

# 一体式直驱带切刀平缝机

LOCKSTITCH MACHINE WITH VERTICAL EDGE TRIMMER

## 使用说明书

OPERATION MANUAL

## 零件手册

PARTS BOOK

# 使用说明

为使您正确使用本机,须对本机的各种功能充分了解,以便安全操作。

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

1. 无论您何时使用本机,须了解基本的安全事项,包括但不限于下列事项。
2. 通读所有说明,并保存好使用说明书。如果需要,请随时翻阅。
3. 使用本机前,必须弄清与本机有关安全规定、标准在您的国家是否适用。
4. 使用本机前或使用本机时,所有安全装置必须配备齐全。机器运转时,无安全装置属违章操作,决不允许。
5. 操作人员必须经过适当的培训。
6. 为了您的人身安全,我们建议您戴上防护上镜。
7. 下列情况下,请关闭电源开关或拔下电源插头:
  - 7-1 机针穿线和换梭心;
  - 7-2 更换机针、压脚、针板、送料牙、布料导板等;
  - 7-3 进行维修时;
  - 7-4 操作区无人时。
8. 在机器加油润滑时,若不小心让油接触眼睛、皮肤或咽下机油或润滑油,请立即清洗被沾染部位或去医院检查。
9. 无论机器运转与否,严禁乱动机器零部件和配套装置。
10. 机器的维修、改造和调整等工作必须由专业技术人员进行。
11. 应由专业受训人员进行一般的维修和检查工作。
12. 必须在专业电器人员或专业技术人员的指导下进行有关电器部件的维修,任何电器部件一经发现受损,立即停止机器运转。
13. 使用期间要定期全面彻底清洗机器。
14. 正常操作本机时,必须进行试运转,工作环境远离强噪音源,如高频电焊机等。
15. 由电气人员选择合适的插头和有地线的插座。
16. 若需要改造或改进本机,请采用有效可行的安全措施。本公司对由此而产生的伤害不承担责任。

17. 本机只适用于专业缝纫。

18. 两种警告提示符：



操作人员或维修人员请注意



特别注意事项

## INSTRUCTION MANUAL

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

Please read this Instruction Manual carefully before use.We hope you will enjoy the use of your machine for a long time.Please remember to keep this manual in a safe place.

1. Observe the basic safety measures, including, but not limited to the following ones, whenever you use the machine.
2. Read all the instructions, including, but not limited to this Instruction Manual before you use the machine, in addition, keep this Instruction Manual so that you may read it at any-time when necessary.
3. Use the machine after it has been ascertained that it conforms with safety rules/standards valid in your country.
4. All safety devices must be in position when the machine is ready for work or in operation The operation without the specified safety devices is not allowed.
5. This machine shall be operated by appropriately-trained operators.
6. For your personalprotection,we recommend that you wear safety glasses.
7. For the following, turn off the power switch of disconnect the power plug of the machine from the receptacle.
  - 7-1 For threading needle(s) and replacing bobbin.
  - 7-2 For replacing part(s) of needle, presser foot, throat plate, feed dog, cloth guide etc.
  - 7-3 For repair work.
  - 7-4 For when leaving the working place of when the working place is unattended.

8. If you should allow oil, grease, etc. used with the machine and devices to come in contact with your eyes or skin or swallow any of such liquid by mistake, immediately wash the contacted areas and consult a medical doctor.
9. Tampering with the live parts and devices, regardless of whether the machine is powered, is prohibited.
10. Repairing, remodeling and adjustment works must only be done by appropriately trained technicians or specially skilled personnel.
11. General maintenance and inspection works have to be done by appropriately trained personnel.
12. Repair and maintenance works of electrical components shall be conducted by qualified electric technicians or under the audit and guidance of specially skilled personnel. Whenever you find a failure of any of electrical components, immediately stop the machine.
13. Periodically clean the machine throughout the period of use.
14. Grounding the machine is always necessary for the normal operation of the machine. The machine has to be operated in an environment that is free from strong noise sources such as high-frequency welder.
15. An appropriate power plug has to be attached to the machine by electric technicians, Power plug has to be connected to grounded receptacle.
16. Remodel or modify the machine in accordance with the safety rules/standards while taking all the effective safety measures. We assume no responsibility for damage caused by remodeling or modification of the machine.
17. The machine is only allowed to be used for the purpose intended. Other uses are not allowed.
18. Warning hints are marked with the two shown symbols.



Danger of injury to operator or service staff



Items requiring special attention

# 安全操作事项

|                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                         |
|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
|  | <p>1. 为避免触电,请不要打开电机的电箱盖,也不要触摸电箱内部组件。</p>                                                                                                                                                                                                                                                                                                                                                                                                |
|  | <p>1. 为避免人身伤害,移动防护罩、护手挡或安全装置时,请不要开动机器。</p> <p>2. 为尽可以避免机器运转造成的人身伤害,手指、头部和衣服应远离上轮,上轮周围不要放置任何物品。</p> <p>3. 为避免人身伤害,当您打开电源开关或操作机器时,切勿将手放在机针下方。</p> <p>4. 为避免人身伤害,机器运转时,切勿将手放入挑线杆防护罩内。</p> <p>5. 旋梭运转时,勿将手指放在旋梭附近。另外,换梭芯时,请关掉机器电源开关。</p> <p>6. 为尽可以避免人身伤害,当翘起或抬起机头时,勿将手指放入机器内部。</p> <p>7. 为尽可以避免机器的突然启动所造成的事故,抬起机头时,请关掉机器的电源。</p> <p>8. 机器配有电机,机器未运转时,电机无噪音;为避免机器的突然启动所先造成的事故,请关掉机器的电源开关。</p> <p>9. 为尽可能避免触电或电器组件受损,在插上或拔下插头之前,请关掉电源开关。</p> |

# FOR SAFE OPERATION



1. To avoid electrical shock hazards, neither open the cover of the electrical box for the motor nor touch the components mounted inside the electrical box.



1. To avoid personal injury, never operate the machine with any of the belt cover, finger guard or safety devices removed.
2. To prevent possible personal injuries caused by being caught in the machine. Keep your fingers, head and clothes away from the handwheel, cover and the motor while the machine is in operation. In addition, place nothing around them.
3. To avoid personal injury, never put your hand under the needle when you turn ON the power switch or operate the machine.
4. To avoid personal injury, never put your fingers into the thread take-up cover while the machine is in operation.
5. The hook rotates at a high speed while the machine is in operation. To prevent possible injury to hands, be sure to keep your hands away from the vicinity of the hook during operation. In addition, be sure to turn OFF the power to the machine when replacing the bobbin.
6. To avoid possible personal injuries, be careful not to allow your fingers in the machine when tilting/raising the machine head.
7. To avoid possible accidents because of abrupt start of the machine, turn OFF the power to the machine when tilting the machine head.
8. If your machine is equipped with a servo-motor, the motor does not produce noise while the machine is at rest. To avoid possible accidents due to abrupt start of the machine, be sure to turn OFF the power to the machine.
9. To prevent possible accidents because of electric shock or damaged electrical component(s), turn OFF the power switch in prior to the connection /disconnection of the power plug.

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# 1 开车前的注意事项

## 1 Precautions Prior to Startup

1. 机头装箱前为了防止机件生锈,在部分均涂有较厚的防锈油脂,同时机头装箱后,还可能可能在较长的贮藏和长途运输阶段造成油脂硬化和在机器表面积聚灰尘,所以必须将表面的油脂和灰尘用汽油和洁净的软布擦拭干净。

2. 机器出厂时,虽经过周密的检查和试验,但在长途运输中也可能受到强烈的震动使机件松动或歪曲,所以应该做一次周密的检查,并用手转动上轮,看机件之间有无转动困难、碰撞现象或其它不均匀的阻力,不正常的声响,如有应作适当的调整,机器状态正常后才可正式试车。

3. 油箱内机油液面高度没有在正常范围内绝不能开车。

4. 机器运转时,上轮转向应该是逆时针方向(从上轮外侧面看)。

5. 确认电控铭牌上所标电压及相位是否正确。

6. 生产日期见合格证。

1.The machine head is coated with a thick layer of rust-prevention grease before encasement, and the encased machine head may possibly be subjected to grease hardening and dust buildup on the machine surface in process of long storage and long-haul traffic; therefore, take care to remove the grease and dust from the surface using soft cloth and gasoline.

2.Though the machine was inspected and tested with care before factory leaving, it might be affected by violent vibration resulting in looseness or distortion of the machine parts; therefore the operator shall thoroughly check the machine, turn the upper wheel by hand and check it for difficulty in free rotation, slight impact, and other uneven resisting force or abnormal noises, and make appropriate adjustment if any to restore the machine state before formal trial run.

3.Never start up the machine if the oil liquid level in the oil box falls outside the normal range.

4.The upper wheel shall rotate counterclockwise (when it is viewed from the lateral surface of the upper wheel) when the machine is operating.

5.Check whether the voltage and phases indicated on the electric-control data plate are correct.

6.The date of manufacture is indicated on the certificate of conformity.

# 2 使用注意事项

## 2 Precautions for Use

1. 当接通电源或机器运转时,请勿将手与机针接触。

2. 机器运转时,请勿将手指伸入挑线杆防护罩内。

3. 操作者用手送料时,请勿将手指伸入护针架。

4. 机头翻动及拆手盖时,一定要切断电源。

5. 操作者离开机器时,必须切断电源。
6. 机器运转时,绝不允许头或手以及任何东西靠近上轮、绕线器。
7. 只有在停机时,才能装卸防护罩或其它保护装置。
8. 不能用香蕉水等油漆稀释剂擦拭机头表面。

1.Never touch the needle by hand when the machine is powered on or while it is operating.

2.Never put your finger into the protection cover of take-up lever during operation of the machine.

3.The operator must not put his finger into the needle guard bracket when he feeds the sewing materials by hand.

4.Operator must trim off the electricity supply before he turns over the machine head or removes the hand cover.

5.The operator must trim off the electricity supply before he gets away from the machine.

6.Prohibit the head, hands and anything to approach the upper wheel and bobbin winder while the machine is operating.

7.Never remove or mount the protection cover or other protection devices before the machine is stopped.

8.Never wipe up the surface of machine head using paint thinner such as acetone.

### 3 主要技术规格 Main Technical Specifications

| 规 格        |     | 参 数           |
|------------|-----|---------------|
| 缝 料        |     | 薄料至中厚料        |
| 最高缝速       |     | 5000针/分       |
| 最大针距       |     | 5毫米           |
| 机 针        |     | DB×1 9# ~ 18# |
| 压脚提<br>升高度 | 手 控 | 6毫米(最大)       |
|            | 膝 控 | 13毫米(最大)      |
| 润滑系统       |     | 自动            |
| 润 滑 油      |     | 10号白油         |
| 电机功率       |     | 220伏/370瓦     |

| Specification               |             | Parmeter                                       |
|-----------------------------|-------------|------------------------------------------------|
| Application                 |             | For light materials and medium heavy materials |
| Max sewing speed            |             | 5000RPM                                        |
| Max stitch length           |             | 5mm                                            |
| Needle                      |             | DB×1 9# ~ 18#                                  |
| Presser foot<br>lift height | Hand lifter | 6mm(Max)                                       |
|                             | Knee lifter | 13mm(Max)                                      |
| Lubricating system          |             | Auto                                           |
| Lubrication oil             |             | 10# White oil                                  |
| Motor power                 |             | 220V/370W                                      |

## 4 机器的安装 (图1、图2、图3、图4) Mounting the Machine (Fig.1, Fig. 2, Fig.3 and Fig. 4)

### 1.油盘的安装

- 1) 油盘②应放置在台板上的凹槽四角上。
- 2) 将两只机头座垫①安装在油盘②的A边 (朝操作者一边), 将两只油盘支座③安装在油盘②的B边 (机头连接钩接合一边), 然后放上油盘②。

3) 将机头连接钩⑤插入底板销孔内, 与台板的机头连接钩座④相嵌合再把机头放到油盘四只角的机头座垫上。

### 1.Fixing oil tray

1) Put the oil tray ② on the four groove corners on the sewing table.

2) Fix two arm cushion ① to the A side of oil tray ② (facing the operator). Fix the two stand bases ③ to the B side of oil tray ② (hinge side), then fix the oil tray ②.

3) Insert machine head coupling hook ⑤ into the pin holes in the bottom plate such that it is embedded into the coupling hook seat ④, and put the machine head onto the seating washer on four corners of the oil tray.

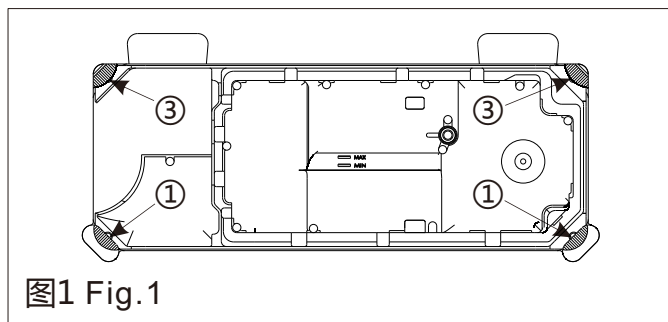


图1 Fig.1

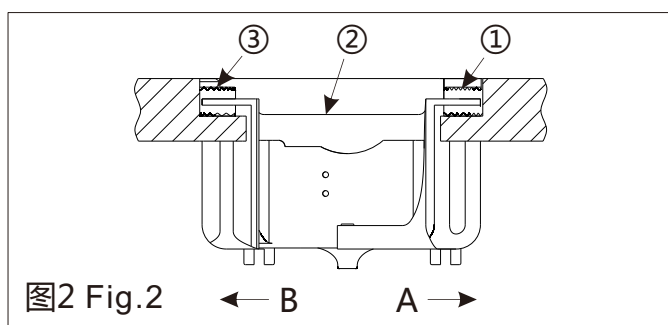


图2 Fig.2

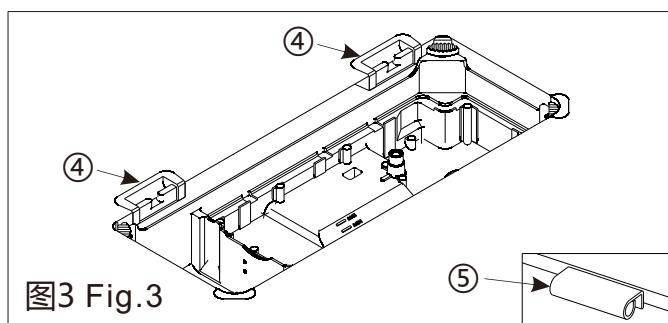


图3 Fig.3

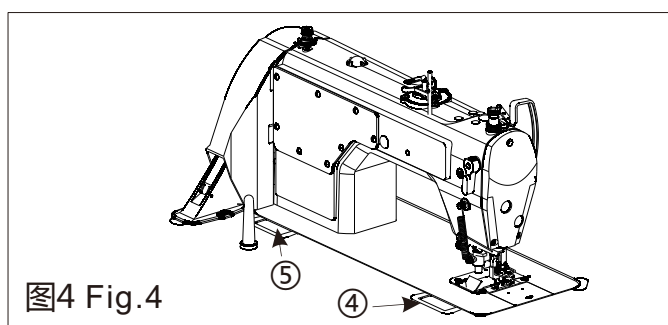


图4 Fig.4

## 5 机器的润滑 (图5) Lubrication (Fig.5)

### 1.润滑须知

- 1) 向油盘①注入缝纫机油 (10号白油) 至“MAX”记号部A。
- 2) 当油面低于MIN记号B时, 应再加油。

### 1.Information on lubrication

- 1) Fill oil pan ① with sewing machine oil (10 while oil) up to MAX mark A.
- 2) When the oil level lowers below MIN mark B, refill the oil pan with the specified oil.

3) 加油后，开动机器，应看到油液飞溅到油窗②上，说明润滑正常。

4) 至于飞溅的油量多少与总润滑油量多少无关。

3) When you operate the machine after lubrication, you will see splashing oil through oil sight window ② if the lubrication is adequate.

4) Note that the amount of the splash oil is unrelated to the amount of the lubricating oil.



注意:



1. 为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



Caution:



1. To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.

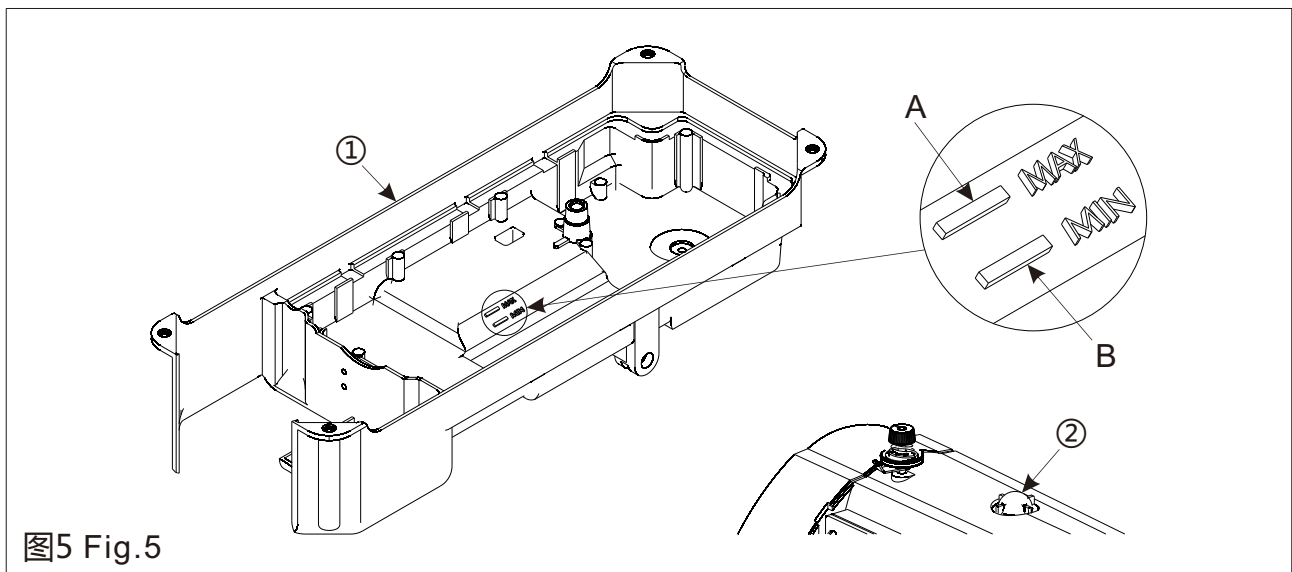


图5 Fig.5

## 6 旋梭油量调节 (图6、图7、图8) Oil mass Adjustment of Rotating Hook (Fig. 6, Fig. 7, Fig. 8)

### 1. 调节方法

1) 旋梭的油量是用旋梭油量调节螺钉①来调节：当旋梭油量调节螺钉朝 + 方向A转动时，油量将增大；朝 - 方向B转动时，油量将减小。

2) 调节油量后缝纫机应进行约30秒钟的空转，以确认油量状态。

### 1. Adjustment method

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

2) When adjustment of oil mass is over, allow the sewing machine to idle for about 30 seconds to confirm the state of oil mass.



