



高速平缝机 ZJ9800系列

HIGH-SPEED LOCKSTITCH SEWING MACHINE

使用说明书

零件手册

OPERATION MANUAL

PARTS BOOK

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

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运转缝纫机前注意事项

注意：为了防止机械的错误动作或损伤，请确认如下项目。

- 请卸下缝纫机机台上安装的放气盖（红色）。
- 使用之前请一定往油槽中加油。
- 最初使用缝纫机之前，请把机器打扫干净。
- 清除运送途中积存的灰尘，并加油。
- 请确认电压设定是否正确。
- 请确认电源插头是否正确连接。
- 电压规格不同时，请绝对不要使用。
- 请确认马达皮带轮的旋转方向是否正确。
- 请不要把缝纫机向前倒，以免漏油或损坏零件。
- 本缝纫机安装有机头放倒后不让缝纫机转动的开关。因此，运转缝纫机时，请正确的设置缝纫机台板后再打开电源开关。

BEFORE OPERATION

Caution: To avoid malfunction and damage of the machine, confirm the following.

- Remove air-vent cap (red color) attached to the sewing machine bed.
- Be sure to pour in the oil before using.
- Before you put the machine into operation for the first time after the set-up , clean it thoroughly.
- Remove all dust gathering during transportation and oil it well.
- Confirm that the voltage has been correctly set.
- Confirm that the power plug has been properly connected to the power supply.
- Never use the machine in the state where the voltage type is different from the designated one.
- Confirm that the direction of rotation of the motor pulley is correct.
- Do not tilt the sewing machine head toward this side since oil leakage or parts breakage occurs.

A safety switch is installed so that the sewing machine cannot be operated with the head tilted. When operation the sewing machine, turn On the power switch after properly setting the head on the table.

1. 主要技术规格、参数

用途	薄料	厚料
最高缝速	5000rpm	4000rpm
最大针距	5mm	
使用机针	DB × 1 9# ~ 18#	DP × 5 16# ~ 18#
压脚高度	手提 18 mm (标准) 膝提 15mm (最大)	
使用机油	ZJ 1号机油	
使用电机	500W	

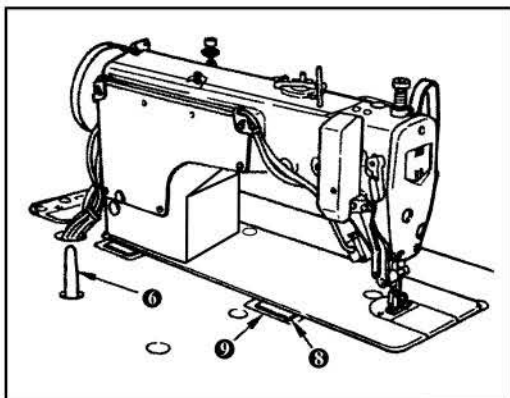
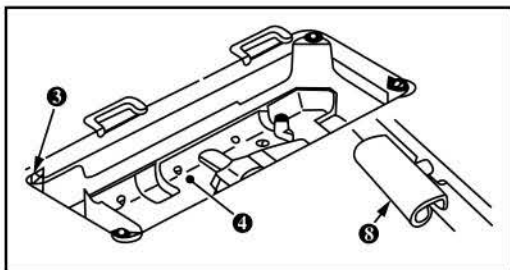
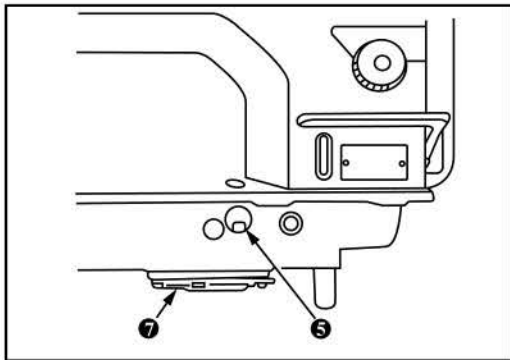
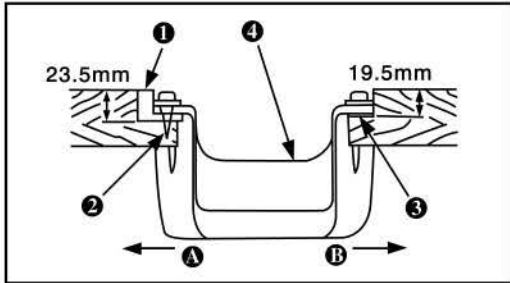
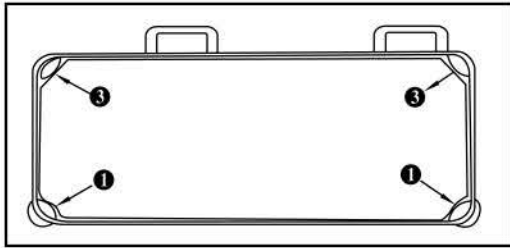
1. Specifications

Application	Thin-medium material	Heavy material
Sewing speed	5000rpm	4000rpm
Stitch length	Max 5mm	
Needle	DB × 1 9# ~ 18#	DP × 5 16# ~ 18#
Presser foot lift	By hand lifter 18 mm (standard) By knee lifter 15mm (max.)	
Oil	ZJ 1#	
Rated power	500W	

2. 缝纫机的安装 Installation

1. 油盘安装

- 1) 油盘放置在台板上的凹槽四角上；
- 2) 两只油盘支座①用油盘座钉②固定在A一边（朝操作者一边），将两只油盘座垫③用油盘座钉②固定在B一边（与机头连接钩接合一边）然后放上油盘④；
- 3) 卸下底板上的放气盖⑤。（搬动机头时，请一定把放气盖⑤盖上）



4) 将机头连接钩⑧插入底板销孔内，与台板的机头连接钩座⑨相嵌合再把机头放到油盘四只角的机头座垫③上。

注意：如果不卸下放气盖⑤运转缝纫机，就会有油从齿轮箱⑦漏出。

1. Installing the oil pan;

- 1) The oil pan should rest on the four corners of the machine table groove;
- 2) Two rubber seats ① for supporting the head portion on the operator side ④ are fixed on the extended portion of the table by hitting the nails ②, and the other two rubber cushion seats ③ on the hinged side ⑤ are fixed by using a rubber-based adhesive. Then, oil pan ④ is placed;
- 3) Remove air vent cap ⑤ attached to the machine bed. (Be sure to attach cap when transporting the machine head in the state that the machine head is removed from the machine table.)
- 4) Fit hinge ⑧ into the opening in the machine bed, and fit the machine head to table rubber hinge ⑨ before placing the machine head on cushions ③ on the four corners.

Caution: If the sewing machine is operated without removing air vent cap ⑤, oil leakage from gearbox portion ⑦ may occur.

3. 膝动提升高度的调整

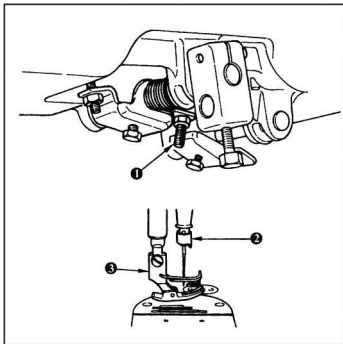
Adjusting the height of the knee lifter



注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



1. 用膝提时的标准压脚高度是10毫米；

2. 用膝提调整螺钉①可以调节压脚提升量最大可至15毫米；

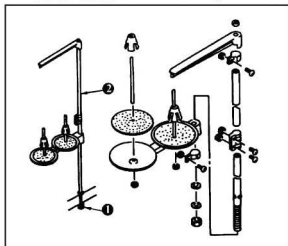
注意：当压脚提升超过10毫米时，请不要运转缝纫机，因为针杆②与压脚③会相碰。

1. The standard height of the presser foot lifted using the knee lifter is 10mm.

2. You can adjust the presser foot lift up to 15mm using knee lifter adjust screw ①.

Caution: Do not operate the sewing machine state that the presser foot ③ is lifted 10mm or more since the needle bar ② is in contact with the presser foot ③.

4. 线架的安装 Installing the thread stand



1. 如图所示那样线架安装到缝纫机台板孔上。

2. 用固定螺母①固定线架。

3. 顶线配线时，请把电源线从线架杆②中穿过。

1. Assemble the thread stand unit, and insert it in the hole in the machine table.

2. Tighten locknut ① to fix the thread stand.

3. For ceiling wiring, pass the power cord through spool rest rod ②.

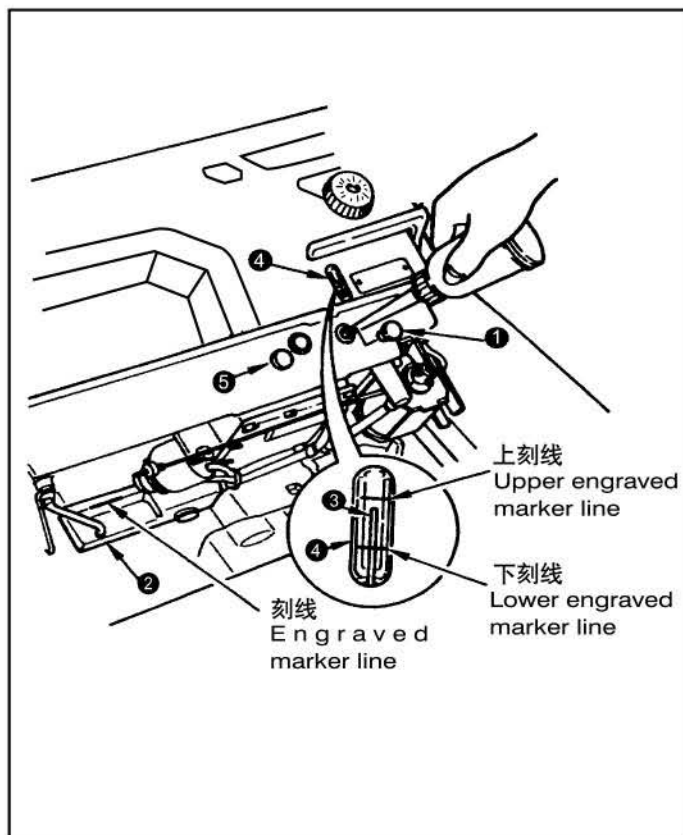
5. 加油 Lubrication



注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



运转缝纫机之前，请一定往旋梭油槽中加油

1. 把缝纫机放倒，并支到机头支撑杆上。
2. 卸下加油口的盖①，使用附带的加油壶加入ZJ 1号机油。
3. 请把油加满到油槽②的刻线位置。请注意加油过多的话，机油会从油槽空气孔漏出来，也会发生不能正常加油的现象。
4. 使用缝纫机时，如果油量指示杆③指到油量指示窗④的下刻线以下，请进行加油。

注意：

1. 使用新缝纫机或较长时间没有使用的缝纫机时，请先进行3000～3500转/分钟的磨合运转之后再使用。

2. 请不要把橡胶栓⑤拔掉。

Fill the oil tank with oil for hook lubrication before the sewing machine.

- 1) Tilt the machine head until it comes in contact with the head support rod.
- 2) Remove oil hole cap ① and fill the oil tank with ZJ No.1 using the oiler supplied with the machine.
- 3) The amount of oil should reach up to the engraved marker line of oil tank②.
If the oil is filled excessively, it will leak from the air vent hole in the oil tank or proper lubrication will be not performed. So , be careful.
- 4) When you operate the sewing machine, refill oil if the top end of oil amount indicating rod③ comes down to the lower engraved marker line of oil amount indicating rod comes down to the lower engraved marker line of oil amount indicating window④.

(Caution) 1. when you use a new sewing machine or a sewing machine after an extended period of disuse, run your machine at 3,000 to 3,500 rpm for the purpose of break-in

2. Do not remove rubber plug ⑤

6. 旋梭油量的调整 (适用于微量供油型机头)

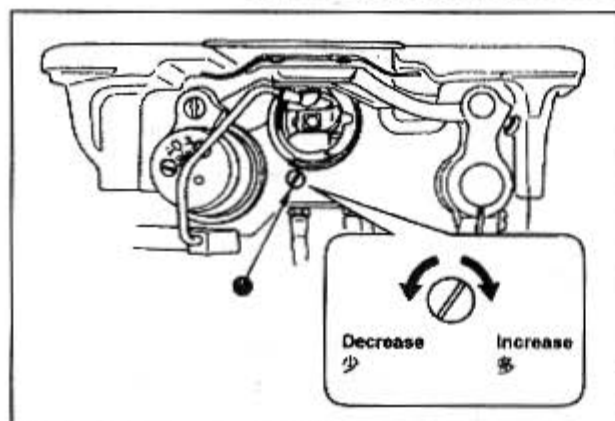
Adjusting the amount of oil in the hook



注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



旋梭油量用旋梭油量调节螺钉①来调节。

1. 调节方法:

拧紧 (向右转动) 旋梭油量调节螺钉①后, 旋梭油量变多, 拧松 (向左转动) 旋梭油量变少。

(注意) 1. 微量供油型缝纫机使用RP旋梭 (干式旋梭) 时, 请一定把油量调到最小, 不让机油流出。

2. 使用RP旋梭 (干式旋梭) 时, 也一定不能把机油槽的油放掉。

Adjustment of the amount of oil in the hook is performed with oil amount adjustment screw ①

1. Adjustment procedure

Tighten (turn clockwise) oil amount adjustment screw ① to increase the amount of oil in the hook, or loosen (turn counterclockwise) to decrease it.

(Caution) 1. When using RP hook (hook for dry head) for the SS type, be sure to loosen the oil amount adjustment screw up to the minimum so as to reduce the oil amount in the hook.

2. Never drain the oil in the oil tank even when RP hook (hook for dry head) is used.

7. 旋梭部油量（油迹）的调整方法 Adjusting the amount of oil (oil splashes) in the hook



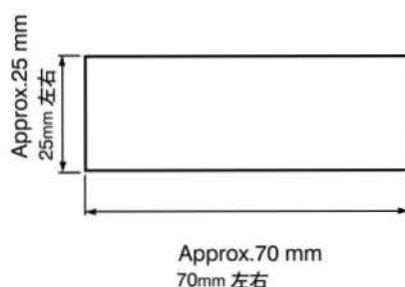
注意：旋梭是已高速运转的。为了防止人身事故，调整油量时，请加以充分的注意。



Warning: Be extremely careful about the operation of the machine since the amount of oil has to be checked by turning the hook at a high speed.

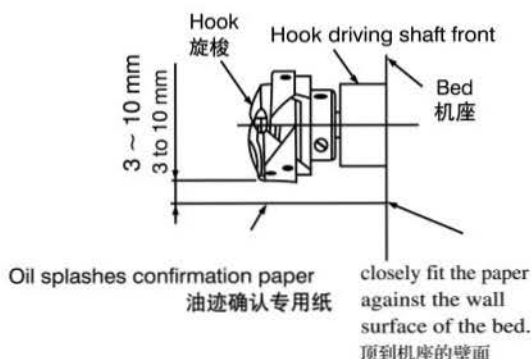
① Amount of oil(oil splashes) confirmation paper

① 油量(油迹)确认专用纸



② Position to confirm the amount of oil(oil splashes)

② 油量(油迹)确认位置



* Use any paper available regardless of the material.
※ 不用考虑纸的质量。

* Place the amount of oil (oil splashes) co paper under the hook.
※ 把油量(油迹)确认专用纸插到旋梭下面。

1. 油量（迹）确认方法

进行下列2)的操作时，请卸下滑板，同时要充分注意手指不要碰到旋梭。

- 1) 机头冷却时，请进行3分钟左右的空转。（适当的间歇运转）。
- 2) 请在缝纫机转动时将油量（油迹）确认专用纸插入。
- 3) 确认油槽中是否有油。
- 4) 油量（油迹）确认时间为5秒。

1. How to confirm the amount of oil (oil splashes)

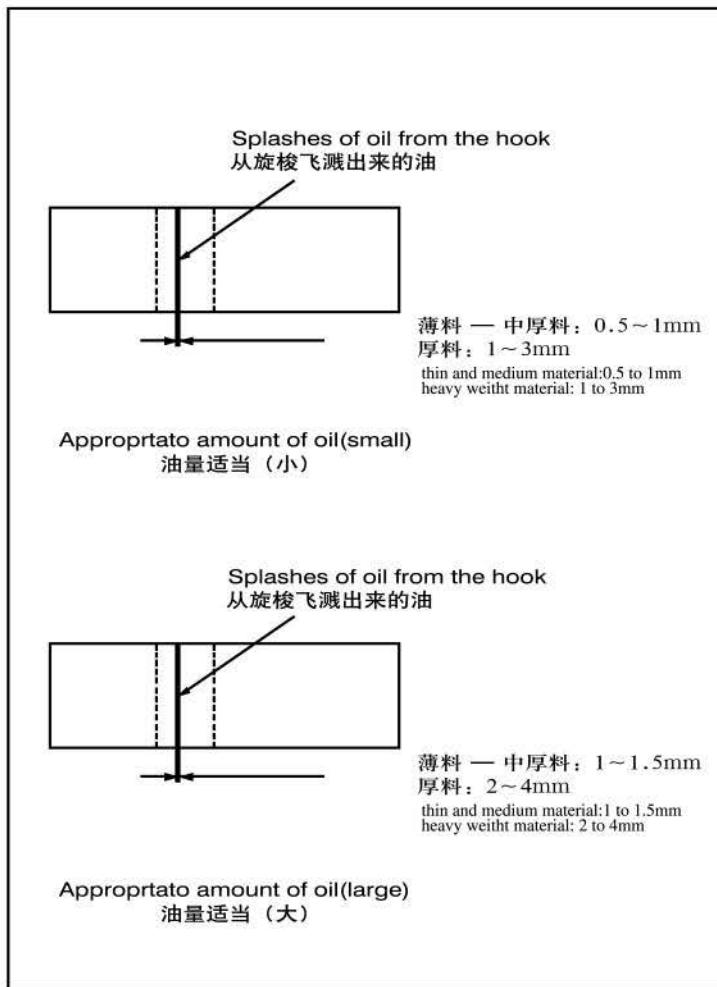
When carrying out the procedure described below in 2, remove the slide plate and take extreme caution not to allow your fingers to come in contact with the hook.

- 1) If the machine has not been sufficiently warmed up for operation, make the machine run idle for approximately three minutes. (Moderate intermittent operation)
- 2) Place the amount of oil (oil splashes) confirmation paper under the hook while the sewing machine is in operation.

3) Confirm that oil exists in the oil tank.

4) Confirmation of the amount of oil should be completed in five seconds. (Check the period of time with a watch.)

2. 油量（油迹）适合标样



1) 左图标样根据缝制供需需要微调增减，但注意增减不能过大。油量减少时，会发热烧坏旋梭。油量过多时，会污染缝料。

2) 油量（油迹）应确认3次均无变化方可。

2. Sample showing the appropriate amount of oil

1) The amount of oil shown in the samples on the left should be finely adjusted in accordance with sewing processes. Be careful not to excessively increase/decrease the amount of oil in the hook.(if the amount of oil is too small, the hook will be seized (the hook will be hot). If the amount of oil is too much, the

sewing product may be stained with oil.)

2) Adjust the amount of oil in the hook so that the oil amount (oil splashes) should not change while checking the oil amount three times (on the three sheets of paper).

8. 机针的安装方法 Attaching the needle



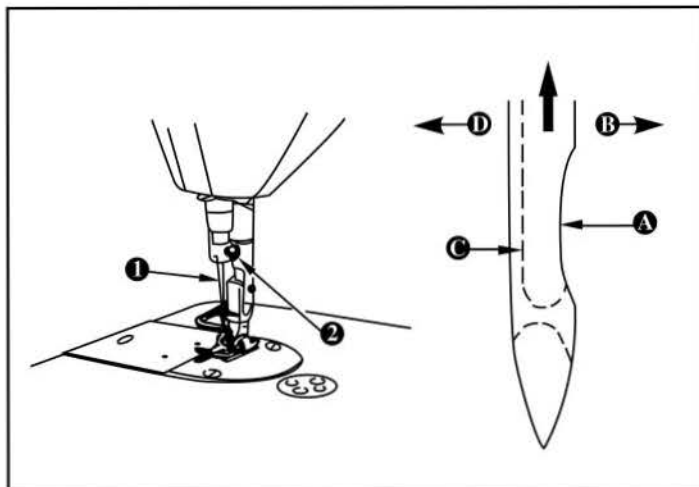
注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

请使用DBx1或DPx5的机针。请根据线的粗细、布料的种类选择适当的机针。

1. 转动手轮，把针杆升到最高处。
2. 拧松机针固定螺钉②，手拿机针把机针①凹部Ⓐ横向转到Ⓑ的方向。
3. 把机针插到针杆孔的深处。
4. 拧紧机针固定螺钉②
5. 确认针的长孔Ⓒ在左横向Ⓓ的方向。



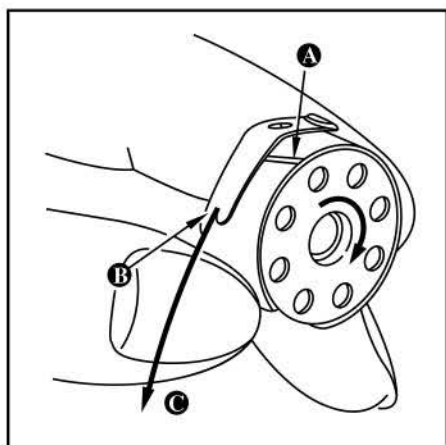
注意：使用长丝机线时，如果机针凹部朝向前方，容易发生线环不稳定或断线的现象。
使用这类机线时，请把机针稍稍向后倾斜安装，就可以有效地防止这些现象。

A needle of DBx1 or DPx5 should be used. Select a proper needle size according to the count of thread and the type of material used.

1. Turn the hand-wheel until the needle bar reaches the highest point of its stroke.
2. Loosen screw ②, and hold needle ① with its indented part Ⓐ facing exactly to the right in direction Ⓑ.
3. Insert the needle fully into the hole in the needle bar in the direction of the arrow until the end of hole is reached.
4. Securely tighten screw ②.
5. Check that long groove Ⓒ of the needle is facing exactly to the left in direction Ⓓ.

Caution: When filament thread is used, if the indented part of the needle is tilted toward operator's side, the loop of thread becomes unstable, As a result, hangnail of thread or thread breakage may occur. For the thread that such phenomenon is likely to occur, it is effective to attach the needle with its indented part slightly slanting on the rear side.

9. 梭心的安装方法 Setting the bobbin into the bobbin case



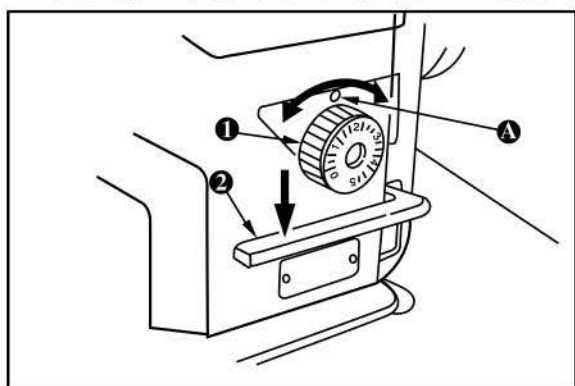
1. 将梭心装入梭子内；
2. 将线从梭子上的线槽①中穿过，朝②方向拉出。
这样，线通过夹线簧下从线孔③处引出；
3. 拉底线③时，梭心应按箭头方向转动。

1. Install the bobbin in the bobbin case so that the thread wound direction is clockwise.
2. Pass the thread through thread slit ①, and pull the thread in direction ②. By so doing, the thread will pass under the tension spring and come out from notch ③.

