



**ZOJE**  
中捷

# 超高速包缝机

SUPER HIGH-SPEED OVERLOCK SEWING MACHINE

**使用说明书**

OPERATION MANUAL


**零件手册**

PARTS BOOK

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

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## 致使用者:

我们非常感谢您使用本公司出品的超高速直针锁边缝纫机(拷克车)。请详细阅读此说明书,将使您更了解本机器独特的性能及正确的使用方法,进而提高您缝制的效率及品质。首先请您注意:请先注入润滑油及确认马达的转向为顺时针方向,才可以开动本机器。

## TO THE OPERATORS

Thank you very much for using our Super High Speed, Straight Needle, Overlock/Safety Stitch Machine. Before operating this machine, please study this book thoroughly, understand the functions and features of the machine. Then it will help you to increase your sewing efficiency and quality.

ATTENTION: Because this is an super high speed machine. Do not run it before filling oil and/ making sure the correct turning direction of motor.

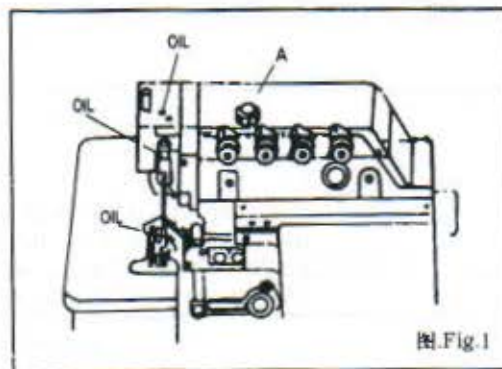
## 机器安装

- (1)依本机所附桌板截制图及零件组合图所列的配件,依序安装防震机座铅板半沉式时,机台针板面与桌板面的距离为100mm,全沉式为5mm。
- (2)马达启运踏板装于左边,抬压脚踏板则装于右边。
- (3)按零件图示装置废料槽及线架。
- (4)注意马达的转向为顺时针方向,皮带的松紧度以用手指向内压下缩10mm为宜,皮带轮与缝合转速请参照表(1)。但常用转速就放为第一档为宜。

## HOW TO INSTALL THE MACHINE

- (1)Install the machine according to the table cut-out diagram, Cushion Rubber and Rest Board as enclosed. In case of semi-submerged, the distance between Needle plate top surface and Table Top is about 100mm, and for fully-submerged is about 5mm.
  - (2)Setting the pedal of clutch motor to the left side and the pedal of presser foot lift at right side.
  - (3)Install the cloth waste chute, thread stand as parts list.
  - (4)Be sure the motor turning direction is clockwise. And the belt can be pressed inwards about 10mm.
- NOTE: The dimensions of motor pulley and sewing speed are shown in Table 1.

Machine speed (s.p.m)	Motor pulley diameter(mm)	
	60Hz	50Hz
5500	90	110
6000	95	115



## 新机器

新机器在最初启用四个星期内，请用低于最高速度20%的速度运转，然后换新润滑油即可运转到最高速度

## HOW TO OPERATE THE NEW MACHINE

Please run the new machine in the first four at 20% less speed than maximum. Then replace the new oil and thereafter the machine may be operated up to maximum speed.

## 润滑油

### (1) 润滑油的注入 图1

- 将螺丝A旋开，以包装箱内所附的超高速润滑油或选用MOBIL#10或AGIP等相当的机油加入，使油量指示杆位于油标上下之间即可，然后再锁紧螺丝A。
- 开箱新机器或久置未使用重新要用时，请在针棒、上勾针台等加油润滑。

### (2) 润滑油的更换 图2

- 将螺丝A放松旋开，使油完全排出后再锁紧。
- 为延长本机器的寿命，请于开始使用四个星期更换新油后约四个月更换一次。
- 本机器特别装有滤油器，约每使用一个月后卸下清洗，必要时更换新品。

### (3) 针的冷却油

使用油：硅油(SILICON OIL)

## LUBRICATION AND DRAINAGE

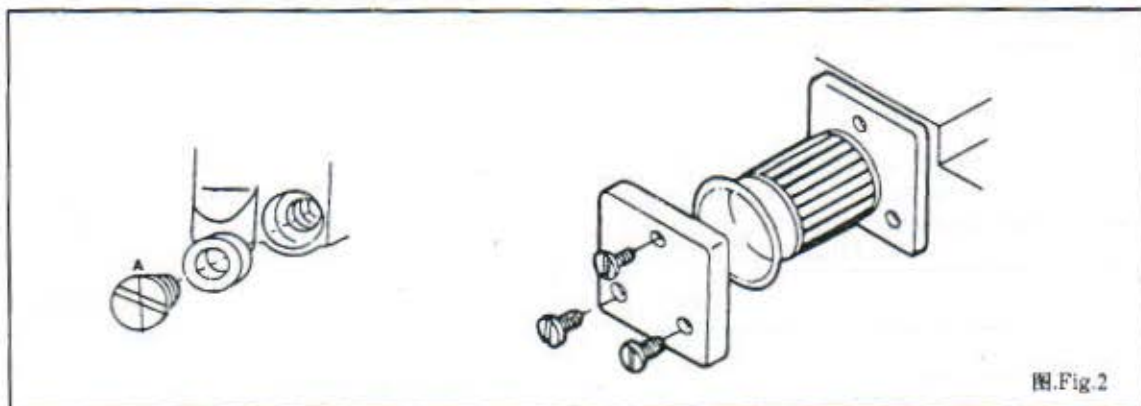
### (1) Lubrication Fig.1

- Remove Screw A and fill in enclosed ultra high speed lubricate oil (or similar to Mobil # 10, Esso #32) until the top of oil Level indicator between two lines of Oil Level Sight Window, Then replace Screw A.
- When the machine is operated for the first time it was idle for a long time, please be sure to oil the top of the needle holder, guide, upper looper guide etc. before operating the machine.

### (2) Drainage Fig.2

- Remove Screw A and drain out the oil then replace Screw A.
- For keeping the good lubrication and machine life, please replace the new oil when the new machine has been operating over four weeks. And after that, change oil every four months.
- This machine has been fixed with oil filler. Please clean it every month or replace a new one if necessary.

### (3) Needle Cooling Lubrication-Silicon oil.

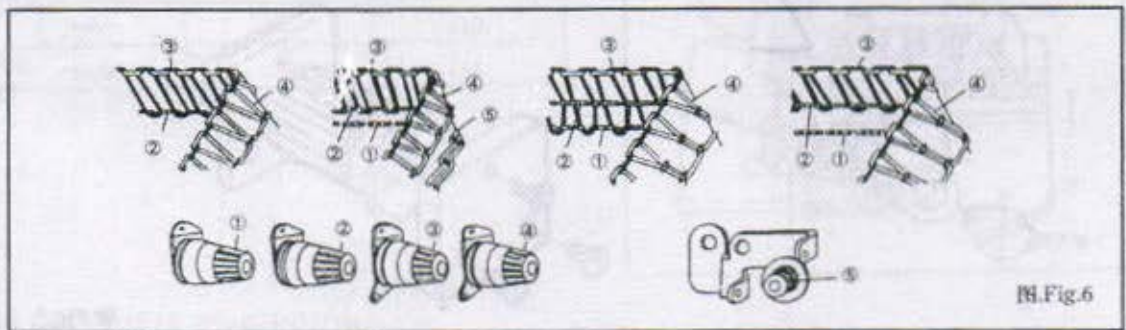
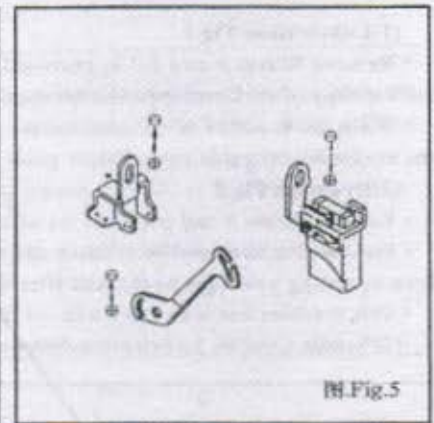
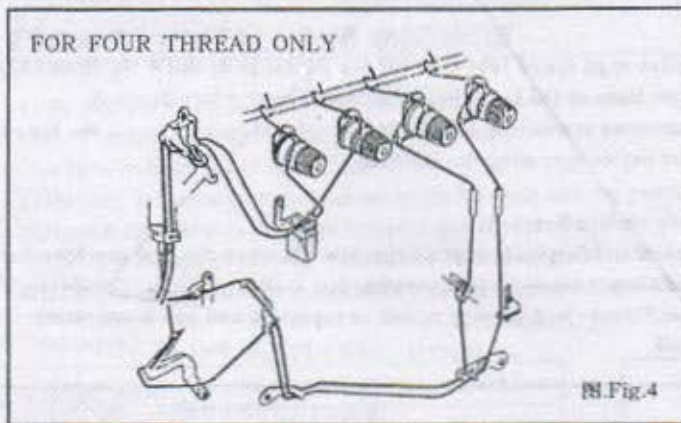
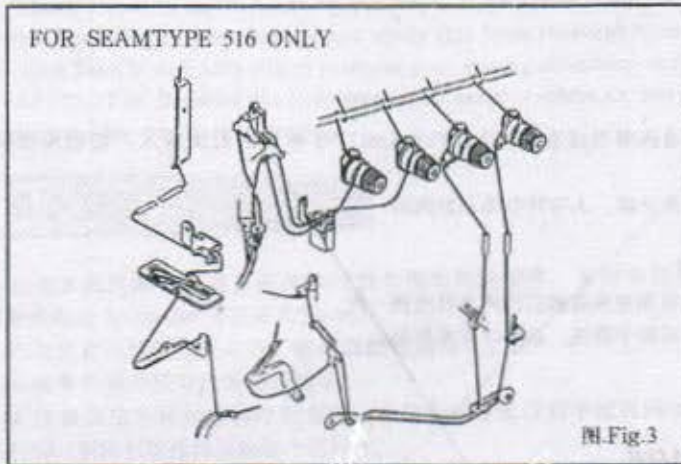


## 穿线方法 图3, 4

请确实按照图示各种不同缝合形式穿线, 错误的穿线将引起断线、跳针或车缝不平整等现象。

### **T**HREADING THE MACHINE Fig3,4

Refer to the sewing type you need for correct threading. Any incorrect threading may cause thread break, uneven stitches or skip stitches etc.



## 控线调整

控线强弱必须根据缝合材料种类、厚薄、线、针距及包边宽度等的不同而做不同的调整。

(1) 调整钮的控线关系 图5

- 第一调整钮控制双环针线或左边拷克针线。
- 第二调整钮控制包边针线。
- 第三调整钮控制上勾针线。
- 第四调整钮控制下勾针线。
- 第五调整钮控制双环勾针线。

(2) 针线控线关系 图6

- 在缝合方式504、512、514时，将①②移至最下端。缝合方式503及505时，将①②移至最上端。
- ⊕表示增加针线强度，⊖表示减少针线强度。

(3) 勾针控线关系 图7

- 在缝合方式为512、504当上勾针移至最左时，将①及②调整至实线位置。若缝合方式为503、505、514及上勾针移至最左时，将①及②调整至虚线位置。

• 估定线导板③如下：

- A点：尼龙伸缩线
- B点：拷下摆
- C点：缝合方式512

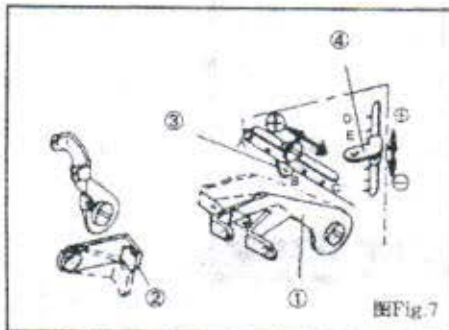
• 固定线导板④如下：

- D点：尼龙伸缩线
- E点：拷下摆

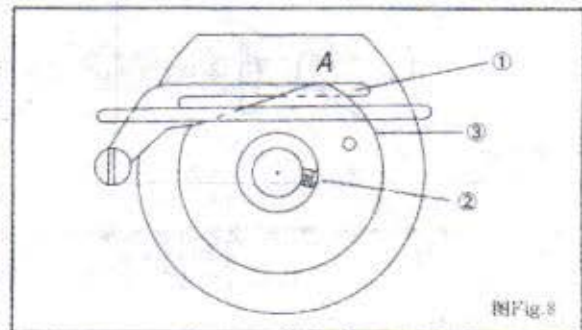
⊕方向为缝合线较多，反之较少。

(4) 环缝线凸轮控线关系 图8

- 正确的环线凸轮位置是当针提升至最高点时，A点恰好在勾针线导板①的表面，放松凸轮螺钉②轮动凸轮③向逆时针方向则勾针收线较快。



图Fig.7



图Fig.8

## THREAD TENSION

The thread tension be adjusted according to sewing fabric, thickness, sewing thread, seam width, stitch length etc. Therefore the pressure of the Tension Nuts or Thread Guides must be adjusted in each individual case.

(1) Tension Nuts Adjustment Fig. 5

- The tension Nut ① controls the double chain needle thread or left side overlock needle thread.
- The Tension Nut ③ controls the double chain looper thread.
- The Tension Nut ② controls the overlock needle thread.

## 针距调整 图9

- 通常按缝合布料，差动比等之不同而调整
- 持续压下按钮并转动皮带轮使钮卡住，再转动皮带轮至所需的针距后放开此按钮。

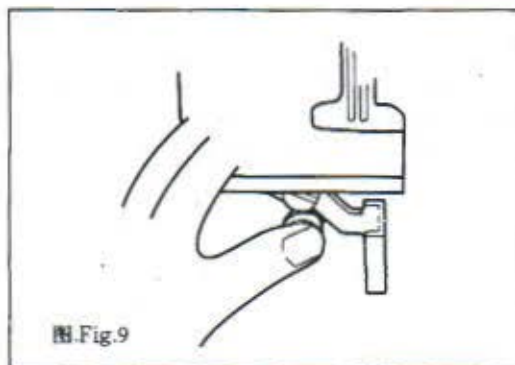
## STITCH LENGTH ADJUSTMENT Fig.9Tab2

The stitch length adjustment is made according to the sewing fabric, differential feed ratio etc.

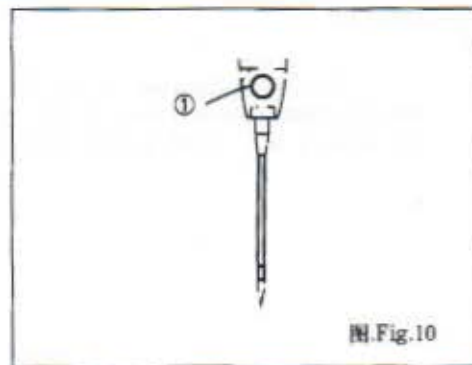
- Keep pushing the Push Button enter deep inside.
- Keep pressing the Push Button and match the desired stitch length which is shown on the pulley with the indicating point of Belt Cover.

Tab.2

Maxi diff ratio	Machine type	Pulley scale						
		1	2	3	4	5	6	7
1:2	Seaming	1	1.5	2	2.5	3	3.5	3.8
1:3	Shirring	0.7	1	1.4	1.7	2	2.3	2.5
1:1.3	Serging	1.6	2.3	3.1	3.9	4.7	5.4	5.9
1:4	Special	0.6	0.9	1.2	1.5	1.8	2.1	1



图Fig.9



图Fig.10

## 换针 图10

- 使用DC × 27或同规格的针
- 旋开螺丝①并取下针
- 将新针插至针孔最底端，并使针的长沟面向自己。
- 固定螺丝①。

## NEEDLE REPLACEMENT Fig.10

- Please use DC × 27 or equivalent needle size.
- Loosen Screw ① and remove the old needle.
- Insert the needle which long groove faces you and push it up deep into the needle hole until it stops and tighten Screw ①

## 差动比调整 (三)

若主送料具的运动程大于分送料具运动程时, 则布料车缝时伸张, 反之则收缩。

调整方法为放松螺丝①转动螺丝②顺时针方向时使布料伸张, 反之则收缩, 调整后再固定螺丝①。

注: 当调整杆③的表面固定在刻划2时差动比为1:1, 若将其固定在刻划2以上时, 可使布料伸张至1:0.7。

## DIFFERENTIAL FEED RATIO ADJUSTMENT (Fig.11 Tab.3)

The differential feed ratio is the ratio of movements between Main Feed Dog and Differential Feed Dog, when the movement of Main Feed Dog is bigger than Differential Feed Dog, the fabric be stretched in sewing. Otherwise the fabric be shrunk.

• Loosen Nut ① then turn Screw ② in clockwise for stretching the fabric, and in reverse direction for shrinking the fabric then tighten Nut ①.

NOTE: When the surface of adjusting Level ③ be set at the scale ② the differential feed ratio is 1:1, and if it be set over the scale its ratio can be adjustable up to 1:0.7.

