



**ZOJE**

中捷

# 直驱中厚料上下送料平缝机

DIRECT DRIVE TOP AND BOTTOM FEED  
LOCKSTICH SEWING MACHINE

**使用说明书**  
OPERATION MANUAL

**零件样本**  
PARTS BOOK

10048317

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CONTENTS  
Operation Manual

# 使用说明

## Operation Manual

Parts Book

## 1、机器简介

直驱中厚料上下送料自动剪线平缝机系单直针，采用连杆式送料，连杆挑线机构，旋梭勾线，形成301线迹。

本机采用油泵自动润滑，运转轻滑，噪音低，振动小，特别适用于缝制皮革，帆布，厚重装饰布，织带类织物，如：箱包，汽车座垫，帐篷，沙发等。

电脑控制的剪线、定针数、定针位功能，准确可靠。

## 2、主要技术规格

缝料	中厚料
最高转速	2000针/分
最大针距	8mm
针杆行程	37mm
压脚交互量	3.5-5.5mm
采用机针	DP x 17 23#
压脚提升高度	手控 8mm 膝控 16mm
采用旋梭	自动润滑大旋梭
供油方式	全自动供油
电机功率	750w

## 3、安装油盘 (图1)

1、将机头防震块②(两个)插进油盘①前方的角内。

2、将机头防震块③(两个)插进油盘①后方的角内。

3、水平地将油盘④嵌在台板的框孔内。

4、将两个机壳铰链套⑤放入台板的凹槽内。

## 3、Installing the oil pan (Fig.1)

1、Insert the two head cushion ② into the front corners of the oil pan ①;

2、Insert the two head cushion ③ into the back corners of the oil pan ①;

3、Place the oil pan ④ into the cutouts of table;

4、Insert the two rubber cushion ⑤ into the notches of table.

## 1、Brief introduction

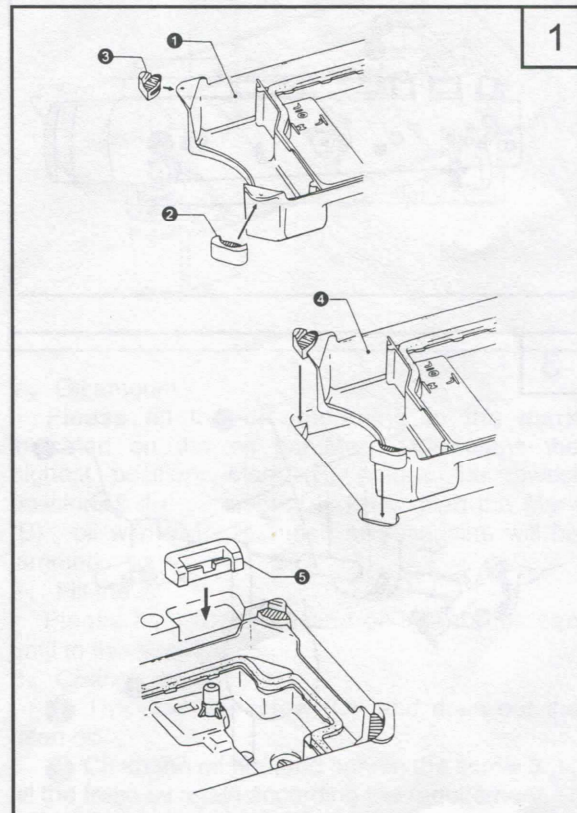
This machine is designed with link type feed mechanism and link lever thread take-up mechanism and full lubrication by pump.

It's suitable for sewing leather, canvas and other heavy weight materials; such as suitcase, car seat, tent, sofa, etc.

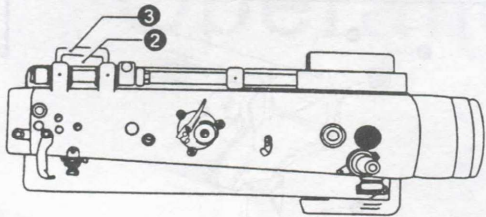
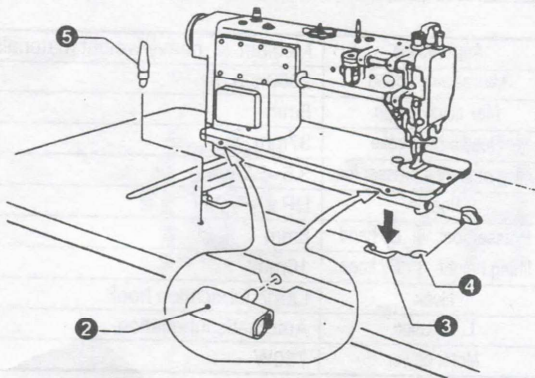
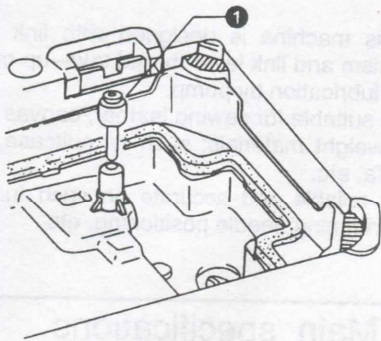
It's reliable and accurate on such functions as thread trimming, needle positioning, etc.

## 2、Main specifications

Applications	Medium & heavy weight materials
Max sewing speed	2000 s.p.m
Max stitch length	8mm
Needle bar stroke	37mm
Lifting amount of presser feet	3.5-5.5mm
Needle	DP x 17 23#
Presser foot lifting height	By hand 8mm By knee 16mm
Hook	Large lubrication hook
Lubrication	Automatic lubrication
Motor power	750W



2



#### 4、安装机头 (图2)

- 1、插入膝控提升顶杆 ①。
  - 2、将两个机壳铰链 ② 插入机头平板的两孔内。
  - 3、将机头上的铰链勾住台板上的铰链套, 平稳地将机头放入台板的框孔中。
  - 4、将机头撑杆 ⑤ 插入孔中。
- 注意: 确保机头撑杆插入孔中。  
如撑杆未插到最低位置, 放入机头时, 机头将发生倾倒, 这样比较危险。

#### 4、Installing the machine head (Fig.2)

- 1、Insert the knee lifter lifting bar ①.
  - 2、Insert the two hinges ② into the holes in the machine bed.
  - 3、Clamp the two hinges onto the rubber cushions ③ in the work table, and place the machine head onto the head cushions ④ which are on the top of the oil pan corners.
  - 4、Tap the rest bar ⑤ into the table hole.
- NOTE: Tap the rest bar securely into the table hole. If not, the machine head will not be safe when it is tilted back.

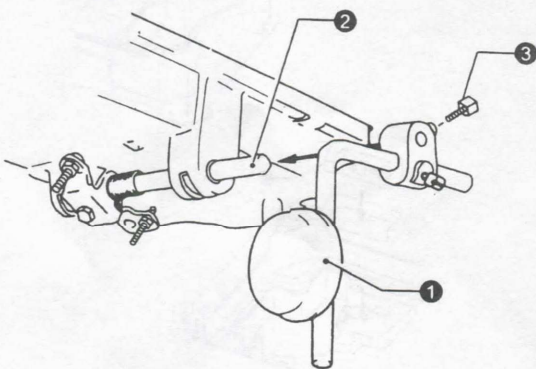
#### 5、安装膝控装置 (图3)

将膝控碰块 ①, 弯杆及接头插入铰链轴 ② 中, 稍微拧紧螺钉 ③。

#### 5、Installing the knee lifter assy (Fig.3)

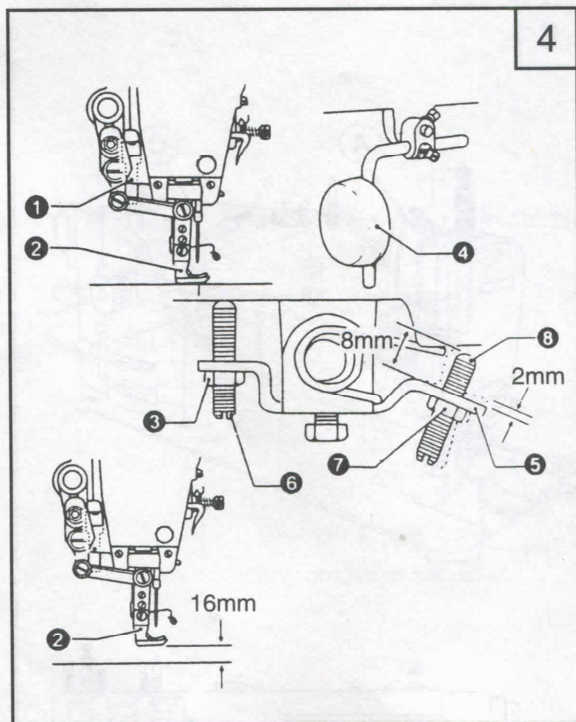
Insert the knee lifter assy. ① into the shaft ② under the oil pan, and slightly tight the screw ③.

3



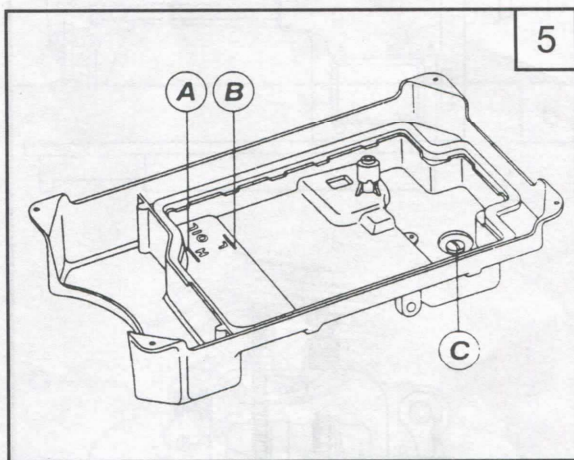
## 6、调整膝控装置 (图4)

- 1、转动压脚提升扳手①将压脚②完全放下。
- 2、松开螺母③。
- 3、拧紧螺母⑥调节膝控限位架，使之转动2mm。
- 4、拧紧螺母③。
- 5、松开螺母⑦。
- 6、拧动螺钉⑧，使该螺钉的末端至膝控限位架之间的长度达到8mm。
- 7、通过转动螺钉⑧并操作膝控碰块，可以使压脚底面至针板的距离在16mm之内得到调整。
- 8、调节完成后，拧紧螺母⑦。



## 6、Adjusting knee lifter (Fig.4)

- 1、Lower the presser foot ② by turning the presser foot bar lifter ①.
- 2、Loosen the nut ③.
- 3、Turn the screw ⑥ to adjust the bracket ⑤ to 2mm play.
- 4、Securely tighten the nut ③.
- 5、Loosen the nut ⑦.
- 6、Turn the screw ⑧ until the distance between the end of the screw and bracket is approximately 8mm.
- 7、Turn the adjusting screw ⑧ to adjust, so that the presser foot is at the desired position within a distance of 16mm above the needle plate when the knee lifter plate ④ is fully pressed.
- 8、After adjustment, tighten the nut ⑦.

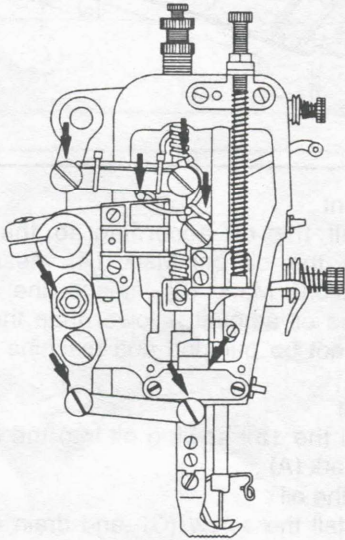
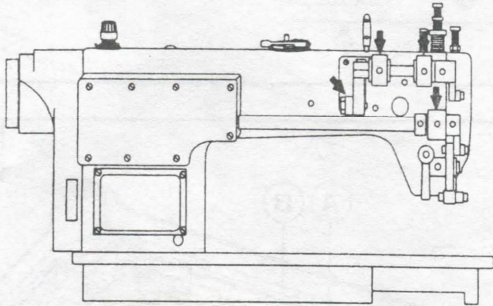
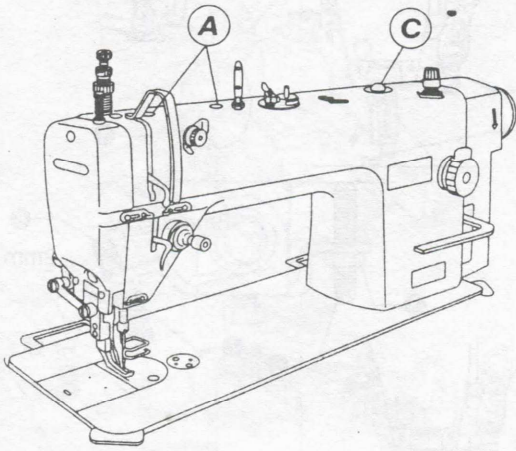


## 7、润滑 (图5) Lubrication (Fig.5)

- 1、油量  
油量必须按油盘内标记加注，图中标记(A)是油量最高位，(B)是油量最低位。注意油量不得低于标记(B)否则缝纫机各部位就会出现进油停止，造成发热咬死等情况。
- 2、加油  
必须使用18#高速缝纫机油，运转前油量加至标记(A)。
- 3、换油  
①旋下放油螺钉(C)，排净废油。  
②扫清油盘污尘，旋紧放油螺钉(C)，加注新油。

- 1、Oil amount  
Please fill the oil according to the mark indicated on the oil pan. Mark (A) means the highest position. Mark (B) means the lowest position. If the oil amount is lower than the Mark (B), oil will not be pumped and machine will be jammed.
- 2、Fill the oil  
Please fill the 18# sewing oil into the oil pan until to the Mark (A).
- 3、Change the oil  
① Uninstall the screw (C), and drain out the used oil  
② Clean the oil pan, and tighten the screw (C), fill the fresh oil again according the requirement.

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## 8、试车 (图6)

新机器在开始使用和长期搁置重新使用时,先卸下机头上部的橡皮塞(A)和面板,按图示的位置充分加油,然后装上面板,抬起压脚进行低速运转1000~1500针/分,并观察油窗(C)的喷油情况,润滑正常后,仍须保持低速30分钟的运转试验,以后逐步充分磨合。然后根据工作的性质再提高到一定缝速。

## 8、Test operation (Fig.6)

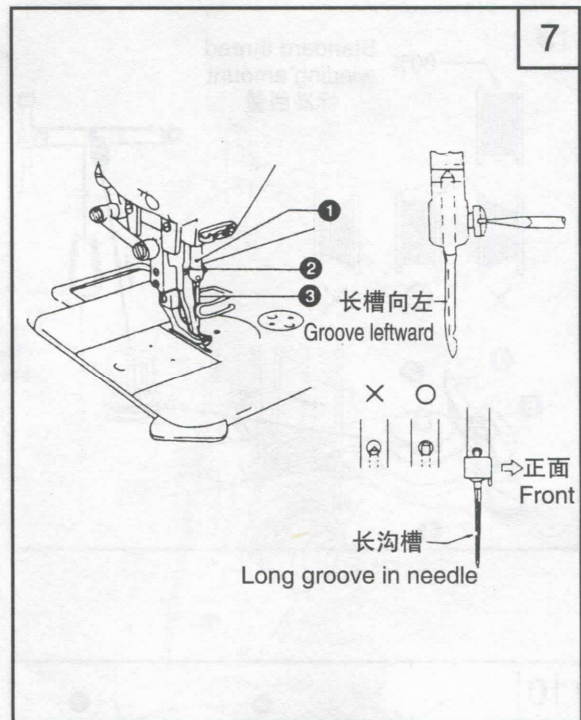
Carry out test operation when start up a new sewing machine for the first time, or restart after a long period of non-use. Remove the rubber cap (A) on the top of the arm and face plate, fully lubricate the parts showed by the arrows. Install the face plate again, lift the presser foot and operate the machine at a lower speed of 1000-1500spm, and observe the oil running through the oil gauge window. After one month, then the speed can be increased according to the different sewing operation.

## 9、安装机针 (图7)

- 1、转动上轮使机针上升至最高位置。
- 2、旋松夹针螺钉 ②。
- 3、将机针 ③ 直线插入到底 (碰到针杆孔的底部为止), 确保长槽向左, 然后拧紧螺钉 ②。

## 9、Installing the needle (Fig.7)

- 1、Turn the machine pulley to move the needle bar 1 to its highest position ;
- 2、Loosen the screw ② .
- 3、Insert the needle ③ in a straight line as far as it will go, making sure that the long groove on the needle is at the left, and then securely tighten the screw ② .



## 10、装卸梭芯套 (图8)

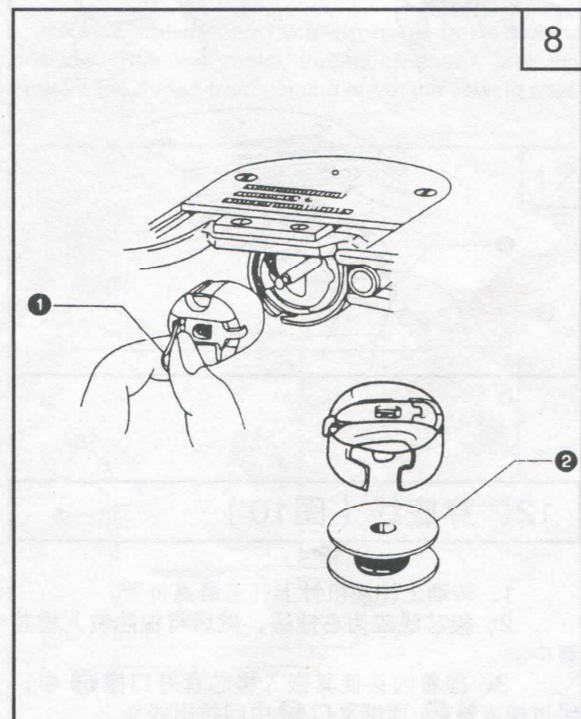
1、装梭心套的时候, 机针应该是最高位置。先拉开梭门盖 ①, 之后把梭心套放入旋梭中。放入时请注意梭心套上的定位板是否已经和旋梭心轴上的定位槽相扣合。

2、卸梭心套时, 必须将梭门套向外扳开并且扳足, 之后捏着扳开的梭门盖徐徐地取下梭心套, 如此才能使梭心套钩住梭心, 不让梭心脱落。

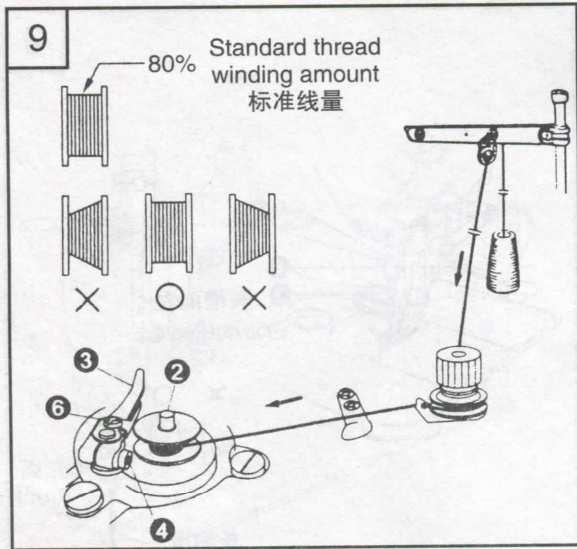
## 10、Removing the bobbin case (Fig.8)

1、Turn the machine pulley to lift the needle bar to its highest position. Pull the latch ① of the bobbin case upward and then put the bobbin into the bobbin case, finally insert the complete bobbin case with bobbin into the hook shaft.

