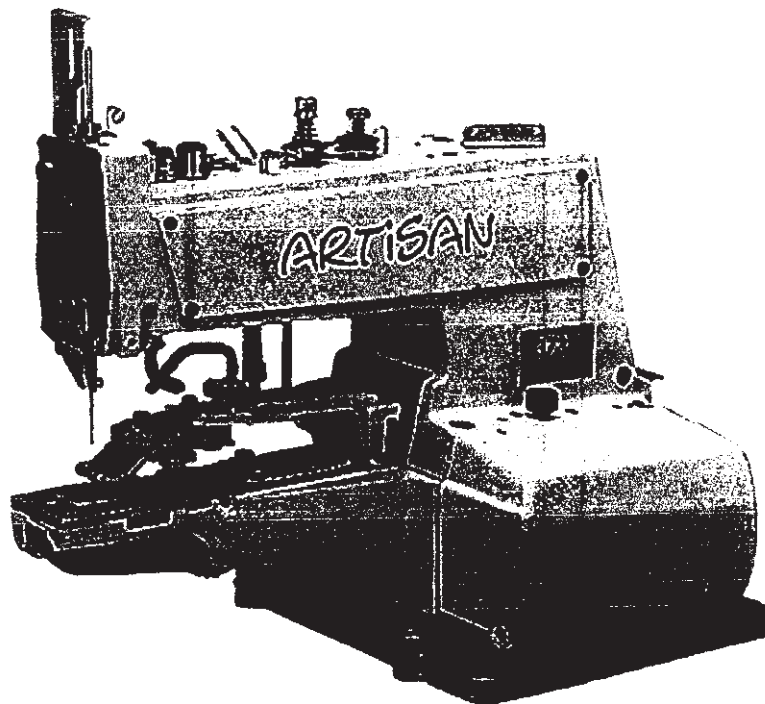


ARTISAN®

**Model 373
Button Attaching Machine**

Instruction Manual



Unpacking and set up instructions

After you have opened this carton and located these instructions. Please follow the directions carefully.

First remove the drawer, thread stand and accessories from inside of the package and set them aside for now.

Next while the machine and table are lying flat on the buck board pallet shipping carton you may want to extend the legs to their maximum position. Loosen the 13 mm leg adjusting bolts, then gently pull from the bottom of the legs outwardly to extend the length of the legs. The normal standing height of the table should be set at 36 inches, and is measured from the bottom of the table top to the floor leg cushions. You may set the height at any level that is comfortable for your machine operator. After setting the correct height, please tighten the bolts securely. The chain from the starting pedal to the machine must be adjusted at the lower "S" hook to minimize any excess free play.

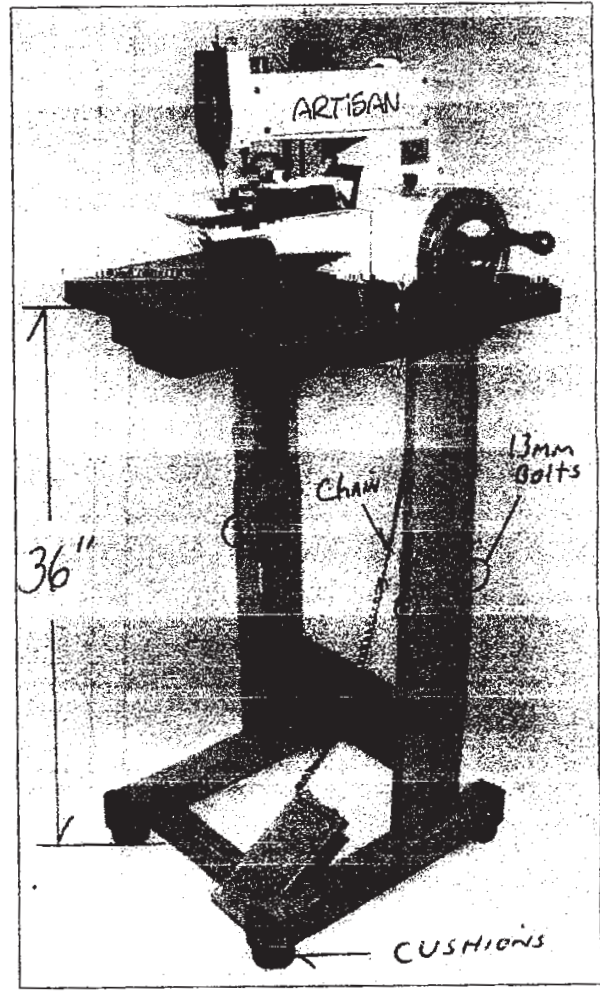
The next step is to stand the complete machine up. This should be done with two people. Remember to work safely and carefully as not to injure yourself.

After standing the machine upright, remove the cardboard cover and packing over the button machine. You may discard the packing materials at this time.

