



中国缝制机械协会理事单位 / 本企业已通过ISO9001管理体系认证  
浙江科技型企业 台州著名商标 / ISO14001环境体系认证

# H86D 系列 SERIES

步进高速电脑带刀平缝机  
HIGH SPEED COMPUTER LOCKSTITCH  
MACHINE WITH SIDE CUTTER

## 使用说明 · 零件手册

INSTRUCTIONS MANUAL&PARTS BOOK

本使用说明书内容，为了改良不经预告随时会更改，请谅解为盼。

## 使用说明书

为使您正确使用本机，须对本机的各种功能充分了解，以便安全操作。

使用前请仔细阅读使用说明书。我们希望您能长期愉快地使用本机，请保存好说明书，以备查阅。

- 1、无论您何时使用本机，须了解基本的安全事项，包括但不限于下列事项。
- 2、通读所有说明，并保存好使用说明书，如果需要，请随时翻阅。
- 3、使用本机前，必须弄清与本机有关安全规定、标准在您的国家是否适用。
- 4、使用本机前或使用本机时，所有安全装置必须配备齐全。机器运转时，无安全装置属违章操作，决不允许。
  - 5、操作人员必须经过适当的培训。
  - 6、为了您的人身安全，我们建议您戴上防护眼镜。
  - 7、下列情况下，请关闭电源开关或拔下电源插头。
    - 7-1机针穿线和换梭心。
    - 7-2更换机针、压脚、针板、送料牙、布料导板等。
    - 7-3进行维修时。
    - 7-4操作区域无人时。
  - 8、在机器加油润滑时，若不小心让油碰到眼睛、皮肤或咽下机油或润滑油，请立即冲洗被沾染部位或去医院检查。
  - 9、无论机器运转与否，严禁乱动机器零部件和配套装置。
  - 10、机器的维修、改造和调整等工作必须由专业技术人员进行。
  - 11、一般的维修和检验工作应由专业受训人员进行。
  - 12、有关电器部件的维修必须在专业电器人员或专业技术人员的指导下进行，任何电器部件一经发现受损，立即停止机器运转。
  - 13、使用期间要定期全面彻底清洗机器。
  - 14、正常操作本机时，必须进行试运转，工作环境远离强噪声源。
  - 15、由电器人员选择合适的插头和有接地线的插座。
  - 16、若需要改造或改进本机，请采用有效可行的安全措施。本公司对此产生的伤害不承担责任。
  - 17、本机只适用于专业缝纫。
  - 18、两种警提示符



操作人员或维修人员请注意



特别注意事项

✧ This book was prepared based on information available in October 2009.

## INSTRUCTION MANUAL

To get the most out of the many functions of this machine and operate it in safely, it is necessary to use this machine correctly.

Please read this Instruction Manual carefully before use. We hope you will enjoy the use of your machine for a long time.

Please remember to keep this manual in a safe place

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 of disconnect the power plug of the machine from the receptacle.
  - 7-1 For threading needle (s) and replacing bobbin.
  - 7-2 For replacing part (s) of needle, presser foot, throat plate, feed dog, cloth guide etc.
  - 7-3 For repair work,
  - 7-4 For when leaving the working place of when the working place is unattended.
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. Repairing, remodeling and adjustment works must only be done by appropriately trained technicians or specially skilled personnel.
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. Periodically clean the machine throughout the period of use.

14. 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.
15. An appropriate power plug has to be attached to the machine by electric technicians. Power plug has to be connected to grounded receptacle.
16. The machine is only allowed to be used for the purpose intended. Other uses are not allowed.
17. Remodel or modify the machine in accordance with the safety rules/standards while taking all the effective safety measures. We assume no responsibility for damage caused by remodeling or modification of the machine.
18. Warning hints are marked with the two shown symbols.



Danger of injury to operator or service staff



Items requiring special attention

## 安全操作事项

	<p>1、为避免触电，请不要打开电机的电箱盖，也不要触摸电箱内部组件。</p>
	<ol style="list-style-type: none"> <li>1、为避免人身伤害,移动皮带罩,护手挡或安全装置时,请不要开动机器。</li> <li>2、为尽可能避免机器运转造成的人身伤害,手指、头部和衣服应远离上轮、皮带和电机。除此之外,上轮、皮带和电机周围不要放置任何物品。</li> <li>3、为避免人身伤害,当您打开电源开关或操作机器时,切勿将手放在机针下方。</li> <li>4、为避免人身伤害,机器运转时,切勿将手放入挑线杆防护罩内。</li> <li>5、旋梭高速运转时,勿将手指放在旋梭附近。另外,换梭心时,请关掉机器电源开关。</li> <li>6、为尽可能避免人身伤害,当翘起或抬升机头时,勿将手指放入机器内部。</li> <li>7、为尽可能避免机器的突然启动所造成的事故,抬起机头或移动皮带罩和皮带时,请关掉机器的电源。</li> <li>8、如果你的机器配用伺服电机,机器未运转时,电机无噪声。为避免机器的突然启动所造成的事故,请关掉机器的电源开关。</li> <li>9、为避免触电,移动电源线时,请勿让机器运转。</li> <li>10、为尽可能避免触电或电器组件受损,在插上或拔下插头之前,请关掉电源开关。</li> </ol>

# FOR SAFE OPERATION



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.



1. To avoid personal injury, never operate the machine with any of the belt cover, finger guard or safety devices removed.
2. To prevent possible personal injuries caused by being caught in the machine, keep your fingers, head and clothes away from the handwheel, cover and the motor while the machine is in operation. In addition, place nothing around them.
3. To avoid personal injury, never put your hand under the needle when you turn "ON" the power switch or operate the machine.
4. To avoid personal injury, never put your fingers into the thread take-up cover while the machine is in operation.
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.
6. To avoid possible personal injuries, be careful not to allow your fingers in the machine when tilting/raising the machine head.
7. To avoid possible accidents because of abrupt start of the machine, turn OFF the power to the machine when tilting the machine head.
8. If your machine is equipped with a serve-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.
9. To avoid electrical shock hazards, never operate the sewing machine with the ground wire for the power supply removed.
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.

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## 1. 开车前的注意事项 BEFORE OPERATION

- 1、机头装箱前为了防止机件生锈，各部分均涂有较厚的防锈油脂，同时机头装箱后，还可能在较长的贮藏和长途运输阶段造成油脂硬化和积聚在机器表面的灰尘，所以必须将表面的油脂和灰尘用汽油和洁净的软布拭擦干净。
- 2、机器出厂时，虽经过周密的检查和试验，但在长途运输中也可能受到强烈的震动使机件松动或歪曲，所以应该作一次周密的检查，并用手转动主动轮，看机件之间有无转动困难，碰撞现象或其它不均匀的阻力，不正常的声响，如有应作适当的调整，机器状态正常后才可正式试车。
- 3、油盘内机油液面高度没在正常范围内绝不能开车。
- 4、机器运转时，上轮转向应该是逆时针方向（从上轮外侧面看）。
- 5、确认电机标牌上所标电压及相位是否正确。
- 6、生产日期见合格证。

1. In order to resist rust before machine head packing, all parts are smeared with thick rust-resistant oil. After packing, perhaps in a relatively long storage and transportation period, the oil will harden and absorb dusts. Therefore, it's necessary to clean the oil and dusts with neat soft cloth and gasoline.
2. The machine are examined and checked thoroughly before leaving the factory. But in a long journey, the machine may be shaken intensely and some parts become loose. It's advisable to test again and turn the driving gears with hands so as to make sure if turning is difficult, run foul of each other or if there is non-uniform block or irregular voice. If so, the machine should be adjusted until every part is normal before driving.
3. Operation are forbidden before pouring oil in the plate.
4. When the machine is in operation, the direction of the upper wheel are anti-clockwise (viewing from the outer part of the upper wheel).
5. Confirm the given electric voltage and phase on motor nameplate.
6. The date of manufacture is shown on the inspection certification.

## 2. 使用注意事项 OPERATION PRECAUTIONS

- 1、当接通电源或机器运转时，请勿将手与机针接触。
  - 2、机器运转时，请勿将手指伸入挑线杆护罩内。
  - 3、操作者用手送料时，请勿将手指伸入护针架。
  - 4、机头翻动及拆后盖时，一定要切断电源。
  - 5、操作者离开机器时，必须切断电源。
  - 6、机器运转时，注意不允许任何人的头或手以及任何东西靠近上轮、后盖、绕线器。
  - 7、只有在停机时，才能装卸防护罩、或其他保护装置。
  - 8、不能用香蕉水等油漆稀释剂擦洗机头表面。
1. When the power supply is open or the machine is operating, don't touch the machine needle with your hands.
  2. When the machine is running, don't stretch your hands in the mat of the thread stitch bar.
  3. When the machine head is turning and the "V" belt is being disassembled, the electric supply should be cut off.
  4. When the operator is leaving the machine, cut out the power supply.
  5. When the machine is running, no heads, hands or any other things are allowed to get close to the upper wheels, "V" belts bobbin winder and motor.
  6. Not until the machine stops running can you disassemble the belt cover, protection cover or other protecting devices?
  7. The machine head's surface can't be cleaned with dilutes such as banana oil.
  8. Don't put your finger into the finger guard when you feed material by hand.

### 3. 主要技术规格 CHIEF TECHNICAL SPECIFICATIONS

规格	型号	带刀直驱缝纫机
缝料		薄料至中厚料
最高转速 (rpm)		4500
最大针距 (mm)		5
机针		DBX1 #14
压脚提升高度	手控 (mm)	6
	膝控 (mm)	13
润滑系统		自动
润滑油		10号白油
电机功率		220伏/500瓦

Specifications	Modle	Provided with cutter and direct drivewith motor of sewing machine
Sewing material		Light -middle thick materials
Sewing speed(Max)		4500rmp
Maximum stitch length		5mm
Needle		DBX1 #14
Pressure foot lifting high		6mm(standard) 13mm(max)
Lukr Cant System		Automatism
Lukr Cant Oil		#10 White oil
Motor Power		220v/500w

### 4. 机器的安装 (图1、图2、图3、图4) INSTALLATION (FIG. 1,FIG.2,FIG.3,FIG.4)

#### 1. 油盘安装

- 1) 油盘应放置在台板凹槽四角。
- 2) 将两只机头坐垫①安装在油盘③的A边(朝操作者一边), 将两只油盘支座②安装在油盘③的B边(用机头连接钩接合一边), 然后放上油盘③(图1、图2)
- 3) 将机头连接钩①插入底板销孔内, 与台板的机头连接钩座②相嵌合再把机头放到油盘四只角的坐垫上。(图3、图4)

#### 1. fixing oil tray

- 1) Oil tray should be put at the four corners of the slot in table plate.
- 2) Fix two arm cushion "1" to the "A" side of oil tray "3" (facing the operator). fix the two stand bases "2" to the "B" side of oil tray "3" (hinge side), then fix the oil tray "3" (picture 1, picture 2).
- 3) Plug the hinge "1" into hole of bed plate, put the machine head on the table plate, hinge at the sink place and then fix the machine head on cushions of the four oil tray corners (picture 3, picture 4).



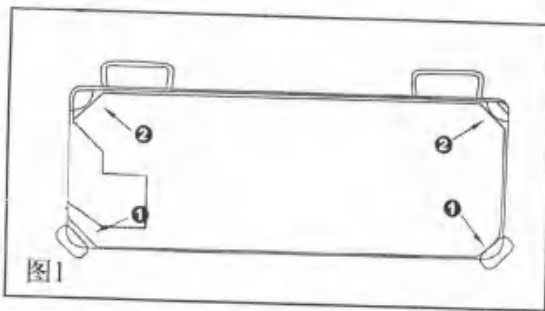


图1

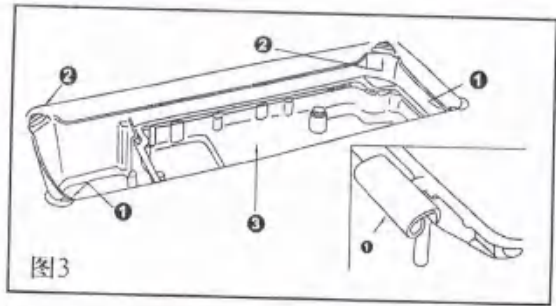


图3

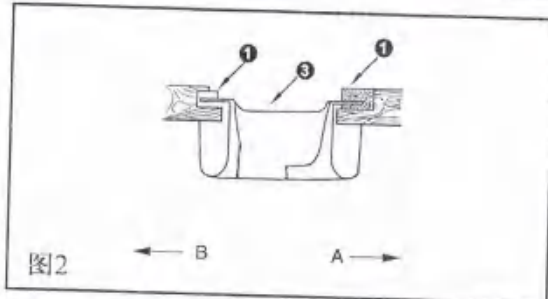


图2

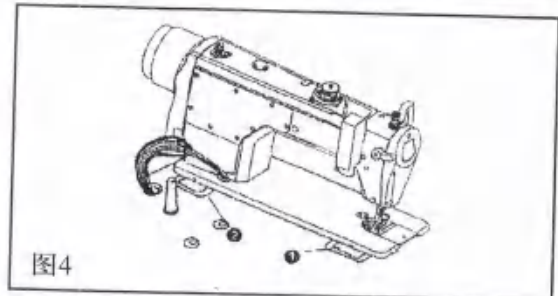


图4

## 5. 机器的润滑 (图5、图6) LUBRICATION (FIG.5)

### 1. 润滑须知:

- 1). 向油盘①注入缝纫机油 (10号白油) 至HIGH记号A。
- 2). 当油面低于LOW记号B, 应再加油。
- 3). 加油后, 开动机器, 应看到油液飞溅到油窗②上, 说明润滑正常。
- 4). 至于飞溅的油量多少与总润滑油量多少无关。

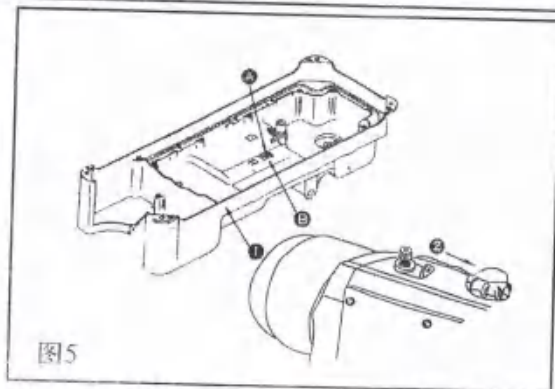


图5

### 1. Information on lubrication(Fig.5)

- 1) Fill oil pan①with sewing machine oil (10 white oil)up to HIGH mark A.
- 2) when the oil level lowers below LOW mark B,refill the oil pan with the specified oil.
- 3) when you operate the machine after lubrivation,you will see splashing oil through oil sight window②if the lubrication is adequate.
- 4) Note that the amount of the splashing oil is unrelated to the amount of the lubricating oil.

### \*Precaution

when you first operate your machine after set up or after an extended period of disuse,run your machine at 2,000 sp.m to 2,500s.p.m for about 10 minutes for the purpose of break-in.

## 6. 旋梭油量调节 (图6、图7、图8) ADJUSTING THE AMOUNT OF OIL (OIL SPLASHES) IN THE HOOK (FIG.6.7.8)

### 1. 调节前的注意事项

- 1). 未使用的机器应进行约3分钟的空转 (适当的断续运转)。
- 2). 油量纸必须在机器运转状态下插入。
- 3). 确认油盘内的油面高度处在HIGH和LOW范围内。
- 4). 油量确认时间需5秒钟 (请用秒表计时)。

## 2. 适当的油量标样:

1) .下图标样根据不同的缝制工序需进行增或减的微调整, 但应注意不要增加或减少过多。

油量过少会引起旋梭发热, 油量过多会油污缝料。

2) .用三张油量纸试用三次, 调节旋梭油量, 直至纸上油迹不发生变化为止。

## 3. 调节旋梭油量:

1) .将下轴前轴套上的油量调节螺钉朝+方向A转动时, 油量将增大。当油量调节螺钉朝-方向B转动时, 油量将减小。

2) .调整后应进行约30秒钟的空转, 以确认油量状态。

1. Notice before adjustment:

1) The unexpended machine should run without material for around 3 minutes.(or suitable running now and then ).

2) Plug in the oil amount paper only when the machine is running.

3) Make sure the oil height in the oil plate ranges between HIGH and LOW.

4) The confirming time of the oil amount is 5 seconds (by manual time -keeping).

2. Appropriate oil amount sample:

1) In the following sample figures,tiny adjustments may be considered according to different sewing process but not too much oil may cause the warming of spinning shuttle and contaminate the material.

2) Try the oil amount paper three times and adjust the oil amount of the spinning shuttle until the oil trail on the paper is stable.

3. Adjust the oil amount of the spinning shuttle:

1) Turning the oil adjusting screw of the front shaft sleeve on bottom shaft towards + direction A, the oil amount will increase ,and towards -direction B,the oil amount will decrease.

2) After adjustment without material for 30 seconds to confirm the condition of the oil amount.

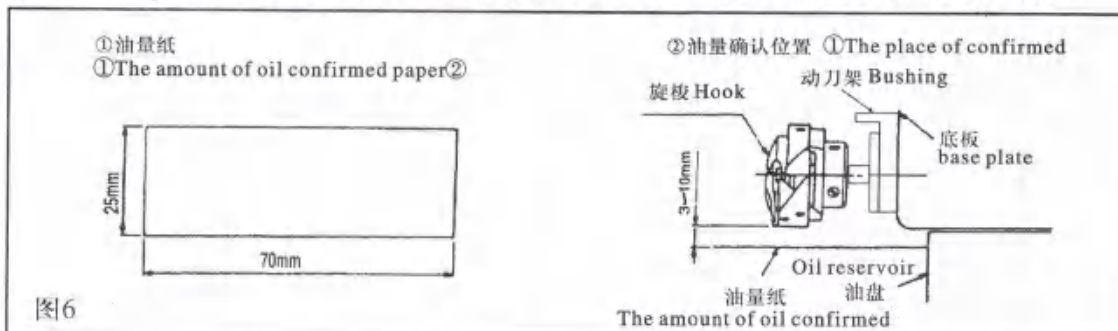


图6

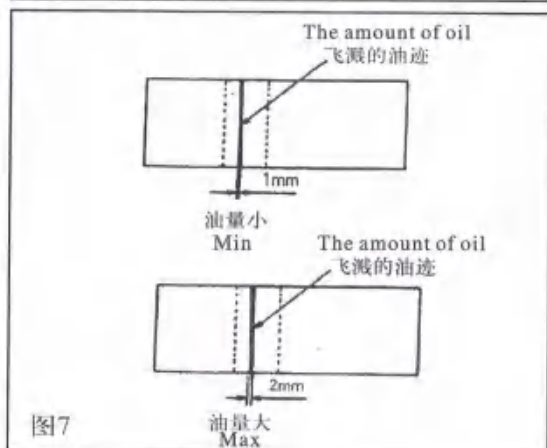
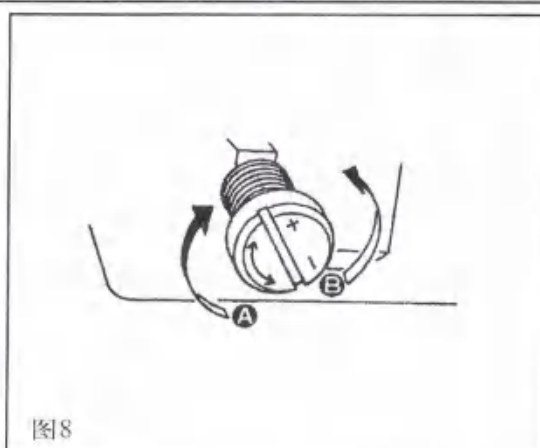


图7



## 7. 机针的装法 (图9) ATTACHING THE NEEDLE (FIG.9)

注意：在装机针前，必须切断电动机的电源。  
机针有各种编号，根据所用线的粗细和缝料来选择适当的机针。

- 1). 转动上轮使针杆上升到最高位置。
- 2). 旋松支针螺钉②，使机针①的凹弧部分A正对右方向B。
- 3). 将机针朝箭头方向插入针孔的底部，直至插不进为止。
- 4). 旋紧支针螺钉②。
- 5). 务必使机针的长槽C正对左方向D。

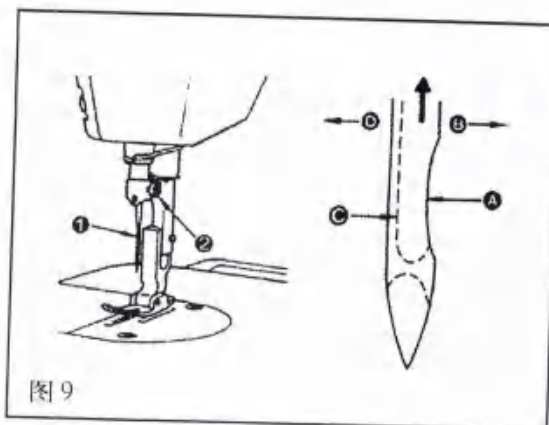


图9

\* Turn the motor power OFF before starting to attach the needle.

