



Model GN1 - 113

中速三綫包縫機

**MEDIUM-SPEED THREE-THREAD
OVERLOCK SEWING MACHINES**

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前 言

GN1-113型包缝机通常是针织厂的专用设备，在缝制针织品（如汗衫、棉毛衫、卫生衫和羊毛衫裤等）时作包缝和包边之用。其主要技术规格如下：

1. 主轴转速：根据缝件材料的性质，最高可达每分钟3000转。
2. 针 迹：由一根直机针二根弯针构成三线包缝针迹。
长度：2.5~3.2毫米。
宽度：2.5~3.5毫米。
3. 能缝最大厚度：在自由状态下的缝料为3.5毫米。
4. 机 针 型 号：81×1型7~14号。
5. 电动机功率：不超过0.25瓩。
6. 机头外型尺寸：约250×210×270毫米（连油盘）。
7. 机 头 净 重：约13公斤。

这种机器在出厂前经过周密的检查和试验，保证符合质量规格和具有完善的使用性能。

使用这种机器的技术员工，可能对这种机器的结构和性能已经非常熟悉，但为了更合理地使用和维护这种机器，我们还是建议在使用前能仔细地阅读这本使用说明书。并按照这本说明书的规定进行操作。如果还有其他疑难或问题，可随时和本厂联系。

Foreword

Three Thread Overlock Sewing Machine Model GN1-113, is usually a special purpose machine for knitting mills, used to perform overlocking in sewing various knitted goods such as sweaters, cotton jerseys, sweatshirts and woolen goods, etc.

The main technical specifications of the machine are as follows:

1. Rotating speed of main shaft: According to the nature of the materia being sewn, max. 3000 rpm.
2. Stitch: Overlock stitch forms with a needle and two loopers.
stitch length: 2.5-3.2mm
Stitch width: 2.5-3.5mm
3. Max. thickness of material to be sewn: 3.5mm
4. Type of needle: Type 81×1 No.7-14
5. Power of motor: Less than 0.25 Kw
6. Overall dimension of the head: Approx. 250×210×270 mm (including oil reservoir)
7. Net weight of the head: Approx. 13kg

Before being dispatched by the factory, each machine has been subjected to careful examination so as to ensure that it meets the required specifications and is in perfect working order.

For its proper use and adequate maintenance, it is recommended that the operator should read these instructions carefully and follow the suggested usage and method of operation even though he (she) may be familiar with the construction and performance of such a machine. If you encounter any difficulties or troubles please contact our corporation.

Before using the machine for the first time, the following steps should be.

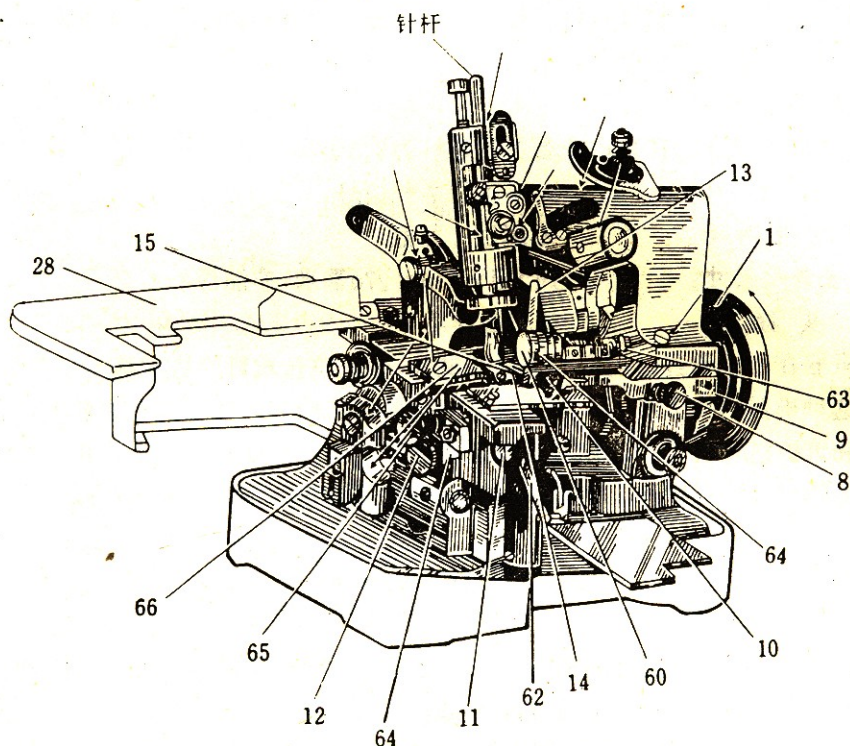


图 1

开箱和第一次使用前的注意事项(指机头开箱)

1. 应按下列顺序开箱。

- 1) 拆除机头纸箱打包紧固带，将纸箱打开，取出全部附件。
- 2) 将机头从装箱泡沫中取出。
- 3) 拆除旋紧油盘的螺丝。

2. 在开箱后到第一次使用前，首先应做好以下几项工作：

1) 清洗油污：机头在装箱前，为了防止机件生锈，各部份都涂有较厚的防锈油脂；同时，机头装箱后，还可能有较长的贮藏和长途运输阶段，造成油脂硬化或积聚灰尘。所以首先必须将表面及油孔中的油脂和灰尘清除干净。

2) 检查：机头在长途运输中，可能因受到强烈的振动而使机件松动或歪曲。所以在清除油污以后应该作一次周密的检查，并用手转动轮盘，看机件之间有无转动困难、碰撞

现象或其它不均匀的阻力、不正常的声音；如有，应作适当的调整，待机器运转情况正常后方可试车。

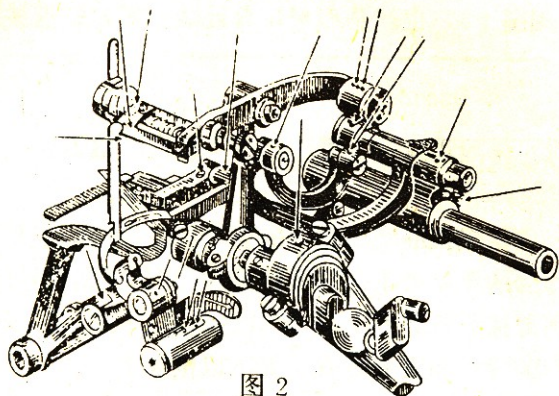


图 2

3) 润滑和试车：应该使用洁净的缝纫机油加入各个应该加油的部份（如图1—3箭头所示），并用手转动轮盘，使油渗入机件的运转部份。然后，用干布将流在零件外面的油揩抹干净，用较低的转速带动机器空车运转。如情况正常，可提高转速到每分钟2500转，继续空车运转几分钟，再检查各部份。直到情况完全正常时，方可正式使用。

taken after unpacking:

a.) Cleaning grease and dirt: Before packing the head, all the machine parts have been coated with grease to prevent rust, it may become hardened in storage or transport, furthermore, dust may gather in the machine, so it is necessary to clean the grease and dirt from the surface and oil holes of the machine.

b.) Inspecting: The machine parts may become loose or damaged after being subjected to strong shock in transport. So after cleaning the grease and dirt, a careful inspection should be made, meanwhile turning balance wheel to make sure that there are no trouble such as sticking, knocking, uneven friction of rotating, etc, if found proper adjustment should make. (machine installation see also fig. of assembly)

c.) Lubrication and trial runs: Add the clean spindle oil to all places where need oiling (as is indicated with arrows in Figs. 1-3).

Turn the balance wheel so as to allow the oil to make its way into the running part. Then wipe out the remaining oil outside and then make idle run at a low speed. If the machine runs smoothly, continue the idle run at a higher speed of 2500rpm for several minutes. After that, recheck all the parts. Once you are satisfied that the machine is running properly, you may begin regular operation.

使用和调整方法

1. 使用转速:

为了延长机器的使用寿命，新机器在开始使用时的转速应不超过每分钟2500转，以使

机器充份跑合。经过一个月左右的使用后,可根据工作的性质再提高到每分钟3000转。机器轮盘应向外旋转(参阅图1),也就是面对轮盘处端面时,轮盘按顺时针方向旋转。

2. 选择机针和缝线:

缝制松薄的材料时,一般用81-1型*7-9*机针;缝制坚厚的材料时,用81-1型11*-14*机针。

选择机针时,首先应该根据缝制工作物的要求,选好缝线,然后根据缝线的粗细选择机针的号数;或根据工作物的质量要求选好机针号数,然后根据机针的号数再选择缝线粗细。缝线应能非常轻滑顺利地通过机针的大、小弯针的针孔,机针、大、小弯针都必须使用软线。

各种缝料一般选用的缝线和机针规格表如下以供参考:

缝 料 名 称	缝 线 规 格	机 针 规 格
100~120支汗衫布	80~120支四股棉线	*7—*9
80支汗衫布	80支四股棉线	*9
60支汗衫布	60支三股棉线	*11
42支汗衫布	60支三股棉线	*11
棉 毛 衫	60支三股棉线	*11
卫 生 衫	60支三股棉线	*14

Use and Adjustment

1. Operation speed:

To ensure longer service life, at first the machine should be run at a speed of not more than 2500rpm so as to break it in sufficiently. After use for a month, the speed may be increased to approx. 3000rpm according to the material being sewn. The machine balance wheel should be turned toward the outside i.e. when facing the wheel, it should be turned the clockwise (see Fig. 1).

2. Selecting the needle and thread:

The needles of type 81-1 No. 7-9 are usually used for sewing soft and thin materials, while needles of No. 11-14 are for sewing tough and thick materials. The needle and thread are to be selected in two ways: selecting a needle suitable thread required by the workpiece or selecting thread suitable for the needle required by the workpiece. The threads should be able to pass very easily through the holes of needle and the two loopers. Soft thread should also be used.

The following table is suggested for your guidance, showing the suitable threads and needle usually used with different materials.

Material	Thread	Needle
Thin silk and satin	80—120 count cotton thread	No. 7—9
Thin chemical fibre cotton cloth	60—80 count cotton thread	No. 9
Medium-long fibre and cotton cloth	42—60 count cotton thread	No. 11—12
Khaki drills and denim	42—60 count cotton thread	No. 11—12
Chemical fibre and thin pure woolen fancy suiting	42—60 count cotton thread	No. 11—12
Chemical fibre and pure woolen cloth for overcoat, canvass, etc.	42—60 count cotton thread	No. 14
120 count knitting for undershirt	80—120 count 4 strand cotton thread	No. 7—9
80 count knitting for undershirt	80 count 4 strand cotton thread	No. 9
60 count knitting for undershirt	60 count 3 strand cotton thread	No. 11
42 count knitting for undershirt	60 " "	No. 11
Cotton jersey	60 " "	No. 11
Sweater	60 " "	No. 14

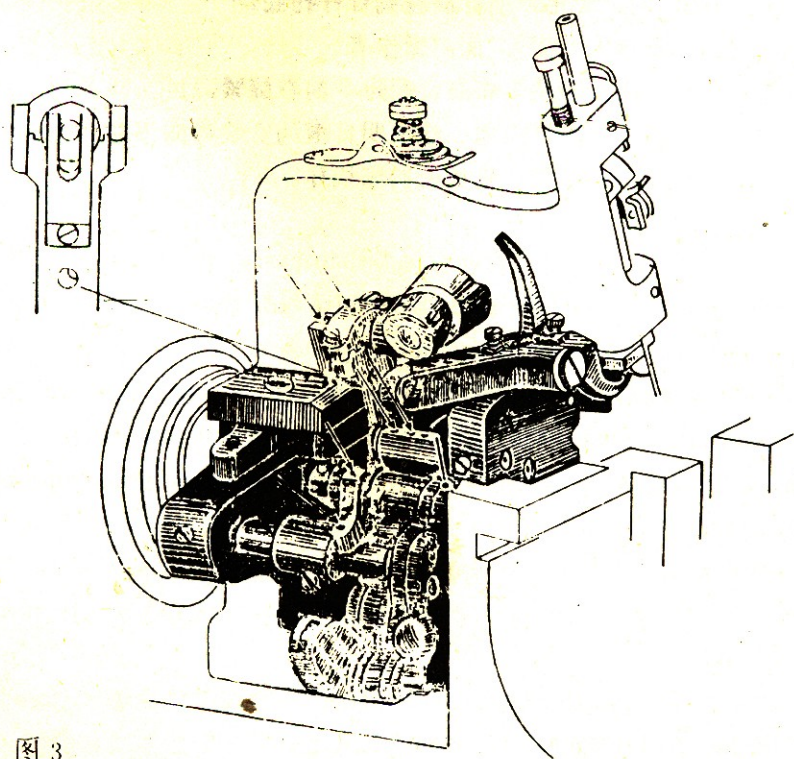


图 3

3. 按装机针

机针和缝线选定后, 必须检查一下, 机器上原装机针是否和所选定的号数相同。如果不同, 应该调换。

调换机针时, 可用右手向外旋转轮盘 1 (参阅图 1 及图 4), 使针杆上升到最高位置、然后用本厂随机供应的搬头 2 (图 4), 将夹针螺母 3 向左旋松, 取下机针 4 换装所需要的机针。

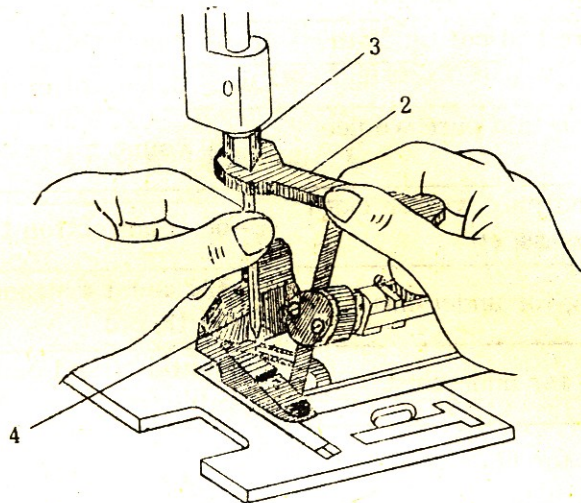


图 4

安装机头时应注意:

- 1) 机针的针柄必须向上装足, 使针柄碰到针杆孔底。
- 2) 机针的长槽(无缺口的一面)应面向操作者。

新机针装入针杆后, 仍用搬头 2 将夹针螺母 3 向右旋紧。

新机针装上市后, 可能产生跳针现象。这说明针槽的安装方向不对。需要将机针稍为向左或右旋转, 使小弯针能正确地穿进机针所构成线环。

3. Setting the needle:

After determining the needle and thread sizes for the material being sewn, check to see if the needle on the machine is the proper size.

