

ARTISAN®

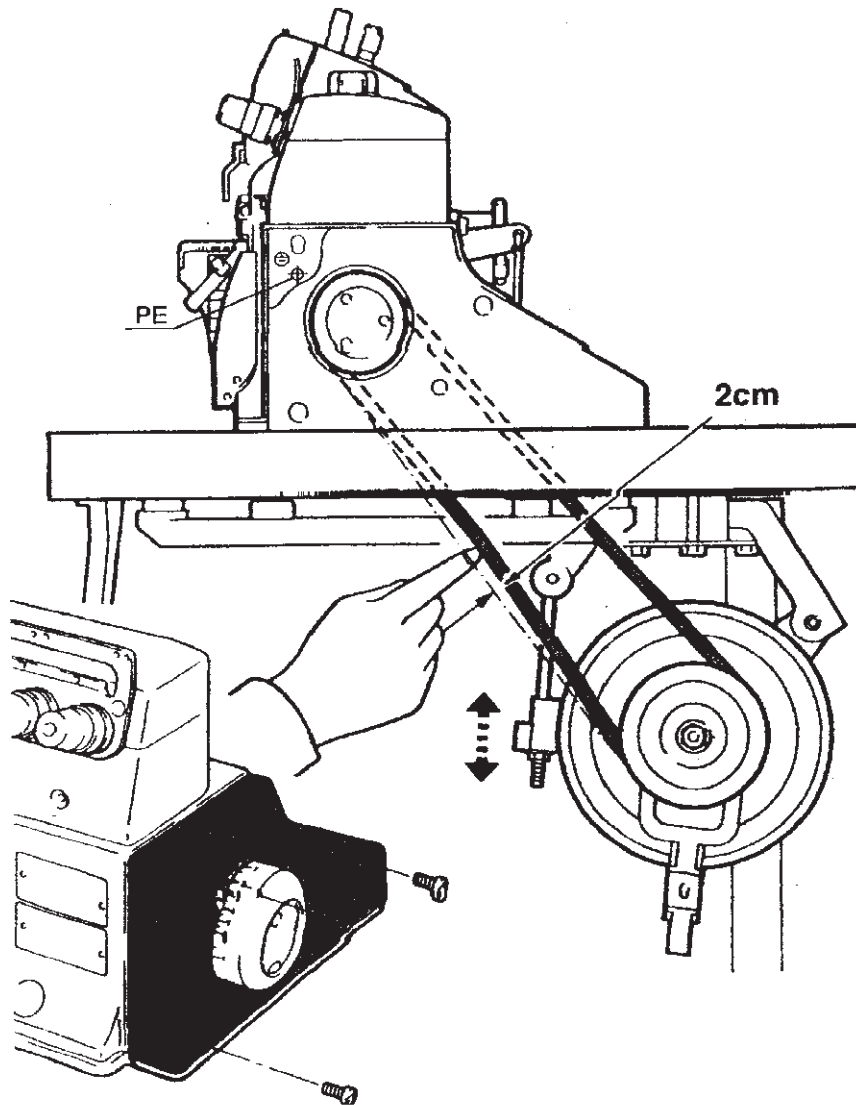


**Models
732 and 752
Spare Parts
and Operators
Manual**

BEFORE
OPERATING

Installing the machine head

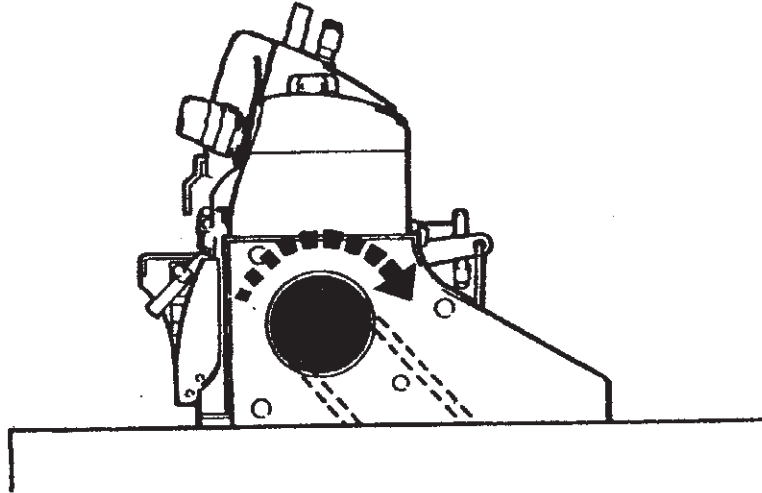
1. Mount the machine head on the machine rest board .
2. Install ground wire at PE.
3. Adjust the tension of the belt so that it can be about 2cm bent inward when you press the middle of it. Adjust the height of the motor to do this.
4. Install the belt cover referring to the Figure.



BEFORE
OPERATING

The machine speed and the turning direction

The machine rotates clockwise when seen from the machine pulley side.



Make sure your machine type and run it not exceeding the maximum speed as listed in the table.

Machine model	The highest speed (r.p.m.)
732-36	6,500
732-38	6,500
732-48	5,500
732-70	6,500
732-86	5,500
752-01	7,000
752-13	6,500
752-16S2	6,000
752-17	7,000

BEFORE
OPERATING

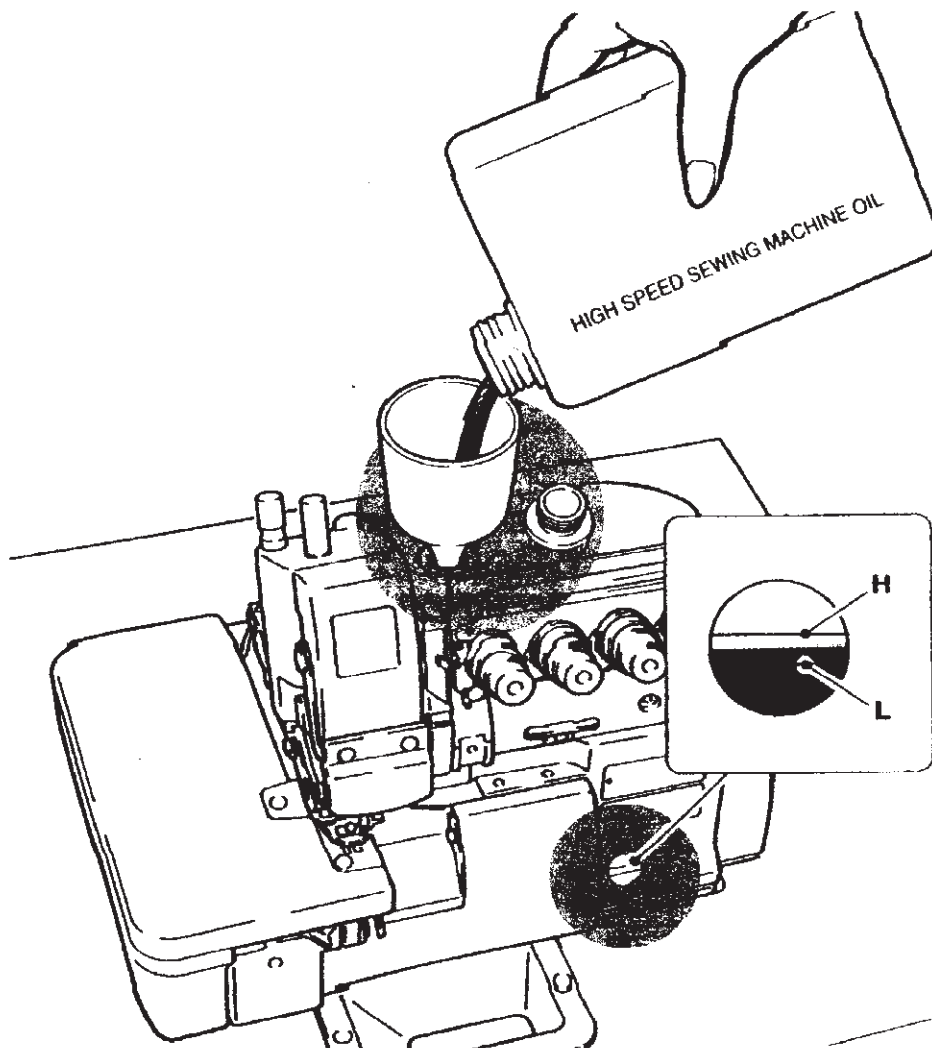
Lubrication

(HIGH SPEED SEWING MACHINE OIL)

After filling the oil pan, the oil surface should lie between (H) and (L) lines.

Add oil when the oil surface reaches or goes below (L)

Note: Use recommended oil (HIGH SPEED SEWING MACHINE OIL) (ISO VG22)

