



自动加油珠边机 ZJ200型

AUTOMATIC OILING BEADING MACHINE

使用说明书

零件手册

OPERATION MANUAL

PARTS BOOK

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开车前的注意事项:

BEFORE OPERATION

- 1.油盘内未加油绝不能开车。
 - 2.机器运转时,从上轮外侧看转向应为逆时针方向,注意,不能倒转。
 - 3.在第一月中,不要选用大尺寸的电动机皮带轮。
 - 4.确认电动机标牌上所标电压及相位是否正确。
- 1.Never operate the machine unless its oil pan has been filled with oil.
 - 2.After setting up the machining,check the direction of motor rotation.to check it, turn the handwheel by hand to bring the needle down,and turn the power switch ON while observing the handwheel.(The handwheel should turn counterclockwise as observed from the handwheel side.)
 - 3.Do not use a lager motor pulley for the first one month.
 - 4.Confirm that the voltage and phase (single or 3-phase)are correct by checking them against the ratings showm on the motor namaeplate.

使用注意事项:

OPERATION PRECAUTIONS

- 1.接通电源开关或机器运转时,请勿将手放到针的下部。
 - 2.机器运转时,请勿将手指伸入挑线杆护罩内。
 - 3.机头翻动及拆三角皮带时,一定要切断电机开关。
 - 4.操作者离开机器时,必须切断电源。
 - 5.机器运转期间,注意不允许任何人的头或手以及任何东西靠近上轮“V”形皮带、绕线轮和电动机。
 - 6.不要用香蕉水等油漆稀释剂擦洗机头表面。
- 1.Keep your hands away from the needle when you turn the power switch ON or while the machine is operating.
 - 2.Do not put your fingers into the thread take-up cover while the machinc is operating.
 - 3.Be sure to turn the power switch OFF before tilting the machine head or removing the V belt.
 - 4.When an operation leaves from the machine, make sure to turn off the power.
 - 5.During operator,be careful not to allow your or any other person's head or heads to come close to the handwheel, vbelt,bobbm winder or motor or motor.Also,do not place anything close to them.Doing so may be dangerous.
 - 6.Don't clean the face of machine head with thinner.

1.机器的安装(图1、图2、图3、图4)

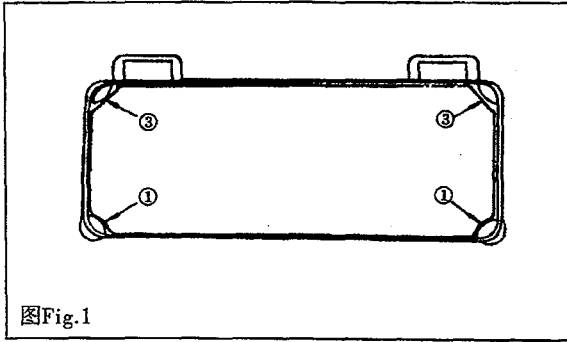
1.INSTALLATION(Fig.1, Fig.2, Fig.3, Fig.4)

*油盘安装:

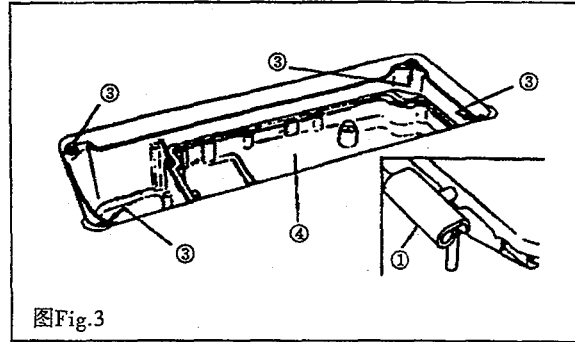
- 1)油盘应搁在工作台凹槽四角。
- 2)如图所示,将两只油盘支座①用油盘座钉②固定在A一边(朝操作者一边),将两只油盘座垫③用油盘座钉②固定在B一边(用机头连接钩接合一边),最后把油盘④放在其上。(图1 图2)
- 3)将机头连接钩①放入底板孔内,与台板的机头连接钩座②相嵌合,再将机头到四只角的机头座垫③上。(图3 图4)

* Installing the oil pan

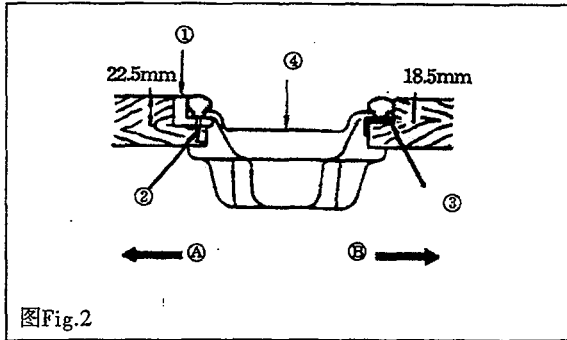
- 1)The oil pan should rest on the four corners of the machine table groove.
- 2)Fix two rubber seats ①on side A(operator's side)using nails②as illustrated above.Fix two cushion seats③ on side B(hinged side)using nails②.Then place oil pan④on the fixed seats.(Fig.1, Fig.2)
- 3)Fix hinge①into the opening in the machine bed,and fit the machine head to table rubber hinge②before placing the machine head on cushions③on the four corners.(Fig.3, Fig.4)



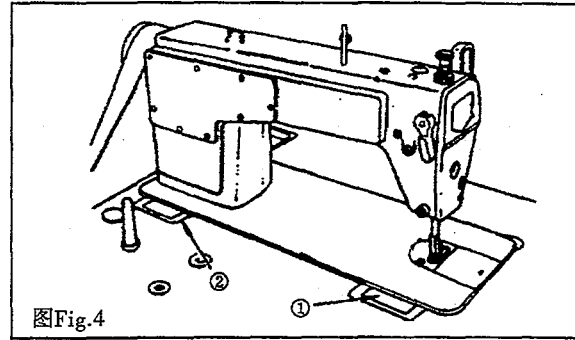
图Fig.1



图Fig.3



图Fig.2



图Fig.4

2. 机器的润滑(图5、图6)

2. LUBRICATION(Fig.5, Fig.6)

1. 润滑须知: (图5)

- 1) 向油盘①内加缝纫机油(7号白油)至HIGH记号部位A。(图5)
- 2) 当油面低于LOW记号B, 应再加油量。
- 3) 加油后, 开动机器, 应看到油液飞溅到油窗②上, 说明润滑正常。
- 4) 至于飞溅的油量多少与总润滑油量多少无关。

*注意:

使用新机器或者长期未使用过的机器时, 应在每分钟1000-1500针的状态下使机器进行十分钟左右的适应性运转。

2. 调节面部油量: (图6)

- 1) 转动油量调节销①, 可以调节挑线曲柄②的供油量。
- 2) 油量调节销朝B方向转动, 刻点A靠近挑线曲柄时, 油量达到最小值。
- 3) 油量调节销朝C方向转动, 刻点A背离挑线曲柄时, 油量达到最大值。

1. Information on Lubrication(Fig.5)

* Before starting the machine

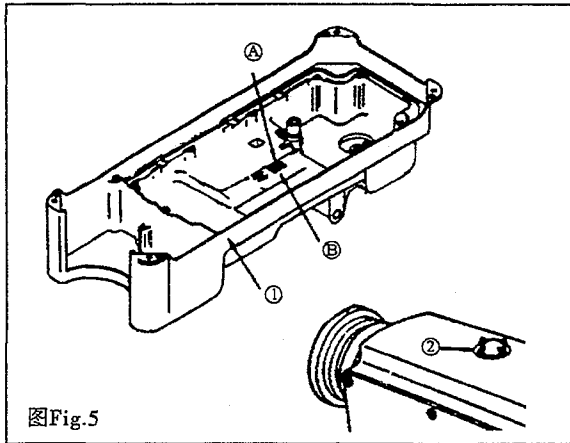
- 1) Fill oil pan ① with sewing machine oil (7 white oil) up to HIGH mark A.
- 2) When the oil level lowers below LOW mark B, refill the oil pan with the specified oil.
- 3) When you operate the machine after lubrication, you will see splashing oil through oil sight window ② if the lubrication is adequate.
- 4) Note that the amount of the splashig oil is unrelated to the amount of the lubricating oil.

* Precaution

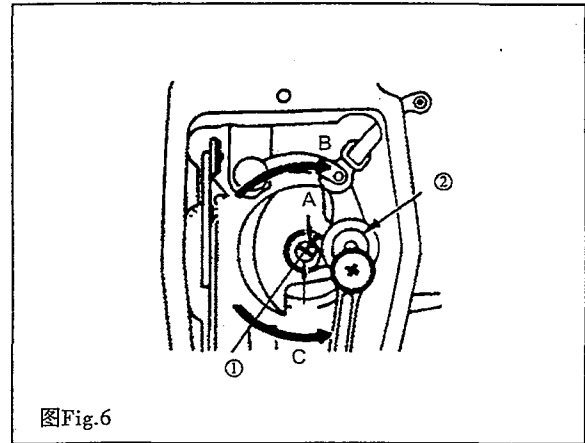
When you first operate your machine after set up or after an extended period of disuse, run your machine at 3,000s.p.m. to 3,500s.p.m. for about 10 minutes for the purpose of break-in.

2. Adjusting the amount of oil supplied to the face plate parts (Fig.6)

- 1) Adjust the amount of oil supplied to the thread take-up and needle bar crank ② by turning adjust pin ①.
- 2) The minimum amount of oil is reached when marker dot A is brought close to needle crank ② by turning the adjust pin in direction B.
- 3) The maximum amount of oil is reached when marker dot A is brought to the position just opposite from the needle bar crank by turning the adjust pin in direction C.



图Fig.5



图Fig.6

3.油量的调节(图7、图8、图9)

3.ADJUSTING THE AMOUNT OF OIL SUPPLIED TO THE HOOK(Fig.7, Fig.8, Fig.9)

1)未使用的机器应进行约3分钟的空转(适当的断续运转)。(图7)

2)油量纸必须在机器运转状态下插入。

3)确认油盘内的油面高度处在HI和LOW范围内。

4)油量确认时间需5秒钟(请用秒表计时)。

*适量的油量标样: (图8)

1)下图标样根据不同的缝制工序需进行增或减的微调整, 但应注意不要增加或减少得过多。

*油量过少会引起发热, 油量过多会油污缝料。

2)用油量纸试用三次, 当纸上油迹不发生变化时, 就不需要调节了。

*调节机器油量: (图9)

1)将下轴前轴套上的油量调节螺钉朝+方向A转动时, 油量将增大。当油量调节螺钉朝-方向B转动时, 油量将减小。

2)调整后应进行约30秒钟的空转, 以确认油量的状态。

1)After cooling, the machine may be idling for three minutes (operating continued properly). (Fig.7)

2)The amount of oil confirmed paper must be inserted in the state when the machine is operating.

3)Oil in the oil pan is confirmed within HI and LOW.

4)The amount of oil confirmed is for five seconds (please use the clock with the second)

* The proper amount of oil manual (Fig.8)

1)The amount of oil can be adjusted according to the different sewing process but it must be suitable amount.

* Otherwise the machine will generate heat or the sewing material will be contaminated.

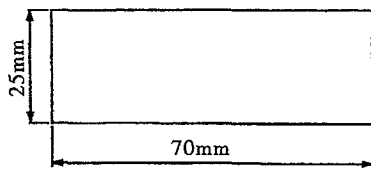
2)Use the amount of confirmed paper for three times to observe the amount of oil. Adjust the screw until the mark on the paper hasn't changed.

