

Safety attention

1. When using the machine, please strictly observe the safety measures as the following items.
2. Before using the machine, please read all instructions contained in the instruction manual. Please proper keep the manual so as to consult at anytime .
3. When using this machine, make sure that all the safety devices are installed to the required location. Forbid to use the machine if the safety devices are not in the right position.
4. The machine shall be operated by the trained operator.
5. When using the machine, safety glasses are recommended.
6. Please turn off the power or unplug the power plug when the following cases happen.
 - 6-1 When threading for needle ,looper, separator ,or replace hook .
 - 6-2 When change needle ,presser foot ,needle plate ,looper , separator ,feeding dog , needle guide ,stand ,cloth guideway device .
 - 6-3 When repair
 - 6-4 Nobody in the working site ,or leave working site
7. In case of The oil, lubrication grease used in the machine and the peripheral device flow into eyes or skin, or be drunk mistakenly, please wash and go to hospital.
8. Prohibit to touch the power on/off accessory and devices of the machine with oil hand .
9. The repair, alteration, adjustment about the machine should be carried out by professional staff.
10. General repair and maintenance of the machine should be carried out by trained staff.
11. Repair and maintenance about electrical aspects of the machine should be done by professional staff or experts.
12. When repairing, preserving the accessory about the air, compressed air cylinder , the air compressor to supply source should be cut off.
13. The sewing machines should be regular cleaned while using.
14. The machine should be connected to ground wire for safe operation. It should be used against strong noise such an high-frequency welding machine.
15. Electrical power plug should be installed by trained staff. Power plug must be connected to the grounding receptacle
16. Sewing machine can not be used other than the designated purpose.
17. Alteration and modification of the machine should be accorded to safety requirements and effective safety measures should be taken. In addition, we assume no responsibility for alteration and modification.
18. The instructions using the following two warning signs.

Safety instruction



Dangerous to operators, maintenance staff.



Special attention needed for safety.

Precautions for safety use of the machine



Dangerous

1. To prevent electric shock, please do not open the shell of the control box or touch the control box parts when power on.



caution

1. Please do not operate the machine when the safety devices ,such as, belt cover, eye protective cover are unload ,to prevent personal injury.
2. To prevent operator being rolled into machine to cause life accidents , please use those motor with motor protection cover .
3. Please do not operate the machine when the power ground wire is took away ,to avoid electric shock.
4. To prevent operator to be rolled into machine to cause life accidents , please do not put your fingers, hair, clothes near the belt pulley when the machine is running , and do not put anything above the machine.
5. To prevent personal injury, please don't let your fingers near to cloth cutting and needle after turning on the power or the machine in operation.
6. To prevent personal injury, when the machine is in operation, do not put your finger in the eye shield.
- 7.To prevent electric shock, electric leakage, fire accident, be sure to turn off the power of the sewing machine before unplug or insert the power plug with your hand.
8. To prevent personal injury due to sudden starts, be sure to turn off the power when leaving the machine.
9. To prevent personal injury due to machine sudden starts, turn off the power after a power outage.
10. In order to prevent personal injury due to machine sudden start, when disassembling motor shield, be sure to turn off the power and the foot pedal is firmly fixed.
11. To prevent personal injury due to sudden starts, when repair, adjusting, removing, threading, replacing stitch, be sure to turn off the power , and the foot pedal is firmly fixed.
- 12.To prevent personal injury due to falling the machine, please do not hand carry shield cover when sewing machine. Take shield cover off, the shield will open, this will result in the falling of the machine.

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1. preface




- This instruction manual describes how to use our products safely.
- Read this instruction manual and learn very carefully how to operate, adjust and service this sewing machine before beginning any of the procedures.

2. Warning label









To prevent accidents and ensure safety, warning indications which show the degree of danger are used on our products and in this manual.

Follow all warnings and instructions. Indication labels should be found easily. Attach new labels when they are stained or removed. Contact our sales department when new labels are needed.

Symbols, signs and/or signal words which attract users`attention

 DANGER	Indicates an immediate hazard to life or limb.
 WARNING	Indicates a potential hazard to life or limb.
 CAUTION	Indicates a possible mistake that could result in injury or damage

Symbols and messages

	Be sure to follow the instructions when operate the machine.
	It`s dangerous to get an electrical shock.
	It`s dangerous to injure your hands or fingers.
	Indicates a danger of burn injury due to high temperature.
	Never do this.
	Shut off the power when checking, adjusting and repairing the machine or when lightning may strike.
	Be sure to ground the machine and labor saying device securely.
	Denotes the normal rotating direction of the machine pully.

3. Safety measures

➤ Using environment

The environment in which our industrial sewing machines are used may seriously affect their lives, functions, performance and/or safety.



For safety protection, please don't use machine in the following environment

1. Do not use the machine near objects which make noise such as a high-frequency welder, etc.
2. Do not use or store the machine in the air which has vapor from chemicals, or do not expose the device to chemicals.
3. Do not leave the machine outside, in high temperatures or the direct sun.
4. Do not use the machine in the places of high ambient temperature and humidity that seriously affects sewing machines.
5. Do not use the machine on the condition that the voltage fluctuation range is more than $\pm 10\%$ of the rated voltage.
6. Do not use the machine in the place where the supply voltage specified for the control motor cannot be properly obtained.

➤ Safety measures



(1) Safety protection during maintenance and examine of machines

- Always turn off the power unplug the machine and then make sure that the machine does not run by pressing the treadle before performing any maintenance, such as checking, repairing, cleaning, etc. However, if you need to perform these procedures with the power on, to prevent accidents due to the unexpected start of the machine and users' misoperation, establish your own procedures for safely and follow them.
- Always turn off the power and unplug the machine before performing the procedures shown below.
 - Add oil
 - Threading
 - Clean sewing machine
 - Change needle
 - Clean and replace the oil supply component
 - Change machine oil
- Please turn off the power switch before the following action
 - Adjust stitch
 - Adjust different stitch ratio
- Only well-trained people should perform routine daily maintenance and/or repair the machine.



