



DDL-227 MODEL DDL-555 SINGLE NEEDLE LOCKSTITCH INDUSTRIAL SEWING MACHINE

INSTRUCTION BOOK

Use instructions book carefully in order to operate it in the correct and efficient manner.

CAUTIONS BEFORE OPERATION

1. Never operate the machine before filling up the oil reservoir with the lubricating oil.
2. Always let the machine run in the reverse direction. (The handwheel must rotate in the counter-clockwise direction when viewed from the pulley side.)
3. Operate the machine at about 4,000 r.p.m. for model DDL-227 and 4,500 r.p.m. for DDL-555 in the first few months after setting up.

CAUTIONS IN OPERATION

1. Never put your fingers under the needle while the machine is "on" or operate the machine.
2. Never put your fingers into the thread take-up lever cover.
3. Never turn to start the handwheel before the machine completes one cycle.
4. Never touch the motor when the motor does not stop immediately after the motor switch is turned "off" due to the moment of inertia. When you lift the machine head back or make some adjustment, wait until the motor completely stops.
5. Never bring your fingers or hair close to, or place anything on the handwheel, V-belt, bottom wheel, wheel or motor during operation. It may lead to serious personal injuries.
6. If your machine is provided with a left cover, finger guard and eye guard, never operate your machine with any of them removed.

1. INSTALLATION



- **Attaching the oil reservoir**
Insert the oil reservoir into the hole in the machine head. It is supported by four screws of the opening in the head. Tighten them with a screwdriver. Then, attach the reservoir to the machine head with four screws. The reservoir is attached to the machine head in a premarked order on the top and always with the same side of the reservoir.

2. LUBRICATION



Insert finger into the hole in the machine head, insert a screwdriver finger on the side and place the machine head so that it seats in the head position in four corners.

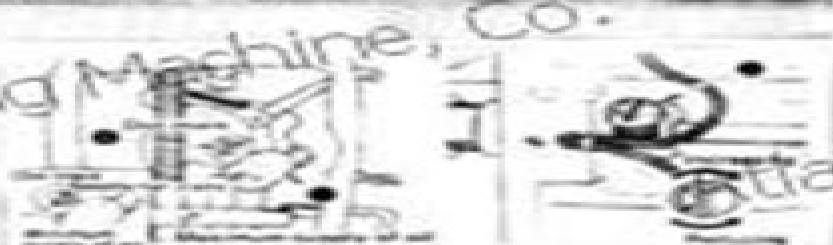
2. LUBRICATION



• Before operating the machine

1. Fill the oil reservoir up to the "FULL" mark indicated on it.
2. Add the oil when the oil level comes down the "LOW" mark.
3. As long as the oil reservoir is properly filled up with the lubricating oil, you will see the oil reflecting on the inner surface of the oil sight window while the machine is running. When the oil sight window is empty, add the lubricating oil to the sight window. When the oil level is low, add the lubricating oil to the sight window.

CAUTION: Do not add oil to the sight window when the machine is running.



• Lubrication of the components in the face plate

The amount of oil fed to the thread take-up lever and the needle bar crank components by adjusting the oiling pump will adjust the oil supply to the components. You want to reduce or increase the oil supply to the components by adjusting the supply of oil.

• Lubrication of the hook components

The amount of oil fed to the hook components is adjusted by turning and adjusting screw. As the hook driving shaft bearing has a clearance of 0.01 to 0.02 mm, the oil supply to the hook components is adjusted by turning and adjusting screw. As the hook driving shaft bearing has a clearance of 0.01 to 0.02 mm, the oil supply to the hook components is adjusted by turning and adjusting screw.

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