



JK-K4-D

产品使用说明书&产品零件图册  
Manual book & parts book

**JACK 杰克**

# JACK

## K4-D系列使用说明

## K4-D 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

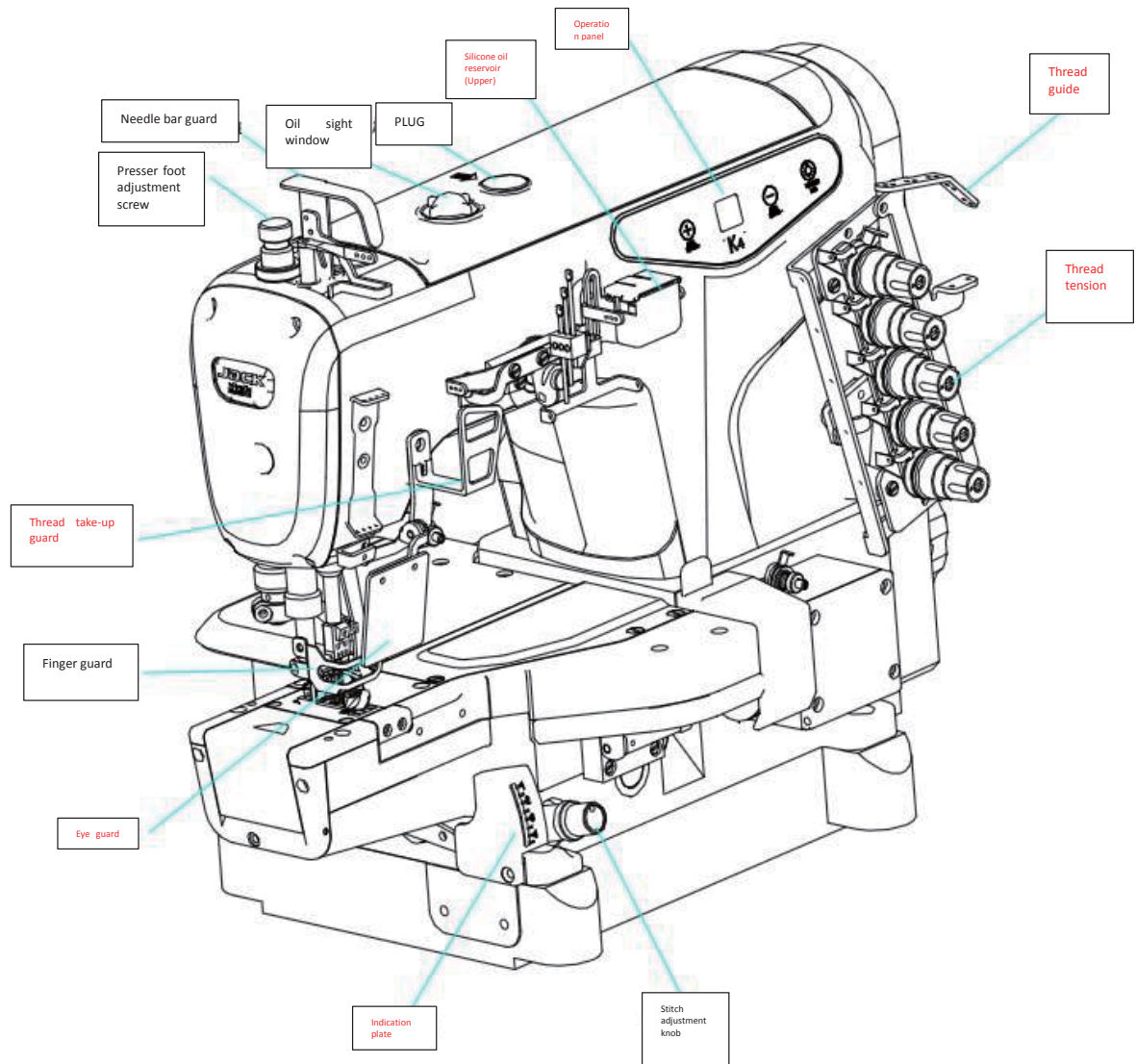


Figure2-1

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

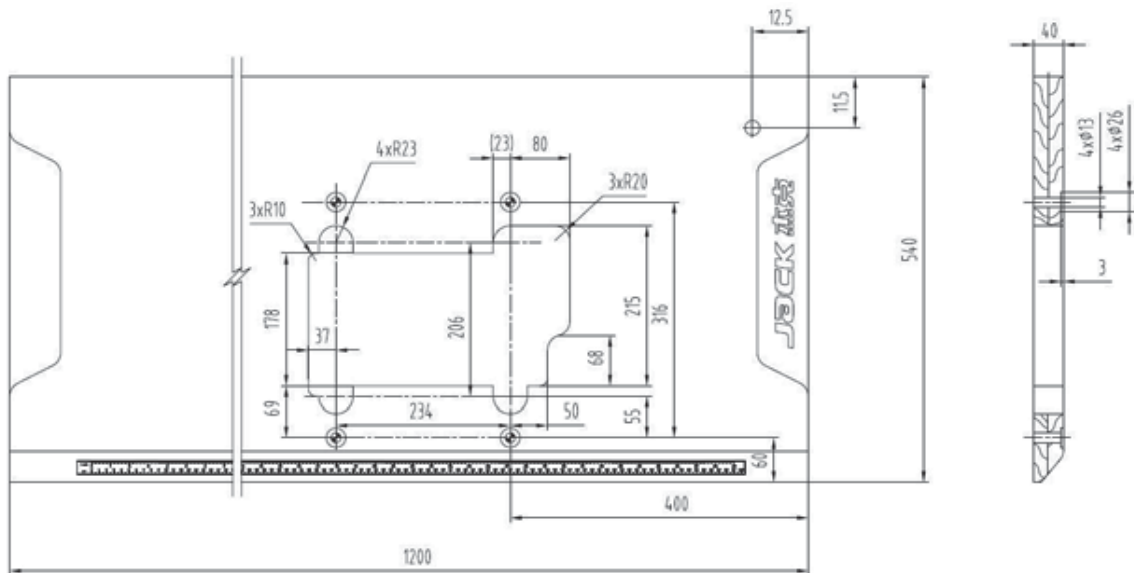


图 3-1

#### 2、链条的安装

##### 2. the installation of the chain

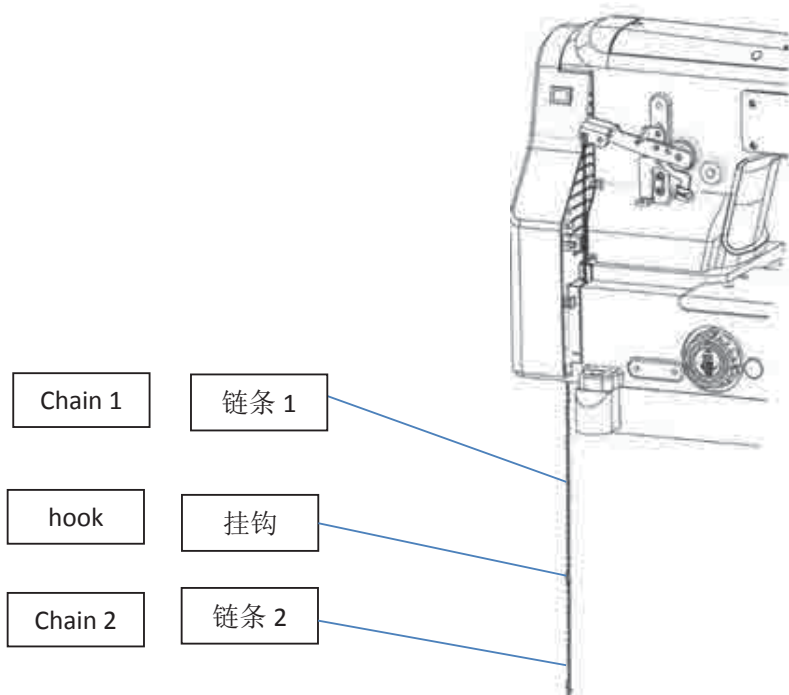


图 3-2

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.

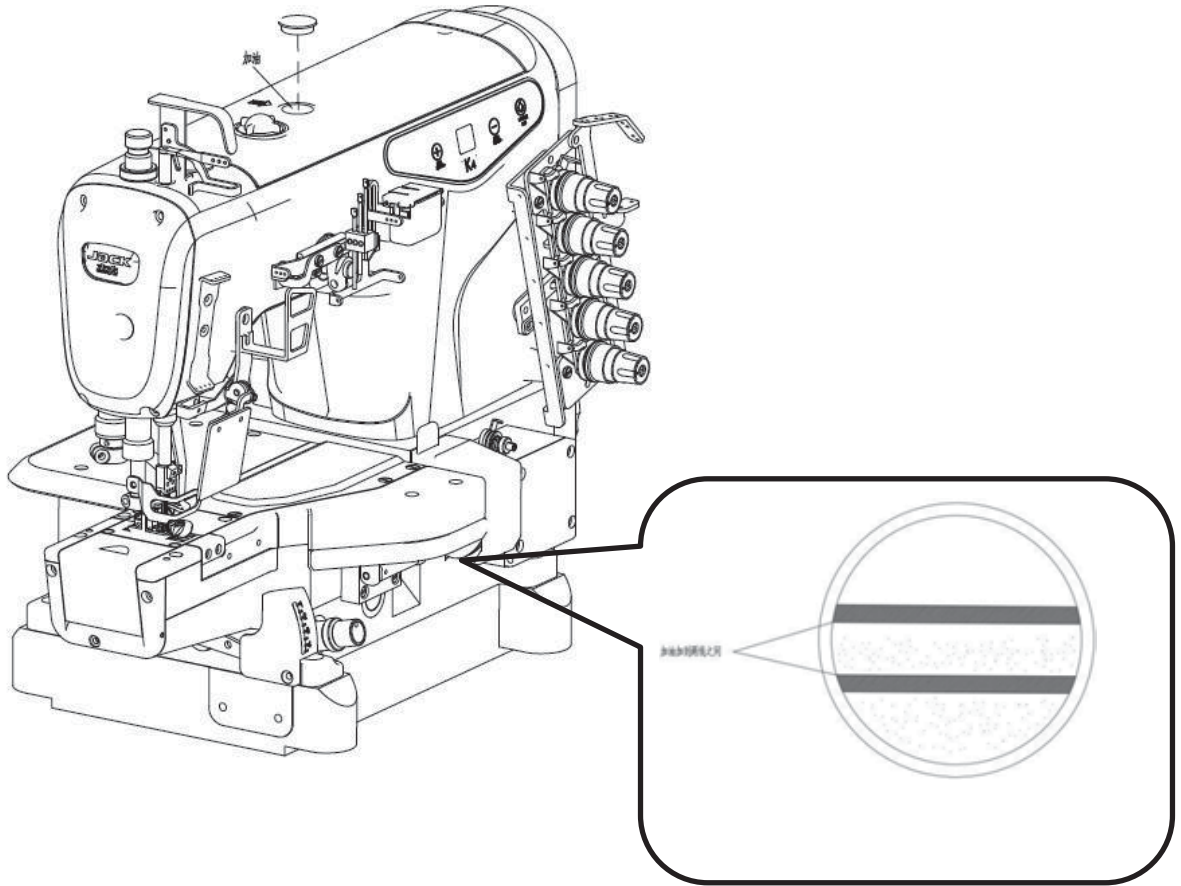


图4-1

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！

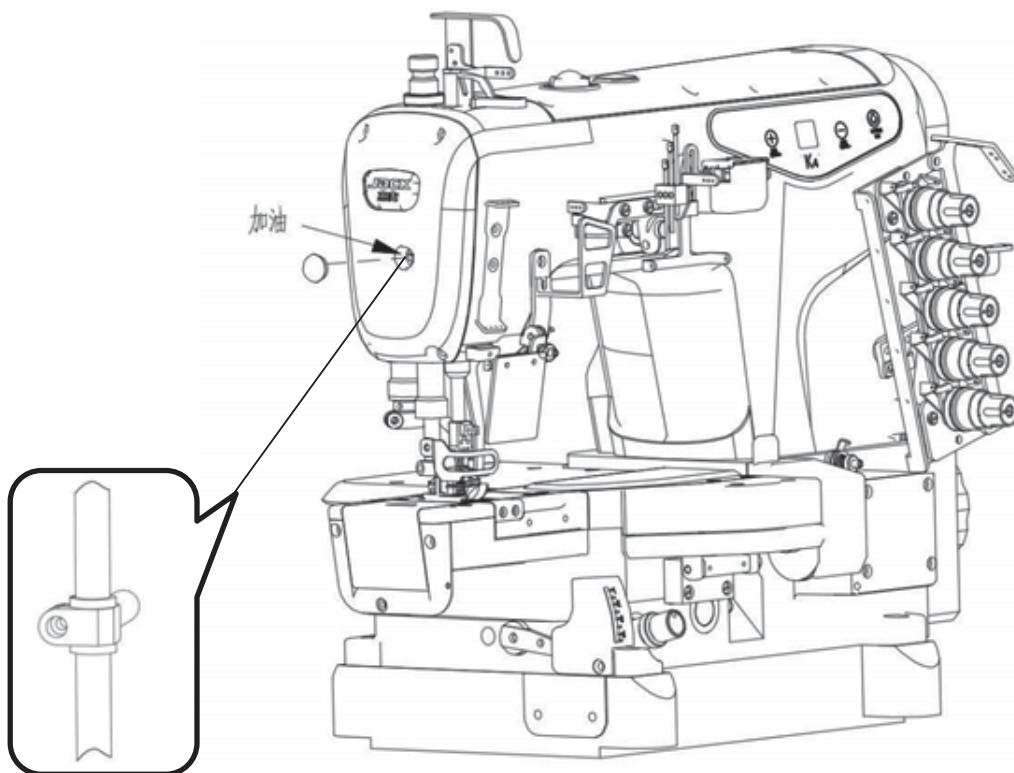
Note: In order to prevent personal accident caused by the sudden start of the machine, please turn off the power, make sure the motor does stop turning and then operate!

## 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.

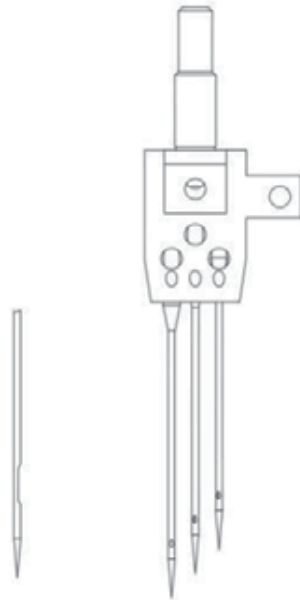


图 5-1

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:

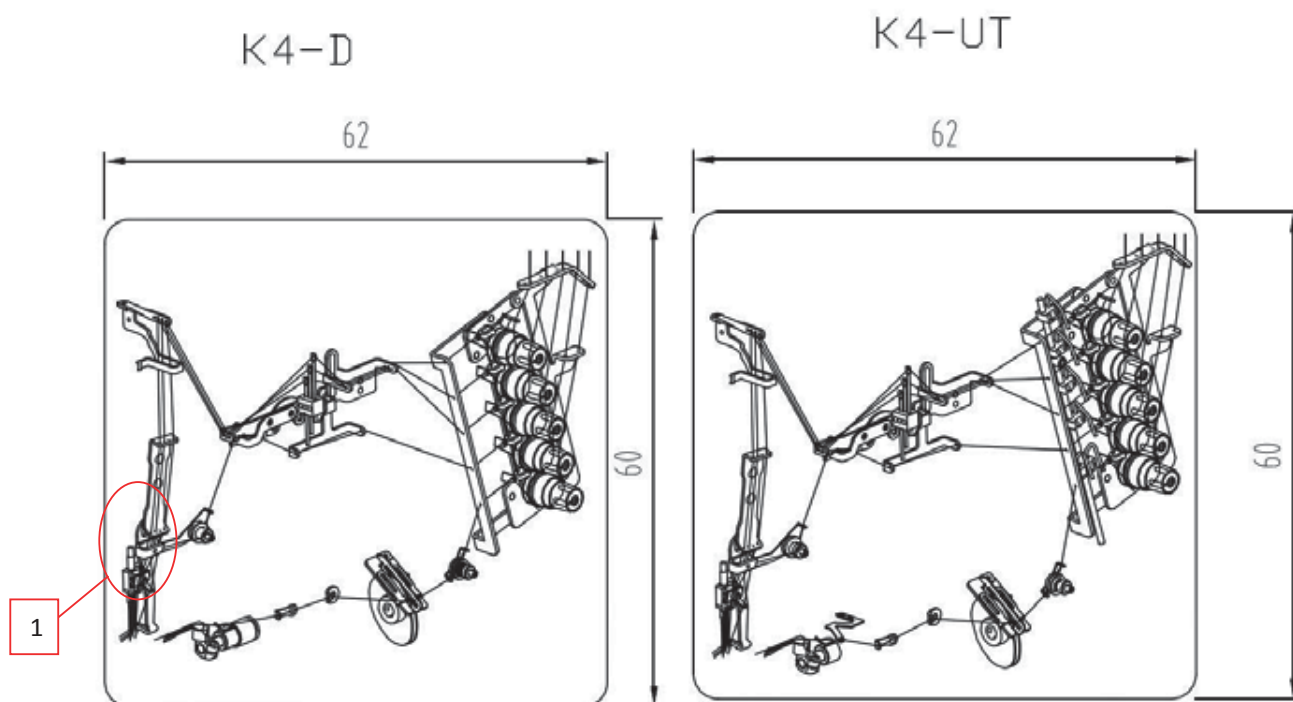


图 5-2

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

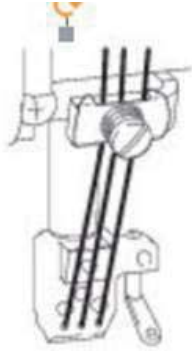


figure5-3

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

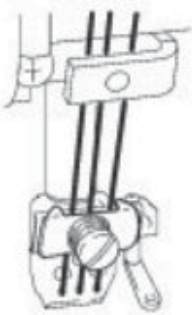


figure5-4

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.

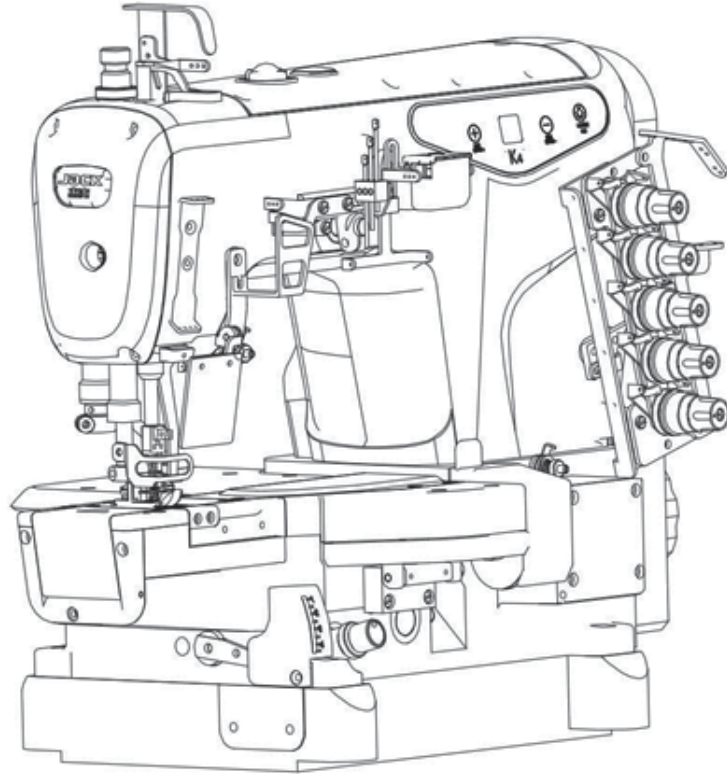


图 5-5 Figure 5-5

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.

