



# 高速平缝机 ZJ9800系列

HIGH-SPEED LOCKSTITCH SEWING MACHINE

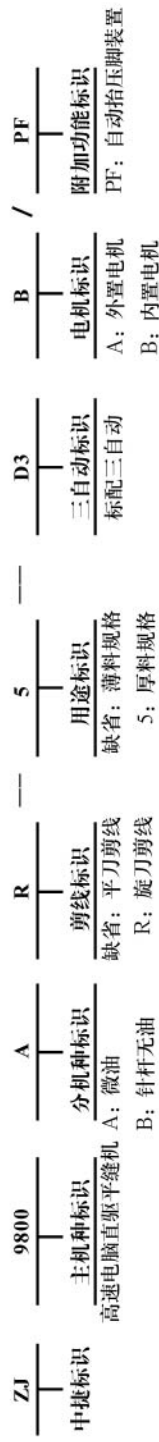
使用说明书  
零件手册  
OPERATION MANUAL  
PARTS BOOK

中国·中捷缝纫机股份有限公司  
ZOJE SEWING MACHINE CO., LTD.  
地址：浙江玉环大麦屿开发区  
ADD:DAMAIYU ZONE, YUHUAN, ZHEJIANG, 317604 CHINA  
免费咨询电话：TEL:800-857-6715

中国·中捷缝纫机股份有限公司  
ZOJE SEWING MACHINE CO., LTD.

## ZJ9800系列直驱平缝机编号

### 产品型号表示方法



# 目 录

|                   |    |
|-------------------|----|
| 运转缝纫机前的注意事项       | 1  |
| 1. 主要技术规格、参数      | 2  |
| 2. 缝纫机的安装         | 2  |
| 3. 膝动提升高度的调整      | 4  |
| 4. 线架的安装          | 4  |
| 5. 加油             | 5  |
| 6. 旋梭油量的调整        | 6  |
| 7. 旋梭部油量（油迹）的调整方法 | 7  |
| 8. 机针的安装方法        | 9  |
| 9. 梭心的安装方法        | 10 |
| 10. 针距的调节         | 10 |
| 11. 压脚压力的调节       | 10 |
| 12. 面线的穿线方法       | 11 |
| 13. 底线的卷绕方法       | 12 |
| 14. 缝线张力的调整       | 14 |
| 15. 挑线簧的调节        | 14 |
| 16. 挑线杆挑线量的调节     | 16 |
| 17. 机针停止位置的调整     | 17 |
| 18. 齿轮箱润滑油的查看与添加  | 18 |
| 19. 踏板的调整         | 19 |
| 20. 踏板操作          | 19 |
| 21. 单触手动倒缝        | 21 |
| 22. 拨线杆           | 22 |
| 23. 机针与旋梭的关系      | 23 |
| 24. 固定刀           | 24 |
| 25. 定刀与动刀的更换      | 25 |
| 26. 剪线装置的调整       | 26 |
| 27. 送料牙的高度和倾斜度    | 27 |
| 28. 送布的同步         | 28 |
| 29. 解除机构          | 29 |
| 30. 微量压脚提升        | 30 |
| 31. 缝纫机的搬运及放置注意事项 | 31 |

# CONTENTS

|   |    |
|---|----|
| Before operation.....   | 1  |
| 1. Specifications.....  | 2  |
| 2. Installation.....  | 2  |
| 3. Adjusting the height of the knee lifter.....               | 4  |
| 4. Installing the thread stand.....                           | 4  |
| 5. Lubrication.....   | 5  |
| 6. Adjusting the amount of oil in the hook.....               | 6  |
| 7. Adjusting the amount of oil(oil splashes) in the hook..... | 7  |
| 8. Attaching the needle.....                                  | 9  |
| 9. Setting the bobbin into the bobbin case.....               | 10 |
| 10. Adjusting the stitch length.....                          | 10 |
| 11. Presser foot pressure.....                                | 10 |
| 12. Threading the machine head.....                           | 11 |
| 13. Winding the bobbin thread.....                            | 12 |
| 14. Thread tension.....                                       | 14 |
| 15. Thread take-up spring.....                                | 14 |
| 16. Adjusting the thread take-up stroke.....                  | 16 |
| 17. Adjusting the needle stop position.....                   | 17 |
| 18. Oil check and addition .....                              | 18 |
| 19. Adjusting of the pedal.....                               | 19 |
| 20. Pedal operation.....                                      | 19 |
| 21. One-touch reverse stitching mechanism.....                | 21 |
| 22. Wiper.....  | 22 |
| 23. Needle-to-hook relationship.....                          | 23 |
| 24. Counter knife.....  | 24 |
| 25. Change of counter knife and moving knife .....            | 25 |
| 26. Adjustment of trimming system.....                        | 26 |
| 27. Height and tilt of the feed dog.....                      | 27 |
| 28. Adjusting the feed timing.....                            | 28 |
| 29. Thread tension release releasing mechanism.....           | 29 |
| 30. Micro-lifting mechanism of the presser foot.....          | 30 |
| 31. Caution when carrying or placing the sewing machine.....  | 31 |



## 运转缝纫机前注意事项

注意：为了防止机械的错误动作或损伤，请确认如下项目。

- 请卸下缝纫机机台上安装的放气盖（红色）。
- 使用之前请一定往油槽中加油。
- 最初使用缝纫机之前，请把机器打扫干净。
- 清除运送途中积存的灰尘，并加油。
- 请确认电压设定是否正确。
- 请确认电源插头是否正确连接。
- 电压规格不同时，请绝对不要使用。
- 请确认马达皮带轮的旋转方向是否正确。
- 请不要把缝纫机向前倒，以免漏油或损坏零件。
- 本缝纫机安装有机头放倒后不让缝纫机转动的开关。因此，运转缝纫机时，请正确的设置缝纫机台板后再打开电源开关。

## BEFORE OPERATION

Caution: To avoid malfunction and damage of the machine, confirm the following.

- Remove air-vent cap (red color) attached to the sewing machine bed.
- Be sure to pour in the oil before using.
- Before you put the machine into operation for the first time after the set-up, clean it thoroughly.
- Remove all dust gathering during transportation and oil it well.
- Confirm that the voltage has been correctly set.
- Confirm that the power plug has been properly connected to the power supply.
- Never use the machine in the state where the voltage type is different from the designated one.
- Confirm that the direction of rotation of the motor pulley is correct.
- Do not tilt the sewing machine head toward this side since oil leakage or parts breakage occurs.

A safety switch is installed so that the sewing machine cannot be operated with the head tilted. When operation the sewing machine, turn On the power switch after properly setting the head on the table.

## 1. 主要技术规格、参数

| 用途   | 薄料                          | 厚料           |
|------|-----------------------------|--------------|
| 最高缝速 | 5000rpm                     | 3500rpm      |
| 最大针距 | 5mm                         |              |
| 使用机针 | DB×1 9#~18#                 | DP×5 16#~18# |
| 压脚高度 | 手提 8 mm (标准)<br>膝提15mm (最大) |              |
| 使用机油 | 旋梭: 10号白油 齿轮箱: 壳牌22号液压油     |              |
| 使用电机 | 500W                        |              |

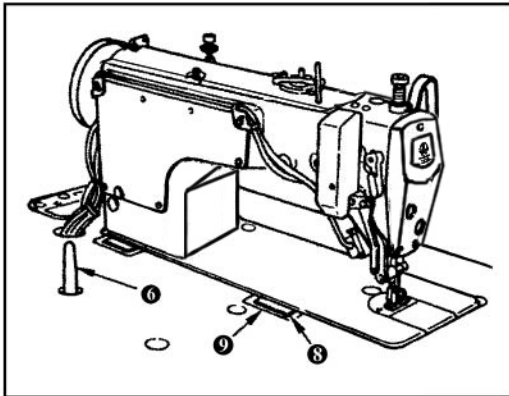
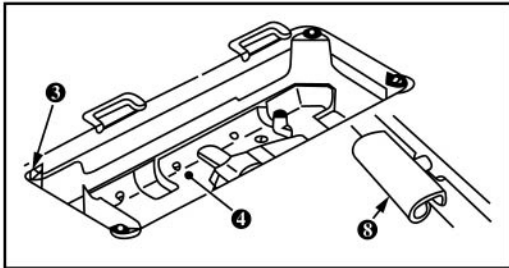
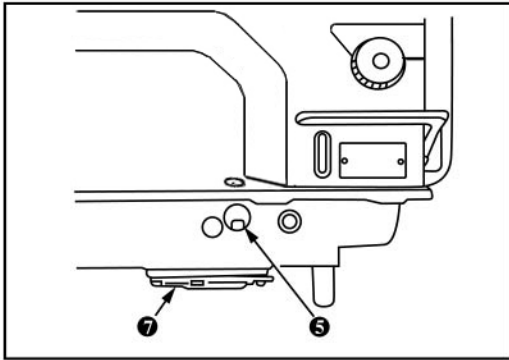
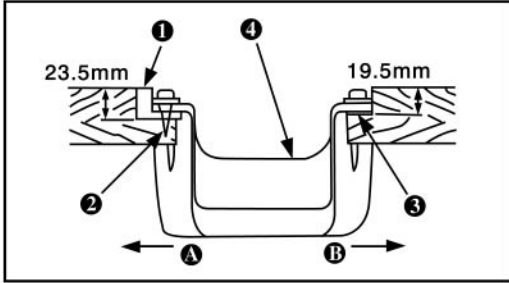
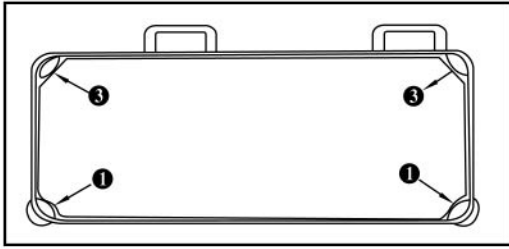
## 1. Specifications

| Application       | Thin-medium material   | Heavy material |
|-------------------|--|----------------|
| Sewing speed      | 5000rpm  | 3500rpm        |
| Stitch length     | Max 5mm  |                |
| Needle            | DB×1 9#~18#  | DP×5 16#~18#   |
| Presser foot lift | By hand lifter 8 mm (standard)<br>By knee lifter 15mm (max.) |                |
| Oil               | Hook: White Oil No.10 Gear Box: Shell Tellus Oil No.22       |                |
| Rated power       | 500W   |                |

## 2. 缝纫机的安装 Installation

### 1. 油盘安装

- 1) 油盘放置在台板上的凹槽四角上;
- 2) 两只油盘支座①用油盘座钉②固定在A一边 (朝操作者一边), 将两只油盘座垫③用油盘座钉②固定在B一边 (与机头连接钩接合一边) 然后放上油盘④;
- 3) 卸下底板上的放气盖⑤。(搬动机头时, 请一定把放气盖⑤盖上)



4) 将机头连接钩⑧插入底板销孔内，与台板的机头连接钩座⑨相嵌合再把机头放到油盘四只角的机头座垫③上。

注意：如果不卸下放气盖⑤运转缝纫机，就会有油从齿轮箱⑦漏出。

1. Installing the oil pan:

- 1) The oil pan should rest on the four corners of the machine table groove;
- 2) Two rubber seats ① for supporting the head portion on the operator side ④ are fixed on the extended portion of the table by hitting the nails ②, and the other two rubber cushion seats ③ on the hinged side ④ are fixed by using a rubber-based adhesive. Then, oil pan ④ is placed;
- 3) Remove air vent cap ⑤ attached to the machine bed. (Be sure to attach cap when transporting the machine head in the state that the machine head is removed from the machine table.)
- 4) Fit hinge ⑧ into the opening in the machine bed, and fit the machine head to table rubber hinge ⑨ before placing the machine head on cushions ③ on the four corners.

**Caution:** If the sewing machine is operated without removing air vent cap ⑤, oil leakage from gearbox portion ⑦ may occur.

### 3. 膝动提升高度的调整

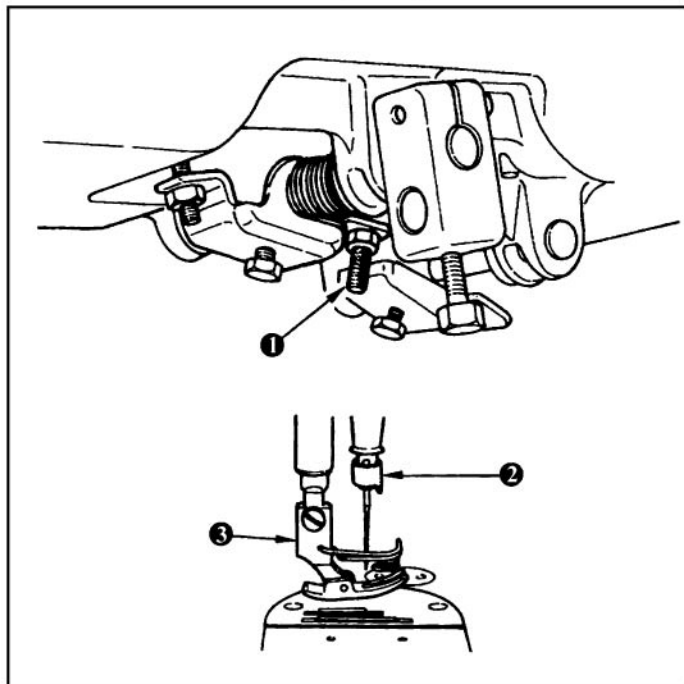
#### Adjusting the height of the knee lifter



注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



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最大可至15毫米；

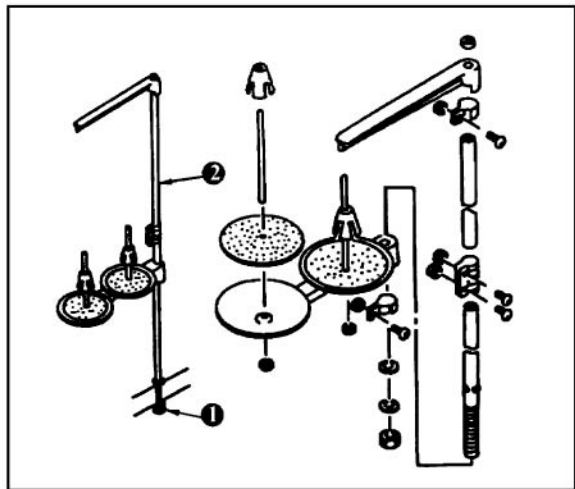
注意：当压脚提升超过10毫米时，请不要运转缝纫机，因为针杆②与压脚③会相碰。

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 15mm using knee lifter adjust screw ①.

Caution: Do not operate the sewing machine state that the presser foot ③ is lifter 10mm or more since the needle bar ② in contact with the presser foot ③.

### 4. 线架的安装 Installing the thread stand



1. 如图所示那样线架安装到缝纫机台板孔上。

2. 用固定螺母①固定线架。

3. 顶线配线时，请把电源线从线架杆②中穿过。

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.

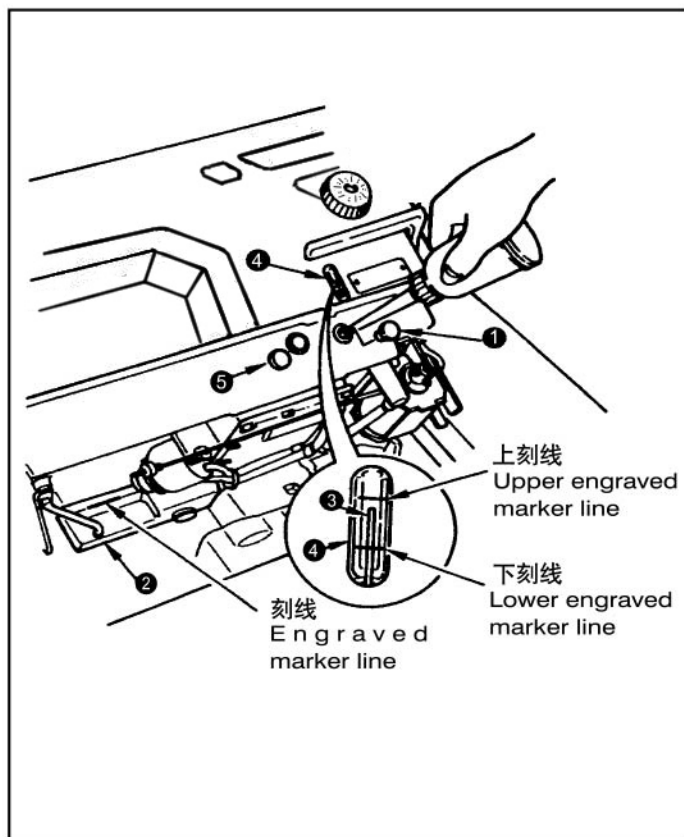
## 5. 加油 Lubrication



注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



运转缝纫机之前，请一定往旋梭油槽中加油

1. 把缝纫机放倒，并支到机头支撑杆上。
2. 卸下加油口的盖①，使用附带的加油壶加入ZJ 1号机油。
3. 请把油加满到油槽②的刻线位置。请注意加油过多的话，机油会从油槽空气孔漏出来，也会发生不能正常加油的现象。
4. 使用缝纫机时，如果油量指示杆③指到油量指示窗④的下刻线以下，请进行加油。

注意：

1. 使用新缝纫机或较长时间没有使用的缝纫机时，请先进行3000~3500转/分钟的磨合运转之后再使用。

2. 请不要把橡胶栓⑤拔掉。

**Fill the oil tank with oil for hook lubrication before the sewing machine.**

- 1) Tilt the machine head until it comes in contact with the head support rod.
- 2) Remove oil hole cap ① and fill the oil tank with ZJ No.1 using the oiler supplied with the machine.
- 3) The amount of oil should reach up to the engraved marker line of oil tank ②.  
If the oil is filled excessively, it will leak from the air vent hole in the oil tank or proper lubrication will be not performed. So , be careful.
- 4) When you operate the sewing machine, refill oil if the top end of oil amount indicating rod ③ comes down to the lower engraved marker line of oil amount indicating rod comes down to the lower engraved marker line of oil amount indicating window ④.

(Caution) 1. when you use a new sewing machine or a sewing machine after an extended period of disuse, run your machine at 3,000 to 3,500rpm for the purpose of break-in

2. Do not remove rubber plug⑤

## 6. 旋梭油量的调整

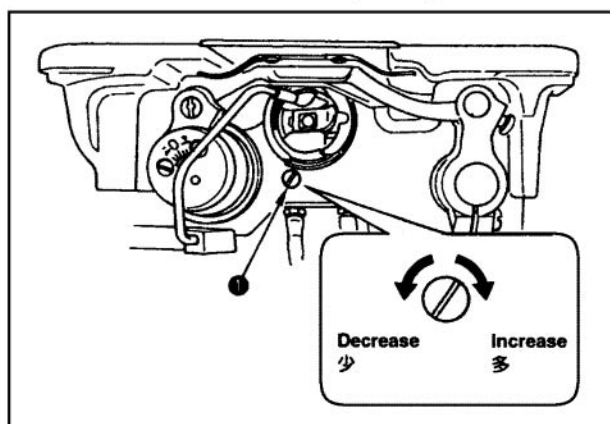
### Adjusting the amount of oil in the hook



注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



旋梭油量用旋梭油量调节螺钉①来调节。

1. 调节方法：

拧紧（向右转动）旋梭油量调节螺钉①后，旋梭油量变多，拧松（向左转动）旋梭油量变少。

(注意) 1. 微量供油型缝纫机使用RP旋梭（干式旋梭）时，请一定把油量调到最小，不让机油流出。

2. 使用RP旋梭（干式旋梭）时，也一定不要把机油槽的油放掉。

Adjustment of the amount of oil in the hook is performed with oil amount adjustment screw ①

1. Adjustment procedure

Tighten (turn clockwise) oil amount adjustment screw ① to increase the amount of oil in the hook, or loosen (turn counterclockwise) to decrease it.

(Caution) 1. When using RP hook (hook for dry head) for the SS type, be sure to loosen the oil amount adjustment screw up to the minimum so as to reduce the oil amount in the hook.

2. Never drain the oil in the oil tank even when RP hook (hook for dry head) is used.

## 7. 旋梭部油量（油迹）的调整方法 Adjusting the amount of oil (oil splashes) in the hook



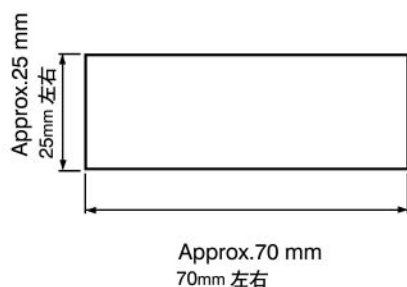
注意：旋梭是已高速运转的。为了防止人身事故，调整油量时，请加以充分的注意。



Warning: Be extremely careful about the operation of the machine since the amount of oil has to be checked by turning the hook at a high speed.

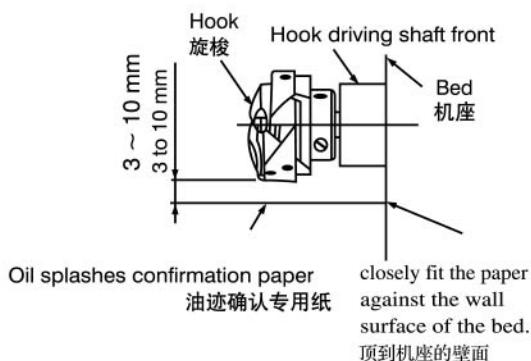
① Amount of oil(oil splashes) confirmation paper

① 油量(油迹)确认专用纸



② Position to confirm the amount of oil(oil splashes)

② 油量(油迹)确认位置



\* Use any paper available regardless of the material.  
※ 不用考虑纸的质量。

\* Place the amount of oil (oil splashes) confirmation paper under the hook.  
※ 把油量(油迹)确认专用纸插到旋梭下面。

### 1. 油量（迹）确认方法

进行下列2)的操作时，请卸下滑板，同时要充分注意手指不要碰到旋梭。

- 1) 机头冷却时，请进行3分钟左右的空转。（适当的间歇运转）。
- 2) 请在缝纫机转动时将油量（油迹）确认专用纸插入。
- 3) 确认油槽中是否有油。
- 4) 油量（油迹）确认时间为5秒。

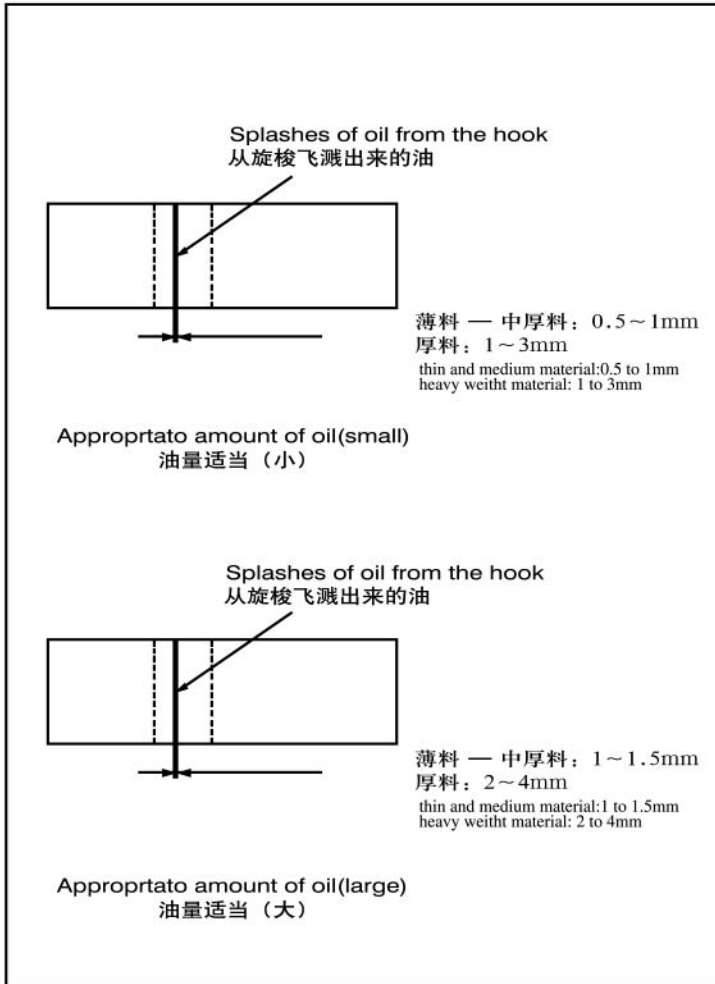
### 1. How to confirm the amount of oil (oil splashes)

When carrying out the procedure described below in 2, remove the slide plate and take extreme caution not to allow your fingers to come in contact with the hook.

- 1) If the machine has not been sufficiently warmed up for operation, make the machine run idle for approximately three minutes. (Moderate intermittent operation)
- 2) Place the amount of oil (oil splashes) confirmation paper under the hook while the sewing machine is in operation.

- 3) Confirm that oil exists in the oil tank.
- 4) Confirmation of the amount of oil should be completed in five seconds. (Check the period of time with a watch.)

## 2. 油量（油迹）适合标样



1)左图标样根据缝制供需需要微调增减，但注意增减不能过大。油量减少时，会发热烧坏旋梭。油量过多时，会污染缝料。

2)油量（油迹）应确认3次均无变化方可。

2. Sample showing the appropriate amount of oil

1) The amount of oil shown in the samples on the left should be finely adjusted in accordance with sewing processes. Be careful not to excessively increase/decrease the amount of oil in the hook.(if the amount of oil is too small, the hook will be seized (the hook will be hot). If the amount of oil is too much, the

sewing product may be stained with oil.)

2) Adjust the amount of oil in the hook so that the oil amount (oil splashes) should not change while checking the oil amount three times (on the three sheets of paper).