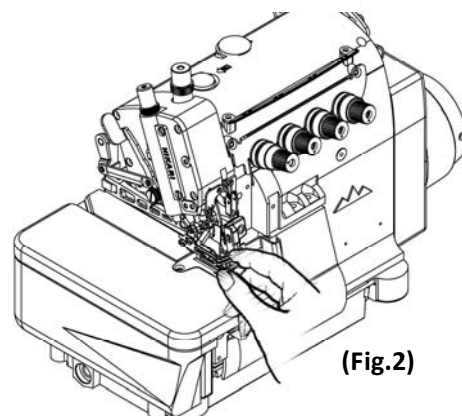
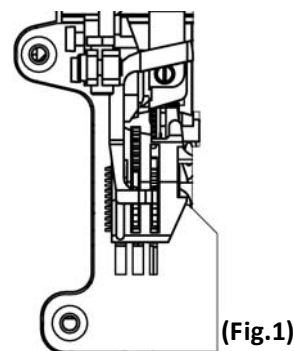
- Do not modify the machine yourself.

※Consult your local Hikari sales office or representative for modification.



(2) Before operating the machine

- Check the machine head and unit for any damage and/or faulty function at the start of each day. If there should be something wrong with the machine, immediately perform repair and/or other necessary procedures
- Make sure the thimble is fixed well
 - ※Be care of the needle point
- Before starting the machine, make sure that the presser foot is positioned correctly(turn the machine pulley slowly by hand to see if the needle point is centered in the needle drop hole on the presser)(Fig.1)
- Check to see if the presser foot is secured(raise the presser foot by the foot lifter and press it by hand front to back and left to right)(Fig.2)



(3) Training

- To prevent accidents, operators and service/maintenance personnel should have proper knowledge and skills for safe operation. To ensure so, managers must design and conduct training for these people.

4. All attention matters in following operation

➤ Open carton

1. The machine is packaged in a cardboard box before shipping. Unpack your machine in orderly sequence while checking them right-side up by referring to the indications, such as logo, etc. printed on the boxes.
2. When take off the machine head from the cushion packing material , don't bring up those parts of machine needle or thread line device , or will happen dangerous or damage machine.
3. When take off machine head , please take care of the centrybaric position , be careful to take off .
4. Keep the cardboard box and packing carefully in case secondary transport is needed in the future.

Disposal of the packaging

- The packaging material of the machine consists of wood, paper, cardboard and VCE fiber. The proper disposal of the packaging is the responsibility of the customer.

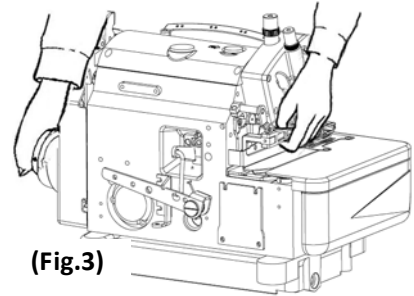
Disposal of machine waste

1. Customer take responsibility to dispose sewing machine waste
 2. Some material like steel , aluminum ,zinc etc which used to make sewing machine
 3. The disposal of sewing machine waste should obey the rule of local environmental protection department .in necessity ,please ask help from special factory to dispose these waste .
- ※For some oiled parts ,please make disposal according to the regulation of local environmental protection .

warning

➤ transportation

1. Need two above person to carry sewing machine head .moreover , only sewing machine table can be carried by small trolley by people.
2. When move machine head , use right hand to hold the handwheel and motor cover , use left hand hold machine head ,to lift up with smoothly and fasten . (Fig.3) When sewing machine is stained with oil ,it is easy to slip from hand to be broken when carry it ,please clean well the oil before carry machine .
3. When carry machine table or carry machine by small trolley ,please note that don't powerful strike or shock ,so as to avoid sewing machine slope to cause danger .
4. If need re-transport sewing machine and make packing , please clean oil from machine head . otherwise ,the machine will slip away to broken machine head or the oil will deteriorate the packing material .



(Fig.3)

warning



➤ Install and preparation

sewing machine table

1. Please use those machine table which can hard enough to bear the weight of sewing machine head and the reactive force when carry machine .(table ,brandrich)
2. Please sufficient in consider the brightness of sewing machine parts and operation light ,put machine in easy-operation environment .if the brightness is not enough , please install lamp according to requirement .
3. When operate sewing machine , in order to avoid accident caused by slide foot from pedal ,so must install anti-skidding mat on the pedal .
4. According to the operator's pose , adjust the height of table (working status height)


warning

Wiring

1. Please check up the wire plug which connect machine head and motor .
Use wire to connect sewing machine head and motor ,make sure the power is off .
2. Don't put strong force when wiring .
3.  Don't overbending wire .
4. Close to the connection wire from moving parts , keep at least 25mm away to install .
5. In necessity , consider the connection location or put protection cover to protect the connection wire .
6.  Don't use pin when connect wires .


 **warning**

Grounding

1. Each special ground wire is used for each sewing machine only , can not used for other sewing machine .
2.  Correctly install ground wire in the right place of machine head .

 **Warning**


➤ **Use sewing machine oil**

1. Don't operate machine before inject oil to the oil tray .pls use the exclusive lubricate oil for sewing machine .(equivalent ISO viscosity grade VG22)
2. Please wear protective glasses to avoid the machine oil enter into eyes and cause eye inflammation .
※In case ,the oil enter into eyes, please use water to wash at 15 minutes ,and go to doctor .
3. If skin touch machine oil , please use water and soap to wash immediately .
4.  Never allow machine oil enter into mouth .
5. Please keep the machine oil away from the place that kids can reach . in case the oil enter into mouth ,don't emesis , ask for doctor immediately .
6. Please correctly dispose the waste oil ,container according to the disposal measures from environmental protection law .if don't know the law ,pls contact the local agent ,and then make disposal .
7. In order to prevent dusty ,moisture from mix in ,please fasten down the oil tank cover to store oil after work , put in the shade place to keep .

 **Warning**

➤ **Attention matters before operate sewing machine**



Sewing machine table

1. Please make sure the connection wire or wire contact without damage ,shed ,lossen before power on .
2.  Don't put hands around machine needle or trimmer when power on .
3. The operator must had been trained and full understand this book and operation manual before they operate machine .
4. Must familiar and understand the dangerous and warning labels , when necessary , should make safety education toward the operators .
5. In the beginning use of the first month ,should reduce the operation speed . please use the three fourth of the max speed .



Warning

➤ attention matters when operating sewing machine .

1.  After take off the eyeshield board ,fingershield support ,transmission cover , don't operate sewing machine .
2.  Sewing machine is running is very dangerous , don't put hands under machine needle .
3. Sewing machine is running is very dangerous , make sure don't let finger ,hair ,cloth close to needle bar and automatic trimmer device .
4. When don't use sewing machine or leave sewing machine , please power off .
5. When power cut , please turn off power .
6. When operate sewing machine , don't wear some cloth which is easy to be rolling into machines .
7. When machine is running , don't put tools or some irrelevant items on machine table .

