

ARTISAN®

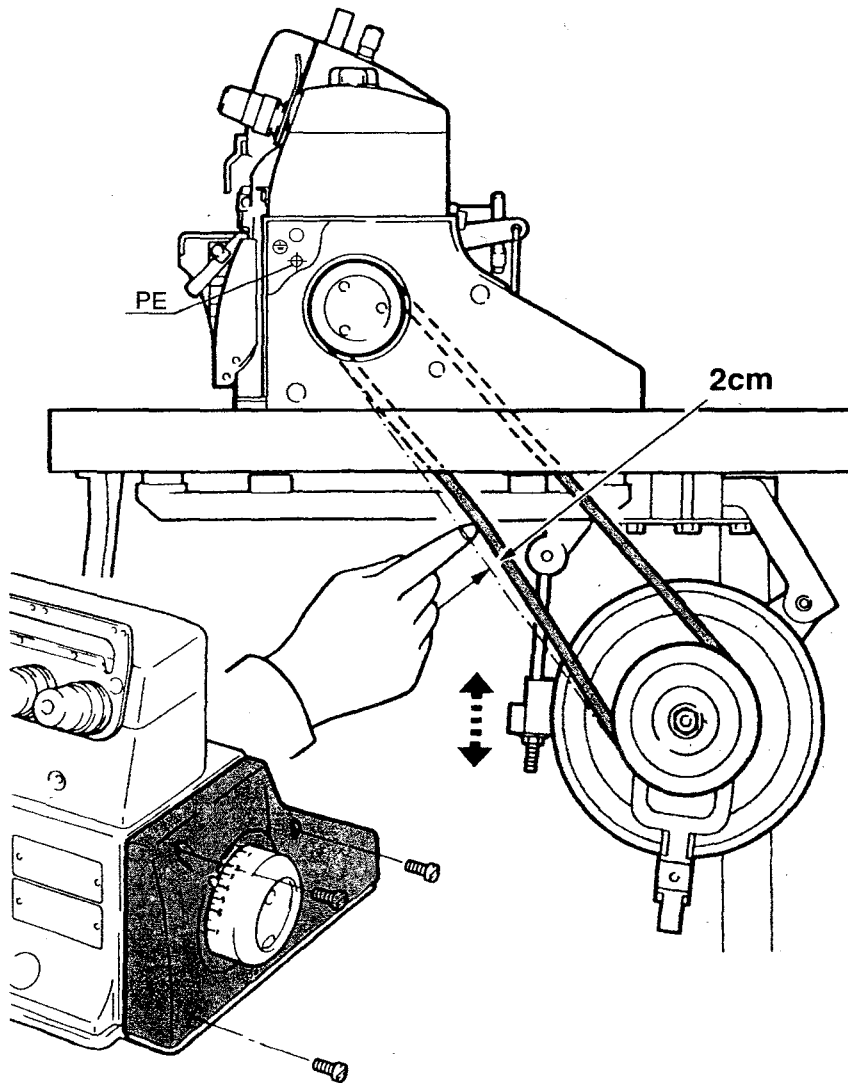


**Models
732 and 752
Spare Parts
and Operators
Manual**

BEFORE
OPERATING

Installing the machine head

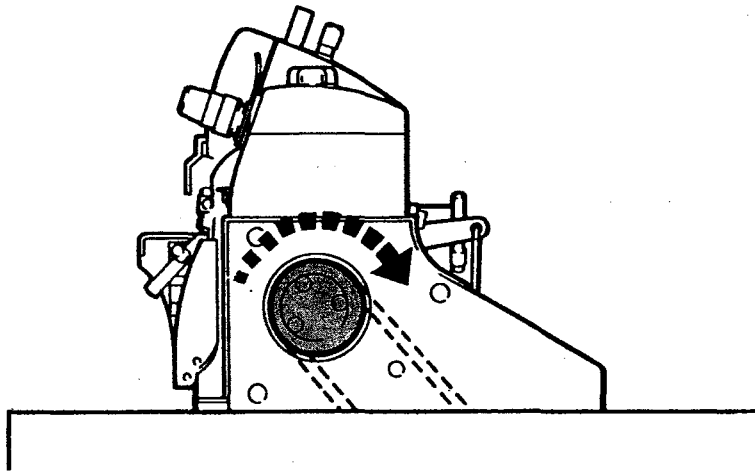
1. Mount the machine head on the machine rest board .
2. Install ground wire at PE.
3. Adjust the tension of the belt so that it can be about 2cm bent inward when you press the middle of it. Adjust the height of the motor to do this.
4. Install the belt cover referring to the Figure.



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.

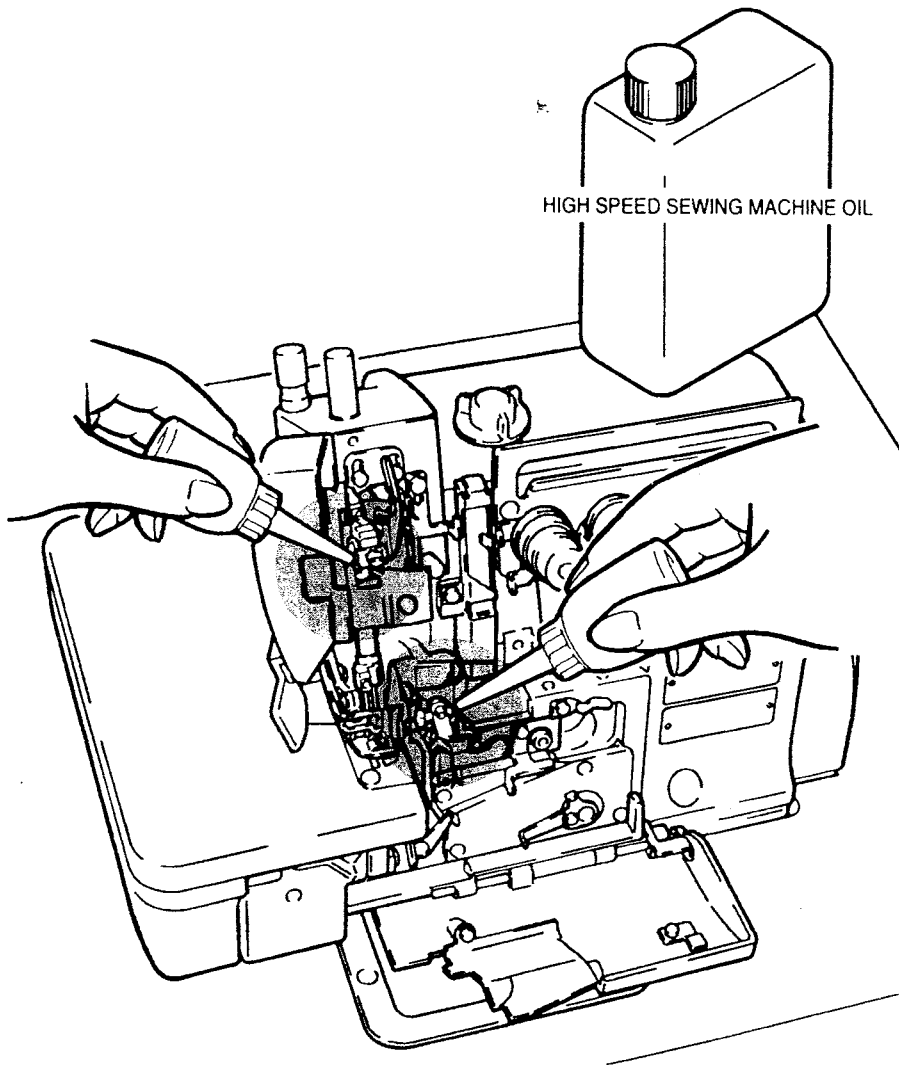
Machine model	The highest speed(r.p.m) r.p.m)
732-36	6,500
732-38	6,500
732-48	5,500
732-70	6,500
732-86	5,500
752-01	7,000
752-13	6,500
752-16S2	6,000
752-17	7,000

BEFORE
OPERATING

Manual lubrication

(HIGH SPEED SEWING MACHINE OIL)

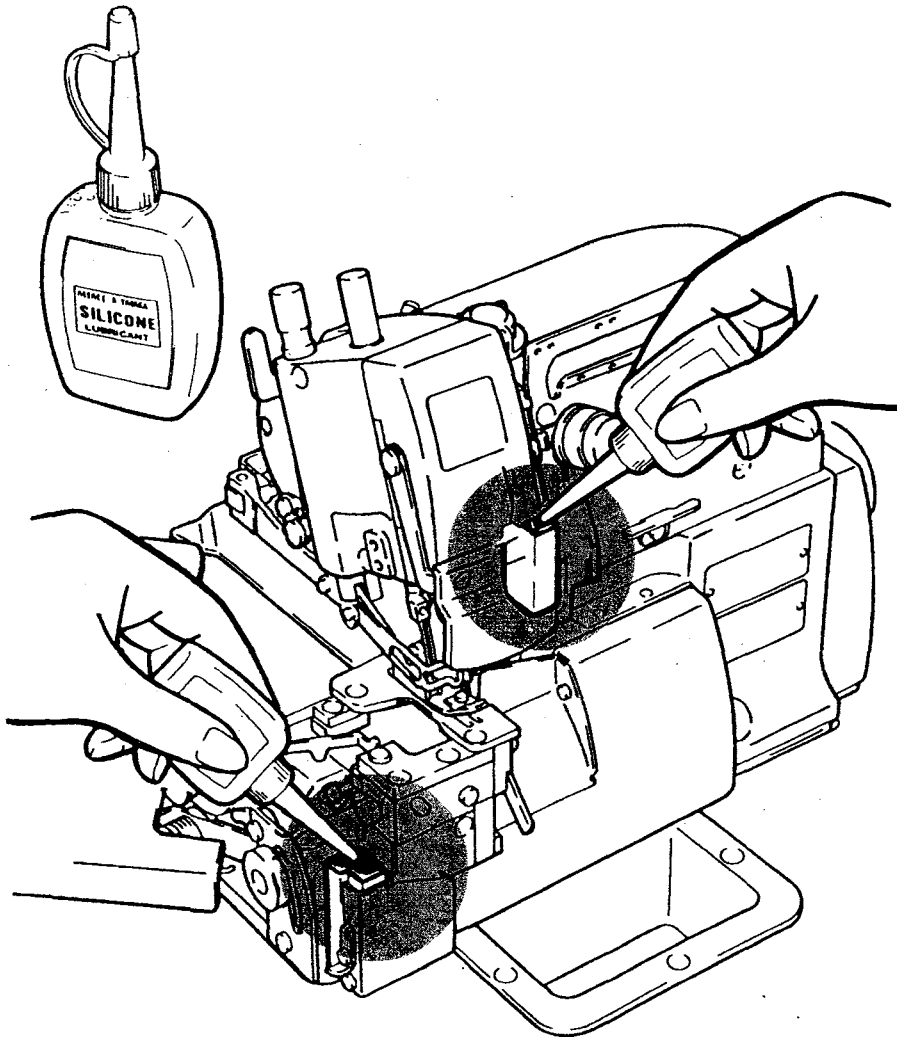
Apply 2 or 3 drops of oil by hand when the machine is used for the first time or has been left unused for some time.
Note: Use recommended oil (HIGH SPEED SEWING MACHINE OIL) (ISO VG22)