3. Check that the bobbin rotates in the direction of the arrow when thread ③ is pulled.

10. 针距的调节 Adjusting the stitch length

1. 将送料距旋钮①按箭头方向转动，旋至所需数字对准机壳上的刻点②；
2. 旋钮上的刻度数字单位用毫米表示；
3. 若欲缩短线迹长度，把倒缝扳手③朝箭头方向压下的同时，转动送料距旋钮。



1. Turn stitch length dial ① in the direction of the arrow, and align the desired number to marker dot ② on the machine arm.
2. The dial calibration is in millimeters.
3. When you want to decrease the stitch length, turn stitch length dial ① while pressing feed lever ② in the direction of the arrow.

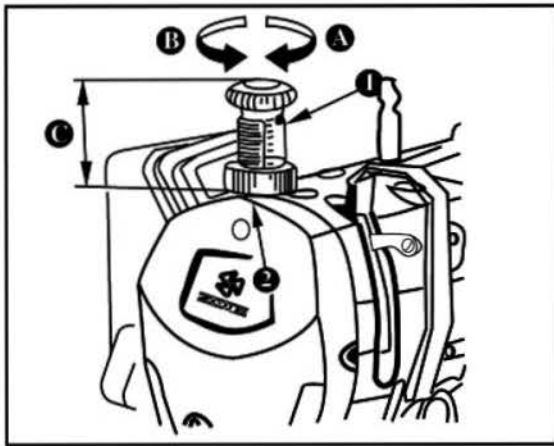
11. 压脚压力的调节 Presser foot pressure



注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



1. 旋松调压螺母②顺时针（即A方向）转动压力脚调节螺钉，压力将增强；
2. 逆时针（即B方向）转动压力脚调节螺钉，压力将减弱；
3. 调节后旋紧调压螺母②；
4. 对一般布料而言，压脚调节螺钉的标准高度为32~34毫米（4.5Kg）。

1. Loosen nut ②. As you turn presser spring regulator ① clockwise(in direction A), the presser foot pressure will be increased.
2. As you turn the presser spring regulator counterclockwise(in direction B), the pressure will be decreased.
3. After adjustment, tighten nut ②.
4. For general fabrics, the standard height of the presser spring regulator is 32 to 34mm(4.5kg).

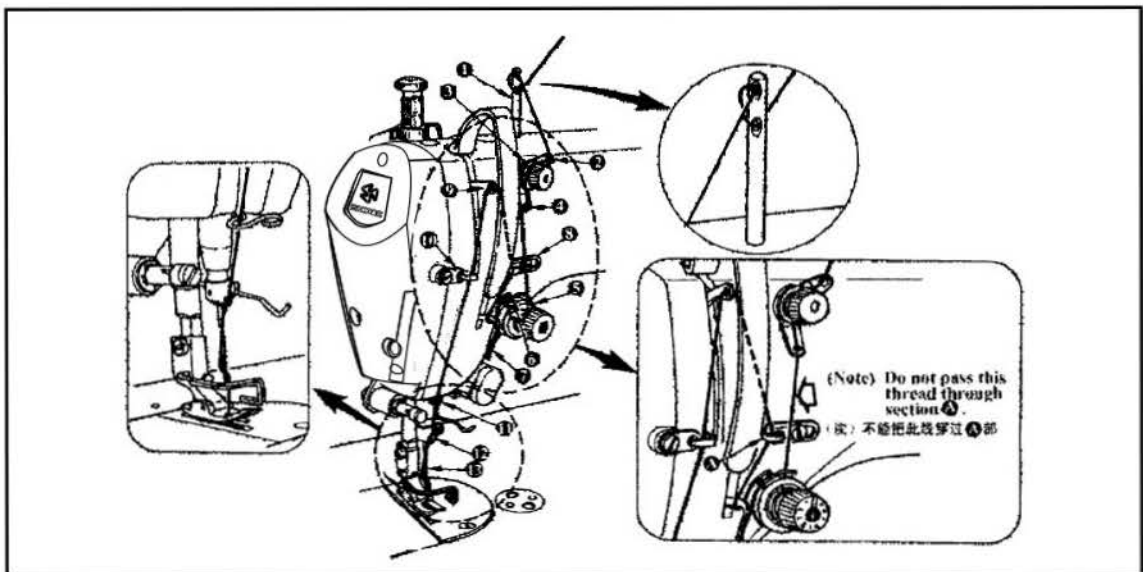
12. 面线穿线的方法 Threading the machine head



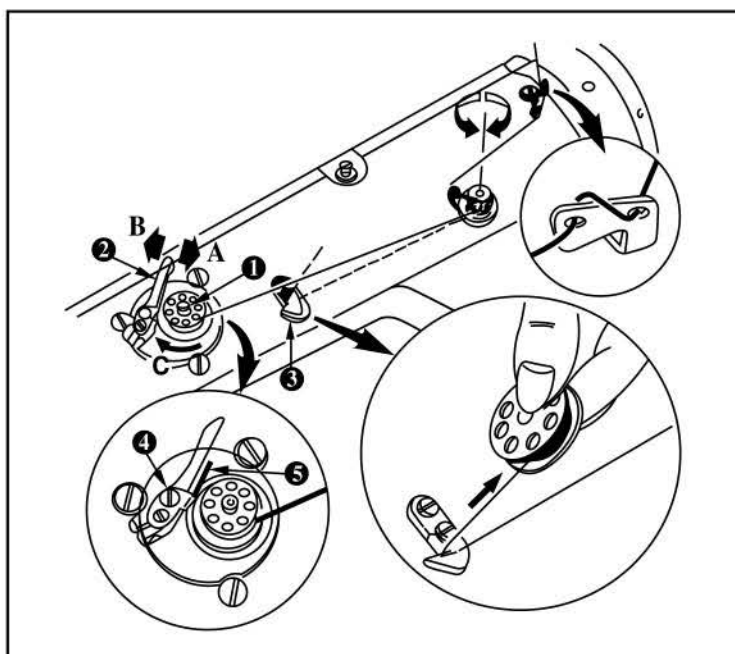
注意：为了防止缝纫机的意外起动，请关掉电源后再进行此操作。



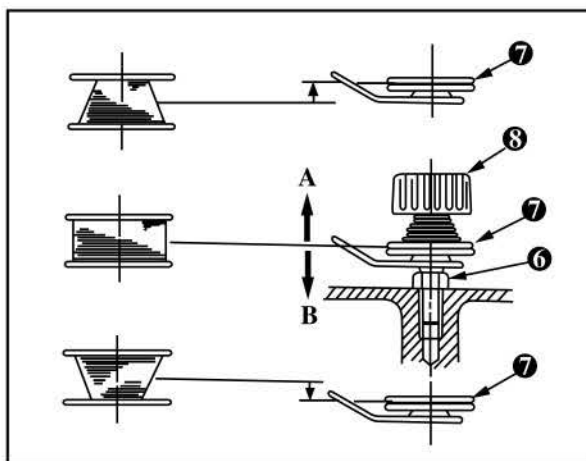
Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



13. 底线的卷绕方法 Winding the bobbin thread



1. 把梭心推到卷绕轴①的最里面；
2. 把线架右侧的卷线如图所示穿线，并把线端向右缠绕数圈（铝旋梭时，把线端向右缠绕后，再把线张力盘过来的线向左缠绕数圈后，就容易绕线了）。
3. 把卷线拔杆②推到A方向，转动缝纫机。梭心向C方向转动，线卷绕到梭心上。卷绕结束后卷线轴①自动停止。
4. 取下梭心，用切线保持板③切断机线。



5. 调整底线卷线量时，请拧松固定螺钉④，把调节板⑤移动到A方向或B方向，然后再固定螺钉④。A方向变少，B方向变多。
6. 如果线不能平绕梭心时，请拧松螺母⑥，转动卷线张力器，调整线张力盘⑦的高度：

- 旋梭中心和线张力盘中心高度一样时为标准位置；
- 下部卷得多时，向如图A方向移动线张力盘的位置，上部卷得多时，向如图B方向移动线张力盘⑦的位置。

调整到适合的位置后，把固定螺钉⑥拧紧；

7. 调整底线卷绕张力时，请转动线张力螺母⑧进行调整。

注意：

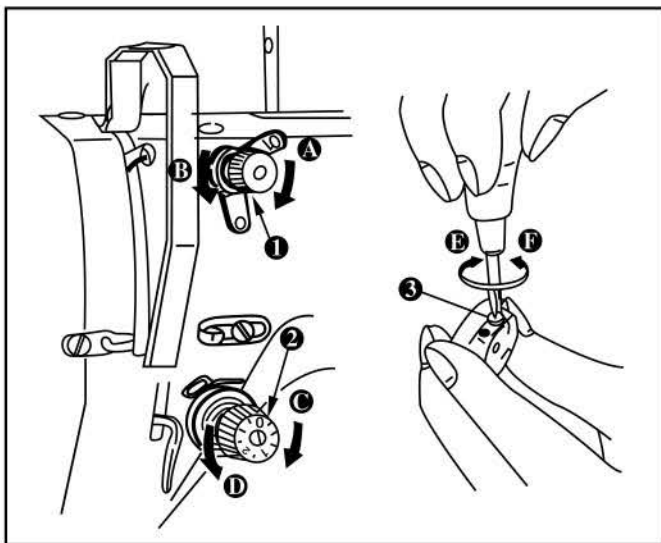
1. 卷绕底线时，请在梭芯和线张力盘⑦之间拉线的状态开始绕线。
2. 不进行缝制时给梭芯绕底线时，请把上线从挑线杆过线孔上抽出来，把梭芯从旋梭里卸下来后再进行。

- 1) Insert the bobbin deep into the bobbin winder spindle ① until it will go no further.
- 2) Pass the bobbin thread pulled out from the spool rested on the right side of the thread stand following the order as shown in the figure on the left. Then, wind clockwise the end of the bobbin thread on the bobbin several times. (In case of the aluminum bobbin, after winding clockwise the end of the bobbin thread, wind counterclockwise the thread coming from the bobbin thread tension several times to wind the bobbin thread with ease.)
- 3) Press the bobbin winder trip latch ② in the direction of Ⓐ and start the sewing machine. The bobbin rotates in the direction of C and the bobbin thread is wound up. The bobbin winder spindle ① automatically as soon as the winding is finished.
- 4) Remove the bobbin and cut the bobbin thread with the thread cut retainer ③.
- 5) To adjust the winding amount of the bobbin thread, loosen the setscrew ④ and move the bobbin winder adjusting plate ⑤ to the direction of Ⓐ or Ⓑ. Then, tighten the setscrew ④. To the direction of Ⓐ: Decrease; to the direction of Ⓑ: Increase.
- 6) In case that the bobbin thread is not wound evenly on the bobbin, loosen the nut ⑥ and turn the bobbin thread tension to adjust the height of the thread tension disk ⑦.
- It is the standard that the center of the bobbin is as high as the center of the thread tension disk.
- Move the position of the thread tension disk ⑦ to the direction of Ⓐ as shown in the figure on the left when the winding amount of the bobbin thread on the lower part of the bobbin is excessive and to the direction of Ⓑ as shown in the figure on the left when the winding amount of the bobbin thread on the upper part of the bobbin is excessive. After the adjustment, tighten the nut ⑥.
- 7) To adjust the tension of the bobbin winder, turn the thread tension nut ⑧.

Caution:

1. when winding the bobbin thread, start the winding in the state that the thread between the bobbin and thread tension disk ⑦ is tense.
2. When winding the bobbin thread in the state that wing is not performed, remove the needle thread from the thread path of thread take-up and remove the bobbin from the hook.

14. 缝线张力的调整 Thread tension



1. 面线张力的调整

- 1) 把面线张力螺母①顺时针方向(Ⓐ方向)转动, 面线的张力变强;
- 2) 把面线张力螺母①逆时针方向(Ⓑ方向)转动, 面线的张力变弱;
- 3) 把线张力螺母②向右Ⓒ方向转动, 面线张力变强;
- 4) 把线张力螺母②向左Ⓓ方向转动, 面线张力变弱。

2. 底线张力的调整

- 1) 把线张力螺钉③向右Ⓔ的方向转动, 底线张力变强;
- 2) 向左Ⓕ的方向转动则变弱。

1. Adjusting the needle thread tension

- 1) As you turn thread tension nut ① clockwise (in direction Ⓐ), the thread remaining on the needle after thread trimming will be shorter.
- 2) As you turn nut ① counterclockwise (in direction Ⓑ), the thread length will be longer.
- 3) As you turn thread tension nut ② clockwise (in direction Ⓒ), the needle thread tension will be increased.
- 4) As you turn nut ② counterclockwise (in direction Ⓓ), the needle thread tension will be decreased.

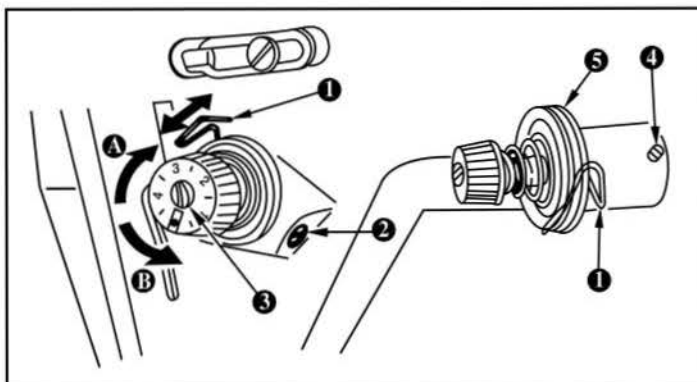
2. Adjusting the bobbin thread tension

- 1) AS you turn tension adjust screw ③ clockwise (in direction Ⓔ), the bobbin thread tension will be increased.
- 2) As you turn screw ③ counterclockwise (in direction Ⓕ), the bobbin thread tension will be decreased.

15. 挑线簧的调节 Thread take-up spring

1. 挑线簧摆动量的调节:

- 1) 旋松定位螺钉②;
- 2) 把夹线螺钉③朝顺时针方向(即Ⓐ方向)转动时, 挑线簧的摆动量将增大;



(即Ⓐ方向)转动时,挑线簧的张力将增大;

4) 把夹线螺钉③朝逆时针方向(即Ⓑ方向)转动时,挑线簧的张力将减小。

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

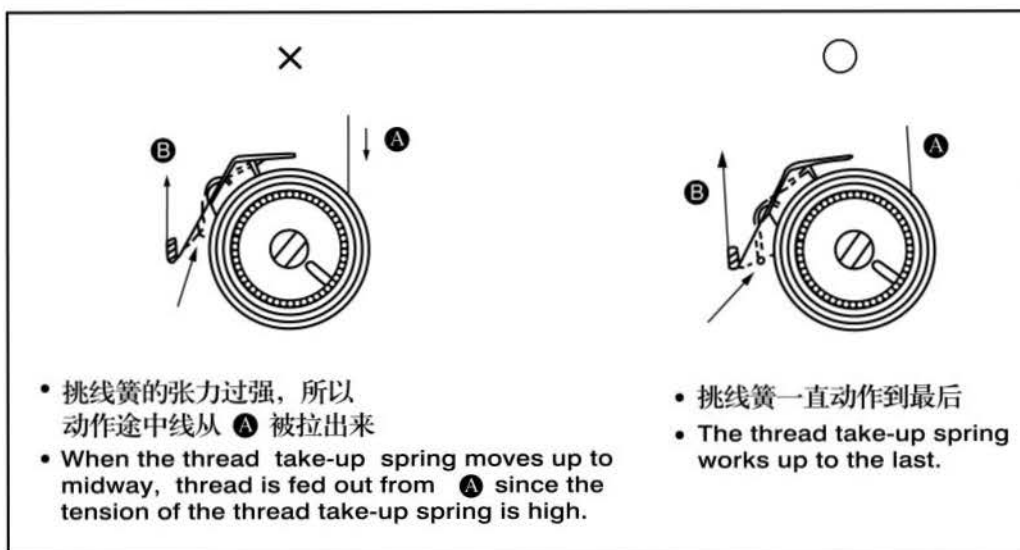
3) 把夹线螺钉③朝逆时针方向(即Ⓑ方向)转动时,挑线簧的摆动量将减小。

2. 挑线簧张力的调节:

1) 旋松定位螺钉②, 取出夹线器⑤(组件);

2) 旋松定位螺钉④, 并转动夹线螺钉③;

3) 把夹线螺钉③朝顺时针方向



挑线簧调整适当的判定方法: 确认挑线簧的压力调整后, 把面线向Ⓑ方向拉出, 如果在挑线簧到达最低位置之前面线Ⓑ处就被拉动, 请减弱挑线簧的压力。

1. Changing the stroke of thread take-up spring

1) Loosen setscrew ②.

2) As you turn tension post ③ clockwise(in direction Ⓐ), the stroke of the thread take-up spring will be increased.

3) As you turn tension post ③ counterclockwise(in direction Ⓑ), the stroke will be decreased.]

2. Changing the pressure of thread take-up spring ①

1) Loosen setscrew ②, and remove thread tension ⑤.

2) Loosen setscrew ④.

3) As you turn tension post ③ clockwise(in direction Ⓐ), the pressure will be increased.

4) As you turn tension post ③ counterclockwise (in direction ⑥), the pressure will be decreased.

Usually, upon the machine coming out, all the take-up spring has been adjusted well, only while sew special material thread, it need to be adjusted again.

To judge the work of the thread take-up spring, confirm whether or not the thread take-up spring works up to the last before needle thread is pulled out from ④ when pulling out needle thread in the direction of ⑥ after the pressure of the thread take-up spring has been performed. When it does not work up to the last, decrease the pressure of the thread take-up spring. In addition, the stroke of the thread take-up spring is excessively small, the spring does not work properly. For the general fabrics, a stroke of 10 to 13 mm is proper.

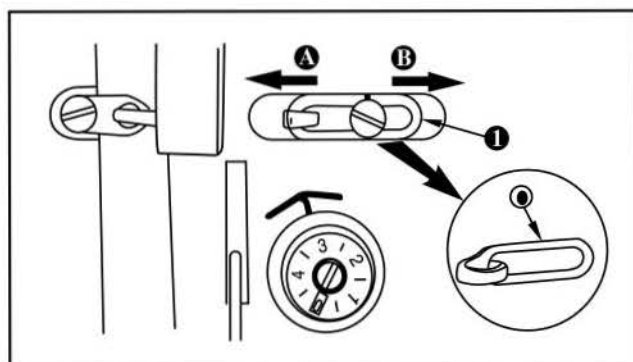
16. 挑线杆挑线量的调节 Adjusting the thread take-up stroke



注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



1. 缝制厚料时，应将右线钩①朝左方向④移动，以增大挑线量；
2. 缝制薄料时，应将右线钩①朝右方向⑤移动，以减少挑线量；
3. 右线钩①上的刻线③与螺钉中心一致时为标准位置。

1. When sewing heavy-weight materials, move thread guide ① to the left (in direction ④) to increase the length of thread pulled out by the thread take-up.
2. When sewing light-weight materials, move thread guide ① to the right (in direction ⑤) to decrease the length of thread pulled out by the thread take-up.
3. Normally, thread guide ① is positioned in a way that marker line ③ is aligned with the center of the screw.

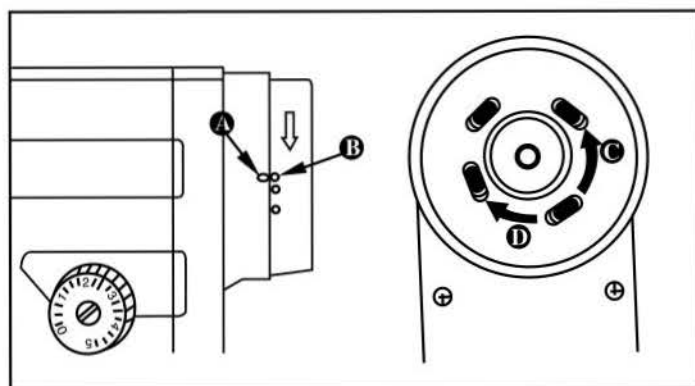
17. 机针停止位置的调整 Adjusting the needle stop position



注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



1. 切线后的停止位置

- 1) 标准的机针停止位置是皮带轮外罩的刻点Ⓐ和上轮的白刻点Ⓑ一致时的位置；
- 2) 让机针上升到最上的停止位置，在长孔范围对外片进行调节。

➤ 向Ⓒ的方向移动，机针停止提前；

➤ 向Ⓓ的方向移动，机针停止推迟；

1. Stop position after thread trimming

1) The standard needle stop position is obtained by aligning marker dot ① on the pulley cover with white marker dot ② on the hand-wheel.

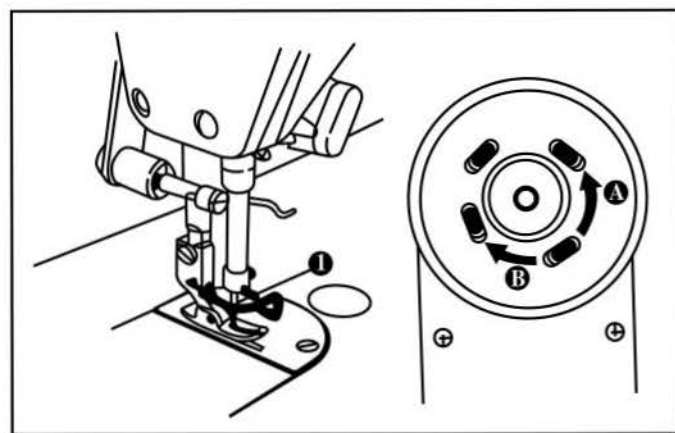
2) Stop the needle in its highest position, loosen screw ① to perform adjustment within the slot of the screw.

➤ The needle stop timing is advanced if you move the screw in direction ③.

➤ The needle stop timing is delayed if you move the screw in direction ④.

2. 缝制的结束

1) 踏板从前踩踏变为中立时的机针下停止位置与上停止一样，让机针①下停止之后，在长孔范围内对内片进行调整。向Ⓐ方向移动机针停止位置提前，向Ⓑ方向移动机针停止位置推迟。



2. Lower stop position

1) The lower needle stop position when the pedal is returned to the neutral position after the front part of the pedal is depressed can be adjusted as follows:

Stop needle ① in its lowest position. Loosen screw ②, and make adjustment within the slot of the screw. Moving the screw in direction ③ advances the needle stop timing. Moving the screw in direction ④ delays the timing.

18. 齿轮箱润滑油查看与添加

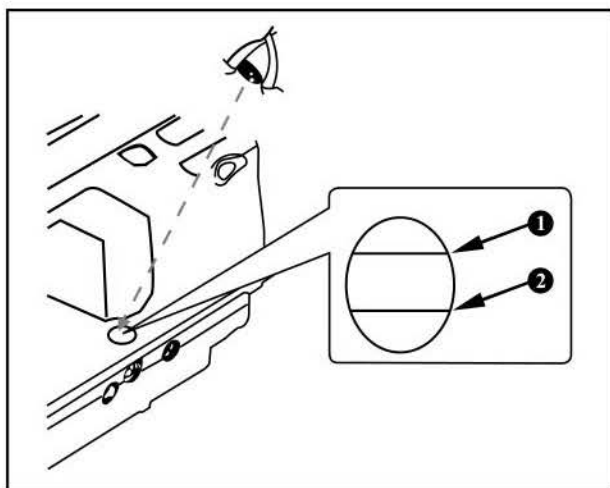
Oil check and addition



注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。

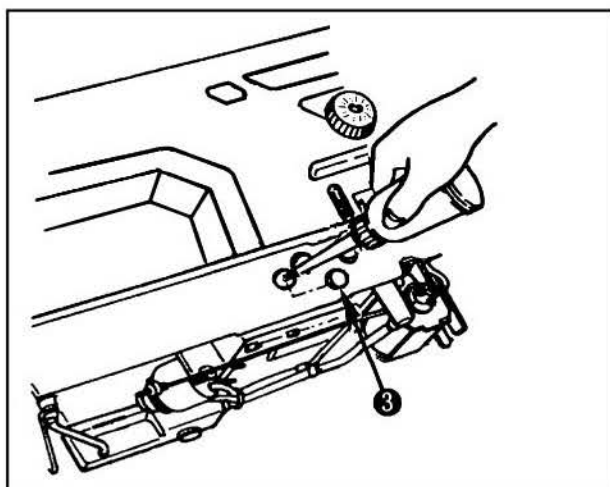


Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



运转缝纫机时，请一定要查看齿轮箱润滑油是否充足，及时添加充足的润滑油。

1. 缝纫机出厂时已往齿轮箱添加充足的润滑油，缝纫机在使用时，齿轮箱中的润滑油会不断被消耗，通过机器上的齿轮箱油标可以实时查看齿轮箱油标可以实时查看齿轮箱润滑是否充足，按图标查看位置可清晰查看到齿轮箱油标上的刻度，刻线①表示齿轮箱油量充足可安全使用缝纫机，刻线②表示齿轮箱油量已消耗完毕，需要尽快添另齿轮油。
2. 如果齿轮箱中的润滑油已消耗完毕，可按图示揭开③齿轮箱橡皮塞，然后按图示方法添加润滑油，当润滑油液面到达刻度线①即可。



When the sewing machine running, please check lubricating oil of gear box is sufficient or not. Add sufficient oil in time.