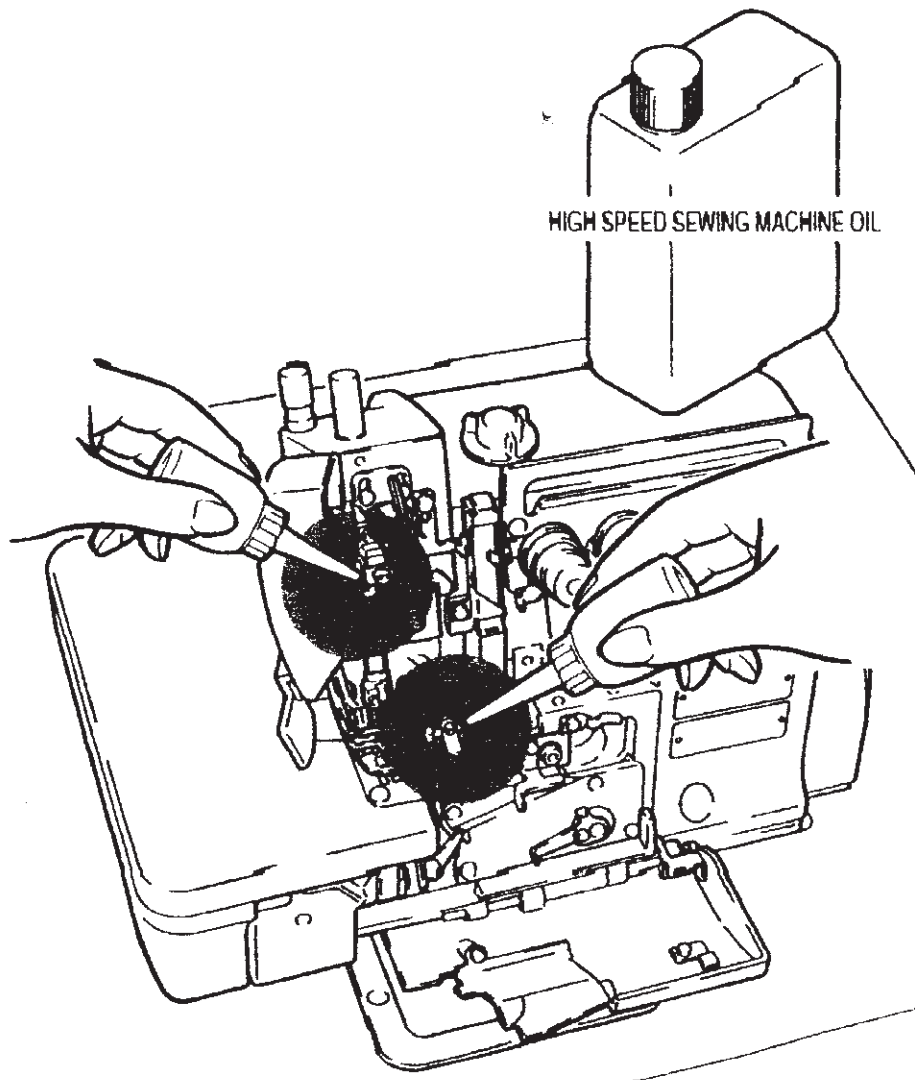


BEFORE
OPERATING

Manual lubrication

(HIGH SPEED SEWING MACHINE OIL)

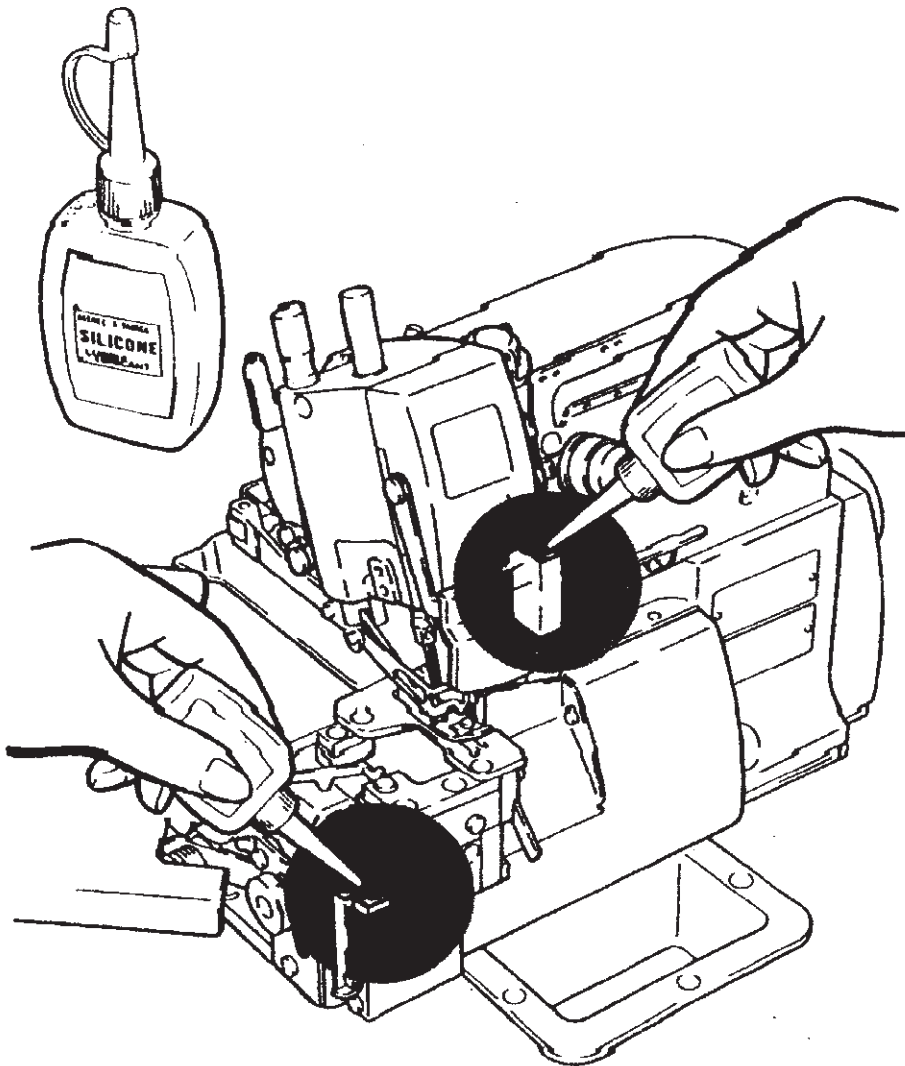
Apply 2 or 3 drops of oil by hand when the machine is used for the first time or has been left unused for some time.
Note: Use recommended oil (HIGH SPEED SEWING MACHINE OIL) (ISO VG22)



**BEFORE
OPERATING**

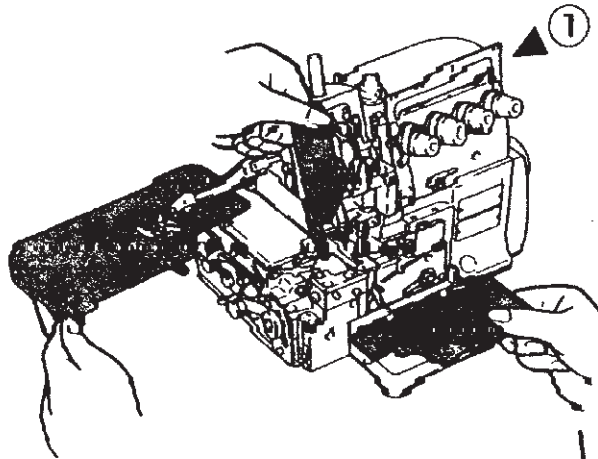
Filling the HR device with silicon oil

Fill the HR device with oil before it is too low in order to prevent needle thread breakage and fabric damage.
Note:Uss recommended silicon oil



BEFORE
OPERATING

Threading

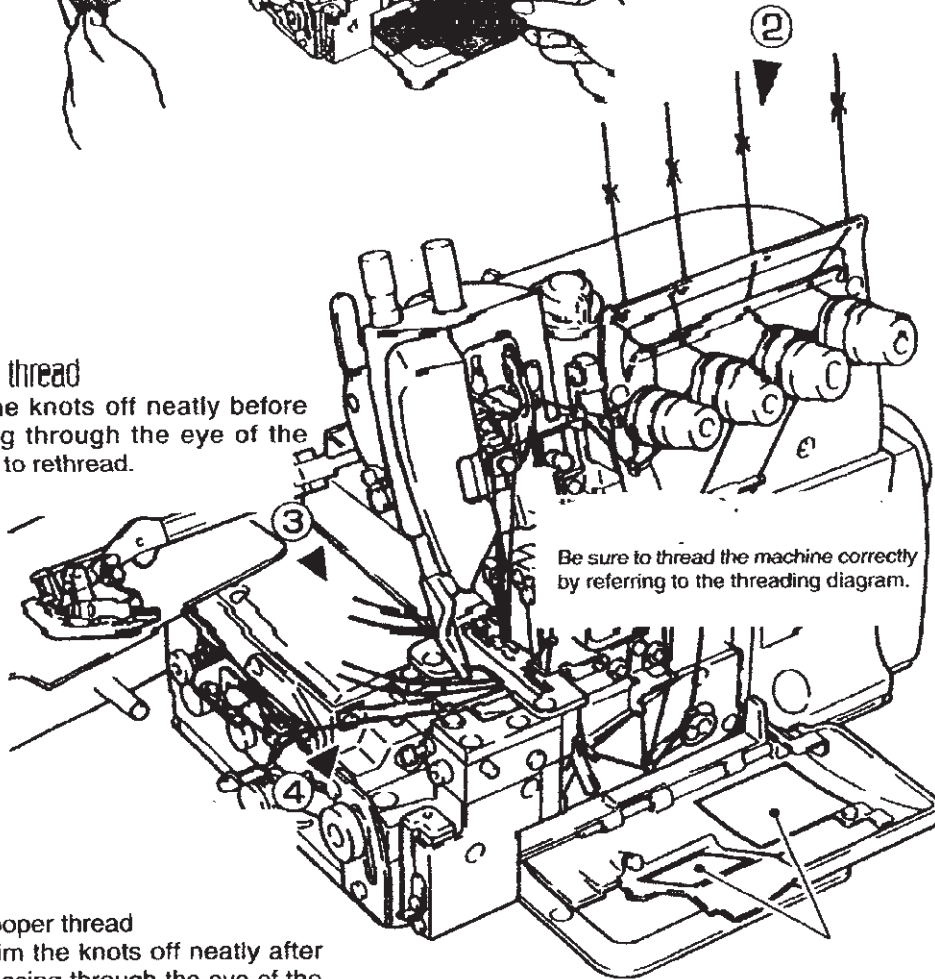


①
Open three covers.
Swing the presser foot aside.

Knot the preset thread and the
thread being used together to
thread the machine.

Needle thread

Trim the knots off neatly before
passing through the eye of the
needle to rethread.



②
Be sure to thread the machine correctly
by referring to the threading diagram.