2、To remove the bobbin case, pull the latch and draw the bobbin case out if the hook.







## 11、绕取梭芯线 (图9)

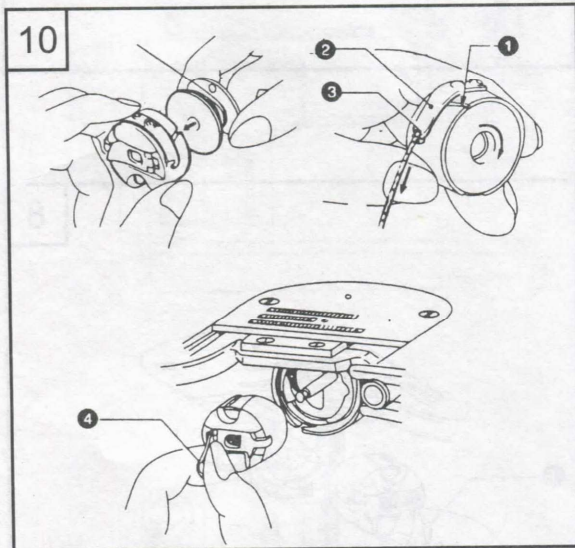
- 1、打开电源。
- 2、将梭芯插入绕线轴 ② 的底部。
- 3、根据箭头所示的方向，先将线在梭芯上绕几圈。
- 4、扳动绕线摆杆 ③。
- 5、将压脚抬起来。
- 6、踩下踏板，便开始自动绕底线了。
- 7、当梭芯绕满后，绕线摆杆 ③ 便会自动复位。

\*如果梭芯线排列不齐，可以通过松开过线架螺钉 ④ 及移动绕线摆杆 ③ 的位置进行调节。

\*绕线量由满线跳板上的满线度调节螺钉 ⑥ 加以调节。

### 注意:

适当的绕线量为平行绕线至梭芯外径的80%。



## 11、绕取梭芯线 (图9)

- 1、Turn the power on ;
- 2、Place the bobbin ① onto the bobbin winder shaft ;
- 3、Wind the thread several circles around the bobbin in the direction indicated by arrow ;
- 4、Push down the bobbin presser arm ③ ;
- 5、Lift the presser foot ;
- 6、Depress the treadle, the winding operation will start;
- 7、Once finished, the bobbin presser arm ③ will release automatically.

\* If the thread winding is not neat and even, loosen the screw ④ to adjust the position of bobbin presser arm ③ .

\* Turn the screw ⑥ to adjust the bobbin winding amount.

### Note:

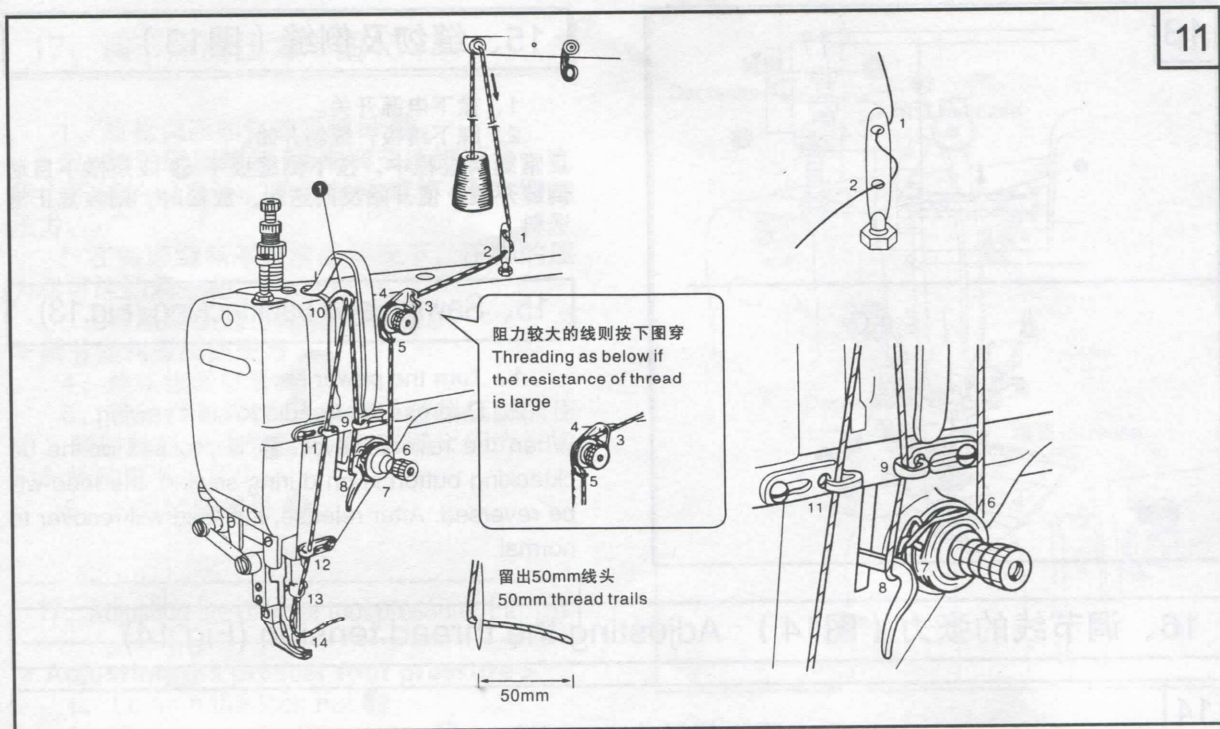
The proper winding amount should be around 80% of the bobbin capacity.

## 12、穿底线 (图10)

- 1、转动上轮使机针上升至最高位置。
- 2、梭芯线应为右捻线，然后将梭芯装入梭芯套中。
- 3、捏着线头使其嵌入梭芯套开口槽 ① 中，经过梭皮簧 ② 顶端叉口 ③ 中间拉出线头。
- 4、当牵引线时，梭芯应是顺时针转动。
- 5、扳开梭门盖 ④，将梭芯套装入旋梭中（放入时请注意梭芯套上的定位板是否已经和旋梭芯轴上的定位槽相吻合。）

## 12、Threading the bobbin thread (Fig.10)

- 1、Turn the machine pulley to lift the needle to its highest position;
- 2、The bobbin thread should be right twist, place the bobbin into the bobbin case ;
- 3、Pass the thread through the slot ① and spring plate ②, and finally pull it out of the notch ③ ;
- 4、Check that the bobbin should turn clockwise if the thread is pulled ;
- 5、Hold the latch ④, and place the bobbin case in the hook.



### 13、穿面线 (图11)

在穿面线之前请让挑线杆上升至最高位置, 这样便于穿线并可防止开始缝纫时发生面线从针孔中脱落。

### 13、Threading the needle thread (Fig.11)

Raise the thread take-up lever to its highest position. This will make threading easier and prevent the thread from coming out at the sewing start.

### 14、调节针距 (图12)

按下针距按键②, 左右转动针距盘, 将针距标盘上的数字对准针距按键②上的竖线标记。

\* 数字越大, 相应的针距越大。

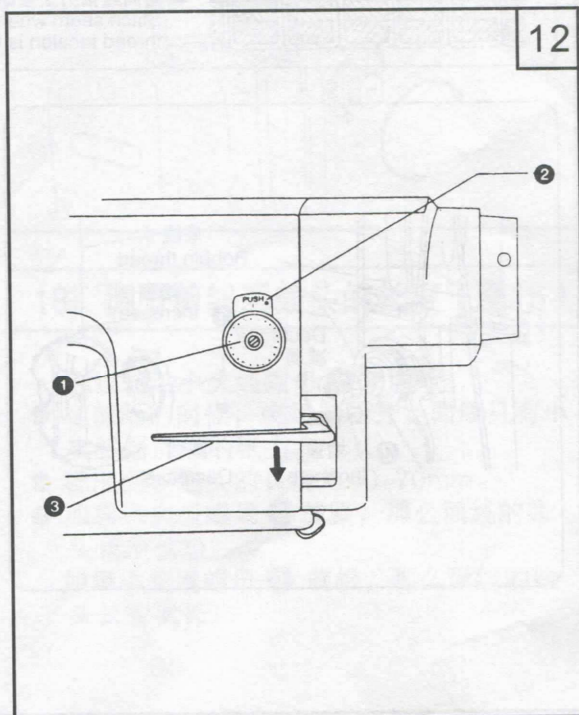
\* 当针距标盘上的数字从大向小方向转动时, 将倒缝扳手向下压至一半位置时, 转动时更加轻松一些。

### 14、Adjusting the stitch length (Fig.12)

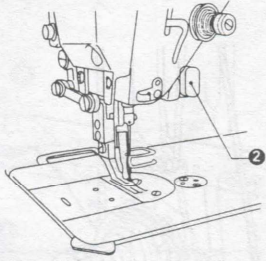
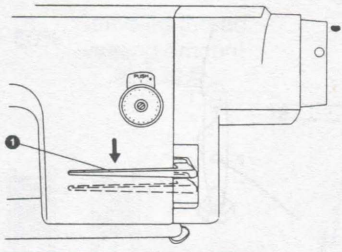
While press the stopper ②, turn the stitch length dial ① to make the number on the dial align with the mark on the stopper ②. The number is the stitch length in mm.

\* The larger the number, the longer the stitch length will be.

\* When turn the dial from a larger setting to a smaller setting, it will be easy to turn if the reverse lever ③ is pressed down.



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## 15、缝纫及倒缝 (图13)

- 1、按下电源开关。
- 2、踩下踏板，缝制开始。

正常缝制过程中，按下倒缝扳手 ① 或是按下自动倒缝开关，便开始反向送料，放松时，则恢复正常送料。

## 15、Sewing and backtacking (Fig.13)

- 1、Turn the power on;
- 2、Depress the treadle to start sewing.

When the reverse lever ① is pressed or the backtacking button is on during sewing, the feed will be reversed. After release, the feed will recover to normal.

## 16、调节线的张力 (图14) Adjusting the thread tension (Fig.14)

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## 正常线迹 Normal Seam



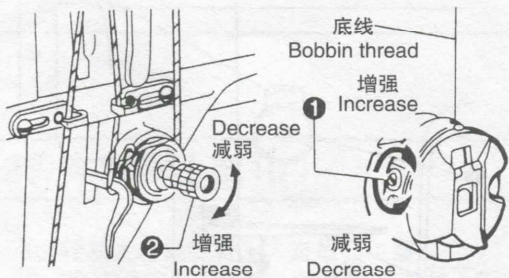
● 当面线张力太弱时出现的线迹  
Stitch seam when needle thread tension is too weak

- 增大面线张力 increase the needle thread tension
- 减弱底线张力 decrease the bobbin thread tension



● 当面线张力太强时出现的线迹  
Stitch seam when needle thread tension is too strong

- 减弱面线张力 decrease the needle thread tension
- 增大底线张力 increase the bobbin thread tension



## &lt; 底线张力 &gt;

通过转动梭皮螺钉 ① 调节底线的张力，一般为捏住线头吊起梭心套，梭芯套能够缓慢地自由落下就可使用了。

## &lt; 面线张力 &gt;

将底线张力调节完后，再调节面线张力更好，会出现正常的线迹。

- 1、放下压脚。
- 2、调节夹线器螺母 ②。

## &lt; Bobbin thread tension &gt;

Adjust by turning the screw ① until the bobbin case drops gently by its own weight while the thread end coming out if the bobbin case is held.

## &lt; Needle thread tension &gt;

After adjust the bobbin thread tension, adjust the needle thread tension so that a good, even stitch seam is obtained.

- 1、Lower the presser foot;
- 2、Adjust by turning the thread tension nut ②.

## 17、调节压脚压力 (图15)

- 1、旋松调压螺钉锁紧螺母 ①。
- 2、转动调压螺钉 ② 来调节压脚压力, 在压力不够的情况下, 可以转动螺钉 ⑤ 来增加压力。

\* 在保证缝料不打滑的情况下, 压脚的壓力尽可能的弱一些。

- 3、拧紧调压螺钉锁紧螺母 ①。

### < 调节送料压脚的压力 >

- 4、旋松锁紧螺母 ③。
- 5、转动调节螺钉 ④ 来调节送料压脚的壓力, 顺时针转动调节螺钉 ④ 来增大压力, 逆时针转动则减小压力。
- 6、拧紧锁紧螺母 ③。

## 17、Adjusting the presser foot pressure (Fig.15)

### < Adjusting the presser foot pressure >

- 1、Loosen the lock nut ①;
- 2、Turn the adjusting screw ② to adjust the pressure of presser foot, if it's not enough, please turn the screw ⑤ to increase the pressure

\* The pressure should be as weak as possible, but strong enough so that the material doesn't slip.

- 3、Tighten the nut ①.

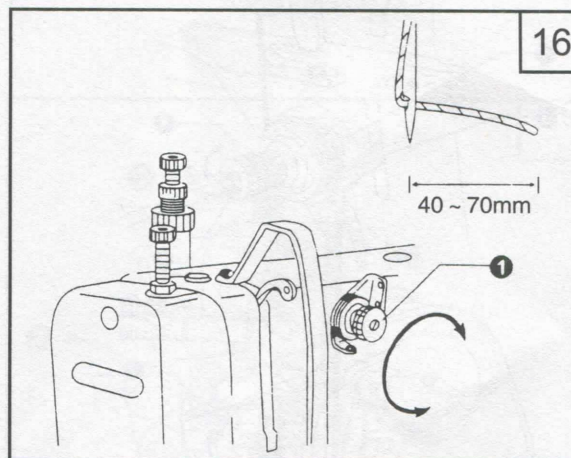
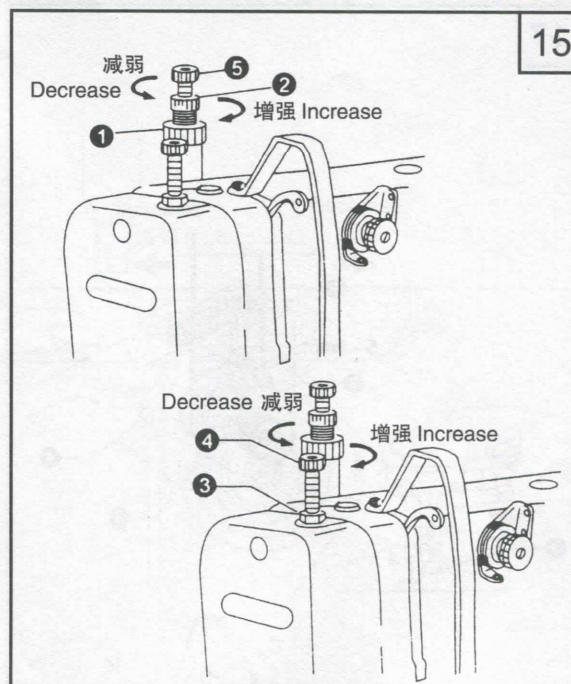
### < Adjusting the walking foot presser >

- 1、Loosen the nut ③;
- 2、Turn the screw ④ clockwise to increase the pressure, on the contrary, turn the screw counterclockwise to decrease the pressure;
- 3、Tighten the nut ③.

## 18、Adjusting the trailing length after thread trimming (Fig.16)

Turn the nut ① to adjust the trailing length.

- At the time of thread trimming, the thread tension mechanism will release and the needle thread tension is only applied by the thread ①;
- The standard trailing length for the needle thread is 40-70 mm;
- If increase the thread guide tension, the trailing length will be short; if decrease the thread guide tension, the trailing length will be longer.

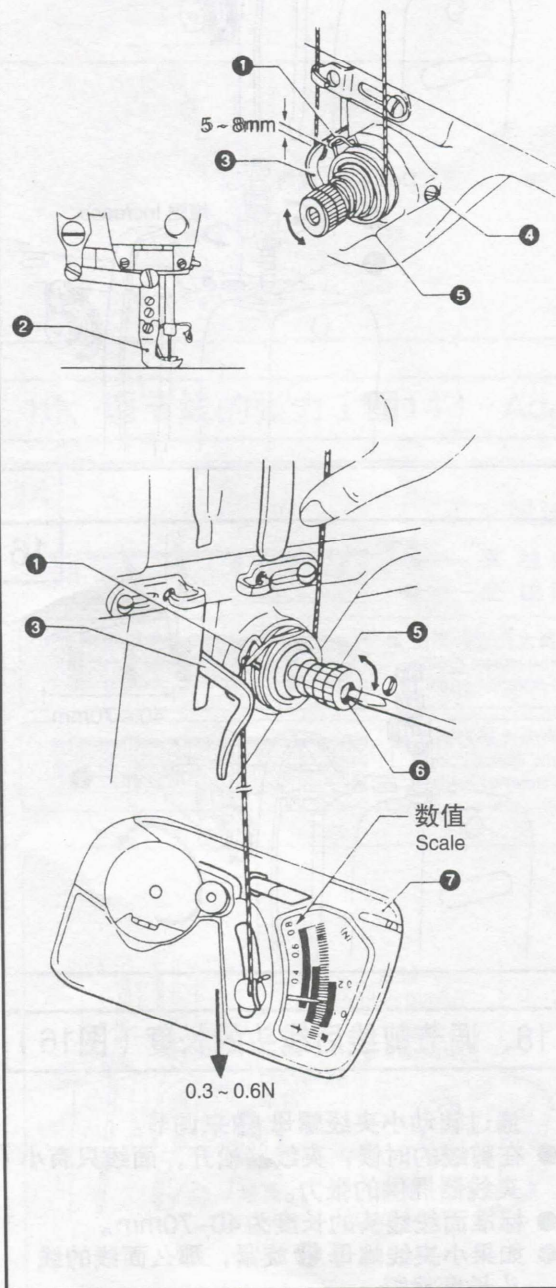


## 18、调节剪线后线头的长度 (图16)

通过转动小夹线螺母 ① 来调节。

- 在剪线的时候, 夹线器松开, 面线只有小夹线器提供的张力。
- 标准面线线头的长度为40~70mm。
- 如果小夹线螺母 ① 旋紧, 那么面线的线头长度就短。
- 如果小夹线螺母 ① 旋松, 那么面线的线头长度就长。

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## 19、安装机针 (图17)

\* 挑线簧的标准位置为: 当压脚②放下时, 大线勾③的上表面至挑线簧① 5~8mm。

- 1、放下压脚②。
- 2、松开固定螺钉④。
- 3、转动夹线组件⑤ 调整夹线簧的位置。
- 4、拧紧固定螺钉④。

\* 挑线簧的标准强度为0.3~0.6N

5、将面线拉出夹线器⑤ 少许, 并用手指按住。

6、将面线向下拉, 使挑线簧① 与大线勾③上表面一致, 这时就测定挑线簧的强度。

7、用开刀插入夹线螺钉槽⑥ 中, 通过转动开刀来调节挑线簧① 的力度。

**注意:**

当使用测力器⑦ 请读取对准红线上的那个数字。

## 19、Adjusting the thread tension spring (Fig.17)

\* The standard position if the thread tension spring ① is 5-8mm above the upper surface ③ when the presser foot ② is lowered.

