



JK-K4-UT

产品使用说明书&产品零件图册

Manual book & parts book

**JACK 杰克**

# JACK

## K4 系列使用说明 K4 series' use manual



一、规格 First. specification

机种名称 type	小头式高速绷缝机 High Speed Computerized Cylinder-bed Interlock Machine
型式 model name	K4
缝迹形式 Stitch type	ISO 标准 : 406/407/602/605 ISO standard : 406/407/602/605
用途 use	针织、编织产品的包边缝、包缠缝 Knitting, knitting products of the wrap seam 、wrapping
缝纫速度 Sewing speed	最高转速 The maximum speed : 5500RPM 出厂转速 Factory speed : 4000RPM
针幅 Needle width	3 根针 3Needle : 5.6mm、6.4mm 2 根针 2Needle : 2.8mm、3.2mm、5.6mm、6.4mm
差动送布比 Differential feed ratio	0.8-1.3
缝迹长度 Stitch length	1.5mm-4.5mm
使用机针 Needle type	UY128GAS 11#、14# ( 标准 standard : 11# )
针杆行程 Needle bar stroke	33mm
压脚高度 Presser foot height	7.0mm
体积 volume	纸箱体积 Carton size : 675mm×450mm×602mm 机器体积 Machine size : 500mm×380mm×260mm
重量 weight	净重 net weight : 52Kg 毛重 Gross weight : 62Kg

表 1

## 二、各部分的名称 Second, the name of each part

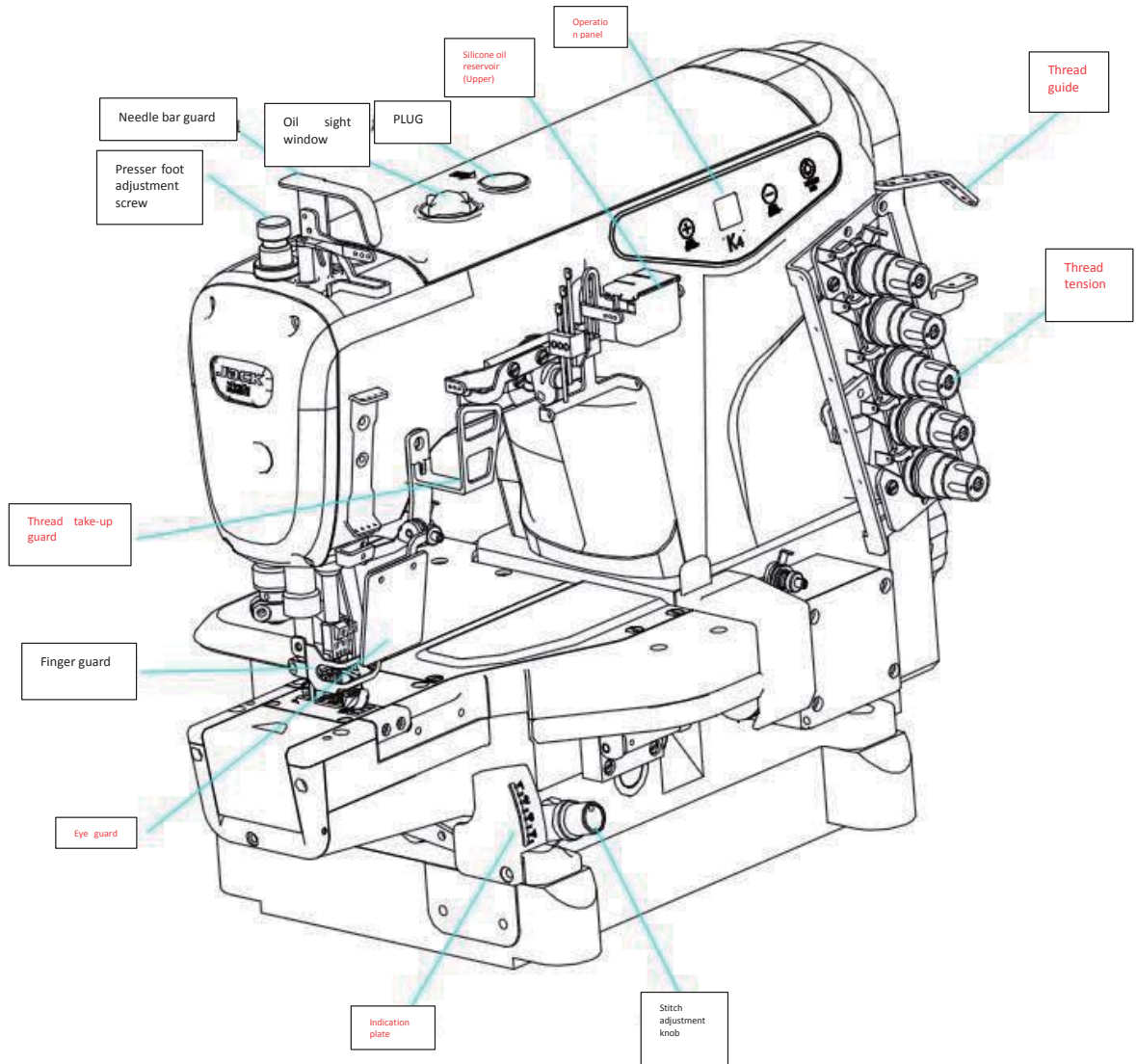


图 Figure2-1

简介：K4机器电控与机械一体，可以在机器上调节电控相关参数，实现了人性化的人机交换模式，操作便利！

Introduction : K4 , which control box is integrated into machine head, parameters can be adjusted on machine directly, achieved interpersonal exchange, easy and convenient to operate !

三、安装方法 Third, the installation method

1、台板尺寸及其安装方法

1、 table size and installation method

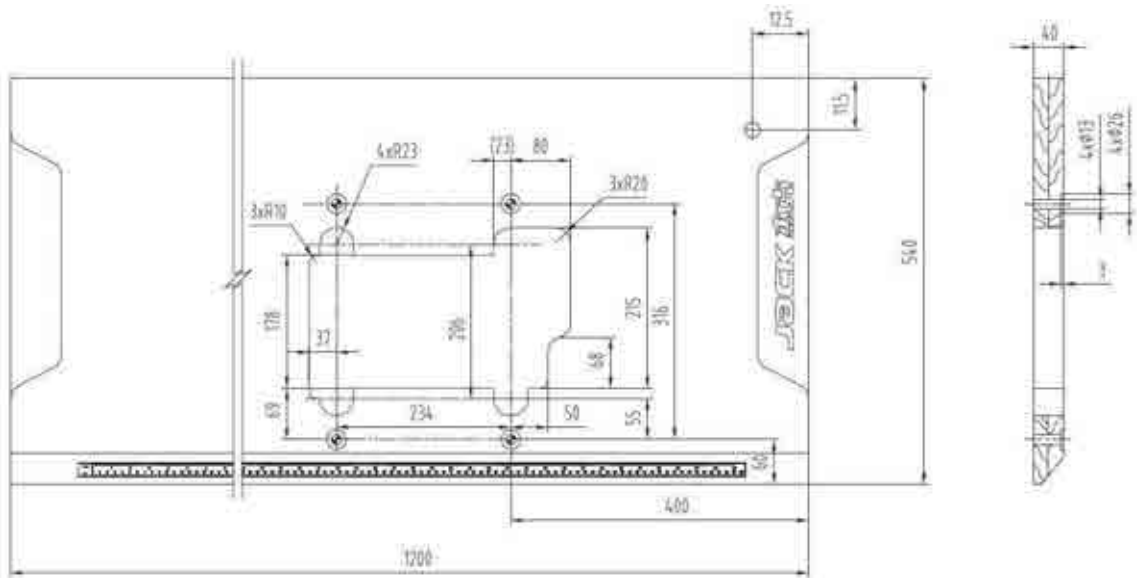


图 3-1

2、链条的安装

2、 the installation of the chain

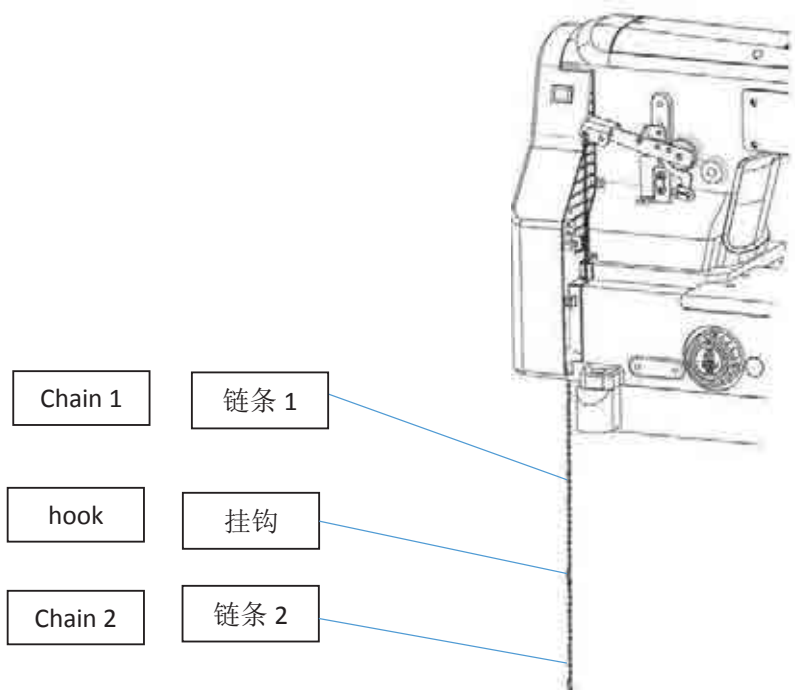


图 3-2

脚踏板链条如上图所示安装

Pedal chain installed as shown above

#### 四、关于加油、注油 Fourth, on the Lubrication, oiling

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

Note: In order to prevent personal accident caused by the sudden start of the machine, please turn off the power, make sure the motor does stop turning and then operate!

##### 1、出厂加油

机器出厂时，机油均被排放，因初次使用缝纫机前，请一定要加入机油，推荐使用机油：白油 22#，加油时请拿开标有 OIL 的加油口盖子，把机油加到油尺的上下刻线之间，加油完成后转动缝纫机，看油窗是否有机油喷出，如果没有机油喷出，请进行检修。

When the machine is shipped from the factory, the oil is discharged. Be sure to add the oil before using the sewing machine for the first time. It is

1, the factory refueling

recommended to use the oil 22#. When filling, open the plug marked with OIL and add the oil between the upper and lower engraved lines. Turn on the sewing machine after refueling to see if there is any oil spilled in the oil window. If there is no oil spilled, please carry out overhaul.

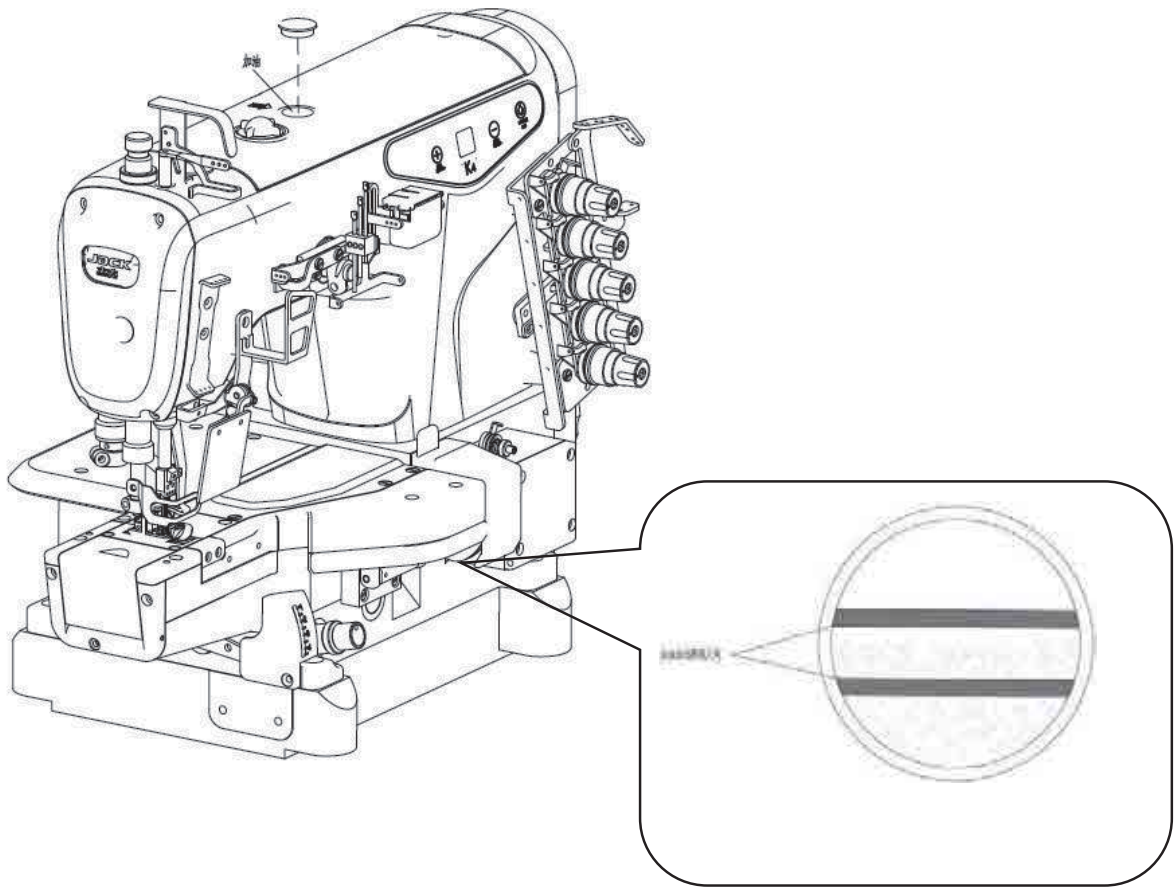


图4-1

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

Note: In order to prevent personal accident caused by the sudden start of the machine, please turn off the power, make sure the motor does stop turning and then operate!

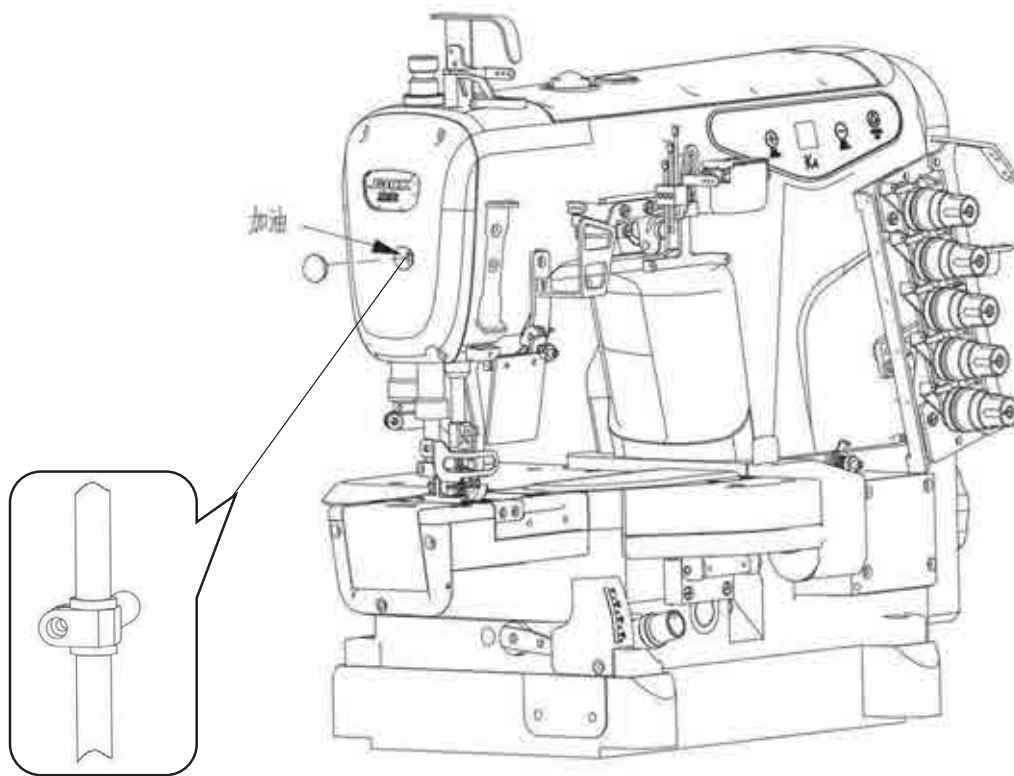
## 2、出厂注油

机器出厂首次使用或较长时间没有使用缝纫机时，请一定向针杆滴 2-3 滴机油，滴在针杆扎头与针杆的连接处，确保针杆机构润滑。

## 2, factory oiling

When the machine is used for the first time in the factory or when the sewing machine is not used for a long time, be sure to drop 2-3 drops of oil to the needle bar and drop it at the junction of the bar head and needle bar to ensure the needle bar mechanism is lubricated.





被加油机构 ( fueling agencies )

图 Figure4-2

## 五、缝纫机的使用方法

### Fifth、the use of sewing machines

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

Note: In order to prevent personal accident caused by the sudden start of the machine, please turn off the power, make sure the motor does stop turning and then operate!

#### 1、机针的安装方法

安装机针时，机针头部需要完全插入针古里，且机针凹槽部位向里侧。

#### 1、the needle installation method

When installing the needle, the needle head needs to be completely inserted into the needle clamp, and the needle groove is to the inside.

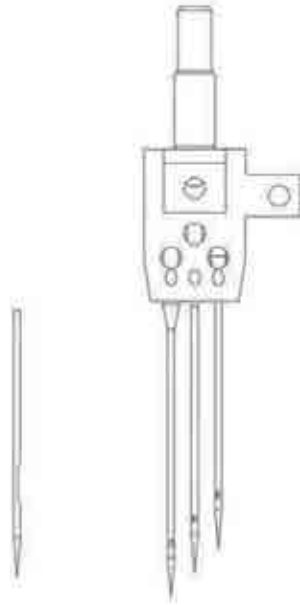


图 5-1

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

Note: In order to prevent personal accident caused by the sudden start of the machine, please turn off the power, make sure the motor does stop turning and then operate!

2、穿线方法

2、threading method

①、标准穿线法：①, standard threading method:

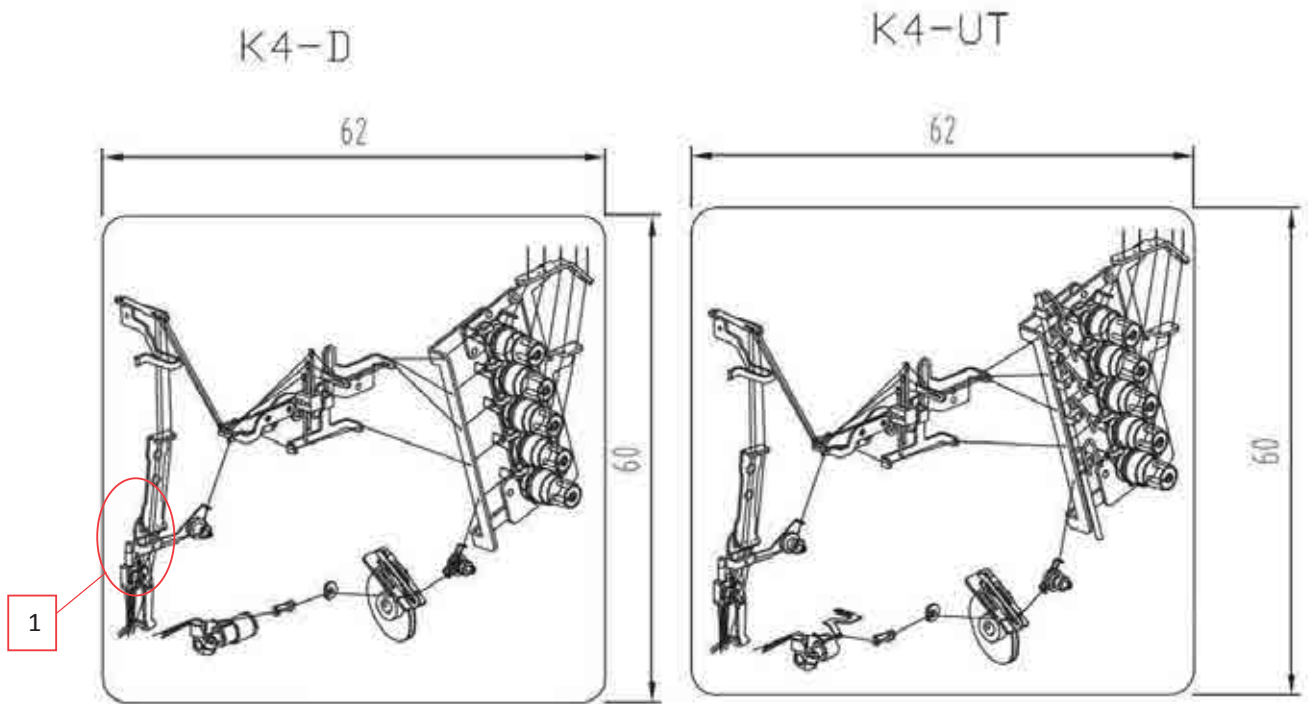


图 5-2

当机针线伸缩量较大时 : When the needle thread stretching in a larger amount

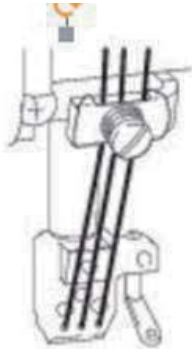


figure5-3

当机针线伸缩量较小时:When the needle thread stretching in a smaller amount

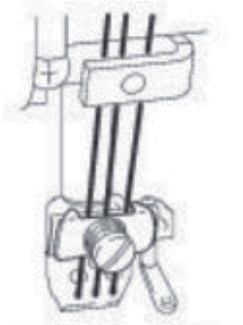


figure5-4

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

Note: In order to prevent personal accident caused by the sudden start of the machine, please turn off the power, make sure the motor does stop turning and then operate!

### 3、针距调节

### 3、stitch length adjustment

机器针距可以在 1.5mm-4.5mm 范围内任意调整(实际缝料线迹长度,随布料的种类和厚度有所不同),缝纫机针距的调节是通过旋转针距调节旋钮调节的,顺时针旋转,针距变大,逆时针旋转,针距变小。

Machine stitch length can be adjusted within the range of 1.5mm-4.5mm (actual sewing stitch length, depending on the type and thickness of the cloth). The sewing machine stitch length is adjusted by rotating the stitch length adjusting knob. Clockwise Rotation, needle length becomes larger, counterclockwise rotation, stitch length becomes smaller.

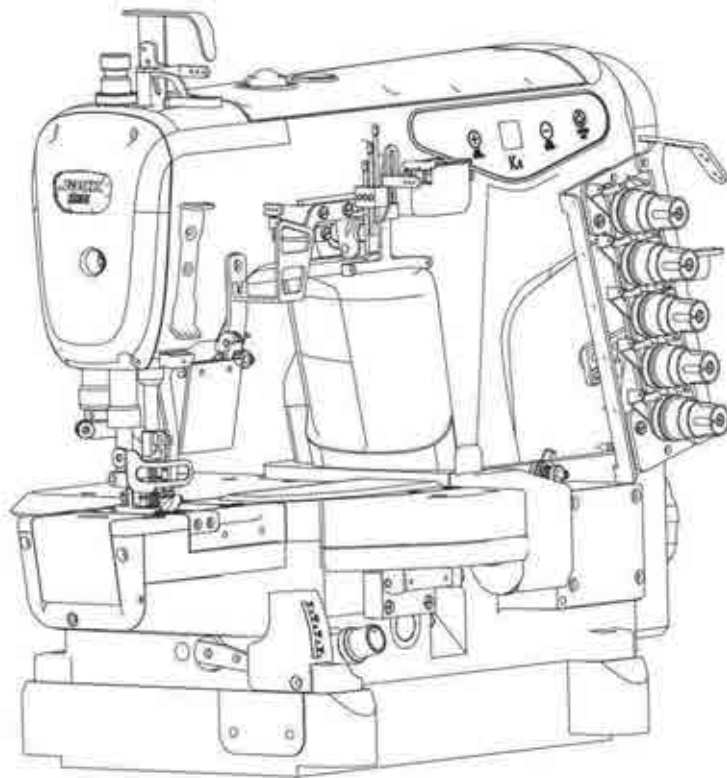


图 5-5 Figure 5-5

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

Note : In order to prevent the machine from personal accident suddenly, please turn off the power supply, confirm the motor really stop running again then operate !

#### 4、差动的调节 Differential regulation

差动调节范围在 0.8-1.3 内，松开调节螺钉，上下扳动，往上是顺差动，往下是逆差动。Within differential range of 0.8-1.3, loose and adjust screw, throw up and down, up is To Shrink, down is To Stretch.

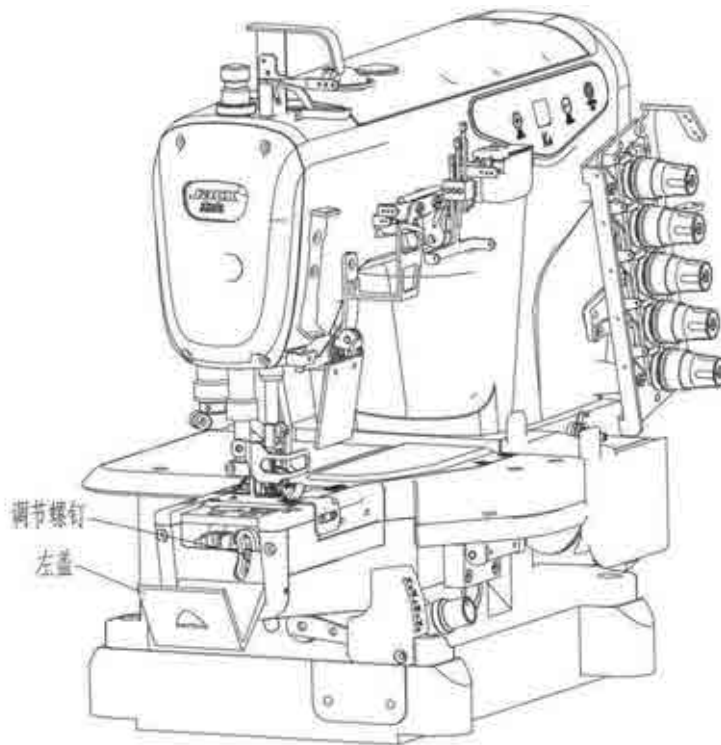


图 5-6 Figure 5-6

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

Note : In order to prevent the machine from personal accident suddenly, please turn off the power supply, confirm the motor really stop running again then operate !

#### 5、压脚压力调节 Adjust presser foot pressure

请把压脚压力在缝迹稳定范围内尽量调弱

调节压脚压力时，拧松压脚调节螺母，并将压脚调节螺杆顺时针或逆时针旋转，顺时针旋转则压脚压力变大，逆时针旋转，则压脚压力变小。

It should be as light as possible, yet be sufficient to obtain the proper stitch formation.

When adjust pressure for presser foot ,loosen adjusting screw presser foot , and make presser foot adjusting screw clockwise or counterclockwise

rotation, when clockwise, the pressure of presser foot is Heavy, when counterclockwise, the pressure of presser foot is Light.

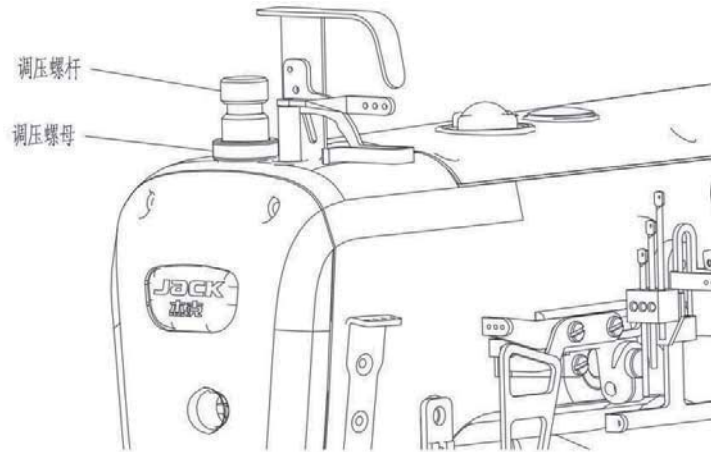


图 5-7 Figure 5-7

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

Note : In order to prevent the machine from personal accident suddenly, please turn off the power supply, confirm the motor really stop running again then operate !

## 6、线张力调节 Thread tension adjustment

夹线器按照布料、线、线迹宽度的不同，及使用条件的变化而变化。对照使用条件，调整夹线器的螺母，顺时针方向转，线紧；逆时针方向转，线松。

Thread clamp device according to the different fabric, thread and width of the thread, and the changeable conditions of use. Controlled conditions of use, adjust the nut thread clamp device, turn clockwise, tight thread; Turn counterclockwise, thread loose.

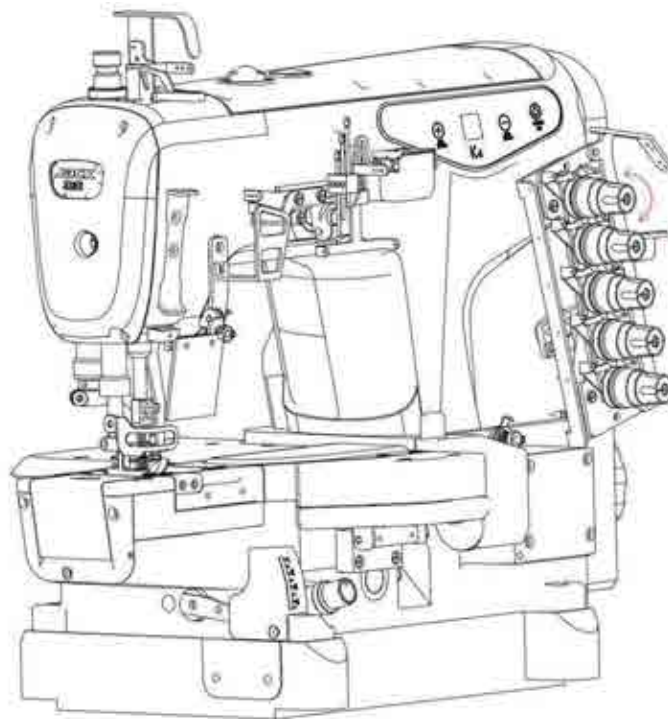


图 5-8 Figure 5-8

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作！

Note : In order to prevent the machine from personal accident suddenly, please turn off the power supply, confirm the motor really stop running again then operate !

#### 7、滤油器的检查和更换 Inspect and replace oil filter

过滤器有灰尘在上面，不能正常使用，每使用 6 个月后请进行检查或更换。

注：如果油按规定的油量加入，油窗喷出的油量异常、过弱、有气泡等现象时，请及时更换或清扫过滤器

There are dust on oil filter, it couldn't normal use, every six months for inspection or replacement, please.



Note: if the oil in accordance with the provisions, oil window spewing oil abnormal, too weak, the phenomenon such as bubbles, please timely replace or clean oil filter.

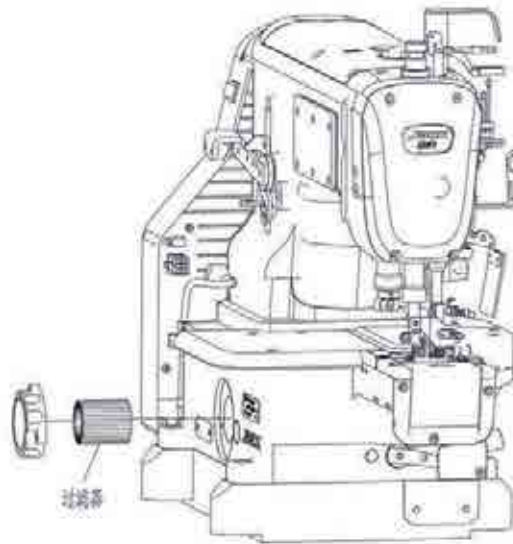


图 5-9 Figure 5-9

## 六、缝纫机调整 Sewing machine adjustment

注意：为了防止机器突然启动造成人身事故，请关掉电源，确认电机确实停止转动后再进行操作

Attention : In order to prevent the sudden start of the machine which causing a personal accident, please turn off the power, make sure the motor does stop rotating before operating!

### 1、冷却器导线器的调整

松开紧定螺钉，把各导线杆高度调整为图示的尺寸，然后拧紧紧定螺钉（图7-1），针对不同布料时可通过调节A、B、C的高度来调节挑线量，导线杆的高度增加挑线量减小，导线杆的高度降低挑线量增加（图1）。

#### 1、Cooler **wire** guide adjustment.

Adjust the release needle thread guide hight to the number below , then tightening screw ( Figure7-1 ) , Accounting to different fabric, we can change thread taking up length by adjusting needle thread guide hight A、 B、 C , Thread taking up quantity increase when needle thread guide hight decrease and thread taking up quantity decrease when needle thread guide hight increase. ( Figure 1 ) 。

A	B	C
12	21	32

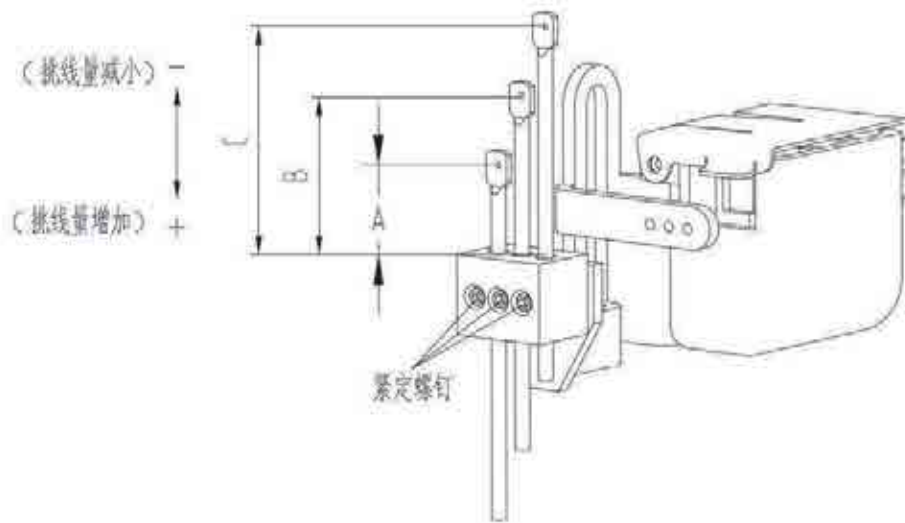


Figure 7-1

2、松开紧定螺钉，左右移动针线操作器，如图 2 所示，把针线操作器边缘到摆动挑线杆轴的中心调整至 80mm，然后拧紧紧定螺钉，针对不同布料时可通过调节针线操作器边缘到摆动挑线杆轴的中心距离来调节挑线量，针线操作器边缘到摆动挑线杆轴的中心距离加大，挑线量减小，针线操作器边缘到摆动挑线杆轴的中心距离减小，挑线量加大（图 8-2）。

2、Release set screw, shuffling the needle thread operator, showed by figure 8-2, change the distance between margin of needle thread operator and center of shuffling release pole rod to 80mm, then tight the set screw. For various type of fabric, we can adjust the thread taking up length by change this distance. The distance between margin of needle thread operator and center of shuffling release pole rod increase, the thread taking up length decrease. Also, the distance decrease, the thread taking up length increase.

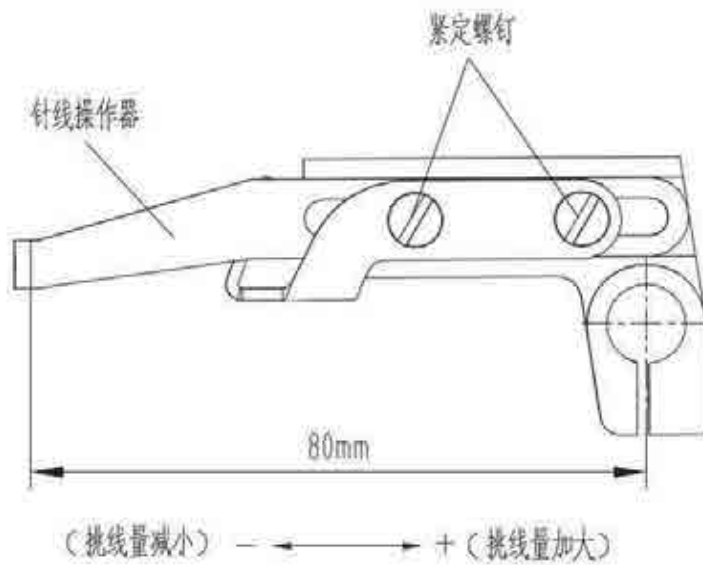


Figure8-2

### 3、分布导线器的调整

分布导线器①在最高点时，松开紧定螺钉③，分布导线器的导线线道里侧上端调整成与分布导线器的长槽下端一致，然后拧紧紧定螺钉③（图 8-3）。

### 3、Adjustment of spreader thread take up

① at the top point , release set screw③ , make the top of inner guide line fix to the bottom of guider slot, then tight the set screw ③ ( Figure 8-3 ) 。

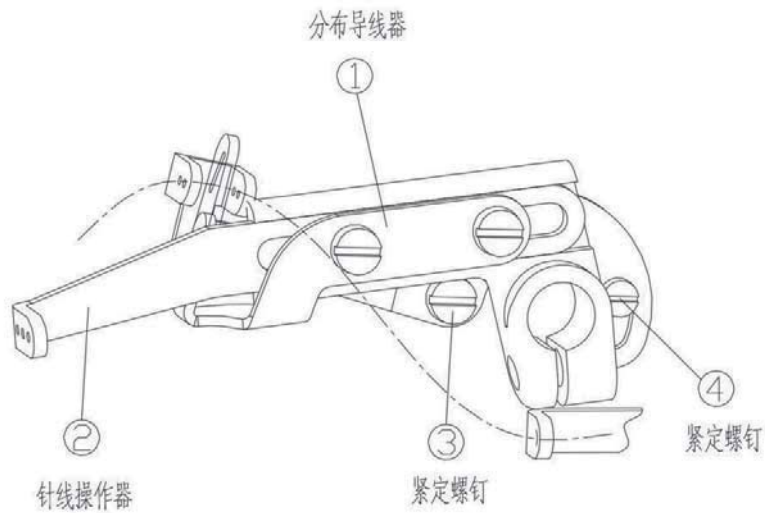


Figure 8-3

#### 4、打线凸轮及打线凸轮导线器的调整

##### ①、打线凸轮位置调整

当机针处于最高点时（图 8-4），调整打线凸轮，使之恰好开始打线。

#### **5. Adjusting the looper thread cam thread guide and the looper thread cam**

##### 1、Adjustment of thread cam and thread cam guider

##### ①、Hit thread cam adjustment

When needle at the top ( Figure 8-4 ) , adjust hit thread cam , make it at the position that just start hit thread.

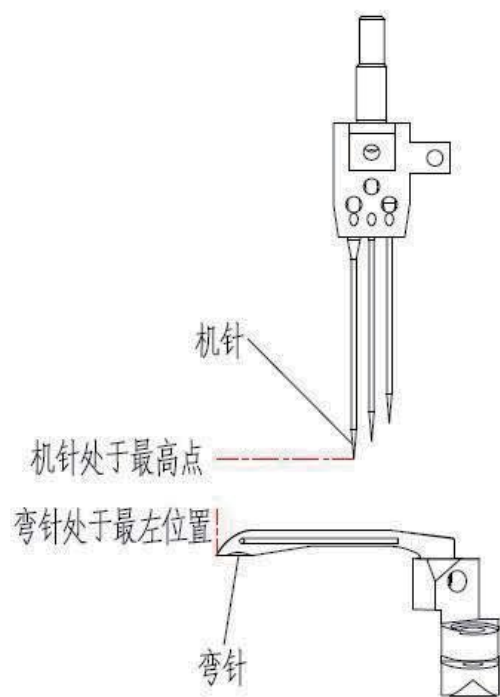


图8-4

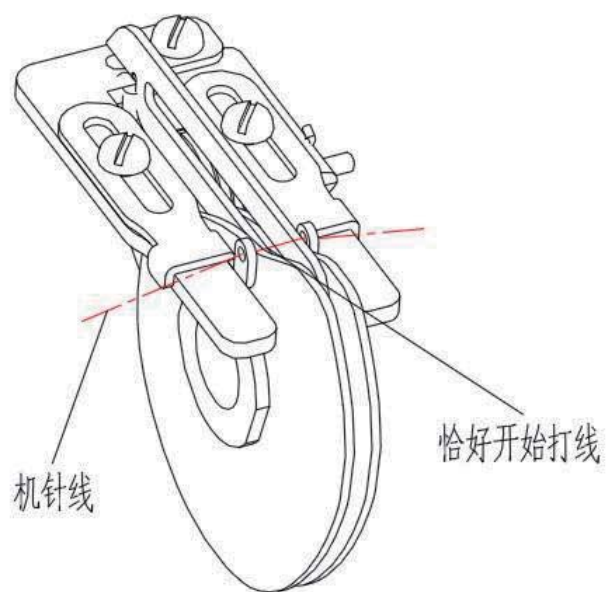


图5

## ②、打线凸轮打线量调整

当需要调节底线打线量时，松开紧定螺钉，调节分线片位置，分线片往上移动打线量减小，分线片往下运动，打线量增加。（图6）

## ②、Adjusting thread guides of CAM

When adjusting the base thread distance, first loose screw and adjust dividing thread plate position. If dividing thread plate moving up ,the thread distance get less, while vice versa.

