

Yamato[®]

使 用 说 明 书

Instruction Manual

Parts List

两针双线链式缝纫机
2-NEEDLE DOBLE CHAINSTITCH MACHINE

CF2302M

本册只有包括和CF2300M使用说明书不同的部分，请与CF2300M使用说明书配合使用。


务请妥善保存所有的使用说明书。为了保证操作安全，请在完全熟读使用说明书之后，再开始操作机器。

This instruction manual only includes the different adjustment from CF2300M. Before using your CF2300M, please read both instruction manuals for CF2300M and this model, and understand the contents well.

After reading the instruction manuals, please keep them in a location where it is easily accessible to the operator.


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***ILLUSTRATED SPARE PARTS LIST ***

注意

- ◇本说明书主要面向技术人员编写，但是，为了妥善操作缝纫机，凡是标有  标记的项目，也希望操作人员阅读。
◇本说明书的说明图左下方所标注的数字表示图号。根据需要，在正文中也标清了图号，用户可以结合相关说明图查阅。

Attention

- ◇This instruction manual is designed mainly for technicians, but it is advisable that also operators read the instructions with  mark to use the machine properly.

声明

本产品将会由于改良等原因而改变使用部件。因此，本说明书中的部分内容和说明图，可能与本产品不完全一致，请予谅解。

另外，在编写本说明书时我们虽然采取了万全之策，但是，错误记载和遗漏之处在所难免，即使得以发现，有时也难以马上更正。

Attention

The parts used for this product are subject to change without notice. If such a change is made, any part of the contents and illustrations of this instruction manual may not conform to this product.

In preparing the instruction manual, we have made our best efforts for making it free of any error or omission. If any error or omission should yet be found, it might not be rectified immediately.

