



ZJOE
中捷

ZJ1850系列加固缝纫机

**ZJ1850 SERIES TACKING INDUSTRIAL SEWING
MACHINE**

使用说明书
OPERATION MANUAL

零件手册
PARTS BOOK

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

From the library of: Superior Sewing Machine & Supply LLC

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PARTS LIST

加固缝纫机

Tacking Industrial Sewing Machine

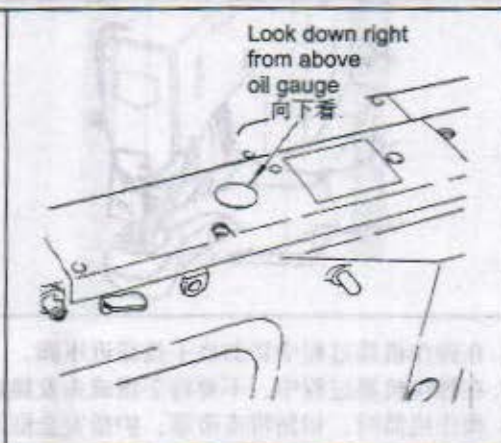
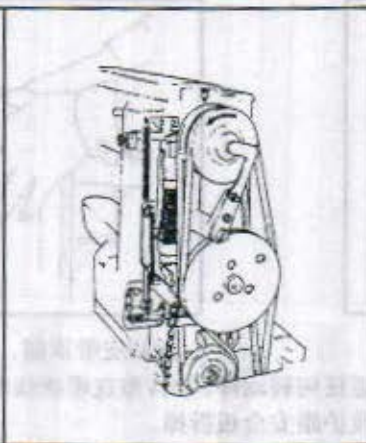
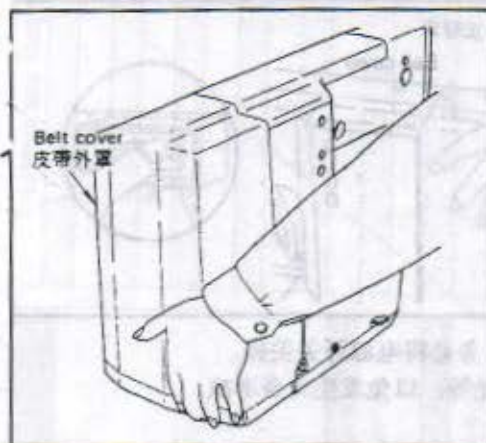
使用说明书

INSTRUCTION MANUAL

为使机器使用良好及获得较长的寿命，请在使用前认真阅读使用说明书。

Thank you for buying a sewing machine. Please read this Instruction Manual carefully before using this unit order to get the most out of it and to enjoy using it for a long time.

操作前注意事项 CAUTIONS BEFORE OPERATION



1. 搬动机器时切勿搬动皮带罩。

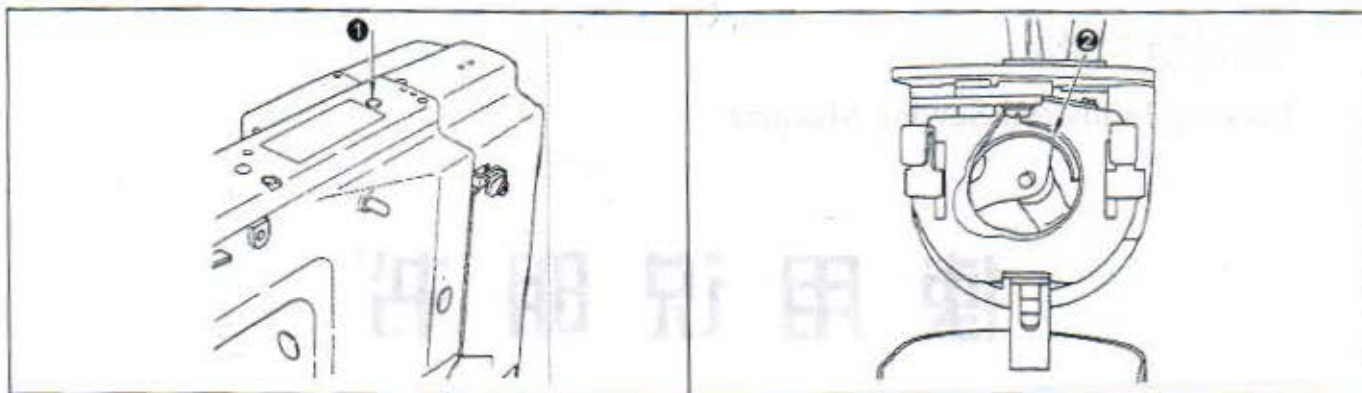
1. Do not hold the belt cover when carrying the sewing machine.

2. 机器上轴转动方向为箭头方向，不得反向。

2. The sewing machine should run in the arrowed direction. Never allow the machine to run in the reverse direction.

3. 观察图中油标处是否有红色标记，如果有则要根据后面“九、机器的润滑”栏中所述进行加油。

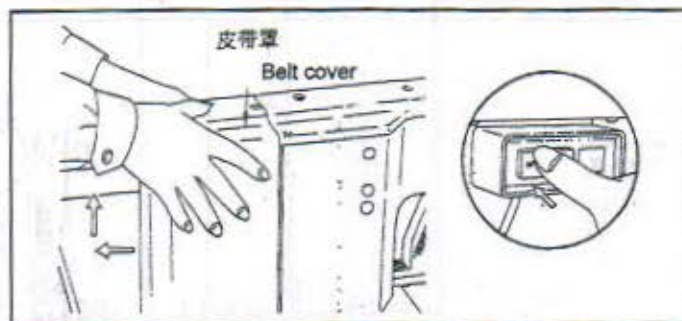
3. If the red color is observed in the oil gauge when looking down from just above the oil gauge, supply the lubrication oil according to "9. Lubrication".



4. 在新的或放置已久的机器起初前，要通过油孔①向上轴部件加几滴润滑油，再向梭道表面②加一滴油。

4. Before starting a machine which has been newly set up or has not been used for a long period of time, apply a few drops of the lubricating oil to main shaft components through hole ①, one drop to the racing surface ② of the shuttle race.

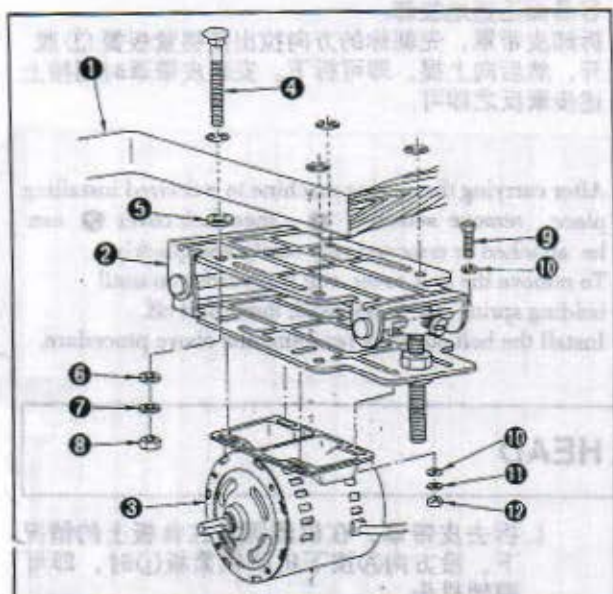
操作中的注意事项 CAUTIONS IN OPERATION



1. 在操作机器过程中切勿将手指靠近压脚。
2. 拆卸皮带罩前，务必将电源开关关掉。
3. 在操作机器过程中，不要将手指或头发接近任何转动件，如V型皮带绕线轮等。以免发生人身事故。
4. 操作机器时，切勿将皮带罩，护指安全框及护眼安全板拆掉。

1. Do not place your fingers near the work clamp foot while the machine is in operation
2. Make sure to turn off the power switch before removing the belt cover.
3. Never bring your fingers or hair close to, or place any-thing on the handwheel, V-belt, bobbin winder wheel or motor during operation, it may lead to serious personal injuries.
4. If your machine is provided with a belt cover, finger guard and eye guard, neve operate your machine with any of them removed.

一、电机的安装 INSTALLING THE MOTOR



1. 按图示用螺栓④、防震橡胶垫⑤、垫圈⑥、弹簧垫圈⑦以及螺母⑧将电机座②固定在台板①上。
2. 用螺栓⑨垫圈⑩ 弹簧垫圈⑪ 和螺母⑫,再将电机③固定在电机座②上。

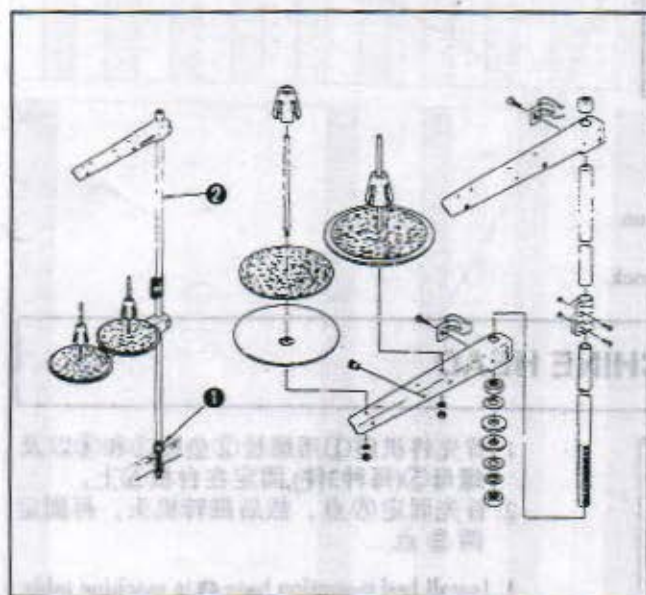
注: 安装时切记, 以电机轴 ⑬ 为参照, 确认电机座②方向, 可同时参见《零件目录》P₂₁图。

1. Attach motor base ② to table ① using bolt ④, vibration-proof rubber pad ⑤, washer ⑥, spring washer ⑦, and nut ⑧.
2. Using bolt ⑨, washer ⑩, spring washer ⑪, and nut ⑫, install motor ③ to motor base ②.

Note:

When installing, please determine the direction of the motor base ② comparing with the shaft of motor ⑬ you can also see the figure of "Parts List" page 21.

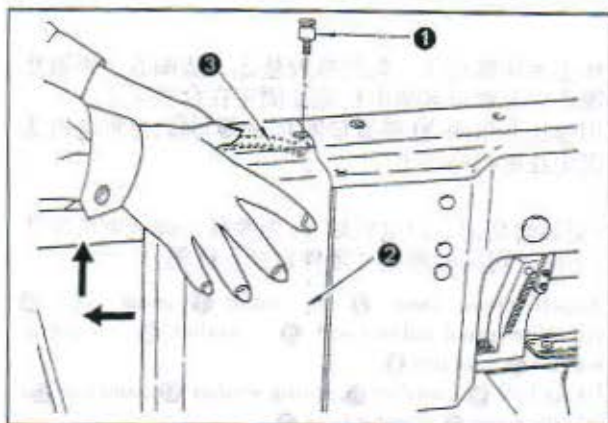
二、线架的安装 INSTALLING THE THREAD STAND



先将线架组装起来, 然后将它固定在台板上。
拧紧螺母①以固定线架。如果没有吊式电线, 则可将电源线通过线架杆空心穿过。

1. Assemble the thread stand, and set it in the hole in the table.
2. Tighten nut ① to fix the thread stand.
If ceiling wiring is made, pass the power cord through spool rest rod ②.

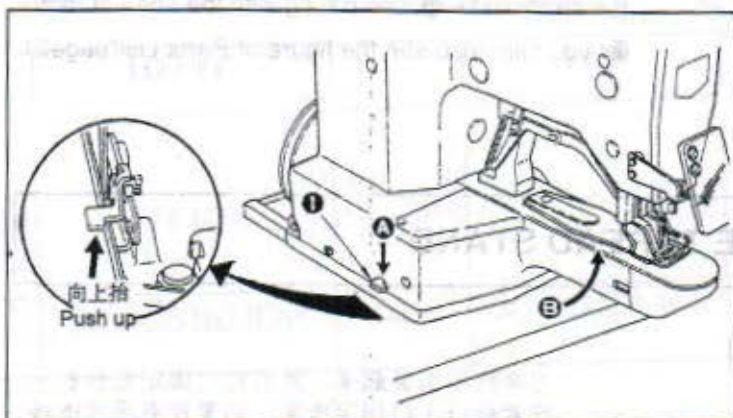
三、拆卸皮带罩 REMOVING THE BELT COVER



1. 将机器放在安装位置后，拧去螺钉①，皮带罩即可容易而迅速地装卸。
2. 拆卸皮带罩，先朝你的方向拉出使锁紧板簧③脱开，然后向上提，即可拆下。安装皮带罩时则按上述步骤反之即可。

1. After carrying the sewing machine to a desired installing place, remove setscrew ①, then belt cover ② can be attached or removed very easily and quickly.
 2. To remove the belt cover, pull it towards you until holding spring ③ is released, then lift it off.
- ★ Install the belt cover by reversing the above procedure.

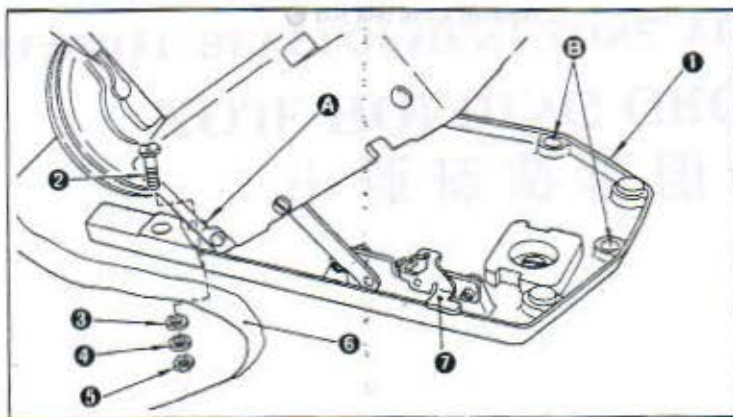
四、机头的翻转 RAISING THE MACHINE HEAD



1. 拆去皮带罩，在机器固定在台板上的情况下，沿方向④按下机头锁紧板①时，即可翻转机头。
2. 放开机头锁紧板，然后继续延方向⑤翻转机头直到锁紧为止。
若要放下机头则可抬起机头锁紧板即可放下机头。

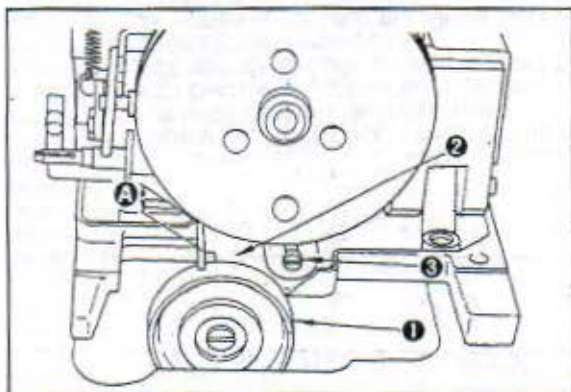
1. Remove the belt cover. With the machine head set in its installing position on the machine table, raise the machine head in direction B while pushing down (in direction A) bed locker ①.
 2. Releasing the bed locker, further raise the machine head in direction B until it locks.
- ★ To lower the machine head, push up the bed locker to release the lock.

五、机头的安装 INSTALLING THE MACHINE HEAD



1. 首先将机座①用螺栓②垫圈③和④以及螺母⑤(每种3件),固定在台板⑥上。
 2. 首先固定④点，然后翻转机头，再固定两③点
1. Install bed mounting base ① to machine table ⑥ using bolts ②, flat washers ③ and ④, and nuts ⑤ (each 3 pcs.)
 2. Fix point A before raising the machine head. Then fix two points B

六、安装空转皮带轮 ATTACHING THE IDLER PULLEY



由螺钉③将涨紧轮①固定在固定板②上。
(注)：将A外空间调至刚刚可使V形皮带通过为好。

Fix idler pulley ① to mountins plate by ② setscrew ③ .
(Note) Adjust the clearance at A to just allow the V belt to pass it through.

七、电机皮带轮及皮带的选择和安装 MOTOR PULLEYS AND BELTS

(一) 选择 Choose

1. 该型机器使用O型三角皮带。
2. 该机使用两条V形皮带，一个是高速皮带，一个是低速皮带。
3. 下面表格所列为各种电机皮带轮，V形皮带以及缝速间的关系参数。

1. M-type V belts are used for this model of sewing machine.
2. This sewing machine uses two V belts, one for high-speed sewing, and the other for low-speed swewing.
3. The tabe below shows the relation between the motor pulleys, V belts ,and sewing speeds.

频率 Frequency	缝速针/分 Sewing speed	电机皮带轮图号 分 Motor pulley part No.	打印标记 Engarved mark	高速 V 形皮带 High-speed V belt	低速 V 形皮带 Low-speed V belt
50Hz	2300	*90-01-018	50-2300	90-011-023(50")	90-011-029 (46")
	2000	*90-011-014	50-2000	90-011-024(49")	
	1800	*90-011-019	50-1800	90-011-025(48")	
60Hz	2300	*90-011-020	60-2300	90-011-026(49")	90-011-029 (46")
	2000	*90-011-021	60-2000	90-011-027(48")	
	1800	*90-011-022	60-1800	90-011-028(47")	

注:带*号和电机皮带轮仅用于使用棉线的机器，请订购使用棉线的电机皮带轮。

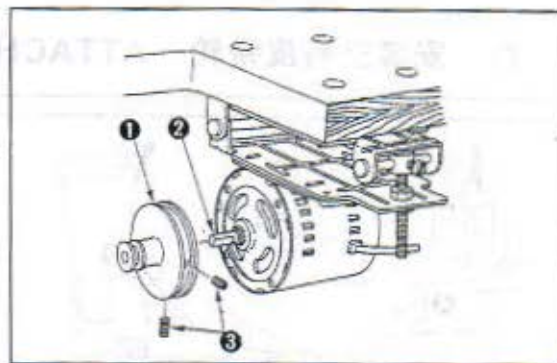
Note: The motor pulleys marked with asterisks are applicable only to cotton thread. Please order the motor pulleys for threads other than cotton thread.

(二) 安装

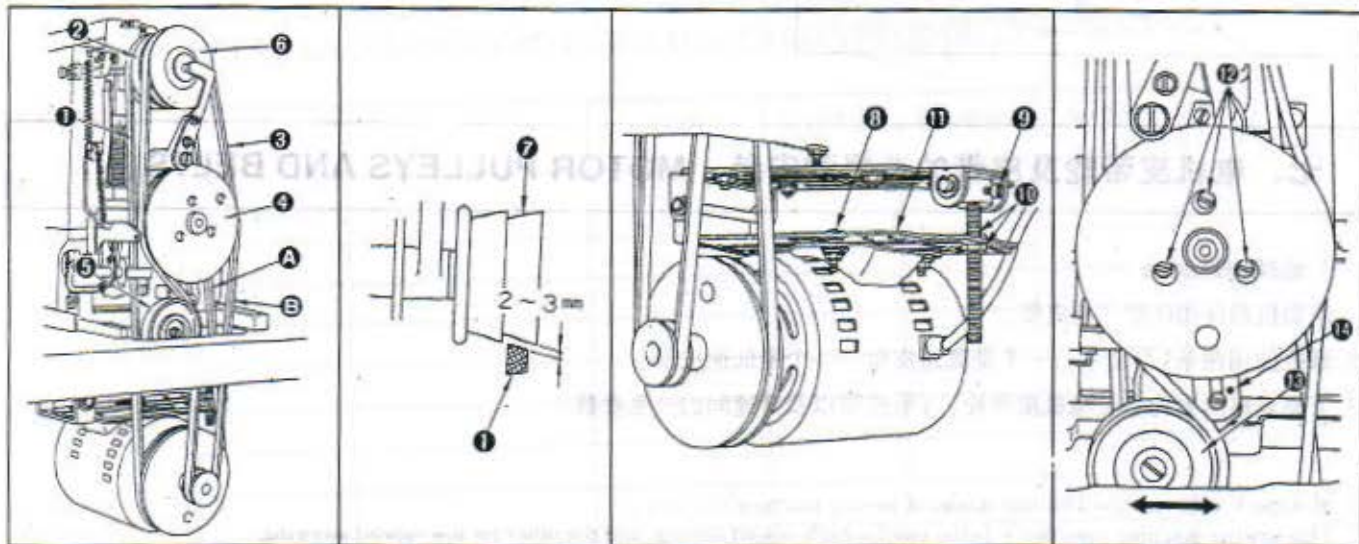
* 安装电机皮带轮 Installing the motor pulley

首先将电机皮带轮①装在电机轴②上,使一个螺钉③固定在电机轴的平面上,然后将另一个螺钉③固定即可。

Set motor pulley ① onto motor shaft ② so that one of two setscrews ③ meets the flat part of the motor shaft. Then tighten setscrews ③



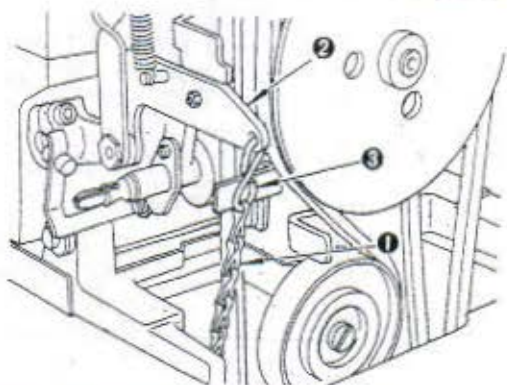
* 安装电机皮带 Attaching the belts



- (1) 将高速V形皮带①装在高速皮带轮②和大直径的电机皮带轮上。
- (2) 将低速V形皮带装在低速皮带轮⑥上,并通过减压轮④和涨紧轮⑤装在小直径的电机皮带轮上。
- (3) 将电机皮带轮前后移动至使高速V形皮带①和绕线轮⑦之间的距离为2~3mm为止。
- (4) 松开螺钉⑧并左右移动电机以使在绕线时高速V形皮带均匀地与绕线轮保持接触。(参见十五、梭芯的绕线)
- (5) 松开螺钉⑨通过螺母⑩进行调整上下移动电机⑪,使得当您在高速V形皮带中部①处,互相压动时可有10mm的压动量。
- (6) 松开螺钉⑫,并且沿箭头方向移动涨紧轮⑬,以便当您在低速V形皮带中部处相互压动时可有10mm的动量。(在安装涨紧轮时,要使其紧固螺钉与固定板上的标记列)⑭

1. Set high-speed V belt ① on the large diameters of high-speed pulley ② and the motor pulley.
2. Set low-speed V belt ③ on the small diameters of lowspeed pulley ⑥ and the motor pulley through pressure decreasing pulley ④ and idler pulley ⑤.
3. Move the motor pulley back or forth to provide a 2 to 3mm clearance between high-speed V belt ① and bobbin winder wheel ⑦.
4. Loosen setscrew ⑧, and move the motor to the right or left to make adjustment so that the high-speed V belt comes evenly in contact with the bobbin winder wheel when the bobbin winder is used (refer to "15. winding a bobbin").
5. Loosen setscrew ⑨, and move motor base ⑪ up or down by adjusting nut ⑩ to perform adjustment so that the high-speed V belt slacks about 10mm when you push the belt at middle ①.
6. Loosen setscrew ⑫, and move idler pulley ⑬ in the arrowed direction to perform adjustment so that the low-speed V belt slacks about 10mm when you push the belt at middle ③, (At this time, set the idler pulley so that it is aligned with engraved marker dot ⑭ on the installing plate.)

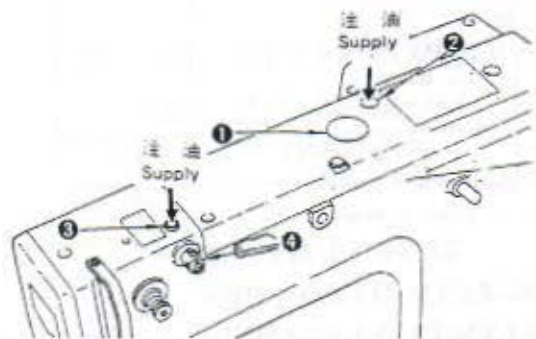
八、安装锁链 ATTACHING THE CHAIN



将S型链勾③挂打起动杆②上，然后再将链条①挂在S型链勾上。

Hook S-shaped hook ③ into the hole in the tip of starting lever ②, and attach chain ① to the S-shaped hook.

九、润滑 LUBRICATION



每天要润滑一次机器，可通过润滑油孔②加油观察油标①，直到油标中的红标记消失为止。使用润滑油采用缝纫机专用油。

1. Lubricate the machine once everyday. Supply the lubricating oil through lubricating hole ② until the red color in oil gauge ① completely disappears as observed from right above the oil gauge.
2. Use oil for sewing machine.