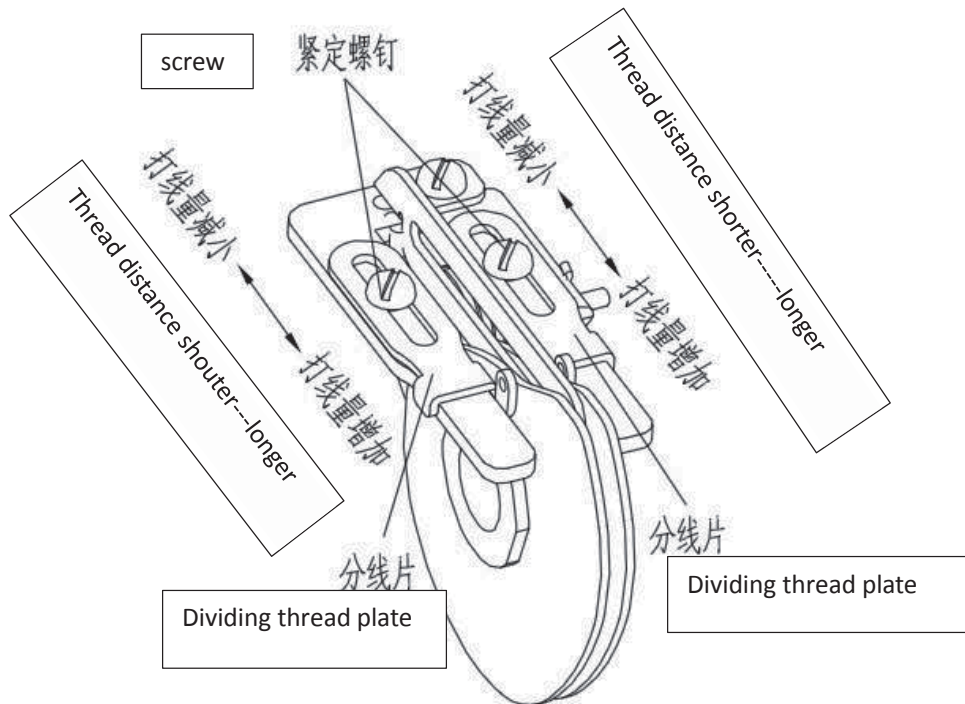


图6(Picture 6)

## 5、机针高度调整

首先调整机针与针板的间隙，保证机针与针板的间隙均等，调整机针高度，机针运行到最高点，针板到左针针尖的高度为H（图7），H参数如下表：

## 5、 Adjusting needle height

Firstly, adjusting the gap between the needle and the needle plate to ensure the gap is equal. And then adjusting needle height ,when the needle run to the highest point,the height of needle plate to left needle pinpoint is H( Picture 7),and H parameter as follows:

标准 standards 机型 Machine Model	标准行程 ( 30.8mm ) Standards(30.8mm)	高行程 ( 33.4mm ) Height(33.4mm)
型号 Model	左针高度H left needle Height	左针高度H Left needle Hight
K4-01GB×356	7.5	9
K4-01GB×364	7.1	8.6
K4-02BB×356	7.5	9
K4-01BB×364	7.1	8.6
K4-35AC×356	9	9
K4-35AC×364	8.6	8.6



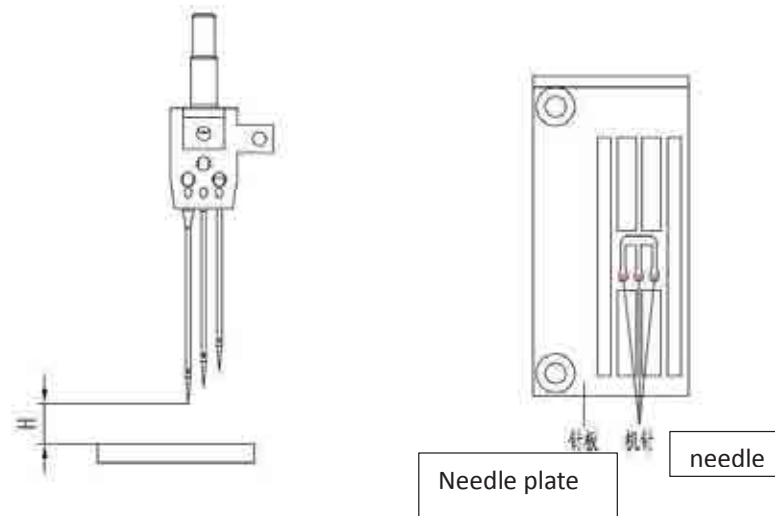


图7(picture 7)

## 6、弯针的调整方法

### 6、Looper adjusting method

#### ①、弯针与机针引量的调节

当机针在最低点时，弯针在最右点，弯针针尖到右针中心点距离为弯针与机针的引量A（图8），详细参数见下表：

#### ①、Adjusting the distance of looper to needle

When needle in the lowest point, and looper in the right end point, the distance between looper pinpoint to right needle middle point is called Leading distance A (Picture 8) between looper to needle, the detailed parameter see as follows:

	标准 Standard	标准行程 ( 30.8mm ) Standards(30.8mm)	高行程 ( 33.4mm ) Height (33.4mm)
机型 Model			

型号 Model	弯针与机针引量A Leading distance A between looper to needle	弯针与机针引量A Leading distance A between looper to needle
K4-01GB×356	3.5-3.8	3.0-3.2
K4-01GB×364	3.1-3.4	2.6-2.8
K4-02BB×356	3.5-3.8	3.0-3.2
K4-01BB×364	3.1-3.4	2.6-2.8
K4-35AC×356	3.1-3.3	3.0-3.2
K4-35AC×364	2.7-2.9	2.6-2.8

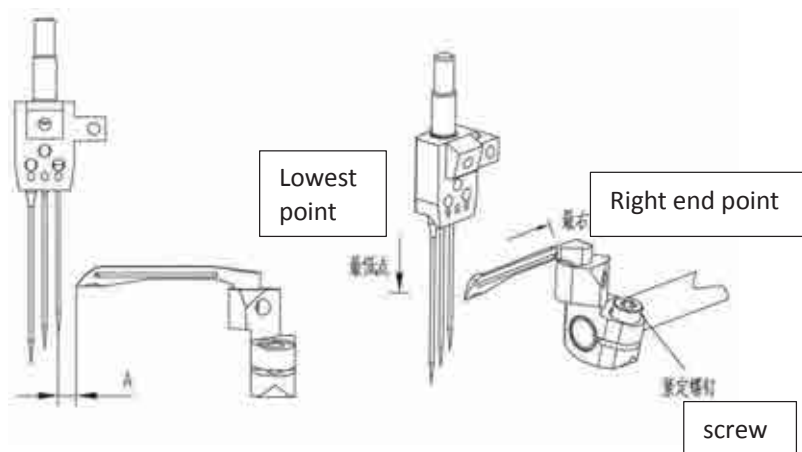


图8(Picture 8)

## ②、弯针与机针间隙的调整

弯针从最右端运行到中针中心后，把弯针与机针间隙调整为0-0.05mm（图9），弯针继续向左运动，当弯针运行到左针中心是，弯针与左针间隙为0.05-0.1mm（图9）。

## ②、Adjusting the distance between looper and needle

When looper moving from right at needle middle, adjusting the distance of looper and needle to be 0-0.05 mm(Picture 9), and looper continue to moving towards left, when is arrive the middle of left needle, the distance of looper and left needle is 0.05-0.1mm(picture 9) .

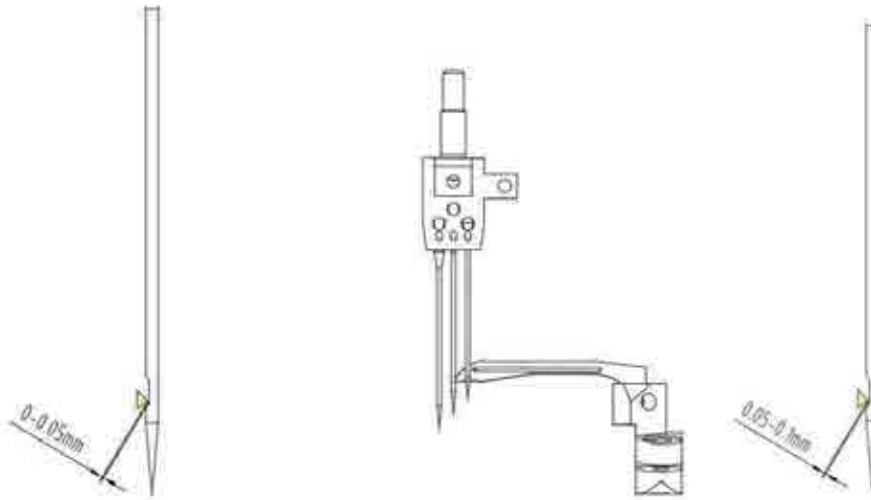


图9 Picture 9

### 7、后护针的调节

针杆在最低点时，调整后护针，使护针在右针孔上方1/3处，弯针先端最右位置开始到右针中心时>右针和弯针的先端前后间隙为0-0.05mm（图10）

### 7、 Adjusting rear guard needle

When the needle bar is at the lowest point, adjusting the rear guard needle to make it on 1/3 of the right needle hole, the right end of looper to the middle of right needle>the front and rear clearance of the right needle and looper is 0-0.05mm (Figure 10).

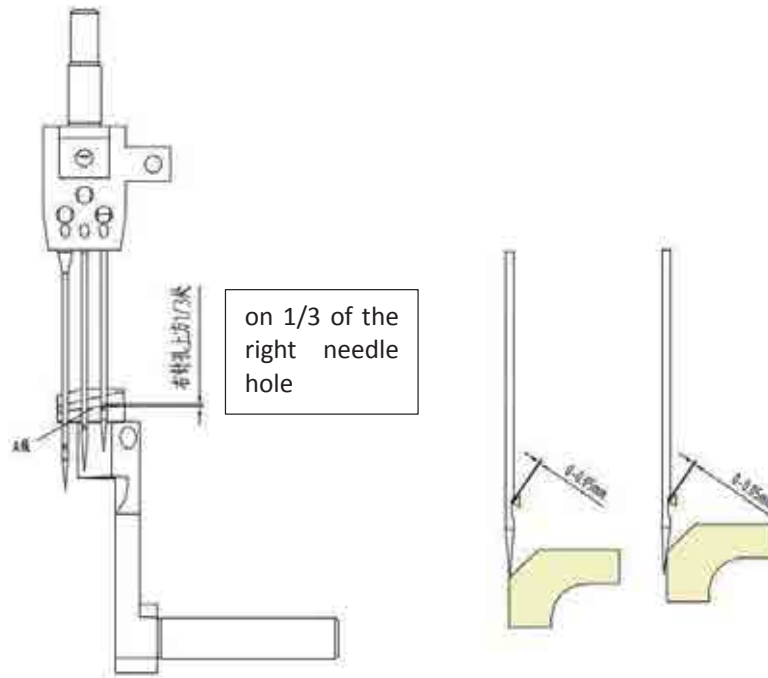


图10 picture 10

### 8、摆动挑线杆的同步和线环的关系

### 8、 The relationship between swing timing bar and thread loop

提要：如果由于线环过大或过小等找出机器跳针、断线时，可以通过调节摆动挑线杆来调整线环的大小。

Tips:you can adjust swing timing bar to adjust the size of thread loop, if the thread loop is too large or too small that leads to needle-skipping,thread-broken problems.

利用过线球连杆调整

Making use of over-thread bar to adjust

松开紧定，调节过线球连杆，移动过线球连杆想前或向后，向前移动则线环变小，向后移动则线环变大。（图11）

Loose set, adjusting over-thread bar, moving the bar forward or backward,

if forward movement, the thread loop get smaller, otherwise if backward movement, the thread loop get larger.

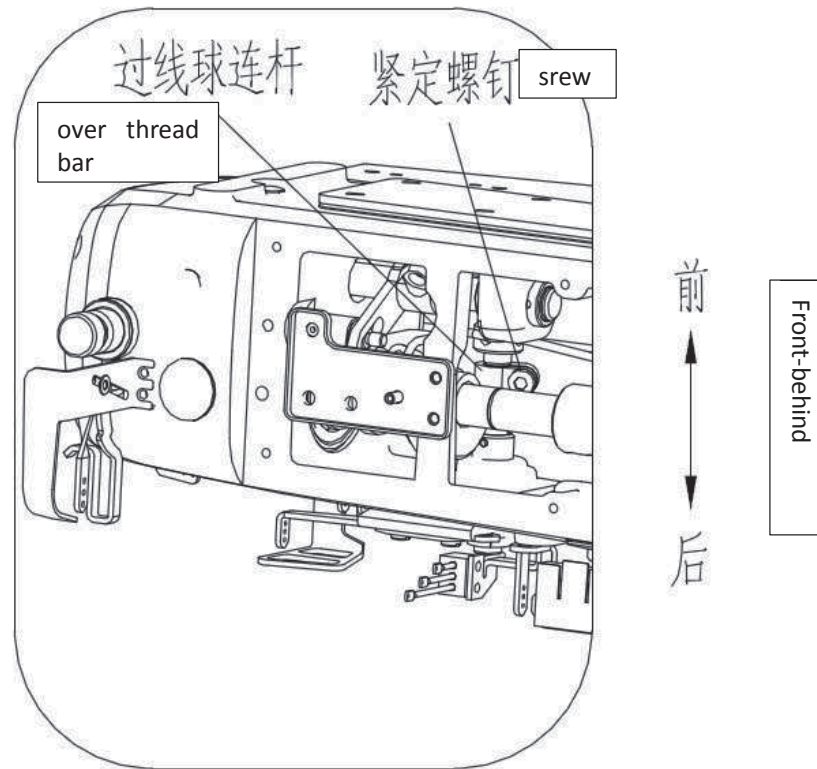


图11 (Picture 11)

### 9、送布牙高度的调整

### 9、 Adjusting feed teeth height

调整送布牙高度 ,牙齿来到最高点时 ,松开螺钉2 将主送布牙高度调整刀1.2mm ,  
然后拧紧螺钉2 ,同理松开螺钉1 ,将差动送布牙的高度调整到1.2mm ,然后拧紧螺钉1。

Adjusting feed teeth height,when feed teeth get the maxmium point,loose srew2,and adjusting the feed teeth height to 1.2mm,then ,tighten screw2 and loose screw1, adjusting the feed teeth

height to 1.2mm, and after that tighten screw 1.

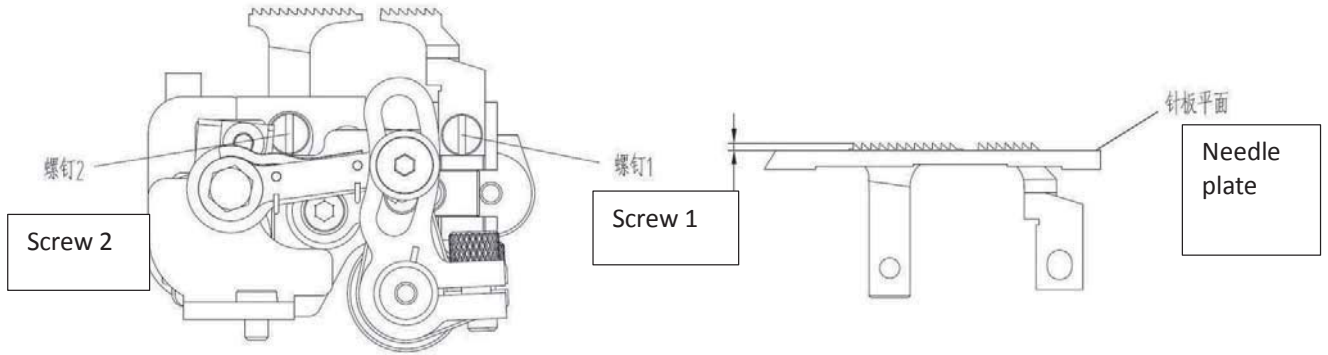


图12 picture12

#### 10、喂针的安装位置

#### 10、Installation position of spreader

喂针高度是针板上平面到喂针下面的距离为H，调整喂针高度，松开螺钉1，上下移动喂针（图13），使其高度为为H，H的具体取值如下表：

Spreader height H is the distance between needle plate to needle ,adjusting Spreader height, and loosening screw 1, then move Spreader up or down (picture 13) to adjusting the height is H, the specific references as follows:

	标准	标准行程 ( 30.8mm )	高行程 ( 33.4mm )
机型model		Standards(30.8mm)	Height(33.4)

型号 model	喂针高度H Spreader height H	喂针高度H Spreader height H
K4-01GB×356	7.8	9.2
K4-01GB×364	7.8	8.8
K4-02BB×356	7.8	9.2
K4-02BB×364	7.8	8.8
K4-35AC×356	7.8	9.2
K4-35AC×364	7.8	8.8

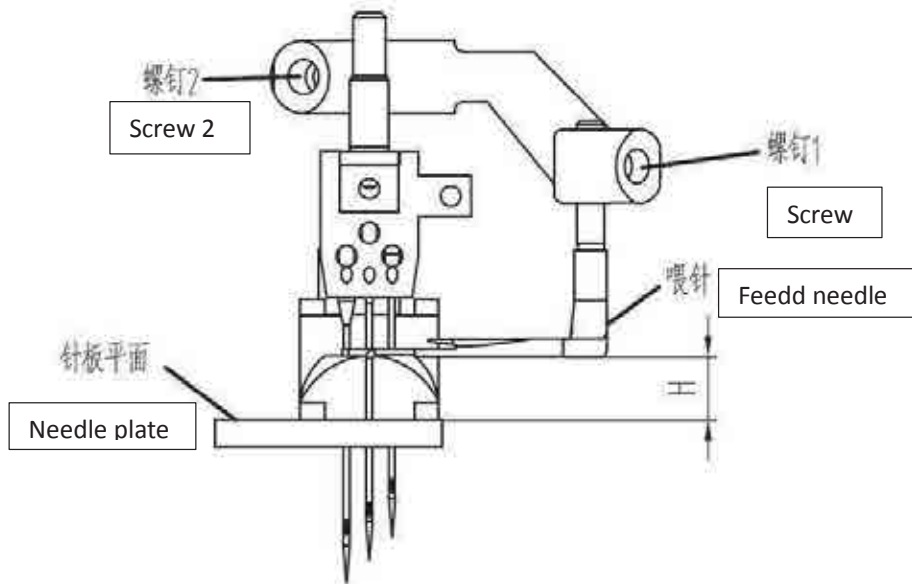
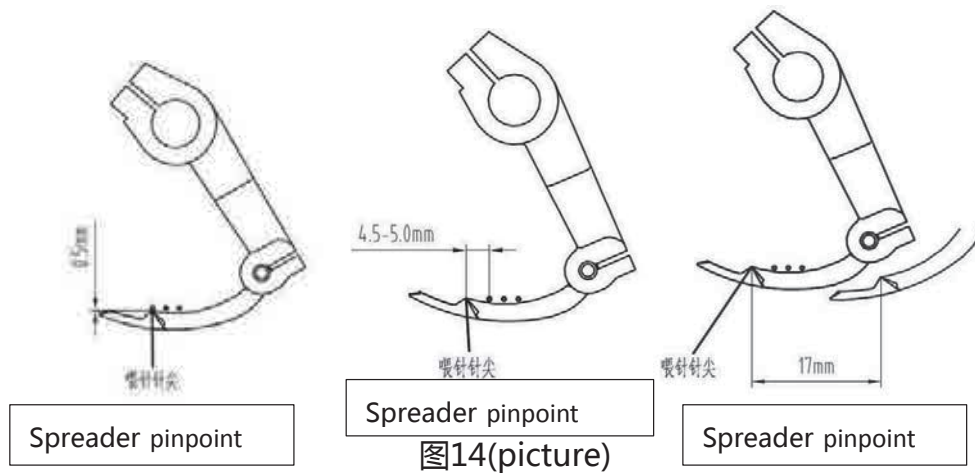


图13(Picture 13)

喂针从右往左运动，松开螺钉1，调整喂针针尖与左针间隙调整喂0.5mm，喂针继续向左运动到左极限，松开螺钉2，调整喂针与左针中心的间隙为4.5-5.0mm，然后拧紧螺钉2。

Spreader moving from right towards to left, loose screw 1, adjusting the distance between Spreader pinpoint and left needle to be 0.5mm, and continue moving to the left limit, loose screw 2, adjusting the distance between Spreader and left needle center to be 4.5-5.0mm, then tighten screw 2.

Spreader continue to move towards left to the end; and then loosening screw 2, adjusting the distance between Spreader and left needle middle to be 4.5-5.0mm, next is tighten screw 2.



11、弯针向左运动通过各针的内侧，调整针和前护针和的间隙为0.3-0.5mm，对照线的粗细，针线能顺利通过，前护针尽量靠近安装。调整前护针与前护针架为0.5mm。

11. Looper moving towards left through the inside of all needles, adjusting the distance between needle and front guard needle to be 0.3-0.5mm. Checking thread is thick or thin to ensure the thread can be pass needle successfully, the front guard needle should near to installation. And adjusting the distance between front guard needle and front guard needle protect device to 0.5mm.



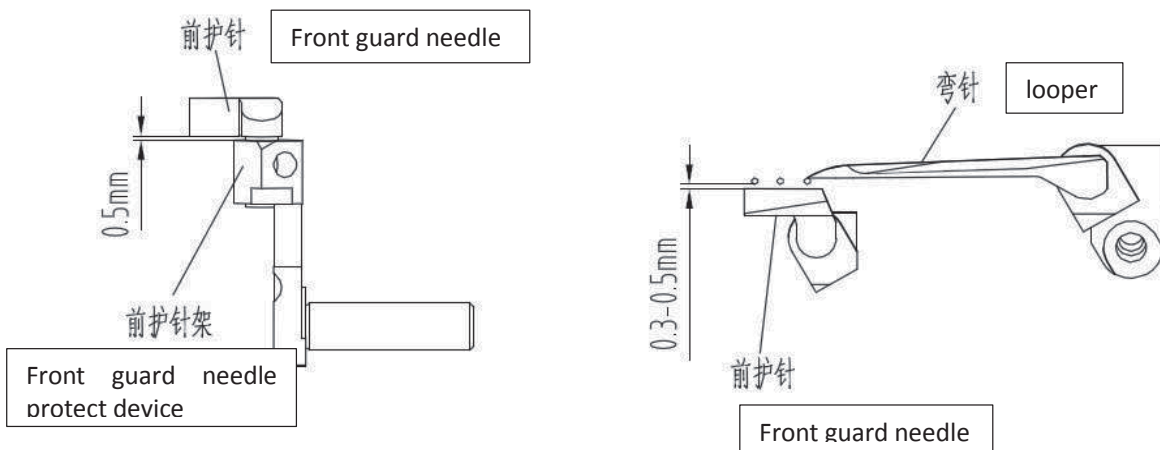


图15

12、压脚高度调节

12. Adjusting presser height

调节压脚高度时，调整螺钉的高度，不让压脚和其他零件相接触，然后用螺母进行固定。

When you are adjusting presser height, you should adjust the screw height to avoid presser touching other spare parts, and then fix it withnut

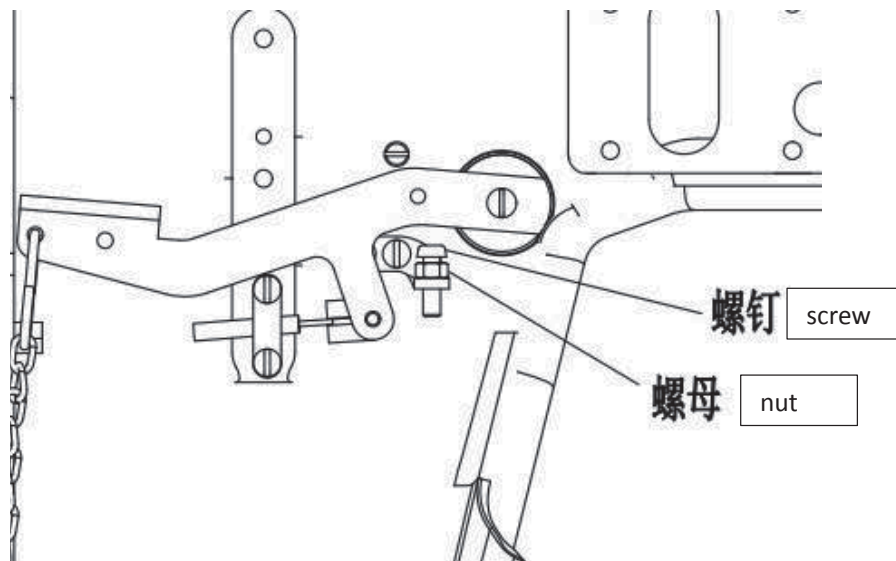


图16

## 七、下切刀调整 adjust lower cutter

### 1、下切刀左右位置调整 adjust left and right positions of lower cutter

进行下切刀调整时应使缝纫机机针处于上停针点，并关闭电控进行手动调试，手推剪线电磁铁运动通过刀盘驱动连杆带动下切刀组件向左运动（图 1），动刀向左移动（机头位置）到最左时，，动刀刀 b 尖须超出弯针孔 0.5-1.0mm，定刀下平面与弯针上平面间隙为 0-0.1mm（图 2），调节下切刀左右位置可松开紧定螺钉 2，通过调节曲柄 2 左右方向来调节下切刀位置（图 3），

When we adjust lower cutter we need to made needle point in the above on the sewing machine , and close the electronic control to manual debug,the movement of hand shear wire magnet is through the to make lower cutter component movement to the left (figure 1), At the time of the moving cutter moves to the far left position (nose position), the point of moving cutter should be 0.5 -1.0 mm beyond the hole of the looper, distance between the lower plane of the stationary knife and upper plane of the looper is 0-0.1 mm (figure 2), Adjusting the left and right position can loosen the 2, by adjusting the crank 2 left and right to regulate lower cutter position (figure 3),

当下切刀组件复位时，下切刀组件刀架与下切刀安装版边缘距离为 4mm（图 4），如上述条件在调节过程中无法同时满足，则需要通过松开调节螺母 1 与调节螺母 2 来调节剪线电磁铁行程，通过调节电磁铁行程满足上述调节要求，剪线电磁铁标准行程为 20mm（图 3）。

when lower cutter component reset, distance between component tool rest of the lower cutter and incised edge of lower cutter is 4 mm (figure 4), if the above conditions can't meet at the same time, then need to loosen nut 1 and nut 2 to adjust the process of shearing electromagnet, by adjusting the process of shearing electromagnet to meet the requirements of the above regulation, standard of shearing electromagnet is 20 mm (figure 3).

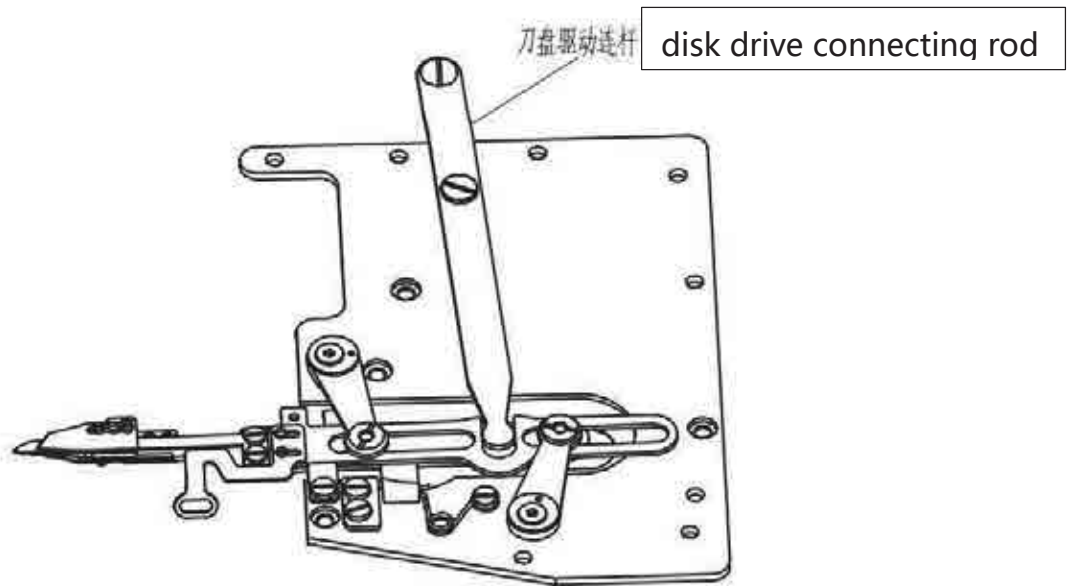


Figure 1

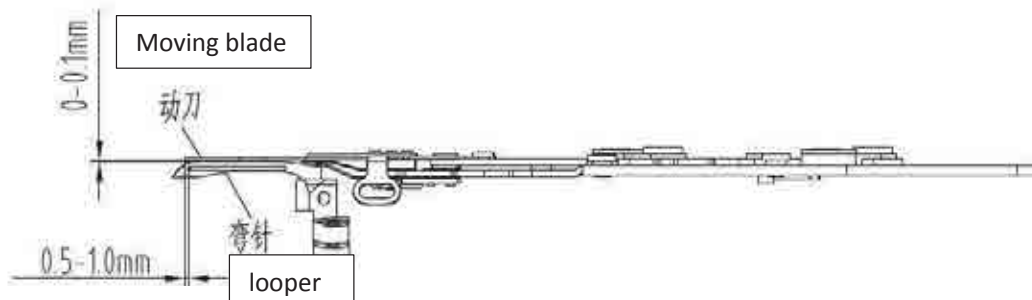


Figure 2

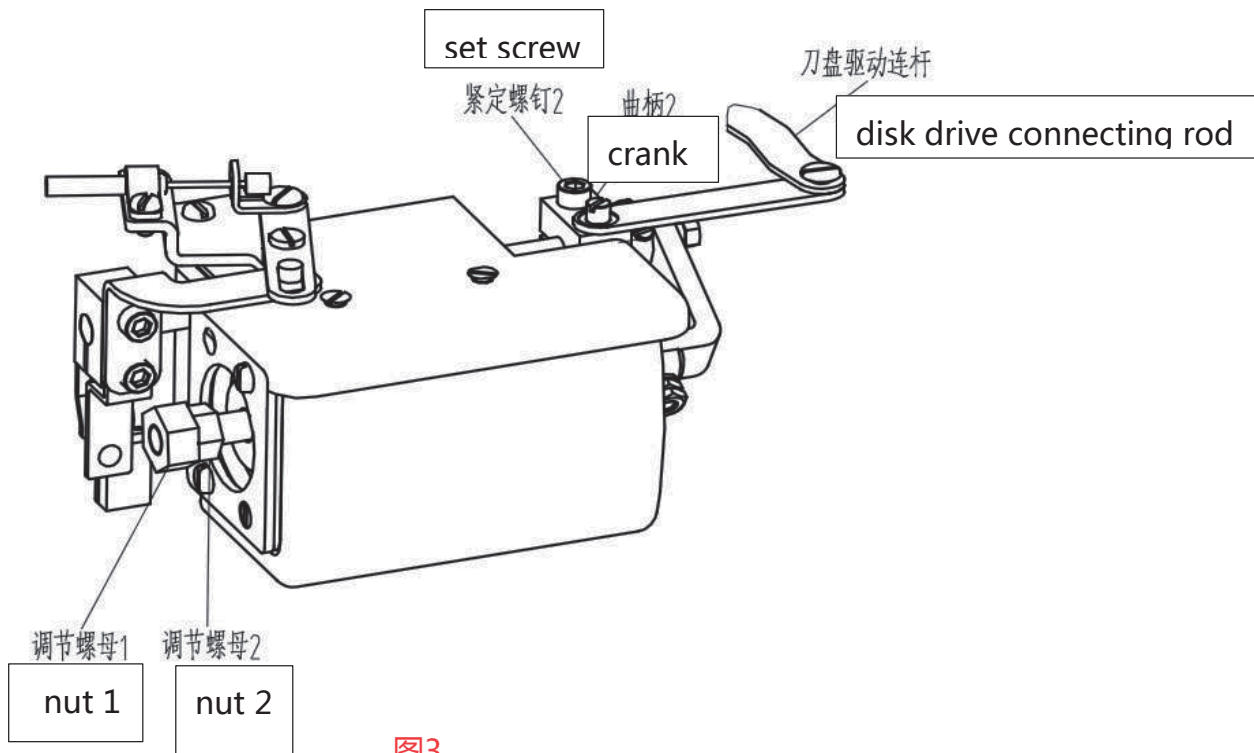


图3

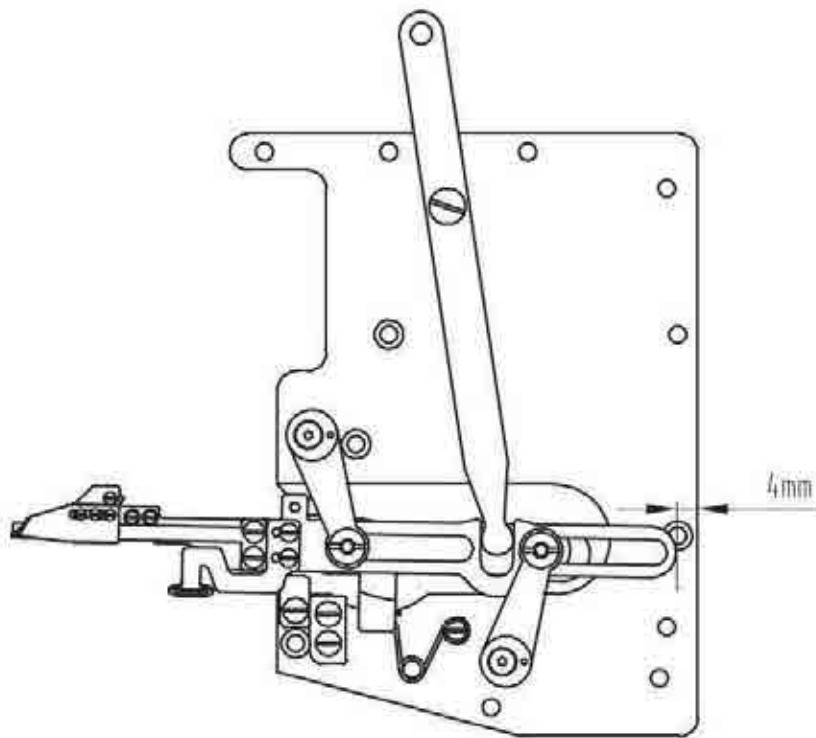


图4

## 2、下切刀前后位置的调整

adjust before and after positions of lower cutter

当下切刀组件由初始位置向左运动，动刀刀尖运动到弯针处，约在弯针宽度中心，前后 1/2 位置（图 5），调整时可通过松开紧定螺钉 2，再转动偏心销，使动刀前后移动，调整刀正确位置（图 6）。

When lower cutter components moves from the initial position to the left, the moving blade moves to the place of looper, roughly in the center width of the looper, 1/2 position (figure 5), we can by loosening set screw 2, then turn to made it move back, adjust the cutter correct position (figure 6).

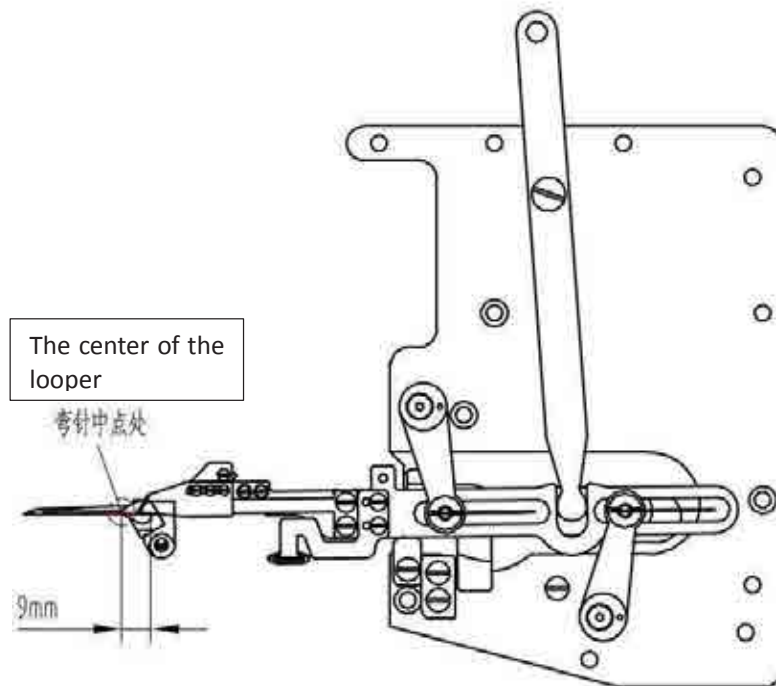


图 5

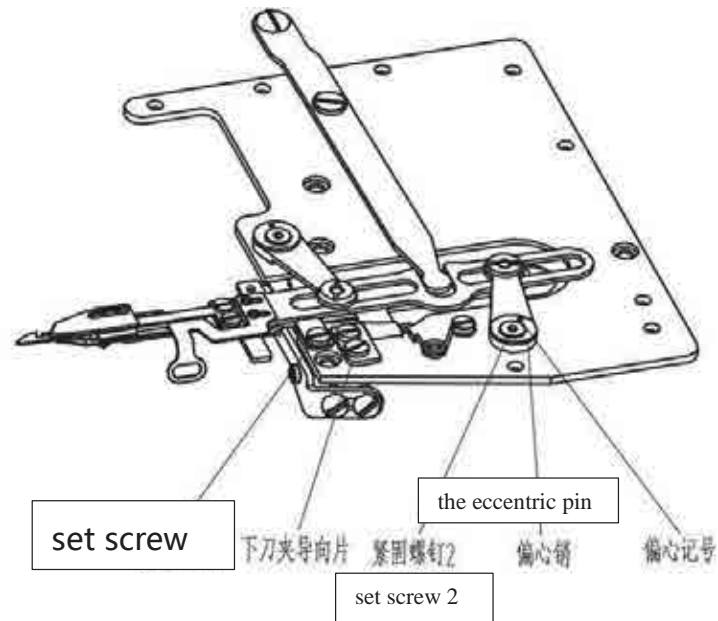


图 6

### 3、下切刀组件相对位置调整

Adjust relative position of the lower blade component

注意:下切刀组件安装前须先检查下切刀组件相对位置是否正确, 是否有卡点。

Note: Before install the lower blade ,we must check the relative position of the lower blade component and there is a card point or not.

当动刀运动到最右时, 也就是下切刀组件初始状态时, 动刀与定刀前端的啮合距离为 0.5-1mm (图 7), 调整时可通过松开螺钉 1 (图 9), 移动定刀调整动刀与定刀的相对位置, 动刀与定刀啮合距离 0.5-1mm, 动刀与定刀平行(图 7、图 8)。松开螺钉 1 调整夹线片的前后及左右位置, 保证夹线片与定刀平行(图 10)。压力片的调整可通过调节螺钉 4, 移动压力片, 使其与定刀尖端距离 4mm, 且与定刀平行(图 11)。

When moving blade moves to the far right, when is it in the original

state, the engaging distance between the point of moving blade and fixed blade is 0.5-1 mm (figure 7), adjustments can be loosen screw 1 (figure 9), moving the fixed blade to adjust the relative position of the moving blade with the fixed blade, engaging distance between the moving blade and the fixed blade is 0.5-1 mm , at that time the moving blade is parallel to the fixed blade (figure 7 and figure 8).

Loosen the screw 1 to adjust the before and back distance , and ensure that the clip is parallel to the fixed blade. (FIG. 10).

The adjustment of the clip can be adjusted by adjusting the screw 4, moving the clip, to make the distance between it and fixed cutter is 4mm, and is parallel to the set cutter. (figure 11).