1. When you open then new machines, the lubricating oil of gear box is sufficient. While you running the machines, the oil is spent contnuously, we can inspect the oil of gear box is sufficient or not through the oil mark on gear box. According to the picture, we can gear box's oil mark. 1, It means oil is enough and machines c-an be running safely. 2, It means oil is used out and need to add oil immediately.

2. If the oil is used out, please uncover the rubber plug 1 of gear box(note the picture), then add lubricating oil, it is ok when the oil is up to the scale 1 of oil mark.

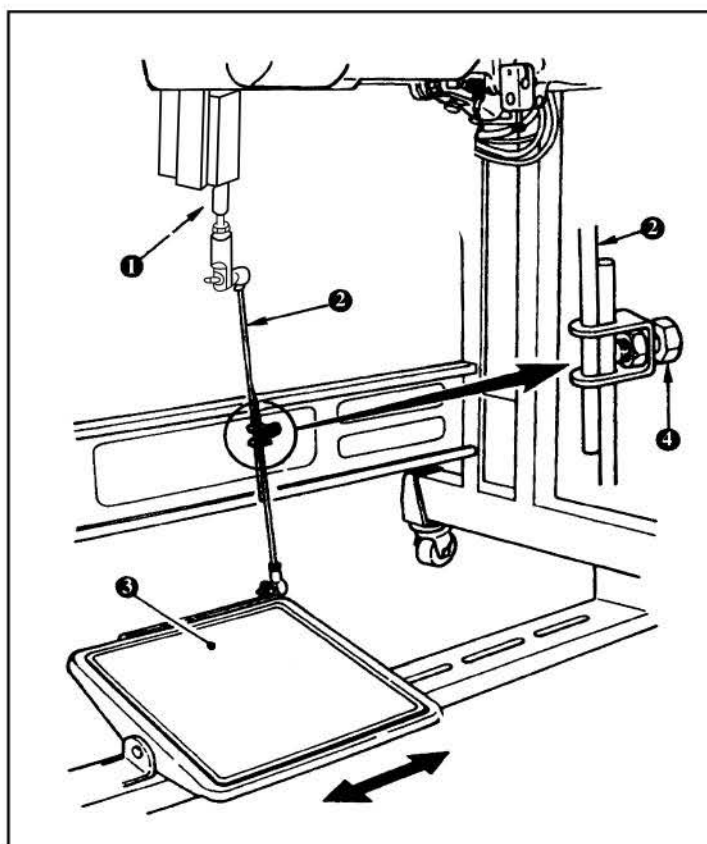
19. 踏板的调整 Adjustment of the pedal



注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



1. 连接杆的安装

- 1) 向箭头方向移动踏板调节板③，让马达控制杆①和连接杆②成一直线。

2. 踏板的角度

- 1) 调节连接杆的长度即可以改变踏板的角度。
2) 拧松调节螺钉④，移动连接杆②进行调节。

1. Installing the connecting rod

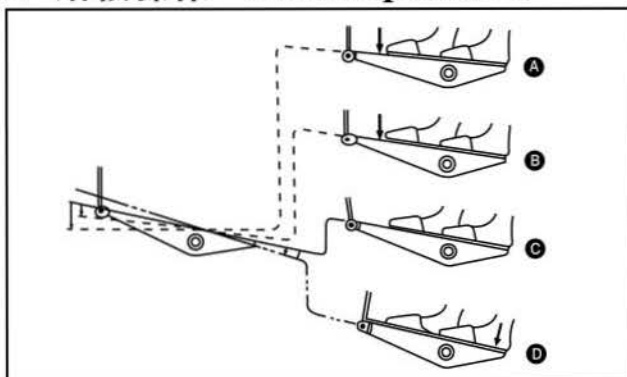
- 1) Move pedal ③ to the right or left as illustrated by the arrows so that motor control lever ① and connecting rod ② are straightened.

2. Adjusting the pedal angle

- 1) The pedal tilt can be freely adjusted by changing the length of the connecting rod.

- 2) Loosen adjust screw ④, and adjust the length of connecting rod ②.

20. 踏板操作 Pedal operation



1. 踏板有4级操作

- 1) 向前轻轻踩踏板为低速缝纫ⓐ；
- 2) 再继续往前踩踏板为高速缝纫ⓐ；（但是，设定了自动倒缝开关后，倒缝结束之后为高速缝纫）；
- 3) 向后踩踏板为切线动作ⓐ。

※ 使用自动压脚提升装置时，在停止和切线之间增加一级开关，向后轻轻踩踏板，为压脚提升动作ⓐ在继续踩踏板为切线动作。

- 始缝的自动倒缝中，把踏板返回中立位置则缝纫机倒缝结束后停止。
- 从高速缝纫或低速缝纫中向后用力踩踏板缝纫机均可切线。
- 缝纫机切线中把踏板返回中立位置但机器仍然把线切完。
- 缝纫机停止机针下降停止之后，如果想升起机针时，请往后踩一次踏板。

1. The pedal is operated in the following four steps:

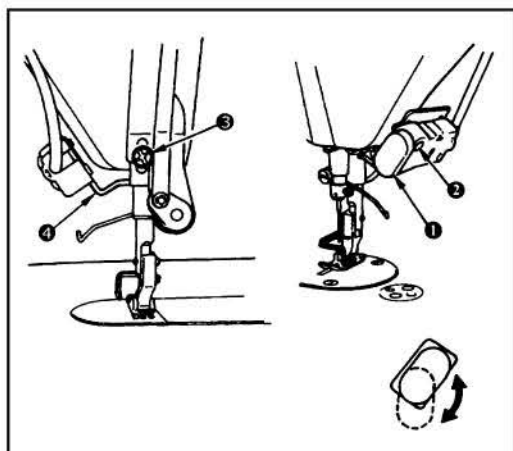
- 1) The machine runs at low sewing speed when you lightly depress the front part of the pedal ⓐ.
- 2) The machine runs at high sewing speed when you further depress the front part of the pedal ⓐ. (If the automatic reverse feed stitching has been preset, the machine runs at high speed after it completes reverse feed stitching.)
- 3) The machine trims threads when you fully depress the back part of the pedal ⓐ.

※ If your machine is provided with the Auto-lifter, an additional step is given between the machine stop and thread-trimming step. The presser foot goes up when you lightly depress the back part of the pedal ⓐ, and if you further depress the back part, the thread trimmer is actuated.

- If you reset the pedal to its neutral position during the automatic reverse feed stitching at seam start, the machine stops after it completes the reverse feed stitching;
- The machine will perform normal thread trimming even if you depress the back part of the pedal immediately following high or low speed sewing.
- The machine will completely perform thread trimming even if you reset the pedal to its neutral position immediately after the machine started thread trimming action.
- When the machine stops with its needle down, and if you want to bring the needle up, depress the back part of the pedal once.

21. 单触手动倒缝

One-touch type reverse feed stitching mechanism



1. 使用方法

- 1) 按下开关拨杆①，缝纫机立即倒缝；
- 2) 在按下的时间进行倒缝；
- 3) 手一松开立即变为正向缝纫。

1. How to operate

- 1) The moment switch lever ① is pressed, the machine performs reverse feed stitching.
- 2) The machine performs reverse feed stitching as long as the switch lever is held depressed.

3) The machine resumes normal feed stitching the moment the switch lever is released.

2. 开关的高度 Height of the switch



注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

- 1) 开关①有两挡位置可以使用；
- 2) 想把开关①的位置再下降时，请拧松缝纫机背面的固定螺钉③，降下开关座④。

1) Switch ① can be used in two positions by turning it.

2) In addition, when you desire to lower the position of switch ①, loosen setscrew ③ located in the back of the machine head and lower switch base ④.

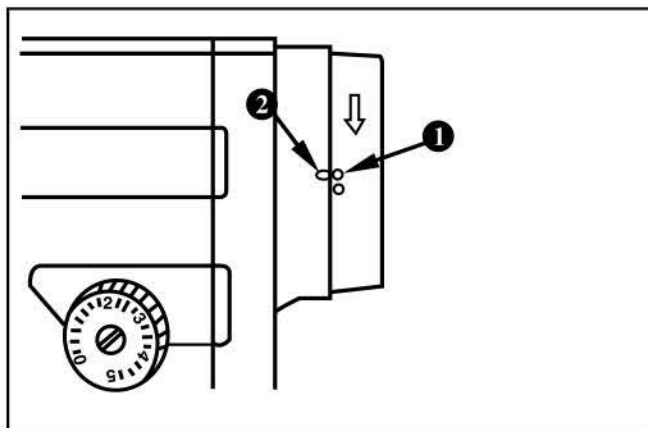
22. 拔线杆 Wiper



注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



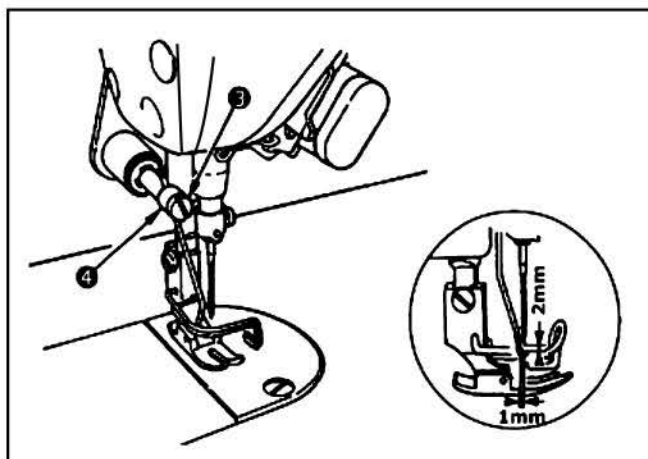
Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



1. 拔线杆的位置

拔线杆的位置根据布料的厚度按下列方法进行调节

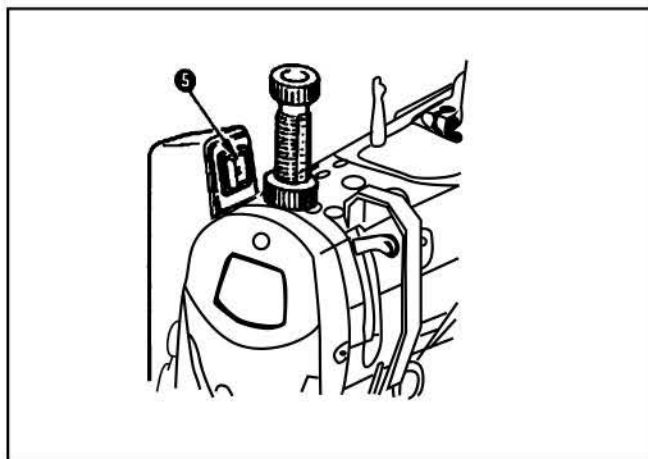
- 1) 向正常方向转动飞轮，让飞轮白刻点①对准机壳的刻点②。
- 2) 用拔线杆环④推拔线杆，然后拧紧固定螺钉③，把挑线杆的平坦部和机针中心的距离相距离1mm；
- 3) 不使用拔线杆时，请关掉拔线杆开关



1. Positioning the wiper

Adjust the position of the wiper according to the thickness of the material sewn. The adjustment procedure is as follows:

- 1) Turn the hand-wheel in the normal direction of rotation to align white marker dot ① on the hand-wheel with marker dot ② on the machine arm.
- 2) Adjust the distance between the flat part of the wiper and the center of the needle to 1mm. Tighten wiper adjust screw ③ so that the wiper is pressed and fixed by wiper collar ④.
- 3) When the wiper is unnecessary, turn wiper switch ⑤ OFF.



23. 机针与旋梭的关系 Needle-to-hook relationship

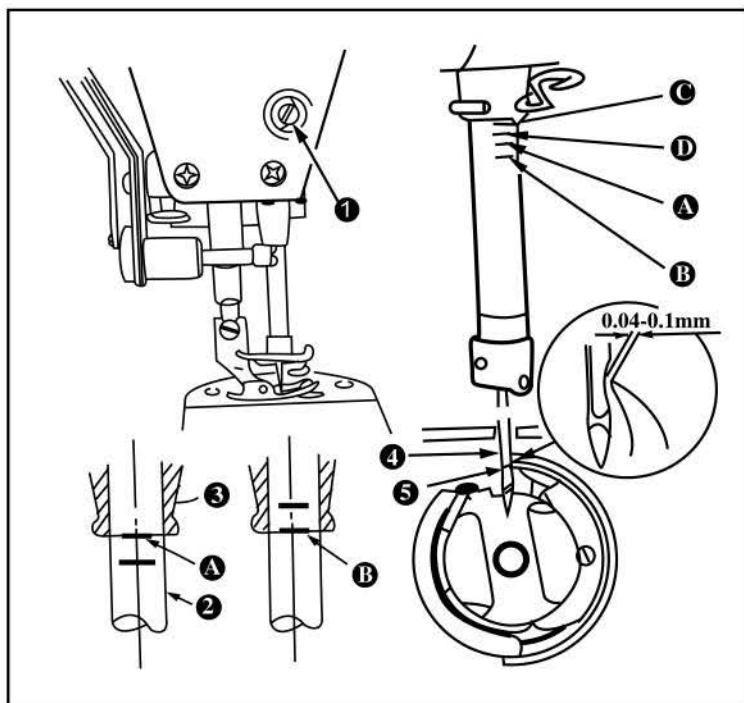


注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

1. 转动上轮，使针杆下到最低点，然后拧松针杆连接柱紧固螺钉①；
2. 确定针杆高度：
 - 1) 使用DB针时，使针杆②上的刻线Ⓐ对准针杆下轴套③的下端，然后拧紧针杆连接柱定位螺钉①；
 - 2) 使用DA针时，使针杆②上的刻线Ⓑ对准针杆下轴套③的下端，然后旋紧针杆连接柱定位螺钉①。
3. 确定旋梭位置：
 - 1) 使用DB针时，旋松三颗旋梭定位螺钉，并转动上轮，使针杆②在上升的方向刻线Ⓒ



- 对准针杆下轴套③的下端；
- 2) 使用DA针时，旋松三颗旋梭定位螺钉，并转动上轮，使针杆②在上升的方向刻线Ⓓ对准针杆下轴套③的下端；
 4. 在上述状态下，使旋梭的勾线尖⑤对准机针④的中心，针与旋梭的间隙为0.04~0.1（大约）毫米，然后拧紧旋梭紧固螺钉。

注意：

1. 若间隙太小，会磨损梭尖；若间隙太大，会引起跳针；
2. 旋梭损坏后更换，请使用相同的型号。

1. Turn the hand-wheel to bring the needle bar down to the lowest point of its stroke, and loosen setscrew ①.
2. Adjusting the needle bar height:
 - 1) While using DB needle, align marker line Ⓐ with the bottom end of needle bar lower bushing ③, then tighten setscrew ①.

- 2) While using DA needle, align marker line ㉓ with the bottom end of needle bar lower bushing ㉑, then tighten setscrew ㉑.
3. Locate the hook position:
 - 1) While using DB needle, loosen the three hook set screw, turn the hand-wheel, and align marker line ㉒ on ascending needle bar 2 with the bottom end of needle bar lower bushing ㉑.
 - 2) While using DA needle, loosen the three hook set screw, turn the hand-wheel, and align marker line ㉑ on ascending needle bar 2 with the bottom end of needle bar lower bushing ㉑.
4. After making the adjustments mentioned in the above steps, align hook blade point ㉑ with the center of needle ㉑. Provide a clearance of 0.04mm to 0.10mm(reference value) between the needle and the hook, then securely tighten setscrews in the hook.

Caution:

1. If the clearance between the blade point of hook and the needle is smaller than the specified value, the blade point of hook will be damaged. If the clearance is larger, stitch skip-ping will result.
2. Use a hook of the same part No. when replacing your hook with a new one.

24. 定刀的研磨与更换 (平刀)

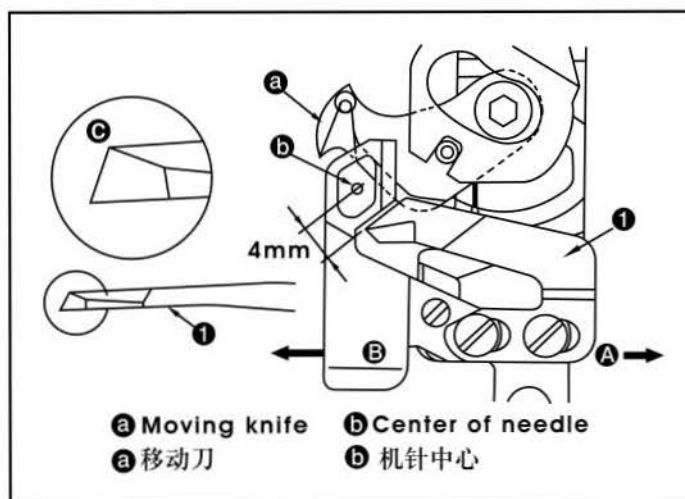
Change of counter knife (Parallel knife)



注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



切刀不快时，请尽早如图㉑所示研磨固定刀①，然后正确的安装好。

- 1) 把固定刀的安装位置往标准位置的右㉑方向移动，切线长度比标准位置时长；
- 2) 往左㉑方向移动，切线变短。

注意：研磨固定刀时请注意研磨方法。

When the knife sharpness has deteriorated, re-sharpen counter knife ① as illustrated in ㉞, and properly reinstall it.

- 1) If the mounting position of the counter knife is moved in direction ㉞ from the standard mounting position, the thread length after thread trimming will be increased accordingly.
- 2) If the mounting position is moved in direction ㉞, the thread length will be decreased accordingly.

Caution: When re-sharpening the knife blade, extra special care must be taken on the handling of the knife.

25. 定刀和动刀的研磨与更换(旋刀)

Change of counter knife and moving knife (Rotation knife)

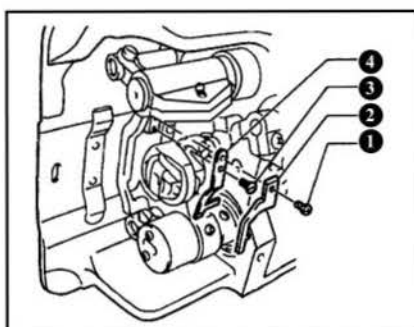


注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

25.1 固定刀

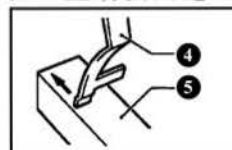


1. 放倒机头。
2. 松掉螺钉①，拆下旋梭定位钩②。
3. 松掉螺钉③，取出固定刀④。

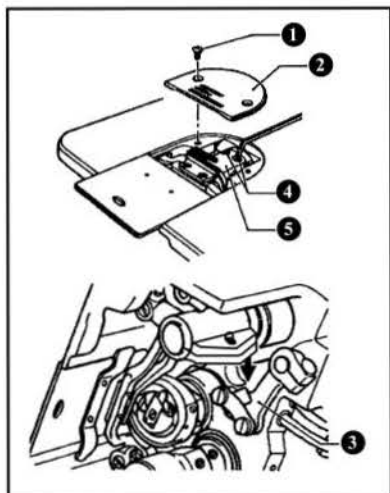
* 安装方法 请按照上面的相反步骤进行。

固定刀的研磨方法

如刀具变钝，按图示在油石⑤上磨快固定刀④。



25.2 动刀



1. 取下机针。
2. 用抬压脚扳手抬起压脚。
3. 松掉螺钉①[2个]，然后取出针板②。
4. 转动手轮，将针杆上升至最高的位置。
5. 放倒机头。
6. 按箭头所示方向推动切线驱动曲柄③直至看到螺钉④的位置。
7. 松掉螺钉④[2个]，然后取出动刀⑤。

* 安装方法 请按照上面的相反步骤进行。

26. 剪线装置的调整 (旋刀)

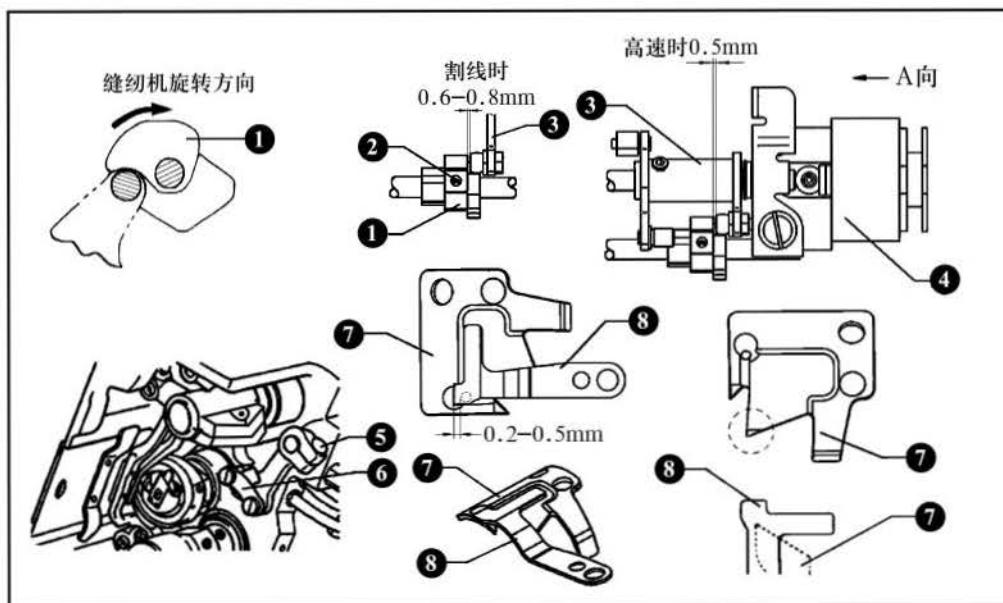
Adjustment of trimming system (Rotation knife)



注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



(一) 剪线凸轮位置的调节

转动缝纫机的上轮，当针杆从最低位置上升5mm时，用手沿A方向压紧剪线电磁铁④的铁芯，在电磁铁④的作用下，切线凸轮曲柄组件③中的滚珠被压进剪线凸轮①的凹部，临时旋紧剪线凸轮①中螺钉②，放开电磁铁铁芯，电磁铁④复位。旋松螺钉②，左右调整剪线凸轮①位置，使剪线凸轮①右端面与滚珠左端面间隙为0.5mm，旋紧螺钉②，完成剪线凸轮①位置的调节。

(二) 动刀、定刀位置调节

压紧电磁铁铁芯，切线凸轮曲柄组件③中滚珠进入剪线凸轮①凹部，转动上轮，当刀轴连杆⑥带动动刀⑦做剪线动作时，定刀⑧前端与动刀⑦刃口应当啮合0.2-0.5mm。如果没有啮合，旋松螺钉⑤，移动刀轴连杆⑥使定刀⑧的前端与动刀⑦的刃部啮合。动刀⑦、定刀⑧位置调节后要能保证在手动剪线时能剪断203棉线。

27. 送料牙的高度和倾斜度 Height and tilt of the feed dog



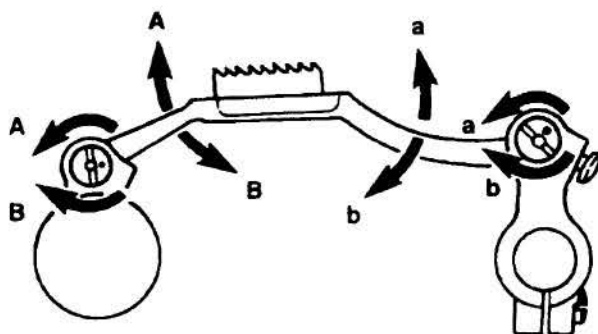
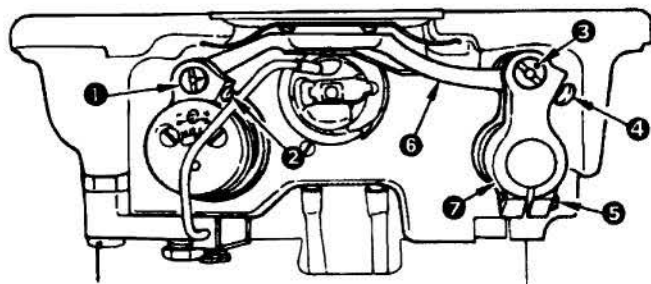
注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

薄料—中厚料 0.75 ~ 0.85mm

厚料 1mm



送料牙的高度是高出针板0.75-0.85mm(厚料为1mm)，请根据布料的具体情况调节适当的高度。

1. 送料牙的高度和倾斜度的调整

1) 拧松抬牙曲柄调节偏心销①紧定螺钉②以及牙架座偏心销③的紧定螺钉④；

2) 用螺丝刀转动①、③两销，就可以改变送料牙的高度和倾斜度；

3) 有关各销的转动方向和牙架⑥的倾斜度关系请参照图示；

4) 调整后，请把拧松的螺钉拧紧固定。（请在推住①、③偏心销的状态下拧紧②、④两颗紧定螺钉）

注意：

1. 如果只用一侧的偏心销来调整送料牙的倾斜度，送料牙的高度也会变化，所以请一定要用两侧的销来调整。
2. 如果调整销位置之后，送料牙的运动位置偏斜，请拧松牙架座⑦的紧定螺钉⑤，调整送料牙的运动位置。

Height of the feed dog is adjusted so that the feed dog protrudes from the throat plate surface by 0.75 to 0.85 mm (1 mm for Heavy type). Adjust the height in accordance with the material to be used.