- 1、Lower the presser foot ②;
- 2、Loosen the screw ④;
- 3、Turn the thread tension bracket ⑤ to adjust the spring position;
- 4、Tighten the screw ④.

\* The standard tension of the spring is 0.3-0.6N.

5、Push the needle thread with your finger until it is slightly higher than the thread tension bracket ⑤ and so that the upper thread is not pulled out;

6、Pull the needle thread down until the spring ① is at the same height with the upper surface of thread guide, ③, and then measure the tension of the spring.

7、Insert a screwdriver into the slot of the thread tension stud ⑥, and turn the stud to adjust the tension of the spring ①.

**Note:**

If using a tension gauge ⑦ to measure the tension, take the reading from the scale on the side of the red line.

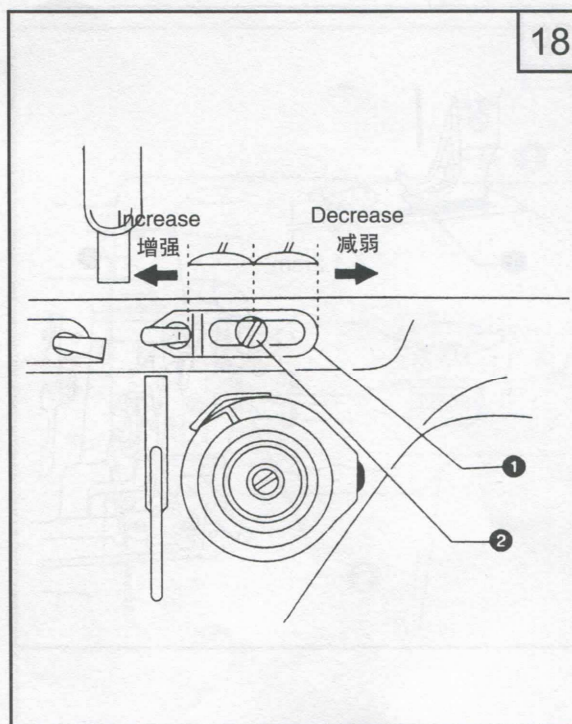
## 20、调节机壳线勾 (图18)

机壳线勾 ① 的标准位置是螺钉 ② 处于机壳线勾调节范围的中心位置。

通过松开螺钉 ②，移动机壳线勾来调节位置。

当缝纫厚料时，将机壳线勾向左移（挑线力将增大）。

当缝纫薄料时，将机壳线勾向右移（挑线力将减弱）。



## 20、Adjusting the upper thread guide (Fig.18)

The standard position of upper thread guide ① is where the screw ② is in the center of the adjustable range of upper thread guide.

To adjust the position, loosen the screw ② and move the thread guide.

If stitch the heavy materials, move the thread guide leftward. (To increase the thread take-up tension)

If stitch the light materials, move the thread guide rightward. (To decrease the thread take-up tension)

## 21、调节压脚高度 (图19)

当使用压脚扳手提升压脚时，压脚的标准提升高度为8mm。

1、松开压脚调节螺钉 ③ 使压紧杆及压脚上升。

2、在压脚下放置8mm厚的量块。

3、松开螺钉 ④ 上下调整压脚高度。

4、拧紧螺钉 ④。

## 21、Adjusting the presser foot height(Fig.19)

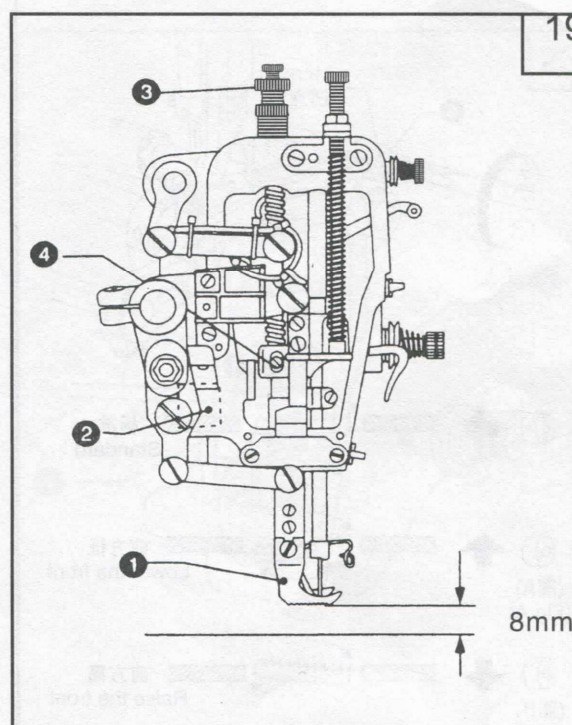
The standard height of presser foot ① is 8mm when it is lifted by hand.

1、Loosen the screw ③ to lift the presser bar.

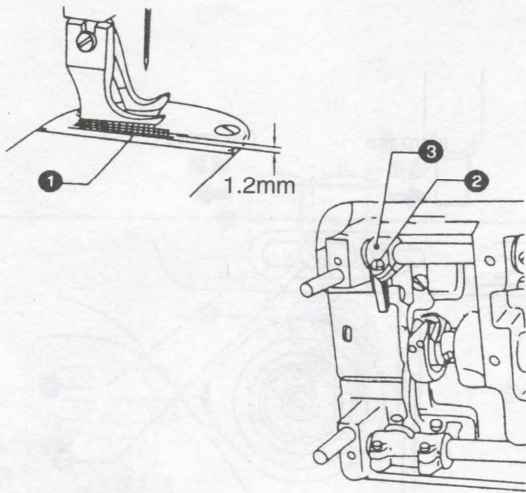
2、Put a measurement gauge with 8mm height under the presser foot ;

3、Loosen the screw ④ and adjust the height of presser foot ;

4、Tighten the screw ④.



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## 22、调节送布牙高度 (图20)

当使用压脚扳手提升压脚时，压脚的标准提升高度为8mm

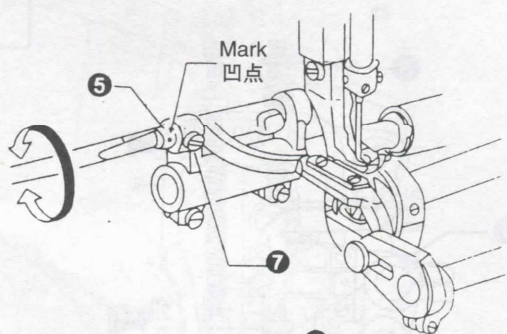
- 1、松开压脚调节螺钉 ③ 使压紧杆及压脚上升。
- 2、在压脚下放置8mm厚的量块。
- 3、松开螺钉 ④ 上下调整压脚高度。
- 4、拧紧螺钉 ④。

## 22、Adjusting the feed dog height (Fig.20)

The standard height of presser foot ① is 8mm when it is lifted by hand.

- 1、Loosen the screw ③ to lift the presser bar.
- 2、Put a measurement gauge with 8mm height under the presser foot;
- 3、Loosen the screw ④ and adjust the height of presser foot;
- 4、Tighten the screw ④.

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送布牙的标准倾斜角度为：当送布牙高于针板并处于最高位置时，牙架曲柄偏心轴 ⑤ 上的凹点标记处于水平位置。

- 1、转动上轮使送布牙浮出针板并处于最高位置。
- 2、松开牙架曲柄轴螺钉 ⑦。
- 3、根据送布牙的标准角度位置，使凹点标记90° 范围内转动调整。

\* 送布牙前降低，可以防止布料起皱 (图A)。

\* 送布厅前方抬高，可以防止布料跑偏 (图B)。

- 4、拧紧牙架曲柄轴螺钉 ⑦。

送布牙角度调整结束后，重新调节送布牙的高度是必要的。

## 23、调节送布牙的角度 (图21)

The standard angle of the feed bog is: when the feed dog is at its highest position above the needle plate, the Mark on the feed bracket shaft is on the horizontal position.

- 1、Turn the machine pulley to lift the feed dog to its highest position;
- 2、Loosen the screw ⑦;
- 3、Turn the feed bracket shaft in the direction of the arrow within a range of 90 with respect to the standard angle position.

\* In order to prevent puckering, lower the front if the feed dog (Fig.A)

\* In order to keep the materials straight, raise the front of the feed bog (Fig.B)

- 4、Securely tighten the set screw ⑦;

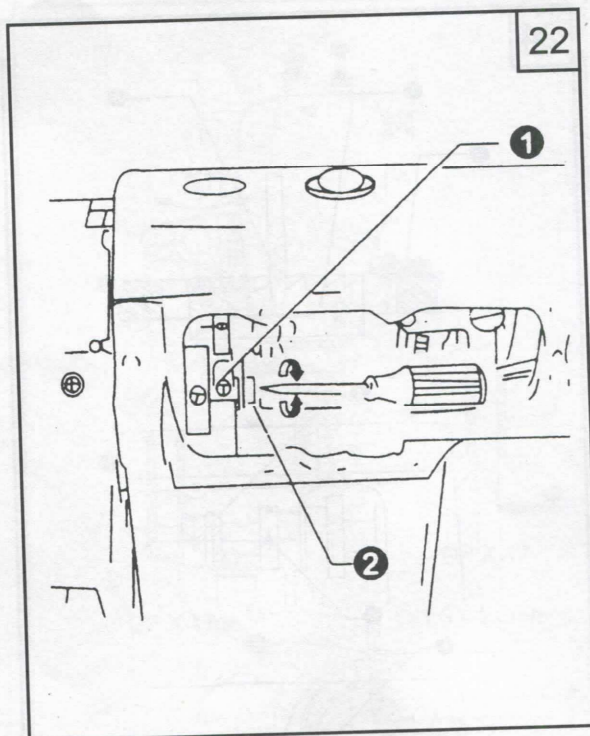
It's necessary to adjust the feed dog height again after this adjustment.

## 24、调节倒顺缝针距误差 (图22)

- 1、卸下后盖板。
  - 2、松开螺钉① 转运针距调节连杆偏心销钉②。
- \* 顺时针转：顺缝针距变大，倒缝针距变小。
- \* 逆时针转：顺缝针距变小，倒缝针距变大。

24、 Adjusting the difference of stitch length between the forward and backtacking (Fig.22)

- 1、 Remove the rear cover ;
  - 2、 Loosen the screw ① and turn the connectin stud ② .
- \* Turn the stud ② clockwise, the forward stitch length will be longer and the backtacking stitch length will be shorter ;
- \* Turn the stud ② counterclockwise, the forward stitch length will be longer ;
- 3、 Tighten the screw ① .



## 25、调节松线器的挺线 (图23)

压脚在提升范围内，夹线器上的夹线板有一个张开期，挺线的时间可进行调节。调节时，先卸下机头后侧面的橡皮塞，用螺丝刀旋松膝控提升杠杆（械）螺钉①，这是松线凸轮可以左右移动，往右移挺线慢，往左移挺线快。

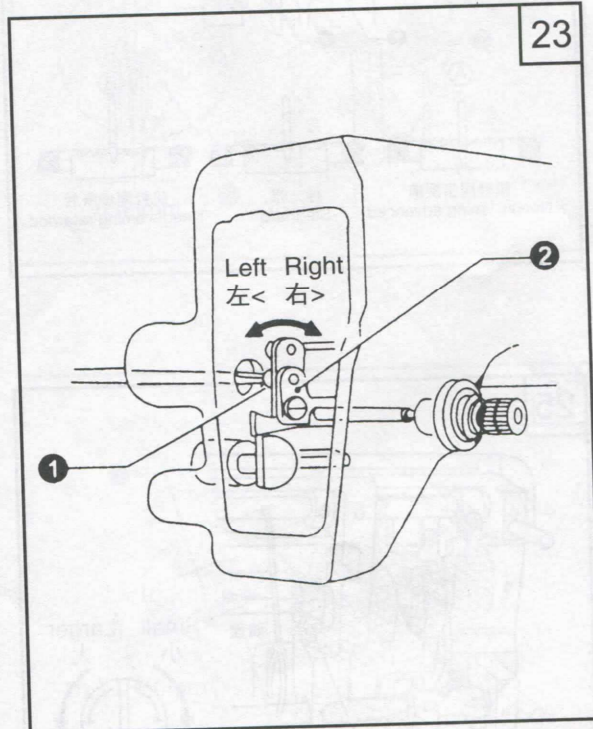
## 25、 Adjusting the tension release (Fig.23)

The opening time of the thread tension discs can be adjusted.

Remove the rubber cap on the rear of arm, and turn the screw ① then the thread release cam ② can be moved left or right .

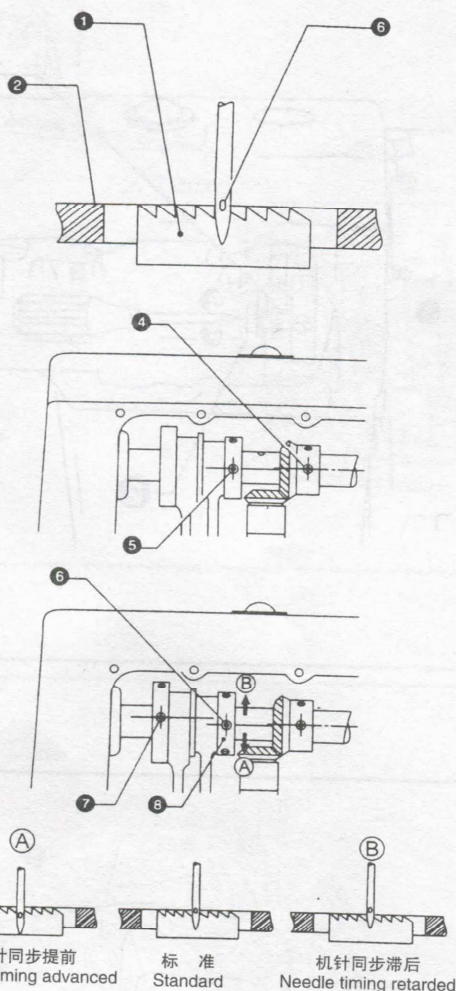
Move the cam rightward, the releas time will be slow.

Move the cam leftward, the release time will be quick





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## 26、调节机针与送布机构同步 (图24)

标准位置:

当送布牙从最高位置下降, 机针孔中心③应与针板上表面②、送布牙顶端①在同一水平面上。调整可以通过调节送布凸轮和抬牙凸轮的安置位置进行。

- 1、卸下后盖板。
- 2、用左手逆时针转运上轮, 以上轴齿轮第二只固定螺钉④为基准, 抬牙凸轮的第三只固定螺钉⑤中心, 将对齐④中心, 稍微向下偏一点。
- 3、继续逆时针转动上轮, 以抬牙凸轮⑧第二只紧固螺钉⑥为基准, 送布凸轮的第三只紧固螺钉⑦中心, 将对齐⑥中心, 稍微向上偏一点。
- 4、若要调整为非标准位置, 则先松开抬牙凸轮上三颗螺钉, 再根据A或B所示方向少许转动偏心凸轮⑧。

为增加线的张力, 则向A方向转动。  
为避免机针折弯, 则向B方向转动。

## 26、Adjusting the timing of needle and feed mechanism (Fig.24)

The standard timing is when the feed dog is lowered from its highest position until it is flush with the top of the needle plate ②, and the needle eye ③ is also aligned horizontally with the surface. Adjust by changing the phases of feed cam and eccentric wheel UD.

- 1、Remove the rear cover.
- 2、Turn the machine pulley in reverse direction, set the second screw ④ on the gear of upper shaft as reference mark, mark, make the third screw 5 of eccentric wheel UD slightly lower than the reference mark screw ④;
- 3、Continue to turn the machine pulley, set the second screw ⑥ of eccentric wheel UD as reference mark, make the third screw ⑦ of feed cam slightly higher than the reference mark screw ⑥;
- 4、If need a non-timing position, loosen the three screws of eccentric wheel UD, adjust the eccentric cam ⑧ in the direction of arrow (A) or (B).  
To increase the tension of thread, turn the eccentric cam ⑧ to direction (A).  
To avoid the needle bent, turn the eccentric cam ⑧ to direction (B).
- 5、After adjustment, tighten all of the screws.

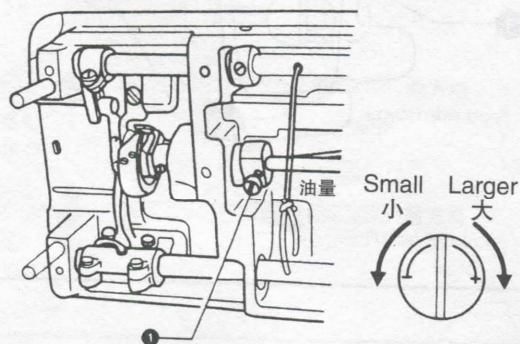
## 27、调节旋梭油量 (图25)

放倒机头, 转动油量调节螺钉①来调节油量大小。

## 27、Adjusting the rotary hook lubrication amount (Fig.25)

Tilt back the machine head, and turn the oil adjustment screw ① to adjust the hook oiling amount.

