



# 超高速绷缝机 ZJ-VF

SUPER HIGH SPEED INTERLOCK SEWING MACHINE

ZJ 2500 A

## 使用说明书 OPERATION MANUAL

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

本使用说明书内容为了改良不经预告随时会更改，请谅解为盼。

The description covered in this OPERATION MANUAL is subject to change for improvement of the commodity without notice.

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## 1. 规格

外型尺寸: 500mm(长)x250mm(宽)x430mm  
(全高)

重量(机头): 42kg

线迹型号: ISO 406, 407, 602, 605

适用范围: 适用于针织服装的绷缝

缝纫速度: 最高 7000 转/分(无上饰线装置)  
6500 转/分(有上饰线装置)

针距: 1.4~3.6mm

针数: 8~21 针/30mm

7~18 针/英寸

适用机针: schmetz 或 Organ UY128GAS  
#65~#90

针间距: ZJ2400(2 针): 3.2, 4.0, 4.8,  
6.4mm

ZJ2500(3 针): 4.8, 5.6, 6.4mm

针杆行程: 31mm

压脚提升高度: 7.0mm (有上饰线)  
8.0mm (无上饰线)

针距调节方式: 按钮式

差动送料调节比率: 最大顺差比: 1:2  
最大逆差比: 1:0.7

差动送料调节形式: 调节杆(能够在运转工  
作中随时调节)

润滑方式: 油泵自动供油

润滑油: 特 18# 高速工业缝纫机油

贮油容量: 1050ml

安装: 半沉式

## 1.Specifications

Dimensions: 500mm(L)x250mm(W)x430mm(H)

Weight: 42kg

Stitch Type: ISO 406, 407, 602 and 605

Applications: Covering seam of knitted wear, etc.

Sewing Speed: Up to 7,000 s.p.m.(without Top  
Cover Thread Mechanism)

6,500 s.p.m.(with Top Cover  
Thread Mechanism)

Stitch Length: 1.4~3.6mm

Stitch number:

8~21 stitch/30mm

7~18 stitch/inch

Needle to be used: Schmetz or Organ UY128GAS  
#65~#90

Needle Distance: ZJ2400 (2 needles): 3.2, 4.0,  
4.8, 6.4mm

ZJ2500 (3 needles): 4.8, 5.6,  
6.4mm

Needle Bar Stroke: 31mm

Presser Foot Raising Height:

7.0mm(with Top Cover Thread)

8.0mm(without Top Cover Thread)

Feed Regulation: By Pushbutton

Differential Ratio:

Maximum Normal differential: 1:2

Maximum Reverse differential: 1:0.7

Differential Feed Regulation: Adjustment during  
operation is possible by moving Lever up and  
down from the outside.

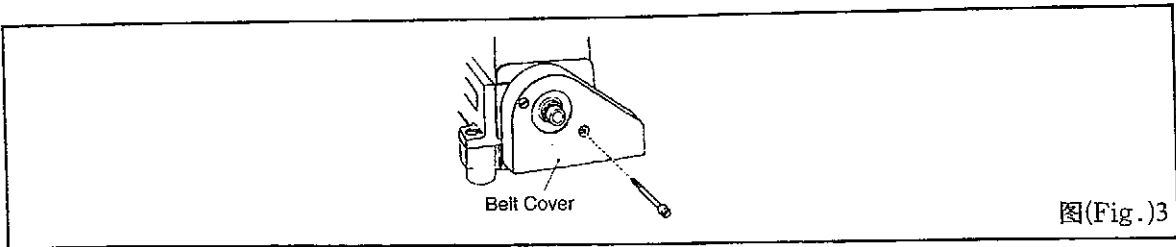
Lubrication: Automatic Lubrication by oil Pump

Lubricating Oil: white oil No.18

Capacity of oil Reservoir: 1050mm

Installation: Semi-submerged type





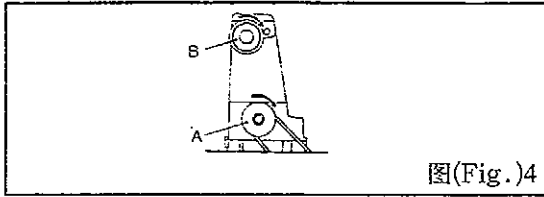
图(Fig.)3

### 3. 缝纫速度和转向

最高转速和常用转速如下表所示。

从机器的使用寿命上考虑,我们推荐先以最高转速的80%~85%运转200小时(约一个月),之后再以常用转速工作。

上轮和手轮都是顺时针转动的(如图4所示)



图(Fig.)4

型号	最高转速(转/分)	常用转速(转/分)
ZJ2411(无上饰线装置)	7000	6500
ZJ2400(有上饰线装置)	6500	6000

### 4. 电机和皮带

用550w三相二极离合式电动机及M型V带。调节电机位置,保证当踏板将电机带轮向左推时电机带轮中心能与机器带轮中心对齐。

电机带轮直径 Diameter of Motor Pulley (mm)	转速(分/转) Number of Rotation	
	50Hz	60Hz
80		4500
90		5000
95	4500	5300
100	4800	5500
105	5000	6000
115	5500	6500
125	5800	7000
130	6000	
140	6500	
150	7000	

注:市场上带轮直径系列间隔为5mm,表中转带为近似值。

The diameters of Pulleys on the market are at 5mm interval, the above measurements are the nearest ones to the calculated value.

### 3. Sewing speed and turning direction

The maximum sewing speed and ordinary speed are shown in the table below.

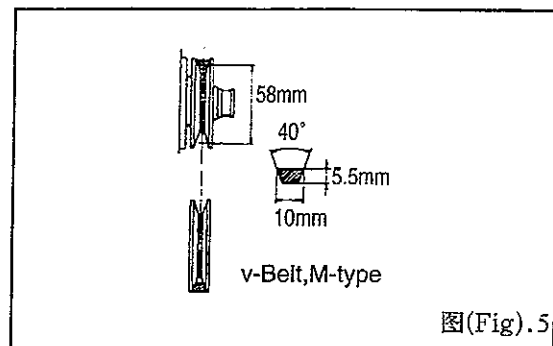
From the point of durability, it is recommended to rotate at the speed about 15~20% lower than max. speed for initial 200 hours (about 1 month) and then at ordinary speed.

The turning direction of Pulley(A) is clockwise like Handwheel(B) as shown in the illustration.(Fig.4)

model	max.sewing speed	ordinary sewing speed
ZJ2411(without Top Cover Thread Mechanism)	7000	6500
ZJ2400(with Top Cover Thread Mechanism)	6500	6000

### 4. Motor and Belt

Use Clutch Motor of 3-phase, 2-pole 550w(3/4 HP) and V-Belt of M-type. Position Motor so that its center aligns with the center of Machine Pulley when the Pulley is shifted to the left by treading Pedal.



图(Fig.)5

## 5. 润滑油

### 5-1 适用润滑油型号

特 18# 高速工业缝纫机油。

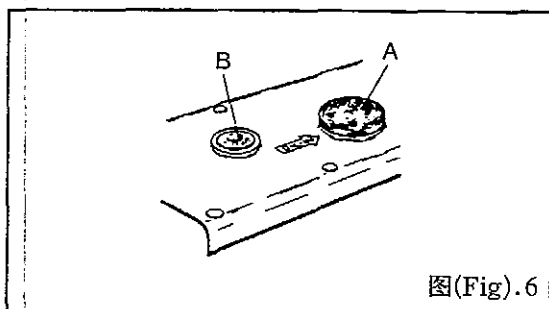
### 5-2 润滑油的加注

因为机器出厂前都已经排干了油,所以使前须将“OIL-IN”所指橡皮塞 A 取下,加润滑油到油标 C 上刻度线为止。(图 6、图 7)

### 5-3 油标和润滑油循环系统的检查

每天开机前检查油量,如果低于下刻度线,就要加油了。

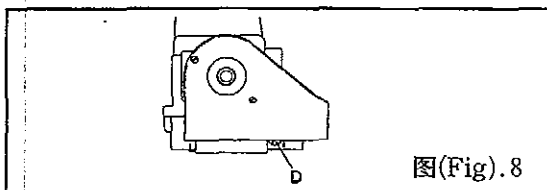
开机时还应确定一下顶盖的视油窗 B 压力油是否有正常喷射。(图 6、图 7)



### 5-4 润滑油的更换

在机器使用过程中,每隔 250 小时就必须将润滑油彻底更换一次。操作步骤如下(图 8):

- ① 拆下 V 带,并将机头从台板上拆下;
- ② 拆去皮带防护附罩;
- ③ 拆去排油螺钉 D,排空残油(别让 V 带碰到油);
- ④ 装上排油螺钉 D 并拧紧;
- ⑤ 参照 5-2 重新加油。



## 5. Lubricating Oil

### 5-1 Oil to be used

Use white oil No.18 as Lubricant

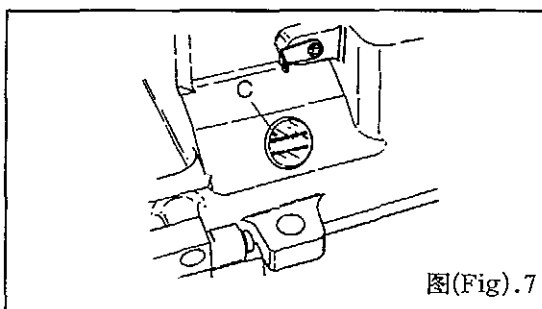
### 5-2 Feeding Oil

As the machine has been completely drained before shipment, replenish it with oil up to the upper line of Oil Sight Gauge(C) by removing rubber Seal Plug(A) indicated "OIL-IN" without fail before operation.(Fig. 6、Fig.7)

### 5-3 Oil sight Gauge and Oil Sight Top Nozzle

Check Oil Sight Gauge (C) everyday before operating machine and if the oil is below the lower line,supply oil.

Make sure that oil comes out of Nozzle (B).(Fig.6、Fig.7)



### 5-4 Change of Oil

For the long machine life, oil must be changed completely after 250 hour operation, The order of oil change (Fig8):

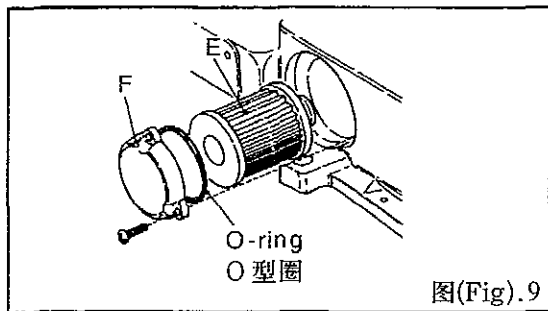
- ① Remove V-Belt from Pulley and remove machine from table;
- ② Remove belt cover;
- ③ After removing Screw(D), drain oil. At this time, take care not to smear V-Belt with oil;
- ④ After draining oil, tighten Screw(D) without fail.
- ⑤ For replenishing oil, refer to 5-2 "Feeding Oil".

### 5-5 滤油器的检查与更换

当滤油E被脏物堵住时, 润滑不好, 就会影响正常供油, 所以每隔6个月就要检查一次滤油器; 当油盘中油很多, 喷油嘴中却不喷油或很少喷油时, 也要检查滤油器。检查滤器要先拆掉滤油器端盖F, 拆卸方法见图示。如滤油器堵住时, 就必须清洁或更新滤油器。(图9)

注意: 拆滤油器端盖时别把油溢出来。

无论是加注或更换润滑油及滤油器清理时都应注意不要让V带及机内同步齿形带沾上机油。



## 6. 正确操作

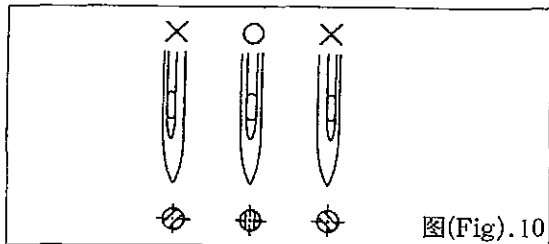
### 6-1 机针的选用

本机应使用Schmetz或Organ UY128GAS型机针。下表列出常用的针号以供选用:

日本规格 Japanese sizes	9	10	11	12	13	14
公制规格 Metric sizes	65	70	75	80	85	90

### 6-2 机针的安装

安装机针时要使机针缺口朝后。(图10)



### 6-3 穿线方法

参照图示方法正确穿线, 不正确的穿线会引起跳针、断线、线迹不均匀等等。

A, B, C: 针线, D: 上饰线, E: 底线  
插图是三针绷缝机穿线图。(对于双针绷缝机只有

### 5-5 Checking and replacement of Oil Filter

When Oil Filter(E) get clogged with dirt, the proper lubrication is impossible. Check Filter every 6 months. When the oil does not or very little comes out of Nozzle in spite of sufficient oil is in reservoir, check the Filter. The checking of Oil Filter is made by removing Oil Filter Cap(F). When Oil Filter gets clogged, replace it.(Fig.9)

Note: Be careful not to spill the oil collected on Filter when removing Oil Filter Cap.

Whenever oil feeding or exchanging of oil, cleaning of filter, care must be taken, not to contaminate V belt and timing belt inside the machine.

## 6. Proper Operation

### 6-1 Needle to be used

Needle to be used is Schmetz or Organ UY128GAS.

There are many Needle sizes and most suited size should be selected.

### 6-2 Fixing of Needle

At the time of replacement of Needle, fix it correctly with its scarf just facing backward as shown in the illustration.(Fig.10)

### 6-3 Threading

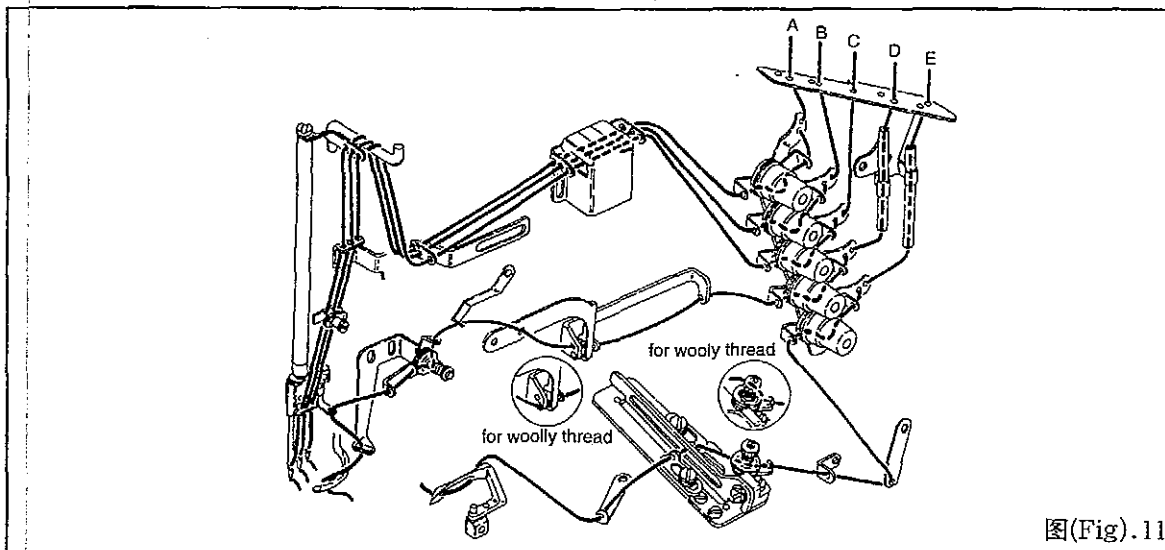
Make threading correctly referring to the illustration. Incorrect threading may cause skip stitch, thread breakage, uneven seam etc.

2根针线)

A, B, C; Needle Thread, D: Top Cover Thread, E; Loper Thead

\* The illustration shows the threading for 3 needle machine.

(2 needle thread, in case of 2 needle machine)



#### 6-4 线的张力

线的张力与缝线、线迹宽度、针距等等有关。所以在保证行到稳定、均匀的线迹的前提下，应尽量调松缝线的张力。

注：具有调节方法见“缝纫机调整”中的相关条款。

#### 6-4 Thread tension

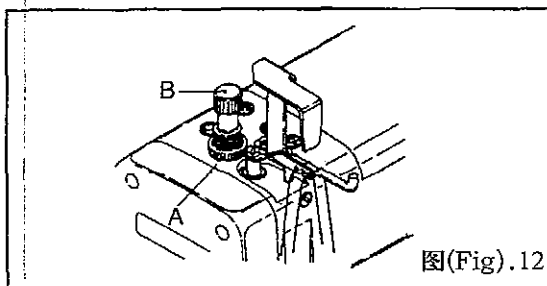
Thread tension changes according to thread to be used, stitch width, stitch length, etc..

Make the thread tension as weak as possible according as the sewing condition so long as stable seam can be obtained.

Note: Refer to the clause regarding thread tension of "Adjustment of Sewing Machine".

#### 6-5 压脚的压力

当松掉锁紧螺母A向右旋螺钉B时，压脚压力增大，向左旋时减小。如压力调整不当则会影晌送料和线迹的质量，所以在调整压力时应在保证缝制要求下，压力尽量小。(图12)



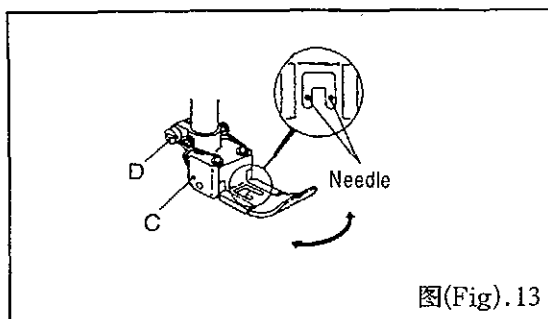
#### 6-5 Pressure of Presser Foot

When turning Adjusting Screw(B) to the right after loosening Lock Nut(A), the pressure of Presser Foot becomes strong and turning to the left, it becomes weak.

Imperfeet feeding or poor stitch will be caused if the pressure of presserfoot is not properly. so that the pressure should be as weak as possible so long as Presser Foot can follow.(Fig.12)

### 6-6 压脚的调整

当机针在压脚上的落针不正确时,应调节压脚针孔的位置。其调整方法为:先松掉螺钉D,将压脚C左右调整,使机针能刚好落在压脚针孔中心,然后旋紧螺钉D。(图13)



图(Fig).13

### 6-6 Adjustment of Presser Foot

As for the adjustment of lateral position of needle drop point of Presser Foot(C), loosen Screw(D) and moving the tip of Presser Foot laterally against it so that the needle drops into the center of needle drop point and then tighten Screw(D).(Fig.13)

### 6-7 油量的调节

机头上部前腔的供油量可以通过油量调节螺钉E调节,松掉螺母F,向左旋转油量调节螺钉,供油量增加;反之向右旋转,供油量减小。油量调节螺钉上的开槽e必须在标记G、H之间(不要把开槽朝向G、H之外)。(图14、图15)

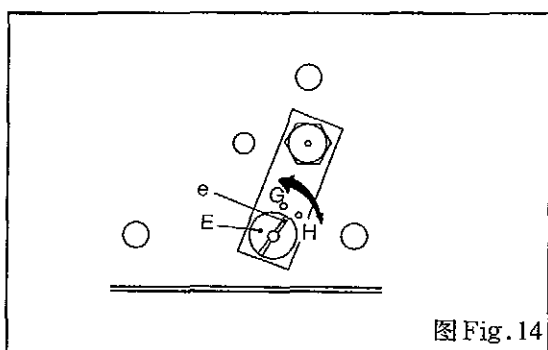


图 Fig.14

### 6-7 Adjustment of feed amount of oil to Connecting Rod

When turning Oil Adjusting Screw(E) to the left, the feed amount increases and turning to the right it decreases. Adjustment is made by loosening Nut(F). The slot (e) for screw-driver of Oil Adjusting Screw(E) to be in the middle between the mark(G) and (H) is the standard.

Note: Do not set slot (e) outside of the mark (G) and (H).(Fig.14, Fig.15)

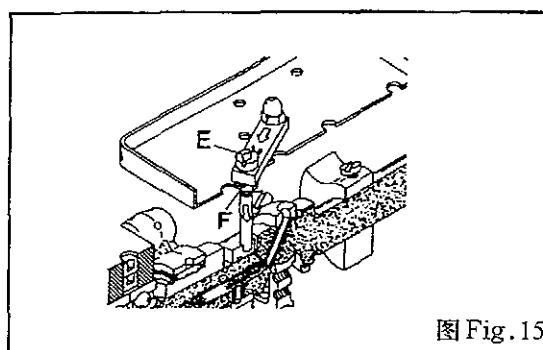


图 Fig.15

### 6-8 针距的调节

针距可以在1.4mm到3.6mm范围内进行无级调整。下表示每寸及30mm的针数。

### 6-8 Adjustment of stitch length

Stitch length can be adjusted continuously from 1.4mm to 3.6mm. The table below shows the number of stitches per inch and per 30mm.

针迹距 stitch length (mm)	针 stitches per-	
	inch	30mm
3.6	7	8
2.4	10.5	12.5
1.4	18	21

\* 针距的调节

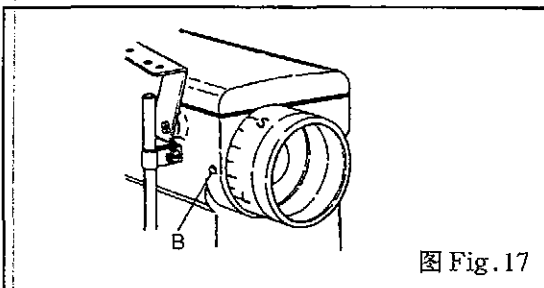
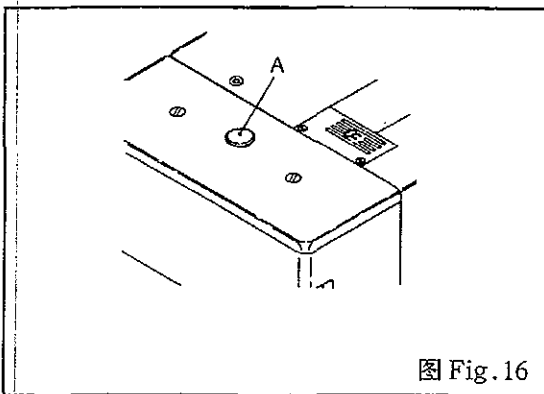
松开针距保险板，左手轻轻按下按钮A，右手转动手轮，直到按钮A落下去，使劲按下A，向右转动手轮。(图16)

向右旋转手轮，使刻度“L”靠近标记“B”时，针距变大，当刻度“L”对齐标记“B”时，针距最大(约3.6mm)；相反，向左旋转手轮，使刻度“S”靠近标记“B”时，针距最小(约1.4mm)。即使在相同刻度，针距也因布料的种类、厚度、差动量的不同而变化，这时须重新调整手轮刻度到合适的位置。(图17)

注：调节针距时，要确保电机开关在“OFF”位置。

\* 针距保险板

用此保险板保持预置针距。先松掉螺钉C，将按钮保险板C向上推，并接触按钮A，然后拧紧螺钉C。(图18)



\* Change of stitch length

Press Push-button(A) with left hand lightly until its tip can be noticed to touch inner parts. Press it lightly, turn Handwheel with right hand until the Pushbutton drops in, then press in the Pushbutton strongly and turn Handwheel.(Fig.16)

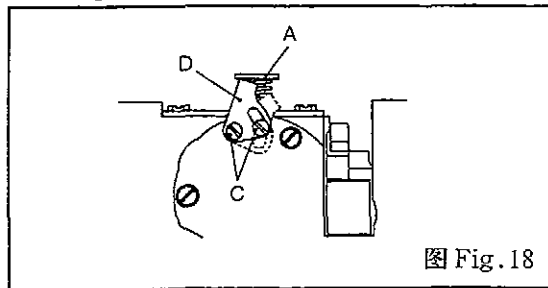
When getting graduation "L" closer Mark(B) by turning Handwheel to the right, the stitch length becomes long.(Fig.17)

At the position "L", the stitch length is about 3.6mm. When getting graduation "S" closer to Mark(B) by turning Handwheel to the left, the stitch length becomes short. At the position "S" the stitch length is about 1.4mm. Even with the same graduation, the stitch length varies according to the kind and thickness of fabrics and amount of differential, etc. In that case, re-adjust Handwheel for proper position.

Note: When changing stitch length, turn Switch of Motor "OFF" without fail.

\* Push-button Stop

Use this Stop(D) to keep determine stitch length. To actuate the Stop, loosen Screw (C), turn Pushbutton Stop(D) upward and set it under Pushbutton then tighten Screw (C).(Fig.18)



## 6-9 差动送料的调节

### ① 顺差动送料(收缩缝)

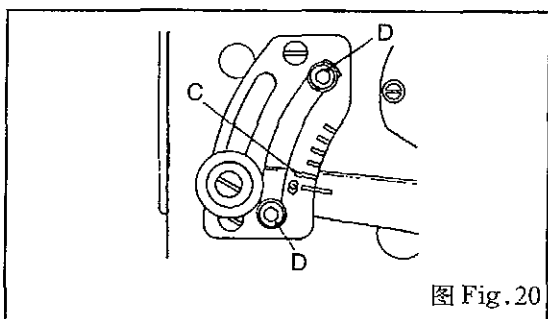
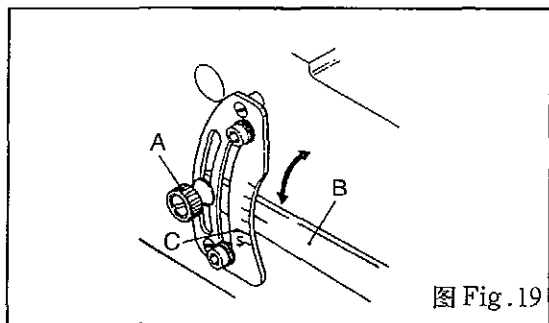
松开螺母A, 上下调整差动调节杆B至预期位置后拧紧螺母A。当差动调节杆上的刻度补给。对准刻度板上的长刻度C时, 主送料量和差动送料量之比为1:1。当差动调节杆上的刻度高于刻度板上的长刻度C时, 送料为顺送差动送料, 从下到上刻度依次代表: 1:1.25, 1:1.75, 1:2。(图19、图20)

### ② 逆差动送料(拉伸缝)

当差动调节杆上的刻度低于刻度板上的长度刻C时, 送料为逆差动送料, 差动调节杆上的刻度对准刻度“S”时, 主送料量与差动送料量之比为1:0.7。

③ 将差动调节杆连上一根链子, 可以在操作过程中调节差动比。设置2个限位螺钉D分别在合适的位置来限制差动调节杆的移动范围。

差动比和不同针距之间关系如下表所示



## 6-10 机针冷却和线润滑

在高速缝纫时, 因针与缝料加速磨擦使用机针产生高温, 因而会造成断线、跳针以及缝料上针刺孔变大, 特是用合成纤维的缝线和缝料时, 更是出现以上现象。为了减少以上现象, 本机装有机针冷却装置(“HR”装置)和针线润滑装

## 6-9 Adjustment of differential feed

### ① Normal differential feed (shrink sewing)

Loosen Nut(A), moving Lever(B) up and down and set it at the desired position by tightening Nut(A). When Lever is set at graduation(Long)(C), the ratio of main feed to differential feed is 1:1, When Lever is raised above this graduation, it becomes normal differential feed. Graduation of upper part represent 1:1.25, 1:1.5, 1:1.75, 1:2 in order from the bottom.(Fig.19, Fig.20)

### ② Reverse differential feed (stretch sewing)

When the Lever is lowered below graduation(Long)(C), the Feed becomes reverse differential feed. When it is set at “S”, the ratio of main feed to differential feed is 1:0.7.

③ Adjustment of differential feed during operation. To adjust differential feed during operation, connect a Chain, etc. to Lever. Fix Stopper (D)(2pcs.) at the desired position to set upper and lower limits between which Lever is moved up and down.

\* The range of Differential Ratio varies according to the stitch length. Please refer to the table below.

针距 stitch length	最大顺差比 max. normal differential ratio	最大逆差比 max. reverse differential ratio
3.6	1:1.2	1:0.7
2.5	1:1.6	1:0.7
2.0	1:1.8	1:0.7
1.4	1:2	1:0.7

## 6-10 “HR” and “SP” Unit

In case of sewing a high speed, sometimes temperature of needle rises by the friction with material causing such troubles as thread breakage, skip stitch and enlargement of needle hole on the fabrics especially when using

置(“SP”装置),最有效的是在这些装置中加入硅油。(图21)

注意:经常打开油箱盖A、B检查油时,不足就补给。

我们推荐使用“HR”装置和“SP”装置,但是根据缝纫情况,当针和线不接触干毛毡缝纫效果更好时,就不使用这些装置,把干毛毡拆下来。

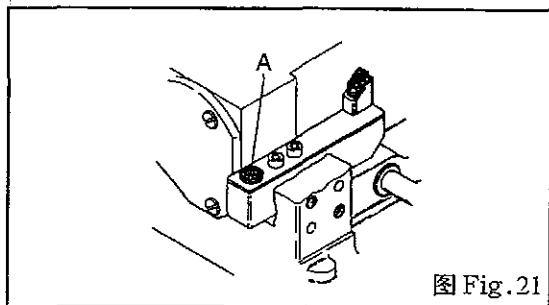


图 Fig.21

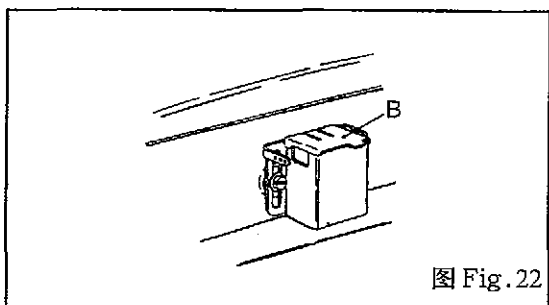


图 Fig.22

synthetic thread and fabrics. To reduce this trouble, “HR” Unit (Needle Point Cooling Device) and “SP” Unit (Needle Thread Oiling Device) are attached as the standard equipment. Most effective oil is silicone system. (Fig.21、Fig.22)

Note: Open Seal Plug(A) of HR Container and Lid(B) of SP Container and check the oil if it is running short, supply it.

We recommend to use “HR” and “SP” Unit but if the oiling is not necessary judging from sewing condition, it will be better for thread and needle not to touch dry Felt in the units. In this case, Felt should be removed.

## 7. 缝纫机调整

### 7-1 针线张力

当针杆处于上限位置时,针线挑线杆A的a边处于水平状态,其顶部距螺钉B中心为52mm,这是标准的。紧线时,先松螺钉B,将针线挑线杆向Y向移动,相反,松线时向X向移动。如果通过以上调整针线张力还未能调好,可以松掉螺钉C移动油箱固定板来调整,向Y向移动时线收紧,向X向移动时线放松,在标准状态下,穿线孔上边缘到螺钉C中心距离为8mm。(图23、图24)

\*有些线不易形成针线环,弯针不易勾住线,引起跳针。这时可将线从面线过线器中穿过。(图25)

注:这样的方法不能用于带自动剪线装置的机器,因为刚开始缝制时形不成缝合线。

\*当使用弹性线(如人工合成纤维)时,不能形成稳定的针线环,此时可使用面线调节杆F。当

## 7. Adjustment of Sewing Machine

### 7-1 Needle Thread tension

The part(a) of Needle Thread Take-up (A) is horizontal when its tip is 52mm from the center of Screw(B) and Needle Bar is at its highest position. That is the standard. To tighten needle thread, move Needle Thread Take-up (A) in the direction of (Y), and to release, move it in the direction of (X). This adjustment is made by loosening Screw(B). (Fig.23)

When this adjustment is not sufficient, check thread tension by moving Thread Eyelet (D) after loosening Screw(C). When it is moved in the direction of (Y), the thread is tightened and in the direction(X),the thread is loosened. The upper end of Eyelet is 8mm above the center of Serew(C). That is the

针杆处于最低点时，挑线杆的穿线孔E中心和面线调节杆F上表面相平，而且E、F相互平行，这是标准状态。调整面线调节杆高度和左右位置，要先松掉螺钉G。(图26)

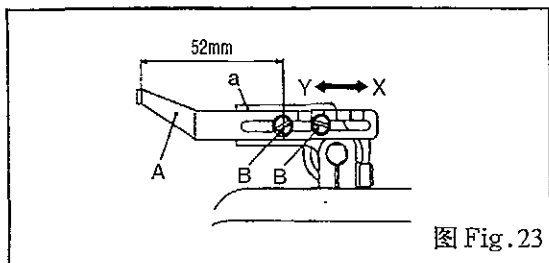


图 Fig.23

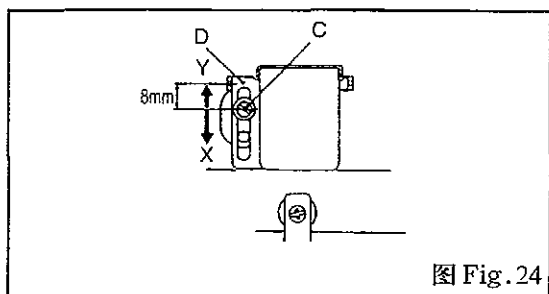


图 Fig.24

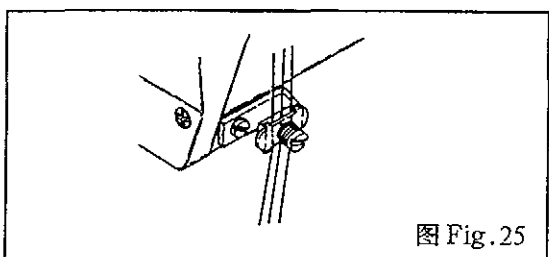


图 Fig.25

standard adjustment.(Fig.24)

\* Some kind of thread is difficult to make needle thread loop, and Loper cannot seize the needle thread—causing skip stitch. In this case, pass the thread through Needle Thread Retainer Disc.(Fig.25)

Note: This method should not be applied to the machine with “UT” Device because the seam will not be formed at the sewing start.

\* When the formation of needle thread loop is unstable because of using stretchable thread like synthetic thread, use Needle Thread Guide. When Needle Bar is at the bottom of ist travel, the center of hole of Needle Bar Thead Eyelet(E) is the same height as the top surface of Needle Thread Guide (F), and (E) and (F) are parallel with each other. That is the standard. Adjust the height and lateral position of Needle Thread Guide (F) by loosening Screw(G).(Fig.26)

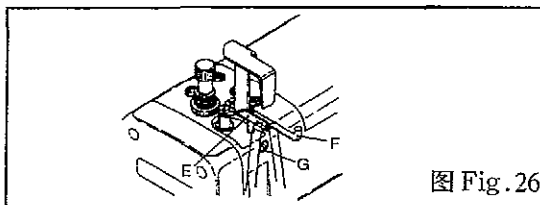


图 Fig.26

### 7-2 上饰线张力

沿 X 向提升右绷线过线板 A，线松弛，沿 Y 向降下右绷线过线板 A，线收紧，当绷线为弹性线(如毛质线)时，线要松弛，松掉螺钉 B，降低右绷线过线板，并将毛质线从右绷线过线板的下孔穿过。(图 27)

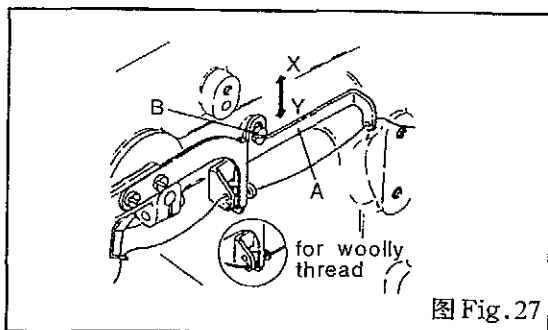


图 Fig.27

### 7-2 Top Cover Thread tension

When raising Top Cover Thread Eyelet (Right)(A) to the direction(X), the thread take-up decreases, and descending it downward the thread take-up increases. When using stretchable thread such as woolly thread for top cover thread, descend Top Cover Thread Eyelet(Right) (A) to the direction (Y) by loosening Screw(B). In case of using woolly thread, pass it through the lower eye. (Fig.27)

### 7-3 底线张力

图示为底线紧线器部件。在标准状态下，过线环 F、G 的穿线孔与挡线板 E 上标记 X 对齐。松线时，将过线环 F、G 同时向前移，紧线时同时向后移。

注意：松线量太大容易跳针。使用毛质线时，将 F 和 G 尽量向前移，不让线通过辅助夹线板 H。(图 28、图 29)

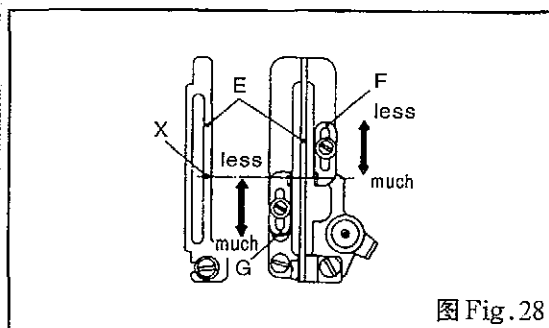


图 Fig.28

### 7-3 Looper Thread tension

The illustration shows the part of Looper Thread Take-up. To adjust the holes of Eyelet (F) and (G) to Mark(X) of Cast-off Plate(E) is the standard adjustment. To increase the running out of thread, loosen Screws of Eyelet(F) and (G) and move Eyelets forward, and to decrease move them backward.

Note: Take care not to increase the running out of thread too much because it may cause skip stitch. When using woolly thread, move Eyelet(F) and (G) all the way to the front and do not pass the thread through Supplementary Tension Disc (H).(Fig.18、Fig19)

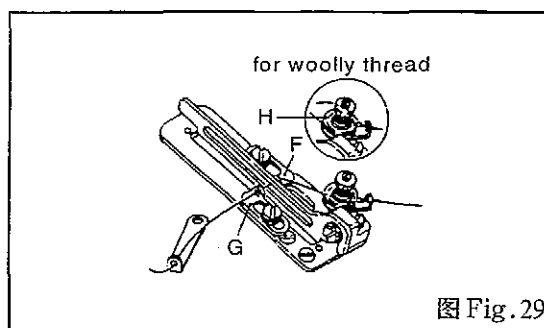


图 Fig.29

### 7-4 底线挑线凸轮的定位

图示为从针杆方向一侧看底线挑线凸轮。

首先转动手轮使针杆从上极限位置降低下来，当左机针降到弯针中间位置时，拨动底线挑线凸轮，使底线恰好能从底线挑线凸轮 I 最高处脱离出来。上述调整是先松开螺钉 J 再调整。(图 30、图 31)

\* 对 ZJ2411 机型，可使挑线凸轮稍滞后一些。

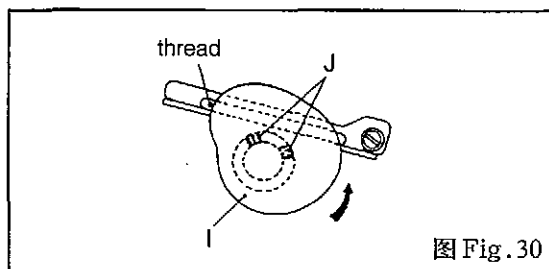


图 Fig.30

### 7-4 Position of Looper Thread Take-up

The illustration shows Looper Thread Take-up viewed from Needle Bar side.

Lower the the needle from its highest position and adjust so that the thread comes off from the highest point of looper thread Take-up (I) when Left needle reaches to the the mid point of Looper, —See the illustration. The adjustment is made by loosening Screw(J). (Fig.30、Fig.31)

\* In case of ZJ2411, delay Looper Thread Take-up a littel.

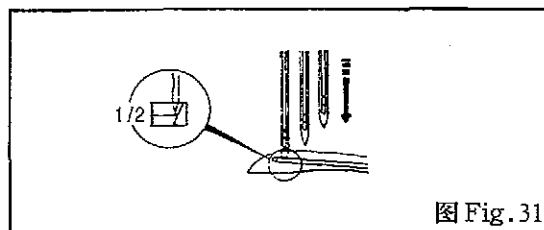


图 Fig.31

### 7-5 压脚的装拆和提升量

松开压脚柄夹紧螺钉H, 按下压脚提升杆E可以拆下压脚。

首先旋松压脚限位板A的固定螺丝B和压脚限位接圈C的紧定螺丝D。压下压脚提杆E, 调整压脚高度, 使压脚底面到针板上表面距离为7mm(带绷针G), 压紧压脚限位板A, 拧紧限位板螺钉B, 同时调整压杆下套F与挡圈C之间距离为0.2mm, 拧紧螺钉D。(图32、图33)

当不装绷针G时, 其压脚提升量为8mm, 而且可免去限位挡圈。

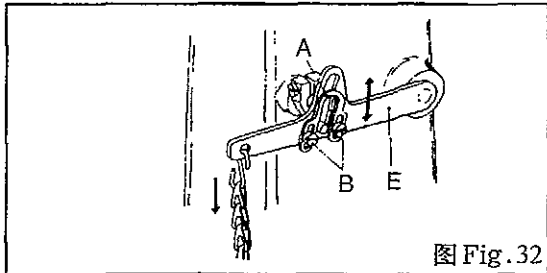


图 Fig.32

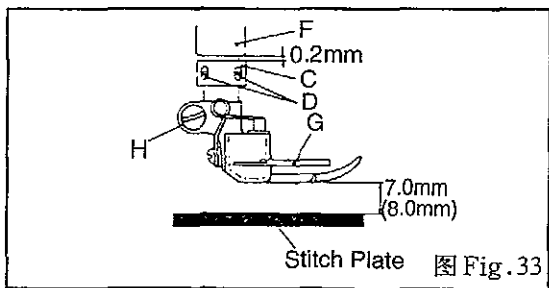


图 Fig.33

### 7-6 机针与针板的配合

针杆高度调整后, 机针须如图中实线所示排成一行, 不要调整成虚线所示。(图34)

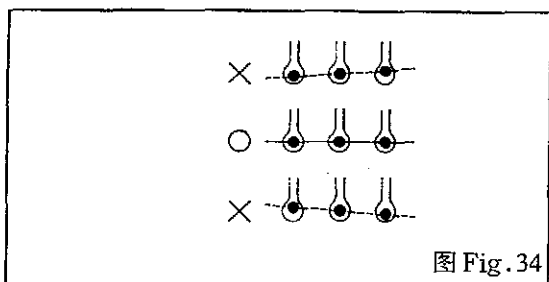


图 Fig.34

### 7-7 弯针的安装角度和高度

将弯针全部插入弯针曲柄A中, 旋紧螺钉B, 高度和安装角 $3^{\circ}$ 也相应设置好了。(图35)

### 7-5 Removing Piesser Foot and amount of Presser Foot lift

When Screw(H) is loosened, remove Presser Foot by pushing Lifter(E) downward. After loosening screw(B) of Lifter lever Stop(A) and Screw(D) of stop Collar(C). Adjust the height of Presser Foot to make the distance from the surface of Stitch Plate to the bottom surface of Presser Foot to be 7.0mm (in case of with Spreader) by pushing down Lifter Lever(E) and then tighten Screw(B) of Lifter Lever Stop(A). Keeping this condition, provide a clearance of 0.2mm between the end surface of Presser Bar Bushing(F) and Stop Collar(C), and tighten Screw(D).(Fig.32、Fig.33)

In case of without Spreader(G), the distance is 8.0mm. Stop Collar is not used in case of without Spreader.