1. Adjusting the height and tilt of the feed dog

- 1) Loosen setscrew ② in feed bar driving shaft ① and setscrew ④ in feed bar rocker shaft ③
- 2) Height and tilt of the feed dog will change by turning both shafts ① and ③ with a screwdriver.
- 3) For the relation between the rotating direction of each shaft and tilt of feed bar ⑥, refer to the figure on the left.
- 4) After the adjustment, securely tighten the setscrews. (Tighten setscrews ② and ④ in the state that shafts ① and ③ are pushed against the hand-wheel side.)

Caution:

1. If the tilt of the feed dog is adjusted with one shaft only, the height of the feed dog changes. Be sure to adjust it with both shafts.
2. Movement position of the feed dog may be shifted depending on the adjusting position of the shaft. At this time, loosen setscrew ⑤ in feed rocker shaft arm ⑦ and adjust the movement position.

28. 送布的同步 Adjusting the feed timing



注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.

改变抬牙凸轮①的固定位置，就可以改变送料的同步时间。

送料同步的调整方法：

1. 放倒缝纫机，拧松抬牙凸轮①的两颗固定螺钉②；
 2. 转动抬牙凸轮①，就可以变更送布的同步时间。
把抬牙曲柄的刻度③对准抬牙轴的刻线④
- 向（+）方向转动抬牙凸轮①，上下抬牙的同步时间变快；
 - 向（-）方向转动抬牙凸轮①，上下抬牙的同步时间变慢。

注意：一般情况，请把刻度③的中央对准刻线。

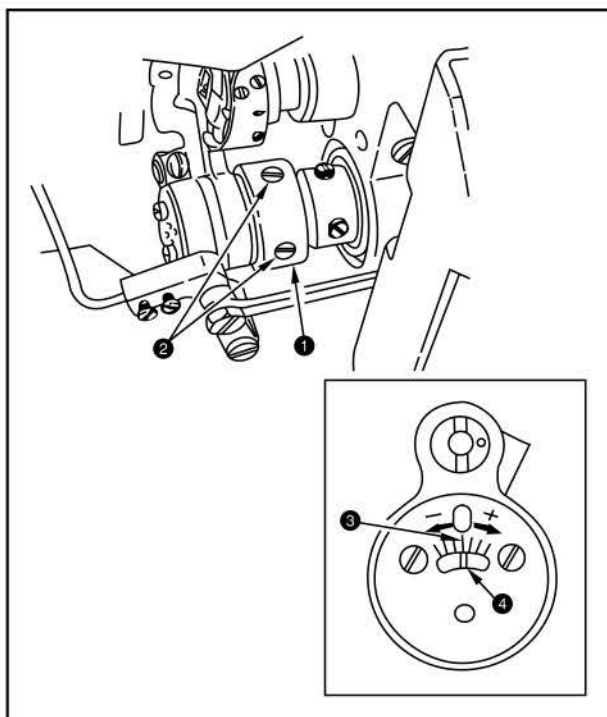
The feed timing can be changed by changing the stop position of feed eccentric cam ①.

How to adjust the feed timing

1. Tilt the sewing machine head and loosen two setscrews ② in feed eccentric cam ①.
2. Turn feed eccentric cam ① to change the feed timing.

Align graduation ③ on the feed bar driving arm with engraved marker line ④ on the feed driving shaft.

- Turn feed eccentric cam ① in the direction of (+) → Increases the feed timing.
- Turn feed eccentric cam ① in the direction of (-) → Decreases the feed timing.



Caution: For general use, use the machine in the state that center of graduation ③ is aligned with the engraved marker line.

29. 解除机构

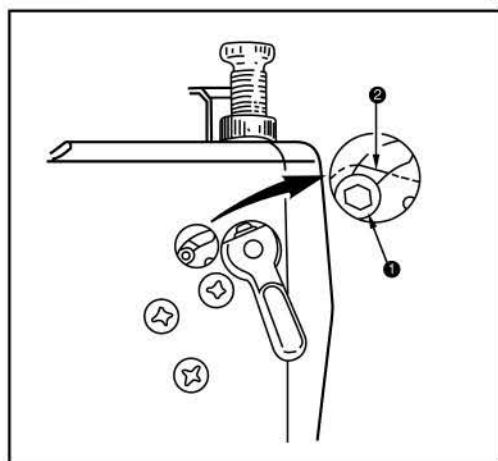
Thread tension release releasing mechanism



注意：为了防止缝纫机的意外起动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



利用松线解除机构，缝制中也可以提升面线也不松线。（厚的叠层部用膝动提升压脚，让它越过叠层部，而线张力不变化）

1. 解除方法

- 1) 卸下缝纫机的盖子，用内六角扳手拧松松线变换螺钉①；
- 2) 把螺钉①固定到松线变换板②的最上部。
抬起压脚时夹线器也不松线，面线张力也不松弛（只在切线时夹线器才松线）

注意：螺钉①的位置，只能固定到松线变换板的最上或最下位置，其它位置不能使用。
缝纫机出货时固定在最下位置。

By means of the thread tension release releasing mechanism, sewing can be performed without slackening the needle thread tension even when the presser foot is lifted during sewing. (Even when the presser foot is slightly lifted at the thick overlapped section by the knee lifter, this mechanism can prevent the thread tension from being changed.)

1. How to release

- 1) Remove the cap in the machine head and loosen thread tension release changeover screw ① using a hexagon wrench.
- 2) Fix screw ① on the top of thread tension release changeover plate ②. The thread tension disk does not rise even when the presser foot is lifted, and the needle thread tension is not loosened. (The thread tension disk rises only when thread trimming is performed.)

Caution: Do not use screw ① at any position other than the top or bottom position of the thread tension release changeover plate. The screw has been factory-set to the bottom position at the time of delivery.

30. 微量压脚提升

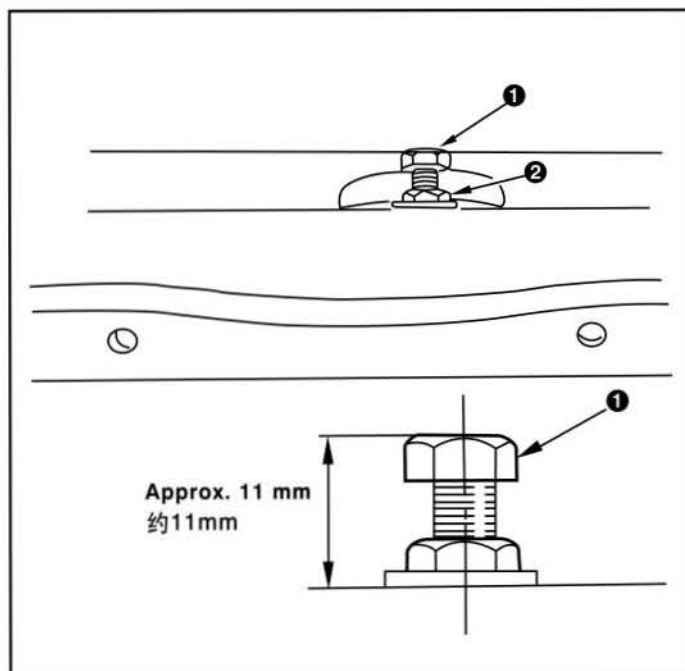
Micro-lifting mechanism of the presser foot



注意：为了防止缝纫机的意外启动，请关掉电源之后再进行操作。



Warning: Turn OFF the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



缝制丝绒等起毛性缝料时，使用微量压脚提升螺钉①功能就可以不使缝料缝偏，减轻缝料的损伤。

在螺母②拧松的状态下，一点一点拧紧微量压脚提升螺钉①，调整到适合缝料的让压脚微量上升的位置，然后将螺母②固定。

注意：微量压脚提升机构不使用时，请把螺钉①高度调整到比缝纫机高约11mm的位置。微量压脚提升机构提升后缝纫机的送布能力会减弱。

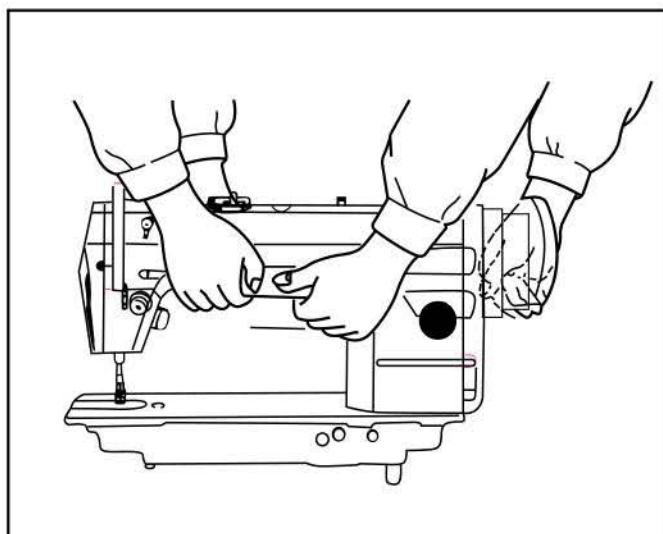
When sewing velvet or the like which is fluffy, slippage of material or damage of material is reduced by using screw ① for presser foot micro-lifting.

Gradually tighten screw ① for presser foot micro-lifting in the state that nut ② is loosened, adjust the presser foot to the position where it is finely lifted until it matches the material, and fix it with nut ②.

Caution: when the presser foot micro-lifting mechanism is not used, adjust the height of screw ① so that it is higher by approximately 11 mm than the sewing machine. If the sewing machine is operated in the state that the micro-lifting mechanism is working, sufficient feed force cannot be obtained.

31. 缝纫机的搬运及放置注意事项

Caution when carrying or placing the sewing machine



1. 搬运方法

请按照图示那样，由两人来搬运

注意：请不要抬着皮带轮来搬运

2. 放置缝纫机时的注意事项

请不要把螺丝刀等东西放到放置缝纫机的地方。

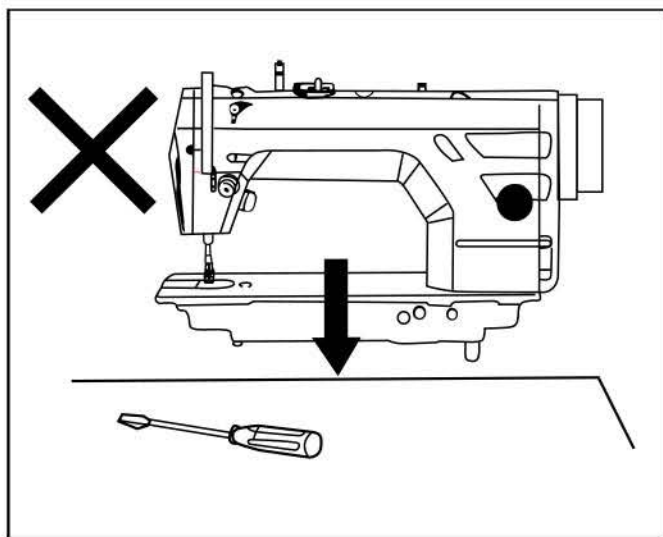
3. How to carry the sewing machine

Carry the sewing machine with two persons as shown in the figure.

Caution: Do not hold the hand-wheel.

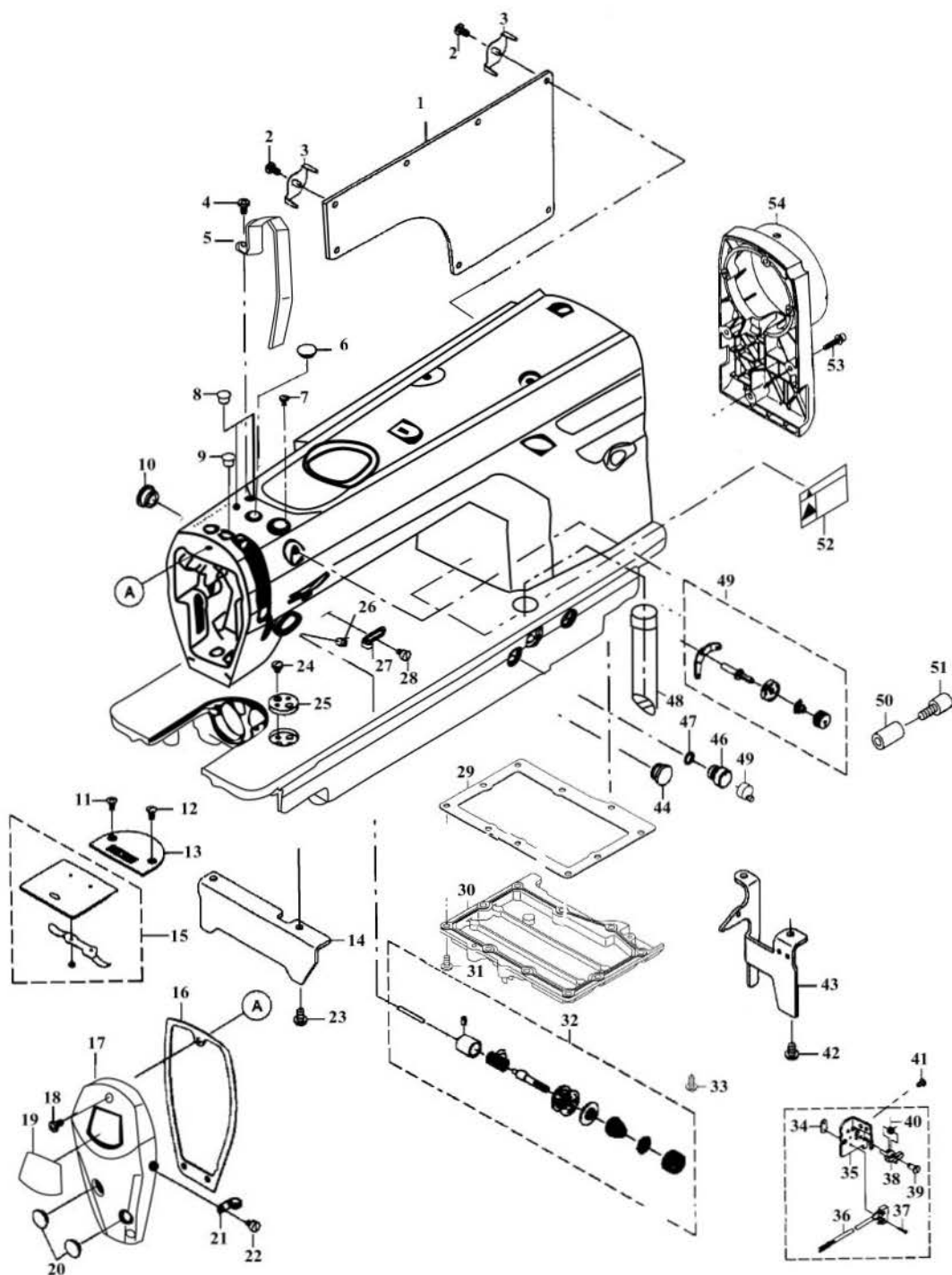
4. Caution when placing the sewing machine

Do not place any protruding thing such as screwdriver or the like on the place where the sewing machines is set.



1、机体部件

MACHINE FRAME & MISCELLANEOUS COVER COMPONENTS



1、机体部件

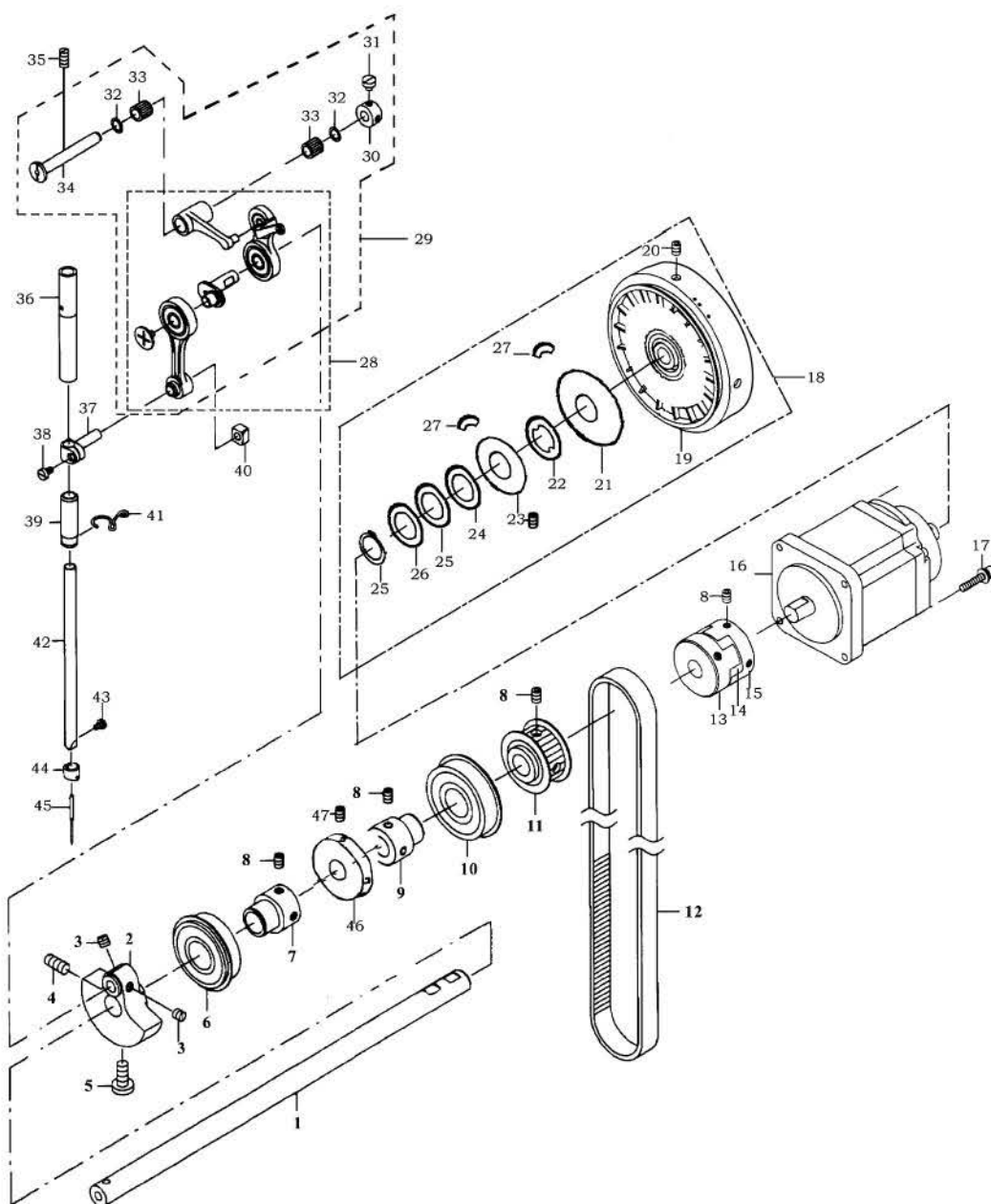
序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
1	217GR103	后盖板	SIDE PLATE	1	☆	
2	GS300-8	后盖板螺钉	SCREW 3/16-28 L=9	7	☆	
3	GR1006-8	电线压板	CORSHOLDER	2	☆	
4	GS300-8	挑线杆防护罩螺钉	SCREW 3/16-28 L=9	1	☆	
5	280GR101	挑线杆防护罩	THREAD TAKE-UP LEVER COVER	1	☆	
6	217GR109	橡胶塞 $\phi 12$	RUBBER PLUG D=12.5 L=4	1	☆	
7	217GS107	小夹线固定螺钉	SCREW 11/64-40 L=7	1	☆	
8	217GR105	橡胶塞 $\phi 8$	RUBBER PLUG	1	☆	
9	217GR113	针杆上套橡胶塞	CAP	2	☆	
10	217GR104	橡胶塞 $\phi 13.5$	RUBBER PLUG	1	☆	
11	217GS103	针板螺钉	SCREW 11/64-40 L=8.5	1	☆	
	GC5580-D3. 1-8	针板螺钉	SCREW 11/64-40 L=8.5	1		☆
12	GS338-8	针板螺钉(一字头)	SCREW 11/64-40 L=8.5	1	☆	
	GC5580-D3. 1-9	针板螺钉(一字头)	SCREW 11/64-40 L=8.5	1		☆
13	217GM101	针板	THROAT PLATE	1	☆	
	ZJ5580-5-D3. 1-2	针板	THROAT PLATE	1		☆
14	217. 1-23	齿轮箱油标	CEAR BOX FLOATER ASM.	1	☆	
15	GW167/4-8	推板组件	SLIDE PLATE ASM.	1	☆	
16	280GO101	面板垫	FACE PLATE PACKING	1	☆	
17	280GR102	面板	PACE PLATE	1	☆	
18	GS300-8	面板螺钉	SCREW 3/16-28 L=9	3	☆	
19	240GB101	面板装饰牌	PLATE	1	☆	
20	GR583-8	面板橡胶塞	RUBBER PLUG D=12.5 L=4	2	☆	
21	GR604-8	左线勾	ARM THREAD GUIDE B.	1	☆	
22	GS313-8	左线勾固定螺钉	SCREW 11/64-40 L=6	1	☆	
23	217GS101	前支撑板螺钉	SCREW 15/64-28 L=9	2	☆	
24	GS373-8	限位挡片螺钉	SCREW 11/64-40 L=5	2	☆	
25	GR724-8	限位挡片	RULER STOP SEAT	1	☆	
26	GS316-8	夹线调节座固定螺钉	SCREW 15/64-28 L=7	1	☆	
27	GR603-8	右线勾	ARM THREAD GUIDE A	1	☆	
28	GS313-8	右线勾固定螺钉	SCREW 11/64-40 L=6	1	☆	
29	217GR106	箱盖密封垫	GEAR BOX PACKING	1	☆	
30	217GR110	齿轮箱盖	GEAR BOX COVER	1	☆	
31	217GS102	齿轮箱盖螺钉	SCREW 3/16-28 L=10	10	☆	
32	GR605/11-8	夹线组件	THREAD TENSION ASM.	1	☆	
	ZJ5580-5-D3. 1-2	夹线组件	THREAD TENSION ASM.	1		☆
33	217GS105	油窗固定螺钉	SCREW	4	☆	
34	218GD153	保险开关螺母板	SAFETY SWITCH HUT	1	☆	
35	218GD156	保险开关体	SAFETY SWITCH BASE	1	☆	
36	218GD157	保险开关	SAFETY SWITCH CORD ASM	1	☆	
37	218GD152	插座螺钉	SCREW	1	☆	
38	218GD155	保险开关支架	SAFETY SWITCH ARM	1	☆	
39	218GD154	保险开关支架轴	SAFETY SWITCH ARM SHAFT	1	☆	
40	218GD151	保险开关簧	SAFETY SWITCH SPRING	1	☆	

