



中国·中捷缝纫机股份有限公司
ZOJE SEWING MACHINE CO., LTD.
地址: 浙江玉环大麦屿开发区
ADD: DAMAIYU ZONE, YUHUAN ZHEJIANG, 317604 CHINA
免费咨询电话: TEL: 800-857-6715



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超 高 速 包 缝 机

ZJ900系列

SUPER HIGH-SPEED OVERLOCK SEWING MACHINE

使 用 说 明 书 零 件 手 册

OPERATION MANUAL
PARTS BOOK



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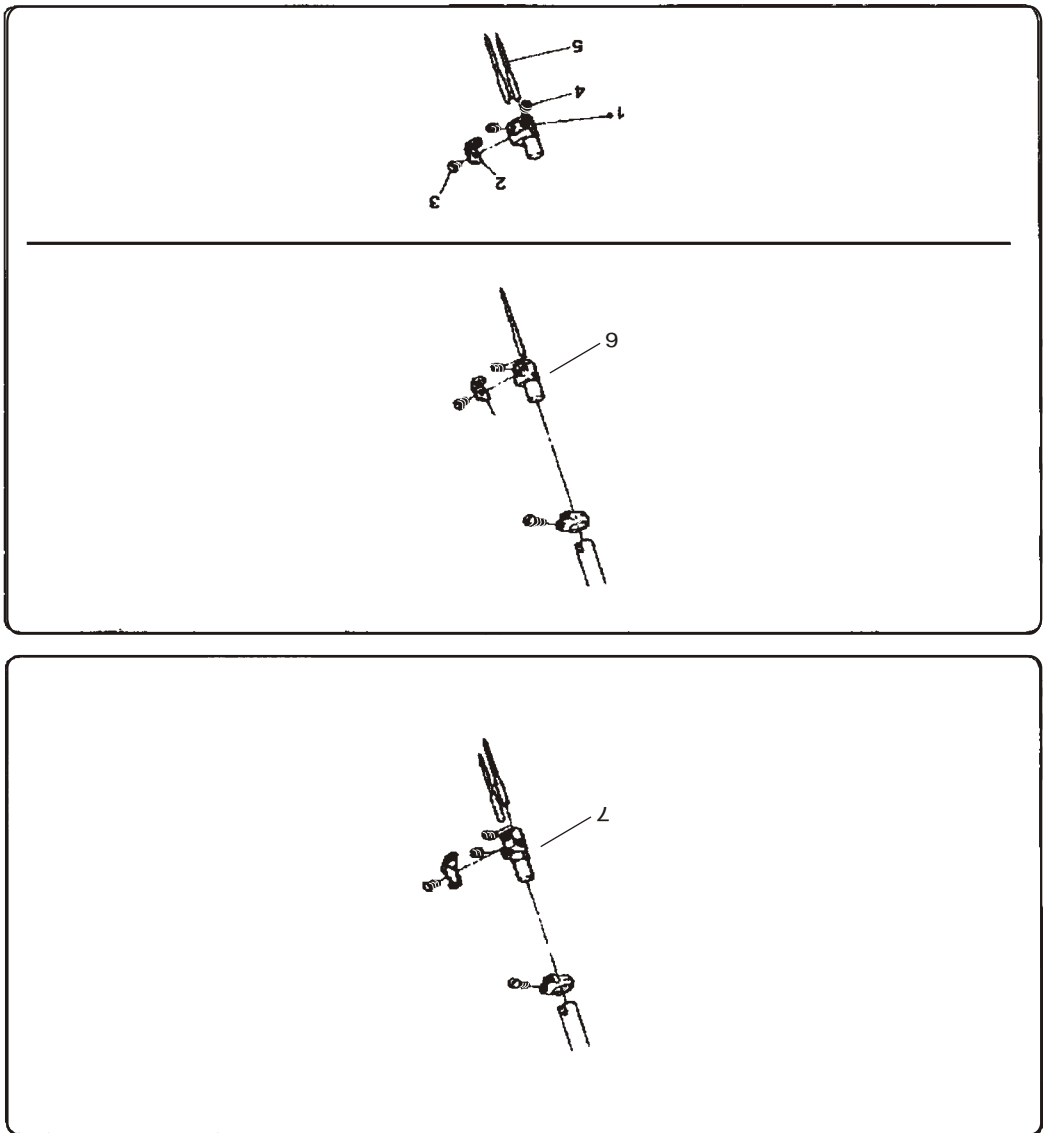
序号	件号	名称	NAME OF PARTS	数量
1	Z-91-102094-05	针杆传动轴	drive shaft for needle bar	1
2	Z-91-102211-05	垫圈	washer	1
3	Z-12-606007-15	挡圈	retaining ring	1
4	Z-91-102294-05	挡圈	retaining ring	1
5	Z-91-101066-15	螺钉	screw	1
6	Z-91-102078-05	针杆传动曲柄	crank on needle bar drive shaft	1
7	Z-91-101137-15	螺钉	screw	1
8	Z-91-102312-05	直针连杆销	pin for connecting rod	1
9	Z-91-101136-15	螺钉	screw	1
10	Z-91-102073-05	直针传动连杆	connecting rod for needle bar drive	1
11	Z-91-102310-15	螺钉	screw	2
12	Z-91-102097-05	直针曲柄	crank for needle bar	1
13	Z-91-101078-15	螺钉	screw	1
14	Z-91-102099-05	直针曲柄销	bush with thread	1
15	Z-91-102100-05	油线	oil wick	1
16	Z-91-102101-85	针杆	needle bar	1
17	Z-91-102102-05	针杆套	needle bar bush	1
18	Z-91-102104-75-004	O型圈	O ring	1
19	Z-91-101136-15	螺钉	screw	1
20	Z-91-102103-05	针杆套毛毡	felt for needle bar bush	1
21	Z-91-102295-15	针杆头夹	needle ban clamp	1
22	Z-91-102300-15	螺钉	screw	1

10、针杆机构（1）/NEEDLE BAR FRAME（1）

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序号	件号	名称	NAME OF PARTS	数量
1	Z-91-102301-05	针夹头	needle holder	1
2	Z-91-102302-35	针夹头过线板	thread guide plate of needle holder	1
3	Z-91-102303-15	螺钉	screw	1
4	Z-91-101468-15	螺钉	screw	2
5	Z-99-008012-35	机针	nddle	1
6	Z-91-102414-05	针夹头	needle holder	1
7	Z-91-102388-05	针夹头	needle holder	1

11、针杆机构（2）/NEEDLE BAR FRAME（2）



11、针杆机构（2）/NEEDLE BAR FRAME（2）



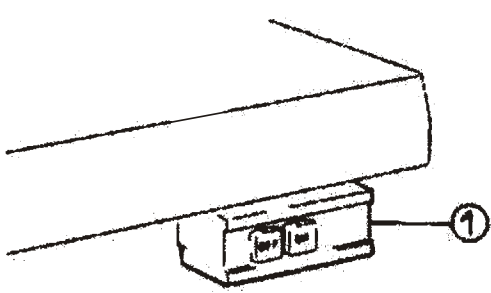
为了安全

对于缝纫机本身及各种装置，我们充分考虑到它的安全性。请遵照基本的操作方法，安全的进行工作

- 拆除为保证安全所设置的装置、零件的情况下使用，是非常危险的，请绝对不要拆除后使用。
- 缝纫机在使用时，请不要在缝纫机台板上放置工具及缝纫时不必要的物品。
- 在对缝纫机进行检修、调节、清扫、穿线、换针等时，为防止发生事故，务必请切断电源。在确定即使踩缝纫机踏板，缝纫机也不动之后，再进行操作。

注意

使用离合式马达的情况下，在关掉电源①后因惯性作用马达仍会继续旋转。这时如不注意踩动缝纫机踏板②时，缝纫机会突然动作，这是很危险的。请在关掉电源后，仍继续踩动踏板②，直至缝纫机完全停下来为止。



- 在离开缝纫机台时，务必请关掉电源。
- 停电时也请务必关掉电源。
- 为了总是安全地、运转良好的使用缝纫机，H常的检点是不可缺少的。请予以注意。



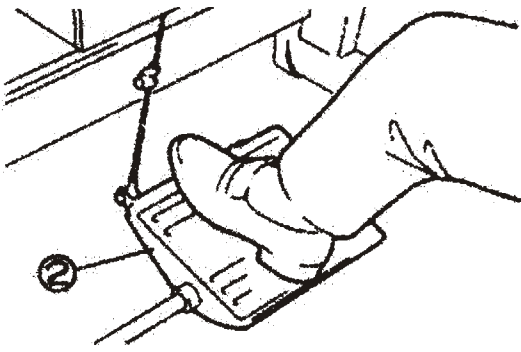
CAUTION

OBSERVE THESE SAFETY PRECAUTIONS
Though Pegasus takes the utmost care to produce safe sewing machines and devices, operstors should follow these basic safety rules.

- To prevent accidents,do not remove safety devices or parts while operating the machine.
- Do not leave tools or other unnecessary objects on the machine table while operating the machine.
- Before maintenance,adjusting,cleaing, threading or replacing the needle,and to prevent accidents,be sure the power is turned off.Check that the machine will not operate when the pedal is pressed.

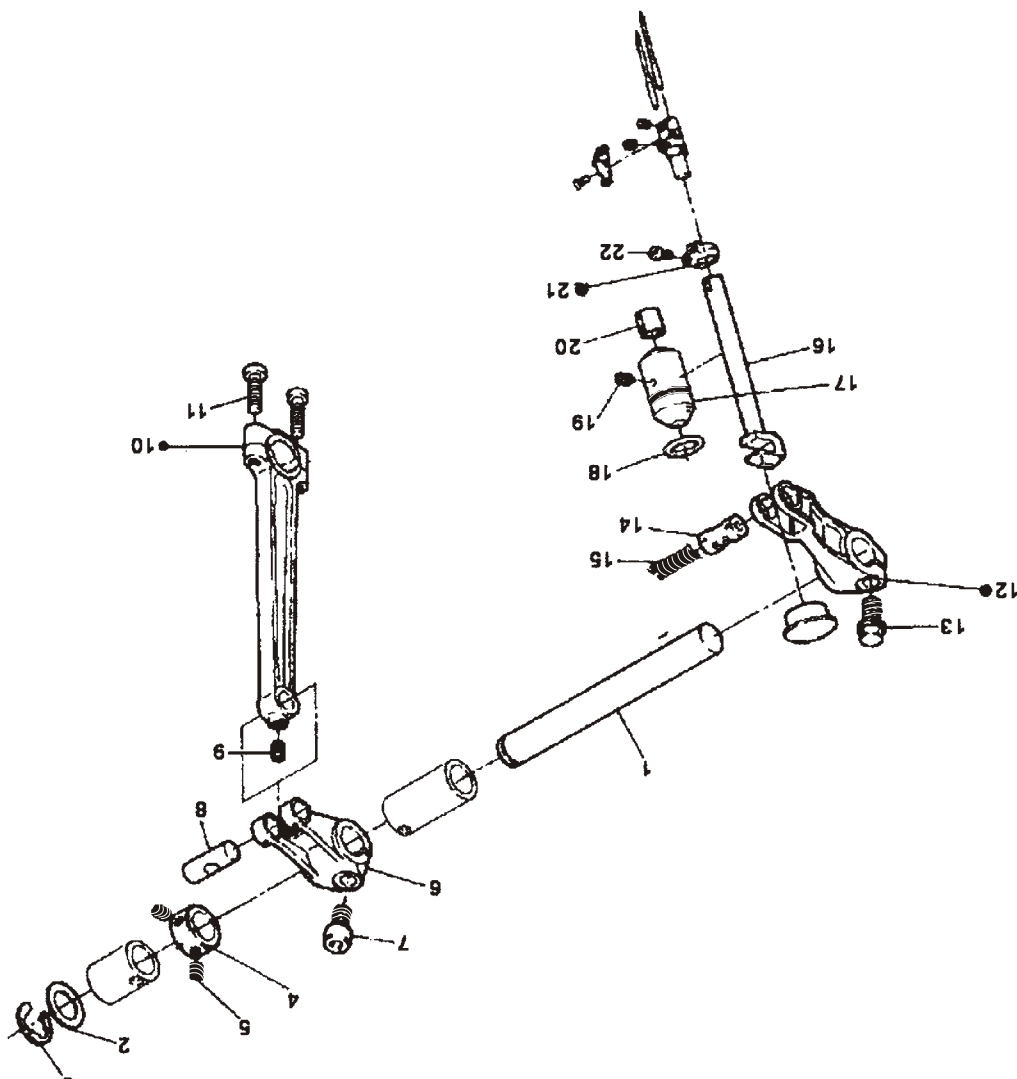
Note

Incase a clutch type motor is used,it will keep on rotating by inertia after turning off power supply.①If the machine pedal ②is stepped on inadvertently,it is dangerous because the machine will move unexpectedly.keep on stepping on the pedal ② until the machine comes to a stop after tuming off power supply.



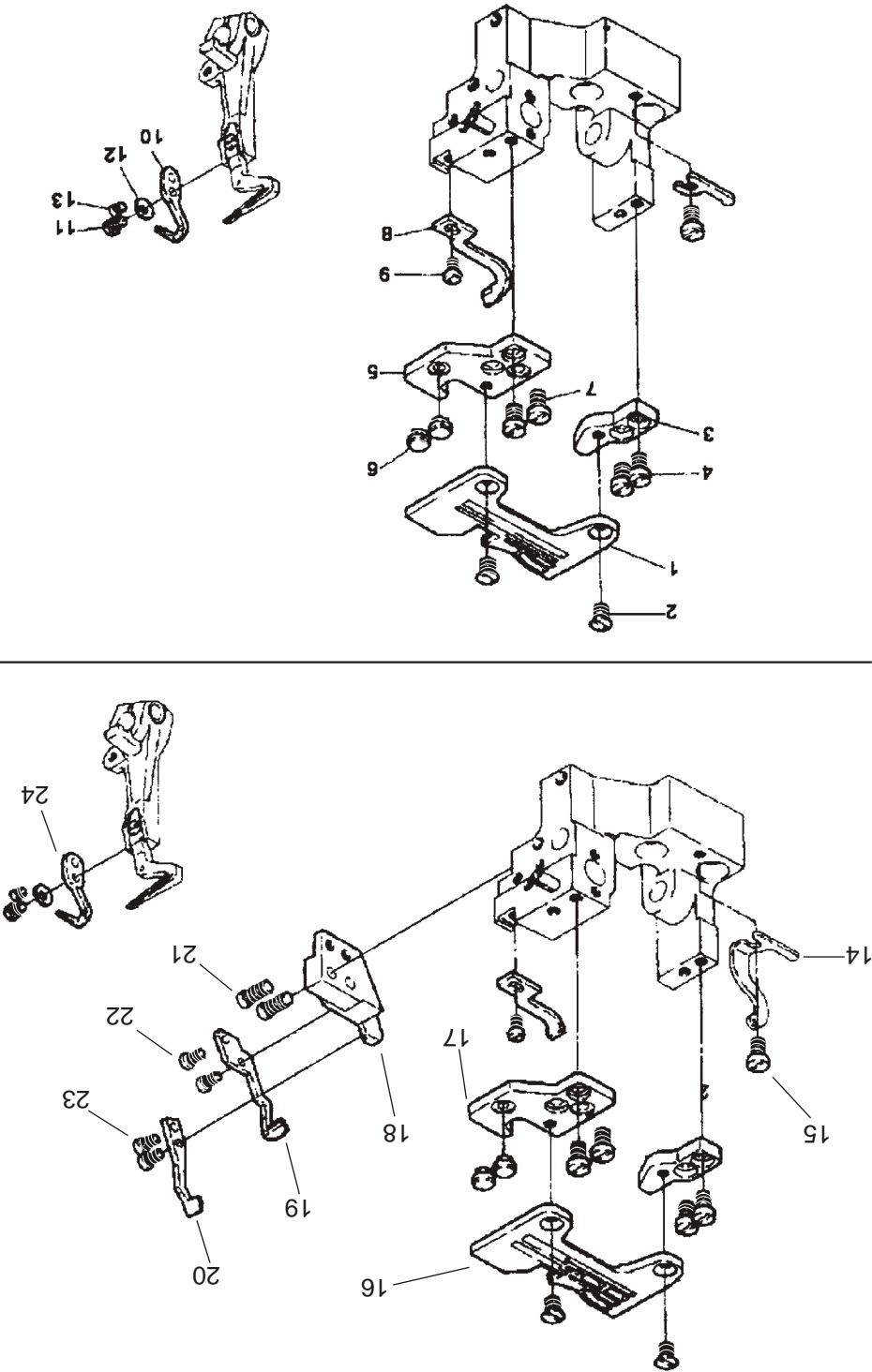
- Tum the power off before leaving the machine table.
- In the event of a power failure,be sure to tum the machine off.
- Check that the machine is securely grounded.

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10、针杆机构 (1) /NEEDLE BAR FRAME (1)

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12、针杆机构 (3) /NEEDLE BAR FRAME (3)

932标准零件表

932 GAUGE PARTS LIST



序号	名 称	型 号	针 板	主送料牙组件	主送料牙	辅送料牙	差送料牙	压脚组件	吐线舌	上弯针
9	超高速五线包缝机(普通)	932-38	Z-91-102387-35	Z-91-102412-91	Z-91-102348-05	Z-91-102178-05	Z-91-102382-05	Z-91-102383-91		Z-91-102304-05
10	超高速五线宽边包缝机	932-70	Z-91-102346-35	Z-91-102412-91	Z-91-102348-05	Z-91-102178-05	Z-91-102349-05	Z-91-102368-91		Z-91-102304-05
11	超超高速五线厚料包缝机	932-86	Z-91-102487-35	Z-91-102494-91	Z-91-102500-05	Z-91-102503-05	Z-91-102506-05	Z-91-102582-91		Z-91-102522-05
12	超高速六线包缝机(普通)	932-355	Z-91-102598-35	Z-91-102495-91	Z-91-102501-05	Z-91-102178-05	Z-91-102349-05	Z-91-102596-91		Z-91-102304-05
13	超高速六线厚料宽边包缝机	932-365	Z-91-102489-35	Z-91-102494-91	Z-91-102502-05	Z-91-102503-05	Z-91-102506-05	Z-91-102517-91		Z-91-102522-05

932标准零件表

932 GAUGE PARTS LIST



序号	名 称	型 号	下 弯 针	链弯针	上 刀	下 刀	前 护 针	后 护 针	针 夹	机 针
9	超高速五线包缝机 (普通)	932-38	Z-91- 102306-05	Z-91- 102338-05	Z-91- 101495-95	Z-91- 101496-05	Z-91- 102345-05	Z-91- 102130-05	Z-91- 102388-05	DC× 27#14
10	超高速五线宽边包缝机	932-70	Z-91- 102306-05	Z-91- 102338-05	Z-91- 101495-95	Z-91- 101496-05	Z-91- 102345-05	Z-91- 102130-05	Z-91- 102350-05	DC× 27#14
11	超超高速五线包料包缝机	932-86	Z-91- 102306-05	Z-91- 102523-05	Z-91- 102524-95	Z-91- 102525-95	Z-91- 102345-05	Z-91- 102130-05	Z-91- 102526-05	DC× 27#21
12	超高速六线厚料包缝机 (普通)	932-355	Z-91- 102306-05	Z-91- 102338-05	Z-91- 101495-95	Z-91- 101496-05	Z-91- 102345-05	Z-91- 102130-05	Z-91- 102603-05	DC× 27#11
13	超高速六线厚料宽边包缝机	932-365	Z-91- 102306-05	Z-91- 102523-05	Z-91- 102524-95	Z-91- 102525-95	Z-91- 102345-05	Z-91- 102130-05	Z-91- 102528-05	DC× 27#21

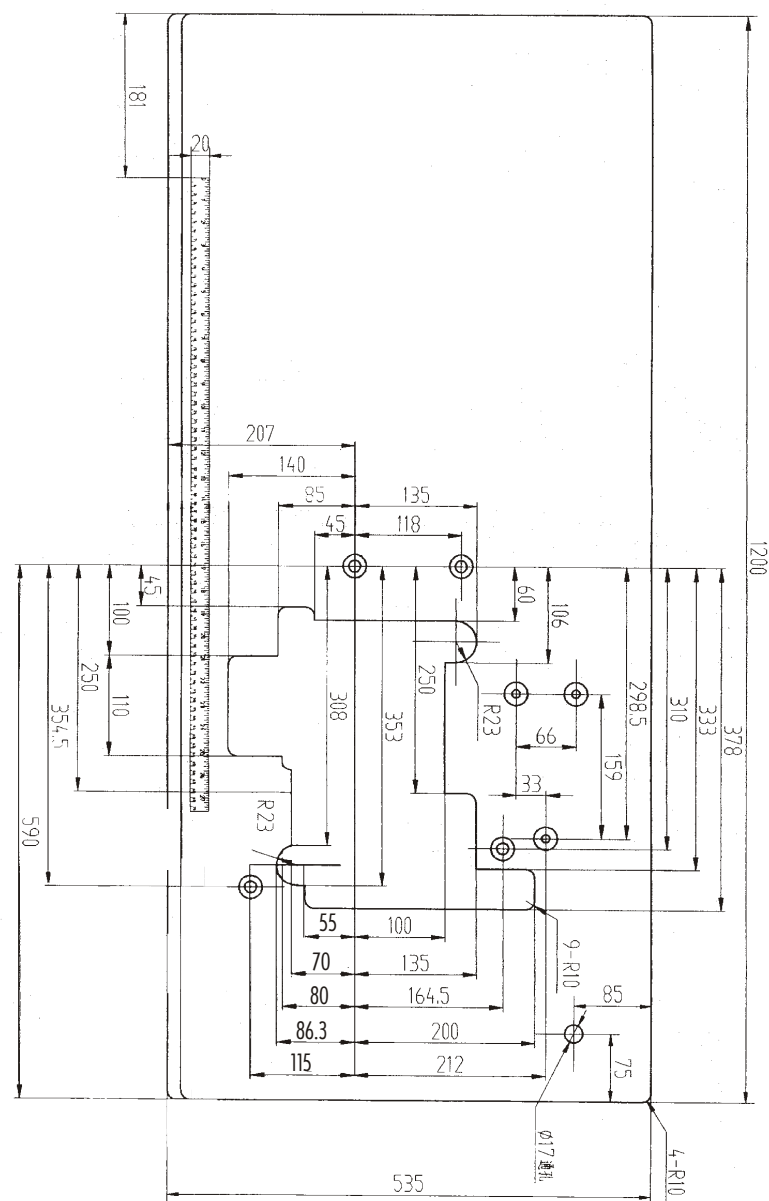
-60-

台板加工图

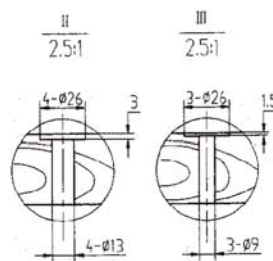
Schematic diagram of the machine table

请参照下图进行台板的加工。

Cut the table referring to the diagram.