### 7-6 Relation between Needle and Stitch Plate

After adjustment of height of Needle Bar, etc., the needles must be correctly aligned as shown by solid line in the illustration. Pay attention not to be the one as shown by dotted line.(Fig.34)

### 7-7 (Fixing angle and height of Looper)

Insert Looper all the way into Looper Holder(A) and tighten it with Screw(B). Then the height and fixing angle ( $3^{\circ}$ ) are set accordingly.(Fig.35)

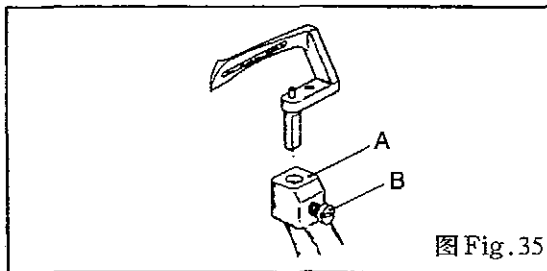


图 Fig. 35

### 7-8 弯针引线量 M 的确定

当机针处于下限位置时,弯针应同步运动至其右限位置(弯针针尖和右机针中心之间的距离 M), M 因机针间距不同而不同,松开弯针曲柄固定螺钉 F, 根据下表调整 M 量。(图 36)

\* 针杆中心到弯针针尖间距离都是 6mm, 与针间距无关。

\* M 量可以用同步规调整, 同步规是单独配件, 可以与我们的办事处或直接与我们联系。

针间距 Needle Distance(Mark)	M 量 Movement of looper to the Right
3.2mm (A)	4.4mm
4.0mm (B)	4.0mm
4.8mm (C)	3.6mm
5.6mm (D)	3.2mm
6.4mm (E)	2.8mm

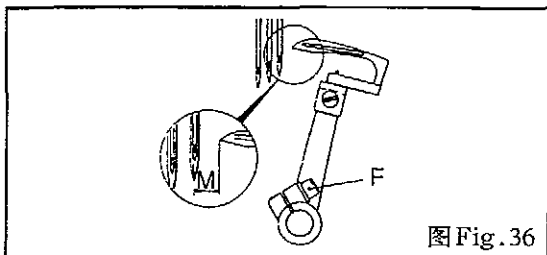


图 Fig. 36

### 7-9 如何作用同步规

同步规上都标上了标记(A, B, C, D, E)来表示相应针间距。当弯针运动到右极限位置时,右边的机针正好在相应针间距的 V 槽中, 调整弯针尖适应同步规, 之后旋紧弯针曲柄固定螺钉。(图 37)

### 7-8 Movement of Looper to the right

When Needle is at its lowest position and Looper comes all the way to the right, "Movement of Looper to the Right" (M) (distance between the tip of Looper and the center of Needle) is different according to the needle distance. Adjust the "Movement of Looper to the Right" as shown in the table below. The adjustment is made by loosening Screw(F) of Looper Holder.(Fig. 36)

\* The distance to the tip of Looper from the center of Needle Bar is always 6mm regardless of needle distance.

\* The adjustent for movement to the right can be made easily by using Timing Gauge(95220). Timing Gauge in an extra part. Please place an order with our agents or directly with us.

### 7-9 How to use Timing Gauge

Marks (A, B, C, D, E) of each needle distance are stamped on Timing Gauge.

When Looper is all the way to the right, in the condition that the right Needle is in the "V" groove of corresponding Needle distance, apply the tip of Looper to Timing Gauge, then tighten Screw(F) of Looper Holder.(Fig. 37)

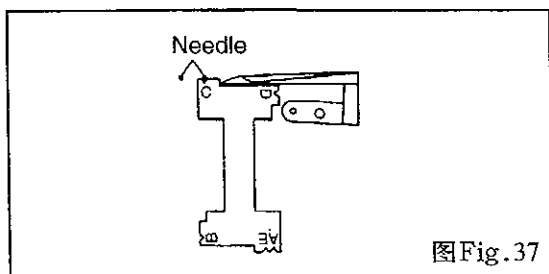


图 Fig. 37

### 7-10 机针的高度

当弯针在摆到左针中心时,弯针针尖应处于应处于左针针眼之上,与针眼孔上缘的距离为0.5~1mm,简单地说,机针高度是以弯针作基准的。当然,机针必须完全插入针夹头,弯针也必须完全插入弯针曲柄。(图 38)

调整机针高度时,从面板上孔A插入螺丝刀松掉针杆连接头螺钉B,上下调整针杆到合适位置,再拧紧螺钉B。(图 39)

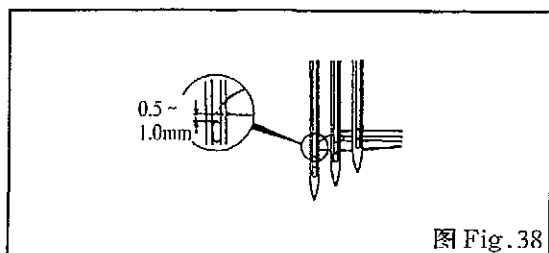


图 Fig. 38

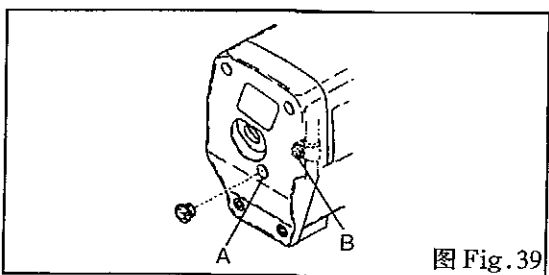


图 Fig. 39

### 7-11 机针与弯针的前后位置关系

\* 三针绷缝机

当弯针针尖运动到左机针中心时,其间隙为0.2~0.3mm;

当弯针针尖运动到中机针中心时,其间隙为0.05~0.15mm;

当弯针针尖右机针中心时,它们会轻微接触(约0.2mm),但必须通过后护针架把右针稍微前推,使右机针与弯针针尖产生间隙为0~0.05mm。

### 7-10 Height of Needle

When the tip of Loper comes to the center of left Needle, the Loper must pass 0.5~1.0mm above the upper end of eye—that is—the height of Needle is set on the basis of Loper. Of course the Needle must be inserted into the hole of Needle Clamp perfectly and Loper must be inserted all the way into Loper Holder.(Fig.38)

The adjustment of height of Needle is made by inserting a Screwdriver through the hole(A) of Head Cover, loosening Screw (B) of Needle Bar Bracket and moving Needle Bar up and down.(Fig.39)

### 7-11 Longitudinal position of Needle and Loper

\* In case of 3 Needles

When the tip(A) of Loper meets the Left Needle(B), the clearance between them must be 0.2~0.3mm.

When the tip(A) of Loper meets the Center Needle (C), the clearance between them must be 0.05~0.15mm.

When the tip(A) of Loper meets the

作上述调整时, 要先松掉弯针曲柄固定螺钉。(图 40)

\* 双针绷缝机

当弯针针尖运动到左机针中心时, 其间隙为 0.2~0.3mm;

当弯针针尖运动到右机针中心时, 它们会轻微接触(约0.2mm), 但必须通过后护针架把右机针销微前推, 使右机针与弯针针尖产生间隙为 0~0.05mm。

作上述调整时, 要先松掉弯针曲柄固定螺钉。(图 41)

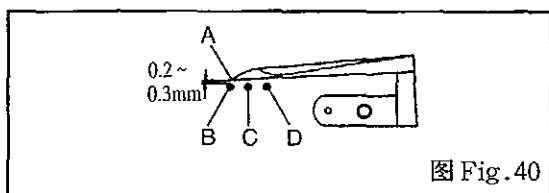


图 Fig.40

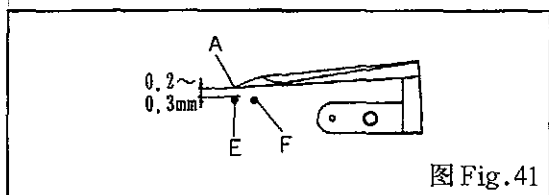


图 Fig.41

7-12 机针与后护针架的位置关系

\* 后护针架高度

当机针处于最低位置时, 后护针架A的棱边a与机针针孔中心重合。(图 42)

\* 后护针架纵向位置

当弯针针尖运动到右机针中心时, 能把右机针稍微前推, 保证机针与弯针针尖的间隙为 0~0.05mm, 同时保证左机针与后护针架的间隙为 0~0.05mm(参考 7-11 条款)。(图 43)

后护针架的调整主要通过松开固定螺钉B、C而进行。(Fig.44)

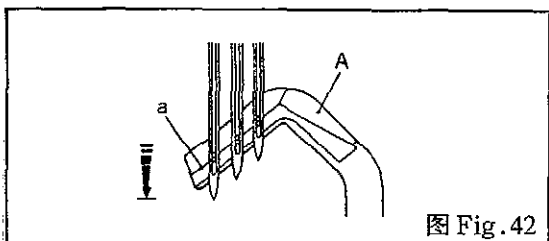


图 Fig.42

Right Needle(D). they contact slightly about 0.2mm. In this case, give the clearance of 0~0.05mm between the tip of Looper and Needle(D) by pushing Needle Guard(Rear) against Needle(D).

The adjustment is made by loosening Screw of Looper Holder.(Fig.40)

\* In case of 2 Needles

When the tip(A) of Looper meets the Left Needle(E), the clearance between them must be 0.2~0.3mm.

When the tip(A) of Looper meets the Right Needle(F), they contact slightly (about 0.2mm). Make the clearance of 0~0.05mm between the tip of Looper and Needle(F) by pushing Needle Guard(Rear).

The adjustment is made by loosening Screw of Looper Holder.(Fig41)

7-12 Needle and Needle Guard(Rear)

\* The height of Needle Guard(Rear)

When the Needle is in its lowest position, align the line(a) of Needle Guard(Rear) (A) with the center of eye of Needle.(Fig.42)

\* Longitudinal Position of Needle Guard (Rear)

When the tip of Looper comes to the center of the Right Needle, make the clearance between Needle and Looper to be 0~0.05mm by actuating Needle guard(Rear), At this time, adjust the clearance between the left Needle and Needle guard(Rear) to be 0~0.05mm (refer to the clause 7-11). (Fis.43)

These adjustments are made by loosening Screw(B) and (C).(Fig.44)

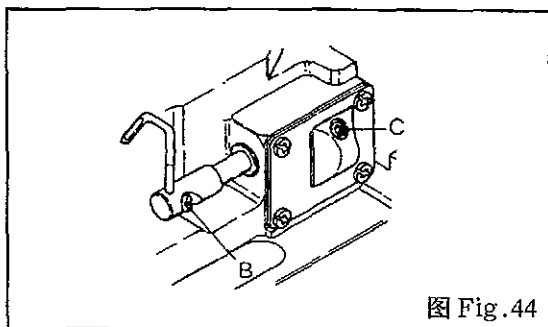


图 Fig.44

### 7-13 机针与前护针板的位置关系

当弯针针尖运动到左机针中心时,调整前护针板与这些机针的间隙为0~0.3mm。作上述调整前,先板掉螺钉E。(图45)

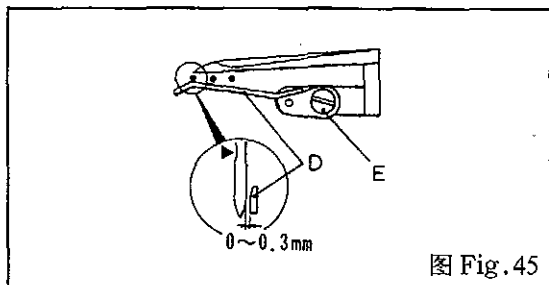


图 Fig.45

### 7-14 送料牙的高度

当送料牙运动上升到最高点时,送料牙的齿面与针板上平面相互平行,此时主送料牙与差送料牙在同一高度,与针板上平面距离为1.0~1.2mm。(图46)

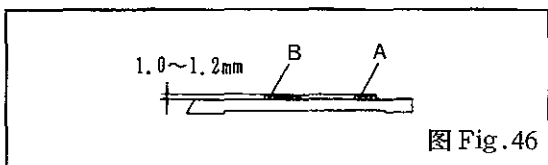


图 Fig.46

### 7-15 上饰线绷针的安装及调整

#### ① 绷针的安装

当绷针A从右向左运动时,其勾线尖a与左机针间隙为0.5~0.8mm,运动到左极限时,其勾线尖与左机针中心距离约为4.5~5.5mm。(图47)

调整绷针底平面距离针板上平面约为9~11mm。(图48)

作上述调整前,先松掉绷针螺钉B和绷针摆动曲柄螺钉C。(图49)

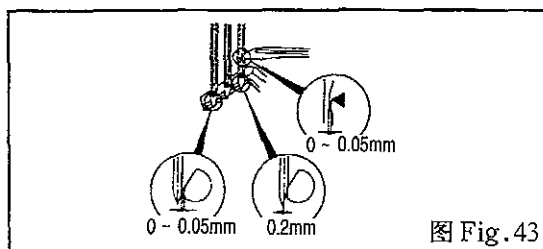


图 Fig.43

### 7-13 Needle and Needle Guard(Front)

When the tip of Loper comes to the center of Left and Right Needle, adjust the clearances between those Needles and Needle Guard(Front) (D) to be 0~0.3mm.

The adjustments are made by loosening Screw(E).(Fig.45)

### 7-14 Height fo Feed Dogs

When Feed Dogs are at the highest position, the surface of Feed Dogs and the surface of Stitch Plate become parallel with each other. At this time, make Differential Feed Dog(A) and Main Feed Dog(B) to be at the same height and adjust the distance from surface of Stitch Plate to the surface of Feed Dogs to be 1.0~1.2mm.(Fig.46)

### 7-15 Needle and Spreader

#### ① Fixing of Spreader

When Spreader (A) moves from right to left. provide a clearance of 0.5~0.8mm between left Needle and tip(a) of thread hooking point, and when it comes to the extreme left, the clearance between the center of Left Needle and tip(a) of thread hooking point must be 4.5~5.5mm.(Fig.47)

② 勒线板的安装

调整勒线板,使勒线板下底面与绷针平面的间隙为0.5mm,并且绷针左到右极限,绷针能顺利地勾住线,此时旋紧螺钉E。(图50)

③ 绷针过线勾的安装

当针杆下降到下限时,调整绷针过线勾F的底面与勒线板D的上平面间隙为1mm,并将绷针过线勾的穿线孔中心安装到勒线板槽的中心延长线上,旋紧螺钉G。(图50、图51)

\* 上述①②③要根据缝纫用线做适当调整。

Adjust the height of undersurface of Spreader(A) above the top surface of Stitch Plate to be 9~11mm.(Fig.48)

This adjustment is made by loosening Screw(B) of Spreader and Screw(C) of Spreader Holder.(Fig.49)

② Fixing of Top Cover Thread Guide Provide a clearance of 0.5mm between undersurface of Top Cover Thread Guide (D) and the top surface of Loooper (A). At the position where the thread is caught smoothly by thread hooking part when Spreader comes to extreme right, tighten Screw(E).(Fig.50)

③ Fixing of Top Cover Thread Eyelet When the needle bar drops to its lowest, provide a clearance of 1.0mm between top surface of Top Cover Thread Guide(D)and undersurface of Top Cover Thread Eyelet (F). Set the hole of Top Cover Thread Eyelet on the extension line of slot of Top Cover Thread Guide then tighten Screw(G).(Fig50、Fig.51)

\* The above ①、② and ③ should be adjusted properly according as the thread to be used.

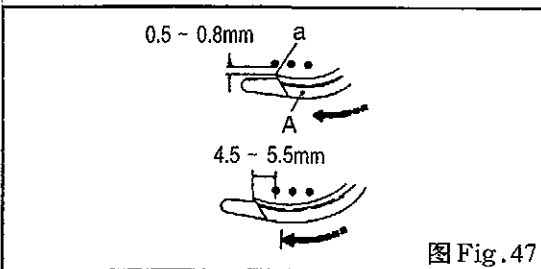


图 Fig.47

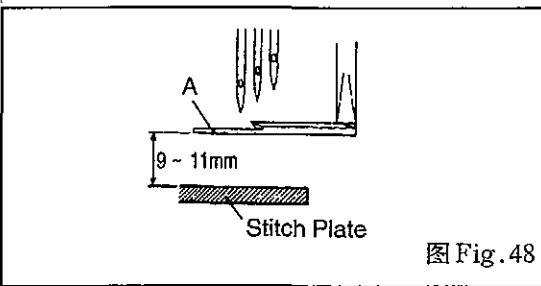


图 Fig.48

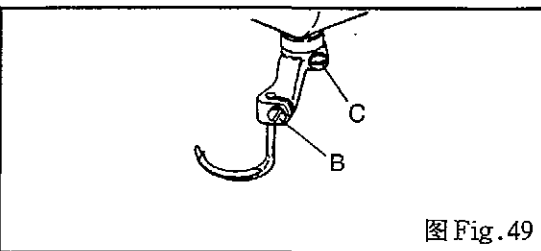


图 Fig.49

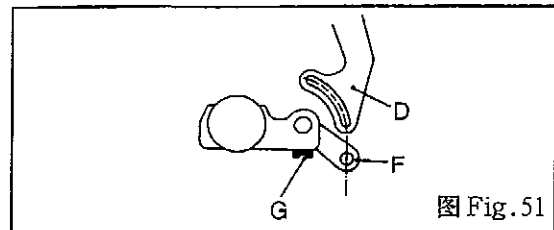


图 Fig.51

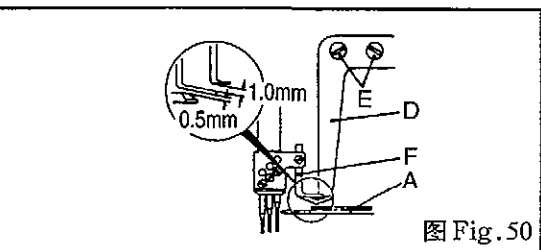


图 Fig.50



**ZOJE**  
中捷

# 超高速绷缝机 ZJ-VF

SUPER HIGH SPEED INTERLOCK SEWING MACHINE

## 零件手册 PARTS BOOK

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

# 零件手册使用说明

零件手册中的零部件是以 ZJ2400 为基础。

从第 1 页到第 13 页列出了基本机型的零部件。

从第 14 开始(包括 14 页)列出了系列产品专用零部件和附带装置。

套类零件都标记出了外形尺寸(内径×外径×厚度)。

零部件订购应注意以下几项:

- ☆ 当需要采购手册中的零部件时, 请清晰地把你所需零部件的件号(例如: 3100026)发送给我们, 以便正确地发送零件。
- ☆ 当需要件号为“0093659”形式时, 采购时可以传送件号“0093659”或“96359”。
- ☆ 当需要采购聚氯乙烯管时, 请把零件件号和管的长度一并发送给我们。  
注: 本零件手册的内容, 为了改良不经预告随时会更改, 请谅解为盼。

## How to use this Parts List

The illustrations on this Parts List are drawn on the basis of ZJ2400.

The items from No.1 to No.13 contain the standard model.

The following items included No.14 contain the submodel and Devices.

The dimension of Collar on this Parts List shows Inside diameter x Outside diameter x Width.

## How to place an order for the parts

☆ When placing an order for the parts from this Parts List, please clearly state the Parts No. (e.g. 3100026) which you require so that we can deliver the correct parts to you.

☆ When the Part No. is“0093659”, please place an order for the part by showing “0093659” or “93659”.

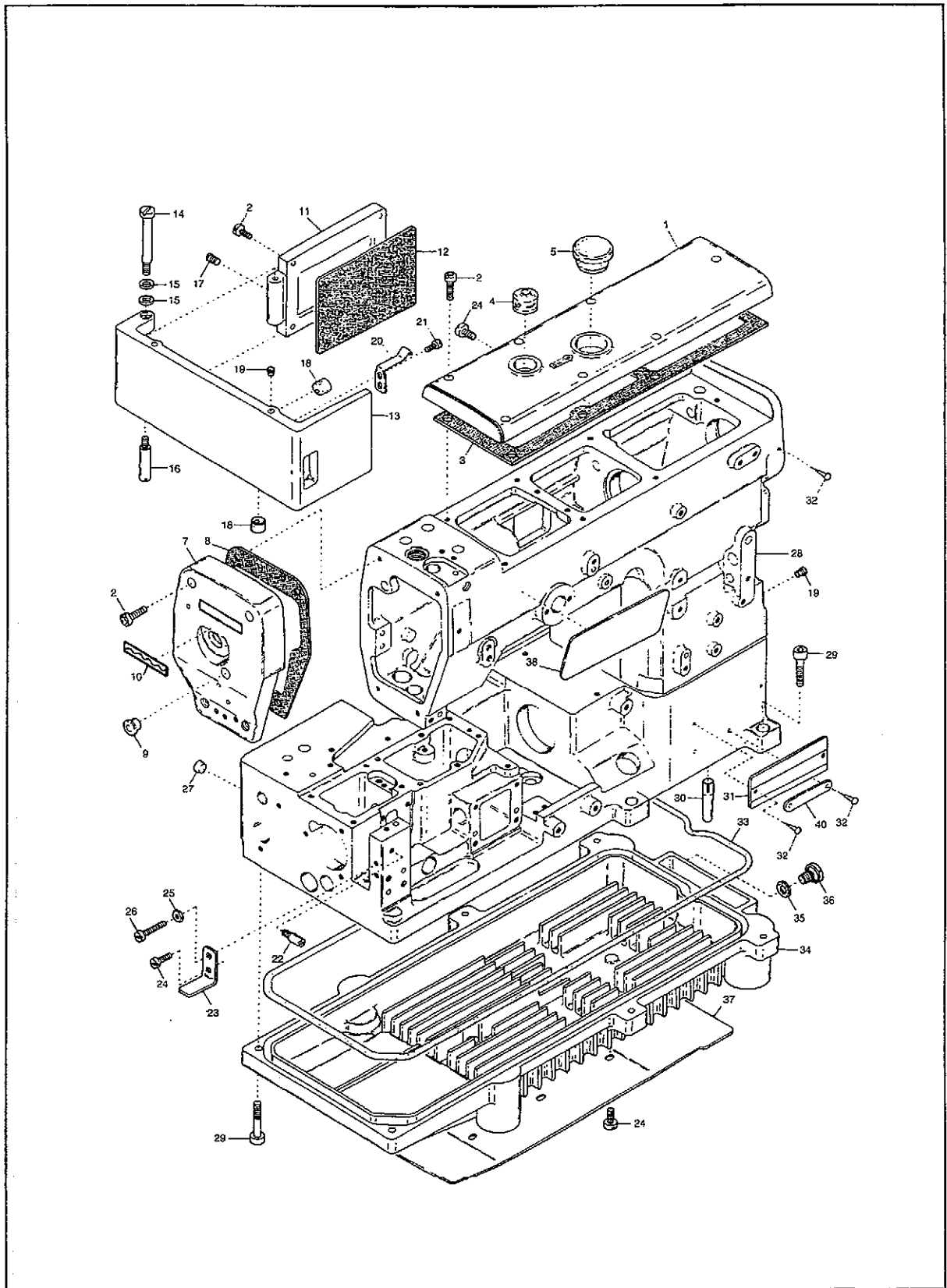
☆ When ordering Vinyl Tube, Please inform us of the Part No. and the length.

Note: The description covered in this PARTS BOOK is subject to change for improvement of the commodity without notice.

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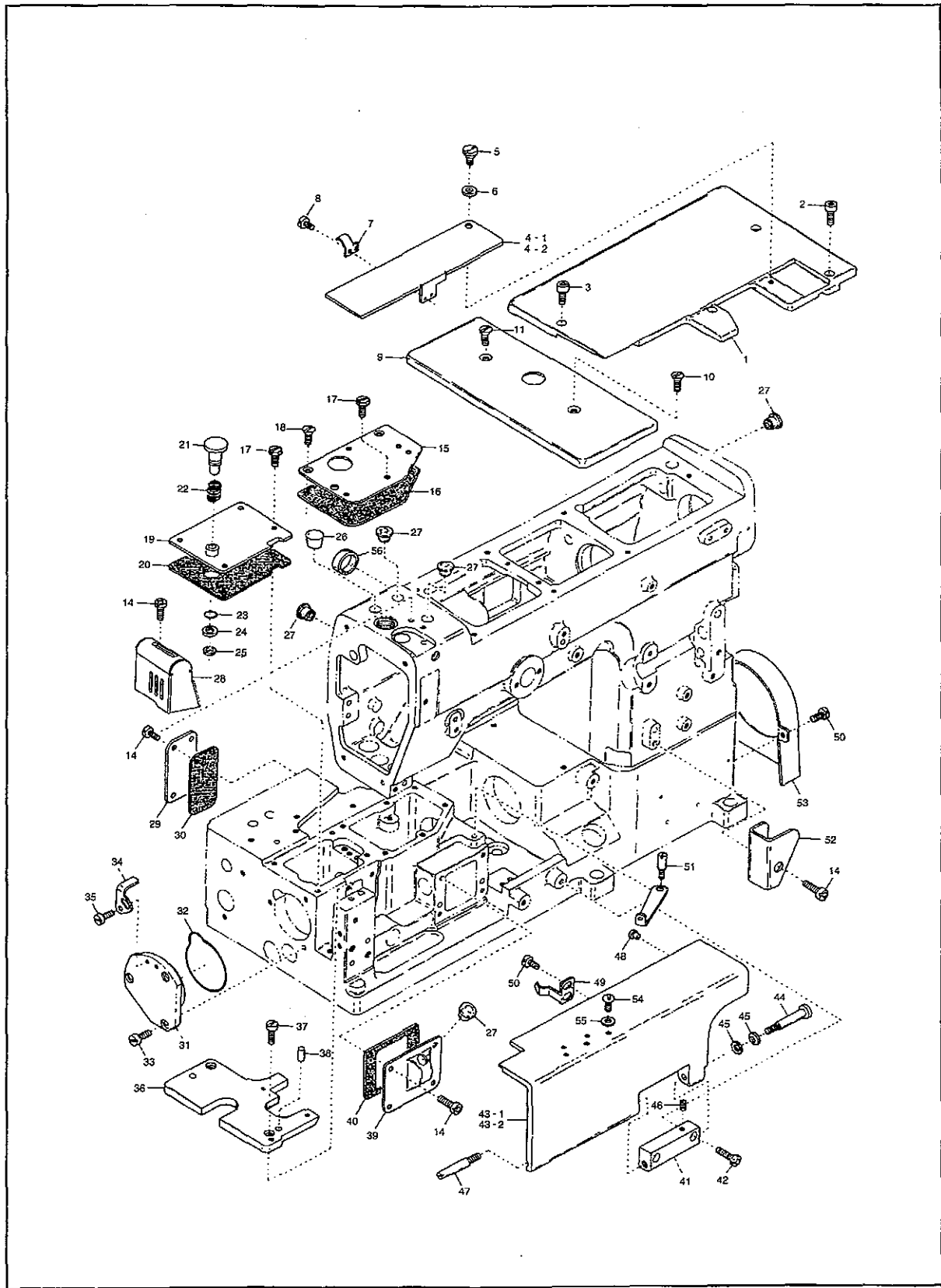
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过线部件	MISCELLANEOUS THREAD EYELETS	3
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## 机壳部件(1)

## MISCELLANEOUS COVERS(1)

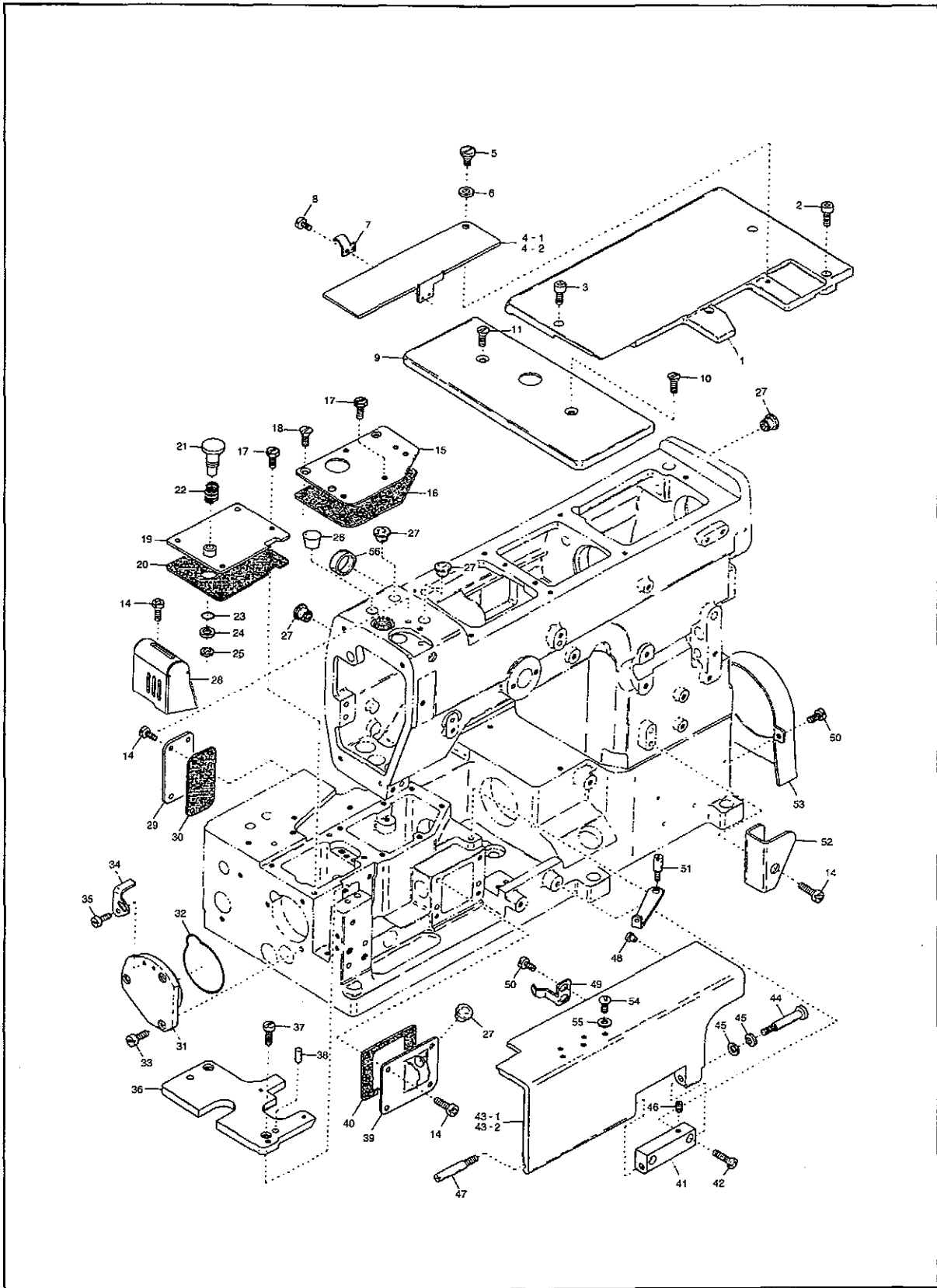
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3100026	机壳上盖板	Top Cover	1
2	110045	上盖螺钉	Screw(M4x2)	15
3	3100027	上盖油垫	Top Cover Gasket	1
4	0068011	上盖油窗	Oil Sight Window	1
5	0020759	上盖油塞	Top Cover Seal Plug	1
6				
7	3100018	面板	Head Cover	1
8	3100019	面板油垫	Head cover Gasket	1
9	0093864	面板油塞	Head Cover Seal Plug	1
10	390073	面板装饰牌	Emblem of Head Cover	1
11	3200010	底板后盖板(大)	Bed Rear Cover	1
12	0095108	底板后盖油垫	Bed Rear Cover Gasket	1
13	3200011	底板左侧罩板	Side Cover	1
14	170001	后盖板铰链轴位螺钉	Screw(M5x8)	1
15	300100	轴位螺钉垫圈	Conical Spring Washer	2
16	180005	后盖板铰链下轴位螺钉	Screw(M5x8)	1
17	160000	上轴位螺钉支头螺钉	Screw(M3x3)	1
18	0032604	左侧罩板内橡皮垫块	Rubber Cushion(Large)	2
19	3200033	左侧罩板上橡皮垫块	Rubber Cushion(Small)	2
20	3200012	左侧罩板锁紧簧	Cover Latch Spring	1
21	110012	锁紧簧紧固螺钉	Screw(M4x5)	2
22	180018	锁紧簧轴位柱	Lock Bar	1
23	3200013	左侧摇摆定位板	Side Cover Holder	1
24	110013	定位板短螺钉	Screw(M4x8)	5
25	000015	长螺钉螺母	Nut	1
26	110016	定位板长螺钉	Screw(M4x15)	1
27	330000	堵塞	Seal Pulg	1
28	3200000	机壳	Machine Frame Unit	1
29	009970	油盘螺钉	Screw(M6x20)	6
30	340016	底板支柱	Machine Frame Supporting Bar	4
31	4109403	型号牌	Model Plate(See the below)	1
32	000726	型号牌铆钉	Rivet	4
33	3200007	油盘防油垫	Oil Reservoir Gasket	1
34	3200006	油盘	Oil Reservoir	1
35	0020137	排油螺钉垫	Drain Hole Seal	1
36	005075	油盘油螺钉	Screw(SM3/8" x24x8)	1
37	3200021	油盘通风盖板	Wind Guide Plate	1
38	390067	中捷标志牌	Brand Name Plate(106)	1
39				1
40	2049401	编号牌	Serial Number Plate	1



## 机壳部件(2)

## MISCELLANEOUS COVERS(2)

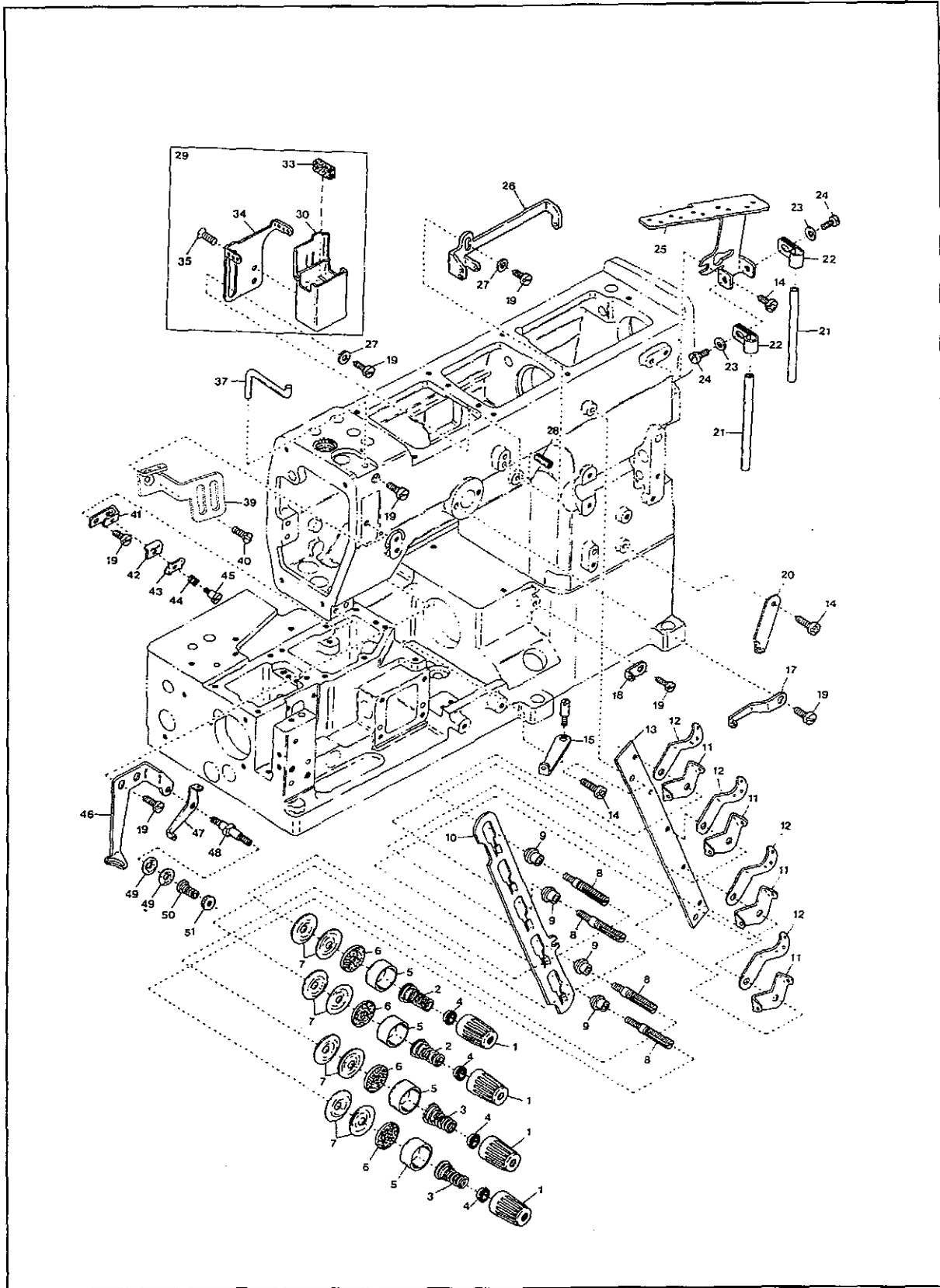
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3200017	缝台	Cloth Plate(Large)	1
2	009749	缝台后螺钉	Screw(M4x16)	3
3	009747	缝台前螺钉	Screw(M4x10)	1
4-1	3200018	缝台摇板	Looper Thead Take-up Cover(32,40,48,56)	1
4-2	3200035	" "	" " (64)	1
5	006004	缝台摇板轴位螺钉	Screw(SM11/64" x40x10)	1
6	000010	轴位螺钉弹性垫圈	Conical Spring Washer	1
7	3200019	缝台摇板锁紧簧	Take-up Cover Spring	1
8	110030	锁紧簧螺钉	Screw(M3x2.6)	2
9	3200014	底板左上盖板	Cloth Plate(Small)	1
10	130003	上盖板前螺钉	Screw(M4x7.3)	1
11	130004	上盖板后螺钉	Screw(M4x14)	1
12				
13				
14	110013	护罩螺钉	Screw(M4x8)	11
15	3200024	主轴上盖板	Bed Top Cover(Right)	1
16	3200025	上盖板油垫	Bed Top Cover(Right) Gasket	1
17	007610	上盖板六角螺钉	Screw(M4x10)	8
18	130006	上盖板沉头螺钉	Screw(M4x10)	2
19	3200022	针距上盖板	Bed Top Cover(Left)	1
20	3200023	针距上盖板油垫	Bed Top Cover(Left) Gasket	1
21	3200209	针距销	Feed Regulating Pushbutton	1
22	0063152	销距销弹簧	Feed Regulating Pushbutton Spring	1
23	0020472	针距销O型圈	O-ring(P6)	1
24	000425	针距销垫圈	Washer	1
25	0033024	针距销开口挡圈	Retaining Ring	1
26	0065275	绷针孔上油塞	Seal Plug	1
27	0093864	绷针曲柄孔油塞	Seal Plug	5
28	3100070	针杆护罩	Needle Bar Guard	1
29	3200028	底板后盖板(小)	Bed Rear Cover(Small)	1
30	3200029	底板后盖板油垫	Bed Rear Cover(Small) Gasket	1
31	3200030	主轴前轴承盖	Ball Bearing Housing	1
32	3200031	主轴前轴承盖油封圈	O-ring	1
33	110035	主轴前轴承盖螺钉	Screw(M4x10)	3
34	3200210	针距保险板	Pushbutton Stop	1
35	110008	保险板螺钉	Screw(M4x5)	2
36	3200032	针板架	Stitch Plate Support	1
37	110041	针板架螺钉	Screw (M4x8)	2
38	000745	针板架定位销	Knock Pin	2
39	3200026	后保针架盖板	Bed Front Cover	1
40	3200027	盖板螺钉	Bed Front Cover Gasket	1
41	3100030	前罩板铰链座	Front Cover Hinge	1
42	110016	铰链座螺钉	Screw(M4x15)	2
43-1	3200015	底板前罩板	Front Cover(32,40,48,56)	1



## 机壳部件(2)

## MISCELLANEOUS COVERS(2)

序号 No.	件号 Parts No.	名称	Description	数量 Number
43-2	3200034	底板前罩板	Front Cover(64)	
44	170020	铰链座右轴位螺钉	Screw(M4x8)	1
45	300100	轴位螺钉垫圈	Conical Spring Washer	1
46	160001	右轴位螺钉支头螺钉	Screw(M4x4)	2
47	180017	铰链座左轴位螺钉	Screw(M4x6)	1
48	3200033	前罩板橡皮垫块	Rubber Cushion(Small)	1
49	3200016	前罩板锁紧簧	Front Cover Spring	2
50	110012	锁紧簧螺钉	Screw(M4x5)	1
51	180018	锁紧簧轴位螺钉	Screw(M4x7)	4
52	3100071	弯针线道护罩	Eyelet Cover	1
53	3200020	主轴带轮罩	Oil Cooling Fan Cover	1
54	110105	前罩板附件螺钉	Screw(M5x12)	1
55	000426	螺钉垫圈	Washer	2
56	310006	后轴套油封	Seal Plug	2
				1



