

**GLOBAL**

**100 P**  
**100 S**

**Single thread chainstitch, handstitch machine**

**spare parts &  
instruction manual**

## 一、机器简介：

ST-128 型链式珠边机是单直机针，单直钩针，单线链式线迹的工业缝纫机。线迹的一面与手工缝制的线迹相同，适用于缝纫中等厚度的棉、毛、化纤等织物，是高级西服、西裤、女大衣时装等服装装饰缝纫的理想产品。

机器结构采用连杆挑线，钩针勾钩，直线往复式推线弯针推线，上下轴用螺旋伞齿轮转动，因此能保证机器运转平稳，噪音低使用方便，经久耐用。

### 1.Introduction

ST-128 series chains-type hand-stitch machine is one single-thread chainstitch industrial sewing machine with single straight needle and crochet hook. Its stitch is similar to handmade type, it is suitable for medium--thickness fabric, such as cotton, wool, chemical fibre etc. And it is the perfect products for sewing advanced suit, western-style trousers, woman overcoat and fashionable dress etc.

The machine adopt link-type thread take-up, crochet hook thread catching, linear reciprocating looper pushing and spiral bevel gear driving, thus guarantee that the machine working steadily, low noise, operating easily and long life.

## 二、主要技术规格

1. 最高缝纫速度：1000 针/分钟
2. 最长针距：5-8 毫米
3. 珠边长度：2-5 毫米
4. 压脚提升高度：6 毫米（膝提 10 毫米）
5. 能缝最大厚度：5 毫米（自由状态下呢绒或类似缝料）
6. 缝线规格：20S-60S × 3 涤纶线
7. 使用机针：DP5 16#-20#
8. 使用直钩针：151S (CP × 12) 12-21#
9. 针杆右侧面工作空间：270 × 135 毫米（长 × 高）
10. 电动机功率：380V/370W 四级（220V/250W 四级）

### II .Main technical specification

1. Max.Sewing Speed: 1000 r.p.m
2. Max.needle gauge: 5-8mm
3. Hand-stitch length: 2-5mm
4. Presser foot lift: 6mm(by knee 10mm)
5. Max.Permitting Thickness: 5mm (woolen cloth or similar stitching material under free condition)

6. Suture specification: 20S 60 S \* 3 dacron thread.
7. Needle No.: DP5 16#~20#
8. Straight crochet hook No.: 151 S(CP\*12) 12-21#
9. Needle bar right-side work space: 270 \* 135mm(length \* height)
10. Motor power: 380V / 370 W four grade (220V250 W four grade)

### 三、机器的调整

#### 1. 钩线弯针的调整

当机针向下运动到最低位置后，再回升 1.5 毫米时钩线弯针的针尖应正好运动到机针中心线位置，这时钩线弯针的钩尖高于针孔上边 2 毫米，钩尖平面与机针缺口底部的间隙是 0.05-0.1 毫米，调节的方法是松开钩线凸轮和钩线针架的螺钉进行调节。

#### 2. 送线弯针的调整

转动上轮，使送线弯针架运动到左极限，松开送线弯针调节螺钉，调好送线弯针的左右位置，然后松开送线弯针螺钉调整送线弯针的前后位置。

#### 3. 送线弯针和钩线弯针的同步调整

松开送线凸轮上的二个紧固螺钉，转动上轮，使钩线弯针的勾尖运动到机针中心线位置。再沿下轴转动方向转动送线弯针凸轮，使送线弯针的针尖向前运动到直钩针中心线位置时紧固送线弯针凸轮上的二个紧固螺钉。送线弯针和钩线弯针的配合是这台缝纫机的重点必须反复细致地调整。

### III. Adjustment of the machine

#### 1. The adjustment of the hooking looper

When the needle moves downward the lowest position and goes up 1.5mm, the hooking looper point should just reach the center line of the needle, which the hooking looper point is higher than the needle hole 2mm and the intervals between the looper point plane and jag bottom of the needle is 0.05-0.1mm, the regulating method is to unclamp and regulate screws of hook cam and hook rack.

#### 2. The adjustment of feeding looper

It moves the feeding looper rack to the left limit by rotating upper wheel, then loosens the feeding looper to regulate the screws and adjust the right-and-left position, at last it loosens the feeding looper to regulate the screws to adjust its around position.