使用合成纤维线或化纤布料时注意：

要向油孔③加入硅油，这时检查一下已穿过过线勾④的线上面，是否有硅油。

★ When using the thread guide a synthetic fiber thread and cloth

Supply silicone oil through silicone oil lubricating hole ③ when using thread guide ④ for a synthetic fiber thread

At this time, check that the thread which has passed through thread guide ④ has the silicone oil on it.

十、机器的操作 OPERATING THE SEWING MACHINE

操作机器程序如下：

1. 打开电源开关。
2. 稍微踏下起动踏板，压脚好落下，如果您想使压脚再抬起，则放开踏板即可。
3. 再继续踏动起动踏板，则机器即开始打结，这时应马上放开脚踏板。
4. 当机器完成一个加固结缝纫时，线即被自动剪断，压脚自动抬起。

Operate the sewing machine in the following procedure:

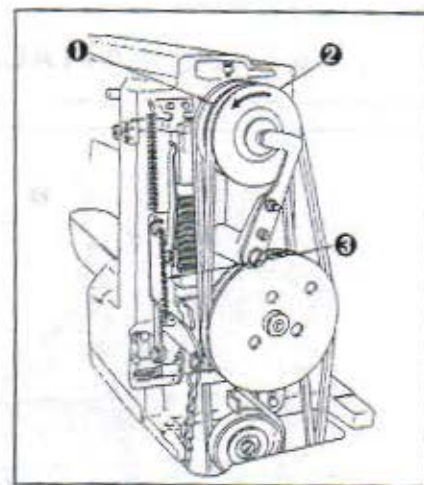
1. Turn on the power switch.
2. Depress the starting pedal a little, and the work clamp foot will come down. When you want to make the work clamp foot go up, release the pedal.
3. Further depress the pedal, and the sewing machine starts bar-tacking. Immediately after the sewing machine starts bartacking, release the pedal.
4. When the machine has completed the specified bar-tacking cycle, the work clamp foot will automatically go up, and the needle and bobbin threads are trimmed before the machine stops.

(注意)

1. 当机器开始打结时要尽快地释放起脚踏板，否则机器就不会在预定的位置上停下来。
2. 如果你不完全释放踏板，则机器将可能停在第一针处，这时可以再完全地踏下踏板以进行缝纫。
3. 如果完全踏下踏板，机器仍不起动，则关上开关，取下皮带罩，然后以低速皮带轮②的箭头方向转动转速轮①（带滚花纹）。
4. 该机器在较寒冷的早晨可能运转得不灵活，这是因为机器使用的润滑油所致，在这种情况下，可在工作前空转5-6次即可。

手动操作机器：

关掉开关，取下弹簧③的上端，沿箭头方向使低速皮带转两圈，压脚即落下，然后踏下起脚踏板，这时机器即可手动操作。



- (Cautions)
1. Be sure to release the pedal as soon as the machine starts bar-tacking, or else the machine will not stop at the predetermined point.
 2. If you fail to depress the pedal sufficiently, the machine may stop at the first stitch. In this case, depress the pedal again sufficiently.
 3. If the machine will not start even when you depress it strong enough, turn off the power switch. And remove the belt cover. Then turn changeover pulley ① (Knurled part) in the arrowed direction of low-speed pulley ②.
 4. This sewing machine may run rather unsmoothly on a cold morning because it uses grease for the lubrication of several parts. In such a case, allow the machine to idle for 5 or 6 times before starting the work.

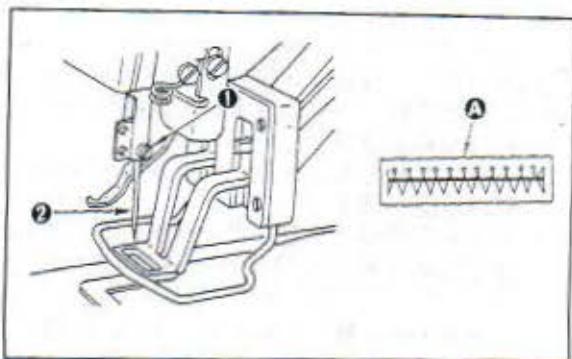
★ To operate the sewing machine manually;

Turn off the power switch, remove the upper end of spring ③, give low-speed pulley two ② turns in the arrowed direction and the work clamp foot will come down. Then depress the starting pedal, and the machine can be run manually.

十一、面料及机针的选用 MATERIALS AND NEEDLES TO BE USED

面料 Material	机针 Needle	小针板 Needle plate needle hole guide	产品种类 Class of work
合成纤维料 Synthetic fiber material	#4(DP5,高级) #14(DP 5, SUPER needle)	90-03-013	男西装、女装 Men's suits, ladies'wear
中厚料 Medium-weight material	#16(DP × 5)	90-03-013	男西装、女装 Men's suits, ladies'wear
厚料 Heavy-weight material	#18(DP × 5)	90-03-013 90-03-014	工作服、女装 Working wear, over coats
薄料 Thin material	#14(DP × 5)	90-03-013	雨伞 Umbrella

十二、机针的安装 ATTACHING THE NEEDLE



松开螺钉①，将机针②完全插入针杆孔中，并使机针长槽面向操作者，然后拧紧螺钉①即可。

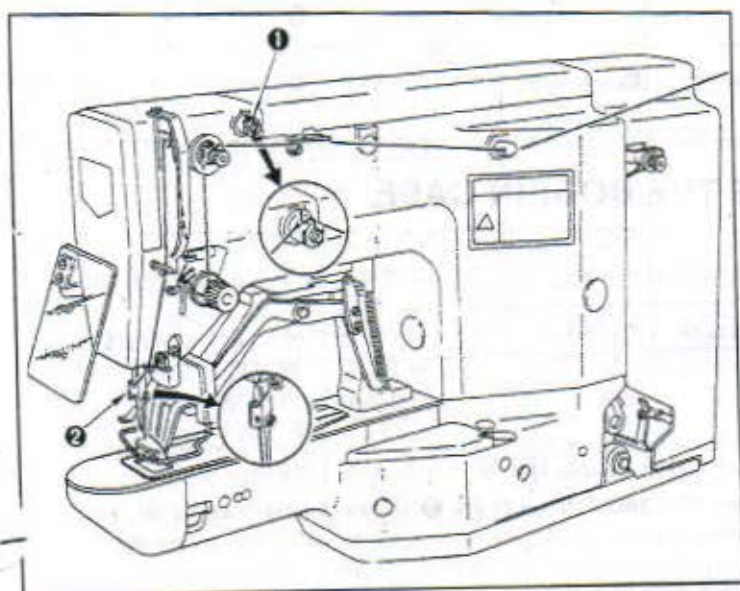
(注): 1.如果打结出现图中所示② 则可将机针销向左转一下。2.缝制合成纤维布料时，用合成纤维线，并且使用特别好的机针。

Loosening setscrew ①, insert needle ② fully into the needle bar hole with the long groove of the needle facing towards you, then tighten setscrew ①

(Note) 1. If the bar-tacking stitches as ② shown

above are produced. Install the needle so that it slightly faces to the left. 2. Use a SUPER needle for synthetic fiber when sewing with synthetic fiber thread or material.

十三、穿线 THREADING THE MACHINE



穿针方法如图所示，最后留在机针上的线头大约4厘米。

(注)1. 用合成纤维线时(使用硅油)要把线通过硅油润滑的过线勾①。

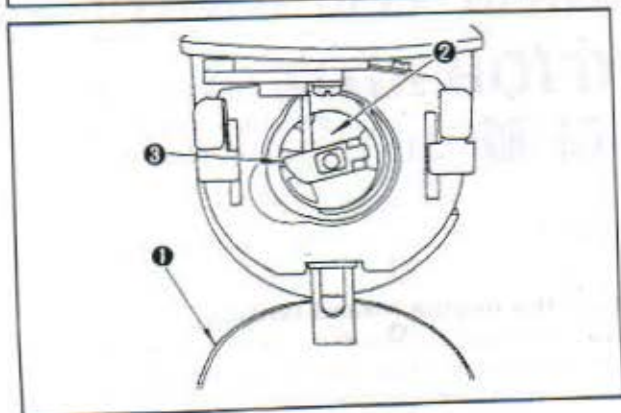
2. 用细线时，只须穿过针杆导线板②上一个孔即可。

Thread the machine in the order as shown above. Leave thread of approx. 4cm on the needle.

(Note) 1. For a synthetic fiber thread (silicone oil is used), pass the thread also through silicone lubricant thread guide ①.

2. For a thick thread, pass the thread through only one of the two holes in needle bar thread guide ②.

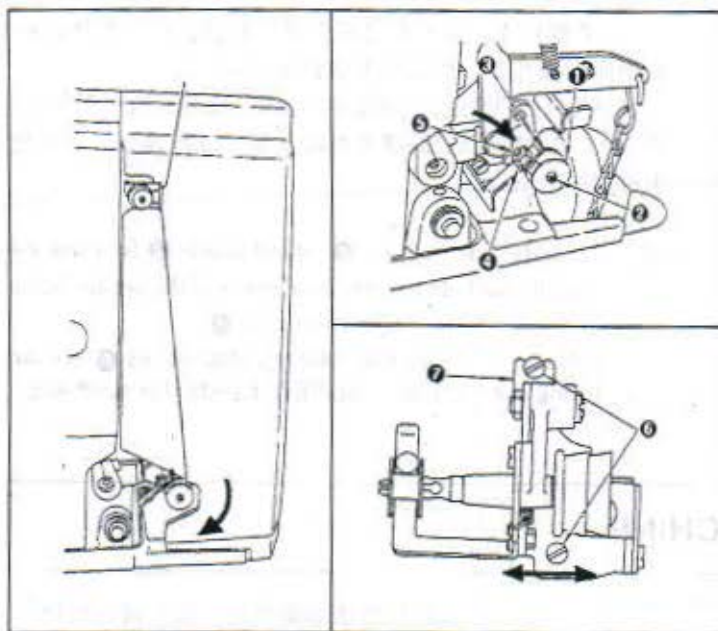
十四、装卸梭芯套 REMOVING AND INSTALLING THE BOBBIN CASE



1. 打开罩盖①。
2. 抬起梭芯套②的梭门盖③即可取出。
3. 要将梭芯套装入梭床时，先将梭芯套装入摆梭轴，然后按紧梭门盖即可听到到位的声音。

1. Open cylinder arm cap ①.
2. Raise and hold the latch lever of bobbin case ② to take it out. The bobbin in the bobbin case does not fall as far as latch lever ③ is raised and held.
3. To load the bobbin case into the shuttle, fit it onto the shaft of the shuttle and snap in the latch lever of the bobbin case.

十五、梭芯的绕线 WINDING A BOBBIN

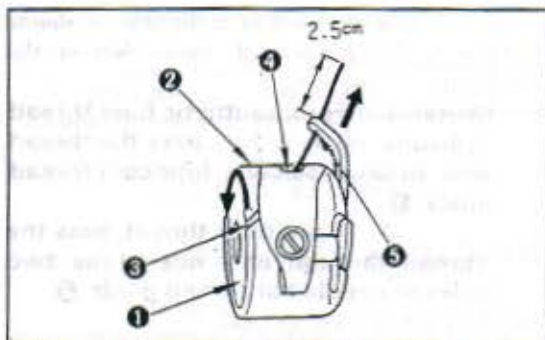


1. 将梭芯①装在绕线轴②上。
2. 将线按图所示绕在梭芯上4-5圈。
3. 将绕线行程板③压向梭芯, (如图箭头方向), 即开始绕线, 待梭芯绕满 (梭芯容量的80%) 即自动停止绕线。
4. 若要调节梭芯的绕线量, 可松开螺母④和螺钉轴⑤进行调节。
5. 如果梭芯绕线不平整, 可松开螺钉⑥, 并移动绕线固定板⑦(沿箭头方向) 进行调整即可。

1. Attach bobbin ① to bobbin winder spindle ②.
2. Thread the winder in the order as illustrated and wind the thread onto the bobbin four or five turns.
3. Push bobbin winder trip latch ③ towards the bobbin (in the arrowed direction), and the winder starts to wind the bobbin. The winder will automatically amount (80% of the capacity of the bobbin)
4. To adjust the amount of thread wound round the bobbin, loosen nut ④ and screw in adjusting screw ⑤ to decrease the thread amount.

5. If the thread is not wound evenly round the bobbin, loosen screw ⑥ and move bobbin winder base ⑦ in the arrowed direction to make adjustment.

十六、梭芯套的穿线 THREADING THE BOBBIN CASE

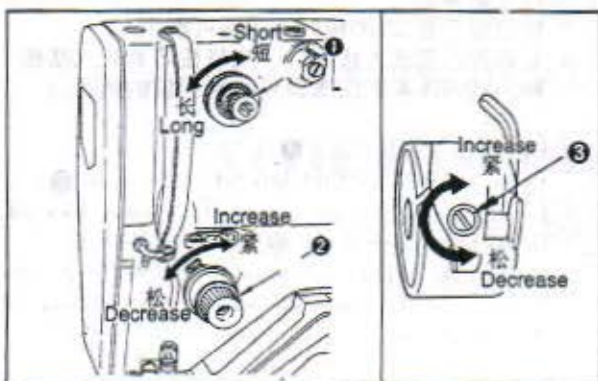


1. 将梭芯①装入梭芯套②中, 并使梭芯绕线方向为逆时针方向。
2. 将线通过槽口③, 并使其经过弹簧片下面, 通过线出口④, 这时拉线, 梭芯转动方向应为逆时针, 即图所示方向。
3. 然后, 再将线穿穿孔⑤, 并使线头保留约2.5厘米即可。

1. Hold bobbin ① in hand so that it spins counter-clockwise and set it in bobbin case ②.
2. Pass the thread through slot ③ in the bobbin case. Pull the thread to pass it under the tension spring out to thread exit ④. At this time confirm that the bobbin spins in the arrowed direction when the thread is pulled.

3. Pass the thread through hole, and allow the thread to trail about 2.5mm from the hole.

十七、线的松紧调整 THREAD TENSION



* 机针线松紧的调整

将1号压线器①沿顺时针方向旋转时, 在剪线后留在机针上的线头量就会减短, 反之则增长, 最小留线量以针线不得滑出机针为原则。当2号压线器②沿顺时针旋转时, 机针处的张力增加, 反之减少。

* 梭芯线松紧的调整

旋转调节螺钉③沿顺时针方向, 梭芯线的张力增加, 反之减少。

Adjusting the needle thread tension

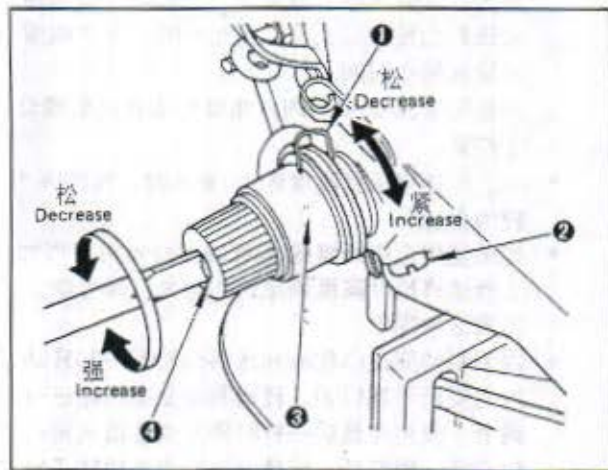
As thread tension controller No.1 ① turned clockwise, the length of the thread remaining on the needle after thread trimming will decrease, and vice versa. Minimize the length of the thread remaining on the needle as far as the thread does not slip off the

needle. As thread tension controller No.2 ② is turned clockwise the needle thread tension increases, and vice versa.

★ Adjusting the bobbin thread tension

Turning thread tension adjusting screw ③ clockwise will increase the bobbin thread tension, and vice versa.

十八、挑线簧的调整 ADJUSTING THE THREAD TAKE-UP SPRING



通常挑线簧行程为6-8毫米，且其初始张力为30-50克。

*行程的调整

松开螺钉②，旋转压力器组件③，沿顺时针方向旋转时行程增加，反之则减小。

*张力的调整

将平头螺丝刀插入夹线螺轴槽口④，顺时针旋转可增加张力，反之，则减小压力。

(注：使用合成纤维线时要减小挑线簧的张力。

The normal stroke of thread take-up spring is ① is 6 to 8mm, and the tension at the starting point is 30 to 50g.

★ Adjusting the stroke

Loosen screw ②, and turn tension controller assembly ③ clockwise to increase the stroke or counterclockwise to decrease it.

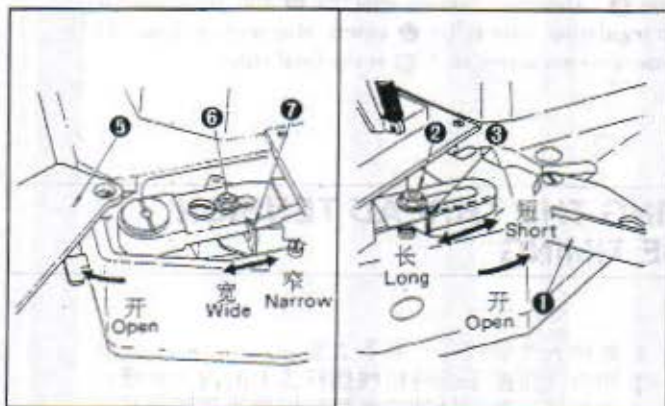
★ Adjusting the tension

Insert the blade of a flat-bit screwdriver into the groove in the tension post ④, and turn it clockwise to increase the tension or counterclockwise to decrease it.

(Note) decrease the tension of the thread take-up spring for a synthetic fiber thread.

十九、加固结长度调整和宽度的调整

ADJUSTING THE LENGTH AND WIDTH OF BAR-TACKING



* 加固结长度的调整

沿箭头方向按推右侧盖①将其打开，然后松开螺母②将调节板向操作者方向滑动时，可增长加固结长度，反之则减小加固结长度，调节完毕要将螺母②拧紧后盖好右侧盖①。

* 加固结宽度的调整

沿箭头方向将左侧盖⑤按动推开，松开螺母⑥然后沿逆时针方向转动调节板⑦可增加加固结宽度，反之则减小加固结宽度，调整完毕后将螺母⑥拧紧并盖上左侧盖⑤。

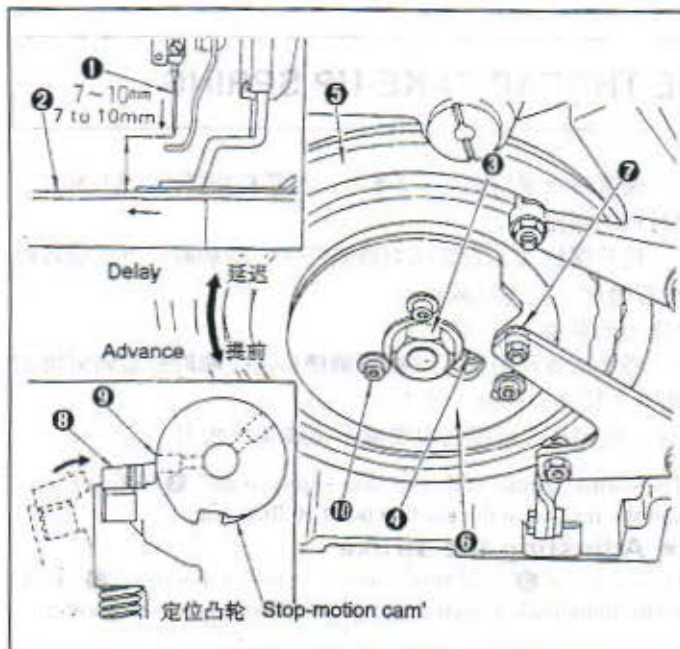
★ Adjusting the bar-tacking length

Push and open bed cover(A) ① in the arrowed direction, and loose nut ② using the wrench supplied with the machine. Turn feed across regulator ③ towards you to increase the bar-tacking length, and vice versa. After adjustment, tighten nut ② and close bed cover(A) ①.

★ Adjusting the bar-tacking width

Push and open bed cover(B) ⑤ in the arrowed direction, and loosen nut ⑥ using the wrench supplied with the machine. Turn feed regulator ⑦ counterclockwise to increase the bar-tacking width, and vice versa. After adjustment, tighten nut ⑥, and close bed cover(B) ⑤.

二十、送料时间的调整 ADJUSTING THE FEED TIMING

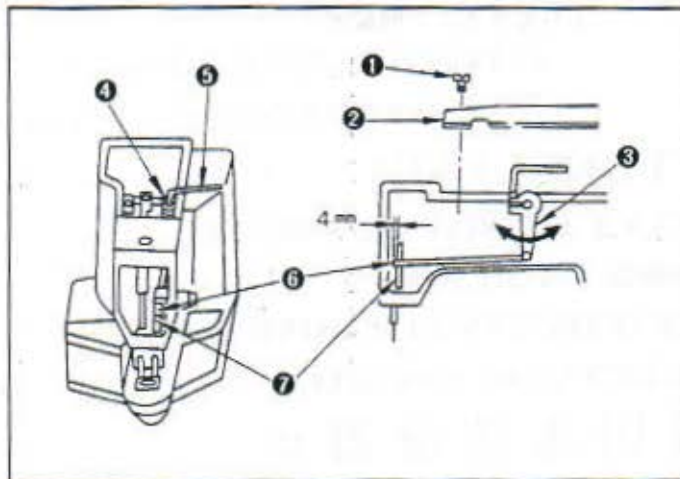


1. 将机对翻转(见“四、机头的翻转”)。
2. 松开六角螺母③和内六角螺钉④转动送料凸轮⑤进行调整, 使机针降到距针板表面②距离为7-10毫米时完成拖布, 沿顺时针方向转动送料凸轮则延长完成拖布时间, 反之则缩短完成拖布时间。
3. 调整完毕, 务必要将内六角螺钉④和六角螺母③拧紧。
* 如上所述当机针高度约为7毫米时, 线的张力较为合适。
* 如果使用合成纤维线, 起始线迹松弛时可以如上所述将机针高度调至约10毫米, 即可防止出现这种现象。
4. 因为制动变速凸轮⑥和送料凸轮⑤一起转动, 为此要松开螺钉⑩, 转动制动变速凸轮进行调节, 使得在最后一针时停车块⑧落入定凸轮⑨第一螺钉处, 以使制动变速凸轮转子轴⑦由低速运转进入停止运动。

1. Raise the machine head. (see "4. Raising the machine head")
2. Loosening hexagon nut ③ and socket screw ④, turn feed cam ⑤, to perform adjustment so that the material feed is completed at the moment the point of needle ① has lowered to a height of 7 to 10mm above the surface of throat plate ②. Turning the feed cam clockwise will delay the completion of the material feed, and vice versa.
3. After adjustment, securely tighten socket screw ④ and hexagon nut ③.
☆ Better thread tension is obtained as the above-mentioned height is adjusted to about 7mm.
☆ If starting stitches formed are loose when using a synthetic fiber thread, adjust the above-mentioned height to about 10mm in order to prevent such trouble.
4. Stop-motion regulating cam ⑥ is turned together with feed cam ⑤. Therefore, loosen setscrew ⑩ and turn the stop-motion regulating cam to make adjustment so that stop-motion regulating cam roller ⑦ enters stop motion from the low-speed revolution when stop-motion hook ⑧ falls onto stop-motion cam screw no.1 ⑨ at the final stitch.

