



**MODEL**  
**7360RATCWL (E)**

**PARTS & INSTRUCTION MANUAL**

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Before putting a new machine into operation, remove the plugs (A) on the top of the arm and replenish the oil supply. Lift the presser foot and run the machine at a low speed of 2000 spm to check that the oil is being distributed correctly by inspecting the window on the oil reservoir. When lubrication is normal, keep the machine running at this speed for 30 minutes, and then increase the running speed gradually. After a month of running, the machine can be run at maximum speed assuming normal working conditions.

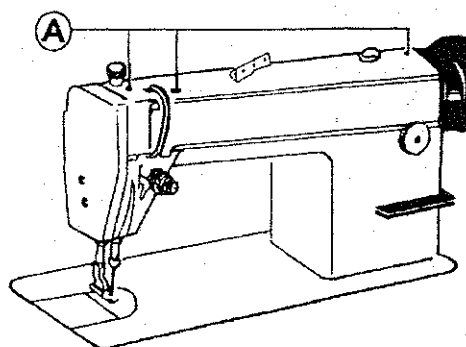


Fig. 1

## FILLING THE OIL RESERVOIR

The amount of oil in the reservoir is controlled through the reference marks A and B shown in Fig 2. A indicates the maximum oil level, the mark B is the minimum oil level. If the oil level is below the mark B refill the oil reservoir.

When filling the reservoir, loosen the oil draining screw (c), drain off the remaining oil reservoir completely, clean the reservoir and re-tighten the oil draining screw (c) and fill the oil reservoir with fresh sewing machine oil.

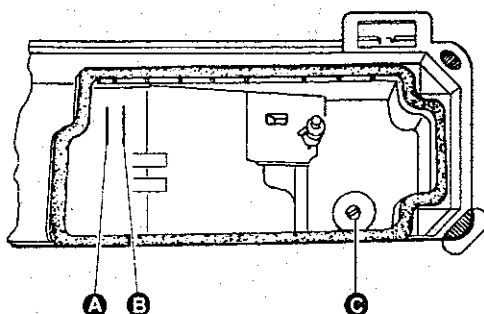


Fig. 2

## REGULATING OIL DISTRIBUTION ON THE ROTATING HOOK

Adjust the amount of oil used to lubricate the rotating hook by turning the oil flow adjusting screw (A). Turn the screw (A) clockwise (in the direction of the + sign) to increase the oil flow; turn it counter-clockwise (in the direction of the - sign) to decrease the oil flow.

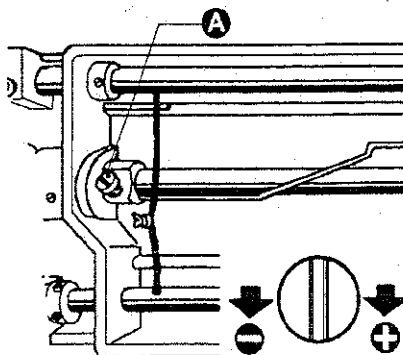


Fig. 3  
1

## OIL PUMP ADJUSTMENT

During everyday operation, adjusting the oil pump is not usually necessary. If the oil level doesn't fluctuate in the oil reservoir window when the machine runs at a low speed, close the clearance on the oil bypass hole.

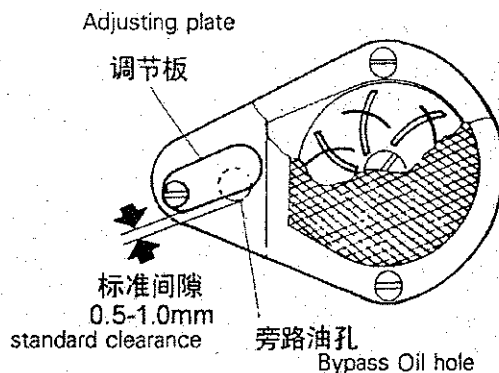


Fig. 4

## NEEDLE INSTALLATION

Turn the balance wheel to lift the needle bar to the upper end of its stroke. Loosen the needle clamp screw while keeping the long groove of the needle facing left; insert the needle shank up to the bottom of the needle socket, then tighten the needle clamp screw.

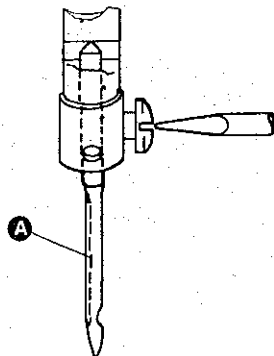


Fig. 5

## CONNECTING THE CLUTCH LEVER TO THE PEDAL

The optimum tilt angle of the pedal is approximately 15 degrees.

Adjust the clutch so that the clutch lever (c) aligns with the draw bar (B) as shown

in Fig. 6. The machine pulley should rotate counter clockwise when viewed from the outside of it. The rotating direction of motor pulley can be reversed by turning the plug of the motor 180 degrees.

Adjust the tension of 0-Belt (F) by moving the motor up and down; the proper tension on the 0-belt is a slack of 10-20 mm when the belt is depressed at the center of the belt.

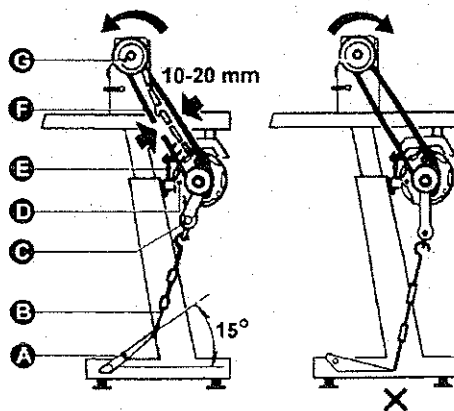


Fig. 6

## BELT COVER INSTALLATION

Install the belt cover for the sake of safety. Install belt cover (C) to arm with screw (A) and screw (B) , and install belt cover (E) onto table with screw (D).

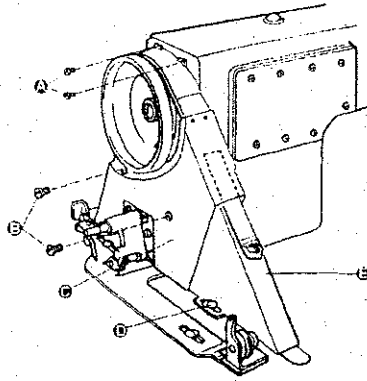


Fig. 7

## ADJUSTING THE TIMING OF THE TENSION DISCS

Within the presser foot lift range, the timing of the tension discs can be adjusted as follows:

Remove the rubber plug from the back of the arm and loosen the screw (A) of the knee lift lever (left).

Move the tension releasing cam (D) to the left for earlier opening or to the right for later opening.

It will facilitate the adjustment if a block is put under the presser foot lift.

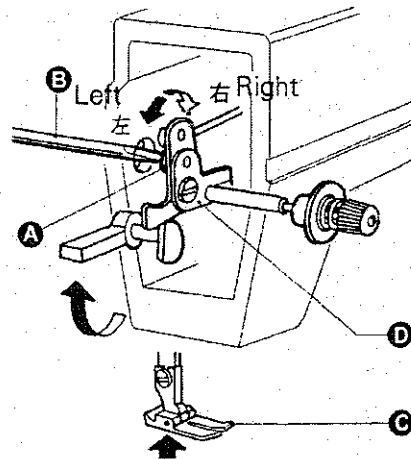


Fig. 8

## THREADING

To thread the needle, raise the needle bar to the upper end of its stroke. Lead the thread from the spool and follow the progression as shown in Fig. 9. To draw the bobbin thread, hold the end of the needle thread and turn the balance wheel to lower the needle bar and then lift it to its highest position. Pull the ends of needle thread and bobbin thread toward the front and under the presser foot.

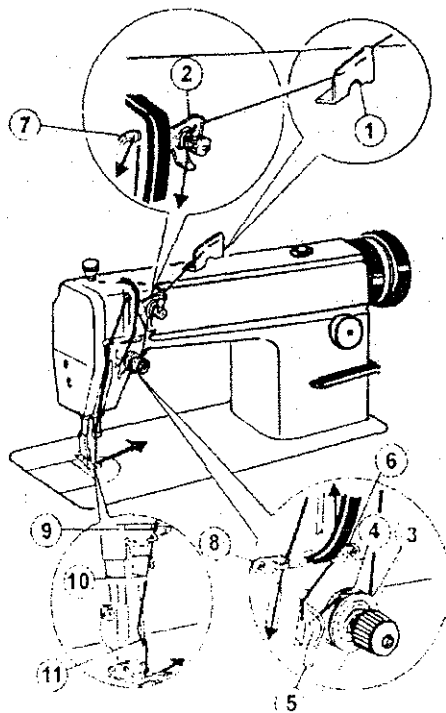


Fig. 9

## BOBBIN WINDER INSTALLATION AND ADJUSTMENT

The bobbin winder pulley should align with the V belt and there should be some clearance between them. When the bobbin winder stop latch lever is depressed, the V belt should be in contact with the bobbin winder pulley so that the bobbin winder pulley can be driven by the V belt. The thread on the bobbin should be uniform and tight. If not, turn the tension stud nut (A) on the bobbin winder tension bracket to adjust the tension. First, loosen the set screw (B) on the bobbin winder tension bracket and move the bracket (C) either left or right as needed. For instance, if the thread is wound as illustrated by figure (b), move the bracket left. If it is wound as in figure (c) move it right. After adjusting the tension make sure to tighten set screw (B). Don not overfill the bobbin, figure (d). For best results, fill to about 80% capacity. This can be adjusted by using screw (E).

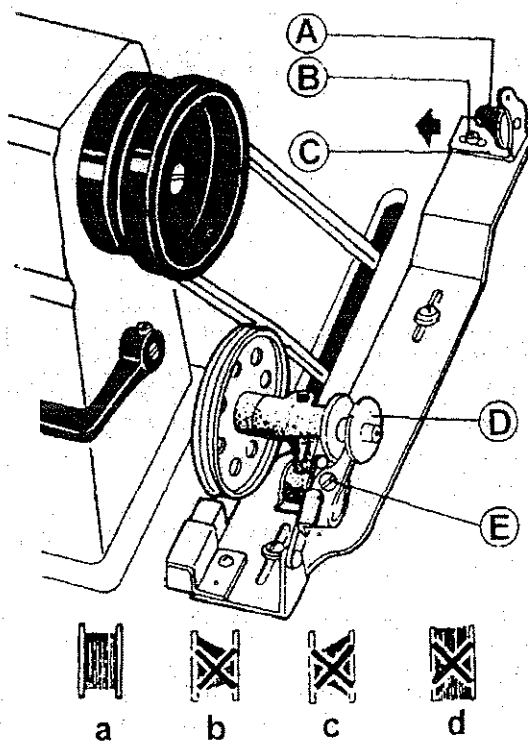


Fig. 10

## ADJUSTING THE PRESSURE ON THE PRESSER FOOT

Adjusting the pressure on the presser foot is dependent upon the thickness of the material being sewn. First, loosen lock nut (A). For heavy materials turn the pressure regulating thumb screw in the direction indicated in Fig. 11 (a) to increase the pressure. For light materials turn the thumb screw in the opposite direction as shown in Fig. 11 (b) to decrease the pressure. Once the appropriate pressure has been set tighten lock nut (A).

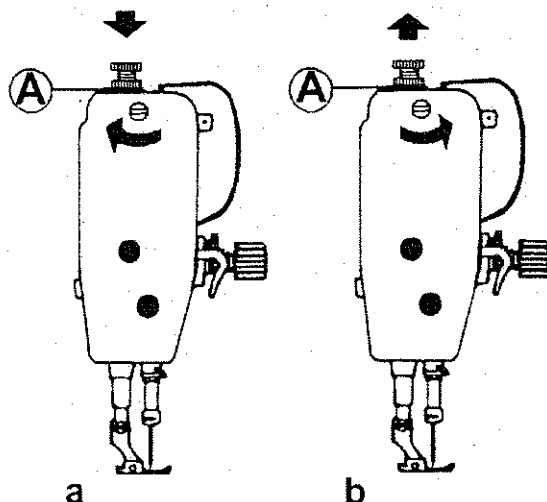


Fig. 11

## THREAD TENSION ADJUSTMENT

Thread tension should be determined in tandem with the stitch obtained by adjusting the tension on the bobbin thread and the needle thread Fig. 12. The tension of the bobbin thread should be adjusted by turning the tension spring regulating screw on the bobbin case. Once it is adjusted, insert the bobbin into the bobbin case and hold the end of the thread from the case and let it hang. If the bobbin rotates slowly downward the tension is correct. The tension on the needle thread is adjusted by turning the thumb nut.