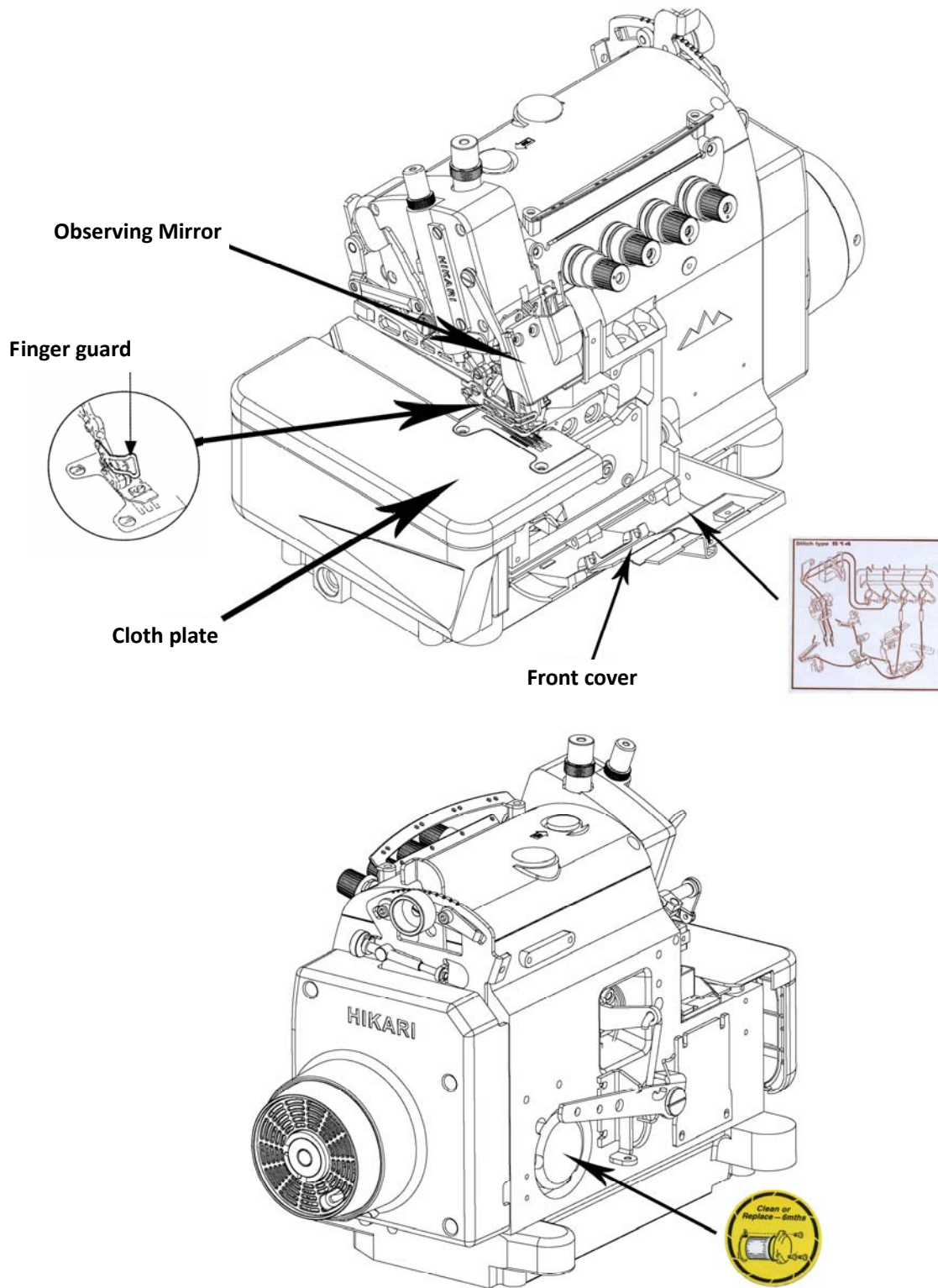


Note

➤ **maintenance ,inspection ,repair**

1. The work of maintenance ,inspection ,repair need some one who is gained special training and full understand this book and operation manual .
2. Please turn off power before lay down machine head to maintain ,check up ,repair sewing machine , unplug the power plug from socket , and make sure to operate sewing machine only in the condition that even use foot to press pedal ,the machine can not running .
3. For routing inspection and regular inspection toward sewing machine head ,please according to the instruction of operation manual .
4. Please use the original parts to repair and change parts , our company will not take responsibility for accidents which caused by improper repair or use fake and poor quality parts.
5. Don't modify sewing machine according to customer' judgment, otherwise our company don't take responsibility for accidents caused by this .
6. For the purpose of temporary repair ,adjustment to disassemble safety device ,safety protective shield , after work, please reinstall according to the original state .
7. After finish work of maintain ,inspection and repair sewing machine , please check-up whether it is safe after switch-on power .

5.The position of warning label and safety protective device



(Fig.4)

6. Safety protective device

This program is composed to let you know all the safety protective device , and record all the attention matters .

Note

Safety protective device

➤ Eye shield board

 Don't open

For the eye safety purpose , don't open the eye shield board when operate sewing machine . eye shield board is the eye shield cover which can avoid the broken needle fly into eyes .

➤ Finger protective support

 Don't stretch hands into

In order to avoid the danger that operator contact the up-down moving needle , install finger protective support around needle . but , above the finger protective support reserve space to convenient threading , if stretch finger into the space , there may be the danger that needle spur into finger .

➤ Presser foot

 Don't stretch hands into


The distance from surface of needle plate and presser foot is above 5mm , there have danger of clamp finger in this space .when use knee contact to lift presser foot or use foot press pedal for automatic presser foot lift , don't stretch finger to the presser foot .

➤ Front protective cover

 Don't stretch hands into

Look from front side of sewing machine ,the looper is moving in the circular motion . in order to avoid the looper contact operator , must operate sewing machine on the condition that the front cover is closed .