Select a proper needle size according to the count of thread and the type of material used.

- 1) Turn the handwheel until the needle bar reaches the highest point of its stroke. highest point of its stroke.
- 2) loosen screw ②, and hold needle ① with its indented part A facing exactly to the right in direction B.
- 3) Insert the needle in the direction of the arrow until it will go no further.
- 4) Securely tighten screw ②.
- 5) Check that long groove C of the needle is facing exactly to the left in direction D.

## 8. 梭心的装法(图10) SETTING THE BOBBIN INTO THE BOBBIN CASE (FIG.10)

- 1). 拿出梭子，将梭心装入梭子内。
- 2). 将线从梭子上的线槽A中穿过，朝B方向拉出这样，线通过夹线簧下从线孔B处引出。
- 3). 拉底线C时，梭心应按箭头方向转动。

- 1) Hold the bobbin in a way that the thread open end is directed to the right as observed from you, and set the bobbin into the bobbin case.
- 2) Pass the thread through thread slit, and pull the thread in direction. By so doing, the thread will pass under the tension spring and come out from notch.
- 3) Check that the bobbin rotates in the direction of the arrow when thread is pulled.

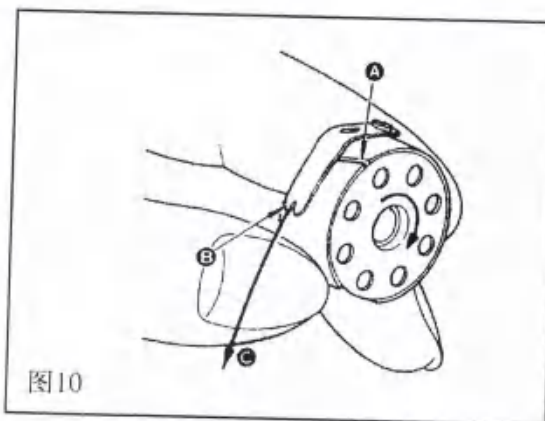


图10

### 9. 面线的穿法(图11) THREADING THE MACHINE HEAD (FIG.11)

穿面线时针杆应在最高位置，然后由线架上引出线头按如图示顺序穿线。

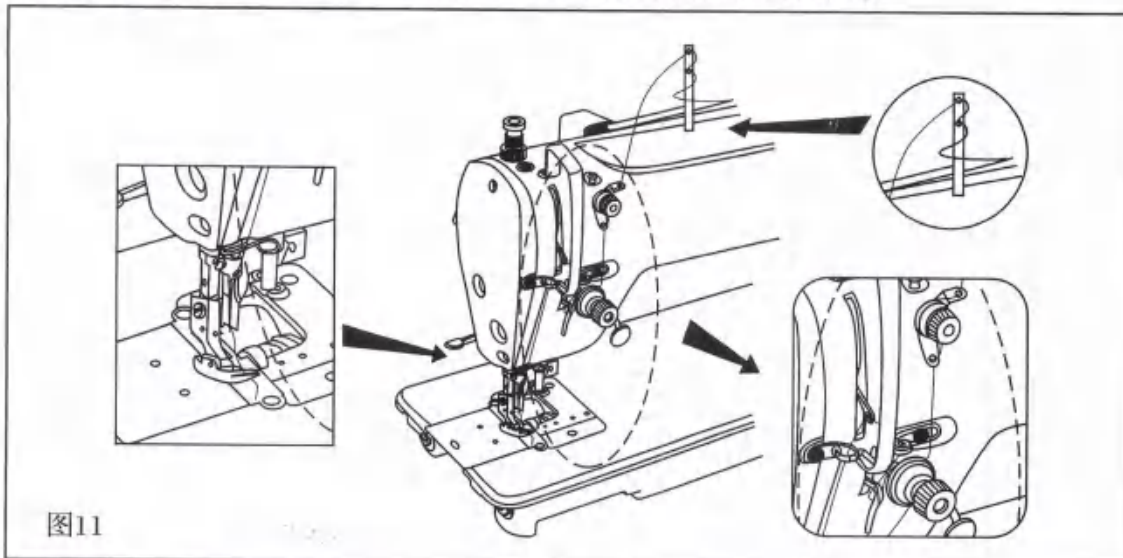


图11

### 10. 底线的绕法(图12) WINDING THE BOBBIN (FIG.12)

底线卷绕时，线的穿法及切线如图13所示。

Thread the bobbin winder and wind the bobbin thread onto the bobbin illustrated in the figure 13.

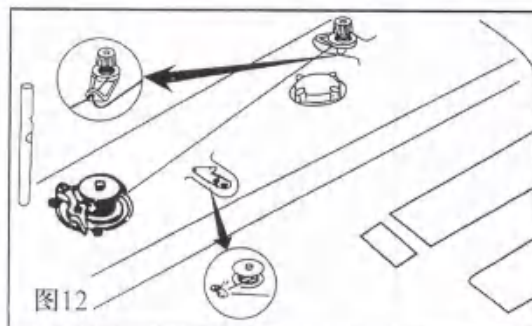


图12

### 11. 针距的调节(图13) ADJUSTING THE STITCH LENGTH (FIG.13)

- 1). 将送料距旋钮①朝箭头方向转动，旋至所需数字对准机壳上的刻点A
- 2). 旋钮上的刻度数字用毫米表示。
- 3). 当你向缩短线迹长度时，把倒送料扳手②朝箭头方向压的同时，转动送料距旋钮。

- 1) Turn stitch length dial ① in the direction of the arrow, and align the desired number to marker dot (A) on the machine arm.
- 2) The dial calibration is in millimeters.
- 3) When you want to decrease the stitch length, turn stitch length dial ① while pressing feed lever ② in the direction of the arrow.

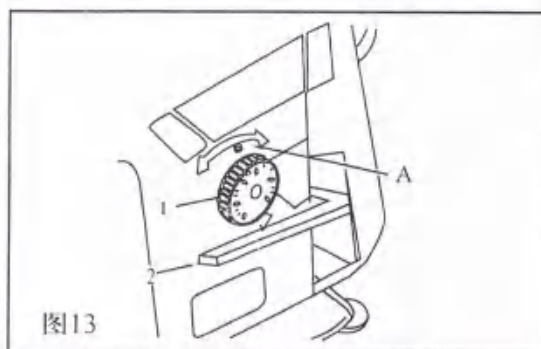


图13

## 12. 线架的装法 (图14) INSTALLING THE THREAD STAND (FIG.14)

1). 安装线架部件, 并将它插入缝纫机台板孔里。

2). 旋紧线架杆下节螺母 ① 固定线架装置。

1). Assemble the thread stand unit, and insert it in the hole in the machine table.

2). Tighten locknut ① to fix the thread stand.

3). For ceiling wiring, pass the power cord through spool rest rod ②

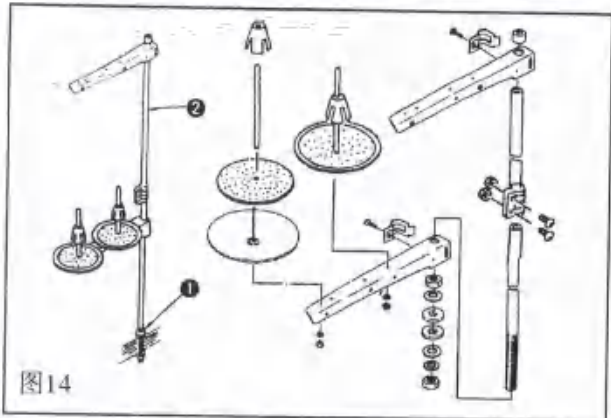


图14

## 13.1. 定刀和动刀的更换 (图15、图16、图17.1 (旋刀) REPLACE THE COUNTER KNIFE AND MOVING KNIFE (FIG15, FIG16, FIG17.1)

### 1. 定刀的拆卸方法

1. 将缝纫机放倒

2. 取下紧固螺钉①和旋梭定位勾②

3. 拆下沉头螺钉③和定刀④

\*切线不良时请磨定刀④ (如图16)

### 2. 移动刀的拆卸方法

1. 用压脚扳手将压脚抬起

2. 拆下沉头螺钉⑤, 取下针板⑥

3. 转动缝纫机主动轮, 将针杆停止在最高位置

4. 将刀轴连杆⑦按箭头方向用手推动, 停在沉头螺钉⑧显露的位置

5. 拆下沉头螺钉⑧, 取下移动刀⑨  
注1) 拆针板⑥及动刀⑨时请先取下机针。

注2) 组装按相反的顺序进行。

1. The method of tearing down the counter knife

1). Put down the sewing machine

2). Take down the screw ① and positioning finger ②

3). Take down the screw ③ and counter knife ④ (Fig.16)

\* Please the grinding the counter knife when it is not good for cutting thread

2. The method of tearing down the moving knife

1). Lifting the preser foot for using hand lifter

2). Take down the screw ⑤, put down the needle plate ⑥

3). Turn the wheel and stop the needle bar ni its highest posttion

4). Drive the knife link ⑦ as illustrated by the arrows, and stop to the position when screw ⑧ is unfolded

5). Take down the screw ⑨ and noving knife

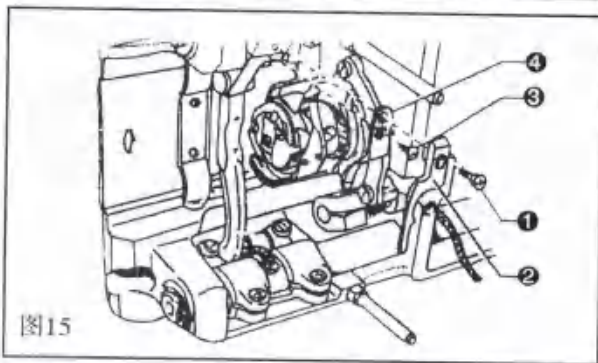


图15

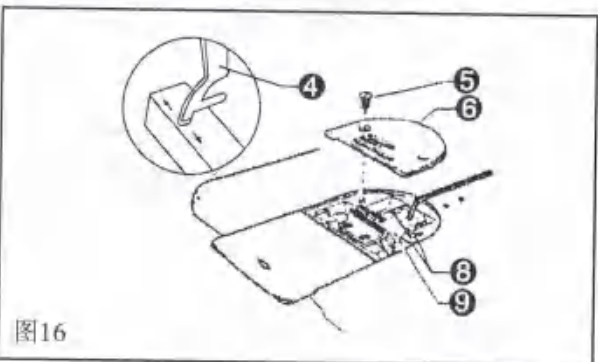


图16

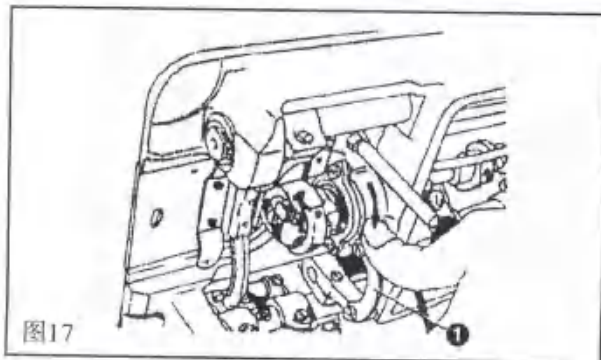


图17

Attention:

- 1). Please take down the needle before removing the needle plate and moving knife
- 2). Assemble by reversing sequence

### 13.2. 剪线的装置的调整 (图17.2) (旋刀) ADJUSTING THE THREAD TRIMMING EQUIPMENT (FIG17.2) (ROUND KNIFE)

#### (一) 剪线凸轮位置的调节

转动缝纫机的上轮, 当针杆从最低位置上升5mm时, 用手压剪线电磁铁④使滚珠接触剪线凸轮①的凹部, 然后用定位螺钉②临时紧固。然后把剪线电磁铁④返回原来的位置 (离开位置), 同时旋松定位螺钉②调整剪线凸轮①, 使凸轮端面 and 切线驱动轴端面之间的间隙为0.5mm。(以40kg.cm的扭矩拧紧定位螺钉②)

#### (二) 移动刀, 定位刀位置的调整

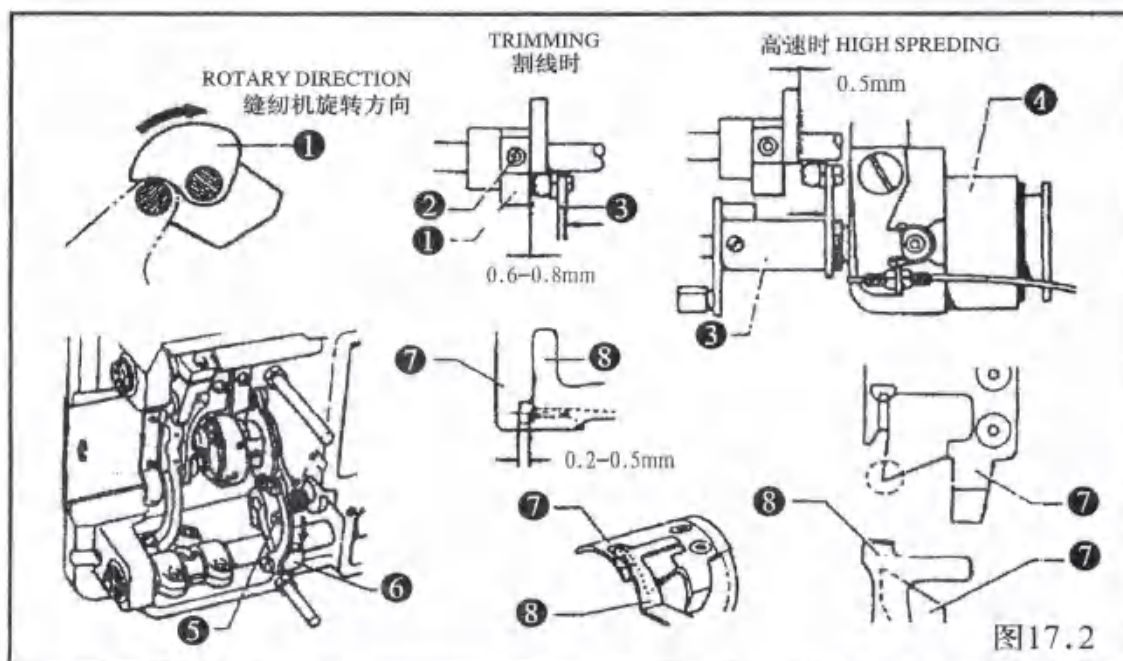
当切线驱动轴③的头部超过剪线凸轮时, 定刀⑧的前端和动刀⑦的刀刃部应当啮合0.2-0.5mm。当不啮合时, 在切线驱动轴超过剪线凸轮①的情况下移动刀轴连杆⑥, 使定刀⑧的前端和动刀⑦的刀刃部相啮合, 然后拧紧螺钉⑤。

#### (一) Adjusting the position of the thread trimming cam.

If you run the handwheel of the machine, the needle bar goes from the bottom up to 5mm, then the thread trimming solenoid ④ is pressed to impel the roller ball touches to the concave of the thread trimming cam ①, Then use the position screw ② to tighten it in casual. And then replace the thread trimming solenoid ④, while loose the screw ② to adjust the cam ①, the clearance of the end plane between the cam and thread trimming driving shaft is 0.5mm. (Use the torion with -40kg.cm to tighten the position screw ②)

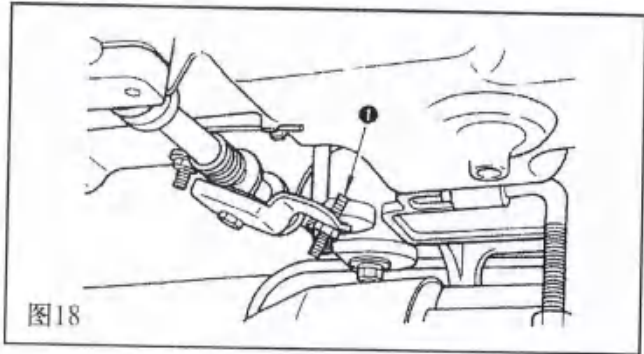
#### (二) Adjusting the position of the counter knife and moving knife.

When the head of the thread trimming driving shaft ③ exceeds the cam, the mesh between the front plate of the counter knife ⑧ and the edge of the moving knife ⑦ is 0.2-0.5mm. If they are not meshed, moves the knife shaft crack rod ⑥ before the thread trimming driving shaft exceeded the cam ①, the front plane of the counter knife ⑧ and the edge of the moving knife is meshed, then tighten the screw ⑤.

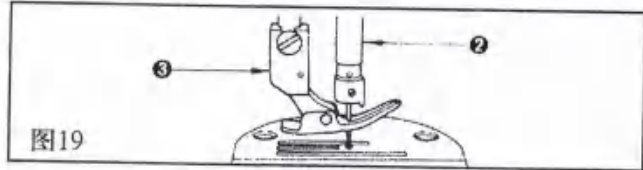


## 14. 膝提高度的调节 (图18、图19) ADJUSTING THE HEIGHT OF THE KNEE LIFTER (FIG.18,19)

- 1). 用膝提时的标准压脚高度是10毫米
- 2). 用膝提调整螺钉①可以调节压脚提升量至13毫米。
- 3). 当压脚提升超过10毫米时,不能使处于最低位置的针杆②底端与压脚③相碰。



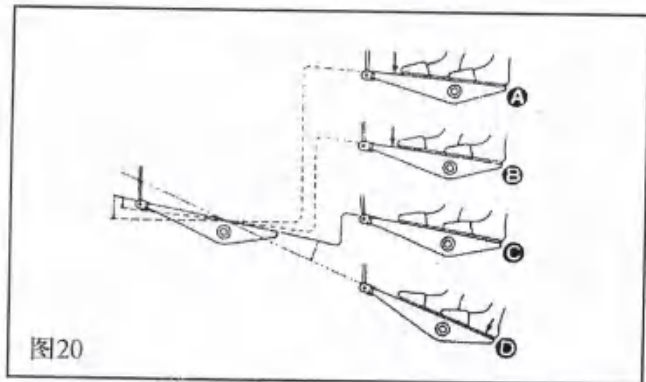
- 1) The standard height of the presser foot lifted using the knee lifter is 10mm.
- 2) You can adjust the presser foot lift up to 13mm using knee lifter adjust screw ①. (The max. lift should be 9 mm for the A type.)
- 3) When you have adjusted the presser foot lift to over 10 mm, be sure that the bottom end of needle bar ② in its lowest position does not hit presser foot ③.