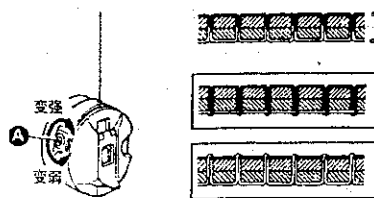
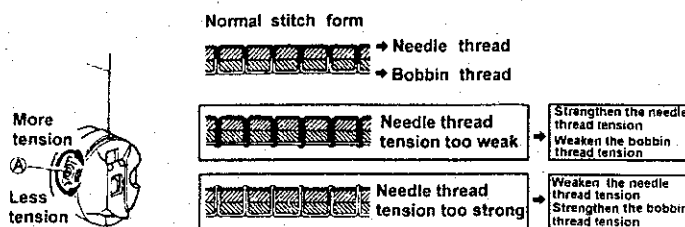


Fig. 12



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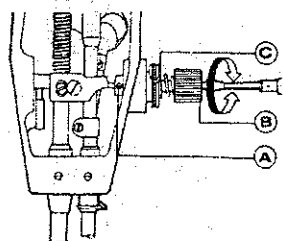


Fig. 13

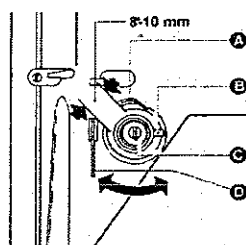


Fig. 14

The stroke of the thread take-up spring runs from 8mm to 10mm. When sewing very thin fabrics, reduce the thread take-up spring tension and increase the thread take-up spring stroke. Conversely increase the thread take-up spring tension and reduce the thread take-up stroke when sewing very thick fabrics.

To adjust the thread take-up spring tension: (Fig. 13), first loosen the set screw (A) then turn the tension stud (B) counter clockwise to decrease the tension of the thread take-up spring (C) to zero. then turn the tension stud (B) clockwise till the spring (C) comes to the notch of the tension regulating bushing, and again turn the tension stud (B) halfway back (counter clockwise ), After the adjustment, tighten the set screw (A).

Adjusting the thread take-up spring stroke: (Fig. 14) loosen the set screw (B) turn the stud (C) clockwise to increase the stroke or turn stud (C) counter clockwise to decrease the stroke. After making the adjustment, tighten set screw (B).

## SYNCHRONIZATION OF THE NEEDLE WITH THE ROTATING HOOK

When the needle bar is raised from its lowest position the gap should equal that illustrated by (A) in Fig. 15. The hook point (D, Fig. 16) of the bobbin should align with the center line of the needle and be 1- 1.5 mm above upper end of the needle eye (Fig 15).

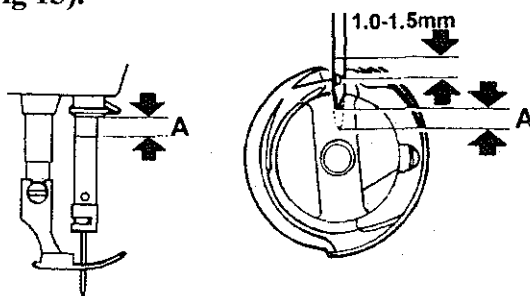


Fig. 15

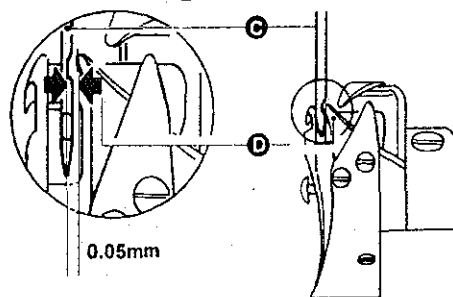


Fig. 16

The clearance between the bottom of the needle notch and the hook point should be approximately 0.05 mm (Fig. 16).



## ADJUSTING STITCH LENGTH AND REVERSE FEEDING

The stitch length can be adjusted by turning dial (A). The figures on the face (B) of the dial show the stitch length in mm. The reverse feed lever must be depressed while adjusting the stitch length. Reverse feeding starts when the reverse feed lever (c) is depressed, the machine will feed forward again when the reverse feed lever is released.

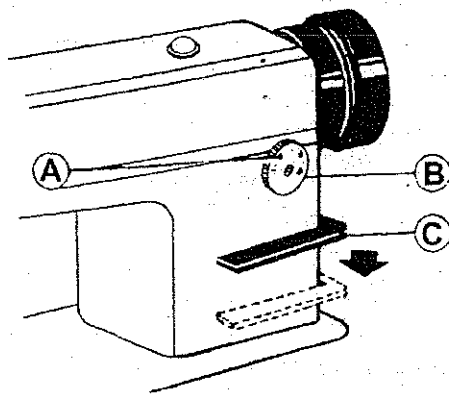


Fig. 17

## ADJUSTING THE POSITION OF THE FEED DOG AND NEEDLE

Turn the balance wheel to lower the Feed Dog (A). When the top of the feed dog is flush with the Throat Plate Surface (B), the Needle Point (C) should be 3mm below the surface of the throat plate. The adjustment should be made by adjusting the position of the feed cam and feed lift cam (Fig. 19).

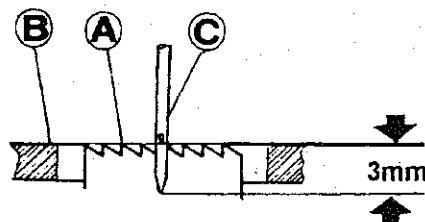


Fig. 18

Standard position is shown in Fig. 19. For the third screw (A) of feed cam and the second screw (B) of feed lift cam to Arm Shaft Oil Hole (C) is set to the direction of the balance wheel turning.

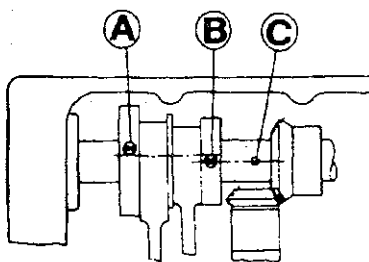


Fig. 19

## STITCH LENGTH ADJUSTMENT

Loosen Screw (A) to adjust Stitch Length Adjusting Cam (B). Turn it to the right to narrow the stitch length for forward stitches, and widen it for reverse; turn it left to widen the stitch length for forward stitches, and narrow it for reverse.

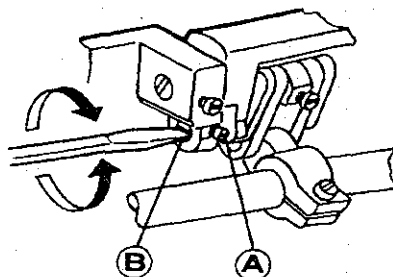


Fig. 20

## FEED DOG HORIZONTAL ADJUSTMENT

Lift the front of the feed dog to prevent the fabric from puckering. Lower the front of the feed dog to prevent the fabric from tearing or the bobbin thread breaking.

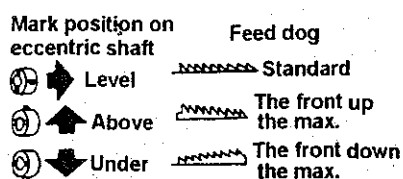


Fig. 21

## THREAD CUTTING MECHANISM

The thread cutting mechanism adapts the hook shaft cam driving for thread cutting. If thread cutting electromagnet works, and after it finishes trimming the thread, reset thread cutting cam crank at once, otherwise this may cause the movable knife and needle to collide and damage them.

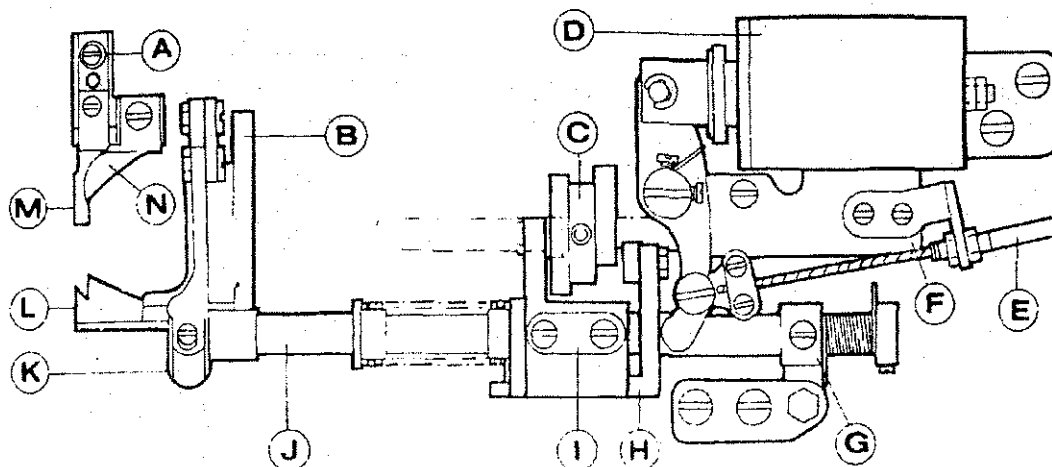


Fig. 22

### KEY FOR Fig. 22

- |                              |                                   |
|------------------------------|-----------------------------------|
| A - fixed knife support asm. | B - knife support asm. (left)     |
| C - thread cutting cam.      | D - thread cutting electromagnet. |
| E - soft thread.             | F - electromagnet asm.            |
| G - stopper.                 | H, I - thread cutting cam crank.  |
| J - cutter driving shaft.    | K - cutter driving crank.         |
| L - knife (left).            | M - fixed knife.                  |
| N - thread retainer.         |                                   |

## KNIFE SUPPORT ASM (left)

Insert the left knife support assembly (B) into Hook Shaft Bushing (C) as the figure shows and then tighten screw (A).

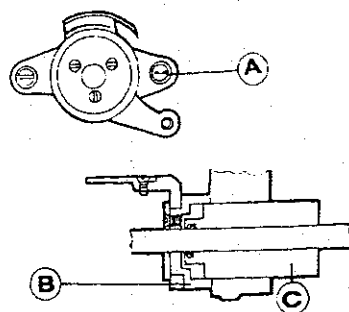


Fig. 23

## FIXED KNIFE SUPPORT ASSEMBLY

Remove the hook positioner and then set it with screw (A) shown in Fig 24 (B)-fixed knife support assembly.

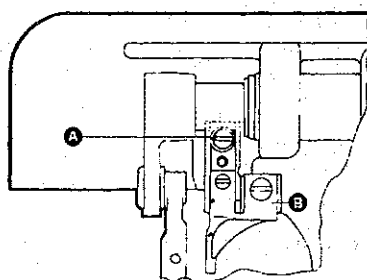


Fig. 24

## POSITION OF THE FIXED KNIFE AND LEFT KNIFE POINT

(1) The standard position is shown in figure 24. If the size is larger than the standard, the knife will either cut the 3 threads or draw the thread out of the needle eye; if smaller, it will cause damage, so be sure to avoid that. If any of the above mentioned situations occur, adjust by setting the fixed knife support or the fixed knife (B).

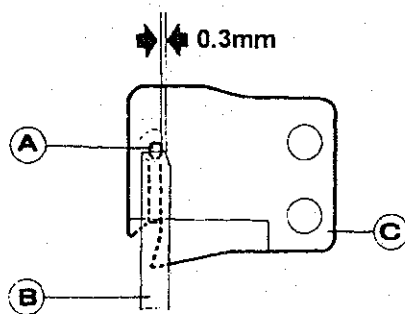


Fig. 25

A-the blade C-the knife (left)

## CONNECTING THE KNIFE SUPPORT AND CUTTER DRIVING CRANK

Connect them as figure 26 shows and notice the position of Cutter Link Lever (A).

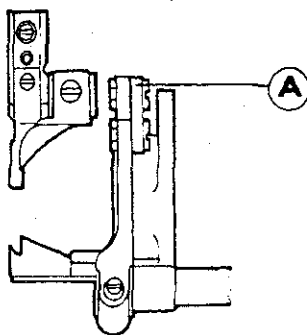


Fig. 26

## POSITIONING THE CUTTER DRIVING SHAFT

The Standard position is shown in figure 27. When assembled, the Cutter Driving Shaft (G) should first be put in Cutter Driving Crank (A). Set Thread Cutting Cam Crank 1 (D) on the cutter driving shaft by referring to the standard position. Set Stopper (F), make sure that there is no clearance between parts around the cutter driving shaft, and rotate evenly.