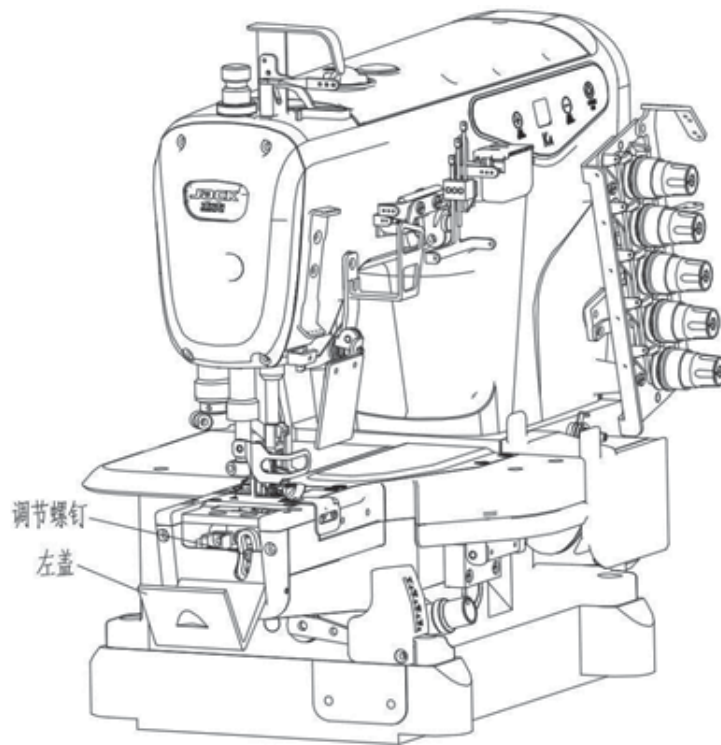


图 5-6 Figure 5-6

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.

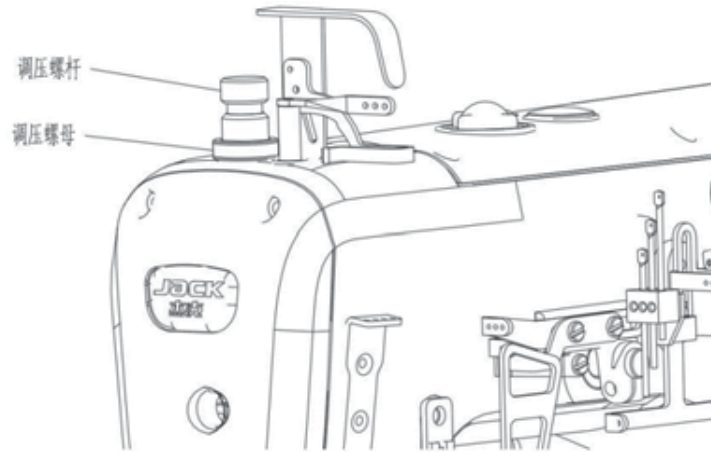


图 5-7 Figure 5-7

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.

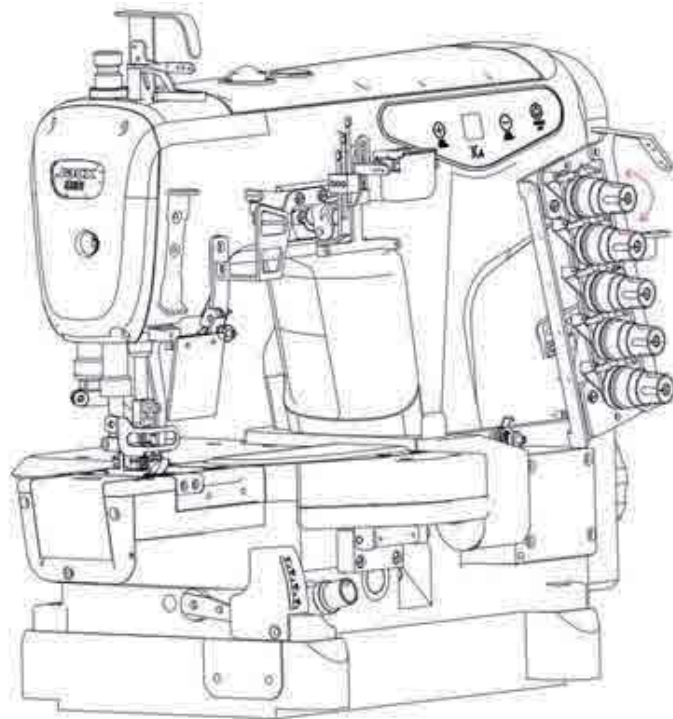


图 5-8 Figure 5-8

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.

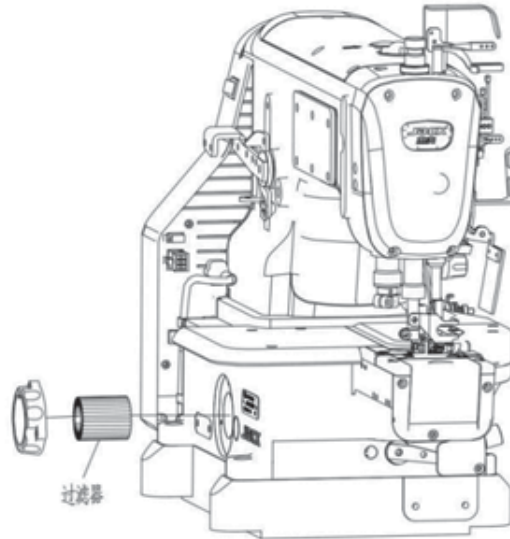


图 5-9 Figure 5-9



## 六、电控操作 Six Electric control box operation

### 1、K4-D 电控操作 K4-D Electric control box operation

#### Instructions of K4 Interlock sewing machine panel operation

本控制器使用双位数码管显示实现参数调整。在 P 主界面，第一个数码管显示“P”，第二个数码管显示当前设定的停针位置，上、下停针如图所示（图 1）。

In P interface, the first digit display “P”, the second digit display shows the current needle position, picture 1 shows the upper and lower needle position.



图 1 上、下停针显示界面

In figure 1, upper and down needle position display interface

#### 1.转速的修改 Modify speed

在待机 P 界面按+键或者-键，显示当前转速，按▲键速度递增 100RPM（数值递增 1），按▼键速度递减 100RPM（数值递减 1），长按▲键（▼键）可实现快速递增（递减），停止按▲键或者▼键后约 3 秒，自动保存设定的速度参数，并回退到 P 界面。

The panel shows “P”. Then press ▲ or ▼ to adjust speed up and down, short-press ▲ or ▼ to adjust speed up 100RPM and down 100RPM, long-press ▲ (▼) speed rapidly up (down). After 3 seconds, the parameter saved and the panel back to the “P” .

#### 2.停针位修改 Needle Position Adjust

在 P 界面下，长按▲键约 3 秒不松开，可以调节上下停针位。

The panel shows “P”, press ▲ for 3 seconds, then set the position up or down.

#### 3.恢复出厂设置 Factory reset

在 P 界面，长按▼键 3 秒，参数将恢复出厂设置。（J4、J5、J6 的监控数据除外）

In the P interface, long ▼ button for 3 seconds, parameter will restore factory Settings.(J4, J5, except for the monitoring data of J6)

4.操作参数说明表 Parameter description

序号 NO.	参数定义 parameter	范围 range	默认 值 Default	参数说明 Description
<p>在 P 界面，长按▲和▼组合键 3s，可进入技术员界面，并显示 F The panel shows "P", press ▲ and ▼ for 3 seconds, inter engineers interface, and it shows "F"</p>				
K	机头灯亮度调节 LED light adjustment	0 - 3	2	0 : 灭 off 1~3 : 亮度 1~3 level 1~3
L	缝纫限制速 Speed limitation	05 - 55	50	以 500rpm 为单位递减 Decline by 500rpm every time
M	停针位开关 needle position function	0 - 1	1	0 : 关闭 off    1 : 开启 on
H	休眠时间 Dormancy time	0 - 6	3	0 : 关闭 off    unit : 10min
V	速度显示使能 Speed display	0 - 1	0	0 : 关闭 off    1 : 开启 on
<p>在 F 界面，长按▼键 3s，进入监控参数，并显示 J The panel shows "P", press ▼ for 3 seconds, inter monitoring parameter, and it shows "J"</p>				
J1	实时速度 Real-time Speed	显示的数×100=实际速度 the showing number multiples by 100 equal to the real speed.		
J2	实时功率 Real-time Power	显示的数×10=实际功率 the showing number multiples by 10 equal to the real power.		
J3	输入电压 Input Voltage	显示的数×10=实际电压 the showing number multiples by 10 equal to the		

		real voltage.
J4	历史电压 Historical Voltage	显示历史输入最低电压和最高电压 Display the historical lowest input voltage and highest input voltage.
J5	历史错误代码 Historical Error	显示最新的 5 个错误代码 Display historical error code(only show the latest 5 ).
J6	累计运行时间 Cumulative Running Time	显示的数×100=实际时间 ( Hour ) the showing number multiples by 10 equal to the real time(hour).

### 5.错误码说明表 Error code description

错误 Error code	内容 Reasons	对策 Solutions
E1	电机堵转 Motor stuck	<p>请转动手轮检查机头是否卡住或者干涩转动困难；请检查电机插件是否松动或者脱落；请检查加工物料是否过厚，电机因扭力不足而无法贯穿；请检查机器是否缺少润滑油。</p> <p>The motor run out of load capacity, please reduce the load capacity for the motor and then restart the motor;</p> <p>Please check if the plug of motor loose or drop;</p> <p>Please check if the sewing material is too heavy;</p> <p>Please check if the machine needs lubrication.</p>
E2	软件过流 software over-current	<p>请关电后重新上电，如果不能消除报警，请检查：电机负荷过大，请减轻负荷后重启电机；Motor used too much, Restart machine after several minutes, then please check if the fabric much too heavy.</p>
E3	参数保存异常	<p>出现此种状况，需要关闭电源，稍后再打开电源开关即可；恢复出厂设置（长按▼键约 3s 不松开）；</p>

	Parameter save abnormal	若重启或者恢复出厂设置后也不能解决，建议联系经销商解决。Restart machine after several minutes or reset machine(press ▼3s); If the problem unsolved, please contact dealers.
E4	电机霍尔信号异常 Hall of the motor with problem	请检查电机编码器插头连接是否可靠，编码器信号线是否有断线，插针是否退出或者变形。Please check if the 10 core line connect well or not, please check if the connect line of hall is well or not.
E5	定位器信号异常 The synchronizer signal	请检查定位器是否连接电控；请检查上下定位信号是否正常。 Forget to insert the synchronizer cable before turn on the machine To check the both up needle position signal and the down needle position signal is working.
E6	调速器异常 Speed governor abnormal	请检查压脚机构是否回到正确位置，压脚安全开关是否损坏，插座是否正常。To check if the presser foot back to the correct position or not , to check if the safety switch button is damaged or not, the outlet is abnormal or not.
E7	电流检测电路故障 Current detection and circuit fault	请检查电路板是否干净整洁；请检测电源电压是否正常；请等待电源重新开启/复位（请仔细检查电源板各项机能）。Please check whether the circuit board is clean; Please check whether the power voltage is normal; Please wait after restarting the power or reset(please carefully check each function of the power board).
EA	硬件过流 Hardware over-current	请关电后重新上电；请检查供电电压是否正常；请尝试恢复出厂设置。Please switch off the power and restart;Please check whether the supply voltage is normal; Please try to restore factory defaults.

Eb	系统过电压 System over-voltage	立即切断电源，并检查供电电压是否过高，如果是，请调整供电电压到额定电压后再开机工作(额定电压：220V)。Immediately switch off the power, and check whether the supply voltage is too high, if yes, please adjust the rated voltage, then start to work(rated voltage:220v).
EC	系统欠电压 System under-voltage	请检查供电电压是否正常；请等待电源重新开启/复位(请仔细检查电源板各项机能)。Mean the voltage abnormal, please check if the voltage is normal or not; Means waiting for the power, and need to restart again or recover to the factory reset.
Ed	刹车电阻保护 Brake resistor protection	请检查刹车电阻插头是否松动或脱落；请检查供电电压是否正常；请尝试恢复出厂设置或将电源重启；Please check whether the plug of brake resistor is loose or drop off;Please check whether the supply voltage is normal;Please try to restore factory defaults or restart.

## 、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

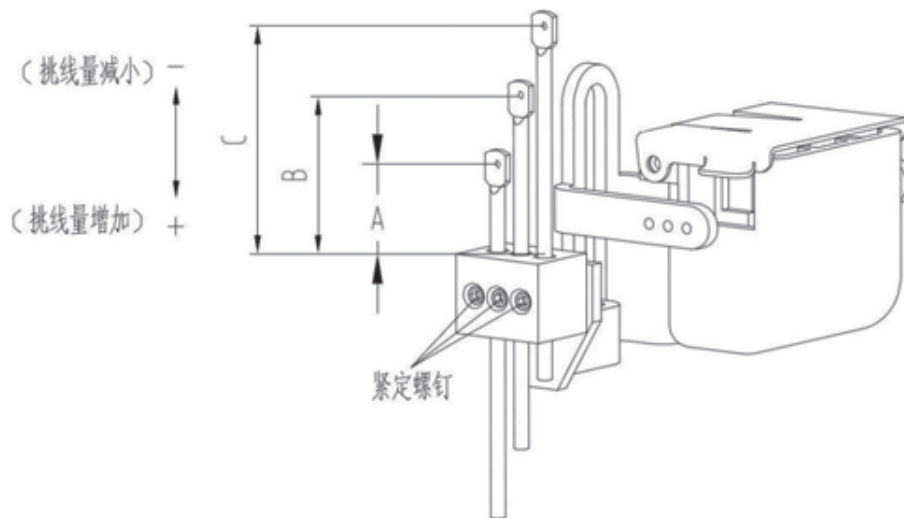


Figure 7-1

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.



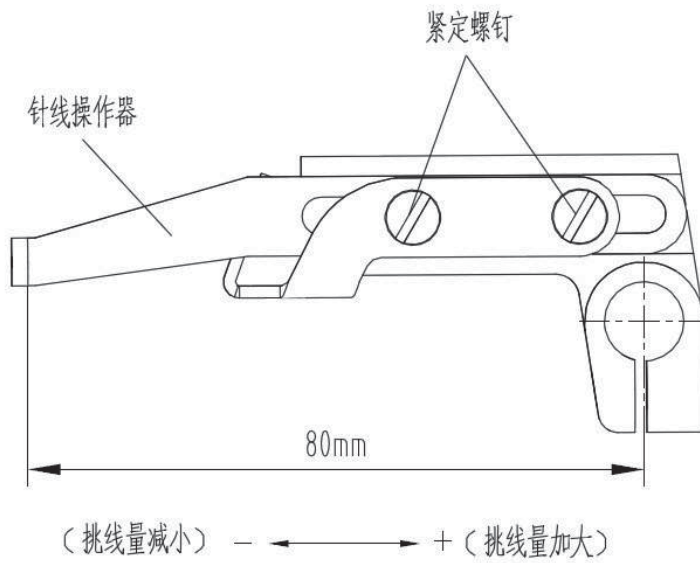


Figure8-2

### 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 ) 。

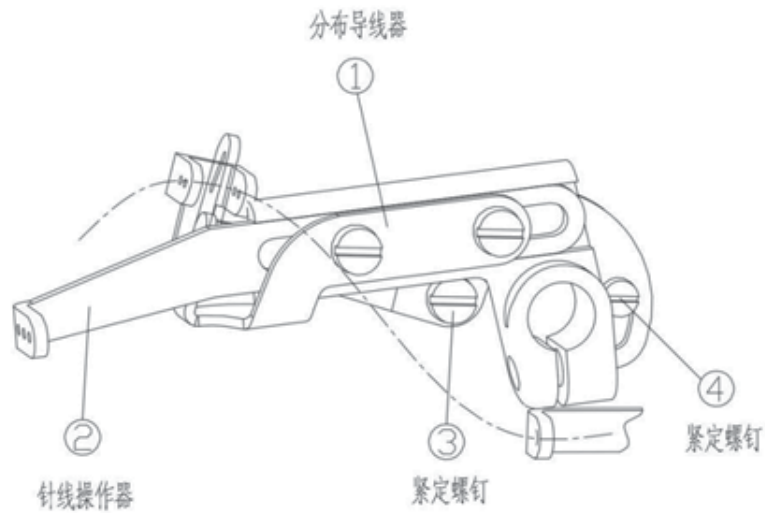


Figure 8-3

#### 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.

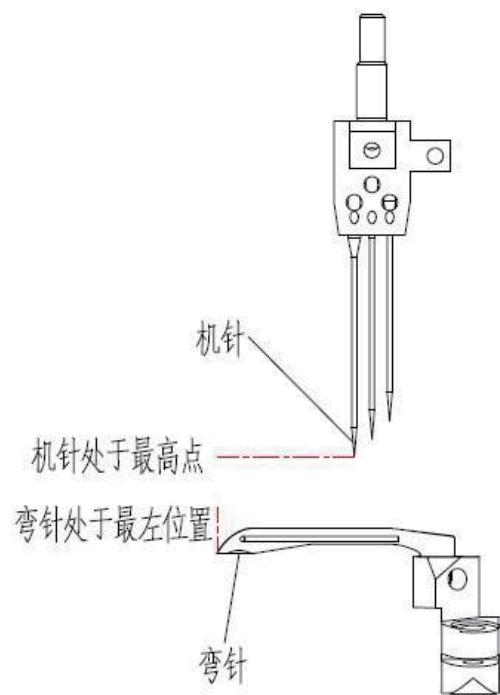


图8-4

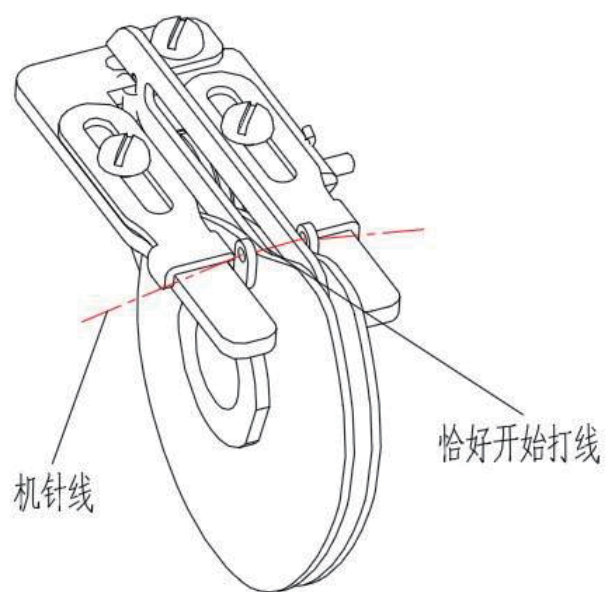


图5

## 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.

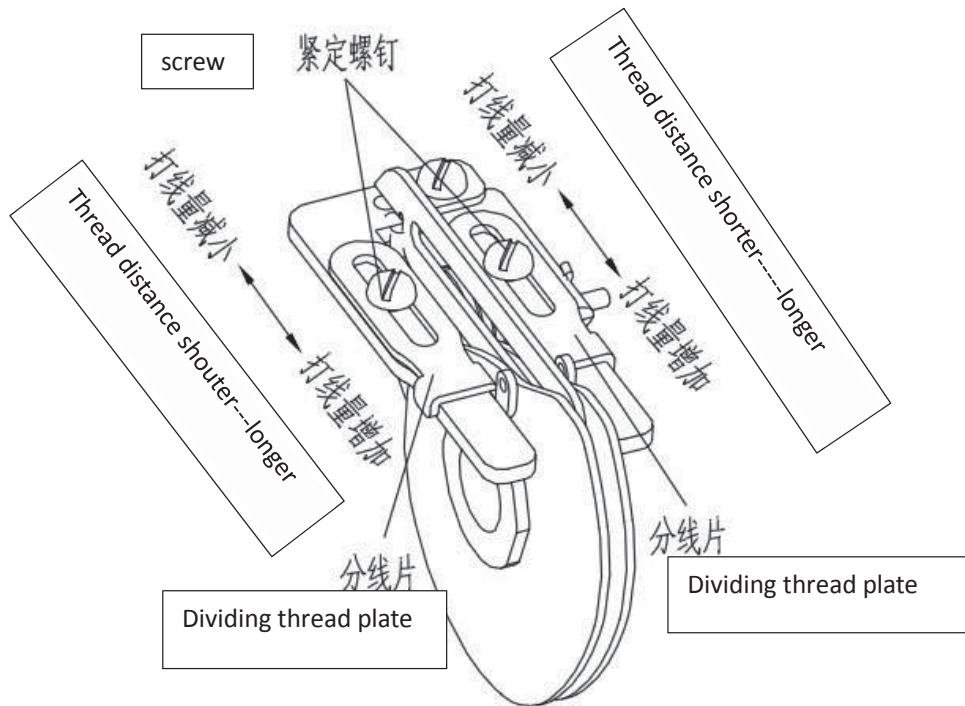


图6(Picture 6)