## 15. 踏板操作 (图20) PEDAL OPERATION (FIG.20)

踏板分四个阶段操作:

- 1). 将踏板朝前轻踏, 则低速缝纫
- 2). 进一步朝前踏, 就是高速缝纫 (图示A)
- 3). 当踏板恢复到原始状态时, 机器停止运转 (上停针或下停针)。 (图示C)
- 4). 将踏板朝后踏, 执行剪线动作。 (图示D)



\*在执行高速缝纫或低速缝纫时, 将踏板朝后踏, 剪线动作能正常执行。

\*机器开始剪线后, 即时将踏板回复到中间位置, 剪裁动作也能完成。

\*当机器停止, 针处于下针位状态时, 如果要使处于上针位, 请将踏板朝后踏一次。

\*若机器安装自动抬压脚机构, 当机器停止后, 延时2-3秒, 再将踏板朝后踏一次, 则压脚自动抬起。踏板复位, 则压脚自动放下。

1. The pedal is operated in the following four steps:

- 1) The machine runs at low sewing speed when you lightly depress the front part of the pedalⒺ.
- 2) The machine runs at high sewing speed when you further depress the front part of the pedalⒺ.
- 3) The machine stops(with its needle up or down) when you reset the pedal to its original positionⒸ.
- 4) The machine trims threads when you fully depress the back part of the pedalⒺ.

\* The machine will perform normal thread trimming even if you depress the back part of the pedal immediately following high or low speed sewing.

\* The machine will completely perform thread trimming even if you reset the pedal to its neutral position immediately after the machine started thread trimming action.

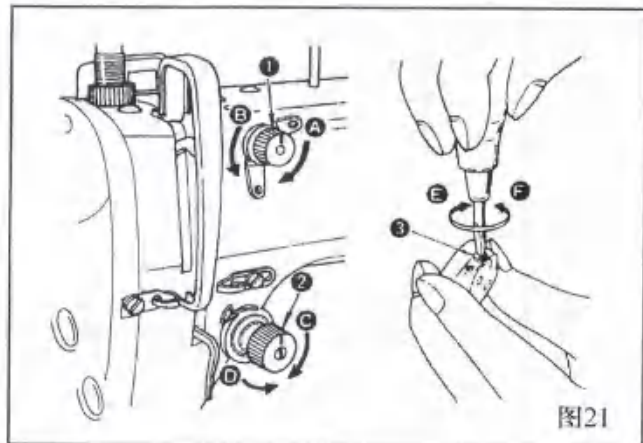
\* When the machine stops with its needle down ,and if you want to bring the needle up ,depress the back part of the pedal once.

\* If the machine is fixed with the automatic lifting pressure foot structure,after stopped the machine and delayed two or three seconds,then thrample the threadle backward once,so the pressure foot will lift automatically when the threadle reback,the pressure foot will be down automaticly.

## 16. 缝线张力 (图21) THREAD TENSION (FIG.21)

### 1. 面线张力的调节:

- 1). 若将上夹线螺母①朝顺时针方向(即A方向)转动时,剪线后,留在针孔处线的长度就会短些。
- 2). 若朝逆时针方向(即B方向)转动时,则线会长些。
- 3). 若将夹线螺母②朝顺时针方向(即C方向)转动时,面线张力将增大。
- 4). 若朝逆时针方向(即D方向)转动时,面线张力将减小。



### 2. 底线张力的调节:

- 1). 若将梭子上底线张力调节钉③朝顺时针方向(即E方向)动时,底线张力将增大。
- 2). 若朝逆时针方向(即F方向)动时,底线张力减小。

#### 1. Adjusting the needle thread tension

- 1) As you turn thread tension No.1 nut ① clockwise (in direction A). The thread remaining on the needle (in direction A). The thread remaining on the needle after thread trimming will be shorter. after thread trimming will be shorter.
- 2) As you turn nut ① counterclockwise(in direction B), the thread length will be longer.
- 3) As you turn thread tension No.2 nut ② clockwise (in direction C),the needle thread tension will be increased.
- 4) As you turn nut ② counterclockwise(in direction D), the needle thread tension will be decreased.

#### 2. Adjusting the bobbin thread tension

- 1) As you turn tension adjust screw ③ clockwise(in direction E), the bobbin thread tension will be increased.
- 2) As you turn screw ③ counterclockwise(in direction F),the bobbin thread tension will be decreased.



## 17. 挑线簧调节 (图22) THREAD TAKE-UP SPRING (FIG.22)

### 1. 改变挑线簧①的摆动量:

- 1). 旋松定位螺钉②。
- 2). 把夹线螺钉③朝顺时针方向 (即A方向) 转动时, 挑线簧的摆动量将增大。
- 3). 把夹线螺钉朝逆时针方向 (即B方向) 转动时, 挑线簧的摆动量将减小。

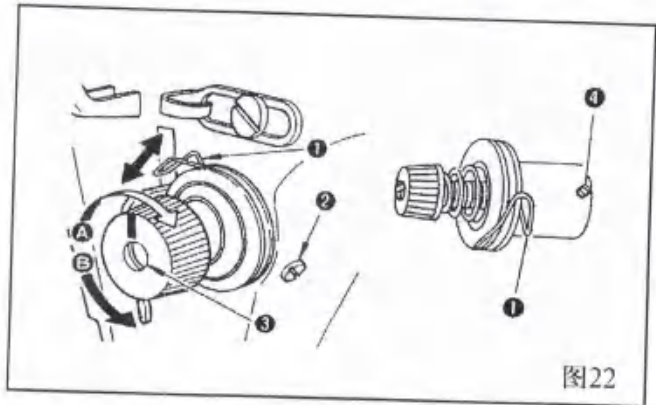


图22

### 2. 改变挑线簧①的张力:

- 1). 旋松定位螺钉②, 并转动夹线螺钉③。
- 2). 旋松定位螺钉④。
- 3). 把夹线螺钉③朝顺时针方向 (即A方向) 转动时, 挑线簧的张力将增大。
- 4). 把夹线螺钉③朝逆时针方向 (即B方向) 转动时, 挑线簧的张力将减小。

### 1. Changing the stroke of thread take-up spring①

- 1) Loosen setscrew②.
- 2) As you turn tension post ③ clockwise (in direction A), the stroke of the thread take-up spring will be increased.
- 3) As you turn the knob counterclockwise (in direction B) the stroke will be decreased.

### 2. Changing the pressure of thread take-up spring①

- 1) Loosen setscrew②, and remove tension post ③
- 2) Loosen setscrew④
- 3) As you turn tension post ③ clockwise (in direction A), the pressure will be increased.
- 4) As you turn the post counterclockwise (in direction B), the pressure will be decreased.

## 18. 压脚扳手 (图23) HAND LIFTER (FIG.23)

- 1). 停车后, 将压脚扳手①朝A方向转动, 使压脚抬起。
- 2). 压脚的抬起量约为5.5毫米。
- 3). 当压脚扳手①朝B方向转动时, 压脚将放回原来的位置。
- 4). 对膝提压脚而言, 压脚的抬起量约为10毫米, 最大抬起量约为13毫米。

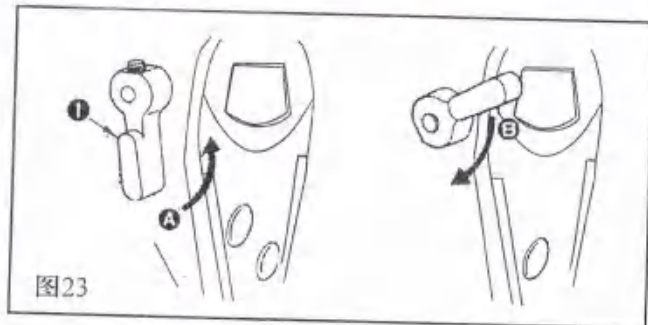
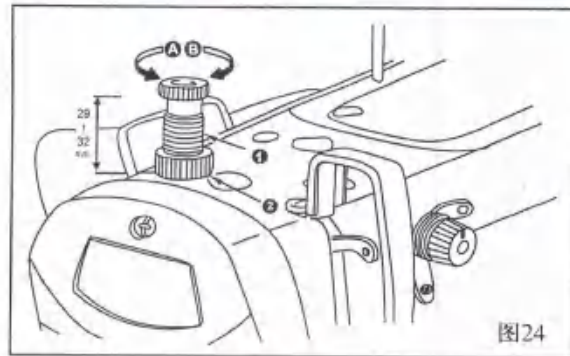


图23

- 1) To stop the machine with its presser foot up, turn hand lifter ① in direction A.
- 2) The presser foot will go up about 5.5mm and stop.
- 3) The presser foot will go back to its original position when hand lifter is turned down in direction B.
- 4) Using the knee lifter, you can get the standard presser foot lift of about 10mm and the maximum lift of about 13mm.

## 19. 压脚压力的调节 (图24) PRESSER FOOT PRESSURE(FIG.24)

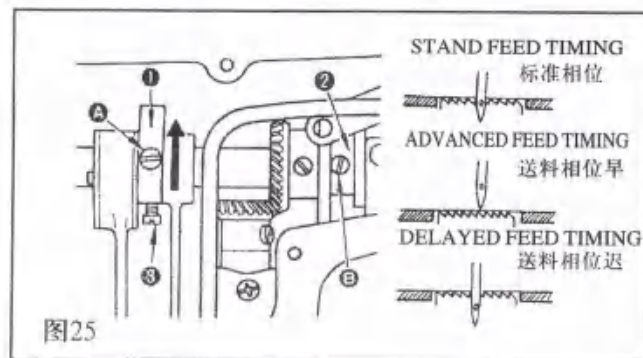
- 1) 旋松调压螺母②。顺向 (即A方向) 转动压脚调节螺钉, 压力将增强。
- 2) 逆向 (即B方向) 转动压脚调节螺钉, 压力将减弱。
- 3) 调整后, 旋紧调压螺母②。
- 4) 对一般布料而言, 压脚调节螺钉的标准高度为 29~32 毫米 (5公斤) 左右。



- 1). Loosen nut ② . As you turn presser spring regulator①clock wise(in direction A),the presser foot pressure will be increased.
- 2). As you turn the presser spring regulator counterclock wise (in direction B ),the pressure will be decreased.
- 3). After adjustment, tighten nut②
- 4). For general fabrics,the standard height of the presser spring regulator is 29 to 30mm(5kg).

## 20. 送料相位的调节 (图25) ADJUSTING THE FEED TIMING (FIG.25)

- 1) 在标准相位情况下, 将送料偏心轮①的定位螺钉A与上轴挡圈②的定位螺钉B对齐。
- 2) 调整时, 旋松送料偏心轮上两个定位螺钉③, 将送料偏心轮调到适当的位置上, 然后拧紧定位螺钉。
- 3) 为了防止缝料的潜移, 要加快送料相位, 可将送料偏心轮朝箭头方向调整。

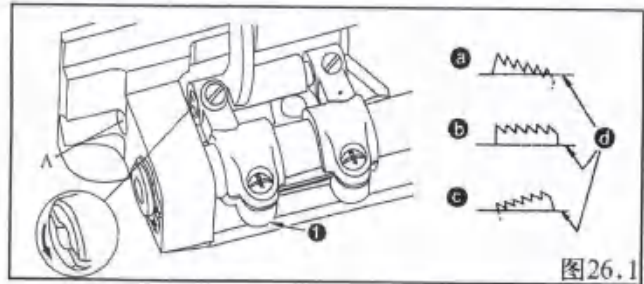


- 4) 为了增大线迹的紧密度, 要减慢送料相位, 可将送料偏心轮朝箭头相反方向移动。
- 5) 千万小心不要将送料偏心轮移动得太多, 不然的话, 会造成断针现象。

- 1)To obtain the standard feed timing align setscrew A on feed eccentric cam① with setscrew B on main shaft thrust collar②.
- 2)To make adjustment,loosen two setscrews③to release the feed eccentric cam, properly position the eccentric cam. Then retighten the setscrews.
- 3)To advance the feed timing in order to prevent uneven material feed move the feed eccentric cam in the direction of the arrow.
- 4)To delay the feed timing in order to increase stitch tightness, move the feed eccentric cam in the opposite direction for the arrow.
- 5)Be careful not to move the feed eccentric cam too far, or elae need breakage may result.

**21. 送料牙的倾斜 (图26.1) (旋刀)**  
**TILT THE FEED DOG (FIG.26.1) (ROUND KNIFE)**

- 1). 为了防止浮线, 要送料方向高, 则旋松固定螺钉, 用螺丝刀从A孔处把牙架销朝箭头方向移动90度。
- 2). 为了防止缝料的潜移, 要送料方向低, 则牙架销朝箭头相反方向转动90度。



a 前面高 b 标准 c 前面底 d 针板  
 ① Front up ② Standard ③ Front down ④ Throat plate

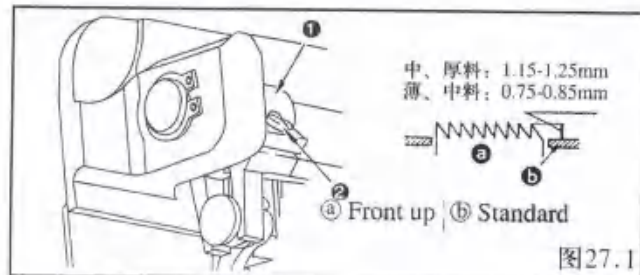
**\*注意**

无论什么时候, 调节送料牙的倾斜, 送料牙的高度将会变化。所以, 在调整之后, 请再次确认送料牙的高度。

- 1) The standard tilt (horizontal) of the feed dog is obtained when marker dot (A) on the feed bar shaft is aligned with marker dot (B) on feed rocker (1).
- 2) To tilt the feed dog with its front up in order to prevent puckering, loosen the setscrew, and turn the feed bar shaft 90 degrees in the direction of the arrow using a screw driver.
- 3) To tilt the feed dog with its front down in order to prevent uneven material feed, turn the feed bar shaft 90 degrees in the opposite direction from the arrow (Precaution) Whenever the feed dog tilt is adjusted, the feed dog height will be changed, So, it is necessary to check the feed dog height after tilt adjustment.

**22. 送料牙的高度 (图27.1) (旋刀)**  
**HEIGHT OF THE FEED DIG (FIG.27.1) (ROUND KNIFE)**

- 1). 送料牙一般应比针板高出 0.75-0.85毫米。厚料应高出1.15-1.25毫米。
- 2). 送料牙高度的调节:
  - (1) 旋松拾牙叉形曲柄①的紧固螺钉②。
  - (2) 上下移动牙架进行调节;
  - (3) 旋紧曲柄螺钉②。



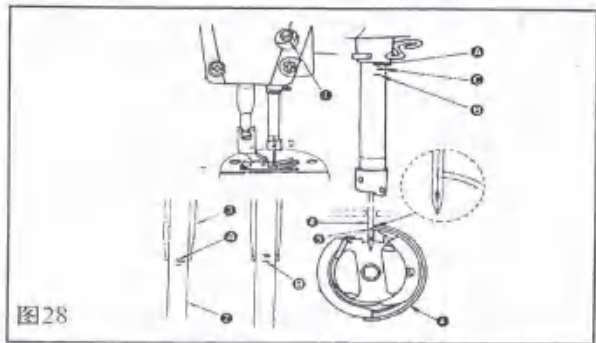
a 送料牙 b 针板  
 a. Feed b. Throat plate

- 1) The standard tilt (horizontal) of the feed dog is obtained when marker dot (A) on the feed bar shaft is aligned with marker dot (B) on feed rocker (1).
- 2) To tilt the feed dog with its front up in order to prevent puckering, loosen the setscrew, and turn the feed bar shaft 90 degrees in the direction of the arrow using a screw driver.
- 3) To tilt the feed dog with its front down in order to prevent uneven material feed, turn the feed bar shaft 90 degrees in the opposite direction from the arrow (Precaution) Whenever the feed dog tilt is adjusted, the feed dog height will be changed, So, it is necessary to check the feed dog height after tilt adjustment.

### 23. 针与旋梭的关系 (图28) NEEDLE-TO-HOOK RELATIONSHIP (FIG.28)

针与旋梭的关系应配合如下:

- 1). 转动上轮, 使针杆位于最低点, 再旋松针杆连接柱定位螺钉①;
  - \* 针杆高度的确定。
- 2). 使针杆②上的刻线A对准针杆下衬套③的下端, 然后旋紧针杆连接柱定位螺钉①。
  - \* 旋梭位置的确定。
- 3). 旋松两只旋梭定位螺钉, 并转动上轮, 使针杆②的下刻线B对准针杆下衬套③的下端。
- 4). 在上述状态下, 使旋梭的勾线尖⑤对准机针④的中心, 针与旋梭的间隙为0.04-0.1 mm, 然后拧紧旋梭紧固螺钉。
  - \* 旋梭原来用什么型号, 调换后, 也请使用原来的型号。

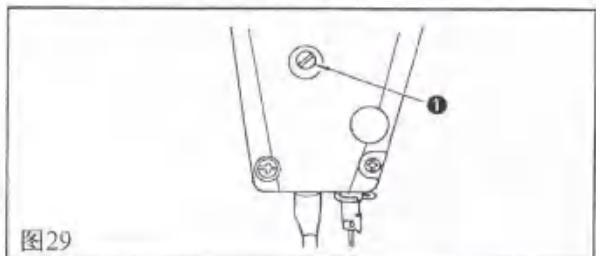


1. Adjust the timing between the needle and the hook as follows:
- 1) Turn the handwheel to bring the needle bar down to the lowest point of its stroke, and loosen setscrew ①.
  - \* Adjusting the needle bar height
  - 2) Align marker line A on needle bar ② with the bottom end of needle bar lower bushing ③, then tighten set-screw ①.
  - \* Adjusting position A of the hook
  - 3) Loosen the two hook setscrews, turn the handwheel, and align marker line B on ascending needle bar ② with the bottom end of needle bar lower bushing ③.
  - 4) After making the adjustments mentioned in the above steps align hook blade point ⑤ with the center of needle ④. Provide a clearance of 0.04mm to 0.1mm between the needle and the hook, then securely tighten the hook setscrews.
- \* Note that the type of hook to be substituted for, when replacing the hook, shall be in conformity with the very type of the hook installed in the sewing machine of original assemblage.