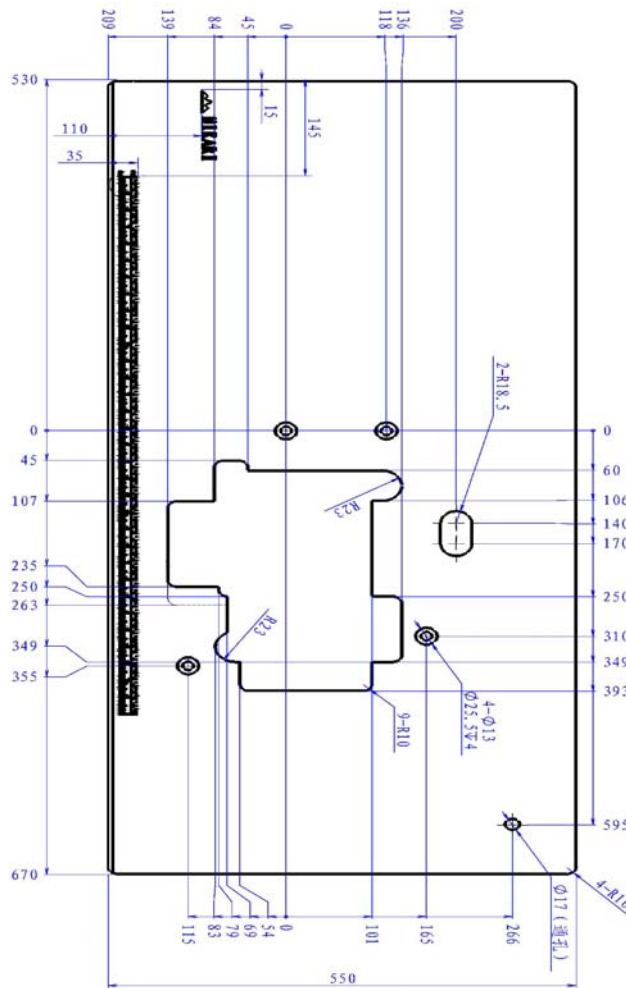
➤ big cover

 Don't open

When mahine is running , in order to avoid the looper thread routing camshaft to contact with looper , please close the big cover .

7. General matters in daily operation

➤ drawing of table



(Fig.5)

Safety instruction

➤ regarding oil supply



note

When add or change machine oil , please use the oil supplied by our company . if use oil from other company , may damage sewing machine .

1. oil category

Use we supplied “HIGH SPEED SEWING MACHINE OIL ”(high speed low viscosity lubrication oil)(ISO viscosity/VG22)

2. the method of supply(Fig.6)

Open the cover of oil supply mouth, add oil to the oil level between oil scale H and L .after adding oil ,cover the oil supply mouth .

3. The required amount of oil (Fig.6)

The H line and L line of The oil scale 2 marks the maximum oil amount and minimum oil amount .

In order to normally keep oil amunt between H line and L line , please often check and add oil .

4. Use hand to add oil (Fig.7)



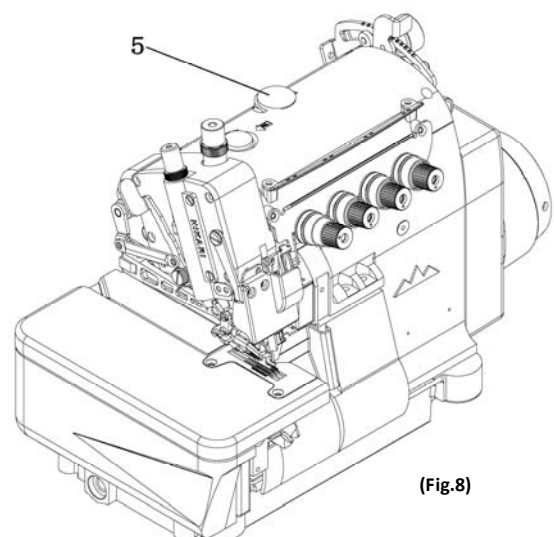
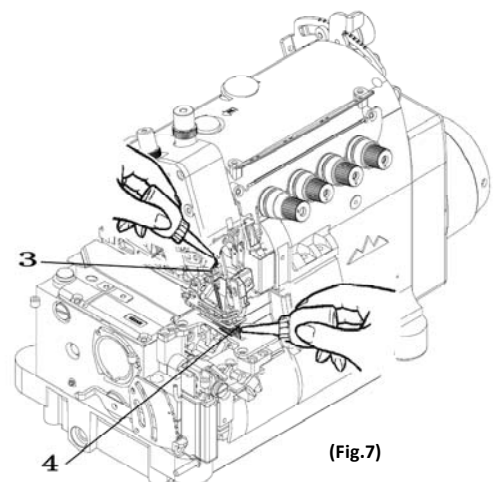
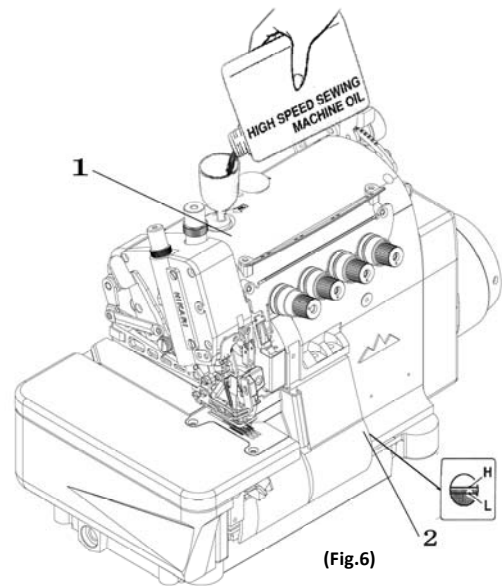
note

Before add oil by hands , please turn off the power ,and unplug the plug from socket

It is the first time to use sewing machine , or it is a period of time to use sewing machine again , please use oil supply bottle to add 2-3 drip of oil to the needle bar 3 and upper looper 4.

5. check the machine oil circulation condition (Fig.8)

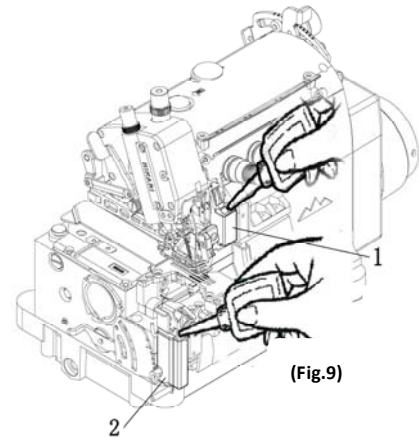
After add oil , press the sewing machine pedal , make machine running , check the oil circulation by oil window 5.



