

Operation manual
for high speed direct drive
automatic lockstitch machine
with built-in energy saving motor

Tronic 6 NEO

 *texi*

CONTENTS

Safety precautions	1
User's manual	2
1. Before starting work	2
2. Mounting the machine	3
3. Mounting the thread stand	4
4. Lubrication of machine	4
5. Oil mass adjustment of rotating hook	4
6. Mounting the needle	5
7. Mounting the bobbin	5
8. Installation of bobbin case	6
9. Threading	6
10. Winding up the bobbin thread	7
11. Lifting of presser foot	8
12. Adjusting the stitch length and the use of back feeding lever	8
13. Hand-touch backstitch device	9
14. Operating the treadle	9
15. Adjusting the treadle	9
16. Adjusting the presser foot pressure	11
17. Adjusting the height and angle of presser foot	11
18. Adjustment of the knee lift height	11
19. Adjusting the tension of stitch thread	12
20. Adjustment of the upper thread length after trimming	12
21. Adjusting the take-up amount of take-up lever	13
22. Adjusting the take-up spring	13
23. Adjust the height of the needle bar	14
24. Adjust the synchronization of the needle and hook	14
25. Adjust the synchronization of the needle and feed	15
26. Adjustment of the height of feed dog	15
27. Adjust the lean of feed dog	16
28. Replacing the fixed knife and movable knife	16
29. Adjusting the thread-trimming device	17
30. Maintenance	18
31. Carrying and placing of the sewing machine	19
32. Ask your supplier about	20
CE Declaration of Conformity	21

SAFETY PRECAUTION

This instruction manual contains important guidelines regarding correct, safe and economical method of use of the machine. Following recommendations contained in this manual will decrease work down-time, increase machine reliability and durability, and will make work safer.

This instruction manual must always be available at the workplace. The machine can be serviced only by an employee trained in Industrial Safety, after reading this instruction manual.

The supplier is not responsible for damages caused by improper use or by usage of this product for functions other than those it has been designed for.

To minimize the risk of fire, electric shock, or injury, observe the following precautions:

- Keep the workplace clean.
- Pay attention to the machine's work environment; do not subject it to atmospheric conditions.
- Do not install the machine in rooms that are dusty, where aerosols are sprayed, or to which oxygen is supplied.
- Keep the workplace well lit.
- Be careful of danger of electric shock.
- Pay attention to clothing. Let-down hair or loose clothing can be caught by the machine's mobile elements.
- Take care not to damage the power supply cable.
- When the machine is not in use, disconnect it from the power grid.
- Take care not to turn-on the machine accidentally.
- In case of even the slightest damage, always check if the damaged part requires replacement.
- Never install on the machine attachments and accessories other than those recommended by the manufacturer and supplier.
- Do not perform machine modifications independently.
- Do not leave near the machine unattended bystanders or children.

Electric installation

Check if the supply voltage in the electric socket corresponds to the data on the machine's rating plate 1-phase voltage 230V 50Hz.

Check the correctness of electric connections in the plug and electric socket, **observing electric shock safety countermeasures.**

Do not use extension power cords.

Apply the valid electrical and Industrial Safety norms.

ATTENTION – all work related to the electrical installation must be carried out by a qualified electrician.

Before starting work

Using machine without any of the safeguarding parts (finger guard, eye guard, etc.) is dangerous to an operator.

During work, only the items necessary for sewing should be found on the machine's work table.

Before connecting the machine to the power grid, always release the pedal and the start button.

Do not use blunt or bent needles.

Do not touch any of the machine's mobile elements, such as the needle, needle bar, thread tensioner or take-up, or hook, during its operation.

Turn machine off before: replacing needle, threading, installing attachments, changing the bobbin or bobbin case.

If you notice any abnormalities in the machine's function, turn it off immediately and inform a mechanic or your superior. After finishing work, turn the machine off and remove the plug from the electric socket. In case of power grid failure, disconnect the machine from the power grid.

This machine is not a toy!

We hope that you will use this machine with pleasure for a long time.

USER'S MANUAL

The lockstitch machine TEXI Tronic 6 NEO is a high speed sewing machines, designed for sewing knitted materials or other textiles.

Attention!

The machine is not to be used for other materials than those for which it has been designed.

Non-observance of this rule places the user at risk and can cause irreversible damage to the machine.

Before use, the user should become acquainted with this instruction manual, general safety precautions and maintenance instructions.

1. Before starting work

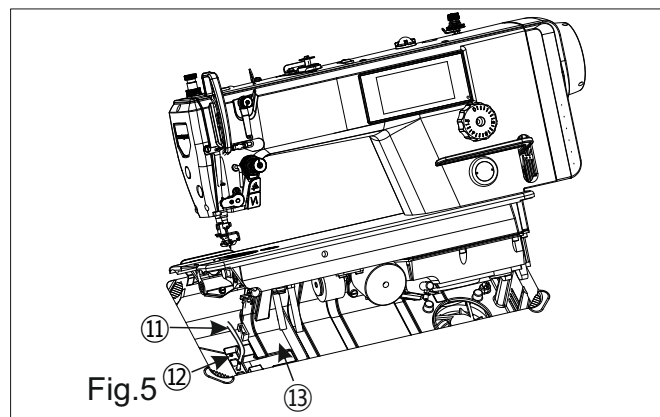
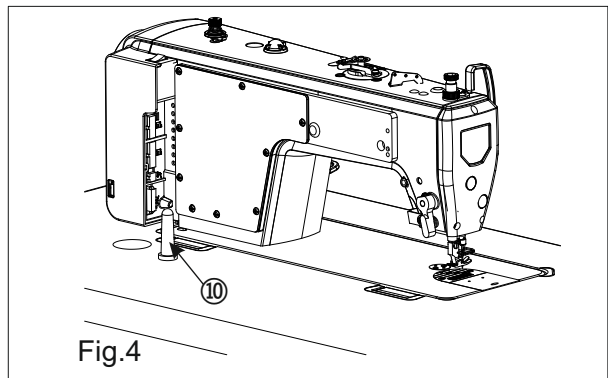
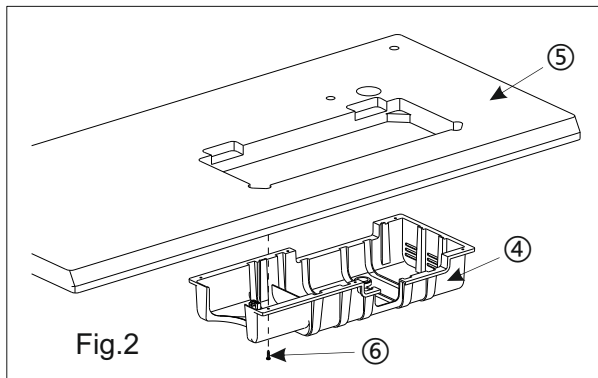
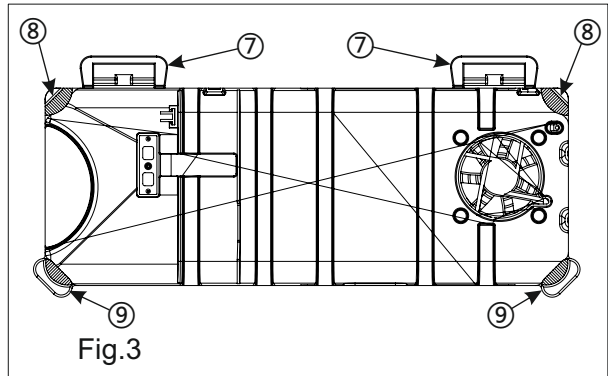
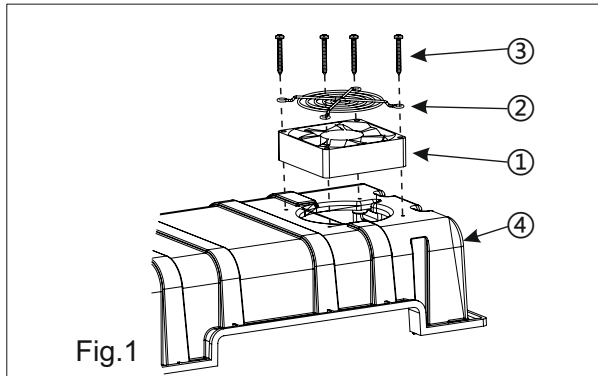
1. After turning-on the machine and during its operation, do not touch the needle or put fingers into the thread take-up guard.
2. During sewing, do not put fingers into the needle guard.
3. Turn power off before tilting the machine head or uninstalling parts.
4. Turn machine off before leaving it unattended.
5. Do not allow hair, loose clothing, fingers or any objects to be in the vicinity of the pulley during machine run.
6. Do not clean the machine with paint thinner.

Technical specifications

Model	Tronic 6 NEO
Application	Light medium materials
Power supply	AC 220 - 240V, 550W
Sewing speed (max)	5000 stitches/min
Maximum stitch length	5 mm
Presser foot raising height	5.5 mm (standard), 13 mm (max)
Needle	135x5 with tips, appropriate to the type of sewn material
Lubricating oil	Oil for lockstitch machine (recommended: SPIRIT 2)
Net weight	40 kg
Packaging dimensions	685 x 247 x 570 mm

2. Mounting the machine

- 1) As shown in the picture fix the fan ① and fan protective cover ② on the oil pan ④ by the 4 screws ③, label upwards.
- 2) Fix oil pan ④ under the machine table ⑤ with 6 fixed screws ⑥.
- 3) Fix tow head cushions ⑦ and two head support seats ⑨ in four corner of the machine table ⑤ respectively, then fix connecting head hook seat ⑧ on the machine table with 6 screws.
- 4) Insert the head connect hook in the pin hole of baseboard, align head connect hook seat, then put head in four corners of head cushion in the machine table.
- 5) As shown in the picture, insert head support ⑩ into the machine table firmly.
- 6) As shown in the picture, insert oil pipe of the baseboard ⑪ into oil return press plate ⑫ of the oil pan then fix it with oil pipe clamp ⑬.



3. Mounting the thread stand

1. As shown in the picture, mount the thread stand component onto the mounting hole for thread stand on the sewing machine table.
2. Screw down retaining nut ① for lower segment of thread stand lever to fix the thread stand.