* Adjusting the amount of oil supplied to the hook (Fig.9)

1)More oil is supplied as oil amount adjust screw mounted on the hook driving shaft is turned toward + in direction A. As the oil amount adjust screw is turned toward - in direction B, the amount of oil supplied will be decreased.

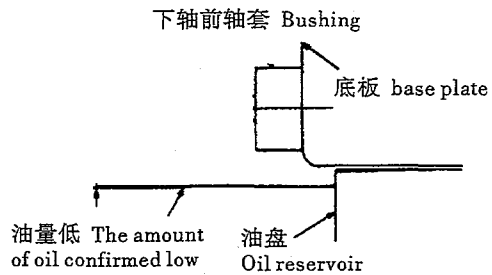
2)After adjusted, the machine must be idling for thirty seconds. It can be confirmed the state of oil supplied.

①油量纸 The amount of oil confirmed paper

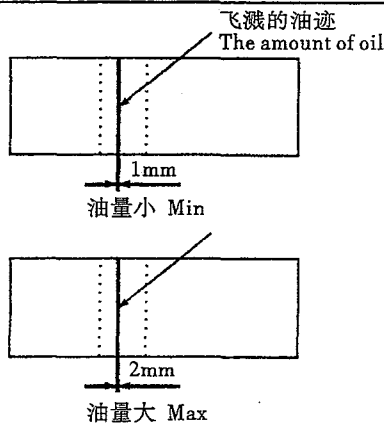


图Fig.7

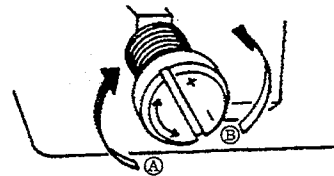
②油量确认位置 The place of confirmed



图Fig.8



图Fig.9



4. 机针的装法(图10)

4. ATTACHING THE NEEDLE (Fig. 10)

*在装机针前，必须切断电动机电源。

标准用针为DB×1#18。机针有各种编号，根据所用线的粗细和缝料来选择适当的机针。

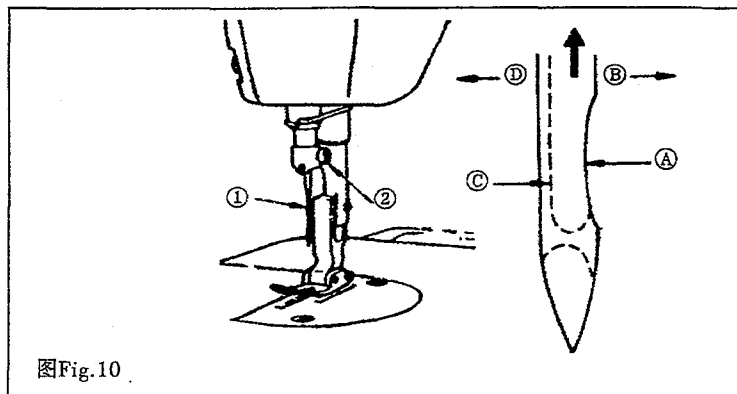
- 1)转动上轮使针杆上升到最高位置。
- 2)旋松支针螺钉②，使机针①的凹弧部分A正对右方向B。
- 3)将机针朝箭头方向插入针孔的底部，直至插不进为止。
- 4)旋紧支针螺钉②。
- 5)务必使机针的长槽C正对左方向D。

* Turn the motor power OFF before starting to attach the needle.

A needle of DB × 1#18 should be used.

Select a proper needle size according to the count of thread and type of material used.

- 1)Turn the handwheel until the needle bar reaches the highest point of its stroke.
- 2)Loosen screw②,and hold needle①with its indented part A facing exactly to the right in direction B.
- 3)Insert the needle in the direction of the arrow until it will go no further.
- 4)Securely tighten screw②.



图Fig.10

四、机器的操作：

警告：操作不熟练者需大轮安装降低运转速度。

D:Operation

Warning:For the unskilled,great wheel should be installed to lower the motion speed.

针距长短调节

针距的长度，可以用转动针距旋钮来调节。

1.Regulate needle gauge and feeding:

Turning the rotary button can regulate the width of needle gauge(Fig.16).

挑线簧的调节

挑线簧的张力，一般在20克左右。其摆动范围为7~10毫米。缝纫特别薄的缝料(短针距)，则要减弱挑线簧的张力和放宽其摆动范围。缝制特别厚的缝料则相反。(产生珠边点深)

调节挑线簧的摆动范围时，可以先松开固定螺钉，然后转动夹线器，以调节其摆动范围。夹线器顺时针转动，则摆动范围增大。反之则减小。最后再将固定螺钉支紧。同样，挑线簧的张力，也可以进行调节。调节时，先松开固定螺钉1，将夹线器整个取出，再松开固定螺钉2，这时，夹线螺钉就能转动。顺时针转动时，张力增加。反之则减少。调节好后，按同样方法，将夹线器装好。

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

2.Regulating take up spring:

In general, the tension of take-up spring is 20g and the range of swinging is 7-10mm. When sewing special light material(narrow needle gauge),the tension should be reduced and the range should be broadened. Vive-versa for special heavy material.

When regulating the range of swinging,first loosen the set screw 1.Then turn the tensioner to regulate the range of swinging.If turn the tensioner clockwise,the range is broadened.If turning counter clockwise,the range is narrowed.Then tighten the screw.

When regulating the tension of take up spring, first loosen set screw 1, and take out the tensioner. Then loosen set screw 2, so the tension screw can be turned. Turning clockwise can increase tension. Turning counter clockwise can reduce tension.

压脚压力的调节

压脚的压力，要根据缝料的厚度加以调整。缝纫厚料时，应加大压脚的压力。这时，可以将机头顶部的调压螺钉，按图7(厚)所示箭头方向转动。反之，缝薄料时，可按图21(薄)所示的方向，转动调压螺钉，以减小压脚的压力。

压脚的压力，应以能正常推送缝料为度，宜尽量减轻一些。

3. Regulating presser pressure:

Presser pressure should be regulated as per sewing materials. When sewing heavy materials, the pressure should be increased. Just turn the screw on top of the machine head (Fig 7.) (heavy). Vice-versa when sewing light material (Fig 7) (light).

Presser pressure should be properly regulated so that it can feed material without a hitch.

线构的调节

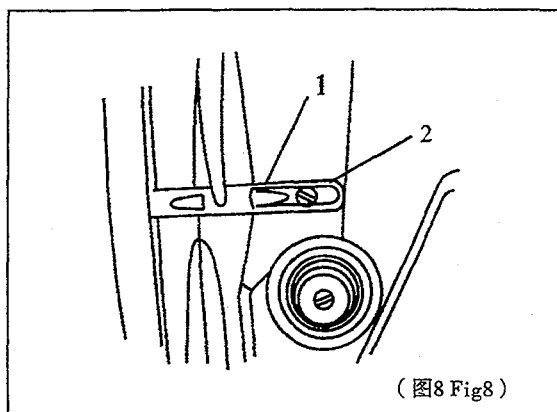
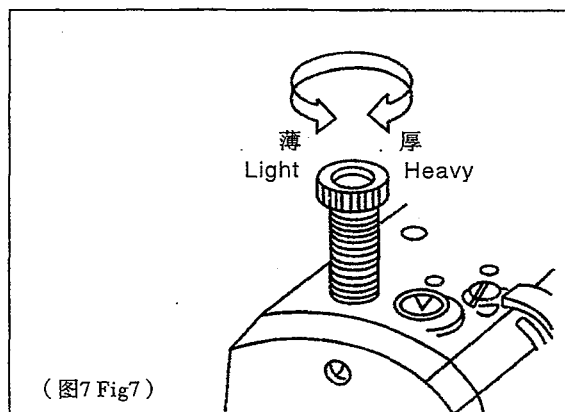
根据缝纫物的厚度和针距长度调节好线钩的位置后，将能使缝纫的线迹更为整齐。

在缝纫厚料时，松开螺钉2(图8)，将线钩1向左移动，以增加线量。在缝纫薄料时则往右移动线钩以减少线量。

4. Regulating thread hook:

In order to make the stitches move beautifully, the position of thread hook should be regulated as per materials and the gauge of the needles:

When sewing heavy materials, first loosen the screw 2 (Fig 8) and move the thread hook 1 to left to increase the thread amount. Vice-versa when sewing light materials.



五、机针的安装

调换或调整机针时，用手转动皮带轮，使针杆升到最高位置，然后用本厂供应的螺丝刀，将机针扎头螺丝刀松开用镊子或尖咀钳安装新机针。

按装新机针

请注意几点

(1) 机针的柄必须向上装到上限，(碰到针杆孔低)；先装直针，后装钩针。

(2) 机针的长槽应面向左。

新机针装上后，用螺丝刀轻微将螺丝拧紧，如有跳针现象，可能是针槽方向有误差，或可能是双针不在用一垂直平面上。

如果新机针装上后发生断线情况，可能新机针的针孔槽不够光滑，一般情况下经连续使用一会儿，断线次数即会显著减少，否则需要更换新机针，

警告：缝纫转弯时，挑线杆到最到位置，提压脚，方向转弯。

E.Needle' installation

Changing on regulating the needle, rotate the belt wheel with hand and made the needle lever rise in the highest position, then loosen the binding-head by the highest position, then loosen the binding-head screw-driver of the install new one with tweesens on long flat nosepliens.

New needles' installation

Notes:

(1)、The haft of the needle should be installed upward to the upper limit, (contacted with the face of the needle lever hole); straight one first, then hook one.

(2)、The long slot of the needle should be left-faced, When installed, slightly twist the screw with a screw-driver if there appear drop stitches, maybe there is something wrong with the direction of the slot, on maybe the two needles are not in a same rental plane.

If thread-broken takes place, it may be because the slot isn't smooth enough, and in general, the times of thread-broken should be reduced notally after continuously used for a while, on the needle should be changed with new one.

Warning: When make a turn in sewing, should rise the needle in the highest position and lift the presson foot.

机针和缝纫配合

此机器在出厂时安装的机针是DB×1 16#~20# 151S 16#~21#(西德产)

针号	线 号		缝 纫 材 料
	棉线	丝线	
16#	40/2-40/3	60-80/2	粗布、步其布、薄呢 粗厚棉布、薄绒布、 厚绒布、薄帆布、 大衣呢
18#	最好上海 产制线二 厂出	40-60/3	
20#		32-40/3	

警告：贡针最好选择较细而强的线才能使珠点达到最理想的效果。

Coordination of needles and sewing

The machines are equipped with the needles DB×1 16#~20#

151S 16#~21#

needle number	thread number		materials for sewing
	cotton thread	silk thread	
16#	It's best to use the products made by No.2 shanghai Thread Factory.	60-80/2	coarse cloth、khaki cloth、thin woollen cloth、 thin flannelette thick flannelette、thin canvas overcoat woollen cloth
18#		40-60/3	
20#		32-40/3	

Warning: It is better for needles to select both thinner and stronger thread to make the pearl dots ideal effect.