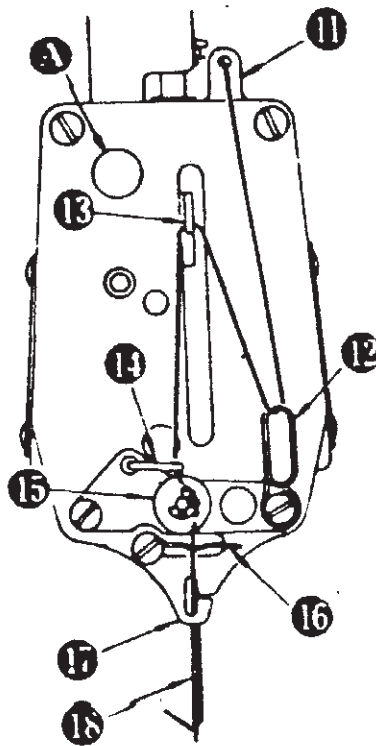
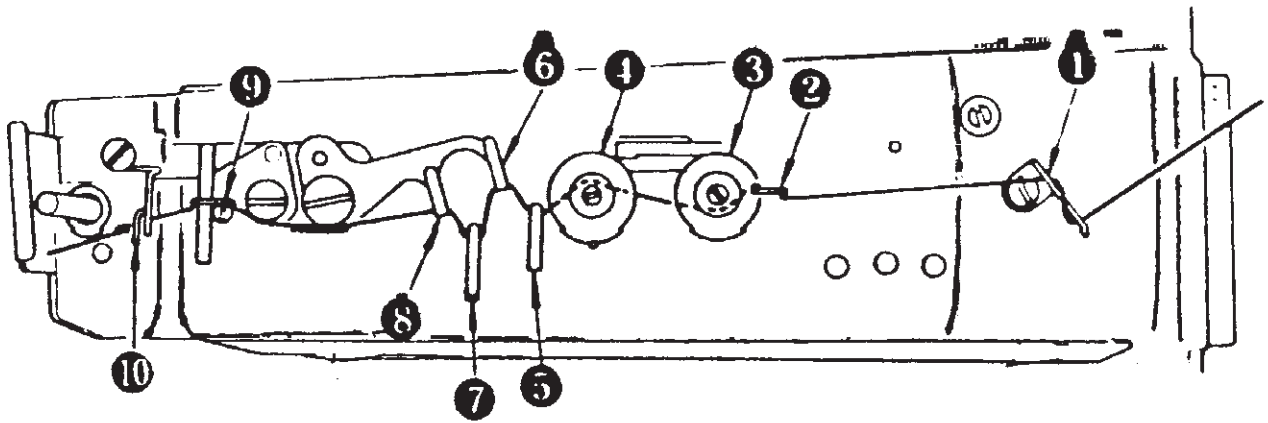
Mount the thread stand with the 3 screws provided in the predrilled holes in the rear left hand corner of the table top. Next slide the drawer into its sliders and place the accessories inside. (Because of space limitations, only the hand operated machine includes a drawer.)

Your machine has been fully tested and correctly adjusted for normal 4 hole button sewing. Please read and understand the instruction booklet before operating the machine.

Thank You for your wise purchase of the *ARTISAN* button attaching machine.



Threading Instructions for the **ARTISAN** Button Attaching Machine



Use Needle Size: 175 x 1 #16

运转前的注意事项

Care Befor Operating Machine

1. 钉扣机出厂时都经过调整,但为慎重起见,先用手旋转皮带轮,若机器能正常运转,再接通电源开关,开机使用。

2. 钉扣机皮带轮的旋转方向,从皮带轮外端面看,应是顺时针转,注意不要反向。

1. Before starting the motor, turn the pulley **OVER** a few revolutions by hand to see if the machine moves well. If ok, turn on motor switch, allow motor to gather full speed.

2. Direction of rotation must be clockwise, when look towards the outside cover of pulley.

Pay attention not to turn the pulley in opposite direction.

使用注意事项

Care When Operating Machine

1. 接通电源开关后以及在机器运转过程中,手不要伸入机针下附近处。

2. 机器运转过程中,手指不要伸入机身两侧的边罩盖内。

3. 放倒机头或装拆皮带时,一定要断开电源开关。

4. 机器运转时,手指、头发或其它物品,请不要靠近正在运转的零部件处。

1. Keep hands away from the needle at all times after turn on the switch.

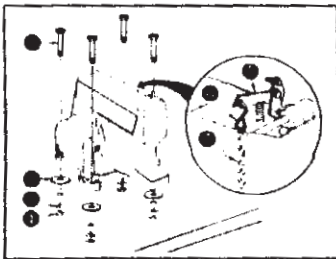
2. Keep fingers away from the inside of the side cover, when the machine is moving.

3. Before performing any of the following procedures: putting down the nose, assembling or disassembling the belt, and so on, make sure that the attaching plug has been disconnected from power source.