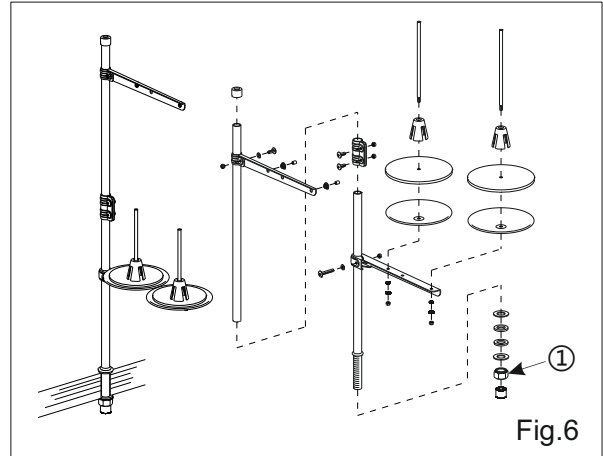


Fig.6

4. Lubrication of machine

1. Lubrication of gearbox

Fill gearbox if the oil pointer ② below the lower tick mark in the oil window ③ when using the sewing machine.

The steps of lubrication are as follows:

- 1) Remove the rubber plug ① of oil filler, fill with oil using the oil bottle in accessory box.
- 2) Fill oil until the oil pointer ② reaches the upper tick mark in the oil window ③. Do not fill too much oil otherwise the oil will flow into machine head.
- 3) Close rubber plug ① of oil filler after finishing lubrication.

Caution:

1. To prevent the unexpected startup of sewing machine, switch off power supply before the operation is conducted.
2. When using the new sewing machine for the first time, open the rubber plug ① of oil filler and fill with 200ml oil.

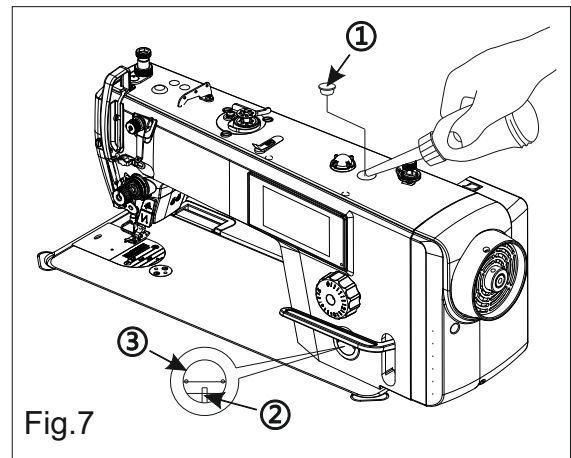


Fig.7

5. Oil mass adjustment of rotating hook

1. Adjustment method

- 1) Adjust the oil mass of rotating hook using adjusting screw ①: Screw down (turn it to the right) adjusting screw ① to raise the oil mass, or unscrew (turn it to the left) the adjusting screw to lower the oil mass. Amount repeatedly until the lubrication amount is correct.
- 2) Check the lubrication amount again after the sewing machine has been used for approximately two hours.

2. Confirming the Oil Mass

- 1) Remove the thread from all points from the thread take-up to the needle.
- 2) Use the lifting lever to lift the presser foot.
- 3) Run the machine at the normal sewing speed for approximately 3 minute without sewing any material (following the same start/stop pattern as when actually sewing).
- 4) Place the lubrication amount check sheet ② underneath the rotary hook ③ and hold it there. Then run the sewing machine at the normal sewing speed for 10 seconds. (Any type of paper can be used as the lubrication amount check sheet ②).
- 5) Check the amount of oil which has splattered onto the sheet ②.

Caution:

1. Prior to the above-mentioned operation, remove the knockout plate and check whether there is oil in the oil box.
2. Do not use fingers to touch the hook or other running components of feeding mechanism when checking the amount of oil for the hook to avoid the accident.
3. Use the following procedure to check the amount of oil being supplied to the rotary hook when replacing the rotary hook or when changing the sewing speed.

3. Guide sample of oil mass adequacy

- 1) The guide sample shown in the right-hand figure (see Fig. 10) may be finely adjusted (increased or reduced) as per different sewing processes; however, excessive increase or reduction shall be avoided. Too little oil mass may lead to rotating hook heating, and over much oil mass may lead to contamination of the sewing materials.
- 2) Test the oil mass 3 times using special oil mass confirmation paper till the oil traces indicated by the special paper show no changes.

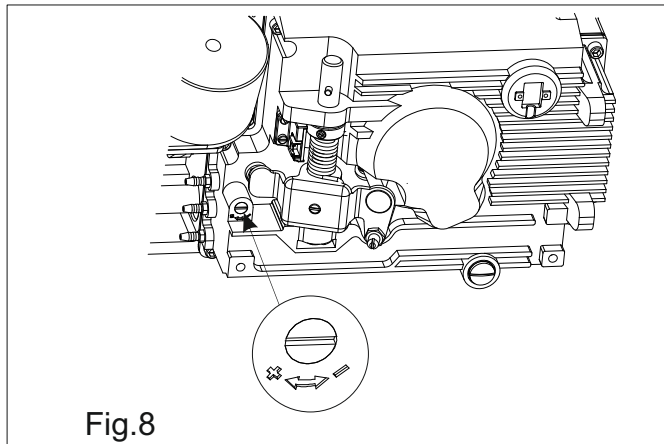


Fig.8

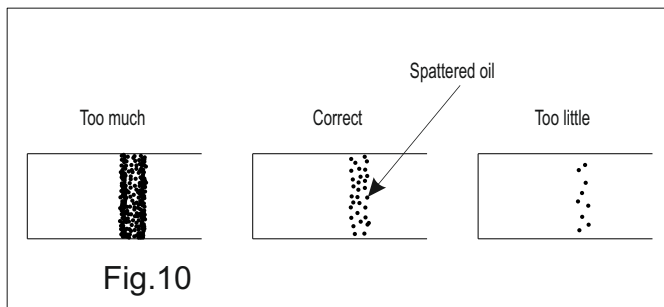


Fig.10

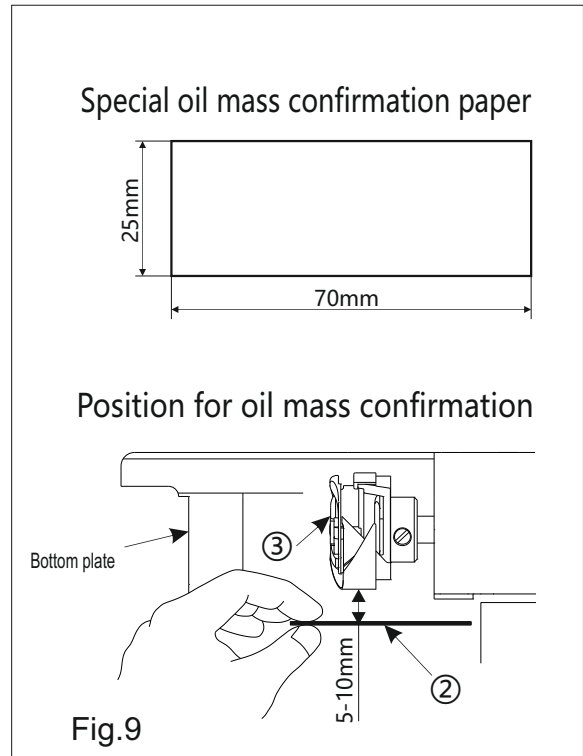


Fig.9

6. Mounting the needle

1. Turn the upper wheel to allow the needle to reach its maximum height.
2. Unscrew needle carrying screw ②, hold needle ① by hand, and align the indentation A of needle to right direction B.
3. Insert the needle into the bottom of needle hole in direction of arrow till it reaches the end point.
4. Screw down the needle carrying screw ②.
5. Take care to ensure that the elongated slot C on the needle is aligned to the left direction D.

Caution:

1. To prevent the unexpected startup of sewing machine, switch off power supply before the operation is conducted.
2. Needles are available in different sizes. Please select appropriate needle as per the thickness of threads and the sewing materials.

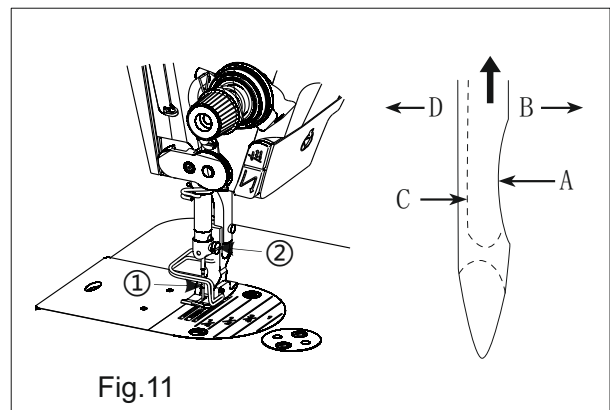


Fig.11

7. Mounting the bobbin

1. Hold the rotating hook by hand, and fit the bobbin into the rotating hook.
2. Thread the thread through the thread groove A in the rotating hook, and draw out the thread in direction C. In this way, the thread is led out of hole B through the tension spring.
3. When bobbin thread is drawn, the bobbin shall turn clockwise in direction of arrow.

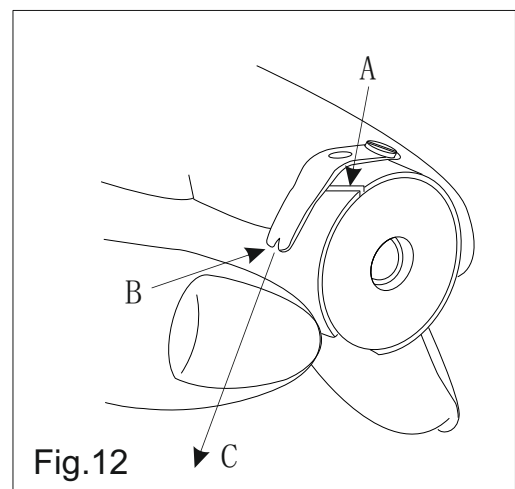


Fig.12

8. Installing bobbin case

1. Turn the machine pulley to raise the needle until it is above the needle plate.
2. Hold the bobbin case ① (with bobbin) with one hand, then install the bobbin case into the hook.

Caution:

Switch off machine before installing the bobbin case.



Fig.13

9. Threading

Thread the needle thread when needle bar stays in its highest position, lead out the thread end from the thread stand, and conduct threading as per the serial numbers indicated in the figure.

The threading in the Fig.14 is suitable for thin material sewing sewn thread: thin cotton thread.

The threading in the Fig.15 is suitable for heavy material sewing sewn thread: coarse cotton thread.