Looper thread

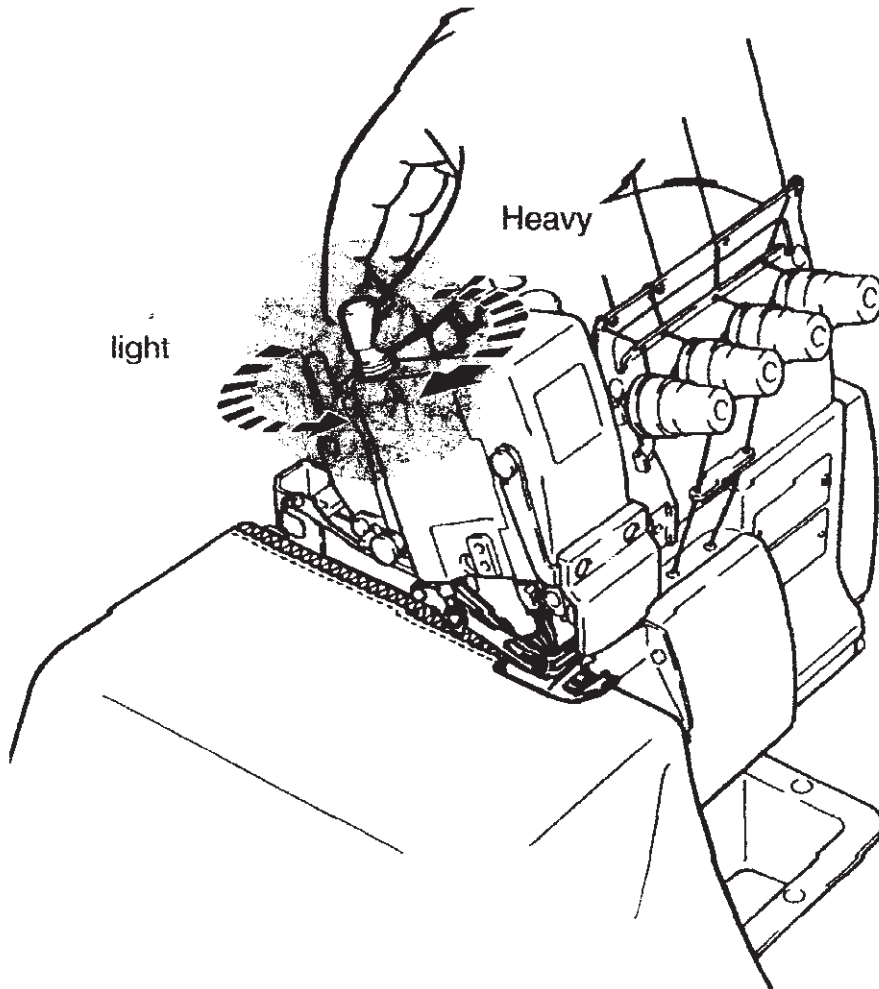
Trim the knots off neatly after
passing through the eye of the
looper.

Threading diagram

TEST SEWING

Adjusting the presser foot pressure

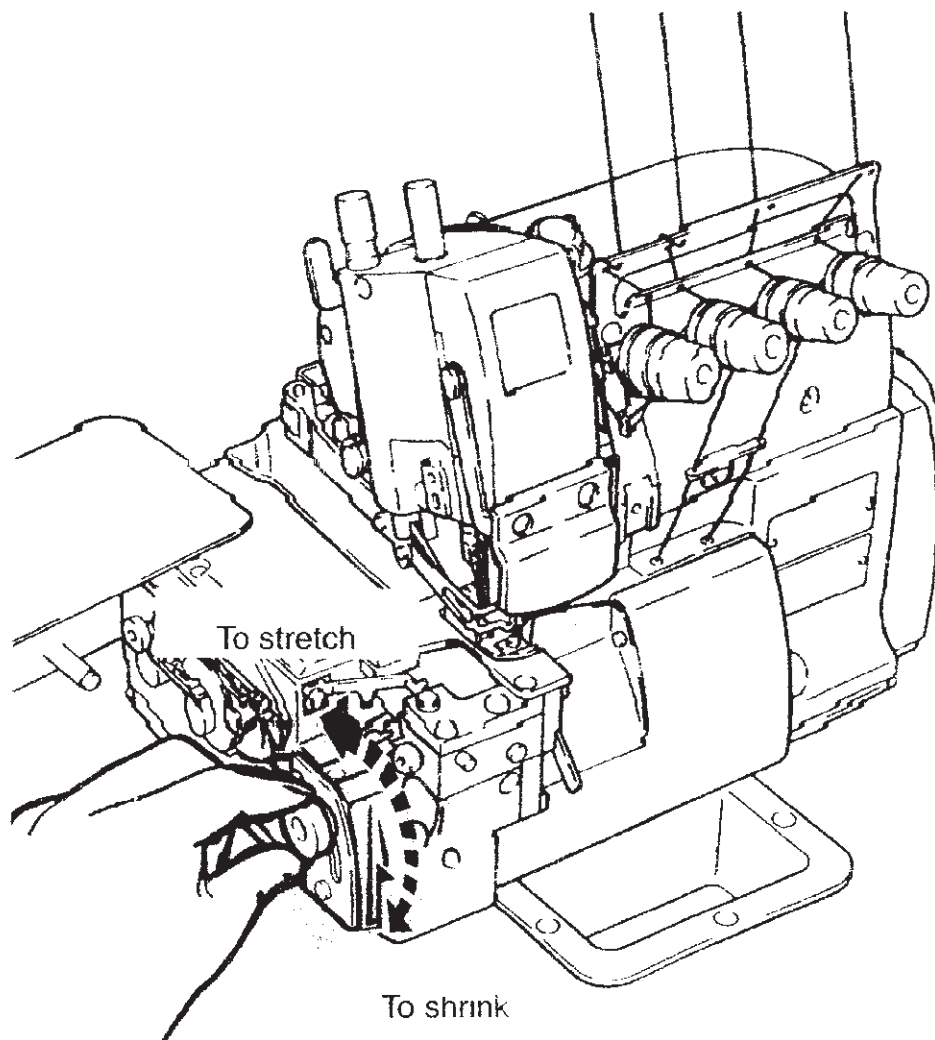
Turn adjusting screw to adjust the presser foot pressure. It should be as light as possible, yet be sufficient to obtain the proper stitch formation.



TEST SEWING

Adjusting the diff.feed ratio

Loosen the nut and move the lever up and down to obtain the correct differential feed ratio.
Tighten the nut after positioning the lever as desired.

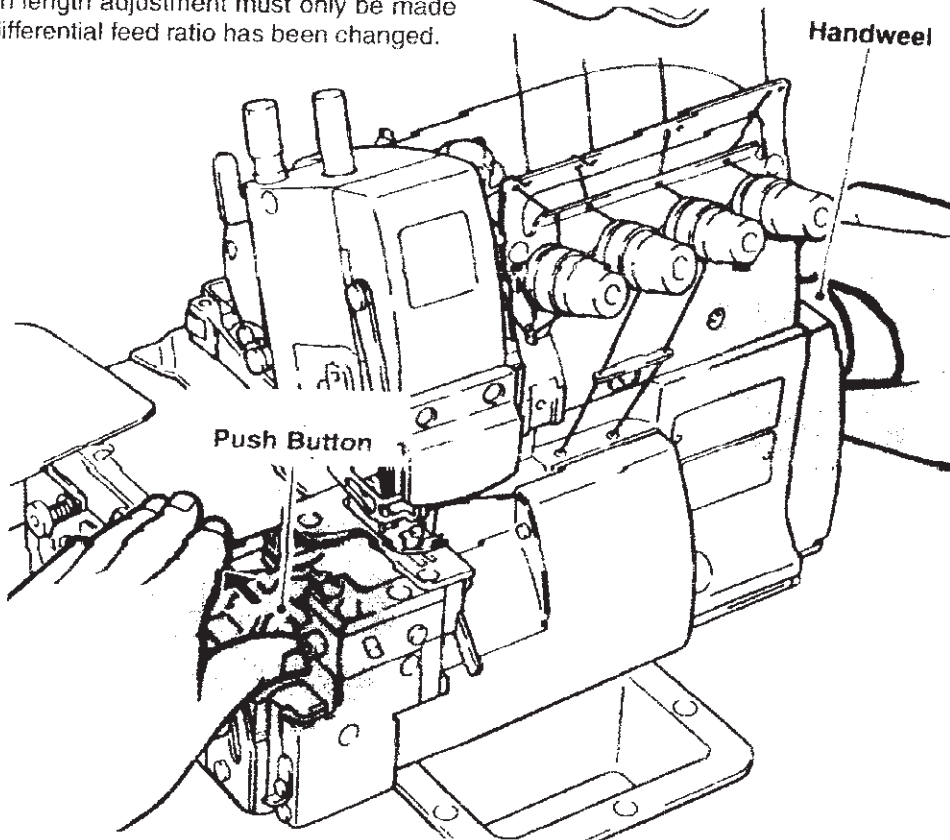
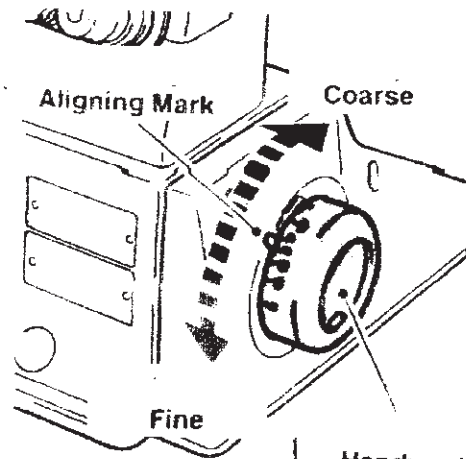


Adjusting the stitch length

① While pressing the push button, turn the handwheel to seek the position at which the push button goes further into the depth.

② Then, keeping the push button pressed, turn the handwheel and, set the desired scale to the aligning mark.

