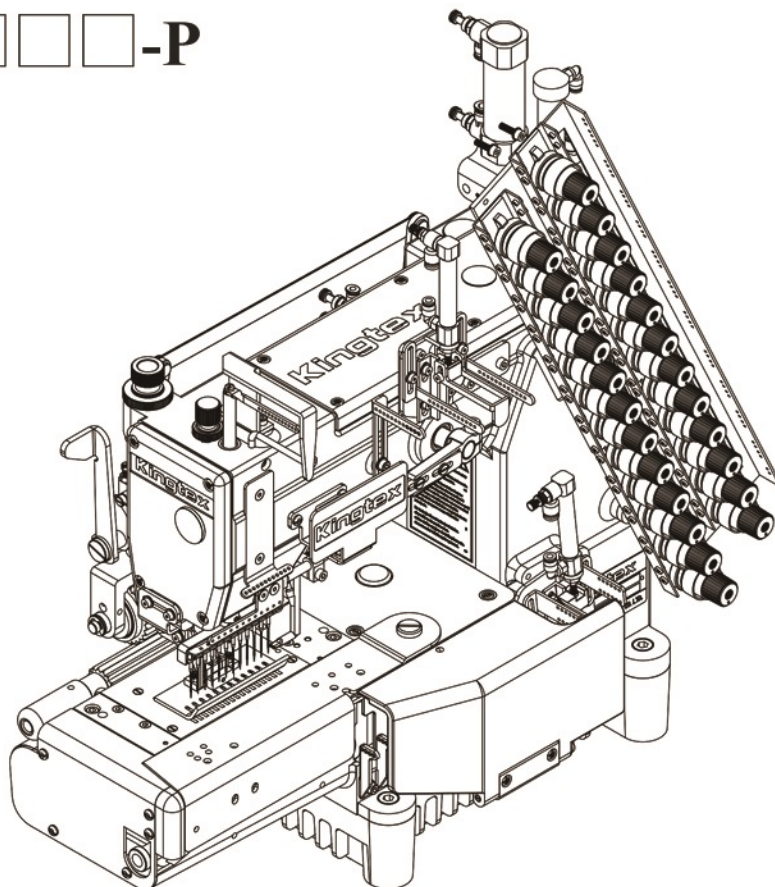


MT SERIES

寶獅牌工業用縫紉機 INDUSTRIAL SEWING MACHINE

MODEL

MTD4500/UT□□□-P



THREAD TRIMMING SYSTEM FOR MULTI-NEEDLE DOUBLE CHAIN STITCH MACHINE

User Manual



精機機械廠股份有限公司 CHING CHI MACHINE CO., LTD
<http://www.kingtexsewing.com.tw>

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一般安全指示說明 General Safety Instructions

警告！當使用這台機器時，基本的安全預防措施應加以遵守，以避免火災、電擊和個人的受傷。

Warning ! When using this machine, basic safety precautions should always be followed to reduce the risk of fire, electric shock and personal injury .

請在使用這台機器時，先閱讀下列安全性注意事項並妥善收藏本說明書。

Read all these instructions before operating this product and save these instructions.

1. 請保持工作環境之清潔 Keep work area clean

雜亂的區域及板凳易引起意外之發生。

Cluttered areas and benches invite injuries.

2. 考慮到工作區域之環境 Consider work area environment

請勿將電力暴露於雨水之中，請勿使用潮溼之工具，或在潮溼之環境工作，請保持工作區域之明亮，請勿使用易遭火災或爆炸之工具。

Do not expose power to rain. Do not use machine tools in damp or wet locations. Keep work area well lit. Do not use power tools where there is risk to cause fire or explosion.

3. 請對電擊特別小心 Guard against electric shock

請勿接觸地線或有接地線之物品表面（如管線、散熱器或電冰箱）。

Avoid body contact with earthed or grounded surfaces (e.g. pipes, radiators, refrigerators)

4. 請勿讓兒童靠近 Keep children away

請勿讓訪客觸摸工具或延長線。

Do not let visitors touch the tool or extension cord.

5. 請穿著適當衣物 Dress properly

請勿穿著寬鬆衣物或配戴珠寶，因這些物品有可能會捲入機器內，如留有長髮，則煩請戴上髮套。

Do not wear loose clothing or jewelry, they can be caught in moving parts. Wear protecting hair covering to contain long hair.

6. 請勿濫用電線 Do not abuse the cord

請勿以電線提著機器或從插頭上用力拔起，請勿讓電線靠近熱油或物品之尖銳邊緣。

Never carry the machine by cord or yank it to disconnect it from the socket. Keep the cord away from heat, oil and sharp edges.

7. 請小心維護機器 Maintain machine with care

請依照使用說明按時潤滑機器以及更換零件，定期檢查工具電線，如有損傷，請儘早授權服務機構修理。

Follow instructions for lubrication and changing accessories. Inspect tool cord periodically and if damaged, have it repaired by an authorized serviced facility.

8. 關閉機器電源 Disconnect machine power

當不使用機器時，或在維修、更換零件附件時，請先關閉電源。

When not in use, before servicing and changing accessories, please disconnect electricity.

一般安全指示說明 General Safety Instructions

9. 請避免無意中開機 Avoid unintentional starting

在搬運有插入電源之工具時，請勿將手放置在開關之位置，當插入電源線時請先確認開關是在關閉的位置。

Do not carry plugged - in tool with finger on the switch. Ensure switch is off when plugging in.