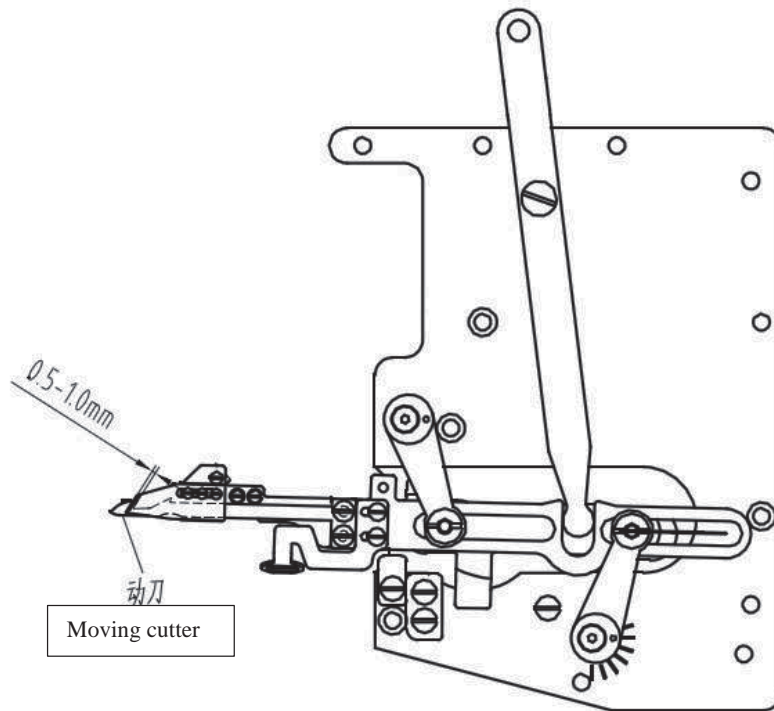


图 7

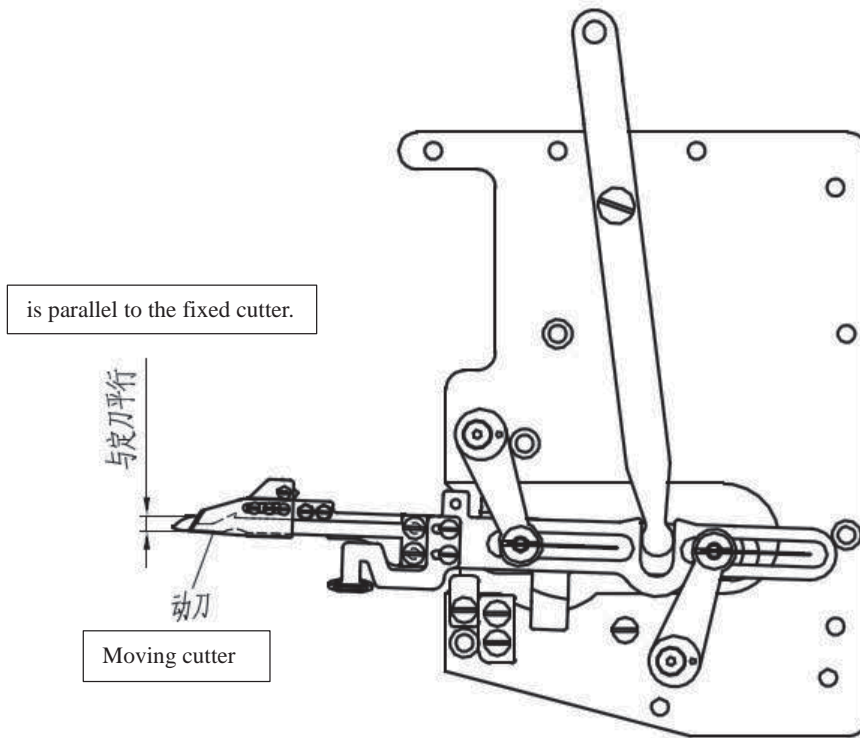


图 8

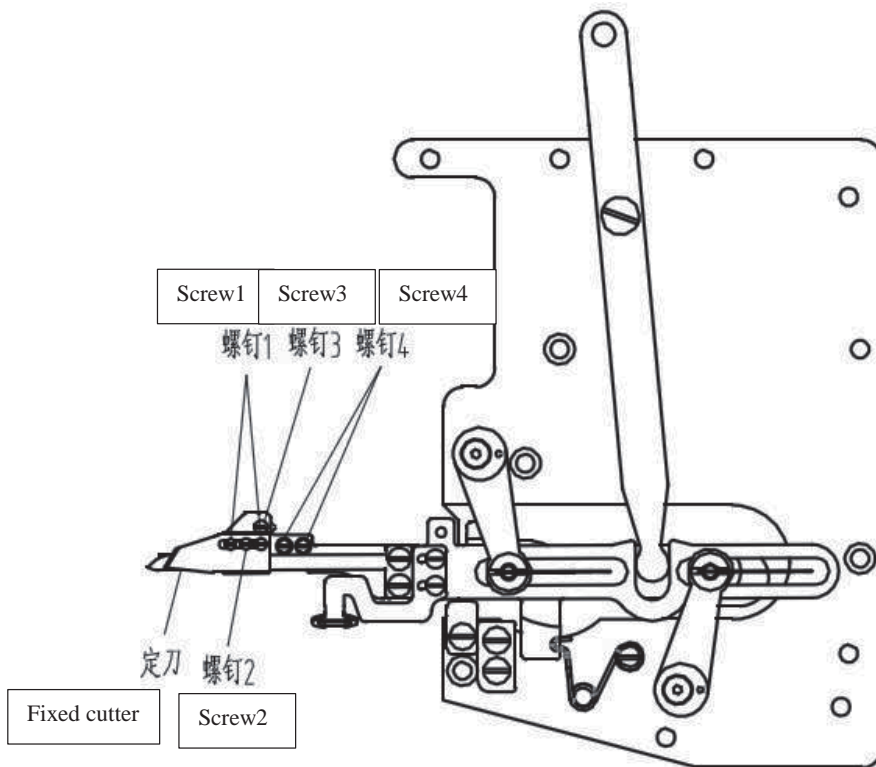


图 9



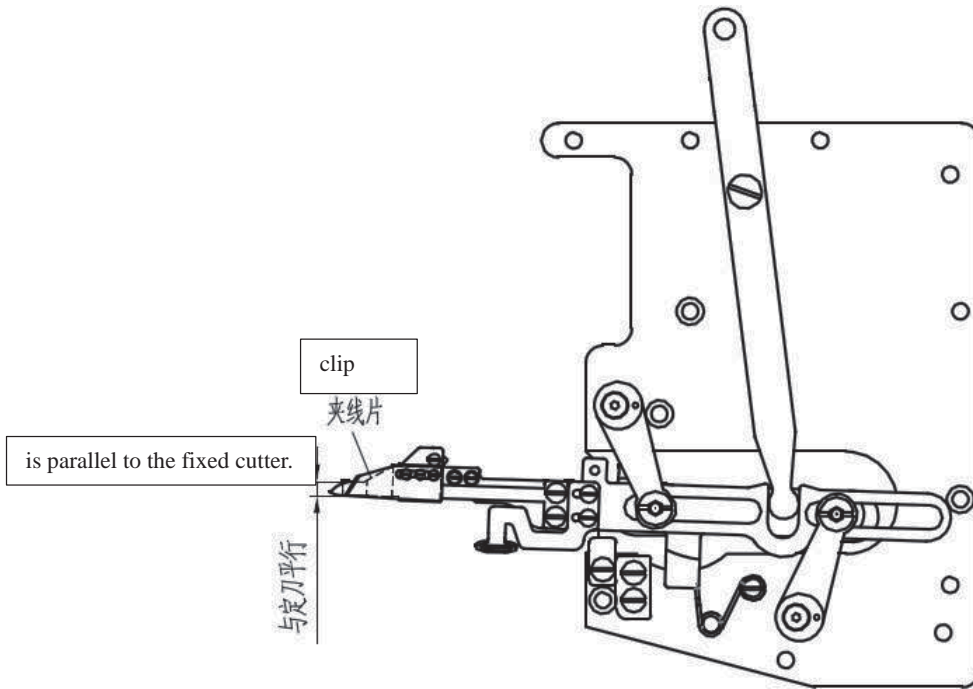


图 10

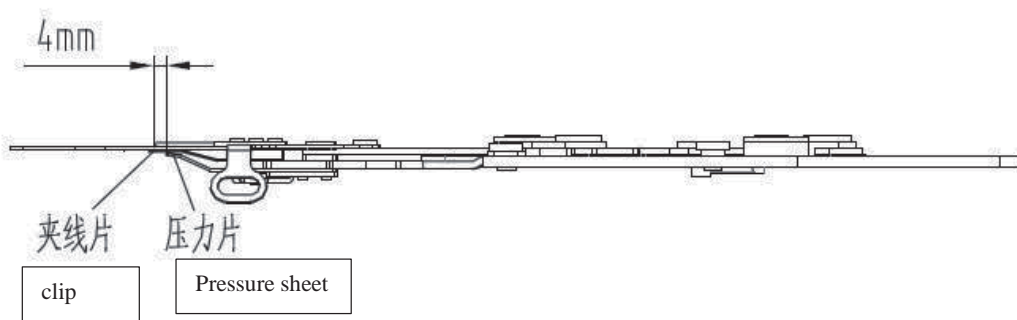


图 11

#### 4、夹线片及压力片的调整

##### Adjust clip and pressure sheet

当下弯针线被下切刀组件切断后，动刀与夹线片需将底线（下弯针线）稳定夹住，调节夹线片与动刀之间的夹紧力，可由紧定螺钉旋转来调整，顺时针方向则夹紧力越大，反之则夹紧力越小（图 12）。

When the lower looper was cut of lower blade components , we need use moving blade and the clip to steadily the bottom line (lower looper) , to adjust the clamp force between the clip and moving blade ,it can be adjusted by rotating set screw , clockwise for clamp force is bigger and bigger, otherwise is smaller and smaller. (figure 12).

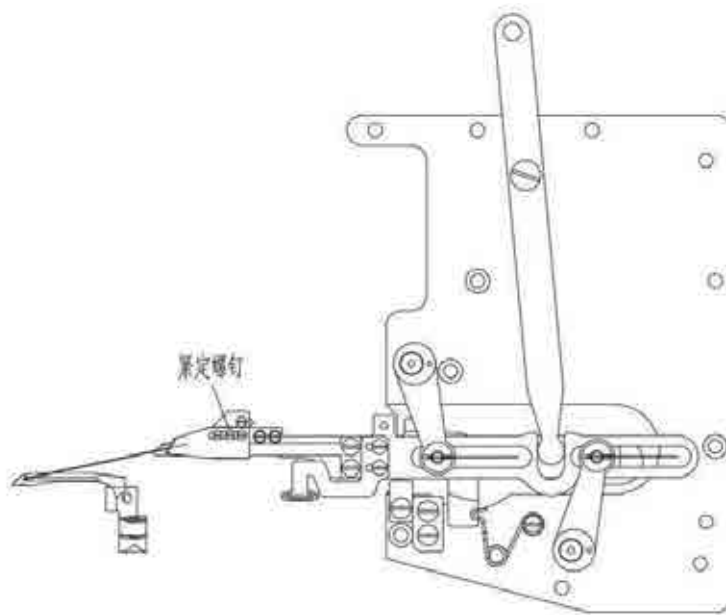


图 12

注意：

- 1、下切刀组件完成调试后，需再次手动推动下切刀组件的定刀剪线，确认相对位置准确，下切刀组件推出及复位均无卡点后方可重启电控，然后进行剪线。
- 2、当下切刀组件需要进行调整时，需确认针杆处于最高点，下弯针处于最右点，然后方可手动推动下切刀组件确认相关位置。

#### 八、上切刀组调整

注意：安装调整上切刀组前，必须先确认针杆处于最高点，且喂针与机针位置处于

标准状态。

#### 1、上切刀组动刀与定刀啮合量的调整

请把定刀与动刀的啮合量调整为0.5-1.0mm，可通过松开紧定螺钉，上下移动动刀架，调整定刀与动刀的啮合量为0.5-1.0mm（图13）。

note:

1. After the lower cutter assembly is finished debugging, it is necessary to manually push the cutter of the lower cutter assembly again to confirm the relative position is accurate. The lower cutter assembly is released and reset without any stuck before restarting the electric control and then cutting the wire.

2, when the lower cutter assembly needs to be adjusted, be sure to confirm the needle bar at the highest point, the lower looper at the far right point, and then can only manually push the lower cutter assembly to confirm the relevant position.

Second, adjust the top cover thread trimmer

Note: Before installing and adjusting the top cover thread trimmer, confirm that the needle bar is at the highest point and the position of the needle and the needle are in the standard state.

1, on the knife group knife and fixed knife meshing amount of adjustment  
Adjust the amount of engagement between the fixed knife and movable knife to 0.5-1.0mm. By loosening the set screw, move the movable knife

holder up and down to adjust the amount of engagement between the fixed knife and movable knife to 0.5-1.0mm (Figure 13).

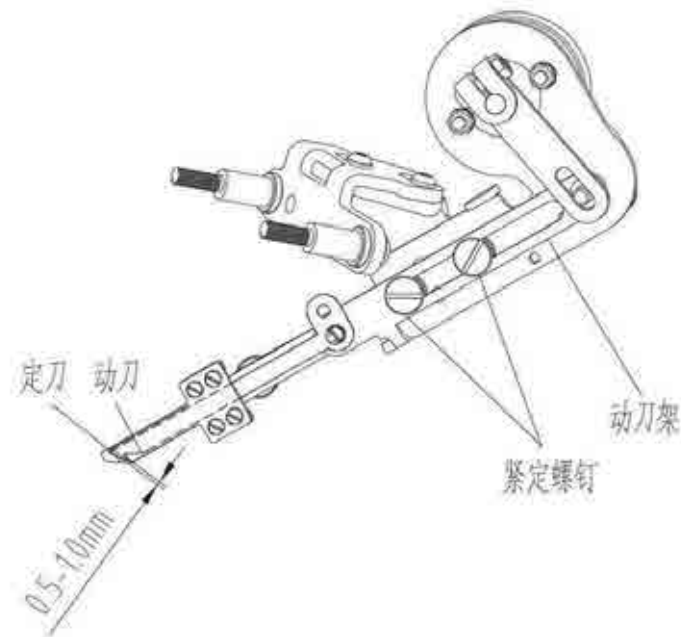


图13

## 2、上切刀组弹簧夹紧力的调整

上饰线切线后，被夹紧弹簧夹持，调节夹紧弹簧夹紧力，松开紧定螺母转动紧定螺钉，可以调节夹紧弹簧的夹紧力，拧紧紧定螺钉夹紧弹簧夹紧力加大，拧松紧定螺钉夹紧弹簧的夹紧力减小，调整完成后，拧紧紧定螺母（图14）

注意：请在能夹紧上饰线的范围内，尽量把夹持力调整到稍小范围！

## 2, spring clamping force of up thread trimmer asms adjustment

Trim the upper thread trimmed by the clamping spring to adjust the clamping force of the clamping spring and release the clamping nut to rotate the clamping screw to adjust the clamping force of the clamping

spring and tighten the clamping screw. If the force increases, loosen the set screw. The clamping force of the clamping spring decreases. After the adjustment is completed, tighten the set nut (Figure 14)

Note: Please be able to clamp the upper decorative line range, try to adjust the clamping force to a lesser extent!

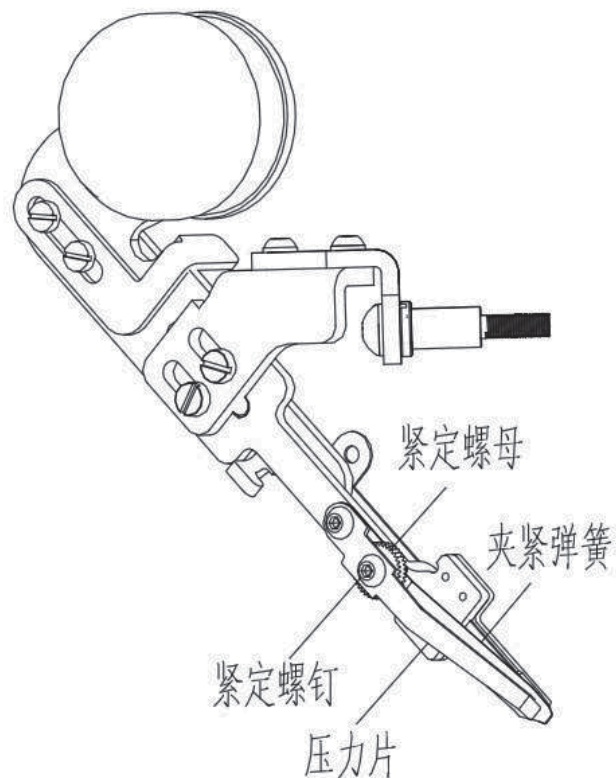


图14

### 3、上切刀组高度及角度的调整

当动刀往下运动，并运动到最低点时，动刀需在喂针与机针中间位置，动刀尖与压脚间距2-3mm，可通过调节紧定螺钉3和紧定螺钉4来调节安装板左右位置，从而调节上切刀组的角度，使动刀在机针和喂针中间（图15），动刀勾尖与喂针勾尖

基本齐平（图17），松开紧定螺钉1，上下移动挡板，可以调节动刀行程，同时松开紧定螺钉2，将整个上切刀上下移动，调节上切刀组的行程，调节标准。动刀运行到最低时，动刀尖与压脚间距为2-3mm。（图16）

3, on the top cover thread trimmer height and angle adjustment

When the movable knife moves downward and moves to the lowest point, the moving knife needs to be positioned between the needle and the needle. The distance between the movable knife tip and the presser foot should be 2-3mm. By adjusting the set screw 3 and the set screw 4 Adjust the mounting plate to the left and right to adjust the angle of the upper knife set so that the knife is centered between the needle and the needle (Figure 15). The tip of the knife is essentially flush with the tip of the needle (Figure 17) Set screw 1, move the baffle up and down, you can adjust the movable knife stroke, while loosening the set screw 2, move the entire cutter up and down, adjust the stroke of the cutter group, adjust the standard. Moving knife to the lowest operation, moving the tip and presser foot spacing of 2-3mm. (Figure 16)

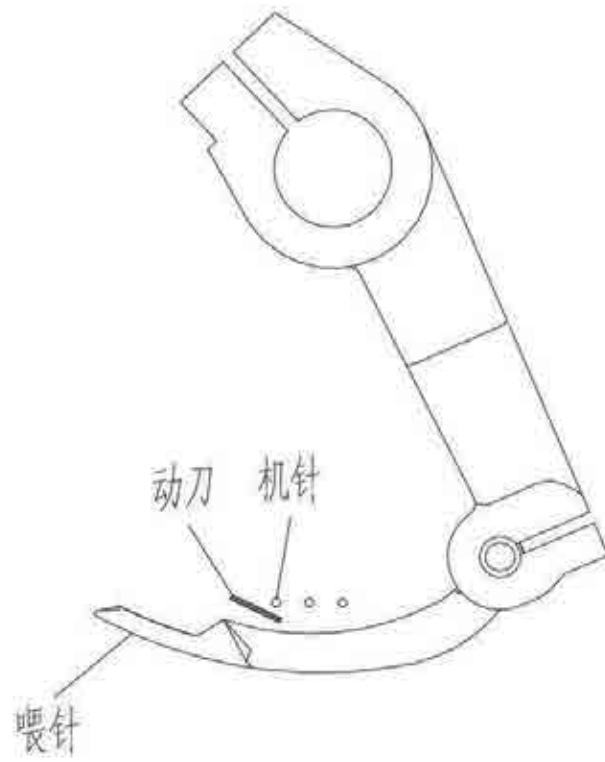


图15

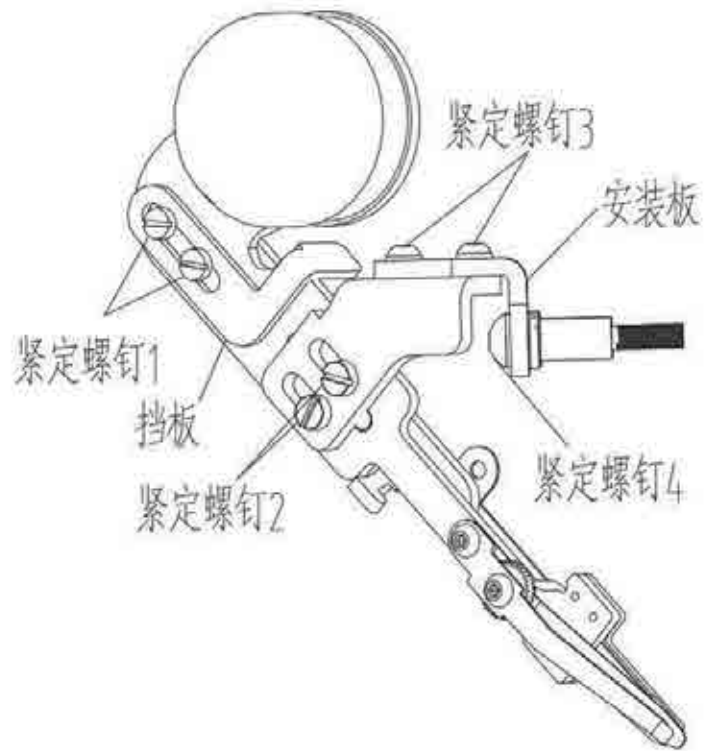


图16

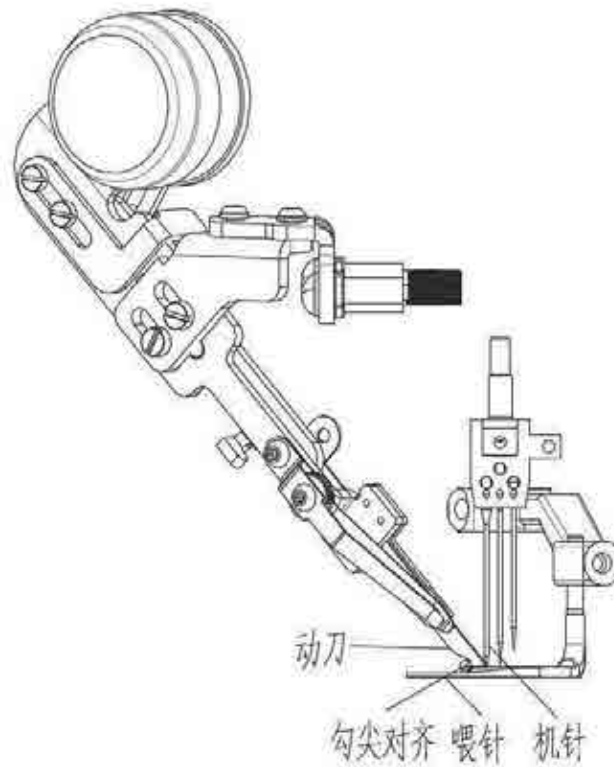


图17

## 九、拔线器的调整

### 1、拔线器高度调整

当拔线片往下运动到最低点时，拔线片底面与左机针（长针）针尖齐平（图18）。可以通过松开紧定螺钉1来调节拔线器上下位置，从而调节拔线器的高度（图19）。

### 2、拔线器前后位置调整

当拔线器通过压脚时，拔线片与压脚的间隙为1mm（图18），可通过松开紧定螺钉2来调节拔线器的前后位置，从而调节拔线器与压脚的间隙。

### 3、拔线器左右位置调节



当拨线片运行到最左端的时候 拨线片的勾尖与左针之间的距离为3.5mm( 图20 ), 可通过松开紧定螺钉3来调节拨线器的左右位置。

Third, the adjustment of the wire

1, thread height adjustment

When the wiper is moved down to the lowest point, the underside of the wiper is flush with the left needle (long needle) tip (Figure 18). You can adjust the wiper position by loosening the set screw 1 Dial height (Figure 19).

2, before and after the wiper position adjustment

When the wiper passes the presser foot, the gap between the splinter and the presser foot is 1 mm (Figure 18) and the front and rear position of the wiper can be adjusted by loosening the set screw 2 to adjust the position of the wiper and presser foot gap.

3, about the position adjustment dial

When the wiper is run to the far left, the distance between the hook tip of the wiper and the left needle is 3.5 mm (Figure 20). Adjust the left and right positions of the wiper by loosening the set screw 3.

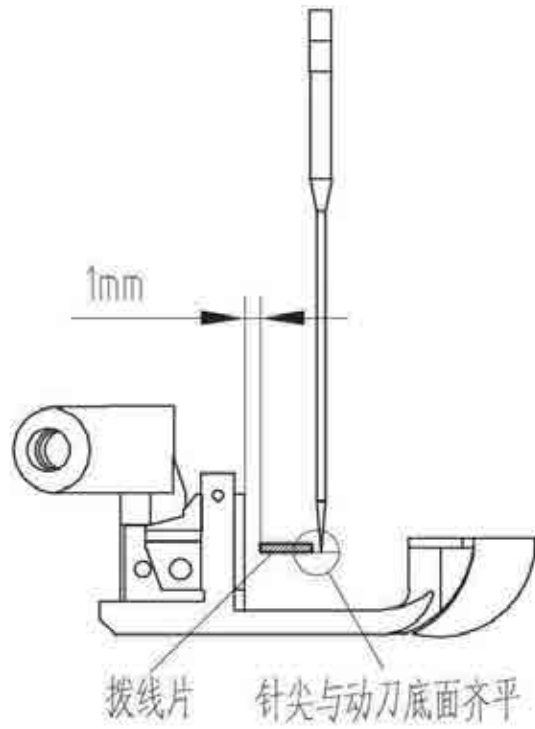


图18

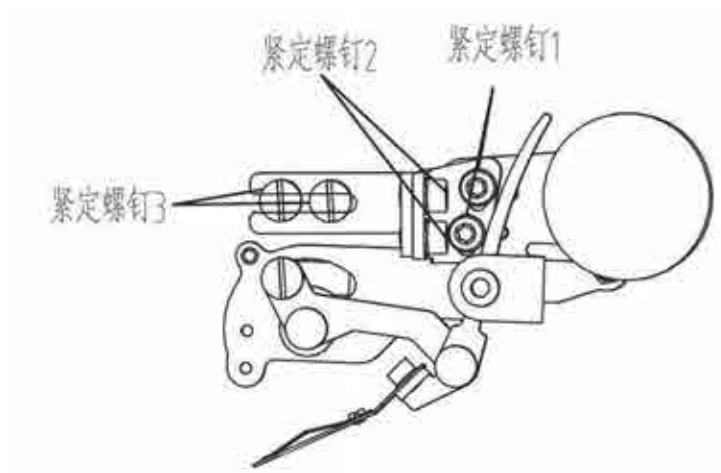


图19

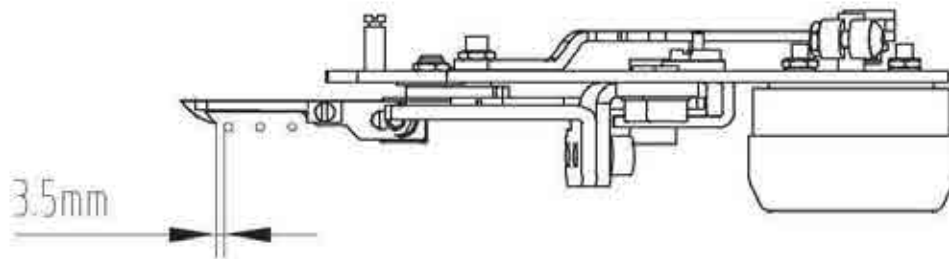


图20

#### 十、安全开关的调整

调节安全开关与电磁阀间隙，安全开关与电磁阀间隙为0.5mm，可通过松开紧定螺钉上下调节安全开关与电磁阀的间隙，知道安全开关灯亮为止，然后拧紧紧定螺钉（图21）

Fourth, the safety switch adjustment

Adjust the clearance between the safety switch and the solenoid valve. The clearance between the safety switch and the solenoid valve is 0.5mm. Adjust the clearance between the safety switch and the solenoid valve by loosening the set screw. Until the safety switch is on and tighten the set screw (Figure 21)

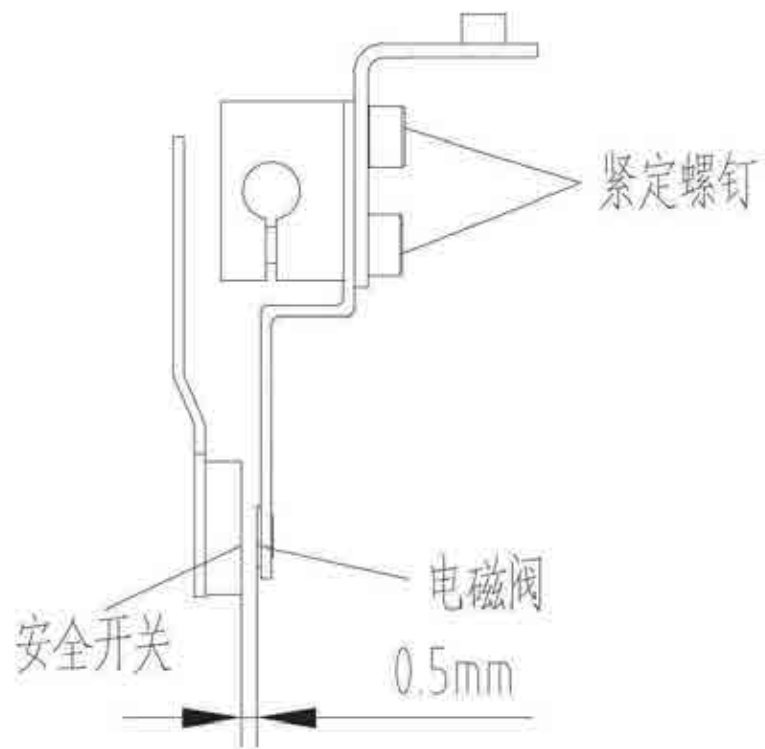



图21

# 杰克 K4 电脑一体机操作手册

## 安全事项

- 在使用本产品之前，请先阅读《操作手册》及所搭配的缝纫机机械说明书。
- 本产品必须由接受过专业培训的人员来安装或操作。
- 请尽量远离电弧焊接设备，以免产生的电磁波干扰本控制器而发生误动作。
- 请不要在室温 45℃ 以上或者 0℃ 以下的场所使用。
- 请不要在湿度 30% 以下或者 95% 以上或者有露水和酸雾的场所使用。
- 安装控制箱及其他部件时，请先关闭电源并拔掉电源插头。
- 为防止干扰或漏电事故，请做好接地工程，电源线的接地线必须牢固的方式与大地有效连接。
- 所有维修用的零部件，须由本公司提供或认可，方可使用。
- 在进行任何保养维修动作前，必须关闭电源并拔掉电源插头。控制箱里有高压危险，必须关闭电源五分钟后方可打开控制箱。
- 本手册中标有  符号之处为安全注意点，必须注意并严格遵守，以免造成不必要的损害。

## 第 1 章 产品安装

### 1.1 产品规格

品型号	AHE59	电源电压	AC 220 ± 20% V
电源频率	50Hz/60Hz	最大输出功率	550W

### 1.2 接口插头的连接

将脚踏板及机头的各连接插头安插到控制器后面对应的插座上，各插座名称如图 1-2 所示。连接好，请检查插头是否插牢。

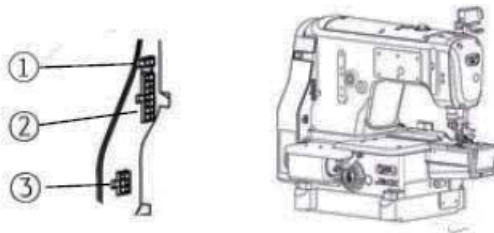



图 1-1 AHE 系列控制器图

①抬压脚电磁铁插座；②自动电磁铁插座；③脚踏板插座；

: 使用正常的力量插不进去时，请检查插头与插座是否匹配，插入方向或针的方向是否正确！

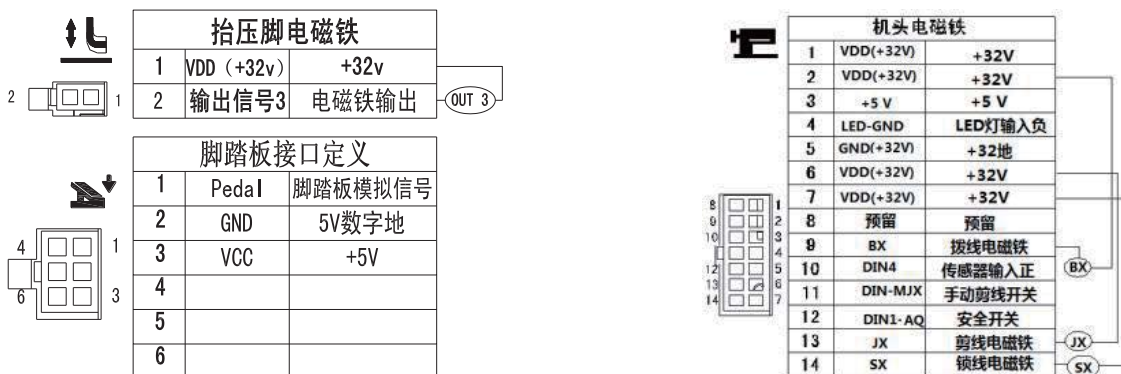



图 1-2 控制器接口定义

### 1.3 接线与接地

必须要做好系统的接地工程，请合格的电气工程人员予以施工。产品通电及投入使用前，必须确保电源插座 AC 输入端已安全可靠的接地。系统的接地线为黄绿线，该地线请务必可靠连接至电网安全保护接地上，以保证安全使用，并可防止出现异常情况。

: 所有电源线、信号线、接地线等接线时不要被其它物体压到或过度扭曲，以确保使用安全！

## 第 2 章 操作面板使用说明

### 2.1 操作面板的显示说明

根据系统工作状态，操作面板的液晶屏模块将显示当前的缝纫模式、各种参数，以及抬压脚、停针位、剪线、慢速起缝等液晶字符。操作面板上的功能图标显示说明如下所示。

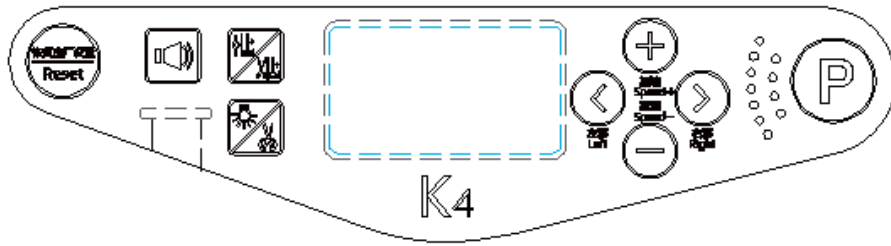


图 2-1 操作面板外观界面

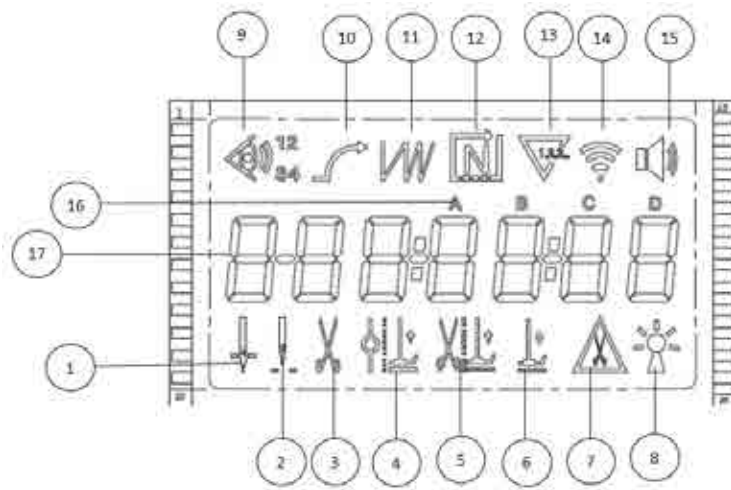










图 2-2 操作面板液晶显示屏图示

索引	图标	描述	索引	图标	描述
①		中间停针下停针	⑪		W 缝纫（无此功能）
②		中间停针上停针	⑫		四段缝（无此功能）
③		自动剪线功能	⑬		记切线次数
④		中间停针抬压脚	⑭		无线信号（无此功能）
⑤		剪线后抬压脚	⑮		语音播报
⑥		抬压脚	⑯	A B C D	针数段落
⑦		计剪数	⑰	88888888	计数/参数值显示
⑧		灯光亮暗			
⑨		感应自动抬压脚			
⑩		软启动功能			

## 2.2 操作面板各按键功能说明

序号	外观	名称	功能描述
1		参数进入及返回键	在开机状态下，长按  键进入参数模式。修改参数后按一下  键储存，再按  键退出参数模式。
2		抬压脚键	在正常缝纫模式下，按  键，循环切换缝纫中途停车时抬压脚与缝纫结束后自动切线抬压脚。
3		灯按键等级以及剪线键	按下  ，灯的等级会发生变化；长按  ，循环切换是否剪线。
4		喇叭键	在报错的时候，短按一下，将会报故障原因；长按，循环切换喇叭开关。
5		参数递增键	参数设定中，参数值递增键。
6		参数递减键	参数设定中，参数值递减键。
7		向左选择键	参数设定中，向左选择参数范围。
8		向右选择键	参数设定中，向右选择参数范围。
9		恢复出厂设置	长按 3S 触动开关恢复出厂程序。

## 2.3 复合按键说明

序号	外观组合	名称	功能描述
1	 + 	计剪线快捷键	快速进入计剪线模式，按下按键  或  ，可以自动切换成计针数模式；按下  或  时可以退出计针数计剪数模式。
2	 + 	监控模式快捷键	快速的进入监控模式，对一些参数进行监控。

## 第 3 章 系统参数设置说明

### 3.1 参数模式

- 1、待机状态下，按 **P** 键进入参数模式；
- 2、按 **<** **>** 键和 **+** **-** 键修改相对应的参数。
- 3、当参数值有修改时，参数界面闪烁。此时，短按 **P** 键，保存修改后的参数，再长按 **P** 键退出参数界面，返回待机页面。

参数编号	参数范围	出厂值	参数描述
P99	0/1/2	1	语音选择 0: 语音关闭;1: 中文 2: 英文 默认 1 中文
P01	200-5500	4000	自由缝最高速度 (全局最高速度)
P03	0/1	0	上下停针选择 (0: 为上停针; 1: 为下停针)
P04	200-3000	1800	前加密缝速度
P05	200-3000	1800	后加密缝速度
P07	0-200	0	前加密缝针数(0 没有加密缝功能, 如果有针数为有加密缝功能)
P08	0-200	0	后加密缝针数(0 没有加密缝功能, 如果有针数为有加密缝功能)
P09	0/1	0	慢速起缝开关(0 为关闭, 1 开启)
P10	0-4	0	计件数模式 (0: 手动计数; 1: 自动计模式——增量模式; 2: 自动计件数模式——减数模式; 3: 自动计件数到 PAA 的数值, 电机停止转动, 手动复位——增量模式; 4: 自动计件数到零, 电机停止转动, 手动复位——减量模式)
P16	1-3000	50	调节响应时间, 感应压脚检测到有布之后相应时间
P17	0-99	0	自动感应抬压脚灵敏度设置 (在参数 02C 显示的参数最大值和最小值之间)
P24	0-1024	150	踏板剪线位置
P27	0-3	1	抬压脚感应模式选择 (0/1/2), 0: 关闭; 1: 剪线后有效; 2: 都有效
P30	0-31	0	电机低速加力功能开关: 0: 正常功能 1~31: 低速加力过厚能力档位
P32	1-500	60	加密缝电磁铁全出力时间 ms
P33	0-100	6	加密缝电铁每周期关闭时间 ms
P37	0-100	5	加密缝电磁铁每周期开通时间 ms (夹线力度)
P38	1-999	120	绷缝剪线速度 (下刀维持时间) -----下刀
P39	1-999	160	扫线延迟动作时间-----上刀 (注意: 此项也是绷缝机上剪线)
P40	1-9999	30	扫线速度 (扫线持续时间) -----上刀 (注意: 此项也是绷缝机上剪线)
P41	0-9999	120	吹风开始延迟时间 ms
P42	1-9999	300	吹风持续时间 ms
P43	0-25	2	扫线、吹风选择功能 (2 为扫线; 8 为吹风)
P45	0-100	1	剪线电磁铁每周期开通时间 ms
P46	0-100	2	剪线电磁铁每周期关闭时间 ms
P49	100-500	300	剪线速度



P 50	1~500	100	抬压脚电磁铁全出力时间 ms
P 51	0~100	15	抬压脚电磁铁每周期开通时间 ms
P 52	1~800	150	放压脚延迟时间 (ms)
P 53	0/1	1	抬压脚开关： 0：不抬 1：抬
P 54	0~100	35	抬压脚电磁铁每周期关闭时间 ms
P 56	0/1	1	上电自动找上针位： 0：不找 1：找
P 57	0~600	200	抬压脚电磁铁保护时间 100ms
P 60	200~5500	4000	定长缝最高速（自动测试速度）
P 62	0~4	0	特殊运行模式： 0：操作工选择（正常） 1：简易缝模式 2：测电机初始角（不再需要取下皮带） 3：计算传动比模式（需要有停针传感器，且不能取下皮带） 4：自动测试模式 1（带停针位的自动测试，运行 5S，停止 5S）
P 66	0~2	2	0：关闭；2：打开安全开关功能
P 71	0~50	0	缓放压脚级别调整，数值越小放的越快；（超频打开时间）
P 76	1~500	60	剪线电磁铁全出力时间 ms
P 98	0~4	4	音量调节（0~4）4 为音量最大（恢复出厂设置以后会发生改变）
P 99	0/1/2	1	语音选择 0：语音关闭，1：中文，2：英文
PA 0	0~9999	0	感应开启时，撤除布料后放压脚延迟时间，单位 ms
PA 1	0~9999	50	感应开启时，带布料放压脚延迟时间，单位 0.1s
PA 5	0~3	0	0：开机语音，按键语音，参数语音，故障语音；1：仅为开机语音；2：仅为按键语音及故障语音；3：开机语音，按键语音，故障语音
PA 6	1~100	1	计底线针数比例
PA 7	1~9999	1	底线总针数设置
PA 8	0~6	0	计针数模式（0：不计针数；1：递增加满自动复位；2：递减至零自动复位；3：递增加满，报错停机，手动复位；4：递减至零，报错停机，手动复位；5：递增加满，报错不停机，剪线后停机，手动复位；6：递减至零，报错不停机，剪线后停机，手动复位）
PA 9	1~100	1	计件数次数比例
PAA	1~9999	1	总件数设置
PAB	0~4	0	计件数模式（0：手动计数；1：自动计模式——增量模式；2：自动计件数模式——减数模式；3：自动计件数到 PAA 的数值，电机停止转动，手动复位——增量模式；4：自动计件数到零，电机停止转动，手动复位——减量模式）

