

FY872

双针平缝系列

OPERATION MANUAL
PARTS BOOK

使用说明书、零件图册

LM - ORIGINAL

FY872

双针平缝机

OPERATION MANUAL
PARTS BOOK

使用说明书、零件图册

ORIGINAL - [M]

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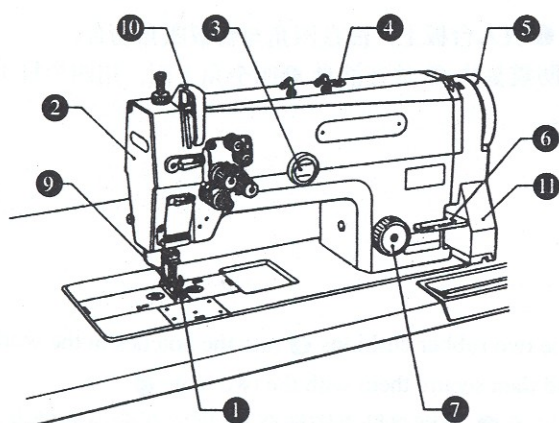
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1.Names of major parts

1.主要部件的名称

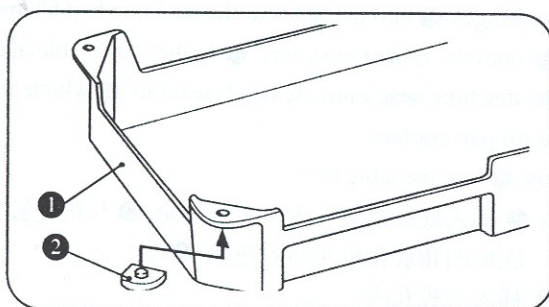


- | | |
|----------------------|-------------------------|
| 1 Needle plate | 2 Face plate |
| 3 Oil gauge window | 4 Oil inlet |
| 5 Machine pulley | 6 Reverse Stching lever |
| 7 Stitch length dial | 8 Bobbin winder |
| 9 Finger guard | 10 Thread take-up cover |
| 11 Belt cover | |
| 1 针杆 | 2 面板 |
| 3 油窗 | 4 注油口 |
| 5 主动轮 | 6 标盘 |
| 7 标盘 | 8 绕线轴 |
| 9 护指器 | 10 挑线杆防护罩 |
| 11 皮带罩 | |

		-1	-3	-5
用途 Applica Aim		薄料 Thin materials	中厚料 Medium-thick materials	厚料 Thick materials
缝制速度 Sewing speed		4000spm		3000spm
最大针距 Max.stitch length		4mm		5mm
压脚 提升 高度 Presser foot heifht	手动 Presser foot lifter	7mm		
	膝控 Knee lifter	13mm		
送布牙高度 Teed day height		1mm		
机针 Needle		DPx5 #9-#14	DPx5 #11-#16	DPx5 #14-#22
针送机构 Needle feed machanism		有 Yes		
片针停止机构 Single needle step machism		无 No		

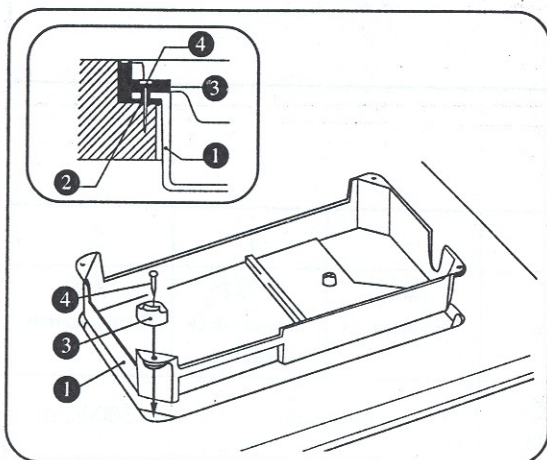
2. Installing the oil pan

2. 油盘安装



1.Insert the four oil pan cushions② into the oil pan① from below so that the four corner holes are aligned.

1.将四块机头防震钉垫②插入油盘①四角孔内。

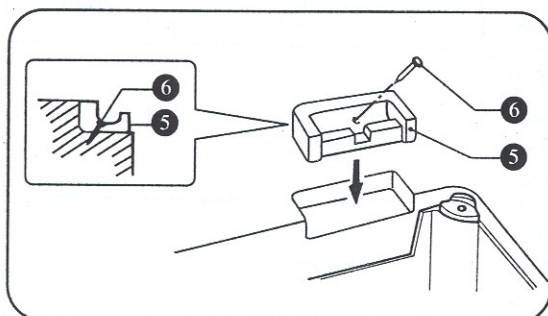


2. Place the oil pan ① into the groove in the work table so that corners are aligned.

3. Place the four head cushions ③ on top of the corners in the oil pan ①, and then secure them with the four nails ④.

2. 将油盘 ① 放入台板上，油盘四角与台板四角吻合。

3. 将机壳防震垫块 ③ 放在油盘 ① 四个角上面，用四个钉子 ④ 固定。

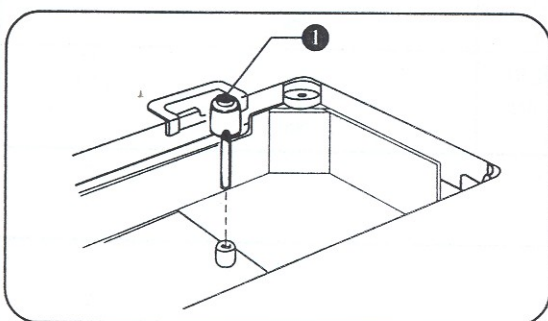


4. Insert the two rubber cushions ⑤ into the notches in the work table, and then secure them with the two nails ⑥.

4. 用两个钉子 ⑥ 分别将机壳铰链套 ⑤ 固定在台板凹槽内。

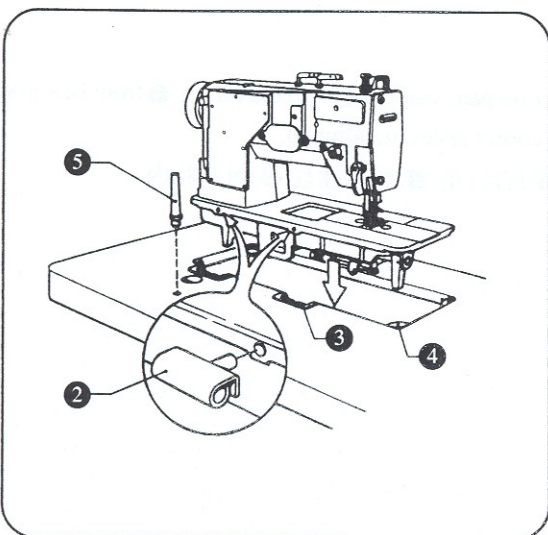
3. Installing the machine head

3. 缝纫机头部安装



1. Insert the knee lifter complying bar ①.

1. 放入膝控顶杆 ①。



2. Insert the two hinges ② into the holes in the machine bed. Clamp the hinges ② onto the rubber cushions ③ in the work table, and then place the machine head onto the head cushions ④ which are on top of the oil pan corners.

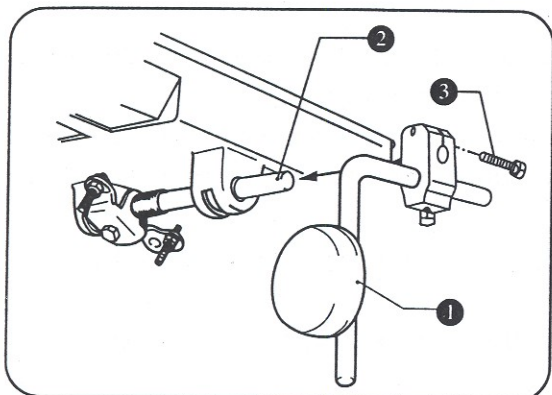
3. Tap the pillow ⑤ into the table hole.

2. 将机壳铰链 ② 插入底板安装孔内，机壳铰链 ② 与机壳铰链套 ③ 吻合，底板四角放在机头防震垫块 ④ 上。

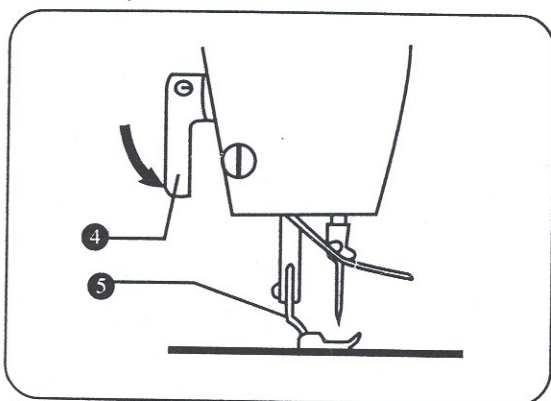
3. 机头撑杆 ⑤ 插入台板孔内。

4. Installing the knee lifter assembly

4. 油盘安装



1. Place the knee lifter assembly ① onto the knee lifter bar ② on the oil pan, and then secure it by tightening the bolt ③.
1. 将膝控组件 ① 插入膝控铰链轴 ② 内，拧紧螺钉 ③。

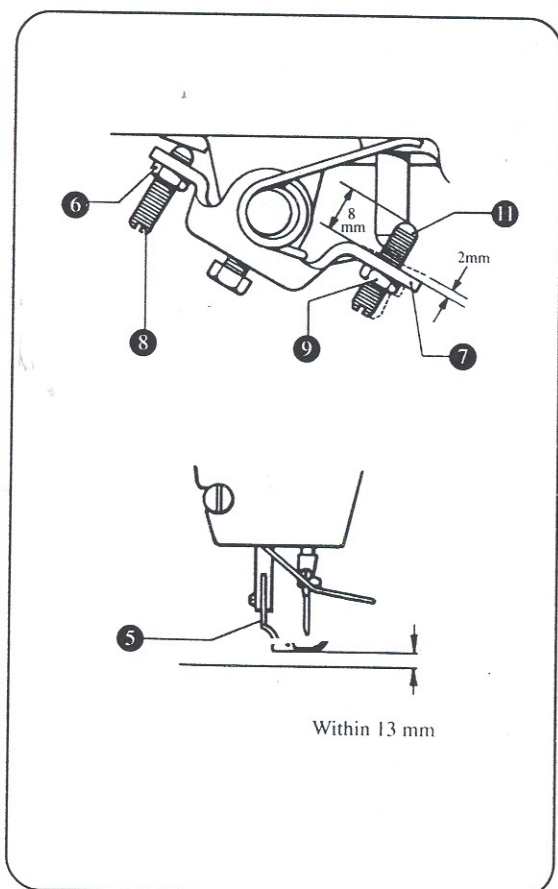


2. Adjust the knee lifter.

- 1) Lower the presser foot ⑤ by using the presser bar lifter ④. Loosen the nut ⑥. Turn the screw to ⑧ adjust so that amount of play in the knee lifter ⑦ is approximately 2 mm when the knee lifter plate ① is gently pressed. Securely tighten the nut ⑥.

2. 调整膝控

- 1) 放下压脚板手 ④，松开螺母 ⑥，拧动螺钉 ⑧ 来调整膝控压力约 2mm，拧紧螺母 ⑥。



- 2) Loosen the nut ⑨, Turn the screw ⑩ until the distance between the end of the screw ⑩ and the knee lifter ⑦ is approximately 8 mm.

- 3) Turn the adjusting screw ⑩ to adjust so that the presser foot ⑤ is at the desired position within a distance of 13 mm of the needle plate when the knee lifter plate ① is fully pressed.

- 4) After adjustment is completed, securely tighten the nut ⑨.

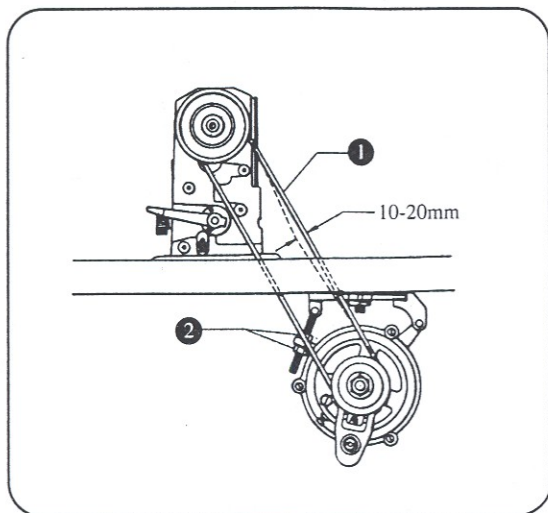
- 2) 松开螺母 ⑨，转动螺钉 ⑩ 直到螺钉头部到膝控限位架平面约 8mm。

- 3) 转动调整螺钉 ⑩ 来调整压脚 ⑤ 到针板平面距离为 13mm 时膝控顶杆压力最大。

- 4) 调整完后，拧紧螺母 ⑨。

5. Installing the belt

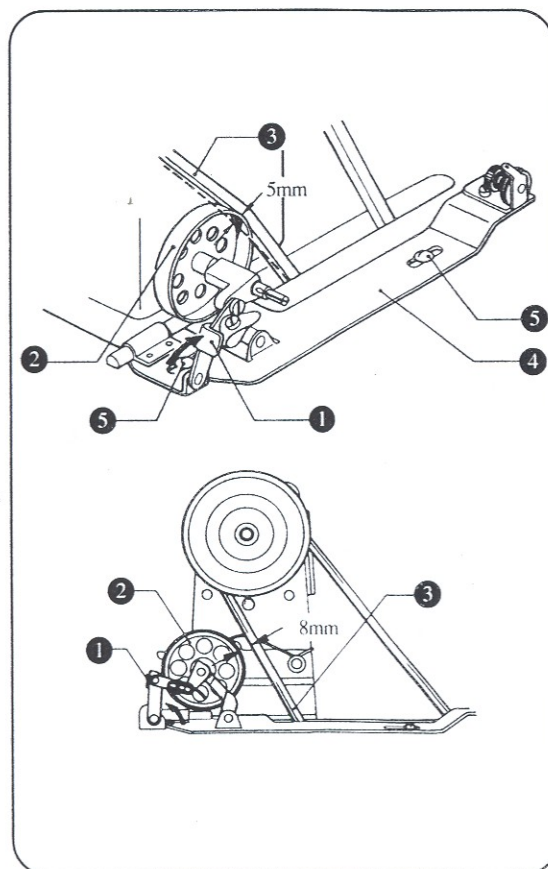
5. 皮带的安装调整



1. Tilt back the machine head, and then place the belt ① onto the motor pulley and the machine pulley.
2. Turn the nut ② to adjust so that there is 10-20 mm of deflection in the belt ① when it is pressed with a finger with a force of 9.8 N (1 kgf).
1. 将缝纫机头部放倒后, 将皮带分别挂在电机皮带轮和缝纫机皮带轮上。
2. 用 9.8N(1kg)力压住皮带 ①, 调整螺母 ②, 使皮带的张力有保持 10-20min 的余量。

6. Installing the bobbin winder

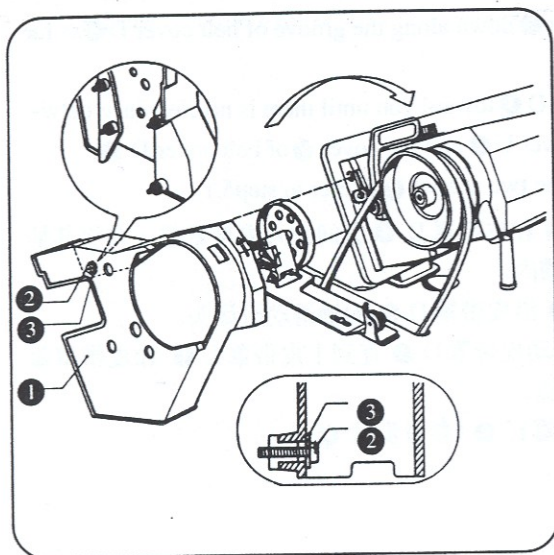
6. 绕线器安装



1. Push down the bobbin presser arm ① as far as it will go.
2. Place the bobbin winder wheel ② so that it pushes the belt ③ by approximately 5 mm, tighten the two screws ⑤.
3. Pull the bobbin presser arm ① back and check that there is approximately 8 mm of clearance between the bobbin winder wheel ② and the belt ③.
1. 将梭芯压板 ① 向下压到底。
2. 将绕线器放在台板上, 移动绕线轮 ② 使皮带张力保持 5mm 左右时, 拧紧两个螺钉 ⑤。
3. 扳回梭芯压板 ① 核对绕线轮 ② 与皮带 ③ 之间距离约 8mm。

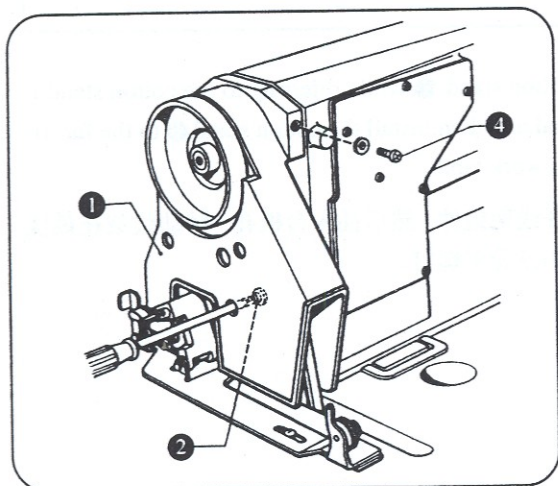
7. Installing the belt cover

7. 皮带罩安装



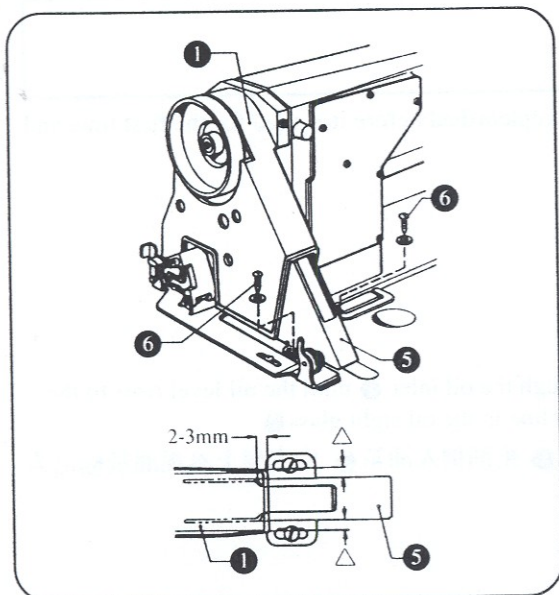
1. Tilt back the machine head.
2. Attach the screw ② and washers ③ to the rubber cushions on the inside of the belt cover U ① (in four places).
3. Place belt cover U ① onto the machine pulley, and then return the machine head to its original position.

