

Model

GN737/747/757

超高速包缝机

SUPER HIGH-SPEED
OVERLOCK SEWING MACHINE

使用说明 零件样本

Operation Manual Parts Book

 - ORIGINAL

34 folhas



中国飞跃缝纫机集团公司

CHINA FEIYUE SEWING MACHINE GROUP CORPORATION

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致使用者：图1.2

我们非常感谢您使用本公司出品之超高速直针锁边缝纫机(拷克车)。

请详细阅读此说明书，将使您更了解本机器独特之性能及正确的使用方法，进而提高您缝制的效率及品质，首先请您注意：请先注入润滑油及确认马达之转向为顺时针方向，才可以开动本机器。

TO THE OPERATORS

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

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

ALAS OPERARIAS

Gracias por utilizar nuestras máquinas overlock o de puntada de seguridad. Antes de empezar a trabajar con la máquina, por favor lean detenidamente este libro de instrucciones para comprender el funcionamiento y las ventajas de esta máquina. Esto os ayudará para aumentar la eficacia y calidad de vuestro trabajo.

A TENCION: Porque ésta es una máquina de alta velocidad, no hacerla funcionar antes de llenar el depósito de aceite y asegurarse que el motor gira en dirección correcta.

POUR LES OPERATRICE

La machine que vous utilisez est une surjeteuse ultra-rapide de grande précision. Avant de démarrer la machine, nous vous conseillons de parcourir minutieusement ce livret pour comprendre les fonctions et les caractéristiques de la machine. Ceci vous permettra d'augmenter votre production et d'obtenir un travail constant et de haute qualité.

A TTENTION: Etant donné qu'il s'agit d'une machine qui tourne à grande vitesse, ne pas la démarrer avant de remplir le réservoir d'huile et de s'assurer que le moteur tourne dans le bon sens.

AS OPERADORAS

Obrigados por utilizarem a nossa máquina de Costura Overlock / ponto de segurança de alte velocidade. Antes de utillzar a máquina, é fundamental estudar atentamente este manual, para compreender as funções e carecterísticas da máquina. Seróum precioso auxilio para aumentar a suaeficiência e qualidade de costura.

CUIDADO: Tratando-se dumamáquina de alta velocidade, não trabalhe com ela antes velocidade, não trabalhe com ela antes de encher o depósito com óleo e assegurar-se de que o motor está a rodar na direccão correcta.

机器安装

(1) 依本机所附桌板裁制图及零件组合图所列之配件，依序安装也震机座铝板半沉式时，机台针板面与桌板面之距离为100mm，全沉式为5mm。

(2) 马达启运踏板装于左边，抬压脚踏板则装于右边。

(3) 按零件图示装置废料槽及线架。

(4) 注意马达之转向为顺时针方向，皮带之松紧度以用手指向内压下缩 10mm 为宜，皮带轮与缝合转速请

参照表 (1)。但常用转速就放为第一档为宜。

HOW TO INSTALL THE MACHINE

(1) Install the machine according to the table cut-out diagram, Cushion Rubber and Rest Board as enclosed. In case of semi-submerged, the distance between Needle plate top surface and Table Top is about 100mm, and for fully-submerged is about 5mm.

(2) Setting the pedal of clutch motor to the left side and the pedal of presser foot lift at right side.

(3) Install the cloth waste chute, thread stand as parts list.

(4) Be sure the motor turning direction is clockwise. And the belt can be pressed inward about 10mm.

NOTE: The dimensions of motor pulley and sewing speed are shown in Table 1.

COMO INSTALAR LA MAQUINA

(1) Montar la maquina en el tablero cortado, de acuerdo con el diagrama que se adjunta sobre los tacos de goma y el plato base. En case de ser semisumergida, la distancia entre la superficie del placa-aguja y el tablero, será de 100mm. y de 5mm. cuando la queramos totalmente sumergida.

(2) Montar el pedal del embrague del motor a la izquierda y el alzapatas a la derecha.

(3) Montar el guia-retales, porta-conos y demás accesorios que se adjuntan.

(4) Asegurarse que el motor gira en sentido de las agujas del reloj. La tensión en la correa del motor será correcta si empujando con el dedo en el centro, puede desplazarse aproximadamente 10mm.

NOTA: Las dimensiones de la polea del motor y la velocidad de la máquina, están en la tabla 1.

INSTALLTION DE LA MACHINE

(1) La machine doit être installée sur une table dont l'entaille correspond à son gabarit. La machine est livrée avec des amortisseurs en caoutchouc et un contre-plateau. Pour un montage en semi-submergé, la distance entre la surface supérieure de la plaque aiguille et la table doit être environ 10mm. Pour un montage en submergé la distance est d'environ 5mm.

(2) Monter la pédale du moteur à gauche et la pédale du relevage du pied presseur à droite.

(3) Fixer la goulotte et le porte-bobines tel que montre la liste des pièces.

(4) S'assurer que le moteur tourne dans le sens des aiguilles d'une montre. Régler le moteur de sorte que la courroie ne soit pas ni trop tendue ni trop lâche un pincement de 10mm est suffisant.

NOTA: Pour la relation entre les dimensions de la poulie et la vitesse de la machine voir tableau N° 1.

INSTALACAO DA MAQUINA

(1) Instale a máquina numa mesa cujo corte para entalhe corresponda à dimensão da máquina, conforme diagrama anexo. A máquina é fornecida com amortecedores de borracha e uma placa base. Para obter a posição semisubmersa, a distância entre a superfície superior do prato da agulha e a superfície da mesa deve ser de 100mm, e para uma submersão completa, deve ser de 5mm.

(2) Monte o pedal do motor à esquerda e o pedal de elevação do calçador à direita.

(3) Instale a guia do tecido e o portaconos, de acordo com a lista de peças.

(4) Certifique-se de que o motor roda no sentido dos ponteiros do relógio. A tensão da correia do motor estará correcta, se se deslocar cerca de 10mm quando pressionado com o dedo.

NOTA: consulte o Quadro 1 sobre a relação entre as dimensões da polia e a velocidade da máquina.

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

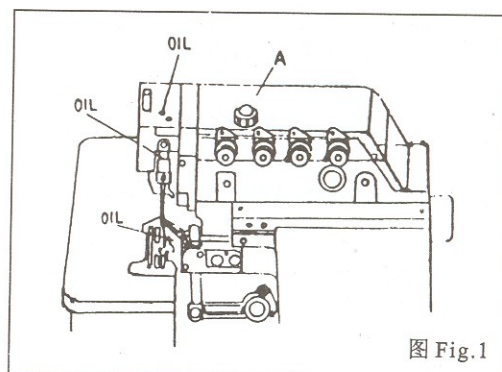


图 Fig.1

新机器之启用规定

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

HOW TO OPERATE THE NEW MACHINE

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

COMO TRABAJAR CON LA MAQUINA

Por favor rodar la máquina a un 20% por debajo de la velocidad máxima durante las primeras 4 semanas. Luego sacar el aceite y cambiarlo por nuevo. Después la máquina puede ponerse a la máxima velocidad.

FONCTIONNEMENT DE LA MACHINE

Une machine neuve doit être. Pour les quatre premières semaines, la faire tourner à 20% en moins de sa vitesse maxi. Après cette période de rodage, remplacer l'huile et après quoi on peut travailler à la vitesse maxi.

FUNCIONAMENTO DA MAQUINA

A nove máquina deve ser rodada durante as quatro primeiras semanas, a uma velocidade inferior em 20% à velocidade máxima. Em seguida, substitua o óleo, podendo ser então rodada à velocidade máxima.

润滑油之注入与更换

(1) 润滑油之注入 图1

• 将螺丝 A 旋开，以包装箱内所附之超高速润滑油或选用 MOBIL # 10 或 AGIP 等相当之机油加入，使油量指示杆位于油标上下之间即可，然后再锁紧螺丝 A。

• 开箱新机器或久置未使用重新要用时，请在针棒、上勾针台等加油润滑。

(2) 润滑油之更换 图2

• 将螺丝 A 放松旋开，使油完全排出后再锁紧。

- 为延长本机器之寿命，请于开始使用四个星期更换新油后约四个月更换一次。
- 本机器特别装有滤油器，约每使用一个月后卸下清洗，必要时更换新品。

(3) 针之冷却油

使用油：硅油 (SILICON OIL)

LUBRICATION AND DRAINAGE

(1) Lubrication Fig.1

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

(2) Drainage Fig.2

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

(3) Needle Cooling Lubrication-Silicon oil.

LUBRIFICACION Y VACIADO DEL ACEITE

(1) Vaciado del aceite Fig.1

- Quitar el tapón de llenado A y poner aceite de lubricación a alta velocidad (MOBIL#10, ESSO#32. similar), hasta que la cabeza del flotador quede entre las dos líneas en la mirilla de nivel. Poner el tapón A.
- Cuando la máquina trabaja por primera vez o ha estado parada mucho tiempo, por favor asegurarse que el aceite llegue a la guía de la barra aguja, a la guía del ancla superior, etc. antes de empezar a trabajar normalmente.

(2) Vaciado del aceite. Fig.2

- Quitar el tapon A y dejar salir todo el aceite, después poner nuevamente el tapón A.
- Para mantener una buena lubricación y vida de la máquina, por favor cambiar el aceite a la máquina nueva después de trabajar las 4 primeras semanas. Después cambiar el aceite cada cuatro meses y rellenar siempre que sea necesario.
- Esta máquina ha sido fijada con filtro de aceite. Por favor limpiar el filtro del aceite cada mes y cambiarlo por uno nuevo cuando sea necesario.

(3) Lubricación y refrigeración de las agujas-Silicona.

LUBRIFICATION ET VIDANGE

Lubrication Fig.1

- Retirer la vis bouchon A et remplir le réservoir avec de l'huile ultra rapide (bidon dans accessoires) ou (une huile similaire à Mobil#10, Esso#32) le niveau de l'huile doit se trouver entre les deux lignes du voyant. Remettre la vis bouchon A.
- Lorsque la machine est mise en route pour la première fois ou bien si elle n'a pas travaillé pendant une longue période, il faut mettre quelques gouttes d'huile sur la bielle de commande du crochet supérieur et ceci avant de faire tourner la machine.

(2) Vidange Fig.2

- enlever la vis A, drainer l'huile puis remettre la vis A.
- Pour assurer une lubrification adéquate, il faut remplacer l'huile après les quatre premières semaines, puis la remplacer tous les quatre mois.

• Cette machine est dotée d'un filtre à huile, celui-ci doit être nettoyé une fois par mois ou le remplacer si c'est nécessaire.

(3) Lubrification du refroidisseur d'aiguille - Utiliser du Silicone.

LUBRIFICACAO E ESCOAMENTO

(1) Lubrificação (Fig.1)

• Remova o parafuso A e encha com óleo de lubrificação de alta velocidade (ou semelhante ao Mobil#10, Esso#32) até ao nível superior do indicador do óleo entre as duas linhas do Visor do Nível do óleo. Volte a colocar o parafuso A.

• Quando se utiliza a máquina pela primeira vez, ou quando esteve muito tempo inoperante, certifique-se de que lubrifica a parte superior da guia do porta-agulhas, a guia superior da lancadeira, antes de pôr a máquina em funcionamento.

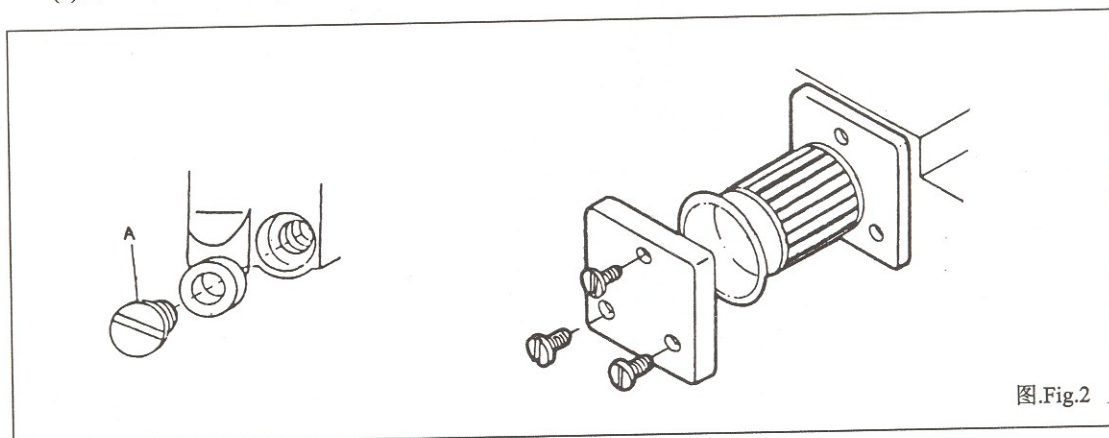
(2) Escoamento (Fig.2)

• Remova o parafuso A e encoe o óleo; volte a colocar o parafuso A.

• Para manter uma boa lubrificação e garantir a longevidade da máquina, mude o óleo ao fim das primeiras quatro semanas de funcionamento, e, depois disso, de quatro em quatro meses.

• Esta máquina está equipada com um filtro de óleo. Limpe-o mensalmente e substitua-o quando necessário.

(3) Lubrificação e refrigeração das agulhas use silicone.



穿线方法 图3,4

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

THREADING THE MACHINE Fig3,4

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

ENHEBRADO DE LAS MAQUINA Fig3,4

Enhebrar la máquina correctamente según su diagrama de enhebrado. Un enhebrado incorrecto nos pued causar rotura del hilo, mal ajuste de la puntada, fallos en la misma, etc.

ENFILAGE DE LA MACHINE Fig3,4

Se référer à l'enfilage qui correspond au modèle de la machine utilisée. Si l'enfilage est incorrect on risque des casse de fil, des points de manque, une couture irrégulière et grignée.

COME ENFIAR A MAQUINA Fig3, 4

Ajuste o tipo de enfiamento ao modelo da máquina utilizada. Um enfiamento incorreto pode dar origem a que o fio parta e a pontos irregulares e omissos.

FOR SEAMTYPE 516 ONLY

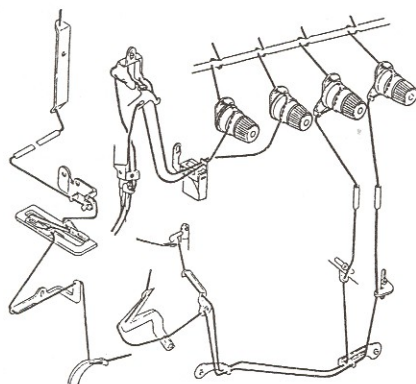


图.Fig.3

FOR FOUR THREAD ONLY

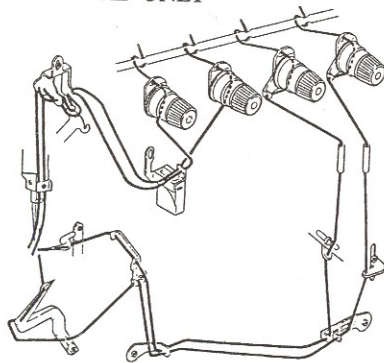


图.Fig.4

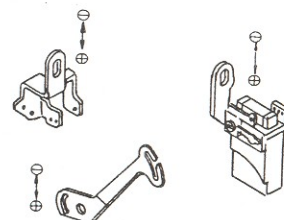


图.Fig.6

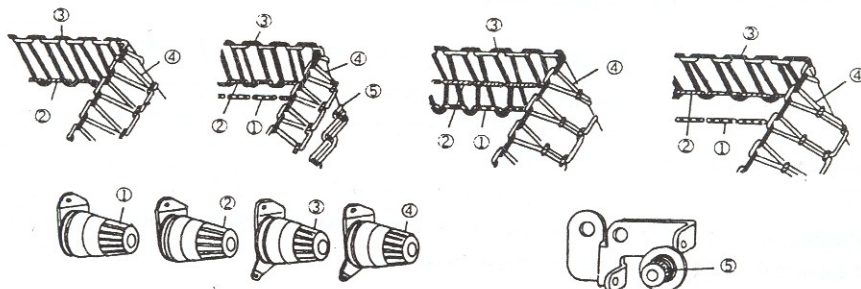


图.Fig.6

控线调整

控线强弱必须根据缝合材料种类、厚薄、线、针距及包边宽度等之不同而做不同之调整。

(1) 调整钮之控线关系 图5

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

(2) 针线控线关系 图6

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

(3) 勾针控线关系 图7

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

• 估定线导板③如下：

A点：尼龙伸缩线

B点：拷下摆

C点：缝合方式512

• 固定线导板④如下：

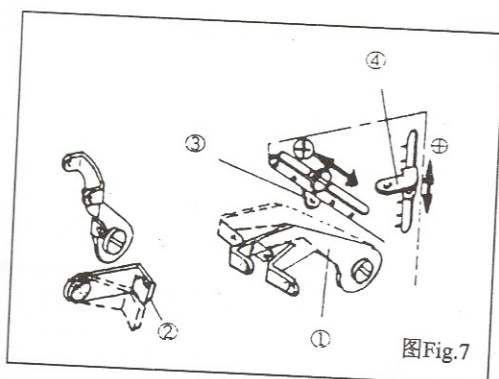
D点：尼龙伸缩线

E点：拷下摆

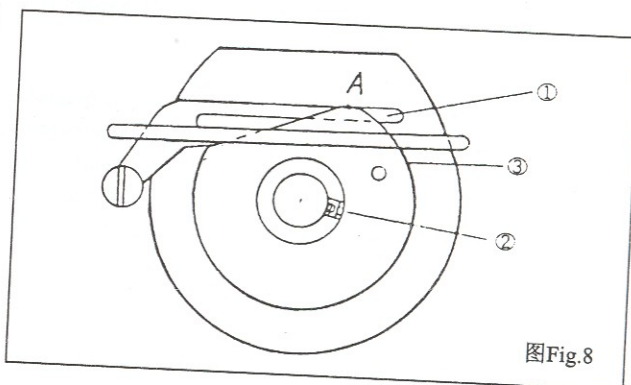
⊕方向为缝合线较多，反之较少。

(4) 环缝线凸轮控线关系 图8

正确之环线凸轮位置是当针提升至最高点时，A点恰好在勾针线导板①之表面，放松凸轮螺线②转动凸轮③向反时针方向则勾针收线较快。



图Fig.7



图Fig.8

THREAD TENSION

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

(1) Tension Nuts Adjustment. Fig.5

- The tension Nut ① controls the double chain needle thread or left side overlock needle thread.
- The Tension Nut ⑤ controls the double chain looper thread.
- The Tension Nut ② controls the overlock needle thread.

- The Tension Nut ③ controls the upper looper thread.
- The Tension Nut ④ controls the lower looper thread.

(2) Needle Thread Control Fig.6

• In case of sewing type 504, 512, & 514, push Thread guide ① and ② to lowest point. And up to highest point for sewing type 503, 505.

Note: The ⊕ direction is for more needle thread tension, and the ⊖ direction is for less needle thread tension.

(3) Looper Thread Control Fig.7

• For sewing type 512, when Upper Looper is extremely left, push Takeup ① and ② at the position as the chain line(——).

• In case of sewing type 503, & 505, when Upper Looper moves to lowest, set Take up ① and ② at the position as the continuous line(——).

• Adjust Thread Guide ③ as follows. Point A—for stretchy thread is used.

Point B -- for seaming and blindstitch hemming.

Point C -- for seaming type 512.

• Adjust Thread Guide ④ as follows; Point D—for stretchy thread is used.

Point E -- for seaming and blindstitch hemming.

NOTE: The ⊕ direction is for more thread in sewing seam, and the ⊖ direction is for less thread in sewing seam.

(4) Chain Looper Thread Cam Control Fig.8

When the needle moves to its highest position, the right corner of the Thread Cam ③ matches with the upper surface of Thread Guide Bracket ①.