BEFORE
OPERATING

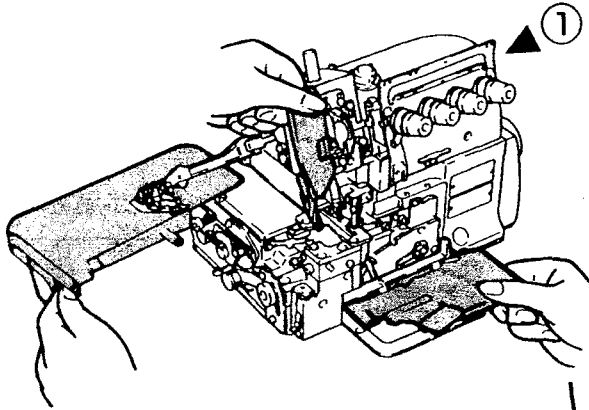
Filling the HR device with silicon oil

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



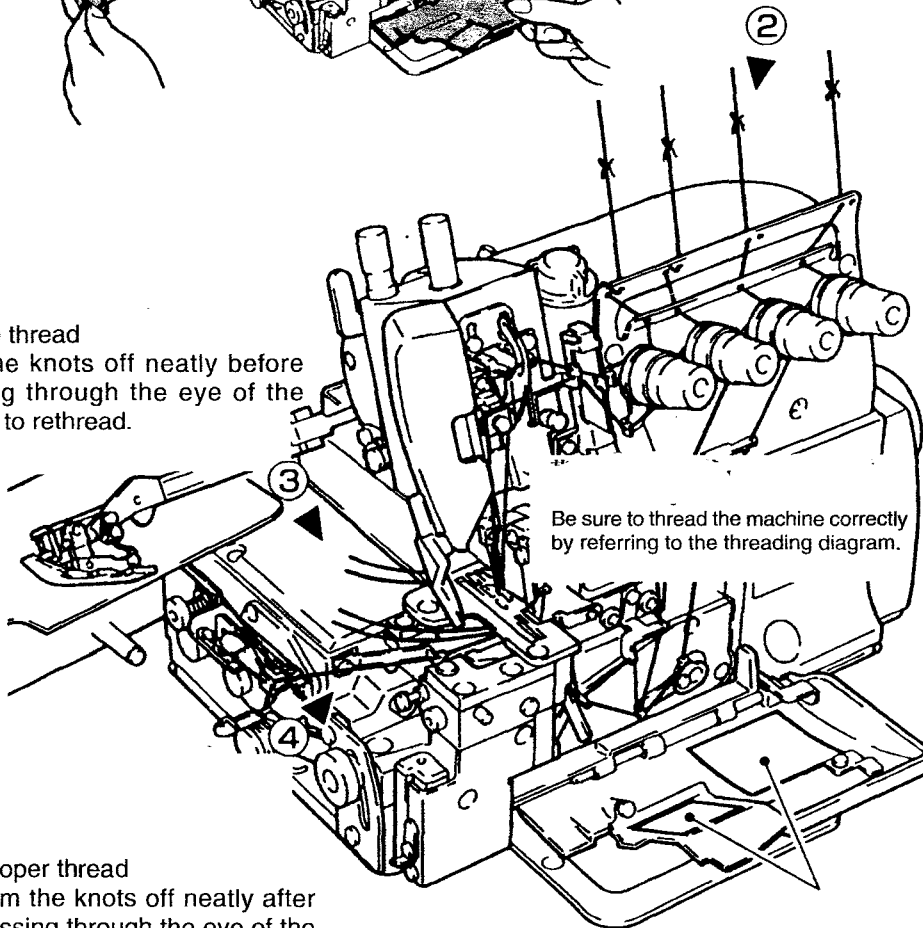
BEFORE
OPERATING

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.

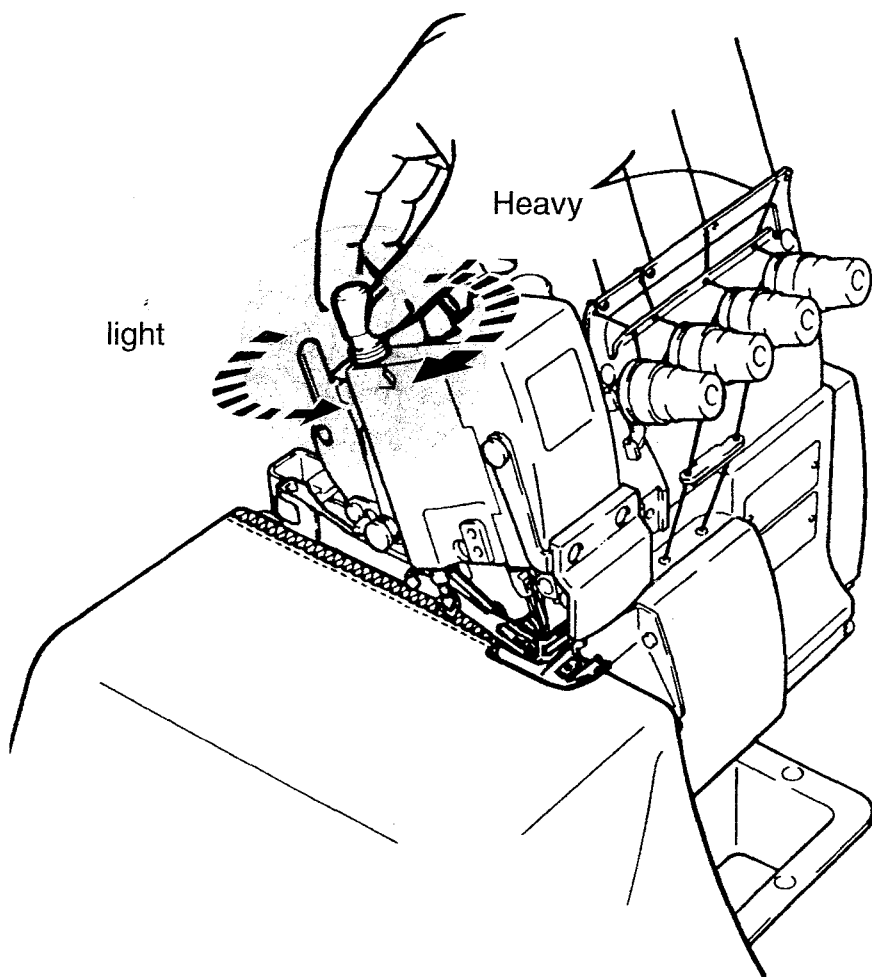
③
④
Looper thread
Trim the knots off neatly after
passing through the eye of the
looper.