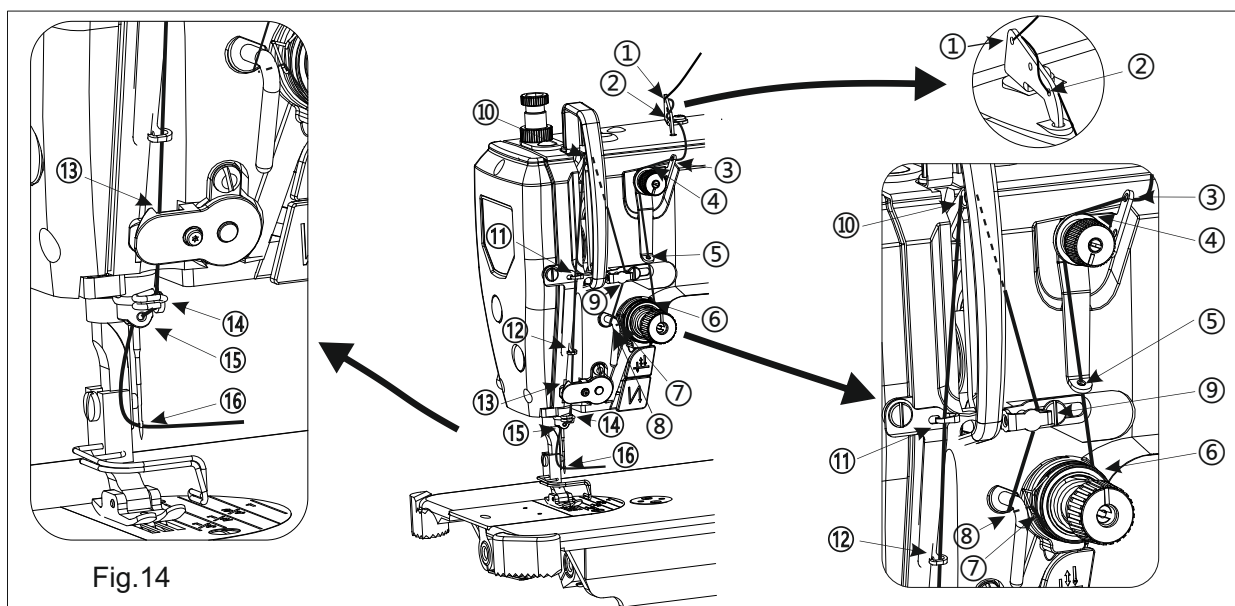


Fig.14

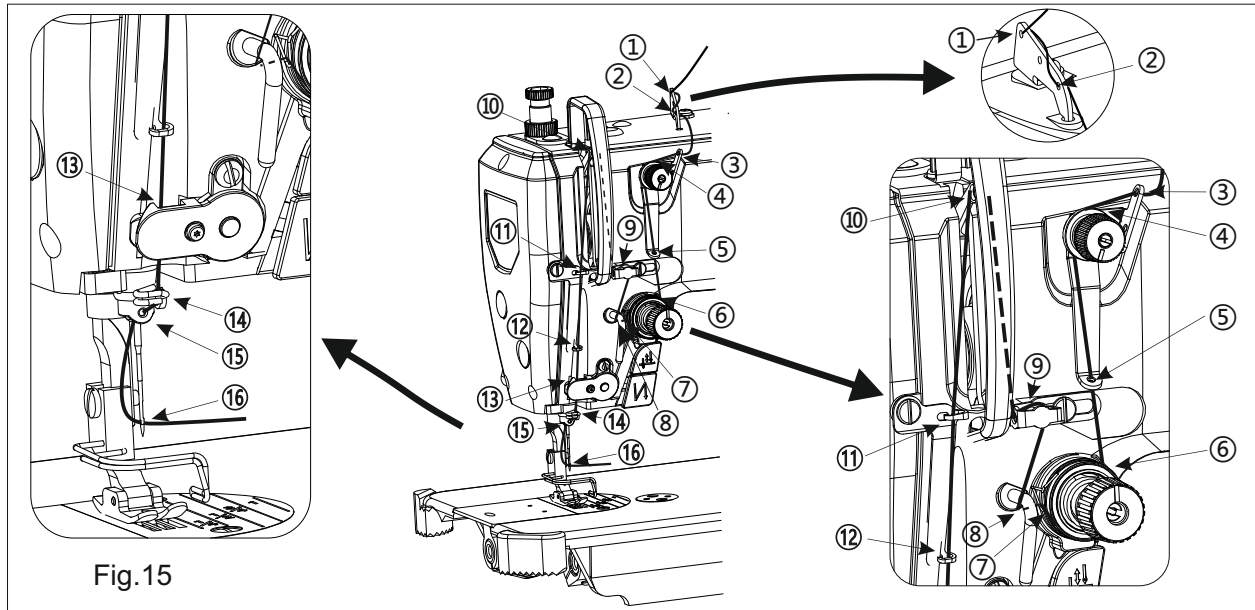


Fig.15

10. Winding up the bobbin thread

1. Bobbin thread winding-up method

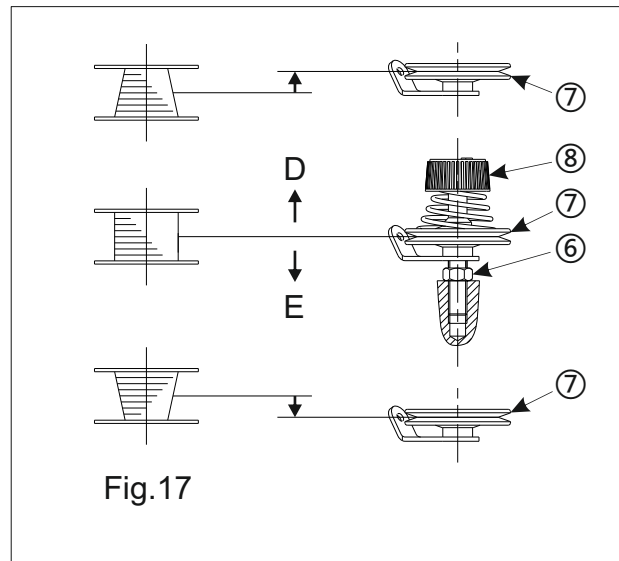
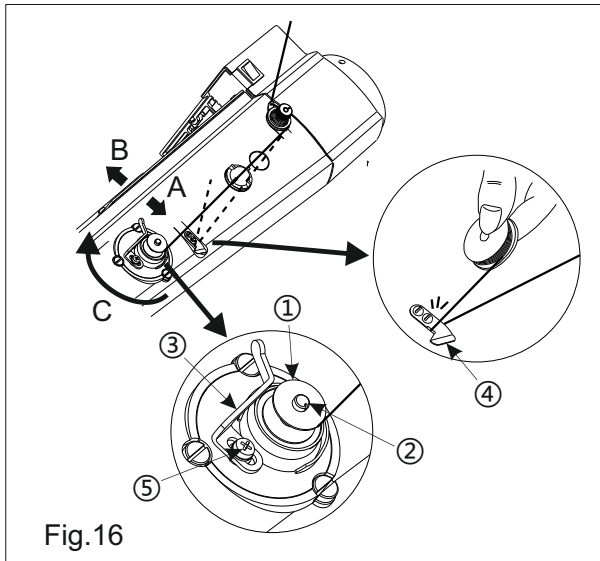
- 1) Fit bobbin ① onto spool ②.
- 2) Thread the right-hand thread coiling on thread stand as shown in right-hand figure, and reel the thread end rightwards onto the bobbin for several turns.
- 3) Push winding lever ③ over to direction A, and run the sewing machine. Bobbin ① is rotated in direction C, and thread is reeled onto bobbin ①. Once the reel is full, winding lever ③ is pushed toward direction B, and wind.
- 4) Remove bobbin ①, and trim off the thread using winding trimmer ④.

Caution:

1. To reel bobbin thread onto bobbin ① when no sewing is performed, draw the needle thread out of hole in the take-up lever, remove bobbin ① out of rotating hook.
2. Do not touch or lean anything to any running components when rolling the bottom line, in order to avoid the safety accident.

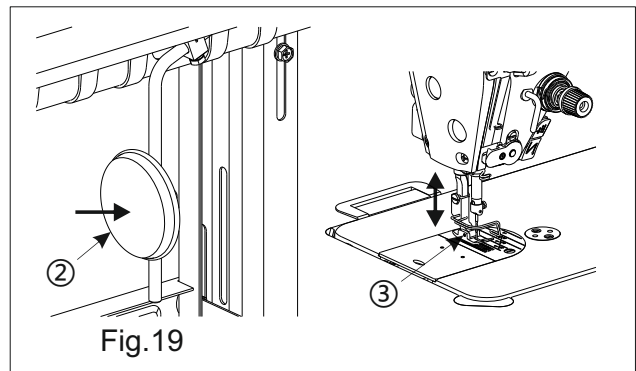
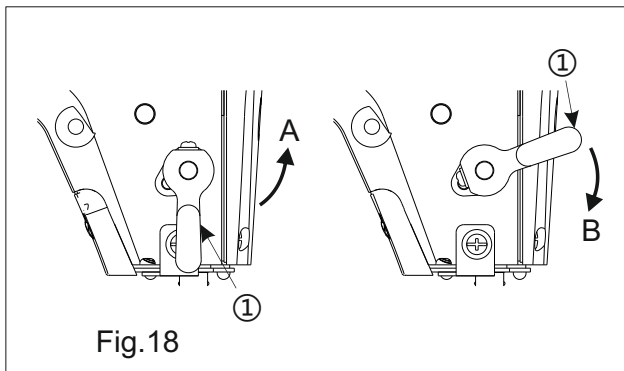
2. Adjusting the bobbin thread winding

- 1) To adjust the winding capacity of bobbin thread, unscrew fixing screw ⑤, set winding lever ③ in direction A or direction B, and fix screw ⑤ again. Direction A is intended for reduction, and direction B is intended for increase (Caution: The amount of thread wound onto the bobbin should be a maximum of 80% of the bobbin capacity).
- 2) If thread cannot be wound onto the bobbin flatly, unscrew nut ⑥, turn the winding tension disco, and adjust the height of thread gripper plate ⑦.
 - a. The standard position is reached once the center heights of rotating hook ① and thread gripper plate ⑦ are identical.
 - b. If the winding amount on the lower part is bigger, move the winding tension disco in direction D indicated in the right-hand figure. If the winding amount on upper part is bigger, move the winding tension disco in direction E indicated in the right-hand figure.
 - c. When the winding tension disco reaches its suitable position, screw down fixing screw ⑥.
- 3) Adjust the winding tension of bobbin thread by turning thread tension nut ⑧.