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## 28、调整针杆高度与旋梭同步 (图26)

当针杆降至最下位置时，针杆①最上面的刻线标记应与针杆下套②的下端面一致。

1、转动上轮，使针杆降至最下位置。

2、取下橡皮塞③。

3、松开螺钉④，然后上下移动针杆①来调节它的位置。

4、拧紧螺钉④。

5、塞上橡皮塞③。

使针杆①从最下位置上升，当针杆①上数第二条刻线标记B对准针杆下套②的下端面时（如图所示），旋梭的梭尖⑤应对准机针⑥的中心。

1、转动上轮使针杆①从最低位置上升，直至上数第二条刻线标记B对准针杆下套的边沿。

\* 当针杆上升2mm时，针眼上限与旋梭梭尖之间的距离为1.3~1.8mm。

2、松开螺钉⑦，然后将梭尖对准机针⑥的中心。此时梭尖与机针的侧面间隙为0.05mm。

3、拧紧螺钉⑦。

## 28、Adjusting the height of needle bar and the timing with hoot (Fig.26)

When the needle bar ① is at its lowest position, the top reference line A on the needle bar should be aligned with the bottom edge of the needle bar bush ②.

1、Turn the machine pulley to lower the needle bar to its lowest position;

2、Take out the rubber cap ③;

3、Loosen the screw ④ and move the needle bar ① to proper position;

4、Tighten the screw ④;

5、Close the rubber cap ③;

Lift the needle bar ① from the lowest position, when the second reference line B on the needle bar is aligned with the bottom edge of the needle bar bush ② the tip ⑤ of the hook should be aimed at the center of needle ⑥.

1、Turn the machine pulley to raise the needle bar ① from its lowest position until the reference line B is aligned with the bottom edge of the needle bar bush ②.

\* When the needle bar moves up 2mm, the clearance between the upper of needle hole and the hook tip should be 1.3~1.8 mm.

2、Loosen the screw ⑦, and make the hook tip aimed at the center of needle ⑥, the clearance between the hook tip and needle should be 0.05mm

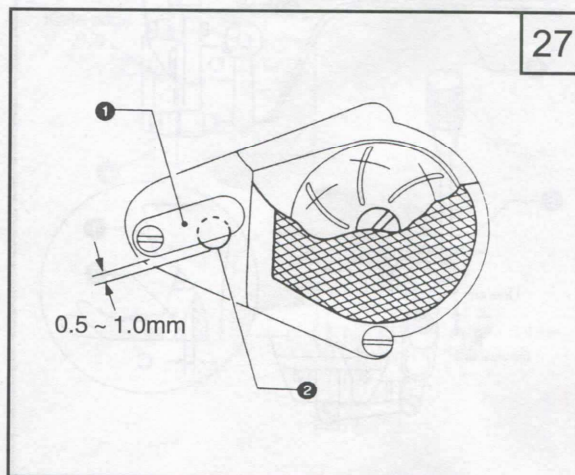
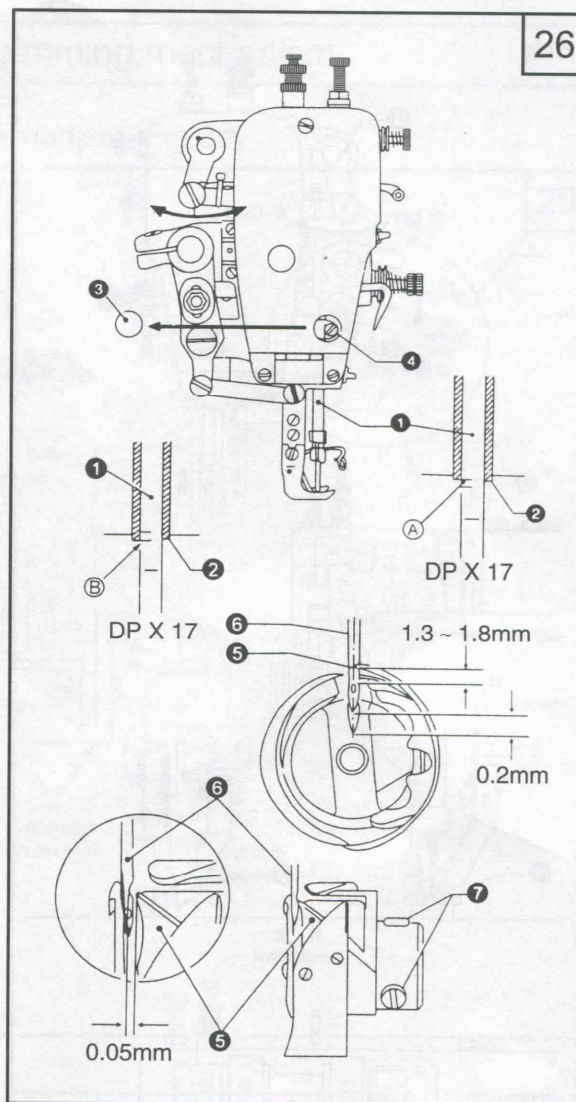
3、Tighten the screw ⑦.

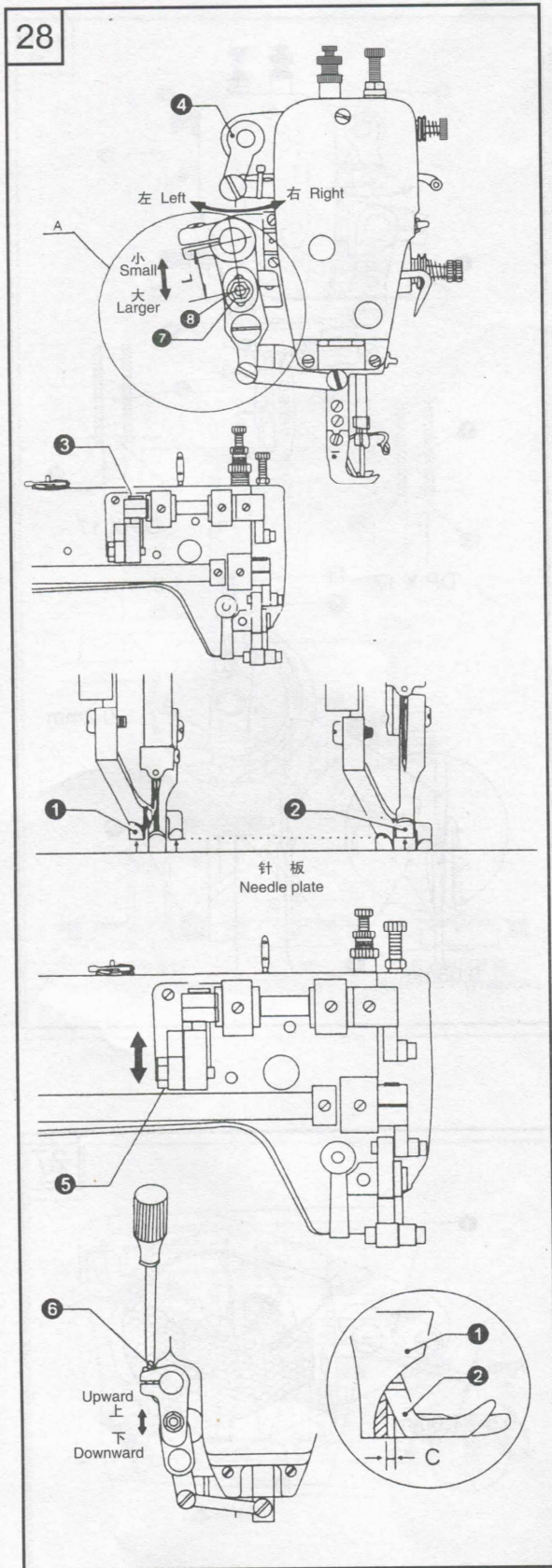
## 29、调节油泵供油 (图27)

当低速运转时，观察油窗，无喷油现象时，请转动供油调节板①，将其盖住油孔②。

## 29、Adjusting the oil pump (Fig.27)

If the oil is not crled observed from the oil gauge window at a lower sewing speed, turn the oil adjustment plate ① to cover the oil hole ②.





## 30、调节摆压脚与小压脚交替提升量 (图28)

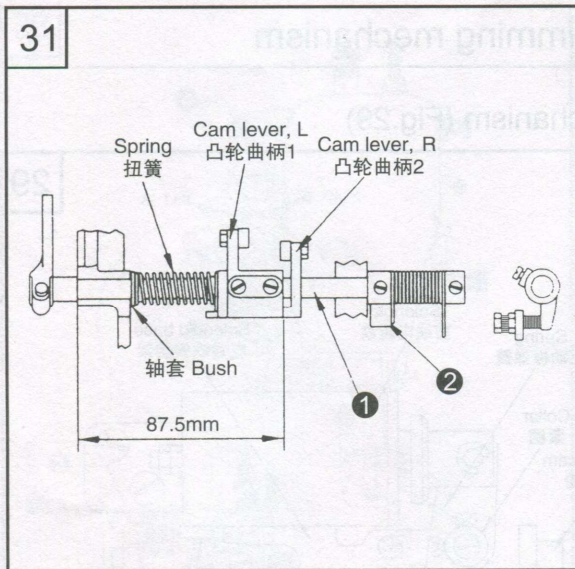
- 1、摆压脚及小压脚的垂直方向运动：
  - \* 摆压脚及小压脚是交替式的上下运动。
  - \* 摆压脚及小压脚上升高度一般是相同的或是小压脚的上升高度略低一些。
- 2、摆压脚及小压脚总提升量的调节：
  - 根据缝料的不同要改变摆压脚，小压脚的提升量。先将偏心轮连杆螺钉⑤旋松，然后上、下移动来调节螺钉与压脚升降轴的中心距，中心距调小，则各自的提升量都增加。
- 3、摆压脚、小压脚前后方向间隙的调节：
  - \* 为了在缝纫过程中，使摆压脚槽的前端与小压脚后端面不碰撞，必须保持适当的间隙C (3mm左右)。
  - 旋松摆压脚前曲柄螺钉，然后上、下转动压脚摆动轴⑥来进行调节。
- 4、摆压脚量的调节 (见A部)
  - \* 送布牙送料量与摆压脚送料量之间的标准比率为1:1 (同步送料)。
  - 摆压脚的送料量可根据缝料不同进行调整，松开螺母⑦，上下移动摆压脚滑块⑧来调节。
  - (向上：减小中心距L，摆压脚送料量减小)
  - (向下：增大中心距L，摆压脚送料量增大)

## 30、Adjusting the lifting amount of presser feet (Fig.28)

- 1、Vertical movement of presser foot and walking foot.
  - \* The walking foot ① and presser foot ② move vertically one after another.
  - \* Usually the stroke of walking foot and presser foot is same or the stroke of presser foot is slightly lower.
  - Place the thread take-up lever at the lowest position, and lower the presser bar lifter, loosen the screw ⑤ and move the upper feed lifting cam ④.
  - Move it rightward to make the stroke of two feet be equal.
  - Move it leftward to make the stroke of presser foot be smaller.
- 2、Adjusting the lifting amount of presser feet Adjust the lifting amount of two feet to match the materials to be sewn.
  - Loosen the screw ⑤, and move the screw upward to increase the lifting amount or move the screw downward to decrease the lifting amount.
- 3、Adjusting the forward/backward clearance of the two feet.
  - To keep the front groove of walking foot not strike the rear of the presser foot, the clearance of C must be kept about 3mm.
  - Loosen the screw of feed arm R, and the turn then turn the feed rock shaft ⑥ to adjust.
- 4、Adjusting the feed amount of walking foot (Fig.A)
  - \* The standard ration of feed amount between feed dog and walking foot is 1:1.
  - The feed amount of walking foot can be adjusted to suit for the materials to be sewn.
  - Loosen the nut ⑦, and move the slide block ⑧ feed amount be smaller Downward: increase the distance L to make the feed amount be larger.



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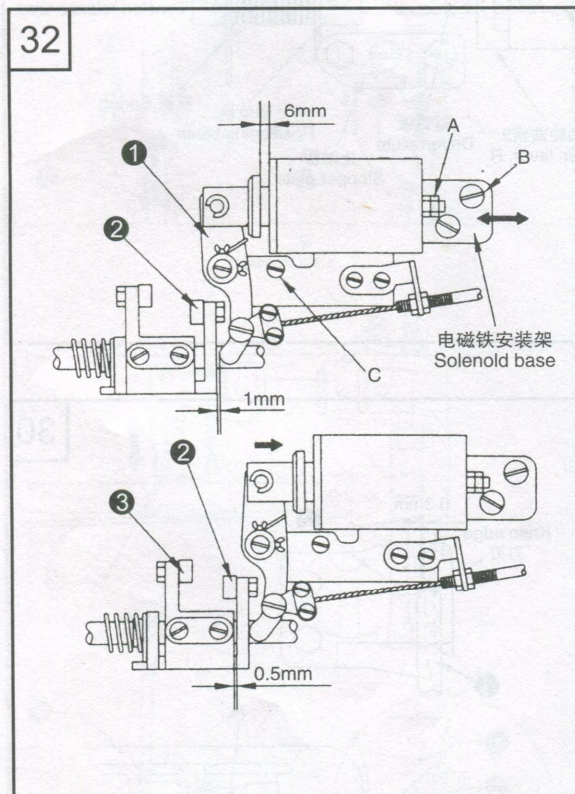
### 3、凸轮曲柄轴 (见图31)

- (1) 装配时, 将凸轮曲柄轴 ① 最先装在底板上。
- (2) 凸轮曲柄 ① 必须如图所示安装, 固定在凸轮曲柄轴 ① 上的平面处。
- (3) 轻轻转动凸轮曲柄轴 ①, 将限位块 ② 安装在凸轮曲柄轴 ① 上的平面处。

### 3、Thread trimmer cam lever shaft (Fig.31)

- (1) Install the shaft ① on the machine bed first;
- (2) Install the cam lever L on the shaft ① as illustrated;
- (3) Slightly turn the shaft ①, and install the positioning block ② as illustrated.

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### 4、安装剪线电磁铁 (见图32)

- (1) 剪线电磁铁的行程:
  - a. 标准的行程为6.0mm。
  - b. 通过调节螺母A来调整行程。
- (2) 安装剪线电磁铁:
  - A. 剪线电磁铁用螺钉B和C来固定。
  - B. 在安装时必须保证驱动板 ① 与凸轮曲柄 ② 之间的间隙1mm。
  - C. 电磁铁工作时, 凸轮曲柄 ③ 与凸轮曲柄 ② 柄之间会有0.5mm间隙, 这是标准的情况。如需调整可以如图26所示箭头方向滑动电磁铁安装架。

### 4、Installing the trimming solenoid (Fig.32)

- (1) The stroke of solenoid.
  - a. The standard stroke is 6.0mm.
  - b. Turn the nut (A) to adjust the stroke.
- (2) Installing the solenoid.
  - A. Fixed the solenoid by the screws B and C.
  - B. Be sure to keep the clearance between the driven plate ① and cam lever R ② 1mm.
  - C. When the solenoid is active, there should be a 0.5mm clearance between the cam lever L ③ and cam lever R ②. If need to adjust, please move the solenoid base shown by the arrow.

## 5、安装剪线凸轮 (见图33)

(1) 将主动轮上的第②标记点对准电机罩上的定位标记点。

(2) 将剪线电磁铁开动向前旋转剪线凸轮①直到接触滚柱, 然后固定凸轮。

(3) 剪线电磁铁关闭, 使凸轮曲柄②回复到原始位置, 这样凸轮与滚柱端面将会产生0.5-1.0mm的标准间隙。

## 5、Instaling the trimming cam (Fig.33)

(1) Align the second mark A on the machine pulley with the Positioning Mark on the arm;

(2) Set the solenoid active and turn the trimming cam ① until the cam is touched with the roller. then fix the cam;

(3) Set the solenoid inactive and make the cam lever ② restore to the original position, there should be a 0.5-1.0mm clearance between cam and roller.

## 6、刀片的调整 (见图34)

(1) 动刀片与定刀片的关系:

如图所示, 动刀片①与机针中心的距离为7.5mm, 定刀片②与机针中心的距离为5mm。

(2) 刀片的调整:

开动电磁铁, 启动机器。这样, 剪线凸轮会使动刀片①右旋转。当动刀片①左移动到其最远位置时, 与定刀片②的间隙为1.5-2.0mm。

(3) 剪线电磁铁的调整:

A. 如果剪线情况不良, 尤其当线较粗时, 只需增加剪线压力即可。

B. 剪线压力可如下所述进行调整: 松开螺母B, 通过调节螺钉A来调节螺母B。

## 6、Adjusting the knives (Fig.34)

(1) The relation between fixed knife and movable knife.

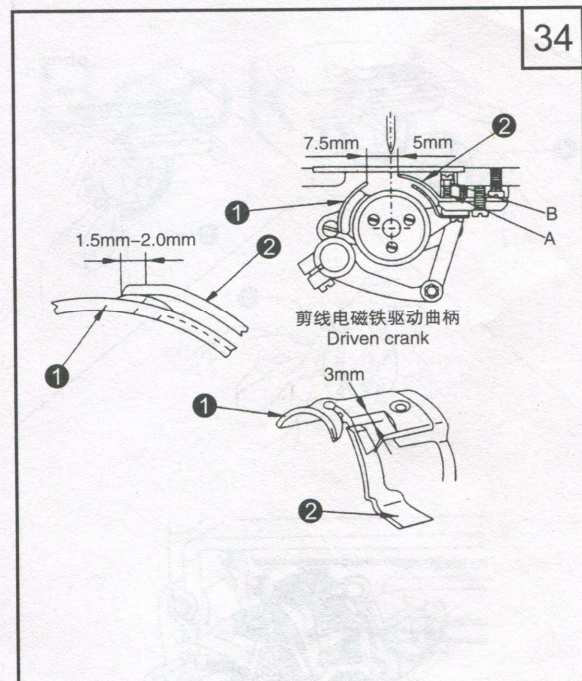
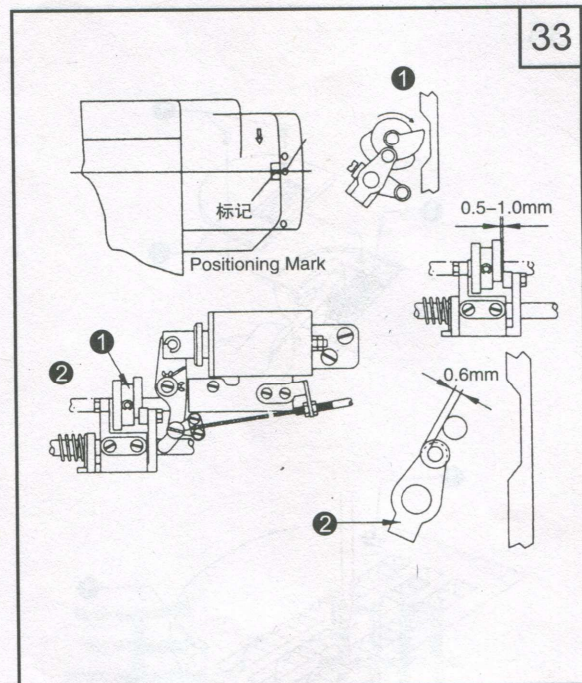
The clearance between movable knife ① and needle center is 7.5mm, and the clearance between fixed knife ② and needle center is 5mm.