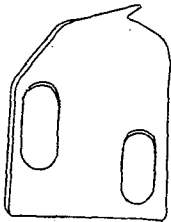
六、常见故障和解决方法：

1.故障分类	2.可能产生的原因	3.建议处理方法
4. 针迹不均或不正确	5. ①夹线板之间有灰尘或纤维使这失去夹线板的作用②钩针位置不正确	6. ①拆开夹线析,消除灰尘和纤维②调整钩针位置。
7. 上跳杆	8. ①针杆左右位置不正确,钩针的左右和方向不对②机针的尘端或柄部弯曲针尖磨纯③机针型号或针号不对④双针不在同一个垂直平面上⑤钩针左右不正确⑥针杆和钩针左右不正确⑦线老度过强,压线板压力大直针向左弯走	9. ①注意针杆左右是否平等②注意钩针钩是否对准直针③线老度过强直针向左弯走要注意钩针向左弯少量,绒环圈向左走,直针尖对准钩针绒环圈不会跳针。
7. 跳针 下跳杆	10. ①重新调整针杆左右②更换新机针③选用合适的机针型号④双针重新调整使在同一垂直平面上⑤转动钩针的左右方向⑥针杆高低有何标准? 答针杆上的直针冲线孔向上,弯针尖距离3-4毫米⑦护针析左右有何标准? 答护针板向左放松直针同弯针之间距离0.20毫米,减少断直针时,直至碰到弯针尖停止不会跳针⑧横针左右有何标准?	答横针转到左停止点时横针尖与直针之间距离5-6毫米 ⑨弯针前后有什么标准?答当转动弯针尖与直针中心时横针尖头未到双针之间距离1.5-1.8毫米⑩针杆与下弯针之间有何标准? 答针杆到下止点弯针尖未到针空隔4-5毫米。
11. 钩丝原因	①带有交强性能的丝料尼龙麻纱布,进口布等容易钩丝。	②注意事项,选择钩针头多弯、牙齿时间过早些转动手轮钩针钩头,达到针板平面,牙齿已爬0.5-1毫米。
12. 机针断线	13. ①针号和线号不对②针孔毛糙或机针质量太差③缝线质量不好④穿线错误和面线太紧⑤线架有阻力⑥线夹过紧	14. ①更换适当缝线②更换新机针③换用质量较好和缝线④正确穿线和调松面线⑤调整线架位置⑥松动线夹
15. 断针倒针	16. ①机针型号不对②上下布边不对准③弯角处过厚④挑线杆不到最高位置时就转弯⑤过硬或布针工作会断针工人操作不熟练	17. ①更换机针②上下布边注意对准③减慢速度④挑线杆到最高位置时才转弯⑤要用手转动皮带轮⑥用机针型号有能低于18-20号

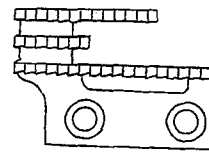
- 12、(1).Change suitable thread.
 (2).Change new needles.
 (3).Change better quality thread.
 (4).Make thread correct and loosen the ball thread.
 (5).Regulate the thread-tension.
 (6).loosen the thread clamp.
- 13、(1).Needle-broken and needle-returned appear.
- 14、(1).Wrong thpe of the needle is used.
 (2).The upper edge of cloth is not aligned with the lower one.
 (3).The turn corner is too thick.
 (4).The needle thrms when it isn't in its highest position.
 (5).The cloth is too hard.
- 15、(1).Change the needle.
 (2).Pay attention to the alignment with the upper and lower edge of cloth.
 (3).Lower the speed.
 (4).Don't make the needle turn until it is in its highest.
 (5).Move the belt wheel with hand.

详见易磨损配件

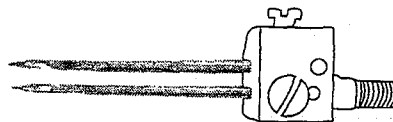
Easy-worn attachments:



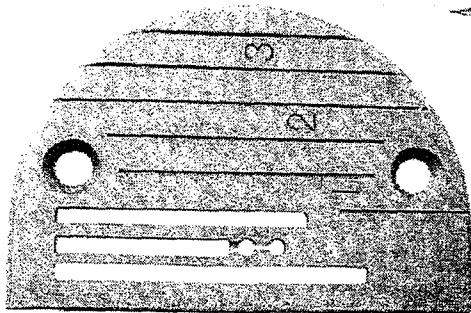
下弯针 Lower bend needle
 下横针 Lower horizontal needle



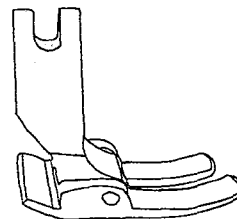
牙齿 tooth



直针 straight needle
 钩针 hook needle



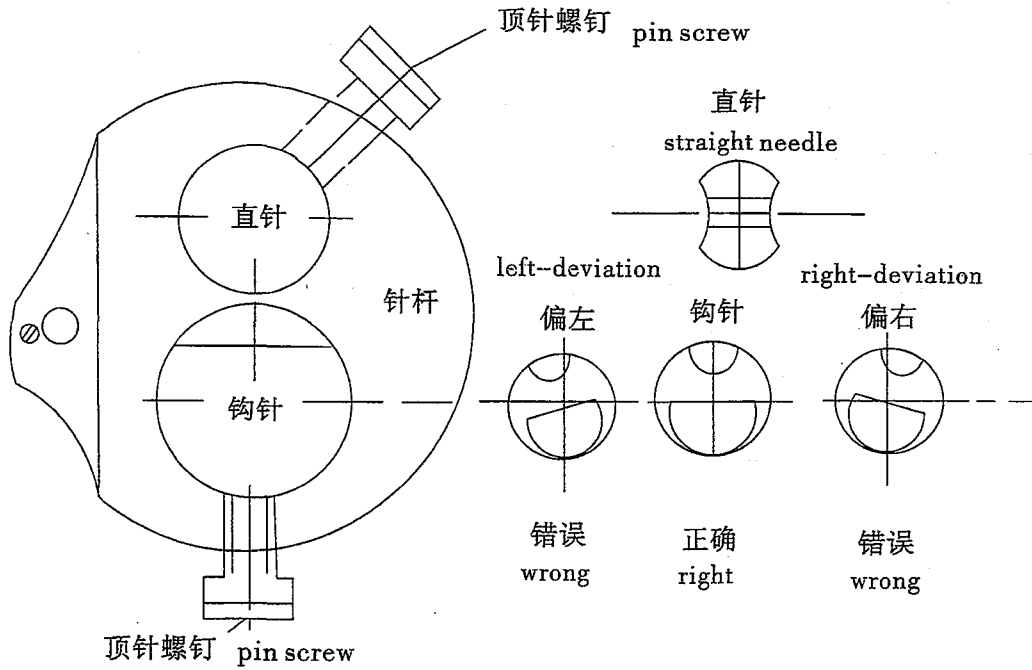
针板 needle plate



压脚 presser foot

调节偏左 偏右 控制上线 跳线位置图

Figure of regulating left-deviation, right-deviation and controlling the position of upper jumper thread

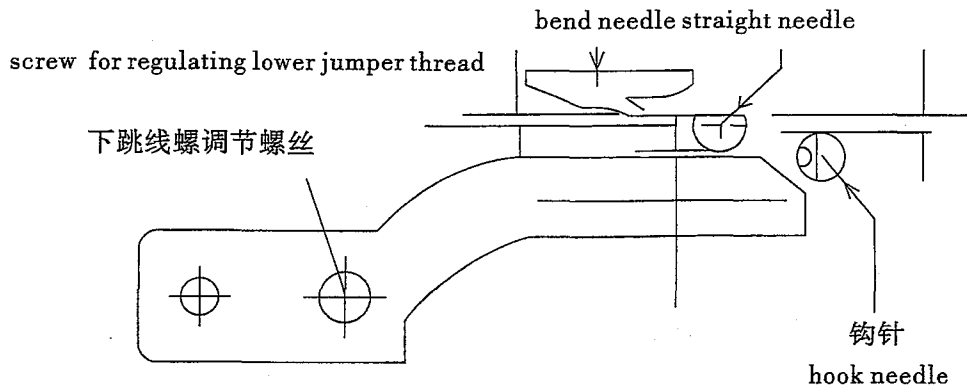


警告：顶针螺钉，禁用大螺丝刀旋紧，以免扭断螺钉

Warning: Don't revolve the pin screw with big screw

-driven in order not to make it broken. 弯针

直针

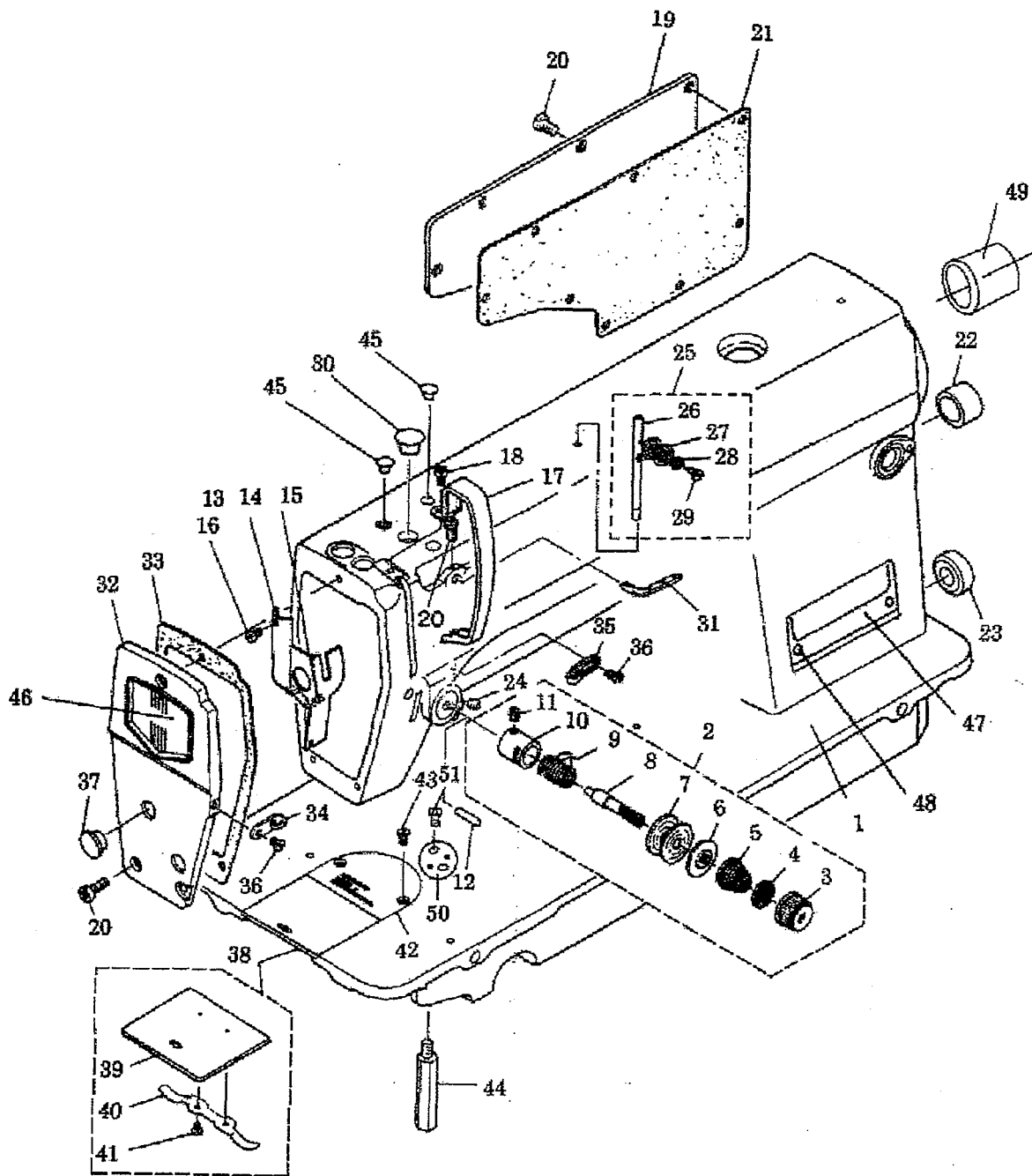


下线弯针位置图

figure of position of bend needle in lower thread

零件样本 **Parts List**

Model (For Medium Heavy Materials)



