



GLOBAL

US 63900 CH SERIES

CHAINSTITCH HEMMING MACHINES

Instruction & Parts manual

www.globalsew.com

info@globalsew.com

63900CS系列机专用调整说明及图解零件手册

Adjusting Instructions & Illustrated Parts List for 63900CS Series Machines

前 言

本零件手册将有助于在63900CS系列机器上寻找特别的零件或组件。
本手册中的零件均是为机器特别设计并用极致的精度制造出来，以保证机器能长时间运转。
本手册由可提供的资料基础组成。设计上的改变或改进会包含在图解或零件号配置上的轻微修改。

PREFACE

- This parts manual has been prepared to assist you in locating individual parts or assemblies on 63900CS Series machines.
- Parts listed in this manual are designed specifically for your machine and are manufactured with utmost precision to assure long lasting service.
- This manual has been comprised on the basis of available information. Changes in design and/or improvements may incorporate a slight modification of configuration in illustrations or part numbers.

安全规则

SAFETY RULES

1. 机器安装前要按手册所述保养并认真阅读使用说明，在取得开机指令之后才允许由有资格的操作员开动每台机器。

注意：机器安装前，也要阅读安全规则和电机厂家提供的使用说明。

Before putting the machines described in this manual into service, carefully read the instructions. The starting of each machine is only permitted after taking notice of the instructions and by qualified operators.

IMPORTANT! Before putting the machine into service, also read the safety rules and instructions from the motor supplier.

2. 遵守贵国所颁布的国家安全规则。

Observe the national safety rules valid for your country.

3. 机器准备工作或正在工作时，所有的安全设施必须在其位。没有安全设施的机器禁止开动。

All safety devices must be in position when the machine is ready for work or in operation. Operation of the machine without the appertaining safety devices is prohibited.

4. 配戴安全眼镜。

Wear safety glasses.

5. 更换机器时必须考虑其安全规则，否则会很危险。

In case of machine conversions and changer all valid safety rules must be considered. Conversions and changes are made at your own risk.

6. 警告提示使用以下符号之一作记号：

The warning hints in the instructions are marked with one of these two symbols:



7. 机器在下列情况下必须通过关闭主开关或拔出主插头断开动力供应。

7.1 机针、弯针、叉针的穿线；

7.2 更换如机针、压脚、针板、弯针、叉针、护针板、夹边器、导布器等零部件；

7.3 离开工作岗位而又没人顶替；

7.4 维修保养机器；

When doing the following the machine has to be disconnected from the power supply by turning off the main switch or by pulling out the main plug:

When threading needle(s), looper, spreader etc.

When replacing any parts such as needle(s), presser foot, throat plate, looper, spreader, needle guard, folder, fabric guide etc.

When leaving the workplace and when the workplace is unattended.

When doing maintenance work.

8. 维护、修理及更换机件必须只能由经训练的技术人员或专门的熟练工人根据使用说明来进行。

Maintenance, repair and conversion work (see item 7) must be done only by trained technicians or special skilled personnel under consideration of the instructions.

9. 在任何电设备上工作必须由电工或在专业人员监督指导下进行。

Any work on the electrical equipment must be done by an electrician or under direction and supervision of special skilled personnel.

10. 在带电零件及设备上的工作是不允许的，除非另有说明。

Work on parts and equipment under electrical power is not permitted. Permissible exceptions are described in the applicable sections of standard sheet.

11. 在维护及修理气动设备上的机件前，机器必须与压缩空气断开，这时，还存有残留的空气压力，与压缩空气（如带有气罐的设备）断开后，压力必须完全释放。

Before doing maintenance and repair work on the pneumatic equipment, the machine has to be disconnected from the compressed air supply. In case of existing residual air pressure, after disconnecting from compressed air supply (i.e. pneumatic equipment with air tank), the pressure has to be removed by bleeding.