## 8. 机针的安装方法 Attaching the needle



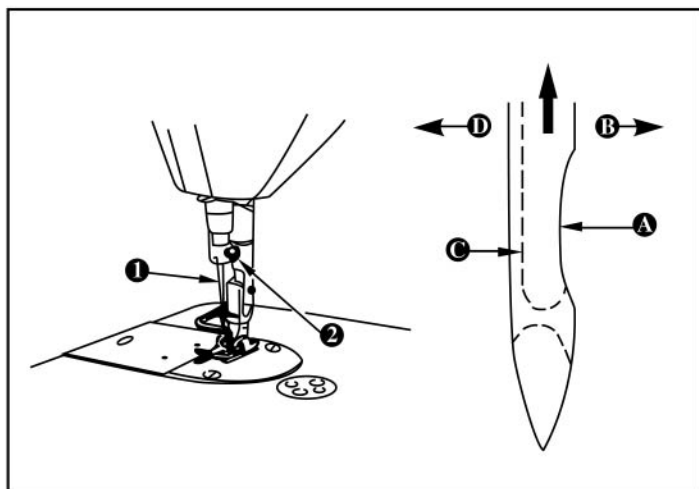
注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



**Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.**

请使用DBx1或DPx5的机针。请根据线的粗细、布料的种类选择适当的机针。

1. 转动手轮，把针杆升到最高处。
2. 拧松机针固定螺钉②，手拿机针把机针①凹部Ⓐ横向转到Ⓑ的方向。
3. 把机针插到针杆孔的深处。
4. 拧紧机针固定螺钉②
5. 确认针的长孔Ⓒ在左横向Ⓓ的方向。



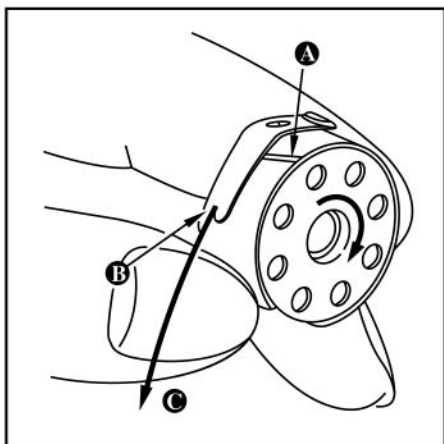
注意：使用长丝机线时，如果机针凹部朝向前方，容易发生线环不稳定或断线的现象。使用这类机线时，请把机针稍稍向后倾斜安装，就可以有效地防止这些现象。

A needle of DBx1 or DPx5 should be used. Select a proper needle size according to the count of thread and the type of material used.

1. Turn the hand-wheel until the needle bar reaches the highest point of its stroke.
2. Loosen screw ②, and hold needle ① with its indented part ④ facing exactly to the right in direction ⑤.
3. Insert the needle fully into the hole in the needle bar in the direction of the arrow until the end of hole is reached.
4. Securely tighten screw ②.
5. Check that long groove ③ of the needle is facing exactly to the left in direction ⑥.

**Caution:** When filament thread is used, if the indented part of the needle is tilted toward operator's side, the loop of thread becomes unstable, As a result, hangnail of thread or thread breakage may occur. For the thread that such phenomenon is likely to occur, it is effective to attach the needle with its indented part slightly slanting on the rear side.

## 9. 梭心的安装方法 Setting the bobbin into the bobbin case



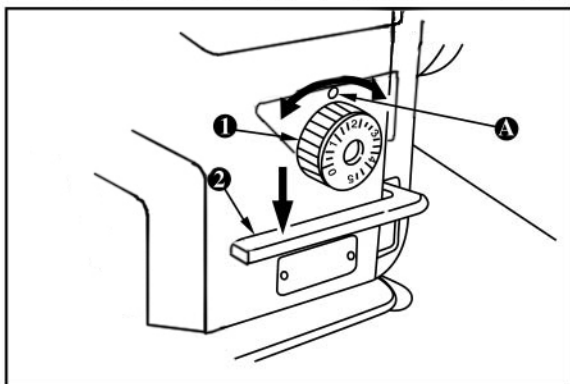
1. 将梭心装入梭子内；
2. 将线从梭子上的线槽Ⓐ中穿过，朝Ⓑ方向拉出。这样，线通过夹线簧下从线孔Ⓒ处引出；
3. 拉底线Ⓒ时，梭心应按箭头方向转动。

1. Install the bobbin in the bobbin case so that the thread wound direction is clockwise.
2. Pass the thread through thread slit ①, and pull the thread in direction ②. By so doing, the thread will pass under the tension spring and come out from notch ③.

3. Check that the bobbin rotates in the direction of the arrow when thread ③ is pulled.

## 10. 针距的调节 Adjusting the stitch length

1. 将送料距旋钮①按箭头方向转动，旋至所需数字对准机壳上的刻点Ⓐ；
2. 旋钮上的刻度数字单位用毫米表示；
3. 若欲缩短线迹长度，把倒缝扳手②朝箭头方向压下的同时，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 ① 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.

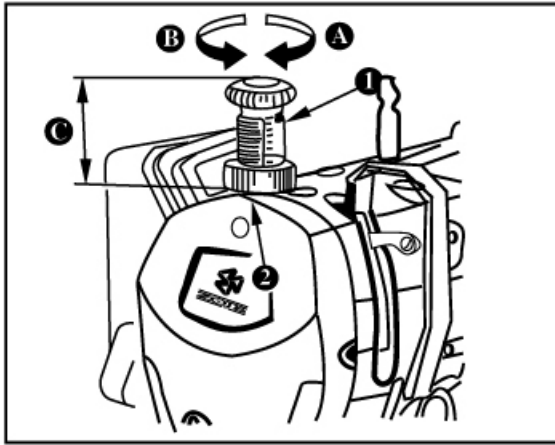
## 11. 压脚压力的调节 Presser foot pressure



注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



**Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.**



1. 旋松调压螺母②顺时针（即A方向）转动压力脚调节螺钉，压力将增强；
2. 逆时针（即B方向）转动压力脚调节螺钉，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32~34毫米（4.5Kg）。

1. Loosen nut ②. As you turn presser spring regulator ① clockwise(in direction A), the presser foot pressure will be increased.
2. As you turn the presser spring regulator counterclockwise(in direction B), the pressure will be decreased.
3. After adjustment, tighten nut ②.
4. For general fabrics, the standard height of the presser spring regulator is 32 to 34mm(4.5kg).

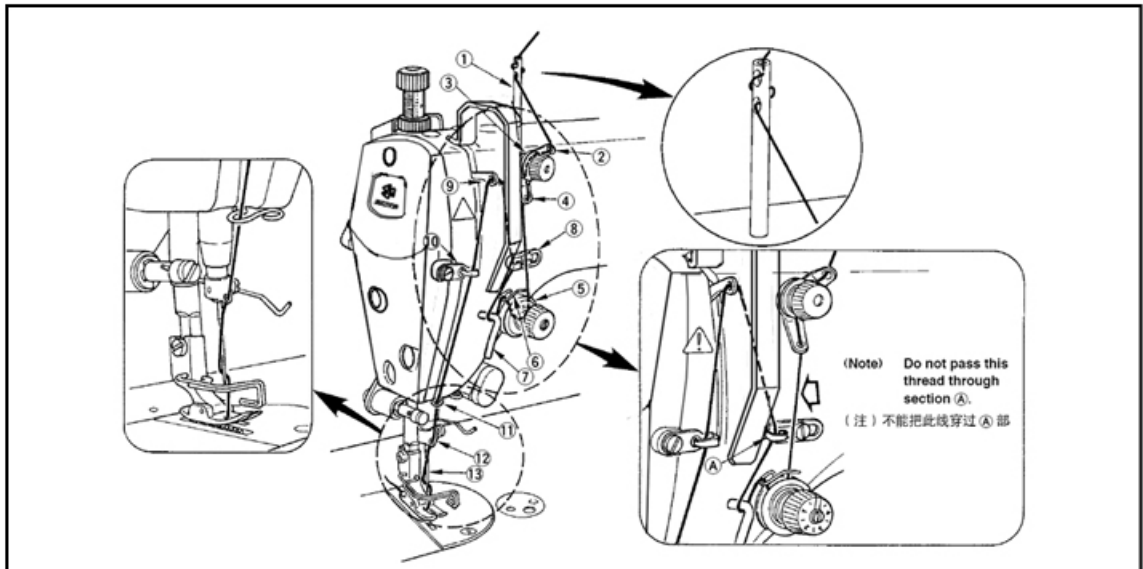
## 12. 面线穿线的方法 Threading the machine head



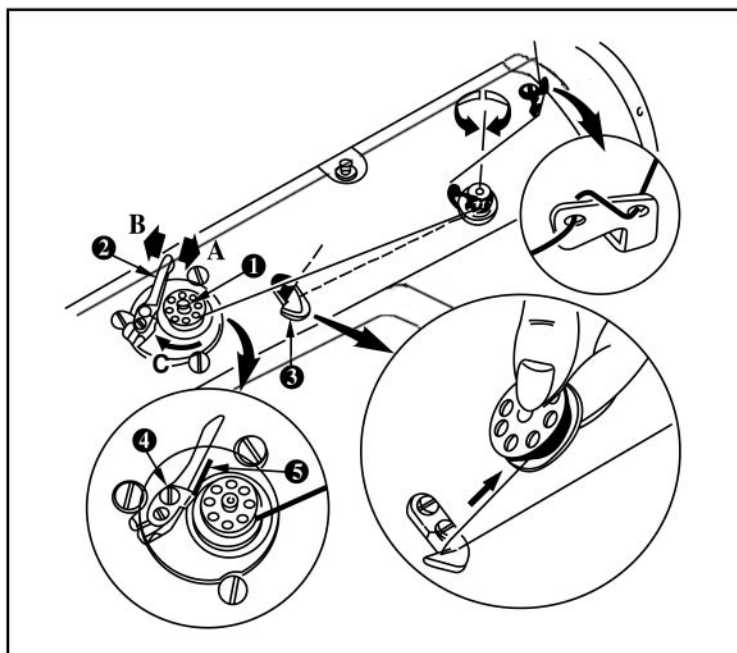
注意：为了防止缝纫机的意外起动，请关掉电源后再进行此操作。



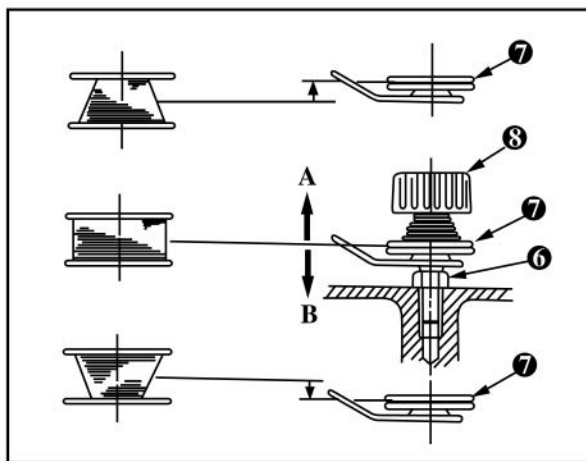
Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



### 13. 底线的卷绕方法 Winding the bobbin thread



1. 把梭心推到卷绕轴①的最里面；
2. 把线架右侧的卷线如图所示穿线，并把线端向右缠绕数圈（铝旋梭时，把线端向右缠绕后，再把线张力盘过来的线向左缠绕数圈后，就容易绕线了）。
3. 把卷线拔杆②推到A方向，转动缝纫机。梭心向C方向转动，线卷绕到梭心上。卷绕结束后卷绕轴①自动停止。
4. 取下梭心，用切线保持板③切断机线。



5. 调整底线卷线量时，请拧松固定螺钉④，把调节板⑤移动到A方向或B方向，然后再固定螺钉④。A方向变少，B方向变多。
6. 如果线不能平绕梭心时，请拧松螺母⑥，转动卷线张力器，调整线张力盘⑦的高度：

- 旋梭中心和线张力盘中心高度一样时为标准位置；
- 下部卷得多时，向如图A方向移动线张力盘的位置，上部卷得多时，向如图B方向移动线张力盘⑦的位置。

调整到适合的位置后，把固定螺钉④拧紧；

7. 调整底线卷绕张力时，请转动线张力螺母⑧进行调整。

注意：

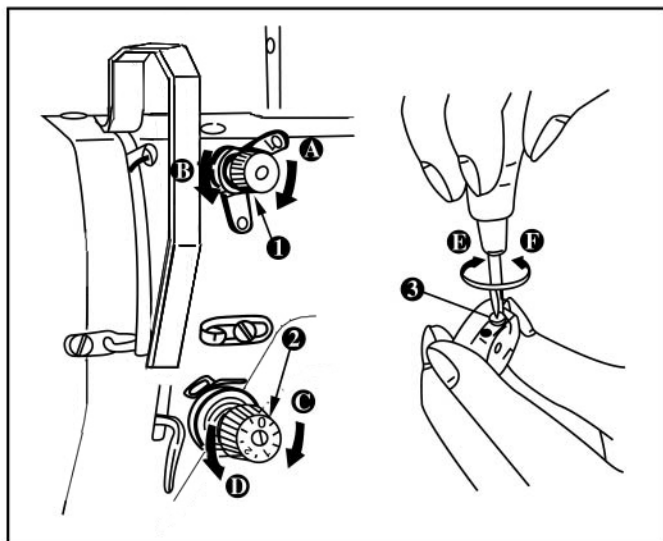
1. 卷绕底线时，请在梭芯和线张力盘⑦之间拉线的状态开始绕线。
2. 不进行缝制时给梭芯绕底线时，请把上线从挑线杆过线孔上抽出来，把梭芯从旋梭里卸下来后再进行。

- 1) Insert the bobbin deep into the bobbin winder spindle ① until it will go no further.
- 2) Pass the bobbin thread pulled out from the spool rested on the right side of the thread stand following the order as shown in the figure on the left. Then, wind clockwise the end of the bobbin thread on the bobbin several times. (In case of the aluminum bobbin, after winding clockwise the end of the bobbin thread, wind counterclockwise the thread coming from the bobbin thread tension several times to wind the bobbin thread with ease.)
- 3) Press the bobbin winder trip latch ② in the direction of Ⓐ and start the sewing machine. The bobbin rotates in the direction of C and the bobbin thread is wound up. The bobbin winder spindle ① automatically as soon as the winding is finished.
- 4) Remove the bobbin and cut the bobbin thread with the thread cut retainer ③.
- 5) To adjust the winding amount of the bobbin thread, loosen the setscrew ④ and move the bobbin winder adjusting plate ⑤ to the direction of Ⓐ or Ⓑ. Then, tighten the setscrew ④. To the direction of Ⓐ: Decrease; to the direction of Ⓑ: Increase.
- 6) In case that the bobbin thread is not wound evenly on the bobbin, loosen the nut ⑥ and turn the bobbin thread tension to adjust the height of the thread tension disk ⑦.
  - It is the standard that the center of the bobbin is as high as the center of the thread tension disk.
  - Move the position of the thread tension disk ⑦ to the direction of Ⓐ as shown in the figure on the left when the winding amount of the bobbin thread on the lower part of the bobbin is excessive and to the direction of Ⓑ as shown in the figure on the left when the winding amount of the bobbin thread on the upper part of the bobbin is excessive. After the adjustment, tighten the nut ⑥.
- 7) To adjust the tension of the bobbin winder, turn the thread tension nut ⑧.

**Caution:**

1. when winding the bobbin thread, start the winding in the state that the thread between the bobbin and thread tension disk ⑦ is tense.
2. When winding the bobbin thread in the state that wing is not performed, remove the needle thread from the thread path of thread take-up and remove the bobbin from the hook.

## 14. 缝线张力的调整 Thread tension



### 1. 面线张力的调整

- 1) 把面线张力螺母①顺时针方向(Ⓐ方向)转动, 面线的张力变强;
- 2) 把面线张力螺母①逆时针方向(Ⓑ方向)转动, 面线的张力变弱;
- 3) 把线张力螺母②向右Ⓒ方向转动, 面线张力变强;
- 4) 把线张力螺母②向左Ⓓ方向转动, 面线张力变弱。

### 2. 底线张力的调整

- 1) 把线张力螺钉③向右Ⓔ的方向转动, 底线张力变强;
- 2) 向左Ⓕ的方向转动则变弱。

#### 1. Adjusting the needle thread tension

- 1) As you turn thread tension nut ① clockwise (in direction Ⓐ), the thread remaining on the needle after thread trimming will be shorter.
- 2) As you turn nut ① counterclockwise (in direction Ⓑ), the thread length will be longer.
- 3) As you turn thread tension nut ② clockwise (in direction Ⓒ), the needle thread tension will be increased.
- 4) As you turn nut ② counterclockwise (in direction Ⓓ), the needle thread tension will be decreased.

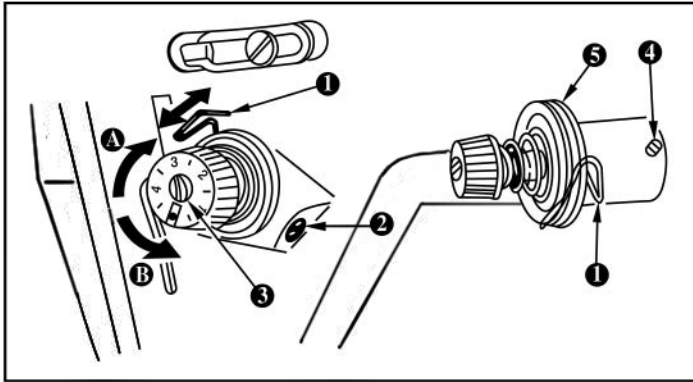
#### 2. Adjusting the bobbin thread tension

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

## 15. 挑线簧的调节 Thread take-up spring

### 1. 挑线簧摆动量的调节:

- 1) 旋松定位螺钉②;
- 2) 把夹线螺钉③朝顺时针方向(即Ⓐ方向)转动时, 挑线簧的摆动量将增大;



(即Ⓐ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Ⓑ方向)转动时,挑线簧的张力将减小。

通常,机器在出厂前,挑线簧均已调整妥善。只是在缝纫特殊的缝料或特殊的缝线时,才需要重新进行调整。

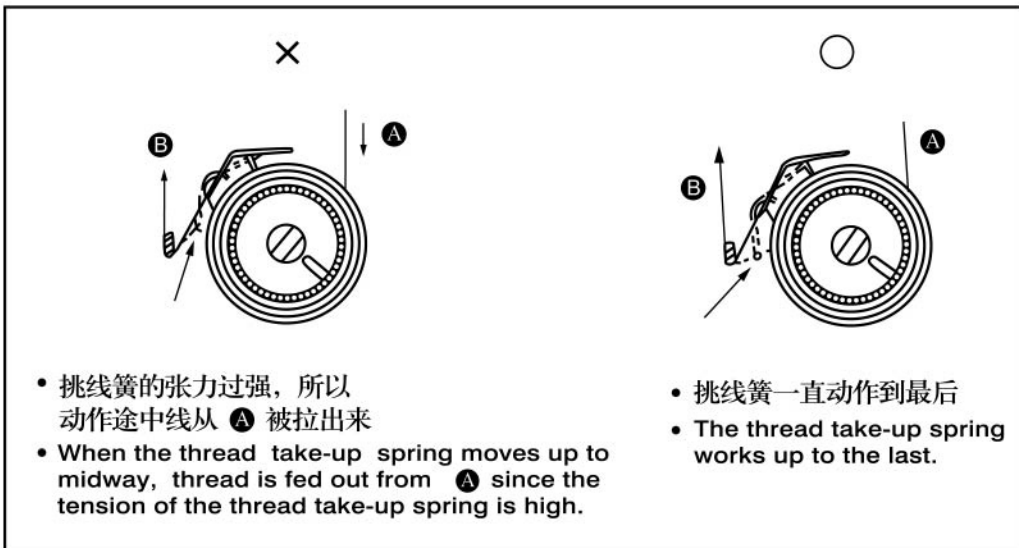
3) 把夹线螺钉③朝逆时针方向(即Ⓑ方向)转动时,挑线簧的摆动量将减小。

2. 挑线簧张力的调节:

1) 旋松定位螺钉②,取出夹线器⑤(组件);

2) 旋松定位螺钉④,并转动夹线螺钉③;

3) 把夹线螺钉③朝顺时针方向



- 挑线簧的张力过强,所以动作途中线从Ⓐ被拉出来
- When the thread take-up spring moves up to midway, thread is fed out from Ⓐ since the tension of the thread take-up spring is high.

- 挑线簧一直动作到最后
- The thread take-up spring works up to the last.

挑线簧调整适当的判定方法:确认挑线簧的压力调整后,把面线向Ⓑ方向拉出,如果在挑线簧到达最低位置之前面线Ⓑ处就被拉动,请减弱挑线簧的压力。

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

1) Loosen setscrew ②.

2) As you turn tension post ③ clockwise(in direction Ⓐ), the stroke of the thread take-up spring will be increased.

3) As you turn tension post ③ counterclockwise(in direction Ⓑ), the stroke will be decreased.]

### 2. Changing the pressure of thread take-up spring ①

1) Loosen setscrew ②, and remove thread tension ⑤.

2) Loosen setscrew ④.

3) As you turn tension post ③ clockwise(in direction Ⓐ), the pressure will be increased.

4) As you turn tension post ③ counterclockwise(in direction ②), the pressure will be decreased.

Usually, upon the machine coming out, all the take-up spring has been adjusted well, only while sew special material thread, it need to be adjusted again.

To judge the work of the thread take-up spring, confirm whether or not the thread take-up spring works up to the last before needle thread is pulled out from ④ when pulling out needle thread in the direction of ⑤ after the pressure of the thread take-up spring has been performed. When it does not work up to the last, decrease the pressure of the thread take-up spring. In addition, the stroke of the thread take-up spring is excessively small, the spring does not work properly. For the general fabrics, a stroke of 10 to 13 mm is proper.

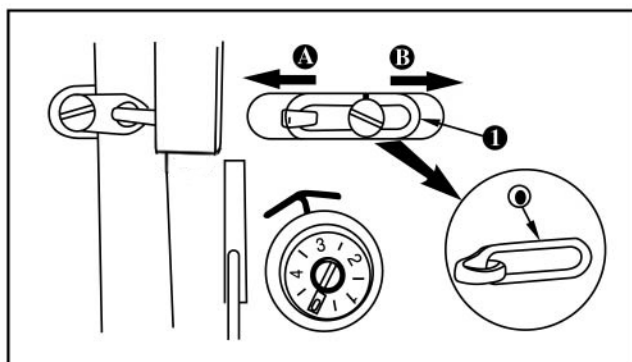
## 16. 挑线杆挑线量的调节 Adjusting the thread take-up stroke



注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



**Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.**



1. 缝制厚料时，应将右线钩①朝左方向Ⓐ移动，以增大挑线量；
2. 缝制薄料时，应将右线钩①朝右方向Ⓑ移动，以减少挑线量；
3. 右线钩①上的刻线Ⓒ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 ②) 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 ③) 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 ④ is aligned with the center of the screw.



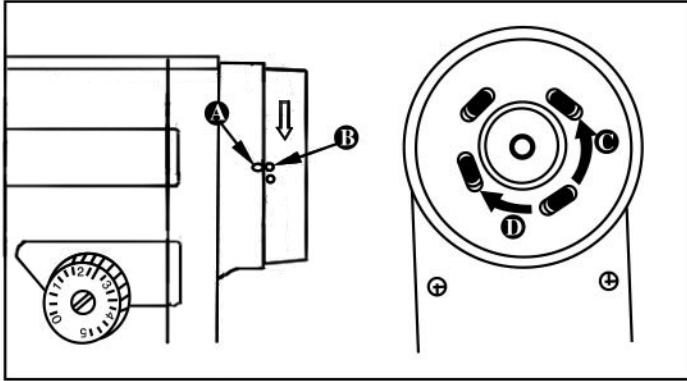
## 17. 机针停止位置的调整 Adjusting the needle stop position



注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



**Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.**



### 1. 切线后的停止位置

- 1) 标准的机针停止位置是皮带轮外罩的刻点Ⓐ和上轮的白刻点Ⓑ一致时的位置；
- 2) 让机针上升到最上的停止位置，在长孔范围对外片进行调节。

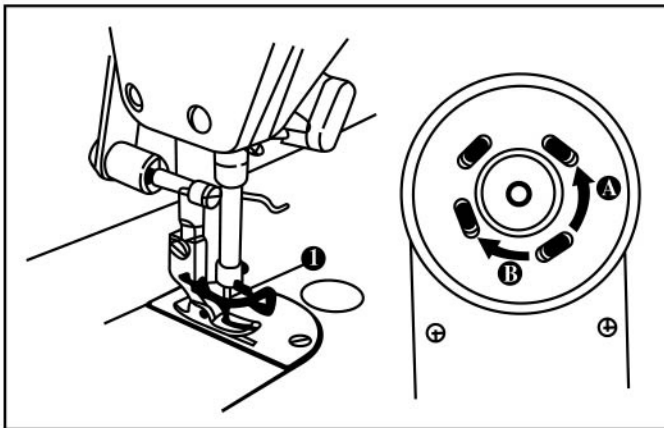
- 向Ⓒ的方向移动，机针停止提前；
- 向Ⓓ的方向移动，机针停止推迟；

### 1. Stop position after thread trimming

- 1) The standard needle stop position is obtained by aligning marker dot Ⓐ on the pulley cover with white marker dot Ⓑ on the hand-wheel.
  - 2) Stop the needle in its highest position, loosen screw ① to perform adjustment within the slot of the screw.
- The needle stop timing is advanced if you move the screw in direction Ⓒ.
  - The needle stop timing is delayed if you move the screw in direction Ⓓ.

### 2. 缝制的结束

- 1) 踏板从前踩踏变为中立时的机针下停止位置与上停止一样，让机针①下停止之后，在长孔范围内对内片进行调整。向Ⓐ方向移动机针停止位置提前，向Ⓑ方向移动机针停止位置推迟。



### 2. Lower stop position

- 1) The lower needle stop position when the pedal is returned to the neutral position after the front part of the pedal is depressed can be adjusted as follows:  
Stop needle ① in its lowest position. Loosen screw ②, and make adjustment within the slot of the screw. Moving the screw in direction Ⓐ advances the needle stop timing. Moving the screw in direction Ⓑ delays the timing.