注意:



1. 为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



Caution:



1. To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.

## 2.油量的确认方法

1) 机头冷却时, 请进行三分钟左右的空转(适当的间歇运转)。

2) 请在缝纫机转动时将油量确认专用纸插入(具体操作见图8所示)。

3) 油量确认时间为5秒。



注意:



- 1.进行上述操作时, 确认油盘内的油面高度处在“MAX”和“MIN”范围内。
- 2.旋梭是高速运转的。为了防止人身事故, 调节油量时, 要充分注意手指不要碰到旋梭。

### 1. Confirming the Oil Mass

1) To cool down the machine head, allow it idle for about 3 minutes (appropriate discontinuous running).

2) Insert the special oil mass confirmation paper when the sewing machine is rotating (detailed operations are described in Fig. 8).

3) Oil mass confirmation time lasts for 5 seconds.



Caution:



1. Prior to the above-mentioned operation, Make sure the oil height in the oil plate ranges between MAX and MIN.
2. Rotating hook works at high speed. To prevent human injury, the operator shall keep his fingers away from the rotating hook during oil mass adjustment.

### 3. 油量适合标样

1) 右图标样(见图8)根据不同的缝制工序需求进行增或减的微调整, 但应注意不要增加或减少过多。油量过少时会引起旋梭发热, 油量过多时会污染缝料。

2) 用油量确认专用纸测试三次, 直至确认3次油量确认专用纸油迹均无变化为止。

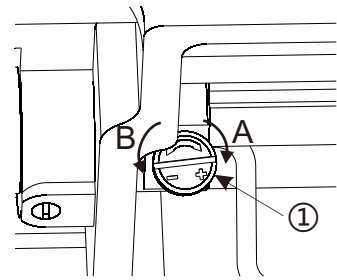
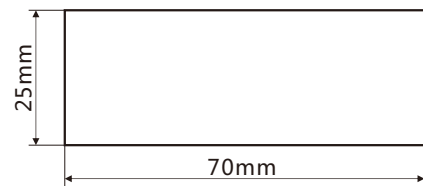


图6 Fig.6

#### ① 油量确认专用纸

Special oil mass confirmation paper



#### ② 油量确认位置

Position for oil mass confirmation

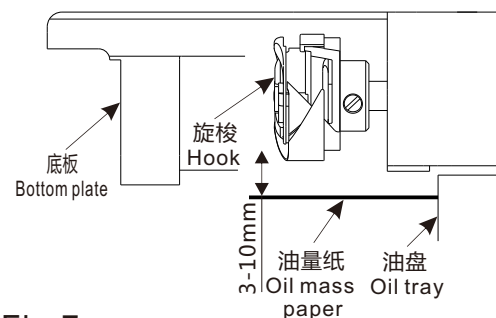
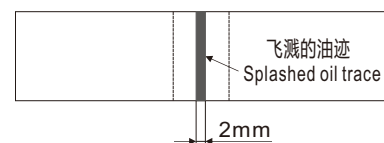


图7 Fig.7

油量小  
MIN



油量大  
MAX

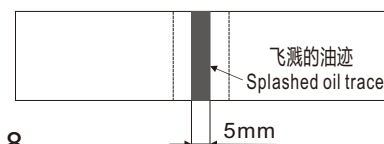


图8 Fig.8

### 3. Guide sample of oil mass adequacy

1) The guide sample shown in the right-hand figure (see Fig. 8) may be finely adjusted (increased or reduced) as per different sewing processes; however, excessive increase or reduction shall be avoided. Too little oil mass may lead to rotating hook heating, and overmuch oil mass may lead to contamination of the sewing materials.

2) Test the oil mass 3 times using special oil mass confirmation paper till the oil traces indicated by the special paper show no changes.

## 7 机针的装法 (图9) Mounting the Needle (Fig.9)

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



注意:

1. 为了防止缝纫机的意外启动，请关掉电源之后再进行操作。
2. 机针有各种编号，请根据所用线的粗细和缝料来选择适当的机针。

1. Turn the upper wheel to allow the needle to reach its maximum height.

2. Unscrew needle carrying screw ②, hold needle ① by hand, and align the indentation A of needle to right direction B.

3. Insert the needle into the bottom of needle hole in direction of arrow till it reaches the end point.

4. Screw down the needle carrying screw ②.

5. Take care to ensure that the elongated slot C on the needle is aligned to the left direction D.



Caution:

1. To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.
2. Needles are available in different sizes. Please select appropriate needle as per the thickness of threads and the sewing materials.

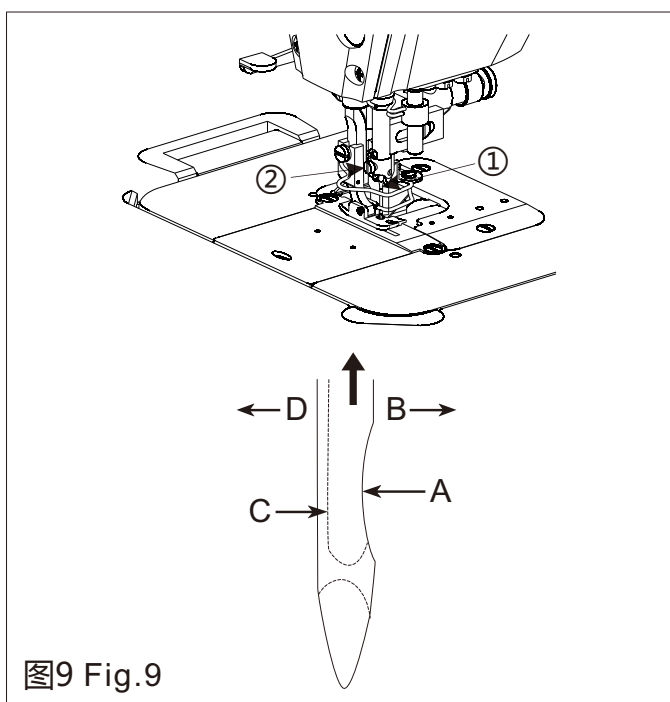


图9 Fig.9

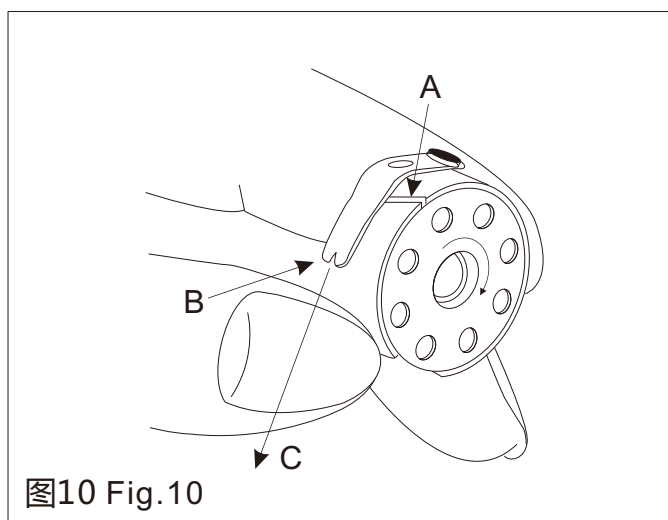


图10 Fig.10

## 8 梭芯的装法 (图10) Mounting the Bobbin (Fig. 10)

1. 拿住梭子，将梭芯装入梭子内。
2. 将线从梭子上的线槽A中穿过，朝C方向拉出。这样，线通过夹线簧从孔B处引出。
3. 拉底线时，梭芯应按箭头方向顺时针转动。

1. Hold the rotating hook by hand, and fit the bobbin into the rotating hook.
2. Thread the thread through the thread groove in the rotating hook, and draw out the thread in direction C. In this way, the thread is led out of hole B through the tension spring.
3. When bobbin thread is drawn, the bobbin shall turn clockwise in direction of arrow.

## 9 面线的穿法 (图11) Threading the Needle Thread (Fig. 11)

穿面线时针杆应在最高位置，然后由线架上引出线头按图示序号顺序进行穿线。

Thread the needle thread when needle bar stays in its highest position, lead out the thread end from the thread stand, and conduct threading as per the serial numbers indicated in the figure.

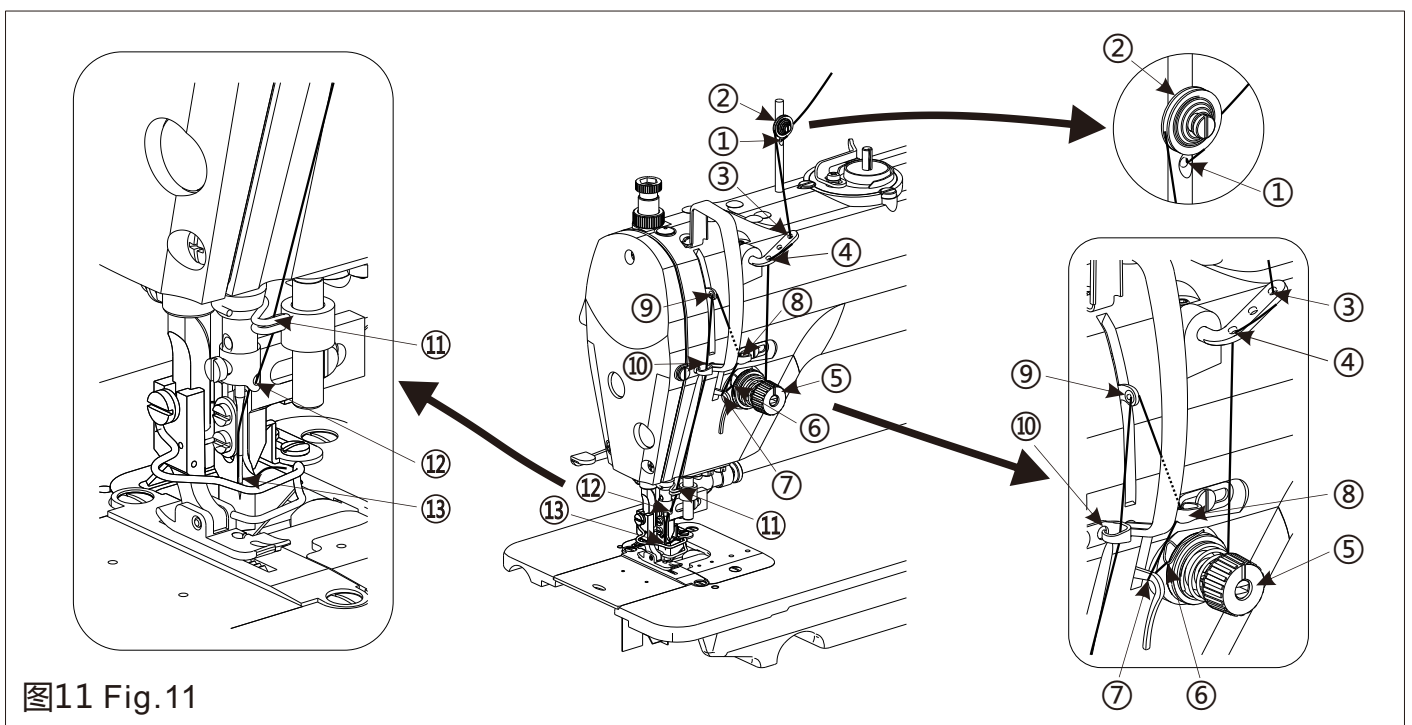


图11 Fig.11

## 10 底线的卷绕 (图12、图13) Winding up the Bobbin Thread (Fig. 12, Fig. 13)

1. 底线卷绕的方法
  - 1) 把梭芯①装到绕线轴②上。
  - 2) 把线架右侧的卷线如右图所示穿线，并把线端向右缠绕梭芯数圈。
  - 3) 把卷绕手柄③推到A方向，然后运转缝纫

1. Bobbin thread winding-up method
  - 1) Fit bobbin ① onto spool ②.
  - 2) Thread the right-hand thread coiling on thread stand as shown in right-hand figure, and reel the thread end rightwards onto the bobbin for several turns.
  - 3) Push winding lever ③ over to direction

机。梭芯①向C方向转动，线卷绕到梭芯①上。卷绕线满后卷绕手柄③自动向B方向弹开并停止卷绕。

4) 取下梭芯①，用绕线切刀④切断机线。



注意:

1.卷绕底线时，请将要卷绕的底线处于梭芯①和夹线板③之间拉线状态下开始绕线。

2.不进行缝制时给梭芯①绕底线时，请把面线从挑线杆孔上抽出来，把梭芯①从旋梭里卸下来后再进行。

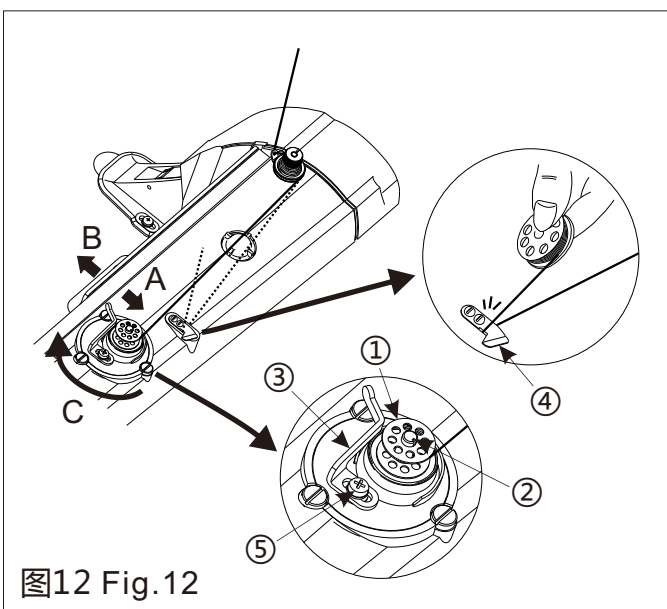


图12 Fig.12

## 2.底线卷绕的调节

1) 调整底线卷线量时，请拧松固定螺钉⑤，把卷绕手柄③移动到A方向或B方向，然后再固定螺钉⑤。A方向变少，B方向变多。

2) 如果线不能平绕梭芯时，请拧松螺母⑥，转动绕线夹线器，调整夹线板⑦的高度：

a.旋梭①中心和夹线板⑦中心高度一样时为标准位置。

b.下部卷的多时，向如右图D方向移动绕线夹线器的位置，上部卷的多时，向如右图E方向移动绕线夹线器的位置。

A, and run the sewing machine. Bobbin ① is rotated in direction C, and thread is reeled onto bobbin ①. Once the reel is full, winding lever ③ is pushed toward direction B, and winding is over.

4) Remove bobbin ①, and trim off the thread using winding trimmer ④.



Caution:

1.To reel the bobbin thread, set the bobbin thread to between bobbin ① and thread gripper plate ③ in taking-up mode, and start thread winding.  
2.To reel bobbin thread onto bobbin ① when no sewing is performed, draw the needle thread out of hole in the take-up lever, remove bobbin ① out of rotating hook.

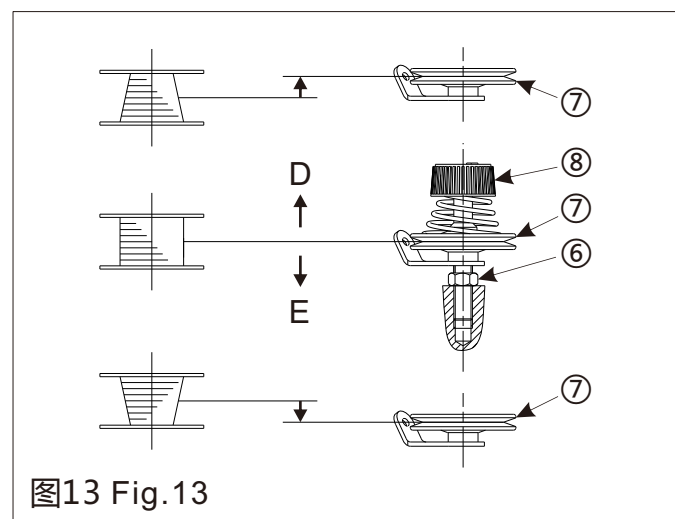


图13 Fig.13

## 1.Adjusting the bobbin thread winding

1)To adjust the winding capacity of bobbin thread, unscrew fixing screw ⑤, set winding lever ③ in direction A or direction B, and fix screw ⑤ again. Direction A is intended for reduction, and direction B is intended for increase.

2)If thread cannot be wound onto the bobbin flatly, unscrew nut ⑥, turn the winding tension disco, and adjust the height of height of thread gripper plate ⑦.

a.The standard position is reached once the center heights of rotating hook ① and thread gripper plate ⑦ are identical.

c.调整绕线夹线器到合适位置后，把固定螺钉⑥拧紧。

3) 调整底线卷绕张力时，请转动线张力螺母⑧进行调整。

b.If the winding amount on the lower part is bigger, move the winding tension disc in direction D indicated in the right-hand figure. If the winding amount on upper part is bigger, move the winding tension disc in direction E indicated in the right-hand figure.

c.When the winding tension disc reaches its suitable position, screw down fixing screw ⑥.

3)Adjust the winding tension of bobbin thread by turning thread tension nut ⑧.

## 11 针距的调节 (图14) Adjusting the Stitch Length (Fig. 14)

1.将送料距旋钮①朝箭头方向转动，旋至所需数字对准机壳上的刻点A。

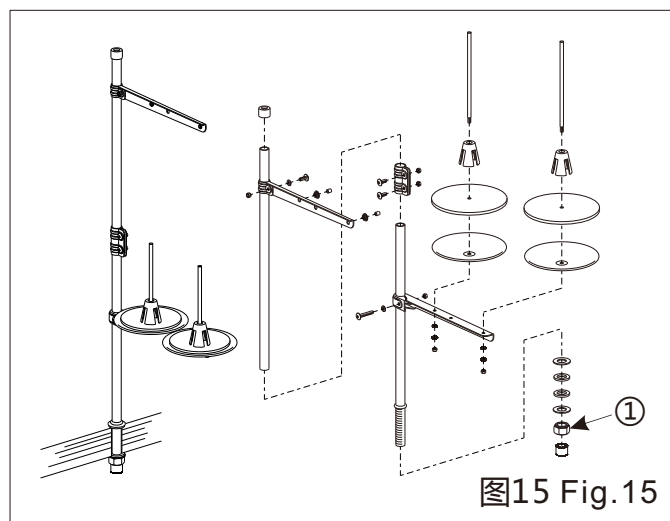
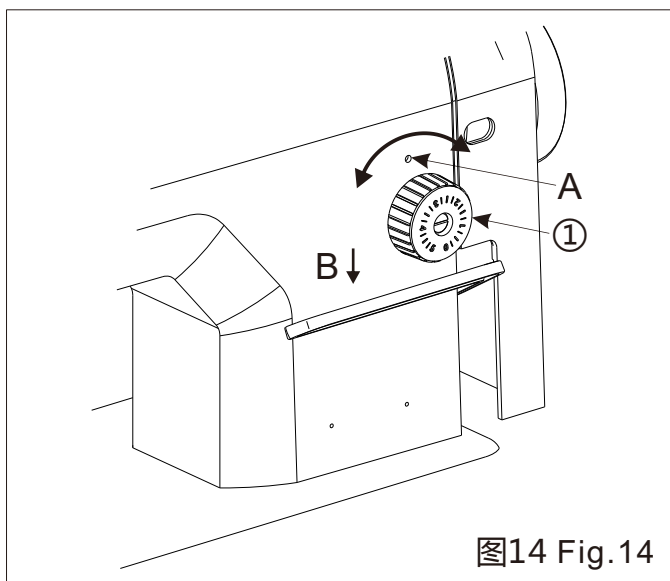
2.旋钮上的刻度数字用毫米表示。

3.当你想缩短线迹长度时，把倒送料扳手②朝B方向压下的同时并转动送料距旋钮。

1.Turn stitch length dial ① in the direction of the arrow, and align the desired number to marker dot "A" on the machine arm.