标准尺寸
Standard dimension



●使用类似于日本产的马达时.....	306mm
●使用类似德国EFKA或QUICK公司马达时.....	334mm
Notes	
●Dimension for motors in Japan.....	306mm
●Dimension for EFK motor.....	334mm

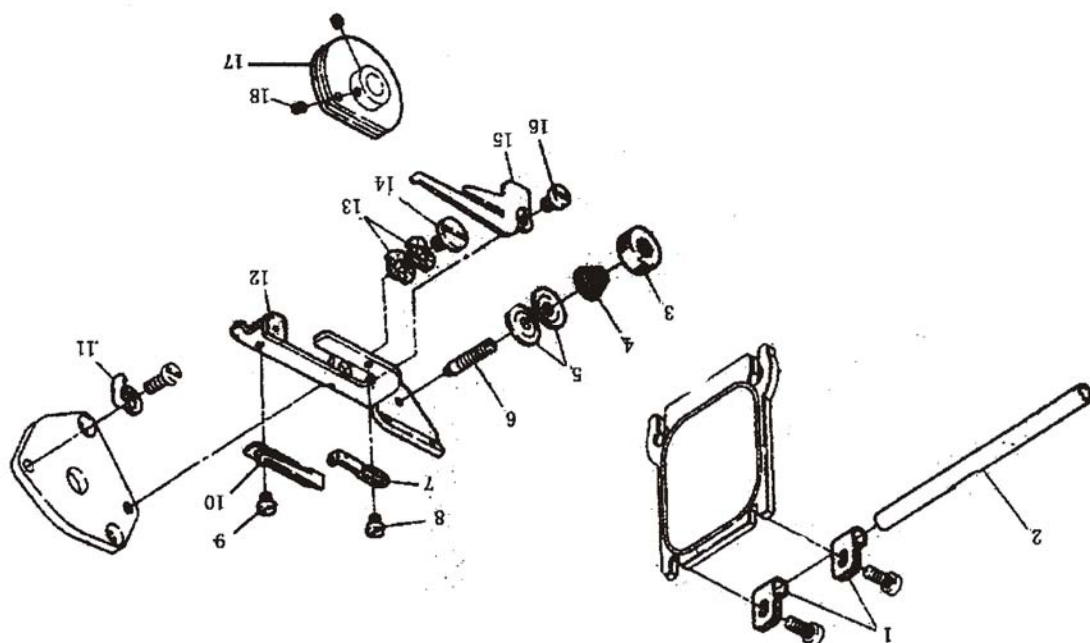
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序号	件号	名称	NAME OF PARTS	数量
1	Z-91-102108-35	针板	needle plate	1
2	Z-91-101427-35	螺钉	screw	2
3	Z-91-102109-15	针板托	needle plate support	1
4	Z-91-101019-15	螺钉	screw	2
5	Z-91-102111-15	针板座	base of needle guard	1
6	Z-91-101034-75-004	防震橡胶垫	vibration-proof rubber cushion	2
7	Z-91-101019-15	螺钉	screw	2
8	Z-91-102112-05	直针前护针	front needle guard	1
9	Z-91-101019-15	螺钉	screw	1
10	Z-91-102130-05	直针后护针	rear needle guard	1
11	Z-91-102307-15	螺钉	screw	1
12	Z-12-308006-15	垫圈	washer	1
13	Z-91-102307-15	螺钉	screw	1
14	Z-91-102356-35	链弯针前过线板	front thread guide	1
15	Z-91-101024-15	螺钉	screw	1
16	Z-91-102387-35	针板	needle plate	1
17	Z-91-102345-05	直针前护针	front needle guard	1
18	Z-91-102340-15	护针座	needle guard bar cket	1
19	Z-91-102343-05	链弯针后护针	rear needle guard	1
20	Z-91-102344-05	链弯针后护针	front needle guard	1
21	Z-91-102347-15	螺钉	screw	2
22	Z-91-101403-15	螺钉	screw	2
23	Z-91-101403-15	螺钉	screw	2
24	Z-91-102130-05	直针后护针	rear needle guard	1

12. 针杆机构 (3) / NEEDLE BAR FRAME (3)

9、挑线·过线(4)/THREAD TAKE UP AND THREADING(4)



9、挑线·过线(4)/TIREAD TAKE UP AND THREADING(4)

序号	件号	名称	NAME OF PARTS	数量
1	Z-91-101715-05	过线管夹翼	elastic clamp for thread guide pipe	2
2	Z-91-102376-25	横过线管	horizontal thread guide pipe	2
3	Z-91-101721-91	夹线螺母	thread tension nut	1
4	Z-91-101726-15	弹簧	spring	1
5	Z-91-101727-05	夹线板	thread tension dish	2
6	Z-91-101728-15	螺钉	screw	1
7	Z-91-101720-35	过线架	thread guide plate	1
8	Z-91-101409-15	螺钉	screw	1
9	Z-91-101409-15	螺钉	screw	1
10	Z-91-101719-35	过线板	thread guide plate	1
11	Z-91-101026-15	垫圈	washer	1
12	Z-91-101718-35	夹线架	thread tension stand	1
13	Z-91-101026-15	垫圈	washer	2
14	Z-91-101439-15	螺钉	screw	1
15	Z-91-101729-35	打线架	thread take-up stand	1
16	Z-91-101024-15	螺钉	screw	1
17	Z-91-101731-91	打线凸轮组件	thread take-up cam assembly	1
18	Z-91-101735-15	螺钉	screw	2

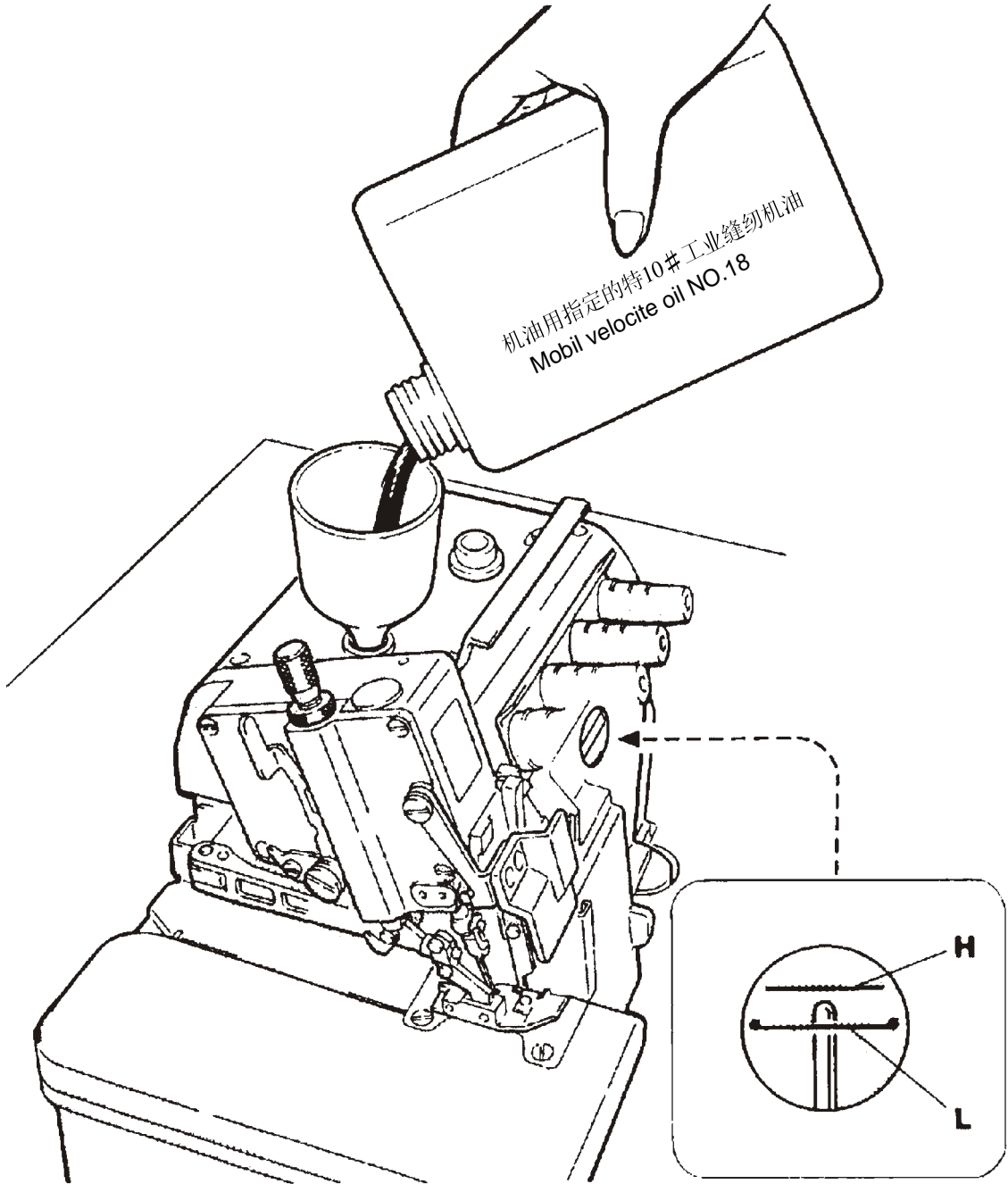
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给油
Lubrication

加油量是使油面处于H线与L线之间为好。
当油面低于L线时，就要及时补充机油。

After filling the oil pan ,the top of the indicator
should lie between (H)and(L) lines.

Add oil, when the oil level indicator reaches or
goes below(L) .



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952标准零件表

952 GAUGE PARTS LIST

序号	名称	型号	针板	主送料牙组件	主送料牙	辅送料牙	差动送料牙	压脚组件	吐线舌	上弯针
1	超高速三线包缝机(普通)	952-17	Z-91-102409-35	Z-91-102176-91	Z-91-102177-05	Z-91-102178-05	Z-91-102179-05	Z-91-102407-91	Z-91-102408-05	Z-91-102304-05
2	超高速三线中厚料包缝机	952-17H	Z-91-102192-35	Z-91-102098-91	Z-91-102496-05	Z-91-102504-05	Z-91-102508-05	Z-91-102512-91	Z-91-102519-05	Z-91-102522-05
3	超高速三线倒回缝包缝机	952-180	Z-91-102556-35	Z-91-102490-91	Z-91-102498-05	Z-91-102178-05	Z-91-102509-05	Z-91-102511-91	Z-91-102518-05	Z-91-102304-05
4	超高速三线暗缝包缝机(下摆缝即暗缝)	952-01	Z-91-102484-35	Z-91-102491-91	Z-91-102497-05	Z-91-102178-05	Z-91-102507-05	Z-91-102554-91	Z-91-102518-05	Z-91-102304-05
5	超高速三线窄边包缝机	952-16S2	Z-91-102485-35	Z-91-102492-91	Z-91-102497-05	Z-91-102505-05	Z-91-102507-05	Z-91-102541-91	Z-91-102520-05	Z-91-102304-05
6	超高速四线厚料宽边包缝机(普通)	952-13	Z-91-102108-35	Z-91-102176-91	Z-91-102177-05	Z-91-102178-05	Z-91-102179-05	Z-91-102208-91	Z-91-102215-05	Z-91-102304-05
7	超高速四线厚料宽边包缝机	952-13H	Z-91-102473-35	Z-91-102477-91	Z-91-102470-05	Z-91-102178-05	Z-91-102469-05	Z-91-102476-91	Z-91-102475-05	Z-91-102472-05
8	超高速四线倒回缝包缝机	952-181	Z-91-102486-35	Z-91-102493-91	Z-91-102499-05	Z-91-102178-05	Z-91-102510-05	Z-91-102589-91	Z-91-102588-05	Z-91-102304-05

952标准零件表

952 GAUGE PARTS LIST

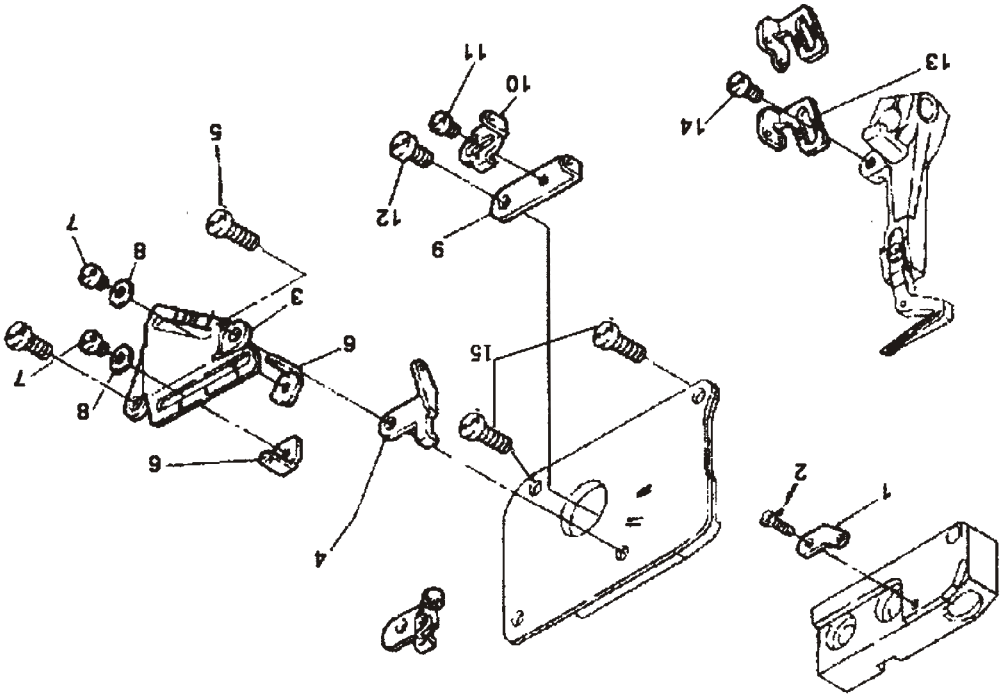
序号	名称	型号	下弯针	链弯针	上刀	下刀	前护针	后护针	针夹	机针
1	超高速三线包缝机(普通)	952-17	Z-91-102306-05		Z-91-101495-95	Z-91-101496-05	Z-91-102112-05	Z-91-102130-05	Z-91-102414-05	DC×27#9
2	超高速三线中厚料包缝机	952-17H	Z-91-102306-05		Z-91-102524-95	Z-91-102525-95	Z-91-102112-05	Z-91-102130-05	Z-91-102414-05	DC×27#18
3	超高速三线倒回缝包缝机	952-180	Z-91-102306-05		Z-91-101495-95	Z-91-101496-05	Z-91-102112-05	Z-91-102130-05	Z-91-102414-05	DC×27#9
4	超高速三线暗缝包缝机(下摆缝即暗缝)	952-01	Z-91-102306-05		Z-91-101495-95	Z-91-101496-05	Z-91-102112-05	Z-91-102130-05	Z-91-102414-05	DC×27#9
5	超高速三线窄边包缝机	952-16S2	Z-91-102306-05		Z-91-101495-95	Z-91-101496-05	Z-91-102112-05	Z-91-102130-05	Z-91-102414-05	DC×27#11
6	超高速四线厚料宽边包缝机(普通)	952-13	Z-91-102306-05		Z-91-101495-95	Z-91-101496-05	Z-91-102112-05	Z-91-102130-05	Z-91-102301-05	DC×27#11
7	超高速四线厚料宽边包缝机	952-13H	Z-91-102471-16		Z-91-101495-95	Z-91-101496-05	Z-91-102112-05	Z-91-102130-05	Z-91-102301-05	DC×27#11
8	超高速四线倒回缝包缝机	952-181	Z-91-102306-05		Z-91-101495-95	Z-91-101496-05	Z-91-102112-05	Z-91-102130-05	Z-91-102301-05	DC×27#9

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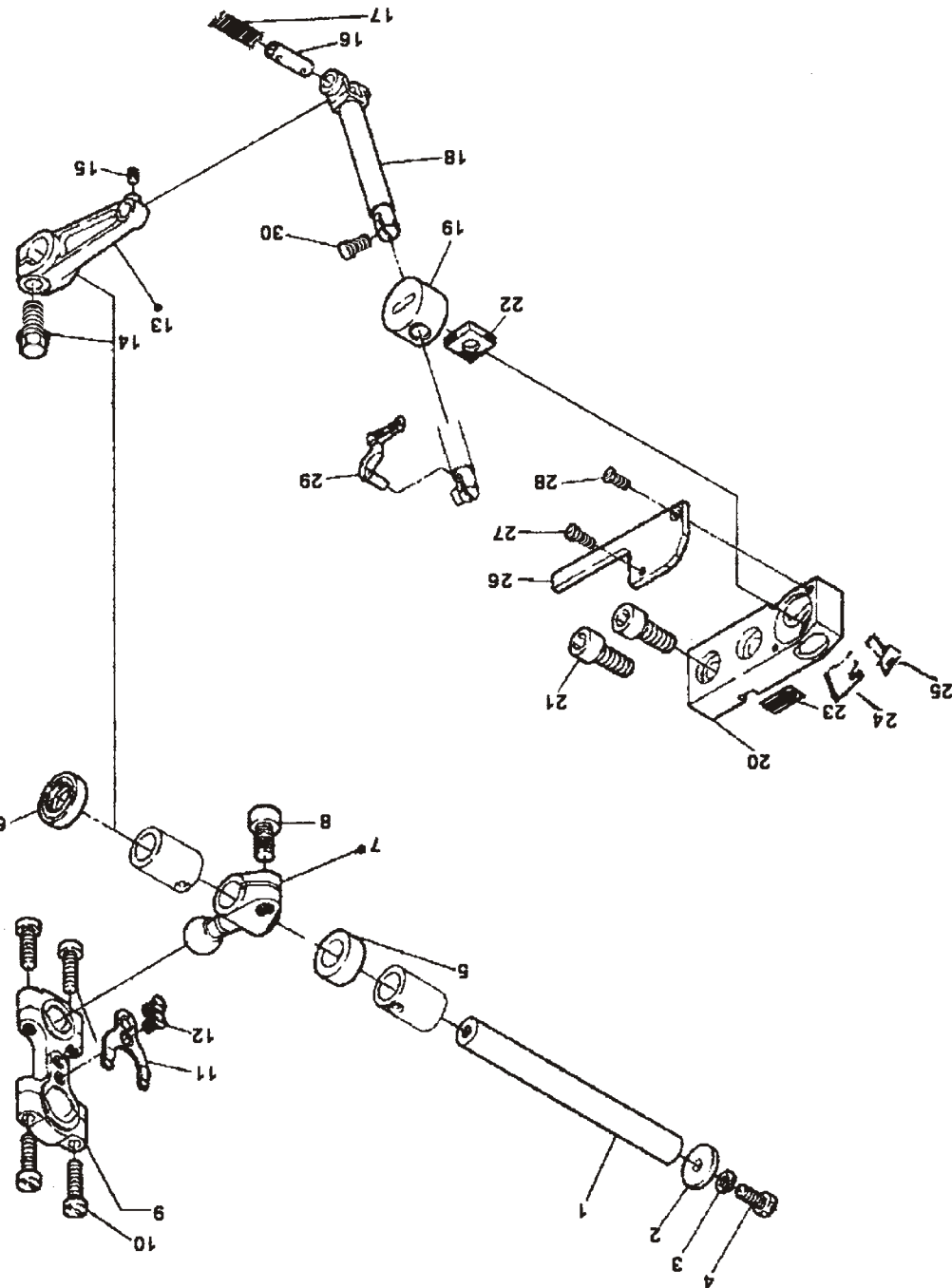
序号	件号	名称	NAME OF PARTS	数量
1	Z-91-102128-35	上弯针小过线板	small thread guide plate of upper looper	1
2	Z-91-101409-15	螺钉	screw	1
3	Z-91-102229-35	弯针下过线板架	stand of lower thread guide plate	1
4	Z-91-102232-35	上弯针过线板	thread guide plate of upper looper	1
5	Z-91-101019-15	螺钉	screw	2
6	Z-91-102230-35	弯针小过线板	thread guide plate of looper	2
7	Z-91-101409-15	螺钉	screw	2
8	Z-91-101308-15	垫圈	washer	2
9	Z-91-102234-35	上弯针轴内过线板	inner thread guide plate mounted on the shaft	1
10	Z-91-102235-35	上弯针轴外过线板	outer thread guide plate mounted on the shaft	1
11	Z-91-101409-15	螺钉	screw	1
12	Z-91-101019-15	螺钉	screw	1
13	Z-91-102254-35	下弯针过线板	thread guide plate for lower looper	1
14	Z-91-105055-15	螺钉	screw	1
15	Z-91-134105-15	螺钉	screw	2

8、挑线·过线(3)/TIIRAD TAKE UP AND THREADING(3)



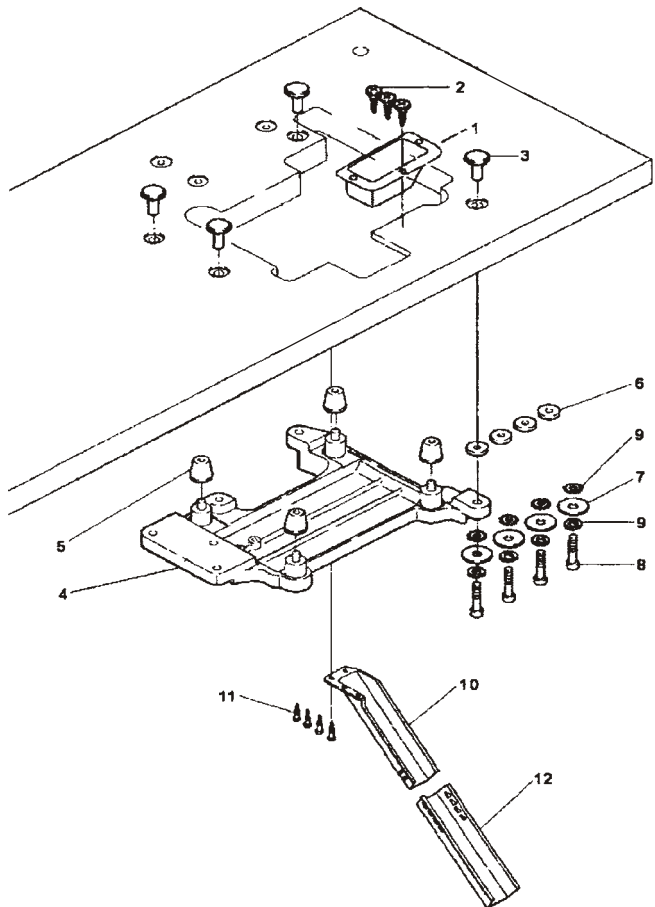
8、挑线·过线(3)/TIIRAD TAKE UP AND THREADING(3)

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13、上弯针机构/UPPER LOOPER FRAME

24、油盘托架/OIL TANK BRACKET



24、油盘托架/OIL TANK BRACKET

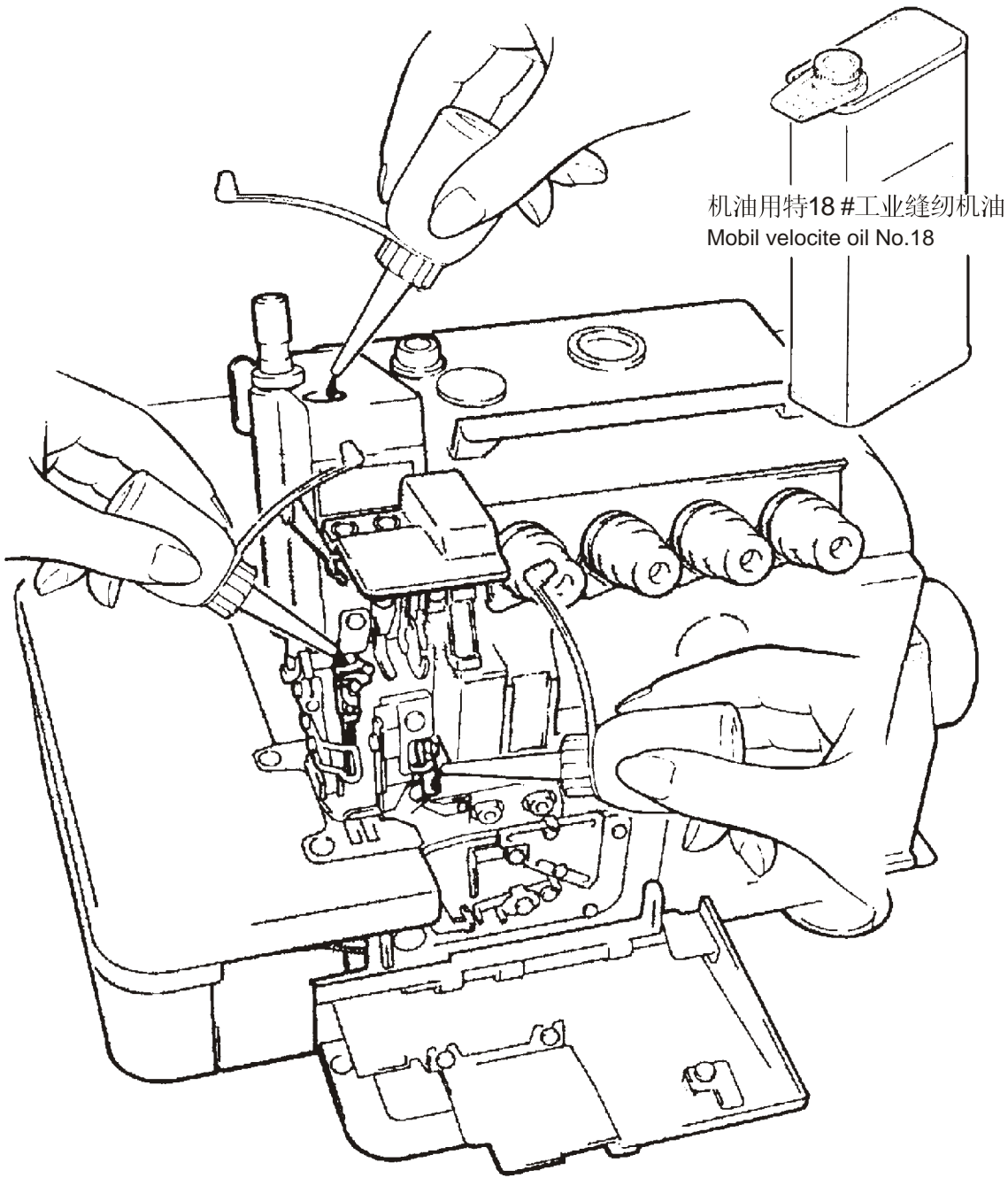
序号 No.	件号 Parts No.	名 称	NAME OF PARTS	数量 Number
1	Z-91-101237-75-001	下料口	scrap mouth	1
2	Z-11-402001-25	螺钉	screw	3
3	Z-91-101241-15	螺套	bush with inner thread	4
4	Z-91-102283-05	安装托板	installation plate	1
5	Z-91-102284-75-004	托盘橡胶垫	washer	4
6	Z-12-315002-15	垫圈	washer	4
7	Z-91-101243-25	垫圈	washer	8
8	Z-11-103013-15	螺钉	screw	4
9	Z-91-101244-25	垫圈	washer	4
10	Z-91-101238-75-001	下料槽上节	upper section of scrap channel	1
11	Z-11-402001-25	螺钉	screw	4
12	Z-91-101239-75-001	下料槽下节	lower section of scrap channel	1

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手动供油
Manual lubrication

手动给油是在缝纫机最初开始使用时。
或相当一段时间没使用了时，请供给
2-3滴油。

Apply 2 or 3 drops of oil by hand when the
machine is used for the first time or has been
left unused for some time.