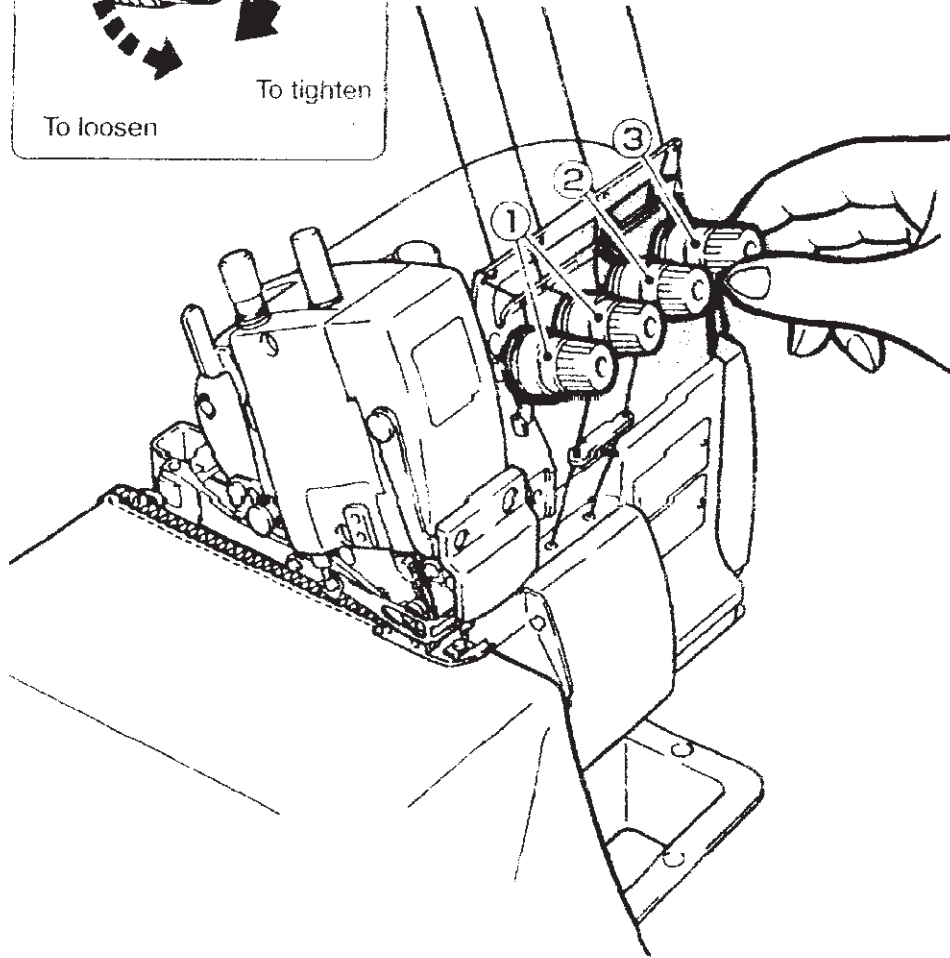
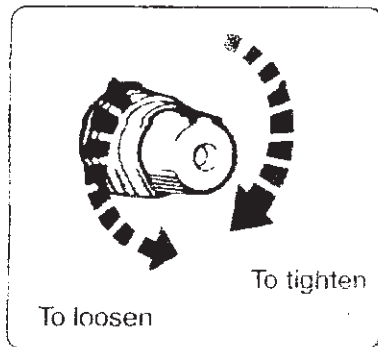
Note: Stitch length adjustment must only be made after the differential feed ratio has been changed.



TEST SEWING

Adjusting the thread tension

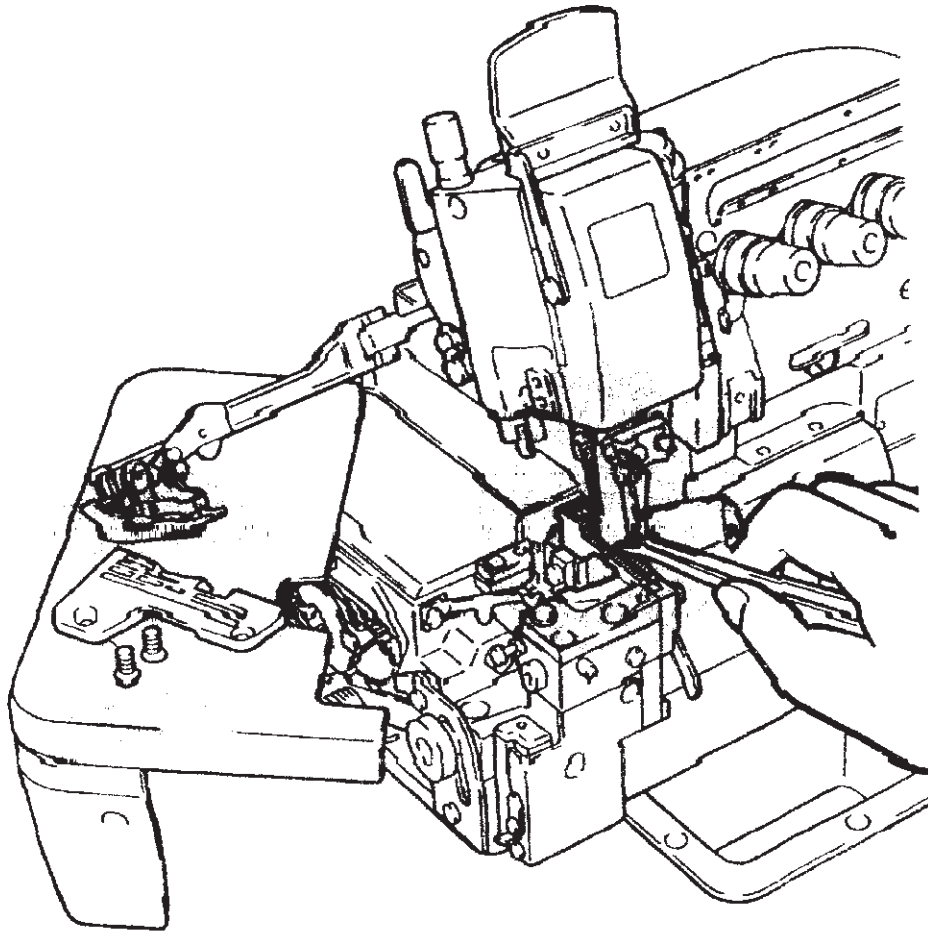
Make tension adjustments with the needle thread knob ①, the upper looper knob ②, and the lower looper knob ③.



MAINTENANCE
DURING USE

Cleaning the machine

Mainly the slots of the needle plate and the feed rows should be cleaned.