2.Scale mark digits are expressed on the knob in millimeters.

3.To reduce the stitch length, hold down the reverse feed lever ② in direction B, and turn the feeding distance knob.



## 12 线架的安装(图15) Mounting the Thread Stand (Fig.15)

1.如右图所示那样将线架部件安装到缝纫机台板线架安装孔上。

2.旋紧线架杆下节固定螺母①固定线架。

1.As shown in right-hand figure, mount the thread stand component onto the mounting hole for thread stand on the sewing machine table.

2.Screw down retaining nut ① for lower segment of thread stand lever to fix the thread stand.

## 13 膝提高度的调节 (图16、图17) Adjusting the Knee Lifting Height (Fig.16, Fig. 17)

- 1.膝提时的标准高度是10mm。
- 2.用膝提调整螺钉①可以调节压脚提升量，最大可至13毫米。



注意:



- 1.为了防止缝纫机的意外启动，请关掉电源之后再进行操作。
- 2.当压脚提升超过10mm时，请不要运转缝纫机，因为针杆②与压脚③会相碰。

1.Standard knee lifting height is 10mm.

2.Knee-lifting adjusting screw ① may be used to adjust the lifting amount of presser foot, and the maximum lifting amount may reach 13mm.



Caution:



- 1.To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.
- 2.When the presser foot lifting exceeds 10mm, do not run the sewing machine because needle bar ② may collide with presser foot ③.

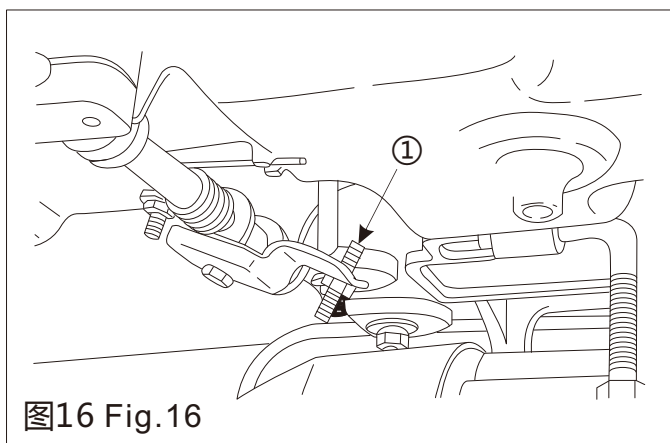


图16 Fig.16

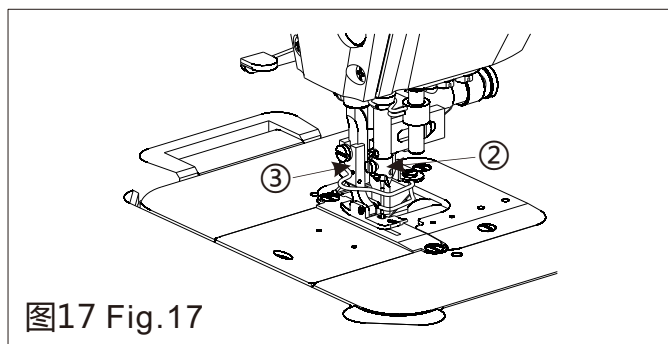


图17 Fig.17

## 14 挑线簧的调节 (图18、图19) Adjusting the Take-up Spring (Fig.18, Fig. 19)

### 1.挑线簧摆动量的调节

1) 若将夹线器⑤中的螺钉③朝顺时针方向(即A方向)转动时，挑线簧①的摆动量将增大；若朝逆时针方向(即B方向)转动时，挑线簧①的摆动量将减小。

### 2.挑线簧张力的调节

1) 旋松螺钉②，取出夹线器⑤(组件)。

2) 旋松线器⑤中螺钉④。

3) 若将夹线器⑤中的螺钉③朝顺时针方向(即A方向)转动时，挑线簧①的张力将增大；若逆时针方向(即B方向)转动时，挑线簧①的张力将减小。

### 1.Adjusting the oscillating quantity of take-up spring

1) The oscillating quantity of take-up spring ① is increased if screw ③ in tension disco ⑤ is turned clockwise (namely in direction A), and it ① is reduced if the screw is turned counter clockwise (namely in direction B).

### 2.Adjusting the tension of take-up spring

1) Unscrew screw ②, and take out tension disco ⑤(assembly).

2) Unscrew screw ④ in tension disco ⑤.

3) The tension of take-up spring ① is increased if screw ③ in tension disco ⑤ is turned clockwise (namely in direction A), and it ① is reduced if the screw is turned counterclockwise (namely in direction B).

4) 调节结束后旋紧螺钉④，并将夹线器⑤(组件)装入机器中再旋紧螺钉②。

### 3.挑线簧调整适当的判断依据

1) 确认挑线簧①的张力调整后，把面线向B方向拉出，如果在挑线簧①达到最低位置之前面线B处就被拉动,请减弱挑线簧①的张力。

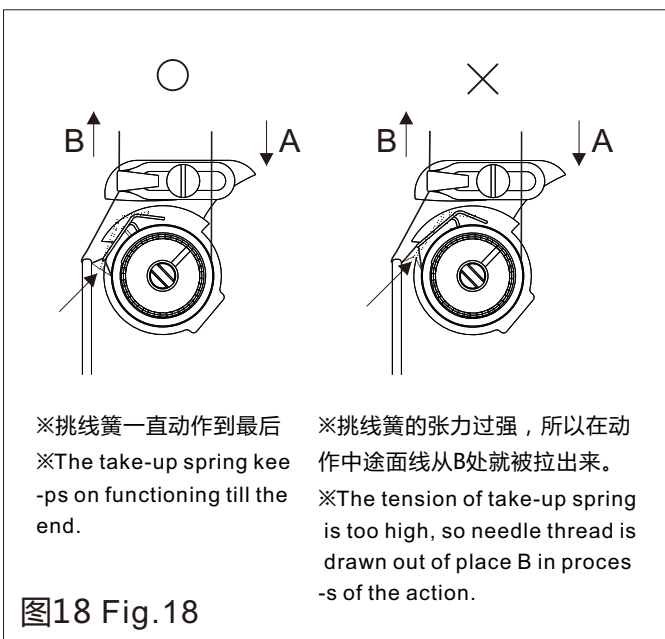


注意:



1.为了防止缝纫机的意外启动，请关掉电源之后再进行操作。

2.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。



4) Screw down screw ④ when adjustment is over, fit tension disco ⑤(assembly) into the machine, and screw down screw ②.

### 3.Judgment basis for adjustment adequacy of take-up spring

1) Confirm that the tension of take-up spring ① is properly adjusted, draw out the needle thread in direction B. If place B of needle thread is drawn before take-up spring ① reaches its lowest position, reduce the tension of take-up spring ①.

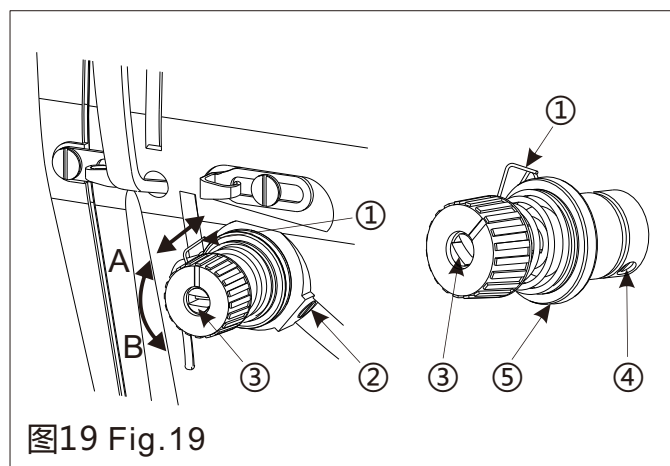


Caution:



1.To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.

2.The take-up spring is already adjusted properly before the machine leaves the factory as a rule, and it requires readjustment only for sewing of special materials or usage of special stitch threads.



## 15 缝线张力调整 (图20) Adjusting the Tension of Stitch Thread (Fig.20)

### 1.面线张力的调节

1) 若将夹线器中的调节螺母①朝顺时针方向(即A方向)转动时，面线张力将增大；若朝逆时针方向(即B方向)转动时，面线张力将减小。

### 2.底线张力的调节

1) 若将夹线螺钉②朝顺时针方向(即C方向)转动时，底线张力将增大；若朝逆时针方向(即D方

### 1.Adjusting the tension of needle thread

1) The tension of needle thread is increased if the adjusting nut ① in tension disco is turned clockwise (namely in direction A), and it is reduced if the nut is turned counterclockwise (namely in direction B).

### 2.Adjusting the tension of bobbin thread

1) The tension of bobbin thread is increased if the adjusting screw ② is turned clockwise (namely in direction A), and it is reduced if it

向)转动时，底线张力将减小。



注意:



- 1.为了防止缝纫机的意外启动，请关掉电源之后再进行操作。

the screw is turned counterclockwise (namely in direction B).



Caution:



1. To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.

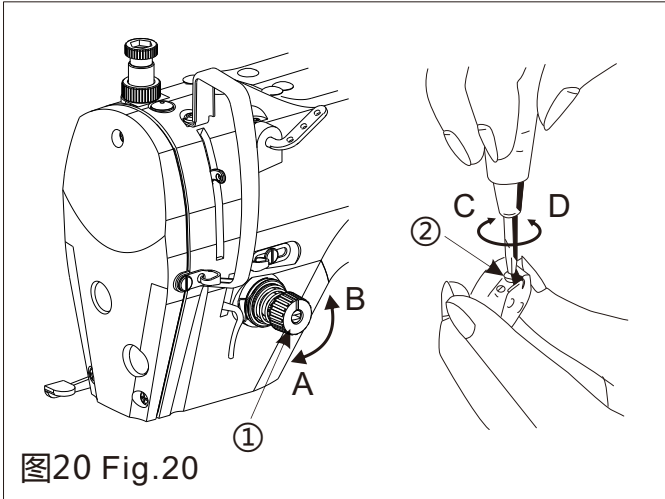


图20 Fig.20

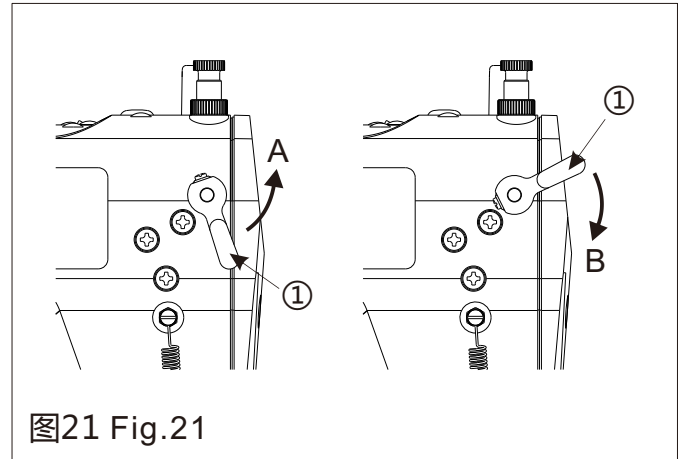


图21 Fig.21

## 16 压脚扳手 (图21) Presser Foot Lever (Fig.21)

1. 停车后将压脚扳手①朝A方向转动使压脚抬起(压脚的抬起量约为6mm)。
2. 当压脚扳手①朝B方向转动时，压脚将放回原来的位置。

1. Shut down the machine, turn presser foot lever ① in direction A to uplift the presser foot (for about 6mm).
2. When presser foot lever ① is turned in direction B, presser foot will be returned to its original position.

## 17 挑线杆挑线量的调节 (图22) Adjusting the Take-up Amount of Take-up Lever (Fig.22)

1. 右线钩上的刻线C与螺钉中心一致时为标准位置。
2. 缝制厚料时，应旋松螺钉①再将右线钩②朝左方向(即A方向)移动，以增大挑线量，调节完成后旋紧螺钉①。
3. 缝制薄料时，应旋松螺钉①再将右线钩②朝右方向(即B方向)移动，以减小挑线量，调节完成后旋紧螺钉①。

1. The standard position is obtained when graduation line C on right thread hook is aligned to screw center.
2. For thick material sewing, unscrew screw ① and move right thread hook ② to the left (namely in direction A) to increase the take-up amount, and screw down screw ① when adjustment is over.
3. For thin material sewing, unscrew screw ① and move right thread hook ② to the right (namely in direction B) to reduce the take-up amount, and screw down screw ① when adjustment is over.



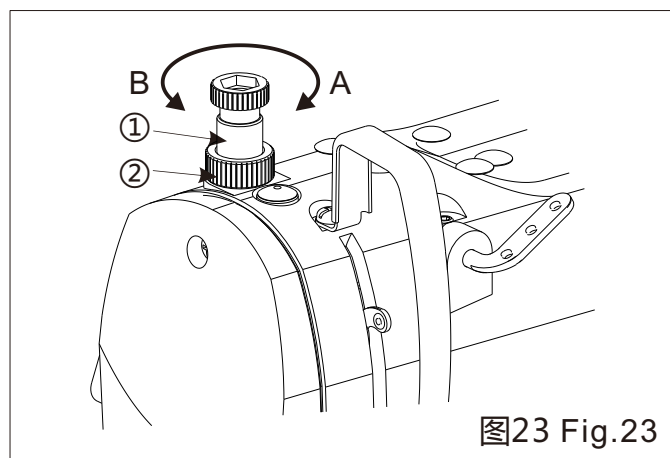
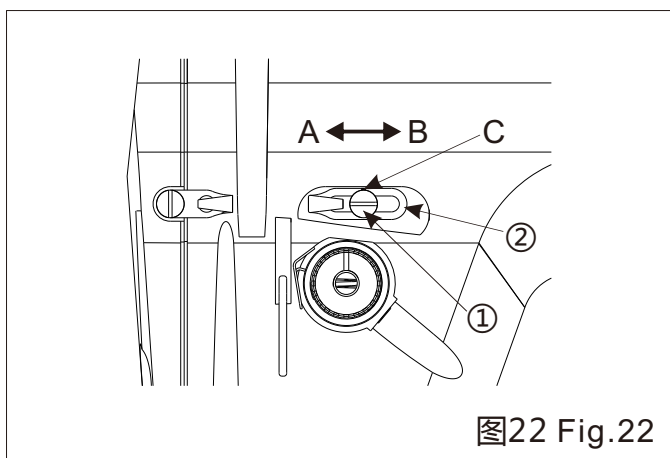
注意:

- 1.为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



Caution:

- 1.To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.



## 18 压脚压力的调节 (图23) Adjusting the Presser Foot Pressure (Fig.23)

- 1.旋松调压螺母②。
- 2.若将调压螺钉①朝顺时针方向(即A方向)转动时，压脚压力将增强；若朝逆时针方向(即B方向)转动时，压脚压力将减弱。
- 3.调节完成后旋紧调压螺母②。

- 1.Unscrew pressure adjusting nut ②.
- 2.Presser foot pressure is increased if pressure adjusting screw ① is turned clockwise (namely in direction A); the pressure is reduced if the screw is turned counterclockwise (namely in direction B).
- 3.Screw down pressure adjusting nut ② when adjustment is over.



注意:

- 1.为了防止缝纫机的意外启动，请关掉电源之后再进行操作。
- 2.对一般布料而言，调压螺钉①的标准高度为32~34毫米，(4.5公斤力)左右。



Caution:

- 1.To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.
- 2.When the presser foot lifting exceeds 10mm, do not run the sewing machine because needle bar ② may collide with presser foot ③.

## 19 手动抬压脚高度的调节 (图24) Adjusting the Manual Foot Lifting Height (Fig.24)

- 1.将压脚扳手朝顺时针转动使压脚抬起，旋松压杆导架紧固螺钉①，上下移动压杆②来调节手动抬压脚高度(压脚高度为针板面与压脚底面的距离，手动抬压脚高度的标准值为6mm)。
- 2.调节结束后，拧紧压杆导架紧固螺钉①。

- 1.Turn clockwise the presser foot lever to up-lift the presser foot, unscrew tightening screw ① of presser bar spring bracket, moving upward/downward pressure bar ② to adjust the manual foot lifting height (presser foot height indicates the distance from the surface of needle plate to the bottom surface of presser foot, and



注意:

- 1.为了防止缝纫机的意外启动，请关掉电源之后再进行操作。

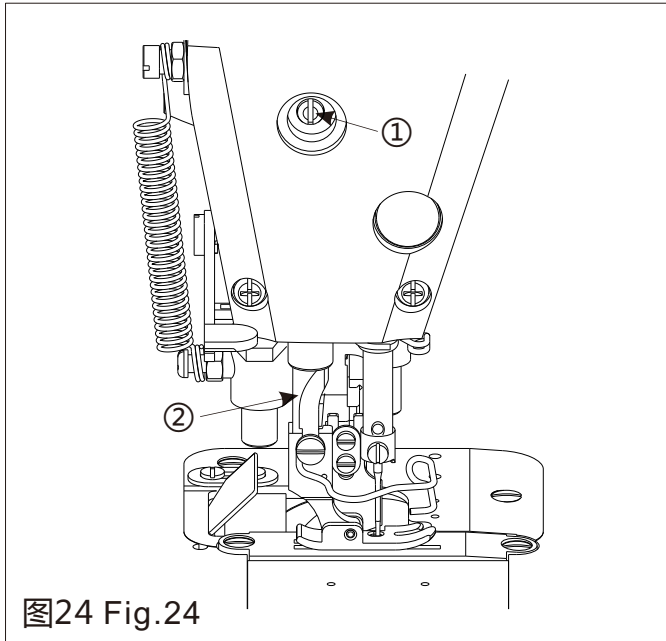


图24 Fig.24

- the standard value of manual foot lifting height is 6mm).
2. When adjustment is over, screw down tightening screw ① of presser bar spring bracket.



Caution:

1. To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.

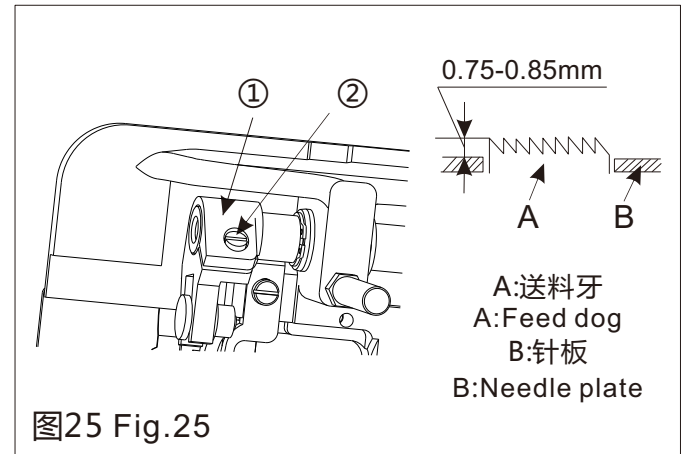


图25 Fig.25

## 20 送料牙的高度 (图25) Height of the feed dog (Fig.25)

- 1.送料牙一般应比针板高出0.75-0.85毫米。
- 2.送料牙高度的调节
  - 1) 旋松抬牙叉形曲柄①的紧固螺钉②。
  - 2) 上下移动牙架进行调节。
  - 3) 旋紧曲柄螺钉②。

1. The feed dog is factory-adjusted so that it just out from the throat plate 0.75 to 0.85mm.
2. To adjust the height of the feed dog
  - 1) Loosen screw ② of crank ①.
  - 2) Move the feed bar up or down to make adjustment.
  - 3) Securely tighten screw ②.