#### 3. The synchronous adjustment of the feeding & hook looper

Please unclamp two fastening screws of the feeding cam and rotate the upper wheel until the hook looper point reaches the centerline of the needle, then rotate the feeding looper cam along the lower shaft until the feeding looper point moves to the centerline of the straight needle to fasten the two tightening screws of feeding looper cam. It is vital for the machine to assort the feeding looper with hook looper carefully and iteratively.

四、零件样本及图号：

IV.Parts sample and fig.No.:

序号 Serial number	件号 Piece number	名称 Name	数量 Quantity	备注 Remark
1	ST128-1	送线弯针 Feeding looper	1	
2	ST128-2	送线弯针螺钉 Feeding looper screw	3	1/8×44×5 1/8*44*5
3	ST128-3	送线弯针架 Feeding looper rack	1	
4	ST128-4	送线弯针调节块 Feeding looper regulating block	1	
5	ST128-5	送线弯针轧头 Feeding looper nobbing	1	
6	ST128-6	送线弯针轧头螺钉 Feeding looper nobbing screw	1	4×12 内六角 4*12 Hexagon
7	ST128-7	送线弯针调节螺钉 Feeding looper regulating screw	1	4×16 内六角 4*16 Hexagon
8	ST128-8	送线弯针固定轴 Feeding looper fixed axis	1	
9	ST128-9	送线弯针凸轮 Feeding looper cam	1	
10	ST128-10	送线弯针弹子 Feeding looper billiards	2	
11	ST128-11	送线凸轮哈夫 Feeding cam cotter	1	
12	ST128-12	支架 Bracket	1	
13	ST128-13	支架螺钉 Bracket screw	2	5×16 内六角 5*16 Hexagon
14	ST128-14	钩线凸轮哈夫 Hook cam cotter	1	
15	ST128-15	钩线凸轮 Hook cam	1	
16	ST128-16	钩线连杆 Hook connecting rod	1	
17	ST128-17	凸轮紧定螺钉 Cam fastening screw	4	6×6 紧定 6*6 fastening

序号 Serial number	件号 Piece number	名称 Name	数量 Quantity	备注 Remark
18	ST128-18	钩线连杆轧头螺钉 Hook link nobbing screw	1	4×10 内六角 4*10 Hexagon
19	ST128-19	钩线弯针轴 Hook looper axis	1	
20	ST128-20	钩线弯针轴垫川 Hook looper axis gasket	1	8×13×1 垫川 8*13*1 gasket
21	ST128-21	钩线弯针架 Hook looper rack	1	
22	ST128-22	钩线弯针架轧头螺钉 Hook looper rack nobbing screw	1	4×10 内六角 4*10 Hexagon
23	ST128-23	钩线弯针 Hook looper	1	
24	ST128-24	钩线弯针固定螺钉 Hook looper fastening screw	1	4×12 内六角 4*12 Hexagon
25	ST128-25	哈夫螺钉 Cotter screw	4	19/64×40×8 19/64*40*8
26	ST128-26	送线弹子固定螺钉 Feeding billiards fixed screw	1	4×10 内六角 4*10 Hexagon
27	ST128-27	钩线连杆固定螺钉 Hook link fixed screw	1	4×8 内六角 4*8 Hexagon
28	ST128-28	下轴 The lower shaft	1	
29	ST128-29	送线弯针架垫川 Feeding looper rack gasket	1	8×13×0.5 8*13*0.5
30	ST128-30	针杆 Needle rod	1	
31	ST128-31	针位 Needle gauge	1	
32	ST128-32	钩针 Hook needle	1	151S(CP×12) 151S(CP*12)
33	ST128-33	直针 Straight needle	1	
34	ST128-34	针板 Needle plate	1	D13×1 D13*1