1. 倒放机头。
2. 将4个螺钉 ② 和垫片 ③ 固定在机头侧面，不要旋紧。
3. 将皮带罩 U 盖在皮带轮上，摆正机头。



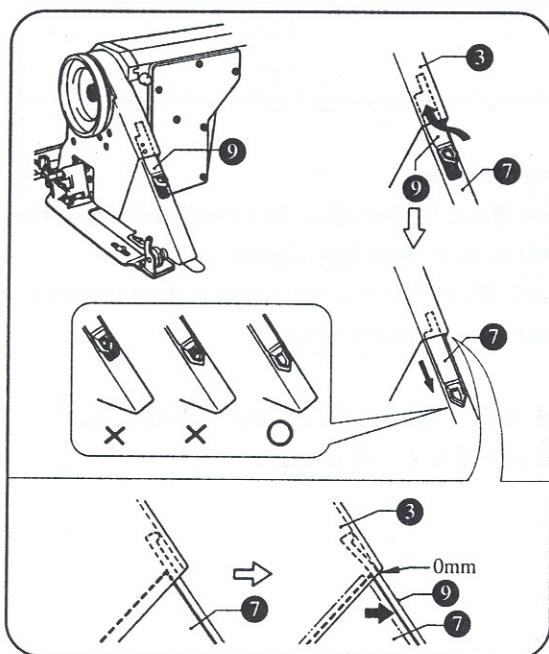
4. Tighten the four screws ② attached in step 2. above and the screw ④ to install belt cover U ①.

1. 拧紧4个螺钉 ②，在机头背面旋上螺钉 ④。



5. Place belt cover D ⑤ so that it overlaps the belt cover U ① by 2-3 mm, and then provisionally tighten the two screws ⑥.

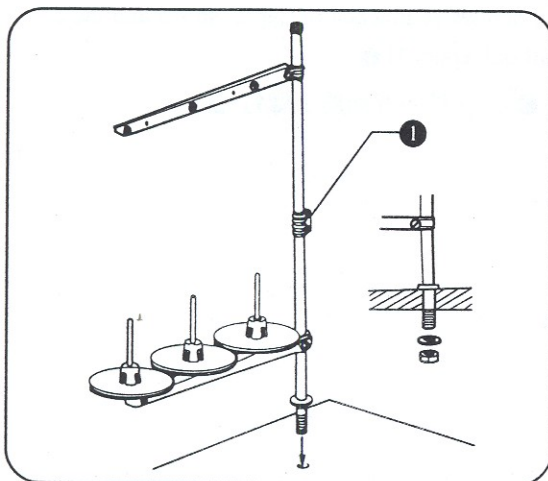
5. 放置皮带罩 D ⑤，使其与皮带罩 U ① 重叠 2-3mm，轻微旋上2个螺钉 ⑥。



6. Insert the cover 7 of belt cover D 5 in between the belt cover U 1 and belt cover D 5, and then place it into the groove of belt cover D 5.
7. Slide the cover 7 down along the groove of belt cover D 5 as far as it will go.
8. Pull belt cover D 5 toward you until there is no clearance between the belt cover U 1 and the cover 7 of belt cover D 5.
9. Fully tighten the two screws 6 (Refer to step 5.)
6. 在皮带罩 U 1 和皮带罩 D 5 之间放入皮带罩盖, 并将其插入皮带罩 5 槽内。
7. 使皮带罩盖 7 沿皮带罩 D 5 的槽滑动至尽头。
8. 沿箭头方向拉动皮带罩 D 5 直到上皮带罩 U 1 和皮带罩盖 7 之间无间隙。
9. 彻底旋紧 2 个螺钉 6 (参考步骤 5。)

8. Installing the cotton stand

8. 线架安装



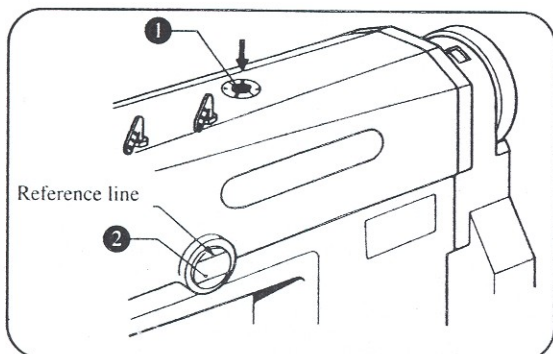
Assemble the cotton stand 1 while referring to the cotton stand instruction manual, and then install the cotton stand 1 to the far right corner of the work table.

按照图示组装好线架组件, 然后插入台板孔, 转动线架在最佳位置拧紧螺母和撑管夹螺钉。

9. Lubrication

9. 供油系统

- The sewing machine should always be lubricated and the oil supply replenished before it is used for the first time, and also after long periods of non-use.
- 机器在使用之前必须有足够油量, 对各供油系统进行加油。



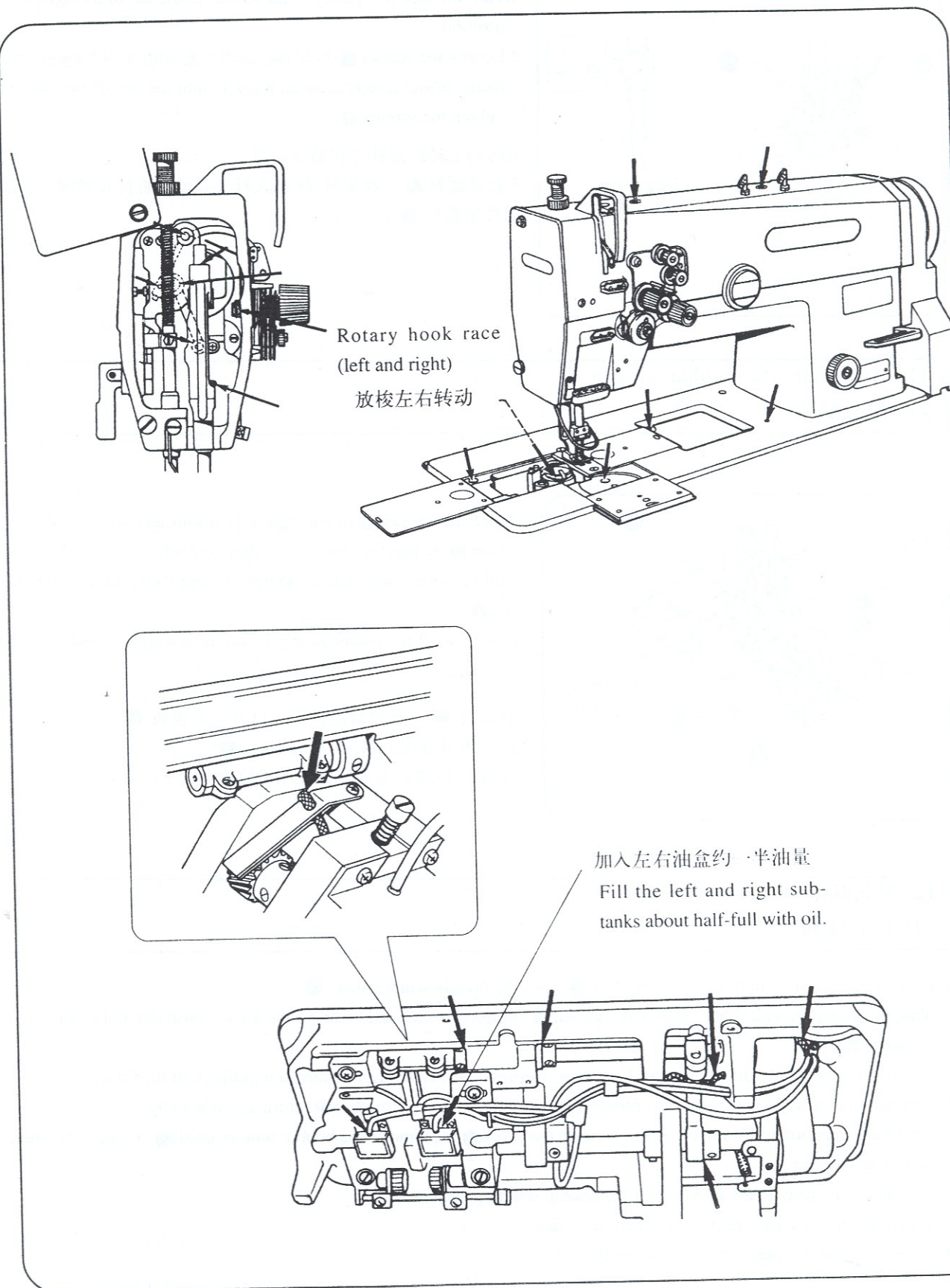
- 1. Lubrication
- 1. 供油

Pour oil in through the oil inlet 1 until the oil level rises to the upper reference line in the oil sight glass 2.

通过注油入口 1 把油倒入油箱 2 内直到上参观油量标记为止。

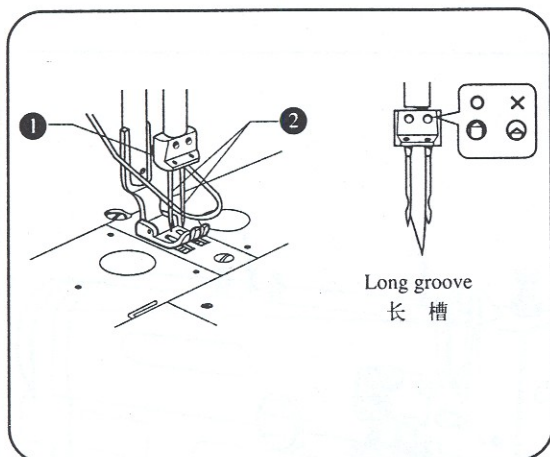
- 2. Oiling
- 2. 加油

Add 1-2 drops of oil in the places indicated by the arrows.
加 1-2 点油在箭头标记处。



10. Installing the needle

10. 机针安装

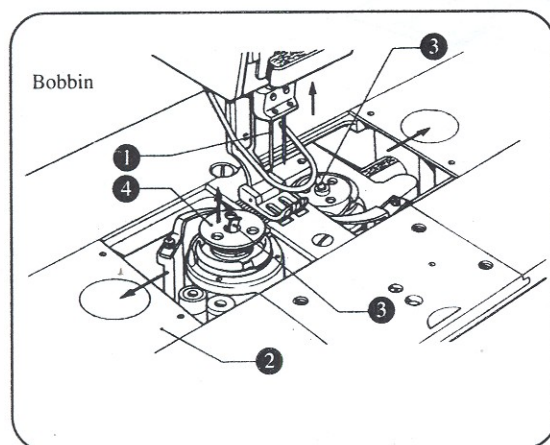


1. Turn the machine pulley to move the needle bar to its highest position.
2. Loosen the screws ①, hold the needles ② with their long groove facing inward, insert them all the way into the needle bars, and re-tighten the screws ①.

1. 转动主轴轮使针杆在最高位置。
2. 松开螺钉 ①，将机针 ② 插入针夹孔内，机针长槽向里，最后拧紧螺钉 ①。

11. Removing the bobbin or cap

11. 梭心御载



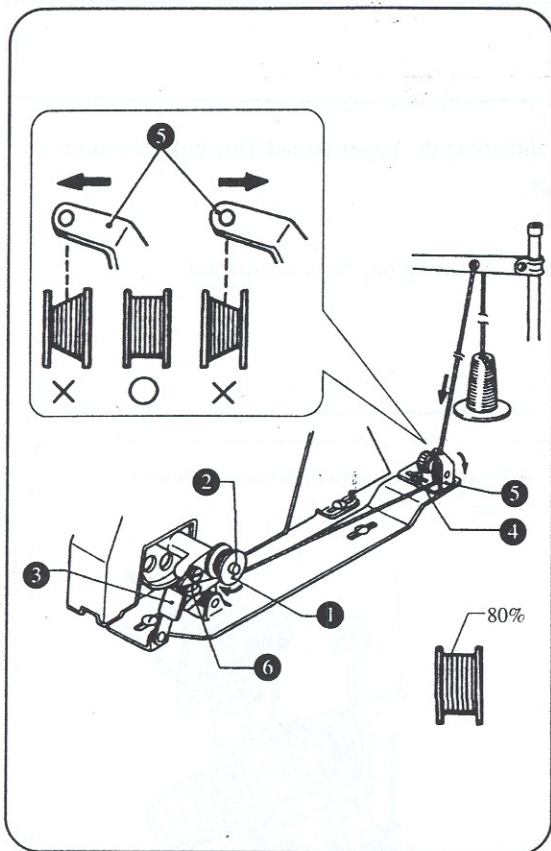
1. Raise the needles ① to the highest positions, and open the slide plates ② by moving them to the right and left.
 2. Pull the rotary hook latches ③ upward, and then remove the bobbin ④.
- Note: Turn off the power supply before removing the bobbin or the cap.

1. 将机针 ① 上升到最高位置，打开左右推板 ②。
 2. 向上扳开旋梭门簧 ③ 取出梭心 ④。
- 注意：在取梭心前要确保发动机完全停止。

12. Winding the lower thread

12. 梭心绕线

1. Turn on the power switch. Place the bobbin ① onto the bobbin winder shaft ②.
 2. Wind the thread several times around the bobbin ① in the direction indicated by the arrow. Push down the bobbin presser arm ③.
 3. Raise the presser foot with the presser foot lifter. Depress the treadle. Lower thread winding will then start.
 4. Once winding of the lower thread is completed, the bobbin presser arm ③ will return automatically.
- * If the thread cannot be wound on evenly, loosen the screw ④ and move the bobbin winder guide ⑤ to the side where there is less thread.
- * Turn the adjustment screw ⑥ to adjust the bobbin winding amount.
- To increase the winding amount: Tighten the screw.
 - To decrease the winding amount: Loosen the screw.



Note: The amount of thread wound onto the bobbin should be a maximum of 80% of the bobbin capacity.

1. 开动电源将梭芯 ① 插入绕线器轴上 ②。
2. 先将线按照箭头方向在梭芯 ① 上绕几圈后，将梭芯压板 ③ 向下压到底。
3. 抬起压脚扳手，踏动踏板绕线开始。
4. 绕线完毕，梭芯压板 ③ 自动返回原位。

* 如果绕线排列不均匀，先松开过线架螺钉 ④，左右移动过线架进行调整。

* 转动调节螺钉 ④ 来调节梭芯线量。

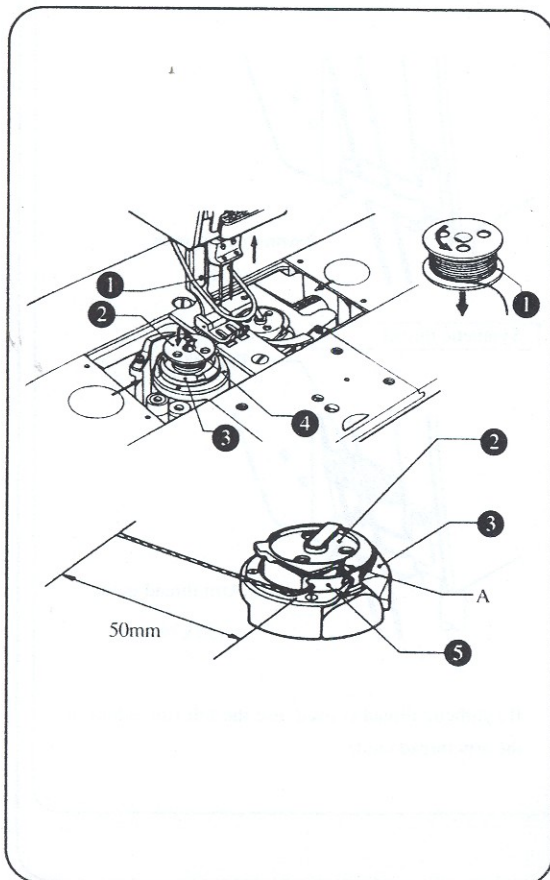
● 增加线量：拧紧螺钉

● 减小线量：松动螺钉

注意：梭芯线量占整个梭芯 80% 为准。

13. Installing the bobbin or cap

13. 梭心安装



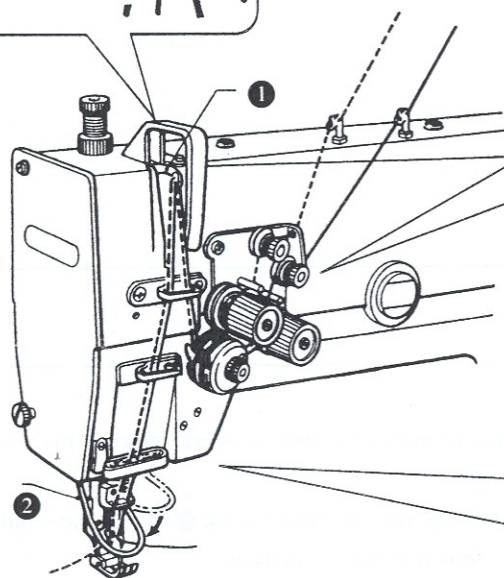
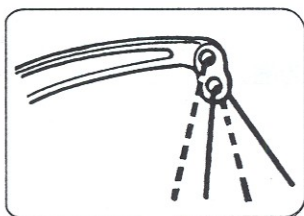
1. Turn the machine pulley to raise the needle ① to its highest position.
2. Insert the bobbin ② into the rotary hook ③ so that the winding direction is as shown in the illustration.
3. Return the rotary hook latch ④ to its original position.
4. Turn the machine pulley to rotate the rotary hook ③ until the tension spring ⑤ is visible.
5. Pass the thread through slit A in the rotary hook and then pass it under the thread tension spring ⑤.
6. Pull out the thread to a length of approximately 50 mm.
7. Close the slide plates.

1. 转动将主动轮使机针 ① 在最高位置。
2. 将梭芯插入旋梭，线头拉出方向如图所示。
3. 按下旋梭门簧 ④ 到原来位置。
4. 转动主动轮让张力簧片 ⑤ 在可见位置。
5. 将线穿过缝隙“A”，从张力簧片 ⑤ 的底下穿过。
6. 底线拉出量为约 50mm。
7. 关上两边推板。

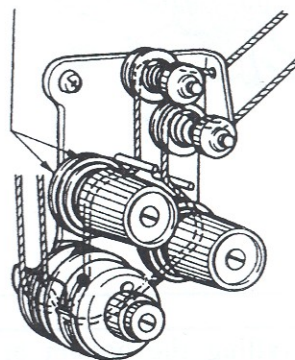
14. Threading the upper thread

14. 上线穿线方法

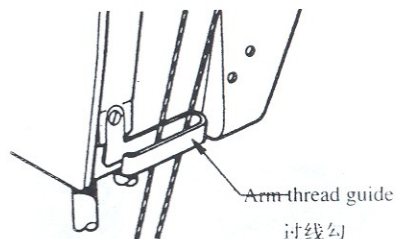
1. Turn the machine pulley and raise the thread take-up lever ❶ before threading the upper thread. This will threading easier and it will prevent the thread from coming out at the sewing start.
 2. Thread the left-side thread first.
 3. The position of the finger guard ❷ is adjustable. Be sure to lower it once threading has been completed.
1. 将挑线杆 ❶ 转到最高点便于穿线。
 2. 从左边开始穿线。
 3. 穿线完毕，护指器 ❷ 在最低位置。



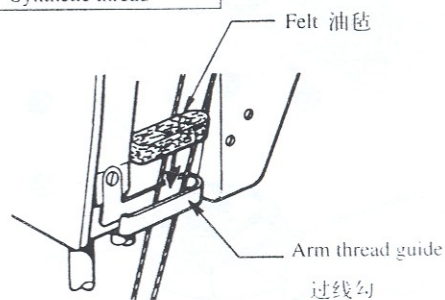
- Pass the thread correctly between the tension discs.