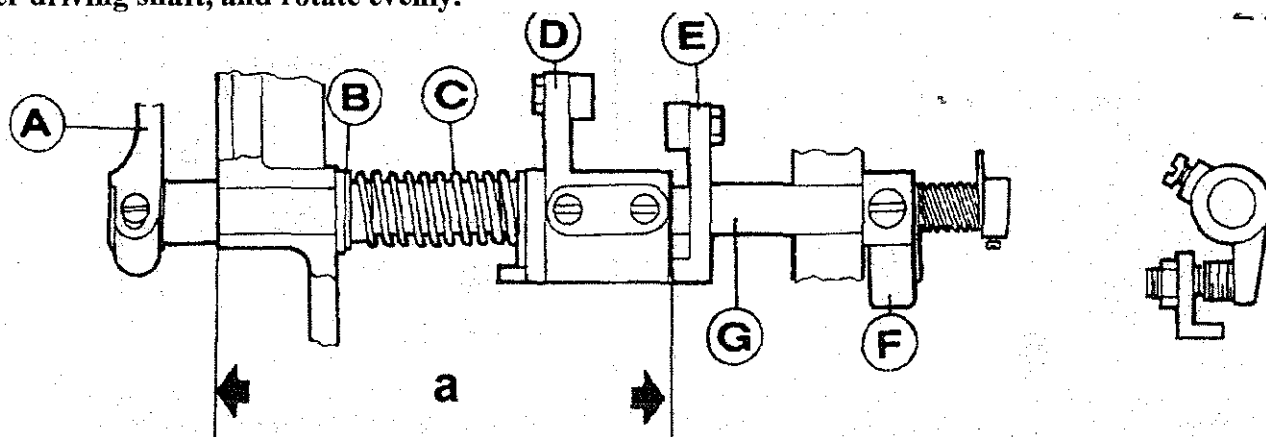


Fig. 27 B-spring end cover C-spring E-thread cutting cam crank 2

## THE ELECTROMAGNET CORE STROKE

The standard stroke of the electromagnet core is 6mm. The stroke can be adjusted with Positioning screw (A).

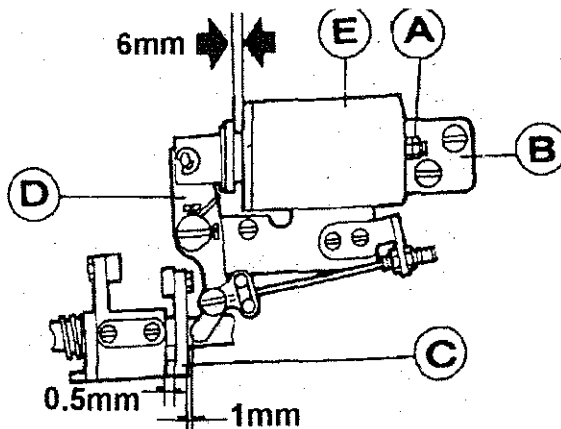


Fig. 28

B-thread cutting electromagnet holder

C-thread cutting cam crank 2

D-driving bar

E-thread cutting electromagnet

The installation parameters are shown in Fig. 28.

## INSTALLING THE THREAD CUTTING CAM

Align balance wheel machine arm No. 2 Positioning Mark (A) with Positioning Mark (B) on the machine arm as shown in Fig. 29.

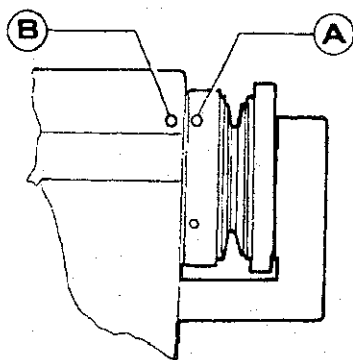


Fig. 29

As the thread cutting electromagnet runs, the Thread Cutting Cam (A) rotates in the normal direction. Fix the cam when Cam (A) is engaged with Roller (B).

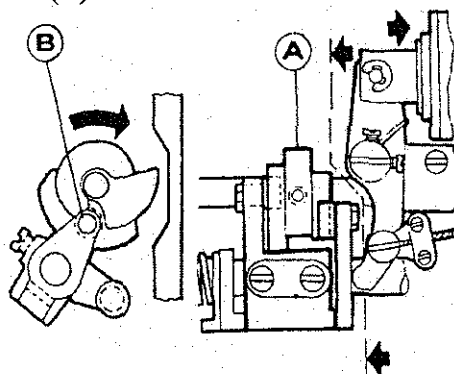


Fig. 30

To stop operating the electromagnet, reset Cam Driving Crank (A), Cam (B) is separated from engaging with the roller, the standard clearance is 0.5- 1 mm.

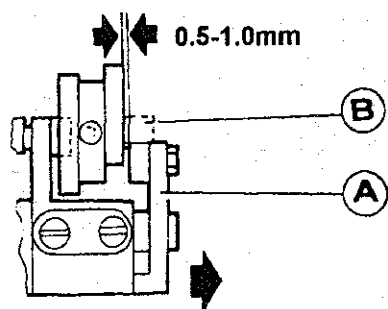


Fig. 31

Note: figure 32 shows the standard position of Cam Driving Crank (D) before operation.

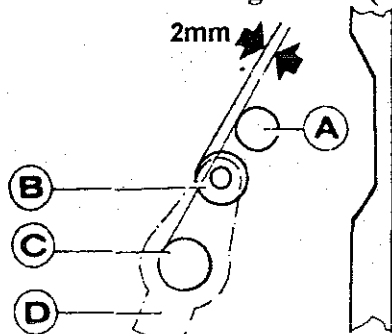


Fig. 32

Key: A-hook shaft B-roller C-cutter driving shaft

It may change the positions mentioned above to remove the stopper, then adjust with Screw (A), and readjust following the progression from Fig. 29-31.

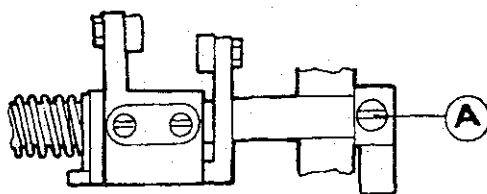


Fig. 33

## ADJUSTING KNIFE CUTTING DEPTH

Figure 34 shows the standard positions of left knife and the fixed knife.

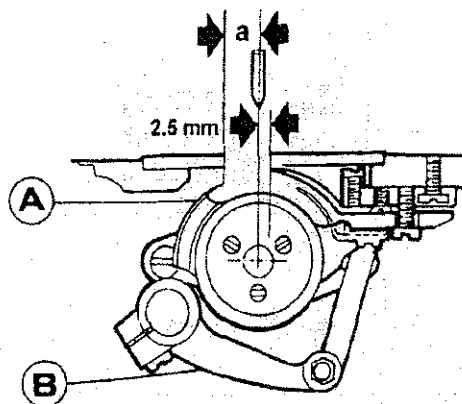


Fig. 34

Key: A-knife (right) B-cutter driving shaft

**Adjusting the knife cutting depth:** When the electromagnet is working, run the machine, the left knife (A) will follow the motion of the thread cutting cam. The maximum degree of cutting depth is 1.5-2.0mm (B) for the fixed knife. Adjust the cutter driving crank if necessary.

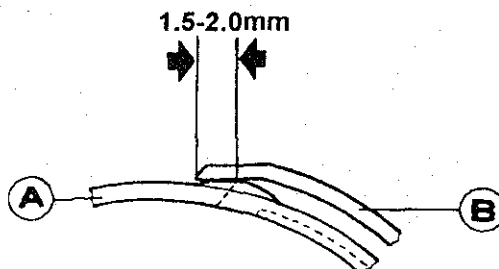


Fig. 35

## ADJUSTING THE CUTTING PRESSURE

Figure 36 shows the standard position that the Left Knife (A) begins to touch the Fixed Knife (B).

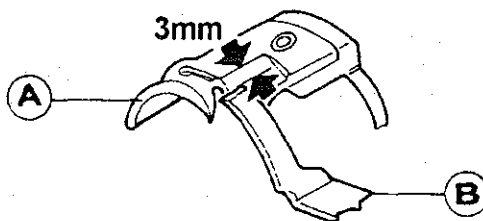


Fig. 36

(2) When cutting heavier thread, increase the cutting pressure. To adjust the cutting pressure, loosen Set Nut (A), and adjust Screw (B).

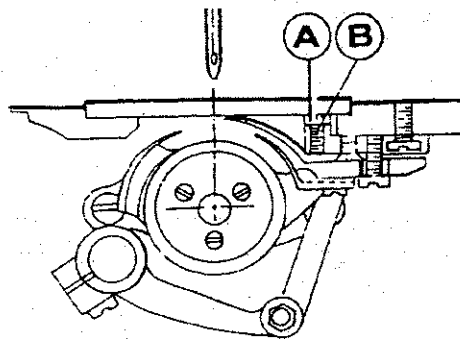


Fig. 37

## ADJUSTING THE NEEDLE THREAD TENSION

There should be a clearance of 1 mm between the two discs while the thread cutting electromagnet (A) is working. To make an adjustment, loosen Nut (B) and move soft thread (C).

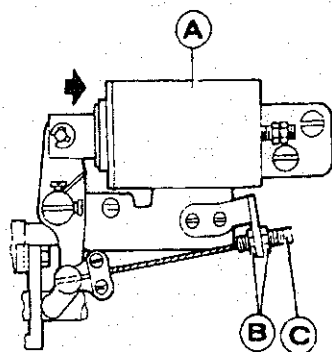


Fig. 38

**Note:** If the clearance is too narrow, the thread end left after cutting is too short and may be pulled away from the needle eye; otherwise the tension will be slack and will effect the needle thread tension.

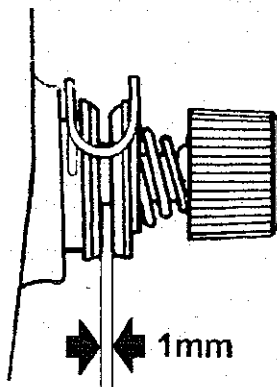


Fig. 39

## THREAD ENDS ADJUSTMENT

To get the needle thread ends to the proper length, adjust Nut (A). Turn right to shorten. Turn left to lengthen.

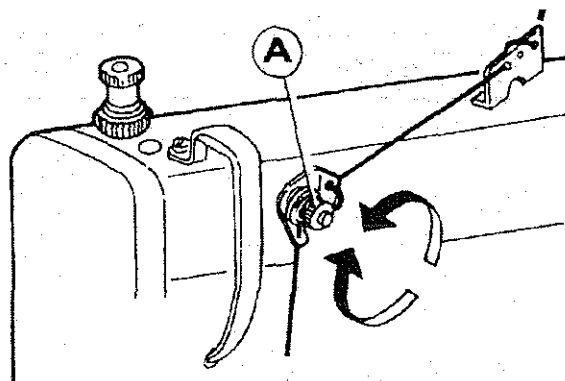


Fig. 40

## INSTALLING REVERSE STITCH ELECTROMAGNET

Adjust the position of Electromagnet (A) properly to guarantee the flexible connection of the magnet to the link lever and the convenient operation of Reverse Stitch Bar (B), then set with a screw.

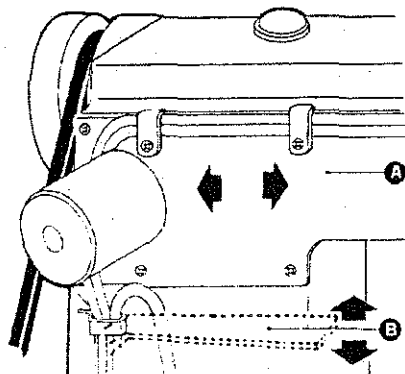


Fig. 41

## REVERSE SWITCH

The figure shows the normal position. To reverse stitch, simply slide the switch as indicated in Fig. 42. To resume normal sewing, slide the switch back to the original position.

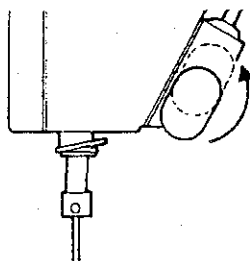


Fig. 42



## THREAD RETAINING DEVICE

### Thread Retainer Height

The standard height is 2 mm from the needle point when the needle is at its highest position.

To adjust Thread Retainer (B), loosen screw (A).

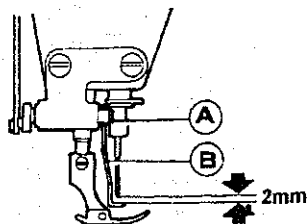


Fig. 43

When the magnet is electromagnetically engaged, the standard distance between the thread retainer and the center of the needle should be 0-2 mm.

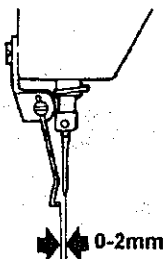


Fig. 44

To adjust its position, loosen Screw (C) and Screw (B) and then adjust the position of Electromagnet Assembly (A).