## 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

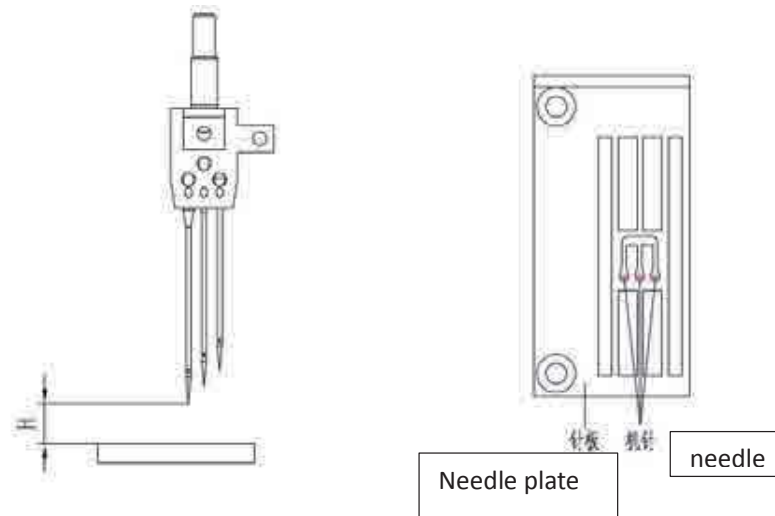


图7(picture 7)

## 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

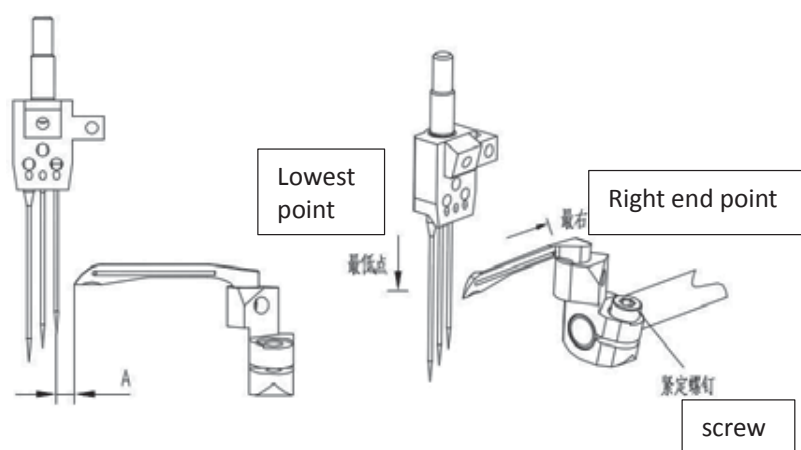


图8(Picture 8)

## 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) .

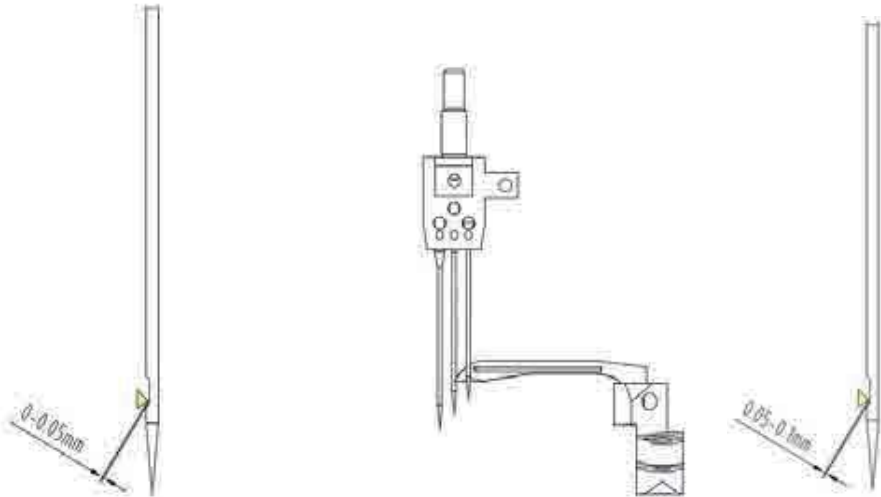


图9 Picture 9

#### 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).



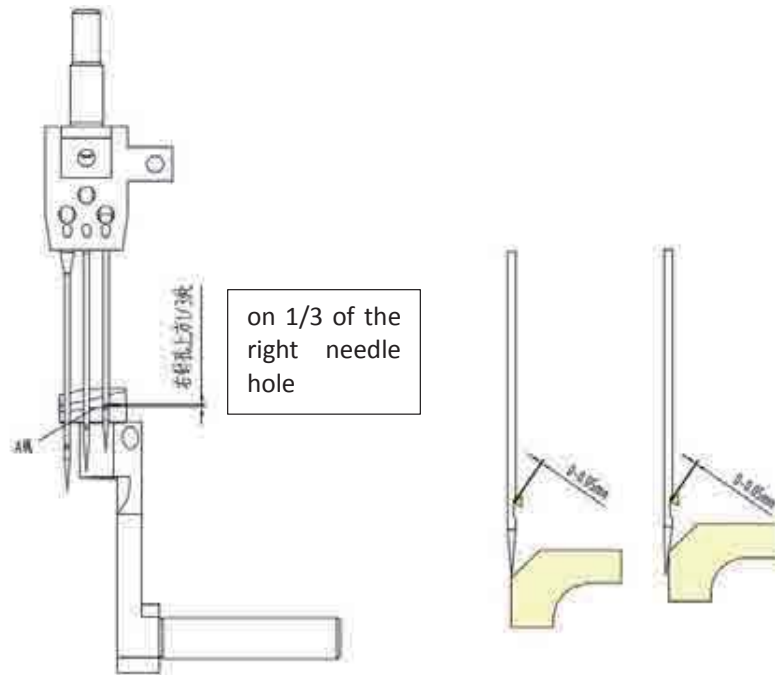


图10 picture 10

### 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.

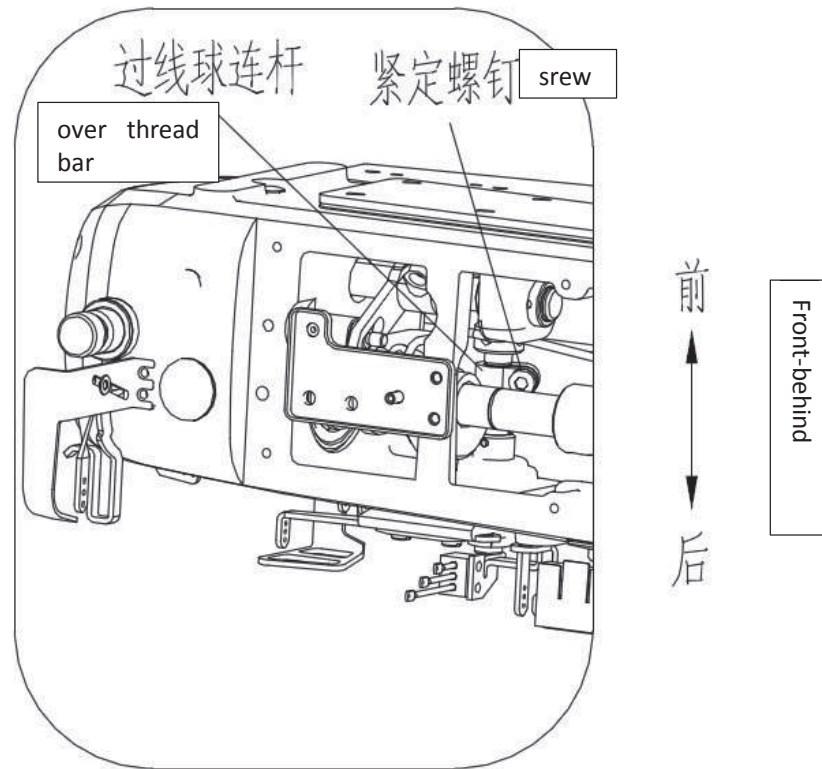


图11 (Picture 11)

### 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.

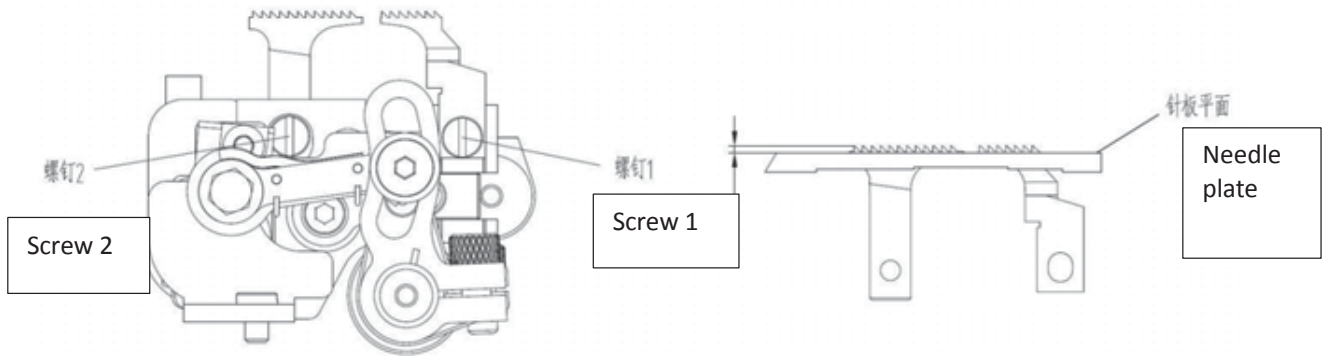


图12 picture12

#### 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

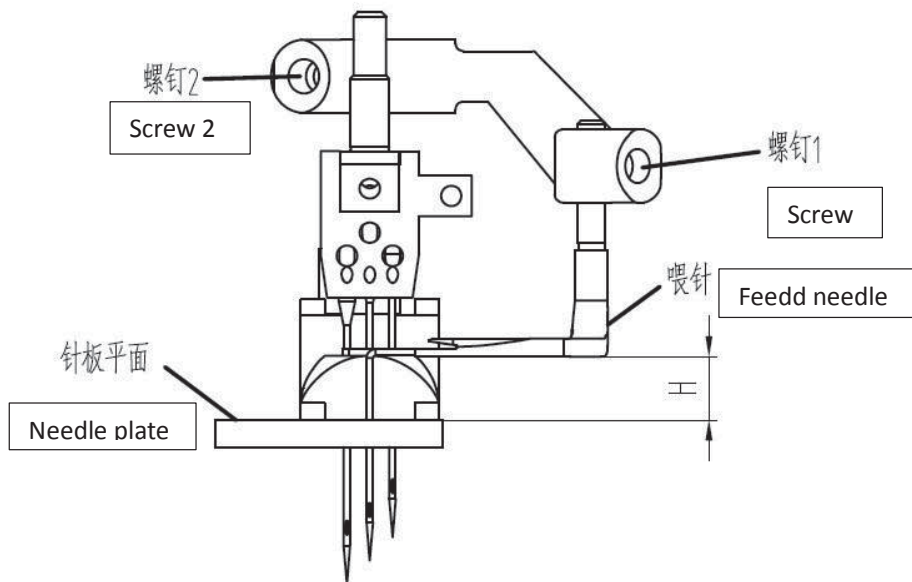


图13(Picture 13)

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

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.

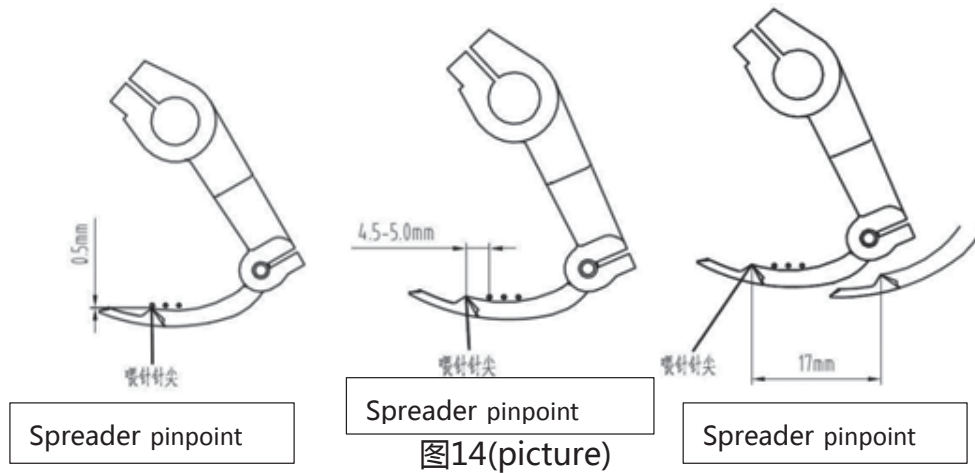


图14(picture)

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.

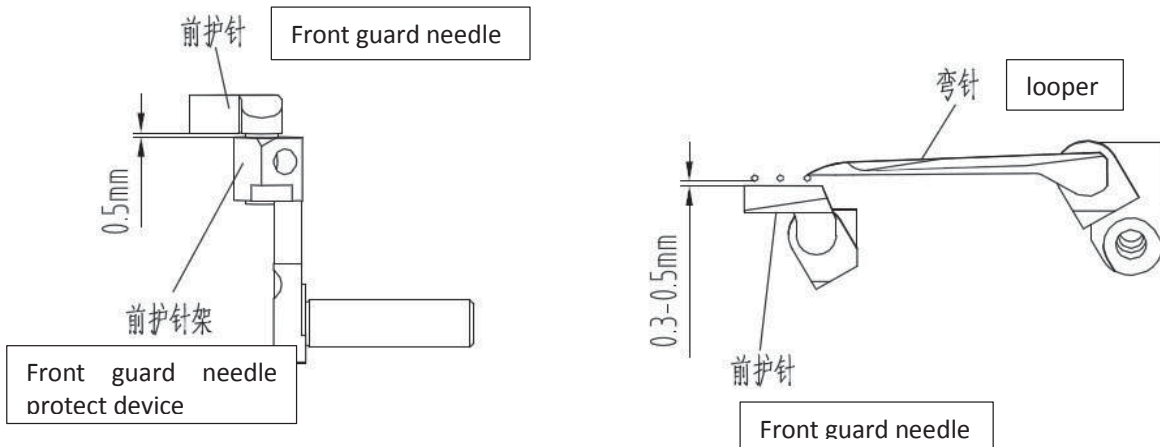


图15

## 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

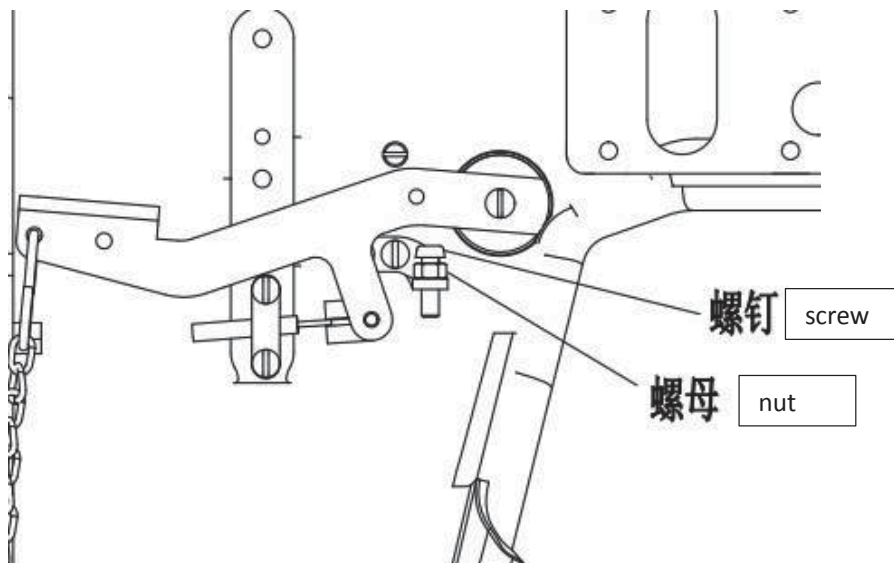
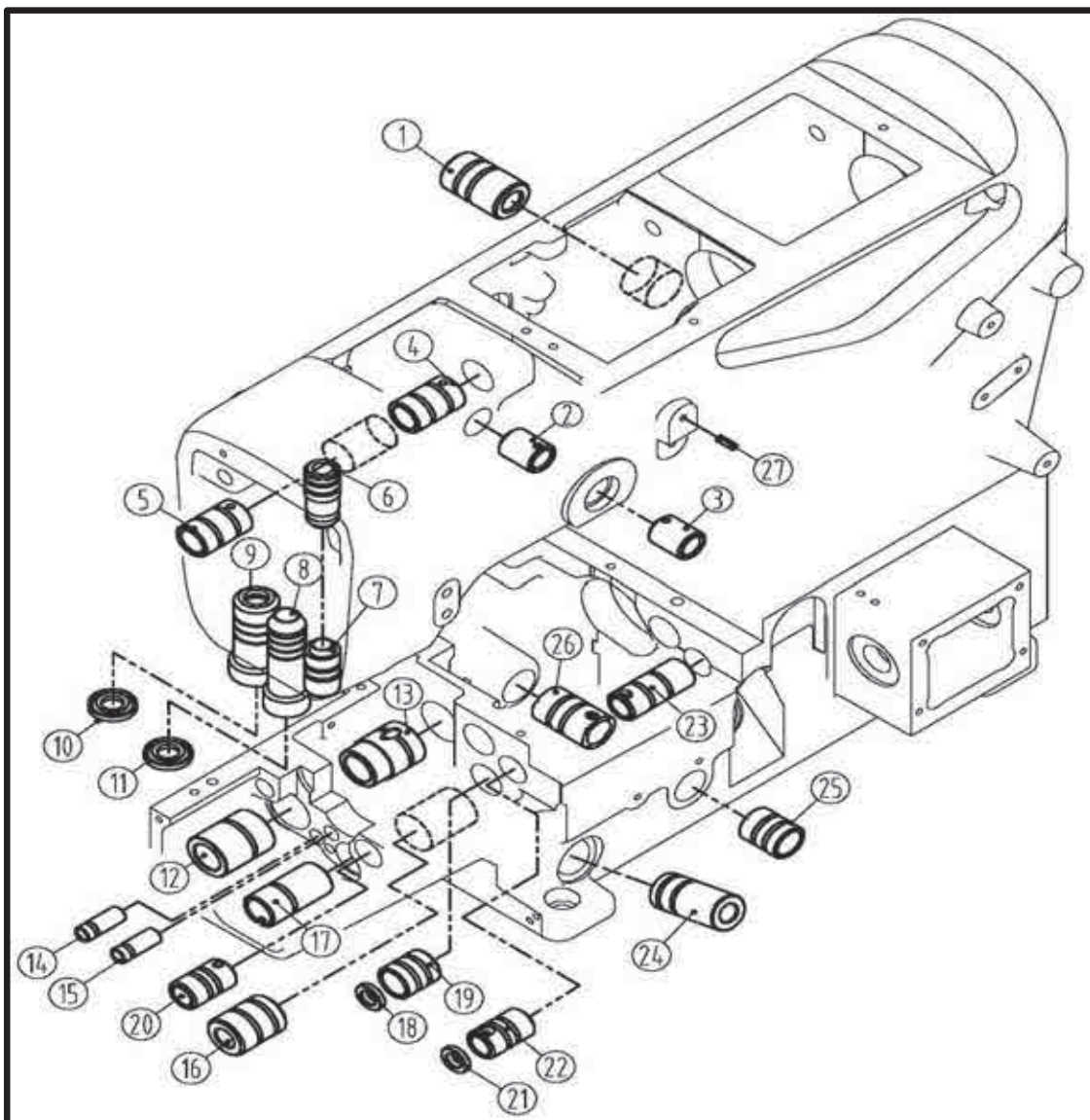