1. 缝纫速度

该缝纫机的最高缝纫速度为 5000sti/min，标准缝纫速度为 4500sti/min。

使用新缝纫机时，最开始的 200 小时（大约 1 个月）请以低于最高缝纫速度约 15 ~ 20% 的速度运转，以确保缝纫机能够在良好状态下长期使用。

2. 使用方法

穿线方法



线没穿好时，请按照图 2-1 所示正确穿线。

线穿好时，将缝制用线打结后重新穿线。

A：针线

将线一直引出到针的前方。将针孔前的结头剪掉后重新穿线。

请按照图 2-1 所示为最里侧的左针正确穿线。

B：上装饰线

将线引出直到结头出来。然后剪掉结头。

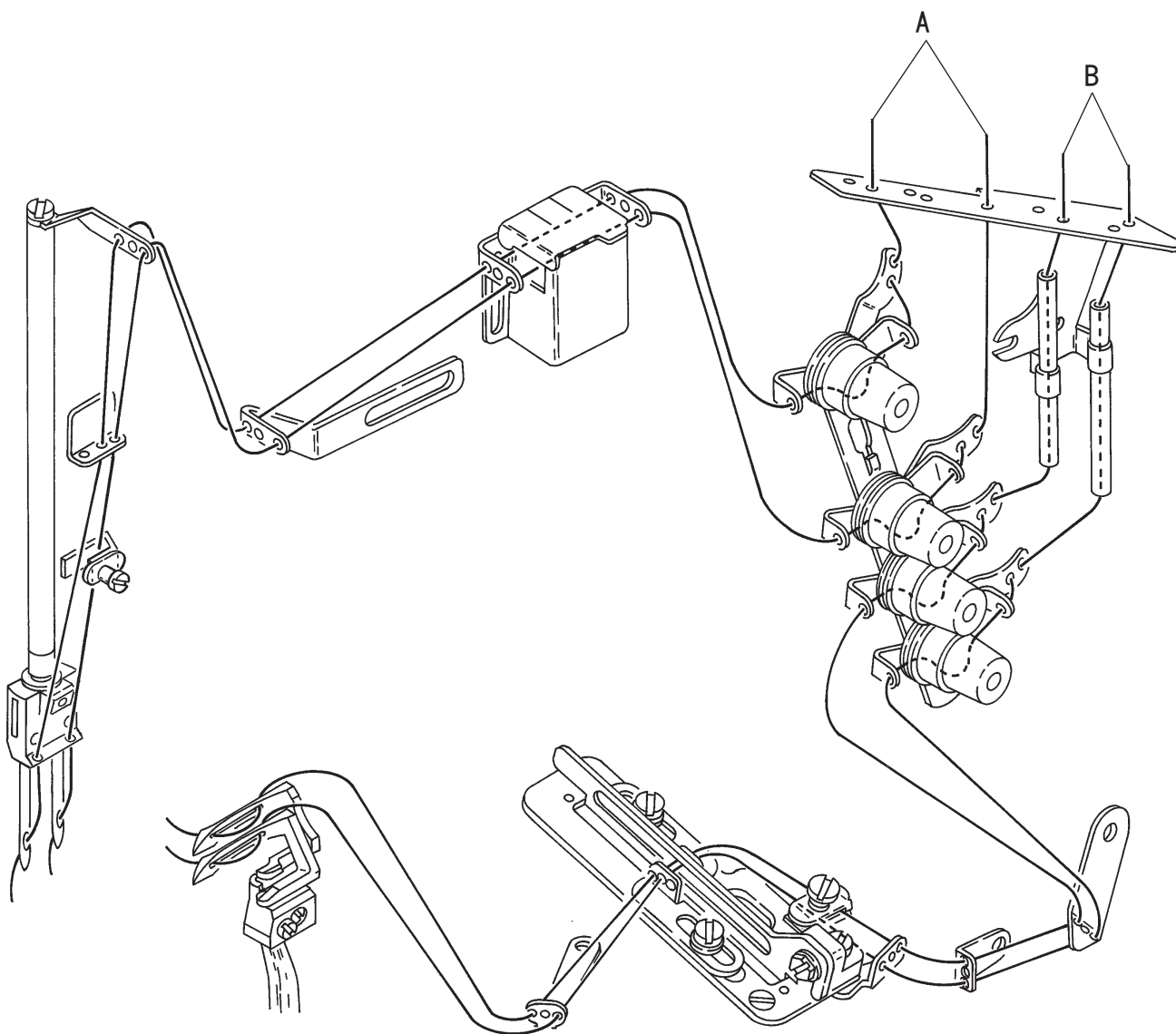


图 2-1

3. 缝纫机的调节

⚠ 注意

调节前，请务必关闭电源开关并确认缝纫机已经停止运转。

3.1 弯针与针间的距离

当针在最低点，弯针在最右端时，弯针前端到各针中心的距离必须为 3.0 ~ 3.5mm。

松开弯针台定位螺丝①调节左弯针前端到左针中心的距离。

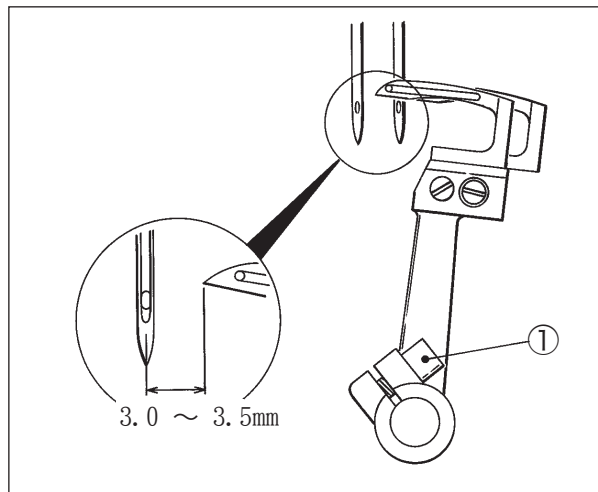


图 3-1

3.2 针棒的高度

确认事项：

- ◇ 务必将针完全插入针托的针孔并牢固地固定。
- ◇ 务必将弯针完全插入弯针台并牢固地固定。

调节：

- (1) 转动手轮直到左弯针前端到达左针的中心位置。
- (2) 松开针棒抱紧定位螺丝②。向上或向下移动针棒，使得弯针的前端从针孔上方 1.0 ~ 1.5mm 的位置通过。
- (3) 确认各针从针板的相应落针孔中心落下。
牢固地拧紧定位螺丝②。

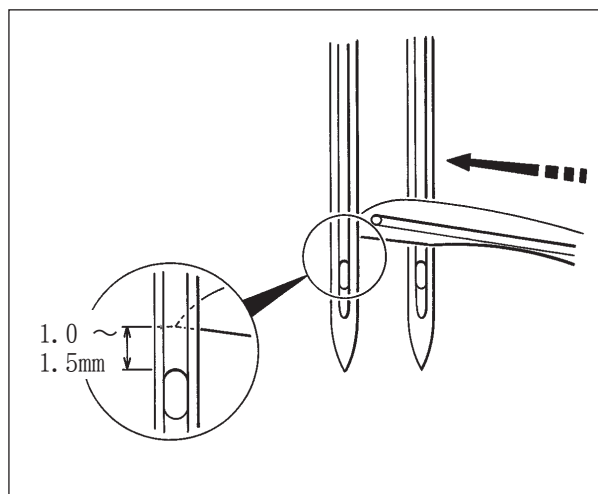


图 3-2

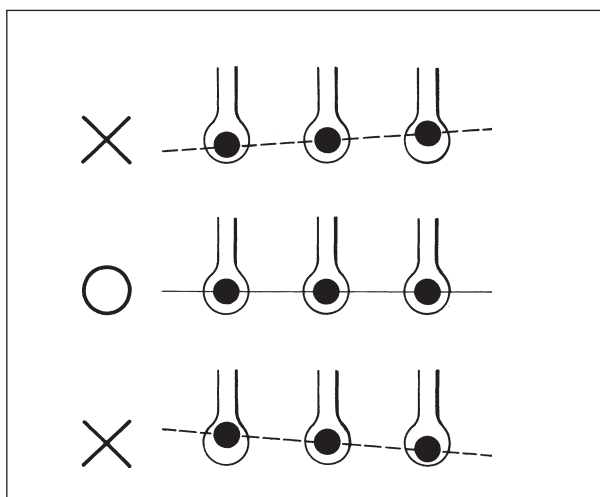


图 3-3

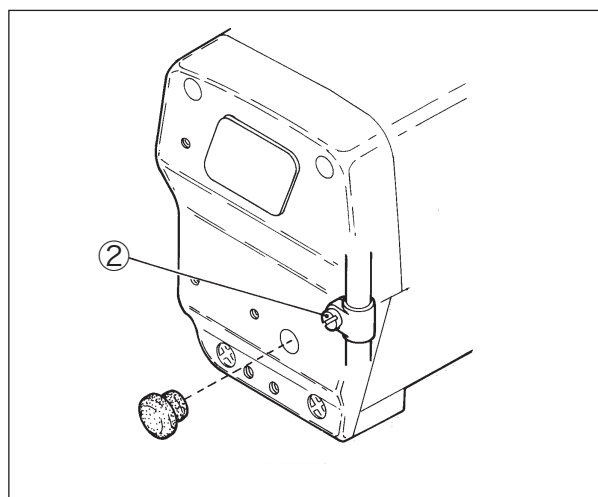


图 3-4

3. 缝纫机的调节

3.3 针和弯针的前后位置

◇当弯针前端①和②到达针③和④的位置时，在弯针与针之间留出 0 ~ 0.05mm 的间隙。

应该首先对弯针⑤进行调节。

- (1) 将弯针⑤（有平坦处）完全插入弯针台，然后拧紧定位螺丝⑥。
- (2) 松开定位螺丝⑦。通过前后移动弯针台⑧进行调节，然后牢固地拧紧定位螺丝⑦。
- (3) 松开定位螺丝⑩。通过转动弯针⑨（无平坦处）进行调节，然后拧紧定位螺丝⑩。