4. Make sure everything is away from the running spare parts when the machine is working.

1 安装

1 Installation



1. 在工作台上放上橡皮垫圈①,再放上机头,用螺钉②、平垫圈③、螺母④将机头紧固在工作台上。

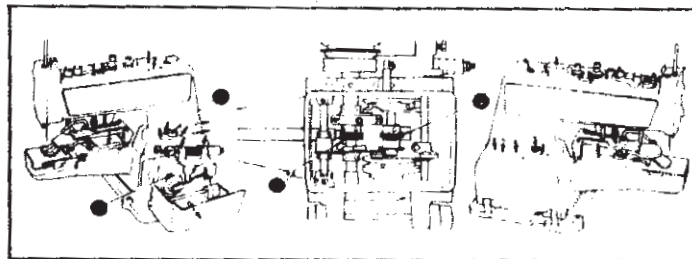
2. 把S形钩子⑤和链条⑥挂在起动杆⑦上。

1. Fasten the nose on the machine sub-base with rubber cushion ①, screw ②, washer ③ and nut ④ as indicated by the chart.

2. Put the s-shaped hook ⑤ and ⑥ chain on the stop motion trip lever ⑦.

2 加油

2 Oiling



1. 把 No. 1 润滑油加到箭头所示部位。

2. 打开右侧罩盖,卸下皮带轮上的螺钉①,给皮带轮轴孔补充润滑油脂。

3. 松开螺钉②,放倒机头,给螺旋齿轮付③及蜗杆付④补以润滑油。

4. 检查一下润滑油是否加至安装底座上的供油毡上,不足时加以补充。

1. Fill No. 1 lubricating oil into the places as indicated by arrows in the charts.

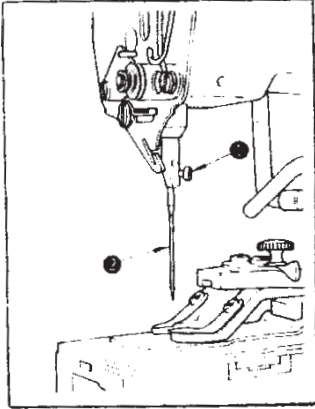
2. Open the rightside cover, remove the screw ① on the pulley and fill the lubricating grease into the shaft hole.

3. Release the screw ②, put down the nose, fill the oil into the opening of a pair of spiral gear ③ and worm and worm gear ④.

4. Check to see if the oil is added to the oil dripfelt base plate, if not, add more.

3 针的安装

3 Needle Installation

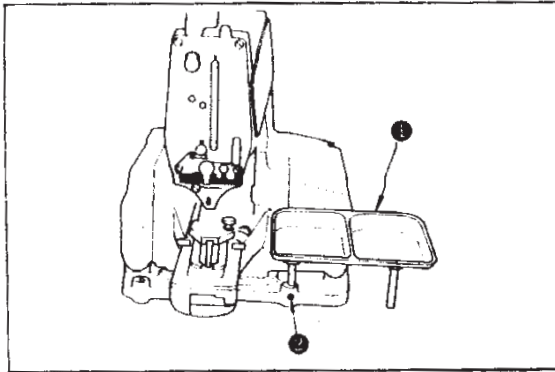


- ★关掉马达电源:
- ★机针型号:
TQ×1(短针)
TQ×7(长针)
机针规格:18#、16#
- 1. 松开紧固螺钉①,手持针②,使针的长沟朝前面对操作者
- 2. 将针插入到针杆孔底,再将螺钉①紧固。
- ★Turn off the motor switch
- ★Needle's Type:
TQx1(short)
TQx7(long)
Needle Size:18#,16#

1. Release the fastener screw ①, handle the needle ② and let the slot in the needle towards operator.
2. Insert the needle into the bottom of hole in the needle bar, then fasten the screw ①.

5 钮扣盘的安装

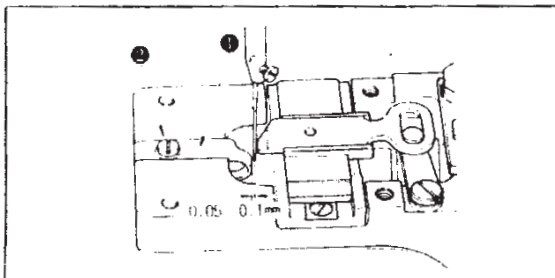
5 To Install The Button Tray



- 把钮扣盘①插入位于底座前部右侧的孔中并拧紧紧固螺钉②,必要时也可将盘安装在左侧。
- Insert the button tray ① into the hole in the front right-side of the base and fasten the screw ②, or on the left side if necessary.

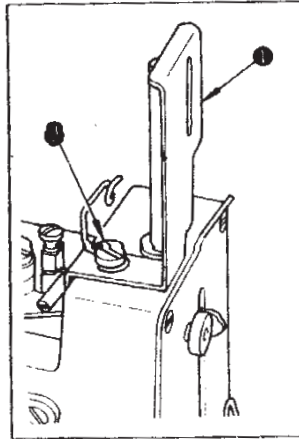
7 针导轨的位置

7 To Locate The Needle Guide



4 针杆护板的安装

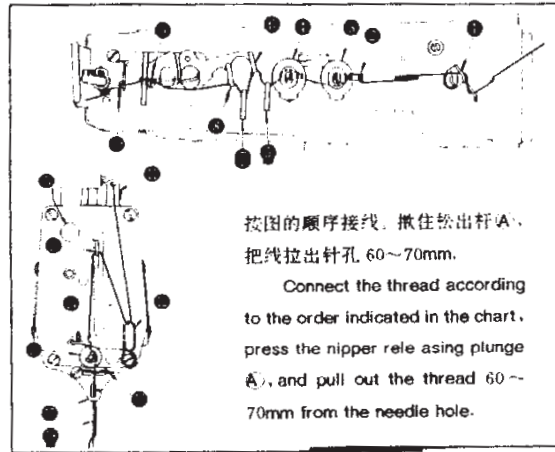
4 Installation Of Needle-bar Guard



1. 卸下紧固螺钉②。
2. 在导线环的下面安放针杆挡板①。
3. 用紧固螺钉将导线环,挡板一起固定在机头上。
1. Remove the fastener screw ②.
2. Put the needle bar guard ① under the thread guide.
3. Fasten the thread guide and the bar guard on the nose with the screw ②.