机器的介绍

CLASS DESCRIPTION

本机是一种高速最新型长臂针送料链式线迹缝纫机。单针、轻、中、重型，连续运转针送料，弯针，水平弯针轴，改变线迹长度的齿轮，调整针送料的狭槽，1 1/4英寸的针杆传动，一个油池环绕自动润滑系统，机头虹吸润滑，可调整的旋梭润滑控制，挑线杆用针轴承及针杆由连杆驱动，针送料与上轴同步，针杆右边有8英寸的极大工作空间。

High speed streamlined long arm needle food chainstitch machines. One needle, light, medium and heavy duty, continuous running roller feed, looper, horizontal looper shaft, gears for changing stitch length, slot segment for adjusting needle feed, 1 1/4 inch needle bar travel, one reservoir enclosed automatic lubrication system, head oil siphon, adjustable hook oil control, needle bearing for take-up lever and needle bar driving link, needle feed timing on upper shaft, maximum work space to right of needle bar 8 inches.

插图

ILLUSTRATIONS

本手册是为了简化订购维修零件而编制，机器各个部件的分解图显示每个零件在机器中的实际位置。在每一页的插图会有一份明细表，表中列有零件的代号、件号、名称以及件数。

This manual has been arranged to simplify ordering repair parts. Exploded views of various sections of the mechanism are shown so that the parts may be seen in their actual position in the machine. On the page opposite the illustration will be found a listing of the parts with their symbol, part numbers, description and the number of pieces required in the particular view being shown.

第一列的数字只是表示零部件在插图中的位置，在订购零部件时决不使用。订购零部件时只使用第二、第三列的零件代号及件号。

Numbers in the first column are reference numbers only, and merely indicate the position of the part in the illustration. The reference numbers should never be used in ordering parts. Always use the symbol listed in the second column or the part number listed in the third column.

为维修提供的辅助零部件排在其主部件之下，例如：

Component parts of sub-assemblies which can be furnished for repairs are indicated by indenting their descriptions under the description of the main sub-assembly. As an example refer to the following text.

20	9D-20	63984A	滚针轴承止动圈-----1
			Needle Bearing Retaining Collar
21	9D-21	95	紧定螺钉-----2
			Set Screw

如果一个零件在机器中多次使用，则在手册中的名称一栏就没有明确其用途。如果这个零件在不同的机器中是不一样的，则在手册中的名称一栏明确标明其用途。如果需要，会在插图中显示其不同之处。

When a part is common to all machines covered in this manual, no specific usage will be mentioned in the description. However, when the parts for the various machines are not the same, the specific usage will be mentioned in the description and, if necessary, the difference will be shown in the illustration.

序号不等于件号，只是代表位置。

* Ref.No. showing no part No. is for location only. part is not for sale separately.

在手册的后面有一个全部零件的件号索引，当您只知道件号时助您查找其插图和名称。

A numerical index of all the parts shown in this manual is located at the back. This will facilitate locating the illustration and description when only a part number is known.

机针 NEEDLES

每支机针都有型号和规格，型号数字代表针柄类型、针尖形式、长度、针槽形式、磨光及其他细节，规格数字印在机针针柄上，表示针眼与针柄之间针杆的最大直径。

Each needle has both a type and size number. The type number denotes the kind of shank, point, length, groove, finish and other details. The size number, stamped on the needle shank, denotes the largest diameter of the blade measured between the shank and the eye.

类型 TYPE

DVX57

机针种类 DESCRIPTION

圆柄、圆刃、链式线迹、短长度、外球针眼、双槽、穿槽、扁位、镀铬。

规格: 14# 16# 18# 20# 22#

Round shank, round point, chainstitch, short length, oversize ball eye, double groove, deep spot, chromium plate-sizes 14# 16# 18# 20# 22#

更换机针时，必须使机针完全插入针夹，并拧紧螺钉。

When changing the needles, make sure it is fully inserted in the needle holder before the screw is tightened.

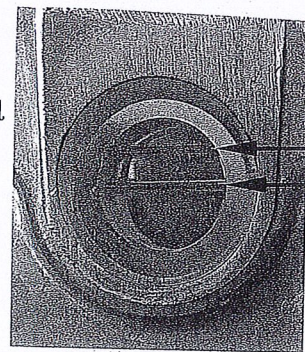
润滑油 LUBRICATION

注意：机器出厂前油池内的油是排干的，开动机器前必须往油池内注满油。

机器慢慢地开动几分钟，使润滑油分布到各个部件，彻底润滑。全速开动机器时才可减少机器的磨损。

CAUTION! Oil has been drained from the main reservoir before shipment and the reservoir must be filled before starting to operate.