注意:

- 1.为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



Caution:

1. To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.

## 21 送料牙的倾斜 (图26) To tilt the feed dog (Fig.26)

- 1.标准的倾斜，是在牙架销上的刻点A与牙架座①上的刻点对齐。
- 2.为了防止浮线，要送料方向高，则旋松固定螺钉，用螺丝刀把牙架销朝箭头方向转动90°。

1. For standard adjustment, align point A with point ①.
2. To prevent thread float, it has to make the sending direction higher, so loose the screw and turn the feeding bar shaft 90° in the direction of the arrow with a screwdriver.

3.为了防止缝料的潜移，要送料方向低，则牙架销朝箭头相反方向转动90°。

3.To prevent uneven material feed , turn the feeding bar shaft 90° in the opposite direction from the arrow with a screwdriver.



注意:



1.为了防止缝纫机的意外启动，请关掉电源之后再进行操作。

2.无论什么时候，调节送料牙的倾斜，送料牙的高度会发生变化；所以，在调整之后，请再次确认送料牙的高度。



Caution:



1.To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.

2.Whenever make the adjustment , the height of the feed dog changes. so after adjustment , please check the height of the feed dog again.

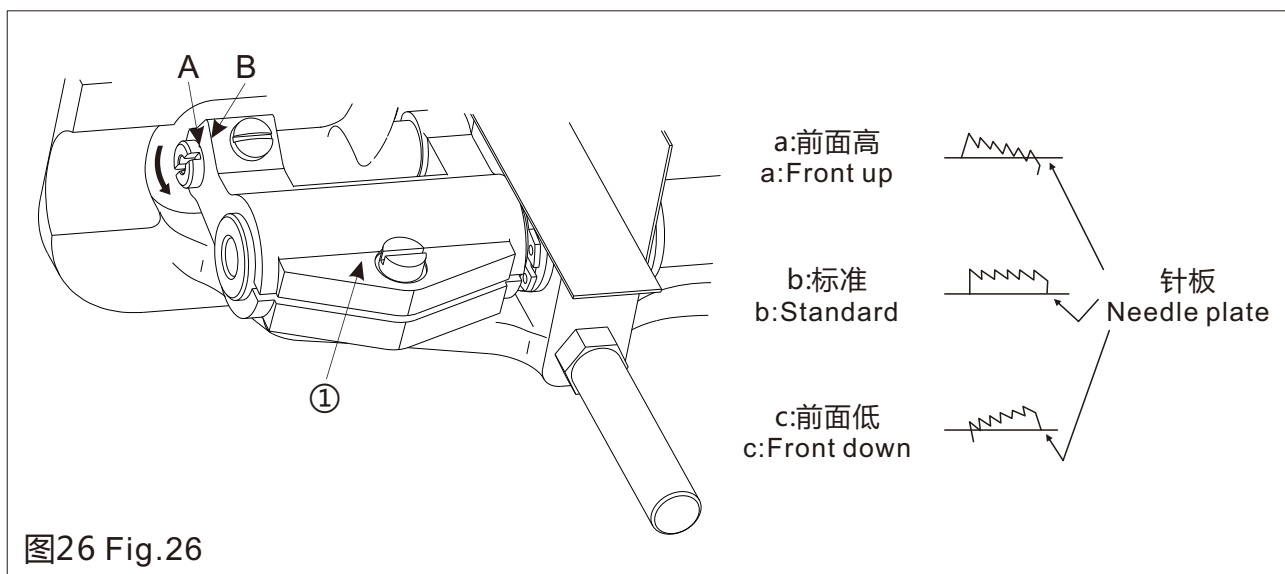


图26 Fig.26

## 22 送料相位的调节 (图27) Adjusting the feed timing (Fig.27)

1.在标准相位下，将送料偏心轮①的定位螺钉A与上轴挡圈②的定位螺钉B对齐。

2.调整时，旋松送料偏心轮上的两个定位螺钉③，将送料偏心轮调到适当的位置上，然后拧紧定位螺钉。

3.为了防止缝料的潜移，要加快送料相位，可将送料偏心轮朝箭头方向调整。

4.调为了增大线迹的紧密度，要减慢送料相位，可将送料偏心轮朝箭头相反方向移动。

1.To obtain the standard feed timing align setscrew "A" on feed eccentric cam ① with setscrew "B" on main shaft thrust collar ②.

2.To make adjustment , loosen two setscrews ③ to release the feed eccentric cam , properly position the eccentric cam. Then retighten the setscrews.

3.To advance the feed timing in order to prevent uneven material feed , move the feed eccentric cam in the direction of the arrow.

4.To delay the feed timing in order to increase stitch tightness , move the feed eccentric cam in the opposite direction for the arrow.



注意:



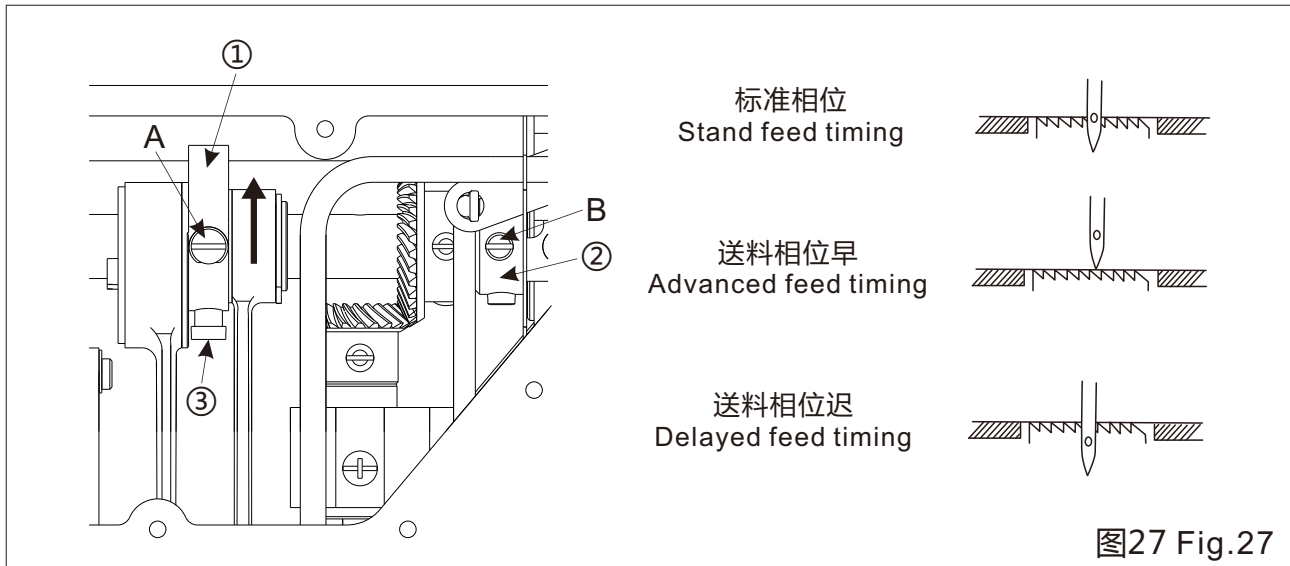
- 1.为了防止缝纫机的意外启动，请关掉电源之后再进行操作。
- 2.千万小心不要将送料偏心轮移动得太多，不然会造成断针现象。



Caution:



- 1.To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.
- 2.Be careful not to move the feed eccentric cam too far, or else needle breakage may result.



## 23 机针与旋梭的位置的调整 (图28)

### Adjusting the Positions of Needle and Rotating Hook (Fig.28)

1.转动上轮，使针杆下到最低点，再旋松针杆连接柱紧固螺钉①。

2.使针杆②上的刻线A对准针杆下轴套③的下端，然后旋紧针杆连接柱紧固螺钉①。

3.旋松3颗旋梭紧固螺钉并转动上轮，使针杆②的上刻线B对准针杆下轴套③的下端。

4.移动旋梭使旋梭的勾线尖⑤对准机针④的缺口处并使机针④的缺口处与旋梭的勾线尖⑤间隙为0.04~0.1mm，然后拧紧旋梭紧固螺钉。

1.Turn the upper wheel to allow the needle bar to reach its lowest point, and unscrew trip bolt ① of needle bar joint pin.

2.Align graduation line A on needle bar ② to the lower end of lower shaft sleeve ③ of needle bar, and screw down tightening screw ① of needle bar joint pin.

3. Unscrew 3 tightening screws of rotating hook, turn the upper wheel, and align graduation line B on needle bar ② to the lower end of lower shaft sleeve ③ of needle bar.

4.Move the rotating hook such that its thread hooking tip ⑤ is aligned to the notch on needle ④, ensure that the clearance between notch on needle ④ and thread hooking tip ⑤ ranges from 0.04 to 0.1mm, and screw down the tightening screw of rotating hook.



注意:



- 1.为了防止缝纫机的意外启动，请关掉电源之后再进行操作。
- 2.若机针④的缺口处与旋梭勾线尖⑤的间隙过小，会磨损旋梭梭尖；若间隙过



Caution:



- 1.To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.

大，会引起跳动针。

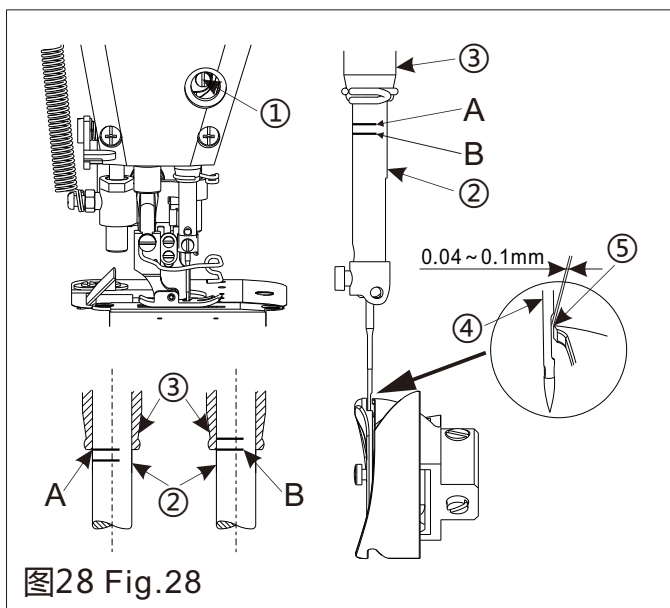


图28 Fig.28

2.If the clearance between notch on needle ④ and thread hooking tip ⑤ of rotating hook is too small, rotating hook tip may be worn; if the clearance is excessive, skipped stitch may take place.

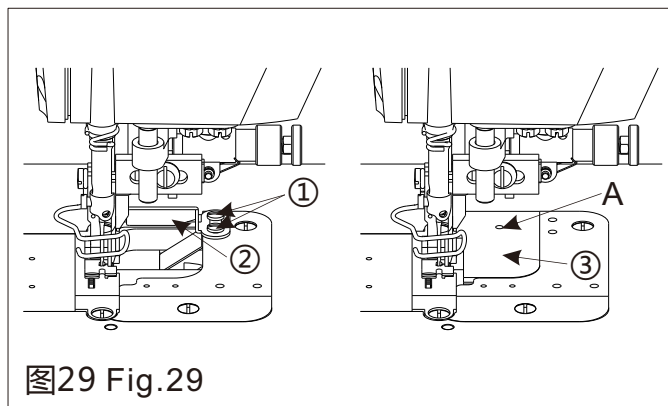


图29 Fig.29

## 24 排屑孔盖板的使用 (图29) The use of clearance hole cover (Fig.29)

1.不使用切刀时，请先将两布屑导板螺钉①和布屑导板②卸下，然后把排屑孔盖板盖到排屑斗板③上，请从A部上方按下。

2.排屑孔盖板牢固的盖好后，就可作普通的平缝机使用。

1.When not in use the cutting knife , please unload the two cloth scraps guides screws ① and cloth scraps guides ② first,then put the clearance hole cover onto the plate ③ , press the A section from above.

2.After clearance hole cover firmly covered , you can make an ordinary sewing machine use.



注意:



1.为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



Caution:



1.To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.

## 25 切刀的更换与安装 (图30) The replacenment and installation of cutting knife (Fig.30)

### 1.切刀的操作

1) 让切刀动作时，请沿箭头方向按压控刀扳手①，使切刀⑥下降，刀架导向架与缝纫机同时驱动。

2) 让切刀停止动作，转换为普通平缝机时，请沿箭头方向拉出控刀拉钮②即可。

### 2.切刀的装法

### 1.The operation of cutting knife

1) When operate cutting knife , please press control Knife wrench ① in the direction of the arrow , make cutting knife ⑥ drop ,the knife holder guide frame and sewing machine drive at the same time.

2)Let the cutting knife stop action , when converted into ordinary sewing machine , please pullout knob ② in direction of the arrow .

### 2.The installation method of cutting knife

1) Loosen the screw ③ of knife holder , mov

1) 拧松刀架螺钉③，移动刀架④。

2) 拧松两切刀螺钉⑤，按如图所示装上切刀⑥。

3) 按下控刀扳手①，转动上轮使切刀⑥下降到最低点时，上下移动切刀⑥，让切刀⑥的A部比针板⑦上平面低0-0.5mm，并交替拧紧两切刀螺钉⑤。

4) 移动刀架④，让切刀⑥的刀刃接触到针板⑦的刀刃上，然后拧紧刀架螺钉②。

### 3. 切断宽度的变更

切断宽度通过更换针板组件来决定的。

#### 1) 针板组件的更换

a. 拧松刀架螺钉③，移动刀架④。

b. 卸下两针板螺钉⑧，按如图所示取下针板⑦，换上要更换的针板，然后将两针板螺钉⑧装上。

c. 移动刀架④，让切刀⑥的刀刃接触到针板⑦的刀刃上，然后拧紧刀架螺钉③。

-e the knife holder ④.

2) Loosen the two screws ⑤ of cutting knife, install the cutting knife ⑥ as shown in Figure .

3) Press Control Knife wrench ①, turn the hand wheel, move cutting knife ⑥ up and down when the cutting knife ⑥ dropped to the lowest point, let the A portion of cutting knife ⑥ lower than the needle plate ⑦ 0-0.5mm, then tighten the two screws ⑤ of cutting knife alternately .

4) Move the knife holder ④, let the blade of cutting knife ⑥ contact the blade of needle plate assembly, then tighten the screws ② of knife holder.

### 3. The change of cutting width

The cutting width is decided By changing the needle plate assembly .

1) Replacement of the needle plate assembly.

a. Loosen the screw ③ of knife holder, move the knife holder ④.

b. Remove the two screws ⑧ of needle plate, remove the needle plate ⑦ as shown in Figure, Replace the needle plate that is needed to replace, then install the two needle plate screws ⑧ .

c. Move the knife holder ④, let the blade of cutting knife ⑥ contact the blade of needle plate ⑦ assembly, then tighten the screws ③ of knife holder.



注意:



1. 为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



Caution:



1. To prevent the unexpected startup of sewing machine, trim off the power supply before the operation is conducted.

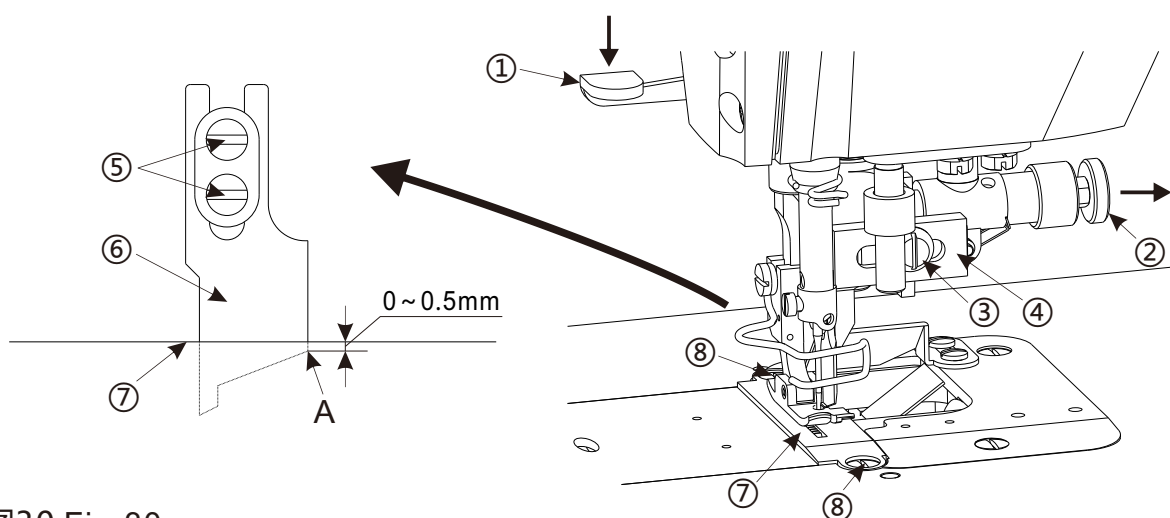


图30 Fig.30

## 26 其他零件的更换 Changing other parts

本机配置的标准裁断宽度是1/8in(3.2mm)。根据用户需求，我们还另外配置了其他规格的裁断宽度，如需更换，请参阅下表更换零件。

Standard configuration of the machine cutting width is 1/8 in(3.2mm) . According to user needs , we also additionally equipped with other specifications of the cutting width, see the following table to replace parts if you need to replace.

| 裁断宽度          | 件 号      |          |          |
|---------------|----------|----------|----------|
|               | 针板       | 送料牙      | 压脚       |
| 1/8in(3.2mm)  | 10045639 | 10044601 | 10044596 |
| 3/16in(4.8mm) | 10046026 | 10044601 | 10044596 |
| 1/4in(6.4mm)  | 10046025 | 10046027 | 10046028 |

| Cutting width | Part NO.     |          |              |
|---------------|--------------|----------|--------------|
|               | Needle plate | Feed dog | Presser foot |
| 1/8in(3.2mm)  | 10045639     | 10044601 | 10044596     |
| 3/16in(4.8mm) | 10046026     | 10044601 | 10044596     |
| 1/4in(6.4mm)  | 10046025     | 10046027 | 10046028     |