Cotton thread

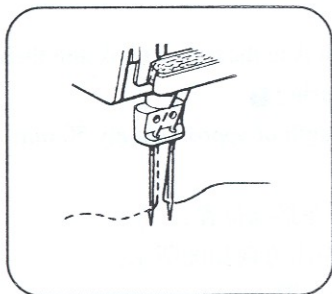


Synthetic thread



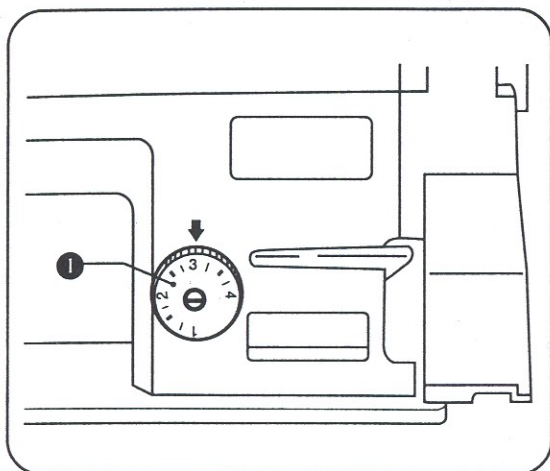
If synthetic thread is used, use the felt (included) in the arm thread guide.

- Pass the threads through the needle eyes from inside to outside.
Pull out about 50 mm of thread through each of the needle eyes.
线从机针里面向外面穿出，线头拉出约 50mm。



15. Adjusting the stitch length

15. 针距长度的调节



1. Turn the stitch length dial ❶ clockwise or counterclockwise so that the desired stitch length is at the uppermost position on the dial.

* The larger the number, the longer the stitch length will be.

2. When the reverse stitching lever ❷ is pushed, the cloth feed direction will be reversed, and when it is returned to its original position, the feed direction will change back to normal.

1. 将针距标盘 ❶ 按顺序方向转动，倒缝操纵杆会打到最高位置。

* 数字越大，送布量也越大。

2. 按下倒缝料纵杆，布料即可倒逆，松开后操纵杆复位，恢复顺向自动送料。

16. Thread tension

16. 线张力的调节



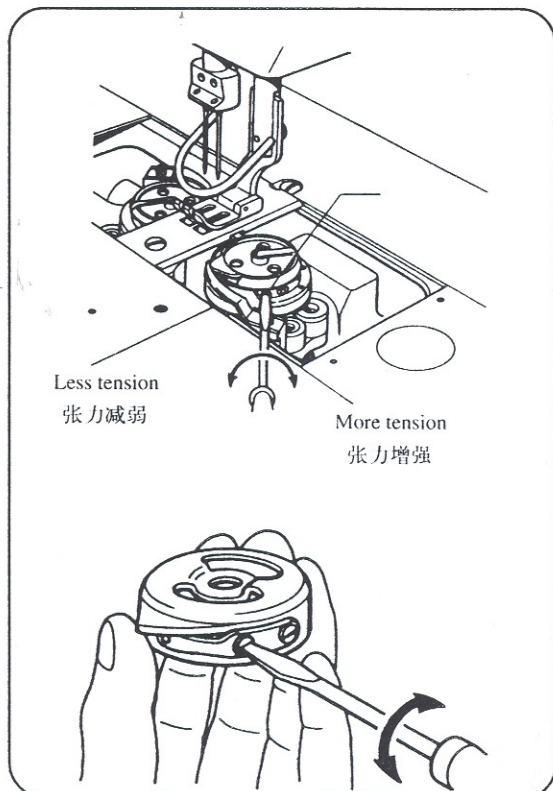
Good even stitches
正确线迹



Upper thread tension too strong or lower thread tension too weak
上线太紧的线迹



Upper thread tension too weak or lower thread tension too strong
下线太松的线迹

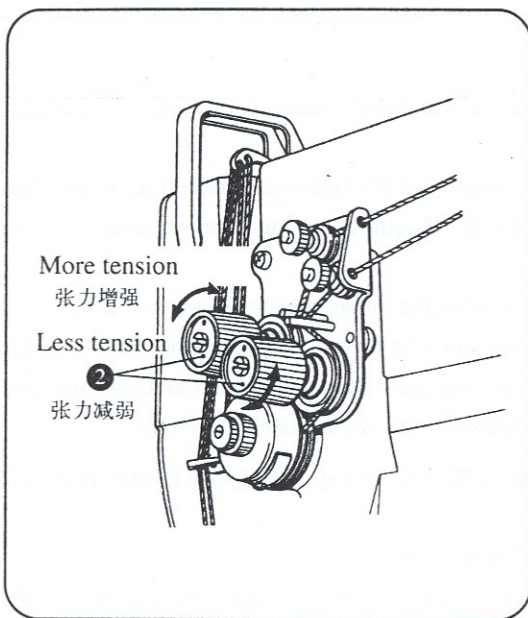


■ Lower thread tension

The tension of the lower thread varies with the kind of cloth and thread, and can be adjusted by turning the lower thread tension adjustment screw ❶.

■ 底线张力调节

转动螺钉 ❶，根据布料，缝线来调整底线张力。



■ Upper thread tension

After the lower thread tension has been adjusted, adjust the upper thread tension so that a good, even stitch is obtained.

1. Lower the presser foot.
2. Adjust by turning the thread tension nut ②.

■ 上线张力调节

首先调整底线张力后，再调整上线张力，线迹达到最好。

1. 降低压脚压力
2. 转动张力调节螺母来调节。

17. Adjusting the presser foot pressure

17. 压脚压力调节

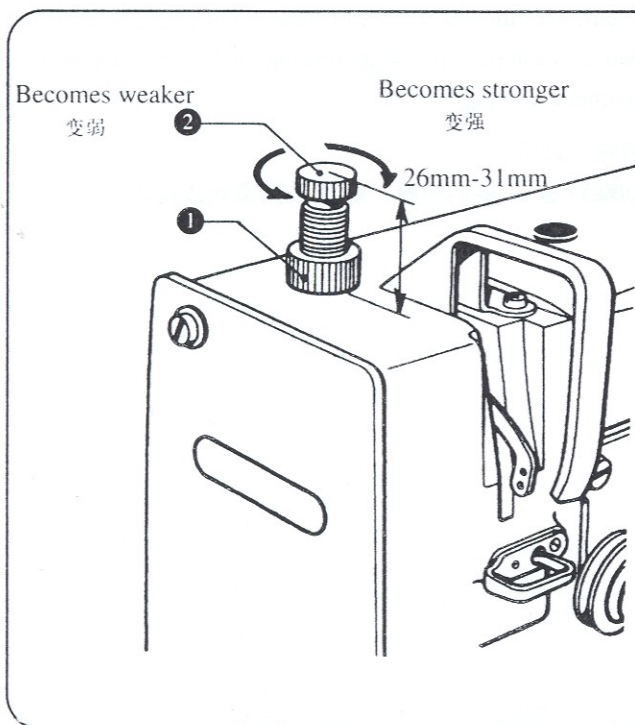
正常线迹 ← correct stitches

出现跳针
Skipped stitches occur
针距长短不齐
Uneven stitch length

增加压力
● Increase the pressure.

线迹起皱
Stitches are puckered

减小压力
● Decrease the pressure



The presser foot pressure should be as weak as possible, but strong enough so that the material does not slip.

1. Loosen the adjustment nut ①.
2. Turn the adjustment screw ② to adjust the presser foot pressure.

3. Tighten the adjustment nut ①.

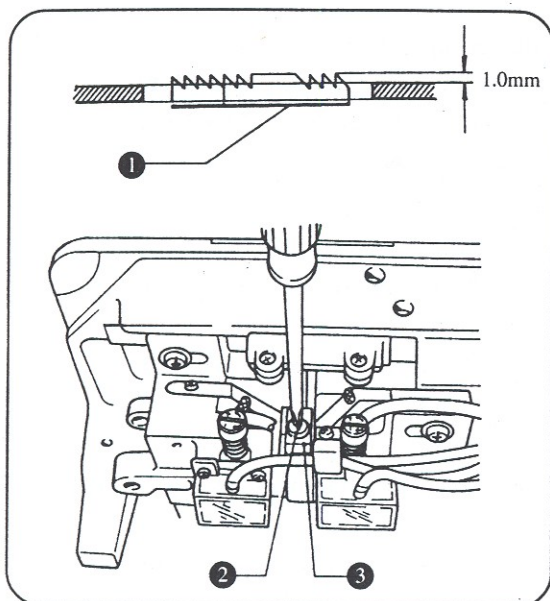
压脚压力应该尽量轻，但增足够力压力才能防止布量起皱。

1. 松开调节螺母。
2. 转动调节螺钉来调整压脚压力。
3. 拧紧调节螺钉。

	压脚压力 Presser foot pressure	调整高度 Adjustment screw height
薄料 For thin materials	29.4N (3 kgf)	31mm
中厚料 For medium thick	39.2N (4 kgf)	28mm
厚料 For thick materials	49N (5 kgf)	26mm

18. Adjusting of the feed dog height

18. 送布牙的高度调节

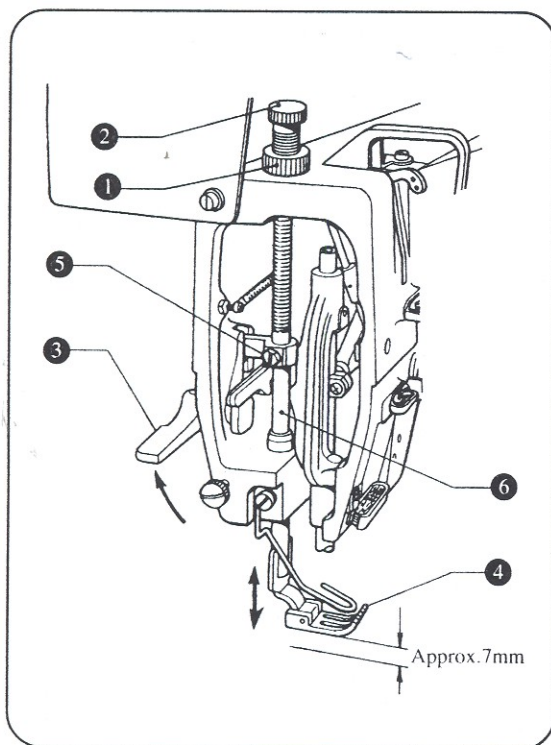


1. Turn the pulley until the feed dog ① rises to the highest position.
2. Tilt back the machine head.
3. Loosen screw ② and raise or lower the feed dog holder ③ so that the feed dog ① will rise to about 1.0 mm above the needle plate.
4. Tighten the screw ②.

1. 转动主动轮，使送布牙提升最高位置。
2. 放倒机壳。
3. 松开螺钉 ② 上下移动牙叉 ③；使送布牙高出针板面约 1.0mm
4. 拧紧螺钉 ②。

19. Adjusting the presser foot height

19. 压脚高度的调节



1. Loosen the nut ①, and then loosen the presser foot adjustment screw ②.

2. Open the face plate.

3. Raise the presser foot ④ with the presser foot lifter ③.

4. Loosen the screw ⑤, and then move the needle bar ⑥ up or down to adjust so that the presser foot ④ is approximately 7 mm above the top of the needle plate.

NOTE: Be careful not to rotate the needle bar ⑥.

5. Tighten the screw ⑤.

6. Adjust the presser foot pressure by turning the presser foot adjustment screw ②, and then tighten the nut ①.

1. 松动调节螺母 ①，转动压脚调节螺钉 ②。

2. 打开面板

3. 提升压脚板手 ③。

4. 松开螺钉 ⑤，上下移动压紧杆使压脚离针板高度约 7mm。

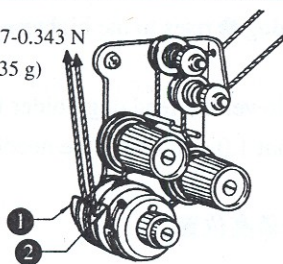
5. 拧紧固定螺钉 ⑤。

6. 转动调节螺钉 ② 来调节压脚压力，最后拧紧螺母 ①。

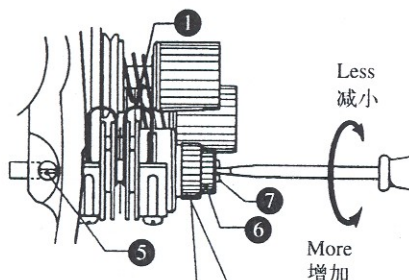
20. Adjusting the thread tension spring

20. 挑线器的调节

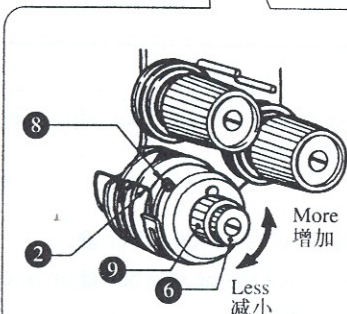
0.147-0.343 N
(15-35 g)



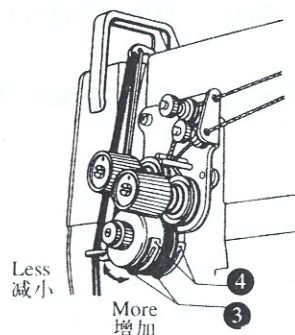
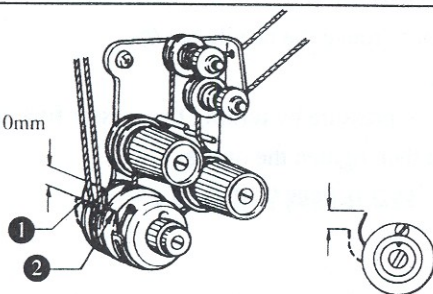
<L ①>



<R ②>



5-10mm



■ Thread take-up spring tension

The standard tension for thread take-up spring L ① and thread take-up spring R ② is 0.147-0.343 N (15-35 g) for both springs.

< Thread take-up spring L ① >

1. Open the face plate.
2. Loosen the screw ⑤.
3. Loosen the knob ⑥, and then turn the thread tension stud ⑦ to adjust the tension.
4. Tighten the screw ⑤, and then tighten the knob ⑥.

< Thread take-up spring R ② >

1. Loosen the set screw ⑧.
2. Loosen the knob ⑥, and then turn the adjustment knob ⑨ to adjust the tension.
3. Tighten the screw ⑧, and then tighten the knob ⑥.

■ 挑线簧张力

挑线簧 L ① 与挑线簧 R ②, 标准张力为 0.147-0.343N (15-35g)。

〈挑线簧 L ① 调节〉

1. 打开面板。
2. 松开螺钉 ⑤。
3. 松开调节螺母 ⑥ 转动夹线器轴来调节挑线簧张力。
4. 调好后, 拧紧螺钉 ⑤ 和调节螺母 ⑥。

〈挑线簧 R ② 调节〉

1. 松开螺钉 ⑧。
2. 松开调节螺母 ⑥, 转动调节螺母 ⑨, 来调整挑线簧 R 张力。
3. 拧紧螺钉 ⑧ 和调节螺母 ⑥。

■ Operating range of thread take-up spring

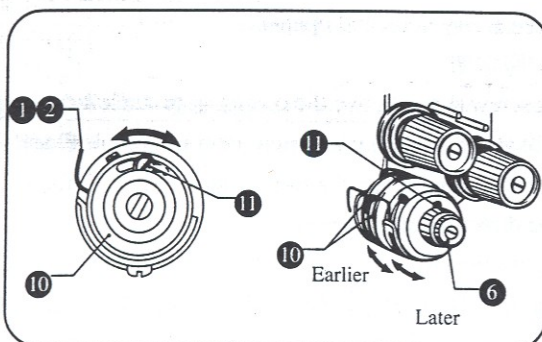
The standard operating range for thread take-up spring L ① and thread take-up spring R ② is 5-10 mm for both springs.

1. Loosen the left and right screws ③, and then turn the left and right thread take-up spring stoppers ④ to adjust the operating range.
2. Tighten the screws ③.

■ 挑线簧弹力范围

挑线簧 L 与挑线簧 R 弹力范围一般为 5-10mm

1. 松开左右螺钉 ③, 左右调节挑线簧限位板来调整弹力范围。
2. 拧紧螺钉 ③。



■ Thread take-up spring operation timing

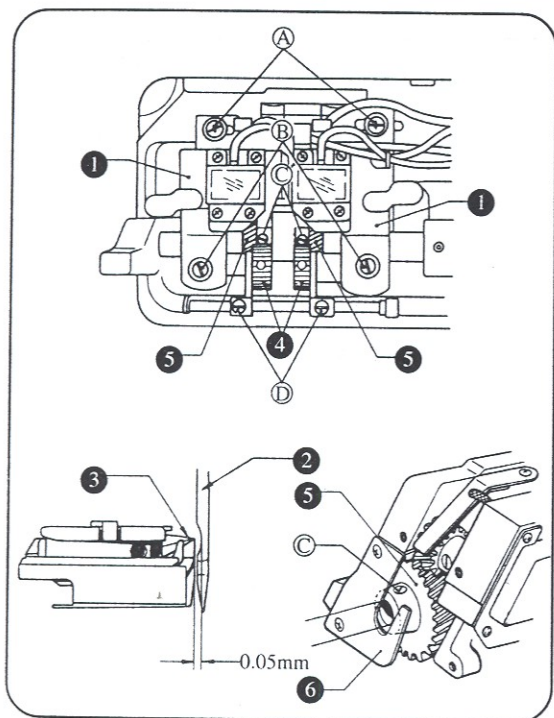
The standard operation timing for thread take-up spring L ① and thread take-up spring R ② is the middle position within the operating range of the thread take-up spring guide ⑩.

■ 挑线簧位置调节

挑线簧 L 与挑线簧 R 位置一般为挑线簧过线板中间位置。

21. Adjusting the needle and rotary hook timing

21. 机针与旋梭同步调整



■ Needle to rotary hook point gap

■ 机针与旋梭尖调整。

1. Tilt back the machine head.
2. Loosen screws ①, ②, ③ and ④.
3. Move the rotary hook base ① to the left or right so that the clearance between the needle ② and the rotary hook tip ③ is 1-3mm.
4. Tighten screw ④, and then turn the adjusting screw ⑤ to adjust so that the clearance between the needle ② and the rotary hook tip ③ is 0.05mm.
5. After adjusting, securely tighten screws ①, ② and ③.