6 线的接法

6 To Connect The Thread



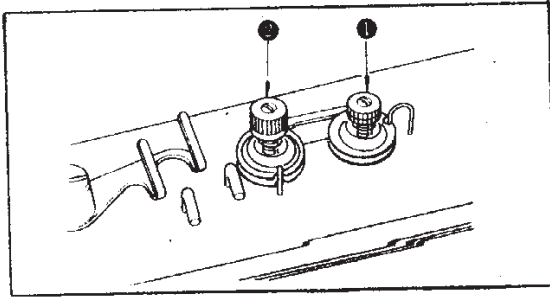
- 按图的顺序接线, 抓住引出杆A, 把线拉出针孔 60~70mm.
- Connect the thread according to the order indicated in the chart, press the nipper reeling plunge ①, and pull out the thread 60~70mm from the needle hole.

拧松螺钉②,当针杆在最低点时,移动针导轨①,使之与针的间隙为0.05~0.1mm。调好后将螺钉拧紧。

Release screw ②, when the needle bar is at the lowest, move needle guide ① to the extent that the interval between the guide and needle is at the range of 0.05~0.1mm, then fasten screw ②.

8 线夹的调节

8 To Adjust The Thread Tension Nut



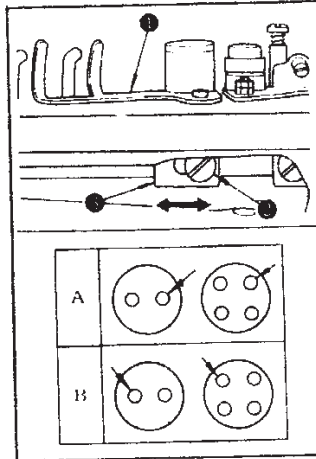
第一线夹螺母①用于调节钮扣的缝纫强度,使线既有一定的张力,又不使缝钮产生障碍。

第二线夹螺母②用于调节钮扣内侧线的勒紧程度,其线的张力比第一线夹强,张力的大小随使用的线,布的质地、钮扣的厚度而异。

The thread tension nut ① is for the adjustment of button sewing strength, it makes the thread not only to have some tension, but also not to produce an obstacle to the button attaching. Tension nut ② is for the tension adjustment of the thread under button, the tension of nut ② is stronger than that of nut ①, and different with the thread, cloth and the thickness of button.

9 线调节杆的调节

9 To Adjust The Thread Pull-Off Lever



线调节杆①的调节方法是:用螺丝刀从左侧盖板孔中松开止动螺钉②,将线调节杆滑块③左右移动。缝纫结束时,若线头从A部的箭头所示孔中露出,则把滑块向左移动;若线头从B部的箭头所示的孔中露出,则把滑块向右移动,使线不露出。

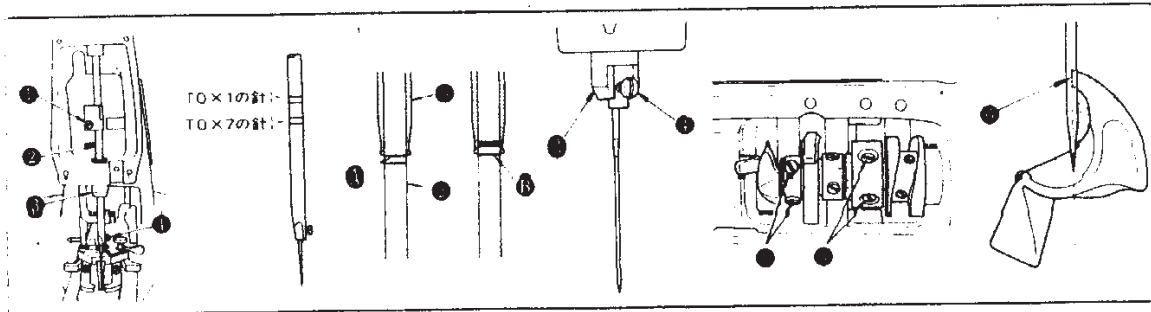
How to adjust the thread pull off lever ①: Release stopper screw ② from the left side cover with screw driver,

move nipper bar blok ③ to right or left.

At the end of stitching, if the thread shows its head from the holes as indicated by arrows in A part, put block ③ to left; if the thread head emerges from the holes as indicated by arrows in B part, put block ③ to right, at last, to the extent that the thread head will not reveal.