Turn balance wheel(1) clockwise first as shown in Fig.1 until the needle bar is in its highest position. Loosen the needle clamp screw(3) by turning it clockwise with the spanner(2) (Fig.4) supplied with the machine, and exchange the needle(4) for a suitable one.

Take care to make sure that

- 1) The stem of the needle is inserted fully as far as it will go into the end of the needle bushing.
- 2) The long groove of the needle (i.e. the side without notch) faces the operator. The needle has to be adjusted properly.

After setting a new needle, tighten the needle clamp screw(3) with the spanner(2) by turning it counter-clockwise.

Skipping of a new needle may occur because the needle clamp groove has been placed in the wrong direction. Turn the needle clockwise slightly until the small loop gets into the loop formed with the needle thread.

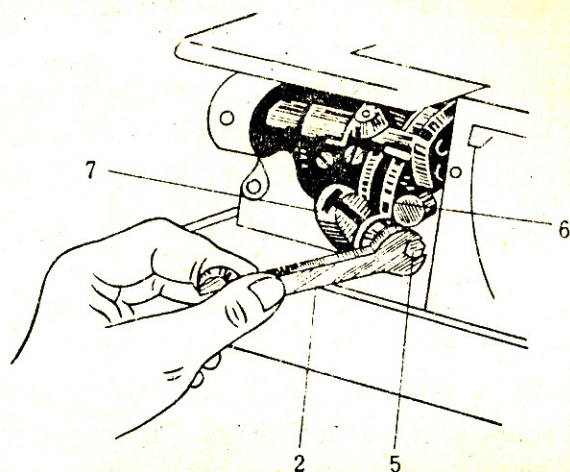


图 5

4. 调节针迹长度:

针迹的长度可根据工作物的需要在本厂规定的范围内调节。调节时首先旋转轮盘使针杆上升到最高位置，然后用本厂随机供应的搬头 2 向下旋松针距螺丝 5 (参阅图 5)，再将针距螺丝 5 连同抬牙架连杆 6 一起，在大开针架 7 的槽子里移动。这样就可以放长或缩短针迹。要放长针迹时，可将针距螺丝 5 向外移动；要缩短针迹时，可将针距螺丝 5 向里移动。调节完毕后仍将针距螺丝 5 旋紧。

4. Regulating Stitch Length

The stitch length can be regulated according to the requirements of the work-piece, within the range specified by the manufacturer. Turn the balance wheel first until the needle bar is in its highest position, then loosen the stitch regulating screw stud(5) by turning it counterclockwise with the spanner(2) supplied with the machine (see Fig.5). Then move it together with the feed lifting link(6) along the slot of the feed regulator so as to obtain a longer or shorter stitch. To obtain longer stitch, move the stitch regulating screw stud(5) outward; to obtain a shorter stitch, move it inward. Then retighten the stitch regulating screw stud(5).

5. 调节针迹宽度:

针迹的宽度同样可以根据工作物的需要在本厂规定的范围内调节。要调节针迹宽度，必须同时调节切边刀地位和编结导块的地位。调节时，首先旋松拦刀架螺丝 8 (参阅图 1)，

将拦架9连同拦刀板10一起向右移动；然后用起子旋松下刀架螺丝11，再用手旋转下刀架调节螺丝12，使下刀架向左或向右移动，以达到所需要调整的位置，并将下刀架螺丝11旋紧；最后将拦刀架9向左移动，使拦刀板10的左端轻轻地顶着上刀片13，并将拦刀架螺丝8旋紧。

要放大针迹宽度时，应使下刀架向右移动；要缩小时则应向左移动。

切刀边的地位调节完毕后，应进一步调节编结导块。编结导块的位置应根据切边刀的地位来确定。

调节时，首先将压脚上的编结导块螺丝14旋松，然后根据切边刀的位置将编结块15在压脚的槽子向右或向左移动。位置确定后仍将编结导块螺丝14旋紧。

如果工作物切齐后，边缘上包缝针迹清晰整齐，说明编结导块位置已经正确。

5. Regulating Stitch Width

The stitch width can also be regulated according to the requirements of the workpiece, within the range specified by the manufacturer. To regulate the stitch width, the positions both for knife and loop finger have to be regulated at the same time. First loosen the screw(8) of the knife guard bracket (shown in Fig.1) and move the knife guard bracket(9) together with the knife guard(10) to the right. Then loosen the screw(11) of the lower knife holder with a screwdriver and turn its adjusting screw(12) with the hand so as to move the lower knife holder toward the left or right side to reach the required position. Then tighten the screw(11) of the lower knife holder. Finally, move the knife guard bracket(9) to the left until the left end of the knife guard(10) touches the upper blade(13) gently. Then tighten the screw(8) of the knife holder.

To obtain a wider stitch width, move the lower knife holder to the right; to obtain a narrower stitch width, move it to the left.

The position of the knife having been regulated, go on to regulate the loop finger on presser foot. Its position is to be determined in accordance with that of the knife.

Loosen the screw(14) of the loop finger on the presser foot first, then move the loop finger along the slot of the presser foot toward the right or left sides, in accordance with the position of the knife. After determining its position, retighten the screw(14) of the loop finger.

The position of the loop finger is regulated correctly if the tidy and neat overlocking stitches are interwoven on the trimmed edge of the workpiece.

6. 机针穿线方法(参阅图6)

将线轴装在线轴座上，然后按下列步骤穿线：

从线轴上引出线头，向上通过过线钩16：

向下穿过上过线板17的孔18：

再向上穿过上过线板17的孔19；
 在两块夹线板20的中间通过；
 向下穿过上过线板17的孔21；
 从前面穿过针杆过线板22的孔23；
 在针杆过线架24上导线柱25的右侧通过。
 在两块小夹线板26的中间通过；
 在导线柱27的后面通过；
 将线头从前面穿过机针4的针孔；
 从后面拉出线头约20毫米长。

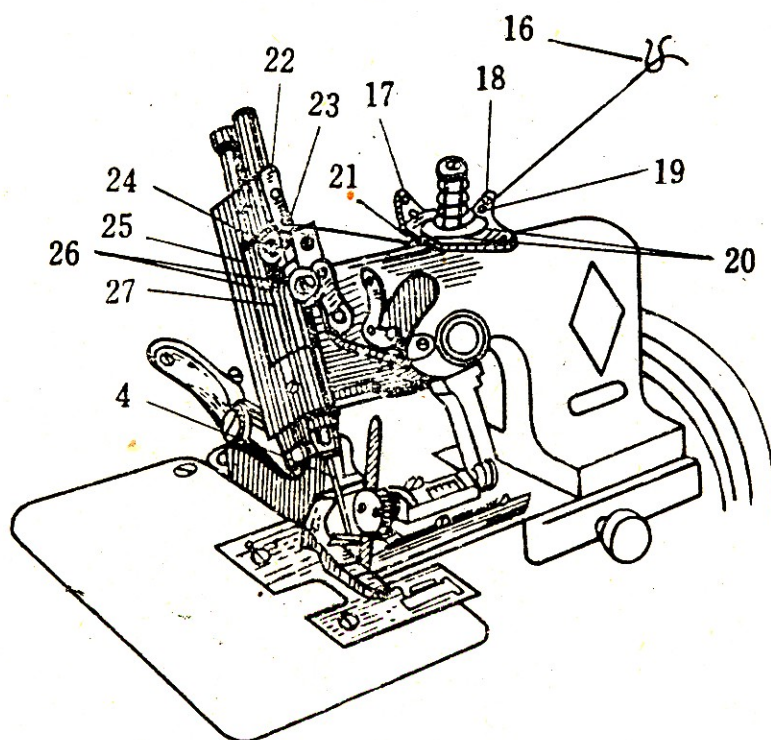


图 6

6. Threading the Needle (see Fig. 6)

Place the bobbin on the spool pin and then thread in the following manner:

Draw out the end of the thread from the bobbin and pass it across the thread hook(16), down through the hole(18) of the upper thread guide (17) and up again through the hole (19) of the upper thread guide (17).

Allow it to pass between the two tension discs (20), down through the hole (21) of the upper thread guide (17), and from the front, in to the hole (23) of the thread guide (22) of the needle bar.

Allow it to pass beside the right of the guide post (25) on the thread take-up guide (24) of the needle bar.

Allow it to pass between the small tension discs(26), by the back of the guide post (27), and from the front, into the hole of the needle (4). Draw out the end of the thread from the back for a length of about 20mm.

7. 小弯针穿线方法: (参阅图 7 ~ 8)

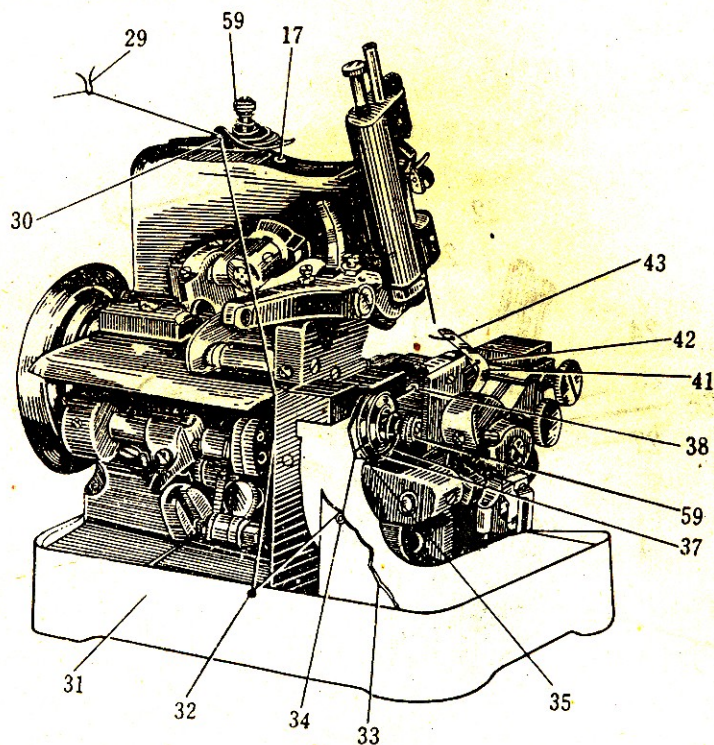


图 7

旋转轮盘使针杆上升到最高位置, 将缝台28(参阅图 1)向左拉开, 把线轴装在线轴座上, 然后按下列步骤穿线:

从线轴上引出线头, 向上通过过线钩29(参阅图 7);

向下穿过上过线板17的孔30;

向下从外面穿过油盘31的孔32;

向上从外面穿过下罩壳33的孔34;

穿过下过线板35的孔36(参阅图 7 ~ 8);

在两块夹线板37的中间通过;

通过过线管38;

用随机供应的穿线钳夹住线头、套进小弯针线钩39(参阅图 8)的穿线孔40中, 仍将线头夹住。

向外旋转轮盘, 使针杆下降到最低地位;

将穿线钳夹住的线头, 从后面向前面穿进小弯针41的穿线孔42中;

从前面向后面穿进小弯针41的穿线孔43中;

将线头拉出约125毫米长。

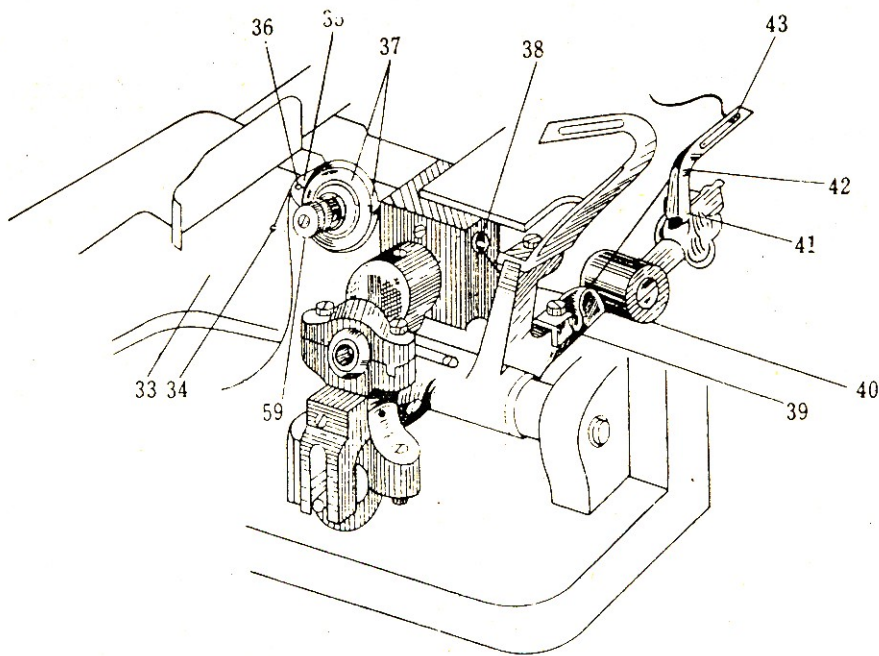


图 8

7. Threading for the Small Looper (see Figs.7-8)

Turn the balance wheel until the needle bar is raised to its highest position. Slide the cloth plate(28) (see Fig.1) to the left, and place the bobbin on the spool pin. Then thread in the following manner:

Draw the thread out from the bobbin and pass it (see Fig.7) across the thread hook(29).