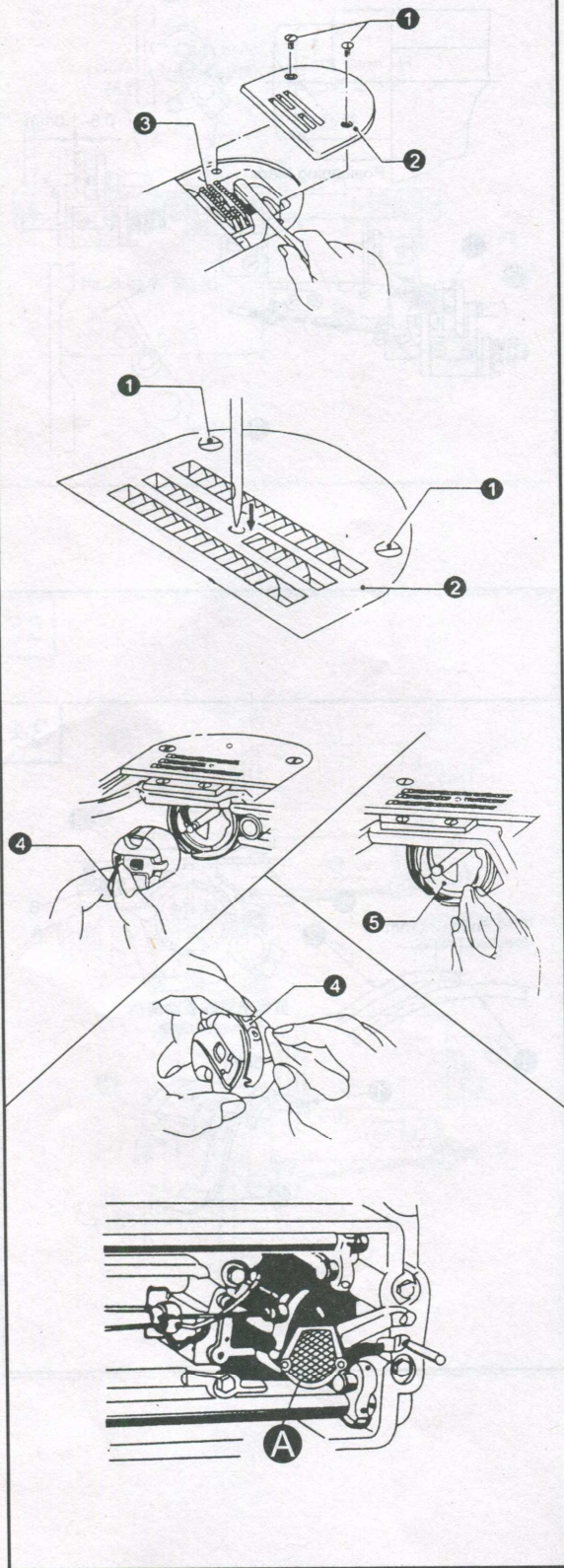
(2) Set the solenoid active, the movable knife ① will turn rightward driven by the trimming cam. When the movable knife ① moves to its left furthest position, the clearance between two knives ① and ② should be 1.5-2.0mm.

(3) Adjusting the trimming solenoid.

A. If the thread trimming not smoothly, especially the thick thread used, just need to increase the trimming pressure;

B. Adjusting the trimming pressure: loosen the nut B, adjust the screw A to get the reasonable pressure.





## 32、清扫 (图35)

- 1、抬起压脚。
- 2、拧开两螺钉①，然后卸下针板②。
- 3、使用软毛刷对送布牙进行清扫。
- 4、装上针板②及拧紧两螺钉①。
- 5、缓慢转动上轮，观察机针是否落入针板孔的中心位置。
  - \* 如果机针不时落入中心位置。
  - \* 检查机针是否弯曲。
  - \* 松开两螺钉①，然后重新安装针板②。
- 6、转动上轮将机针上升至针板以上，然后观察机针针尖是否钝挫，如果钝则更换机针。
- 7、放倒机头。
- 8、卸下梭芯套④。
- 9、用软布将旋梭中的灰尘擦除干净，并检查旋梭是否被损坏。
- 10、将梭芯从梭芯套中拿出，用布将梭芯套擦干净。
- 11、将梭芯放入梭芯套中，然后将梭芯套装入旋梭中。
- 12、清除油泵滤网(A)上的尘屑。

## 32、Clean (Fig.35)

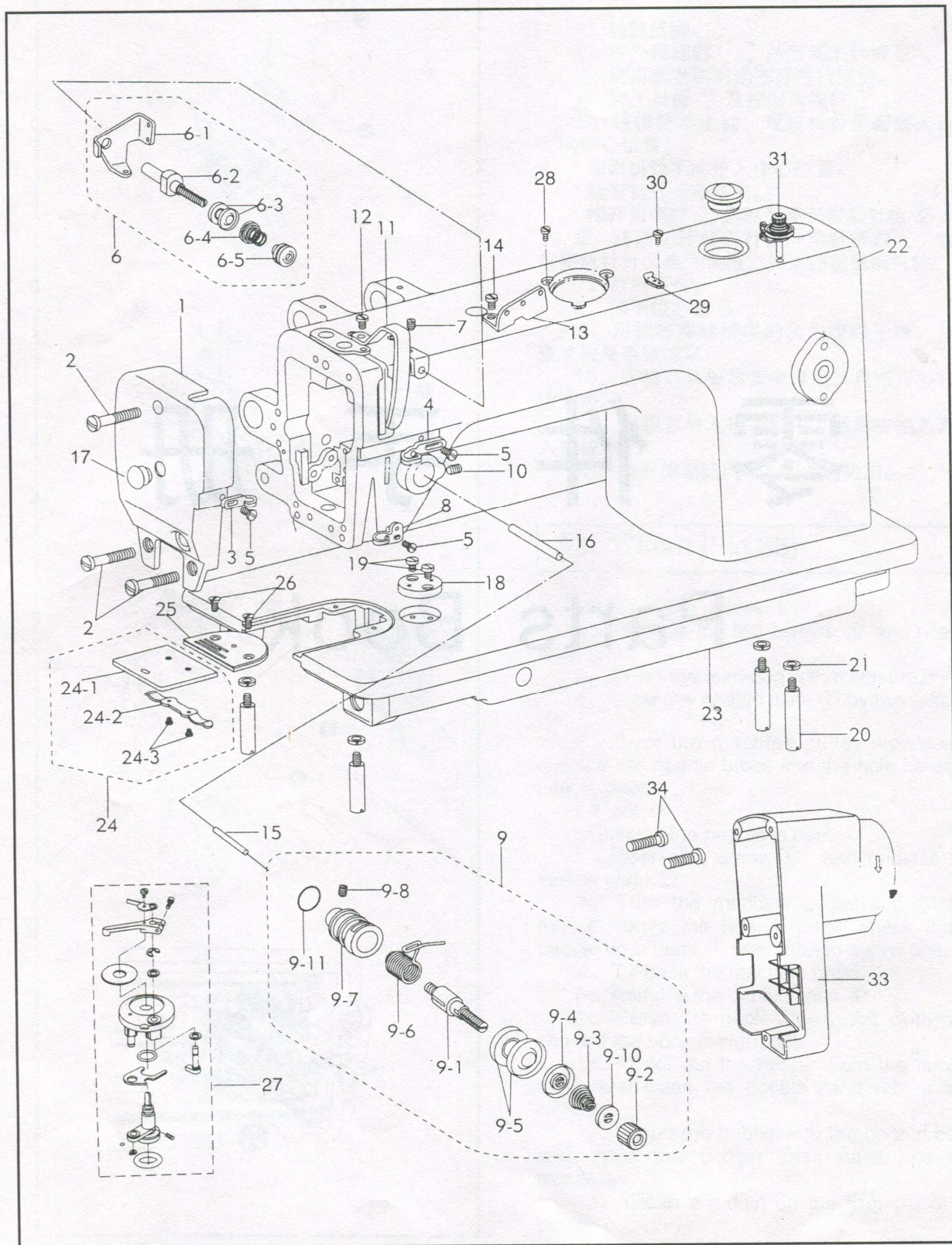
- 1、Raise the presser foot ;
- 2、Remove the two screws ① and needle plate ② ;
- 3、Clean the feed dog with a soft brush ;
- 4、Install the needle plate ② by two screws ① .
- 5、Turn the machine pulley slowly and check if the needle drops into the hole center if needle plate.
  - \* If not
  - \* Check if the needle is bent.
  - \* Loosen the xcrew ① , and reinstall the needle plate ② .
- 6、Turn the machine pulley and lift the needle above the needle plate, check if the needle tip is blunt, if yes, change a new one.
- 7、Tilt back the machine head.
- 8、Remove the bobbin case ④ .
- 9、Clean the hook with a soft cloth and check if the hook is worn out.
- 10、Take out the bobbin from the bobbin case, and clean the bobbin case with a soft cloth.
- 11、Insert the bobbin into the bobbin case and place the bobbin case back into the machine.
- 12、Clean the dust on the filter (A) of oil pump.

# 零件手册

Parts Book



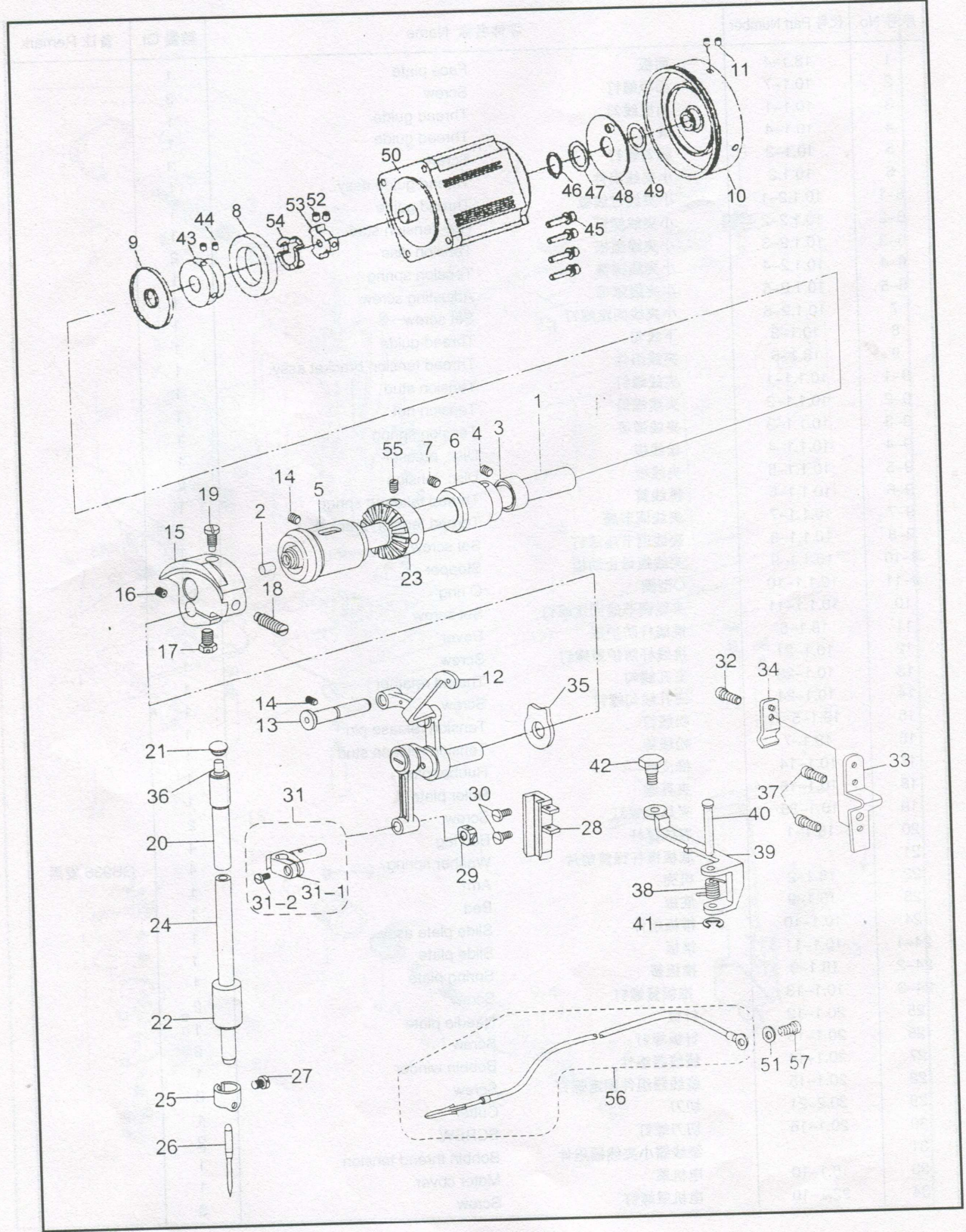
# 1、机壳部件 Casting mechanism



# 1、机壳部件 Casting mechanism

序号 No.	代号 Part Number	零件名称 Name	数量 Qt.	备注 Remark
1	18.1-4	面板 Face plate	1	
2	10.1-7	面板螺钉 Screw	3	
3	10.1-1	面板线勾 Thread guide	1	
4	10.1-4	线勾 Thread guide	1	
5	10.1-2	线勾螺钉 Screw	3	
6	10.1.2	小夹线组件 Thread guide assy.	1	
6-1	10.1.2-1	小夹线过线板 Thread guide	1	
6-2	10.1.2-2	小夹线螺钉 Pre-tension stud	1	
6-3	10.1.2-3	小夹线组板 Tension disc	2	
6-4	10.1.2-4	小夹线弹簧 Tension spring	1	
6-5	10.1.2-5	小夹线螺母 Adjusting screw	1	
7	10.1.2-6	小夹线固定螺钉 Set screw	1	
8	10.1-3	下线勾 Thread guide	1	
9	18.1-5	夹线组件 Thread tension bracket assy.	1	
9-1	10.1.1-1	夹线螺钉 Tension stud	1	
9-2	10.1.1-2	夹线螺母 Tension nut	1	
9-3	10.1.1-3	夹线弹簧 Tension spring	1	
9-4	10.1.1-4	松线板 Disc presser	1	
9-5	10.1.1-5	夹线板 Disc, tension	2	
9-6	10.1.1-6	挑线簧 Thread take-up spring	1	
9-7	10.1.1-7	夹线调节座 Thread tension bracket	1	
9-8	10.1.1-8	夹线调节座螺钉 Set screw	1	
9-10	10.1.1-9	夹线螺母止动板 Stopper	1	
9-11	10.1.1-10	O型圈 O ring	1	
10	10.1.1-11	夹线调节座固定螺钉 Set screw	1	
11	18.1-6	挑线杆防护罩 Cover	1	
12	10.1-21	挑线杆防护罩螺钉 Screw	1	
13	10.1-23	三孔线勾 Thread retainer	1	
14	10.1-24	三孔线勾螺钉 Screw	1	
15	18.1-5-1	松线钉 Tension release pin	1	
16	18.1-7	松线棒 Tension release stud	1	
17	10.1-14	橡皮塞 Rubber plug	1	
18	10.1-15	夹具座 Ruler plate	1	
19	10.1-35	夹具座螺钉 Screw	2	
20	18.1-1	底板撑杆 Bed leg	4	
21		底板撑杆弹簧垫片 Washer, spring	4	GB936 发黑
22	18.1-2	机壳 Arm	1	
23	10.1-9	底板 Bed	1	
24	10.1-10	推板组件 Slide plate assy.	1	
24-1	10.1-11	推板 Slide plate	1	
24-2	18.1-9	推板簧 Spring plate	1	
24-3	10.1-13	推板簧螺钉 Screw	2	
25	20.1-12	针板 Needle plate	1	
26	20.1-13	针板螺钉 Screw	2	
27	20.1-14	绕线器组件 Bobbin winder	1	
28	20.1-15	绕线器组件固定螺钉 Screw	3	
29	30.2-21	切刀 Cutter	1	
30	20.1-16	切刀螺钉 SCREW	2	
31		绕线器小夹线器组件 Bobbin thread tension	1	
33	18.1-10	电机罩 Motor cover	1	
34	22.1-10	电机罩螺钉 Screw	3	