10. 檢查受損零件 Check damaged parts

在進一步的使用機器前，在更換受損零件之後，都應確實檢查來決定機器是否能適當操作，並達到想要之功能。

Before further use of the machine, after replaced the damaged parts, the machine should be carefully checked to determine that it will operate properly and perform its intended function.

11. 警告 Warning

如使用在此本使用說明中，任何未經推薦之零件，將會有可能帶來人身之危險。

The use of any accessory or attachment, other than those recommended in this instruction manual, may present a risk of personal injury.

12. 請使用合格之維修人員修理您的機器 Have your machine repaired by a qualified person

任何修理需經過合格之維修人員處理，並使用原廠零件。

Repairs should only be carried out by qualified persons and using original spare parts.

對於電力聯結之特別警告 Special Warning For Electric Connection !

1. 請在此台機器中使用合於歐州規範之開關。

Incorporate this machine only with "CE" certificate switch.

2. 請依照使用說明來安裝控制盒。

Follow the instruction manual to install control device.

3. 永遠在使用機器上安裝地線。

Always earth machine appropriately during operation.

4. 在做任何調整、零件更換或維修之前，請確認所有電源線已從插頭上拔除，以避免機器無意中突然啟動時之危險。

Before adjustment, parts change or servicing must be sure to pull out the plug from socket to prevent the hazard of unintentionally start of machine.

CONTENTS

機型編號說明	MODEL NUMBERING	1
1. 安裝基本線路	WIRING INSTALLATION	2
2. 切刀速度控制	THREAD TRIMMER SPEED CONTROL	3
3. 調整調壓濾水閥的空壓設定	ADJUSTMENT OF THE AIR PRESSURE SETTING FOR AIR REGULATOR	3
4. 調整活動刀與固定刀	ADJUSTMENT OF MOVABLE KNIFE AND FIXED KNIFE	4
5. 結線鉤及活動刀之間的關係	THE CONNECTION BETWEEN THE KNOT HOOK AND THE MOVABLE KNIFE	5
6. 調整夾線簧片與簧壓	ADJUSTMENT OF THE THREAD CLAMP SPRING AND SPRING PRESSURE	6
7. 調整壓腳支架	ADJUSTMENT OF PRESSER FOOT HOLDER	6
8. 調整吹線器	ADJUSTMENT OF THE AIR WIPER	7
9. 鬆線裝置調整	ADJUSTMENT OF THREAD TENSION RELEASE COMPONENTS	8
10. 拆卸切線機構	DISASSEMBLY OF THE THREAD TRIMMING MECHANISM	9
11. 換向閥配線圖	WIRING OF ELECTROMAGNETIC VALVE	10
12. 空壓組件	COMPRESSED AIR COMPONENTS	11

M T 4 5 0 0 SERIES 筒型多針雙鏈縫紉機 Cylinder Bed Multi-Needle Double Chainstitch Machine

● 機型編號說明 Model numbering

M T 4 5 1 2 P - 0 6 4 / U T 1 2 A - P



① 自動切線裝置代號

Under bed thread trimmer device

② 針數 Number Of Needles :

04 : 4針 4-Needle 13 : 13針 13-Needle

06 : 6針 6-Needle 17 : 17針 17-Needle

09 : 9針 9-Needle 25 : 25針 25-Needle

12 : 12針 12-Needle

U T 1 2 A - P
 ↓ ↓ ↓ ↓
 ① ② ③ ④

③ 針距 Needle Distance Code

UT	A	B	C	S	S1
	064 (1/4)	085 (1/3)	095 (3/8)	127 (1/2)	064-254
UT04 □	●	● *	●	●	●

UT	A	S
	064 (1/4)	032 (1/8)
UT06 □	●	
UT09 □	●	
UT12 □	● *	
UT17 □		●
UT25 □		● *

* 版本 - P 已推出販售 New version available for sale

④ 版本代號 Version code

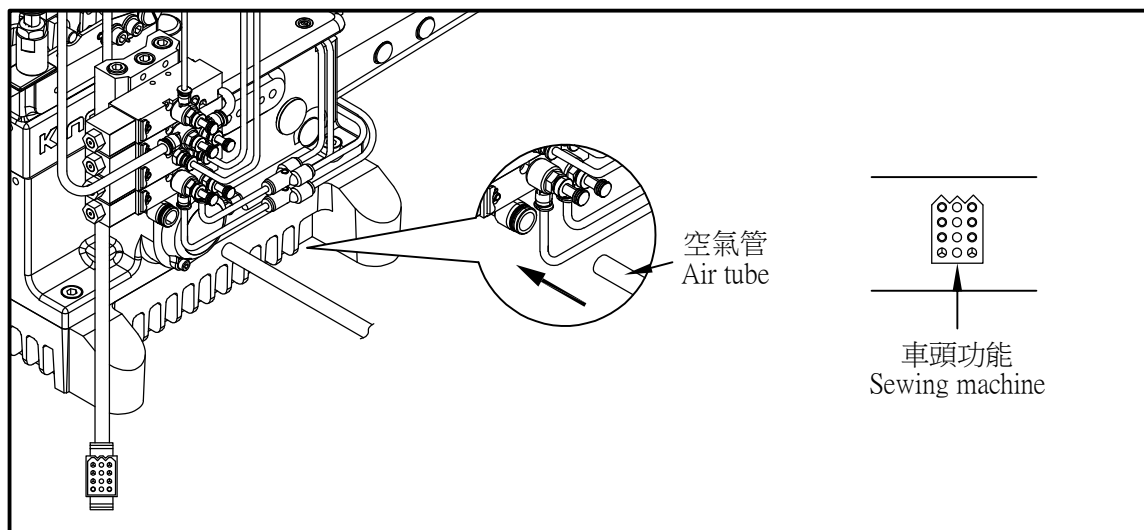
※機型、用途及可選擇加裝的裝置等其他資訊內容，可至本公司網站查詢或以電話方式諮詢

If you have any questions about our machine models, applications, optional device's or any other informations needed to know, please visit our company's website or contact us via e-mail, fax, telephone directly.