11. Lifting of presser foot

1. Lift presser foot controlled by hands
 - 1) Shut down the machine, turn presser foot lever ① in direction A to uplift the presser foot (for about 5.5 mm).
 - 2) When presser foot lever ① is turned in direction B, presser foot will be returned to its original position.
2. Lift presser foot controlled by knees
 - 1) The presser foot ③ can be raised by pressing the knee lifter plate ②. (Height of presser lifting is relate to the degree of knees pressing)
Caution: standard and maximal lifting height of presser foot are respectively about 10mm and 13mm when pressing knees fully.
 - 2) The lifting presser foot ③ lowers as soon as loosing the knee lifter plate ② release.



12. Adjusting the stitch length and the use of back feeding lever

Adjusting stitch length:

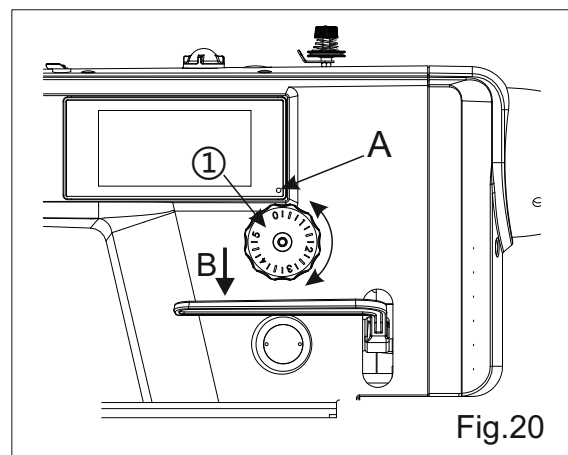
Press needle gauge knob ① and rotate it according to arrows, do not release it until the number you require aim at A direction right above machine head. Loose needle gauge knob ①.

Caution:

1. Scale mark digits are expressed on the knob in millimeters.
2. Press the reverse feeding wrench ② towards B direction and rotate needle gauge knob ① when changing the scale of it from largest to smallest.

The use of back feeding lever

1. Press the reverse feeding wrench ① towards B direction.
2. Press towards B direction can realize back feeding.
3. Recover to forth feeding when release hands.



13. Hand-touch backstitch device

1. Use of back sewing push- button
 - 1) Push the backstitch switching push-button ① to allow the sewing machine to start backstitch immediately.
 - 2) Backstitch is implemented only while the push-button is held down.
 - 3) It is changed to forward stitch once the push-button is released.
2. Use of reinforce sewing
Press the reinforce sewing button ② one time, the sewing machine reinforce forth with half stitch, press all the time, it continues sewing with forth reinforce.

Caution:

In addition to continue back reinforce sewing, the reinforce sewing button can be as stop button ② during any sewing condition. (before trimming)

3. Use of the light push- button
The illuminating lamp goes on at full brightness once the machine is powered on. Push illuminating lamp control button ③ to reduce in sequence the brightness till turn off.

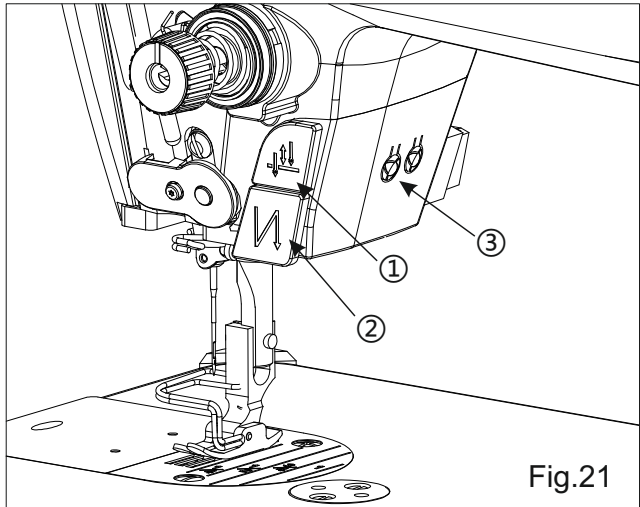


Fig.21

14. Operating the treadle

1. The treadle has 4 operation levels:
 - 1) The machine runs at low sewing speed when you lightly depress the front part of the pedal. (as shown in the picture B)
 - 2) The machine runs at high sewing speed when you further depress the front part of the pedal. (as shown in the picture A)
 - 3) Pedal back to the initial position when stop stepping on it and the machine stop working. (needle in the upper or down position, as shown in the picture C)
 - 4) The machine trims threads when you fully depress the back part of the pedal. (as shown in the picture A)
 - 5) When the auto-lifer is used, one more operating switch is provided between the sewing machine stop switch and thread trimming switch. The presser foot goes up when you lightly depress the back part of the pedal (D), and if you further depress the back part, the thread trimmer is actuated.

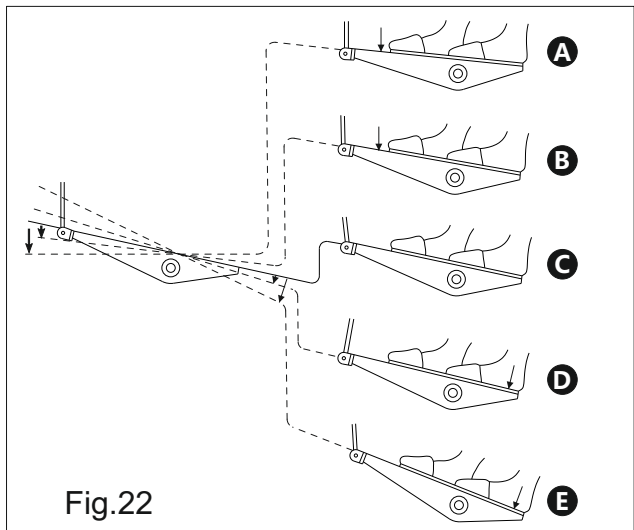


Fig.22

15. Adjusting the treadle

Caution:

To prevent the unexpected startup of sewing machine, switch off the power supply before the operation is conducted.

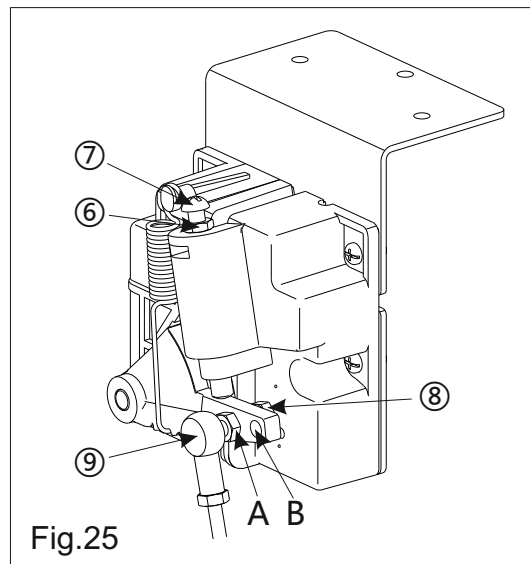
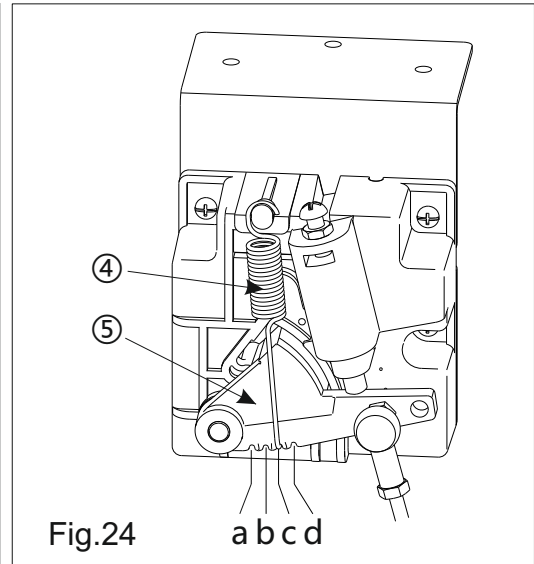
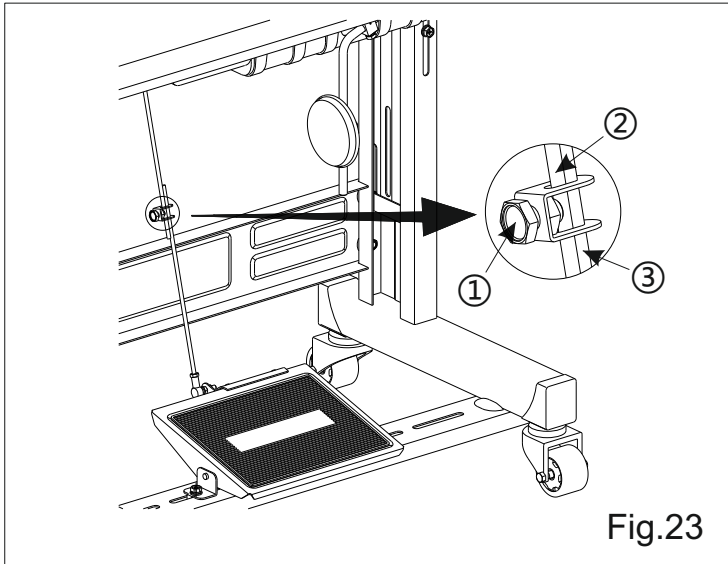
1. Adjusting the angle of treadle
 - 1) Adjust the angle of treadle only by adjusting the length of treadle connecting rod: unscrew screw ①, and adjust the length of treadle connecting rod by moving upward/downward the upper connecting rod ② and lower connecting rod ③.
 - 2) Screw down screw ① when adjustment is over.
2. Adjustment of the strength of pedal
The sewing machine run at a low speed when step forth on the pedal slightly. If the strength is insufficient, hang the stepping adjustment spring ④ on the panel spiral arm driving lever ⑤ in order to adjust strength. (a is the minimum stepping strength, b, c, d increase gradually)
3. Adjustment of stepping return strength
 - 1) Loosening nut ⑥ and turn bolt ⑦ to adjust stepping return strength: tighten bolt ⑦, the strength increases; loosen bolt ⑦, the strength decreases.
 - 2) Tighten nut ⑥ after adjusting stepping return strength.

4. Adjustment of panel moving distance

- 1) Remove nut ⑧.
- 2) Move connecting rod joint ⑨ from A to B, panel moving distance is 1.3times than original one. Move reversely the distance is 0.8 times as original one.
- 3) Assembly the nut ⑧ after adjusting panel moving distance.

Caution:

Stepping strength and stepping return strength both change after adjusting panel movement, follow the steps above to have adjustments again.