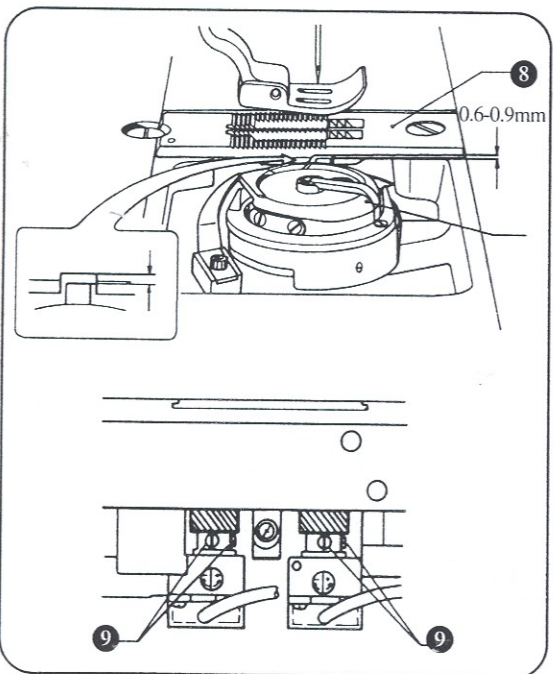
1. 放倒机壳。

2. 松开螺钉 ①、②、③ 和 ④。

3. 左右移动旋梭支架 ①，使机针 ② 与旋梭尖 ③ 保持在 1-3 mm 内。

4. 拧紧螺钉 ④，再转动调节螺钉来调整机针缺口与旋梭尖距离为 0.05mm。

5. 调整后，拧紧固定螺钉 ①、②、和 ③。



■ Clearances between rotary hooks and needle plate

■ 旋梭与针板间隙调整

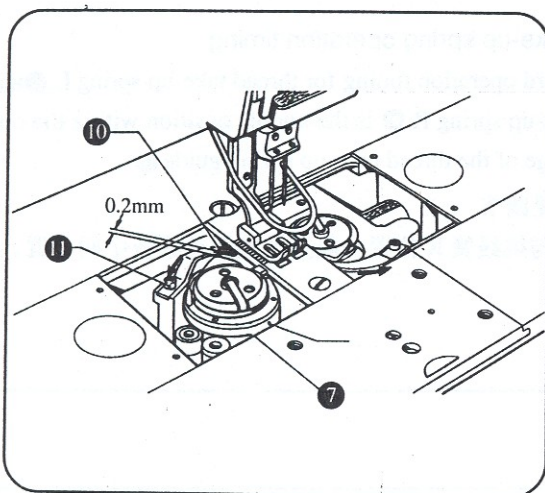
1. Remove the slide plates.
2. Tilt back the machine head.
3. Loosen the set screws ⑨ and move the rotary hook ⑦ up and down to adjust so that the clearance between the rotary hook ⑦ and the needle plate ⑧ is 0.6-0.9 mm.
4. Tighten the set screws ⑨.

1. 打开推板

2. 摆正缝纫机头部

3. 松开固定螺钉 ⑨ 上下移动旋梭来确保旋梭与针板间隙 0.6 - 0.9mm。

4. 拧紧固定螺钉 ⑨。



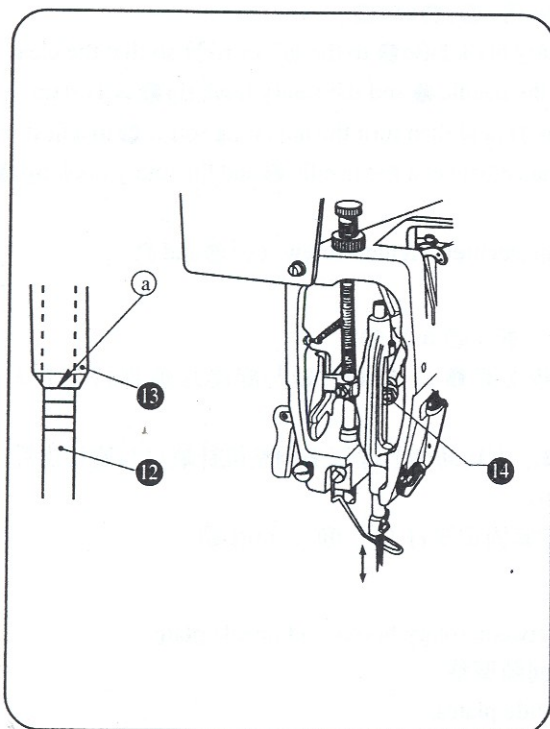
Clearance between rotary hook and opener

旋梭与分线勾间隙调节

1. Loosen the set screw ⑪ and move the opener ⑩ to the left or right to adjust so that the clearance between the rotary hook ⑦ and the opener ⑩ is 0.2 mm when the opener ⑩ is pulled as far as it will go in the direction of the arrow.
 2. Tighten the set screw ⑪.
1. 松开螺钉 ⑪ 左右移动分线勾 ⑩ 来调，当分线勾达到最大位置，即将如箭头方向运动时，整旋梭 ⑦ 与分线勾 ⑩ 间隙为 0.2mm
2. 拧紧螺钉 ⑪。

22. Needle bar height and lift amount

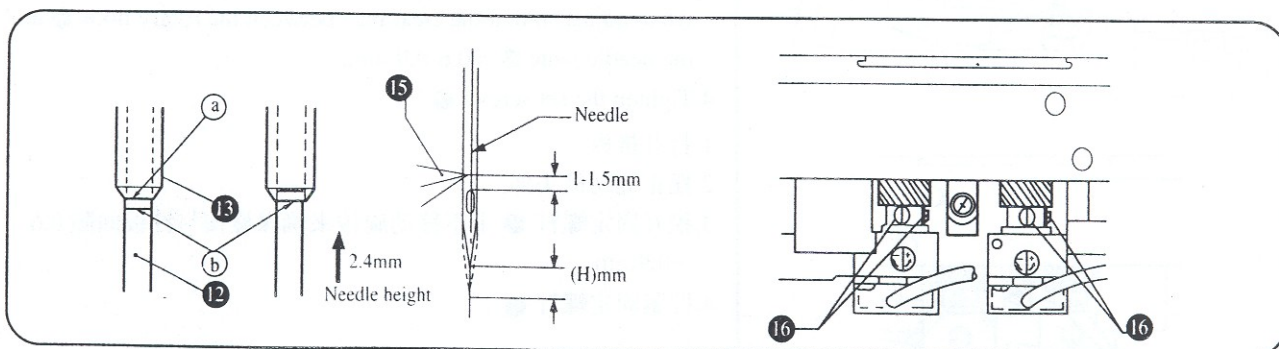
22. 针杆高度和上升量的调整



■ Needle bar height

■ 针杆高度

1. Open the face plate.
 2. Loosen the screw ⑭.
 3. Turn the machine pulley to move the needle bar ⑫ to its lowest position.
Reference line ③ at the top of the needle bar ⑫ must be aligned with the lower edge of the needle bar supporter at this time.
 4. Tighten the screw ⑭.
 5. Turn the machine pulley and check that the needle goes into the middle of the needle hole in the feed dog.
1. 打开面板。
2. 松开螺钉 ⑭。
3. 转动主动轮使针杆处于最低位置，移动针杆使针杆上刻线 ③ 应与针杆支架下端 ⑭ 一致刻线 a 必须在钱杆运动最下端往上走时。
4. 拧紧螺钉 ⑭。
5. 转动主动轮，调整机针在送布牙针孔中心。



■ Needle bar lift amount

■ 针杆上升量

6.Remove the needle plate.

7.Remove the feed dog.

8.Turn the machine pulley to raise the needle bar ⑫ by 2.4mm from its lowest position.

9.Tilt back the machine head, Loosen the screw ⑩ and the distance from the upper edge of the needle hole to the rotary hook tip must be 1-1.5mm when the rotary hook tip ⑮ is aligned with the center of the needle.

10.Tighten the screws ⑩.

11.Install the feed dog and the needle plate.

6、打开针板

7、取出送布牙

8、转动主动轮使针杆从刻度线⑫上升刻度线⑬距离为2.4mm。

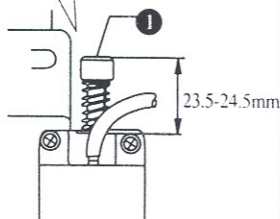
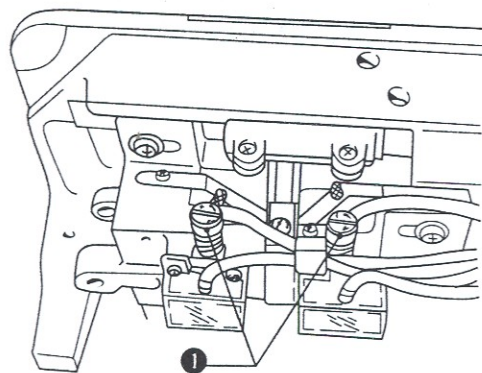
9、放倒机头，松开螺钉⑩，调整旋梭尖与机针中心距离为1-1.5mm左右。

10、拧紧螺钉⑩。

11、装上送布牙和针板。

23. Adjusting the rotary hook lubrication amount

23. 旋梭油量调节



■ Lubrication adjustment guide

■ 油量调节方法

1.Tilt back the machine head.

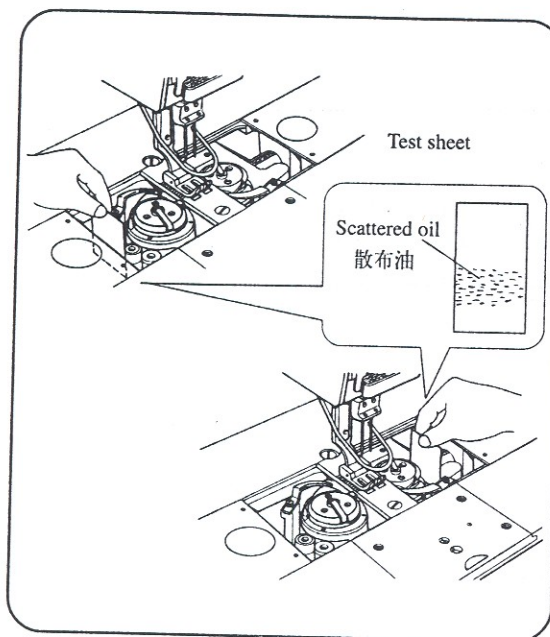
2.Turn the lubrication adjustment screw ① to adjust its height to 23.5-24.5mm

NOTE:Be careful not to loosen the lubrication adjustment screw ① too much otherwise the oil in the oil tank will be consumed too quickly.

1.放到机头。

2.小轻转动油量调节螺钉①高度在23.5-24.5mm左右。

注意：测量调节螺钉不能太松，否则过快造成测量消耗。



■ Checking the lubrication amount.

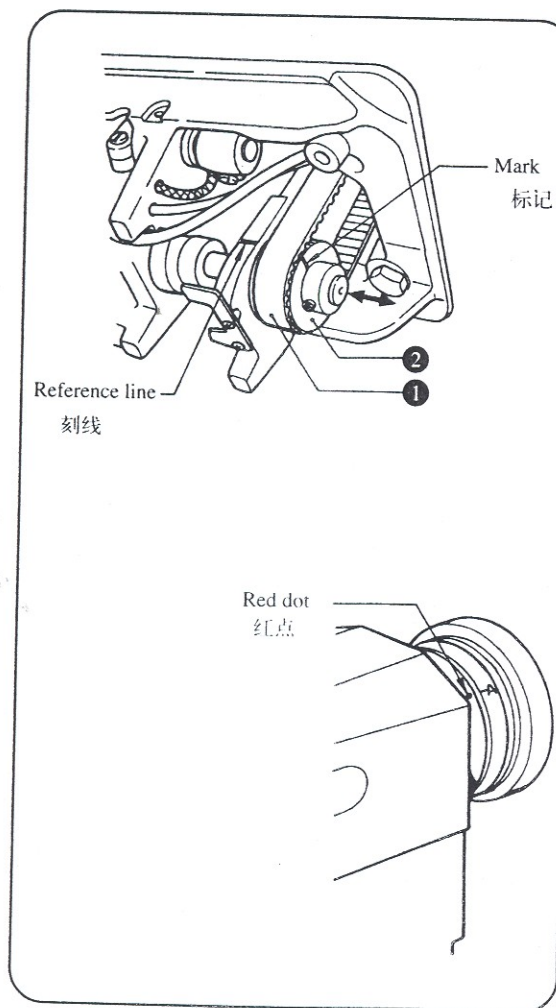
■ 油量测试法

1. Turn on the power.
2. Insert a piece of white paper into the left side of the rotary hook (into the right side for the right rotary hook) and depress the treadle fully to operate the machine at maximum speed for approximately 10 seconds.
3. Stop the machine and check the amount of oil that is scattered on the paper.
(The adjustment is good if the amount of oil shown at left is scattered during approximately 10 seconds.)

1. 打开电源。
2. 在转速最大时，分别在梭旋左右侧放入一张白纸约 10 秒钟。
3. 停放机器，核对白纸上油量。
(在测试 10 秒后，散布在白纸上油量如图所示为佳)。

24. Adjusting the needles and feed timing

24. 机针与送布同步调整



1. Remove the needles.
2. Remove the belt cover.
3. Tilt the machine head back and remove the timing belt ①.
4. Turn the machine pulley until the "A" mark is aligned with the red dot.
5. While holding the upper shaft so that it won't move, align the mark on the lower belt pulley ② with the reference line on the arm bed, and attach the timing belt ①.
6. Check the position of the "A" mark on the machine pulley.
7. Replace the belt cover.
8. Install the needles.

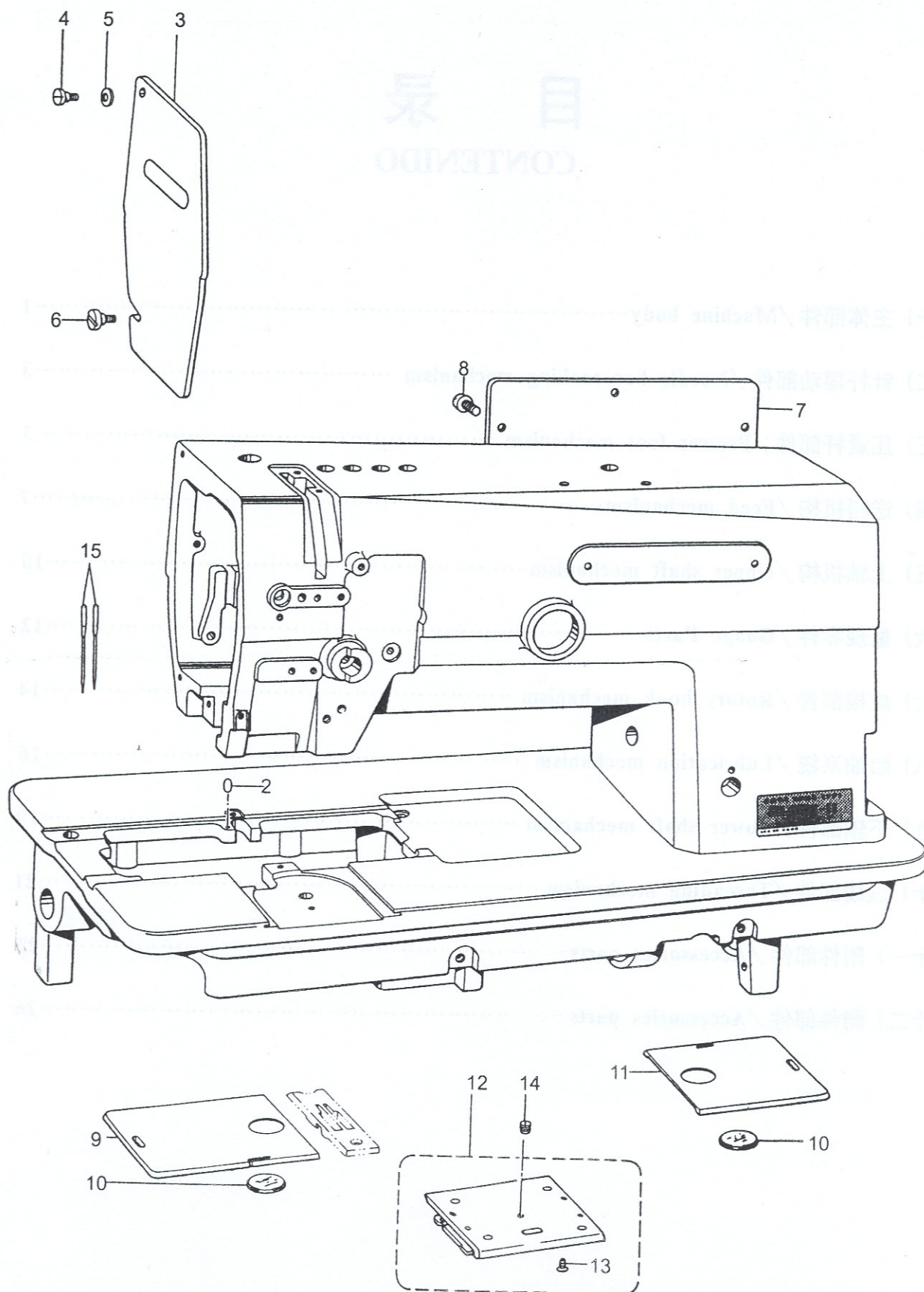
1. 取下机针。
2. 取下皮带罩。
3. 放倒机头，移动同步带。
4. 转动主动轮到轮上 "A" 标记与机头上红点标记一致。
5. 确保上轴不动，转动下时规轮 ② 上标记与底板上红刻线一致，装上同步带。
6. 核对主动轮上 "A" 标记位置是否正确。
7. 装上皮带罩。
8. 装上机针。

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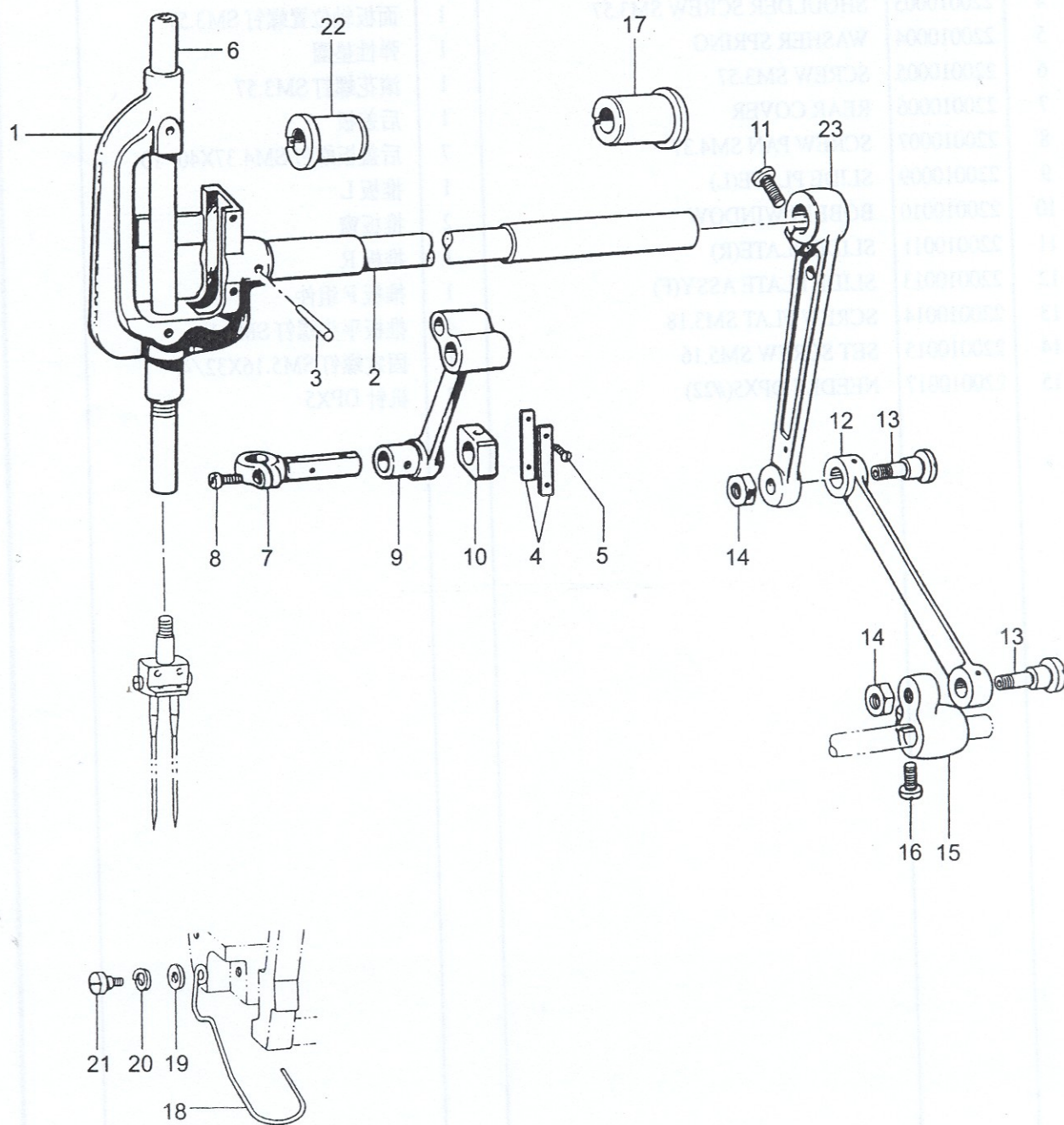
(一) 主体部件 / Machine body