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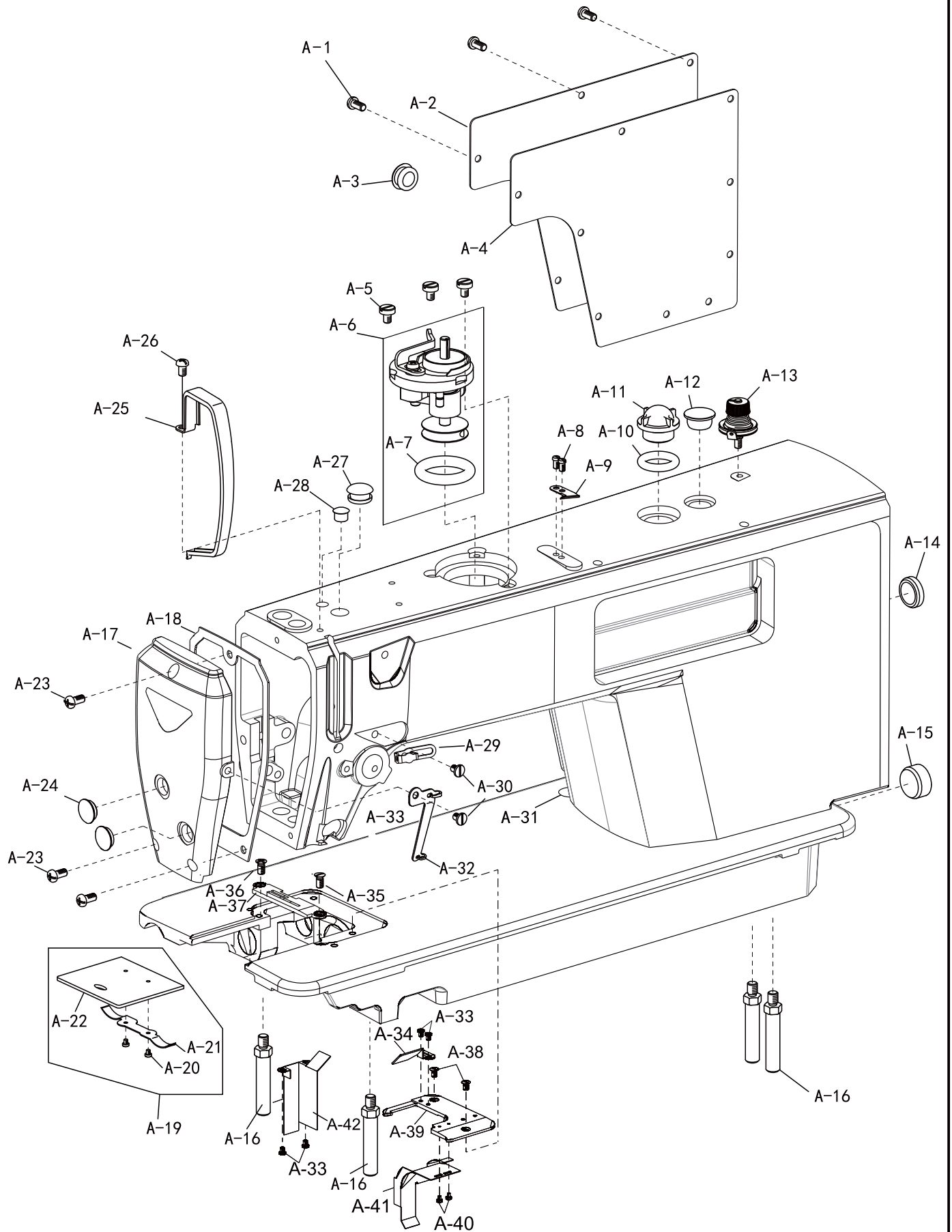
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# A

## 机壳分组件

## Machine frame & miscellaneous cover components

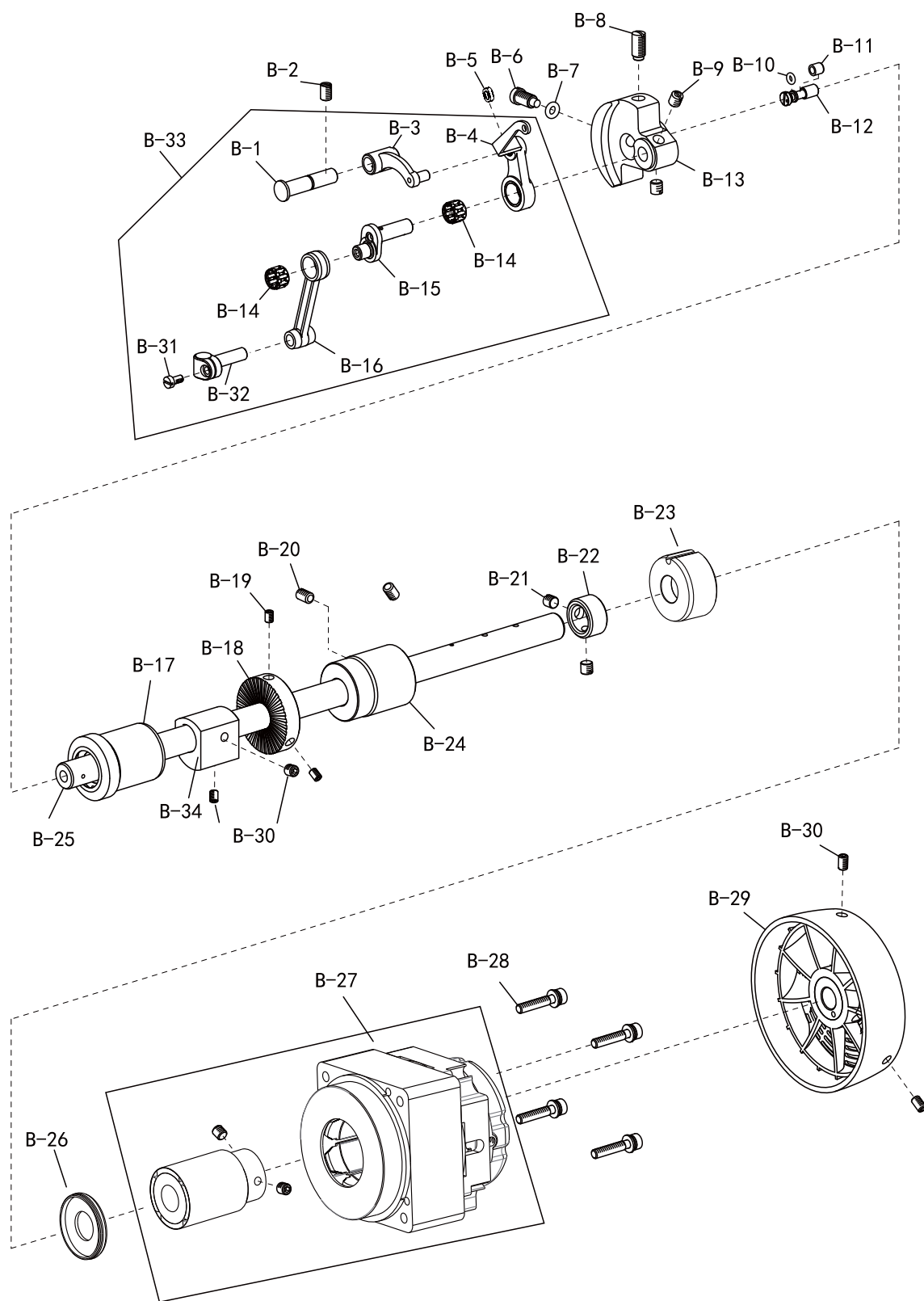


A

机壳分组件

Machine frame&amp;miscellaneous cover components

| 序 号<br>Ref.No. | 物 料 号<br>Part.No. | 名 称           | Description                | 数量<br>Q'ty | 备 注<br>Remark |
|----------------|-------------------|---------------|----------------------------|------------|---------------|
| A-1            | 10008972          | 螺钉            | Screw                      | 9          |               |
| A-2            | 20021544          | 后窗板           | Side plate                 | 1          |               |
| A-3            | 10008977          | 橡胶塞           | Rubber plug                | 1          |               |
| A-4            | 10058208          | 后窗板垫          | Side plate gasket          | 1          |               |
| A-5            | 10004380          | 螺钉            | Screw                      | 3          |               |
| A-6            | 10031086          | 绕线器           | Bobbin wider ASM.          | 1          |               |
| A-7            | 10008773          | 橡胶轮           | Rubber ring                | 1          |               |
| A-8            | 10050423          | 螺钉            | Screw                      | 2          |               |
| A-9            | 10011149          | 绕线切刀          | Thread cutter              | 1          |               |
| A-10           | 10008939          | O形圈           | O-ring                     | 1          |               |
| A-11           | 10008938          | 油窗            | Oil window                 | 1          |               |
| A-12           | 10009576          | 橡胶塞           | Rubber plug                | 1          |               |
| A-13           | 10059716          | 绕线夹线器         | Bobbin thread tension ASM. | 1          |               |
| A-14           | 10008975          | 橡胶塞           | Rubber plug                | 1          |               |
| A-15           | 10008941          | 橡胶塞           | Rubber plug                | 1          |               |
| A-16           | 10002577          | 底板支柱          | Bed screw stud             | 4          |               |
| A-17           | 20022331          | 面板            | Face plate                 | 1          |               |
| A-18           | 10058098          | 面板垫           | Face plate gasket          | 1          |               |
| A-19           | 10013706          | 推板部件          | Side plate ASM.            | 1          |               |
| A-20           | 10010080          | 螺钉            | Screw                      | 2          |               |
| A-21           | 10003963          | 推板簧           | Spring of side             | 1          |               |
| A-22           | 10003960          | 推板            | Side plate                 | 1          |               |
| A-23           | 10008972          | 螺钉            | Screw                      | 3          |               |
| A-24           | 10008977          | 橡胶塞           | Rubber plug                | 2          |               |
| A-25           | 200004035         | 挑线杆防护罩        | Thread take-up lever cover | 1          |               |
| A-26           | 10008934          | 螺钉            | Screw                      | 1          |               |
| A-27           | 10008942          | 橡胶塞           | Rubber plug                | 1          |               |
| A-28           | 10008943          | 橡胶塞           | Rubber plug                | 1          |               |
| A-29           | 10008940          | 右线钩           | Arm thread guide right     | 1          |               |
| A-30           | 10008973          | 螺钉            | Screw                      | 2          |               |
| A-31           | 100005289         | 电线过线套         | Rubber plug                | 1          |               |
| A-32           | 10040996          | 左线钩           | Arm thread guide left      | 1          |               |
| A-33           | 10045276          | SM9/64"×40螺钉  | Screw SM9/64"×40           | 4          |               |
| A-34           | 10045827          | 布 导板          | Scraps guide plate         | 1          |               |
| A-35           | 10009005          | 螺钉            | Screw                      | 1          |               |
| A-36           | 10012463          | 螺钉            | Screw                      | 1          |               |
| A-37           | 10045639          | 1/8针板         | Needle plate 1/8           | 1          |               |
| A-38           | 10011566          | SM11/64"×40螺钉 | Screw SM11/64"×40          | 4          |               |
| A-39           | 10045826          | 排 斗板          | Clearance hole plate       | 1          |               |
| A-40           | 10010744          | SM3/32"×56螺钉  | Screw SM3/32"×56           | 2          |               |
| A-41           | 10045828          | 排 斗           | Clearance-hole             | 1          |               |
| A-42           | 10045829          | 挡 板           | Shelter scraps plate       | 1          |               |

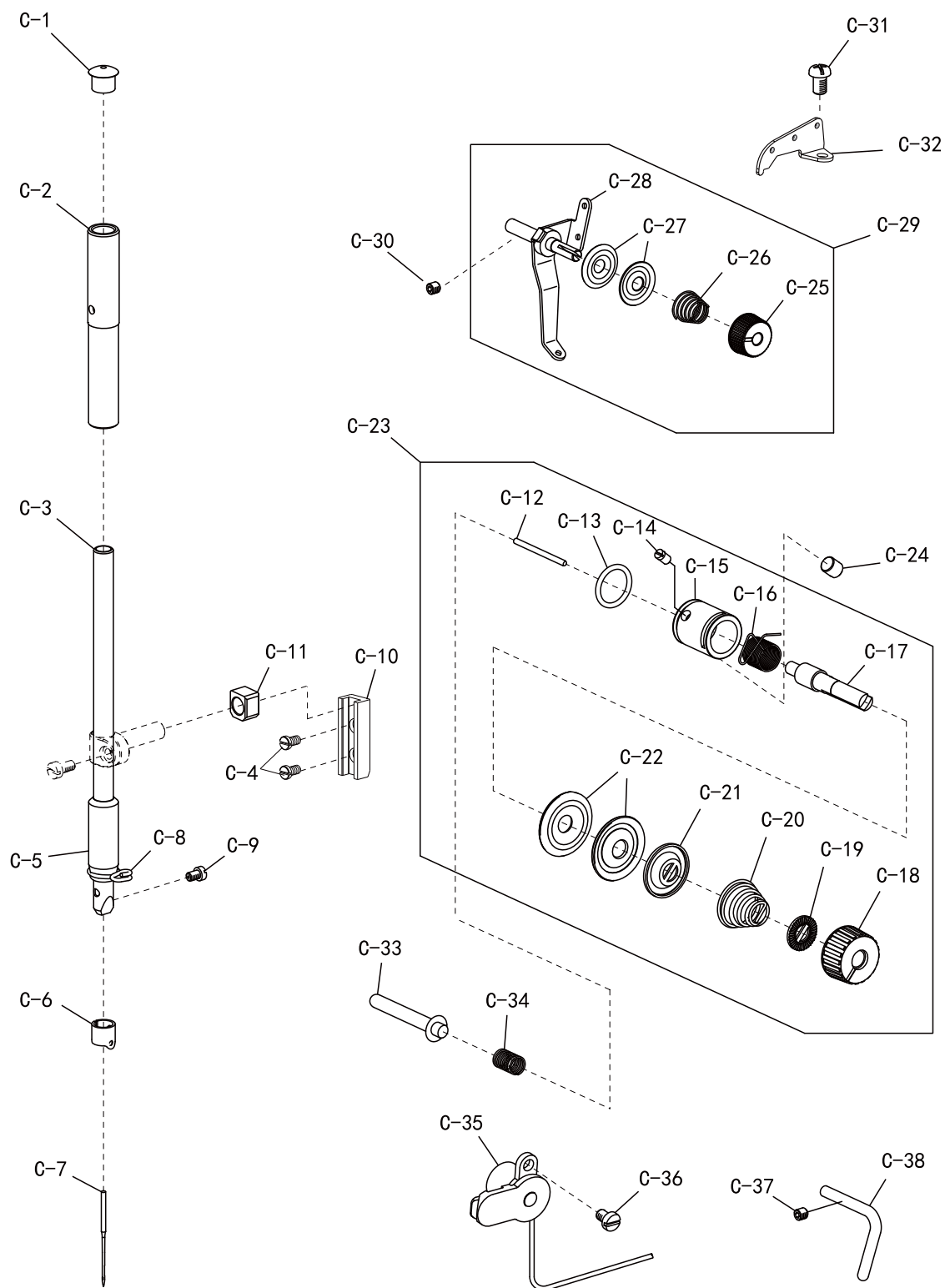


**B**

上轴、挑线分组件

Main shaft&amp;thread take-up components

| 序 号<br>Ref.No. | 物 料 号<br>Part.No. | 名 称    | Description                | 数量<br>Q'ty | 备 注<br>Remark |
|----------------|-------------------|--------|----------------------------|------------|---------------|
| B-1            | 10050672          | 挑线连杆销  | Thread take-up crank shaft | 1          |               |
| B-2            | 10010083          | 螺钉     | Screw                      | 1          |               |
| B-3            | 10010535          | 挑线连杆   | Thread take-up bar         | 1          |               |
|                |                   |        |                            |            |               |
| B-4            | 10038474          | 挑线杆分部件 | Thread take-up lever Asm.  | 1          |               |
|                |                   |        |                            |            |               |
| B-5            | 10010539          | 挑线杆防油圈 | Oil resistant cover        | 1          |               |
| B-6            | 10010545          | 螺钉     | Screw                      | 1          |               |
| B-7            | 10010534          | O形圈    | O-ring                     | 1          |               |
| B-8            | 10010082          | 螺钉     | Screw                      | 1          |               |
| B-9            | 10010065          | 螺钉     | Screw                      | 2          |               |
| B-10           | 10010538          | O形圈    | O-ring                     | 1          |               |
| B-11           | 10010540          | 油量调节销套 | Sleeve of adjusting pin    | 1          |               |
| B-12           | 10010504          | 油量调节销  | Adjusting pin              | 1          |               |
| B-13           | 10012203          | 针杆曲柄   | Counter weight             | 1          |               |
| B-14           | 10010504          | 滚针轴承   | Bearing                    | 2          |               |
| B-15           | 10004144          | 挑线曲柄   | Needle bar crank           | 1          |               |
| B-16           | 10010592          | 针杆连杆   | Needle bar crank rod       | 1          |               |
| B-17           | 10044580          | 上轴前轴套  | Bearing support            | 1          |               |
| B-18           | 10004472          | 绕线主动轮  | Wheel                      | 1          |               |
| B-19           | 10012062          | 螺钉     | Screw                      | 2          |               |
| B-20           | 10010506          | 螺钉     | Screw                      | 1          |               |
| B-21           | 10005020          | 螺钉     | Screw                      | 2          |               |
| B-22           | 10010542          | 上轴挡圈   | Thrust collar              | 1          |               |
| B-23           | 10056893          | 上轴后轴套  | Bearing support            | 1          |               |
| B-24           | 10007239          | 上轴中轴套  | Bearing support            | 1          |               |
| B-25           | 100002227         | 上轴     | Main shaft                 | 1          |               |
| B-26           | 100002521         | 上轴油封   | Oil seal                   | 1          |               |
| B-27           | 100005589         | 电机     | Motor                      | 1          |               |
| B-28           | 100001396         | 螺钉     | Screw                      | 4          |               |
| B-29           | 20022332          | 上轮     | Head wheel                 | 1          |               |
| B-30           | 10011232          | 螺钉     | Screw                      | 4          |               |
| B-31           | 10011063          | 螺钉     | Screw                      | 1          |               |
| B-32           | 10010590          | 针杆连接柱  | Needle bar holder          | 1          |               |
| B-33           | 100001349         | 挑线杆组件  | Thread take-up lever Asm.  | 1          |               |
| B-34           | 100002634         | 平衡块    | Balance block              | 1          |               |
|                |                   |        |                            |            |               |
|                |                   |        |                            |            |               |
|                |                   |        |                            |            |               |