Tab.3

Scale		1	2	3	4	5
Differ- ential	1:3	—	1:0.7	1:0.9	1:1.1	1:1.3
	1:2	1:0.7	1:1	1:1.4	1:1.7	1:2
Feed ratio	1:3	1:1	1:1.5	1:2	1:2.5	1:3
	1:4	1:1.1	1:1.6	1:2.3	1:2.8	1:3.3

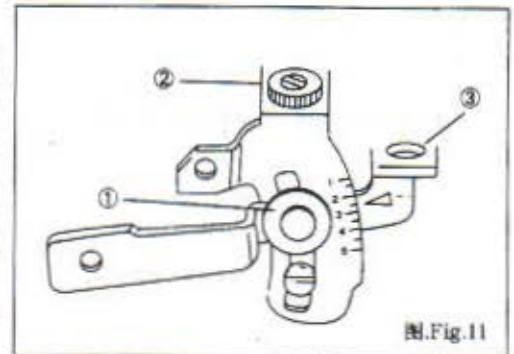


图.Fig.11

## 各缝纫元件的相互关系

### (1) 针于针板的关系 图12

当针上升至最高时, 针尖端(双针时以左针为准)于针板面的距离, 标准程机器为9.5-9.7mm(但高程机器为10.8-11.0mm), 双针时右针必须略比左针向前0.2-0.3mm, 但右针与板沟前端距离1.2mm。

放松针动连杆螺丝①使之能以手推动针座滑块, 转动皮带轮使针插在针孔槽中央, 必要时放松螺丝②以调整针座。

转动皮带轮使针到最高点后, 轻敲针座滑块至正确针高度后锁紧螺丝①。

### (2) 上勾针与针的关系 图13

当上勾针移至最左时, 勾针尖端与针中心线约4.5-5.0mm, 双针时其左边针中心线与勾针尖端约距5.5-6.0mm。

### (3) 下勾针与针的关系 图14, 图15

• 当下勾针移至最左时, 勾针尖与针中心线(双针时以左针为准)的距离A标准程机构: 3.2-3.4mm 高程机器: 3.0-3.2mm

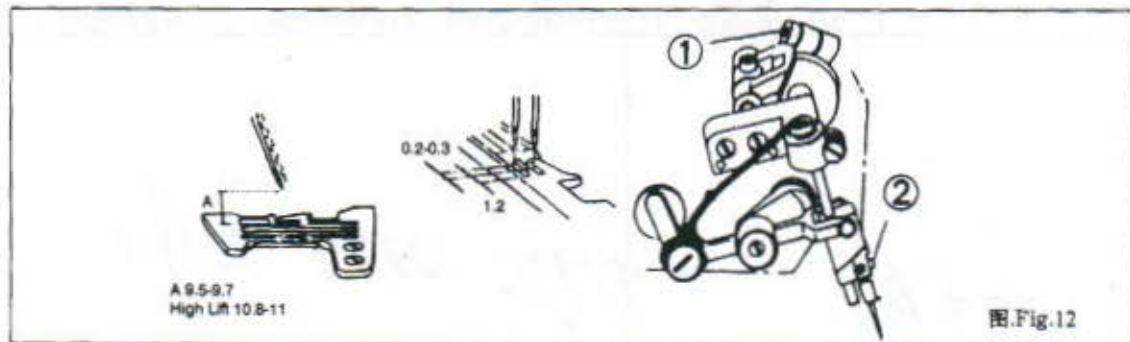
• 当下勾针移到针中心线(双针时以左针为主)时, 针与勾针的间隙为0-0.5mm。

### (4) 上勾针与下勾针的关系 图16

• 当上、下勾针相交会时, 两勾针尽可能接近, 但不可磨擦相撞, 其间隙A点为0.5mm及B点为0.2mm。

### (5) 针与导针片的关系 图17

- 当下勾针尖刚好到针（双针时以左针为准）中心线时，针与后导针片A的间隙为0mm。
  - 当针移到了低点量，针与前导针板B的间隙为0.1-0.2mm。
- (6) 环缝勾针与针的关系 图18
- 当环缝勾针移至最左时勾针尖端与针中心线的距离为2.5mm。



## PART

### (1) Needle and Needle Plate Fig. 12

When the Needle moves to the highest position, the distance between needle point (left needle if two needle) and Needle Plate is 9.5-9.7mm for standard lift machine or 10.8-11.0mm for high lift machine. Each needle must centers in each needle slot of Needle plate. The right needle must ed ahead about 0.2-0.3mm than left needle. And the distance between the needle point (right needle if two needle) to needle slot of Needle Plate or Presser Foot is 1.2mm.

- Slightly loosen Screw ① of Needle Drive Crank.
- Rotate the Pulley to check if needle center in each needle slot of Needle Plate. or you may loosen Screw ② and adjust Needle Holder.
- Rotate the Pulley for removing the needle to the highest position, tap the Needle Holder Guide until the correct needle height is obtained.

- Tighten Screw ①

### (2) Upper Lopper (Spreader) and Needle Fig.13

• When the Upper (spreader) moves to the extremely left, the distance between the point of looper (spreader) and center line of needle is 4.5-5.0, for 1 needle (spreader) to center line of left needle is 5.5-6.0mm for 2 needle machine.

### (3) Lower Lopper and Needle Fig.14.15

- When the Lower Lopper moves to the extremely left, the distance between looper point and center line of needle (left needle if 2 needle) is 3.4-3.6mm for high lift machine.
- When the Lower Lopper moves to the center line of needle (left needle if 2 needle), the gap between needle and looper is 0-0.05mm.

### (4) Upper Lopper and Lower Lopper Fig.16

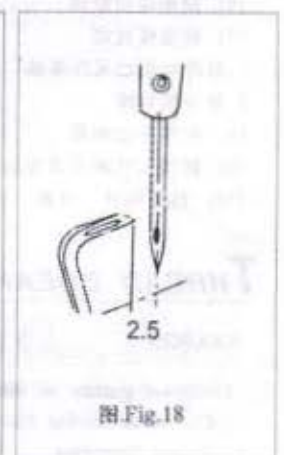
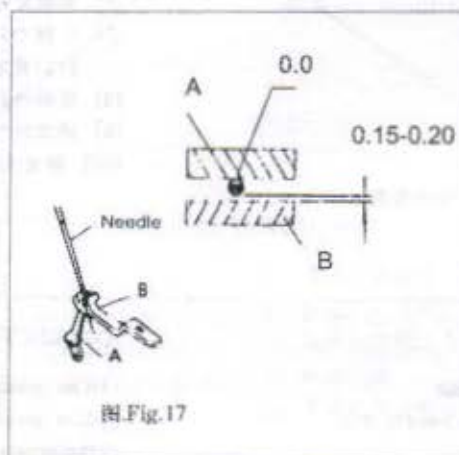
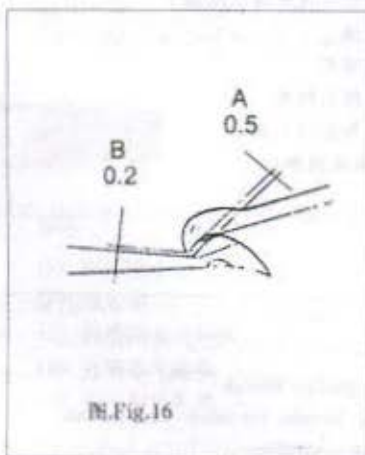
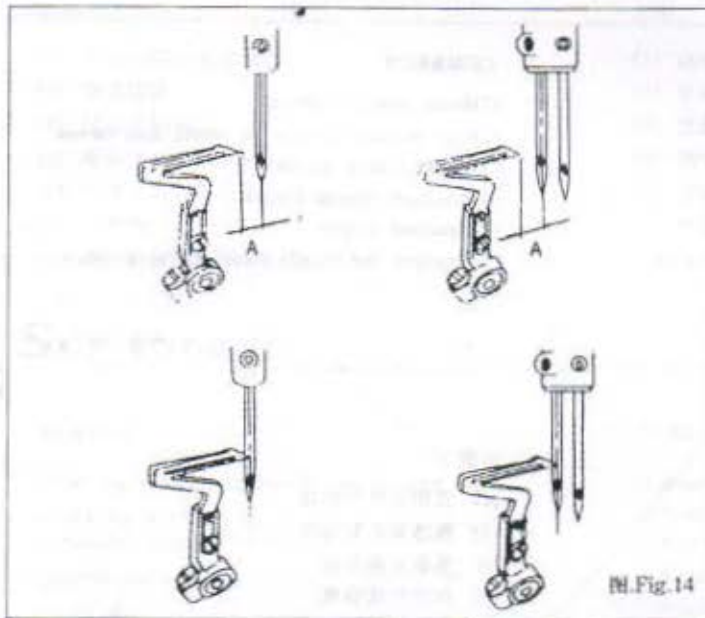
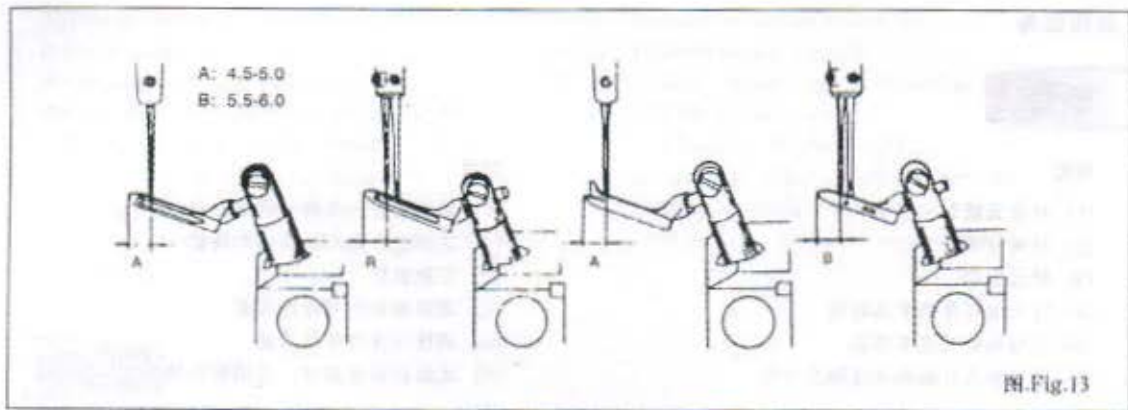
When the Upper and Lower Lopper is crossed.

### (5) Needle and Needle Guard Fig.17

When the Lower Lopper point is opposite the center line of Needle (left needle if 2 needle), the gap between Needle and rear Needle Guard A is 0mm. When Needle moves to the lowest position, the gap between Needle and front Needle Guard B is 0.15-0.2mm.

### (6) Chain Lopper and Needle Fig.18

The Chain Lopper must be fixed into the lowest position of its holder and when the Chain Lopper moves to the extremely left, the distance between the looper point and center line of needle is 2.5 mm.



## 故障排除



### 原因

- (1) 针安装错误
- (2) 针尺寸不合
- (3) 针已变弯
- (4) 针与顶针片的关系错误
- (5) 针与勾针的关系错误
- (6) 针未插入针板沟或压脚中央

### 对策

- (1) 重新装针，长沟面向您自己
- (2) 选用适合布料和缝线的机针
- (3) 更换新针
- (4) 调整顶针片与针的关系
- (5) 调整勾针与针的关系
- (6) 重新装针板或针，或调整压脚

## NEEDLE BREAK

### REASON

- (1) Needle installed wrong
- (2) Wrong needle size.
- (3) Needle is bended.
- (4) Wrong relation with Needle Guard
- (5) Wrong relation with looper
- (6) Needle does not center the needle slot of Needle Plate or Presser Foot

### CORRECT

- (1) Reset needle correctly.
- (2) Use properly needle for fabric and thread.
- (3) Replace new needle.
- (4) Readjust Needle Guard.
- (5) Readjust looper
- (6) Readjust the Needle Plate and Presser Foot.



### 原因

- (1) 线品质不良
- (2) 线粗细不均或比针孔大
- (3) 穿线错误
- (4) 控线压力太强
- (5) 针安装错误
- (6) 线架过线错误
- (7) 针温度过高
  1. 针冷却槽已无冷却油
  2. 针导板装错
- (8) 控线片已粗糙
- (9) 针与勾针的关系错误
- (10) 针、勾针、针板、针导板擦伤起毛头

### 对策

- (1) 改用品质好的线
- (2) 换适宜的针与线
- (3) 重新正确穿线
- (4) 调整控线强度
- (5) 重新正确装针
- (6) 重新装线架使线能通过自如
- (7)
  - 1 加冷却油
  - 2 调整针导片
- (8) 用砂布拉滑后抛光
- (9) 调整针与勾针的关系
- (10) 磨去毛头或换新品

## THREAD BREAK

### REASON

- (1) Inferior quality of thread
- (2) Thread is thicker than Needle hole
- (3) Wrong threading

### CORRECT

- (1) Use good quality thread.
- (2) Use proper Needle for fabric and thread.
- (3) Rethreading correctly.

- (4) Thread tension is too strong
- (5) Needle installed wrong
- (6) Thread Stand installed wrong
- (7) Over heat of Needle 1.No silicon oil 2 Wrong setting of Needle Guard
- (8) Thread Disc or Guide is burred
- (9) Wrong relation of Needle and Looper
- (10) Needle, Looper, Needle Plate and Guide is burred

- (4) Readjust thread tension nut.
- (5) Reset needle correctly.
- (6) Reset thread stand for threading smoothly.
- (7) 1. fill in Silicone oil  
2. Readjust Needle Guard
- (8) Grind off polish or replace new one.
- (9) Readjust Needle and Looper
- (10) Grind off, polish or replace new one.



**原因**

- (1) 针与勾针的关系错误
- (2) 穿线错误
- (3) 针安装错误
- (4) 控线压力太强或太弱
- (5) 勾针尖端损坏起毛头
- (6) 针变弯
- (7) 顶针片安装错误

**对策**

- (1) 调整针与勾针关系
- (2) 重新正确穿线
- (3) 重新正确装针
- (4) 调整控线强度
- (5) 去除毛头或换新品
- (6) 换新品
- (7) 重新正确安装顶针片

## SKIP STITCHES

**REASON**

- (1) Wrong relation of Needle and Looper
- (2) Wrong threading
- (3) Needle installed wrong
- (4) Inadequate thread tension or tension too strong
- (5) Looper point is damaged
- (6) Needle is bended
- (7) Wrong installed Needle Guard

**CORRECT**

- (1) Readjust Needle and Looper
- (2) Rethreading correctly.
- (3) Reset Needle correctly.
- (4) Readjust Thread Tension Nut.
- (5) Replace new one.
- (6) Replace new one.
- (7) Readjust Needle Guard



**原因**

- (1) 穿线错误
- (2) 线太粗
- (3) 控线圈未压到线
- (4) 针线已无硅油
- (5) 针与勾针装错

**对策**

- (1) 重新正确穿线
- (2) 换适当尺寸的针
- (3) 调整控线圈适当压着线
- (4) 添加硅油
- (5) 重新正确安装

## LOOSE

### REASON

- (1)Wrong threading
- (2)Thread is thicker than Needle hole
- (3)Tension Disc do not press thread properly
- (4)Needle thread is not lubricated
- (5)Wrong setting of Needle and Loopers

### CORRECT

- (1)Rethreading correctly.
- (2)Use proper Needle
- (3)Reset Tension Disc properly
- (4)Fill silicon oil
- (5)Readjust Needle and Loopers.

## 缝合不均

### 原因

- (1) 穿线错误
- (2) 线架安装错误
- (3) 下刀安装错误
- (4) 刀未能剪布整齐
  1. 刀装错
  2. 刀钝
- (5) 过线孔擦伤
- (6) 针尖受损
- (7) 送料具高度不适宜
- (8) 押具压力太强或太弱

### 对策

- (1) 重新正确穿线
- (2) 重新装线架使线能通过自如
- (3) 重新安装下刀
- (4) 1 调整刀正确位置
  - 2 磨利或换新品
- (5) 重新打光
- (6) 换新针
- (7) 调整正确高度
- (8) 调整押具压力强度

## UNEVEN

### REASON

- (1)Wrong threading
- (2)Thread Stand installed wrong
- (3)Lower Knife installed wrong
- (4)Knives do not trim neatly.
  1. Knives installed wrong
  2. Dull lower Knife
- (5)Thread Disc or Guide is burred
- (6)Needle point is damaged
- (7)Inadequate heigh of Feed Dogs
- (8)Inadequate thread tension

### CORRECT

- (1)Rethreading correctly.
- (2)Reset Thread for threading smoothly.
- (3)Readjust Lower Knife.
- (4)Correct as follow:
  - 1.Readjust Knives
  - 2.Sharpen or replace new Knives.
- (5)Grind off, polish or replace new one
- (6)Replace new Needle.
- (7)Readjust Feed Dogs.
- (8)Readjust Thread Tension Nut.

## 缝合起皱纹

### 原因

- (1) 控线压力大强
- (2) 押具压力太强或太弱
- (3) 送料具太突出针板
- (4) 刀无法快切
- (5) 差动送料未配合
- (6) 针太粗
- (7) 包边宽度比针板舌狭窄

### 对策

- (1) 重新调整控线强度
- (2) 调整押具压力强度
- (3) 调整送料具正确高度
- (4) 磨利刀片或换新品
- (5) 调整适当差动送料
- (6) 用适宜布和线的针
- (7) 调整包边宽度或换针板舌

## WRINKLED SEAM

### REASON

- (1) Thread tension is too strong
- (2) Inadequate pressure of Presser Foot
- (3) Inadequate height of Feed Dogs
- (4) Knives do not trim neatly
- (5) Differential feed is not matched
- (6) Needle is too thick
- (7) Seam width is too narrow against the chain-off finger of Needle Plate

### CORRECT

- (1) Readjust Thread Tension Nut.
- (2) Readjust Presser Foot pressure.
- (3) Readjust Feed Dogs.
- (4) Readjust Knives or sharpen Knives.
- (5) Readjust differential feed ratio.
- (6) Use proper Needle for fabric and thread.
- (7) Readjust seam width or replace chain off finger.

## 环缝出线不顺原因

### 原因

- (1) 押具安装错误
- (2) 勾针线凸轮运动时间配合不适当
- (3) 环缝勾针安装错误
- (4) 穿线错误
- (5) 控线强度太大或太弱
- (6) 针与勾针的关系错误
- (7) 针板或押舌起毛边
- (8) 控制片已粗糙

### 对策

- (1) 重新正确安装
- (2) 调整适当凸轮方位
- (3) 重新正确安装
- (4) 重新正确穿线
- (5) 调整适当控线强度
- (6) 调整针与勾针的关系
- (7) 用砂布或油石打磨并抛光
- (8) 用砂布拉磨并抛光

## THREAD CHAIN DISK

### REASON

- (1) Presser Foot installed wrong
- (2) Inadequate timing of Looper Thread Cam
- (3) Double Chain Looper installed wrong
- (4) Wrong threading
- (5) Inadequate or too strong thread tension
- (6) Wrong relation of Needle and Looper
- (7) Needle Plate Thread Disc or Presser Foot is burred.
- (8) Thread tension disk is rough.

### CORRECT

- (1) Reset Presser Foot correctly.
- (2) Readjust Looper thread Cam.
- (3) Reset Double Chain Looper correctly.
- (4) Rethreading correctly.
- (5) Readjust Thread Tension Nut.
- (6) Readjust Needle and Looper.
- (7) Grind off, polish or replace new one.
- (8) Polish thread tension disk.