(一) 主体部件 / Machine body

序号 (N0)	图 号 (Ref.No)	Name of parts	数量 (Qt)	零 件 名 称	备注 (Rm)
2	220010001	POSITIONING PIN	1	针板定位销	
3	220010002	FACE PLATE	1	面板	
4	220010003	SHOULDER SCREW SM3.57	1	面板轴位置螺钉 SM3.57	
5	220010004	WASHER SPRING	1	弹性垫圈	
6	220010005	SCREW SM3.57	1	滚花螺钉 SM3.57	
7	220010006	REAR COVER	1	后盖板	
8	220010007	SCREW PAN SM4.37	7	后盖板螺钉 SM4.37X40-10	
9	220010009	SLIDE PLATE(L)	1	推板 L	
10	220010010	BOBBIN WINDOW	2	推板窗	
11	220010011	SLIDE PLATE(R)	1	推板 R	
12	220010013	SLIDE PLATE ASSY(F)	1	推板 F 组件	
13	220010014	SCREW FLAT SM3.18	4	推板平头螺钉 SM3.18	
14	220010015	SET SCREW SM5.16	1	固定螺钉 SM5.16X32/4	
15	220010017	NEEDLE DPX5(#22)	2	机针 DPX5	

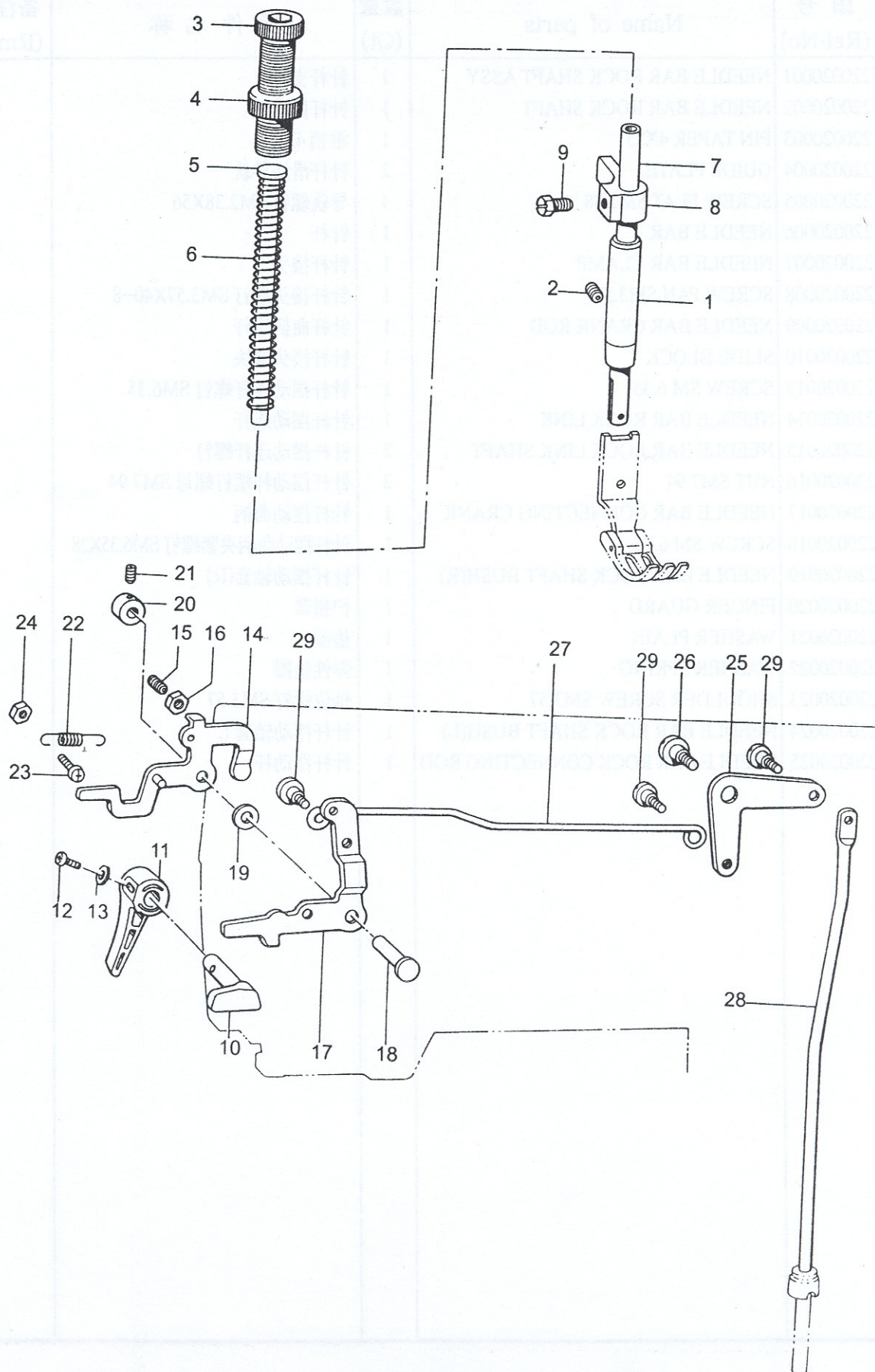
(二) 针杆摆动部件 / Needle bar rocking mechanism



(二) 针杆摆动部件 / Needle bar rocking mechanism

序号 (N0)	图 号 (Ref.No)	Name of parts	数量 (Qt)	零 件 名 称	备注 (Rm)
1	220020001	NEEDLE BAR ROCK SHAFT ASSY	1	针杆支架	
2	220020002	NEEDLE BAR ROCK SHAFT	1	针杆摆动轴	
3	220020003	PIN TAPER 4X25	1	锥销 4X25	
4	220020004	GUIDE PLATE	2	针杆滑块导轨	
5	220020005	SCREW FLAT SM2.38	4	导轨螺钉 SM2.38X56	
6	220020006	NEEDLE BAR	1	针杆	
7	220020007	NEEDLE BAR CLAMP	1	针杆接头	
8	220020008	SCREW PAN SM3.57	1	针杆接头螺钉 SM3.57X40-8	
9	220020009	NEEDLE BAR CRANK ROD	1	针杆曲柄连杆	
10	220020010	SLIDE BLOCK	1	针杆接头滑块	
11	220020013	SCREW SM 6.35	1	针杆摆动连杆螺钉 SM6.35	
12	220020014	NEEDLE BAR ROCK LINK	1	针杆摆动连杆	
13	220020015	NEEDLE BAR ROCK LINK SHAFT	2	针杆摆动连杆螺钉	
14	220020016	NUT SM7.94	2	针杆摆动杆螺钉螺母 SM7.94	
15	220020017	NEEDLE BAR CONNECTING CRANK	1	针杆摆动曲柄	
16	220020018	SCREW SM 6.35	1	针杆摆动曲柄夹紧螺钉 SM6.35X28	
17	220020019	NEEDLE BAR ROCK SHAFT BUSH(R)	1	针杆摆动轴套(R)	
18	220020020	FINGER GUARD	1	护指器	
19	220020021	WASHER PLAIN	1	垫圈	
20	220020022	WASHER SPRING	1	弹性垫圈	
21	220020023	SHOULDER SCREW SM3.57	1	轴位螺钉 SM3.57	
22	220020024	NEEDLE BAR ROCK SHAFT BUSH(L)	1	针杆摆动轴套 L	
23	220020025	NEEDLE BAR ROCK CONNECTING ROD	1	针杆摆动杆	

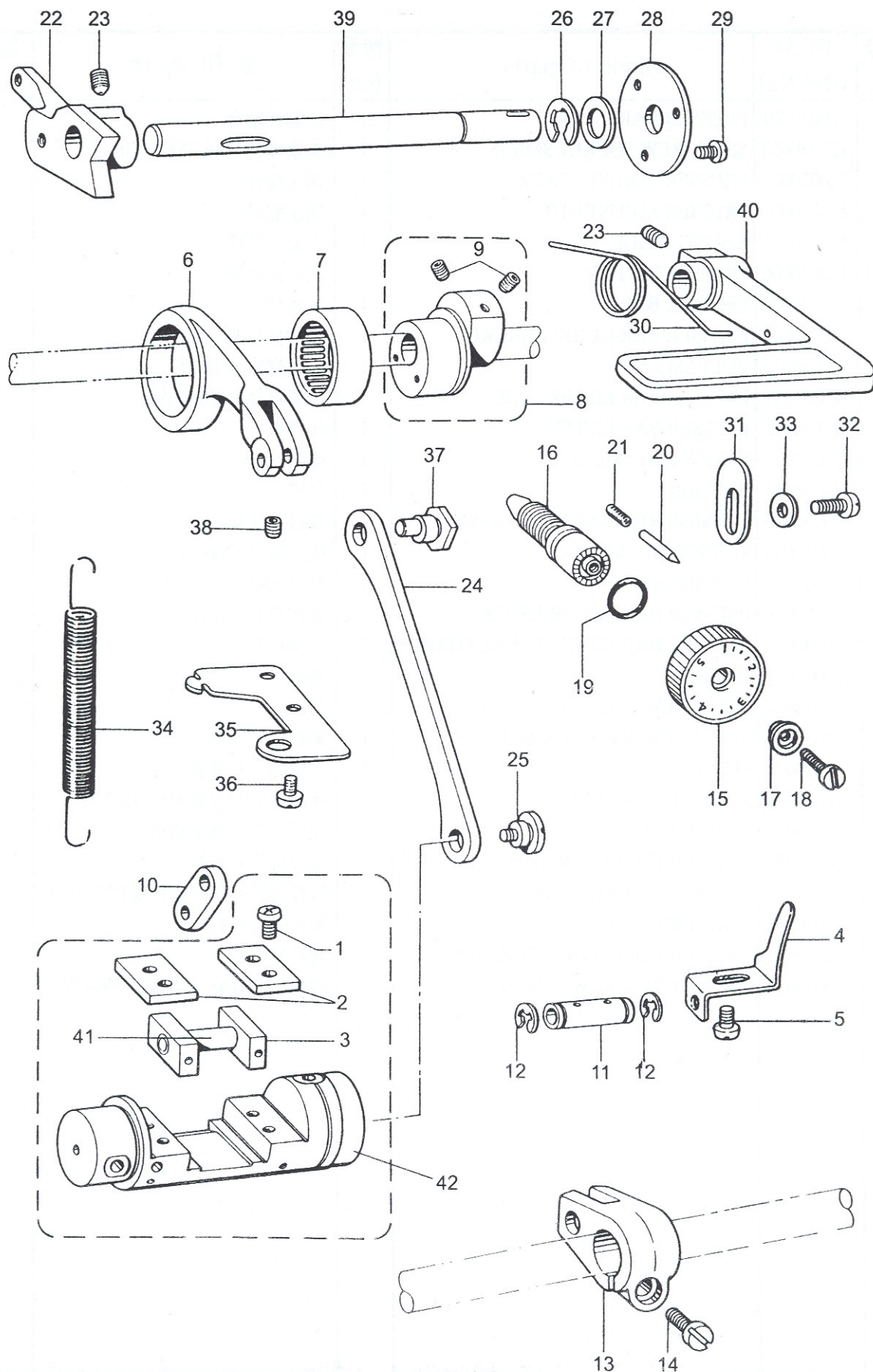
(三) 压紧杆部件 / Presser foot mechanism



(三) 压紧杆部件 / Presser foot mechanism

序号 (N0)	图号 (Ref.No)	Name of parts	数量 (Qt)	零件名称	备注 (Rm)
1	220030001	PRESSER BAR BUSH	1	压紧杆轴套	
2	220030002	SET SCREW SOCKET SM6.35	1	支紧螺钉 SM6.35X28/10	
3	220030003	PRESSER ADJUST SCREW	1	调压螺钉	
4	220030004	PRESSER ADJUST NUT	1	调压螺母	
5	220030005	SPRING GUIDE	1	压紧杆导柱	
6	220030006	PRESSER SPRING	1	压紧杆弹簧	
7	220030007	PRESSER BAR	1	压紧杆	
8	220030009	PRESSER BAR GUIDE BRACKET	1	压紧杆导架	
9	220030010	BOLT SM5.95	1	六角螺栓 SM5.95	
10	220030011	PRESSER BAR LIFTER STUD	1	压紧杆导架提升凸轮	
11	220030012	PRESSER BAR LIFTER	1	压脚扳手	
12	220030013	SCREW PAN SM3.57	1	螺钉 SM3.57	
13	220030014	WASHER	1	垫圈	
14	220030015	TENSION RELEASE PLATE ASSY	1	挺线左杠杆	
15	220030016	SET SCREW SM6.35	1	固定螺钉 SM6.35	
16	220030017	NUT SM6.35	1	螺母 SM6.35	
17	220030018	PRESSER BAR LIFTER LEVER	1	膝控提升左杠杆	
18	220030019	PRESSER BAR LIFTER LEVER SHAFT	1	压脚提升轴	
19	220030020	WASHER	1	垫圈	
20	220030021	SET SCREW COLLAR	1	紧圈	
21	220030022	SET SCREW SOCKET SM4.37	1	紧圈螺钉 SM4.37	
22	220030023	SPRING	1	压脚提升杆弹簧	
23	220030024	SCREW PAN SM3.57	2	压脚提升杆弹簧螺钉 SM3.57	
24	220030025	BUT SM3.57	1	压脚提升杆弹簧螺母	
25	220030026	KNEE LIFTER LEVER (right)	1	膝控提升右杠杆	
26	220030027	SHONLDER SCREW SM6.35	1	膝控提升右杠杆轴位螺钉 SM6.35	
27	220030028	KNEE LIFTER BAR	1	膝控提升拉杆	
28	220030029	KNEE LIFTER CONNECTING ROD	1	膝控提升连杆	
29	220030030	SHONLDOR SCREW SM4.76	3	膝控提升连杆轴位螺钉 SM4.76	

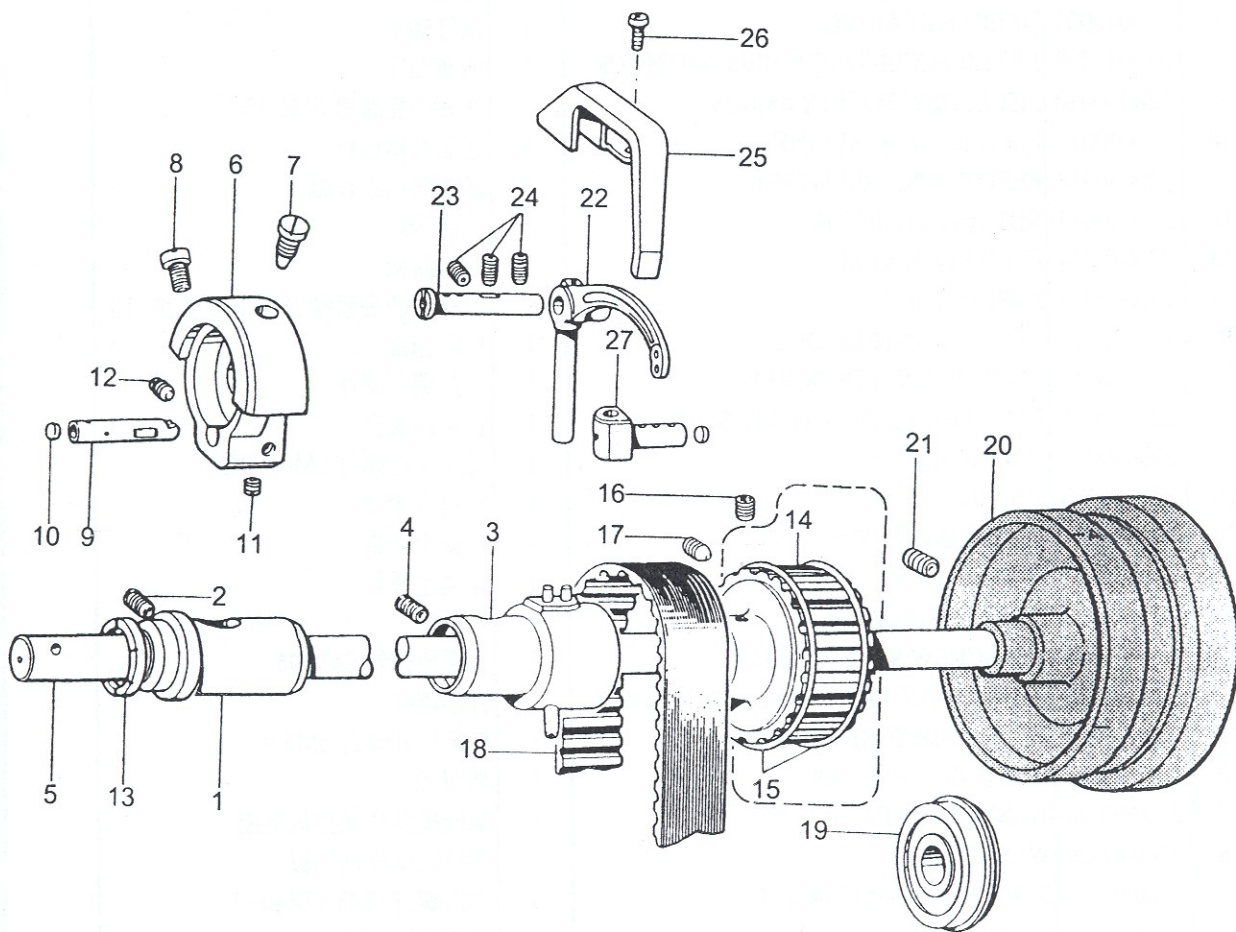
(四) 送料机构 / Feed mechanism



(四) 送料机构 / Feed mechanism

序号 (N0)	图 号 (Ref.No)	Name of parts	数量 (Qt)	零 件 名 称	备注 (Rm)
1	220040001	SCREW PAN SM4.37	4	滑块导板螺钉 SM4.37X40-10	
2	220040002	SLIDE BLOCK GUIDE PLATE	2	滑块导板	
3	220040003	FEED REGULATOR SLIDE BLOCK	2	针距调节导板	
4	220040004	FEED REGULATOR STOPPER	1	针距调节限位器	
5	220040005	SCREW PAN SM4.76 X32-6	1	针距调节限位器螺钉 SM4.76X32-6	
6	220040006	FEED ROCK CONNECTING ROD	1	送料连杆	
7	220040007	NEEDLE BEARING	1	滚针轴承	
8	220040009	LEVER ECCENTRIC WHEEL WITH SCR	1	送布凸轮	
9	220040010	SET SCREW SOCKET SM6.35	2	送布凸轮螺钉 SM6.35	
10	220040011	FEED ROCK ARM LINK	1	送布曲柄连杆	
11	220040012	FEED ROCK ARM SHAFT	1	送布曲柄连杆轴	
12	220040013	RETAINING RING E6	2	挡圈 E6	
13	220040014	FEED ROCK ARM	1	送布曲柄	
14	220040015	SCREW SM6.35	1	送布曲柄夹紧螺钉 SM6.35X28-18	
15	220040016	STITCH CONTROL DIAL	1	针距标盘	
16	220040017	STITCH CONTROL SCREW	1	针距调节螺杆	
17	220040018	LENGTH CONTROL PLATE SUPPORT	1	针距标盘套	
18	220040019	SCREW SM4.76	1	针距标盘螺钉 SM4.76X28	
19	220040020	O RING	1	密封 O 型圈	
20	220040021	POSITIONING PIN	1	标盘止动销	
21	220040022	SPRING	1	止动销弹簧	
22	220040023	FEED REGULATOR	1	针距座	
23	220040024	SET SCREW SOCKET SM5.95	3	针距座螺钉 SM5.95	
24	220040025	FEED REGULATOR CONNECTING ROD	1	针距连杆	
25	220040026	SHOULDER SCREW SM5.95	1	针距连杆螺钉 SM5.95	
26	220040027	RETAINING RING E8	1	挡圈 E8	
27	220040028	WASHER PLAIN	1	倒缝操纵杆轴挡板垫圈	
28	220040029	WASHER	1	倒缝操纵杆轴挡板	
29	220040030	SCREW PAN SM3.57X40-7	3	挡板螺钉 SM3.57X40-7	
30	220040031	SPRING	1	板手复位弹簧	
31	220040032	REVERSE LEVER STOPPER	1	倒缝板手限位器	
32	220040033	SCREW PAN SM4.76	1	倒缝板手限位器螺钉 SM4.76	
33	220040034	WASHER PLAIN	1	平垫圈	
34	220040035	SPRING FEED REGULATOR	1	复位弹簧	
35	220040036	SPRING HOOK	1	弹簧架	
36	220040037	SCREW PAN SM4.76	2	弹簧架螺钉 SM4.76 X32-6	
37	220040038	FEED REGULATOR ECCENRIC WHEEL SHAFT	1	针距连杆偏心轴	
38	220040039	SET SCREW SOCKET SM5.95	1	固定螺钉 SM5.95	
39	220040040	REVERSE STITCH LEVER SHAFT	1	倒缝板手轴	
40	220040041	REVERSE LEVER	1	倒缝操纵杆	
41	220040042	FEED REGULATOR PIN	1	针距调节倒板销	
42	220040043	FEED REGULATOR	1	针距调节器	