➤ supply oil for HR device

note

Before supply oil for HR device , please turn off the power , unplug the plug from socket . often check and supplement silicone for the silicone oil box 1 and 2 ,to avoid the thread broken caused by the neele in lack of silicone oil . (Fig.9)



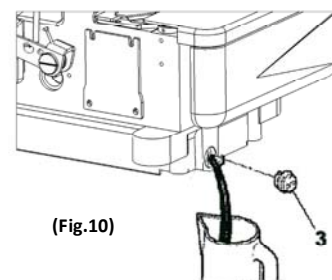
➤ change machne oil

note

Need professional technician to change oil . Sewing machine need change oil after one month in the first using ,after please change oil every six month . if don't change oil , the sewing machine may break down .

➤ the method of oil extraction

1. Please unscrew the screw 3 of the oil extraction hole on the oil tank base ,drain out the old oil .
2. After oil extraction , please fasten the screw 3. (Fig.10)



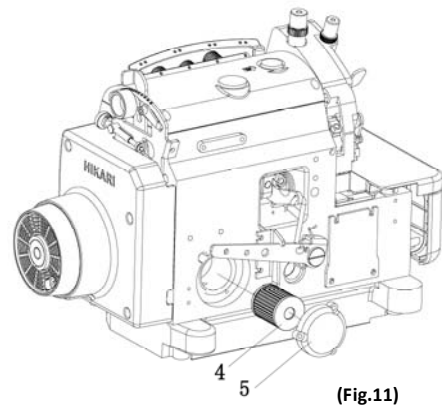
➤ maintenance and change filter

note

When maintenance and change filter ,please turn off the power ,unplug the plug from socket , require professional technician to operate . When the filter is block by wate material , the filter would not normally work . please Disassemble the filter 4 , make clean and change .

To renmove the filter(Fig.11)

Please refer the drawing , after disassemble 4-5, Check the filter . when find the fiter have badly scar , please change the filter .

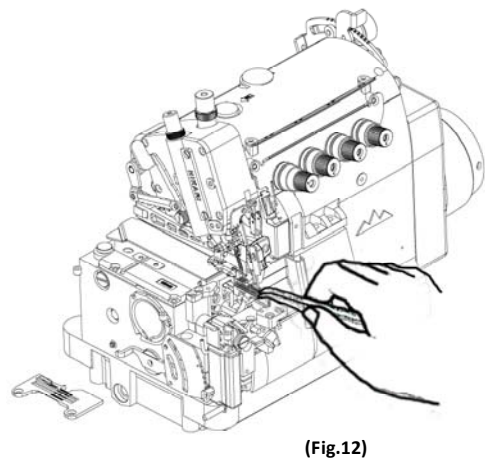


➤ clean the sewing machine

note

Before clean the sewing machine , pleae turn off the power , unplug the plug from socket .

Please clean the empty slot of the needle plate and feed dog . (Fig.12)

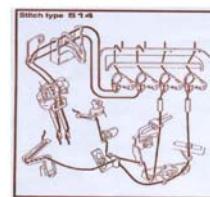
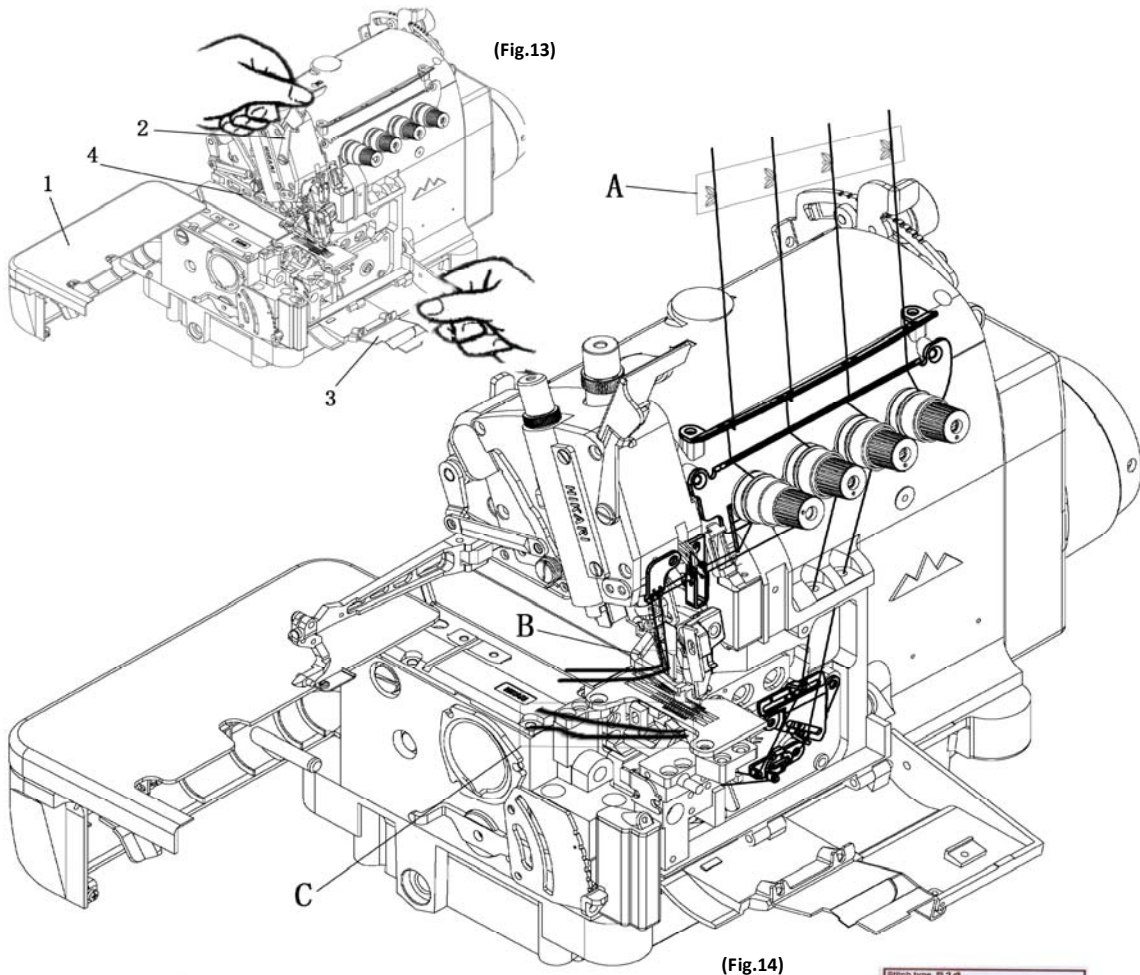


Safety instruction

➤ method of threading

note

Before threading , please turn off the power ,and unplug the plug from socket .