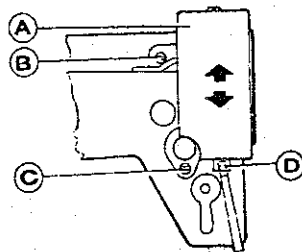
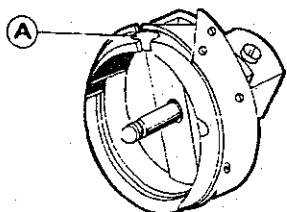
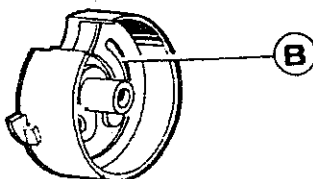


Fig. 45

## HOOK BOBBIN CASE AND BOBBIN

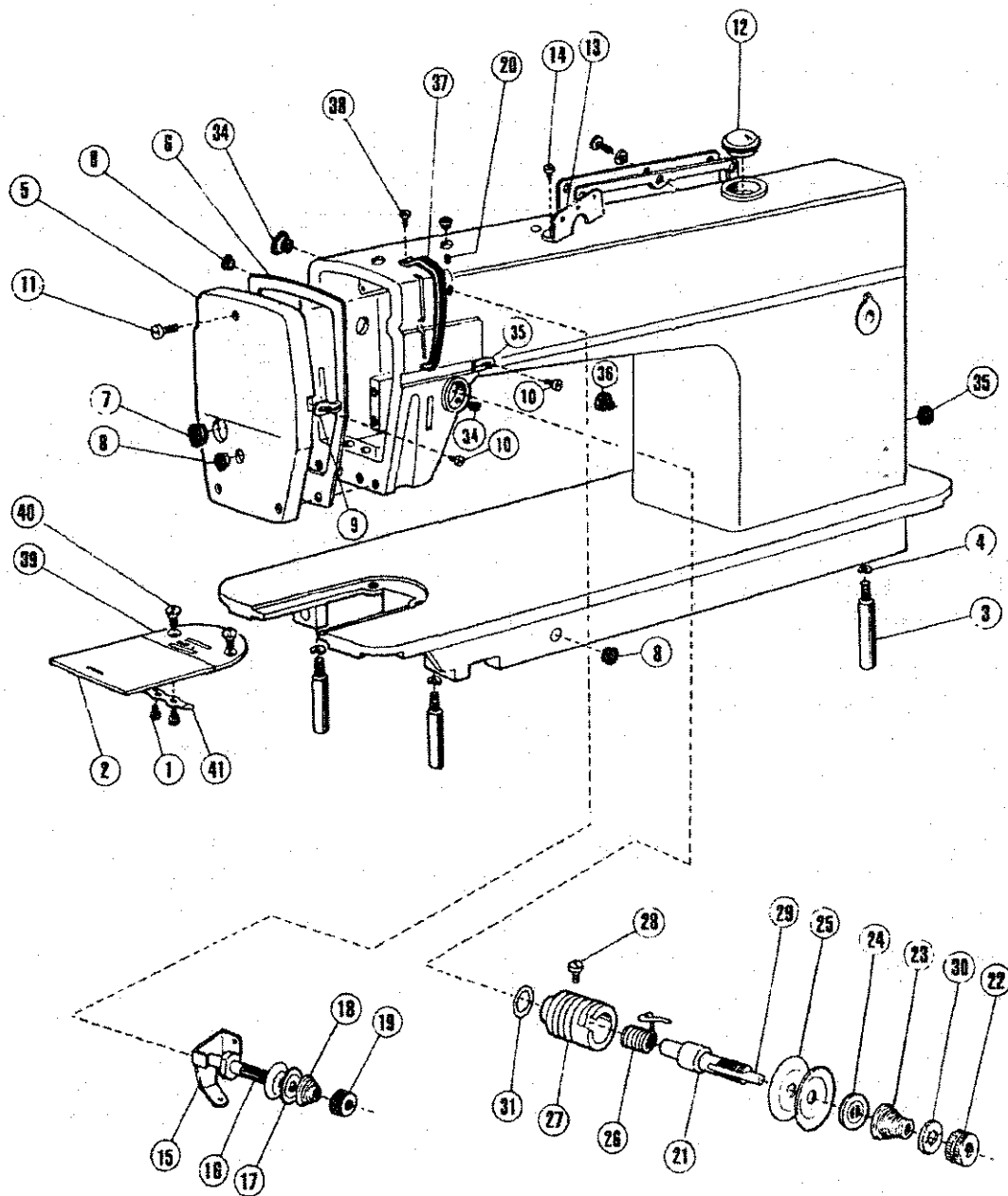


There is a thread groove (A) in the special hook for thread cutting sewing machine.



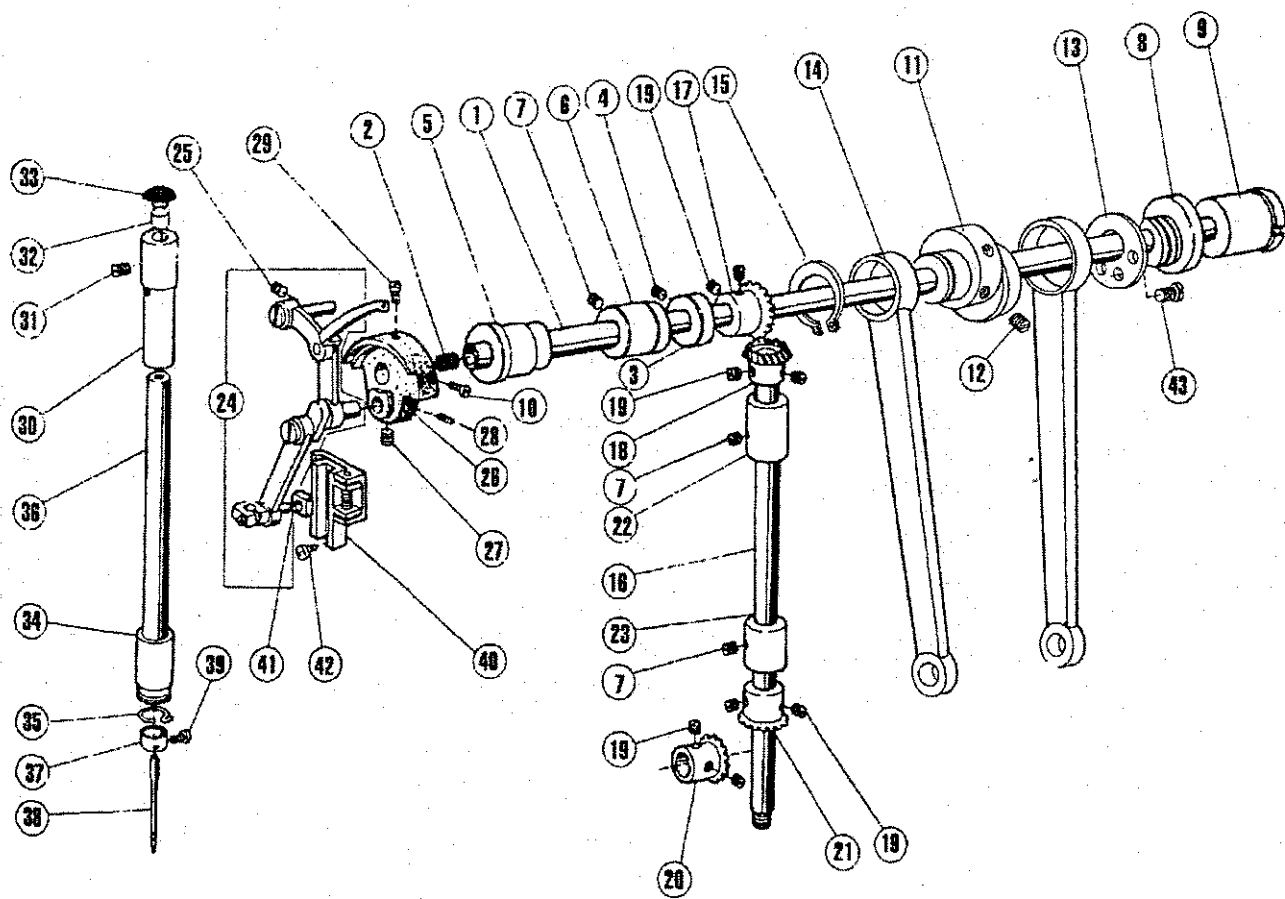
2. The bobbin case used in the machine should be equipped with a spring (B) in the bottom, which prevents the bobbin from running when it is empty.

# PARTS CATALOGUE



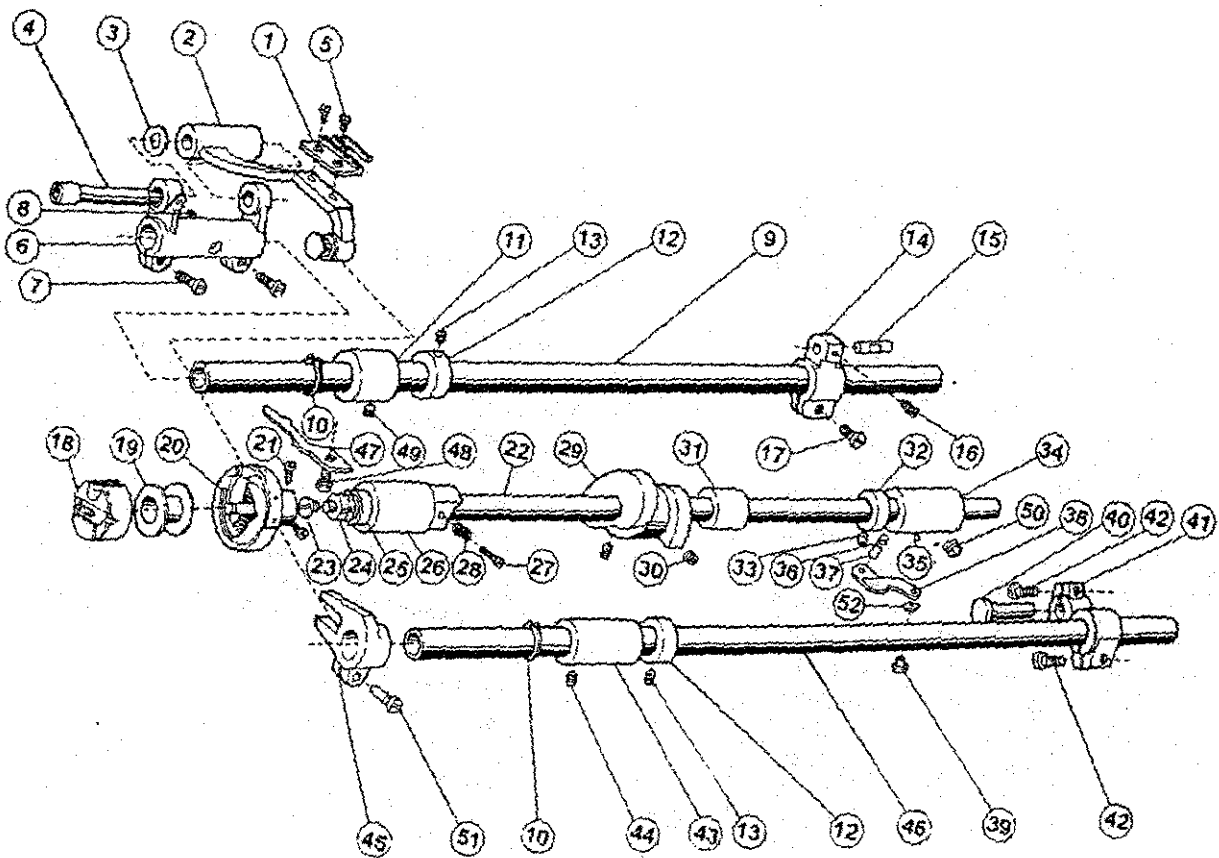
# ARM AND BED MECHANISM

| No. | Part No.     | Description |
|-----|--------------|-------------|
| 1   | 22T1 -021G3  | 推板簧螺钉       |
| 2   | 22T1 -021G1  | 推板          |
| 3   | 48T1 -005    | 底板撑杆        |
| 4   | GB93 -76     | 垫圈 6        |
| 5   | 124T1 -002B1 | 面板          |
| 6   | 124T1 -002B2 | 面板垫片        |
| 7   | 22T1 -003C3  | 橡皮塞         |
| 8   | 22T1 -003C4  | 橡皮塞         |
| 9   | 22T1 -003C5  | 面板线勾        |
|     | 78T1 -004C1  | 面板线勾        |
| 10  | 22T1 -003C6  | 线勾螺钉        |
| 11  | 22T1 -004    | 面板螺钉        |
| 12  | 22T1 -008H   | 油窗组件        |
| 13  | 36T2 -004    | 三孔线勾        |
| 14  | 36T2 -005    | 三孔线勾螺钉      |
| 15  | 36T2 -006D1  | 小夹线过线板      |
| 16  | 36T2 -006D2  | 小夹线螺钉       |
| 17  | 22T1 -009E3  | 小夹线板        |
| 18  | 36T2 -006D3  | 小夹线弹簧       |
| 19  | 36T2 -006D4  | 小夹线螺母       |
| 20  | 22T1 -011    | 小夹线固定螺钉     |
| 21  | 22T1 -012F1  | 夹线螺钉        |
| 22  | 22T1 -012F2  | 夹线螺母        |
| 23  | 22T1 -012F3  | 夹线弹簧        |
|     | 48T1 -003A1  | 夹线弹簧        |
| 24  | 22T1 -012F4  | 松线板         |
| 25  | 22T1 -012F5  | 夹线板         |
| 26  | 22T1 -012F6  | 挑线簧         |
|     | 48T1 -003A2  | 挑线簧         |
| 27  | 22T1 -012F7  | 夹线调节座       |
| 28  | 22T1 -012F8  | 夹线调节座螺钉     |
| 29  | 22T1 -012F9  | 松线钉         |
| 30  | 22T1 -012F10 | 夹线螺母止动板     |
| 31  | 22T1 -012F11 | O 型圈        |
| 32  | 22T1 -013    | 夹线调节座固定螺钉   |
| 33  | 22T1 -014    | 线勾          |
|     | 78T1 -005    | 线勾          |
| 34  | 22T1 -015    | 橡皮塞         |
| 35  | 22T1 -016    | 橡皮塞         |
| 37  | 36T2 -007    | 挑线杆护罩       |
|     | 78T2 -002    | 挑线杆护罩       |
| 38  | 22T2 -004    | 挑线杆护罩螺钉     |
| 39  | 36T2 -008    | 针板(B1.8)    |
|     | 48T1 -004    | 针板          |
| 40  | 22T1 -020    | 针板螺钉        |
| 41  | 22T1 -012G2  | 推板簧         |