### 3.2 监控参数表

参数编号	参数描述	参数编号	参数描述
010	针数计数	025	踏板电压采样值
011	计件数	026	机头传动比实际值
012	机头实际速度	027	电机累计运行时间 (Hour)
013	霍尔状态	028	机头交互量电压采样值
020	母线电压	029	DSP 软件版本号
021	机头速度	02A	模拟输入 1 采样值
022	相电流	02B	模拟输入 2 采样值
023	初始角度	02C	错误计数器
024	机械角度	030-037	历史故障代码

### 3.3 安全报警表

报警代码	代码含义	解决措施
<b>ALA-2</b>	计针数报警	表示计针数已达所设上限，按 P 键可取消报警并重新计数
<b>ALA-3</b>	计剪线数报警	表示计剪线数已达所设上限，按 P 键可取消报警并重新计数
<b>POHOFF</b>	断电提醒	请等候 30 秒再重新打开电源开关
<b>ARN UP</b>	安全开关报警	请检查剪线刀是否回复到位，若回复到位后安全开关灯不亮，请调节感应支架位置，仍无法解决需要临时使用请将 P66 项参数里的 2 改为 0 即可；上述如仍无法解决请联系当地服务商或拨打 4008876858。
<b>SLEEP</b>	休眠	关闭系统电源，30 秒后重新接通电源，控制器若仍不能正常工作，请更换控制器并通知厂方。

### 3.4 故障代码表

若系统出现报错或报警，请首先检查如下项：

1、先确认机器的连接线是否连接完好；2、确认电控和机头是否匹配；3、确认恢复出厂是否准确。

故障代码	代码含义	解决措施
<b>Err-01</b>	硬件过流	关闭系统电源，30 秒后重新接通电源。上述如仍无法解决请联系当地服务商或拨打 4008876858。
<b>Err-02</b>	软件过流	
<b>Err-03</b>	系统欠压	关闭系统电源，检查输入电源电压是否偏低（低于 176V）。若电源电压偏低，请在电压恢复正常后重新启动控制器。上述如仍无法解决请联系当地服务商或拨打 4008876858。
<b>Err-04</b>	停机时过压	关闭系统电源，检查输入电源电压是否偏高（高于 264V）。若电源电压偏高，请在电压恢复正常后重新启动控制器。上述如仍无法解决请联系当地服务商或拨打 4008876858。
<b>Err-05</b>	运行时过压	
<b>Err-06</b>	电磁铁回路故障	关闭系统电源，检查电磁铁连线是否正确，是否有松动、破损等现象。若有则及时更换。确认无误后重启系统。上述如仍无法解决请联系当地服务商或拨打 4008876858。
<b>Err-07</b>	电流检测回路故障	关闭系统电源，30 秒后重新接通电源。重试几次，若该故障频繁出现，请更换控制器。上述如仍无法解决请联系当地服务商或拨打 4008876858。

Err-08	电机堵转	关闭系统电源，检查电机电源输入插头是否脱落、松动、破损，是否有异物缠绕在机头上。排除后重启系统仍不能正常工作，请更换控制器。上述如仍无法解决请联系当地服务商或拨打 4008876858。
Err-09	制动回路故障	关闭系统电源，检查电源板上白色的制动电阻接头是否松动或脱落，将其插紧后重启系统。上述如仍无法解决请联系当地服务商或拨打 4008876858。
Err-10	HMI 通讯故障	检查控制面板与控制器的连线是否脱落、松动、断裂，将其恢复正常后重启系统。上述如仍无法解决请联系当地服务商或拨打 4008876858。
Err-11	机头停针 信号故障	检查机头同步信号装置与控制器的连线是否松动，将其恢复正常后重启系统。若仍不能正常工作，请更换控制器。上述如仍无法解决请联系当地服务商或拨打 4008876858。
Err-12	电机初始角度检测故障	请断电后再尝试 2-3 次，若仍报故障，请更换控制器。上述如仍无法解决请联系当地服务商或拨打 4008876858。
Err-13	电机 HALL 故障	关闭系统电源，检查电机传感器接头是否脱落、松动、破损，将其恢复正常后重启系统。若仍不能正常工作，请更换控制器。上述如仍无法解决请联系当地服务商或拨打 4008876858。
Err-14	DSP 读写 EEPROM 故障	关闭系统电源，30 秒后重新接通电源，若仍不能正常工作，请更换控制器。上述如仍无法解决请联系当地服务商或拨打 4008876858。
Err-15	电机超速保护	
Err-16	电机反转	
Err-17	HMI 读写 EEPROM 故障	
Err-18	电机过载	

## 第 4 章 脚踏板灵敏度调整

脚踏板动作由初始位置①（136 号参数）开始，缓慢向前踩至②（137 号参数）开始低速缝纫，继续前踩至③（138 号参数）开始加速，再深踩至④（139 号参数）达到最高速度。②③段之间维持起缝速度，③④段之间为无级调速过程；

- 1、当脚踏板由初始位置①（136 号参数）开始，缓慢后踩至⑤（135 号参数）时抬压脚自动抬起；
- 2、当脚踏板由初始位置①（136 号参数）开始，缓慢后踩至⑥（134 号参数）时自动完成剪线动作。
- 3、各参数数值设置需保证（134 号参数）<（135 号参数）<（136 号参数）<（137 号参数）<（138 号参数）<（139 号参数）
- 4、可通过监控模式下 025 号参数实时监测，不同位置下的踏板采样数值作为各参数的参考值。

调整对应参数，抬压脚和前踩或后踩的动作位置也随之改变。如前踩很大距离机器还没有运转，可适当减小 137 参数（不能小于回中位置参数 136），即可提高前踩的灵敏度；若机器过于灵敏，轻触踏板机器就开始运行，可适当加大 137 参数；若不容易补针，稍微前踩，速度就迅速提高造成前冲多针，可适当增大 138 参数或减小 137 参数（即增大脚踏板低速范围），也可以适当降低初始起缝速度（100）。

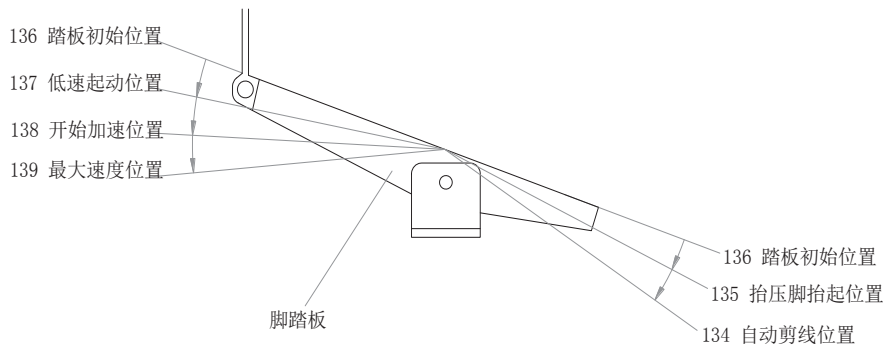



图 4-1 踏板动作各位置参数示意图

# K4 Operation Manual

## Safety Instruction

- Please read this manual carefully, also with related manual for the machinery before use the controller.
- For installing and operating the controller properly and safely, qualified engineers are required.
- Please stay away from arc welding equipment, in order to avoid electromagnetic interference and malfunction of the controller.
- Keep room temperature below 45°C and above 0°C
- Do not use in humidity below 30% or above 95% or dew and mist places.
- Please turn off the power and unplug the power cord, before install the control box and other components,
- To prevent interference or electric leakage accidents, please make the ground work; the power cord ground wire must be securely connected to earth by an effective way.
- All parts for the repair provided by the Company or approved before use.
- Please turn off the power and unplug the power cord before any maintenance action. There is dangerous high voltage control box, you must turn the power off after one minute before opening the control box.
- The symbol  in this manual means Safety Precautions, please pay attention to it and strictly follow it, to avoid any unnecessary damage.

## 1 Installation Instructions

### 1.1 Product specifications

Product Type	AHE59	Supply Voltage	AC 220 ±20%V
Power frequency	50Hz/60Hz	Maximum output power	550W

### 1.2 Interface plug connections

Connecting the plugs of pedal and machine head to the corresponding sockets at the back of controller, as Figure 1-2. Please check and confirm the plug is inserted firmly.

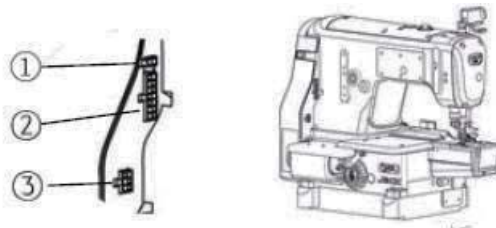



Fig.1-1 Controller Socket Diagram

- ① Presser Foot lifter solenoid socket; ② Solenoid socket ; ③ Pedal socket;

: If it is difficult to insert plug into socket, please check whether they are matching with each other, or the inserting direction or needle insertion direction is correct!

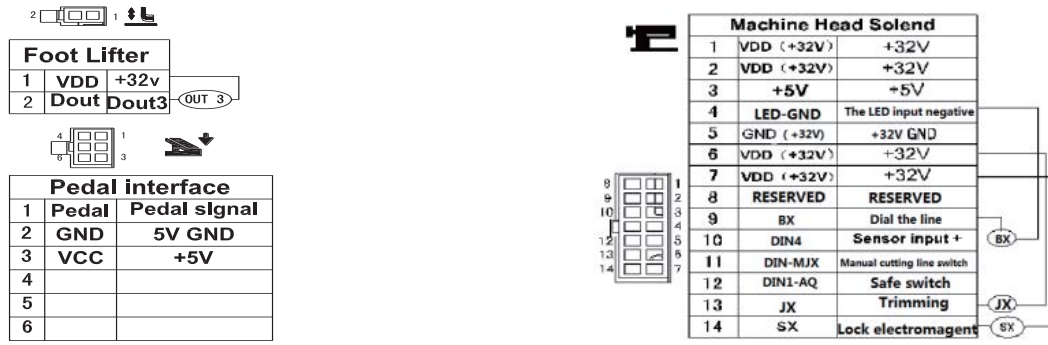


Fig.1-2 Controller Interface Definition

### 1.3 Wiring and Grounding

We must prepare the system grounding project, a qualified electrical engineer is requested for the construction. Product is energized and ready for use; you must ensure that the power outlet the AC input is securely grounded. The grounding wire is yellow and green lines, it must be connected to the grid and reliable security protection on the ground to ensure safe use, and prevent abnormal situation.

: All power lines, signal lines, ground lines, wiring not to be pressed into other objects or excessive distortion, to ensure safe use!

## 2 Operation Panel Instructions

### 2.1 Operation Panel Display Instruction

According to the system working state, the LCD module of operation panel will display the current sewing mode, parameters, start / end back tacking, and presser foot, needle position, trimming, soft start sewing etc. Function mark of the operation panel is as follows:

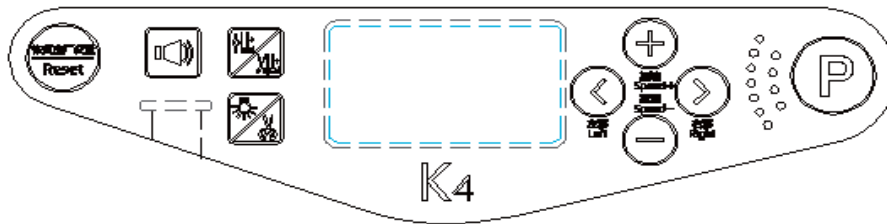


Fig.2-1 Operation Panel

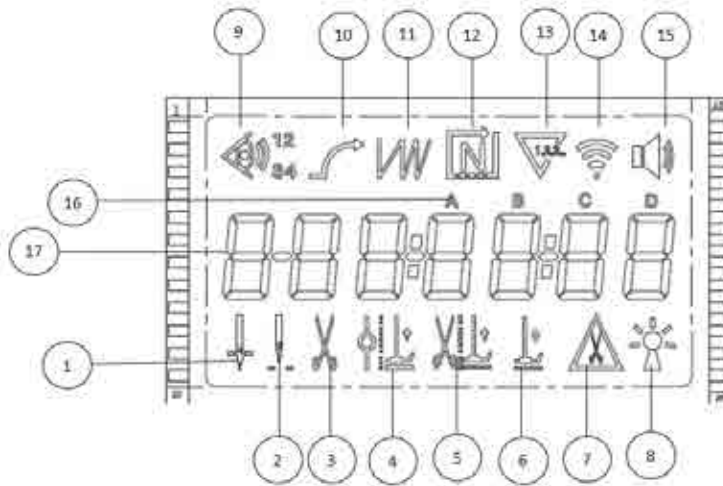


Fig.2-2 Operation Panel LCD display









Index mark Description Index Icon Description

Index	Icon	Description	Index	Icon	Description
①		Down needle Position	⑪		W bar tacking sewing(No function)
②		Up needle Position	⑫		Multi-section constant-stitch sewing(No function)
③		Automatic trimming	⑬		The bottom line counter
④		Foot lifting at seam End	⑭		One-Shot-Sewing in constant-stitch
⑤		Foot lifting after trimming	⑮		Voice reminder
⑥		Presser foot lifting	⑯	A B C D	Sewing segments
⑦		Trimming counter	⑰	8 8 8 8 8 8 8 8	Number/parameter display
⑧		Light level	⑱		
⑨		Sensor for automatic presser foot lifting	⑲		
⑩		Soft start	⑳		

2.2 Key Functions S/L mark Key Name Description








Key	Name	Description
	Parameter setting key	In the boot state, long press  key to enter the parameter modes. After modify the parameters, press  key to storage. Then long press  key to exit this mode.
	Presser foot key	Under the normal sewing mode, press  key, switch between cycle sewing midway parking presser foot and sewing after the end of automatic trimming presser foot.
	Light level button and Shear line switch	Short press  Key, light level will change. Long press  Key, circular will cut line switch.
	Voice button	At the time of an error, short press  Key, will be submitted to the cause of the problem. Long press  Key, Switching the horn switch.
	The parameter increment setting key	Parameter value increment key.
	The parameter decrement setting key	Parameter value decrement key.
	The left selection key	Parameters selection toward to left key. ( In constant-stitch sewing mode, long press this key, One-shot-sewing can be turned on or turned off. )
	The right selection key	Parameters selection toward to right key.
	factory reset	Long press 3 s touch switch to restore the factory program.

## 2.3 Composite keys that

The serial number	Appearance of the combination	Name	Functional description
1	 + 	Trimming shortcuts	Quickly into the trimming mode, press the button  or  , can automatically switch to pin number mode, press the  or  , can exit the meter gauge needle thread model
2	 + 	Monitoring mode shortcuts	Quickly into monitor mode, to monitor some parameters.

## 3 System parameters setting list

### 3.1 Parameter mode

- 1、 In the standby state ,press  key to enter the parameter modes.
- 2、 Press corresponding key   and key   to adjust the corresponding parameter.
- 3、 When the parameter values have increased and decreased, parameter interface flash. Short press  key to save the modified parameters .Long press  key to exit parameter interface, return to standby model.

NO.	Range	Default	Description
P99	0-2	1	language selection 0: off, 1: Chinese, 2:English, default language 1 Chinese
P01	200-5000	4000	the maximum speed of free sewing (the global maximum speed)
P03	0/1	0	Needle stop position selection (0:up; 1: down)
P04	200-3000	1800	Start encryption sewing speed
P05	200-3000	1800	End encryption sewing speed
P07	0-200	0	Start encryption stitches number (0 is not encrypted function, if there is a pin number for encryption seam features)
P08	0-200	0	End encryption stitches number (0 is not encrypted function, if there is a pin number for encryption seam features)
P09	0/1	0	Soft start switch (0:off; 1: on)
P10	0-4	0	Quantity of meter to adjust
P16	1-3000	50	Adjust the lift foot response time after the sensor has detected the cloth.

P 17	0-99	0	Automatic induction presser foot sensor setting (between the maximum and minimum value of the 02C parameter display)
P 24	0-1024	150	Trimming point of pedal
P 27	0-3	1	Presser Foot sensor mode setting: 0: off 1: turn on only after trimming 2: always ON
P 30	0-31	0	Feedforward torque of motor: 0: normal functions 1-31: feedforward torque level
P 32	1-500	60	Encryption seam solenoid full open time (ms)
P 33	0-100	6	Encryption seam solenoid off time per cycle (ms)
P 37	0-100	5	Encryption seam solenoid on time per cycle (ms), means the clamp strength.
P 38	1-999	120	Flat seaming shear velocity (under the knife to maintain time) -- -- -- -- -- under the knife
P 39	1-999	160	Scavenging action time delay -- -- -- -- -- on the knife (note: this is also flat seaming machine cut line)
P 40	1-999	30	Duration and linear velocity (scan line) -- -- -- -- -- on the knife (note: this is also flat seaming machine cut line)
P 41	0-9999	120	Blowing began to delay time(ms)
P 42	1-9999	300	Blowing duration(ms)
P 43	0-25	2	Sweep line, choice of blowing function (2 for scavenging; 8 for blowing)
P 45	0-100	1	Trimming electromagnet per cycle opening time (ms)
P 46	0-100	2	Trimming electromagnet per cycle closing time (ms)
P 49	100-500	300	Trimming Speed
P 50	1-500	100	Presser foot lifting electromagnet full output time ms
P 51	0-100	15	Presser foot lifting electromagnet per cycle opening time (ms)
P 52	1-800	150	Running delay time when presser footer comes down (ms)
P 53	0/1	1	Presser foot lifting function selection 0: off 1: on
P 54	0-100	35	Presser foot lifting electromagnet per cycle closing time (ms)
P 56	0/1	1	Run to up needle position after Power on : 0: no action 1: action
P 57	0-600	200	Presser foot lifting electromagnet protection time 100ms
P 60	200-5500	4000	The maximum speed of constant sewing (Automatic test speed)
P 62	0-4	0	Special mode: 0: normal Mode 1: simply sewing mode 2: motor initial angle measurement (Do not remove the belt) 3: Automatically setting the pulley ratio by the CPU. (Synchronizer is necessary and the belt not removed) 4: automatic test mode 1 (It has needle stop position of automatic test, running and stopping 5S)
P 66	0/2	2	Safety switch function set: 0:off 2:on
P 71	0-50	0	Slow release lifter level adjustment, the smaller values and the faster quickly (OC open





			time)
P76	1-500	60	Trimming electromagnet full output time ms
P98	0-4	4	Mention voice volume (0 to 4) 4 for maximum volume changes (factory default)
P99	0-2	1	language selection 0: off, 1: Chinese, 2:English, default language 1 Chinese
PA0	1~9999	0	The lift foot release down Delay time after remove cloth when sensing turn on.
PA1	0-600	50	The lift foot release down Delay time with cloth when sensing turn on.
PA5	0-3	0	0: Switch on the voice,Buttons voice,Parameters voice,Error voive;1: Switch on the voice;2: Buttons voice, Error voive;3: Switch on the voice,Buttons voice,Error voice
PA6	1-100	1	Stitch counter mode setting ratio
PA7	1-9999	1	Stitch counter mode total stitches setting
PA8	0-6	0	Stitch counter mode setting
PA9	1-100	1	Pieces counter mode setting ratio
PAA	1-9999	1	Pieces counter mode total stitches setting
PAB	0-4	0	Pieces counter mode setting

### 3.2 Monitor mode

No.	Description	No.	Description
010	stitch counter	025	The sampling voltage of pedal
011	Counter for sewing pieces	026	The ratio between motor and machine
012	The head of real speed	027	The total used time(hours) of motor
013	State of encoder	028	The sampling voltage of interaction
020	DC voltage	029	Software version
021	Machine speed	02A	Analog input 1
022	The phase current	02B	Analog input 2
023	Initial electrical angle	02C	Error counter
024	Machine angle	030-037	The history record of error codes

### 3.3 The warning message

Alarm code	Description	Corrective
<b>ALA-2</b>	Stitch counter alarm	The stitch counter reaches the limit. Press  key to cancel the alarm and reset the counter.
<b>ALA-3</b>	Trimming counter alarm	The trimming counter reaches the limit. Press  key to cancel the alarm and reset the counter.

<b>P O W E R F F</b>	Power is off alarm	Please wait for 30 seconds, then turn on the power switch
<b>R R N U P</b>	Safety switch alarm	Please check the trimming cutter is back the original place, after checking still safety alarm, please adjust the sensor holder, if still cannot solved, please enter P66 parameter change from 2 to 0.
<b>SLEEP</b>	Dormancy	Shut down the system power supply, 30 seconds to connect the power supply, controller, if still doesn't work, please replace the controller and notify the manufacturer.

### 3.4 Error mode

If the error code appears, please check the following items first:

1. Make sure the machine has been connected correctly;
2. Confirm that the control box match with the machine head.
3. Confirm factory reset is accurate

Error Code	Description	Solution
Err-01	Hardware overcurrent	Turn off the power switch, and restart after 30 seconds. If the controller still does not work, please replace it and inform the manufacturer.
Err-02	Software flow	
Err-03	Under-voltage	Disconnect the power to the controller; check the input power supply voltage is low or not (less than 176V). If the power supply voltage is low, please start the controller after recovers the voltage. If the controller still does not work, please inform the manufacturer and replace the controller.
Err-04	Over-voltage when the machine is off	Disconnect the controller power and check if the input voltage is too high (higher than 264V). If yes, please restart the controller when the normal voltage is resumed. If the controller still does not work when the voltage is at normal level, please replace the controller and inform the manufacturer.
Err-05	Over-voltage in operation	
Err-06	Solenoid circuit fault	Turn off the system power. Check carefully, if the solenoid connection is loose or damage, please change it in time. Then restart the system after confirmation, if it still does not work, please inform the manufacturer and replace the controller.
Err-07	Motor current measuring failure	Turn off the system power, restart after 30 seconds to see if it works well. If such failure happens frequently, seek technical support.
Err-08	Sewing motor blocked	Turn off the system power. Check whether the motor power input plug is off, loose or broken, or there is something tangled on the machine head. Please make them correct then restart the system. If it still does not work, please inform the manufacturer and replace the controller.
Err-09	Brake circuit fault	Turn off the system power. Check carefully, if white braking resistor connector on the power board is loose or fall off, please plug it tight then restart the system, if it still does not work, please inform the manufacturer and replace the controller.
Err-10	Communication failure	Check carefully, if the connection between the control panel and controller is off, loose, or broken, please make it correct then restart the system, if it still does not work, please inform the manufacturer and replace the controller.
Err-11	Machine head needle positioning failure	Check if the connection line between machine head synchronizer and controller is loose or not, restore it and restart the system. If it still does not work, please replace the controller and inform the manufacturer.

Err-12	Initial motor electrical angle failure	-Try 2 to 3 more times after power down - if it still does not work, please replace the controller and inform the manufacturer.
Err-13	Motor HALL failure	Turn off the system power, check if the motor sensor plug is loose or dropped off, restore it and restart the system. If it still does not work, please replace the controller and inform the manufacturer.
Err-14	DSP Read/Write EEPROM failure	Turn off the system power, restart the system after 30 seconds, if it still does not work, please replace the controller and inform the manufacturer.
Err-15	Motor over-speed protection	
Err-16	Motor reversion	
Err-17	HMI Read/Write EEPROM failure	
Err-18	Motor overload	

## 4 Pedal sensitivity adjustment

Pedal movement starts from the initial position (p.136) where the motor stops, slowly stepped forward to the low speed point (p.137) where the motor runs at the minimum speed (p.100), proceeding to the accelerated point (p.138) where the motor start fasten, until the max speed point (p.139) where the motor run up to the maximum speed (p.101). And when the pedal steps back to the foot lifter position (p.135), the automatic presser foot lifting. Continuing back to the auto trimming position (p.134), thread trimming is completed automatic. The parameter value is set for an assurance (No. 134 parameters) < (No. 135 parameter) < (No. 136 parameters) < (No. 137 parameters) < (No. 138 parameters) < (No. 139 parameters). Adjusting the corresponding parameters, user can acquire the proper pedal response to fit the personal habit.

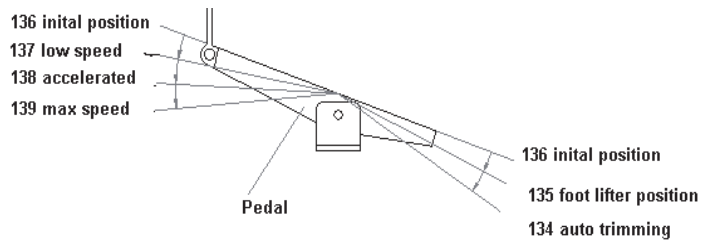
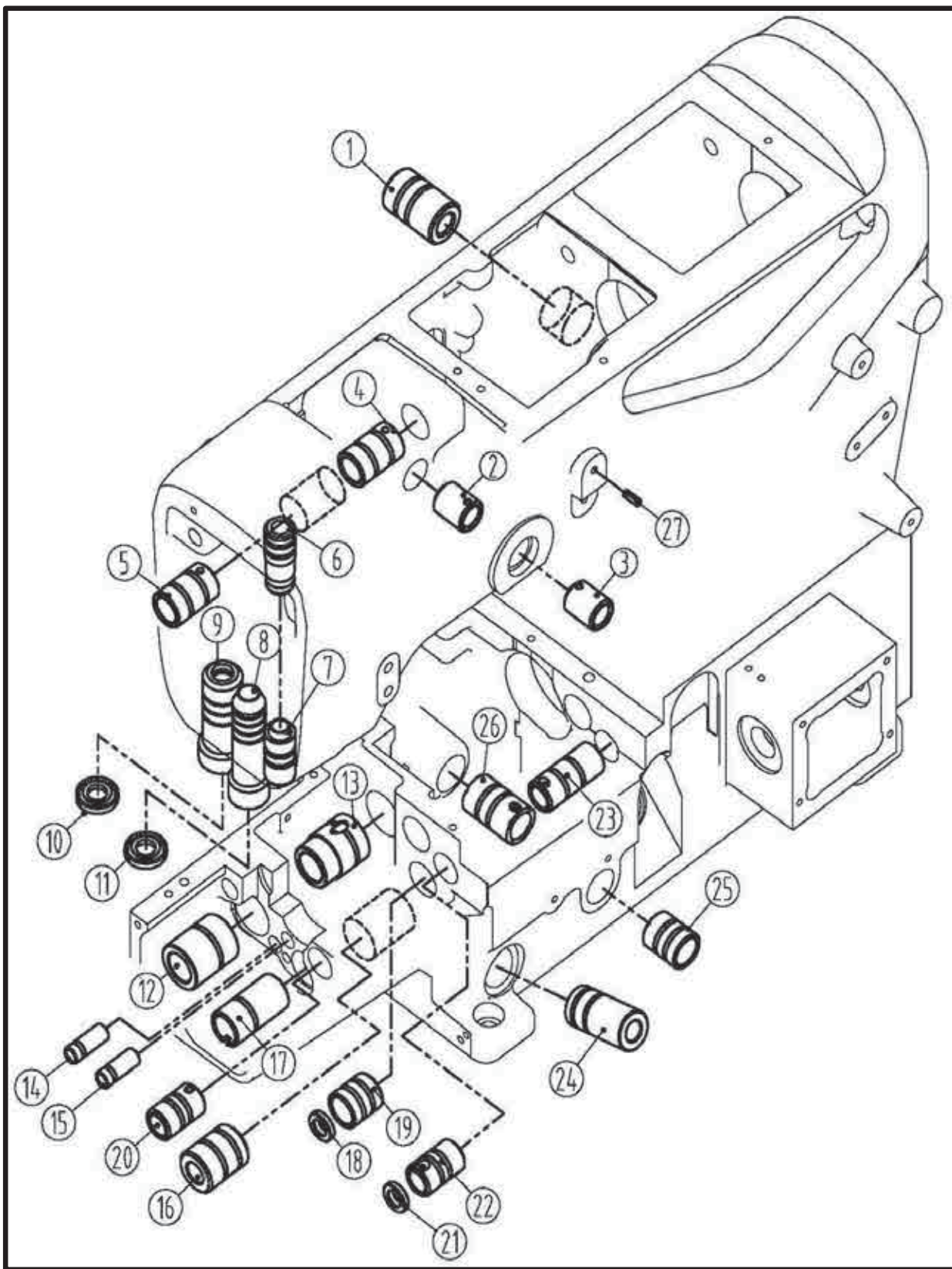


Fig. 4-1 pedal movement of each position parameter

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# 套筒部件/Bushing assemblies



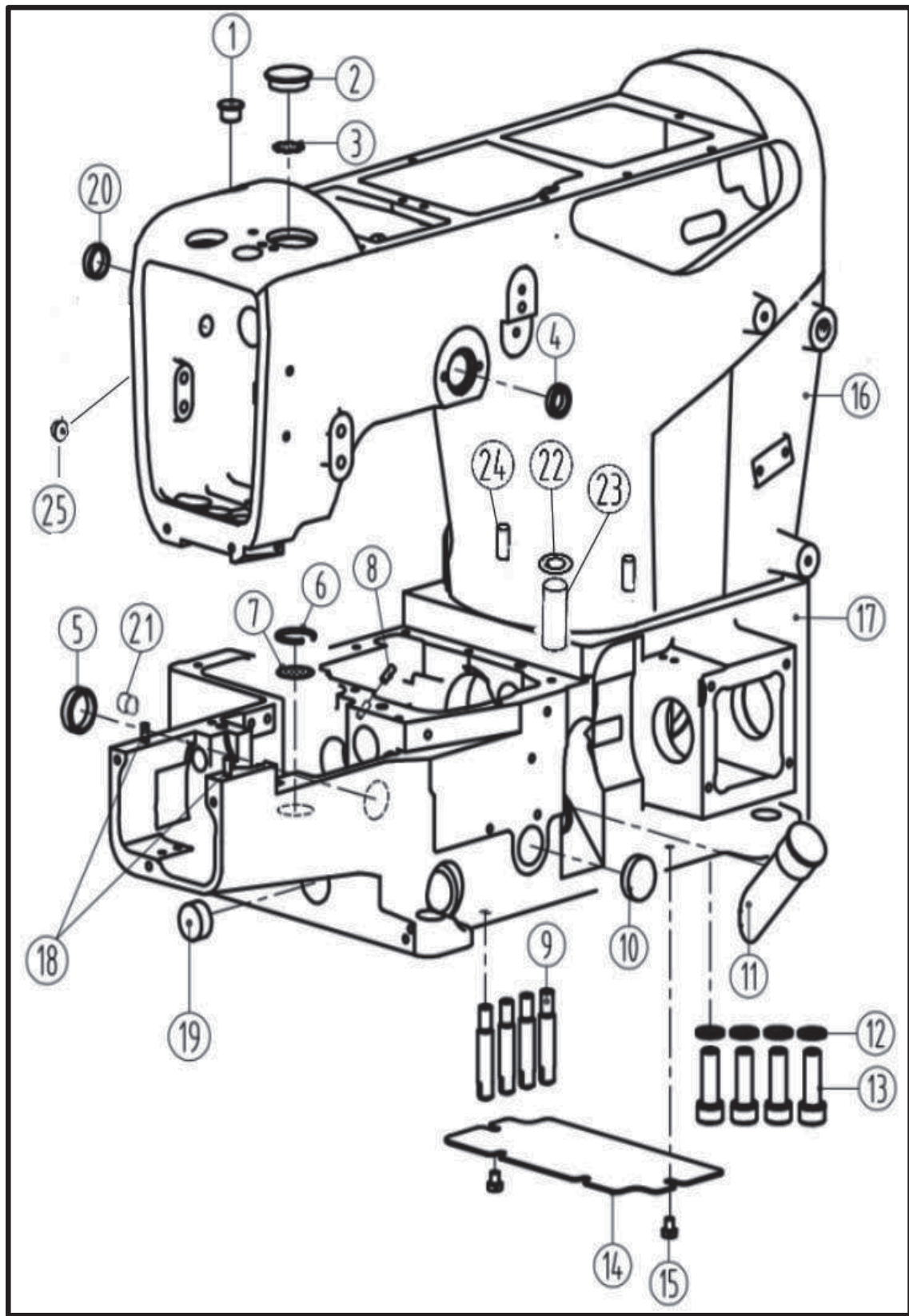
注：点划线框代表暂时不用或以改进零件。

套筒部件/Bushing assemblies

序号 No.	件号 Parts No.	参考件号 Ref. Part. NO	名称	Description	数量 Number
1	131103007		扳手轴套筒	sleeve	1
2	30103106	210297	过线座轴前后套筒	sleeve	1
3	131103006	210297	挑线轴前套	sleeve	1
4	20103047	250141	送布轴右套	sleeve	1
5	20103047	250141	送布轴右套	sleeve	1
6	30203004	250146	针杆上套筒	sleeve	1
7	30203005	251003	针杆下套筒	sleeve	1
8	30203024	250147	压脚轴套筒	sleeve	1
9	30203025	250136	喂针摆动轴套筒	sleeve	1
10	20622019		油封	plug	1
11	30122039		压脚轴套油封	plug	1
12	30203002	250137	下主轴前套	sleeve	1
13	30203003	250138	下主轴后套	sleeve	1
14	30203006	0628	护针轴套	sleeve	1
15	30203039	0628	护针轴套	sleeve	1
16	30203011	250139	针距轴套	sleeve	1
17	30203017	250140	差动轴前套	sleeve	1
18	30222011		差动油封	plug	1
19	30203018	250141	差动轴后套	sleeve	1
20	30203040		抬牙轴前(中)套	sleeve	1
21	30222010		抬牙油封	plug	1
22	30203040		抬牙轴前(中)套	sleeve	1
23	30203049	204089	抬牙轴后套	sleeve	1
24	30203012		调节座套	sleeve	1
25	30203009	250191	下弯针轴前套	sleeve	1
26	30203010	250144	下弯针轴后套	sleeve	1
27	P03005		弹性圆柱销3×12	pin	1
28	20122029		油封	plug	1
29	20122029		油封	plug	1

注：点划线框代表暂时不用或以改进零件。

# 一、车壳部件/Frame assemblies



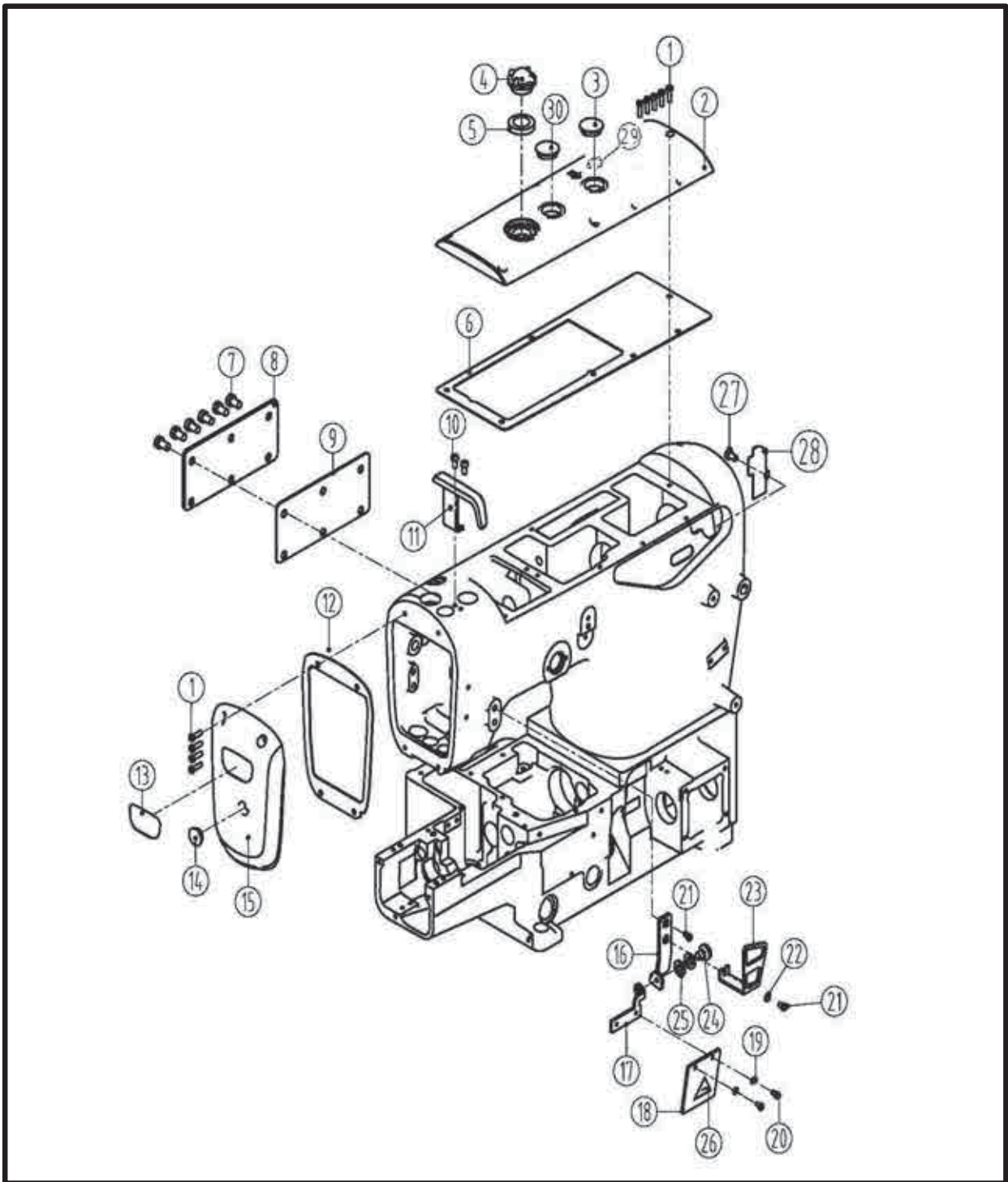
注：点划线框代表暂时不用或以改进零件。

### 一、车壳部件/Frame assemblies

序号 No.	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	30122006	240052	油堵	plug	1
2	21022007		油封	plug	1
3	21012018		油封垫	washer	1
4	20622019		油封	plug	1
5	30222007	209084	密封盖	plug	1
6	H01001	240001	孔用弹性挡圈18	ring	1
7	30112001	255002	滤油网	filter	1
8	20123021	255108	限油芯	pin	1
9	301S30001	250117	机壳螺钉	bed pin	4
10	20122009	210003	油封	plug	1
11	30111001	206590	油标	oil sight gauge	1
12	W02003		垫圈10	washer	4
13	S05001		螺钉M10×27.5	screw	4
14	30112002	250020	盖板	cover	1
15	S01002	7017	螺钉M4×6.5	cscrew	2
16	100886		机壳上节	chassis	1
17	100887		机壳下节	Casing under section	1
18	30226004		定位销	pin	2
19	30122007		油封	plug	1
20	30122008		油封	plug	1
21	30222003		油堵	plug	1
22	001001		O型圈 15×2.65	o ring	1
23	30221016		铜油管	oil pipe	1
24	P02002		销6×32	pin	2
25	30222031		油封	plug	1

注：点划线框代表暂时不用或以改进零件。

## 二、罩壳部件/Cover assemblies



注：点划线框代表暂时不用或以改进零件。

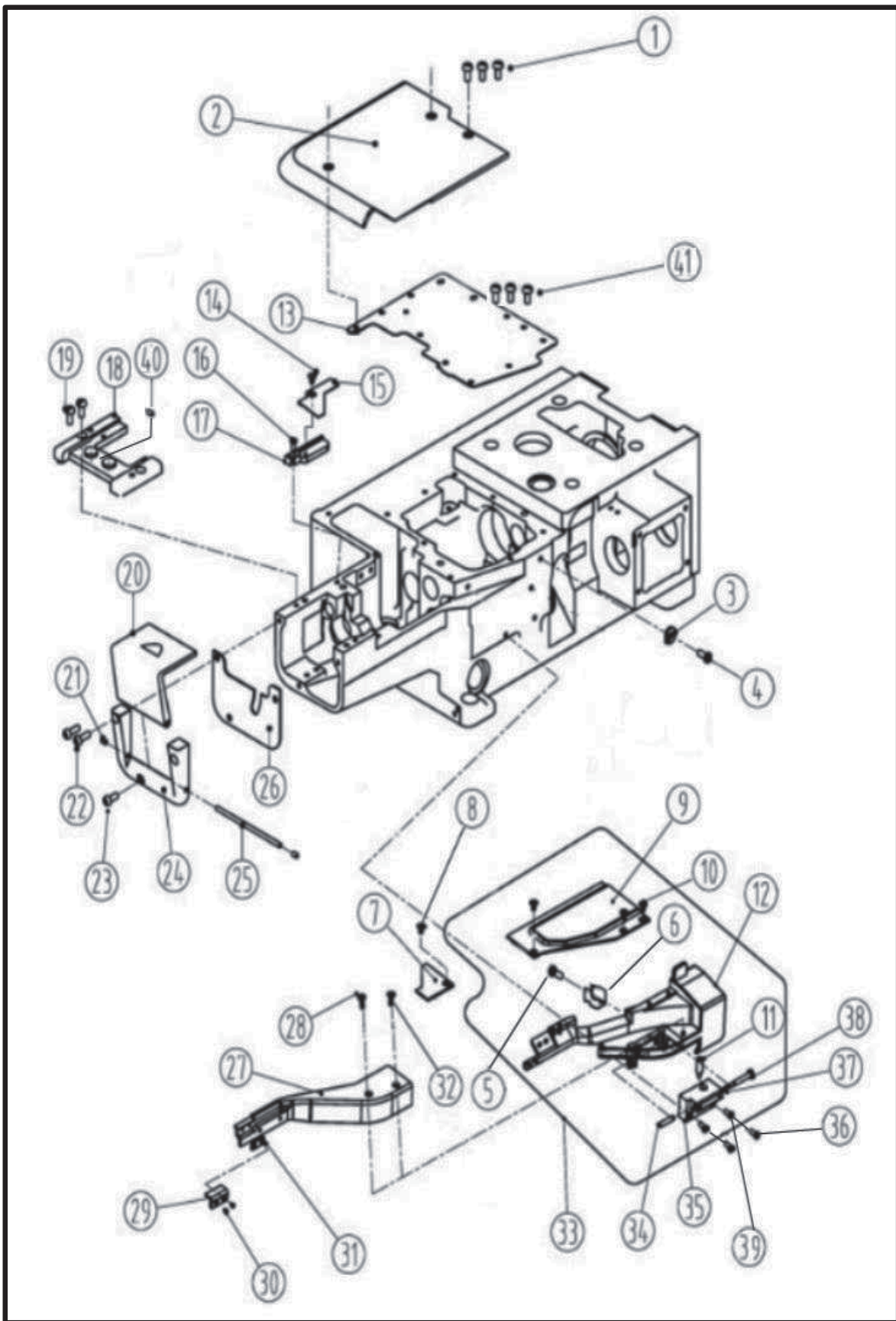


## 二、罩壳部件/Cover assemblies

序号 No.	件号 Parts No.	参考件号 Ref. Part. NO	名称	Description	数量 Number
1	S04060	7021	螺钉M4×10	screw	9
2	303600		上盖（喷漆）	arm cover (top)	1
3	21022007		油塞	plug	1
4	20711055		油窗	Oil Sight Window	1
5	21022003		油窗垫	o ring	1
6	31022010		上盖垫	The head gasket	1
7	S01060	7052	螺钉M6×10	screw	6
8	303605	250154	后窗板	arm cover (rear)	1
9	31022013	250155	后盖板垫	gasket	1
10	207S11007		螺钉	screw	2
11	<u>131412001</u>		针杆护罩	needle bar cover	1
12	31022006		机头左盖垫	o ring	1
13	13837002		商标牌	plug	1
14	10122003		面板调节孔塞	plug	1
15	303599		机头左盖（喷漆）	arm cover (rear)	1
16	31012042		玻璃罩安装板	glass plate	1
17	31012029		护罩架	Shield frame	1
18	30111003	250257	有机玻璃罩	eye guard	1
19	W01002	202875	垫圈	sticker	2
20	S01006	7009	螺钉M3×4.5	screw	2
21	S01060	7052	护罩螺钉	screw	2
22	W02004	303335	垫圈6	sticker	2
23	31012012		过线护罩	threan takeup cover	1
24	301S20001		螺钉	screw	1
25	W03001	210307	波形垫圈	washer	1
26	20131063		护罩警示牌	sticker	1
27	S01055		螺钉	screw	1
28	20711210		R型线夹3.3	Card line piece	1
29	21012018		油窗垫	o ring	1
30	<u>30122012</u>		密封垫	plug	1

注：点划线框代表暂时不用或以改进零件。

### 三、缝台部件/Cloth plate assemblies



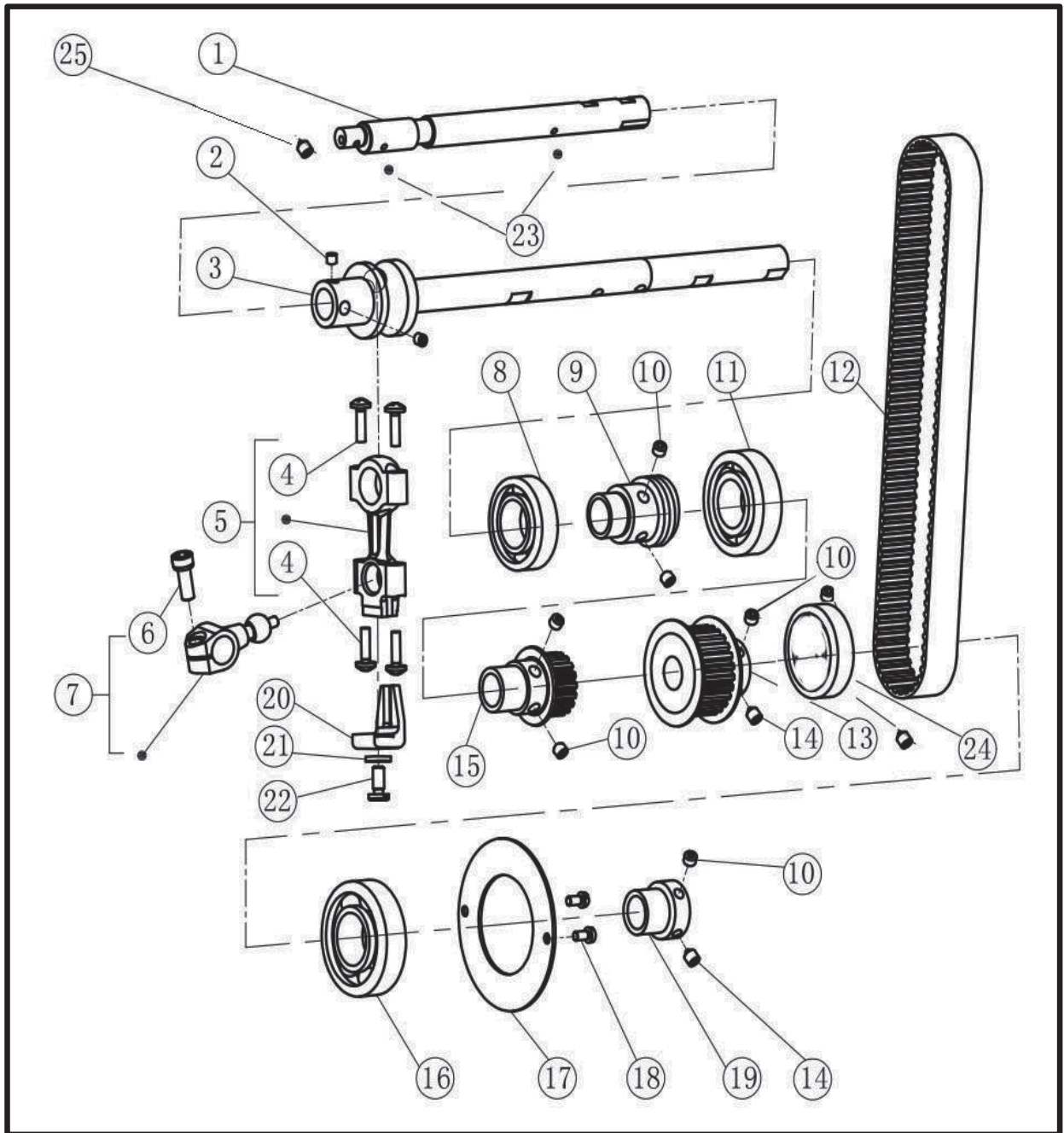
注：点划线框代表暂时不用或以改进零件。

### 三、缝台部件/Cloth plate assemblies

序号 No.	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	S01005	7021	螺钉M4×10	screw	3
2	303607		后缝台组件（喷漆）	bed cover	1
3	30213009		过线环	threadguide	1
4	S01055		螺钉 M4×6	screw	1
5	S01055		螺钉 M4×6	screw	1
6	30227030		卡簧	circlip	1
7	31012081		前罩缝台拼接块	Front cover joint	1
8	S02003		螺钉 M4×6	screw	1
9	31012088		前罩缝台面板	Front cover panel	1
10	<del>310S11003</del>	007043	螺钉M4×5	screw	3
11	310S20011		四合一缝台卡簧螺钉	screw	1
12	31001013		前罩缝台	Front hood	1
13	30222027		盖板垫	Flat mat	1
14	S02003		螺钉 M4×6	screw	1
15	31012080		缝台板	bed cover	1
16	S01004		螺钉 M4×7.8	screw	1
17	31001015		缝台块安装座	Mounting seat	1
18	31001005		针板架	needle plate	1
19	S01005		螺钉M4×10	screw	2
20	31012023	0389	左盖板	cover plate assembly	1
21	S10007	4554	螺钉M4×4	screw	2
22	S04060	7024A	螺钉M4×10	screw	2
23	301S11024		螺钉M4×8	screw	1
24	303604	0388	U型盖（喷漆）	left cover plate rack	1
25	31026004	0330	下节左盖板销	pin	1
26	31022004	0325	左盖密封垫	needle town after boards	1
27	303930		前罩缝台盖（喷漆）	Front cover	1
28	310S01011		螺钉M5×10	screw	1
29	31009005		针板架接块	bracket	1
30	S01009		螺钉M3×7.5	screw	2
31	31012084		针板接块垫块	Needle plate block	1
32	310S01011		螺钉M5×10	screw	1
33	303928		前缝台组件（喷漆）	bed cover	1
34	31026006	240198	销	pin	1
35	31001014		合销块	Closing pin	1
36	207S13008	007022A	螺钉M4×16	screw	2
37	30128002		垫片	bracket assembly	2
38	310S20006	250013	合销块螺钉	screw	1
39	S10005		螺钉M3×3	screw	2
40	30122018		防震垫	cushion	1
41	L02001		螺钉M3×3	screw	3

注：点划线框代表暂时不用或以改进零件。

#### 四、下轴部件/Hook shaft assemblies



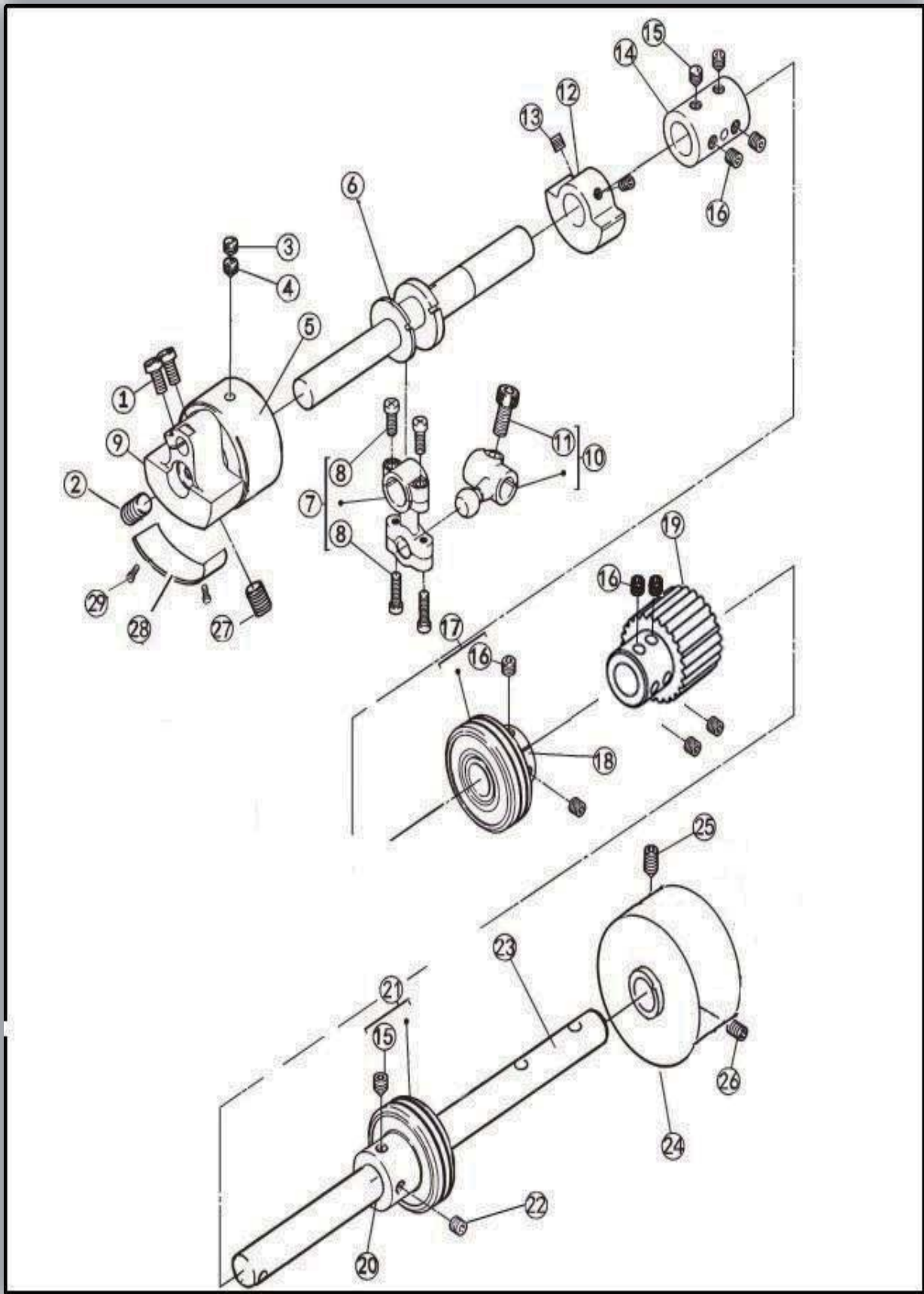
注：点划线框代表暂时不用或以改进零件。

#### 四、下轴部件/Hook shaft assemblies

序号 No.	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	400082	250551	下轴前轴	crankshaft	1
2	S10015	7128	螺钉M6×0.75×4	screw	2
3	31002008	250554-92	下轴后轴	crankshaft	1
4	201S20015	5376	铜连杆螺丝M3.5×13	screw	4
5	400070	3020500100	球连杆	connection	1
6	S05002	4534	螺钉 M6×0.75×15.2	bolt	1
7	400228	30204001	球曲柄	crank	1
8	3012400300	250529A91	油封轴承	bearing	1
9	30103008	250544	蜗杆	bushing	1
10	S10029	4547	螺钉 M6×0.75×5	screw	8
11	3012400400	250557-91	油封轴承	bearing	1
12	30135021		同步带	timing belt	1
13	3023502500	401	下轴同步带轮组件	gear (lower)	1
14	S12003	4555	螺钉M6×0.75×7	screw	2
15	3023502600	402	下轴小同步带轮组件	gear (lower)	1
16	B01003		油封轴承	bearing	1
17	30108001	250514	轴承挡圈	ring	1
18	207S11007	7018A	螺钉 M4×7.5	screw	2
19	31003004		下轴轴承套	bushing	1
20	30109001	201074	比叉	guide	1
21	W02001	202286	垫圈5	washer	1
22	301S11004	4019	比叉螺钉	screw	1
23	30223009		毛毡	sponge	2
24	131203001		防松套	bushing	1

注：点划线框代表暂时不用或以改进零件。

五、上轴部件/Main shaft assemblies



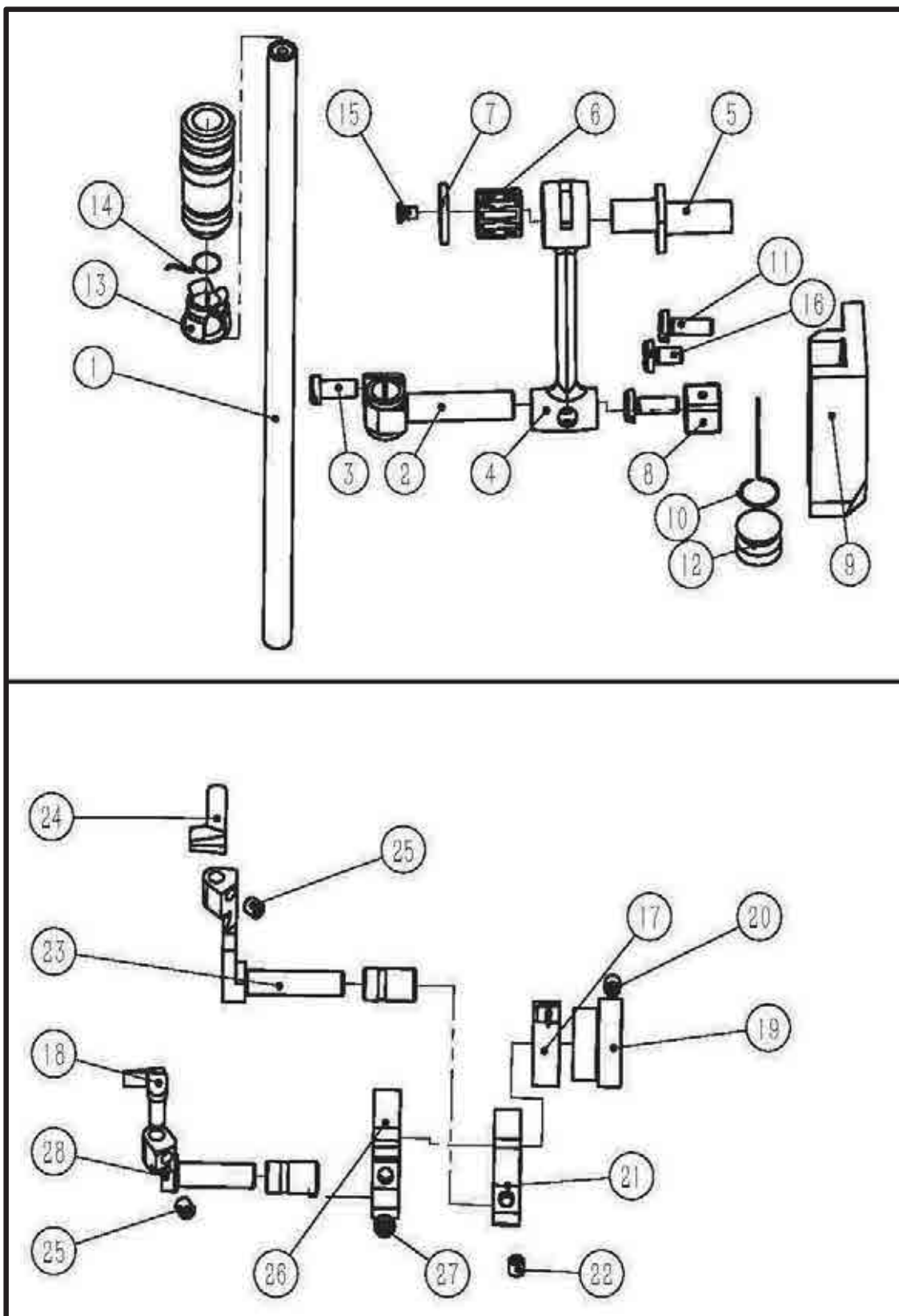
注：点划线框代表暂时不用或以改进零件。

### 五、上轴部件/Main shaft assemblies

序号 No.	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	S01011	7028	螺钉M5×10	screw	2
2	301S10004	4592	针杆曲柄螺钉	screw	1
3	S08001	7153	螺钉M6×0.75×3.5	screw	1
4	S11001	7152	螺钉M6×0.75×6	screw	1
5	30224005		针杆曲柄轴承	bearing	1
6	400065	30102005	上前轴	crankshaft	1
7	400061	30105004	弯针连杆	connection assembly	1
8	S01008	007021A	螺钉M3.5×13	screw	4
9	31004004		针杆曲柄	motion assy	1
10	30104006	253501A	弯针曲柄	crank assembly	1
11	S05002	4534	螺钉M6×0.75×15.2	bolt	1
12	30109003	250524	上轴平衡块	balance weight	1
13	S10002	4514	螺钉M5×5	screw	2
14	30103004	250506	接轴套	joint	1
15	S12003	4555	螺钉M6×0.75×7	screw	3
16	S10029	4547	螺钉M6×0.75×5	screw	8
17	3012400400	250529-91	油封轴承	bearing	1
18	30103012		轴承套	bushing	1
19	31035022		上同步带轮	gear (upper)	1
20	31003003		上轴轴承套	bushing	1
21	3012400400	250528-91	油封轴承	bearing	1
22	S10029	4547	螺钉M6×0.75×5	screw	1
23	31002011		上后轴	shaft	1
24	31035002		手轮	pulley	1
25	S12001	4556	螺钉M6×8	screw	1
26	S10009	4541	螺钉M6×8	screw	1
27	S10004	4592	螺钉M8×1×12	screw	1
28	31009001		针杆曲柄平衡块	Balance weight	1
29	S02003		螺钉	screw	2

注：点划线框代表暂时不用或以改进零件。

## 六、针杆部件/Needle bar assemblies



注：点划线框代表暂时不用或以改进零件。

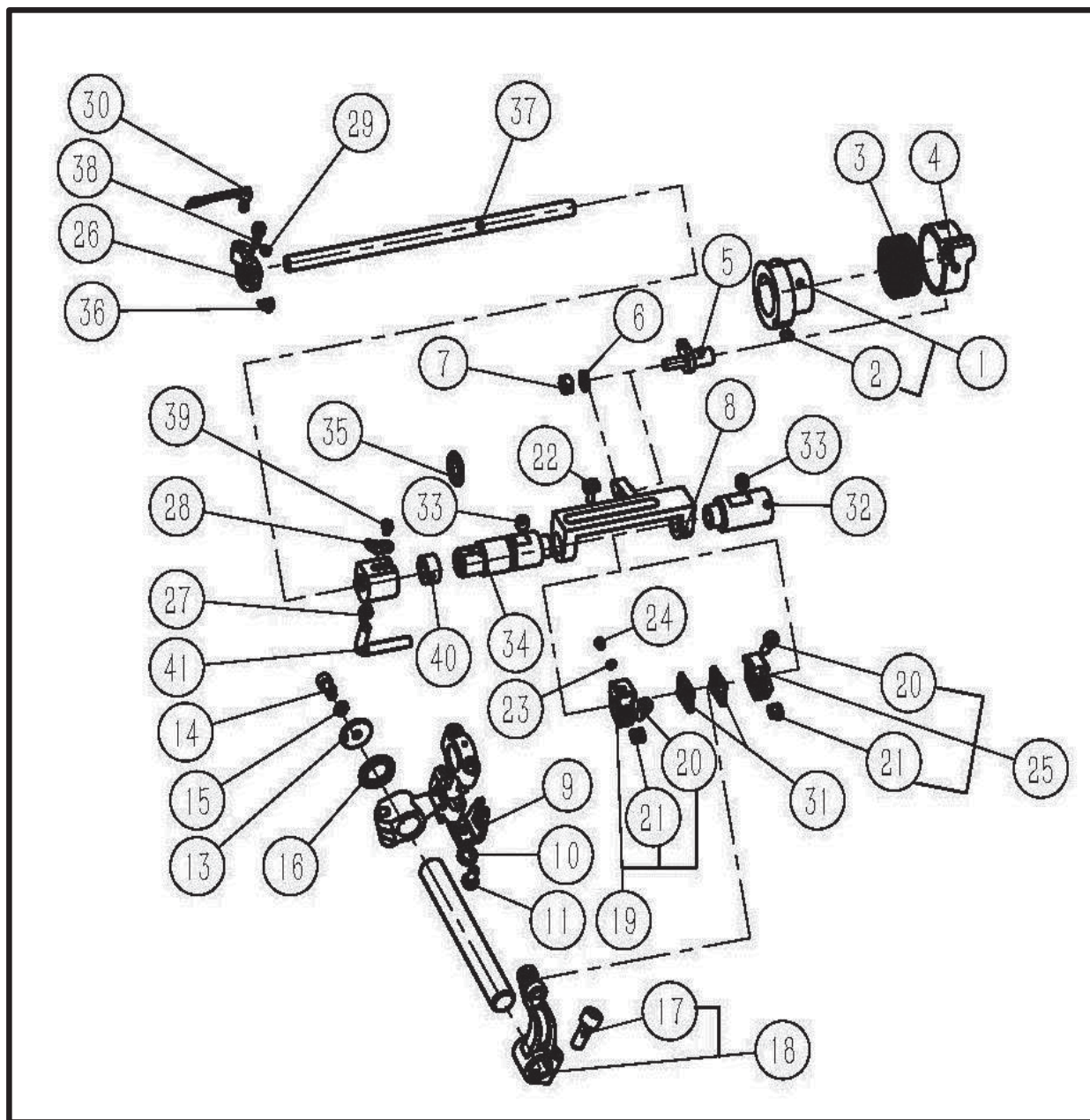


## 六、针杆部件/Needle bar assemblies

序号 No.	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	30202024	251014-91	针杆	needle bar	1
2	30102009	206061	针杆轧头	needlebar clamp	2
3	301S11005	5325	针杆轧头螺钉	screw	1
4	30205002	251016	针杆连杆	link	1
5	30102050	206053	连杆偏心轴	eccentric pin	1
6	B07001	240098	轴承K8×12×12	needle bearing	1
7	30128030	240101	偏心轴垫	washer	1
8	30109004	206063	针杆滑块	guide block	1
9	31009006	251017	滑块导座	guide	1
10	30227003	251018	毛毡弹簧	latch	1
11	S01003	7021	螺钉M4×12	screw	2
12	30123002	179040-05	毛毡	sponge	1
13	30112009	206524	油线托	oil wick retainer	1
14	30123014	212186	油线	oil wick	1
15	S02007		螺钉M3×5	screw	1
16	S01004	7019	螺钉 M4×7.8	screw	1
17	30203056		护针套筒	sleeve	1
18	30217001	257568	前护针	needle guard(front)	1
19	30210005		后护针偏心凸轮	sponge	1
20	S10007	4546	螺钉M4×4	screw	2
21	30204035	4035	护针曲柄	oil wick	1
22	301S11025	7086	护针曲柄螺钉	screw	1
23	30201008	251512	后护针架	needle guard(rear)	1
24	30217002	257567	后护针	needle guard(rear)	1
25	S10007	4543	螺钉M4×4	screw	2
26	30204003	251513-92	护线曲柄	lever	1
27	S01029	7013	螺钉M3.5×7.5	screw	1
28	30201007	251514	前护针架	needle guard(front)	1

注：点划线框代表暂时不用或以改进零件。

## 七、弯针部件/Needle guard assemblies



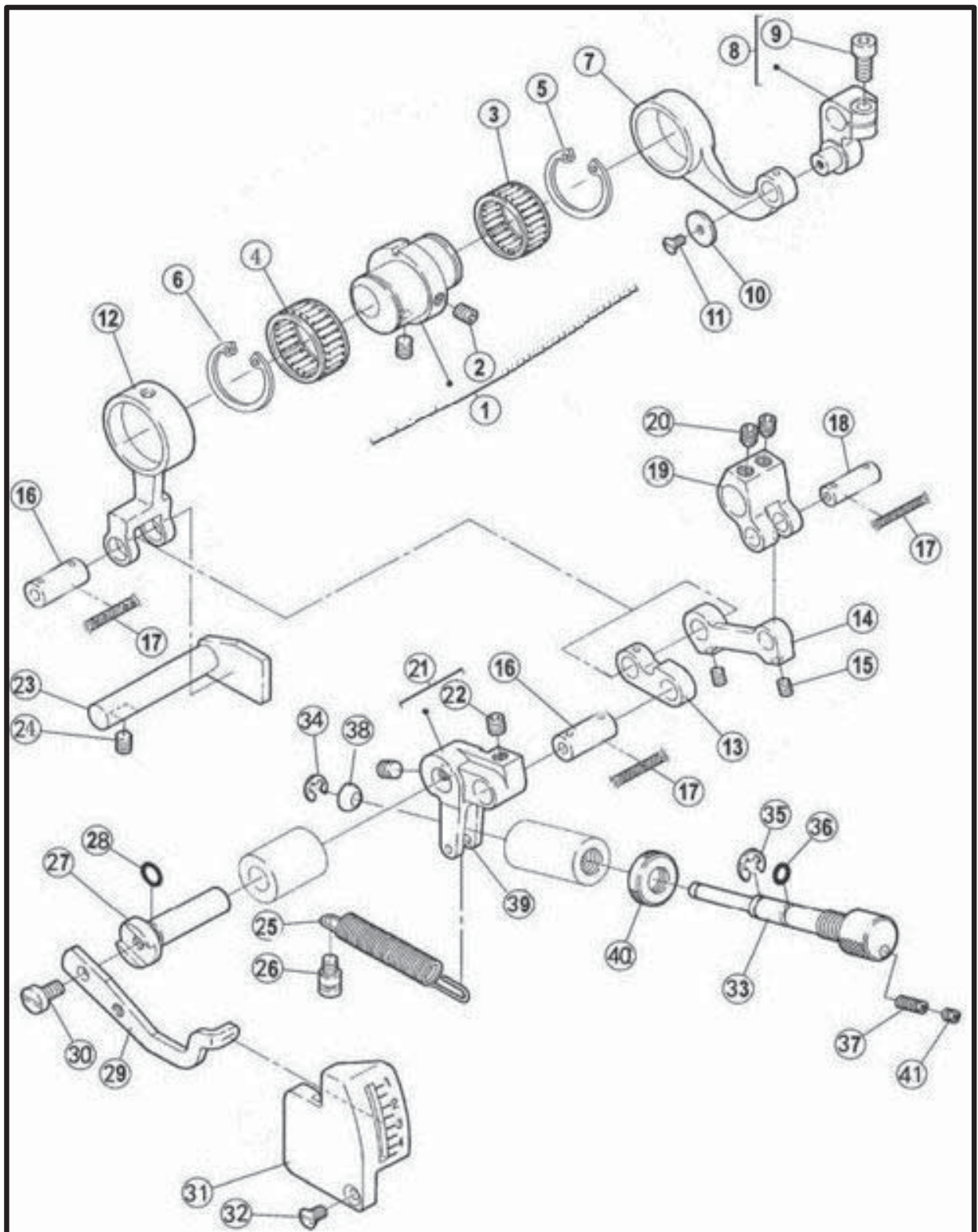
注：点划线框代表暂时不用或以改进零件。

## 七、弯针部件/Needle guard assemblies

序号 No.	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	30210002	252036-92	偏心套	eccentric	1
2	S10015	7128	螺钉M6×0.75×4	screw	2
3	B07009	206172	轴承K26×30×12.7	needle bearing	1
4	30205003	252035	连杆	rod	1
5	30226005	252037-91	滑杆销	pin assembly	1
6	N01004	4805	螺母M5	nut	1
7	W01004	240062	连杆轴垫圈	washer	1
8	30201010	252039	滑杆架	guide/looper shaft	1
9	30203045		油棉盖	oil cover	1
10	30223014		油棉	felt	1
11	12921002		回油管	pipe	1
12	30202007	252044	下弯针连杆轴	shaft	1
13	30228006	240232	垫片	washer	1
14	S05048	4524\7110	螺钉M4×10	bolt	1
15	W02002	201252	垫圈4	washer	1
16	30228005	240231	垫片	washer	1
17	30204004	252046-92	下弯针轴曲柄	lever	1
18	S05002	4534	螺钉M6×0.75×15.2	screw	1
19	30201011	252040-92	前挡块	holder	1
20	S04019	7021A	螺钉M4×12	screw	2
21	30228003	252041	下弯针轴曲柄垫片	washer	2
22	30209003	252042	弯针滑块	slider	1
23	30209004	252043	弯针滑块螺钉垫	pin	1
24	S10007	4543	螺钉M4×4	screw	1
25	30201012	252045-92	下弯针曲柄后挡块	holder	1
26	30201101		弯针固定架	looper holder	1
27	30221018		铜油嘴	joint screw	1
28	30213050		滑杆过线	threadguide	1
29	S10007	7129	螺钉M4×4	screw	1
30	30217003	257566	弯针	looper	1
31	30228004	252047	下弯针轴曲柄挡块垫片	washer	2
32	30203007	252052	滑杆后套	bushing	1
33	S10013		螺钉	screw	2
34	30203044	252049-91	滑杆前套	bushing	1
35	001021	231011	O型圈12.2×2.4	o ring	1
36	30228002	252055	弯针固定架垫片	washer	1
37	30202006	252048	滑杆	shaft	1
38	S05046		螺钉M3.5×10.5	screw	1
39	S01006		螺钉	screw	1
40	30226017		弹性圆柱销	pin	1

注：点划线框代表暂时不用或以改进零件。

## 八、护针部件/Feed mechanism



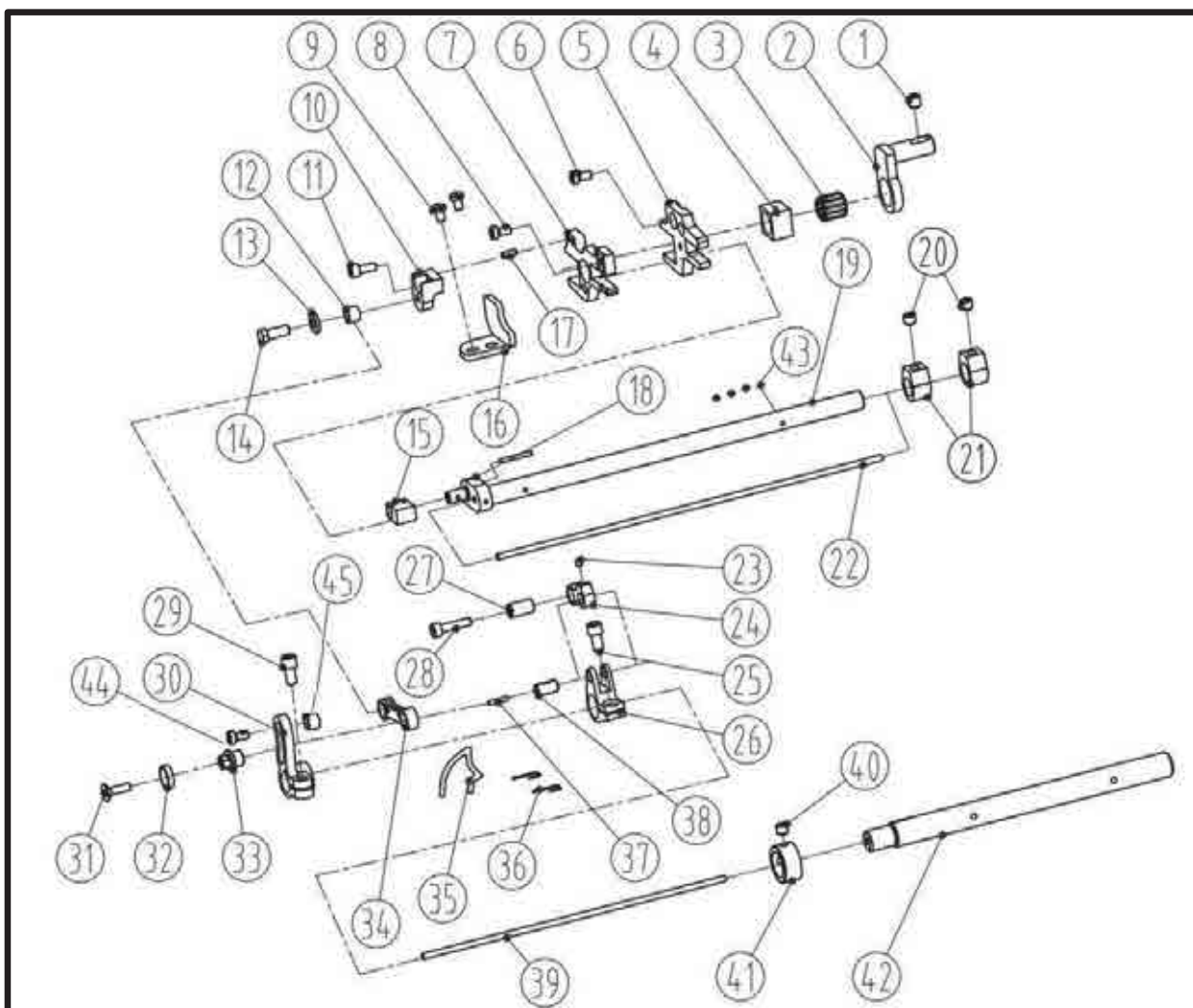
注：点划线框代表暂时不用或以改进零件。

## 八、护针部件/Feed mechanism

序号 No.	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	3021000300	252607-92	送布偏心轮组件	eccentric	1
2	S10006	4539	螺钉M5×6	screw	2
3	B07007	204084	轴承22×26×10	needle bearing	1
4	30224001	240236	轴承28×24×13	needle bearing	1
5	30229001	240234	卡簧	ring	1
6	30229002	240237	卡簧	ring	1
7	30205004	252608	连杆	rod	1
8	30204005	252609-92	曲柄	crank	1
9	S05005	4531	螺钉M5×12	screw	1
10	30228007	240055	垫片	washer	1
11	S02016	7041	螺钉M3×3.2	screw	1
12	30205005	252612	偏心连杆	rod	1
13	30205007	252614	针距轴杆	link	1
14	30205006	202176	连杆	link	1
15	S10007	4537	螺钉M4×4	screw	2
16	30226007	252613	连杆销	pin	2
17	20123021	202176	JK795油线	oil wick	1
18	30226008	252616	曲柄销	pin	1
19	30204006	252617	曲柄	crank	1
20	S10029	7142	螺钉M6×5	screw	2
21	30204007	252618-91	调节曲柄	link	1
22	S10029	2547	螺钉M6×5	screw	2
23	30202008	252622	针距调节挡板	guide	1
24	S10006	4539	螺钉M5×6	screw	1
25	30227005	252620	拉簧	spring	1
26	302S30001	7131	螺钉	screw	1
27	30202009	252621	针距指示轴	shaft	1
28	001022	240017	O型橡胶密封圈6.9×1.5	oring	1
29	30212013	252523	指示板	lever	1
30	S01011		螺钉M5×10	screw	1
31	31011007	252624-VB	刻度板	indication plate	1
32	S02004	4537	螺钉M4×8	screw	1
33	30202010	252625	针距调节轴	screw	1
34	H05012	201629	挡圈4	ring	1
35	H05006	200983	挡圈5	ring	1
36	001023	240251	O型橡胶密封圈5×1.5	o ring	1
37	S09015	4550	螺钉M4×10	screw	1
38	30209006		垫块	block	1
39	P03011		弹性圆柱销3×12	pin	1
40	302S16001	252660	针距调节轴锁紧螺母	nut	1
41	S10007	4543	螺钉M4×4	screw	1

注：点划线框代表暂时不用或以改进零件。

## 九、送布部件/Need mechanism



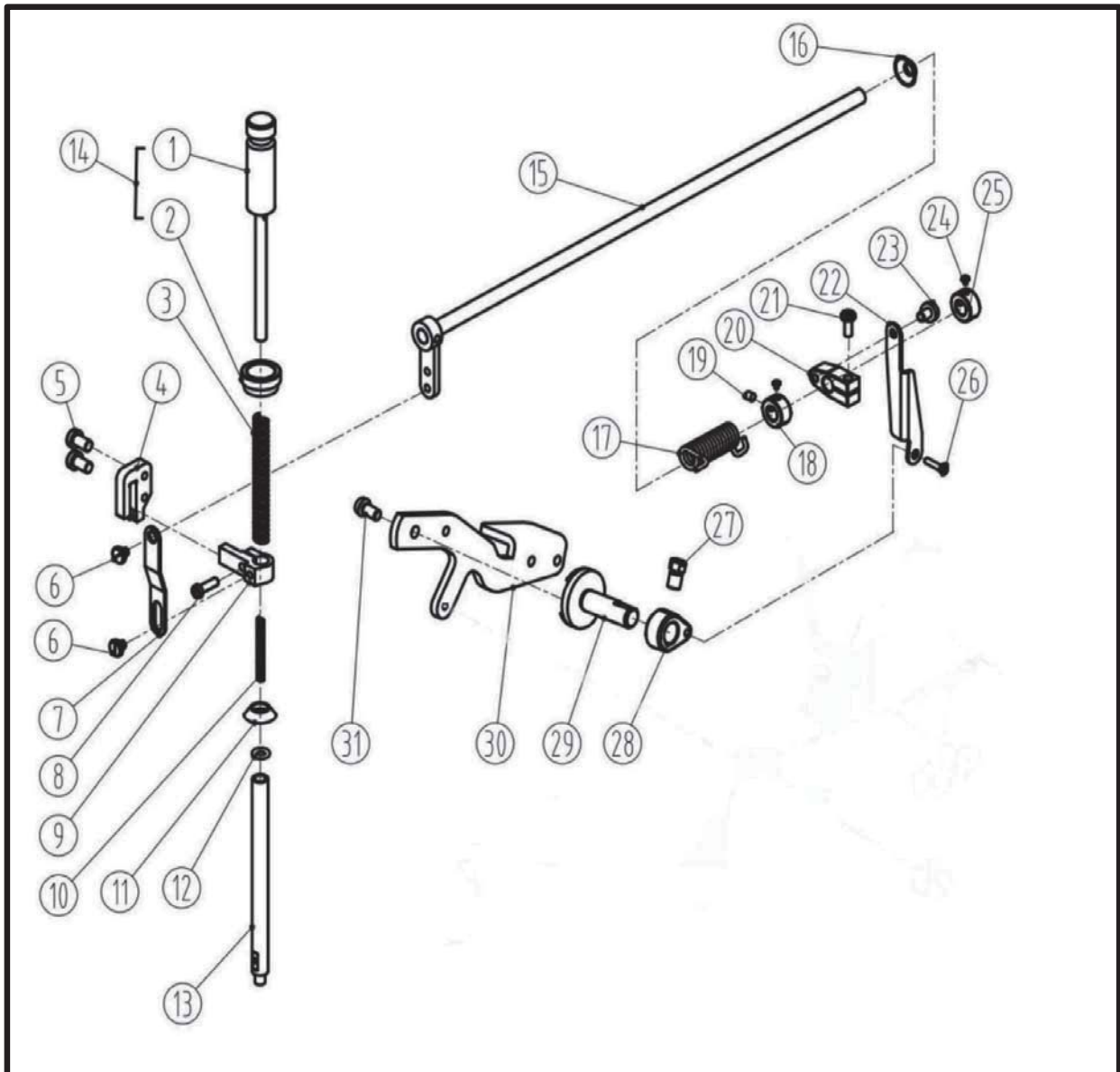
注：点划线框代表暂时不用或以改进零件。

### 九、送布部件/Need mechanism

序号 No.	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	S10013	7152	螺钉M6×6	screw	1
2	30204008	252628	送布牙架右挡板	guide (right)	1
3	B07008	210238	轴承K9×12×13	needle bearing	1
4	30209008	252632	抬牙滑块	block	1
5	30206004	0904	送布牙架	feed dog stand	1
6	301S11024		螺钉	screw	1
7	30206003	0903	差动牙架	differential braces	1
8	207S11007		螺钉	screw	1
9	S01002	7017	螺钉M4×6.5	screw	2
10	30209050	0950	差动曲柄挡板	differential crank	1
11	S05048	S7028	螺钉M4×10	screw	1
12	30203013	252637	差动小连杆衬套衬套	bushing	1
13	30228008	240039	差动小连杆衬套垫圈	washer	1
14	L01004	7056	螺栓M5×0.5×13	screw	1
15	30209080	0980	抬牙小滑块	slider	1
16	30212099	252629	牙架挡板	guide (left)	1
17	30226032	0932	定位销	pin	1
18	20123021		油线	screw	1
19	30202036	0936	抬牙轴	crankshaft	1
20	S10029		螺钉	screw	2
21	30208001		挡块	collar	2
22	20123021		油线	oil wick	1
23	S10026		螺钉M3×3(进口)	collar	1
24	30205081	0981	差动曲柄连杆	link	1
25	S05003	4531	螺钉M5×10	screw	1
26	30204077	0977	差动曲柄	link	1
27	30203041	0941	衬套	bushing	1
28	302S09010	0910	螺钉M4×18	screw	1
29	S05003	4531	螺钉M5×10	screw	1
30	30204321	1026	差动摆动连杆	link	1
31	302S17005	0905	内六角沉头螺钉	screw	1
32	30228020	1045	锥形垫圈	washer	1
33	30204322	1027	差动摆动连杆连接销	pin	1
34	30205008	252636	差动小连杆	link	1
35	30123014	202175	油线	oil wick	1
36	30126009	210766	大头针	pin	1
37	20123021		油线	screw	1
38	30226040	0940	差动曲柄销	pin	1
39	20123021	202176	JK795油线	oil wick	1
40	S10029		螺钉	screw	1
41	30208026		差动轴挡圈	collar	1
42	30202035	0935	差动轴	crankshaft	1
43	30223009		油孔毛毡	sponge	6
44	S01011		螺钉M5×10	screw	1
45	N01004		螺母M5	nut	1

注：点划线框代表暂时不用或以改进零件。

## 十、压布部件/Presser form assemblies



注：点划线框代表暂时不用或以改进零件。

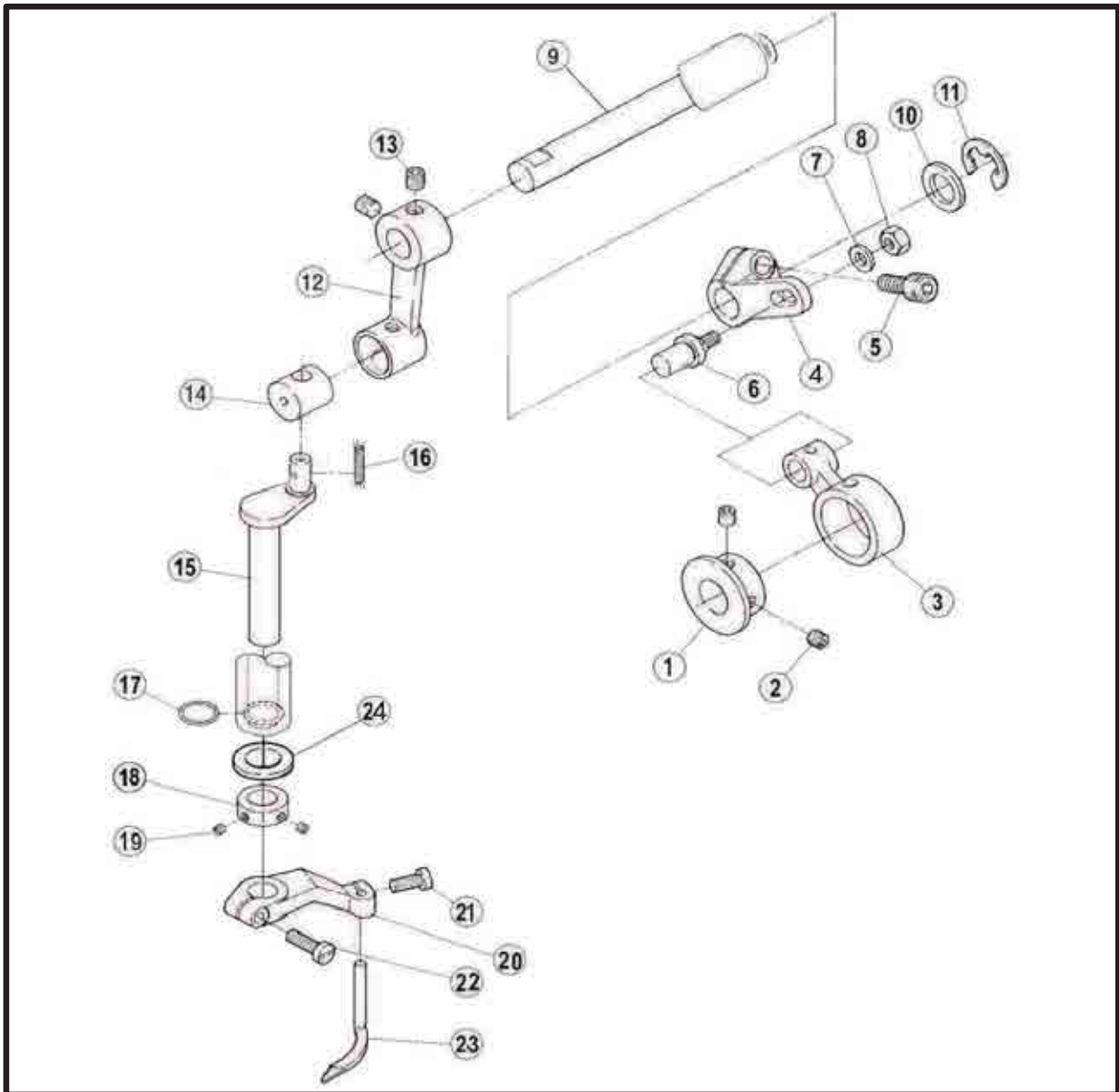


## 十、压布部件/Presser form assemblies

序号 No.	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	310S30002	253000-91	调压螺杆	adjusting bar	1
2	301S16005	253003	调压螺母	nut	1
3	30227008	240252	调压簧	spring	1
4	3010901700	253005-91	导块销簧组件	guide	1
5	S11025	7025	螺钉M4×20	screw	2
6	301S20007	5386	螺钉	screw	2
7	30112016	206157	压脚轧头连接板	link	1
8	301S11009		螺钉M4×12	screw	1
9	30104017	206139	压脚轧头	presser bar clamp	1
10	30227009	240253	压脚轴小弹簧	spring	1
11	30122023		抬压轴油封	oil guard.	1
12	001006	240095	O型圈8.5×1.8	o ring	1
13	30202017	240095	压脚轴	presser shaft	1
14	3100201000		调压螺杆组件	adjusting bar assembly	1
15	3010206400	253010	抬牙轴曲柄组件	shaft	1
16	30122023		抬压轴油封	oil guard.	1
17	30127009	253010	抬压轴簧	spring	1
18	30108005	206156	挡圈	ring	1
19	301S12001	5084	曲柄螺钉	screw	2
20	30104019	206149	抬压脚轴后曲柄	bell crank (upper)	1
21	301S11011	5187	抬压曲柄螺钉	screw	1
22	30212018	253011	抬压曲柄连接板	link	1
23	301S20008	5184	连接板螺钉	screw	1
24	301S12001	5084	曲柄螺钉	screw	1
25	30108006	192024	挡圈	ring	1
26	301S20008	5184	连接板螺钉	screw	1
27	301S20013	002022-4	抬压曲柄II固定螺钉	screw	1
28	30104020	206148	抬压扳手轴曲柄	bell crank (lower)	1
29	31002006		抬压扳手轴	shaft	1
30	31012109		压脚扳手	lever	1
31	S01011	4531	螺钉M5×10	screw	1

注：点划线框代表暂时不用或以改进零件。

# 十一、喂针部件/Needle feeding assemblies



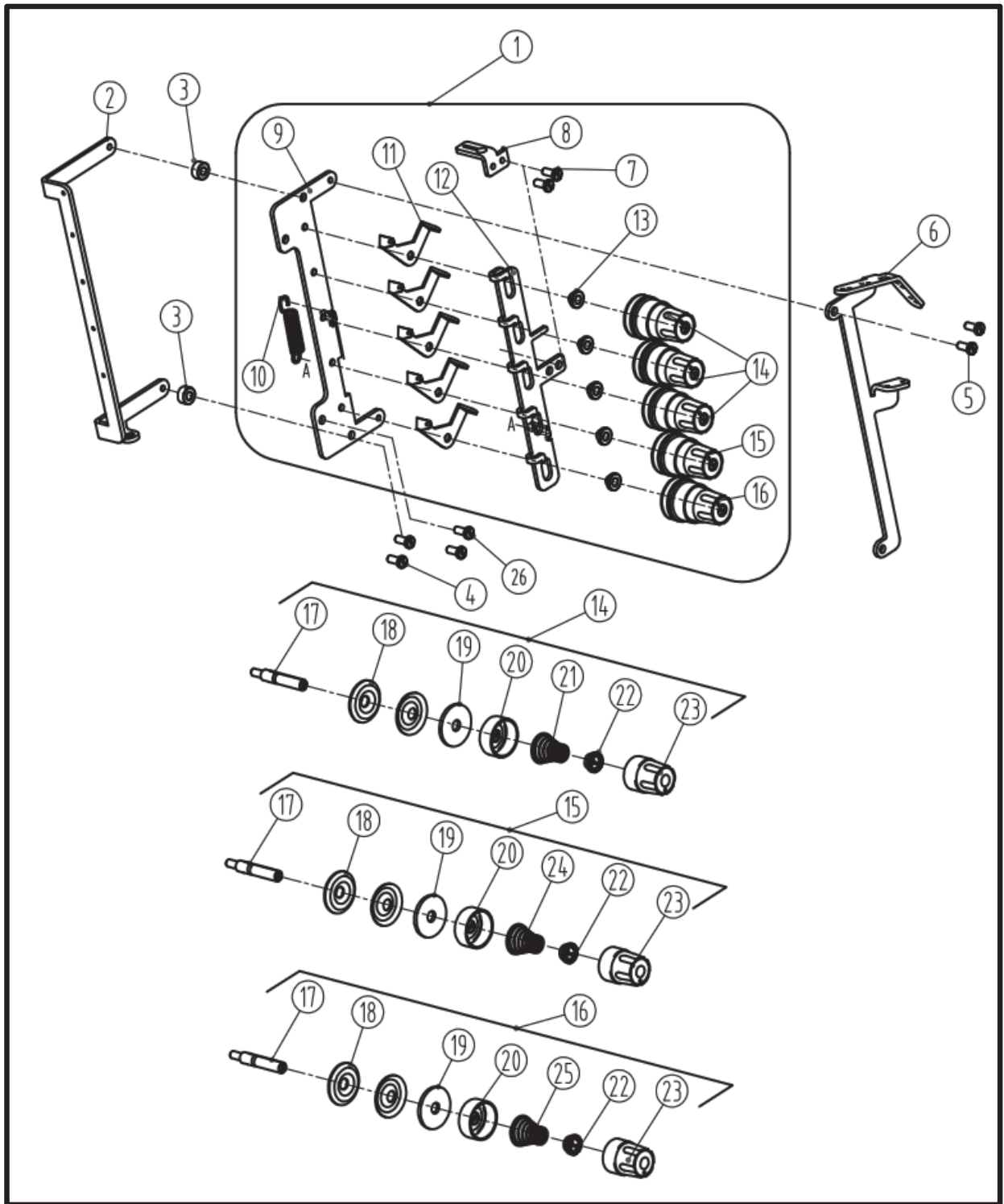
注：点划线框代表暂时不用或以改进零件。

### 十一、喂针部件/Needle feeding assemblies

序号 No.	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	30110007	254501A	喂针凸轮	eccentric assembly	1
2	S10002	4514	螺钉M5×5	screw	2
3	400059	254511	喂针连杆	connection	1
4	30104024	254503	喂针摆动曲柄	crank	1
5	S05002	4534	螺钉M6×0.75×15.2	screw	1
6	30126006	254504	喂针摆动曲柄连杆销	screw	1
7	30128032	240062	摆动曲柄垫圈5.5	washer	1
8	N01004	4805	螺母M5	nut	1
9	30102024	254519	摆动连杆轴	shaft	1
10	30128015	206180	摆动连杆轴垫圈	washer	1
11	H05004	306671	挡圈12	ring	1
12	30105013	254506B	喂针摆动连杆	crank	1
13	S10029	4547	螺钉M6×0.75×5	screw	2
14	30126005	254507	喂针摆动销	block	1
15	30202018	254518	喂针摆动架	crankshaft	1
16	20123021	202176	JK795油线	oil wick	1
17	001008	233020	O型橡胶密封圈9×1.8	o ring	1
18	30208010		挡圈	collar	1
19	S10026		挡圈螺钉	screw	2
20	30104022	254516	喂针架	lever assembly	1
21	S01005	7020	螺钉M4×10	screw	1
22	S01017	7022	螺钉M4×14	screw	1
23	30117005	257565	喂针	spreader	1
24	30128018		喂针摆动轴套垫圈10	washer	1

注：点划线框代表暂时不用或以改进零件。

十二、松线部件(一)/Thread loosening assemblies (one)



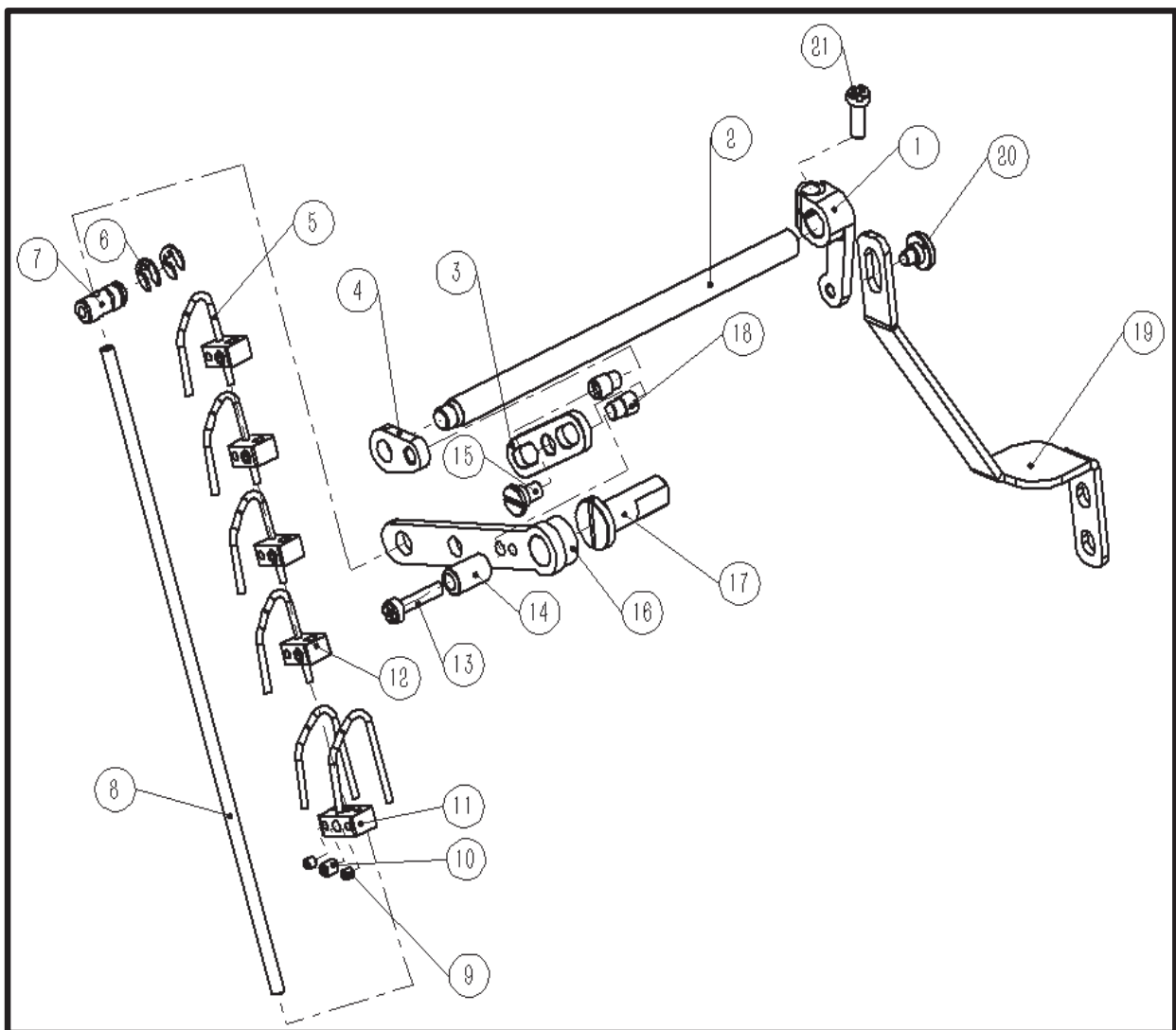
注：点划线框代表暂时不用或以改进零件。

## 十二、松线部件(一)/Thread loosening assemblies (one)

序号 No.	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	3101300700	201068	夹线器	tension	1
2	31013010		松线架	loose thread stand	1
3	31009004		松线垫块	block	2
4	S04019		螺钉M4×12	screw	2
5	<del>207S11011</del>		螺钉M4×5.5	screw	2
6	31013022		夹线器过线	loose line board	1
7	S04010		螺钉M4×5.5	screw	2
8	31012048		松线拉板	loose line board	1
9	31013007		过线架	loose line board	1
10	30127010		调节板簧	reset spring	1
11	30113007		二孔过线板	thread guide	5
12	31013008		松线板	loose line board	1
13	30103041	206202	调节套	spacer	5
14	3011300400	254010A9U	调线组件(强)	tension spring assembly(heavy)	3
15	3011300500	254010B9U	调线组件(中)	tension spring assembly	1
16	3011300600	254010C9U	调线组件(弱)	tension spring assembly(light)	1
17	301S30010	001817-2A	夹线延	screw stud	1
18	30128016	210319	夹线片	tension disc	2
19	20623008		松线夹线片垫	felt	1
20	21111096	208450-UA	调压止动盖	cup	1
21	30127011	301037	调压簧(强)	spring(heavy)	3
22	30111006	208448	调压止动套	ratchet	1
23	20111091	208447-UA	调压螺母	nut	1
24	30127012	201086	调压簧(中)	spring(medium)	1
25	30127013	201068	调压簧(弱)	spring(light)	1
26	<del>207S11007</del>		螺钉 M4×7.5	screw	2

注：点划线框代表暂时不用或以改进零件。

### 十三、松线部件(二)/Thread loosening assemblies (two)



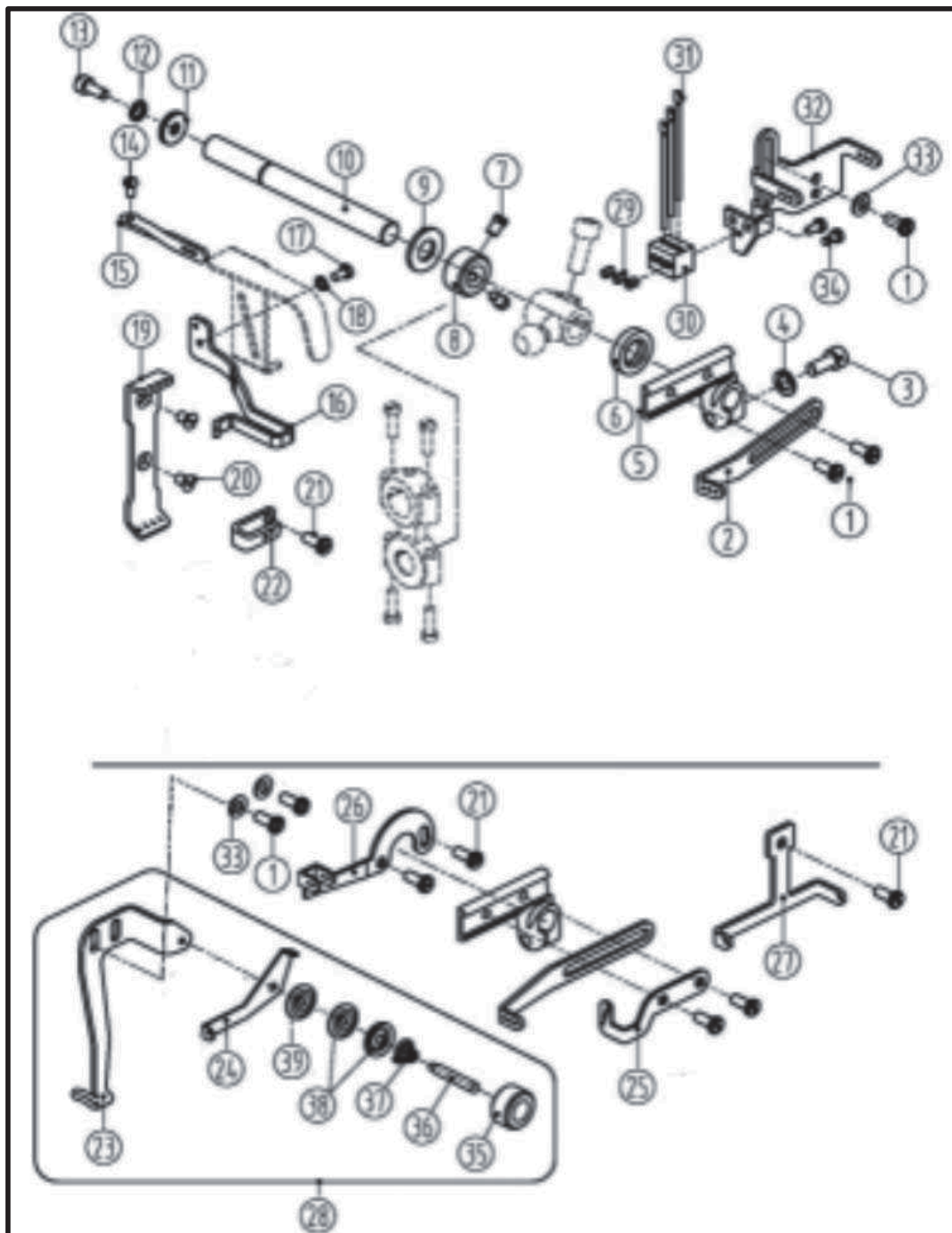
注：点划线框代表暂时不用或以改进零件。

### 十三、松线部件(二)/Thread loosing assemblies (two)

序号 No	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	131412006		松线曲柄	crank	1
2	30502018		松线轴	shaft	1
3	131412004		转接板	thread	1
4	131404002		松线轴前曲柄	crank	1
5	30129058		松线	thread releaser	6
6	H05006		卡簧	ring	2
7	31028003		管座	holder	1
8	31002007		挑线杆	shaft	1
9	207S14009		螺钉M3x3	screw	6
10	S01007		螺钉M4x4	screw	5
11	31009003		长打线块	block	1
12	31009002		小打线块	block	1
13	S04020		螺钉	screw	1
14	31003005		轴套	spacer	1
15	423S20004		轴位螺钉	screw	1
16	131404002		松线曲柄	crank	2
17	31026003		轴位销	shaft pin	1
18	301S20030		螺钉	screw	2
19	131512002		松线摆杆	plate	1
20	206S20004		轴位螺钉	screw	1
21	S05005		螺钉M5×12	screw	1

注：点划线框代表暂时不用或以改进零件。

#### 十四、过线部件/Thread loosening assemblies



注：点划线框代表暂时不用或以改进零件。

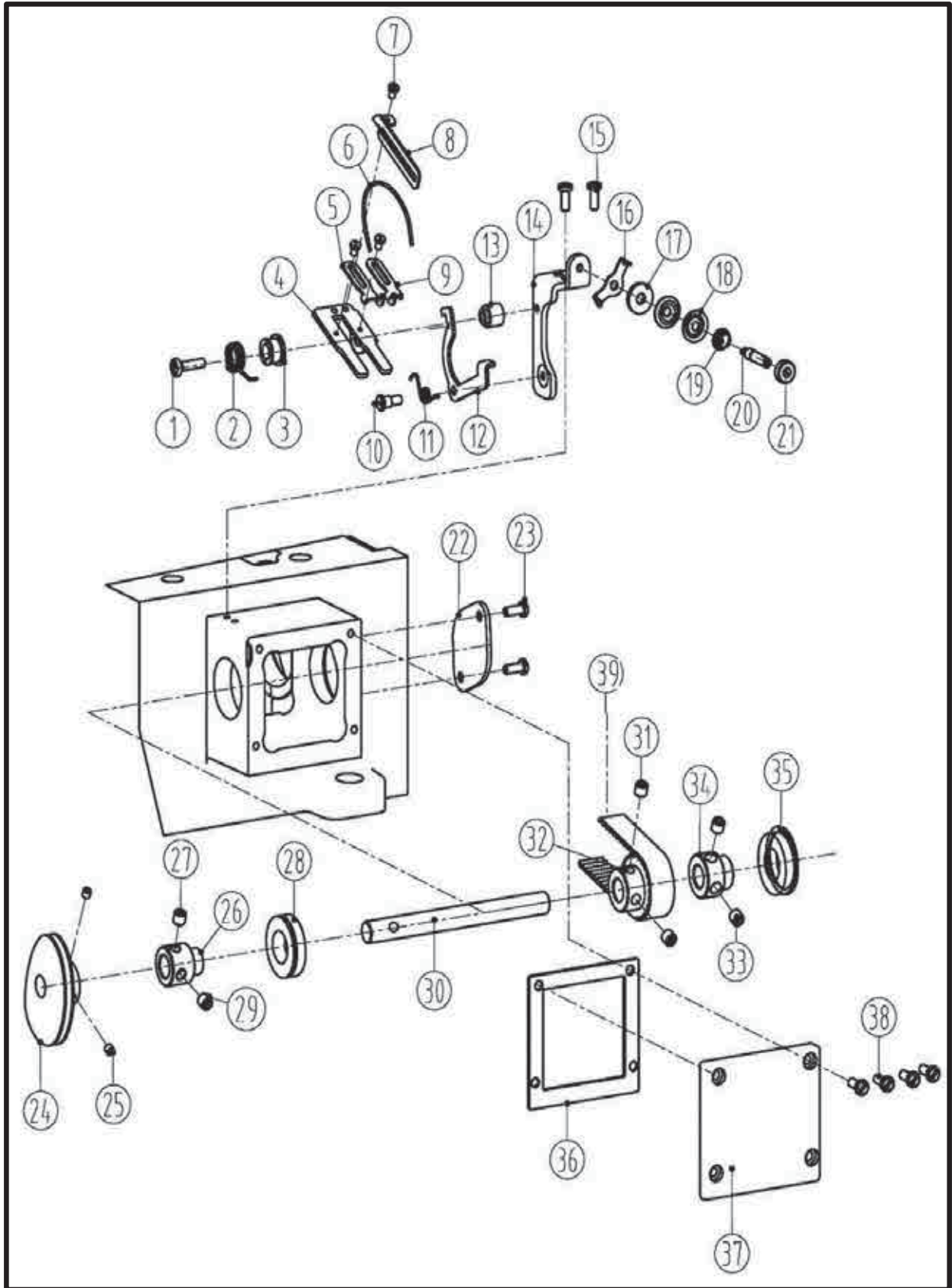


#### 十四、过线部件/Thread loosing assemblies

序号 No.	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	S01004	7019	螺钉M4×7.8	screw	5
2	31013006	253505A	长过线板	thread take-up	1
3	S05004	4501	螺钉M5×14	screw	1
4	W02001	303067	垫圈	washer	1
5	30101018	253504	过线座	lever	1
6	20622019		油封	plug	1
7	301S12001	5084	曲柄螺钉	screw	2
8	30108008	240201	过线座轴挡圈	ring	1
9	30128008		摆架轴垫圈	washer	1
10	31002001	253503	过线座轴（中轴）	shaft	1
11	30128019	204107	挑线轴垫圈4.5	washer	1
12	W02002	201252	M4垫圈	washer	1
13	S05048	4527	螺钉M4×10	screw	1
14	S01027	7009	螺钉M3×6	screw	1
15	31013017	253507	针杆三孔过线	thread guide	1
16	131412002		护线罩	thread support	1
17	S01027		螺钉	screw	2
18	30128034		护线罩垫圈3.5	washer	2
19	131213001		针杆过线板	thread guide	1
20	206S30016	7170	螺钉	screw	2
21	S01004	7018	螺钉M4×7.8	screw	4
22	31012045		U型夹线座	thread tension brackeat	1
23	30112032	253547	喂针二眼过线	thread guide	1
24	31012046	253548	喂针过线板	thread guide	1
25	31012018		长过线压板	thread guide	1
26	30112029	253514	喂针过线	thread guide	1
27	31013011	253515	过线板	thread guide	1
28	3101204600		喂针二眼过线组件	thread guide	1
29	S10001	4535	螺钉 M3×4	screw	3
30	30113012	253545	针杆过线座	holder	1
31	30113013	234521	过线杆	thread guide	3
32	30112027	253544	硅油合固定架	thread guide	1
33	W01001	303448	M4垫垫片	washer	3
34	S01006	7009	螺钉M3×4.5	screw	2
35	302S16005		调压螺母	adjusting nut	1
36	301S30055		调压螺钉	adjusting screw	1
37	12927012	137109	夹线簧	spring	1
38	12928036	137108	夹线片	thread retainer	2
39	10128001		松线铺钉垫片	sticker	1
37	12927012	137109	夹线簧	spring	1
38	12928036	137108	夹线片	thread retainer	2
39	10128001		松线铺钉垫片	sticker	1

注：点划线框代表暂时不用或以改进零件。

十五、打线凸轮部件/Cam assesblies



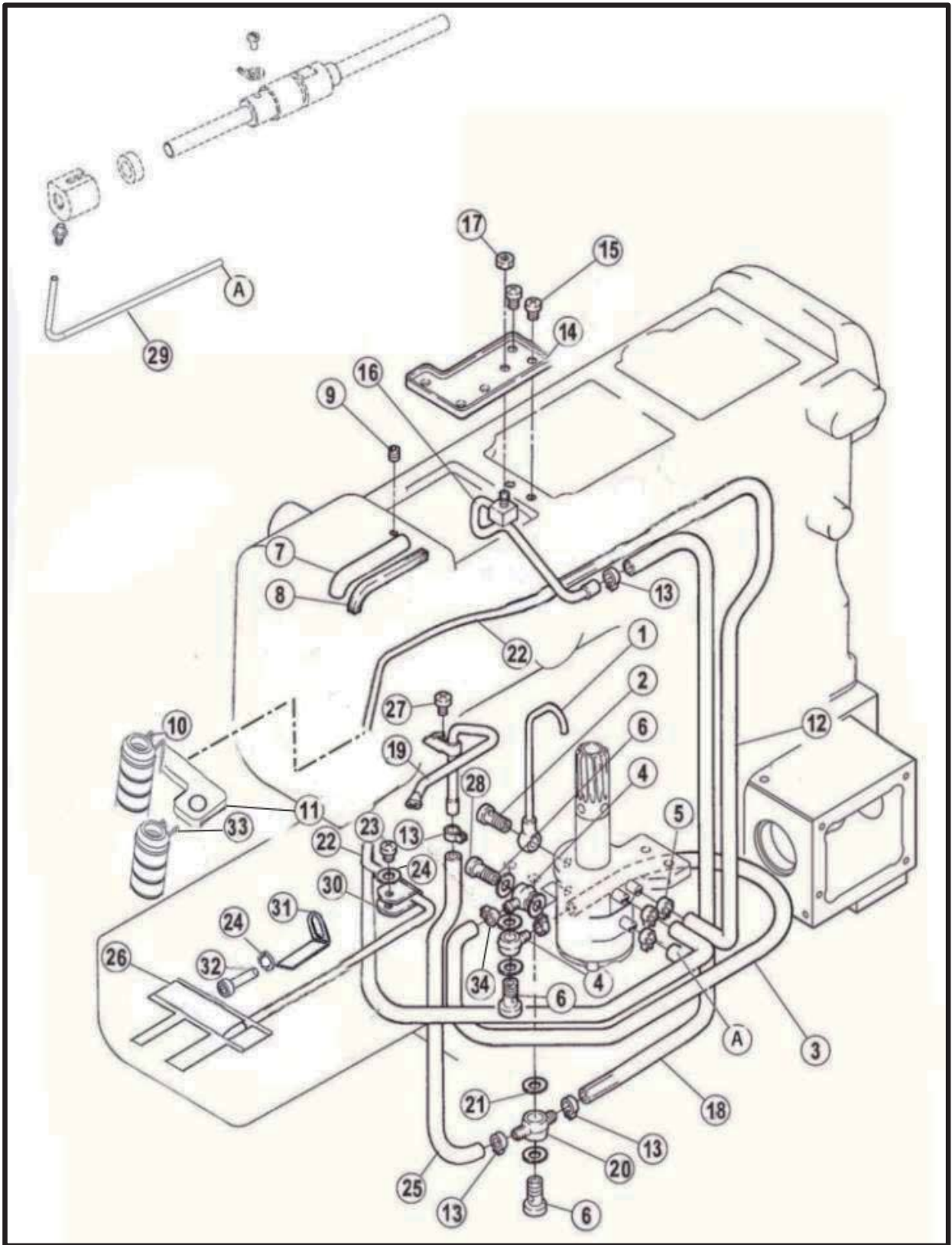
注：点划线框代表暂时不用或以改进零件。

### 十五、打线凸轮部件/Cam assesblies

序号 No.	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	S04004		螺钉M4×15	screw	1
2	30227016	1516	复位弹簧	reset spring	1
3	30208020	1520	打线架挡圈	Fight line retaining ring	1
4	30212068	1568	打线架组件	bracket	1
5	30313019		打线凸轮左过线	thread guide (left)	1
6	30123022		毛根	Wool top	1
7	S01006	7009	螺钉M3×4.5	screw	3
8	30212084	1584	打线片	thread guide	1
9	30313020		打线凸轮右过线	thread guide (right)	1
10	310S20007		螺钉	screw	1
11	31027002		限位片复位簧	reset spring	1
12	31012037		打线凸轮架扳手	fight line wrench	1
13	30208022	1522	打线凸轮架止动圈	stop	1
14	31012036		打线架安装板	layer	1
15	S01002	7017	螺钉M4×6.5	screw	2
16	30213024	167079	两眼过线	thread guide	1
17	10128001		松线铺钉垫片	sticker	1
18	12928036	137108	小夹线片	thread retainer	2
19	12927012	211388	夹线簧	spring	1
20	301S30055		调压螺钉	adjusting screw	1
21	1311NS16002		自锁调压螺母	adjusting nut	1
22	31012034		打线凸轮端盖	cover	1
23	S01002		螺钉M4×4	screw	2
24	3101302700		打线凸轮组件（外移）	looper thread take-up	1
25	S10007		螺钉M4×4	screw	2
26	31008010		轴承套	collar	1
27	S10007		螺钉M4×4	screw	1
28	B04042		深沟球轴承（61902-ZNR）	bearing	1
29	S10007		螺钉M4×4	screw	1
30	31002012		凸轮轴	shaft	1
31	S10029	4547	螺钉M6×0.75×5	screw	2
32	30235027		凸轮轴小同步带轮	time belt	1
33	S10029	4547	螺钉M6×0.75×5	screw	1
34	30203038		凸轮轴轴承套	bushing	1
35	30224004		油封轴承（6902-ZNR）	bearing	1
36	31022011		凸轮座盖板垫	felt	1
37	303603		打线凸轮座盖板	cover	1
38	S01005	7017	螺钉M4×10	screw	4
39	30235045	4547	小同步带	timing belt	1

注：点划线框代表暂时不用或以改进零件。

## 十六、润滑部件/Lubrication assemblies



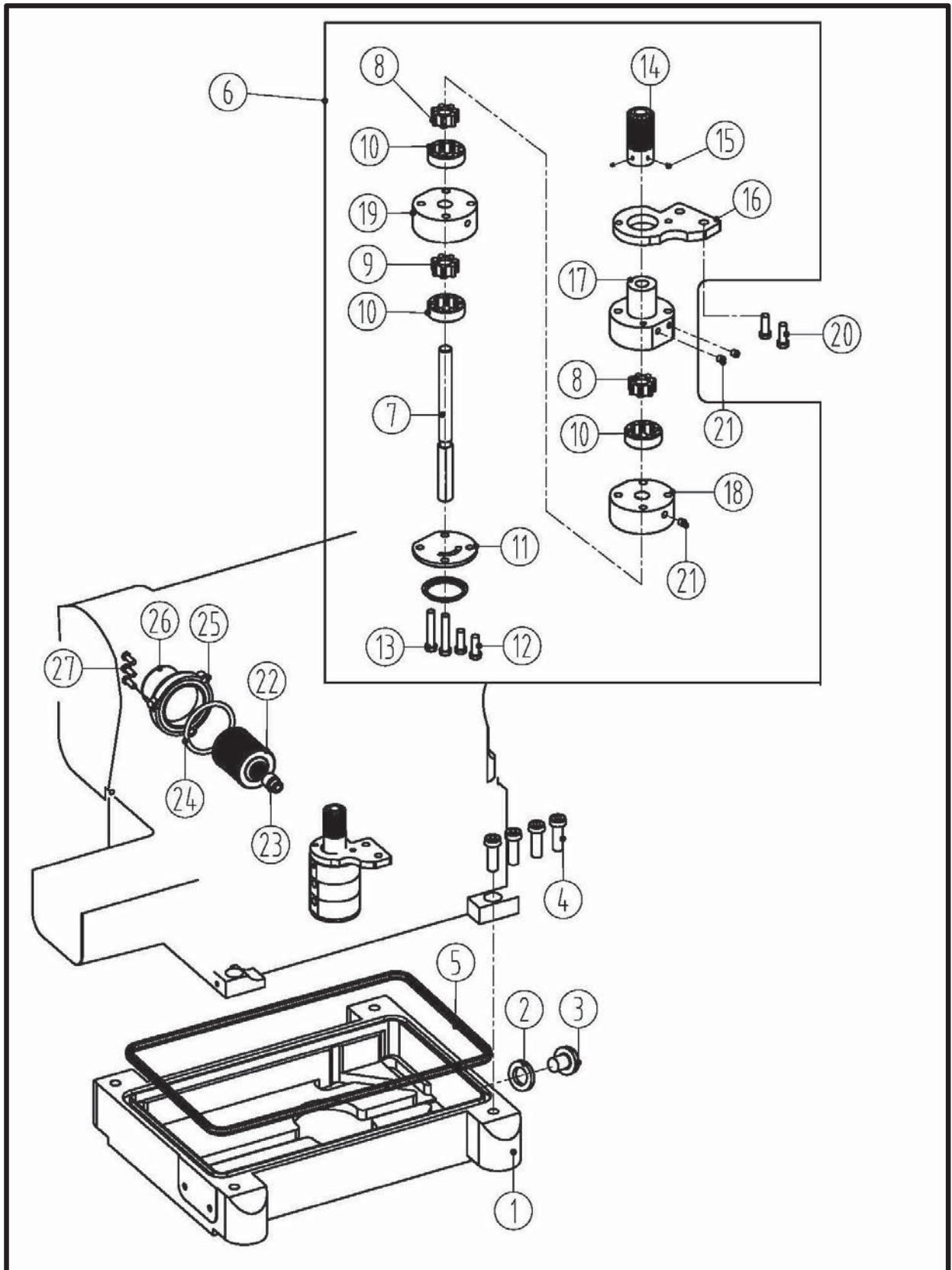
注：点划线框代表暂时不用或以改进零件。

## 十六、润滑部件/Lubrication assemblies

序号 No.	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	30136006	1609	铜油管接头	pipe	1
2	301S30012	255037	油管螺钉	screw	1
3	30121021	205113A	油管 $\Phi 5 \times \Phi 7$	tube	1
4	20636001	200136	油管接头	joint	2
5	30129006	202199	油管卡簧 (大)	clamp	3
6	301S30013	200152	过油螺钉	screw	2
7	30221003	255003	铜油管	oil pipe	1
8	30123010	240136	油毡	felt	1
9	S10002	4514	螺钉 M5×5	screw	1
10	31027005		回油毡卡簧	back felt circlip	1
11	3102300100		针杆回油毡组件	The needle bar back felt	1
12	12921002	240006	$\Phi 3 \times \Phi 5$ 油管	screw	1
13	20429001	202199	油管卡簧	clamp	4
14	30112039	255006	接油盘	oil guard	1
15	S01002	7017	螺钉 M4×6.5	screw	2
16	3012101500	255007-91	喷油管	oil distributor	1
17	N01001	4821	螺母 M4	nut	1
18	12921005	240134	$\Phi 4 \times \Phi 6$ 油管	tube	1
19	3022100800	255094-91	油管组件	oil splash pipe	1
20	30136005	255123	双头油管接头	joint	1
21	20122033		垫片	washer	6
22	12921002		$\Phi 3 \times \Phi 5$ 油管	screw	1
23	S04010	7018A	螺钉 M4×5.5	screw	2
24	W01001		垫片	sticker	2
25	30221023		回油管	pipe	1
26	30223022		机座回油毡	felt	1
27	S01002	7018	螺钉M4×6.5	screw	1
28	201S30004		过油螺钉	joint screw	1
29	12921002		$\Phi 3 \times \Phi 5$ 油管	tube	1
30	20712055		油管夹	tubing clamps	1
31	30227040		固定板	screw	1
32	<del>207S13007</del>		螺钉	screw	1
33	30127060		毛毡卡簧	back felt circlip	1
34	30129006		油管卡簧 (大)	clamp	2

注：点划线框代表暂时不用或以改进零件。

十七、油泵部件/Oil pump assemblies



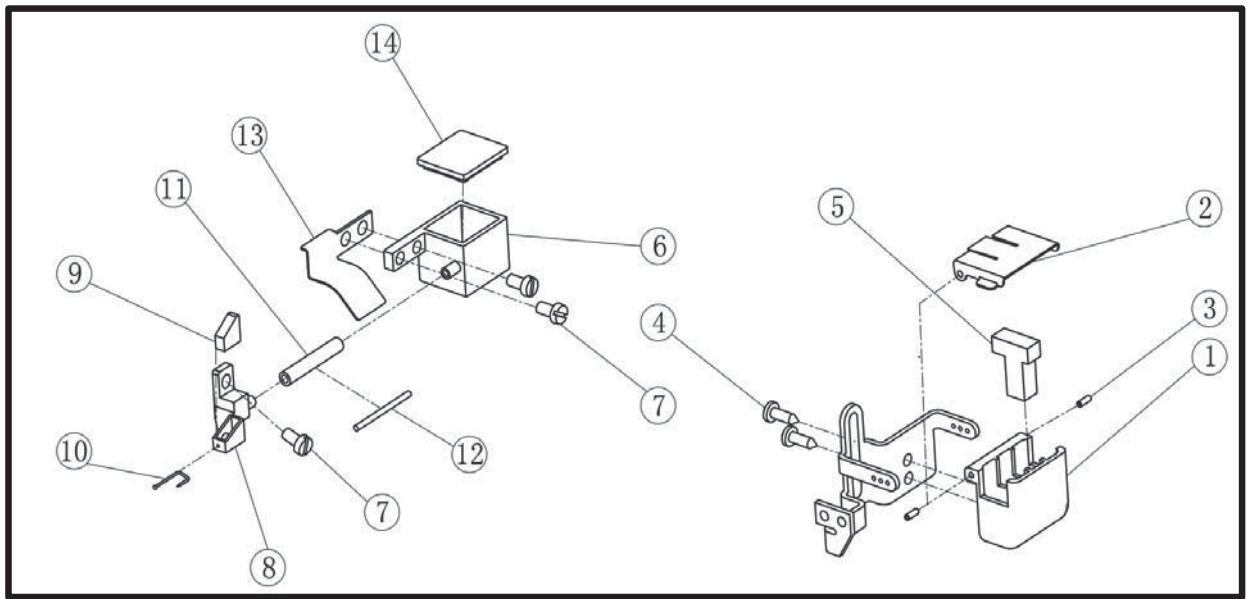
注：点划线框代表暂时不用或以改进零件。

## 十七、油泵部件/Oil pump assemblies

序号 No.	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	30201029	225041	油盘	oil reservoir	1
2	20528014	202287A	垫圈	washer	1
3	301S11015	5138B	堵油螺钉	screw	1
4	S05007	4504	螺钉 M8×20	screw	4
5	30222014	255042	油盘密封圈	o ring	1
6	3022000300	1722	油泵组件	oil pump assy	1
7	30102044	255024	油泵轴	shaft	1
8	30120030	1730	主动轮	rotor	2
9	30120030	1730	主动轮	rotor	1
10	30120031	255027	从动轮	rotor	3
11	30120008	255028	油泵盖	cover	1
12	301S20011	7105	油泵螺钉	screw	2
13	302S13002	1713	油泵螺钉	screw	2
14	30125003	255019	油泵蜗轮	worm wheel	1
15	S10002	4514	螺钉 M5×5	screw	2
16	30120002	W17-4	油泵固定板	oil pump fixed plate	1
17	30220002	1714	油泵体（上）	pump body	1
18	30120009	1719	油泵体（中）	pump body	1
19	30120003	1720	油泵体（下）	pump body	1
20	S05004	4534	螺钉 M5×12	screw	2
21	301S30014	205111	过油螺钉	joint screw	3
22	20136004	206233	滤油器	oil filter	1
23	201S30030	210200	螺钉	screw	1
24	001010	206431	O型圈38.7×3.55	O ring	1
25	300140	210201-PD	滤油器盖	cover	1
26	30131004	9A3002	提示说明	filter seal	1
27	207S11008	7021	螺钉M4×12	screw	3

注：点划线框代表暂时不用或以改进零件。

## 十八、硅油盒装置部件/Silicon oil delice assemblies



注：点划线框代表暂时不用或以改进零件。

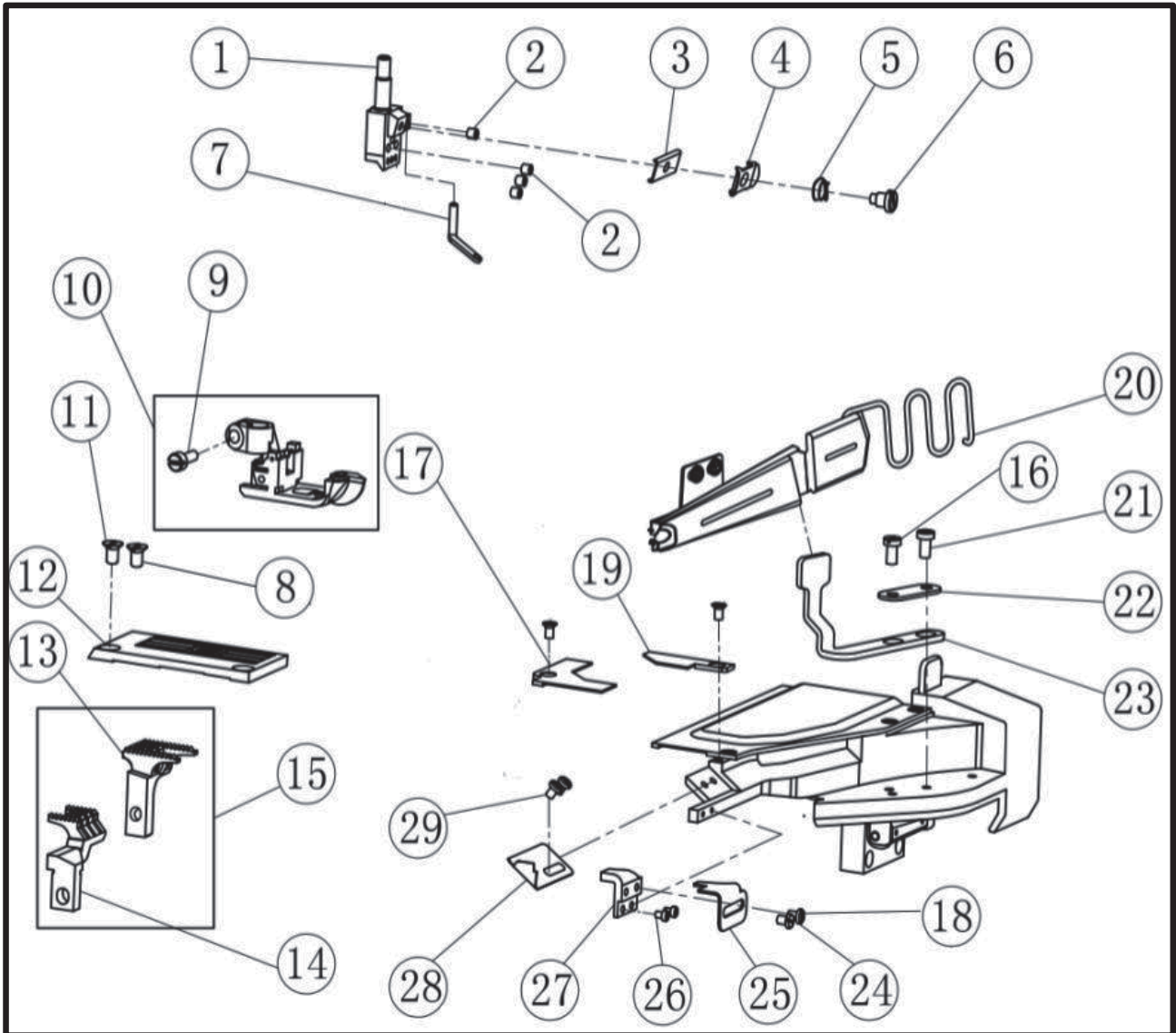


### 十八、硅油盒装置部件/Silicon oil delice assemblies

序号 No.	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	30111070		上硅油盒	silicone oil reservoir (upper)	1
2	30112040	207067-PD	上硅油盒盖	cap	1
3	P03008	206781	销 2×6	pin	2
4	S16002	7009	自攻螺钉 ST3.5×8	screw	2
5	30123011	207068	硅油棉	felt	1
6	30201075	1075	下硅油盒	silicone oil box	1
7	207S11007	7019	螺钉 M4×7.5	screw	3
8	30201014	255107	固定架	needle cooler (lower)	1
9	30223005	240247	硅油棉	felt	1
10	30126009	210766	销	pin	1
11	12921002	240246	维尼龙油管	tube	1
12	20123021	202175	JK8568油线	oil wick	1
13	30212666	2666	硅油盒挡板	silicone oil box baffle	1
14	30222028	2028	下硅油盒盖	silicone oil box cover	1

注：点划线框代表暂时不用或以改进零件。

十九、针位组专用件部件/Gauge set specific parts



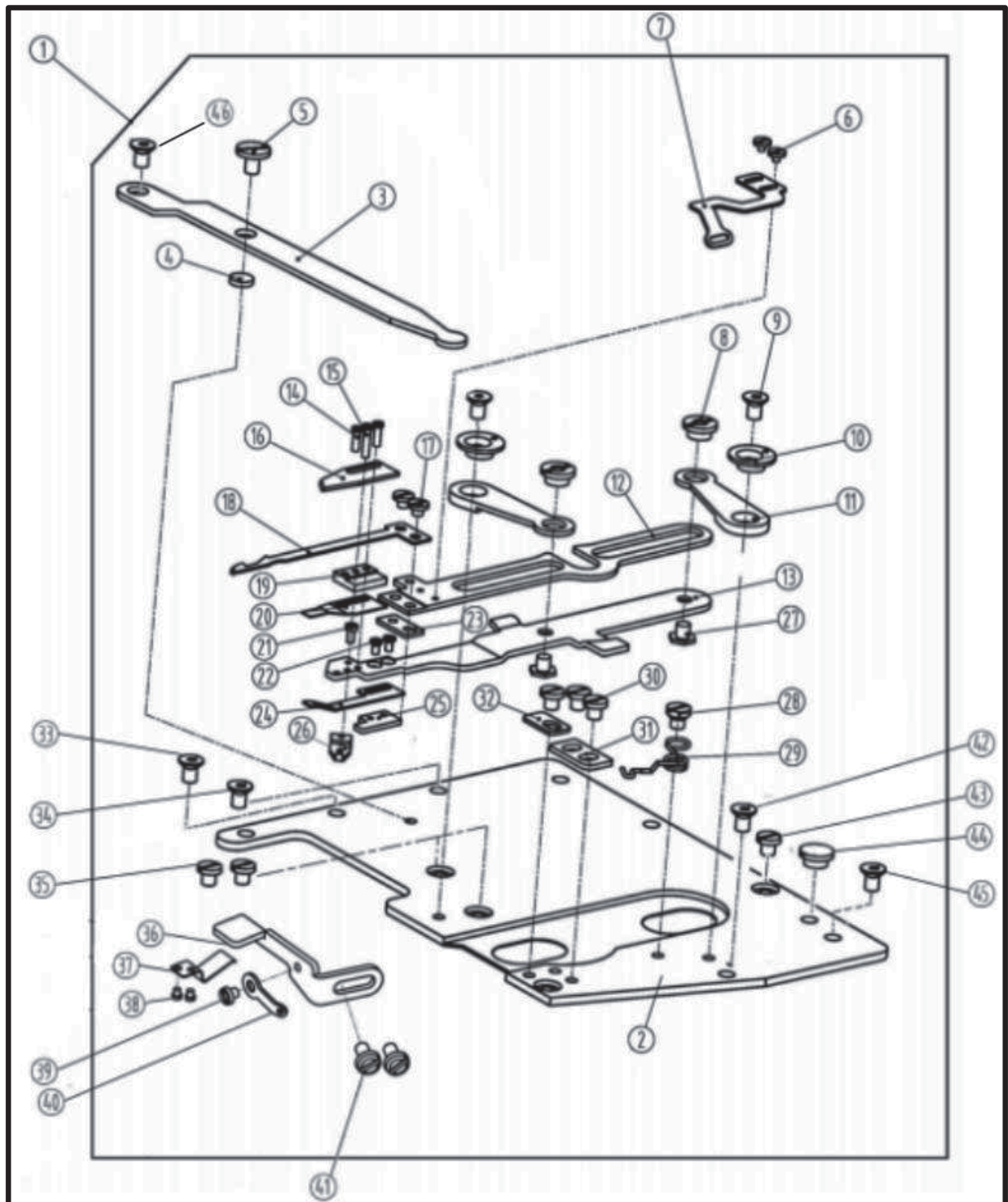
注：点划线框代表暂时不用或以改进零件。

### 十九、针位组专用件部件/Gauge set specific parts

序号 Ref. No	公司件号 Part No	参考件号 Ref. Part. No	名称	Description	数量 Number
1	30134001		356针古	needle holder	1
	30134002		364针古	needle holder	1
2	S10026	4554	螺钉M3X3	screw	4
3	30112025	234561	夹线板	thread guide	1
4	30112026	253593	压线板	tension disc	1
5	30127014	253517	调压簧	spring	1
6	301S20009	0W09070-2	调线螺钉	screw	1
7	30112033	253511	喂针小过线	thread guide	1
8	302S17001		螺钉(进口)	screw	1
9	301S11010	1170-3	压脚固定螺钉	screw	1
10	3021601000		压脚(01GB)	presser foot assy(01GB)	1
	30116005		压脚(02BB*356)	presser foot assy(02BB*356)	1
	30116006		压脚(02BB*364)	presser foot assy(02BB*364)	1
11	302S17001		螺钉(进口)	screw	1
12	30115067		356针板(01GB)	needle plate(01GB*356)	1
	30115068		364针板(01GB)	needle plate(01GB*364)	1
	30115006		356针板(02BB)	needle plate(02BB*356)	1
	30115007		364针板(02BB)	needle plate(02BB*364)	1
13	30214001		送布牙(01GB)	main feed dog(01GB)	1
14	30214002		差动牙(01GB)	diff feed dog(01GB)	1
15	3021400100		送布差动牙组件(01GB)	main feed dog and diff feed dog(01GB)	1
	30214008		送布牙(02BB)	main feed dog(02BB)	1
	30214009		差动牙(02BB)	diff feed dog(02BB)	1
16	S01011		螺钉M5×10	screw	1
17	31012083		缝台板(02BB专用)	sewing block	1
18	S04021		螺钉M4×4	screw	1
19	31012082		前罩缝台盖拼接块(02BB专)	front cover joint	1
20	3011206800		龙头组件	Faucet assembly	1
21	S01011		螺钉M5×10	screw	1
22	30112063		龙头架垫	Head pad	1
23	31012085		龙头架	Leading frame	1
24	S04021		螺钉M4×4	screw	1
25	31012086		前缝台挡板	Front baffle	1
26	S01027		螺钉M3×4.5	screw	2
27	303929		前缝台挡板座	mounting seat	1
28	31012087		缝料挡板	Slit baffle	1
29	S04021		螺钉M4×4	screw	2

注：点划线框代表暂时不用或以改进零件。

## 二十、下剪线部件/Knife holder assemblies



注：点划线框代表暂时不用或以改进零件。

## 二十、下剪线部件/Knife holder assemblies

序号 No	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	3021900700		下切刀组件	slice knife components	1
2	30212156		刀盘底板	the knife dish plate	1
3	30212246		摆杆	swinging rod	1
4	30212116		垫片	washer	1
5	302S30022		螺钉M4x4	screw	2
6	S01091		螺钉M2x2.3	screw	2
7	30213046		UT松线片	UT pine line piece	1
8	30203112		刀架固定套	rest a fixed set	2
9	S14002		内六角沉头螺钉M4x4	screw	2
10	30203113		刀架转动套	head rotating sleeve	2
11	30212225		刀架连杆	head connecting rod	2
12	30212255		上刀架	on the rest	1
13	30212256		下刀架	under the rest	1
14	S01197		开槽圆柱头螺钉M2x6	screw	2
15	S01198		开槽圆柱头螺钉M2x10	screw	1
16	30219009		定刀	stationary knife	1
17	S01196		开槽圆柱头螺钉M3x3	screw	2
18	30219008		动刀	dynamic knife	1
19	30212328		定刀固定块	stationary knife fixed block	1
20	30212327		压板（二）	bracket	1
21	S01199		开槽圆柱头螺钉M2x3	screw	1
22	S02165		开槽沉头螺钉M2x3	screw	2
23	30212329		垫板	plat	1
24	30212326		压板（一）	bracket	1
25	30212324		垫块（一）	block	1
26	30212325		垫块（二）	block	1
27	302S12002		外六角螺钉M4x4	screw	2
28	302S20015		螺钉M4x2.5	screw	1
29	30227124		复位弹簧	reset spring	1
30	S01195		开槽圆柱头螺钉M4x3	screw	3
31	30212257		限位板	the limit board	1
32	30212245		上刀架挡板	rest on the baffle	1
33	L02001		螺栓M4X8	screw	1
34	302S10011		刀盘定位螺钉	screw	1
35	301S11024		滑块导座螺钉	screw	2
36	30212161		支撑板	support plate	1
37	30212240		弹簧片	leaf spring	1
38	S01091		螺钉M2×2.3	screw	2
39	208S11007		螺钉	screw	1
40	20613008		过线	thread guide	1
41	207S11007		螺钉M4×7.5	screw	2
42	302S10011		刀盘定位螺钉	screw	1
43	301S11024		滑块导座螺钉	screw	1
44	31022016		减震垫	cushioning	1
45	L02001		螺栓M4X8	screw	1
46	206S20004		螺钉	screw	1

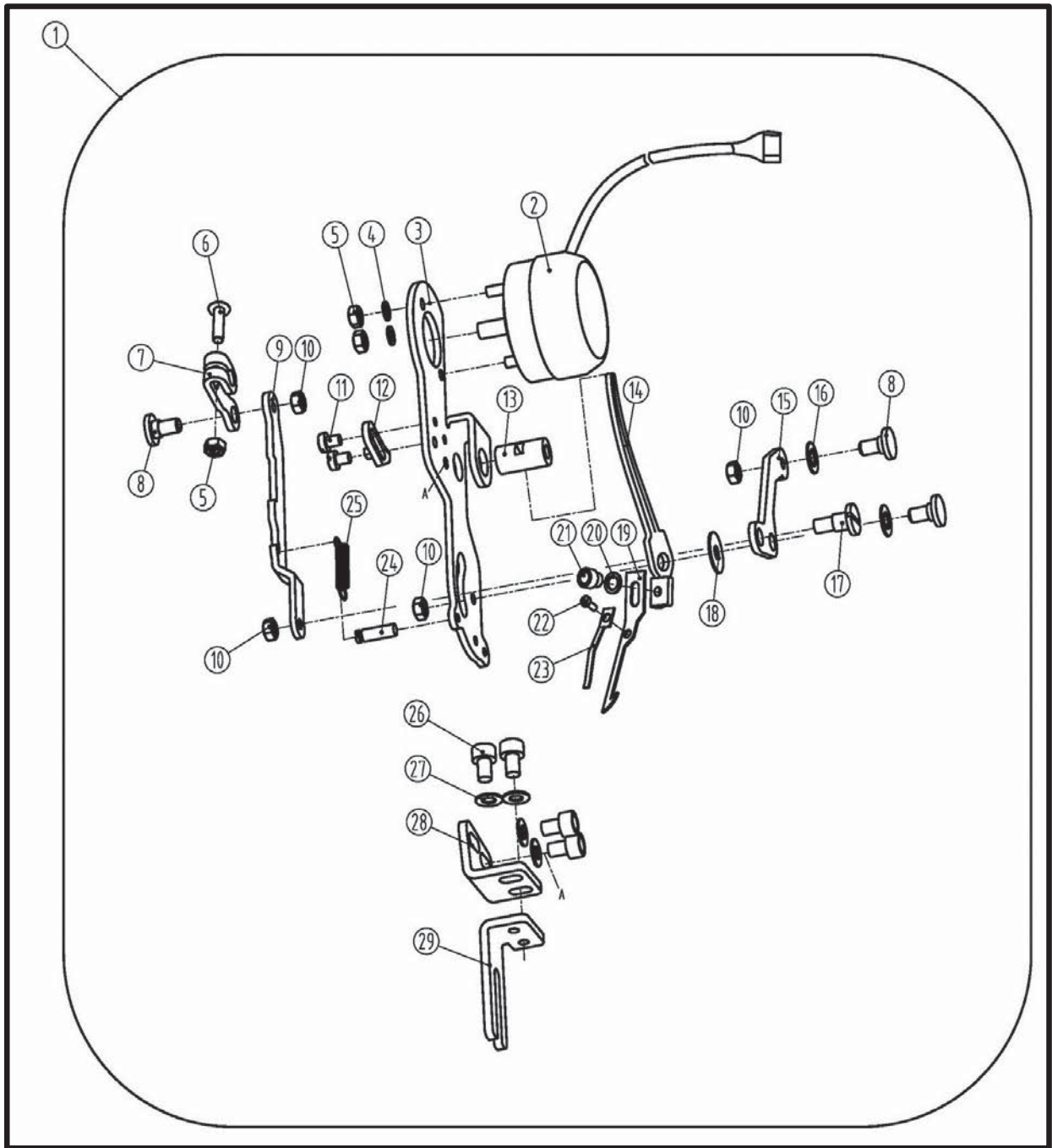
注：点划线框代表暂时不用或以改进零件。

## 二十一、上剪线部件/Knife Holder Assemblies

序号 No	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	3101900100		上切刀组件	knife holder assembly	1
2	31030005		电磁铁组件	solenoid assembly	1
3	W02025		弹性垫圈	washer	2
4	N01013		螺母	nut	2
5	30112118		刀座安装底板	install plat	1
6	30112251		刀座锁紧板	plat	1
7	N01013		螺母	nut	1
8	S05114		螺钉	screw	1
9	30127039		弹簧	spring	1
10	301S30036		螺钉	screw	1
11	301S30037		螺钉	screw	1
12	30112120		刀架滑板	plat	1
13	301S20021		螺钉	screw	2
14	30112121		刀架刀座连接垫片	washer	2
15	30112122		限位板	plat	1
16	S01087		螺钉M3.5X4	screw	2
17	30112123		上切刀动刀压片一	presser plat	1
18	30112124		上切刀动刀压片二	presser plat	1
19	W01005		垫片	washer	1
20	301S30038		螺钉	screw	1
21	301S30039		螺钉	screw	1
22	301S16014		上切刀动刀调节螺母	nut	1
23	301S20022		螺钉	screw	1
24	30119008		上切刀动刀	plat	1
25	30119009		上切刀定刀	thread wiper	1
26	S01088		开槽圆柱头螺钉M2X3.5	screw	4
27	30112125		刀盘安装连接板	install plat	1
28	S01089		螺钉M4X5.5	screw	2
29	31012014		安装板	install plat	1
30	W01006		垫片	washer	2
31	S05304		开槽平端紧定螺钉SM1/8"x4	screw	2
32	301S30041		螺钉	screw	2
33	W01006		垫片	washer	2
34	S05304		螺钉	screw	2

注：点划线框代表暂时不用或以改进零件。

## 二十二、拨线器部件/Top wiper assemblies



注：点划线框代表暂时不用或以改进零件。

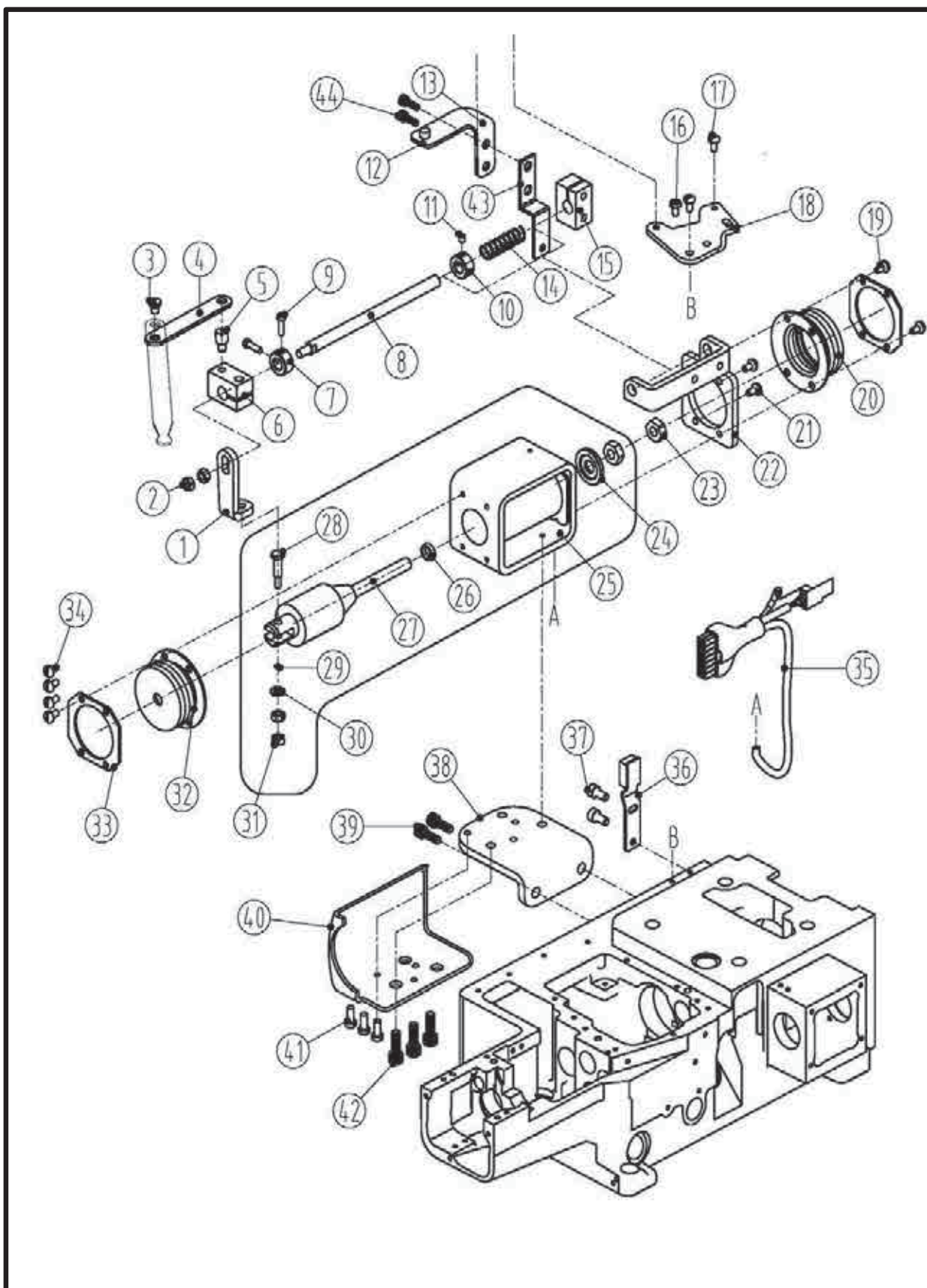
## 二十二、拨线器部件/Top wiper assemblies

序号 No	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	3101900200		拨线器组件	cable assembly	1
2	31030005		电磁铁组件	electromagnet assembly	1
3	30109088		安装板	mounting plate	1
4	42428008		弹簧垫圈	spring washer	2
5	N01013		螺母M3	nut	3
6	S05032		内六角平圆头螺钉M3x12	screw	1
7	30104070		曲柄	crank	1
8	301S20055		拨线器转动曲柄轴位螺钉	screw	3
9	30105066		连杆	connecting rod	1
10	N01006		螺母M4	nut	4
11	417S15007		螺钉	screw	2
12	30109088		挡块	block	1
13	30126034		转动销	rotating pin	1
14	30102156		曲柄	crank	1
15	30104076		曲柄	crank	1
16	W01048		垫片	washer	2
17	301S20056		拨线器连杆轴位螺钉	screw	1
18	W01049		垫片	washer	1
19	30112203		勾线片	cancel the piece	1
20	W01050		垫圈3	washer	1
21	S05047		螺钉M3x4	screw	1
22	S01097		螺钉M2x2	screw	1
23	30112204		弹簧片	leaf spring	1
24	301S01005		螺钉	screw	1
25	30127061		拨线器复位簧	spring	1
26	421S13005		螺钉	screw	4
27	W01051		垫圈4	washer	4
28	30112261		固定板	fixed plate	1
29	31012049		安装板	fixed plate	1

注：点划线框代表暂时不用或以改进零件。



### 二十三、剪线电磁铁部件/Solenoid assemblies



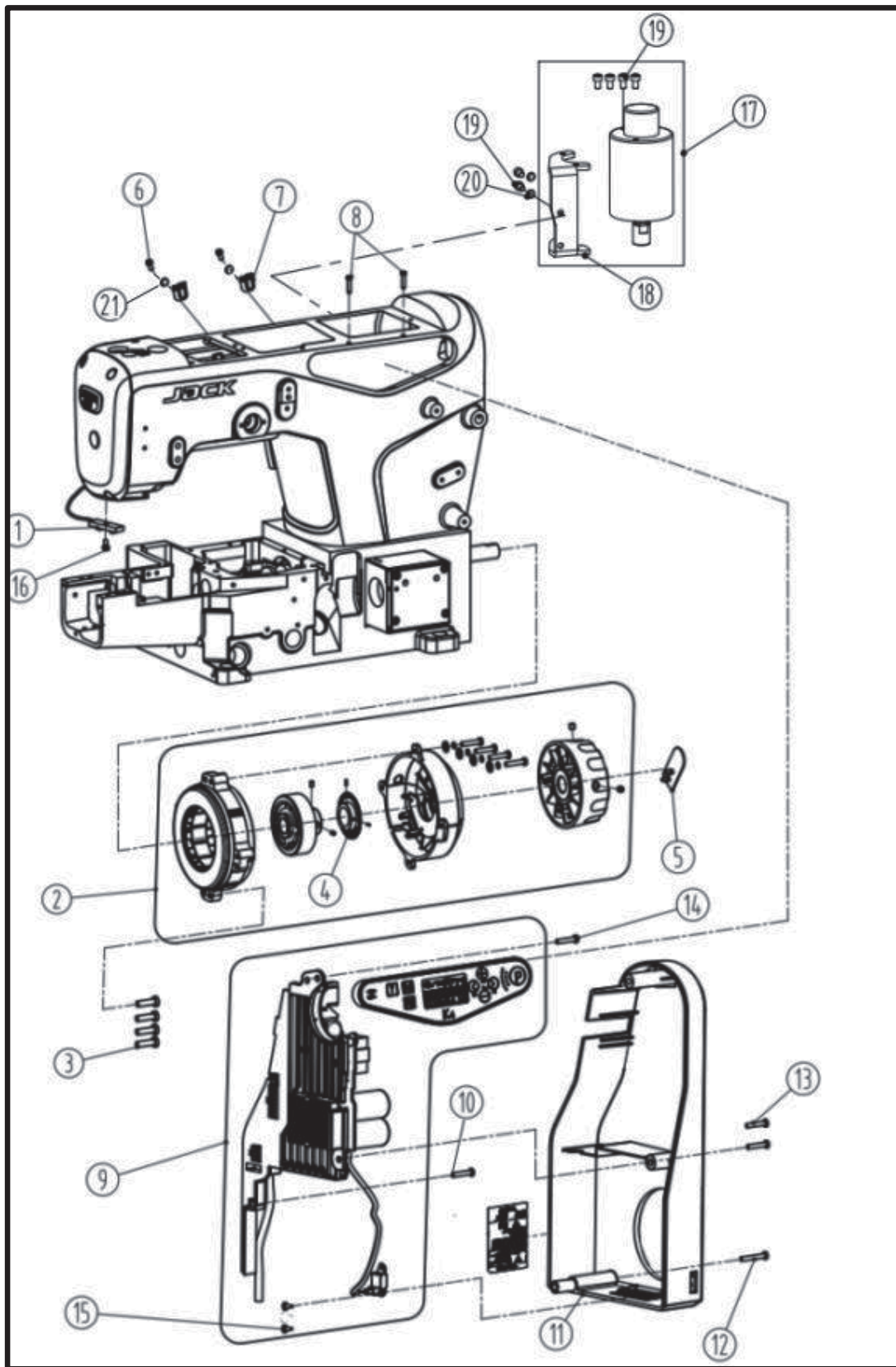
注：点划线框代表暂时不用或以改进零件。

### 二十三、剪线电磁铁部件/Solenoid assemblies

序号 No	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	30212183		连接板	bed pin	1
2	N01012		螺母M6	pin	2
3	206S200004		螺钉	screw	1
4	30212190		连杆	bed pin	1
5	301S20030		螺钉	screw	1
6	30104066		曲柄块	fixed block	1
7	30108004		挡圈	plug	1
8	30102111		导向轴	washer	1
9	301S11023		螺钉	screw	2
10	30108006		挡圈	retaining ring	1
11	201S14002		螺钉	screw	1
12	S05068		螺钉	screw	1
13	131512002		推板组件	dead plate	1
14	30127058		弹簧	cscrew	1
15	30104066		曲柄块	sticker	1
16	207S11007		螺钉M4X7.5	screw	2
17	207S11007		螺钉M4X7.5	screw	1
18	131412006		松线曲柄	the reversing lever	1
19	S04019		螺钉M4×12	screw	1
20	30122108		防尘罩	dust cover	1
21	207S11007		螺钉M4X7.5	screw	2
22	30212184		支架	stents	1
23	302S16010		螺母M8	nut	2
24	13822010		电磁铁下垫片	gasket	1
25	31030007		剪线电磁铁框	electromagnet box shear line	1
26	11322008		减震垫	cushioning	1
27	30130046		电磁铁芯	electromagnetic iron core	1
28	114S20005		螺钉	screw	1
29	W02002		弹性垫片	gasket	1
30	W01006		垫片	gasket	1
31	114S16008		螺母	nut	2
32	30122105		防尘罩	dust cover	1
33	30112185		防尘压板	dust depressor	1
34	S04010		螺钉M4X5.5	screw	4
35	3103000700		剪线电磁铁组件	connect the wire	1
36	31030013		安全开关	safety switch	1
37	S04010		螺钉M4X5.5	screw	2
38	30212182		下安装板	dead plate	1
39	305S13004		螺钉	screw	2
40	31011010		电磁铁罩壳	cover	1
41	207S11007		螺钉M4X7.5	screw	3
42	S05003		螺钉M5X12	screw	2
43	31012090		感应支架	stents	1
44	S05068		螺钉	screw	2
45	S01004		螺钉M4X7.8	screw	2
46	30122108		防尘罩	dust cover	1

注：点划线框代表暂时不用或以改进零件。

## 二十四、电控部件/Electronic control assemblies



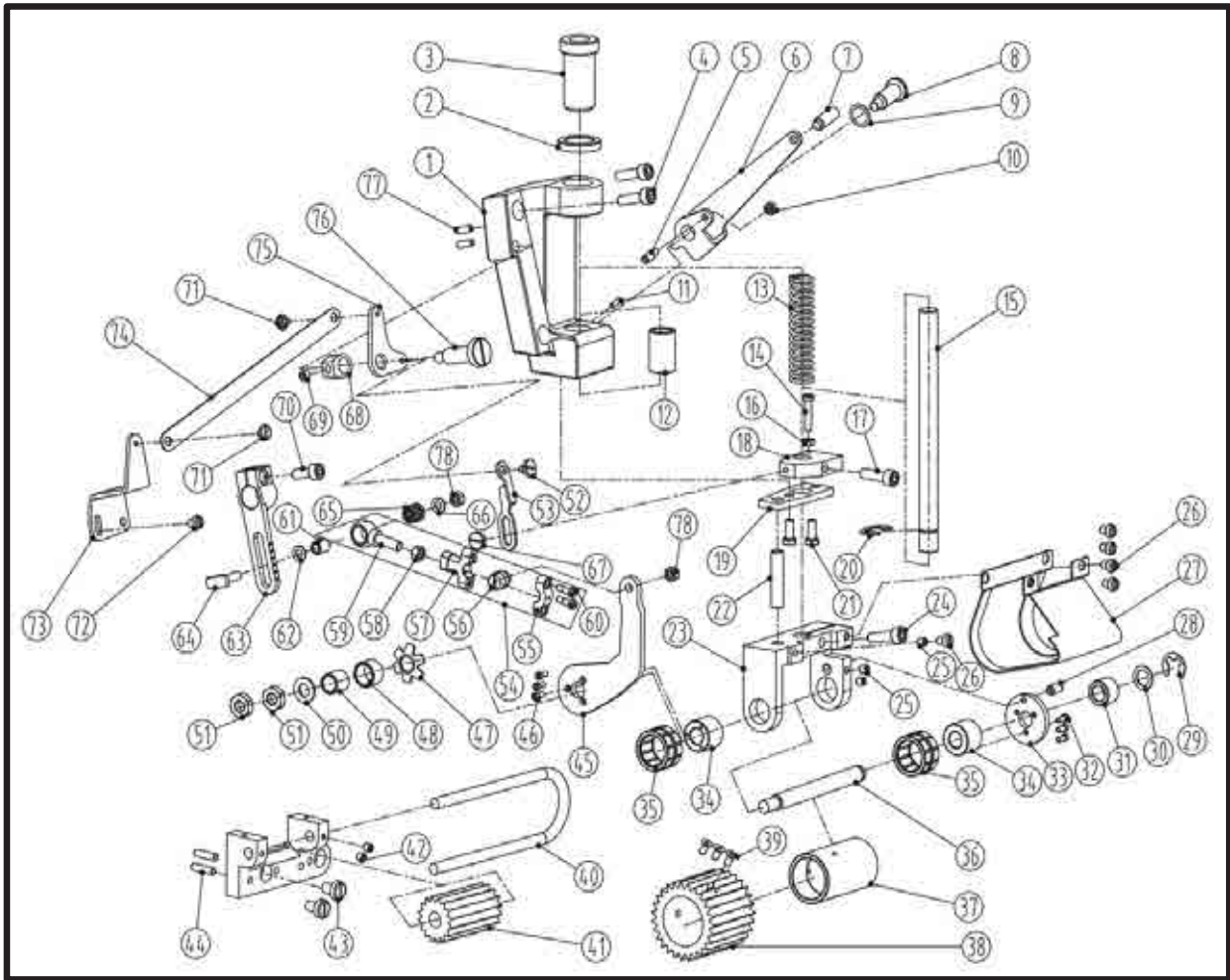
注：点划线框代表暂时不用或以改进零件。

## 二十四、电控部件/Electronic control assemblies

序号 No	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	3103001000		LED灯	LED light	1
2	3103300100		绷缝光电伺服电机	electrical machine	1
3	S05068		螺钉M5x20	screw	4
4	95300018		光栅组件	plug	1
5	21111018		塑料 logo	logo	1
6	207S11007		螺钉M4x7.5	screw	2
7	20711210		线夹	clip	2
8	310S17001		螺钉	screw	2
9	3103000500		电控组件	electrically controlled	1
10	S05068		螺钉M5x20	screw	1
11	13101100100		电控罩壳	electrically controlled housing	1
12	302S13001		螺钉M5x35	screw	1
13	S05004		螺钉M5x14	screw	2
14	S05003		螺钉M5x10	screw	1
15	S16002		自攻螺钉 ST3.5×8	screw	2
16	S05190		螺钉M3×6	screw	1
17	3103001100		抬压脚电磁铁组件	electromagnet assembly	1
18	30112241		支架	stents	1
19	413S13005		螺钉	screw	6
20	W02004		弹性垫片	washer	2
21	W01001		垫片	washer	2

注：点划线框代表暂时不用或以改进零件。

## 二十五、后拖轮部件/After cam assemblies



注：点划线框代表暂时不用或以改进零件。

## 二十五、后拖轮部件/After cam assemblies

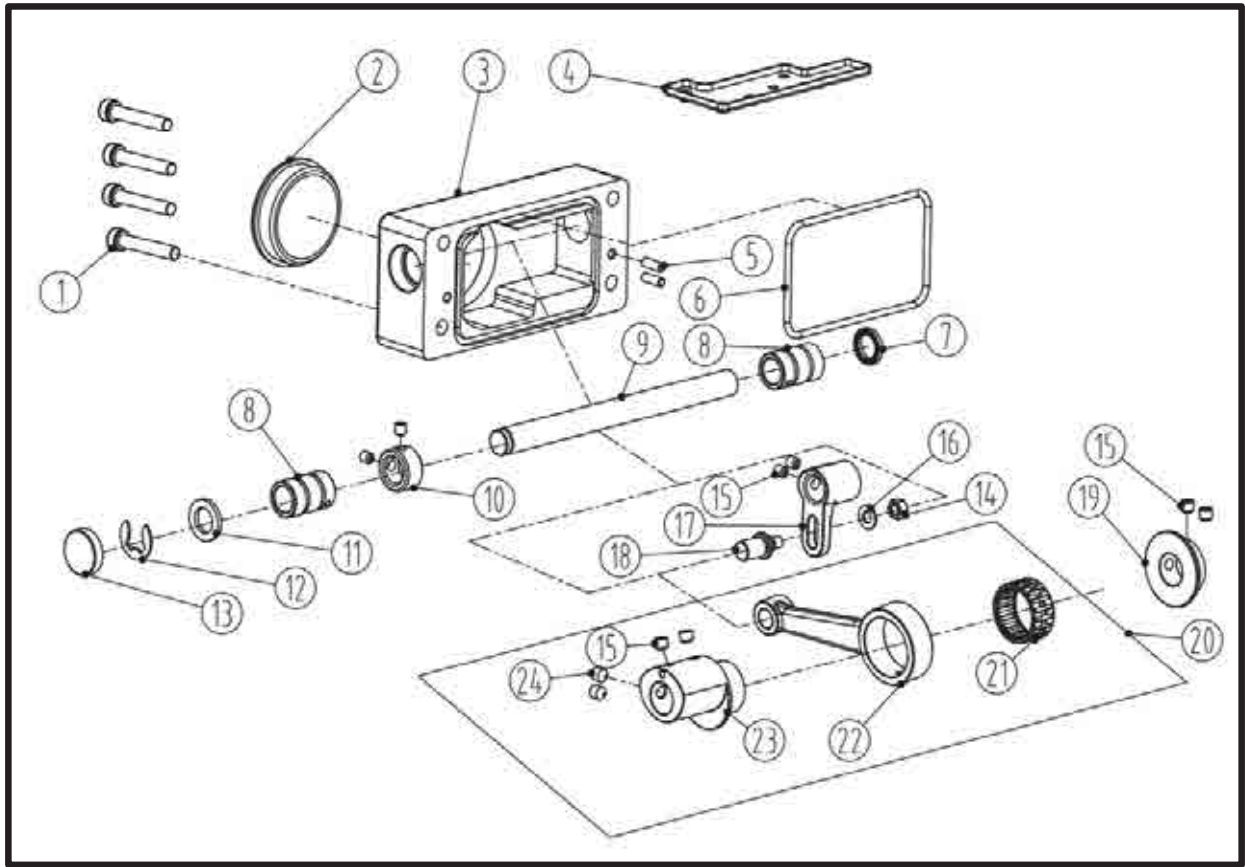
序号 No	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	31175		压脚架	finger screw	1
2	305S16006		螺母M20	nut	1
3	305S30006		调节螺钉	screw	1
4	S05031		螺钉M6×20	screw	2
5	305S11014		螺钉	screw	1
6	3051205100		调节板	plate	1
7	30226050		曲柄销钉	pin	1
8	305S20013		螺钉	screw	1
9	30528012		波形垫片	washer	1
10	N01001		螺母	nut	1
11	30526023		销	pin	1
12	30503031		铜套	sleeve	1
13	30527011		弹簧	spring	1
14	S01018		螺钉M4X20	screw	1
15	30502022		轴	shaft	1
16	N01001		螺母M4	nut	1
17	S05031		螺钉M6×20	screw	1
18	30212102		压板	plate	1
19	30212104		调节板	plate	1
20	H05010		挡圈12	ring	1
21	L02012		螺栓M5×12	screw	2
22	30526020		销	pin	1
23	30201100		压轮架	roller frame	1
24	S05031		螺钉M6×20	screw	1
25	S09008		螺钉M5×5	screw	3
26	S01065		螺钉M5×6	screw	4
27	30512054		挡板	plate	1
28	305S11012		螺钉	screw	1
29	H05011		挡圈9	ring	1
30	W01026		垫片	washer	1
31	31003010		轴套(左)	sleeve	1
32	305S11002		螺钉	screw	3
33	30512057		压板	plate	1
34	30503063		轴承套	bushing	2
35	B07048		滚针轴承K26×20×16	needle bearing	2
36	30202101		轴	shaft	1
37	30203103		齿轮套	sleeve	1
38	30225103		齿轮	gear wheel	1
39	207S13007		螺钉	screw	3
40	30202100		U型轴	U shaft	1
41	30225101		齿轮	gear wheel	1
42	S10027		螺钉M5X5	screw	2
43	S01060		螺钉M6×10	screw	2
44	30226004		销	pin	2
45	30512055		冲压件铁臂	stamping Tiebi	1
46	305S11002		螺钉	screw	3
47	30512056		蝶形卡簧	butterfly spring	1

注：点划线框代表暂时不用或以改进零件。

48	31003011		轴套(右)	sleeve	1
49	30503036		铁套	sleeve	1
50	W01010		平垫圈8	washer	1
51	N01008		螺母M8	nut	2
52	305S20012		螺钉	screw	1
53	30212103		连接板	plate	1
54	3050501700		连杆组件	connecting rod assembly	1
55	30505018		连杆	connecting rod	1
56	305S30007		球曲柄螺钉	screw	1
57	30505019		连杆	connecting rod	1
58	305S16008		螺母M6	nut	1
59	30505020		连杆	connecting rod	1
60	305S20014		螺钉	screw	1
61	30503034		铁套	sleeve	1
62	W01004		平垫圈5	washer	1
63	30504015		曲柄	link	1
64	305S30009		螺钉	screw	1
65	B07011		滚针轴承K8×11×10	needle bearing	1
66	W01004		平垫圈5	washer	1
67	N01004		螺母M5	nut	1
68	30208001		挡块	rod	1
69	S10029		螺钉M6×0.75×5	screw	1
70	S05037		螺钉M6×15	screw	1
71	302S20014		螺钉	screw	2
72	S01065		螺钉M5×6	screw	1
73	31012114		后拖轮驱动板	plate	1
74	31012115		拉板	plate	1
75	31012116		后拖轮拉板	plate	1
76	310S20015		轴位螺钉M8	screw	1
77	30226004		销子	pin	2

注：点划线框代表暂时不用或以改进零件。

## 二十六、后拖轮架部件/After fight cam assemblies



注：点划线框代表暂时不用或以改进零件。

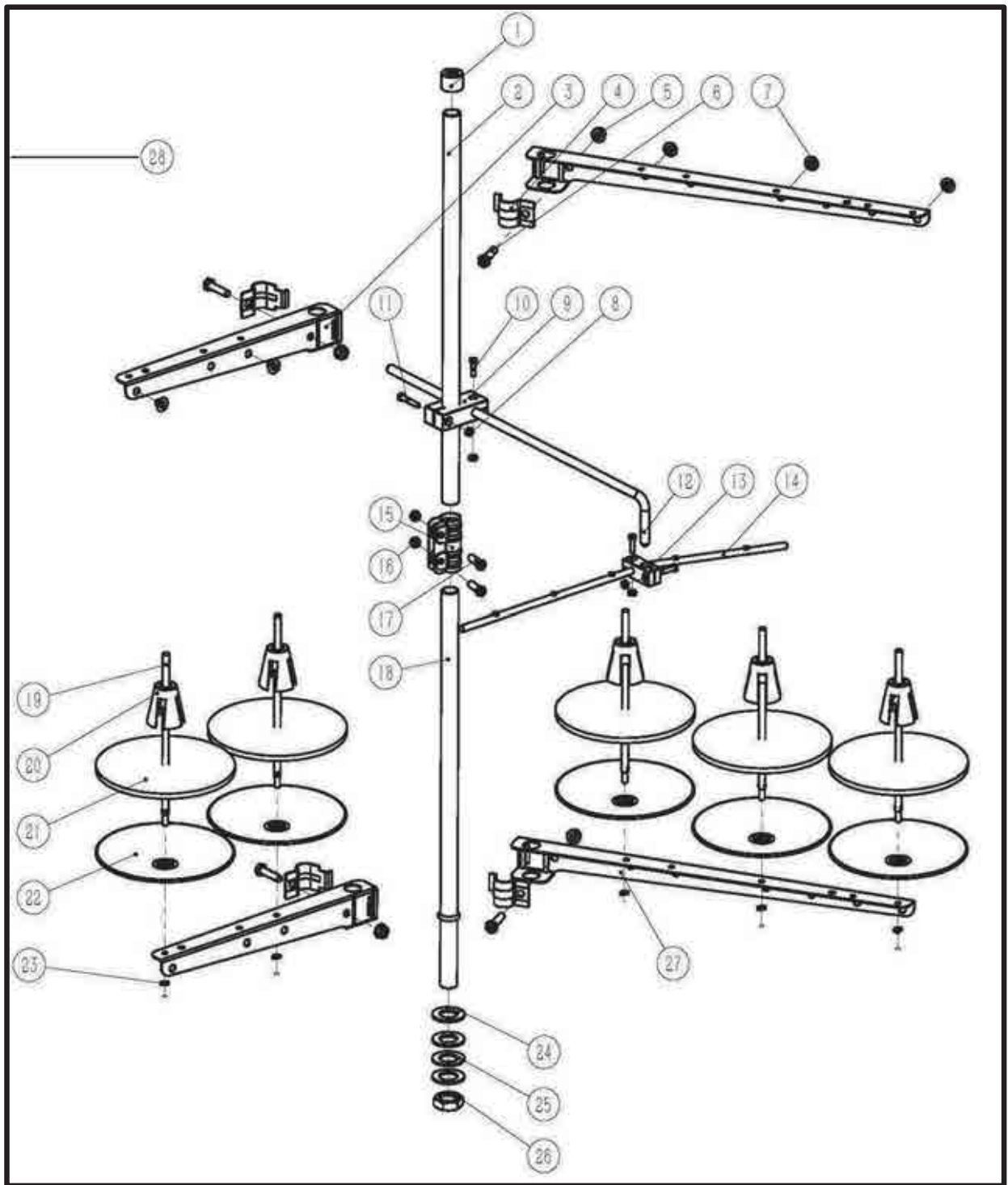


## 二十六、后拖轮架部件/After fight cam assemblies

序号 No	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	207S13004		螺钉M6×35	screw	4
2	30522069		油封	plug	1
3	301175		后盖(喷漆)	rear cover	1
4	30212023		接油盘	oil guard	1
5	P03002		弹性圆柱销	pin	2
6	30522070		后盖密封圈	o ring	1
7	20122021		油封	plug	1
8	20103047		送布轴右套(粉末)	sleeve	2
9	30502045		拖轮轴	shaft	1
10	30508001		挡圈	ring	1
11	30128015		垫圈	washer	1
12	H03006		挡圈10	ring	1
13	30522019		油封	plug	1
14	N01004		螺母M5	nut	1
15	S10029		螺钉M6×0.75×5	screw	6
16	W01004		垫圈	washer	1
17	30504035		曲柄	crank	1
18	30126006		连杆销	pin	1
19	30503060		轴套	sleeve	1
20	3050502600		连杆组件	connecting rod assembly	1
21	30224001		滚针轴承28×24×13	needle bearing	1
22	30505025		连杆	connecting rod	1
23	30503061		连杆轴套	sleeve	1
24	S12003		螺钉M6×0.75×7	screw	2

注：点划线框代表暂时不用或以改进零件。

## 二十七、线架部件/Thread Apool Assemblies



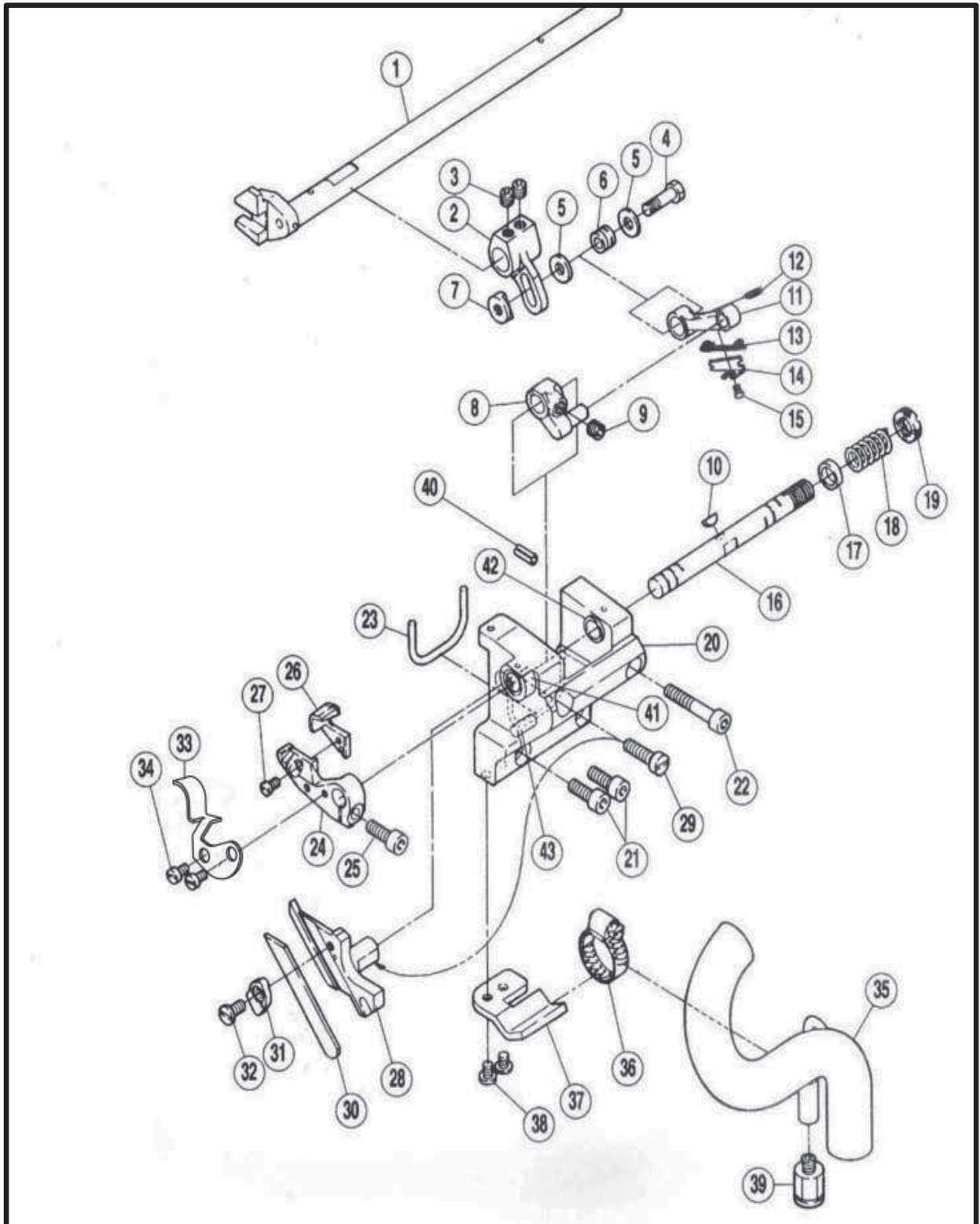
注：点划线框代表暂时不用或以改进零件。

## 二十七、线架部件/Thread Apool Assemblies

序号 Ref. No	公司件号 Part No	参考件号 Ref. Part. No	名称	Description	数量 Number
1	20131019		棒帽	Rod cap	1
2	21131008		上管	Upper thread column	1
3	21131009		导线架（短）	Thread spool tray bracket	1
4	20131011		导线环	Thread guide hook	1
5	201S16006		导线环螺母	Thread guide hook nut	4
6	201S12008		导线环螺钉	Screw	4
7	20131018		过线环	Thread guide hook	5
8	201S16004		螺母	Nut	9
9	21131010		导线棒固定块	Clamp plate	1
10	20131021		棒架螺钉	Screw	3
11	20131022		棒架螺钉	Screw	1
12	20131011		导线棒	Thread guide bar	1
13	21131013		导线棒固定块	Clamp plate	1
14	20131036		过线棒	Thread guide	2
15	21131014		套	Bushing	1
16	N01030		套螺母	Nut	2
17	S04050		螺钉 M5×19	screw	2
18	21131018		下管	Lower thread cloumn	1
19	20131006		线托棒	Spool pin	5
20	21131015		线圈定位套	Spool Cushion	5
21	20131010		线盘垫	Spool tray cushing	5
22	21131018		下管	Upper thread column	1
23	20128018		线盘垫圈	Washer	5
24	20122049		橡胶垫圈	Plate dog link washer	2
25	20128025		下管垫圈	Lower Washer	2
26	201S16005		下管固定螺母	Nut	1
27	21131012		导线架（长）	screw	2
28	2113100500		C4-2340线架组件(五线)	thread stand component	1

注：点划线框代表暂时不用或以改进零件。

## 二十八、35AC切刀专用件/35ACFT device



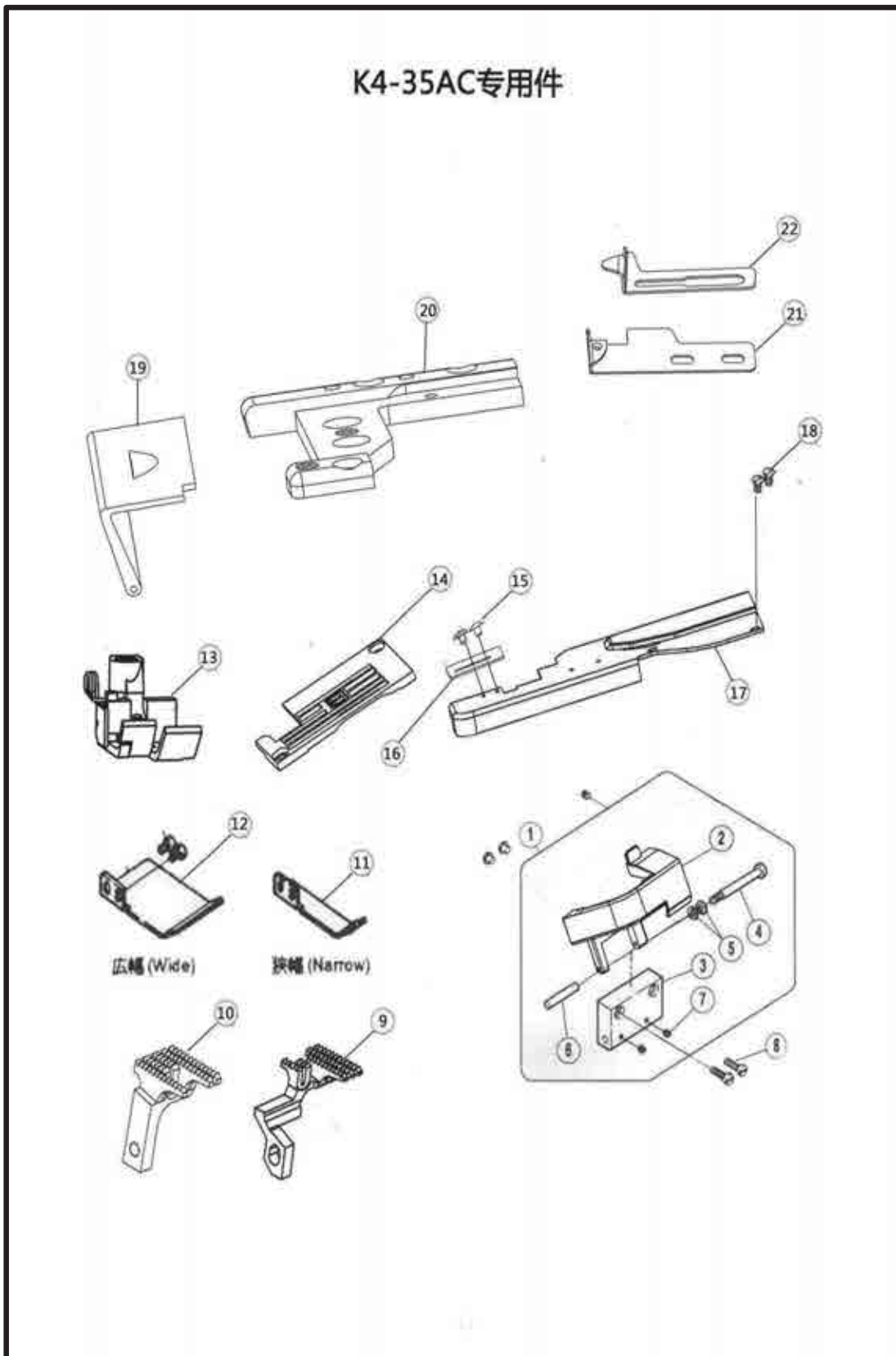
注：点划线框代表暂时不用或以改进零件。

二十八、35AC切刀专用件/35ACFT device

序号 No.	件号 Parts No.	参考件号 Ref.Part.No.	名称	Description	数量 Number
1	30202043		曲柄轴	shaft	1
2	30204011	255552	曲柄	crank	1
3	S10013		螺钉 M6×6	screw	2
4	302S12001	7057	六角螺钉	screw	1
5	30228008		垫圈	washer	1
6	30203027	179160-05	轴衬	bushing	1
7	302S02001	255553	螺母	nut	1
8	30204012	255554	曲柄	crank	1
9	S10013		螺钉 M6×6	screw	1
10	30226016	240008	键	key	1
11	400080	252557A	连杆	link	1
12	30223005	202174	油线	oil wick	1
13	20123021	202175	油线	oil wick	1
14	30201044	255077	油线架	latch	1
15	205S30008		压刀板螺钉	screw	1
16	30202023	255555	自动剪切轴	shaft	1
17	302S01003	230030	垫圈	washer	1
18	30227012	255548	弹簧	spring	1
19	302S01001	255546	螺母	nut	1
20	300704	255549-9P	下刀架座	lower knife holder	1
21	S05004		螺钉 M5×14	screw	2
22	302S13001		螺钉 M5×10	screw	1
23	30222015	255557	油封	oil seal	1
24	30201046	255564-91	上刀架	upper knife stand	1
25	S01011		螺钉 M5×12	screw	1
26	30219001	257574	上刀	upper knife	1
27	201S11035		S084螺钉	screw	1
28	30201047	255560	下刀架	lower knife stand	1
29	S11015		螺钉 M4×16	screw	1
30	20619002	204161A	下刀	lower knife	1
31	30201048	255558-91	下刀压板	lower knife clamp	1
32	101S11008		滑块导轨螺钉	screw	1
33	31001020		吸管宵口	waste chute top	1
34	207S11025		螺钉 M3.5×6.7 (进口)	screw	2
35	3021101000	255567-91	排料管组件	suction pipe	1
36	30211005	608005	携管带	hose band	1
37	30212059	255562	挡板	latch	1
38	S01002		螺钉 M4×6	screw	2
39	302S09001	601115	连接螺钉	screw	1
40	30226004		销 4×16	pin	2
41	30203028		左轴套	sleeve	1
42	30203029		右轴套	sleeve	1
43	30226021		销子	pin	1

注：点划线框代表暂时不用或以改进零件。

二十九、35AC专用件/35ACFT device



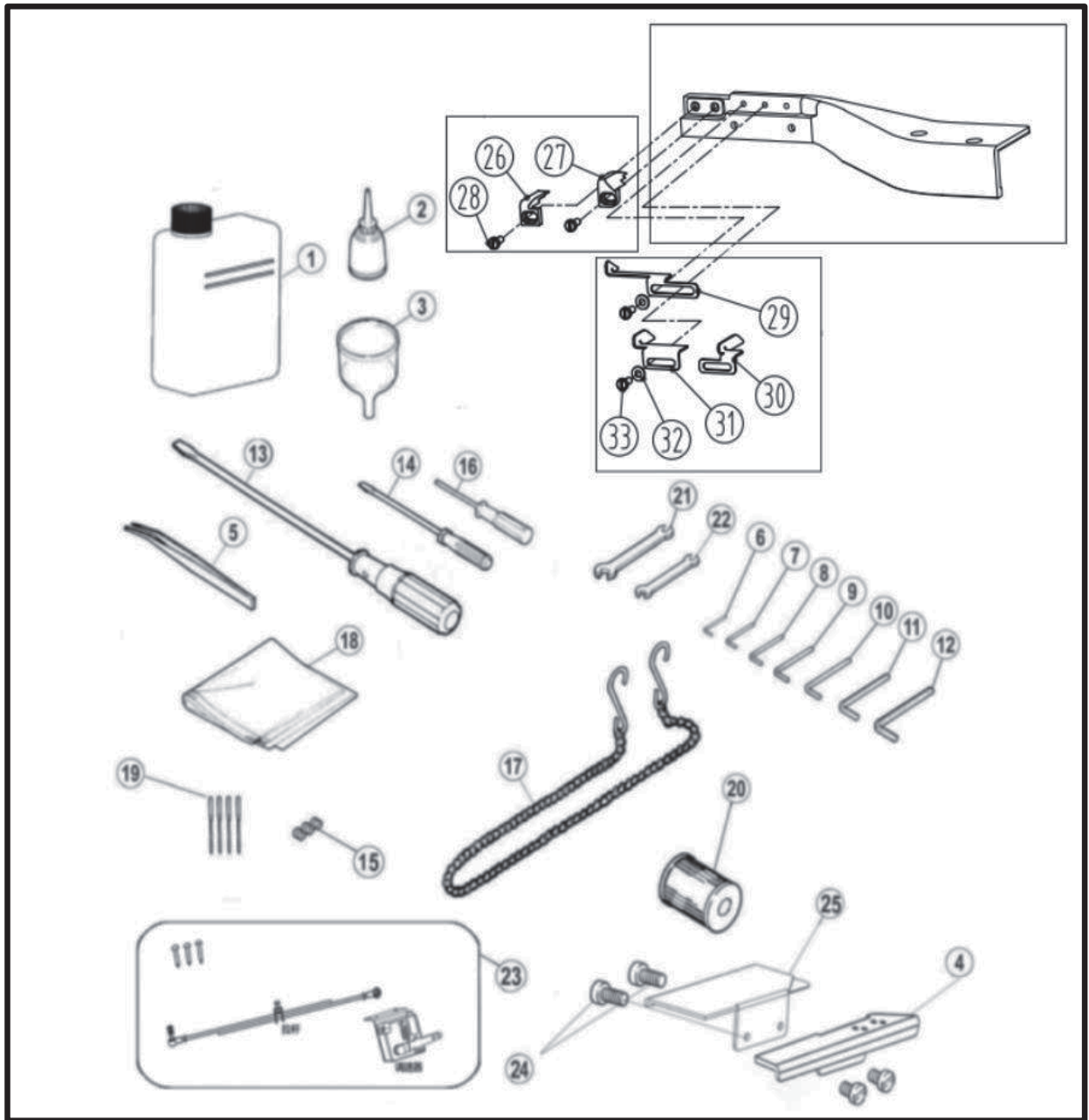
注：点划线框代表暂时不用或以改进零件。

## 二十九、35AC专用件/35ACFT device

序号 No.	件号 Parts No.	参考件号 Ref. Part. No	名称	Description	数量 Number
1	304347		前罩缝台组件 (喷漆)	front cover assy	1
2	31001022		前罩缝台	front cover	1
3	30201016		合销块	hinge	1
4	301S20002		前罩缝台座螺钉	screw	1
5	30128002		弹簧垫片	washer	2
6	31026006		销	pin	1
7	S10005		螺钉M3×3	screw	2
8	207S11016		螺钉M4×16	screw	2
9	30214017		差动牙 (35AC)	diff feed dog	1
10	30214016		送布牙 (35AC)	main feed dog	1
11	30212155		辅助板窄 (35AC)	fabric guide	1
12	30212052		辅助板宽 (35AC)	fabric guide	1
13	30216005		压脚356	presser foot assy	1
	30216008		压脚364	presser foot assy	1
14	31015001		针板356	needle plate	1
	31015002		针板364	needle plate	1
15	31012100		垫布板	spring washer	1
16	310S11002		缝料板螺钉	screw	2
17	304348		缝台盖板 (喷漆)	cover plate	1
18	310S11003		缝台板螺钉	screw	2
19	31012092		左盖板 (35AC)	colth plate	1
20	31004031		针板架 (35AC)	needle plate holder	1
21	30201020		缝料左挡块	hemming guide (right)	1
22	30201019		缝料右挡块	hemming guide (left)	1

注：点划线框代表暂时不用或以改进零件。

三十、附件/Accessories assemblies



注：点划线框代表暂时不用或以改进零件。

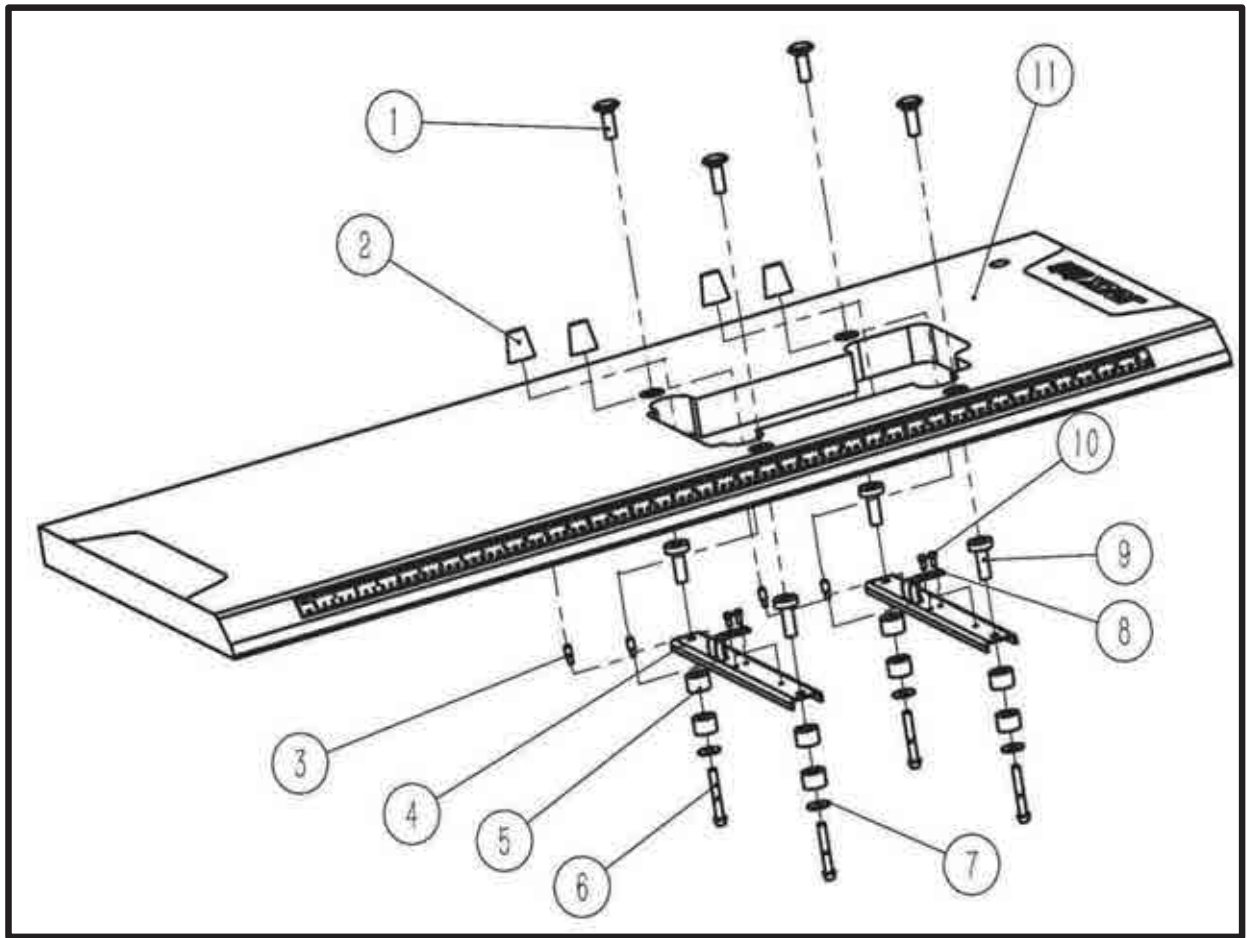


### 三十、附件/Accessories assemblies

序号 Ref. No	公司件号 Part No	参考件号 Ref. Part. No	名称	Description	数量 Number
1	20131037		油壶 (大)	oil container	1
2	20131038		小油壶 (尖嘴)	oiler	1
3	20131039		漏斗	oil funnel	1
4	31012053		缝台板 (右)	machine table(right)	1
5	20131051		镊子	tweezers	1
6	30131007		内六角扳手 (1.5mm)	allen key driver/1.5mm	1
7	20131046		内六角扳手 (2mm)	allen key driver/2mm	1
8	30131010		内六角扳手 (2.5mm)	allen key driver/2.5mm	1
9	30131012		内六角扳手 (3mm)	allen key driver/3mm	1
10	20131047		内六角扳手 (4mm)	allen key driver/4mm	1
11	20131056		内六角扳手 (5mm)	allen key driver/5mm	1
12	30131026		内六角扳手 (6mm)	allen key driver6mm	1
13	20731047		螺丝刀 (大)	screwdriver (large)	1
14	10131004		螺丝刀 (小)	screwdriver (small)	1
15	S10005		螺钉 M3×3	screw	3
16	20131044		内六角扳手 (1.5mm直柄)	allen key driver/1.5mm	1
17	30131018		链条 (非直驱、DI专用)	chain	1
18	10131005		机头罩	dust cover	1
19	30117001		机针	needle	4
20	20136001		滤油器	filter element	1
21	30131005		扳手 (6mm-7mm)	wrench/(7mm-9mm)	1
22	30131006		扳手 (8mm-10mm)	wrench/(8mm-10mm)	1
23	3103000500		直驱控制器配件	dl Special Part	1
24	S01060		螺钉 M6×10	screw	4
25	31012054		缝台板 (左)	machine table(left)	1
26	30201020		缝料左挡块	fabric guide(left)	1
27	30201019		缝料右挡块	fabric guide(right)	1
28	S01009		螺钉M3×7.5	screw	2
29	31012033		缝料左挡板	fabric plate(left)	1
30	31012043		缝料右挡板 II	fabric plate(right)	1
31	31012035		缝料右挡板 I	fabric plate(right)	1
32	W01002		M3垫片 (普通)	bracket assembly	2
33	S01009		螺钉M3×7.5	screw	2

注：点划线框代表暂时不用或以改进零件。

### 三十一、台板部件/Bedplate assemblies



注：点划线框代表暂时不用或以改进零件。

### 三十一、台板部件/Bedplate assemblies

序号 Ref. No	公司件号 Part No	参考件号 Ref. Part. No	名称	Description	数量 Number
1	20131028		油盘螺钉固定头	Oil pan screw fixing head	4
2	30122029		油盘减振垫	Oil pan damping pad	4
3	301S30018		油盘托板螺钉	Oil pan bracket screw	4
4	30112198		油盘托盘	Oil pan tray	2
5	131222003		防振垫橡胶套	Pubber sleeve of anti vibration	8
6	20131027		托盘螺钉	screw	4
7	20131029		大垫圈	Washer	4
8	30112041		链条挡板	Chain baffie	2
9	131038001		防振垫刚套	Anti vibration pad steel sleeve	4
10	S01011		螺钉M5×10	screw	4
11	\		台板	Bedplate	1

注：点划线框代表暂时不用或以改进零件。

工业缝纫机安全使用注意事项:

1. 必须遵守基本措施;
2. 必须经过专业培训, 对缝纫机设备性能、
3. 使用前应检查所有安全装置;
4. 在安装机针、更换机针、压脚、针板、送布牙、弯针、旋梭或修理时, 应立即关闭电源;
5. 离开缝纫机或工作场所时应关闭电源;
6. 使用离合马达时, 要等待马达完全停止后再进行;
7. 缝纫机及附属装置使用的机油, 润滑油等液体流入眼睛或沾到皮肤上应立即清洗;
8. 禁止用手触摸缝纫机通电时的零件或装置;
9. 有关工业用平缝机与包缝机的修理、改造、主要机构的调整由专门技术人员来进行;
10. 一般的维修保养由专人进行;
11. 在电气方面的修理应在电气技术员的监督和指导下进行;
12. 缝纫机使用期间应定期清扫;
13. 为了正常安全运转, 应安装地线, 同时应在不受高频焊接机等强噪声源影响的环境下使用;
14. 电源插头应由专人安装;
15. 工业用平缝机、包缝机在指定用途以外不能使用。

环保要求:

1. 使用过程中产生的废油及其他废弃物请根据当地环保的要求进行合理的处置。
2. 请在使用完后及时关闭电源, 减少电能的消耗。
3. 请在说明书要求的电压及环境下使用, 已延长产品的使用寿命, 减少废弃物的产生。
4. 机器报废后请勿将本机器及其附件作为普通的生活垃圾处理。请遵守本设备及其附件处理的本地法令, 并支持回收行动。

Notes for safe use of industrial sewing machines:

1. Basic measures must be observed.
2. Pass the specialized training and master sewing machine equipment performance.
3. All safety devices should be checked before use.
4. When installing needle, and changing needle, presser foot, plate, feed dog, bent needle, hook or repairing, the power supply should be turned off immediately.
5. Power should be turned off when leaving the sewing machine or workplace.
6. When using the clutch motor, please wait until the motor stops completely.
7. The machine oil and other liquids used in sewing machines and ancillary devices should be cleaned immediately when they are put into eyes or touch skin.
8. Do not touch the parts or devices when the machine is powered by hand.
9. The repair, renovation and adjustment of the main mechanisms of the relevant industrial sewing machines and overseers shall be carried out by specialized technicians.
10. General maintenance is carried out by specially-assigned persons.
11. Electrical repairs should be performed under the supervision and direction of the electrical technician.
12. The machine should be cleaned regularly during operation.
13. In order to operate normally and safely, ground lines should be installed, and they should be used in an environment free from strong noise sources such as high frequency welding machine.
14. Power plug should be installed by specially-assigned person.
15. Industrial lockstitch sewing machine and overlock sewing machine can not be used except the designated use.

Environmental requirements:

公司地址(Address of Company):

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电话(TEL): 0086-0576-88177767 88177782

服务热线: 400-8890100

<http://www.chinabruce.cn>

资料如有更改, 恕不另行通知, 以实物为准。

You will be not informed if the file has been revised. Please set sample as standard.

2019年10月版

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