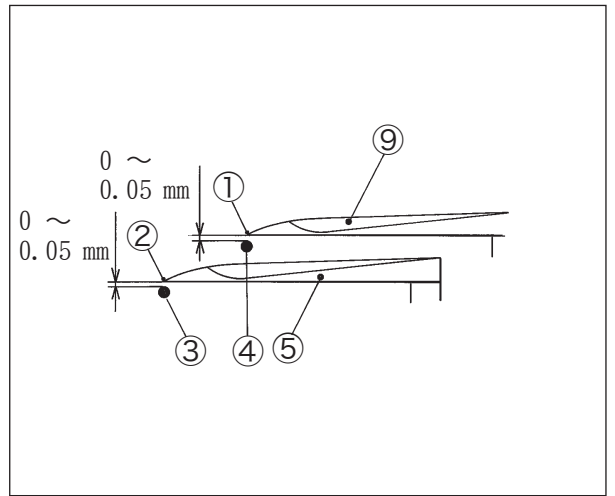


图 3-5

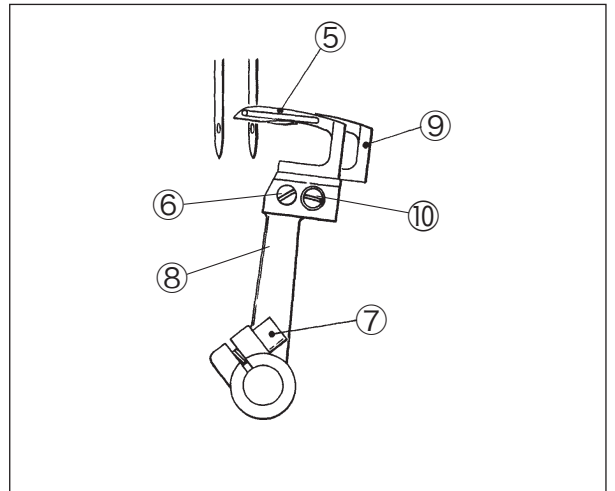


图 3-6

3.4 针和护针器（后）

高度：

将护针器（后）①上的线“A”与位于最低点的针孔中心对准。
松开定位螺丝②进行调节。

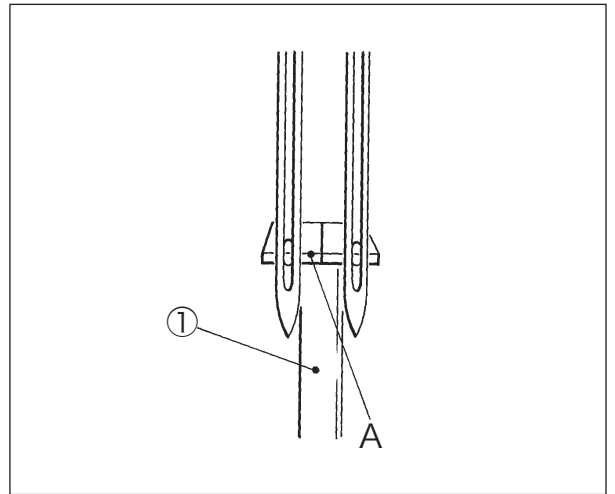


图 3-7

前后位置：

当弯针③前端到达针的中心位置时，在针与弯针③前端之间留出 0 ~ 0.05mm 的间隙以将各护针器（后）①推向相应的针。
松开定位螺丝②和④进行调节。

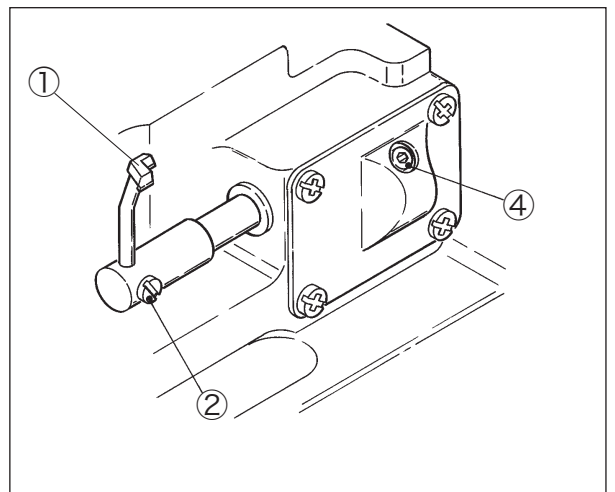


图 3-8

① 补充

当针位于最低点时，针与护针器（后）之间的间隙为 0 ~ 0.05mm。

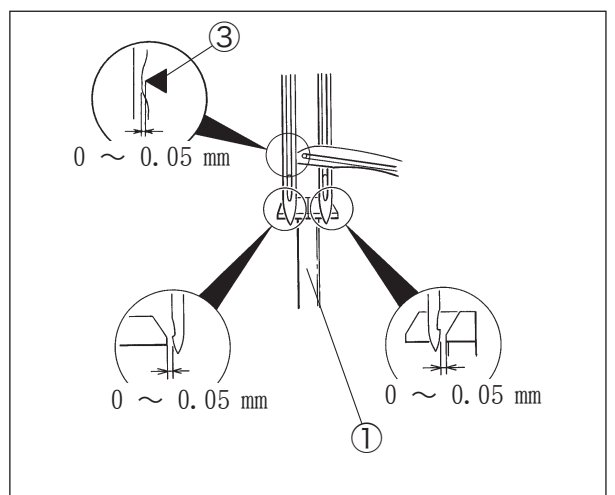


图 3-9

4. 规格

型 号	CF2302M
名 称	两针双线链式缝纫机
外 观 尺 寸	500 (长) × 250 (宽) × 430 (高) mm
重 量	41 kg
针 迹 形 式	ISO 标准 (401、401)
用 途	缝制内裤的正面、将带子缝到 T 恤衫的颈部以及类似用途
缝 制 速 度	间歇运行时, 最高 5000sti/min
针 迹 长 度	1.4 ~ 3.6mm 针迹数 1 英寸 (25.4mm) 内 7 ~ 18 针 30mm 内 8 ~ 21 针
针	UY128GAS : #10-#14
针 距	2 针 : 6.4、8.0、9.5mm
针 的 行 程	31 mm
压 脚 提 升 量	7.0 mm
送 齿 调 节 方 法	按钮方式
差 动 送 齿 比 例	1:0.7 - 1:2
差 动 调 节 方 法	外手柄 (在运行中也可以调节)
润 滑 方 法	泵自动供油
润 滑 油	YAMATO SF 润滑油 #28
贮 油 量	1100 ml
安 装 方 法	全沉式和半沉式
符 合 标 准	CE 标志
噪 音 值	$L_{pA}=79.0\text{dB}$ (5000sti/min) 依据 ISO 10821-C6.2-ISO 11204 GR2

表 1

1. Sewing speed

The maximum sewing speed is 5000 sti/min and the standard sewing speed is 4500 sti/min.

Run a new machine at speed about 15 – 20% lower than maximum sewing speed during the first 200 hours (for about one month) so that a machine can offer a long service life in good condition.

2. Operation

Threading



When not threaded, thread correctly as shown in Fig. 2-1.

When threaded, rethread after knotting the preset threads.