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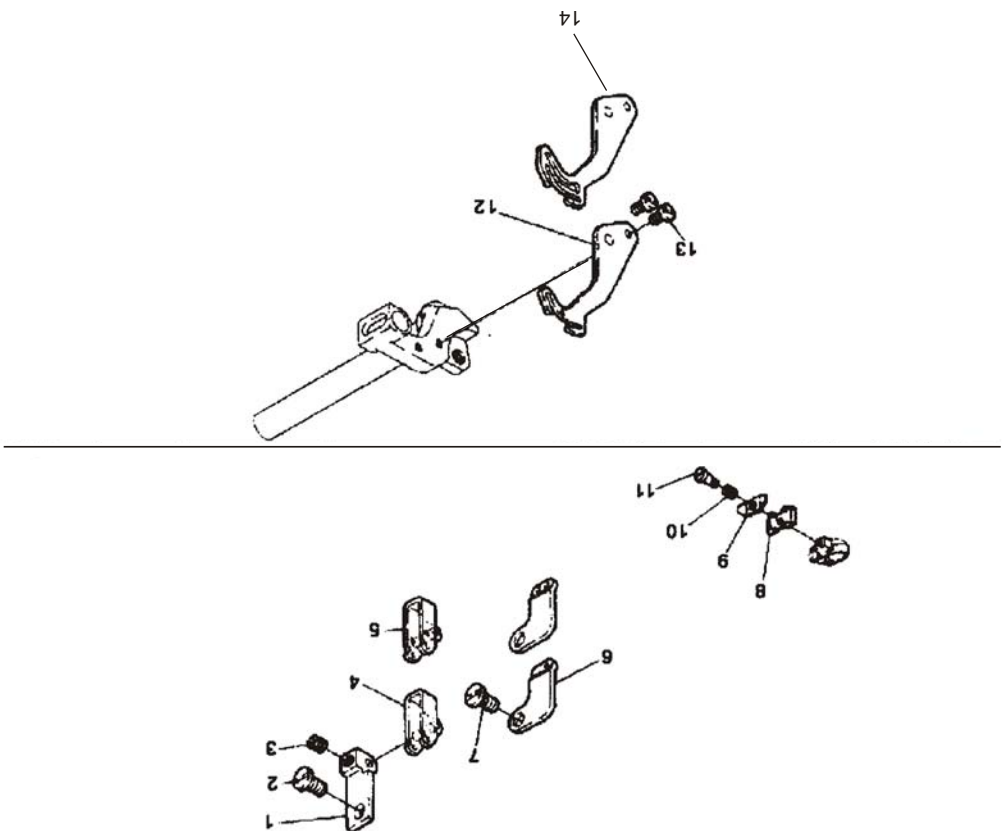
序号 No.	件号 Parts No.	名 称	NAME OF PARTS	数量 Number
1	Z-91-102117-05	上弯针轴	drive shaft for upper looper	1
2	Z-91-101341-05	垫圈	washer	1
3	Z-12-301002-15	垫圈	washer	1
4	Z-91-101342-15	螺钉	screw	1
5	Z-91-102118-05	挡圈	retaining ring	1
6	Z-91-102119-95	密封圈	seal ring	1
7	Z-91-102075-05	上弯针球曲柄	crank bush with ball hand for upper looper	1
8	Z-91-101137-15	螺钉	screw	1
9	Z-91-102074-05	弯针传动连杆	connecting bar for upper looper drive	1
10	Z-91-102310-15	螺钉	screw	4
11	Z-91-102079-05	连杆挡板	fender for connecting bar	1
12	Z-91-101181-15	螺钉	screw	2
13	Z-91-102121-55	上弯针摇杆	swing bar for upper looper shaft	1
14	Z-91-101078-15	螺钉	screw	1
15	Z-91-101070-15	螺钉	screw	1
16	Z-91-101352-05	销	pin	1
17	Z-91-101353-05	油线	oil wick	1
18	Z-91-102123-85	滑杆	sliding bar	1
19	Z-91-101347-05	滑杆套	sliding bar bush	1
20	Z-91-102124-05	滑杆座	sliding bar bracket	1
21	Z-91-101010-15	螺钉	screw	2
22	Z-91-102317-05	滑杆孔毛毡	felt for hold of sliding bar bush	1
23	Z-91-101349-05	毛毡	felt	1
24	Z-91-102126-15	毛毡压板	press plate for felt	1
25	Z-91-101191-15	螺钉	screw	1
26	Z-91-102127-15	盖板	cover plate	1
27	Z-91-101358-15	螺钉	screw	1
28	Z-91-101357-15	螺钉	screw	1
29	Z-91-102304-05	上弯针	upper looper	1
30	Z-91-133158-15	螺钉	screw	1

13、上弯针机构/UPPER LOOPER FRAME

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序号 No.	件号 Parts No.	名 称	NAME OF PARTS	数量 Number
1	Z-91-102223-15	挑线固定架	fixing stand for thread take-up clamp	1
2	Z-91-101030-15	螺钉	screw	1
3	Z-91-101066-15	螺钉	screw	1
4	Z-91-102225-05	挑线夹	thread take-up clamp	1
5	Z-91-102226-05	挑线夹销	pin for thread take-up clamp	1
6	Z-91-102227-35	直针过线板	thread guide plate on the needle bar	1
7	Z-91-101030-15	螺钉	screw	2
8	Z-91-102296-35	下夹线板	lower thread tension plate	1
9	Z-91-102297-35	上夹线板	upper thread tension plate	1
10	Z-91-102298-15	夹线簧	thread tension spring	1
11	Z-91-102299-15	螺钉	screw	1
12	Z-91-102189-35	挑线架	thread take-up clamp	1
13	Z-91-101310-15	螺钉	screw	2
14	Z-91-102362-35	挑线架	thread tak-up damp	1

7、挑线·过线(2)/THREAD TAKE UP AND THREADING(2)



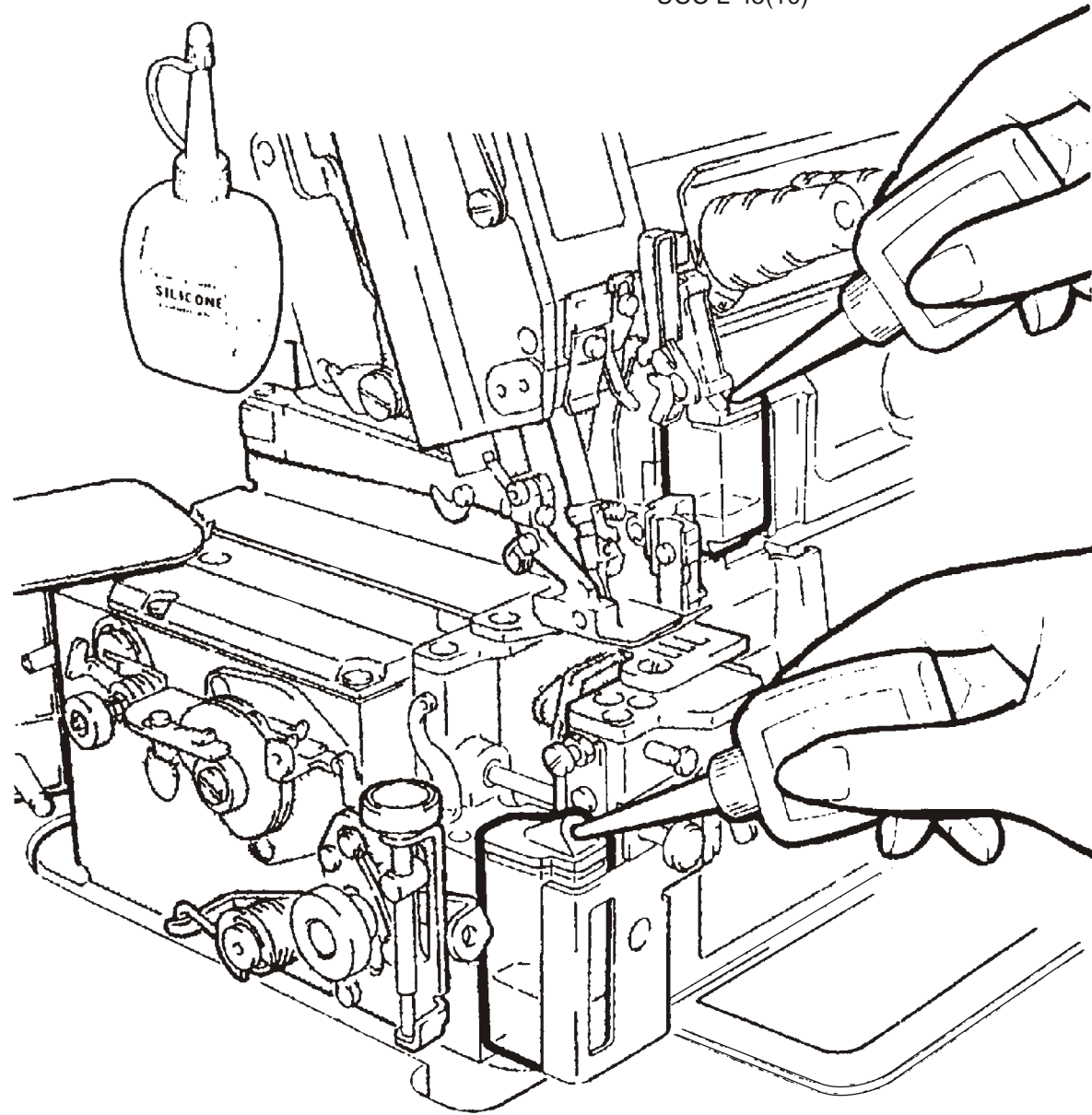
7、挑线·过线(2)/THREAD TAKE UP AND THREADING(2)

给HR装置供油 Filling the HR device with silicon oil

为防止断线，尽早给HR装置供油。
注：关于购买硅油，请询问代理店或公司营业部联系。

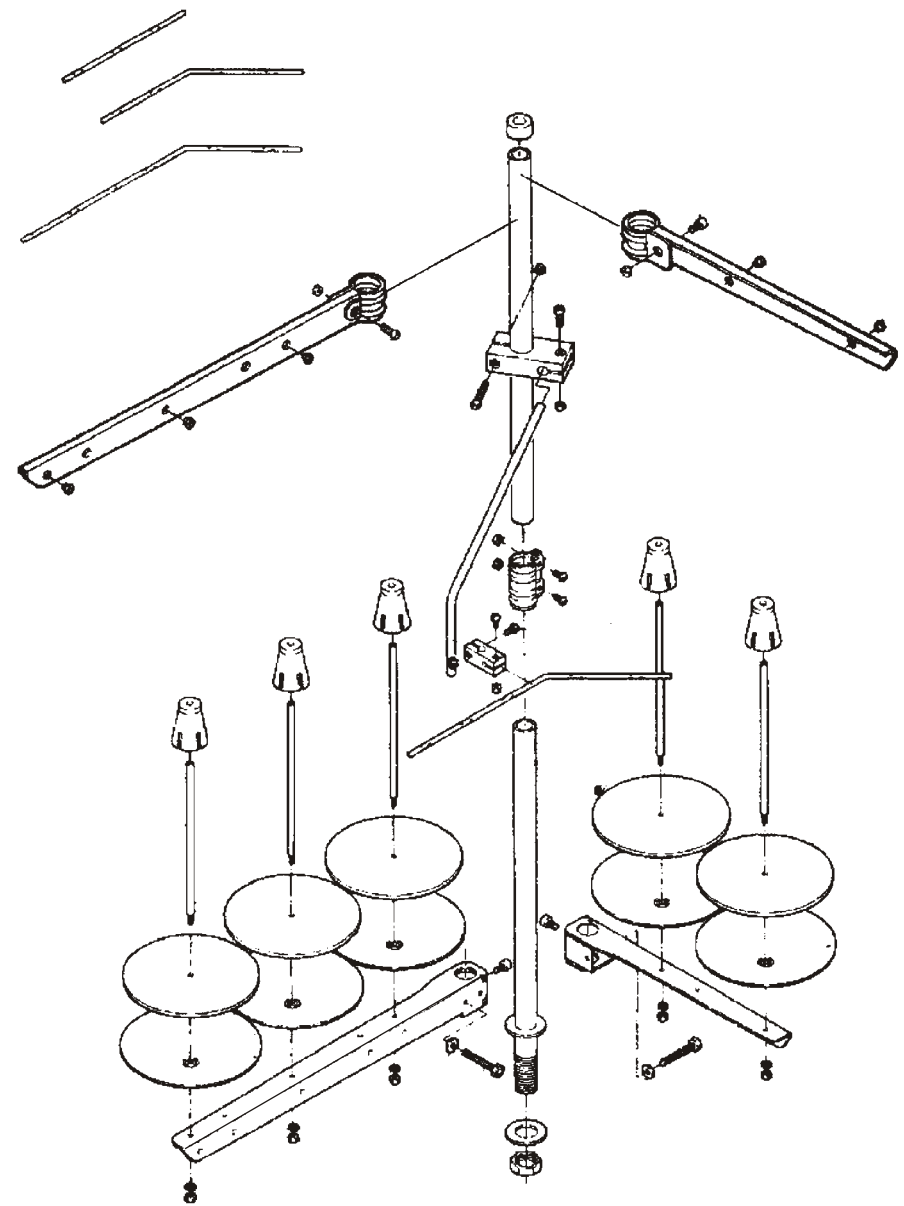
Fill the HR device with oil before it is too low in order to prevent needle thread breakage and fabric damage.

Note: Use Pegasus recommended silicon oil.
[UNION CARBIDE CORPORATION]
UCC L-45(10)



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23、线架/THREAD STAND PARTS



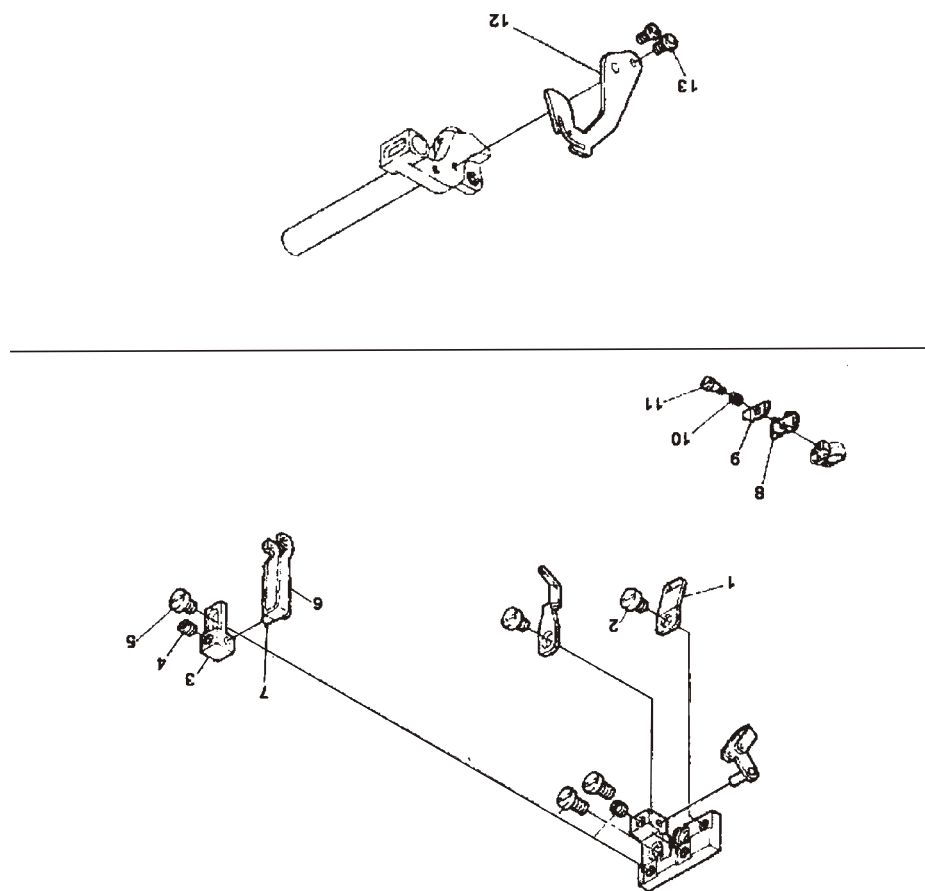
23、线架/THREAD STAND PARTS

序号 No.	件号 Parts No.	名 称	NAME OF PARTS	数量 Number
1	Z-91-101622-91	四线线架组件	thread stand aggregate	1
2	Z-91-134907-91	五线线架组件	thread stand aggregate	1
3	Z-91-145807-91	三线线架组件	thread stand aggregate	1

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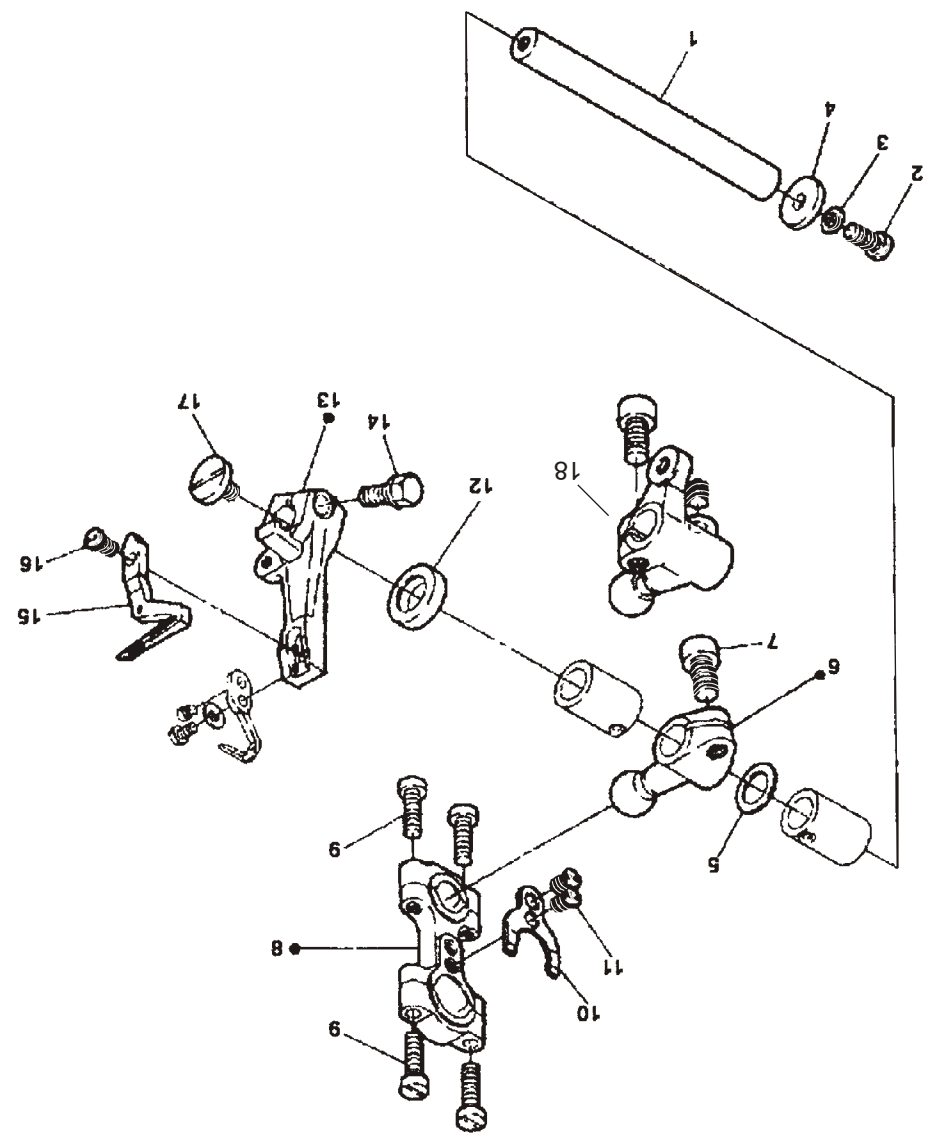
6、挑线·过线/THREAD TAKE UP AND THREADING

序号	零件号	名称	数量
1	Z-91-102272-35	螺钉	1
2	Z-91-101030-15	螺钉	2
3	Z-91-102223-15	挑线夹固定架	1
4	Z-91-101066-15	螺钉	1
5	Z-91-101030-15	螺钉	1
6	Z-91-102225-05	挑线夹	2
7	Z-91-102226-05	挑线夹销	1
8	Z-91-102296-35	下夹线板	1
9	Z-91-102297-35	上夹线板	1
10	Z-91-102298-15	夹线簧	1
11	Z-91-102299-15	螺钉	1
12	Z-91-102188-35	挑线架	1
13	Z-91-101310-15	螺钉	2



6、挑线·过线/THREAD TAKE UP AND THREADING

14、下弯针机构/LOUER LOOPER FRAME



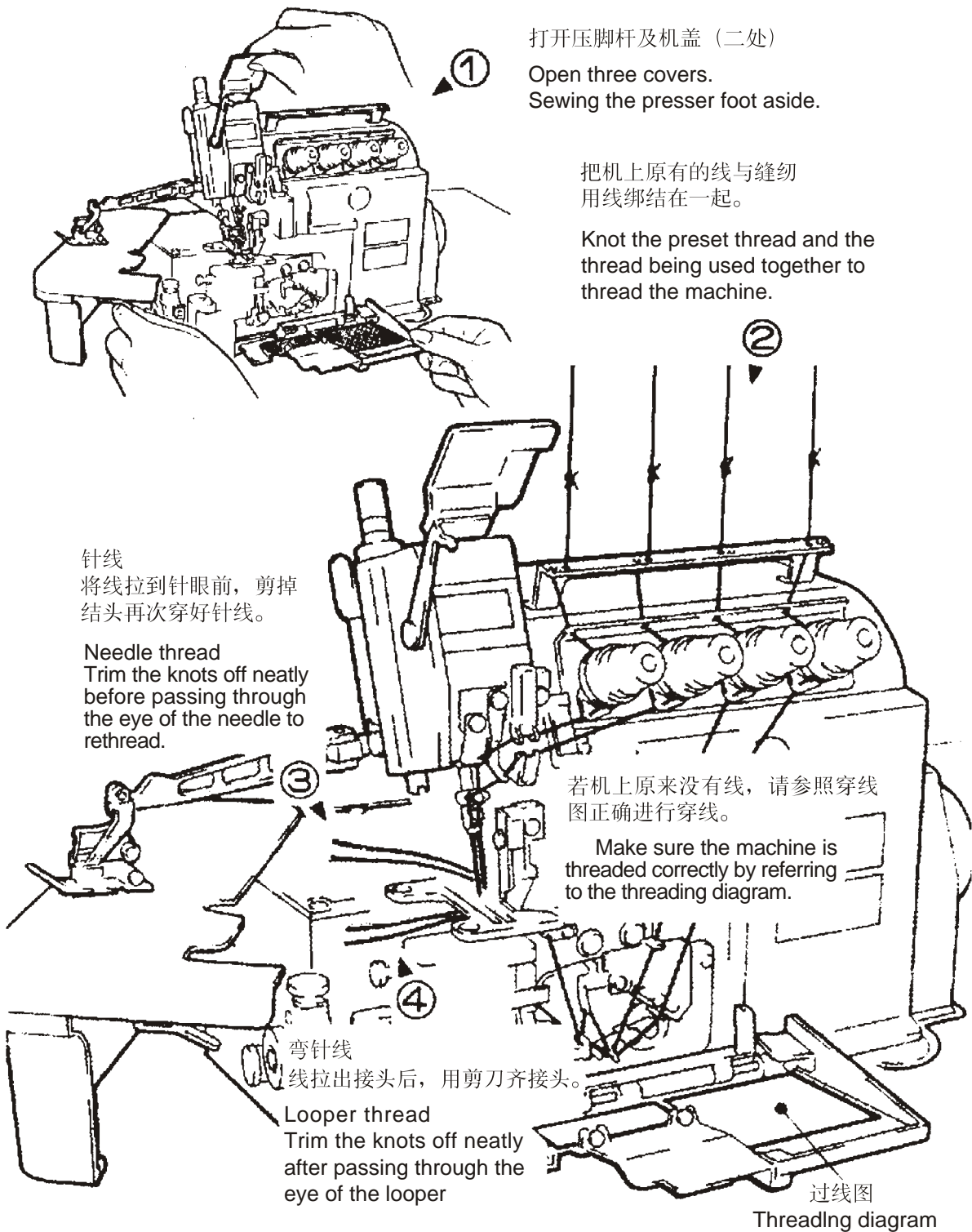
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22、润滑装置/HR DEVICE