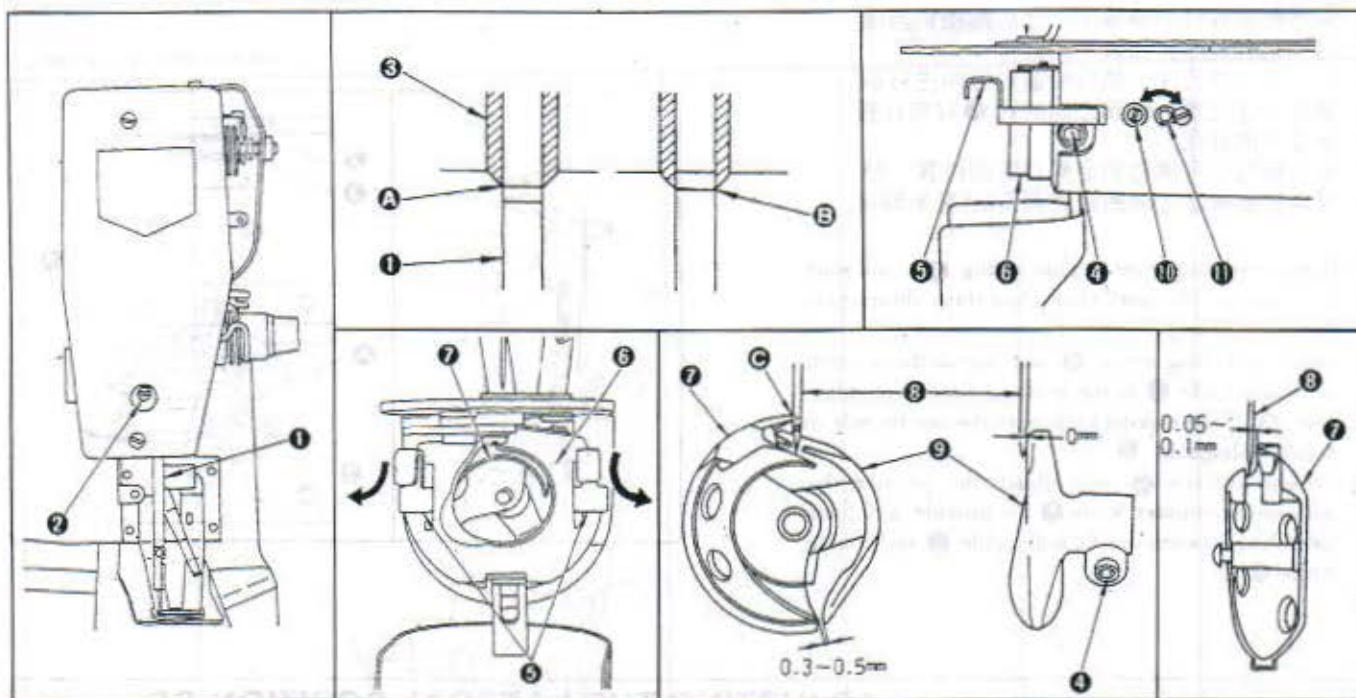
二十一、松紧线时间的调整

ADJUSTING THE THREAD TENSION RELEASE TIMING



1. 卸掉五个螺钉①, 取下上盖②。
 2. 用内六角扳手⑤将松线摆杆③上的内六角螺钉④松开, 然后转动松线摆杆以使当压脚抬起时, 松线杆端部至支承板间距离为4毫米。
 3. 调整完毕, 务必要拧紧内六角螺钉④。
1. Remove five setscrews ① to take off top cover ②.
 2. Loosen socket screw ④ of tension arm ③ by L shaped wrench ⑤, and turn the tension arm to make adjustment so that a 4mm clearance is provided between the end of connecting rod ⑥ and that of tension post support plate ⑦ when the work clamp foot is up (when connecting rod ⑥ is retreated).
 3. After adjustment, securely tighten socket screw ④

二十二、机针与摆梭的关系 NEEDLE-TO-SHUTTLE RELATION



(机针高度的调整)

1. 用手转动转速轮使针杆①降至其行程的最低位置(见“手动操作机器”)。
2. 取下橡胶堵, 然后松开螺钉②。
3. 用手转动转速皮带轮使针杆①上的刻度上线 A 对准针杆下套③的底端, 然后固定螺钉②。(摆梭的定位)。
4. 继续转动转速皮带轮直到针杆①上的下刻度线 B 对准针杆下套③的底端。
5. 分别松开梭托螺钉④, 并将梭床左右压板⑤分别打开, 这时即可将梭床盖⑥取下。

(注): 这时一定要小心, 不要使摆梭掉出。

6. 完成上述步骤后, 即可进行调整以使当摆梭⑦尖部对准针杆⑧中心 C 时, 机针⑧与梭托⑨前面之间没有间隙, 然后固定梭托螺钉④。
7. 松开螺钉⑩, 顺时针或逆时针方向转动梭床体调节轴 以使机针⑧与摆梭⑦之间的间隙调至 0.05-0.1 毫米。调整后紧固好螺钉⑩。
8. 调整完毕, 将梭床盖⑥装入即可。

(注): 这时一定要注意梭床体不可再发生转动。

(Adjusting the height of the needle bar)

1. Turn the cahngeover pulley by hand to bring needle bar ① to the lowest position of its stroke (see "To operate the sewing machine manually".)
2. Remove the rubber cap, and loosen setscrew ②.
3. Turn the driving pulley by hand to make upper marker line A engraved on the needle bar meet the bobbom end of lower bushing ③ of the needle bar, tighten setscrew ②.

(Positioning the shuttle)

4. Furthre turn the driving pulley until lower marker line B engraved on needle bar ① meets the bottom end of lowr bushing ③ of the needle bart.
5. Loosen shuttle driver setscrew ④, and open shuttle race latches ⑤ to the right and left, respectively while pulling them towards you to remove shuttle race ring ⑥.

(Note) At this time, be careful not to allow shuttle ⑦ to fall.

6. Perform adjustment so that no clearance is provided between the needle and the front end of shuttle driver ⑨ when the blade point of shuttle ⑦ is aligned with center C of needle ⑧. Then tighten shuttle driver setscrew ④.

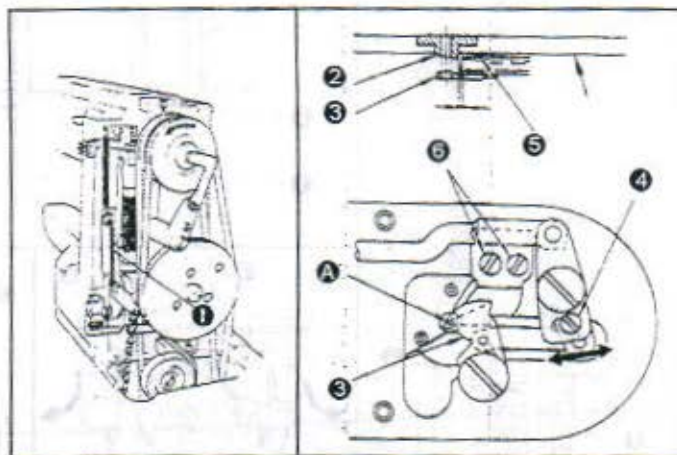
(Caution) At this time, be very careful not to cause the shuttle race to slip in the direction of rotation

7. Loosenting setscrew ⑩, turn shuttle race adjusting shaft ⑪ clock wise or counterclockwise for adjustment to provide a 0.05 to 0.1mm clearance between needle ⑧ and shuttle ⑦, then tighten setscrew ⑩.
8. After adjustment, install shuttle race ring ⑥.

二十三、剪线刀的调整 ADJUSTING THE THREAD TRIMMER

1. 取下起动杆拉力弹簧①，然后起动机（此时当机器停止，压脚不抬起）。
2. 松开调节螺钉④，然后沿箭头方向进行调整剪刀③位置，使其上面的孔A对准针板座②上的针孔。
3. 松开螺钉⑥可调整固定剪刀⑤的位置，使其与针板座②之间的距离调至0.5毫米即可。

1. Remove starting lever tension spring ①, and start the machine. (the work clamp foot stays down when the machine stops.)
2. Loosen adjusting screw ④ and adjust the position of moving knife ③ in the arrowed direction to align hole A of the moving knife with the needle hole in needle hole guide ②.
3. Loosen setscrew ⑥ and adjust the position the position of counter knife ⑤ to provide a 0.5mm clearance between needle hole guide ② and counter knife ⑤.



二十四、压脚的横向调整 ADJUSTING THE LATERAL POSITION OF THE WORK CLAMP FOOT

松开螺母③，并沿方向B转动横向进给联杆，使压脚中心向左移或沿方向C转动，则压脚中心向右移。

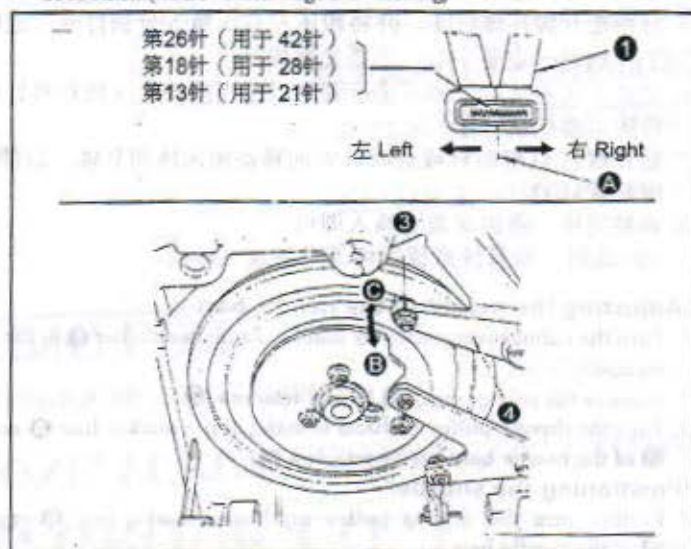
* 42针打结时，线迹的第26针位应在压脚框内的正中间。

* 28针打结时，线迹的第18针位应在压脚框内的正中间。

* 21针打结时，线迹的第13针位应在压脚框内的正中间。

(注)：若想校正压脚中心的偏差，可松开螺母，详见“十九、打结长度及宽度的调整”部分，并可用手来适当扳动压脚，向左或向右以达到调整的目的。

26th stitch (for 42-stitch large bar-tacking)
18th stitch (for 28-stitch large bar-tacking)
13th stitch (for 21-stitch large bar-tacking)



Loosen nut ③, and move feed across regulator in direction B to shift lateral center A of work clamp foot ① to the right or in direction C to shift to the left.

★ For 42-stitch bar-tacking, adjust the lateral center at the 26th stitch.

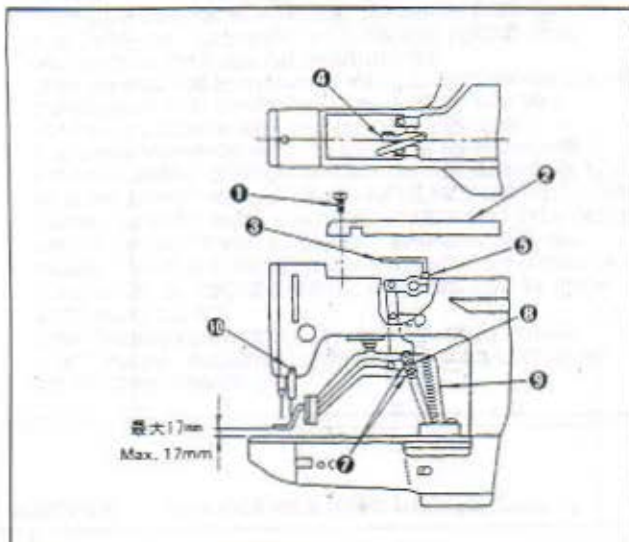
★ For 28-stitch bar-tacking, adjust the lateral center at the 18th stitch.

★ For 21-stitch bar-tacking, adjust the lateral center at the 13th stitch.

(Note) To correct a slight deviation of the lateral feed center, loosen the nut described in "19. Adjusting the length and width of bar tacking", and push the work clamp foot to the right or left by hand to make adjustment.

二十五、压脚抬高的调整

ADJUSTING THE LIFT OF THE WORK CLAMP FOOT



压脚抬高最大可调至17毫米。

1. 在机器不工作情况下，取下五个螺钉①，取下上盖②。
2. 用内六角扳手③，松开启动板摆杆的内六角螺钉⑤。
3. 向下按动内六角扳手③，即可提高压脚向上抬起高度；向上提内六角扳手③，则可降低压脚高度。

4. 调整完毕，务必将内六角螺钉⑤拧紧。

5. 如果左右压脚不在一个水平面内，松开螺钉⑦，并调整压脚驱动板⑧，以调至左右压脚在一个水平面内。

(注)：注意不要使驱动板⑧与压脚架⑨发生干涉。如果压脚与拨线杆发生干涉，可通过螺钉⑩重新调整拨线杆的高度。

The lift of the work clamp foot can be adjusted up to 17mm.

1. With the machine in stop mode, remove five setscrews ① to take off top cover ②.

2. Apply L-shaped wrench ③ to socket screw ⑤ of clamp ④ and loosen socket screw.

3. Push down L-shaped wrench ③ to increase the lift of the work clamp foot, or pull it up to decrease the lift.

4. Securely tighten socket screw ⑤ after adjustment.

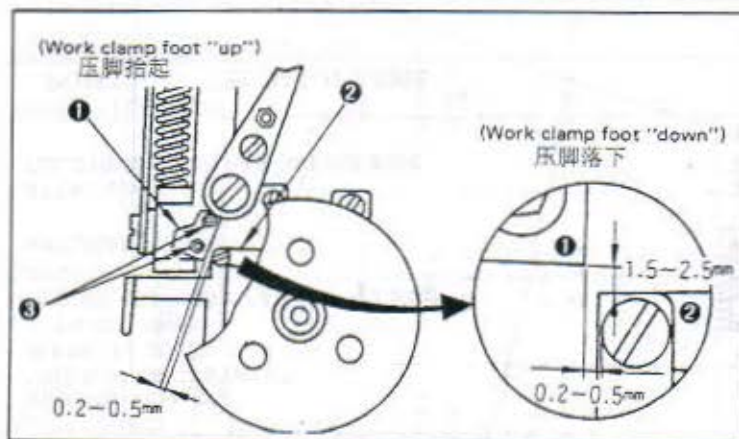
5. If the right and left work clamp feet are not levelled, loosen screw ⑦ and adjust the position of work clamp foot lever support plate ⑧ to level them.

(Caution) Be careful not to cause work clamp foot lever support plate ⑧ to interfere with feed bracket ⑨

If the work clamp foot lever support plate interferes with the wiper, readjust the height of wiper using setscrew ⑩

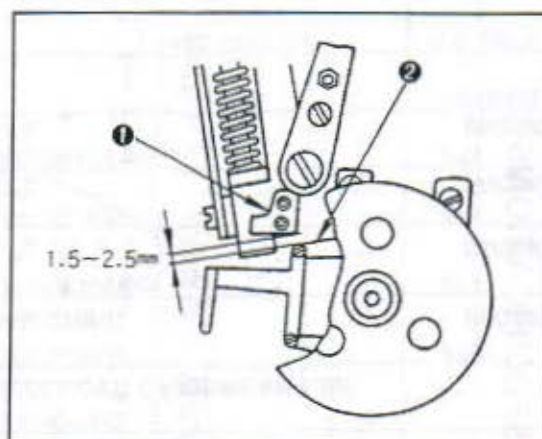
二十六、安全板的调整

ADJUSTING THE SAFETY PLATE



1. 打开两螺钉③进行调整，当机器停止工作，压脚抬起时，将安全板①与抬压脚联接板②之间的横向间隙调至0.2~0.5毫米，而当压脚落下时，安全板与抬压脚联接板之间纵向间隙调至1.5~2.5毫米。

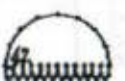
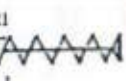
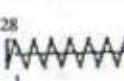
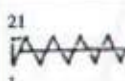
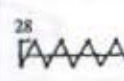
1. Loosening two setscrews ③, perform adjustment so that a 0.2 to 0.5mm lateral clearance is provided between safety plate ① and lifting lever ② when the work clamp foot is up at the time of stop motion, and a 1.5 to 2.5mm longitudinal clearance between them when the work clamp foot is down.



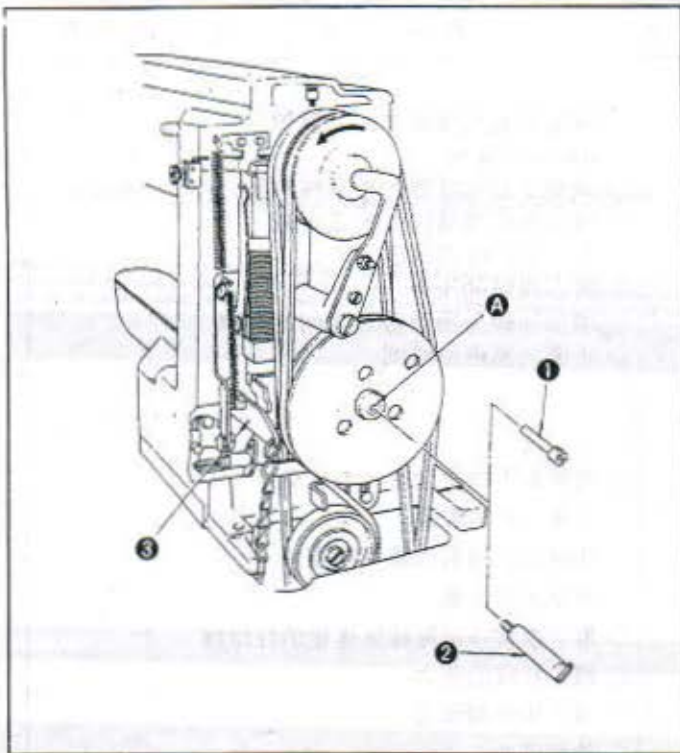
2. 观察在高速打结过程中，(压脚处于落下的状态)安全板①与抬压脚联接板②之间的纵向间隙是否为1.5~2.5毫米。

2. Check that the longitudinal clearance between safety plate ① and lifting lever ② is 1.5 to 2.5mm during the high-speed bar tacking (the work clamp foot is down).

二十七、技术参数 SPECIFICATIONS

	标 准 Standard	系 列 品 种 Subclass							
型 号 Model		-B	-1	-2	-10	-20	-200	-TH	-210
应 用 Application	大尺寸加固结 Large size bar tacking	半圆加固结 Semi-circular tacking	小尺寸加固结 Small size bar tacking	←	钮孔加固结 Buttonhole bar tacking	←	裤带环加固结 Belt looper bar tacking	厚料加固结 Heavy-duty bar tacking	伞顶圆加固结 Umbrella-top circular tacking
缝速(转/分) Sewing speed(s.p.m)	1700	←	←	←	←	←	←	←	←
线迹类型 Stitching pattern									
针 数 Number of stitches	42	42	21	28	21	28	28	42	28
加固结宽度 Bat tacking width(mm)	1.5-3 标准3 (Standard 3)	最大7 Max.7	1.5-3 标准3 (Standard 3)	←	1.5-3 标准2.5 (Standard 2.5)	←		1.5-3 标准3 (Standard 3)	Φ6-Φ14 (标准Φ12) (Standard 12)
加固结长度 Bat tacking width(mm)	8-16 标准16 (Standard 3)	最大10 Max.10	4-8 (标准6) (Standard 3)	←	←	←	6.5-14 (标准14) (Standard 14)	8-16 (标准16) (Standard 16)	
机 针 Needle	LP×5 #14#16	←	←	←	←	←	←		DP×7 #12#14
压脚提升高度 Work clamp foot lift(mm)					最大17 Max.17				最大8 Max.8
润 滑 油 Lubricating oil	缝纫机专用油 Oil for sewing machine								

二十八、减压联动控制器(装置)润滑方法 HOW TO SUPPLY GREASE TO THE REDUCER



对于联动控制机器使用半年以上或噪音较大时，要向减压装置加入润滑脂，步骤如下：

1. 停止机器运转并取下螺钉①。
2. 将随机附带的无盖润滑脂管旋入孔 A 中，并挤出润滑脂。
3. 从孔 A 旋出油脂管后，用油孔螺轴①将润滑脂向里推。
4. 重复上述步骤，向孔内注入两次或酌量。
5. 拧紧螺钉①。

(注意)：如果润滑脂没有顺利进入机构中，则可将润滑脂管②旋入孔 A，打开电机开关，并用起动杆③上下触动抬压脚联接板，这样就可以使润滑脂很容易地进入机构中。

Supply grease to the reducer in accordance with the following procedure when the machine has been used for more than half year or if it chatters.

1. Stop the machine and remove screw ① .
2. Uncap grease tube ② supplied with the machine, screw the tube into hole A , and push the grease out of the tube.
3. Removing grease tube ② from A , push in the grease by screw ① .
4. Repeat the step of injecting the grease and pushing it in by the screw twice or so.
5. Tighten screw ① .

(Note) If the grease will not get into the unit smooth'y, screw in grease tube ② . Turn on the motor switch, and move the presser foot up and down two or three times using lever ③ . By doing this, you can make the grease get into the unit easily.

二十九、故障及其排除方法

故 障	原 因	排 除 方 式	项 数
1. 开始打结时, 针线从机针上脱出	① 开始时跳线 ② 剪线后留在机针上的线头过短 ③ 梭芯线头过短 ④ 进给时间不正确	○ 调整机地与摆梭之间的间隙 0.05-0.1毫米 ○ 调整 2 号压线器的松紧线时间 ○ 增加挑线弹簧的张力或者减小 1 号压线器的压力 ○ 减小梭线的压力 ○ 增加针板与固定剪刀之间的间隙 ○ 正确调整进给时间	
2. 经常断线或使用合成纤维线时扎线、融线	① 摆梭或摆梭托有痕迹 ② 针板有划伤 ③ 机针碰压脚 ④ 梭床体槽里有较多的纤维绒 ⑥ 挑线簧张力过大 ⑦ 由机针产生的热而使合成纤维线融化	○ 将其取下并用细磨石或软皮(布)去掉痕迹 ○ 用软皮去掉划伤或更换零件 ○ 调整压脚位置 ○ 取下摆梭并清除梭床体里的纤维绒 ○ 减小针线的张力 ○ 减小挑线簧张力 ○ 使用硅油	
3. 经常断线	① 针弯 ② 机针碰压脚 ③ 进给时间不正确 ④ 机针对布料太细 ⑤ 摆梭托碰弯机针	○ 更换机针 ○ 纠正压脚偏量 ○ 纠正进给时间 ○ 根据布料更换较粗机针 ○ 纠正摆梭托与机针的位置	
4. 不剪线	① 固定剪刀变钝 ② 针板与固定剪刀的水平间隙不够 ③ 动剪刀位置不正确 ④ 最后一跳线	○ 更换定剪刀 ○ 增大定剪刀的弯度 ○ 纠正动剪刀的位置 ○ 纠正机针与摆梭之间的运动时间	
5. 经常发生跳线	① 机针与摆梭的运动不协调 ② 机针与摆梭之间的间隙过大 ③ 针弯 ④ 进给时间不正确 ⑤ 摆梭托碰弯机针	○ 纠正机针与摆梭的位置 ○ 纠正机针与摆梭的位置 ○ 更换机针 ○ 纠正进给时间 ○ 纠正摆梭托的位置	
6. 缝线跑位	① 针线张力不够 ② 松紧线机构失灵 ③ 剪线后针线头过长	○ 增加针线的张力 ○ 检查一下在打结其间 2 号压线盘是否松线 ○ 增加 1 号压线器的压力	
7. 剪线时断线	① 动剪刀位置不正确	○ 纠正动剪刀的位置	

TROUBLES AND CORRECTIVE MEASURES

Trouble	Cause	Corrective measures	Page
1. The needle thread slips off the needle at the start of bar-tacking.	① Stitches are skipped at the start.	○ Adjust the clearance between the needle and the shuttle to 0.05 to 0.1mm.	13
	② The needle thread remaining on the needle after thread trimming is too short.	○ Correct the thread tension release timing of the thread tension controller No.2.	10
	③ The bobbin thread is too short.	○ Increase the tension of the thread take-up spring or decrease the tension of the thread tension controller No.1	10
	④ The feed timing is bad.	○ Decrease the tension of the bobbin thread. ○ Increase the clearance between the needle hole guide and the counter knife. ○ Correct the feed timing.	10 14 12
2. Thread often bareaks or synthetic fiber thread splits finely.	① The shuttle or the driver has scratches.	○ Take it out and remove the scratches using a fine whetstone or buff.	15
	② The needle hole guide has scratches.	○ Buff or replace it.	
	③ The needle strikes the work clamp foot.	○ Correct the position of the work clamp foot.	13
	④ Fibrous dust is in the groove of the shuttle race.	○ Take out the shuttle and remove the fibrous dust from the shuttle race.	10
	⑤ The needle thread tension is too high.	○ Reduce the needle thread tension.	
	⑥ The tension of the thread take-up spring is too high.	○ Reduce the tension.	11
	⑦ The synthetic fiber thread melts due to heat generated on the needle.	○ Use silicone oil.	7
3. The needle often breaks.	① The needle is bent.	○ replace the bent needle	9
	② The needle hits the work clamp foot.	○ correct the position of the work clamp foot.	15
	③ The feed timing is bad.	○ Correct the feed timing.	12
	④ The needle is too thin for the material.	○ replace it with a thicker needle according to the material.	8
	⑤ The driver excessively bends the needle.	○ correctly position the needle and the shuttle.	13
4. Threads are not trimmed.	① The counter knife is dull.	○ replace the counter knife.	14
	② The difference in level between the needle hole guide and the counter knife is not enough.	○ increase the bend of the counter knife.	14
	③ The moving knife has been improperly positioned.	○ correct the position of the moving knife.	14
	④ The last stitch is skipped.	○ correct the timing between the needle and the shuttle.	13
5. Stitch skipping often occurs.	① The motions of the needle and shuttle are not properly synchronized.	○ Correct the positions of the needle and shuttle.	13
	② The clearance between the needle and shuttle is too large.	○ Correct the positions of the needle and shuttle.	13
	③ The needle is bent.	○ Replace the bent needle.	9
	④ The feed timing is bad.	○ Correct the feed timing.	12
	⑤ The driver excessively bends the needle.	○ Correctly position the driver.	13
6. The needle thread comes out on the wrong side of the material.	① The needle thread tension is not high enough.	○ Increase the needle thread tension.	10
	② The tension release mechanism fails to work properly.	○ Check whether or not the tension disc No.2 is released during bar-tacking.	10
	③ The needle thread after thread trimming is too long.	○ Increase the tension of the thread tension controller No.1.	10
7. Threads break at time of thread trimming.	① The moving knife has been improperly positioned.	○ Correct the position of the moving knife.	14