## 针杆、夹线分组件

## Needle bar &amp; thread tension components

| 序 号<br>Ref.No. | 物 料 号<br>Part.No. | 名 称     | Description                    | 数量<br>Q'ty | 备 注<br>Remark |
|----------------|-------------------|---------|--------------------------------|------------|---------------|
| C-1            | 10010587          | 橡胶塞     | Rubber plug                    | 1          |               |
| C-2            | 10011063          | 针杆上轴套   | Bearing support                | 1          |               |
| C-3            | 10045046          | 针杆      | Needle bar                     | 1          |               |
| C-4            | 10008972          | 螺钉      | Screw                          | 2          |               |
| C-5            | 10014117          | 针杆下轴套   | Bearing support                | 1          |               |
| C-6            | 10045047          | 针杆下轴套线钩 | Needle bar thread guide        | 1          |               |
| C-7            | 10034917          | 机针      | Needle DB×1 14#                | 1          |               |
| C-8            | 100006700         | 针杆线钩    | Needle bar thread guide        | 1          |               |
| C-9            | 10010588          | 支针螺钉    | Screw                          | 1          |               |
| C-10           | 10054645          | 滑块导轨    | Needle bar holder              | 1          |               |
| C-11           | 10011194          | 针杆连接柱滑块 | Slide block                    | 1          |               |
| C-12           | 10004184          | 松线钉     | Thread release pin             | 1          |               |
| C-13           | 10004183          | O形圈     | O-ring                         | 1          |               |
| C-14           | 10004200          | 螺钉      | Screw                          | 1          |               |
| C-15           | 10039524          | 挑线簧调节座  | Tension post socket            | 1          |               |
| C-16           | 10004201          | 挑线簧     | Spring                         | 1          |               |
| C-17           | 10004177          | 夹线螺钉    | Screw                          | 1          |               |
| C-18           | 10012981          | 夹线螺母    | Nut                            | 1          |               |
| C-19           | 10004199          | 夹线制动板   | Tension disc stopper           | 1          |               |
| C-20           | 10004176          | 夹线簧     | Spring                         | 1          |               |
| C-20           | 10005941          | 夹线簧     | Spring                         | 1          |               |
| C-21           | 10004179          | 松线板     | Thread release disc            | 1          |               |
| C-22           | 10004180          | 夹线板     | Tension disc holder            | 2          |               |
| C-23           | 10059714          | 夹线器     | Thread take-up device          | 1          |               |
| C-24           | 10006264          | 螺钉      | Screw                          | 1          |               |
| C-25           | 10004181          | 夹线螺母    | Nut                            | 1          |               |
| C-26           | 10005838          | 夹线簧     | Spring                         | 1          |               |
| C-27           | 10005839          | 夹线板     | Tension disc holder            | 2          |               |
| C-28           | 10005841          | 夹线螺钉    | Screw                          | 1          |               |
| C-29           | 10059712          | 上夹线器    | Thread take-up device          | 1          |               |
| C-30           | 10009074          | 螺钉      | Screw                          | 1          |               |
| C-31           | 10008934          | 螺钉      | Screw                          | 1          |               |
| C-32           | 10033232          | 上过线板    | Thread tension guide           | 1          |               |
| C-33           | 10058041          | 松线辅钉    | Tension release supporting pin | 1          |               |
| C-34           | 10050348          | 弹簧      | Spring                         | 1          |               |
| C-35           | 10039460          | 电子夹线器   | Electromagnet                  | 1          |               |
|                |                   |         |                                |            |               |
|                |                   |         |                                |            |               |
|                |                   |         |                                |            |               |
|                |                   |         |                                |            |               |

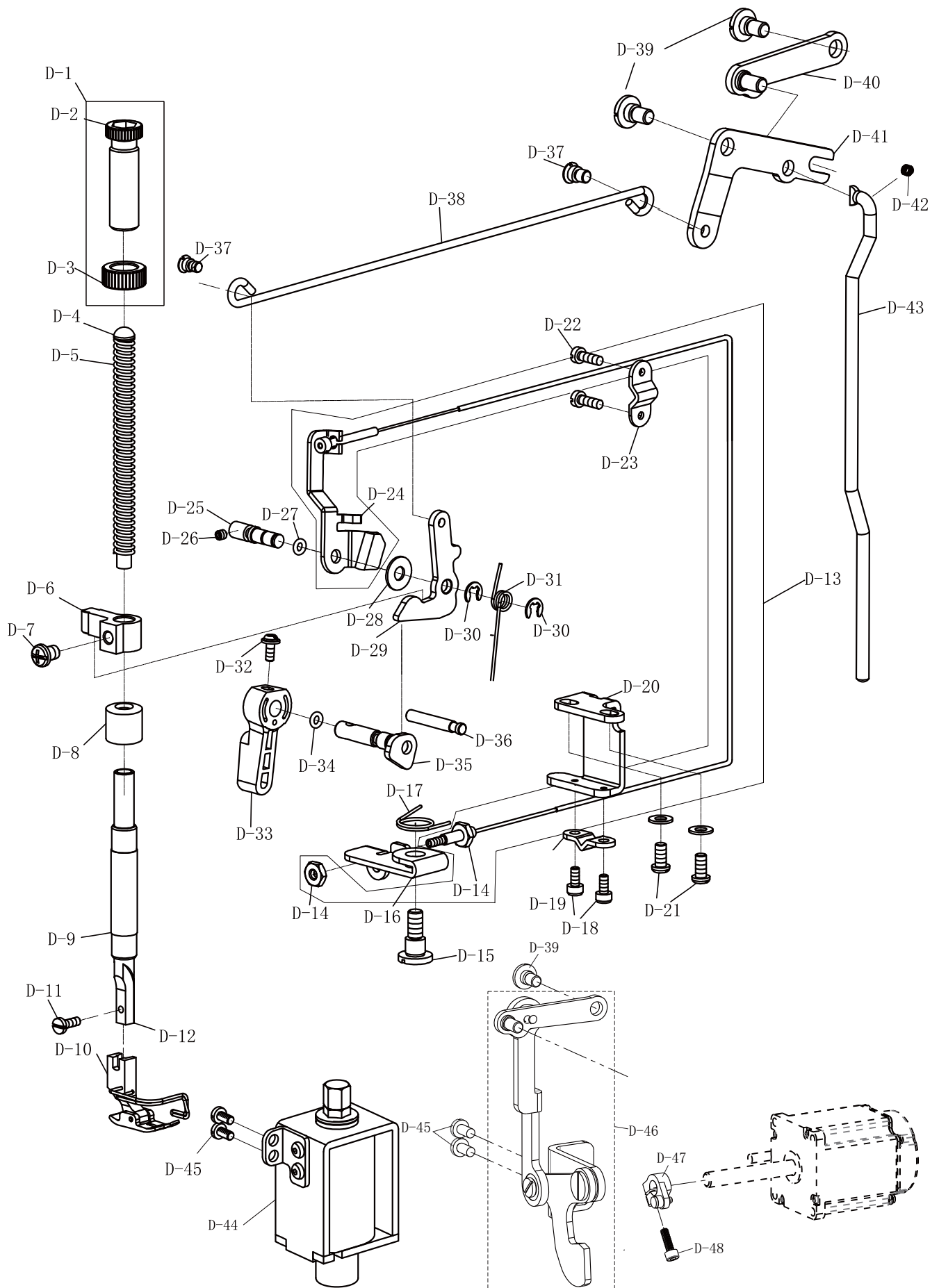
### 针杆、夹线分组件

### Needle bar & thread tension components

7

# D 压料、松线分组件

## Presser bar & tension release components



## D

压料、松线分组件

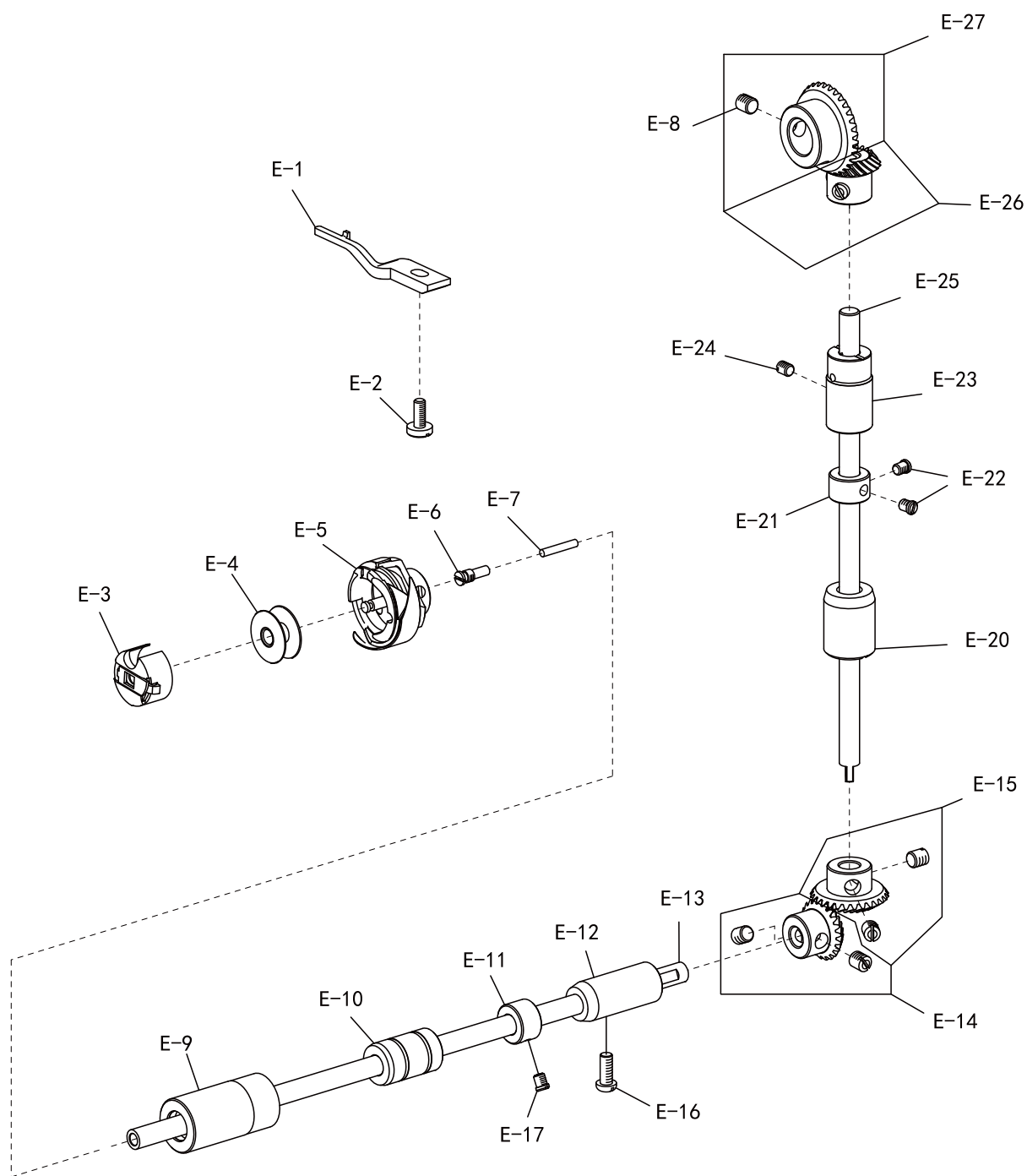
Presser bar &amp; tension release components

| 序 号<br>Ref.No. | 物 料 号<br>Part.No. | 名 称      | Description                        | 数量<br>Q'ty | 备 注<br>Remark |
|----------------|-------------------|----------|------------------------------------|------------|---------------|
| D-1            | 10051433          | 调压螺钉组件   | Screw ASM                          | 1          |               |
| D-2            | 10051428          | 螺钉       | Screw                              | 1          |               |
| D-3            | 10051429          | 螺母       | Nut                                | 1          |               |
| D-4            | 10004439          | 调压导杆     | Presser guide bar                  | 1          |               |
| D-5            | 10004473          | 弹簧       | Spring                             | 1          |               |
| D-6            | 10039365          | 压杆导架     | Presser guide bar bracket          | 1          |               |
| D-7            | 10000325          | 螺钉       | Screw                              | 1          |               |
| D-8            | 100003533         | 压紧杆防油罩   | Oil protector cover                | 1          |               |
| D-9            | 10014118          | 轴套       | Bearing support                    | 1          |               |
| D-10           | 10044596          | 活压脚部件    | Presser foot ASM                   | 1          |               |
| D-11           | 10010650          | 螺钉       | Screw                              | 1          |               |
| D-12           | 10010646          | 压杆       | Presser bar                        | 1          |               |
| D-13           | 10039380          | 抬压脚拉线组件  | Foot lifter pull thread components | 1          |               |
| D-14           | 10005834          | 螺母       | Nut                                | 2          |               |
| D-15           | 10012467          | 螺钉       | Screw                              | 1          |               |
| D-16           | 10008860          | 松线座      | Loosing plate                      | 1          |               |
| D-17           | 10008834          | 弹簧       | Spring                             | 1          |               |
| D-18           | 10006624          | 螺钉       | Screw                              | 2          |               |
| D-19           | 10013615          | 挡线板      | Fixing shutter                     | 1          |               |
| D-20           | 10008811          | 松线钢绳座    | Loosing plate                      | 1          |               |
| D-21           | 10008972          | 螺钉       | Screw                              | 2          |               |
| D-22           | 10009037          | 螺钉       | Screw                              | 2          |               |
| D-23           | 10039378          | 钢丝绳压板    | Wire rope pressing plate           | 1          |               |
| D-24           | 10039372          | 松线顶板     | Tension release plate              | 1          |               |
| D-25           | 10039373          | 销        | Pin                                | 1          |               |
| D-26           | 10009074          | 螺钉       | Screw                              | 3          |               |
| D-27           | 10010027          | O形圈      | O-ring                             | 1          |               |
| D-28           | 10050590          | 垫圈       | Snap ring                          | 1          |               |
| D-29           | 10050188          | 升降板      | Lifting lever                      | 1          |               |
| D-30           | 10013038          | 挡圈       | Snapring                           | 2          |               |
| D-31           | 10052046          | 弹簧       | Spring                             | 1          |               |
| D-32           | 10010016          | 螺钉       | Screw                              | 1          |               |
| D-33           | 10051430          | 压脚扳手     | Handlifter                         | 1          |               |
| D-34           | 10010027          | O形圈      | O-ring                             | 1          |               |
| D-35           | 10050190          | 压脚扳手凸轮部件 | Handlifter CAM ASM                 | 1          |               |
| D-36           | 10039374          | 销        | Pin                                | 1          |               |
| D-37           | 10010651          | 螺钉       | Screw                              | 2          |               |
| D-38           | 100002079         | 抬压脚拉杆    | Lifting lever connecting rod       | 1          |               |
| D-39           | 10010652          | 螺钉       | Screw                              | 2          |               |
| D-40           | 100003258         | 抬压脚连接板   | Presserfoot lifter connector plate | 1          |               |
| D-41           | 100002081         | 抬压脚后杠杆   | Lifinglever link                   | 1          |               |

### 压料、松线分组件

## Presser bar & tension release components

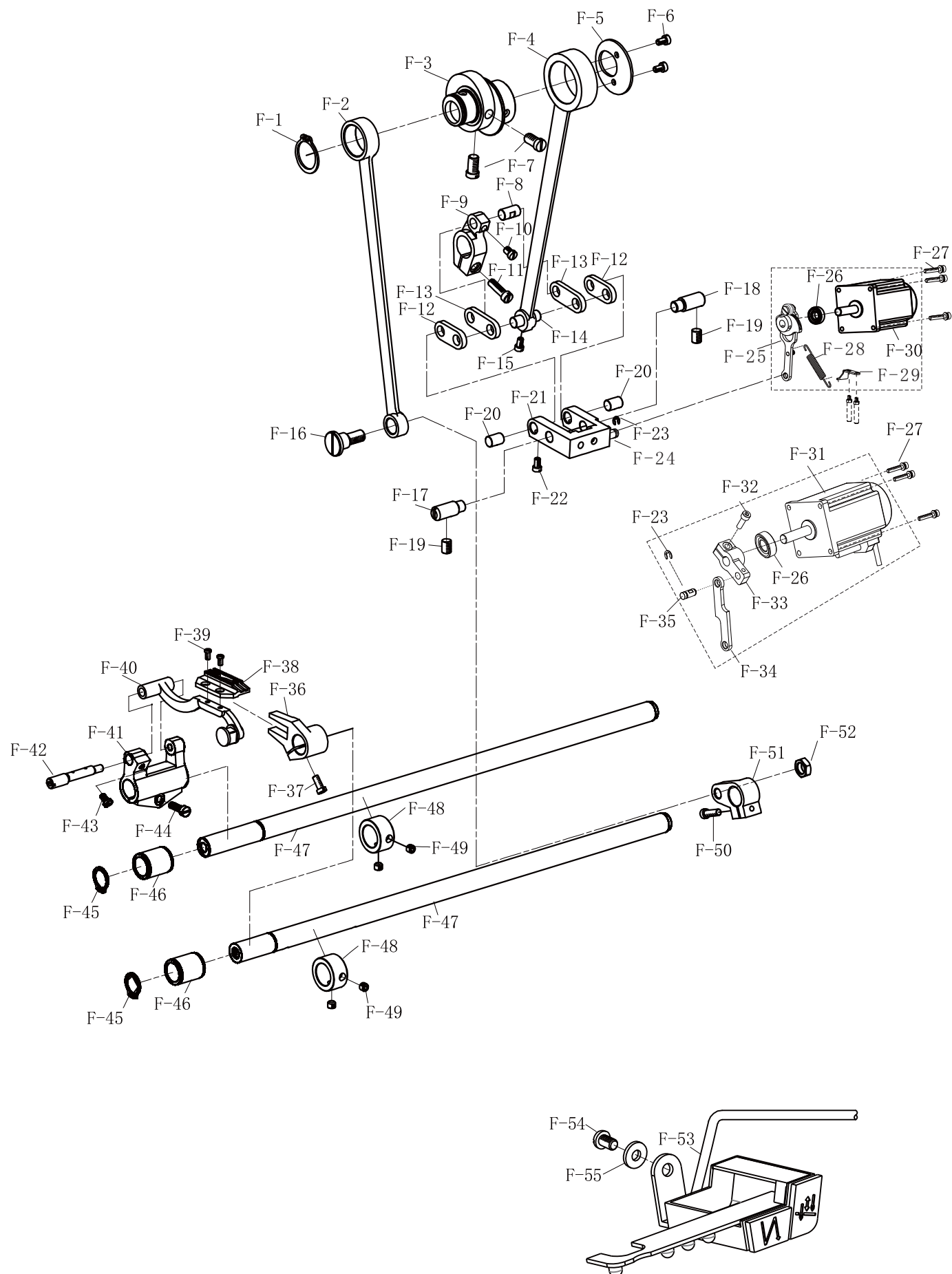
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## 钩线分组件