Threading diagram

TEST SEWING

Adjusting the presser foot pressure

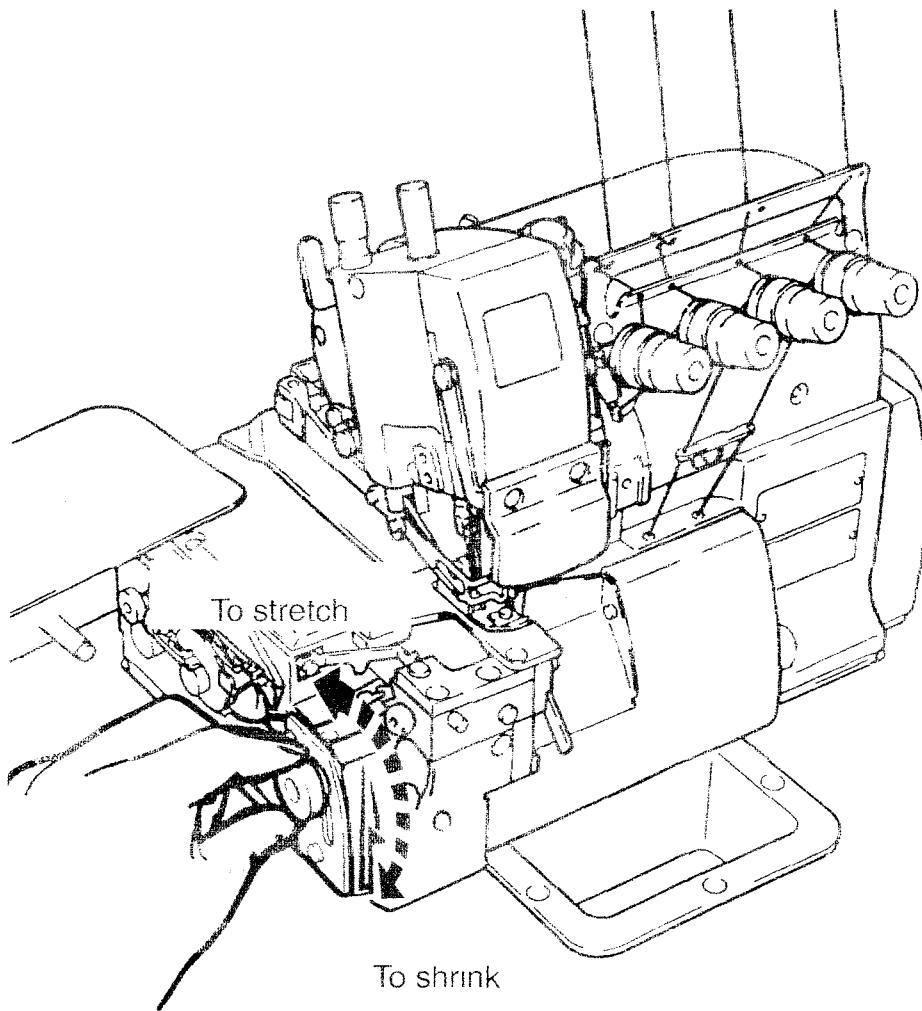
Turn adjusting screw to adjust the presser foot pressure. It should be as light as possible, yet be sufficient to obtain the proper stitch formation.



TEST SEWING

Adjusting the diff.feed ratio

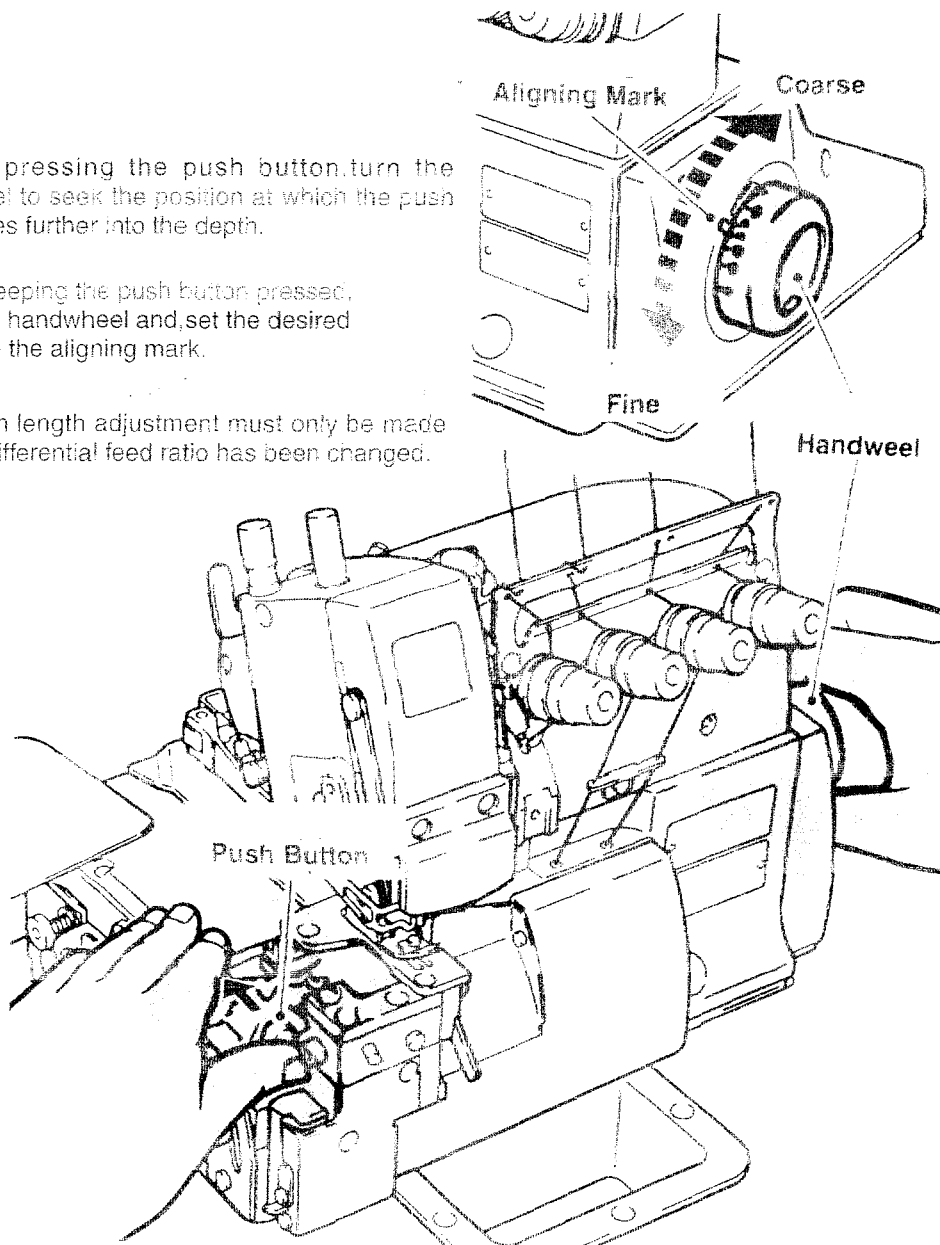
Loosen the nut and move the lever up and down to obtain the correct differential feed ratio.
Tighten the nut after positioning the lever as desired.



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.

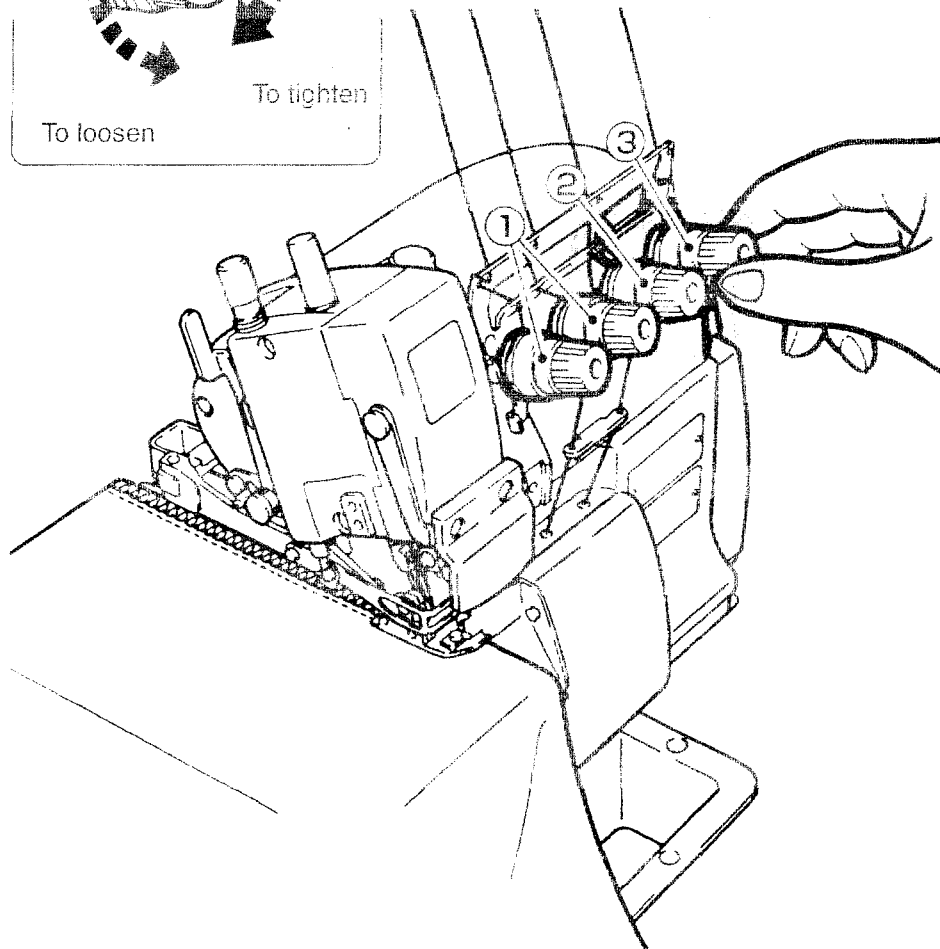
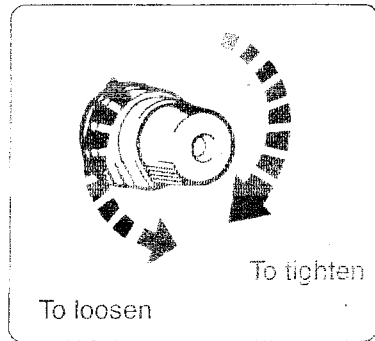
Note: Stitch length adjustment must only be made after the differential feed ratio has been changed.