## 五、常见故障和解决方法：

故障分类		可能产生的原因	建议处理方法
针迹不均或不正确		①夹线板之间有灰尘或纤维使这失去夹线板的作用②钩针位置不正确	①拆开夹线板，消除灰尘和纤维②调整钩针位置
跳针	上跳针	①针杆左右位置不正确，钩针的左右和方法不对②机针的尖端或柄部弯曲针尖磨钝③机针型号或针号不对④双针不在同一个垂直平面上⑤钩针左右不正确⑥针杆和钩针左右不正确⑦线牢度过强，压线板压力大直针向左弯走	①注意针杆左右是否平行②注意钩针钩是否对准直针③线强度过强直针向左弯走要注意钩针向左弯少量，线环圈向左走，直针尖对准钩针线环圈不会跳针。
	下跳针	①重新调整针杆左右②更换新机针③选用合适的机针型号④双针重新调整使在同一垂直平面上⑤转动钩针的左右方向⑥针杆高低有何标准？答针杆上的直针穿线孔上，弯针尖距离 3-4 毫米。 ⑦横针左右有何标准？答横针转到左停止点时横针尖与直针之间距离 5-6 毫米⑧弯针前后有什么标准？答当转动弯针尖与直针中心时横针尖头未到双针中之间跳离 1.5-1.8 毫米。	⑨针杆与下弯针之间有何标准？答针杆到下止点弯针尖未到针空隔 4-5 毫米。
钩针原因		①带有较强性能的丝料尼龙麻纱布，进口布等容易钩丝。	②注意事项，选择钩针头多弯、牙齿时间过早些转动手轮钩针钩头，达到针板平面，牙齿已爬 0.5-1 毫米。
机针断线		①针号和线号不符②针孔毛糙或机针质量太差③缝线质量不好④穿线错误和面线太紧⑤线架有阻力⑥线夹过紧	①更换适当缝线②更换新机针③换用质量较好的缝线④正确穿线和调松面线⑤调整线架位置⑥松动线夹
断针倒针		①机针型号不对②上下布边不对准③弯角处过厚④挑线杆不到最高位置时就转弯⑤过硬或布针工作会断针⑥工人操作不熟练。	①更换机针②上下布边注意对准③减慢速度④挑线杆不到最高位置时就转弯⑤要用手转支皮带轮⑥用机针型号不能低于 18-20 号

## V. Malfunctions and treatments :

Malfunction Category		Possible reason	Advised treatment
Stitch is uneven Or incorrect		①there are dusts or fibres among cramps so that the cramp is out of order ②the hook on the wrong position	①take apart cramp to put out dusts and fibres ②regulate the hook
Needle	Upper Jumping	①the needle rod position is incorrect,so as to the direction and position of the hook②the needle point or petiole curved and the needle point dull③ the needle type or number is incorrect④a pair of needles is not on the same vertical plane ⑤hook is on the wrong position⑥the needle rod and hook is on the wrong position⑦the tightness of the thread is too strong, the clamp pressure is large and the straight needle turn left.	①make sure the needle rod is parallel ②make sure the hook point aiming at the straight needle③when the thread tightness is too strong and the straight needle turn left, you should make sure the hook turn left only a little, the thread winding move left, the straight needle point aims at the hook thus the needle will not jump away.
	Lower Jumping	①readjust the needle rod position②change the needle③select fit needle type④readjust a pair of needles on the same vertical plane⑤turn the hook s right-and-left direction⑥is there any standard for the needle rod? Key:on the vertical punch of the needle rod,the distance from looper point is3-4mm ⑦is there any standard for horizontal needle? Key:the horizontal needle reaches the left stop point,the distance from the straight needle is 5-6mm⑧looper position standard:When rotating looper to straight needle centre,the distance between the horizontal needle and the midst of two needle is 1.5-1.8mm	⑨the standard between the needle rod and lower looper: The distance is 4-5mm
Hook silk		①some fabres as silk, nylon,flax, imported cloth etc.with strong performance are easily hooked	②make sure to flat the hook point in time under the condition of too many crooks,the distance is 0.5-1mm
The needle break the thread		①the needle number is not agree with the thread number②pinhole is coarse or the needle is bad③suture are not good④thread-needle is wrong and too tight⑤there is obstruction in the thread rack⑥the clip is too tight	①change the suture ②change the needle ③ put on a better suture ④ thread the needle correctly and unclamp the thread ⑤regulate the rack position ⑥ loose clip
Break or reverse needle		①the needle type is incorrect②the upper and the lower cloth edge is not homologous③the curved part is too thick④the take-up rod turns under the highest position⑤too hard or the needle is easy broke⑥the workers operating is unexperienced.	①change the needle②level the upper and the lower cloth edge③reduce the speed④make the take-up rod turn at the highest position⑤rotate the leather belt wheel by hand⑥the needle type should be over 18-20#