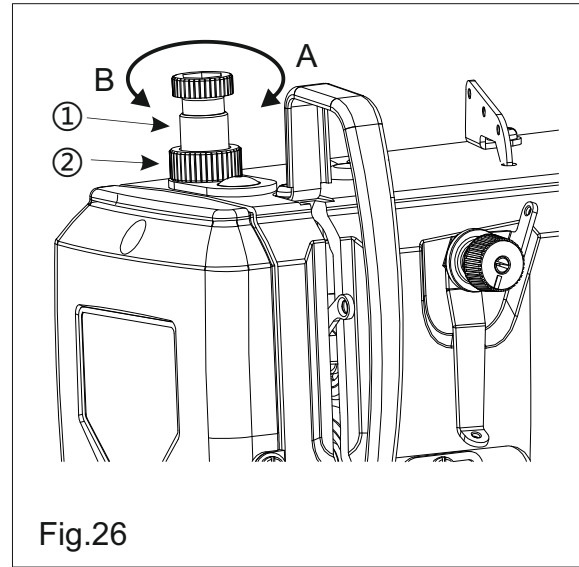


16. Adjusting the presser foot pressure

1. Unscrew pressure adjusting nut ②.
2. Presser foot pressure is increased if pressure adjusting screw ① is turned clockwise (namely in direction A); the pressure is reduced if the screw is turned counterclockwise (namely in direction B).
3. Screw down pressure adjusting nut ② when adjustment is over.

Caution:

1. To prevent the unexpected startup of sewing machine, switch off the power supply before the operation is conducted.
2. For ordinary materials, the standard height of pressure adjusting screw ① ranges from 32 to 34mm (4.5 kilogram force) approximately.

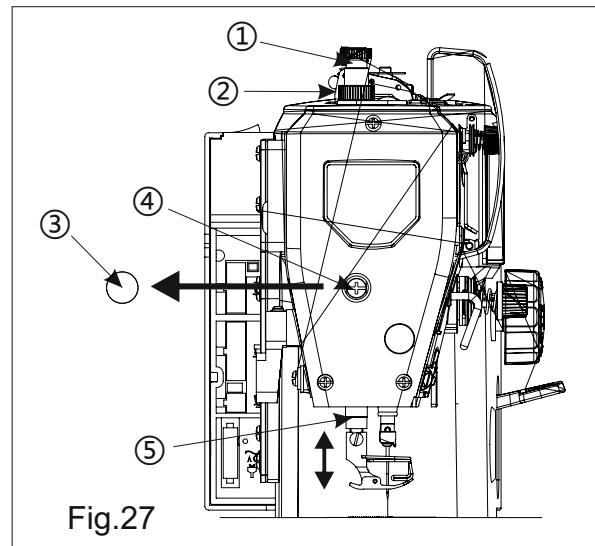


17. Adjusting the height and angle of presser foot

1. Loosen pressure adjusting nut ② and screw ①, free the pressure of presser foot.
2. Open rubber plug ③ in panel.
3. Loosen screw ④ in compression rod guide frame, move mobile compression rod ⑤ from up and down to adjust the height and angle of presser foot. (height of presser foot is the distance from needle plate surface to the bottom of it, the standard height of lifting presser foot by hand is 5.5mm)
4. Tighten the screw ④ in compression rod guide frame and assembly the rubber plug ③ after adjusting.
5. Adjust pressure of presser foot through pressure adjusting screw ①, tighten the nut ② after adjusting.

Caution:

1. To prevent the unexpected startup of sewing machine, switch off the power supply before the operation is conducted.
2. After adjusting, check that the needle moves down into the center of the groove in the presser foot.

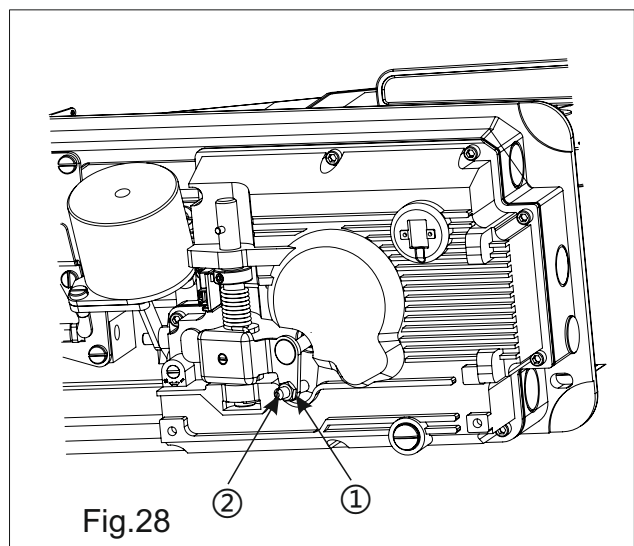


18. Adjustment of the knee lift height

1. Turn the machine pulley so that the feed dog is below the top of the needle plate.
2. Lower the presser foot by using the lifting lever.
3. Unscrew the nut ① and rotating the screw ② are the purpose to adjust the height of presser foot when the knee totally pushed to the touch point (by knee, the standard height: 10mm, the maximum height :13mm)
4. Securely tighten the nut ①.

Caution:

To prevent the unexpected startup of sewing machine, switch off the power supply before the operation is conducted.



19. Adjusting the tension of stitch thread

1. Adjusting the tension of bobbin thread.

Hold the end of a thread which hanging from the bobbin case and use the adjusting rotating screw ① to regulate. The tension of the bottom thread is become strong by tight the screw ①, loose the screw to make it weak.

The standard adjustment of the bottom thread tension: Rotating the adjusting screw ① till the bobbin case can falling slowly by it's own weight.

Caution:

To prevent the unexpected startup of sewing machine, switch off the power supply before the operation is conducted.

2. Adjusting the tension of needle thread

After the lower thread tension has been adjusted, adjust the upper thread tension so that a good, even stitch is obtained.

1) Lower the presser foot by using the lifting lever.

2) Adjust by turning the tension nut ② : The tension of the upper thread will become strong when turning toward the clockwise(A), otherwise weak when toward anti-clockwise (B).

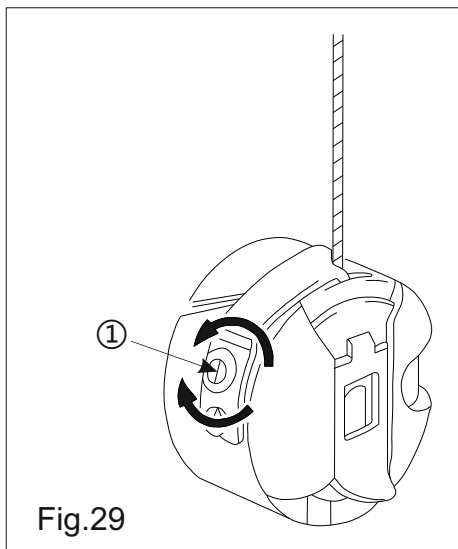


Fig.29

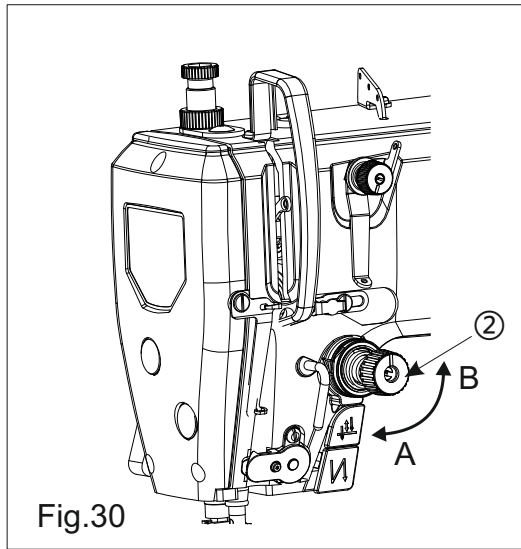


Fig.30

20. Adjustment of the upper thread length after trimming

At the time of thread trimming, the thread tension is loosened and tension is applied by the thread clamp ① only. If added the tension in the thread clamp ①, the upper thread length that left in the pinhole will be shorter, and vice versa.

The length of upper thread which left in the pinhole will decrease when turning the adjusting nut ② in the thread clamp ① towards the clockwise (A), otherwise it will increase when turn toward anti-clockwise (B).

The standard length of the upper thread which left in the pinhole is 25~30mm.

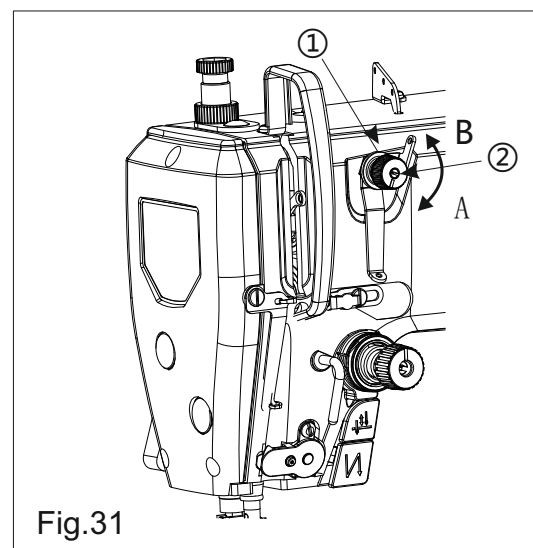


Fig.31

21. Adjusting the take-up amount of take-up lever

1. Unscrewing the screw ①.
2. Move the right thread hook ② to adjust: the thread amount of thread take-up lever will increase if turned it towards left (A direction), while turning it to the right (direction B) and the thread amount of thread take-up lever will decrease accordingly. (The standard position is obtained when graduation line C on right thread hook is aligned to screw center.)
3. Remember to tight the screw ① after adjustment.

Caution:

1. To prevent the unexpected startup of sewing machine, switch off the power supply before the operation is conducted.
2. For heavy duty , move the right thread hook ② to left to add amount of thread.
3. For light material , move the right thread hook ② to right to reduce amount of the thread.