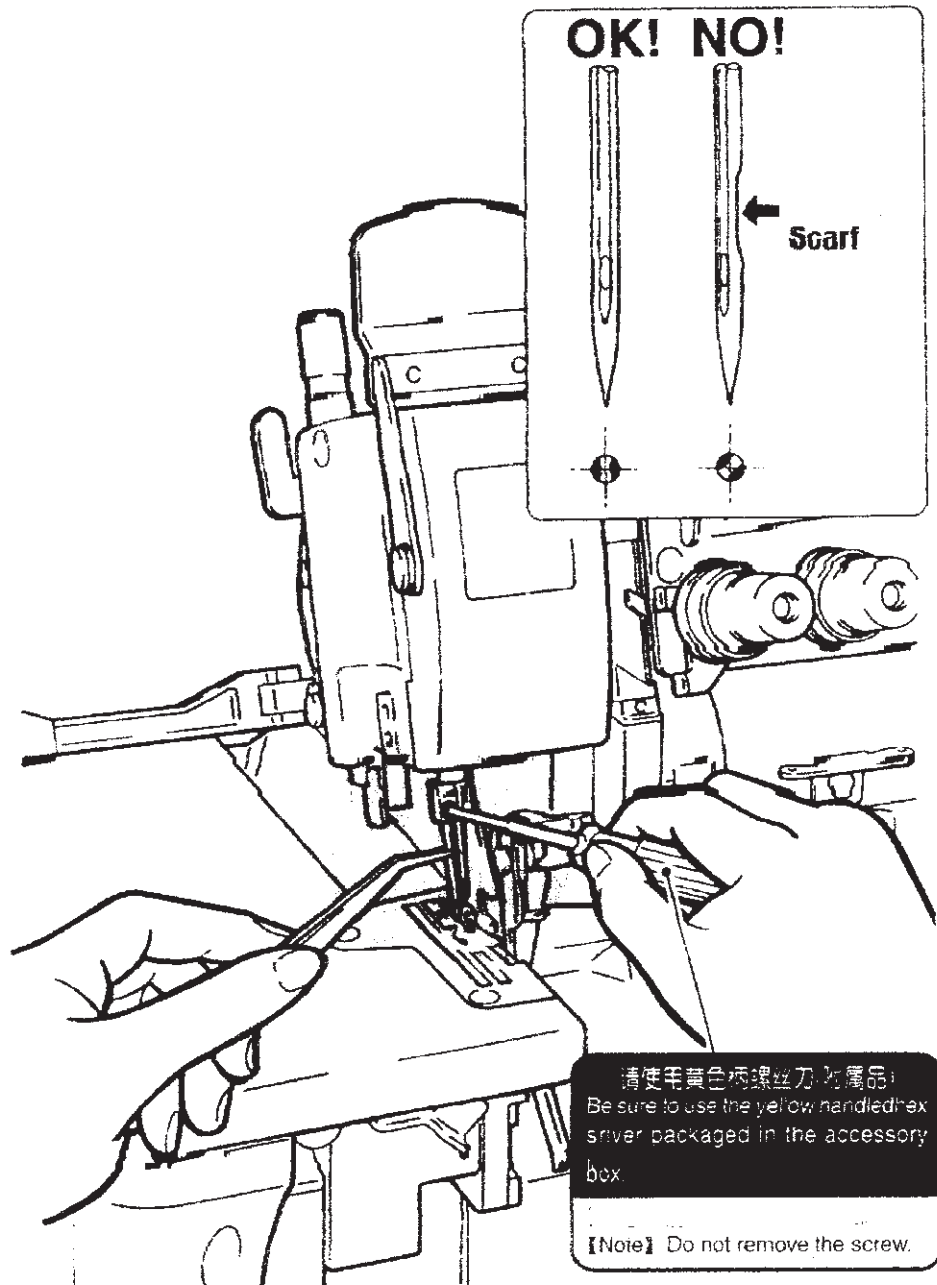


MAINTENANCE
DURING USE

Replacing the needle

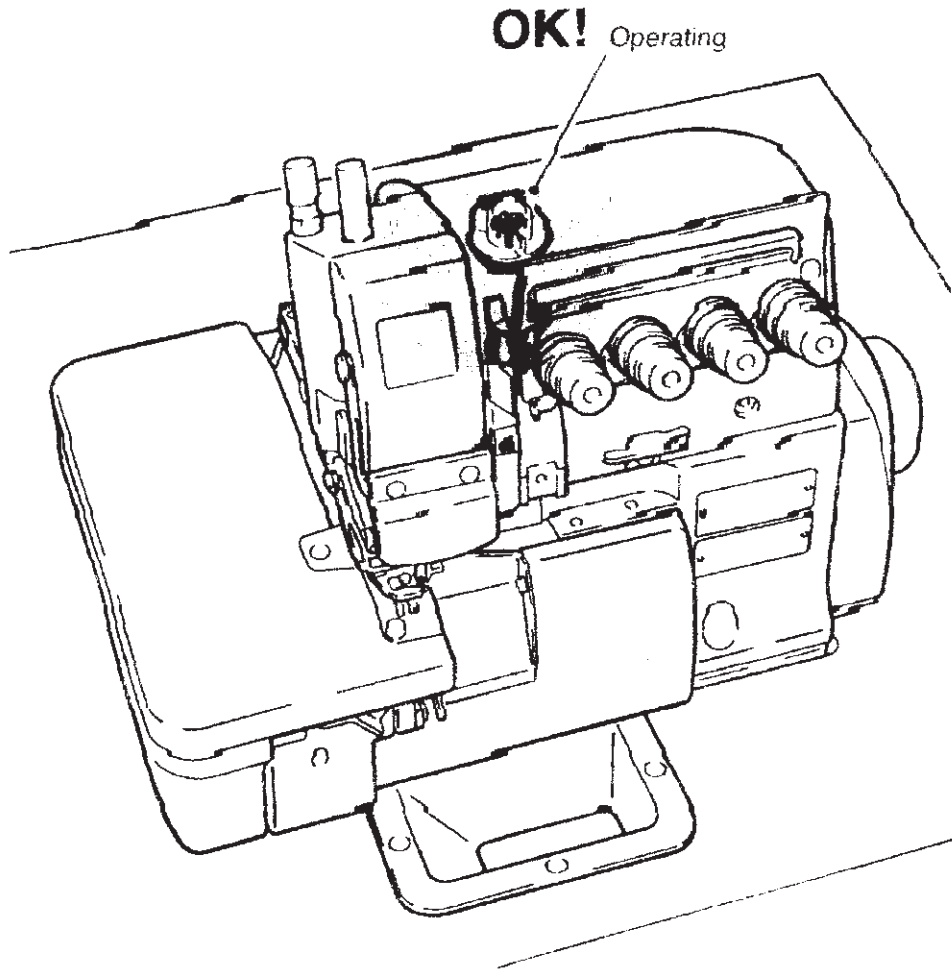
- Check the needle carefully to see that the scarf is turned to the rear of the machine.
- Insert the needle to the proper depth, and fasten securely.

Be sure to use standard needle. Refer to ADJUSTMENT DIMENSIONS on the end of instructions.



MAINTENANCE
DURING USE

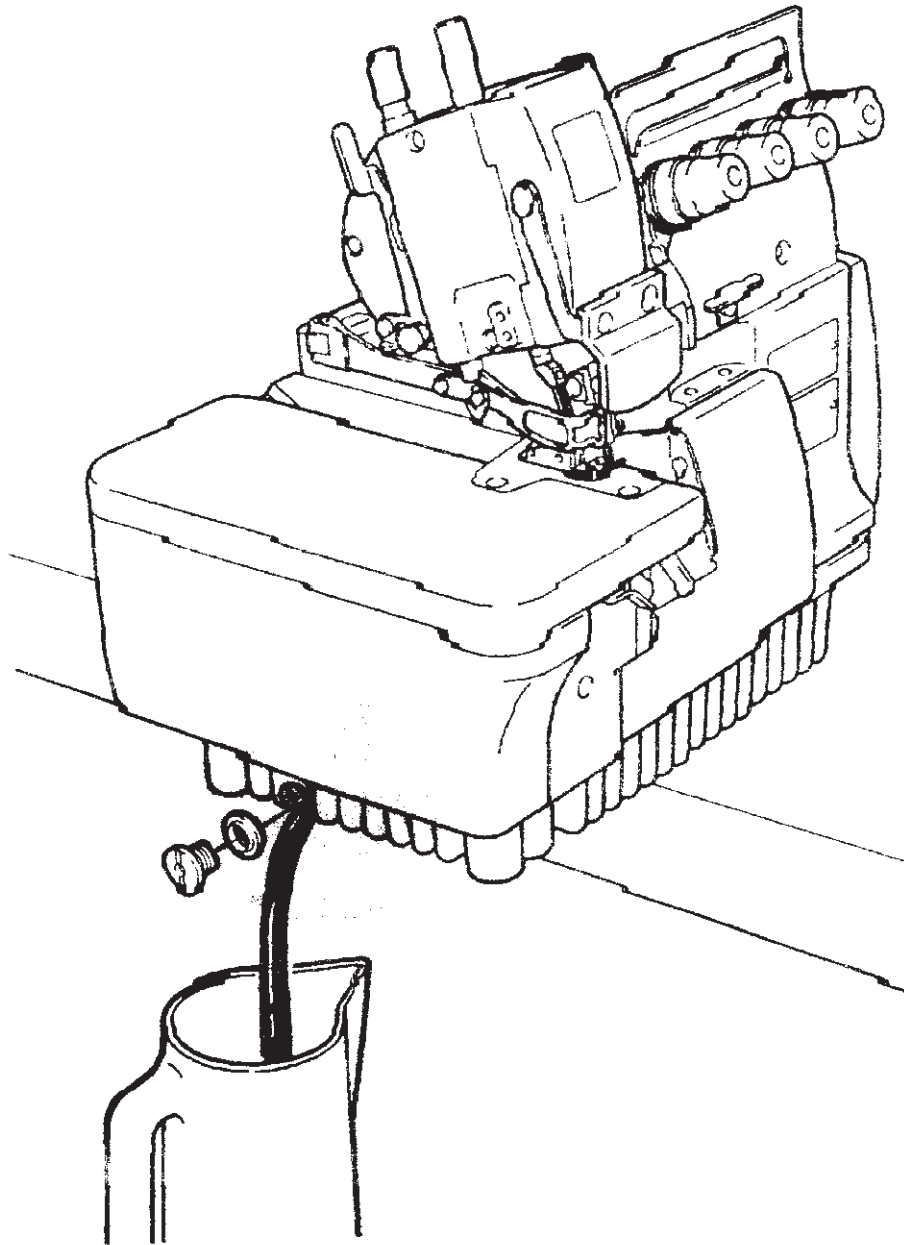
Checking the oil circulation



MAINTENANCE
DURING USE

Replacing the oil

Replace the oil one month after the first use and every six months thereafter. (See P7.)

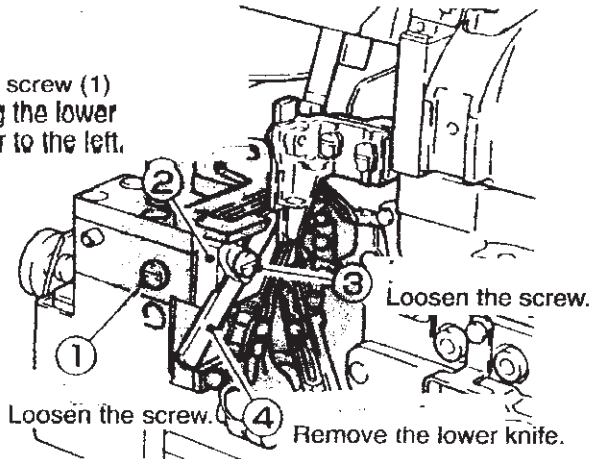


MAINTENANCE
DURING USE

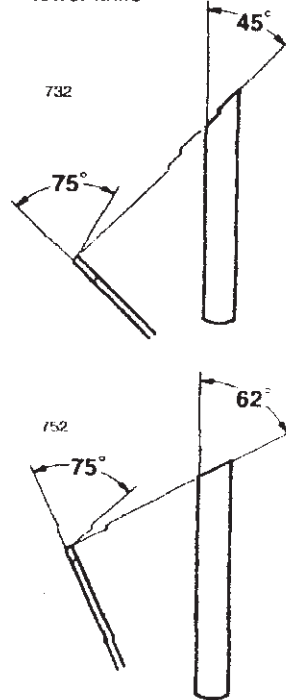
Replacing the lower knife

To remove the lower knife

Temporarily screw (1)
after sliding the lower
knife holder to the left.



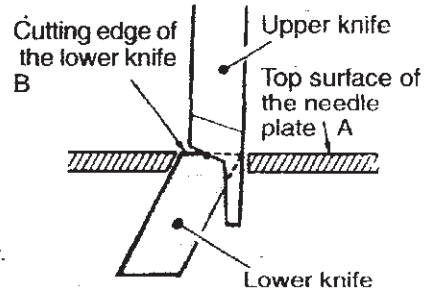
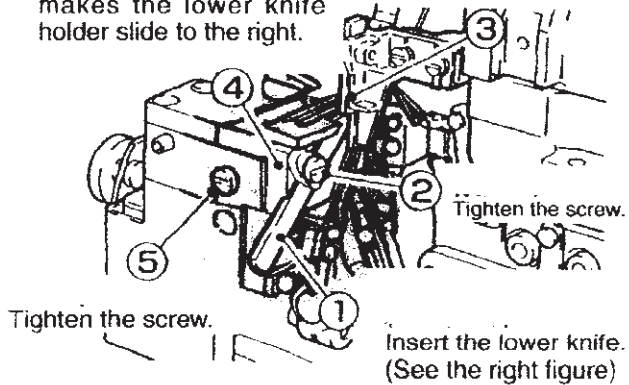
Correct angles to sharpen the
lower knife



To replace the lower knife

Loosening the screw (3)
makes the lower knife
holder slide to the right.

Turn the handwheel
as the drawing on the
right figure.



Level of (A)=Level of (B)

Check cutting action of knives.