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Tacking Industrial Sewing Machine

零 件 目 录

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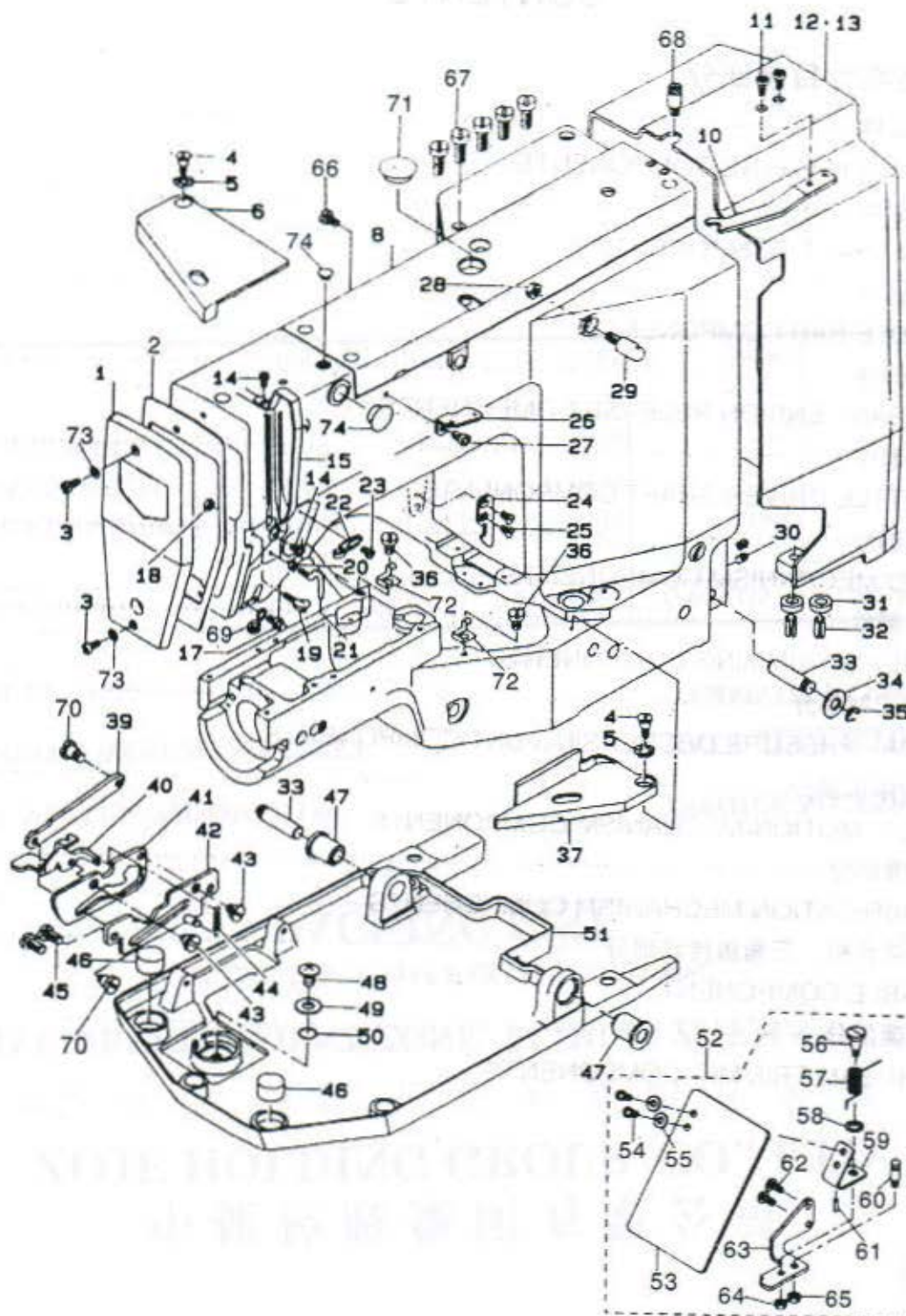
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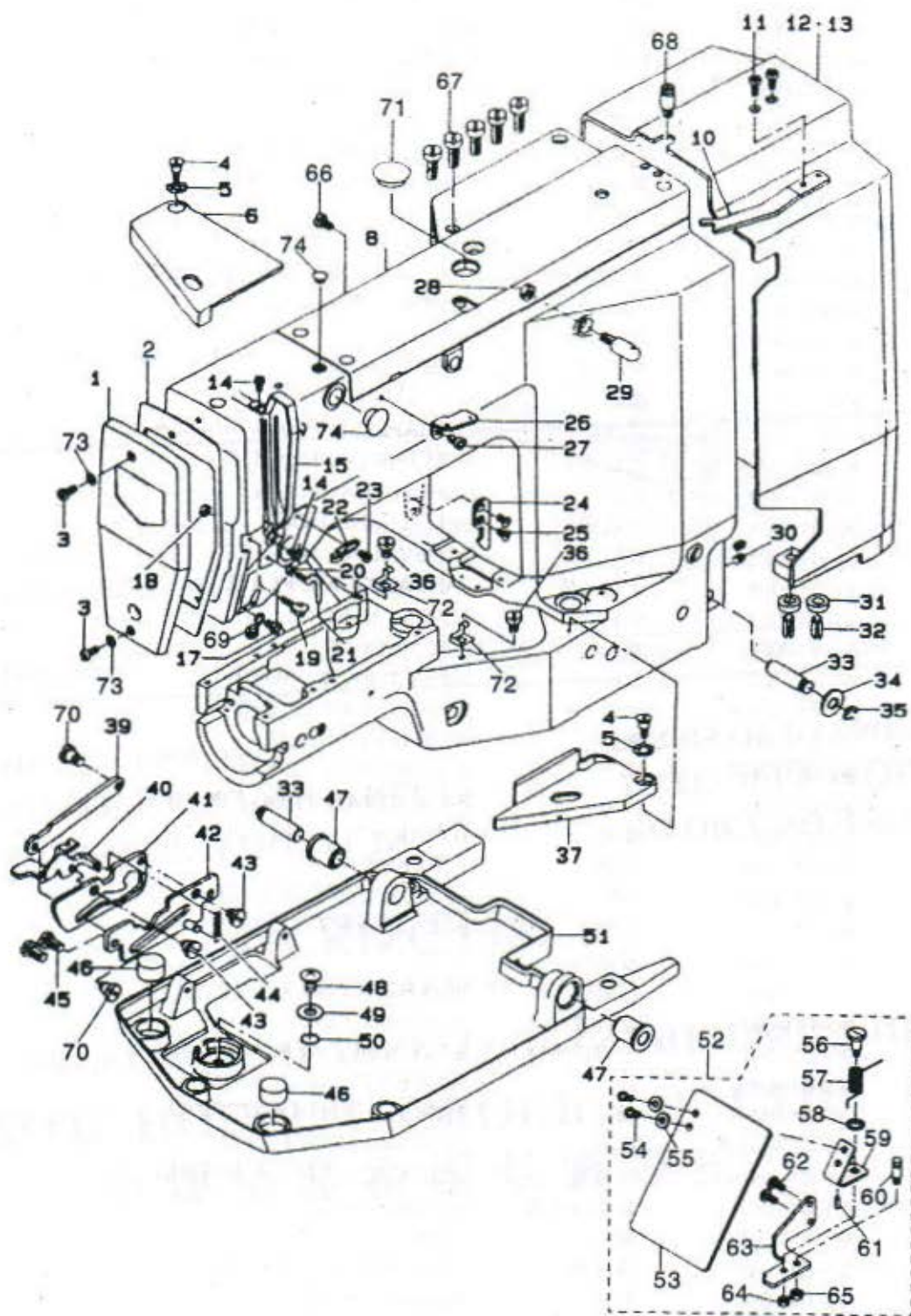
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一、机壳部件 SEWING MACHINE COMPONENTS



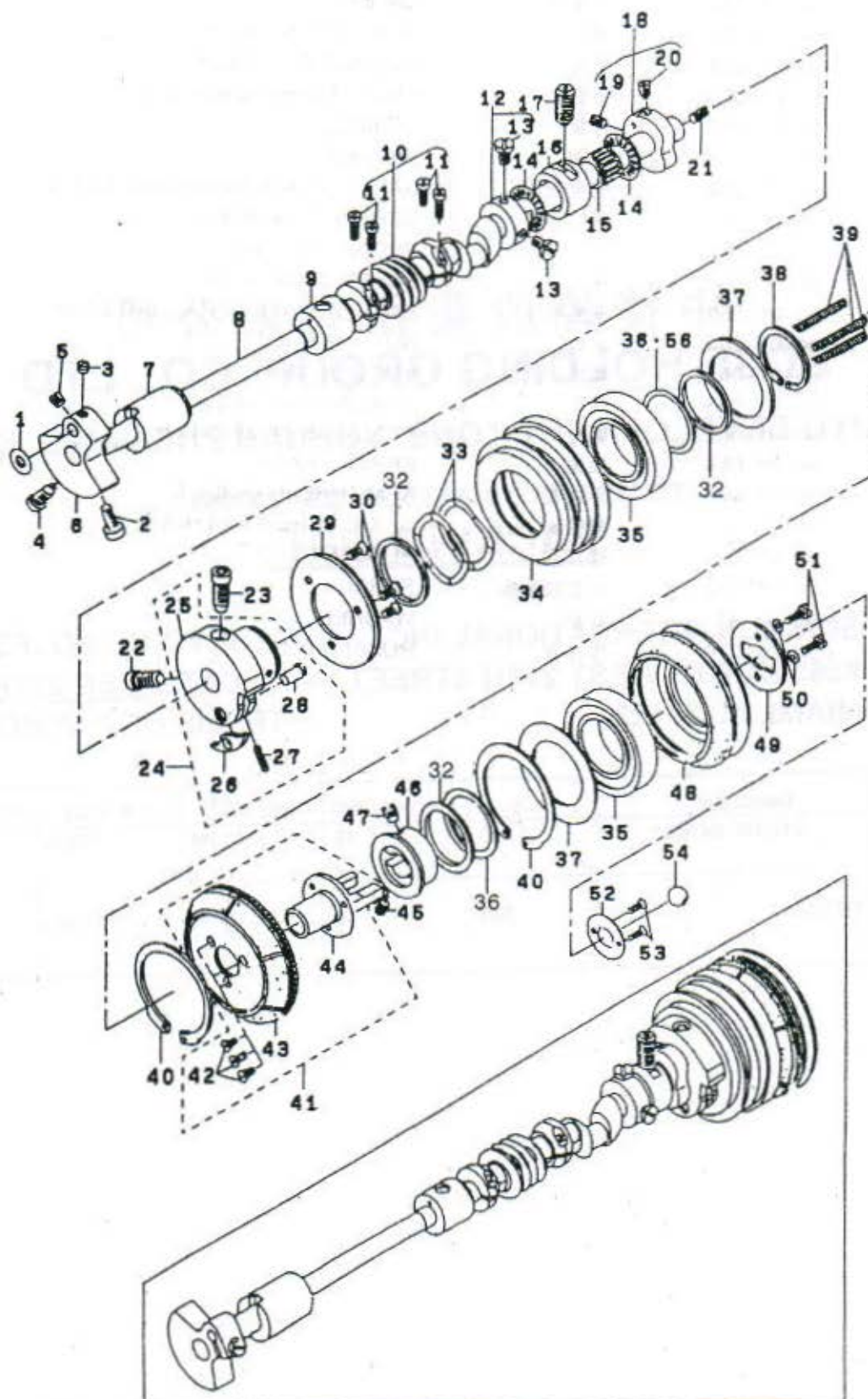
REF No 序号	PART. NO 件 号	DESCRIPTION 名 称		Q'TY 数量
1	90-01-001	面板	FACE PLATE ASM.	1
2	90-01-002	面板垫	FACE PACKING	1
3	90-01-003	螺钉	SCREW 11/64-40 L=10	2
4	90-01-004	螺钉	HINGE SCREW D=6.35 H=4.7	2
5	90-01-005	垫圈	WAVED WASHER 6.4×11×0.3	2
6	90-01-006	左侧盖	BED COVER B	1
8	90-01-008	上盖	TOP COVER	1
10	90-01-010	锁紧板	BELT COVER FIXING PALTE	1
11	90-01-011	螺钉	SCREW 11/64-40 L=8	2
12	90-01-012	皮带罩	BELT COVER	1
14	90-01-014	螺钉	SCREW 9/64-40 L=7	2
15	90-01-015	挑线杆防护罩	THREAD TAKE-UP LEVER OIL GAURD	1
17	90-01-017	螺钉	SCREW 11/64-40 L=7.8	1
18	90-01-018	螺母	NUT 9/64-40	1
19	90-01-019	中线勾	THREAD GUIDE	1
20	90-01-020	螺母	NUT 9/64-40	1
21	90-01-021	拦线勾	L-SHAPED THREAD GUIDE A	1
22	90-01-022	过线钩	ARM THREAD GUIDE A	1
23	90-01-023	螺钉	SCREW 9/64-40 L=6	1
24	90-01-024	锁紧钩	BED FITTING HOOK	1
25	90-01-025	螺钉	SCREW 11/64-40 L=8.3	2
26	90-01-026	上过线板	THREAD GUIDE PLATE	1
27	90-01-027	螺钉	SCREW 15/64-28 L=7	1
28	90-01-028	螺母	NUT 15/64-28	1
29	90-01-029	导线柱	FIRST THREAD GUIDE	1
30	90-01-030	螺钉	SCREW 15/64-28 L=8	2
31	90-01-031	橡胶垫	RUBBER WASHER	2
32	90-01-032	销	SPRING PIN 8×20	2
33	90-01-033	转轴	BASE CONNEVTING PIN	2
34	90-01-034	垫圈	WASHER 10.5×18×2	1
35	90-01-035	挡圈	E-RING 6	1
36	90-01-036	螺钉	SCREW 15/64-28 L=11	2
37	90-01-037	右侧盖	BED COVER A	1
39	90-01-039	支承板	STAY	1
40	90-01-040	锁紧板	BED ROCKER	1
41	90-01-041	定位板	STAY ROCKER	1
42	90-01-042	固定板组件	STAY GUIDE ASM.	1
43	90-01-043	螺钉	HINGE SCREW D=8 H=3.4	2
44	90-01-044	弹簧	THREAD TENSION SPRING	1
45	90-01-045	螺钉	SCREW 15/64-28 L=12	2
46	90-01-046	橡胶垫	VIBRATION-PROOF RUBBER	2
47	90-01-047	转轴橡胶套	RUBBER BUSH	2
48	90-01-048	螺钉	SCREW	1
49	90-01-049	橡胶垫	WASHER 4.5×10×0.8	1
50	90-01-050	垫圈	RUBBER RING	1
51	90-01-051	机座	BED FITTING BASE	1
52	90-01-052	安全板组件	SAFETY PLATE ASM.	1

一、机壳部件 SEWING MACHINE COMPONENTS



REF No 序号	PART NO 件 号	DESCRIPTION 名 称		Q'TY 数量
53	90-01-053	安全板	SAFETY PLATE	1
54	90-01-054	螺钉	SCREW 11/64-40 L=7	2
55	90-01-055	垫圈	WASHER 4.5X10X0.8	2
56	90-01-056	螺钉轴	HINGE SCREW D=6 H=0.2	1
57	90-01-057	弹簧	SPRINGER	1
58	90-01-058	垫圈	WASHER	1
59	90-01-059	安全板架	SAFETY PLATE INSTALLING PLATE	1
60	90-01-060	螺钉	SCREW 11/64-40 L=7	1
61	90-01-061	销	SPRING PIN 2×6	1
62	90-01-062	螺钉	SCREW 11/64-40 L=7	2
63	90-01-063	安全板座	SAFETY PLATE INSTALLING BASE	1
64	90-01-064	螺母	NUT 11/64-40	1
65	90-01-065	螺母	NUT 3/16-28	1
66	90-01-066	螺钉	SCREW 11/64-40 L=7	2
67	90-01-067	螺钉	SCREW 15/64-28 L=11.5	5
68	90-01-068	挂销	SPRING RACK	1
69	90-01-069	下线勾	ARM THREAD GUIDE B	1
70	90-01-070	螺钉轴	HINGE SCREW D=8 H=6.8	2
71	90-01-071	橡皮塞	RUBBER PLUG	1
72	90-01-072	侧盖锁紧板	SPRING	2
73	90-01-073	垫圈	WASHER	2
74	90-01-074	橡皮塞	RUBBER PLUG	1

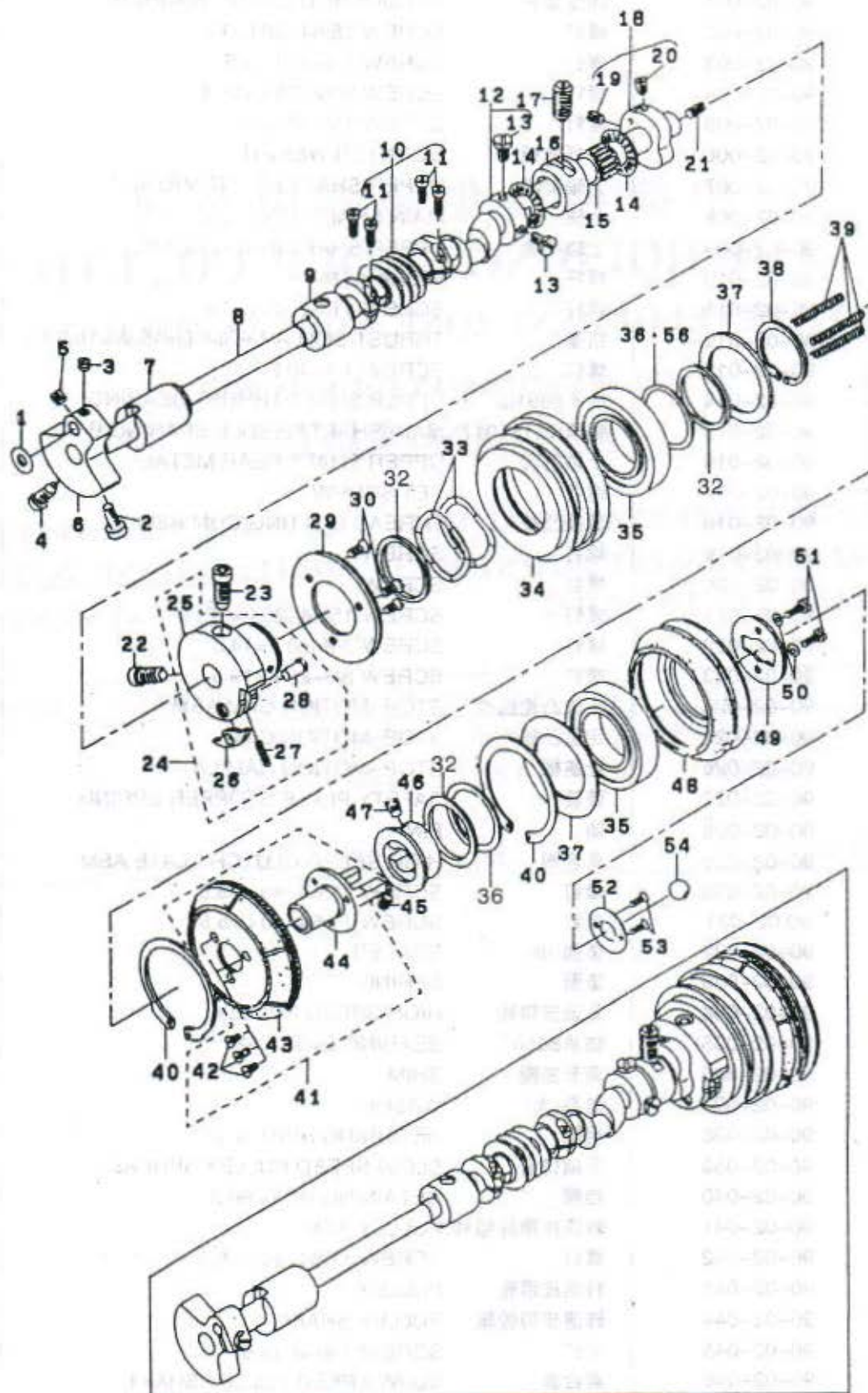
二、上轴部件 MAIN SHAFT COMPONENTS



REF No 序号	PART NO 件 号	DESCRIPTION 名 称	Q'TY 数量
1	90-02-001	调整垫片 NEEDLE ROD CRANK WASHER	1
2	90-02-002	螺钉 SCREW 15/64-28 L=14	1
3	90-02-003	螺钉 SCREW 1/4-40 L=4.5	1
4	90-02-004	螺钉 SCREW 9/32-28 L=16.5	1
5	90-02-005	螺钉 SCREW 1/4-40 L=6	1
6	90-02-006	针杆曲柄 COUNTER WEIGHT	1
7	90-02-007	上轴前套 UPPER SHAFT FRONT METAL	1
8	90-02-008	上轴 MAIN SHAFT	1
9	90-02-009	上轴中套 UPPER SHAFT INNER METAL	1
10	90-02-010	蜗杆 WORK ASM.	1
11	90-02-011	螺钉 SCREW 11/64-40 L=14	4
12	90-02-012	挡圈 THRUST COLLAR ASM. D=15 W=10.8	1
13	90-02-013	螺钉 SCREW 1/4-40 L=11	2
14	90-02-014	轴承889102 UPPER SHAFT THRUST BEARING	2
15	90-02-015	轴承KS151917 MAIN SHAFT NEEDLE BEARING B	1
16	90-02-016	上轴后套 UPPER SHAFT REAR METAL	1
17	90-02-017	螺钉 SET SCREW	1
18	90-02-018	剪线凸轮 THREAD CUTTING CUM ASM.	1
19	90-02-019	螺钉 SCREW	1
20	90-02-020	螺钉 SCREW	1
21	90-02-021	螺钉 SCREW 15/64-26 L=12	1
22	90-02-022	螺钉 SCREW 3/8-28 L=14.5	1
23	90-02-023	螺钉 SCREW 3/8-28 L=19.5	1
24	90-02-024	定位凸轮组件 STOP-MOTION CAM ASM.	1
25	90-02-025	定位凸轮 STOP-MOTION CAM	1
26	90-02-026	止逆板 STOP-MOTION CAM LATCH	1
27	90-02-027	弹簧 SAFETY PLATE STOPPER SPRING	1
28	90-02-028	销 PIN	1
29	90-02-029	离合圈 HIGH SPEED CLUTCH PLATE ASM.	1
30	90-02-030	螺钉 SCREW 11/64-40 L=8.5	2
31	90-02-031	螺钉 SCREW 11/64-40 L=5.5	1
32	90-02-032	垫圈(小) SPACER	3
33	90-02-033	垫圈 SPRING	2
34	90-02-034	高速皮带轮 HIGH SPEED PULLEY	1
35	90-02-035	轴承80107 BEARING D=35 x 62	2
36	90-02-306	调节垫圈 SHIM	4-6
37	90-02-037	垫圈(大) WASHER	2
38	90-02-038	挡圈 RETAINING RING 32.2	
39	90-02-039	压缩弹簧 SLOW SPEED PULLEY SPRING	3
40	90-02-040	挡圈 RETAINING RING 66.2	2
41	90-02-041	转速皮带轮组件 PULLEY ASM.	1
42	90-02-042	螺钉 SCREW 11/64-40 L=5.5	3
43	90-02-043	转速皮带轮 PULLEY	1
44	90-02-044	转速皮带轮轴 PULLEY SHAFT	1
45	90-02-045	螺钉 SCREW 1/4-40 L=6	1
46	90-02-046	离合套 SLOW SPEED PULLEY SHAFT	1