Loosen Screw ② and adjust the Thread Cam ③ as clockwise is late for timing of looper thread cam.

TENSION DEL HILO

La tensión del hilo deberá ajustarse de acuerdo con el tipo de tejido, el grueso del mismo, tipo de hilo, ancho de costura, longitud de puntada, etc., por lo que hemos de ajustar la presión en los postes de tensión y tira-hilos para cada caso en particular.

Ajuste de los postes de tensión. Fig.5

- El poste de tensión ① controla la tensión del hilo aguja (puntada de seguridad 401) (Aguja izquierda).
- El poste de tensión ⑤ controla la tensión del hilo áncora (puntada de seguridad 401).
- El poste de tensión ② controla la tensión del hilo aguja overlock.
- El poste de tensión ③ controla la tensión del áncora superior.
- El poste de tensión ④ controla la tensión del hilo áncora inferior.

Control hilo-aguja Fig.6

• En caso de coser con las puntadas 504, 512 y 514, empujar los pasahilos ① y ② a su posición más alta para las puntadas 503 y 505.

NOTA: La dirección ⊕ es para dar más tensión al hilo-aguja y la dirección ⊖ es para dar menos tensión al hilo aguja.

Control hilo-áncora. Fig.7

• Para coser con la puntada 512 cuando el áncora superior está en el punto más alto (a la izquierda) de su recorrido, empujar los tira-hilos ① y ② a la posición de la línea discontinua(——).

• En caso de las puntadas 503, 504 y 505, cuando el áncora superior está en el punto más bajo de su recorrido (a la derecha), situar los tira-hilos ① y ② en la posición de la línea continua(——).

• Ajustar el guía-hilos ③ de la forma siguiente:

Posición A --- Para coser con hilos elásticos.

Posición B --- Para Para dobladillo con puntada invisible.

Posición C --- Para Para coser con puntada 512.

• Ajustar el guía-hilos ④ de la forma siguiente:

Posición D --- Cuando usamos hilos elásticos.

Posición E --- Para dobladillar con puntada invisible.

NOTA: La dirección $\oplus$ es para dar más hilo a la costura y la dirección $\ominus$ es para dar menos hilo a la costura.

Control hilo ó ncora puntada de seguridad Fig.8

Cuando la aguja está en la posición más alta de su recorrido, la esquina derecha del excéntrico tira- hilo ③ deberá estar a ras con el brazo guía-hilo ①. Aflojar el tornillo ② y ajustar el excéntrico tirahilo ③ en su posición correcta.

REGLAGE DE LA TENSION DES FILS

On règle les tensions d'après la matière à travailler, son éoaisseur, le de couture, la largeur du surjet, la longueur du point, etc...

Par conséquent la pression des écrous de tension ou des passe-fils doit être réglée selon chaque cas particulier.

Reglage des écrous de tension Fig.5

- Ecou de tension ① Contrôle le fil de l'aiguille de chaînette ou le fil de l'aiguille du sprjet côté gauche.
- Ecou de tension ⑤ Contrôle le fil du boucleur du point de chaînette.
- Ecou de tension ② Contrôle le fil de l'aiguille du pointsurjt.
- Ecou de tension ③ Contrôle le fil du boucleur supéricut.
- Ecou de tension ④ Contrôle le fil du boucleur inférieur.

Contrôle de l'aiguille Fig.6

• Pour la couture points 504, 512 et 514 baisser le passe-fil ① et ② jusqu'à l'extrême bas. Pour la couture type 503 et 505 soulever les passe-fils jusqu'au point le plus haut.

NOTA: Le sens marqué $\oplus$ consiste à obtenir plus de tension de fil de l'aiguille, tandis que le sens marqué $\ominus$ est prévu pour moins de tension de fil de l'aiguille.

Contrôle du fil du boucleur Fig.7

• Pour la couture au point 512, lorsque le boucleur atteint son point mort gauche pousser le tendeur de fil ① et ② à la position telle que la ligne de chaînette (—).

• Dans le sens de la couture aux points 503, 504 et 505, lorsque le boucleur se déplace vers le bas, régler le tendeur de fil ① et ② à la position telle que la ligne continue (—).

• Régler le passe-fil ③ comme suit:

Point A - Si on emploie un fil extensible.

Point B - Pour l'ourlage surjet invisible.

Point C - Pour la couture point 512. Régler le passe-fil ④ comme suit:

Point D - Si on emploie un fil extensible.

Point E - Pour l'ourlage en surjet invisible.

NOTA: Le sens marqué par $\oplus$ est destiné pour plus de fil dans la couture et le sens marqué par $\ominus$ pour moins de fil dans la couture.

Contrôle de la came du fil du boucleur de chaînette Fig.8

Lorsque l'aiguille se déplace vers sa position haute maxi, le coin à droite de la came du fil ③ doit coïncider avec la surface supérieure du support du passe-fil ①. Si ce n'est pas le cas, desserrer la vis ② et régler la came de sorte à rattraper le retard dû à la rotation dans le sens des aiguilles d'une montre, ce qui est nécessaire pour la synchronisation du boucleur avec l'aiguille.

TENSAO DO FIO

A tensão do fio deve ser ajustada de acordo com o tipo de tecido, a largura da costura, o comprimento do ponto, etc. Desta forma, as pressões das porcas de tensão ou os passa-fios devem ser ajustados para cada caso específico.

(1) Ajuste das porcas de tensão (fig.5)

- A porca de tensão 1 controla a tensão do fio da agulha de ponto em cadeia ou do fio da agulha do ponto

de luva da esquerda.

- A porca de tensão 5 controla o fio da lancadeira do ponto em cadeia.
- A porca de tensão 2 controla o fio de agulha do ponto de luva.
- A porca de tensão 3 controla o fio da lancadeira superior.
- A porca de tensão 4 controla o fio da lancadeira inferior.

(2) Controle do fio da agulha (Fig.6)

• No caso dos pontos de costura 504, 512 e 514, empurre os passa-fios 1 e 2 para a sua posição mais baixa. Para os pontos 503 e 505, empurre-os para a posição mais elevada.

NOTA: O sentido marcado com + destina-se obter maior tensão do fio da agulha, enquanto que o sentido marcado com - destina-se obter menor tensão.

(3) Controle do fio da lancadeira

• Para o ponto 512, quando a lancadeira superior está na posição extrema à esquerda, empurre o tensor de fios 1 e 2 para a posição da linha em cadeia (—).

• No caso dos pontos 503, 504 e 505, quando a lancadeira superior está na posição mais baixa, regule o tensor de fio 1 e 2 para a posição da linha contínua (-).

• Ajuste o pass-fios 3 do seguinte modo:

Posição A - Para coser com fios elásticos

Posição B - Para coser bainhas com ponto invisível

Posição C - Para coser com o ponto 512

• Regule o passa-fios 4, do seguinte modo:

Posição D - Para coser com fios elásticos

Posição E - Para coser bainhas com ponto invisível

NOTA: O sentido marcado com + destina-se a dar mais fio à costura

e o sentido marcado com - destina-se a dar menos fio à costura.

(4) Controle do excêntrico do fio da lancadeira de cadeia (Fig.8)

Quando a agulha se desloca para a sua posição superior máxima, o canto direito do excêntrico do fio 3 deve coincidir com a superfície superior do suporte do passa-fios 1. Solte o parafuso 2 e ajuste o excêntrico do fio de forma a recuperar o atraso devido à rotação no sentido dos ponteiros do relógio, necessário à sincronização da lancadeira com a agulha.

针距调整 图9 表2

通常按缝合布料，差动比等之不同而调整

- 持续压下按钮并转动皮带轮使钮卡住，再转动皮带轮至所需之针距后放开此按钮。

STITCH LENGTH ADJUSTMENT Fig.9 Tab2

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

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

AJUSTE LONGITUD DE PUNTADA Fig.9 Tab.2

La longitud de puntada se hace de acuerdo con el género, la relación de diferencial, etc.

- Apretar el botón y girar el volante hasta que se acople.
- Mantener apretado el botón y girar el volante hasta conseguir la longitud de puntada deseada, según la escala de tepacorreas.

REGLAGE DO LA LONGUEUR DU POINT Fig.9 Tableau2

Le réglage de la longueur du point se fait selon la matière à travailler l'intensité d'entraînement des griffes différentielles, etc...

- Appuyer sur le bouton poussoir et tourner le volant pour que le bouton poussoir y entre profondément.
- Conserver la pression sur le bouton poussoir et coïncider la longueur avec le point de repère se trouvant sur le cache-courroie.

AJUSTE DO COMPRIMENTO DO PONTO (Fig.9-Quadro2)

O ajuste do comprimento do ponto faz-se de acordo com o tipo de tecido, a relação do diferencial, etc.

- Pressione o botão e rode o volante até que o botão penetre nele.
- Mantenha a pressão sobre o botão e faça coincidir o comprimento do ponto desejado marcado no volante com o ponto assinalado na capa da correia.

Tab.2

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

图.Fig.9

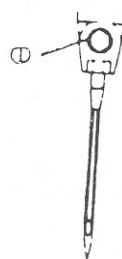
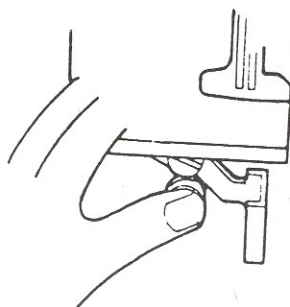


图.Fig.10

换针 图10

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

NEEDLE REPLACEMENT Fig.10

- Please use DC×27 or equivalent needle size.

- Loosen Screw ① and remove the old needle.
- Insert the needle which long groove faces you and push it up deep into the needle hole until it stops and tighten Screw ①

CAMBIO DE AGUJA Fig.10

- Por favor usar las agujas DC×27 ou un sistema equivalente.
- Afojar el tornillo ① y sacar la aguja vieja.
- Introducir una aguja nueva a tope en su alojamiento y apretarel tornillo ① después de asegurarse que la ranura larga queda en la parte frontal de la máquina.

REPLACEMENT DE L'AIGUILLE Fig.10

- Utiliser l'aiguille DC×27 ou équivalent
- Desserrer la vis ① et retirer l'aiguille défilante.
- Insérer une nouvelle aiguille de sorte que la longue rainure trouve face à l'opératrice et que l'extrémité du talon atteigne le fond du trou. Serrer la vis de fixation ①.

SUBSTITUICAO DA AQLHA

- Use agulhas de tamanho DC×27 ou equivalente
- Solte o parafuso ① e retire a agulha velha
- Introduza uma agulha nova de forma a que a ranhura comprida fique voltada para a operadora, empurrando-a para dentro do orifício até ao fundo. Aperte o parafuso de fixação ①.

差动比调整(主送料具与分送料具运动程之比)图11 表3

若主送料具之运动程大于分送料具运动程时，则布料车缝时伸张，反之则收缩。

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

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

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

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

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

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

AJUSTE DE LA RELACION DE DIFERENCIAL Fig.11 Tab3

La "relación de diferencial" es la relación de movimiento entre el diente Principal y el diente Diferencial. Cuando el movimiento del diente Principal es mayor que el diente Diferencial, el género se estira al coserlo. En caso contrario se arruga.

• Aflojar la tuerca ① y girar el tornillo ② en sentido de las agujas del reloj, si fuera necesario estirar mas el telido y en caso contrario para obtener un resultado opuesto apretar la tuerca ①.

NOTA: Cuando la palanca ③ se sitúa en ② de la escala, la "relación diferencial" es de 1:1 y por encima de él puede ajustarse hasta 1:0.7.

REGLAGE DE L'INTENSITE DE LA GRIFFE DIFFERENTIELLE Fig.11 et Tableau3.

L'intensité du différentiel est le rapport entre l'entraînement de la griffe principale est plus important que celui de la griffe différentielle, on obtient une couture étirée et dans le cas contraire on obtient une couture froncée. Pour régler le différentiel procéder comme

• Desserrer l'écrou ① et tourner la vis ② dans le sens des aiguilles d'une montre pour étirer le tissu et dans le sens inverse des aiguilles d'une montre pour le froncer puis serrer l'écrou ①.

NOTA: Lorsque l'échelle de réglage ③ est réglée à la graduation ② le rapport du différentiel est de 1:1 dans ce cas son rapport serait réglable jusqu'à 1:0.7 adjustable up to 1:0.7.

AJUSTE DA RELACAO DO DIFERENCIAL (Fig.11 e Quadro.3)

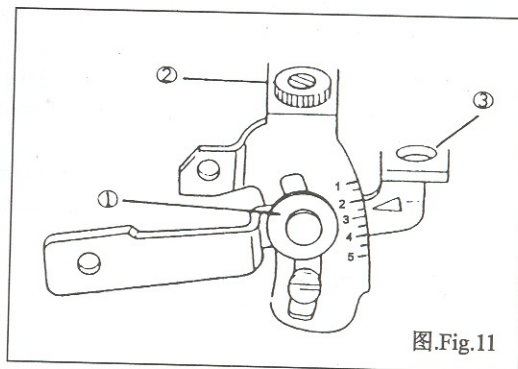
A relação do diferencial é a relação entre o movimento do dente principal e do dente diferencial. Quando o movimento do dente principal é maior que o do dente diferencial, o tecido é esticado ao ser costurado. No caso contrário, o tecido franze. Para regular o diferencial, procede da seguinte forma:

• Solte a porca 1 e rode o parafuso 2 no sentido dos ponteiros do relógio, para esticar o tecido, e no sentido inverso, para o franzir; aperte em seguida a porca 1.

NOTA: Quando a superfície de ajuste de nível 3 é fixada na escala 2, a relação do diferencial é de 1:1; se for fixada acima desta escala, a relação pode ser regulada até 1:0.7.

Tab.3

Scale		1	2	3	4	5
Differential Feed ratio	1:13	—	1:07	1:09	1:11	1:13
	1:2	1:07	1:1	1:14	1:17	1:2
	1:3	1:1	1:15	1:2	1:25	1:3
	1:4	1:11	1:16	1:23	1:28	1:33



各缝纫元件之相互关系

(1) 针于针板之关系 图 12

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

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

转动皮带轮使针到最高点后, 轻敲针座滑块至正确针高度后锁紧螺丝①。

(2) 上勾针与针之关系 图13

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

(3) 下勾针与针之关系 图14, 图15

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

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

(4) 上勾针与下勾针之关系 图16

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

(5) 针与导针片之关系 图17

- 当下勾针尖刚好到针（双针时以左针为准）中心线时，针与后导针片A之间隙为0mm

- 当针移到了低点量，针与前导针板B之间隙为0.1—0.2mm。

(6) 环缝勾针与针之关系 图18

当环缝勾针移至最左时勾针尖端与针中心线之距离为2.5mm。

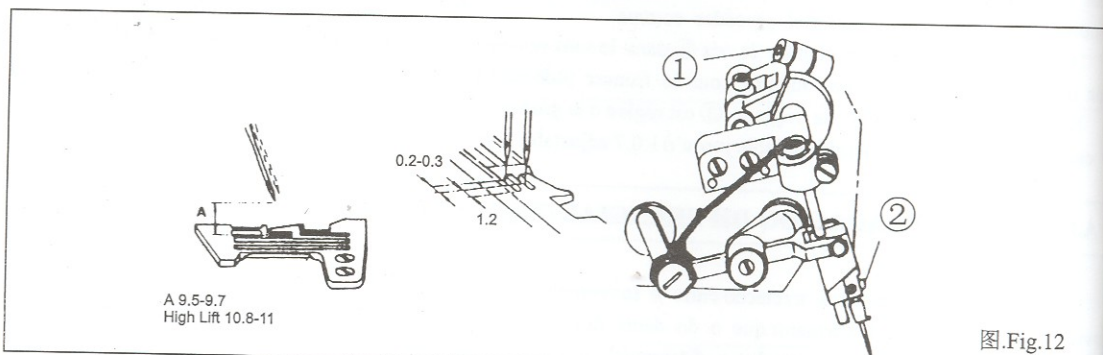


图.Fig.12

PARTS RELATION AND TIMING

(1) Needle and Needle Plate Fig.12

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

- Slightly loosen Screw ① of Needle Drive Crank.

- Rotate the Pulley to check if needle center in each needle slot of Needle Plate. or you may loosen Screew ② and adjust Needle Holder.

- Rotate the Pulley for removing the needle to the highest position, tap the Needle Holder Guide until the correct needle height is obtained.

- Tighten Screw ①

(2) Upper Looper (Spreader) and Needle Fig.13

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

(3) Lower Looper and Needle Fig.14.15

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

- When the Lower Looper moves to the center line of needle (left needle if 2 needle), the gap between needle and looper is 0-0.05mm.

(4) Upper Looper and Lower Lopper Fig.16

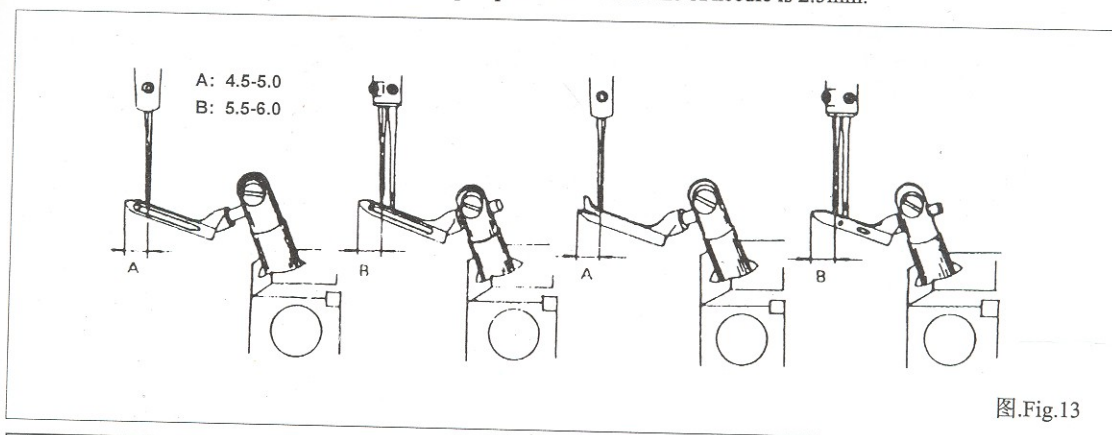
When the Upper and Lower Looper is crossed.

(5) Needle and Needle Guard Fig.17

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

(6) Chain Looper and Needle Fig.18

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



AJUSTE Y SINCRONIZACION DE

Aguja-placa aguja. Fig.12

Cuando la aguja está en el punto más alto de su recorrido, la distancia de la punta de la aguja (aguja izquierda en máquinas de dos agujas) a la placa-aguja debe ser de 9.5 a 9.7mm en máquinas de recorrido standard y de 10.8 a 11mm en máquinas de alto recorrido. Cada aguja debe estar centrada con su ranura de la placa-aguja. La aguja de la derecha deberá estar adelantada de 0.2 a 0.3mm. La distancia entre la punta de la aguja (aguja derecha en máquinas de dos agujas) a la parte frontal de la ranura aguja en la placa-aguja y pata presatelas será de 1.2. (fig.27, detalle).

- Aflojar ligeramente el tornillo ① de la bila movimiento aguja.
- Girar el volante y revisar que las agujas estén perfectamente en sus agujeros; si fuera necesario ajustar, aflojar los tornillos ② del soporte aguja.
- Girar el volante hasta que la aguja esté en el punto más alto de su recorrido y ajustar la altura barra-aguja.

- Apretar el tornillo ①.

Ancora Superior-Aguja. Fig.13

Cuando el áncora superior está en el punto más alto de su recorrido (izq.), la distancia de la punta del áncora al centro de la aguja será de 4.5 a 5.5mm. en máquinas de una aguja y de 5.5 a 6mm en máquinas de dos agujas que tomaremos como referencial a aguja izquierda.