732

调整标准表

Adjustment dimensions

(mm)

732-36	10.6	3.9	3.3	0.9~1.1	5.5	1.5			
732-38	10.6	3.9	3.3	0.9~1.1	5.5	1.5			
732-48	10.1	3.9	3.3	0.9~1.1	5.5	1.5			
732-70	10.6	3.9	3.3	0.9~1.1	5.5	1.5			
732-86	12.0	3.4	3.3	0.9~1.1	5.5	1.5			

752

调整标准表

Adjustment dimensions

(mm)

752-01	10.1	4.2	3.3	0.9~1.1	5.5				
752-13	10.1	4.6	4.0	0.9~1.1	5.5				
752-16S2	10.1	4.2	3.3	0.9~1.1	6.0				
752-17	10.1	4.2	3.3	0.9~1.1	5.5				

732

标准使用的缝纫针 Standard needle

	针号 Organ DCX27		
732-36	11		
732-38	14		
732-48	14		
732-70	14		
732-86	21		

752

标准使用的缝纫针 Standard needle

	针号 Organ DCX27		
752-01	9		
752-13	9		
752-16S2	11		
752-17	9		

732 - 752

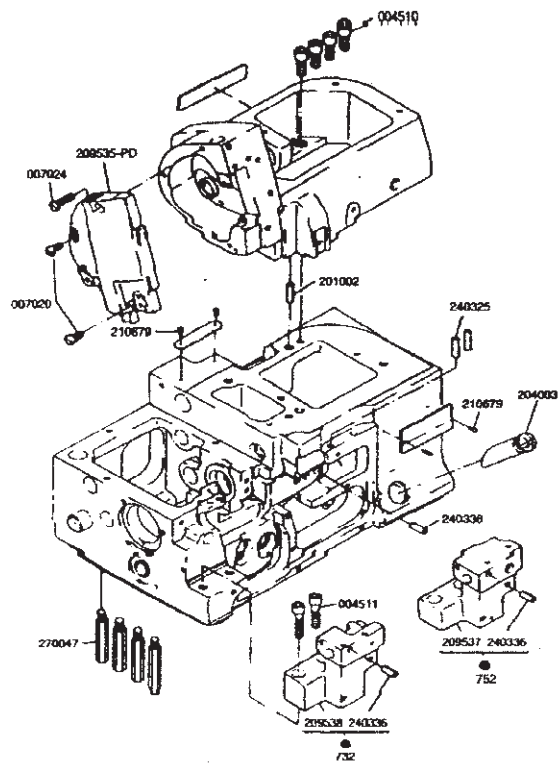
针号对照表 Comparison table of equivalent sizes

日本针号 (Organ) Japanese size (Organ)	#	9	11	14	16	18	21	
中国针号 Chinese size (Organ)	Nm	65	75	90	100	110	130	

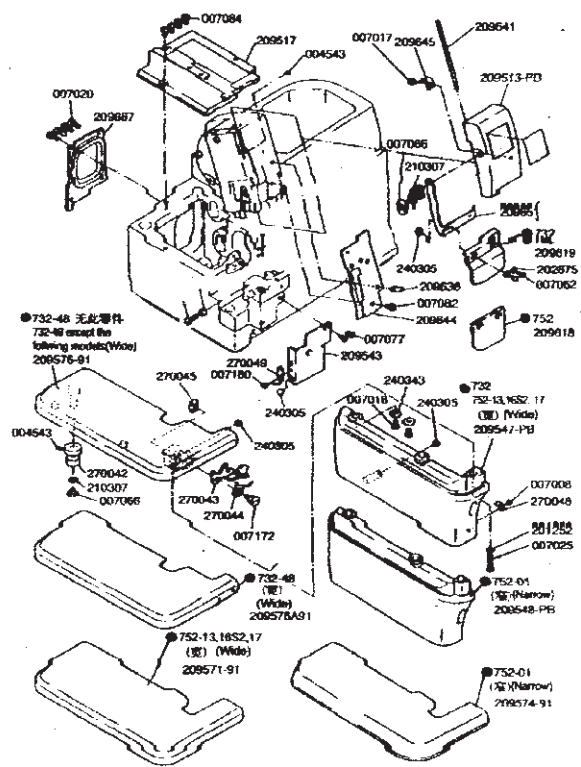
HIGH-SPEED OVERLOCK SEWING MACHINE

PARTS BOOK

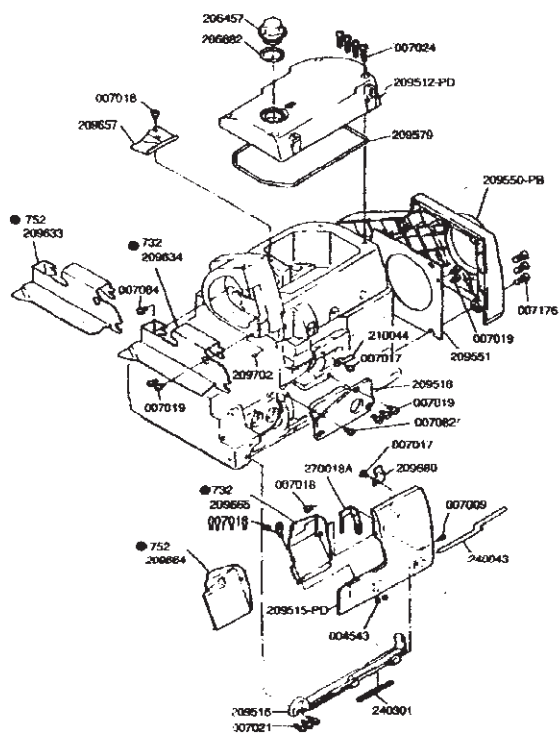
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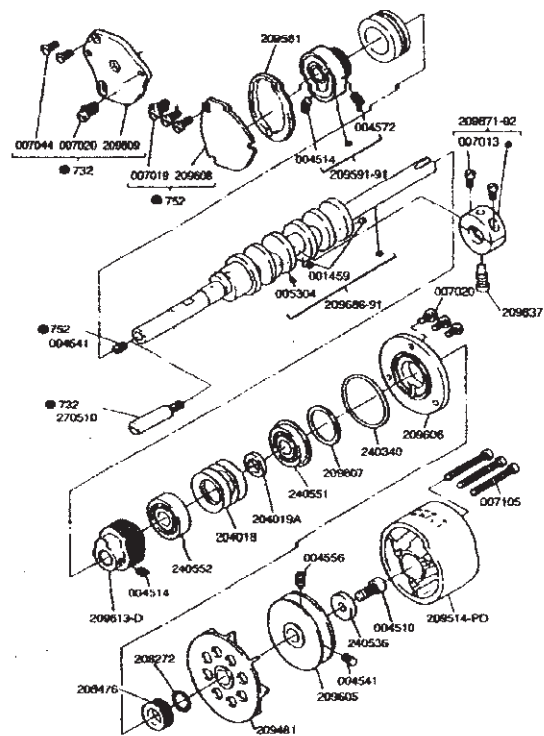
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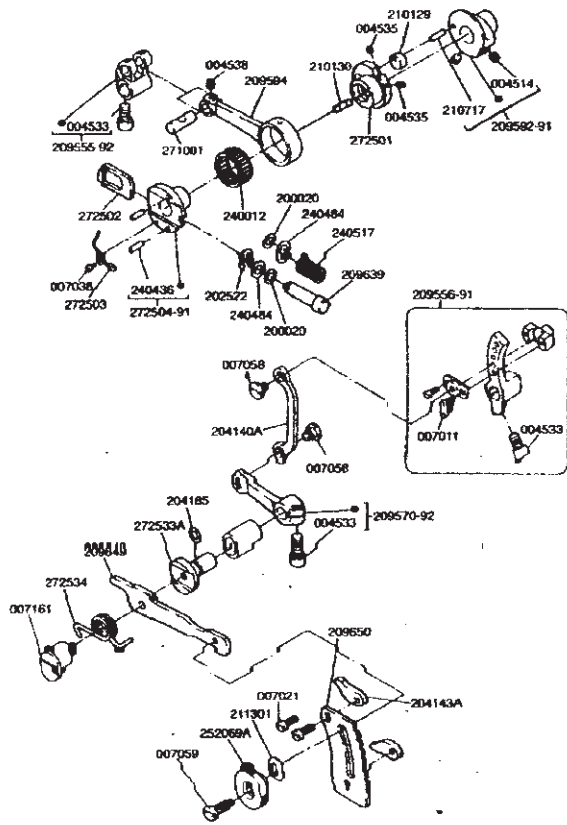
3