## 18. 齿轮箱润滑油查看与添加

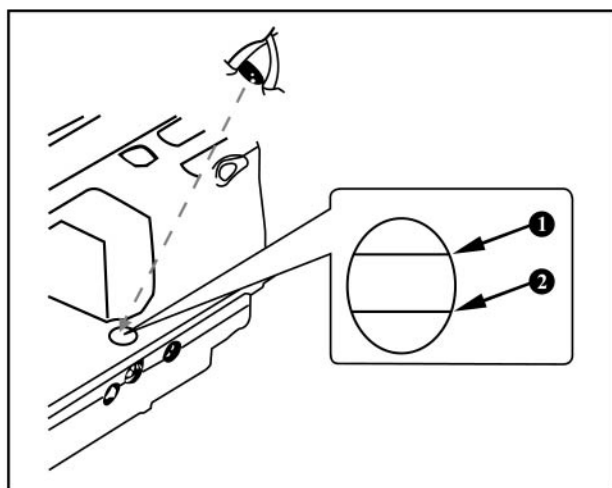
### Oil check and addition



注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。

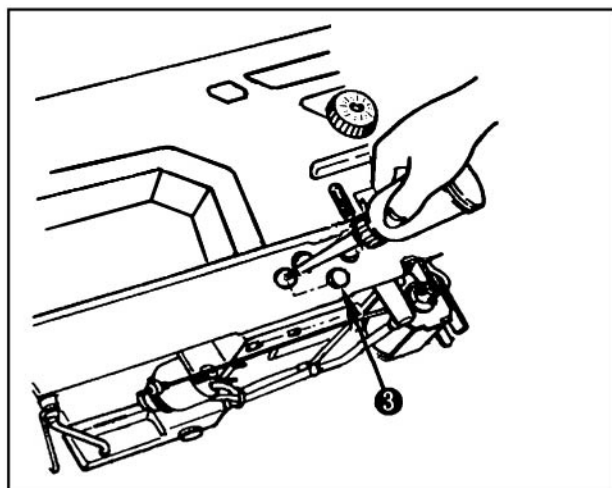


Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



运转缝纫机时，请一定要查看齿轮箱润滑油是否充足，及时添加充足的润滑油。

1. 缝纫机出厂时已往齿轮箱添加充足的润滑油，缝纫机在使用时，齿轮箱中的润滑油会不断被消耗，通过机器上的齿轮箱油标可以实时查看齿轮箱油标可以实时查看齿轮箱润滑是否充足，按图标查看位置可清晰查看到齿轮箱油标上的刻度，刻线①表示齿轮箱油量充足可安全使用缝纫机，刻线②表示齿轮箱油量已消耗完毕，需要尽快添加齿轮油。
2. 如果齿轮箱中的润滑油已消耗完毕，可按图示揭开③齿轮箱橡皮塞，然后按图示方法添加润滑油，当润滑油液面到达刻度线①即可。



When the sewing machine running, please check lubricating oil of gear box is sufficient or not. Add sufficient oil in time.

1. When you open then new machines, the lubricating oil of gear box is sufficient. While you running the machines, the oil is spent contnuously, we can inspect the oil of gear box is sufficient or not through the oil mark on gear box. According to the picture, we can gear box's oil mark. 1, It means oil is enough and machines can be running safely. 2, It means oil is used out and need to add oil immediately.

gear box' s oil mark.1, It means oil is enough and machines can be running safely. 2, It means oil is used out and need to add oil immediately.

2. If the oil is used out, please uncover the rubber plug 1 of gear box(note the picture), then add lubricating oil, it is ok when the oil is up to the scale 1 of oil mark.

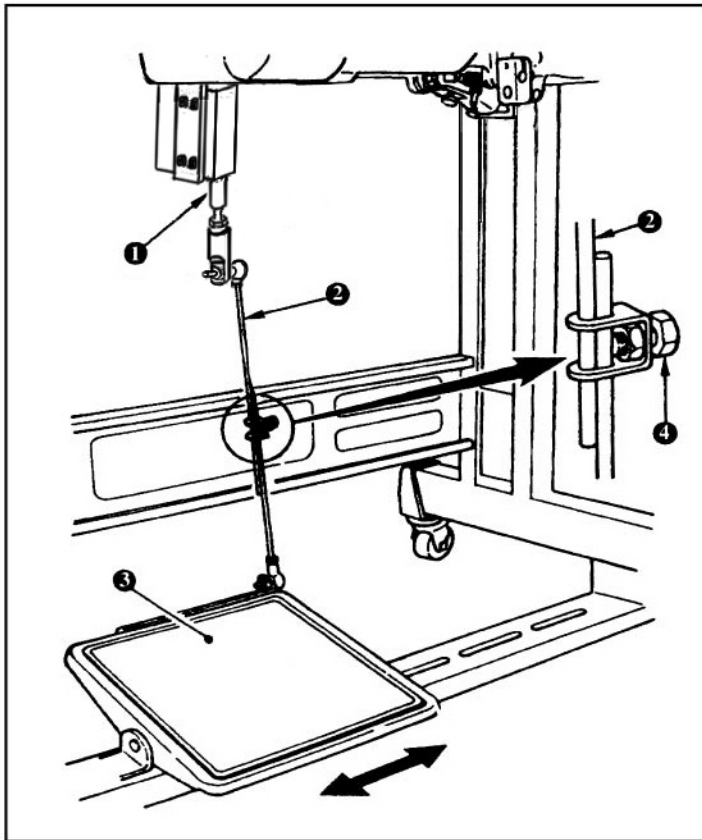
## 19. 踏板的调整 Adjustment of the pedal



注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



**Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.**



### 1. 连接杆的安装

- 1) 向箭头方向移动踏板调节板③，让马达控制杆①和连接杆②成一直线。

### 2. 踏板的角度

- 1) 调节连接杆的长度即可以改变踏板的角度。
- 2) 拧松调节螺钉④，移动连接杆②进行调节。

### 1. Installing the connecting rod

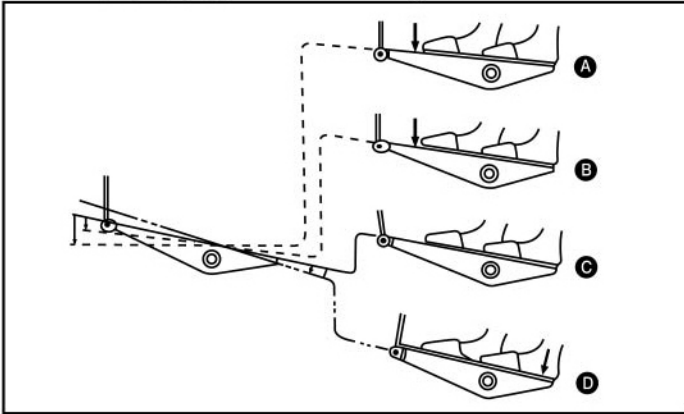
- 1) Move pedal ③ to the right or left as illustrated by the arrows so that motor control lever ① and connecting rod ② are straightened.

### 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 ④, and adjust the length of connecting rod ②.

## 20. 踏板操作 Pedal operation



### 1. 踏板有4级操作

- 1) 向前轻轻踩踏板为低速缝纫ⓑ；
- 2) 再继续往前踩踏板为高速缝纫Ⓐ；（但是，设定了自动倒缝开关后，倒缝结束之后为高速缝纫）；

3) 向后踩踏板为切线动作ⓓ。

※ 使用自动压脚提升装置时，在停止和切线之间增加一级开关

向后轻轻踩踏板，为压脚提升动作Ⓒ在继续踩踏板为切线动作。

- 始缝的自动倒缝中，把踏板返回中立位置则缝纫机倒缝结束后停止。
- 从高速缝纫或低速缝纫中向后用力踩踏板缝纫机均可切线。
- 缝纫机切线中把踏板返回中立位置但机器仍然把线切完。
- 缝纫机停止机针下降停止之后，如果想升起机针时，请往后踩一次踏板。

### 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 Ⓐ. (If the automatic reverse feed stitching has been preset, the machine runs at high speed after it completes reverse feed stitching.)

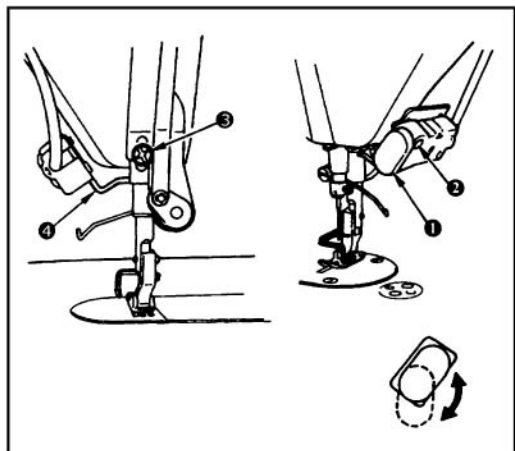
3) The machine trims threads when you fully depress the back part of the pedal ⓓ.

※ If your machine is provided with the Auto-lifter, an additional step is given between the machine stop and thread-trimming step. The presser foot goes up when you lightly depress the back part of the pedal Ⓒ, and if you further depress the back part, the thread trimmer is actuated.

- If you reset the pedal to its neutral position during the automatic reverse feed stitching at seam start, the machine stops after it completes the reverse feed stitching;
- 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.

## 21. 单触手动倒缝

### One-touch type reverse feed stitching mechanism



#### 1. 使用方法

- 1) 按下开关拔杆①，缝纫机立即倒缝；
- 2) 在按下的时间进行倒缝；
- 3) 手一松开立即变为正向缝纫。

#### 1. How to operate

- 1) The moment switch lever ① is pressed, the machine performs reverse feed stitching.
- 2) The machine performs reverse feed stitching as long as the switch lever is held depressed.

3) The machine resumes normal feed stitching the moment the switch lever is released.

#### 2. 开关的高度 Height of the switch



注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



**Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.**

- 1) 开关①有两挡位置可以使用；
- 2) 想把开关①的位置再下降时，请拧松缝纫机背面的固定螺钉③，降下开关座④。

1) Switch ① can be used in two positions by turning it.

2) In addition, when you desire to lower the position of switch ①, loosen setscrew ③ located in the back of the machine head and lower switch base ④.

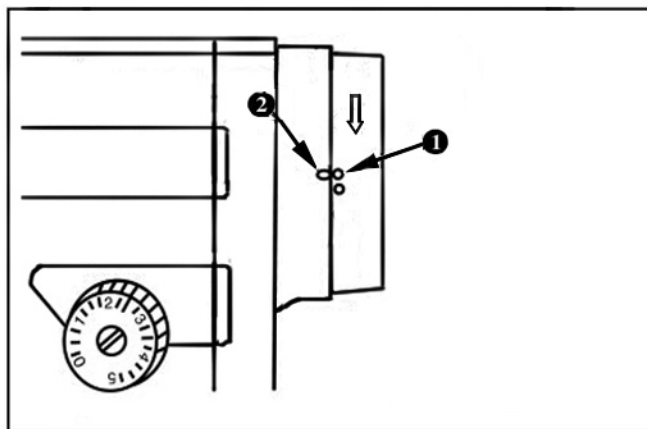
## 22. 拔线杆 Wiper



注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



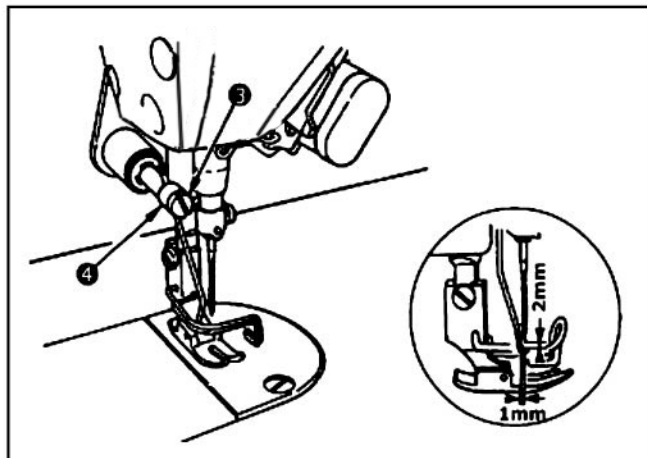
**Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.**



### 1. 拔线杆的位置

拔线杆的位置根据布料的厚度按下列方法进行调节

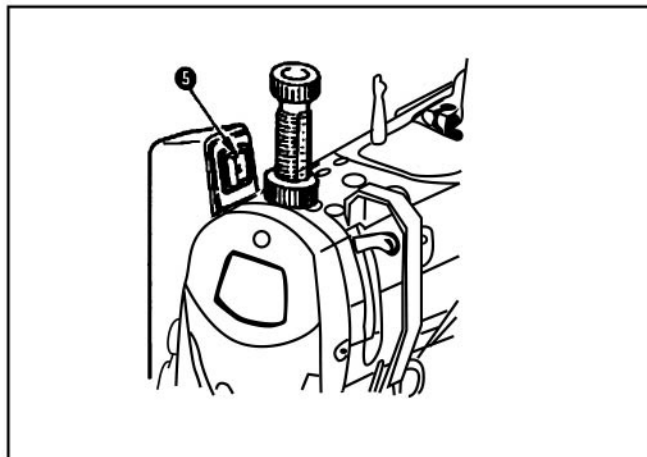
- 1) 向正常方向转动飞轮，让飞轮白刻点①对准机壳的刻点②。
- 2) 用拔线杆环④推拔线杆，然后拧紧固定螺钉③，把挑线杆的平坦部和机针中心的距离相距离1mm；
- 3) 不使用拔线杆时，请关掉拔线杆开关



### 1. Positioning the wiper

Adjust the position of the wiper according to the thickness of the material sewn. The adjustment procedure is as follows:

- 1) Turn the hand-wheel in the normal direction of rotation to align white marker dot ① on the hand-wheel with marker dot ② on the machine arm.
- 2) Adjust the distance between the flat part of the wiper and the center of the needle to 1mm. Tighten wiper adjust screw ③ so that the wiper is pressed and fixed by wiper collar ④.
- 3) When the wiper is unnecessary, turn wiper switch ⑤ OFF.



## 23. 机针与旋梭的关系 Needle-to-hook relationship

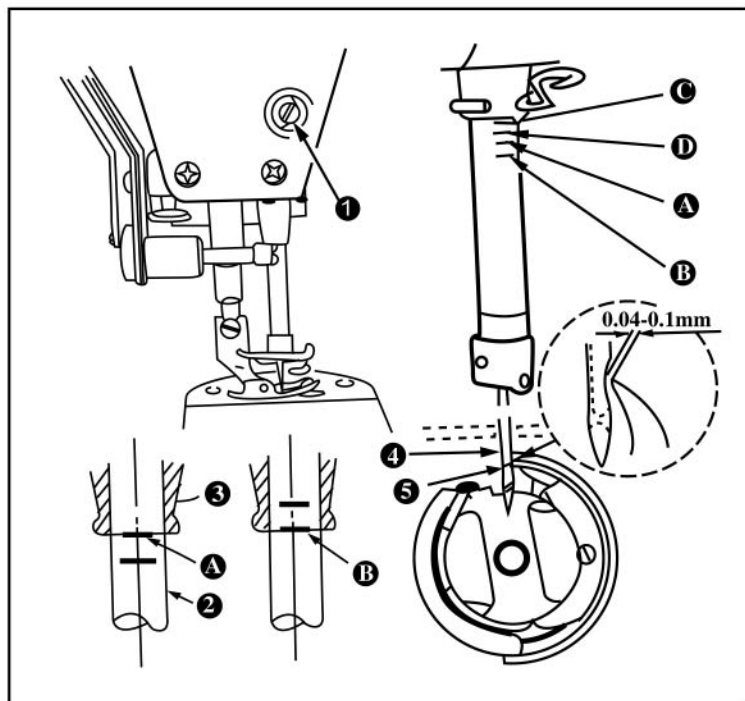


注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



**Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.**

1. 转动上轮，使针杆下到最低点，然后拧松针杆连接柱紧固螺钉①；
2. 确定针杆高度：
  - 1) 使用DB针时，使针杆②上的刻线Ⓐ对准针杆下轴套③的下端，然后拧紧针杆连接柱定位螺钉①；
  - 2) 使用DA针时，使针杆②上的刻线Ⓒ对准针杆下轴套③的下端，然后旋紧针杆连接柱定位螺钉①。
3. 确定旋梭位置：
  - 1) 使用DB针时，旋松三颗旋梭定位螺钉，并转动上轮，使针杆②在上升的方向刻线Ⓔ



- 对准针杆下轴套③的下端；
- 2) 使用DA针时，旋松三颗旋梭定位螺钉，并转动上轮，使针杆②在上升的方向刻线Ⓒ对准针杆下轴套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（大约）毫米，然后拧紧旋梭紧固螺钉。

注意：

1. 若间隙太小，会磨损梭尖；若间隙太大，会引起跳针；
2. 旋梭损坏后更换，请使用相同的型号。

1. Turn the hand-wheel to bring the needle bar down to the lowest point of its stroke, and loosen setscrew ①.
2. Adjusting the needle bar height:
  - 1) While using DB needle, align marker line ⑥ with the bottom end of needle bar lower bushing ③, then tighten setscrew ①.

- 2) While using DA needle, align marker line ㉞ with the bottom end of needle bar lower bushing ㉟, then tighten setscrew ㊱.
3. Locate the hook position:
  - 1) While using DB needle, loosen the three hook set screw, turn the hand-wheel, and align marker line ㉞ on ascending needle bar 2 with the bottom end of needle bar lower bushing ㉟.
  - 2) While using DA needle, loosen the three hook set screw, turn the hand-wheel, and align marker line ㉞ on ascending needle bar 2 with the bottom end of needle bar lower bushing ㉟.
4. After making the adjustments mentioned in the above steps, align hook blade point ㊲ with the center of needle ㊳. Provide a clearance of 0.04mm to 0.10mm(reference value) between the needle and the hook, then securely tighten setscrews in the hook.

Caution:

1. If the clearance between the blade point of hook and the needle is smaller than the specified value, the blade point of hook will be damaged. If the clearance is larger, stitch skip-ping will result.
2. Use a hook of the same part No. when replacing your hook with a new one.

## 24. 定刀的研磨与更换(平刀)

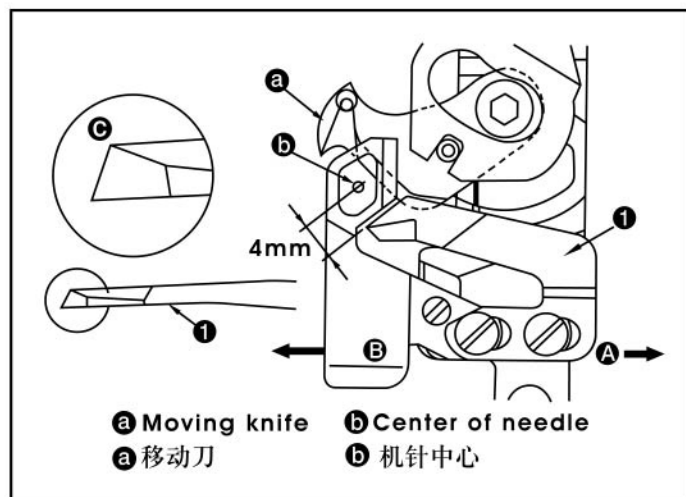
### Change of counter knife (Parallel knife)



注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



**Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.**



切刀不快时，请尽早如图㉞所示研磨固定刀㉟，然后正确的安装好。

- 1) 把固定刀的安装位置往标准位置的右㉞方向移动，切线长度比标准位置时长；
- 2) 往左㉞方向移动，切线变短。

注意：研磨固定刀时请注意研磨方法。



When the knife sharpness has deteriorated, re-sharpen counter knife ① as illustrated in ㉞, and properly reinstall it.

- 1) If the mounting position of the counter knife is moved in direction ㉞ from the standard mounting position, the thread length after thread trimming will be increased accordingly.
- 2) If the mounting position is moved in direction ㉞, the thread length will be decreased accordingly.

**Caution:** When re-sharpening the knife blade, extra special care must be taken on the handling of the knife.

## 25. 定刀和动刀的研磨与更换(旋刀)

### Change of counter knife and moving knife (Rotation knife)

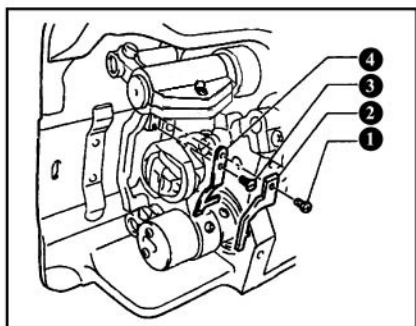


注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



**Warning:** Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

#### 25.1 固定刀

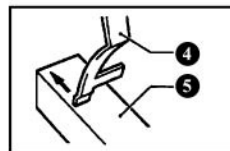


1. 放倒机头。
2. 松掉螺钉①，拆下旋梭定位钩②。
3. 松掉螺钉③，取出固定刀④。

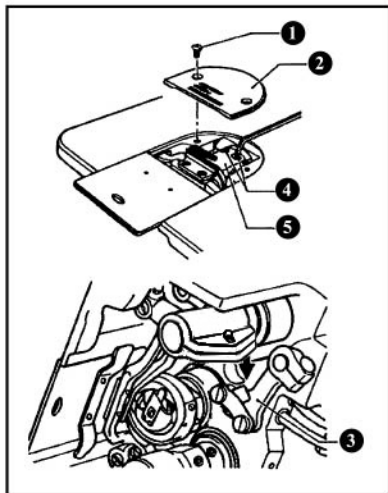
\* 安装方法 请按照上面的相反步骤进行。

固定刀的研磨方法

如刀具变钝，按图示在油石⑤上磨快固定刀④。



#### 25.2 动刀



1. 取下机针。
2. 用抬压脚扳手抬起压脚。
3. 松掉螺钉①[2个]，然后取出针板②。
4. 转动手轮，将针杆上升至最高的位置。
5. 放倒机头。
6. 按箭头所示方向推动切线驱动曲柄③直至看到螺钉④的位置。
7. 松掉螺钉④[2个]，然后取出动刀⑤。

\* 安装方法 请按照上面的相反步骤进行。

## 26. 剪线装置的调整 (旋刀)

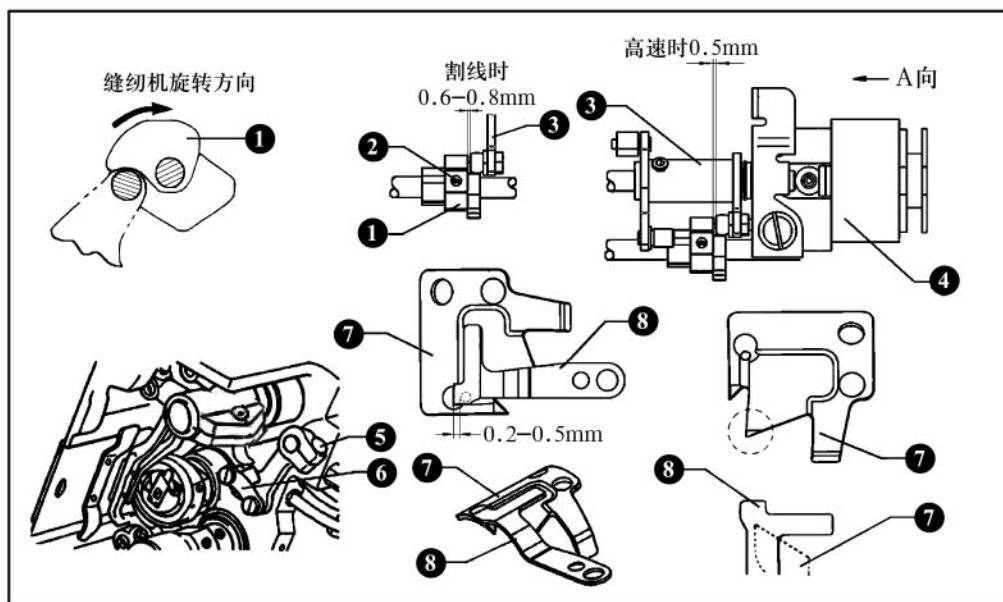
### Adjustment of trimming system (Rotation knife)



注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



#### (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，用手沿A方向压紧剪线电磁铁④的铁芯，在电磁铁④的作用下，切线凸轮曲柄组件③中的滚珠被压进剪线凸轮①的凹部，临时旋紧剪线凸轮①中螺钉②，放开电磁铁铁芯，电磁铁④复位。旋松螺钉②，左右调整剪线凸轮①位置，使剪线凸轮①右端面与滚珠左端面间隙为0.5mm，旋紧螺钉②，完成剪线凸轮①位置的调节。

#### (二) 动刀、定刀位置调节

压紧电铁铁芯，切线凸轮曲柄组件③中滚珠进入剪线凸轮①凹部，转动上轮，当刀轴连杆⑥带动动刀⑦做剪线动作时，定刀⑧前端与动刀⑦刃口应当啮合0.2-0.5mm。如果没有啮合，旋松螺钉⑤，移动刀轴连杆⑥使定刀⑧的前端与动刀⑦的刃部啮合。动刀⑦、定刀⑧位置调节后要能保证在手动剪线时能剪断203棉线。

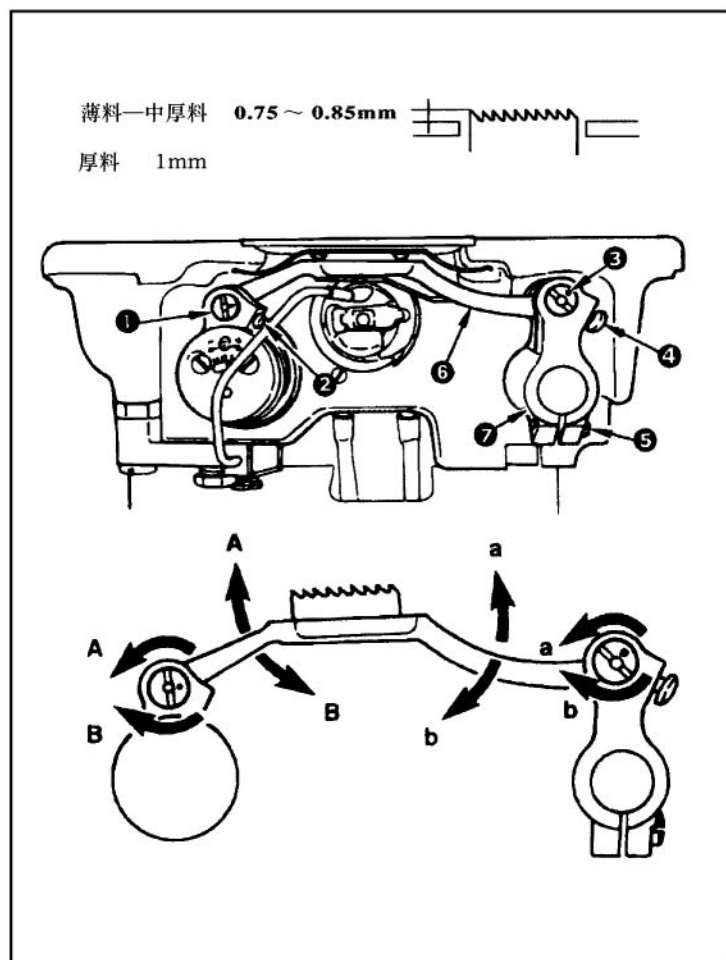
## 27. 送料牙的高度和倾斜度 Height and tilt of the feed dog



注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



送料牙的高度是高出针板0.75-0.85mm(厚料为1mm), 请根据布料的具体情况调节适当的高度。

1. 送料牙的高度和倾斜度的调整

- 1) 拧松抬牙曲柄调节偏心销①紧定螺钉②以及牙架座偏心销③的紧定螺钉④；
- 2) 用螺丝刀转动①、③两销，就可以改变送料牙的高度和倾斜度；
- 3) 有关各销的转动方向和牙架⑥的倾斜度关系请参照图示；
- 4) 调整后，请把拧松的螺钉拧紧固定。（请在推住①、③偏心销的状态下拧紧②、④两颗紧定螺钉）

注意：

1. 如果只用一侧的偏心销来调整送料牙的倾斜度，送料牙的高度也会变化，所以请一定要用两侧的销来调整。
2. 如果调整销位置之后，送料牙的运动位置偏斜，请拧松牙架座⑦的紧定螺钉⑤，调整送料牙的运动位置。

Height of the feed dog is adjusted so that the feed dog protrudes from the throat plate surface by 0.75 to 0.85 mm (1 mm for Heavy type). Adjust the height in accordance with the material to be used.