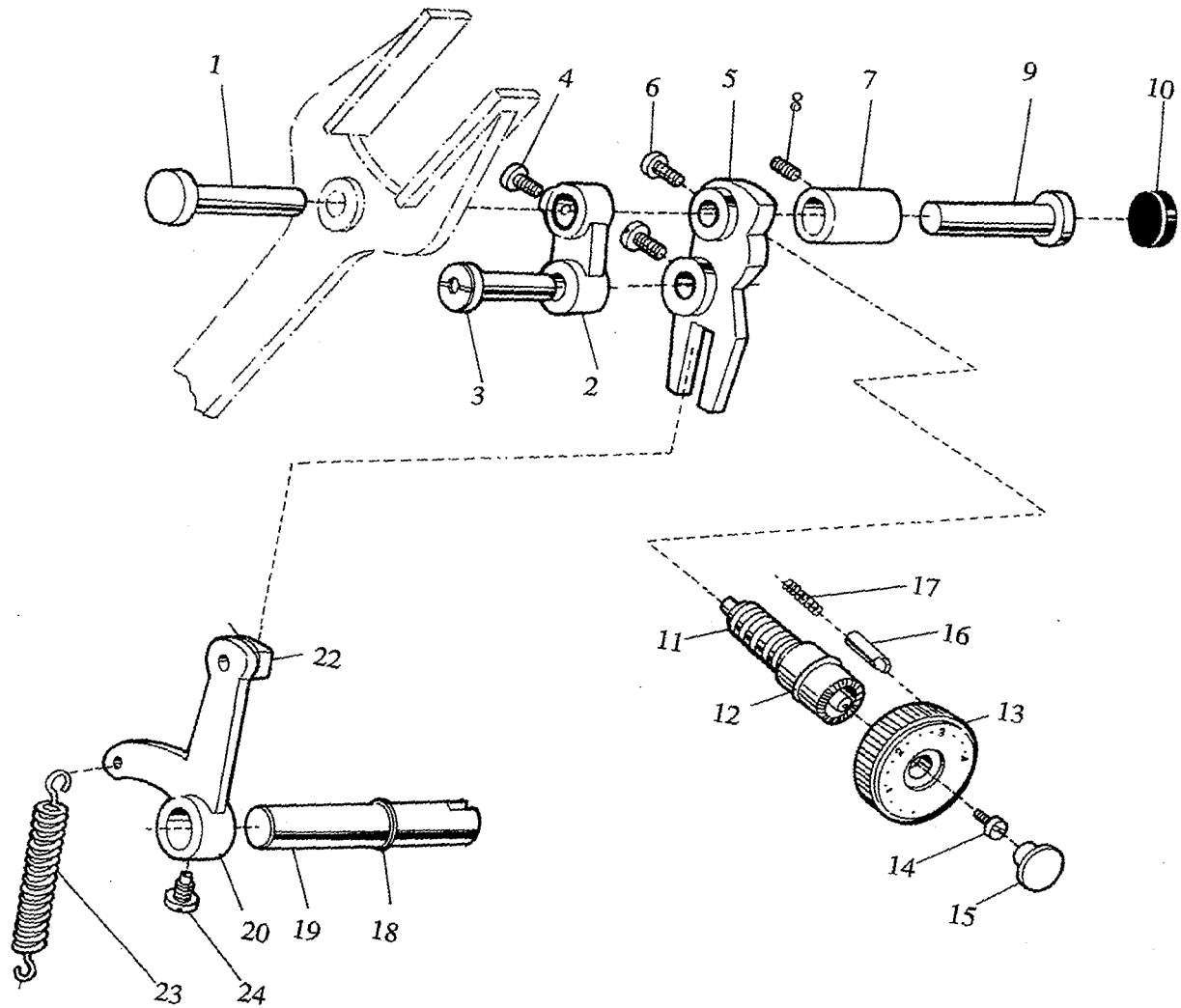
1.机壳分组件 Arm Bed Components

序号 Ref.No	件号 Part No	名 称	Description	数量 Amt.Req
1	01.01.1-0	机壳部件	Arm bed assembly	1
2	01.01.2-0(229-45356)	夹线器组件	Tension Complete subassembly	1
3	01.01.2-1(229-21308)	夹线螺母	Thread tension nut	1
4	01.01.2-2(229-21407)	夹线制动板	Thread disc rotation stopper	1
5	01.01.2-3(229-21704)	夹线簧	Thread tension spring	1
6	01.01.2-4(229-21803)	松线板	Thread release disc	1
7	01.01.2-5(229-21506)	夹线板	Thread tension disc	2
8	01.01.2-6(229-21209)	夹线螺钉	Tension screw	1
9	01.01.2-7(229-21605)	挑线簧	Take-up spring	1
10	01.01.2-8(229-45307)	挑线簧调节座	Thread tension post socket	1
11	01.01.2-9(SS-8090670-SP)	夹线紧固螺钉	Set screw	1
12	01.01.3(B3188-552-E00)	松线钉	Tension release pin	1
13	01.01.4(229-00757)	悬臂油封组件	Oil packing subassembly	1
14	01.01.4-1	悬臂油封罩	Oil packing cover	1
15	01.01.4-2	油线	Oil wick	1
16	01.01.5(SS-6080410-SP)	悬臂油线座螺钉	Screw	1
17	01.01.6(229-00609)	挑线杆护罩	Thread take-up lever cover	1
18	01.01.7(SS-412615-SP)	挑线杆护罩螺钉	Thread take-up lever cover screw	1
19	01.01.8(229-00401)	侧面板	Face plate asm	1
20	01.01.9(SS-412915-SP)	侧面板螺钉	Screw	8
21	01.01.10(110-00619)	侧面板垫	Gasket	1
22	01.01.11(TA-2000502-RO)	针距座支承孔塞	Rubber plug	1
23	01.01.12(TA-2101002-RO)	送料针距调节孔塞	Rubber plug	1
24	01.01.13(SS-8150710-SP)	夹线器螺钉	Thread tension screw	1
25	01.01.14-0(229-32552)	面线过线钉组件	Face plate thread retaining guide subassembly	1
26	01.01.14-1(229-32503)	面线过线钉	Face plate thread guide retaining	1
27	01.01.14-2(229-32602)	小夹线板	Thread tension disc	2
28	01.01.14-3(229-32701)	小夹线簧	Thread tension spring	1
29	01.01.14-4(SD-0380552-SL)	小夹线螺钉	Thread tension screw	1
30	01.01.15(TA-1250705-RO)	针杆曲柄螺孔塞	Rubber plug needle drining crank hole	1
31	01.01.16(229-20706)	三眼过线勾	Three hole thread eyeket	1
32	01.01.17(229-02159)	面板	Face plate	1
33	01.01.18(229-02209)	面板垫	Face plte sealing gasket	1
34	01.01.19(229-20607)	面板导线勾	Face plate thread guide	1
35	01.01.20(229-20508)	右线勾	Thread guide right	1
36	01.01.21(110-01500)	线勾螺钉	Thread guide screw	2
37	01.01.22(TA-1250406-RO)	面板调节孔塞	Rubber plug	1
38	01.01.23-0(229-01250)	推板组件	Bed slide subassembly	1
39	01.01.23-1(229-01201)	推板	Slide plate	1
40	01.01.23-2(229-01300)	推板簧	Slide plate spring	2
41	01.01.23-3(SS-6060210-SP)	推板簧螺钉	Slide plate spring screw	1
42	01.01.24(110-28008)	针板	Throat plate	2
43	01.01.25(SS-6060210-SP)	针板螺钉	Throat plate screw	2
44	01.01.26(229-01003)	底板螺栓	Bed screw stud	4
45	01.01.27(TA-0850604-RO)	挑线连杆销孔塞	Rubber plug thread take-up lever link pin hole	2
46	01.01.28	面板装饰板		1
47	01.01.29	型号牌	Brand plate	1
48		型号牌	Brand plate rivet	2
49	01.01.30(110-04109)	主轴套	Main shaft bushing	1
50	01.01.31(229-02605)	连接板	Connecting rod	1
51	01.01.32(SS-7110540-SP)	连接螺钉	Screw	2