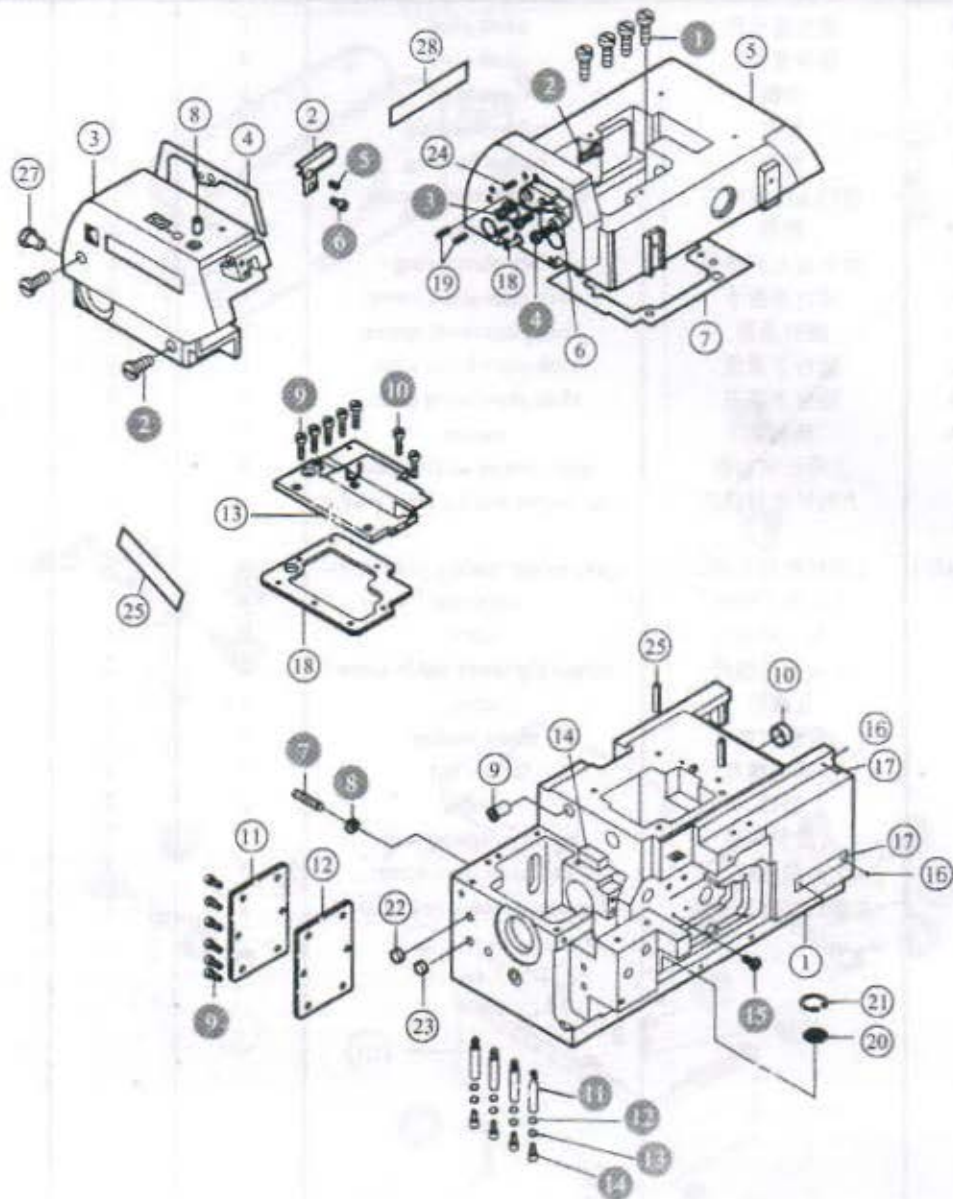
# 1.机壳部分 Frame Assembly

序号 No	件号 Part No	名称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTC89	机壳	machine frame	1	1	1
2	YTA04	针线罩壳护板	needle thread cover plate	1	1	1
3	YTA05	上罩	upper onode cover	1	1	1
4	YTA06	上节罩垫	upper onode cover pad	1	1	1
5	YTA08	车壳上节	lathe shell upper knot	1	1	1
6	YTA09	针杆座	needle plate	1	1	1
7	YTA10	上节垫片	upper washer	1	1	1
8	YTA12	油管	oil tube	1	1	1
9	YTA14	回油胶套	rear oil adhesive case	1	1	1
10	YTA22	油封	oil seal	1	1	1
11	YTA25-1	后盖板	rear cover	1	1	1
12	YTA25-2	后盖板油封	rear cover oil seal	1	1	1
13	YTA27	盖板	cover	1	1	1
14	YTA28	油封垫	oil sear washer	1	1	1
15	YTA29	盖板垫	cover washer	1	1	1
16	YTA33	铆钉	rivet	4	4	4
17	YTA36	机型牌	machine model plate	1	1	1
18	YTA38	塑料管	model tube	1	1	1
19	YTA39	圆柱销	pin	2	2	2
20	YTA40	滤油网	oil screen	1	1	1
21	YTA42	卡簧	snap ring	1	1	1
22	YTA21	油封 I	oil seal i	1	1	1
23	YTA24	油封 II	oil seal ii	1	1	1
24	YTP07	开口销	begin pin	4	4	4
25	YTA65	商标牌	trade mark plste	1	1	1
26	YTA67	油封	oil seal	1	1	1
27	YTA84	标牌	mark plate	1	1	1
1	S307	车壳连接螺钉	screw	4	4	4
2	S292	左罩螺钉	screw	3	3	3
3	S290	针杆座螺钉	needle bar asm screw	2	2	2
4	S299	针杆座紧固螺钉	needle lind set screw	1	1	1
5	S216	针杆罩壳护板顶丝	needle thread cover plate top silk	1	1	1
6	S357	针杆罩壳护板紧固螺钉	needle thread cover plate set screw	1	1	1
7	S268	大盖轴调节螺钉	main cover bearing regulate screw	1	1	1
8	N26	大盖轴调节螺母	main cover bearing regulate nut	1	1	1
9	S257	后盖板螺钉	rear cover plate	11	11	11
10	S261	盖板螺钉	lower cover plate	2	2	2
11	S401	油盘连接螺钉	oil pan join screw	4	4	4
12	W23	油盘连接垫圈	washer	4	4	4
13	W02	油盘连接弹性垫圈	elasticity washer	4	4	4
14	S400	油盘连接内六角螺钉	nexagon socket screw	4	4	4
15	S308	螺钉	screw	1	1	1

注：零件样本图序号说明：○—代表零件；●—代表螺钉螺母。

一.机壳部分

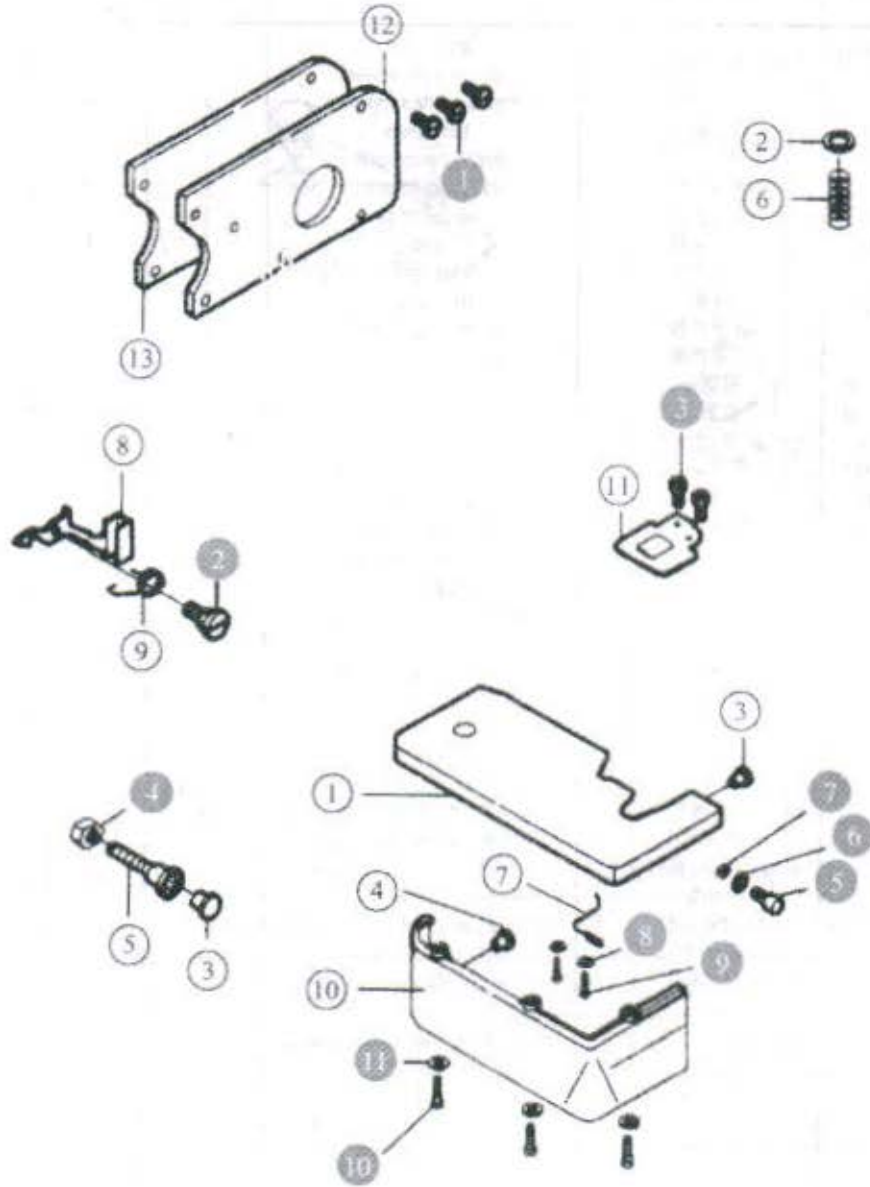
Frame Assembly



## 2.缝台部分 Cloth plate assemblies

序号 No	件号 Part No	名称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTB01	缝台盖组件	cloth plate	1	1	0
	YTB02	缝台盖组件	cloth plate	0	0	1
2	YTB03	垫圈	washer	1	1	1
3	YTB04	胶套	rubber bushing	4	4	4
4	YTB05	胶套	rubber bushing	1	1	1
5	YTB06	缝台盖防震螺钉	cloth plate spring screw	1	1	1
6	YTB08	弹簧	spring	1	1	1
7	YTB12	缝台盖开启弹簧	cloth plate spring	1	1	1
8	YTB15	缝台盖板手	cloth plate slider cover	1	1	1
9	YTB17	缝台盖簧	cloth plate cover spring	1	1	1
10	YTB22	缝台下罩壳	cloth plate lower plate	1	1	0
	YTB23	缝台下罩壳	cloth plate lower plate	0	0	1
11	YTB29	挡油罩	washer	1	1	1
12	YT30	上弯针密封板	upper looper sealing plate	1	1	1
13	YT31	上弯针密封板垫	upper looper sealing plate washer	1	1	1
1	YTB06E-1	上弯针密封板螺钉	upper looper sealing plate screw	3	3	3
2	S279	大盖板手螺钉	set screw	1	1	1
3	S217	凸轮上罩螺钉	screw	2	2	2
4	N26	大盖定位螺母	set nut big cover stable screw	2	2	2
5	S403	台螺钉	screw	1	1	1
6	W09	台螺钉垫	screw washer	1	1	1
7	N23	台螺钉螺母	screw nut	1	1	1
8	W06	垫圈	washer	2	2	2
9	S221	大盖簧螺钉	big cover spring screw	2	2	2
10	S560	大盖连接螺钉	big cover joint screw	3	3	3
11	W05	大盖连接螺钉垫圈	big cover joint screw washer	3	3	3

注：零件样本图序号说明：○—代表零件；●—代表螺钉螺母。

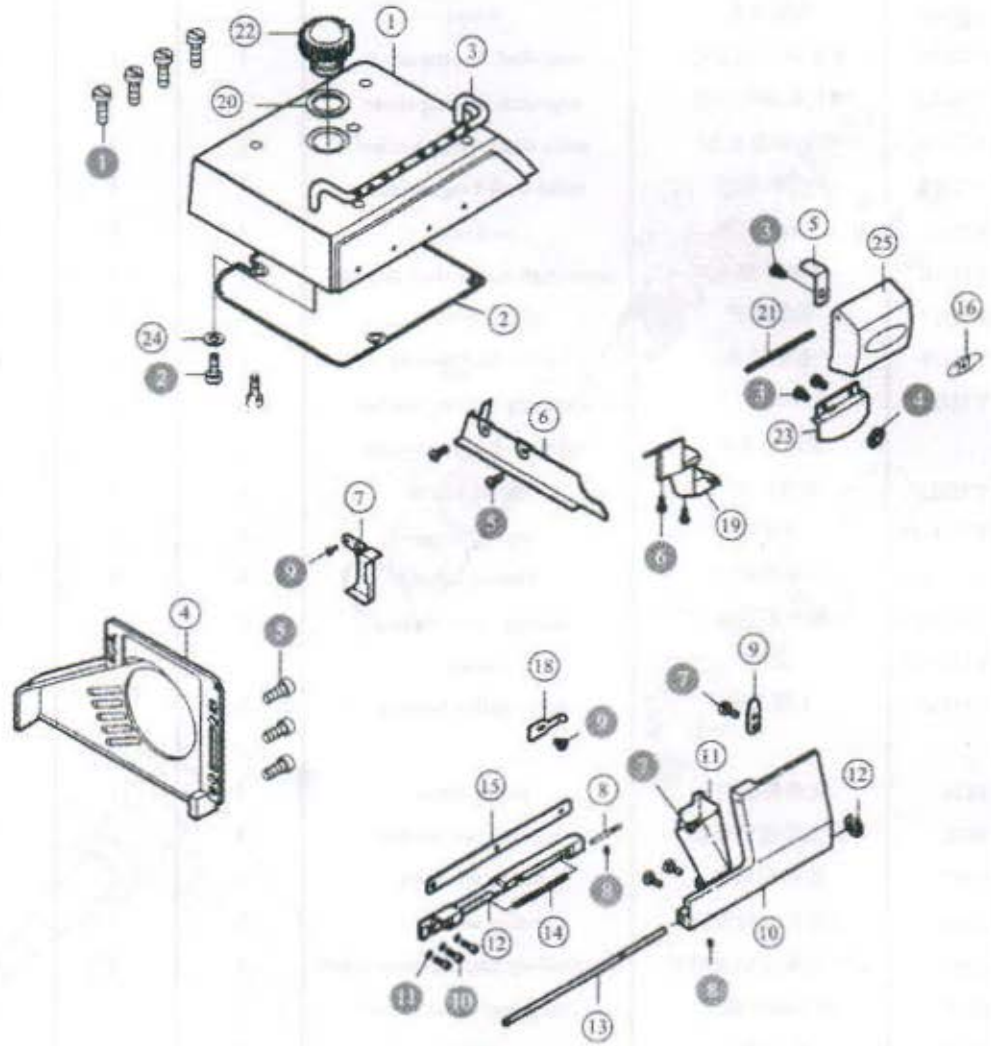


### 3. 罩壳部分 Cover assemblies

序号 No	件号 Part No	名称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTC01F	上盖	upper cover	1	1	1
2	YTC03	上盖垫	upper cover washer	1	1	1
3	YTC05E	过线架	thread guide supporter	1	1	1
4	YTC09F	皮带轮罩	belt cover	1	1	1
5	YTC13	针线罩壳簧	thread cover spring	1	1	1
6	YTC15	缝料挡板	cloth guide plate	1	1	1
7	YTC17	挡油板 II	oil guide II	1	1	1
8	YTC18	前罩架销	pin	1	1	1
9	YTC20	前罩簧片	front spring	1	1	1
10	YTC21E	前罩	front cover	1	1	0
11	YTC22B	前罩挡板	front cover guard	0	0	1
	YTC23B	前罩挡板	front cover guard	1	1	1
12	YTC24B	前罩架	front cover hinge	1	1	1
13	YTC25B	前罩销	hinge pin	1	1	1
14	YTC28	前罩架弹簧	front cover hinge spring	2	2	2
15	YTC29	前罩架垫	front cover hinge washer	1	1	1
16	YTC38F	商标牌	trade mark plate	1	1	1
17	YTC39-4	进油指示	oil flow window	2	2	2
18	YTC36	前罩挡板簧	front cover snap guard	1	1	1
19	YTC55B	挡油板 I	oil guide I	1	1	1
20	YTC58	油标垫	oil level gauge washer	1	1	1
21	YTC62	上罩销	pin	1	1	1
22	YTC67	油标盖	oil level gauge washer	1	1	1
23	YTC69F	有机玻璃罩	oil sight	1	1	1
24	YTC81	垫圈	washer	1	1	1
25	YTC61F	上罩	upper cover	1	1	1
1	S503	上盖螺钉	upper cover screw	4	4	4
2	S438	过线架螺钉	thread guard screw	2	2	2
3	S233	上罩簧片螺钉	upper cover spring screw	3	3	3
4	M84	垫圈	washer	2	2	2
5	S257	缝料挡板螺钉	cloth guide plate screw	5	5	5
6	S238	挡板螺钉 I	oil guard screw I	2	2	2
7	S432	挡板螺钉	snap plate	4	4	4
8	S401	铰链销固定螺钉	screw	3	3	3
9	S250	前罩板簧螺钉	front cover plate block spring screw	2	2	2
10	S245	前罩架螺钉	front cover hinge screw	3	3	3
11	W09	前罩架垫	front cover hinge washer	3	3	3
12	E03	卡簧	snap ring	1	1	1