### 1. Adjusting the height and tilt of the feed dog

- 1) Loosen setscrew ② in feed bar driving shaft ① and setscrew ④ in feed bar rocker shaft ③
- 2) Height and tilt of the feed dog will change by turning both shafts ① and ③ with a screwdriver.
- 3) For the relation between the rotating direction of each shaft and tilt of feed bar ⑥, refer to the figure on the left.
- 4) After the adjustment, securely tighten the setscrews. (Tighten setscrews ② and ④ in the state that shafts ① and ③ are pushed against the hand-wheel side.)

#### Caution:

1. If the tilt of the feed dog is adjusted with one shaft only, the height of the feed dog changes. Be sure to adjust it with both shafts.
2. Movement position of the feed dog may be shifted depending on the adjusting position of the shaft. At this time, loosen setscrew ⑤ in feed rocker shaft arm ⑦ and adjust the movement position.

## 28. 送布的同步 Adjusting the feed timing



注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



**Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.**

改变抬牙凸轮①的固定位置，就可以改变送料的同步时间。

送料同步的调整方法：

1. 放倒缝纫机，拧松抬牙凸轮①的两颗固定螺钉②；
  2. 转动抬牙凸轮①，就可以变更送布的同步时间。  
把抬牙曲柄的刻度③对准抬牙轴的刻线④
- 向（+）方向转动抬牙凸轮①，上下抬牙的同步时间变快；
  - 向（-）方向转动抬牙凸轮①，上下抬牙的同步时间变慢。

注意：一般情况，请把刻度③的中央对准刻线。

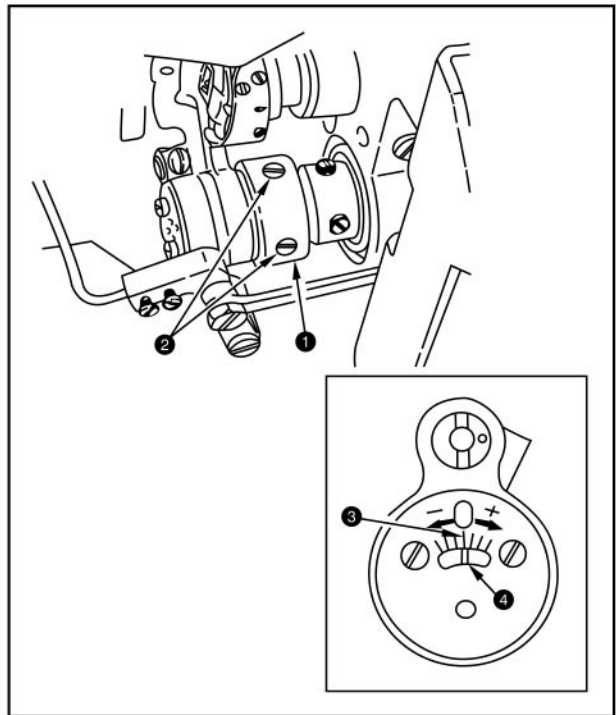
The feed timing can be changed by changing the stop position of feed eccentric cam ①.

### How to adjust the feed timing

1. Tilt the sewing machine head and loosen two setscrews ② in feed eccentric cam ①.
2. Turn feed eccentric cam ① to change the feed timing.

Align graduation ③ on the feed bar driving arm with engraved marker line ④ on the feed driving shaft.

- Turn feed eccentric cam ① in the direction of (+) → Increases the feed timing.
- Turn feed eccentric cam ① in the direction of (-) → Decreases the feed timing.



**Caution:** For general use, use the machine in the state that center of graduation ③ is aligned with the engraved marker line.

## 29. 解除机构

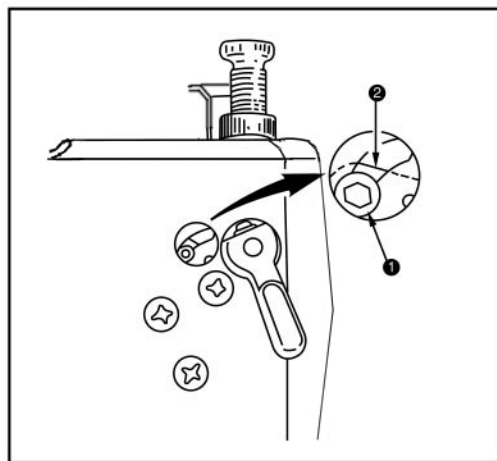
### Thread tension release releasing mechanism



注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



**Warning:** Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



利用松线解除机构，缝制中也可以提升面线也不松线。（厚的叠层部用膝动提升压脚，让它越过叠层部，而线张力不变化）

#### 1. 解除方法

- 1) 卸下缝纫机的盖子，用内六角扳手拧松松线变换螺钉①；
- 2) 把螺钉①固定到松线变换板②的最上部。  
抬起压脚时夹线器也不松线，面线张力也不松弛（只在切线时夹线器才松线）

注意：螺钉①的位置，只能固定到松线变换板的最上或最下位置，其它位置不能使用。  
缝纫机出货时固定在最下位置。

By means of the thread tension release releasing mechanism, sewing can be performed without slackening the needle thread tension even when the presser foot is lifted during sewing. (Even when the presser foot is slightly lifted at the thick overlapped section by the knee lifter, this mechanism can prevent the thread tension from being changed.)

### 1. How to release

- 1) Remove the cap in the machine head and loosen thread tension release changeover screw ① using a hexagon wrench.
- 2) Fix screw ① on the top of thread tension release changeover plate ②. The thread tension disk does not rise even when the presser foot is lifted, and the needle thread tension is not loosened. (The thread tension disk rises only when thread trimming is performed.)

**Caution:** Do not use screw ① at any position other than the top or bottom position of the thread tension release changeover plate. The screw has been factory-set to the bottom position at the time of delivery.

## 30. 微量压脚提升

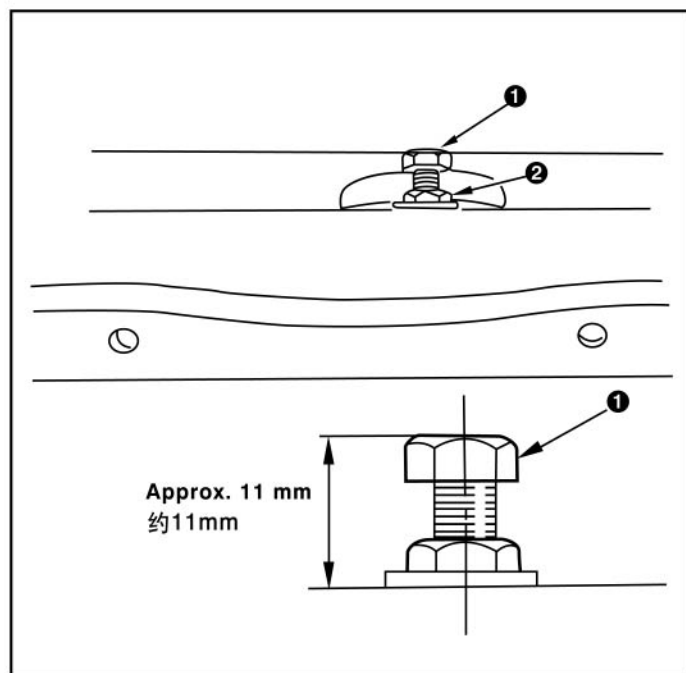
### Micro-lifting mechanism of the presser foot



注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



**Warning:** Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



缝制丝绒等起毛性缝料时，使用微量压脚提升螺钉①功能就可以不使缝料缝偏，减轻缝料的损伤。

在螺母②拧松的状态下，一点一点拧紧微量压脚提升螺钉①，调整到适合缝料的让压脚微量上升的位置，然后将螺母②固定。

注意：微量压脚提升机构不使用时，请把螺钉①高度调整到比缝纫机高约11mm的位置。微量压脚提升机构提升后缝纫机的送布能力会减弱。

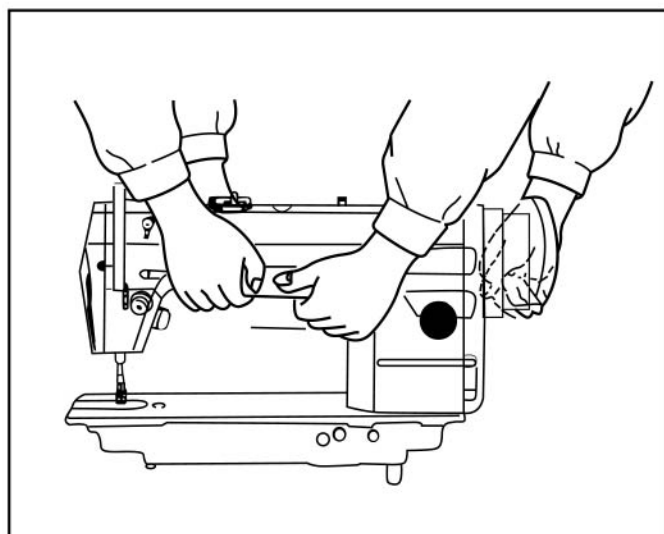
When sewing velvet or the like which is fluffy, slippage of material or damage of material is reduced by using screw ① for presser foot micro-lifting.

Gradually tighten screw ① for presser foot micro-lifting in the state that nut ② is loosened, adjust the presser foot to the position where it is finely lifted until it matches the material, and fix it with nut ②.

**Caution:** when the presser foot micro-lifting mechanism is not used, adjust the height of screw ① so that it is higher by approximately 11 mm than the sewing machine. If the sewing machine is operated in the state that the micro-lifting mechanism is working, sufficient feed force cannot be obtained.

### 31. 缝纫机的搬运及放置注意事项

#### Caution when carrying or placing the sewing machine



#### 1. 搬运方法

请按照图示那样，由两人来搬运

注意：请不要抬着皮带轮来搬运

#### 2. 放置缝纫机时的注意事项

请不要把螺丝刀等东西放到放置缝纫机的地方。

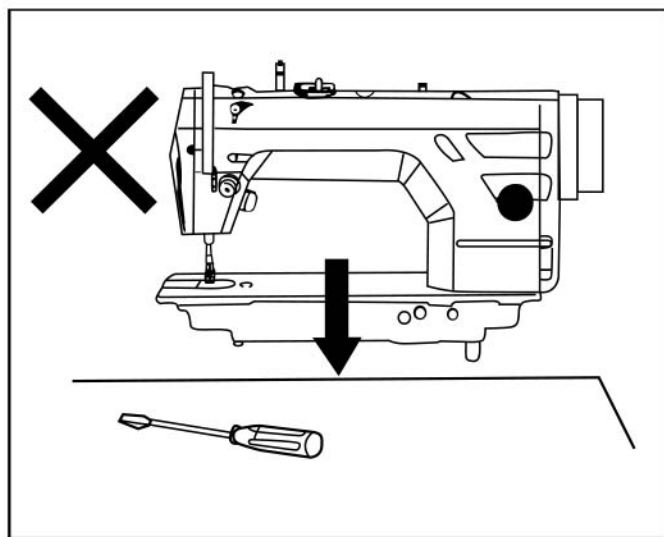
#### 3. How to carry the sewing machine

Carry the sewing machine with two persons as shown in the figure.

**Caution:** Do not hold the hand-wheel.

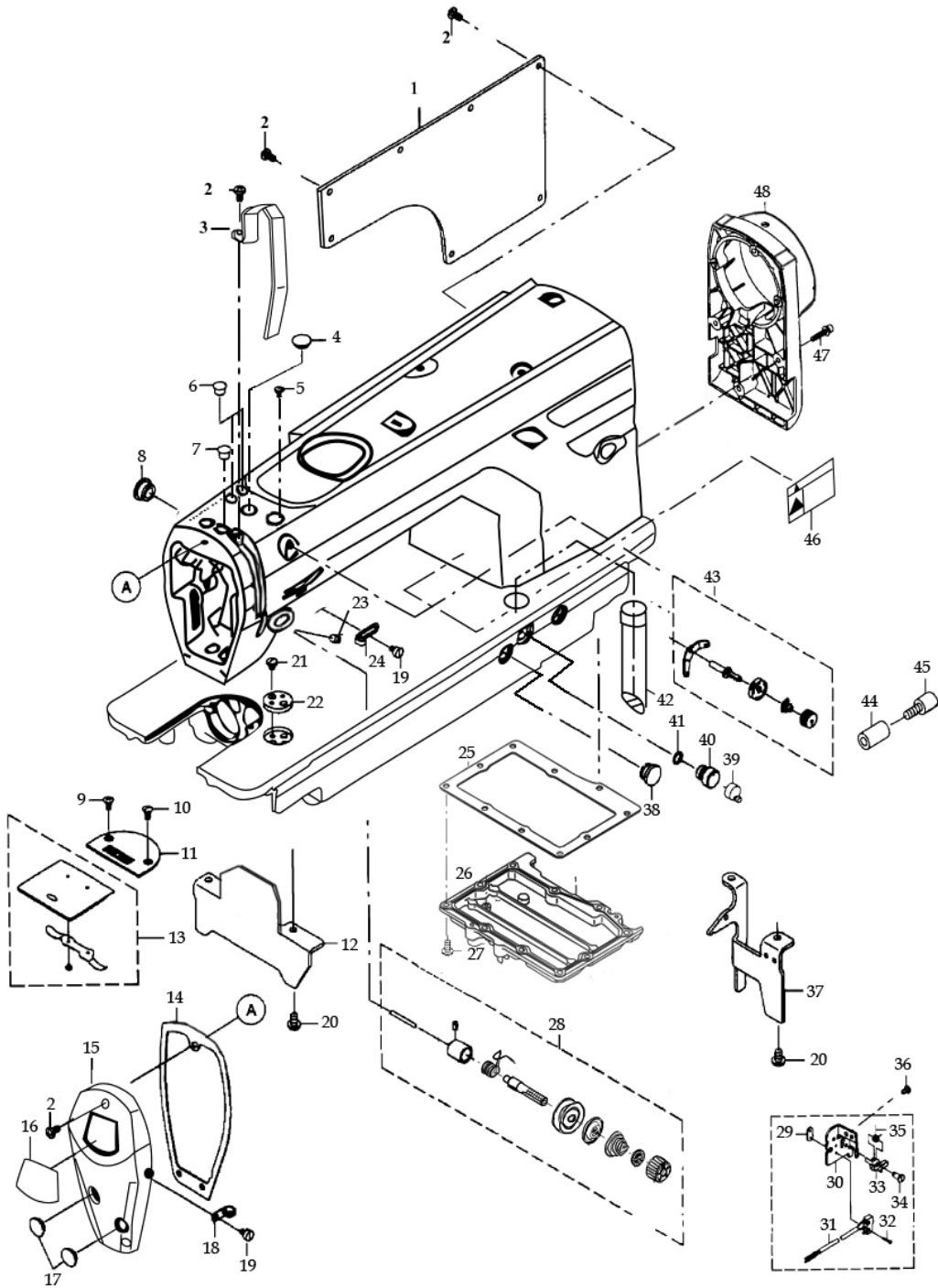
#### 4. Caution when placing the sewing machine

Do not place any protruding thing such as screwdriver or the like on the place where the sewing machines is set.



# 1、机体部件

## MACHINE FRAME & MISCELLANEOUS COVER COMPONENTS





## 1、机体部件

## MACHINE FRAME&amp;MISCELLANEOUS COVER COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称      | Name of the part           | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|---------|----------------------------|------------|-----------|----|
| 1         | 20003404       | 后盖板     | Side Plate                 | 1          | ☆         |    |
| 2         | 10008972       | 螺钉      | Screw 3/16-28 L=10         | 12         | ☆         |    |
| 3         | 20003407       | 挑线杆防护罩  | Thread Take-Up Lever Cover | 1          | ☆         |    |
| 4         | 10012136       | 橡胶塞     | Rubber Plug D=12.8 L=4     | 1          | ☆         |    |
| 5         | 10010666       | 螺钉      | Screw 11/64-40 L=14        | 1          | ☆         |    |
| 6         | 10008943       | 橡胶塞     | Rubber Plug                | 2          | ☆         |    |
| 7         | 10012460       | 针杆上套橡皮塞 | Rubber Plug                | 1          | ☆         |    |
| 8         | 10012147       | 橡胶塞     | Rubber Plug                | 1          | ☆         |    |
| 9         | 10009005       | 螺钉      | Screw 11/64-40 L=8.5       | 1          | ☆         |    |
| 10        | 10012463       | 螺钉      | Screw 11/64-40 L=8.5       | 1          | ☆         |    |
| 11        | 10012131       | 针板      | Needle Plate               | 1          | ☆         |    |
|           | 10014459       | 针板      | Needle Plate               | 1          |           | ☆  |
| 12        | 10012135       | 前支撑板    | Front Plate                | 1          | ☆         |    |
| 13        | 10013706       | 推板部件    | Slide Plate ASM            | 1          | ☆         |    |
| 14        | 10013009       | 面板垫     | Face Plate Packing         | 1          | ☆         |    |
| 15        | 20003406       | 面板      | Face Plate                 | 1          | ☆         |    |
| 16        | 10005468       | 面板装饰牌   | Face Plate Adorning        | 1          | ☆         |    |
| 17        | 10008977       | 橡胶塞     | Rubber Plug D=12.5 L=4     | 2          | ☆         |    |
| 18        | 10008937       | 左线钩     | Arm Thread Guide B         | 1          | ☆         |    |
| 19        | 10008973       | 螺钉      | Screw 11/64-40 L=6         | 2          | ☆         |    |
| 20        | 10012142       | 螺钉      | Screw 15/64-28 L=9         | 4          | ☆         |    |
| 21        | 10004374       | 螺钉      | Screw 11/64-40 L=4.8       | 2          | ☆         |    |
| 22        | 10004373       | 限位挡片    | Ruler Stop Seat            | 1          | ☆         |    |
| 23        | 10010593       | 螺钉      | Screw 15/64-28 L=7.5       | 1          | ☆         |    |
| 24        | 10008940       | 右线钩     | Arm Thread Guide A         | 1          | ☆         |    |
| 25        | 10012143       | 箱盖密封垫   | Gear Box Packing           | 1          | ☆         |    |
| 26        | 10012145       | 齿轮箱盖    | Gear Box Cover             | 1          | ☆         |    |
| 27        | 10012146       | 螺钉      | Screw 3/16-28 L=15         | 10         | ☆         |    |
| 28        | 10013000       | 夹线器组件   | Thread Tension ASM         | 1          | ☆         |    |
|           | 10012476       | 夹线器组件   | Thread Tension ASM         | 1          |           | ☆  |
| 29        | 10005877       | 螺母      | Nut                        | 1          | ☆         |    |
| 30        | 10006133       | 保险开关体   | Safety Switch Base         | 1          | ☆         |    |
| 31        | 10006284       | 保险开关    | Safety Switch              | 1          | ☆         |    |
| 32        | 10003052       | M2×12螺钉 | Screw                      | 2          | ☆         |    |
| 33        | 10006132       | 保险开关支架  | Safety Switch Arm          | 1          | ☆         |    |
| 34        | 10012612       | 保险开关支架轴 | Safety Switch Arm Shaft    | 1          | ☆         |    |
| 35        | 10005855       | 弹簧      | Spring                     | 1          | ☆         |    |
| 36        | 10013608       | 螺钉      | Screw                      | 1          | ☆         |    |
| 37        | 10012148       | 后支撑板    | Back Plate                 | 1          | ☆         |    |
| 38        | 10012128       | 橡胶塞     | Rubber Plug                | 1          | ☆         |    |
| 39        | 10008771       | 橡胶盖     | Air-Discharging Cap        | 1          | ☆         |    |
| 40        | 10012141       | 排气阀     | Air-Discharging            | 1          | ☆         |    |
| 41        | 10012139       | O型圈     | Rubber Ring                | 1          | ☆         |    |
| 42        | 10012138       | 齿轮箱油标   | Gear Box Floater ASM       | 1          | ☆         |    |
| 43        | 10012867       | 上夹线器部件  | Thread Tension Guide       | 1          | ☆         |    |
| 44        | 10013621       | 倒缝板手螺柱套 | Reverse Feed Lever Stopper | 1          | ☆         |    |
| 45        | 10012149       | 螺钉      | Screw 9/64-40              | 1          | ☆         |    |

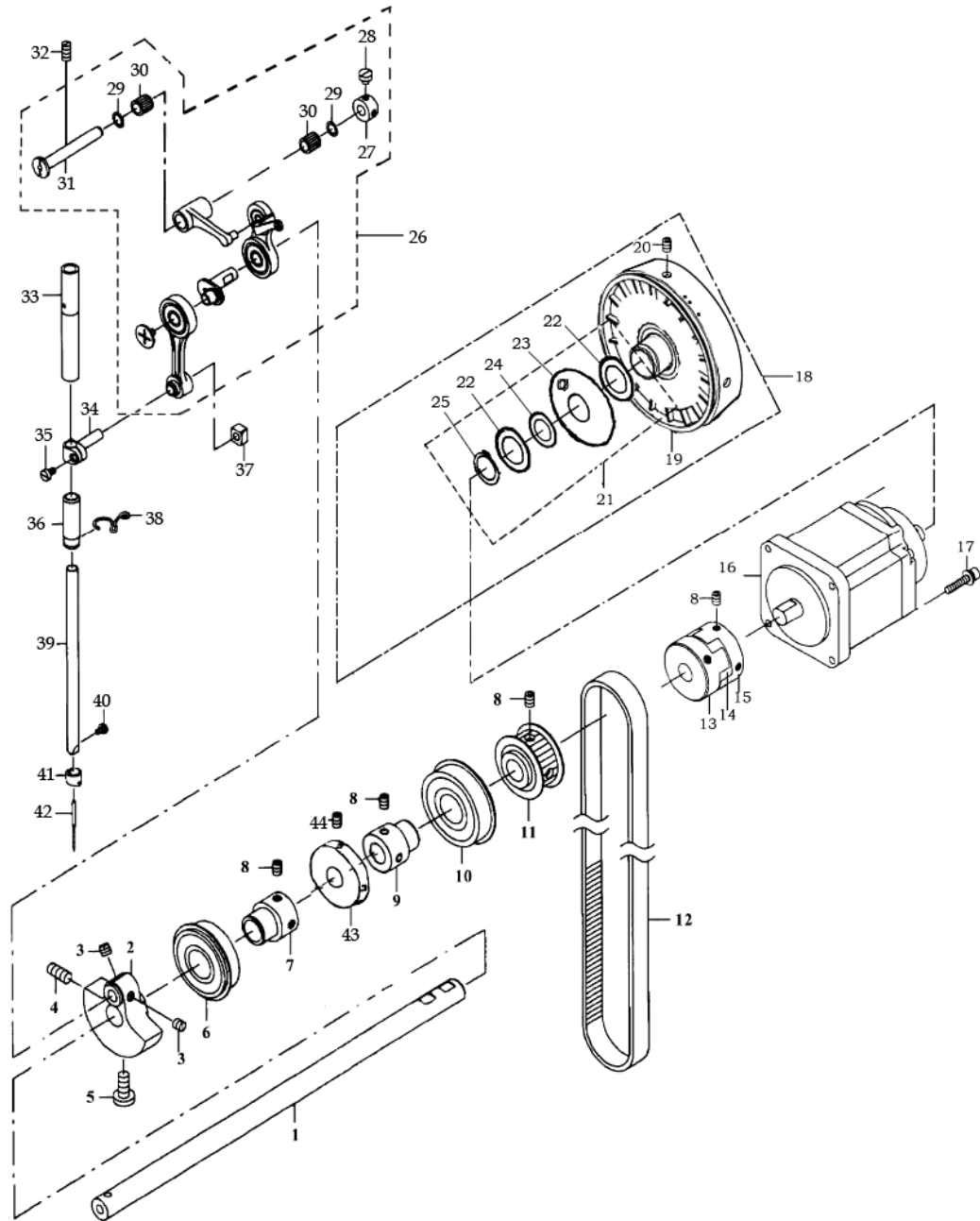
1、机体部件

MACHINE FRAME&MISCELLANEOUS COVER COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称      | Name of the part | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|---------|------------------|------------|-----------|----|
| 46        | 10008936       | 机头安全提示牌 | Safety Label     | 1          | ☆         |    |
| 47        | 10006157       | 螺钉组件    | Bolt             | 5          | ☆         |    |
| 48        | 10006174       | 后盖      | Back Cover       | 1          | ☆         |    |