A: Needle thread

Pull out the thread until it is in front of the needle. Then cut off the knot before the needle eye to rethread.

Thread correctly for the left needle in the inmost position as shown in Fig. 2-1.

B: Looper thread

Pull the thread until the knot is out. Then, cut off the knot.

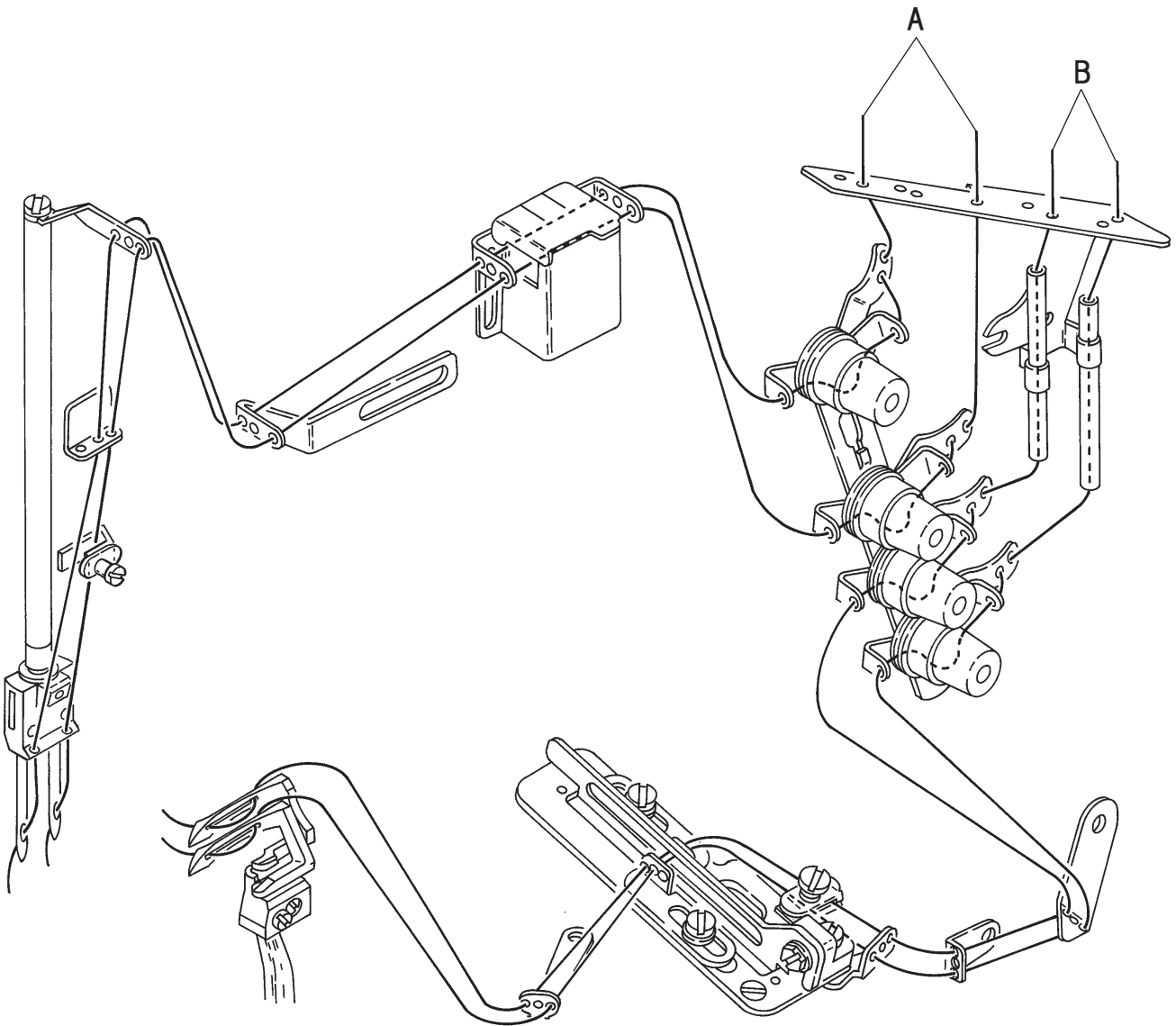


Fig. 2-1

3. Adjustments

⚠ CAUTION

Before adjusting, ALWAYS turn the power switch OFF and check that the machine has already stopped.

3.1 Distance between looper and needle

The distance between the looper tip and the center of the needle must be 3.0 - 3.5 mm respectively when the needles are at the lowest points and the looper is at the extreme right.

Loosen the screw ① of the looper holder to adjust the distance between the left looper tip and the center of the left needle.

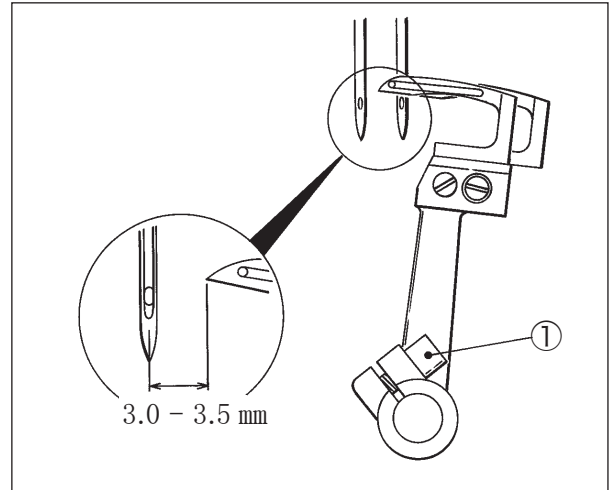


Fig. 3-1

3.2 Height of needle bar

Check points:

- ◇ Needles should be inserted fully into the needle holes of the needle clamp and fixed securely.
- ◇ Looper should be inserted fully into the looper holder and fixed securely.

Adjusting:

- (1) Turn the handwheel until the left looper tip meets the center of the left needle.
- (2) Loosen the screw ② of the needle bar bracket. Move the needle bar up or down so that the looper tip passes 1.0 - 1.5 mm above the top of the needle eye.
- (3) Check that the needles drop in the centers of the needle holes of the stitch plate respectively.

Tighten the screw ② securely.