2.上轴、挑线分组件

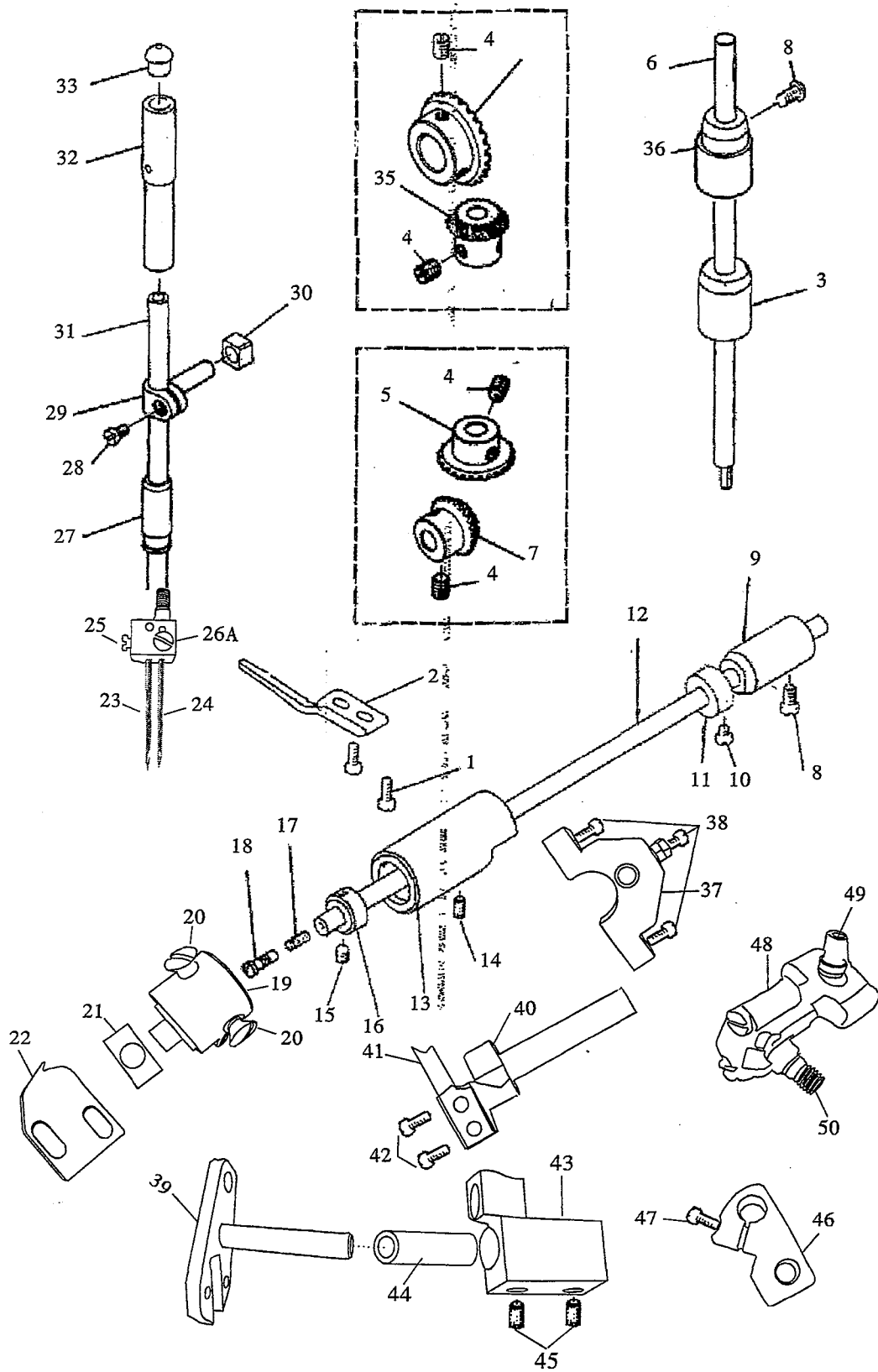
Main Shaft Thread Take-up Components

序号 Ref.No	件号 Part No	名 称	Description	数量 Amt.Req
1	01.02.1-0(110-39070)	挑线杆组件	Thread take-up subassembly	1
2	01.02.2(229-03108)	针杆曲柄	Needle bar crank	1
3	01.02.3(SS-8681650-TP)	针杆曲柄紧固螺钉	Set screw	1
4	01.02.4(SS-7681650-TP)	针杆曲柄定位螺钉	Screw	1
5	01.02.5(RO-0442401-00)	定位螺钉O型圈	O-Rubber ring	1
6	01.02.6(110-39062)	挑线连杆	Thread take-up lever link	1
7	01.02.7(229-27206)	上轮	Hand wheel	1
8	01.02.8(SS-8151550-SP)	上轮螺钉	Screw, hand wheel	2
9	01.02.9(229-03504)	上轴油封	Sealing ring	1
10	01.02.10(229-03405)	上轴后轴套组件	Main shaft rear bushing subassembly	1
11	01.02.11	送布凸轮	Cloth-feeding cam	1
12	01.02.12	送布凸轮螺钉	Screw	2
13	01.02.13	牙叉滑块	Indented fork	1
14	01.02.14	拾牙连杆挡圈	Collar feed driving connecting rod	1
15	01.02.15(SS-8660610-TP)	上轴挡圈螺钉	Snap ring screw	1
16	01.02.16(229-04155)	上轴挡圈	Main shaft thrust collar	1
17	01.02.17(229-03306)	上轴中轴套	Main shaft middle bushing	1
18	01.02.18(SS-8151150-SP)	挑线连杆销螺钉	Screw	1
19	01.02.19(229-19559)	挑线连杆销	Thread take-up lever link pin	1
20	01.02.20(CQ-3500000-FO)	挑线连杆销油线	Oil wick	1
21	01.02.21(B1903-552-000)	挑线曲柄左旋螺钉	End screw, left-hand	1
22	01.02.22-0(110-05204)	挑线曲柄组件	Thread take-up crank subassembly	1
23	01.02.23(B1408-552-000)	针杆连杆	Needle bar crank connecting rod	1
24	01.02.24(b1905-541-B00)	针杆轴承	Needle bearing	2
25	01.02.25(B1212-552-000)	针杆曲柄护板	Needle bar crank wearing plate	1
26	01.02.26-0	油量调节销组件	Crank oil adjusting subassembly	1
27	01.02.26-1(229-03900)	曲柄油量调节销	Crank oil adjusting pin	1
28	01.02.26-2(229-04007)	曲柄油量调节销套	Rubber bushing	1
29	01.02.26-3(RO-0291801-00)	O型耐油密封圈	O-Rubber ring	1
30	01.02.27(229-03702)	上轴油毡	Main shaft felt	1
31	01.02.28(229-03207)	上轴前轴套组件	Main shaft front bushing subassembly	1
32	01.02.29(229-03009)	上轴	main shaft	1
33	01.02.31	上轴轴端螺钉	Screw	1



3.针距调节部件 FEED REGULATING COMPONENTS

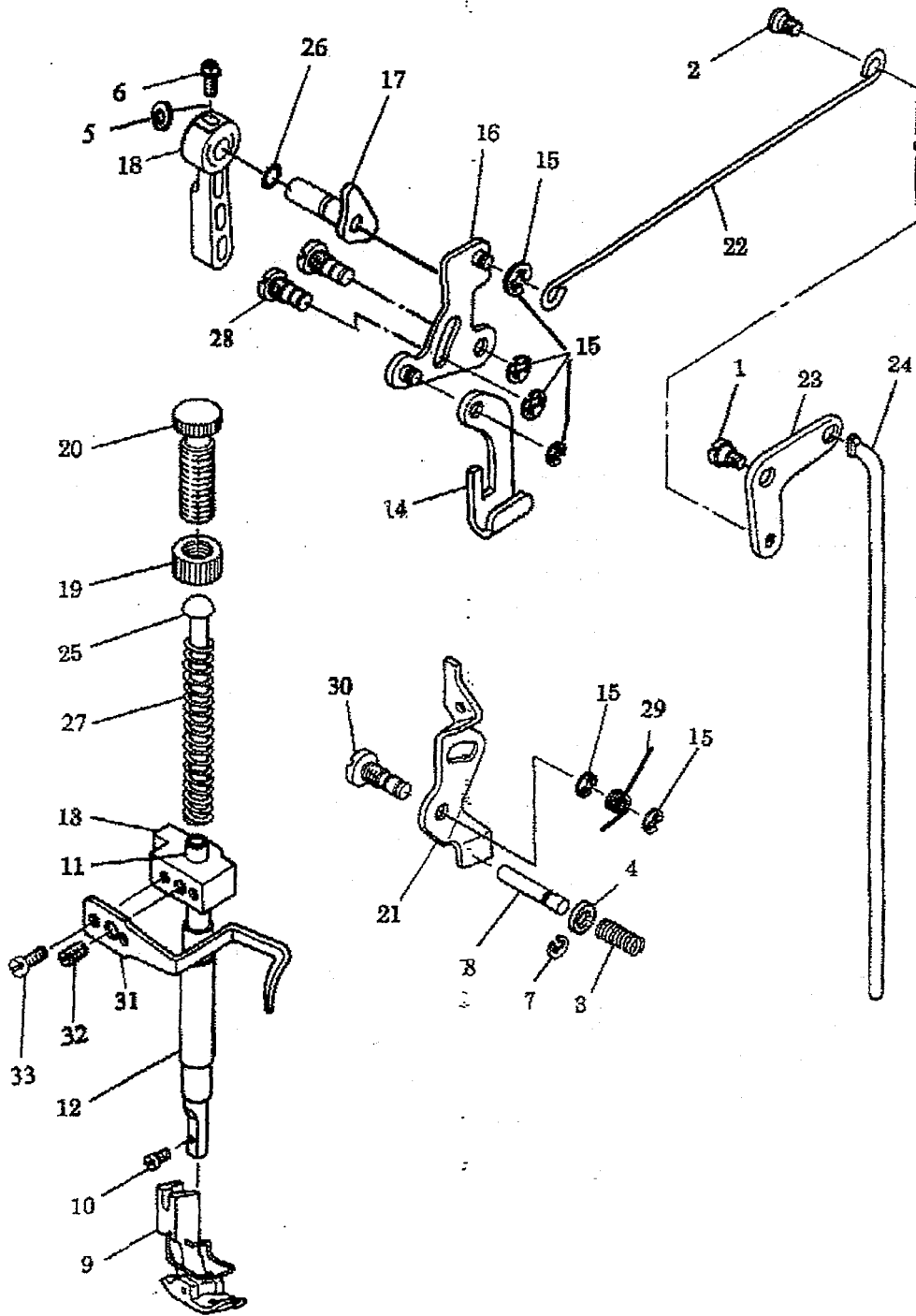
序号	图号	名 称		件数
1	01.03.1	牙叉铰链轴	feed fock connecting shaft	1
2	01.03.2	针距连杆	the stitch length link lever	1
3	01.03.3	针距连相铰链轴	gemel shaft of stitch length link lever	1
4	01.03.4	牙叉铰链轴螺钉	screw	1
5	01.03.5	针距调节摆杆	swinging lever for adjusting pin pitch	1
6	01.03.6	针距调节摆杆螺钉	screw	2
7	01.03.7	针距调节摆杆轴套	shaft bushing of swinging lever for adjusting pin pitch	1
8	01.03.8	针距调节摆杆轴套螺钉	screw	1
9	01.03.9	针距调节摆杆铰链轴	hinge shaft of swinging lever for adjusting pitch	1
10	01.03.10	橡皮塞20×4	rubber plug	1
11	01.03.11	针距调节螺杆	feed regulator screw	1
12	01.03.12	针距调节螺钉O型圈	o-ring	1
13	01.04.13	针距标盘	feed dial	1
14	01.03.14	针距标盘螺钉	screw	1
15	01.03.15	针距标盘橡皮塞	stitch dial rubber	1
16	01.03.16	止动销	stopper pin	1
17	01.03.17	止动销弹簧	stopper pin spring	1
18	01.03.18	倒缝操纵杆短轴	feed reverse shaft(short)	1
19	01.03.19	倒缝操纵杆短轴O型圈	rubber ring	1
20	01.03.20	倒缝操纵杆曲柄	reverse feed control lever asm	1
21	01.03.21	倒缝操纵杆曲柄滑块轴	reverse feed control lever asm slipe shaft	1
22	01.03.22	倒缝操纵杆曲柄滑块	slipe block	1
23	01.03.23	倒缝操纵杆曲柄滑弹簧	feed reverse spring	1
24	01.03.24	倒缝操纵杆螺钉	feed reverse asm acrow	1