## 2、上轴部件

### MAIN SHAFT & NEEDLE BAR COMPONENTS



## 2、上轴部件

## MAIN SHAFT &amp; NEEDLE BAR COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称           | Name of the part           | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|--------------|----------------------------|------------|-----------|----|
| 1         | 10012663       | 上轴           | Main Shaft                 | 1          | ☆         |    |
| 2         | 10012607       | 针杆曲柄         | Needle Bar Crank           | 1          | ☆         |    |
| 3         | 10005020       | 螺钉           | Screw 1/4-40 L=6           | 2          | ☆         |    |
| 4         | 10010082       | 螺钉           | Screw 9/32-28 L=16         | 1          | ☆         |    |
| 5         | 10010545       | 螺钉           | Screw 9/32-28 L=16         | 1          | ☆         |    |
| 6         | 10009781       | 6204ZZNRC3轴承 | Bearing                    | 1          | ☆         |    |
| 7         | 10012668       | 轴承套          | Bearing Support            | 1          | ☆         |    |
| 8         | 10009187       | M6×8螺钉       | Screw M6 L=8               | 6          | ☆         |    |
| 9         | 10012611       | 轴承套          | Bearing Support            | 1          | ☆         |    |
| 10        | 10009791       | 6304ZZNRC3轴承 | Bearing                    | 1          | ☆         |    |
| 11        | 10006241       | 上轴同步齿形带轮组件   | Sprocket, Upper            | 1          | ☆         |    |
| 12        | 10014095       | 齿形带          | Timing Belt                | 1          | ☆         |    |
| 13        | 10012613       | 联轴器          | Coupling Joint             | 1          | ☆         |    |
| 14        | 10011227       | 传动连接橡胶块      | Connecting Rubber Block    | 1          | ☆         |    |
| 15        | 10012615       | 联轴器          | Coupling Joint             | 1          | ☆         |    |
| 16        | 10006316       | 小型伺服马达       | Motor                      | 1          | ☆         |    |
| 17        | 10006157       | 螺钉组件         | Bolt                       | 4          | ☆         |    |
| 18        | 20002766       | 上轮组件         | Head Wheel ASM             | 1          | ☆         |    |
| 19        | 20003408       | 上轮           | Head Wheel                 | 1          | ☆         |    |
| 20        | 10002436       | M5×8螺钉       | Screw M6 L=8               | 2          | ☆         |    |
| 21        | 10023937       | 停针装置         |                            | 1          | ☆         |    |
| 22        | 10003845       | 垫圈           | Washer                     | 2          | ☆         |    |
| 23        | 10006898       | 停针磁铁组件       | Separate Parcel            | 1          | ☆         |    |
| 24        | 10003364       | 波形垫圈         | Spring Washer              | 1          | ☆         |    |
| 25        | 10003365       | 挡圈           | E-Ring                     | 1          | ☆         |    |
| 26        | 10012458       | 挑线杆组件        | Thread Take-Up Asm         | 1          | ☆         |    |
|           | 10013011       | 挑线杆组件        | Thread Take-Up Asm         | 1          |           | ☆  |
| 27        | 10005745       | 挡圈           | Thrust Collar              | 1          | ☆         |    |
| 28        | 10013590       | 螺钉           | Screw 11/64-40 L=4         | 2          | ☆         |    |
| 29        | 10005786       | 7×10×1.2挡圈   | Bearing Support            | 2          | ☆         |    |
| 30        | 10005747       | K7×10×9.7轴承  | Bearing                    | 2          | ☆         |    |
| 31        | 10005794       | 挑线连杆铰链轴      | Thread Take-Up Crank Shaft | 1          | ☆         |    |
| 32        | 10010083       | 螺钉           | Screw 15/64-28             | 1          | ☆         |    |
| 33        | 10013790       | 针杆上套         | Needle Bar Metal Upper     | 1          | ☆         |    |
| 34        | 10010590       | 针杆连接柱        | Needle Rod Holder          | 1          | ☆         |    |
| 35        | 10010643       | 螺钉           | Screw 9/64-40              | 1          | ☆         |    |
| 36        | 10012493       | 针杆下套         | Needle Bar Metal Lower     | 1          | ☆         |    |
|           | 10013188       | 针杆下套         | Needle Bar Metal Lower     | 1          |           | ☆  |
| 37        | 10010586       | 针杆连接柱滑块      | Slide Block                | 1          | ☆         |    |
| 38        | 10010638       | 针杆下轴套线钩      | Needle Bar Thread Guide    | 1          | ☆         |    |
| 39        | 10006378       | 针杆           | Needle Bar                 | 1          | ☆         |    |
|           | 10021346       | 针杆           | Needle Bar                 | 1          |           | ☆  |
| 40        | 10013182       | 螺钉           | Screw                      | 1          | ☆         |    |
| 41        | 10013181       | 针杆过线环        | Needle Bar Thread Guide    | 1          | ☆         |    |
|           | 10012614       | 针杆过线环        | Needle Bar Thread Guide    | 1          |           | ☆  |
| 42        | 10004898       | DB×114#风琴机针  | Needle                     | 1          | ☆         |    |
|           | 10004868       | DP×518#风琴机针  | Needle                     | 1          |           | ☆  |

## 2、上轴部件

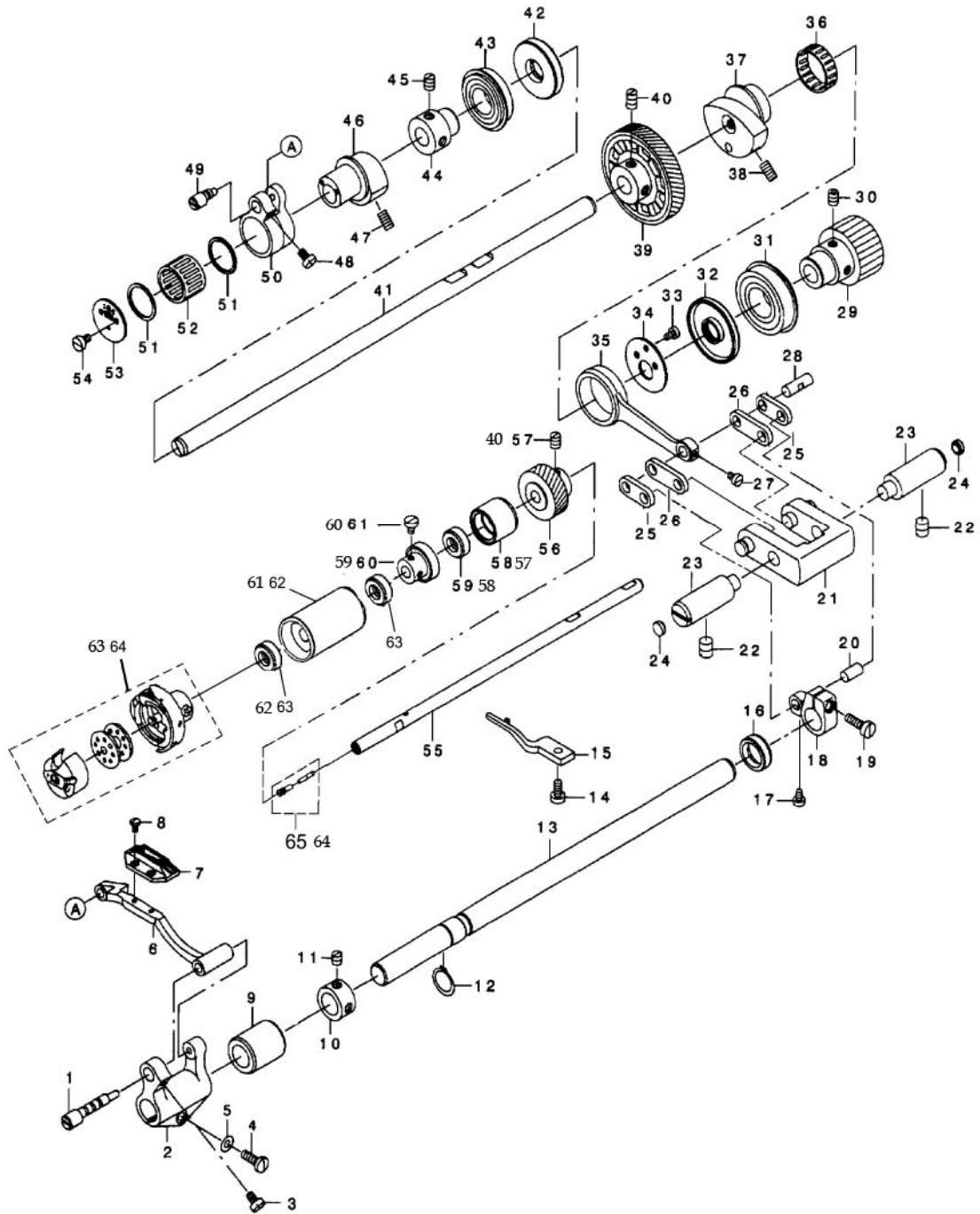
## MAIN SHAFT &amp; NEDDLE BAR COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称    | Name of the part            | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|-------|-----------------------------|------------|-----------|----|
| 43        | 10013112       | 绕线驱动轮 | Bobble Winder Driving Wheel | 1          | ☆         |    |
| 44        | 10011062       | 螺钉    | Screw 11/64-40              | 2          | ☆         |    |

### 3.1 下轴送料部件 (平刀)

#### HORIZONTAL FEED & VERTICAL FEED AND

#### HOOK DRIVING SHAFT COMPONENTS (Parallel knife)



### 3.1、下轴送料部件

#### HORIZONTAL FEED & VERTICAL COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称           | Name of the part           | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|--------------|----------------------------|------------|-----------|----|
| 1         | 10012490       | 销            | Feed Rocker Base Shaft     | 1          | ☆         |    |
| 2         | 10012540       | 牙架座          | Feed Rocker Base Arm       | 1          | ☆         |    |
| 3         | 10010074       | 螺钉           | Screw 11/64-40 L=7         | 1          | ☆         |    |
| 4         | 10025329       | 螺钉           | Screw 3/16-28 L=15         | 1          | ☆         |    |
| 6         | 10012531       | 牙架组件         | Feed Base                  | 1          | ☆         |    |
| 7         | 10025331       | 送料牙          | Feed Dog                   | 1          | ☆         |    |
|           | 10012982       | 送料牙          | Feed Dog                   | 1          |           | ☆  |
| 8         | 10010099       | 螺钉           | Screw 1/8-44 L=6           | 2          | ☆         |    |
| 9         | 10012494       | 轴套           | Feed Rocker Shaft Metal    | 1          | ☆         |    |
| 10        | 10010542       | 挡圈           | Main Shaft Thrust Collar   | 1          | ☆         |    |
| 11        | 10005020       | 螺钉           | Screw 1/4-40 L=6           | 2          | ☆         |    |
| 12        | 10003290       | 挡圈           | E-Ring                     | 1          | ☆         |    |
| 13        | 10012640       | 送料轴          | Feed Rocker Shaft Metal    | 1          | ☆         |    |
| 14        | 10010066       | 螺钉           | Screw 11/64-40 L=9.5       | 1          | ☆         |    |
| 15        | 10012530       | 旋梭定位钩        | Bobbin Case Holder         | 1          | ☆         |    |
| 16        | 10012536       | 油封           | Oil Seal                   | 1          | ☆         |    |
| 17        | 10010071       | 螺钉           | Screw 9/64-40              | 1          | ☆         |    |
| 18        | 10012492       | 送料后曲柄        | Feed Rocker Arm            | 1          | ☆         |    |
| 19        | 10010095       | 螺钉           | Screw 3/16-28 L=15.5       | 1          | ☆         |    |
| 20        | 10010096       | 销            | Walking Foot Pin B         | 1          | ☆         |    |
| 21        | 10012500       | 送料摆动座组件      | Adjusting Link ASM         | 1          | ☆         |    |
| 22        | 10010593       | 螺钉           | Screw 15/64-28             | 2          | ☆         |    |
| 23        | 10012532       | 销            | Adjusting Link ASM Fulcrum | 2          | ☆         |    |
| 24        | 10012495       | 橡胶塞          | Rubber Plug                | 2          | ☆         |    |
| 25        | 10010075       | 送料短摆动板       | Connecting Link, B         | 2          | ☆         |    |
| 26        | 10012537       | 送料摆动座长连接板    | Connecting Link, A         | 2          | ☆         |    |
| 27        | 10010071       | 螺钉           | Screw 9/64-40              | 1          | ☆         |    |
| 28        | 10010069       | 销            | Walking Foot Pin C         | 1          | ☆         |    |
| 29        | 10012535       | 拾牙轴同步齿形带轮    | Lower Sprocket             | 1          | ☆         |    |
| 30        | 10009187       | M6×8螺钉       | Screw M6 L=8               | 2          | ☆         |    |
| 31        | 10003542       | 拾牙轴后轴承       | Bearing                    | 1          | ☆         |    |
| 32        | 10012538       | 油封           | Oil Seal                   | 2          | ☆         |    |
| 33        | 10010643       | 螺钉           | Screw 9/64-40 L=6          | 2          | ☆         |    |
| 34        | 10005742       | 送料偏心轮挡片      | Feed Rocker Cam Plate      | 1          | ☆         |    |
| 35        | 10005787       | 送布摆动连杆       | Feed Rocker Rod            | 1          | ☆         |    |
| 36        | 10005792       | K25×29×9.6轴承 | Needle Bearing             | 1          | ☆         |    |
| 37        | 10005740       | 送布偏心轮        | Feed Rocker Cam            | 1          | ☆         |    |
| 38        | 10010083       | 螺钉           | Screw 15/64-28 L=10.5      | 2          | ☆         |    |
| 39        | 10012462       | 齿轮           | Gear, Large                | 1          | ☆         |    |
| 40        | 10008862       | 螺钉           | Screw 1/4-40 L=5.8         | 4          | ☆         |    |
| 41        | 10012489       | 拾牙轴          | Feed Driving Shaft         | 1          | ☆         |    |
| 42        | 10012533       | 油封           | Oil Seal                   | 1          | ☆         |    |
| 43        | 10009782       | 拾牙轴轴承        | Bearing                    | 1          | ☆         |    |
| 44        | 10012501       | 轴承套          | Bearing Support            | 1          | ☆         |    |
| 45        | 10003921       | 螺钉           | Screw 1/4-40               | 2          | ☆         |    |
| 46        | 10005750       | 拾牙凸轮         | Feed Driving Cam           | 1          | ☆         |    |
|           | 10006135       | 拾牙凸轮         | Feed Driving Cam           | 1          |           | ☆  |

### 3.1、下轴送料部件

#### HORIZONTAL FEED & VERTICAL COMPONENTS

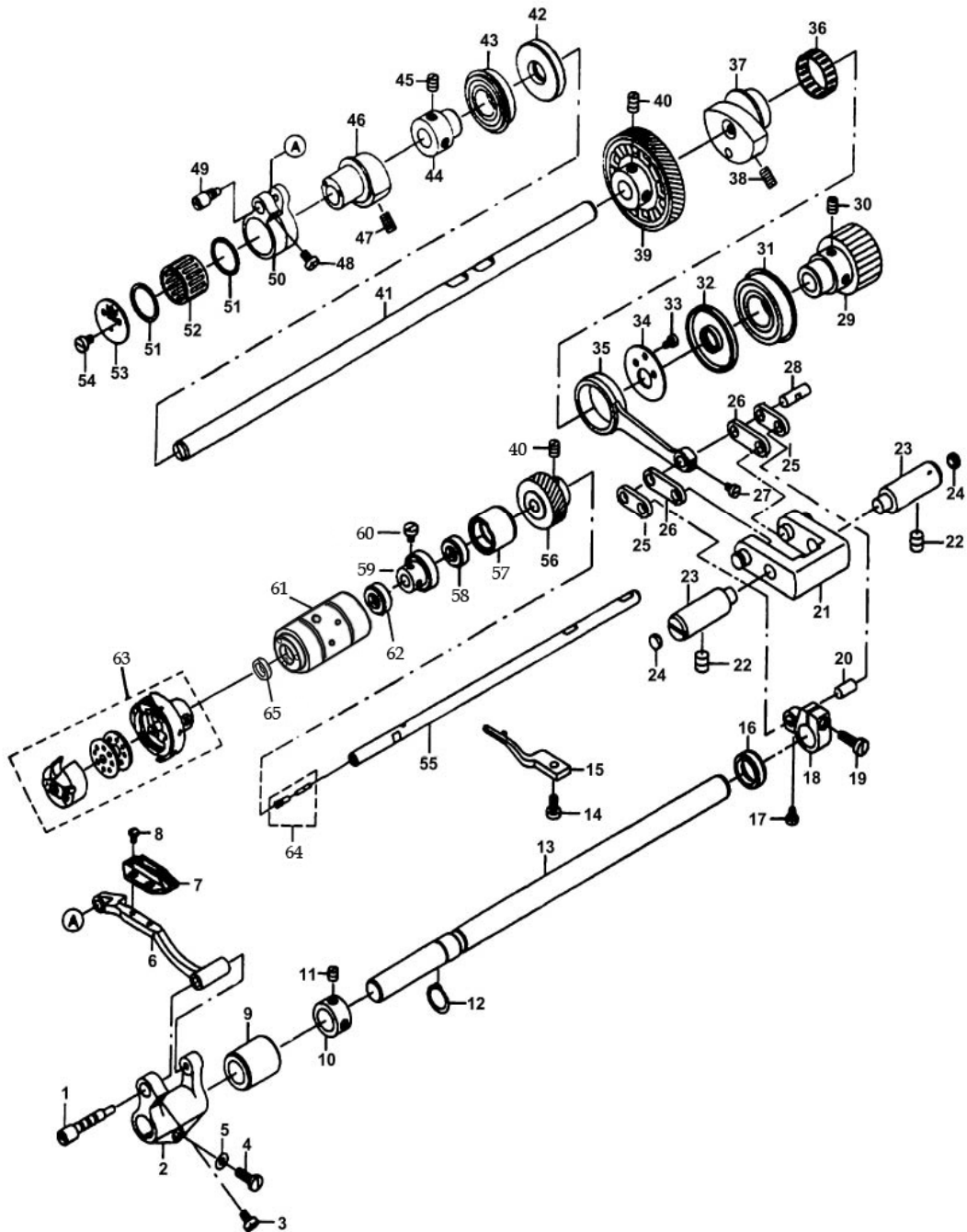
| 序号<br>No. | 件号<br>Part No. | 名称                    | Name of the part            | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|-----------------------|-----------------------------|------------|-----------|----|
| 47        | 10010083       | 螺钉                    | Screw 15/64-28              | 2          | ☆         |    |
| 48        | 10010074       | 螺钉                    | Screw 11/64-40              | 1          | ☆         |    |
| 49        | 10012498       | 销                     | Feed Driving Base Shaft     | 1          | ☆         |    |
| 50        | 10005789       | 拾牙曲柄                  | Feed Driving Base Arm       | 1          | ☆         |    |
| 51        | 10005790       | 挡圈                    | Feed Driving Cam Thrust BU  | 2          | ☆         |    |
| 52        | 10005744       | 轴承                    | Bearing                     | 1          | ☆         |    |
| 53        | 10012503       | 拾牙凸轮挡板                | Feed Driving Cam Plate      | 1          | ☆         |    |
| 54        | 10010643       | 螺钉                    | Screw 9/64-40               | 2          | ☆         |    |
| 55        | 10012534       | 下轴                    | Hook Shaft                  | 1          | ☆         |    |
| 56        | 10012554       | 齿轮                    | Gear Smale                  | 1          | ☆         |    |
| 57        | 10012678       | 轴套                    | Hook Shaft Rear Metal       | 1          | ☆         |    |
| 58        | 10012423       | 油封                    | Hook Driving Shaft Oil Seal | 1          | ☆         |    |
| 59        | 20000175       | 轴承组件                  | Bearing Support ASM         | 1          | ☆         |    |
| 60        | 10013608       | 螺钉                    | Screw 11/64-40              | 2          | ☆         |    |
| 61        | 10012610       | 轴套                    | Hook Shaft Metal Compl      | 1          | ☆         |    |
| 62        | 10014503       | 油封                    | Oil Seal                    | 2          | ☆         |    |
| 63        | 10013921       | KHS12SINGER+SC31旋梭+梭壳 | Hook ASM                    | 1          | ☆         |    |
|           | 10013922       | SKRT875LKZ旋梭+梭壳       | Hook ASM                    | 1          |           | ☆  |
| 64        | 20001663       | 螺钉组件                  | Screw ASM                   | 1          | ☆         |    |



### 3.2 下轴送料部件 (旋刀)

#### HORIZONTAL FEED & VERTICAL FEED AND

#### HOOK DRIVING SHAFT COMPONENTS (Rotation knife)



### 3.2、下轴送料部件

#### HORIZONTAL FEED & VERTICAL COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称           | Name of the part           | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|--------------|----------------------------|------------|-----------|----|
| 1         | 10012490       | 销            | Feed Rocker Base Shaft     | 1          | ☆         |    |
| 2         | 10012540       | 牙架座          | Feed Rocker Base Arm       | 1          | ☆         |    |
| 3         | 10010074       | 螺钉           | Screw 11/64-40 L=7         | 1          | ☆         |    |
| 4         | 10025329       | 螺钉           | Screw 3/16-28 L=14         | 1          | ☆         |    |
| 6         | 10012531       | 牙架组件         | Feed Base                  | 1          | ☆         |    |
| 7         | 10025331       | 送料牙          | Feed Dog                   | 1          | ☆         |    |
|           | 10012982       | 送料牙          | Feed Dog                   | 1          |           | ☆  |
| 8         | 10010099       | 螺钉           | Screw 1/8-44 L=6           | 2          | ☆         |    |
| 9         | 10013006       | 轴套           | Feed Rocker Shaft Metal    | 1          | ☆         |    |
| 10        | 10006134       | 14.72挡圈      | Feed Shaft Thrust Collar   | 1          | ☆         |    |
| 11        | 10012162       | M5×5螺钉       | Screw M5 L=5               | 2          | ☆         |    |
| 12        | 10003290       | 15挡圈         | Retaining ring             | 1          | ☆         |    |
| 13        | 10013022       | 送料轴          | Feed Rocker Shaft Metal    | 1          | ☆         |    |
| 14        | 10010066       | 螺钉           | Screw 11/64-40 L=9.5       | 1          | ☆         |    |
| 15        | 10012530       | 旋梭定位钩        | Bobbin Case Holder         | 1          | ☆         |    |
| 16        | 10012536       | 油封           | Oil seal                   | 1          | ☆         |    |
| 17        | 10010071       | 螺钉           | Screw 9/64-40              | 1          | ☆         |    |
| 18        | 10012492       | 送料后曲柄        | Feed Rocker Arm            | 1          | ☆         |    |
| 19        | 10010095       | 螺钉           | Screw 3/16-28 L=15.5       | 1          | ☆         |    |
| 20        | 10010096       | 7×13销        | Walking Foot Pin B         | 1          | ☆         |    |
| 21        | 10012500       | 送料摆动座组件      | Adjusting Link ASM         | 1          | ☆         |    |
| 22        | 10010593       | 螺钉           | Screw 15/64-28             | 2          | ☆         |    |
| 23        | 10012532       | 销            | Adjusting Link ASM Fulcrum | 2          | ☆         |    |
| 24        | 10012495       | 13橡胶塞        | Rubber Plug                | 2          | ☆         |    |
| 25        | 10010075       | 送料短摆动板       | Connecting Link, B         | 2          | ☆         |    |
| 26        | 10012537       | 送料摆动座长连接板    | Connecting Link, A         | 2          | ☆         |    |
| 27        | 10010071       | 螺钉           | Screw 9/64-40              | 1          | ☆         |    |
| 28        | 10010069       | 销            | Walking Foot Pin C         | 1          | ☆         |    |
| 29        | 10012535       | 拾牙轴同步齿形带轮    | Lower Sprocket             | 1          | ☆         |    |
| 30        | 10009187       | M6×8螺钉       | Screw M6 L=8               | 2          | ☆         |    |
| 31        | 10003542       | 拾牙轴后轴承       | Bearing                    | 1          | ☆         |    |
| 32        | 10012538       | 14.72×42×5油封 | Oil Seal                   | 2          | ☆         |    |
| 33        | 10010643       | 螺钉           | Screw 9/64-40 L=6          | 2          | ☆         |    |
| 34        | 10005742       | 送料偏心轮挡片      | Feed Rocker Cam Plate      | 1          | ☆         |    |
| 35        | 10005787       | 送布摆动连杆       | Feed Rocker Rod            | 1          | ☆         |    |
| 36        | 10005792       | K25×29×9.6轴承 | Needle Bearing             | 1          | ☆         |    |
| 37        | 10005740       | 送布偏心轮        | Feed Rocker Cam Plate      | 1          | ☆         |    |
| 38        | 10010083       | 螺钉           | Screw 15/64-28 L=10.5      | 2          | ☆         |    |
| 39        | 10012462       | 齿轮           | Gear, Large                | 1          | ☆         |    |
| 40        | 10008862       | 螺钉           | Screw 1/4-40 L=5.8         | 4          | ☆         |    |
| 41        | 10012489       | 拾牙轴          | Feed Driving Shaft         | 1          | ☆         |    |
| 42        | 10012533       | 油封           | Oil Seal                   | 1          | ☆         |    |
| 43        | 10009782       | 拾牙轴轴承        | Bearing                    | 1          | ☆         |    |
| 44        | 10012501       | 轴承套          | Bearing Support            | 1          | ☆         |    |
| 45        | 10003921       | 螺钉           | Screw 1/4-40               | 2          | ☆         |    |
| 46        | 10005750       | 拾牙凸轮         | Feed Driving Cam           | 1          | ☆         |    |
|           | 10006135       | 拾牙凸轮         | Feed Driving Cam           | 1          |           | ☆  |