TEST SEWING

Adjusting the thread tension

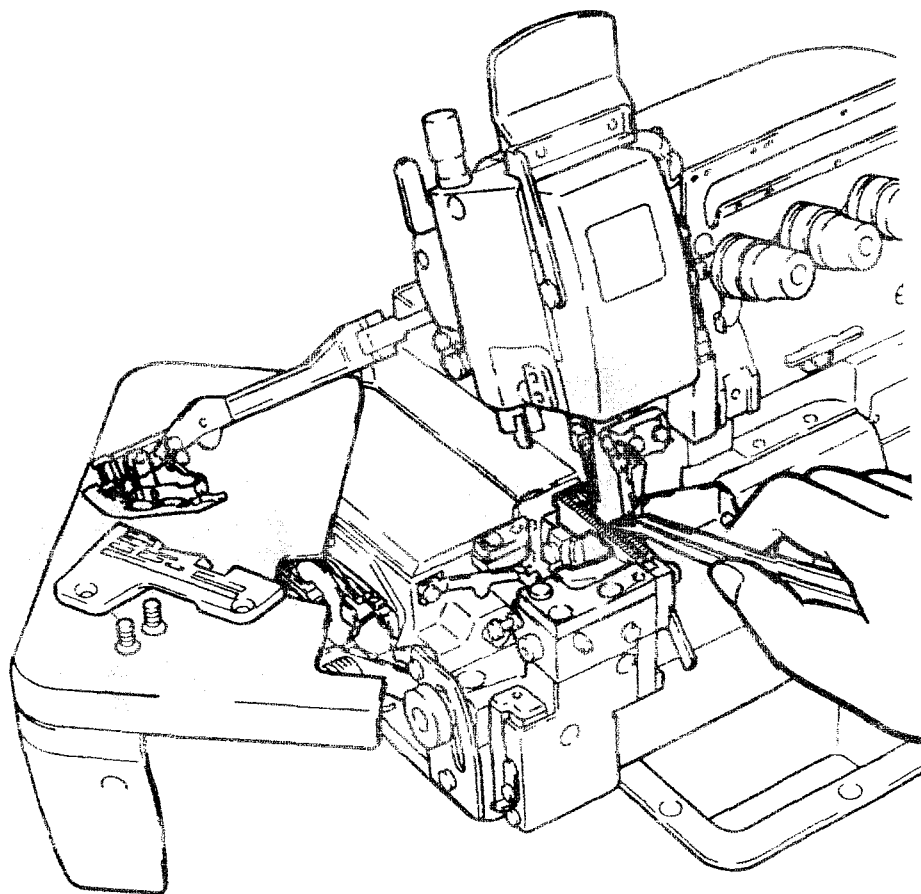
Make tension adjustments with the needle thread knob ①, the upper looper knob ②, and the lower looper knob ③.



MAINTENANCE
DURING USE

Cleaning the machine

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

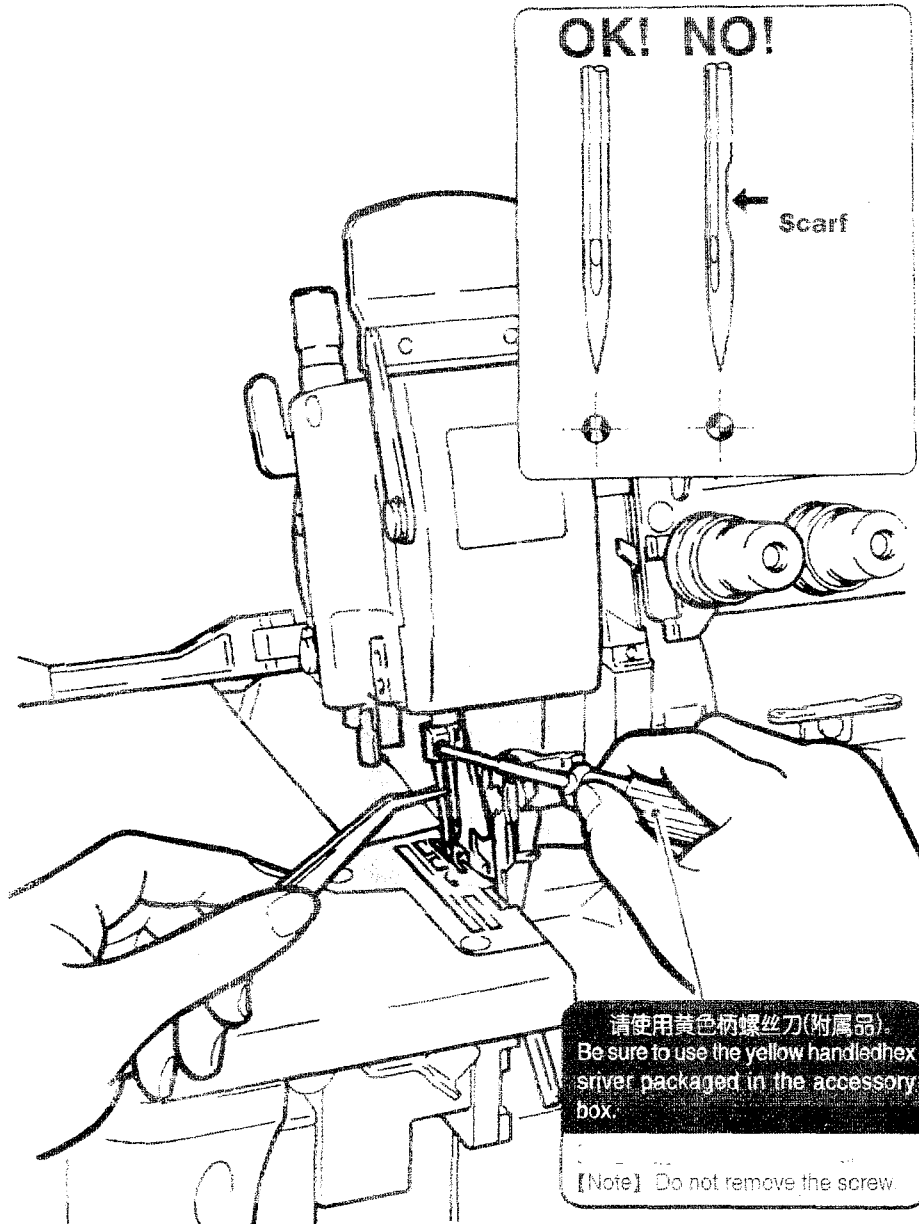


MAINTENACE
DURING USE

Replacing the needle

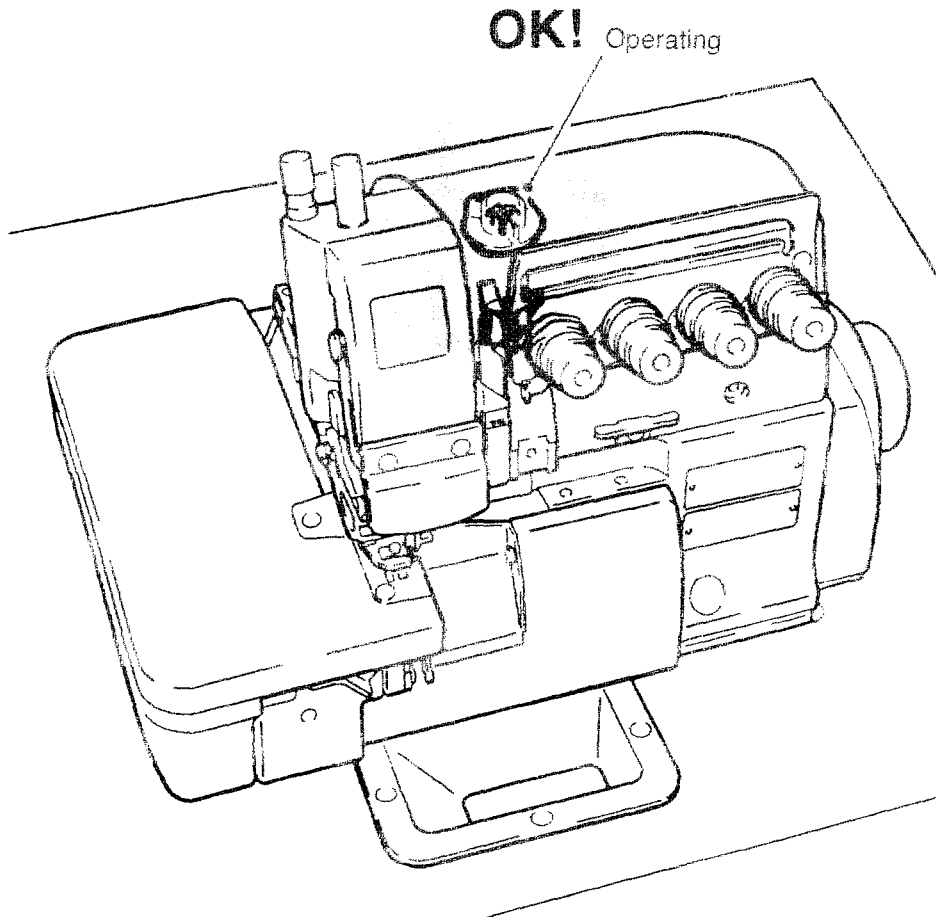
- Check the needle carefully to see that the scarf is turned to the rear of the machine.
- Insert the needle to the proper depth, and fasten securely.