4.刺料、钩线分组件

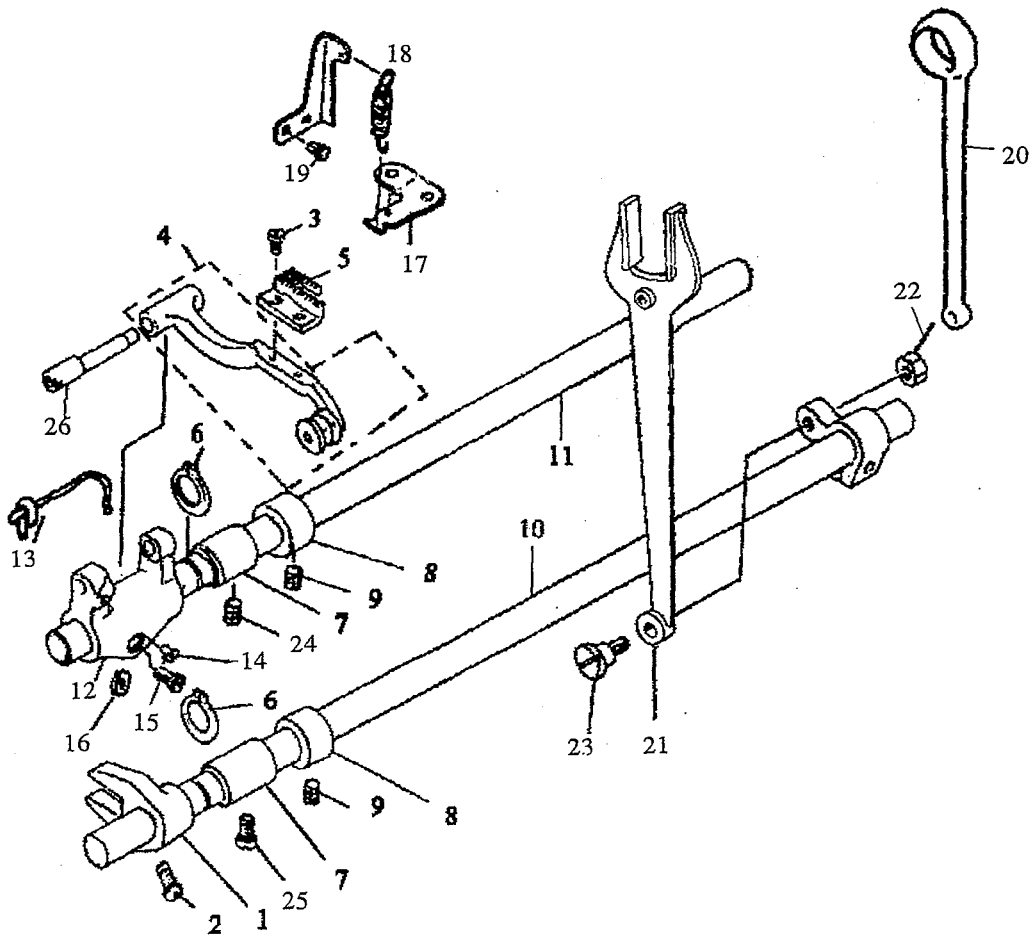
Fabric-Piercing Hook Driving Components

序号 Ref.No	件号 Part No	名 称 Description	数量 Amt.Req
1	01.04.1(SS-4110915-SP)	定位螺钉 Screw	2
2	01.04.2(229-16407)	定位靠 Rotating leanon positioning finger.....	1
3	01.04.3(229-05202)	竖轴下轴套 Upright shaft lower bushing	1
4	01.04.4(SS-8660810-TP)	伞齿轮螺钉 Set screw	8
5	01.04.5(B1307-155-OAO)	竖轴下伞齿轮..... Bevel gear	1
6	01.04.6(229-05004)	竖轴..... Upright shaft	1
7	01.04.7(B1308-155-OAO)	下轴伞齿轮 Bevel pinion	1
8	01.04.8(SS-4120915-SP)	竖轴上轴套、下轴后轴套螺钉 Screw.....	2
9	01.04.9(229-16308)	下轴后轴套 Hook driving shaft rear bushing	1
10	01.04.10(SS-6110420-TP)	下轴后挡圈螺钉 Screw.....	2
11	01.04.11(229-17157)	下轴后挡圈 Hook driving shaft thrust collar	1
12	01.04.12(229-16001)	下轴 Hook driving shaft.....	1
13	01.04.13-0(229-16100)	下轴前轴套组件 Hook driving shaft front bushing subassembly ...	1
14	01.04.14(SS-8150432-TH)	下轴前轴套螺钉 Set screw.....	1
15	01.04.15(SS-8110410-TP)	下轴前挡圈螺钉 Screw.....	2
16	01.04.16(229-17058)	下轴前挡圈 Hook driving shaft front thrust collar	1
17	01.04.17(229-16605)	下轴限油芯 Oil wick	1
18	01.04.18(229-16506)	下轴限油螺钉 Hook driving shaft front screw	1
19	01.04.19	活生头 slip head	1
20	01.04.20	活生头螺钉 slip head screw	1
21	01.04.21	滑块 slip block	1
22	01.04.22	下弯针 lay bend needle	1
23	01.04.23(151S)	上钩针 upright hook needle	1
24	01.04.24	直针 straight needle	1
25	01.04.25	针夹头螺钉 Screw	1
26	01.04.26A	针夹头 clip-on needle	1
27	01.04.23(229-06200)	针杆下套 Needle bar lower bushing	1
28	01.04.24(SS-6090670-TP)	针杆连接柱螺钉 Screw.....	1
29	01.04.25(229-06457)	针杆连接柱 Needle bar connecting pin.....	1
30	01.04.26(229-06507)	针杆连接柱滑块 Needle bar guide block.....	1
31	01.04.27(229-06002)	针杆 Needle bar.....	1
32	01.04.28(229-06101)	针杆上套 Needle bar upper bushing.....	1
33	01.04.29(229-01409)	针杆上套油塞 Rubber plug	1
34	01.04.30(B1305-012-OAO)	上轴伞齿轮 Bevel gear	1
35	01.04.31(B1306-155-OAO)	竖轴上伞齿轮 Bevel pinion	1
36	01.04.32(229-05103)	竖轴上轴套 Upright shaft upper bushing	1
37	01.04.37	大针架座 Macro-needle frame seat	1
38	01.04.38	大针架座螺钉 Screw.....	3
39	01.04.39	大针架 Macro-needle frame	1
40	01.04.40	横针架 Across needle frame	1
41	01.04.41	横针 Across needle	1
42	01.04.42	横针螺钉 Screw	2
43	01.04.43	横针架座 Across needle frame seat	1
44	01.04.44	横针架座轴套..... Across needle frame seat swinging	1
45	01.04.45	横针架座轴套螺钉..... Across needle frame seat swinging screw... 2	
46	01.04.46	开针连杆 Needle connecting rod	1
47	01.04.47	开针连杆螺钉 Screw	1
48	01.04.48	哈夫 Hafu	1
49	01.04.49	哈夫弹子 Hafu bullet	1
50	01.04.50	哈夫螺纹弹子 Hafu bullet	1



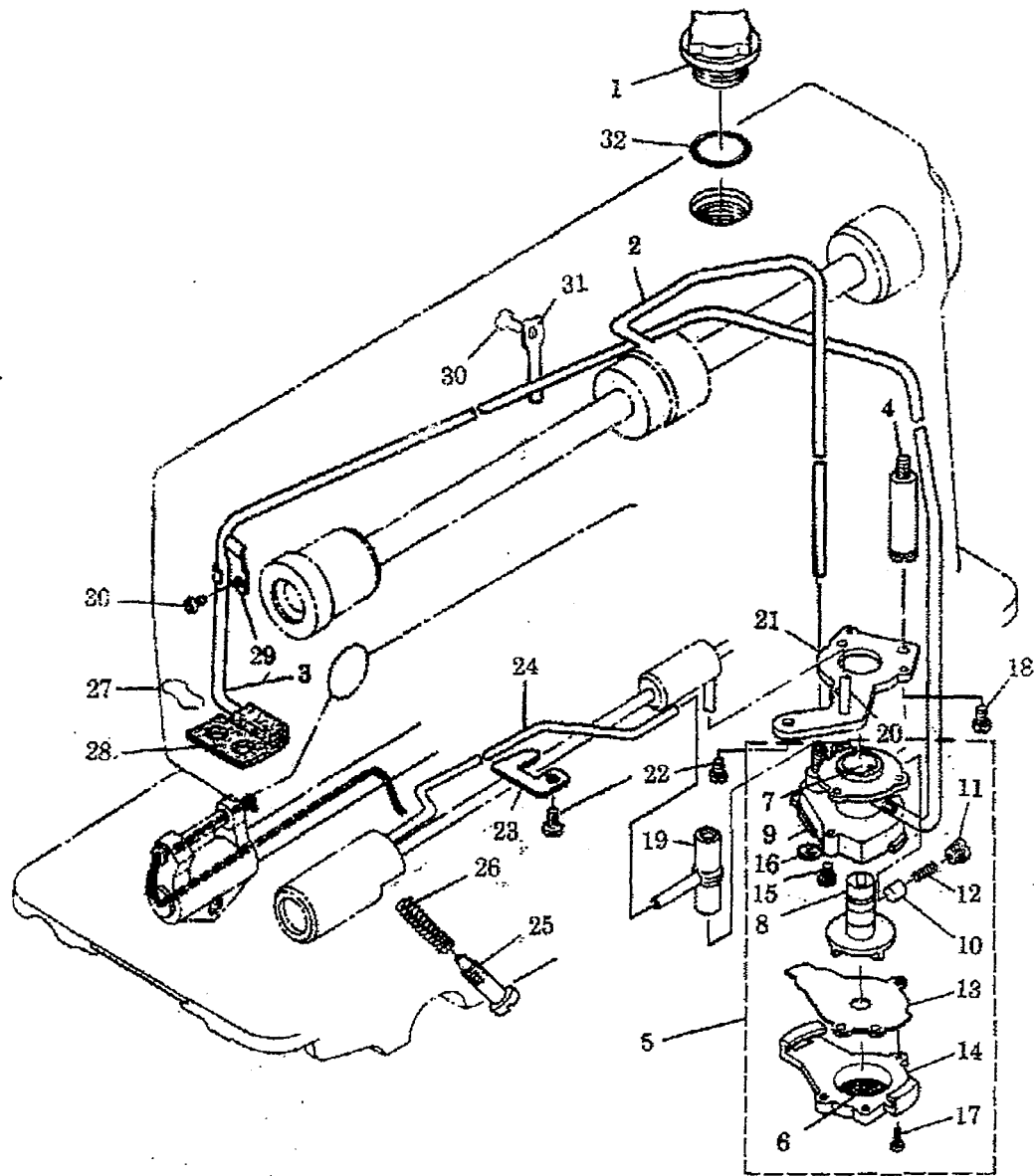
5.压料分组件 Presser Bar Components

序号 Ref.No	件号 Part No	名称 Description	数量 Amt. Req
1	01.05.1(SD-0721331-SP)	后曲柄轴位螺钉····· Hinge screw ·····	1
2	01.05.2(229-08909)	后曲柄螺钉····· Screw ·····	1
3	01.05.3(229-20409)	松线销弹簧····· Spring·····	1
4	01.05.4	松线销垫圈····· Washer ·····	1
5	01.05.5	拾压脚扳手螺钉垫圈····· Washer ·····	1
6	01.05.6(B1521-555-000)	拾压脚扳手螺钉····· Screw·····	1
7	01.05.7	松线销开口挡圈····· Snap ring ·····	1
8	01.05.8(110-18306)	松线销····· Pin ·····	1
9	01.05.9-0(B1524-012-0BA)	活压脚组件····· Hinged presser foot subassembly ·····	1
10	01.05.10(SS-709110-SP)	活压脚螺钉····· Screw ·····	1
11	01.05.11(229-07000)	压杆····· Presser bar ·····	1
12	01.05.12(229-07208)	压杆套····· Presser bar bushing ·····	1
13	01.05.13(229-07208)	压杆导架····· Presser bar guide bracket·····	1
14	01.05.14(229-08008)	压脚提升钩····· Lifting hook·····	1
15	01.05.15(RE-0500000-KO)	开口挡圈····· Spring ·····	6
16	01.05.16-0(229-08156)	拾压脚杠杆组件····· Connecting rod subassembly ·····	1
17	01.05.17-0(229-08552)	拾压脚凸轮组件····· Hand lifer cam subassembly ·····	1
18	01.05.18(229-07802)	拾压脚扳手····· Hand lifer lever ·····	1
19	01.05.19(229-07604)	调压螺母····· Presser spring regulator nut ·····	1
20	01.05.20(229-07505)	调压螺钉····· Presser spring regulator·····	1
21	01.05.21(229-20003)	松线板····· Tension release lever ·····	1
22	01.05.22(229-08305)	拾压脚连杆····· Lifting lever presser rod·····	1
23	01.05.23(229-08800)	拾压脚后曲柄····· Lifting lever rear crank ·····	1
24	01.05.24(229-09006)	拾压脚顶杆····· Lifting lever presser rod·····	1
25	01.05.25(229-07703)	调压导杆····· Pressure lever·····	1
26	01.05.26(RO-0371801-00)	拾压脚凸轮轴油封····· Lifting lever crank shaft screw ·····	1
27	01.05.27(229-07406)	调压簧····· Presser spring·····	1
28	01.05.28(110-06509)	拾压脚轴位螺钉····· Lifting lever shaft hinger screw ·····	2
29	01.05.29(229-20201)	扭簧····· Sping ·····	1
30	01.05.30(110-18108)	松线板轴位螺钉····· Hinger screw ·····	1
31	01.05.31(229-07307)	面线缓线钩····· Thread release finger ·····	1
32	01.05.32(SS-8660810-TP)	压杆导架螺钉····· Presser bar guide screw·····	1
33	01.05.33(SS-6090910-SP)	面线缓线勾螺钉····· Screw·····	2