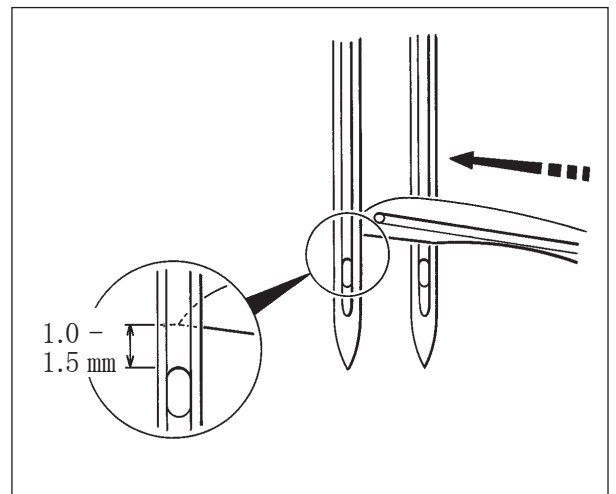


Fig. 3-2

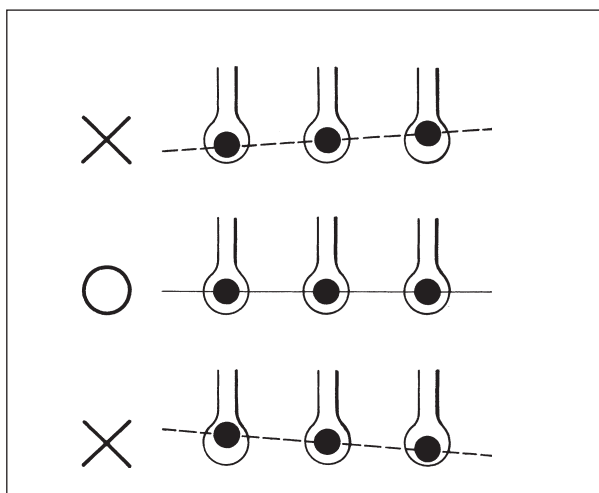


Fig. 3-3

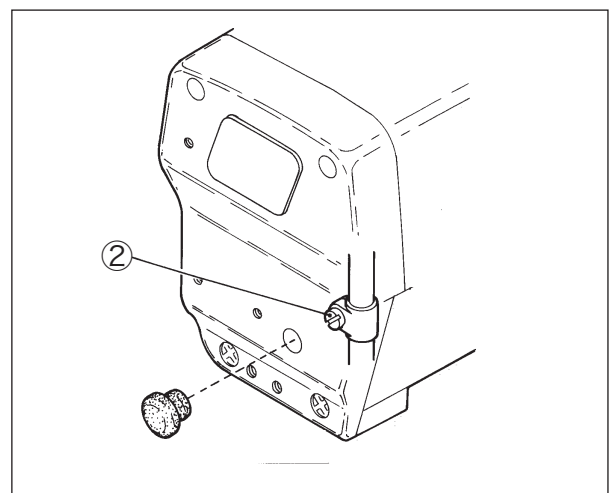


Fig. 3-4

3.3 Back-and-forth position of needle and looper

◇ When the looper tip ① and ② meets the needle ③ and ④, make the clearance between them to 0 - 0.05 mm. The adjustment for the looper ⑤ should be made at first place.

- (1) Insert the looper ⑤ (with a flat spot) all the way into the looper holder then tighten the screw ⑥.
- (2) Loosen the screw ⑦. Adjust by moving the looper holder ⑧ back and forth then tighten the screw ⑦ securely.
- (3) Loosen the screw ⑩. Adjust by turning the looper ⑨ (without flat spot) then tighten the screw ⑩.

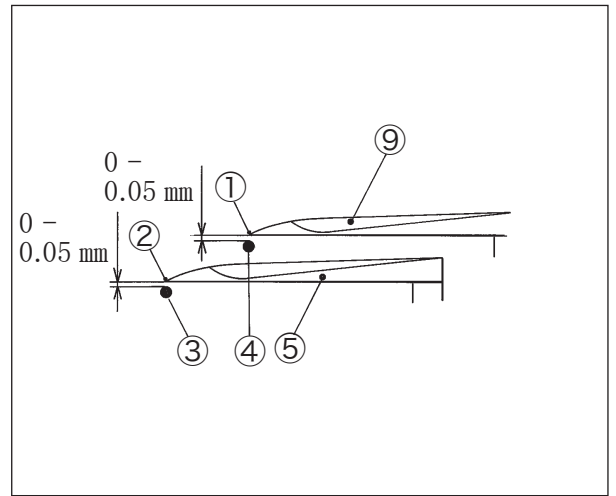


Fig. 3-5

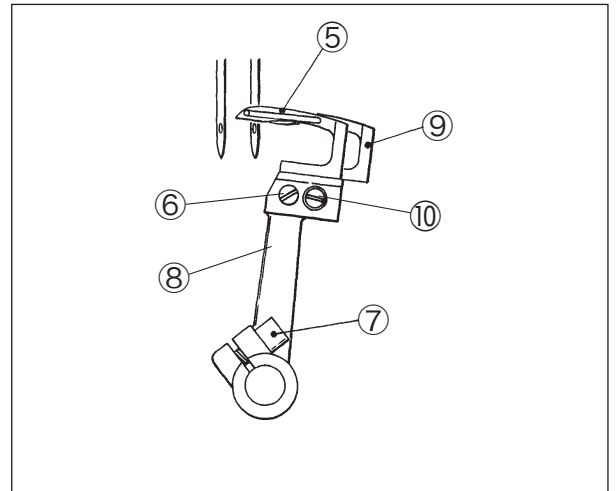


Fig. 3-6

3.4 Needle and needle guard (rear)

Height:

Align the line "A" on the needle guard(rear) ① with the center of the needle eye at the lowest point.

Loosen the screw ② to adjust it.

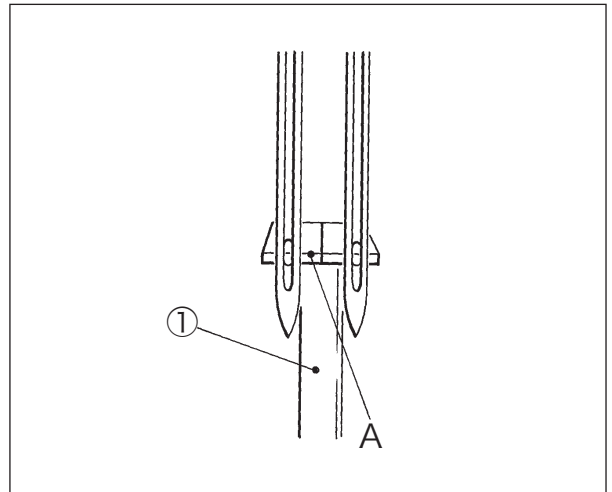


Fig. 3-7

Back-and-forth position:

When the looper ③ tip meets the center of the needle, make the clearance between the needle and the looper ③ tip to 0 - 0.05 mm to push the needle guard(rear) ① to the needles respectively.