### 24. 压杆高度的调节 (图29) ADJUSTING THE HEIGHT OF THE PRESSER BAR (FIG.29)

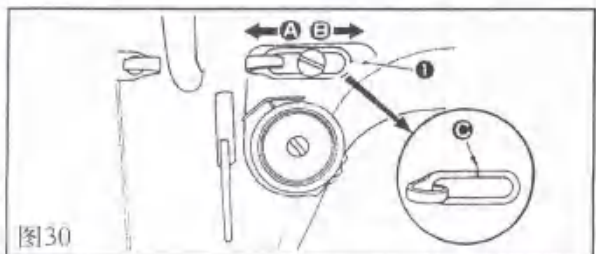
- 1). 旋松压杆导架紧固螺钉①, 调节压杆高度 (在压脚上升最高时, 针板面与压脚底面距离为5.5毫米)。
- 2). 调节后, 拧紧紧固螺钉。

- 1) Loosen setscrew ①, and adjust the presser bar height or the angle of the presser foot.
- 2) After adjustment, securely tighten the setscrew.



### 25. 挑线杆挑线量的调节 (图30) ADJUSTING THE THREAD TAKE-UP STAOKE (FIG.30)

- 1). 缝制厚料时, 应将右线钩①朝左方向A移动, 以增大挑线量。
- 2). 缝制薄料时, 应将右线钩①朝左方向B移动, 以减小挑线量。
- 3). 右线钩 1 上的刻线C与螺钉中心一致时为标准位置。



- 1) When sewing heavy-weight materials, move thread guide ① to the left (in direction ④) to increase the length of thread pulled out by the thread take-up.
- 2) When sewing light-weight materials, move thread guide ① to the right (in direction ⑤) to decrease the length of thread pulled out by the thread take-up.
- 3) Normally, thread guide ① is positioned in a way that marker line ③ is aligned with the center of the screw.

## 26. 停针位置的调整 (图31) ADJUSTING THE NEEDLE STOP POSITION (FIG.31)

### 1. 剪线后的上停针位置

接通电源开关, 在针上停止位置停下缝纫机时, 针板上平面到针尖的距离: 中厚料为10-20mm (即后盖上的刻点A与上轮上的红刻点B对齐); 厚料为10-14mm (即后盖上的刻点A与上轮上的白刻点E对齐)。

- 2) 要使上停针位置有所变化, 旋松两个紧固螺钉 ①, 就可在长槽范围内调整。

- ① 若螺钉朝C方向移动, 针杆 ② 在高位置停止;
- ② 若螺钉朝D方向移动, 停止位置则变低相应。

\*注意:

在旋松螺钉 ① 的时候, 请不要启动机器。此外, 螺钉 1 只要旋松即可, 不要拆下。

### 2. 下停针位置

\*注意: 针下停止位置不要调整

### 1. Needle position after thread trimming.

After switch on the machine, stop the machine as the needle goes to its highest position and then the distance between the needle plate upper plate and the needlepoint is: middle heavy cloth: 10-20mm (the red point A on the back cover aligns with the red point B on the upper wheel); the heavy cloth: 10-14mm (the red point A aligns with the point E on the upper wheel). If you want to change the needle position, loose the two fixed screws 1 and then you can adjust it in the long slot.

- ① If the screw moves to C, the needle bar ② stops at its highest position;
- ② If the screw moves to D, the needle bar stops at a lower position.

Remarks:

When loose the screw ①, please do not set up the machine; besides, just loose the screw ①, do not take it off.

### 2. The needle's lower position

Precaution: Don't adjusting the needle's stop position.

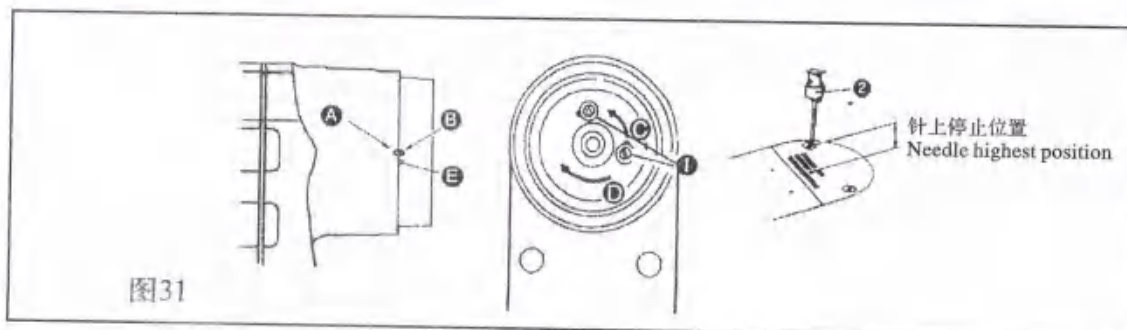


图31

## 27. 踏板压力与行程 (图32)

### PEDAL PRESSURE AND PEDAL STROKE (FIG.32)

#### 1. 踏板踩踏压力的调整

- 1) 摘下踏板压力调节弹簧 ① 进行调整;
- 2) 把弹簧挂到左侧压力变小;
- 3) 挂到右侧压力变大。

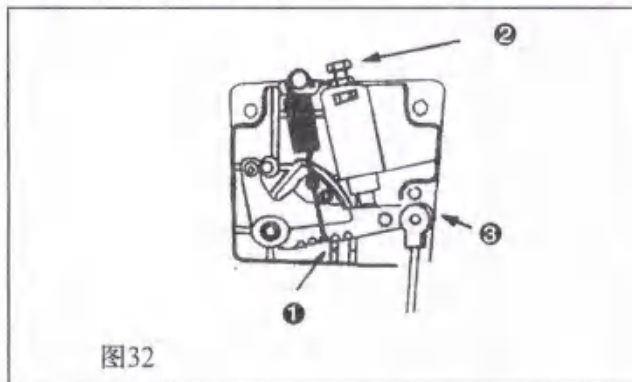
#### 2. 踏板返回力的调整

- 1) 用返踩调节螺钉 ② 进行调整;
- 2) 拧紧调节螺钉压力变大;
- 3) 拧紧螺钉压力变小。

#### 3. 踏板踩踏行程的调整

- 1) 把连接杆 ③ 安装到左侧的孔内, 行程变小。

1. Adjusting the pressure required to depress the front part of the pedal
  - 1) This pressure can be changed by altering the mounting position of pedaling pressure adjust spring ①. The pressure decreases when you hook the spring on the left side. The pressure increases when you hook the spring on the right side.



#### 2. Adjusting the pressure required to depress the back part of the pedal

- 1) This pressure can be adjusted using regulator screw ②.
  - 2) The pressure increases as you turn the regulator screw in.
  - 3) The pressure decreases as you turn the screw out.
- #### 3. Adjusting the pedal stroke
- 1) The pedal stroke decreases when you insert connecting rod ③ into the left hole.

## 28. 踏板的调整 (图33) ADJUSTMENT OF THE PEDAL (FIG.33)

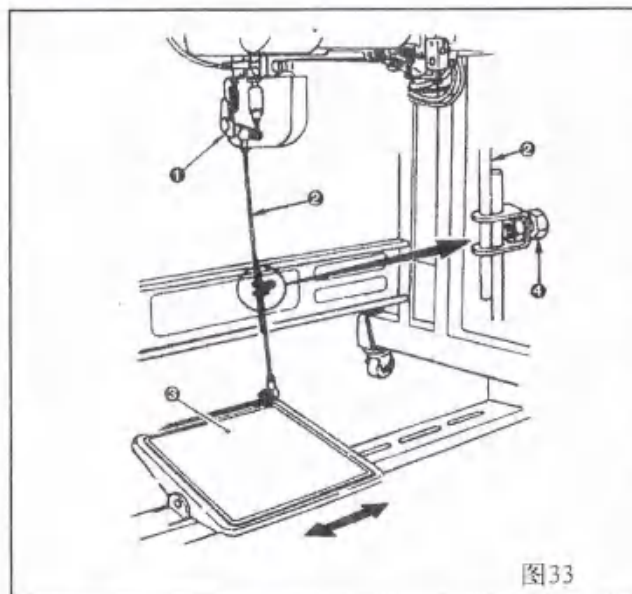
#### 1. 拉杆位置的调整:

- 1) 左右移动踏板调节板, 将踏板曲柄 ① 和拉杆部件 ② 垂直连接。

#### 2. 踏板角度的调整:

- 1) 踏板的倾斜, 可以根据拉杆长度的调节自由改变。旋松螺钉 ④, 就可以调节拉杆的 ② 长度。

1. Installing the connecting rod
  - 1) Move pedal to the right or left as illustrated by the arrows so that motor control lever and connecting rod are straightened.
- 2) Adjusting the pedal angle
  - 1) The pedal tilt can be freely adjusted by changing the length of the connecting rod.
  - 2) Loosen adjust screw, and adjust the length of connecting rod.



## 29. 手触倒缝装置 (图34)

### ONE-TOUCH TYPE REVERSE FEED STITCHING MECHANISM (FIG.34)

#### 1. 使用方法:

- 1) 手按手触倒缝开关①, 机器执行倒缝动作。
- 2) 机器执行自动倒缝与手按着开关按钮的时间同步。
- 3) 手一离开开关按钮, 机器又重新恢复到顺缝状态。

#### 2. 手触倒缝开关的高度

- 1) 调节手触倒缝开关①的高度, 使之便于操作。
- 2) 旋松螺钉②, 上下移动开关杆就可以调整它的高度。

#### 1. How to operate

- 1) Pressing the switch presses button 1, the sewing machine pours to sew immediately;
- 2) Proceed to pour to sew at time that press;

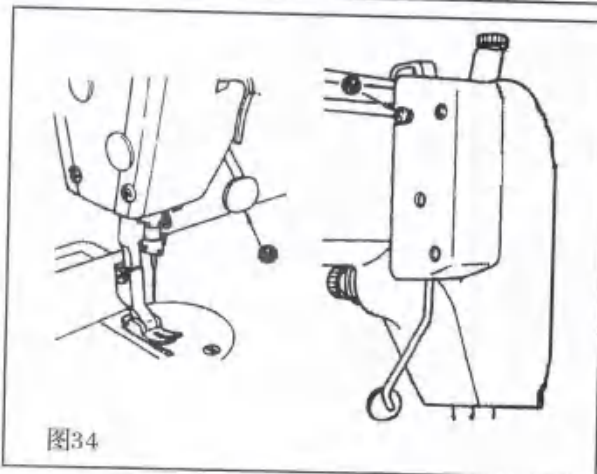


图34

- 3) Loosen to draw to change into namely facethe sewing;

- 4) Turning on the machinc hour floodlight is an all opening, pressing to move to press button 2 illuminate the ray will die down gradually,totally 3 class.

## 30. 针板组件的安装 (图35)

### NEEDLE PLATE INSTALLATION (FIG.35)

安装针板组件时, 一定要把切刀移动到最下端, 让针板组件轻轻地顶到切刀, 然后交替的拧紧两个固定螺钉。

Be sure move the cutter to the bottom to get needle plate complete touching knife, then tighten the screws by alternation when install needle place complete.

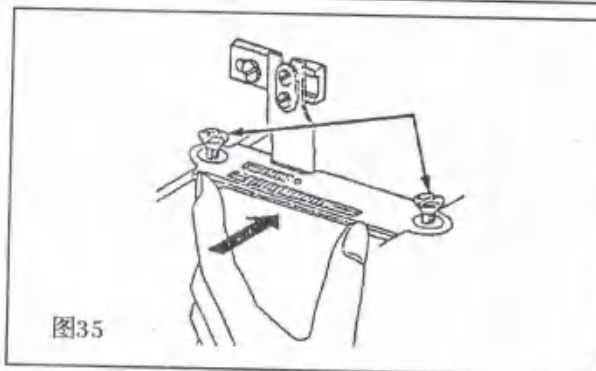


图35

## 31. 切刀的操作与安装 (图36、图37)

### OPERATON AND INSTALLATION OF CUTTER (FIG.36, FIG.37)

#### 1. 切刀的操作:

- 1) 让切刀动作时, 请按压控刀杆1, 使切刀下降, 刀架导向架与缝纫机同时驱动。
- 2) 让切刀停止动作, 转换为普通缝纫机使, 沿箭头方向拉出旋钮2即可。

#### 2. 切刀的安装:

- 1) 如图所示安装切刀, 切刀下降到最下点时, 上下移动切刀, 让切刀的A部比针板的上平面低0~0.5mm。

#### 3. 切刀宽度的变更:

- 1) 切断宽度通过更换针板组件来决定。更换时请拧松导向架导轨固定螺钉1, 平行地拉出切刀, 以保持良好的切断质量。因变更了针板组件的尺寸, 而需要变更切刀位置时, 请拧松螺钉2, 让切刀刃接触到针板组件的刀刃, 然后固定螺钉2。
- 2) 标准规格安装的是3.2mm的针板组件。

1. Operation of cutter  
 1) Letting cutter works, Pressing control knife pole to, make cutter down, driving by knife rest oriented frame and sewing machine.

2) Just pull knob 2 if want to make cutter knife shopping working to swith into common sewing machine use.

2. Installation of cutter

1) Install cutter as per picture, When cutter dropping to the rock-bottom, move knife by fluctuation, make "A" part of cutter lower 0-0.5mm than upper plane.

3. Adjust cutting width

1) Cutting width are decided by different needle plate complete. When changing, please loose screw driven frame rail 1, pill out of cutter knife by parallel to keep good quality of cutting width. If changing situation of cutter based on different needle plate complete, please loose screw 2 to make cutter-knife blade to touch blade of needle plate complete. Then tighten screw 2.

2) Standard equipment is 3.2mm needle plate complete.

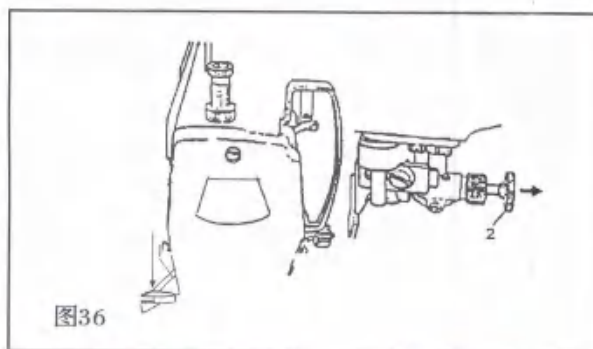


图36

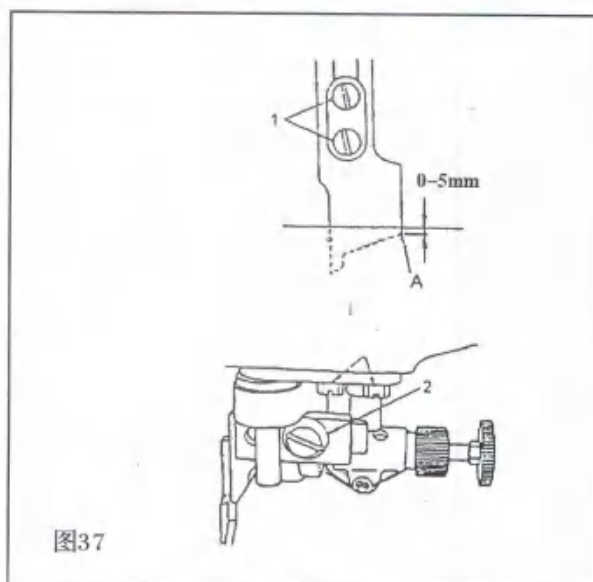


图37

### 32. 排屑孔盖板的使用 (图38)

#### USAGE OF CLEARANCE HOLE COCER (FIG.38)

1). 在使用布切刀时, 请先将排屑导板拆下, 然后把附属的排屑孔盖板到屑斗板上, 请A部上方按下。

2). 排屑孔盖板牢固的盖好后, 就可作为普通机器使用。

1) If no need function of cuttee, just discharge chip-rejecting guide plate then cover attaching clearance hole cover plate on chip-rejecting plate, please press from part A as per picture.

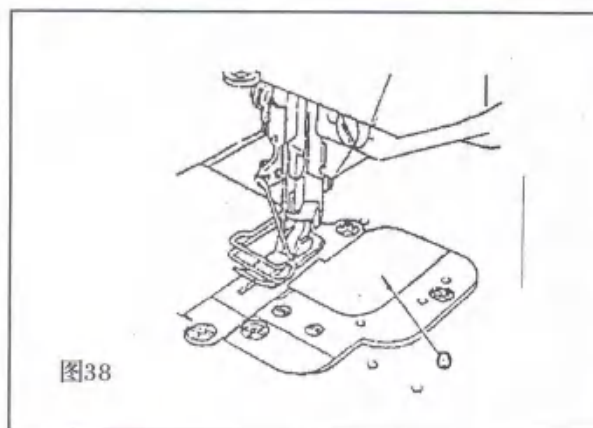


图38



**33. 其他切刀规格零件的更换**  
**CHANGE OF DIFFERENT CUTTER SPECIFICATION PARTS**

本机配备的标准裁断宽度是1/8"(3.2mm).根据用户需求,我们还另外配备了其它的规格,如需更换,请参阅相关零件更换一览表。

**Standard installation for cutting width is 1/8" ( 3.2 mm) ,other sizes please check the follow chart**

名称 裁宽 图号	针板组件	送布牙	压脚	排屑斗	布屑导板
3/32" (2.4)	3/32"	3/32"	1/8"	1/8"	1/8"
1/8" (3.2)	1/8"	1/8"			
5/32" (4.0)	5/32"	1/8"			
3/16" (4.8)	3/16"	1/4"	1/4"	1/4"	1/4"
1/4" (6.4)	1/4"	1/4"	1/4"	1/4"	1/4"
3/8" (9.5)	3/8"	3/8"	3/8"	3/8"	3/8"

name Cutter width Specifications	Needle plate complete	Feed dog	Presser foot	Clearance hole	Clearance hole guide plate
3/32" (2.4)	3/32"	3/32"	1/8"	1/8"	1/8"
1/8" (3.2)	1/8"	1/8"			
5/32" (4.0)	5/32"	1/8"			
3/16" (4.8)	3/16"	1/4"	1/4"	1/4"	1/4"
1/4" (6.4)	1/4"	1/4"	1/4"	1/4"	1/4"
3/8" (9.5)	3/8"	3/8"	3/8"	3/8"	3/8"

# 零件手册

## PARTS BOOK

本使用说明书内容，为了改良不经预告随时会更改，  
请谅解为盼。

The description in this operation manual is subject to  
change for improvement of the commodity without notice.