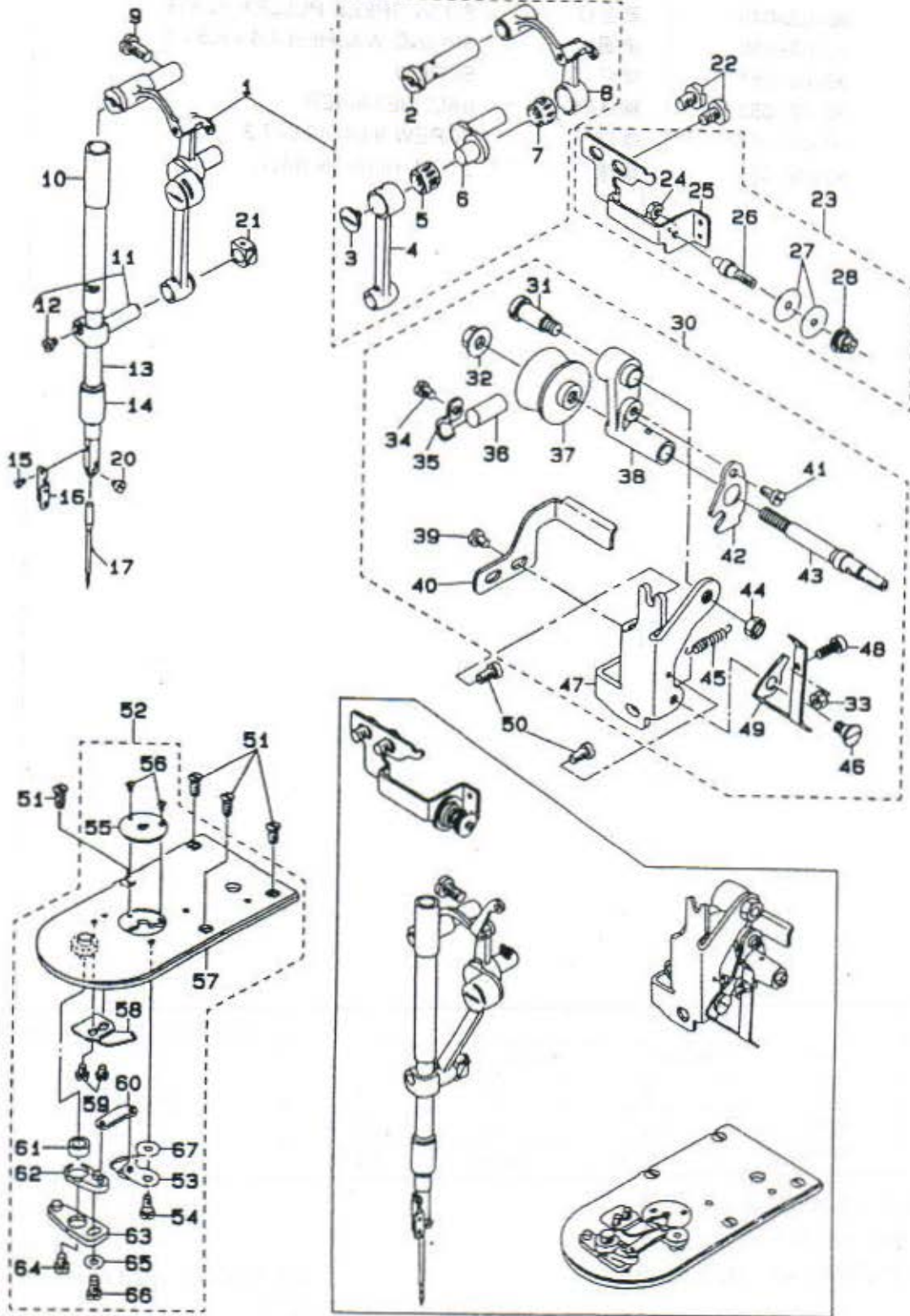
二、上轴部件

MAIN SHAFT COMPONENTS



REF No 序号	PART NO 件号	DESCRIPTION 名称	QTY 数量
47	90-02-047	螺钉 SCREW 1/4-40 L=11	1
48	90-02-048	低速皮带轮 SLOW SPEED PULLEY	1
49	90-02-049	离合板 SLOW SPEED PULLEY PLATE	1
50	90-02-050	垫圈 SPRING WASHER 4.5 × 8.5 × 1	2
51	90-02-051	螺钉 SCREW	2
52	90-02-052	钢球碗 BALL RETAINER	1
53	90-02-053	螺钉 SCREW 9/64-40 L=7.2	2
54	90-02-054	钢球 STOP-HOTION BALL	1

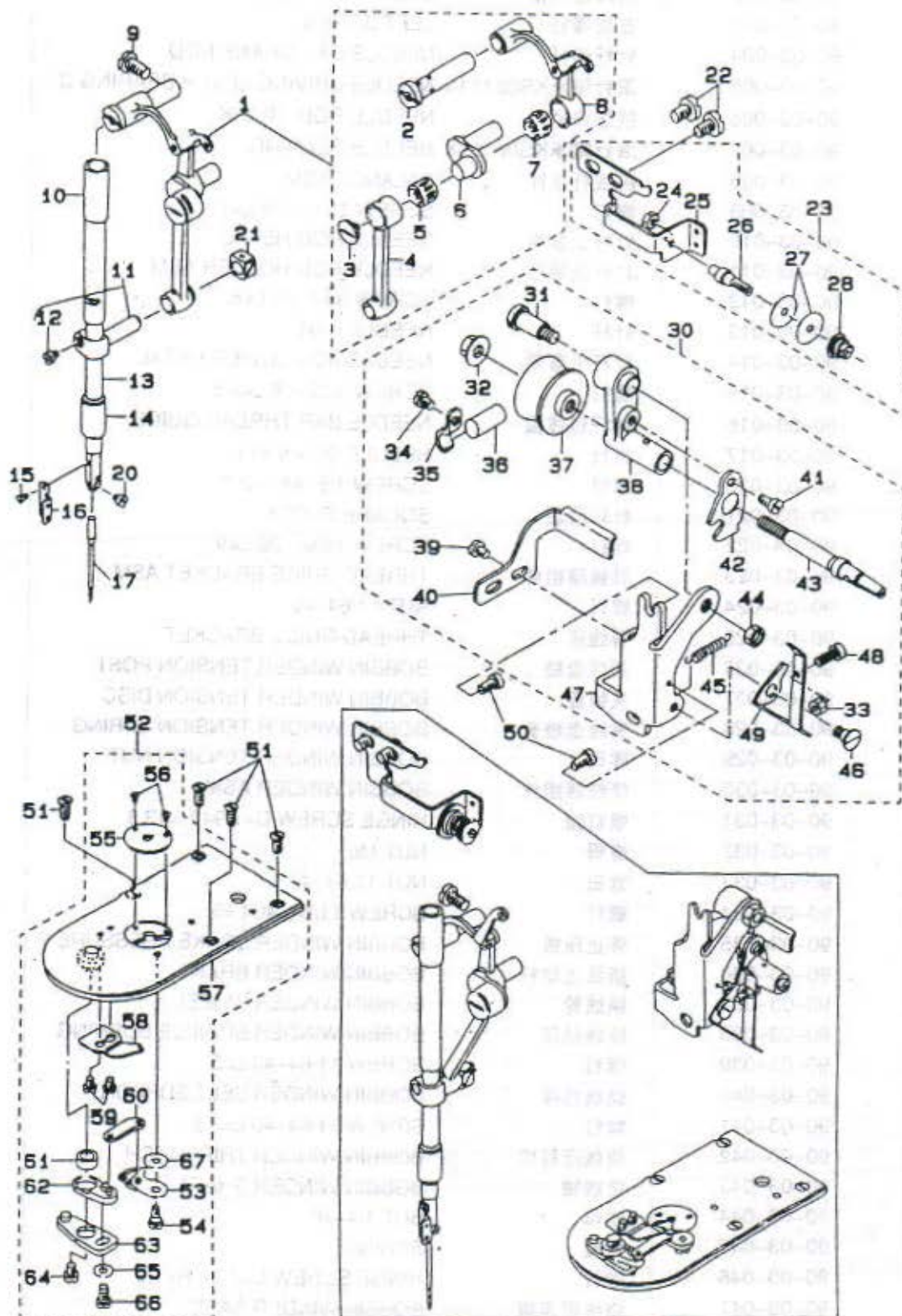
三、针杆部件



REF No 序号	PART NO 件 号	DESCRIPTION 名 称	QTY 数量
1	90-03-001	挑线杆大组件	LINK BALANCE ASM.
2	90-03-002	挑线连杆销	BALANCE CRANK PIN
3	90-03-003	左旋螺钉	LEFT SCREW
4	90-03-004	针杆连杆	NEEDLE BAR CRANK ROD
5	90-03-005	滚针轴承KS081110	NEEDLE DRIVING LEVER BEARING C
6	90-03-006	挑线曲柄	NEEDLE ROD CRANK
7	90-03-007	滚针轴承KS081208	NEEDLE BEARING
8	90-03-008	挑线杆组件	BALANCE ASM.
9	90-03-009	螺钉	SCREW 15/64-28 L=11
10	90-03-010	针杆上套筒	NEEDLE ROD HETAL
11	90-03-011	针杆连接柱	NEEDLE ROD HOLDER ASM.
12	90-03-012	螺钉	SCREW 9/64-40 L=6
13	90-03-013	针杆	NEEDLE BAR
14	90-03-014	针杆下套筒	NEEDLE ROD LOWER HETAL
15	90-03-015	螺钉	SCREW 3/32-56 L=4.5
16	90-03-016	针杆过线板	NEEDLE BAR THREAD GUIDE
17	90-03-017	机针	NEEDLE DP x 5 #14
20	90-03-020	螺钉	SCREW 1/8-44 L=2.9
21	90-03-021	针杆滑块	SQUARE BLOCK
22	90-03-022	螺钉	SCREW 15/64-28 L=9
23	90-03-023	导线座组件	THREAD GUIDE BRACKET ASM.
24	90-03-024	螺母	NUT 11/64-40
25	90-03-025	导线座	THREAD GUIDE BRACKET
26	90-03-026	夹线盘轴	BOBBIN WINDER TENSION POST
27	90-03-027	夹线盘	BOBBIN WINDER TENSION DISC
28	90-03-028	夹线盘塔簧	BOBBIN WINDER TENSION SPRING
29	90-03-029	螺母	BOBBIN WINDER TENSION NUT
30	90-03-030	绕线器组件	BOBBIN WINDER ASM.
31	90-03-031	螺钉轴	HINGE SCREW D=7.94 H=13.3
32	90-03-032	螺母	NUT M6
33	90-03-033	螺母	NUT 11/64-40
34	90-03-034	螺钉	SCREW 11/64-40 L=5
35	90-03-035	停止压板	BOBBIN WINDER BRAKE PRESSURE P
36	90-03-036	绕线止动杆	BOBBIN WINDER BRAKE
37	90-03-037	绕线轮	BOBBIN WINDER WHEEL
38	90-03-038	绕线轴架	BOBBIN WINDER SPINDLE BUSHING
39	90-03-039	螺钉	SCREW 11/64-40 L=5
40	90-03-040	绕线挡板	BOBBIN WINDER BELT SUPPORT
41	90-03-041	螺钉	SCREW 11/64-40 L=7.8
42	90-03-042	绕线行程板	BOBBIN WINDER TRIP LATCH
43	90-03-043	绕线轴	BOBBIN WINDER SHAFT
44	90-03-044	螺母	BUT 1/4-40
45	90-03-045	弹簧	SPRING
46	90-03-046	螺钉	HINGE SCREW D=7.24 H=1.9
47	90-03-047	绕线固定板	BOBBIN WINDER BASE
48	90-03-048	螺钉	BOBBIN WINDER ADJUSTING SCREW

三、针杆部件

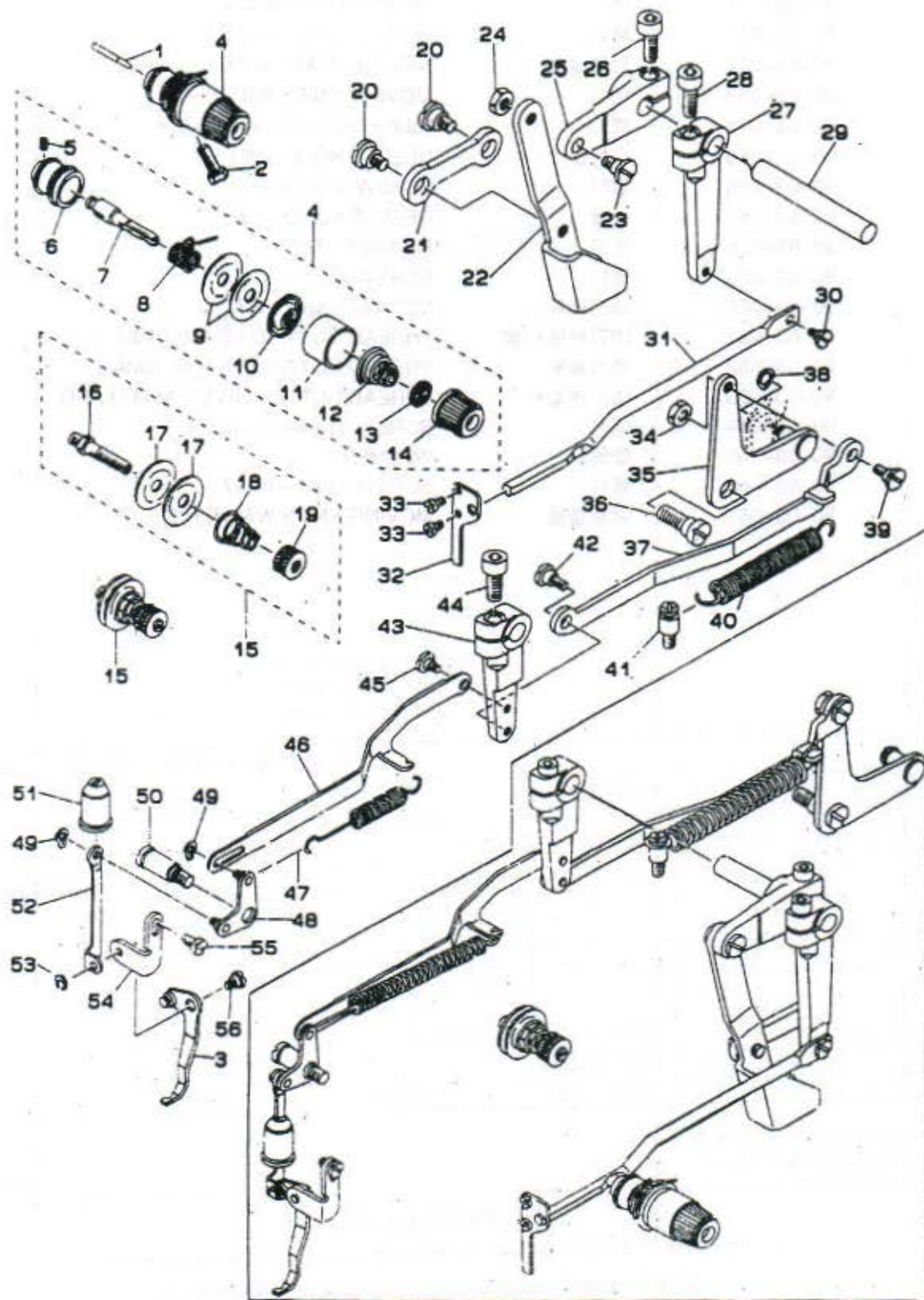
NEEDLE BAR COMPONENTS



REF No 序号	PART NO 件 号	DESCRIPTION 名 称		Q'TY 数 量
49	90-03-049	满线跳板	BOBBIN WINDER TRIP LATCH	1
50	90-03-050	螺钉	SCREW 11/64-40 L=9	2
51	90-03-051	螺钉	SCREW 11/64-40 L=5.5	4
52	90-03-052	针板组件	NEEDLE PLATE ASM.	1
53	90-03-053	动刀	MOVING KNIFE ASM.	1
54	90-03-054	螺钉	HINGE SCREW D=5.0 H=0.9	1
55	90-03-055	小针板	NEEDLE HOLE GUID	1
56	90-03-056	螺钉	SCREW 3/32-56 L=2.2	2
57	90-03-057	针板	NEEDLE PLATE ASM.	1
58	90-03-058	定刀	FIXING KNIFE	1
59	90-03-059	螺钉	SCREW 9/64-40 L=3.5	2
60	90-03-060	动刀连杆	MOVING KNIFE LINK	1
61	90-03-061	动刀杆销衬套	THREAD CUTTING LEVER RING	1
62	90-03-062	动刀曲柄	THREAD CUTTING LEVER , SMALL	1
63	90-03-063	动刀传动杆	THREAD CUTTER LEVER ASM., LARG	1
64	90-03-064	螺钉	SCREW 11/64-40 L=4.0	1
65	90-03-065	垫圈	WASHER	1
66	90-03-066	螺钉	SCREW 11/64-40 L=7	1
67	90-03-067	调整垫圈	MOVING KNIFE WASHER C	1

四、扫线部件

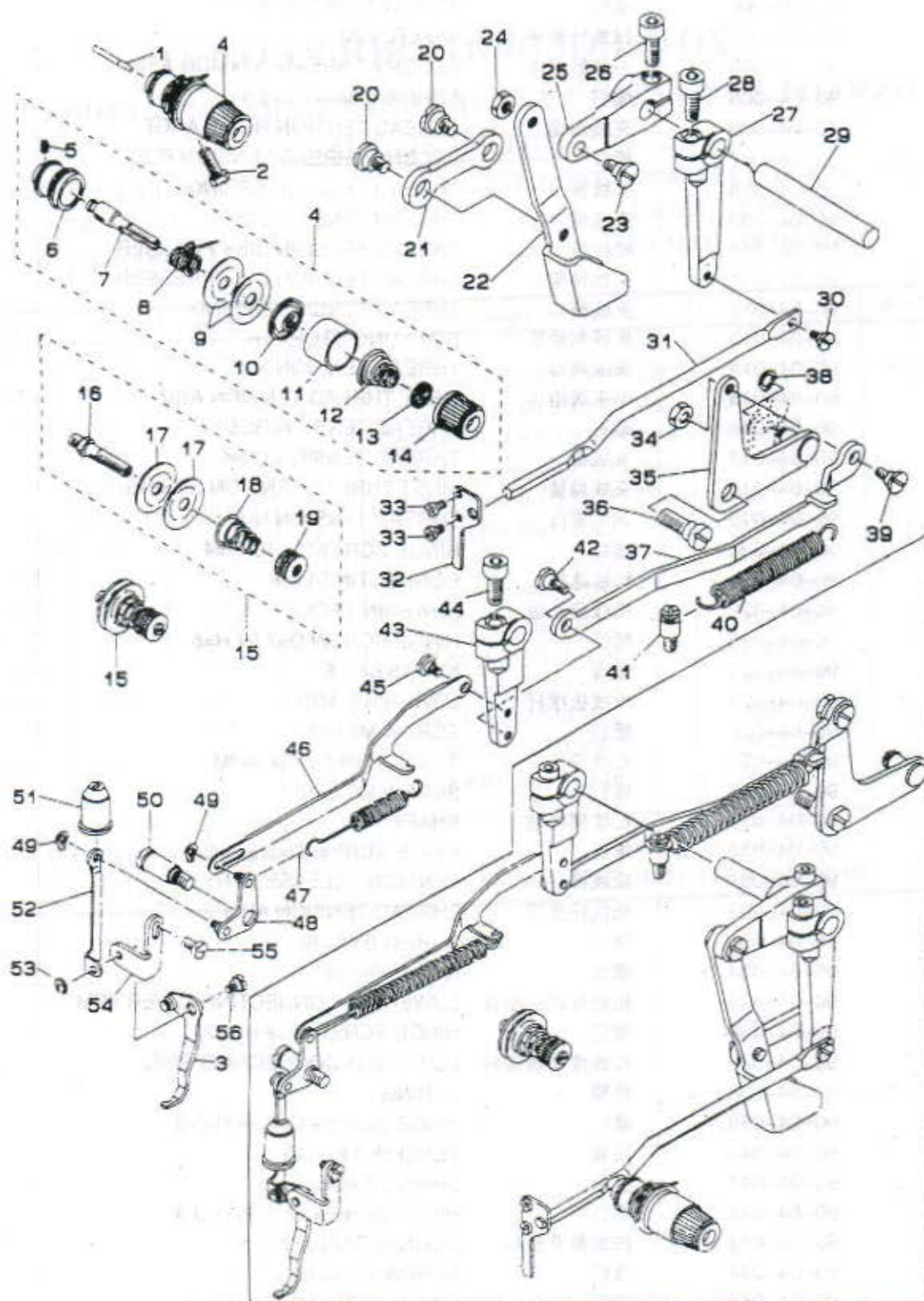
THREAD TENSION RELEASE COMPONENTS



REF No 序号	PART NO 件 号	DESCRIPTION 名 称	Q'TY 数 量
1	90-04-001	松线钉 TENSION RELEASE PIN	1
2	90-04-002	螺钉 SCREW 15/64-28 L=17	1
3	90-04-003	扫线杆组件 WIPER ASM.	1
4	90-04-004	夹线器组件 SECOND THREAD TENSION ASM.	1
5	90-04-005	螺钉 SCREW 9/64-40 L=5.9	1
6	90-04-006	夹线器座 THREAD TENSION ROD. LARGE	1
7	90-04-007	螺钉 SECOND THREAD TENSION ROD	1
8	90-04-008	挑线簧 THREAD TAKE-UP SPRING	1
9	90-04-009	夹线板 THREAD TENSION DISK	2
10	90-04-010	松线板 THREAD TENSION DISK PRESSER	1
11	90-04-011	夹线簧座 THREAD TENSION DISK PRESSER	1
12	90-04-012	夹线簧 THREAD TENSION SPRING	1
13	90-04-013	夹线制动板 ROTATING STOPPER	1
14	90-04-014	夹线螺母 THREAD TENSION NUT	1
15	90-04-015	小夹线组件 FIRST THREAD TENSION ASM.	1
16	90-04-016	螺钉 THREAD TENSION ROD	1
17	90-04-017	夹线板 THREAD TENSION DISK	2
18	90-04-018	夹线器簧 FIRST THREAD TENSION SPRING	1
19	90-04-019	调节螺母 THREAD TENSION NUT	1
20	90-04-020	螺钉 HINGE SCREW D=10 H=4	2
21	90-04-021	松线连杆 CONNECTING LINK	1
22	90-04-022	松线启动板 LOWERING FOOT	1
23	90-04-023	螺钉 HINGE SCREW D=7.94 H=6	1
24	90-04-024	螺母 NUT 15/64-28	1
25	90-04-025	松线板摆杆 LOWERING ARM	1
26	90-04-026	螺钉 SCREW M6 L=18	1
27	90-04-027	松线摆杆 TENSION RELEASE ARM	1
28	90-04-028	螺钉 SCREW M6 L=18	1
29	90-04-029	松线摆杆轴 SHAFT	1
30	90-04-030	螺钉 HINGE SCREW D=5.3 H=2.2	1
31	90-04-031	松线杆 TENSION RELEASE BAR	1
32	90-04-032	松线杆支架 THREAD TENSION ARM	1
33	90-04-033	螺钉 SCREW 9/64-40 L=6.1	2
34	90-04-034	螺母 NUT 15/64-28	1
35	90-04-035	松线传动板组件 LOWERING CONNECTING LEVER ASM.	1
36	90-04-036	螺钉 HINGE SCREW D=9 H=3.2	1
37	90-04-037	松线传动板连杆 LOWERING CONNECTING RING	1
38	90-04-038	挡圈 C-RING	1
39	90-04-039	螺钉 HINGE SCREW D=7.24 H=3.3	1
40	90-04-040	拉簧 TENSION SPRING	1
41	90-04-041	挂销 SPRING PACK	1
42	90-04-042	螺钉 HINGE SCREW D=6.35 H=3.9	1
43	90-04-043	扫线调节连杆 CONNECTING ARM	1
44	90-04-044	螺钉 SCREW M6 L=18	1
45	90-04-045	螺钉 HINGE SCREW D=5.3 H=2.2	1
46	90-04-046	扫线调节杆 WIPER CONNECTING LINK	1