# ARM SHAFT, VERTICAL SHAFT AND THREAD TAKE-UP MECHANISM

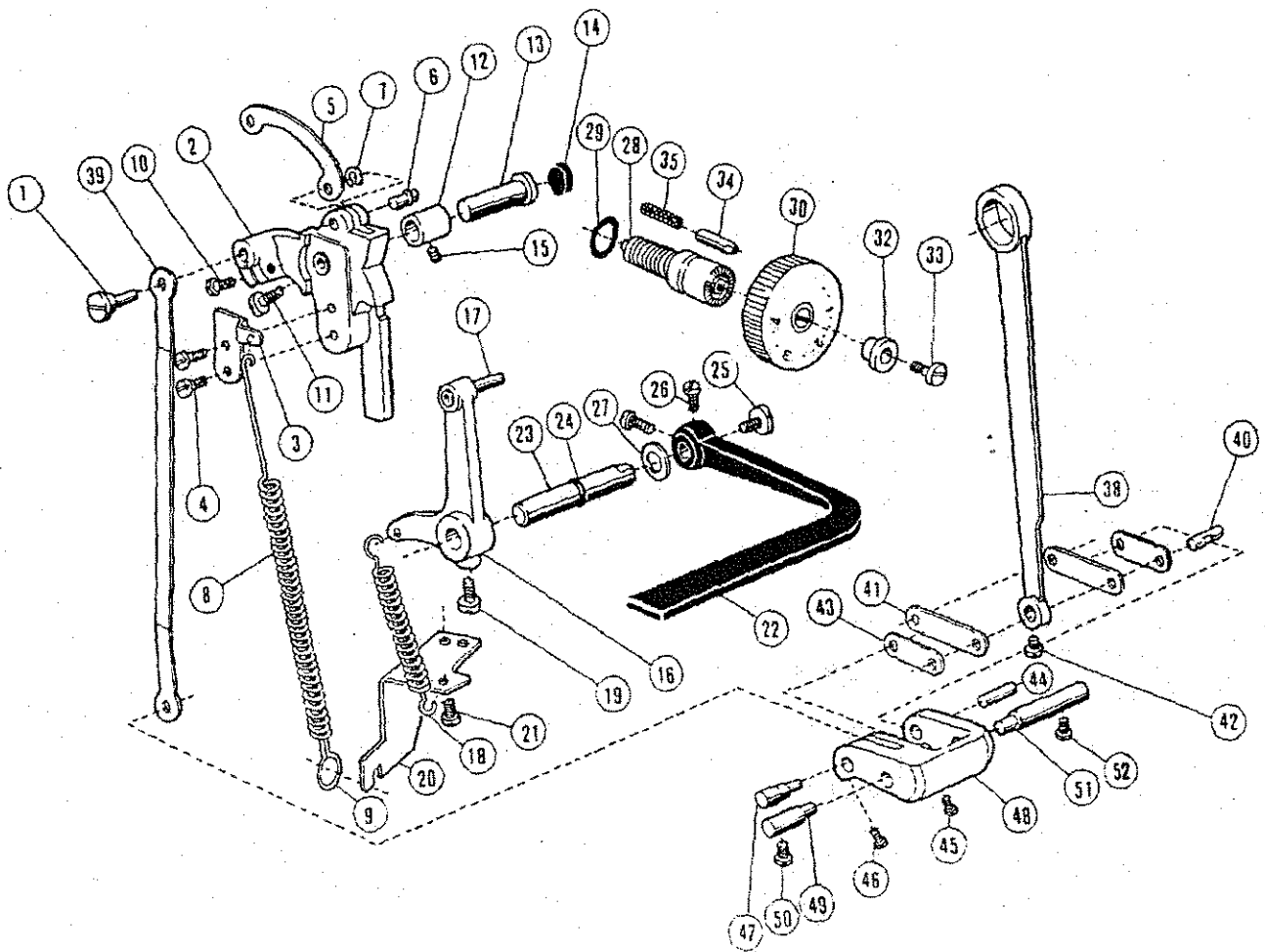
| No. | Part No.         | Description |
|-----|------------------|-------------|
| 1   | 108T3 -001A1     | 上轴          |
| 2   | 22T3 -001A2      | 上轴橡皮塞       |
| 3   | 22T3 -002B1      | 上轴紧圈        |
| 4   | 22T2 -005B3      | 上轴紧圈螺钉      |
| 5   | 22T3 -003        | 上轴轴套(左)     |
| 6   | 22T3 -004        | 上轴轴套(中)     |
| 7   | 22T2 -002        | 轴套螺钉        |
| 8   | 165310001        | 上轴轴套(右)     |
| 9   | 124T3 -003C2     | 上轴轴套(右)油封   |
| 10  | 22T2 -006        | 针杆曲柄螺钉      |
| 11  | 36T3 -003        | 凸轮          |
|     | 114T3 -001       | 凸轮          |
| 12  | 22T1 -013        | 凸轮螺钉        |
| 13  | 36T3 -004        | 凸轮挡板        |
| 14  | 22T3 -009D1c     | 抬牙连杆        |
| 15  | 36T3 -004        | 送布凸轮挡板      |
| 16  | 22T3 -010E1      | 竖轴          |
| 17  | 22T3 -010E2a1 -2 | 上轴伞齿轮       |
| 18  | 22T3 -010E2a2 -2 | 竖轴伞齿轮(上)    |
| 19  | 22T2 -005B3      | 伞齿轮螺钉       |
| 20  | 22T3 -010E2b1 -2 | 下轴伞齿轮       |
| 21  | 22T3 -010E2b2 -2 | 竖轴伞齿轮(下)    |
| 22  | 22T3 -011        | 竖轴轴套(上)     |
| 23  | 22T3 -011        | 竖轴轴套(下)     |
|     | 78T3 -002        | 竖轴轴套(下)     |
| 24  | 22T2 -001A       | 针杆连杆挑线大组件   |
|     | 48T2 -001A       | 针杆连杆挑线大组件   |
|     | 78T2 -001A       | 针杆连杆挑线大组件   |
| 25  | 22T2 -002        | 挑线连杆铰链轴螺钉   |
| 26  | 22T2 -005B1      | 针杆曲柄        |
|     | 48T2 -002B       | 针杆曲柄        |
| 27  | 22T2 -005B2      | 挑线曲柄螺钉      |
| 28  | 22T2 -006        | 挑线曲柄定位螺钉    |
| 29  | 22T2 -007        | 针杆曲柄定位螺钉    |
| 30  | 22T2 -008        | 针杆轴套(上)     |
| 31  | 22T2 -009        | 针杆轴套(上)螺钉   |
| 32  | 22T2 -010        | 针杆轴套(上)毡塞   |
| 33  | 22T2 -011        | 针杆轴套(上)橡皮塞  |
| 34  | 22T2 -012C1      | 针杆轴套(下)     |
|     | 124T2 -006       | 针杆轴套(下)     |
| 35  | 22T2 -012C2      | 针杆轴套(下)过线勾  |
| 36  | 22T2 -014        | 针杆          |
|     | 78T2 -004        | 针杆          |
| 37  | 22T2 -015        | 针杆过线环       |
|     | 48T2 -004        | 针杆过线环       |
| 38  | DB x1 14#        | 机针          |
|     | DP x5 18#        | 机针          |
|     | DB x1 22#        | 机针          |
| 39  | 22T2 -017        | 夹针螺钉        |
| 40  | 36T3 -005E       | 针杆接头滑块导轨组件  |
| 41  | 22T2 -020        | 针杆接头滑块      |
| 42  | 22T2 -019        | 滑块导轨螺钉      |
| 43  | 100T6 -012       | 送布凸轮挡板螺钉    |



# FEEDING, FEED LIFTING AND ROTATING HOOK MECHANISM

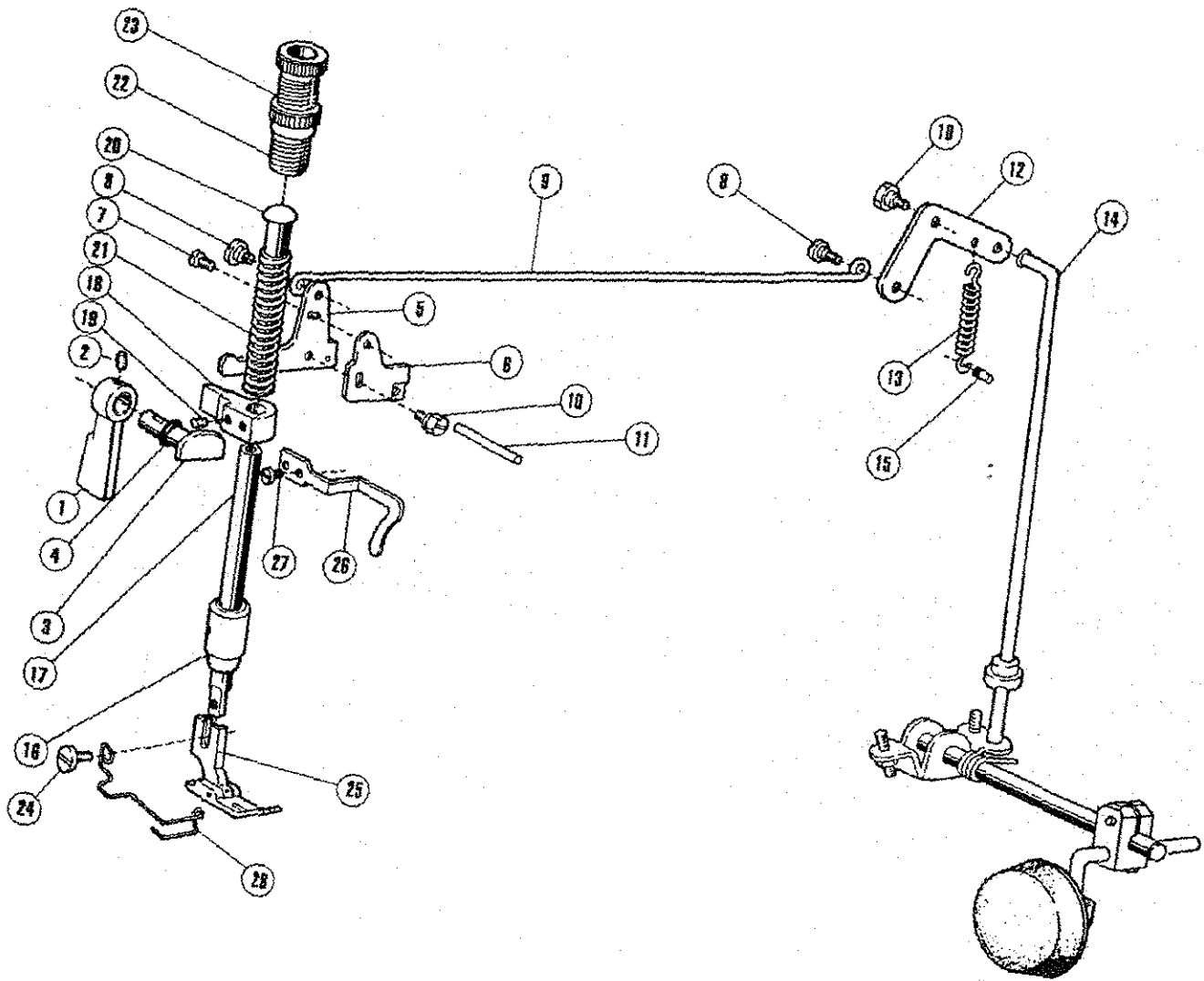
| No. | Part No.      | Description |
|-----|---------------|-------------|
| 1   | 22T6 -001A3   | 送布牙         |
| 2   | 36T4 -001A1a  | 牙架小组件       |
| 3   | 22T6 -001A6   | 牙架垫圈        |
| 4   | 36T4 -001A2   | 牙架曲柄偏心轴     |
| 5   | 22T6 -001A4   | 送布牙螺钉       |
| 6   | 22T6 -001A1a  | 牙架曲柄        |
| 7   | 22T6 -001A1b  | 牙架曲柄螺钉      |
| 8   | 22T2 -019     | 牙架曲柄轴螺钉     |
| 9   | 36T4 -002     | 送布轴         |
| 10  | GB894 -76     | 轴用弹性挡圈      |
| 11  | 22T6 -004     | 送布轴轴套       |
| 12  | 22T6 -005B1   | 紧圈          |
| 13  | 22T3 -002B2   | 紧圈螺钉        |
| 14  | 36T4 -003     | 送布轴曲柄(右)    |
|     | 114T4 -001    | 送布轴曲柄(右)    |
| 15  | 36T4 -004H01  | 曲柄连杆短销      |
| 16  | 36T5 -008E5   | 曲柄连杆短销螺钉    |
| 17  | 22T6 -008D3   | 送布轴曲柄(右)螺钉  |
| 18  | 36T4 -005B    | 梭芯套组件       |
|     | 78T4 -004F    | 梭芯套组件       |
| 19  | 36T4 -006     | 梭芯          |
|     | 78T4 -005     | 梭芯          |
| 20  | 36T4 -007C    | 旋梭组件        |
|     |               | 旋梭组件        |
| 21  | 36T4 -007C4   | 旋梭螺钉        |
| 22  | 36T4 -008D1   | 下轴          |
|     | 120T4 -001    | 下轴          |
| 23  | 22T4 -001A1a1 | 下轴滤油塞螺钉     |
| 24  | 22T4 -001A1a2 | 下轴滤油塞       |
| 25  | 36T4 -009G    | 下轴油封        |
| 26  | 36T4 -010     | 下轴轴套(左)     |
| 27  | 22T4 -005     | 油量调节螺钉      |
| 28  | 22T4 -006     | 油量调节弹簧      |
| 29  | 36T4 -011E1   | 切线凸轮        |
| 30  | 36T4 -011E2   | 切线凸轮螺钉      |
| 31  | 36T4 -012     | 下轴轴套(中)     |
| 32  | 22T4 -002B1   | 下轴紧圈        |
| 33  | 22T2 -009     | 下轴紧圈螺钉      |
| 34  | 36T4 -014F1   | 下轴轴套(右)     |
| 35  | 22T4 -007C2   | 下轴轴套油管      |
| 36  | 36T4 -015     | 柱塞          |
| 37  | 36T4 -016     | 柱塞弹簧        |
| 38  | 22T4 -010     | 挡板          |
|     | 78T4 -006     | 挡板          |
| 39  | 22T8 -009     | 挡板螺钉        |
| 40  | 22T6 -007     | 抬牙轴曲柄铰链轴    |
| 41  | 36T4 -017     | 抬牙曲柄(右)     |
| 42  | J0.0.71       | 抬牙曲柄螺钉      |
| 43  | 22T6 -012     | 抬牙轴套(左)     |
| 44  | 22T2 -002     | 抬牙轴套螺钉      |
| 45  | 36T4 -018H1D1 | 抬牙叉         |
| 46  | 36T4 -018H2   | 抬牙轴         |
| 47  | 22T4 -013     | 旋梭定位勾       |
|     | 48T4 -002     | 旋梭定位勾       |
|     | 78T4 -003     | 旋梭定位勾       |
| 48  | 22T4 -015     | 旋梭定位勾螺钉     |
| 49  | 22T2 -009     | 送布轴轴套螺钉     |
| 50  | 22T1 -013     | 下轴轴套(右)螺钉   |
| 51  | 22T6 -008D3   | 抬牙叉夹紧螺钉     |
| 52  | GB93 -76      | 挡板螺钉弹簧垫圈    |