1. Open the big cover 1,eye shield cover 2,front cover3,the arm of presser foot 4. After threading , please restore to the original place .(Fig 13)

2. If already threading (Fig 14)

A:please connect the already threading and the sewing machine threading .

B: needles thread

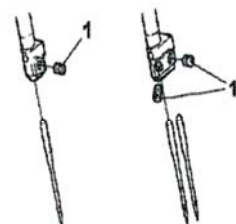
 Cutting the joint head first ,then threading .

C: looper thread ,chain stitch looper thread

3. Threading according to the threading drawing

➤ change needle

note

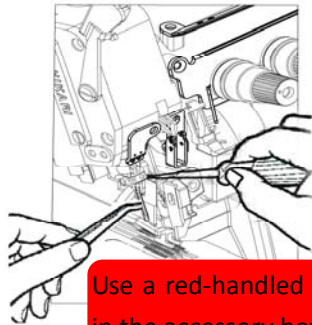


(Fig.15)

Before change needle , please turn off the power , unplug the plug from power socket . Please loosen the screw 1 (but don't pull off the screw) to change needlw .

(Fig 15,16)

When install needles ,please place the the groove parts of the needle to the right astern ,insert the needle to the end of the thimble ,fasten the screw 1.(Fig17)



(Fig.16)

Use a red-handled acrewdriver in the accessory box.

➤ the adjustment of thread tension .

Please use thread ajsument knob , upper looper adjustment knob and down looper adjustment knob to adjust the thread tension .(drawing 18) To turn by clockwise direction to tense the thread , to turn by anti-clockwise to loose the thread .in the condition that realize beautiful sewing stitch , it is better to adopt more loosen thread clamp status .

➤ open and close the automatic presser foot lift

⚠ note

before open and close automatic preffer foot lifer , please turn off the power ,and unplug the plug from power socket .

When open presser fott ,(Fig 19)

1. Turn the handwheel , place the needle at the toppest position .
2. Press the presser foot switch handle 1, open the arm of presser foot lifter 2 .

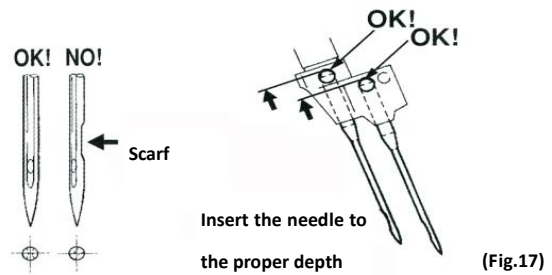
When close the presser foot ,(Fig 19)

1. Turn the handlewheel , place the needle to the toppest position .
2. Press the presser foot switch handle 1, return the arm of presser foot lifter to the original place .

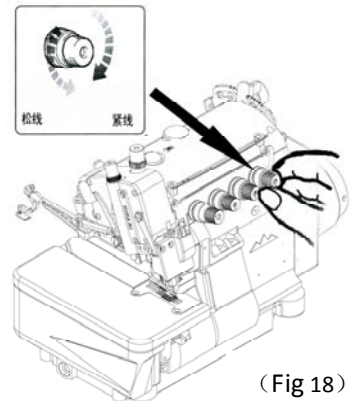
➤ the adjustment of press strength of presser foot

Under the condition that the feeding fabric can normal conduct , and can sewing stable stitch , try to use smaller press strength .

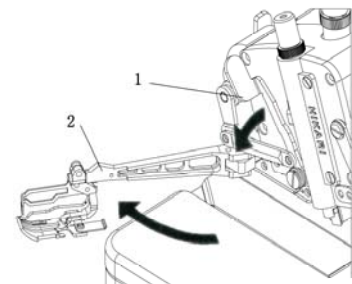
Turn the adjustment screw 3 to adjust the press strength of presser foot .(Fig 20)



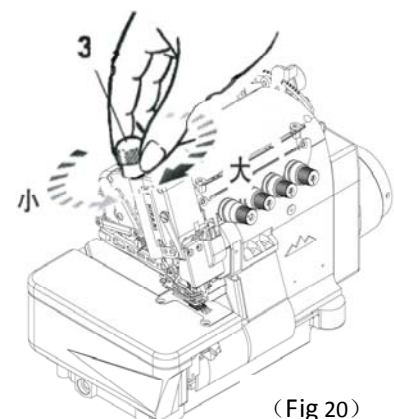
(Fig.17)



(Fig 18)



(Fig 19)

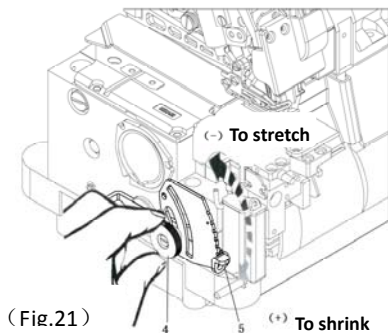


(Fig 20)

Safety instruction

➤ The adjustment of differential ratio

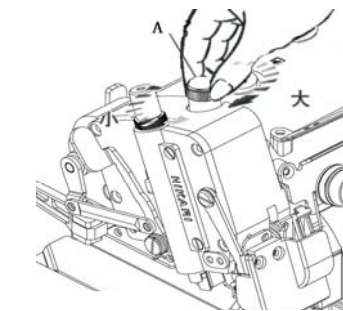
1. Loosen the screw 4 ,press handle 5 to increase the differential ratio ,
The already sewing fabric will shrink . uplift the handle 5 , the
differential ratio will reduced ,
The already sewing fabric will extent .
- 2.After adjust the dirrerencial ratio , please fasten the screw 4 .
(Fig 21)



➤ The adjustment to the presser strength of upper feeding

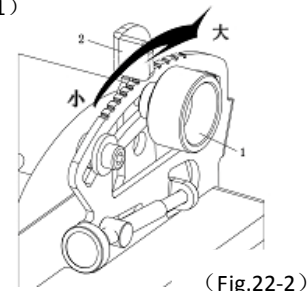
Dog

- under the condition that the normally feeding fabric ,and
can swing the stable stitch try to use the smaller presse strength .
turn the adjustment screw A to adjust the pressure of upper
feeding dog according to the right drawing (Fig 22-1)