四、扫线部件

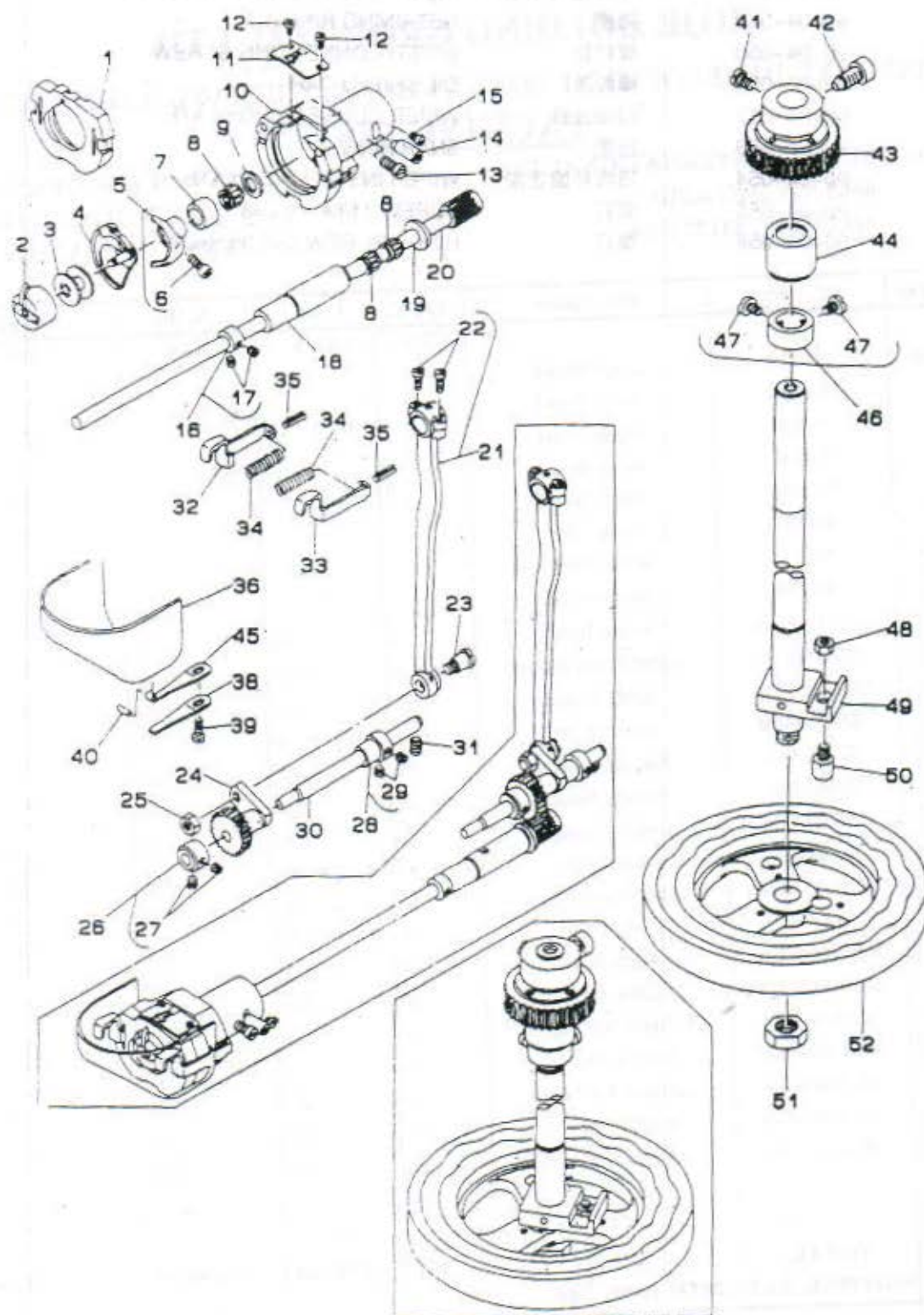
THREAD TENSION RELEASE COMPONENTS



REF No 序号	PART NO 件 号	DESCRIPTION 名 称		Q'TY 数 量
47	90-04-047	拉簧	SPRING	1
48	90-04-048	扫线连接板组件	WIPER CONNECTING ARM ASM.	1
49	90-04-049	挡圈	RETAINING RING 4.7	2
50	90-04-050	螺钉销	WIPER CONNECTING SCREW	1
51	90-04-051	橡胶罩	OIL SHIELD CAP	1
52	90-04-052	扫线拉板	WIPER CONNECTING PLATE	1
53	90-04-053	挡圈	SNAP RING	1
54	90-04-054	扫线杆固定架	WIPER INSTALLING PLATE	1
55	90-04-055	螺钉	SCREW 11/64-40 L=8	1
56	90-04-056	螺钉	HINGE SCREW D=6.35 H=2.1	1

五、下轴部件

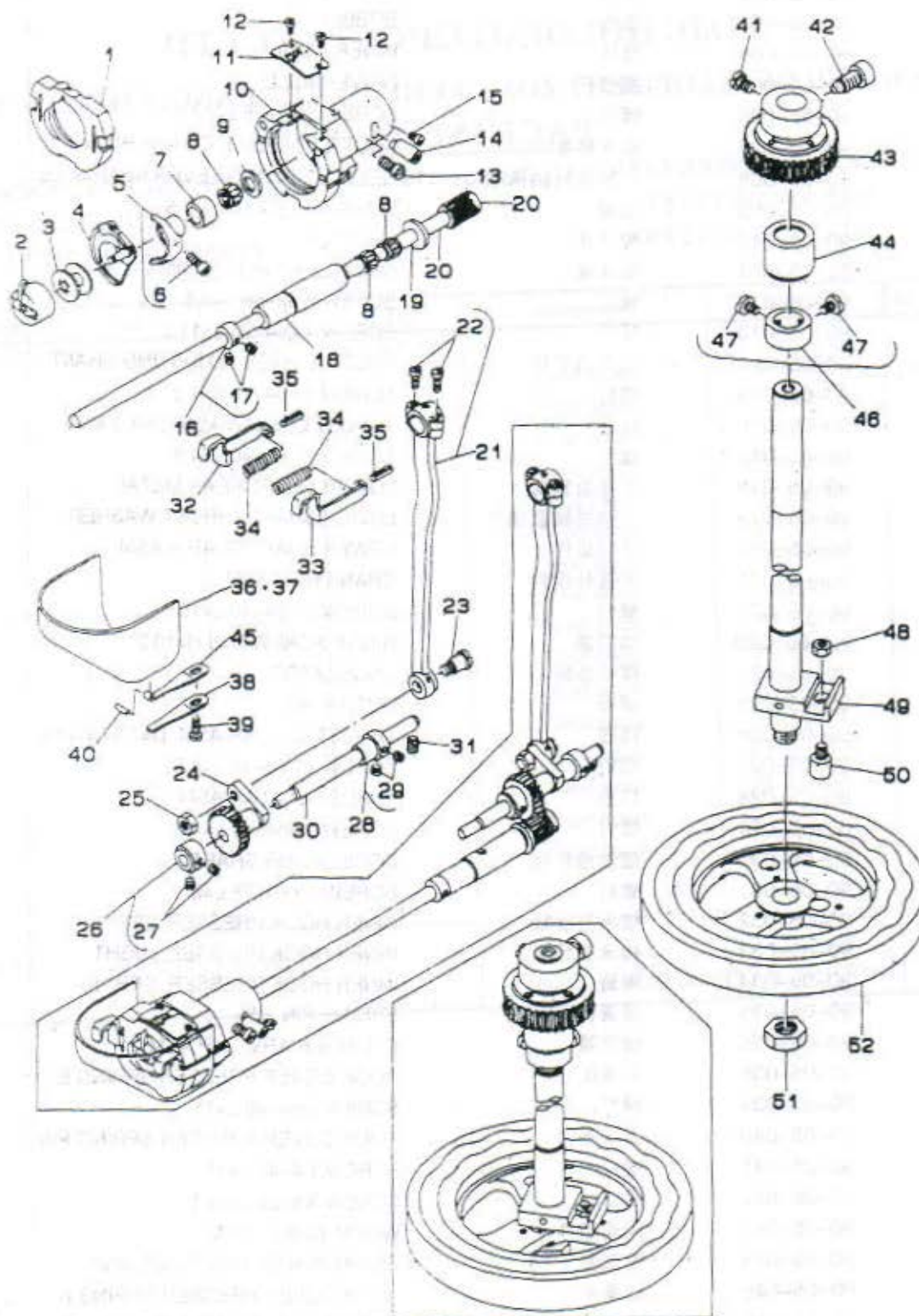
SHUTTLE DRIVER SHAFT COMPONENTS



REF No 序号	PART NO 件 号	DESCRIPTION 名 称		Q'TY 数 量
1	90-05-001	梭床组件	INNER HOOK PRESSER ASM.	1
2	90-05-002	梭壳	BOBBIN CASE ASM.	1
3	90-05-003	梭心	BOBBIN	1
4	90-05-004	摆梭	INNER HOOK	1
5	90-05-005	摆梭托	DRIVER ASM.	1
6	90-05-006	螺钉	SCREW 3/16-28 L=12.0	1
7	90-05-007	梭床轴套	SHUTTLE NEEDLE OUTER RING	1
8	90-05-008	下轴滚针轴承KS081110	NEEDLE DRIVING LEVER BEARING B	3
9	90-05-009	垫圈	WASHER 9.5×14.8×2.6	1
10	90-05-010	梭床体	SHUTTLE	1
11	90-05-011	梭床簧	SHUTTLE UPPER SPRING	1
12	90-05-012	螺钉	SCREW 3/32-56 L=3.5	2
13	90-05-013	螺钉	SCREW 15/64-28 L=11.5	1
14	90-05-014	梭床调节销	SHUTTLE RACE ADJUSTING SHAFT	1
15	90-05-015	螺钉	SCREW 11/64-40 L=4.3	1
16	90-05-016	挡圈	THRUST COLLAR ASM. D=8.0 W=8	1
17	90-05-017	螺钉	SCREW 11/64-40 L=4.5	2
18	90-05-018	下轴后轴套	LOWER SHAFT REAR METAL	1
19	90-05-019	下轴后轴套垫片	LOWER SHAFT THRUST WASHER	1
20	90-05-020	下轴组件	LOWER SHAFT GEAR A ASM.	1
21	90-05-021	大连杆组件	CRANK ROD ASM.	1
22	90-05-022	螺钉	SCREW 11/64-40 L=10.5	2
23	90-05-023	螺钉销	HINGE SCREW D=8 H=10.2	1
24	90-05-024	摆动齿轮	OSCILLATOR	1
25	90-05-025	螺母	NUT 1/4-40	1
26	90-05-026	挡圈	THRUST COLLAR ASM. D=7.94 W=10	1
27	90-05-027	螺钉	SCREW 11/64-40 L=4.5	2
28	90-05-028	挡圈	THRUST COLLAR ASM.	1
29	90-05-029	螺钉	SCREW 11/64-40 L=4.5	2
30	90-05-030	摆动齿轮轴	OSCILLATING SHAFT	1
31	90-05-031	螺钉	SCREW 15/64-28 L=8	1
32	90-05-032	梭床左压板	INNER HOOK PRESSER, LEFT	1
33	90-05-033	梭床右压板	INNER HOOK PRESSER, RIGHT	1
34	90-05-034	弹簧	INNER HOOK PRESSER, SPRING	2
35	90-05-035	弹簧销	SPRING PIN 2.5×16	2
36	90-05-036	梭床罩	CYLINDER ARM CAP ASM.	1
38	90-05-038	弹簧B	HOOK COVER PRESSER SPRING B	1
39	90-05-039	螺钉	SCREW 1/64-40 L=11	1
40	90-05-040	梭床罩销	HOOK COVER PRESSER SPRING PIN	1
41	90-05-041	螺钉	SCREW 1/4-40 L=11	1
42	90-05-042	螺钉	SCREW 3/8-28 L=19.5	1
43	90-05-043	蜗轮组件	WORM WHEEL ASM.	1
44	90-05-044	竖轴套	WORM WHEEL SHAFT BUSHING	1
45	90-05-045	弹簧A	HOOK COVER PRESSER SPRING A	1
46	90-05-046	挡圈	THRUST COLLAR ASM. D=18 W=12	1
47	90-05-047	螺钉	SCREW 1/4-40 L=7	2

五、下轴部件

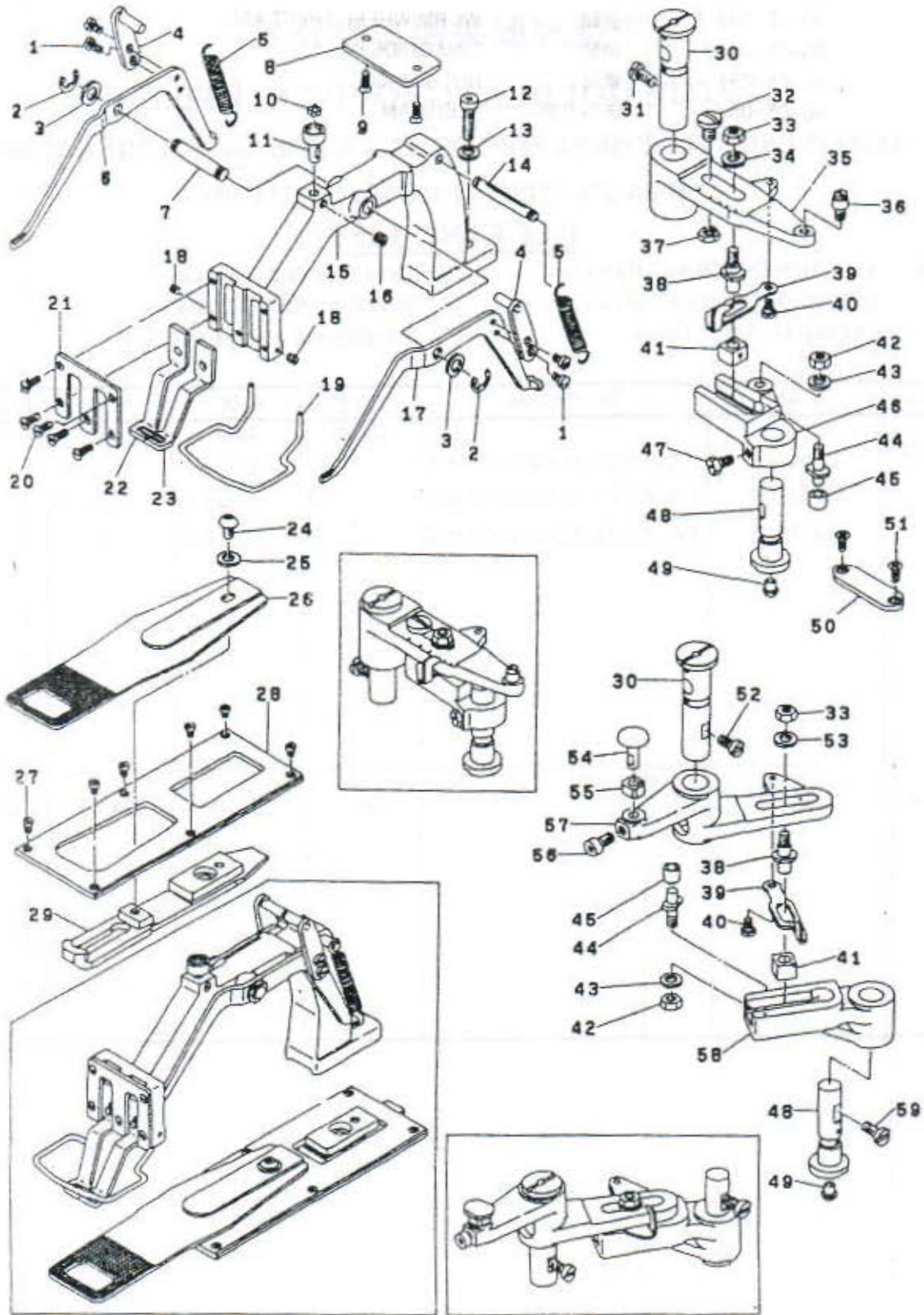
SHUTTLE DRIVER SHAFT COMPONENTS



REF No 序号	PART NO 件 号	DESCRIPTION 名 称		Q'TY 数 量
48	90-05-048	螺母	NUT 1/4	1
49	90-05-049	竖轴	WORM WHEEL SHAFT ASM.	1
50	90-05-050	销轴	CAM GUIDE IN	1
51	90-05-051	螺母	NUT 9/16-20	1
52	90-05-052	送料凸轮	FEED CAM	1

六、送料部件

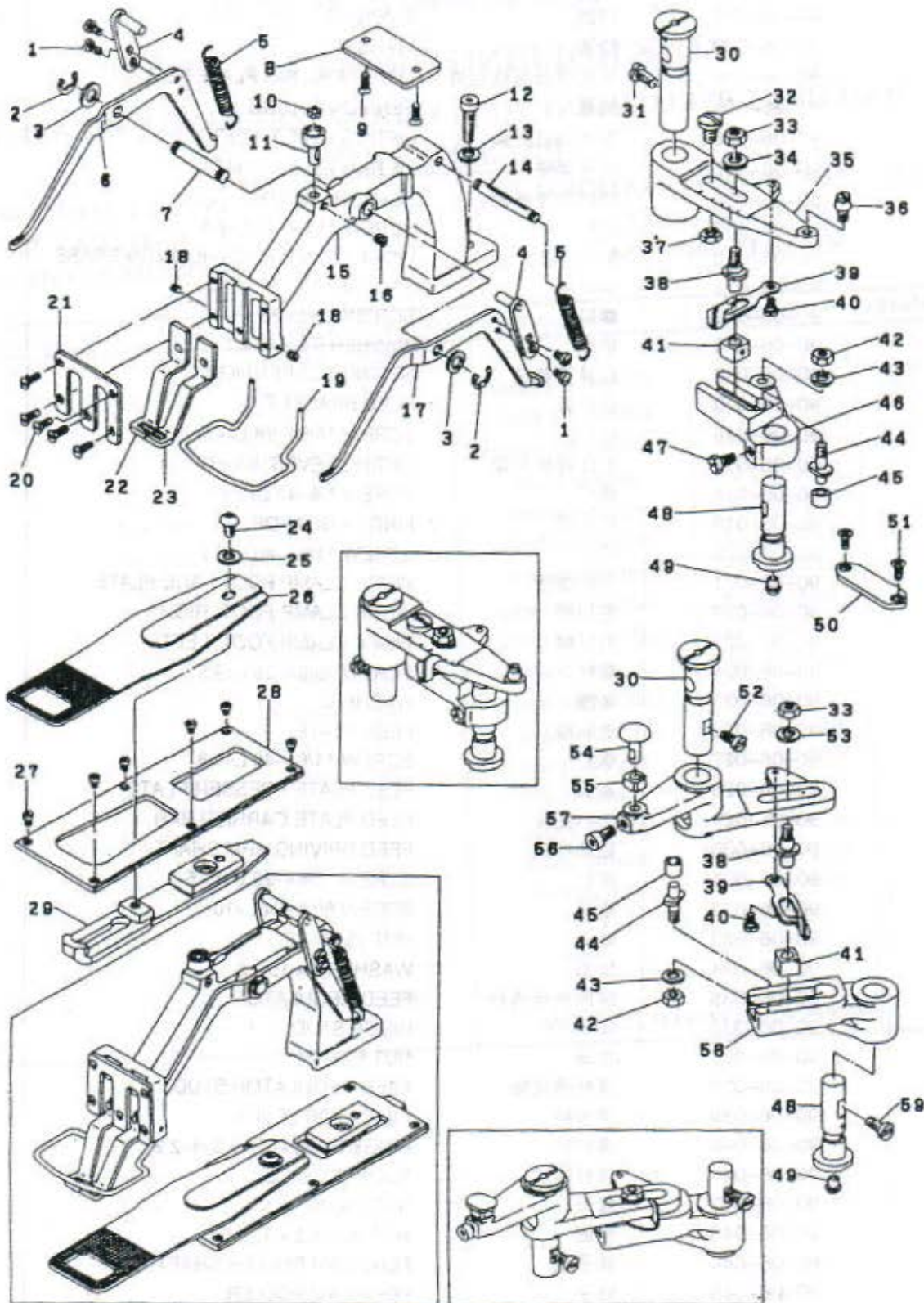
FEED MECHANISM COMPONENTS



REF No 序号	PART NO 件 号	DESCRIPTION 名 称		Q'TY 数量
1	90-06-001	螺钉	SCREW 11/64-40 L=7	4
2	90-06-002	挡圈	E-RING 7	2
3	90-06-003	垫圈	WASHER	2
4	90-06-004	压脚提升导板组件	LEVER DRIVING PLATE ASM.	2
5	90-06-005	拉簧	TENSION SPRING	2
6	90-06-006	左压脚提升架	LIFTING LEVER, LEFT	1
7	90-06-007	提升架轴	LIFTING LEVER SHAFT	1
8	90-06-008	送料架支承板	SUPPORT PLATE	1
9	90-06-009	螺钉	SCREW 11/64-40 L=8.5	2
10	90-06-010	钢球(1/8")	WORK CLAMP FOOT HOUNTING BASE	7
11	90-06-011	钢球座	BALL RETAINER	1
12	90-06-012	螺钉	SCREW M6 L=20	1
13	90-06-013	垫圈	WASHER 6.2 × 13 × 1	1
14	90-06-014	拉簧支轴柱	SPRING SUSPENSION	1
15	90-06-015	送料架	FEED BRACKET	1
16	90-06-016	螺钉	SCREW 15/64-28 L=4.7	1
17	90-06-017	右压脚提升架	LIFTING LEVER, RIGHT	1
18	90-06-018	螺钉	SCREW 1/8-44 L=2.8	2
19	90-06-019	护手圈	FINGER GUARDE	1
20	90-06-020	螺钉	SCREW 11/64-40 L=8.7	5
21	90-06-021	压脚面板	WORK CLAMP FOOT FACE PLATE	1
22	90-06-022	左压脚	WORK CLAMP FOOT, RIGHT	1
23	90-06-023	右压脚	WORK CLAMP FOOT, LEFT	1
24	90-06-024	螺钉	SCREW 15/64-28 L=9.5	1
25	90-06-025	垫圈	WASHER	1
26	90-06-026	送料板	FEED PLATE	1
27	90-06-027	螺钉	SCREW 11/64-40 L=4.8	5
28	90-06-028	盖板	FEED PLATE PRESSER PLATE	1
29	90-06-029	送料托架	FEED PLATE CARRIER BAR	1
30	90-06-030	驱动杆轴	FEED DRIVING ARM SHAFT	2
31	90-06-031	螺钉	SCREW 15/64-28 L=11.5	1
32	90-06-032	螺钉	SCREW 5/16-24 L=10	1
33	90-06-033	螺母	NUT 15/64-28	2
34	90-06-034	垫圈	WASHER 7 × 15 × 2	1
35	90-06-035	纵向进给连杆	FEED REGULATOR	1
36	90-06-036	销	HINGE STUD	1
37	90-06-037	螺母	NUT 5/16-24	1
38	90-06-038	摆杆滑块轴	FEED REGULATOR STUD	2
39	90-06-039	调节板	INDICATOR LEVER	2
40	90-06-040	螺钉轴	HINGE SCREW D=5.3 H=2.2	2
41	90-06-041	摆杆滑块	SLIDE BLOCK B	2
42	90-06-042	螺母	NUT 1/4-40	2
43	90-06-043	垫圈	WASHER 6.5 × 13 × 0.8	2
44	90-06-044	转子轴	FEED CAM ROLLER SHAFT	2
45	90-06-045	转子	FEED CAM ROLLER	2
46	90-06-046	纵向进给摆杆	FEED DRIVING ARM	1

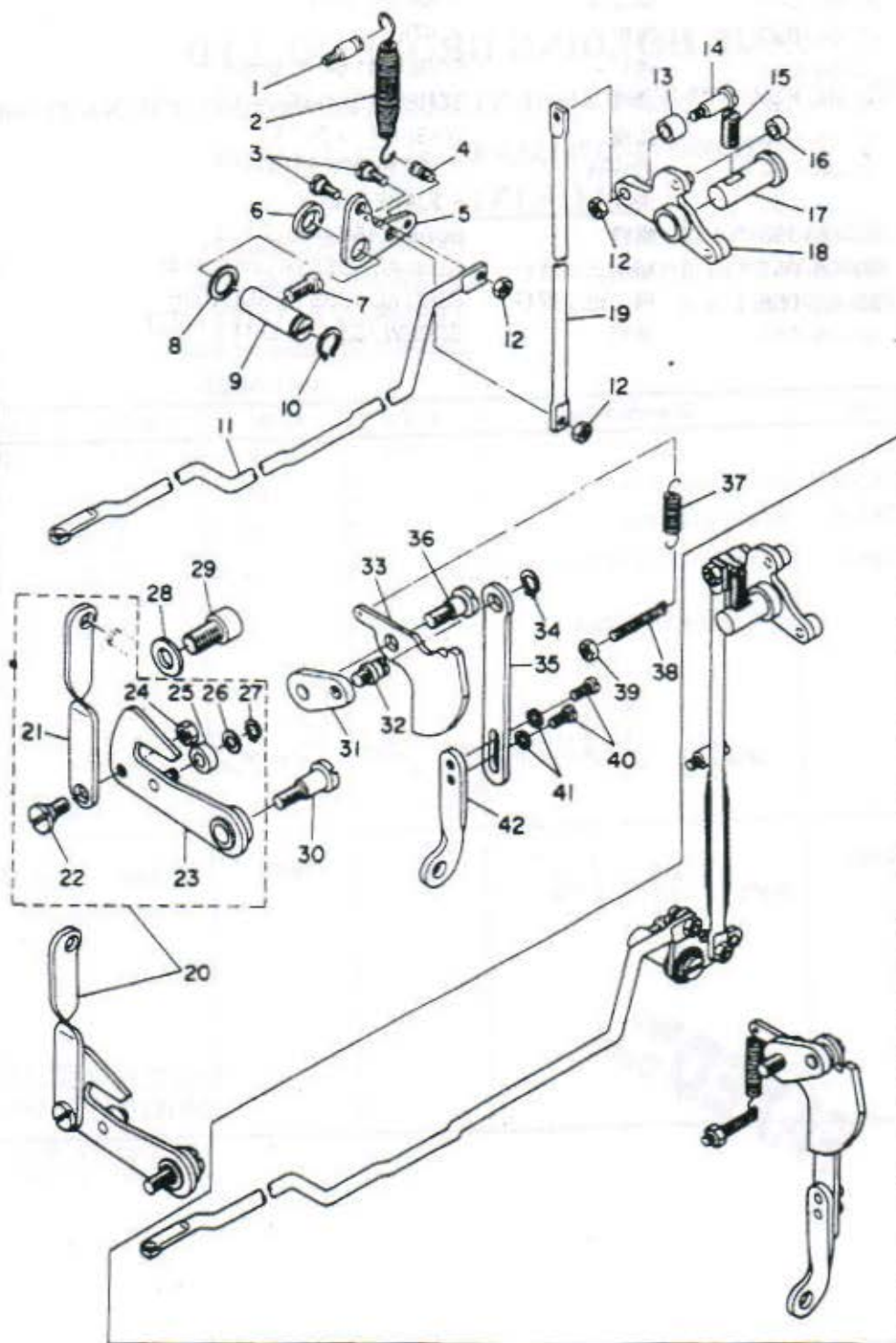
六、送料部件

FEED MECHANISM COMPONENTS



REF No 序号	PART NO 件 号	DESCRIPTION 名 称		Q'TY 数 量
47	90-06-047	螺钉	SCREW 15/64-28 L=14	1
48	90-06-048	摆杆轴	FEED REGULATOR SHAFT	2
49	90-06-049	橡胶堵	RUBBER PLUG	2
50	90-06-050	拖板	PLATE	1
51	90-06-051	螺钉	SCREW 11/64-40 L=8.3	2
52	90-06-052	螺钉	SCREW 15/64-28 L=11.5	1
53	90-06-053	垫圈	WASHER 7 x 20 x 4.5	1
54	90-06-054	滑块轴	SLIDE BLOCK STUD	1
55	90-06-055	滑块	SQUARE BLOCK	1
56	90-06-056	螺钉	SCREW 15/64-28 L=10.5	1
57	90-06-057	横向进给连杆	FEED ACROSS DRIVING ARM	1
58	90-06-058	横向进给摆杆	FEED ACROSS REGULATOR	1
59	90-06-059	螺钉	SCREW 15/64-28 L=11.5	1