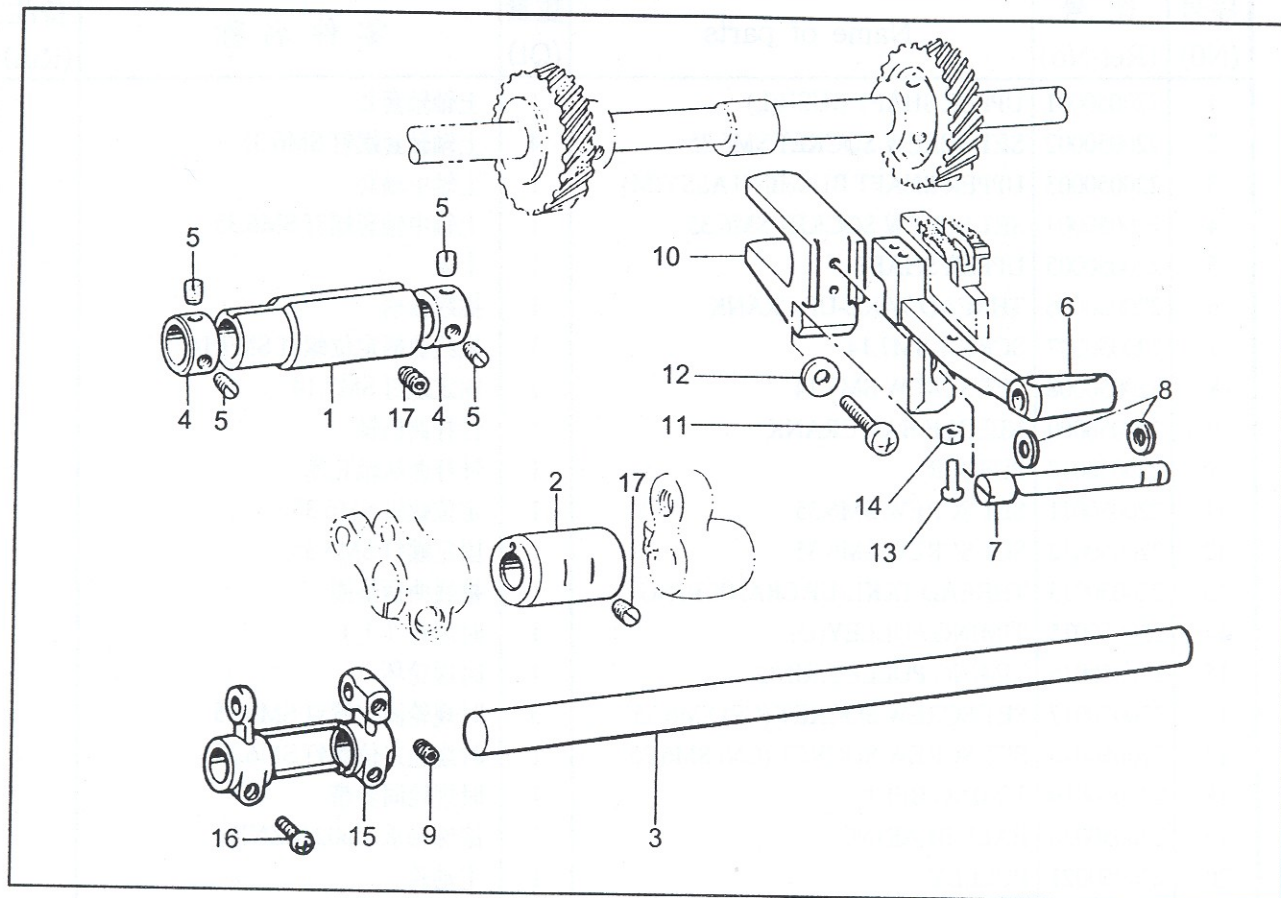
(五) 上轴机构 / Upper shaft mechanism



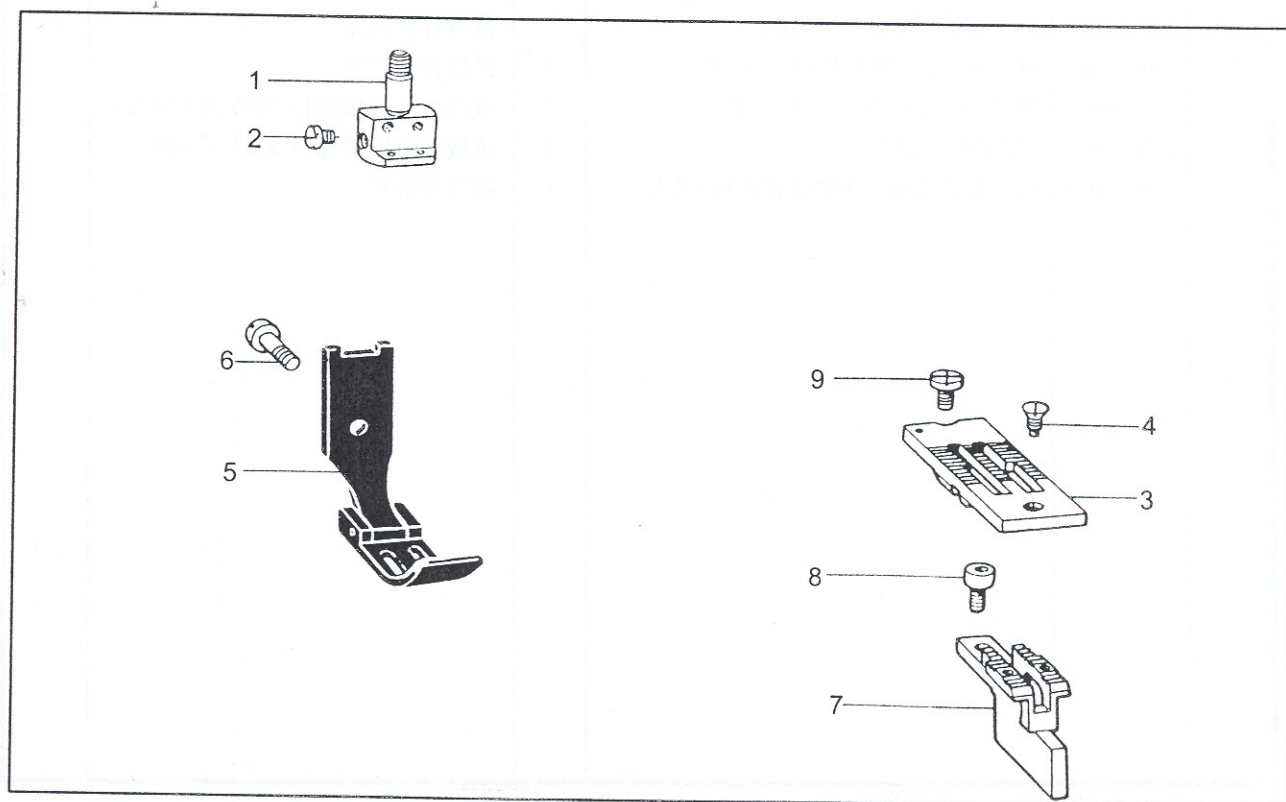
(五) 上轴机构 / Upper shaft mechanism

序号 (N0)	图 号 (Ref-No)	Name of parts	数量 (Qt)	零 件 名 称	备注 (Rm)
1	220050001	UPPER SHAFT BUSH(L)	1	上轴轴套 L	
2	220050002	SET SCREW SOCKET SM6.35	4	上轴轴套螺钉 SM6.35	
3	220050003	UPPER SHAFT BUSHING ASSY(M)	1	上轴中轴套	
4	220050004	SET SCREW SOCKET SM6.35	1	上轴中轴套螺钉 SM6.35	
5	220050005	UPPER SHAFT	1	上轴	
6	220050006	THREAD TAKE-UP CRANK	1	挑线曲柄	
7	220050007	SCREW SM7.14	1	挑线曲柄定位螺钉 SM7.14	
8	220050008	SET SCREW SM7.14	1	固定螺钉 SM7.14	
9	220050009	NEEDLE BAR CRANK	1	针杆曲柄轴	
10	220050010	PUSHER	1	针杆曲柄轴孔塞	
11	220050011	SET SCREW SM6.35	1	定位螺钉 SM6.35	
12	220050012	SET SCREW SM6.35	1	固定螺钉 SM6.35	
13	220050013	THREAD TAKE-UP CRANK RING	1	挑线曲柄垫圈	
14	220050015	TIMING PULLEY(U)	1	时规轮 (上)	
15	220050016	TIMING PULLEY RING	1	时规轮环	
16	220050017	SET SCREW SOCKET (CP) SM6.35	3	时规轮固定螺钉 SM6.35	
17	220050018	SET SCREW SOCKET (CN) SM6.35	1	时规轮定位螺钉 SM6.35	
18	220050019	TIMING BELT	1	时规轮同步带	
19	220050020	BALL BEARING	1	滚珠轴承 (6024ZZNR)	
20	220050021	PULLEY	1	主动轮	
21	220050022	SET SCREW SM5.95	2	主动轮螺钉 SM5.95	
22	220050023	THREAD TAKE-UP	1	挑线杆	
23	220050024	THREAD TAKE-UP SHAFT	1	挑线杆铰链轴	
24	220050026	SET SCREW SOCKET SM6.35	3	挑线杆防护罩	
25	220050025	THREAD TAKE-UP COVER	1	挑线杆铰链轴螺钉 SM6.35X28/10	
26	220050027	SCREW SM3.57	2	挑线杆防护罩螺钉 SM3.57X40-5	
27	220050028	THREAD TAKE-UP SLIDE BLOCK	1	挑线杆滑套	

(五) 送料部件 / Feed shaft mechanism



(六) 量规零件 / Gauge Parts



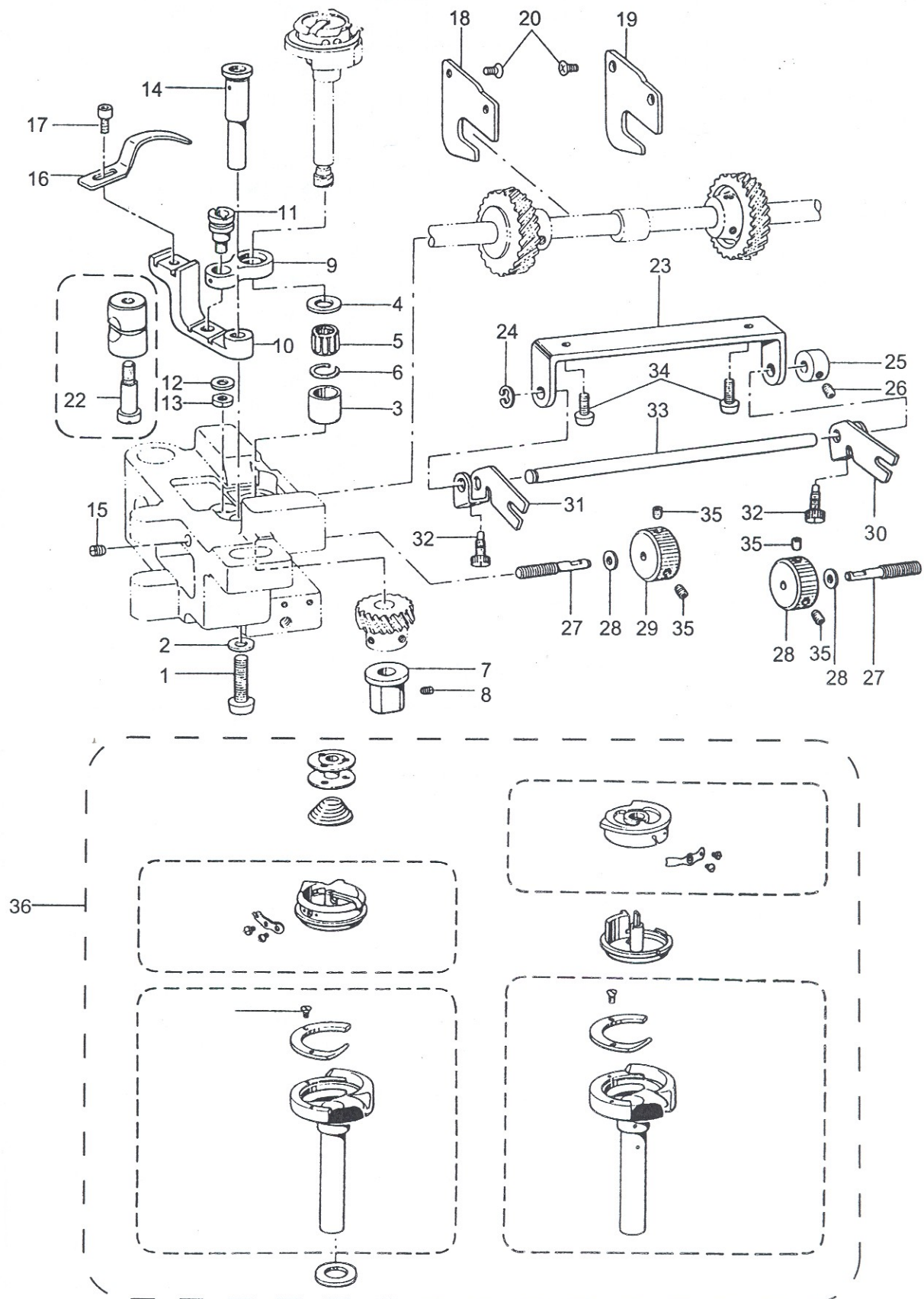
(五) 送料部件 / Feed shaft mechanism

序号 (N0)	图 号 (Ref.No)	Name of parts	数量 (Qt)	零 件 名 称	备注 (Rm)
1	220060001	FEED SHAFT BUSH(L)	1	送布轴轴套 (L)	
2	220060002	FEED SHAFT BUSH(R)	1	送布轴轴套 (R)	
3	220060003	FEED ROCK SHAFT	1	送布轴	
4	220060004	SET SCREW COLLAR	2	送布轴紧圈	
5	220060005	SET SCREW SM6.35	4	送布轴紧圈螺钉 SM6.35	
6	220060006	FEED BAR	1	牙架体	
7	220060007	FEED BAR SHAFT	1	牙架轴	
8	220060008	THRUST RING	2	牙架轴止堆环	
9	220060009	SET SCREW SOCKET SM65.95	1	牙架轴固定螺钉 SM5.95X28	
10	220060010	FEED BAR FORK	1	抬牙叉	
11	220060011	SCREW PAN SM5.95	1	抬牙叉螺钉 SM5.95X28-14	
12	220060012	WASHER PLAIN	1	抬牙叉螺钉垫圈	
13	220060013	SCREW PAN SM3.18	1	支撑送布牙螺钉 SM3.18X40-12	
14	220060014	NUT SM3.18	1	支撑送布牙螺母 SM3.18	
15	220060015	FEED ROCK ARM	1	牙架曲柄	
16	220060016	SCREW PAN SM4.37	2	牙架曲柄螺钉 SM4.37X40-12	
17	220060017	SET SCREW SM6.35	2	送布轴套螺钉 SM6.35	

(六) 量规零件 / Gauge Parts

序号 (N0)	图 号 (Ref.No)	Name of parts	数量 (Qt)	零 件 名 称	备注 (Rm)
1	2200B0001	NEEDLE CLAMP	1	针夹	
2	2200B0002	SCREW SM3.57	2	针夹螺钉	
3	2200B0003	NEEDLE PLATE	1	针板	
4	2200B0004	SCREW SM4.37	1	针板螺钉	
5	2200B0005	PRESSER FOOT ASSY	1	压脚组件	
6	2200B0007	SCREW SM3.57	1	压脚螺钉 SM3.57	
7	2200B0008	FEED DOG	1	送布牙	
8	2200B0009	SCREW SM3.18	2	送布牙螺钉 SM3.18X44	
9	2200B0010	SCREW SM4.37	1	针板固定螺钉 SM4.37	

