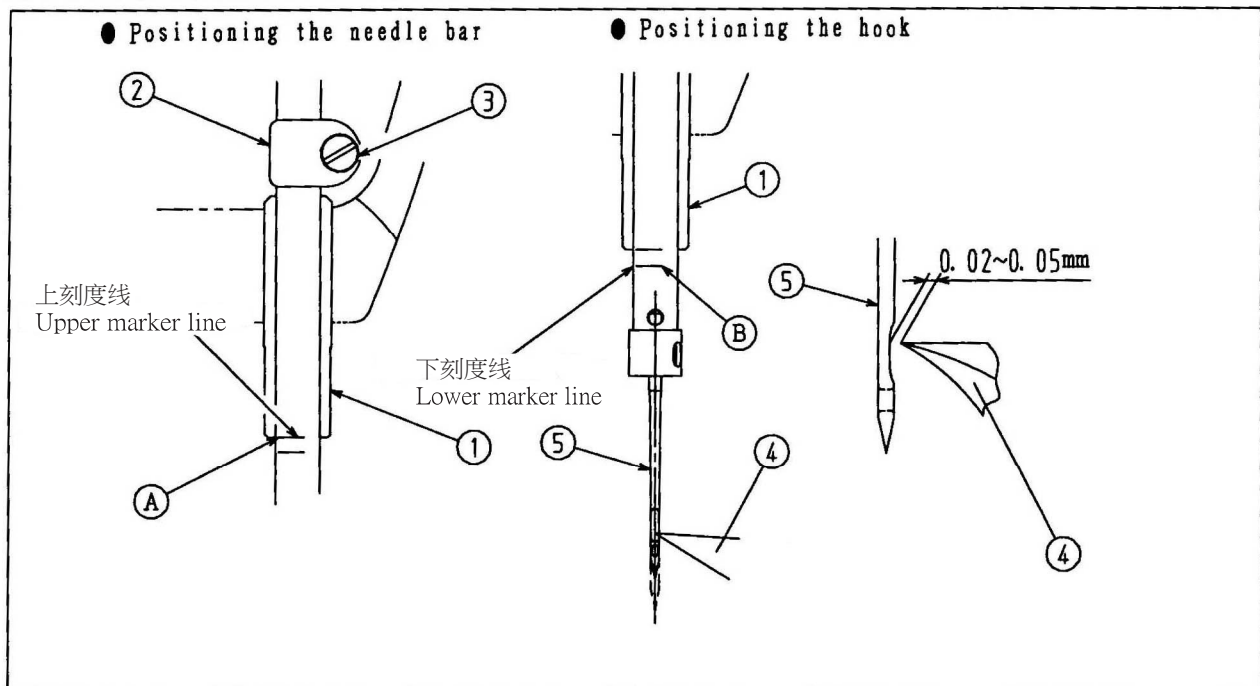
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○ 针棒高度的调整：

1) 使针棒位于最低位置，是针棒的上刻度线 A 对准针棒下套管 ① 的底端,然后锁紧针棒束环 ② 固定螺丝 ③。

○ 机针与旋梭同步的调整：

2) 使上升针棒的下刻度线 B 对准针棒下套管 ① 的底端，进一步调整使旋梭的勾线尖部 ④ 与针的中心位置 ⑤ 无限接近。

3) 使旋梭的勾线尖部 ④ 与针的中心位置 ⑤ 的间隙为 0.02-0.05MM。

○ **Set the needle bar at the proper height first as follows:**

1) Bring the needle bar down to its lowest position, and adjust so that specified marker line A on the needle bar aligns with the bottom end of needle bar lower bushing ①, then tighten screw ③ of needle bar clamp ②.

○ **Adjust the timing between the needle and the hook as follows:**

2) Adjust so that the specified marker line B on the ascending needle bar aligns with the bottom end of lower bushing ①. Further adjust to make hook point ④ nearly meet the center of needle ⑤.

3) Adjust the clearance between needle ⑤ and hook point ④ to 0.02 to 0.05mm

9. 护针片位置的调整 / ADJUSTING THE NEEDLE GUIDE



注意

进行此操作时，务必关掉电源开关避免意外伤害。操作前确保马达停止工作。



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☆ 更换旋梭时，务必确认护针片与旋梭的位置。

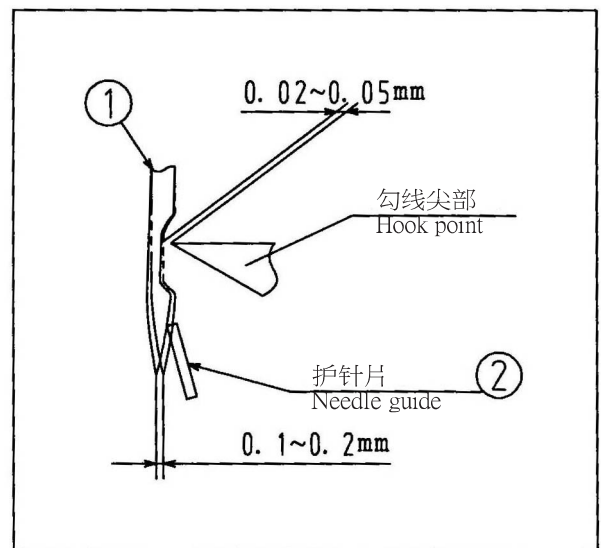
让护针片 ② 让针 ① 稍微弯曲 0.1-0.2mm。

使用螺丝刀调整护针片，往内或往外之方向。

☆ Confirm the position of the needle guide in the hook when you changed the hook

The needle ① is a slight bend to 0.1 to 0.2 mm by needle guide ②.

Adjust the needle guide position to inside or outside direction using screwdriver.



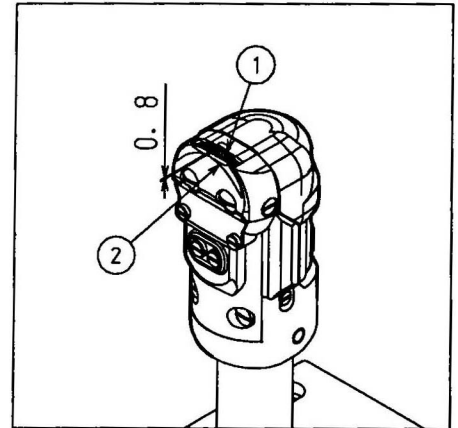
## 10. 下送料轮的高度 / THE HEIGHT OF THE LOWER WHEEL FEED

下送料轮 ① 的标准高度：下送料轮牙齿顶部上升时与针板 ② 表面的距离是 0.8mm,这个距离不应该超过 0.8mm.

万一送料轮的位置高于标准高度，缝线是否能形成取决于所用线的大小。

The standard height of the lower wheel feed ① is that the top of the tooth on the wheel comes up by 0.8mm from the surface of the needle plate ② and its height should not be over 0.8mm

\*In case of the wheel feed is set at heigher position than standard, the stitches can not be formed depending on the size of thread being used



## 11. 齿轮压脚压力的调整 / ADJUSTING THE ROLLER PRESSER PRESSURE

1) 向右转动压力调节螺帽，压力增加；反之向左转动，

1) Turn the presser spring regulator to the right to increase and to the left to decrease pressure.