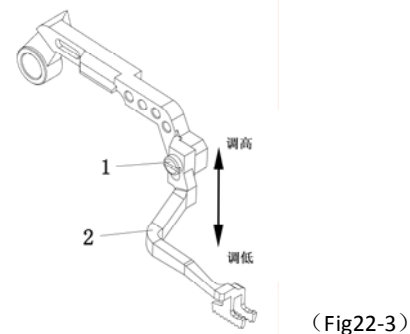
➤ Adjus the front –back direction of upper feeding dog

- turn the adjustment screw 1 by anti-clockwise direction to
loosen the screw , push the adjustent lever2 ,to realize
the front – back direction adjustment of feeding dog
movement .(Fig 22-2)



➤ The adjustment of the up-down direction of feed dog

- Use the screwdriver to loosen bolt 1 to adjust the the up-down
Moving height of feeding dog .(Fig 22-3)



➤ the adjustment to the stitch length

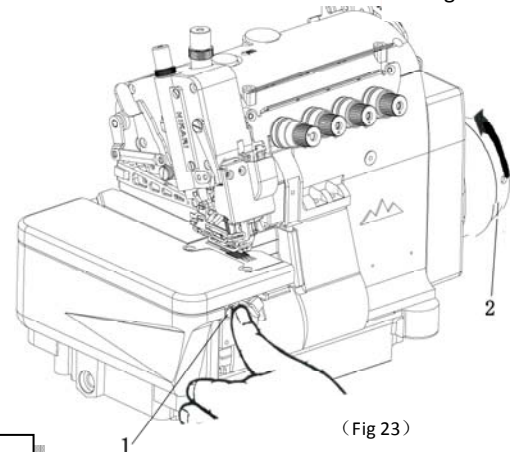
⚠ note

Before adust the stitch length ,please turn off the ower ,unplug the plug
from power socket .

1. Pree the button 1 , meanwhile to turn the handwheel 2 ,
Pree the button to the more deep position .
2. Turn handwheel by clock-wise direction to large the stitch ; turn
handwheel by anti-clockwise direction to lessen the stitch .

note

Before adjust the stitch length ,please adjust the dirrerencial ratio .



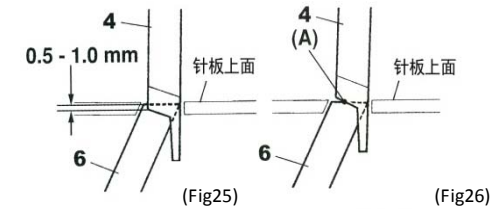
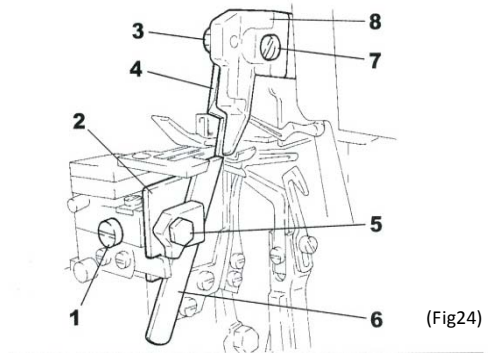
 **note**

When adjust the knife , please turn off the power , unplug the plug from power socket , need special profession mechanician to do .

Please be careful that the blade of the knife have the danger of scratch the finger .

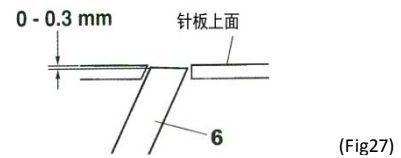
➤ **change the upper knife**

1. Please loosen the screw 1 ,lay the down knife support to the most left place , use screw 1 to make temporary fasten .
2. Please pull out the screw 3 , disassemble the upper knife 4 . use screw 3 to temporary fasten the new upper knife , turn handwheel , place the upper knife at the lowest position ,up-down moving the upper knife to adjust , and make the upper knife and downknife to occlude at depth of 0.5-1.0mm ,and then fasten the screw 3.
3. Aim the centry point of upper knife to centry crossed parts of the down knife 6 (refer Fig26),loosen the screw 1, after confirm the no gap between the upper knife and down knife , fasten the screw 1.
4. Put thread between the upper knife and down knife , turn handwhee to make sure can smoothly cut the thread .



➤ **change the down knife**

1. Loosen the screw 1 , place the down knife support in the most left position , use screw 1 to temporary fasten .
2. Loosen the screw 5 , take out the dow knife 6 , change the new down knife . to adjust the down knife ,make the gap between the down knife blade and needle plate at 0-0.3mm ,and then fasten the screw 5 .
3. Operate according to the method 3 and method 4 of changing upper knife .(Fig27)



➤ **the stitch width adjustment**

1. Loosen the screw 1 , place the down knife support to the most left position , and use screw 1 to temporary fasten .
2. Loosen the screw 7 , move the upper knife base 8 by left and right direction , to adjust the stitch width .
3. Operate according to the method 3-4 of changing upper knife .

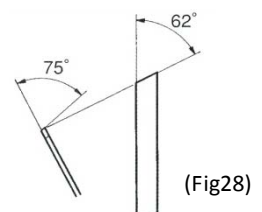
➤ **the method of grinding knife**



The material of upper knife superhard alloy , no need to grind in a long timme usage .when the knife is getting no sharp , please grind the down knife .

the grind method see(Fig 28),

if don't the correct method to grind knife , it will make the knife no sharp ,can not immediately cut the thread ,please note .



Safety instruction

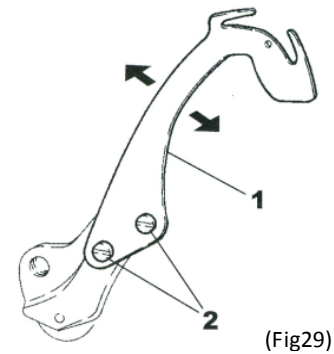
When grind upper knife , need use the special grinding machine , it is better to purchase the gringing machine from the special shop . in order to improve the working efficiency , please keep the upper knife in your stock .(see Fig 28)

➤ the standard install place and adjustment to the thread routing pieces

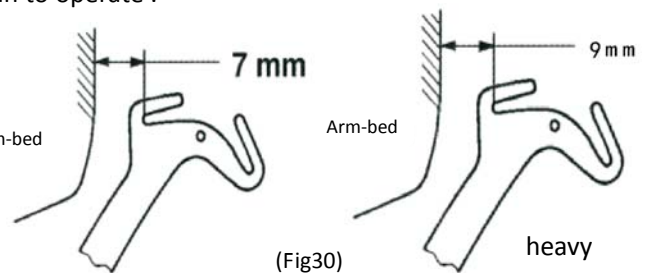
⚠ note

Before adjust the thread routing pieces , please turn off the power and unplu the plug from power socket ,need professional technician to operate .