1、机体部件

序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
41	GR1006-8	电线压板	CORSHOLDER	2	☆	
42	217GS101	后支撑板固定螺钉	SCREW 15/64-28 L=9	2	☆	
43	217GY501	后支撑板	BED STUD B	1	☆	
44	217GR107	橡胶塞 $\phi 12$	RUBBER PLUG	1	☆	
45	101GR103	橡皮盖	AIR-DISCHARGING CAP	1	☆	
46	217GR108	排气阀	AIR-DISCHARGING	1	☆	
47	217GF101	O型圈	RUBBER RING	1	☆	
48	217GF101	O型圈	RUBBER RING	1	☆	
49	GR1013/5-8	小夹线组件	THREAD TENSION GUIDE	1	☆	
50	211-0320	限位柱套	REVERSE FEED LEVER STOPPER	1	☆	
51	217GS150	限位柱	SCREW	1	☆	
52	GQ196-8	警示标牌	SAFETY LABEL	1	☆	
53	101BJ114	后盖螺钉	BOLT	4	☆	
54	280BJ101	后盖组件	PULLEY COVER	1	☆	

2、上轴部件

MAIN SHAFT & NEDDLE BAR COMPONENTS



2、上轴部件

序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
1	218GZ101	上轴	MAIN SHAFT	1	☆	
2	217GH101	针杆曲柄	COUNTER WEIGHT	1	☆	
3	GS305-8	挑线曲柄紧固螺钉	SCREW 1/4-40 L=6	2	☆	
4	GS307-8	针杆曲柄紧固螺钉	SCREW 9/32-28 L=16	1	☆	
5	GS371-8	针杆曲柄定位螺钉	SCREW 9/32-28 L=16	1	☆	
6	217GU102	上轴前轴承	BEARING	1	☆	
7	217GO106	上轴前轴承套	MAIN SHAFT BEARING SUPPORT	1	☆	
8	217GS107	上轴前轴承套螺钉	SCREW M6 L=8	6	☆	
9	217GO105	上轴后轴承套	MAIN SHAFT BEARING SUPPORT	1	☆	
10	217GU101	上轴后轴承	BEARING	1	☆	
11	217GP101	上轴同步齿形带轮	SPROCKET,UPPER	1	☆	
12	27GE101	齿形带	TIMING BELT	1	☆	
13	218GO151	上轴连轴器	COUPLING	1	☆	
14	501GB118	上轴传动连接橡胶块	SCREW	1	☆	
15	218GO152	电机轴连轴器	COUPLING	1	☆	
16	218GD162	电机	MOTOR	1	☆	
17	101BJ114	上轴电机螺钉组件	BOLT	4	☆	
18	218GP149	上轮组件	HEAD WHEEL ASM	1	☆	
19	280GP101	上轮	HEAD WHEEL	1	☆	
20	218GS105	上轮紧固螺钉	SCREW	2	☆	
21	218GD158	下定位片	DOWN GO TO PARCEL	1	☆	
22	218GD159	隔离片	SEPARATE PARCEL	1	☆	
23	218GD160	上定位片	HEAD GO TO PARCEL	1	☆	
24	218GK150	垫片	WASHER	2	☆	
25	218GK149	弹簧垫片	WASHER	1	☆	
26	218GK151	卡圈	E-RING	1	☆	
27	218GD161	反光片	GLISTEN PARCEL	1	☆	
28	217BJ150	挑线杆组件	THREED TAKE-UP ASM	1	☆	
	282.2.2	挑线杆组件	THREED TAKE-UP ASM	1		☆
29	217BJ108	挑线杆部件	THREED TAKE-UP ASM	1	☆	
		挑线杆部件	THREED TAKE-UP ASM	1		☆
30	217GK101	挑线杆铰链轴挡圈	THRUST COLLAR	1	☆	
31	217GS108	挑线杆铰链轴挡圈螺钉	SCREW	1	☆	
32	217GK102	挑线杆铰链轴滚针轴承挡圈	BEARING SUPPORT	1	☆	
33	217GU103	挑线杆铰链轴滚针轴承	BEARING	1	☆	
34	217GZ103	挑线杆铰链轴	THREED TAKE-UP CRANK SHAFT	1	☆	
35	GS308-8	挑线杆铰链轴紧固螺钉	SCREW	1	☆	
36	280GO102	针杆上套	NEEDLE BAR METAL UPPER	1	☆	
37	GR598-8	针杆连接柱	NEEDLE ROD HOLDER	1	☆	
38	GS311-8	针杆连接柱螺钉	SCREW	1	☆	
39	GU152-8	针杆连接柱滑块	SLIDE BLOCK	1	☆	
40	217GO104	针杆下套	NEEDLE BAR METAL LOWER	1	☆	
	282.2-1a/b	针杆下套	NEEDLE BAR METAL LOWER	1		☆

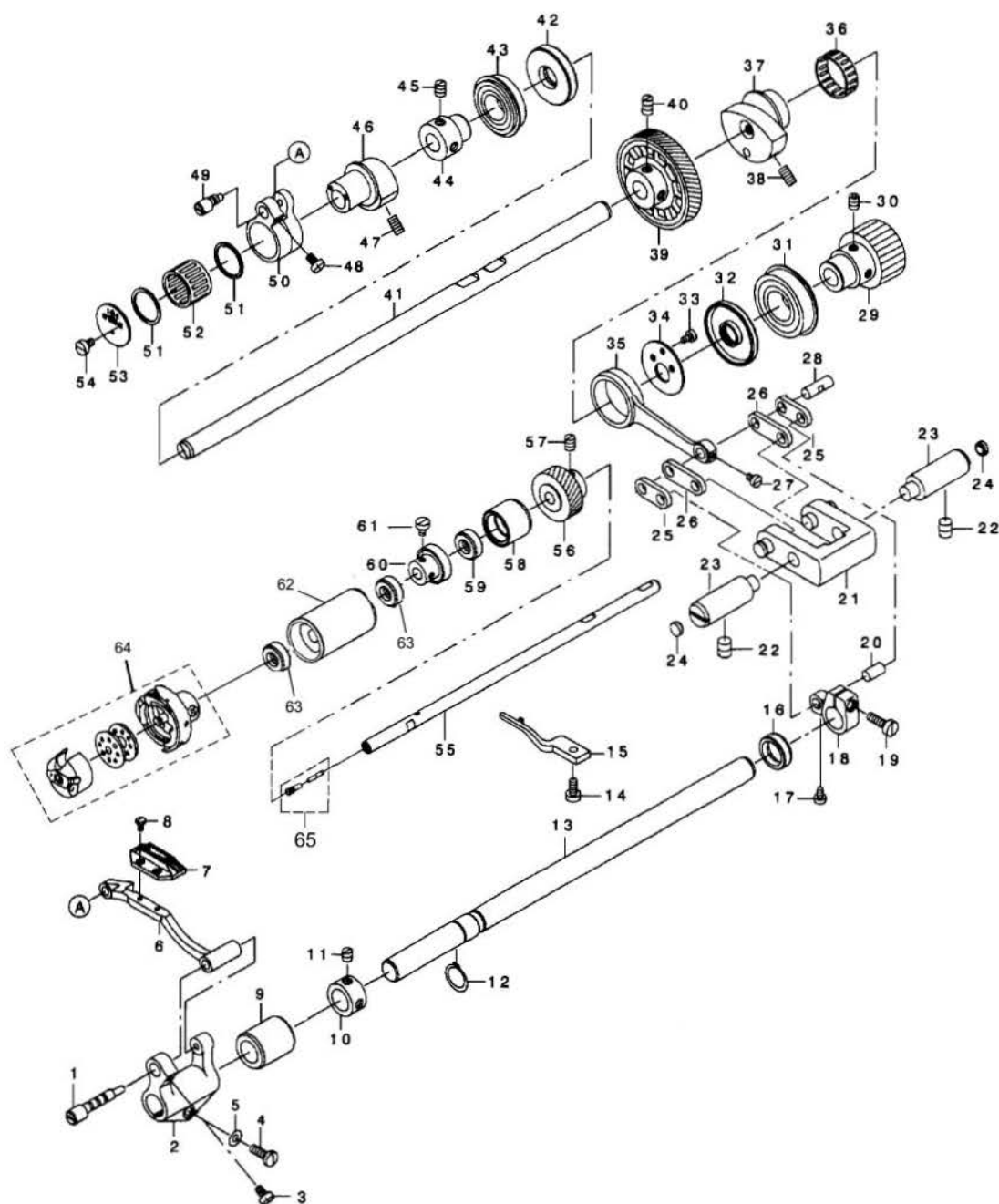
2、上轴部件

序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
41	GR909-8	针杆下套分线勾	NEEDLE BAR THREAD GUIDE	1	☆	
42	217GZ102	针杆	NEEDLE BAR	1	☆	
	282.2.1.1-1a/b	针杆	NEEDLE BAR	1		☆
43	GS467-8	支针螺钉	SCREW	1	☆	
44	GR904-8	针杆过线环	NEEDLE BAR THREAD GUIDE	1	☆	
	GC5600NL3-4	针杆过线环	NEEDLE BAR THREAD GUIDE	1		☆
45	217GU101	机针DPx5 14#	NEEDLE	1	☆	
46	217GC151	绕线器驱动轮	BOBBLE WINDER DRIVING WHEEL	1	☆	
47	217GC152	绕线器驱动轮螺钉	SCREW	2	☆	

3.1 下轴送料部件 (平刀)

HORIZONTAL FEED & VERTICAL FEED AND

HOOK DRIVING SHAFT COMPONENTS (Parallel knife)



3.1 下轴送料部件（平刀）

序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
1	217GX105	牙架座偏心销	FEED ROCKER BASE SHAFT	1	☆	☆
2	217GH107	牙架座	FEED ROCKER BASE ARM	1	☆	
3	GS336-8	牙架座偏心销紧定螺钉	SCREW 11/64-40 L=7	1	☆	
4	GS335-8	牙架座固定螺钉	SCREW 3/18-28 L=14	1	☆	
5	GR646-8	牙架座垫圈	WASHER 4.8x8.4x0.8	1	☆	
6	GM192-8	送料牙	FEED BASE	1	☆	
	ZJ5580-5-D3.6-1	送料牙	FEED BASE			
7	217GH106	牙架	FEED DOG	1	☆	
8	GS337-8	送料牙螺钉	SCREW 1/8-44 L=6	2	☆	
9	217GO108	送料轴轴套	FEED ROCKER SHAFT METAL	1	☆	
10	GR589-8	送料轴挡圈	MAIN SHAFT THRUST COLLAR	1	☆	
11	GS305-8	送料轴挡圈螺钉	SCREW 1/4-40 L=6	2	☆	
12	217GK104	送料轴卡圈	BETAINING RING 13.8	1	☆	
13	217GZ105	送料轴	FEED ROCKER SHAFT METAL	1	☆	
14	GS328-8	旋梭定位勾螺钉	SCREW 11/64-40 L=9.5	1	☆	
15	GR631-8	旋梭定位勾	BOBBIN CASE HOLDER	1	☆	
16	217GF104	送料轴油封	OIL SEAL	1	☆	
17	GS338-8	送料后曲柄销紧定螺钉	SCREW	1	☆	
18	217GH111	送料后曲柄	FEED ROCKER ARM	1	☆	
19	GS334-8	送料后曲柄固定螺钉	SCREW 3/16-28 L=15.5	1	☆	
20	GX208-8	送料后曲柄销	WALKING FOOT PIN B	1	☆	
21	217BJ118	送料摆动板座组件	ADJUSTING LINK ASM	1	☆	
22	GS316-8	送料摆动座销紧定螺钉	SCREW	2	☆	
23	217GX106	送料摆动座销	ADJUSTING LINK ASM FULCRUM	2	☆	
24	217GR114	送料摆动座销孔橡皮塞	RUBBER PLUG	2	☆	
25	GR640-8	送料摆动座短连接板	CONNECTING LINK,B	2	☆	
26	217GH110	送料摆动座长连接板	CONNECTING LINK,A	2	☆	
27	GS333-8	送料连接销螺钉	SCREW	1	☆	
28	GX204-8	送料连杆销	WALKING FOOT PIN C	1	☆	
29	217GC116	抬牙轴同步齿形带轮	LOWER SPROCKET	1	☆	
30	217GS107	抬牙轴同步齿形带轮螺钉	SCREW M6 L=8	2	☆	
31	217GU110	抬牙轴后轴承	BEARING	1	☆	
32	GS311-8	送料偏心轮挡片螺钉	OIL SEAL	2	☆	
33	217GR115	送料偏心轮挡片	SCREW 9/64-40 L=6	1	☆	
34	217GH109	送料摇动连杆	FEED ROCKER CAM PLATE	1	☆	
35	217GF103	抬牙轴后油封	FEED ROCKER ROD	1	☆	
36	217GU109	送布偏心轮滚针轴承	NEEDLE BEARING	1	☆	
37	217GT102	送料偏心轮	FEED ROCKER CAN PLATE	1	☆	
38	GS308-8	送料偏心轮螺钉	SCREW 15/64-28 L=10.5	2	☆	
39	217BJ116	抬牙轴斜齿轮	GEAR,LARGE	1	☆	
40	SS-7161040	抬牙轴斜齿轮螺钉	SCREW 1/4-40 L=10	2	☆	
41	217GZ104	抬牙轴	FEED DRIVING SHAFT	1	☆	
42	217GF102	抬牙轴前油封	OIL SEAL	1	☆	
43	217GU107	抬牙轴轴承	BEARING	1	☆	
44	217GO108	抬牙轴轴承套	BEARING SUPPORT	1	☆	

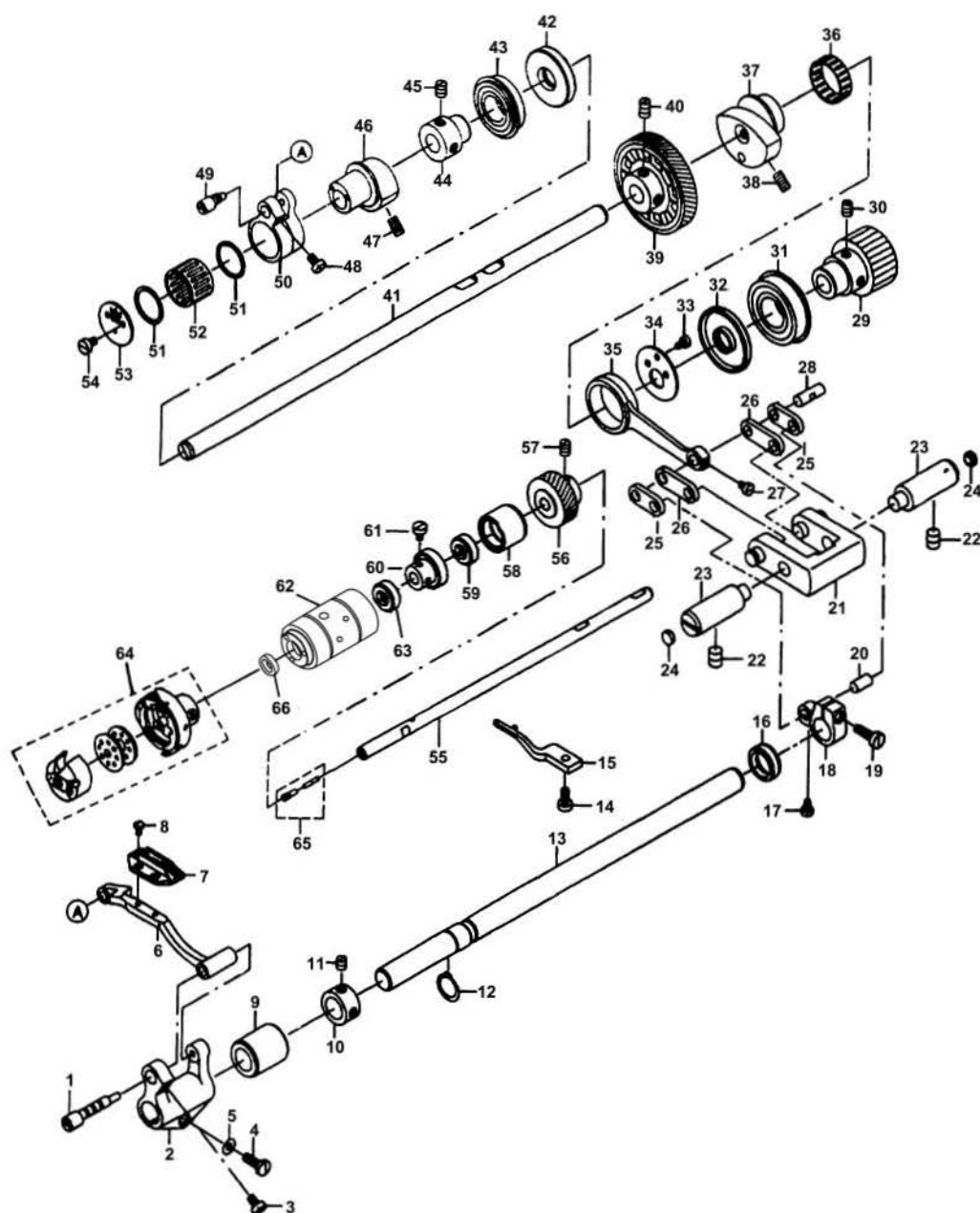
3.1 下轴送料部件（平刀）

序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
45	GS319-8	抬牙轴轴承套螺钉	SCREW	2	☆	☆
46	217GT101	抬牙凸轮	FEED DRIVG CAM	1	☆	
	282.3.1.1-1	抬牙凸轮	FEED DRIVG CAM	1		
47	GS308-8	抬牙凸轮紧定螺钉	SCREW	2	☆	
48	GS336-8	抬牙曲柄偏心销紧定螺钉	SCREW	1	☆	
49	217GX104	抬牙曲柄偏心销	FEED DRIVG BASE SHAFT	1	☆	
50	217GH108	抬牙曲柄	FEED DRIVING BASE ARM	1	☆	
51	217GK103	抬牙凸轮滚针轴承挡圈	FEED DRIVING CAM THRUST BU	2	☆	
52	217GU106	抬牙凸轮滚针轴承	BEARING	1	☆	
53	217GR114	抬牙凸轮挡板	FEED DRIVING CAM PLATE	1	☆	
54	GS311-8	抬牙凸轮挡板螺钉	SCREW	2	☆	☆
55	217GZ104	下轴	HOOK SHAFT	1	☆	
56	217GC103	下轴斜齿轮	GEAR SMALE	1	☆	
57	GS319-8	下轴斜齿轮螺钉	SCREW	2	☆	
58	217GO112	下轴后轴承	HOOK SHAFT REAR METAL	1	☆	
59	217GF105	下轴后轴承油封	HOOK DRIVING SHAFT OIL SEAL	1	☆	
60	217BJ112	下轴后轴承套组件	BEARING SUPPORT ASM	1	☆	
61	SS-6110640	下轴后轴承套螺钉	SCREW	2	☆	
62	227GO103	下轴前轴套	HOOK SHAFT MATAL COMPL	1	☆	
63	227GO104	下轴前轴承油封	OIL SEAL	2	☆	
64	217BJ110	旋梭组件	HOOK ASM	1	☆	
	HPT-1H	旋梭组件	HOOK ASM	1		
65	227GB150	下轴限油组件	OIL SEAL SCREW ASM		☆	

3.2 下轴送料部件 (旋刀)

HORIZONTAL FEED & VERTICAL FEED AND

HOOK DRIVING SHAFT COMPONENTS (Rotation knife)



3.2 下轴送料部件 (旋刀)