Ancora inferior-aguja. Fig.14.15

• Cuando el áncora inferior está en el extremo izquierdo de su recorrido, la distancia de la aguja (aguja izquierda en máquinas de dos agujas) será de 3.4 a 3.6mm. Para máquinas de recorrido standard y de 3.0 a 3.2mm. para máquinas de alto recorrido.

• Cuando la punta del áncora en su recorrido hacia la derecha llega al centro de la aguja (aguja izquierda en máquinas de 2 agujas), la separación entre las dos debe ser de 0 a 0.05mm.

Ancora superior-áncora inferior, Fig.16

En el momento del cruce de las dos áncoras.

Aguja-salva agujas. Fig.17

Cuando la punta del áncora inferior en su recorrido hacia la derecha llega al centro de la aguja (Aguja izquierdas en máquinas de dos agujas), la separación entre la aguja y el salva-agujas posterior A será de 0mm. Cuando la aguja llega al punto más bajo de su recorrido, la separación entre la aguja y el salvaagujas frontal B será de 0.15 a 0.2mm.

Ancora (puntada de seguridad 401) - Aguja Fig. 18

El óncora debe fijarse en su soporte en su posición más baja. Cuando el óncora (puntada 401) está en el extremo izquierdo de su recorrido, la distancia de la punta del óncora al centro de la aguja (puntada 401) será de 2.5mm

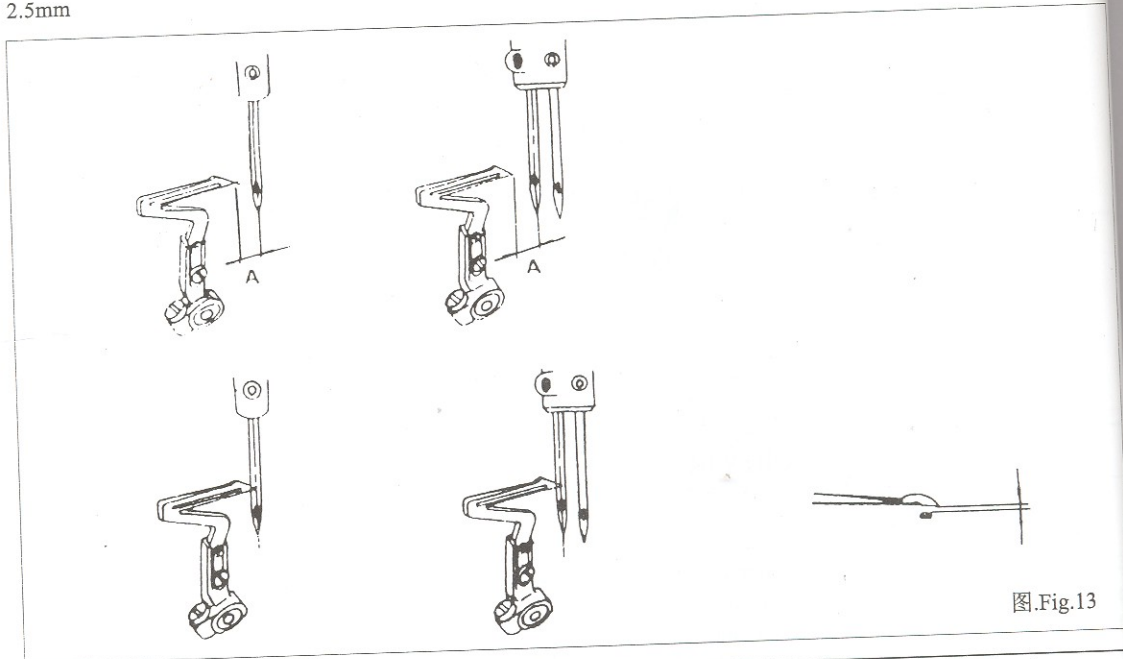


图.Fig.13

SYNCHRONISATION ET RELATION ENTRE LES PIÉCES

Aiguille et plaque aiguille Fig.12

Lorsque l'aiguille atteint sa position haute maxi, la distance entre la pointe de l'aiguille (de gauche si machine à 2 aiguilles) et la plaque aiguille est de 9.5-9.7mm pour les machines à élévation standard ou de 10.8-11.0mm pour les machines à haute élévation. Chaque aiguille doit passer au centre de chaque trou de la plaque aiguille. L'aiguille de droite doit dépasser l'aiguille de gauche d'environ 0.2 à 0.3mm. La distance entre la pointe de l'aiguille (de droite si machine à 2 aiguilles) et le trou de la plaque aiguille ou du pied presseur doit se situer à 1.2mm.

Pour le réglage procéder comme suite:

- Dévisser légèrement la vis ① du levier du mouvement de l'aiguille.
- Tourner le volant et s'assurer si la ou les aiguilles entrent au centre de chaque trou de la plaque-aiguille.
- Dans la négative, desserrer les vis ② et régler le porte-aiguille.
- Tourner le volant pour déplacer l'aiguille à sa position haute maxi. Taper légèrement sur le guide du porte-aiguille jusqu'à qu'on obtienne la hauteur adéquate de l'aiguille.
- Serrer la vis ①

Boucleur supérieur et aiguille Fig.13

Lorsque le boucleur supérieur atteint son point mort aguche, la distance entre la pointe du boucleur et le centre de l'aiguille est de 4.5-5.0mm pour les machines à une aiguille ou 5.5-6.0mm entre la pointe du boucleur et le centre de gauche pour les machines à 2 aiguilles.

Boucleur inférieur et aiguille Fig.14.15

• Lorsque le crochet inférieur atteint son point mort gauche, la distance entre la pointe du crochet et la ligne médiane de l'aiguille (aiguille de gauche pour les machines à 2 aiguilles) doit se situer entre 3.4 et 3.6mm pour les machines à élévation standard et entre 3.0 et 3.2mm pour les machines à haute élévation.

• Lorsque le crochet inférieur atteint la ligne médiane de l'aiguille (de gauche pour les machines à 2 aiguilles), l'écart entre l'aiguille et le crochet doit se situer entre 0 et 0.5mm.

Boucleur supérieur et boucleur inférieur Fig.16

Lorsque les boucleurs supérieur et inférieur se croisent l'écart.

Aiguille et garde-aiguille Fig.17.

Lorsque la pointe du boucleur inférieur se trouve face de la ligne médiane de l'aiguille (aiguille de gauche pour les machines à 2 aiguilles) l'écart entre l'aiguille et l'arrière de la garde-aiguille A est de 0mm. Lorsque l'aiguille atteint sa position basse maxi, l'écart entre l'aiguille et la face de la garde-aiguille B se situe entre 0.15 et 0.2mm.

Boucleur de chaînette et aiguille Fig.18.

Le crochet de chaînette doit être fixé le plus bas possible dans son support et lorsqu'il atteint son point mort gauche, l'écart entre la pointe du crochet et la ligne médiane de l'aiguille doit être de 2.5mm.

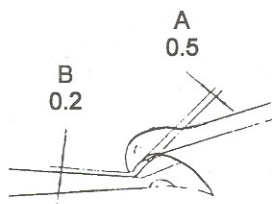


图.Fig.16

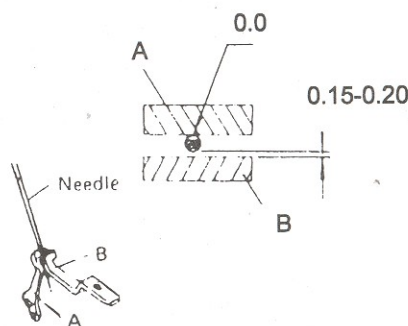


图.Fig.17

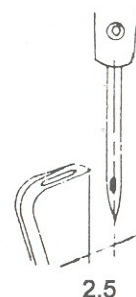


图.Fig.18

AJUSTE E SINCRONIZACAO DAS PECAS

(1) Agulha E Placa Da Agulha (Fig.12)

Quando a agulha atinge a sua posição superior máxima, a distância entre a ponta da agulha (a da esquerda, se a máquina tiver 2 agulhas) e a placa de agulha é de 9.5-9.7mm, nas máquinas de elevação 'standard', ou de 10.8-11mm, nas máquinas de alta elevação. Cada agulha deve passar pelo centro de cada orifício da placa da agulha. A agulha da direita deve estar à frente da esquerda cerca de 0.2 a 0.3mm. A distância entre a ponta da agulha (da direita, em máquinas de 2 agulhas) e o orifício da placa da agulha ou do calcador deve ser de 1.2mm.

Para regular, proceda do seguinte modo:

- Solte ligeiramente o parafuso 1 da alavanca de movimento da agulha.
- Rode o volante e certifique-se de que a / as agulhas entram no centro de cada orifício da placa da agulha.
- Caso não entrem, solte os parafusos 2 e regule o suporte das agulhas.
- Rode o volante para deslocar a agulha para a sua posição superior máxima. Bata levemente sobre a guia do suporte das agulhas, até obter a altura da agulha desejada.
- Aperte o parafuso 1.

(2) Lancadeira superior e agulha (Fig.13)

Quando a lancadeira superior atinge o seu ponto morto à esquerda, a distância entre a ponta da lancadeira e o centro da agulha é de 4.5-5mm, nas máquinas de 1 agulha, ou de 5-6mm, entre a ponta de lancadeira e o centro da agulha esquerda, nas máquinas de 2 agulhas.

(3) Lancadeira inferior e agulha (Fig.14.15)

• Quando a lancadeira inferior atinge o seu ponto morto à esquerda, a distância entre a ponta da lancadeira e a linha média da agulha (agulha da esquerda, em máquinas de 2 agulhas) deve ser de 3.4 a 3.6mm, nas máquinas de 3.4 a 3.6mm, nas máquinas de elevação 'standard', e de 3 a 3.2mm, nas máquinas de alta elevação.

- Quando a lancadeira inferior atinge a linha média da agulha (da esquerda, em máquinas de 2 agulhas), a

distância entre a agulha e a lancadeira deve ser entre 0 e 0.05mm.

(4)Lancadeira superior e lancadeira inferior (Fig.16)

Quando as lancadeiras superior e inferior se cruzam.

0.2 0.5

(5)Agulha e protecção da agulha (Fig. 17)

Quando a ponta da lancadeira inferior se encontra em frente da linha central da agulha (agulha da esquerda, em máquinas de 2 agulhas), a distância entre a agulha e a parte de trás da protecção da agulha A é de 0mm. Quando a agulha atinge a sua posição inferior máxima, a distância entre a agulha e a parte frontal da protecção da agulha B situa-se entre 0.15 e 0.2mm.

(6)Lancadeira de cadeia e agulha (Fig.18)

A lancadeira de cadeia deve ser fixada o mais baixo possível no seu suporte e, quando atinge o seu ponto morto da esquerda, a distância entre a ponta da lancadeira e a linha central da agulha deve ser de 2.5mm.

故障排除

断针

原因

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

对策

- (1) 重新装针, 长沟面向您自己
- (2) 选用适合布料及用线之针
- (3) 重换新针
- (4) 调整顶针片与针之关系
- (5) 调整勾针与针之关系
- (6) 重新装针板或针, 或调整压脚

NEEDLE BREAK

REASON

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

CORRECT

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

ROTURA DE AGUJAS

CAUSE

- (1)Medida incorrecta de la aguja
- (2)Aguja mal puesta

(3)Aguja doblada

- (4)Posición incorrecta del salva-agujas posterior
- (5)Posición incorrecta del salva-agujas frontal

(6) La aguja no esta centrada en sus ranuras de la placa-aguja prensatelas

CORRECT

(1) Usar la aguja apropiada para el género y el hilo.

(2) Colocar la aguja correctamente

(3) Cambiar por una nueva

(4) Ajustar correctamente salva-agujas posterior

(5) Ajustar correctamente salva-agujas frontal

(6) Centrar la aguja correctamente

DEPANNAGE CASSE D'ALGUILLES

CAUSAS

(1) Grosueur d'aiguille ne convenant pas.

(2) Mauvais positionnement de l'aiguille.

(3) Aiguille tordue.

(4) Mauvais rapport entre l'aiguille et la garde.

(5) L'aiguille n'est pas centrée par rapport au trou de la plaque ou du pied.

(6) Enfiler le bout de l'aiguille dans le milieu de la

rainure.

REMEDIOS (1) Utiliser une aiguille et un fil qui conviennent.

(2) Fixer l'aiguille dans le bon sens.

(3) Remplacer l'aiguille.

(4) Réajuster la garde aiguille.

(5) Réajuster la plaque aiguille et le pied presseur.

QUEBRA DE AGULHAS

CAUSA:

(1) Tamanho de agulha errado

(2) Má colocação da agulha

(3) Agulha torta

(4) Má relação entre a agulha e a respectiva protecção

(5) A agulha não está centrada relativamente ao orifício da placa ou do calcador.

(6) Fie da agulha inset no centro de fosso do peca da agulha so cheio do centro.

SOLUCAO:

(1) Utilize uma agulha e fio convenientes

(2) Fixe a agulha no sentido correcto

(3) Substitua a agulha

(4) Reajuste a protecção da agulha

(5) Reajuste a placa de agulha e o calcador.

断线

原因

(1) 线品质不良

(2) 线粗细不均或比针孔大

(3) 穿线错误

(4) 控线压力太强

(5) 针安装错误

(6) 线架过线错误

(7) 针温度过高

1. 针冷却槽已无冷却油

2. 针导板装错

(8) 控线片已粗糙

(9) 针与勾针之关系错误

(10) 针、勾针、针板、针导板擦伤起毛头

对策

(1) 改用品质好的线

(2) 换适宜之针与线

- (3) 重新正确穿线
- (4) 调整控线强度
- (5) 重新正确装针
- (6) 重新装线架使线能通过自如

- (7) 1 加冷却油 2 调整针导片
- (8) 用砂布拉滑后抛光
- (9) 调整针与勾针之关系
- (10) 磨去毛头或换新品

THREAD BREAK

REASON

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

CORRECT

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

ROTURA ED HILOS

CAUSE

- (1) Mala calidad del hilo
- (2) El hilo es grueso para el ojo de la aguja
- (3) Máquina mal enhebrado
- (4) Mucha tensión en el hilo
- (5) Mal puesta la aguja
- (6) Mal colocado el porta-conos
- (7) Calentamiento en la aguja 1. No hay silicona 2. Mal colocados los salvaagujas
- (8) Rebabas en los discos tensión guía-hilos
- (9) Desincronización aguja-óncora
- (10) Rebabas en la aguja, óncora, placa aguja o algún guía-hilo

CORRECT

- (1) Usar un hilo de mejor calidad
- (2) Usar un hilo apropiado
- (3) Enhebrar correctamente
- (4) Ajustar correctamente la tensión del hilo
- (5) Colocar la aguja correctamete
- (6) Colocar correctamente el porta-conos de forma que el hilo salga (suavemente)
- (7) 1. Poner silicona en el depósito 2. Ajustar correctamente los salvaagujas.
- (8) Pulir o cambiar por unos en buen estado
- (9) Sincronizar correctamente aguja-óncora
- (10) Pulir o cambiar por otros en buen estado

DEPAMMAGE CASSE DE FIL

CAUSAS

- (1) Fil de mauvaise qualité.
- (2) Fil plus gros que le chas de l'aiguille.
- (3) Mauvais enfilage.
- (4) Tension du fil trop forte
- (5) Aiguille mal positionnée
- (6) Porte-cônes mal installé
- (7) Echauffement de l'aiguille
 1. pas de silicone
 2. garde-aiguille mal fixé
- (8) Bavures sur les disques de tension et du passe-fil
- (9) Mauvais rapport entre l'aiguille et le crochet
- (10) Surface rugueuse de l'aiguille, du crochet, de

la plaque ou du passe-fil

REMEDIOS

- (1) Utiliser un fil de bonne qualité
- (2) Utiliser l'aiguille qui convient au tissu et au fil
- (3) Refaire l'enfilage (voir schéma)
- (4) Réajuster l'écrou du réglage tension
- (5) Fixer l'aiguille dans le bon sens
- (6) Remonter le porte cônes (voir schéma de montage)
- (7) 1. remplir le réservoir de silicone
 2. réajuster le garde-aiguille
- (8) Polir ou remplacer
- (9) Réajuster l'aiguille et le crochet
- (10) Polir, meuler ou remplacer

QUEBRA DE FIOS

CAUSA:

- (1) Fio de má qualidade
- (2) Fio mais grosso que o orifício da agulha
- (3) Mau enfiamento
- (4) Tensão excessiva do fio
- (5) Agulha mal colocada
- (6) Porta-cones mal instalado
- (7) Sobre-aquecimento da gulha
 1. Falta de silicone
 2. Protecção da agulha mal fixada
- (8) Rebarba nos discos de tensão e no passa-fios
- (9) Má relação entre a agulha e a lancadeira
- (10) Superfície rugosa da agulha, da lancadeira, da placa ou do pass-fios.