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



MAINTENANCE
DURING USE

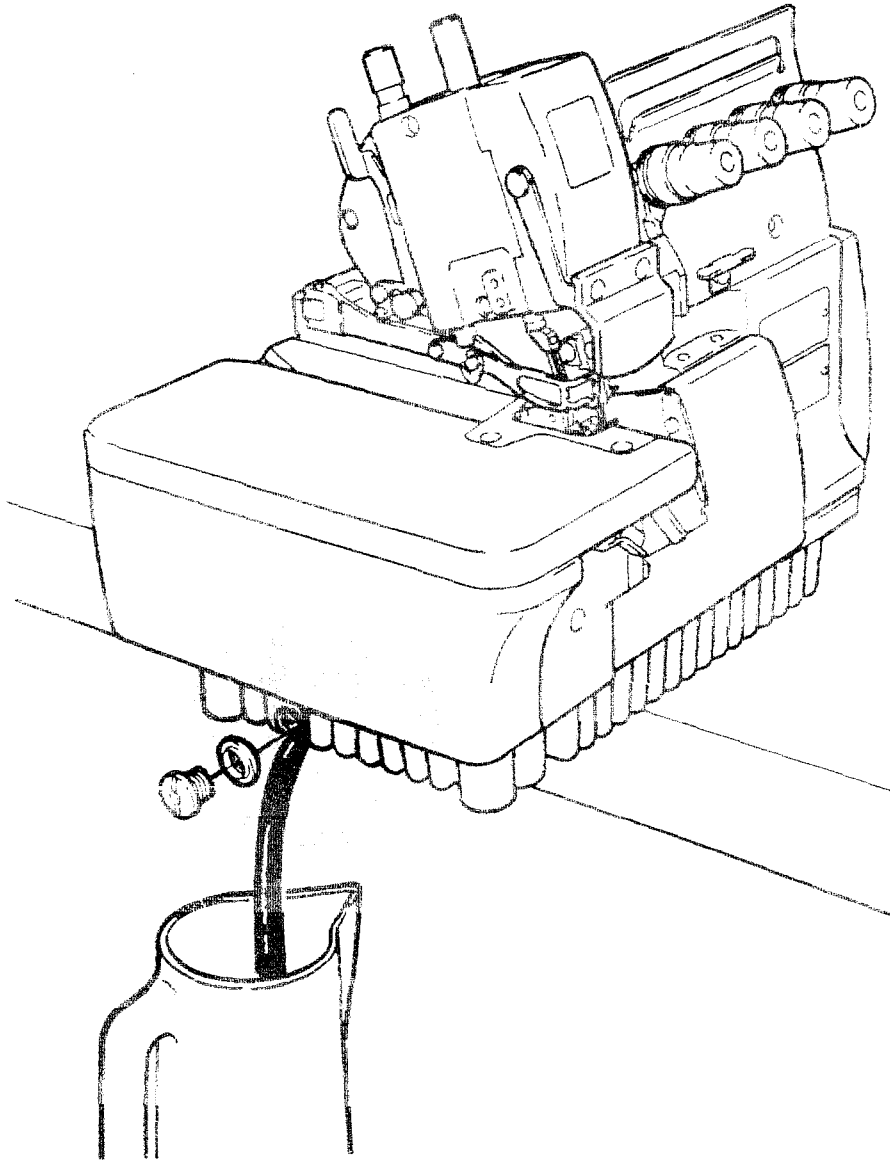
Checking the oil circulation



MAINTENACE
DURING USE

Replacing the oil

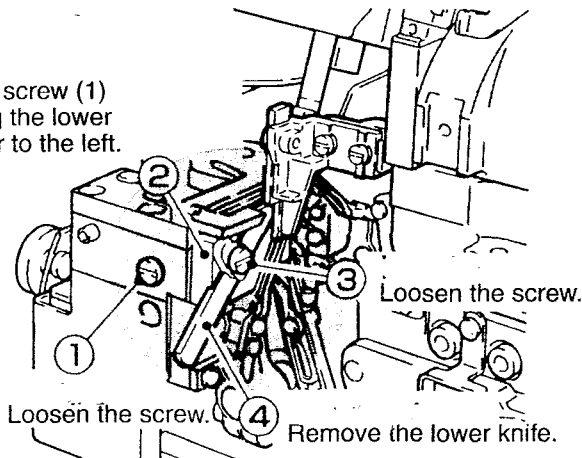
Replace the oil one month after the first use and every six months thereafter.(See P7.)



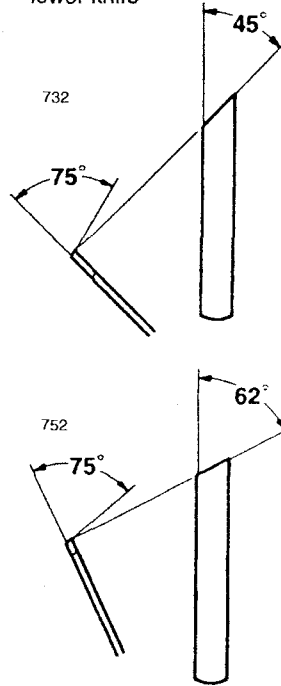
Replacing the lower knife

To remove the lower knife

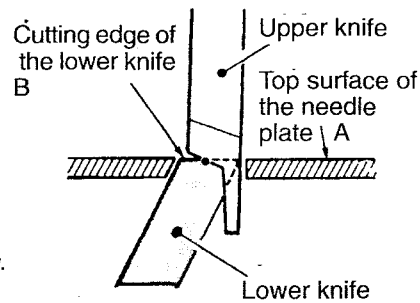
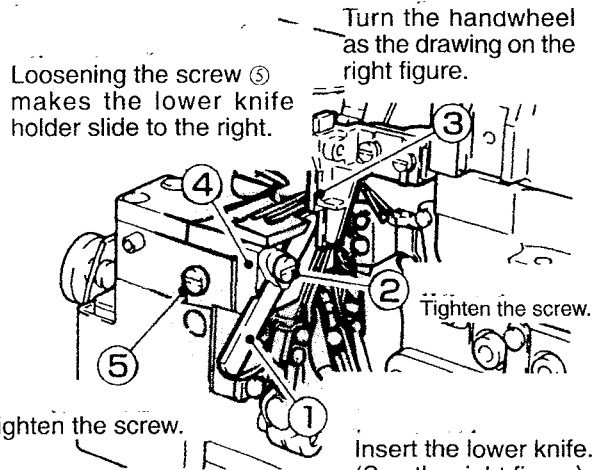
Temporarily screw (1)
after sliding the lower
knife holder to the left.



Correct angles to resharpen the
lower knife



To replace the lower knife



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

752

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		

	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

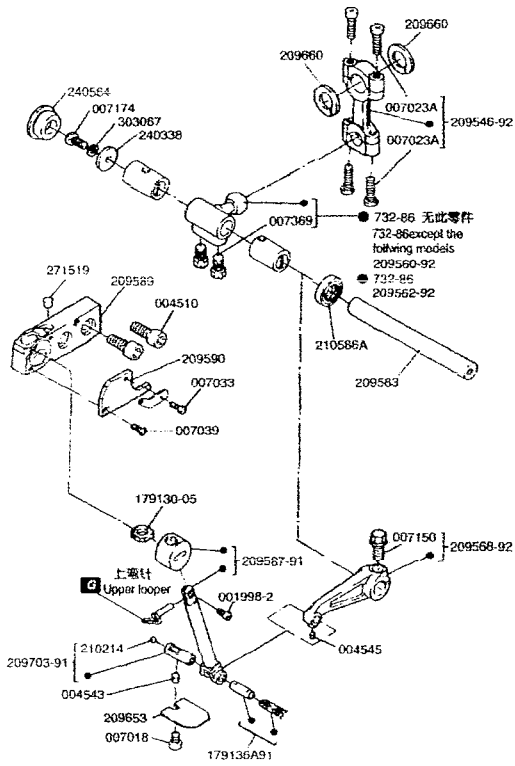
日本针号 (Organ) Japanese size (Organ)	#	9	11	14	16	18	21	
中国针号 Chinese size (Organ)	Nm	65	75	90	100	110	130	

HIGH-SPEED OVERLOCK SEWING MACHINE

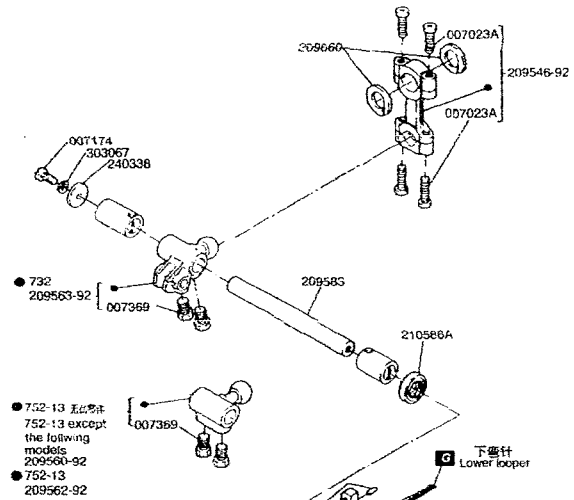
PARTS BOOK

5

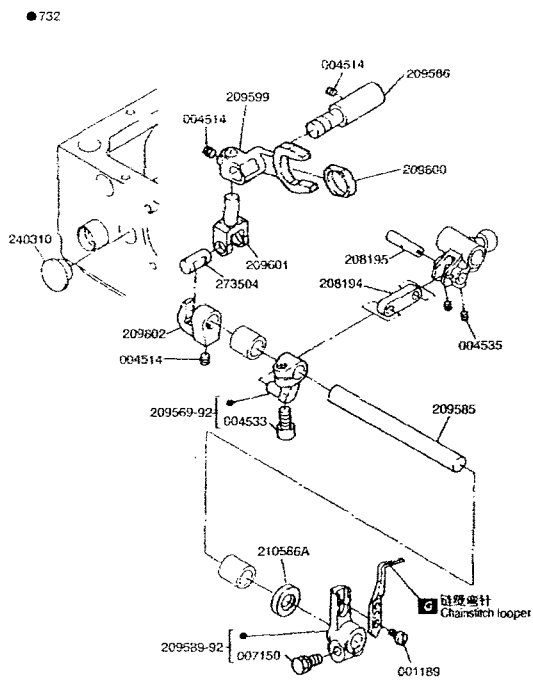
Please confirm the correct part by the gauge parts lists.