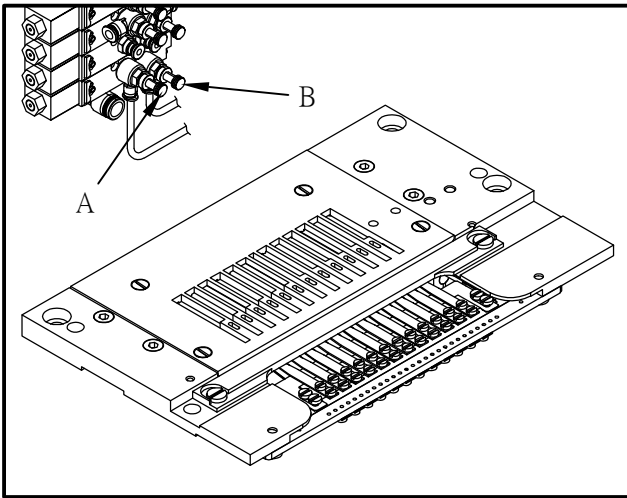
1. 安裝基本線路 WIRING INSTALLATION

當新機器置於車板上，且部份組件已安裝完成，接著請依圖示，將連接器安裝至馬達的控制箱上，進氣空氣管安裝至換向閥接頭上。

When the new machine is placed on the table and some components have been installed, please install the connector to the control box and the intake air pipe to be connected with electromagnetic valve as shown in the figure.

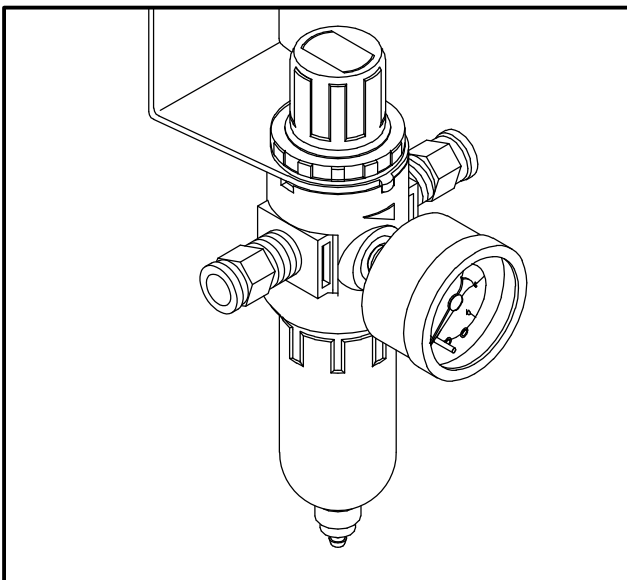


2. 切刀速度控制 THREAD TRIMMER SPEED CONTROL



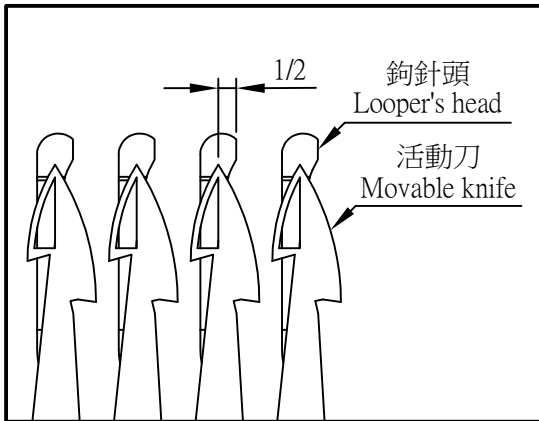
A 為切刀伸出速度控制，B 為切刀縮回速度控制。
A are the forwarding speed control for thread trimmer,
B are the retrieving speed control for thread trimmer.

3. 調整調壓濾水閥的空壓設定 ADJUSTMENT OF THE AIR PRESSURE SETTING FOR AIR REGULATOR



設定調壓濾水閥空壓為 $5\text{KG}/\text{cm}^2$
Setting the air pressure as $5\text{kg}/\text{cm}^2$.

4. 調整活動刀與固定刀 ADJUSTMENT OF MOVABLE KNIFE AND FIXED KNIFE

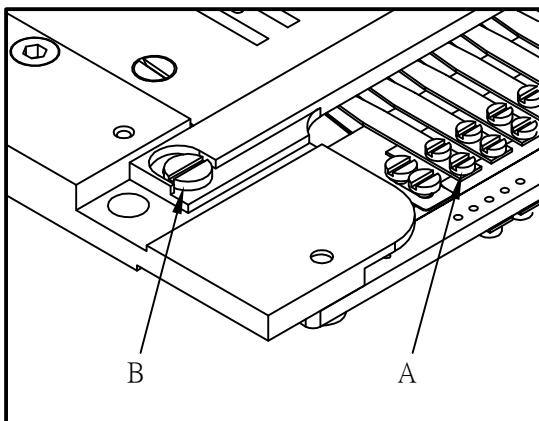
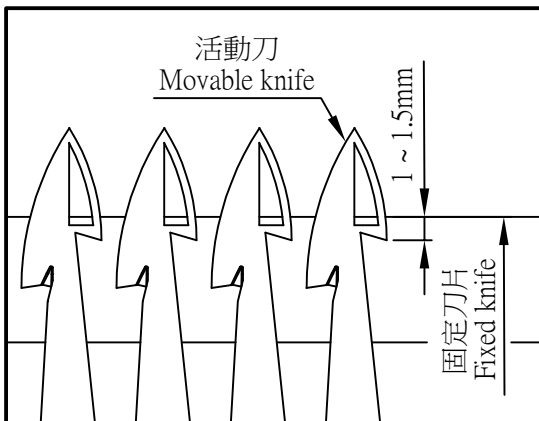