### 零件手册使用说明

- 1、本手册使用于封面上所示同种系列的缝纫机；
- 2、部分零件设计上的改变不预先通知用户；
- 3、本手册为2009年10月的版本

### Notes for using this parts book

- 1.This book is applicable to sewing machines which have the same plate number  
as shown on the cover of this book(or correction sheet).
- 2.Parts are subject to changes in design without prior notice.
- 3.This book was prepared based on information available in October 2009

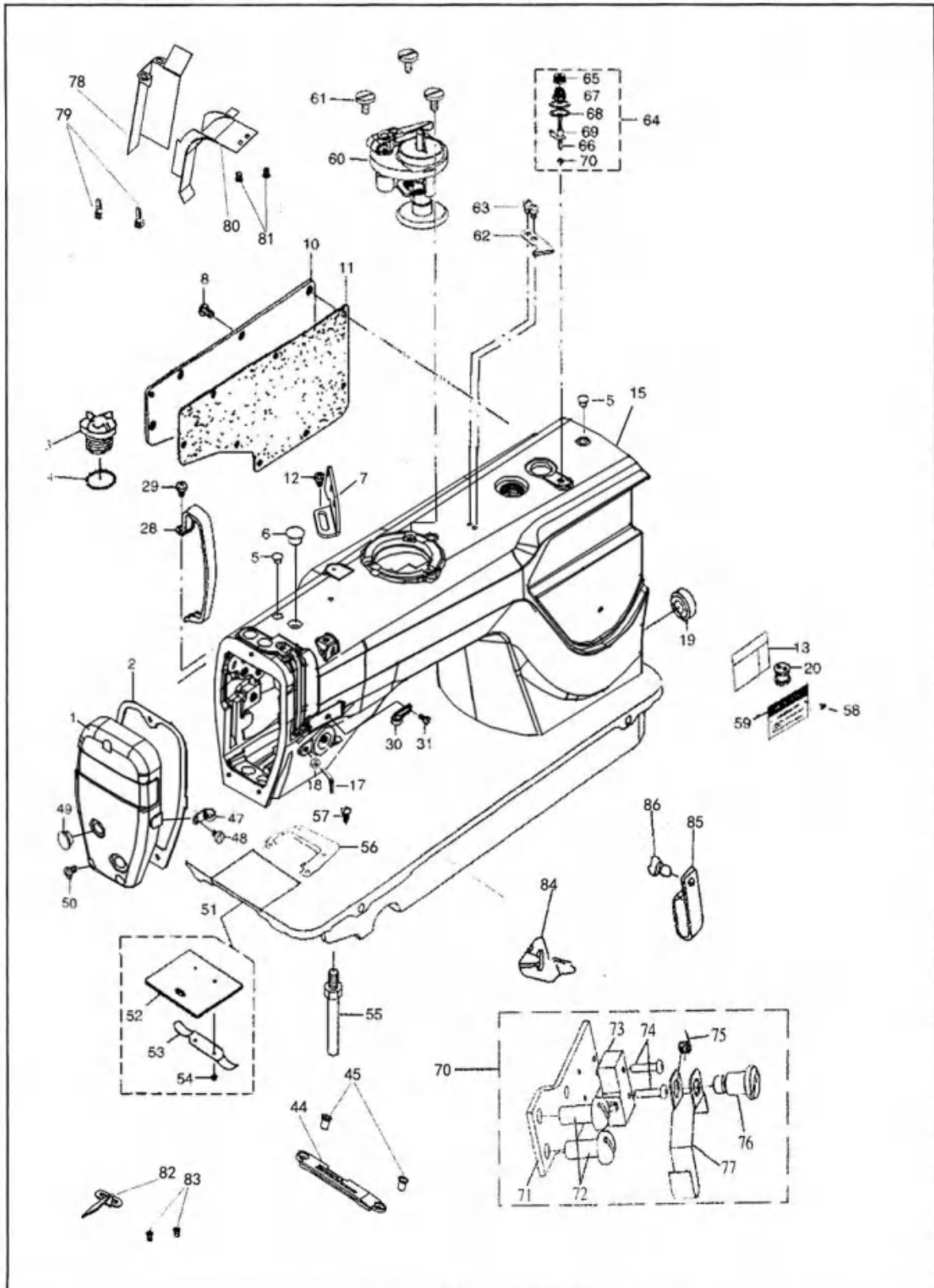
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# 1. 机壳分组件

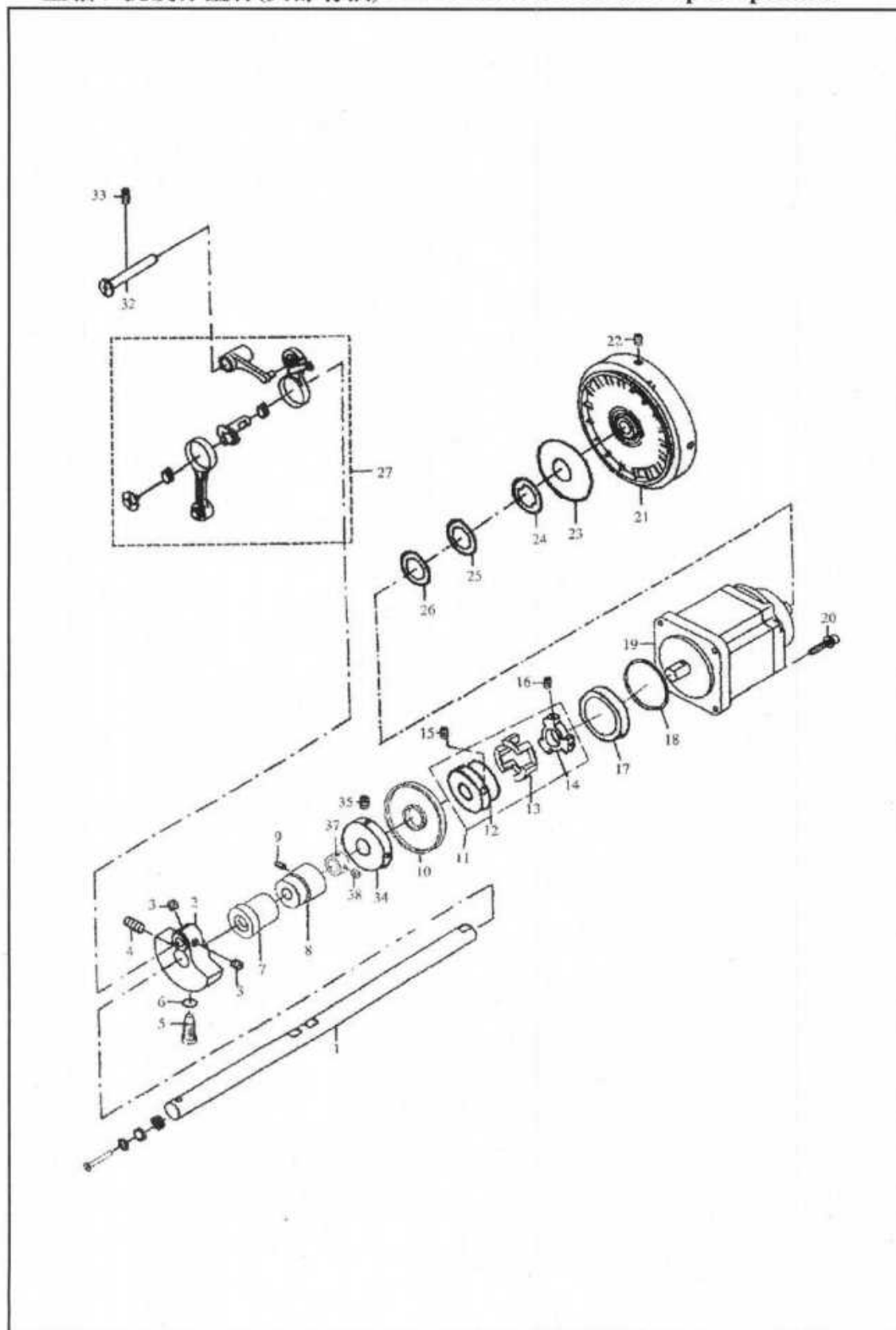
## MACHINE FRAME & MISCELLANEOUS COVER COMPONENTS



序号 Ref.No	图号 Part Number	名称	Description	数量 QTY
1	22-01-001	面板	Face plate	1
2	22-01-002	面板垫	Face plate agsket	1
3	22-01-003	油窗	Oil window	1
4	22-01-004	油窗O形圈	Thrust colar asm	1
5	22-01-005	挑线连杆销螺孔塞	Rubber plug	3
6	22-01-006	针杆曲柄螺孔塞	Rubber plug	1
7	22-01-007	三眼过线板	Three eye line board	1
8	22-01-008	后窗板螺钉	Screw 3/16x28 L=9	11
10	22-01-010	后窗板	Side plate	1
11	22-01-011	后窗板垫	Gasket	1
12	22-01-012	三眼过线板螺钉	Screw 11/64x40 L=6	1
13	22-01-013	安全指示牌	Safety label	1
15	22-01-015	机壳	Machine cover	1
17	22-01-017	缓线勾	Slow wire hook	1
18	22-01-018	缓线勾螺母	Tension nut 11/64X40	1
19	22-01-019	下轴盲孔塞	Rubber plug	1
20	22-01-020	导线过线套	Magnet cord rubber	1
28	22-01-028	挑线杆防护罩	Thread take-up lever cover	1
29	22-01-029	挑线杆护罩螺钉	Screw 3/16x28 L=6	1
30	22-01-030	右线钩	Arm thread guide Right	1
31	22-01-031	右线钩螺钉	Screw 11/64x40 L=6	1
44	22-01-044	针板	Throat plate	1

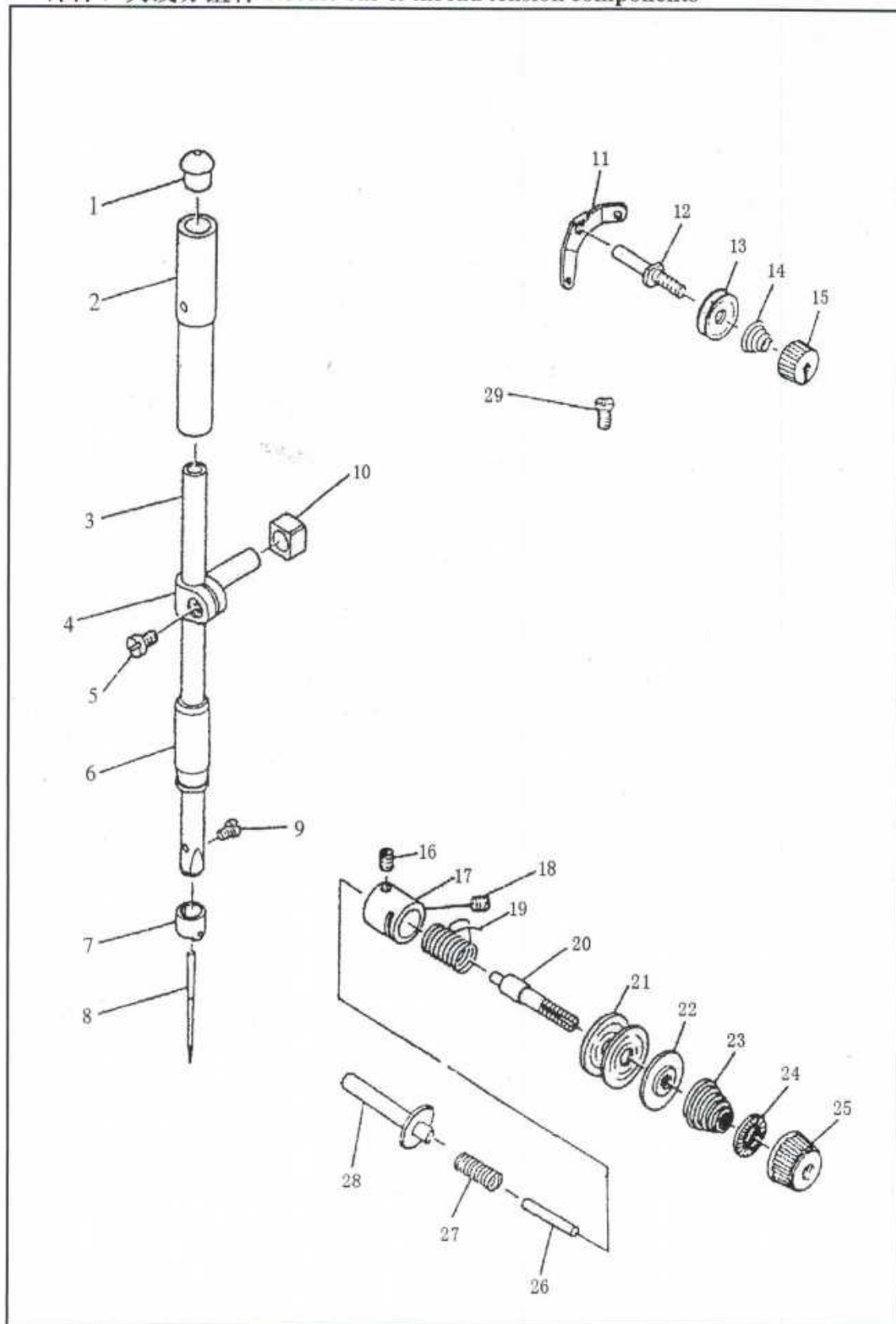
序号 Ref.No	图号 Part Number	名称	Description	数量 QTY
46	22-01-046	针板螺钉	Screw 11/64x40 L=6	1
47	22-01-047	左线钩	Arm thread guide Left	1
48	22-01-048	左线钩螺钉	Screw 11/64x40 L=6	1
49	22-01-049	面板调节螺孔塞	Ribber plug	2
50	22-01-050	面板螺钉	Screw 3/16x28 L=9	3
51	22-01-051	推板部件	Slide plate asm.	1
52	22-01-052	推板	Slide plate	1
53	22-01-053	推板簧	Bed slide spring	1
54	22-01-054	推板簧螺钉	Screw 3/32x56 L=2.2	2
55	22-01-055	底板支柱	Bed screw stud	4
56	22-01-056	夹边器	Ruler stopper	1
57	22-01-057	夹边器螺钉	Screw 11/64x40 L=6	1
58	22-01-058	型号牌铆钉	Pole	2
59	22-01-059	型号牌	Model plate	1
60	22-01-060	绕线器组件	Bobbin base	1
61	22-01-061	绕线器螺钉	Screw	3
62	22-01-062	割线刀	Knife	1
63	22-01-063	割线刀螺钉	Knife screw	2
64	22-01-064	绕线夹线器组件	Thread tension asm.	1
65	22-01-065	绕线夹线螺母	Tension nut	1
66	22-01-066	绕线夹线螺钉	Tension post	1
67	22-01-067	绕线夹线弹簧	Tension spring	1
68	22-01-068	绕线夹线板	Thread tension disk presser	2
69	22-01-069	绕线过线板	Thread tension guide	1
70	22-01-070	绕线夹线螺母(下)	Tension nut	1
71	22-01-071	保险开关安装板	SAFETY SWITCH PLATE	1
72	22-01-072	保险开关固定螺钉	SCREW	2
73	22-01-073	保险开关	SAFETY SWITCH CORS ASM.	1
74	22-01-074	保险插座螺钉	SCREW	2
75	22-01-075	保险开关弹簧	SAFETY SWITCH SPRING	1
76	22-01-076	保险开关支架轴	SAFETY SWITCH ARM.SHAFT	1
77	22-01-077	保险开关支架	SAFETY SWITCH BASH	1
78	22-01-078	挡屑板	SHELTER SCRAPS PLATE	1
79	22-01-079	挡屑板螺钉	SCREW	2
80	22-01-080	排屑斗	CLEARANCE-HOLE	1
81	22-01-081	排屑斗螺钉	SCREW	2
82	22-01-082	布屑导板	SCRAPS GUIDE PLATE	1
83	22-01-083	布屑导板螺钉	SCREW	2
84	22-01-084	电线夹	CORD HOLDER	1
85	22-01-085	电线夹螺钉	SCREW	1
86	22-01-086	电线压板	CORD HOLDER	1

## 2. 上轴、挑线分组件(头部有油) Main shaft & thread take-up components



序号 Ref.No	图号 Part Number	名称	Description	数量 QTY
1	22-02-001	上轴	MAIN SHAFT	1
2	22-02-002	针杆曲柄	COUNTER WEIGHT	1
3	22-02-003	挑线曲柄定位螺钉	SCREW	1
4	22-02-004	针杆曲柄紧固螺钉	SCREW 9/32-28 L=16	1
5	22-02-005	针杆曲柄定位螺钉	SCREW	1
6	22-02-006	针杆曲柄定位螺钉O型圈	RUBBER RING	1
7	22-02-007	上轴前轴套组件	MAIN SHAFT BEARING SUPPORT	1
8	22-02-008	上轴中轴套	BUSHING INTERNEDIATE	1
9	22-02-009	上轴中轴套螺钉	SCREW 15/64-28 L=9	1
10	22-02-010	上轴油封	OIL SEAL	1
11	22-02-011	联轴器组件	COUPLING ASM.	1
12	22-02-012	上轴联轴器	COUPLING ASM.	1
13	22-02-013	联轴器橡胶圈	WASHER	1
14	22-02-014	电机联轴器	COUPLING ASM.	1
15	22-02-015	上轴联轴器紧固螺钉	SCREW	1
16	22-02-016	电机联轴器紧固螺钉	SCREW	1
17	22-02-017	轴承	BEARING	1
18	22-02-018	电机密封圈	FOLDER	1
19	22-02-019	电机	MOTOR	1
20	22-02-020	上轴电机螺钉组件	BOLT	4
21	22-02-021	上轮	HEAD WHEEL	1
22	22-02-022	上轮螺钉	SCREW	2
23	22-02-023	下定位片	DOWN GO TO PARCEL	1
24	22-02-024	隔离片	SEPARATE PARCEL	1
25	22-02-025	上定位片	HEAD GO TO PARCEL	1
26	22-02-026	垫片	WASHER	1
27	22-02-027	挑线杆组件	THREED TAKE-UP ASM.	1
32	22-02-032	挑线连杆铰链轴	THREED TAKE-UP CRANK SHAFT	1
33	22-02-033	挑线连杆铰链轴螺钉	SCREW	1
34	22-02-034	绕线主动轮	WHEET	1
35	22-02-035	绕线主动轮紧定螺钉	SCREW	2
37	22-02-037	上轴挡圈	THRUST COLLAR ASM.	1
38	22-02-038	上轴挡圈螺钉	SCREW 1/4-40 L=6	2