注：零件样本图序号说明：○—代表零件；●—代表螺钉螺母。

三.罩壳部分 Cover Assemblies

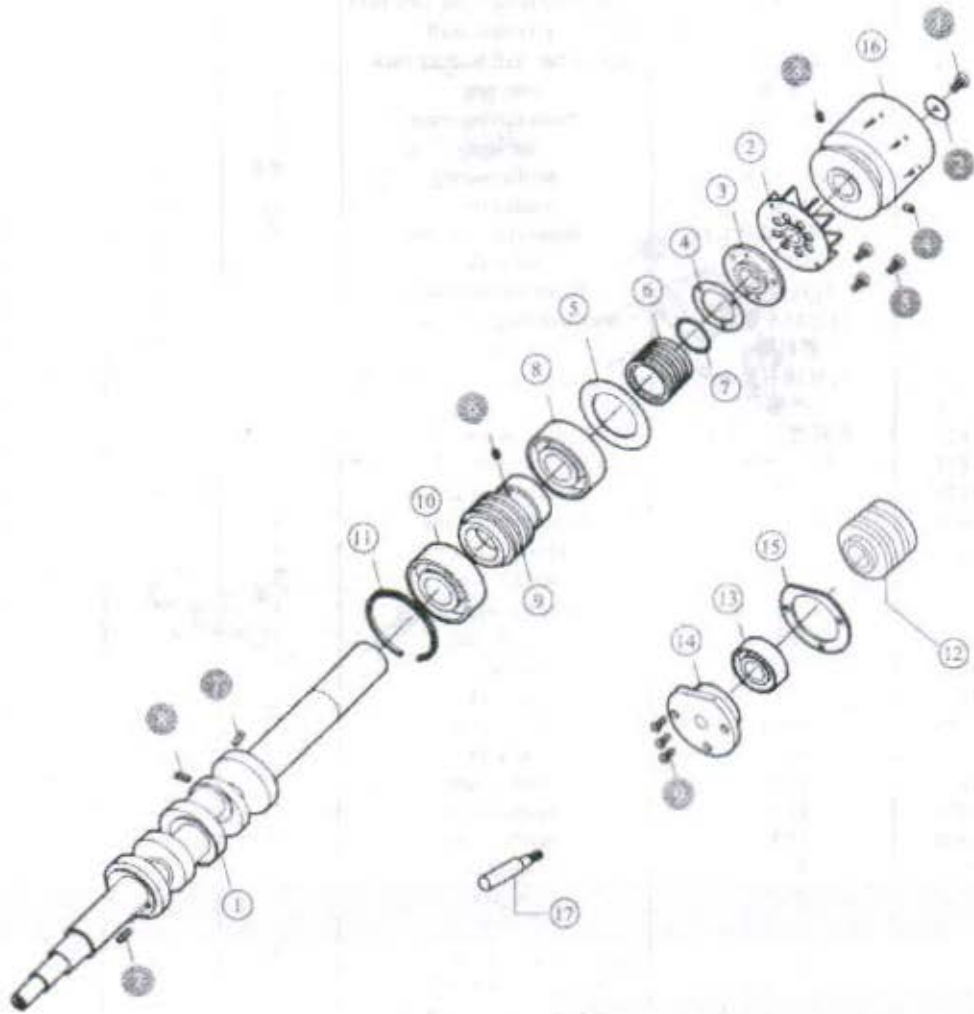


## 4. 主轴部分 Main shaft assemblies

序号 No	件号 Part No	名称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTD01	主轴	main shaft	1	1-	1
2	YTD09	冷却风扇	wheel	1	1	1
3	YTD100	滚针轴承制动盖	rear shaft bearing cover	1	1	1
4	YTD120	滚针轴承制动垫	rear shaft bearing cover	1	1	2
5	YTD13	主轴弹簧垫圈	main shaft spring washer	1	1	1
6	YTD14	叶轮间隔套	main shaft bysgubg asm	1	1	1
7	YTD15	主轴密封圈	seal ring	1	1	1
8	YTD16	主轴后轴承	main shaft queen shaft bearing	1	1	1
9	YTD17	油泵蜗杆	oil pump worm	1	1	1
10	YTD19	主轴轴承	main shaft bearing	1	1	0
11	YTD20	卡簧	shaft and bushing washer	0	0	1
12		主轴中套筒	main shaft light bushing	1	1	1
13	YTD22	轴承80200	bearing 80200	1	1	1
14	YTD27D	轴承盖	bearing cover	1	1	0
	YTD26D	轴承盖	bearing cover	0	0	0
15	YTD28D	轴承盖垫圈	bearing cover washer	1	1	1
16	YTD35D	上轮	pulley	1	1	1
17	YTD36	上轮凸轴	bulgy pulley bearing	0	0	1
1	S374	皮带轮螺钉	pulley screw	1	1	1
2	W02	皮带轮螺钉垫圈	pulley screw washer	1	1	1
3	S347	皮带轮顶丝	pulley set screw	1	1	1
4	S414	皮带轮定位螺钉	pulley set scerw	1	1	1
5	S257	滚针轴承止动盖螺钉	rear shafting bearing cover screw	3	3	3
6	S270	油泵蜗杆螺钉	oil pump worm screw	1	1	1
7	S396	油瓦螺钉	screw	2	2	2
8	S235	油孔螺钉	screw	1	1	1
9	S241	轴承盖螺钉	bearing cover screw	3	3	3

注：零件样本图序号说明：○—代表零件；●—代表螺钉螺母。

四. 主轴部分 Main shaft assemblies

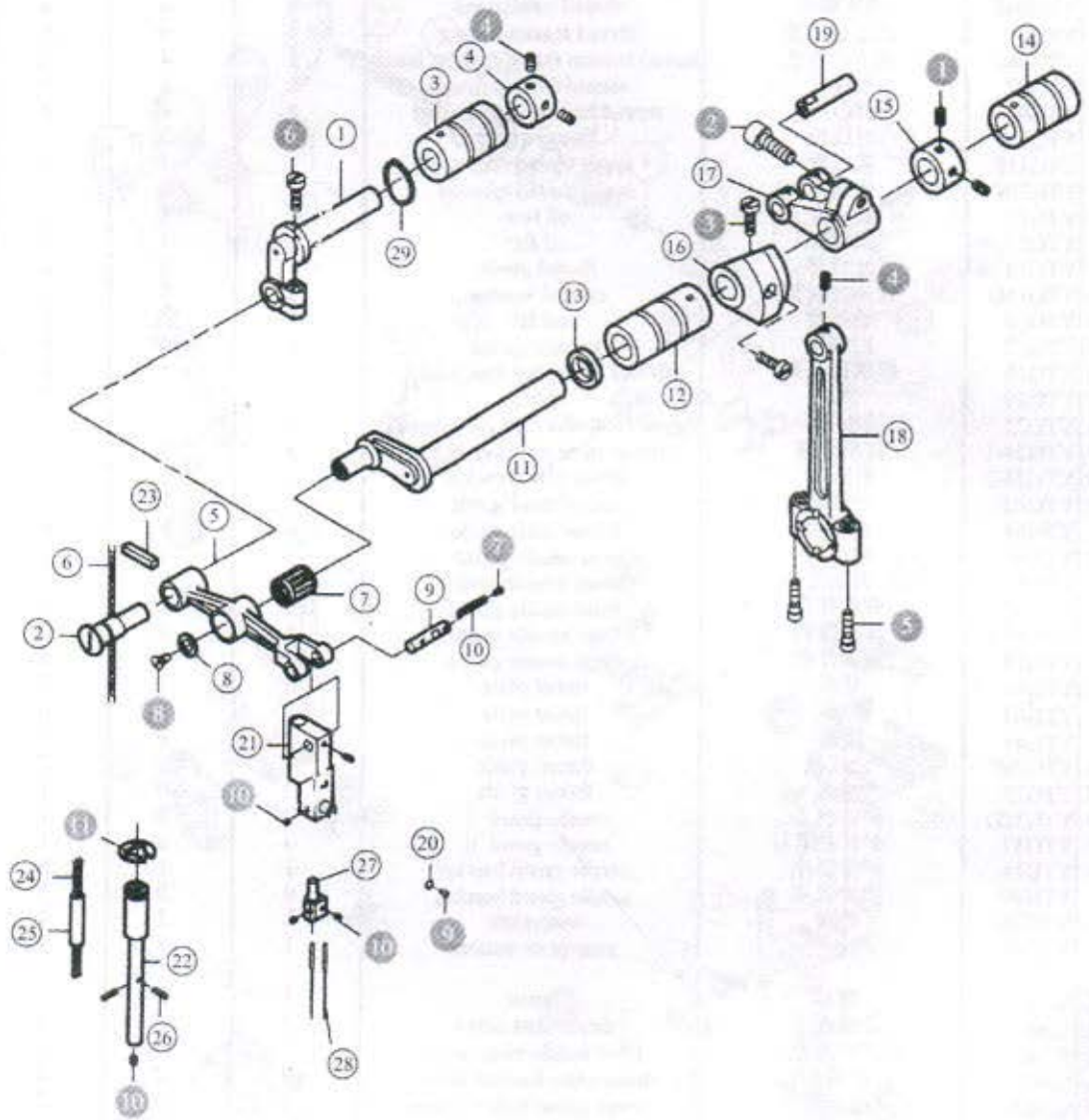


## 5. 针杆部分 Needle bar assemblies

序号 No	件号 Part No	名称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTF01	针杆曲柄轴	needle bar driving frame rock shaft	1	1	1
2	YTF02	针杆曲柄销	eccentric shaft	1	1	1
3	YTF05	针杆轴后套筒	needle bar shaft bushing back	1	1	1
4	YTF07	挡圈	snap ring	1	1	2
5	YTF09	针杆传动曲柄	throat driving crank	1	1	1
6	YTF10F	油线	oil wick	1	1	1
7	YTF11	滚针轴承	needle bearing	1	1	1
8	YTF12	垫圈	washer ring	1	1	1
9	YTF14	针夹导线销	throat clip guide pin	1	1	1
10	YTF16	油线	oil wick	1	1	1
11	YTF17	针杆摆轴	throat bar rock crank	1	1	1
12	YTF18	行针轴左套筒	needle driving shaft bearing	1	1	1
13	YTF19	密封圈	seal ring	2	2	2
14	YTF20	行针轴右套筒	needle bar frame rock shaft crank	1	1	1
15	YTF21	挡圈	snap ring	2	2	2
16	YTF23	针杆摆轴平衡块	balance block	1	1	1
17	YTF25	针杆摆轴曲柄	needle bar frame rock shaft crank	0	1	0
	YTF26	针杆摆轴曲柄	throat bar shaft crank	1	0	1
18	YTF28	针杆传动连杆	needle bar connecting rod	1	1	1
19	YTF30	针杆传动连杆销	connecting link pin	1	1	1
20	YTF31	垫圈	washer ring	1	1	1
21	YTF32	针夹导套	throat clip guide bushing	1	1	1
22	YTF33	针夹导杆体	needle bar	1	1	1
23	YTF34	毛毡	oil felt	1	1	1
24	YTF35	油线	oil wick	1	1	1
25	YTF35F	塑料管	plastics tube	1	1	1
26	YTF37	油线	oil wick	2	2	2
27	YTF38	针夹	needle clamp	0	1	0
	YTF39	针夹	needle clamp	1	0	0
	YTF40	针夹	needle clamp	0	0	1
28	YTF41	机针	needle	1	2	2
29	YTF42	油封	oil seal	1	1	1
	S293	挡圈螺钉	snap ring screw	4	4	4
	S612	针杆摆轴曲柄螺钉	hexagon socket screw	1	1	1
	S291	针杆摆轴平衡块螺钉	balance block position screw	2	2	2
	S270	行针传动连杆顶丝	frame rock shaft set screw	3	3	3
	S385	行针传动连杆螺钉	shaft position screw	2	2	2
	S287	针杆曲柄紧固螺钉	screw	1	1	1
	S204	油线堵油螺钉	screw	1	1	1
	S212	垫圈螺钉	screw	1	1	1
	S221	垫圈螺钉	screw	1	1	1
	S216	顶针螺钉	screw	5	5	5
	E01	卡簧	snap ring	1	1	1

注：零件样本图序号说明：○—代表零件；●—代表螺钉螺母。

# 五.针杆部分 Needle bar assemblies

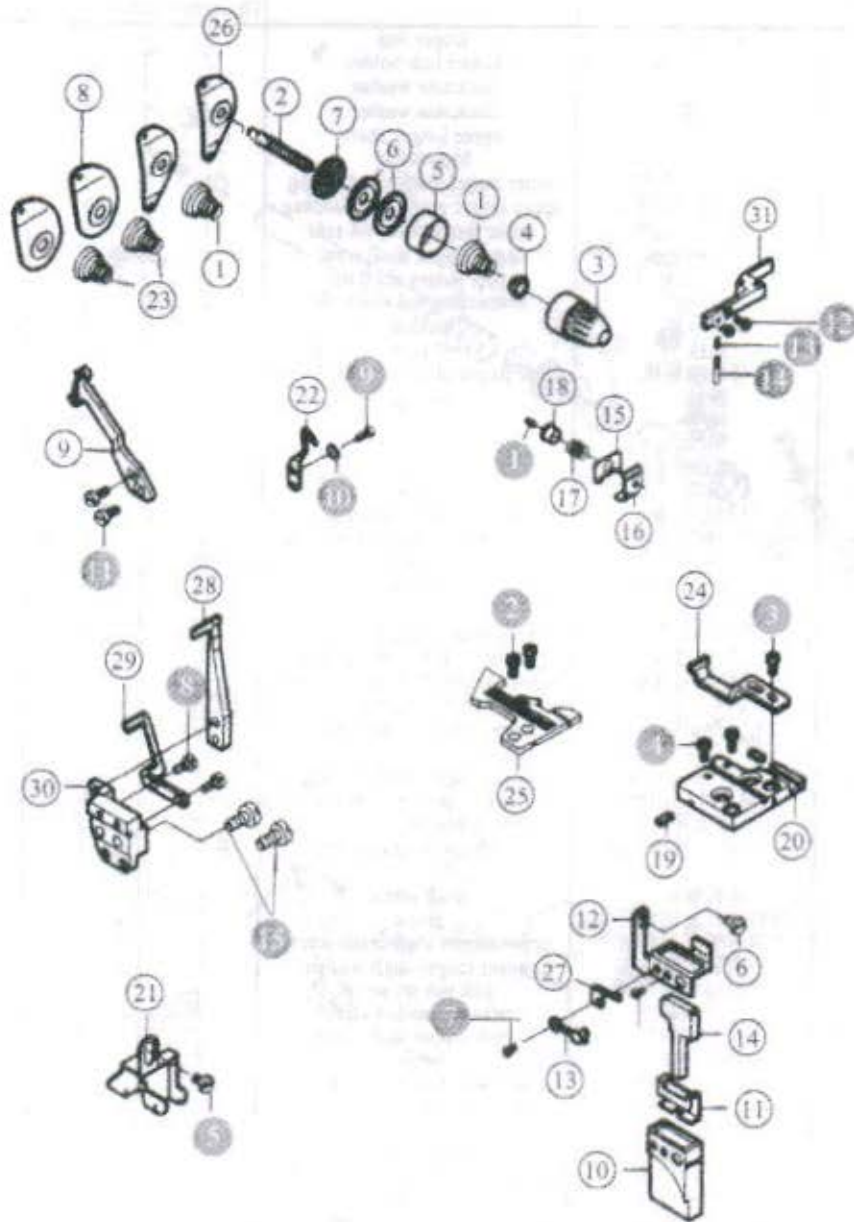


## 6.过线部分 Thread guide assemblies

序号 No	件号 Part No	名称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTG02E	弯针调压簧	thread tension spring	1	2	2
2	YTG03	夹线螺钉	thread tension screw	3	4	4
3	YTG04F	调压螺母	thread tension nut	3	4	4
4	YTG05	调压止动套	thread tension spring	3	4	4
5	YTG06E	调压止动盖	thread tension spring retainer house	3	4	4
6	YTG07	夹线片	thread tension disc	6	8	8
7	YTG08	夹线片垫	thread tension disc washer	3	4	4
8	YTG09F	过线板	thread guide	2	2	2
9	YTG11F	挑线板	upper thread take-up	1	1	0
	YTG60F	挑线板	upper thread take-up	0	0	1
10	YTG12	硅油盒	oil box	1	1	1
11	YTG13	油毡垫架	oil felt	1	1	1
12	YTG14	过线架	thread guide	1	1	1
13	YTG15D	硅油盒胶垫	oil box washer	1	1	1
14	YTG16	油毡垫	oil felt	1	1	1
15	YTG17	拦线板	tension spring	1	1	1
16	YTG18	拦线板支架	thread controller disc holder	1	1	1
17	YTG19	弹簧	spring	1	1	1
18	YTG21	拦线板导向套	thread controller disc guide bushing	1	1	1
19	YTG24-1	针板座键	throat plate positioning rod	2	2	2
20	YTG24-2	针板座	throat plate bracket	1	1	1
21	YTG42	过线架	thread mark guide	1	0	1
	YTG54	过线架	thread mark guide	0	1	0
22	YTG59	护针挡	reat needle guard	1	1	1
23	YTG68	调压簧	thread tension spring	2	2	3
24	YTG47-2	前护针挡	front needle guard	0	1	0
	YTG47-1	前护针挡	front needle guard	1	0	0
	YTG35	前护针挡	front needle guard	0	0	1
25	YTG43	针板	throat plate	0	1	0
	YTG44	针板	throat plate	1	0	0
	YTG45	针板	throat plate	0	0	1
26	YTG20F	过线板	thread guide	1	2	2
27	YTG25	过线	thread guide	0	0	1
28	YTG31D	护针挡 I	needle guard I	0	0	1
29	YTG37	护针挡 II	needle guard II	0	0	1
30	YTU18	护针挡座	needle guard barcket	1	1	0
	YTG39	护针挡座	needle guard barcket	0	0	1
31	YTG26	挡板	snap plate	1	1	1
32	YTG46	挡板垫	snap plate washer	1	1	1
1	S216	螺钉	screw	1	1	1
2	S260	针板螺钉	throat plate screw	2	2	2
3	S230	前护针板螺钉	front needle snap screw	1	1	1
4	S299	针板座螺钉	throat plate barcket screw	2	2	2
5	S250N	过线架螺钉	thread guide holder screw	2	2	2
6	S250N	硅油盒固定螺钉	oil box set screw	1	1	1
7	S359	硅油盒胶垫固定螺钉	oil box washer set screw	1	1	1
8	S209	后护针挡螺钉	rear needle guard screw	2	2	4
9	S243	护针挡螺钉	needle guard screw	1	1	1
10	W03	护针挡垫圈	needle guard washer	1	1	1
11	S233	挑线螺钉	thread take up screw	2	2	2
12	S242	挡板螺钉 I	snap plate screw I	2	2	2
13	S235	挡板螺钉 II	snap plate screw II	1	1	1