SOLUCAO:

- (1) Utilize um fio de boa qualidade
- (2) Utilize a agulha que convém ao tecido e ao fio
- (3) Volte a enfiar (ver esquema)
- (4) Reajuste a porca de tensão
- (5) Fixe a agulha correctamente
- (6) Volte a montar o porta-cones (ver esquema de montagem)
- (7) 1. Encha o reservatório com silicone
 2. Reajuste a protecção de agulha
- (8) Proceda ao polimento ou à substituição
- (9) Reajuste a agulha e a lancadeira
- (10) Proceda ao polimento, raspagem ou substituição

跳针

原因

- (1) 针与勾针之关系错误

- (2) 穿线错误

- (3) 针安装错误

- (4) 控线压力太强或太弱
 - (5) 勾针尖端损坏起毛头
 - (6) 针变弯
 - (7) 顶针片安装错误
- 对策
- (1) 调整针与勾针关系

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

SKIP STITCHES

REASON

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

CORRECT

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

FALLO DE PUNTADA

CAUSE

- (1) Enhebrado incorrecto
- (2) Aguja mal puesta
- (3) Tensión del hilo incorrecta
- (4) Ancora despuntada
- (5) Aguja boblada
- (6) Posición incorrecta de los salva-agujas
- (7) Desincronización Agujas

CORRECT

- (1) Enhebrar la m6quina correctamente
- (2) Colocar la aguja correctamente
- (3) Ajustar correctamente en los postes o tira-hilos
- (4) Cambiar por una nueva
- (5) Cambiar por una en buen estado
- (6) Ajustar correctamente los salva-agujas
- (7) Sincronizar correctamente Agujas-Ancora

DEPANNAGE POINTS DE MANGUE

CAUSAS

- (1) Mauvais enfilage
- (2) Mauvaise fixation de l'aiguille
- (3) Tension du fil inad6quate
- (4) Pointe du crochet 6point6e

(5) Aiguille tordue

- (6) Garde-aiguille mal fix6
- (7) Mauvaise relation entre l'aiguille et le crochet

REMEDIOS

- (1) Refaire l'enfilage (voir sch6ma)

- (2)Revoir la fixation de l'aiguille
- (3)Réajuster l'écrou du réglage tension
- (4)Le remplacer par un neuf

- (5)La remplacer par une neuve
- (6)Réajuster le garde-aiguille
- (7)Revoir la relation entre l'aiguille et le crochet

PONTOS SALTADOS

CAUSA:

- (1)Mau enfiamento
- (2)Má colocação da agulha
- (3)Tensão do fio inadequada
- (4)Ponta da lancadeira danificada
- (5)Agulha torta
- (6)Proteção da agulha mal colocada
- (7)Má relação entre a agulha e a lancadeira

- (1)Volte a enfiar (ver esquema)
- (2)Reveja a colocação da agulha
- (3)Reajuste a porca de tensão
- (4)Substitua-a por uma nova
- (5)Substitua-a por uma nova
- (6)Reajuste a proteção da agulha
- (7)Reveja a relação entre a agulha e a lancadeira

SOLUCAO:

松缝合

原因

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

对策

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

LOOSEN STITCHES

REASON

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

CORRECT

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

PUNTADAS FLOJAS

CAUSE

- (1)Enhebrado incorrecto

- (2)El hilo es grueso para el ojo de la aguja
- (3)los discos de tensión no sujetan el hilo

correctamente

- (4) El hilo aguja no está lubricado
- (5) Aguja o áncoras mal ajustadas

CORRECT

- (1) Enhebrar correctamente
- (2) Usar un hilo apropiado

- (3) Ajustar correctamente los postes de tensión

- (4) Poner silicona en el depósito

- (5) Ajustar correctamente la altura barraaguja

Ajustar correctamente la sincronización de las

áncoras

DEPANNAGE COUTRE LACHE

CAUSAS

- (1) Mauvais enfilage
- (2) Le fil est plus gros que le chas de l'aiguille
- (3) Pression des disques de tension inadéquate
- (4) Le fil d'aiguille n'est pas lubrifié
- (5) Aiguille et crochet non synchronisés

REMEDIOS

- (1) Revoir l'enfilage

- (2) Utiliser une aiguille qui convient au fil et au

tissu

- (3) Réajuster les disques de tension

- (4) Remplir le réservoir de silicone

- (5) Réajuster le rapport entre les deux éléments

PONTOS FALSOS

CAUSA:

- (1) Mau enfiamento
- (2) O fio é mais grosso que o orifício da agulha
- (3) Pressão inadequada dos discos de tensão
- (4) O fio da agulha não está lubrificado
- (5) Agulha e lançadeira dessincronizadas

SOLUCÃO:

- (1) Voltar a enfiar

- (2) Utilizar uma agulha que convinha ao fio e ao

tecido

- (3) Reajuste os discos de tensão

- (4) Encher o reservatório com silicone

- (5) Reajuste a relação entre os dois elementos

缝合不均

原因

- (1) 穿线错误
- (2) 线架安装错误
- (3) 下刀安装错误
- (4) 刀未能剪布整齐
 - 1. 刀装错
 - 2. 刀钝
- (5) 过线孔擦伤
- (6) 针尖受损

- (7) 送料高度不适宜

- (8) 压具压力太强或太弱

对策

- (1) 重新正确穿线

- (2) 重新装线架使线能通过自如

- (3) 重新安装下刀

- (4) 1 调整刀正确位置

- 2 磨利或换新品

- (5) 重新打光

(6) 换新针

(7) 调整正确高度

(8) 调整押具压力强度

UNEVEN STITCHES

REASON

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

CORRECT

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

PUNTADAS DESIGUALES

CAUSE

- (1) Enhebrado incorrecto
 - (2) Mal colocado el portaconos
 - (3) Mal colocada la cuchilla inferior
 - (4) Las cuchillas no cortan correctamente
 1. Cuchillas mal puestas
 2. Cuchillas mal afiadas
 - (5) Rebabas en los discos de tensión quiahilo
 - (6) Aguja despuntada
 - (7) Tensión del hilo incorrecta
 - (8) Alturn incorrecta de los dientes
- CORRECT

- (1) Enhebrar correctamente
- (2) Colocar correctamente el portaconos de forma que el hilo salga suavemente
- (3) Colocar correctamente
- (4) Corregir como sigue:
 1. Colocar correctamente las cuchillas
 2. Afilas o poner unas nuevas
- (5) Pulir o cambiar por unos en buen estado
- (6) Cambiar por una nueva
- (7) Ajustar correctamente la tensión del hilo
- (8) Ajustar correctamente la altura de los dientes

DEPANNAGE COUTURE IRREGUIERE

CAUSAS

- (1) Mauvais enfilage
- (2) Mauvais montage du couteau intérieur
- (3) Couteaux coupent mal

- (4) Couteaux coupent mal
 1. mauvais montage
 2. couteaux émoussés
- (5) Surface rugueuse des disques de tension et des

passes-fil

(6)Pointe de l'aiguille émoussée

(7)Tension de fil inadéquate

(8)Hauteur des griffes inadéquate

REMEDIOS

(1)Revoir l'enfilage, se conformer au schéma

(2)Remonter le porte-cônes (voir schéma)

(3)Réajuster le outeau inferieur

(4)Rectifier comme suit:

1.réajuster les couteaux

2.les affuter ou les remplacer

(5)Polir, meuler ou remplacer

(6)Rèmplacer l'aiguille

(7)Réajuster l'écrou du règle-tension

(8)Réajuster les griffes

COSTURA IRREGULAR

AUSA:

(1)Mau enfimento

(2)Mó fixação da faca inferior

(3)Mó fixação do porta-cones

(4)As facas cortam mal

1.Mó montagem

2.Facas mal afiadas

(5)Superfície rugosa dos discos de tensão e dos passa-fios

(6)Ponta da agulha rombuda

(7)Tensão de fio inadequada

(8)Altura dos dentes inadquada

SOLUCAO:

(1)Volte a enfiar (ver esquema)

(2)Reguste a faca inferior

(3)Volte a montar o porta-cones(ver esquema)

(4)Rectifique do seguinte modo:

1.Reajuste as facas

2.Afie-as ou substitua-as

(5)Porceda ao polimento, raspagem ou substituição

(6)Substitua a agulha

(7)Reajuste a porca de tensão

(8)Reajuste os dentes

缝合起皱纹

原因

(1) 控线压力大强

(2) 押具压力太强或太弱

(3) 送料具太突出针板

(4) 刀无法快切

(5) 差动送料未配合

(6) 针太粗

(7) 包边宽度比针板舌狭窄

对策

(1) 重新调整控线强度

(2) 调整押具压力强度

(3) 调整送料具正确高度

(4) 磨利刀片或换新品

(5) 调整适当差动送料

(6) 用适宜布和线之针

(7) 调整包边宽度或换针板舌

WRINKLED STITCHES

REASON

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

CORRECT

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

COSTURA ARRUGADAS O FRUNCIDAS

CAUSE

- (1) Mucha tensión en el hilo
- (2) Presión incorrecta en el prensatelas
- (3) Altura incorrecta de los dientes
- (4) Las cuchillas no cortan correctamente
- (5) Diferencial incorrecto
- (6) Aguja muy gruesa
- (7) El ancho de costura es muy estrecho o desgastado el dedo formador de cadeneta de la placa-aguja.

CORRECT

- (1) Ajustar correctamente la tensión del hilo
- (2) Ajustar correctamente la presión del prensatelas
- (3) Ajustar correctamente la altura de los dientes
- (4) Ajustar correctamente las cuchillas o afilar
- (5) Ajustar correctamente el diferencial
- (6) Usar la aguja apropiada para el género y el hilo
- (7) Ajustar el ancho de costura o cambiar el dedo formador de cadeneta de la placa-aguja

DEPANAGE GRIGNAGE

CAUSAS

- (1) Tension de fil trop forte
- (2) Pression du pied in édequate
- (3) Hauteur des griffes inadéquate
- (4) Couteaux coupent mal
- (5) Griffes différentielle mal réglée
- (6) Aiguille trop grosse
- (7) Largeur de couture trop étroite à la sortie du doigt mailleur

REMEDIOS

- (1) Réajuster l'écrou du réglage tension
- (2) Réajuster la pression du pied presseur
- (3) Réajuster les griffes
- (4) Réajuster les couteaux ou les affûter
- (5) Réajuster le rapport du différentiel
- (6) Utiliser l'aiguille qui convient au tissu et fil
- (7) Réajuster la largeur du surjet ou remplacer le doigt mailleur

PIONTOS ENRUGADOS

CAUSA:

- (1) Tensão excessiva do fio
- (2) Pressão incorrecta do calcador
- (3) Altura dos dentes inadequada
- (4) Facas cortam mal
- (5) Dente diferencial mal regulado
- (6) Agulha demasiado grossa
- (7) Largura da costura demasiado estreita á saída do dedo da placada agulha

SOLUCAO:

- (1) Reajuste a porca de tensão
- (2) Reajuste a pressão do calcador
- (3) Reajuste os dentes
- (4) Reajuste as facas ou afie-as
- (5) Reajuste a relação do diferencial
- (6) Utilize a agulha que convém ao tecido e fio
- (7) Reajuste a largura da costura ou substitua o dedo de formação do nó

环缝出线不顺原因

原因

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

对策

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

THERAD CHAIN DOES NOT COME OUT SMOOTHLY

REASON

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

CORRECT

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

LA DADENETA NO SALES SUAVE Y CONTINUAMENTE

CORRECT

- (1)Mal colocada la pata prensatelas
- (2)Mala sincronización de excéntrico tirahilos óncora
- (3)Mala sincronización óncora puntada 401 (4)Enhedrado incorrecto
- (5)Tensión del hilo incorrecto
- (6)Aguja o óncoras mal ajustadas
- (7)Rebabas en la placa-aguja, discos de tensión o prensatelas
- (8)Pieza de Control ya fue aspera.

OCORRECT

- (1)Ajustar correctamente la pata prensatelas
- (2)Ajustar correctamente el excéntrico tira-hilos óncora.
- (3)Sincronizar correctamente el óncora puntada 401
- (4)Enhebrar correctamente
- (5)Ajustar correctamente la tensión del hilo
- (6)Sincronizar correctamente agujas-óncoras
- (7)Pulir o cambiar por piezas nuevas
- (8)Suavizar y pulir con papel de lija.

DEPANNAGE MAUVAIS DEGAGEMENT DE LA CHAINETTE

CAUSAS

- (1)Mauvais montage du pied presseur
- (2)Synchronisation de la came du fil du crochet inadéquate
- (3)Mauvaise fixation du crochet double-chainette
- (4)Mauvais enfilage
- (5)Tension de fil inadéquate
- (6)Mauvaise relation entre l'aiguille et le crochet
- (7)Surface rugueuse des disques de tension de la plaque aiguille ou du pied presseur
- (8)La feuille de contrôle est déjà rugueuse.

REMEDIOS

- (1)Corriger le montage du pied presseur
- (2)Réajuster la came du fil du crochet
- (3)Réajuster le crochet du double-chainette
- (4)Refaire l'enfilage
- (5)Réajuster l'écrou du réglage tension
- (6>Régler la relation entre le crochet et l'aiguille

- (7) Polir, meuler ou remplacer les pièces
- (8) Utiliser un papier de verre pour la frotter et la polir.

A CADEIA NAO SAISUAVE E CONTINUAMENTE

CAUSA:

- (1) Má montagem do calcador
- (2) Má sincronização do excêntrico do fio da lancadeira
- (3) Má fixação da lancadeira de ponto duplo em cadeia
- (4) Mau enfiamento
- (5) Tensão de fio inadequada
- (6) Má relação entre a agulha e a lancadeira
- (7) Superfície rugosa dos discos de tensão da placa da agulha ou do calcador
- (8) A talhada de mando já estava grosseiro.

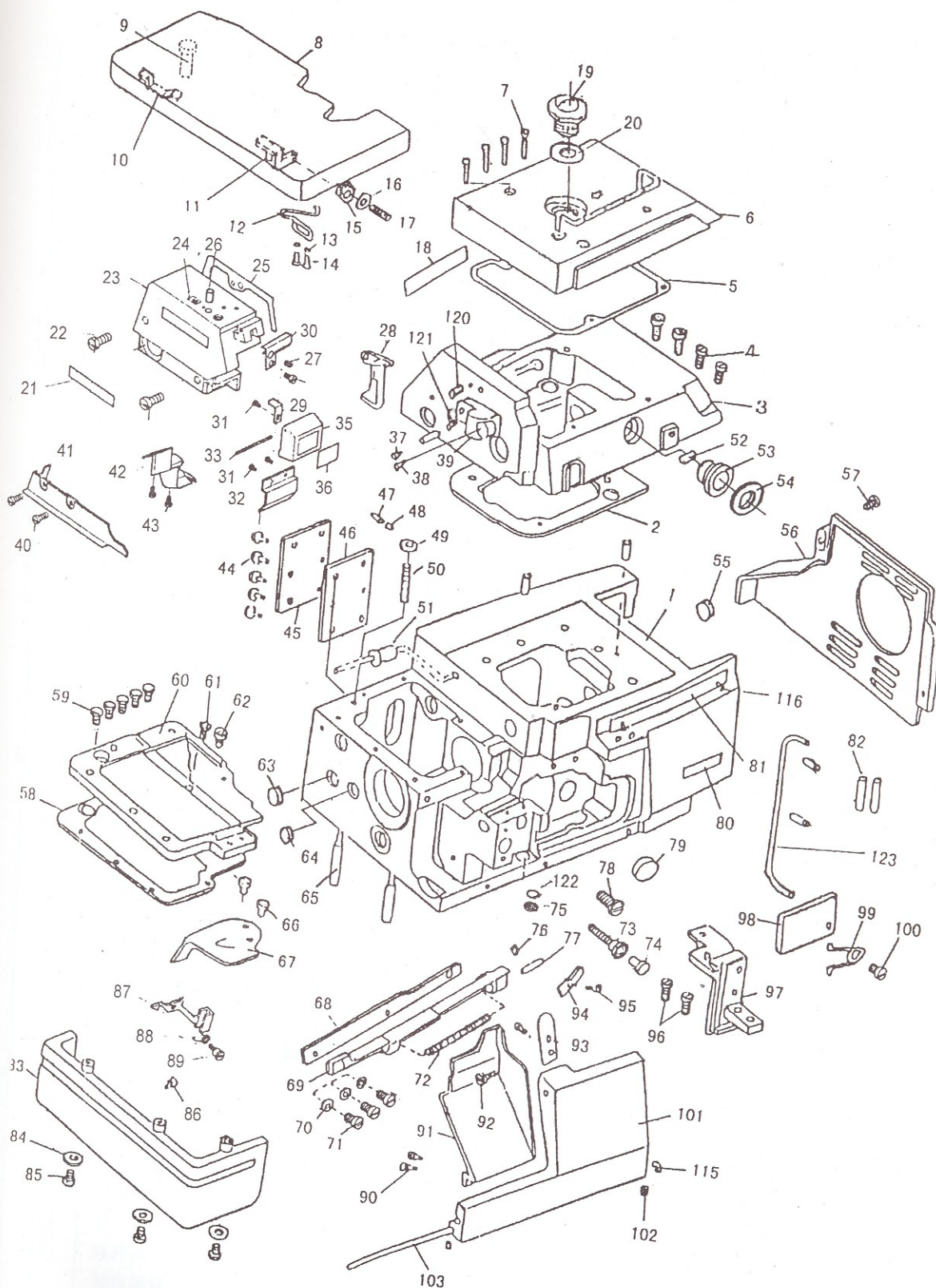
SOLUCAO:

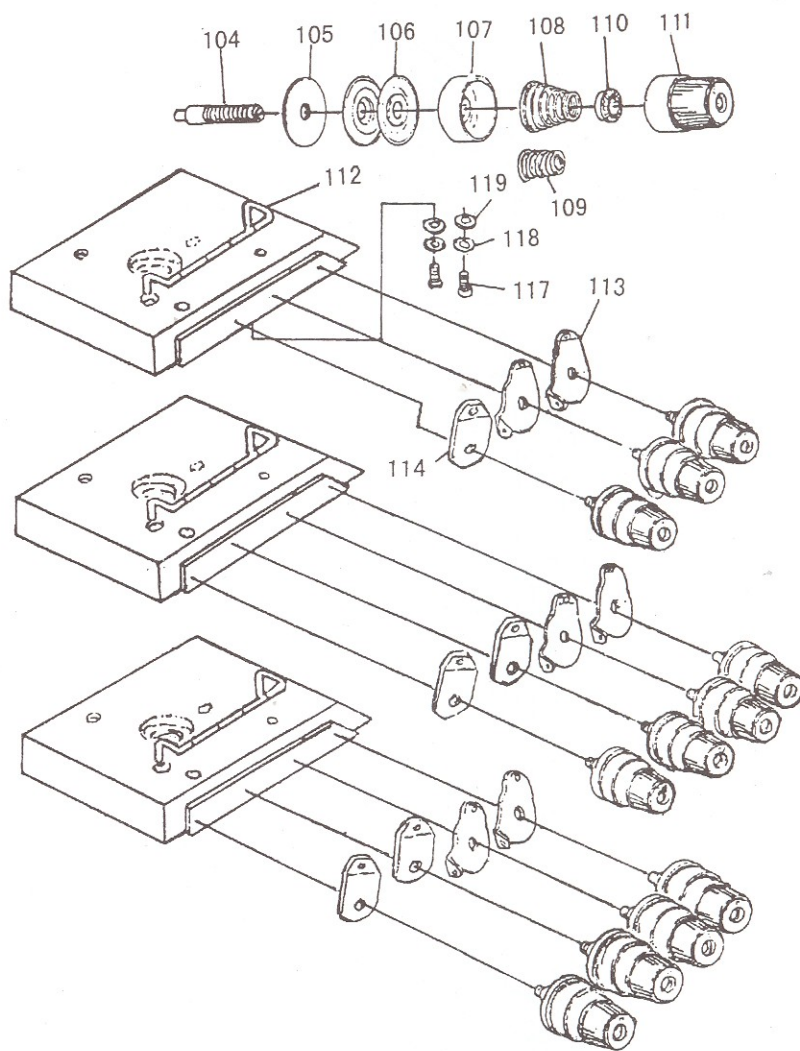
- (1) Rectifique a montagem do calcador
- (2) Reajuste o excêntrico do da lancadeira
- (3) Reajuste a lancadeira de ponto duplo em cadeia
- (4) Volte a enfiar
- (5) Reajuste a porca de tensão
- (6) Reajuste a relação entre a lancadeira e a agulha
- (7) Proceda ao polimento, raspagem ou substituição das peças
- (8) Use o algodão a Tira-se por fica liso e lança para lustre.