Down through the hole(30) of the upper thread guide(17).

Down from the outside through the hole(32) on the oil reservoir(31).

Up from the outside through the hole(34) on the lower cover(33) through the hole(36) of the lower thread guide(35) (see Figs.7-8).

Allow it to pass between the two tension discs(37) through the thread guide tube(38).

Grip the end of the thread with the tweezers supplied with the machine and pass it into the thread hole(40) of the thread hook(39) for the small looper (see Fig.8).

Continue to grip the end of the thread and turn the balance wheel clockwise until the needle bar lowers to its lowest point. Pass the thread from back to front into thread hole (42) of the small looper (41).

Pass the thread from front to back into the thread hole (43) of the small looper (41).

Draw out the end of the thread to a length of about 125mm.

8. 大弯针穿线方法：（参阅图9）

将右照板44向下打开，向外旋转轮盘，使针杆上升到最高位置，把线轴装在线轴座上然后按下列步骤穿线：

从线轴上引出线头，向上通过过线钩42；

向下穿过上过线板17的孔45；

再向下穿过拦刀架9上的穿线孔46；

向下绕过夹线螺丝47的右侧和下面，在二块夹线板48中间通过；

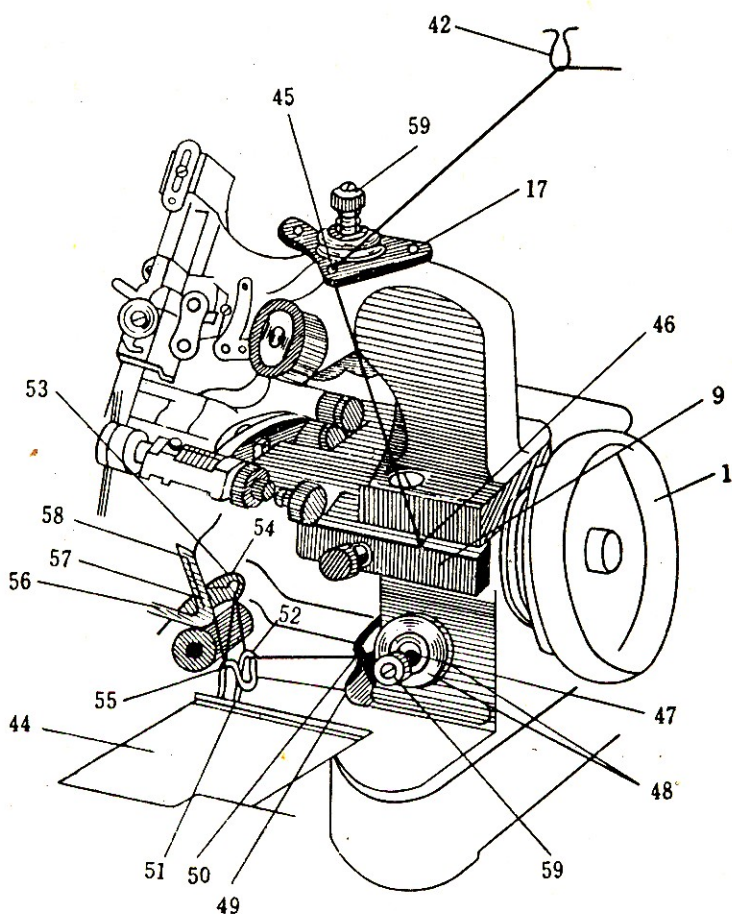


图 9

从前面穿过下过线板49的孔50；

向左穿进大弯针过线51里面的钩子52中；

向上套进大弯针线钩53的孔54中；

向下穿进大弯针过线51外面的钩子55中；

向外旋转轮盘使针杆下降到最低位置；

用穿线钳从后面穿进大弯针56的孔57中；

再用穿线钳将线头从前面穿进大弯针56尖端的孔58中；

将线头拉出约125毫米长。

8. Threading for the Big Looper (see Fig.9)

Pull down the right side cover(44). Turn the balance wheel clockwise until the needle bar rises to its highest position, and place the bobbin on the spool pin. Then thread in the following manner:

Draw out the end of the thread from the bobbin and pass it up across the thread hook(42).

Down through the hole (45) of the upper thread guide(17).

Down again through the thread hole(46) on the knife guide bracket(9).

Down to the right and below the tension post(47), allowing it to pass between the two tension discs(48).

Pass the thread from the front through the hole(50) of the lower thread guide(49).

To the left into the hook (52) inside the thread guide(51) of the big looper.

Up into the hole(54) of the thread hook(53) of the big looper.

Down into the hook(55) outside the thread guide(51) of the big looper.

Turn the balance wheel clockwise until the needle bar lowers to its lowest point.

Grip the end of the thread with the tweezers and pass it from the back into the hole (57) of the big looper(56).

Grip it again with the tweezers and pass it from the front into the hole (58) on the tip of the big looper(56), then draw it out to a length of about 125mm.

9. 缝纫的开始和结束

缝纫开始时，须先用压脚搬手或踏脚将压脚抬起，将工作物放在压脚下面，使工作物和压脚的右侧相齐；然后放下压脚；再开始缝纫。这样，切边刀才能正确地切除参差不齐的工作物边缘。

在缝纫时，不应该用力推拉工作物；只需轻轻地扶持，使工作物根据所需要的方向前进。

每个针缝结束时，必须空缝一段，使针缝末端，编结成辫子，以巩固针缝；再用剪刀或机器上的切边刀剪断辫子，取下工作物。切勿用手来拉断辫子。以防拉弯机针。

在缝纫时切勿用起子或其他工具强加压力于压脚，以免损坏送布牙和工作物。

9. Starting and Finishing Sewing

When starting sewing, first lift up the presser foot with the presser foot lifter or pedal, allowing the workpiece to be placed under the presser foot so as to keep the workpiece parallel with the right side of the presser foot. Then put down the presser foot to begin sewing. Only in this way the knife can trim the untidy edge of the workpiece accurately.

In sewing, no pressure should be exerted to push or pull the workpiece which needs only a gentle guiding in order to go forward in the required direction.

After each stitching is over, continue to sew without a workpiece until the thread chain has formed will help to fasten the stitch. Then cut off the chain with a pair of scissors or the knife and remove the workpiece. Be sure not to break the chain by pulling or the needle will be bent.

To prevent damaging the feed dog or workpiece, when sewing, no pressure should be applied on the presser foot with a screwdriver or other tool.

10. 调节缝线松紧的方法:

缝纫工作正式开始前, 应该根据工作物的性质进行试缝, 以调节缝线的松紧。

三线包缝机所缝制的交叉线结, 一般应该交织在工作物边缘的中间(如图10所示)。

如果线结交织在工作物边缘的上部, 说明大弯针上的缝线(即工作物上面的缝线)太紧或小弯针的上缝线(即工作物反面的缝线)太松。

如果线结交织在工作物边缘的下部, 说明大弯针上的缝线太松或小弯针上的缝线太紧。

调节机针及大、小弯针上的缝线松、紧时, 可使用夹线螺母(参阅图7~9)。

大、小弯针上的缝线松紧程度经过调节后, 如果还不能获得满意的针迹, 就必须进一步调节机针缝线的松紧。一般机针上的缝线, 必须要有足够的紧密程度, 才能使大、小弯针上的缝线平服地交织在工作物的边缘中间。

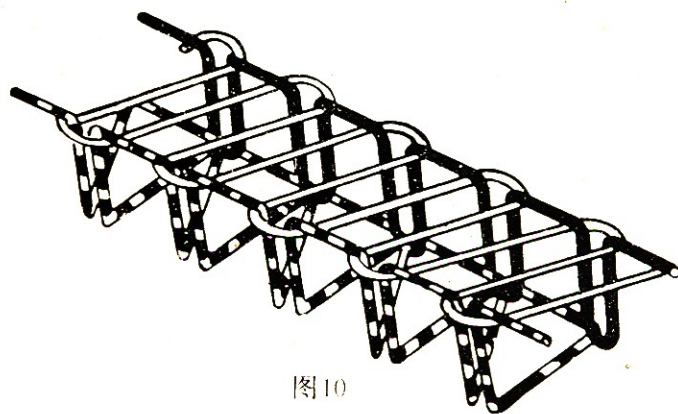


图10

10. Adjusting the Thread to a Suitable Tightness

Before commencing regular sewing, it is necessary to make a trial run in order to adjust the threads to a tightness suitable to the nature of the workpiece, since this will greatly affect the sewing stitch.

A correct cross knot woven by the Three-Thread Overlock industrial sewing machine should be interweaved on the middle edge of the workpiece (see Fig. 10).

A stitch woven on the upper edge may be attributed to the thread tension of big looper (i.e. the thread on the surface of workpiece) being too tight or the thread tension of small looper (i.e. the thread on the back of workpiece) being too loose.

A stitch woven on the lower edge may be attributed to the thread tension of big looper being too loose or the thread tension of small looper being too tight.

The tension nut(59) (see Figs.7-9) can be used to adjust the tension of thread of the needle as well as the big and small loopers.

If no satisfactory stitches can be obtained after adjusting the thread tension on the big and small loopers, it is necessary to adjust the thread tension on the needle. The threads of the big and small loopers will not be interwoven neatly on the middle edge of the workpiece unless the thread of the needle is sufficiently tight.

维 护 和 检 修

1. 经常性维护和检修:

在经常使用时,可按照本说明书的规定,在应该加油的地方,每小时加油一次。所用润滑油必须是洁净的缝纫机油,切勿使用其他润滑油,绝对不能使用任何植物油,以免影响机器的使用寿命。

机器的各部份,必须经常保持清洁。在使用过程中,应定期检查运转部份的温度是否正常。发现有不正常的现象和声音时,应该马上仔细检查纠正。小问题不解决,将产生大问题。正确的使用,经常的维护和检修,是延长机器使用寿命的主要关键。

在一般情况下,每个月应进行一次小检修,每半年进行一次清洗和大检修。长期搁置后第一次使用,应作大检修处理。

使用速度应该根据工作物的性质来确定,不可超速、超负荷使用。

2. 调换切边刀片(参阅图1):

切边刀片经过一定时期的使用,就会失去锋利,需要研磨或更换,在拆除刀片前,应将拦刀架螺丝8旋松(图1),再将拦刀架9向右移动。拆装切边刀的方法如下:

首先拆除上刀片。可用左手向右轻轻推压上刀盖60的左端面,使上刀片13销离下刀片62。然后用右手旋松挺刀螺丝63,再用右手将上刀片13,从上刀座64中抽出,最后将左手松开。

然后拆除下刀片。只要用左手旋松下刀座螺母65,即可将下刀片62抽出。

上、下刀片拆除后,就可将这两种刀片在细砂轮上研磨。研磨时必须保持原有的刀刃度,同时要防止在研磨时发热退火。必要时需换装新刀片。

刀片研磨完毕或更换新刀片重新安装时,必须先安装下刀片。安装时,用右手把下刀片62插进下刀座的槽子中,使刀刃和针板66的上平面一样平;切勿超过针板的上平面。然后用左手旋紧下刀座螺母65。

安装上刀片时,先向外转动轮盘,使针杆下降到最低位置。然后再用左手轻轻推压上刀盖60的左端面,用右手将上刀片13插入上刀座64的槽子中,使上刀片13和下刀片62重叠0.5毫米。用右手将挺刀螺丝63旋紧。最后,将拦刀架9向左移动,使拦刀板10(图1)的左端轻轻地顶着上刀片13,并将拦刀架螺丝8旋紧。

3. 可能遇到的故障和解决方法:

现将使用过程中可能遇到的故障、故障的原因及其处理方法如下:

可能遇到的故障	可能产生的原因	建议处理方法
1. 针缝的针迹不匀或不正确。	1. 各种夹线板之间积聚灰尘或纤维, 因而失去了夹紧缝线的作用。	1. 拆开夹线板, 将灰尘和纤维清除干净。
2. 跳针。	2. ①针杆高低位置不正确, 机针的高低和方向不正确。 ②机针的针尖或柄部已经弯曲, 针尖磨钝, 没有正确选用机针的型号或针号不对。 ③刀片用钝。	2. ①重新调整针杆高低, 参阅本说明书选择和按装机针的方法。 ②更换新的型号和针号正确的机针。 ③研磨上、下刀片。
3. 机针断线。	3. ①针号和线号不相适应。 ②针孔毛糙或机针质量太差。 ③缝线质量不好。 ④穿线错误或面线太紧。 ⑤刀片用钝。	3. ①换用适当线号。 ②换用新机针。 ③换用质量较好的缝线。 ④参阅本说明书。 ⑤研磨上、下刀片。
4. 缝制人造纤维工作物时缝线被拉进工作物。	4. 针太粗或已损坏。	4. 换用新机针。
1. 缝制较狭针迹时损坏编结导块。	5. 机针已弯曲, 因而和编结导块碰撞。	5. 换用新机针
6. 针缝边缘毛糙或切边不够整齐。	6. 切边刀片已经用钝, 或编结导块没有正确调整, 因而和切边刀的位置不相适应。	6. 研磨或更换上、下刀片, 重新调整编结导块的位置。

Maintenance and Repair

1. Routine Maintenance And Repair

If the machine is in contant use, the oil positions will have to be lubricated once every 4 hours as described below. Clean spindle oil to be used. Never use any other lubricative oil, especially vegetable oil of any kind or the service life of the machine may be affected.