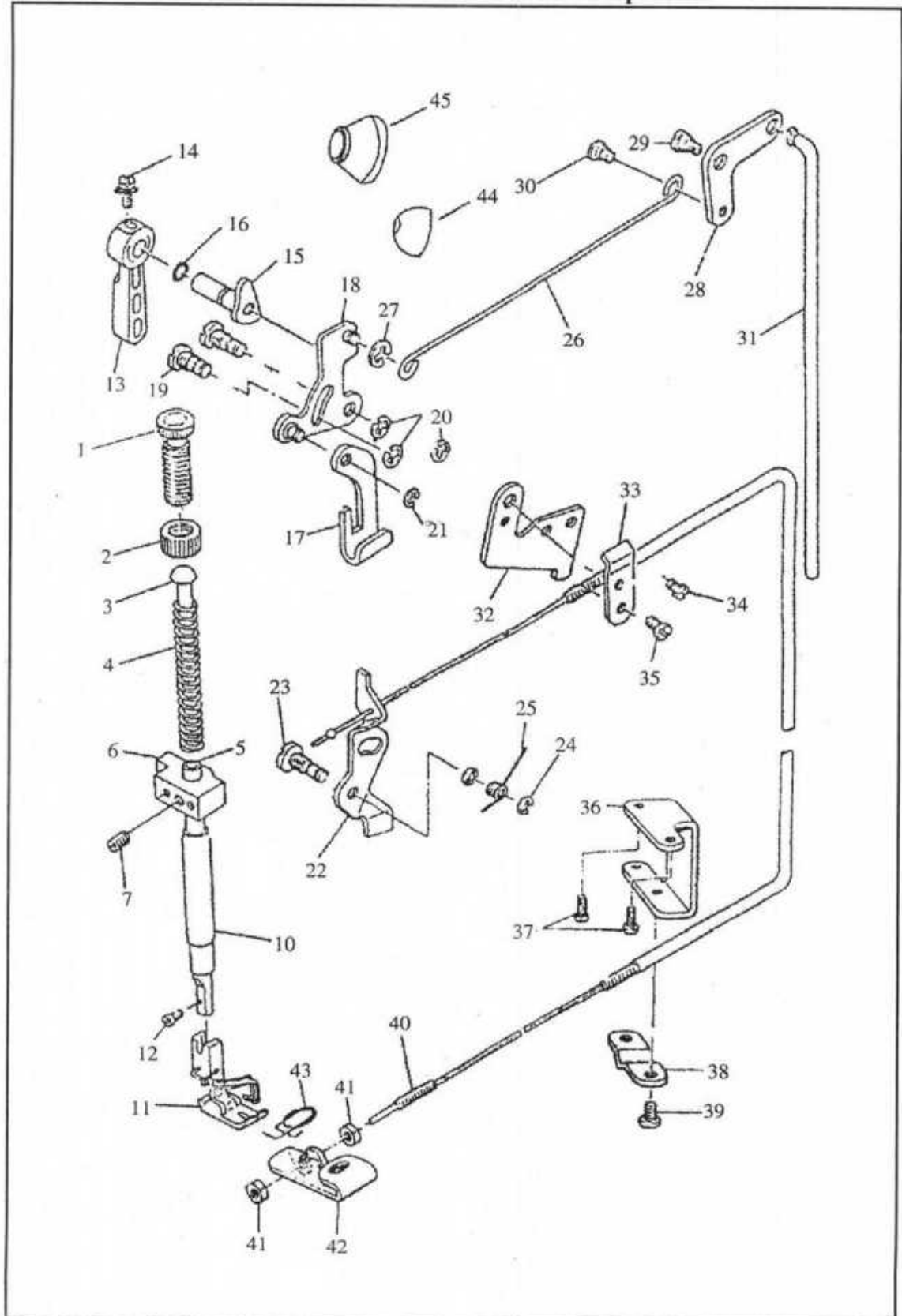
### 3. 针杆、夹线分组件 Needle bar & thread tension components





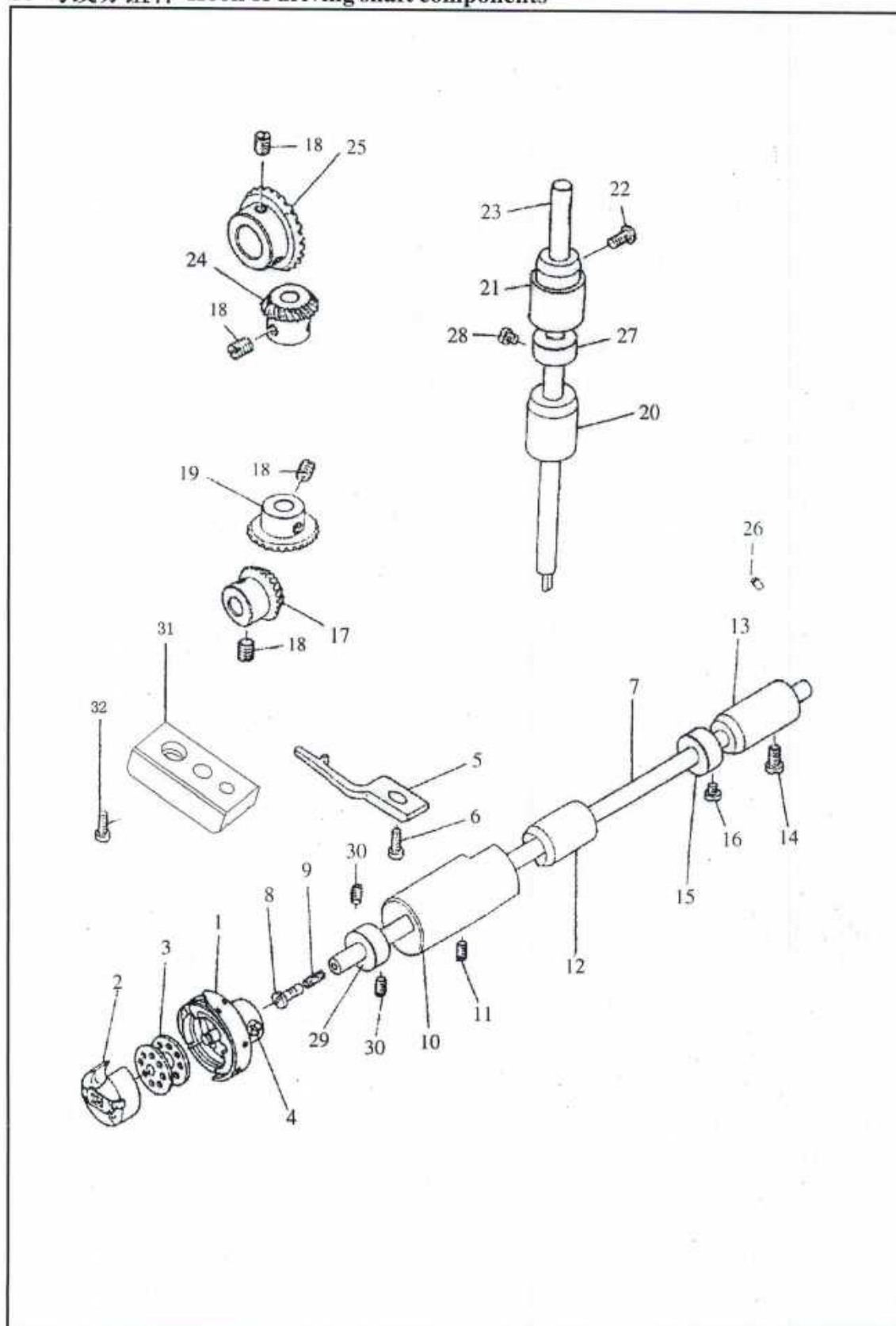
序号 Ref.No	图号 Part Number	名称	Description	数量 QTY
1	22-03-001	针杆上轴套橡皮塞	CAP	1
2	22-03-002	针杆上轴套	NEEDLE BAR BUSHING,UPPER	1
3	22-03-003	针杆	NEEDLE BAR	1
4	22-03-004	针杆连接柱	NEEDLE BAR HOLDER	1
5	22-03-005	针杆连接柱螺钉	SCREW 9/64-40 L=6	1
6	22-03-006	针杆下轴套	NEEDLE BAR BUSHING,LOWER	1
7	22-03-007	针杆线钩	NEEDLE BAR THREAD GUIDE	1
8	22-03-008	机针	NEEDLE(DBX1 #14)	1
9	22-03-009	支针螺钉	SCREW 1/8-44 L=4.5	1
10	22-03-010	针杆连接柱滑块	SLIDE BLOCK	1
11	22-03-011	上过线板	THREAD TENSION GUIDE	1
12	22-03-012	上夹线螺钉	FIRST TENSION POST	1
13	22-03-013	上过线板	BOBBIN WINDER TENSION DISC	1
14	22-03-014	上夹线簧	THREAD TENSION SPRING	1
15	22-03-015	上夹线螺母组件	THREAD TENSION NUT	1
16	22-03-016	夹线螺钉紧固螺钉	SET SCREW 9/64-40 L=5.5	1
17	22-03-017	挑线簧调节	TENSION POST SOCKET	1
18	22-03-018	夹线器螺钉	SCREW	1
19	22-03-019	挑线簧	TAKE-UP SPRING	1
20	22-03-020	夹线螺钉	SCREW	1
21	22-03-021	夹线板	TENSION DISC	1
22	22-03-022	松线板	TENSION DISC HOLDER	1
23	22-03-023	夹线簧	TENSION SPRING	1
24	22-03-024	夹线制动板	TENSION DISC STOPPER	1
25	22-03-025	夹线螺母	TENSION NUT	1
26	22-03-026	松线钉	THREAD RELEASE PIN	1
27	22-03-027	松线辅钉弹簧	TENSION RELEASE PIN SPRING	1
28	22-03-028	松线辅钉	TENSION RELEASE SUPPOREING PIN	1
29	22-03-029	上夹线器螺钉	SCREW 3/16-28 L=6	1

#### 4. 压料、松线分组件 Presser bar & tension release components



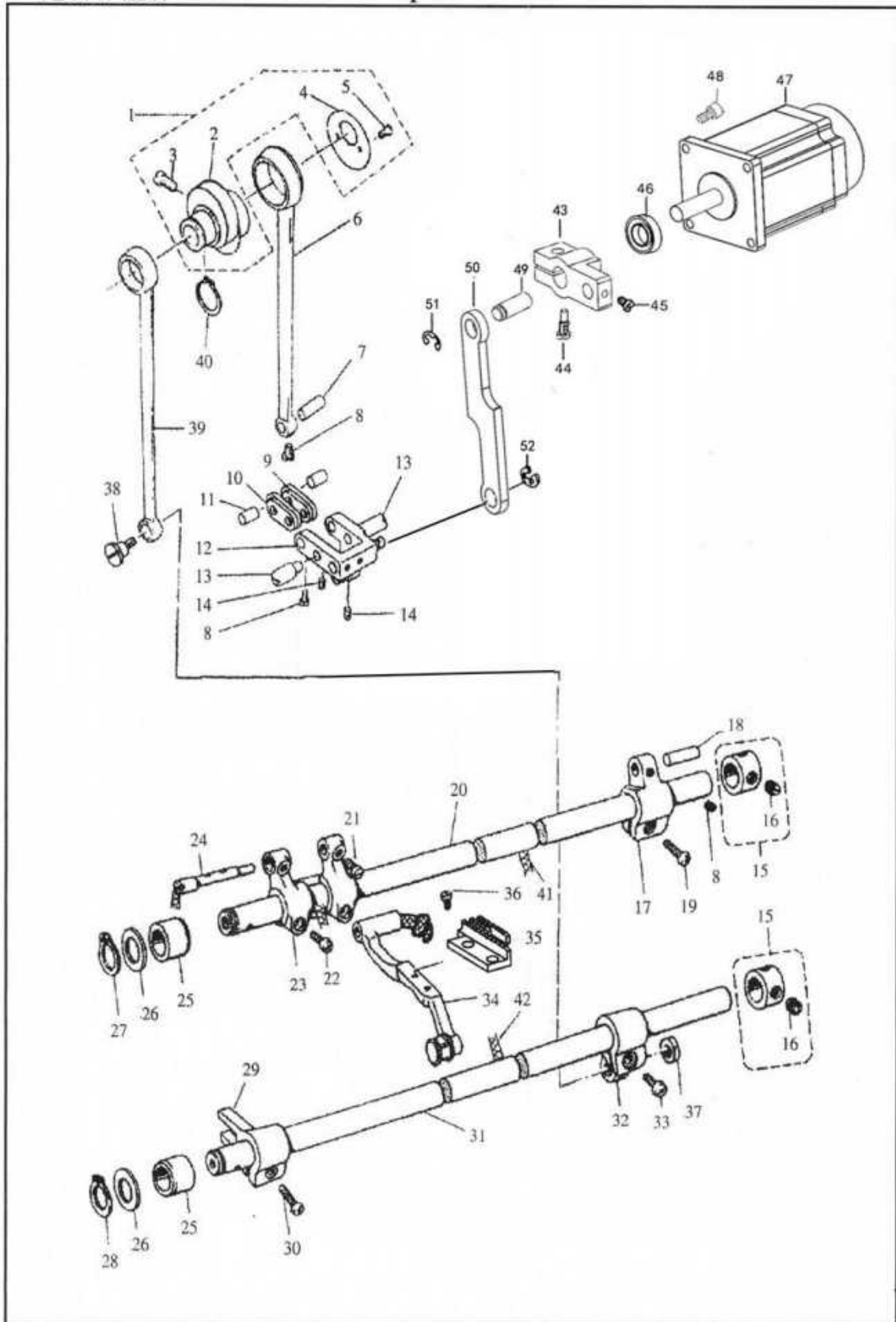
序号 Ref.No	图号 Part Number	名称	Description	数量 QTY
1	22-04-001	调压螺钉	PRESSER SPRING REGULATOR	1
2	22-04-002	调压螺母	NUT 1/2-28	1
3	22-04-003	调压导杆	PRESSER GUIDE BAR	1
4	22-04-004	调压簧	PRESSER SPRING REGULATOR	1
5	22-04-005	压杆	PRESSER GUIDE BAR	1
6	22-04-006	压杆导架	NEEDLE BAR GUIDE BRACKET	1
7	22-04-007	压杆导架螺钉	SCREW 1/4-40 L=8	1
10	22-04-010	压杆下套	PRESSER BAR BUSHING LOWER	1
11	22-04-011	活压脚部件	PRESSER FOOT ASM	1
12	22-04-012	活压脚螺钉	SCREW 9/64-40 L=9.5	1
13	22-04-013	压脚扳手	HAND LOFTER	1
14	22-04-014	压脚扳手螺钉	SCREW 9/64-40 L=8.5	1
15	22-04-015	压脚扳手凸轮部件	HAND LOFTER CAM ASM.	1
16	22-04-016	压脚扳手O型圈	RUBBER RING	1
17	22-04-017	压脚升降板	LIFTING LEVER	1
18	22-04-018	抬压脚前杠杆部件	HAND LIFTER LINK ASM.	1
19	22-04-019	前杠杆螺纹销	LINK SHAFT	1
20	22-04-020	螺纹销开口挡圈	SNAP RING	6
21	22-04-021	升降板连接特制开口挡圈	LIFTING LEVER RING	1
22	22-04-022	松线顶板	TENSION RELEASE PLATE	1
23	22-04-023	松线顶板螺纹销	TENSION RELEASE SHAFT	1
24	22-04-024	螺纹销开口挡圈	SNAP RING	1
25	22-04-025	松线顶板复位簧	TENSION RELEASE RETURN SPRING	1
26	22-04-026	抬压脚拉杆	LIFTING LEVER CONNECTING ROD	1
27	22-04-027	拉杆挡圈	SNAP RING	1
28	22-04-028	抬压脚后杠杆	LIFTING LEVER LINK	1
29	22-04-029	后杠杆轴位螺钉	HINGE SCREW	1
30	22-04-030	抬压脚拉杆螺钉	HINGE SCREW	1
31	22-04-031	抬压脚顶杆	CONNECTING ROD VERRICAL	1
32	22-04-032	软管支承板	WIRE HOLDER BRACKET(UPPER)	1
33	22-04-033	软管压板	WIRE HOLDER	1
34	22-04-034	软管支承板螺钉	SCREW 3/16-28 L=6	1
35	22-04-035	软管压板螺钉	SCREW 11/64-40 L=7	1
36	22-04-036	松线钢绳座	LOOSING LINE PLATE	1
37	22-04-037	松线钢绳座螺钉	SCREW	2
38	22-04-038	钢绳固定板	FIXING SHUTTER	1
39	22-04-039	钢绳固定板螺钉	SCREW	2
40	22-04-040	松线钢丝组件	LOOSING LINE ASM.	1
41	22-04-041	松线钢丝调节螺母	NUT	1
42	22-04-042	松线座	LOOSING PLATE	1
43	22-04-043	松线复位弹簧	SPRING	1
44	22-04-044	松线钢丝挡块	BEFFLE	1
45	22-04-045	压紧杆防油罩	PRESSER BAR OIL SEAL	1

### 5. 勾线分组件 Hook of driving shaft components



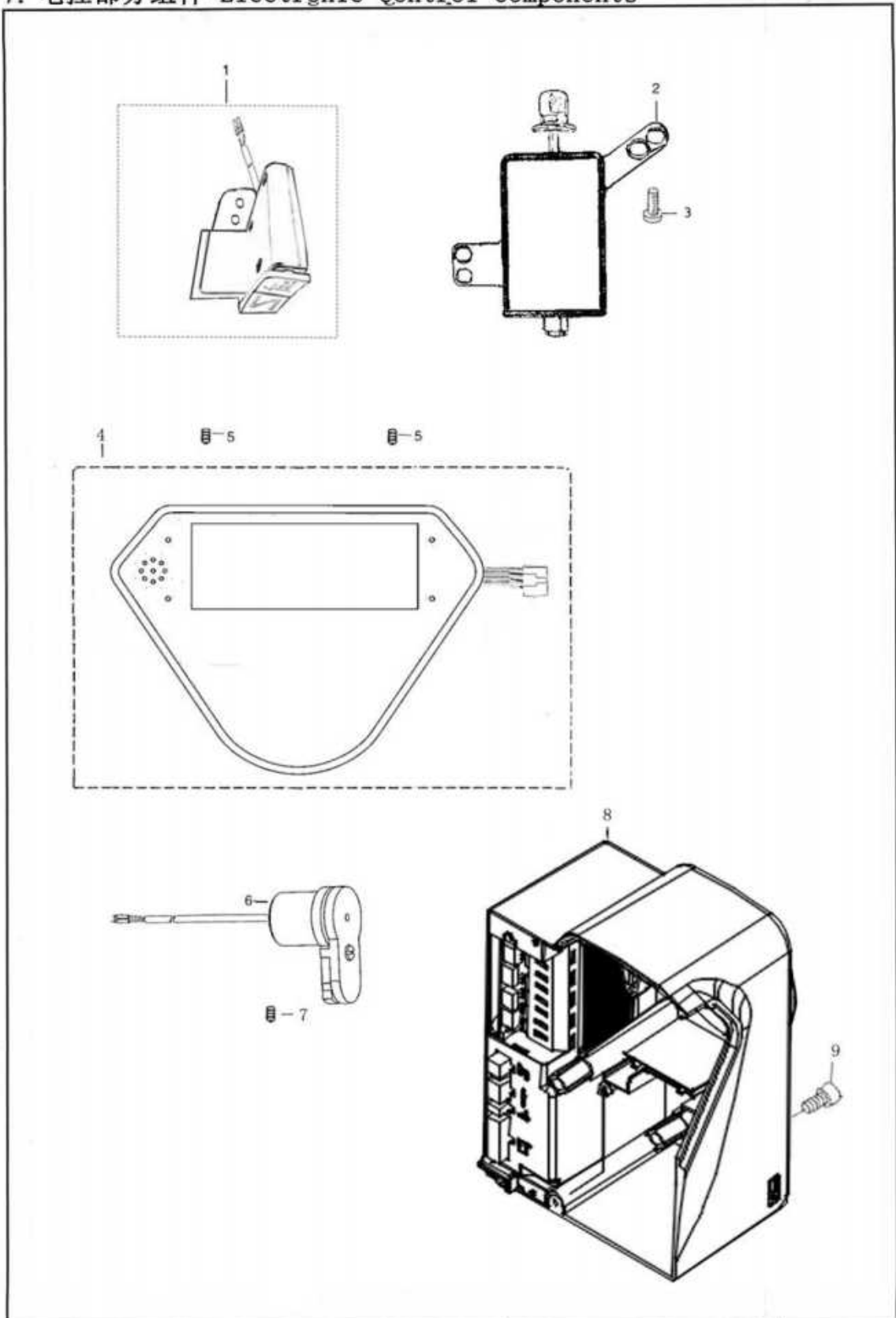
序号 Ref.No	图号 Part Number	名称	Description	数量 QTY
1	22-05-001	旋梭	HOOK ASM.	1
2	22-05-002	梭子	BOBBIN CASE ASM.	1
3	22-05-003	梭心	BOBBIN	1
4	22-05-004	旋梭紧固螺钉	SCREW	2
5	22-05-005	旋梭定位钩	POSTIONING FINGER	1
6	22-05-006	旋梭定位钩螺钉	SCREW 11/64-40 L=9.5	1
7	22-05-007	下轴	KOOK DRIVING SHAFT	1
8	22-05-008	下轴限油螺钉	OIL SEAL SCREW ASM.	
9	22-05-009	下轴限油螺钉部件	OIL WICK	1
10	22-05-010	下轴前轴套	BUSHING ASM .FRONT	1
11	22-05-011	下轴前轴套螺钉	SCREW 15/64-28 L=7.5	1
12	22-05-012	下轴中轴套	BUSHING MIDDLE	1
13	22-05-013	下轴后轴套	BUSHING REAR	1
14	22-05-014	下轴后轴套螺钉	SCREW 3/16-28 L=15	2
15	22-05-015	下轴挡圈	THRUST COLLAR ASM.	1
16	22-05-016	下轴挡圈螺钉	SCREW 1/4-40 L=8	2
17	22-05-017	下轴伞齿轮	PINION ASM.	1
18	22-05-018	伞齿轮螺钉	SCREW 1/4-40 L=8	8
19	22-05-019	竖轴下伞齿轮	GEAR ASM LARGE	1
20	22-05-020	竖轴下轴套	UPRIGHT SHAFT BUSHING,LOWER	1
21	22-05-021	竖轴上轴套	BUSHING ,UPPER	1
22	22-05-022	竖轴上轴套螺钉	SCREW 11/64-40 L=9	1
23	22-05-023	竖轴	UPRINGT SHAFT	1
24	22-05-024	竖轴上伞齿轮	PINION ASM.	1
25	22-05-025	上轴伞齿轮	GEAR ASM.	1
26	22-05-026	橡胶塞	BLOCK	1
27	22-05-027	竖轴上轴套挡圈	THRUST COLLAR ASM.	1
28	22-05-028	竖轴上轴套挡圈螺钉	SCREW 1/4-40 L=8	2
29	22-05-029	下轴防油圈	OIL SEAL RING	1
30	22-05-030	下轴防油圈螺钉	SCREW	2
31	22-05-031	定刀安装架	SHELF	1
32	22-05-032	定刀安装架螺钉	SCREW	1