活動刀出刀時，刀尖對準鉤針頭的 1/2 處，放鬆螺絲 A 可做調整。

切刀組退到定位時，固定刀片與活動刀，兩刀口需有 1~1.5mm 的間距咬合，放鬆螺絲 B 可做調整

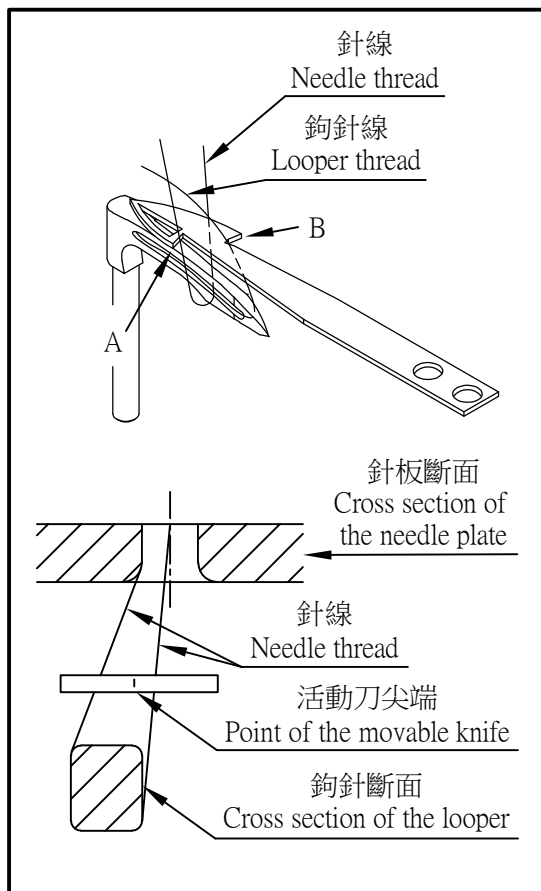
The movable knife must be at the 1/2 of looper's head, loose screw A to adjustment.

When trimming knife moves to its set position, there should have 1~1.5mm overlap between fixed knife and hook blade of movable knife, When adjusting , loosening screw B



5. 結線鉤及活動刀之間的關係

THE CONNECTION BETWEEN THE KNOT HOOK AND THE MOVABLE KNIFE



活動刀由下作動至上死點時，必須從針線的線環穿過，同時活動刀前段的鉤刀 B 必須在鉤針線的前面。

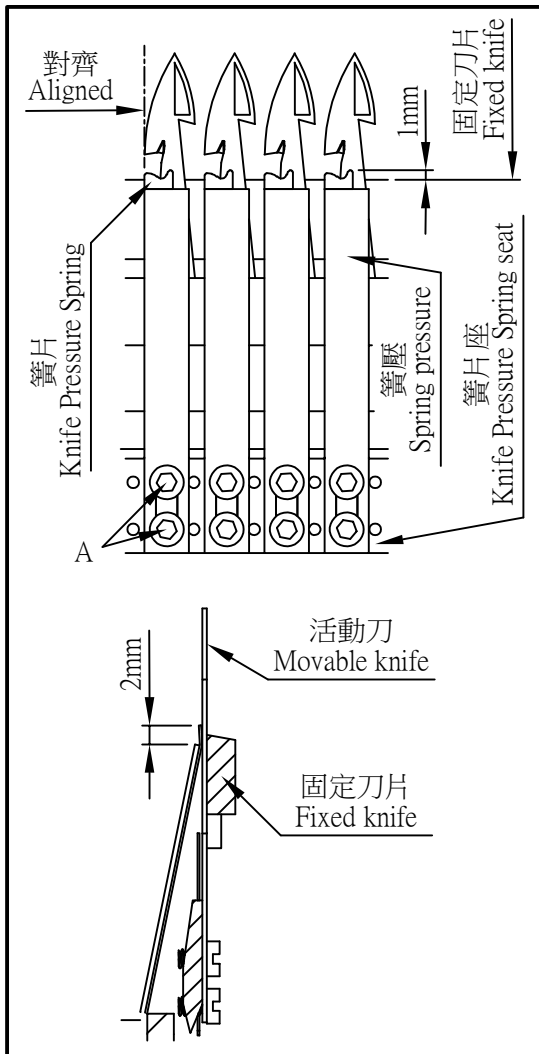
活動刀由上死點向下退回時，鉤刀 A、B 鉤住針線及鉤針線拉向固定刀片，隨後依序被切斷。

When movable knife moves from down to the top, it must go thru the needle thread loops, at the same time, the front hook blade B of movable knife must be in front of looper thread.

When movable knife moves from its top position to its down, hook blade A、B should hold needle threads and looper thread and pull it to the fixed knife then cut it sequentially.