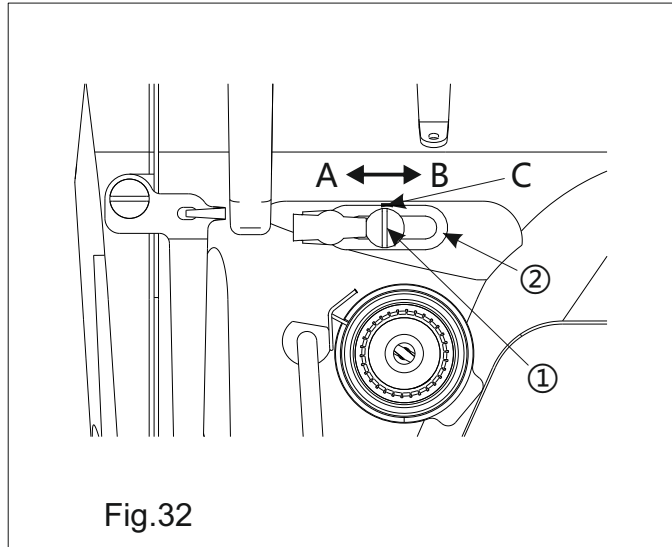


Fig.32

22. Adjusting the take-up spring

1. Adjusting the tension of take-up spring
 - 1) Unscrew screw ②, and take out thread clamp ⑤(assembly).
 - 2) Unscrew screw ④ in thread clamp ⑤.
 - 3) Rotating the screw ③ in the thread clamp ⑤ to adjust, The tension of the thread take-up spring will become larger when turning toward the clockwise(A), otherwise smaller when towards anti-clockwise (B).
 - 4) Screw down screw ④ when adjustment is over, fit thread clamp ⑤(assembly) into the machine, and screw down screw ②.

Judgment basis for adjustment adequacy of take-up spring: Confirm that the tension of take-up spring is properly adjusted, draw out the needle thread in direction B. If place B of needle thread is drawn before take-up spring reaches its lowest position, reduce the tension of take-up spring.

2. Adjustment of the Stroke to the Thread take-up Spring
 - 1) Lower the presser foot by using the lifting lever.
 - 2) Loosen the set screw ②.
 - 3) Rotating the screw ③ in the clamp to adjust, the stroke to the Thread take-up Spring ① will increase when turning toward the clockwise(A), otherwise decrease when toward anti-clockwise (B). (The standard stroke, under the state of presser foot was put down is around 6~7mm higher than the slow hook)
 - 4) Securely tighten the screw ②

Caution:

1. To prevent the unexpected startup of sewing machine, switch off the power supply before the operation is conducted.
2. The take-up spring is already adjusted properly before the machine leaves the factory as a rule, and it requires readjustment only for sewing of special materials or usage of special stitch threads.

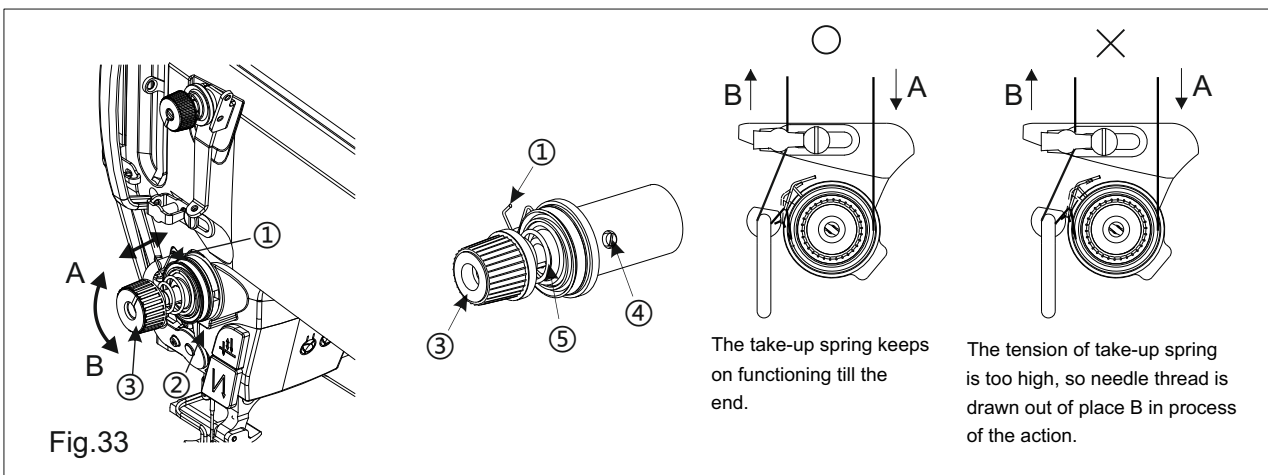


Fig.33

23. Adjust the height of the needle bar

1. Turn the machine pulley to set the needle bar ① to its lowest position.
2. Remove the rubber cap ② from the face plate.
3. Unscrewing the connecting screw ③ of needle bar, through moving the needle bar ① up and down to adjust, when using needle DBX1 and DPX5, the mark A on the needle bar ① should be match to the bottom of needle bar lower bushing; When using DAX1, the mark C on needle bar ① should match to the bottom of needle bar lower bushing.
4. Tighten the screw ③ in compression rod guide frame and assembly the rubber plug ② after adjusting.

Caution:

To prevent the unexpected startup of sewing machine, switch off the power supply before the operation is conducted.

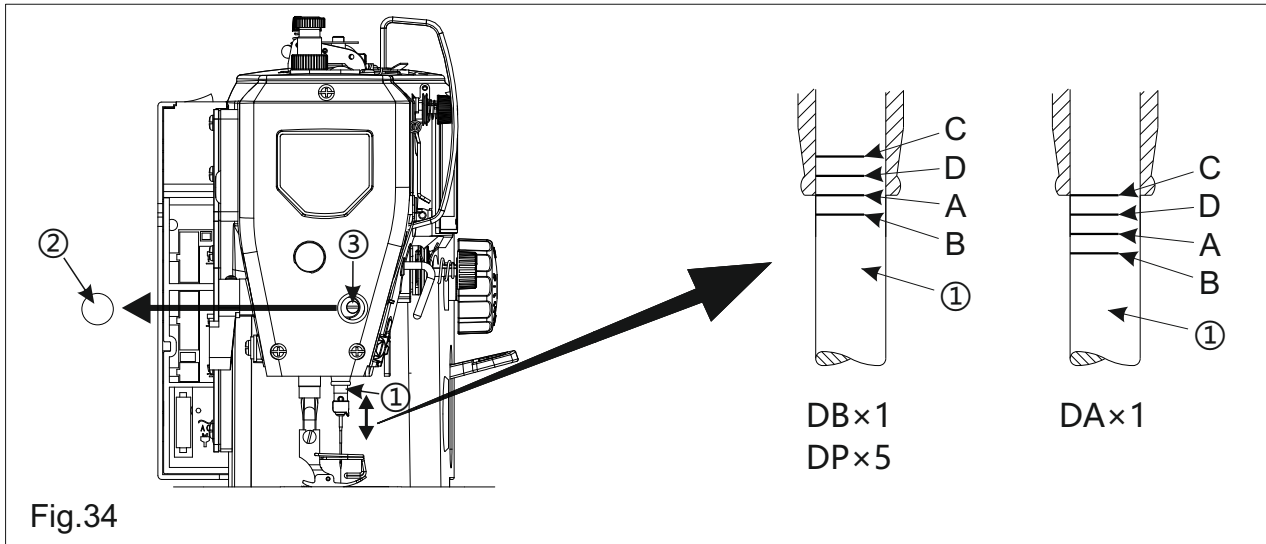


Fig.34

24. Adjust the synchronization of the needle and hook

1. Unscrewing the two positioning screw ① of hook.
2. Rotating the hand wheel to make needle bar ② lift from the lowest place, when using needle DBX1 and DPX5, the mark B on needle bar ② should match to the bottom of lower needle bar ② bushing, when using needle DAX1, the mark D on needle bar ② should match to the bottom of lower needle bar ② bushing.
3. Moving the hook to match the hook point ③ with center of needle ④. Meantime, make the space between the hook point ③ and needle ④ 0~0.05mm.
4. Tightening two positioning screw ① of hook.

Caution:

1. To prevent the unexpected startup of sewing machine, switch off the power supply before the operation is conducted.
2. If the clearance between notch on needle and thread hooking tip of rotating hook is too small, rotating hook tip may be worn; if the clearance is excessive, skipped stitch may take place.
3. It may lead to needle breakage if over-rotating the eccentric wheel towards A direction.