序号 No.	件号 Parts No.	名 称	NAME OF PARTS	数量 Number
1	Z-91-102273-75-004	盒盖	box cover	1
2	Z-91-102272-05	上硅油盒	upper silicon oil box	1
3	Z-91-102309-05	毛毡	felt	1
4	Z-91-102274-35	毛毡压板	presser plate for felt	1
5	Z-91-101039-15	螺钉	screw	1
6	Z-91-102277-05	硅油盒	silicon oil box	1
7	Z-91-101321-15	螺钉	screw	2
8	Z-91-102278-05	毛毡	felt	1
9	Z-17-601002-05	大头针	pin	1
10	Z-14-601001-05	钢球	steel ball	1
11	Z-91-134467-45	紧固圈	fastening ring	2
12	Z-91-102280-05	油线	oil wick	1
13	Z-91-102281-05	下硅油盒	lower silicon oil box	1
14	Z-91-102282-75-004	盒盖	box cover	1
15	Z-11-101011-15	螺钉	screw	1
16	Z-12-302001-15	垫圈	washer	1
17	Z-12-307001-15	垫圈	washer	1
18	Z-91-102341-05	硅油盒	silicon oil box	1

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穿线的方法
Threading



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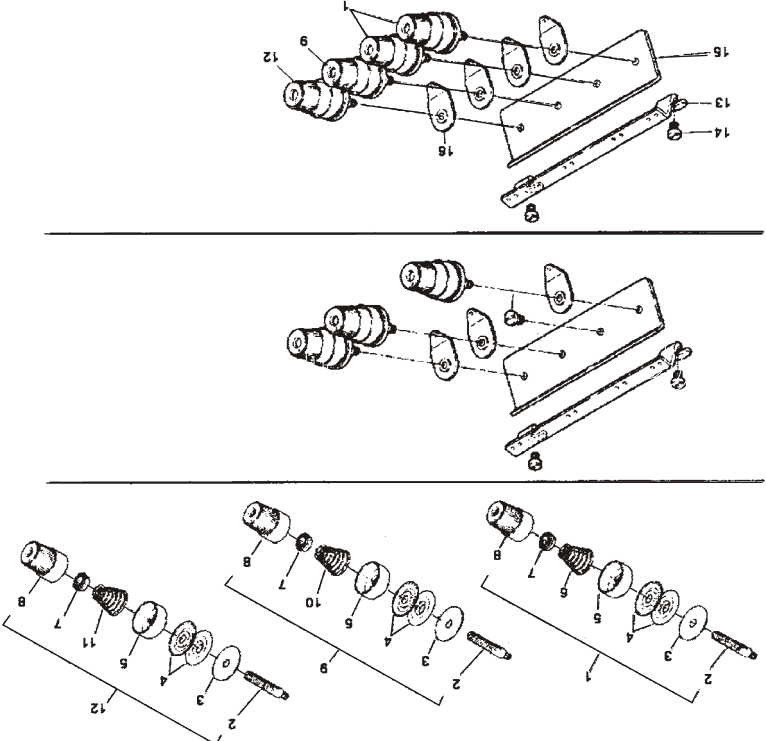
序号 No.	件号 Parts No.	名 称	NAME OF PARTS	数量 Number
1	Z-91-102117-05	下弯针轴	drive shaft for lower looper	1
2	Z-91-101342-15	螺钉	screw	1
3	Z-12-301002-15	垫圈	washer	1
4	Z-91-101341-05	垫片	washer	1
5	Z-91-101067-05	垫圈	washer	1
6	Z-91-102076-05	下弯针球曲柄	crank bush with ball head for lower looper	1
7	Z-91-101078-15	螺钉	screw	1
8	Z-91-102074-05	下弯针传动连杆	connecting bar for lower looper drive	1
9	Z-91-102310-15	螺钉	screw	4
10	Z-91-102079-05	连杆挡板	fender for connecting bar	1
11	Z-91-101181-15	螺钉	screw	1
12	Z-91-101343-95	油封	seal ring	2
13	Z-91-102305-05	下弯针架	stand for lower looper	1
14	Z-91-101078-15	螺钉	screw	1
15	Z-91-102306-05	下弯针	lower looper	1
16	Z-91-116092-15	螺钉	screw	1
17	Z-91-102308-15	螺钉	screw	1
18	Z-91-102334-05	链弯针左曲柄	crank bush with chain stitch looper	1

14、下弯针机构/LOWER LOOPER FRAME

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序号 No.	件号 Parts No.	名 称	NAME OF PARTS	数量 Number
1	Z-91-102021-91	直针夹线器组件	thread tension aggregate for needle	1
2	Z-91-101421-15	螺钉	screw	1
3	Z-91-101420-75-003	布垫	cloth cushion	1
4	Z-91-101419-05	夹线盘	thread tension dish	2
5	Z-91-102024-75-002	夹线碗	thread tension bowl	1
6	Z-91-101417-15	弹簧	spring	1
7	Z-91-101416-75-004	防松垫	release-proof cushion	1
8	Z-91-102022-71-002	夹线螺母	thread tension nut	1
9	Z-91-102025-91	上弯针夹线器组件	thread tension aggregate for upper looper	1
10	Z-91-101424-15	弹簧	spring	1
11	Z-91-102023-91	下弯针夹线器组件	thread tension aggregate for lower looper	1
12	Z-91-101426-15	弹簧	spring	1
13	Z-91-102027-25	过线架	thread guide stand	1
14	Z-91-101098-15	螺钉	screw	2
15	Z-91-102020-25	夹线器座	base of thread tension device	1
16	Z-91-101422-35	过线板	thread guide plate	4

5、调线机构/ADJUSTING THREAD FRAME

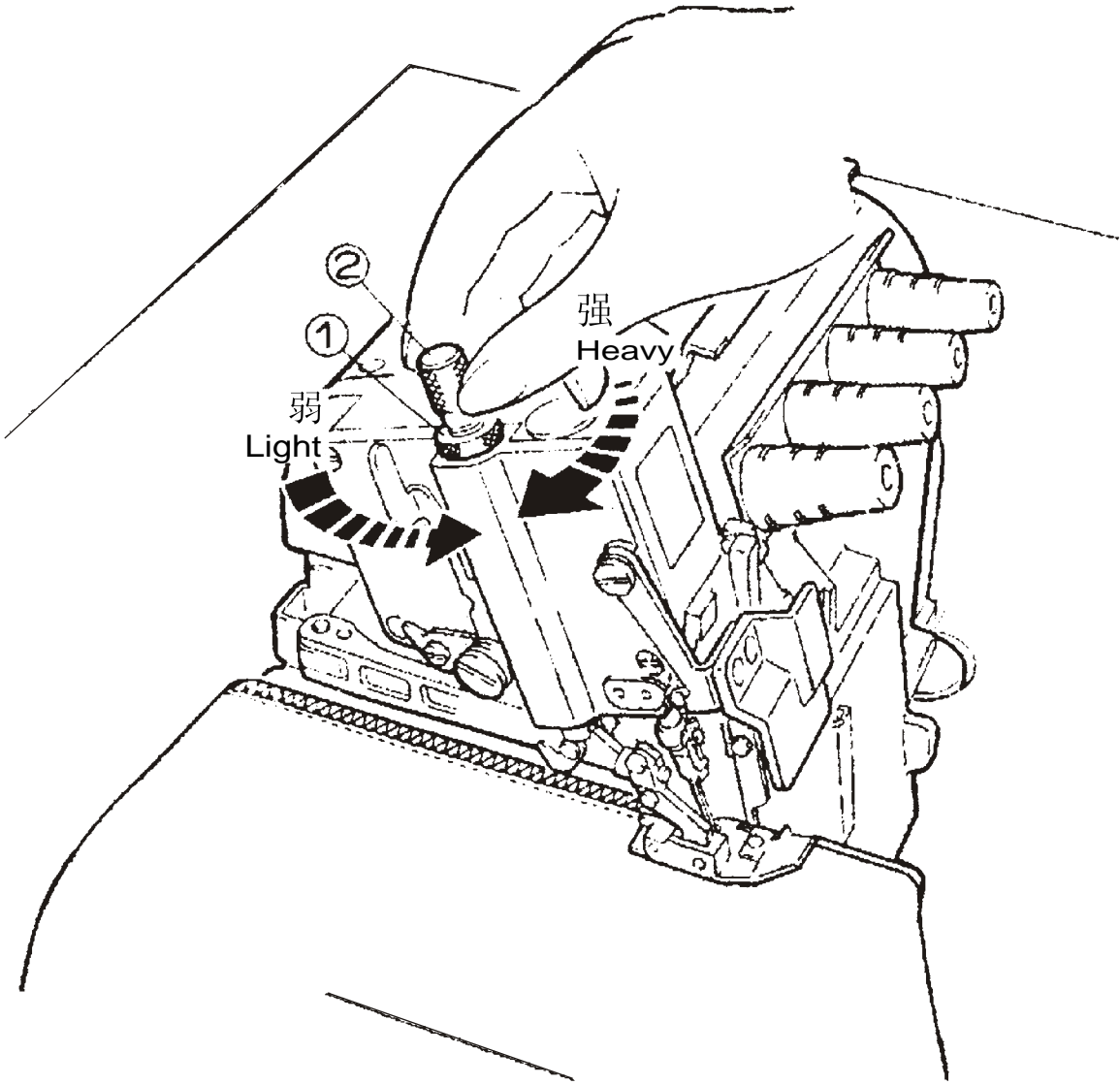


5、调线机构/ADJUSTING THREAD FRAME

压脚压力的调节
Adjusting the presser foot pressure

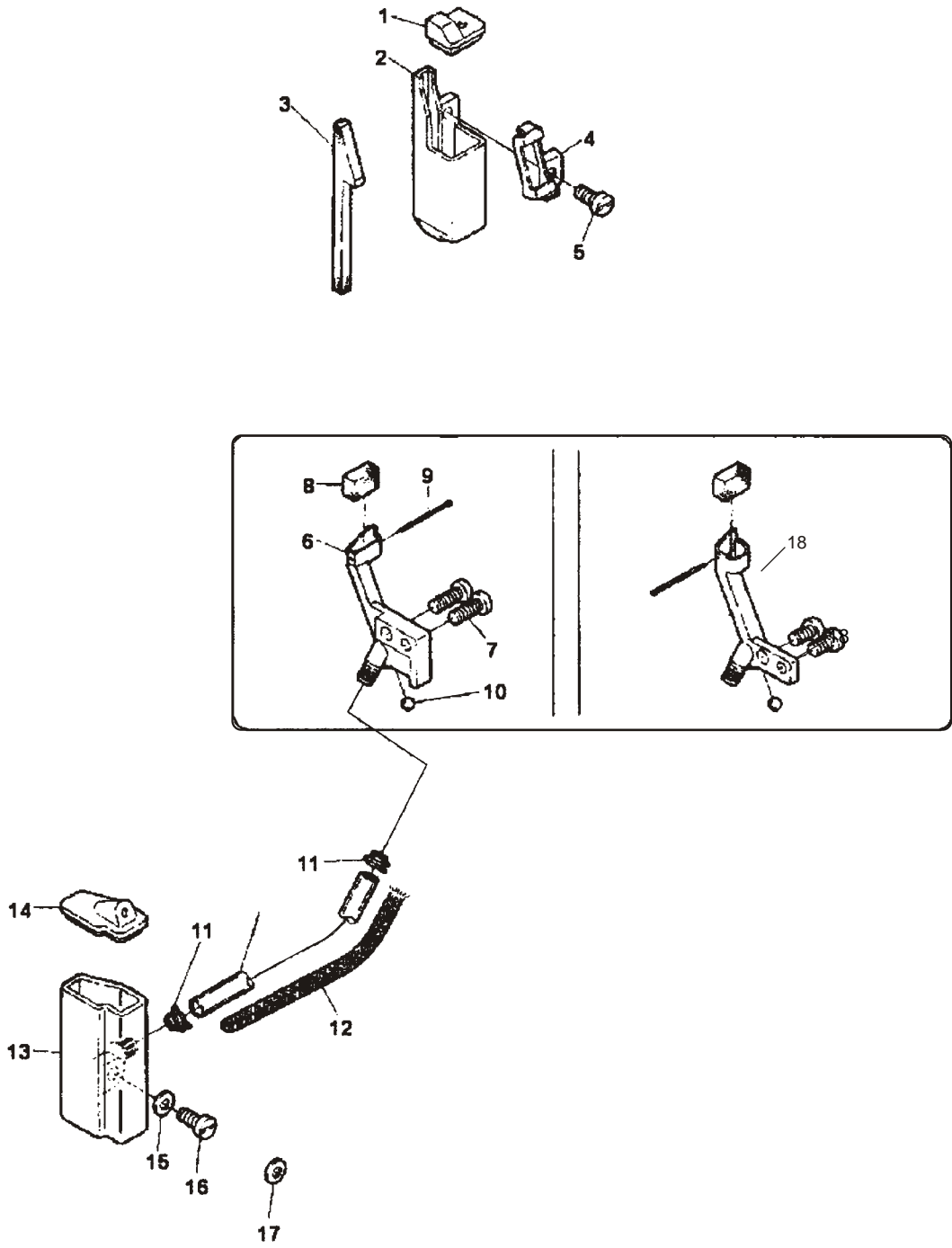
压脚压力的调节，松动螺母①，调节螺母②，在送布得到稳定状态下尽可能使用较弱的压力为好。

Loosen sadjusting nut ① and turn adjusting nut ② to adjust the presser foot pressure. Is should be as light as possible.yet be sufficient to obtain the proper stitch formation.



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22、润滑装置/HR DEVICE



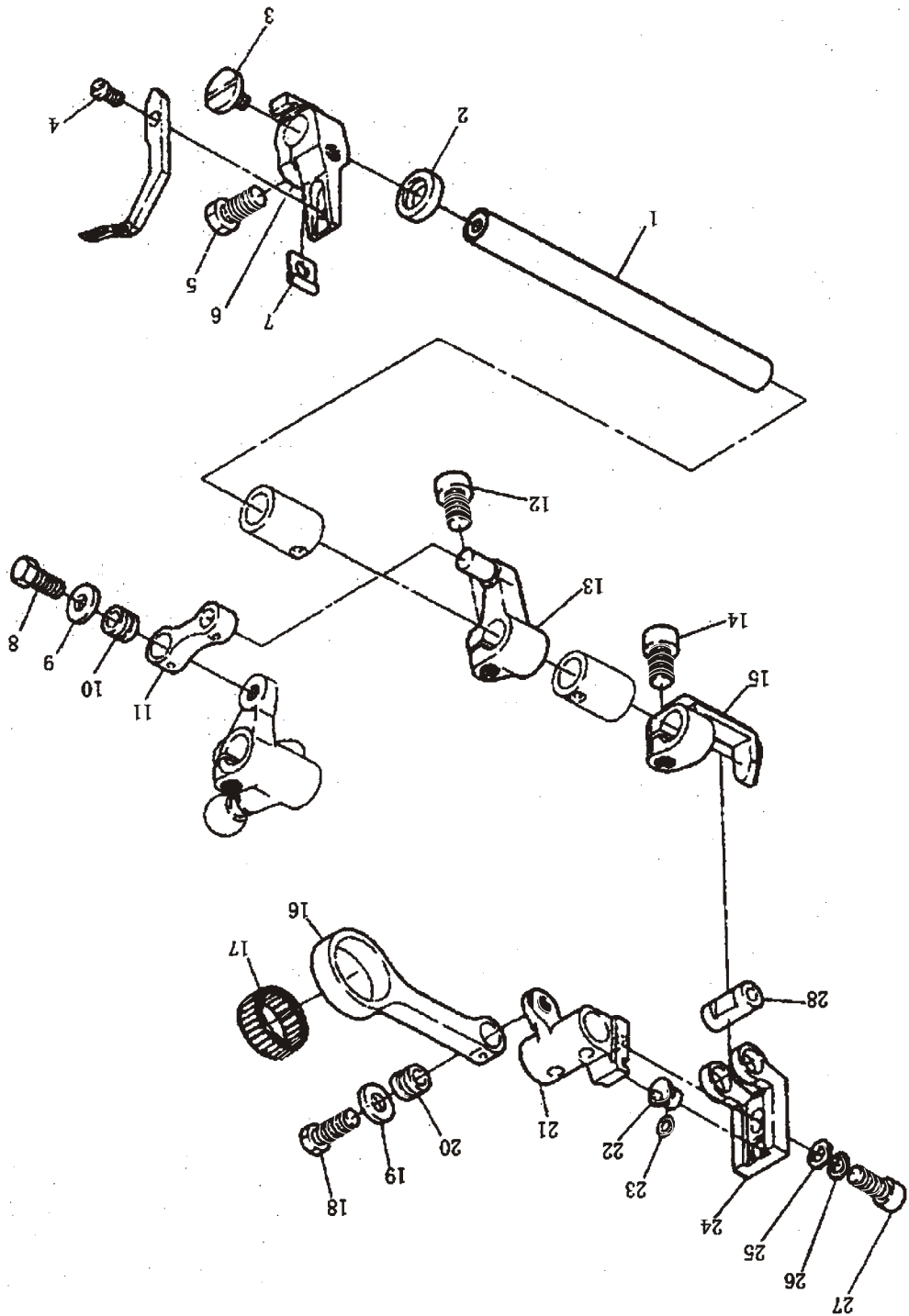
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序号 No.	件号 Parts No.	名称	NAME OF PARTS	数量 Number
1	Z-91-101019-15	螺钉	screw	3
2	Z-91-102061-15	左盖	left cover	1
3	Z-91-102062-75-004	O型圈	O ring	1
4	Z-91-102064-05	轴承套	bush mounted in bearing	1
5	Z-91-101046-15	螺钉	screw	1
6	Z-91-101047-15	螺钉	screw	1
7	Z-91-102218-05	左轴承	left bearing	1
8	Z-91-102065-75-004	O型圈	O ring	1
9	Z-91-101336-15	螺钉	screw	1
10	Z-91-102069-15	主轴油芯	oil wick of main shaft	1
11	Z-91-102070-05	主轴	main shaft	1
12	Z-91-102071-15	螺钉	screw	5
13	Z-91-102080-18	平衡块	balance block	2
14	Z-11-102010-15	螺钉	screw	4
15	Z-91-102082-15	蜗杆套	bush mounded in worm bush	1
16	Z-91-102084-05	蜗杆	worm bush	1
17	Z-91-101046-15	螺钉	screw	1
18	Z-14-002046-91	轴承	bearing	1
19	Z-91-102085-15	右盖垫片	washer for right cover	1
20	Z-91-102086-15	螺纹套	bush mounted in screw	1
21	Z-91-102087-75-004	O型圈	O ring	1
22	Z-91-102088-75-004	O型圈	O ring	1
23	Z-91-102089-05	右盖	right cover	1
24	Z-91-101039-15	螺钉	screw	3
25	Z-91-102090-05	风扇	fan	1
26	Z-91-101336-15	手轮紧固螺钉	screw for hand wheel	2
27	Z-91-102093-75-002	手轮	hand wheel	1
28	Z-12-315001-15	垫圈	washer	1
29	Z-91-101571-15	螺钉	screw	1
30	Z-91-101572-75-004	手轮盖	cover of hand wheel	1
31	Z-91-102610-05	螺钉	screw	1
32	Z-91-102364-15	左盖	leftcover	1
33	Z-91-101039-15	螺钉	screw	1
34	Z-91-101687-15	螺钉	screw	2

4、主轴机构/MAIN SHAFT FRAME

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15、链弯机构 (1) /CHAIN STITCH LOOPER FRAME (1)

21、供油机构（2）/LUBRICATION FRAME（2）

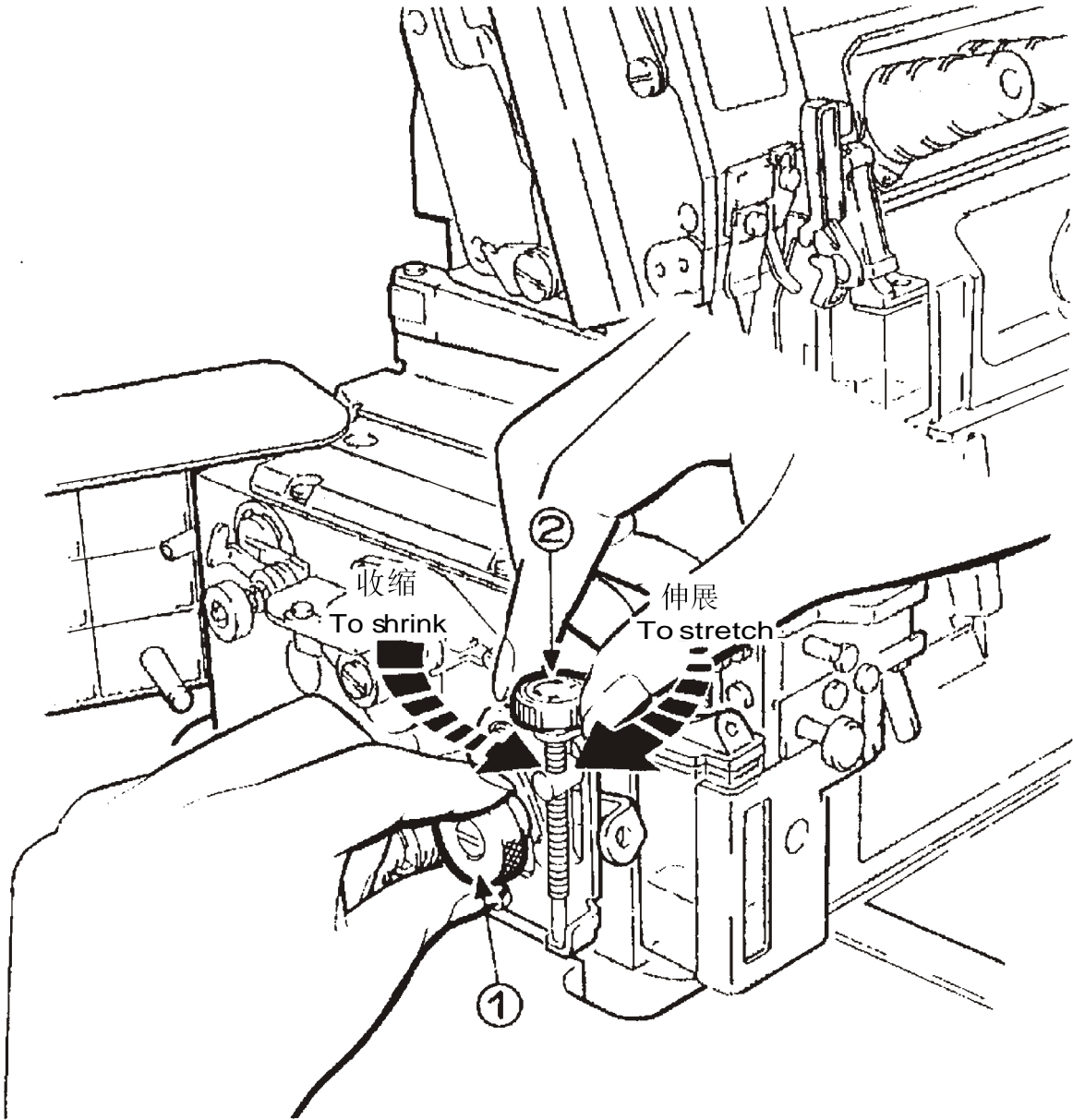
序号 No.	件号 Parts No.	名 称	NAME OF PARTS	数量 Number
1	Z-91-102251-75-004	橡胶塞	rubber plug	2
2	Z-91-102250-15	针杆给油销	oil pin for needle bar	1
3	Z-91-101066-15	螺钉	screw	1
4	Z-91-102253-05	针杆回油管	oil tube for oil return bush of needle bar	1
5	Z-91-102255-05	针杆回油架	oil return bush of needle bar stand	1
6	Z-91-102258-05	油毡	felt	1
7	Z-91-102422-15	给油销	oil pin	1
8	Z-91-102260-05	油线	oil wick	1
9	Z-14-601001-05	钢球	steel ball	1
10	Z-91-101066-15	螺钉	screw	1
11	Z-91-102261-91	指示窗组件	oil scase aggregate	1
12	Z-91-102264-75-004	密封圈	seal ring	1
13	Z-91-102266-75-007	油标	oil scase	1
14	Z-91-102267-75-006	浮标	buoy	1
15	Z-91-102268-75-001	油标座	stand of oil scase	1
16	Z-11-101010-15	螺钉	screw	2
17	Z-12-302001-15	垫圈	washer	2
18	Z-12-307001-15	垫圈	washer	2
19	Z-91-102269-05	油盘	oil tray	1
20	Z-91-102270-75-004	油盘垫	washer for oil tray	1
21	Z-91-101228-15	螺钉	screw	4
22	B.09-32	垫圈	washer	4
23	Z-91-101224-15	螺钉	screw	1
24	Z-91-101225-91	垫圈组件	washer	1

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差动比的调节
Adjusting the diff. feed ratio

差动比的调节松开螺母①调节螺母②。

Loosen the adjusting nut ① and tum the adjusting nut ② to adjust the differential feed ratio.