图16

# 套筒部件/Bushing assemblies



注：点划线框代表暂时不用或以改进零件。

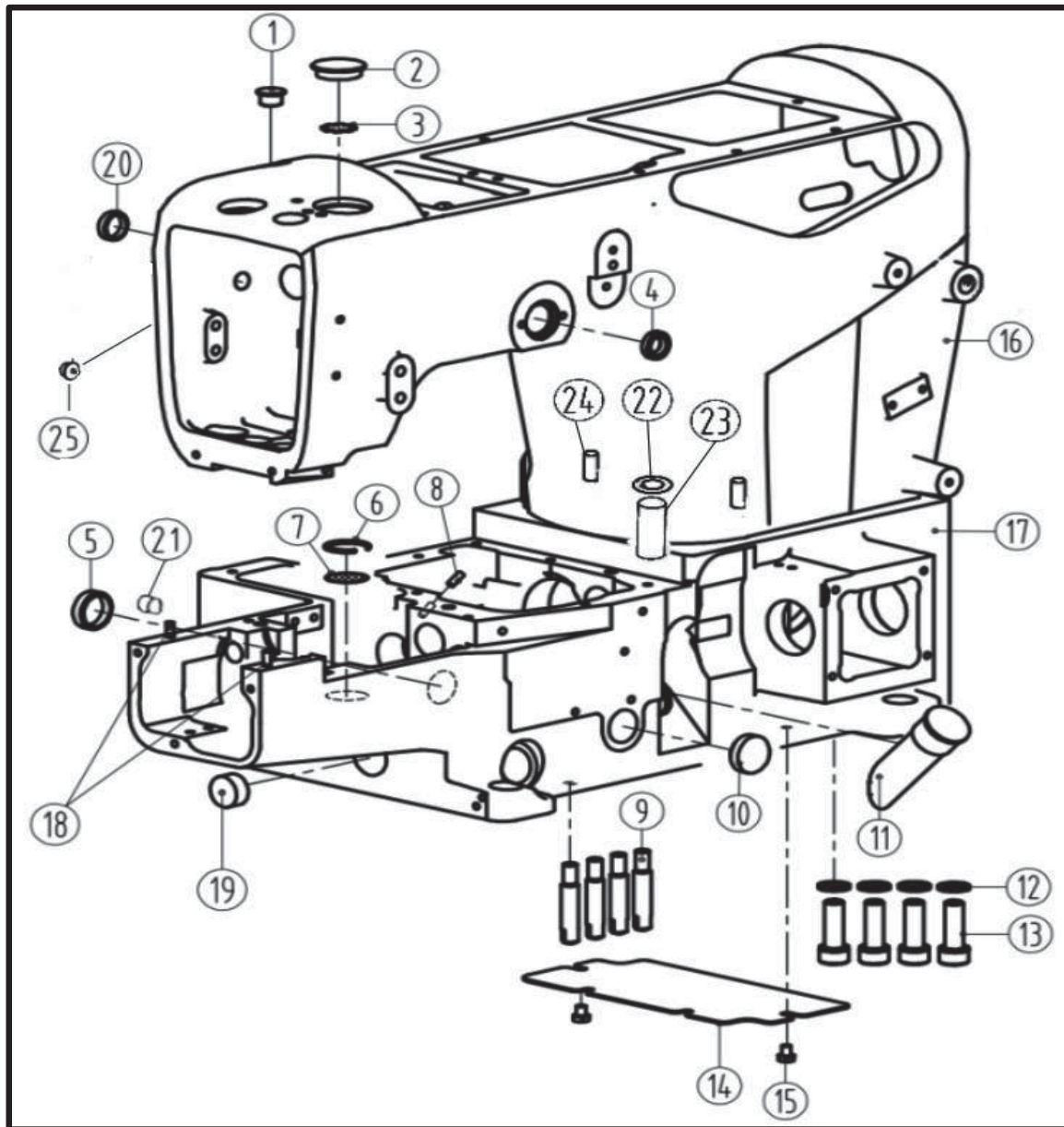
套筒部件/Bushing assemblies

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



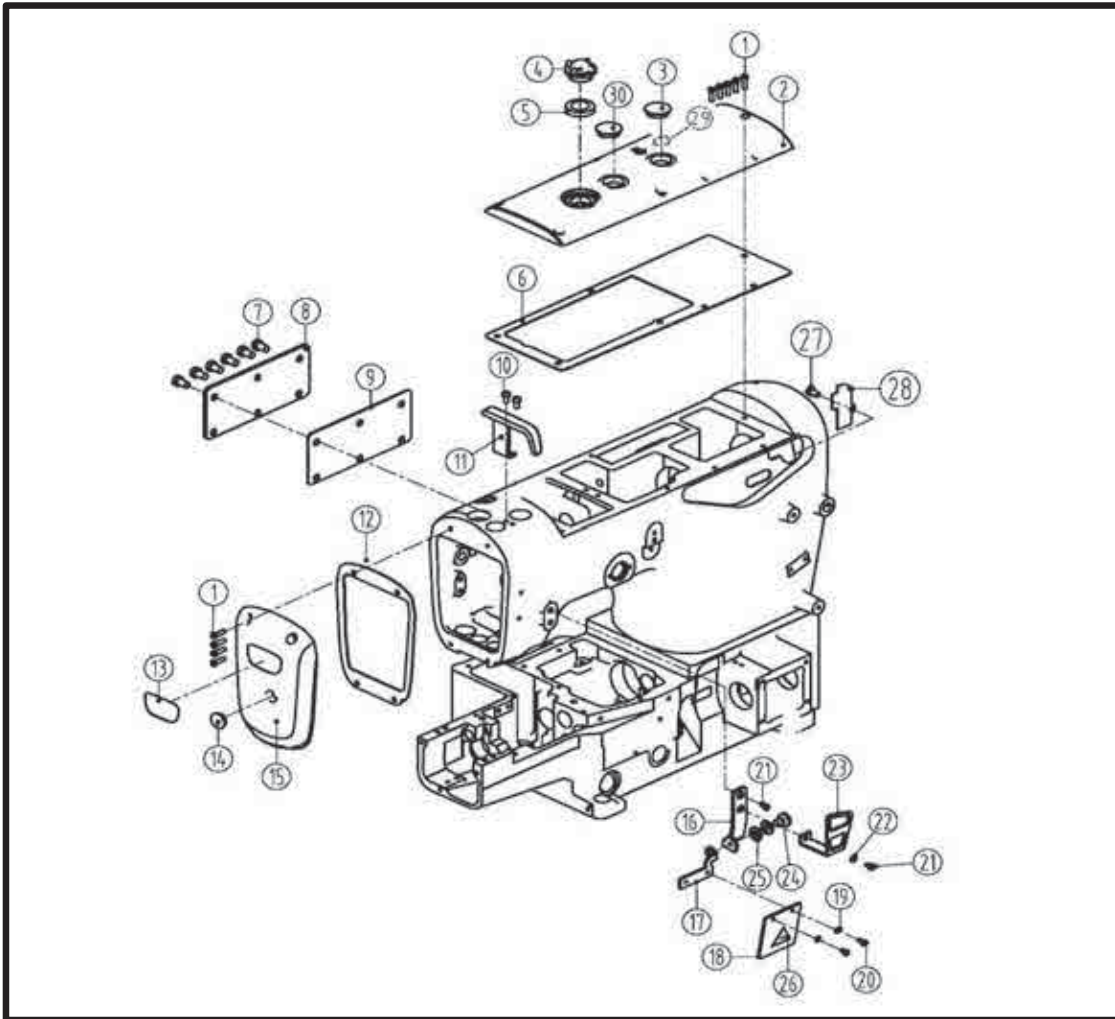
注：点划线框代表暂时不用或以改进零件。

## 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



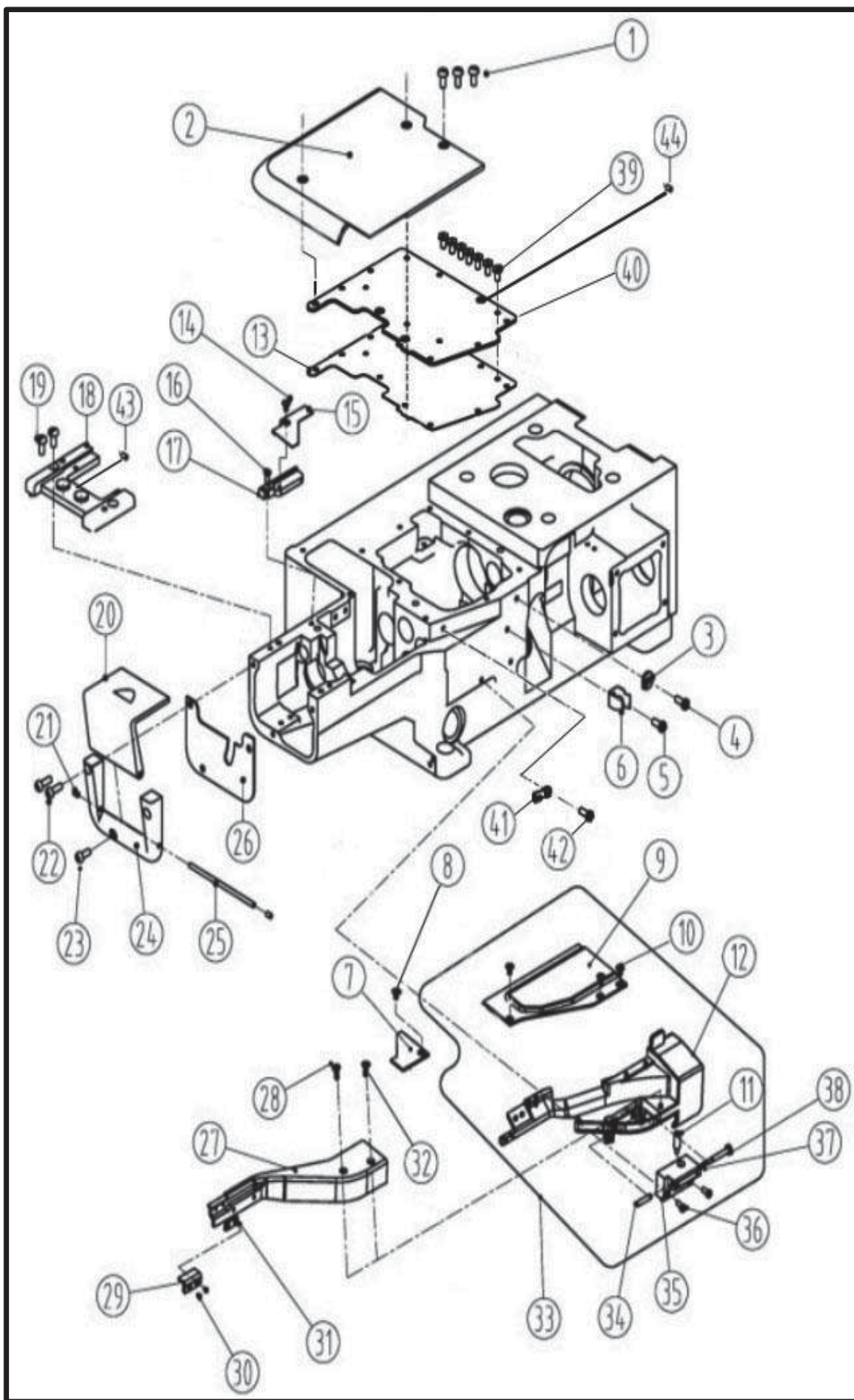
注：点划线框代表暂时不用或以改进零件。

## 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



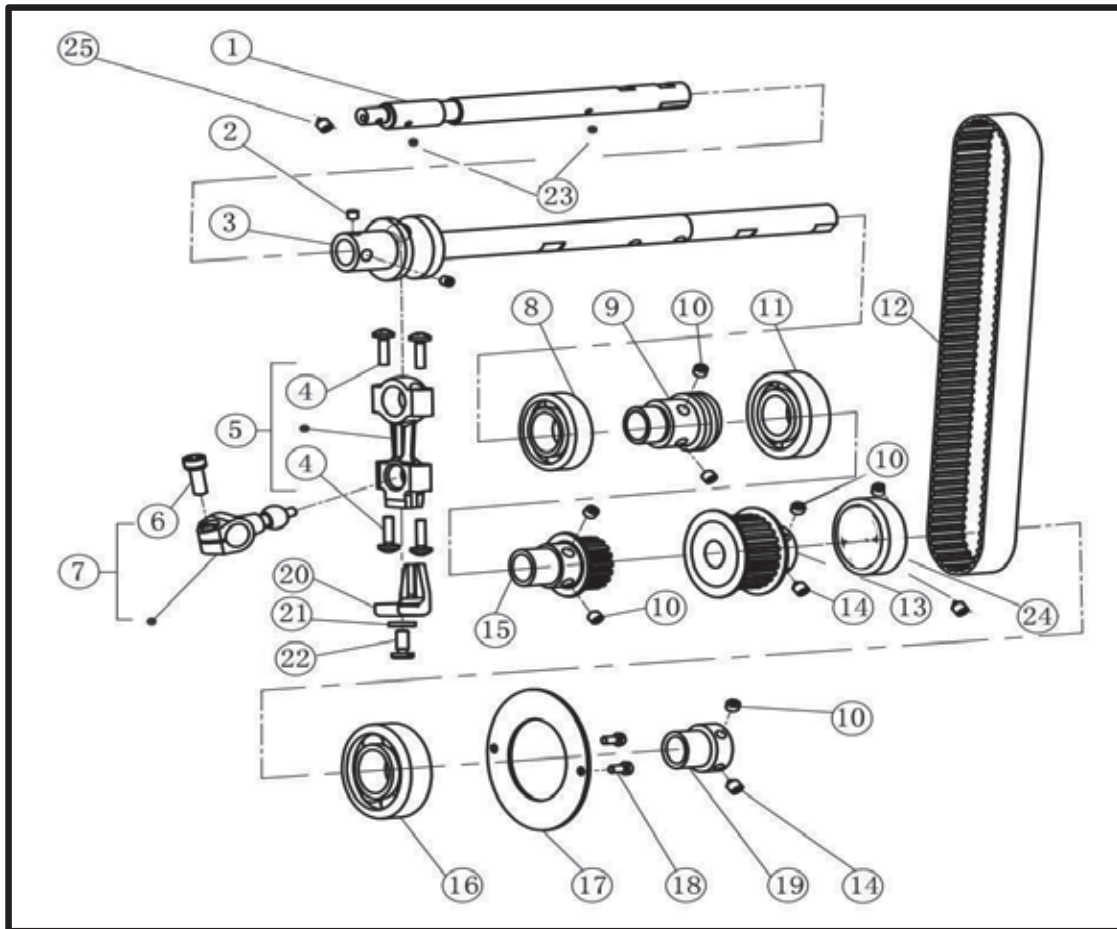
注：点划线框代表暂时不用或以改进零件。

### 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	3101207600	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	310S11003	007043	缝台板螺钉	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	207S11007		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	31001002	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	31001017	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	3100101300	前缝台组件（喷漆）		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	L02001		螺钉M3×3	screw	9
40	30212288		盖板	Cover plate	1
41	30213045		过线	thread guide	1
42	S01055		螺钉 M4×6	screw	1
43	30122018		防震垫	cushion	1
44	31022016		防震垫	cushion	1