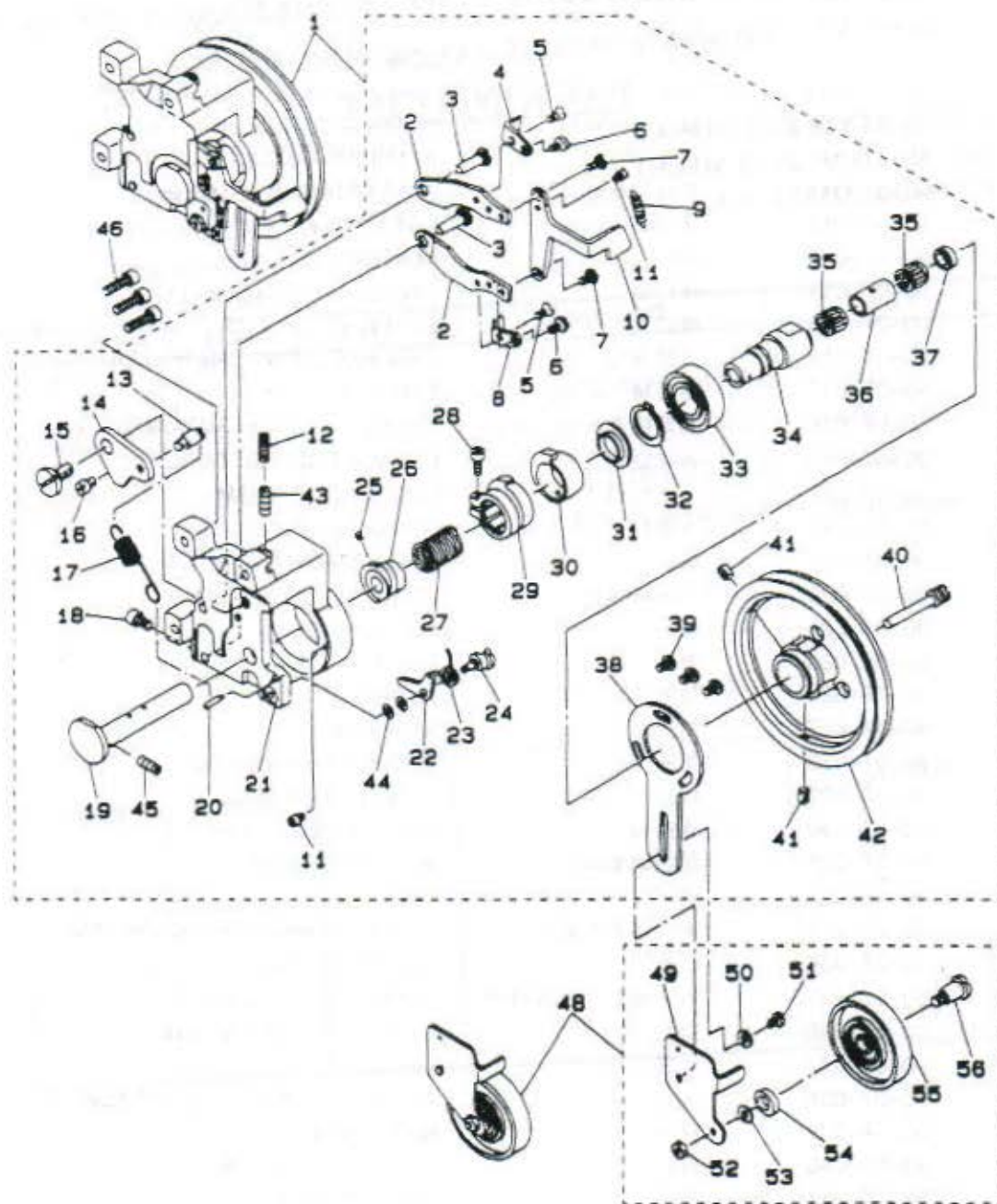
七、剪线部件 THREAD TRIMMING COMPONENTS



REF No 序号	PART NO 件 号	DESCRIPTION 名 称		Q'TY 数 量
1	90-07-001	柱销A	TENSION SPRING RACK B	1
2	90-07-002	拉簧	TENSION SPRING	1
3	90-07-003	螺钉	HINGE SCREW D=6.5 H=3	2
4	90-07-004	柱销B	THREAD CUTTING LINK SPRING RAC	1
5	90-07-005	剪线连接板组件	THREAD CUTTING LINK	1
6	90-07-006	挡圈	THREAD CUTTING RING	1
7	90-07-007	螺钉	SCREW 15/64-28 L=14	1
8	90-07-008	垫圈	THREAD CUTTING LINK WASHER	1
9	90-07-009	剪线连接板轴	THREAD CUTTING LINK SHAFT	1
10	90-07-010	挡圈	RETAINING RING 10.2	1
11	90-07-011	剪线刀传动杆	CONNECTING ROD. LARGE	1
12	90-07-012	螺母	NUT 3/16-28	3
13	90-07-013	滚柱	ROLLER	1
14	90-07-014	螺钉销	HINGE SCREW D=6.5 H=13	1
15	90-07-015	螺钉	SCREW 9/32-28 L=19	1
16	90-07-016	摇臂滚柱	THREAD CUTTING CAM ROLLER	1
17	90-07-017	摇臂销	CAM STUD	1
18	90-07-018	摇臂组件	THREAD CUTTING CAM COMPL.	1
19	90-07-019	剪线驱动立杆	COMMECTING ROD. SMALL	1
20	90-07-020	下连杆组件	LOWERING LINK ASM.	1
21	90-07-021	下连杆	LOWERING LINK	1
22	90-07-022	螺钉	HINGE SCREW D=7.94 H=4	1
23	90-07-023	下摆杆组件	LOWERING LEVER ASM.	1
24	90-07-024	螺母	NUT 15/64-28	1
25	90-07-025	滚柱	ROLLER	1
26	90-07-026	垫圈	WASHER	1
27	90-07-027	挡圈	STOP RING	1
28	90-07-028	垫圈	WASHER 9.8×24.0×2.6	1
29	90-07-029	螺钉	SCREW 3/8-28 L=14.5	1
30	90-07-030	螺钉轴	HINGE SCREW D=9 H=11	1
31	90-07-031	剪线辅助连杆	AUXILIARY LEVER	1
32	90-07-032	螺钉	SHAFT	1
33	90-07-033	剪线辅助凸轮	THREAD TRIMMING AUXILIARY CAM	1
34	90-07-034	挡圈	RETAINING RING	1
35	90-07-035	剪线辅助凸轮连接板	CONNECTING PLATE B	1
36	90-07-036	螺钉	HINGE SCREW D=7.94 H=8	1
37	90-07-037	拉簧	SPRING	1
38	90-07-038	挂销	TNESION SPRING ADJUSTING SCREW	1
39	90-07-039	螺母	NUT 11/64-40	1
40	90-07-040	螺钉	SCREW 11/64-40 L=8.5	2
41	90-07-041	垫圈	WASHER 4.8×8.4×0.8	2
42	90-07-042	剪线辅助凸轮连接弯板	CONNECTING PLATE A	1

八、联动控制部件

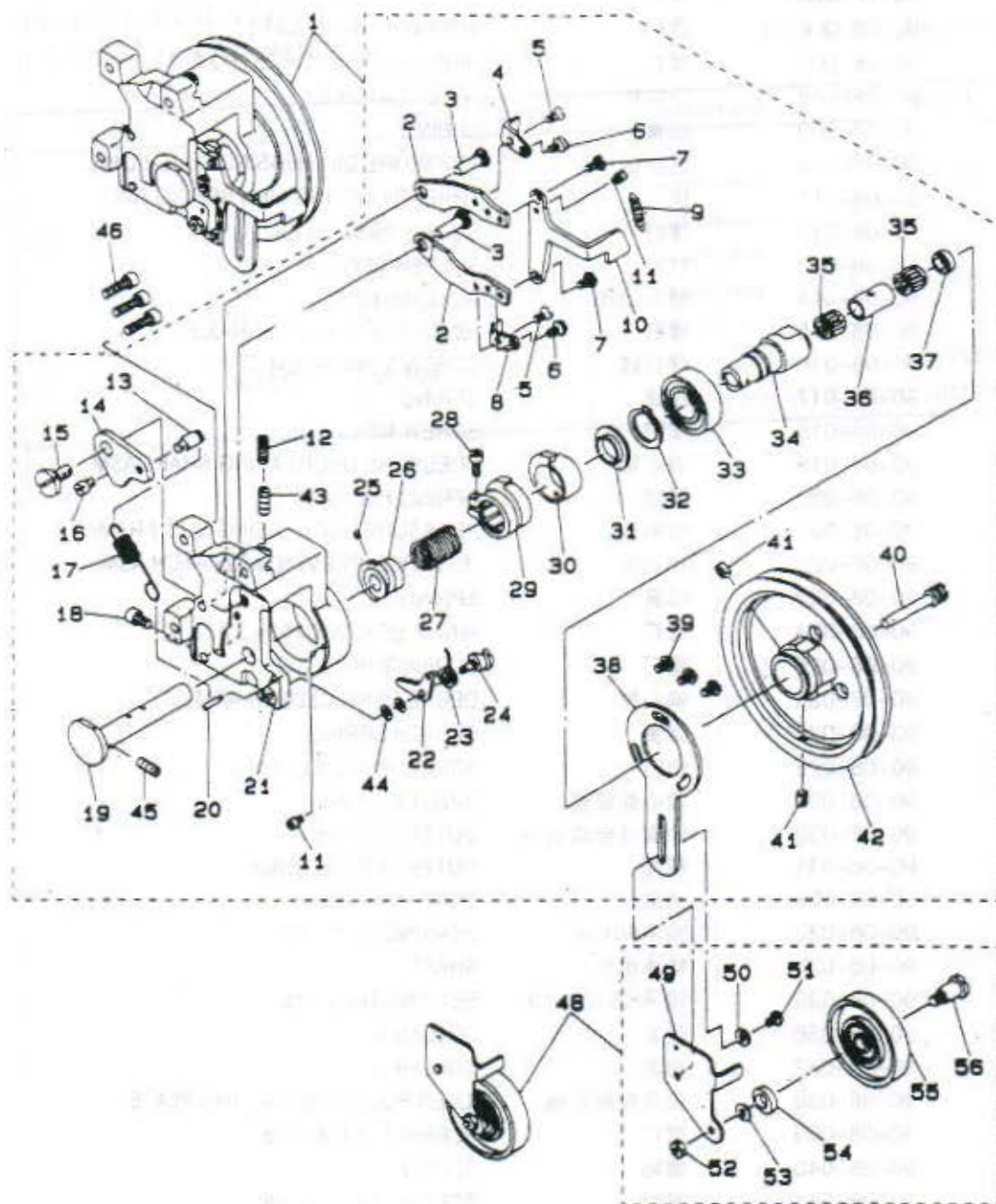
PEDAL PRESSURE DECREASING UNIT COMPONENTS



REF No 序号	PART NO 件 号	DESCRIPTION 名 称		Q'TY 数 量
1	90-08-001	联动组件	PRESSURE DECREASING DEVICE	1
2	90-08-002	联板	PRESSURE DECREASING LEVER	2
3	90-08-003	联板销	STUD	2
4	90-08-004	上挡板	LEVER LATCH A	1
5	90-08-005	螺钉	SCREW 11/64-40 L=8.5	2
6	90-08-006	螺钉	SCREW 11/64-40 L=8.5	2
7	90-08-007	螺钉	HINGE SCREW D=6.35 H=3.2	2
8	90-08-008	下挡板	LEVER LATCH B	1
9	90-08-009	拉簧	SPRING	1
10	90-08-010	连接板	PRESSURE DECREASING LEVER LINK	1
11	90-08-011	销	THREAD CUTTING LINK SPRING RAC	2
12	90-08-012	螺钉	SCREW 15/64-28 L=7	1
13	90-08-013	柱销	SUSPENSION PIN	1
14	90-08-014	辅助凸轮	AUXILIARY CAM	1
15	90-08-015	螺钉	HINGE SCREW D=7.24 H=3.3	1
16	90-08-016	螺钉轴	SCREW 11/64-40 L=6.5	1
17	90-08-017	拉簧	SPRING	1
18	90-08-018	螺钉	SCREW M6 L=10	1
19	90-08-019	偏心轴	PRESSURE DECREASING SHAFT ASM.	1
20	90-08-020	簧销	SPRING PIN 3 x 16	1
21	90-08-021	控制架	PRESSURE DECREASING NUT FRAME	1
22	90-08-022	止动板	ROTATION PREVENTING LATCH ASM.	1
23	90-08-023	扭簧	SPRING	1
24	90-08-024	螺钉	HINGE SCREW D=6 H=3.2	1
25	90-08-025	螺钉	SCREW 3/16-32 L=6	1
26	90-08-026	偏心轮	DECREASING CLUTCH ASM.	1
27	90-08-027	弹簧	CLUTCH SPRING	1
28	90-08-028	螺钉	SCREW M5 x 0.8 L=12	1
29	90-08-029	偏心轮紧圈	INNER SLEEVE	1
30	90-08-030	外套结合体组件	OUTER SLEEVE	1
31	90-08-031	挡圈	OUTER SLEEVE GUIDE	1
32	90-08-032	挡圈	SNAP RING 18.5	1
33	90-08-033	轴承80104	BEARING D=20 x 42	1
34	90-08-034	轴承组件	SHAFT	1
35	90-08-035	轴承KS121513	BEARING D=12 x 15	2
36	90-08-036	隔套	COLLAR A	1
37	90-08-037	挡套	COLLAR B	1
38	90-08-038	皮带轮固定板	IDLER PULLEY INSTALLING PLATE	1
39	90-08-039	螺钉	SCREW 11/64-40 L=8	3
40	90-08-040	螺轴	SCREW	1
41	90-08-041	螺钉	SCREW 15/64-28 L=8	2
42	90-08-042	皮带轮	DRIVING PULLEY	1
43	90-08-043	螺钉	SCREW 15/64-28 L=15	1
44	90-08-044	垫圈	WASHER 4.8 x 11.5 x 2	2
45	90-08-045	销	SCREW 3/16-32 L=8.0	1
46	90-08-046	螺钉	SCREW M6 L=20	3

八、联动控制部件

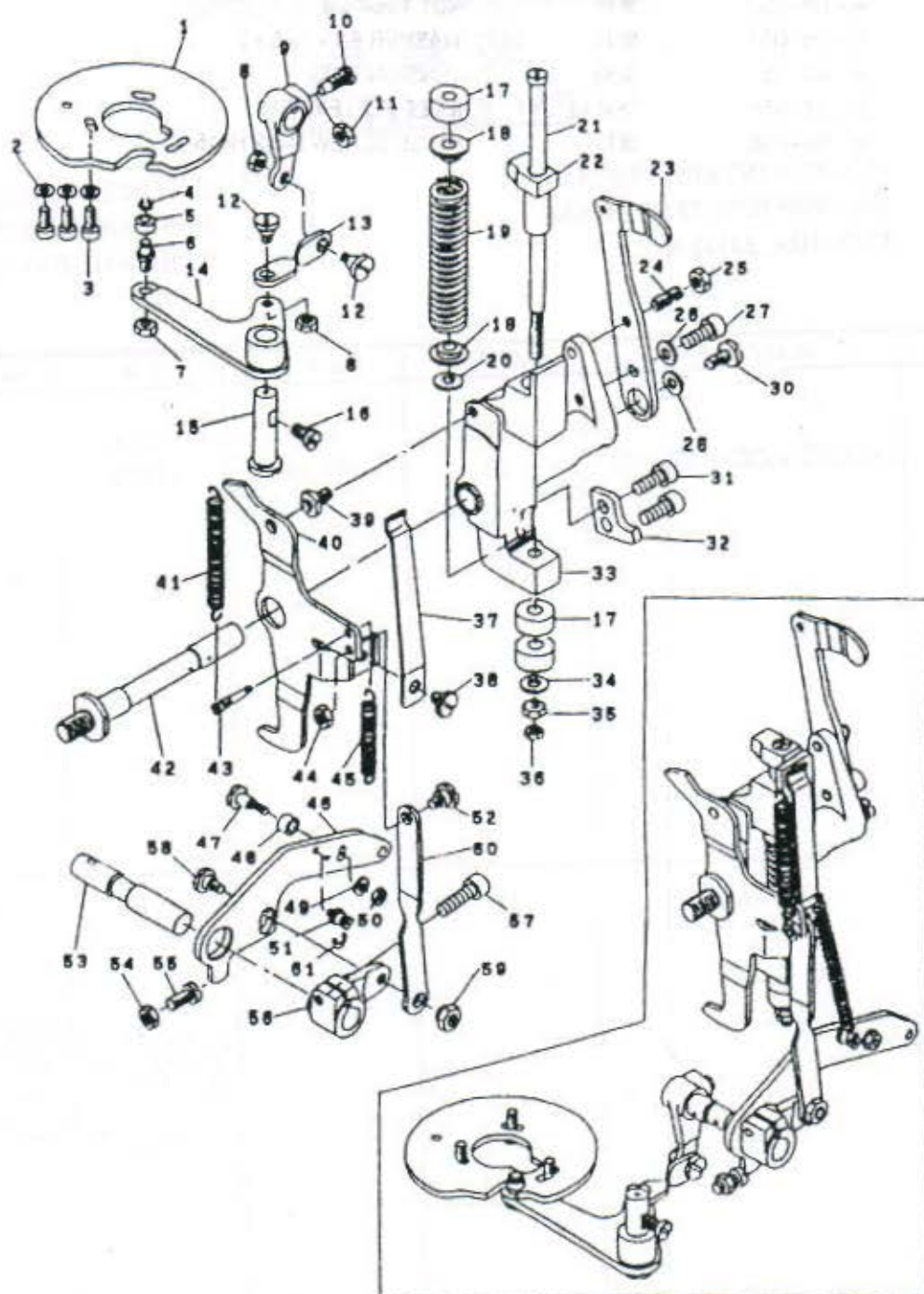
PEDAL PRESSURE DECREASING UNIT COMPONENTS



REF NO 序号	PART NO 零件号	HR DEVICE	DESCRIPTION 名称	Q'TY 数量
48	90-08-048	空转轮组件	IDLER PULLEY ASM.	1
49	90-08-049	托架	IDLER PULLEY BRACKET	1
50	90-08-050	垫圈	WASHER 6.2 x 13 x 1	1
51	90-08-051	螺钉	SCREW 15/64-28 L=6.5	1
52	90-08-052	螺母	NUT 15/64-28	1
53	90-08-053	垫片	WASHER 6.1 x 18.5 x 2	1
54	90-08-054	垫圈	TENSION RING	1
55	90-08-055	涨紧轮	IDLER PULLEY ASM.	1
56	90-08-056	螺钉	HINGE SCREW D=12 H=15	1

九、起动停车部件

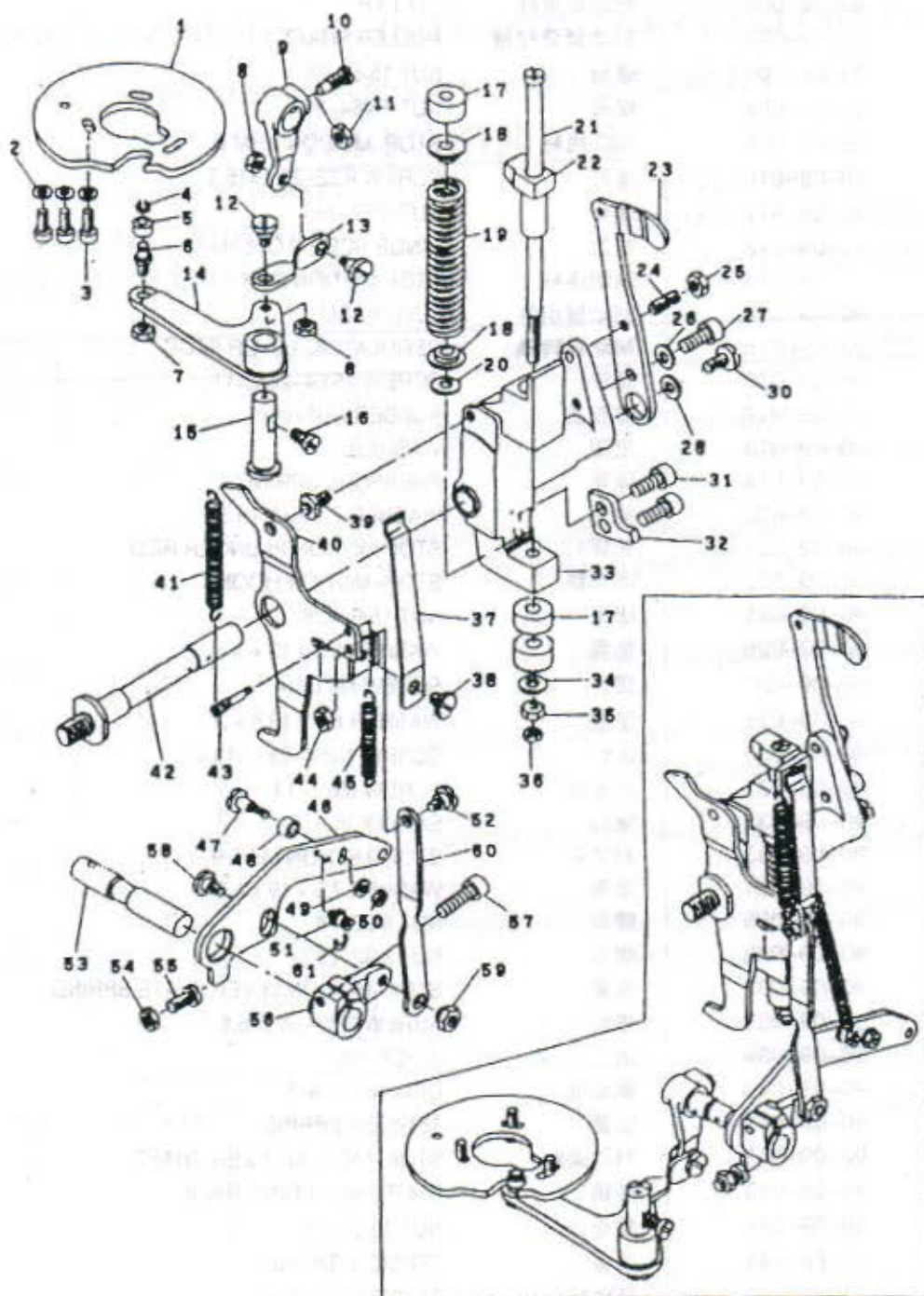
STOP-MOTION MECHANISM COMPONENTS



REF No 序号	PART NO 件 号	DESCRIPTION 名 称		Q'TY 数量
1	90-09-001	制动变速凸轮	STOP-MOTION REGULATING CAM	1
2	90-09-002	垫圈	WASHER 4.8×8.4×0.8	3
3	90-09-003	螺钉	SCREW 3/16-28 L=12.0	3
4	90-09-004	挡圈	RETAINING RING 4.7	1
5	90-09-005	制动臂滚柱	COLLAR	1
6	90-09-006	制动臂滚柱轴	ROLLER SHAFT	1
7	90-09-007	螺母	NUT 15/64-28	1
8	90-09-008	螺母	NUT 15/64-28	2
9	90-09-009	制动摆杆	STOP-MOTION ARM B	1
10	90-09-010	螺钉	SCREW 9/32-28 L=16.5	1
11	90-09-011	螺母	NUT 9/32-28	1
12	90-09-012	螺钉	HINGE SCREW D=8 H=4	2
13	90-09-013	制动连杆	STOP MOTION LINK	1
14	90-09-014	制动臂组件	LEVER ASM.	1
15	90-09-015	制动臂转轴	REGULATING LEVER STUD	1
16	90-09-016	螺钉	SCREW 15/64-28 L=11	1
17	90-09-017	橡胶垫	RUBBER CUSHION	3
18	90-09-018	垫圈	WASHER	2
19	90-09-019	弹簧	PRESSURE SPRING	1
20	90-09-020	垫片	WASHER 7.5×19×1.5	1
21	90-09-021	长螺钉	STOP MOTION PLUNGER ROD	1
22	90-09-022	停车块	STOP-MOTION HOOK	1
25	90-09-025	螺母	NUT 15/64-28	1
26	90-09-026	垫圈	WASHER 6.2×13×1	1
27	90-09-027	螺钉	SCREW M6 L=14	1
28	90-09-028	垫圈	WASHER 6.1×18.5×2	1
30	90-09-030	螺钉	SCREW 15/64-28 L=13.0	1
31	90-09-031	安全板	SCREW M6 L=14	1
32	90-09-032	螺钉	SAFETY PLATE	2
33	90-09-033	制动架	STOP-MOTION LEVER	1
34	90-09-034	垫圈	WASHER 7.5×19×1.5	1
35	90-09-035	螺母	NUT 9/32-28	1
36	90-09-036	螺母	NUT 9/32-28	1
37	90-09-037	板簧	STOP-MOTION LEVER PLATE SPRING	1
38	90-09-038	螺钉	SCREW 9/32-28 L=6.8	1
39	90-09-039	销	GUIDE PIN	1
40	90-09-040	驱动板	DRIVING PLATE	1
41	90-09-041	拉簧	TENSION SPRING	1
42	90-09-042	制动架轴	STOP-MOTION LEVER SHAFT	1
43	90-09-043	挂销	STARTING SPRING RACK	1
44	90-09-044	螺母	NUT 15/64-28	1
45	90-09-045	拉簧	TENSION SPRING	1
46	90-09-046	起动机杆	STARTING LEVER	1
47	90-09-047	螺钉	HINGE SCREW D=6.35 H=8.0	1
48	90-09-048	起动机杆滑套	SLIDE ROLLER	1
49	90-09-049	垫圈	WASHER 4.8×8.4×0.8	1