4

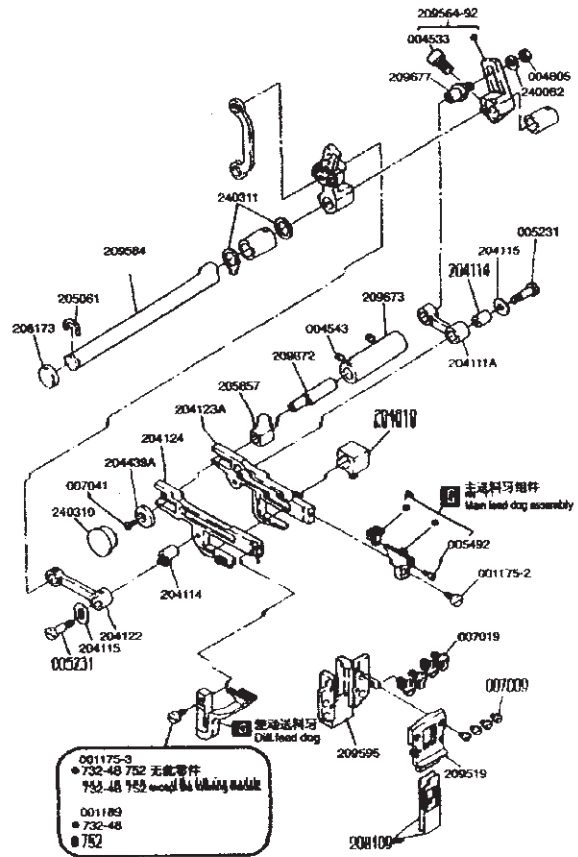


13

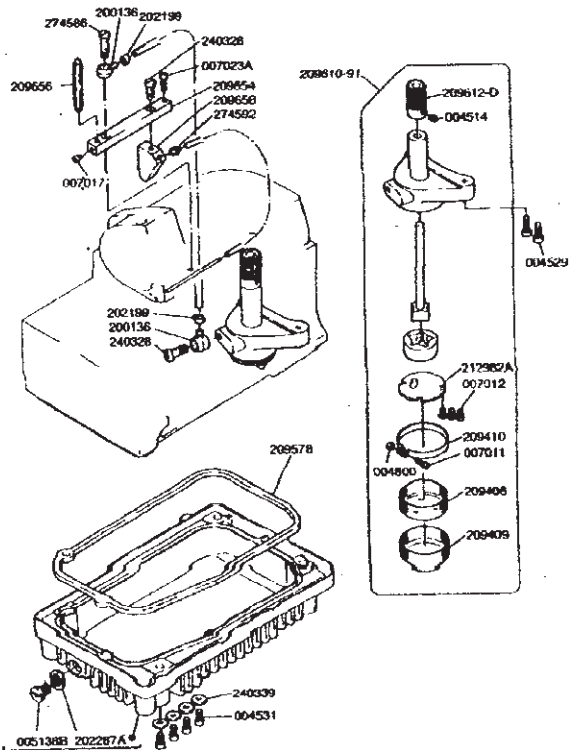


14

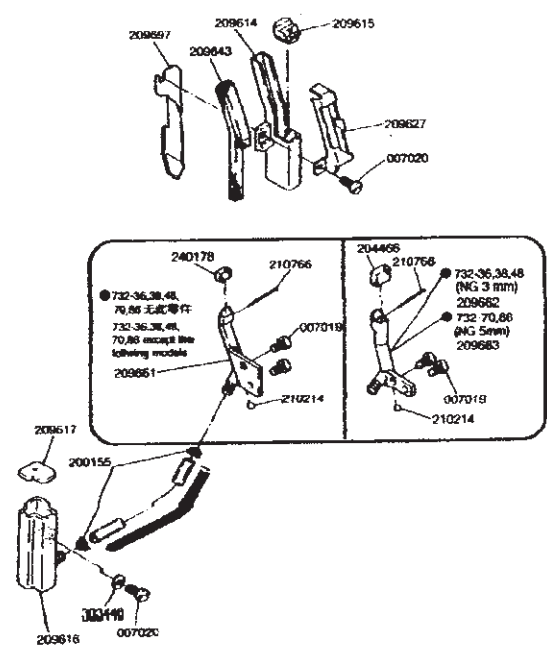
G Please confirm the correct part by the gauge parts lists.



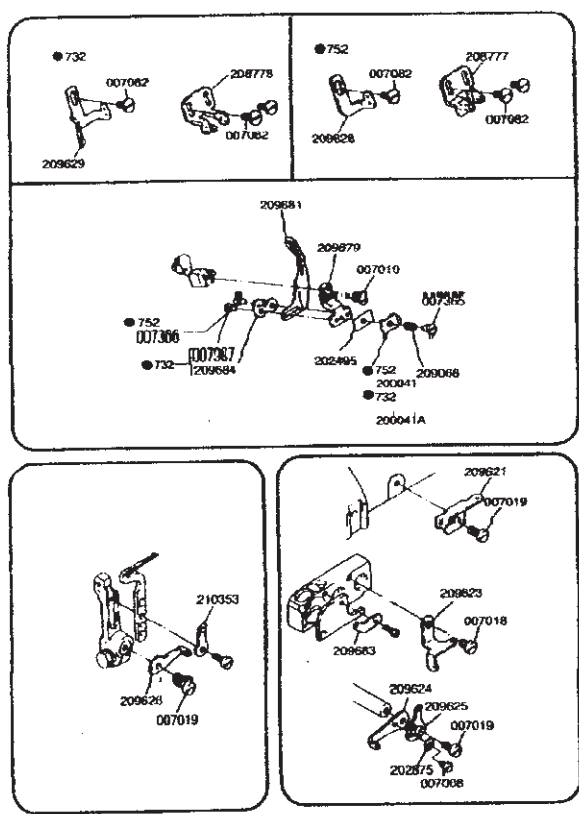
15



16

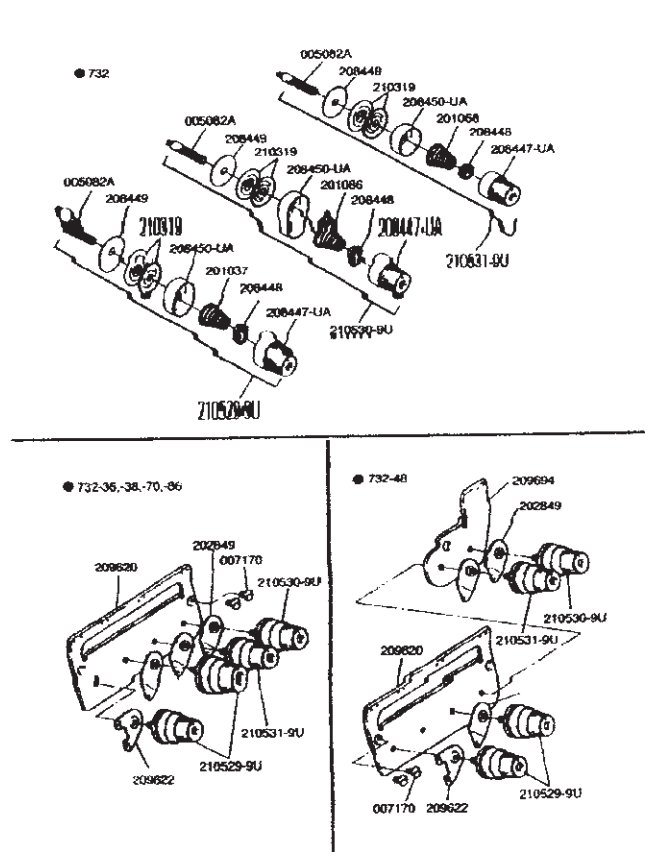


17

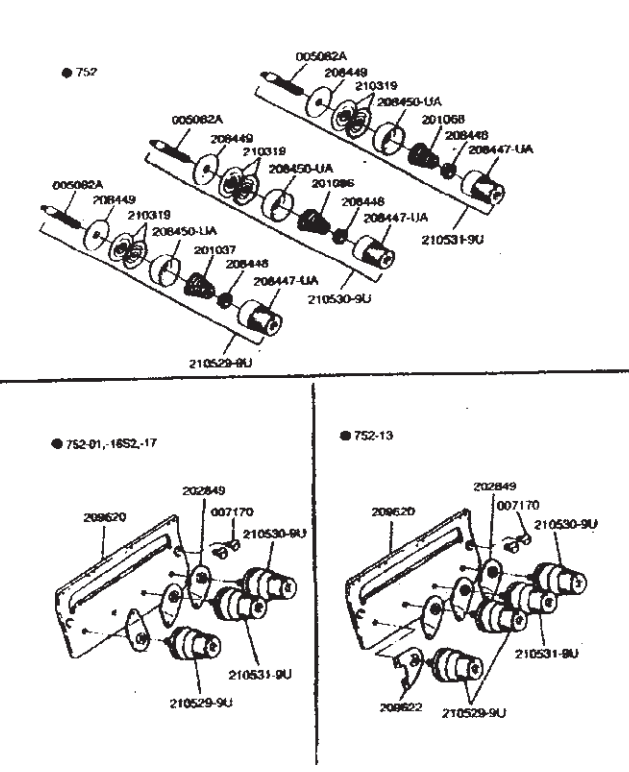


18

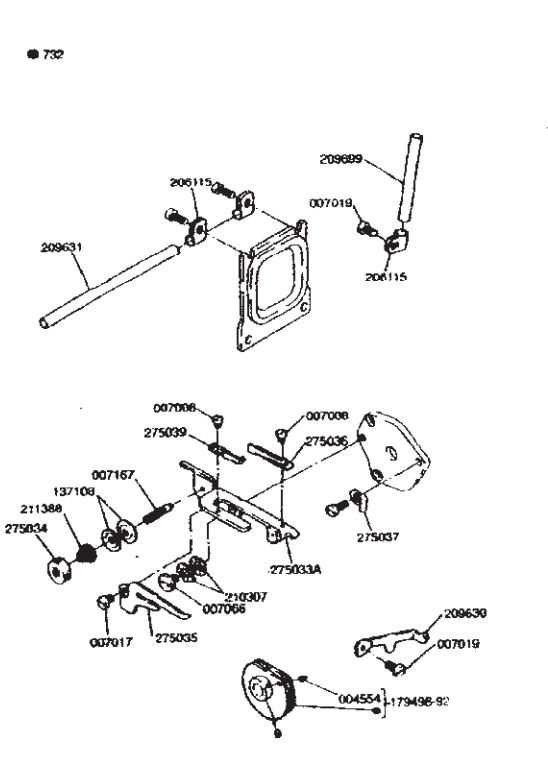
G Please confirm the correct part by the gauge parts lists.