## 过线部件

## MISCELLANEOUS THREAD EYELETS

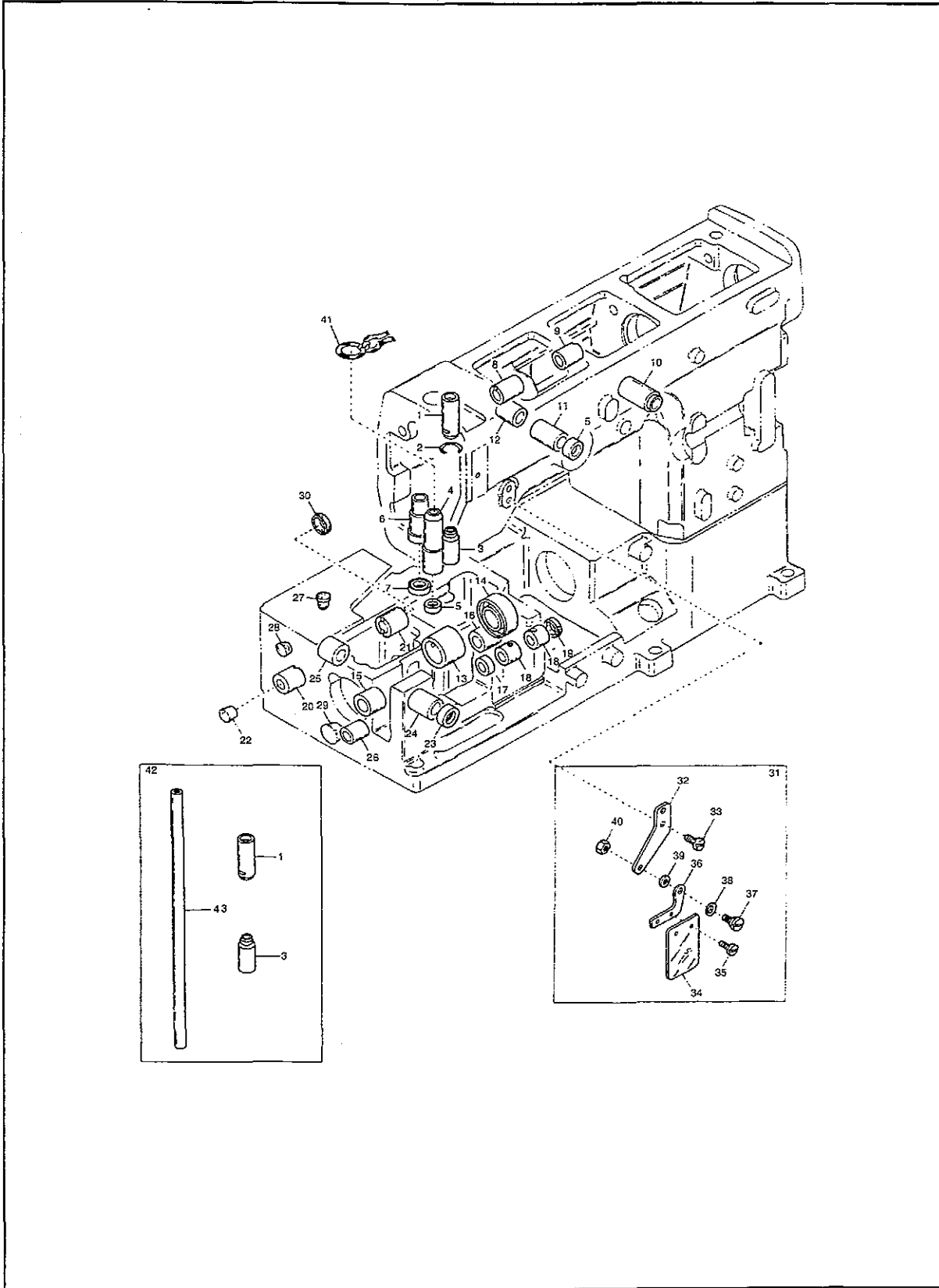
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	0093863	夹线螺母	Thread Tension Spring Cap	4
2	0090814	面线夹线簧	Needle Thread Tension Spring	2
3	3100086	绷线夹线簧	Top Cover Thread Tension Spring	2
4	0093865	夹线定位螺母	Thread Tension Spring cover	1
5	0090071	夹线簧座	Thread Tension Spring Retainer	4
6	000177	夹线板垫	Felt	4
7	0031111	夹线盘	Tension Disc	8
8	009835	夹线螺钉	Tension Post	4
9	0090812	松线板套管	Tension Post Ferrule	4
10	3100075	松线板	Tension Disc Separator	1
11	0090856	双线过线板	Tension Disc Eyelet	4
12	0090807	单线过线板	Thread Lead-in Guide	4
13	3100074	夹线底板	Tension Post Support	1
14	110013	夹线底板螺钉	Screw(M4x8)	5
15	2100065	弯针前过线板	Looper Thread Eyelet	1
16				
17	3200048	左绷线过线板	Top Cover Thread Eyelet(Left)	1
18	3200042	弯针中过线板	Looper Thread Eyelet	1
19	110009	弯针中过线板螺钉	Screw(M4x8)	8
20	0093556	弯针后过线板	Looper Thread Eyelet(Long)	1
21	0020119	面线过线管	Thread Eyelet Pipe(Short)	2
22	0093528	面线过线管夹	Thread Eyelet Pipe Stay	2
23	000532	管夹螺钉垫圈	Washer	2
24	004353	面线过线管夹螺钉	Screw(SM3/64"x40x7)	2
25	0063104	总过线板	Thread Guide Plate	1
26	3200047	右绷线过线板	Top Cover Thread Eyelet(Right)	1
27	000538	过线板螺钉垫圈	Washer	2
28	000651	油箱座销	Guide Pin	1
29	3100382	面线润滑油箱组件	SP Device, Complete Set	1
30	3100381	面线润滑油箱	SP Container	1
31				1
32				1
33	0093526	油箱夹毛毡	Felt	1
34	0093521	油箱座	Needle Thread Eyelet	1
35	005403	面线润滑油箱螺钉	Screw(SM1/8"x44x8)	2
36				
37	0090068	面线调节杆	Needle Thread Guide	1
38				
39	3100442	面线中过线板	Needle Thread Eyelet	1
40	130003	面线中过线板螺钉	Screw(M4x4.5)	1
41	3100087	面线下夹线座	Needle Thread Retainer Support	1
42	0036175	面线过线垫板	Thread Retainer Disc Support	1
43	0032425	面线过线压板	Needle Thread Retainer Dice	1
44	0032426	面线过线压簧	Needle Thread Retainer Spring	1



过线部件

MISCELLANEOUS THREAD EYELETS

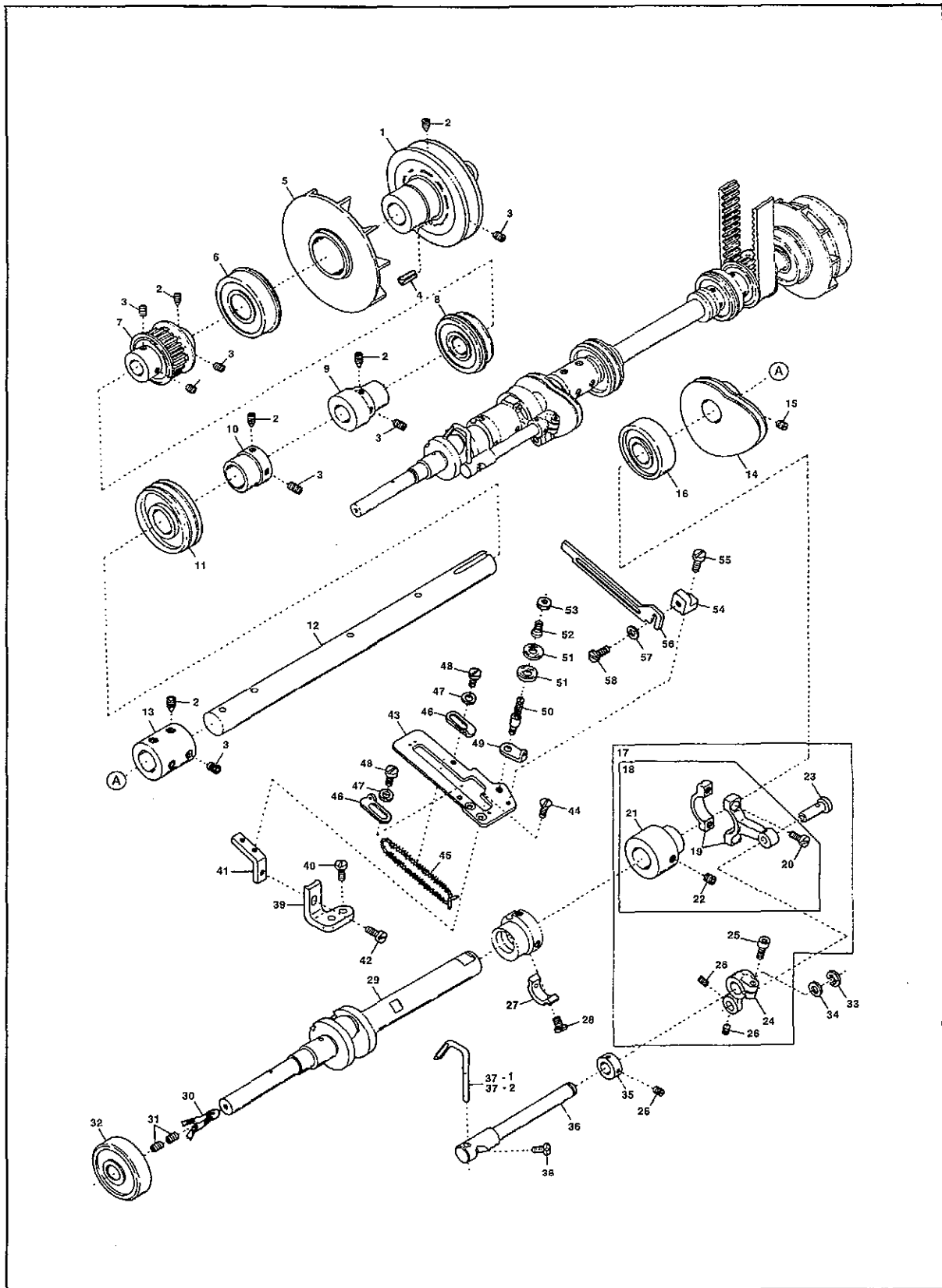
序号 No.	件号 Parts No.	名称	Description	数量 Number
45	001093	面线过线压簧螺钉	Screw(SM1/8"x44x2.2)	1
46	3200045	绷针勒线板	Top Cover Thread Guide	1
47	0063074	绷针过线板	Supplementary Thread Guide	1
48	001818	绷针夹线板螺钉	Tension Post	1
49	0037108	绷针夹线板	Supplementary Tension Disc	2
50	0035813	绷针夹线板弹簧	Supplementary Tension Spring	1
51	000360	绷针夹线板螺母	Nut	1



## 轴套及安全板部件

## MISCELLANEOUS BUSHINGS &amp; EYE GUARD

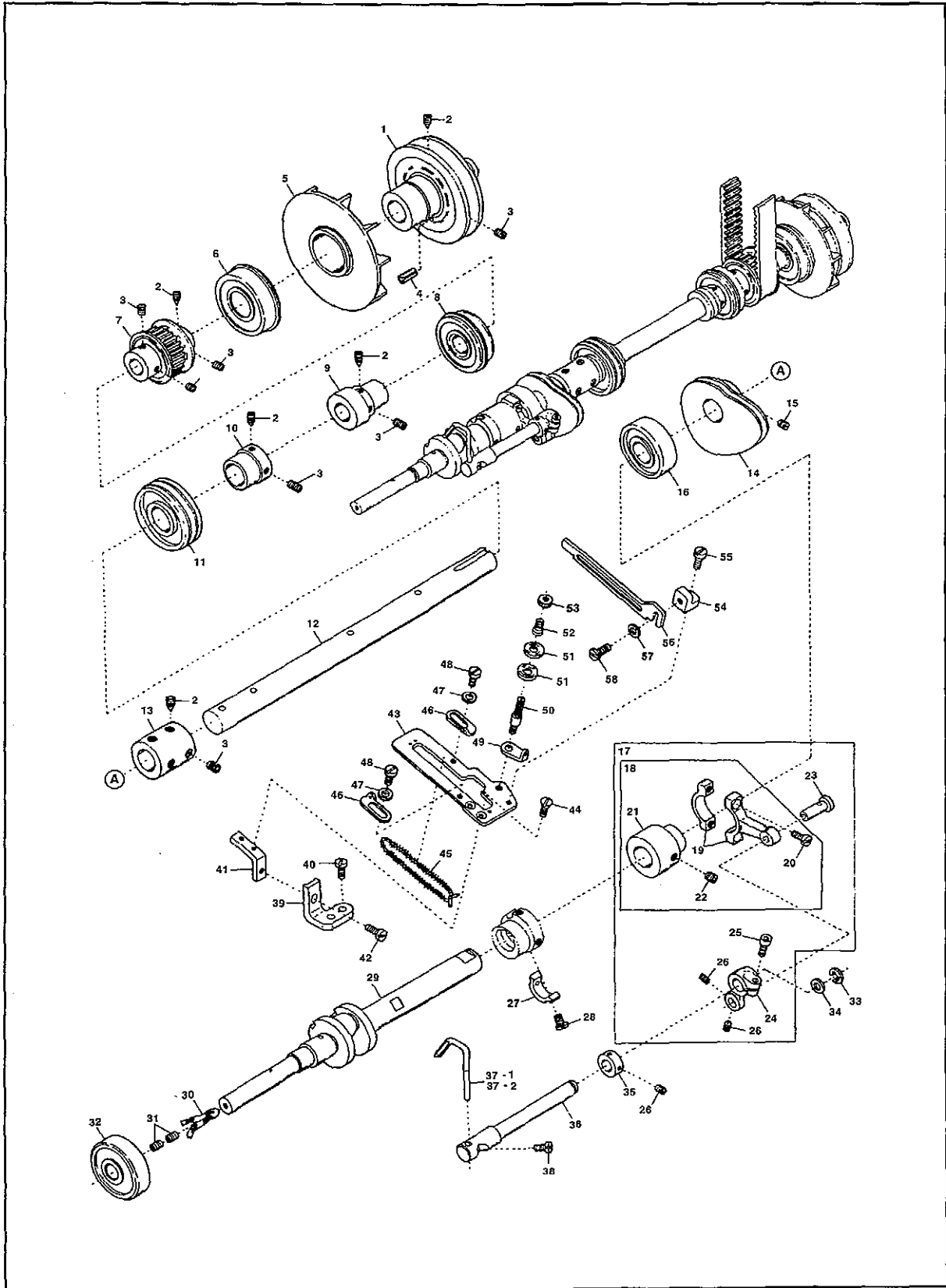
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3200058	针杆上轴套	Needle Bar Bushing(Upper)	1
2	310009	轴套油线	Oil Wick	1
3	3200060	针杆下轴套	Needle Bar Bushinf(Lower)	1
4	3200059	压杆下轴套	Presser Bar Bushing	1
5	0030291	后杆下轴套油封	Oil Seal	2
6	3100100	绷针曲柄轴套	Spreader Driving Bar Bushing	1
7	0063055	轴套油封	Oil Seal	1
8	3200063	绷针轴前轴套	Spreader Driving Shaft Bushing(Left)	1
9	3200064	绷针轴后轴套	Spreader Driving Shaft Bushing(Right)	1
10	3100108	凸轮板销轴套	Foot Lifter Lever Bushing	1
11	0093201	球曲柄轴前轴套	Needle Thread Take-up Bushing(Front)	1
12	3100098	球曲柄轴后轴套	Needle Thread Take-up Bushing(Rear)	1
13	3200050	主轴前节轴套	Lower Shaft Bushing(Left)	1
14	3200067	主轴前节后轴承油封	Oil Seal	1
15	3200062	弯针摆动轴前轴套	Looper Rocker Shaft Bushing(Left)	1
16	3200052	弯针摆动轴后轴套	Looper Rocker Shaft Bushing(Right)	1
17	0077300	前轴套油封	Oil Seal	1
18	3200056	摆轴前后轴套	Needle Guard Driving Shaft	2
19	3200057	后轴套油封	Seal Plug	1
20	3200053	送料轴前轴套	Feed Bar Driving Shaft Bushing(Left)	1
21	3200065	送料轴后轴套	Feed Bar Driving Shaft Bushing(Ringt)	1
22	2100034	前轴套油封	Seal Plut	1
23	0093303	前轴套油封	Oil Seal	1
24	3200061	弯针轴前轴套	Looper Driving Shaft Bushing(Front)	1
25	3200051	弯针轴后轴套	Looper Driving Shaft Bushing(Rear)	1
26	3200055	差动曲柄销轴套	Differential Lever Shaft Bushing	1
27	0093864	底板油塞	Seal Plug	1
28	0065275	调整牙架轴油塞	Seal Plug	1
29	0095218	弯针摆动轴盲孔油塞	Seal Plug	1
30	3200066	后轴套油封	Seal Plug	1
31	3200251	安全板组件	Eye Guard, Complete Set	1
32	3101200	安全架座	Eye Guard, Support	1
33	009784	安全架座螺钉	Screw(M6x10)	1
34	3200252	安全板	Eye Guard	1
35	004236	安全板螺钉	Screw(SM3/32"x56x4.2)	2
36	0060175	安全板架	Eye Guard Hoider	1
37	006004	安全板架轴位螺钉	Screw(SM11/64"x40x7.8)	1
38	000010	轴位螺钉弹性垫圈	Conical Spring Wsasher	1
39	000547	轴位螺钉垫圈	Washer	1
40	000334	轴位螺钉螺母	Nut	1
41	000195	后杆下轴套油线	Oil Wick	1
42	3200109	针杆组件	Nddele Bar & Needle Bar Bushing, C, Set	1
43	3200110	针杆	Needle Bar	1



主轴部件

MAIN SHAFT DRIVING MECHANISE

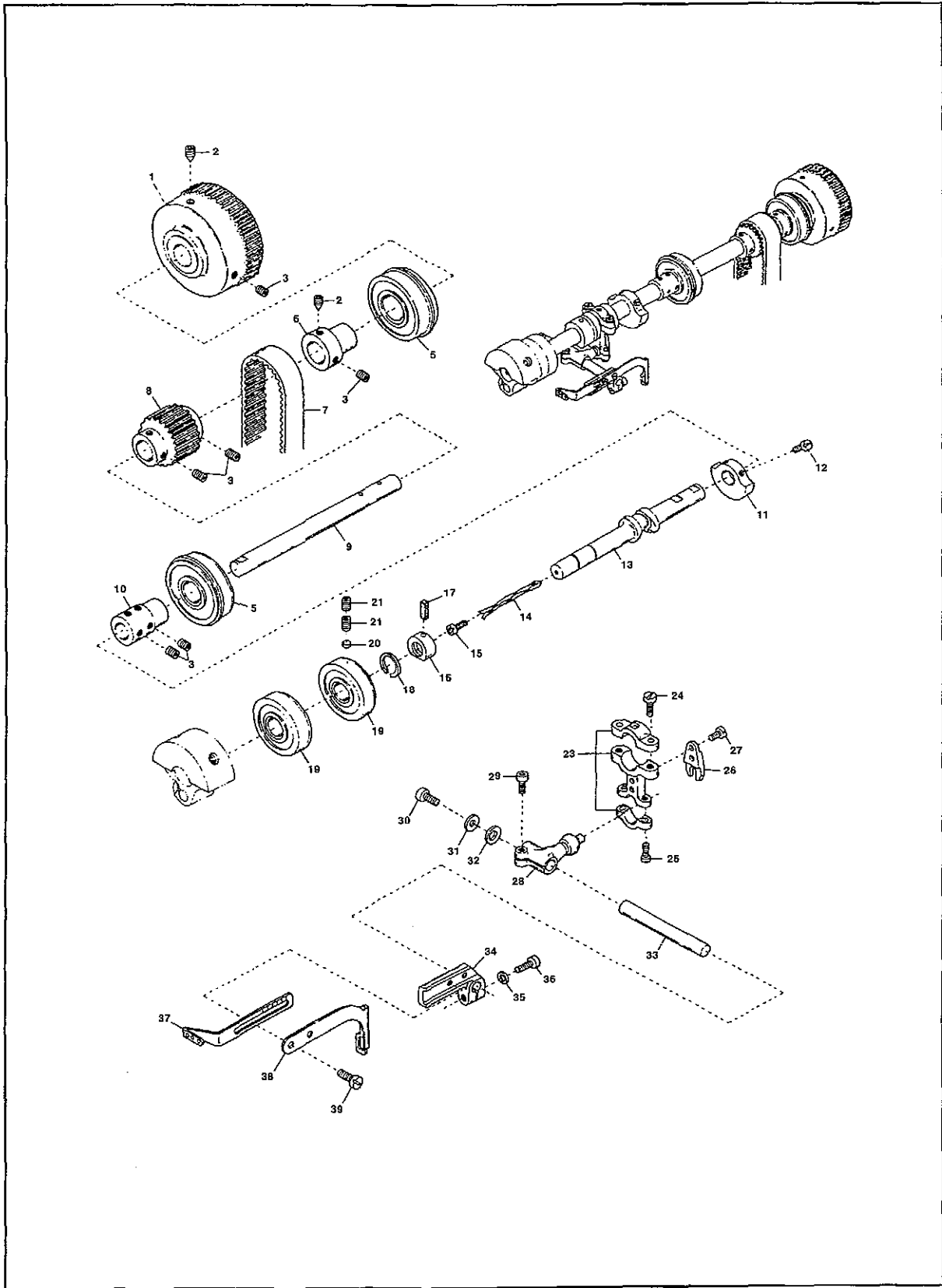
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3200070	主轴带轮	Pulley	1
2	160005	主轴带轮定位螺钉	Screw(M6x8)	5
3	160007	主轴带轮螺钉	Screw(M6x6)	9
4	000037	冷却轮定位销	Roll Pin	1
5	3200071	冷却轮	Oil Cooling Fan	1
6	3200095	主轴后节后轴承	Ball Bearing(Right)	1
7	3100128	主轴同步齿形带轮	Main Shaft Sprocket(Lower)	1
8	0093090	主轴后节中轴承	Bsll Bearing(Middle)	1
9	3200072	油泵蜗杆	Oil Pump Driving Worm	1
10	3100129	主轴后节前轴承挡圈	Adapter	1
11	3200078	主轴后节前轴承	Ball Bearing(Left)	1
12	3200073	主轴后节轴	Lower Shaft(Right)	1
13	3200074	主轴联接套	Lower Shaft Joint	1
14	3200076	弯针挑线凸轮	Looper Thread Take-up	1
15	008047	凸轮片紧固螺钉	Screw(SM7/32"x32x3.6)	2
16	0093091	主轴前节后轴承	Ball Bearing	1
17	3200080	后保针架连杆组件 2	Needle Guard Connecting Rod, C.Set(2)	1
18	3200079	后保针架连杆组件 1	Needle Guard Connecting Rod, C.Set(1)	1
19	3200082	后保针架连杆	Needle Guard Connecting Rod	1
20	110005	上盖螺钉	Screw(M3.5x12)	2
21	3200081	弯针后保针架偏心轮	Needle Guard Eccentric	1
22	160003	后保针架偏心轮螺钉	Screw(M5x5)	2
23	3200087	后保针架小连杆销	Connecting Rod Pin	1
24	3200084	后保针架小连杆	Needle Guard Driving Shaft Arm	1
25	005650	小连杆夹紧螺钉	Screw(M5x14)	1
26	160000	小连杆销螺钉	Screw(M3x3)	4
27	3200077	偏心轮平衡块	Counterweight	1
28	110036	平衡块螺钉	Screw(M3x6.5)	2
29	3200075	主轴前节轴	Lower Crankshaft	1
30	310035	主轴前节油线	Oil Wick	1
31	160001	主轴前节油线塞螺钉	Screw(M4x4)	2
32	0020159	主轴前节前轴承	Ball Bearing	1
33	0068202	摆轴挡圈	Retaining Ring	1
34	3200085	摆轴垫圈	Spacer	1
35	3200086	摆轴紧圈	Collar(Ø48xØ13x6mm)	1
36	3200083	后保针架摆轴	Needle Guard Driving Shaft	1
37-1	0093659	弯针后保针架	Needle Guard(Rear) (32, 40, 48, 56, 64)	1
37-2	0093669	" " 特制	" " (Extra)	1
38	110083	后保针架螺钉	Screw(M3.5x4.5)	1
39	3200093	弯针挑线凸轮架座	Supporting Plate Stay(Lower)	1
40	110035	凸轮架座螺钉	Screw(M4x10)	2
41	3200092	凸轮架座连接板	Supporting Plate Stay(Upper)	1
42	110009	连接板螺钉	Screw(M4x8)	1
43	3200091	挑线凸轮架	Supporting Plate	1



主轴部件

MAIN SHAFT DRIVING MECHANISE

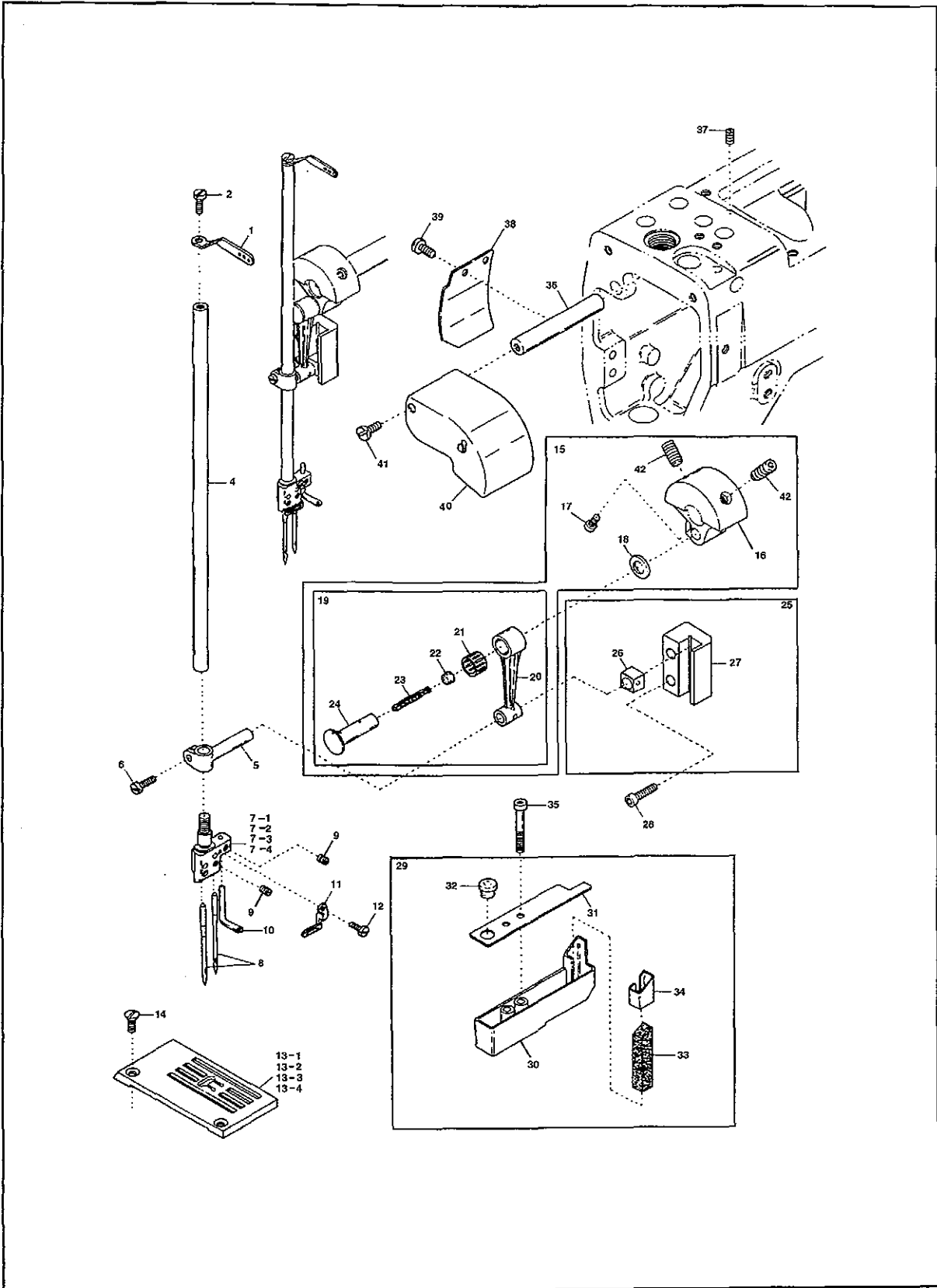
序号 No.	件号 Parts No.	名称	Description	数量 Number
44	130002	挑线凸轮架螺钉	Screw(M3x6)	2
45	000463	弯针线毛刷	Laced Wire	1
46	0093515	挑线凸轮架左右过线环	Thread Take-up Eyelet	2
47	000014	左右过线环螺钉垫圈	Washer	2
48	001227	左右过线环螺钉	Screw(SM1/8"x44x3.8)	2
49	3200042	夹线器过线板	Looper Thread Eyelet	1
50	001818	挑线凸轮架夹线螺钉	Tension Post	1
51	0037108	挑线凸轮夹线板	Supplementary Tension Disc	2
52	0035813	夹线板弹簧	Supplementary Tension Spring	1
53	00360	夹线板螺母	Adjusting Nut	1
54	0063197	挑线凸轮挡线座板座	Cast-off Plate Bracket	1
55	001223	挡线板座螺钉	Screw(SM9/64"x40x7.5)	1
56	3200094	挑线凸轮挡线板	Cast-off Plate	1
57	000532	挡线板螺钉垫圈	Washer	1
58	004106	挡线板螺钉	Screw(SM9/64"x40x6.5)	1



## 上轴及挑线部件

## UPPER SHAFT &amp; NEEDLE THREAD TAKE-UP MECHANISM

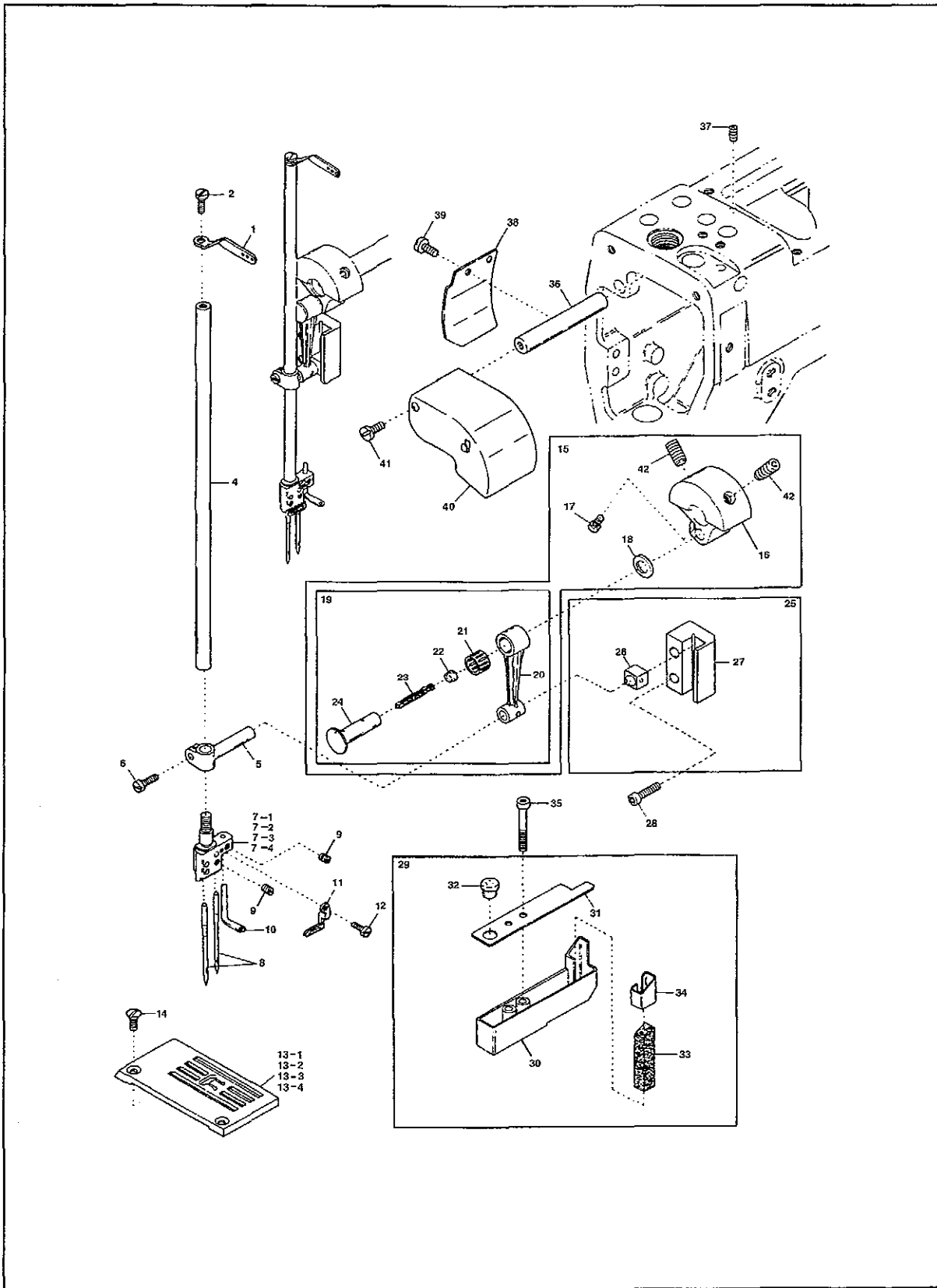
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3200102	上轴手轮	Handwheel	1
2	160005	上轴手轮定位螺钉	Screw(M6x8)	2
3	160007	上轴手轮螺钉	Screw(M6x6)	10
4				
5	0093090	上轴后轴承	Ball Bearing	2
6	3100129	上轴后轴承挡圈	Handwheel Adapter	1
7	0095214	同步齿轮带	Timing Belt	1
8	3100281	上轴同步齿形带轮	Upper Shaft Sprocket(Upper)	1
9	3100275	上轴后节轴	Upper Shaft (Right)	1
10	3100283	上轴联接套	Upper Shaft Joint	1
11	3100127	上轴前节轴平衡块	Counterweight (Small)	1
12	110009	平衡块螺钉	Screw(M4x8)	2
13	3200100	上轴前节轴	Upper Crankshaft	1
14	310040	上轴前节油线	Oil Wick	1
15	110012	上轴前节油线螺钉	Screw(M4x4)	1
16	3200226	上盖前节进油套	Oil Sleeve	1
17	000290	进油套毛毡	Oil Wick	1
18	0060057	上轴前节开口挡圈	Retaining Ring	1
19	0093154	上轴前节轴承	Ball Bearing	2
20	000926	轴承支头螺钉垫	Rubber Seat	1
21	160004	轴承支头螺钉	Screw(M6x4.8)	2
22				
23	0095170	面线挑线连杆	Connecting Rod	1
24	005071	连杆上盖螺钉	Screw(SM11/64" x32x14)	2
25	001174	连杆下盖螺钉	Screw(SM9/64" x40x10.3)	2
26	0095168	球曲柄导向叉	Guide Fork	1
27	004312	球曲柄导向叉螺钉	Screw(SM1/8" x44x7.9)	2
28	3100285	面线挑线球曲柄	Driving Lever	1
29	120013	球曲柄螺钉	Screw(M6x15)	1
30	120015	球曲柄轴端面螺钉	Screw(M5x10)	1
31	000555	端面螺钉垫圈	Washer	1
32	3100286	球曲柄垫圈	Spacer	1
33	3100287	球曲柄轴	Driving Shaft	1
34	3100078	面线挑线杆座	Bracket	1
35	000600	挑线杆座弹簧垫圈	Spring Washer	1
36	005650	面线挑线杆座螺钉	Screw(M5x14)	1
37	0063096	面线挑线杆	Needle Thread Take-up	1
38	3200049	绷线挑线杆	Top Cover Thread Take-up	1
39	110004	挑线杆螺钉	Screw(M3.5x8)	2



## 针杆部件

## NEEDLE BAR MECHANISM

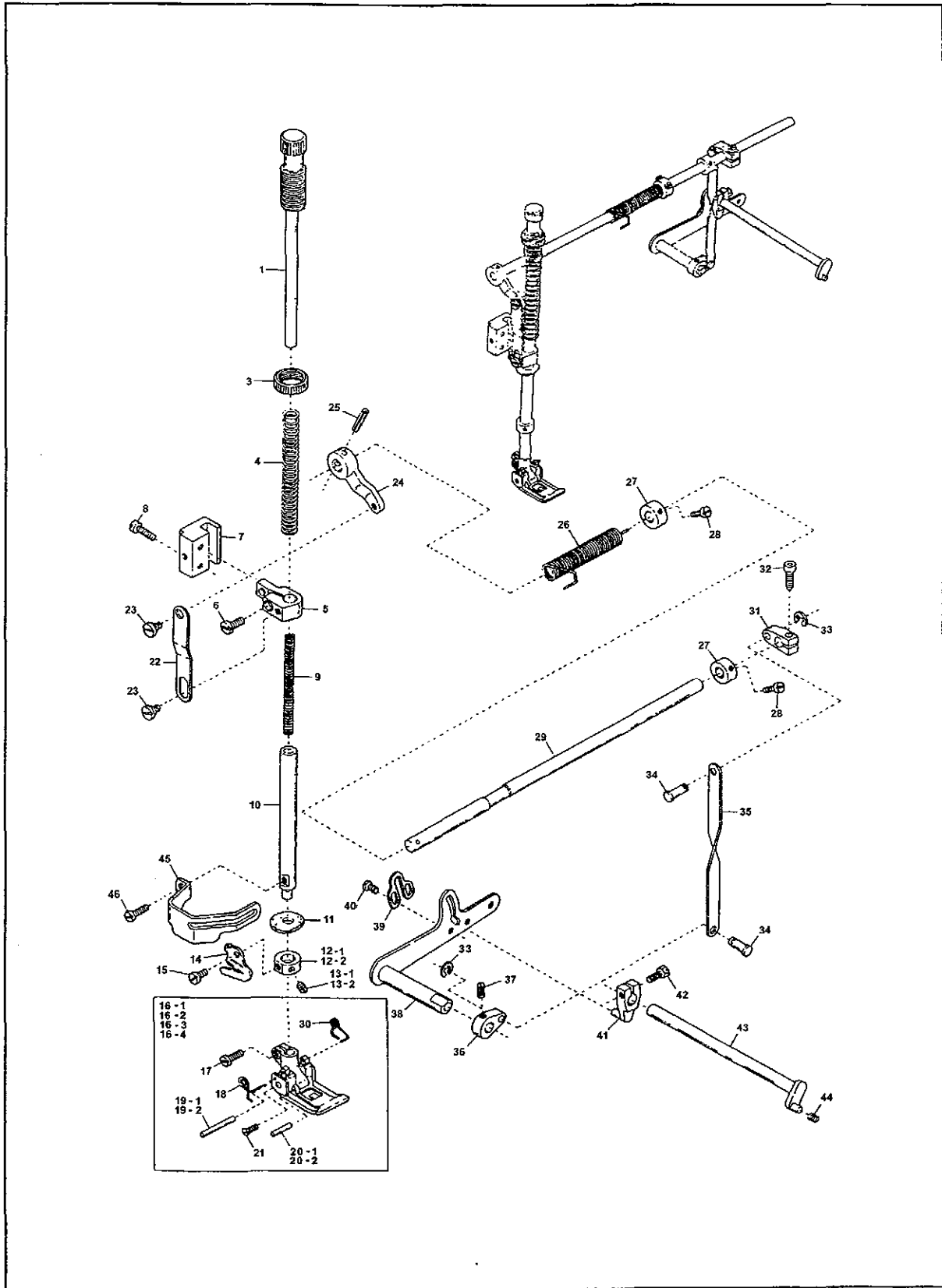
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3200041	针杆挑线杆	Needle Bar Thread Eyelet	1
2	004358	针杆挑线杆螺钉	Screw(SM9/64"x40x5.6)	1
3				
4	3200110	针杆	Needle Bar	1
5	3200111	针杆连接柱	Needle Bar Bracket	1
6	110035	针杆连接柱螺钉	Screw(M4x10)	1
7-1	3209100	针夹(32)	Needle Clamp(32)	1
7-2	3209101	" (40)	" " (40)	1
7-3	3209102	" (48)	" " (48)	1
7-4	3209104	" (64)	" " (64)	1
8		机针	Needle (UY128 GAS)	2
9	001892	机针螺钉	Screw(SM1/8"x44x2.9)	3
10	3200046	绷针过线勾	Top Cover Thread Eyelet	1
11	3200117	针夹三眼过线板	Needle Clamp Eyelet	1
12	001230	针夹三眼过线板螺钉	Screw(SM3/32"x56x3.8)	1
13-1	0093170	针板(32M)	Stitch Plate(32M)	1
13-2	0093171	" (40M)	" " (40M)	1
13-3	0093172	" (48M)	" " (48M)	1
13-4	0093174	" (64M)	" " (64M)	1
14	009142	针板螺钉	Screw(SM9/64"x40x4.8)	2
15	3200115	针杆曲柄组件	Counterweight, Complete Set	1
16	3200101	针杆曲柄	Counterweight	1
17	120015	针杆连杆接销螺钉	Screw(M5x10)	1
18	0093214	滚针轴承垫圈	Connecting Rod Ring	1
19	3200114	针杆连杆组件	Connecting Rod, Complete Set	1
20	3200112	针杆连杆	Connecting Rod	1
21	0093212	针杆连杆滚针轴承	Roller Bearing	1
22	330000	油线塞	Seal Plug	1
23	000309	针杆连接销油线	Oil Wich	1
24	3200113	针杆连接销	Connecting Rod Pin	1
25	3200118	针杆滑块导轨组件	Needle Bar Guide, C. Set	1
26	0093186	针杆连接柱滑块	Slide Block	1
27	3200116	针杆滑块导轨	Needle Bar Guide, C. Set	1
28	009749	针杆滑块导轨螺钉	Screw(M4x16)	2
29	3200120	机针冷却组件	HR Device, Complete Set	1
30	3200121	机针冷却油箱	HR Cup	1
31	3200122	油箱盖	HR Cup Lid	1
32	0093864	油箱油塞	Seal Plug	1
33	310036	机针冷却油毡	HR Felt	1
34	0093663	油毡夹	HR Felt Guard	1
35	006219	油箱螺钉	Screw(M4x14)	2
36	3200090	罩板销	Connecting Rod Cover Shaft	1
37	160023	罩板销螺钉	Screw(M4x4)	1
38	3200089	针杆弯杆后罩	Connerctiong Rod Cover(Rear)	1



针杆部件

NEEDLE BAR MECHANISM

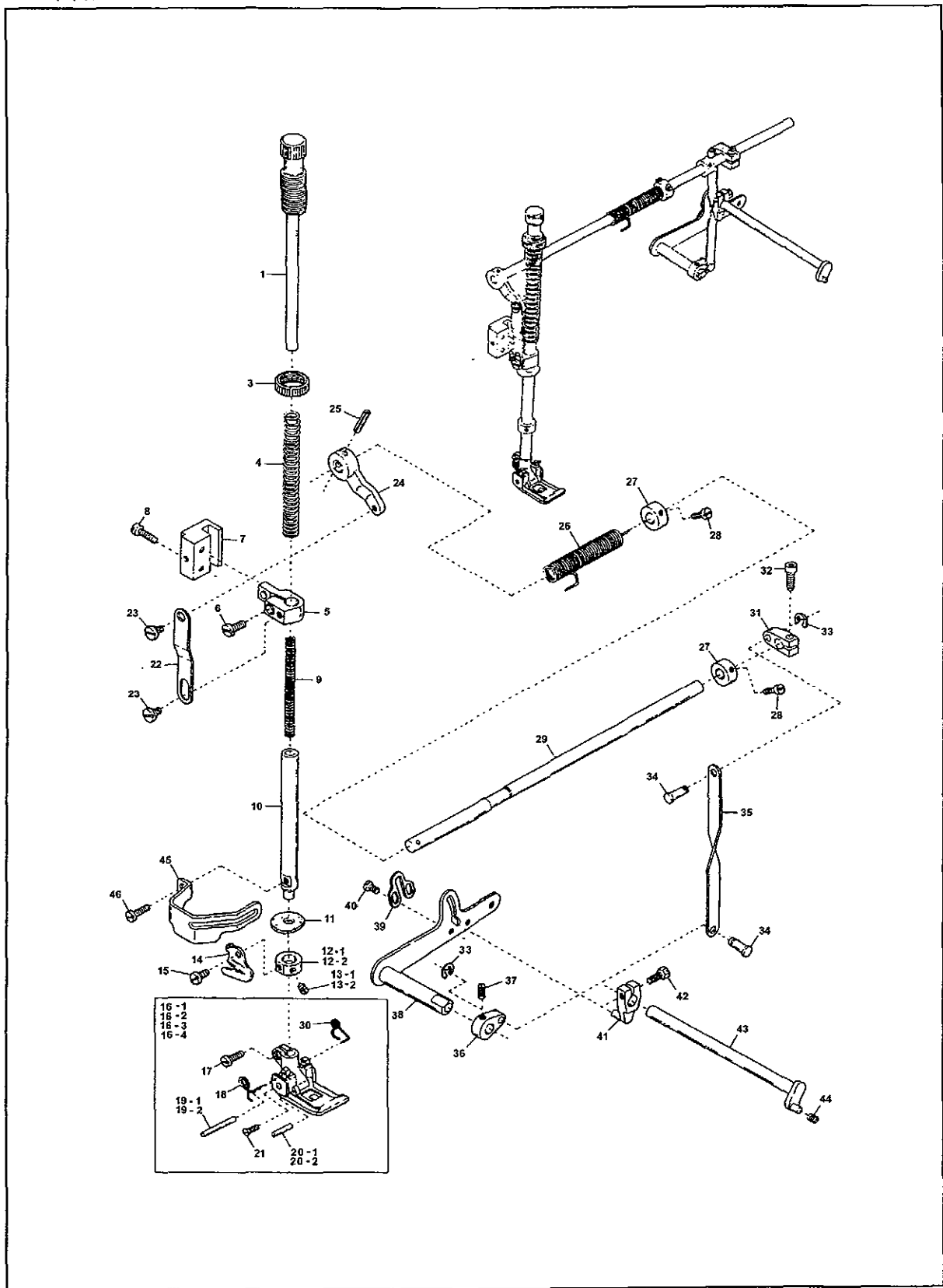
序号 No.	件号 Parts No.	名称	Description	数量 Number
39	110002	针杆连杆后罩螺钉	Screw(M3x5)	2
40	3200088	针杆连杆前罩	Connecting Rod Cover(Front)	1
41	110012	针杆连杆前罩螺钉	Screw(M4x5)	1
42	260000	针杆曲柄螺钉	Screw(SM5/16"x24x15.88)	2