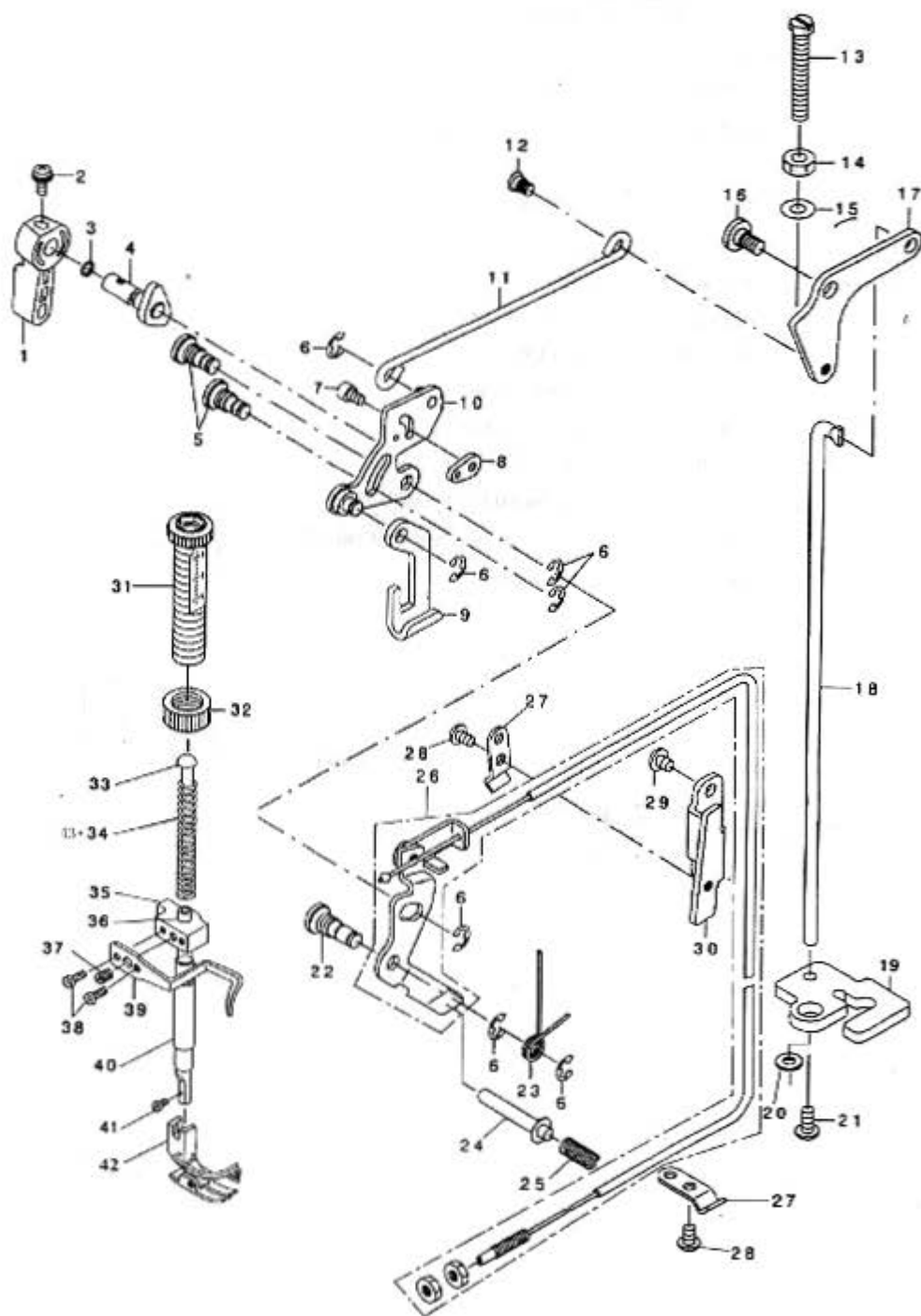
序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
1	217GX105	牙架座偏心销	FEED ROCKER BASE SHAFT	1	☆	☆
2	217GH107	牙架座	FEED ROCKER BASE ARM	1	☆	
3	GS336-8	牙架座偏心销紧定螺钉	SCREW 11/64-40 L=7	1	☆	
4	GS335-8	牙架座固定螺钉	SCREW 3/16-28 L=14	1	☆	
5	GR646-8	牙架座垫圈	WASHER 4.8x8.4x0.8	1	☆	
6	GM192-8	送料牙	FEED BASE	1	☆	
	ZJ5580-5-D3.6-1	送料牙	FEED BASE	1		
7	217GH106	牙架	FEED DOG	1	☆	
8	GS337-8	送料牙螺钉	SCREW 1/8-44 L=6	2	☆	
9	281.3-1	送料轴轴套	FEED ROCKER SHAFT METAL	1	☆	
10	281.3-5	送料轴挡圈	MAIN SHAFT THRUST COLLAR	1	☆	
11	B.2-5	送料轴挡圈螺钉	SCREW	2	☆	
12	217GK104	送料轴卡圈	BETAINING RING 13.8	1	☆	
13	281.3-2	送料轴	FEED ROCKER SHAFT METAL	1	☆	
14	308.3-5	旋梭定位勾螺钉	SCREW 11/64-40 L=9.5	1	☆	
15	GC999.2-4	旋梭定位勾	BOBBIN CASE HOLDER	1	☆	
16	217GF104	送料轴油封	OIL SEAL	1	☆	
17	GS338-8	送料后曲柄销紧定螺钉	SCREW	1	☆	
18	217GH111	送料后曲柄	FEED ROCKER ARM	1	☆	
19	GS334-8	送料后曲柄固定螺钉	SCREW 3/16-28 L=15.5	1	☆	
20	GX208-8	送料后曲柄销	WALKING FOOT PIN B	1	☆	
21	217BJ118	送料摆动板座组件	ADJUSTING LINK ASM	1	☆	
22	GS316-8	送料摆动座销紧定螺钉	SCREW	2	☆	
23	217GX106	送料摆动座销	ADJUSTING LINK ASM FULCRUM	2	☆	
24	217GR114	送料摆动座销孔橡皮塞	RUBBER PLUG	2	☆	
25	GR640-8	送料摆动座短连接板	CONNECTING LINK,B	2	☆	
26	217GH110	送料摆动座长连接板	CONNECTING LINK,A	2	☆	
27	GS333-8	送料连接销螺钉	SCREW	1	☆	
28	GX204-8	送料连杆销	WALKING FOOT PIN C	1	☆	
29	217GC116	抬牙轴同步齿形带轮	LOWER SPROCKET	1	☆	
30	217GS107	抬牙轴同步齿形带轮螺钉	SCREW M6 L=8	2	☆	
31	217GU110	抬牙轴后轴承	BEARING	1	☆	
32	GS311-8	送料偏心轮挡片螺钉	OIL SEAL	2	☆	
33	217GR115	送料偏心轮挡片	SCREW 9/64-40 L=6	1	☆	
34	217GH109	送料摇动连杆	FEED ROCKER CAN PLATE	1	☆	
35	217GF103	抬牙轴后油封	FEED ROCKER ROD	1	☆	
36	217GU109	送布偏心轮滚针轴承	NEEDLE BEARING	1	☆	
37	217GT102	送料偏心轮	FEED ROCKER CAN PLATE	1	☆	
38	GS308-8	送料偏心轮螺钉	SCREW 15/64-28 L=10.5	2	☆	
39	217BJ116	抬牙轴斜齿轮	GEAR,LARGE	1	☆	
40	SS-7161040	抬牙轴斜齿轮螺钉	SCREW 1/4-40 L=10	2	☆	
41	217GZ104	抬牙轴	FEED DRIVING SHAFT	1	☆	
42	217GF102	抬牙轴前油封	OIL SEAL	1	☆	
43	217GU107	抬牙轴轴承	BEARING	1	☆	
44	217GO108	抬牙轴轴承套	BEARING SUPPORT	1	☆	

3.2 下轴送料部件（旋刀）

序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
45	GS319-8	抬牙轴轴承套螺钉	SCREW	2	☆	☆
46	217GT101	抬牙凸轮	FEED DRIVG CAM	1	☆	
	282.3.1.1-1	抬牙凸轮	FEED DRIVG CAM	1	☆	
47	GS308-8	抬牙凸轮紧定螺钉	SCREW	2	☆	
48	GS336-8	抬牙曲柄偏心销紧定螺钉	SCREW	1	☆	
49	217GX104	抬牙曲柄偏心销	FEED DRIVG BASE SHAFT	1	☆	
50	217GH108	抬牙曲柄	FEED DRIVING BASE ARM	1	☆	
51	217GK103	抬牙凸轮滚针轴承挡圈	FEED DRIVING CAM THRUST BUSH	2	☆	
52	217GU106	抬牙凸轮滚针轴承	BEARING	1	☆	
53	217GR114	抬牙凸轮挡板	FEED DRIVING CAM PLATE	1	☆	
54	GS311-8	抬牙凸轮挡板螺钉	SCREW	2	☆	☆
55	217GZ104	下轴	HOOK SHAFT	1	☆	
56	217GC103	下轴斜齿轮	GEAR SMALE	1	☆	
57	GS319-8	下轴斜齿轮螺钉	SCREW	2	☆	
58	217GO112	下轴后轴承	HOOK SHAFT REAR METAL	1	☆	
59	217GF105	下轴后轴承油封	HOOK DRIVING SHAFT OIL SEAL	1	☆	
60	217BJ112	下轴后轴承套组件	BEARING SUPPORT ASM	1	☆	
61	SS-6110640	下轴后轴承套螺钉	SCREW	2	☆	
62	281.3-3	下轴前轴套	HOOK SHAFT MATAL COMPL	1	☆	
63	227GO104	下轴前轴承油封	OIL SEAL	2	☆	
64	217BJ110	旋梭组件	HOOK ASM	1	☆	☆
	HPT-1H	旋梭组件	HOOK ASM	1		
65	227GB150	下轴限油组件	OIL SEAL SCREW ASM	1	☆	
66	281.3-4	下轴前轴套前油封	OIL SEAL	1	☆	

4、抬压脚部件

HANG LIFTER & TENSION RELEASE COMPONENTS

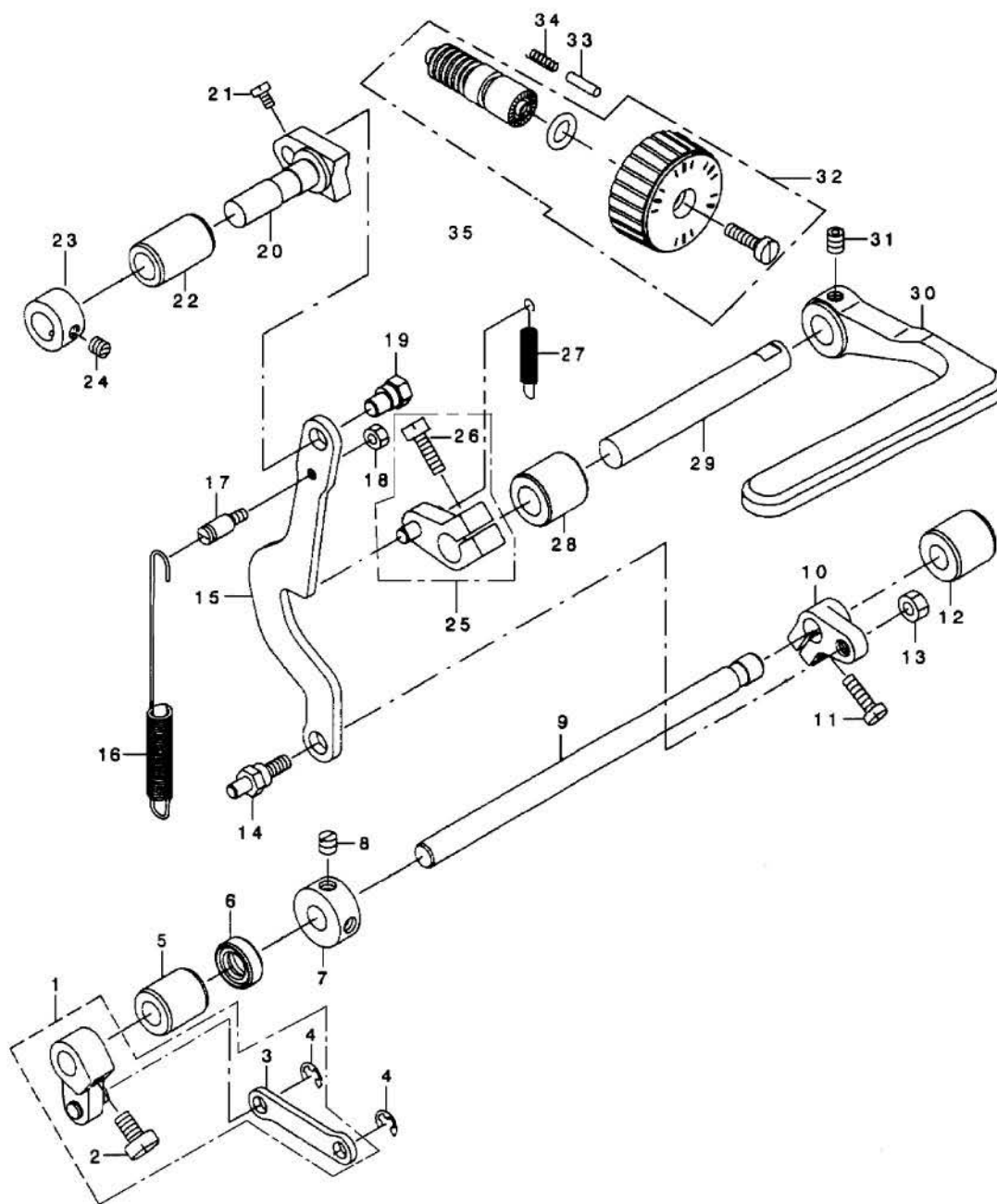


4、抬压脚部件

序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	微油	无油	
						薄料 中厚料	极薄料 内衣料
1	GR619-8	压脚扳手	HAND LIFTER	1	☆	☆	☆
2	GS322-8	压脚扳手螺钉	SCREW	1	☆	☆	☆
3	GR621-8	压脚扳手轴O形圈	RUBBER RING	1	☆	☆	☆
4	GR620/2-8	压紧杆提升凸轮组件	HAND LIFTER CAM ASM.	1	☆	☆	☆
5	GS323-8	前杠杆轴	LINK SHAFT	2	☆	☆	☆
6	GR625-8	卡簧	E-RING	7	☆	☆	☆
7	217GS116	连接销螺钉	SCREW	1	☆	☆	☆
8	217GH119	小连板	PLATE	1	☆	☆	☆
9	GR622-8	压脚升降板	LIFTING PLATE	1	☆	☆	☆
10	217BJ128	前杠杆组件	LIFTING LINK COMPL.	1	☆	☆	☆
11	217GH117	膝控提升杆	LIFTING LEVER CONNECT ROD	1	☆	☆	☆
12	217GS115	拉杆螺钉	HINGE SCREW	1	☆	☆	☆
13	217GS109	六角螺钉	BOLT	1	☆	☆	☆
14	217GL101	螺母	NUT	1	☆	☆	☆
15	217GK105	垫圈	WASHER	1	☆	☆	☆
16	217GS112	后杠杆轴位螺钉	HING SCREW	1	☆	☆	☆
17	217GH116	后杠杆	LIFTING LEVER LINK	1	☆	☆	☆
18	217GH115	膝控提升拉杆	CONNECTING ROD	1	☆	☆	☆
19	217GH113	提升杆导板	CONNECTING ROD GUIDE	1	☆	☆	☆
20	217GF106	抬压脚顶杆O形圈	WASHER	1	☆	☆	☆
21	217GS113	提升杆导板螺钉	SCREW	1	☆	☆	☆
22	GS324-8	拉线杠杆轴	TENSION RELEASE SHAFT	1	☆	☆	☆
23	GW189-8	松线顶板复位簧	TENSION RELEASE RETURN SPRING	1	☆	☆	☆
24	217GX101	松线轴钉	TENSION RELEASE SUPPORTING PIN	1	☆	☆	☆
25	GW185-8	松线轴钉弹簧	TENSION RELEASE PIN SPRING	1	☆	☆	☆
26	217BJ126	抬压脚拉线组件	KNEELIFTING TENSION RELEASE MODULE	1	☆	☆	☆
27	217GD101	拉线固定板	WIRE HOLDER A	1	☆	☆	☆
28	217GS106	拉线固定板螺钉	SCREW	1	☆	☆	☆
29	217GS110	拉线固定架螺钉	SCREW	1	☆	☆	☆
30	217GD103	抬压脚拉线固定架螺钉	SCREW	1	☆	☆	☆
31	217GS111	调压螺钉	PRESSER SPRING REGULATOR	1	☆	☆	☆
32	GL168-8	调压螺母	NUT	1	☆	☆	☆
33	GR613-8	压紧杆弹簧导柱	PRESSER GUIDE BAR	1	☆	☆	☆
34	GW187-8	压杆弹簧	PRESSER SPRING	1	☆	☆	☆
35	GR614-8	压紧杆架	PRESSER BAR GUIDE BRACKET	1	☆	☆	☆
36	GZ231-8	压紧杆	PRESSER BAR	1	☆	☆	☆
37	GS319-8	压杆导架螺钉	SCREW	1	☆	☆	☆
38	GS320-8	缓线调节勾螺钉	SCREW	2	☆	☆	☆
39	GR615-8	大线勾	PRESSER BAR THREAD GUIDE	1	☆	☆	☆
40	217GD114	压杆衬套	BUSHING	1	☆	☆	☆
41	GS321-8	活压脚螺钉	SCREW	1	☆	☆	☆
42	GM164/5-8	压脚组件	PRESSER FOOT ASM.	1	☆	☆	☆
43	218GW101	压杆弹簧	PRESSER SPRING	1	—	—	☆

5、倒缝部件

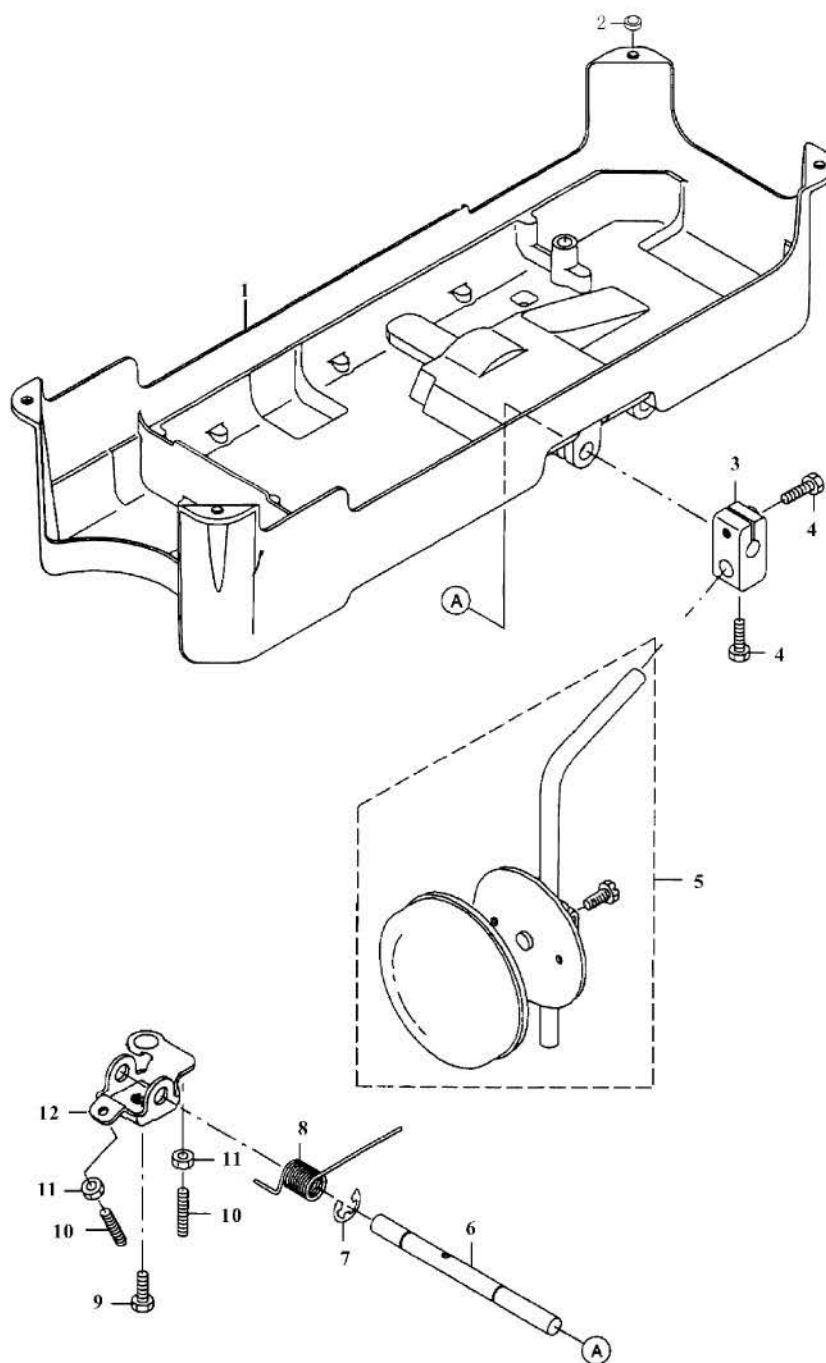
FEED ADJUST MECHANISM COMPONENTS



5、倒缝部件

序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
1	217BJ131	送料摆动座前曲柄组件	FEED CHANGING SHAFT ARM,A	1	☆	
2	GS332-8	送料摆动座前曲柄螺钉	SCREW 1/4-40 L=11	1	☆	
3	217GH121	送料摆动座摆动连板	ADJUSTING LINK CONNECTING LINK	1	☆	
4	GR625-8	送料摆动座前曲柄销卡簧	E-RING	1	☆	
5	217GO115	针距调节轴前套	METAL,A	1	☆	
6	217GF107	针距调节轴油封	FEED CHANGING SHAFT OIL SEAL	1	☆	
7	217GK106	针距调节轴挡圈	THRUST COLLAR	1	☆	
8	GS305-8	针距调节轴挡圈螺钉	SCREW 1/4-40 L=6	2	☆	
9	217GZ106	针距调节轴	FEED CHANGING SHAFT	1	☆	
10	217GH124	送料摆动座后曲柄	FEED CHANGING SHAFT ARM,B	1	☆	
11	GS334-8	送料摆动座后曲柄螺钉	SCREW 3/16-28 L=15.5	1	☆	
12	217GO116	针距调节轴后套	METAL,B	1	☆	
13	217GL103	摆动座后曲柄连接销螺母	NUT 15/64-28	1	☆	
14	217GX111	送料摆动座后曲柄连接销	FEED CHANGING SHAFT ARMB PIN	1	☆	
15	217GH125	针距调节连接板	FEED ADJUSTING ROD	1	☆	
16	217GW102	倒送料调节簧	FEED ADJUSTING SPRING	1	☆	
17	217GX112	弹簧挂销	SPRING SUSPENSION	1	☆	
18	217GL104	弹簧挂销螺母	NUT 11/64-40	1	☆	
19	217GX110	针距调节偏心销	FEED ADJUSTING PIN	1	☆	
20	217GH126	针距调节座	FEED ADJUSTING BASE	1	☆	
21	GS311-8	针距调节座螺钉	SCREW 9/64-40 L=6	2	☆	
22	217GO118	针距座轴套	ADJUSTING BASE SHAFT METAL	1	☆	
23	217GK107	针距调节座挡圈	COLLAR ASM D=11.1 W=10	1	☆	
24	217GS117	针距调节座挡圈螺钉	SCREW 1/4-40 L=3.0	2	☆	
25	217BJ134	倒送料扳手曲柄组件	FEED LEVER ARM ASM	1	☆	
26	GS334-8	倒送料曲柄螺钉	SCREW 3/16-28 L=15.5	1	☆	
27	217GW101	倒送料曲柄簧	FEED LEVER SPRING	1	☆	
28	217GO117	倒送料扳手轴轴套	FEED LEVER SHAFT METAL	1	☆	
29	217GZ107	倒送料轴	FEED LEVER SHAFT	1	☆	
30	217GH120	倒送料扳手	FEED LEVER	1	☆	
31	217GS107	倒送料轴紧固螺钉	SCREW M6 L=8	2	☆	
32	217BJ129	针距标盘组件	FEED DIAL ASM	1	☆	
33	GX211-8	针距旋钮锁销	PIN	1	☆	
34	GW191-8	针距旋钮锁簧	SPRING	1	☆	

6、油盘膝提部件 UNDER COVER COMPONENTS

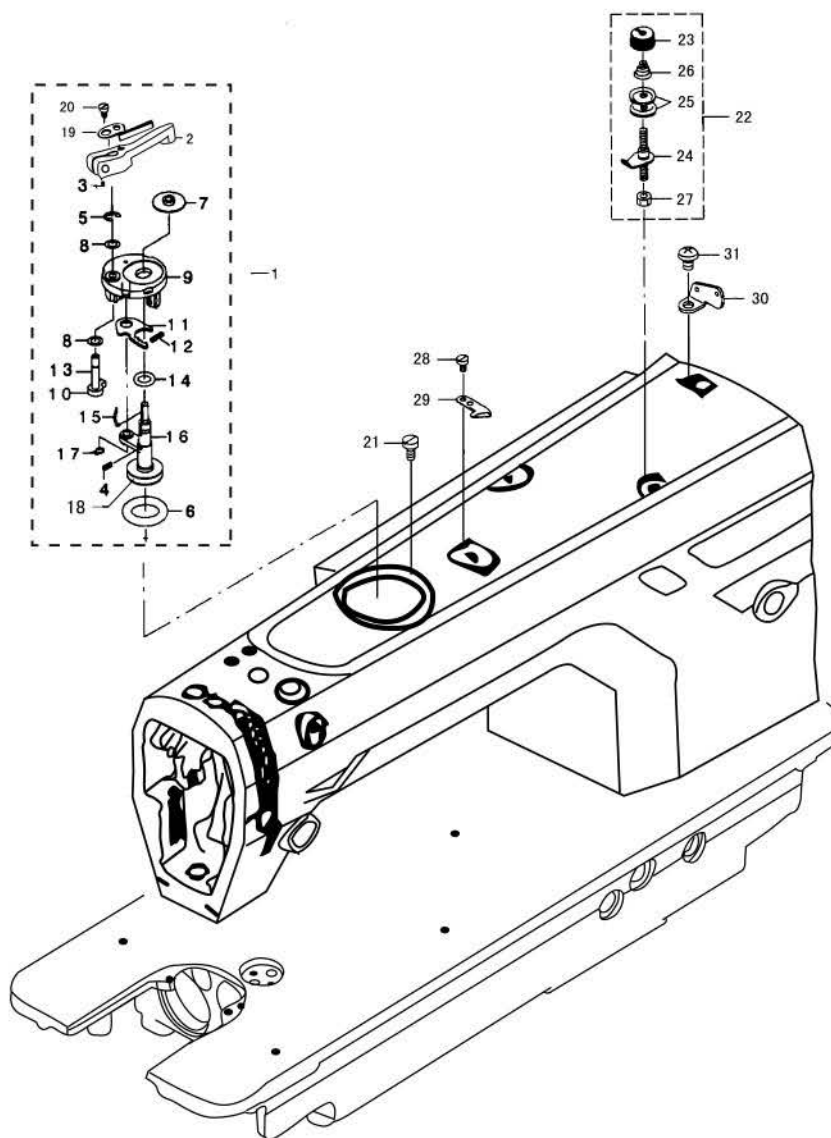


6、油盘膝提部件

序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
1	217GR116	油盘	UNDER COVER	1	☆	
2	GR683-8	机头座垫	HEAD GASK	1	☆	
3	GR689-8	操纵杆接头	BRACKET	1	☆	
4	GS358-8	接头螺栓	SCREW	2	☆	
5	GR690-8	操纵杆部件	KNEE PAD PLATE	1	☆	
6	217GZ108	抬压脚轴	KNEE PRESS ROD	1	☆	
7	GR688-8	挡圈	E-RING	1	☆	
8	217GW103	复位弹簧	SPRING	1	☆	
9	GS356-8	双向曲柄定位螺钉	SCREW	1	☆	
10	GS357-8	双向曲柄限位调节螺柱	SCREW	2	☆	
11	GL170-8	双向曲柄限位调节螺母	NUT M6	2	☆	
12	217GH130	膝控限位架	BRACKET	1	☆	