Loosen the screws ② and ④ to adjust them.

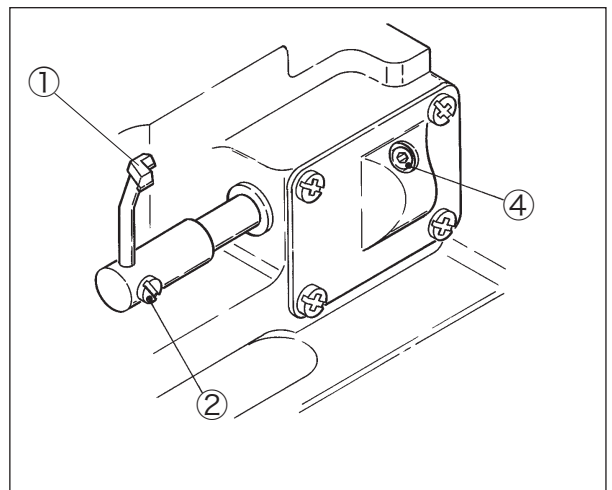


Fig. 3-8

i SUPPLEMENT

When the needles are at the lowest point, the clearance between the needles and the needle guard(rear) is 0 - 0.05 mm.

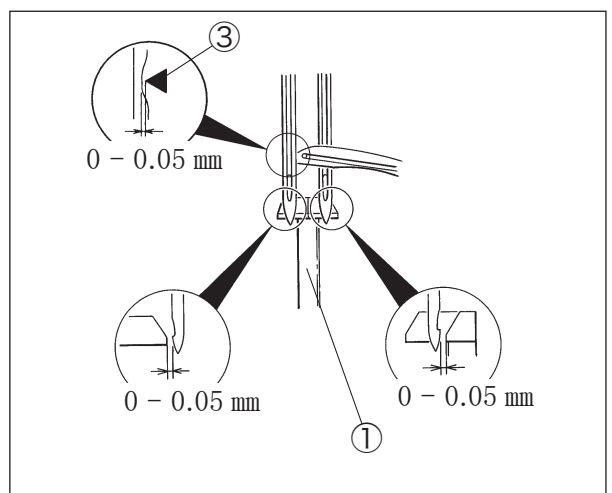


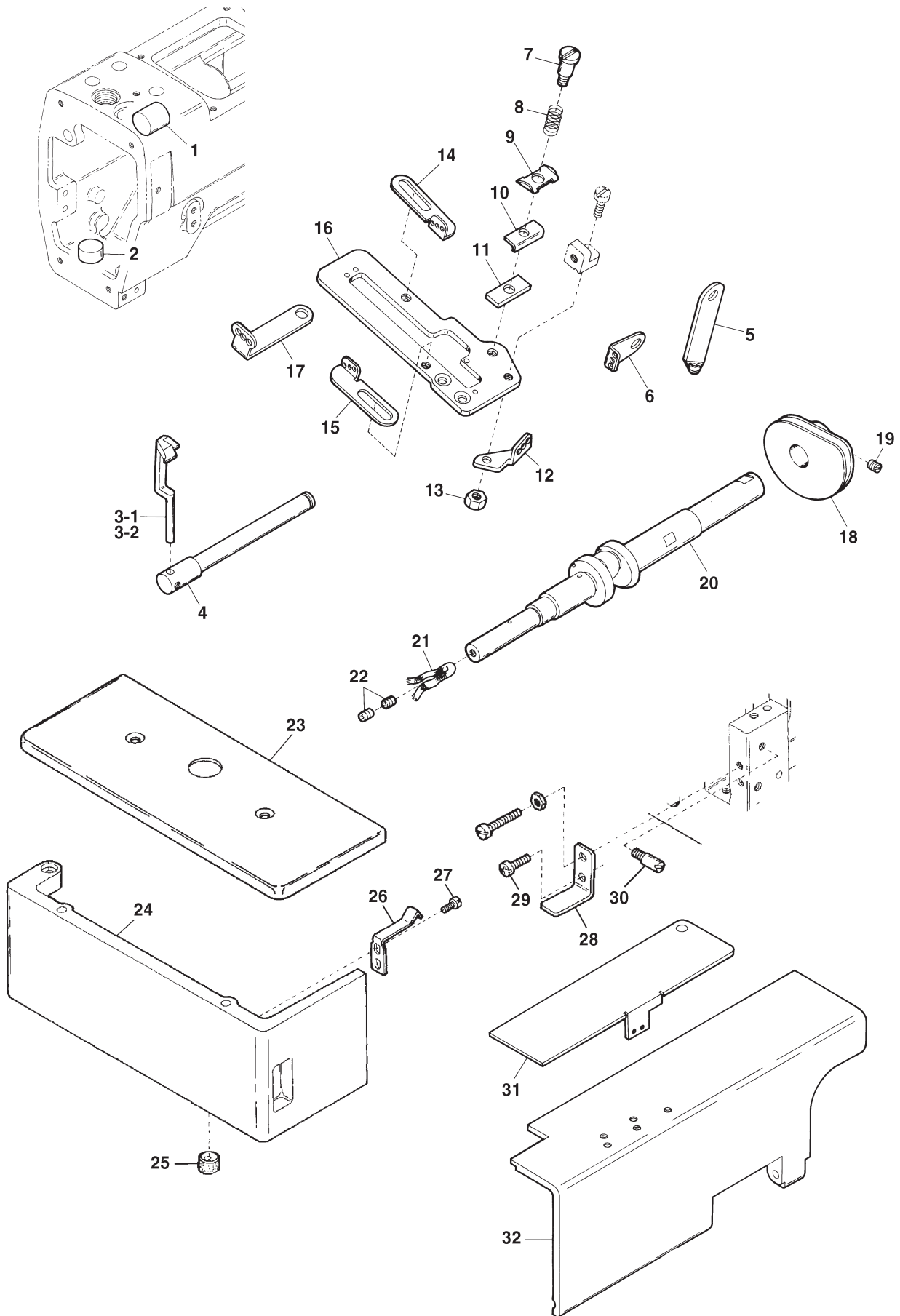
Fig. 3-9

ILLUSTRATED SPARE PARTS LIST

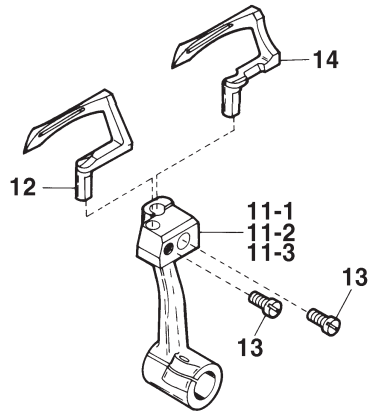
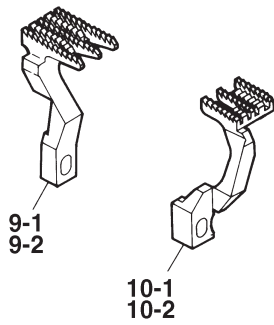
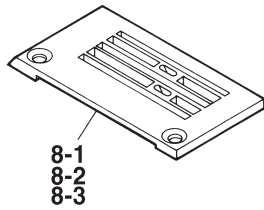
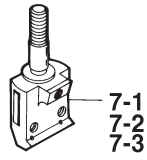
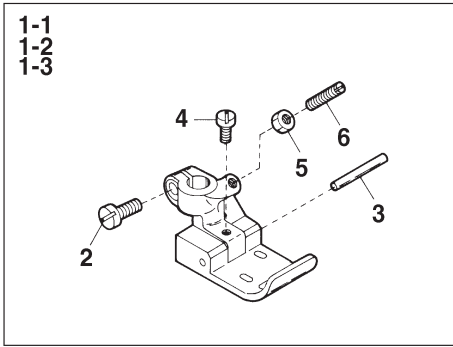
CF2302M

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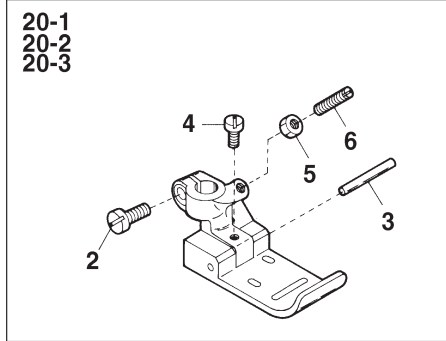
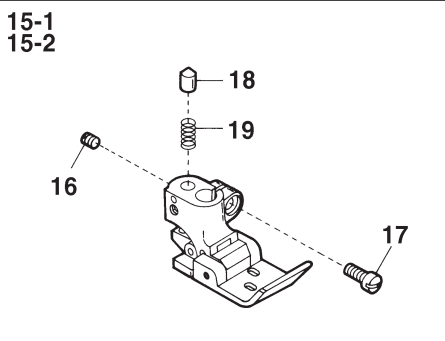
CF2302M-064, 080, 095(1)



Ref.No	Parts No.	Description	品 名	Amt. Req
1	6101128	Seal Plug	詰詮	1
2	6101125	Seal Plug	詰詮	1
3-1	9109208	Needle Guard(Rear)(64, 80)	針受ケ (後)	1
3-2	6109209	Needle Guard(Rear)(95)	針受ケ (後)	1
4	6101139	Needle Guard Driving Shaft	針受ケ軸	1
5	6101131	Looper Thread Eyelet	ルーパ糸道	1
6	6101140	Looper Thread Eyelet(Right)	ルーパ糸道 (右)	1