6. 調整夾線簧片與簧壓

ADJUSTMENT OF THE THREAD CLAMP SPRING AND SPRING PRESSURE



活動刀往回作動時，簧片與活動刀邊緣切齊，上方凸出固定刀片 1mm，而間距可由螺絲 B 做調整。

簧壓的前端與簧片有 2mm 的距離，調整螺絲 B，可做位移。

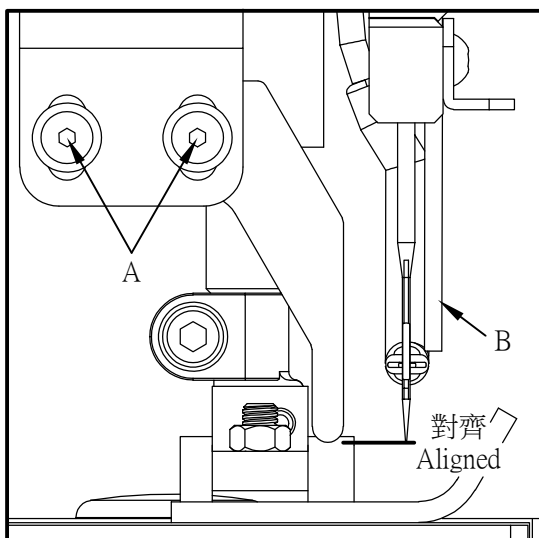
When the movable knife moves back, the spring is aligned with the edge of the movable knife, and the upper part protrudes 1mm from the fixed knife. The distance can be adjusted by screw B.

There is a 2mm distance between the front end of the spring pressure and the spring leaf, and the adjustment screw B can be used for displacement.

< 注意 Note >

調整簧片時，注意活動刀回復切斷針線後，針線不會卡住。Adjust the back spring so that the back spring does not hold the needle thread after it is cut.

7. 調整壓腳支架 ADJUSTMENT OF PRESSER FOOT HOLDER

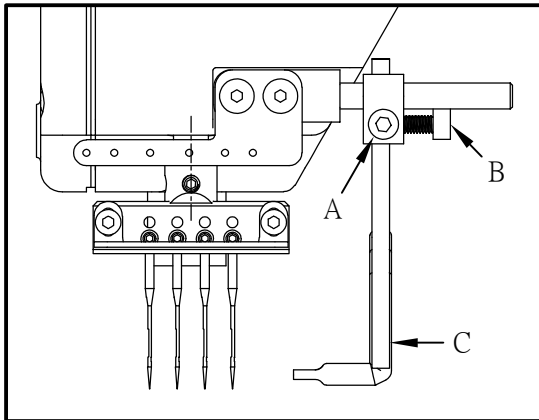


限制壓腳抬起時的角度，有助於吹線裝置 B 的運作，壓腳底部必須和針尖切齊，如有誤差，請放鬆螺絲 A 進行調整。

Limiting the angle at which the presser foot is raised helps the operation of the thread wiper device B.

Pressure foot must be aligned with the pin tail If timing is incorrect, loose screw A for adjustment.

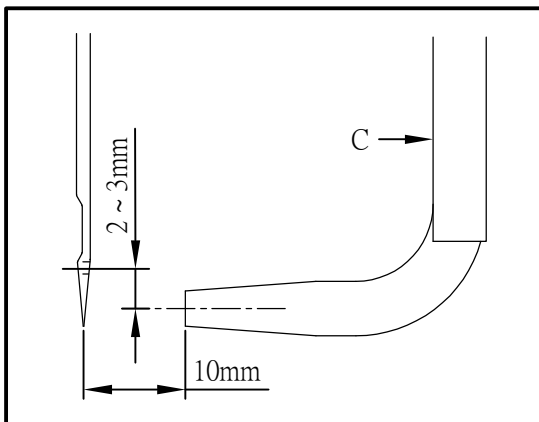
8. 調整吹線器 ADJUSTMENT OF THE AIR WIPER



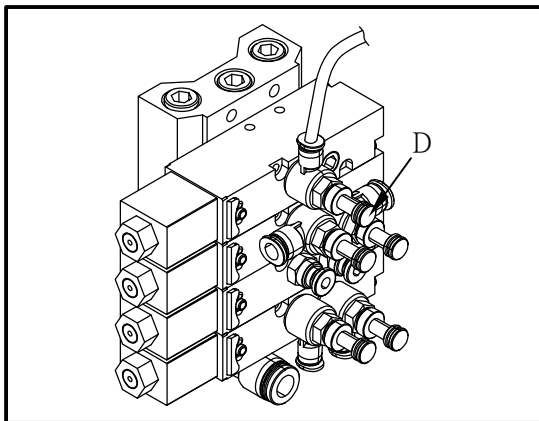
當針停在最高點時，吹線裝置 C 吹氣口與最右針距離 10mm，高度為針孔下方 2~3mm，放鬆螺絲 A、B 可做調整，風量調整則是旋轉車頭後方的調節鈕 D。

吹線裝置吹氣時間，出廠設定為 2 秒，如需要調整更長時間或改變較短時間，可由控制箱調整。

When the needle reached its highest position, the distance between air wiper C and rightest needle is 10mm, the height of air wiper is located 2~3mm below needle eyelet, When adjusting , loosening screw A and B, Turning speed controller of D can adjust the blowing amount of compressed air.



For original setting from factory, the standard setting of blowing time is 2 seconds. Any changes of blowing time, can be obtained by the adjustments from the control box.



9. 鬆線裝置調整 ADJUSTMENT OF THREAD TENSION RELEASE COMPONENTS

針線與底線經過正確的穿線，縫線均在合適的線孔後，其鬆線量，可以透過調整 A 的距離來改變。針線以螺絲 B 調整，底線則是以螺絲 C 調整。

若要增加線量，請減少距離 A。若要減少線量，請增加距離 A。

如果縫線是使用伸縮線，則是盡量減少距離 A。

After the needle and thread are correctly threaded and the sewing threads are in the appropriate thread holes, the amount of loose thread can be changed by adjusting the distance of A. The needle and thread are adjusted by screw B, and the bobbin thread is adjusted by screw C.