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。

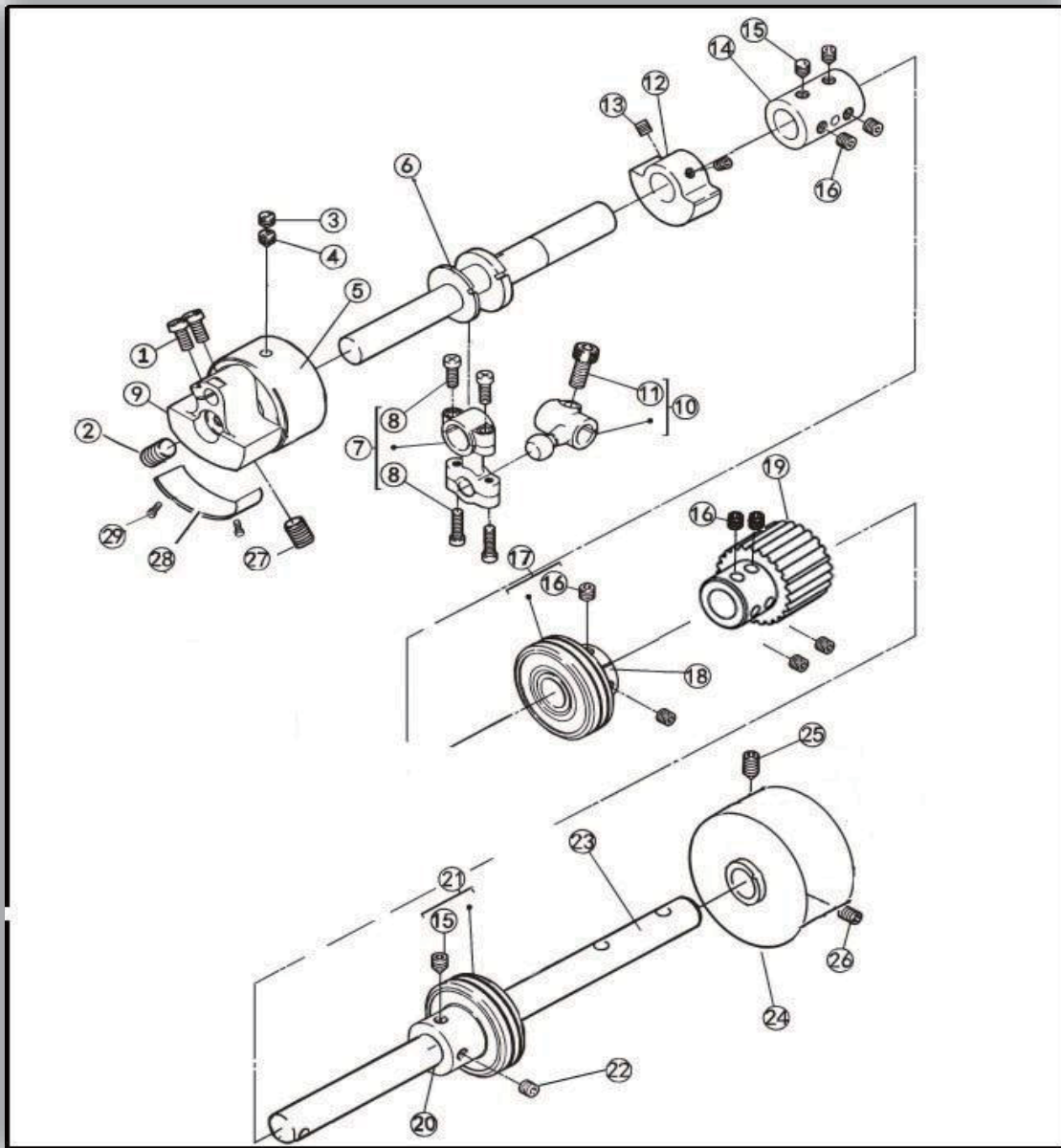
#### 四、下轴部件/Hook shaft assemblies

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	<u>31203001</u>		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