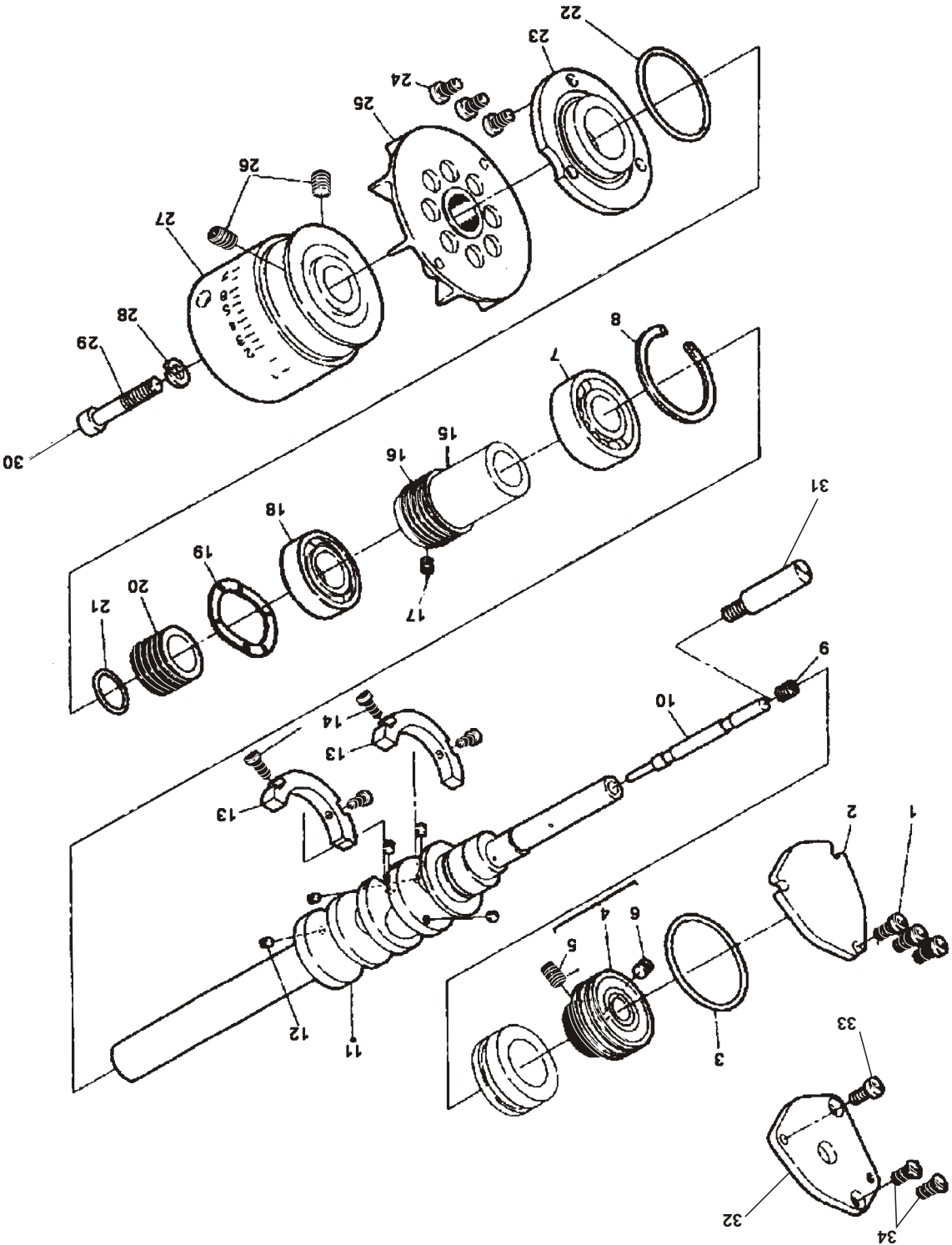
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序号 No.	件号 Parts No.	名 称	NAME OF PARTS	数量 Number
1	Z-91-102332-05	链弯针轴	shaft for chain stitch looper	1
2	Z-91-102119-95	密封圈	seal ring	1
3	Z-91-102308-15	螺钉	screw	1
4	Z-91-116092-15	螺钉	screw	2
5	Z-91-102337-15	螺钉	screw	1
6	Z-91-102336-05	链弯针架	stand of chain stitch looper	1
7	Z-91-102357-15	挡片	blocking ring	1
8	Z-91-102162-15	螺钉	screw	2
9	Z-91-102161-05	垫圈	washer	1
10	Z-91-102160-05	连杆销套	needle pin for connecting bar	1
11	Z-91-102159-05	送料连杆	connecting bar of feed dog	1
12	Z-91-101078-15	螺钉	screw	1
13	Z-91-102333-05	摆动曲柄	swing crank	1
14	Z-91-101078-15	螺钉	screw	1
15	Z-91-102331-05	摆动叉	swing fork	1
16	Z-91-102327-05	链弯针传动连杆	connecting bar for chain stitch looper	1
17	Z-91-105371-95	轴承	bearing	1
18	Z-91-102162-15	螺钉	screw	1
19	Z-91-102162-15	螺钉	screw	1
20	Z-91-102160-05	垫圈	washer	1
21	Z-91-102160-05	连杆销套	needle pin for connecting bar	1
22	Z-91-102329-05	偏心销	pin	1
23	Z-91-102354-75-004	O型圈	O ring	1
24	Z-91-102330-05	调节座	base of regulator	1
25	Z-91-102161-05	垫圈	washer	1
26	Z-12-301002-15	垫圈	washer	1
27	Z-91-101228-15	螺钉	screw	2
28	Z-91-101702-05	调节杆轴	shaft of adjusting bar	2

15、链弯机构（1）/CHAIN STITCH LOOPER FRAME(1)

4、主轴机构/MAIN SHAFT FRAME



-22-

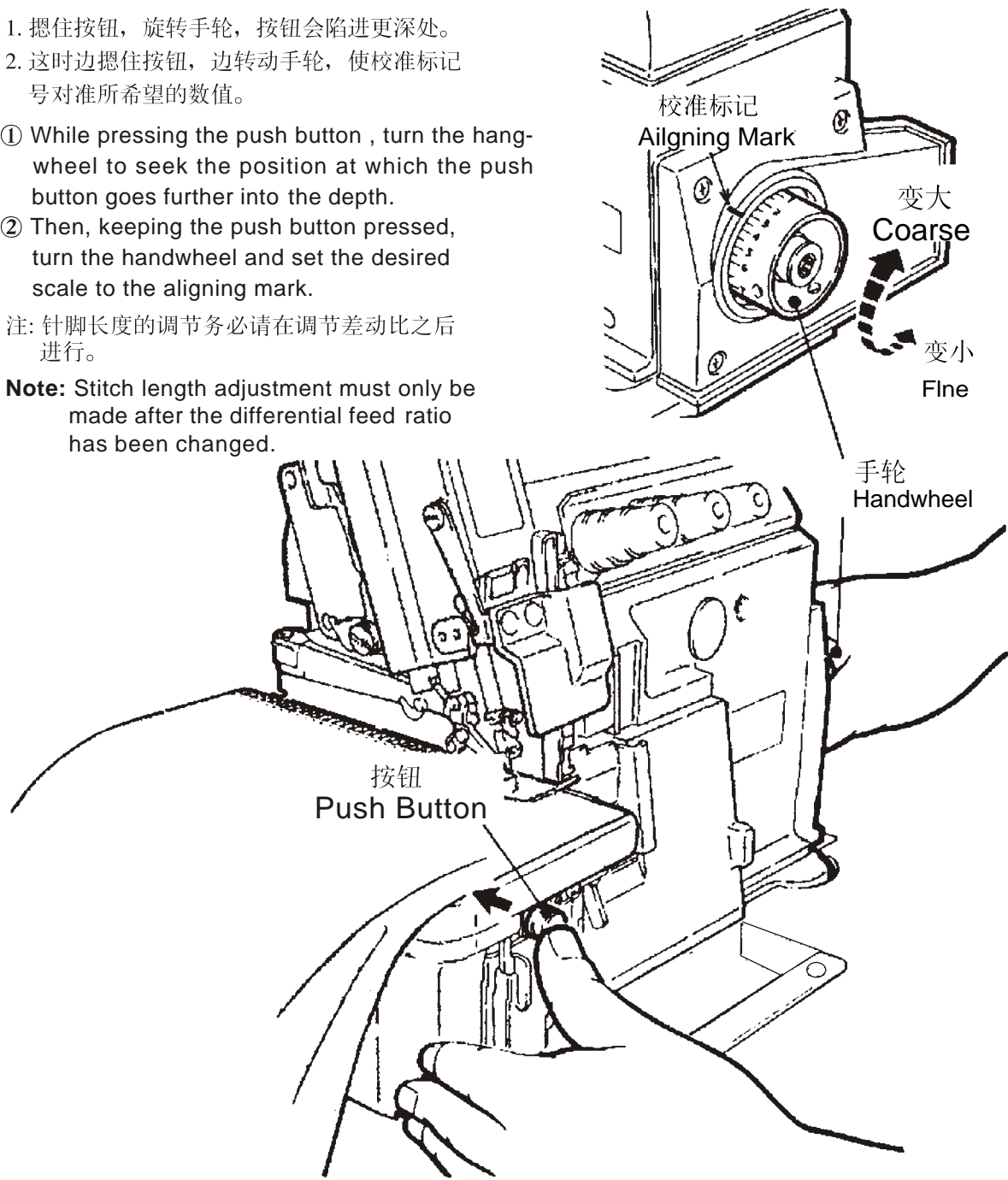
针脚长度的调节
Adjusting the stitch length

1. 摁住按钮，旋转手轮，按钮会陷进更深处。
2. 这时边摁住按钮，边转动手轮，使校准标记号对准所希望的数值。

- ① While pressing the push button , turn the hang-wheel to seek the position at which the push button goes further into the depth.
② Then, keeping the push button pressed, turn the handwheel and set the desired scale to the aligning mark.

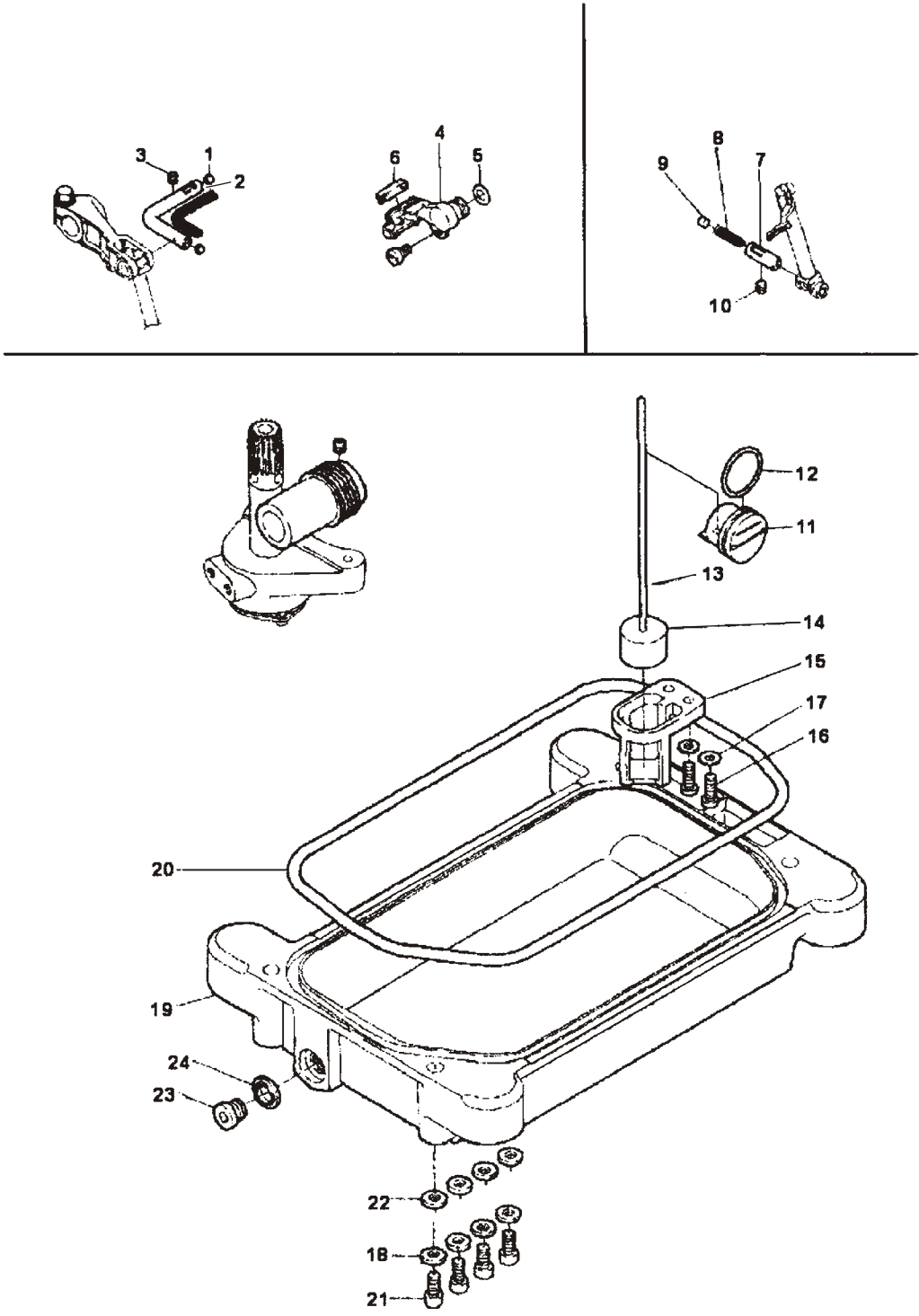
注: 针脚长度的调节务必请在调节差动比之后进行。

Note: Stitch length adjustment must only be made after the differential feed ratio has been changed.



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21、供油机构（2）/LUBRICATION FRAME（2）

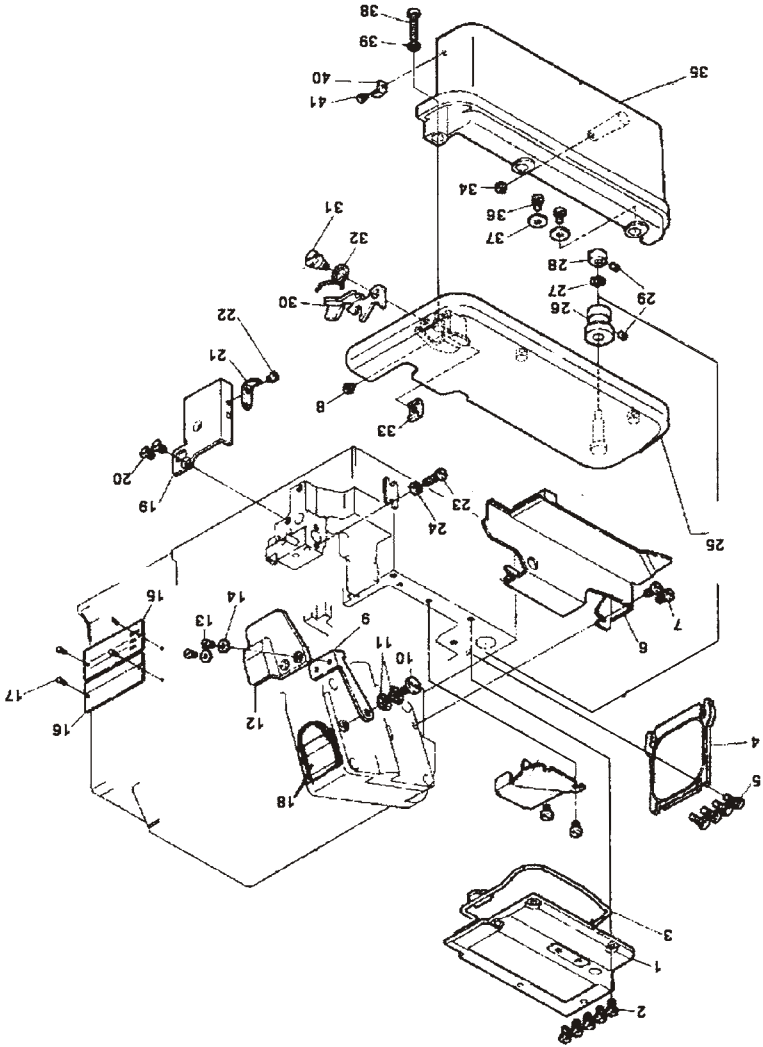


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-21-

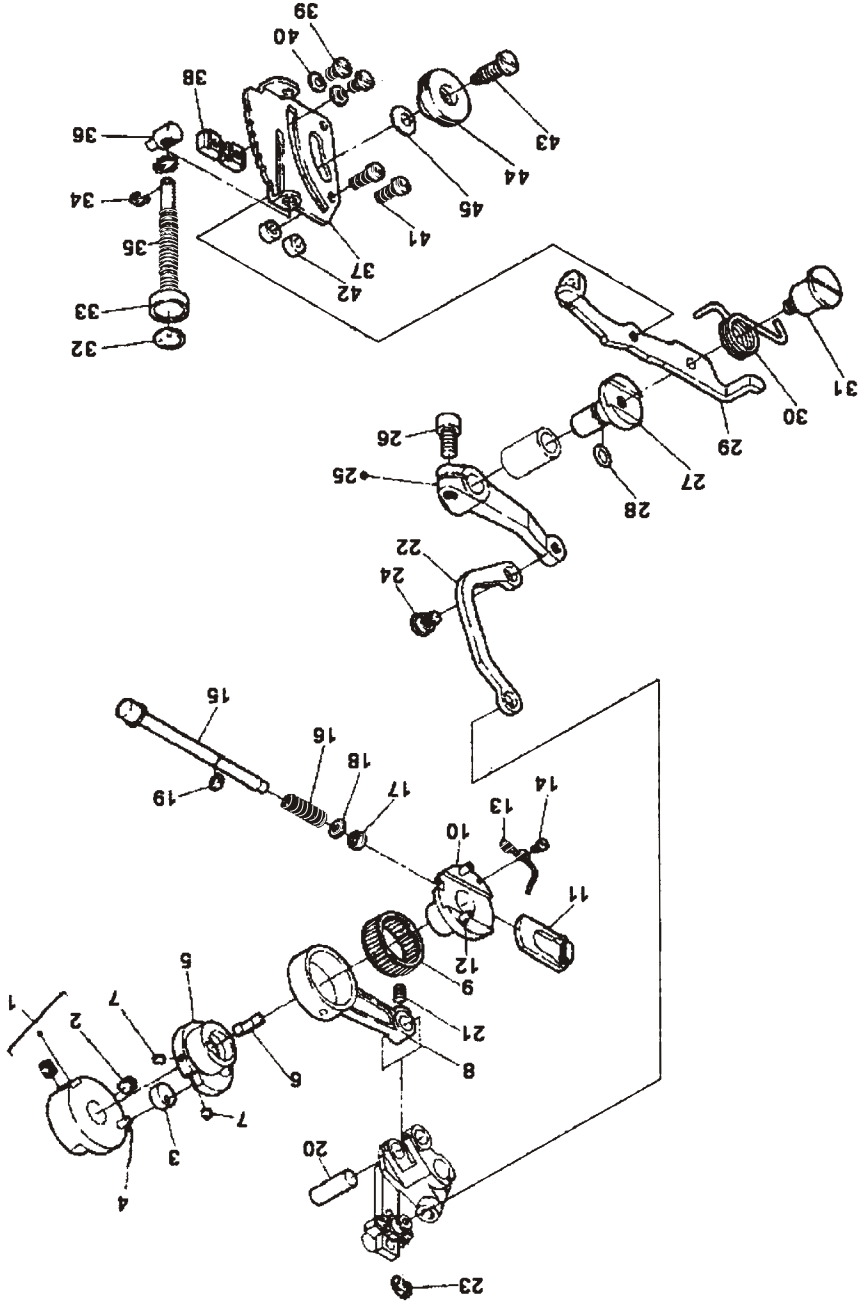
序号 No.	件号 Parts No.	名称 Name	NAME OF PARTS	数量 Number
41	Z-91-101409-15	螺钉	screw	1
40	Z-91-101448-15	横盖限位板	position limiting plate	1
39	Z-12-301001-15	垫圈	washer	1
38	Z-91-101447-15	螺钉	screw	1
37	Z-91-101446-15	垫圈	washer	2
36	Z-91-101019-15	螺钉	screw	2
35	Z-91-102060-91	横盖	lower left side cover	1

3、外罩机构(2) /OUTER COVER FRAME(2)



3、外罩机构（2）/OUTER COVER FRAME(2)

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16、送布机构(1)/FEEDING FRAME(1)

20、供油机构（1）/LUBRICATION FRAME（1）

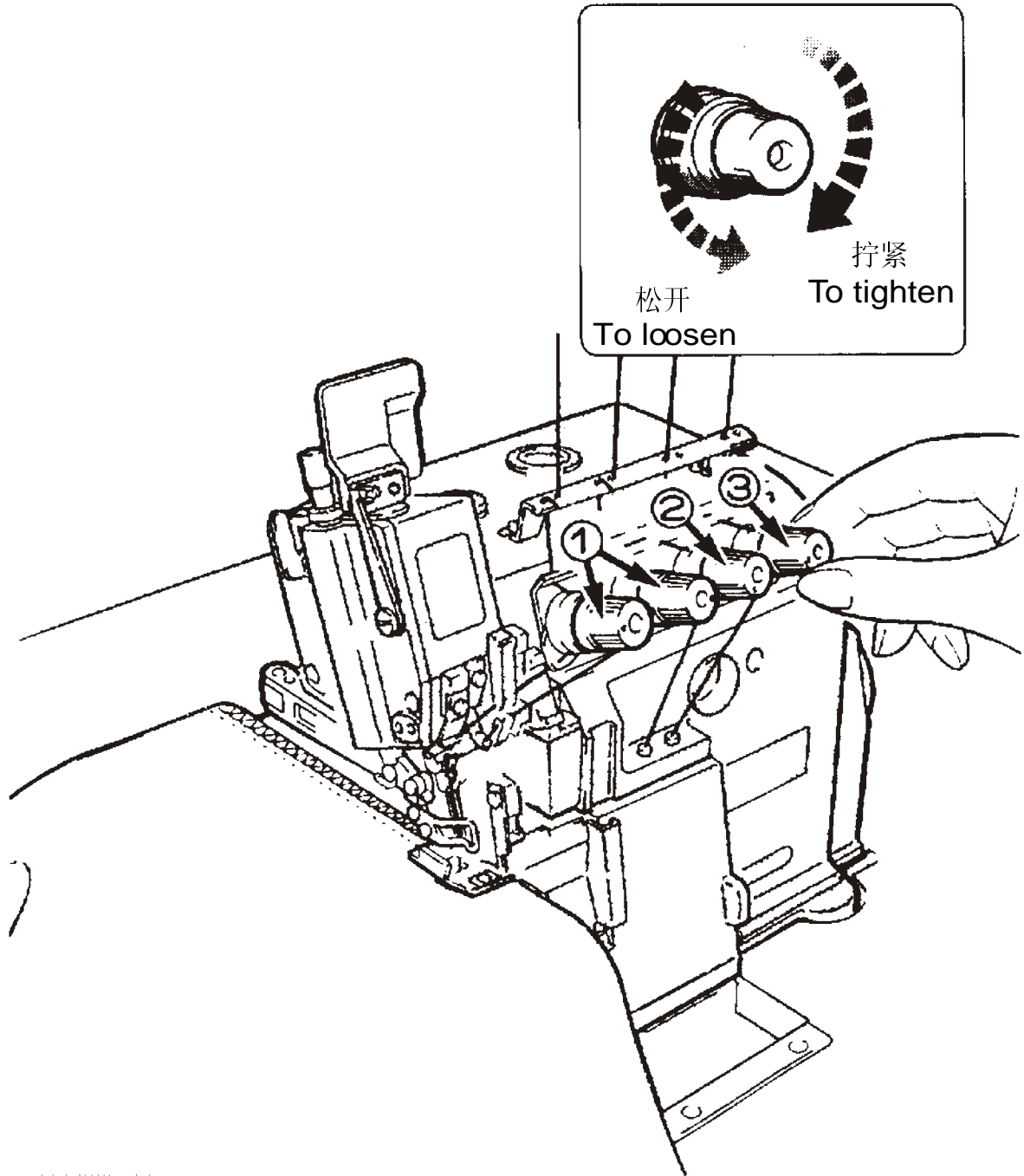
序号 No.	件号 Parts No.	名 称	NAME OF PARTS	数量 Number
1	Z-91-102237-05	斜齿轮	bevel gear	1
2	Z-91-101046-15	螺钉	screw	1
3	Z-91-101196-05	油泵体	oil pump body	1
4	Z-91-101198-05	油泵轴	shaft of oil pump	1
5	Z-91-101199-05	油泵内转子	insiderotor of oil pump	1
6	Z-91-101200-05	油泵外转子	outside rotor of oil pump	1
7	Z-91-101201-05	端盖	end cover	1
8	Z-91-101202-15	螺钉	screw	1
9	Z-91-101205-05	内过滤网	inside filter net	1
10	Z-91-101206-05	外过滤网	outside filter net	4
11	Z-91-101203-15	紧固圈	fastening ring	1
12	Z-91-101204-15	螺钉	screw	1
13	Z-12-003005-15	螺母	nut	1
14	Z-91-101211-15	螺钉接头	joint part	1
15	Z-91-101212-05	螺钉接头	joint part	1
16	Z-91-101214-15	螺钉	screw	2
17	Z-91-102248-75-001	分油杆	oil division pole	1
18	Z-14-601006-05	钢球	steel ball	1
19	Z-11-101011-15	螺钉	screw	1
20	Z-12-302001-15	垫圈	washer	1
21	Z-12-307001-15	垫圈	washer	1
22	Z-91-101021-15	螺钉	screw	3
23	Z-91-102241-15	油分配器盖	cover of oil distributor	1
24	Z-91-102240-75-004	油分配器密封圈	seal ring of oil distributor	1
25	Z-91-133474-91	滤油器组件	oil filter	1
26	Z-91-102239-05	油分配器	oil distributor	1
27	Z-91-102246-15	蜗杆导油板	worm pde oil guide plate	1
28	Z-11-101010-25	螺钉	screw	2
29	Z-91-134467-45	油管夹	fastening ring	4
30	Z-91-1012257-05	吸油软管	hose	4

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线状态的调节
Adjusting the thread tension

线张力状态的调节，请用针线调节螺帽①、上弯针线调节螺帽②、弯针线调节螺帽③来进行调节。

Make tension adjustments with the needle thread knob ①、the upper looper knob ②、and the lower looper knob ③.