九、起动停车部件

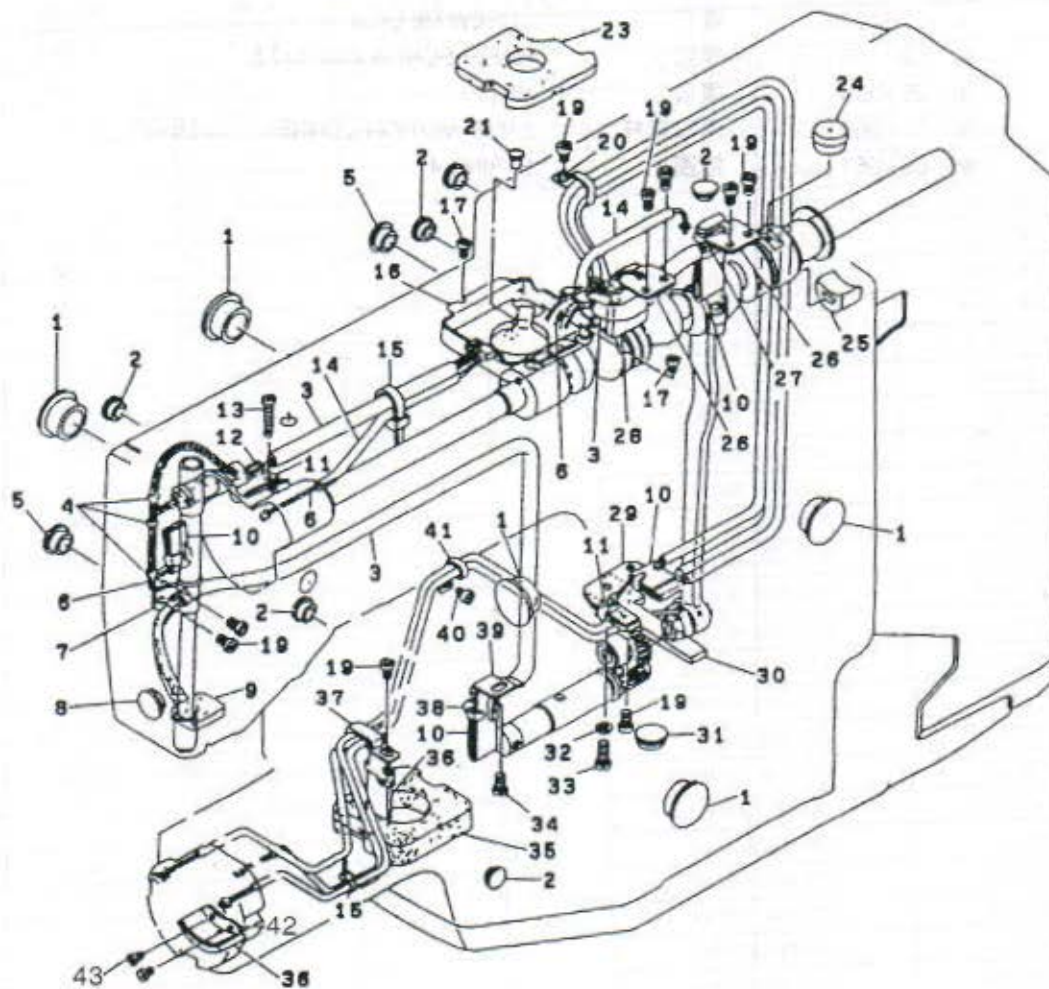
STOP-MOTION MECHANISM COMPONENTS



REF No 序号	PART NO 件 号	DESCRIPTION 名 称		Q'TY 数 量
50	90-09-050	螺母	NUT 11/64-40	1
51	90-09-051	螺钉	SUSPENSION SCREW	1
52	90-09-052	螺钉	HINGE SCREW D=8 H=4	1
53	90-09-053	连接轴	STOP-MOTION ARM SHAFT	1
54	90-09-054	螺母	NUT 15/64-28	1
55	90-09-055	螺钉	SCREW 15/64-28 L=14	1
56	90-09-056	起动摆杆	STOP-MOTION ARM A	1
57	90-09-057	螺钉	SCREW M6 L=20	1
58	90-09-058	螺钉	HINGE SCREW D=8 H=3.5	1
59	90-09-059	螺母	NUT	1
60	90-09-060	停车连杆	STOP-MOTION CONNECTING LEVER	1
61	90-09-061	挡圈	E-RING 4	1

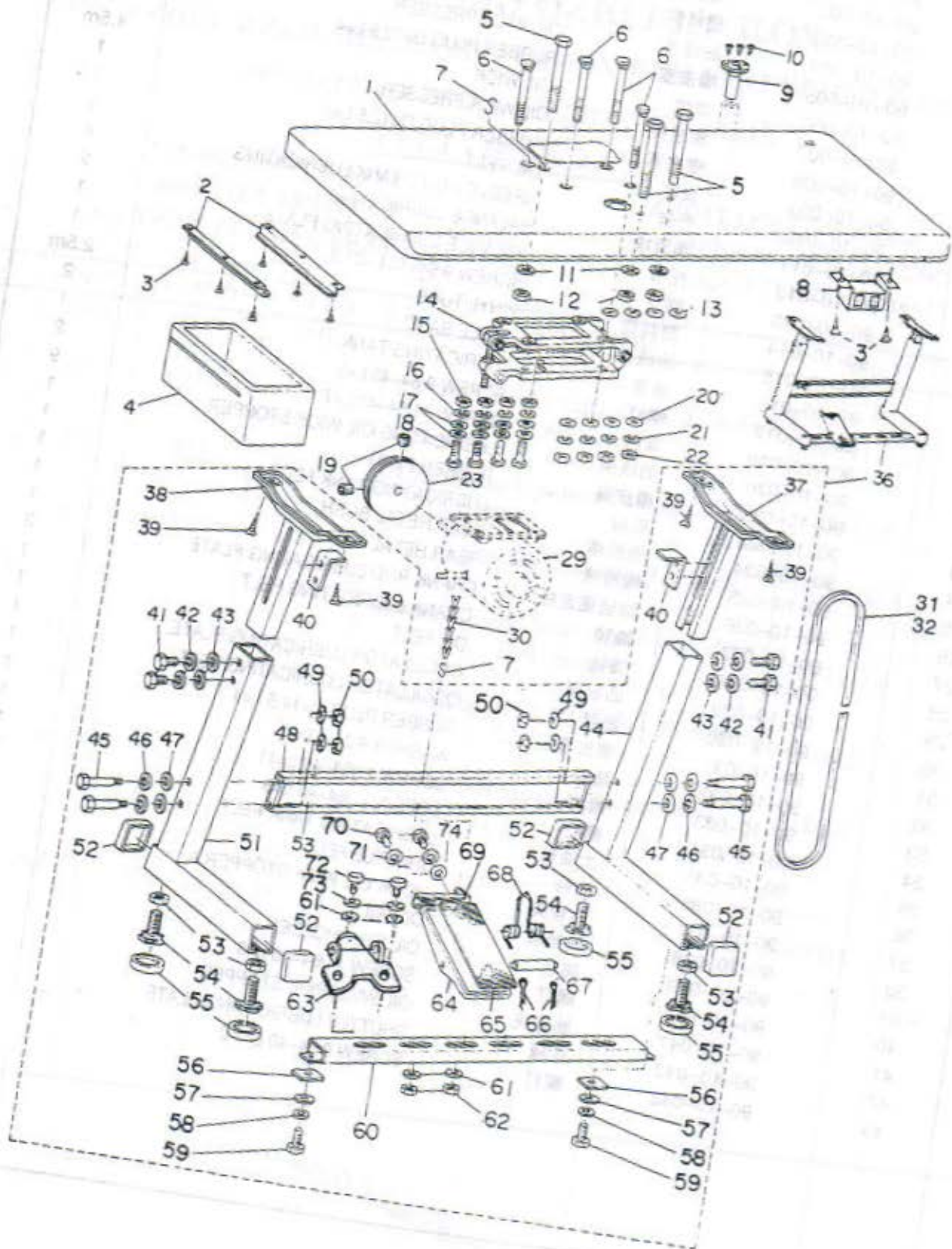
十、润滑部件

LUBRICATION MECHANISM COMPONENTS



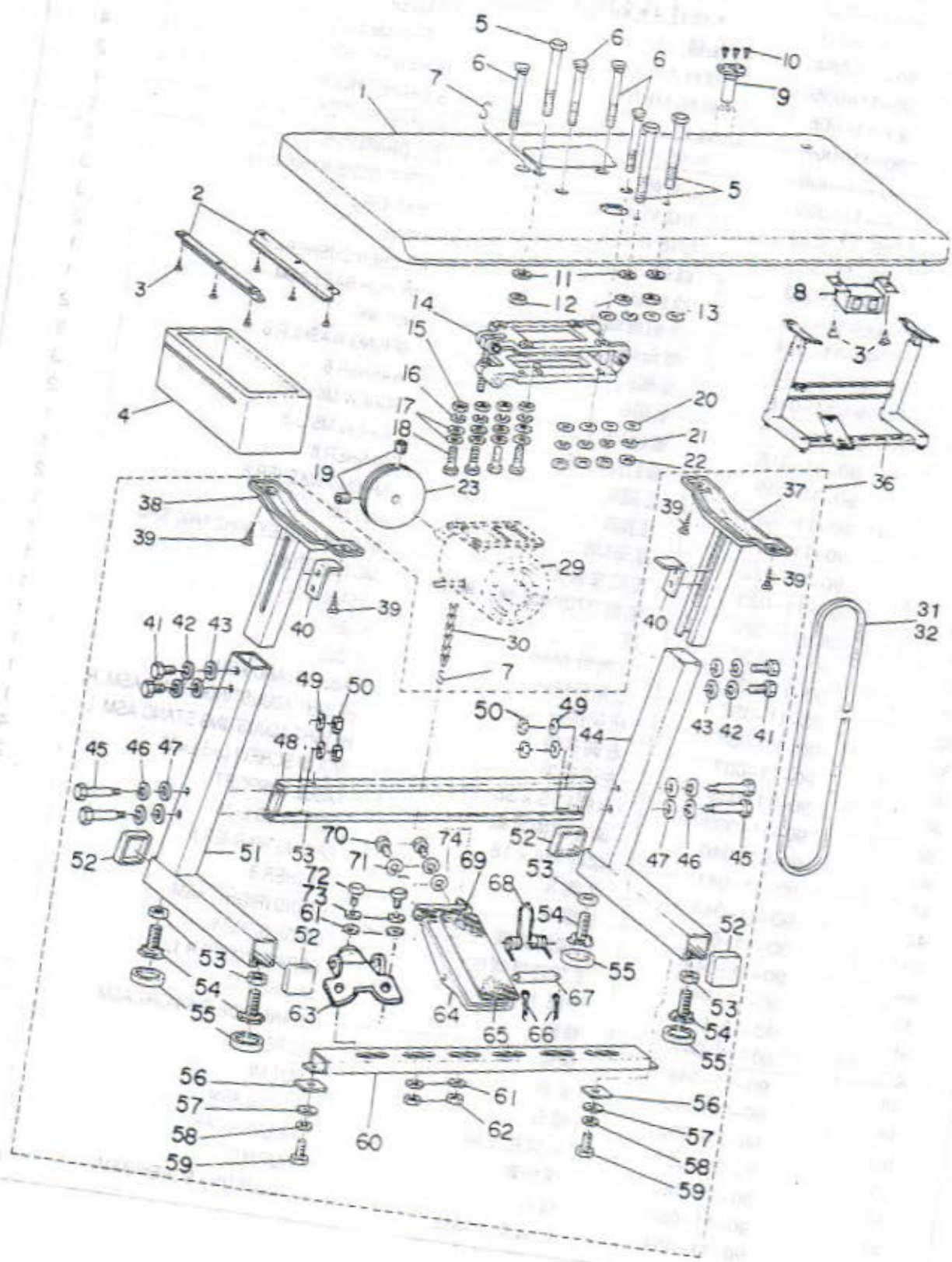
REF No 序号	PART NO 件 号	DESCRIPTION 名 称	Q'TY 数量
1	90-10-001	橡皮塞 RUBBER PLUG	5
2	90-10-002	橡皮塞 RUBBER PLUG	6
3	90-10-003	塑料管 VINYL PIPE	0.7m
4	90-10-004	油线卡 OIL WICK PRESSER	3
5	90-10-005	橡皮塞 RUBBER PLUG D=12.5 L=4	2
6	90-10-006	油线 OIL WICK	4.5m
7	90-10-007	油线夹 OIL WICK PRESSER	1
8	90-10-008	橡皮塞 RUBBER PLUG D=12.5 L=4	1
9	90-10-009	油毡 OIL FELT	1
10	90-10-010	毛毡 NEEDLE ROD CRANK LUBRICATING	4
11	90-10-011	润滑块 BALANCE LUBRICATING	2
12	90-10-012	托板 BALANCE LUBRICATING PLATE	1
13	90-10-013	螺钉 SCREW 9/64-40 L=21.2	1
14	90-10-014	塑料管 VINYL TUBE	2.5m
15	90-10-015	油线夹 CABLE BAND	2
16	90-10-016	油盒 LUBRICATING TANK	1
17	90-10-017	螺钉 SCREW 9/64-40 L=5	2
19	90-10-019	螺钉 SCREW 11/64-40 L=7	9
20	90-10-020	油线夹 LUBRICATING OIL WICK STOPPER	1
21	90-10-021	橡皮塞 RUBBER PLUG	1
23	90-10-023	毛毡 LUBRICATING TANK FELT	1
24	90-10-024	橡胶堵 REAR HETAL BUSH	1
25	90-10-025	橡胶堵 REAR HETAL BUSH	1
26	90-10-026	油毡固定板 CRANK ROD LUBRICATING PLATE	2
27	90-10-027	油毡 CRANK LUBRICATING FELT	1
28	90-10-028	油毡 OIL FELT	1
29	90-10-029	油毡座 OSCILLATOR LUBRICATING PLATE	1
30	90-10-030	油毡 OSCILLATOR LUBRICATING FELT	1
31	90-10-031	橡皮塞 RUBBER PLUG D=14.5 L=4	1
32	90-10-032	垫圈 WASHER 6.2×13×1	1
33	90-10-033	螺钉 SCREW 11/64-40 L=11	1
34	90-10-034	螺钉 SCREW 11/64-40 L=5	1
35	90-10-035	大油毡 LUBRICATING TANK FELT	1
36	90-10-036	油毡 SHUTTLE FELT	2
37	90-10-037	油管夹 HOOK OIL WICK STOPPER A	1
38	90-10-038	油毡座 OIL WICK	1
39	90-10-039	油毡 OIL FELT HOLDER	1
40	90-10-040	螺钉 SCREW 11/64-40 L=5	1
41	90-10-041	油管夹 OIL WICK PIPE STOPPER	1
42	90-10-042	压板 SHUTTLE LUBRICATING PLATE	1
43	90-10-043	螺钉 SCREW 9/64-40 L=4.0	2

11. 机架台板、三角带传动部分 TABLE COMPONENTS



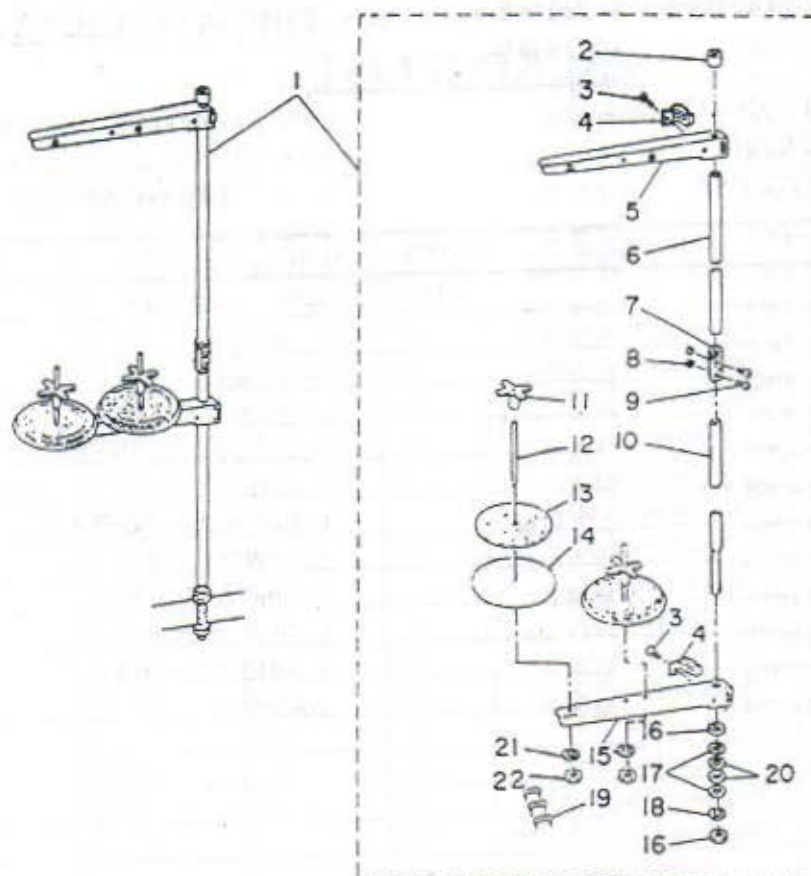
REF No 序号	PART NO 件 号	DESCRIPTION 名 称	Q'TY 数 量	
1	90-11-001	台板	TABLE	1
2	90-11-002	抽屉固定架	DRAWER SUPPORT	2
3	90-11-003	木螺钉 4 × 20	WOOD SCREW D=4 L=20	8
4	90-11-004	抽屉	DRAWER	1
5	90-11-005	螺栓 M6 × 70	SCREW M6 L=70	3
6	90-11-006	螺栓 M870	SCREW M8 L=70	4
7	90-11-007	挂勾	S SHAPED HOOK	2
8	90-11-008	开关	MOTOR SWITCH	1
9	90-11-009	排油管	OIL DRAIN PIPE	1
10	90-11-010	木螺钉 4 × 12	WOOD SCREW D=4 L=12	2
11	90-11-011	垫圈 6	WASHER 6	3
12	90-11-012	螺母M6	NT M6	3
13	90-11-013	橡胶垫	RUBBER CUSHION	2
14	90-11-014	电机座组件	MOTOR BASE ASM.	1
15	90-11-015	螺母M6	NUT M6	1
16	90-11-016	垫圈6	SPRING WASHER 6	2
17	90-11-017	垫圈6	WASHER 6	3
18	90-11-018	螺栓M6 × 30	SCREW M6 L=30	3
19	90-11-019	螺钉M6 × 8	SCREW M6 L=8	2
20	90-11-020	垫圈8	WASHER 8	1
21	90-11-021	垫圈8	SPRING WASHER 8	1
22	90-11-022	螺母M8	NUT M8	2
23	90-11-023	电机皮带轮	MOTOR PULLEY 50HZ 1800 SPM	1
29	90-11-029	电机 370W(三相、单相)	MOTOR 370W	1
30	90-11-030	链	CHAIN	1
31	90-11-031	三角带 M46	V-BELT	1
32	90-11-032	三角带M49	V-BELT	1
36	90-11-036	机架部分	TABLE STAND ASM.	1
37	90-11-037	右调节架	HEIGHT ADJUSTING STAND ASM.,R.	1
38	90-11-038	左调节架	HEIGHT ADJUSTING STAND ASM.,L.	1
39	90-11-039	木螺钉 5 × 38	WOOD SCREW D=5 L=38	4
40	90-11-040	调节架固定板	TABLE SUPPORT	2
41	90-11-041	螺栓 M8 × 16	SCREW M8 L=16	4
42	90-11-042	垫圈 8	SPRING WASHER 8	4
43	90-11-043	垫圈 8	WASHER 8	4
44	90-11-044	机架右支架	STAND (RIGHT) ASM.	1
45	90-11-045	支架连接螺栓	HINGE SCREW	4
46	90-11-046	垫圈 12	SPRING WASHER 12	4
47	90-11-047	垫圈	WASHER 12	4
48	90-11-048	横梁	STAND SIDE SUPPORT ASM.	1
49	90-11-049	垫圈	SCREW M8	4
50	90-11-050	螺母	NUT M8	4
51	90-11-051	机架左支架	STAND ASM.	1
52	90-11-052	保护套	RUBBER CAP	4
53	90-11-053	螺母	NUT M12	4
54	90-11-054	机架支承螺栓	ADJUSTING SCREW ASM.	4

11. 机架台板、三角带传动部分 TABLE COMPONENTS



REF No 序号	PART NO 件 号	DESCRIPTION 名 称		Q'TY 数 量
55	90-11-055	机架支承垫	LEG SUPPORT CAP	4
56	90-11-056	横支板螺母	LEG BOTTOM SUPPORT BRACKET	2
57	90-11-057	垫圈 8	WASHER 8	2
58	90-11-058	垫圈 8	SPRING WASHER 8	2
59	90-11-059	螺栓 M8 × 16	SCREW M8 L=16	2
60	90-11-060	横支板	LEG BOTTOM SUPPORT	1
61	90-11-061	垫圈 8	WASHER 8	4
62	90-11-062	螺母 M8	NUT M8	2
63	90-11-063	踏板支架	PEDAL SHAFT BRACKET	1
64	90-11-064	踏板	PEDAL	1
65	90-11-065	踏板胶垫	PEDAL MAT	1
66	90-11-066	销 1.8 × 16	SPLIT PIN 1.8 × 16	2
67	90-11-067	踏板轴	PEDAL CONNECTING ROD	1
68	90-11-068	扭簧	SPRING	1
69	90-11-069	调节拉板	PEDAL ADJUSTING PLATE	1
70	90-11-070	螺栓 M6 × 10	SCREW M6 L=10	2
71	90-11-071	垫圈 6	SPRING WASHER 6	2
72	90-11-072	螺栓 M8 × 16	SCREW M8 L=16	2
73	90-11-073	垫圈 8	SPRING WASHER 8	2
74	90-11-074	垫圈 6	WASHER 6	2

12. 线架部分 THREAD STAND COMPONENTS



REF No 序号	PART, NO 件 号	DESCRIPTION 名 称	Q'TY 数 量
1	90-12-001	线架组件	1
2	90-12-002	橡胶盖	1
3	90-12-003	螺钉 M 6 × 16	2
4	90-12-004	线架固定板	2
5	90-12-005	线架	1
6	90-12-006	线架上管	1
7	90-12-007	管接头	1
8	90-12-008	螺母 M5	2
9	90-12-009	螺钉 M5 × 14	2
10	90-12-010	线架下管	1
11	90-12-011	线挡	2
12	90-12-012	线轴	2
13	90-12-013	线垫	2
14	90-12-014	线座	2
15	90-12-015	线架	1
16	90-12-016	螺母	2
17	90-12-017	垫圈 16	2
18	90-12-018	垫圈 16	1
19	90-12-019	骑马钉 (20 × 2)	3
20	90-1-020	橡胶垫	2
21	90-12-021	垫圈 5	2
22	90-12-022	螺母 M5	2



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