抬压脚部件

PRESSER FOOT MECHANISM

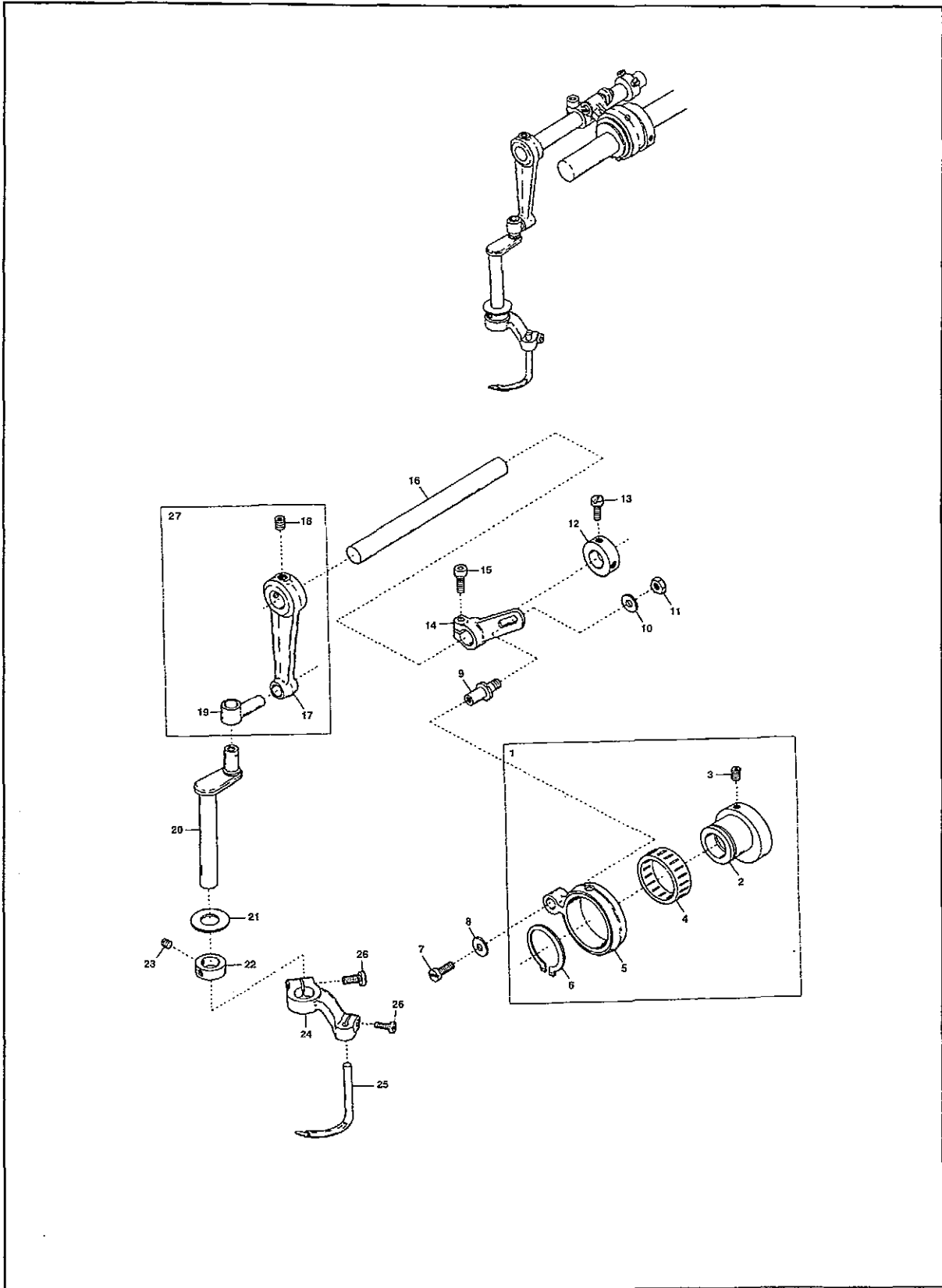
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	0093500	调压螺钉	Presser Spring Regulator	1
2				
3	000445	调压螺母	Lock Nut	1
4	3200132	调压簧	Presser Bar Spring(Outer)	1
5	3200131	压杆导架	Presser Bar Connecting Bracket Unit	1
6	110031	压杆导架螺钉	Screw(M4x12)	1
7	0093483	压杆导轨	Presser Bar Guide	1
8	004441	压杆导轨螺钉	Screw(SM11/64" x40x16)	2
9	0093485	加压簧	Presser Bar Spring(Inner)	1
10	3100110	压杆	Presser Bar	1
11	0093611	压杆油封罩	Oil Protector Ring	1
12-1	3100310	压杆挡圈	Collar(ø8xø17x7mm)	1
12-2	0063079	"	" (ø9xø15x7mm)	1
13-1	150001	压杆挡圈螺钉	Screw(M4x4)	2
13-2	001459	"	" (SM9/64" x40x3)	2
14	0020271	割线刀	Thread Chain Cutting Knife	1
15	110054	割线刀螺钉	Screw(M3x3.5)	1
16-1	0063318	压脚组件	Presser Foot, Complet Set(32)	1
16-2	0063319	"	" " " " (40)	1
16-3	0063320	"	" " " " (48)	1
16-4	0063322	"	" " " " (64)	1
17	001186	压脚柄夹紧螺钉	Screw(SM9/64" x40x7.8)	1
18	3107303	弹性板左扭簧	Presser Foot Spring(Left)	1
19-1	0063283	压脚柄限位销	Locking Pin(32,40,48)	1
19-2	0063284	"	" " (64)	1
20-1	0063281	压脚柄销	Presser Foot Hinge Pin(32,40,48)	1
20-2	0063282	"	" " " " (64)	1
21	005122	压板螺钉	Screw(SM3/32" x56x5.6)	2
22	0093487	抬压脚升降板	Lifter Link	1
23	006038	升降板轴位螺钉	Screw(SM3/16" x2x2.2)	2
24	0063083	抬压脚前杠杆	Lifter Link Lever	1
25	000690	前杠杆弹簧销	Fastener Pin	1
26	0063084	抬压脚轴复位簧	Lifter Spring	1
27	0093491	复位簧挡圈	Collar(ø8xø16x8mm)	2
28	009604	复位簧挡圈螺钉	Screw(SM11/64" x40x5.5)	2
29	0093479	抬压脚轴	Lifter Shaft	1
30	3107304	弹性板右扭簧	Presser Foot Spring(Right)	1
31	3100294	抬压脚上曲柄	Intermediate Lever	1
32	120017	上曲柄螺钉	Screw(M5x15)	1
33	0077179	上曲柄销挡圈	Retaining Ring	2
34	0093509	上曲柄销	Connecting Pin	2
35	0093507	抬压脚连接板	Connecting Plate	1
36	0093508	抬压脚下曲柄	Lifter Lever(Small)	1
37	009200	抬压脚下曲柄螺钉	Screw(SM15/64" x28x9.5)	1



抬压脚部件

PRESSER FOOT MECHANISM

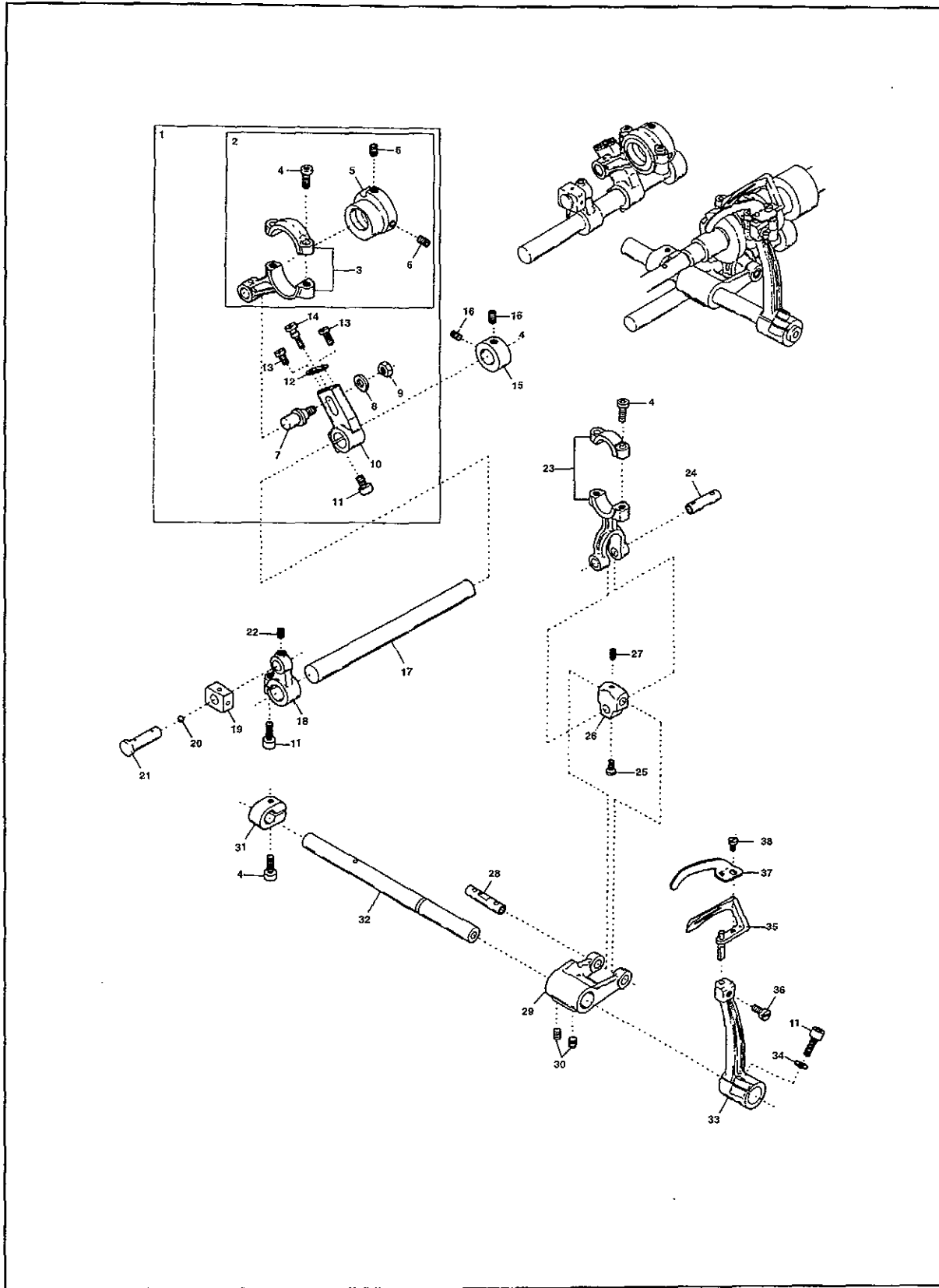
序号 No.	件号 Parts No.	名称	Description	数量 Number
38	0093496	抬压脚凸轮板	Lifter Lever	1
39	0093499	抬压脚限位板	Lifter Lever Stop	1
40	004358	限位板螺钉	Screw(SM9/64"x40x5.6)	2
41	0090801	抬压脚松线曲柄	Tension Release Lever	1
42	005542	松线曲柄螺钉	Screw(SM11/64"x40x14.5)	1
43	0093545	松线曲柄轴	Tension Release Shaft	1
44	0090824	松线曲柄定位簧	Swing-proof Spring	1
45	3100112	机针前护罩	Finger Guard	1
46	110002	机针前护罩螺钉	Screw(M3x5)	1



绷针部件

SPERADER MECHANISM

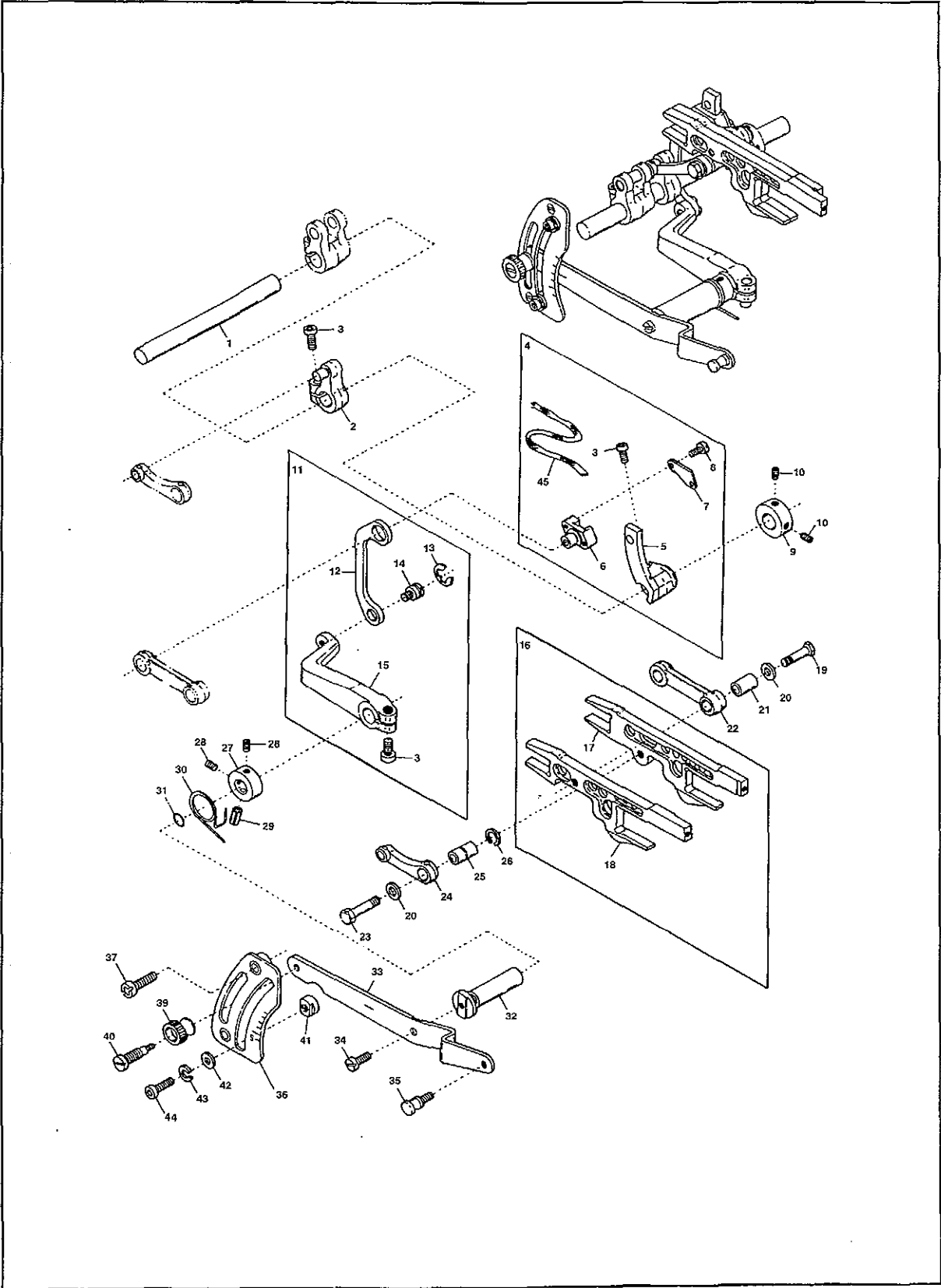
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3100302	绷针偏心轮组件	Connecting Rod, Complete Set	1
2	3100300	绷针偏心轮	Eccentric	1
3	160003	绷针偏心轮螺钉	Screw(M5x5)	2
4	0077322	偏心轮滚针轮承	Roller Bearing	1
5	3100301	偏心轮连杆	Connecting Rod	1
6	0094566	轴承弹簧挡圈	Retaining Ring	1
7	110009	垫圈螺钉	Screw(M4x8)	1
8	300006	调整曲柄销垫圈	Washer	1
9	3100309	调整曲柄销	Adjusting Lever Pin	1
10	000528	绷针调整曲柄垫圈	Washer	1
11	100003	曲柄垫圈螺母	Nut(M6)	1
12	0032646	绷针轴挡圈	Collar(ø12xø20x8mm)	1
13	009604	挡圈螺钉	Screw(SM11/64"x40x5.5)	2
14	3100303	绷针调整曲柄	Adjusting Lever	1
15	120013	曲柄夹紧螺钉	Screw(M6x15)	1
16	3100304	绷针轴	Driving Shaft	1
17	3100305	绷针轴连杆	Rocking Arm	1
18	160007	连杆螺钉	Screw(M6x6)	2
19	0063051	绷针连接柱	Rocking Pin	1
20	0063053	绷针曲柄轴	Spreader Bar	1
21	0063056	绷针曲柄轴垫圈	Bushing Ring	1
22	0063057	绷针曲柄轴挡圈	Collar(ø10xø18x7mm)	1
23	009526	挡圈螺钉	Screw(SM9/64"x40x4.4)	2
24	3100307	绷针摆动曲柄	Spreader Holder	1
25	3209300	绷针	Spreader	1
26	110031	曲柄夹紧螺钉	Screw(M4x12)	2
27	3100306	绷针轴连杆组件	Rocking Arm, Complete Set	1



## 弯针部件

## LOOPER DRIVING MECHANISM

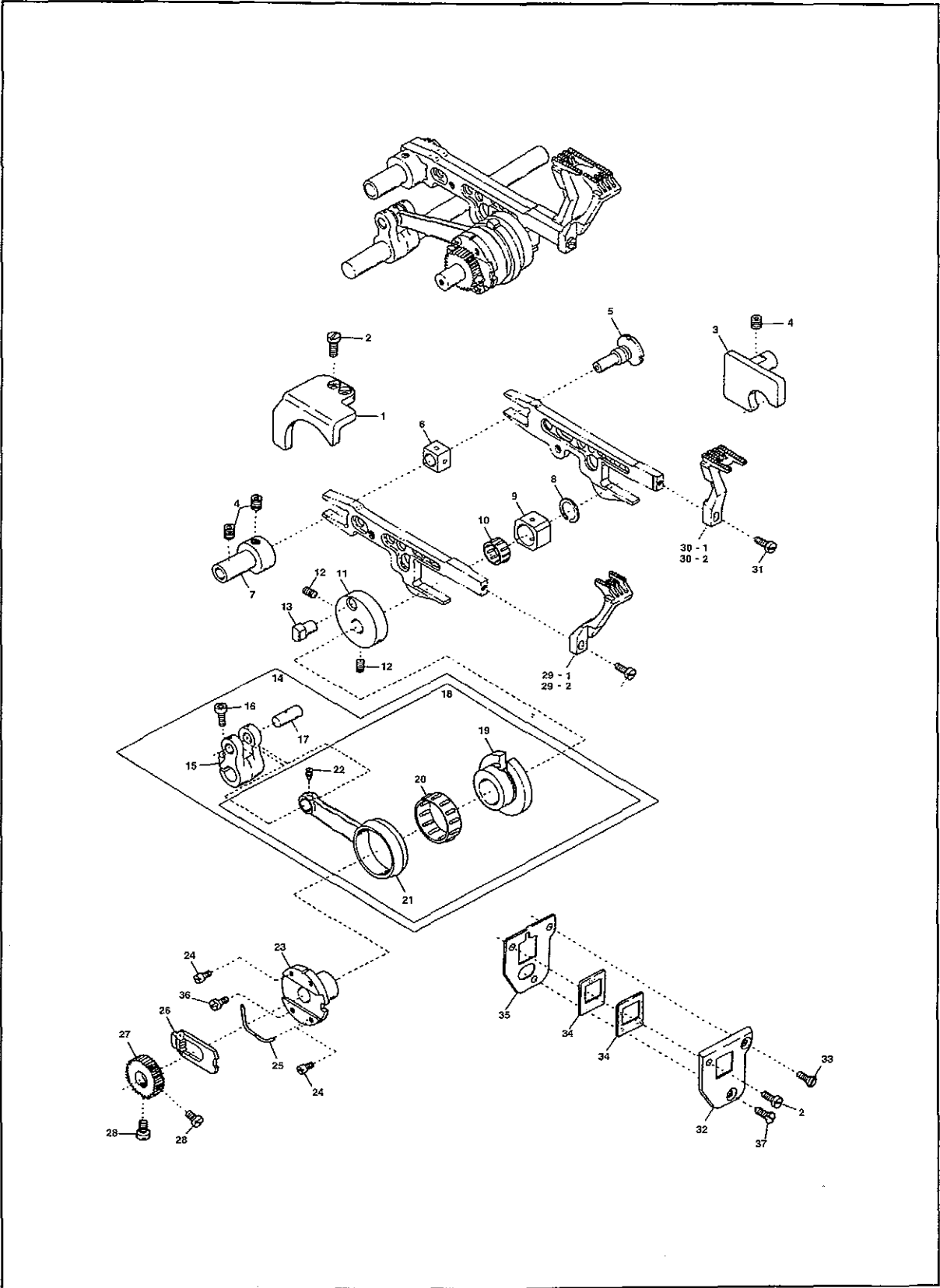
序号 No.	件 号 Parts No.	名 称	Description	数量 Number
1	3200150	弯针连杆前后摆动连杆组件 1	Looper Rocker Connecting Rod, C. Set(2)	1
2	3200149	弯针连杆前后摆动连杆组件 2	Looper Rocker Connecting Rod, C. Set(1)	1
3	3200152	弯针前后摆动连杆	Looper Rocker Connecting Rod	1
4	120001	摆动连杆上盖螺钉	Screw(M4x14)	5
5	3200151	弯针前后摆动偏心轮	Looper Rocker Eccentric	1
6	160003	偏心轮螺钉	Screw(M5x5)	2
7	3200159	摆动调整曲柄销	Connecting Rod Pin	1
8	300000	曲柄销垫圈	Washer	1
9	100002	曲柄销螺母	Nut	1
10	3200154	弯针前后摆动调整曲柄	Looper Rocker Lever	1
11	005650	调整曲柄夹紧螺钉	Screw(M5x14)	3
12	3200155	摆动曲柄调节板	Looper Rocker Adjusting Guide Plate	1
13	110007	调节板螺钉	Screw(M2.5x6)	2
14	170021	调整曲柄销调节螺钉	Adjusting Screw(M2.5x10.5)	1
15	2100267	弯针摆动轴挡圈	Collar( $\phi 10 \times \phi 17 \times 8 \text{mm}$ )	1
16	160001	挡圈螺钉	Screw(M4x4)	2
17	0093314	弯针摆动轴	Looper Rocker Shaft	1
18	3200157	弯针前后摆动曲柄	Looper Rocker Arm	1
19	0093319	弯针前后摆动曲柄滑块	Looper Slide Block	1
20	000637	油孔堵塞	Seal Plug	1
21	0033074	弯针前后摆动曲柄销	Looper Slide Block Pin	1
22	160009	曲柄销螺钉	Screw(M5x5)	1
23	3200161	弯针球连杆	Looper Connecting Rod	1
24	0032784	弯针左右摆动曲柄销	Looper Pin(Short)	1
25	009604	导向块销螺钉	Screw(SM11/64" x40x5.5)	1
26	0032785	弯针球连杆导向块	Looper Driving Lever Link	1
27	001457	左右摆动曲柄销螺钉	Screw(SM11/64" x40x3.3)	1
28	0032786	弯针球连杆导向块销	Link Pin(Long)	1
29	3200162	弯针左右摆动曲柄	Looper Driving Lever	1
30	160007	左右摆动曲柄螺钉	Screw(M6x6)	2
31	3200163	摆动曲柄滑块挡块	Collar	1
32	0093300	弯针轴	Looper Driving Shaft	1
33	3200164	弯针曲柄	Looper Holder	1
34	000669	夹紧螺钉垫圈	Washer	1
35	3209311	弯针	Looper	1
36	110057	弯针支头螺钉	Screw(M4x7)	1
37	0095723	弯针前保针板	Needle Guard (Front)	1
38	004236	弯针前保针板螺钉	Screw(SM3/32" x56x4.2)	1



差动送料部件

FEED DRIVING COTROOL MECHANISM

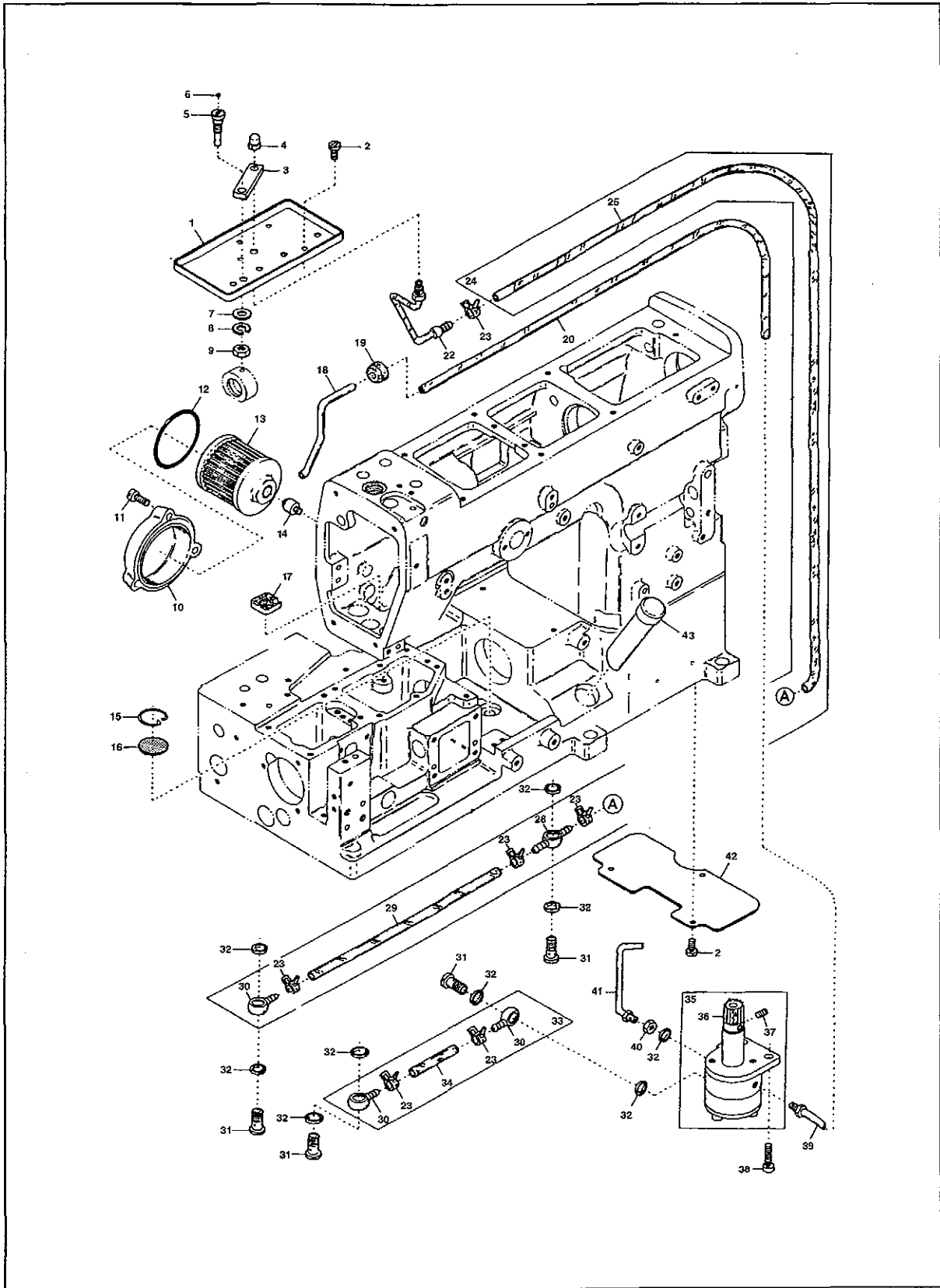
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3200181	送料轴	Feed Bar Driving Shaft	1
2	3200183	送料牙架调节曲柄	Main Feed Bar Lever	1
3	120006	调整曲柄螺钉	Screw(M6x12)	3
4	3200184	差动调整曲柄组件	Differential Rocker Complete Set)	1
5	3200185	差动牙架连杆调整曲柄	Differential Rocker	1
6	3200186	差动牙架连杆调整滑块	Differential Regulating Slider	1
7	3200187	调整滑块盖板	Differential Regulating Slider Cap	1
8	110033	调整滑块盖板螺钉	Screw(M3x6)	2
9	2100161	调整曲柄挡圈	Collar(ø10xø19x9mm)	1
10	160003	调整曲柄挡圈螺钉	Screw(M5x5)	2
11	3200205	差动曲柄组件	Differential Lever(Inner), C. Set	1
12	2100252	差动牙架调整连杆	Slider Link	1
13	0068202	轴位螺钉开口挡圈	Retaining Ring	1
14	2100253	调整连杆轴位螺钉	Slider Ling Pin	1
15	3200206	差动曲柄	Differential Lever(Inner)	1
16	3200189	牙架组件	Feed Bar, Complets Set	1
17	3200190	送料牙架	Main Feed Bar	1
18	3200191	差动牙架	Differential Feed Bar	1
19	140018	差动牙架连杆轴位螺钉	Screw(M5x6)	1
20	300000	轴位螺钉垫圈	Washer	2
21	3200194	差动牙架连杆衬套	Connection Bushing	1
22	3200193	差动牙架连杆	Differential Feed Bar Connection	1
23	140017	送料牙架连杆套螺钉	Screw(M5x6)	1
24	2100248	送料牙架连杆	Main Feed Bar Connection	1
25	3200192	送料牙架连杆套	Connection Bushing	1
26	3200215	连杆套夹紧挡圈	Retaining Ring	1
27	2100267	差动曲柄销挡圈	Collar(ø10xø17x8mm)	1
28	160001	挡圈螺钉	Screw(M4x4)	1
29	000690	挡圈弹性圆柱销	Roll Pin	2
30	3200216	差动曲柄复位簧	Differential Lever Spring	1
31	0020538	差动曲柄销O型圈	O-ring(P7)	1
32	3200207	差动曲柄销	Differential Lever Shaft	1
33	0095132	差动扳手	Differential Lever(Left)	1
34	110009	差动扳手螺钉	Screw(M4x8)	1
35	004143	差动扳手拉勾螺钉	Screw(SM11/64" x40x3.2)	1
36	3200213	差动刻度板	Differential Feed Graduation	1
37	110045	差动刻度扳螺钉	Screw(M4x12)	2
38				
39	000210	差动度板螺母	Adjusting Nut	1
40	005511	差动刻度板螺母螺钉	Adjusting Screw(SM1/4" x40x11, SM11/64" x40x4)	1
41	0020350	限位螺钉螺母	Differential Lever Stop	2
42	000669	限位螺钉垫圈	Washer	2
43	000600	弹性垫圈	Spring Washer	2
44	005049	差动刻度板限位螺钉	Screw(M5x8)	2
45	310071	油线	Oil Wick	1



## 送料抬牙部件

## FEED DRIVING MECHANISM

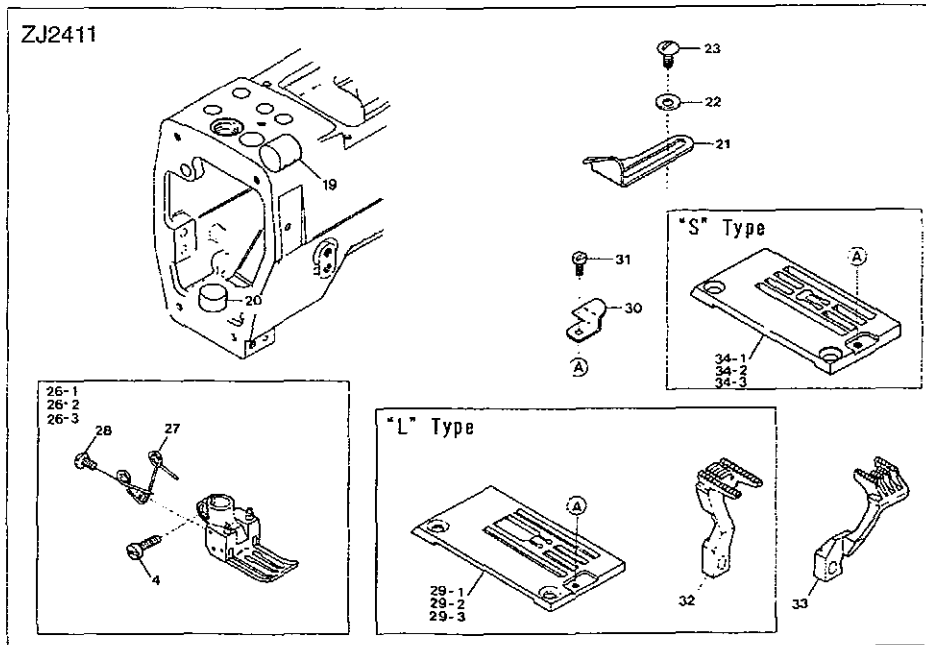
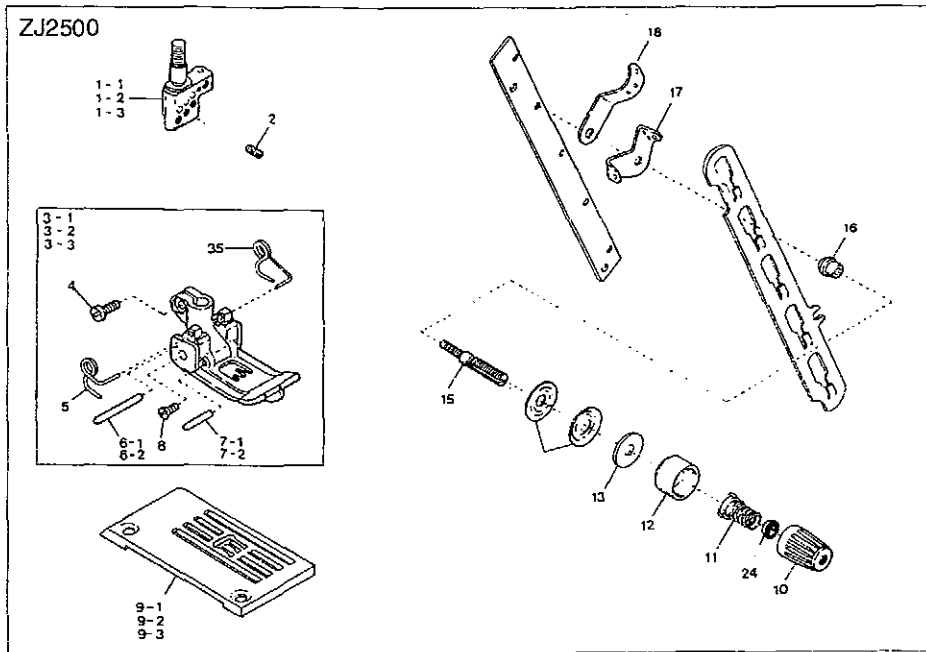
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3200199	送料牙架外挡板	Feed Bar Guide(Left)	1
2	110080	外挡板螺钉	Screw(M4x8)	3
3	3200200	送料牙架内挡板	Feed Bar Guide(Right)	1
4	160007	内挡板螺钉	Screw(M6x6)	3
5	0033141	送料牙架偏心销	Feed Adjusting Pin	1
6	0093389	偏心销滑块	Feed Bar Block(Rear)	1
7	3200201	调整牙架轴	Feed Bar Guide(Rear)	1
8	0060076	抬牙滑块弹性挡圈	Retaining Ring	1
6	0060075	抬牙滑块	Feed Bar Block(Front)	1
10	2110527	抬牙滑块滚针轴承	Roller Bearing	1
11	3200198	开针定位销偏心轮	Eccentric Pin Holder	1
12	160003	偏心轮螺钉	Screw(M5x5)	2
13	0020401	开针土凸轮定位销	Feed Dog Eccentric Pin	1
14	3200214	送料连杆部件	Driving Connecting Rod Mechanism, C. Set	1
15	3200182	送料曲柄	Feed Bar Driving Shaft Lever	1
16	120006	送料曲柄螺钉	Screw(M6x12)	1
17	2100173	送料曲柄销	Connecting Rod Pin	1
18	3200195	送料连杆组件	Driving Connecting Rod, C. Set	1
19	2100277	开针凸轮	Feed Dog Eccentric	1
20	2100278	送料连杆滚针轴承	Roller Bearing	1
21	3200196	送料连杆	Feed Dog Driving Connecting Rod	1
22	160016	送料曲柄螺钉	Screw(M4x4.5)	1
23	2100276	送料凸轮座	Feed Dog Regulating Eccentric	1
24	180002	凸轮座无头轴位螺钉	Screw(M3x4)	2
25	2100289	开针凸轮簧	Feed Dog Regulating Plate Spring	1
26	0023473	开针凸轮锁紧滑块	Feed Dog Regulating Plate	1
27	3200197	开针凸轮锁紧滑块座	Feed Dog Regulating Gear	1
28	180003	锁紧滑块座螺钉	Screw(M5x8)	2
29-1	3209001	差动牙	Differential Feed Dog(32,40,48,56)	1
29-2	3209003	"	" " " (64)	1
30-1	3209000	送料牙	Main Feed Dog(32,40,48,56)	1
30-1	3209002	"	" " " (64)	1
31	110004	送料牙螺钉	Screw(M3.5x8)	2
32	3200203	牙架外防油板	Feed Bar Shield Holder(Front)	1
33	130003	牙架防油板沉头螺钉	Screw(M4x7.3)	1
34	3200211	牙架防油板隔板	Feed Bar Shield	2
35	3200204	牙架内防油板	Feed Bar Shield Holder(Rear)	1
36	110070	凸轮座螺钉	Screw(M3x6.3)	1
37	130024	牙架防油板螺钉	Screw(M4x7.3)	1



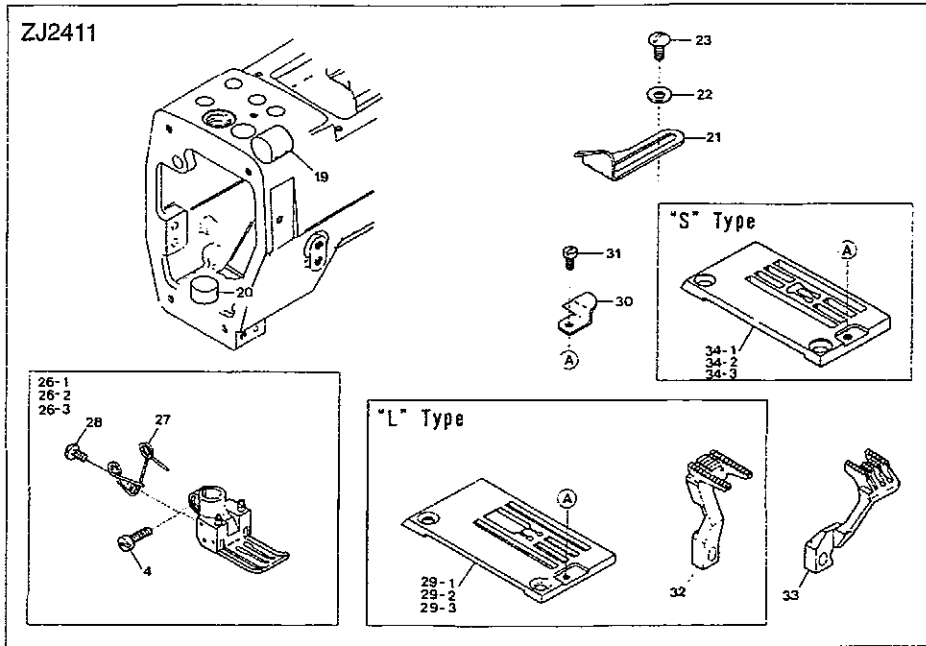
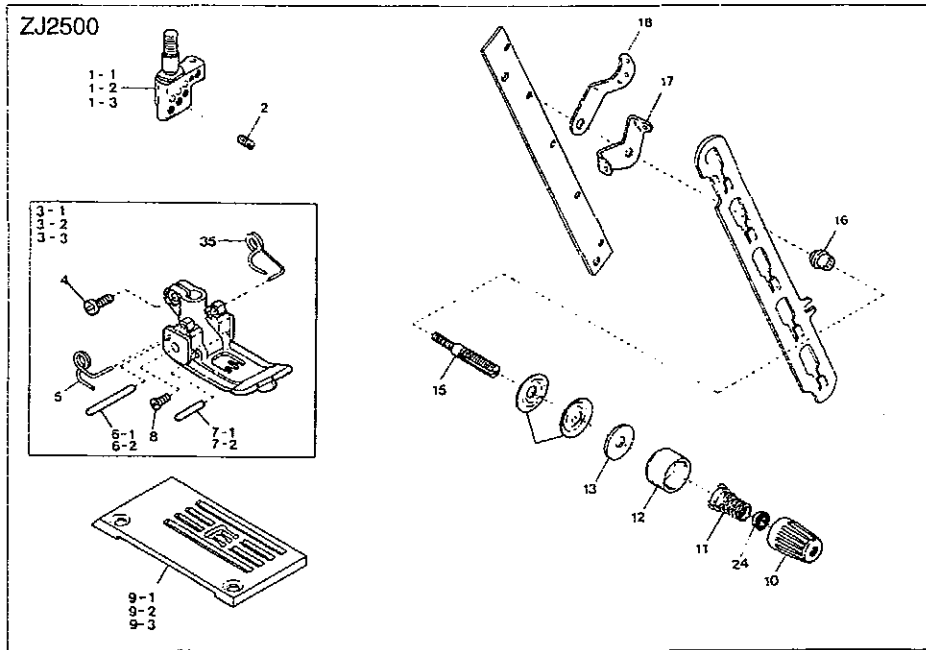
润滑部件