机壳部件 Frame Assembly

件号	名 称	Name	数 量		
			三线	四线	五线
1	机壳	machine frame	1	1	1
2	机头垫片	machine head gasket	1	1	1
3	机头	machine head	1	1	1
4	机头紧定螺钉	machine head set screw	4	4	4
5	油封	oil seal	1	1	1
6	上盖	upper cover	1	1	1
7	上盖螺钉	upper cover screw	4	4	4
8	缝台	cloth plate	1	1	1
9	缝台转动轴	cloth plate rotating shaft	1	1	1
10	下罩壳联接架	lower cover connecting plate	2	2	2
11	缝台弹簧座	cloth plate spring holder	1	1	1
12	缝台弹簧	cloth plate spring	1	1	1
13	缝台弹簧螺钉垫圈	cloth plate spring screw washer	2	2	2
14	缝台弹簧紧固螺钉	cloth plate spring screw	2	2	2
15	螺母	nut	1	1	1
16	垫圈	washer	1	1	1
17	缝台锁紧定位销	cloth plate lock pin	1	1	1
18	铭牌	model plate	1	1	1
19	油窗	oil flow window	1	1	1
20	油窗垫	oil flow window washer	1	1	1
21	商标牌	trade mark plate	1	1	1
22	机头罩紧固螺钉	head cover set screw	3	3	3
23	机头罩	head cover	1	1	1
24	油标	oil gauge	2	2	2
25	机头罩垫片	head cover washer	1	1	1
26	加油管	oil supply tube	1	1	1
27	挡油罩固定螺钉	oil guard set screw	1	1	1
28	挡油罩	oil guard	1	1	1
29	机针线罩弹簧	needle thread cover spring	1	1	1
30	机针线罩壳护罩	needle thread cover guard	1	1	1
31	观察镜螺钉	oil sight screw	3	3	3
32	观察镜	oil sight	1	1	1
33	机针线罩壳销	needle thread cover pin	1	1	1
34	机针线罩壳销螺钉	needle thread cover pin screw	1	1	1
35	机针线罩壳	needle thread cover	1	1	1
36	型号牌	model plate	1	1	1
37	针杆固定座螺钉	needle bar set plate screw	2	2	2
38	针杆固定螺钉	needle bar set screw	1	1	1
39	针杆固定座	needle bar set plate	1	1	1
40	导布板螺钉	cloth guide screw	2	2	2
41	导布板	cloth guide	1	1	1
42	集油斗	oil collector	1	1	1
43	集油斗螺钉	oil collector screw	2	2	2
44	后盖板螺钉	rear cover screw	6	6	6
45	后盖板	rear cover	1	1	1
46	后盖板油封	rear cover oil seal	1	1	1
47	球面头螺钉	ball head screw	1	1	1
48	缝台固定六角螺母	cloth plate set hexagon nut	1	1	1
49	缝台转动轴垫圈	cloth plate rotating shaft washer	1	1	1
50	缝台转动轴弹簧	cloth plate rotating shaft spring	1	1	1
51	油管柱	oil tube socket	1	1	1
52	油位线	oil level mark	1	1	1
53	油窗	oil flow window	1	1	1
54	油位标	oil level gauge	1	1	1
55	油封	oil seal	1	1	1
56	皮带轮罩	belt cover	1	1	1

件号	名 称	Name	数 量	
			三线	四线
57	皮带轮罩螺钉	belt cover screw	3	3
58	盖板垫片	cover washer	1	1
59	左上盖紧固螺钉	left-upper cover set screw	5	5
60	盖板	cover	1	1
61	左上盖六角头螺钉	left-upper cover hexagon screw	1	1
62	左上盖六角头螺钉	left-upper cover hexagon screw	1	1
63	油封	oil seal	1	1
64	油封	oil seal	1	1
65	支柱	column holder	4	4
66	挡油罩螺钉	oil shield cap screw	2	2
67	挡油罩	oil shield cap	1	1
68	密封垫片	sealing washer	1	1
69	前盖板铰链	front cover hinge	1	1
70	垫圈	washer	3	3
71	铰链螺钉	hinge screw	3	3
72	铰链销弹簧	hinge pin spring	1	1
73	下罩壳支撑螺钉	lower cover holer screw	1	1
74	定位垫圈	set waher	1	1
75	滤网	oil screen	1	1
76	链销紧定螺钉	set screw	3	3
77	防转销	hinge pin	1	1
78	螺塞	screw	1	1
79	油毡	oil felt	1	1
80	标牌	modle plate	1	1
81	商标牌	trade mark plate	1	1
82	过线管	thread guide tube	2	2
83	缝台下罩壳	cloth plate lower cover	1	1
84	下罩壳垫圈	lower cover washer	3	3
85	下罩壳紧固螺钉	lower cover set screw	3	3
86	缝台下罩壳防震塞	lower cover shockproof plug	2	2
87	缝台闸弹簧	cloth plate slide cover spring	1	1
88	缝台闸	cloth plate slide cover	1	1
89	缝台闸固定螺钉	cloth plate slide voer set screw	1	1
90	前盖板罩板螺钉	front cover locking fastener screw	4	4
91	前盖板罩板	front cover guard	1	1
92	前盖板罩板螺钉	front cover locking fastener screw	3	3
93	前盖板锁紧板	front cover locking fastener	1	1
94	前盖板锁紧舌	frong cover locking tongue	1	1
95	前盖板锁紧舌螺钉	front cover locking tongue screw	1	1
96	油封架螺钉	oil seal supporter screw	2	2
97	油封架	oil seal supporter	1	1
98	油毡	oil felt	1	1
99	压毡簧	oil felt clamp spring	1	1
100	压毡螺钉	oil felt screw	1	1
101	前盖板	front cover	1	1
102	铰链销紧定螺钉	set screw	3	3
103	铰链销	hige pin	1	1
104	压线螺钉	thread tension screw	3	3
105	压线板垫	thread tension disc washer	3	3
106	压线板	thread tension disc	6	6
107	压线外壳	thread tension spring house	3	3
108	压线簧	thread tension spring	1	1
109	压线簧	thread tension spring	2	2
110	调压定位圈	thradd tension spring retainer	3	3
111	压线螺母	thread tension nut	3	3
112	导线杆	thread guide bar	1	1
113	二眼过线板	thread guide for 2-thread	2	2
114	过线板	thread guide	1	1
115	开口挡圈 $\phi 3.4$ GB896-86	snap ring	1	1
116	铆钉 2×6 GB827-86	rivet	4	4
117	螺钉 $M4 \times 12$ GB70-85	screw	2	2
118	垫圈4 GB97.1-85	washer	2	2
119	垫圈4 GB93076	washer	2	2
120	销 5×18 GB829-86	pin	4	4
121	销 GB119-86 A3 $\times 12$	pin	2	2
122	挡圈 GB893.2-86-16	snap ring	1	1
123	油线	oil wick		



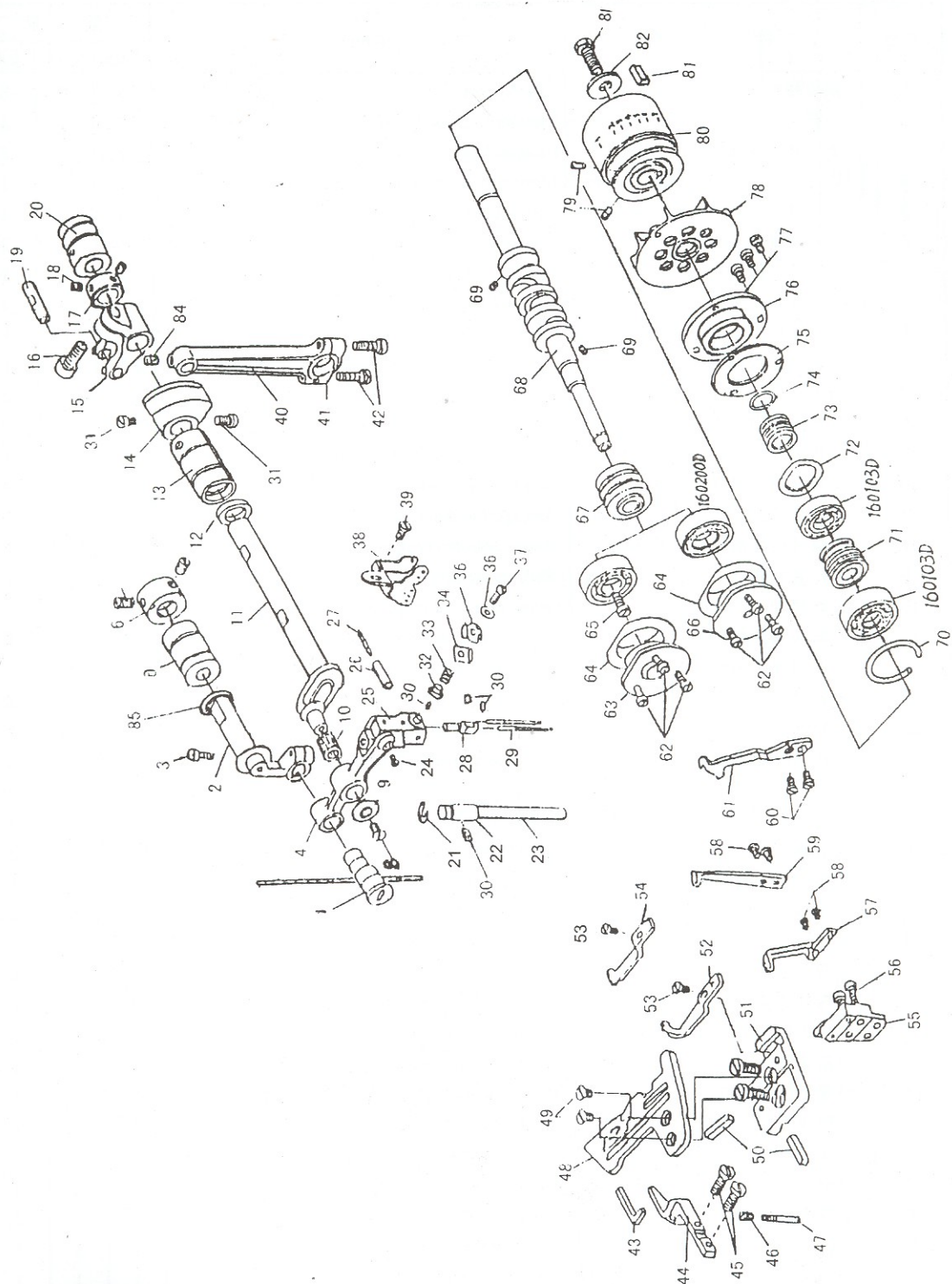


主轴针杆部件

Main shaft and needle bar assemblies

件号	名 称	Name	数 量		
			三线	四线	五线
1	偏心轴	eccentric shaft	1	1	1
2	机针传动摆轴	needle bar driving frame rock shaft	1	1	1
3	偏心轴紧固螺钉	eccentric shaf set screw	1	1	1
4	机针传动杆	needle bar actuating arm	1	1	1
5	机针传动铜轴承	needle bar driving copper shaft bearing	1	1	1
6	摆轴挡圈	frame rock shaft snap ring	1	1	1
7	挡圈紧定螺钉	snap ring set screw	2	2	2
8	滚针轴承螺钉	needle bearing screw	1	1	1
9	滚针轴承螺钉垫圈	needle bearing screw washer	1	1	1
10	机针传动滚针轴承	needle bar driving bearing	1	1	1
11	机针摆轴	needle bar frame rock shaft	1	1	1
12	机针摆轴油封	needle bar frame rock shaft oil seal	1	1	1
13	机针传动前铜轴承	needle driving shaft bearing	1	1	1
14	平衡块	balance block	1	1	1
15	机针摆轴曲柄	needle bar frame rock shaft crank	1	1	1
16	内六角螺钉	hexagon socket screw	1	1	1
17	挡圈	snap ring	1	1	1
18	挡圈紧定螺钉	snap ring set screw	2	2	2
19	连杆销	connecting link pin	1	1	1
20	机针传动后铜轴承	needle bar rear driving copper bearing	1	1	1
21	档圈GB896-86-8	shaft end bushing washer GB896-86-8	1	1	1
22	针杆偏心套	needle bar eccentric bush	1	1	1
23	针杆	needle bar	1	1	1
24	针杆滑块销闷头螺钉	needle bar slide block pin screw	1	1	1
25	针杆滑块	needle bar slide block	1	1	1
26	针杆滑块销	needle bar slide block pin	1	1	1
27	油线	oil wick	1	1	1
28	针类	needle clamp	1	1	1
29	机针	needle	1	2	2
30	内六角紧定螺钉	hexagon socket screw	4	5	5
31	平衡块紧定螺钉	balance block position screw	2	2	2
32	挡线板导向套	thread controller disc guide bushing	1	1	1
33	异向套弹簧	guide bushing spring	1	1	1
34	拦线板	thread controller disc	1	1	1
35	拦线板支架	thread controller disc holder	1	1	1
36	拦线板螺钉垫圈	thread contoller screw washer	1	1	1
37	拦线板螺钉	needle controller set screw	1	1	1
38	双眼过线	thread guide for 2-thread	1	1	1
39	三眼过线紧固螺钉	thread guide for 3-thread set screw	1	1	1
40	机针传动连杆	needle bar connecting rod	1	1	1
41	连杆盖	link cover	1	1	1
42	轴位螺钉	shaft position screw	2	2	2

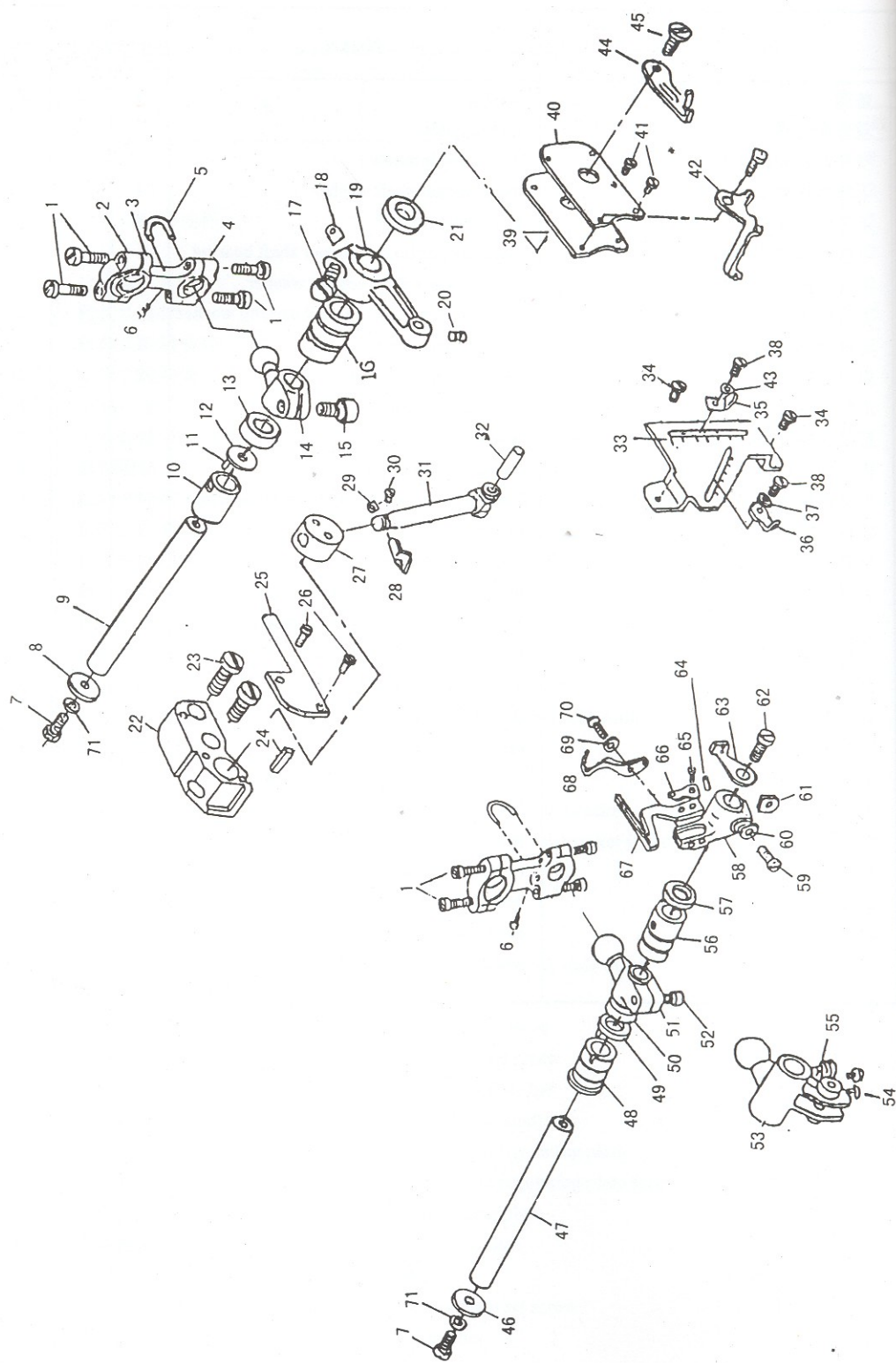
件号	名 称	Name	数 量	
			三线	四线
43	针板橡胶垫	throat plate rubber cushion	1	1
44	针板支架	throat plate supporter	1	1
45	针板支架紧固螺钉	throat plate supporter set screw	2	2
46	调整固定螺钉	adjusting set screw	1	1
47	轴螺钉	shaft screw	1	1
48	针板	throat plate	1	1
49	针板螺钉	throat plate screw	2	2
50	针板定位键	throat plate positioning rod	2	2
51	针板座	throat plat barcket	1	1
52	前护针板	front needle guard		
53	前护针板螺钉	front needle guard screw	1	1
54	前护针板 (三线)	front needle guard (for 3-thread)	1	1
55	前护针板 (五线)	needle guard holder (for 5-thread)		
56	护针板架螺钉	needle guard holder screw	2	2
57	后直针后护针板 (五线)	rear neelde guard for rear needle		
58	护针板螺钉	needle guard screw		
59	后直针前护针板 (五线)	rear needle guard for front needle		
60	上挑线勾固定螺钉	upper thread take-up set screw	1	1
61	上挑线勾	upper thread take-up		
62	前轴承座螺钉	front shaft bearing bracket screw	3	3
63	三线轴承座	shaft bearing bracket(for 3-thread)	1	1
64	前轴承座垫片	front shaft bearing bracket washer	1	1
65	主轴堵螺钉	main shaft screw	1	1
66	轴承座	shaft bearing bracket		
67	主轴中轴套	main shaft bushing asm	1	1
68	主轴	main shaft	1	1
69	主轴螺塞	main shaft screw	4	4
70	孔用弹性挡圈	shaft end bushing washer	1	1
71	油泵蜗杆	oil pump worm	1	1
72	弹性垫圈	elastic washer	1	1
73	油封	oil seal	1	1
74	O型密封圈	"o"shape seal ring	1	1
75	后轴承盖垫片	rear shaft bearing cover washer	1	1
76	后轴承盖	rear shaft bearing cover	1	1
77	后轴承盖螺钉	rear shaft bearing cover screw	3	3
78	叶轮	wheel	1	1
79	带轮紧定螺钉	pulley set screw	2	2
80	皮带轮	pulley	1	1
81	皮带轮平键	pulley pin	1	1
82	垫圈	washer	1	1
83	带轮轴间固定螺钉	pulley set screw	1	1
84	摆轴坚强固螺钉	frame rock shaft set screw	2	2



上、下弯针部件 upper and lower looper assemblies

件号	名 称	Name	数 量		
			三线	四线	五
1	轴位螺钉	shaft screw	8	8	
2	连杆上盖	looper link upper cover	2	2	
3	上下弯针球连杆	looper link	2	2	
4	连杆下盖	looper link lower cover	2	2	
5	止摆轴	guide shaft	2	2	
6	圆柱头螺钉	screw	2	2	
7	六角头开槽螺钉	hexagon screw	2	2	
8	上弯针轴垫圈	upper looper shaft washer	1	1	
9	上弯针轴	upper looper shaft	1	1	
10	上弯针球曲柄铜轴承(后)	upper looper crank copper shaft bearing(rear)	1	1	
11	铜垫圈销	copper washer pin	2	2	
12	上弯针轴铜垫圈	upper looper crank copper washer	1	1	
13	上弯针轴套	upper looper shaft bushing	1	1	
14	上弯针球曲柄	upper looper crank	1	1	
15	内六角螺钉	hexagon socket screw	2	2	
16	下弯针球曲柄铜轴承(前)	lower looper crank copper shaft bearing(front)	1	1	
17	连杆紧定螺钉	link set screw	1	1	
18	连杆垫片	connecting rod washer	1	1	
19	上弯针滑杆连杆	upper looper slide bar connecting rod	1	1	
20	连杆销固定螺钉	link pin set screw	1	1	
21	油封	oil seal	2	2	
22	上弯针滑杆座	upper looper slide bar bracket	1	1	
23	上弯针滑杆座轴位螺钉	upper looper slide bar bracket set screw	2	2	
24	油封	oil seal	2	2	
25	挡板	guard	1	1	
26	挡板螺钉	guard screw	2	2	
27	上弯针滑杆滑块	upper looper slide bar slide block	1	1	
28	上弯针	upper looper	1	1	
29	上弯针垫片	upper looper washer	1	1	
30	上弯针紧定螺钉	upper looper set screw	1	1	
31	上弯针滑杆	upper looper slide bar	1	1	
32	连杆轴销	connecting rod shaft pin	1	1	
33	线量调节板	thread amount regulating plate	1	1	
34	线量调节板螺钉	thread amount regulating plate screw	2	2	
35	右穿线板	right threading plate	1	1	
36	左线线板	left threading plate	1	1	
37	垫圈	washer	2	2	
38	穿线板紧定螺钉	threading plate set screw	2	2	
39	盖板垫片	cover washer	1	1	
40	盖板	cover	1	1	
41	盖板螺钉	cover screw	3	3	
42	三眼过线	thread guide for 3-thread	1	1	