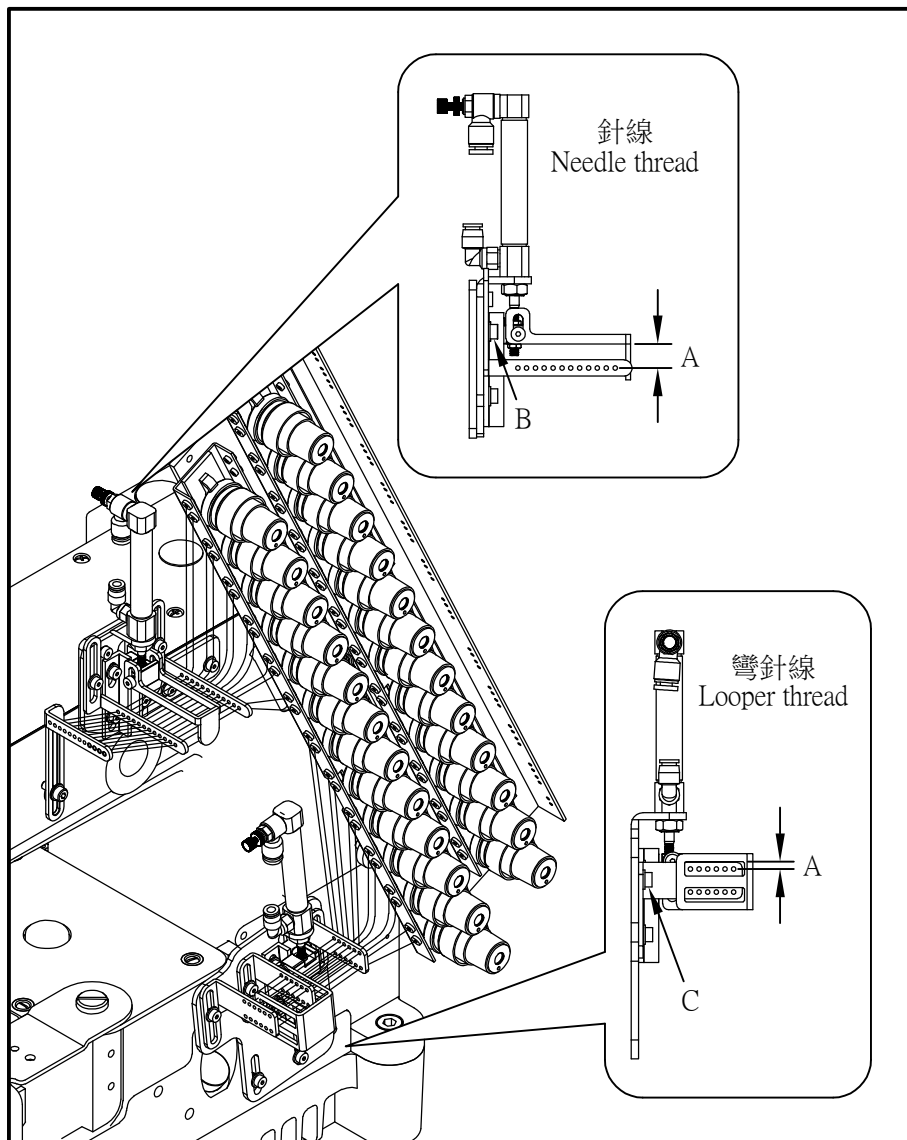
Thread the machine correctly by referring to the illustration on the below.

Install the thread eyelets for the needle and looper threads according to the distance in the illustration below.

To increase the amount of the thread to be released, decrease distance A.

To decrease the amount of the thread to be released, increase distance A.

If stretchable threads are used, decrease distance A.



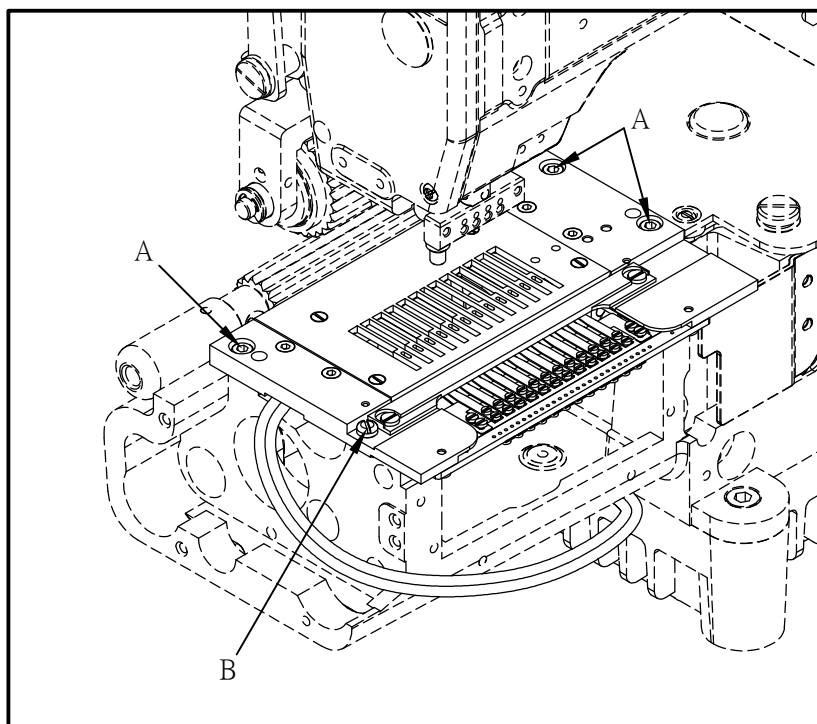
10. 拆卸切線機構 DISASSEMBLY OF THE THREAD TRIMMING MECHANISM