**6**

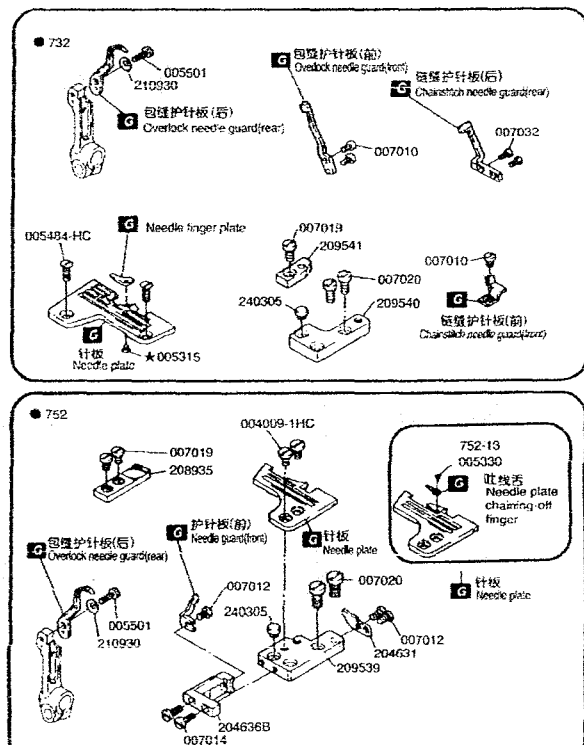
Please confirm the correct part by the gauge parts lists.

**7**

Please confirm the correct part by the gauge parts lists.

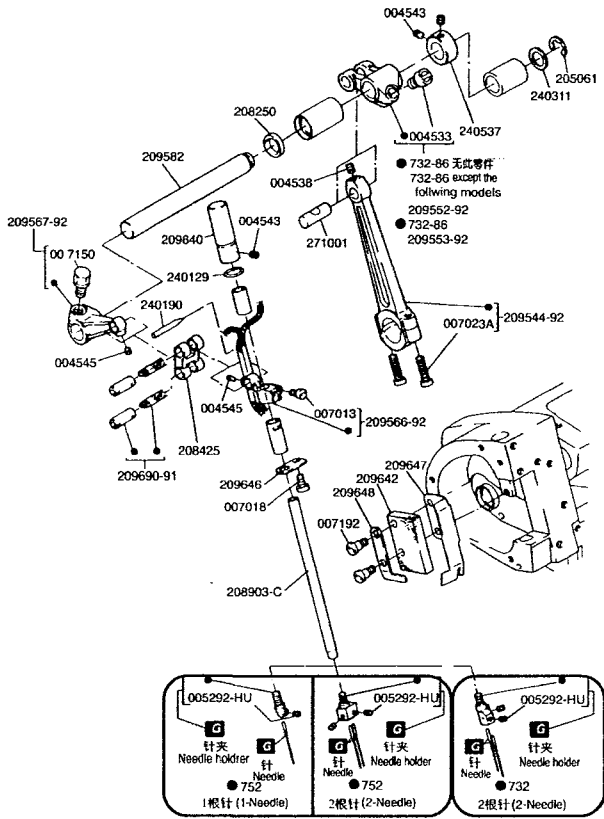
**8**

Please confirm the correct part by the gauge parts lists.