件号	名 称	Name	数 量		
			三线	四线	五线
43	垫圈	washer	2	2	2
44	双弯针过线板	thread guide	1	1	1
45	双弯针过线板螺钉	thread guide screw	3	3	3
46	下弯针轴垫圈	lower looper shaft washer	1	1	1
47	下弯针轴	lower looper shaft	1	1	1
48	下弯针架轴铜轴承	lower looper holder copper shaft bearing	1	1	1
49	下弯针轴铜垫圈	lower looper shaft copper washer	1	1	1
50	下弯针轴铜套垫圈	lower looper shaft copper bushing washer	1	1	1
51	下弯针球曲柄	lower looper crank	1	1	
52	内六角螺钉	hexagon socket screw	2	2	2
53	下弯针球曲柄	lower looper crank			1
54	圆柱头螺钉	screw			2
55	内六角螺钉	hexagon socket screw			2
56	下弯针架铜轴承	lower looper holder copper shaft bearing	1	1	1
57	油封	oil seal	1	1	1
58	下弯针架	lower looper holder	1	1	1
59	下弯针架紧定螺钉	lower looper holder set screw	1	1	1
60	下弯针架螺钉垫圈	lower looper holder screw washer	1	1	1
61	下弯针架垫片	lower looper holder washer	1	1	1
62	双弯针过线螺钉	thread guide screw	3	3	3
63	过线板	thread guide	1	1	1
64	定位铆钉	set rivet	2	2	2
65	下弯针过线螺钉	lower looper thread guide screw	1	1	1
66	下弯针过线	lower looper thread guide	1	1	1
67	下弯针	lower looper	1	1	1
68	后直针后护针板	rear needle guard			1
69	护针螺钉垫圈	needle guard washer			1
70	护针固定螺钉	needle guard set screw			1
71	垫圈 5 GB 93-76	washer			2

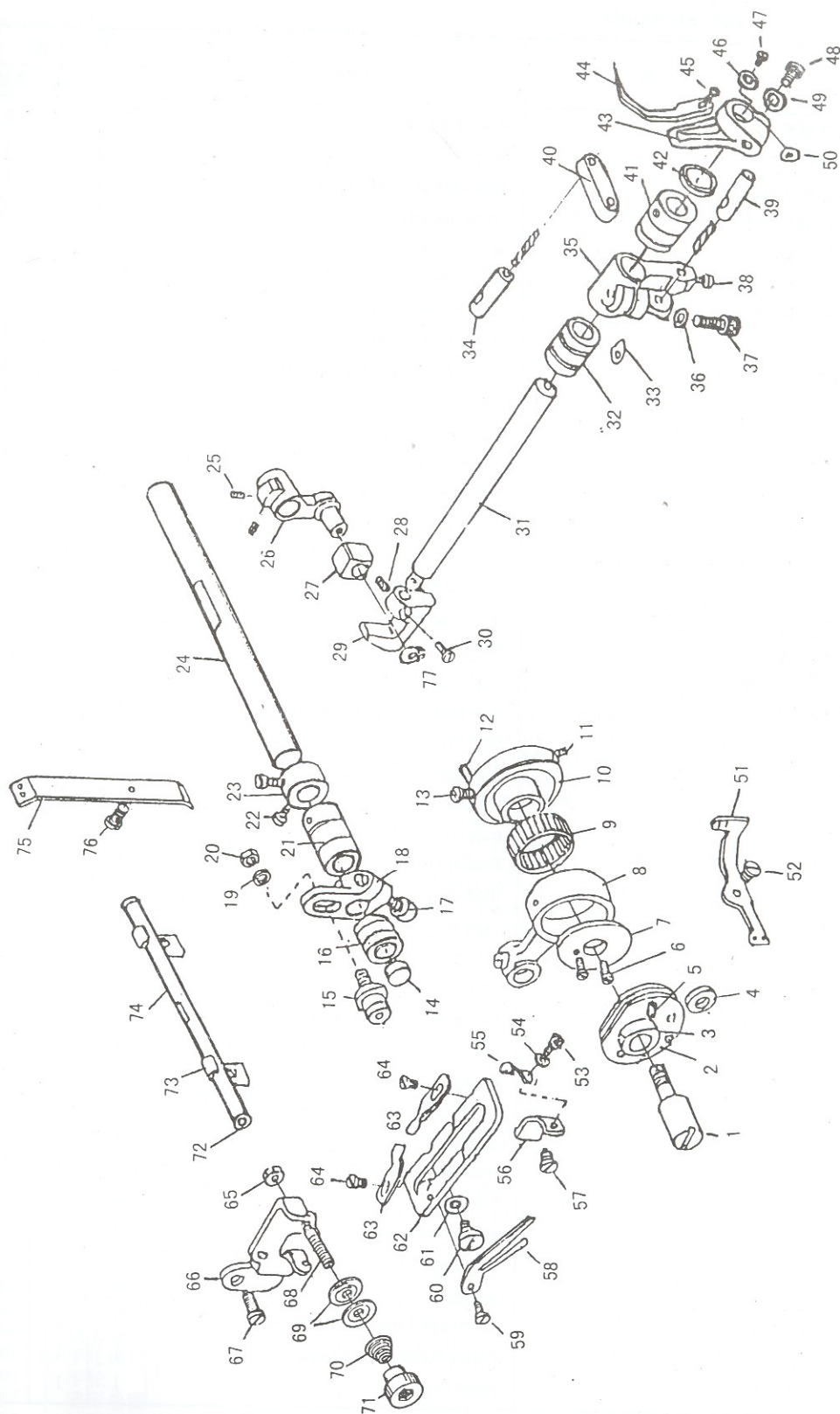


前弯针部件

Front lower looper assemblies

件号	名 称	Name	数 量		
			三线	四线	五线
1	凸轮轴	cam shaft			1
2	张力变换凸轮	tension adjusting cam			1
3	凸轮轴套	cam shaft bushing			1
4	凸轮中间套	cam centre bushing			1
5	凸轮固定螺钉	cam set screw			2
6	挡圈螺钉	snep ring screw			2
7	横轴曲柄连杆挡圈	shaft crank connecting rod snap ring			1
8	横轴曲柄连杆	shaft crank connecting rod			1
9	横轴连杆滚针轴承	shaft connecting link rolling pin bearing			1
10	横轴曲柄连杆凸轮	shaft crank connecting rod cam			1
11	内六角紧定螺钉	hexagon socket set screw			3
12	销	pin			1
13	螺钉	screw			1
14	油封	oil seal			1
15	曲柄销	crank pin			1
16	前弯针横轴铜轴承	front looper copper shaft bearing			1
17	曲柄紧固螺钉	crank set screw			1
18	横轴曲柄	shaft crank			1
19	曲柄调整销垫圈	crank adjusting pin washer			1
20	曲柄调整螺母	crank adjusting pin nut			1
21	前弯针横轴铜轴承	front looper copper shaft bearing			1
22	螺钉	screw			2
23	横轴挡圈	shaft snap ring			1
24	前弯针横轴	front looper shaft			1
25	内六角紧定螺母	hexagon socket set screw			2
26	驱动曲柄	driving crank			1
27	前弯针滑块	front looper slide block			1
28	驱动座固定螺钉	driving lever set screw			1
29	驱动座	driving lever			1
30	驱动座固定螺钉	driving lever set screw			1
31	前弯针轴	front looper shaft			1
32	前弯针纵轴铜轴承(后)	front looper copper shaft bearing(rear)			1
33	前弯针曲柄垫圈	front looper crank washer			1
34	前弯针连杆销	front looper link pin			1
35	前弯针曲柄	front looper crank			1
36	垫圈	washer			1
37	内六角螺钉	hexagon socket screw			1
38	前弯针连杆销螺钉	front looper link pin screw			1
39	前弯针连杆销	front looper link pin			1
40	前弯针连杆	front looper link			1
41	前弯针纵轴铜轴承(前)	front looper copper shaft bearing (front)			1
42	油封	oil seal			1

件号	名 称	Name	数 量	
			三线	四线
43	前弯针架	front looper holder		
44	前弯针	front looper		
45	前弯针勾固定螺钉	front looper thread guide set screw		
46	前弯针勾调节垫片	front looper thread guide washer		
47	前弯针勾定位螺钉	front looper thread guide set screw		
48	前弯针架紧固螺钉	front looper holder set screw		
49	垫圈	washer		
50	前弯针架垫片	front looper holder washer		
51	二眼过线	thread guide for 2-thread		
52	二眼过线螺钉	thread guide for 2-thread screw		
53	过线环螺钉	thread guide hook screw		
54	过线环螺钉垫片	thread guide hook screw washer		
55	过线环	thread guide hook		
56	限位板	position plate		
57	限位板螺钉	position plate screw		
58	导线板	thread guide plate		
59	导线板螺钉	thread guide plate screw		
60	导线架固定螺钉	thread guide finger set screw		
61	波形垫圈	corrugated washer		
62	前弯针导线架	front looper thread guide finger		
63	过线板	thread guide plate		
64	过线板螺钉	thread guide plate screw		
65	压线螺钉螺母	thread tension screw nut		
66	压线器架	thread tension plate holder		
67	前弯针后导线板螺钉	front looper rear thread guide plate screw		
68	压线螺钉	thread tension screw		
69	压线板	thread tension disc		
70	压线弹簧	thread tension spring		
71	压线螺母	thread tension nut		
72	过线管套	thread guide tube bushing		
73	过线管压板	thread guide tube clamp		
74	过线管	thread guide tube		
75	前弯针后导线板	front looper rear thread guide plate		
76	前弯针后导线板螺钉	front looper rear thread guide plate screw		
77	挡圈 GB 894.1-86-8	snap ring		

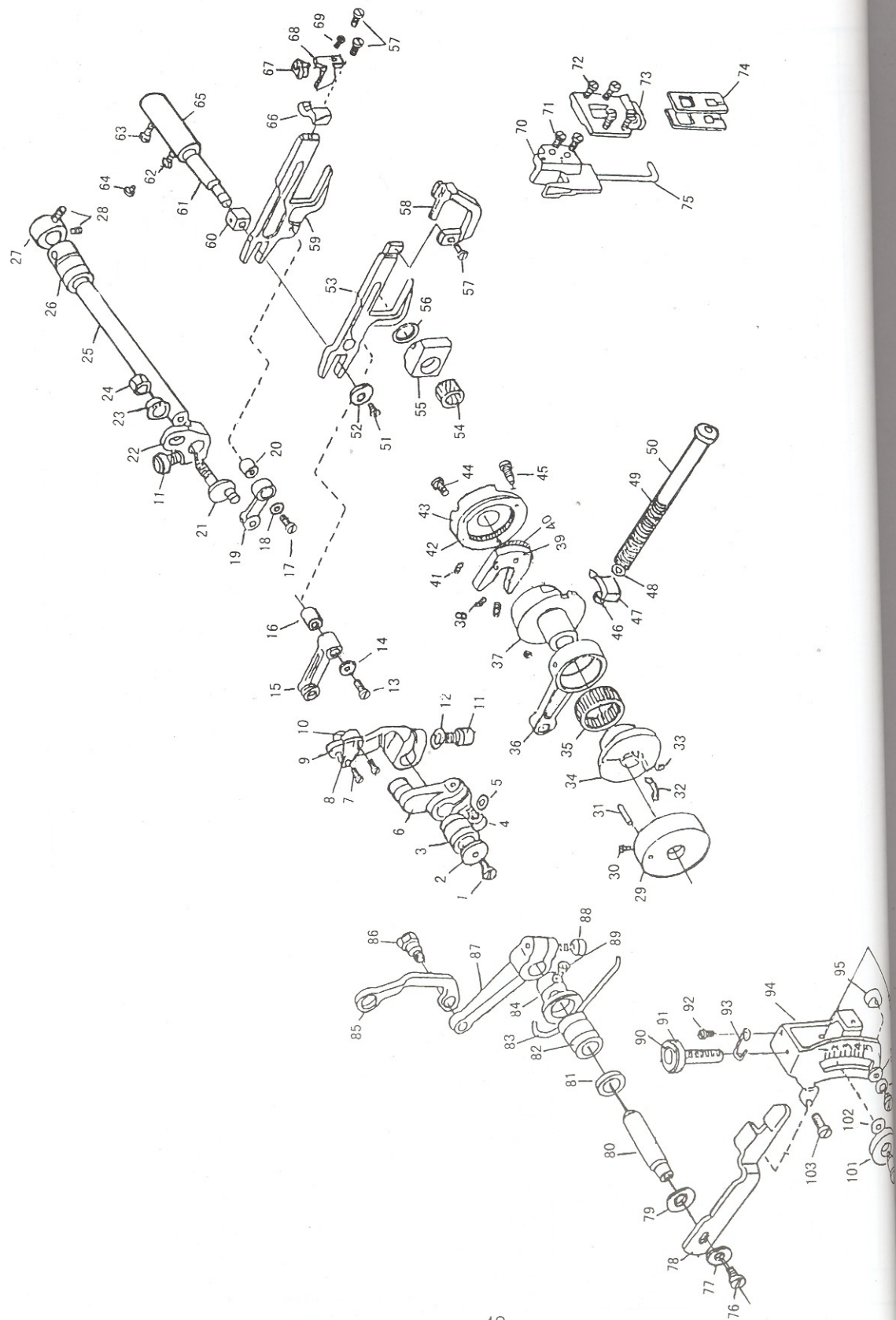


送料部件

Feed assemblies

件号	名 称	Name	数	
			三线	四线
1	挡圈螺钉	snap ring screw	2	2
2	挡圈	snap ring	1	1
3	送布轴铜轴承	feed copper shaft bearing	1	1
4	曲柄紧固螺钉	crank set screw	2	2
5	曲柄垫圈	crank washer	1	1
6	送布曲柄	feed crank	1	1
7	滑块盖板螺钉	slide block cover screw	1	1
8	滑块盖板	slide block cover	1	1
9	差动牙调整曲柄	differential feed dog regulating crank	1	1
10	滑块	slide block	1	1
11	曲柄紧固螺钉	crank set screw	2	2
12	曲柄垫圈	crank washer	1	1
13	差动牙架连杆套螺栓	differential feed dog link bushing screw	1	1
14	差动牙架连杆套垫圈	washer	1	1
15	差动牙架连杆	differential feed dog holder link	1	1
16	差动牙架连杆套	differential feed dog holder link bushin	1	1
17	送布牙架连杆套螺栓	feed dog holder link bushing screw	1	1
18	送布牙架连杆套垫圈	washer	1	1
19	送布牙架连杆	feed dog holder link	1	1
20	送布牙架连杆套	feed dog holder link bushing	1	1
21	送布牙架连杆偏心轴	feed dog link eccentric shaft	1	1
22	送布调整曲柄	feed regulating crank	1	1
23	垫圈	washer	1	1
24	偏心轴螺母	eccentric shaft nut	1	1
25	送布轴	feed shaft	1	1
26	送布轴铜轴承	feed copper shaft bearing	1	1
27	挡圈	snap ring	1	1
28	紧定螺钉	set screw	3	3
29	偏心轮挡圈	snap ring	1	1
30	内六角紧定螺钉	hexagon socket set screw	3	3
31	销	pin	1	1
32	弹簧	spring	1	1
33	内六角紧定螺钉	hexagon socket set screw	1	1
34	送布凸轮	feed cam	1	1
35	送布连杆滚针轴承	feed rod rolling pin bearing	1	1
36	送布连杆	feed link	1	1
37	针距凸轮	stitch length cam	1	1
40	扇形齿环	fan-shaped ring	1	1
38	弹簧	spring	2	2
39	扇形齿环固定滑块	fan-shaped ring set blade block	1	1
41	拉杆曲柄轴垫圈	puller crank shaft washer	1	1
42	调节定位齿圈	positon ring.	1	1

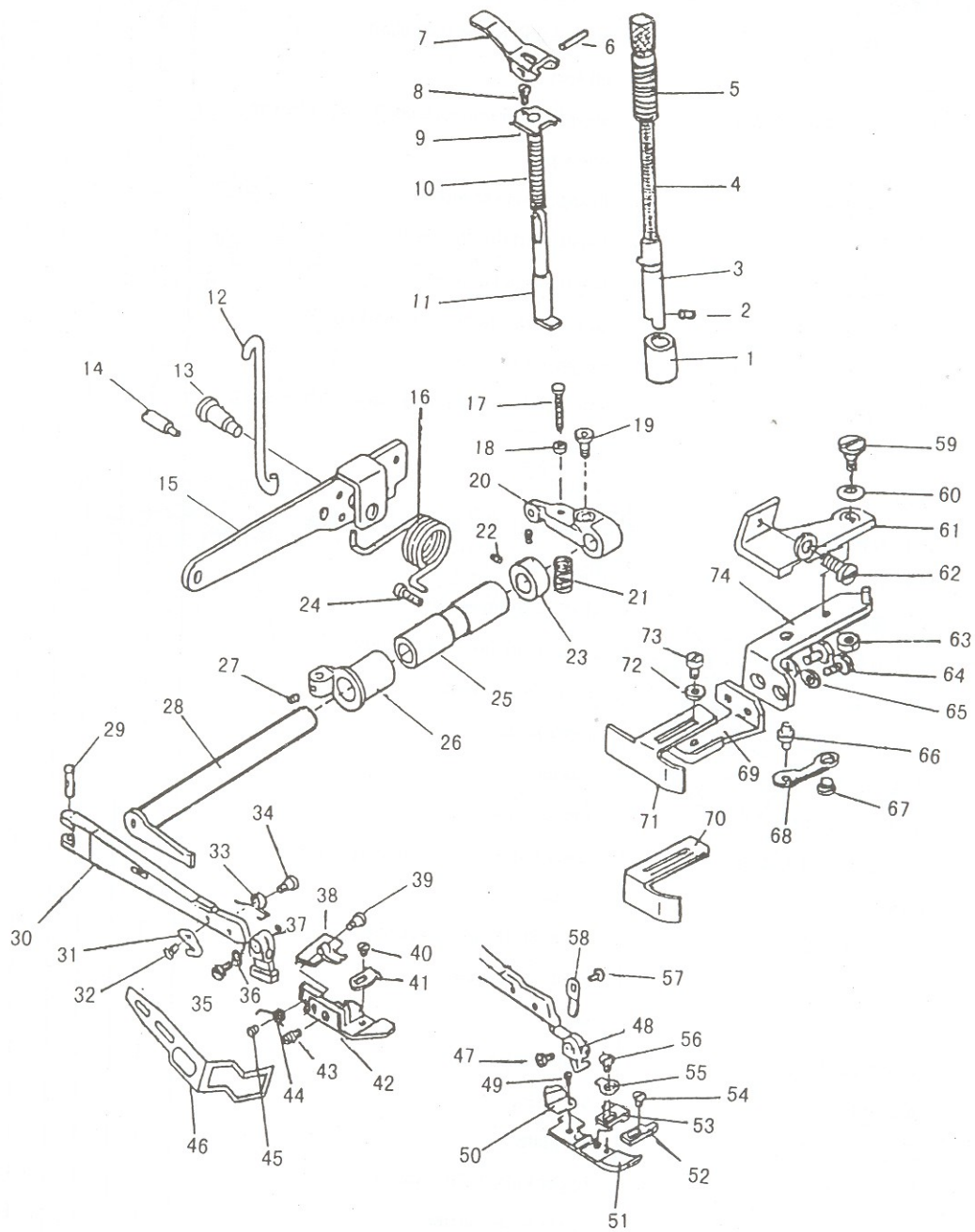
件号	名 称	Name	数 量		
			三线	四线	五线
43	齿圈座	ring plate			
44	螺钉	screw	1	1	1
45	螺钉	screw	2	2	2
46	固定螺钉	set screw	1	1	1
47	针距调节块	stitch length regulating block	1	1	1
48	O型密封圈	o-shaped seal ring	1	1	1
49	弹簧	spring	1	1	1
50	针距调节轴	stitch length reglating shaft	1	1	1
51	挡圈螺钉	snap ring screw	1	1	1
52	差动送布滑块	differential feed slide block	1	1	1
53	差动牙架	differential feed dog holaer	1	1	1
54	滚针轴承	shaft bearing	1	1	1
55	抬牙滑块	feed dog lift slide block	1	1	1
56	挡圈	snap ring	1	1	1
57	螺钉	screw	1	1	1
58	差动牙	diferential feed dog	3	3	3
59	送布牙架	feed dog holer	1	1	1
60	差动送布滑块	differential feed slide block	1	1	1
61	滑块偏心轴	slide block eccentric shaft	1	1	1
62	滑块偏心轴螺钉	slide block eccetric shaft screw	1	1	1
63	滑块轴固定套螺钉	slide block shaft set bushing screw	1	1	1
64	油封	oil seal	1	1	1
65	滑块轴固定套	slide block shaft set bushing	1	1	1
66	送布牙底板	feed dog plate	1	1	1
67	副送布牙	feed dog	1	1	1
68	主送布牙	main fed dog	1	1	1
69	副送布牙螺钉	feed dog screw	1	1	1
70	牙架导轨	feed dog carrier connection rod	1	1	1
71	牙架导轨螺钉	feed dog carrier connecting rod screw	2	2	2
72	密封导架螺钉	sealing connecting screw	4	4	4
73	密封导架	sealing connecting rod	1	1	1
74	活动油封	adjustable oil seal	2	2	2
75	油封	oil seal	1	1	1
76	挡圈螺钉	snap ring screw	1	1	1
77	O型密封圈	O-shaped seal ring	1	1	1
78	差动调节板手	diferential feed regulaing handle	1	1	1
79	拉杆曲柄轴垫圈	puller crank shaft washer	1	1	1
80	拉杆曲柄轴	puller crank shaft	1	1	1
81	油封	oil seal	1	1	1
82	拉杆曲柄铜轴承	puller crank copper shaft bearing	1	1	1
83	差动拉手扭簧	differential feed spring	1	1	1
84	拉杆曲柄轴挡圈	puller crank shaft snap ring	1	1	1
85	差动调节连杆	differential feed regulating link	1	1	1
86	轴位螺钉	shaft posiion screw	1	1	1
87	差动调节曲柄	differential feed regulating crank	1	1	1
88	差动调节曲柄螺钉	differential feed regulating crank screw	1	1	1
89	挡圈紧定螺钉	snap ing set screw	1	1	1
90	标记牌	mark plate	1	1	1
91	调节螺栓手轮	regulating screw wheel	1	1	1
92	调节螺栓卡簧螺栓	regulating screw spring screw	1	1	1
93	调节螺栓卡簧	regulating screw spring	1	1	1
94	针距调节指示板	stitch length regulator indicating plate	1	1	1
95	调节螺钉螺母	regulatign screw nut	1	1	1
96	针距调节曲柄螺钉	stitch length regulating crank screw	1	1	1
97	调节螺钉垫圈	regulating screw washer	2	2	2
98	碟形垫圈	washer	1	1	1
99	调节螺钉	regulating screw	1	1	1
100	手轮螺钉	hand wheel screw	1	1	1
101	手轮	hand wheel	1	1	1
102	碟形垫圈	washer	1	1	1
103	针距调节曲柄螺钉	stitch length regulating crank screw	1	1	1