10 针和结扣线钩的关系

10 The Relationship Between Needle And Looper

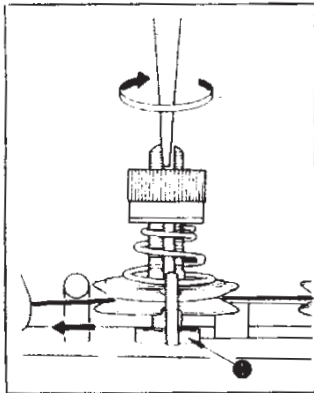


1. 用力踩下脚踏板,用手沿旋转方向驱动皮带轮,使针杆处于最低点状态并松开止动螺钉①。(决定针杆的高度)
2. 若使用TQ×1机针(短针),则使针杆上端的二根刻线,若使用TQ×7针(长针),则使用针杆下端的二根刻线。调整针杆的高度时,使二根一组刻线中的上刻线(A)与针杆下轴瓦③的下端面重合并使针杆下端的斜切面朝正前方,调好后拧紧止动螺钉①。(决定结扣线钩的位置)
3. 松开止动螺钉⑤,驱动皮带轮,当针杆在上升时,使二根一组刻线中的下刻线⑥与下轴瓦③的下端面重合。
4. 在3的状态下,使结扣线钩的勾端④与针的中心重合,拧紧止动螺钉⑤。
5. 松开螺钉⑦,调整勾端与针的间隙在0.05~0.1mm范围内,拧紧螺钉⑦。

1. Step down the foot driving plate, drive the pulley with hand accordig to the rounding direction, let the needle bar to the lowest, and release the stopper screw ①. (adjust the needle bar's height)
2. if use needle TQ×1 (short), then the upper two-lines scratch on the same needle bar will be applied. when adjusting the needle bar's height, make sure the upper line A between the two-lines scratch coincides with the bottom face of bush ③ and let the bevel face on the bottom of needle bar towards the right front, then fasten the stopper screw ①. (adjust the location of looper)
3. Release stopper screw ⑤, drive the pulley by hand, while the needle bar is rising, make sure that the lower line B between the two-lines scratch coincides with the bottom face of the lower bush.
4. In 3 situation, coincide the head of looper ④ with the centre of needle, fasten the stopper screw ⑤.
5. Release screw ⑦, adjust the gap between the head of looper and the needle at the range of 0.05 ~ 0.1mm, fasten the screw ⑦.

11 线松懈同步的调节方法

11 To Adjust The Thread Elastic Synchronization



把线往箭头方向拉，同时旋转皮带轮，在针杆上升过程中，当第二线夹的上夹盘开始被顶动时，从针杆上轴瓦的上端面到针杆顶端的高度标准调节到 54~56mm。

特别是下面列举的现象频繁发生时，须进行调节，方法如下：

松开螺母①，将螺丝刀插入线夹螺杆槽，沿箭头方向旋转，则针杆高度变低，沿反向旋转，则针

杆高度变高。

Pull the thread as indicated by arrow, and turn the pulley simultaneously, in the rising of needle bar, and when the upper face of the second nipper is being pushed, adjust the interval from the upper face of the upper bush on the needle bar to the top of needle bar in the range of 54~56mm.

Esp. if the following phenomenon emerge frequently, have to adjust them as follows:

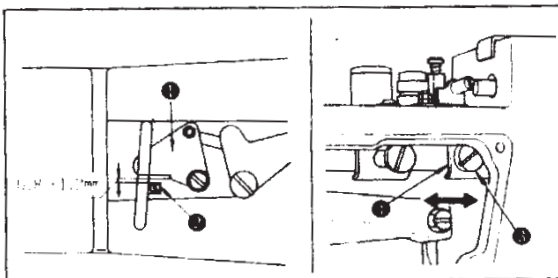
Release screw ①, insert screwdriver into the slot of the nipper, turn it as indicated by arrow, the height of needle bar will become lower, otherwise become higher.

现象	针杆高度
1. 布背面的线不牢固时	稍微提高。
2. 切线时，线从中途断掉。	稍微提高。
3. 断线现象多时	稍微降低

Phenomenon	The Height Of Needle bar
1. The thread is not firm.	Raise the needle bar a little.
2. The thread is broken in the middle when trimming.	Raise a little.
3. Too much thread breaking.	Lower a little.

13 前线夹的调整

13 To Adjust The Front Nipper

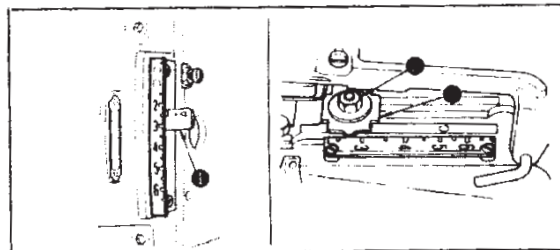


12 两孔和四孔的调节方法

12 To Alternate The Two-Holes Button And Four-Holes Button

首先，实测钮扣的孔距是几毫米，对四孔钮扣，则调节纵向进给刻度与横向进给刻度，使其值相同。

First, directly measure the hole distance in a button, then according to the measured distance to adjust the size of the lengthwise feed scale and crosswise feed scale for four-holes button and make sure the same with the measured distance.



★纵向进给刻度

把纵向进给杆①在下按，两孔钮扣时，将杆推至 0 刻度，四孔钮扣时，则推至孔距实测值刻度。

★横向进给刻度

松开螺母②，把指针③对准与孔距实测值对应的刻度值，并紧螺母②。

(注意)在确认针落在钮扣各个孔的中心之后，才能运转缝纫机。

★Lengthwise Feed Scale

Put down lengthwise feed indicator ① to scale mark 0 for two holes button and to the measured distance scale for four-holes button.