LUBRICATING MECHANISM

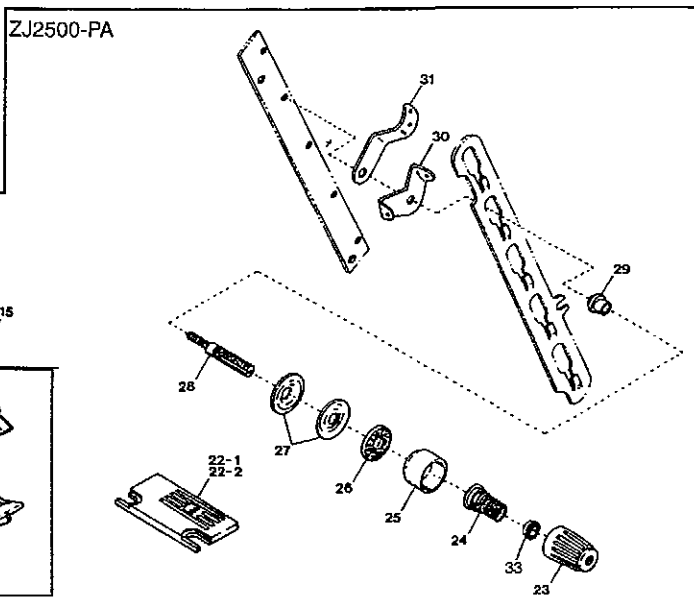
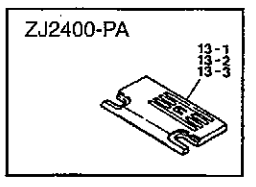
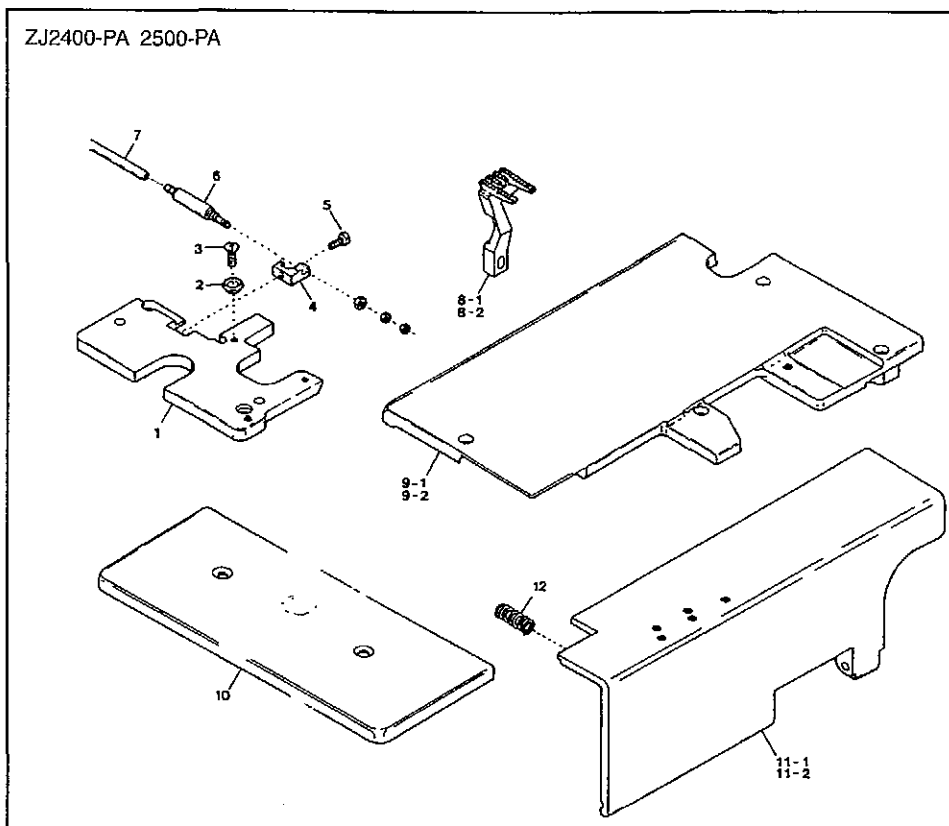
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	0065453	上轴喷油分布盘	Oil Receiver	1
2	110012	分布盘螺钉	Screw(M4x5)	5
3	3200229	上轴两孔通油板	Lubricant Guiding Block	1
4	320006	上轴喷油嘴	Top Nozzle Cap	1
5	3200230	上轴进油套调节螺钉	Oil Adjusting Screw	1
6	000636	调节螺钉油塞	Seal Plug	1
7	300000	调节螺钉垫圈	Washer	1
8	000600	调节螺钉弹簧垫圈	Spring Washer	1
9	100002	调节螺钉螺母	Nut	1
10	3100060	过滤器孔端盖	Oil Filter Cap	1
11	110045	过滤器孔盖螺钉	Screw(M4x12)	3
12	3100061	过滤器孔O型圈	O-ring(P42)	1
13	3100345	过滤器	Oil Filter	1
14	3100329	过滤器出油螺钉	Oil Filter Connector	1
15	0063217	过滤网卡簧	Oil Filter Screen Clamp	1
16	0063216	底板过滤网	Oil Filter Screen	1
17	3200237	回油毡	Felt	1
18	3200236	回油管	Suction Pipe	1
19	0093617	回油管塞	Suction Pipe Bushing	1
20	3200238	回油长管	Oil Tube(ø3xø5x500mm)	1
21				
22	3200227	上轴喷油管组件	Oil Pipe Unit	1
23	0031831	进油短油管夹	Oil Tube Clamp	6
24	3200234	上腔进油组件	Oil Tube(Long), Complete Set	1
25	3100335	上轴进油长油管	Oil Tube(ø4xø6x290mm)	1
26				
27				
28	0037668	油泵进油分流接管接头	Oil Tube Joint, Two Way	1
29	3200233	主轴前套进油管	Oil Tube(ø4xø6x175mm)	1
30	0037669	油泵进油管接头	Oil Tube Joint, One Way	3
31	004124	油管接头通油螺钉	Fitting Stud(Short)	4
32	000567	通油螺钉垫圈	Seal	9
33	3200235	进油短油管组件	Oil Tube(Short), Complete Set	1
34	3200232	进油短油管	Oil Tube(ø4xø6x45mm)	1
35	3100328	油泵部件	Oil Pump, Complete Set	1
36	0030711	油泵蜗轮	Oil Pump Driving Worm Gear	2
37	160001	油泵蜗轮螺钉	Screw(M4x4)	2
38	120006	油泵安装板螺钉	Screw(M6x12)	1
39	0090918	回油管接头	Suction Pipe	1
40	000419	回油管弯管螺套螺母	Nut	
41	3100349	回油管弯管螺套	Oil Nozzle for Worm Gear	1
42	3200231	底板防尘板	Dustproof Plate	1
43	0020533	底板油标	Oil Sight Gauge	1



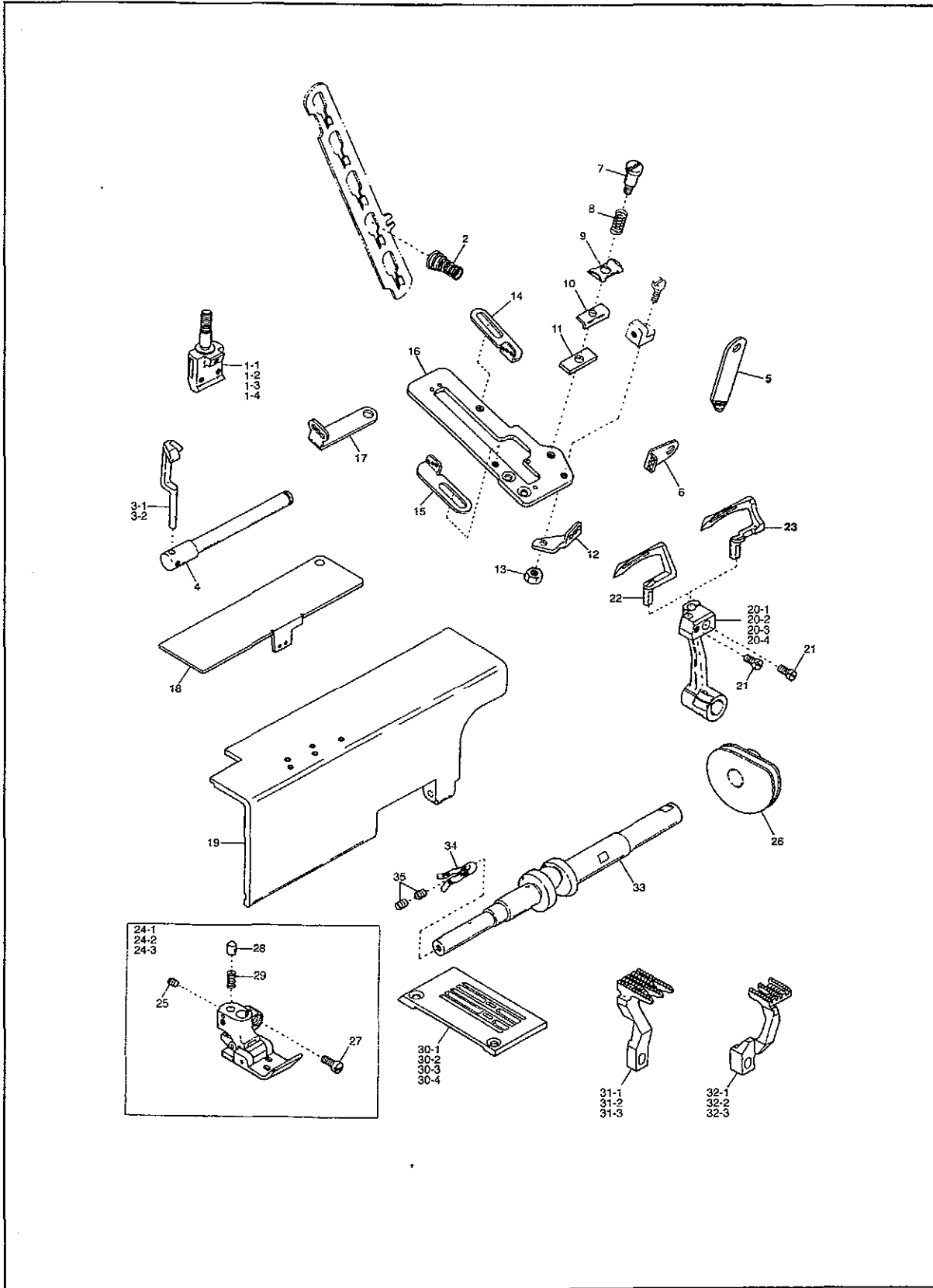
序号 No.	件 号 Parts No.	名 称	Description	数量 Number
1-1	3209106	针夹	Needle Clamp(48)	1
1-2	3209107	"	" " (56)	1
1-3	3209108	"	" " (64)	1
2	001892	机针螺钉	Screw(SM1/8"x44x2.9)	3
3-1	3107050	压脚组件	Presser Foot, Complete Set(48)	1
3-2	0064041	"	" " " " (56)	1
3-3	0064042	"	" " " " (64)	1
4	001186	压脚柄夹紧螺钉	Screw(SM9/64"x40x7.8)	1
5	3107303	弹性板左扭簧	Presser Foot Spring(Left)	1
6-1	0063283	压脚柄限位销	Locking Pin(48)	1
6-2	0063284	"	" " (56,64)	1
7-1	0063281	压脚柄销	Presser Foot Hinge Pin(48)	1
7-2	0063282	"	" " " " (56,64)	1
8	005122	压板螺钉	Screw(SM3/32"x56x5.5)	2
9-1	0094800	针板	Stitch Plate(48M)	1
9-2	0094801	"	" " (56M)	1
9-3	0094802	"	" " (64M)	1
10	0093863	夹线螺母	Thread Tension Spring Cap	1
11	0090814	面线夹线簧	Needle Thread Tension Spring	1
12	0090071	夹线簧座	Thread Tension Spring Retainer	1
13	000177	夹线垫板	Felt	1
14	0031111	夹线盘	Tension Disc	2
15	009835	夹线螺钉	Tension Post	1
16	0090812	松线板套管	Tension Post Ferrule	1
17	0090856	双线过线板	Tension Disc Eyelet	1
18	0090807	单线过线板	Thread Lead-in Guide	1
19	0094604	绷针轴孔油塞	Seal Plug	1
20	0063548	绷针曲柄轴孔油塞	Seal Plug	1
21	0094616	挡线板	Edge Guide(on thr Front Cover)	1
22	000426	挡线板螺钉垫片	Washer	2
23	110105	挡线板螺钉	Screw(M5x12)	2
24	0093865	夹线定位螺母	Thread Tension Spring Cover	1
25				
26-1	0094871	压脚组件	Presser Foot, Complete Set(32)	1
26-2	0094872	"	" " " " (40)	1
26-3	0094873	"	" " " " (48)	1
27	0094890	压脚扭簧	Presser Foot Spring	1
28	005133	压脚扭簧螺钉	Screw(SM1/8"x44x4.5)	1
29-1	0094961	针板	Stitch Plate(32L)	1
29-2	0094962	"	" " (40L)	1
29-3	0094963	"	" " (48L)	1
30	0094615	送布导向板	Fabric Guide	1
31	001228	送布导向板螺钉	Screw(SM3/32"x56x3.2)	1
32	3209010	送料牙	Main Feed Dog	1



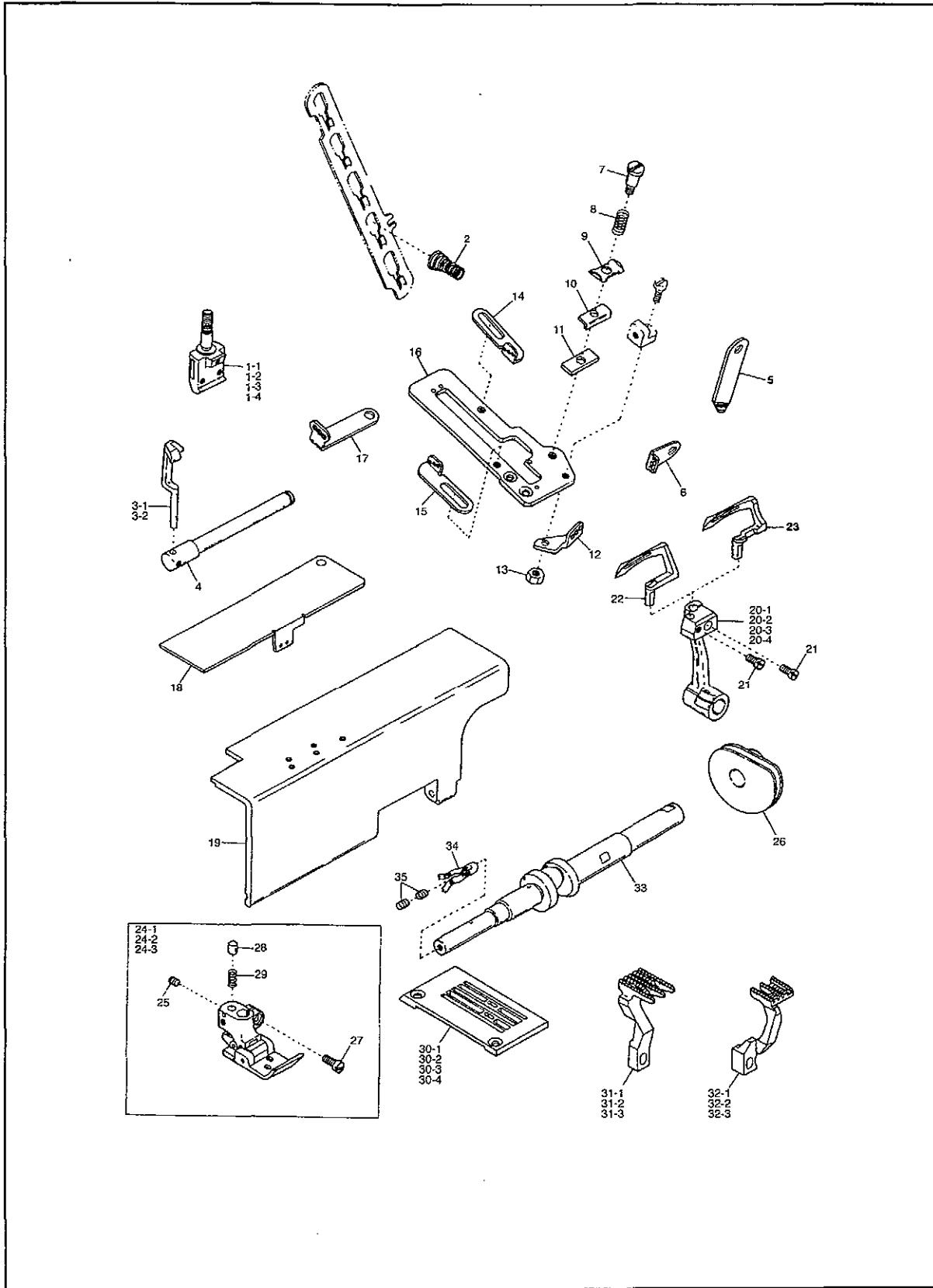
序号 No.	件号 Parts No.	名称	Description	数量 Number
33	3209011	差动牙	Differential Feed Dog	1
34-1	3208011	针板	Stitch Plate(32S)	1
34-2	3208012	"	" " (40S)	1
34-3	3208013	"	" " (48S)	1
35	3107304	弹性板右扭簧	Presser Foot Spring(Right)	1



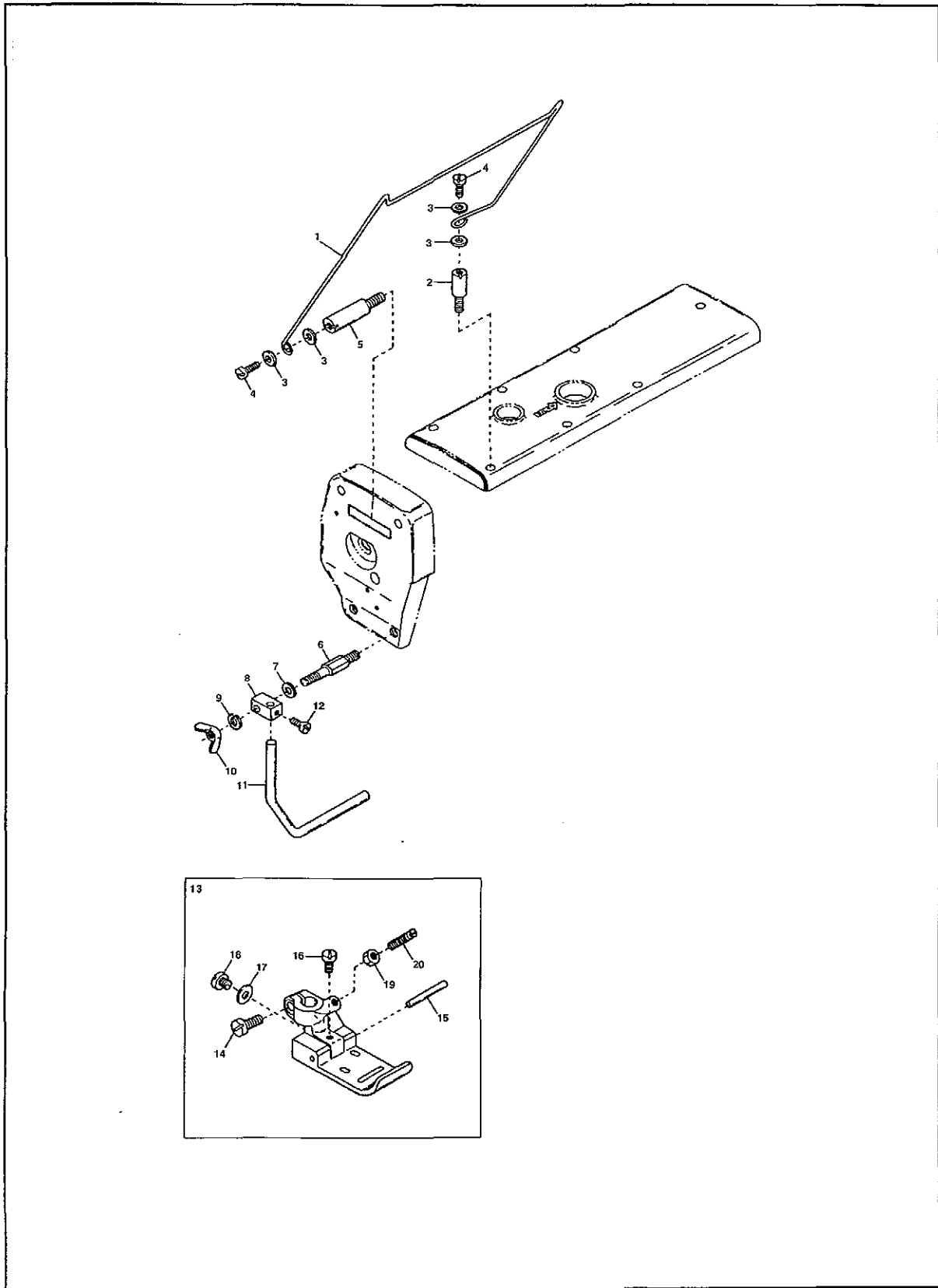
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3201014	针板架	Stitch Plate Support	1
2	3201016	角缝转角套	Corner Sewing Sleeve	2
3	009142	转角套螺钉	Screw(SM9/64" x40x7.1)	2
4	3201015	滚套固定块	Cylinder Support	1
5	110036	滚套安装螺钉	Screw(M3x6.5)	1
6	1091051	滚套	Air Cylinder(MS4 NFS)	1
7	0010260	塑料管	Vinyl Tube(ø4x2.5mm)	1
8-1	3209018	送料牙	Main Feed Dog(32,40,48,56)	1
8-2	3209020	"	" " " (64)	1
9-1	3201011	缝台	Cloth Plate(Large)(32,40,48,56)	1
9-2	3201017	"	" " " (64)	1
10	3201012	底板左上盖板	Cloth Plate(Small)	1
11-1	3201013	底板前罩板	Front Cover(32,40,48,56)	1
11-2	3201018	"	" " (64)	1
12	4017013	复位弹簧	Return Spring	1
13-1	3208005	针板	Stitch Plate(32S)	1
13-2	3208006	"	" " (40S)	1
13-3	3208007	"	" " (48S)	1
14-1	3209107	针夹	Needle Clamp(56)	1
14-2	3209108	"	" " (64)	3
15	001892	机针螺钉	Screw(SM1/8"x44x2.9)	1
16-1	0064041	压脚组件	Presser Foot, Complete Set(56)	1
16-2	0064042	"	" " " " (64)	1
17	001186	压脚柄夹紧螺钉	Screw(SM9/64" x40x7.8)	1
18	3107303	弹性板左扭簧	Presser Foot Spring(Left)	1
19	0063284	压脚柄限位销	Locking Pin(56, 64)	1
20	0063282	压脚柄销	Presser Foot Hinge Pin (56, 64)	1
21	005122	压板螺钉	Screw(SM3/32"x56x5.5)	2
22-1	3208000	针板	Stitch Plate(56S)	1
22-2	3208001	"	" " (64S)	1
23	0093863	夹线螺母	Thread Tension Spring Cap	1
24	0090814	面线夹线簧	Needle Thread Tension Spring	1
25	0090071	夹线簧座	Thread Tension Spring Retainer	1
26	000177	夹线垫板	Felt	1
27	0031111	夹线盘	Tension Disc	2
28	009835	夹线螺钉	Tension Post	1
29	0090812	松线板套管	Tension Post Ferrule	1
30	0090856	双线过线板	Tension Disc Eyelet	1
31	0090807	单线过线板	Thread Lead-in Guide	1
32	3107304	弹性板右扭簧	Presser Foot Spring(Right)	1
33	0093865	夹线定位螺母	Thread Tension Spring Cover	1



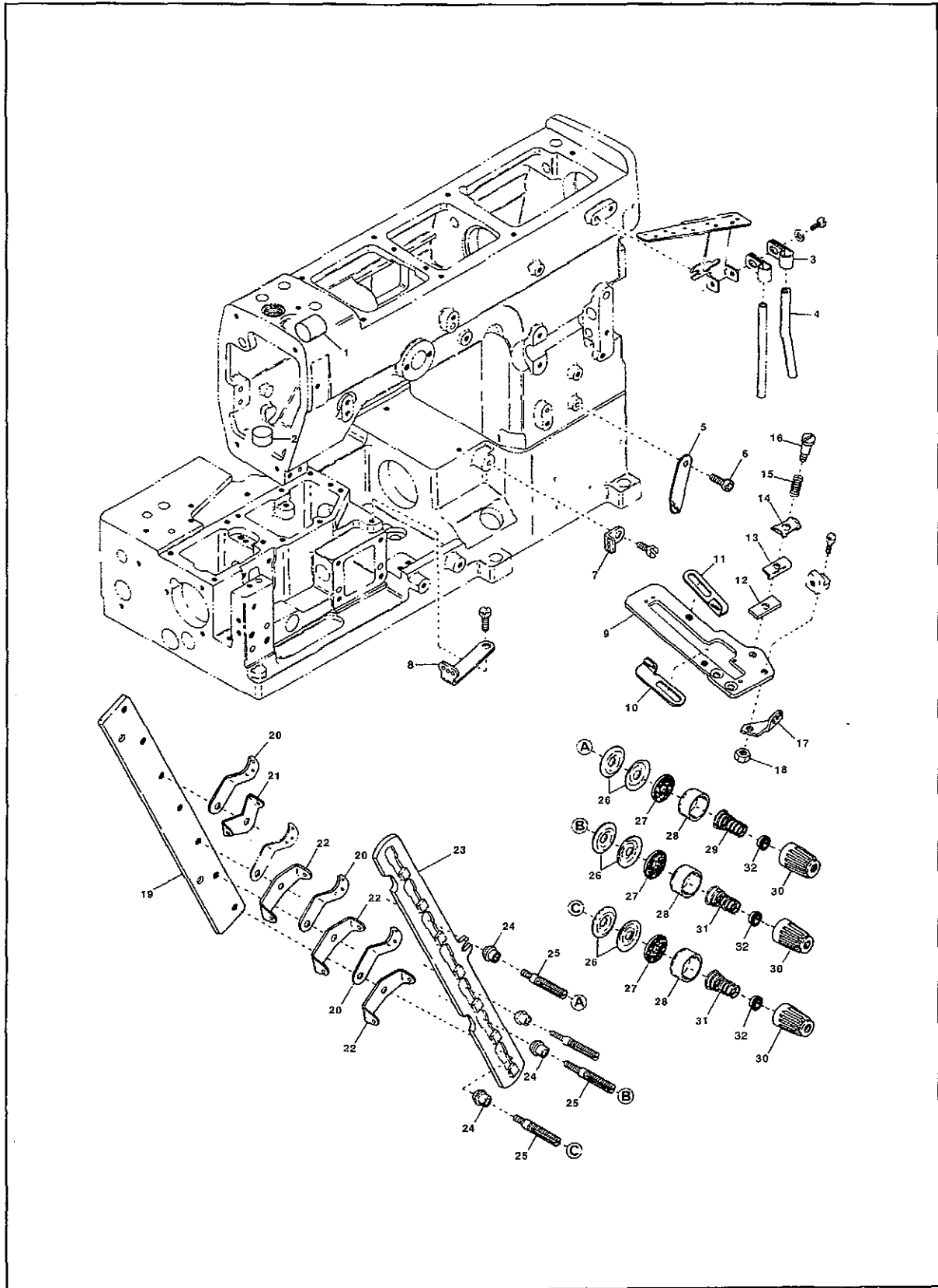
序号 No.	件号 Parts No.	名称	Description	数量 Number
1-1	3209109	针夹	Needle Clamp(48)	1
1-2	3209110	"	" " (64)	1
1-3	3209111	"	" " (80)	1
1-4	3209120	"	" " (95)	1
2	0090847	绷线夹线簧	Looper Thread Tension Spring	1
3-1	3209200	后保针架	Needle Guard(Rear)(48,64,80)	1
3-2	3209204	"	" " " (95)	1
4	3201155	后保针架摆轴	Needle Guard Driving Shaft	1
5	0095916	弯针后过线板	Looper Thread Eyelet	1
6	3201156	弯针中过线板	Looper Thread Eyelet(Right)	1
7	270012	夹线器压簧螺钉	Screw(SM1/8" x44x5)	1
8	0090846	夹线器压簧	Looper Thread Retainer Spring	1
9	0032425	挑线凸轮夹线器压板	Looper Thread Retainer	1
10	0036175	挑线凸轮夹线器垫板	Looper Thread Retainer Bracket	1
11	0095909	挑线凸轮夹线器底板	Looper Thread Retainer Holder	1
12	3201153	夹线器过线板	Looper Thread Eyelet(Center)	1
13	000322	挡线板座螺母	Nut	1
14	0095922	挑线凸轮架右过线环	Looper Thread Take-up Eyelet(Righth)	1
15	0095921	挑线凸轮架左过线环	Looper Thread Take-up Eyelet(Left)	1
16	3201152	挑线凸轮架	Supporting Plate	1
17	3201157	弯针前过线板	Looper Thread Eyelet(Left)	1
18	3200035	缝台播板	Looper Thread Take-up Cover(64,80,95)	1
19	3200034	缝台	Front Cover(64,80,95)	1
20-1	3201158	弯针曲柄	Looper Holder(48)	1
20-2	3201150	"	" " (64)	1
20-3	3201151	"	" " (80)	1
20-4	3201148	"	" " (95)	1
21	110057	弯针支头螺钉	Screw(M4x7)	2
22	0095930	左弯针	Looper	1
23	0095931	右弯针	Looper(Right)	1
24-1	3207036	压脚组件	Presser Foot, Coplete Set(48)	1
24-2	3207008	"	" " " " (64)	1
24-3	3207010	"	" " " " (80)	1
25	001459	压脚弹簧销螺钉	Screw(SM9/64" x40x3)	1
26	0094512	弯针挑线凸轮	Looper Thread Take-up	1
27	001186	压脚柄夹紧螺钉	Screw(SM9/64" x40x7.8)	1
28	0037166	压脚弹簧销	Presser Foot Pin	1
29	0037164	压脚弹簧	Presser Foot Spring	1
30-1	3208070	针板	Stitch Plate(48)	1
30-2	3208022	"	" " (64)	1
30-3	3208021	"	" " (80)	1
30-4	3208068	"	" " (95)	1
31-1	3209043	送料牙	Main Feed Dog(48)	1
31-2	3209025	"	" " " (64)	1



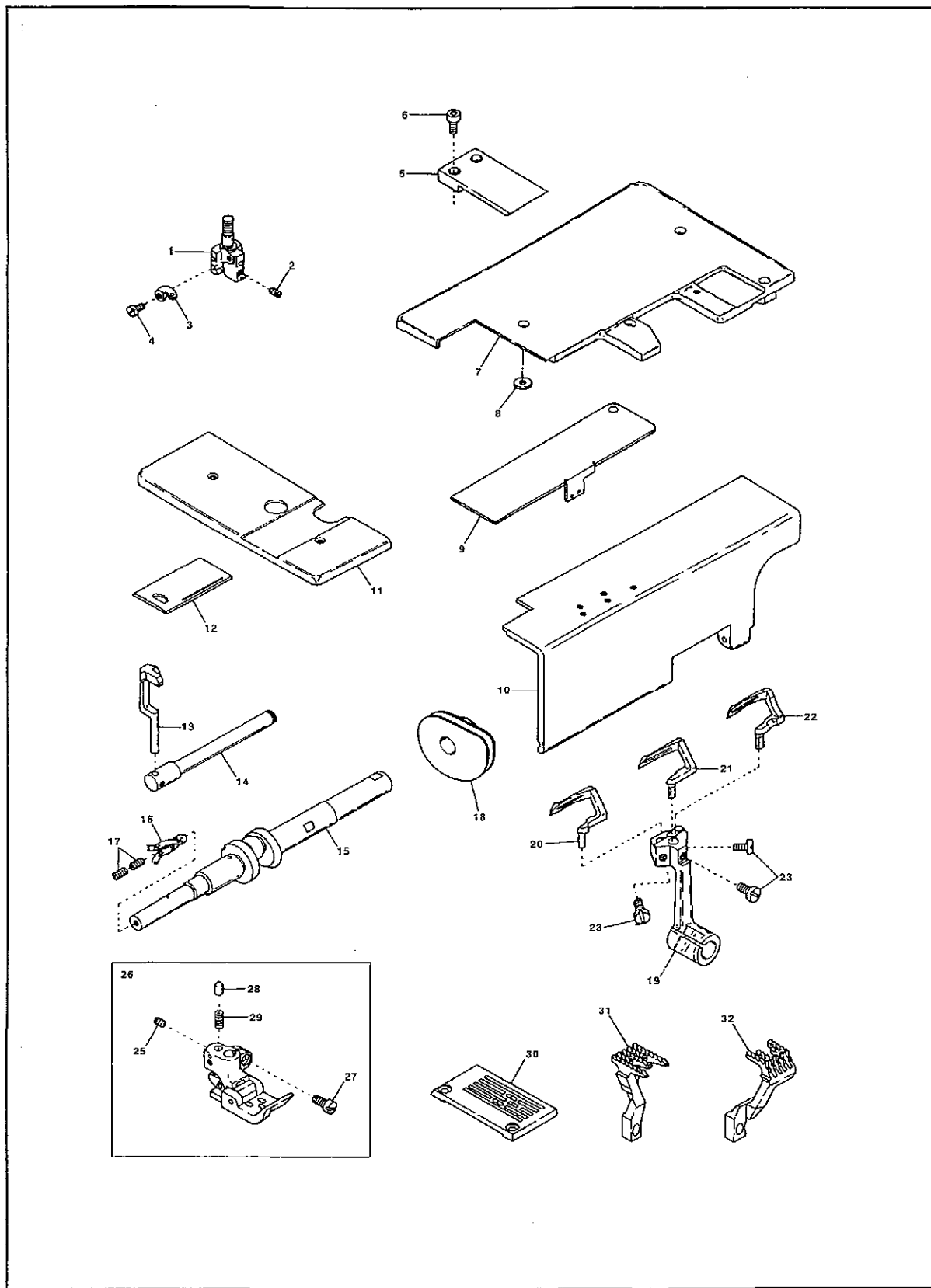
序号 No.	件 号 Parts No.	名 称	Description	数量 Number
31-3	3209027	送料牙	Main Feed Dog (80,95)	1
32-1	3209044	差动牙	Differential Feed Dog(48)	1
32-2	3209026	"	" " " (64)	1
32-3	3209028	"	" " " (80,95)	1
33	3201166	主轴前节轴	Lower Crankshaft	1
34	310055	主轴前节轴	Oil Wich	1
35	160007	主轴前节油线塞螺钉	Screw(M6x6)	2



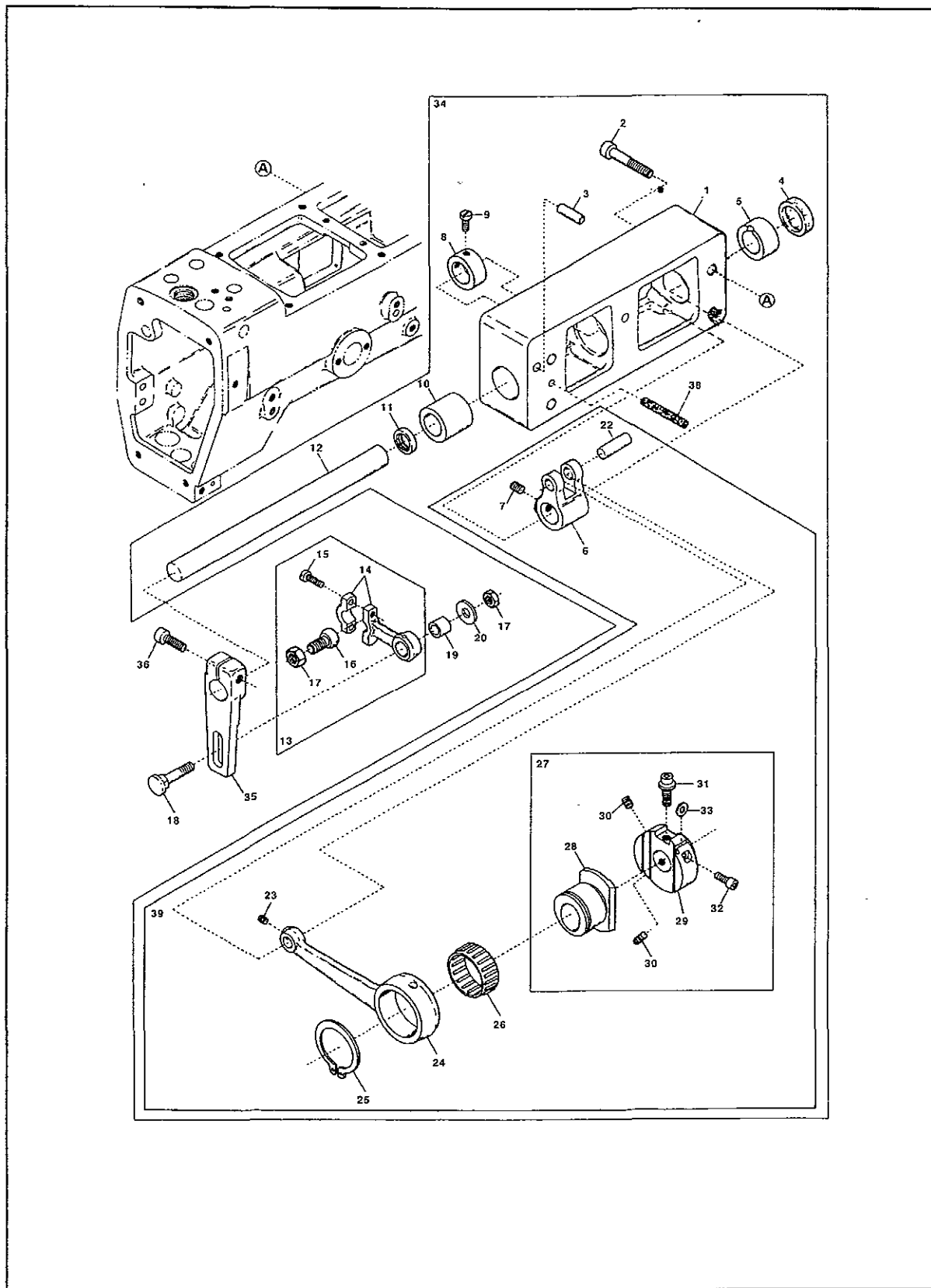
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3201329	托布架	Tape Holder	1
2	190021	托布架右轴位螺钉	Screw(M4x12)	1
3	000538	托布架螺钉垫圈	Washer	4
4	110048	托布架螺钉	Screw(M4x10)	2
5	190044	托布架左轴位螺钉	Screw(M4x12)	1
6	190022	导带杆螺柱	Screw(M4x12, M5x21)	1
7	000669	导带杆螺柱垫圈	Washer	1
8	0095269	导带杆固定块	Tape Guide Bar Holder	1
9	000600	弹性垫圈	Spring Washer	1
10	100028	蝶形螺母	Wing Nut	1
11	0095270	导带杆	Tape Guide Bar	1
12	009604	导带杆螺钉	Screw(SM11/64" x40x5.5)	1
13	3207165	压脚组件	Presser Foot, C. Set(95)	1
14	110004	压脚柄夹紧螺钉	Screw(M3.5x8)	1
15	3207167	压脚柄销	Presser Foot Hinge Pin	1
16	110084	螺钉	Screw(M3x4.2)	1
17	000531	垫圈	Washer	1
18	110054	螺钉	Screw(M3x3.5)	1
19	000327	螺母	Nut	1
20	260006	螺钉	Screw(SM1/8" x44x9.5)	1



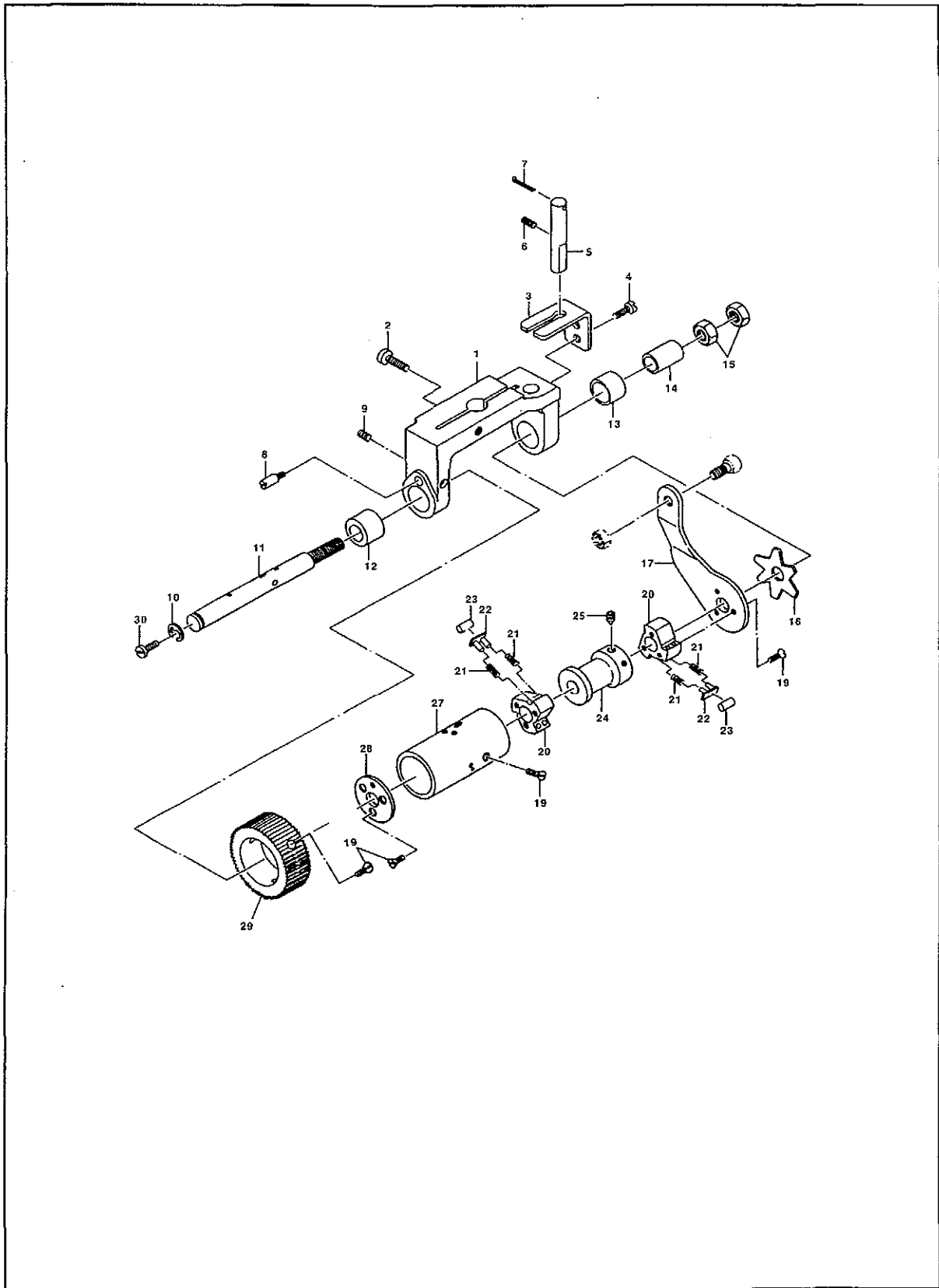
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	0094604	绷针轴孔油塞	Seal Plug	1
2	0063548	绷针曲柄轴孔油塞	Seal Plug	1
3	0093528	面线过线管夹	Thread Eyelet Pipe Stay	1
4	0021735	面线过线管	Thread Eyelet Pipe(Long)	1
5	0095916	弯针后过线板	Looper Thread Eyelet	1
6	110013	弯针后过线板螺钉	Screw(M4x8)	1
7	3201156	弯针中过线板	Looper Thread Eyelet(Right)	1
8	3201157	弯针前过线板	Looper Thread Eyelet(Left)	1
9	3201152	挑线凸轮架	Supporting Plate	1
10	0095921	挑线凸轮架左过线环	Thread Take-up Eyelet(Left)	1
11	0095922	挑线凸轮架右过线环	Thread Take-up Eyelet(Right)	1
12	0095909	挑线凸轮夹线器底板	Supplementary Tension Holder	1
13	0036175	挑线凸轮夹线器垫板	Supplementary Tension Plate	1
14	0032425	挑线凸轮夹线器压板	Supplementary Tension Disc	1
15	0090846	夹线器压簧	Looper Thread Retainer Spring	1
16	270012	夹线器压簧螺钉	Screw(SM1/8" x44x5)	1
17	3201153	夹线器过线板	Looper Thread Eyelet(Center)	1
18	000322	挡线板座螺母	Nut	1
19	3201163	夹线底板	Tension Post Support	1
20	0090807	单线过线板	Thread Lead-in Guide	3
21	0090856	双线过线板 1	Tension Disc Eyelet	1
22	0090857	双线过线板 2	Looper Thread Tension Disc Eyelet	3
23	3201162	松线板	Tensin Post Support	1
24	0090812	松线板管套	Tensin Post Ferrule	3
25	009835	夹线螺钉	Tensin Post	3
26	0031111	过线盘	Tensin Disc	6
27	000177	夹线垫板	Felt	3
28	0090071	夹线簧座	Thread Tension Spring Retainer	3
29	0090814	面线夹线簧	Needle Thread Tension Spring	1
30	0093863	夹线螺母	Thread Tension Spring Cap	3
31	0090847	绷线夹线簧	Looper Thread Tension Spring	2
32	0093865	夹线定位螺母	Thread Tension Spring Cover	1