19

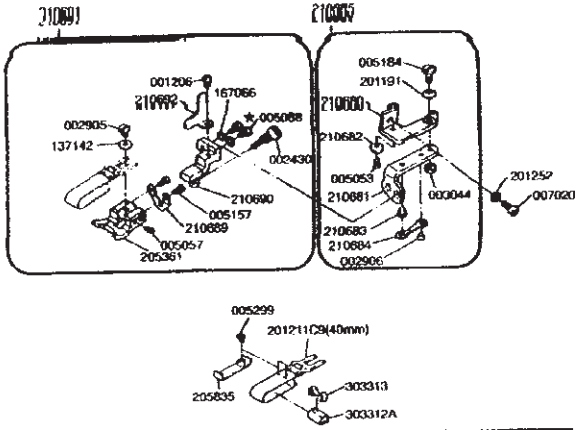


20

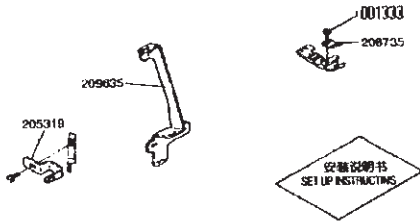


21

邊位 (Band hanging)
● 752-01

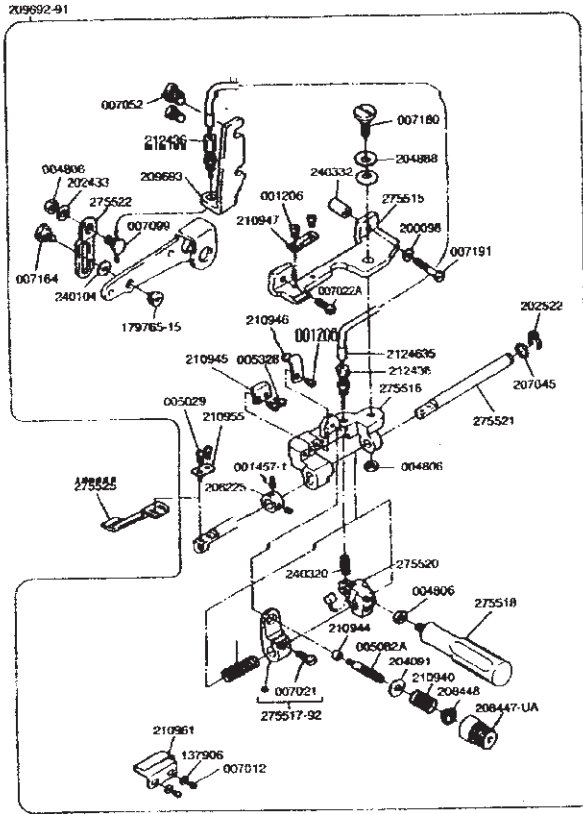


邊位附件 (Attaching tape)
● 752-13

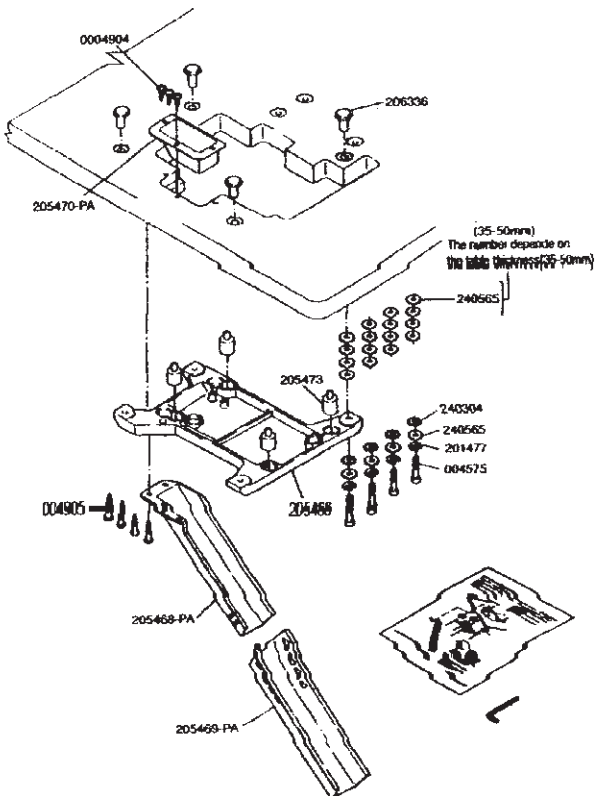


22

蓋蓋 (Shims)
● 732-35

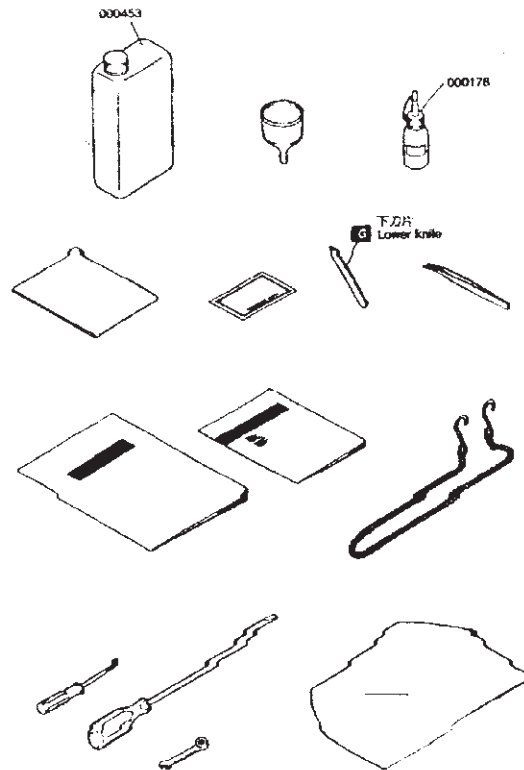


23



24

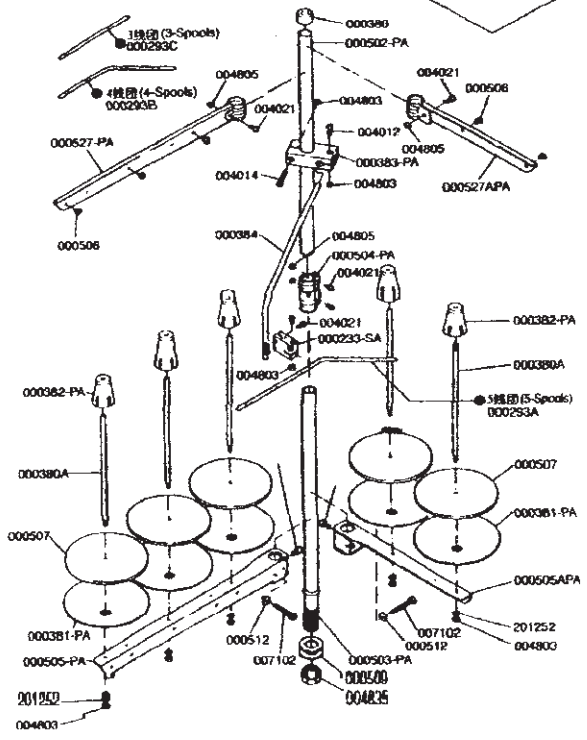
G Please confirm the correct part by the gauge parts lists.



732-01-1052-17
 3轴器(3-Spools)
 000480C9P
 732-13
 4轴器(4-Spools)
 000480B8P

732
 5轴器(5-Spools)
 000480A9P

安装说明书
 SET UP INSTRUCTION



732 GAUGE PARTS LIST

E	Gauge	NG	SW	针板 NEEDLE PLATE	针钩 NEEDLE HOOK	主送料牙 MAIN FEED DOG ASS.	主送料牙 MAIN FEED DOG	脚踏送料牙 CHIFF. FEED DOG	脚踏送料牙 FOOT ASS.	上弯针 UPPER LOOPER	下弯针 LOWER LOOPER	脚踏弯针 CHAMSTITCH LOOPER
3	4	4	4	204367	210505	208065	204365	208218	208501	204062	204072	208686
3	4	4	4	204367	210505	208066	204390	208219	208501	204072	204072	208686
3	4	4	4	204940	210505	208074	204931	208442	208508	204702	204072	208686
5	5	5	5	20490A	210506	208063	204265	208215	208502	204072	204072	208686
5	5	5	5	204929	210508	208064	204394	208217	208555	204703	204072	208686



E	Gauge	NG	SW	下刀片 LOWER KNIFE	上刀片 UPPER KNIFE	脚踏送料牙		针夹		针 NEEDLE
						FRONT	REAR	NEEDLE HOLDER	NEEDLE	
3	4	4	4	204181	204181	204536	204536	2089892	DCX27#11	DCX27#11
3	4	4	4	204181	204181	204536	204536	2089892	DCX27#14	DCX27#14
3	4	4	4	204181	204181	204536	204536	2089892	DCX27#14	DCX27#14
5	5	5	5	204181	204181	204536	204536	2089892	DCX27#14	DCX27#14
5	5	5	5	204181	204181	204536	204536	2089892	DCX27#14	DCX27#14



PE	Gauge	NG	SW	针板 NEEDLE PLATE	针钩 NEEDLE HOOK	主送料牙 MAIN FEED DOG ASS.	主送料牙 MAIN FEED DOG	脚踏送料牙 CHIFF. FEED DOG	脚踏送料牙 FOOT	上弯针 UPPER LOOPER	下弯针 LOWER LOOPER
2	4	4	4	205773	208000-BF <td>204674 <td>204674 <td>204674 <td>208730 <td>204948 <td>204072</td> </td></td></td></td></td>	204674 <td>204674 <td>204674 <td>208730 <td>204948 <td>204072</td> </td></td></td></td>	204674 <td>204674 <td>208730 <td>204948 <td>204072</td> </td></td></td>	204674 <td>208730 <td>204948 <td>204072</td> </td></td>	208730 <td>204948 <td>204072</td> </td>	204948 <td>204072</td>	204072
2	4	4	4	20554E <td>208078-BF <td>204674 <td>204674 <td>204674 <td>208730 <td>204948 <td>204072</td> </td></td></td></td></td></td>	208078-BF <td>204674 <td>204674 <td>204674 <td>208730 <td>204948 <td>204072</td> </td></td></td></td></td>	204674 <td>204674 <td>204674 <td>208730 <td>204948 <td>204072</td> </td></td></td></td>	204674 <td>204674 <td>208730 <td>204948 <td>204072</td> </td></td></td>	204674 <td>208730 <td>204948 <td>204072</td> </td></td>	208730 <td>204948 <td>204072</td> </td>	204948 <td>204072</td>	204072
1.5	4	4	4	20546S	208911 <td>204674 <td>204674 <td>204674 <td>201230C <td>204052 <td>204072</td> </td></td></td></td></td>	204674 <td>204674 <td>204674 <td>201230C <td>204052 <td>204072</td> </td></td></td></td>	204674 <td>204674 <td>201230C <td>204052 <td>204072</td> </td></td></td>	204674 <td>201230C <td>204052 <td>204072</td> </td></td>	201230C <td>204052 <td>204072</td> </td>	204052 <td>204072</td>	204072
1.5	4	4	4	20546E	208076-BF <td>204674 <td>204674 <td>204674 <td>201230C <td>204052 <td>204072</td> </td></td></td></td></td>	204674 <td>204674 <td>204674 <td>201230C <td>204052 <td>204072</td> </td></td></td></td>	204674 <td>204674 <td>201230C <td>204052 <td>204072</td> </td></td></td>	204674 <td>201230C <td>204052 <td>204072</td> </td></td>	201230C <td>204052 <td>204072</td> </td>	204052 <td>204072</td>	204072



PE	Gauge	NG	SW	上刀片 UPPER KNIFE	下刀片 LOWER KNIFE	脚踏送料牙		针夹		针 NEEDLE
						FRONT	REAR	NEEDLE HOLDER	NEEDLE	
4	4	4	4	201121A	2-02295	204659	209009	208670-92	DCX27#9	DCX27#9
2	4	4	4	201121A	2-02295	204659	209009	208670-92	DCX27#9	DCX27#9
1.5	4	4	4	201121A	2-02295	204659	209009	208670-92	DCX27#11	DCX27#11
1.5	4	4	4	201121A	2-02295	204659	209009	208670-92	DCX27#9	DCX27#9