注：零件样本图序号说明：○—代表零件；●—代表螺钉螺母。

六.过线部分 Thread guide assemblies

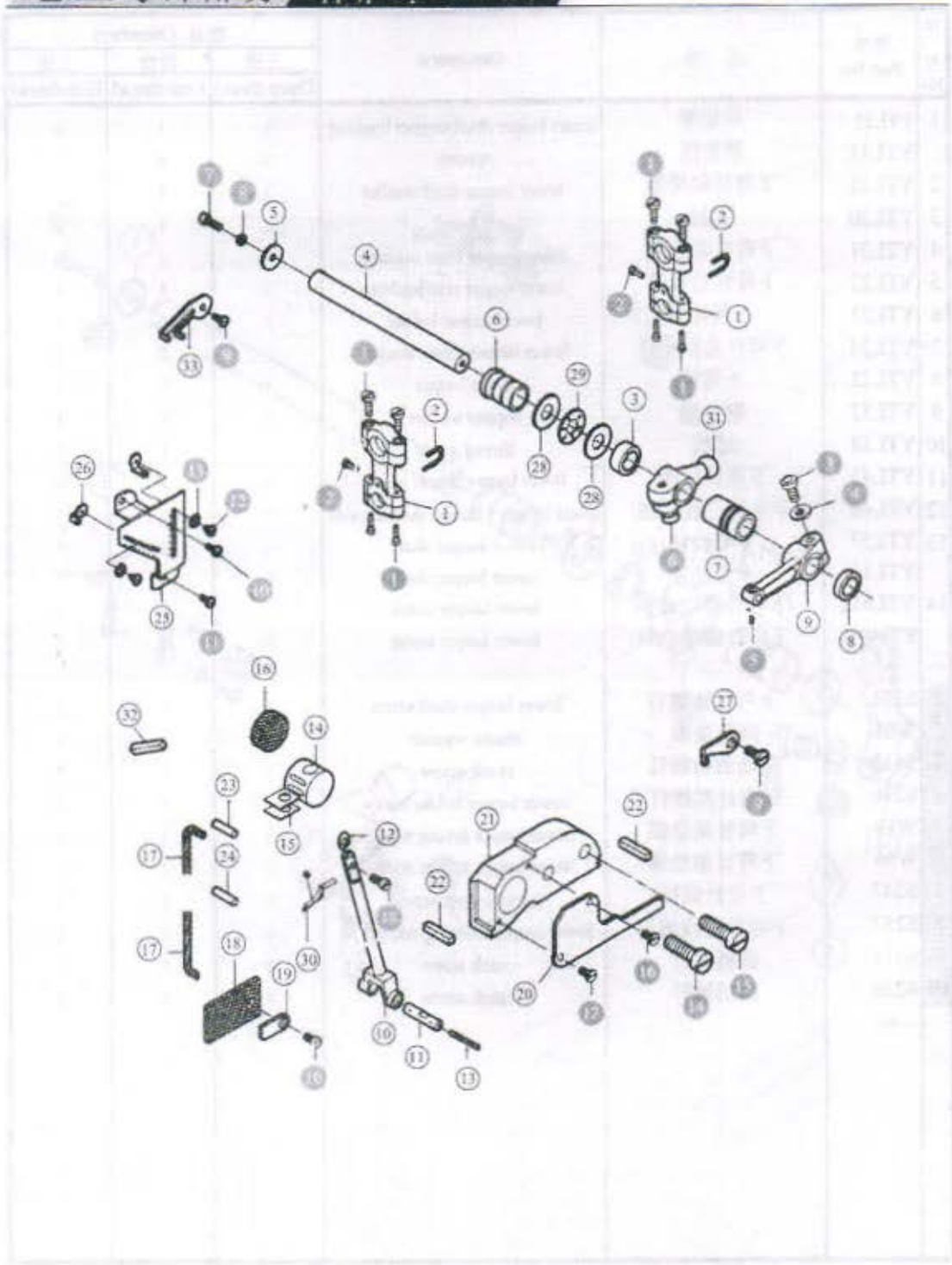


## 7. 上弯针部分 Upper looper assemblies

序 号 No	件号 Part No	名 称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTJ01	弯针连杆	looper link	2	2	2
2	YTJ06	弯针连杆摆架	looper link holder	2	2	2
3	YTJ10	厚度圈	thickness washer	0	1	0
	YTJ13	厚度圈	thickness washer	1	0	1
4	YTJ15	上弯针轴	upper looper shaft	1	1	1
5	YTJ16	大垫圈	big washer	1	1	1
6	YTJ19	上弯针轴后套筒	upper looper shaft rear bushing	1	1	1
7	YTJ20	上弯针轴前套筒	upper looper shaft front bushing	1	1	1
8	YTJ21	上弯针轴油封	upper looper shaft oil seal	1	1	1
9	YTJ22	上弯针轴曲柄	upper looper shaft crank	1	1	1
10	YTJ26	上弯针连杆	upper looper shaft bar	1	1	1
11	YTJ27	连杆销	connecting rod shaft pin	1	1	1
12	YTJ28	连杆衬片	washer	1	1	1
13	YTJ29	油线	oil wick	1	1	1
14	YTJ30	上弯针轴导块	upper looper shaft slide block	1	1	1
15	YTJ33	油毡	oil felt	2	2	2
16	YTJ34	油毡	oil felt	1	1	1
17	YTJ37	油线	oil wick	2	2	2
18	YTJ39	滤油板	screen oil plate	1	1	1
19	YTJ40	压板	felt plate	1	1	1
20	YTJ41	导架座挡板	thread holder snap plate	1	1	1
21	YTJ42	上弯针轴导架座	upper looper shaft slide bar bracket	1	1	1
22	YTJ44	油封	oil seal	2	2	2
23	YTJ47	油管	oil tube	1	1	1
24	YTJ49	油管	oil tube	1	1	1
25	YTJ61	调线刻度板	thread amount regulating plate	1	1	1
26	YTJ63	上弯针过线	upper looper thread guard	1	1	1
27	YTJ66	上弯针轴过线板	upper looper shaft thread plate	1	1	1
28	YTJ71	轴承挡板	shaft bearing guard	2	2	2
29	YTJ79	滚针端盖轴承	lower looper holder copper	1	1	1
30	YTJ80	弯针	looper	1	1	1
31	YTJ612	上弯针摆动曲柄	upper looper crank bearing	0	1	0
	YTL09	上弯针摆动曲柄	upper looper crank bearing	1	0	1
32	YTJ32	穿线管	threading tube	2	2	2
33	YTJ68	两孔过线板	two for thread guide	1	1	1
1	S385	连杆螺钉	shaft screw	8	8	8
2	S408	弯针连杆止动螺钉	screw	2	2	2
3	S295	上弯针轴曲柄螺钉	upper looper shaft crank screw	1	1	1
4	W11	上弯针轴曲柄垫圈	upper looper shaft washer	1	1	1
5	S216	上弯针轴曲柄顶丝	link pin set screw	1	1	1
6	S612	摆动曲柄螺钉	hexagon socket screw	1	1	1
7	S261	上弯针轴螺钉	upper looper shaft screw	1	1	1
8	W03	弹簧垫圈	washer	1	1	1
9	S257	上弯针轴过线架螺钉	upper looper shaft thread guide	2	2	2
10	S250	调线刻度板螺钉	thread amount regulating plate			
11	S262	调线刻度板螺钉	screw	1	1	1
12	S223	弯针过线螺钉	looper shaft thread guide screw	2	2	2
13	W06	弯针过线垫圈	looper shaft thread guide washer	2	2	2
14	S454	上弯针轴导板螺钉	upper looper shaft thread plate screw	1	1	1
15	S300	上弯针轴导板螺钉	upper looper shaft thread plate screw	1	1	1
16	S221	导架座挡板螺钉	thread holder snap plate screw	1	1	1
17	S451	导架座挡板螺钉	thread holder snap plate screw	1	1	1
18	S229	上弯针紧固螺钉	upper looper set screw	1	1	1

注：零件样本图序号说明：○—代表零件；●—代表螺钉螺母。

七.上弯针部分 Upper looper assemblies

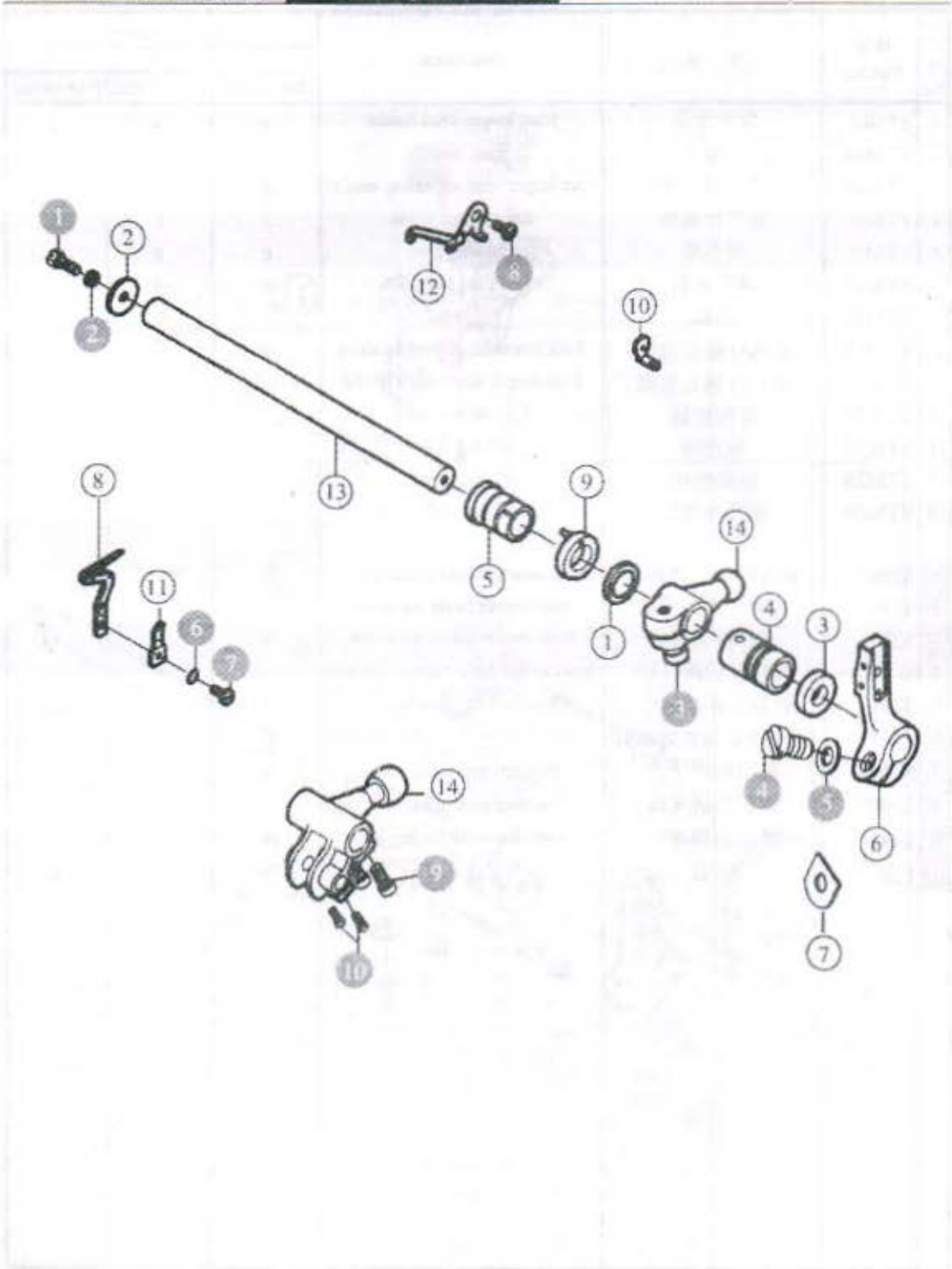


## 8. 下弯针部分 Lower looper assemblies

序号 No	件号 Part No	名称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTL15	厚垫圈	lower looper shaft copper bushing	1	1	0
	YTL11	厚垫圈	washer	0	0	1
2	YTL11	下弯针轴垫圈	lower looper shaft washer	1	1	1
3	YTL20	油封	oil seal	1	1	2
4	YTL21	下弯针前套筒	lower looper front bushing	1	1	1
5	YTL22	下弯针后套筒	lower looper rear bushing	1	1	1
6	YTL23	下弯针架	lower looper holder	1	1	1
7	YTL24	下弯针曲柄垫片	lower looper crank washer	2	2	5
8	YTL25	下弯针	lower looper	1	1	0
9	YTL32	铜垫圈	copper washer	1	1	1
10	YTL38	过线	thread guide	1	1	1
11	YTL43	下弯针过线	lower looper thread guide	1	1	1
12	YTL46	下弯针三孔过线	lower looper 3-thread thread guide	1	1	1
13	YTL57	下弯针轴	lower looper shaft	1	1	0
	YTL16	下弯针轴	lower looper shaft	0	0	1
14	YTL612	下弯针摆动曲柄	lower looper crank	1	1	0
	YTL09B	下弯针摆动曲柄	lower looper crank	0	0	1
1	S261	下弯针轴螺钉	lower looper shaft screw	1	1	1
2	W03	弹簧垫圈	elastic washer	1	1	1
3	S612	摆动曲柄螺钉	crank screw	1	1	1
4	S296	下弯针架螺钉	lower looper holder screw	1	1	1
5	W11	下弯针架垫圈	lower looper holder washer	1	1	1
6	W05	下弯针架垫圈	lower looper holder washer	1	1	1
7	S247	下弯针螺钉	lower looper screw	1	1	1
8	S257	下弯针过线螺钉	lower looper thread guide screw	1	1	1
9	S311	曲柄螺钉	crank screw	0	0	2
10	S229	曲柄螺钉	crank screw	0	0	2

注：零件样本图序号说明：○—代表零件；●—代表螺钉螺母。

八.下弯针部分 Lower looper assemblies

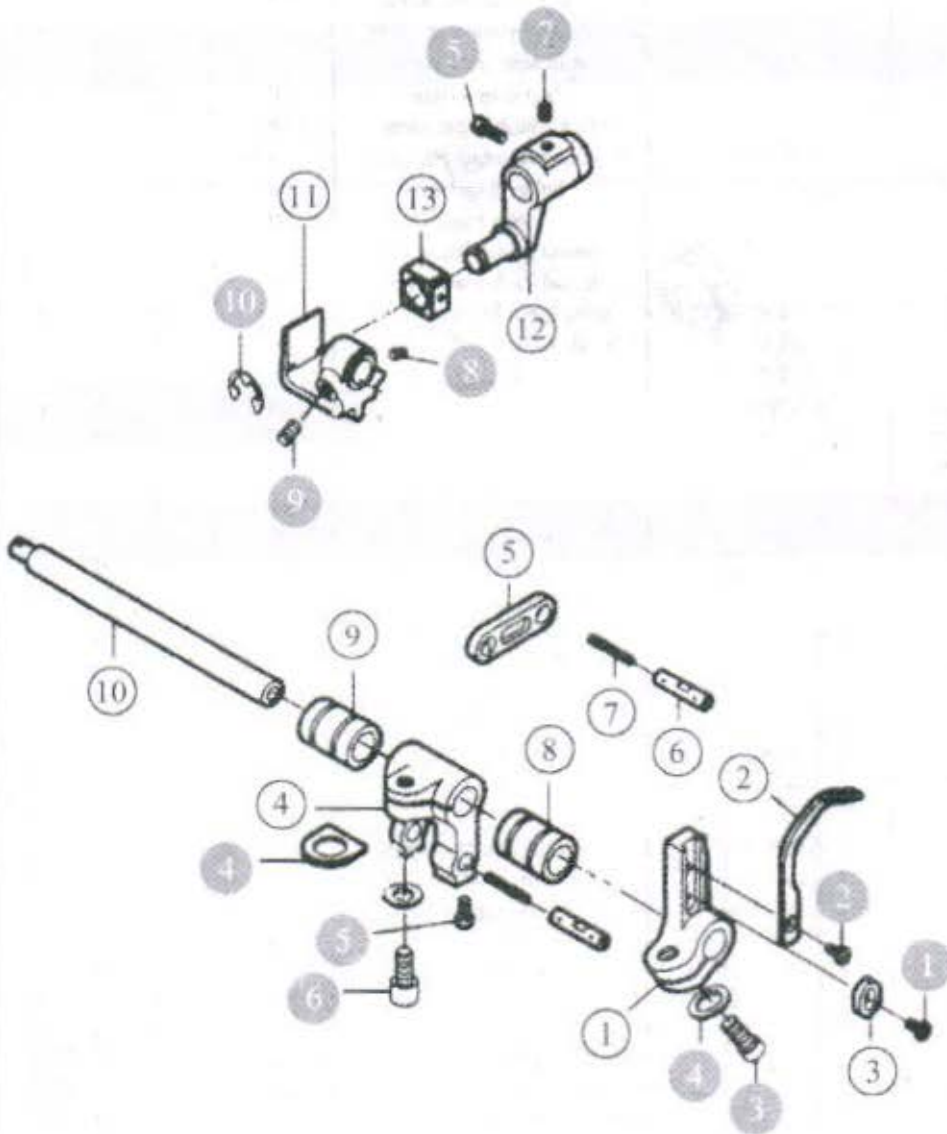


## 9.前弯针部分 Front lower looper assemblies

序号 No	件号 Part No	名称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTM01	前弯针架	front looper shaft holder	0	0	1
2	YTM04	前弯针	front looper	0	0	1
3	YTM06	前弯针调节垫片	front looper shaft regulating washer	0	0	1
4	YTM08	前弯针曲柄	front looper crank	0	0	1
5	YTM11	调节板	regulating plate	0	0	1
6	YTM12	调节板销	regulating plate pin	0	0	2
7	YTM15	油线	oil thread	0	0	2
8	YTM17	前弯针轴前套筒	front looper shaft front bushing	0	0	1
9	YTM18	前弯针轴后套筒	front looper shaft rear bushing	0	0	1
10	YTM26	前弯针轴	front looper shaft	0	0	1
11	YTM27	驱动座	driving lever	0	0	1
12	YTM28	驱动曲柄	driving crank	0	0	1
13	YTM29	前弯针滑块	front looper slide block	0	0	1
1	S209	前弯针调节垫螺钉	front looper thread guide screw	0	0	1
2	S230	前弯针固定螺钉	front looper guide set screw	0	0	1
3	S298	前弯针架螺钉	front looper holder set screw	0	0	1
4	W11	前弯针架螺钉垫	front looper holder screw washer	0	0	2
5	S251	前弯针曲柄螺钉	front looper crank screw	0	0	2
6	S295	前弯针曲柄紧固螺钉	front looper crank holder set screw	0	0	1
7	S270	驱动曲柄顶丝	hexagon socket set screw	0	0	1
8	S499	驱动曲柄顶丝	driving lever set screw	0	0	1
9	S441	驱动曲柄螺钉	driving lever set screw	0	0	1
10	E20	卡簧	snap ring	0	0	1