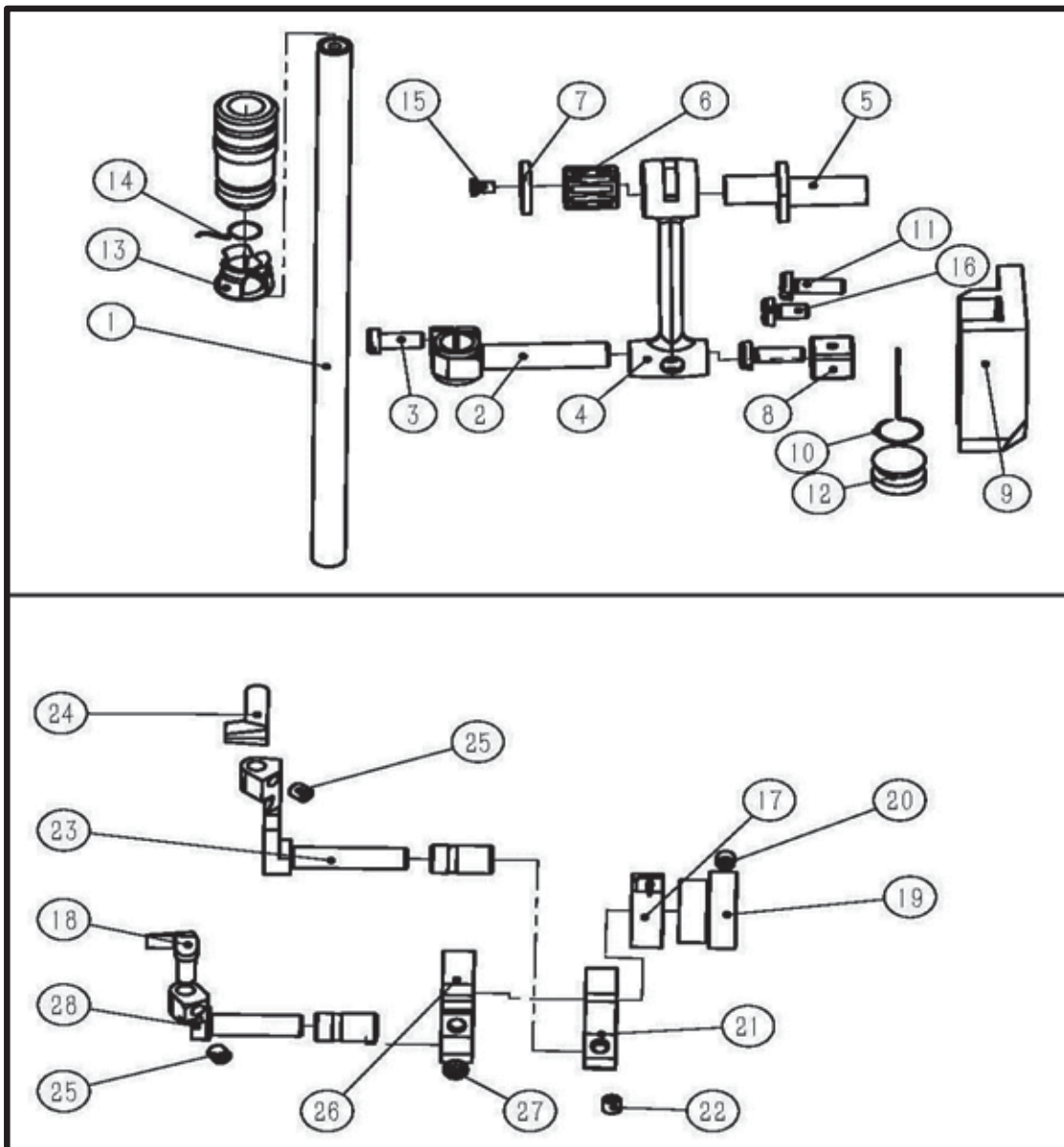
注：点划线框代表暂时不用或以改进零件。

### 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



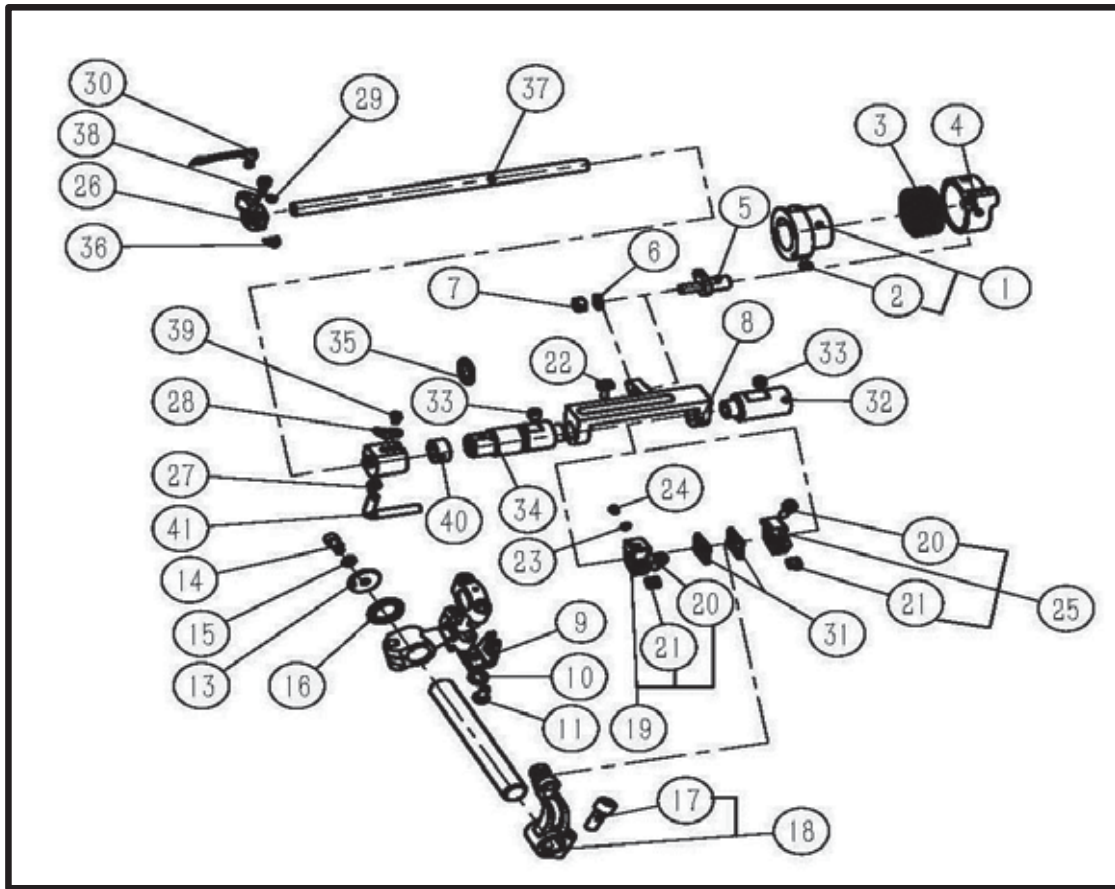
注：点划线框代表暂时不用或以改进零件。

## 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



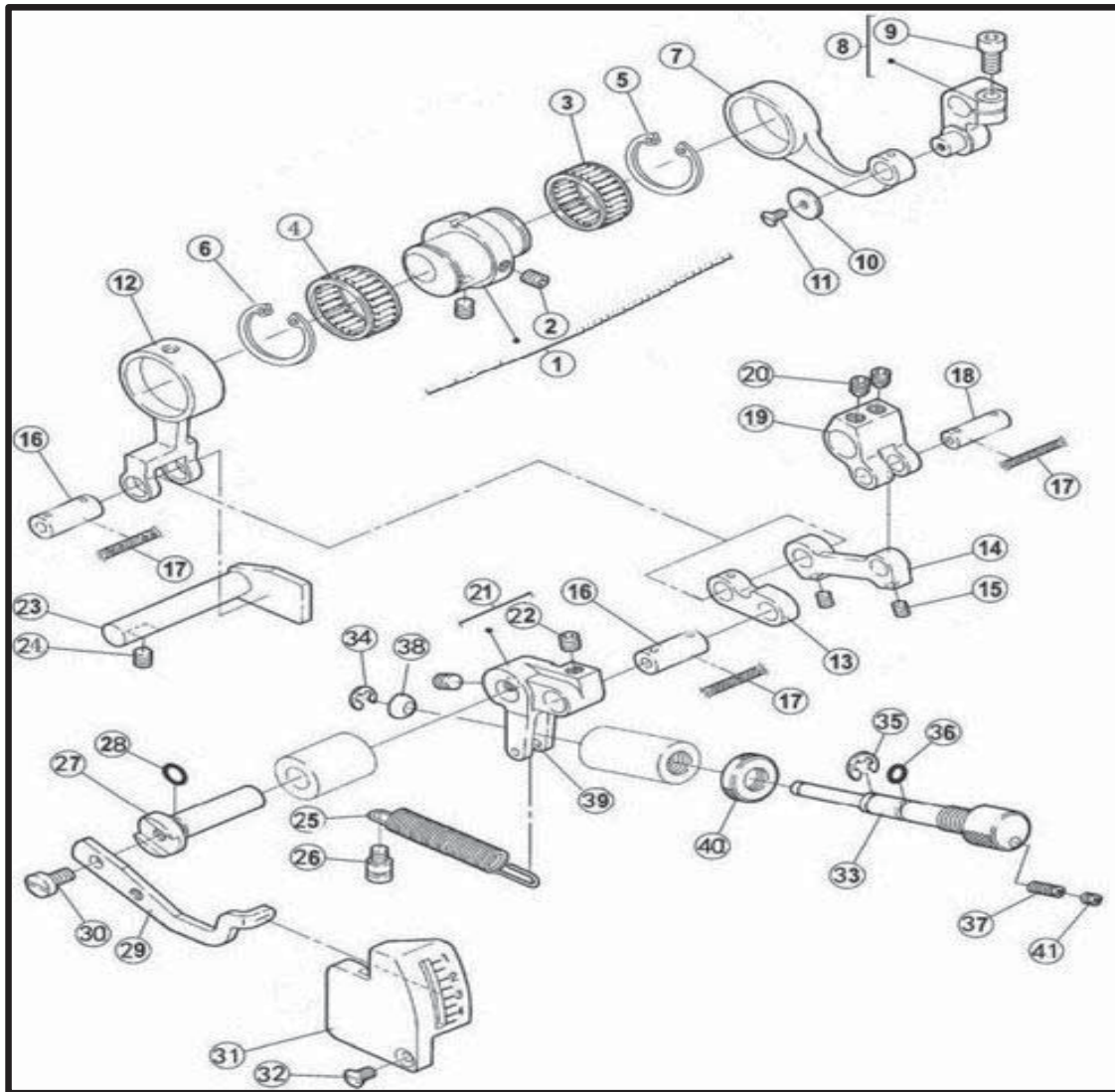
注：点划线框代表暂时不用或以改进零件。

## 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。

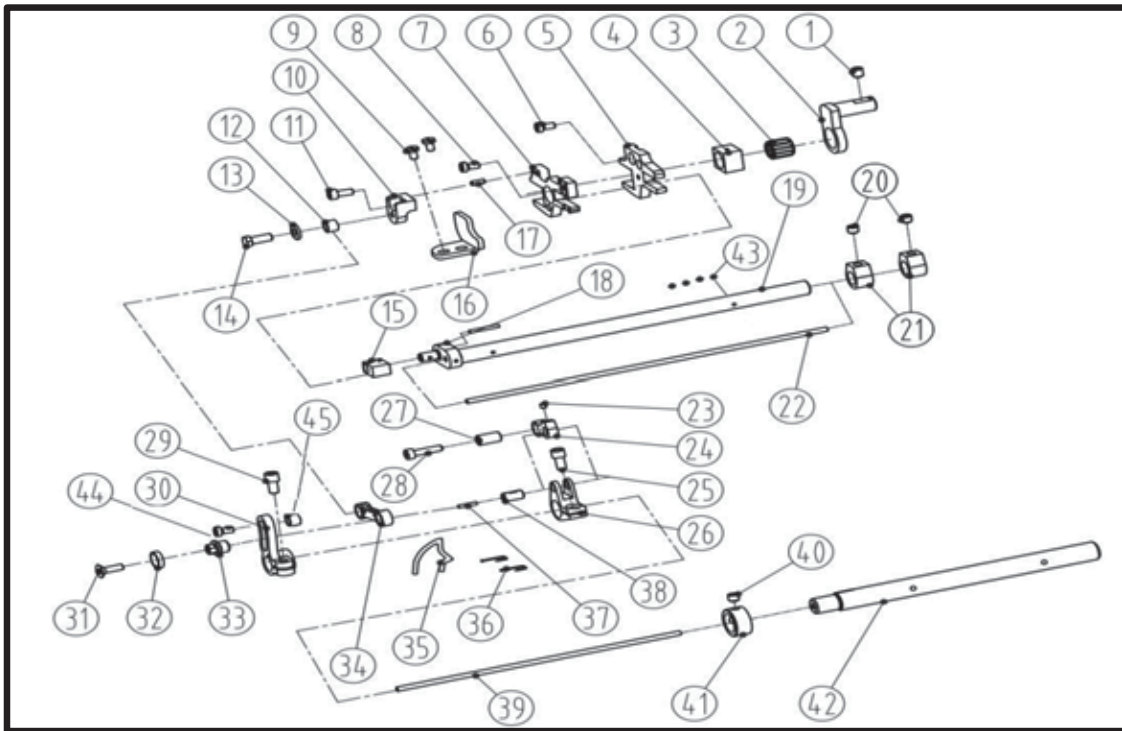
## 八、护针部件/Feed mechanism

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



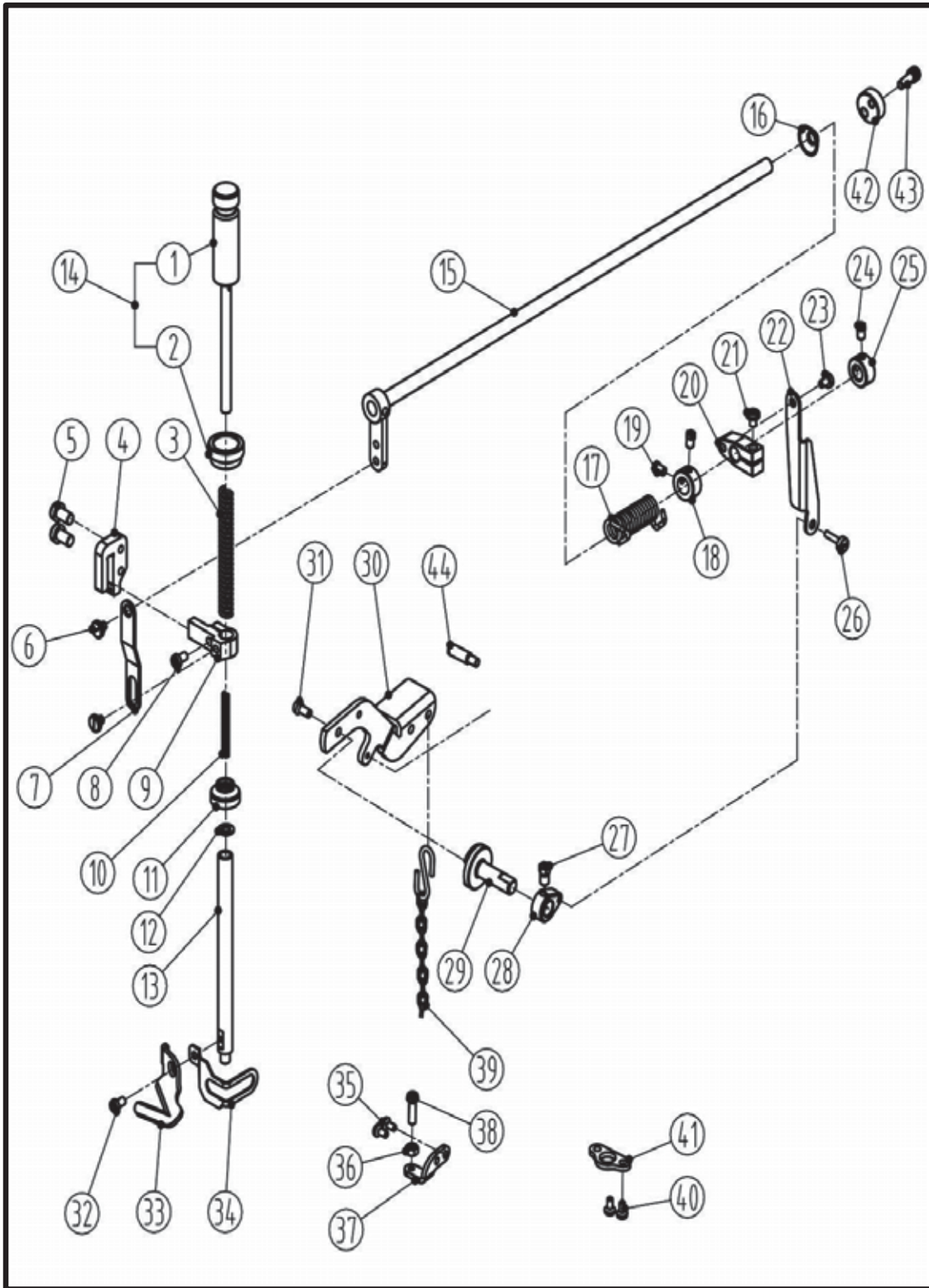
注：点划线框代表暂时不用或以改进零件。

### 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



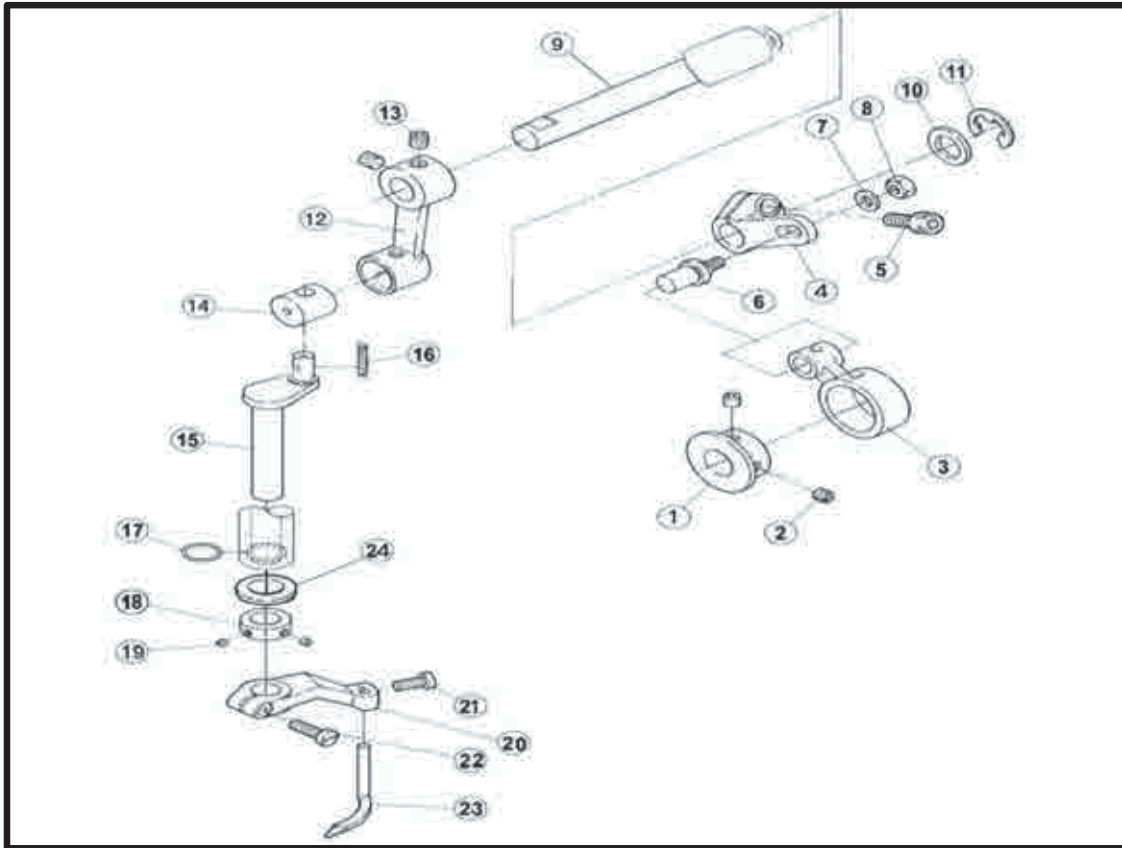
注：点划线框代表暂时不用或以改进零件。

## 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	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	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	131412003		压脚扳手	lever	1
31	S01011	4531	螺钉M5×10	screw	1
32	S01006		螺钉M3×4.5	screw	1
33	30119020		线辫割刀	cutter	1
34	30112017		压脚护罩	finger guard	1
35	S01005		螺钉M4×10	screw	2
36	N01004		螺母M5	nut	1
37	31012110		压脚限位板	link	1
38	S01016		开槽圆柱螺钉M5×17	screw	1
39	31031004		链条	chain	1
40	S01002		螺钉M4×6.5	screw	2
41	31012062		链条挡板	guide	1
42	31009008		电控安装柱	erection column	1
43	S05004		螺钉 M5×14	screw	1
44	207S11007		螺钉M4×7.5	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



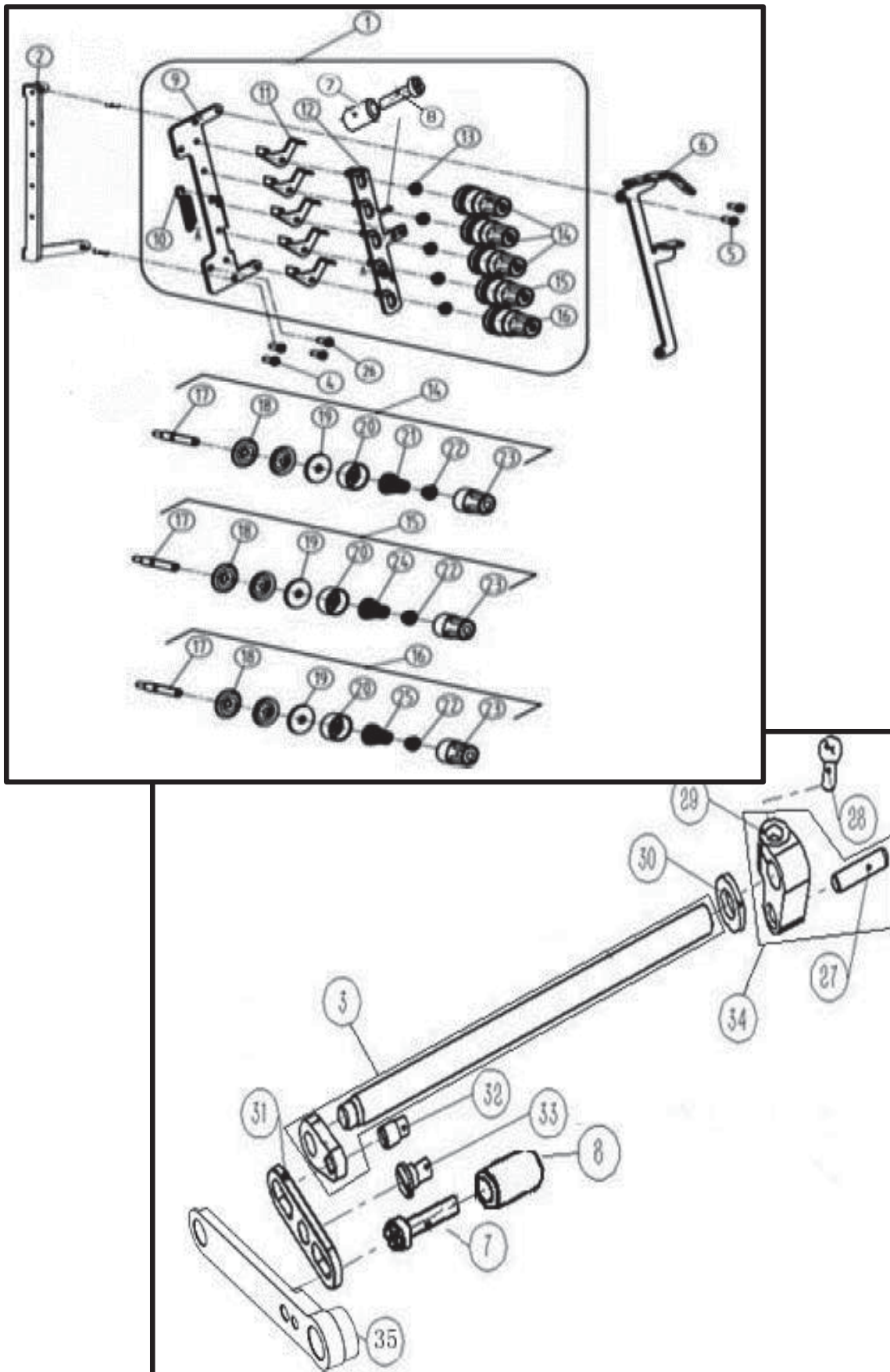
注：点划线框代表暂时不用或以改进零件。

### 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/Thread loosening assemblies (one)



注：点划线框代表暂时不用或以改进零件。

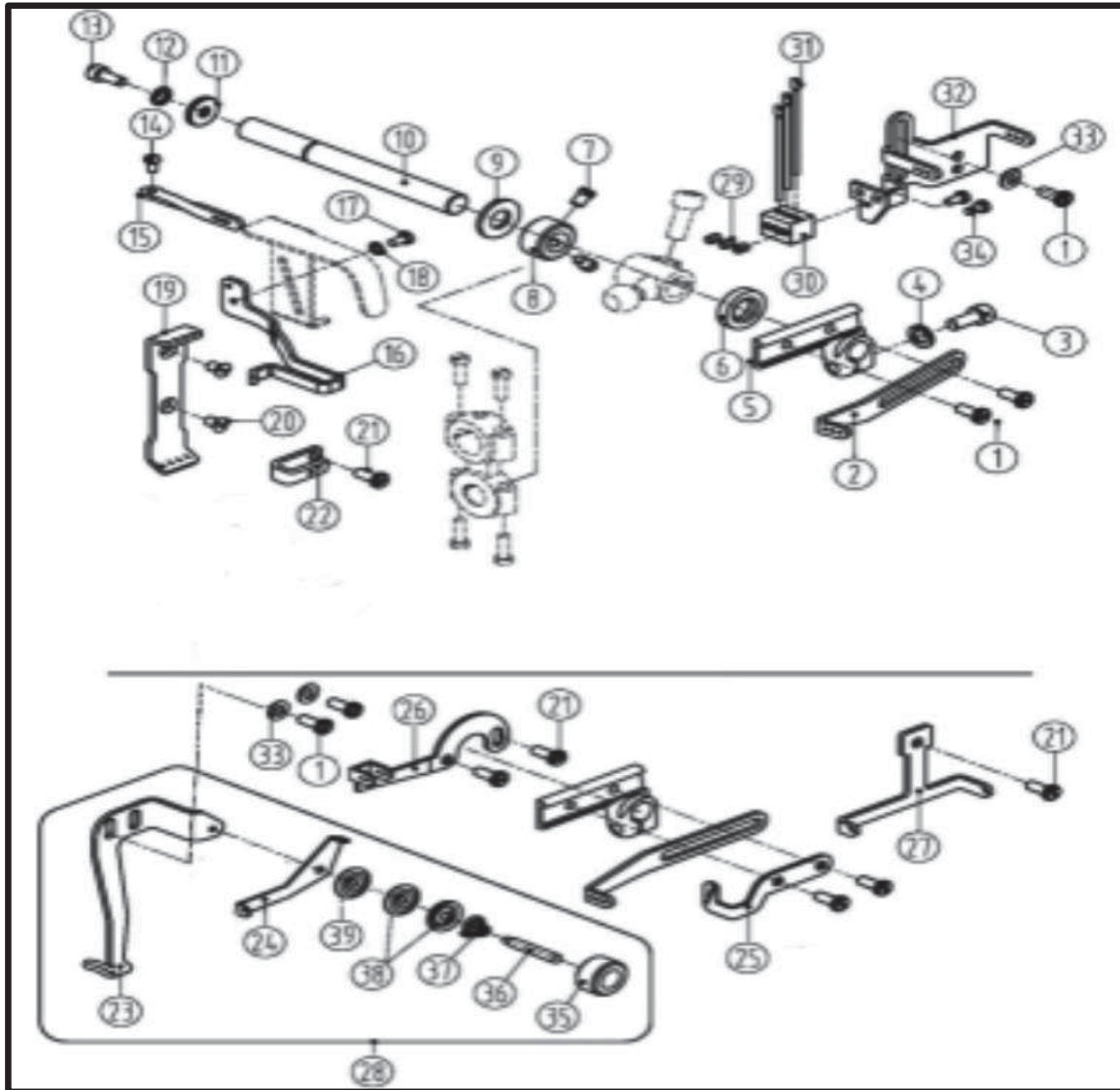
## 十二、松线部件/Thread loosening assemblies (one)

序号 No.	件号 Parts No.	参考件号 Ref. Part. No.	名称	Description	数量 Number
1	3101300800		夹线器	tension	1
2	31013014		松线架	Loose thread stand	1
3	131104001		松线曲柄	block	1
4	207S11007		螺钉M4×7.5	screw	2
5	<u>207S11007</u>		螺钉M4×7.5	screw	2
6	31013022		夹线器过线	Loose line board	1
7	S04020		螺钉	screw	1
8	31003005		轴套	Nut	1
9	31013007		支撑板	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		调节套	spacer	5
14	3011300800		调线组件(强)	tension spring assembly(heavy)	3
15	3011300900		调线组件(中)	tension spring assembly	1
16	3011301600		调线组件(弱)	tension spring assembly(light)	1
17	301S30010		夹线延	screw stud	1
18	30128016		夹线片	tension disc	2
19	20623008		松线夹线片垫	felt	1
20	20111005		调压止动盖	cup	1
21	30127011		调压簧(强)	spring(heavy)	3
22	30111006		调压止动套	ratchet	1
23	30111059		调压螺母	nut	1
24	30127012		调压簧(中)	spring(medium)	1
25	30127013		调压簧(弱)	spring(light)	1
26	<u>207S11007</u>		螺钉 M4×7.5	screw	4
27	30126007		松线曲柄定位销	screw	2
28	S05005		螺钉M5×12	screw	1
29	30104026		松线曲柄	crank	1
30	W01010		平垫圈	washer	1
31	131412004		转接板	thread	1
32	301S20030		过线螺钉	screw	1
33	423S20004		轴位螺钉	screw	1
34	3010403100		松线曲柄I组件	crank	1
35	131404002		松线曲柄	crank	1