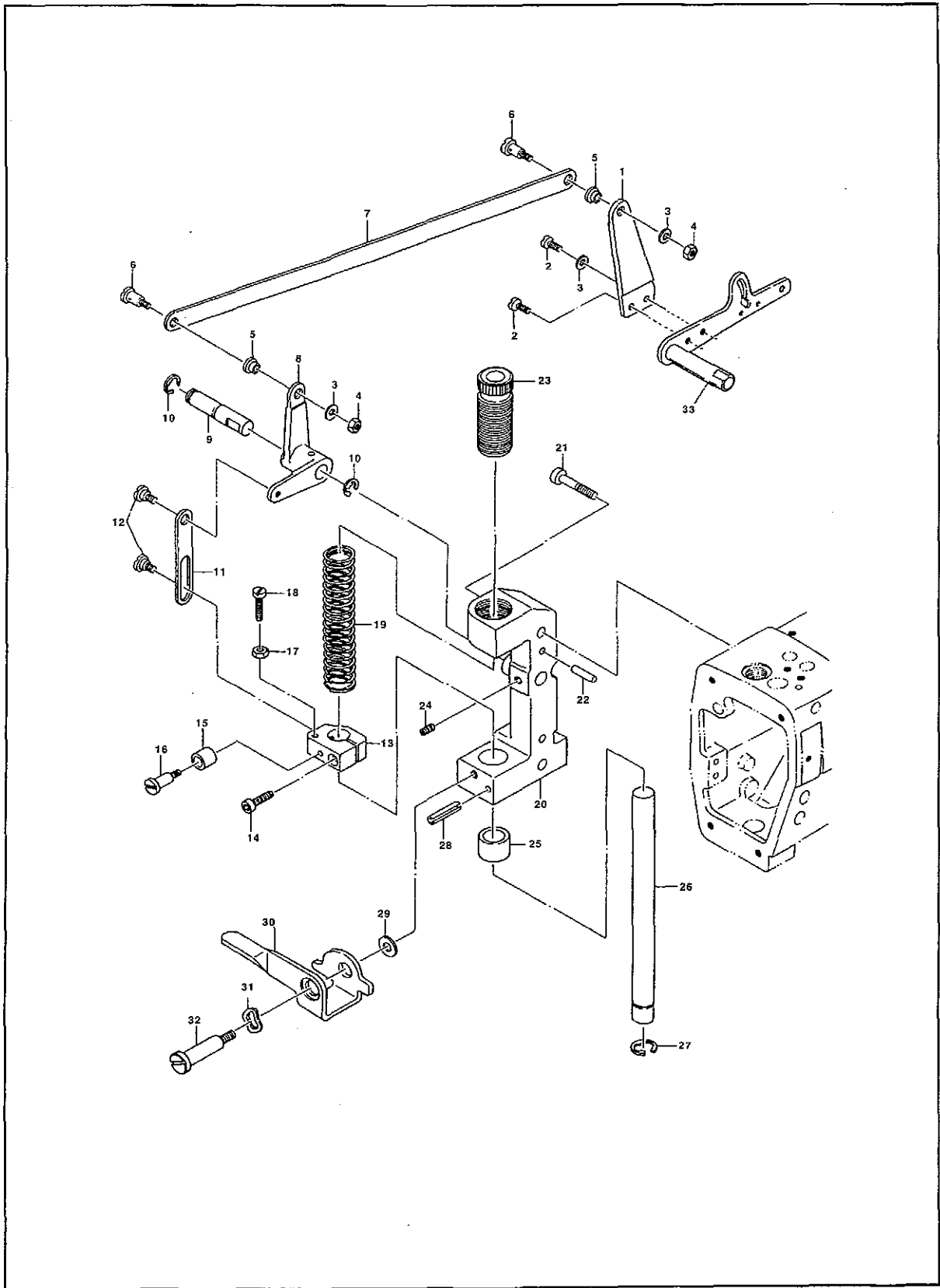
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3209113	针夹	Needle Clamp(64)	1
2	001892	机针螺钉	Screw(SM1/8"x44x2.9)	3
3	3201493	针夹单眼过线板	Needle Clamp Eyelet	1
4	001230	针夹单眼过线板螺钉	Screw(SM3/32"x56x3.8)	1
5	3201491	推板盖板	Puller Support	1
6	009747	推板盖板螺钉	Screw(M4x10)	2
7	3201492	缝台	Cloth Plate(Large)	1
8	300006	缝台螺钉垫圈	Washer	1
9	3200035	缝台摇板	Looper Thread Take-up Cover	1
10	3200034	底板前罩板	Front Cover	1
11	3201160	底板左上盖板	Cloth Plate(Small)	1
12	0095936	左上盖板推板	Slide Cover	1
13	3209203	弯针后保针架	Needle Guard	1
14	3201155	后保针架摆轴	Needle Guard Driving Shaft	1
15	3201166	主轴前节轴	Lower Crankshaft	1
16	310055	主轴前节油线	Oil Wick	1
17	160007	主轴前节油线塞螺钉	Screw(M6x6)	2
18	0094512	弯针挑线凸轮	Looper Thread Taku-up	1
19	3201490	弯针曲柄	Looper Holder	1
20	3209314	左弯针	Looper(Left)	1
21	3209313	中弯针	Looper(Medium)	1
22	0095931	右弯针	Looper(Right)	1
23	110057	弯针支头螺钉	Screw(M4x7)	3
24				
25	001459	压脚弹簧销螺钉	Screw(SM9/64"x40x3)	1
26	3207013	压脚组件	Presser Foot, Complete Set(64)	1
27	001186	压脚柄夹紧螺钉	Screw(SM9/64"x40x7.8)	1
28	0037166	压脚弹簧销	Presser Foot Pin	1
29	0037164	压脚弹簧	Presser Foot Spring	1
30	3208063	针板	Stitch Plate(64)	1
31	3209038	送料牙	Main Feed Dog	1
32	3209039	差动牙	Differential Feed Dog	1



序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3100625	上送布轮轴架	Upper Feed Roller Shaft Bracket	1
2	120019	上送布轮轴架螺钉	Screw(M6x18)	4
3	000779	上送布轮轴架定位销	Knock Pin	2
4	3100006	右轴套油塞	Seal Plug	1
5	3100607	上送布轮轴右轴套	Roller Shaft Bushing(Right)	1
6	3100604	上送布轮轴右曲柄	Upper Feed Roller Shafte Lever	1
7	160007	右曲柄螺钉	Screw(M6x6)	2
8	0065398	上送布轮轴垫圈	Collar(ø14xø22x10mm)	1
9	009604	垫圈螺钉	Screw(sm11/64"x40x5.5)	2
10	3100626	上送布轮轴左轴套	Roller Shaft Bushing(Left)	1
11	0065395	左轴套油封	Oil Seal	1
12	3100605	上送布轮轴	Upper Feed Roller Shaft	1
13	3100633	上送布轮左连杆组件	Upper Feed Roller Lever Rod,c,set	1
14	0065400	上送布轮左连杆	Upper Feed Roller Lever Rod	1
15	001174	上盖螺钉	Screw(SM9/64"x40x10.3)	2
16	0060109	球头螺钉	Ball Stud	1
17	000306	球头螺钉螺母	Nut	2
18	0065401	上送轮轴左曲柄销	Upper Feed Roller Lever Pin	1
19	0065402	主送布轮左连杆套管	Upper Feed Roller Lever Rod Sleeve	1
20	000613	左曲柄销垫圈	Washer	1
21				
22	0032921	上送布轮轴左曲柄销	Upper Feed Roller Driving Rod Pin	1
23	160001	右曲柄销螺钉	Screw(M4x4)	1
24	3100602	上送布轮右连杆	Upper Feed Roller Driving Rod	1
25	3100192	轴承弹性挡圈	Retaining Ring	1
26	3100623	上送布轮右连杆滚针轴承	Roller Bearing	1
27	3100603	上送布轮偏心轮组件	Upper Feed Roller Regulator, Complete Set	1
28	3100601	上送布轮偏心轮	Upper Feed Roller Eccentric	1
29	3100600	上送布轮偏心轮座	Upper Feed Roller Regulator	1
30	160003	偏心轮座螺钉	Screw(M5x5)	2
31	190007	调节螺钉	Ajusting Screw(M5x6)	
32	120008	偏心轮座夹紧螺钉	Screw(M4x8)	1
33	300045	夹紧螺钉垫	Spacer	1
34	3100636	上送布轮组件	Upper Feed Roller Shaft Bracket	1
35	3100608	上送布轴左曲柄	Upper Feed Roller Lever	1
36	120012	左曲柄螺钉	Screw(M6x20)	1
37				1
38	310063	油线	Oil Wick	1
39	3101212	上送布轮右连杆组件 2	Upper Feed Roller Driving Rod, C. Set(2)	1



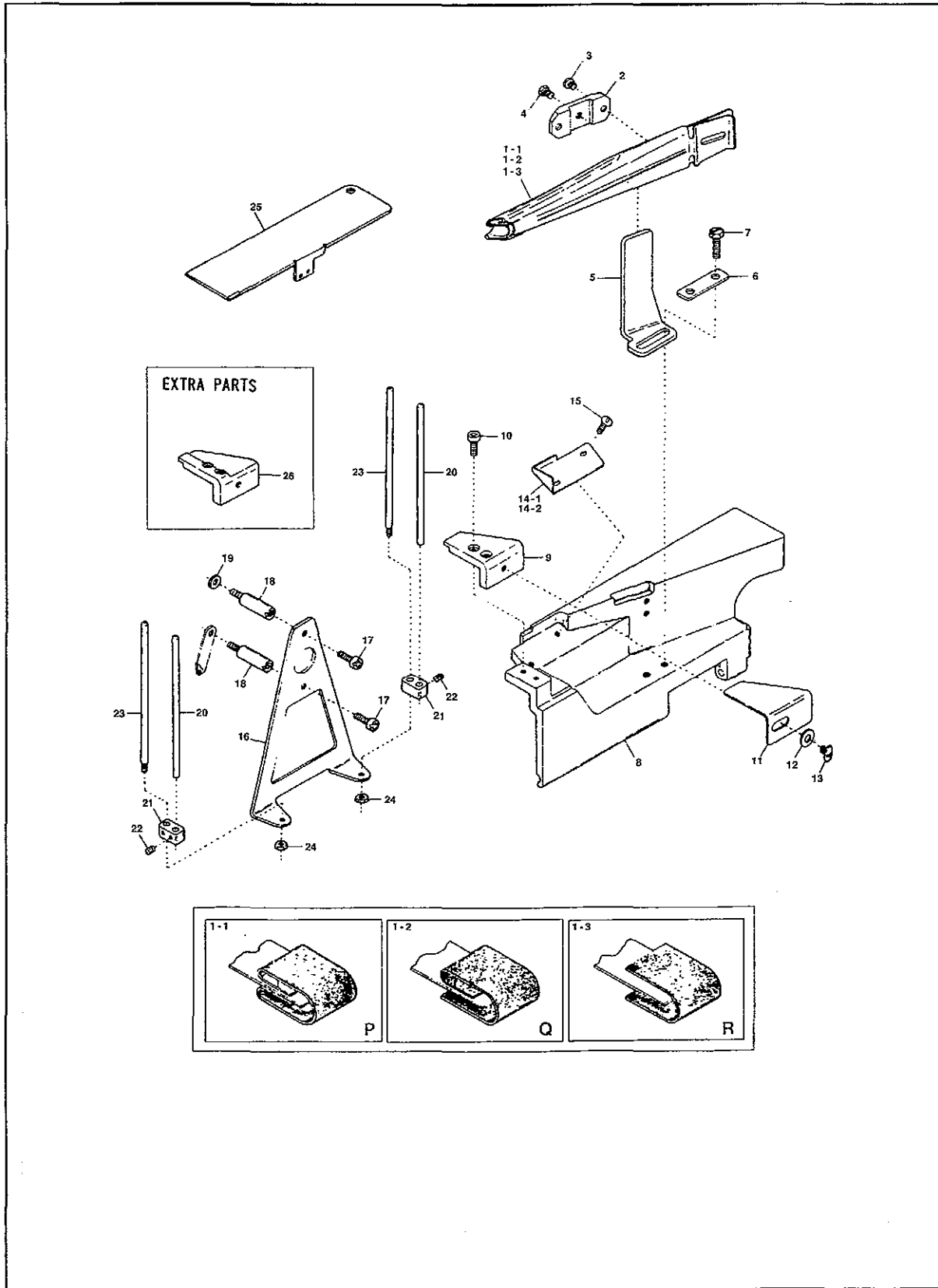
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3300070	上送布轮支架	Upper Feed Roller Yoke	1
2	120012	支架螺钉	Screw(M6x20)	1
3	3300071	上送布轮支架导向板	Upper Feed Roller Yoke Guide	1
4	110009	支架导向板螺钉	Screw(M4x8)	2
5	3100613	上送轮支架销	Upper Feed Roller Yoke Pin	1
6	160007	支架销螺钉	Screw(M6x6)	1
7	0090620	开口销	Cotter Pin	1
8	006270	支柱螺钉	Screw(SM9/64"x40x0.5)	1
9	160001	紧定螺钉	Screw(M4x4)	2
10	0060056	离合器开口挡圈	Retaining Ring	1
11	3300072	离合器轴	Clutch Driving Shaft	1
12	3100616	离合器轴左轴套	Clutch Driving Shaft Bushing(Left)	1
13	0065414	离合器轴右轴套	Clutch Driving Shaft Bushing(Right)	1
14	0065421	离合器轴隔套	Clutch Tension Sleeve	1
15	000145	调节螺母	Adjusting Nut	2
16	0065420	离合器拉簧	Clutch Tension Spring	1
17	3300074	离合器右曲柄	Clutch Driving Lever	1
18				
19	007621	左曲柄螺钉	Screw(SM9/64"x40x8.5)	12
20	0095061	离合块	Clutch	2
21	3201277	离合器弹簧	Clutch Spring	12
22	0095066	离合器弹簧座	Clutch Spring Seat	6
23	0065417	离合器滚子	Clutch Roller	6
24	3300073	离合器隔套	Clutch Spacer	1
25	160005	隔套定位螺钉	Screw(M6x8)	1
26				
27	3300075	离合器外套	Clutch Sleeve	1
28	0065418	离合器左防松板	Clutch Check Plate	1
29	3201494	上送布轮	Upper Feed Roller (60 teeth)	1
30	110011	离合器轴端面螺钉	Screw(M5x10)	1



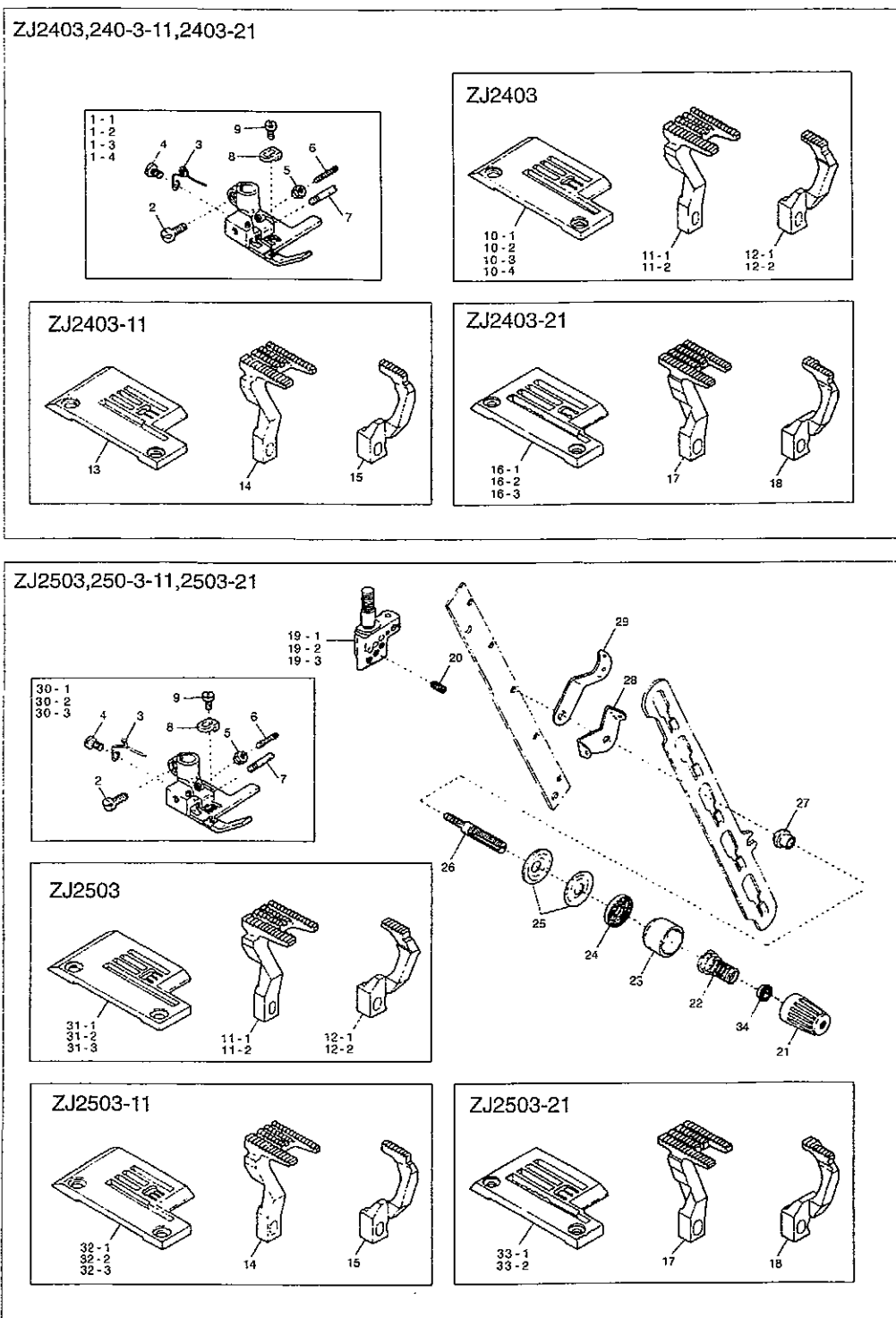
## ZJ2502P 专用零部件(5)

## SUBMODEL EXCLUSIVE PARTS(5)

序号 No.	件号 Parts No.	名称	Description	数量 Number
1	0065381	上送布轮右曲柄	Upper Feed Roller Lifter(Right)	1
2	004440	右曲柄螺钉	Screw(SM11/64" x40x8.3)	2
3	000538	右曲柄螺钉垫圈	Washer	3
4	000334	右曲柄螺母	Nut	2
5	0034979	轴位螺钉套	Flexible Wire Vlamp Bushing	2
6	006075	右曲柄轴位螺钉	Screw(SM11/64" x40x6)	2
7	0067126	连杆板	Lifter Connecting Plate	1
8	0065374	上送布轮左曲柄	Upper Feed Roller Lifter(Left)	1
9	0065375	左曲柄销	Upper Feed Roller Lifter Pin	1
10	0095027	左曲柄销开口挡圈	Retaining Ring	2
11	0065376	抬压脚台升降连接板	Lifter Connecting Plate	1
12	006038	连接板轴位螺钉	Screw(SM3/16" x32x2.2)	2
13	0065407	压杆导架	Roller Press Bar Bracket	1
14	005650	压杆导架螺钉	Screw(M5x14)	1
15	0065402	下轴位螺钉套	Lifting Lever Sleeve	1
16	006411	压杆导架轴位螺钉	Screw(SM11/64" x40x5.5)	1
17	000340	锁紧螺母	Lock Nut	1
18	009931	调节螺钉	Stop Screw(SM11/64" x40x26)	1
19	3100614	调压簧	Roller Press Spring	1
20	3100610	上送布轮压杆支架	Upper Feed Roller Bracket	1
21	009753	支架螺钉	Screw(M6x35)	2
22	000779	支架定位销	Knock Pin	2
23	0065405	调压螺母	Roller Press Bar Bushing(Upper)	1
24	160007	右曲柄销紧定螺钉	Screw(M6x6)	1
25	3100609	压杆下轴套	Roller Press Bar Bushing(Lower)	1
26	0065404	上送布轮压杆	Upper Feed Roller Press Bar	1
27	0034117	压杆开口挡圈	Retaining Ring	1
28	000690	开口销	Stop Pin	1
29	000613	垫圈	Washer	1
30	0067111	上送布轮手柄	Upper Feed Roller Lifting Lever	1
31	000487	波形垫圈	Corrugated Washer	1
32	170008	手柄螺钉	Screw(M6x9)	1
33	3201495	抬压脚凸轮	Lifter Lever	1

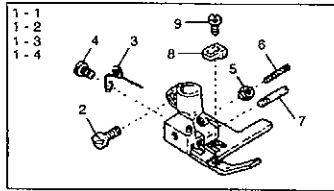


序号 No.	件号 Parts No.	名称	Description	数量 Number
1-1	0093241	卷边器	Folder(for Type P)	1
1-2	0093242	"	" " (Q)	1
1-3	0093243	"	" " (R)	1
2	0091736	卷边器夹紧垫块	Folde Clamp	1
3	009932	垫块螺钉	Screw(SM11/64"x40x4)	2
4	005554	卷边器夹紧螺钉	Screw(SM7/32"x32x6.5)	1
5	0094245	卷边器支架座	Folder Support	1
6	0094246	卷边器支座压板	Folder Suppot Fixing Plate	1
7	140019	支座螺钉	Screw(M5x14)	2
8	3201000	底板前罩板	Front Cover	1
9	3201002	底板小前罩板	Front Cover(Small)	1
10	110009	小前罩板螺钉	Screw(M4x8)	2
11	0096277	导料滑板	Fabric Slide Plate	1
12	000426	滑板螺钉垫	Washer	1
13	110103	滑板螺钉	Screw(M5x8)	1
14-1	3201003	挡料板	Dustproof Cover	1
14-2	3201005	"	" " (ZJ2403-21, 2503-21)	1
15	110104	挡料板螺钉	Screw(M4x8)	2
16	0094235	导带支架	Tape Guide Holder	1
17	110013	导带支架螺钉	Screw(M4x8)	2
18	190028	导带支架支柱螺钉	Screw(M4x10)	2
19	000547	支柱螺钉垫圈	Washer	1
20	0091709	短导带杆	Tape Guide(Short)	2
21	0091707	导带杆固定块	Tape Guide Adjusting Holder	2
22	001457	导带杆紧定螺钉	Screw(SM11/64"x40x3.3)	4
23	0091708	长导带杆	Tape Guide(Long)	2
24	000340	长导带杆螺母	Nut	2
25	3201001	缝台摇板	Loper Thread Take-up Cover	1
26	3201004	底板小前罩板(特制品)	Front Cover (Small) (Extra) (Notel)	1

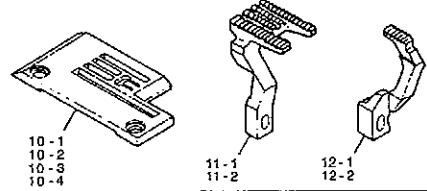


序号 No.	件号 Parts No.	名称	Description	数量 Number
1-1	3207150	压脚组件	Presser Foot, Complete Set(32)	1
1-2	3207151	"	" " (40)	1
1-3	3207152	"	" " (48)	1
1-4	3207154	"	" " (64)	1
2	001186	压脚柄夹紧螺钉	Screw(SM9/64"x40x7.8)	1
3	0091725	压脚扭簧	Presser Foot Spring	1
4	005133	扭簧螺钉	Screw(SMSM1/8"x44x4.5)	1
5	000220	锁紧螺母	Lock Nut	1
6	003300	调节螺钉	Asjusting Screw(SM1/8"x44x15)	1
7	0091696	压脚柄销	Presser Foot Hinge Pin	1
8	3207160	挡布压板	Tape Guide	1
9	001230	压板螺钉	Screw(SM3/32"x56x3.8)	1
10-1	0094210	针板	Stitch Plate(32M)	1
10-2	0094211	"	" (40M)	1
10-3	0094212	"	" (48M)	1
10-4	0094214	"	" (64M)	1
11-1	3209014	送料牙	Main Feed Dog(32, 40, 48, 56)	1
11-2	3209016	"	" " (64)	1
12-1	3209005	差动牙	Differential Feed Dog(32, 40, 48, 56)	1
12-2	3209007	"	" " (64)	1
13	0095234	针板	Stitch Plate(40M-11)	1
14	3209008	送料牙	Main Feed Dog	1
15	3209009	差动牙	Differential Feed Dog	1
16-1	3208102	针板	Stitch Plate(32M-21)	1
16-2	3208103	"	" (40M-21)	1
16-3	3208104	"	" (48M-21)	1
17	3209064	送料牙	Main Feed Dog	1
18	3209065	差动牙	Differential Feed Dog	1
19-1	3209106	针夹	Needle Clamp(48)	1
19-2	3209107	"	" (56)	1
19-3	3209108	"	" (64)	1
20	001892	机针螺针	Screw(SM1/8"x44x2.9)	1
21	0093863	夹线螺母	Thread Tension Spring Cap	3
22	0090814	面线夹线簧	Needle Thread Tension Spring	1
23	0090071	夹线簧座	Thread Tension Spring Retainer	1
24	000177	夹线垫板	Felt	1
25	0031111	夹线盘	Tension Disc	1
26	009835	夹线螺钉	Tension Post	2
27	0090812	松线套管	Tension Post Ferrule	1
28	0090856	双线过线板	Tension Disc Eyelet	1
29	0090807	单线过线板	Thread Lead-in Guide	1
30-1	3207155	压脚组件	Presser Foot, Complete Set(48)	1
30-2	3207156	"	" " (56)	1
30-3	3207157	"	" " (64)	1

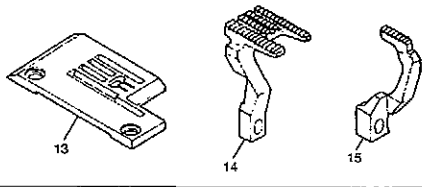
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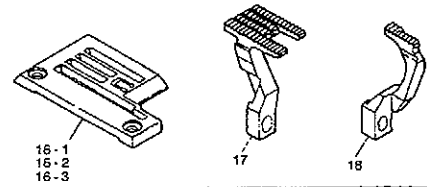
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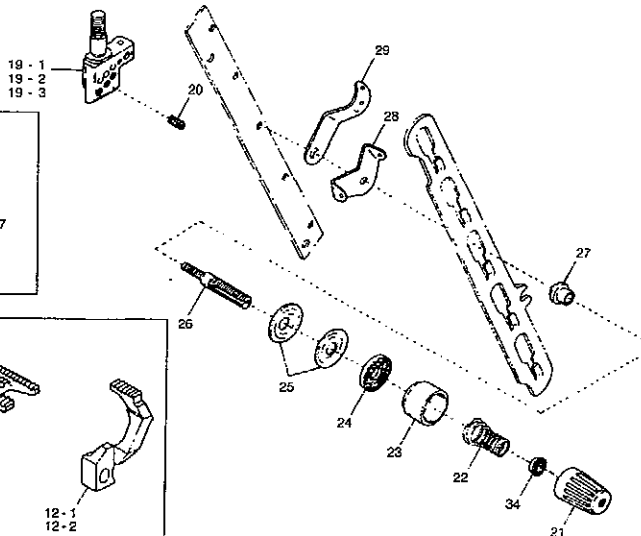
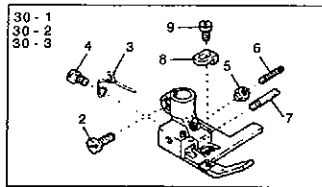
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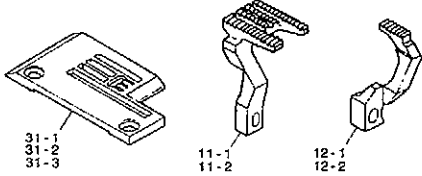
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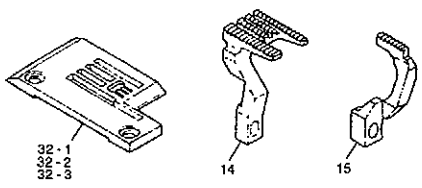
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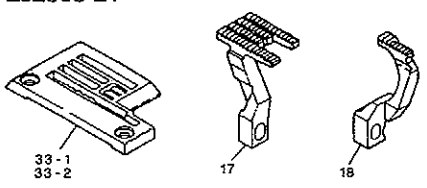
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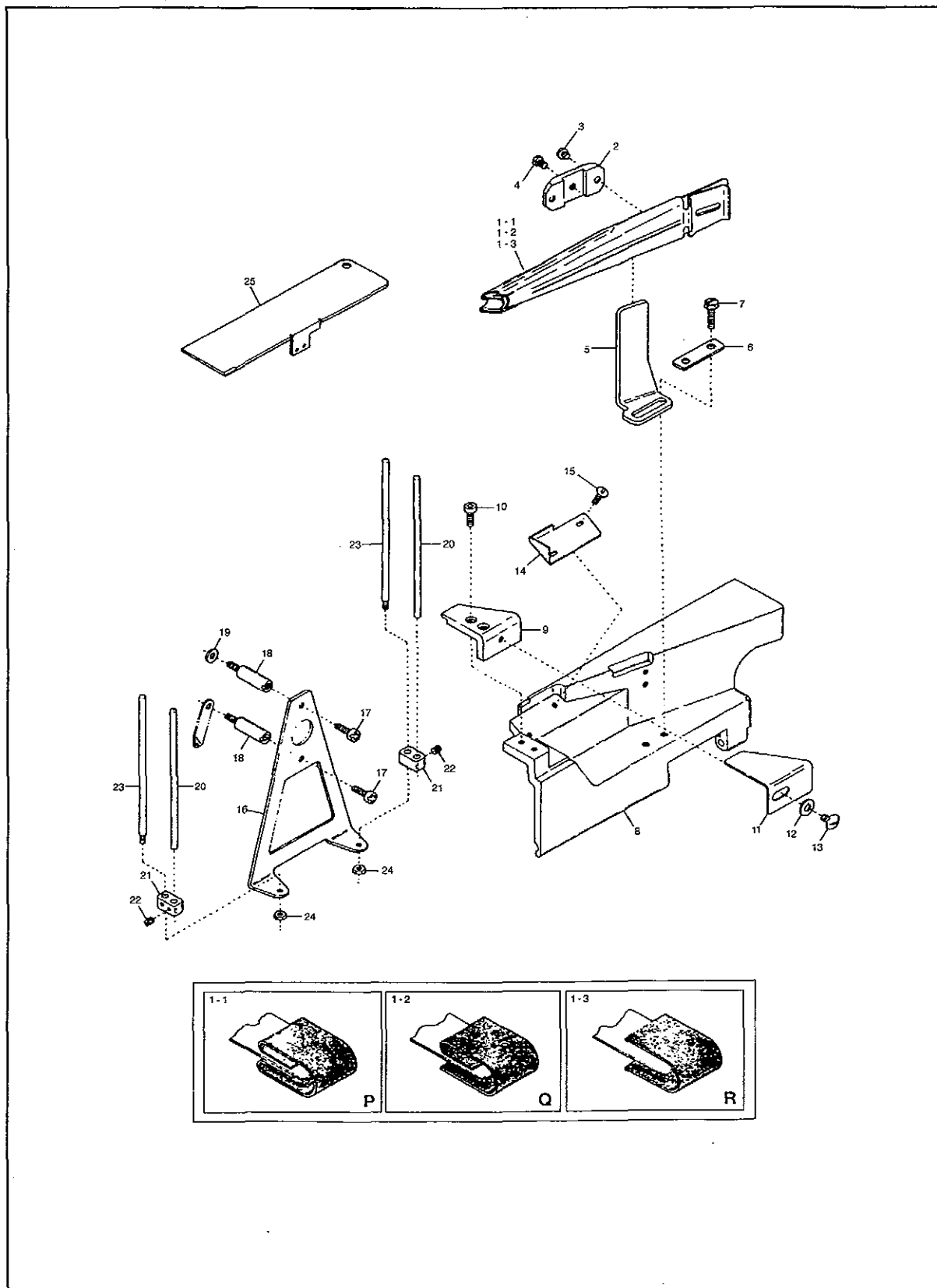
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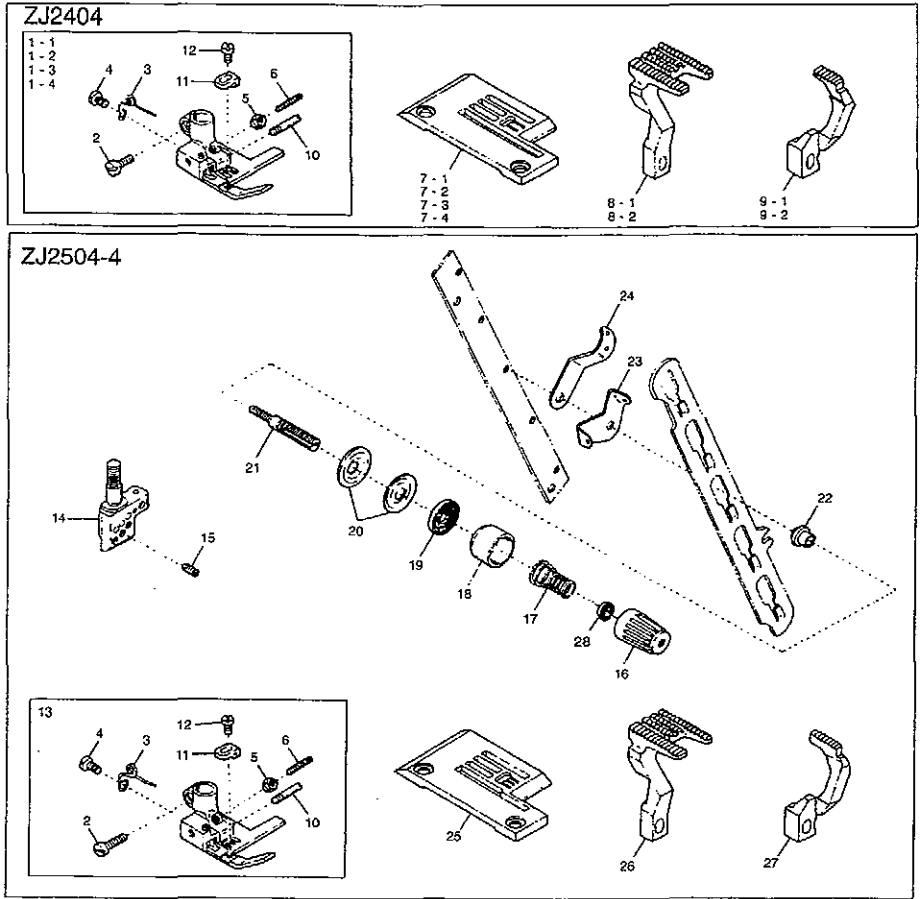
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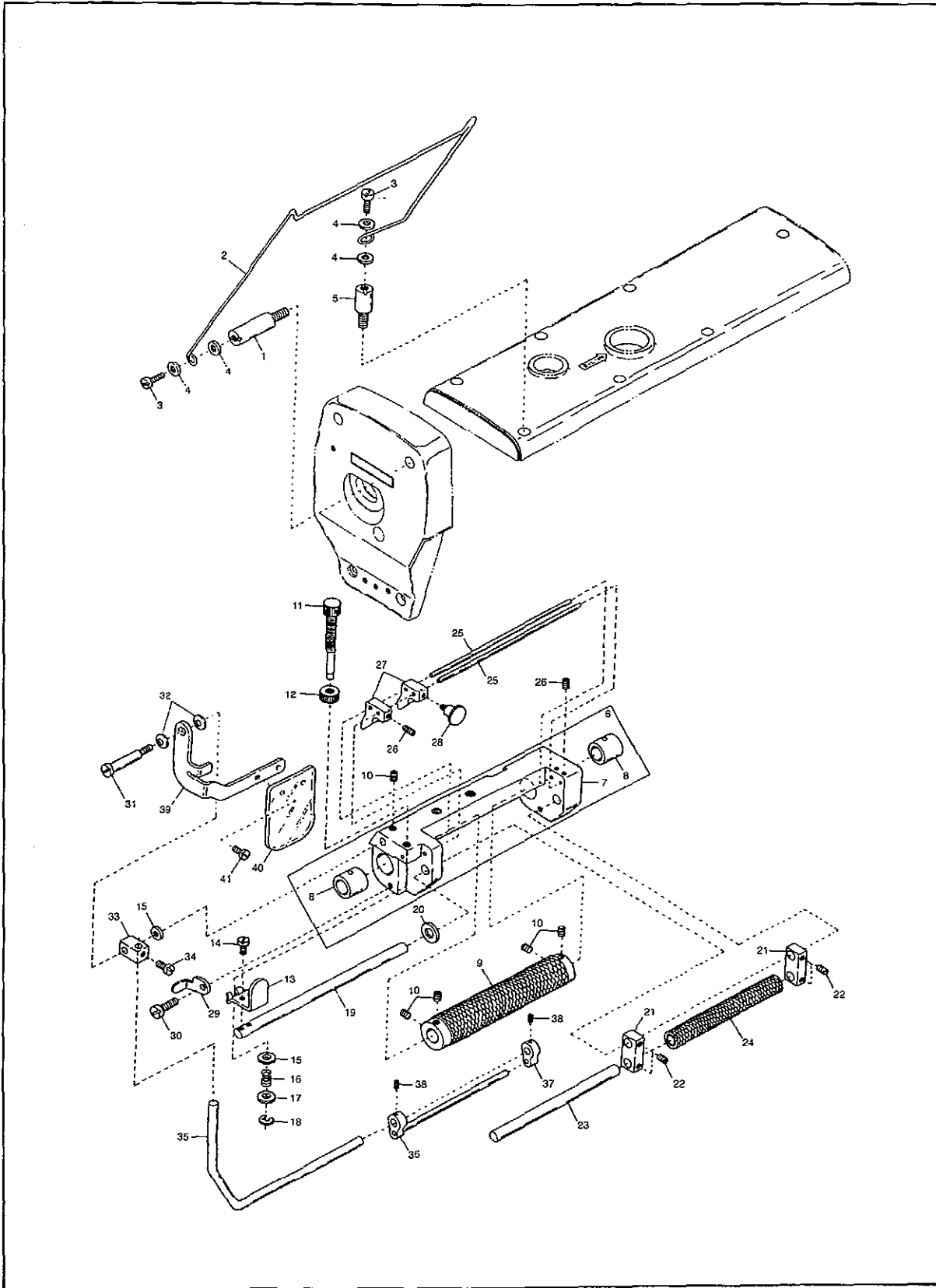
序号 No.	件号 Parts No.	名称	Description	数量 Number
31-1	3208026	针板	Stitch Plate(48M)	1
31-2	0094901	"	" (56M)	1
31-3	0094902	"	" (64M)	1
32-1	3208052	针板	Stitch Plate(48M-11)	1
32-2	0095085	"	" (56M-11)	1
32-3	3008025	"	" (64M-11)	1
33-1	3208108	针板	Stitch Plate(56M-21)	1
33-2	3208109	"	" (64M-21)	1
34	0093865	夹线定位螺母	Thread Tension Spring Cover	1