注：零件样本图序号说明：○—代表零件；●—代表螺钉螺母。

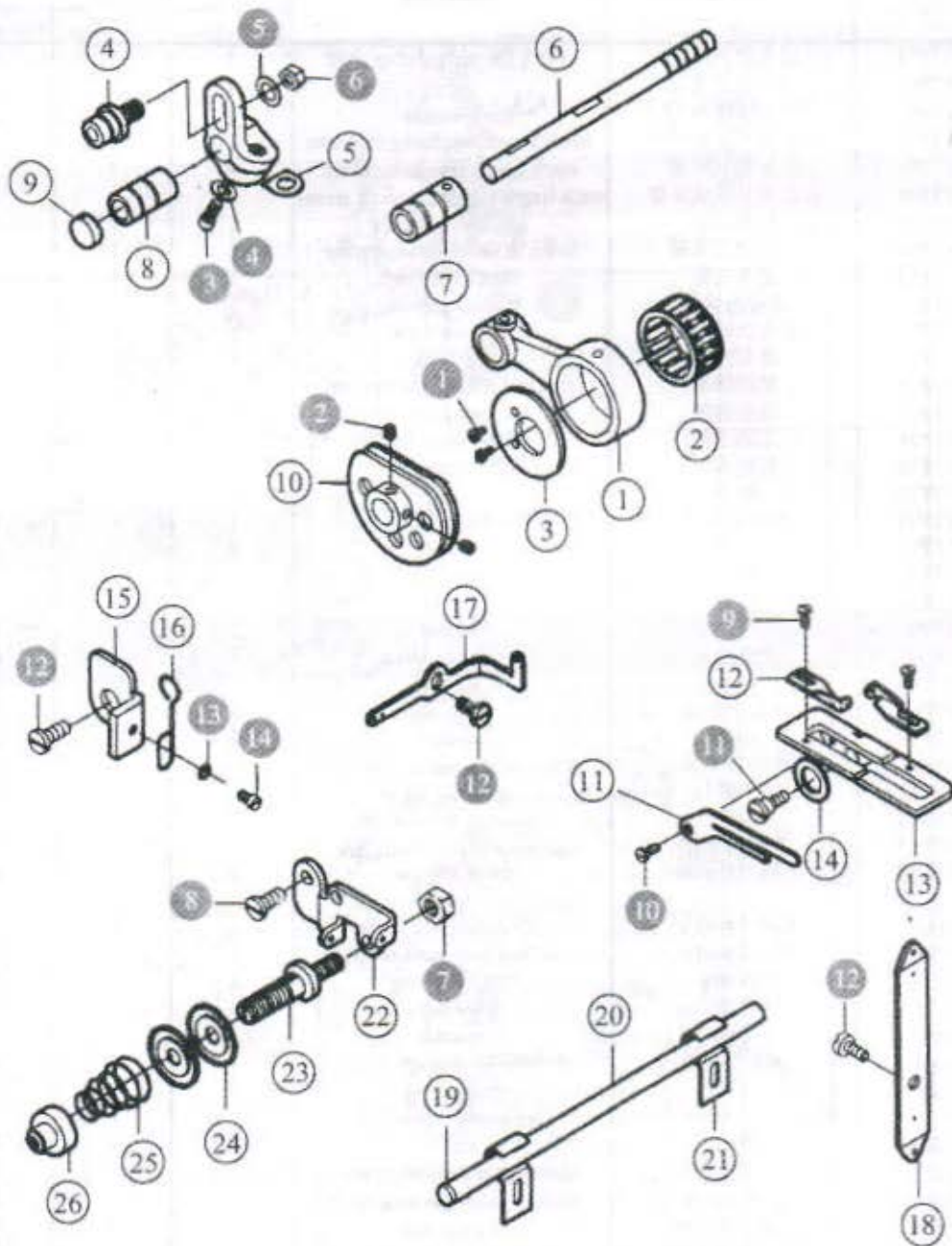
九.前弯针部分 Front lower looper assemblies



# 10.打线凸轮部分 Cam assemblies

序号 No	件号 Part No	名称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTN01	横轴连杆	bearing snap uing screw	0	0	1
2	YTN02	连杆滚针轴承	bear guide cam	0	0	1
3	YTN03	轴承挡圈	shaft snap crank screw	0	0	1
4	YTN05	曲柄销	shaft snap washer	0	0	1
5	YTL23	横轴曲柄	crank adjusting pin wather	0	0	1
6	YTN10	横轴曲柄轴	crank adjusting pin nut	0	0	1
7	YTN11	横轴右套筒	holder finger nut	0	0	1
8	YTN12	横轴左套筒	holder finger	0	0	1
9	YTN13	油封	thread guide plate screw	0	0	1
10	YTN18	打线凸轮	thread guide plate screw	0	0	1
11	YTN20	导线板	thread guide finger set screw	0	0	1
12	YTN22	过线板	thread guide for 2-thread screw	0	0	2
13	YTN24	导线架	washer	0	0	1
14	YTN26	波形垫圈	thread guide hook screw	0	0	1
15	YTN27	限位板		0	0	1
16	YTN29	过线环	thread guide hook	0	0	1
17	YTN32	二眼过线板	2-thread thread guide	0	0	1
18	YTN34	后导线板	rear thread guide finger set screw	0	0	1
19	YTN35	导线管套	thread guide tube bushing	0	0	2
20	YTN36	过线管	thread guide tube	0	0	1
21	YTN37	过线管压板	thread guide tube clamp	0	0	2
22	YTN38	压线器架	thead tension plate holder	0	0	1
23	YTN40	夹线挺	holder spool	0	0	1
24	YTN42	夹线片	holder spool	0	0	2
25	YTN43	夹线簧	holder spool spring	0	0	1
26	YTN44	调压螺母	presser nut	0	0	1
1	S205	轴承挡圈螺钉	bearing snap ring screw	0	0	2
2	S216	打线凸轮顶丝	cam set screw	0	0	2
3	S612	横轴曲柄垫圈	crank set screw	0	0	1
4	W11	横轴曲柄垫圈	crank washer	0	0	1
5	W04	曲柄调整销垫圈	crank adjusting pin wather	0	0	1
6	N25	曲柄调整螺母	crank adjusting pin nut	0	0	1
7	N26	夹线器架螺母	thead tension screw nut	0	0	1
8	S257	夹线器架螺钉	thead tension screw	0	0	1
9	S207	进线板螺钉	thread guide plate screw	0	0	2
10	S233	导线板螺钉	thread guide plate screw	0	0	1
11	S264	导线架固定螺钉	thread guide finger set screw	0	0	1
12	S250	二眼过线板螺钉	thread guide for 2-thread screw	0	0	3
13	W09	垫圈	washer	0	0	1
14	S238	过线环螺钉	thread guide hook screw	0	0	1

注：零件样本图序号说明：○—代表零件；●—代表螺钉螺母。

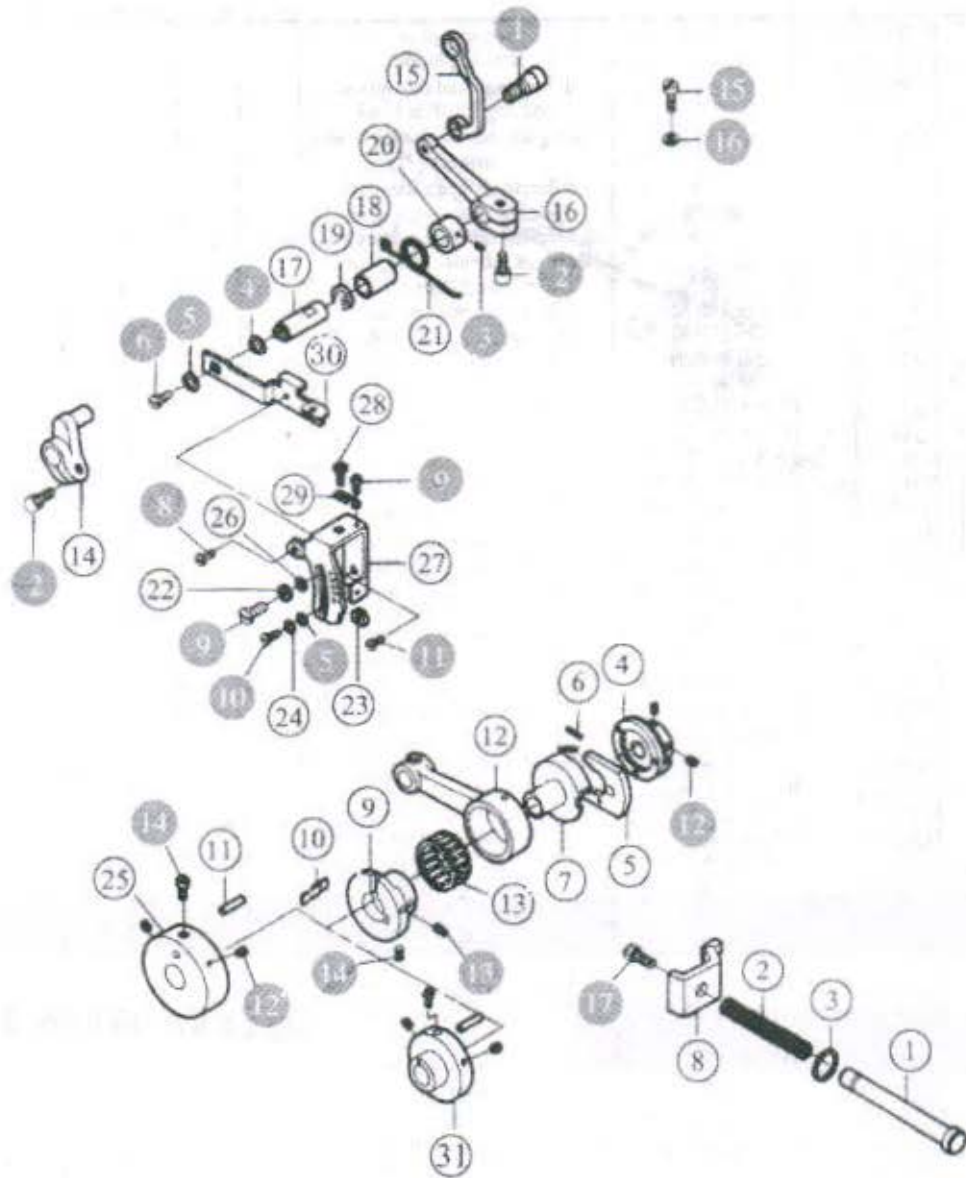


# 11.差动送布部分 Differential feed assemblies

序号 No	件号 Part No	名称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTP01	送布调节器杆	stitch length regulating shaft	1	1	1
2	YTP02	针距调节器簧	spring	1	1	1
3	YTP03	油泵垫圈	oil washer	2	2	2
4	YTP05	针距调节凸轮组件	stitch length regulating cam asm	1	1	1
5	YTP06	针距调节滑块	stitch length regulating block	1	1	1
6	YTP08	针距调节滑块压簧	stitch length regulating block spring	2	2	2
7	YTP09	针距凸轮	stitch length cam	1	1	1
8	YTP11	针距调节压板	stitch length regulating plate	1	1	1
9	YTP13	送布凸轮	feed length cam	1	1	1
10	YTP15	送布凸轮簧	feed cam spring	1	1	1
11	YTP18	送布凸轮座销	feed cam pin	1	1	1
12	YTP21	送布连杆	feed link	1	1	1
13	YTP22	滚动轴承	feed rod rolling pin bearing	1	1	1
14	YTP23	送布曲柄	feed crank	1	1	1
15	YTP25	差动连杆	differential link	1	1	1
16	YTP28	差动曲柄	differential crank	1	1	1
17	YTP30	销子	pin	1	1	1
18	YTP31	差动轴套筒	differential shaft bearing	1	1	1
19	YTP32	油封	oil seal	1	1	1
20	YTP33	挡圈	snap ring	1	1	1
21	YTP34	弹簧	spring	1	1	1
22	YTP35	垫圈	washer	1	1	1
23	YTP43	调节滑块	regulating block	1	1	1
24	YTP46	垫圈	washer	2	2	2
25	YTP59	送布凸轮座	feed cam	1	1	0
26	YTP60	垫圈	washer	1	1	1
27	YTP62	差动调节架	differential regulating holder	1	1	1
28	YTP63	调节螺钉	regulating screw	1	1	1
29	YTP64	卡簧	regulating screw spring	1	1	1
30	YTP65	差动调节杆	differential regulating link	1	1	1
31	YTP19	曲柄连杆凸轮	crank link cam	0	0	1
1	S452	差动连杆螺钉	differential link screw	1	1	1
2	S295	差动曲柄螺钉	differential crank screw	2	2	2
3	S251	挡圈螺钉	snap ring screw	1	1	1
4	W24	垫圈	washer	1	1	1
5	W01	垫圈	washer	2	2	2
6	S262	差动调节杆螺钉	differential position screw	1	1	1
7	S221	卡簧螺钉	spring screw	1	1	1
8	S259	差动调节架紧固螺钉	differential set screw	1	1	1
9	S399	螺钉	screw	1	1	1
10	S250	差动调节螺钉	differential regulating screw	1	1	1
11	S257	差动调节架螺钉	differential regulating screw	1	1	1
12	S270	针距调节凸轮螺钉	stitch length	4	4	4
13	S215	送布凸轮调节螺钉	feed cam regulating screw	1	1	1
14	S216	送布凸轮螺钉	feed cam screw	1	1	1
15	S266	螺钉	screw	1	1	1
16	S261	针距调节压板螺钉	stitch length screw	1	1	1

注：零件样本图序号说明：○—代表零件；●—代表螺钉螺母。

十一. 差动送布部分 Differential feed assemblies

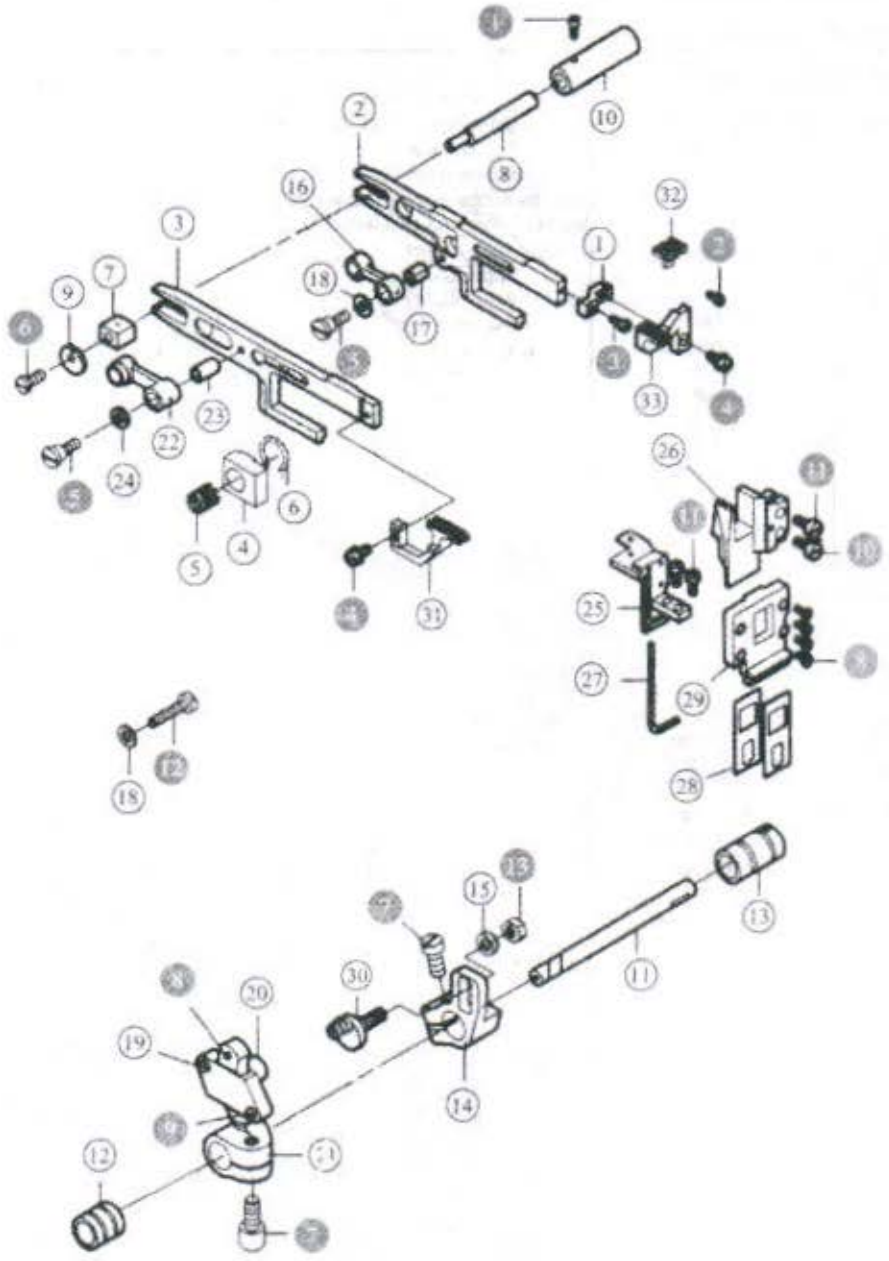


## 12. 抬牙送布部分 Feed dog assemblies

序号 No	件号 Part No	名称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTQ05	牙连接板	dog link plate	1	1	1
2	YTQ07	送布牙架	feed dog holder	1	1	1
3	YTQ10	差动牙架	differential feed dog holder	1	1	1
4	YTQ11	抬牙滑块	feed dog lift slide block	1	1	1
5	YTQ12	抬牙滑块滚针轴承	feed dog lift slide block shaft bearing	1	1	1
6	YTQ13	卡簧	snap ring	1	1	1
7	YTQ14	差动送布滑块	differential feed slide block	1	1	1
8	YTQ15	滑块偏心轮	slide block eccentric shaft	1	1	1
9	YTQ17	差动送布滑块偏心垫	differential feed slide block eccentric washer	1	1	1
10	YTQ19	滑块偏心轴套筒	slide block eccentric shaft bushing	1	1	1
11	YTQ21	送布轴	feed shaft	1	1	1
12	YTQ24	送布轴左套筒	feed shaft bushing(left)	1	1	1
13	YTQ25	送布轴右套筒	feed shaft bushing(right)	1	1	1
14	YTQ28	送布调整曲柄	feed regulating crank	1	1	1
15	YTQ31	垫圈	washer	1	1	1
16	YTQ33	送布牙架连杆	feed dog holder link	1	1	1
17	YTQ34	送布牙架连杆套	feed dog holder link bushing	1	1	1
18	YTQ35	送布牙架连杆套垫圈	differential feed dog holder link bushing	2	2	2
19	YTQ37	曲柄滑块盖板	crank slide block cover	1	1	1
20	YTQ38	曲柄滑块	crank slide block	1	1	1
21	YTQ39	差动牙架调节曲柄	feed regulating crank	1	1	1
22	YTQ40	差动牙架连杆	differential feed dog holder link	1	1	1
23	YTQ41	差动牙架连杆套	differential feed dog holder link bushing	1	1	1
24	YTQ42	差动牙架连杆套垫圈	differential feed dog holder link bushing washer	2	2	2
25	YTQ46	挡油板	screw oil plate	1	1	1
26	YTQ47	牙架导轨	feed dog carrier connection rod	1	1	1
27	YTQ48	密封圈	sealing connecting ring	1	1	1
28	YTQ49	活动油封	adjustable oil seal	2	2	2
29	YTQ50	密封导架	sealing connecting rod	1	1	1
30	YTQ90	送布牙架连杆偏心轴	feed dog link eccentric shaft	1	1	0
	YTQ30	送布牙架连杆偏心轴	feed dog link eccentric shaft	0	0	1
31	YTQ32-4	差动牙	differential dog	1	1	0
	YTQ32-5	差动牙	differential dog	0	0	1
32	YTQ43	辅送布牙	main feed dog	1	1	0
	YTQ44	辅送布牙	main feed dog	0	0	1
33	YTQ51	主送布牙	main feed dog	1	1	0
	YTQ52	主送布牙	main feed dog	0	0	1
1	S251	调牙套筒螺钉	regulating bushing	1	1	1
2	S209	辅助牙套筒螺钉	feed dog bushing screw	1	1	1
3	S245	牙架接板螺钉	screw	1	1	1
4	S576	主送布牙螺钉	main feed dog screw	2	2	2
5	S253	左右牙叉连杆螺钉	dog holder link	2	2	2
6	S212	抬牙布曲柄螺钉	feed dog lift slide block screw	1	1	1
7	S612	右送布曲柄螺钉	feed shaft crank screw(right)	2	2	2
8	S221	左曲柄螺钉	crank screw(left)	5	5	5
9	S343	曲柄滑动盖螺钉	crank slide block cover screw	2	2	2
10	S259	牙叉叉块螺钉 II	tooth rorks screw	1	1	1
11	S277	牙叉叉块螺钉 I	tooth rorks screw	4	4	4
12		螺钉	screw	1	1	1
13	N25	右送布曲柄销螺母	feed crank pin shaft nut	1	1	1