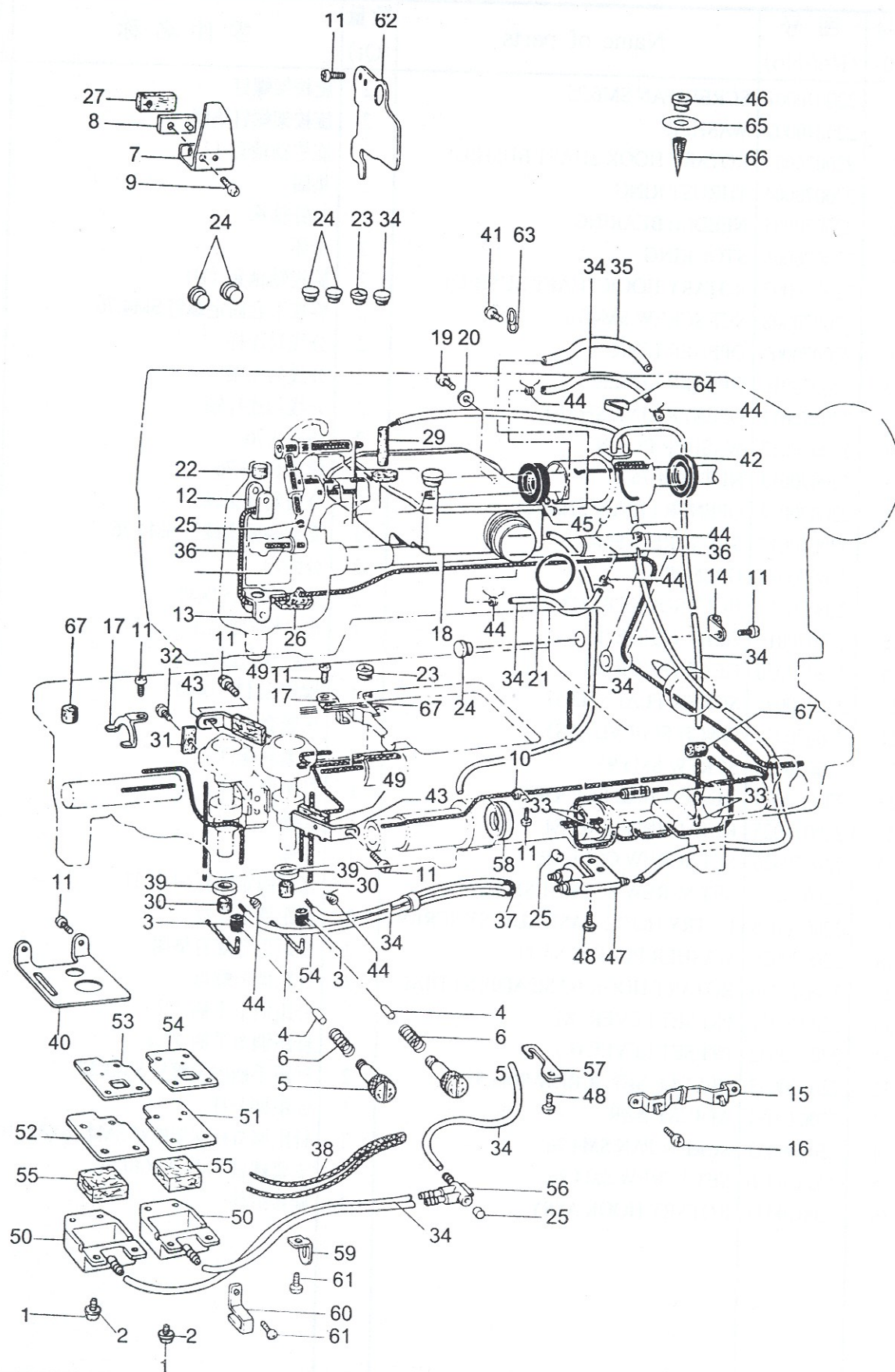
(七) 旋梭部件 / Rotary hook mechanism



(七) 旋梭部件 / Rotary hook mechanism

序号 (N0)	图 号 (Ref.No)	Name of parts	数量 (Qt)	零 件 名 称	备注 (Rm)
1	220070001	SCREW PAN SM6.35	2	旋梭架螺钉	
2	220070002	WASHER	2	旋梭架螺钉垫圈	
3	220070003	ROTARY HOOK SHAFT BUSH(U)	2	旋梭轴轴套 (U)	
4	220070004	THRUST RING	2	垫圈	
5	220070005	NEEDLE BEARING	2	滚针轴承	
6	220070006	STOP RING	2	卡环	
7	220070007	ROTARY HOOK SHAFT BUSH(D)	2	旋梭轴轴套 (D)	
8	220070008	SET SCREW SM4.76	2	旋梭下套固定螺钉 SM4.76	
9	220070009	OPENER LINK	2	分线勾连杆	
10	220070010	OPENER LEVER	2	分线勾支架	
11	220070011	OPENER LINK SHAFT	2	分线勾连杆轴	
12	220070012	WASHER PLAIN	2	垫圈 4.76	
13	220070013	NUT SM4.76	2	螺母 SM4.76	
14	220070014	OPENER LEVER SHAFT	2	分线勾支架轴	
15	220070015	SET SCREW SM4.76	2	支架轴固定螺钉 SM4.76	
16	220070016	OPENER	2	分线勾	
17	220070018	BOLT SOCKET SM3.57	2	螺栓 SM3.57X40	
18	220070019	GEAR GUIDE (L)	1	齿轮导向板(L)	
19	220070020	GEAR GUIDE (R)	1	齿轮导向板 (R)	
20	220070021	SCREW FLAT SM3.57	4	螺钉 SM3.57X40	
21	220070022	PINCH SLEEVE ASSY	2	压紧套	
22	220070023	SCREW SM5.95	2	压紧套螺钉	
23	220070024	ADJUST BAR SUPPORT	1	针距调节杆支架	
24	220070025	RETAINING RING E4	1	挡圈	
25	220070026	SET SCREW COLLAR	1	紧圈	
26	220070027	SET SCREW SOCKET SM4.37	5	紧圈固定螺钉 SM4.37	
27	220070028	ROTRY HOOK BASE ADJUST SCREW	2	针距调节螺钉	
28	220070029	WASHER PLAIN S4.37	2	针距调节螺钉垫圈	
29	220070030	ROTARY HOOK BASE ADJUST DIAL	2	针距调节螺母	
30	220070031	PRESET LEVER (R)	1	针距调节手柄 (R)	
31	220070032	PRESET LEVER (L)	1	针距调节手柄 (L)	
32	220070033	NEEDLE SET SCREW SM3.57	2	针距手柄固定螺钉 SM3.57	
33	220070034	ADJUST BAR	1	针距调节杆	
34	220070035	SCREW PAN SM4.76	2	针距调节杆支架螺钉 SM4.76X32-10	
35	220070036	SET SCREW SM4.76	4	支紧螺钉 SM4.37X40/6	
36	220070037	ROTARY HOOK ASSY	2	旋梭组件	

(八) 给油系统 / Lubrication mechanism



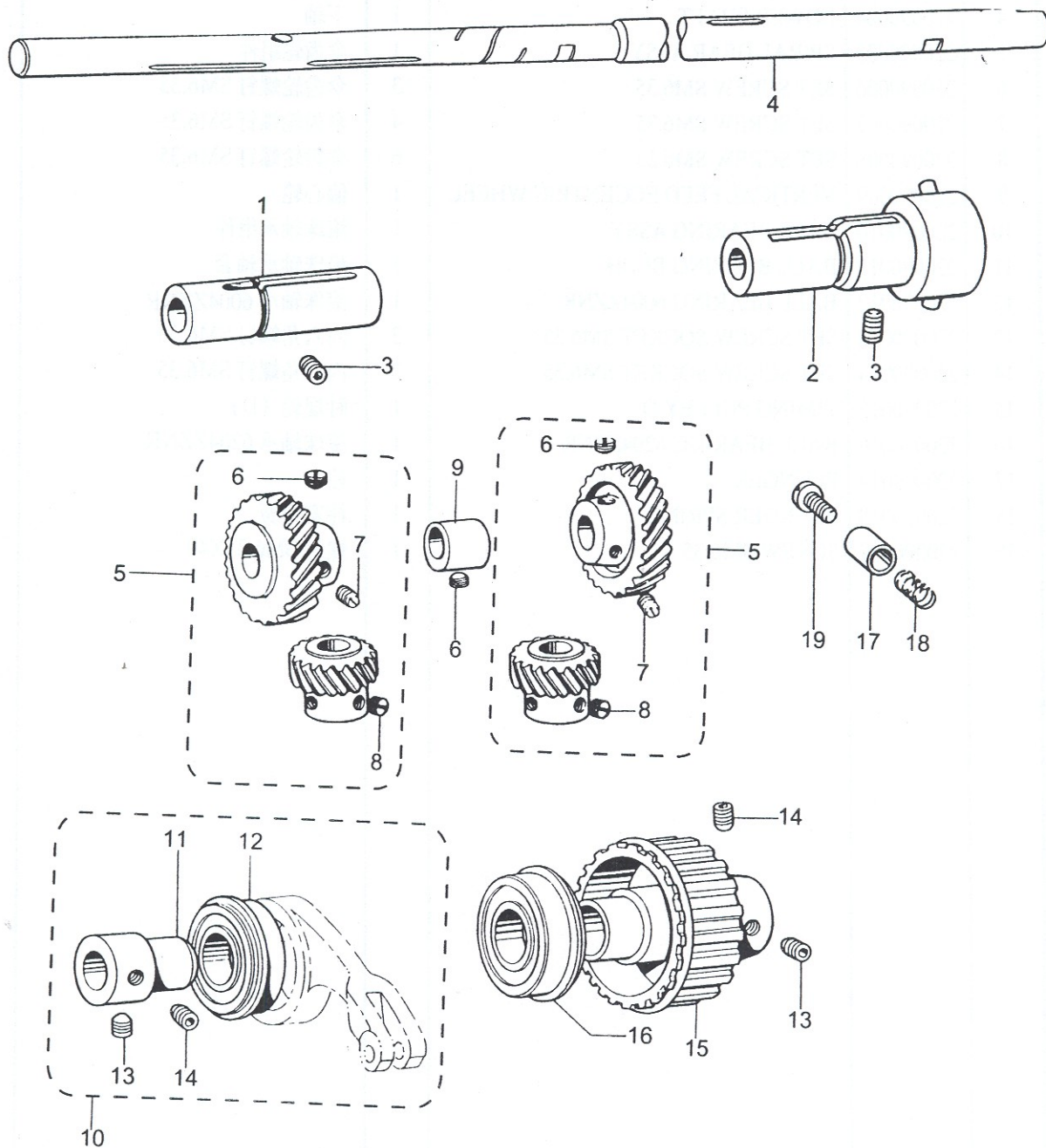
(八) 给油系统 / Lubrication mechanism

序号 (N0)	图 号 (Ref.No)	Name of parts	数量 (Qt)	零 件 名 称	备注 (Rm)
1	220080001	SCREW PAN SM3.57	8	油盒螺钉 SM3.57X40-8	
2	220080001-1	WASHER	8	垫圈	
3	220080002	RUBBER RING	2	橡皮塞	
4	220080003	RUBBER PRESSER	2	橡皮锥销	
5	220080004	OIL ADJUST SCREW	2	油量调节螺钉	
6	220080005	OIL ADJUST SPRING	2	油量调节弹簧	
7	220080006	OIL STOPPER PLATE	1	防油侧板	
8	220080007	OIL STOPPER PLATE PRESSER	1	防 油侧板块	
9	220080008	SCREW PAN SM4.76	1	防油板螺钉 SM4.76 X32-12	
10	220080009	WICK SUPPORT	1	油线夹	
11	220080010	SCREW BIND SM3.57	11	油线夹螺钉 SM3.57X40-5	
12	220080011	FELT SUPPORT (U)	1	滤油毡压簧 (U)	
13	220080012	FELT SUPPORT (D)	1	滤油毡压簧 (D)	
14	220080013	WICK SUPPORT	1	油线夹	
15	220080014	WICK SUPPORT	1	针距调节曲柄油线夹	
16	220080015	SCREW PAN SM3.18	2	油线夹螺钉 SM3.18X40-4	
17	220080016	WICK HOLDER	2	油线支座	
18	220080017	OIL TANK ASSY	1	油箱装配图	
19	220080018	SCREW PAN SM4.76	2	螺钉 SM4.76X32-10	
20	220080019	WASHER PLAIN M4.76	2	垫圈	
21	220080020	O RING P30	1	O 型图	
22	220080021	NEEDLE BAR CAP	1	针杆橡皮塞	
23	220080022	OIL CAP	2	橡皮塞	
24	220080023	OIL CAP	7	橡皮塞	
25	220080024	OIL CAP	3	橡皮塞	
26	220080025	FELT	1	回油滤油毡	
27	220080026	FELT THREAD TAKE-UP	1	挑线杆油线	
28	220080027	FELT UPPER SHAFT L	1	上轴轴套油毡	
29	220080028	FELT	1	油毡	
30	220080029	CLUTCH FELT	2	滤油毡	
31	220080030	FELT	1	牙架叉油毡	
32	220080031	SCREW SM3.57	1	牙架叉油毡螺钉 SM3.57X40-6	
33	220080032	FELT	4	滤油塞	
34	220080033	OIL TUBE		油线套	
35	220080034	OIL TUBE		油线套	
36	220080035	WICK 4X4		油线 4X4	
37	220080036	WICK		油线	
38	220080037	WICK		油线	

(八) 给油系统 / Lubrication mechanism

序号 (NO)	图号 (Ref-No)	Name of parts	数量 (Qt)	零件名称	备注 (Rm)
39	220080038	SPACER	2	垫圈	
40	220080039	DUST PROTECTOR	1	防尘保护架	
41	220080040	SCREW PAN SM3.57	1	固定螺钉 SM4.37X40-8	
42	220080041	OIL SEAL	1	油封	
43	220080042	FELT PRESSER	2	滤油塞支架	
44	220080043	TUBE CLIP	11	油线夹簧	
45	220080044	OIL SEAL	1	油封垫	
46	220080045	OIL CAP	1	橡皮塞	
47	220080046	TERMINAL	1	接线栓	
48	220080047	SCREW PAN SM3.57	3	螺钉 SM3.57X40-6	
49	220080048	FELT	2	滤油塞	
50	220080049	SUB-TANK	2	油箱	
51	220080050	OIL SEAL R SUB-TANK	1	油封垫 (左)	
52	220080051	OIL SEAL L SUB-TANK	1	油封垫 (右)	
53	220080052	SUB-TANK COVER R	1	油封盖 (右)	
54	220080053	SUB-TANK COVER L	1	油封盖 (左)	
55	220080054	FELT SUB-TANK	2	滤油塞	
56	220080055	TERMINAL L	1	油管接头 L	
57	220080056	TUBE SUPPORT BRACKET	1	油管支架 R	
58	220080057	OIL SEAL PLUNGER PUMP	1	油封	
59	220080058	TUBE SUPPRT BRACKET L	1	油管支架 L	
60	220080059	OIL TUBE SUPPORT	1	油管支架	
61	220080060	SCREW PAN SM4.76	2	油管支架螺钉 SM4.76X32-6	
62	220080061	INTERRUPT PLATE	1	挡油板	
63	220080062	TUBE SUPPORT	1	油箱油管支架	
64	220080063	TUBE CALKING	1	油管夹	
65	220080065	OIL MADE SHEET	1	油窗注油薄片	
66	220080066	OIL FILTER	1	过滤网	
67	220080067	FELT	3	滤油毡	

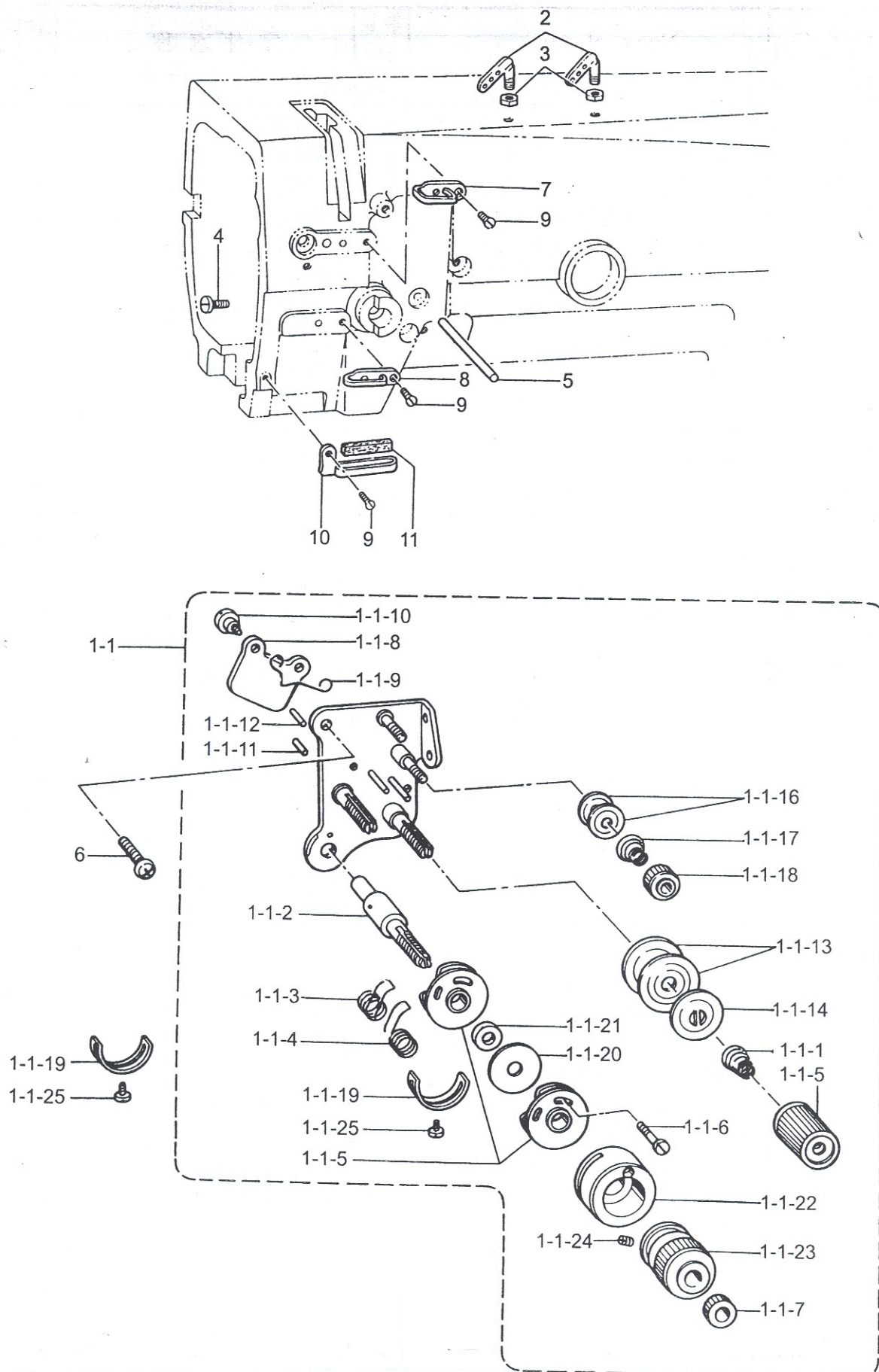
(九) 下轴部件 / Lower shaft mechanism



(九) 下轴部件 / Lower shaft mechanism

序号 (NO)	图 号 (Ref.No)	Name of parts	数量 (Qt)	零 件 名 称	备注 (Rm)
1	220090001	ROTARY HOOK BASE BUSH L	1	旋梭支架轴套 L	
2	220090002	ROTARY HOOK BASE BUSH R	1	旋梭支架轴套 R	
3	220090003	SET SCREW SOCKET SM6.35	2	下轴轴套螺钉 SM6.35X28	
4	220090004	LOWER SHAFT	1	下轴	
5	220090005	SPIRAL GEAR ASSY	1	伞齿轮组件	
6	220090006	SET SCREW SM6.35	3	伞齿轮螺钉 SM6.35	
7	220090007	SET SCREW SM6.35	4	伞齿轮螺钉 SM6.35	
8	220090008	SET SCREW SM6.35	6	伞齿轮螺钉 SM6.35	
9	220090009	VERTICAL FEED ECCENTRIC WHEEL	1	偏心轮	
10	220090010	BALL BEARING ASSY	1	滚珠轴承组件	
11	220090011	BALL BEARING BUSH	1	滚珠轴承轴套	
12	220090012	BALL BEARING 6004ZZNR	1	滚珠轴承 6004ZZNR	
13	220090013	SET SCREW SOCKET SM6.35	2	内六角螺钉 SM6.35	
14	220090014	SET SCREW SOCKET SM6.35	2	内六角螺钉 SM6.35	
15	220090015	TIMING PULLEY D	1	时规轮 (D)	
16	220090016	BALL BEARING 6204ZZNR	1	滚珠轴承 6204ZZNR	
17	220090017	PLUNGER	1	柱塞	
18	220090018	PLUNGER SPRING	1	柱塞弹簧	
19	220090019	SCREW SM6.35	1	螺钉 SM6.35X40	