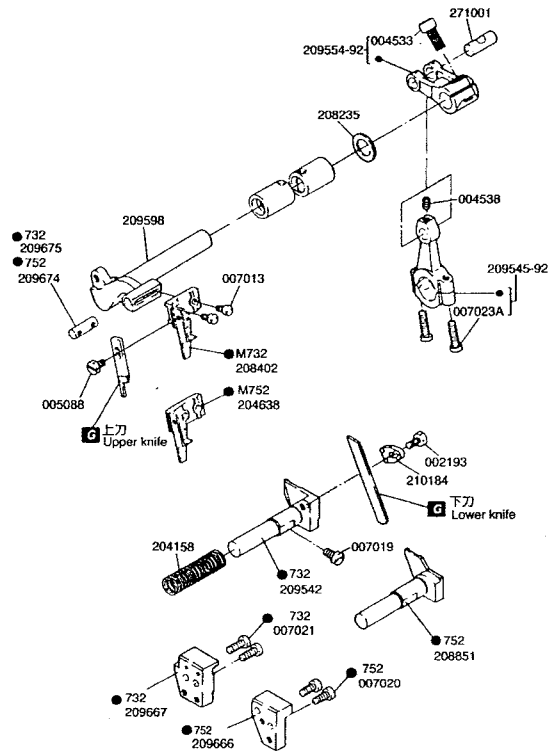
9

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



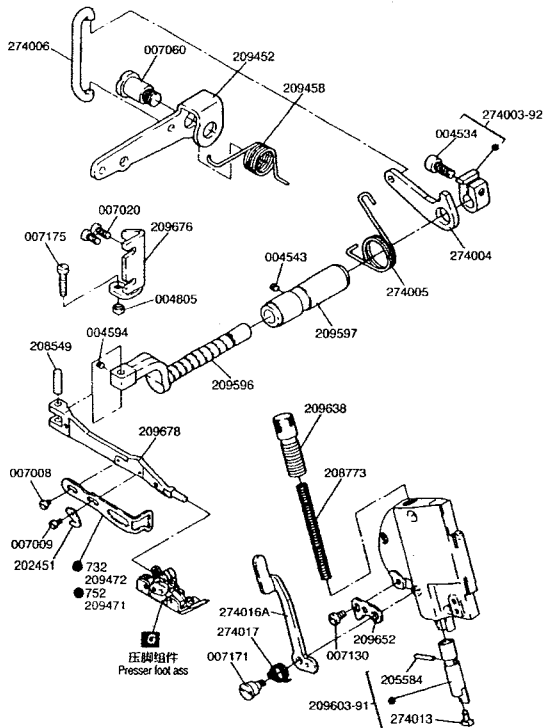
10

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



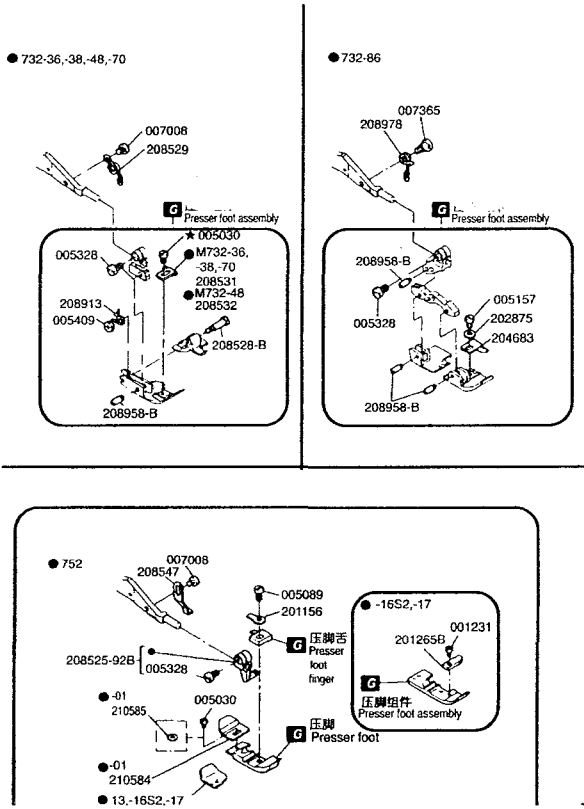
11

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

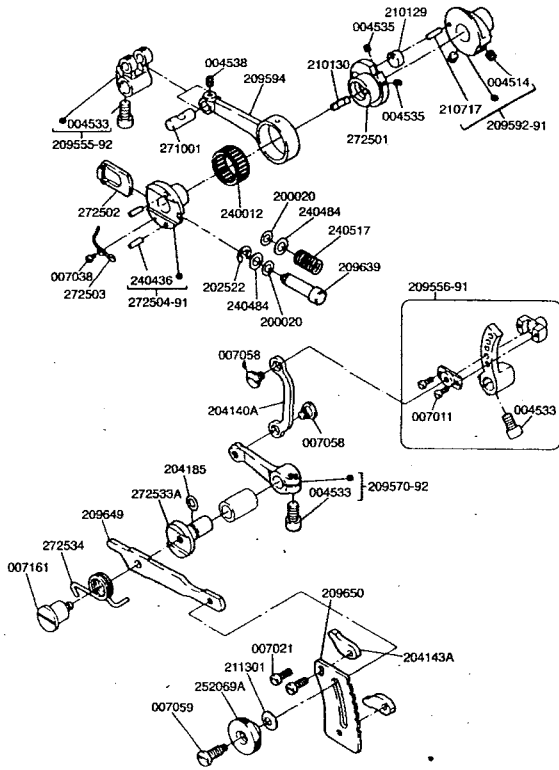


12

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

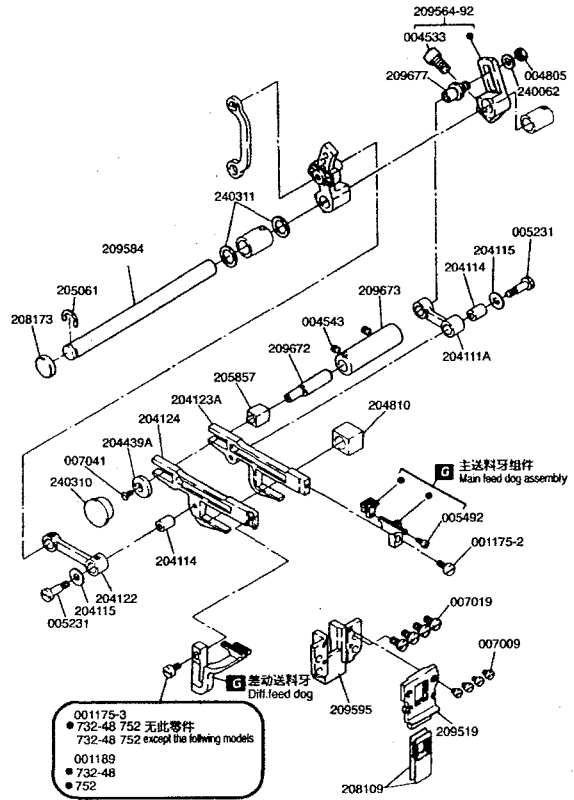


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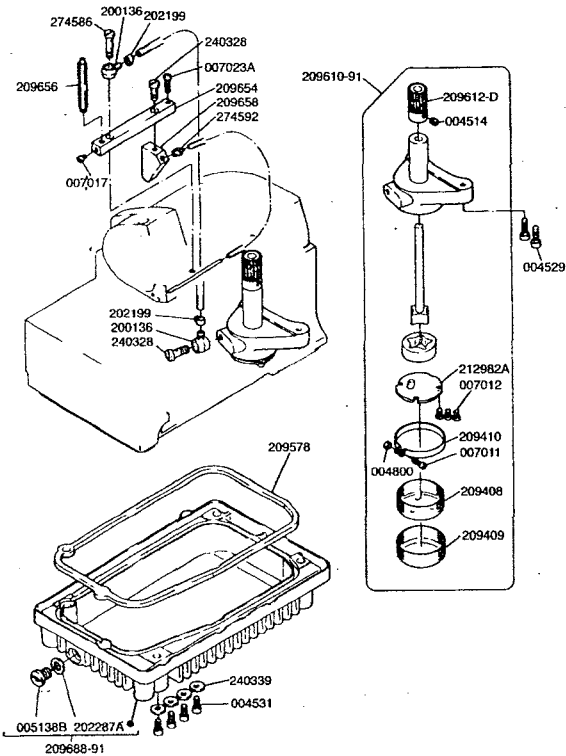


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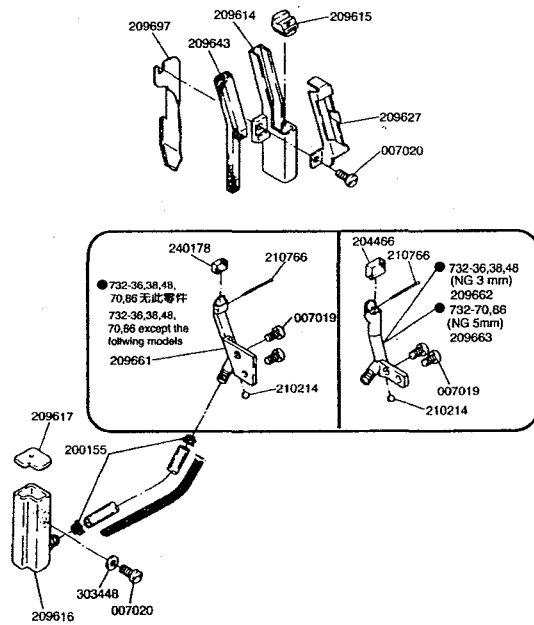
G Please confirm the correct part by the gauge parts lists.



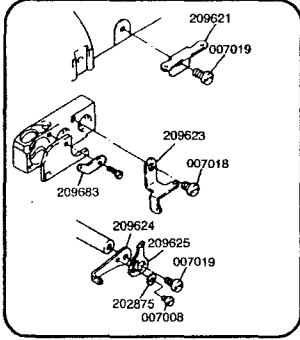
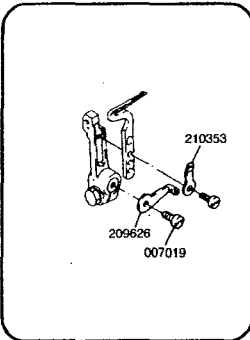
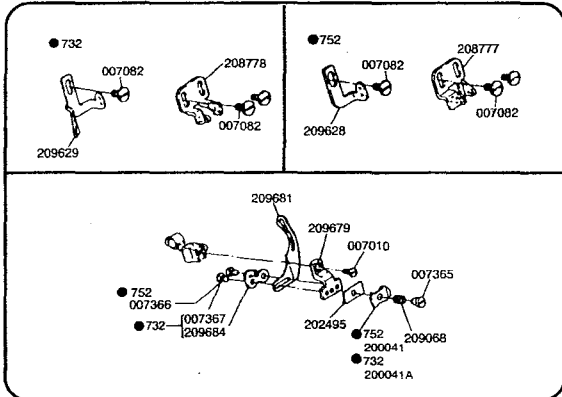
15



16

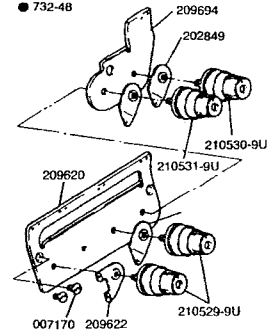
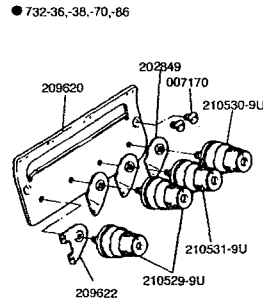
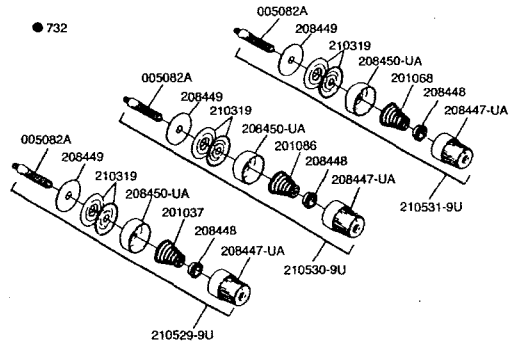


17

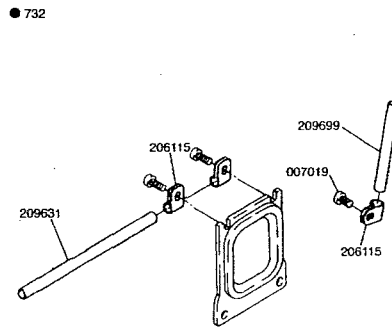
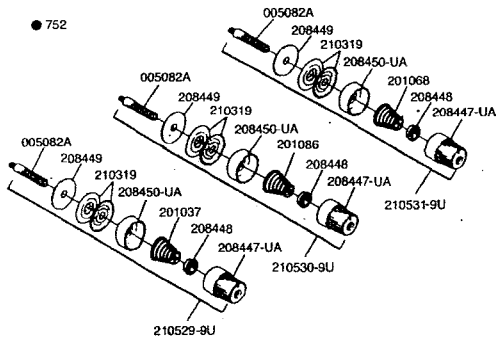


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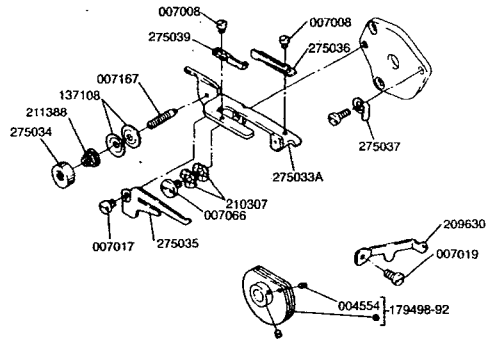
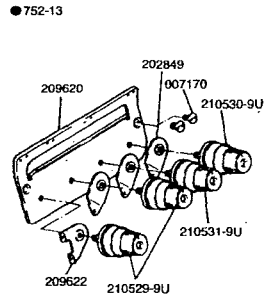
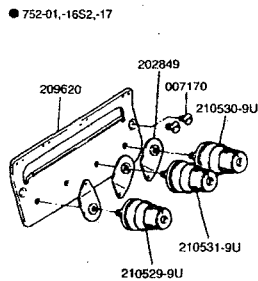
G Please confirm the correct part by the gauge parts lists.



19

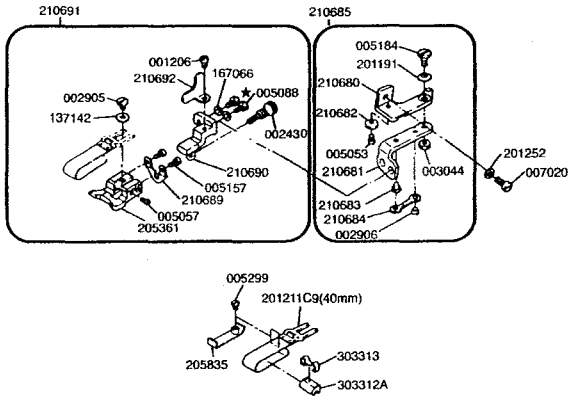


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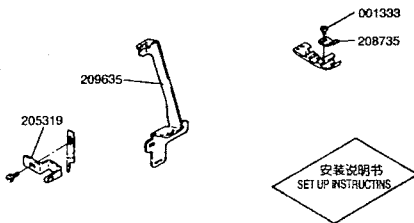