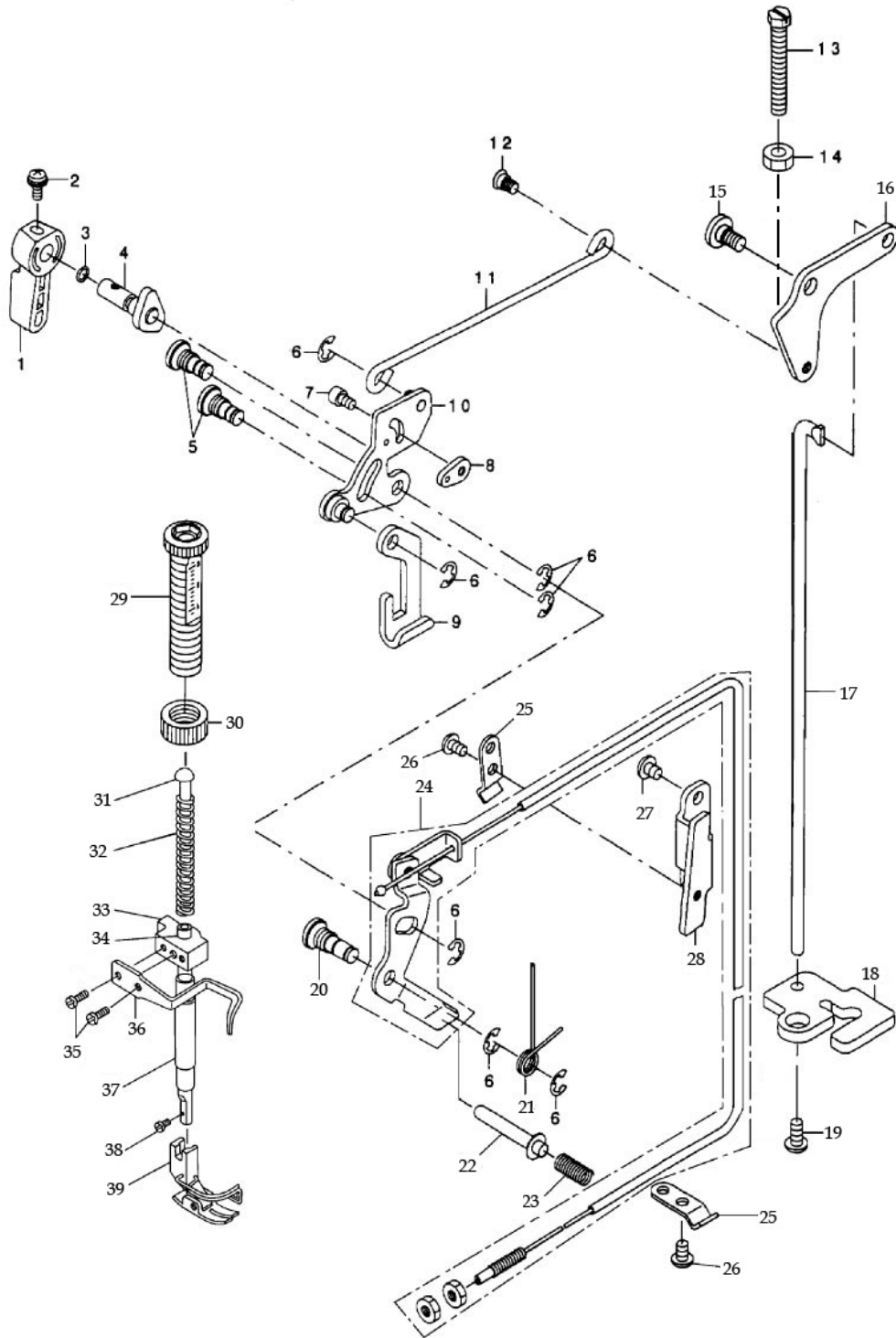
### 3.2、下轴送料部件

#### HORIZONTAL FEED & VERTICAL COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称                    | Name of the part            | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|-----------------------|-----------------------------|------------|-----------|----|
| 47        | 10010083       | 螺钉                    | Screw 15/64-28              | 2          | ☆         |    |
| 48        | 10010074       | 螺钉                    | Screw 11/64-40              | 1          | ☆         |    |
| 49        | 10012498       | 销                     | Feed Driving Base Shaft     | 1          | ☆         |    |
| 50        | 10005789       | 拾牙曲柄                  | Feed Driving Base Arm       | 1          | ☆         |    |
| 51        | 10005790       | 挡圈                    | Feed Driving Cam Thrust BU  | 2          | ☆         |    |
| 52        | 10005744       | 轴承                    | Bearing                     | 1          | ☆         |    |
| 53        | 10012503       | 拾牙凸轮挡板                | Feed Driving Cam Plate      | 1          | ☆         |    |
| 54        | 10010643       | 螺钉                    | Screw 9/64-40               | 2          | ☆         |    |
| 55        | 10012534       | 下轴                    | Hook Shaft                  | 1          | ☆         |    |
| 56        | 10012554       | 齿轮                    | Gear Smale                  | 1          | ☆         |    |
| 57        | 10012678       | 轴套                    | Hook Shaft Rear Metal       | 1          | ☆         |    |
| 58        | 10012423       | 油封                    | Hook Driving Shaft Oil Seal | 1          | ☆         |    |
| 59        | 20000175       | 轴承组件                  | Bearing Support ASM         | 1          | ☆         |    |
| 60        | 10013608       | 螺钉                    | Screw 11/64-40              | 2          | ☆         |    |
| 61        | 10014463       | 轴套                    | Hook Shaft Metal Compl      | 1          | ☆         |    |
| 62        | 10014503       | 油封                    | Oil Seal                    | 2          | ☆         |    |
| 63        | 10013921       | KHS12SINGER+SC31旋梭+梭壳 | Hook ASM                    | 1          | ☆         |    |
|           | 10013922       | SKRT875LKZ旋梭+梭壳       | Hook ASM                    | 1          |           | ☆  |
| 64        | 20001663       | 螺钉组件                  | Screw ASM                   | 1          | ☆         |    |
| 65        | 10013029       | 油封                    | Oil Seal                    | 1          | ☆         |    |

#### 4、抬压脚部件

#### HANG LIFTER & TENSION RELEASE COMPONENTS



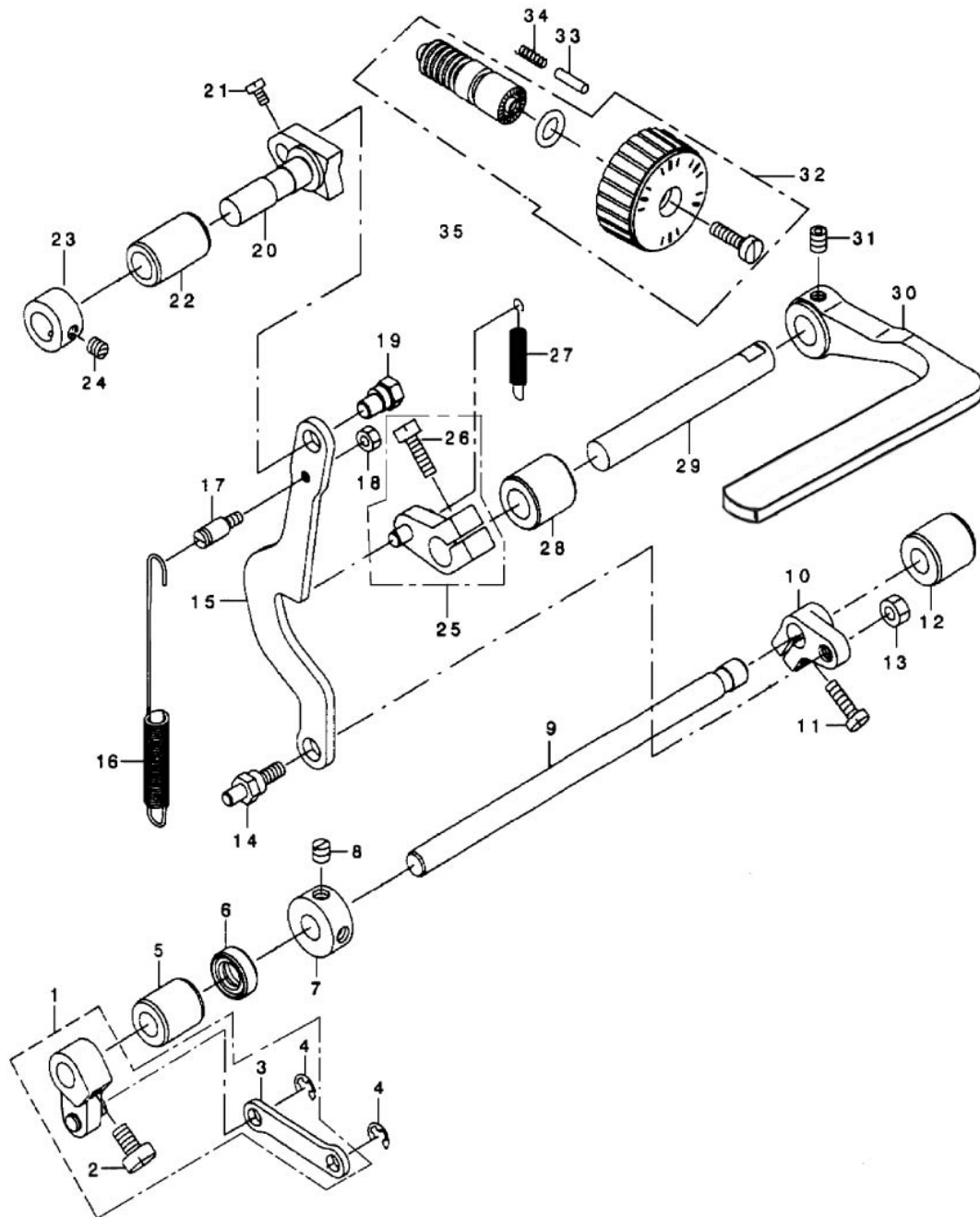
## 4、抬压脚部件

## HANG LIFTER &amp; TENSION RELEASE COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称            | Name of the part              | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|---------------|-------------------------------|------------|-----------|----|
| 1         | 10011064       | 压脚扳手          | Hand Lifter                   | 1          | ☆         |    |
| 2         | 10010016       | SM9/64" ×40螺钉 | Screw                         | 1          | ☆         |    |
| 3         | 10010027       | O形圈           | Rubber Ring                   | 1          | ☆         |    |
| 4         | 10013809       | 压脚扳手凸轮组件      | Hand Lifter Cam Asm           | 1          | ☆         |    |
| 5         | 10010653       | 销             | Pin                           | 2          | ☆         |    |
| 6         | 10010649       | 5.1×0.6挡圈     | E-Ring                        | 7          | ☆         |    |
| 7         | 10002976       | M4×6螺钉        | Screw M4 L=6                  | 1          | ☆         |    |
| 8         | 10005833       | 小连板           | Connecting Plate              | 1          | ☆         |    |
| 9         | 10010648       | 压脚升降板         | Lifting Plate                 | 1          | ☆         |    |
| 10        | 10005685       | 前杠杆组件         | Lifting Link Compl            | 1          | ☆         |    |
| 11        | 10012582       | 膝控提升杆         | Lifting Lever Connect Rod     | 1          | ☆         |    |
| 12        | 10005882       | 螺钉            | Screw 3/16-32                 | 1          | ☆         |    |
| 13        | 10012633       | 螺钉            | Screw 15/64-28                | 1          | ☆         |    |
| 14        | 10012625       | 螺母            | Nut 15/64-28                  | 1          | ☆         |    |
| 15        | 10012430       | 螺钉            | Screw 15/64-28                | 1          | ☆         |    |
| 16        | 10012584       | 后杠杆           | Lifting Lever Link            | 1          | ☆         |    |
| 17        | 10005836       | 膝控提升拉杆        | Connecting Rod                | 1          | ☆         |    |
| 18        | 10012429       | 提升杆导板         | Connecting Rod Guide          | 1          | ☆         |    |
| 19        | 10012637       | 螺钉            | Screw 3/16-28 L=10            | 1          | ☆         |    |
| 20        | 10010022       | 销             | Tension Release Shaft         | 1          | ☆         |    |
| 21        | 10010647       | 弹簧            | Tension Release Return Spring | 1          | ☆         |    |
| 22        | 10012140       | 松线辅钉          | Tension Release Supporting P  | 1          | ☆         |    |
| 23        | 10010642       | 弹簧            | Tension Release Pin Spring    | 1          | ☆         |    |
| 24        | 10012623       | 抬压脚拉线组件       | Knee Lifting Tension Release  | 1          | ☆         |    |
| 25        | 10012445       | 软管压板          | Wire Holder A                 | 1          | ☆         |    |
| 26        | 10012130       | 螺钉            | Screw 11/64-40 L=7            | 1          | ☆         |    |
| 27        | 10012621       | 螺钉            | Screw 3/16-28 L=6             | 1          | ☆         |    |
| 28        | 10005881       | 抬压脚拉线固定架      | Wire Holder Bracket           | 1          | ☆         |    |
| 29        | 10013325       | 螺钉            | Screw                         | 1          | ☆         |    |
| 30        | 10011023       | 螺母            | Nut 1/2-28                    | 1          | ☆         |    |
| 31        | 10012426       | 调压导杆          | Presser Guide Bar C           | 1          | ☆         |    |
| 32        | 10004473       | 弹簧            | Presser Spring                | 1          | ☆         |    |
| 33        | 10012679       | 压杆导架          | Presser Bar Bracket           | 1          | ☆         |    |
| 34        | 10013322       | 压杆            | Presser Bar                   | 1          | ☆         |    |
| 35        | 10010018       | 螺钉            | Screw 9/64-40                 | 2          | ☆         |    |
| 36        | 10012422       | 缓线调节钩         | Presser Bar Thread Guide      | 1          | ☆         |    |
| 37        | 10014141       | 压杆衬套          | Bushing                       | 1          | ☆         |    |
| 38        | 10010650       | 螺钉            | Screw 9/64-40 L=10.5          | 1          | ☆         |    |
| 39        | 10012449       | 活压脚部件         | Presser Foot Asm              | 1          | ☆         |    |

## 5、倒缝部件

### FEED ADJUST MECHANISM COMPONENTS

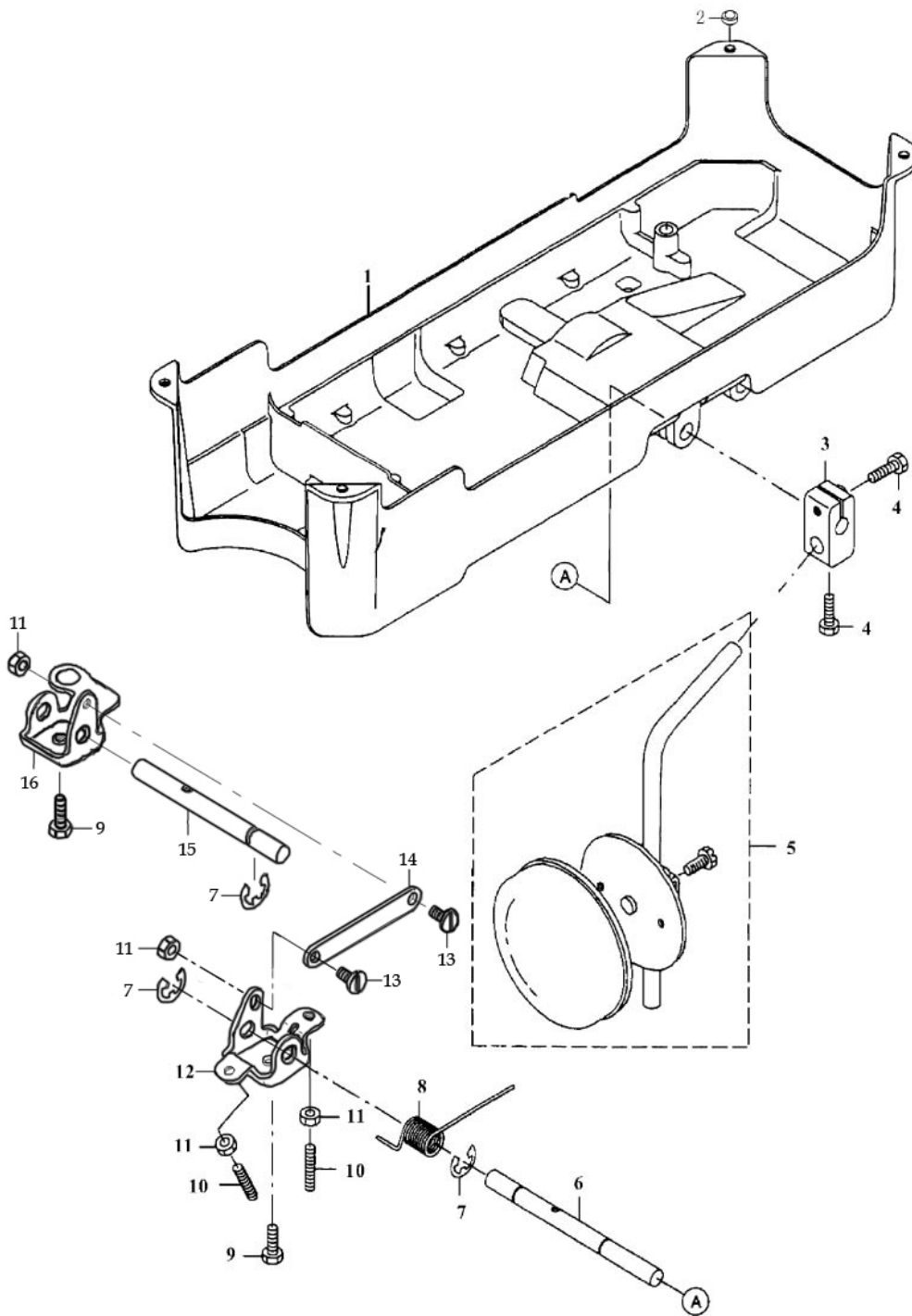


## 5、倒缝部件

## FEED ADJUST MECHANISM COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称          | Name of the part             | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|-------------|------------------------------|------------|-----------|----|
| 1         | 20000148       | 送料摆动座前曲柄组件  | Feed Changing Shaft Arm, A   | 1          | ☆         |    |
| 2         | 10010092       | 螺钉          | Screw 1/4-40 L=11            | 1          | ☆         |    |
| 3         | 10012634       | 送料摆动座摆动连板   | Adjusting Link Plate         | 1          | ☆         |    |
| 4         | 10010649       | 5.1×0.6挡圈   | E-Ring                       | 2          | ☆         |    |
| 5         | 10012629       | 轴套          | Metal, A                     | 1          | ☆         |    |
| 6         | 10012622       | 10×19.2×7油封 | Feed Changing Shaft Oil Seal | 1          | ☆         |    |
| 7         | 10012627       | 挡圈          | Thrust Collar                | 1          | ☆         |    |
| 8         | 10003921       | 螺钉          | Screw 1/4-40 L=8             | 2          | ☆         |    |
| 9         | 10013867       | 针距调节轴       | Feed Changing Shaft          | 1          | ☆         |    |
| 10        | 10012424       | 送料摆动座后曲柄    | Feed Changing Shaft Arm, B   | 1          | ☆         |    |
| 11        | 10010095       | 螺钉          | Screw 3/16-28 L=15.5         | 1          | ☆         |    |
| 12        | 10012586       | 轴套          | Metal, B                     | 1          | ☆         |    |
| 13        | 10012620       | 螺母          | Nut 15/64-28                 | 1          | ☆         |    |
| 14        | 10012418       | 销           | Feed Changing Shaft Arm Pin  | 1          | ☆         |    |
| 15        | 10012680       | 针距调节连接板     | Feed Adjusting Rod           | 1          | ☆         |    |
| 16        | 10013868       | 弹簧          | Feed Adjusting Spring        | 1          | ☆         |    |
| 17        | 10012635       | 销           | Spring Suspension            | 1          | ☆         |    |
| 18        | 10010106       | 螺母          | Nut 11/64-40                 | 1          | ☆         |    |
| 19        | 10013866       | 销           | Feed Adjusting Pin           | 1          | ☆         |    |
| 20        | 10012583       | 针距调节座       | Feed Adjusting Base          | 1          | ☆         |    |
| 21        | 10010643       | 螺钉          | Screw 9/64-40 L=6            | 2          | ☆         |    |
| 22        | 10012626       | 轴套          | Adjusting Base Shaft Metal   | 1          | ☆         |    |
| 23        | 10012428       | 挡圈          | Collar Asm D=11.1 W=10       | 1          | ☆         |    |
| 24        | 10005020       | 挡圈螺钉        | Screw 1/40-40 L=6            | 2          | ☆         |    |
| 25        | 20000150       | 倒缝扳手曲柄组件    | Feed Lever Arm Asm           | 1          | ☆         |    |
| 26        | 10010095       | 螺钉          | Screw 3/16-28 L=15.5         | 1          | ☆         |    |
| 27        | 10012676       | 弹簧          | Feed Lever Spring            | 1          | ☆         |    |
| 28        | 10012578       | 轴套          | Feed Lever Shaft Metal       | 1          | ☆         |    |
| 29        | 10012419       | 倒送料轴        | Feed Lever Shaft             | 1          | ☆         |    |
| 30        | 20003414       | 倒送料扳手       | Feed Lever Spanner           | 1          | ☆         |    |
| 31        | 10009187       | M6×8螺钉      | Screw M16 L=8                | 2          | ☆         |    |
| 32        | 20000144       | 针距标盘组件      | Feed Dial Asm                | 1          | ☆         |    |
| 33        | 10013870       | 3.7×16.5销   | Pin                          | 1          | ☆         |    |
| 34        | 10013869       | 弹簧          | Spring                       | 1          | ☆         |    |

## 6、油盘膝提部件 UNDER COVER COMPONENTS





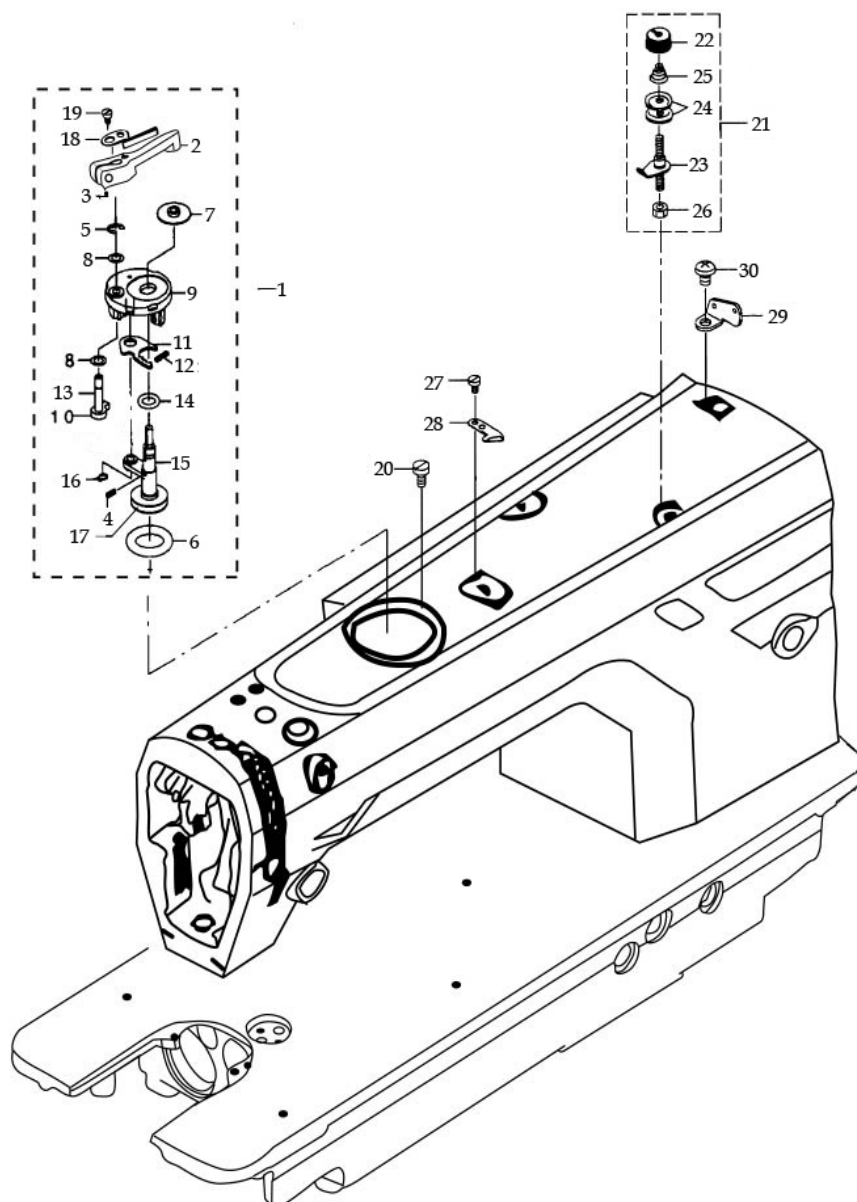
## 6、油盘膝提部件

## UNDER COVER COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称                   | Name of the part   | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|----------------------|--------------------|------------|-----------|----|
| 1         | 10012632       | 油盘                   | Under Cover        | 1          | ☆         |    |
| 2         | 10013102       | 机头座垫                 | Head Gasket        | 4          | ☆         |    |
| 3         | 10003896       | 抬压脚操纵接头              | Bracket            | 1          | ☆         |    |
| 4         | 10002613       | GB/T5781-2000M8×20螺栓 | Screw              | 2          | ☆         |    |
| 5         | 10009985       | 操纵杆部件                | Knee Pad Plate Asm | 1          | ☆         |    |
| 6         | 10008450       | 抬压脚轴 I               | Knee Press Rod I   | 1          | ☆         |    |
| 7         | 10002559       | 9.8×20×1挡圈           | E-Ring             | 1          | ☆         |    |
| 8         | 10012677       | 弹簧                   | Spring             | 1          | ☆         |    |
| 9         | 10003898       | 螺钉                   | Screw              | 2          | ☆         |    |
| 10        | 10003895       | M6×30螺钉              | Screw M6 L=30      | 2          | ☆         |    |
| 11        | 10003890       | M6×3.2螺母             | Nut M6             | 4          | ☆         |    |
| 12        | 10008463       | 膝控限位架 I              | Bracket            | 1          | ☆         |    |
| 13        | 10008465       | 螺钉                   | Screw              | 2          | ☆         |    |
| 14        | 10008464       | 连接板                  | Connecting Rod     | 1          | ☆         |    |
| 15        | 10008466       | 抬压脚轴 II              | Knee Press Rod II  | 1          | ☆         |    |
| 16        | 10008383       | 膝控限位架 II             | Connecting Rot     | 1          | ☆         |    |