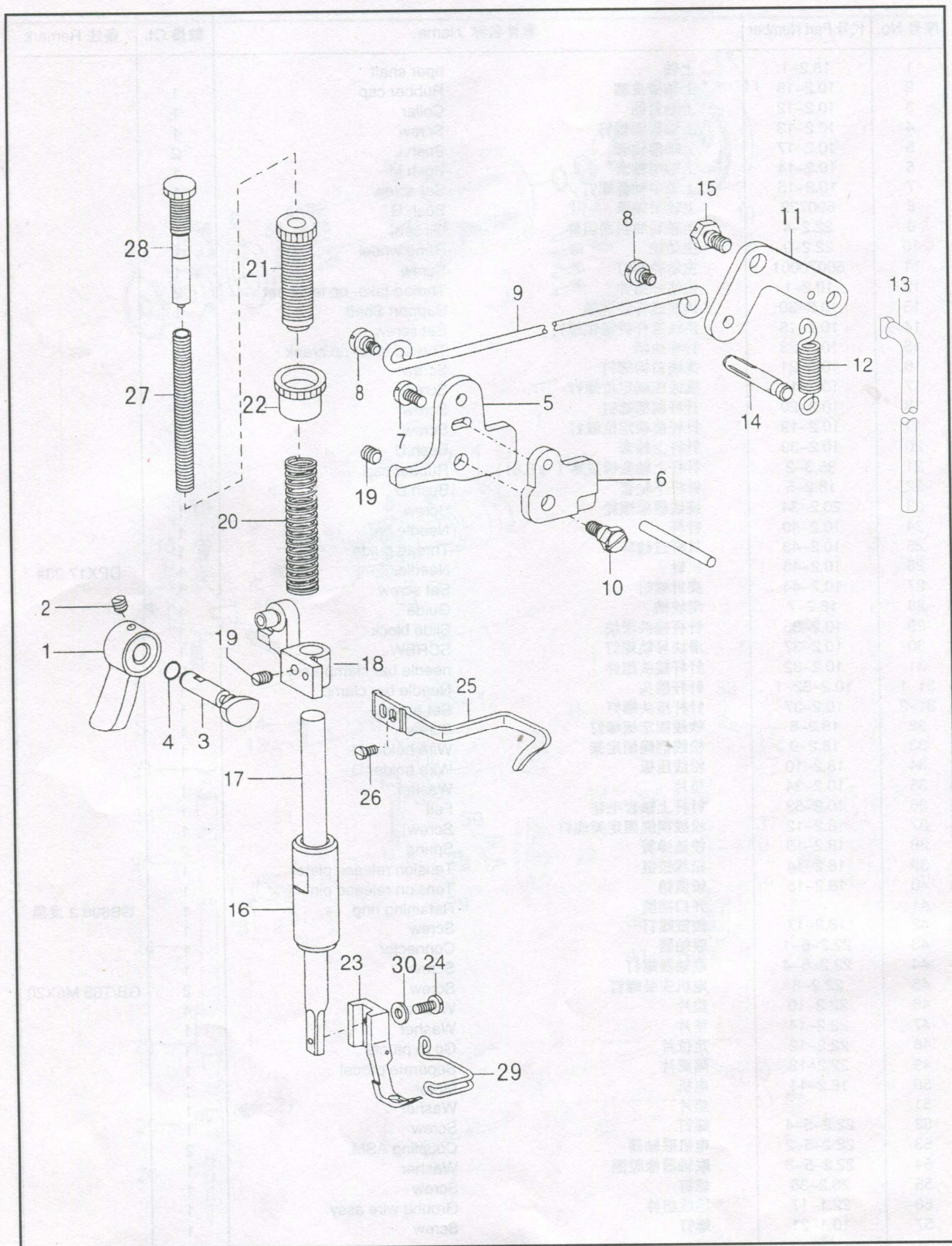
## 2、针杆、挑线部件 Needle bar and thread take-up mechanism



## 2、针杆、挑线部件 Needle bar and thread take-up mechanism

序号 No.	代号 Part Number	零件名称 Name	数量 Qt.	备注 Remark
1	18.2-1	上轴 pper shaft	-	
2	10.2-18	上轴橡皮塞 Rubber cap	1	
3	10.2-12	上轴紧圈 Collar	1	
4	10.2-13	上轴紧圈螺钉 Screw	1	
5	10.2-17	上轴前轴套 Bush.L	1	
6	10.2-14	上轴中轴套 Bush.M	2	
7	10.2-15	上轴中轴套螺钉 Set screw	1	
8	690722	上轴后轴承 Bush.R	1	
9	22.2-4	上轴后油封面组件 Oil seal	1	
10	22.2-9	主动轮 Hand wheel	1	
11	50070001	主动轮螺钉 Screw	1	
12	10.2-1	挑线杆组件 Thread take-up lever set	2	
13	10.2-30	挑线连杆铰链轴 Support Shaft	1	
14	10.2-15	挑线连杆铰链轴螺钉 Set screw	1	
15	10.2-23	针杆曲柄 Thread take-up crank	2	
16	10.2-21	挑线曲柄螺钉 Screw	1	
17	10.2-11	挑线曲柄定位螺钉 Screw	1	
18	10.2-20	针杆曲柄螺钉 Screw	1	
19	10.2-19	针杆曲柄定位螺钉 Screw	1	
20	10.2-39	针杆上轴套 Bush.U	1	
21	35.3-2	针杆上轴套橡皮塞 ( φ 8.8) Rubber cap	1	
22	18.2-5	针杆下轴套 Bush.D	1	
23	20.2-34	绕线器摩擦轮 Screw	1	
24	10.2-40	针杆 Needle bar	1	
25	10.2-43	针杆过线环 Thread guide	1	
26	10.2-45	机针 Needle	1	
27	10.2-44	夹针螺钉 Set screw	1	DPX17 23#
28	18.2-7	滑块槽 Guide	1	
29	10.2-35	针杆接头滑块 Slide block	1	
30	10.2-37	滑块导轨螺钉 SCREW	1	
31	10.2-32	针杆接头组件 needle bar clamp assy.	2	
31-1	10.2-32-1	针杆接头 Needle bar clamp	1	
31-2	10.2-37	针杆接头螺钉 Set ecrew	1	
32	18.2-8	软线固定板螺钉 Screw	1	
33	18.2-9	松线钢绳固定架 Wire holder.U	1	
34	18.2-10	松线压板 Wire holder.D	1	
35	10.2-34	垫片 Washer	1	
36	10.2-52	针杆上轴套毛毡 Felt	1	
37	18.2-12	松线钢绳固定架螺钉 Screw	1	
38	18.2-13	铰链弹簧 Spring	2	
39	18.2-14	松线铰链 Tension release plate	1	
40	18.2-15	铰链销 Tension release pin	1	
41		开口挡圈 Retaining ring	1	
42	18.2-17	铰链螺钉 Screw	1	GB896 2 发黑
43	22.2-5-1	联轴器 Connector	1	
44	22.2-5-4	联轴器螺钉 Screw	1	
45	22.2-8	电机安装螺钉 Screw	1	
46	22.2-10	垫片 Washer	2	GB/T65 M5X20
47	22.2-14	垫片 Washer	4	
48	22.2-12	定位片 Go to parcel	1	
49	22.2-13	隔离片 Separate parcel	1	
50	18.2-11	电机 Motor	1	
51		垫片 Washer	1	
52	22.2-5-4	螺钉 Screw	1	
53	22.2-5-2	电机联轴器 Coupling ASM.	1	
54	22.2-5-3	联轴器橡胶圈 Washer	2	
55	20.2-35	螺钉 Screw	1	
56	22.1-17	地线组件 Ground wire assy.	1	
57	10.1-21	螺钉 Screw	1	

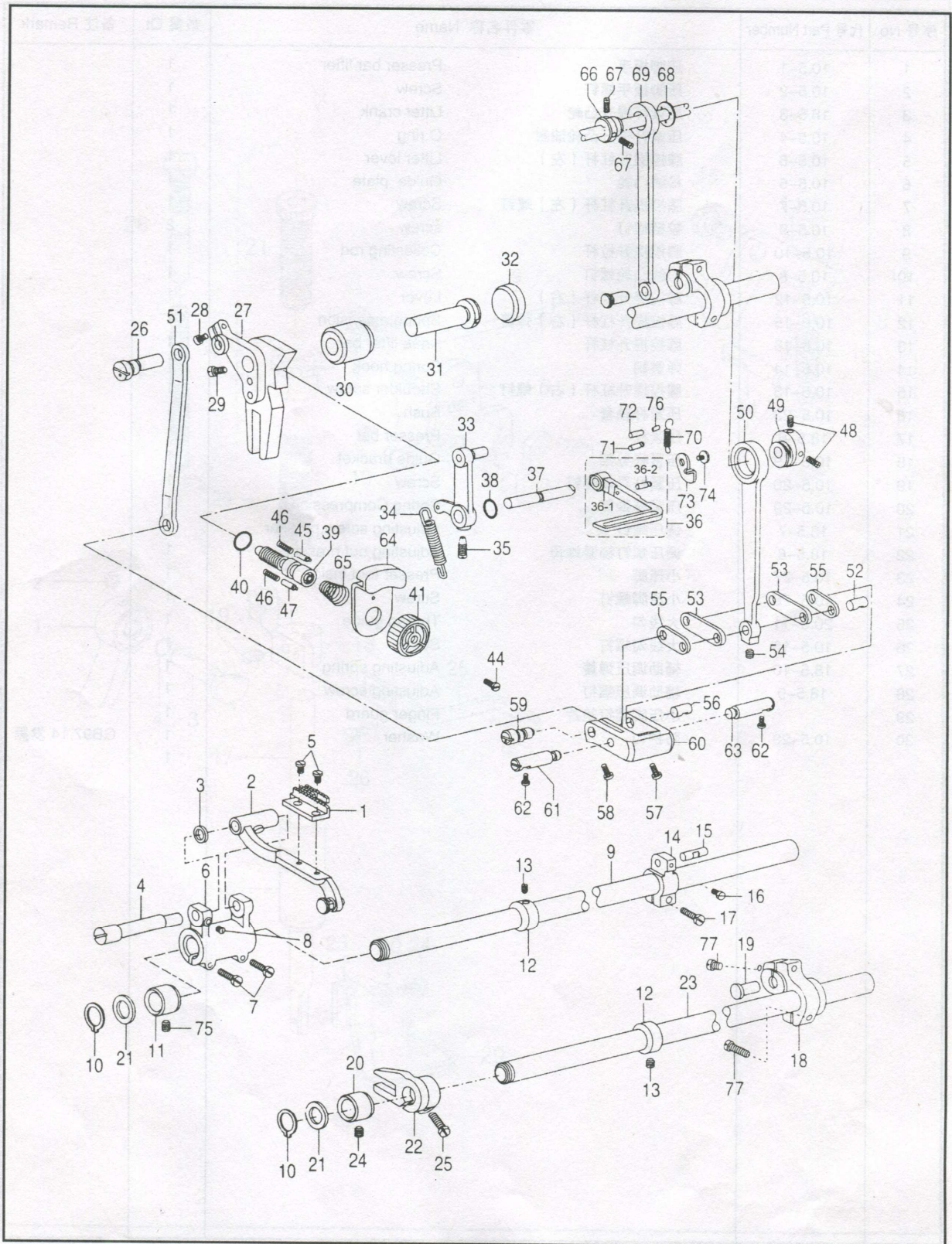
### 3、压脚部件 Presser foot mechanism



### 3、压脚部件 Presser foot mechanism

序号 No.	代号 Part Number	零件名称 Name	数量 Qt.	备注 Remark
1	10.5-1	压脚扳手 Presser bar lifter	1	
2	10.5-2	压脚扳手螺钉 Screw	1	
3	18.5-3	压紧杆提升凸轮 Lifter crank	1	
4	10.5-4	压紧杆提升凸轮油封 O ring	1	
5	10.5-6	膝控提升杠杆 (左) Lifter lever	1	
6	10.5-5	松线凸轮 Guide plate	1	
7	10.5-7	膝控提升杠杆 (左) 螺钉 Screw	1	
8	10.5-9	铰链螺钉 screw	1	
9	10.5-10	膝控提升拉杆 Collecting rod	2	
10	10.5-8	松线凸轮螺钉 Screw	1	
11	10.5-12	膝控提升杠杆 (右) Lever	1	
12	10.5-15	膝控提升杠杆 (右) 弹簧 Spring,extension	1	
13	10.5-16	膝控提升杠杆 Knee lifter bar	1	
14	10.5-14	弹簧销 Spring hook	1	
15	10.5-13	膝控提升杠杆 (右) 螺钉 Shoulder screw	1	
16	10.5-23	压紧杆轴套 Bush	1	
17	18.5-6	压紧杆 Presser bar	1	
18	10.5-19	压紧杆导架 Guide bracket	1	
19	10.5-20	压紧杆导架螺钉 Screw	1	
20	10.5-29	压紧杆弹簧 Spring,Compression	1	
21	18.5-7	调压螺钉 Adjusting screw,presser	1	
22	18.5-8	调压螺钉锁紧螺母 Adjusting nut,presser	1	
23	10.5-27	小压脚 Presser foot,inside	1	
24	10.5-26	小压脚螺钉 Screw	1	
25	20.5-11	大线勾 Thread guide	1	
26	10.5-18	大线勾螺钉 Screw	1	
27	18.5-10	辅助调压弹簧 Adjusting spring	1	
28	18.5-9	辅助调压螺钉 Adjusting screw	1	
29		小压脚螺钉垫片 Finger guard	1	
30	10.5-28	防护勾 Washer	1	
			1	GB97.14 发黑

# 4、送料部件 Feed mechanism

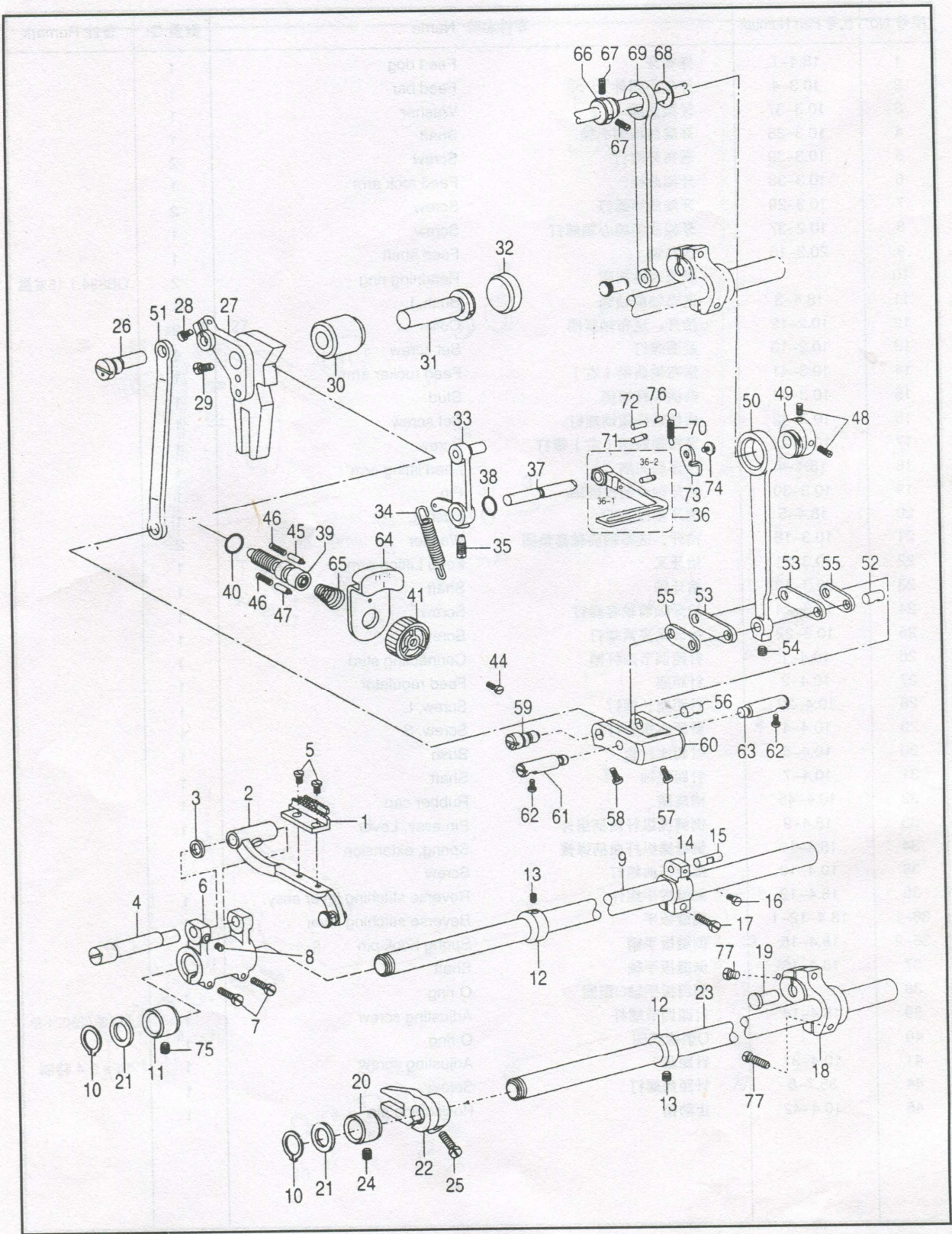


#### 4、送料部件 Feed mechanism

序号 No.	代号 Part Number	零件名称 Name	数量 Qt.	备注 Remark
1	18.4-1	送布牙	1	
2	10.3-4	牙架小组件	1	
3	10.3-37	牙架垫圈	1	
4	10.3-35	牙架曲柄偏心轴	1	
5	10.3-39	送布牙螺钉	2	
6	10.3-33	牙架曲柄	1	
7	10.3-29	牙架曲柄螺钉	2	
8	10.2-37	牙架曲柄偏心轴螺钉	1	
9	20.3-16	送布轴	1	
10		轴用弹性挡圈	2	GB894.1 15发黑
11	18.4-3	送布轴前轴套	1	
12	10.2-12	拾牙、送布轴紧圈	2	
13	10.2-13	紧圈螺钉	4	
14	10.3-41	送布轴曲柄(右)	1	
15	10.3-44	曲柄连杆短销	1	
16	10.3-42	曲柄连杆短销螺钉	1	
17	10.3-22	送布轴曲柄(右)螺钉	1	
18	18.4-4	拾牙后曲柄	1	
19	10.3-30	拾牙轴曲柄铰链轴	1	
20	18.4-5	拾牙轴前轴套	1	
21	10.3-18	拾牙、送布轴前轴套垫圈	2	
22	10.3-21	拾牙叉	1	
23	20.3-13	拾牙轴	1	
24	10.3-24	拾牙轴前轴套螺钉	1	
25	10.3-22	拾牙叉夹紧螺钉	1	
26	10.4-1	针距调节连杆销	1	
27	10.4-2	针距座	1	
28	10.4-22	针距座长螺钉	1	
29	10.4-4	针距座短螺钉	1	
30	10.4-5	针距座衬套	1	
31	10.4-7	针距座轴	1	
32	10.4-45	橡皮塞	1	
33	18.4-9	倒缝操纵杆曲柄组件	1	
34	18.4-10	倒缝操纵杆曲柄弹簧	1	
35	10.4-13	操纵杆曲螺钉	1	
36	18.4-12	倒缝扳手组件	1	
36-1	18.4-12-1	倒缝扳手	1	
36-2	18.4-15	倒缝扳手销	1	
37	18.4-13	倒缝扳手轴	1	
38		倒缝扳手轴O型圈	1	
39	18.4-14	针距调节螺杆	1	6.3 X 1.8G GB3452.1-92
40		O型橡胶圈	1	
41	10.4-37	针距盘	1	
44	35.7-5	针距盘螺钉	1	14 x 2.4 特制
45	10.4-42	止动销	1	