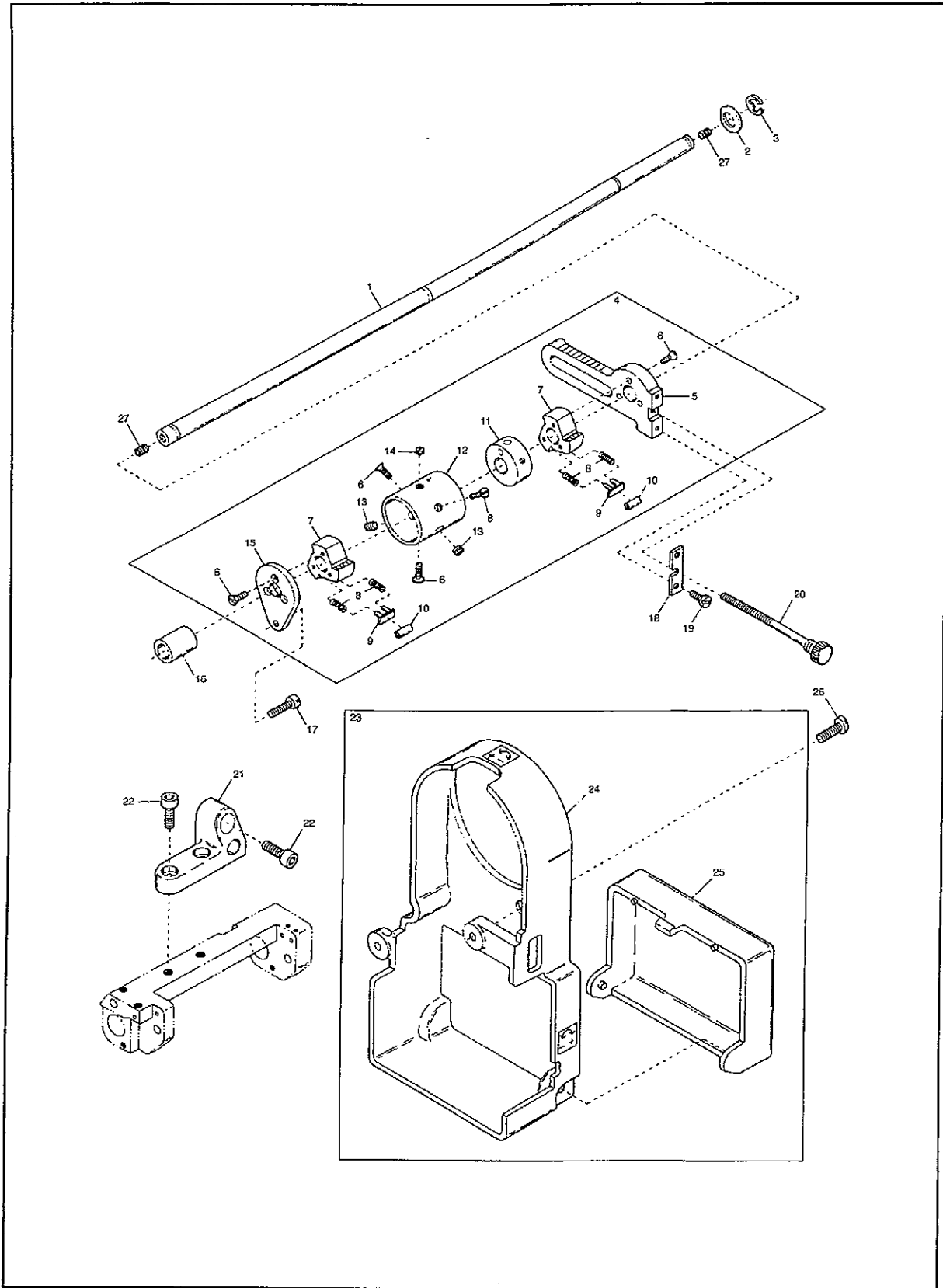
序号 No.	件号 Parts No.	名称	Description	数量 Number
1-1	0093241	卷边器	Folder(for Type P)	1
1-2	0093242	"	" " (Q)	1
1-3	0093243	"	" " (R)	1
2	0091736	卷边器夹紧垫块	Folder Clamp	1
3	009932	垫块螺钉	Screw(SM11/64"x40x4)	2
4	005554	卷边器夹紧螺钉	Screw(SM7/32"x32x6.5)	1
5	0094245	卷边器支座	Folder Support	1
6	0094246	卷边器支座压板	Folder Support Fixing Plate	1
7	140019	支座螺钉	Screw(M5x14)	2
8	3201000	底板前罩板	Front Cover	1
9	3201002	底板小前罩板	Front Cover(Small)	1
10	110009	小前罩板螺钉	Screw(M4x8)	2
11	0096277	导料布滑板	Fabric Slide Plate	1
12	000426	滑板螺钉垫圈	Washer	1
13	110103	滑板螺钉	Screw(M5x8)	1
14	3201003	挡料板	Dustproof Cover	1
15	110104	挡料板螺钉	Screw(M4x8)	2
16	0094235	导带支架	Tape Guide Holder	1
17	110013	导带支架螺钉	Screw(M4x8)	2
18	190028	导带支架支柱螺钉	Screw(M4x10)	2
19	000547	支柱螺钉垫圈	Washer	1
20	0091709	短导带杆	Tape Guide (Short)	2
21	0091707	导带杆固定块	Tape Guide Adjusting Holder	2
22	001457	短导带杆紧定螺钉	Screw(SM11/64"x40x3.3)	4
23	0091708	长导带杆	Tape Guide(Long)	2
24	000340	长导杆螺钉	Nut	2
25	3201001	缝台摇板	Looper Thread Take-up Cover	1



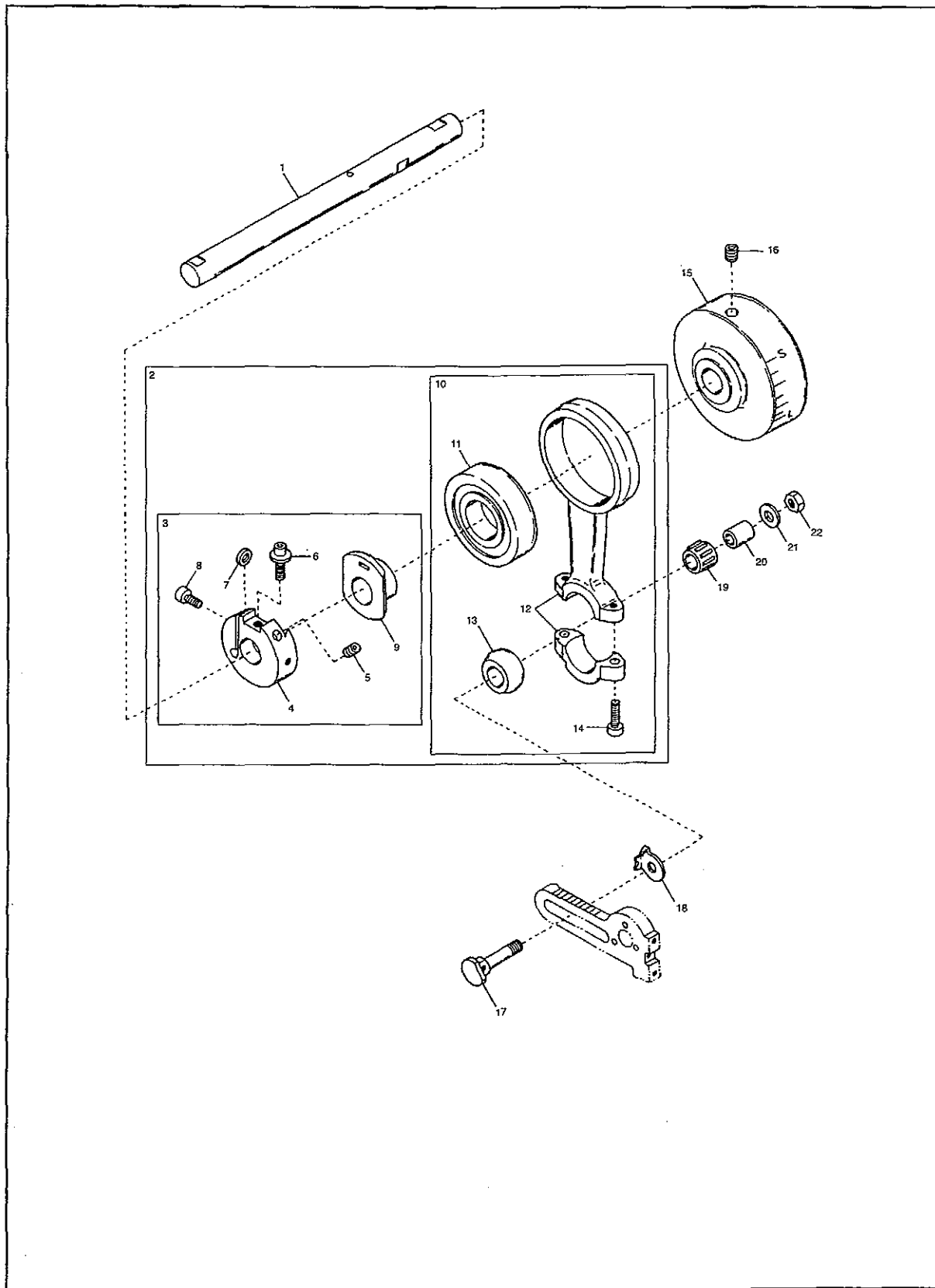
序号 No.	件号 Parts No.	名称	Description	数量 Number
1-1	3207150	压脚组件	Presser Foot, Complete Set(32)	1
1-2	3207151	"	" " (40)	1
1-3	3207152	"	" " (48)	1
1-4	3207154	"	" " (64)	1
2	001186	压脚柄夹紧螺钉	Screw(SM9/64"x40x7.8)	1
3	0091725	压脚扭簧	Presser Foot Spring	1
4	005133	扭簧螺钉	Screw(SM1/8"x44x4.5)	1
5	000220	锁紧螺母	Lock Nut	1
6	003300	调节螺钉	Adjusting Screw(SM1/8"x44x15)	1
7-1	0094210	针板	Stitch Plate(32M)	1
7-2	0094211	"	" (40M)	1
7-3	0094212	"	" (48M)	1
7-4	0094214	"	" (64M)	1
8-1	3209014	送料牙	Main Feed Dog(32, 40, 48, 56)	1
8-2	3209016	"	" " (64)	1
9-1	3209005	差动牙	Differential Feed Hinge Pin(32, 40, 48, 56)	1
9-2	3209007	"	" " (64)	1
10	0091696	压脚柄销	Presser Foot Hinge Pin	1
11	3207160	挡布压板	Tape Guide	1
12	001230	挡布压板螺钉	Screw(SM3/32"x56x3.8)	1
13	3207156	压脚组件	Presser Foot, Complete Set(56)	1
14	3209107	针夹	Needle Clamp(56)	1
15	001892	机针螺钉	Screw(SM1/8"x44x2.9)	3
16	0093863	夹线螺母	Thread Tension Spring Cap	1
17	0090814	面线夹线簧	Needle Thread Tension Spring	1
18	0090071	夹线簧座	Thread Tension Spring Retainer	1
19	000177	松线垫板	Felt	1
20	0031111	夹线盘	Tension Disc	2
21	009835	夹线螺钉	Tension Post	1
22	0090812	松线板套管	Tension Post Ferrule	1
23	0090856	双线过线板	Tension Disc Eyelet	1
24	0090807	单线过线板	Thread Lead-in Guide	1
25	0095085	针板	Stitch Plate(56M)	1
26	3209008	送料牙	Main Feed Dog	1
27	3209009	差动牙	Differential Feed Dog	1
28	0093865	夹线定位螺母	Thread Tension Spring Cover	1



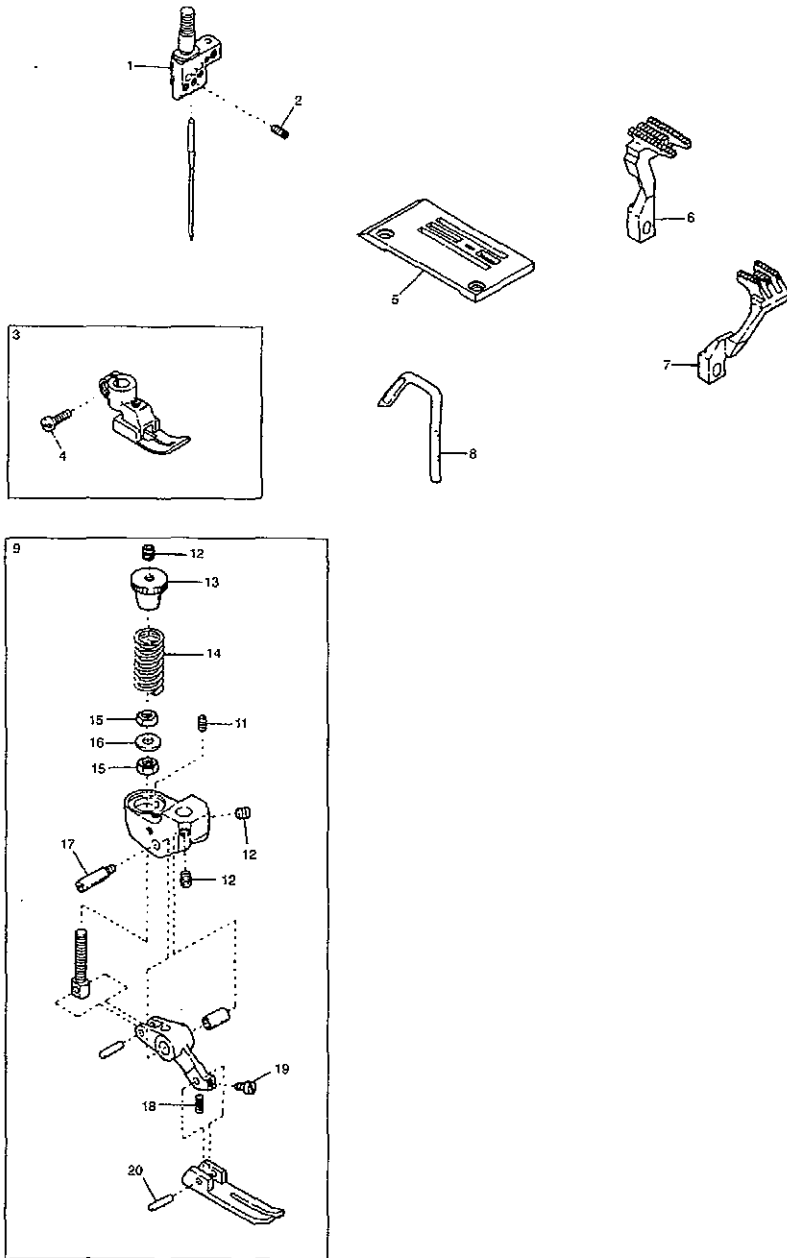
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	190044	托布架左轴位螺钉	Screw(M4x12)	1
2	3201329	托布架	Tape Holder	1
3	110048	托布架螺钉	Screw(M4x10)	2
4	000538	托布架螺钉垫圈	Washer	4
5	190021	托布架右轴位螺钉	Screw(M4x12)	1
6	3201369	夹带滚轮座组件	Tension Roller Holder, C. Set	1
7	3201368	夹带滚轮座	Tension Roller Holder	1
8	3201184	夹带滚轮轴套	Roller Shaft Bushing	2
9	3201185	夹带滚轮(大)	Tension Roller(Large)	1
10	160001	紧定螺钉	Screw(M4x4)	5
11	190075	调节螺钉	Adjusting Screw(M5x28)	1
12	100053	锁紧螺母	Lock Nut	1
13	3201372	夹带滚轮旋转手柄	Roller Lever	1
14	110036	手柄螺钉	Screw(M3x6.5)	2
15	000669	上垫圈	Washer	2
16	2100043	压簧	Tension Spring	1
17	000665	下垫圈	Washer	1
18	0077179	开口挡圈	Retaining Ring	1
19	3201190	夹带滚轮座轴(小)	Tension Link Shaft	1
20	000425	夹带滚轮座轴垫圈	Washer	1
21	3201375	夹带滚轮座(小)	Tension Link	2
22	150001	夹带滚轮座螺钉	Screw(M4x4)	4
23	3201191	夹带滚轮轴(小)	Roller Shaft(Small)	1
24	3201186	夹带滚轮(小)	Tension Roller (Small) Unit	1
25	3201192	上导带杆	Tape Guide Wire	2
26	160000	上导带杆螺钉	Screw(M3x3)	3
27	3201370	上导带杆固定块	Tape Guide	2
28	190064	固定块轴位螺钉	Knob Screw(M3x5)	1
29	3201371	导带器止动板	Tape Guide Stop	1
30	110009	止动板螺钉	Screw(M4x8)	1
31	170001	安全板架轴位螺钉	Screw(M4x8)	1
32	300100	轴位螺钉垫圈	Conical Spring Washer	2
33	0095269	下导带杆固定块	Tape Guide Bar Holder	1
34	009604	固定块螺钉	Screw(SM11/64"x40x5.5)	1
35	3201195	下导带杆	Tape Guide Bar(Long)	1
36	3201197	下导带小杆架组件	Tape Guide Unit	1
37	0095272	小杆固定块	Tape Guide	1
38	001892	固定块螺钉	Screw(SM1/8"x44x2.9)	2
39	3201331	安全板架	Eye Guard Support	1
40	3200252	安全板	Eye Guard	1
41	110038	安全板螺钉	Screw(M2.5x4.5)	2



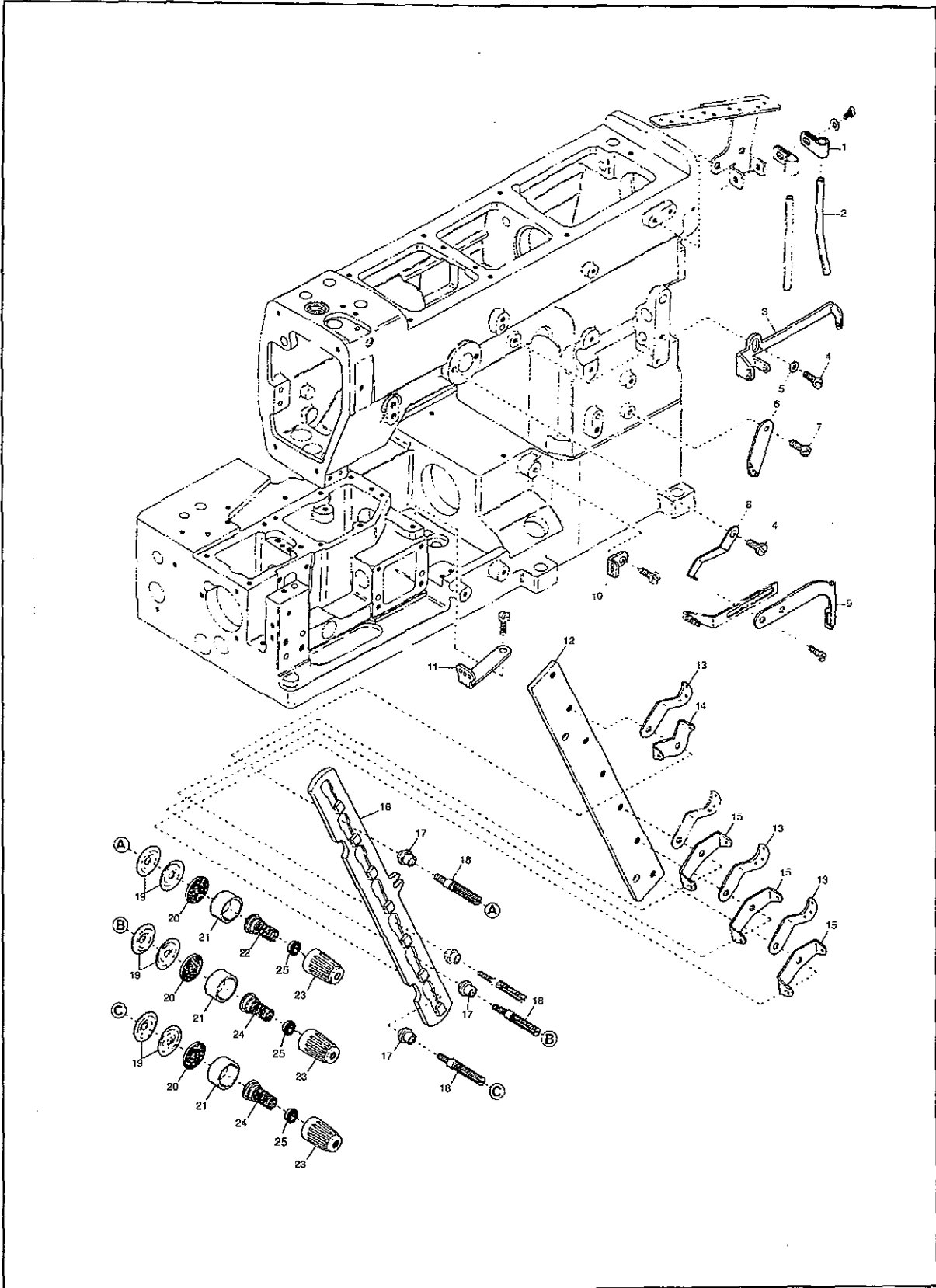
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3201366	夹带滚轮轴	Roller Shaft	1
2	3201382	垫圈	Thrust Washer	1
3	0095027	夹带滚轮轴开口挡圈	Retaining Ring	1
4	3201381	离合器组件	Clutch, Complete Set	1
5	3201358	离合器调整曲柄	Clutch, Lever	1
6	007621	曲柄螺钉	Screw(SM9/64"x40x8.5)	9
7	0095061	离合块	Clutch	2
8	3201277	离合器弹簧	Clutch Spring	12
9	0095066	离合器弹簧座	Clutch Spring Seat	6
10	0095067	离合器滚子	Clutch Roller	6
11	0095063	离合器套垫圈	Clutch Sleeve Collar	1
12	0095062	离合器套	Clutch Sleeve	1
13	003635	垫圈螺钉	Screw(SM1/4"x40x6)	2
14	007645	离合器套螺钉	Screw(SM1/4"x40x3)	1
15	3201360	离合器从动片	Clutch Plate	1
16	3201184	夹带滚轮轴套	Roller Shaft Bushing	1
17	110009	从动片螺钉	Screw(M4x8)	1
18	3201089	调整曲柄板	Clutch Lever Pin Adjusting Plate	1
19	110002	调节板螺钉	Screw(M3x5)	2
20	190034	调整曲柄调节螺钉	Adjusting Screw(M4x69)	1
21	3201367	夹带滚轮座固定架	Tension Roller Holder Bracket	1
22	120006	固定架螺钉	Screw(M6x12)	4
23	3201380	离合器连杆护罩组件	Clutch Rod Cover, C.Set	1
24	3201364	离合器连杆罩	Clutch Rod Cover	1
25	3201365	离合器连杆护罩(右)	Clutch Rod Cover(Right)	1
26	110047	连杆护罩螺钉	Screw(M4x10)	2
27	160003	夹带滚轮轴端面螺钉	Screw(M5x5)	2



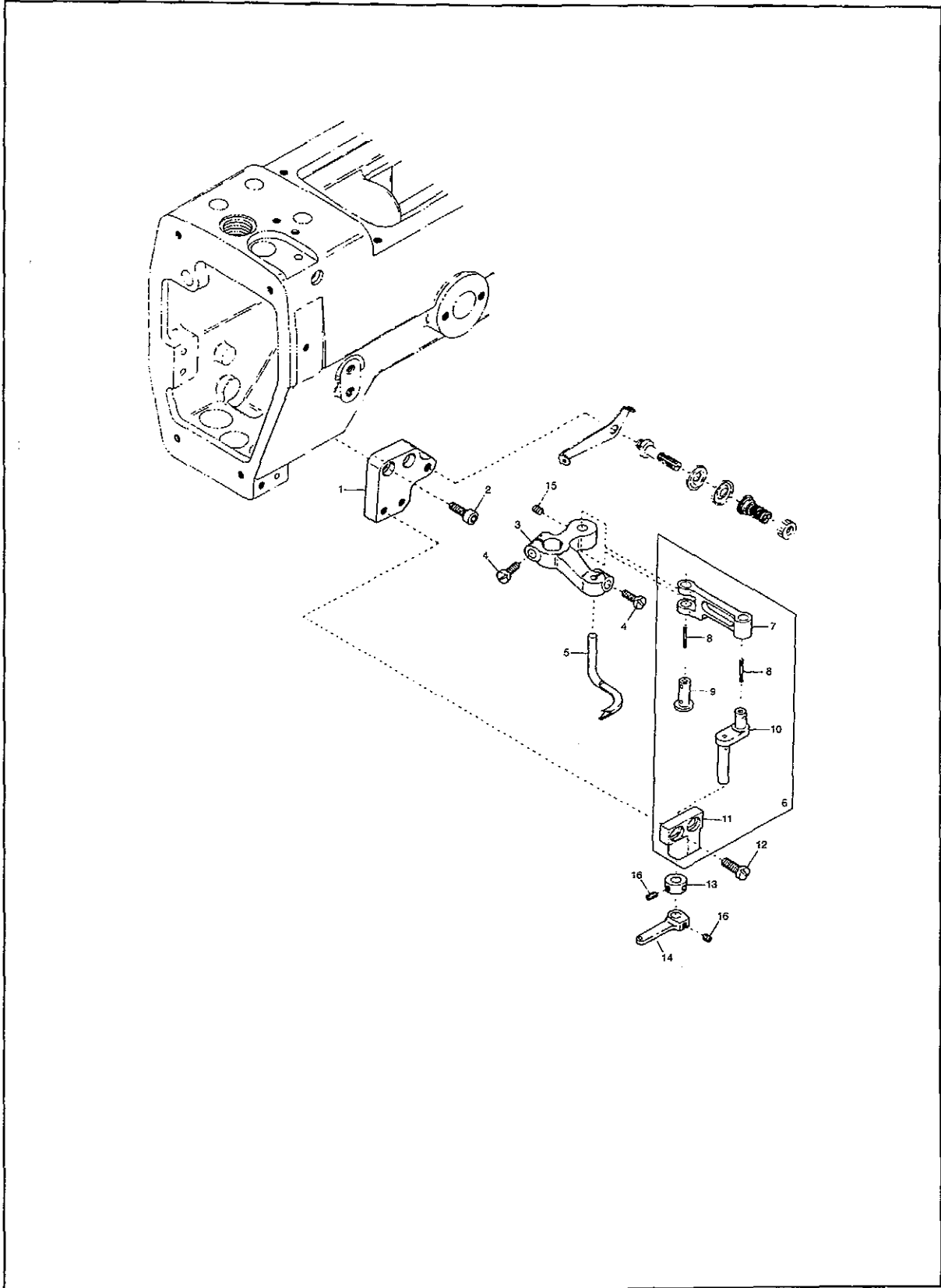
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3201362	上轴后节轴	Upper Shaft(Right)	1
2	3201383	离合器传动组件	Clutch Driving Rod & Eccentric, C. Set	1
3	3201379	离合器偏心轮套组件	Clutch Eccentric, C. Set	1
4	3201351	离合器偏心轮座	Clutch Regulator	1
5	160003	偏心轮座螺钉	Screw(M5x5)	2
6	190007	调节螺钉	Adjusting Screw(M5x6)	1
7	300045	垫片	Spacer	1
8	120008	偏心轮座夹紧螺钉	Screw(M4x8)	1
9	3201350	离合器偏心轮	Clutch Eccentric	1
10	3201378	离合器传动连杆组件	Clutch Driving Rod, C. Set	1
11	3201353	离合器传动连杆轴承	Ball Bearing	1
12	3201352	离合器传动连杆	Clutch Driving Rod	1
13	3201356	连杆球套	Ball	1
14	120001	上盖螺钉	Screw(M4x14)	2
15	3201363	上轴手轮	Handwheel	1
16	160007	手轮螺钉	Screw(M6x6)	2
17	3201359	离合器曲柄销	Clutch Lever Pin	1
18	3201357	曲柄指针	Pointer	1
19	3201355	连杆球套滚针轴承	Roller Bearing	1
20	3201354	轴承内套	Bushing	1
21	000428	曲柄销垫圈	Waher	1
22	100003	曲柄销螺母	Nut	1







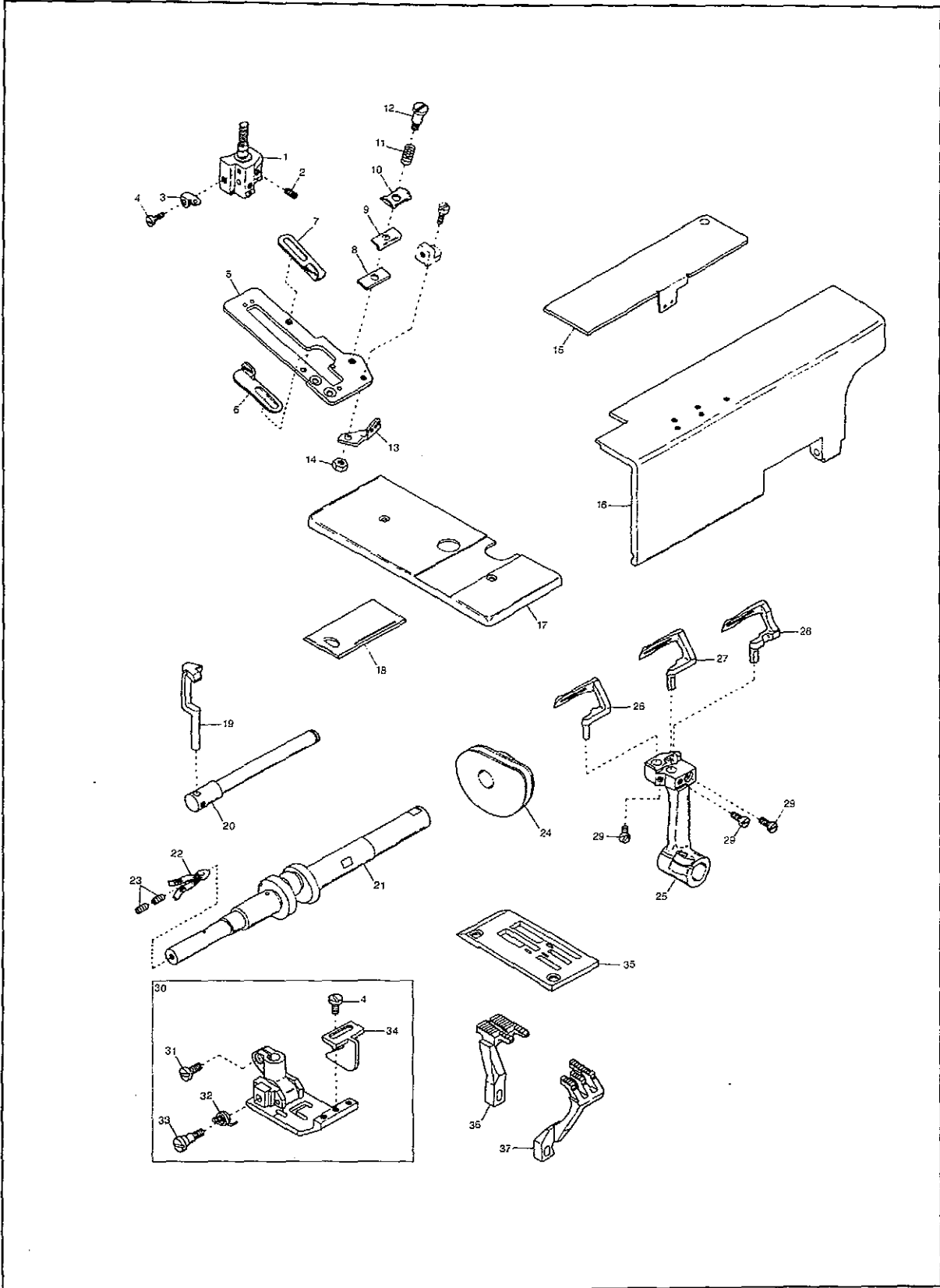
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	0093528	面线过线管夹	Thread Eyelet Pipe Stay	1
2	0021735	面线过线管	Thread Eyelet Pipe(Long)	1
3	3200047	右绷线过线板	Top Cover Thread Eyelet (Righth)	1
4	110009	过线板螺钉	Screw(M4x8)	2
5	000538	过线板螺钉垫圈	Washer	1
6	0095916	弯针后过线板	Looper Thread Eyelet	1
7	110013	弯针后过线板螺钉	Screw(M4x8)	1
8	3200048	左绷线过线板	Top Cover Thread Eyelet (Left)	1
9	3200049	绷线挑线杆	Tap Cover Thread Take-up	1
10	3201156	弯针中过线板	Looper Thread Eyelet (Right)	1
11	3201157	弯针前过线板	Looper Thread Eyelet(Left)	1
12	3201163	夹线底板	Tension Post Support	1
13	0090807	单线过线板	Thread Lead-in Guid	3
14	0090856	双线过线板	Tension Disc Eyelet	1
15	0090857	底线双线过线板	Looper Thread Tension Disc Eyelet	3
16	3201162	松线板	Tension Post Support	1
17	0090812	松线板套管	Tension Post Ferrule	3
18	009835	夹线螺钉	Tension Post	3
19	0031111	夹线盘	Tension Disc	6
20	000177	夹线垫板	Felt	3
21	0090071	夹线簧座	Thread Tension Spring Retainer	3
22	0090814	面线夹线簧	Needle Thread Tension Spring	1
23	0093863	夹线螺母	Thread Tension Spring Cap	3
24	0090847	弯针夹线簧	Looper Thread Tension Spring	2
25	0093865	夹线定位螺母	Thread Tension Spring Cover	1



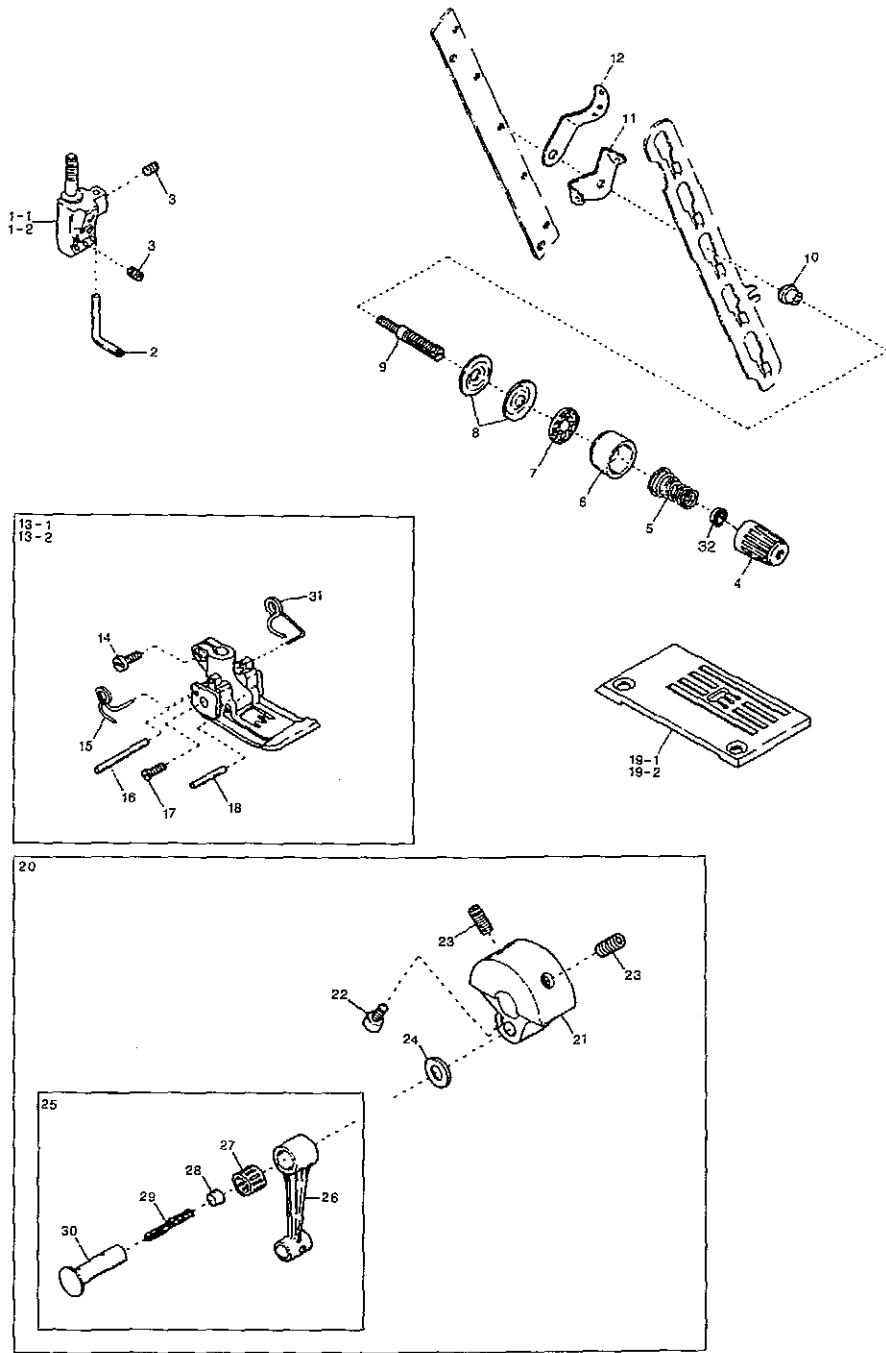
## ZJ2510 专用零部件(2)

## SUBMOLDE EXCLUSIVE PARTS(2)

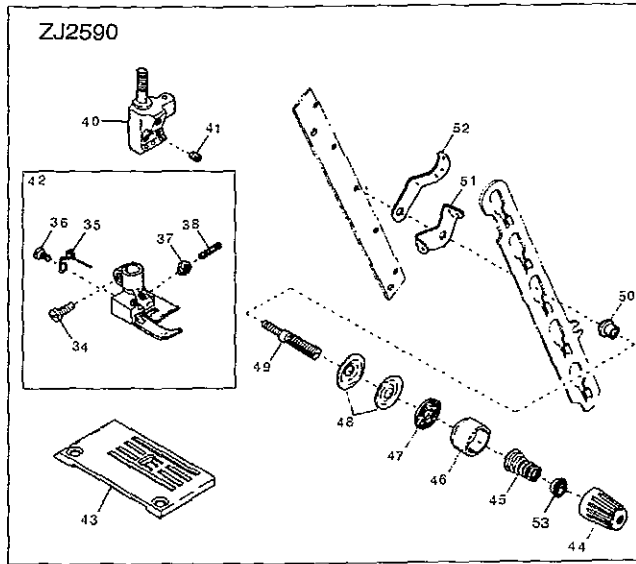
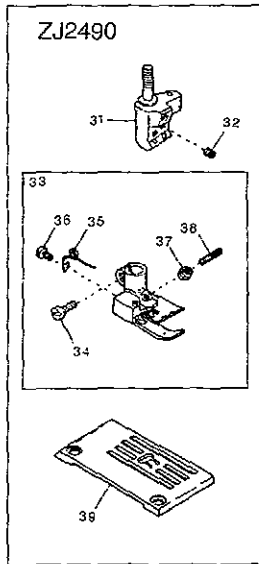
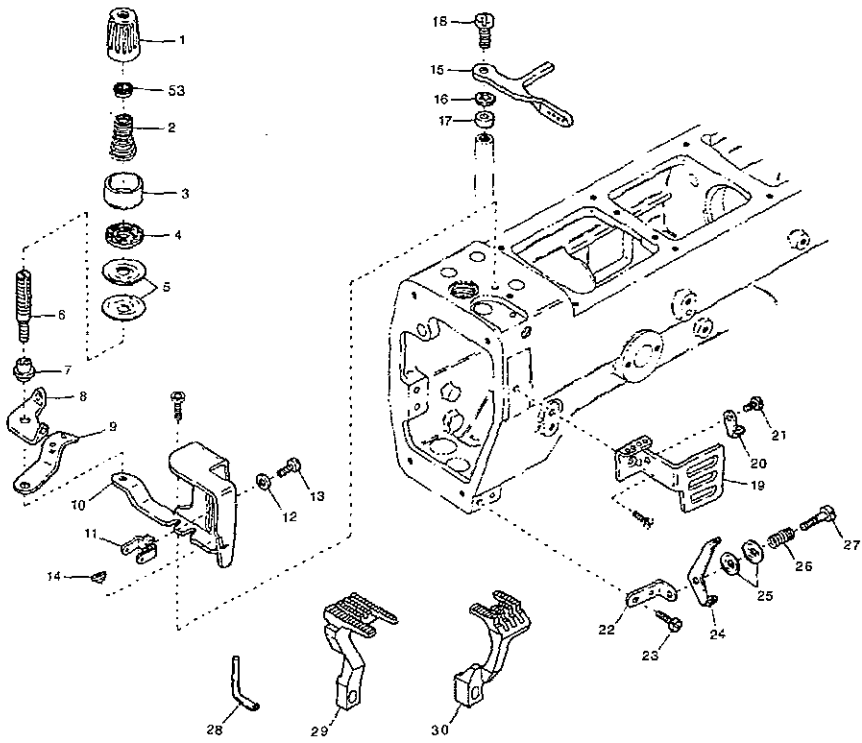
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3201169	绷针勒线板支架座	Thread Guide Holder Block	1
2	120009	支座螺钉	Screw(M4x12)	2
3	3201168	绷针摆动曲柄	Spreader Holder	1
4	110031	曲柄夹紧螺钉	Screw(M4x12)	2
5	3209301	绷针	Spreader	1
6	3201178	绷线导线杆支架组件	Top Cover Thread Guide Holder, C. Set	1
7	3201171	导线杆连杆	Link	1
8	310056	油线	Oil Wick	2
9	3201174	导线杆连杆销	Link Pin	1
10	3201172	导线杆曲柄轴	Thread Guide Lever	1
11	3201170	绷线导线杆支架座	Top Cover Thread Guide Holder	1
12	110035	支架螺钉	Screw(M4x10)	2
13	3201173	曲柄轴垫圈	Collar( $\phi 5 \times \phi 10 \times 5 \text{mm}$ )	1
14	3201175	绷线导线杆	Top Cover Thread Guide	1
15	160001	连杆销紧定螺钉	Screw(M4x4)	1
16	160000	导线杆螺钉	Screw(M3x3)	3



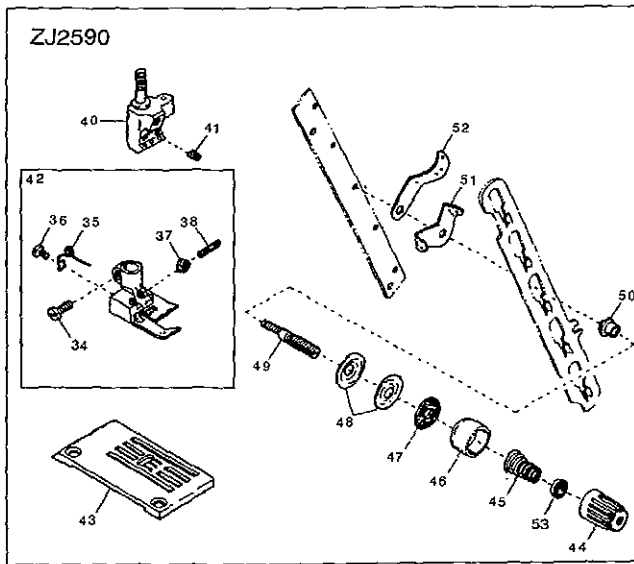
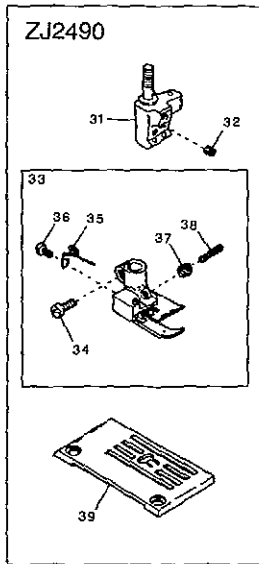
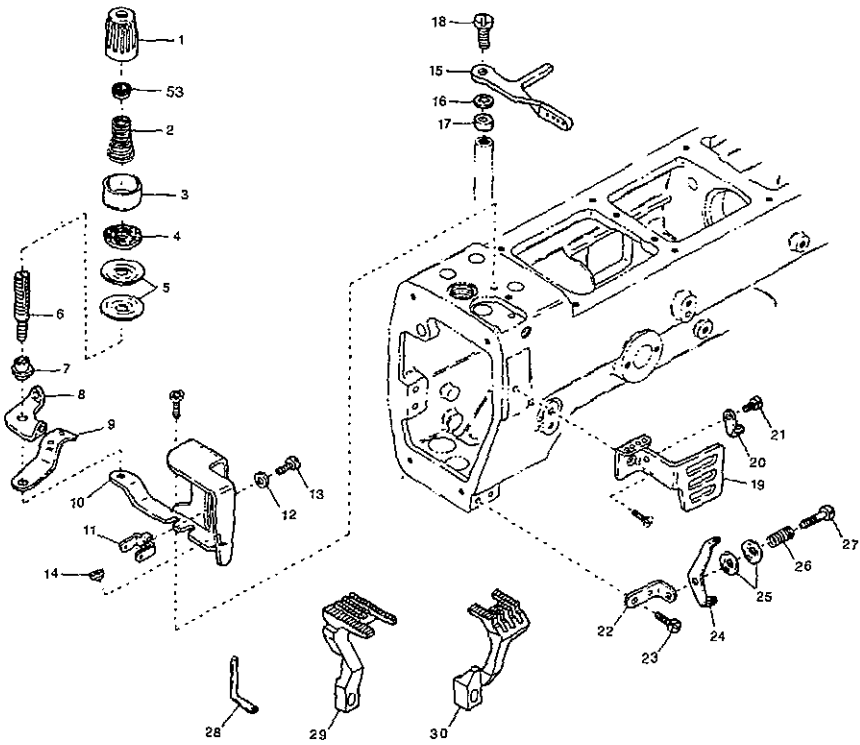
序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3209112	针夹	Needle Clamp(88)	1
2	001892	机针螺钉	Screw(SM1/8"x44x2.9)	3
3	3201164	针夹单眼过线板	Needle Clamp Eyelet	1
4	001230	过线板螺钉	Screw(SM3/32"x56x3.8)	3
5	3201152	挑线凸轮架	Supporting Plate	1
6	0095921	挑线凸轮架左过线环	Thread Take-up Eyelet(Left)	1
7	0095922	挑线凸轮架右过线环	Thread Take-up Eyelet(Right)	1
8	0095909	挑线凸轮夹线器底板	Supplementary Tension Holder	1
9	0036175	挑线凸轮夹线器垫板	Supplementary Tension Plate	1
10	0032425	挑线凸轮夹线器压板	Supplementary Tension Disc	1
11	0090846	夹线器压簧	Looper Thread Retainer Spring	1
12	270012	夹线器压簧螺钉	Screw(SM1/8"x44x5)	1
13	3201153	夹线器过线板	Looper Thread Eyelet(Center)	1
14	000322	挡线板螺母	Nut	1
15	3200035	缝台摇板	Looper Thread Take-up Cover	1
16	3200034	底板前罩板	Front Cover	1
17	3201160	底板左上盖板	Cloth Plate(Small)	1
18	0095936	左上盖板推板	Slide Cover	1
19	3209201	弯针后保针架	Needle Guard	1
20	3201155	后保针架摆轴	Needle Guard Driving Shaft	1
21	3201166	主轴前节轴	Lower Crankshaft	1
22	310055	主轴前节油线	Oil Wick	1
23	160007	主轴前节油线塞螺钉	Screw(M6x6)	2
24	0094512	弯针挑线凸轮	Looper Thread Take-up	1
25	3201176	弯针曲柄	Looper Holder	1
26	0095932	左弯针	Looper (Left)	1
27	0095930	中弯针	Looper (Medium)	1
28	0095931	右弯针	Looper (Right)	1
29	110057	弯针支头螺钉	Screw(M4x7)	3
30	0096006	压脚组件	Presser Foot, Complete Set(88)	1
31	001186	压脚柄夹紧螺钉	Screw(SM9/64"x40x7.8)	1
32	0094839	压脚扭簧	Presser Foot Spring	1
33	006093	扭簧螺钉	Screw(SM5/32"x40x6.5)	1
34	0096005	压脚导布板	Fabric Guide	1
35	0096255	针板	Stitch Plate(88M)	1
36	3209060	送料牙	Main Feed Dog	1
37	3209032	差动牙	Differential Feed Dog	1