## Hook of driving shaft components

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## F

## 送料分组件

## Feed mechanism components

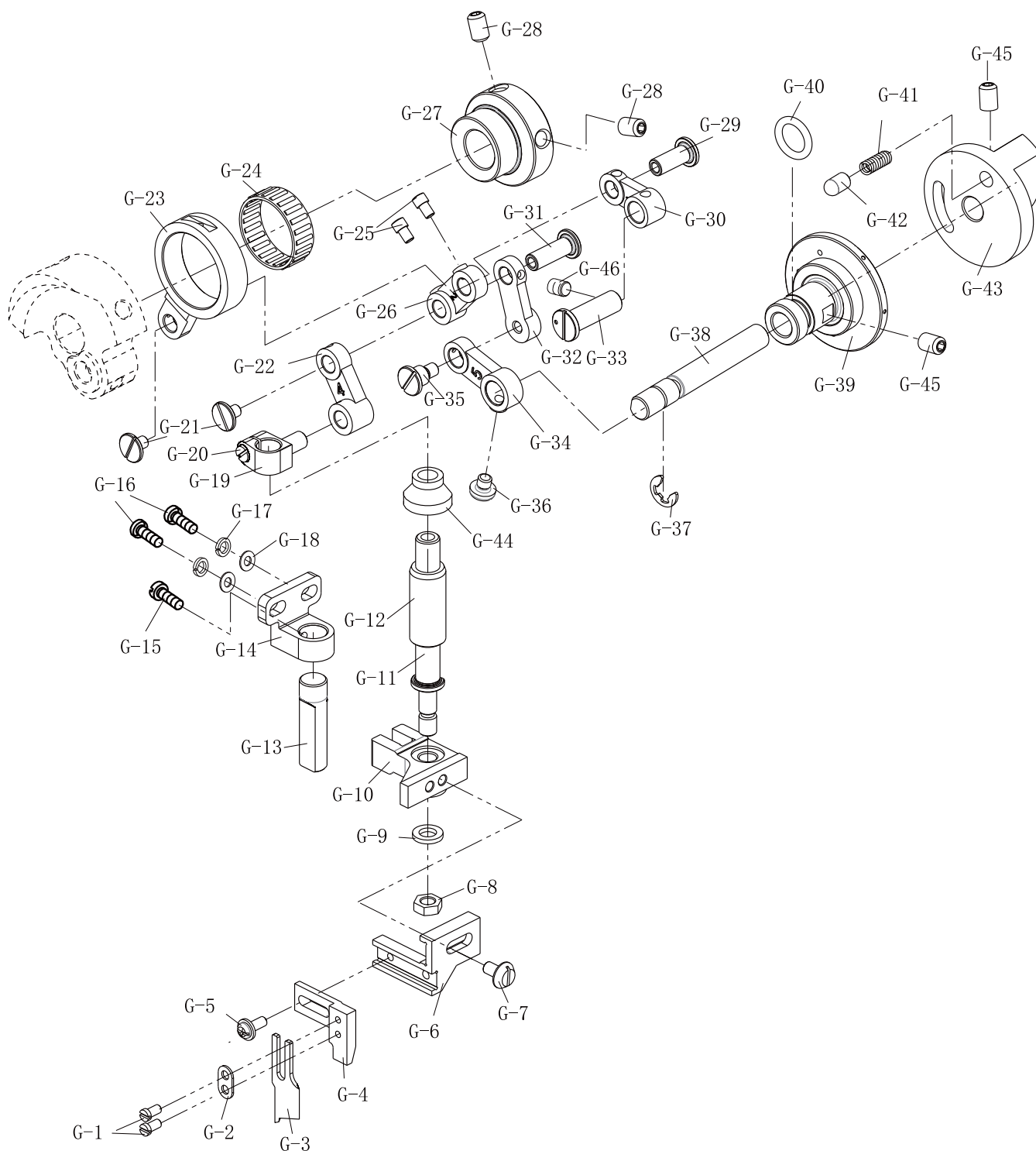
| 序 号<br>Ref.No. | 物 料 号<br>Part.No. | 名 称      | Description              | 数量<br>Q'ty | 备 注<br>Remark |
|----------------|-------------------|----------|--------------------------|------------|---------------|
| F-1            | 10010089          | 挡圈       | Snap ring                | 1          |               |
| F-2            | 10010084          | 抬牙连杆     | Connecting rod           | 1          |               |
| F-3            | 10010115          | 送料偏心轮    | Feed drive eccentric cam | 1          |               |
| F-4            | 10010072          | 送料连杆     | Connecting rod           | 1          |               |
| F-5            | 10010098          | 送料偏心轮盖板  | Thrust cover             | 1          |               |
| F-6            | 10010643          | 螺钉       | Screw                    | 2          |               |
| F-7            | 10010092          | 螺钉       | Screw                    | 2          |               |
| F-8            | 10010096          | 销        | Pin                      | 1          |               |
| F-9            | 10010076          | 送布曲柄     | Feed rocker              | 1          |               |
| F-10           | 10010071          | 螺钉       | Screw                    | 1          |               |
| F-11           | 10010095          | 螺钉       | Screw                    | 1          |               |
| F-12           | 10048736          | 送料短摆动板   | Short link               | 2          |               |
| F-13           | 10048696          | 送料长摆动板   | Long link                | 2          |               |
| F-14           | 10010069          | 销        | Pin                      | 1          |               |
| F-15           | 10010071          | 螺钉       | Screw                    | 1          |               |
| F-16           | 10010091          | 螺钉       | Screw                    | 1          |               |
| F-17           | 100001677         | 销        | Pin                      | 1          |               |
| F-18           | 100001671         | 销        | Pin                      | 1          |               |
| F-19           | 10010678          | 螺钉       | Screw                    | 2          |               |
| F-20           | 10010087          | 销        | Pin                      | 2          |               |
| F-21           | 100005407         | 送料摆动板座组件 | Feed adjusting ASM       | 1          |               |
| F-22           | 10010071          | 螺钉       | Screw                    | 2          |               |
| F-23           | 10010649          | 挡圈       | Snap ring                | 2          |               |
| F-24           | 100001346         | 销        | Pin                      | 1          |               |
| F-25           | 100006643         | 倒回缝组件    | Rewind the seam ASM.     | 1          |               |
| F-26           | 100001355         | 油封       | oil seal                 | 1          |               |
| F-27           | 10065628          | 组合螺钉     | Screw                    | 3          |               |
| F-28           | 100008401         | 拉簧       | Stretch Springs          | 1          |               |
| F-29           | 100006644         | 拉簧固定板    | Mounting plate           | 1          |               |
| F-30           | 100008348         | 步进电机     | Stepper motor            | 1          |               |

## F

## 送料分组件

## Feed mechanism components

| 序 号<br>Ref.No. | 物 料 号<br>Part.No. | 名 称      | Description            | 数量<br>Q'ty | 备 注<br>Remark |
|----------------|-------------------|----------|------------------------|------------|---------------|
| F-31           | 100001715         | 步进电机     | Stepper motor          | 1          |               |
| F-32           | 10065628          | 螺钉       | Screw                  | 1          |               |
| F-33           | 100001348         | 曲柄       | Counter bar crank      | 1          |               |
| F-34           | 100001347         | 连杆       | Connecting rod         | 1          |               |
| F-35           | 100001346         | 销        | Pin                    | 1          |               |
| F-36           | 10042079          | 抬牙叉形曲柄组件 | Lifing fork            | 1          |               |
| F-37           | 10004628          | 螺钉       | Screw                  | 1          |               |
| F-38           | 100003089         | 1/8送料牙   | Feed dog               | 1          |               |
| F-39           | 10010099          | 螺钉       | Screw                  | 2          |               |
| F-40           | 10063520          | 牙架       | Tooth base             | 1          |               |
| F-41           | 10004474          | 牙架座      | Feed bar driving crank | 1          |               |
| F-42           | 10004440          | 销        | Pin                    | 1          |               |
| F-43           | 10010074          | 螺钉       | Screw                  | 1          |               |
| F-44           | 10004993          | 螺钉       | Screw                  | 1          |               |
| F-45           | 10010090          | 挡圈       | Snapring               | 2          |               |
| F-46           | 10014116          | 轴套       | Bearing support        | 2          |               |
| F-47           | 100001689         | 送料轴      | Feed rocker shaft      | 1          |               |
| F-48           | 10010542          | 挡圈       | Thrust collar          | 2          |               |
| F-49           | 10038073          | 螺钉       | Screw                  | 4          |               |
| F-50           | 100001690         | 抬牙轴      | Feed rocker shaft      | 1          |               |
| F-51           | 10010095          | 螺钉       | Screw                  | 1          |               |
| F-52           | 10010086          | 抬牙后曲柄    | Lifing rocker          | 1          |               |
| F-53           | 10004475          | 螺母       | Nut                    | 1          |               |
| F-54           | 10054822          | 机头灯组件    | Headlamp assembly      | 1          |               |
| F-55           | 10008934          | 螺钉       | Screw                  | 1          |               |
| F-56           | 10010649          | 垫圈       | Washer                 | 1          |               |
|                |                   |          |                        |            |               |
|                |                   |          |                        |            |               |
|                |                   |          |                        |            |               |
|                |                   |          |                        |            |               |
|                |                   |          |                        |            |               |
|                |                   |          |                        |            |               |
|                |                   |          |                        |            |               |
|                |                   |          |                        |            |               |





## 切刀控制部件

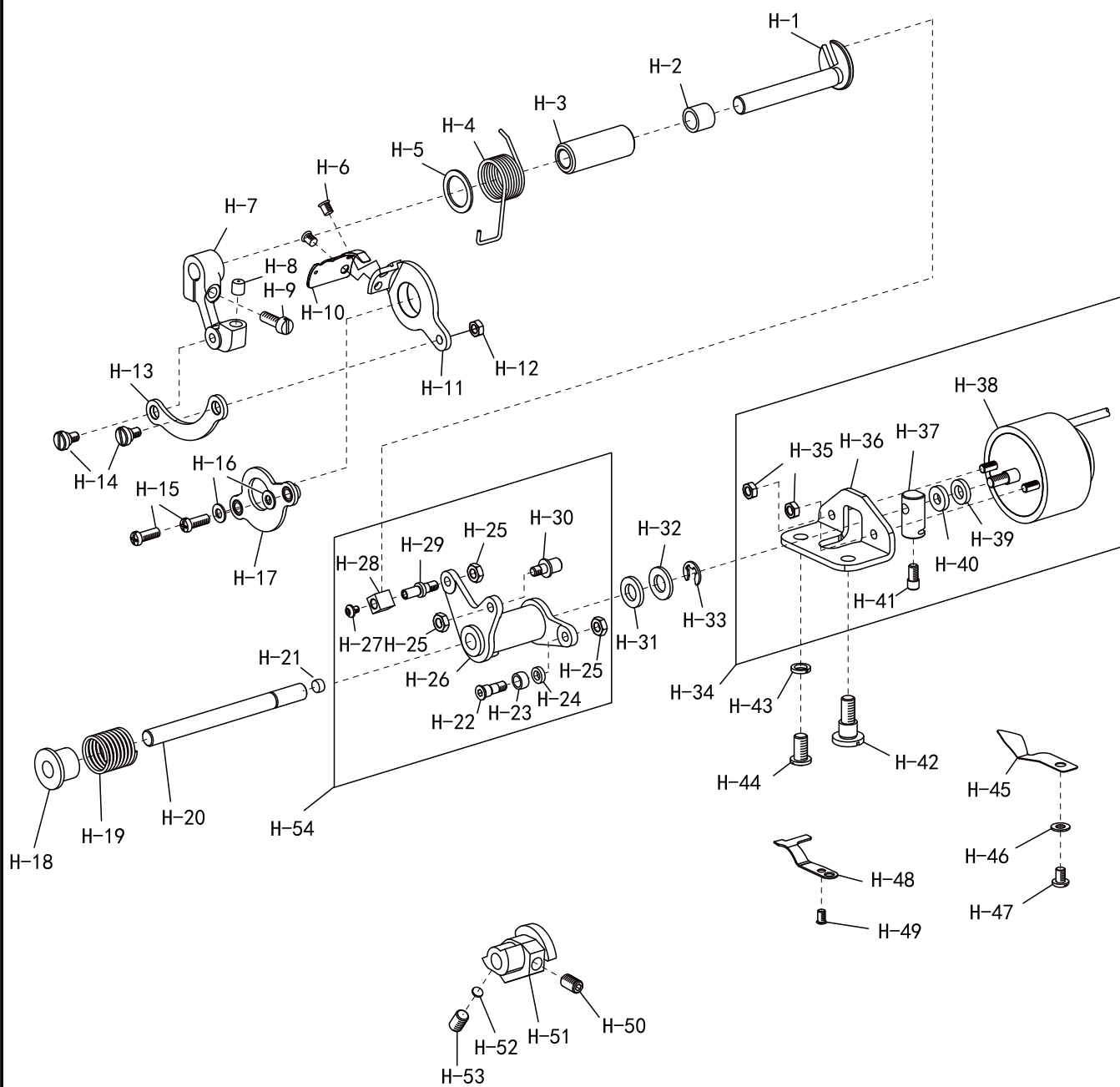
Cutter Control Components

| 序 号<br>RefNo. | 物 料 号<br>PartNo. | 名 称         | Description             | 数量<br>Q'ty | 备 注<br>Remark |
|---------------|------------------|-------------|-------------------------|------------|---------------|
| G-1           | 10044619         | 螺钉          | Screw                   | 2          |               |
| G-2           | 10044618         | 垫片          | Washer                  | 1          |               |
| G-3           | 100006547        | 切刀          | Cutting knife           | 1          |               |
| G-4           | 10053848         | 刀架          | Knife holder            | 1          |               |
| G-5           | 10044616         | 螺钉          | Screw                   | 1          |               |
| G-6           | 10053846         | 切刀调节架       | Adjustment Knife holder | 1          |               |
| G-7           | 10010016         | 螺钉          | Screw                   | 1          |               |
| G-8           | 10012985         | 螺母          | Nuts                    | 1          |               |
| G-9           | 10002995         | 平垫圈         | Washer                  | 1          |               |
| G-10          | 10053844         | 刀架座         | Mounting block          | 1          |               |
| G-11          | 100003250        | 刀杆          | Knife bar               | 1          |               |
| G-12          | 100002366        | 刀杆轴套        | Shaft sleeve            | 1          |               |
| G-13          | 100005870        | 导向轴         | Guide shaft             | 1          |               |
| G-14          | 100005869        | 安装座         | Mounting block          | 1          |               |
| G-15          | 10001580         | 螺钉          | Screw                   | 1          |               |
| G-16          | 10014395         | 螺钉          | Screw                   | 2          |               |
| G-17          | 10002991         | 弹簧垫圈        | Spring washer           | 2          |               |
| G-18          | 10002954         | 垫圈          | Washer                  | 2          |               |
| G-19          | 10053805         | 刀杆连接柱       | Knife bar holder        | 1          |               |
| G-20          | 100002324        | 螺钉          | Screw                   | 1          |               |
| G-21          | 10053800         | 螺钉          | Screw                   | 2          |               |
| G-22          | 10053798         | 刀杆连杆(4)     | Connecting rod(4)       | 1          |               |
| G-23          | 10054697         | 切刀大连杆       | Knife rod               | 1          |               |
| G-24          | 10047396         | 滚针轴承        | Bearing                 | 1          |               |
| G-25          | 10051742         | 螺钉          | Screw                   | 2          |               |
| G-26          | 10053796         | 切刀小连杆(2)    | Connecting rod(2)       | 1          |               |
| G-27          | 10056306         | 刀杆凸轮        | Eccentric cam           | 1          |               |
| G-28          | 10013465         | 螺钉          | Screw                   | 2          |               |
| G-29          | 10053801         | 驱动连杆连接销     | Pin                     | 1          |               |
| G-30          | 10053795         | 切刀驱动连杆(1)   | Connecting rod(1)       |            |               |
| G-31          | 100002331        | 曲柄连杆连接销     | Pin                     |            |               |
| G-32          | 10053797         | 切刀开关曲柄连杆(3) | Connecting rod(3)       |            |               |
| G-33          | 10053802         | 驱动连杆定位销     | Pin                     |            |               |
| G-34          | 10053799         | 切刀开关曲柄(5)   | Connecting rod(5)       |            |               |
| G-35          | 10053804         | 轴位螺钉        | Axial Screw             |            |               |
| G-36          | 10003398         | 螺钉          | Screw                   |            |               |
| G-37          | 10009654         | 开口挡圈6       | Closing ring 6          |            |               |
| G-38          | 10054640         | 切刀开关轴       | Switch shaft            |            |               |
| G-39          | 100002380        | 切刀开关旋钮座     | Switch Knob seat        |            |               |
| G-40          | 10003792         | O型圈         | O-ring                  |            |               |
| G-41          | 100008123        | 弹簧          | Spring                  |            |               |



### Cutter Control Components

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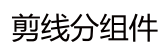