All parts of the machine should constantly be kept clean. A periodical inspec-

tion of its temperature is also necessary. If any disorder or abnormal noise occurs, a careful check and correction should be made at once so as to avoid allowing minor problems to become major ones. The key to a longer life for the machine lies in proper operation and routine maintenance and repair.

Under normal conditions, minor maintenance should be conducted every half a month, while cleaning and major maintenance should be conducted once every six months. Before using for the first time after a long period of idle, a major maintenance and inspection will have to be made.

The rotating speeds are used to be determined in according to the nature of the workpiece. No overspeed or overload should be permitted or the service life of the machine may be affected.

2. Changing the Blade (see Fig.1)

The blade will become dull after being used for a certain period and should be reground or changed. Before dismantling the blade, loosen the screw(8) of the knife guard bracket (Fig.1) and move the knife guard bracket(9) to the right. The blade is to be dismantled and mounted in following way:

Dismantle the upper blade first. Push lightly on the left end of the cover (60) of the upper knife with the left hand until the upper blade (13) moves slightly from the lower blade(62). Then loosen the knife screw (63) with the right hand. After that, take away the left hand from the cover of the upper knife.

Then dismantle the lower blade. The lower blade (62) can be extracted merely by loosening the nut (65) on the lower knife seat with the left hand.

Then regrind the dismantled upper and lower blades on a fine grinding wheel. Care must be taken to retain the original angle of the blade edge and to prevent over heating and annealing during grinding.

When mounting the reground or new blade, the lower blade has to be mounted before the upper one. Insert the lower blade(62) into the slot of the lower knife seat with the right hand until the blade edge is level with but does not exceed the upper surface of the throat plate (66). Then tighten the nut (65) on the lower knife seat with the left hand.

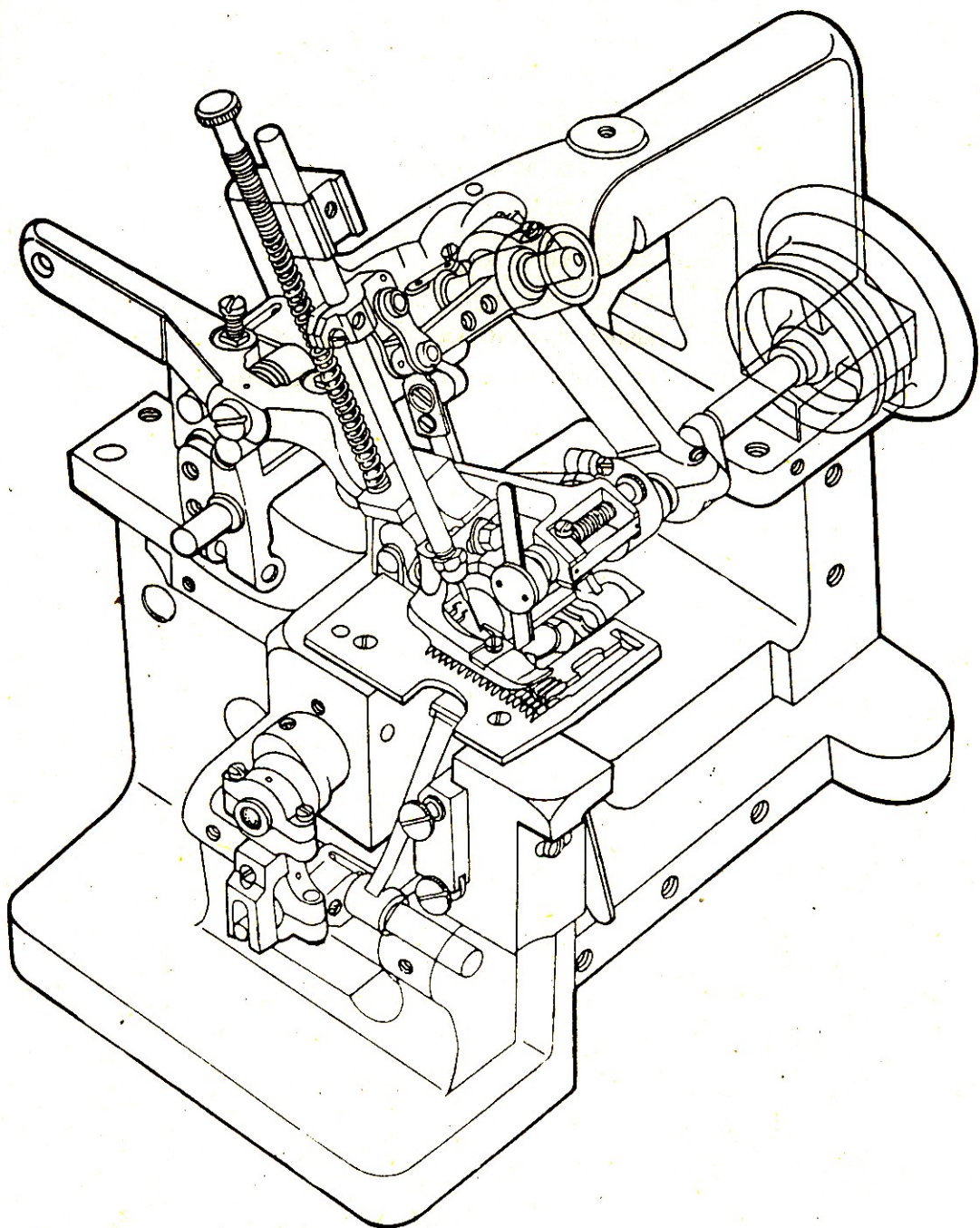
The upper blade is to be mounted in the following way. Turn the balance wheel clockwise until the needle bar lowers to its lowest position. Then push lightly on the left end of the cover (60) of the upper knife with the left hand and insert the upper blade (13) into the slot of the upper knife seat (6) so as to make the upper blade (13) overlap by 0.5 mm with the lower blade (62). Tighten the knife screw (63) with the right hand. Finally, move the knife guard bracket (9) toward the left so as to make the left end of knife guard (10) (see Fig. 1) touch gently against the upper blade (13), and then tighten the screw (8) of the knife guard bracket.

3. Common Problems and their Solutions

Common problems, their possible causes, and recommended solutions are listed in the following table:

Common problems	Possible cause	Recommended solution
1. The stitches are uneven or incorrect	1. Dust or fibre has gathered between the tension discs, making it impossible to clamp the thread	1. Dismantle the tension discs and get rid of dust and fibre
2. Skip stitch	2. (1) The needle bar is at improper height and the needle is at an improper height and direction (2) The tip or stem of the needle is bent, or tip is dull. The type and No. has been incorrectly selected. (3) Blade is dull.	2. (1) Readjust the needle bar to its proper height. Refer to the method of selecting and setting needle height in this manual. (2) Exchange the needle for a new suitable type and No. (3) Grind upper and lower blades.
3. The needle thread breaks	3. (1) The needle No. is not suitable for thread No. (2) Needle hole is coarse or the quality of the needle is poor. (3) The quality of the thread is poor. (4) The threading process has not been correctly followed, or the needle thread is too tight. (5) Blade is dull	3. (1) Exchange for suitable thread No. (2) Exchange for a new needle. (3) Exchange for a thread of better quality. (4) Refer to the relevant description of this instruction (5) Grind upper and lower blades.

Common problems	Possible cause	Recommended solution
4. The thread is hitched into the work-piece of manmade fibre being sewn	4. The needle is too coarse or is damaged.	4. Exchange for a new one.
5. Loop finger is damaged when sewing a narrower stitch.	5. Needle is bent so as to touch with the loop finger	5. Exchange for a new needle.
6. The edge of stitching is coarse or the cut edge is untidy.	6. Blade is dull, or loop finger is improperly adjusted therefore is unsuitable to the position of the knife.	6. Grind or exchange upper and lower blades, and readjust the position of the loop finger.



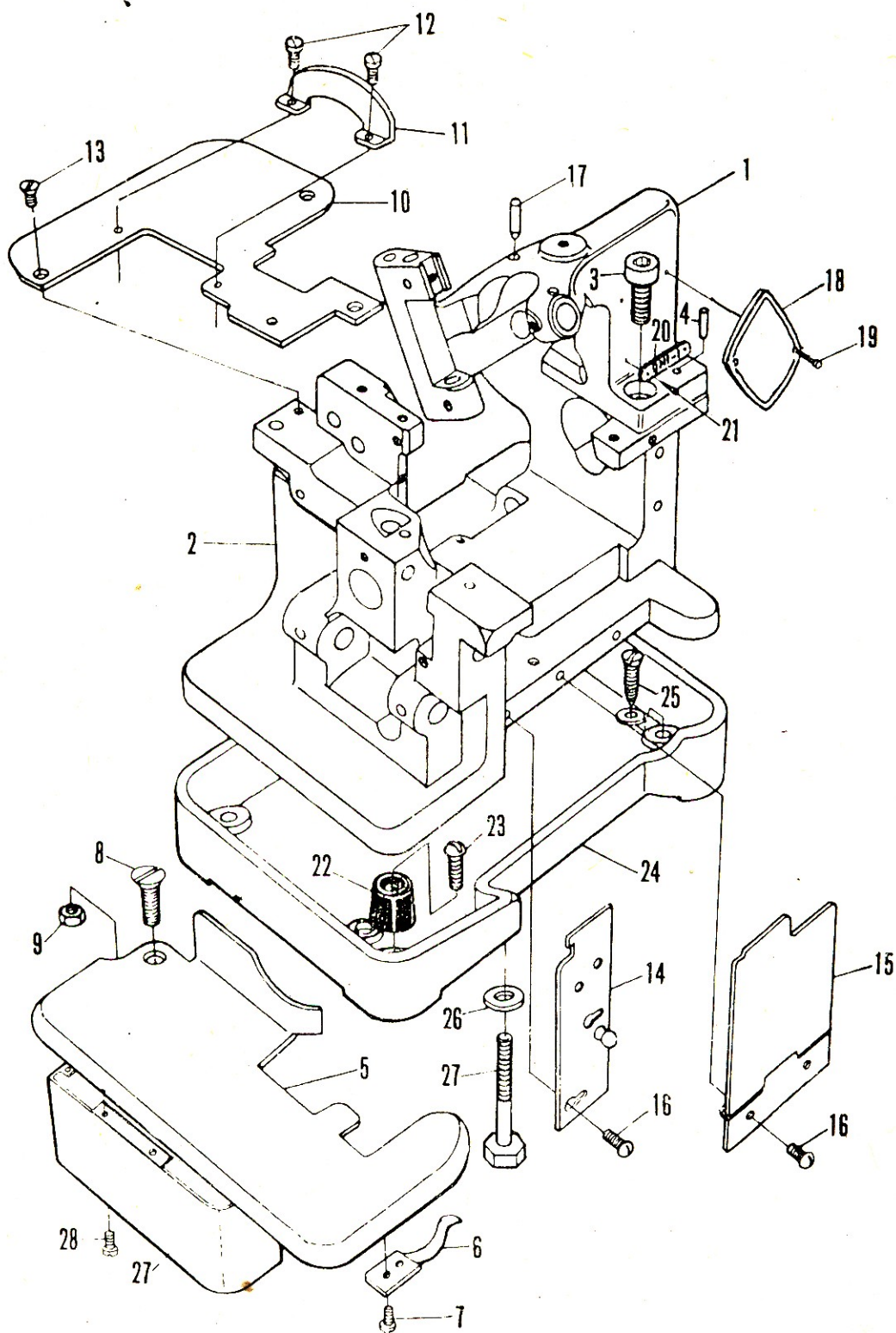
一、机壳部件

货号

I. FRAME COMPONENTS

序号	图 号	名 称	件数	备 注	No. for Singer Model	Description
1	6A1-01	车壳	1			Machine Arm
2	6A1-02	机座	1			Machine Bed
3	6A1-04	机壳螺钉	2	M8×16GB70-76		Arm Screw
4	6A1-03	机壳销	2	φ5×20GB117-66		Arm Pin
5	6A1-a 01	缝台	1		42145	Cloth Plate
6	6A1-a 05	缝台簧	1		42005	Cloth Plate Lock Spring
7	6A1-a 06	缝台簧螺钉	2		236	Cloth Plate Lock Spring Screw
8	6A1-05	缝台螺钉	1		1437	Cloth Plate Hinge Screw
9	6A1-06	缝台螺母	1		1655	Cloth Plate Nut
10	6A1-07	上壳罩	1		42029	Top Cover
11	6A3-29	开针牌	1		42018	Feed Regulator Indicator Plate
12	6A6-21	开针牌螺钉	2	同下弯针线勾螺钉	1253	Feed Regulator Indicator Plate Screw
13	6A6-02	上罩壳螺钉	3	同针板螺钉	742	Top Cover Screw
14	6A1-b	左罩板组件	1		42027	Left Cover Assembly
15	6A1-c	右罩板组件	1		42028	Right Cover Assembly
16	6A1-08	左右罩板螺钉	4		830	Left / Right Cover Screw
17	6A1-d	摆轴油管组件	1			Oscillating Shaft Oil Tube Assembly
18	6A1-16	商标牌	1			Trade Mark Plate
19	J0.080	商标牌钉	2	同JA1-1 商标钉		Trade Mark Plate Pin
20	6A1-18	机型牌	1			Machine Model Plate
21	6A1-17	机型牌钉	2	φ2×6GB 827-76		Machine Model Plate Pin