21

叠边 (Blind hemming)
● 752-01

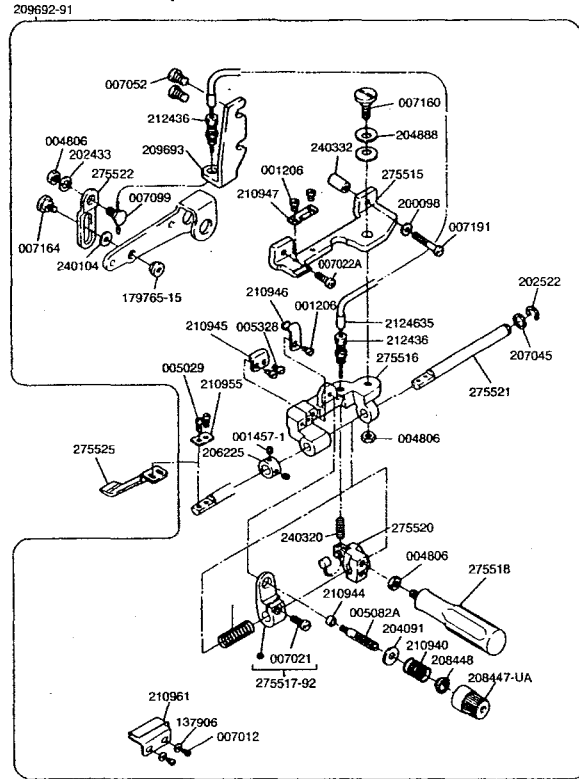


叠边附件 (Attaching tape)
● 752-13

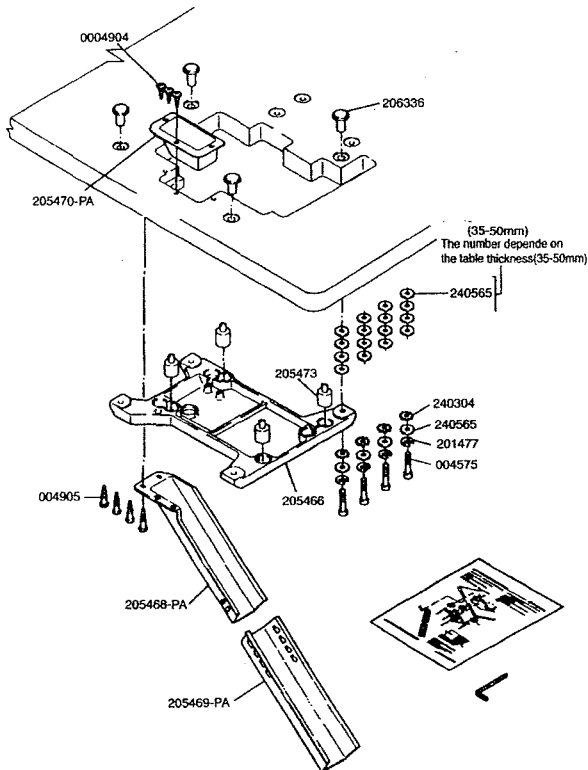


22

抽芯 (Shirring)
● 732-46

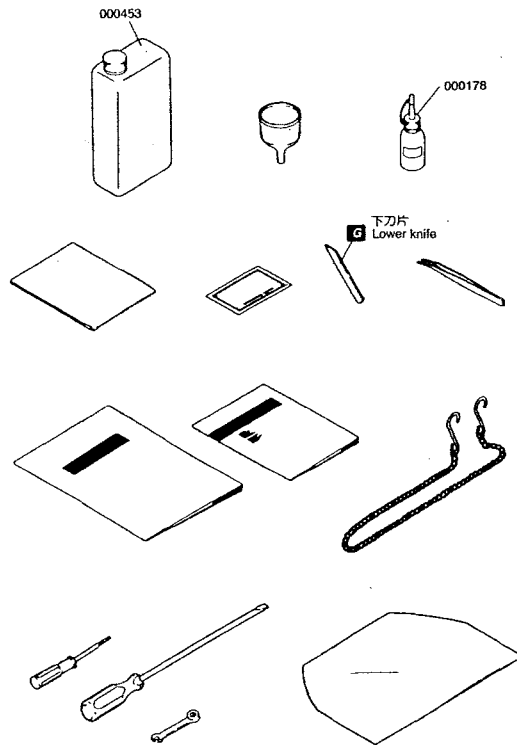


23



24

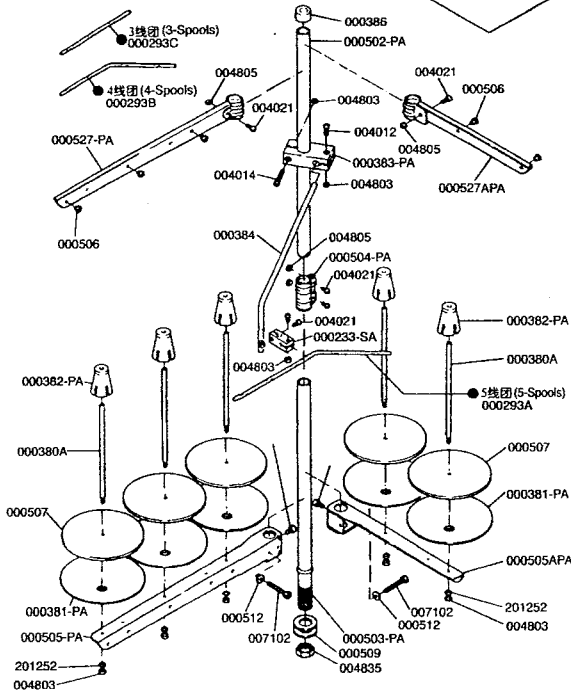
G Please confirm the correct part by the gauge parts lists.



- 752-01-16S2-17
3线团 (3-Spools)
000486C9P
- 752-13
4线团 (4-Spools)
000486B9P

- 732
5线团 (5-Spools)
000486A9P

安装说明书
SET UP INSTRUCTION



732 GAUGE PARTS LIST

732

型号 MACHINE TYPE /SPEC.	包边宽度 GAUGE NG SW	针板 NEEDLE PLATE	吐线舌 NEEDLE FINGER PLATE	主送料杆组件		主送料杆		辅助送料杆		差动送料杆		压脚组件		上弯针		下弯针		链式弯针 CHAINSTITCH LOOPERS
				MAIN FEED DOG ASS.	MAIN FEED DOG	AUX FEED DOG	AUX FEED DOG	DIFF FEED DOG	DIFF FEED DOG	PRESSER FOOT ASS.	UPPER LOOPERS	LOWER LOOPERS						
732-36	3 4	204367	210505	208065	(204395)	208218	208501	208501	208501	204062	204072	209685	209685	204072	204072	209685	209685	209685
732-38	3 4	204367	210505	208066	(204396)	208219	208501	208501	208501	204072	204072	209685	209685	204072	204072	209685	209685	209685
732-48	3 4	204940	210505	208074	(204931)	208061	204420	208508	208508	204702	204702	209685	209685	204702	204702	209685	209685	209685
732-70	5 5	204360A	210508	208063	(204288)	208059	208215	208502	208502	204702	204702	209685	209685	204702	204702	209685	209685	209685
732-86	5 6	204529	210509	208064	(204394)	208059	208217	208955	208955	204703	204703	209685-HC	209685-HC	204702	204702	209685	209685	209685

型号 MACHINE TYPE /SPEC.	包边宽度 GAUGE NG SW	上刀片		下刀片		链式针板				针夹		针 NEEDLE
		UPPER KNIFE	LOWER KNIFE	FRONT	REAR	OVERLOCK NEEDLE GUARD	FRONT	REAR	CHINSTITCH NEEDLE GUARD	FRONT	REAR	
732-36	3 4	201121A	204161	209668	209009	209668	209009	204536	209669	20890892	DCX27#11	DCX27#11
732-38	3 4	201121A	204161	209668	209009	209668	209009	204536	209669	20890892	DCX27#14	DCX27#14
732-48	3 4	201121A	204161	209668	209009	209668	209009	204536	209669	20890892	DCX27#14	DCX27#14
732-70	5 5	201121A	204161	209668	209009	209668	209009	204042	209669A	208910892	DCX27#14	DCX27#14
732-86	5 6	201121A	204161	209668	209009	209668	209009	204042	209669A	208910892	DCX27#21	DCX27#21

752

型号 MACHINE TYPE /SPEC.	包边宽度 GAUGE NG SW	针板 NEEDLE PLATE	吐线舌 NEEDLE FINGER PLATE	主送料杆组件		主送料杆		辅助送料杆		差动送料杆		压脚		上弯针		下弯针	
				MAIN FEED DOG ASS.	MAIN FEED DOG	AUX FEED DOG	AUX FEED DOG	DIFF FEED DOG	DIFF FEED DOG	PRESSER FOOT	PRESSER FOOT FINGER	UPPER LOOPERS	LOWER LOOPERS				
752-01	- 4	205773	-	208090-BF	(204729ABF)	204674	204674	204730-BF	204674	208730	201152E	201152C	204062	204072	204062	204072	204072
752-13	2 4	20254E	(202791A)	208076-BF	(204675ABF)	204674	204674	204676-BF	204674	208730	208730	201230C	205525	204062	204072	204062	204072
752-16S2	- 1.5	205465	-	208911	(204729A)	208912	204730	201230C	205525	204062	204062	204062	204062	204062	204062	204062	204062
752-17	- 4	202546E	-	208076-BF	(204675ABF)	204674	204674	204676-BF	204674	201230C	210371	204062	204062	204062	204062	204062	204062

型号 MACHINE TYPE /SPEC.	包边宽度 GAUGE NG SW	上刀片		下刀片		链式针板				针夹		针 NEEDLE
		UPPER KNIFE	LOWER KNIFE	FRONT	REAR	OVERLOCK NEEDLE GUARD	FRONT	REAR	CHINSTITCH NEEDLE GUARD	FRONT	REAR	
752-01	- 4	201121A	202295	204659	209009	204659	209009	209670-92	DCX27#9	DCX27#9	DCX27#9	DCX27#9
752-13	2 4	201121A	202295	204659	209009	204659	209009	209670-92	DCX27#9	DCX27#9	DCX27#9	DCX27#9
752-16S2	- 1.5	201121A	202295	204659	209009	204659	209009	209670-92	DCX27#11	DCX27#11	DCX27#11	DCX27#11
752-17	- 4	201121A	202295	204659	209009	204659	209009	209670-92	DCX27#9	DCX27#9	DCX27#9	DCX27#9