Lubricate machine thoroughly, in accordance with instructions which follow, and run slowly several minutes to distribute the oil to the various parts. Full speed operation can then be expected without damage.



油池内的油不能超过
此刻度线
the oil can't over this
scale line

油池内的油不能低过
此刻度线
the oil can't be lower
this scale line

图1
Fig.1

推荐的润滑油 RECOMMENDED OIL

主油池内的油使用120° F时粘性为90~125秒的白矿油

Use a stainless water-white straight mineral oil of a Saybolt viscosity of 90 to 125 seconds at 100° Fahrenheit in the main reservoir.

改变线迹长度（针距）

CHANGING THE STITCH LENGTH

63900CS机配有上送料调节器齿轮（63949-44）和下送料调节器齿轮（63949-36）可产生7针数/英寸，其他可使用的齿轮可以个别订购。从以下的“齿轮表”中可根据所需的针数/英寸，查阅对应的齿数件号。

63900CS will be equipped with upper feed regulator gear No.63949-44 and lower feed regulator gear No.63949-36 to produce 7 stitches per inch (S.P.I.). Other gears are available and may be ordered separately. Refer to "Gear Chart" below for the gears necessary to produce S.P.I. other than previously described.

齿轮表

GEAR CHART

针数 S.P.I.	上齿轮 UPPER GEAR	下齿轮 LOWER GEAR
6	63949-47	63949-33
7	63949-44	63949-36
8	63949-41	63949-39
9	63949-39	63949-41
10	63949-37	63949-43
11	63949-36	63949-44
12	63949-33	63949-47

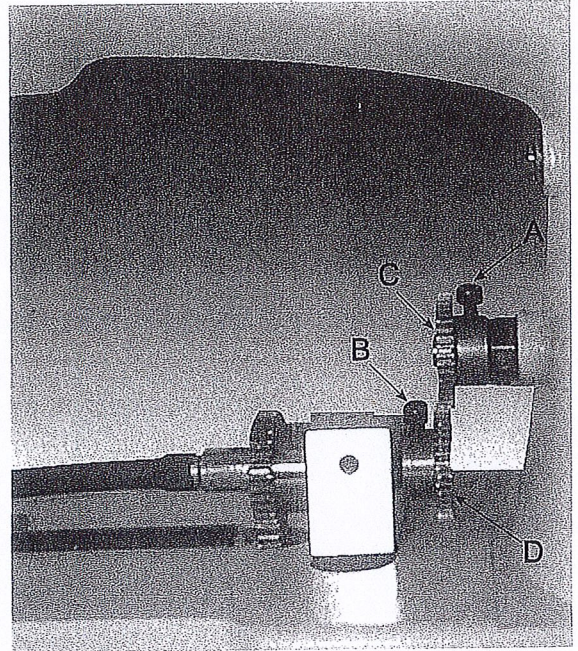


图2
Fig.2

为了拆下送料器齿轮，首先拆下位于机壳下面的送料驱动齿轮盖，松开螺钉（A和B，图2）并将齿轮滑离各自的支承轴，换上所需线迹长度的齿轮。新齿轮装好后，重新调节针送料线迹长度以适应连续旋转滚轮送料。

To remove feed regulators gears, first remove feed drive gear cover located under arm of machine. Now loosen screws (A and B, Fig.2) and slide gears (C and D, Fig.2) off their respective shafts. Replace with gears for desired stitch length. After new gears have been installed be sure to reset needle feed stitch length to agree with the continuous turning roller feed.