6.送料分组件 Feed Machanism Components

序号 Ref.No	件号 Part No	名 称	Description	数量 Amt. Req
1	01.06.1 (229-15300)	叉形拾牙曲柄	Feed lifting shaft crank	1
2	01.06.2(SS-7111120-SP)	叉形拾牙曲柄螺钉	Clamp screw	1
3	01.06.3(SS-4080620-TP)	送料牙螺钉	Feed dog screw	2
4	01.06.4-0(229-13354)	牙架组件	Feed bar body subassembly	1
5	01.06.5(B1613-012-A00)	送料牙	Feed dog	1
6	01.06.6(RC-0150001-KP)	送料轴、拾牙轴轴用挡圈	Shap ring	2
7	01.06.79(229-13008)	送料轴、拾牙轴轴套	Feed rocker shaft ard feed driving shaft bushing	2
8	01.06.8(229-04155)	送料轴、拾压轴挡圈	Thrnst collar	2
9	01.06.9(SS-8660610-TP)	轴挡圈螺钉	Screw	4
10	01.06.10(229-15201)	拾牙轴	Feed driving shaft	1
11	01.06.11(229-12901)	送料轴	Feed rocker shaft	1
12	01.06.12(229-13156)	牙架座	Feed rocker	1
13	01.06.13(CQ-2520000-00)	牙架轴油线	Oil wick	1
14	01.06.14(SS-7110740-TP)	牙架轴紧固螺钉	Screw	1
15	01.06.15(SS-7121410-TP)	牙架座螺钉	Screw	1
16	01.06.16(WP-0480856-SP)	牙架座螺钉垫圈	Washer	1
17	01.06.17(229-13701)	拉簧钩	Guide	1
18	01.06.18(229-11309)	摆动板座复位簧	Spring	1
19	01.06.19(SS-7110510-SP)	复位板螺钉	Screw	2
20	01.06.20(229-10202)	送料连杆	Feed rocking shaft connecting rod	1
21	01.06.21(229-15003)	拾牙连杆	Feed lifting connecting rod	1
22	01.06.22(NS-6680410-SP)	拾牙螺母	Feed lifting nut	1
23	01.06.23(SD-1000801-SH)	拾牙螺钉	Feed lifting rock screw	1
24	01.06.24SS-8660610-TP)	送料轴轴套螺钉	Feed rocker shaft,bushing screw	1
25	01.06.25(SS-8660610-TP)	拾牙轴轴套螺钉	Feed lifting shaft,bushing screw	1
26	01.06.26(229-13206)	牙架轴	Feed holder shaft	1

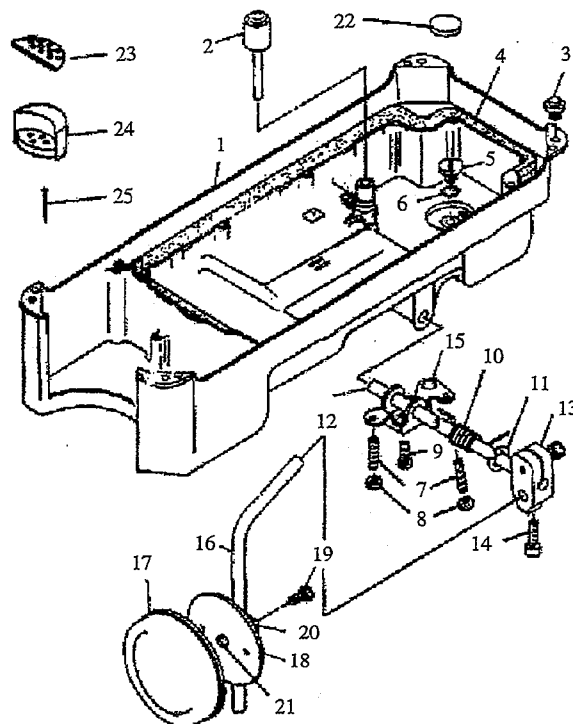


7. 润滑分组件 Lubrication Components

序号 Ref.No	件号 Part No	名 称	Description	数量 Amt. Req
1	01.07.1 (229-24708)	油窗	Oil sight window	1
2	01.07.2 (229-24401)	上轴供油管	Main shaft oil tube	1
3	01.07.3 (229-24153)	回油管	Oil return tube holder	1
4	01.07.4 (229-24005)	油泵支柱	Oil pump installing base	1
5	01.07.5-0 (229-23056)	油泵组件	Lubrication oil pump subassembly	1
6	01.07.5-1	油泵除尘网	Oil pump screen	1
7	01.07.5-2	油泵体衬套	Oil pump body bushing	1
8	01.07.5-3 (229-23700)	油泵叶轮	Oil pump impeller	1
9	01.07.5-4 (229-23007)	油泵体	Lubrication oil pump	1
10	01.07.5-5 (229-23403)	回油柱塞	Oil return pump plunger	1
11	01.07.5-6 (229-23502)	回油调节螺钉	Oil adjusting screw	1
12	01.07.5-7 (229-23601)	回油柱塞簧	Spring	1
13	01.07.5-8 (229-23809)	油泵叶轮托板	Oil pump impeller cover	1
14	01.07.5-9 (229-23205)	油泵盖	Lubricating oil pump cover	1
15	GB818-76 (SL-4030851-SF)	油泵安装螺钉 M3 × 8	Screw	3
16	GB862-76	油泵安装螺钉垫圈 3	Washer	3
17	8B845-76 (SE-4301041-SR)	油泵盖螺钉 A3 × 10	Screw	3
18	8B845-6 (SS-6111010-TP)	油泵右螺钉	Screw	1
19	8B845-7 (229-24609)	油泵三通	Oil pump three way	1
20	8B845-8 (229-23908)	油管接头	Rubber joint	1
21	8B845-9 (229-23304)	油泵座	Oil pump holder	1
22	8B845-10 (SS-4150915-SP)	螺钉	Screw	2
23	8B845-11 (229-24807)	下轴油管托片	Oil pump impeller cover	1
24	8B845-12 (229-24500)	下轴供油管	Oil tube	1
25	8B845-13 (229-25002)	油量调节螺钉	Oil adjusting screw	1
26	8B845-14 (229-24906)	油量调节弹簧	Spring	1
27	8B845-15 (229-25101)	回油毡夹	Oil return tube holder	1
28	8B845-16 (229-24153)	回油毡	Oil return tube plate	1
29	8B845-17 (229-24302)	回油管管夹	Oil return tube holder	1
30	8B845-18 (SS-4120615-SP)	油管夹螺钉	Screw	2
31	8B845-19	回油管压板	Oil return clamp	1
32	GB1235-76 (RO-1952401-00)	O型密封圈 24 × 2.4	O-ring	1

8.油盘、膝拾压脚分组件

Oil Reservoir & knee Lifter Components

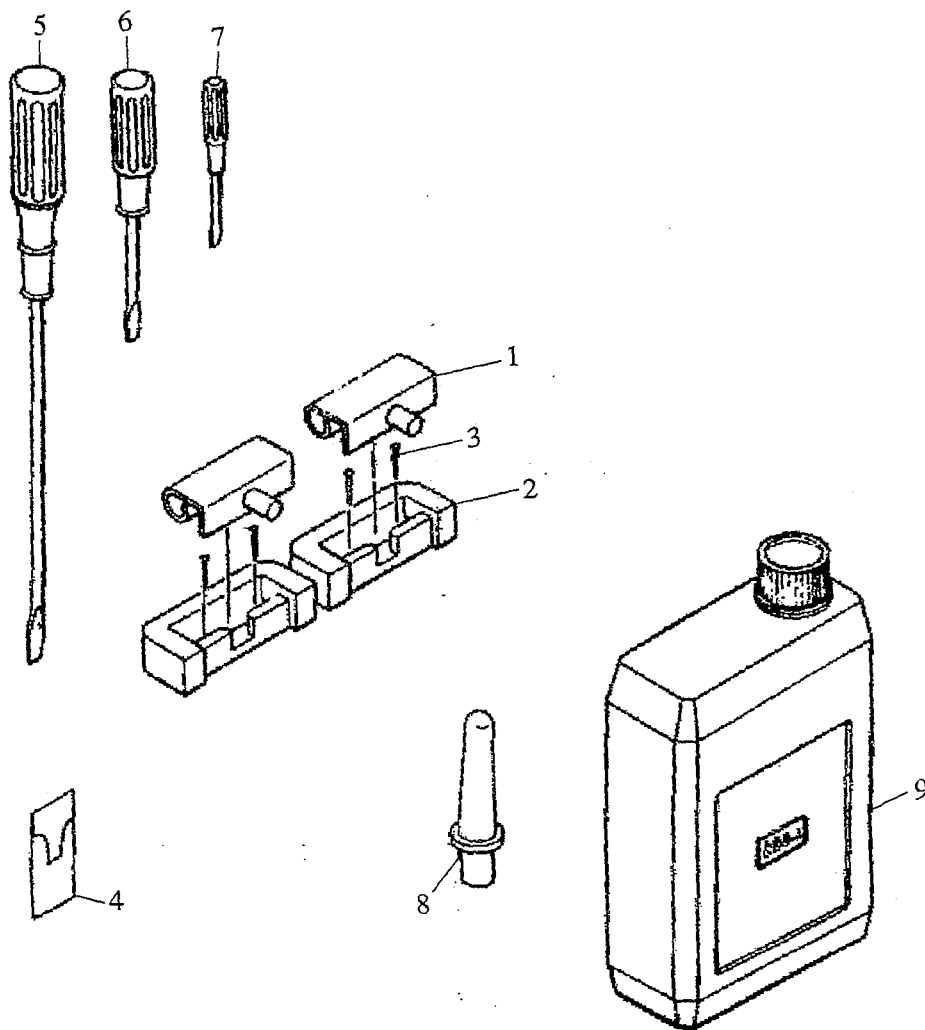


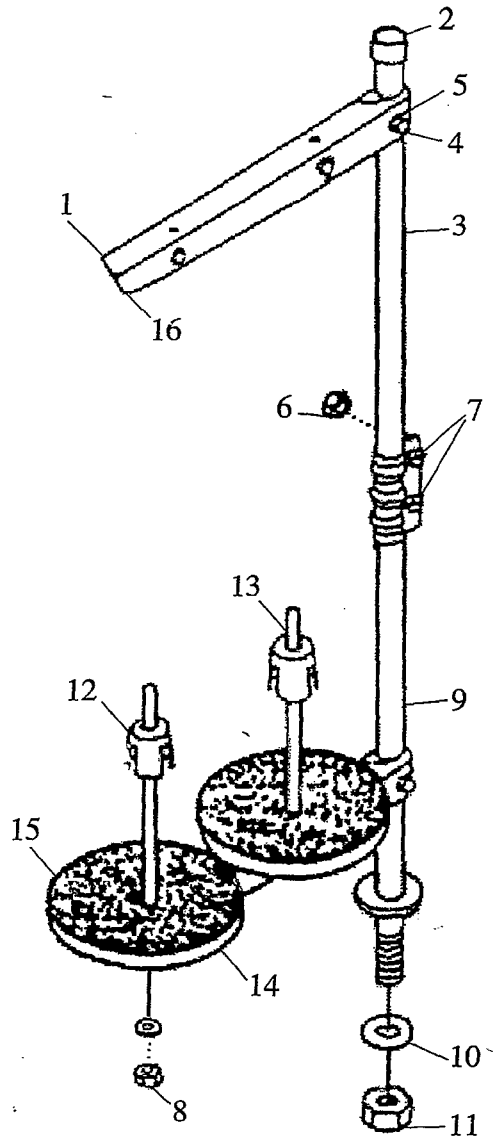
序号 Ref.No	件号 Part No	名称	Description	数量 Amt.Req
1	01.08.1(110-23017)	油盘	Oil reservoir	1
2	01.08.2(229-31703)	膝控拾压脚顶杆	Knee press lifter rod	1
3	01.08.3(110-47107)	垫块	Rubber cushion	4
4	01.08.4(110-24700)	密封衬垫	Gasket	1
5	01.08.5(SS-6700710-SH)	油盘放油螺钉	Screw	1
6	GB1235-76(RO-1082401-00)	O型密封圈15×2.4	O-ring	1
7	GB1235-6(SM-8063012-TR)	螺栓	Screw	2
8	GB1235-(NM-6060001-SE)	螺母	Nut	2
9	GB1235-7(SM-9061853-SR)	拾压脚双向曲柄螺钉	Screw	1
10	GB1235-8(110-24016)	扭簧	Spring	1
11	GB1235-9(RE-1000000-KO)	膝拾压脚轴挡圈	Knee press lifter rod snap ring	1
12	GB1235-10(110-24205)	膝拾压脚轴	Knee press shaft	1
13	GB1235-11(110-24510)	拾压脚操纵节头	Rubber joint	1
14	GB1235-(SM-9062053-SR)	操纵杆节头螺钉	Screw	2
15	GB1235-12(110-24015)	拾压脚双向曲柄	Knee press lifter crank	1
16	GB1235-13(229-34608)	操纵杆	Knee press plate rod	1
17	GB1235-14(229-34509)	操纵板软垫	Knee press plate cover joint	1
18	GB1235-15(229-34202)	操纵板	Knee press plate	1
19	GB1235-16(SM-9061203-SE)	操纵杆夹头螺钉	Screw	1
20	GB1235-17(229-34301)	操纵杆夹头	Knee lifter tube holde	1
21	GB1235-18(229-34400)	操纵杆垫块	Knee lifter pad	1
22	GB1235-19	油盘磁铁	Oil ressrvoir magnet	1
23	GB1235-20	油盘磁铁	Oil ressrvoir felt cushion	2
24	GB1235-21	油盘支座	Oil reservoir rubber cushion	2
25	GB1235-22	油盘座钉	Nail	2