抬压脚部件 Presser foot assemblies

件号	名 称	Name	数 量		
			三线	四线	五线
1	压杆套	presser bar bushing	1	1	1
2	弹性销	plastic pin	1	1	1
3	压杆头	presser bar head	1	1	1
4	压杆弹簧	presser bar spring	1	1	1
5	调压螺钉	presser regulating screw	1	1	1
6	销	pin	1	1	1
7	抬压脚扳手	presser foot lifting handle	1	1	1
8	抬压脚盖板螺钉	presser foot shaft bushing set screw	1	1	1
9	抬压脚盖板	presser foot lifting cover	1	1	1
10	抬压脚弹簧	presser foot lifting spring	1	1	1
11	抬压脚杆	presser foot lifting arm	1	1	1
12	吊钩	hook	1	1	1
13	抬压脚杠杆轴螺钉	presser foot lifting lever shaft screw	1	1	1
14	抬压脚杠杆定位螺钉	presser foot lifting lever set screw	1	1	1
15	抬脚杠杆	presser foot lifting lever	1	1	1
16	杠杆弹簧	lever spring	1	1	1
17	限位螺钉	position screw	1	1	1
18	螺母	nut	1	1	1
19	内六角螺钉	hexagon socket screw	1	1	1
20	抬压脚轴杠杆	presser foot lifting shaft lever	1	1	1
21	杠杆弹簧	lever spring	1	1	1
22	内六角紧定螺钉	hexagon socket set screw	3	3	3
23	挡圈	snap ring	1	1	1
24	压脚轴套固定螺钉	presser foot shaft bushing set screw	1	1	1
25	压脚轴套	presser foot shaft bushing	1	1	1
26	压脚臂铰链	presser foot arm hinge	1	1	1
27	内六角紧定螺钉	hexagon socket set screw	3	3	3
28	抬压脚轴组件	presser foot lifting shaft asm	1	1	1
29	铰链销	hinge pin	1	1	1
30	抬压脚臂	presser foot lifting arm	1	1	1
31	割线刀	thread cutting knife	1	1	1
32	割线刀螺钉	thread cutting knife screw	1	1	1
33	弹簧	spring			1
34	紧固弹簧螺钉	set spring screw			1
35	压脚托架螺钉	presser foot holder screw			1
36	压脚托架垫圈	presser foot holder washer			1
37	压脚托架	presser foot holder			1
38	副压脚	presser foot			1
39	副压脚螺钉	presser foot screw			1
40	缝料调节板螺钉	cloth regulating plate screw			1
41	缝料调了板	cloth regulating plate			1
42	主压脚底板	main presser foot base			1

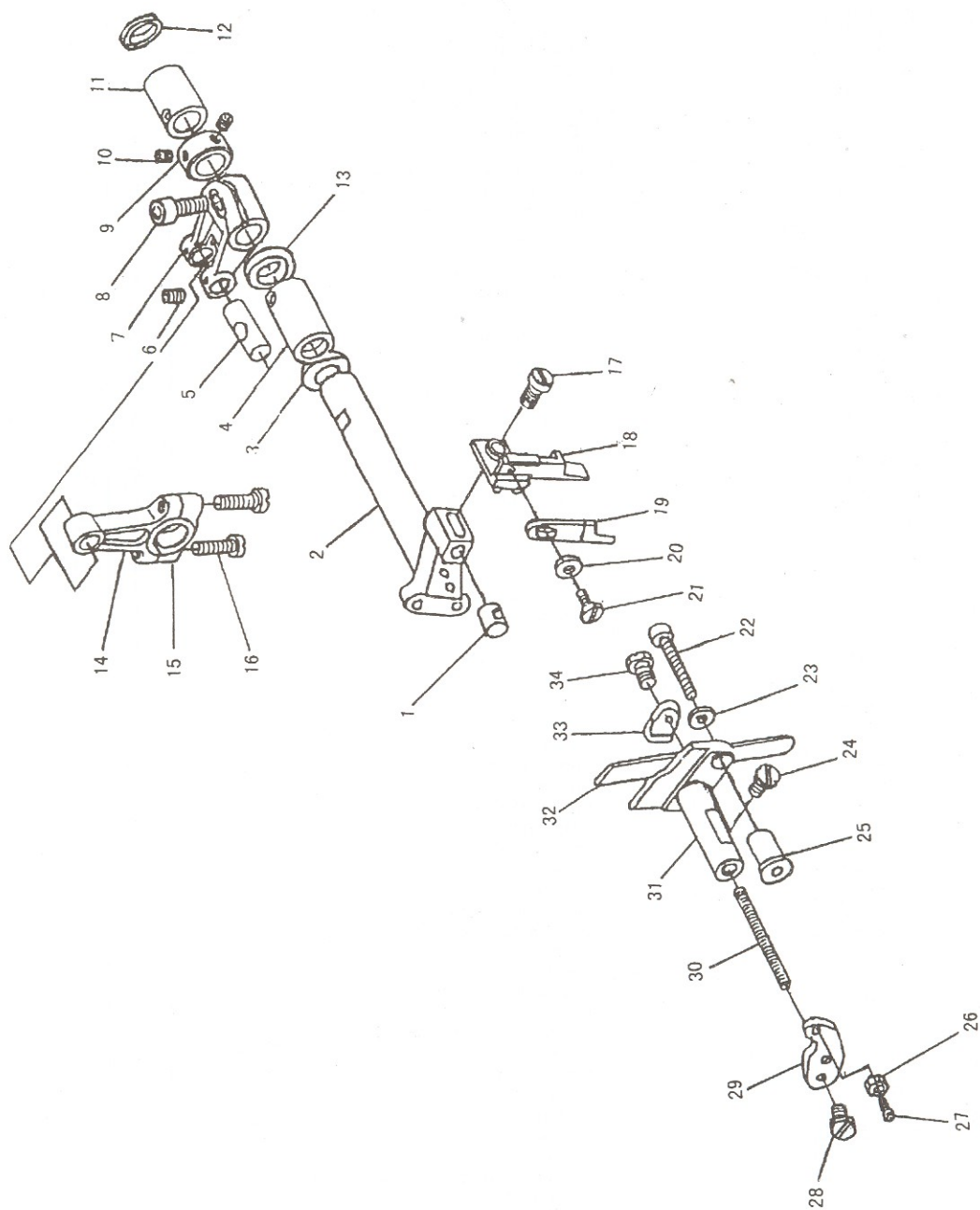
件号	名 称	Name	数 量		
			三线	四线	五线
43	主压脚底板螺钉	main presser foot base screw			1
44	副压脚弹簧	presser foot spring			1
45	螺母	nut	1	1	1
46	上护针	upper needle guard	1	1	
47	压脚托架螺钉	presser foot holder screw	1	1	
48	压脚托架	presser foot holder	1	1	
49	压脚罩板螺钉	presser foot cover screw	1	1	
50	压脚罩板	presser foot cover	1	1	
51	压脚底板	presser foot base	1	1	
52	挡布板	cloth guard	1	1	
53	编结导块	winding guide block	1	1	
54	挡布板螺钉	cloth guard screw	1	1	
55	压脚定位卡	presser foot position washer	1	1	
56	编绕导块螺钉	winding guide block screw			1
57	紧固弹簧螺钉	set spring screw			1
58	压脚限位卡	presser foot position washer	1	1	1
59	铰链螺钉	hinge screw	1	1	1
60	碟形垫圈	washer	1	1	1
61	导布托架	cloth guide holder	1	1	1
62	螺钉	screw	2	1	1
63	螺母	nut	1	1	1
64	六角头开槽螺钉	hexagon screw	1	2	2
65	垫圈	washer		2	2
66	定位销	position pin	1	1	1
67	螺钉	screw	2	1	1
68	弹簧	spring	1	1	1
69	导布支架	cloth guide supportor	1	1	1
70	导布调节板	cloth guide regulating plate			1
71	导布调节板	cloth guide regulating plate	1	1	1
72	垫圈	washer	1	1	1
73	螺钉	screw	1	1	1
74	铰链	hinge	1	1	1



切刀部件

Trimming Knife assemblies

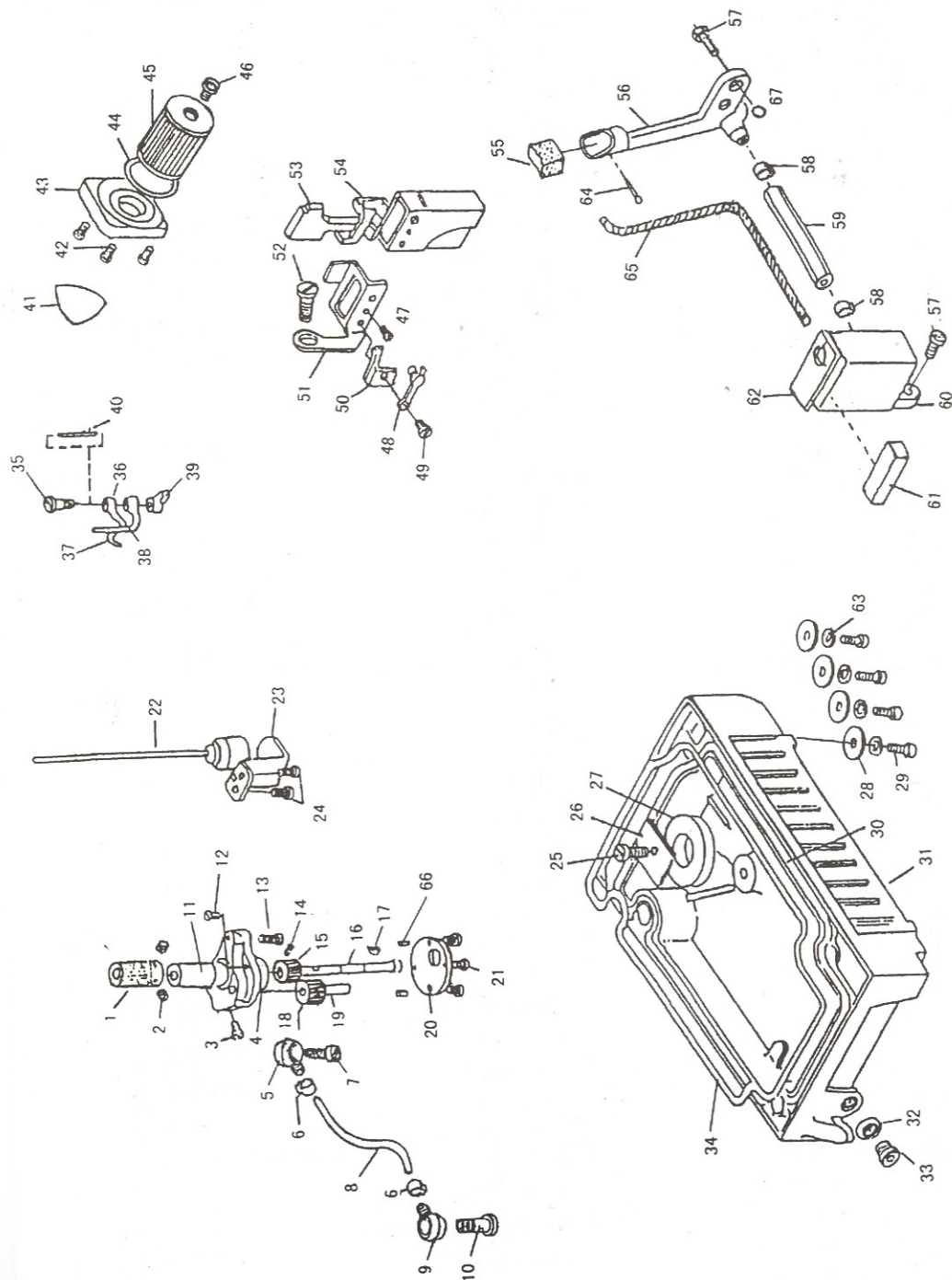
件号	名 称	Name	数 量		
			三线	四线	五线
1	短销子	short pin	1	1	1
2	上切刀摆轴	upper knife frame rock shaft	1	1	1
3	油封	oil seal	1	1	1
4	上切刀摆轴铜轴承(左)	upper knife frame rock shaft copper bearing	1	1	1
5	曲柄销	crank pin	1	1	1
6	内六角紧定螺钉	hexagon socket screw	1	1	1
7	上切刀传动曲柄	upper knife driving crank	1	1	1
8	内六角螺钉	hexagon socket screw	1	1	1
9	上切刀摆轴曲柄	upper knife frame rock shaft crank	1	1	1
10	挡圈紧定螺钉	snap ring set screw	1	1	1
11	上切刀摆轴铜轴承(右)	upper knife frame rock shaft copper bearing	1	1	1
12	油封	oil seal	1	1	1
13	垫圈	washer	1	1	1
14	上切刀传动连杆	upper knife driving connecting link	1	1	1
15	连杆盖	link cover	1	1	1
16	轴位螺钉	shaft position screw	2	2	2
17	上切刀架固定螺钉	upper knife holder set screw	1	1	1
18	上切刀架	upper knife holder	1	1	1
19	上切刀	upper knife	1	1	1
20	垫圈	washer	1	1	1
21	开槽六角头螺钉	hexagon screw	1	1	1
22	下刀架紧定调节螺钉	lower knife carrier adjusting screw	1	1	1
23	垫圈	washer	1	1	1
24	下刀架调节螺钉	lower knife carrier set screw	1	1	1
25	定位套筒	position bushing	1	1	1
26	螺母	nut	1	1	1
27	调节螺母	regulating screw	1	1	1
28	固定螺钉	set screw	1	1	1
29	固定板	set plate	1	1	1
30	上切刀压簧	upper knife holder spring	1	1	1
31	下切刀架	lower knife carrier	1	1	1
32	下切刀	lower knife	1	1	1
33	下切刀压板	lower knife holder locking plate	1	1	1
34	开槽六角头螺钉	hexagon screw	1	1	1



润滑部件

Lubrication assemblies

件号	名 称	Name	数 量		
			三线	四线	五线
1	油泵蜗轮	Oil pump worm gear	1	1	1
2	蜗杆紧定螺钉	worm set screw	2	2	2
3	油封螺钉	oil seal screw	1	1	1
4	油泵座	oil pump base	1	1	1
5	油管接头	oil tube movable joint	1	1	1
6	油管卡簧	oil tube snap ring	1	1	1
7	没管接头	oil tube joint	1	1	1
8	油管	oil tube	1	1	1
9	油管活接头	oil tube movable joint	1	1	1
10	油管接头	oil tube joint	1	1	1
11	油泵体	oil pump	2	2	2
12	油泵体固定螺钉	oil pump body set screw	1	1	1
13	油泵固定螺钉	oil pump set screw	2	2	2
14	龄轮紧定螺钉	rotator set screw	1	1	1
15	油泵齿轮	oil pump rotator	1	1	1
16	油泵主轴	oil pump main shaft	1	1	1
17	半圆键	semi-circular washer	1	1	1
18	油泵齿轮	oil pump rotator	1	1	1
19	油泵齿轮轴	oil pump roatator shaft	1	1	1
20	油泵底板	oil pump base plate	4	4	4
21	底板螺钉	base plate screw	1	1	1
22	浮标	bouy	1	1	1
23	浮标挡板	bouy guard	2	2	2
24	浮标挡板固定螺钉	bouy guard screw	1	1	1
25	磁铁座螺钉	magnet plate screw	1	1	1
26	磁铁座	magnet plate	1	1	1
27	磁铁	magnet	4	4	4
28	垫圈	washer	4	4	4
29	内六角螺钉	hexagon socket screw	1	1	1
30	引油垫	oil sucking gasket	1	1	1
31	油盘	oil pan	1	1	1
32	油封	oil seal	1	1	1
33	放油螺钉	oil drain screw	1	1	1
34	油封	oil seal	1	1	1
35	油管接头	oil tube joint	1	1	1
36	油管接头	oil tube joint	2	2	2
37	油管	oil tube	1	1	1
38	示油管	oil sight tube	1	1	1
39	油管固定套	oil tube clamp	1	1	1
40	挡油针	oil guard needle	1	1	1
41	指示牌	indicaing plate	1	1	1
42	固定螺钉	set screw	3	3	3
43	滤油器盖	oil screen cover	1	1	1
44	油封	oil seal	1	1	1
45	纸质滤油器	paper oil cleaner	1	1	1
46	滤油器接头	oil cleaner joint	1	1	1
47	螺钉	screw	1	1	1
48	防松垫	screw	1	1	1
49	过线板	tightening washer	1	1	1
50	三孔过线板	thread guide	1	1	1
51	螺钉	thread guide for 3-thread	1	1	1
52	过线油毡	screw	1	1	1
53	油毡架	thead guide oil felt	1	1	1
54	油毡	oil felt holder	1	1	1
55	机针冷却器	oil felt	1	1	1
56	螺钉	needle cooler	3	3	3
57	油管卡簧	screw	2	2	2
58	油管	oil tube shap ring	1	1	1
59	小油箱	oil tube	1	1	1
60	滤油毡	small oil box	1	1	1
61	小油箱盖	oil absorbent felt	1	1	1
62	垫圈GB 859-87	small oil box cover	1	1	1
63	大头针	washer	4	4	4
64	油线	pin	1	1	1
65	销3×16 GB859-86	oil wick	2	2	2
66	钢珠 Q4GB308-77	pin	1	1	1
67		steel ball			