Turn the handwheek , when the thread routing piece 1 in the the lowest place , please adjust the upper segment to the thread routing piece dimension . when adjusting , please loosen the screw 2 to make the adjustment (Fig 29 , 30)



(Fig29)



(Fig30)

➤ the the standard installation place and adjustment of needle thread line piece

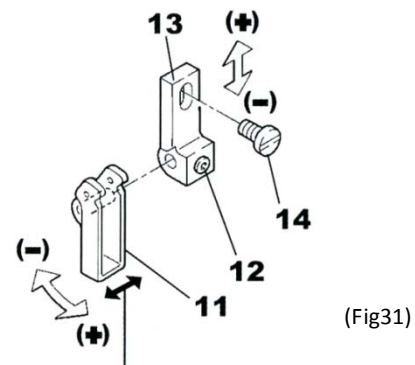
The install place of needle thread line piece is different as the different sewing machine model , the standard place is the needle routing line piece in the lowest and toppest position ,please install the needle thread line piece to the suitable sewing machine model of the correct place .

the adjustment standard of needle thread line pieces (Fig.31)

Loosen the screw 12 and 14 , ajust by moving the needle thread line piece by the arrow instruct direction and adjust the needle thread line support 13 .

Adjust to the (+)direction , the thread draw out

will get more ,adjust to the (-)direction , the thread draw out , Will get less .after adjustment ,please fasten the screw12 and 14 .

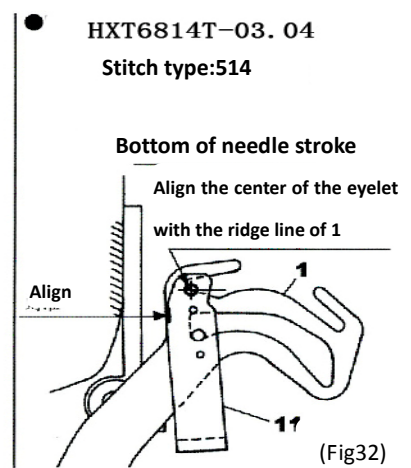


(Fig31)

Adjust thread guide 11 left or right so that the needle thread take-up is centered between the two prongs of each thread guide.

HXT6814T

The standard installation position of needle line piece (Fig32)



(Fig32)

- The standard installation position of looper routing piece and line pieces and the thread routing quantity adjustment of routing camshaft .

 note

Before adjust the routing camshaft ,please turn off the power ,unplug the plug from power socket , need professional technician to operate .

1. To adjust the looper routing piece 9 and 11 at the place of looper'most right .the standard installation place as per the drawing .
Please refer the drawing , loosen screw 10 and 2 , adjust the looper routing piece 9 and 11 .

Adjust the looper routing piece 19 and 11 to the (+) direction , the routing quantitative would become bigger ;adjust to the (-) direction , the routing quantitative would become smaller .

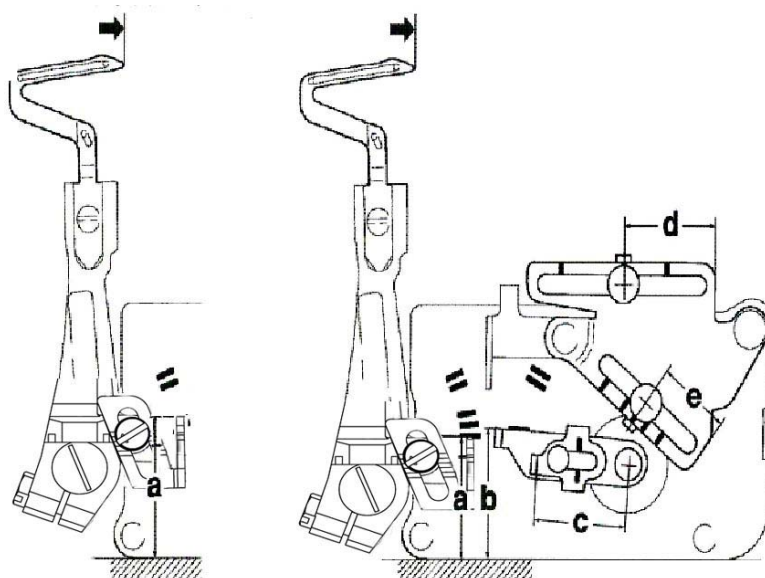
2. The standard installation place of The looper line piece 13,15,17 refer to the drawing .

Refer drawing , please loosen the screw 14,16 and 18 to adjust the every looper line piece .

Adjust every looper line piece to the (+)direction , the thread routing quantitative will get more big , to the (-) direction , the threading routing quantitative will get smaller .(Fig 33)

The standard install place of looper routing piece and line piece (Fig34)

the most right place of down looper



(drawing 34)

HXT6800T	(a)	(b)	(c)	(d)	(e)	HXT6800T	(a)	(b)	(c)	(d)	(e)
HXT6814T-04	30	29	20	33.5	10.5	HXT6814T-03	26	29	28	21.5	14.5

(mm)

(mm)

The dimension adjusting table

(mm)

Subclas											
			(a)	(b)	(c)	(a)	(b)				
HXT6814T-03	10.5	3.8	13.5	5.5	10.5	0.5	0.2	0.7-0.9	5.5	1-6	4.5
HXT6814T-04	11.9	4.2	13.5	5.5	11	0.5	0.2	0.7-0.9	6	1-8	5.5

standard used needle

Subclass	DC×27
HXT6814T-03	#11
HXT6814T-04	#11

HX series sub-model specification

Application	the thickness of fabric	Subclass	Number of needle	Number of thread	Needle space	width of stitch	the length of stitch	Diff.feed rate	Presser foot lift	maxium speed
generalsewing	Medium-heavy	HXT6814T-03	2	4	2	4	0.6-3.8	0.7-2	5.5	6,700
	Extra heavy	HXT6814T-04	2	4	2	4	0.8-5	0.7-2	6	6,400