注：点划线框代表暂时不用或以改进零件。



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



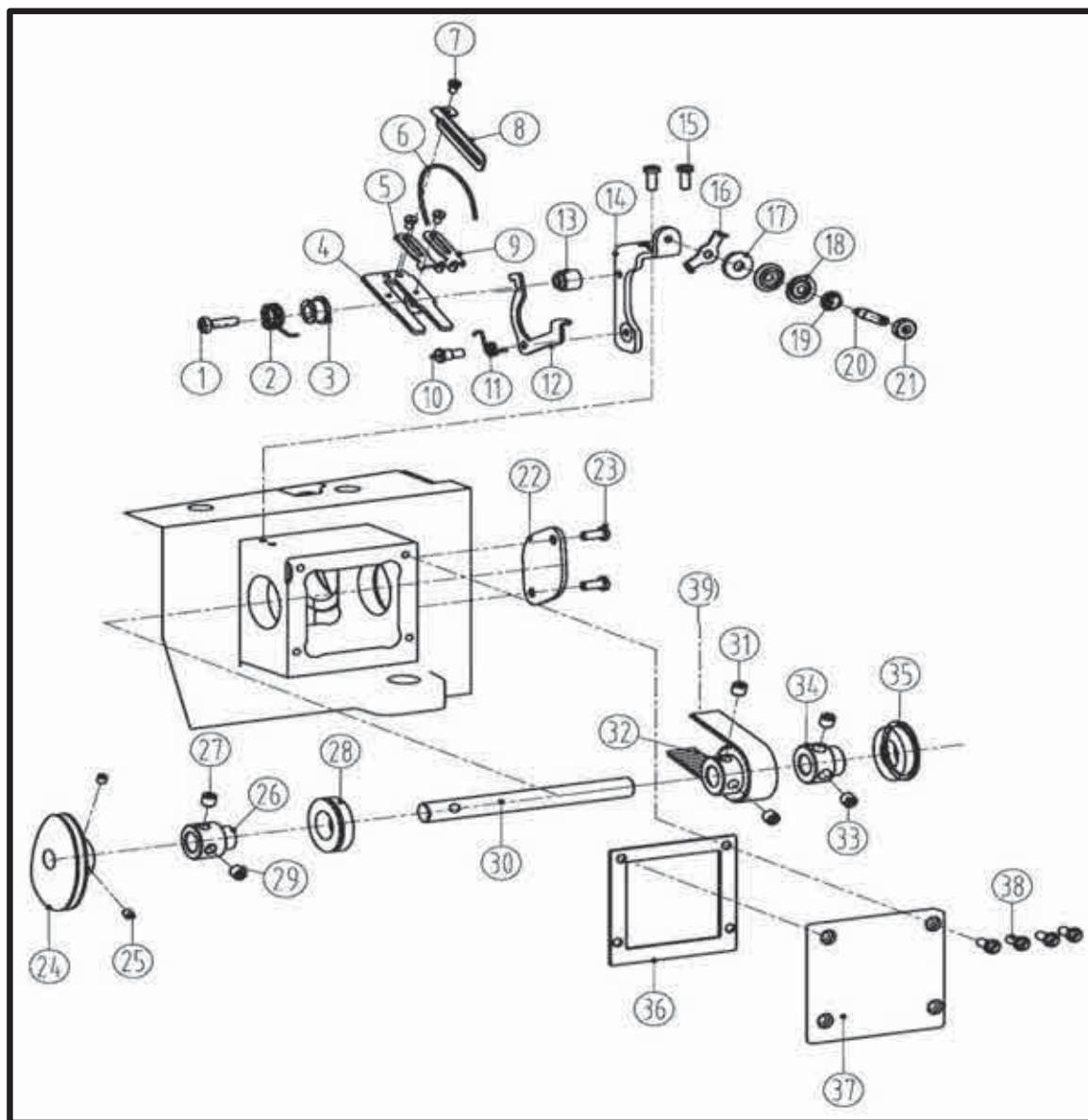
注：点划线框代表暂时不用或以改进零件。

### 十三、过线部件/Thread loosing assemblies

序号 No.	件号 Parts No.	零件号 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。

#### 十四、打线凸轮部件/Cam assesblies



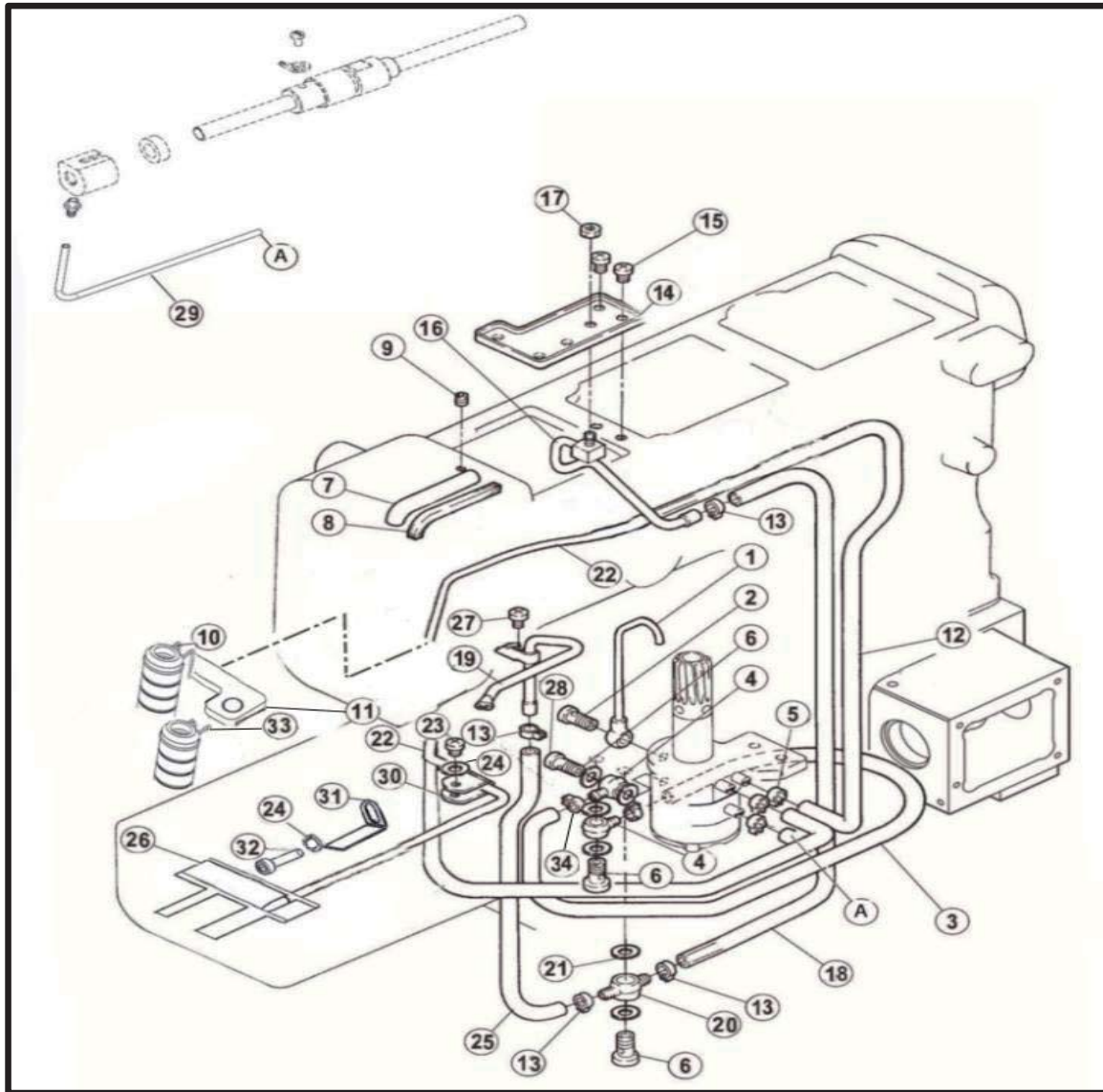
注：点划线框代表暂时不用或以改进零件。

#### 十四、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。

## 十五、润滑部件/Lubrication assemblies



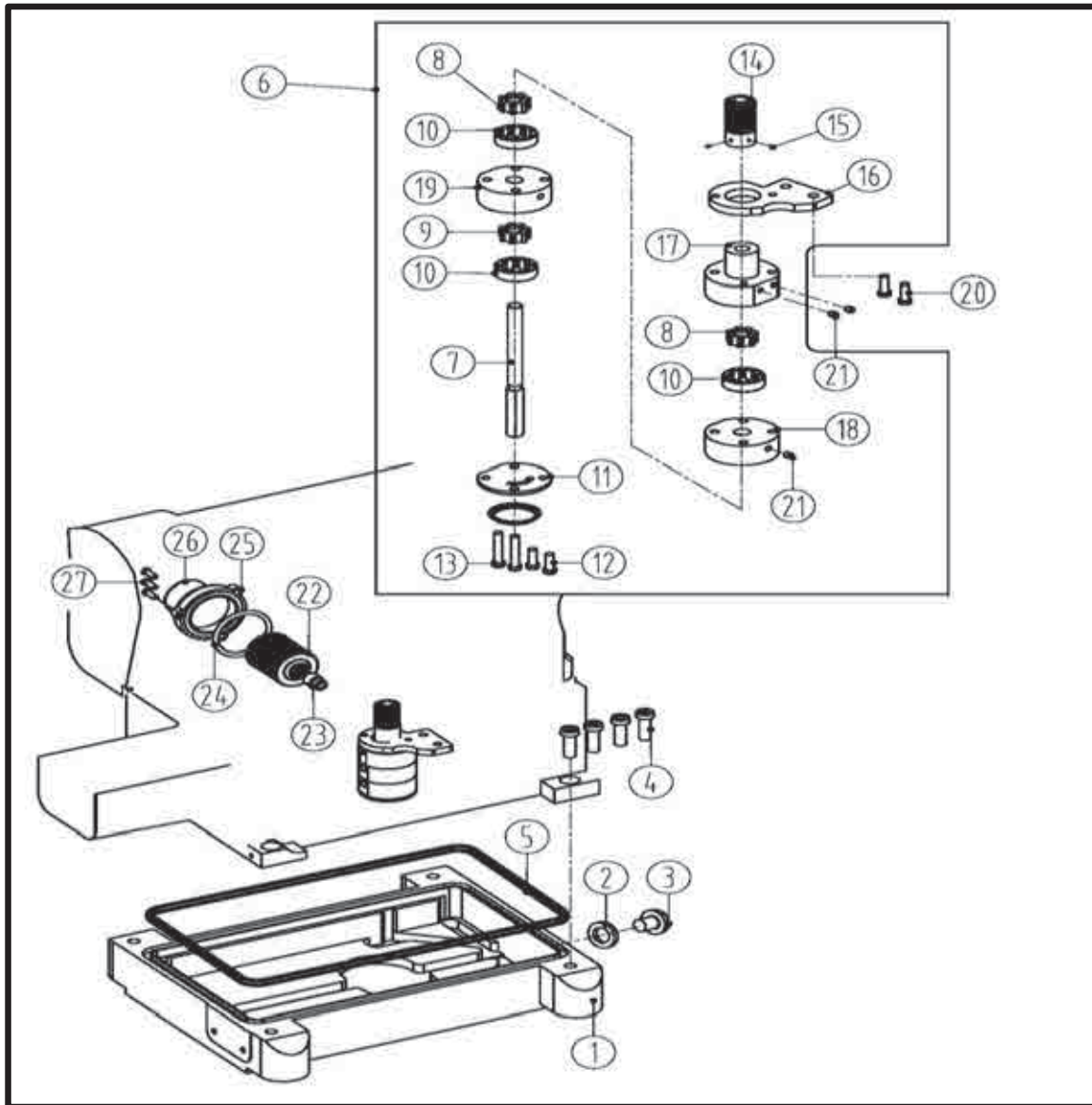
注：点划线框代表暂时不用或以改进零件。

### 十五、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Φ5×Φ7	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	Φ3×Φ5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	Φ4×Φ6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		Φ3×Φ5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		Φ3×Φ5油管	tube	1
30	20712055		油管夹	tubing clamps	1
31	30227040		固定板	screw	1
32	207S13007		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。

## 十六、油泵部件/Oil pump assemblies



注：点划线框代表暂时不用或以改进零件。

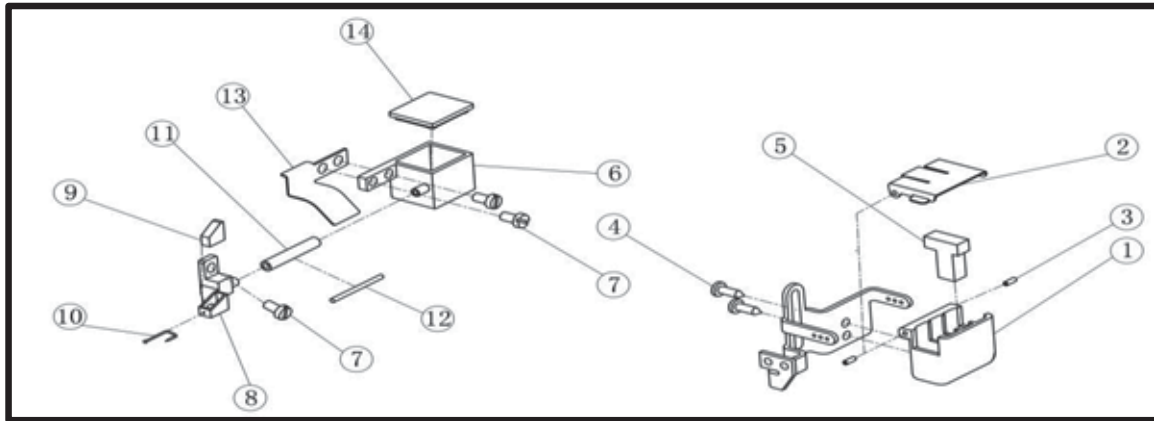
## 十六、油泵部件/Oil pump assemblies

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。



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



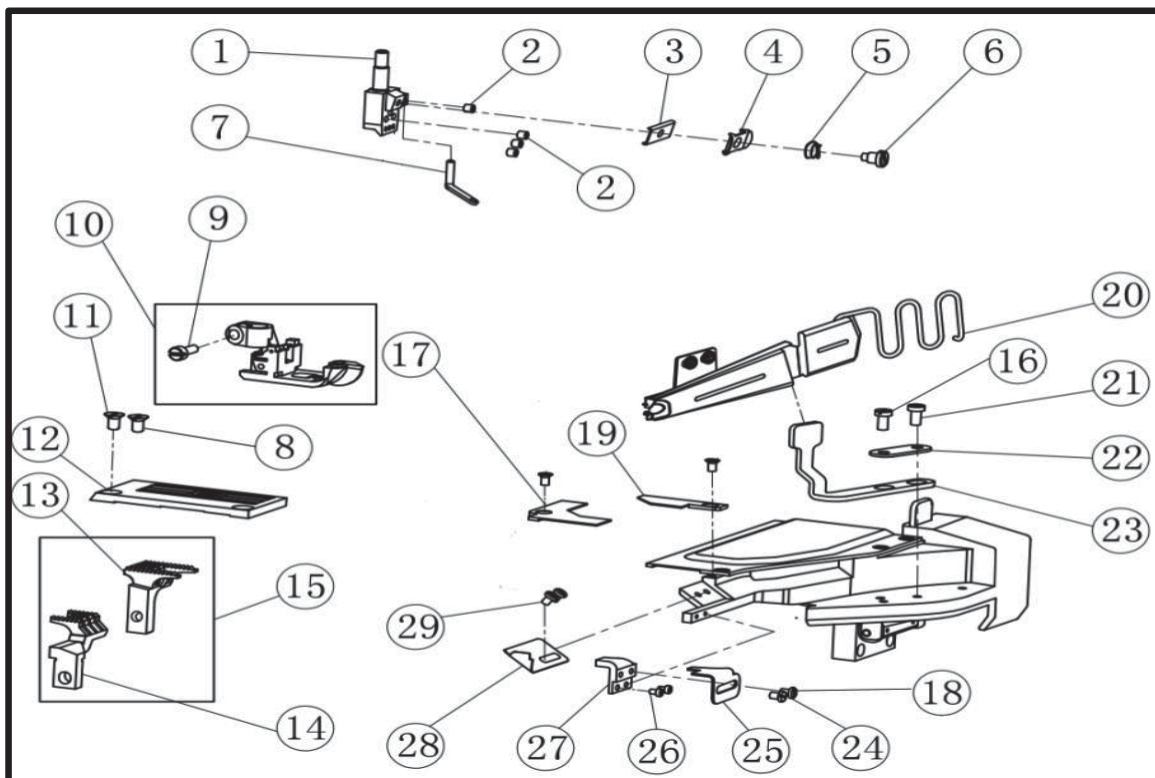
注：点划线框代表暂时不用或以改进零件。

十七、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	<u>207S11007</u>	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。

十八、针位组专用件部件/Gauge set specific parts



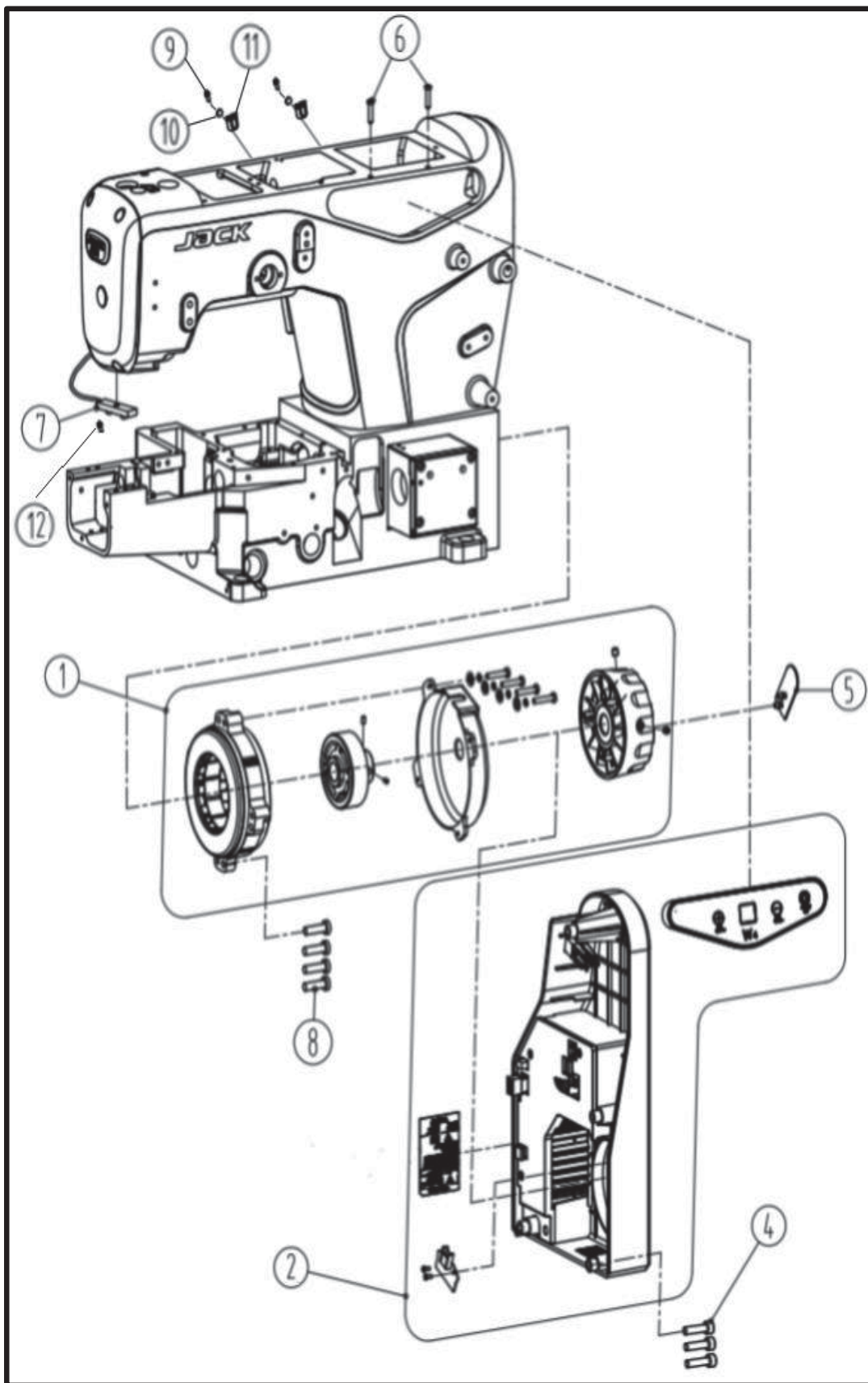
注：点划线框代表暂时不用或以改进零件。

### 十八、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。

# 十九、电控部件/Electronic control assemblies



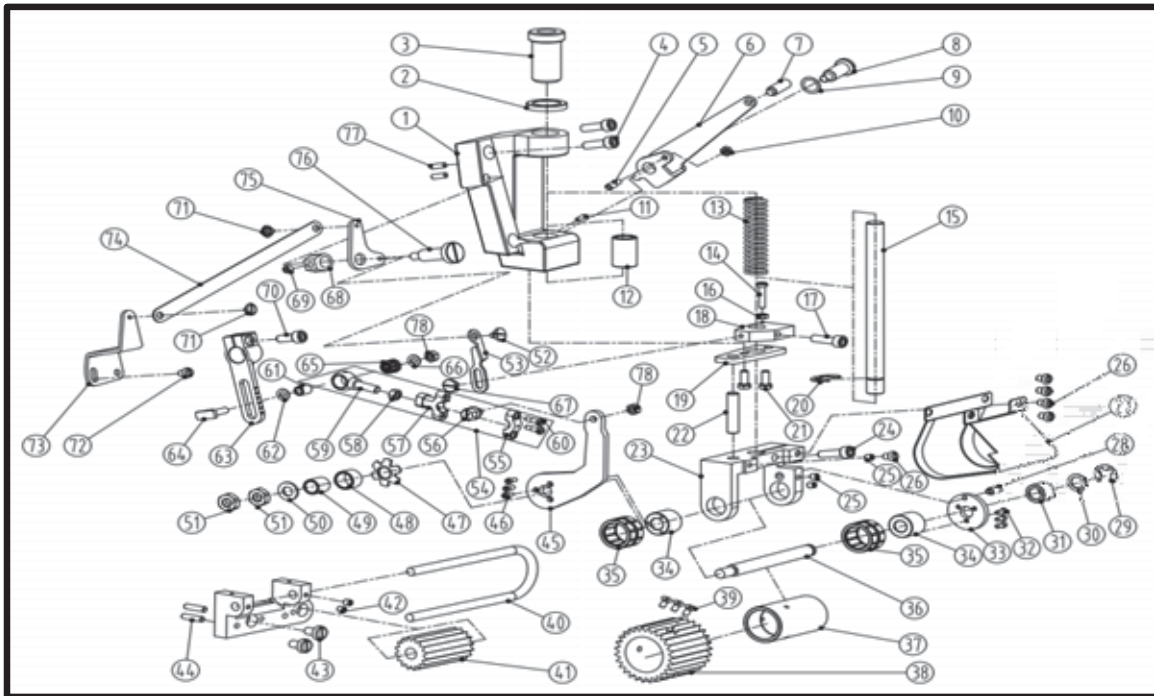
注：点划线框代表暂时不用或以改进零件。

### 十九、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	3103300200		绷缝伺服电机	Photoelectric servo motor	1
2	3103000400		电控	plug	1
3	20131063		警示牌	washer	1
4	S05068		螺钉	screw	4
5	21111018		手轮偏心(手轮贴条)	brand	1
6	310S17001		螺钉	screw	2
7	3103000300		LED灯	LED light	1
8	S05068		螺钉 M5×20	screw	4
9	207S11007		螺钉M4x7.5	screw	2
10	W01001		垫片	washer	2
11	20711212		线夹	clip	2
12	S05190		内六角平圆头螺钉	screw	1