## 6. 送料分组件 Feed mechanism components



序号 Ref.No	图号 Part Number	名称	Description	数量 QTY
1	22-06-001	送料偏心轮部件	FEED DRIVE ECCENTRIC CAM ASM.	1
2	22-06-002	送料偏心轮	FEED DRIVE ECCENTRIC CAM	1
3	22-06-003	送料偏心轮螺钉	SCREW 1/4-40 L=11	2
4	22-06-004	送料偏心轮盖板	THRUST COLLAR	1
5	22-06-005	偏心轮盖板螺钉	SCREW 9/64-40 L=5	2
6	22-06-006	送料连杆	ROCKER SHAFT CONNECTING ROD	1
7	22-06-007	送料连杆销	WALKING FOOT PIN	1
8	22-06-008	连接销螺钉	SCREW 9/64-40 L=6	4
9	22-06-009	送料长摆动板	WALKING FOOT LINK	2
10	22-06-010	送料短摆动板	CONNECTING LINK	2
11	22-06-011	长摆动板连接销	WALKING FOOT PIN	2
12	22-06-012	送料摆动板座部件	WALKING FOOT ADJUST LINK	1
13	22-06-013	送料摆动板座左右销	ADJUSTING LINK FULCRUM SHAFT	2
14	22-06-014	左右销螺钉	SCREW 15/64-28 L=7	2
15	22-06-015	挡圈组件	RETAINING RING ASM.	2
16	22-06-016	挡圈螺钉	SCREW	4
17	22-06-017	送布曲柄	FEED ROCKER SHAFT CRANK ASM.	1
18	22-06-018	送料曲柄销	WALKING FOOD PIN	1
19	22-06-019	送料曲柄螺钉	SCREW 9/64-40 L=14	1
20	22-06-020	送布轴	FEED ROCKER SHAFT CRANK ASM.	1
21	22-06-021	牙架曲柄轴螺钉	SCREW	1
22	22-06-022	牙架曲柄固定螺钉	SCREW	1
23	22-06-023	牙架曲柄	FEED CRACKET	1
24	22-06-024	牙架销	FEED BAR SHAFT	1
25	22-06-025	拾牙送布轴轴套	FEED RICKER SHAFT BUSHING	2
26	22-06-026	拾牙送布轴垫圈	WASHER	2
27	22-06-027	送料轴轴用挡圈	RETAINING RING	1
28	22-06-028	拾牙轴轴用挡圈	RETAINING RING	1
29	22-06-029	拾牙叉形曲柄	DRIVING SHAFT CRANK ASM.FRONT	1
30	22-06-030	拾牙叉形曲柄螺钉	SCREW 11/6-40 L=10.5	1
31	22-06-031	拾牙轴	FEED DRIVING SHAFT	1
32	22-06-032	拾牙后曲柄	REAR CRACK ASM.	1
33	22-06-033	拾牙后曲柄螺钉	SCREW 3/16-28 L=12	1
34	22-06-034	牙架组件	FEED ROCKET BASE ASM.	1
35	22-06-035	送料牙	FEED DOG	1
36	22-06-036	送料牙螺钉	SCREW 1/8-44 L=6	2
37	22-06-037	拾牙连杆轴位螺母	NUT	1
38	22-06-038	拾牙连杆轴位螺钉	SCREW	1
39	22-06-039	拾牙连杆	CONNECTING ROD	1
40	22-06-040	拾牙连杆轴用挡圈	RETAINING RING	1
41	22-06-041	送料轴油线	OIL WICK	1
42	22-06-042	拾牙轴油线	OIL WICK	1
43	22-06-043	倒送料曲柄组件	FEED REVERSE ARM ASM.	1
44	22-06-044	螺钉	SCREW	1
45	22-06-045	螺钉	SCREW	1
46	22-06-046	油封组件	OIL SEAL	1
47	22-06-047	步进电机	STEPPER MOTOR	1
48	22-06-048	螺钉	SCREW M5	4
49	22-06-049	倒送料连杆销	FEED REGULATOR PIN	1
50	22-06-050	倒送料连杆	FEED ADJUST ROD	1
51	22-06-051	倒送料连杆销挡圈	E-RING 5	1
52	22-06-052	倒送料连杆挡圈	E-RING 5	1

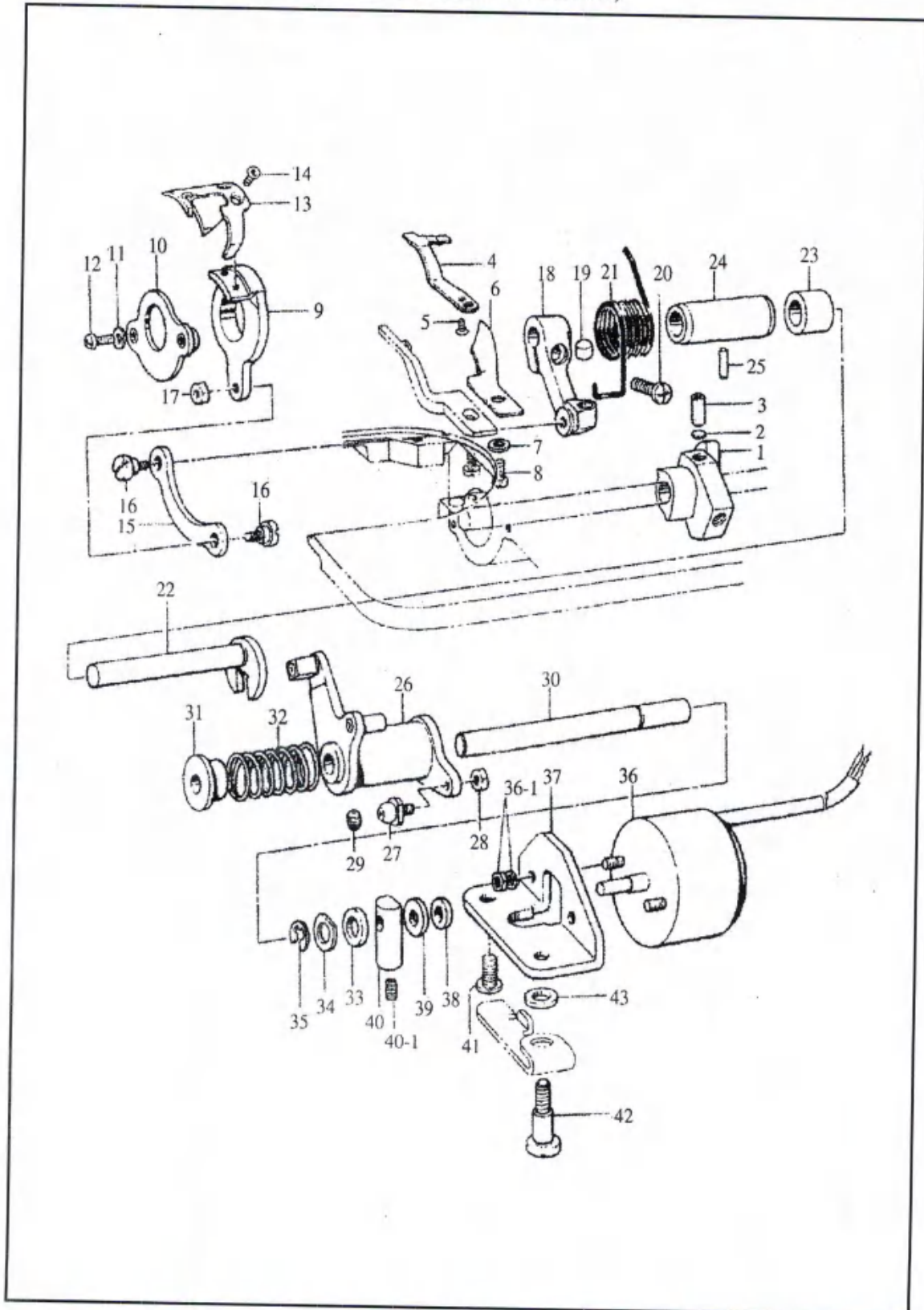
## 7. 电控部分组件 Electronic control components





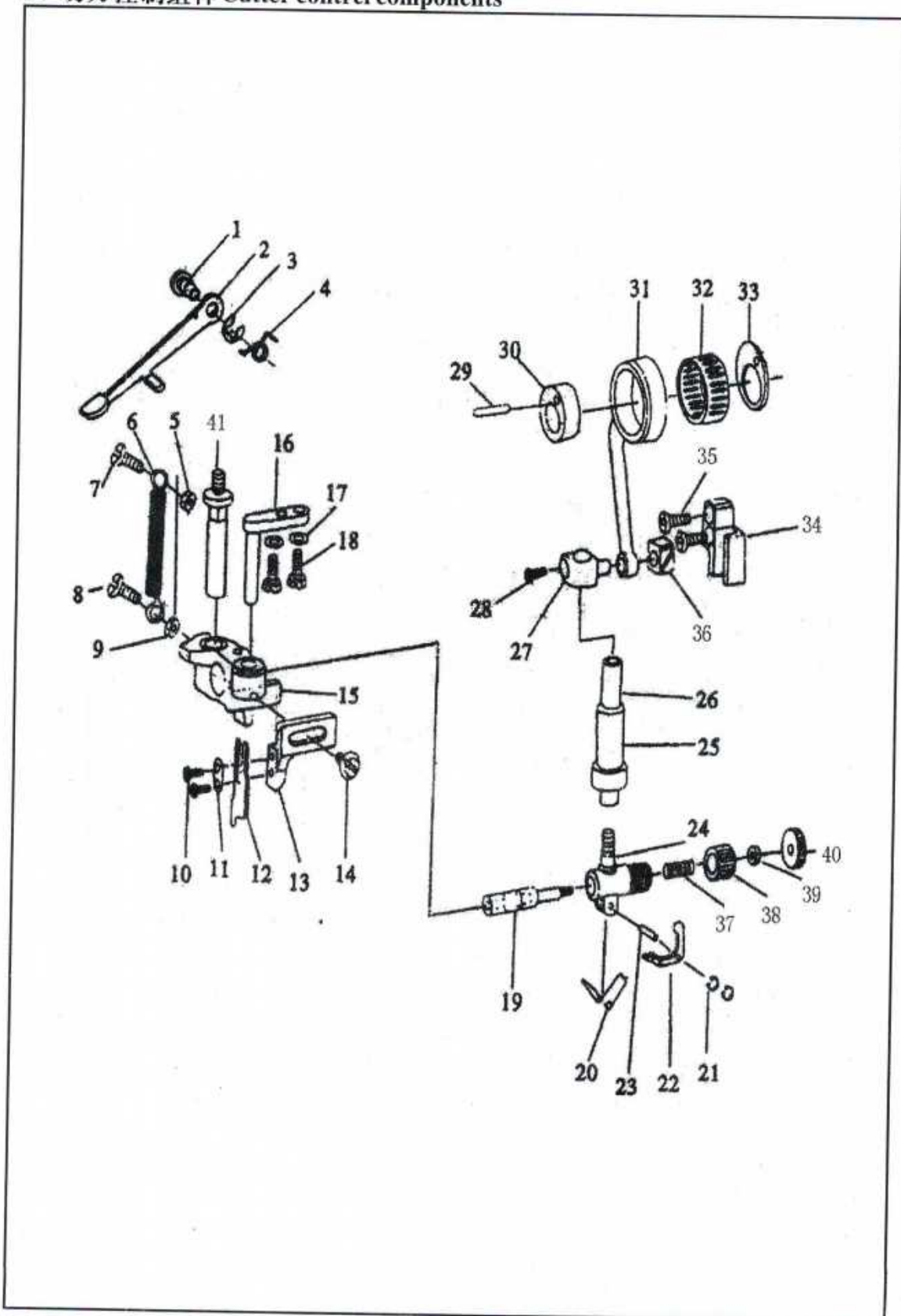
序号 Ref.No	图号 Part Number	名 称	Description	数量 QTY
1	22-07-001	自动倒缝开关组件	REVERSE FEED SWITCH ASM.	1
2	22-07-002	自动抬压组件	AUTOMATIC PRESSER FOOT ASSEMBLY	1
3	22-07-003	螺钉	SCREW	4
4	22-07-004	选针盒组件	NEEDLE SELECTION BOX ASM.	1
5	22-07-005	选针盒固定螺钉	SCREW SM9/64X40 L=8	2
6	22-07-006	电子夹线器组件	ELECTRONIC CONDUCTOR HOLDER ASM.	1
7	22-07-007	电子夹线器固定螺钉	SCREW SM3/16X28 L=6	1
8	22-07-008	控制箱组件	ELECTRIC CONTROL BOX ASM.	1
9	22-07-009	控制箱固定螺钉	SCREW M5	4

8.1. 剪线分组件 Thread trimmer components  
(旋刀组件 ROUND KNIFE COMPONENTS)



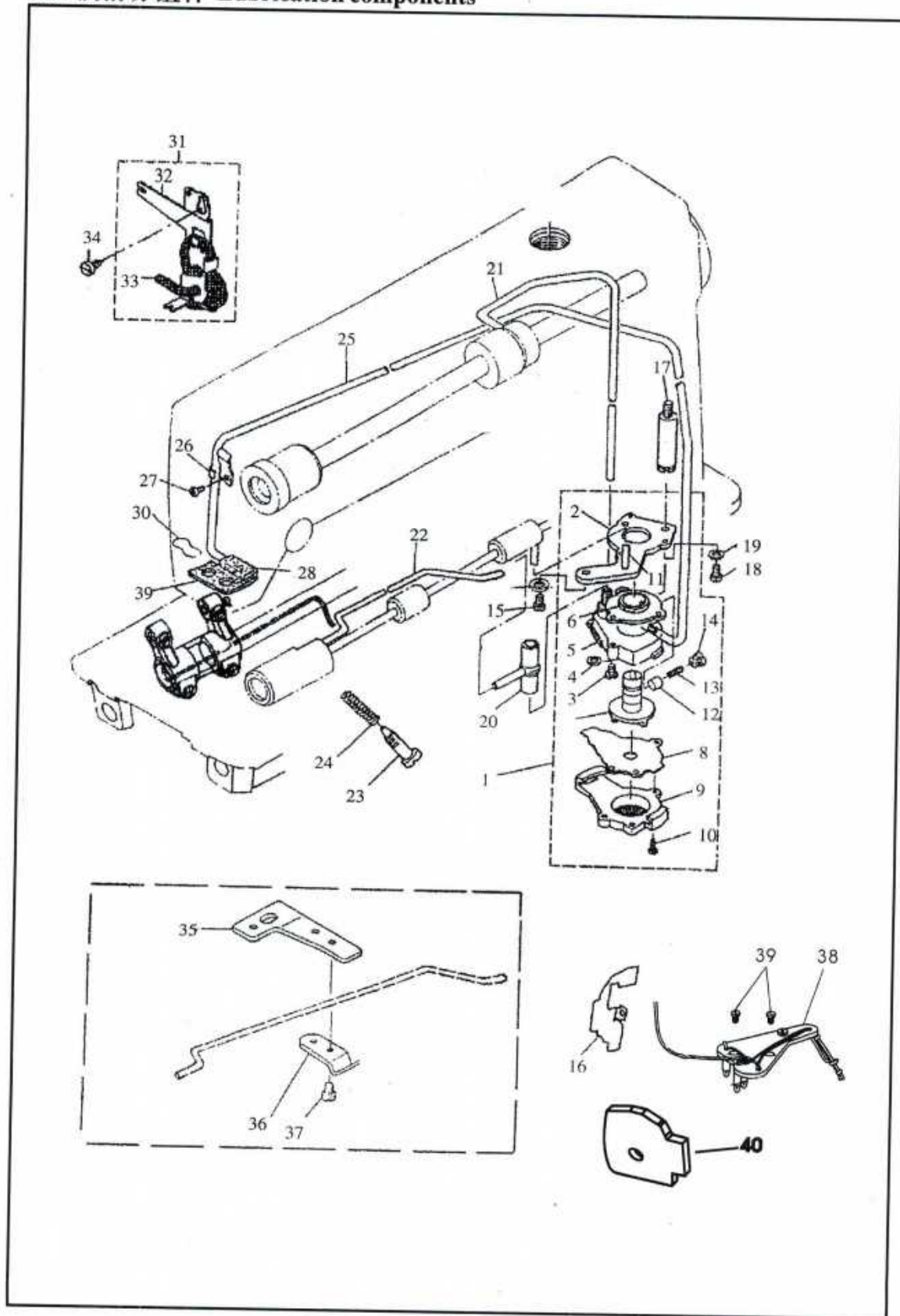
序号 Ref.No	图号 Part Number	名称	Description	数量 QTY
1	22-08-001	剪线凸轮	THREAS TRIMMER CAM	1
2	22-08-002	剪线凸轮垫	CAM COLLAR	2
3	22-08-003	剪线凸轮螺钉	SCREW	2
4	22-08-004	定刀	CONNTER KNIFE	1
5	22-08-005	定刀固定螺钉	SCREW	1
6	22-08-006	分线器	DISPART THREAS SHUTTLE	1
7	22-08-007	分线器固定螺钉垫圈	WASHER	3
8	22-08-008	分线器固定螺钉	SCREW	1
9	22-08-009	动刀架	ROUND KNIFE BRACKET	1
10	22-08-010	刀架压板组件	KNIFE HOLDER ASM.	1
11	22-08-011	刀架压板螺钉垫圈	WASHER	2
12	22-08-012	刀架压板螺钉	SCREW	2
13	22-08-013	动刀	ROUND KNIFE BRACKET	1
14	22-08-014	动刀固定螺钉	SCREW	2
15	22-08-015	刀轴连杆	KNIFE SHAFT CRACK ROD	1
16	22-08-016	刀轴连杆螺钉	SCREW	2
17	22-08-017	刀轴连杆螺母	NUT	1
18	22-08-018	切线驱动曲柄	TRIMMING CRANK	1
19	22-08-019	切线驱动曲柄止动块	BLOCK	1
20	22-08-020	切线驱动曲柄螺钉	SCREW	1
21	22-08-021	复位弹簧	REPLACE SPRING	1
22	22-08-022	切刀驱动曲柄轴	TRIMMING CRANK SHAFT	1
23	22-08-023	驱动曲柄轴短套	SHORT BUSHING	1
24	22-08-024	切线轴套	BUSHING	1
25	22-08-025	切线轴套紧定螺钉	SCREW	1
26	22-08-026	切线凸轮曲柄组件	TRIMMING CAM CRANK ASM.	1
27	22-08-027	滚柱轴分组件	ROLLER BEARING SHAFT ASM.	1
28	22-08-028	切线凸轮曲柄滚柱螺母	NUT	1
29	22-08-029	切线凸轮曲柄紧定螺钉	SCREW	1
30	22-08-030	切刀驱动轴	TRIMMING SHAFT	1
31	22-08-031	扭簧端盖	SPRING COVER	1
32	22-08-032	剪线电磁铁复位弹簧	SPRING	1
33	22-08-033	切线磁铁垫圈	WASHER	1
34	22-08-034	切线驱动轴垫圈	CLIP	1
35	22-08-035	切线驱动轴挡圈	WASHER	1
36	22-08-036	剪线电磁铁组件	THREAD TRIMMER SOLENOID ASM.	1
36-1	22-08-037	剪线电磁铁螺母	NUT	2
37	22-08-038	剪线电磁铁安装座	SOLENOID BASE	1
38	22-08-039	剪线电磁铁缓冲垫	WASHER	1
39	22-08-040	剪线电磁铁垫圈	WASHER	1
40	22-08-041	剪线电磁铁连接体	SOLENOIDCONNECTING SHAFT	1
40-1	22-08-042	剪线电磁铁连接体固定螺钉	SCREW	1
41	22-08-043	剪线电磁铁安装座固定螺钉	SCREW	1
42	22-08-044	松线座螺钉	SCREW	1
43	22-08-045	松线座螺钉垫圈	WASHER	1