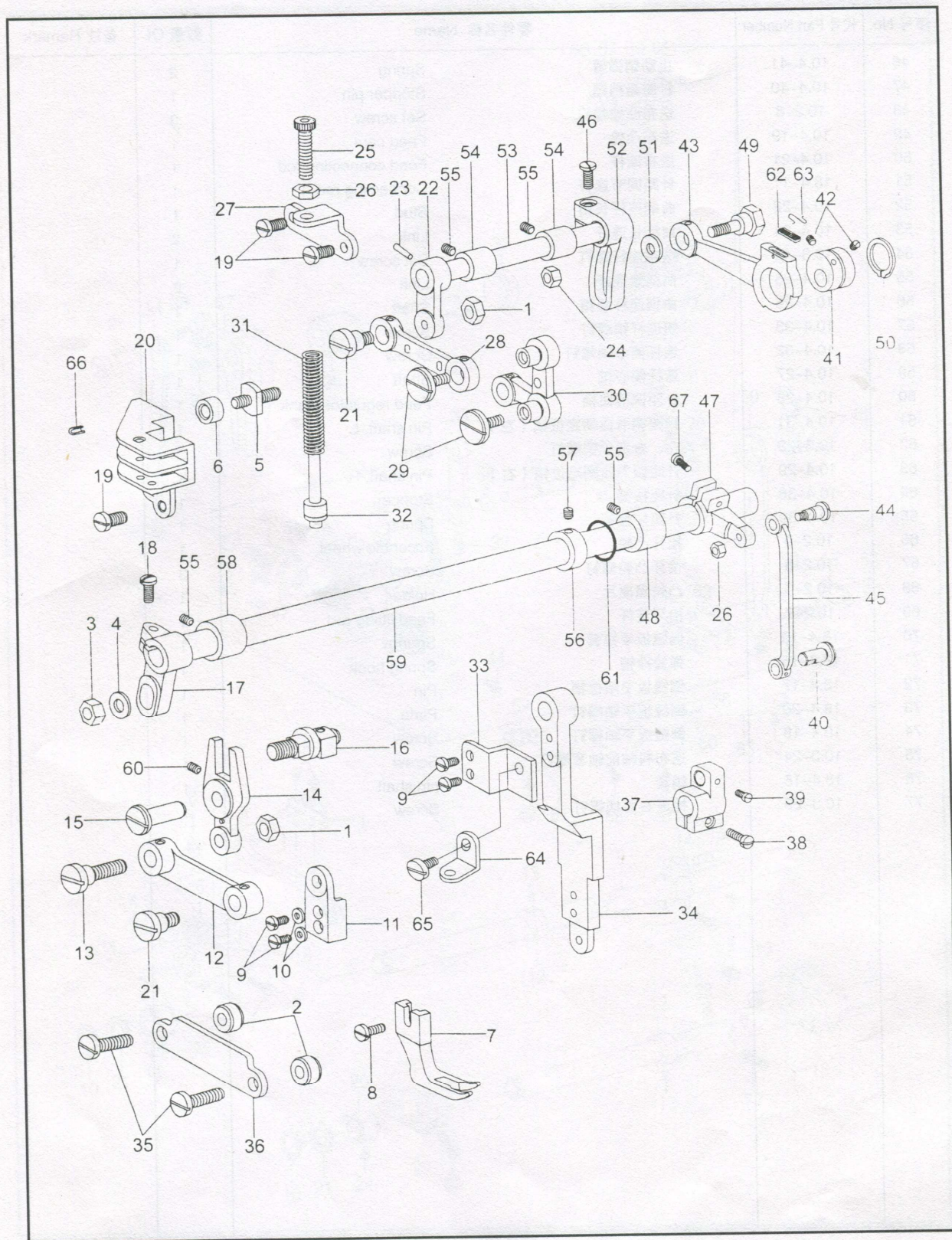
# 4、送料部件 Feed mechanism



#### 4、送料部件 Feed mechanism

序号 No.	代号 Part Number	零件名称 Name	数量 Qt.	备注 Remark	
46	10.4-41	止动销弹簧	Spring	2	
47	10.4-40	针距盘挡销	Stopper pin	1	
48	10.2-8	送布凸轮螺钉	Set screw	3	
49	10.4-19	送布凸轮	Feed cam	1	
50	10.4-21	送布连杆	Feed connecting rod	1	
51	18.4-11	针距调节连杆	Connecting rod	1	
52	10.4-22	曲柄连杆长销	Stud	1	
53	10.4-24	曲柄长连杆	Link	2	
54	10.3-42	送布连杆螺钉	Set screw	1	
55	10.4-25	曲柄短连杆	Link	2	
56	10.4-26	曲柄连杆短销	Shaft	1	
57	10.4-33	短连杆销螺钉	Screw	1	
58	10.4-32	连杆偏心轴螺钉	Screw	1	
59	10.4-27	连杆偏心轴	Shaft	1	
60	10.4-28	针距调节曲柄	Feed regulator crank	1	
61	10.4-31	针距调节曲柄定位销 (左)	Pin shaft. L	1	
62	10.3-22	左、右定位销螺钉	Screw	2	
63	10.4-29	针距调节曲柄定位销 (右)	Pin shaft. R	1	
64	10.4-38	针距按键	Stopper	1	
65	10.4-39	针距按键簧	Spring	1	
66	10.2-9	抬牙凸轮	Eccentric wheel	1	
67	10.2-8	抬牙凸轮螺钉	Screw	3	
68	10.2-6	凸轮隔离片	Holder	1	
69	10.2-7	抬牙连杆	Feed lifting rod	1	
70	18.4-19	倒缝扳手拉簧	Spring	1	
71	18.4-16	弹簧挂销	Spring hook	1	
72	18.4-17	倒缝扳手限位销	Pin	1	
73	18.4-20	倒缝扳手轴螺钉	Plate	1	
74	10.4-18	倒缝扳手轴螺钉	Screw	1	
75	10.3-24	送布料轴前轴套螺钉	Screw	1	
76	18.4-18	销套	pin shaft	1	
77	10.3-29	抬牙右曲柄螺钉	Screw	1	

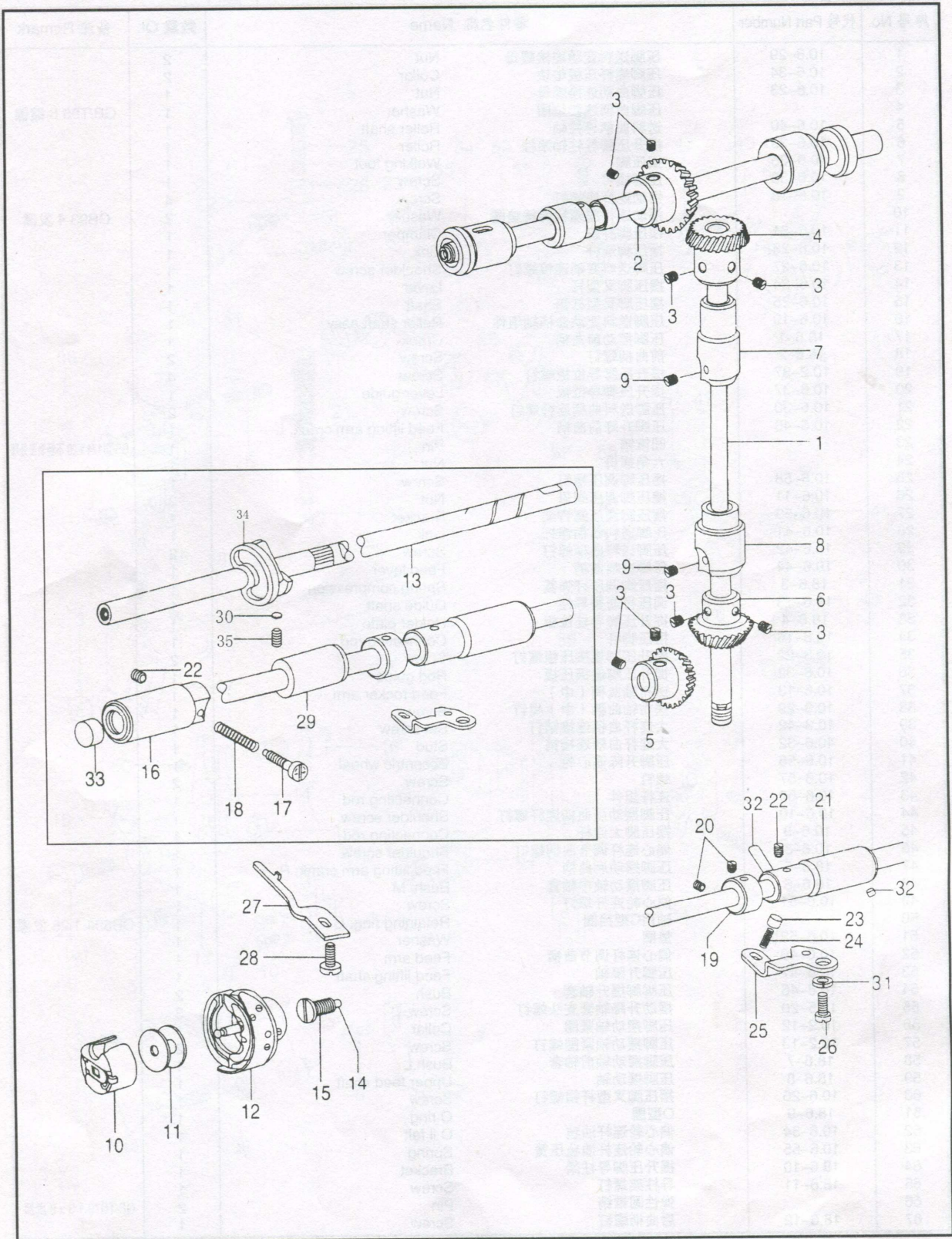
# 5、上送料部件 Upper feed mechanism



## 5、上送料部件 Upper feed mechanism

序号 No.	代号 Part Number	零件名称 Name	数量 Qt.	备注 Remark
1	10.6-29	压脚送料变动连接螺母	Nut	2
2	10.6-34	压脚连杆压板垫块	Collar	2
3	10.6-23	压脚曲柄连接螺母	Nut	1
4		压脚曲柄连接垫圈	Washer	1
5	10.6-40	送料曲柄导柱轴	Roller shaft	1
6	10.6-39	提升压脚导柱轴滚柱	Roller	1
7	10.6-35	摆压脚	Walking foot	1
8	10.6-36	压脚螺钉	Screw	1
9	10.6-18	摆动连杆座螺钉	Screw	4
10		摆动连杆座螺钉弹簧垫圈	Washer	2
11	10.6-31	摆压脚杆座	Clamper	1
12	10.6-28	摆压脚连杆	Link	1
13	10.6-27	压脚送料变动连接螺钉	Shoulder screw	1
14	10.6-24	摆压脚叉型杆	Lever	1
15	10.6-25	摆压脚叉型杆销	Shaft	1
16	10.6-19	压脚送料变动曲柄轴组件	Roller shaft assy	1
17	18.6-1	压脚摆动前曲柄	Crank	1
18	18.6-2	前曲柄螺钉	Screw	2
19	10.2-37	提升压脚导位板螺钉	Screw	4
20	10.6-37	提升压脚导位板	Lever guide	1
21	10.6-30	压脚送料曲柄连杆螺钉	Screw	2
22	10.6-45	压脚升降前曲柄	Feed lifting arm crank, L	1
23		圆锥销	Pin	1
24		六角螺母	Nut	1
25	10.6-58	摆压脚调压螺钉	Screw	1
26	10.6-11	摆压脚调压螺母	Nut	2
27	10.6-59	摆压脚调压螺钉架	Bracket	1
28	10.6-41	压脚送料曲柄连杆	Link	1
29	10.6-42	压脚送料曲柄螺钉	Screw	2
30	10.6-44	压脚送料曲柄	Feed lever	1
31	18.6-3	摆压脚调压杆弹簧	Spring.compression	1
32	18.6-13	调压杆弱簧导柱	Guide shaft	1
33	18.6-4	提升压脚导柱位板	Holder plate	1
34	10.6-16	摆压脚杆	Connecting rod	1
35	10.3-22	提升压脚连接压板螺钉	Screw	2
36	10.6-32	提升压脚连接压板	Rod guide	1
37	10.6-13	送布轴曲柄(中)	Feed rocker arm	1
38	10.3-29	送布轴曲柄(中)螺钉	Screw	1
39	10.3-42	大连杆曲柄连接销钉	Set screw	1
40	40.6-32	大连杆曲柄连接销	Stud	1
41	10.6-56	压脚升降偏心轮	Eccentric wheel	1
42	10.6-57	螺钉	Screw	2
43	10.6-50	连杆组件	Connecting rod	1
44	10.6-10	压脚摆动后曲柄连杆螺钉	Shoulder screw	1
45	10.6-9	摆压脚大连杆	Connecting rod	1
46	10.6-8	偏心连杆调节曲柄螺钉	Shoulder screw	1
47	18.6-5	压脚摆动后曲柄	Feed lifting arm crank, R	1
48	18.6-6	压脚摆动轴中轴套	Bush, M	1
49	10.6-51	偏心轮连杆螺钉	Screw	1
50		轴用C型挡圈	Retaining ring. C	1
51	10.6-52	垫圈	Washer	1
52	10.6-49	偏心连杆调节曲柄	Feed arm	1
53	10.6-47	压脚升降轴	Feed lifting shaft	1
54	10.6-46	压脚脚提升轴套	Bush	2
55	10.5-20	摆动升降轴套支头螺钉	Screw	3
56	10.2-12	压脚摆动轴紧圈	Collar	1
57	10.2-13	压脚摆动轴紧圈螺钉	Screw	2
58	18.6-7	压脚摆动轴前轴套	Bush.L	1
59	18.6-8	压脚摆动轴	Upper feed shaft	1
60	10.6-26	摆压脚叉型杆销螺钉	Screw	1
61	18.6-9	O型圈	O ring	1
62	10.6-54	偏心轮连杆油毡	O il felt	1
63	10.6-55	偏心轮连杆油毡压簧	Spring	1
64	18.6-10	提升压脚导柱架	Bracket	1
65	18.6-11	导柱架螺钉	Screw	1
66		弹性圆锥销	Pin	1
67	18.6-12	后曲柄螺钉	Screw	2

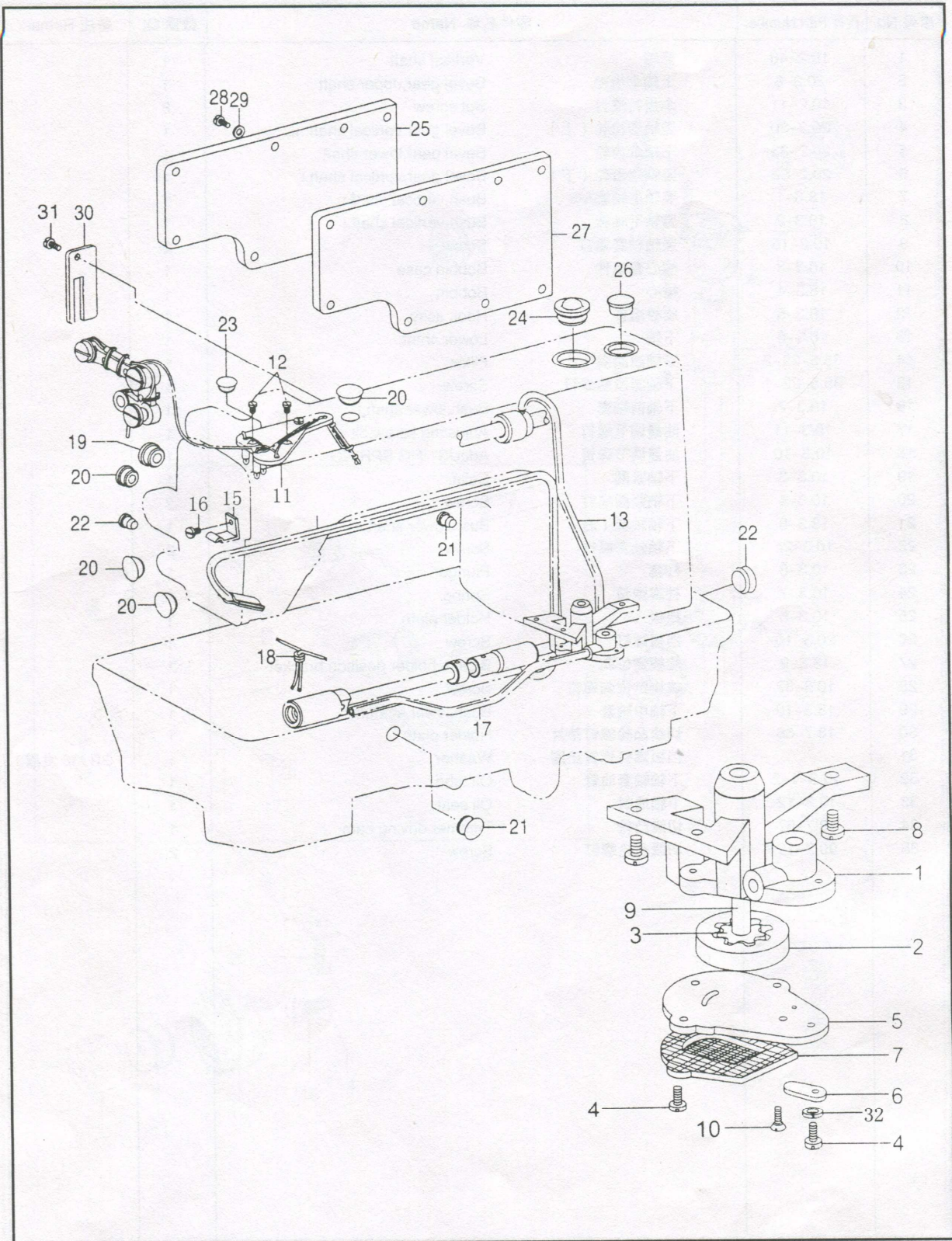
# 6、旋梭部件 Hook mechanism



## 6、旋梭部件 Hook mechanism

序号 No.	代号 Part Number	零件名称 Name	数量 Qt.	备注 Remark
1	10.2-48	竖轴 Vertical shaft	1	
2	20.2-8	上轴伞齿轮 Bevel gear,upper shaft	1	
3	10.2-11	伞齿轮螺钉 Set screw	8	
4	20.2-30	竖轴伞齿轮(上) Bevel gear,vertical shatf..u	1	
5	20.2-33	下轴伞齿轮 Bevel gear,lower shaft	1	
6	20.2-32	竖轴伞齿轮(下) Bevel gear,vertical shaft.l	1	
7	18.3-1	竖轴上轴套 Bush,vertical shatf,u	1	
8	18.3-2	竖轴下轴套 Bush,vertical shatf,l	1	
9	10.2-15	竖轴轴套螺钉 Screw	2	
10	18.3-3	梭心套组件 Bobbin case	1	
11	18.3-4	梭心 Bobbin	1	
12	18.3-5	旋梭组件 Hook assy.	1	
13	18.3-6	下轴 Lower shaft	1	
14	35.5-22-2	下轴滤油塞 Filter	1	
15	35.5-22-1	下轴滤没塞螺钉 Screw	1	
16	18.3-7	下轴前轴套 Bush,lower shaft,l	1	
17	10.3-11	油量调节螺钉 Adjusting screw,oil	1	
18	10.3-10	油量调节弹簧 AdJUSTING SPRING	1	
19	10.3-3	下轴紧圈 Collar	1	
20	10.3-4	下轴紧圈螺钉 Screw	2	
21	18.3-8	下轴轴套(右) Bush,lower shaft,r	1	
22	10.3-24	下轴轴套螺钉 Screw	2	
23	10.3-8	柱塞 Plunger	1	
24	10.3-7	柱塞弹簧 Spring	1	
25	10.3-6	挡板 Holder plate	1	
26	20.3-10	挡板螺钉 Screw	1	
27	18.3-9	旋梭定位勾 B/case holder position bracket	1	
28	10.3-32	旋梭定位勾螺钉 Screw	1	
29	18.3-10	下轴中轴套 Bush,lower shatf,m	1	
30	18.7-66	切线凸轮螺钉垫片 Holder plate	1	
31		挡板螺钉弹簧垫圈 Washer	1	GB936 发黑
32	10.3-1-2	下轴轴套油管 Oil tube	1	
33	18.3-12	下轴油封 Oil seal	1	
34	18.7-67	切线凸轮 Trimmer driving cam	1	
35	90.2-16	切线凸轮螺钉 Screw	2	