序号 No.	件号 Parts No.	名称	Description	数量 Number
1-1	0093357	针夹	Needle Clamp(56)	1
1-2	0093358	"	" (64)	1
2	3201232	绷针过线勾	Top Cover Thread Eyelet	1
3	001900	机针螺钉	Screw(SM1/8"x44x2.4)	4
4	0093863	夹线螺母	Thread Tension Spring Cap	1
5	0090814	面线夹线簧	Needle Thread Tension Spring	1
6	0090071	夹线簧座	Thread Tension Spring Retainer	1
7	000177	夹线垫板	Felt	1
8	0031111	夹线盘	Tension Disc	2
9	009835	夹线螺钉	Tension Post	1
10	0090812	松线板套管	Presser Post Ferrule	1
11	0090856	双线过线板	Tension Disc Eyelet	1
12	0090807	单线过线板	Thread Lead-in Guide	1
13-1	3107025	压脚组件	Presser Foot, Complet Set(56)	1
13-2	3107047	" "	" " (64)	1
14	001186	压脚柄夹紧螺钉	Screw(SM9/64"x40x7.8)	1
15	3107303	弹性板左扭簧	Presser Foot Spring(Left)	1
16	0063284	压脚柄限位销	Locking Pin	1
17	005122	压板螺钉	Screw(SM3/32"x56x5.5)	2
18	0063282	压脚柄销	Presser Foot Hinge Pin	1
19-1	0094801	针板	Stitch Plate(56M)	1
19-2	0094802	"	" " (64M)	1
20	3201230	针杆曲柄组件	Counterweight, Complete Set	1
21	3201231	针杆曲柄	Counterweight	1
22	120015	针杆连接销螺钉	Screw(M5x10)	1
23	260000	针杆曲柄螺钉	Screw(SM5/16"x24x15.9)	2
24	0093214	滚针轴承垫圈	Connecting Rod Ring	1
25	3200114	针杆连杆组件	Connecting Rod, Complete Set	1
26	3200112	针杆连杆	Connecting Rod	1
27	0093212	针杆连杆滚针轴承	Roller Bearing	1
28	330000	油线塞	Seal Plug	1
29	000309	针杆连接销油线	Oil Wick	1
30	3200113	针杆连接销	Connecting Rod Pin	1
31	3107304	弹性板右扭簧	Presser Foot Spring (Right)	1
32	0093865	夹线定位螺母	Thread Tension Spring Cover	1

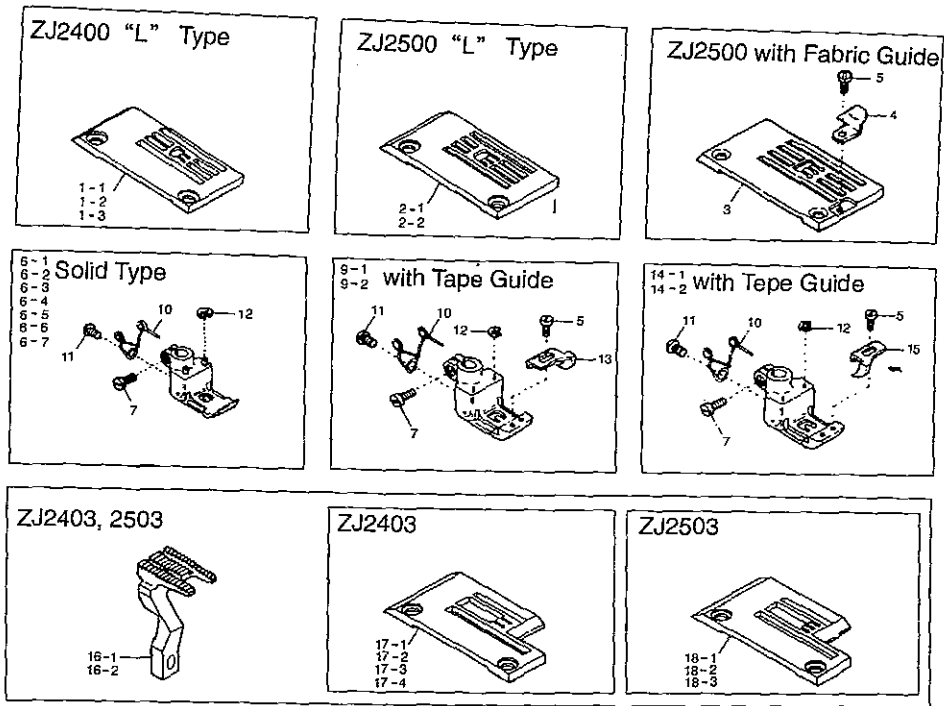


序号 No.	件号 Parts No.	名称	Description	数量 Number
1	0093863	夹线螺母	Thread Tension Spring Cap	1
2	0090814	面线夹线簧	Needle Thread Tension Spring	1
3	0090071	夹线簧座	Thread Tension Spring Retainer	1
4	000177	夹线垫板	Felt	1
5	0031111	夹线盘	Tension Disc	2
6	009835	夹线螺钉	Tension Post	1
7	0090812	松线板套管	Tension Post Ferrule	1
8	0090856	上双线过线板	Tension Disc Eyelet	1
9	0090807	单线过线板	Thread Lead-in Guide	1
10	3201481	针杆护罩	Needle Bar Guard	1
11	3202021	上过线板	Top Cover Thread Eyelet(Upper)	1
12	000531	上过线板螺钉垫	Washer	1
13	110033	上过线板螺钉	Screw(M3x6)	1
14	3120128	过线套	Thread Guide Eyelet	1
15	3201483	针杆挑线杆	Needle Bar Thread Eyelet	1
16	000548	挑线杆垫圈	Washer	1
17	000515	挑线杆垫套	Spacer	1
18	001923	挑线杆螺钉	Screw(SM9/64"x40x14)	1
19	3201488	面线过线板	Needle Thread Take-up Guard	1
20	3200042	下过线板	Looper Thread Eyelet	1
21	110008	下过线板螺钉	Screw(M4x5)	1
22	3201484	绷线过线板支架	Thread Eyelet Support	1
23	110009	支架螺钉	Screw(M4x8)	1
24	0093535	绷线过线板	Top Cover Thread Eyelet (Upper)	1
25	0037108	绷线夹线盘	Supplementary Tension Disc	2
26	0032426	绷线夹线盘压簧	Tension Spring	1
27	270014	过线板螺钉	Screw(SM1/8"x44x2.6)	1
28	0093365	绷线过线勾	Top Cover Thread Eyelet (Lower)	1
29	3209037	送料牙	Main Feed Dog	1
30	3209036	差动牙	Differential Feed Dog	1
31	0093352	针夹	Needle Clamp(40)	1
32	001900	机针螺钉	Screw(SM1/8"x44x2.4)	2
33	0093292	压脚组件	Presser Foot, Complete Set(40)	1
34	001186	压脚柄螺钉	Screw(SM9/64"x40x7.8)	1
35	0091725	压脚扭簧	Presser Foot Spring	2
36	005133	扭簧螺钉	Screw(SM1/8"x44x4.5)	1
37	000220	锁紧螺母	Lock Nut	1
38	003300	调节螺钉	Adjusting Screw(SM1/8"x44x15)	1
39	0093287	针板	Stitch Plate(40M)	1
40	0093357	针夹	Needle Clamp(56)	1
41	001900	机针螺钉	Screw(SM1/8"x44x2.4)	3
42	0095035	压脚组件	Presser Foot, Complete Set(56)	1
43	0093289	针板	Stitch Plate(56M)	1
44	0093863	夹线螺母	Thread Tension Spring Cap	2





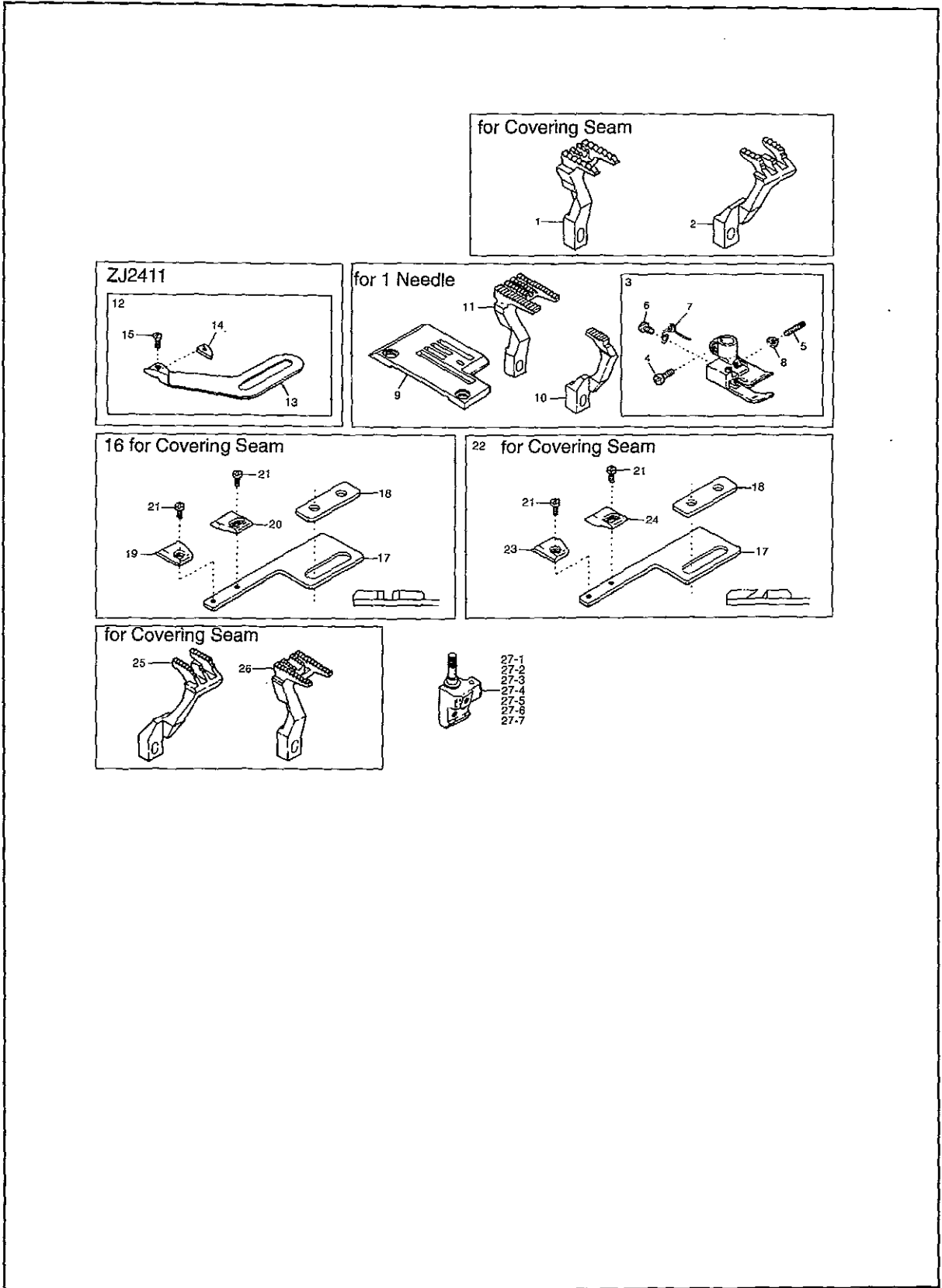
特制零部件(1)



## 特制零部件(1)

## EXTRA PARTS(1)

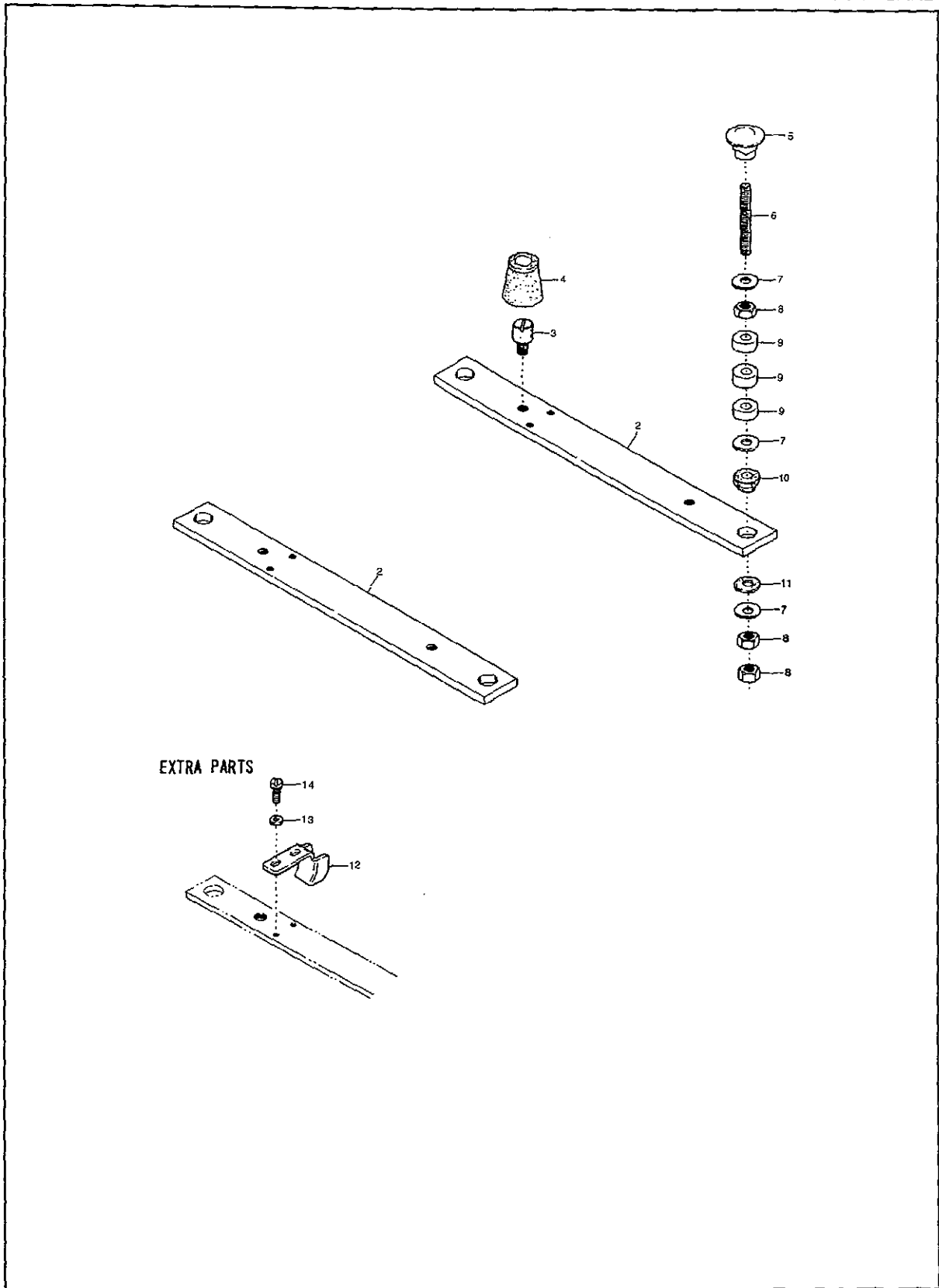
序号 No.	件号 Parts No.	名称	Description	数量 Number
1-1	0095409	针板	Stitch Plate(32L)	1
1-2	0095491	"	" " (40L)	1
1-3	0095492	"	" " (48L)	1
2-1	0095493	针板	Stitch Plate(56L)	1
2-2	0095494	"	" " (64L)	1
3	3208045	针板	Stitch Plate(56)	1
4	0094615	导布板	Fabric Guide	1
5	001228	导布板螺钉	Screw(SM3/32" x56x3.2)	1
6-1	0095580	压脚组件 (双针用)	Presser Foot, C.Set(32) (2 Needle)	1
6-2	0095581	" "	" " (40) ( " )	1
6-3	0095582	" "	" " (48) ( " )	1
6-4	0095584	" "	" " (64) ( " )	1
6-5	0095586	" (三针用)	" " (48) (3 Needle)	1
6-6	0095587	" "	" " (56) ( " )	1
6-7	0095588	" "	" " (64) ( " )	1
7	001186	压脚柄夹紧螺钉	Screw(SM9/64" x40x7.8)	1
8				
9-1	3007029	压脚组件	Presser Foot, C.Set(40)(ZJ2400)	1
9-2	3007030	" "	" " (56)(ZJ2500)	2
10	0095641	压脚扭簧	Presser Foot Spring	1
11	005133	扭簧螺钉	Screw(SM1/8" x44x4.5)	1
12	0095642	压脚开口挡圈	Retaining Ring	1
13	3000009	压脚导布板	Tape Guide	1
14-1	0095730	压脚组件	Presser Foot, C.Set(40)(ZJ2400)	1
14-2	0095731	" "	" " (56)(ZJ2500)	1
15	0095728	压脚导布板	Tape Guide	1
16-1	3209004	送科牙	Main Feed Dog(32, 40, 48, 56)	1
16-2	3209006	"	" " (64)	1
17-1	0094281	针板	Stitch Plate(32M)	1
17-2	0094282	"	" " (40M)	1
17-3	0094283	"	" " (48M)	1
17-4	0094285	"	" " (64M)	1
18-1	3208025	针板	Stitch Plate(48M)	1
18-2	0094921	"	" " (56M)	1
18-3	0094922	"	" " (64M)	1



## 特制零部件(2)

## EXTRA PARTS(2)

序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3209040	送料牙	Main Feed Dog(P=2.5mm)	1
2	3209041	差动牙	Differential Feed Dog (P=2.5mm)	1
3	0093982	压脚组件	Presser Foot, C. Set	1
4	001186	底脚柄夹紧螺钉	Screw(SM9/64"x40x7.8)	1
5	003300	调节螺钉	Adjusting Screw(SM1/8"x44x15)	1
6	006010	扭簧螺钉	Screw(SM1/8"x44x15)	1
7	0091725	压脚扭簧	Presser Foot Spring	1
8	000220	锁紧螺母	Lock Nut	1
9	0093981	针板(单针绷缝用)	Sitch Plate(Single Needle)	1
10	3209007	差动牙	Differential Feed Dog	1
11	3209016	送料牙	Main Feed Dog	1
12	0095365	挡线板组件	Folder(Left), C. Set	1
13	0095366	挡线板	Folder(Left)	1
14	0095367	小挡线板	Folder Chip	1
15	004182	小挡线板螺钉	Screw(SM3/32"x56x2.5)	1
16	3201118	导布板组件	Fabric Guide, C. Set(Covering Seam)	1
17	3201117	导布板垫板	Fabric Guide Support	1
18	3201120	导布板压板	Fabric Guide Fixing Plate	1
19	32101224	导布板	Fabric Guide(Left)	1
20	3101223	右导布板	Fabric Guide(Right)	1
21	110054	导布板螺钉	Screw(M3x3.5)	2
22	3201119	导布板组件	Fabric Guide, C. Set(Covering Seam)	1
23	3101229	左导布板	Fabric Guide(Left)	1
24	3101228	右导布板	Fabric Guide(Rogjt)	1
25	3209024	差动牙	Differential Feed Dog	1
26	3209023	送料牙	Main Feed Dog	1
27-1	0093351	针夹(双针绷缝用)	Needle Clamp(32)(2 Needle)	1
27-2	0093352	针夹( " " )	" " (40)(" )	1
27-3	0093353	针夹( " " )	" " (48)(" )	1
27-4	3009101	针夹( " " )	" " (56)(" )	1
27-5	0093355	针夹( " " )	" " (64)(" )	1
27-6	0093357	针夹(三针绷缝用)	" " (56)(3 Needle)	1
27-7	0090058	针夹( " " )	" " (64)(" )	1



支承板

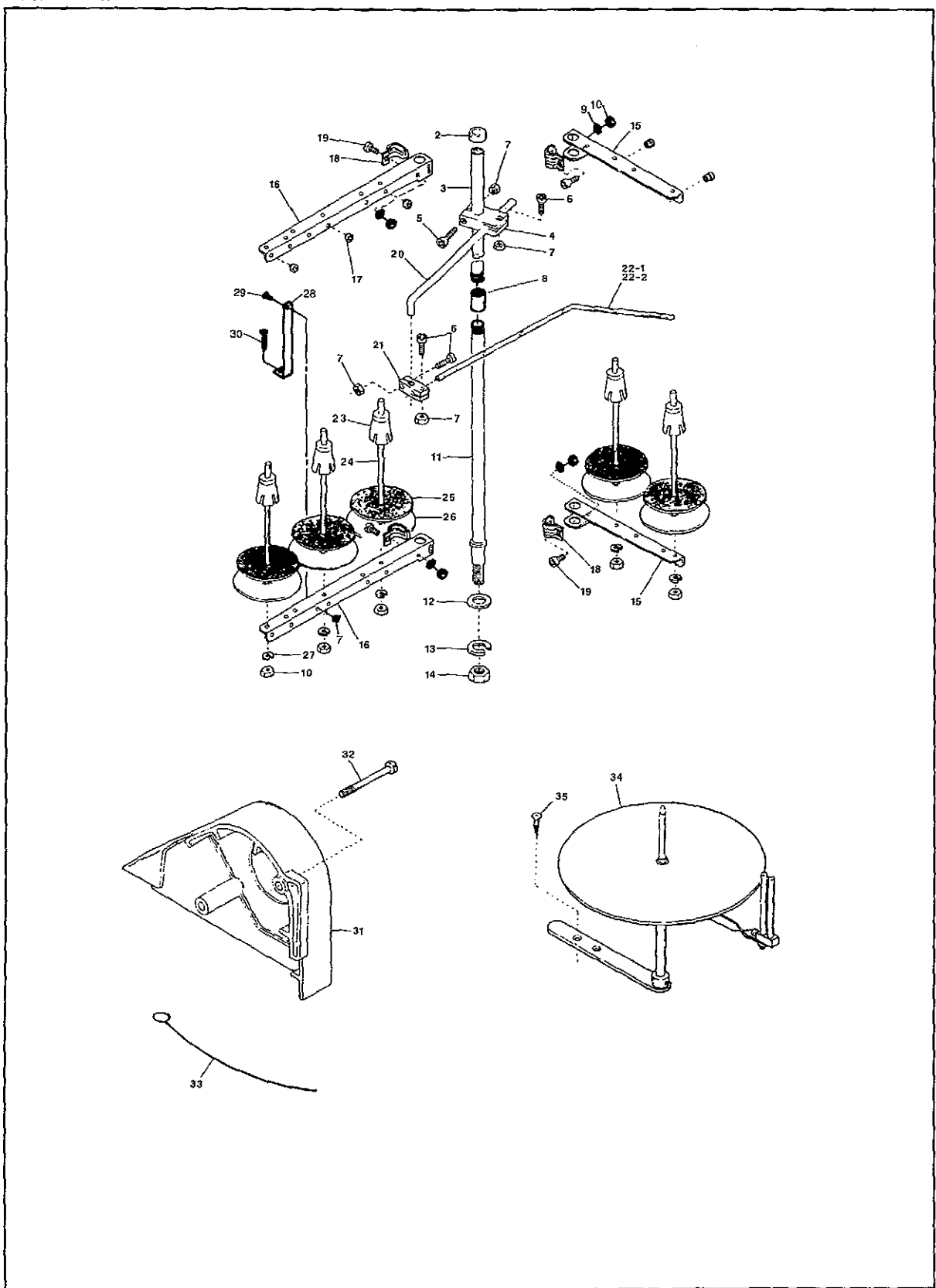
SUPPORTING BOARD

序号 No.	件号 Parts No.	名称	Description	数量 Number
1	3200240	支承板组件	Supporting Board, C. Set	1
2	3200241	支承板	Supporting Board	2
3	180020	调整螺钉	Setting Screw(M6x15)	4
4	0093035	机头橡胶垫	Oil Reservoir Rubber Cushion	4
5	000070	悬挂螺母	Hanging Nut	4
6	009861	悬挂螺栓	Hanging Bolt(M8x95)	4
7	000162	悬挂螺栓垫片	Washer	12
8	000016	螺母	Nut	12
9	2101451	垫块(参考下表)	Spacer(See the table below)	12
10	0020064	支承柱橡皮垫	Supporting Board Rubber Cushion	4
11	0063010	支承板下橡皮垫	Supporting Board Rubber Cushion(Lower)	4
12	3200242	链子滑槽皮	Chain Guide	1
13	000541	垫圈	Washer	2
14	110009	滑槽螺钉	Screw(M4x8)	2

注：件号 2101451 零件使用数量

Note: Number of Spacer(2101451) to be used.

台板厚度 Thickness of Table	垫块数量 Number of Spacer
40mm	3pcs. x5=15
45mm	2pcs. x5=10
50mm	1pc. x5=5

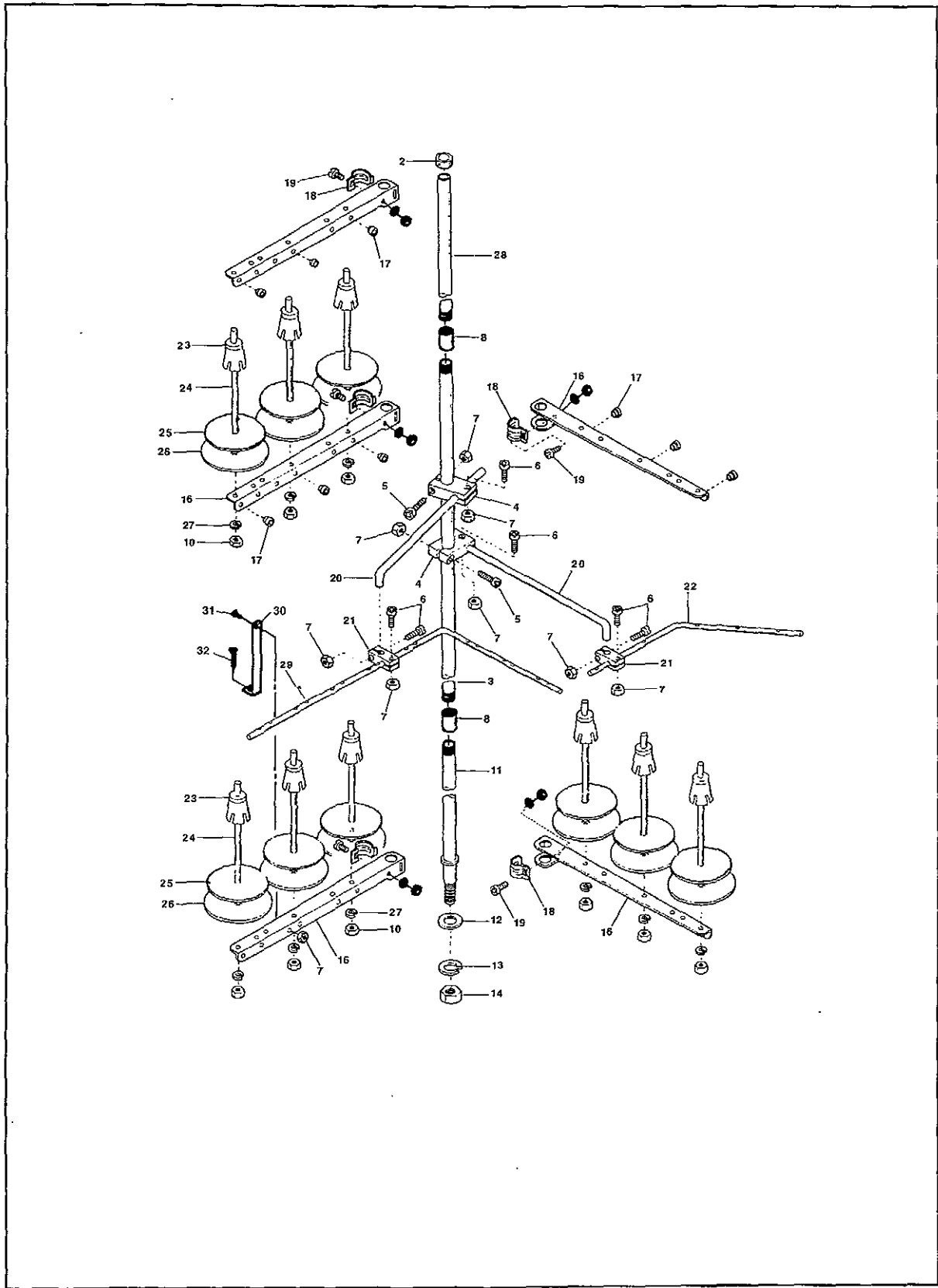


线架和支承板

THREAD STAND & SUPPORTING BOARD

序号 No.	件号 Parts No.	名称	Description	数量 Number
1-1	9620695	线架组件(5线用)	Thread Stand, Complete Set(5 Spools Type)	1
1-2	9620696	" (6")	" " (6 " " )	1
2	9620631	橡皮帽	Column Cap	1
3	9620670	上支承柱	Column Pipe(Upper)	1
4	9620689	导线架接头	Thread Guide Holder (Large)	1
5	911002	导线架接头长螺钉	Screw(M4x20)	1
6	911001	导线架接头短螺钉	Screw(M4x12)	3
7	910001	导线架接头螺母	Nut	4
8	9620673	接头	Column Pipe Connector	1
9	911006	固定卡垫圈	Washer	8
10	910000	固定卡螺母	Nut	8
11	9620675	下支承柱	Column Pipe(Lower)	1
12	930052	垫圈	Washer	1
13	930053	弹性垫圈	Spring Washer	1
14	910003	螺母	Nut(M16)	1
15	9620702	短托架(2托盘用)	Thread Hanger (2 Spools Type)	2
16	9620703	托架(3托盘用)	" " (3 " " )	2(4)
17	9620700	过线套	Thread Eyelet	5(6)
18	9620688	固定卡	Thread Hanger Holder	4
19	911060	固定卡螺钉	Screw(M6x15)	4
20	9620691	导线架	Thread Guide Arm	1
21	9620690	导线杆接头	Thread Guide Holder(Small)	1
22-1	9620665	导线杆(5线用)	Thread Guide(5 Spools Type)	1
22-2	9620666	" (6")	" " (6 " " )	1
23	9620678	防摆座	Spool Cushion	5(6)
24	9620679	摇线钉	Spool Pin	5(6)
25	9620680	缓冲垫	Spool Mat	5(6)
26	9620681	接线托盘	Spool Seat Disc	5(6)
27	930055	接线钉弹性垫圈	Spring Washer	5(6)
28	9620704	支板	Tolder Suppor	1
29	911003	支板螺钉	Screw (M4x8)	1
30	350009	木螺钉	Wood Screw(4x25)	1
31	0063031	皮带罩	Belt Cover	1
32	110028	皮带罩螺钉	Screw(M6x46)	2
33	3000010	穿线勾	Looper Threading Bar	2
34	3201316	针织带支架	Knitted Tape Stand(See the below)	1
35	350008	支架木螺钉	Wood Screw(5x25)	2

序号 No.	件号 Parts NO.	适用机型 Applicable Models
34	3201316	ZJ2403, 2403-11, 2403-21, 2404 ZJ2503, 2503-11, 2503-21, 2504-11



序号 No.	件号 Parts No.	名称	Description	数量 Number
1	9620699	线架组件(9线用)	Thread Stand, Complete Set(9 Spools Type)	1
2	9620631	橡皮帽	Column Cap	1
3	9620670	中支承柱	Column Pipe(Upper)	1
4	9620689	导线架接头	Thread Guide Holder (Large)	2
5	911002	导线架接头长螺钉	Screw(M4x20)	2
6	911001	导线架接头短螺钉	Screw(M4x12)	6
7	910001	导线架接头螺母	Nut	8
8	9620673	接头	Column Pipe Connector	2
9	911006	固定卡垫圈	Washer	4
10	910000	固定卡螺母	Nut	13
11	9620675	下支承柱	Column Pipe(Lower)	1
12	930052	垫圈	Washer	1
13	930053	弹性垫圈	Spring Washer	1
14	910003	螺母	Nut(M16)	1
15				
16	9620703	托架(3托盘用)	Thread Hanger(3 Spools Type)	5
17	9620700	过线套	Thread Eyelet	9
18	9620688	固定卡	Thread Hanger Holder	5
19	911060	固定卡螺钉	Screw(M6x15)	5
20	9620691	导线架	Thread Guide Arm	2
21	9620690	导线架接头	Thread Guide Holder(Small)	2
22	9620665	短导线杆(5线用)	Thread Guide (5 Spools Type)	1
23	9620678	防摆座	Spool Cushion	9
24	9620679	插线钉	Spool Pin	9
25	9620680	缓冲垫	Spool Mat	9
26	9620681	插线托盘	Spool Seat Disc	9
27	930055	插线钉弹性垫圈	Spring Washer	9
28	9620660	上支承柱	Column Pipe( Short) (206mm)	1
29	9620668	长导线杆(8线用)	Thread Guide (8 Spools Type)	1
30	9620704	支板	Foleler Support	1
31	911003	支板螺钉	Screw(M4x8)	1
32	350009	木螺钉	Wood Screw(4x25)	1

## 警告标贴

## WARNING LABEL

标 贴 Label	件 号 Parts No.	名 称 Description
	390140	操作指示牌 CAUTION IN OPERATING
	390145	零线接地接头牌 Be sure to connect earth line
	390146	零线接地接头牌 ROTATING-DIRECTION SYMBOL. CHECK CORRECT ROTATING DIREC- TION
	390147	安全指示牌 EYE GUARD: TAKE CARE NOT CAUSE INJURY TO EYE BELT COVER: DO NOT INSERT FINGERS

主要部件  
LIST OF MAIN SPARE PARTS

ZJ2400 系列主要零部件(ZJ2400 CLASS LIST OF MAIN SPARE PARTS)(1)

Main Parts Models	Needle Clamp	Presser Foot, C. Set	Stitch Plate	Differen- tial Feed Dog	Main Feed Dog	Front Cover	Cloth Plate (Large)	Cloth Plate (Small)	Thread Take-up Cover	Stitch Plate Support	Looper
	针夹	压脚	针板	差动牙	送料牙	底板前罩板	缝台	底板左上盖板	缝台摇板	针板架	弯针
ZJ2400 - 132M	3209100	0063318	0093170	3209001	3209000	3200015	3200017	3200014	3200018	3200032	3209311
140M	3209101	0063319	0093171	3209001	3209000	3200015	3201017	3200014	3200018	3200032	3209311
148M	3209102	0063320	0093172	3209001	3209000	3200015	3200017	3200014	3200018	3200032	3209311
164M	3209104	0063322	0093174	3209003	3209002	3200034	3200017	3200014	3200035	3200032	3209311
ZJ2402 - 048	3209109	3207036	3208070	3209044	3209043	3200015	3200017	3200014	3200018	3200032	(注 1) Note 1
064	3209110	3207008	3208022	3209026	3209025	3200034	3200017	3200014	3200035	3200032	(注 1) Note 1
080	3209111	3207010	3208021	3209028	3209027	3200034	3200017	3200014	3200035	3200032	(注 1) Note 1
095	3209120	3207165	3208068	3209028	3209027	3200034	3200017	3200014	3200035	3200032	(注 1) Note 1
ZJ2403 - 132M	3209100	3207150	0094210	3209005	3209014	3201000	3200017	3200014	3201001	3200032	3209311
132M-21	3209100	3207150	3208102	3209065	3209064	3201000	3200017	3200014	3201001	3200032	3209311
ZJ2403 - 140M	3209101	3207151	0094211	3209005	3209014	3201000	3200017	3200014	3201001	3200032	3209311
140M-11	3209101	3207151	0095234	3209009	3209008	3201000	3200017	3200014	3201001	3200032	3209311
140M-21	3209101	3207151	3208103	3209065	3209064	3201000	3200017	3200014	3201001	3200032	3209311
148M	3209102	3207152	0094212	3209005	3209014	3201000	3200017	3200014	3201001	3200032	3209311
148M-21	3209102	3207152	3208104	3209065	3209064	3201000	3200017	3200014	3201001	3200032	3209311
164M	3209104	3207154	0094214	3209007	3209016	3201000	3200017	3200014	3201001	3200032	3209311
ZJ2404 - 132M	3209100	3207150	0094210	3209005	3209014	3201000	3200017	3200014	3201001	3200032	3209311
140M	3209101	3207151	0094211	3209005	3209014	3201000	3200017	3200014	3201001	3200032	3209311
148M	3209102	3207152	0094212	3209005	3209014	3201000	3200017	3200014	3201001	3200032	3209311
164M	3209104	3207154	0094214	3209007	3209016	3201000	3200017	3200014	3201001	3200032	3209311

(注 1):左弯针用 0095930,右弯针用 0095931。Note:Use 0095930 for Looper(Left) and 0095931 for Looper(Right).

ZJ2400 系列主要零部件(ZJ2400 CLASS LIST OF MAIN SPARE PARTS)(2)

Main Parts Models	Needle Clamp	Presser Foot, C. Set	Stitch Plate	Differen- tial Feed Dog	Main Feed Dog	Front Cover	Cloth Plate (Large)	Cloth Plate (Small)	Thread Take-up Cover	Stitch Plate Support	Looper
	针夹	压脚	针板	差动牙	送料牙	底板前罩板	缝台	底板左上盖板	缝台摇板	针板架	弯针
ZJ2408	3209107	0094500	0094507	3209030	3209029	3200015	3200017	3209014	3200018	3200032	3209311
ZJ2490 - 140M	0093352	0093292	0093287	3209036	3209037	3200015	3200017	3200014	3200018	3200032	3209311
ZJ2500 - 148M	3209106	3107050	0094800	3209001	3209000	3200015	3200017	3200014	3200018	3200032	3209311
156M	3209107	0064041	0094801	3209001	3209000	3200015	3200017	3200014	3200018	3200032	3209311
164M	3209108	0064042	0094802	3209003	3209002	3200034	3200017	3200014	3200035	3200032	3209311
ZJ2502 - 064	3209113	3207013	3208063	3209039	3209038	3200034	3201492	3200160	3200035	3200032	(注2) Note 2
ZJ2503 - 148M	3209106	3207155	3208026	3209005	3209014	3201000	3200017	3200014	3201001	3200032	3209311
148M-11	3209106	3207155	3208052	3209009	3209008	3201000	3200017	3200014	3201001	3200032	3209311
156M	3209107	3207156	0094901	3209005	3209014	3201000	3200017	3200014	3201001	3200032	3209311
ZJ2503 - 156M-11	3209107	3207156	0095085	3209009	3209008	3201000	3200017	3200014	3201001	3200032	3209311
156M-21	3209107	3207156	3208108	3209065	3209064	3201000	3200017	3200014	3201001	3200032	3209311
164M	3209108	3207157	0094902	3209007	3209016	3201000	3200017	3200014	3201001	3200032	3209311
164M-11	3209108	3207157	3008025	3209009	3209008	3201000	3200017	3200014	3201001	3200032	3209311
164M-21	3209108	3207157	3208109	3209065	3209064	3201000	3200017	3200014	3201001	3200032	3209311
ZJ2504 - 156M-11	3209107	3207156	0095085	3209009	3209008	3201000	3200017	3200014	3201001	3200032	3209311
ZJ2510 - 188M	3209112	0096006	0096255	3209032	3209060	3200034	3200017	3201160	3200035	3200032	(注3) Note 3
ZJ2530 - 156M	0093357	3107025	0094801	3209001	3209000	3200015	3200017	3200014	3200018	3200032	3209311
164M	0093358	3107047	0094802	3209003	3209002	3200034	3200017	3200014	3200035	3200032	3209311
ZJ2590 - 156M	0093357	0095035	0093289	3209036	3209037	3200015	3200017	3200014	3200018	3200032	3209311

(注2):左弯针用 3209314, 中弯针用 3209313, 右弯针用 0095931。Note 2:use 3209314 for looper(left),3209313 for looper(middle) and 0095931 for looper(Right)

(注3):左弯针用 0095932, 中弯针用 0095930, 右弯针用 0095931。Note 3:use 0095932 for looper(left),0095930 for looper(middle) and 0095931 for looper(Right)

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0095930	33	27		110013	23	17		120013	6	29	
0095931	16	23		110013	25	17		120013	9	15	
0095931	19	22		110013	31	7		120015	6	30	
0095931	33	28		110016	1	26		120015	7	17	
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0096006	33	30		110033	11	8		130003	2	10	
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100003	29	22		110038	27	41		140018	11	19	
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110002	8	46		110048	27	3		160000	1	17	
110002	28	19		110054	8	15		160000	5	26	
110004	6	39		110054	17	18		160000	27	26	
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110004	17	14		110057	10	36		160001	5	31	
110005	5	20		110057	16	21		160001	10	16	
110007	10	13		110057	19	23		160001	11	28	
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3100281	6	8		3107304	8	30		3200049	31	9	
3100283	6	10		3107304	14	35		3200050	4	13	
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3100601	20	28		3200024	2	15		3200077	5	27	
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3100610	22	20		3200032	2	36		3200085	5	34	
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