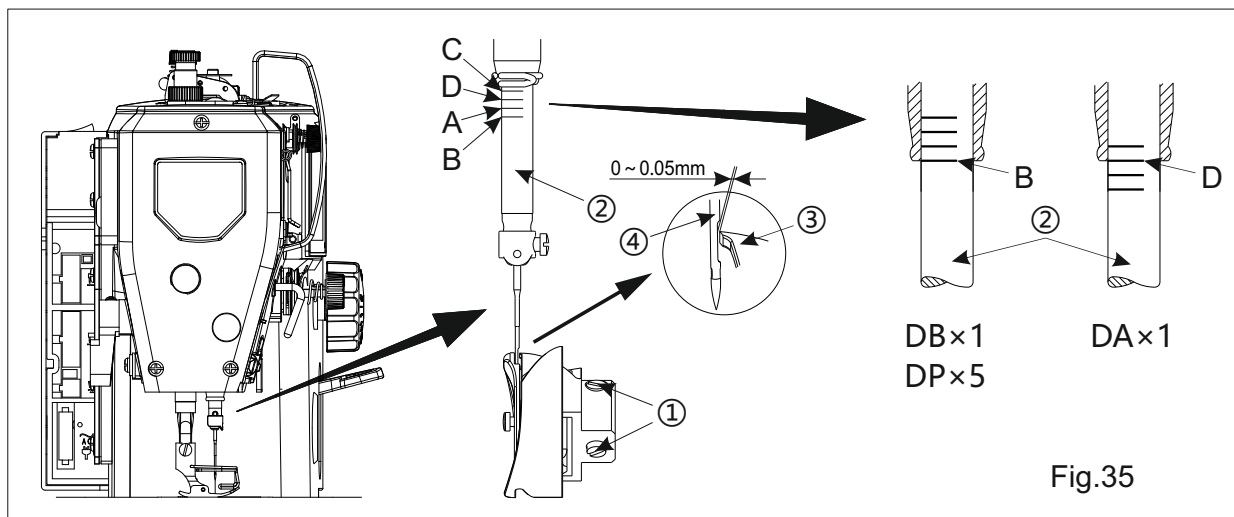


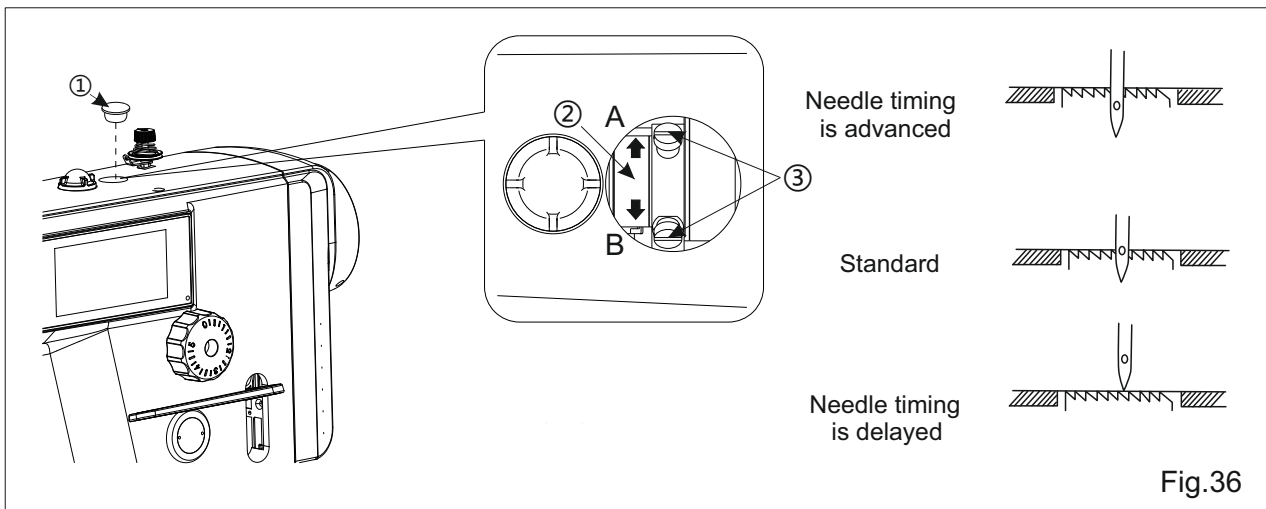
Fig.35

25. Adjust the synchronization of the needle and feed

1. Remove the rubber plug ①.
2. Loosen the two set screws ③ of the feed eccentric cam ②, and then turn the feed eccentric cam ② slightly to adjust the timing : If make the needle sooner than material feeding, rotate toward A direction. If make the needle later than material feeding, rotate toward B direction. (The standard of adjustment is when the feed dog falling from the highest to the surface of needle plate, the top of the needle and needle plate should at the same level).
3. Tightening two positioning screw ③ and assembly the rubber plug ① after adjusting.

Caution:

1. To prevent the unexpected startup of sewing machine, switch off the power supply before the operation is conducted.
2. If the feed lifting eccentric cam ② is turned too far in the direction A, it may cause the needle to break.
3. To prevent material slippage from occurring, delay the needle timing.
4. To improve thread tightening, advance the needle timing.

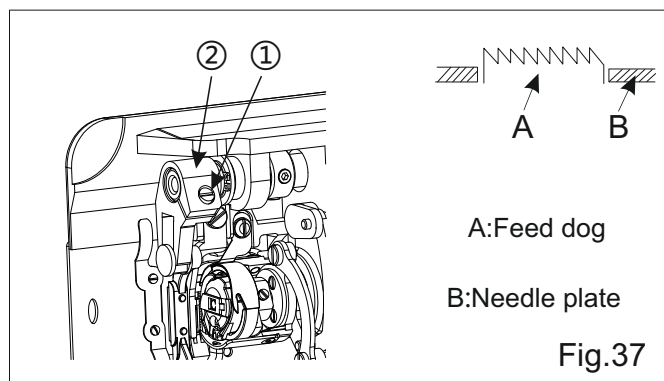


26. Adjustment of the height of feed dog

1. Turn the pulley until the feed dog rises to the highest position.
2. Turn over the sewing machine head on the supporting bar.
3. Unscrewing the tightened screw ① in the feed lifting crank ②.
4. Rotating the feed lifting crank ② to make adjustment: the feed dog will be higher when the feed lifting crank ② is turn towards A direction; turn towards B direction the feed dog will be lower.
When the feed dog in the highest position, the standard height of the type of medium-heavy machine is 0.8~1.0mm and standard height of the heavy duty machine is 1.1~1.3mm).
5. Remember to tighten the tightening screw ① in the feed lifting crank ② after adjusting.

Caution:

To prevent the unexpected startup of sewing machine, switch off the power supply before the operation is conducted.



27. Adjust the lean of feed dog

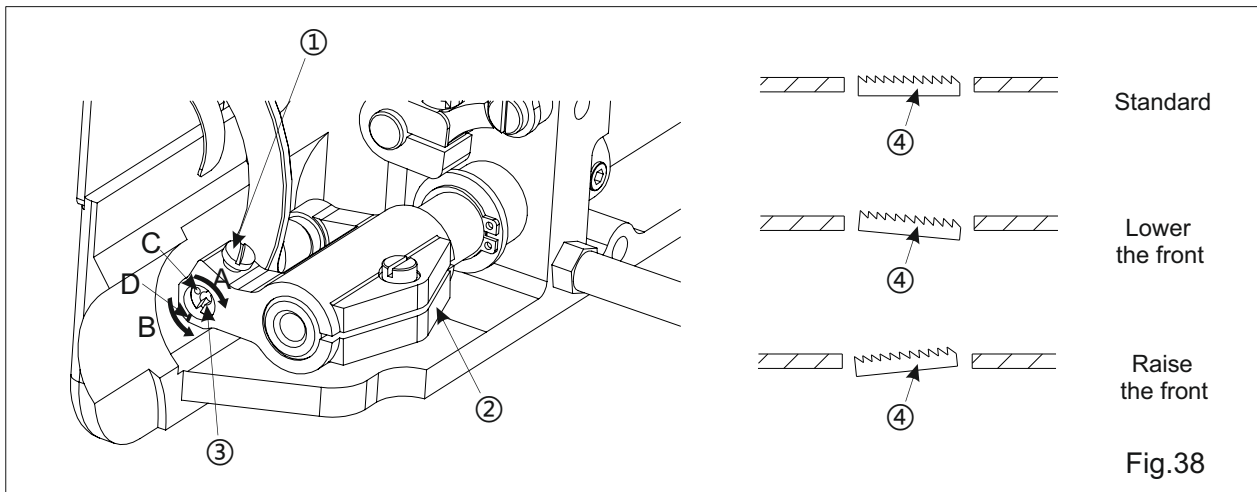
1. Turn the pulley until the feed dog ④ rises to the highest position.
2. Turn over the sewing machine head on the supporting bar.
3. Unscrewing the tightening screw ① in the teeth pedestal ②.
4. Adjust the eccentric pin ③ by screw driver:

Fall front site of tooth feed when moving the eccentric pin ③ towards A, and raising it when move towards B. (When raising the tooth feed to the highest position, The standard lean position of feed dog is that mark C on eccentric pin ③ should be at the same level D with mark on the teeth pedestal ② and the feed dog should be parallel with needle plate.)

5. Remember to tighten the tightening screw ① in the teeth pedestal ② after adjusting.

Caution:

1. To prevent the unexpected startup of sewing machine, switch off the power supply before the operation is conducted.
2. In order to prevent puckering, lower the front of the feed dog.
3. In order to prevent the material from slipping, raise the front of the feed dog.
4. The height of the feed dog will change after the angle has been adjusted, so it will be necessary to re-adjust the height of the feed dog.



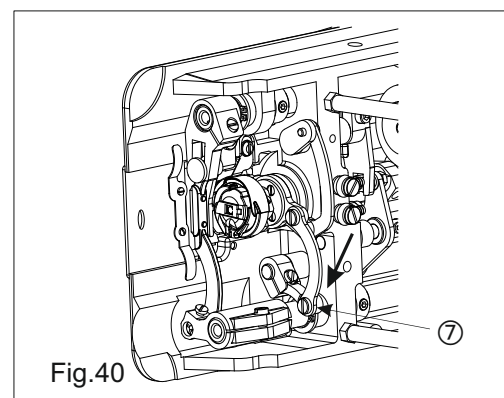
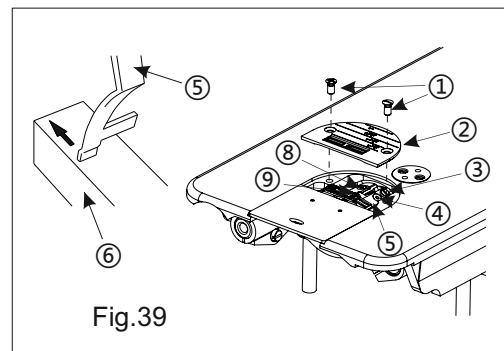
28. Replacing the counter knife and moving knife

1. Removing the counter knife and moving knife.
 - 1) Turn the wheel and stop the needle bar in its highest position.
 - 2) Take down the needle.
 - 3) Loosen the screw ① and put down the needle plate ②.
 - 4) Drive the trimming crank ⑦ as illustrated by the arrows, and stop to position when screw ③, ④, ⑧ is unfolded.
 - 5) Take down the screw ③, ④ and counter knife ⑤.
 - 6) Take down the screw ⑧ and counter knife ⑨.

Caution:

1. To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.
2. Carry out the above steps in reverse to install the fixed knife.
3. Grinding the stationary trimmer

If the cutting performance deteriorates, sharpen the counter knife ⑤ on a grinding stone ⑥ as shown in the illustration.