注：零件样本图序号说明：○—代表零件；●—代表螺钉螺母。

十二.拾牙送布部分 Feed dog assemblies

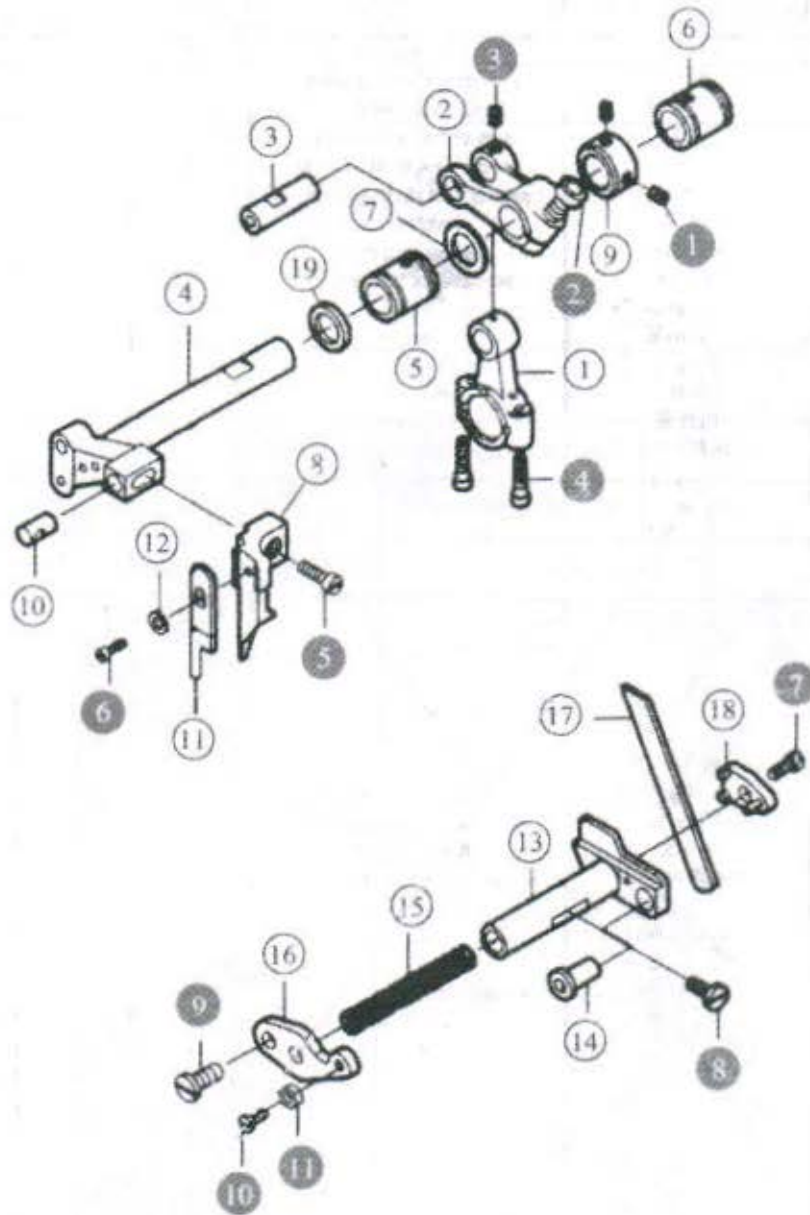


### 13. 剪切部分 Trimming assemblies

序号 No	件号 Part No	名称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTR01	上刀连杆	upper knife driving connecting link	1	1	1
2	YTR03	上刀曲柄	upper knife crank	1	1	0
	YTR04	上刀曲柄	upper knife crank	0	0	1
3	YTR07	曲柄销	crank pin	1	1	1
4	YTR09	上刀架轴	upper knife frame rock shaft	1	1	1
5	YTR12	上刀轴左套筒	upper knife frame rock shaft bushing left	1	1	1
6	YTR13	上刀轴右套筒	upper knife frame rock shaft bushing right	1	1	1
7	YTR14	垫圈	washer	1	1	1
8	YTR20	上刀座	upper knife holder	1	1	0
	YTR19	上刀座	upper knife holder	0	0	1
9	YTR21	挡圈	snap ring	1	1	1
10	YTR22	上刀架轴销	upper knife holder pin	1	1	1
11	YTR23	上刀	upper knife	1	1	1
12	YTR25	垫圈	washer	1	1	1
13	YTR27	下刀架	lower knife holder	1	1	0
	YTR26	下刀架	lower knife holder	0	0	1
14	YTR29	下刀架套筒	lower knife holder bushing	1	1	1
15	YTR32	下刀架弹簧	lower knife holder spring	1	1	1
16	YTR33	下刀架挡板	lower knife holder	1	1	1
17	YTR35	下刀	lower knife	1	1	1
18	YTR36	下刀压板	lower knife holder locking plate	1	1	1
19	F19	切刀轴外套油封	oil sealer	1	1	1
20	S293	挡圈螺钉	snap ring screw	2	2	2
21	S612	上刀曲柄紧固螺钉	upper knife crank set screw	1	1	1
22	S270	上刀曲柄销螺钉	upper knife crank pin screw	1	1	1
23	S385	上刀连杆螺钉	upper knife connecting link screw	2	2	2
24	S277	上刀座螺钉	upper knife holder screw	1	1	1
25	S246	上刀螺钉	upper knife screw	1	1	1
26	S261	下刀压板螺钉	lower knife holder locking plate screw	1	1	1
27	S258	下刀架螺钉	lower knife holder locking plate screw	1	1	1
28	S275	下刀挡板螺钉	lower knife snap plate screw	1	1	1
29	S241	下刀挡板螺钉	lower knife snap plate screw	1	1	1
30	N23	下刀挡板螺母	lower knife snap plate screw	1	1	1

注：零件样本图序号说明：○—代表零件；●—代表螺钉螺母。

十三. 剪切部分 Trimming assemblies

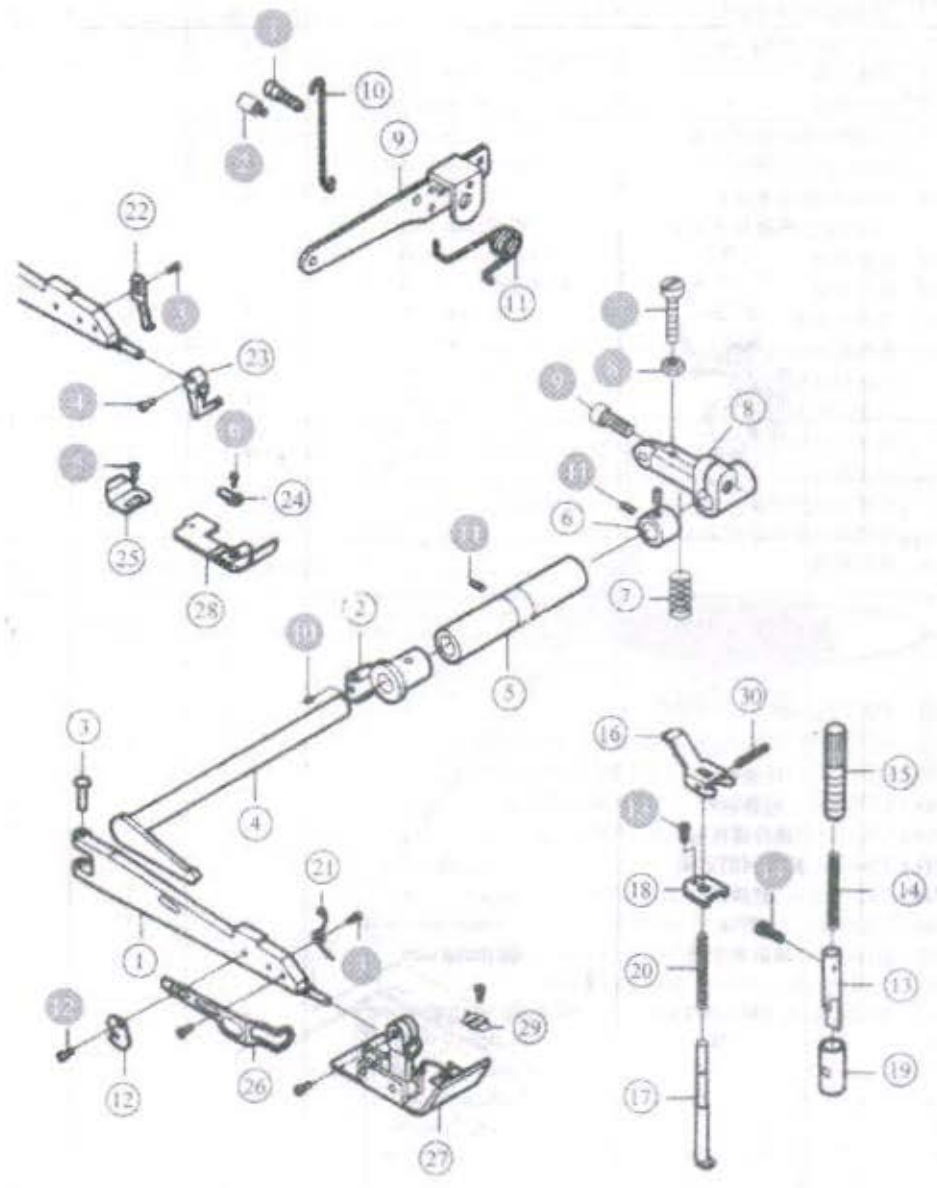


# 14. 压脚部分 Presser foot assemblies

序号 No	件号 Part No	名称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTS01	压脚架	presser foot holder	1	1	1
2	YTS02	压脚轴套	presser foot shaft bushing	1	0	1
3	YTS03	压脚架销	presser foot holder pin	1	1	0
4	YTS09	压脚架轴	presser foot holder shaft	1	1	1
5	YTS10	压脚轴套筒	presser foot shaft bushing	1	1	1
6	YTS12	压脚轴挡圈	presser foot shaft snap ring	1	1	1
7	YTS13	抬挡簧	lever spring	1	1	1
8	YTS14	压脚曲柄	presser foot crank	1	1	1
9	YTS18	压脚柄	presser foot lifting lever	1	1	1
10	YTS20	压脚柄勾	hook	1	1	1
11	YTS21	压脚柄簧	spring	1	1	1
12	YTS24	割线刀	thread cutting knife	1	1	1
13	YTS26	压杆	presser bar	1	1	1
14	YTS27	压杆簧	presser bar spring	1	1	1
15	YTS28	压杆螺钉	presser regulating screw	1	1	1
16	YTS29	压脚扳手	presser foot lifting handle	1	1	1
17	YTS30	压力簧导销	presser foot lifting pin	1	1	1
18	YTS31	压脚板手座	presser foot lifting handle bracket	1	1	1
19	YTS33	压杆套	presser bar bushing	1	1	1
20	YTS34	压力簧	presser foot lifting spring	1	1	1
21	YTS44	压脚弹簧	presser foot	1	1	1
22	YTS54	压脚架连接板	presser foot holder connecting plate	1	1	1
23	YTS56	压脚接柄	presser foot holder	1	1	1
24	YTS58	压脚小舌头簧片	presser foot base	1	1	1
25	YTS64	压脚底板簧片	presser foot	1	1	1
26	YTS65	压脚架护罩	presser foot holder cover	1	1	1
27	YTS66	压脚组件	presser foot form	0	1	0
28	YTS67	压脚底板	presser foot base	0	1	0
29	YTS68	小压脚	lifter presser foot	0	1	0
30	P04	抬压脚扳手销	presser foot lifting handle pin	1	1	1
1	S296	压脚柄勾螺钉	screw	1	1	1
2	S255	压脚柄勾定位螺钉	set screw	1	1	1
3	S219	压脚架连接板螺钉	presser foot holder connecting plate screw	2	2	2
4	S230	压脚接柄螺钉	presser foot holder screw	1	1	1
5	S208	压脚底板簧片螺钉	screw	1	1	1
6	S222	压脚舌头簧片螺钉	screw	1	1	1
7	S331	压脚曲柄螺钉	presser foot crank screw	1	1	1
8	N26	螺母	nut	1	1	1
9	S612	压脚曲柄定位螺钉	presser foot crank set screw	1	1	1
10	S20	压脚轴挡套圈螺钉	presser foot shaft snap washer screw	3	3	3
11	S21	螺钉	screw	1	1	1
12	S65	割线刀螺钉	thread cutting knife screw	2	2	2
13	S213	压脚扳手螺钉	presser foot lifting handle screw	1	1	1
14	S437	压杆螺钉	Presser bar screw	1	1	1

注：零件样本图序号说明：○—代表零件；※—代表螺钉螺母。

十四.压布部分 Presser foot assemblies

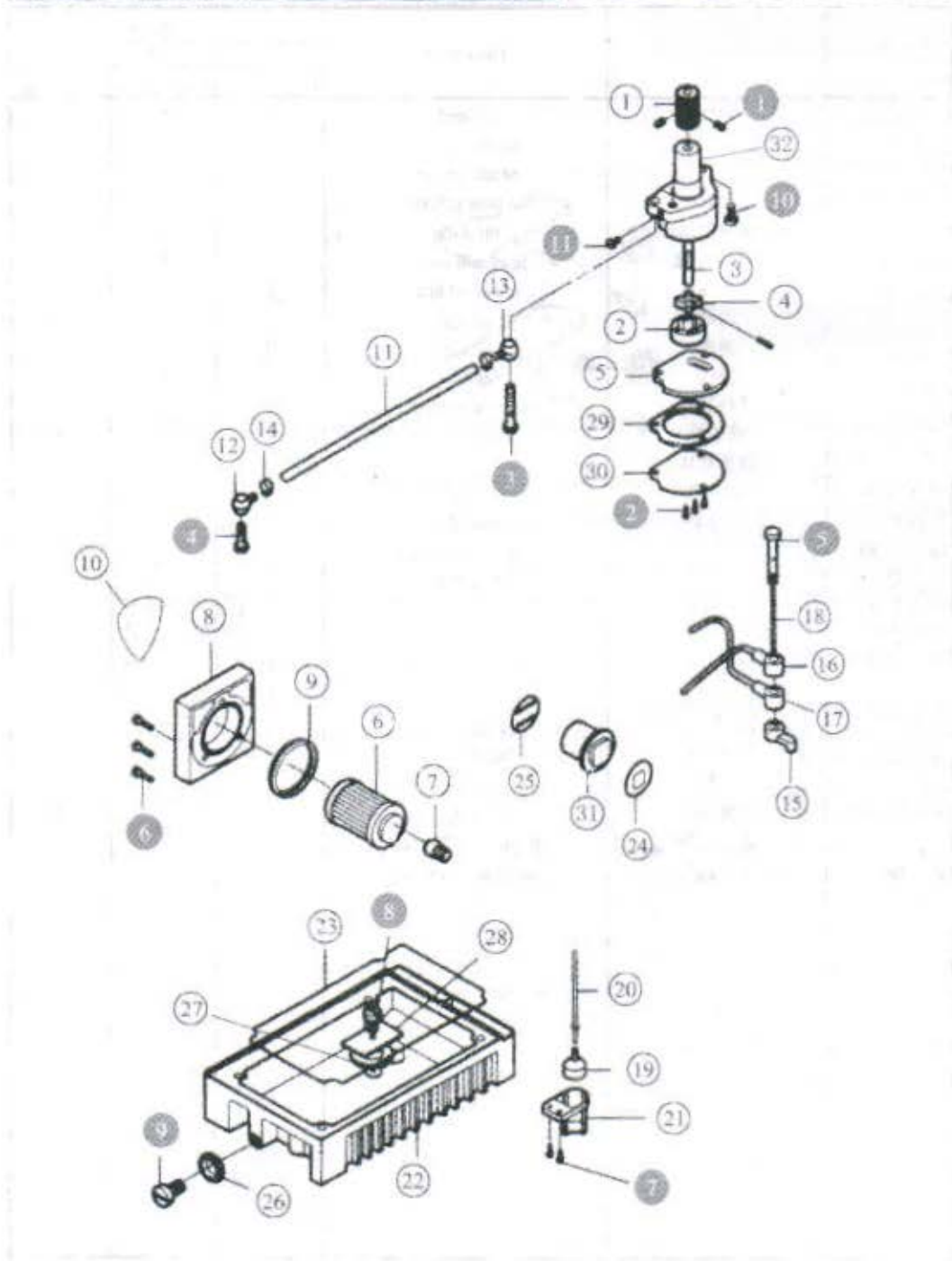


## 15. 润滑部分 Lubrication assemblies

序 号 No	件号 Part No	名 称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTT04	油泵蜗轮	oil pump worn gear	1	1	1
2	YTT06	油泵五星齿轮套	oil pump rotator bushing	1	1	1
3	YTT07	油泵齿轮长轴	oil pump rotator shaft	1	1	1
4	YTT09	油泵五星齿轮	oil pump rotator	1	1	1
5	YTT12	油泵罩板	oil pump cover plate	1	1	1
6	YTT14	滤油器	oil cleaner	1	1	1
7	YTT15	滤油器接头	oil cleaner joint	1	1	1
8	YTT16	滤油器盖	oil cleaner cover	1	1	1
9	YTT17	滤油器盖密封圈	oil cleaner cover seal ring	1	1	1
10	YTT18	润滑提示	indicating plate	1	1	1
11	YTT22	油管	oil tube	1	1	1
12	YTT24	油管接头 I	oil tube joint	1	1	1
13	YTT25	油管接头 II	oil tube joint	1	1	1
14	YTT26	油管卡簧	oil tube sharp ring	4	4	4
15	YTT38	润滑套	lubricate bushing	1	1	1
16	YTT39	上配油器	upper screen	1	1	1
17	YTT40	下配油器	lower screen	1	1	1
18	YTT41	调节销	regulating pin	1	1	1
19	YTT46	油量显示座	oil show bracket	1	1	1
20	YTT47	油量显示器杆	oil show cleaner link	1	1	1
21	YTT49	油量显示支架	oil show cleaner guard	1	1	1
22	YTT51	油盘	oil pan	1	1	1
23	YTT52	油盘垫圈	oil pan washer	1	1	1
24	YTT54	游标不干胶	sticker	1	1	1
25	YTT55	游标刻度	oil dial	1	1	1
26	YTT56	堵油垫圈	oil seal	1	1	1
27	YTT57	油盘磁铁	oil pan magnet	1	1	1
28	YTT58	油盘磁铁盖	oil pan magnet cover	1	1	1
29	YTT64	滤油网固定架	oil screen holder	1	1	1
30	YTT65	滤油网	oil screen felt	1	1	1
31	YTT74	游标	vernier bow	1	1	1
32	YTT03	油泵体组件	oil pump asm	1	1	1
1	S292	油泵蜗轮螺钉	oil pump worn gear screw	2	2	2
2	S245	滤油网螺钉	oil cleaner screw	3	3	3
3	S419	油管接头 II 螺钉	oil tube joint screw	1	1	1
4	S304	油管接头 I 螺钉	oil tube joint screw	1	1	1
5	S286	配油器螺钉	oil screen screw	1	1	1
6	S265	滤油器盖螺钉	oil screen cover screw	3	3	3
7	S269	油量显示器支架螺钉	oil bow finger screw	2	2	2
8	S262	油盘磁铁盖螺钉	oil pan magnet cover screw	1	1	1
9	S310	油盘放油螺钉	oil pan oil screw	1	1	1
10	S278	油泵螺钉	oil pump screw	1	1	1
11	S308	油泵体螺钉	oil pumps asm screw	1	1	1