★Crosswise Feed Scale

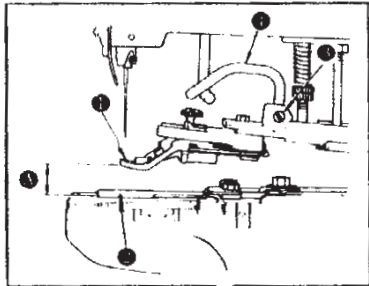
Release screw ②, keep crosswise feed indicator ③ pointing to the measured hole distance scale, and fasten screw ②.

CAUTION: Operate the machine only after making sure needle is pointing to the holes' centre.

线夹柱②和线夹座①的间隙应为 0.8~1.2mm，使运转时不碰线。调整的方法是：拧松螺钉③，将滑块④左右移动。调整后，将螺钉③拧紧。

The interval between nipper block ② and nipper sub-base ① should be 0.8~1.2mm, which ensure not to hinder the thread moving, the method is, release screw ③, move sliding block ④ right and left, fasten screw ③, after adjusting.

14 夹钮器的高度
14 The Height Of Button Clamp

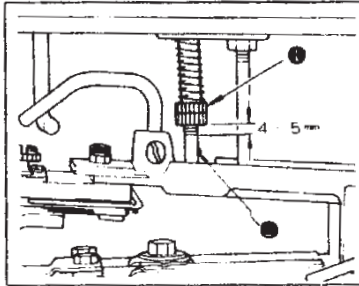


钉扣机在启动前,其夹钮器夹钮杆①的底面与进给面板②的上平面的距离(A)应为9mm。调整时,拧松螺钉③,上下移动下提升杆④,按A值调整好夹钮器的高度后拧紧螺钉③。

Before starting the motor, keep the interval (A) between the basal plane of button clamp lever (1) and the surface of feed plate (2) be 9mm.

Release screw (3), move lifting rod (4) up and down, to the extent that A is 9mm, then fasten screw (3).

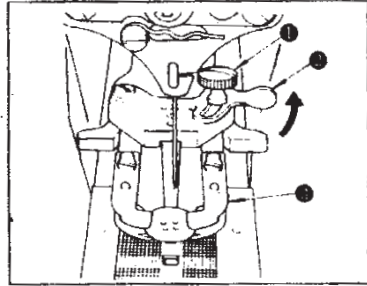
15 撤布压力的调节
15 To Adjust The Pressure To The Cloth



旋转调压螺母①,便可调节撤布的压力。一般的标准是:使调压螺母的下端面与压力调杆②的螺纹的距离为4~5mm。

Turn round the thread tension stud nut (1), and can change the pressure to the cloth. The general standard is: ensure the distance from the bottom of nut (1) to the thread of pressure adjusting bar (2) is 4~5mm.

16 夹钮杆开口的调节
16 To Adjust the Opening Size Of Button clamp

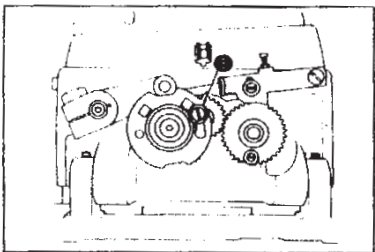


在夹钮器提起的状态下,拧松螺钉①,推动调钮扳手②,使夹钮杆③开口尺寸适合钮扣的尺寸,再拧紧螺钉①。

While the button clamp is up, release screw (1), and push clamp stop lever (2) to make button clamp opening size be suitable for the buttons, fasten screw (1).

17 针数的更换
17 To Select The Stitch Number

打开左侧罩盖,通过针数调节旋钮①,针数调节柄④,调节螺钉⑤以及紧固螺钉③就可以进行针数的变换。
Open the left side cover and change the stitching number by adjusting stitch selecting key (1), shaft (4), screw (5) and fastened screw (3).

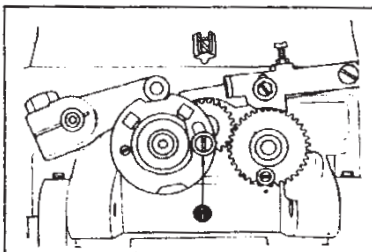


★8 针的变换方法

为了变换到8针,可把针数调节旋钮①往自己面前拉,转到图示位置即可。

★8 Stitches

Pull the stitch selecting knob (1) to the position as indicated by the chart, for 8 stitches.

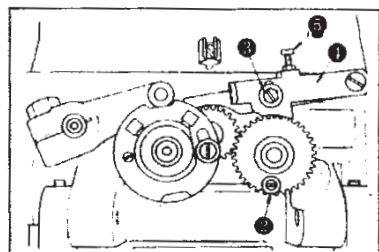


★16 针的变换方法

在8针的状态下,当针数调节旋钮①处在右侧时,把调节旋钮转到图示的位置即轮槽的下端就可变换到16针。

★16 Stitches

In the 8 stitches situation, when the stitch selecting knob (1) is on the right, turn the knob (1) to the bottom of the wheel slot and so select the 16 stitches situation.