7	270012	Screw(1/8-44×5)	止ネジ	1
8	6101126	Looper Thread Retainer Spring	小調子バネ	1
9	6100194	Looper Thread Retainer	小調子皿	1
10	6100193	Looper Thread Retainer Bracket	小調子板	1
11	6101130	Looper Thread Retainer Holder	小調子台	1
12	6101138	Looper Thread Eyelet(Center)	ルーパ糸道 (中)	1
13	000322	Nut	ナット	1
14	6101133	Looper Thread Take-up Eyelet(Right)	調子カム糸道 (右)	1
15	6101132	Looper Thread Take-up Eyelet(Left)	調子カム糸道 (左)	1
16	6101137	Supporting Plate	カム糸道取付板	1
17	6101141	Looper Thread Eyelet(Left)	ルーパ糸道 (左)	1
18	6101127	Looper Thread Take-up	下糸調子カム	1
19	008047	Screw(7/32-32×3.6)	止ネジ	2
20	6101142	Lower Crankshaft	下軸クランク	1
21	310055	Oil Wick	油芯	1
22	160007	Screw(M6-1×6)	止ネジ	2
23	6100007	Cloth Plate(Small)	小カバー	1
24	6100004	Side Cover	横開キカバー	1
25	6100020	Rubber Cushion(Large)	クッションゴム (大)	1
26	6100022	Cover Latch Spring	カバーラッチバネ	1
27	120012	Screw(M4-0.7×5)	止ネジ	2
28	6100023	Side Cover Holder	横開キカバー受ケ	1
29	110013	Screw(M4-0.7×8)	止ネジ	1
30	180018	Screwed Pin(M4-0.7×7)	ピンネジ	1
31	6100034	Looper Thread Take-up Cover(64, 80, 95)	カムカバー	1
32	6101143	Front Cover(64, 80, 95)	前開キカバー	1