22	6A1-09	机头垫块	4		Machine Head Cushion
23	6A1-10	机头垫块螺钉	4		Machine Head Cushion Screw
24	6A1-11	油盘	1		Oil Reservoir
25	6A1-20	油盘紧固螺钉	3	螺钉 5 × 25GB100-66	Oil Reservoir Set Screw
26	6A1-12	机头紧固螺钉垫圈	1	φ8GB96 × 76	Machine Set Screw Washer
27	6A1-13	机头紧固螺钉	1	M8 × 65GB30-76	Machine Set Screw
28	6A1-a 02	下罩壳	1		Lower Cover
29	6A1-a 04	下罩壳螺钉	3		Lower Cover Screw

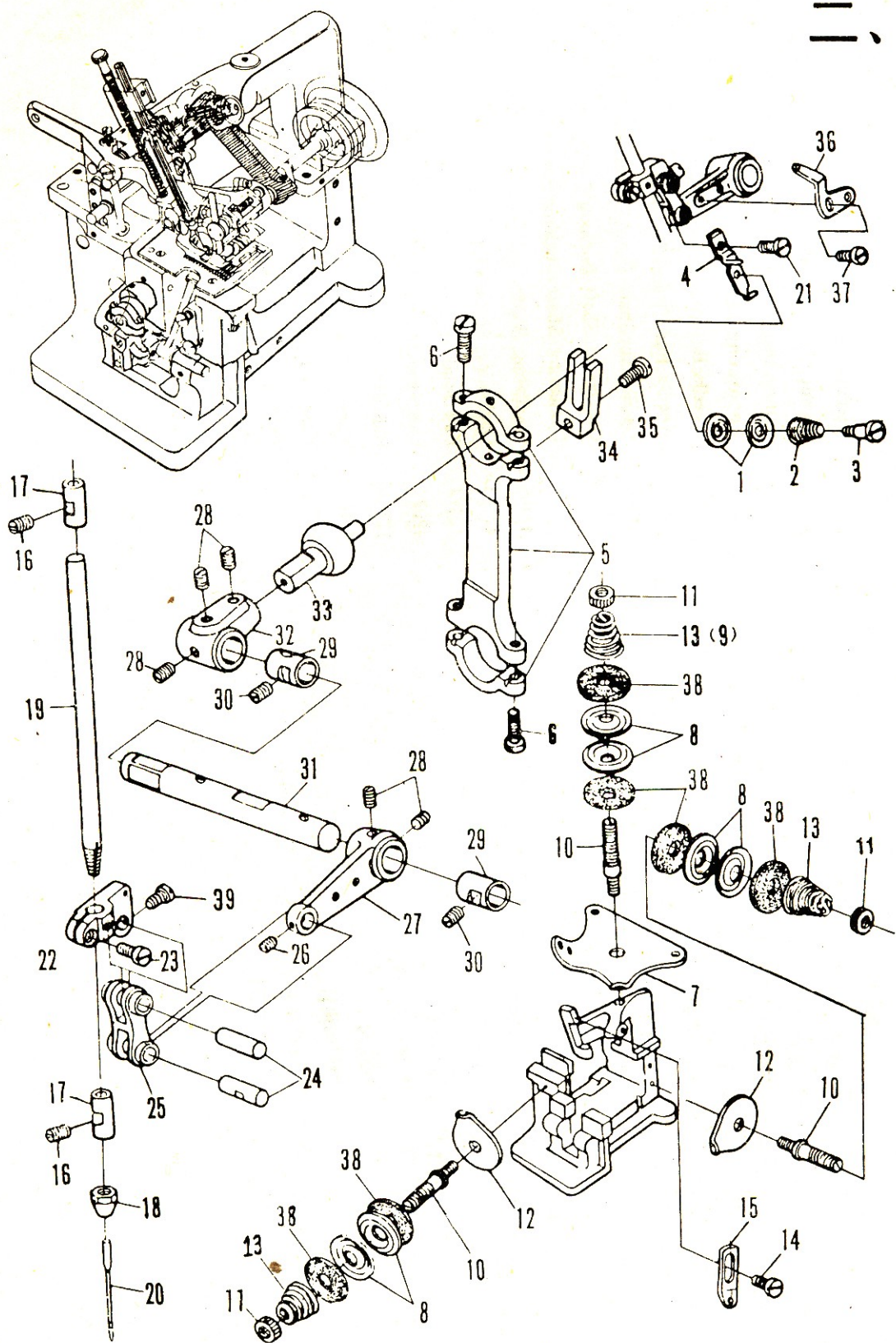


II. NEEDLE BAR AND THREAD GUIDE COMPONENTS

二、针杆过线部件

序号	图 号	名 称	件数	备 注	No. for Singer Model	Description
1	6A2-a 01	小夹线板	2		10106	Thread Retainer Thread Tension Disc
2	6A2-a 02	小夹线簧	1		10107	Thread Retainer Thread Tension Disc Spring
3	6A2-a 03	小夹线螺钉	1		93	Thread Retainer Screw
4	6A2-a 04	针杆过线架	1		42115	Thread Retainer Bracket
5	6A2-b	针杆连杆组件	1		42057	Needle Bar Connecting Rod Assembly
6	6A2-b 03	针杆连杆螺钉	4		1057	Needle Bar Connecting Rod Cap Screw
7	6A2-01	上过线板	1		42082	Upper Thread Guide
8	6A2-02	夹线板	6	同GN6/1-35	2102	Thread Tension Disc
9	6A2-03	夹线板簧	1		10148	Thread Tension Disc Spring
10	6A2-04	夹线螺钉	3		916	Thread Tension Screw Post.
11	J2.2.7	夹线螺母	3	同JAL-1 夹线螺母	1560	Thread Tension Regulation Nut
12	6A2-06	下过线板	2		17547	Lower Thread Guide
13	6A2-03	夹线簧	2			Lower Thread Tension Disc Spring
14	6A2-07	针杆过线板螺钉	1		217	Needle Bar Thread Guide Screw
15	6A2-08	针杆过线板	1		42096	Needle Bar Thread Guide
16	6A2-09	针杆套筒支头螺钉	2	SM4.5×40×5.5		Needle Bar Bushing Set Screw
17	6A2-10	针杆套筒	2		42253	Needle Bar Bushing
18	6A2-11	夹针螺母	1		1629	Needle Clamping Nut
19	6A2-12	针杆	1		42054	Needle Bar
20	6A2-13	机针	1		81×1	Needle
21	6A2-14	针杆过线架螺钉	1		228	Thread Retainer Bracket Screw

22	6A2-15	针杆接头	1	42061	Needle Bar Connector
23	6A2-16	针杆接头螺钉	1	175	Needle Bar Connector Screw
24	6A2-17	链条节销	2	40247	Connecting Link Pin
25	6A2-18	链条节	1	42055	Connecting Link
26	6A2-19	链条节销支头螺钉	1	904	Connecting Link Pin Set Screw
27	6A2-20	针杆曲柄	1	42104	Needle Bar Crank
28	6A2-21	针杆曲柄支头螺钉	2	1258	Needle Bar Crank Set Screw
29	6A2-22	摆轴曲柄螺钉	3	1258	Oscillating Shaft Crank Screw
30	6A2-09	摆轴套筒	2	132589	Oscillating Shaft Bushing
31	6A2-23	摆轴	2		Oscillating Shaft Bushing Screw
32	6A2-24	摆轴曲柄	1	42105	Oscillating Shaft
33	6A2-25	钢弹子	1	42103	Oscillating Shaft Crank
34	6A2-26	止摆夹头	1	42074	Ball Stud
35	6A2-27	止摆夹头螺钉	1	42077	Ball Stud Guide
36	6A2-28	撘线勾	1	171	Ball Stud Guide Screw
37	6A6-19	撘线勾螺钉	1	42162	Thread Take-up
38	6A2-29	压线板垫	2	197	Thread Take-up Screw
39	6A2-17/1	链条节销螺钉	6		Thread Tension Disc Pad
			1		Connecting Link Pin Screw



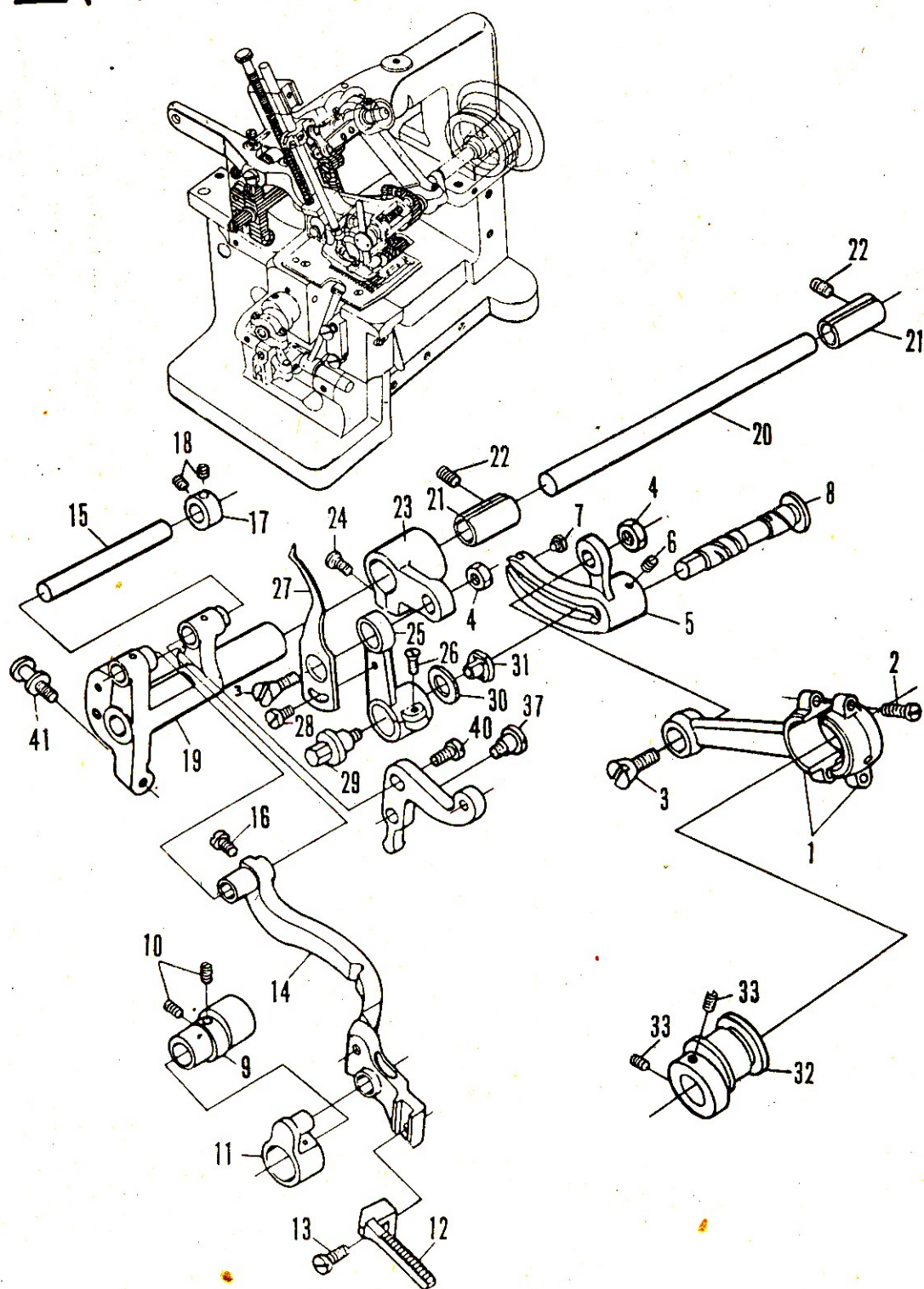
三、抬牙送布部件

III. FEED LIFTING AND FEED COMPONENTS

序号	图号	名称	件数	备注	No. for Singer Model	Description
1	6A3-a	送布牙架连杆组件	1		42008	Feed Bar Connecting Rod Assembly
2	6A2-b 03	送布牙架连杆螺钉	2	同针杆连杆螺钉	1057	Feed Bar Connecting Rod Cap Screw
3	6A6-23	牙架连杆圆锥螺钉	1	同圆锥螺母	1373	Feed Bar Connecting Rod Hinge Screw
	6A6-23	拾牙架连杆圆锥螺钉	1		1373	Feed Lifter Connecting Rod Hinge Screw
4	6A6-24	牙架连杆圆锥螺母	1		1520	Feed Bar Connecting Rod Nut
	6A6-24	拾牙架圆锥连杆圆锥螺母	1	同圆锥螺母	1520	Feed Lifter Connecting Rod Nut
5	6A3-10	大开针架	1		42014	Feed Regulator(large)
6	6A2-21	大开针架支头螺钉	2	同针杆曲柄支头螺钉	1258	Feed Regulator(large) Set Screw
7	6A6-21	开针架限位螺钉	1	同卜弯针线勾螺钉	233	Feed Regulator(large) Stop Screw
8	6A3-30	大开针架轴	1		42016	Feed Regulator(large) stud
9	6A3-63	抬牙上刀凸轮	1		42012	Feed Lifting / Upper Knife Cam
10	6A3-03 2	抬牙上刀凸轮螺钉	2	JA1-1/J0.068	462	Feed Lifting / Upper Knife Cam Screw
11	6A3-04	抬牙连杆	1		42013	Feed Lifting Connection
12	6A3-01	送布牙	1		42182	Feed Dog
13	6A5-26	送布牙螺钉	1	同JA1-1面板过线架螺钉	190	Feed Dog Screw
14	6A3-02	送布牙架	1		42151	Feed Bar
15	6A3-05	牙架轴	1		2007	Feed Bar Pin
16	6A3-07	牙架轴支头螺钉	1		1253	Feed Bar Pin Set Screw
17	6A3-08	牙架轴紧圈	1			Feed Bar Pin Thrust Collar
18	6A4-a 07	牙架轴紧圈螺钉	2			Feed Bar Pin Thrust Collar Screw
19	6A3-06	摇牙架	1		42154	Feed Bar Rocking Bracket