注：零件样本图序号说明：○—代表零件；●—代表螺钉螺母。

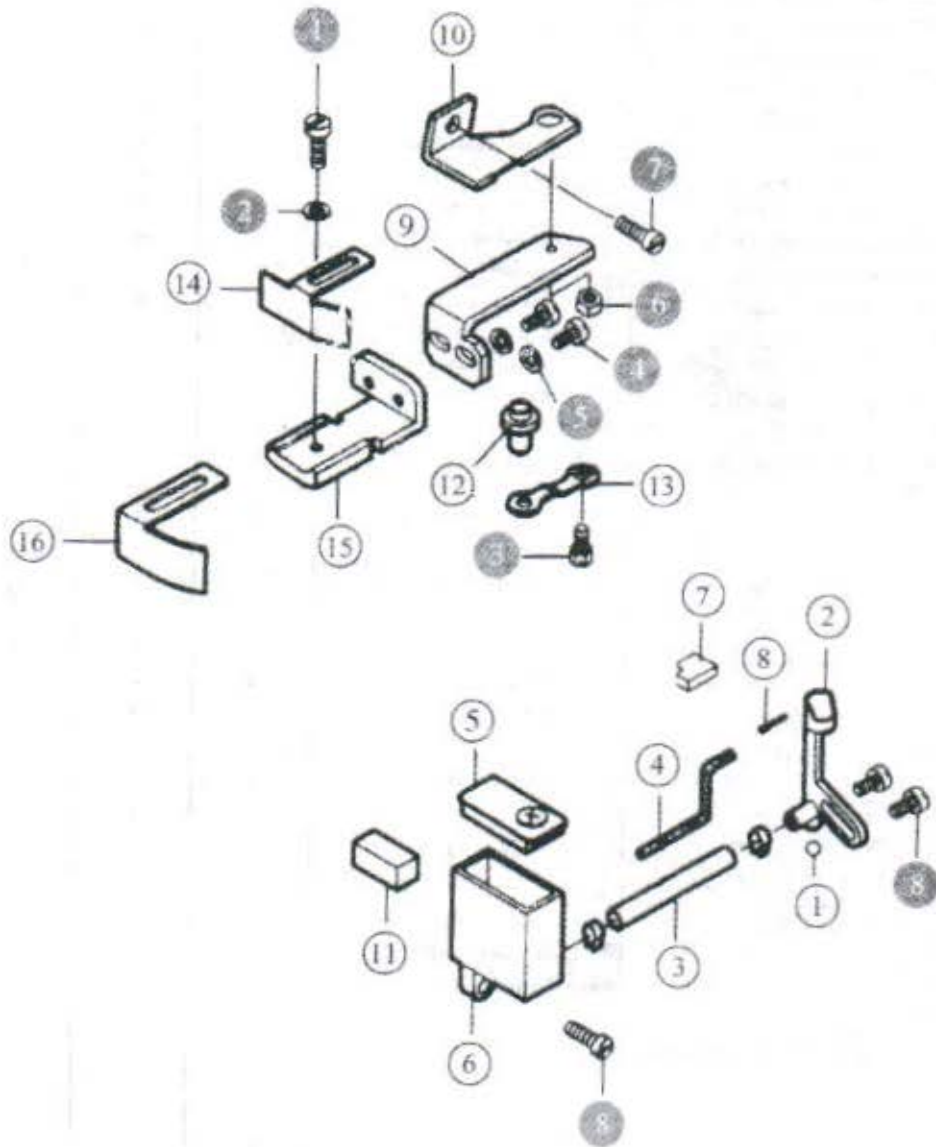
十五. 润滑部分 Lubrication assemblies



## 16.送布挡料部分 Feed snap assemblies

序号 No	件号 Part No	名称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTV02	油堵	oil seal	1	1	1
2	YTV14	机针冷却器	needle cooler	1	1	0
	YTV15	机针冷却器	needle cooler	0	0	1
3	YTV20	油管	oil tube bracket	1	1	1
4	YTV21	硅油冷却油线	oil wick	1	1	1
5	YTV22	下硅油盒盖	lower oil cover	1	1	1
6	YTV23	下硅油盒	lower oil box	1	1	1
7	YTV24	油棉	oil felt	1	1	0
	YTV25	油棉	oil felt	0	0	1
8	YTV26	油线	oil wick	1	1	1
9	YTV28	送料支架	cloth guide holder	1	1	1
10	YTV27	铰链板	hinge plate	1	1	1
11	YTV29	硅油棉块	oil felt block	1	1	1
12	YTV34	铰链销	hinge pin	1	1	1
13	YTV35	铰链弹簧片	snap plate	1	1	0
14	YTV40	挡料板	snap plate bracket	1	1	1
15	YTV43	挡料板座	snap plate	1	1	1
16	YTV39	挡料板	snap plate	0	0	1
1	S266	挡料板螺钉	snap plate screw	1	1	1
2	P46	垫圈	washer	1	1	1
3	S239	铰链簧螺钉	hinge spring screw	1	1	1
4	S246	铰链螺钉	hinge screw	2	2	2
5	W09	垫圈	washer	2	2	2
6	N26	螺母	nut	1	1	1
7	S277	送料支架	cloth guide holder screw	1	1	1
8	S262	机针冷却器螺钉	needle cooler screw	3	3	3

注：零件样本图序号说明：○—代表零件；◎—代表螺钉螺母。

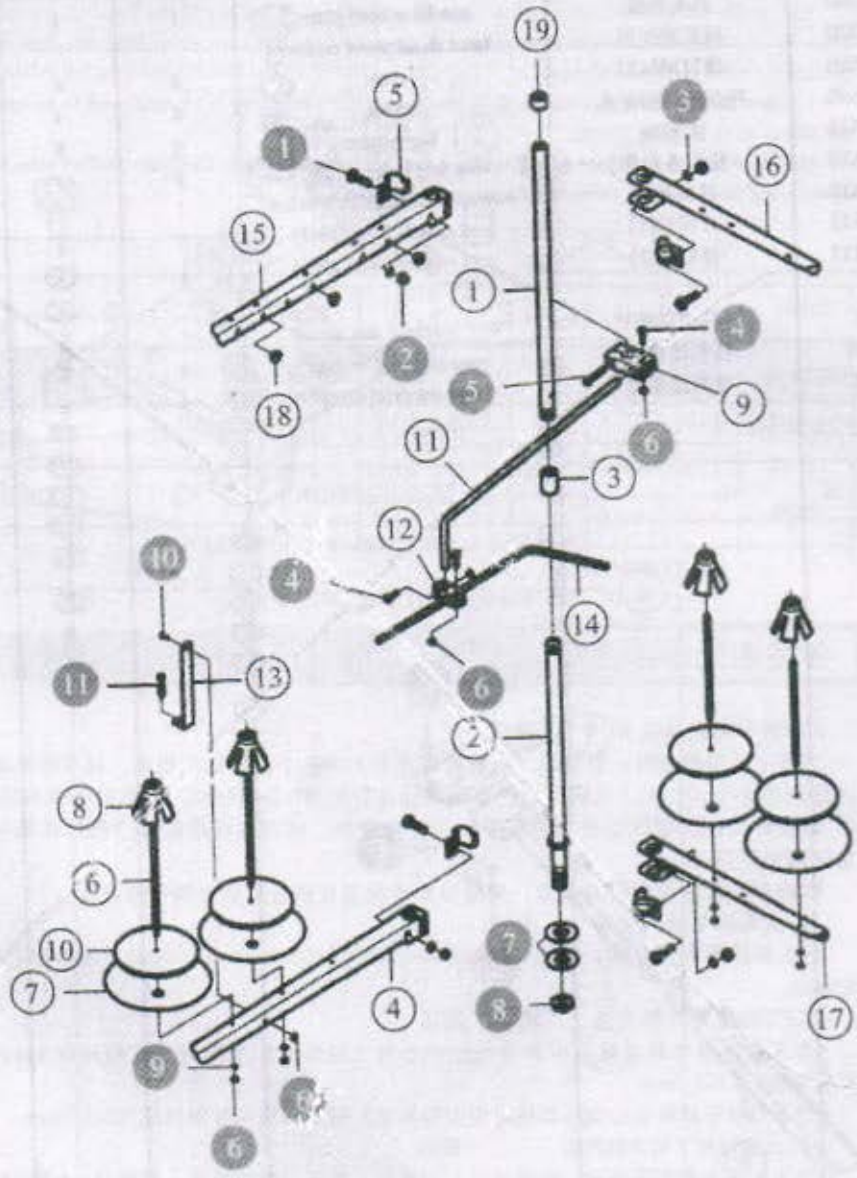


## 17.线架部分 Thread spool assemblies

序号 No	件号 Part No	名称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTW01	上管	upper thread colum	1	1	1
2	YTW02	下管	lower thread colum	1	1	1
3	YTW03	套	bushing	1	1	1
4	YTW04	长托线架	long thread spool tray bracket	1	1	1
5	YTW05	导线环	thread guide hook	4	4	4
6	YTW09	线托棒	spool pin	3	4	5
7	YTW12	线盘	spool tray	3	4	5
8	YTW13	线圈定位套	centering device	3	4	5
9	YTW14	棒架	clamp plate	1	1	1
10	YTW15	线圈垫	spool tray cushion	3	4	5
11	YTW17	导线棒	thread guide connecting bar	1	1	1
12	YTW20	固定器	thread guide joint	1	1	1
13	YTW22	固定板	thread stable holder	1	1	1
14	YTW23	导线棒	thread guide bar	1	1	1
15	YTW26	大导线棒	thread spool tray bracket	1	1	1
16	YTW28	过线板	thread guide plate	1	1	1
17	YTW29	托线架	thread spool tray bracket	1	1	1
18	YTW32	过线环	thread guide hook	3	3	3
19	YTW36	棒帽	rubber seal	1	1	1
1	S421	导线环螺钉	thread guide hook screw	4	4	4
2	N31	导线环螺母	thread guide hook screw	4	4	4
3	S01	导线环垫圈	thread guide washer	4	4	4
4	S386	棒架螺钉	clamp plate screw	3	3	3
5	S281	棒架螺钉	clamp holder screw	1	1	1
6	N29	螺母	nut	8	8	8
7	W25	下管垫圈	lower washer	2	2	
8	N30	螺母	nut	1	1	1
9	S04	垫圈	nut	4	4	4
10	S420	固定板螺钉	thread stand holder screw	1	1	1
11	S422	固定板连接螺钉	thread stand holder joint screw	1	1	1

注: 零件样本图序号说明: ○—代表零件; ●—代表螺钉螺母。

十七. 线架部分 Thread spool assemblies

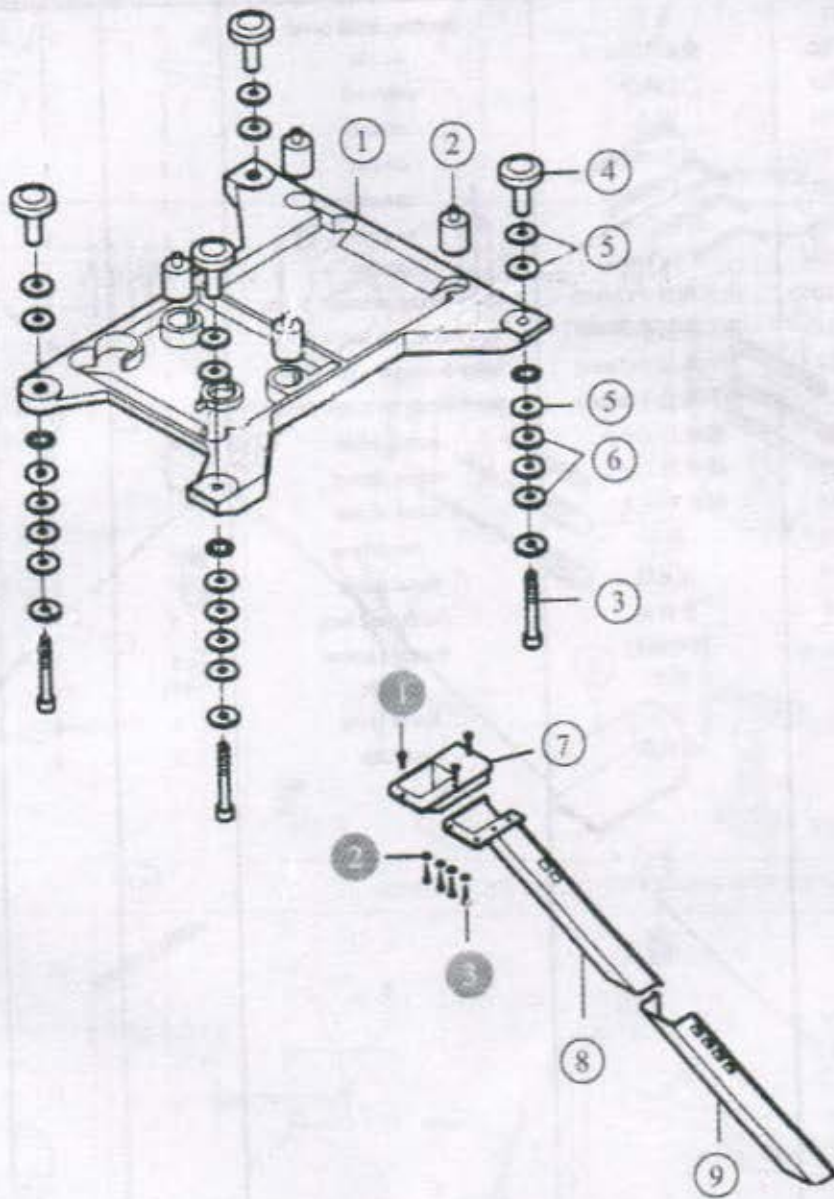


## 18. 托盘、排料部分 Tray, row material assemblies

序号 No	件号 Part No	名称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTX01	机头托盘	machine head plate	1	1	1
2	YTX02	减震垫组件	head shockproof cushion			
3	YTX04	螺钉M8x55	screw	4	4	4
4	YTX05	托盘螺钉固定头	screw	4	4	4
5	YTX08	大垫圈	big washer	8	8	8
6	YTX09	托盘连接套	tray dog link bushing	4	4	4
7	YTX10	排料槽座	row material troligh bracket	1	1	1
8	YTX12	排料槽(1)	row material troligh(1)	1	1	1
9	YTX13	排料槽(2)	row material troligh(2)	1	1	1
1	S391	排料槽座螺钉	row material seat screw	3	3	3
2	SW21	排料槽垫圈	row material washer	4	4	4
3	S392	排料槽螺钉	row material screw	4	4	4

注：零件样本图序号说明：○—代表零件；◎—代表螺钉螺母。

十八. 托盘排料部分 Fray assemblies



19. 随机附件部分 Accessories

序号 No	件号 Part No	名称	Description	数量 (Number)		
				三线	四线	五线
				Three-thread	Four-thread	Five-thread
1	YTY01	机罩	machine head cover	1	1	1
2	YTY02	油壶/100cc	oil can	1	1	1
3	YTY03	注油壶	notes oil	1	1	1
4	YTY04	漏斗	tundish	1	1	1
5	YTY05	油壶/50cc	oil can	1	1	1
6	YTY07	扳手(6mm)	spanner	1	1	1
7	YTY08	扳手(7mm)	spanner	1	1	1
8	YTY09	扳手(8mm)	spanner	1	1	1
9	YTY10	内六角扳手(2mm)	inner-hexagon screw driver	1	1	1
10	YTY11	内六角扳手(3mm)	inner-hexagon screw driver	1	1	1
11	YTY12	内六角扳手(5mm)	inner-hexagon screw driver	1	1	1
12	YTY13	内六角扳手(6mm)	inner-hexagon screw driver	1	1	1
13	YTY14	螺丝刀(小)	screw driver	1	1	1
14	YTY15	螺丝刀(中)	screw driver	1	1	1
15	YTY16	螺丝刀(大)	screw driver	1	1	1
16	YTY18	镊子	tweezer	1	1	1
17	YTY19	金属线	metal guide	1	1	1
18	YTY26	附件盒	attachment box	1	1	1
19	S216	顶针螺钉	thumble screw	1	1	1
20	DC27	机针	needle	1包	1包	1包
21	R35	下刀	lower knife	1	1	1
22	T14	过滤器	oil filter	1	1	1

注：零件样本图序号说明：○—代表零件；●—代表螺钉螺母。