# 7、供油润滑部件 Lubrication mechanism

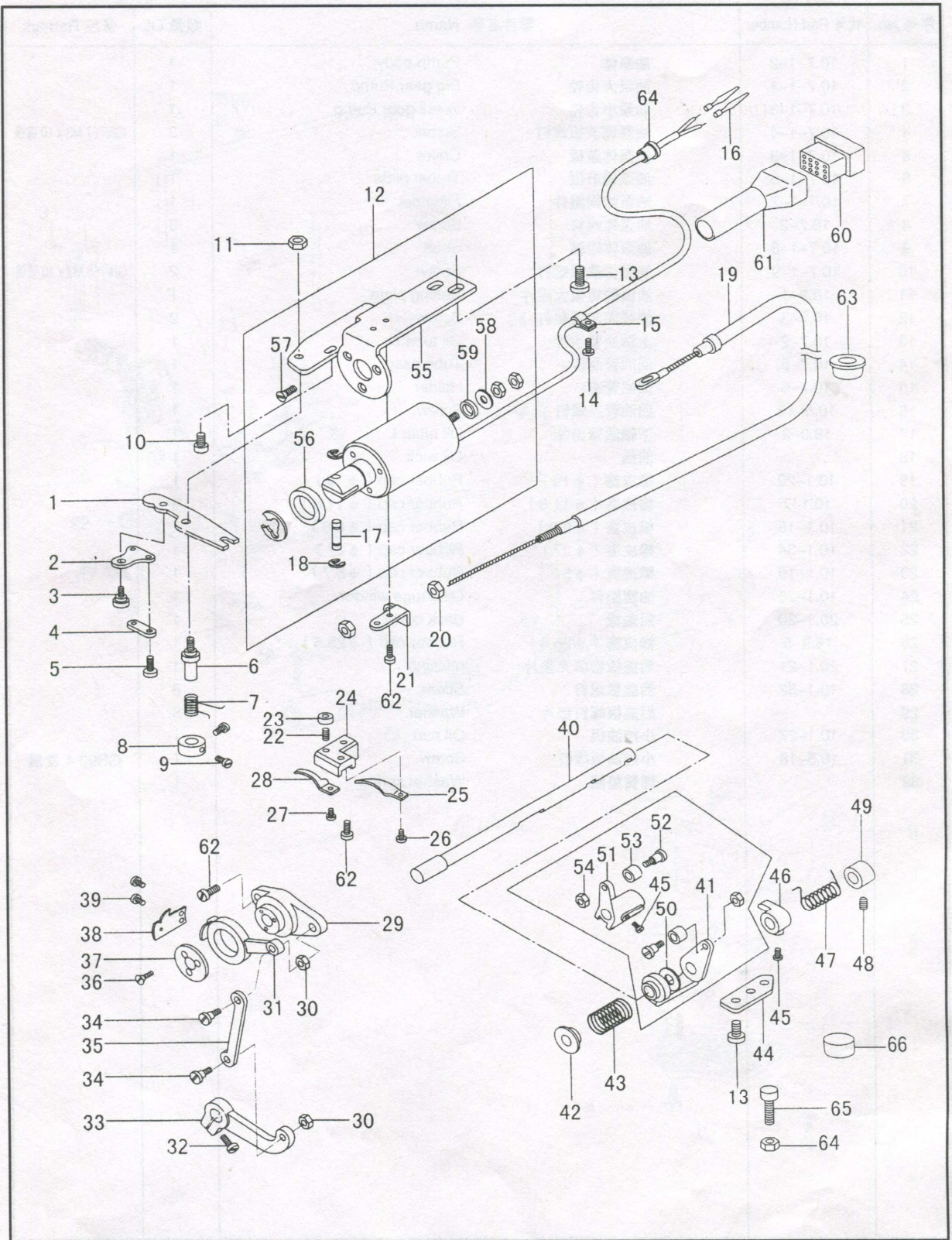


## 7、供油润滑部件 Lubrication mechanism

序号 No.	代号 Part Number	零件名称 Name	数量 Qt.	备注 Remark
1	10.7-1-2	油泵体 Pump body	1	
2	10.7-1-1	油泵大齿轮 Big gear.Pump	1	
3	10.7-1-3	油泵小齿轮 Small gear.Pump	1	
4	10.7-1-4	油泵调节板螺钉 Screw	3	GB/T67 M3 x 10 镀锌
5	10.7-1-5	油泵体盖板 Cover	1	
6	10.7-1-6	油泵调节板 Throat plate	1	
7	10.7-1-7	油泵滤网组件 Filter set	1	
8	10.7-2	油泵体螺钉 Screw	3	
9	10.7-1-8	油泵体短轴 Shaft	1	
10	10.7-1-9	油泵体盖板螺钉 Screw	2	GB/T68 M3 x 10 镀锌
11	18.9-1	油线固定板大组件 Setting plate	1	
12	10.7-3	油线固定板螺钉 Screw	2	
13	10.7-2	上轴油管组件 Oil tube.U	1	
14	10.7-6	回油管组件 Tube assy.	1	
15	10.7-5	回油管夹 Holder	1	
16	10.5-18	回油管夹螺钉 Screw	1	
17	18.9-2	下轴油管组件 Oil tube, L	1	
18		油线 Oil wick	1	
19	10.1-22	橡皮塞 ( φ 19 ) Rubber cap ( φ 19 )	1	
20	10.1-7	橡皮塞 ( φ 11.8 ) Rubber cap ( φ 11.8 )	4	
21	10.1-18	橡皮塞 ( φ 8.8 ) Rubber cap ( φ 8.8 )	2	
22	10.1-34	橡皮塞 ( φ 27 ) Rubber cap ( φ 27 )	1	
23	10.1-19	橡皮塞 ( φ 5.7 ) Rubber cap ( φ 5.7 )	1	
24	10.1-25	油塞组件 Oil gauge window	1	
25	20.1-20	后盖板 Back cover	1	
26	18.9-5	橡皮塞 ( φ 25.5 ) Rubber cap ( φ 25.5 )	1	
27	20.1-21	后盖板密填充垫片 packing	1	
28	10.1-32	后盖板螺钉 Screw	8	
29		后盖板螺钉垫片 Washer	8	
30	10.1-27	小挡油板 Oil pan	1	
31	10.5-18	小挡油板螺钉 Screw	1	GB93 4 发黑
32		弹簧垫圈 Washer,spring	1	



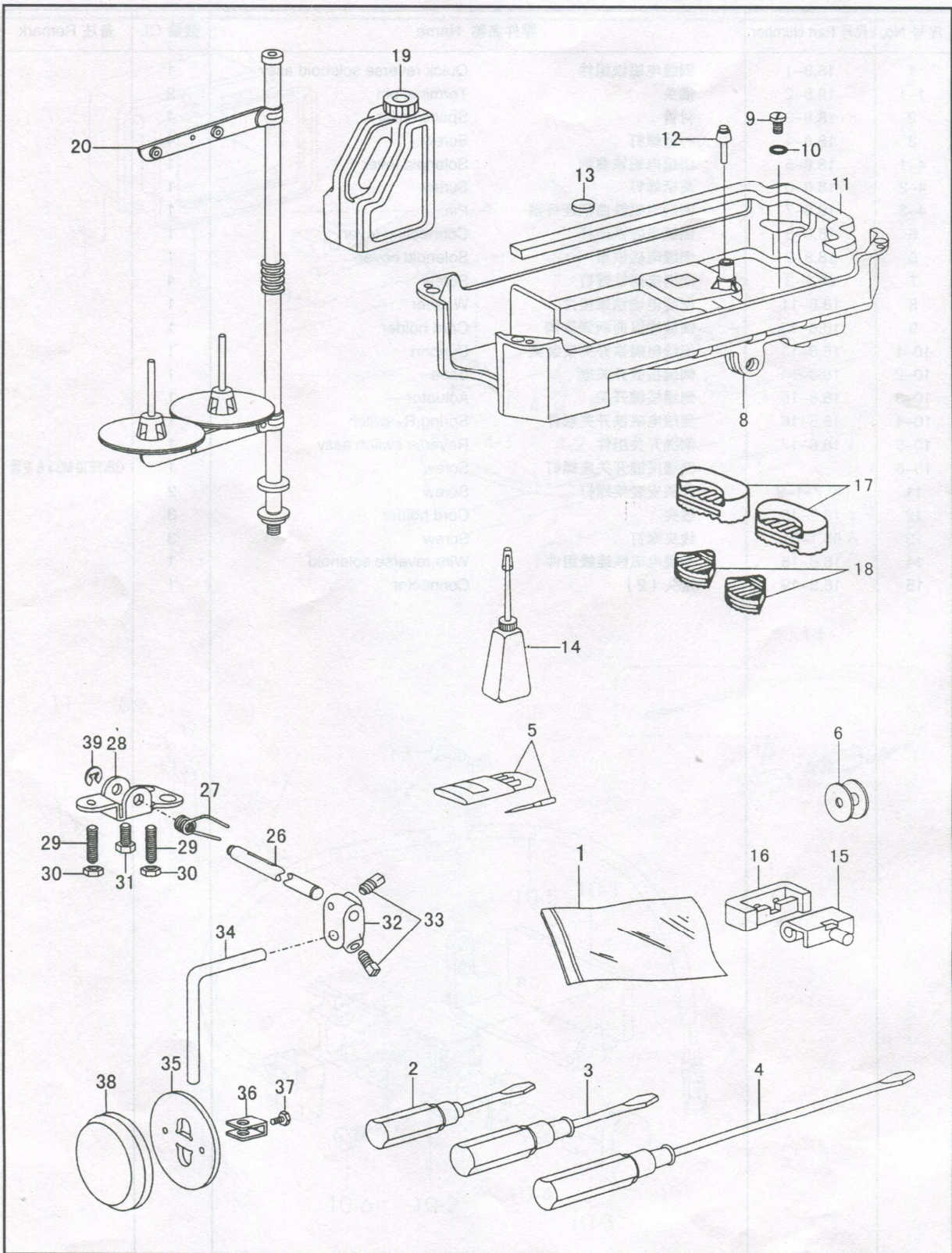
# 8、剪线部件 Thread trimming mechanism



## 8、剪线部件 Thread trimming mechanism

序号 No.	代号 Part Number	零件名称 Name	数量 Qt.	备注 Remark
1	18.7-1	驱动板	Driven plate	1
2	18.7-2	软线支撑板	Wire support	1
3	18.7-3	软线支撑板螺钉	Screw	1
4	18.7-4	软线连板	Link	1
5	18.7-5	软线连板螺钉	Screw	1
6	18.7-6	驱动板轴	Screw pin, driven plate	1
7	18.7-7	驱动板弹簧	Spring	1
8	18.7-8	驱动板轴紧圈	Collar	1
9	10.4-32	驱动板轴紧圈螺钉	Screw	2
10	10.3-32	安装架连接螺钉	Screw	1
11	40.5-36	驱动轴螺母	Nut	1
12	18.7-12	剪线电磁铁转动组件	Thread trimmer solenoid assy.	1
13	43.1-17	安装架固定螺钉	Screw	4
14	90.10-11	线夹螺钉	Screw	1
15	18.7-15	线夹	Wire holder	1
16	18.7-16	插头接头	Terminal pin	2
17	18.7-17	剪线电磁铁销	Pin	1
18	60080029	挡圈	Retaining ring	2
19	18.7-19	松线钢绳组件	Tension release wire	1
20	22.4-11	软线螺母	Nut	2
21	18.7-21	软线座	Tension release lever	1
22	18.7-22	定刀座螺钉	Screw	1
23	18.7-23	定刀座螺母	Nut	1
24	18.7-24	定刀座	Holder, F-knife	1
25	18.7-25	栏线板	Lower thread finger	1
26	90.1-31	栏线板螺钉	Screw	1
27	22.8-22	定刀片螺钉	Screw	1
28	18.7-28	定刀片	Fixed knife	1
29	18.7-29	刀架	Holder, M-knife	1
30	18.7-30	刀轴连杆螺母	Nut	2
31	18.7-31	刀架(左)	Holder, M-knife, L	1
32	18.7-32	驱动曲柄螺钉	Screw	1
33	18.7-33	剪线电磁铁驱动曲柄	Driven crank	1
34	18.7-34	刀架连杆螺钉	Screw	2
35	18.7-35	刀架连杆	Link	1
36	18.7-36	刀架螺钉	Screw	3
37	18.7-37	刀架垫圈	Washer	1
38	18.7-38	动刀片	Movable knife	1
39	22.8-29	动刀片紧固螺钉	Screw	2
40	18.7-40	凸轮曲柄轴	Thread trimmer cam lever shaft	1
41	18.7-41	切线凸轮右曲柄	Thread trimmer cam lever R	1
42	18.7-42	扭簧端盖	Collar	1
43	18.7-43	扭簧	Spring	1
44	18.7-44	止动板	Stopper plate	1
45	90.5-42	限位块螺钉	Screw	3
46	18.7-46	限位块	Positioning block	1
47	18.7-47	凸轮轴扭簧	Spring	1
48	90.2-5	紧圈螺钉	Screw	2
49	18.7-49	凸轮轴紧圈	Collar	1
50	18.7-50	塑料圈	Plastic ring	1
51	18.7-51	切线凸轮左曲柄	Thread trimmer cam lever, L	1
52	18.7-52	滚轮螺钉	Screw	2
53	18.7-53	滚轮	Roller	2
54	18.7-54	滚轮螺母	Nut	2
55	18.7-55	剪线电磁铁安装架	Thread trimmer solenoid base	1
56	18.7-59	密封垫圈(大)	Seal washer, big	1
57	50030001	剪线电磁铁紧固螺钉	Screw	3
58	18.7-58	平垫片	Washer	1
59	18.7-56	密封垫圈(小)	Seal washer, small	1
60	18.7-60	插头套	Connector	1
61	18.7-61	线罩	Cover	1
62	18.7-32	螺钉	Screw	4
63	18.7-63	剪线电磁铁电线保护套	Guard	1
64	18.7-64	螺母	Nut	1
65	18.7-65	止动螺钉	Screw	1
66	18.7-66	缓冲垫	Packing	1

10、附件 Accessories for model



## 10、附件 Accessories for model

序号 No.	代号 Part Number	零件名称 Name	数量 Qt.	备注 Remark	
1	30.8-11	零件袋	Accessory bag	1	
2	10.8-31	一字开刀 (小)	Screw driver,S	1	
3	10.8-30	一字开刀 (中)	Screw driver,M	1	
4	10.8-29	一字开刀 (大)	Screw driver,L	1	
5	10.2-45	机针	Needle	4	DP X17 23#
6	18.3-4	梭芯	Bobbin	3	
8	10.8-1	油盘	Oil pan	1	
9	10.8-2	放油螺钉	Screw	1	
10	10.8-3	放油螺钉垫圈	Washer	1	
11	10.8-4	油盘垫	Pad	1	
12	10.8-11	膝控提升顶杆	Bar	1	
13	10.8-21	磁块	Magnet	1	
14	10.8-22	油壶	Oil pot	1	
15		机壳铰链	Head hinge	2	
16	10.8-25	机壳铰链套	Cushion,head hinge	2	
17	10.8-26	机头防震垫块 (大)	Head cushion,L	2	
18	10.8-23	机头防震垫块 (小)	Head cushion,S	2	
19	10.8-24	油箱	Oil tank	1	
20	20.8-7	线架组件	Thread stand assy.	1	
21	20.8-6				
26	10.8-5	膝控铰链轴	Lifter shaft	1	
27	10.8-6	膝控复位弹簧	Spring	1	
28	10.8-7	膝控限位架	Bracket	1	
29	10.8-8	膝控限位调节螺钉	A djusting screw	2	
30	10.8-9	调节螺母	A djusting nut	2	
31	10.8-10	膝控限位架螺钉	Screw	1	
32	30.7-15	碰块弯杆接头	Bracket	1	
33	30.7-17	碰块弯杆接头螺钉	Screw	各1	GB/T5781 M8 x 12 M8 x 20 镀锌
34	10.8-14	膝控碰块弯杆	Lifter bar	1	
35	10.8-15	膝控碰块	Knee lifter plate	1	
36	10.8-16	碰城架	Stopper	1	
37	10.8-17	碰块架螺钉	Screw	1	
38	10.8-18	碰块垫	Cover,K-lifter Plate	1	
39		开口挡圈	Retaining ring	1	GB896 9 发黑



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