20	6A3-09	大开架芯轴	1	42098	Feed Bar(large) Spindle
21	6A6-16	开口套筒	2	42079	Feed Bar(large) Spindle Bushing
22	6A2-21	开口套筒螺钉	2	1036	Bushing Screw
23	6A3-25	拾牙架轧头	1	42021	Feed Lifter Crank
24	J0.0.45	拾牙架轧头螺钉	1	157	Feed Lifter Crank Screw
25	6A3-27	拾牙架连杆	1	42015	Feed Lifter Connecting Rod
26	6A3-27/1	拾牙架连杆小螺钉	1	1012	Feed Lifter Connecting Rod Clamping Screw
27	6A3-28	针距指针	1	42017	Feed Regulator Indicator
28	6A5-26	号码针螺钉	1	190	Feed Regulator Indicator Screw
29	6A3-13	针距螺钉	1	1374	Feed Regulating Screw
30	6A3-12	针距螺钉垫圈	1	19044	Feed Regulating Screw Washer
31	6A3-14	针距螺母	1	1680	Feed Regulating Screw Nut
32	6A3-15	送布凸轮	1	42011	Feed Cam
33	6A3-16	送布凸轮螺钉	2	453	Feed Cam Screw
34	6A3-23	小开针架夹紧螺钉	1	190	Feed Regulator(small) Clamping Screw
35	6A3-24	小开针架调节螺钉	1	1444	Feed Regulator(small) Regulating Screw
					同JA1-1型压杆导架螺钉

三、



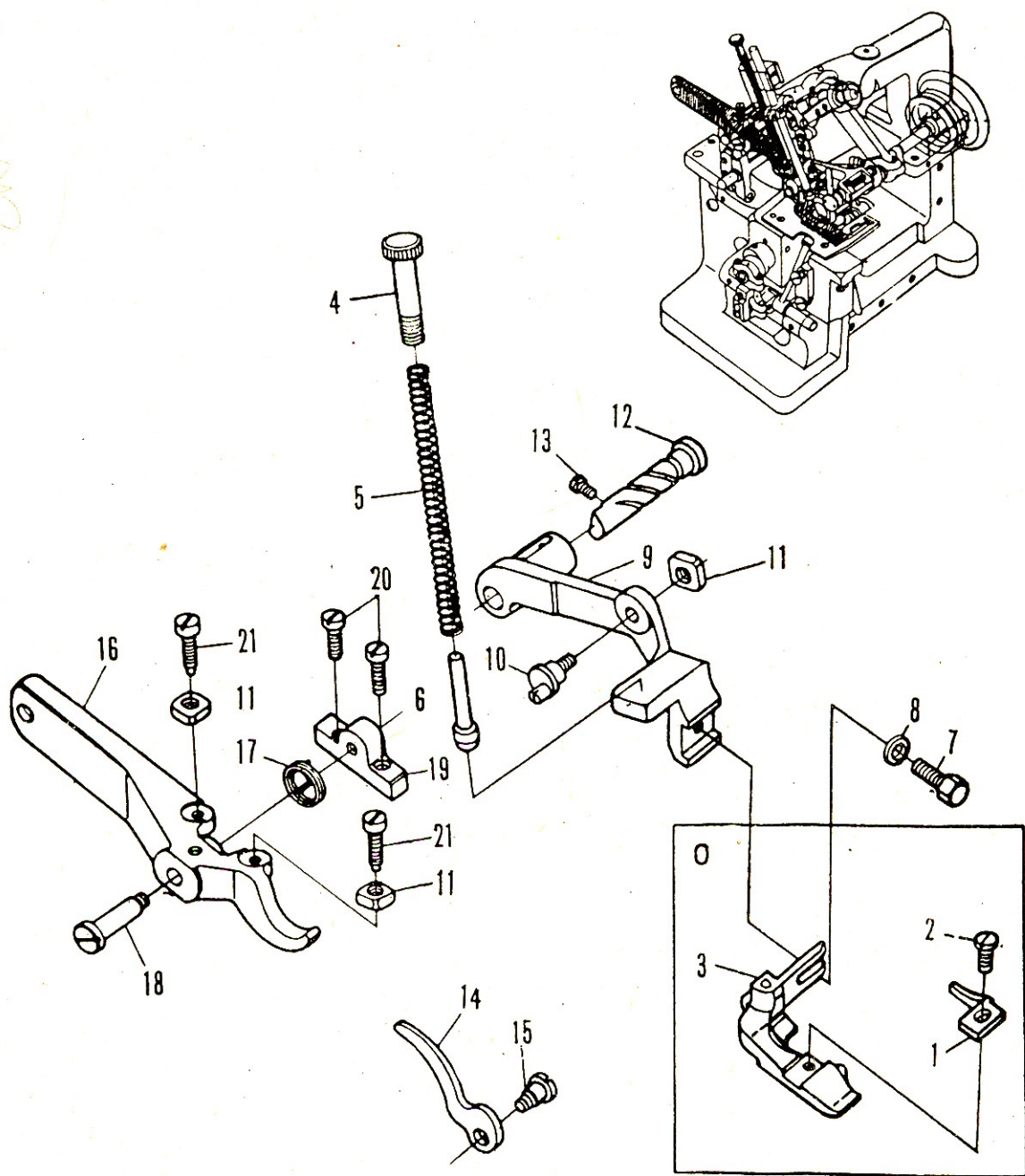
四、压脚部件

IV. PRESSER FOOT COMPONENTS

序号	图号	名称	件数	备注	No. for Singer Model	Description
0	6A4-a	压脚组件	1		42185	Presser Foot Assembly
1	6A4-a 01	编结导块	1			Stitch Finger
2	6A6-21	编结导块螺钉	1			Stitch Finger Screw
3	6A4-a 02	压脚体	1		1378	Presser Foot
4	6A4-01	调压螺钉	1		42071	Pressure Regulating Thumb Screw
5	6A4-02	压紧簧	1			Pressure Spring
6	6A4-03	压紧杆	1			Presser Bar
7	6A4-04	压紧螺钉	1		1324	Presser Foot Screw
8	6A4-05	压脚螺钉垫圈	1		19044	Presser Foot Screw washer
9	6A4-06	压脚架	1		42069	Presser Foot Holder
10	6A4-07	抬压偏心螺钉	1		1377	Presser Lifting Eccentric Screw
11	6A4-18	抬压偏心螺母	1		1547	Presser Lifting Eccentric Screw Nut
	6A4-18	抬压杠杆调节螺母	2	同抬压偏心螺母	1547	Presser Lifting Lever Regulating Screw Nut
12	6A4-08	压脚架轴	1		42045	Presser Foot Holder Stud
13	6A4-09	压脚架轴支头螺钉	1		1120	Presser Foot Holder Stud Screw
14	6A4-10	压脚板手	1		42070	Presser Foot Lifting Handle
15	6A4-11	压脚板手螺钉	1		85	Presser Foot Lifting Handle Screw
16	6A4-12	抬压杠杆	1		42130	Presser Lifting Lever
17	6A4-13	抬压杠杆簧	1		42132	Presser Lifting Lever Spring
18	6A4-14	抬压杠杆螺钉	1		1301	Presser Lifting Lever Screw
19	6A4-15	抬压杠杆座	1		42131	Presser Lifting Lever Base
20	6A4-16	抬压杠杆座螺钉	1		1229	Presser Lifting Lever Base Screw
21	6A4-17	抬压杠杆调节螺钉	2		1148	Presser Lifting Lever Regulating Screw

四、

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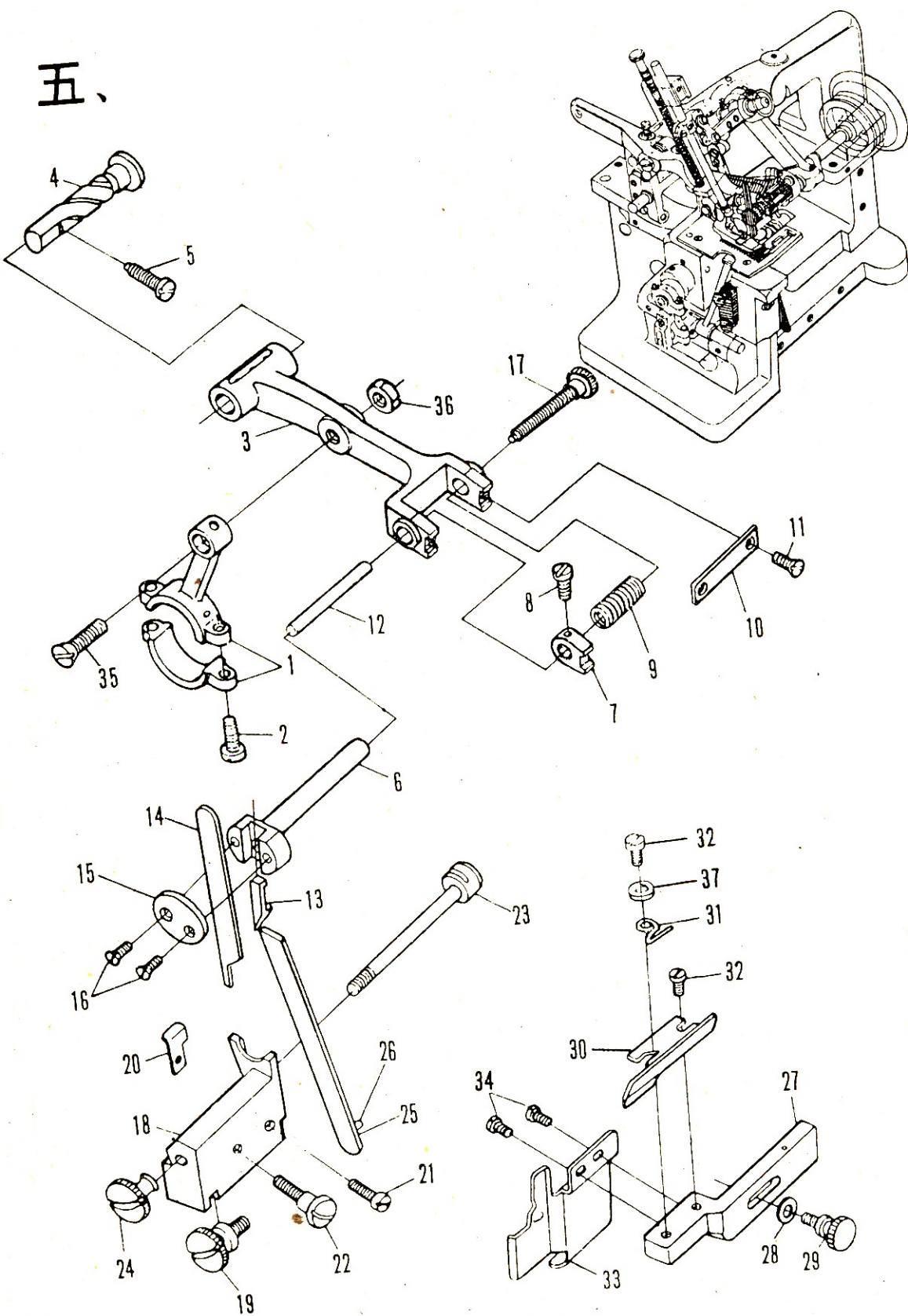
五、刀架部件