9.机头附件

Machine Head Accessories

序号 Ref.No	件号 Part No	名 称	Description	数量 Amt.Req
1	01.09.1	机头连接钩座	Machine hinge plate	2
2	01.09.2	机头连接钩座钉	Nail	4
3	01.09.3	机针	Needle	1包
4	01.09.4	螺丝刀(大)	Screwdriver,(large)	1
5	01.09.5	螺丝刀(中)	Screw driver,(medium)	1
6	01.09.6	螺丝刀(小)	Screw driver,(small)	3
7	01.09.7	机头支柱	Machine rest pin	1
8	01.09.8	油箱部件	Oil reservoir asm	1
9	01.09.9			

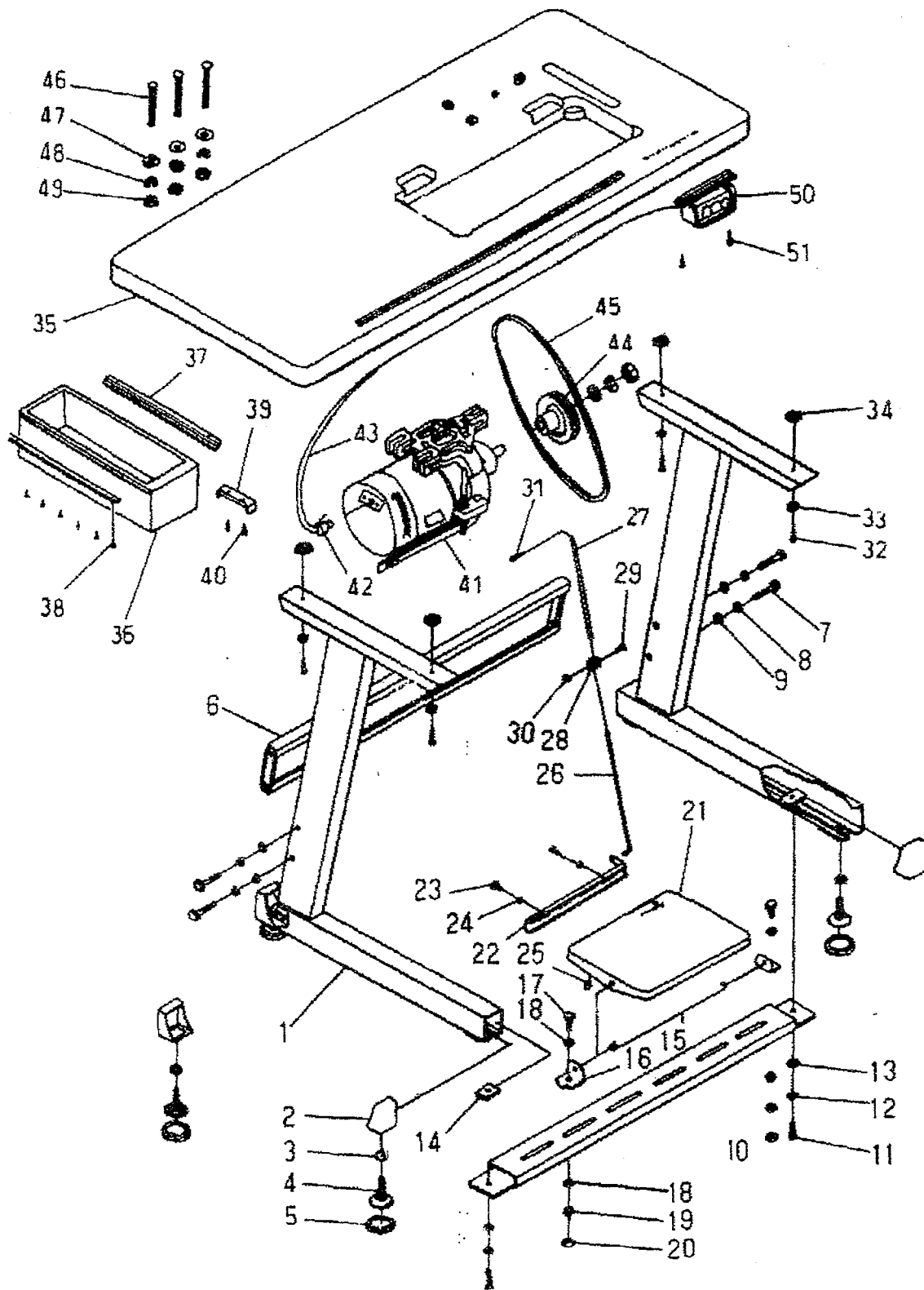




10.线架分组件

Thread stand unit components

序号 Ref.No	件号 Part No	名 称	Description	数量 Amt.Req
1	01.10.26(229-30507)	线架横臂	Thread hanger	2
2	01.10.27(229-31406)	线架帽	Column cap	1
3	01.10.28(229-30408)	上线架管	Spool rest rod upper	1
4	GB5780-86(SM-6061610-SC)	横臂安装螺栓M5×30	Screw	2
5	GB848-85(WS-0510002-KN)	横臂安装螺栓垫圈M5	Washer	4
6	01.09.29(229-31307)	线架管接头	Column pipe connector	1
7	GB818-85(SM-4051405-SE)	线架管接头螺钉M5×15	Screw	2
8	GB6170-86(NM-6050001-SE)	线架管接头螺母M5	Nut	4
9	01.09.30(229-30309)	下线架管	Spool rest rod lower	1
10	GB96-85(WP-1702600-SO)	下线架管垫圈	Washer	2
11	GB6173-86(NM-6160511-SE)	下线架管连接螺母	Nut	1
12	01.10.31(229-31109)	线团定心	Spool vibration stopper	2
13	01.10.32(229-31000)	插线管	Spool pin	2
14	01.10.33(229-30804)	线塔托盘	Spool rest	2
15	01.10.35(229-31208)	过线瓷管	Thread guide tube	2
16		过线瓷管座	Thread guide tube holder	2



11.机架、台板、电器分组件

Machine Stand, Table & Electric Appliance Components

序号 Ref.No	件号 Part No	名 称	Description	数量 Amt. Req
1	GCJ-01	边架部件	Stand side asm	2
2	GCJ-02	边架座套	Rubber cushion	4
3	GCJ-03	调节座螺母	Nut	4
4	GCJ-04	调节座	Screw	4
5	GCJ-05	调节座胶垫	Space ring	4
6	GCJ-06	横档部件	Stand side support asm	1
7	GCJ-07	横档连接螺钉	Screw	4
8	GCJ-08	边架柱弹簧垫圈	Spring washer	4
9	GCJ-09	边架柱垫圈	Washer	4
10	GCJ-10	踏板轴档部件	Threadle brace asm	1
11	GCJ-11	踏板轴档螺钉	Screw	2
12	GCJ-12	踏板轴档垫圈	Washer	2
13	GCJ-13	踏板轴档弹簧垫圈	Spring washer	2
14	GCJ-14	踏板轴档定位螺母板	Threadle brace locknut plate	2
15	GCJ-15	踏板轴	Threadle shaft	1
16	GCJ-16	踏板轴座	Threadle bracket	2
17	GCJ-11	踏板轴座螺钉	Screw	2
18	GCJ-17	踏板轴座垫圈	Washer	1
19	GCJ-13	踏板轴座弹簧垫圈	Spring washer	2
20	GCJ-18	踏板轴座螺母	Nut	2
21	GCJ-19	踏板	Threadle	1
22	GCJ-20	踏板杠杆	Threadle pitman	1
23	GCJ-21	踏板杠杆螺钉	Screw	2
24	GCJ-22	踏板杠杆垫圈	Washer	2
25	GCJ-18	踏板杠杆螺母	Nut	2
26	GCJ-23	下拉杆	Pitman rod, lower	1
27	GCJ-24	上拉杆	Pitman rod, upper	1
28	GCJ-25	拉杆接头	Joint	1
29	GCJ-11	拉杆接头螺钉	Joint screw	1
30	GCJ-26	拉杆接头螺母	Joint nut	1
31	GCJ-27	上拉杆开口销	Pitman rod split pin(upper)	1
32	GCJ-28	台板木螺钉	Table wood screw	4
33	GCJ-22	台板木螺钉垫圈	Table wood screw washer	4
34	GCJ-29	台板垫圈	Table washer	4
35	GCJ-30	台板	table	1
36	GCJ-31	抽斗	Drawer	1
37	GCJ-32	抽斗导轨	Drawer rail	2
38	GCJ-33	抽斗导轨木螺钉	Drawer rail wood screw	6
39	GCJ-34	抽斗限位板	Drawer limit plate	1
40	GCJ-35	抽斗限位木螺钉	Drawer limit plate wood screw	2
41	GCJ-36	4P-250W电机	Modor GFC4042 motor	1
42	GCJ-37	电机接线插头	Modor connecting wire plug	1
43	GCJ-38	电机接线	Modor wire	1
44	GCJ-39	电动机带轮	Modor pulley	1
45	GCJ-40	机头传动带	Machine driving belt	1
46	GCJ-41	电机台板连接螺钉	Motor & table connecting screw	3
47	GCJ-42	电机台板连接垫圈	Motor & table connecting washer	3
48	GCJ-13	电机台板连接弹簧垫圈	Motor & table connecting spring washer	3
49	GCJ-43	电机台板连接螺母	Motor & table connecting nut	3
50	GCJ-44	电源开关	Power source switch	1
51	GCJ-45	电源开关木螺钉	Power source switch wood screw	2

*本分组建需另行订购。

* Note that partd above mentioned shall be purchased in a separate order

* * L用GCJ-39A带轮

* * H用GCJ-39H带轮

* * Part No. GCJ-39A Motor pulley is user for Model

Part No. GCJ-39H Motor pulley is used for Model