# STITCH LENGTH REGULATING MECHANISM

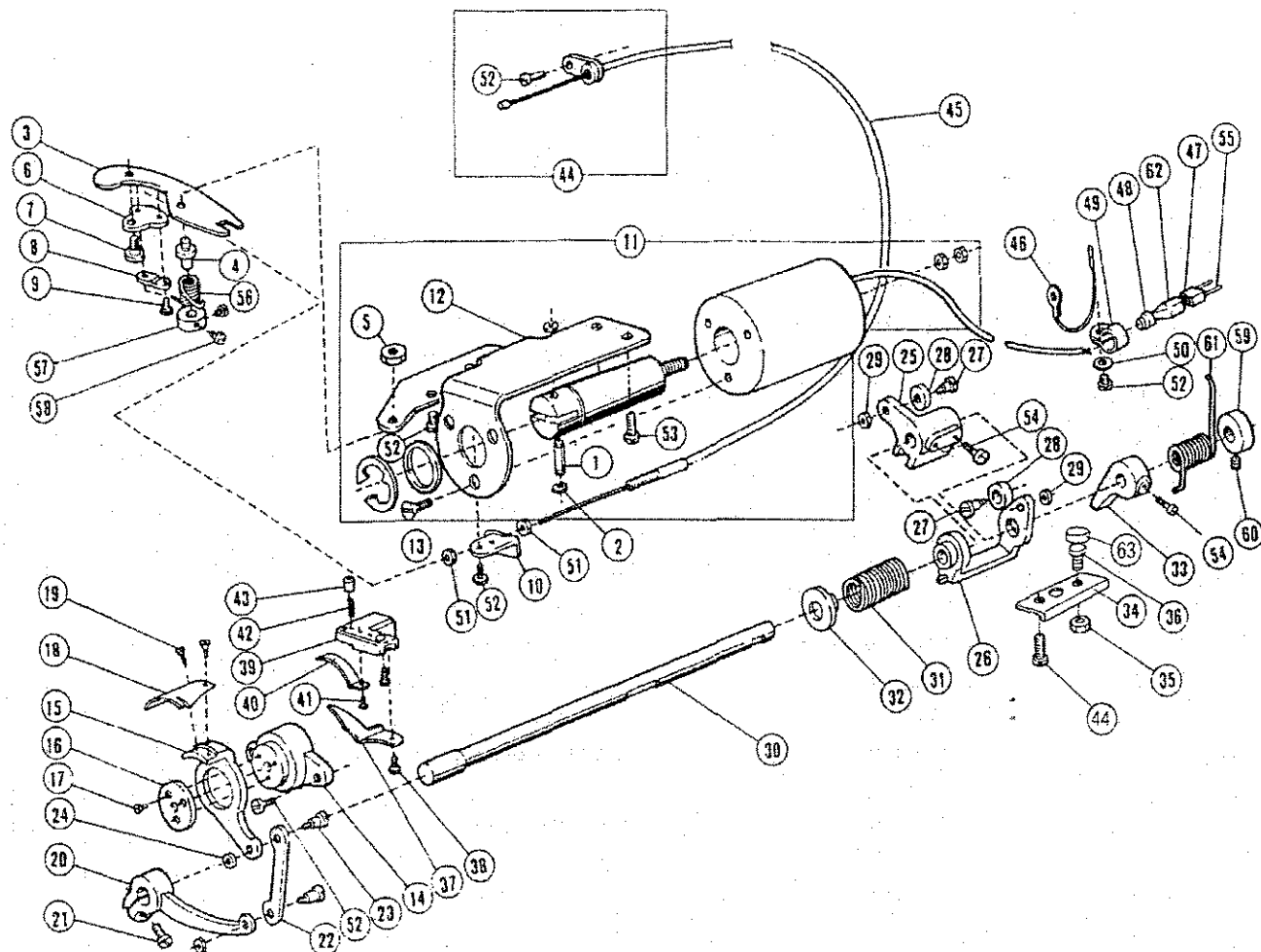
| No. | Part No.       | Description      |
|-----|----------------|------------------|
| 1   | 36T5 -001      | 针距调节连杆销钉         |
| 2   | 36T5 -002A1    | 针距座              |
|     | 114T5 -001     | 针距座              |
| 3   | 36T5 -002A2    | 拉簧勾              |
| 4   | 22T2 -019      | 拉簧勾螺钉            |
| 5   | 36T5 -002A3    | 倒缝连杆             |
| 6   | 36T5 -002A4    | 针距座销             |
| 7   | GB896 - 75     | 开口挡圈             |
| 8   | 36T5 -002A5    | 针距座拉簧            |
| 9   | 36T5 -002A6    | 针距座拉簧调节勾         |
| 10  | 22T6 -008D3    | 针距座长螺钉           |
| 11  | 22T5 -010D4    | 针距座短螺钉           |
| 12  | 22T5 -003      | 针距座衬套            |
| 13  | 22T5 -004      | 针距座轴             |
| 14  | 36T5 -003      | 橡皮塞              |
| 15  | 22T2 -002      | 针距座衬套紧固螺钉        |
| 16  | 36T5 -004B1    | 倒缝操纵杆曲柄          |
| 17  | 36T5 -004B2    | 操纵杆曲柄轴           |
| 18  | 36T5 -004B3    | 操纵杆拉簧            |
| 19  | 22T5 -013      | 操纵杆曲柄螺钉          |
| 20  | 36T5 -005      | 拉簧架              |
| 21  | 22T5 -001A4    | 拉簧架螺钉            |
| 22  | 22T5 -010D1    | 倒缝操纵杆            |
| 23  | 36T5 -006C1a1  | 倒缝操纵杆短轴          |
| 24  | GB3452.1 -92   | O 型密封圈 6.3 ×1.8G |
| 25  | 22T5 -010D3    | 倒缝操纵杆吊紧螺钉        |
| 26  | 22T5 -010D4    | 倒缝操纵杆螺钉          |
| 27  | 22T5 -011      | 倒缝操纵杆垫圈          |
| 28  | 124T5 -001A2   | 针距调节螺杆           |
| 29  | 124T5 -001A3   | O 型橡胶圈           |
| 30  | 124T5 -002B1   | 针距旋钮             |
|     | 124T5 -001A5   | 针距旋钮             |
| 32  | 36T5 -007D4    | 标盘螺钉衬套           |
| 33  | 36T5 -007D5    | 针距盘螺钉            |
| 34  | 36T5 -012      | 止动销              |
| 35  | 22T5 -009      | 止动销弹簧            |
| 38  | 36T5 -008E2    | 送布连杆             |
| 39  | 36T5 -008E3    | 针距调节连杆           |
| 40  | 36T4 -004H02   | 曲柄连杆长销           |
| 41  | 36T5 -008E4H02 | 曲柄长连杆            |
|     | 114T5 -003     | 曲柄长连杆            |
| 42  | 36T5 -008E5    | 送布连杆螺钉           |
| 43  | 36T5 -008E4H01 | 曲柄短连杆            |
| 44  | 36T5 -008E6    | 曲柄短连杆销           |
| 45  | 36T5 -008E7    | 短连杆销螺钉           |
| 46  | 36T5 -008E8    | 连杆偏心轴螺钉          |
| 47  | 36T5 -008E9    | 连杆偏心轴            |
| 48  | 36T5 -008E10   | 针距调节曲柄           |
| 49  | 36T5 -009H02   | 针距调节曲柄定位销(左)     |
| 50  | 22T6 -008D3    | 左定位销螺钉           |
| 51  | 36T5 -009H01   | 针距调节曲柄定位销(右)     |
| 52  | 22T6 -008D3    | 右定位销螺钉           |



# PRESSER FOOT MECHANISM

| No. | Part No. | Description |
|-----|----------|-------------|
|-----|----------|-------------|

|    |               |             |                            |
|----|---------------|-------------|----------------------------|
| 1  | 57T7 -001A1   | 压脚扳手        | Presser bar lifter         |
| 2  | J0.0.35       | 压脚扳手螺钉      | Screw                      |
| 3  | 36T6 -002B1   | 压紧杆提升凸轮     | Presser bar lifting cam    |
| 4  | GB1235 -76    | 压紧杆提升凸轮油封   | Oil seal                   |
| 5  | 36T6 -003C1a1 | 膝控提升杠杆(左)   | Knee lifter lever (left)   |
| 6  | 22T7 -004B1b  | 松线凸轮        | Tension releasing cam      |
| 7  | 22T7 -004B1c  | 膝控提升杠杆(左)螺钉 | Screw                      |
| 8  | 22T7 -004B2   | 铰链螺钉        | Screw                      |
| 9  | 22T7 -004B3   | 膝控提升拉杆      | Knee lifter rod            |
| 10 | 22T7 -005     | 松线凸轮螺钉      | Screw                      |
|    |               | 膝控提升杠杆(右)螺钉 | Screw                      |
| 11 | 36T6 -004     | 松线杆         | Thread releasing pin       |
| 12 | 22T7 -007C1   | 膝控提升杠杆(右)   | Knee lifter lever (right)  |
| 13 | 22T7 -007C2   | 膝控提升杆(右)弹簧  | Coil spring                |
| 14 | 22T7 -007C3   | 膝控提升连杆      | Knee lifter connecting rod |
| 15 | 22T7 -008     | 弹簧销         | Pin for spring             |
| 16 | 22T7 -009     | 压紧杆轴套       | Bushing for presser bar    |
| 17 | 22T7 -010     | 压紧杆         | Presser bar                |
| 18 | 22T7 -011D1   | 压紧杆导架       | Presser bar guide bracket  |
| 19 | 36T6 -007     | 压紧杆导架螺钉     | Screw                      |
| 20 | 22T7 -012     | 压紧杆弹簧导柱     | Presser spring guide       |
| 21 | 48T7 -002     | 压紧杆弹簧       | Presser spring             |
| 22 | 22T7 -014E1   | 调压螺钉        | Thumb screw                |
| 23 | 22T7 -014E2   | 调压螺钉锁紧螺母    | Lock nut                   |
| 24 | 22T7 -015     | 压脚螺钉        | Screw                      |
| 25 | 22T7 -017F    | 压脚组件        | Presser foot asm           |
|    | 48T7 -003A    | 压脚组件        | Presser foot asm           |
| 26 | 36T6 -009     | 大线勾         | Thread guide               |
| 27 | 22T2 -004     | 大线勾螺钉       | Screw                      |
| 28 | 57T7 -002     | 压脚护簧        | Presser foot spring        |