★32 针的变换方法

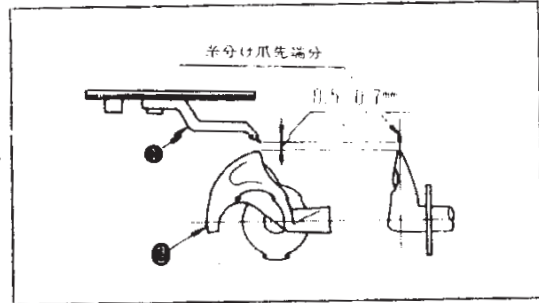
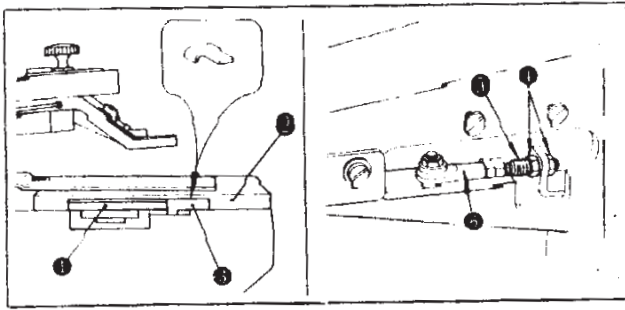
在16针的状态下,当针数调节齿轮滚子②转到下端时,拧松紧固螺钉③,用手按下针数调节杆④,拧紧螺钉③,如果还没有达到32针时,则再拧松螺钉③,旋转调节螺钉⑤进行调节。

★32 Stitches

In the 16-stitch's situation, when the stitch selecting roll (2) is in the bottom, release screw (3), put down stitch selecting lever (4) by hand, fasten screw (3). If it is not 32 stitches, release screw (3) again and

18 关于切线装置

18 To Adjust The Automatic Thread Trimmer



★切线位置的调整

在切线位置,即夹钮器完全提起的状态下,切线连结板①的前端与针板②沟端面的间隔的标准是13mm。

与13mm相对应的是附件量块③,插入量块并调整到它们接触即可。调整的方法是:放倒缝纫机,卸下机身防油板,拧松螺母④,前后移动连结螺钉⑤,使切线连结板顶住量块,在并紧螺母④时,应把关节连轴节调节到大致水平的位置。

★To Adjust The Thread Trimming Position

In the situation of thread trimming, that is the button clamp is raised completely, the standard interval between the front of yoke slide insert plate ① and ditch face of throat plate ② is 13mm.

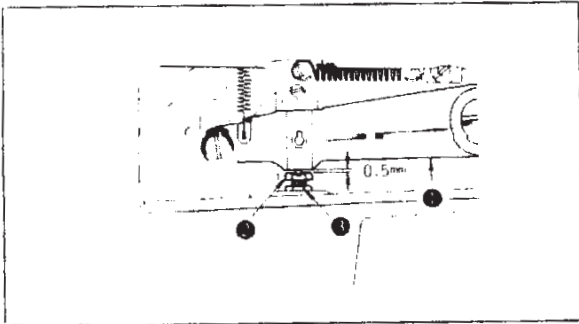
Corresponding to the 13mm interval is the gauge block ③, insert block ③ and adjust as follows: put down the nose, remove the oil-proof block, release screw ④, move screw ⑤ front and back and keep the yoke slide insert plate holding out against the gauge block ③, when the joint ⑥ is adjusted to the level, fasten screw ④.

★分线爪高度的调整

分线爪①与结扣线钩②的间隙调节到0.5~0.7mm。分线爪高度失常时,就会造成分线爪弯曲。

★ To Adjust the Height Of thread-Parting Claw
Adjust the interval of thread-parting claw ① and looper ② to 0.5~0.7mm.

otherwise the claw will be curved.

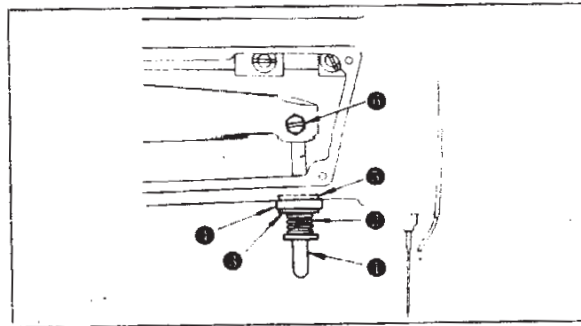


★提升杠杆与调节螺钉的间隙调整

把提升杠杆①的端面与调节螺钉②之间的间隙调整为0.5mm,并用螺母③并紧。

★To Adjust The Interval Between Lifting Lever ① And Screw ②

Adjust the interval between the face of lifting lever ① and screw ② to 0.5mm, and fasten screw ③.



★L形提升杆的安装方法

按复位弹簧②、垫圈③、缓冲垫圈④、垫圈⑤的顺序调节L形提升杆。在确认完全切线状态之后,进行安装,使杆与缓冲垫圈的端面靠紧,不晃动,最后用止动螺钉⑥拧紧。

★To Install The L-Shaped Lifting Lever

Adjust the L-Shaped lifting lever by the order of spring ②, cushion ③, rubber cushion ④, cushion ⑤. Begin to install and keep the lever against the rubber cushion firmly after ensure the complete auto-trimming, and fasten screw ⑥ at last.