台板、机架部件

Table & stand assemblies

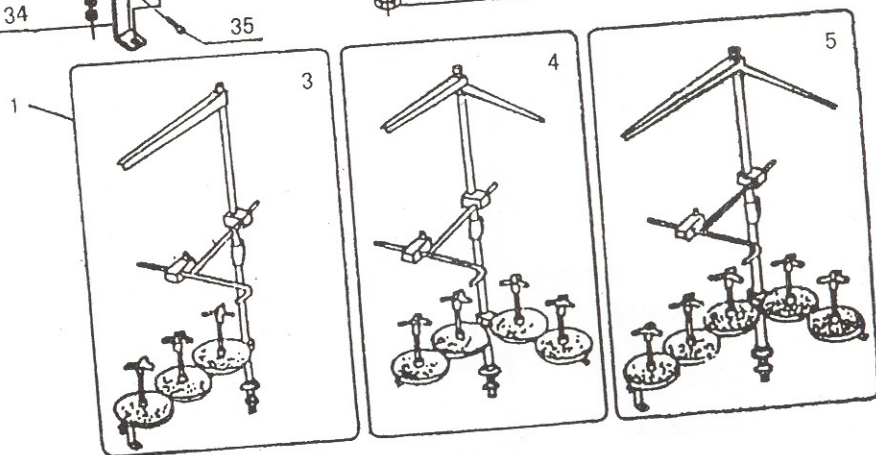
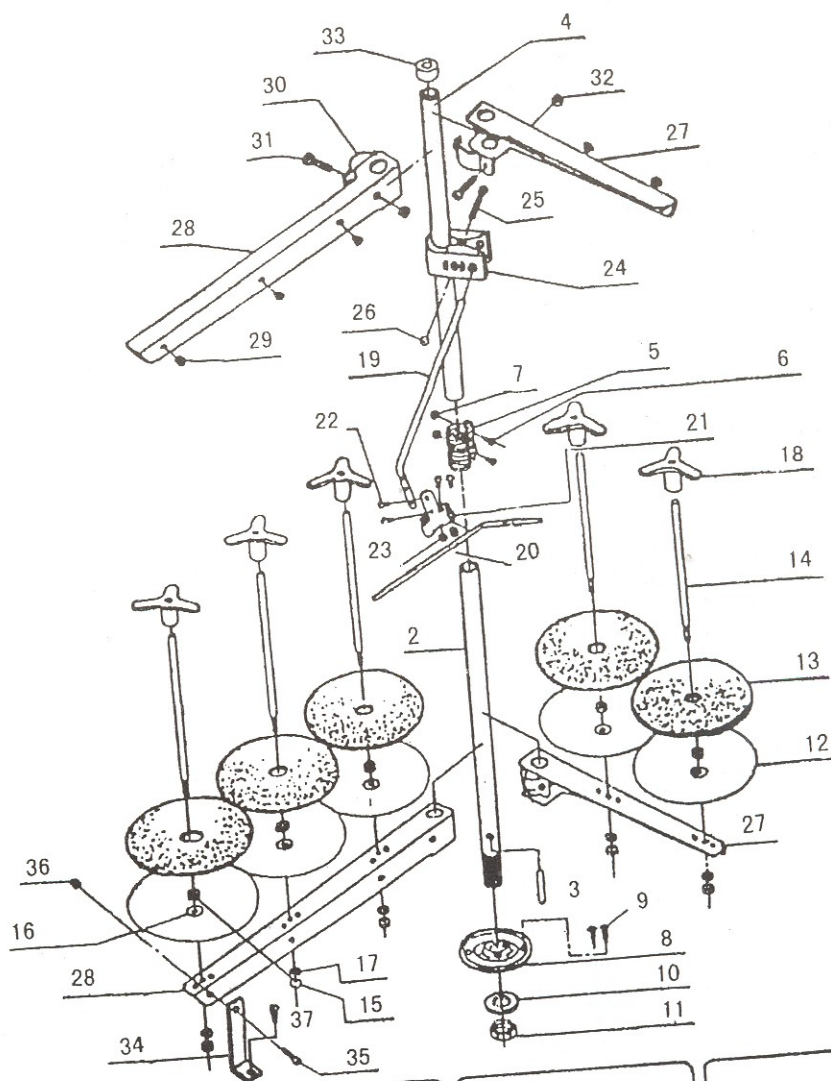
件号	名 称	Name	数 量		
			三线	四线	五
1	机架底档	Stank button rod	1		
GB5780-86	机架底档螺钉M6×12	Screw M6×12	4		
GB6172-86	机架底档螺钉螺母M6	Nut M6	4		
GB97-76	机架底档螺钉垫圈Φ6	Washer Φ6	4		
2	底档螺母	Nut	2		
3	踏板支座	Pedal support	4		
GB70-85	踏板支座螺钉M6×10	Screw M6×10	4		
GB97-76	踏板支座垫圈Φ6	Washer Φ6	4		
4	踏板轴套	Pedal stud bushing	4		
GB70-85	踏板轴套螺钉M6×10	Screw M6×10	4		
GB97-76	踏板轴套垫圈Φ6	Washer Φ6	4		
5	大踏板	Main pedal	1		
6	大踏板橡皮	Rubber	1		
7	小踏板	Mini-pedal	1		
8	小踏板橡皮	Rubber	1		
9	踏板连接杆	Pedal connecting bar	1		
GB70-85	踏板连接螺钉M6×10	Screw M6×10	2		
GB6172-86	踏板连接杆螺母M6	Nut M6	2		
GB97-76	踏板连接杆垫圈Φ6	Washer Φ6	2		
10	机架护套	Stand protector	4		
11	机架调节座避震套	stand adjusting anti-shock device	4		
12	机架调节座套	Stand adjusting device	4		
13	机架调节螺栓	Stand adjusting screw	4		
	机架调节座组件	Stand adjusting assembly	4		
GB6172-86	机架调节座螺母M12	Nut M12	4		
GB97-76	机架调节座垫圈Φ12	Washer Φ12	4		
14	机架底脚螺母	Nut	4		
15	脚架横档	Stand rod	2		
16	脚架直档	Stand rod	2		
16左	左脚架	Left stand	1		
16右	右脚架	Right stand	1		
17	台板直档	Table supporter	2		
18	台板横档	Tadle supporter	2		
18左	台板左撑档	Left supporter	1		
GB5780-85	台板左撑档螺钉M8×12	Screw M8×12	5		
18右	台板右撑档	Right supporter	1		
GB5780-85	台板右撑档螺钉M8×12	Screw M8×12	5		
GB97-76	左右撑档垫圈Φ8	Washer Φ8	10		
19	机架横档	Stand horizetial supporter	1		
GB5780-85	机架横档螺钉M8×12	Screw M8×12	4		
GB97-85	机架横档垫圈Φ8	Washer Φ8	4		
20	拉杆接头	Puller joint	1		
GB70-85	拉杆接头螺钉M6×20	Screw M6×20	1		

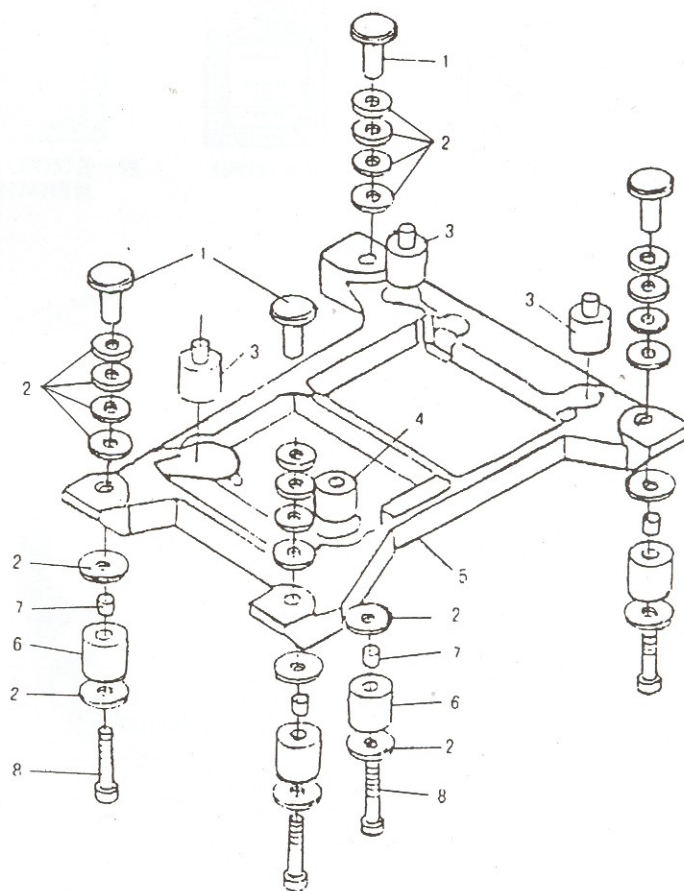
线架部件 Thread stand assemblies

件号	名 称	Name	数 量		
			三线	四线	五线
1	线架部件图	Thread stand complete			
2	线架下立柱	Lower thread column	1	1	1
3	线架下立柱园柱销 $\phi 6 \times 22$ GB119-76	Pin for 10-T $\phi 6 \times 22$	1	1	1
4	线架上立柱	Upper thread column	1	1	1
5	立柱接头	Column joint	1	1	1
6	立柱接头螺钉 $M5 \times 10$ GB65-85	Screw $M5 \times 10$	1	1	1
7	立柱接头螺母 $M5$ G41-86	Nut $M5$	2	2	2
8	线架固定座	Thread stand holder	2	2	2
9	线架固定座木螺钉 4×10 GB100-86	Screw 4×10	1	1	1
10	线架固定垫圈	Washer	2	2	2
11	线架固定螺母	Nut	1	1	1
12	线盘	Spool tray	1	1	1
13	线盘垫	Spool tray cushion	5	4	3
14	线柱	Spool pin	5	4	3
15	线柱螺母 $M6$ GB41-86	Nut $M6$	5	4	3
16	线柱垫圈 $\phi 6$ GB97-76	Washer $\phi 6$	10	8	6
17	线柱垫圈 $\phi 6$ TB859-76	Spring washer $\phi 6$	5	4	3
18	定心座	Centering device	5	4	3
19	中过线接杆	Middle thread guide connecting bar	5	4	3
20	中过线杆	Middle thread guide	1	1	1
21	中过线接头	Middle thread guide joint	1	1	1
22	中过线接头螺钉 $M4 \times 8$ GB65-85	Screw $M4 \times 8$	1	1	1
23	中过线接头螺母 $M4$ GB41-86	Nut $M4$	4	4	4
24	中过线夹紧板	Middle thread clamp plate	2	2	2
25	中过线夹紧板螺钉 $M5 \times 22$ GB65-85	Screw $M5 \times 22$	1	1	1
26	中过线夹紧板螺母 $M5$ GB41-86	Nut $M5$	1	1	1
27	二线穿线架、线盘架	Two thread spool tray bracket	1	1	1
28	三线穿线架、线盘架	Three thread spool tray bracket	2	4	
29	过线管	Thread tube	2		2
30	线盘架夹板	Spool tray holder	5	4	3
31	线盘架夹板螺钉 $M5 \times 18$ GB65-85	Screw $M5 \times 18$	4	4	2
32	线盘架夹板螺母 $M5$ GB41-86	Nut $M5$	4	4	2
33	上立柱橡皮封	upper column rubber seal	4	4	2
34	线架撑	Thread stand holder	1	1	1
35	线架撑螺钉 $M5 \times 8$ GB65-85	Screw $M5 \times 8$	1		1
36	线架撑螺母 $M5$ GB41-86	Nut $M5$	1		1
37	线架撑木螺钉 $M4 \times 10$ GB100-86	Screw $M4 \times 10$	1	1	1

线架部件 Thread stand assemblies

件号	名 称	Name	数 量		
			三线	四线	五线
1	线架部件图	Thread stand complete	1	1	1
2	线架下立柱	Lower thread column	1	1	1
3	线架下立柱园柱销 $\phi 6 \times 22$ GB119-76	Pin for 10-T $\phi 6 \times 22$	1	1	1
4	线架上立柱	Upper thread column	1	1	1
5	立柱接头	Column joint	1	1	1
6	立柱接头螺钉 $M5 \times 10$ GB65-85	Screw $M5 \times 10$	2	2	2
7	立柱接头螺母 $M5$ GB41-86	Nut $M5$	2	2	2
8	线架固定座	Thread stand holder	1	1	1
9	线架固定座木螺钉 4×10 GB100-86	Screw 4×10	2	2	2
10	线架固定垫圈	Washer	1	1	1
11	线架固定螺母	Nut	1	1	1
12	线盘	Spool tray	5	4	3
13	线盘垫	Spool tray cushion	5	4	3
14	线柱	Spool pin	5	4	3
15	线柱螺母 $M6$ GB41-86	Nut $M6$	10	8	6
16	线柱垫圈 $\phi 6$ GB97-76	Washer $\phi 6$	5	4	3
17	线柱垫圈 $\phi 6$ TB859-76	Spring washer $\phi 6$	5	4	3
18	定心座	Centering device	5	4	3
19	中过线接杆	Middle thread guide connecting bar	1	1	1
20	中过线杆	Middle thread guide	1	1	1
21	中过线接头	Middle thread guide joint	1	1	1
22	中过线接头螺钉 $M4 \times 8$ GB65-85	Screw $M4 \times 8$	4	4	4
23	中过线接头螺母 $M4$ GB41-86	Nut $M4$	2	2	2
24	中过线夹紧板	Middle thread clamp plate	1	1	1
25	中过线夹紧板螺钉 $M5 \times 22$ GB65-85	Screw $M5 \times 22$	1	1	1
26	中过线夹紧板螺母 $M5$ GB41-86	Nut $M5$	1	1	1
27	二线穿线架、线盘架	Two thread spool tray bracket	2	4	
28	三线穿线架、线盘架	Three thread spool tray bracket	2		2
29	过线管	Thread tube	5	4	3
30	线盘架夹板	Spool tray holder	4	4	2
31	线盘架夹板螺钉 $M5 \times 18$ GB65-85	Screw $M5 \times 18$	4	4	2
32	线盘架夹板螺母 $M5$ GB41-86	Nut $M5$	4	4	2
33	上立柱橡皮封	upper column rubber seal	1	1	1
34	线架撑	Thread stand holder	1		1
35	线架撑螺钉 $M5 \times 8$ GB65-85	Screw $M5 \times 8$	1		1
36	线架撑螺母 $M5$ GB41-86	Nut $M5$	1		1
37	线架撑木螺钉 $M4 \times 10$ GB100-86	Screw $M4 \times 10$	1	1	1





件号	名 称	Name	数 量		
			三线	四线	五线
1	托盘螺钉固定头	head plate screw set point	4	4	4
2	台板托盘连接垫	table plate connecting washer	28	28	28
3	机头防震垫	head shockproof cushion	3	3	3
4	机头防震垫	head shockproof cushion	1	1	1
5	机头托盘	machine head plate	1	1	1
6	台板托盘防震连接垫	table plate shockproof connecting washer	4	4	4
7	防震连接垫内套	washer bushing	4	4	4
8	托盘螺钉	plate screw	4	4	4

备件及附件 Spare parts and accessories

1. 备件 Spare parts

	型号		数量
	Model		Quantity
(1)机针 Needle	GN737	DC×27-14#	10pcs
	GN747	DC×27-11#	20pcs
	GN757	DC×27-14#	10pcs
		DM×13-14#	10pcs
(2)弯针 Looper	GN737	上弯针 Upper looper	1pcs
		下弯针 Lower looper	1pcs
	GN747	上弯针 Upper looper	1pcs
		下弯针 Lower looper	1pcs
	GN757	上弯针 Upper looper	1pcs
		下弯针 Lower looper	1pcs
		前弯针 Chain stitch looper	1pcs
			1pcs
(3)切刀 knife		上刀 Upper knife	1pcs
		下刀 Lower knife	1pcs
(4)滤油器	oil filter		1pcs

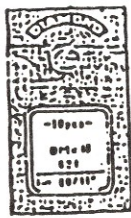
2. 附件 Accessories

(1) 机头托盘	oil pan guard plate	1pcs
(2) 缝纫机油(800毫升)特 18#	sewing machine oil (800ml)18#	1pcs
(3) 油壶	oil can	1pcs
(4) 大旋具	screw driver (Large)	1pcs
(5) 小旋具	screw driver (small)	1pcs
(6) 双头扳手(6MM)	spanner	1pcs
(7) 双头扳手(7MM)	spanner	1pcs
(8) 双头扳手(8MM)	spanner	1pcs
(9) 内六角扳手(1.5MM)	cross screw driver(1.5mm)	1pcs
(10) 内六角扳手(2MM)	cross screw driver(2mm)	1pcs
(11) 内六角扳手(5MM)	cross screw driver(5mm)	1pcs
(12) 内六角扳手(6MM)	cross screw driver(6mm)	1pcs
(13) 弯头镊钳	tweezer	1pcs
(14) 线勾	needle threader	1pcs
(15) 附件盒	attachment box	1pcs
(16) 说明书零件样本	parts list, instruction book	1pcs

1、备件



GN737 GN757各一包
GN747两包



GN757专用



滤油器



上弯针



下弯针



链线勾针(GN757专用)

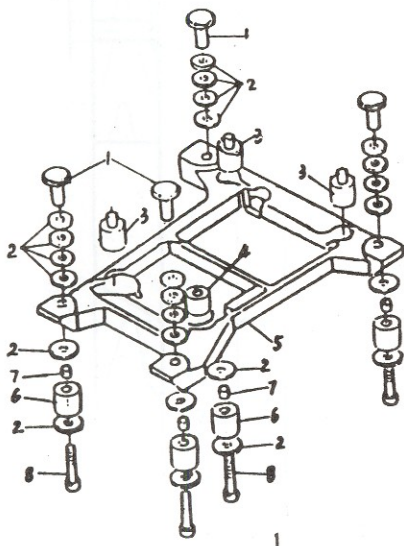


上切刀



下切刀

2、附件



4



5



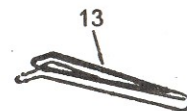
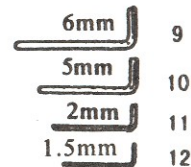
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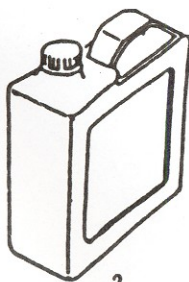
8



13



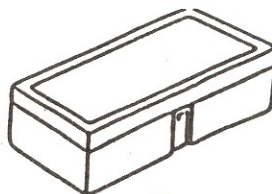
14



2



3



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16