7、绕线部件

BOBBIN WINDER COMPONENTS

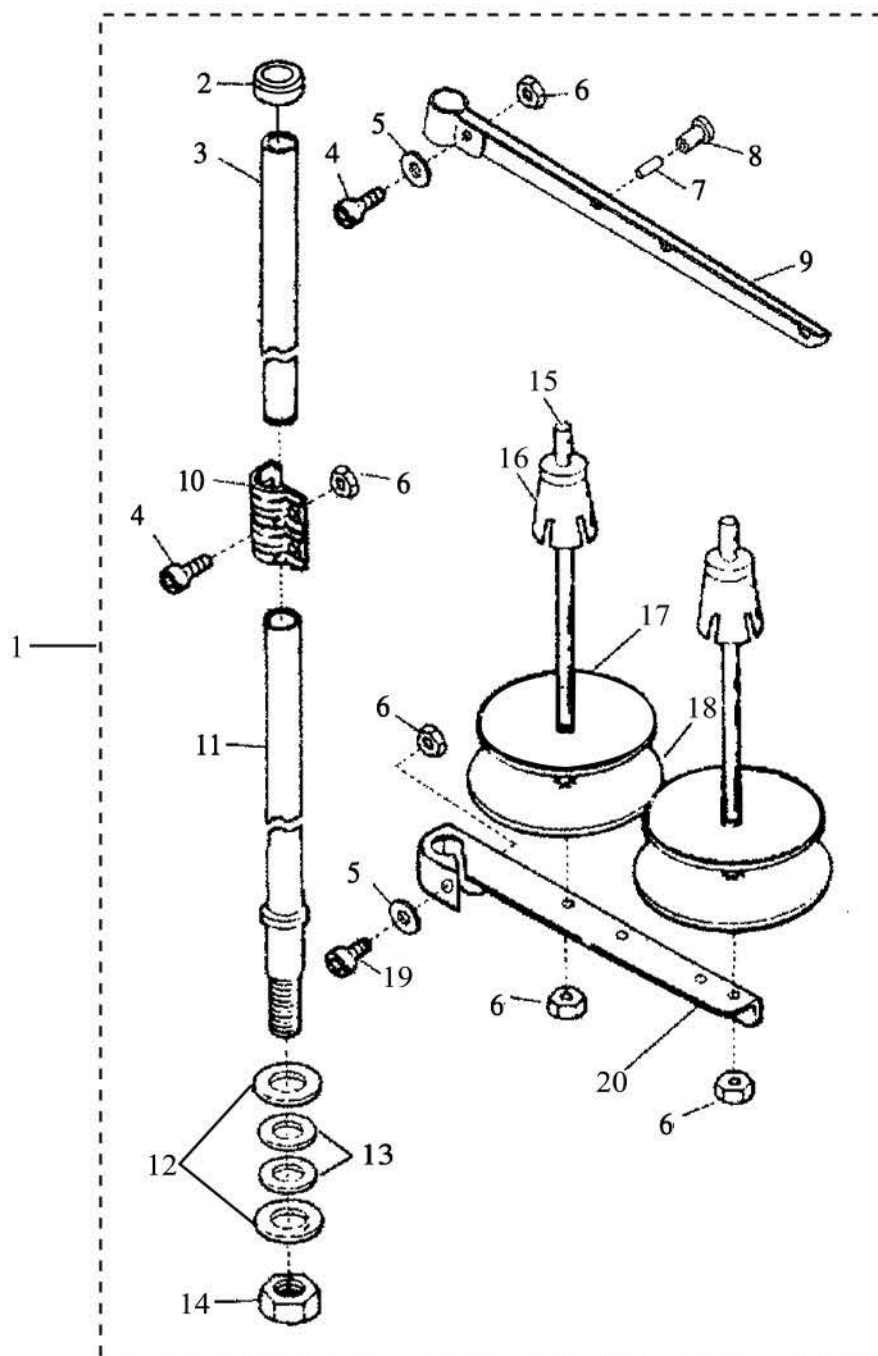


7、绕线器部件

序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
1	280BJ103	绕线器	BOBBIN DEVICE ASM.	1	☆	
2	280GB103	卷绕手柄	BOBBIN LEVER	1	☆	
3	501GS109	螺钉	SCREW	1	☆	
4	101GW102	复位短弹簧	PRESSUR FOOT SPRING	1	☆	
5	501GK105	绕线器绕线凸轮轴挡圈	E-RING	1	☆	
6	101GF115	橡胶轮	RING	1	☆	
7	501GK102	卷绕轴垫	CUSHION	1	☆	
8	501GK104	薄垫片	WASHER	1	☆	
9	501BJ102	梭心卷绕体组件	BOBBIN FITTING BASIS COMPL.	1	☆	
10	GR2058-8	绕线定位块	BOBBIN CAM SHAFT COMPL.	1	☆	
11	501GB112	控制板	ADJUSTING PLATE	1	☆	
12	501GW101	复位长弹簧	SPRING	1	☆	
13	GR2059-8	绕线凸轮轴	BOBBIN CAM SHAFT COMPL.	1	☆	
14	501GF110	卷线轴O形圈	RUBBER RING	1	☆	
15	501GW103	锁芯弹簧	LATCH SPRING	1	☆	
16	280GZ102	梭芯卷绕轴	BOBBIN WINDER SHAFT COMPL.	1	☆	
17	501GK105	绕线器摆动板轴挡圈	RETAINING RING	1	☆	
18	OO4535	绕线轮螺钉	SCREW	1	☆	
19	280GB102	线量调节板	PLATE	1	☆	
20	280GS101	线量调节板螺钉	SCREW	1	☆	
21	101GS120	绕线器螺钉	SCREW	3	☆	
22	501BJ103	绕线夹线器	BOBBIN THREAD TENSION ASM.	1	☆	
23	GL236-8	塑料夹线螺母	THREAD TENSION NUT	1	☆	
24	501GW104	夹线簧	THREAD TENSION SPRING	1	☆	
25	501GB101	夹线板	BOBBIN WINDER TENSION DISC	2	☆	
26	501BJ104	中过线板组件	BOBBIN THREAD TENSION ROD ASM.	1	☆	
27	501GL104	夹线螺母	NUT	1	☆	
28	101GS119	切刀螺钉	SCREW	2	☆	
29	501GB107	绕线切刀	THREAD CUTTER	1	☆	
30	501GB103	上过线板	THREAD GUIDE PLATE	1	☆	
31	501GS101	上过线板螺钉	SCREW	1	☆	

8、过线架部件

THREAD STAND COMPONENTS

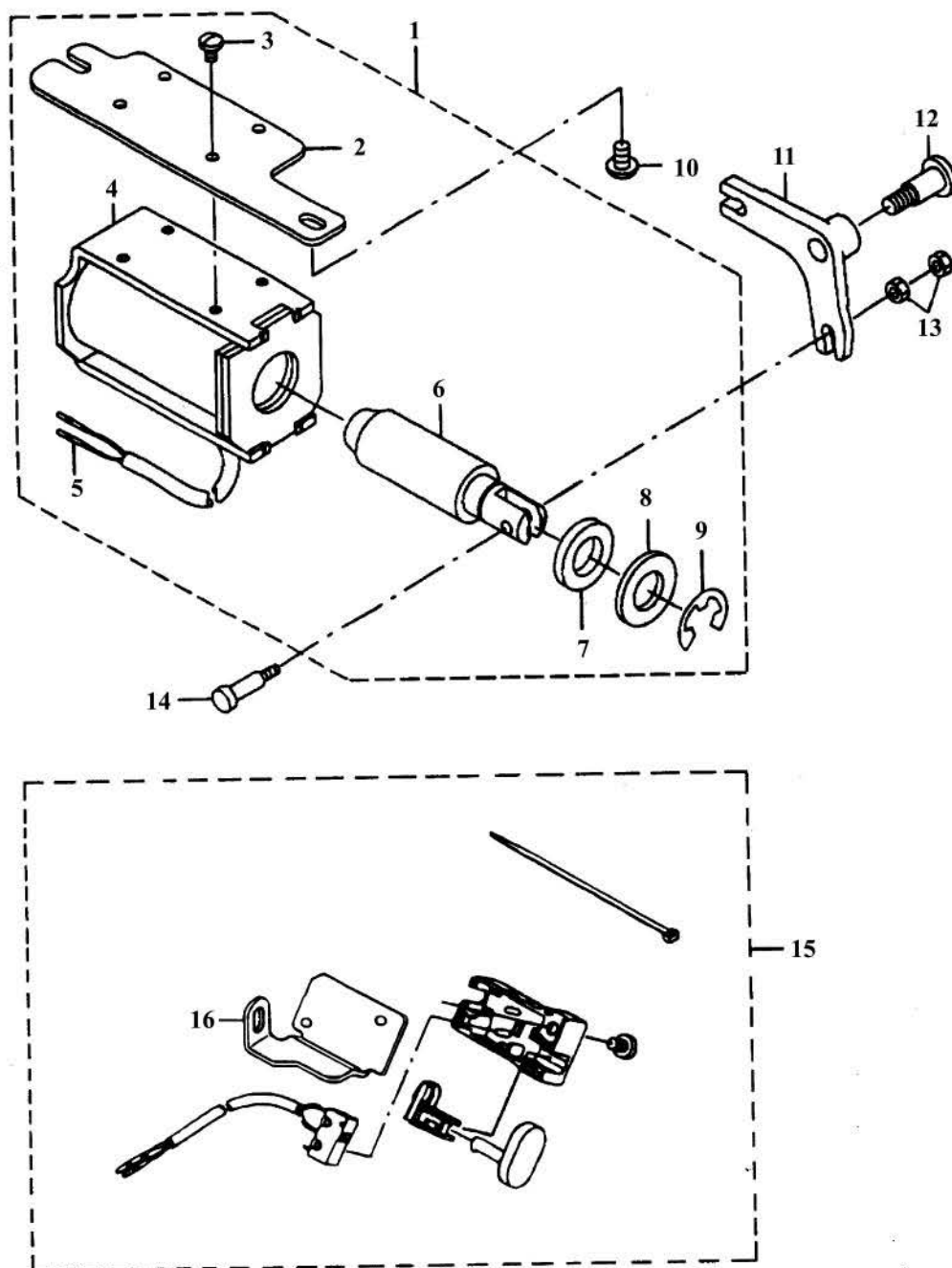


8、过线架部件

序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
1	XJ2.00	二线架组件	THREAD STAND ASM.		☆	
2	XJ2.02-02	撑管套	COLUMN CAP	1	☆	
3	XJ2.02-01	线架上撑管	COLUMN PIPE (UPPER)	1	☆	
4	GB/T973-76M5X14	上过线架螺钉	SCREW	2	☆	
5	GB97.1-85-5	上过线架垫圈	WASHER	2	☆	
6	GB6170-86 M5	上过线架螺母	NUT	5	☆	
7	XJ2.01-02	过线管	THREAD GUIDE PIPE	1	☆	
8	XJ2.01-03	过线管套	THREAD GUIDE BUSHING	1	☆	
9	XJ2.01-01	上过线架	THREAD HANGER (2 SPOOLS TUPE)	1	☆	
10	XJ2.03-01	撑管夹	COLUMN PIPE CONNECTOR	1	☆	
11	XJ2.05-03	线架下撑管	COLUMN PIPE (LOWER)	1	☆	
12	XJ2.05-01	线架下撑管垫圈1	WASHER	2	☆	
13	XJ2.05-04	垫圈	WASHER	2	☆	
14	GB6170-86 M5	下过线架螺母	NUT	1	☆	
15	XJ2.06-04	线轴	SPOOL PIN	2	☆	
16	XJ2.06-03	线盘塑料压块	SPOOL CUSHION	2	☆	
17	XJ2.06-02	线盘软垫	SOFT CUSHION OF THREAD PLARE	2	☆	
18	XJ2.06-01	线盘	THREAD PLATE	2	☆	
19	GB/T973-76M5X30	下过线架螺钉	SCREW	1	☆	
20	XJ2.04-01	下过线架	THREAD HANGER (LOWER)	1	☆	

9、自动倒缝部件

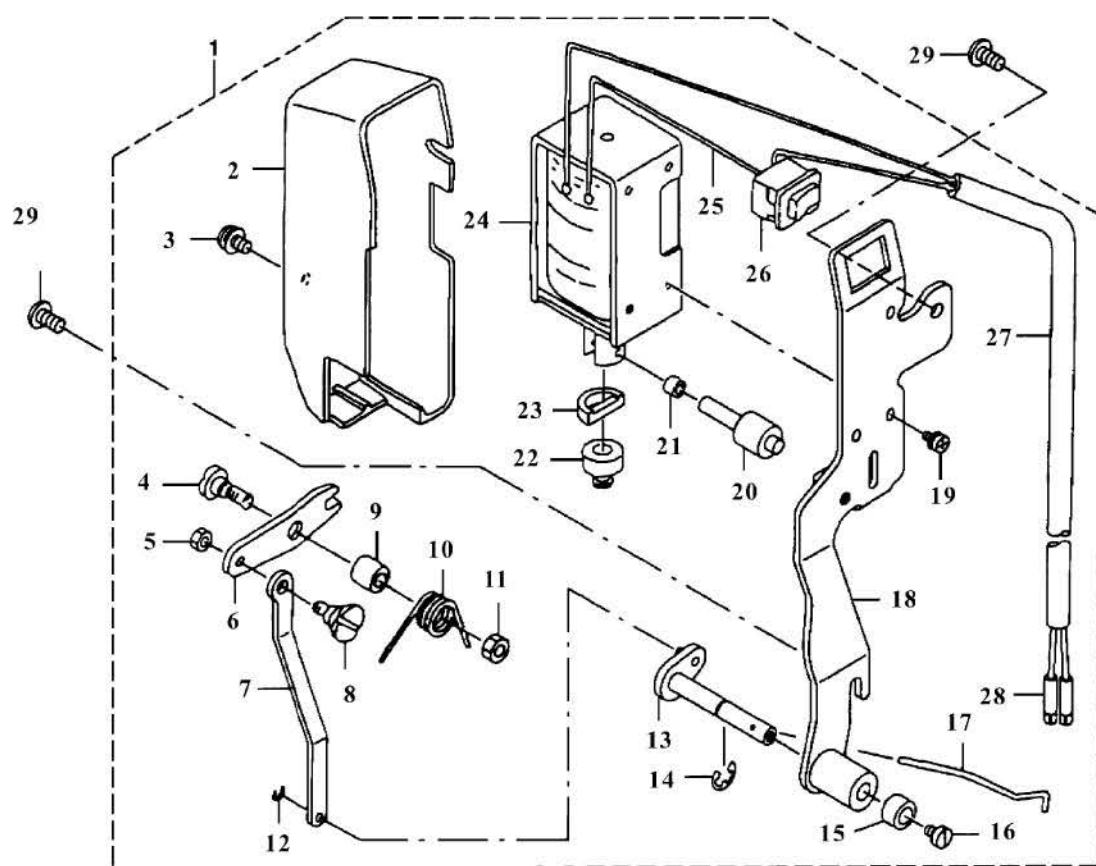
AUTOMATIC REVERSE FEED COMPONENTS



9、自动倒缝部件

序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
1	217GD111	自动倒缝电磁铁组件	REVERSE FEED SOLENOID BASE ASM	1	☆	
2	217GD112	倒缝电磁铁支架	REVERSE FEED SOLENOID BASE ASM	1	☆	
3	217GS180	倒缝电磁铁固定螺钉	SCREW 11/64-40 L=7	4	☆	
4	217GD113	倒缝电磁铁	REVERSE FEED SOLENOID BASE ASM	1	☆	
5	217GD150	倒缝电磁铁接头	PIN CONTACT	2	☆	
6	217GD151	倒缝电磁铁铁芯	REVERSE FEED SOLENOID PLUNGER	1	☆	
7	217GK150	倒缝电磁铁橡胶垫	RUBBER PLUNGER	1	☆	
8	217GK151	倒缝电磁铁垫圈	WASHER 17x30x3	1	☆	
9	217GK152	倒缝电磁铁开口挡圈	E-RING 12	1	☆	
10	217GS101	倒缝电磁铁螺钉	SCREW 15/64-28 L=9	2	☆	
11	217GH131	倒缝摆臂	REVERSE FEED ARM	1	☆	
12	217GS119	倒缝摆臂螺钉	HINGE SCREW D=9.53 H=15	2	☆	
13	217GL150	倒缝电磁铁连接销螺母	NUT 11/64-40	1	☆	
14	217GX152	倒缝电磁铁连接销	PLUNGER ARM PIN	1	☆	
15	280BJ104	点动送料开关组件	OPTION SWITCH ASM	1	☆	
16	280GK101	点动送料开关座	REVERSE FEED SWITCH BASE	1	☆	

10、拔线部件 WIPER COMPONENTS

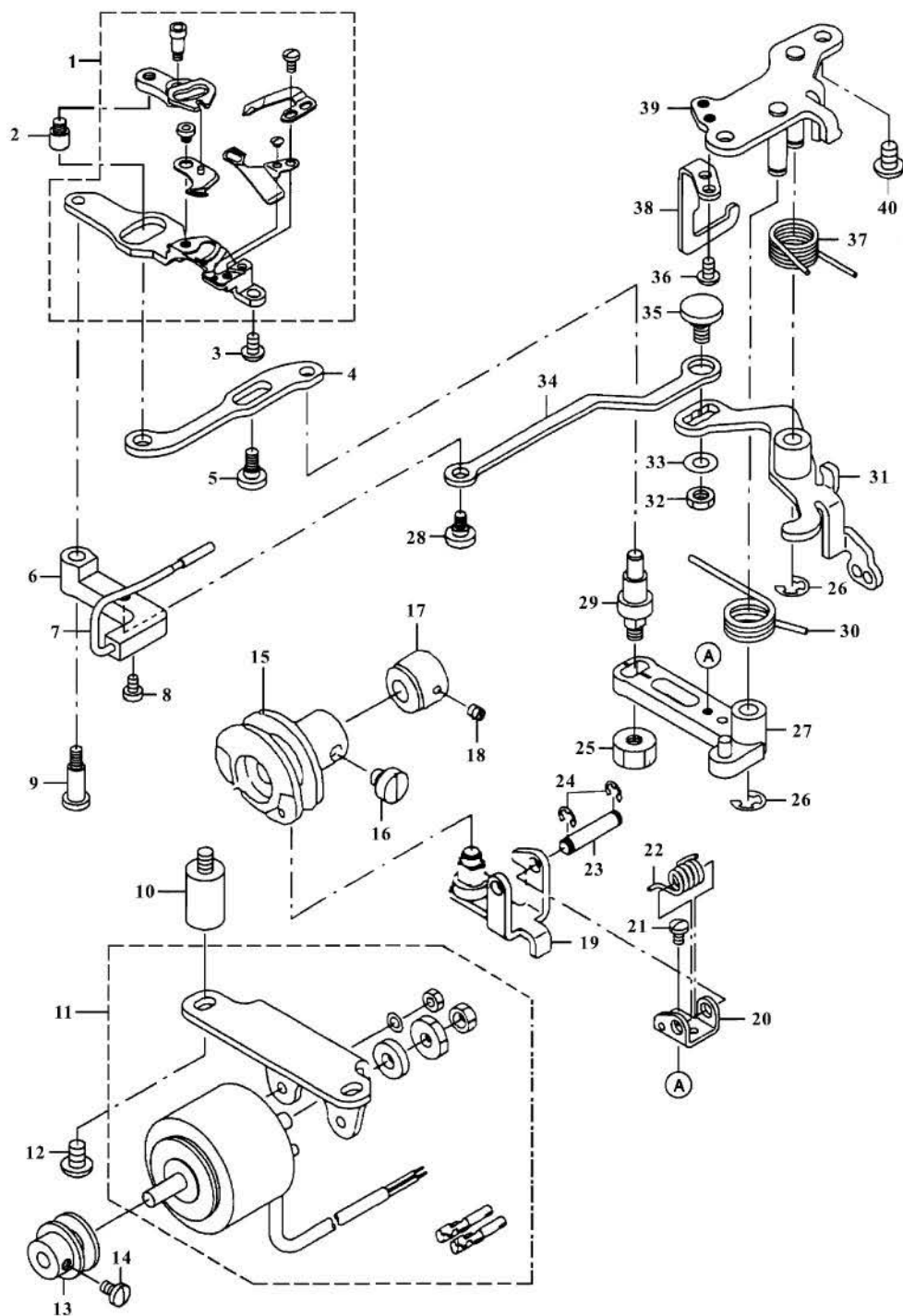


10、拔线部件

序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
1	217GD124	拔线分组件	WIPER ASM.	1	☆	
2	GR1070-8	拔线器罩	WIPER COVER	1	☆	
3	GB818-85 M3X6	拔线器罩螺钉	SCREW M3	1	☆	
4	GS532-8	传动板轴位螺钉	HINGE SCREW D=6.5 H=3.0	1	☆	
5	GL186-8	拉杆轴位螺钉螺母	NUT 9/64-40	1	☆	
6	GR1081-8	拔线传动板	WIPER LINK A	1	☆	
7	217GD125	拔线拉杆	WIPER LINK B	1	☆	
8	GS531-8	拉杆轴位螺钉	WIPER LINK B, HINGE SCREW	1	☆	
9	GO375-8	轴位螺钉定位套	WIPER HINGE SCREW COLLAR	1	☆	
10	GW240-8	传动板复位簧	WIPER SPRING	1	☆	
11	GL185-8	传动板轴位螺钉螺母	NUT 11/64-40	1	☆	
12	GR1072-8	拔线拉杆轴挡圈	E-RING 2.5	1	☆	
13	217GD131	拔线驱动轴部件	WIPER SHAFT ASM.	1	☆	
14	GR625-8	拔线驱动轴挡圈	E-RING	1	☆	
15	GO374-8	螺钉套圈	BRACET INSTALLING COLLAR	1	☆	
16	GS530-8	拔线杆紧固螺钉	SCREW 9/64-40 L=5.0	1	☆	
17	GR1071-8	拔线杆	WIPER	1	☆	
18	217GD129	拔线电磁铁支架组件	WIPER BASE ASM.	1	☆	
19	217GK108	安装螺钉垫圈	SCREW	3	☆	
20	GX258-8	铁芯传动销	WIPER SOLENOID PIN	1	☆	
21	GO376-8	传动销滚柱	WIPER LINK COLLAR	1	☆	
22	GR1073-8	铁芯复位簧	WIPER RUBBER A	1	☆	
23	GR1074-8	铁芯橡皮垫	WIPER RUBBER B	1	☆	
24	217GD128	拔线器电磁铁	WIPER SOLENOID	1	☆	
25	217GD150	拔线器电线	ELECTRIC WIRE	2	☆	
26	217GD126	拔线开关	POWER SWITCH	1	☆	
27	217GD151	电线套	2-CORD CABTYRE CORD	1	☆	
28	217GD152	电线接头	PIN CONTACT	2	☆	
29	GS300-8	拔线分组件固定螺钉	SCREW 3/16-28 L=9	2	☆	