## 7、绕线部件

### BOBBIN WINDER COMPONENTS



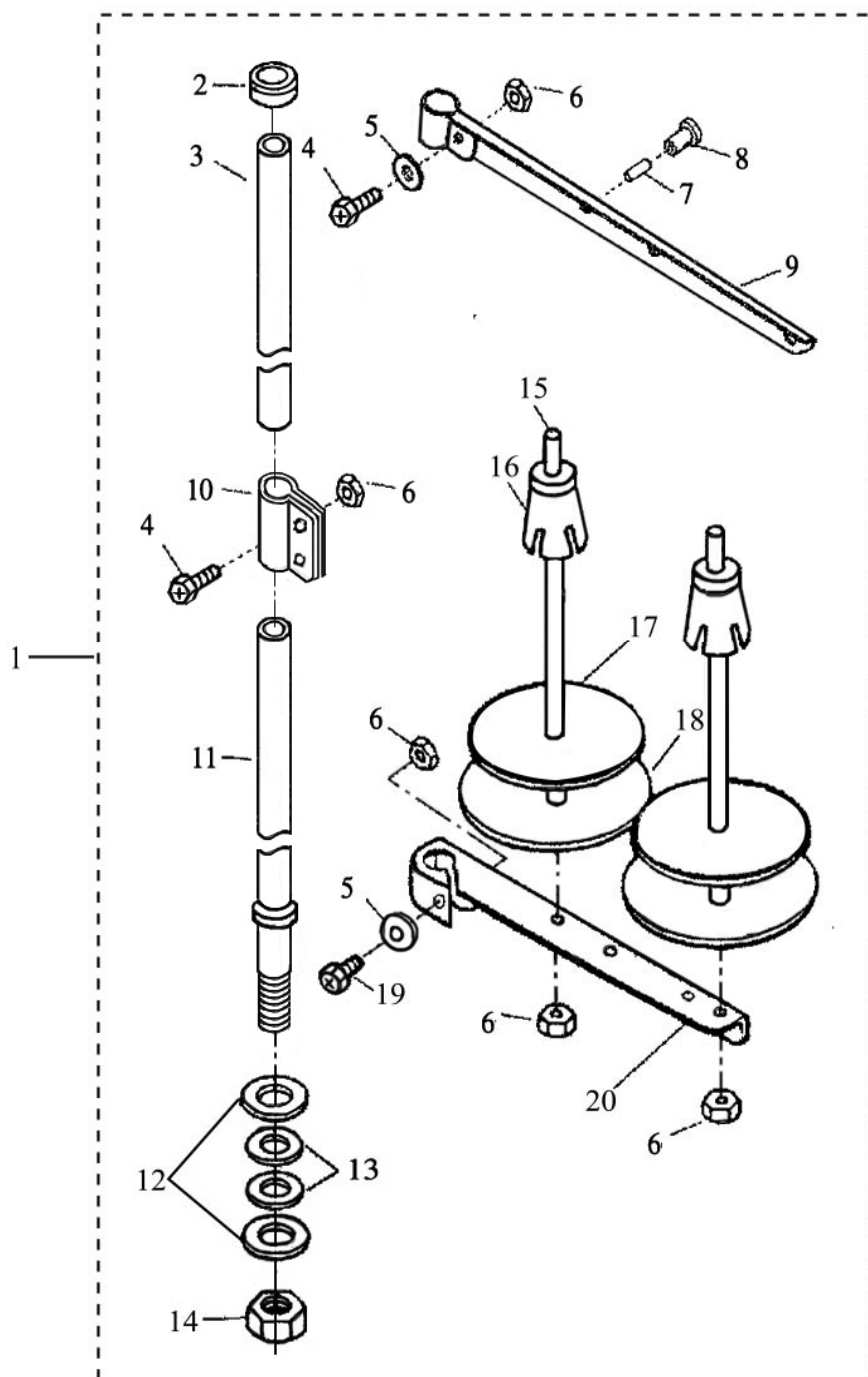
## 7、绕线部件

## BOBBIN WINDER COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称            | Name of the part             | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|---------------|------------------------------|------------|-----------|----|
| 1         | 10013875       | 绕线器           | Bobbin Device Asm            | 1          | ☆         |    |
| 2         | 10000736       | 卷线手柄          | Bobbin Lever                 | 1          | ☆         |    |
| 3         | 10000735       | 螺钉            | Screw 9/64-40                | 1          | ☆         |    |
| 4         | 10004494       | 弹簧            | Pressur Foot Spring          | 1          | ☆         |    |
| 5         | 10013038       | 挡圈            | E-Ring                       | 1          | ☆         |    |
| 6         | 10008773       | 橡胶轮           | Rubber Ring                  | 1          | ☆         |    |
| 7         | 10004498       | 卷绕轴垫          | Bobbin Cushion               | 1          | ☆         |    |
| 8         | 10004486       | 6.2×9.8×0.3垫圈 | Washer 6.2×9.8×0.3           | 1          | ☆         |    |
| 9         | 10006240       | 梭芯卷绕体组件       | Bobbin Fitting Basis Compl.  | 1          | ☆         |    |
| 10        | 10006151       | 绕线定位块         | Bobbin Cam Shaft Compl.      | 1          | ☆         |    |
| 11        | 10004497       | 控制板           | Adjusting Plate              | 1          | ☆         |    |
| 12        | 10004501       | 弹簧            | Spring                       | 1          | ☆         |    |
| 13        | 10006152       | 绕线凸轮轴         | Bobbin Cam Shaft Compl.      | 1          | ☆         |    |
| 14        | 10004485       | O形圈           | Rubber Ring                  | 1          | ☆         |    |
| 15        | 10006158       | 梭芯卷绕轴         | Bobbin Winder Shaft Compl.   | 1          | ☆         |    |
| 16        | 10006142       | 6挡圈           | Retaining Ring               | 1          | ☆         |    |
| 17        | 10013019       | M3×4螺钉        | Screw M3 L=4                 | 1          | ☆         |    |
| 18        | 10005682       | 线量调节板         | Adjusting Plate              | 1          | ☆         |    |
| 19        | 10000759       | 螺钉            | Screw 9/64-40                | 1          | ☆         |    |
| 20        | 10004380       | 螺钉            | Screw 3/16-32                | 3          | ☆         |    |
| 21        | 10013064       | 绕线夹线器组件       | Bobbin Thread Tension ASM.   | 1          | ☆         |    |
| 22        | 10004390       | 塑料夹线螺母        | Thread Tension Nut           | 1          | ☆         |    |
| 23        | 10004504       | 中过线板组件        | Bobbin Thread Tension Rod AS | 1          | ☆         |    |
| 24        | 10004393       | 夹线板           | Bobbin Winder Tension Disc   | 2          | ☆         |    |
| 25        | 10004391       | 弹簧            | Thread Tension Spring        | 1          | ☆         |    |
| 26        | 10004507       | 螺母            | Nut 11/64-40                 | 1          | ☆         |    |
| 27        | 10013269       | 螺钉            | Screw 9/64-40                | 2          | ☆         |    |
| 28        | 10011149       | 绕线切刀          | Thread Cutter                | 1          | ☆         |    |
| 29        | 10011200       | 上过线板          | Thread Guide Plate           | 1          | ☆         |    |
| 30        | 10011158       | 螺钉            | Screw 15/64-28               | 1          | ☆         |    |

## 8、过线架部件

### THREAD STAND COMPONENTS



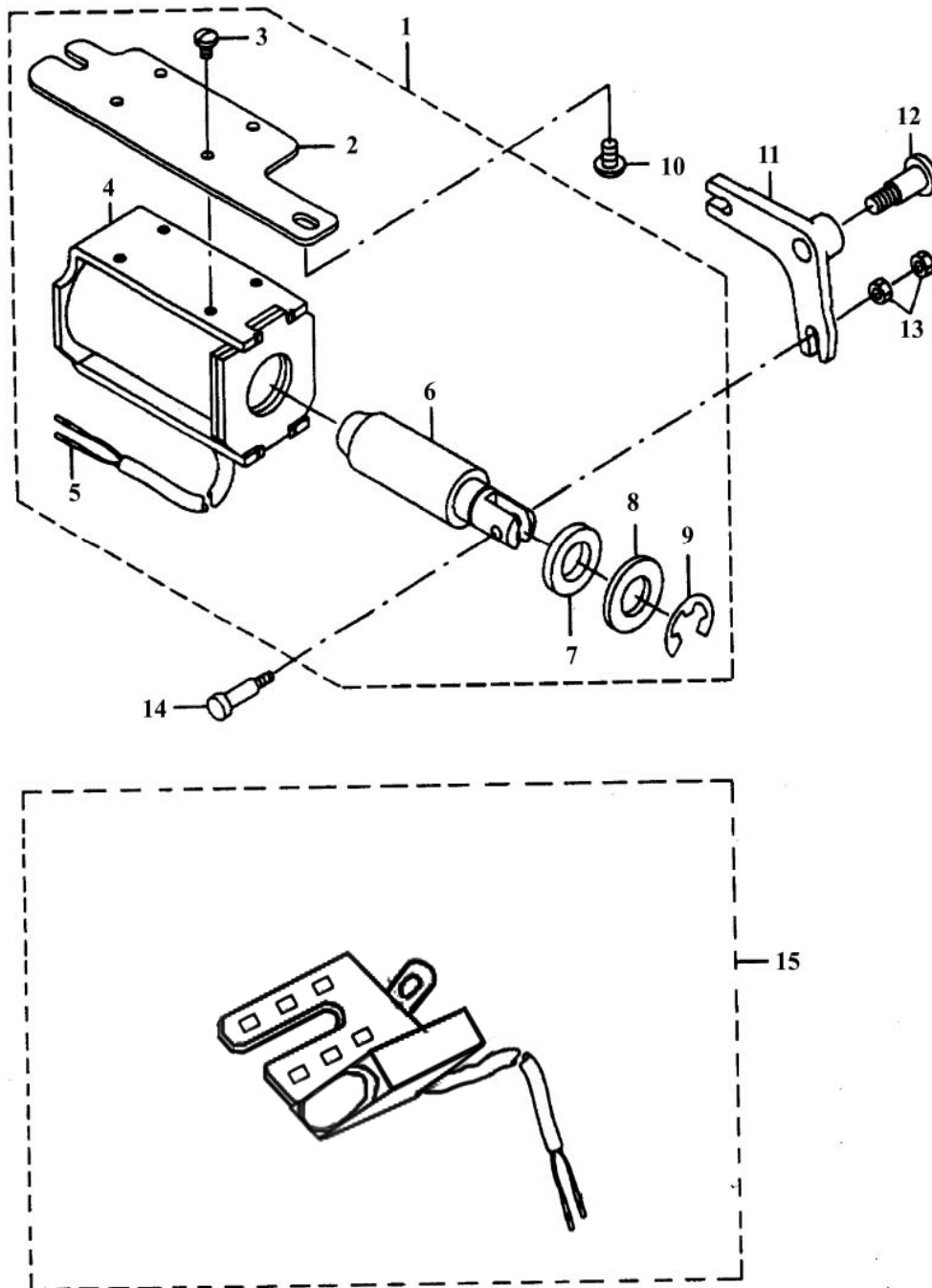
## 8、过线架部件

## THREAD STAND COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称      | Name of the part             | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|---------|------------------------------|------------|-----------|----|
| 1         | 10007130       | 二线线架部件  | Thread Stand Asm.            |            | ☆         |    |
| 2         | 10004282       | 线架上撑管套  | Column Cap                   | 1          | ☆         |    |
| 3         | 10004293       | 线架上撑管   | Column Pipe(Upper)           | 1          | ☆         |    |
| 4         | 10003301       | M5×14螺钉 | Screw                        | 2          | ☆         |    |
| 5         | 10003022       | 垫圈      | Washer                       | 5          | ☆         |    |
| 6         | 10002953       | M5螺母    | Nut                          | 5          | ☆         |    |
| 7         | 10004289       | 过线管     | Thread Guide Pipe            | 1          | ☆         |    |
| 8         | 10004285       | 过线管套    | Thread Guide Bushing         | 1          | ☆         |    |
| 9         | 10004298       | 上过线架    | Thread Hanger(Upper)         | 1          | ☆         |    |
| 10        | 10004286       | 撑管夹     | Column Pipe Connector        | 1          | ☆         |    |
| 11        | 10004291       | 线架下撑管   | Column Pipe(Lower)           | 1          | ☆         |    |
| 12        | 10004290       | 垫圈      | Washer 16×30×1.5             | 2          | ☆         |    |
| 13        | 10004295       | 垫圈      | Washer 16.5×27.5×3           | 2          | ☆         |    |
| 14        | 10002953       | M5螺母    | Nut                          | 1          | ☆         |    |
| 15        | 10004288       | 线轴      | Spool                        | 2          | ☆         |    |
| 16        | 10004287       | 线盘塑料压块  | Spool Cushion                | 2          | ☆         |    |
| 17        | 10004281       | 线盘软垫    | Soft Cushion Of Thread Plate | 2          | ☆         |    |
| 18        | 10004299       | 线盘      | Thread Plate                 | 2          | ☆         |    |
| 19        | 10003312       | M5×30螺钉 | Screw                        | 1          | ☆         |    |
| 20        | 10004284       | 下过线架    | Thread Hanger(Lower)         | 1          | ☆         |    |

## 9、自动倒缝部件

### AUTOMATIC REVERSE FEED COMPONENTS

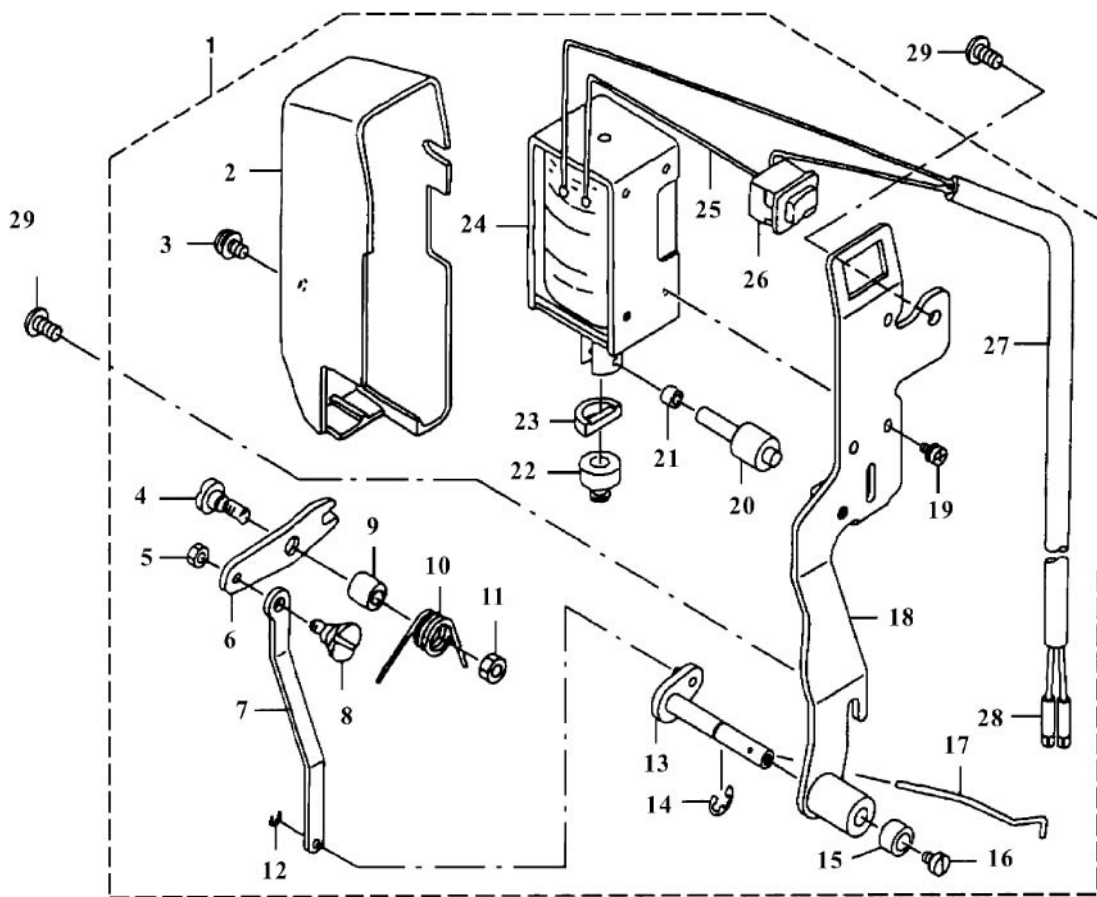


## 9、自动倒缝部件

## AUTOMATIC REVERSE FEED COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称        | Name of the part             | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|-----------|------------------------------|------------|-----------|----|
| 1         | 10012528       | 自动倒缝电磁铁组件 | Reverse Feed Solenoid Base A | 1          | ☆         |    |
| 2         | 10005820       | 电磁铁支架     | Reverse Feed Solenoid Base A | 1          | ☆         |    |
| 3         |                | 倒缝电磁铁固定螺钉 | Screw                        | 4          | ☆         |    |
| 4         |                | 倒缝电磁铁     | Reverse Feed Solenoid Base A | 1          | ☆         |    |
| 5         |                | 倒缝电磁铁接头   | Pin Contact                  | 2          | ☆         |    |
| 6         |                | 倒缝电磁铁铁芯   | Reverse Feed Solenoid Plunge | 1          | ☆         |    |
| 7         |                | 倒缝电磁铁橡胶垫  | Rubber Plunger               | 1          | ☆         |    |
| 8         |                | 倒缝电磁铁垫圈   | Washer                       | 1          | ☆         |    |
| 9         |                | 倒缝电磁铁开口挡圈 | E-Ring                       | 1          | ☆         |    |
| 10        | 10012142       | 螺钉        | Screw 15/64-28 L=9           | 2          | ☆         |    |
| 11        | 10012587       | 倒缝摆臂      | Reverse Feed Arm             | 1          | ☆         |    |
| 12        | 10012628       | 螺钉        | Screw 9/32-28                | 2          | ☆         |    |
| 13        |                | 倒缝电磁铁连接螺母 | Nut                          | 1          | ☆         |    |
| 14        |                | 倒缝电磁铁连接销  | Plunger Arm Pin              | 1          | ☆         |    |
| 15        | 10007561       | 点动倒送料开关组件 | Option Switch Asm            | 1          | ☆         |    |

# 10、拔线部件 WIPER COMPONENTS





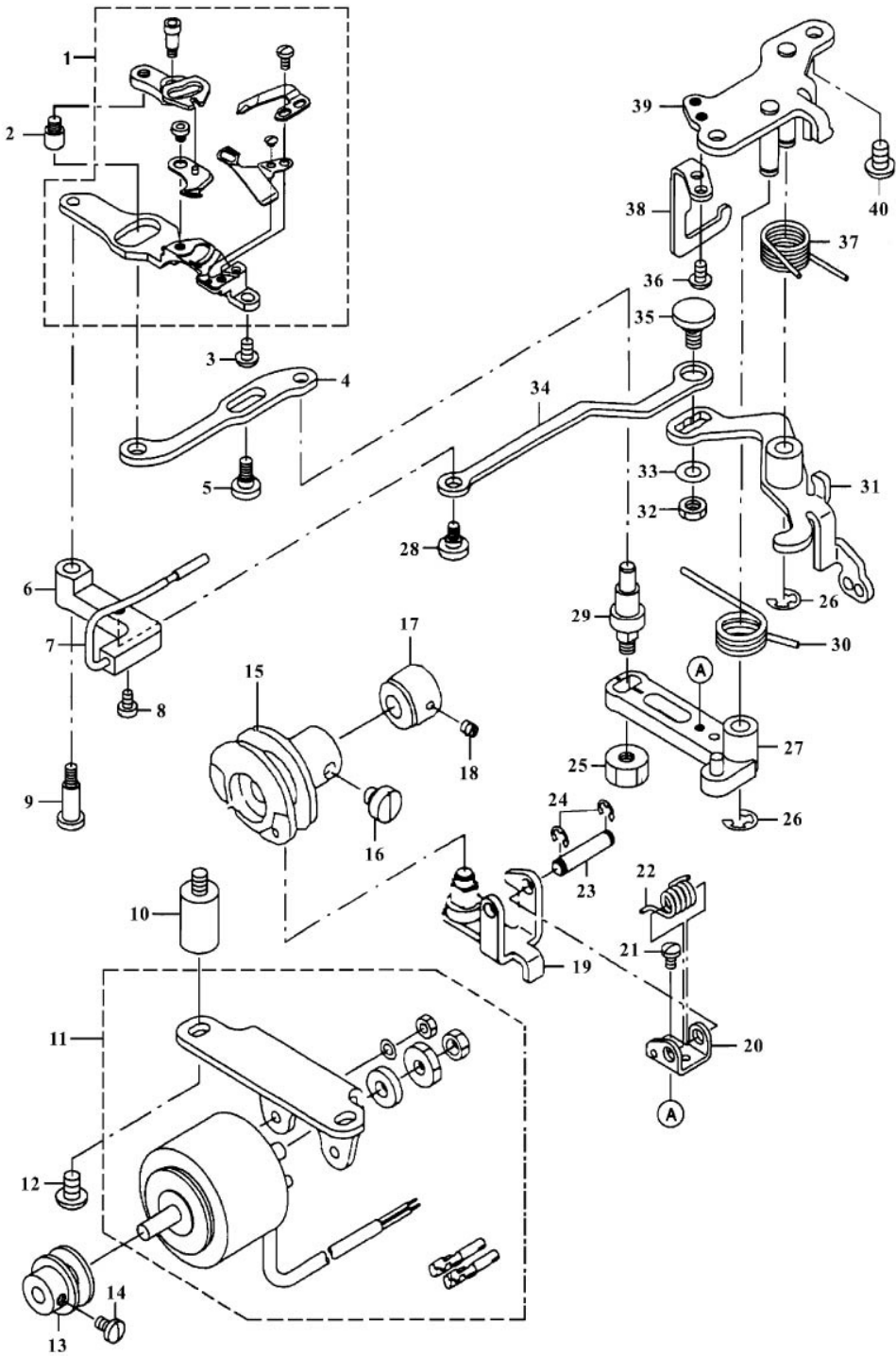
## 10、拨线部件

## WIPER COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称          | Name of the part         | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|-------------|--------------------------|------------|-----------|----|
| 1         | 10012526       | 拨线分组件       | Wiper Asm.               | 1          | ☆         |    |
| 2         | 10005724       | 拨线器罩        | Wiper Cover              | 1          | ☆         |    |
| 3         | 10003036       | M3×6螺钉      | Screw M3                 | 1          | ☆         |    |
| 4         | 10005726       | 螺钉          | Screw 11/64-40           | 1          | ☆         |    |
| 5         | 10005766       | 螺母          | Nut 11/64-40             | 1          | ☆         |    |
| 6         | 10005772       | 拨线传动板       | Wiper Link A             | 1          | ☆         |    |
| 7         | 10005783       | 拨线拉杆        | Wiper Link B             | 1          | ☆         |    |
| 8         | 10005738       | 螺钉          | Screw 9/64-40            | 1          | ☆         |    |
| 9         | 10005767       | 轴套          | Wiper Hinge Screw Collar | 1          | ☆         |    |
| 10        | 10005770       | 弹簧          | Wiper Spring             | 1          | ☆         |    |
| 11        | 10005735       | 螺母          | Nut 11/64-40             | 1          | ☆         |    |
| 12        | 10005737       | 2.5×6×0.4挡圈 | E-Ring                   | 1          | ☆         |    |
| 13        | 10005829       | 拨线驱动轴组件     | Wiper Shaft Asm          | 1          | ☆         |    |
| 14        | 10010649       | 5.1×0.6挡圈   | E-Ring                   | 1          | ☆         |    |
| 15        | 10005725       | 螺钉套圈        | Screw Installing Collar  | 1          | ☆         |    |
| 16        | 10005734       | 螺钉          | Screw 9/64-40 L=5        | 1          | ☆         |    |
| 17        | 10005765       | 拨线杆         | Wiper                    | 1          | ☆         |    |
| 18        | 10005811       | 拨线电磁铁支架组件   | Wiper Base Asm           | 1          | ☆         |    |
| 19        | 10003082       | 垫圈          | Washer                   | 3          | ☆         |    |
| 20        | 10005719       | 销           | Wiper Solenoid Pin       | 1          | ☆         |    |
| 21        | 10005769       | 传动销滚柱       | Wiper Link Collar        | 1          | ☆         |    |
| 22        | 10005812       | 铁芯复位垫       | Wiper Rubber A           | 1          | ☆         |    |
| 23        | 10005739       | 铁芯橡皮垫       | Wiper Rubber B           | 1          | ☆         |    |
| 24        | 10005736       | 拨线器电磁铁      | Wiper Solenoid           | 1          | ☆         |    |
| 25        |                | 拨线器电线       | Electric Wire            | 2          | ☆         |    |
| 26        |                | 拨线开关        | Power Switch             | 1          | ☆         |    |
| 27        |                | 电线套         | 2-Cord Cabtyre Cord      | 1          | ☆         |    |
| 28        |                | 电线接头        | Wire Contact             | 2          | ☆         |    |
| 29        | 10008972       | 螺钉          | Screw 3/16-28 L=9        | 2          | ☆         |    |