19 规格明细表
19 Specification List

缝纫速度	最高每分 1500 针	润滑油	No. 1 润滑油
针 数	8, 16, 32 三种可调针数	马 达	AO: 7114.250W.380V
进给量	横向 2.6~6.5mm, 纵向 0~6.5mm	马达用皮 带轮外径	∅60mm
钮扣尺寸	∅10~∅28mm		
使用机针	TQ×7, TQ×1, 18号, 16号	使用皮带	园皮带, ∅7(或∅8)×650mm

Sewing Speed	Max: 1500 s. p. m	Lubricating Oil	No. 1
Number of stitches	8, 16, 32 (3 kinds)	Motor	AO: 7114.250w.380V
Feeding Range	Lengthwise: 0~6.5mm	Outer Diameter Of motor pulley	∅60mm
	Crosswise: 2.6~6.5mm		
Button Size	∅10~∅28mm		
Type of needle	TQ×7, TQ×1, 18#, 16#	Leather belt	Round belt ∅7(or∅8)×650mm

20 故障原因及对策
20 Trouble Reasons And Solvement

故 障	原 因	对 策
1. 断线	①. 线团出线不良。 ②. 第二线夹盘浮动同步不好。 ③. 线夹座压住线。 ④. 针不落在钮扣孔中心。 ⑤. 与钮扣孔相比, 针粗。	○ 调整线架托盘位置, 使出线阻力均匀。 ○ 稍微提前夹盘的浮动时间。 ○ 调整线夹座与线夹柱间隙, 使运转时不压线。 ○ 通过夹钮支板进行调节。 ○ 换细针。
2. 线勒不紧	①. 线团出线不良。 ②. 第二线夹盘浮动同步不好。 ③. 第二线夹盘压力不好。 ④. 针不落在钮扣孔中心。 ⑤. 撒布压力不良。	○ 调整线架托盘位置, 使出线阻力均匀。 ○ 稍微推迟夹盘的浮动时间。 ○ 由线夹盘螺母进行调节。 ○ 通过夹钮支板进行调整。 ○ 通过夹钮器压力调节棒螺母进行调节。
3. 进线线头露出钮扣孔	①. 线调节杆调节不良。	○ 重新调节线调节杆。
4. 切线不良	①. 切线时线松。 ②. 针碰到钮扣孔。 ③. 夹钮器提升量不对。 ④. 线夹座不压线。 ⑤. 撒布压力过大。 ⑥. 分线爪分开线。 ⑦. 拉线钩动作不同步。	○ 稍微推迟第二线夹盘的浮动时间, 使线勒得紧些。 ○ 通过夹钮支板调节, 使针落在孔的中心。 ○ 调整夹钮器的提升量为 9mm。 ○ 调整线夹座与线夹柱间隙, 切线时应压线。 ○ 通过夹钮器压力调节棒调整压力。 ○ 调整切线位置。 ○ 调节拉线钩与针的动作同步。

Trouble	Reason	Solvement
1. Thread disconnection	①The thread can't go out freely from the thread ball. ②The second(thread tension)nipper's floating synchronization is not good. ③The thread is pressed too much by the nipper sub base. ④The needle is not pointing to the hole centre. ⑤The needle is too thick for the button hole.	<input type="radio"/> Change the position of thread tray, make the thread resistance even. <input type="radio"/> Shift to an earlier floating time of nipper. <input type="radio"/> Adjust the interval between nipper block and nipper sub-base. <input type="radio"/> Adjust by clamp block. <input type="radio"/> Change into thin needle.
2. The thread can't be lightened	①The thread can't go out freely from thread ball. ②The second (thread tension) nipper's floating synchronization is not good. ③The thread is not pressed well by the nipper. ④the needle is not pointing to the hole centre. ⑤The pressure to the cloth is not adequate.	<input type="radio"/> Change the position of the thread tray,make the thread resistance even. <input type="radio"/> Shift to a later floating time of nipper. <input type="radio"/> Adjust by the screw on the thread nipper plate. <input type="radio"/> Adjust by clamp block. <input type="radio"/> Adjust by the screw on the button clamp pressure bar.
3. The thread head emerge from the button hloe	①The thread pull off lever is not in a adequate position.	<input type="radio"/> Adjust the thread pull off lever again.
4. Bad trimming	①The thread is too loose when trimming. ②The needle touches the button hole. ③ The button clamp machine's lifting is not adequate. ④The thread is not pressed by the thread nipper sub-base. ⑤The pressure to the cloth is too much. ⑥The thread-parting claw doesn't separate the thread. ⑦ The motion of thread pull off hook is not synchronous.	<input type="radio"/> shift to a later floating time of the second nipper. <input type="radio"/> Adjust the clamp block to keep the needle pointing to the hole centre. <input type="radio"/> Adjust the button clamp machine's lifting to 9mm. <input type="radio"/> Chngne the interval of nipper sub base and nipper block. <input type="radio"/> Adjust the pressure by the button clamp pressure bar. <input type="radio"/> Adjust the trimming position. <input type="radio"/> Adjust the synchronization of thread pull-off hook and needle.