V. KNIFE HOLDER COMPONENTS

序号	图 号	名 称	件数	备 注	No. for Singer Model	Description
1	6A5-a	上刀连杆组件	1		42043	Upper Knife Connecting Rod Assembly
2	6A5-a 03	上刀连杆螺钉	2		175	Upper Knife Connecting Rod Cap Screw
3	6A5-01	上刀架	1		42042	Upper knife Bracket
4	6A4-08	上刀架轴	1	同压脚架轴	42045	Upper knife Bracket Stud
5	6A4-17	上刀架轴定位螺钉	1	同抬压杆调节螺钉	1148	Upper Knife Bracket Stud Set Screw
6	6A5-02	上刀座	1		42035	Upper Knife Holder
7	6A5-03	上刀座导套	1		42038	Upper Knife Holder Guide Bushing
8	6A2-14	导套螺钉	1	同针杆过线架螺钉	336	Upper Knife Holder Guide Bushing Position Screw
9	6A5-05	上刀座调节簧	1		42041	Upper Knife Holder Pressure Regulating Spring
10	6A5-06	上刀座导板	1		42039	Upper Knife Holder Guide Plate
11	6A5-11	上刀座导板螺钉	2	同上刀盖螺钉(短)	621	Upper Knife Holder Guide Plate Screw
12	6A5-07	挺刀肖	1		42040	Upper Knife Extension Pin
13	6A5-08	上刀垫	1		42112	Upper Knife Spacer
14	6A5-09	上刀	1		42111	Upper Knife
15	6A5-10	上刀盖	1		42037	Upper Knife Cap
16	6A5-11	上刀盖螺钉	2		404	Upper Knife Cap Screw
17	6A5-12	挺刀螺钉	1	19004		Upper Knife Extension Pin Regulating Screw
18	6A5-13	下刀架	1		42156	Lower Knife Bracket
19	6A5-14	下刀架调节螺钉	1		1376	Lower Knife Bracket Regulating Screw
20	6A5-15	护针板	1		42066	Needle Guard
21	6A2-27	护针板螺钉	1	同止摆夹头螺钉	171	Needle Guard Screw

22	6A5-16	下刀架螺钉	1	1101	Lower Knife Baacket Screw
23	6A5-17	下刀座	1	42048	Lower Knife Holder
24	6A5-18	下刀座螺母	1	1534	Lower Knife Holder Nut
25	6A5-19	下刀	1	42046	Lower Knife
26	6A5-20	下刀柄	1	42049	Lower Knife Shank
27	6A5-21	拦刀架	1	42102	Upper Knife Supporter Bracket
28	6A5-22	拦刀架垫圈	1		Upper knife Supporter Regulating Screw Washer
29	6A5-23	拦刀架螺钉	1	283	Upper Knife Supporter Regulating Screv
30	6A5-24	拦刀板	1	42030	Upper Knife Supporter
31	6A5-25	右罩板簧	1	42101	Right Side Cover Lock Spring
32	6A5-26	拦刀板螺钉	2	190	Right Side Cover Lock Spring Screw
33	6A5-27	罩板	1	42153	Cover
34	6A2-07	罩板螺钉	2	217	Cover Screw
35	6A6-23	上刀连杆圆锥螺钉	1	1373	Upper Knife Connecting Rod Hinge Screw
36	6A6-24	上刀连杆圆锥螺母	1	1520	Upper Knife Connecting Rod Hinge Screw Nut
37	6A5-25/1	右罩板簧垫圈	1		Right Side Cover Lock Spring Washer

五、



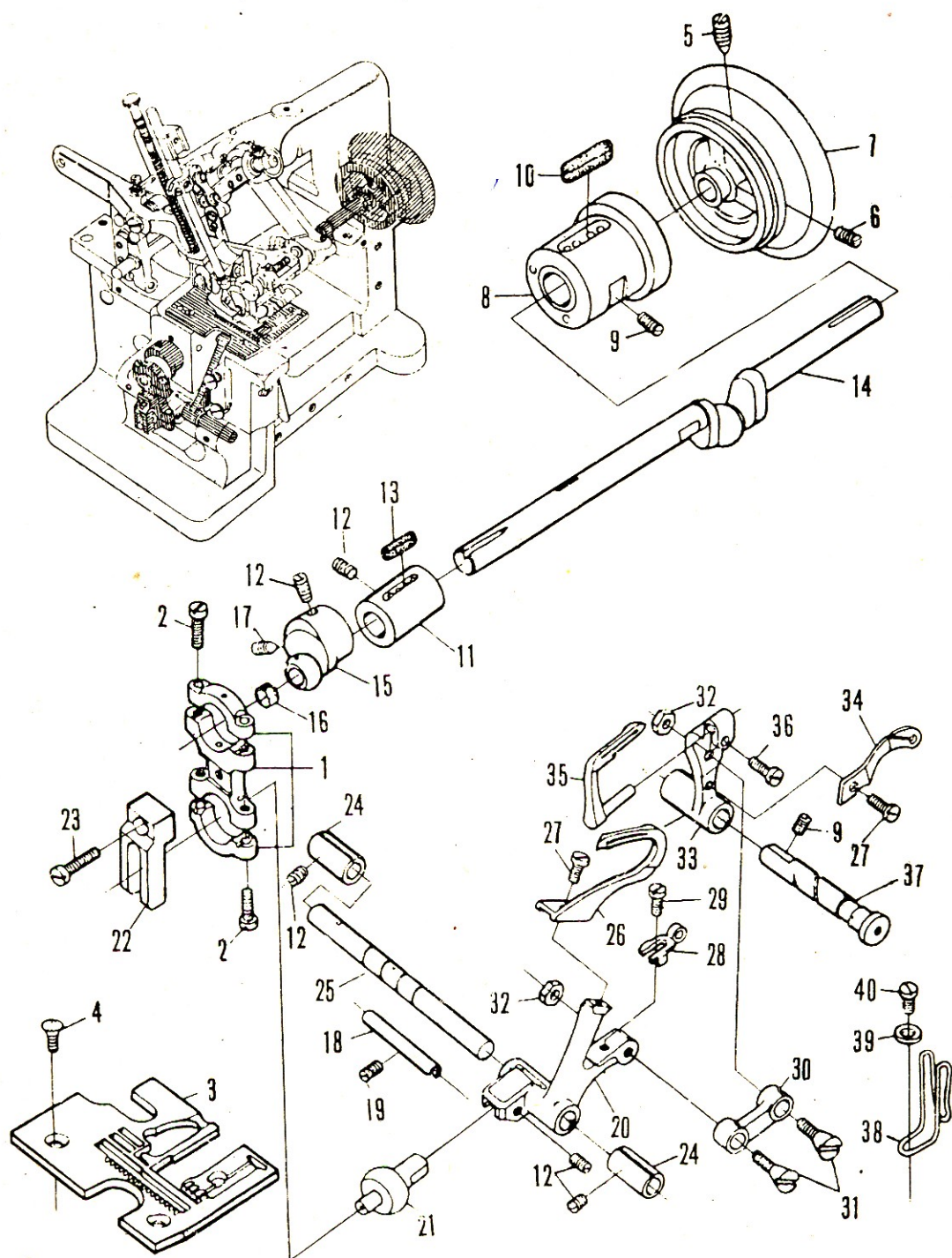
IV. UPPER/LOWER LOOPER COMPONENTS

六、上下弯针部件

序号	图 号	名 称	件数	备 注	No. for Singer Model	Descriptoin
1	6A6-a	上针连杆组件	1		42075	Upper Looper Connecting Rod Assembly
2	6A2-b 03	上针连杆螺钉	4	同针杆连杆螺钉	1057	Upper Looper Connecting Rod Cap Screw
3	6A6-01	针板	1		42186	Throat Plate
4	6A6-02	针板螺钉	2		742	Throat Plate Screw
5	6A6-03	轮盘定位螺钉	1		1354	Hand Wheel Position Screw
6	6A6-04	轮盘支头螺钉	1		424	Hand Wheel Set Screw
7	6A6-05	轮盘	1		42001	Hand Wheel
8	6A6-06	后套筒	1		42026	Main Shaft Bushing(back)
9	6A2-21	后套筒螺钉	1	同针杆曲柄支头螺钉	1036	Main Shaft Bushing(back) Screw
10	6A6-07	下弯针架轴螺钉	1	同后套筒螺钉	1036	Lower Looper Holder Stud Screw
11	6A6-08	后套筒油毡	1			Main Shaft Bushing(back) Oil Felt
12	6A2-21	前套筒	1		42024	Main Shaft Bushing (front)
	6A2-21	前套筒螺钉	1		1036	Main Shaft Bushing (fornt) Screw
	6A2-21	上针曲柄螺钉	1		1259	Upper Lopoer Crank Screw
	6A2-21	开口套筒螺钉	2		1036	Upper Looper Holder Shaft Bushing Screw
	6A2-21	上弯针架螺钉	1	同前套筒螺钉	1259	Upper Looper Holder Screw
13	6A6-09	前套筒油毡	1			Main Shaft Bushing(front) Oil Felt
14	6A6-10	主轴	1		42023	Main Shaft
15	6A6-11	上针曲柄	1		42025	Upper Looper Crank
16	6A6-12	上针曲柄油毡	1			Upper Looper Crank Oil Felt
17	6A6-13	上针曲柄定位螺钉	1		1375	Upper Looper Crank Position Screw

18	6A6-14	过线管	1	同针杆套筒支头螺钉	42084	Thread Tube
19	6A2-09	过线管螺钉	1		42073	Thread Tube Screw
20	6A6-15	上弯针架	1		42074	Upper Loop Holder
21	6A2-25	钢弹子	1	同钢弹子	42077	Ball Stud
22	6A2-26	止摆夹头	1	同止摆夹头	171	Ball Stud Guide
23	6A2-27	止摆夹头螺钉	1	同止摆夹头螺钉	42079	Ball Stud Guide Screw
24	6A6-16	开口套筒	2		42078	Upper Loop Holder Shaft
25	6A6-17	上弯针架轴	1		42166	Upper Loop Holder Shaft
26	6A6-18	上弯针	1		197	Upper Loop Holder
27	6A6-19	上弯针螺钉	1		42083	Upper Loop Screw
28	6A6-20	下弯针线勾	1		378	Lower Loop Thread Guide
29	6A6-21	下弯针线勾螺钉	1	同GB1:1摆轴滑块垫圈螺钉	233	Lower Loop Thread Guide Screw
30	6A6-22	下弯针架连杆	1		42052	Lower Loop Holder Link
31	6A6-23	下弯针架连杆圆锥螺母	2		1520	Lower Loop Holder Link Hinge Screw
32	6A6-24	圆锥螺母	2		42051	Lower Loop Holder
33	6A6-25	下弯针架	1		42127	Upper Loop Thread Take-up
34	6A6-26	上弯针线勾	1		42114	Lower Loop
35	6A6-27	下弯针	1		209	Lower Loop Clamping Screw
36	6A6-28	下弯针夹紧螺钉	1		42053	Lower Loop Holder Stud
37	6A6-29	下弯针架轴	1		42093	Upper Loop Thread Guide
38	6A6-30	上弯针过线	1			Upper Loop Thread Guide Screw
39	6A6-31	上弯针过线螺钉垫圈	1		190	Upper Loop Thread Guide Screw
40	J0.0.72	上弯针过线螺钉		同JA1-1		