## 剪线分组件

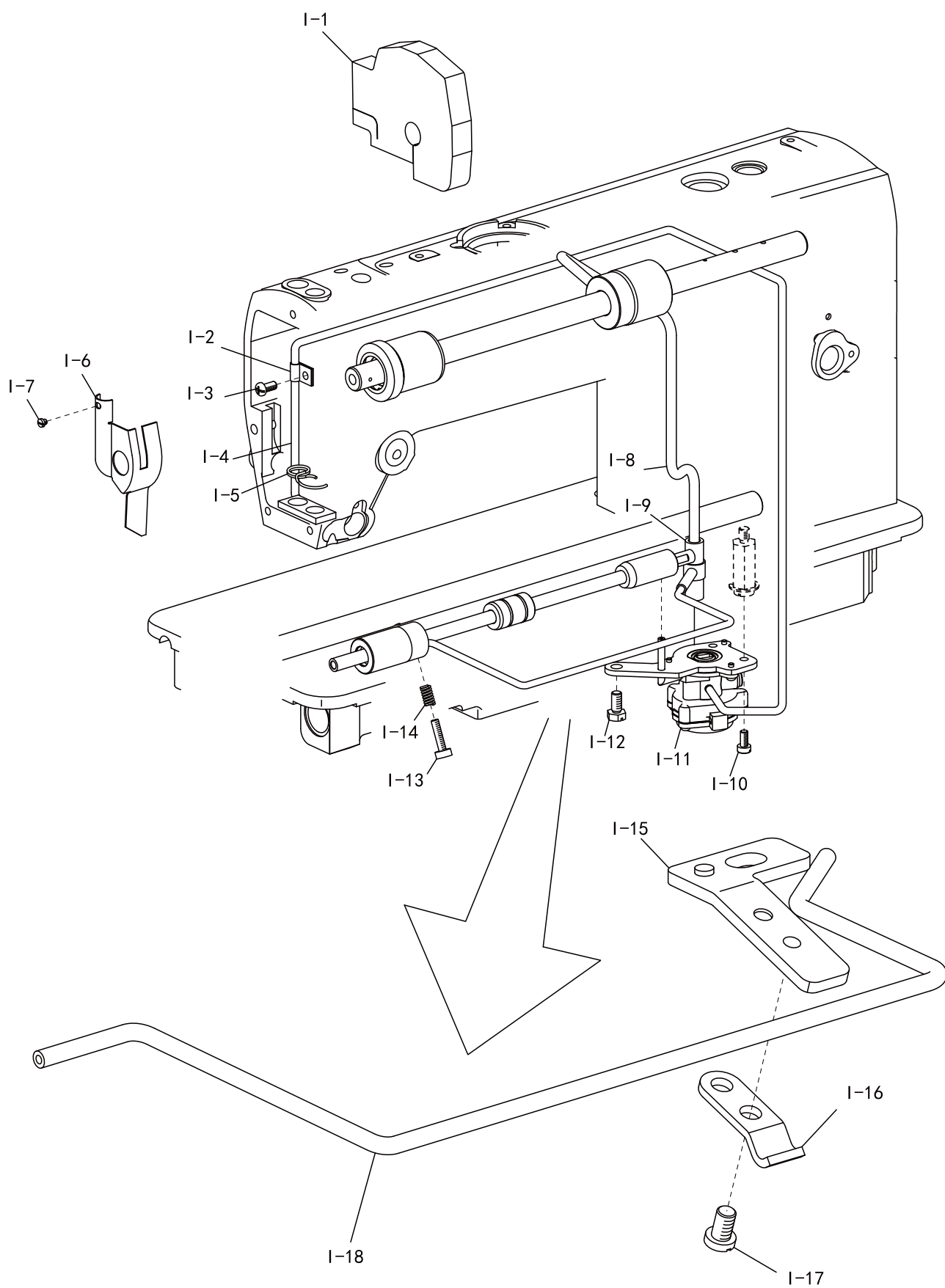
Thread trimmer components

| 序 号<br>Ref.No. | 物 料 号<br>Part.No. | 名 称      | Description                  | 数量<br>Q'ty | 备 注<br>Remark |
|----------------|-------------------|----------|------------------------------|------------|---------------|
| H-1            | 10008866          | 切线驱动曲柄轴  | Trimming crank shaft         | 1          |               |
| H-2            | 10011630          | 曲柄轴短套    | Short bushing                | 1          |               |
| H-3            | 10011630          | 切线轴套     | Short bushing                | 1          |               |
| H-4            | 10011649          | 弹簧       | Spring                       | 1          |               |
| H-5            | 10008865          | 垫圈       | Washer                       | 1          |               |
| H-6            | 10011588          | 螺钉       | Screw                        | 2          |               |
| H-7            | 10058043          | 切线驱动曲柄   | Trimming crank               | 1          |               |
| H-8            | 10011580          | 曲柄止动块    | Block                        | 1          |               |
| H-9            | 10008863          | 螺钉       | Screw                        | 1          |               |
| H-10           | 10011494          | 动刀       | Round knife                  | 1          |               |
| H-11           | 10004640          | 动刀架      | Round knife bracket          | 1          |               |
| H-12           | 10011578          | 螺母       | Nut                          | 1          |               |
| H-13           | 10031612          | 刀轴连杆     | Knife shaft crack rod        | 1          |               |
| H-14           | 10011514          | 螺钉       | Screw                        | 2          |               |
| H-15           | 10013541          | 螺钉       | Screw                        | 2          |               |
| H-16           | 10013154          | 垫圈       | Washer                       | 2          |               |
| H-17           | 10008856          | 刀架压板组件   | Knife holder ASM.            | 1          |               |
| H-18           | 10014196          | 弹簧端盖     | Spring cover                 | 1          |               |
| H-19           | 10008812          | 弹簧       | Spring                       | 1          |               |
| H-20           | 10011697          | 切刀驱动轴    | Trimming shaft               | 1          |               |
| H-21           | 10050266          | 消音塞      | Silencer plug                | 1          |               |
| H-22           | 10004707          | 螺钉       | Screw                        | 1          |               |
| H-23           | 10004651          | 滚柱       | Roller bearing               | 1          |               |
| H-24           | 10025576          | 垫圈       | Washer                       | 1          |               |
| H-25           | 10011578          | 螺母       | Nut                          | 3          |               |
| H-26           | 10004648          | 切线凸轮曲柄   | Trimming cam crank           | 1          |               |
| H-27           | 10025577          | 螺钉       | Screw                        | 1          |               |
| H-28           | 10004703          | 凸轮曲柄滑块   | Slide block                  | 1          |               |
| H-29           | 10004704          | 销        | Pin                          | 1          |               |
| H-30           | 10004705          | 左曲柄滚柱    | Pin                          | 1          |               |
| H-31           | 10011650          | 垫圈       | Washer                       | 1          |               |
| H-32           | 10003031          | 垫圈       | Washer                       | 1          |               |
| H-33           | 10009654          | 挡圈       | Snap ring                    | 1          |               |
| H-34           | 10031414          | 剪线电磁铁组件  | Thread trimmer solenoid ASM. | 1          |               |
| H-35           | 10009471          | 螺母       | Nut                          | 2          |               |
| H-36           | 10008854          | 剪线电磁铁安装座 | Solenoid base                | 1          |               |
| H-37           | 10011607          | 剪线电磁铁连接体 | Solenoid connecting shaft    | 1          |               |
| H-38           | 10031415          | 剪线电磁铁    | Thread trimmer solenoid      | 1          |               |
| H-39           | 10011606          | 垫圈       | Washer                       | 1          |               |
| H-40           | 10011845          | 垫圈       | Washer                       | 1          |               |
| H-41           | 10028999          | 螺钉       | Screw                        | 1          |               |



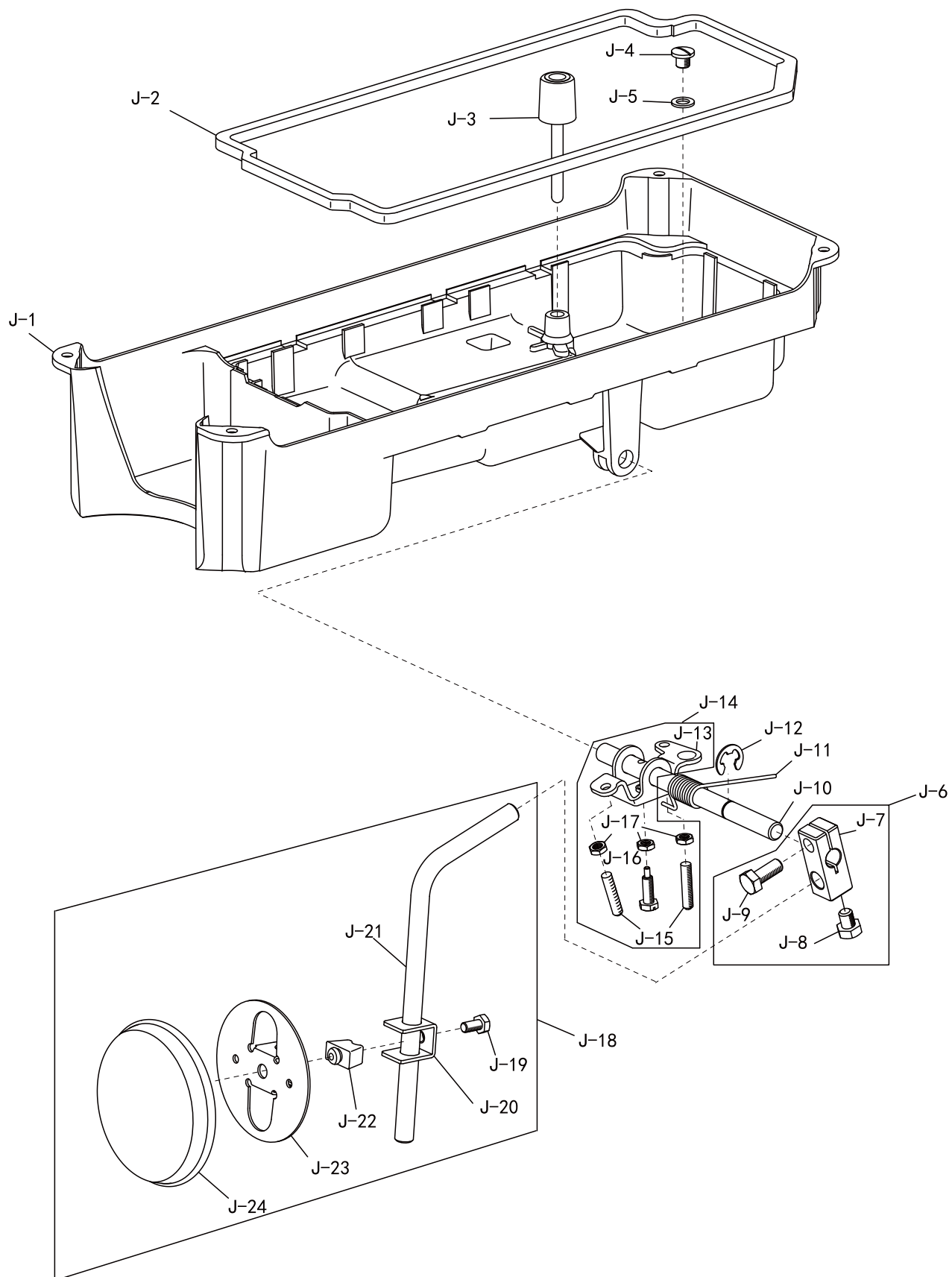
## Thread trimmer components

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## Lubrication components

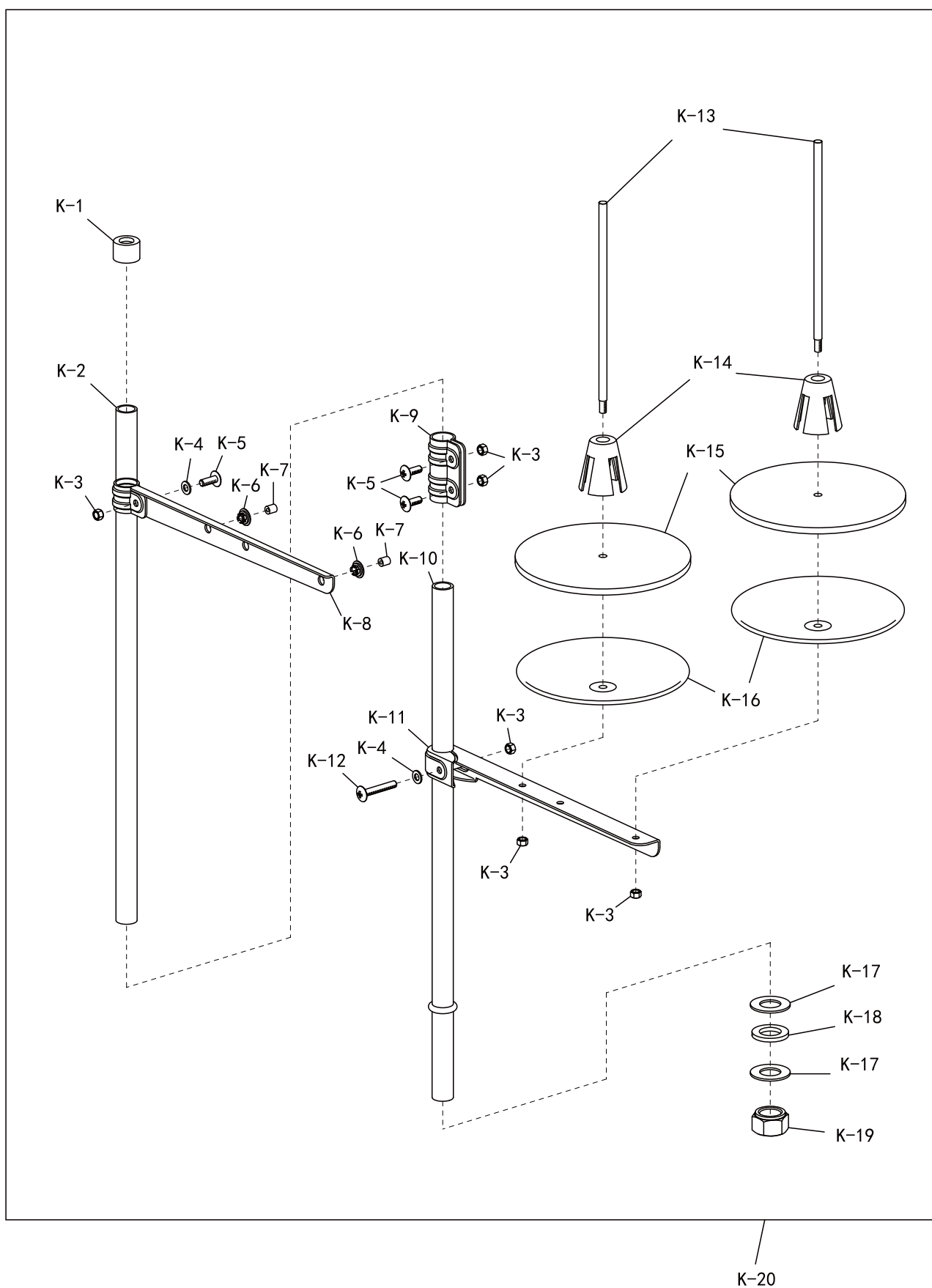
[illegible]



### 油盘、膝抬压脚分组件

### Presser foot components of oil plate knee lift

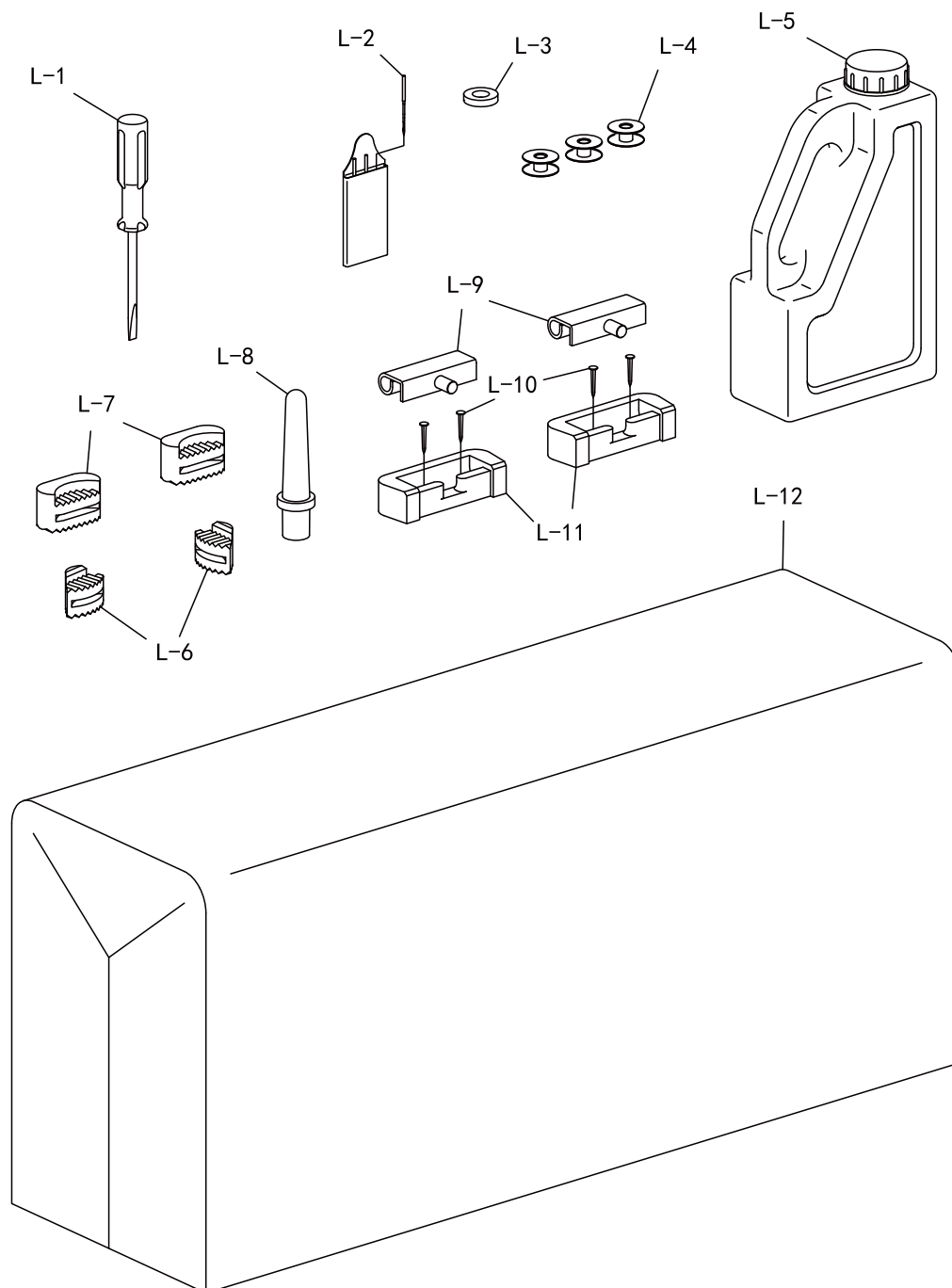
[illegible]



### 过线架分组件

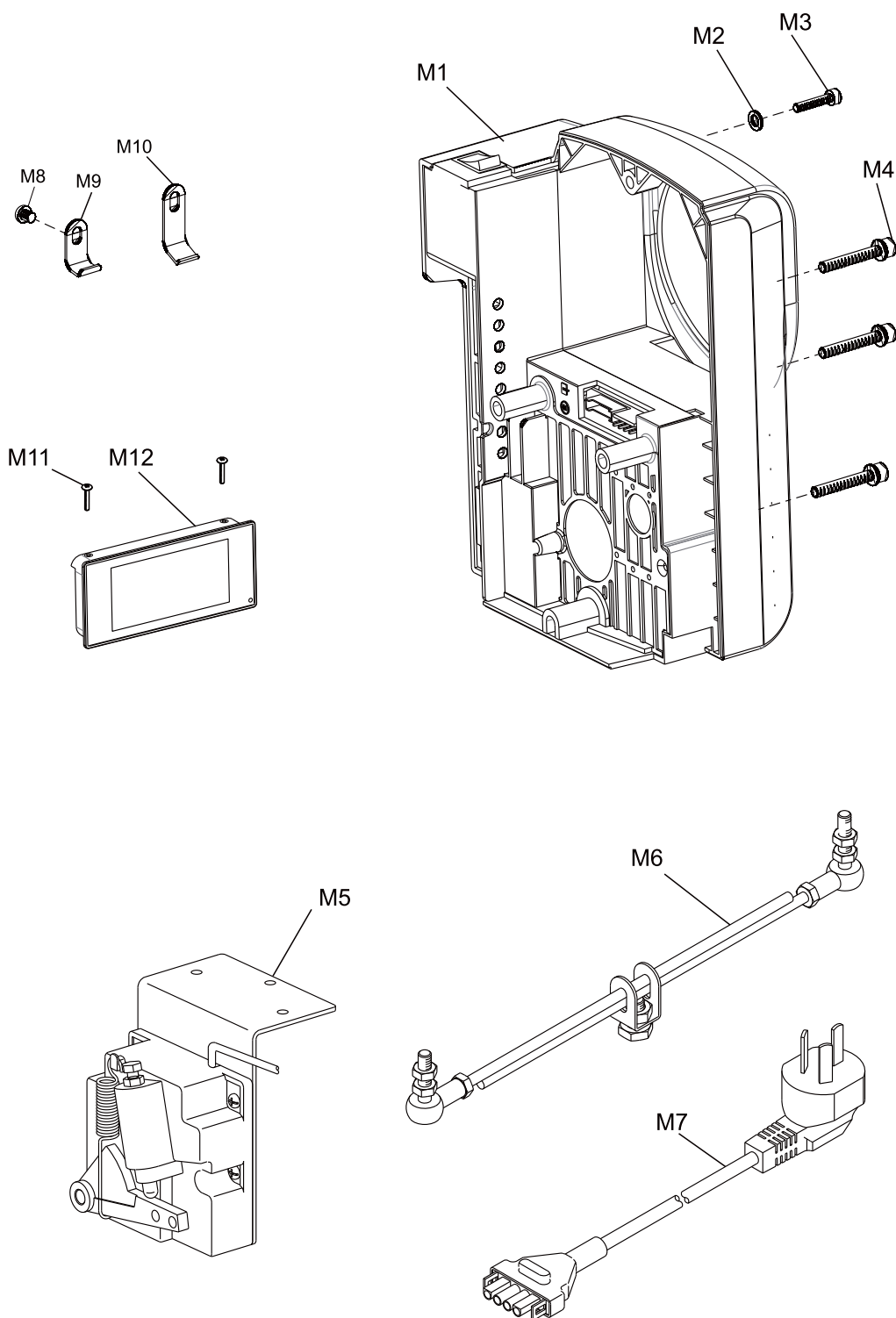
### Components of thread-running stand

[illegible]



附件  
Accessories

[illegible]



## 电控分组件

## Drive-by-wire Components

[illegible]