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序号 No.	件号 Parts No.	名 称	NAME OF PARTS	数量 Number
1	Z-91-102132-05	针距调节偏心轮片	eccentric wheel of stitch length regulator	1
2	Z-91-101046-15	螺钉	screw	2
3	Z-91-101122-05	送布偏心导轮	guiding wheel of feeding eccentric wheel	1
4	Z-91-101121-05	销	pin	1
5	Z-91-101123-05	送布偏心轮	feeding eccentric wheel	1
6	Z-91-101124-15	弹簧	spring	1
7	Z-91-101125-15	螺钉	screw	1
8	Z-91-102133-05	滚针轴承连杆	connecting bar	1
9	Z-91-101127-95	轴承	bearing	1
10	Z-91-101129-05	针距调节凸轮	adjusting cam for stitch length	1
11	Z-91-101132-05	内齿锁紧块	sliding block with inner teeth	1
12	Z-13-003007-15	销	pin	2
13	Z-91-101130-15	扭簧	spring	1
14	Z-91-101131-15	螺钉	screw	1
15	Z-91-102140-25	按钮轴	button shaft	1
16	Z-91-102141-15	弹簧	spring	1
17	Z-91-102142-75-004	油封	oil seal	1
18	Z-91-102143-05	垫圈	washer	1
19	Z-12-606001-15	挡圈	retaining spring	1
20	Z-91-101135-05	销	pin	1
21	Z-91-101136-15	螺钉	screw	1
22	Z-91-102135-05	差动调节右曲柄	right crank of differential regulator	1
23	Z-91-102092-15	开口挡圈	click-in spring	1
24	Z-91-101149-15	螺钉	screw	1
25	Z-91-102139-15	差动调节左曲柄	left crank of differential regulator	1
26	Z-91-101137-15	螺钉	screw	1
27	Z-91-101152-15	差动调节轴	shaft of differential regulator	1
28	Z-91-101153-75-004	O型圈	O ring	1
29	Z-91-102144-15	调节杆	adjusting bar	1
30	Z-91-101155-15	扭簧	tortion spring	1
31	Z-91-101156-15	螺钉	screw	1
32	Z-91-102149-95	指示标贴	loge plate	1
33	Z-91-102148-15	微调螺栓	screw	1
34	Z-12-606001-15	开口挡圈	click-in spring	1

16、送布机构(1)/FEEDING FRAME(1)

-20-

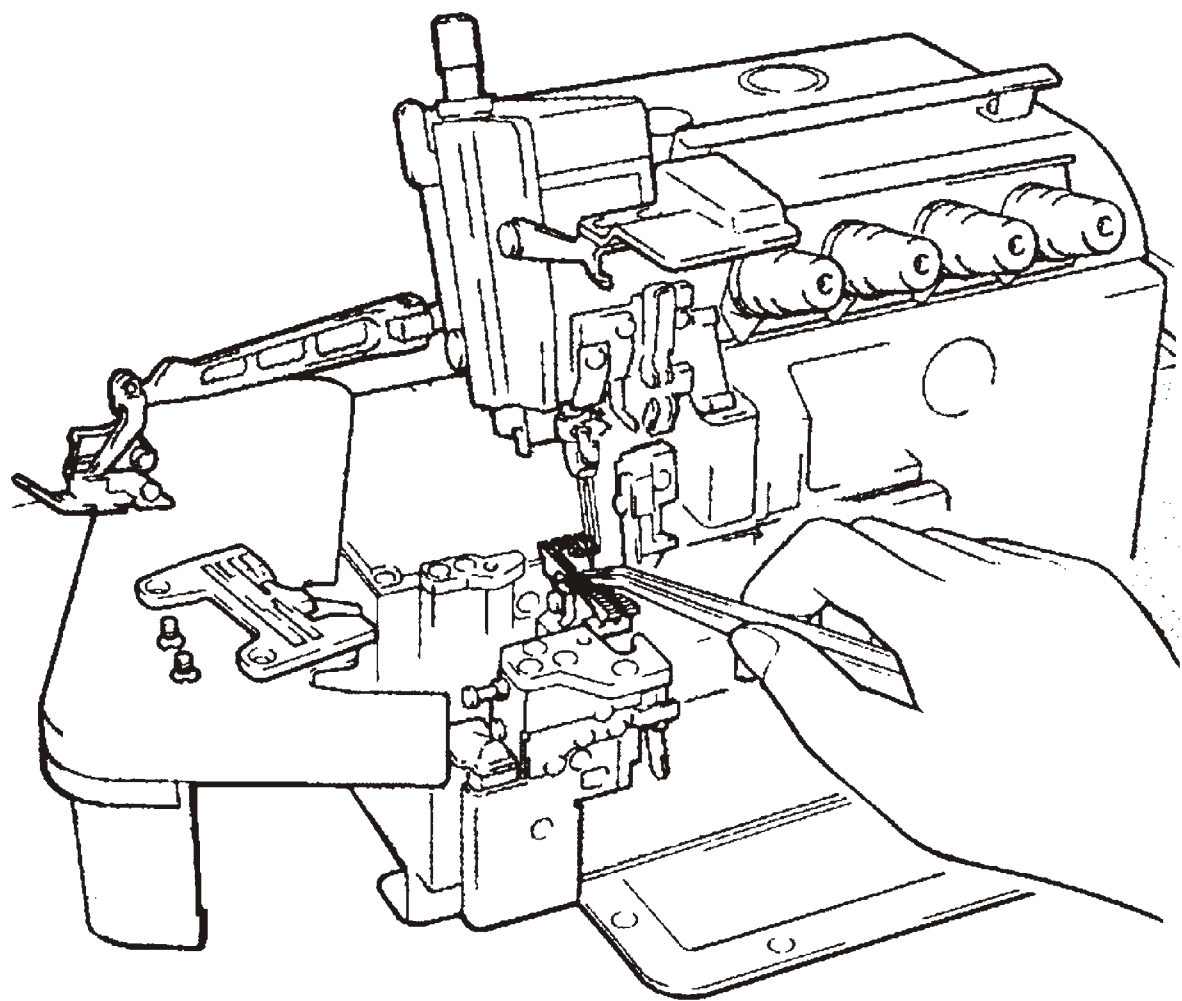
序号 No.	件号 Parts No.	名 称	NAME OF PARTS	数量 Number
1	Z-91-102047-05	左上盖	left upper cover	1
2	Z-91-101008-15	螺钉	screw for left cover	5
3	Z-91-102048-75-004	左上盖垫圈	washer for left upper cover	1
4	Z-91-101036-91	后盖板组件	comp on ent of back cover	1
5	Z-91-101039-15	螺钉	screw	2
6	Z-91-102220-25	内盖板	inside cover	1
7	Z-91-101019-15	螺钉	screw	2
8	Z-91-102221-75-004	泡沫橡胶垫	rubor cushion	1
9	Z-91-102053-35	安全罩架	stand of safety cover	1
10	Z-91-101310-15	螺钉	cscrew	1
11	Z-91-101026-15	垫圈	washer	2
12	Z-91-102355-05	安全罩	safety cover	1
13	Z-91-101310-15	螺钉	screw	2
14	Z-91-101308-15	垫圈	washer	2
15	Z-91-101903-95	标志牌	loge plate	1
16	Z-91-102213-95	型号牌	model plate	1
17	Z-13-103001-05	铆钉	rivet	4
18	Z-91-102319-95	装饰牌	decorative plate	1
19	Z-91-102055-25	前盖左	lft part of front cover	1
20	Z-91-101035-15	前盖左螺钉	screw for left part of front cover	2
21	Z-91-101032-15	挡板	fender	1
22	Z-91-101033-15	挡板螺钉	screw for fender	1
23	Z-91-101220-15	螺钉	screw	1
24	Z-12-003001-15	螺母	nut	1
25	Z-91-102057-91	大盖组件	comp onent of surface cover	1
26	Z-91-101438-15	大盖铜套	brass bush for surface cover	1
27	Z-91-101026-15	垫圈	washer	1
28	Z-91-101025-15	螺钉	screw	1
29	Z-91-101066-15	螺钉	screw	1
30	Z-91-101440-15	大盖卡紧板	grip part for surface cover	1
31	Z-91-101442-15	螺钉	screw	1
32	Z-91-101441-15	弹簧	spring	1
33	Z-91-101443-15	锁紧板	locking plate	1
34	Z-91-101034-75-004	防震橡胶垫	quake-proof rubber cushion	1

3、外罩机构(2)/OUTER COVER FRAME(2)

缝纫机的清扫
Cleaning the machine

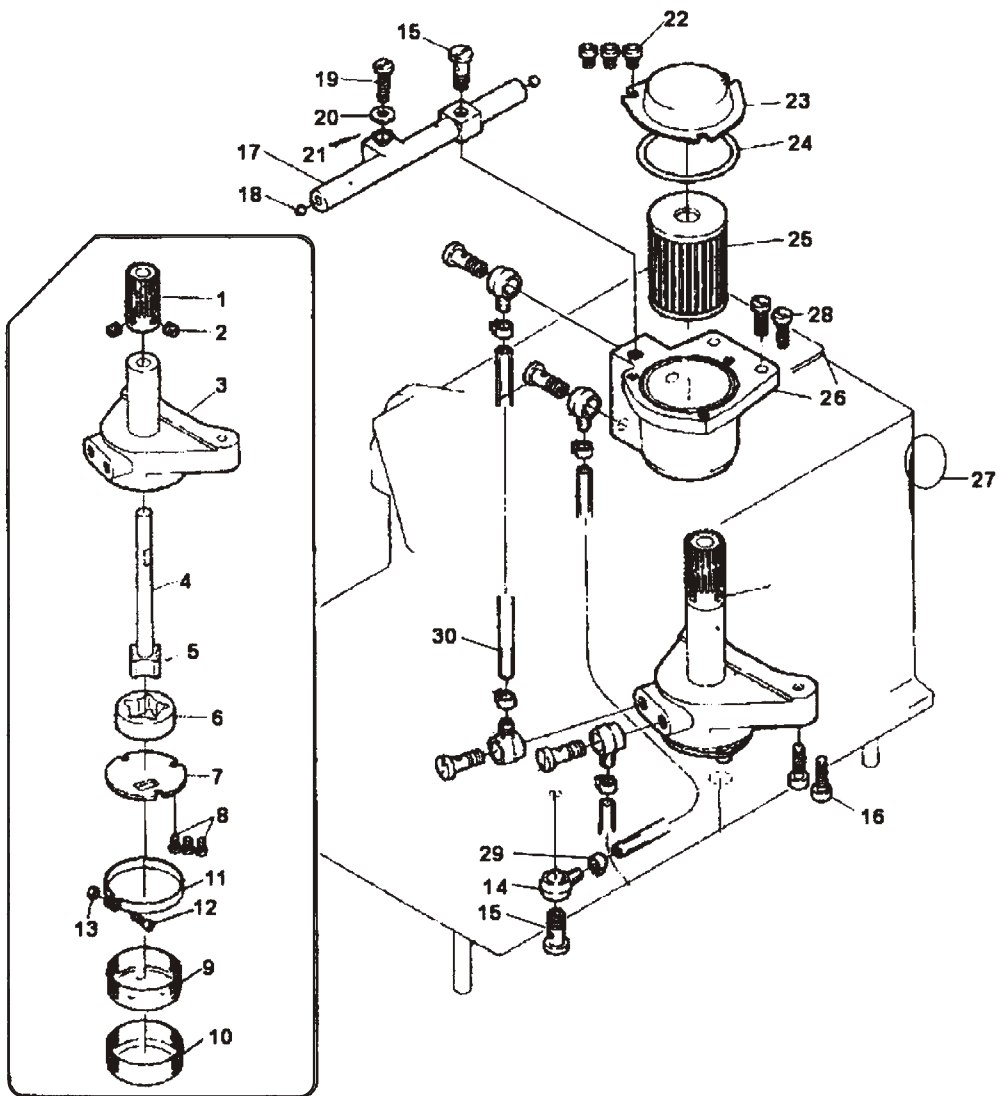
缝纫机的清扫，以针板槽及送布牙周围为主。

Mainly the slots of the needle plate and the feed rows should be cleaned.



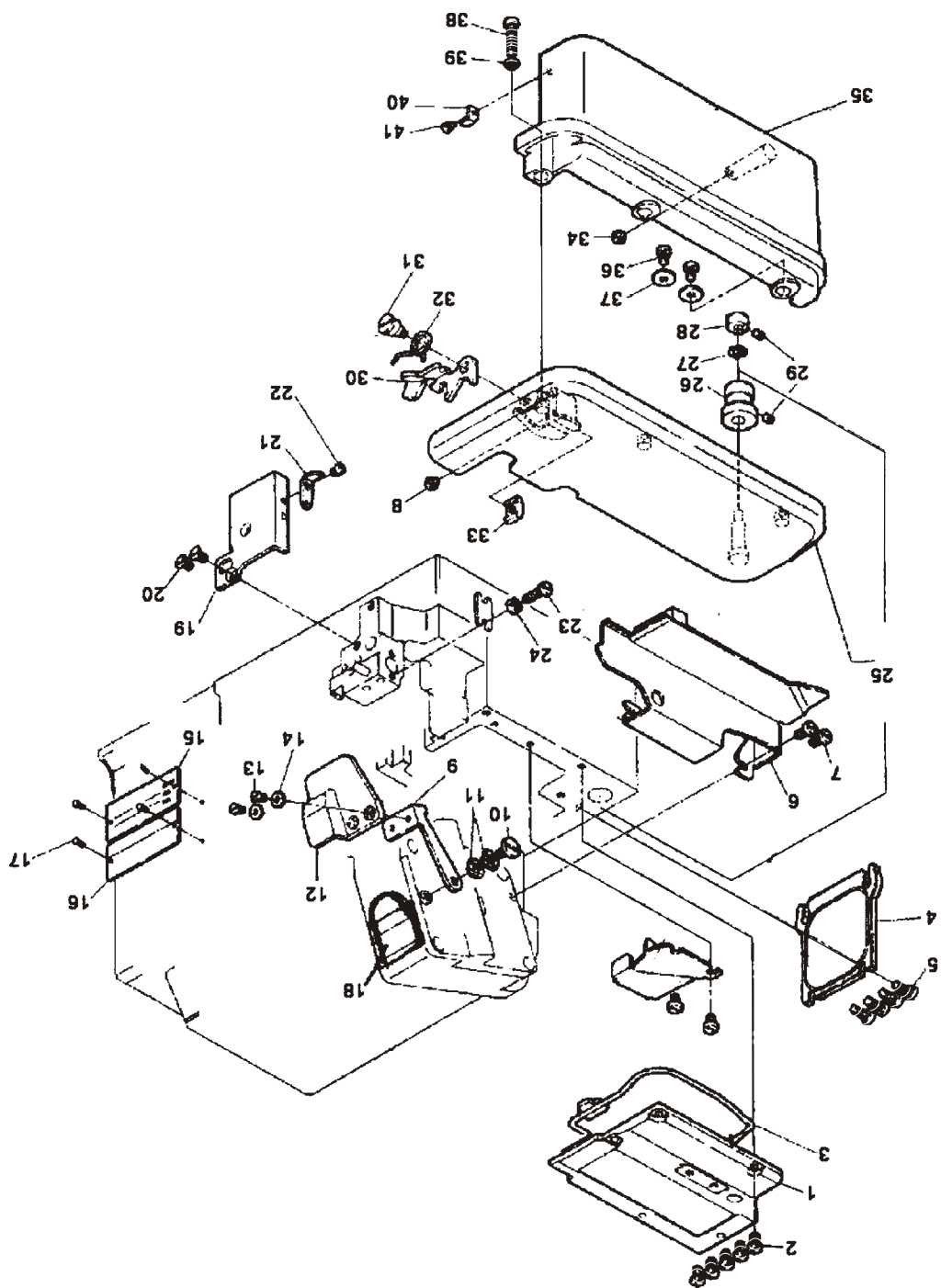
-10-

20、供油机构（1）/LUBRICATION FRAME（1）



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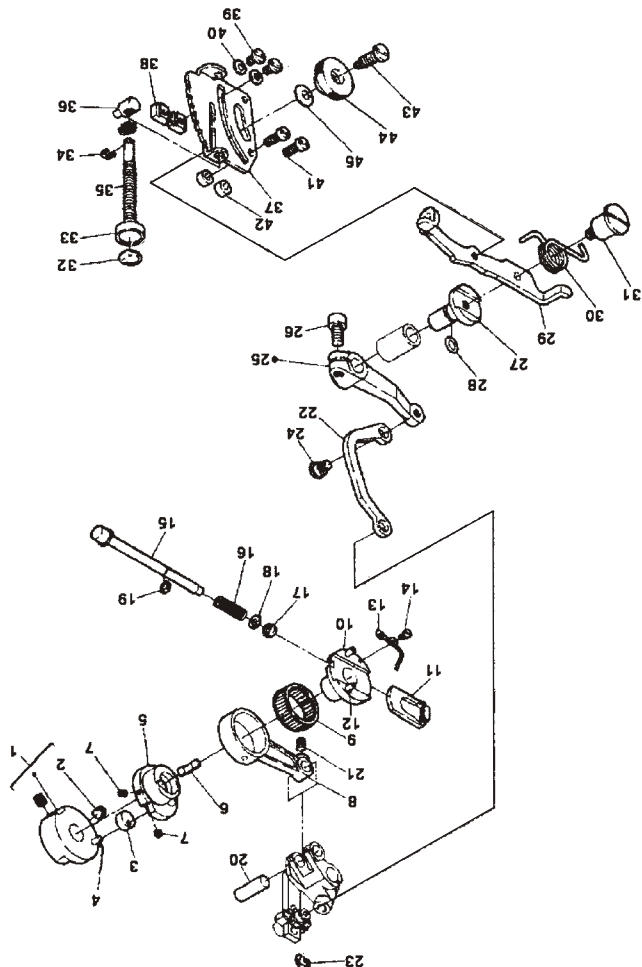


3、外罩机构(2)/OUTER COVER FRAME(2)

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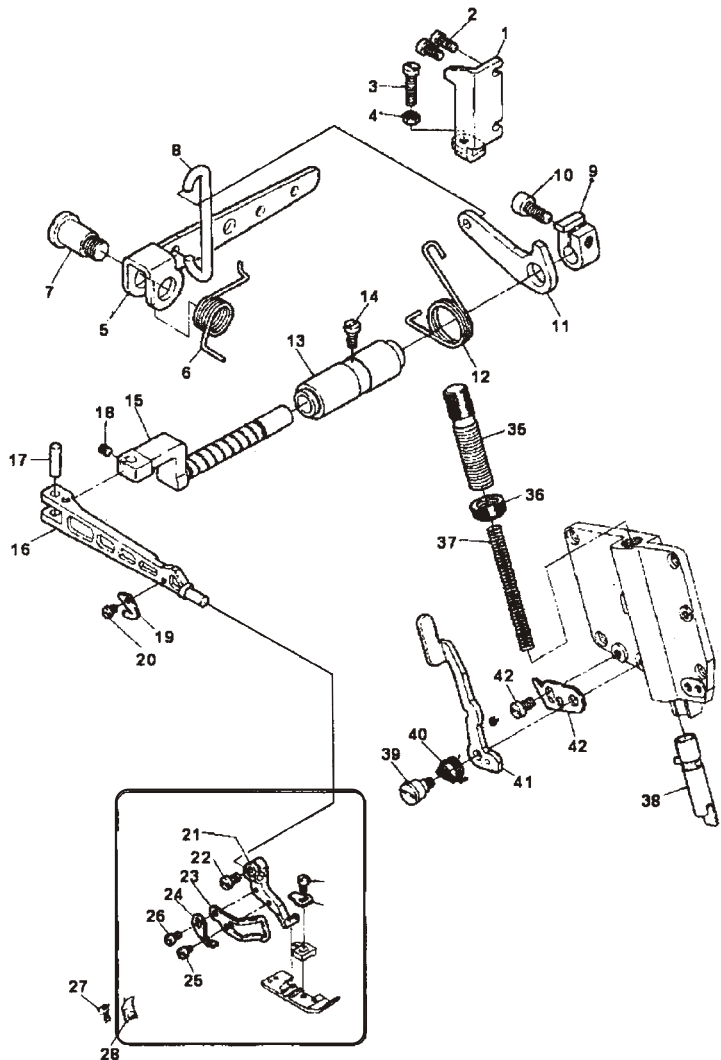
No.	序号	Parts No.	名称	NAME OF PARTS	数量
35	Z-91-102150-15	弹簧	spring		1
36	Z-91-102151-15	螺母	nut		1
37	Z-91-102146-15	调节指示板	indication plate of adjustment		1
38	Z-91-102147-15	限位块	position plate		2
39	Z-91-101021-15	螺钉	screw		2
40	Z-12-305001-15	垫片	washer		2
41	Z-91-101321-15	螺钉	screw		1
42	Z-91-102152-15	垫圈	washer for indication plate		1
43	Z-91-101162-15	螺钉	screw		1
44	Z-91-101161-15	螺母	nut		1
45	Z-91-101159-15	垫片	washer		1

16、送布机构(1)/FEEDING FRAME(1)



16、送布机构(1)/FEEDING FRAME(1)

19、压脚机构/PRESSER FOOT FRAME



19、压脚机构/PRESSER FOOT FRAME

序号 No.	件号 Parts No.	名 称	NAME OF PARTS	数量 Number
35	Z-91-102036-25	调压螺钉	screw for adjusting pressure of presser foot	1
36	Z-91-102292-75-001	调压螺母	nut for adjusting pressure of presser foot	1
37	Z-91-101099-15	弹簧	spring	1
38	Z-91-102034-05	压脚杆	presser bar	1
39	Z-91-101096-15	螺钉	screw	1
40	Z-91-101095-15	弹簧	spring	1
41	Z-91-101094-25	压脚扳手	hand lifter of presser foot	1
42	Z-91-102035-15	挡板	fender	1
43	Z-91-101019-15	螺钉	screw	1