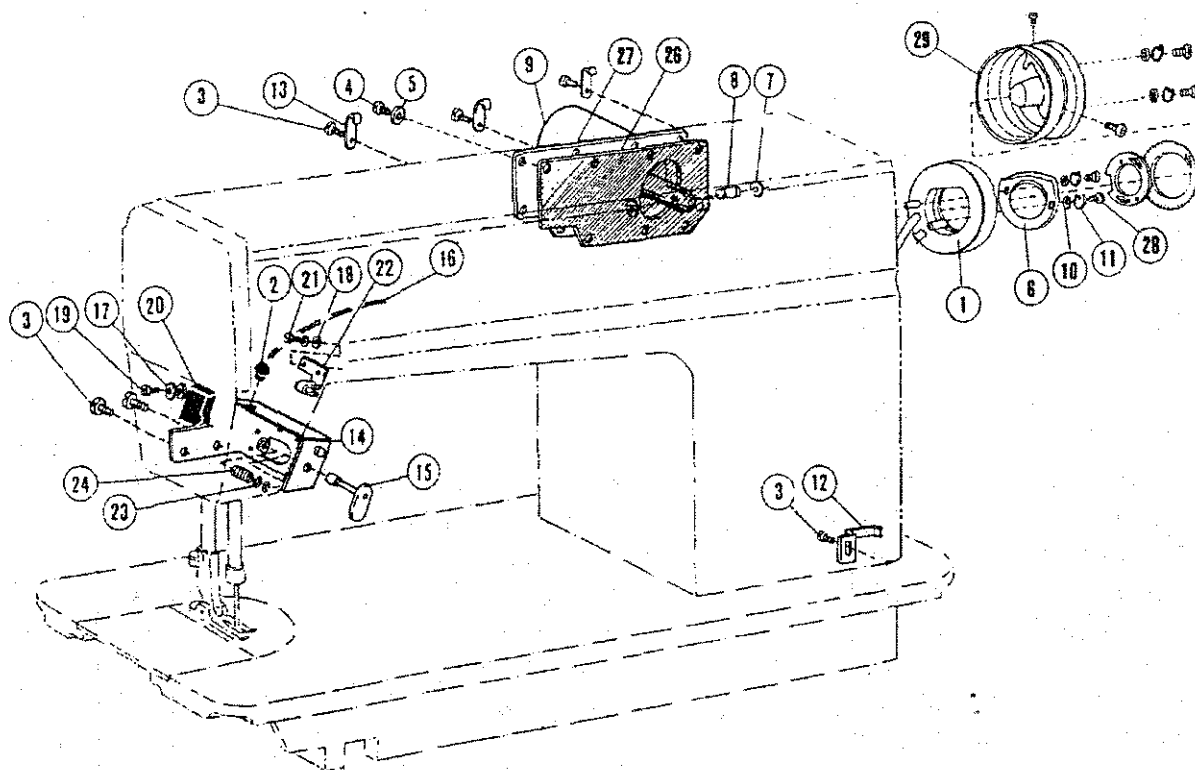


## KNIFE ACTUATING MECHANISM

| No. | Part No.       | Description                                 |
|-----|----------------|---------------------------------------------|
| 1   | 36T8 - 009     | 切线电磁铁销<br>Pin                               |
| 2   | GB896 - 76     | 开口挡圈<br>Split retaining ring                |
| 3   | 36T7 - 001A1   | 挠性驱动板<br>Flexible driving lever             |
| 4   | 36T7 - 001A2   | 驱动板螺钉<br>Screw                              |
| 5   | J0.0.16        | 驱动板螺母<br>Nut                                |
| 6   | 36T7 - 001A3   | 软线支撑板<br>Bracket for flexible wire          |
| 7   | 36T7 - 001A4   | 软线支撑板螺钉<br>Screw                            |
| 8   | 36T7 - 001A5   | 软线连板<br>Flexible wire connecting bracket    |
| 9   | 36T7 - 001A6   | 软线连板螺钉<br>Screw                             |
| 10  | 36T7 - 001A7   | 软线座<br>Holder for flexible wire             |
| 11  | 165710000      | 切线电磁铁组件<br>Solenoid assy for thraed trimmer |
| 12  | 36T7 - 001A8b  | 切线电磁铁架<br>Solenoid mounting bracket         |
| 13  | GB68 - 76      | 切线电磁铁螺钉<br>Screw                            |
| 14  | 36T7 - 002B1a1 | 刀架鞍座<br>Knife holding saddle                |
| 15  | 36T7 - 002B1a2 | 刀架(左)<br>knife base(left)                   |
| 16  | 120T7 - 001A1  | 刀架(左)<br>knife base(left)                   |
| 17  | 36T7 - 002B1a3 | 刀架垫圈<br>Washer                              |
| 18  | 36T7 - 002B1a4 | 刀架螺钉<br>Screw                               |
| 19  | 36T7 - 002B2   | 刀片(左)<br>Blade(left)                        |
| 20  | 120T7 - 001A2  | 刀片(左)<br>Blade                              |
| 21  | 36T7 - 002B3   | 刀片紧固螺钉<br>Set screw                         |

# KNIFE ACTUATING MECHANISM

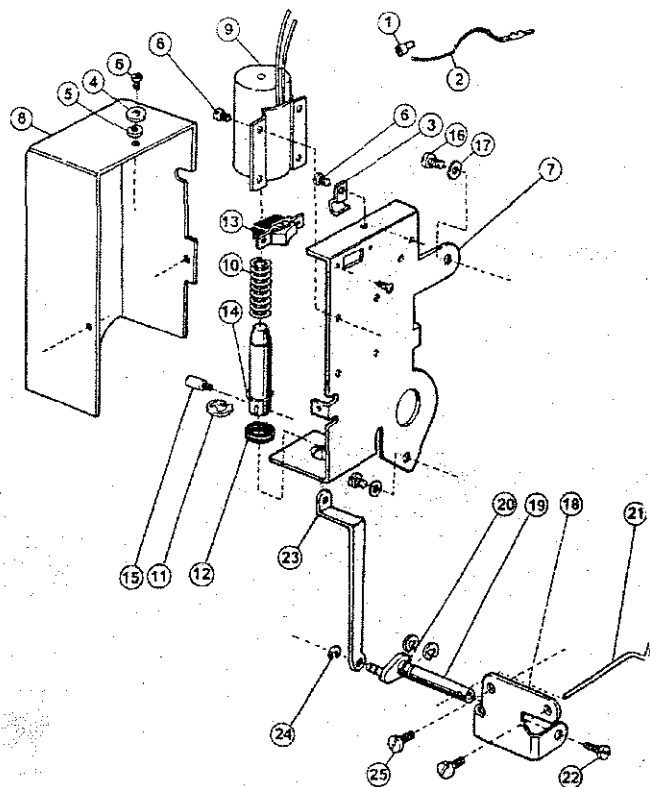
| No. | Part No.       | Description                          |
|-----|----------------|--------------------------------------|
| 20  | 36T7 -002B4    | 切刀驱动曲柄 Knife driving crank           |
| 21  | 61 -04 -01/B6  | 切刀驱动曲柄螺钉 Screw                       |
| 22  | 36T7 -002B5    | 刀轴连杆 Link                            |
| 23  | 36T7 -002B6    | 刀轴连杆螺钉 Screw                         |
| 24  | 36T7 -002B7    | 刀轴连杆螺母 Nut                           |
| 25  | 36T7 -003C1    | 凸轮曲柄(1) Cam follower crank(1)        |
| 26  | 36T7 -003C2    | 凸轮曲柄(2) Cam follower crank(2)        |
| 27  | 36T7 -003C3    | 滚柱轴 Roller stud                      |
| 28  | 36T7 -003C4    | 凸轮曲柄滚柱 Roller                        |
| 29  | 36T7 -003C5    | 滚柱螺母 Nut                             |
| 30  | 36T7 -004      | 切刀驱动轴 Knife driving shaft            |
|     | 120T7 -002     | 切刀驱动轴 Knife driving shaft            |
| 31  | 36T7 -005      | 驱动轴弹簧 Coil spring                    |
| 32  | 36T7 -006      | 扭簧端盖 Bushing                         |
| 33  | 165720004      | 限位块 Stopper                          |
| 34  | 165720001      | 限位板 Stopper plate                    |
| 35  | GB6172 -86 -M6 | 限位板螺母 Nut                            |
| 36  | 165720002      | 限位板螺钉 Screw                          |
| 37  | 36T7 -009E1    | 拦线板 Thread guide                     |
|     | 120T7 -003B1   | 拦线板 Thread guide                     |
| 38  | J0.0.72        | 拦线板螺钉 Screw                          |
| 39  | 36T7 -009E2    | 定刀片固定架 Bracket for fixed blade       |
| 40  | 36T7 -009E3    | 定刀片 Fixed knife                      |
|     | 120T7 -003B2   | 定刀片 Fixed knife                      |
| 41  | 36T7 -009E4    | 定刀片紧固螺钉 Set screw                    |
| 42  | 36T7 -009E5    | 定刀片调节螺钉 Adjusting screw              |
| 43  | 36T7 -009E6    | 定刀片调节螺母 Adjusting nut                |
| 44  | 36T8 -002      | 限位板固定螺钉 Screw                        |
| 45  | 36T7 -010F     | 软线组件 Flexible wire asm               |
| 46  | 36T7 -011G     | 接地线组件 Earth wire asm                 |
| 47  |                | 插头 Plug                              |
| 48  | 36T7 -013      | 橡皮套 Rubber sleeve                    |
| 49  | 36T7 -014      | 导线夹头 Wire clamp                      |
| 50  | GB848 -76      | 垫圈 Washer                            |
| 51  | GB54 -76       | 软线螺母 Nut                             |
| 52  | 22T2 -019      | 螺钉 4.37 x 40/8 Screw 4.37 x 40/8     |
| 53  | 36T8 -002      | 切线电磁铁架固定螺钉 Screw                     |
| 54  | 22T5 -010D4    | 螺钉 Screw                             |
| 55  | 36T9 -001A2a2  | 凸型插针 Pin                             |
| 56  | 36T7 -001A9    | 挠性驱动板扭簧 Coil spring                  |
| 57  | 36T7 -001A10   | 驱动板紧圈 Collar for driving lever       |
| 58  | 36T5 -008E8    | 驱动板紧圈螺钉 Screw                        |
| 59  | 36T7 -015H1    | 驱动轴紧圈 Collar for knife driving shaft |
| 60  | 22T3 -002B1    | 驱动轴紧圈螺钉 Screw                        |
| 61  | 36T7 -016      | 驱动轴扭簧 Coil spring                    |
| 62  | 36T7 -017      | 插头护套 Guard for plug                  |
| 63  | 165720003      | 缓冲垫 Rubber washer                    |