### 9. 切刀控制组件 Cutter control components



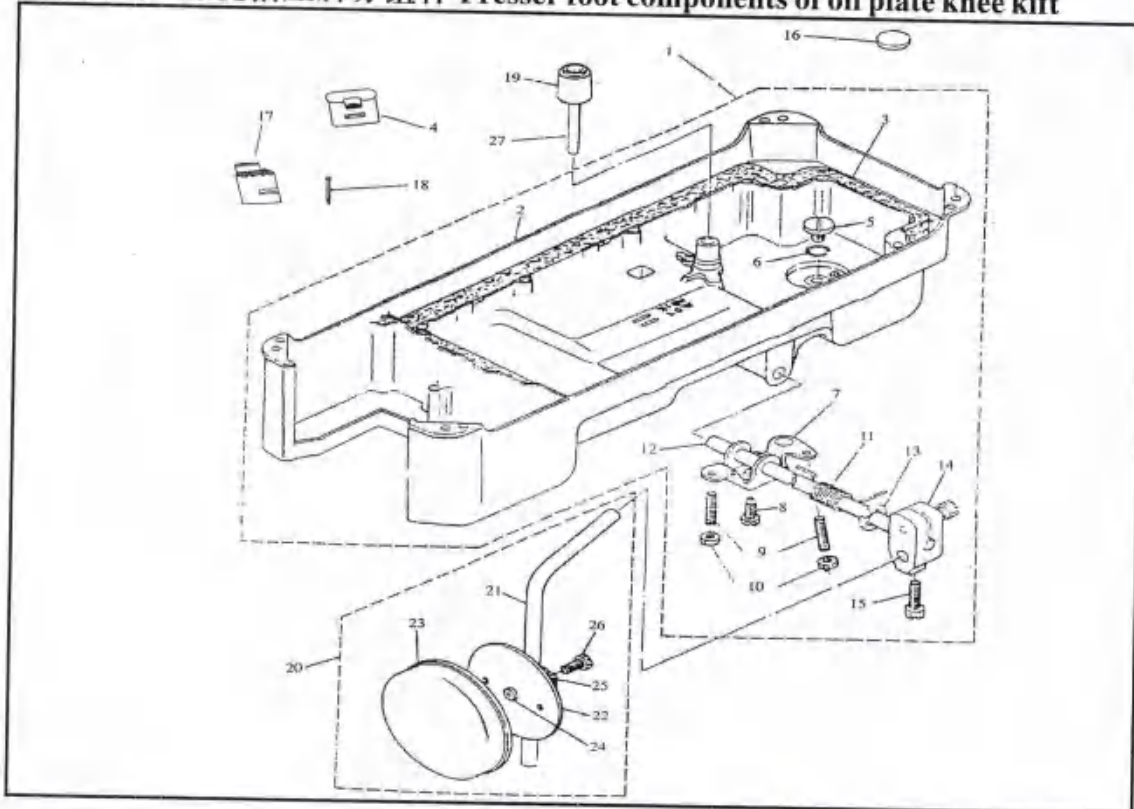
序号 Ref.No	图号 Part Number	名称	Description	数量 QTY
1	22-09-001	控刀轴位螺钉	KNIFE-CONTROLLED AXIAL SCREW	1
2	22-09-002	控刀扳手	KNIFE-CONTROLLED SPANNER	1
3	22-09-003	升降板连接特制开口挡圈	SPLIT BAFFLE RING	1
4	22-09-004	控刀扳手扭簧	KNIFE-CONTROLLED SPANNER SPRING	1
5	22-09-005	导向架拉簧螺帽(上)	ORIENTED GUIDE SPRING NUT(ABOVE)	1
6	22-09-006	导向架拉簧	ORIENTED GUIDE SPRING	1
7	22-09-007	导向架拉簧螺钉(上)	ORIENTED GUIDE SPRING SCREW(ABOVE)	1
8	22-09-008	导向架拉簧螺钉	ORIENTED GUIDE SPRING SCREW	1
9	22-09-009	导向架拉簧螺母	ORIENTED GUIDE SPRING NUT	1
10	22-09-010	刀片固定螺钉	BLADE SET SCREW	2
11	22-09-011	切刀垫片	CUTTER WASHER	1
12	22-09-012	切刀	CUTTER	1
13	22-09-013	刀架	KNIFE REST	1
14	22-09-014	刀架螺钉	KNIFE REST SCREW	1
15	22-09-015	刀架导向架	KNIFE REST ORIENTED GUIDE RACK	1
16	22-09-016	导向架导轨	GUIDE FRAME LEAD RAIL	1
17	22-09-017	固定螺钉垫圈	SET SCREW WASHER	2
18	22-09-018	导向架导轨固定螺钉	SET SCREW	2
19	22-09-019	导向架控制销	GUIDE FRAME CONTROL PIN	1
20	22-09-020	杠杆簧	LEVER SPRING	1
21	22-09-021	E型挡圈	E TYPE RETAINER RING	2
22	22-09-022	切刀控制杠杆	CUTTER CONTROL LEVER	1
23	22-09-023	杠杆连接销	LEVER CONNECTED PIN	1
24	22-09-024	控制销导套	CONTROL PIN GUIDER	1
25	22-09-025	刀杆轴套	CUTTER BAR AXIAL BUSHING	1
26	22-09-026	刀杆	CUTTER BAR	1
27	22-09-027	刀杆接头	JOINT OF CUTTER BAR	1
28	22-09-028	刀杆接头螺钉	SCREW	1
29	22-09-029	连接销	CONNECTED PIN	1
30	22-09-030	刀杆凸轮	CUTTER BAR CAM	1
31	22-09-031	刀杆连杆	CUTTER BAR CONNECTING ROD	1
32	22-09-032	滚针轴承	BEARING	1
33	22-09-033	止推垫片	WASHER	1
34	22-09-034	刀杆接头滑块导轨	LEAD TRAIL	1
35	22-09-035	导轨固定螺钉	SCREW	2
36	22-09-036	刀杆接头滑块	CUTTER BAR CONNECTING ROD SLIDER	1
37	22-09-037	刀控弹簧	KNIFE-CONTROL SPRING	1
38	22-09-038	导套盖	GUIDE BUSHING COVER	1
39	22-09-039	导柱螺帽	NUT	1
40	22-09-040	旋钮	KNOB	1
41	22-09-041	导向架导柱	ORIENTED FRAME GUIDE PIN	1

# 10. 润滑分组件 Lubrication components



序号 Ref.No	图号 Part Number	名称	Description	数量 QTY
1	22-10-001	油泵部件	LUBRICATING OIL PUMP ASM.	1
2	22-10-002	油泵安装板	OIL PUMP INSTALLING BASE	1
3	22-10-003	油泵安装螺钉	SCREW 15/64-28 L=9	3
4	22-10-004	油泵安装止退垫圈	WASHER	3
5	22-10-005	油泵体	OIL PUMP	1
6	22-10-006	油泵体衬套	OIL PUMP BUSHING	1
7	22-10-007	油泵叶轮	OIL PUMP IMPELLER	1
8	22-10-008	油泵叶轮托板	OIL PUMP IMPELLER COVER	1
9	22-10-009	油泵盖部件	LUBRICATING OIL PUMP COVER	1
10	22-10-010	油泵盖螺钉	SCREW	3
11	22-10-011	下轴供油管	HOOK DRIVING SHAFT OIL TUBE	1
12	22-10-012	回油柱塞	PULUNGER	1
13	22-10-013	柱塞簧	PLUNGER SPRING	1
14	22-10-014	柱塞螺钉	SCREW	1
15	22-10-015	油泵螺钉	SCREW	1
16	22-10-016	隔油板	OIL STOPPER ASM.	1
17	22-10-017	油泵连接螺柱	OIL PUMP SUPPORT	1
18	22-10-018	螺柱连接螺钉	SCREW 11/64-40 L=9.5	1
19	22-10-019	油泵连接螺柱挡圈	WASHER	1
20	22-10-020	供油管接头	RUBBER JOINT	1
21	22-10-021	上轴供油管	MAIN SHAFT OIL TUBE	1
22	22-10-022	旋梭供油管	OIL TUBE	1
23	22-10-023	油量调节螺钉	OIL ADJUSTING SCREW	1
24	22-10-024	油量调节簧	SPRING	1
25	22-10-025	回油管	OIL RETURN GUARD	1
26	22-10-026	回油管夹	OIL RETURN TUBE HOLDER	1
27	22-10-027	回油管夹螺钉	SCREW 3/16-28 L=6	1
28	22-10-028	回油除尘毡	ANTI-DUST OIL FELT	1
29	22-10-029	回油毡	OIL FELT	1
30	22-10-030	回油毡夹	OIL FELT PRESSER	1
31	22-10-031	面部油线板组件	OIL WICK SUPPORT ASM.	1
32	22-10-032	面部油线板	OIL WICK SUPPORT	1
33	22-10-033	面部油线	OIL WICK	1
34	22-10-034	面部油线板螺钉	SCREW	1
35	22-10-035	软管下支承板	WIRE HOLDER BARCKET(LOWER)	1
36	22-10-036	软管下支承板压板	WIRE HOLDER	1
37	22-10-037	软管下支承板压板螺钉	SCREW 11/64-40 L=5	1
38	22-10-038	油线固定板大组件	OIL THREAD FIXED PLATE COMPONENT	1
39	22-10-039	油线固定板螺钉	OIL THREAD FIXED PLATE SCREW	2
40	22-10-040	挡油海绵	OIL SPONGE BLOCK	1

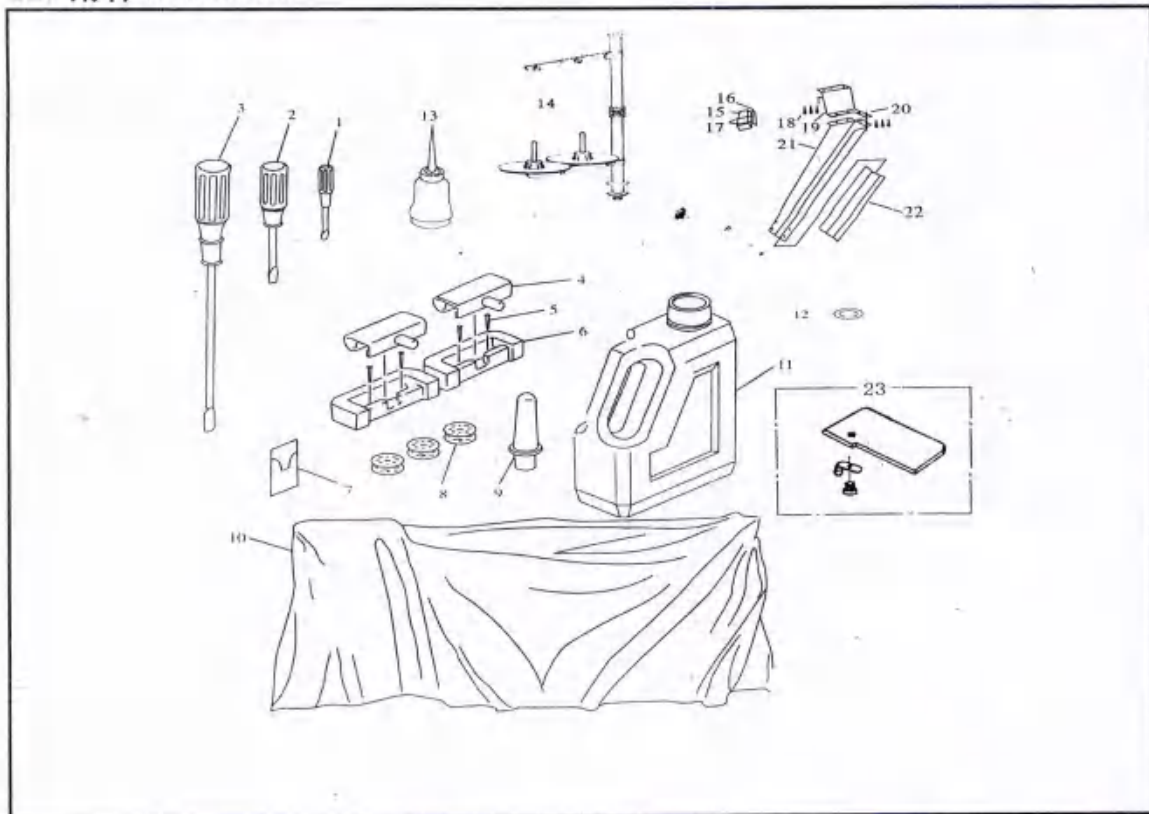
### 11. 油盘、膝提抬压脚分组件 Presser foot components of oil plate knee lift



序号 Ref.No	图号 Part Number	名称	Description	数量 QTY
1	22-11-001	油盘部件	OIL PLATE COMPONENTS	1
2	22-11-002	油盘	OIL PLATE	1
3	22-11-003	油盘垫	OIL PLATE BED	1
4	22-11-004	机头座垫	MACHINE HEAD BED	1
5	22-11-005	排油孔螺钉	OIL EXRRACTION HOLE SCREW	2
6	22-11-006	排油孔螺钉O型圈	"O"RING OF OIL EXTRACTING HOLE SCREW	1
7	22-11-007	抬压脚双向曲柄	TWO-WAY CRANK OF LIFTING PRESSOR FOOT	1
8	22-11-008	双向曲柄螺钉	SCREW	1
9	22-11-009	双向曲柄限位调节螺钉	BANKING SCREW	1
10	22-11-010	双向曲柄限位调节螺母	BANKING NUT OF TWO-WAY CRANK	2
11	22-11-011	双向曲柄扭簧	TWISTING SPRING	1
12	22-11-012	抬压脚轴	LIFTING PRESSOR FOOT SHAFT	1
13	22-11-013	抬压脚轴开口挡圈	OPEN SHIELD RING	1
14	22-11-014	抬压脚操纵杆接头	OPERATING BAR HEAD OF LIFTING PRESSOR FOOT	1
15	22-11-015	操纵杆接头螺钉	OPERATING BAR HEAD SCREW	2
16	22-11-016	油盘磁铁	OIL PLATE MAGNET	1
17	22-11-017	油盘支座	OIL PLATE SEAT	1
18	22-11-018	油盘座钉	OIL PLATE NAIL	2
19	22-11-019	抬压脚顶销	TOP PIN OF LIFTING PRESSOR FOOT	1
20	22-11-020	操纵杆部件	OPERATING BAR COMPONENTS	1
21	22-11-021	操纵杆	OPERATING BAR	1
22	22-11-022	操纵板	OPERATING P:ATE	1
23	22-11-023	操纵板软垫	SOFT CUSHION OF OPERATING BAR	1
24	22-11-024	操纵板垫	OPERATING BAR BED	1
25	22-11-025	操纵杆接头	OPERATING BAR TIP	1
26	22-11-026	接头螺钉	TIP SCREW	1



## 12. 附件 Auxiliaries



序号 Ref.No	图号 Part Number	名称	Description	数量 QTY
1	22-12-001	螺丝刀 (小)	SCREW DRIVER, SMALE	1
2	22-12-002	螺丝刀 (中)	SCREW DRIVER, MIDDLE	1
3	22-12-003	螺丝刀 (大)	SCREW DRIVER, LARGE	1
4	22-12-004	机头连接钩部件	HINGE COMPL	2
5	22-12-005	机头连接钩座钉	NAIL	4
6	22-12-006	机头连接钩座	RUBBER CUSHION	2
7	22-12-007	机针	NEEDLE	1包
8	22-12-008	梭心	BOBBIN	3
9	22-12-009	机头支柱	FRAME SUPPORT BAR	1
10	22-12-010	机头罩	FRAME VINYL COVER	1
11	22-12-011	油箱部件	OIL BOTTLE WITH OIL	1
12	22-12-012	橡胶轮	RUBBER RING	1
13	22-12-013	小油壶	OILER ASM.	1
14	22-12-014	二线架部件	THREAS STAND ASM.	1
15	22-12-015	导屑板	CHIP BOARD GUIDE	1
16	22-12-016	导屑板垫	CHIP BOARD PAD GUIDE	1
17	22-12-017	导屑板螺钉	CHIP BOARD SCREWS GUIDE	2
18	22-12-018	导屑滑板支架木螺钉	SCREW	3
19	22-12-019	导屑滑板支架	CRUMBS SLIDE BRACKET	1
20	22-12-020	导屑滑板螺钉	DEBRIS SLIDE GUIDE SCREW	4
21	22-12-021	导屑滑板	CRUMBS SKATEBOARD	1
22	22-12-022	导屑连接滑板	CRUMBS CONNECTION SKATEBOARD	1
23	22-12-023	排屑孔盖板组件	CLEARANCE HOLE COVER COMPONENTS	1