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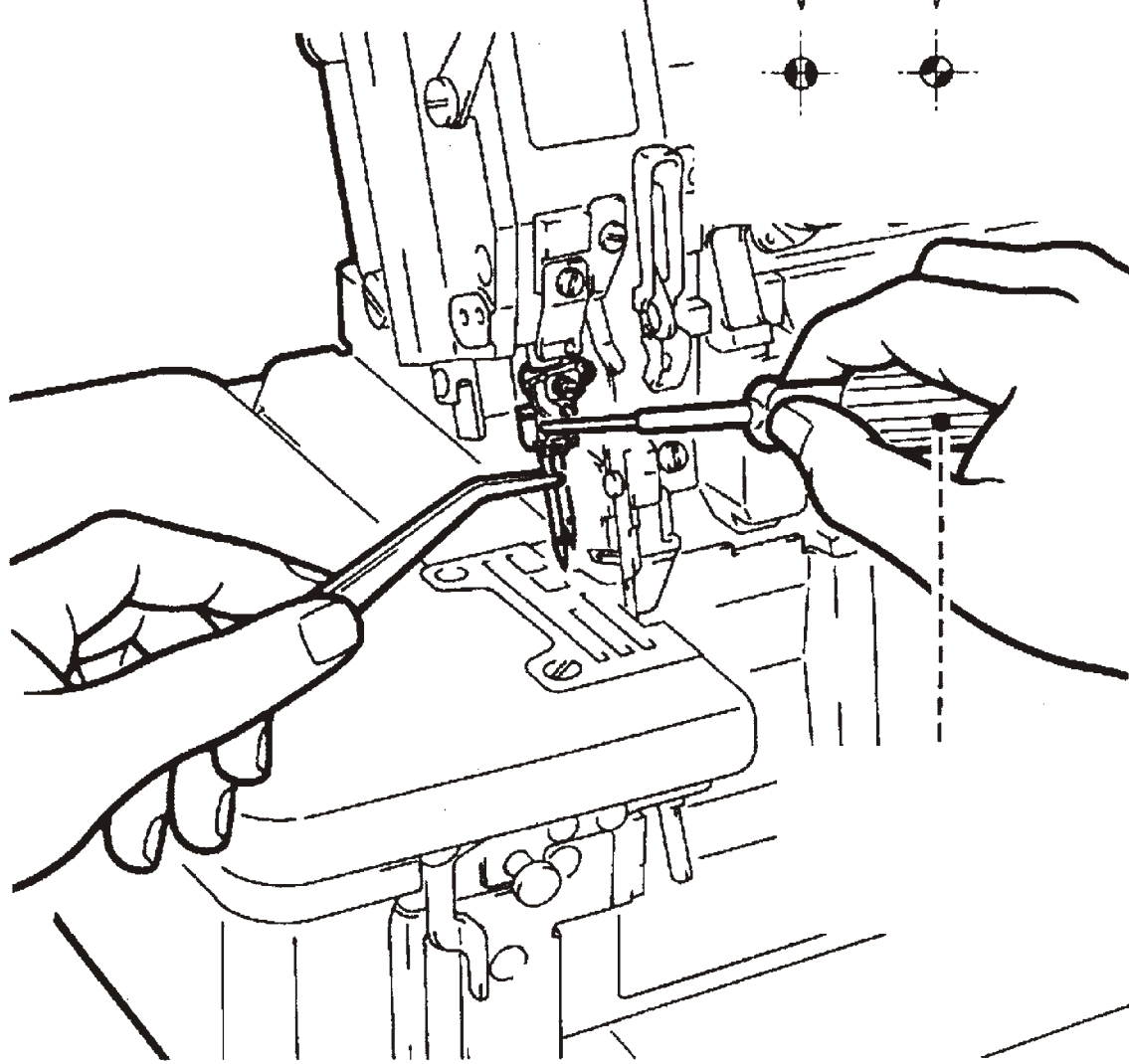
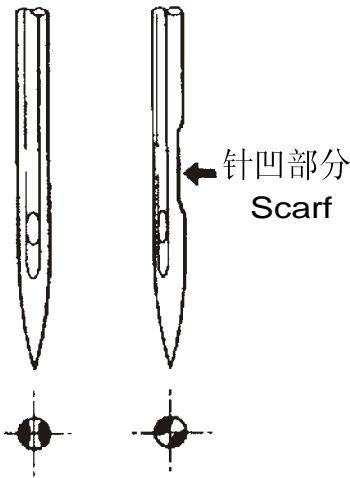
换针
Replacing the needle

准确辨认针的前后，请将针凹向着后方，即背向操作者进行安装。
针要牢固的插到孔的最深处。

- * Check the needle carefully to see that the scarf is turded to the rear of the machine.
- * Insert the needle to the proper depth, and fasten securely.

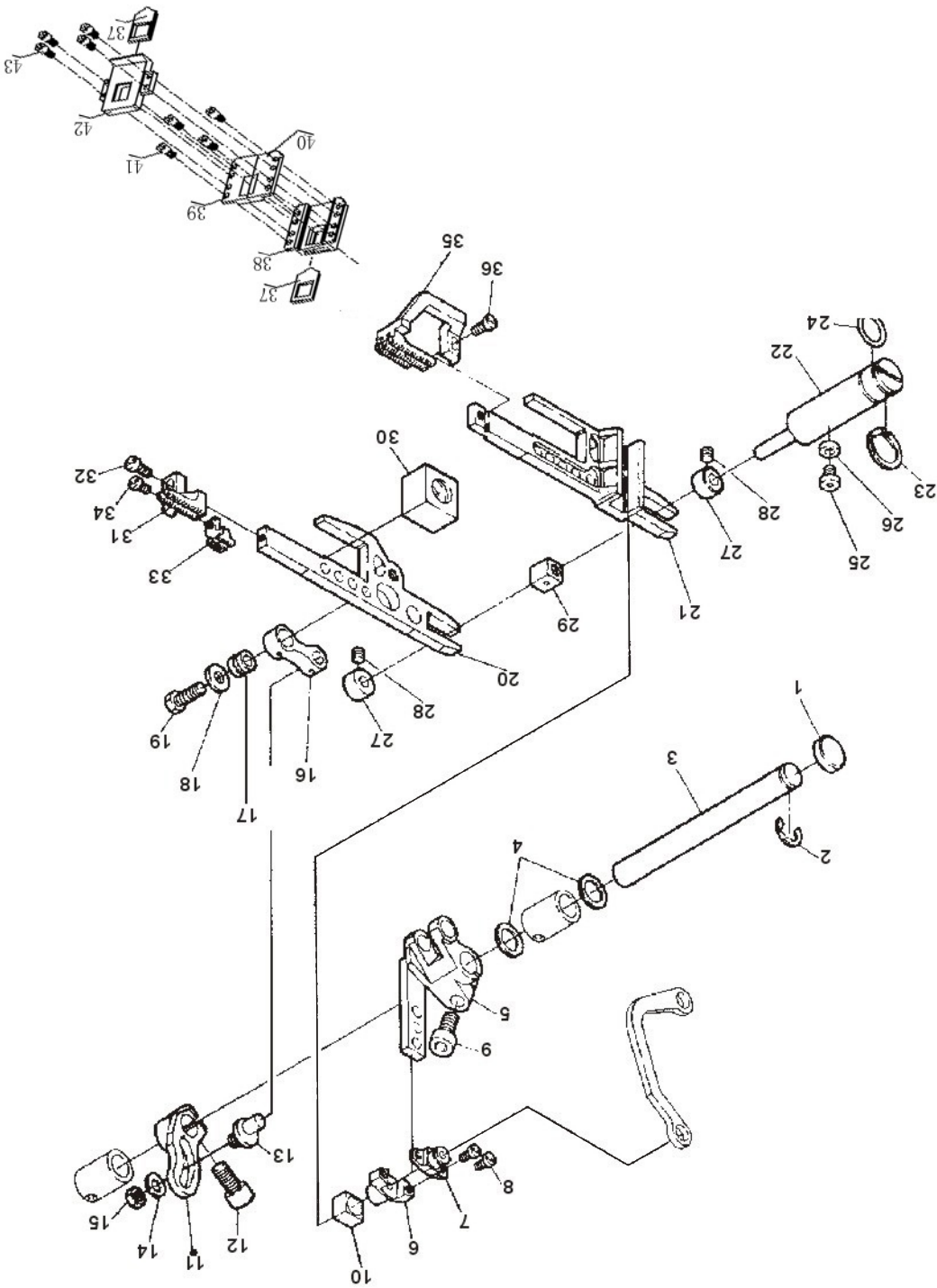
标准使用针：风琴DC×27
包缝系列：风琴DC×27
Standard needle:Organ DC×27
E3200H・5200Hseries:Organ Dc×27

OK! NO!



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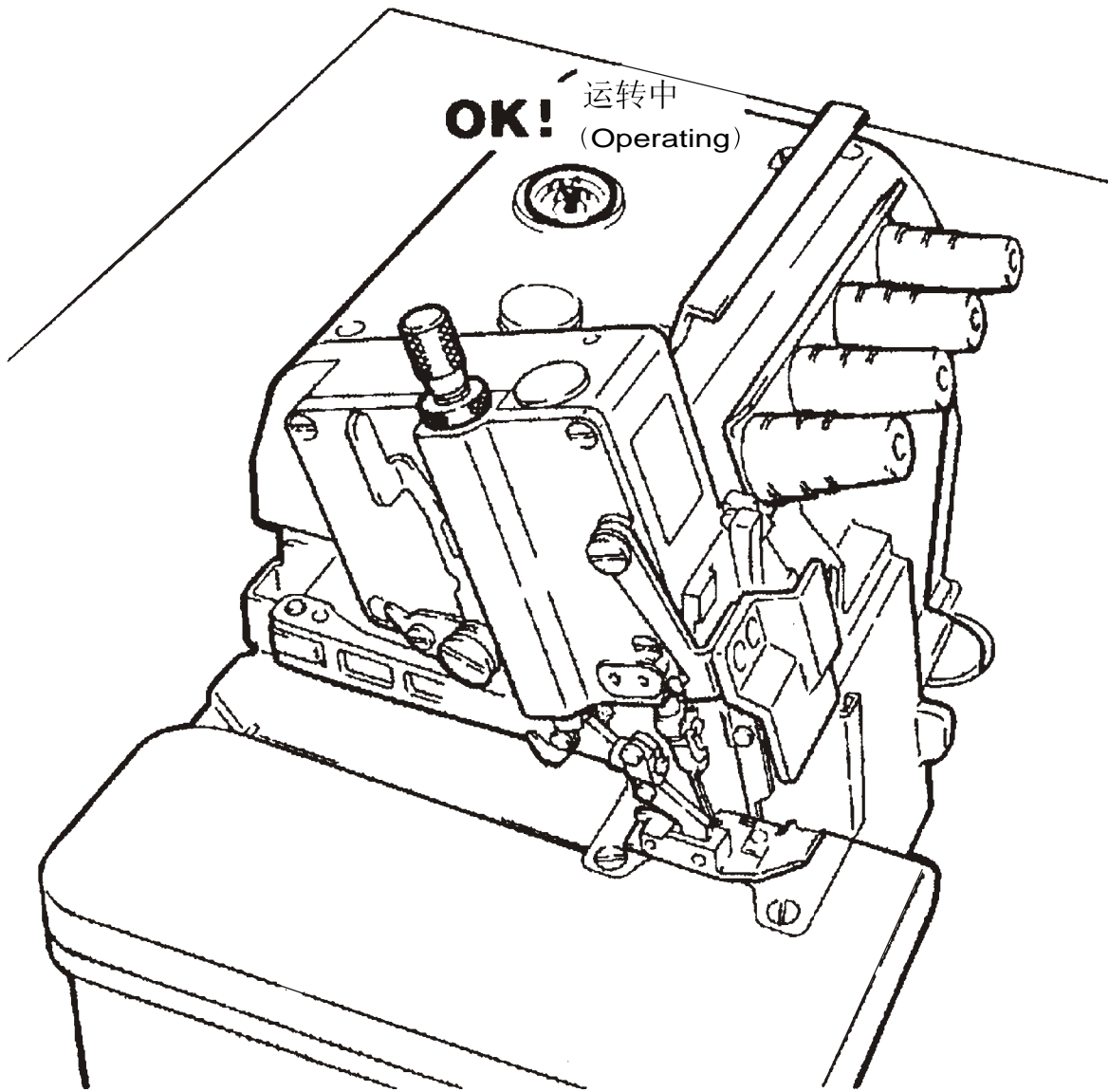
17、送布机构(2)/FEEDING FRAME(2)

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序号 No.	件号 Parts No.	名 称	NAME OF PARTS	数量 Number
1	Z-91-102019-75-001	上盖	upper cover	1
2	Z-91-102291-75-004	橡胶塞	rubber plug	1
3	Z-91-102290-05	上盖视窗	oil sight window	1
4	Z-91-102293-15	螺钉	screw	4
5	Z-91-102028-75-004	上盖密封圈	seal ring for upper cover	1
6	Z-91-101034-75-004	防震橡胶垫	ruver cushion	3
7	Z-91-102030-75-001	侧盖	side cover	1
8	Z-91-101687-15	螺钉	screw	4
9	Z-91-102419-75-002	皮带轮罩	belt cover	1
10	Z-11-101016-15	皮带轮罩螺钉	screw for belt cover	3
11	Z-91-102287-25	风扇盖	fan cover	1
12	Z-91-101019-15	螺钉	screw	2
13	Z-91-102040-75-001	前盖右	right part of front cover	1
14	Z-91-102358-25	前盖中	middle part of front cover	1
15	Z-91-101021-15	螺钉	screw	2
16	Z-91-102042-15	前盖右挡板	fender for right part of front cover	1
17	Z-91-101024-15	螺钉	screw	1
18	Z-91-102043-15	导向板	guiding plate	1
19	Z-91-134346-15	螺钉	screw	1
20	Z-91-102044-05	支架	supporting part	1
21	Z-11-305001-15	螺钉	screw	1
22	Z-91-101125-15	螺钉	screw	1
23	Z-91-101319-15	销	pin	1
24	Z-91-101320-15	弹簧	spring	1
25	Z-91-101066-15	螺钉	screw	1
26	Z-91-101321-15	螺钉	screw	3
27	Z-91-101023-15	弹簧板	spring plate	1
28	Z-91-101024-15	螺钉	screw	2
29	Z-91-102038-05	上弯针架盖	cover for upper looper stand	1
30	Z-91-102293-15	螺钉	screw	4

2、外罩机构(1)/OUTER COVER FRAME(1)

检查机油的循环
Checking the oil circulation



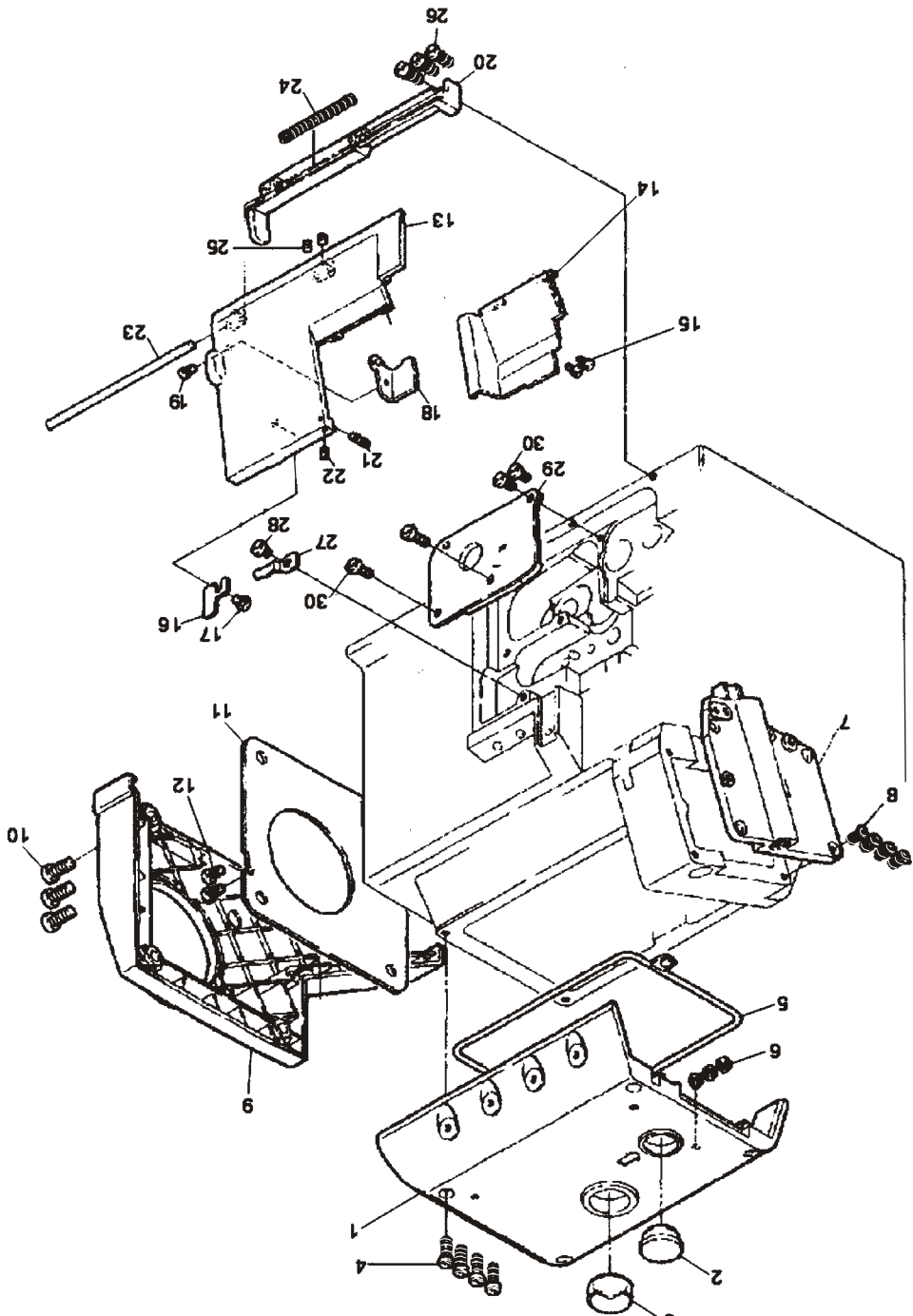
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19、压脚机构/PRESSER FOOT FRAME

序号 No.	件号 Parts No.	名 称	NAME OF PARTS	数量 Number
1	Z-91-102201-15	制动板	brake plate	1
2	Z-91-101039-15	螺钉	screw	2
3	Z-91-101116-15	螺钉	screw	1
4	Z-12-003003-15	螺母	nut	1
5	Z-91-102202-15	抬压脚杠杆	lecvor for presser foot lifting	1
6	Z-91-102203-15	杠杆扭簧	torsing spring foe lever	1
7	Z-91-101112-15	螺钉	screw	1
8	Z-91-101113-15	抬压脚拉杆	pulling lever for press foot lifting	1
9	Z-91-101108-05	抬压脚曲柄	crank for presser foot lifting	1
10	Z-91-101109-15	螺钉	screw	1
11	Z-91-101106-15	抬压脚连杆	connecting bar for presser foot lifting	1
12	Z-91-101105-15	弹簧	spring	1
13	Z-91-102204-05	压脚轴套	bush of presser foot lifting	1
14	Z-91-101458-15	螺钉	screw	1
15	Z-91-102206-05	压脚轴	shaft of presser foot lifting	1
16	Z-91-102207-25	压脚臂	arm of presser foot lifting	1
17	Z-91-101472-05	销	pin	1
18	Z-91-101473-15	螺钉	screw	1
19	Z-91-101474-15	割线刀	thread cutter	1
20	Z-91-101191-15	螺钉	screw	1
21	Z-91-102209-05	压脚连接柄	connecting arm of presser foot	1
22	Z-91-105135-15	螺钉	screw	1
23	Z-91-102210-15	护指架	fmgier guard	1
24	Z-91-101409-15	螺钉	screw	1
25	Z-91-102212-15	限位板	position limiting plate	1
26	Z-91-134346-15	螺钉	screw	1
27	Z-91-101484-05	辅助板	assitant plate	1
28	Z-91-101485-15	螺钉	screw	1
29	Z-91-102214-15	弹簧压板	spring plate	1
30	Z-91-101483-15	螺钉	screw	1
31	Z-91-102215-05	压脚吐线舌	finger plate of presser foot	1
32	Z-91-102216-05	压布块	material press block	1
33	Z-91-101487-15	螺钉	screw	1
34	Z-91-102217-05	压脚底板	base plate of presser foot	1

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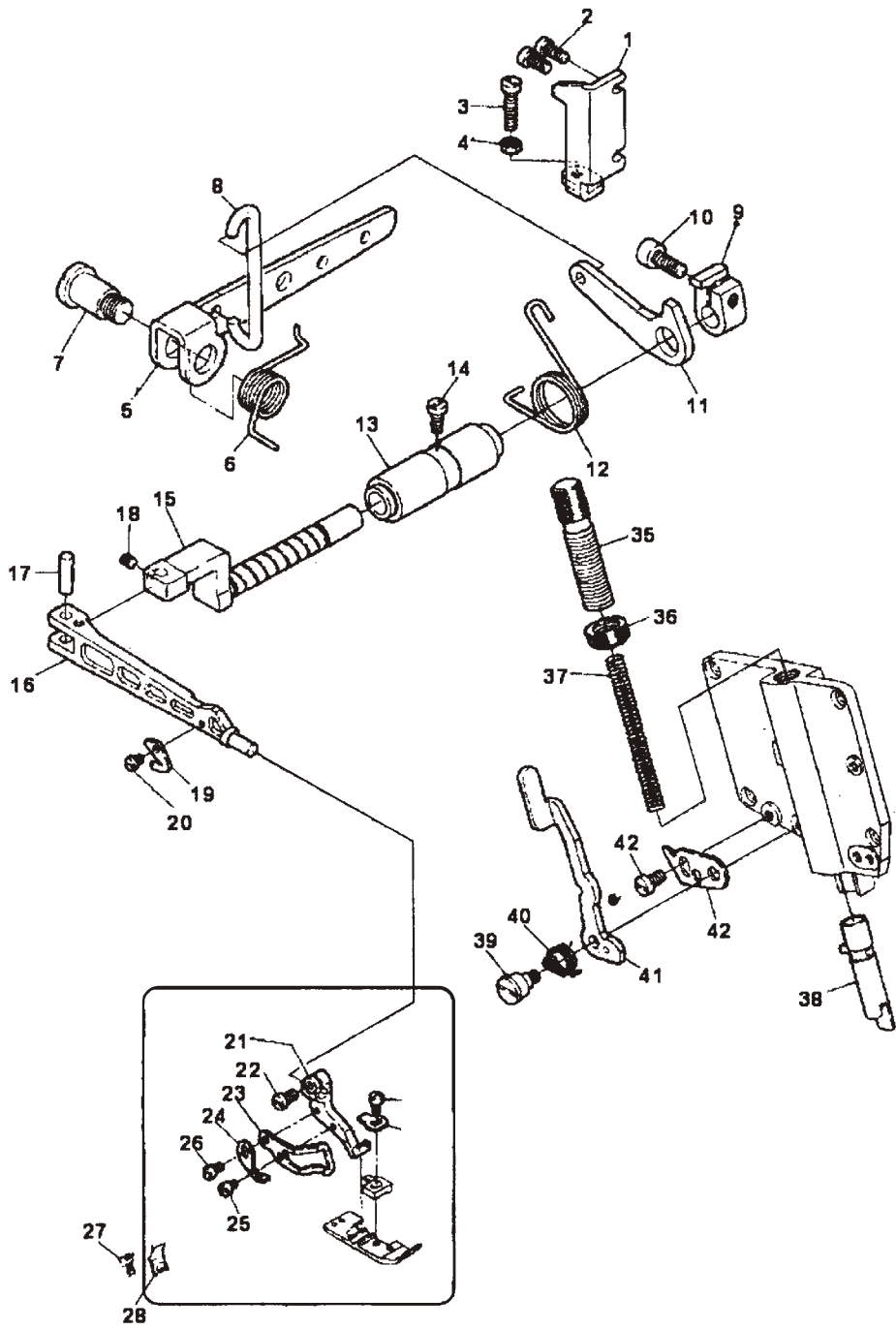
2、外罩机构(1)/OUTER COVER FRAME(1)

17、送布机构(2)/FEEDING FRAME(2)