## REVERSE SEWING MECHANISM

| No. | Part No.     | Description |                                     |
|-----|--------------|-------------|-------------------------------------|
| 1   | 001D3 -001A  | 检测器组件       | Detector componts                   |
| 2   | 36T7 -014    | 橡皮套         | Rubber plug                         |
| 3   | 22T2 -019    | 螺钉          | Screw                               |
| 4   | 22T1 -006    | 后盖板螺钉       | Screw                               |
| 5   | 22T1 -007    | 后盖板螺钉垫片     | Washer                              |
| 6   |              | 检测器压板       | Detector presser plate              |
| 7   | GB896 -76    | 开口挡圈 4      | Split washer 4                      |
| 8   | 36T8 -009    | 倒缝电磁铁销      | Pin                                 |
| 9   | 165820002    | 倒缝电磁铁       | Electric -magnet for reverse sewing |
| 10  | GB97.1 -85   | 垫圈          | Washer                              |
| 11  | GB859 -87    | 弹簧垫圈        | Spring washer 3                     |
| 12  | 36T8 -005    | 总线夹         | Cord holder                         |
| 13  | 36T8 -006    | 电线夹         | Wire clamp                          |
| 14  | 36T8 -007C1  | 开关安装架       | Switch bracket                      |
| 15  | 36T8 -007C2a | 按钮组件        | Button asm                          |
| 16  | 36T8 -007C3b | 倒缝开关组件      | Cable for switch at reverse sewing  |
| 17  | GB859 -76    | 弹簧垫圈 2      | Spring washer 2                     |
| 18  | GB848 -76    | 垫圈 2        | Washer 2                            |
| 19  | GB818 -85    | 微动开关螺钉      | Screw                               |
| 20  | 36T8 -007C4  | 微动开关        | Micro switch                        |
| 21  | GB66 -76     | 片簧螺钉        | Screw                               |
| 22  | 36T8 -007C5  | 片簧          | Leaf spring                         |
| 23  | GB896 -76    | 开口挡圈 3      | Split retaining ring 3              |
| 24  | 36T8 -007C6  | 开口弹簧        | Coil spring                         |
| 26  | 36T8 -008E1  | 后盖板密封垫片     | Gasket                              |
| 27  | 165820001    | 后盖板         | Side cover                          |
| 28  |              | 螺钉          | Screw                               |
| 29  | 165320001    | 主动轮配件       | Balance wheel asm                   |

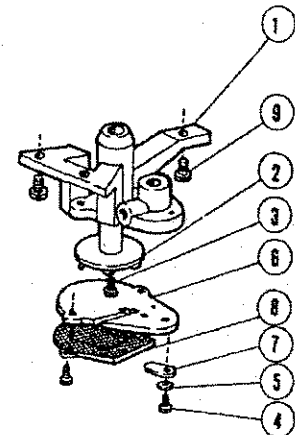
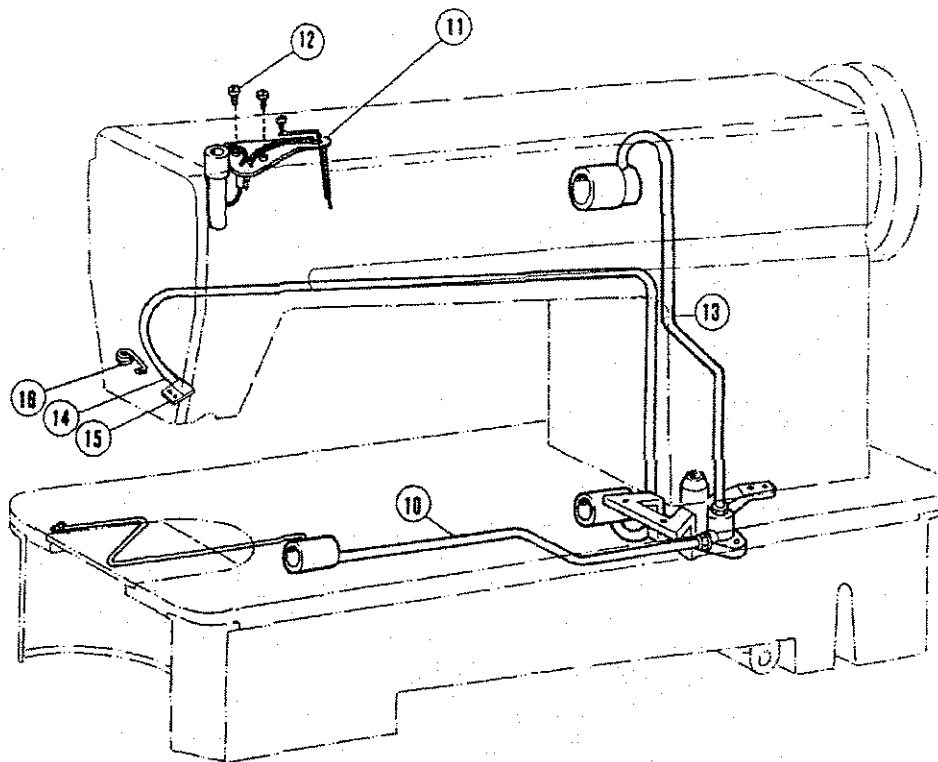




## WIPER MECHANISM

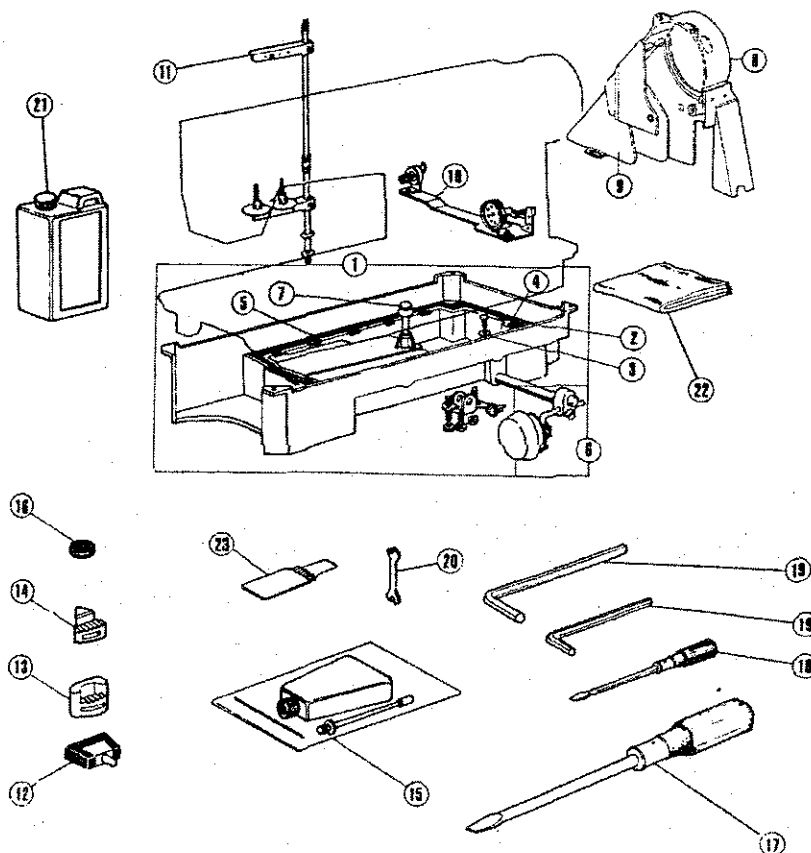
| No. | Part No.     | Description                 |
|-----|--------------|-----------------------------|
| 1   | 36T9 -001A1  | 电线接头 Wire connector         |
| 2   | 36T9 -001A2a | 挡线电磁铁导线组件 Wire              |
| 3   | 36T9 -001A3  | 线夹 Cord clamp               |
| 4   | GB848 -76    | 螺钉垫圈 Washer                 |
| 5   | GB859 -76    | 弹簧垫圈 Washer                 |
| 6   | GB818 -76    | 磁铁盖螺钉 Screw                 |
| 7   | 36T9 -001A4  | 电磁铁安装架 Solenoid bracket     |
| 8   | 36T9 -001A5  | 挡线电磁铁盖 Cover for wiper mech |
| 9   | 36T9 -001A6  | 挡线电磁铁 Solenoid for wiper    |
| 10  | 36T9 -001A7  | 螺旋弹簧 Coil spring            |
| 11  | GB896 -76    | 挡圈 Retaining ring           |
| 12  | 36T9 -001A8  | 橡皮圈 Rubber ring             |
| 13  | 36T9 -001A9  | 挡线开关 Switch for wiper       |
| 14  | 36T9 -001A10 | 垫圈 Washer                   |
| 15  | 36T9 -002    | 衔铁螺钉 Screw                  |
| 16  | 22T5 -001A4  | 安装架螺钉 Screw                 |
| 17  | 36T9 -003    | 安装架螺钉垫圈 Washer              |
| 18  | 36T9 -004B1  | 挡线轴安装架 Wiper bracket        |
| 19  | 36T9 -004B2a | 挡线摆动轴组件 Wiper shaft asm     |
| 20  | G896 -76     | 挡圈 Retaining ring4          |
| 21  | 36T9 -004B3  | 挡线勾 Wiper                   |
| 22  | 22T6 -001A4  | 紧固螺钉 Screw                  |
| 23  | 36T9 -004B4  | 挡线连杆 Link                   |
| 24  | GB896 -76    | 挡圈 Retaining ring           |
| 25  | 36T9 -005    | 挡线轴安装架螺钉 Screw              |





## OIL PUMP MECHANISM

| No. | Part No.    | Description                             |
|-----|-------------|-----------------------------------------|
| 1   | 22T8 -001   | 油泵体 Oil pump                            |
| 2   | 22T8 -002   | 油泵叶轮 Oil pump impeller                  |
| 3   | 22T8 -003   | 油泵叶轮螺钉 Screw                            |
| 4   | 22T8 -004   | 油泵调节板螺钉 Screw                           |
| 5   | 22T8 -005   | 油泵调节板螺钉弹簧垫圈 Springee washer             |
| 6   | 22T8 -006   | 油泵体盖板 Oil pump fitting plate            |
| 7   | 22T8 -007   | 油量调节板 Oil adjusting plate               |
| 8   | 22T8 -008A  | 油泵滤网组件 Oil pump screen asm              |
| 9   | 22T8 -009   | 油泵体螺钉 Screw                             |
| 10  | 36T10 -001A | 下轴油管组件 Oil pump for hook shaft          |
| 11  | 22T8 -011C  | 油线固定板大组件 Oil braid fitting plate        |
| 12  | 22T8 -012   | 油线固定板螺钉 Screw                           |
| 13  | 22T8 -013D  | 上轴油管组件 Oil pump for arm shaft           |
| 14  | 22T8 -014   | 回油管 Oil return pipe                     |
| 15  | 22T8 -015   | 回油管滤油毡 Felt pouch for return oil filter |
| 16  | 36T10 -002  | 回油管夹 Oil filter holder                  |



## OIL RESERVOIR & ACCESSORIES

| No. | Part No.    | Description                             |
|-----|-------------|-----------------------------------------|
| 1   | 36T11 -001A | 油盘组件<br>Oil reservoir asm               |
| 2   | 22T9 -001A2 | 放油螺钉<br>Screw                           |
| 3   | 22T9 -001A3 | 放油螺钉垫圈<br>Washer                        |
| 14  | 22T9 -001A4 | 油盘垫(小)<br>Oil gasket (S)                |
| 5   | 22T9 -001A5 | 油盘垫(大)<br>Oil gasket (B)                |
| 6   | 22T9 -003B  | 膝控碰块组件<br>Knee lifter asm               |
| 7   | 22T9 -003B1 | 膝控提升顶杆<br>knee lifter lifting pin       |
| 8   | 124T9 -003B | 皮带罩组件<br>Belt cover                     |
| 9   | 124T9 -004C | 小皮带罩组件<br>Belt cover (S)                |
| 10  | 6F0         | 绕线器组件<br>Thread winder asm (large hook) |
| 11  | GXJ -2      | 线架组件<br>Thread spool asm                |
| 12  | 22T9 -007F  | 机壳铰链组件<br>Hinge with rubber cushion     |
| 13  | 22T9 -009   | 机头防震垫块(大)<br>Cushion (B)                |
| 14  | 22T9 -010   | 机头防震垫块(小)<br>Cushion (S)                |
| 15  | 22T9 -011   | 小油壶<br>Oil pot                          |
| 16  | 22T9 -012   | 碰块<br>Magnet block                      |
| 17  | 22T9 -013   | 螺钉起子(长)<br>Screw drive (long)           |
| 18  | 22T9 -015   | 螺钉起子(短)<br>Screw drive (short)          |
| 19  | 36T11 -006  | 内六角扳手 M4 M6<br>Allen wrench M4 M6       |
| 20  | 22T9 -016   | 双头扳手<br>Double open - end wrench        |
| 21  | 22T9 -017   | 油箱<br>Oil tank                          |
| 22  | 22T9 -018   | 机罩<br>Machine head cover                |
| 23  | 22T9 -024   | 机针袋<br>Needle bag                       |

# **Consolidated Sewing Machine Corp.**

**Website: [www.consew.com](http://www.consew.com)**

## **MAIN office**

131 W. 25th Street  
New York, NY 10001  
Tel: 212-741-7788  
Fax: 212-741-7787  
e-mail: [consew@att.net](mailto:consew@att.net)

## **Miami, FL**

4013 N.W. 79th Avenue  
Miami, FL 33166  
Tel: 305-471-0200  
Fax: 305-471-0243  
e-mail: [miamisales@consew.com](mailto:miamisales@consew.com)

## **Los Angeles, CA**

2320 South Hill Street  
Los Angeles, CA 90007  
Tel: 213-745-8844  
Fax: 213-745-8855  
e-mail: [lasales@consew.com](mailto:lasales@consew.com)