因清潔或調整機構、更換零件，拆卸切線機構將易於作業。

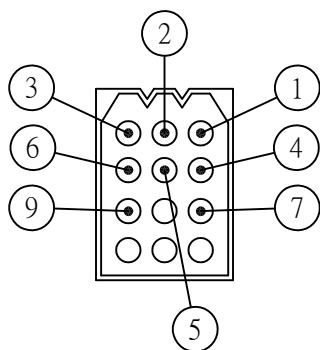
首先將壓腳支架、壓腳、吹線器、外蓋、氣管夾線拆除，接著鬆開螺絲 A、B，即可將切線機構取出。

Disassembling the thread trimming mechanism makes it easier to clean or adjust the mechanism or replace parts.

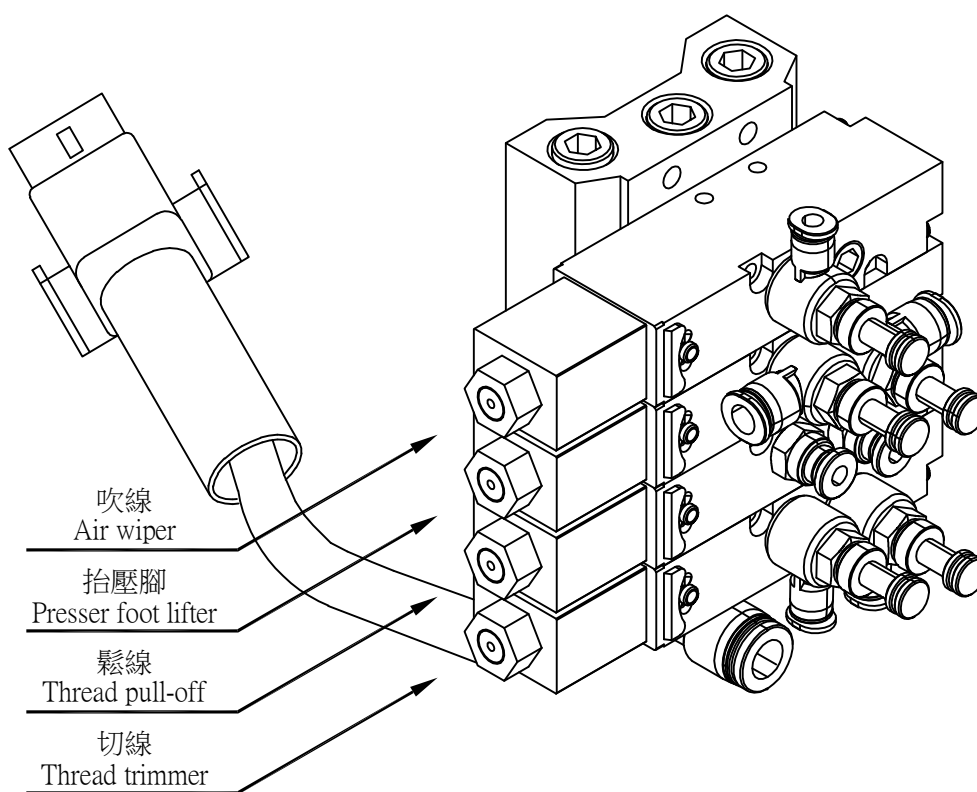
First, remove the presser foot bracket, presser foot, thread blower, outer cover, and air pipe clamp, then loosen screws A and B to take out the thread trimmer mechanism.