六、

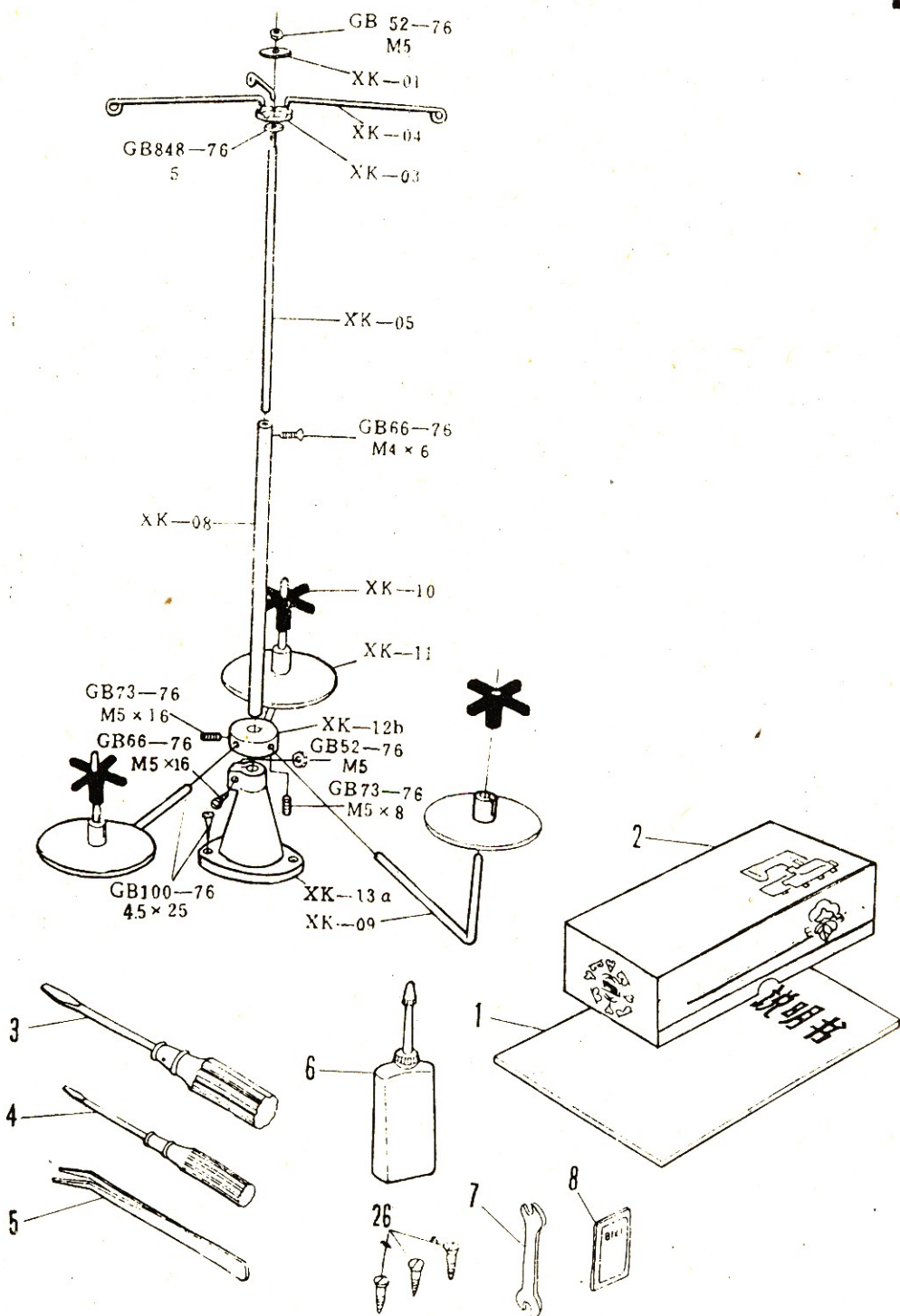


VII. THREAD STAND COMPONENTS

七、附件、线架部件

序号	图 号	名 称	件数	Description	备 注
1		说明书	1	Instruction Book	
2		零件盒	1	Attachments Box	
3		大号螺丝批	1	Screw Driver(large)	
4		小号螺丝批	1	Screw Driver(small)	
5		穿线钳	1	Tweezer	
6		油 壶	1	Oiler	
7		小板手	1	Wrench	
8		机 针	10枚	Needle	型号: 81 × 1 针号: 11
9	XK-01	线勾压板	1	Thread Eyelet Platen	
10	XK-03	线勾托板盘	1	Thread Eyelet Pallet	
11	XK-04	单环线勾	3	Thread Eyelet	
12	XK-05	上立柱	1	Thread Stand Rod(upper)	
13	XK-08	下立柱	1	Thread Stand Rod(lower)	
14	XK-09	线团钉	3	Spool Pin	
15	XK-10	线团定心节	3	Spool Stoper	
16	XK-11	线盘	3	Spool Seat Disc	
17	XK-12b	线团钉接头	1	Spool Pin Joint	
18	XK-13a	线架座(塑料件)	1	Thread Stand Base	

序号	代号	名称	件数	Description	备注
19	GB52-76	六角螺母	2	Hexagon Nut	M5
20	GB73-76	平端紧定螺钉	3	Headless Set Screw	M5×8
21	GB73-76	平端紧定螺钉	1	Headless Set Screw	M5×16
22	GB66-76	球面圆锥头螺钉	1	Ball Head Cap Screw	M4×6
23	GB66-76	球面圆柱头螺钉	1	Ball Head Cap Screw	M5×16
24	GB100-76	沉头木螺钉	3	Counter Sunk Head Wood Screw	4.5×25
25	GB95-76	垫圈	1	Washer	φ5
26		木螺钉	3	Wood Screw	

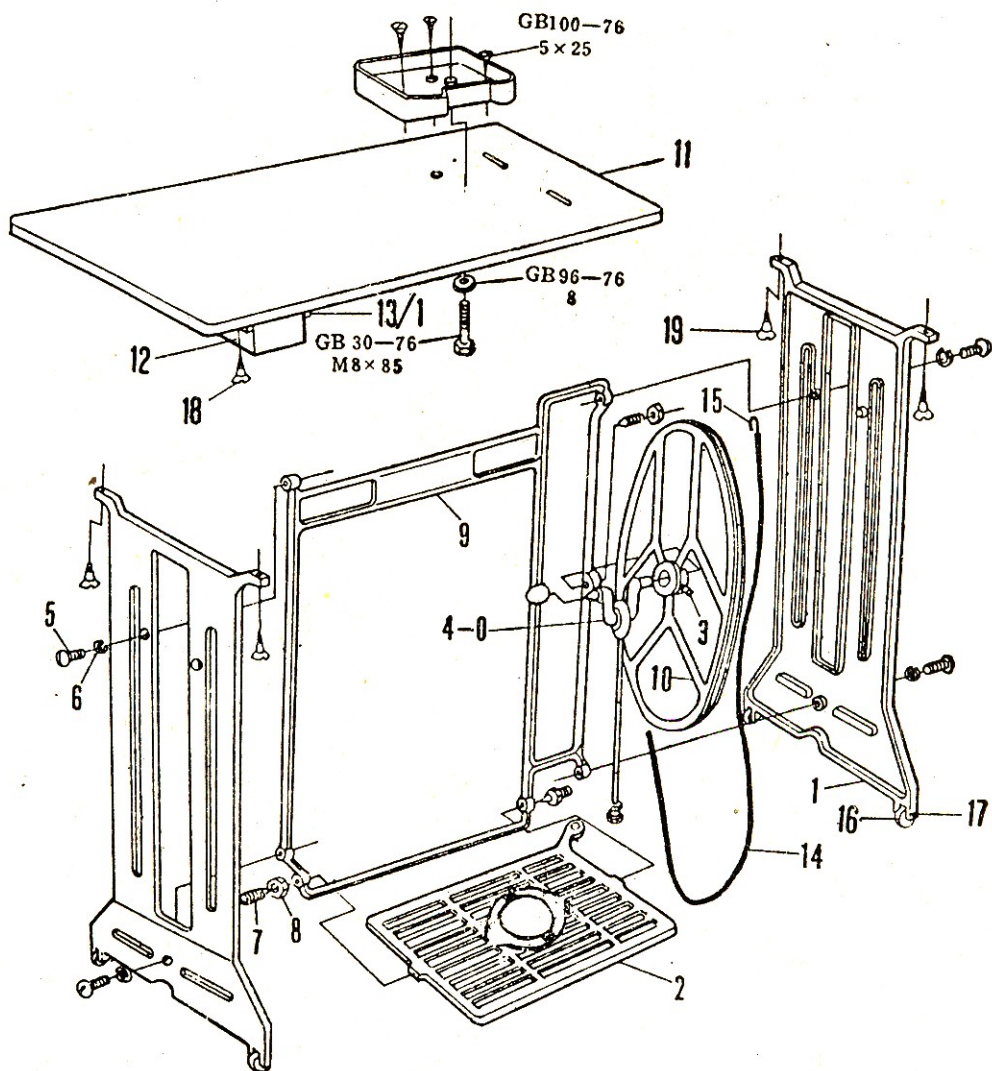


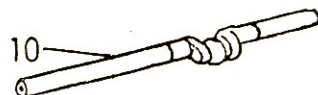
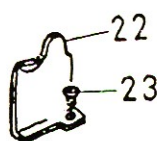
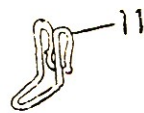
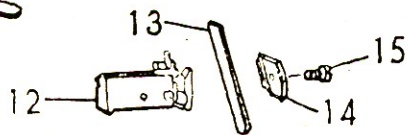
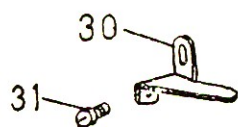
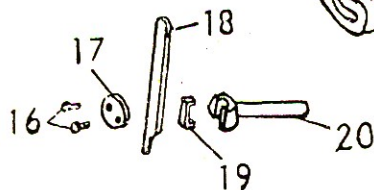
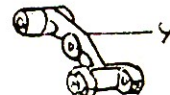
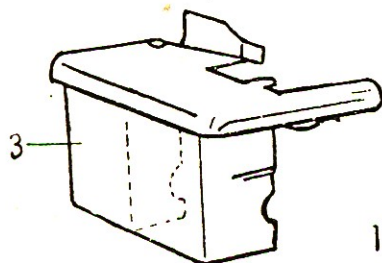
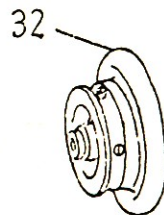
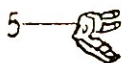
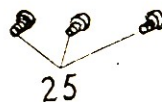
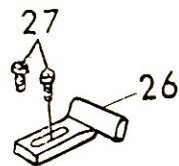
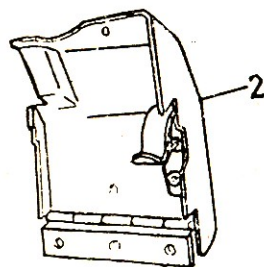
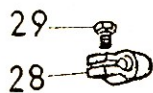
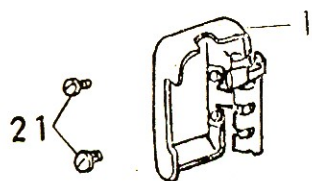
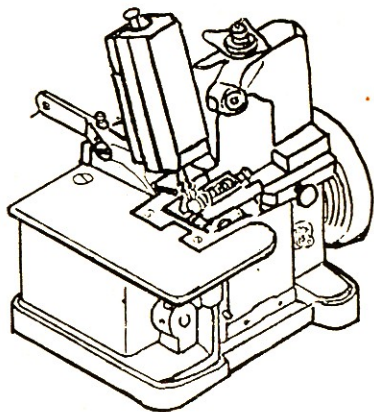
八、机架部件

VIII. TABLE STAND COMPONENTS

序号	图 号	名 称	件数	Description	备 注
1	1	边架	2	Table Stand	
2	2	踏板	1	Pedal	
3	3	下带轮螺钉	1	Belt Pulley Set Screw	
4	4-0	摇杆组件	1	Rock Lever Assembly	
5	5	边架螺钉	4	Table Stand Screw	
6	6	边架弹簧垫圈	4	Table Stand Spring Washer	
7	7	方架顶尖螺钉	3	Frame Screw Center	
8	8	方架顶尖螺母	3	Frame Screw Center Nut	
9	9	方架	1	Frame	
10	10	下带轮	1	Belt Pulley	
11	11	台板	1	Table	
12	12	抽斗	1	Drawer	
13	13/1	抽斗导轨	2	Drawer Rail	
14	14	皮带	1	Belt	
15	15	皮带扣	1	Belt Fastener	
16	16	边架小轮	4	Table Stand Truck	
17	17	小轮轴	4	Table Stand Truck Pin	通GB867-76
18		抽斗导轨木螺钉 4×32	4	Drawer Rail Wood Screw	GB100-76
19		抬板木螺钉 台5×25	4	Table Wood Screw	GB100-76

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GN1-113型另件目录

NUMERICAL LIST OF PARTS FOR MACHINE GN1-113

序号	图 号	名 称	件数	
No.	Ref.No.		Quantity	DESCRIPTION
1	1-1-4-0	上罩壳部件	1	Needle Bar Comple to
2	1-1-5-0	后罩壳部件	1	Frame Bar Cover Complete
3	1-1-3-0	缝台部件	1	Cloth Plate Complete
4	1-2-02	下弯针过线板	1	Tension (looper lefthand) Thresde Guide
5	1-4-01	压脚体	1	Presser Foot Complete
6	1-6-01	针板	1	Throat Plate
7	1-6-02	大针曲柄	1	Frame Rotary Shaft Crank Poslition Screw
8	1-3-01	大开针架	1	Feed (front) Regulator With two 6A2-21
9	1-5-01	上刀连杆	1	Knife (movable) lever
10	1-6-06	曲轴	1	Frame Rotary Shaft
11	1-6-05	大弯针过线	1	Thread (looper right hand) Staple
12	1-5-07	下刀架	1	Knife (Stationary) Holder
13	1-5-10	下刀	1	Knife (Stationary) With Stud
14	1-5-08	下刀压板	1	Knife (Stationary) With Stud
15	1-5-09	下刀压板螺钉	1	Feed (back) Dog Screw
16	1-5-06	上刀盖螺钉	2	Knife (movable) Holder Cap Screw
17	1-5-05	上刀盖	1	Knife (movable) Holder Cap
18	1-5-04	上刀	1	Knife (movable)
19	1-5-03	上刀垫	1	Knife (movable) Gib
20	1-5-02	上刀座	1	Knife (movable) Holder
21	1-1-4-05	上罩壳螺钉	2	Needle Bar Cover Set Scrow
22	1-1-09	前罩壳	1	Frame Top Cover
23	6A2-b03	针杆连杆螺钉	1	Frame Top Cover Screw
24	1-1-13	避震垫块螺钉	4	Machine Cushion Screw
25	6A3-18	小牙齿螺钉	3	Framo Back Cover Bracket Screw
26	1-1-06	止回块	1	Frame Back Cover Catch Bracker
27	GB6-1 1-1-4	止回块螺钉	2	Frame Back Cover Catch Bracker Screw
28	1-2-01	摆轴曲柄	1	Needlle Bar Crank (back) With three 6A2-21
29	1-2-03	摆轴曲柄螺钉	1	Needle Bar Crank (back) Ball Stud Set Screw
30	1-1-08	下弯针过线罩板	1	Thread (Looper. left hand) Guide
31	6A3-18	小牙齿螺钉	2	Thread (Looper. left hand) Guide Bracket Screw
32	1-6-03	轮盘	1	Balanco Wheel With

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