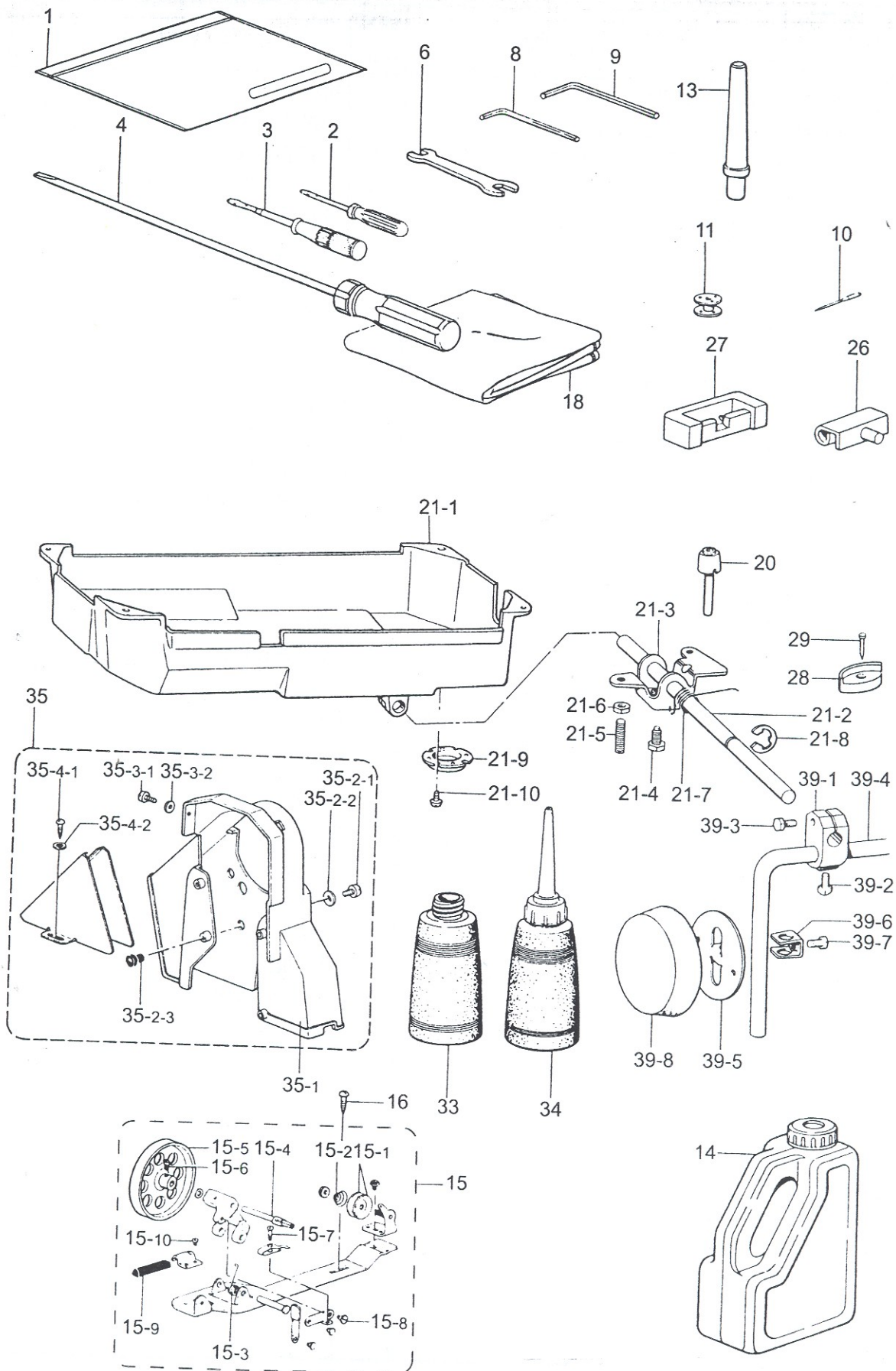
(十) 过线部件 / Threading mechanism



(十) 过线部件 / Threading mechanism

序号 (N0)	图 号 (Ref.No)	Name of parts	数量 (Qt)	零 件 名 称	备注 (Rm)
1-1	2200A0001	UPPER THREAD TENSION ASSY	1	夹线器组件	
1-1-1	2200A0002	SPPING TENSION ADJUST	2	夹线弹簧	
1-1-2	2200A0003	TENSION STUP	1	夹线器轴	
1-1-3	2200A0004	THREAD TAKE-UP SPRING L	1	夹线弹簧 L	
1-1-4	2200A0005	THREAD TAKE-UP SPRING R	1	夹线弹簧 R	
1-1-5	2200A0006	TENDION SPRING GUIDE ASSY	2	挑线簧过线板	
1-1-6	2200A0007	SCREW SM3.38	1	挑线板螺钉 SM2.38	
1-1-7	2200A0008	TENSION NUT	1	夹线调节螺母 (小)	
1-1-8	2200A0009	TENDION RELEASE PLATE	1	挺线板	
1-1-9	2200A0010	SPRING TENSION RELEASE	1	挺线弹簧	
1-1-10	2200A0011	SHOULDER SCREW SM3.57	2	轴位螺钉 SM3.57X40	
1-1-11	2200A0012	PIN TANSION RELEASE L	1	挺线钉 L	
1-1-12	2200A0013	PINTANSION RELEASE R	1	挺线钉 R	
1-1-13	2200A0014	TENSION DISC	4	夹线板	
1-1-14	2200A0015	TENSION DISC PRESSER	2	夹线调节螺母 (大)	
1-1-15	2200A0016	TENSION NUT	2	松线板	
1-1-16	2200A0017	THREAD GUIDE DISC	4	小夹线板	
1-1-17	2200A0018	SPRING PRE-TENSION	2	小夹线弹簧	
1-1-18	2200A0019	TENSION NUT	2	小夹线调节螺母	
1-1-19	2200A0020	TENSION SPRING STOPPER	2	挑线簧限位板	
1-1-20	2200A0021	SPACER	2	垫圈	
1-1-21	2200A0022	COLLAR	1	垫圈垫块	
1-1-22	2200A0023	STOPPER SUPPORT	1	夹线调节座	
1-1-23	2200A0024	ADJUST THUMB	1	异形调节螺母	
1-1-24	2200A0025	SET SCREW SM3.18	1	支紧螺钉 SM3.18	
1-1-25	2200A0026	SCREW PAN SM3.57X40-5	2	三眼线勾螺钉 SM5.95X28	
2	2200A0044	THREAD RETAINER	2	挑线簧限位板螺钉 SM3.5740-5	
3	2200A0027	NUT SM5.95	2	螺母 SM5.95X28	
4	2200A0028	SCREW SM3.57	1	夹紧螺钉 SM3.57	
5	2200A0029	TENSION RELEASE BAR	1	松线顶杆	
6	2200A0030	SCREW PAN SM4.37X40-8	1	螺钉 SM4.37X40-8	
7	2200A0031	ARM THREAD GUIDE (U)	1	机壳过线勾 (V)	
8	2200A0032	ARM THREAD GUIDE (M)	1	机壳过线勾 (M)	
9	2200A0033	SCREW FLAT SM3.57	1	机壳过线勾螺钉 SM3.57X40-5	
10	2200A0034	ARM THREAD GUIDE (D)	1	机壳过线勾 (D)	
11	2200A0035	FELT	1	机壳过线勾 (D) 羊毛毡	

(十一) 附件部件 / Accessories parts



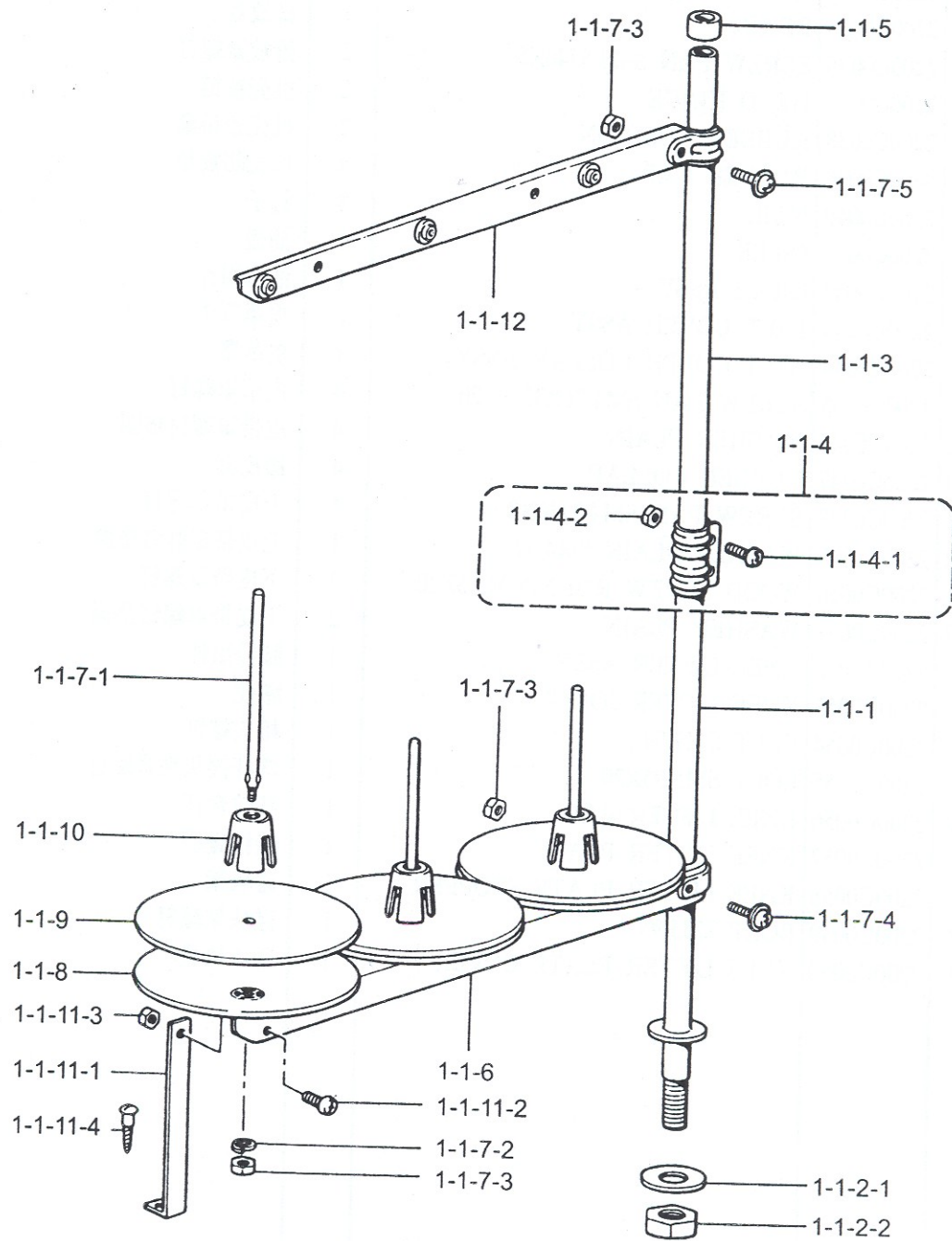
(十一) 附件部件 / Accessories parts

序号 (N0)	图 号 (Ref.No)	Name of parts	数量 (Qt)	零 件 名 称	备注 (Rm)
1	2200C0001	ACCESSORY BAG	1	附件塑料袋	
2	2200C0002	SCREW DRIVR 1.9X52	1	小起子 1.9X52	
3	2200C0003	SCREW DRIVR 3.4X70	1	小起子 3.4X70	
4	2200C0004	SCREW DRIVR 4.7X250	1	大起子 4.7X250	
6	2200C0005	WRENCH 8X9	1	双头扳手 8X9	
8	2200C0006	HEXAGONAL WRENCH 2	1	内六角扳手 (2)	
9	2200C0007	HEXAGONAL WRENCH 3	1	内六角扳手 (3)	
10	2200C0008	NEEDLE DPX5(#22)	4	机针 DDX5(22#)	
11	2200C0009	BOBBIN	4	梭心	
13	2200C0010	HEAD REST	1	机头撑杆	
14	2200C0011	OIL TANK	1	油箱	
15	2200C0012	BOBBIN WINDER ASSY	1	绕线器组件	
15-1	2200C0013	TENSION DISC	2	过线架夹线板	
15-2	2200C0014	TENSION SPRING	1	过线架夹线弹簧	
15-3	2200C0015	SPRING	1	绕线架弹簧	
15-4	2200C0016	BOBBIN WINDER SHAFT	1	绕线轴	
15-5	2200C0017	BOBBIN WINDER	1	绕线轮	
15-6	2200C0018	SET SCREW (FT)SM4.37X5	1	绕线轮螺钉	
15-7	2200C0019	SCREW SM3.18	1	绕线跳板螺钉	
15-8	2200C0020	SHOULDER SCREW SM3.18	2	铆钉	
15-9	2200C0021	BOBBIN WINDER WHEEL STOPPER	1	止动块	
15-10	2200C0022	SCRERR PAN SM3.57X40-3.5	1	止动块固定勾螺钉	
16	2200C0023	WOOD SCREW ROUND M5.5X20	1	下皮带罩螺钉	
18	2200C0024	HEAD COVER	1	机壳外罩	
20	2200C0025	KNEE LIFTER COMPLYING BAR	1	膝控提升顶杆	
21	2200C0026	OIL PAN ASSY	1	油盘组件	
21-1	2200C0027	OIL PAN	1	油盘	
21-2	2200C0028	KNEE LIFTER SHAFT	1	膝控铰链轴	
21-3	2200C0029	KNEE LIFER	1	膝控限位架	
21-4	2200C0030	BOLT SM5.95	1	膝控限位架螺钉	
21-5	2200C0031	SET SCREW SM5.95	2	膝控限位调节螺钉	

(十一) 附件部件 / Accessories parts

序号 (N0)	图号 (Ref.No)	Name of parts	数量 (Qt)	零件名称	备注 (Rm)
21-6	2200C0032	NUT SM5.95	2	调节螺钉螺母	
21-7	2200C0033	TWIST SPRING	1	膝控复位簧	
21-8	2200C0034	RETAINING RING E10	1	挡圈	
21-9	2200C0035	DRAIN	1	排放器	
21-10	2200C0036	SCREW PAN SM3.5740X5	2	排放器螺钉	
26	2200C0037	HEAD HINGE	2	机壳铰链	
27	2200C0038	RUBBER CUSHION	2	机壳铰链套	
28	2200C0039	RUBBER CAP	4	机壳防震垫	
29	2200C0040	NAIL	8	钉子	
33	2200C0041	OILER	1	油壶	
34	2200C0042	OILER ASSY	1	油壶组件	
35	2200C0043	BELT COVER ASSY	1	皮革罩牛	
35-1	2200C0044	BELT COVER COLLAR ASSY	1	皮革罩	
35-2-1	2200C0045	SCREW PAN SM4.76X32 - 20	4	皮革罩螺钉	
35-2-2	2200C0046	WASHER PLAIN	4	皮带罩螺钉垫圈	
35-2-3	2200C0047	RUBBER COLLAR	4	橡皮套	
35-3-1	2200C0048	SCREW PAN SM4.3740X8	1	上皮带罩螺钉	
35-3-2	2200C0049	WASHER PLAIN SM4.37	1	上皮带罩螺钉垫圈	
35-4-1	2200C0050	WOOD SCREW ROUND M5.5X20	2	下皮带罩螺钉	
35-4-2	2200C0051	WASHER PLAIN	2	下皮带罩螺钉垫圈	
39	2200C0052	KNEE LIFTER ASSY	1	膝控组件	
39-1	2200C0053	KNEE LIFTER JOINT	1	膝控	
39-2	2200C0054	BOLT SM7.94	1	接头螺钉	
39-3	2200C0055	BOLT SM5.95X20	1	弯杆接头夹紧螺钉	
39-4	2200C0056	KNEE LIFTER BAR	1	膝控弯杆	
39-5	2200C0057	KNEE LIFTER PLATE	1	膝控碰块	
39-6	2200C0058	KNEE LIFTER PLATE STOPPER	1	碰块架	
39-7	2200C0059	BOLT SM5.95	1	碰块架螺钉	
39-8	2200C0060	KNEE LIFTER PLATE COVER	1	碰块块垫	

(十二) 附件部件 / Accessories parts



(十二) 附件部件 / Accessories parts

序号 (N0)	图 号 (Ref.No)	Name of parts	数量 (Qt)	零 件 名 称	备注 (Rm)
1-1-1	2200D0001	COLUMN PIPE(D)	1	绕架下撑管	
1-1-2-1	2200D0002	WASHER PLAN 16	1	绕架下撑管垫圈	
1-1-2-2	2200D0003	NUT 5/8	1	绕架下撑管螺母	
1-1-3	2200D0004	COLUMN PIPE	1	绕架上撑管	
1-1-4-1	2200D0005	SCREW PAN M5X14	2	撑管夹螺钉	
1-1-4-2	2200D0006	NUT	2	撑管夹螺母	
1-1-5	2200D0007	COLUMN CAP	1	绕架上撑管套	
1-1-6	2200D0008	SPOOL HOLDER	1	下过绕架	
1-1-7-1	2200D0009	SPOOL SHAFT(B)	3	绕轴	
1-1-7-2	2200D0010	WASHER SPRING	3	绕轴弹簧垫圈	
1-1-7-3	2200D0011	NUT	5	撑管夹螺母	
1-1-7-4	2200D0012	SCREW PANM5X32	1	螺钉	
1-1-7-5	2200D0013	SCREW PAN M5X14	1	螺钉	
1-1-8	2200D0014	SPOOL STAND BASE	3	绕盘	
1-1-9	2200D0015	SPOOL MAT	3	绕盘垫	
1-1-10	2200D0016	SPOOL CUSHION	3	绕盘压块	
1-1-11-1	2200D0017	HOLDER SUPPORT(A) SET	1	下过绕架支撑杆	
1-1-11-2	2200D0018	SCREW PAN M5X10	1	固定螺钉	
1-1-11-3	2200D0019	NUT	1	固定螺母	
1-1-11-4	2200D0020	WOOD SCREW ROUND M4.5X22	1	强板上固定螺钉	

厂 名: _____

地 址: _____

电 话: _____