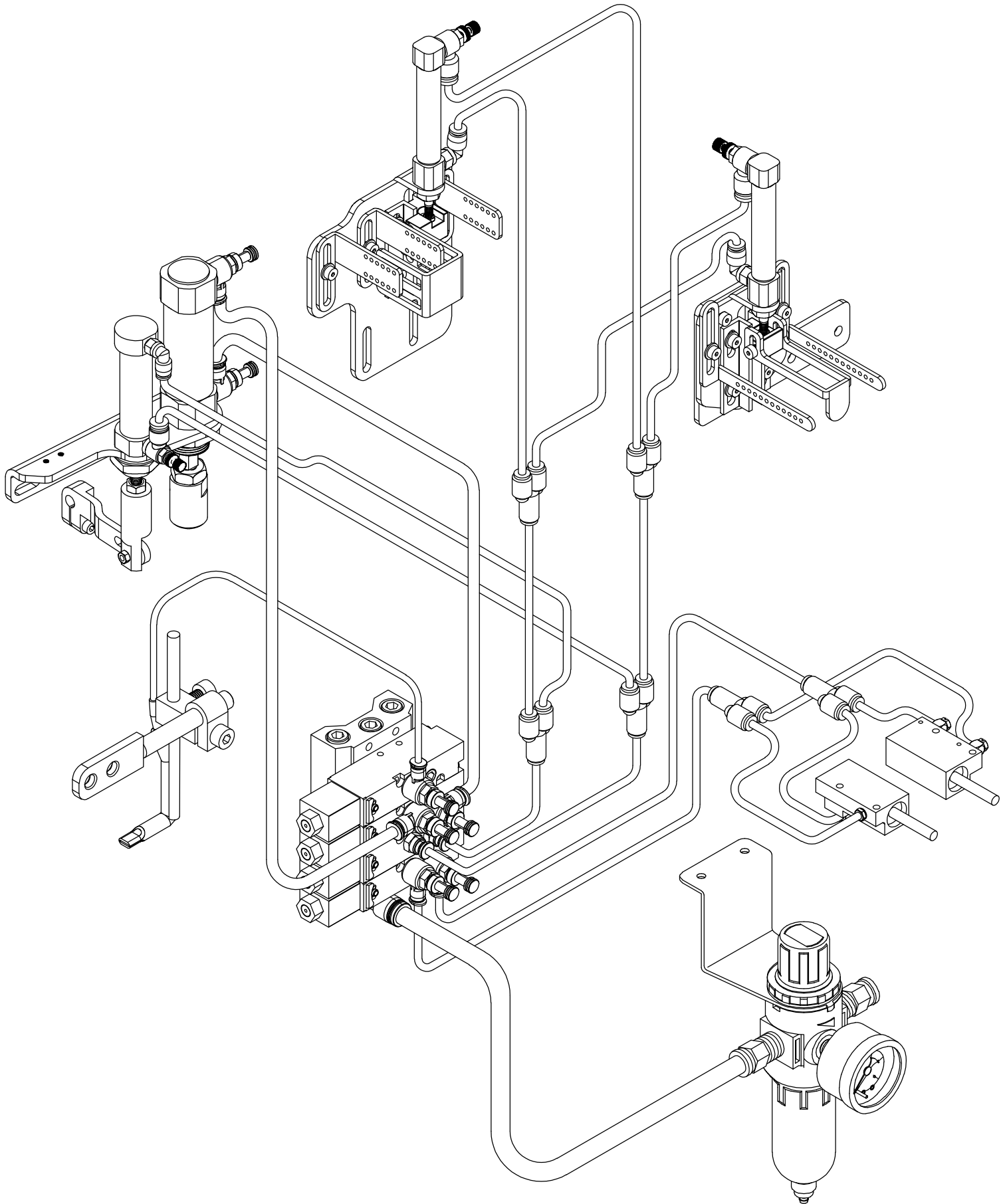
11. 換向閥配線圖 WIRING OF ELECTROMAGNETIC VALVE



SEWING MACHINE 12P	
1	TRIMMER SOL.
3	+24V
2	+24V
5	TENSION SOL.
4	WIPER SOL.
6	+24V
7	A.F.L. SOL.
9	+24V



12. 空壓組件 COMPRESSED AIR COMPONENTS



重要的安全性指示 Important safety instruction

1. 運輸 Transportation

- (1) 機器出廠時，是以上下兩塊保麗龍包裝。

The machine packed with two pieces of cover that made of expanded polystyrene.

- (2) 將機器及其保護之保麗龍放入外銷紙箱內。

Put the machine into a export carton.

- (3) 請使用推車或兩個人搬運此台機器。

Use a cart or by two men's hands to move it.

2. 儲存 Storage

- (1) 當機器沒有在使用時，請用防塵套罩住。

The machine must use dustcover to cover it when it does not work.

- (2) 請勿將機器儲存在室溫超過 45°C 的房間。

Avoid to storage the machine in the room temperature more than 45°C.

3. 工作時 Working

當室溫超過 40°C 時，機器有可能無法正常運作。

The machine doesn't work properly when temperature over 40°C.

4. 警語 Warning

煩請特別注意下列警告 Pay attention to these warning advices as follow :

- A. 工作區域是有危險性的。

Working area is dangerous.

- B. 當機器在運轉操作時，絕對不可碰觸針。

Never touch the needle when the machine is still running.

- C. 當你在操作機器送布時，請特別小心。

Be careful when you feed the fabric.

- D. 當機器在運轉操作時，請勿將手放置針和拖輪之間。

Do not insert your finger between needle and puller during sewing operation.

5. 請特別注意警告標籤 Pay attention to the warning sticker

- A. 當你在操作使用這機器時，任何活動件均需遮蓋擋住。

Movable parts must be covered with guard when you operate.

- B. 當在調整、穿線、更換梭子以及清潔機器時，請務必先關閉電源，並拔掉插頭。

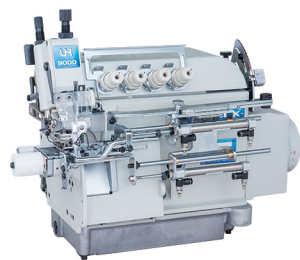
Pull out the plug from socket first when you adjusting, threading, changing bobbin or cleaning.



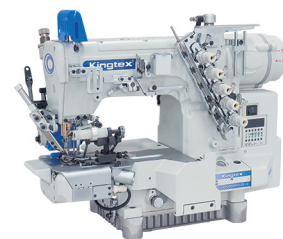
NTD7701
4-Needle, 6-Thread Flat-Seamer,
Feed-Off-The-Arm Machine



MT4512P-050 / PMD / FR01
12-Needle Double Chain Stitch Machine
(Lower Feed Metering Device \ Elastic hemmer)



UHU9304/TR025
Automatic chain cutter device direct-drive
cylinder bed top feed overlock fitted with
labor-saving rib folder



CXM2085-0-356M
Attaching Pre-Closed Flat Knit Elastic Band Onto
Waists Of Tubular Goods
(With Right Knife, Rear Puller & Chips Suction Pipe)



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CHING CHI MACHINE CO., LTD
<http://www.kingtexsewing.com.tw>

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