29. Adjusting the Thread-trimming Device

1. Adjusting the position of thread-trimming cam

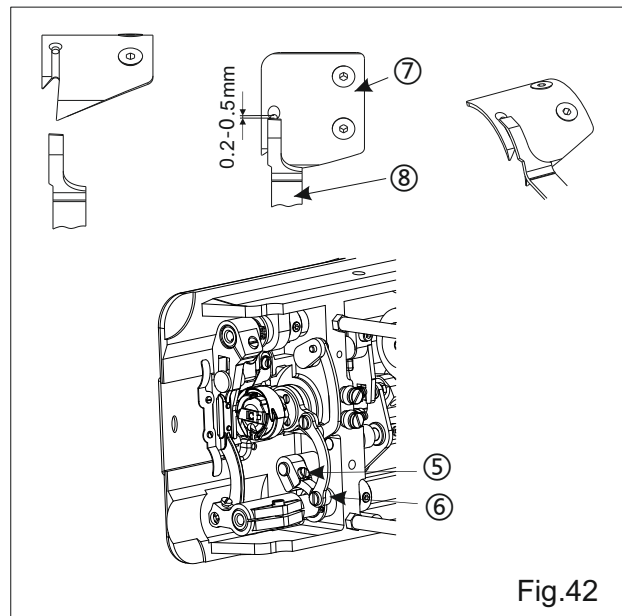
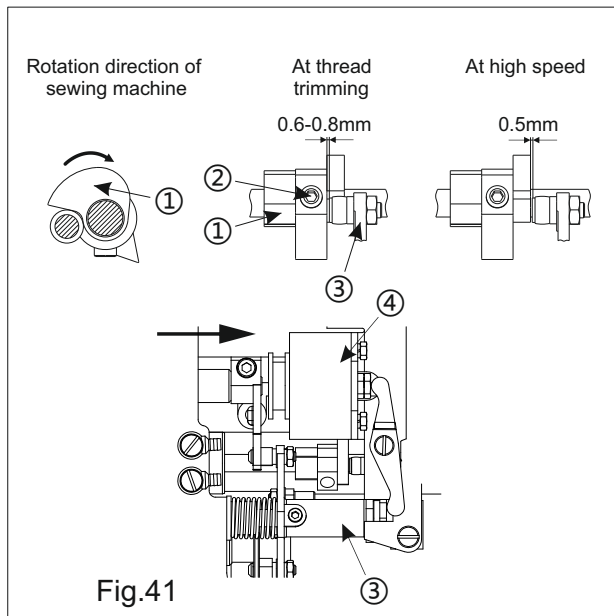
- 1) Rotating the hand wheel to raise the needle bar 5mm from the lowest place.
- 2) To press the core in trimming electromagnet ④ with your hands by arrow direction, allowing the ball of the trimming cam crank ③ press into the cavity in trimming cam ①. And the place of trimming cam ① remains the gap which between the end face of trimming cam ① and the left side on the ball is 0.6~0.8mm.
- 3) With the 25kgf.cm force to tighten the two screws ② from trimming cam.
- 4) When the trimming cam crank ③ back to its original place, please confirm that the gap between the right side on the trimming cam ① and the left side on the ball of the trimming cam crank ③ is 0.5mm.

2. Adjusting the positions of movable trimmer and stationary trimmer:

Hold down electromagnet core so that the balls in slide block assembly ③ is pressed into the recess on thread trimming cam ①. Turn the upper wheel, and the front end stationary trimmer ⑧ and cutting edge of movable trimmer ⑦ shall be engaged for 0.2~0.5mm when thread-trimming driving crank lever ⑥ drives movable trimmer ⑦ to perform thread-trimming action. If no engagement is achieved, unscrew screw ⑤ and move thread-trimming driving crank lever ⑥ to engage the front end stationary trimmer ⑧ and cutting edge of movable trimmer ⑦. The adjusted positions of movable trimmer ⑦ and stationary trimmer ⑧ must ensure that cotton thread 203 can be snipped when manual thread-trimming is conducted.

Caution:

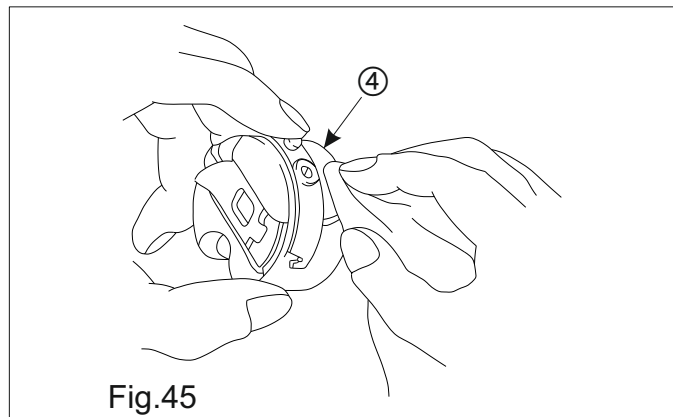
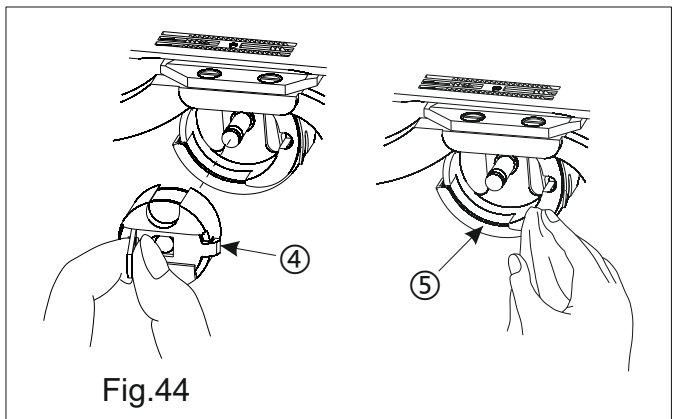
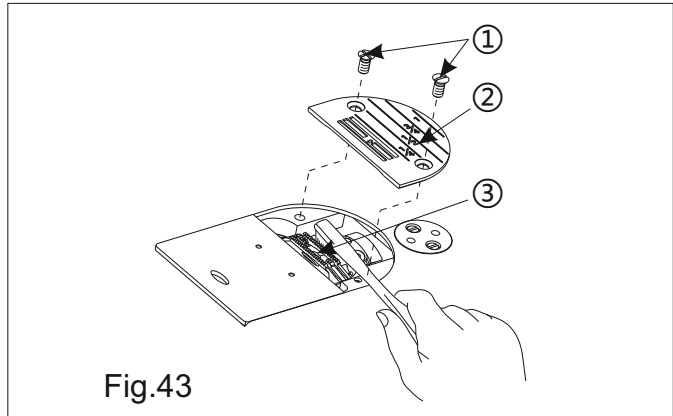
To prevent the unexpected startup of sewing machine, switch off the power supply before the operation is conducted.



30. Maintenance

The following cleaning operations should be carried out each day in order to maintain the performance of this machine and to ensure a long service life.

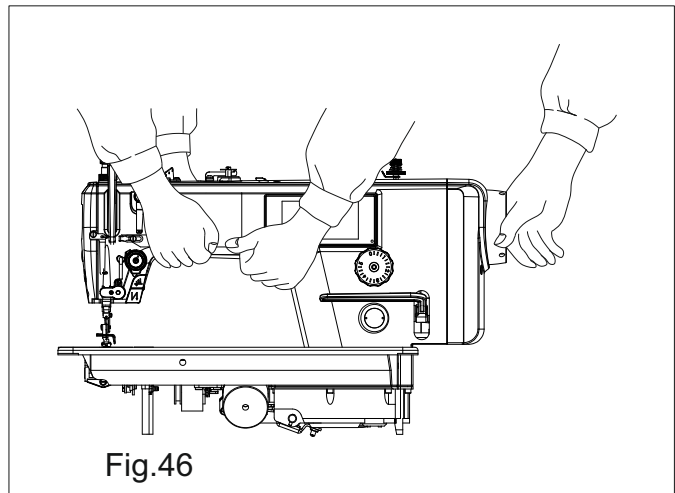
1. Ensuring the oil amount in gear case
Confirm that the top of oil amount indicating rod is between the upper engraved marker line and the lower engraved marker line of the oil amount indicating window. (For the details, refer to "6 Lubrication of machine")
2. Cleaning
 - 1) Raise the presser foot.
 - 2) Remove the two screws ①, and then remove the needle plate ②.
 - 3) Remove dust adhered to feed dog ③ and thread trimmer unit with a soft brush or cloth.
 - 4) Install the needle plate ② with the two screws ①.
 - 5) Turn over the sewing machine down on the supporting bar of head.
 - 6) Remove the bobbin case ④.
 - 7) Wipe off any dust from the rotary hook ⑤ with a soft cloth, and check that there is no damage to the rotary hook ⑤. Wipe out dust and hook oil drained in the under cover near the hook with the cloth.
 - 8) Remove the bobbin from the bobbin case ④ and clean the bobbin case ④ with a cloth.
 - 9) Insert the bobbin into the bobbin case ④, and then place the bobbin case ④ back into the machine



31. Carrying and placing of the sewing machine

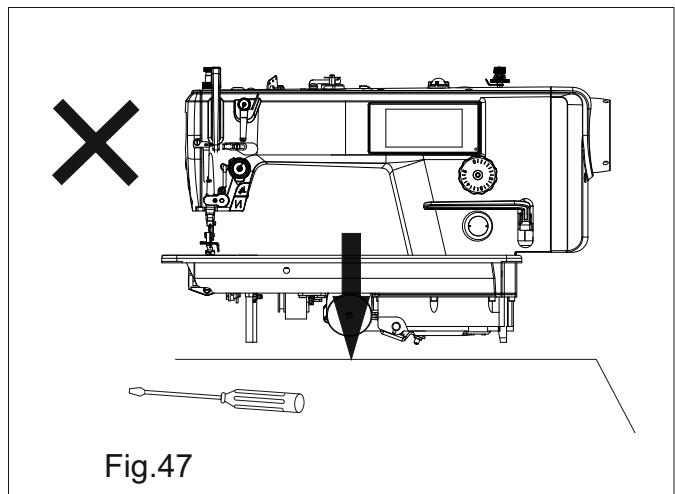
1. Carrying of the machine

It needs to hold tight frame body of the sewing machine by two people as the picture shows.



2. Attention for placing

Must be put in the plain site. Clear the screwdriver or something embossment out of the placing site.



32. Ask your supplier about:

	Machine needle with tip adjusted to sewed material: R - round, standard tip for most fabrics SPI - very slim, acute tip, for a precise piercing of densely woven materials SES - light ball point, especially suitable for jersey, tricot, elastic woven materials SUK - medium ball point, best corsetry, jeans, coarse knitted fabrics, and also elastic materials
	SPIRIT 2 Non-toxic, non-staining, odourless, colourless oil, neutral for plastics. Perfect for lubricating sewing machines (lockstitch, overlock, interlock, etc), needles, knitting cams and other precise mechanism in the textile industry.
	SPIRIT 37 Silicon fluid modified especially for textile industry. Used for preparation of sewing thread and yarn, lubrication of knitting machines needles. Colourless and odourless. Applied with brush, sprinkle or through immersion.
	TWE6 Tweezers

CE DECLARATION OF CONFORMITY

Distributor:

Strima Sp. z o.o.

Swadzim, st. Poznańska 54

62-080 Tarnowo Podgórne, Polska

We declare, that the following product:

Lockstitch machine

Texi Tronic 6 NEO (ZJ9000E-D4S-02)

which this declaration relates, complies with the following directives:

Machinery directive 2006/42/EC

Low voltage directive 2014/35/EU

Harmonized norm used: EN 60204-31:2013

NOTES

[illegible]

NOTES

[illegible]

NOTES

[illegible]



Dealer: