

## 重要安全事项

此缝纫机在有的国家（设置场所）由於该国的安全规定而被禁止使用。同时，技术服务也同样被禁止。

1. 使用此缝纫机时，必须遵守包括如下项目的基本安全措施。
2. 使用此缝纫机之前，请阅读本使用说明书在内的所有指示文件。同时应将此使用说明书妥善保管，以便能够随时查阅。
3. 此缝纫机应与贵国的有关安全规定一起使用。
4. 使用此缝纫机和缝纫机动作中，所有的安全装置应安装到规定的位置。没有安装规定的安全装置的缝纫机禁止使用。
5. 此缝纫机应由接受过培训的操作人员来操作。
6. 使用缝纫机时。建议戴安全防护眼镜。
7. 发生下列情况时，应立即关掉电源开关，或拔下电源线插头。
  - 7-1 机针、弯针、分离器等穿线和更换旋梭时。
  - 7-2 更换机针、压脚、针板、弯针、分离器、送布牙、护针器、支架、布导向器等时。
  - 7-3 修理时。
  - 7-4 工作场所无人了或离开工作场所时。
  - 7-5 使用离合马达时，请等待马达完全停止之后再行。
8. 缝纫机以及附属装置使用的机油、润滑脂等液体流入眼睛或沾到皮肤上时，或被误饮时，应立即清洗有关部分并去医院治疗。

9. 禁止用手触摸打开了缝纫机开关通电的零件或装置。
10. 有关缝纫机的修理、改造、调整应由受过专门训练的技术人员或专家来进行。
11. 一般的维修保养应由受过训练的人员来进行。
12. 有关缝纫机的电气方面的修理、维修应由有资格的电气技术人员或专家的监督和指导下进行。
13. 修理、保养有关空气、汽缸等压缩空气的零件时，应切断空气压缩机供气源后再进行。

如有残留压缩空气时，应放掉压缩空气。

但，受过相当训练的技术人员或专家进行有关调整或确认动作时除外。
14. 缝纫机的使用期间应定期进行清扫。

15. 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音源影响的环境下使用。
16. 电源插头应用具有电气专门知识的人来安装。电源插头必须连接到接地插座上。

17. 缝纫机指定用途以外不能使用。
18. 对缝纫机的改造、变更应符合安全规格，并采取有效的安全措施。另外，對於有关改造和变更，本公司概不负责。

19. 本使用说明书上采用以下 2 个警告符号。



有损伤操作人员、维修人员的危险。



安全上需要特别加以注意的事项。

## IMPORTANT SAFETY INSTRUCTIONS

Putting sewing systems into operation is prohibited until it has been ascertained that the sewing systems in which these sewing machines will be built into, have conformed with the safety regulations in your country. Technical service for those sewing systems is also prohibited.

1. Observe the basic safety measures, including, but not limited to the following ones, whenever you use the machine.
2. Read all the instructions, including, but not limited to this instruction Manual before you use the machine. In addition, keep this Instruction Manual so that you may read it at anytime when necessary.
3. Use the machine after it has been ascertained that it conforms with safety rules/standards valid in your country.
4. All safety devices must be in position when the machine is ready for work or in operation. The operation without the specified safety devices is not allowed.
5. This machine shall be operated by appropriately-trained operators.
6. For your personal protection, we recommend that you wear safety glasses.
7. For the following, turn off the power switch or disconnect the power plug of the machine from the receptacle.
  - 7-1 For threading needle(s), looper, spreader etc. and replacing bobbin.
  - 7-2 For replacing part(s) of needle, presser foot, throat plate, leeper, spreader, feed dog, needle guard, folder, cloth guide etc.
  - 7-3 For repair work,
  - 7-4 When leaving the working place or when the working place is unattended.
  - 7-5 When using clutch motors without applying brake, it has to be waited until the motor stopped totally.
8. If you should allow oil, grease, etc. used with the machine and devices to come in contact with your eyes or skin or swallow any of such liquid by mistake, immediately wash the contacted areas and consult a medical doctor.

9. Tampering with the live parts and devices, regardless of whether the machine is powered, is prohibited.
10. Repair, remodeling and adjustment works must only be done by appropriately trained technicians or specially skilled personnel. Only spare parts designated by can be used for repairs.
11. General maintenance and inspection works have to be done by appropriately trained personnel
12. Repair and maintenance works of electrical components shall be conducted by qualified electric technicians or under the audit and guidance of specially skilled personnel. Whenever you find a failure of any of electrical components, immediately stop the machine.
13. Before making repair and maintenance works on the machine equipped with pneumatic parts such as an air cylinder, the air compressor has to be detached from the machine and the compressed air supply has to be cut off. Existing residual air pressure after disconnecting the air compressor from the machine has to be expelled. Exceptions to this are only adjustments and performance checks done by appropriately trained technicians or specially skilled personnel.
14. Periodically clean the machine throughout the period of use.

15. Grounding the machine is always necessary for the normal operation of the machine. The machine has to be operated in an environment that is free from strong noise sources such as high-frequency welder.
16. An appropriate power plug has to be attached to the machine by electric technicians. Power plug has to be connected to a grounded receptacle.

17. The machine is only allowed to be used for the purpose intended. Other used are not allowed.
18. Remodel or modify the machine in accordance with the safety rules/standards while taking all the effective safety measures. assumes no responsibility for damage caused by remodeling or modification of the machine.

19. Warning hints are marked with the two shown symbols.





Danger of injury to operator or service staff





Items requiring special attention

## 为了安全地使用缝纫机的注意事项

 <b>危险</b>	<ol style="list-style-type: none"><li>1. 为了防止发生触电事故，请不要在打开电源的状态下，打开电气箱盖及触摸电气箱内的零件。</li></ol>
 <b>注意</b>	<ol style="list-style-type: none"><li>1. 为了防止人身事故的发生，请不要在卸下皮带防护罩、手指防护器等安全装置的状态下运转缝纫机。</li><li>2. 为了防止被卷入机器的人身事故，缝纫机运转中请不要将手指、头发、衣服靠近皮带轮、V形皮带、马达，也不要东西放到机器上面。</li><li>3. 为了防止人身事故的发生，打开电源时以及缝纫机运转中，请不要把手指放到机针的附近。</li><li>4. 为了防止人身事故的发生，缝纫机运转中请不要把手指放到挑线杆外罩内。</li><li>5. 缝纫机操作中，旋梭高速地旋转。为了防止手受到伤害，运转中请绝对不要把手靠近旋梭。</li><li>6. 为了防止人身事故的发生，放倒缝纫机或返回原来位置时，要注意不要夹住手。</li><li>7. 为了防止突然的起动造成人身事故，放倒缝纫机时，或卸皮带罩和V形皮带时，请一定关掉电源。</li><li>8. 使用伺服马达时，缝纫机停止马达无声音。为了防止意外的起动造成人身事故，请注意不要忘记关电源。</li><li>9. 为了防止触电事故，卸下电源地线的状态，请不要运转缝纫机。</li><li>10. 为了防止触电和损坏电气零件，拔电源的插头时，请先关掉机器电源开关。</li></ol>

### FOR SAFE OPERATION

	<ol style="list-style-type: none"><li>1. To avoid electrical shock hazards, neither open the cover of the electrical box for the motor nor touch the components mounted inside the electrical box.</li></ol>
	<ol style="list-style-type: none"><li>1. To avoid personal injury, never operate the machine with any of the belt cover, finger guard or safety devices removed.</li><li>2. To prevent possible personal injuries caused by being caught in the machine, keep your fingers, head and clothes away from the handwheel, V belt and the motor while the machine is operation. In addition, place nothing around them.</li><li>3. To avoid personal injury, never put your hand under the needle when you turn "ON" the power switch or operate the machine.</li><li>4. To avoid personal injury, never put your fingers into the thread take-up cover while the machine is in operation.</li><li>5. The hook rotates at a high speed while the machine is in operation. To prevent possible injury to hands, be sure to keep your hands away from the vicinity of the hook during operation. In addition, be sure to turn OFF the power to the machine when replacing the bobbin.</li><li>6. To avoid possible personal injuries, be careful not to allow your fingers in he machine when tiling/raising the machine head.</li><li>7. To avoid possible accidents because of abrupt start of the machine, turn off the power to the machine when tilting the machine head or removing the belt cover and the V belt.</li><li>8. If your machine is equipped with a servo-motor, the motor does not produce noise while the machine is at rest. To avoid possible accidents due to abrupt start of the machine, be sure to turn OFF the power to the machine.</li><li>9. To avoid electrical shock hazards, never operate the sewing machine with the ground wire for the power supply removed.</li><li>10. To prevent possible accidents because of electric shock or damaged electrical component(s), turn OFF the power switch in prior to the connection/disconnection of the power plug</li></ol>

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## 1. 规格 / SPECIFICATIONS

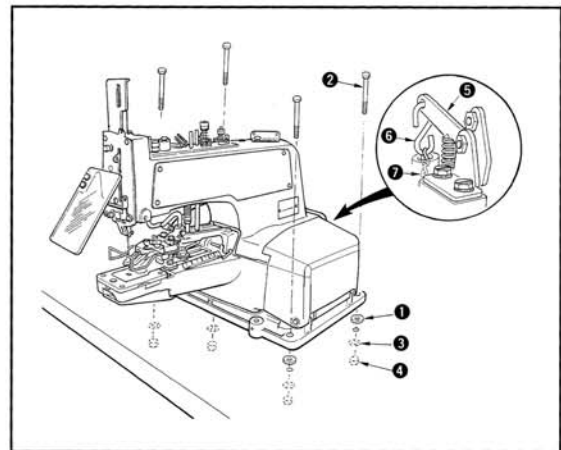
	1377	
缝 速	最高1,500rpm (常用1,300rpm)	
针 数	8,16,32针 (更换凸轮后可为6,12,24针)	
送 布 量	横向送布2.5~6.5mm 竖送布0,2.5~6.5mm	
钮扣尺寸	10~28mm	
机 针	TQx1 #16(#14~#18)	TQx7 #16(#14~#20)
机 油	NO.1 新机油	

	1377	
Sewing speed	Max. 1,500 rpm (Normal 1,300 rpm)	
Number of stitches	8, 16 and 32 stitches (6, 12 and 24 by changing the cam)	
Feed amount	Lateral feed 2.5 to 6.5 mm Longitudinal feed 0, 2.5 to 6.5 mm	
Button size	10 to 28 mm	
Needle	TQx1 #16 (#14 to #18)	TQx7 #16 (#14 to #20)
Lubricating oil	New Defrix Oil No. 1	

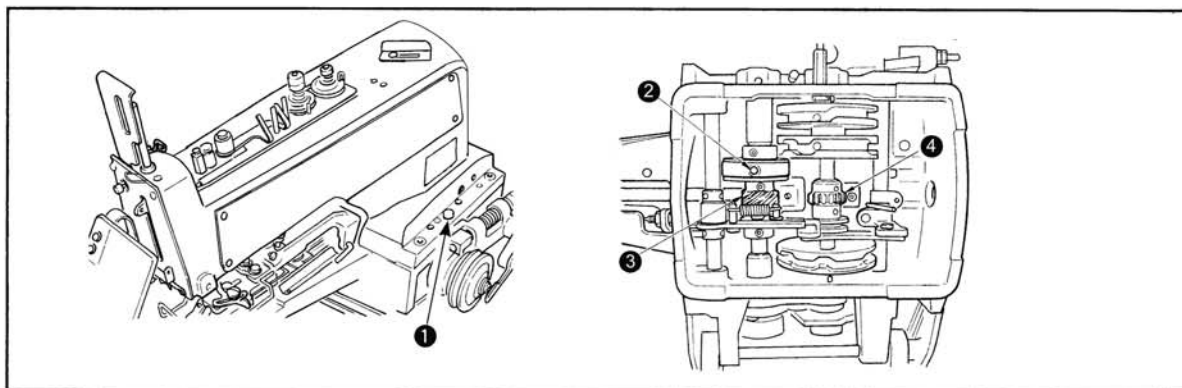
## 2. 缝纫机的安装 / INSTALLATION OF MACHINE HEAD

把防震胶带①放到机台上，然后把机头放到上面，用固定螺丝②、垫片③、螺母④固定好。然后把S型挂钩⑥和铁链⑦安装到起动环⑤上。

Put rubber cushion ① on the table, place the machine head on the rubber cushion and fix it to the table using screws ②, plain washers ③ and nuts ④. Attach "S" chain hook ⑥ and chain ⑦ to stop motion trip lever ⑤.



### 3. 加油 / LUBRICATION



- 1、把No.1 新机油加入到箭头部。(每周1~2次)
  - 2、拧松安装螺钉①，放倒缝纫机，把润滑脂加到螺旋齿轮③和过轮④上。
  - 3、每周检查1次机座安装台内的加油毛毡上面是否吸满油，不够时请加油。同时请往曲轴部②上也加油。
1. Apply New Defrix Oil No. 1 to the components shown by the arrows.  
(Once or twice a week)
  2. Loosen connecting screw ①, tilt the head backward and apply some grease to driving worm gear ④ and gear ③.
  3. Check, approximately once a week, that oil amount is sufficient to reach the top of the oil felt placed inside the bed mounting base. If the amount of oil is insufficient, add an adequate amount of oil. At this time, also apply oil to crank rod ②.

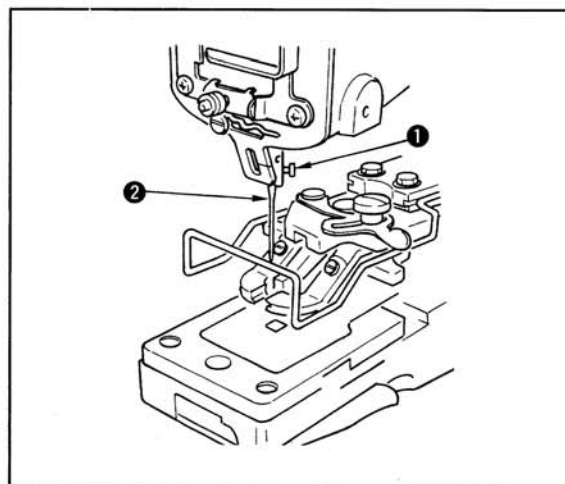
### 4. 机针的安装方法 / ATTACHING THE NEEDLE

★标准机针为使用TQx1 #16。

1. 拧松机针固定螺丝①，手拿机针把机针②长沟转到面前。
2. 把机针②插进针杆孔的深处。
3. 拧紧机针固定螺丝①。

★ Use a standard needle of TQx1 #16.

1. Loosen screw ①.
2. Insert needle ② up into the needle hole in the needle bar until it comes in contact with the deepest end of the needle hole.
3. Tighten screw ① firmly.




### 5. 针杆罩的安装方法 / ATTACHING THE NEEDLE BAR GUARD

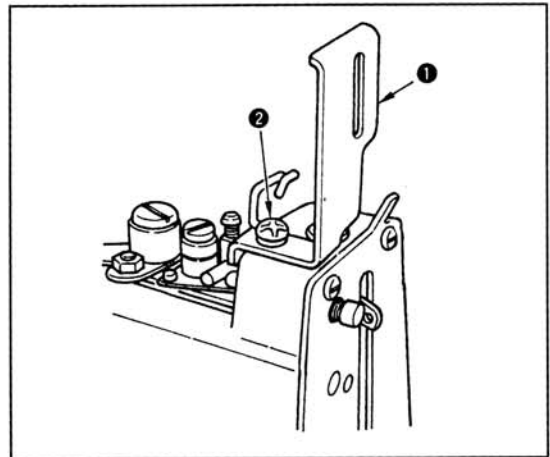
1. 拧松固定螺丝②，并把它卸下。
2. 把针杆罩①安装到第二道线器的下面。
3. 用固定螺丝②固定起来。



如果装挑线电磁阀时，请把针杆罩安装到挑线电磁阀安装台座上。

1. Loosen screw ② and remove the thread guide No. 2.
2. Place needle bar guard ① under the thread guide No. 2.
3. Fix the thread guide No. 2 and needle bar guard ① together using screw ②.

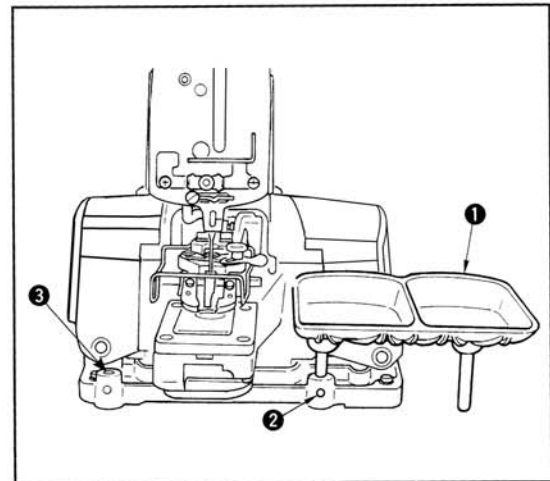
 If your machine has a wiper magnet, attach the needle bar guard onto the wiper magnet base.



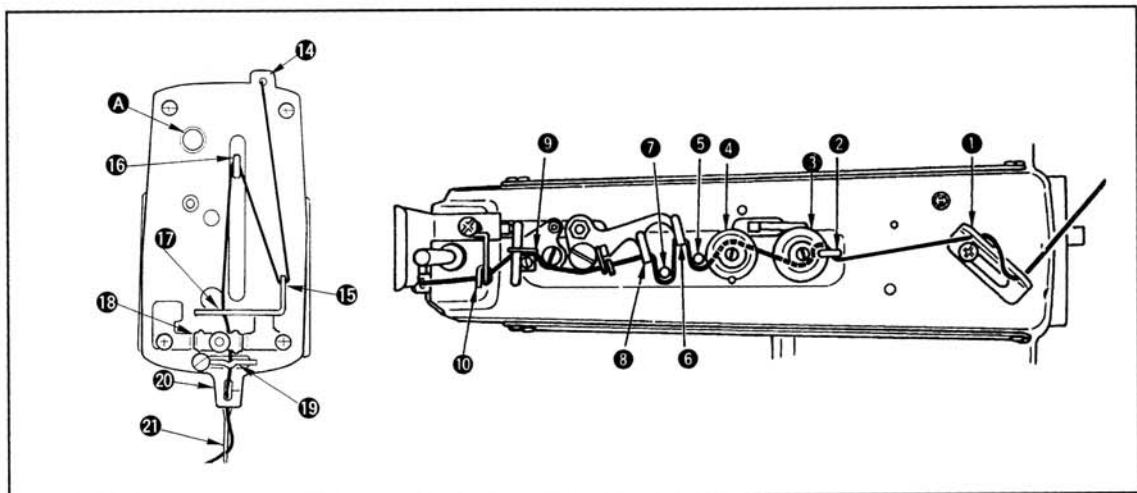
## 6. 钮扣盘的安装方法 / ATTACHING THE BUTTON TRAY ASSEMBLY

把钮扣盘①插进机座前部的右侧的孔上，并把固定螺丝②拧紧固定。如果，右侧抓钮扣不方便的话，请改装到左侧。

Insert the posts of button tray ① in hole on the right of the machine sub-base and tighten each setscrew ②. You may use also the installation hole on the left if the operator wants.



## 7. 上线穿线方法 / THREADING THE MACHINE





如图所示的顺序进行穿线，从针孔的前侧向后侧按松线螺母A，把线拉出约60~70mm左右。

Thread the machine in the order of ❶ to ❷ as illustrated and pass the thread through the needle eye from the front for 60 to 70 mm as you depress nipper releasing knurled thumb nut A.

## 8. 线张力 / THREAD TENSION ADJUSTMENT

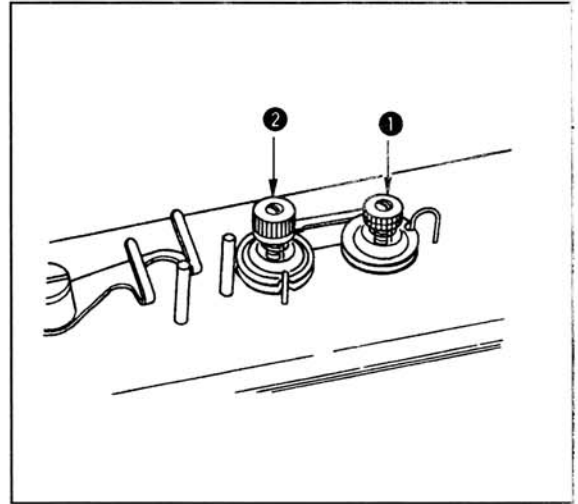
第一线张力螺母❶是调整钉扣强度用的，仅能调详极小的张力。

第二线张力调整螺母❷是调整背面的紧线程度的，其张力比第一线张力螺母❶强，根据使用的机线、布料、钮扣厚度等情况进行调整。

向右转动各线张力螺母之后，线张力变强，向左转动则张力变弱。

Tension post No. 1 ❶ is used to adjust the thread tension to sew on the button and a relatively low tension will be enough. Tension post No. 2 ❷ is used to adjust the thread tension applied to the root of the button sewing stitches.

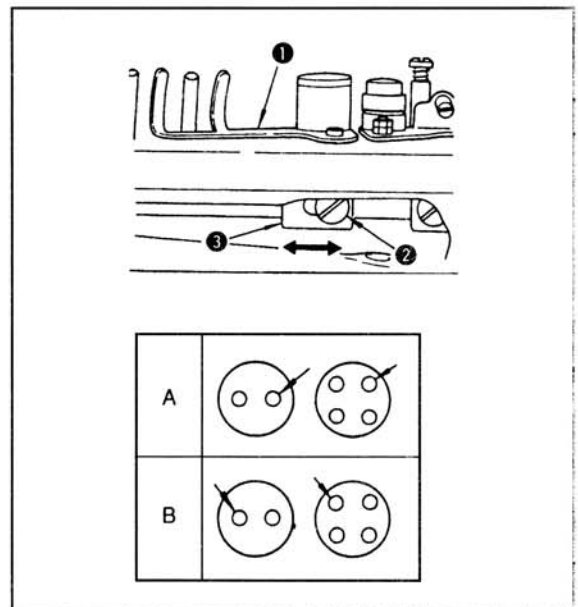
This tension must be determined according to the type of thread, fabric and thickness of the button and must be higher than that of tension post No. 1 ❶. Turn the tension nuts clockwise to increase or counterclockwise to reduce the thread tension.



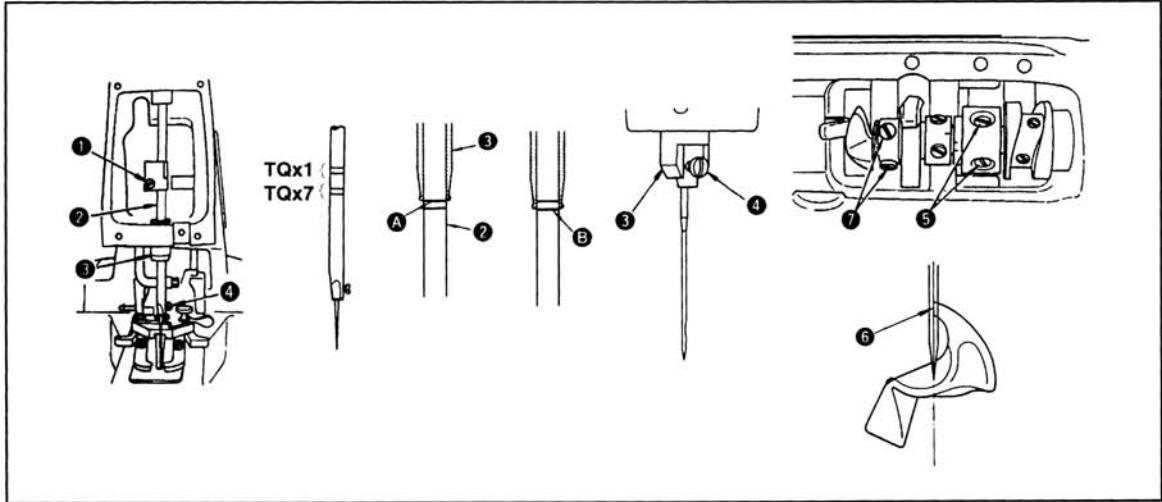
## 9. 线调节杆的调整 / ADJUSTMENT OF THE THREAD PULL-OFF LEVER

调节线调节杆❶时，请把螺丝刀插进左侧面板上的孔中，拧松固定螺丝❷，然后左右移动调节杆的活动滑块❸进行调整。缝制结束，如果线头从A部前头的孔中露出时，请把线调节杆活动滑块❸向左移动，如果线头从B部箭头的孔中露出时，请把滑块向右移动，不让线头露出来。

To adjust the thread pull-off lever ❶, insert a screwdriver through an opening in the machine arm side cover (left), loosen screw ❷ and adjust the position of nipper bar block (rear) ❸ to the left or the right. If the end of thread is drawn from arrow hole A in the button after sewing, change the position of nipper bar block (rear) ❸ to the left. Move the lever to the right when the thread end comes out from arrow hole B.



## 10. 机针和弯针的关系 / NEEDLE-TO-LOOPER RELATION



★机针和弯针按如下方法进行调整。

1. 把踏板踩到底，沿转动方向驱动皮带轮，让针杆落到最下点，然后拧松固定螺丝①。

(决定针杆高度。)

2. TQx1机针时，使用上方的2条刻线，TQx7机针时，使用下方的2条刻线，把其中的上刻线A对准针杆下端块③的下端，然后拧紧固定螺丝①。这时应让机针固定螺丝④进入到避免与针杆下端块③相碰的沟槽里。

(决定弯针的位置。)

3. 拧松固定螺丝⑤，转动皮带驱动轮，把针杆②的2条一组的刻线中的下刻线B对准针杆下端块③的下端

4. 在此状态，把弯针的针尖⑥对准机针的中心，然后拧紧固定螺丝⑤。

5. 拧松固定螺丝⑦，把弯针间隙调整为0.01~0.1mm，再拧紧螺丝⑦。

★ Adjust the needle-to-looper relation as follows :

1. Depress the pedal fully forward, turn the needle driving pulley in the normal sewing direction to bring down the needle bar to the lowest point of its stroke and loosen screw ① .

(Adjusting the needle bar height)

2. Adjust the height of the needle bar using top two lines engraved on the needle bar for the TQx1 needle and using the bottom two lines for the TQx7 needle. Align the upper line A with the bottom end face of needle bar bushing (lower) ③ and tighten screw ① in the way that needle clamp screw ④ rests in the slot of the needle bar bushing (lower) ③ .

(Looper position)

3. Loosen screws ⑤ and turn by hand the needle driving pulley until lower line B of two lines aligns with the bottom end face of needle bar bushing (lower) ③ .

4. By keeping the machine in this state, align looper blade ⑥ with the center of the needle and tighten screws ⑤ .

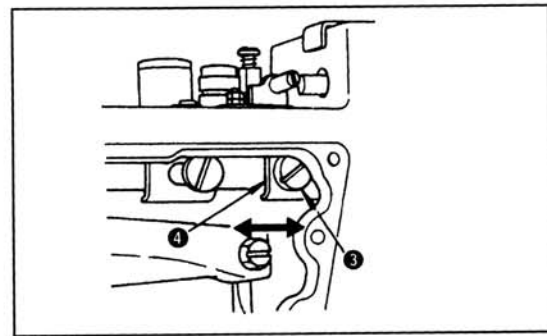
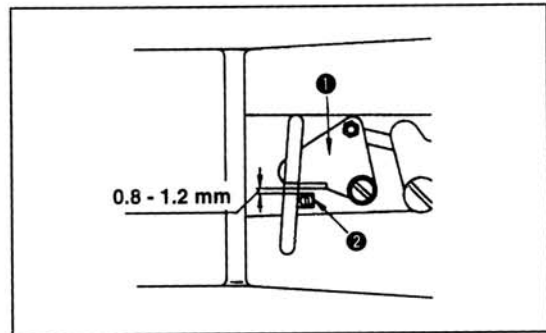
5. Loosen screws ⑦ and provide a 0.01 to 0.1 mm clearance between the looper and the needle. Tighten screws ⑦ .

## 11. 拔针器的调整 / ADJUSTMENT OF THE NIPPER

运转时，把拔针器的方块②和拔针器①的间隙调整为0.8~1.2mm，不让拔针器①压住机线。

调节方法是，拧松固定螺钉③，左右移动拔针器活动滑块④。

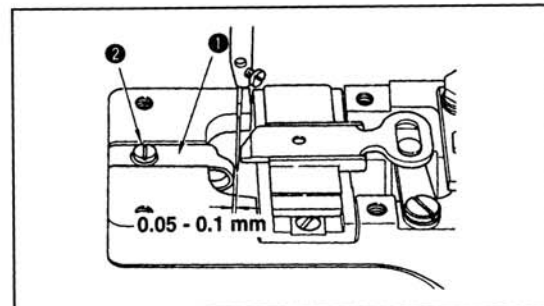
Provide a 0.8 to 1.2 mm clearance between nipper ① and nipper block ② to prevent the nipper from nipping the thread while stitching. Loosen screw ③ and move nipper bar block ④ to the left or the right.



## 12. 针导向器的位置 / POSITION OF THE NEEDLE GUIDE

在针杆最下点，拧紧螺丝②，左右移动针导向器①，把机针和针导向器①的间隙调整为0.05~0.1 mm。

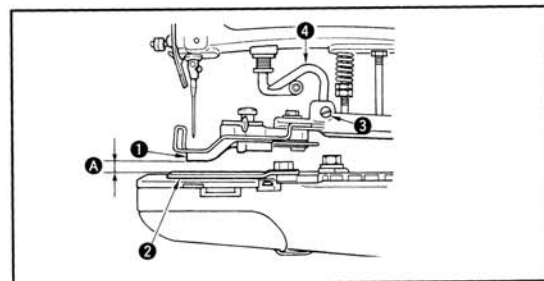
Loosen screw ② and provide a 0.05 to 0.1 mm clearance between the needle guide ① and the needle by moving the needle guide ① to the left or the right when the needle is in the lowest position.



## 13. 抓扣装置的高度 / HEIGHT OF THE BUTTON CLAMP

在断开位置，纽扣抓脚①的底面和布压脚下板②上面的间隔A，1377的标准为8mm。

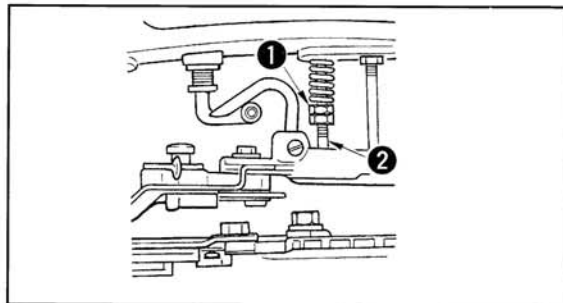
The standard clearance A between the bottom face of button clamp jaw lever ① and the top face of feed plate ② is 9 mm for T373. Loosen screw ③ and adjust the height of button clamp lifting hook ④.



#### 14. 布压脚压力的调节 / WORK PRESSING FORCE

布压脚的压力，以在转动螺母①2个螺母的下端和压脚压力调节杆②的螺丝部间隙为4~5mm时为标准。

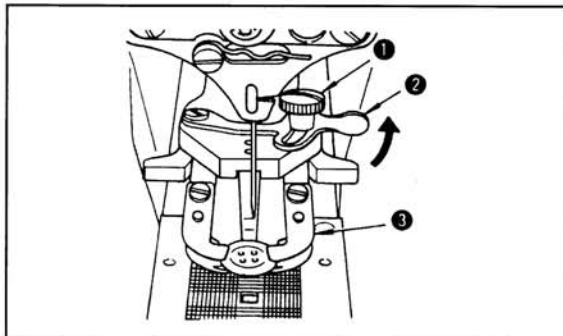
The standard work pressing force is obtained by providing a 4 to 5 mm clearance between the bottom face of nut ① and the bottom end of the screw of pressure adjusting bar ②.



#### 15. 抓脚打开拨杆的调整 / ADJUSTMENT OF THE BUTTON CLAMP STOP LEVER

在断开状态，拧紧固定螺丝①，用抓脚打开拨杆②开关打开抓脚③，把钮扣设定到正确的位置。让钮扣容易放进出口，然后拧紧螺丝①。

Set the machine for stop-motion state, loosen clamp screw ①, place a button correctly in the sewing position and adjust button clamp stop lever ② to permit the button properly to rest on button clamp jaw levers ③. Tighten clamp screw ① after determining the distance between the left and right jaw levers ③.



#### 16. 松线同步时间的调整 / TIMING OF THREAD TENSION RELEASE

沿箭头方向拉机线，转动驱动皮带轮，有一个第二线张力盘浮起，机线迅速拔出的点。此时，从针杆上端块上面到针杆上端的高度为1377使用44~47mm时为标准。TQ×7机针，为54~57mm。特别是频繁发生下列现象时，进行如下调节：

拧松螺母①，把螺丝刀插入第二线张力杆，沿箭头方向转动的话，针杆高度变低，向相反方向转动，则变高。

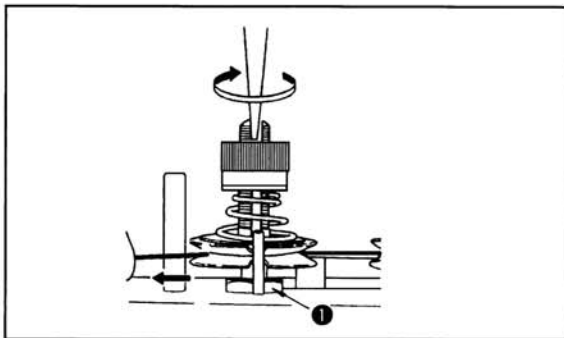
现象	针杆高度
1. 布料里侧的紧线不好时。	稍稍高一点。
2. 断开时，机线中途断线时。	稍稍高一点。
3. 经常断线时。	稍稍低一点。

Turn the needle driving pulley as you draw the thread in the direction of the arrow as illustrated and you will find a point at which the tension disc on the tension post No. 2 release the thread. At this moment, the standard distance from the top end of the needle bar to the top end of the needle bar bushing (upper) is 44 to 47 mm for 1377. Perform the following adjustments especially when the undermentioned troubles occur frequently.

Loosen nut ①, insert the blade of a screwdriver to the top slot of the tension post No. 2 and turn it in the direction of the arrow to lower the needle bar, (to reduce the said distance), and vice versa.

Your adjustment is required when following troubles are frequently;

Phenomenon	Height of needle bar
1. When the stitch made on the wrong side of the workpiece is too loose;	Make the needle bar slightly higher.
2. When the thread is broken at the time of stop-motion;	Make the needle bar slightly higher.
3. When the thread is broken frequently;	Make the needle bar slightly lower.



## 17. 2眼和4眼扣的调整 / SETTING FOR 2- OR 4-HOLE BUTTONS

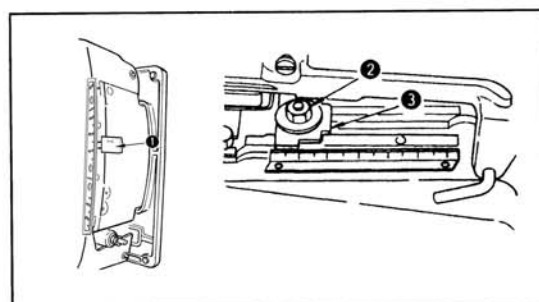
首先量一下钮扣孔间隙有几mm，4眼钮扣的竖送量和横送量值应设为相同。

### ★竖送量

向下压竖送调节杆①，2眼钮扣时设到0的位置，4眼钮扣根据测定进行设定。

### ★横送量

拧松螺母②，把指针③对准相应的刻度，然后拧紧螺母②。



请确认机针准确地落入钮扣各孔的中心，梭再运转缝纫机。

Measure the distance between two holes in a button and set equally crosswise and lengthwise feed regulators for 4-hole buttons.

### ★ Lengthwise feed

Push down lengthwise feed adjusting lever ① and set it to "0" for 2-hole buttons or a corresponding amount for 4-hole buttons.

### ★ Crosswise feed

Loosen nut ② and set pointer ③ to a corresponding amount indicated by the crosswise feed regulation plate. Tighten firmly nut ②.



Before operating the machine, ensure that the needle enters the center of each hole in the button.

## 18. 针数 / SETTING A NUMBER OF STITCHES

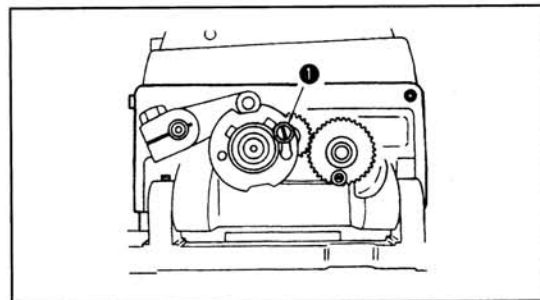
变更针数时，打开左侧防护罩，用针数调节旋钮①和针数调节拨杆④(选购品)进行调整。另外，下图是卸下预备停止装置后的图示，不卸下来也能变换针数。

To change the number of stitches, open the left-hand side cover and change the number of stitches using stitch number adjusting knob ① and stitch number adjusting lever ④ (optional). The illustration gives the machine with the auxiliary stop device removed. The number of stitches can be changed with ease with the auxiliary stop device attached.

### ★8针(6针)的调整方法/ 8 stitches (6 stitches)

设定为8针时，请把针数调节旋钮①向前拉出然后转到图示的位置。

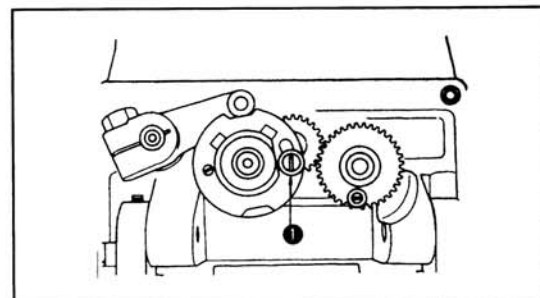
Pull stitch number adjusting cam knob ① and set it as shown in the illustration.



### ★16针(12针)的调整方法/ 16 stitches (12 stitches)

在设定为8针的状态下，把针数调整旋钮①再继续向右转，把针数调整旋钮①设定到图示的位置。

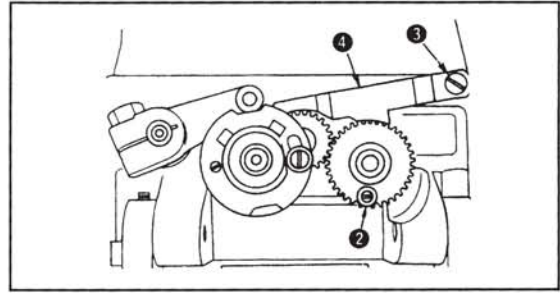
When stitch number adjusting cam knob ① being set for "8 stitches" has arrived at the right end as illustrated, set knob ① in the illustrated position.



★32针(24针)的调整方法/32 stitches (24 stitches)

设定为16针的状态下，针数调节齿轮螺丝②转到下侧时，用螺丝③(选购品)安装上针数调节拨盘拨杆④(选购品)。

When the number of stitches is set to 16, move stitch number adjusting gear roller ② to the lower position. Now, attach stitch number adjusting lever ④ (optional) in position using screw ③ (optional).

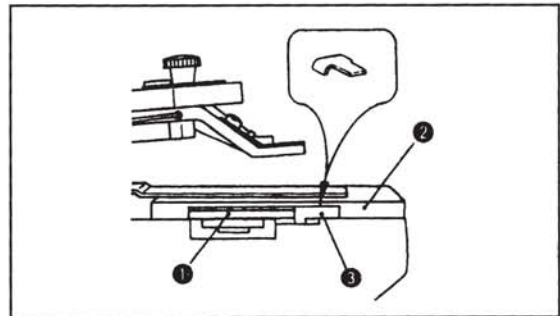


19. 切线装置 / AUTOMATIC THREAD TRIMMER

★移动刀位置的调整

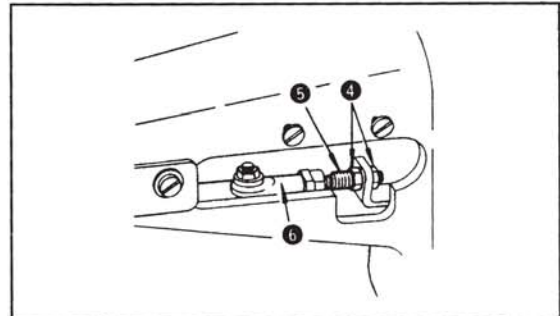
分离后压脚上升到最高处时，切线连接板(前)①和针板②槽沟端面的间隔标准为12.5mm。

调整到12.5mm时，请使用附属品的定位尺③，放倒缝纫机，卸下防油板，拧松螺母④(2个)，前后移动连结螺丝⑤，进行调整。另外，拧紧螺母④时，请看意切线连接接头⑥应基本保持水平。



★ Position of the moving knife

When the machine stops in the state of "stop-motion" and its button clamp assembly rests in the highest position, there must be a standard clearance of 12.5 mm between thread trimming connecting link (front) ① and the end face of the slit in throat plate ②. This clearance is determined by gauge ③ which is stored in the accessory box; tilt the head backwards, remove the bed oil shield, loosen two nuts ④ and adjust the clearance by moving connecting screw ⑤ in the axial direction. When you tighten two nuts ④, ensure that joint ⑥ stays in the horizontal position.

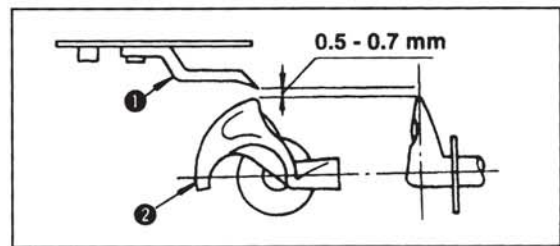


★移动刀分线爪的高度调整

分线爪①和弯针②的间隙为0.5~0.7mm，如果分线爪高度不正确时，请弄弯分线爪①。

★ Height of the moving knife thread separation nail

There must be a 0.5 to 0.7 mm clearance between looper blade point ② and thread separation nail ①. If nail ① does not provide the necessary clearance, bend the nail slightly and adjust the clearance.

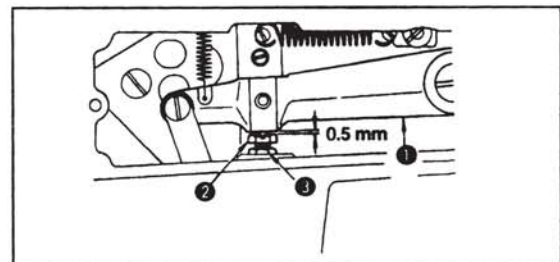


★提升拨杆和调节螺丝的间隙

把提升拨杆①端面和调节螺丝②的间隙调整为0.5mm，然后拧紧调节螺丝螺母③。

★ Clearance between the button clamp lifting lever and the adjusting screw

Provide a 0.5 mm clearance between button clamp lifting lever ① and adjusting screw ② and then tighten nut ③.

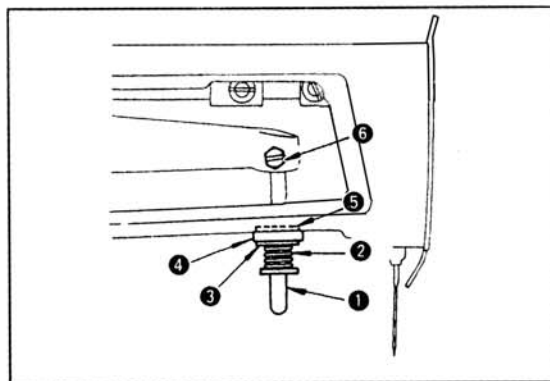


★ L型提升杆的安装方法

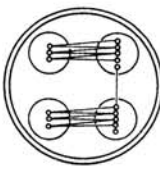

按移动反弹弹簧②、分离垫片③、分离垫④、分离垫片⑤的顺序安装到L型提升杆上。确定完全分离之后让机梁的凸部和分离垫片端面紧密结合，不要有任何松动，用螺丝⑥拧紧固定。

★ How to set the L-shaped lifting rod

Put moving knife push-back spring ②, stop-motion rubber cushion washer ③, stop-motion rubber cushion ④ and stop-motion rubber cushion washer ⑤, in this order, to L-shaped lifting rod ①. After making sure that the stop-motion mechanism has engaged completely, fix the L-shaped lifting rod by tightening screw ⑥ in the way that the end face of the stop-motion rubber cushion washer come into close contact with the jaw of the machine arm.

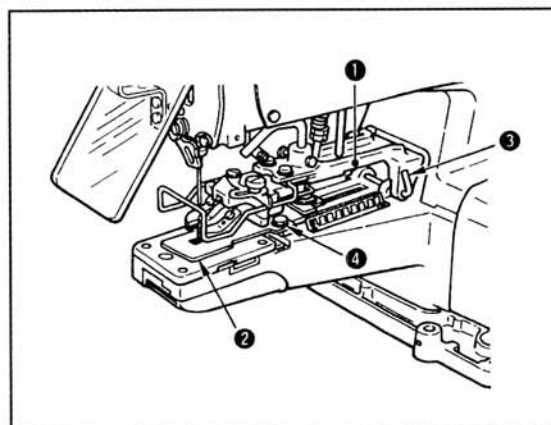


20. 线迹类型/STITCHES MODELS

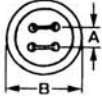
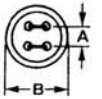
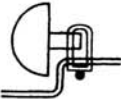


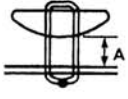
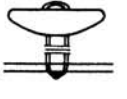
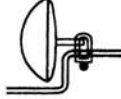
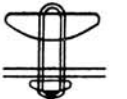

1377	
8, 16, 32针 8, 16, 32 stitches	8, 16, 32针 8, 16, 32 stitches
	

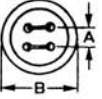
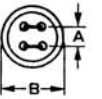
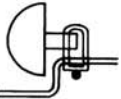


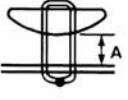
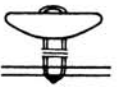
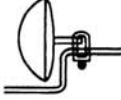
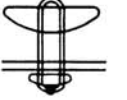

安装各个附件时，有时必须卸下抓扣装置①、布压脚下板②，这时请卸下抓扣装置轴③上的螺母，卸下布压脚下板②上的固定螺丝④，即可以把它卸下来。

In order to install the attachment on the machine, you may have to remove the button clamp mechanism ① or feed plate ②. Dislocate a snap ring from button clamp installing stud ③, and you will be able to remove button clamp mechanism assembly ①. Loosen setscrews ④, and you can remove feed plate ②.



## 21. 附件 / ATTACHMENTS

用途	平扣用		柄扣用		子母扣用
	大钮扣	中钮扣	一般	LEWIS型	
1377	Z031	Z032	Z033	Z040	Z037
示意图					
备考	钮扣尺寸 A : 3 ~ 6.5 mm B : $\phi$ 20 ~ $\phi$ 28 mm	钮扣尺寸 A : 3 ~ 5 mm B : $\phi$ 12 ~ $\phi$ 20 mm	钮扣直径:16mm 柄尺寸 厚:6.5mm 宽:3.2.5mm	钮扣尺寸与Z003 (Z033)相同可以对应柄形状的变化进行一些调整	尺寸: A:8mm
用途	钮扣绕线用		金属钮扣用	力扣用	钉标牌
	第一工序	第二工序	一般		
1377	Z004	Z035	Z038	Z039	Z044
示意图					
备考	钉扣高度 A : 5.5 mm			与Z004共通	折边宽度: 3 to 6.5 mm

Use	Flat buttons		Shank buttons		Snaps
	Large-size	Medium-size	General	Lewis type	
1377	Z031	Z032	Z033	Z040	Z037
Schematic drawing					
Remarks	Button size : A : 3 to 6.5 mm B : $\phi$ 20 to $\phi$ 28 mm	Button size : A : 3 to 5 mm B : $\phi$ 12 to $\phi$ 20 mm	Button diameter : Less than 16 mm Shank size : Thickness : 6 to 5 mm Width : 3 to 2.5 mm	Button size : Same as Z003 (Z033), but possible to sew buttons having some variations of shank in shape.	Snap size : A : 8 mm
Use	Wrapped-around buttons		Metal buttons	Stay button	Labels
	First process	Second process	General		
1377	Z004	Z035	Z038	Z039	Z044
Schematic drawing					
Remarks	Thread shank height : A : 5.5 mm			Common to Z004	Stitch width : 3 to 6.5 mm



★柄扣(珍珠扣) 钉扣附件(Z033,Z040)

★Attachments for shank buttons (Pear buttons) (Z033, Z040)

(安装方法)

卸下抓扣装置和布压脚下板，安装上珍珠扣用珍珠扣装置①，拧松固定螺丝③，前后移动抓脚安装台④，让机针正好落在抓脚②的落针沟中间。同时，让珍珠扣用布压脚下板台⑤正好落在落针沟中间，然后用固定螺丝⑦固定起来。

把钮扣压开杆⑧插进机架凸部的孔里，再用固定螺丝⑦固定起来。

(使用Z040时，还要更换压脚压力调节杆⑩和抓扣装置止动销⑪。)

(使用方法)

1. 拧松固定螺丝⑫，把布压脚下板⑥拉到离抓脚②的左端面0.5mm~1.0mm的地方，然后拧紧固定螺丝⑫。

2. 装上拗扣，拧松固定螺丝⑬和⑭，调节钮扣压脚使其稍稍压住钮扣的中心。

3. 拧紧推力环固定螺丝转动推力环，调节钮扣压脚压力不让钮扣移动。

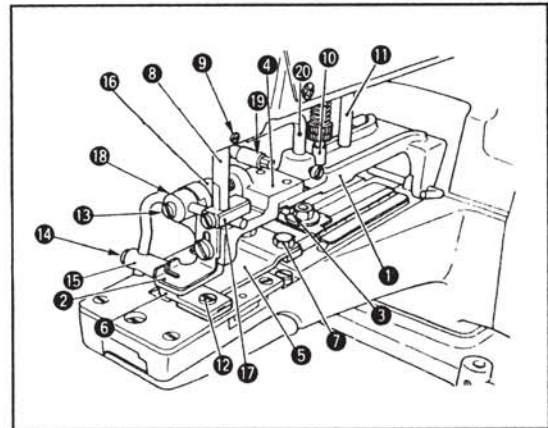


1. 转动推力环后，不要让转动轴⑮在轴方向产生松动。
2. 抓扣装置上升时，请调整抓扣装置的提升钩和抓扣装置的止动销⑪，让L型提升杆凸块⑯和抓脚安装台④不相碰。

(INSTALLATION)

Remove both the button clamp mechanism assembly and the feed plate from the machine and install attachment ① in place. Loosen screws ③ and adjust button clamp bracket ④ to permit the needle to come down in the middle of the needle slot in shank button adaptor ②. Attach button clamp feed plate ⑤ using screws ⑦ in the way that it permits the needle to come down in the middle of the needle slot in feed plate ⑥. Insert the top end of button clamp stud ⑧ into an opening in the jaw of the machine arm and fasten it by screw ⑨.

(When attaching Z040, you must change also button clamp pressure adjusting bar ⑩ and button clamp stopper pin ⑪ at the same time.)



(ADJUSTMENT AND OPERATION)

1. Loosen screw ⑫, let feed plate ⑥ recede 0.5 to 1.0 mm from the left end of button clamp jaw lever ② and retighten screw ⑫.

2. Set a button in place, loosen screws ⑬ and ⑭ and align shank button holding clamp ⑮ with the center of the button.

3. Shank button holding clamp ⑮ must give proper pressure to the button so that the button stays steadily in position while being sewn. Loosen a setscrew in thrust collar ⑯ and rotate the thrust collar until shank button holding clamp ⑮ provides proper pressure.

4. You may fix button clamp block ⑰ in a convenient position for operation.



1. When you fix the thrust collar, ensure that button clamp rotating shaft ⑮ does not play axially in its bracket.
2. Adjust lifting hook ⑳ and stopper pin ⑪ so that L-shaped lifting rod roller ⑱ does not come in contact with button clamp bracket ④.

### ★绕线钉扣第1工序(钉扣工序)用附件(Z004)

#### ★Attachment for the first process of wrapped-around buttons (Z004)

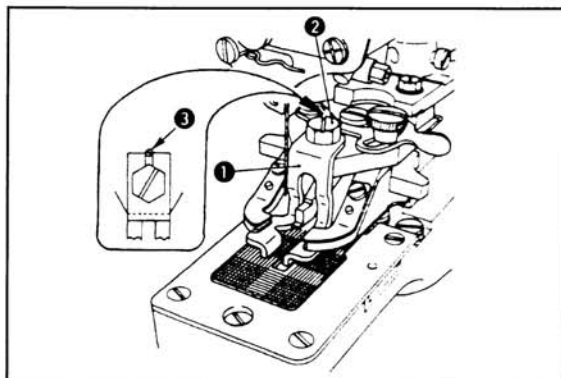
##### (安装方法)

用安装螺丝②和导销螺丝③把绕线用爪①固定到普通的钮扣抓爪部。

此时，把钮扣抓爪①安装到钮扣中心左右均等的位置。

##### (使用方法)

与钉普通的平扣一样，但是从钮扣到布之间的距离变长了，所以需要调节线调节拨杆把拉线量弄长。(参照[9. 线调节拨杆的调节]项)



##### (INSTALLATION)

Attach wrapped-around button foot ① to the ordinary button clamp jaw levers using screw ② and guide pin screw ③. Align foot ① with the jaw levers so that they permit a button to rest in the middle.

##### (ADJUSTMENT AND OPERATION)

Adjustment and operation are almost same as those for the flat buttons, but you must adjust the thread pull-off lever to provide more amount of thread in order to make the thread loose below the button for thread shank formation. (See 9. Adjustment of the thread pull-off lever.)

### ★绕线钉扣第2工序(绕线工序)用附件(Z035)

#### ★Attachment for the second process of wrapped-around buttons (Z035)

##### (安装方法)

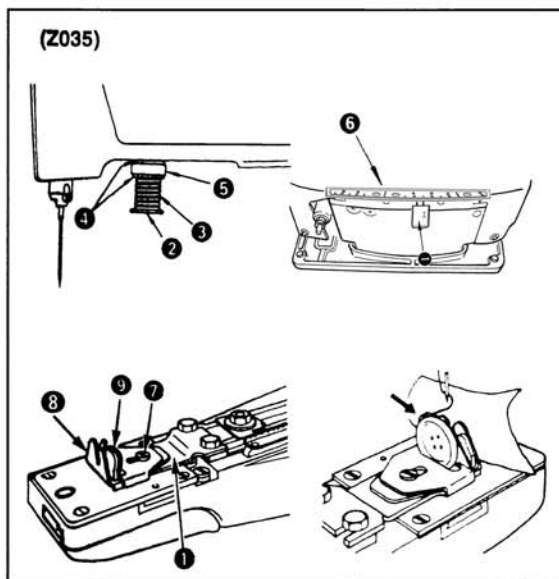
卸下抓扣装置、压脚压力调节杆和布压脚底板，安装上绕线第2工序用附件。但是，Z035需要卸掉L型拉杆，按照移动刀反弹弹簧②、分离垫圈、分离垫片⑤、分离垫圈④的顺序安装，确认了完全分离之后，把机架和分离缓冲器⑤的端面紧紧地安装起来不让它有松动。同时还更换纵送布刻度板⑥。

##### (使用方法)

1. 拧松安装螺丝⑦，绕线用金属部件(大)⑧和绕线用金属部件(小)⑨移动到落针位置的中心，调节绕线长度。

2. 把钮扣放进，把线从箭头部穿进。

3. 把竖送刻度设为0。但是，Z035机种16针时，竖送布刻度设为1.5mm。



##### (INSTALLATION)

Remove the button clamp mechanism assembly, button clamp pressure adjusting bar and feed plate from the machine and install attachment for the second process of wrapped-around buttons ①. When you install a Z035 attachment, you must remove also the L-shaped lifting rod. Insert moving knife push-back spring ②, washer ④, cushion ⑤ and washer ③ in spring guide shaft ② in this order. Make certain that the stop-motion mechanism has completely engaged, and install the attachment assembly in place in the way that cushion ⑤ comes in close contact with the surface of the machine arm without play. Then, replace lengthwise feed graduated plate ⑥.

##### (ADJUSTMENT AND OPERATION)

1. Loosen screw ⑦ and adjust the thread shank length by moving guide (large) ⑧ and guide (small) ⑨ in line with the point of needle entry.
2. Set a button (tilt it slightly for easy insertion) and pass the thread as the arrow shows.
3. Set the lengthwise feed to "0".  
When you sew 16 stitches with Z035, set it to "1.5 mm" instead of "0".

### ★钉子母扣附件(Z037)

### ★Attachment for snaps (Z037)

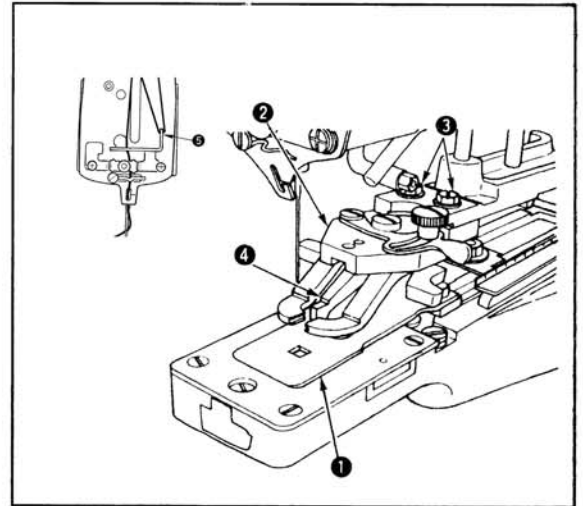
#### (安装方法)

卸下抓口扣装置和布压脚下板，横送布刻度和竖送布刻度设定为4mm以后，安装子母扣用下布压板①，让针均匀地落到四角孔里。然后，在子母扣抓住了子母扣的状态，安装上子母扣抓扣装置②，让机针正确地落到扣孔里。如果落针不正确的话，请拧松六角螺丝③进行调节。

最后，请确认下布压板①的凸形和子母扣用钮扣导爪④下面的凹形是否完全一致。另外，第三导线器⑤也换成子母扣用的。

#### (INSTALLATION)

Remove the button clamp mechanism assembly and the feed plate. Set both the crosswise feed and lengthwise feed graduated plates to "4 mm". Install snap clamp feed plate ① in the way that the needle drops evenly at four corners of its square opening. Install snap attachment assembly ② on the machine, place a snap on the snap clamp jaw levers and make



sure that the needle drops accurately in each hole in the snap. If necessary, loosen hex head screws ③ and adjust the position accurately. Lastly, make sure that the concave section on the bottom face of snap clamp slide guide ④ accurately matches the convex section on snap clamp feed plate ①. Replace thread guide No. 3 ⑤.

### ★钉金属扣附件(Z038)

### ★Attachment for metal buttons (Z038)

#### (安装方法)

卸下抓扣装置和布压脚下板，安装金属扣用抓扣装置①，拧松固定螺丝③，前后移动抓爪安装台④，让机针正好落在抓爪②的落针沟的中间。另外，用固定螺丝⑦固定金属扣用布压脚下板⑤，让机针正好落在压脚下板⑥的落针沟中。

把纽扣压开杆⑧插进机架头部的孔里，然后用固定螺丝⑨拧紧固定。

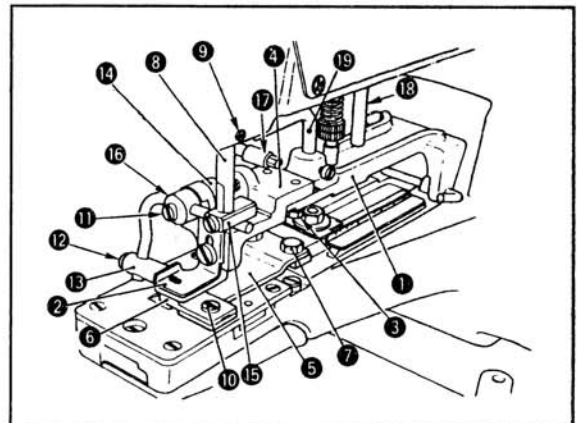
#### (使用方法)

1. 拧松固定螺丝⑩，把布压脚下板⑥从抓爪②的左端面拉进1.0~1.5mm，然后拧紧固定螺丝⑩。

2. 安放钮扣，拧松固定螺丝⑪和⑫，让钮扣压脚⑬正好压住钮扣的中心。

3. 拧紧固定螺丝，转动轴环⑭进行调节，让钮扣压脚⑬的压力在缝制中不让钮扣移动。

4. 把钮扣压脚打开凸轮⑮移动到使用方便的位置固定起来。



#### (INSTALLATION)

Remove both the button clamp mechanism assembly and the feed plate from the machine and install attachment ① in place. Loosen screws ③ and adjust button clamp bracket ④ to permit the needle to come down in the middle of the needle slot in metal button adaptor ②. Attach button clamp feed plate ⑤ using screws ⑦ in the way that it permits the needle to come down in the middle of the needle slot in feed plate ⑥. Insert the top end of button clamp stud ⑧ into an opening in the jaw of the machine arm and fasten it by screw ⑨.



1. 转动轴环时旋转轴⑬在轴方向不能有松动。
2. 抓扣装置上升时，L型提升杆凸轮⑮和抓爪安装台④不要相碰。

**(ADJUSTMENT AND OPERATION)**

1. Loosen screw ⑩, let feed plate ⑥ recede 1.0 to 1.5 mm from the left end of button clamp jaw lever ② and retighten screw ⑩.
2. Set a button in place, loosen screws ⑪ and ⑫ and align metal button holding clamp ⑬ with the center of the button.
3. Metal button holding clamp ⑬ must give proper pressure to the button so that the button stays steadily in position while being sewn. Loosen a setscrew in thrust collar ⑭ and rotate the thrust

collar until metal button holding clamp ⑬ provides proper pressure.

4. You may fix button clamp block ⑮ in a convenient position for operation.



1. When you fix the thrust collar, ensure that button clamp rotating shaft ⑩ does not play axially in its bracket.

2. Adjust lifting hook ⑰ and stopper pin ⑱ so that L-shaped lifting rod roller ⑲ does not come in contact with button clamp bracket ④.

**22. 马达皮带轮和皮带 / MOTOR PULLEY AND BELT**

(1) 马达使用单相、输出功率200W (1/4马力) 的通用马达。

(2) 皮带使用圆皮带 (ø7x650mm)。

(3) 马达皮带轮和缝纫机转速的关系如下表所示。

(1) For this machine a single-phase or 3-phase 200 watts (1/4 HP) induction motor is used.

(2) A round leather belt (ø7x650 mm) is used.

(3) The sewing speed depends on the diameter of the motor pulley as listed below ;

Hz	rpm	马达皮带轮的货号 Motor pulley part No.	
50	1500	40931004	71
	1250	40931004	59.2
60	1500	40931004	59.2
	1300	40931004	51.3

★ 马达皮带轮的有效直径是外径减1mm。

★ 马达的旋转方向从马达皮带轮侧看为反时针方向。请留意方向不要弄反。

★ The effective diameter of motor pulley is obtained by subtracting 1 mm from its outer diameter.

★ The motor must revolve in the counterclockwise direction when viewed from the motor pulley side. Take care not to let it run in the reverse direction.

### 23. 故障的原因和对策 / TROUBLES AND CORRECTIVE MEASURES

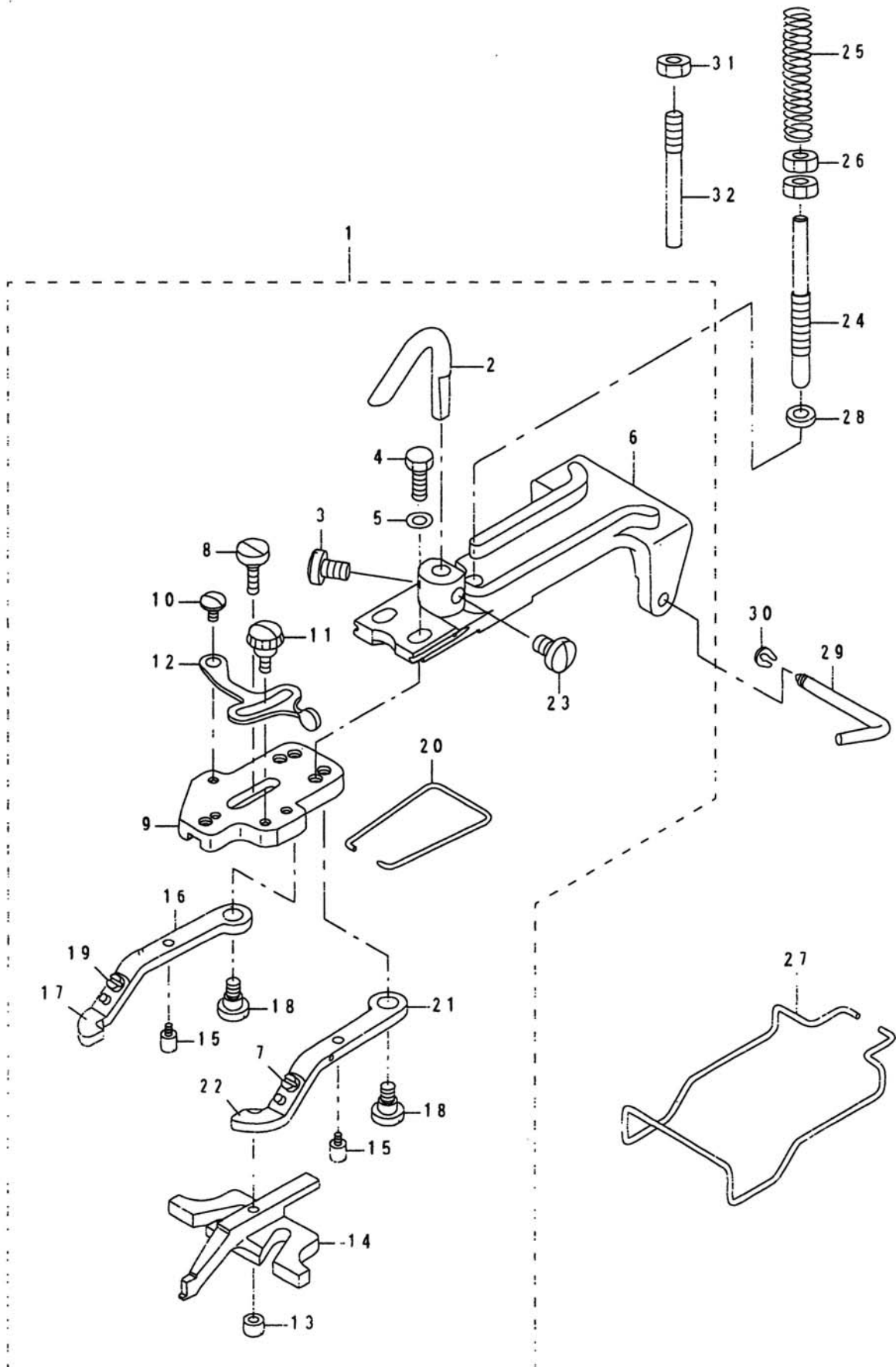
故 障	原 因	对 策
1. 断线	(1)靠线动作不良。 (2)第二线张力盘的同步不好。 (3)拔针器压线。 (4)机针没有落到钮扣的中心。 (5)针与扣眼相比太粗。	调整靠线左右同步。 提早线张力盘浮起同步。 调节拔针器摆动滑块。 用抓脚安装台调整。 换为细针。
2. 紧线不良	(1)靠线动作不良。 (2)第二线张力盘的同步不好。 (3)第二线张力盘的张力不良。 (4)机针没有落到钮扣的中心。 (5)压布脚压力不良。	调整靠线左右同步。 稍稍推迟线张力浮起同步时间。 用第二线张力盘调整。 用抓脚安装台调整。 调整布压脚压力。
3. 钮扣上第一针的线出地太长。	线张力拨杆调整不良。	调整线张力拨杆摆动轴。
4. 分离时切线不良。	(1) 第二线张力盘的同步不好。 (2) 机针碰到钮扣孔。 (3) 抓扣装置上升不良。 (4) 拔针器压线不良。 (5) 布压脚压力太大。	稍稍推迟线张力盘浮起同步，使紧线变好。 调整落针。 让抓扣脚到下板的距离为12mm。 调节拔针器摆动滑块。 用布压脚压力调节螺母进行调节。
5. 切线不断。	(1) 移动刀分线爪不能把布侧的线确实分开。 (2) 机针没有落到钮扣的中心。 (3) 最后落针跳针。 (4) 移动刀分线爪高度不良。	调整移动刀位置。 用抓脚安装台调整。 调整弯针。 调整移动刀分线爪的高度。
6. 面线和底线2根都断线。	(1)移动刀位置不良。 (2)移动刀分线爪高度不良。	调整分离时移动刀的位置。 调整移动刀分线爪的高度。
7. 切线后布里侧线出得太长。	(1)移动刀切线同步不良。 (2)抓扣装置上升量过大。	调整移动刀位置。 把抓脚上升量调整为9mm。

TROUBLES	CAUSES	CORRECTIVE MEASURES
1. Thread breakage	(1) The yoke slide does not move in the correct way. (2) The thread tension post No. 2 fails to release the thread at correct timing. (3) The thread nipper catches the thread. (4) The needle does not enter the center of the holes in the button. (5) The needle is too thick for the diameter of the hole in the button.	<ul style="list-style-type: none"> <li>○ Adjust the timing of the motion of the yoke slide at each end.</li> <li>○ Make the thread release timing slightly earlier.</li> <li>○ Adjust the position of the nipper bar block.</li> <li>○ Adjust the button clamp jaw lever holder.</li> <li>○ Replace the needle by a thinner one.</li> </ul>
2. Buttons are not sewn tightly.	(1) The yoke slide does not move in the correct way. (2) The thread tension post No. 2 fails to release the thread at correct timing. (3) The thread tension post No. 2 does not give sufficient tension. (4) The needle does not enter the center of the holes in the button. (5) The work pressing force is too high or too low.	<ul style="list-style-type: none"> <li>○ Adjust the timing of the motion of the yoke slide at each end.</li> <li>○ Make the thread release timing slightly later.</li> <li>○ Tighten the tension nut of tension post No. 2.</li> <li>○ Adjust the button clamp jaw lever holder.</li> <li>○ Adjust the work pressing force properly.</li> </ul>
3. The first stitch trails relatively long thread from the right side of the button.	The thread pull-off lever does not work properly.	<ul style="list-style-type: none"> <li>○ Adjust the thread pull-off lever by the nipper bar block (rear).</li> </ul>
4. Thread trimming failure in the state of stop-motion	(1) The thread tension post No. 2 fails to release the thread at correct timing. (2) The needle hits the edge of the holes in the button. (3) The button clamp assembly does not rise to the necessary height. (4) The thread nipper fails to press the thread. (5) The work pressing force is too high.	<ul style="list-style-type: none"> <li>○ Make the thread release timing slightly later to give more tension to the stitches.</li> <li>○ Adjust the button clamp jaw lever holder.</li> <li>○ Provide a 12 mm clearance between the feed plate and the button clampjaw levers when rose.</li> <li>○ Adjust the nipper bar block.</li> <li>○ Adjust the work pressing force by the pressure adjusting nut.</li> </ul>
5. Thread trimming failure	(1) The moving knife does not separate the thread on the fabric with its separation nail. (2) The needle does not enter the center of the holes in the button. (3) The last stitch skips. (4) The moving knife thread separation nail is too high or too low.	<ul style="list-style-type: none"> <li>○ Adjust the position of the moving knife.</li> <li>○ Adjust the button clamp jaw lever holders.</li> <li>○ Adjust the looper.</li> <li>○ Adjust the height of the moving knife thread separation nail.</li> </ul>
6. The needle thread is cut in two places on the wrong side of the fabric.	(1) The moving knife is set in wrong place. (2) The moving knife thread separation nail is too high or too low.	<ul style="list-style-type: none"> <li>○ Adjust the position of the moving knife when the machine is in the stop-motion state.</li> <li>○ Adjust the height of the thread separation nail.</li> </ul>
7. Button trails too long thread after thread trimming.	(1) Timing of the moving knife motion is wrong. (2) The button clamp assembly rises too much.	<ul style="list-style-type: none"> <li>○ Adjust the position of the moving knife.</li> <li>○ Reduce the button clamp lift down to 9 mm.</li> </ul>

# 零件样本

## Parts Book

# 1. 钮钳机构部件 BUTTON CLAMP MECHANISM COMPONENTS

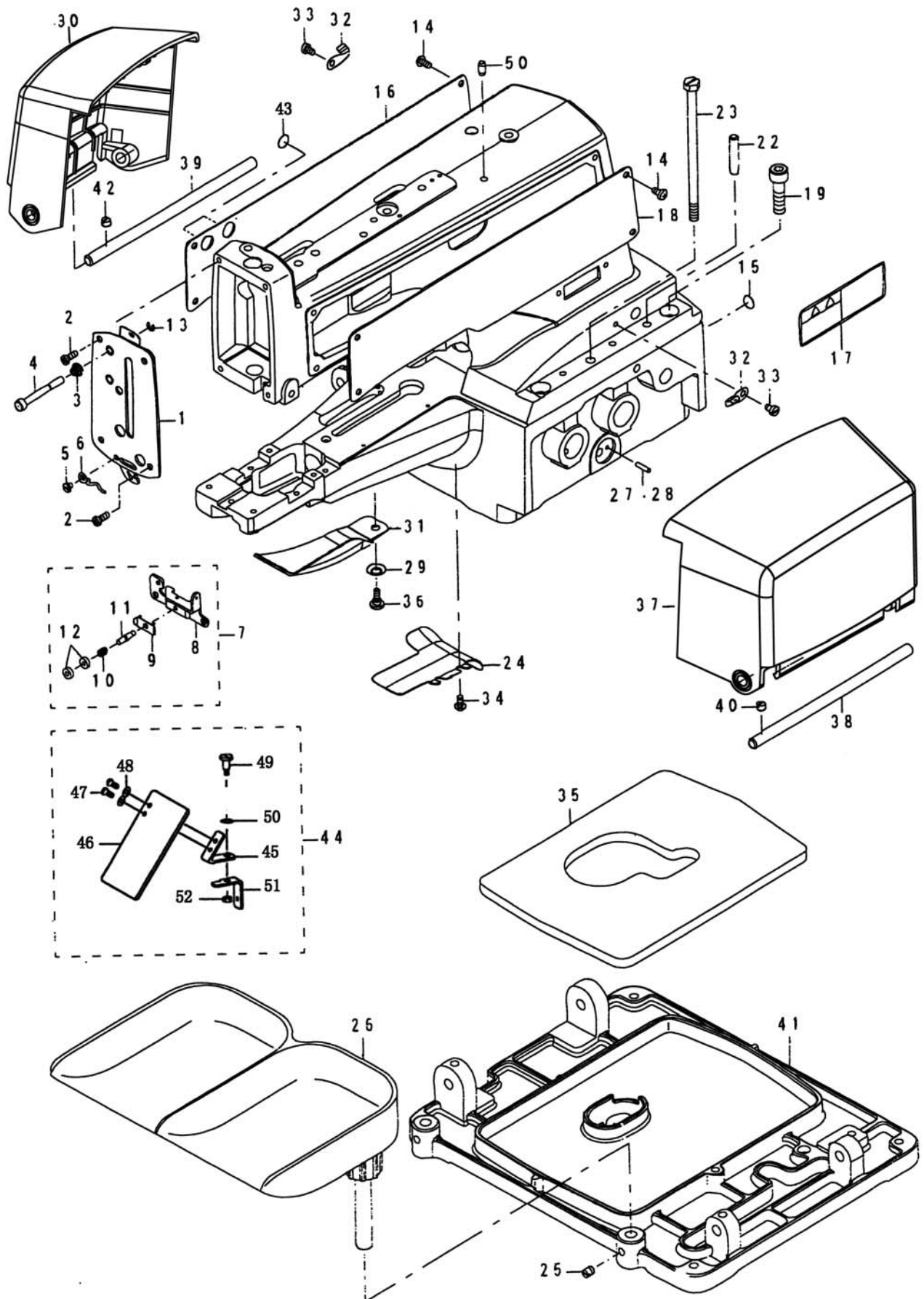




## 第一部件 钮夹部件

序号	零件件号	名称	数量	同类编号	DESCRIPTION
1	××××	拾压脚组件	1	26026856	PICK-UP DEVICE ASM.
2	40902001	钮夹挂钩	1	40041058	BUTTON CLAMP LIFTING HOOK
3	402S14006	螺钉	1	SS7150940SP	SCREW 15/64-28 L=9
4	409S12001	螺钉	2	SS9621413SP	SCREW 3/16-32 L=13.5
5	40928001	垫圈	2	WP0501016SD	WASHER 5×10.5×1
6	300145	钮夹座	1	26025502	BUTTON CLAMP HOULDER
7	409S11002	螺钉	1	SS7090410SP	SCREW 9/64-40 L=3.5
8	409S20001	轴位螺钉	1	SD0550301SP	HINGE SCREW D=5.5 H=3
9	4091200100	钮夹组件	1	26025403	JAW LEVER HOLDER
10	409S20002	轴位螺钉	1	SD0550181SP	HINGE SCREW D=5.5 H=1.8
11	409S20003	钮夹螺钉	1	26025809	CLAMP SCREW A
12	40912003	钮夹止动杆	1	26025700	SNAP FASTENER CLAMP STOP LEVER
13	409S16001	螺母	1	26026005	NUT
14	40901003	钮夹滑块	1	26025908	BUTTON CLAMP SLIDE
15	409S20004	钮夹止动销	2	26026609	BUTTON CLAMP STOP PIN
16	40912005	左钮夹钳夹	1	26026104	BUTTON CLAMP LEVER JAW (LEFT)
17	40912006	钮扣左弹簧压板	1	26026203	BUTTON HOLDING SPRING LEFT
18	409S20005	轴位螺钉	2	SD0640391TP	HINGE SCREW D=6.35 H=3.9
19	409S11002	螺钉	1	SS7090410SP	SCREW 9/64-40 L=3.5
20	40927001	钮夹弹簧	1	26026708	BUTTON CLAMP SPRING
21	40912008	右钮夹钳夹	1	26026302	BUTTON CLAMP LEVER JAW RIGHT
22	40912009	钮夹右弹簧压板	1	26026401	BUTTON HOLDING SPRING RIGHT
23	402S14006	螺钉	1	SS7150940SP	SCREW 15/64-28 L=9
24	409S30016	钮夹压力调节杆	1	40040938	BUTTON CLAMP PRESSUER ADJUSTIN
25	40927002	钮夹压力弹簧	1	26027102	PRESSUER ADJUSTING SPRING
26	409S16003	螺母	2	NM6060001CP	NUT M6
27	40927003	护手架	1	26027409	FINGER GUARD
28	40909019	弹簧固定座	1	40041069	SPRING HOLDING PLATE
29	40902002	插销	1	26025205	HINGE PIN
30	H05007	卡簧	1	B2541372000	SNAP PIN
31	401S16002	螺母	1	NM6060001CP	NUT M6
32	409S30001	拾压脚止动杆	1	40040937	PICK-UP DEVICE STOPPER PIN

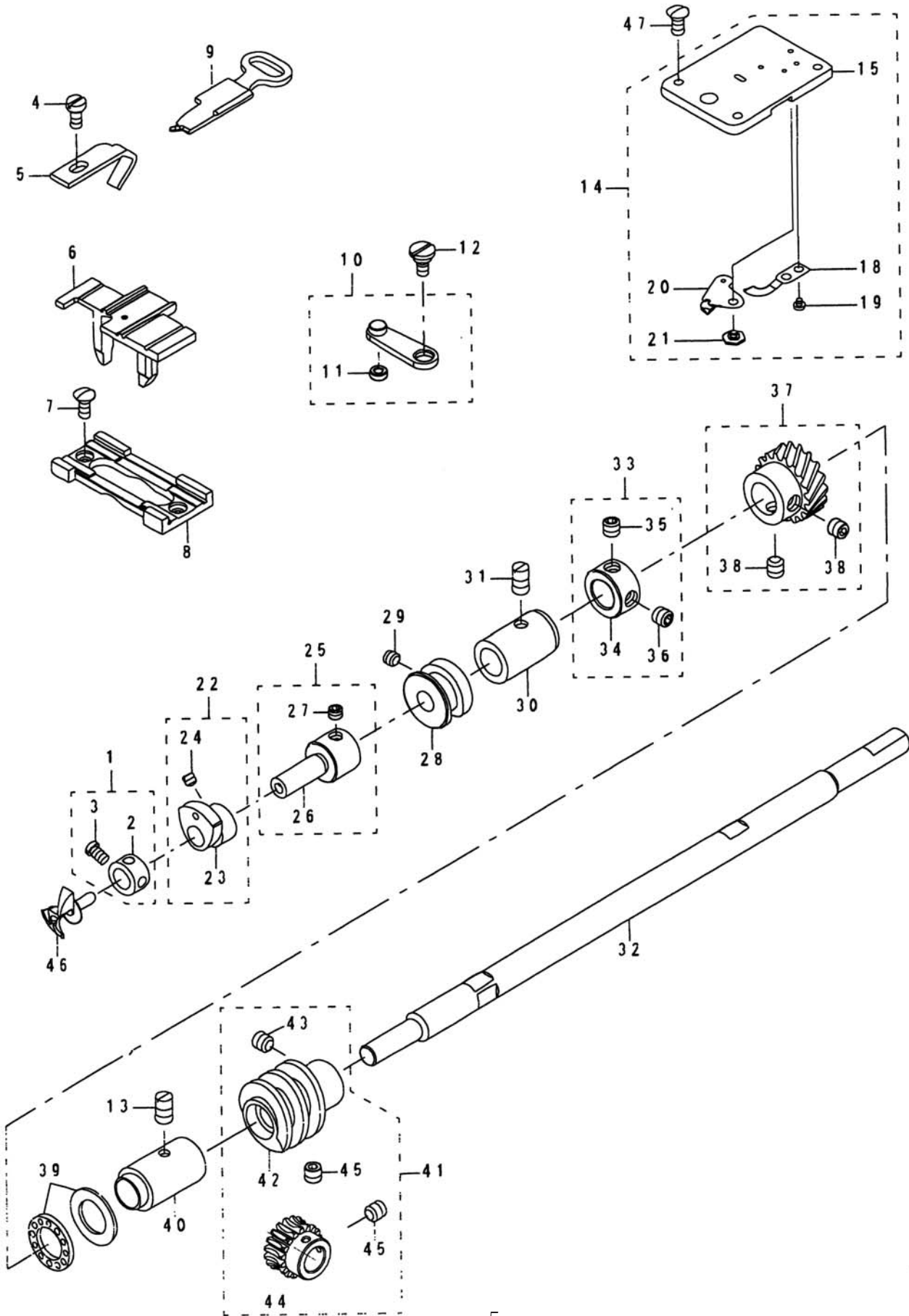
## 2. 机壳部件 ARM & MISCELLANEOUS COVERS COMPONENTS



## 第二部件 机壳部件

序号	零件件号	名称	数量	同类编号	DESCRIPTION
1	4091206200	面板盖组件	1	-----	FACE PLATE COMPL
2	406S11009	螺钉	4	SM4040855SP	SCREW
3	40927004	张紧弹簧	1	26021600	TENSION SPRING
4	40902003	松线杆	1	26032003	NIPPER RELEASING STOP
5	409S11003	螺钉	1	SM6040650TP	SCREW
6	40913002	4号过线	1	26031203	THREAD GUIDE NO. 4
7	4091301400	3号线张力器组件	1	26031351	THREAD TENSION NO. 3 ASM.
8	40913015	3号线张力调节座	1	26031302	TENSION ADJUSTING BASE NO. 3
9	40913016	线张力盘	1	26031401	THREAD PRESSER PLATE
10	40927020	弹簧	1	26031500	TENSION SPRING B
11	409S30017	线张力器螺栓	1	26031609	THREAD TENSION STUD
12	409S16026	张力调节螺母	2	26031708	THREAD TENSION NUT
13	H05002	E型卡簧	1	RE0320000K0	E-RING 3.2
14	406S11009	螺钉	8	SM4040855SP	SCREW
15	40122015	橡皮塞	1	-----	RUBBER PLUG
16	301805	左盖板	1	-----	SIDE COVER RIGHT
17	40937008	安全标签	1	CM301300001	SAFETY LABEL
18	301807	右盖板	1	-----	SIDE COVER LEFT
19	S05024	拼装螺钉	4	SM6083042CH	SCREW M8 L=30
22	P02001	定位销	2	26033704	GUIDE PIN
23	409S30018	连接螺栓	1	SM6050800SP	SET SCREW
24	40912080	防油底板	1	26011205	BED OIL SIELD
25	403S14004	螺钉	1	-----	SCREW
26	4091100100	钮扣盘	1	1780-48458	BUTTON TRAY ASM
27	40926002	凸轮指示销	1	SM80600610TP	CAM INDICATING PIN A
28	40926002	凸轮指示销	1	40041022	CAM INDICATING PIN B
29	40228001	弹性垫圈	1	26022608	SPRING WASHER 6.5×14.0×17
30	40911007	左侧盖	1	-----	SIDE COVER LEFT
31	40912081	底座活动盖	1	WS0650389KP	LOOPER COVER
32	40912067	侧盖弹簧片	2	40038425	SIDE COVER SPRING
33	409S11006	螺钉	2	40038430	SCREW M4 L=6
34	409S11007	螺钉	2	40041067	SCREW
35	40923013	滴油毡	1	SM6040600SP	OIL DRIP FELT
36	409S20006	螺钉	1	SM4040855SP	SHOULDER SCREW D=6 H=2.7
37	40911008	右侧盖	1	-----	SIDE COVER RIGHT
38	40902020	右侧盖轴	2	SD600277TP	SIDE COVER HINGE SHAFT RIGHT
39	40902019	左侧盖轴	1	40038424	SIDE COVER HINGE SHAFT LEFT
40	403S14004	螺钉	1	-----	SCREW M6 L=6
41	40901019	油盘	1	40040935	MACHINE SUB BASE
42	402S14006	螺钉	1	SM8060612TP	SCREW M6 L=6
43	40122017	橡皮塞	1	-----	RUBBER PLUG
44	××××	安全板组件	1	SM8060612TP	SAFETY PLATE
45	40112008	安全板支架	2	-----	SAFETY PLATE
46	40911006	安全板	2	26037200	SAFETY PLATE
47	409S11008	螺钉	2	SM4040655SP	SCREW M4 L=6
48	40928002	垫圈	1	WPO430800SD	SPRING WASHER 5.0×110
49	402S20032	轴位螺钉	1	TA1250406R0	HINGE SCREW D=6 H=2.5
50	40128001	波形垫圈	1	PS0500102KH	SPRING
51	40912020	安全板安装座	1	-----	SAFETY PLATE INSTALLING BASE
52	401S16004	螺母	1	-----	NUT SM15/64-28

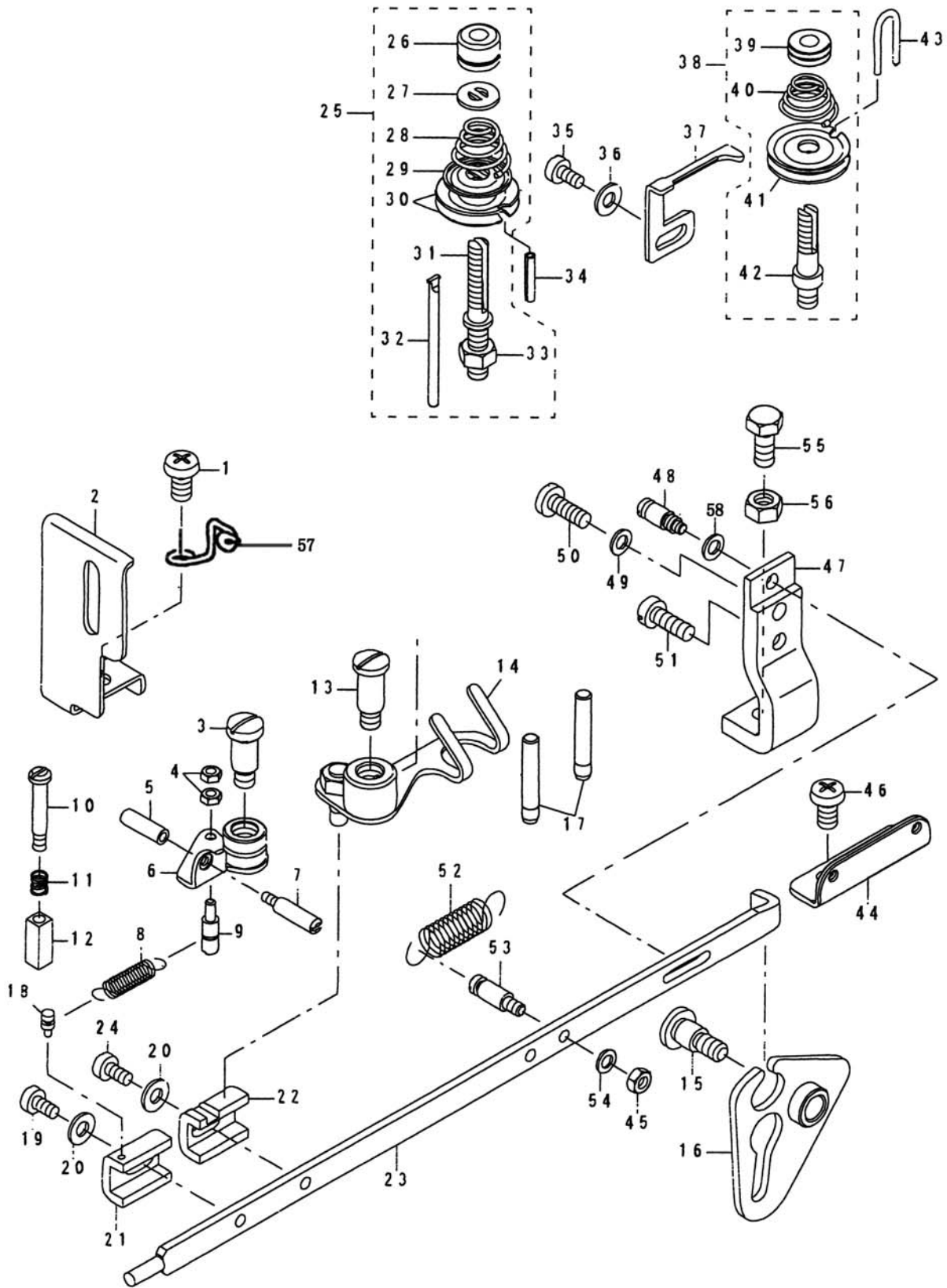
### 3. 下轴部件 LOOPER SHAFT MECHANISM COMPONENTS



## 第三部件 钩线轴部件

序号	零件件号	名称	数量	同类编号	DESCRIPTION
1	××××	挡圈组件	1	CS079072ATH	THRUST COLLAR .ASM
2	40908002	挡圈	1	CS0790721TH	THRUST COLLAR D=7.94 W=7
3	409S11012	螺钉	1	SS7090620TP	SCREW 9/64-40 L=6.1
4	409S11010	螺钉	1	SM6040800SP	SCREW
5	40912021	护针	1	B1242-373-00	NEEDLE GUARD
6	40909001	分线器架	1	26013607	POSITONGNING FINGER YOKE SLIDE
7	409S17001	螺钉	2	SM104095TP	SCREW M4 L=9
8	40909002	分线器滑座	1	26013409	YOKE SLIDE INSERT
9	40912022	分线器	1	26013805	YOKE SLIDE
10	4090500100	环形定位杆	1	B1230-372-0A	ASSY LOOP POSITIONING FINGER L
11	40903003	滚珠	1	B1232-372-00	LOOP POSITIONING FINGER CAM RO
12	409S20008	轴位螺钉	1	SD0640246SP	HINGE SCREW D=6.35 H=2.4
13	401S14001	螺钉	1	SM8061010TP	SCREW
14	××××	针板组件	1	B12413770B0	THROAT PLATE SET
15	40901005	针板	1	B12413770A0	THROAT PLATE ASM.
18	40919003	定刀	1	B2410377000	COUNTER KNIFE
19	409S11011	螺钉	2	SS7080310SP	SCREW1/8-44 L=3.0
20	4091900100	动刀	1	B24063730A0	MOVING KNIFE ASM.
21	409S20009	螺钉	1	SD0600095TH	HINGE SCREW D=6 H=0.85
22	××××	分线三角凸轮	1	40041106	ASSY LOOP POSITIONING FINGER C
23	40910001	分线三角凸轮	1	26003103	LOOP POSITIONING FINGER CAM
24	409S14002	螺钉	2	SS8110410TP	SCREW 11/64-40 L=3.5
25	××××	连接轴组件	1	40037482	ASSY CAM AND LOOPER SLEEVE
26	40902006	连接轴	1	26015503	CAM AND LOOPER SLEEVE
27	409S15004	螺钉	2	SS8150410TP	SCREW 15/64-28 L=4.0
28	40910001	后凸轮	1	B1228372000	LOOP POSITIONING FINGER CAM RE
29	409S14002	螺钉	2	SS8110310SP	SCREW 11/64-40 L=2.8
30	40903004	下轴前套	1	26015305	LOOPER SHAFT BUSHING FRONT
31	401S14001	螺钉	1	SM8061010TP	SCREW
32	40902026	下轴	1	40038111	LOOPER SHAFT
33	××××	挡圈组件	1	CS111101KSH	THRUST COLLAR ASM, D=11.11, W=1
34	40908001	挡圈	1	CS1111019SH	THRUST COLLAR ASM, D=11.11, W=10
35	409S14003	螺钉	1	SS8660512TP	SCREW 1/4-40 L=5
36	409S14004	螺钉	1	SS8660512TP	SCREW 1/4-40 L=5
37	40925002	下轴齿轮	1	B12243720A0	LOOPER SHAFT DRIVER GEAR ASM.
38	409S14001	螺钉	2	SS8660612TP	SCREW 1/4-40 L=6
39	40928004	推力球轴承	1	B1215372A00	THRUST BALL BEARING
40	40903005	下轴后套	1	26013102	LOOPER SHAFT BUSHING REAR
41	××××	蜗轮蜗杆组件	1	B1221373NA0	WORM WHEEL ASM.
42	40925009	蜗杆	1	B1221373N00	WORM
43	409S14003	螺钉	2	SS6660712TP	SCREW 1/4-40 L=7
44	40925001	蜗轮蜗杆组件	1	B1220372000	CAM SHAFT ASM.
45	409S14003	螺钉	2	SS8606612TP	SCREW 1/4-40 L=6
46	40917001	线钩	1	B1239372000	LOOPER
47	409S11009	螺钉	3	SM1040950TP	SCREW M4 L=9

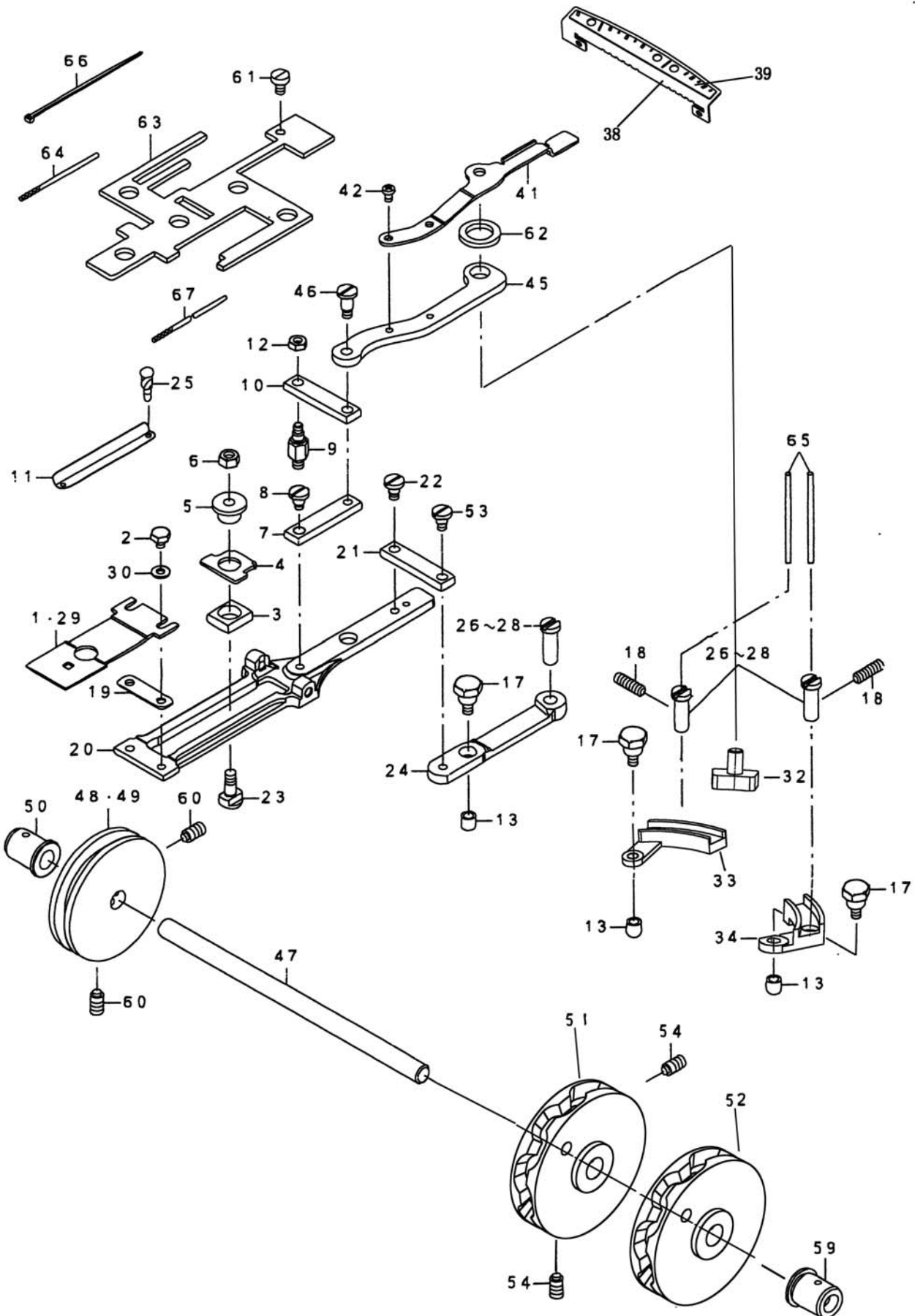
#### 4. 绕线和过线部件 NIPPER & THREAD TENSION PARTS COMPONENTS



## 第四部件 绕线和过线部件

序号	零件件号	名称	数量	同类编号	DESCRIPTION
1	409S11013	螺钉	1	SM4061255SP	SCREW M6 L=12
2	40912024	针杆防护罩	1	B1421-372-00	NEEDLE BAR GUARD
3	409S20010	轴位螺钉	1	SD0791276TP	SHOULDER SCREW
4	409S16005	螺母	2	NM6030001SN	NUT
5	409S16006	松线螺母	1	26020602	NUT
6	4091202500	导线装置	1	26000950	NIPPER COMPL
7	409S20011	松线销	1	26020503	LOOPER SHAFT BUSHING REAR
8	40927007	夹线杆拉伸弹簧	1	B2037-372-00	NIPPER BAR BLOCK SPRING
9	409S30004	弹簧销	1	B1236-372-00	NIPPER BAR BLOCK SPRING SCREW
10	409S20012	螺钉	1	SD0402001TP	HINGE SCREW D=4 H=20
11	40927008	夹线座弹簧	1	26020404	HIPPER SLIDE BLOCK SPRING
12	40909003	夹线座	1	26020305	NIPPER BLOCK
13	409S20013	螺钉	1	SD0791506TP	SHOULDER SCREW D=7.94 H=15
14	4091300400	拨线杆组件	1	26001560	THREAD PULL OFF LEVER ASM.
15	409S20014	驱动杆轴位螺钉	1	SD0790806TP	SHOULDER SCREW D=7.94 H=8
16	4091202700	夹线杆驱动杆组件	1	26000455	NIPPER BAR ACTUATING LEVER ASM.
17	40926006	过线销子	2	26020206	THREAD GUIDE PIN
18	40926007	夹线杆底座弹簧销	1	26019406	NIPPER BAR BLOCK SPRING PIN
19	409S11014	螺钉	1	SM6040800SP	SCREW
20	40928004	垫圈	2	WP0450801SP	WASHER
21	40912029	夹线杆驱动块	1	26019307	NIPPER BAR BLOCK
22	40912030	拨线杆驱动块	1	26019208	TENSION LEVER ROCKING PIECE
23	40912031	夹线杆	1	26001909	NIPPER BAR
24	409S11014	螺钉	1	SM6040800SP	SCREW
25	4091300600	第二夹线器	1	B2019-372-0A	TENSION POST ASM NO. 2
26	409S16007	调节螺母	1	B3116-372-00	TENSION NUT
27	40912032	夹线器防松盘	1	22921407	ROTATION STOPPER
28	40927009	夹线器弹簧	1	26019901	THREAD TENSION SPRING
29	40912033	松线板	1	26020107	THREAD TENSION DISK PRESSER
30	40913007	夹线板	2	26005207	THREAD TENSION NO. 1
31	409S30006	第二夹线杆	1	B2019-372-00	TENSION POST NO. 2
32	409S16008	夹线板松线杆	1	26019802	TENSION RELEASE PIN
33	40926008	螺母	1	NM6060001CP	NUT M6
34	P03009	弹性圆柱销	1	PS0300162KH	SPRING PIN 3×16
35	409S11014	螺钉	1	SM6040800SP	SCREW
36	40928004	垫圈	1	WP0450801SP	WASHER
37	40912034	释压杆	1	26019109	THREAD TENSION RELEASING LEVER
38	4091300800	第一夹线器	1	26005157	ASSY HTREAD RENSON NO. 1
39	409S16009	调节螺母	1	B3125-012-00	THREAD TENSION NUT
40	40927010	夹线器弹簧	1	26005306	FIRST THREAD TENSION SPRING
41	40913007	夹线板	2	26005207	THREAD RENSON DISK NO. 1
42	409S30007	第一夹线杆	1	B2015-372-00	THREAD RENSON POST NO. 2
43	40913009	导线器	1	26019505	THREAD GUIDE
44	40913010	第一导线器	1	26021402	THREAD GUIDE NO. 1
45	409S16010	螺母	1	NM6040002SN	NUT M4
46	409S11013	螺钉	1	SM4061255SP	SCREW M5 L=14
47	40912035	夹线杆导架	1	40038396	NIPPER BAR BEARING BLOCK
48	409S30008	夹线杆导向轴	1	B2006-372-00	ADJUSTING SCREW
49	40928005	垫圈	1	WP0550800SP	WASHER 5.5×10×0.8
50	409S11015	螺钉	1	SM7051460TP	SCREW M6 L=12
51	409S11016	螺钉	1	SM6051400SP	SCREW
52	40927011	夹线杆拉伸弹簧	1	26019000	THREAD TENSION SPRING
53	409S30009	夹线杆拉伸弹簧销	1	B2007-372-00	NIPPER BAR SPRING SCREW
54	40928006	垫圈	1	WP0450846SP	WASHER
55	409S12002	限位螺栓	1	SM9061403CP	SCREW M6 M=14
56	409S16011	螺母	1	NM6060001SE	NUT M6
57	40913012	2号导线钩	1	SM6040600SP	THREAD GUIDE
58	40928005	垫圈	1	WP0501016SD	WASHER 5×10.5×1

## 5. 送料盘部件 FEED PLATE COMPONENTS

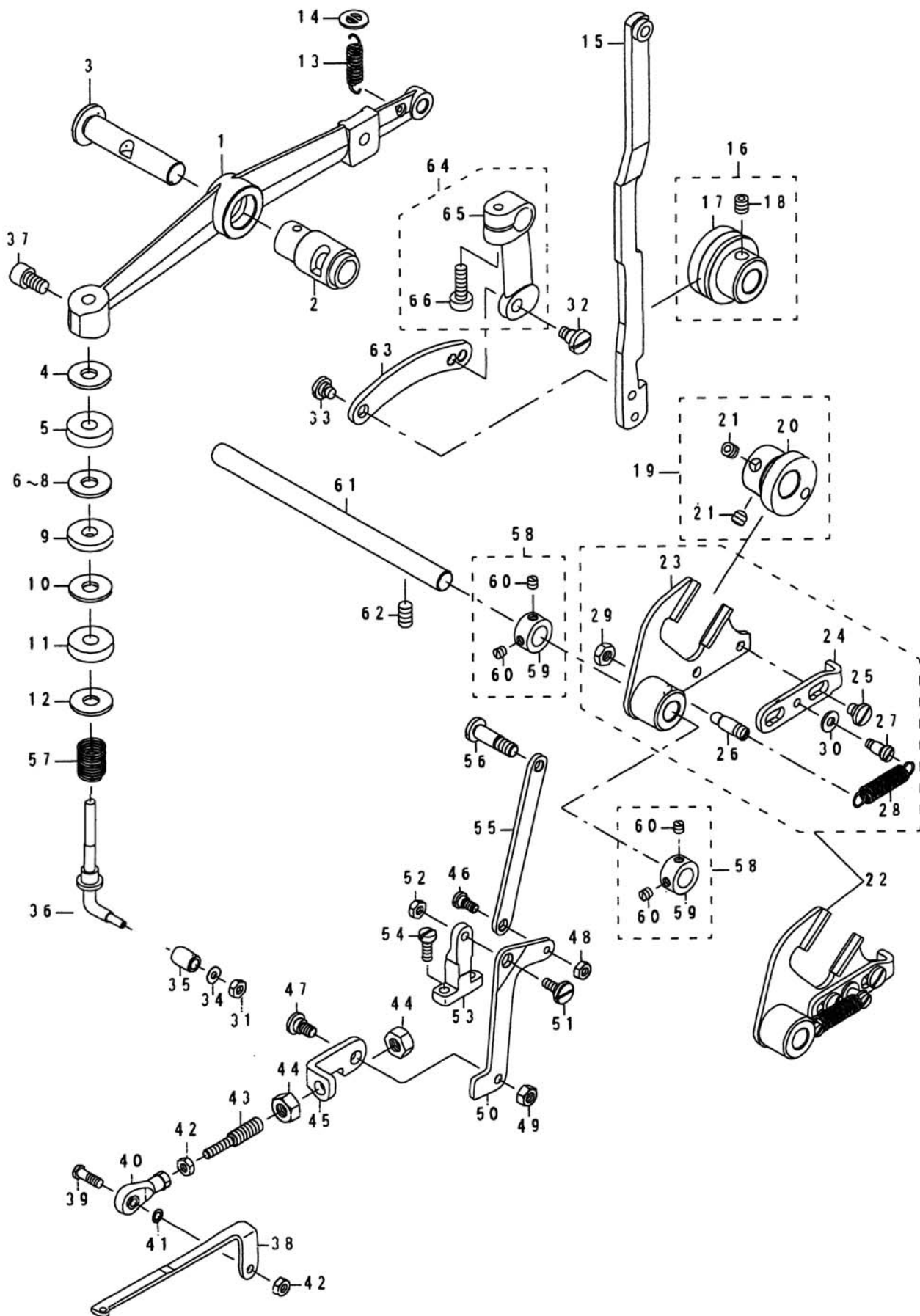




## 第五部件 送料盘部件

序号	零件件号	名称	数量	同类编号	DESCRIPTION
1	40915001	送料板	1	B2529373000	FEED PLATE SMALL BUTTON
2	409S12003	螺钉	2	SS9120643TP	SCREW 3/16-28 L=6
3	40909004	交叉送料滑块	1	26024604	INDICATOR PIN BEARING BLOCK
4	40912036	交叉送料指示板	1	26024901	CROSSWISE FEED INDICATOR
5	40903010	交叉送料轴承座	1	26024703	CROSSWISE FEED INDICATOR PIN
6	409S16012	螺母	1	NM6060001CP	NUT M=6
7	400110	滑板连接杆	1	B2518-372-00	SLIDE PLATE CONNNECTING LINK
8	409S20015	轴位螺钉	1	SD0640481SP	HING SCREW D=6.35 H=4.8
9	409S30010	双头螺栓	1	40038499	STUD
10	400111	连接杆	1	B2519-372-00	INTERMEDI CONNECTING LINK
11	40937001	交叉送料刻度盘	1	40041052	CROSSWISE FEED GRADVATED PLATE
12	409S16013	螺母	1	NM6050001SP	NUT M5
13	40903012	送料凸轮滚子	2	26023200	CAM ROLL
17	409S30019	送料凸轮滚子螺栓	2	40038496	CAM ROLL SCREW STUD
18	401S14001	螺钉	1	SM8061212TP	SCREW M6×12
19	40912040	连接杆	1	26025106	SPACER PLATE
20	40901006	送料底板	1	B252373000A	FEED PLATE
21	40909006	连接杆	1	26024208	INTERMEDI CONNECTING LINK
22	409S20015	轴位螺钉	1	SD0640481SP	HING SCREW D=6.35 H=4.8
23	409S30012	交叉送料轴位螺钉	1	40038221	HING SCREW FOR CROSSWISE FEED
24	40904003	交叉送料调节杠杆	1	40038453	CROSSWISE FEED LEVER
25	R01002	铆钉	5	B1161227000	RIVET
26	40902021	送料销	1	40041055	FEED STUD A
27	40902021	送料销	1	40041056	FEED STUD B
28	40902021	送料销	1	40041057	FEED STUD C
29	40915001	送料板	1	D2529373B00A	FEED PLATE SMALLBUTTON
30	40912068	垫圈	2	WP0501016SD	WASHER 5×10.5×1
32	××××	纵向送料滑块	1	40038439	LENGTHWISE FEED LEVER SLIDE
33	××××	左送料杠杆	1	40038432	FEED LEVER L
34	400813	左右送料杠杆组件	1	40038433	FEED LEVER R
35	40912069	送料调节导向盘	2	40041061	FEED KNOB GUIDE PLATE
36	409S12006	螺钉	1	SM9050813SE	SCREW M5×0.8 L=8
38	40912070	送料盘底座	1	40038436	PLATE BASE
39	40912082	送料刻度盘	1	40038313	GRADUATE PLATE
41	40912071	调节手柄	1	40042281	HANDLE AND INDICATOR SPRING
42	403s11027	螺钉	2	SM4040655SP	SCREW M4 L=6
43	409S11003	螺钉	2	40040965	SCREE
44	40911010	把手	1	SD0640976TP	KNOB
45	40904004	调节手柄连接杆	1	40038444	INDICATOR SPRING CONNECTING LI
46	409S20016	轴位螺钉	2	40041032	SHOULDER SCREW D=6.35 H=9.7
47	40902022	凸轮轴	1	B2506373000A	CAM SHAFT
48	40910019	纵向送料凸轮	1	26022509	LENGRHWASE FEED CAM(X)
50	40903040	凸轮轴右套	1	40041033	CAM SHAFT BUSHING LEFT
51	40910006	送料凸轮组合体	1	40041025	FEED CAM ASM.
52	40910004	送料凸轮组合体	1	SD0640486TP	FEED CAM ASM.
53	409S20035	轴位螺钉	1	SS8681412TP	SHOULDER SCREW D=6.35 H=4.8
54	401S14001	螺钉	2	40042081	SCREW 9/32-28 L=13.5
59	40903039	凸轮轴右套	1	26022400	CAM SHAFT BUSHING RIGHT
60	401S14001	螺钉	4	SS8681412TP	SCREW 9/32-28 L=13.5
61	409S11005	螺钉	1	SM6050800SP	SCREW M5 L=8
62	40923014	油毡	1	40041045	OIL RETAINING FELT
63	40923015	油毡	1	40041044	FEED SHOULDER SCREW FELT
64	40923008	油线	0.06	CQ252000000	OIL WICK
65	40923008	油线	0.06	CQ3000000F0	OIL FELT
66	40111005	扎带	4	EA9500B0100	CABLE BAND
67	40923008	油线	0.3	CQ252000000	OIL WICK

## 6. 钮钳提升机构部件 BUTTON CLAMP LIFTER COMPONENT

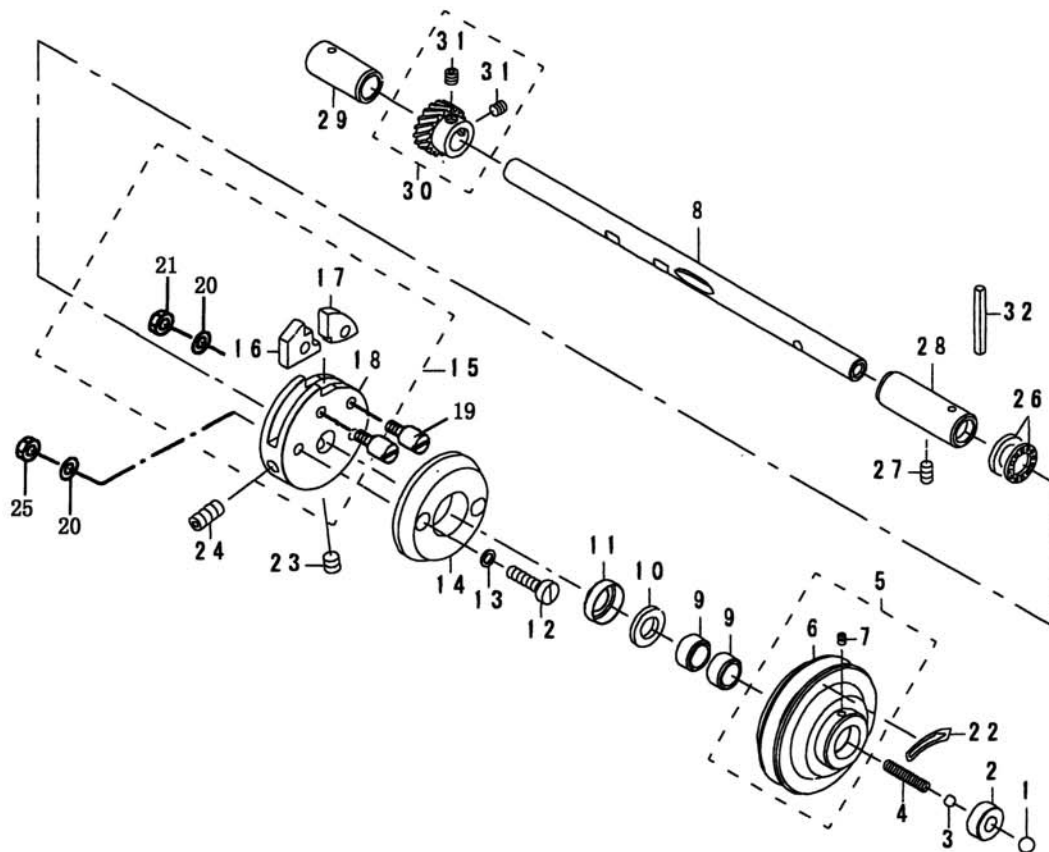


## 第六部件 钮钳提升部件

序号	零件件号	名称	数量	同类编号	DESCRIPTION
1	40901008	拾压杠杆	1	40038119	LIFTING LEVER
2	40903016	轴套	1	26018101	BUSHING
3	40902009	针棒杠杆轴	1	40038116	NDDELE BAR LEVER
4	40928014	垫圈	1	WP0851216SC	WASHER 8.5×18.0×1.2
5	40922001	橡胶垫	1	B4420373000	CUSHION
6	40928014	垫圈	1	WP0851216SC	WASHER 8.5×18.0×1.2
7	40928014	垫圈	1	WP0751576SD	WASHER 7.5×19×1.5
8	40928014	垫圈	1	10510808	WASHER
9	40928014	垫圈	1	WP0751576SD	WASHER 7.5×19×1.5
10	40928014	垫圈	1	WP0751576SD	WASHER 7.5×19×1.5
11	40922001	橡胶垫	1	B4420373000	CUSHION
12	40928014	垫圈	1	WP0703516SP	WASHER 7×20×3.5
13	40927012	弹簧	1	26033407	SPRING
14	40912032	垫圈	1	26033308	WASHER
15	40912041	钮夹提升连接杆	1	B4411372000	BUTTON CLAMP LIFTING LINK SET
16	××××	滑动滚筒	1	40040962	ASSY SLIDING ROLLER
17	40903018	滑动滚筒	1	40040953	SLIDING ROLLER
18	409S14001	螺钉	1	SM8060612TP	SCREW M6 L=6
19	××××	偏心轮	1	40038321	ECCENTRIC CAM
20	40910020	偏心轮	1	40038398	ECCENTRIC CAM
21	409S14001	螺钉	2	SM8060412TP	SCREW
22	4090902200	钮夹提升叉组件	1	40038146	BUTTON CLAMP LIFTING LINK SET
23	40909023	钮夹提升叉	1	40040966	BUTTON CLAMP LIFTING LINK
24	40912073	止动杆	1	40038149	LIFTING HOOK
25	409S11032	螺钉	2	SD0640276TP	SHOULDER SCREW D=6.35 H=2.7
26	40926012	弹簧挂销	1	40040963	TENSION SPRING RACK B
27	40926013	弹簧挂销	1	SD0500726TP	SHOULDER SCREW D=5 H=7.2
28	40927020	弹簧	1	40038150	LIFTING HOOK SPRING
29	413S16004	螺母	1	NM6050001SP	NUT M5
30	40928005	垫圈	1	WP0410846SC	WASHER
31	409S13003	螺母	1	SM6030402TP	NUT 9/64-40
32	409S20015	轴位螺钉	1	SD0640481SP	HINGE SCREW D=6.35 H=4.8
33	409S20019	轴位螺钉	1	SD0640211SP	HINGE SCREW D=6.35 H=2.1
34	40928021	垫圈	1	WP0330501SB	WASHER
35	40903032	滚珠	1	40038283	L TYPE LIFTING BAR ROLLER
36	4090201100	钮夹提升钩	1	260-00653	BUTTON CLAMP LIFTING ROD A
37	S05023	螺钉	1	SM6061002TP	SCREW M6 L=10
38	40912042	切线连杆	1	40038428	CONNECTING LINK FRONT
39	L01002	螺钉	1	26022202	JOINT STUD
40	4090500400	切线连接球体	1	B1632180000	FEED ADJUSTING JOINT
41	40928010	垫圈	1	WP0510516SD	WASHER 5.1×7.5×0.5
42	N01004	螺母	2	NM6050001SP	NUT M5
43	409S30013	双头螺栓	1	40038219	CONNECTING SCREW
44	409S16015	螺母	2	NM6080021SP	NUT M8 TYPE1
45	40912043	切线后拉杆	1	40038429	CONNECTING LINK REAR
46	409S20020	轴位螺钉	1	SD0640323TP	HINGE SCREW D=6.35 H=3.2
47	409S20021	轴位螺钉	1	SD0790402TP	HINGE SCREW D=7.94 H=4
48	409S16016	螺母	1	NS6620310SP	NUT 3/16-32
49	409S16017	螺母	1	NS6150310SP	NUT 15/64-28
50	40912044	切线杠杆	1	40038397	THREAD TRIMMING LEVER
51	409S20022	轴位螺钉	1	SD0790316TP	SHOULDER SCREW D=7.94 H=3.1
52	409S16018	螺母	1	NM6050001SP	NUT M5
53	40901009	切线杠杆座	1	40038495	THREAD TRIMMING LEVER BASE
54	409S11021	螺钉	2	SM7051460TP	SCREW M5 L=14
55	40905006	切线连杆	1	26021709	THREAD TRIMMING LINK
56	409S20023	轴位螺钉	1	SD0641322TP	HINGE SCREW D=6.35 H
57	40927013	弹簧	1	26033605	SPRING
58	××××	挡圈	2	CS0950810SH	THRUST COLLAR ASM. D=9.5 W=8
59	40908003	挡圈	1	CS0950816SH	THRUST COLLAR D=9.5 W=9
60	409S14002	螺钉	2	SS8110410TP	SCREW 11/64-40 L=3.5
61	40902023	杠杆轴	1	40038445	LEVER SHAFT
62	401S14001	螺钉	2	SM8061010TP	SCREW
63	40905003	钮夹提升连杆连接杆	1	26032508	LIFTING LINK
64	××××	钮夹提升连杆连接杆	1	40038414	LIFTING PLATE ROD ASM
65	40904001	钮夹提升连杆连接杆	1	40038413	LIFTING PLATE GUIDE ROD
66	409S11020	螺钉	1	SM6051600SP	SCREW M5 L=6

## 7. 驱针滑轮轴部件 NEEDLE DRIVING PULLEY SHAFT COMPONENTS

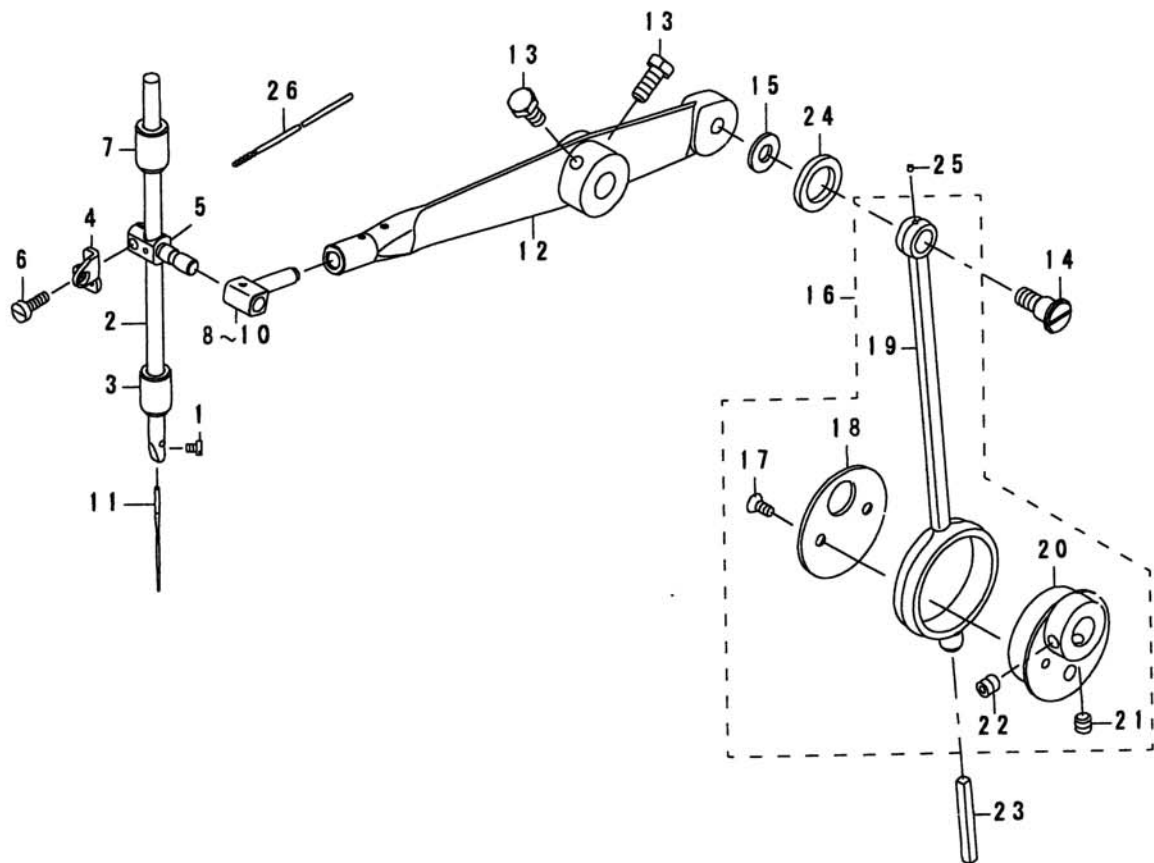
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## 第七部件 推针滑轮轴部件

序号	零件件号	名称	数量	同类编号	DESCRIPTION
1	40909011	大滚珠	1	B1203372000	BALL LARGE
2	40909012	滑轮镶套	1	26012401	PULLEY INSERT
3	40909013	小滚珠	1	B1246-372-000	BALL SMALL
4	40927014	弹簧	1	26012500	SPRING
5	××××	滑轮组件	1	B1202-372-000	DRIVING PULLEY ASM.
6	40935001	滑轮	1	B1202-372-000	DRIVING PULLEY
7	409S14002	螺钉	1	SM8040612TP	SCREW
8	40902024	滑轮轴	1	40038449	NEEDLE DRIVING PULLEY SHAFT
9	40924002	滚针轴承	2	B1243372000	NEEDLE BEARING
10	40923005	油毡	1	26012609	GRESAE RETAINING WICK
11	40912045	密封圈	1	26012708	RETAINING WASHER
12	409S11022	螺钉	2	SM6062450TP	SCREW M6 L=23.5
13	40928011	垫圈	2	WP0621026SP	WASHER 6.2×9.5×1
14	4092200200	滑轮离合器	1	B1208372000	NEEDLE DRIVING PULLEY CLUTCH D
15	4091001300	停车盘组件	1	40038137	STOP MOTION DISC ASM.
16	40909014	停车块A	1	40038135	STOP MOTION DISC LATCH A
17	40909015	停车块B	1	40038136	STOP MOTION DISC LATCH B
18	40910008	停车盘	1	40038138	STOP MOTION DISC
19	409S20024	停车块销	2	40038139	STOP MOTION PAWL SHAFT
20	××××	停车垫圈	1	40038140	STOP MOTION DISC WASHER
21	401S16002	螺母	1	SM6060550TP	SCREW M6 L=4.5
22	40937002	方向标签	1	CM500200001	DIRECTION LABEL
23	409S14009	螺钉	1	SM8080812TP	SCREW M8×8
24	409S14010	螺钉	1	SM8081752TP	SCREW M8 L=17
25	402S16003	螺母	2	NM6060003SP	NUT M6 TYPE3
26	40924001	轴承垫圈	1	B1215372B00	THRUST BALL BEARING
27	409S15002	螺钉	1	SM8061010TP	SCREW
28	40903033	滑轮轴右套	1	40038461	PULLEY SHAFT BUSHING RIGHT
29	40903034	滑轮轴左套	1	40042148	PULLEY SHAFT BUSHING LEFT
30	40925004	滑轮轴齿轮	1	B12173820BA	DRIVING GEAR (A) ASM.
31	409S14001	螺钉	2	SS88660612TP	SCREW 1/4-40 L=6
32	40923008	油线	1	26018309	OIL WICK

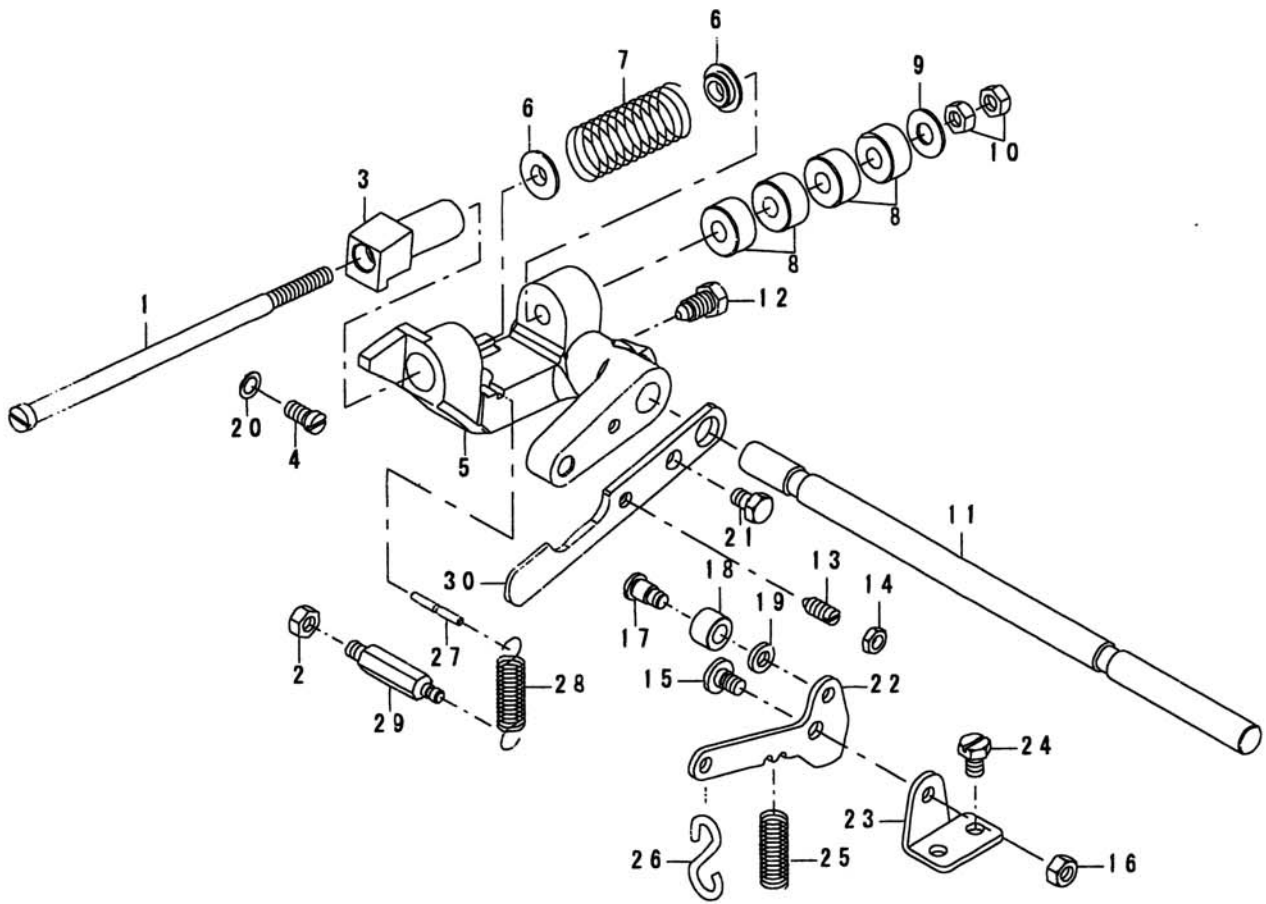
## 8. 针杆驱动部件 NEEDLE BAR DRIVING MECHANISM COMPONENTS



## 第八部件 针杆驱动机构部件

序号	零件件号	名称	数量	同类编号	DESCRIPTION
1	101S11006	螺钉	1	SS7080510TP	SCREW 1/8-44 L=4.5
2	40902027	针杆	1	14606107	NEEDLE ROD
3	40903026	针杆下套	1	26017707	NEEDLE BAR BUSHING LOWER
4	40913013	导线	1	40040951	NEEDLE BAR BALACE
5	40909016	针杆轴承杆座	1	40040952	NEEDLE BAR CLAMP
6	409S11024	螺钉	1	SM6041200SP	SCREW M4 L=12
7	40903035	针杆上套	1	40038142	NEEDLE BAR BUSHING UPPER
8	40909016	针杆轴承座	1	40038120	NEEDLE BAR SLIDE BLOCK A
9	-----	针杆轴承座	1	40038121	NEEDLE BAR SLIDE BLOCK B
10	-----	针杆轴承座	1	40038122	NEEDLE BAR SLIDE BLOCK C
11	41017001	机针	1	MTQ100B1600	NEEDLE TQ×1 #16
12	40905007	针杆杠杆	1	40038117	NEEDLE BAR DRIVING LEVER
13	L02008	螺钉	2	SM9061403CP	SCREW M6 L=14
14	409S20025	轴位螺钉	1	SD0950804TP	SHOULDER SCREW D=9.53 H=8
15	40928013	垫圈	1	26018705	WASHER
16	-----	连杆组件	1	26018457	CRANK ROD ASM.
17	409S11009	螺钉	2	SS2110920TP	SCREW 11/64-40 L=8.5
18	40912046	盖板	1	26018606	THRUST HOLDER
19	40905009	连杆	1	26018408	CRANK ROD
20	40910009	偏心轮	1	26018507	ECCENTRIC CAM
21	40910009	螺钉	1	SS8660612TP	SCREW 1/4-40 L=6
22	409S14001	螺钉	1	SS5660942TP	SCREW 1/4-40 L=8.5
23	40923008	油线	1	26018309	OIL WICK
24	40923014	油毡	1	40041045	OIL RETAINNING FELT
25	40923008	油线	0.01	CQ2500000F0	OIL WICK
26	40923008	油线	0.1	CQ202000000	OIL WICK

# 9. 停车部件 STOP MOTION MECHANISM COMPONENTS

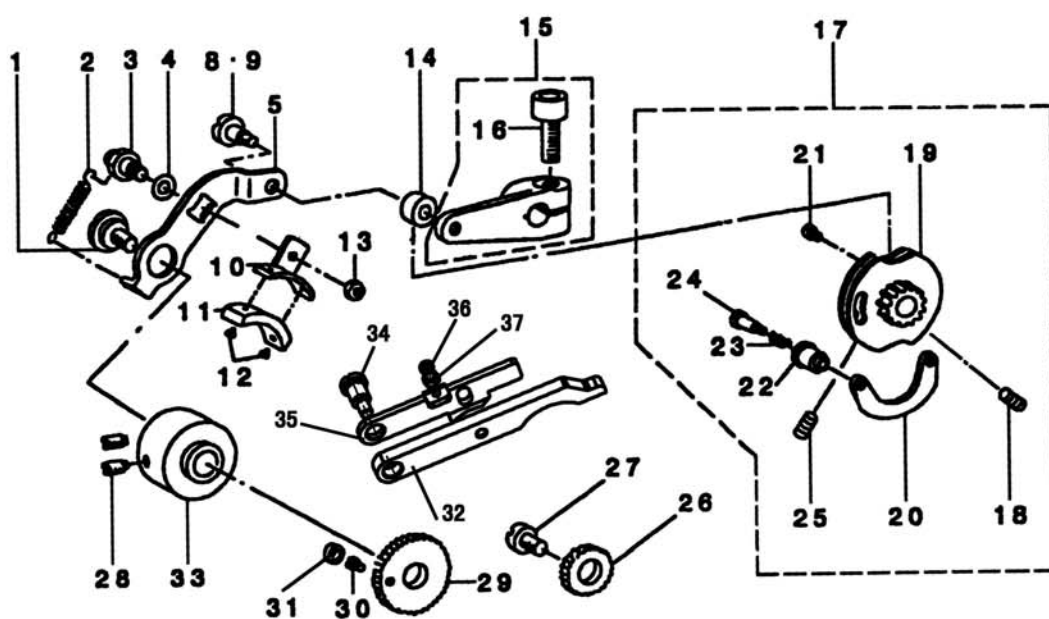




## 第九部件 止动机构部件

序号	零件件号	名称	数量	同类编号	DESCRIPTION
1	409S30014	止动杆	1	26027805	STOP MOTION PLUNGER ROD
2	402S16003	螺母	1	NM6060003SP	NUT M6 TYPE3
3	40909025	止动块	1	40038118	CROSSING HOOK
4	409S11025	螺钉	1	SM6061150TP	SCREW M6 L=11
5	40901010	止动座	1	B2602372000A	STOP MOTION PLUNGER LEVER
6	40928014	垫圈	2	26229104	WASHER
7	40927019	弹簧	1	40038110	STOP MOTION SPRING
8	40922004	橡胶垫圈	4	B2608280000	RUBBER CUSHION
9	40928022	垫圈	1	26030601	WASHER
10	409S16021	螺母	2	NS6680410SP	NUT 9/32-28
11	40902025	止动杆轴	1	40038448	STOP MOTION SHAFT
12	409S12006	螺栓	1	40042437	SCREW
13	409S15009	螺钉	1	SS8151570SP	SCREW 15/64-28 L=15.0
14	402S16003	螺母	1	NS6150310SP	NUT 15/64-28
15	409S20034	螺钉	1	SD0680276TP	SHOULDER SCREW D=6.8 H=12.7
16	413S16005	螺母	1	NM6060001CP	NUT M6
17	409S20033	轴位螺钉	1	SD0710706TP	SHOULDER SCREW D=7.14 H=7
18	40903036	滚珠	1	26029207	STITCH ADJUSTING ROLLER
19	40912075	垫圈	1	WP0612066SP	WASHER 6.1×11×2
20	40912076	垫圈	1	26019604	WASHER
21	409S20026	螺钉	1	SM9061003CP	SCREW M6 L=10
22	40912078	启动控制杆	1	40038160	STOP MOTION TRIP LEVER
23	40912079	启动控制杆座	1	26028308	STOP MOTION TRIP LEVER BRACKET
24	409S12005	螺栓	2	SM9061250TP	SCREW M6 L=10
25	40927015	弹簧	1	22924906	OIL REGULATOR SCREW SPRING
26	40931001	挂钩	1	13160304	S SHAPED HOOK
27	40926011	弹簧挂销	1	26028001	STOP MOTION LEVER SPRING PIN
28	40927016	弹簧	1	40038410	STOP MOTION LEVER SPRING
29	409S30015	弹簧挂销	1	40040940	SCREW STUD
30	40912049	停车压力杆	1	B2611373N00	PRESSURE APPLYING LEVER

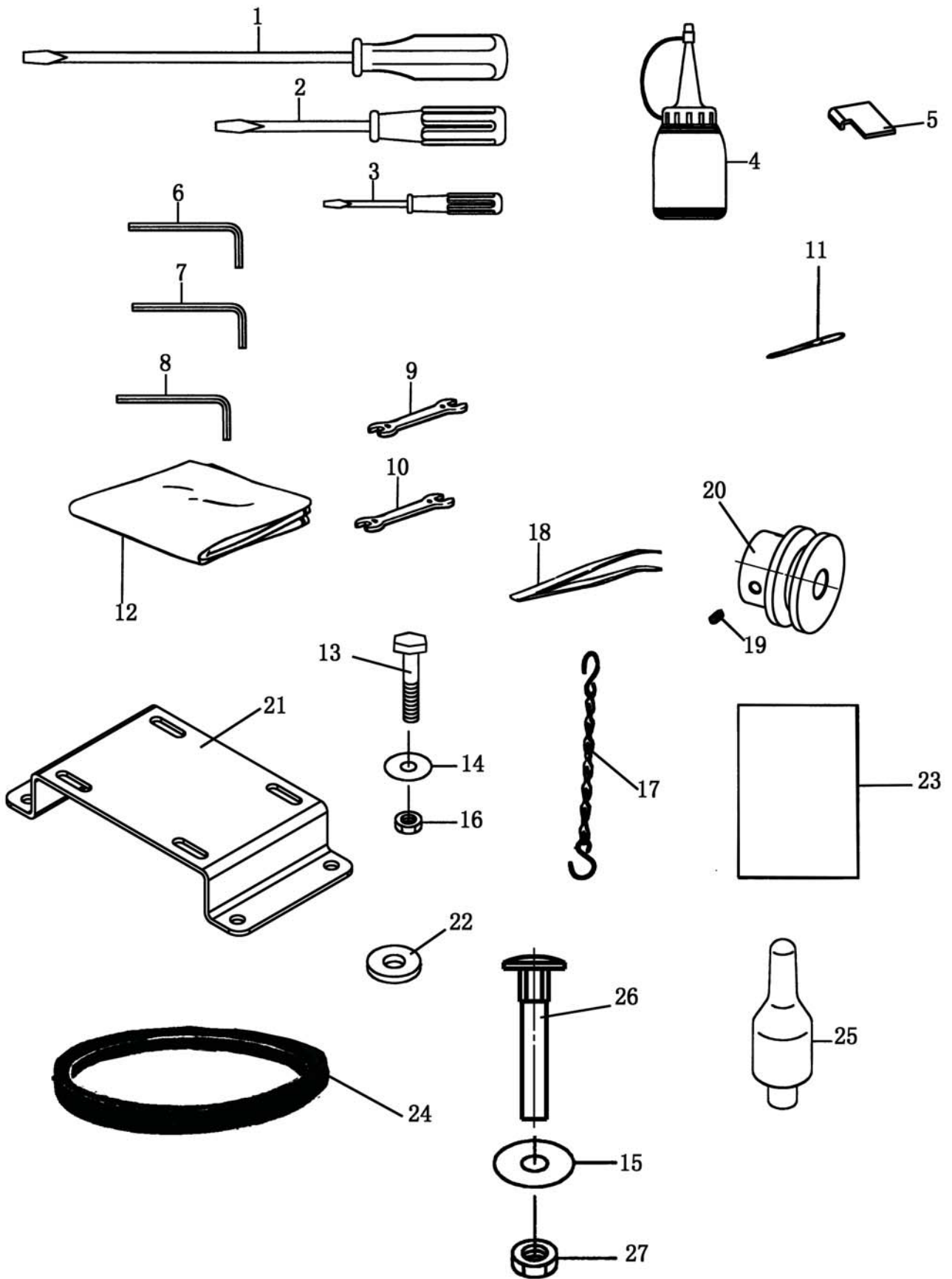
# 10. 选线部件    Stitch selecting parts components



## 第十 部件 选线部件

序号	零件件号	名称	数量	同类编号	DESCRIPTION
1	409S20028	螺钉	1	SD-1127321-S	HINGE SCREW D=12.7 H=3.2
2	40927017	弹簧	1	B2643-372-00	SPRING FOR FRICTION PLATE
3	40902016	螺钉	1	B2638-372-00	FRICTION PLATE ROTATING SHAFT
4	40928015	垫圈	1	WP-0850002-S	WASHER 8.5×18×1.6
5	40912050	减速杆	1	B2636-372-00	SPEED SLOWING LEVER
8	409S20029	螺钉	1	SD-0791331-S	HINGE SCREW D=7.94 H=13.3
10	40912051	摩擦片座	1	B2639-372-00	FRICTION PLATE HOLDER
11	40912052	减速摩擦片	1	B2640-372-00	SPEED SLOWING FRICTION PLATE
12	R01001	铆钉	2	B3211-232-00	POSITIONING PIN
13	409S16023	螺母	1	NS-6110310-S	NUT 11/64-40
14	40903028	止动凸轮滚碾	1	B2619-372-00	STOP MOTION TRIPPING LEVER CAM
15	40904002	止动分离杆	1	B2618-372-0A	STOP MOTION TRIPPING LEVER ASM
16	S05022	螺钉	1	SM-6082502-T	SCREW M8 L=25
17	40910010	止动凸轮	1	B2621-372-0B	STOP MOTION CAM ASM.
18	401S14001	螺钉	2	SS-8150912-T	SCREW 15/64-28 L=9
19	40910011	止动凸轮	1	××××	STOP MOTION CAM SHOE
20	40912053	止动凸轮底板	1	××××	STOP MOTION CAM SHOE
21	409S20030	螺钉	1	××××	SCREW FOR STOP MOTION CAM SHOE
22	40903029	止动凸轮旋钮	1	××××	STOP MOTION CAM KNOB
23	40927018	弹簧	1	××××	SPRING
24	409S20031	螺钉	1	××××	HINGE SCREW D=4.8 H=14.5
25	401S14001	螺钉	1	SS-8150912-T	HINGE SCREW D=7.94 H=4.3
26	40925007	选线齿轮	1	B2629-372-00	STITCH SELECTING SPUR GEAR MI
27	409S11026	齿轮轴	1	B2628-372-00	INTERMDIATE GEAR SHAFT
28	401S14001	螺钉	2	SS-8150912-T	SCREW 15/64-28 L=10.5
29	40925008	选线齿轮	1	B2630-372-00	GEAR, LAGRE
30	409S11027	螺钉	1	B2631-372-00	SCREW
31	40903030	滚圈	1	B2632-372-00	ROLL
32	40912056	选线杆	1	××××	STITCH ADJUSTING LEVER
33	40910012	减速摩擦轮	1	××××	SPEED SLOWING FRICTION WHEEL
34	409S20032	轴位螺钉	1	××××	HINGE SCREW D=7.94 H=9.1
35	40912057	调整板	1	××××	ADJUSTING PLATE
36	409S11030	螺钉	1	××××	SCREW
37	409S16024	螺母	2	××××	NUT 1/8-40

# 11. 附件组件 ACCESSORY PARTS COMPONENTS



## 第十一部分 附件组件

序号	零件件号	名称	数量	同类编号	DESCRIPTION
1	10131002	螺丝刀（大）	1	----	SCREW DRIVER LARGE
2	10131003	螺丝刀（中）	1	----	SCREW DRIVER MIDDLE
3	10131004	螺丝刀（小）	1	----	SCREW DRIVER SMALL
4	20131038	小油壶（尖嘴）	1	----	OILER
5	40931019	定位尺	1	----	GAUGE
6	30131010	内六角扳手（3mm）	1	----	INNER WERNCH 3mm
7	30131012	内六角扳手（4mm）	1	----	INNER WERNCH 4mm
8	20131047	内六角扳手（5mm）	1	----	INNER WERNCH 5mm
9	30131006	扳手（8mm~10mm）	1	----	Wrench 8mm~10mm
10	40931025	扳手（9mm-11mm）	1	----	Wrench 9mm~11mm
11	41017004	TQ*7 16#机针	3	----	NEEDLE TQ×7#16-12
12	10131005	机头罩	1	----	MACHINE COVER
13	40931009	M6×70螺钉	4	----	SCREW M6 L=70
14	40128013	垫圈6.2×13×1	4	----	WASHER 6.2×13×1
15	W01018	垫圈10	4	----	WASHER
16	N01007	螺母M6	4	----	NUT M6
17	20131054	脚踏板链	1	----	CHAIN
18	20131051	镊子	1	----	TWEEZERS
19	S10010	螺钉M5X10	1	----	SCREW M5 L=10
20	40931003	电机飞轮	1	----	MOTOR PULLEY (FOR 50HZ)
21	40931007	电机座	2	----	MOTOR BASE
22	40931008	电机座垫	4	----	MOTOR BASE CUSHION
23	40931028	说明书	1	----	INSTRUCTION MANUAL & PARTS LIST
24	40931004	710型皮带	1	----	BELT
25	40311002	支撑棒	1	----	SUPPORT
26	40931011	马达螺钉	3	----	MOTOR SCREW
27	401S16018	马达固定螺母M8	3	----	NUT M8