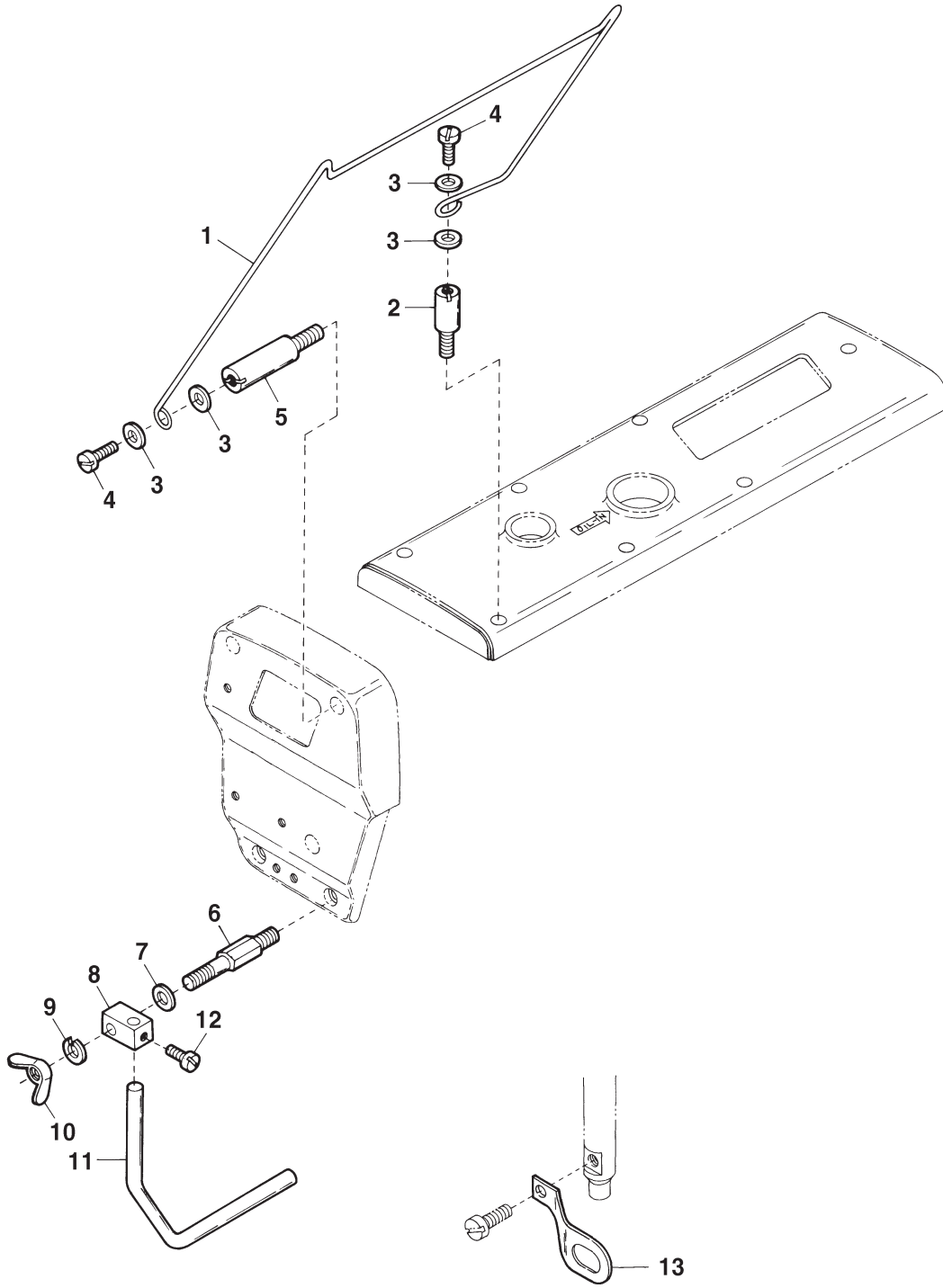
EXTRA PARTS



Ref.No	Parts No.	Description	品 名	Amt. Req
1-1	6107055	Presser Foot, C. Set(64)	押工 (組)	1
1-2	6107056	Presser Foot, C. Set(80)	押工 (組)	1
1-3	6107057	Presser Foot, C. Set(95)	押工 (組)	1
2	110004	Screw(M3.5-0.6×8)	止ネジ	1
3	6107063	Presser Foot Hinge Pin	押エヒンジピン	1
4	110084	Screw(M3-0.5×4.2)	止ネジ	1
5	000327	Nut	ナット	1
6	260006	Screw(1/8-44×9.5)	止ネジ	1
7-1	6109110	Needle Clamp(64)	針止メ	1
7-2	6109111	Needle Clamp(80)	針止メ	1
7-3	6109112	Needle Clamp(95)	針止メ	1
8-1	6108042	Stitch Plate(64)	針板	1
8-2	6108043	Stitch Plate(80)	針板	1
8-3	6108044	Stitch Plate(95)	針板	1
9-1	6109048	Main Feed Dog(64)	後送り	1
9-2	6109049	Main Feed Dog(80, 95)	後送り	1
10-1	6109046	Differential Feed Dog(64)	前送り	1
10-2	6109047	Differential Feed Dog(80, 95)	前送り	1
11-1	6101134	Looper Holder(64)	ルーパ台	1
11-2	6101135	Looper Holder(80)	ルーパ台	1
11-3	6101136	Looper Holder(95)	ルーパ台	1
12	6109312	Looper	ルーパ	1
13	110057	Screw(M4-0.7×7)	止ネジ	2
14	6109313	Looper(Right)	ルーパ (右)	1
15-1	6107058	Presser Foot, C. Set(64)(Extra)	押工 (組)(特注品)	1
15-2	6107059	Presser Foot, C. Set(80)(Extra)	押工 (組)(特注品)	1
16	001459	Screw(9/64-40×3)	止ネジ	1
17	001186	Screw(9/64-40×7.8)	止ネジ	1
18	6107065	Presser Foot Pin	押エピン	1
19	6107064	Presser Foot Spring	押エバネ	1
20-1	6107060	Presser Foot, C. Set(64)(Extra)	押工 (組)(特注品)	1
20-2	6107061	Presser Foot, C. Set(80)(Extra)	押工 (組)(特注品)	1
20-3	6107062	Presser Foot, C. Set(95)(Extra)	押工 (組)(特注品)	1

3

CF2302M-095(3)



Ref.No	Parts No.	Description	品 名	Amt. Req
1	6100561	Tape Holder	テープ受ケ	1
2	190021	Screw(M4-0.7×12)	止ネジ	1
3	000538	Washer	ワッシャ	4
4	110048	Screw(M4-0.7×10)	止ネジ	2
5	190044	Screw(M4-0.7×12)	止ネジ	1
6	190022	Screw(M4-0.7×12, M5-0.8×21)	止ネジ	1
7	000669	Washer	ワッシャ	1
8	6100574	Tape Guide Bar Holder	テープバー腕	1
9	000600	Spring Washer	スプリングワッシャ	1
10	100028	Wing Nut	チョウナット	1
11	6101129	Tape Guide Bar	テープガイドバー	1
12	009604	Screw(11/64-40×5.5)	止ネジ	1
13	6100527	Finger Guard	フィンガガード	1

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