序号 No.	件号 Parts No.	名 称	NAME OF PARTS	数量 Number
1	Z-91-134214-05	橡胶垫	rubber plug	1
2	Z-91-101068-15	挡圈	retaining spring	1
3	Z-91-102154-05	送料轴	feeding shaft	1
4	Z-91-101067-05	垫片	washer	2
5	Z-91-102135-05	差动调节右曲柄	right crank of differential regulator	1
6	Z-91-102136-05	曲柄滑槽	crank slide troligh	1
7	Z-91-102137-05	曲柄滑槽盖	crank slide troligh cover	1
8	Z-91-101147-15	螺钉	screw	2
9	Z-91-101137-15	螺钉	screw	1
10	Z-91-102165-05	差动牙架滑块	sliding block	1
11	Z-91-102156-05	方口曲柄	crank with rec tangular shaft	1
12	Z-91-101137-05	螺钉	screw	1
13	Z-91-102157-15	送料连杆销	pin with thread for feeding connecting rod	1
14	Z-12-305002-15	垫圈	washer	1
15	Z-12-003002-15	螺母	screw	1
16	Z-91-102159-05	送料连杆	feeding connecting rod	1
17	Z-91-102160-05	连杆销套	bush for connecting rod	1
18	Z-91-102161-05	垫圈	washer	1
19	Z-91-102162-15	螺钉	screw	1
20	Z-91-102164-05	送料牙架	stand of feed dog	1
21	Z-91-102165-05	差动牙架	stand of differential feed dog	1
22	Z-91-102168-05	抬牙调节偏心轴	eccentric shaft	1
23	Z-91-102169-15	开口挡圈	click-in spring	1
24	Z-91-102170-75-004	O型圈	O ring	1
25	Z-91-102174-15	螺钉	screw	1
26	Z-91-102175-75-004	橡胶垫	rubber cushion	1
27	Z-91-102171-05	挡圈	retaining ring	2
28	Z-91-101066-15	螺钉	screw	2
29	Z-91-102172-05	滑块	sliding block	1
30	Z-91-102173-05	抬牙滑块	sliding block for feed dog lifting	1
31	Z-91-102177-05	主送料牙	body of main feed dog	1
32	Z-91-101187-15	螺钉	screw	1
33	Z-91-102178-05	辅助送料牙	assistant feed dog	1
34	Z-91-101403-15	螺钉	screw	1

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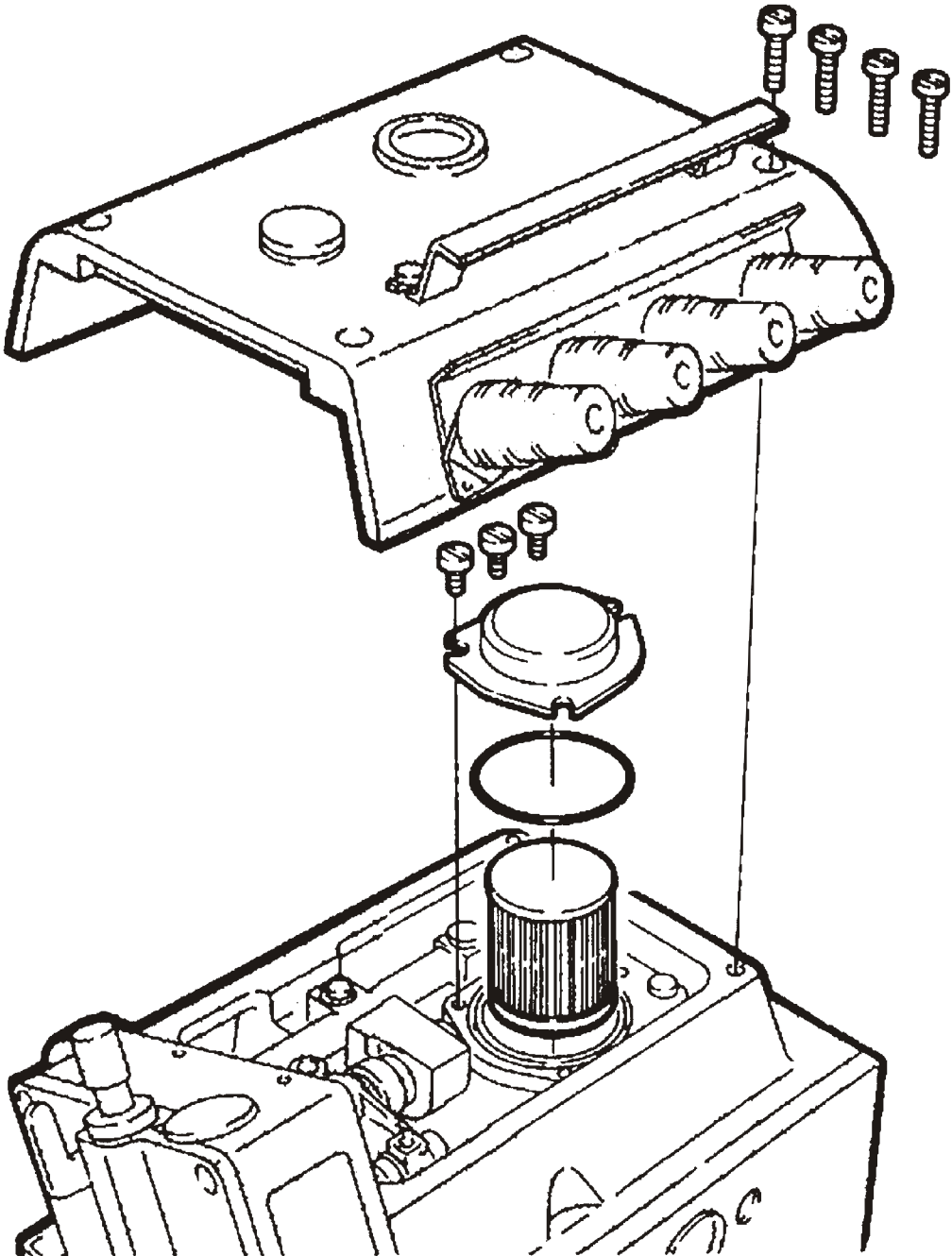
19、压脚机构/PRESSER FOOT FRAME



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检查油质量，更换油
Checking and replacing the oil filter

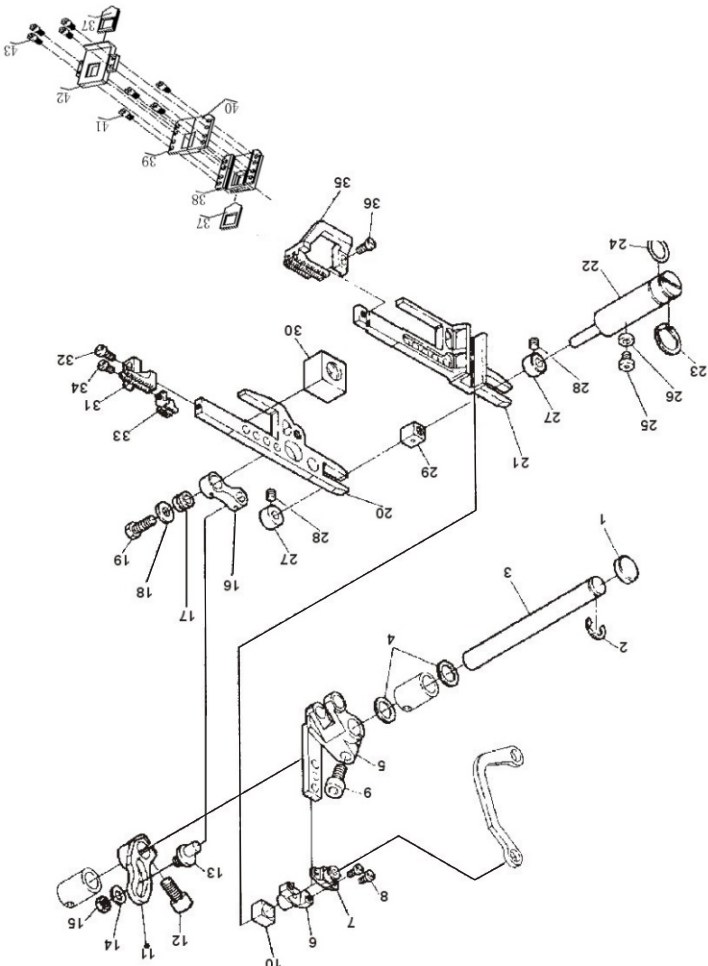
机油每6个月检查并更换。 Check and replace the oil filter every six months.



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序号 No.	件号 Parts No.	名称	名称	NAME OF PARTS	数量 Number
35	Z-91-102179-05	差动送料牙	螺钉	differential feed dog screw	1
36	Z-91-101187-15	螺钉	螺钉	screw	1
37	Z-91-102183-75-004	牙架油封	油封	oil seal	2
38	Z-91-102045-05	内油封架	油封架	oil seal stand	1
39	Z-91-102181-05	牙架右导板	导板	right guiding plate of feed dog stand	1
40	Z-91-102180-05	牙架左导板	导板	left guiding plate of feed dog stand	1
41	Z-91-102182-15	螺钉	螺钉	screw	4
42	Z-91-102184-05	外油封架	油封架	outer oil seal stand	1
43	Z-11-103021-15	螺钉	螺钉	screw	4

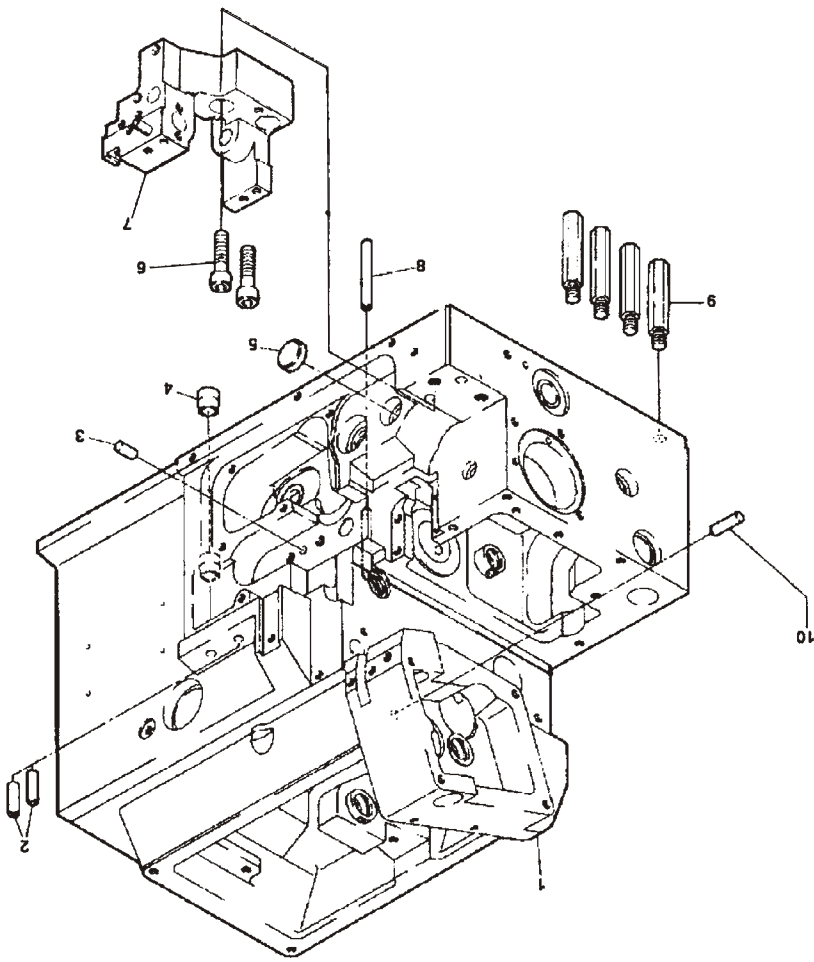
17、送布机构(2)/FEEDING FRAME(2)



17、送布机构(2)/FEEDING FRAME(2)

序号 No.	件号 Parts No.	名称	名称	NAME OF PARTS	数量 Number
1	Z-91-102001-75-001	机壳	机壳	housing	1
2	Z-91-102288-15	上下弯针过线管	过线管	threading pipe for upper and lower loopers	2
3	Z-13-003027-15	销	销	pin	1
4	Z-91-102026-75-001	油标定位套	定位套	locating sleeve of oil scale	1
5	Z-91-102421-95	橡胶塞	橡胶塞	rubber plug	1
6	Z-91-101012-15	螺钉	螺钉	screw	2
7	Z-91-102015-15	下刀座	刀座	lower knife bed	1
8	Z-13-004001-15	销	销	pin	1
9	Z-91-101013-15	机壳支柱	支柱	supp ort for housing	4
10	Z-13-003028-15	销	销	pin	1

1、机壳机构/HOUSING FRAME

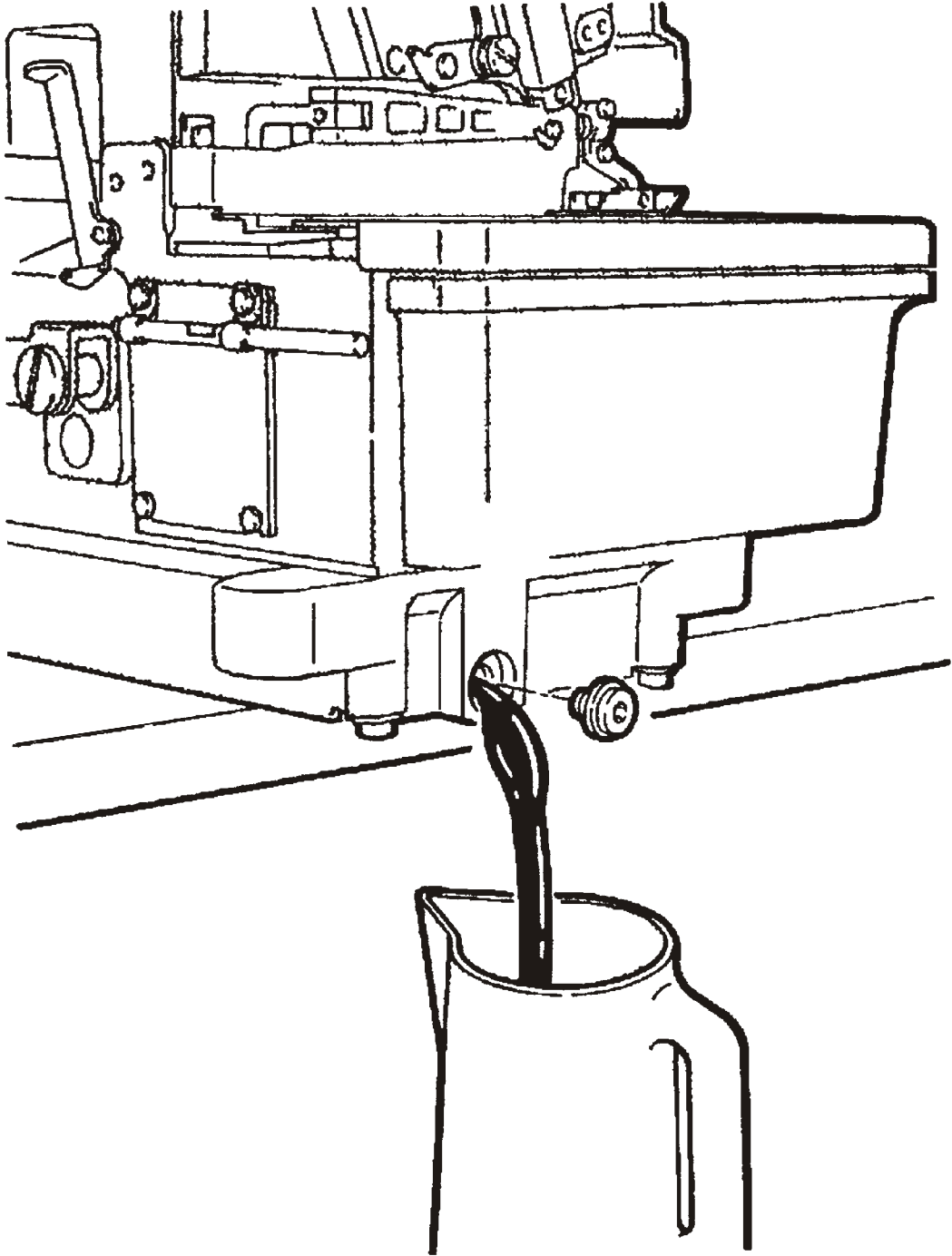


1、机壳机构/HOUSING FRAME

换机油
Replacing the oil

机油的更换，请在使用开始1个月后再更换一次。然后，每6个月更换一次。
供油请参见第2页。

Replacing the oil one month after the first use and every six months thereafter.(See p 2.)



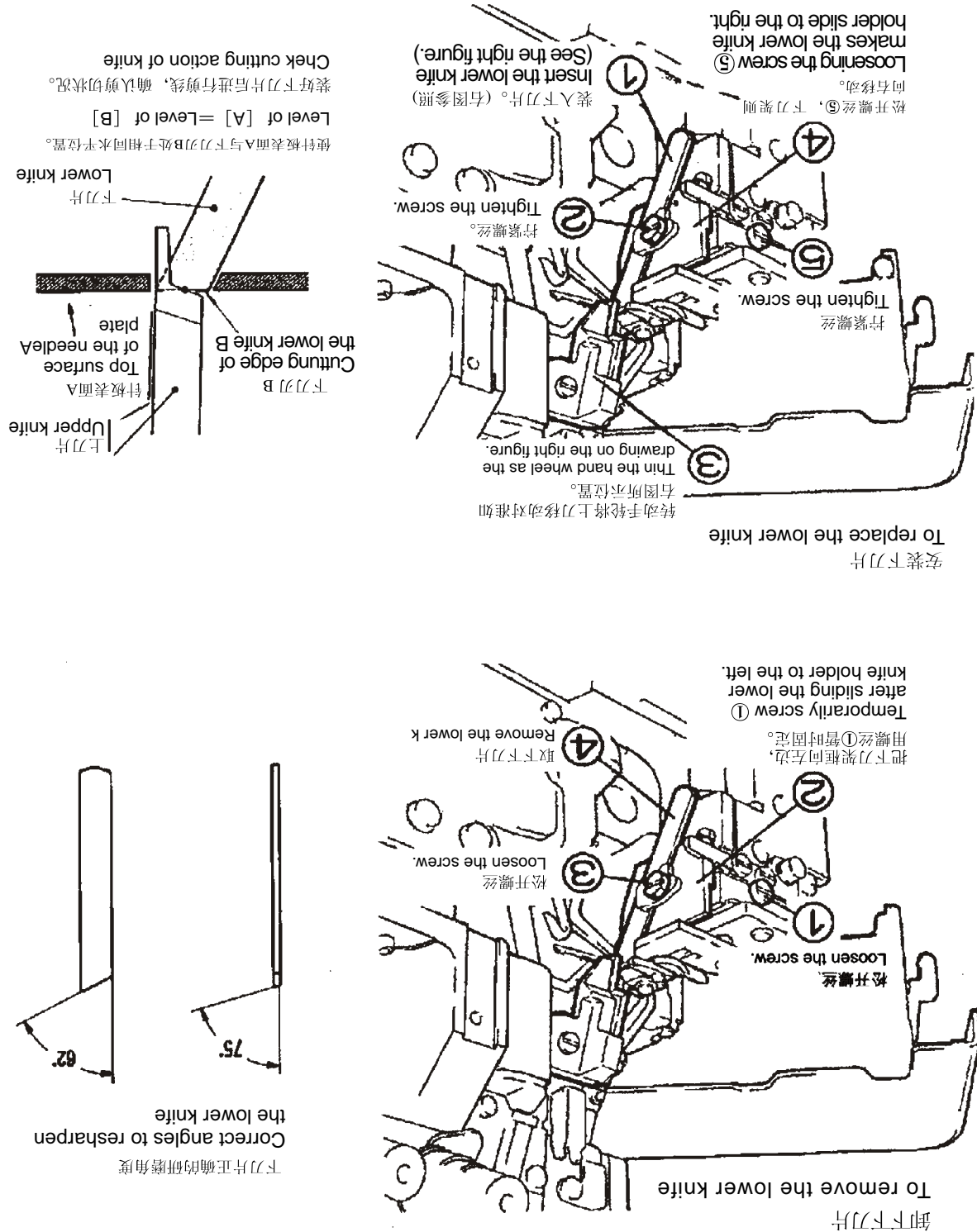
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18、切料机构/FABRIC EDGE CUTTING FRAME

序号 No.	件号 Parts No.	名 称	NAME OF PARTS	数量 Number
1	Z-91-102188-05	上刀轴	shaft of upper knife drive	1
2	Z-91-102186-05	上刀轴挡圈	retaining ring	2
3	Z-91-102314-15	螺钉	screw	2
4	Z-91-102077-05	上刀轴曲柄	crank of upper knife drive	1
5	Z-91-101137-15	螺钉	screw	1
6	Z-91-102312-05	直针连杆销	pin for conncting bar	1
7	Z-91-102072-05	上刀轴传动连杆	connecting bar of upper knife drive	1
8	Z-91-102310-15	螺钉	screw	1
9	Z-91-101136-15	螺钉	screw	1
10	Z-91-102191-05	上刀架	upper knife holder	1
11	Z-91-102190-05	上刀架紧固销	fastening pin for upper knife holder	1
12	Z-91-101321-15	螺钉	screw	1
13	Z-91-101495-95	上刀	upper knife	1
14	Z-91-101076-15	螺钉	screw	1
15	Z-91-101342-15	螺钉	screw	1
16	Z-91-102196-15	下刀压板	press plate for lower knife	1
17	Z-91-101496-05	下刀	lower knife	1
18	Z-91-102195-15	下刀架	lower knife holder	1
19	Z-91-102315-15	螺钉	screw	1
20	Z-91-102197-15	下刀弹簧	spring for lower knife	1
21	Z-91-102198-15	弹簧挡板	fender of spring	1
22	Z-91-101019-15	螺钉	screw	1
23	Z-91-102199-25	挡板	fender	1
24	Z-91-101019-15	螺钉	screw	2
25	Z-91-102339-15	下刀架	lowder knife holder	1

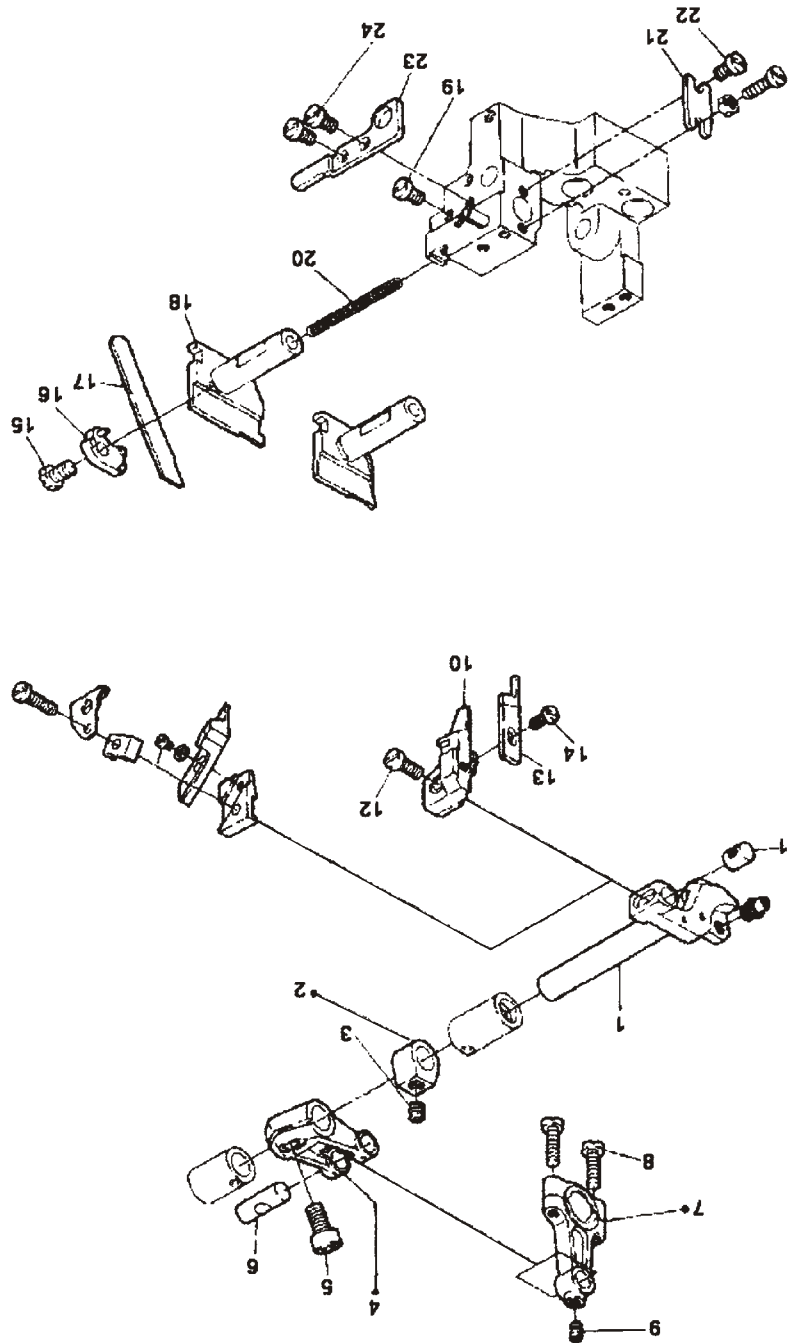
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下刀片的更换
Replacing the lower knife

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18、切料机构/FABRIC EDGE CUTTING FRAME