11.1 自动剪线部件 (平刀)

THREAD TRIMMER COMPONENTS (Parallel knife)

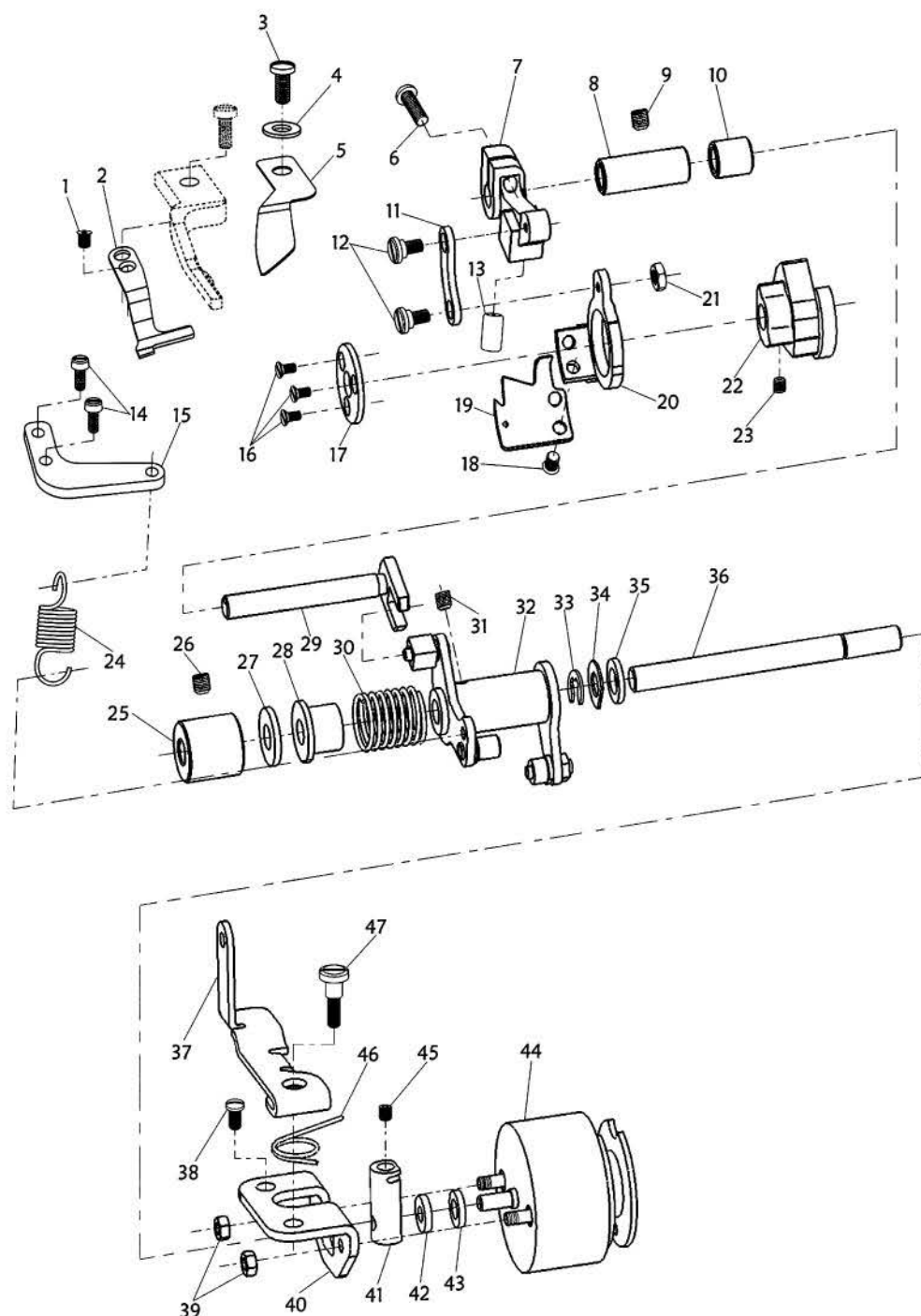


11.1 自动剪线部件（平刀）

序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
1	217GD109	剪线刀座部件	KNIFE UNIT	1	☆	☆
	282.8.1	剪线刀座部件	KNIFE UNIT	1		
2	217GX113	刀体销	PIN	1	☆	
3	GS340-8	剪线刀螺钉	SCREW 11/64-40 L=7	1	☆	
4	217GH132	动刀连杆	HOVING KNIFE LINK	1	☆	
5	217GS123	动刀连杆轴位螺钉	HINGE SCREW D=6 H=3.2	1	☆	
6	217GD136	挡线体组件	PICKER ARM	1	☆	
7	217GD138	挡线器支杆组件	THREAD TAKE-UP PICKER ASM	1	☆	
8	GS333-8	螺钉	SCREW	1	☆	
9	GX254-8	挡线连杆销	HINGE SCREW D=6.35 H=3	1	☆	
10	217GS120	支承钉	BEIT COVER SUPPORT B	2	☆	
11	217GD121	自动剪线电磁铁部件	SOLENOID ASM.	1	☆	
12	217GS101	剪线电磁固定螺钉	SCREW 15/64-28 L=9	2	☆	
13	217GP102	剪线驱动轮	DRIVING BLOOK	1	☆	
14	217GS124	挡圈螺钉	SCREW 11/64 L=7	1	☆	
15	GT165-8	剪线凸轮	THREAD TRIMMER CAM ASM	1	☆	
16	GS305-8	剪线凸轮螺钉	SCREW 1/4-40 L=6	2	☆	
17	GO360-8	剪线凸轮挡圈	CAM COLLAR ASM.	1	☆	
18	GS330-8	剪线凸轮挡圈螺钉	SCREW 11/64-40 L=4.5	2	☆	
19	217GB160	剪线凸轮滚柱部件	PICKER LINK	1	☆	
20	GR1058-8	托板支撑架	ROLLER ARM BRACKET	1	☆	
21	GS33	托板支承架螺钉	SCREW 9/64-40 L=6	1	☆	
22	GW239-8	托板复位簧	ROLLER RETURN SPRING	1	☆	
23	GX256-8	托板支架销	ROLLER FULCRUM SHAFT	1	☆	
24	GR1028-8	卡圈	E-RING 4	2	☆	
25	217GL106	动刀连杆螺母	NUT 15/64-28	1	☆	
26	GR1053-8	离合架挡圈	E-RING 6	2	☆	
27	217GH134	剪线驱动曲柄	KNIEE DRIVING ARM ASM	1	☆	
28	GS522-8	挡线器连接螺钉	HINGE SCREW D=6.35 H=2.7	1	☆	
29	217GX114	动刀连接销	MOVING KNIFE LINK PIN	1	☆	
30	GW237-8	剪线驱动曲柄复位簧	DNIFE RETURN DPRING,B	1	☆	
31	217GD118	离合架组件	CLUTCH PLATE ASM.	1	☆	
32	GL182-8	挡线器栏杆连接销螺母	NUT 15/64-28	1	☆	
33	GO366-8	垫圈	WASHER	1	☆	
34	217GH133	挡线器拉杆	PICKER LINK	1	☆	
35	GX254-8	挡线器拉杆连接螺钉	PICKER LINK PIN	1	☆	
36	GS336-8	剪线定位保护板螺钉	SCREW 11/64-40 L=7	2	☆	
37	217GW104	剪线离合架复位簧	CLUTCH SPRING	1	☆	
38	217GR117	剪线定位保护板	DRIVING ARM STOPPER	1	☆	
39	217GD115	剪线驱动座组件	BASE PLATE ASM.	1	☆	
40	217GS101	剪线、挡线部件固定螺钉	SCREW 15/64-28 L=9	2	☆	

11.2 自动剪线部件 (旋刀)

THREAD TRIMMER COMPONENTS (Rotation knife)



11.2 自动剪线部件 (旋刀)

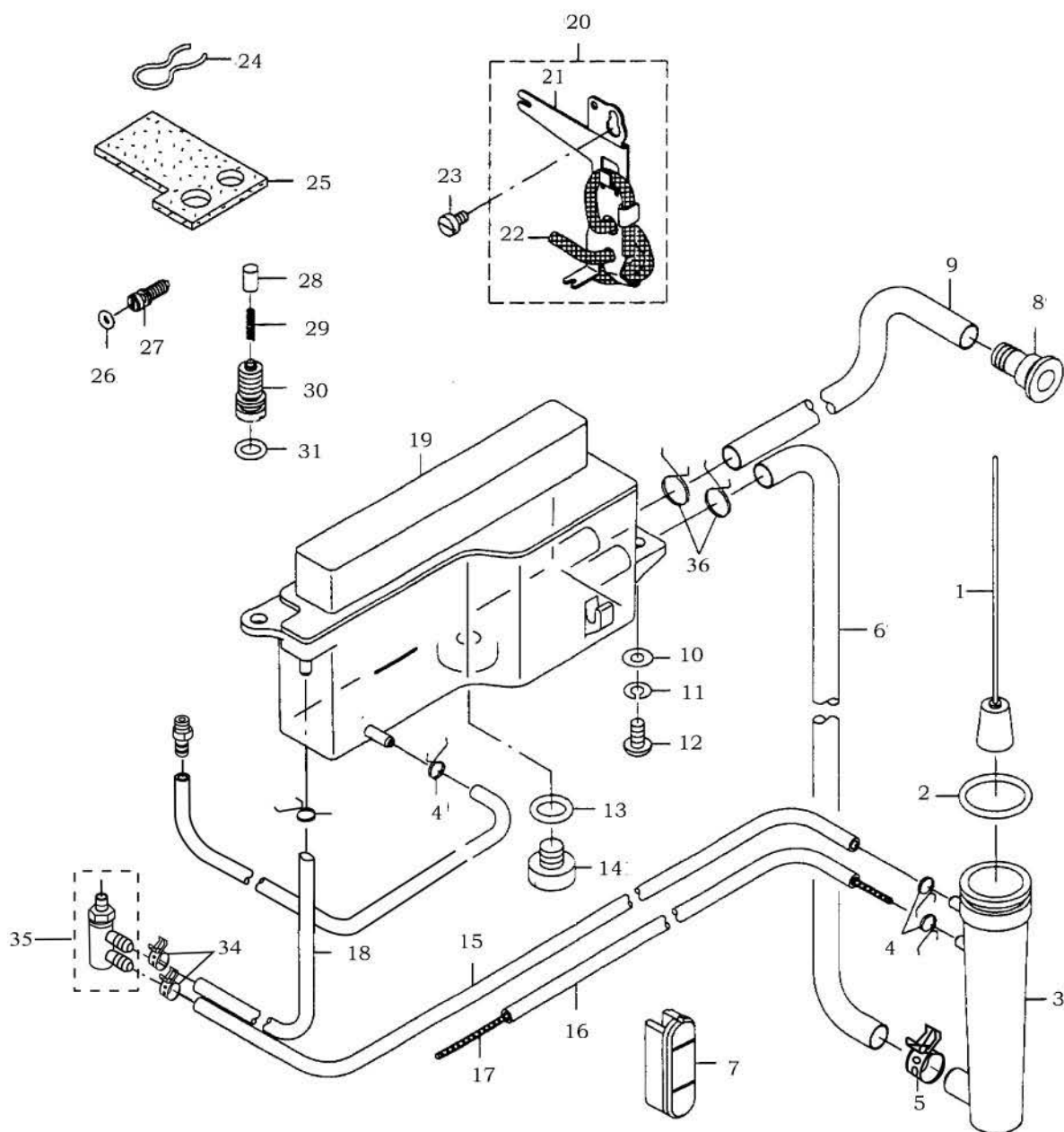
序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
1	220.5-4	定刀固定螺钉	SCREW	1	☆	
2	220.5-3	定刀	CONNTER KNIFE	1	☆	
3	GC999.2-5	分线器固定螺钉	SCREW	1	☆	
4	220.5-26	分线器固定螺钉垫圈	WASHER	1	☆	
5	220.5-5	分线器	DISPART THREAD SHUTTLE	1	☆	
6	205.1.5-3	切线驱动曲柄螺钉	SCREW	1	☆	
7	281.8-8	切线驱动曲柄	TRIMMING CRANK	1	☆	
8	281.8-5	切线驱动曲柄轴轴套	BUSHING	1	☆	
9	B.2-5	切线驱动曲柄轴轴套螺钉	SCREW	1	☆	
10	281.8-6	切线驱动曲柄轴短套	SHORT BUSHING	1	☆	
11	281.8-2	刀轴连杆	KNIFE SHAFT CRACK ROD	1	☆	
12	220.5-10	刀轴连杆螺钉	SCREW	2	☆	
13	281.8-9	切线驱动曲柄止动块	BLOCK	1	☆	
14	B.1-27	切线凸轮曲柄拉簧固定板螺钉	SCREW	2	☆	
15	281.8-12	切线凸轮曲柄拉簧固定板	FIXED PLANK	1	☆	
16	B.5-55	刀架压板螺钉	SCREW	3	☆	
17	281.8-3	刀架压板	KNIFE HOLDER	1	☆	
18	220.5-8	动刀固定螺钉	SCREW	2	☆	
19	220.5-7	动刀	ROUND KNIFE	1	☆	
20	281.8-1	动刀架	ROUND KNIFE BRACKET	1	☆	
21	220.5.2-4	刀轴连杆螺母	NUT	1	☆	
22	220.5-1	剪线凸轮	THREAD TRIMMER CAM	1	☆	
23	201.2.8-3	剪线凸轮螺钉	SCREW	2	☆	
24	281.8-11	切线凸轮曲柄拉簧	SPRING	1	☆	
25	281.8-4	切线驱动轴轴套	BUSHIG	1	☆	
26	B.2-5	切线驱动轴轴套螺钉	SCREW	1	☆	
27	281.8-10	扭簧端盖垫圈	WASHER	1	☆	
28	220.5-19	扭簧端盖	SPRING CVER	1	☆	
29	281.8-7	切线驱动曲柄轴	TRIMMING CRANK SHAFT	1	☆	
30	220.5-20	剪线电磁铁复位弹簧	SPRING	1	☆	
31	220.5-17	切线凸轮曲柄紧定螺钉	SCREW	1	☆	
32	281.8.1	切线凸轮曲柄组件	TRIMMING CAM CRANK ASM.	1	☆	
33	GB/T896-86-5	切线驱动轴卡簧	WASHER	1	☆	
34	281.8-13	切线驱动轴垫圈	WASHER	1	☆	
35	220.5-21	切线磁铁垫圈	WASHER	1	☆	
36	220.5-18	切线驱动轴	TRIMMING SHAFT	1	☆	
37	281.8-14	松线座	LOOSING PLATE	1	☆	
38	220.5-22	剪线电磁铁安装座固定螺钉	SCREW	1	☆	
39	GB6170-86 M4	螺母	NUT	2	☆	
40	281.8.2-1	剪线电磁铁安装座	SOLENOID BASE	1	☆	
41	281.8.2-2	剪线电磁铁连接体	SOLENOID CONNECTING SHAFT	1	☆	
42	220.5.3-3	电磁铁垫圈	SCREW	1	☆	
43	220.5.3-2	减震垫圈	SCREW	1	☆	
44	220.5.3.1	剪线电磁铁	THREAD TRIMMER SOLENOID	1	☆	

11.2 自动剪线部件 (旋刀)

序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
45	201.5.9-2	固定螺钉	SCREW	1	☆	
46	220.5-37	松线复位弹簧	SPRING	1	☆	
47	220.5-23	松线座螺钉	SCREW	1	☆	

12、润滑部件

OIL LUBRICATION COMPONENTS

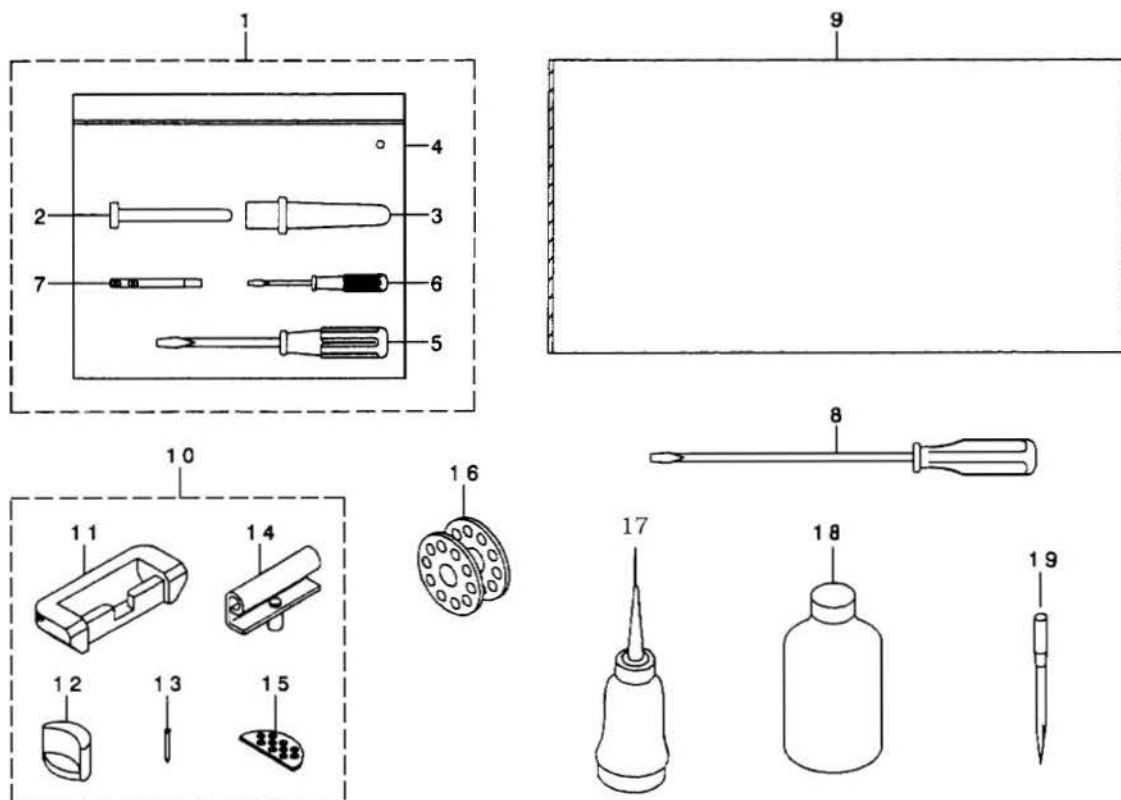


12、润滑部件

序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
1	101BJ139	油标	FLOATER ASM.	1	☆	
2	101GF127	油杯O形圈	RUBBER RING	1	☆	
3	101GB189	油杯	FLOATER CASE	1	☆	
4	101GW118	小油管紧固簧	PIPE STOPPER A	4	☆	
5	280. 12-1	大油管紧固簧	PIPE STOPPER B	3	☆	
6	227GB108	油杯大油管	VINYL TUBE, WHITE	1	☆	
7	101GR108	油标窗	OIL SIGHT WINDOW	1	☆	
8	101GB180	加油杯	OIL INLE	1	☆	
9	227GB107	总进油管	VINYL TUBE, WHITE	1	☆	
10	227GB118	垫片	WASHER	1	☆	
11	227GB119	弹簧垫片	SPRING WASHER	2	☆	
12	GS300-8	油盒固定螺钉	SCREW	2	☆	
13	101GF128	油合O形圈	RUBBER RING	2	☆	
14	101GS175	油合短螺钉	SCREW	1	☆	
15	227GB114	回油管	TUBE	1	☆	
16	227GB110	机头润滑油管	TUBE	1	☆	
17	227GB113	面部供油线	OIL WICK	1	☆	
18	227GB114	回油管	TUBE	1	☆	
19	227GB101	油盒	OIL TANK ASM	1	☆	
20	227GB104	面部油线板组件	OIL WICK SUPPORT ASM	1	☆	
21	227GB105	面部油线板	OIL WICK SUPPORT	1	☆	
22	227GB106	面部油线	OIL WICK	1	☆	
23	227GB107	面部油线板螺钉	SCREW	1	☆	
24	GR678-8	回油毡夹	OIL FELT PRESSER	1	☆	
25	GR676-8	回油除尘毡	OIL RETURN FELT	1	☆	
26	227GB117	油量调节螺钉O型圈	RUBBER RING	1	☆	
27	227GB116	油量调节螺钉	OIL ADJUSTING SCREW	1	☆	
28	101GX116	柱塞	PLUNGER	1	☆	
29	101GW112	柱塞簧	PLUNGER SPRING	1	☆	
30	101GS159	柱塞螺钉	PLUNGER SCREW	1	☆	
31	101GF122	柱塞螺钉O形圈	RUBBER RING	1	☆	
32	101GB178	油管接头	LUBRICATION CONNECTOR	2	☆	
33	227GB107	总进油管	TUBE	1	☆	
34	280. 12-2	小油管紧固簧	PIPE STOPPER A	4	☆	
35	101GB172	油管三接头组件	DISTRIBUTOR	1	☆	
36	101GW119	大油管紧固簧	PIPE STOPPER B	3	☆	

13、附件

ACCESSORIE PART COMPONENTS



13、附件

序号 REF.No.	件 号 Part No.	名 称	Name of the part	数量 Qty.	薄料 中厚料	厚 料
1	217GB190	附件	ACCESSORIE BAG ASM	1	☆	
2	217GH128	抬压脚顶杆	KNEE LIFTER PRESSER ROD	1	☆	
3	GR1123-8	机头支柱	FRAME SUPPORT BAR	1	☆	
4	GF216-8	塑料袋Ⅲ	ACCESSORIE BAG	1	☆	
5	GR701-8	螺丝刀(中)	SCREW DRIVER, MIDDLE	1	☆	
6	GR702-8	螺丝刀(小)	SCREW DRIVER, SMALE	1	☆	
7	GR610/S-8	过线杆组件	NEEDLE THREAD GUIDE ASM	1	☆	
8	GR700-8	螺丝刀(大)	SCREW DRIVER, LARGE	1	☆	
9	101GR111	机头罩	FRAMEVINYL COVER	1	☆	
10	GF215-8	塑料袋Ⅱ	RUBBER HINGE ASM	1	☆	
11	GR697-8	机头连接钩座	RUBBER CUSHION	2	☆	
12	GR687-8	油盘支座	OIL RESERVIOIR SEAT	2	☆	
13	GBX141-8	机头连接钩座钉	NAIL	6	☆	
14	GR696/2-8	机头连接钩部件	HINGE COMPL	2	☆	
15	GR686-8	油盘座垫	OIL RESERVIOIR CUSHION	2	☆	
16	GN139-8	梭心	BOBBIN	3	☆	
17	201-2630	小油壶	OILER ASM	1	☆	
18	GR703/3-8	油箱	OIL BOTTLE WITH OIL	1	☆	
19	GV132-8	机针	NEEDLE	1	☆	



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