注：点划线框代表暂时不用或以改进零件。

## 二十、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

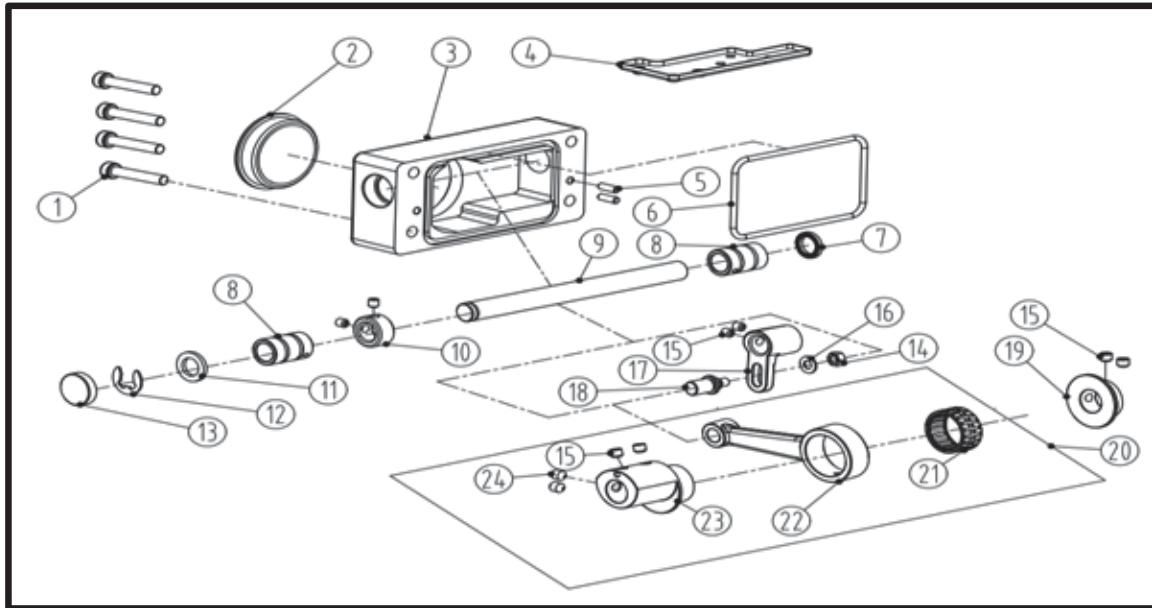
注：点划线框代表暂时不用或以改进零件。



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。

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



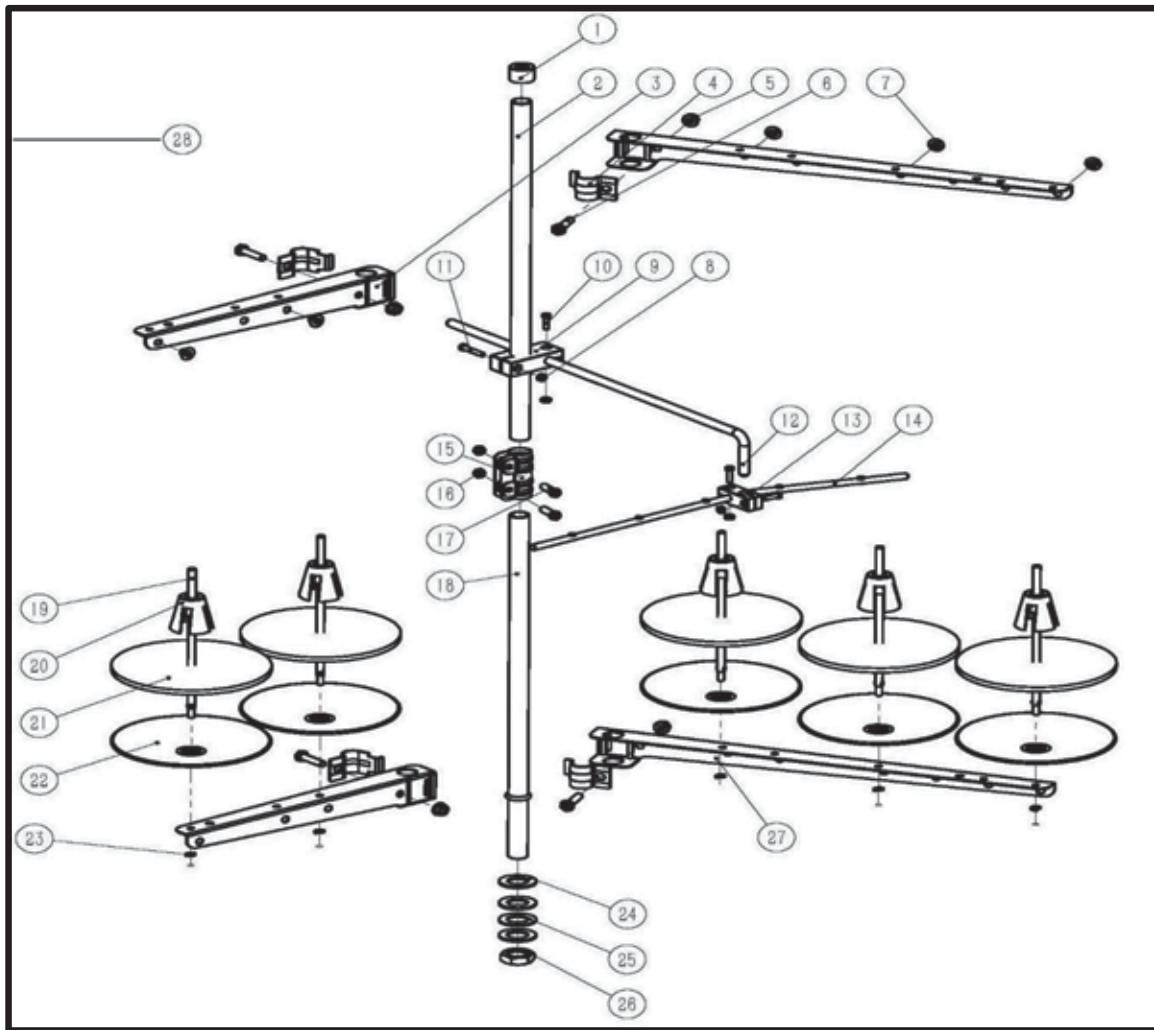
注：点划线框代表暂时不用或以改进零件。

## 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。

## 二十二、线架部件/Thread Apool Assemblies



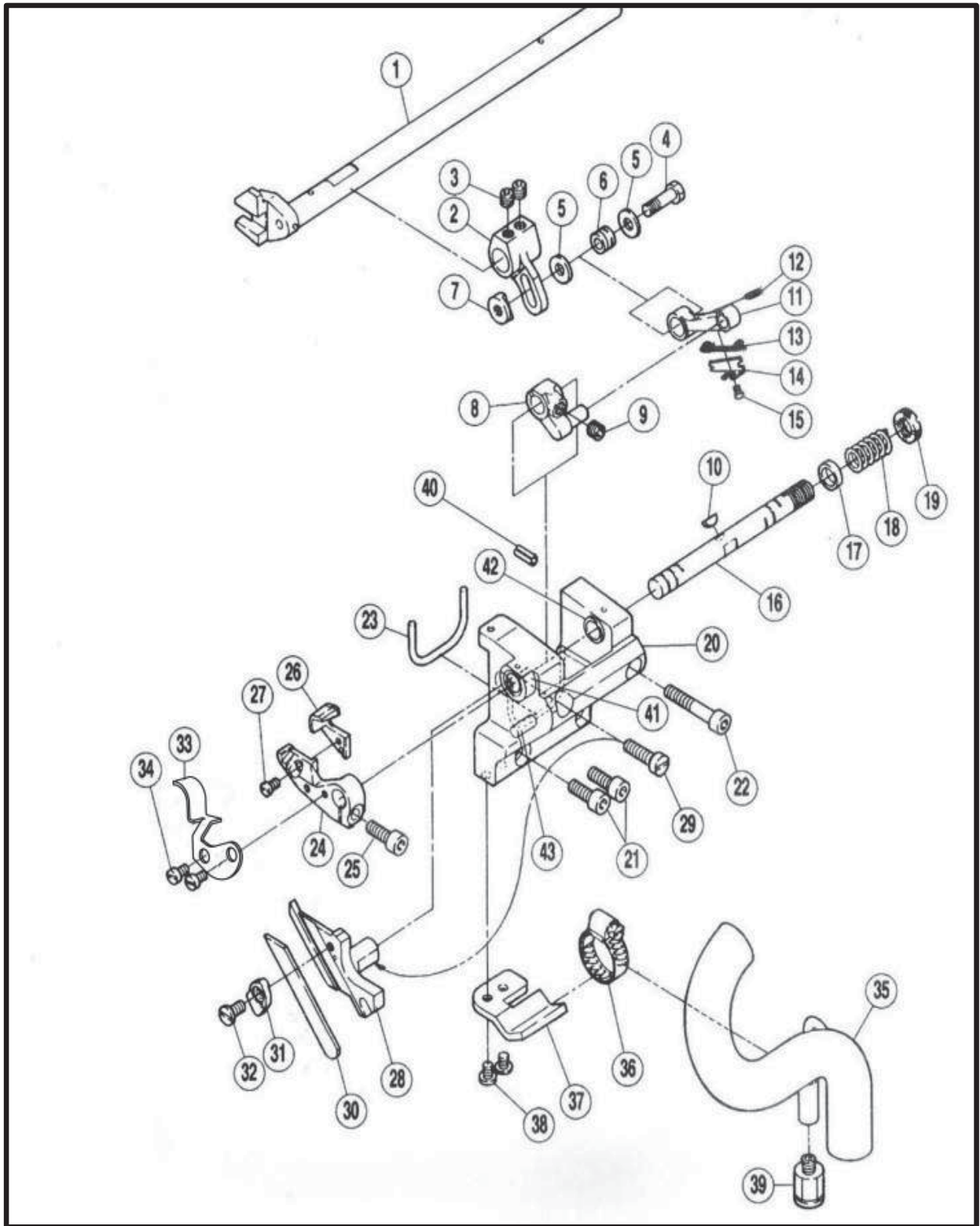
注：点划线框代表暂时不用或以改进零件。

## 二十二、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 cushioning	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。

二十三、35AC切刀专用件/35ACFT device



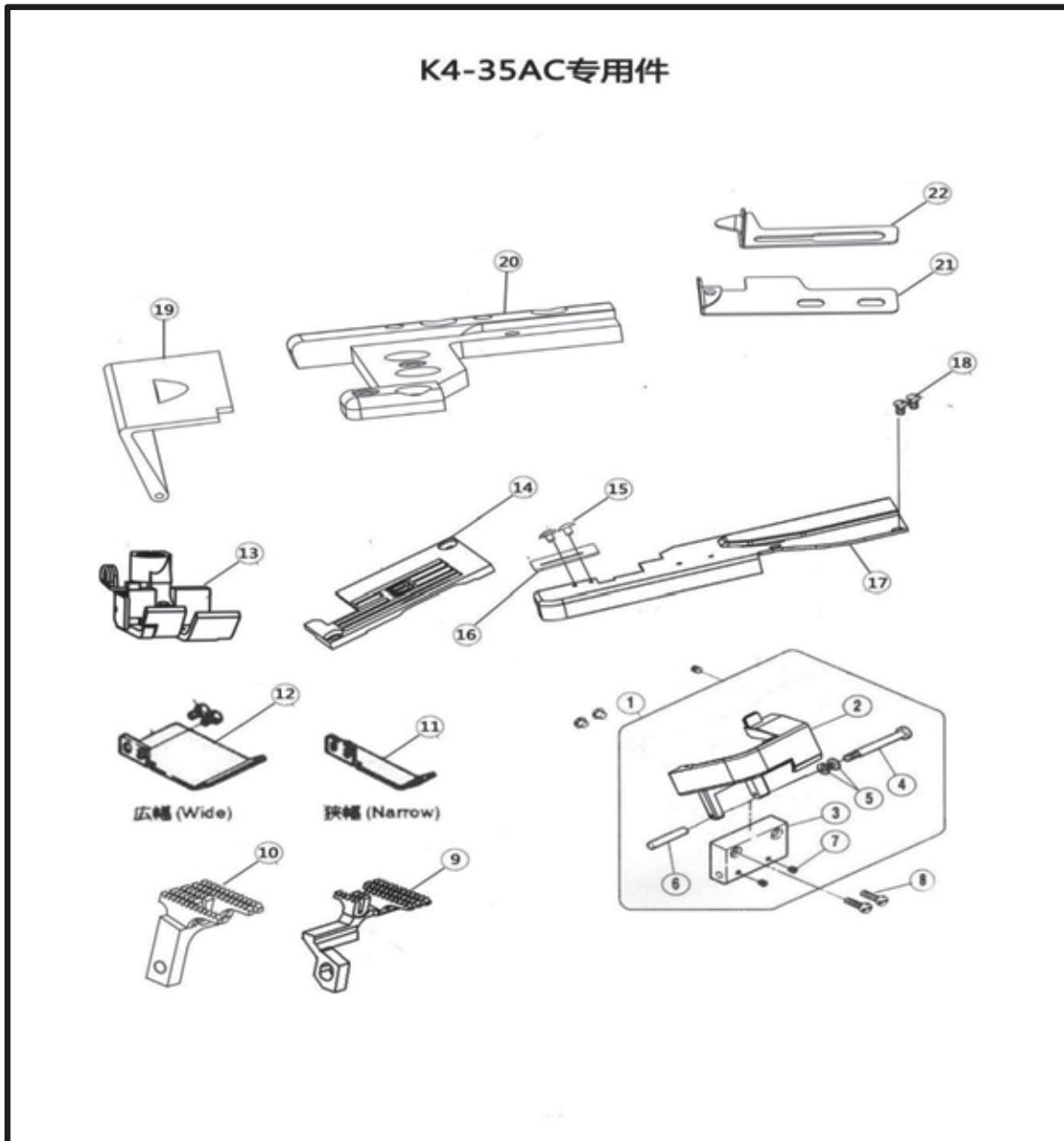
注：点划线框代表暂时不用或以改进零件。

### 二十三、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。

二十四、35AC专用件/35ACFT device



注：点划线框代表暂时不用或以改进零件。

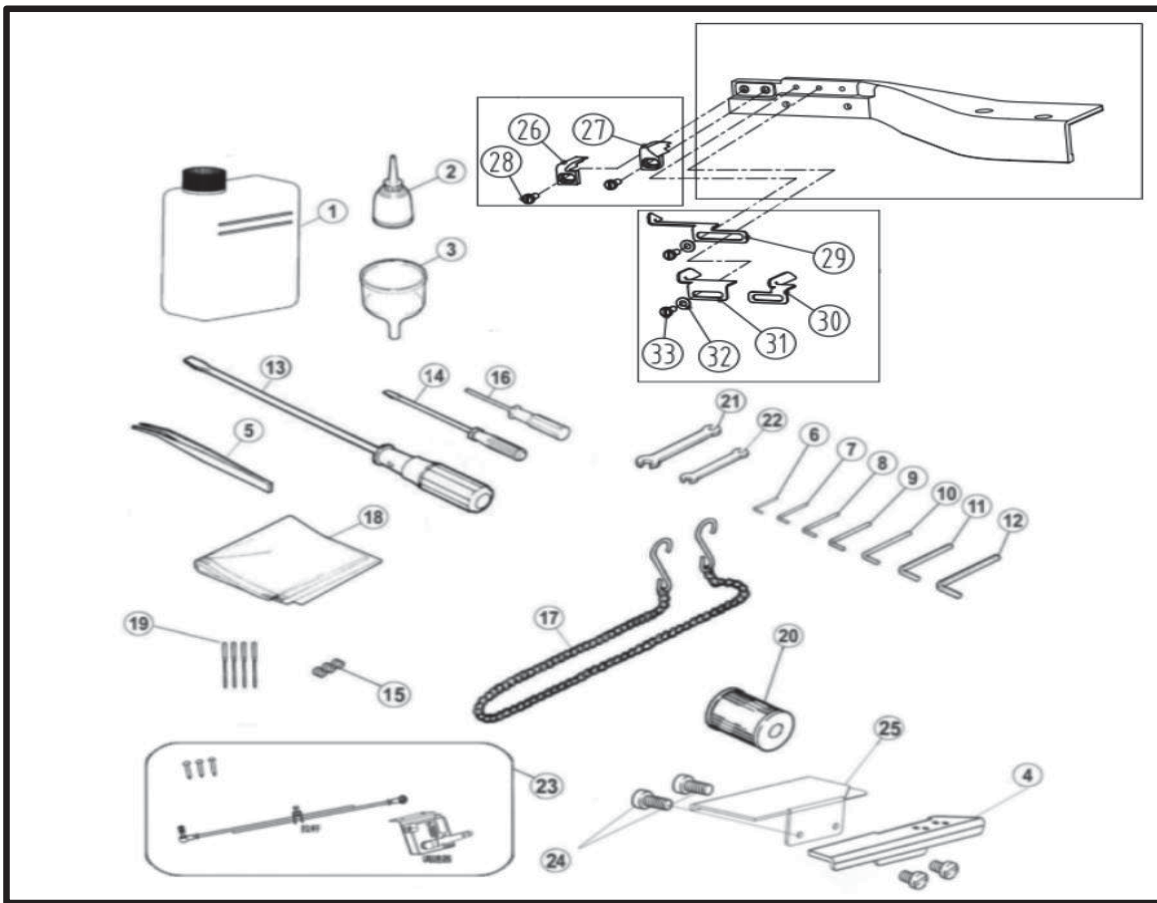


## 二十四、35AC专用件/35ACFT device

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 piate	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。

## 二十五、附件/Accessories assemblies



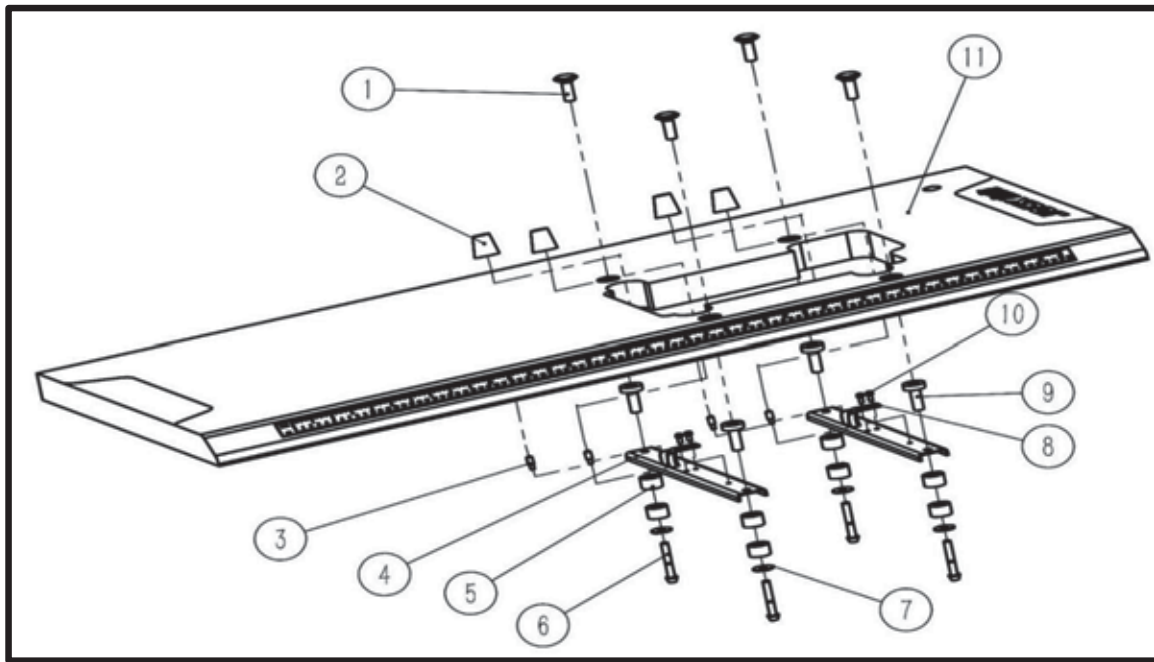
注：点划线框代表暂时不用或以改进零件。

## 二十五、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。

## 二十六、台板部件/Bedplate assemblies



注：点划线框代表暂时不用或以改进零件。

## 二十六、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):

中国浙江省台州市椒江区三甲东海大道东段1008号

NO. 1008, DONGHAI AVENUE EAST, JIAOJIANG DISTRICT, TAIZHOU CITY, ZHEJIANG

邮编(Zip Code): 318000

国内销售部(Domestic Trade Department):

电话(TEL): 0086-0576-88177780 88177789

传真(FAX): 0086-0576-88177758

国贸部(International Trade Department):

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

注: 点划线框代表暂时不用或以改进零件。