## 11.1 自动剪线部件 (平刀)

### THREAD TRIMMER COMPONENTS (Parallel knife)



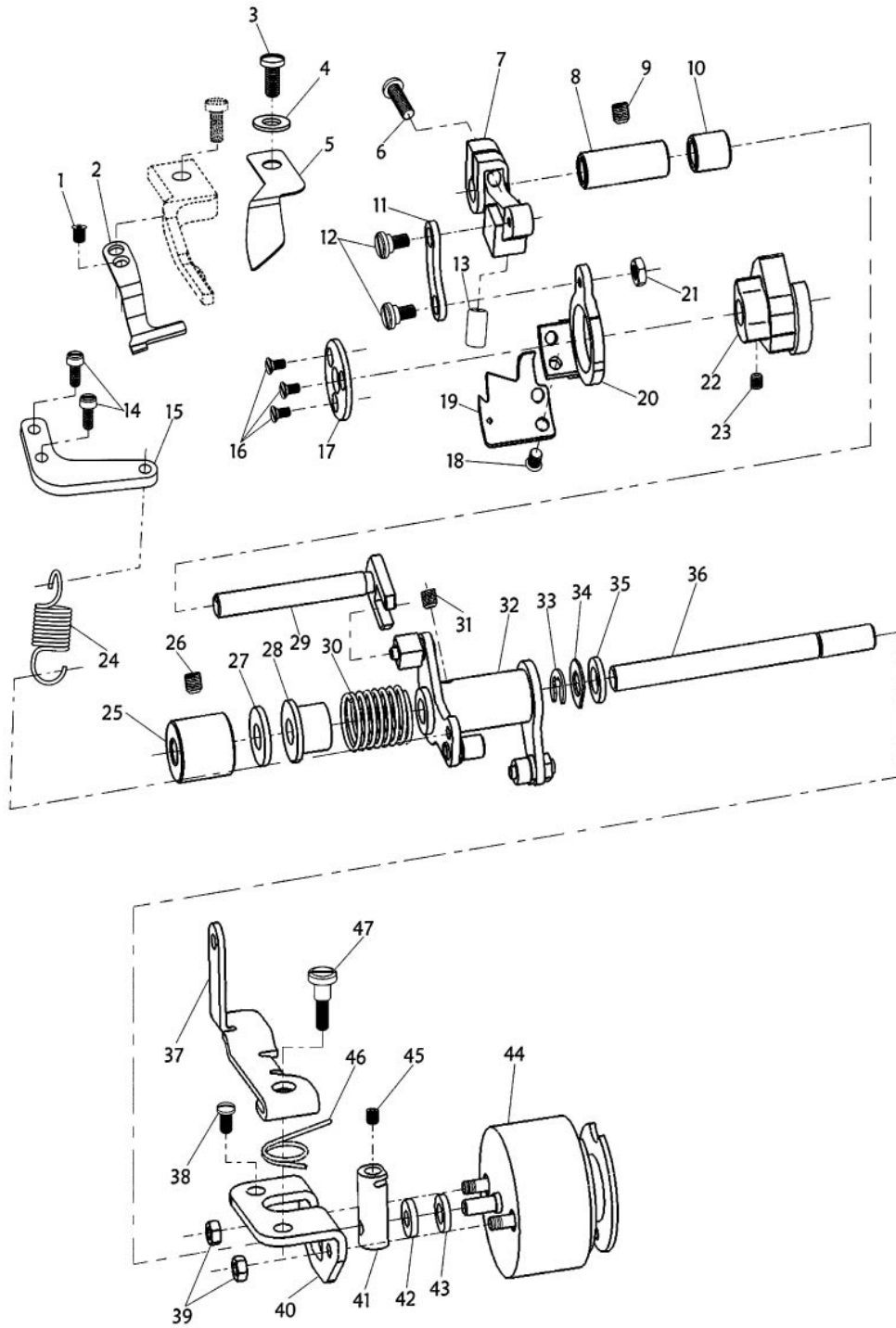
## 11.1、自动剪线部件

## THREAD TRIMMER COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称           | Name of the part          | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|--------------|---------------------------|------------|-----------|----|
| 1         | 10013114       | 剪线刀座部件       | Knife Unit                | 1          | ☆         |    |
|           | 10013329       | 剪线刀座部件       | Knife Unit                | 1          |           | ☆  |
| 2         | 10005720       | SM3/16"×28销  | Pin                       | 1          | ☆         |    |
| 3         | 10010093       | 螺钉           | Screw 11/64-40 L=7        | 1          | ☆         |    |
| 4         | 10005683       | 动刀连杆         | Hoving Knife Link         | 1          | ☆         |    |
| 5         | 10012630       | 螺钉           | Screw 3/16-28             | 1          | ☆         |    |
| 6         | 20000188       | 挡线体组件        | Picker Arm                | 1          | ☆         |    |
| 7         | 10013062       | 挡线支杆组件       | Thread Take-Up Picker Asm | 1          | ☆         |    |
| 8         | 10010071       | 螺钉           | Screw 9/64-40             | 1          | ☆         |    |
| 9         | 10005659       | 销            | Pin                       | 1          | ☆         |    |
| 10        | 10012580       | 螺钉           | Support Screw 15/64-28    | 2          | ☆         |    |
| 11        | 10012527       | 自动剪线电磁铁部件    | Solenoid Asm              | 1          | ☆         |    |
| 12        | 10012142       | 螺钉           | Screw 15/64-28 L=9        | 2          | ☆         |    |
| 13        | 10012573       | 剪线驱动轮        | Driving Wheel             | 1          | ☆         |    |
| 14        | 10012525       | 螺钉           | Screw 11/64-40 L=7        | 1          | ☆         |    |
| 15        | 10012451       | 剪线凸轮         | Thread Trimmer Cam Asm    | 1          | ☆         |    |
| 16        | 10012472       | 螺钉           | Screw 1/4-40 L=6          | 2          | ☆         |    |
| 17        | 10012624       | 7.94挡圈       | Cam Collar Asm            | 1          | ☆         |    |
| 18        | 10010059       | 螺钉           | Screw 11/64-40 L=4.5      | 2          | ☆         |    |
| 19        |                | 剪线凸轮滚动部件     | Picker Link               | 1          | ☆         |    |
| 20        | 10005636       | 托板支承架        | Roller Arm Bracket        | 1          | ☆         |    |
| 21        | 10010016       | 螺钉           | Screw 9/64-40 L=6         | 1          | ☆         |    |
| 22        | 10005676       | 弹簧           | Roller Return Spring      | 1          | ☆         |    |
| 23        | 10005668       | 6×29销        | Roller Fulcrum Pin        | 1          | ☆         |    |
| 24        | 10012795       | 4×9×0.6挡圈    | E-Ring                    | 2          | ☆         |    |
| 25        | 10005809       | 螺母           | Nut 15/64-28              | 1          | ☆         |    |
| 26        | 10005846       | 6×12×0.8挡圈   | E-Ring                    | 2          | ☆         |    |
| 27        | 10005774       | 剪线驱动曲柄       | Knife Driving Arm Asm     | 1          | ☆         |    |
| 28        | 10014481       | 螺钉           | Screw 11/64-40            | 1          | ☆         |    |
| 29        | 10005817       | SM15/64"×28销 | Moving Knife Link Pin     | 1          | ☆         |    |
| 30        | 10005846       | 弹簧           | Knife Return Spring, B    | 1          | ☆         |    |
| 31        | 10005782       | 离合架组件        | Clutch Plate Asm          | 1          | ☆         |    |
| 32        | 10005808       | 螺母           | Nut 15/64-28              | 1          | ☆         |    |
| 33        | 10005637       | 垫圈           | Washer 6.2×13×1           | 1          | ☆         |    |
| 34        | 10005781       | 挡线器拉杆        | Picker Link               | 1          | ☆         |    |
| 35        | 10005659       | 销            | Picker Link Pin           | 1          | ☆         |    |
| 36        | 10010074       | 螺钉           | Screw 11/64-40 L=7        | 2          | ☆         |    |
| 37        | 10005824       | 弹簧           | Clutch Return Spring      | 1          | ☆         |    |
| 38        | 10005818       | 剪线定位保护板      | Driving Arm Stopper       | 1          | ☆         |    |
| 39        | 10005816       | 剪线驱动座组件      | Base Plate Asm            | 1          | ☆         |    |
| 40        | 10012142       | 螺钉           | Screw 15/64-28 L=9        | 2          | ☆         |    |

## 11.2 自动剪线部件 (旋刀)

### THREAD TRIMMER COMPONENTS (Rotation knife)



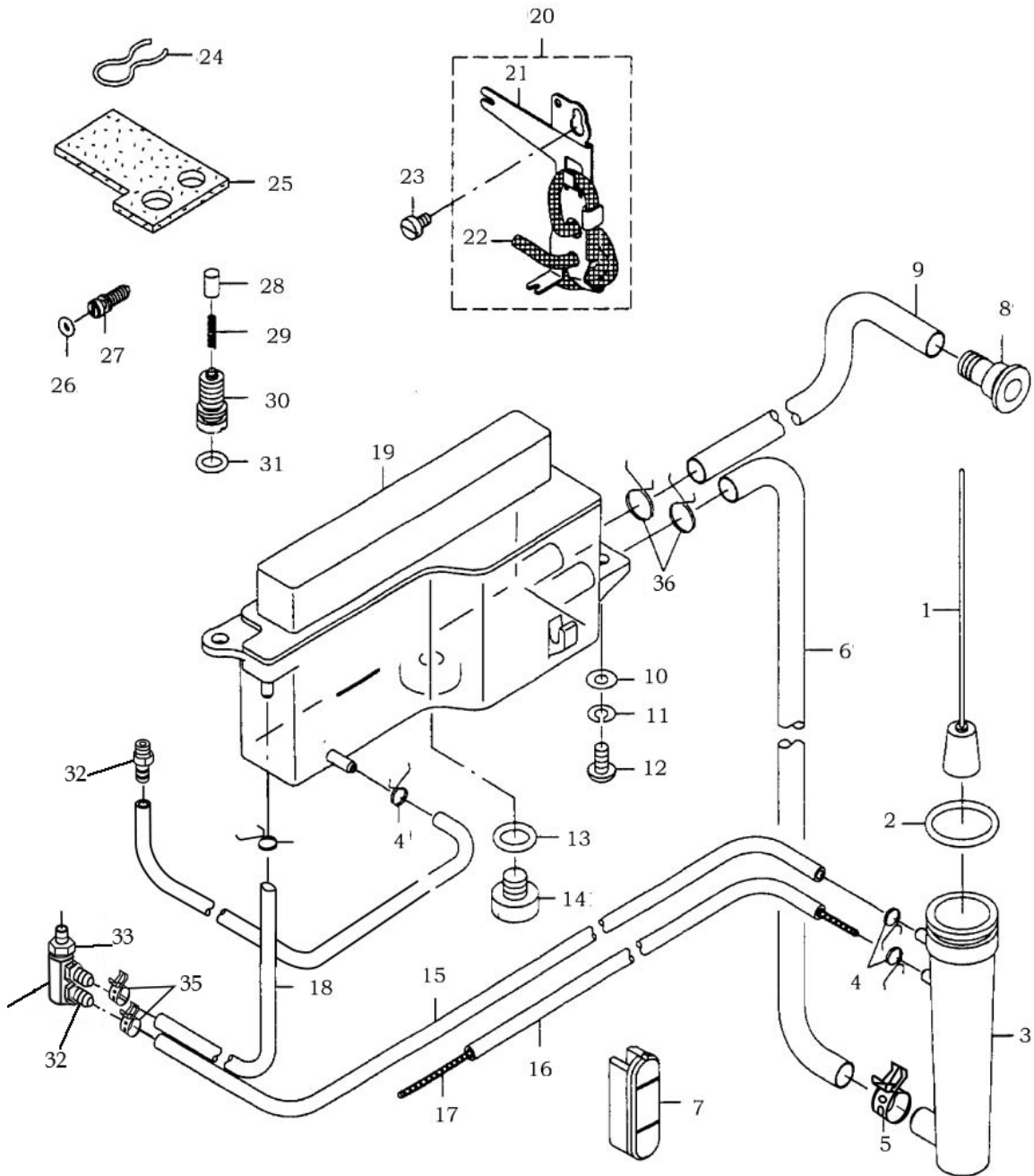
## 11.2、自动剪线部件

## THREAD TRIMMER COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称         | Name of the part             | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|------------|------------------------------|------------|-----------|----|
| 1         | 10011422       | 螺钉         | Screw 9/64-40                | 1          | ☆         |    |
| 2         | 10011421       | 定刀         | Fixed Knife                  | 1          | ☆         |    |
| 3         | 10011497       | 螺钉         | Screw 11/64-40               | 1          | ☆         |    |
| 4         | 10013154       | 垫圈         | Washer 9×4.5×0.8             | 1          | ☆         |    |
| 5         | 10011584       | 分线器        | Dispart Thread Shuttle       | 1          | ☆         |    |
| 6         | 10013333       | 螺钉         | Screw 3/16-32                | 1          | ☆         |    |
| 7         | 10013013       | 切线驱动曲柄     | Trimming Crank               | 1          | ☆         |    |
| 8         | 10013024       | 轴套         | Bushing                      | 1          | ☆         |    |
| 9         | 10012162       | M5×5螺钉     | Screw                        | 1          | ☆         |    |
| 10        | 10013027       | 轴套         | Short Bushing                | 1          | ☆         |    |
| 11        | 10013044       | 刀轴连杆       | Knife Shaft Connecting Bar   | 1          | ☆         |    |
| 12        | 10011514       | 螺钉         | Screw 11/64-40               | 2          | ☆         |    |
| 13        | 10013010       | 切线驱动曲柄止动块  | Crank Block                  | 1          | ☆         |    |
| 14        | 10010595       | M4×7.5螺钉   | Screw                        | 2          | ☆         |    |
| 15        | 10013023       | 弹簧固定板      | Fixed Plate                  | 1          | ☆         |    |
| 16        | 10009626       | M3×4.35螺钉  | Screw                        | 3          | ☆         |    |
| 17        | 10013026       | 刀架压板       | Knife Holder                 | 1          | ☆         |    |
| 18        | 10011588       | 螺钉         | Screw 11/64-40               | 2          | ☆         |    |
| 19        | 10011494       | 动刀         | Round Knife                  | 1          | ☆         |    |
| 20        | 10013045       | 动刀架        | Round Knife Bracket          | 1          | ☆         |    |
| 21        | 10011578       | 螺母         | Nut 11/64-40                 | 1          | ☆         |    |
| 22        | 10010736       | 剪线凸轮       | Thread Trimmer Cam           | 1          | ☆         |    |
| 23        | 10013465       | 螺钉         | Screw 1/4-40                 | 2          | ☆         |    |
| 24        | 10013030       | 弹簧         | Spring                       | 1          | ☆         |    |
| 25        | 10014462       | 轴套         | Bushing                      | 1          | ☆         |    |
| 26        | 10012162       | M5×5螺钉     | Screw                        | 1          | ☆         |    |
| 27        | 10013008       | 8.2垫圈      | Washer                       | 1          | ☆         |    |
| 28        | 10014196       | 扭簧端盖       | Spring Cover                 | 1          | ☆         |    |
| 29        | 10013007       | 切线驱动曲柄轴    | Trimming Crank Shaft         | 1          | ☆         |    |
| 30        | 10008812       | 弹簧         | Spring                       | 1          | ☆         |    |
| 31        | 10008862       | 螺钉         | Screw 1/4-40                 | 1          | ☆         |    |
| 32        | 10013878       | 切线凸轮曲柄组件   | Trimming Cam Crank Asm       | 1          | ☆         |    |
| 33        | 10013038       | 5挡圈        | Washer                       | 1          | ☆         |    |
| 34        | 10014460       | 8.2垫圈      | Washer                       | 1          | ☆         |    |
| 35        | 10011650       | 8.2×15×2垫圈 | Washer 8.2×15×2              | 1          | ☆         |    |
| 36        | 10011697       | 切刀驱动轴      | Trimming Shaft               | 1          | ☆         |    |
| 37        | 10013050       | 松线座        | Loosing Thread Plate         | 1          | ☆         |    |
| 38        | 10011605       | 螺钉         | Screw 1/4-28                 | 1          | ☆         |    |
| 39        | 10009471       | M4螺母       | Nut                          | 2          | ☆         |    |
| 40        | 10006131       | 剪线电磁铁安装座   | Solenoid Base                | 1          | ☆         |    |
| 41        | 10013046       | 剪线电磁铁连接体   | Solenoid Connecting Shaft    | 1          | ☆         |    |
| 42        | 10011845       | 垫圈         | Washer 5.2×12×2.5            | 1          | ☆         |    |
| 43        | 10011606       | 垫圈         | Washer 6.5×12×2.3            | 1          | ☆         |    |
| 44        | 10006137       | 剪线电磁铁      | Thread Trimmer Solenoid      | 1          | ☆         |    |
| 45        | 10013590       | 螺钉         | Screw 11/64-40               | 1          | ☆         |    |
| 46        | 10008834       | 松线复位弹簧     | Loosing Thread Return Spring | 1          | ☆         |    |
| 47        | 10012467       | 螺钉         | Screw 1/4-28                 | 1          | ☆         |    |

## 12、润滑部件

### OIL LUBRICATION COMPONENTS



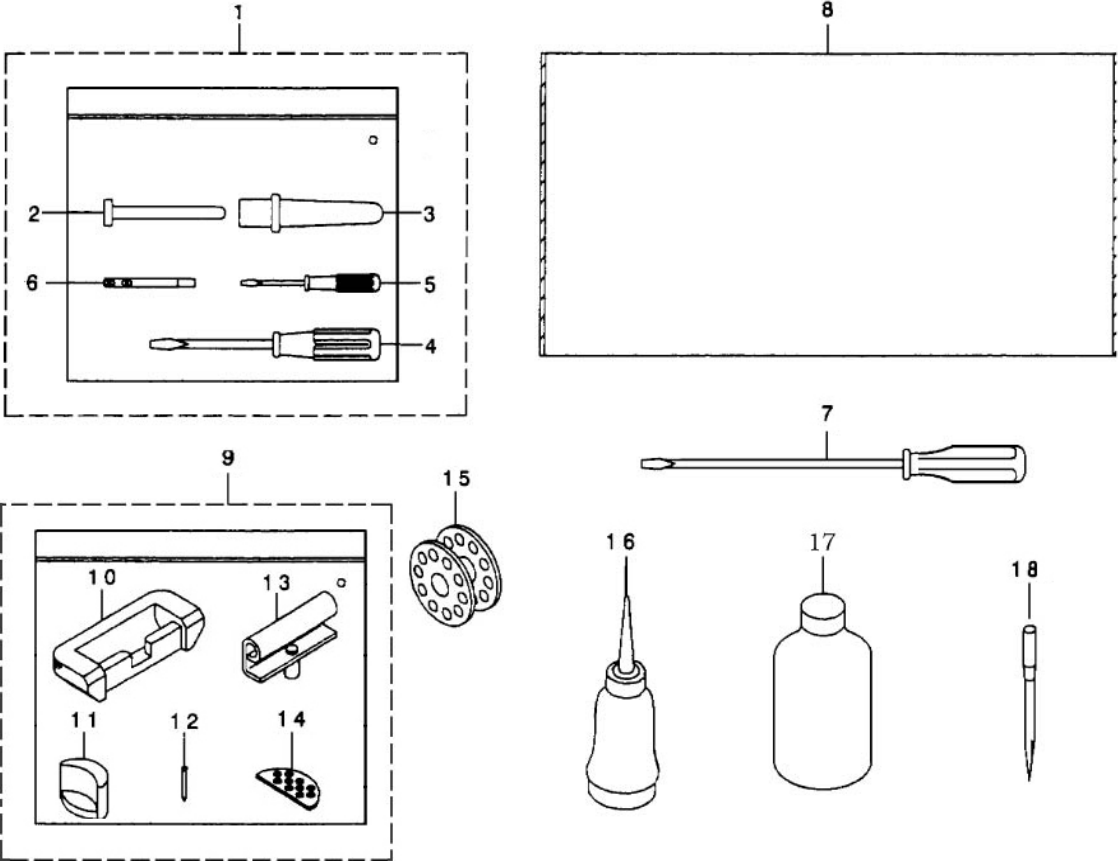
## 12、润滑部件

## OIL LUBRICATION COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称      | Name of the part         | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|---------|--------------------------|------------|-----------|----|
| 1         | 10000569       | 油标      | Floater Asm              | 1          | ☆         |    |
| 2         | 10008777       | 油杯O形圈   | Rubber Ring              | 1          | ☆         |    |
| 3         | 10008782       | 油杯      | Floater Cup              | 1          | ☆         |    |
| 4         | 10008781       | 小油管紧固簧  | Pipe Stopper             | 4          | ☆         |    |
| 5         | 10013048       | 弹簧      | Pipe Stopper             | 3          | ☆         |    |
| 6         | 10007806       | 油杯大油管   | Vinyl Tube, White, L=225 | 1          | ☆         |    |
| 7         | 10008772       | 油标窗     | Oil Sight Window         | 1          | ☆         |    |
| 8         | 10008780       | 加油杯     | Oil Cup                  | 1          | ☆         |    |
| 9         | 10007806       | 总进油管    | Vinyl Tube, White, L=240 | 1          | ☆         |    |
| 10        | 10003022       | 垫圈      | Washer                   | 1          | ☆         |    |
| 11        | 10005537       | 垫圈      | Spring Washer            | 1          | ☆         |    |
| 12        | 10008972       | 螺钉      | Screw 3/16-28            | 2          | ☆         |    |
| 13        | 10014461       | O形圈     | Rubber Ring              | 2          | ☆         |    |
| 14        | 10008783       | 螺钉      | Screw 5/16-24            | 2          | ☆         |    |
| 15        | 10007800       | 回油管     | Tube                     | 1          | ☆         |    |
| 16        | 10007800       | 机头润滑油管  | Tube                     | 1          | ☆         |    |
| 17        | 10008101       | 面部供油线   | Oil Wick                 | 1          | ☆         |    |
| 18        | 10007800       | 回油管     | Tube                     | 1          | ☆         |    |
| 19        | 10012669       | 油盒      | Oil Tank Asm             | 1          | ☆         |    |
| 20        | 20000165       | 面部油线板组件 | Oil Wick Support Asm     | 1          | ☆         |    |
| 21        | 10012616       | 面部油线板   | Oil Wick Support         | 1          | ☆         |    |
| 22        | 10008067       | 面部油线    | Oil Wick                 | 1          | ☆         |    |
| 23        | 10012664       | 螺钉      | Screw 9/64-40            | 1          | ☆         |    |
| 24        | 10012618       | 回油毡夹    | Oil Felt Presser         | 1          | ☆         |    |
| 25        | 10013020       | 毛毡      | Felt                     | 1          | ☆         |    |
| 26        | 10012606       | O形圈     | Rubber Ring              | 1          | ☆         |    |
| 27        | 10012667       | 螺钉      | Screw 11/64-40           | 1          | ☆         |    |
| 28        | 10012609       | 柱塞      | Plunger                  | 1          | ☆         |    |
| 29        | 10014386       | 柱塞簧     | Plunger Spring           | 1          | ☆         |    |
| 30        | 10013025       | 螺钉      | Screw 1/16-24            | 1          | ☆         |    |
| 31        | 10014461       | O形圈     | Rubber Ring              | 1          | ☆         |    |
| 32        | 10008779       | 油管接头    | Lubrication Connector    | 2          | ☆         |    |
| 33        | 10013012       | 螺母      | Tube                     | 1          | ☆         |    |
| 34        | 10013049       | 油管三接头   | Vitta Tie-in             | 1          | ☆         |    |
| 35        | 10012160       | 弹簧      | Pipe Stopper             | 4          | ☆         |    |
| 36        | 10008785       | 大油管紧固簧  | Pipe Stopper             | 3          | ☆         |    |

13、附件

ACCESSORIE PART COMPONENTS





## 13、附件

## ACCESSORIE PART COMPONENTS

| 序号<br>No. | 件号<br>Part No. | 名称          | Name of the part        | 数量<br>Qty. | 薄料<br>中厚料 | 厚料 |
|-----------|----------------|-------------|-------------------------|------------|-----------|----|
| 1         |                | 附件A         | Accessorie Bag Asm A    | 1          | ☆         |    |
| 2         | 10012631       | 抬压脚顶杆       | Knee Lifter Presser Rod | 1          | ☆         |    |
| 3         | 10026033       | 机头支柱        | Frame Support Bar       | 1          | ☆         |    |
| 4         | 10010995       | 中螺丝刀        | Screw Driver, Middle    | 1          | ☆         |    |
| 5         | 10013185       | 小螺丝刀        | Screw Driver, Small     | 1          | ☆         |    |
| 6         | 10005639       | 过线柱         | Needle Thread Guide Asm | 1          | ☆         |    |
| 7         | 10010994       | 大螺丝刀        | Screw Driver, Large     | 1          | ☆         |    |
| 8         | 10005776       | 机头罩         | Frame vinyl Cover       | 1          | ☆         |    |
| 9         |                | 附件B         | Accessorie Bag Asm B    | 1          | ☆         |    |
| 10        | 10006286       | 机头连接钩座      | Rubber Cushion          | 2          | ☆         |    |
| 11        | 10013113       | 油盘支座        | Oil Reservoir Seat      | 2          | ☆         |    |
| 12        | 10003889       | 油盘座钉        | Nail                    | 6          | ☆         |    |
| 13        | 10004466       | 机头连接钩部件     | Hinge Compl             | 2          | ☆         |    |
| 14        | 10013101       | 油盘座垫        | Oil Reservoir Cushion   | 2          | ☆         |    |
| 15        | 10010060       | 梭芯          | Bobbin                  | 3          | ☆         |    |
| 16        | 10013294       | 小油壶         | Oiler Asm               | 1          | ☆         |    |
| 17        | 10004455       | 油箱          | Oil Box                 | 1          | ☆         |    |
| 18        | 10004898       | DB×114#风琴机针 | Needle                  | 1          | ☆         |    |
|           | 10004868       | DP×518#风琴机针 | Needle                  | 1          |           | ☆  |