针送料与连续旋转轮送料的同步

TIMING THE NEEDLE FEED WITH THE CONTINUOUS TURNING ROLLER FEED

掀开机头顶盖（A，图3），松开机针支架驱动摆杆锁紧螺母（B，图3），将连续螺柱（C，图3）移到针送料每英寸针数最大值处，这时连接杆位于字母“S”点。

Open top cover (A, Fig.3) in the head of the machine and loosen needle frame drive segment locking nut (B, Fig.3). Set connection stud (C, Fig.3) to point of maximum number of stitches per inch of needle feed. This would locate the connecting arm at letter "S".

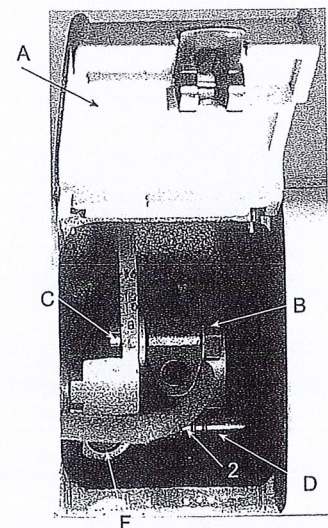


图3
Fig.3

针送料与连续旋转轮送料的同步（续）

TIMING THE NEEDLE FEED WITH THE CONTINUOUS TURNING ROLLER FEED (CONT.)

松开机针支架驱动偏心轮（D，图3）上的两个紧定螺钉，转动手轮直到针杆在其行程的低端，只是转动偏心轮，直到在连接杆上的同步线（2，图3）和偏心轮中心一致。在每次缝制厚料时，拧紧所有的螺钉，因为针送料同步的稍微提前会导致断线。

Loosen two set screws on the needle frame drive eccentric (D, Fig. 3). Rotate the handwheel until the needle bar is at the bottom of its stroke. Rotate the eccentric only, until the timing line (2, Fig. 3) on the connecting arm and the eccentric hub coincide. Tighten all screws, on every thick seams that cause thread breakage advance needle feed timing slightly.

转动手轮直到针杆在其行程的低端，针杆应垂直。如果不垂直，可松开夹紧螺钉（F，图3）并将针杆支架向前和向后移动直到针杆垂直为止，拧紧螺钉，针杆支架和摆杆之间有一定的间隙，使之可以移动。

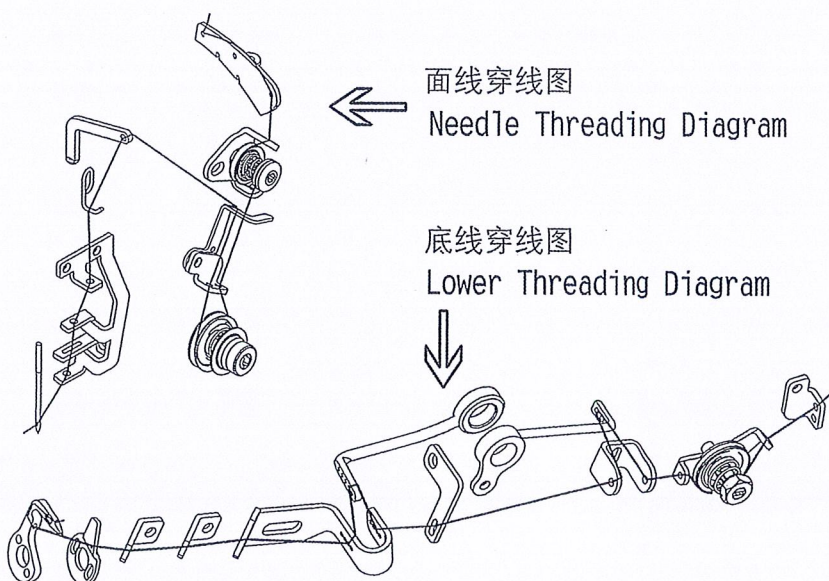
Rotate handwheel until the needle bar is at bottom of its stroke. The needle bar should be vertical. If it is not, loosen clamp screw (F, Fig. 3) and move needle bar frame forward and backward until bar is vertical. Tighten screw, making sure all side play is removed from between the needle bar frame and the segment.

为了调整针送料和滚轮送料一致，松开机针支架驱动摆杆锁紧螺母，将其连接点调向摆杆上更高的指定字母。这只是一盒近似的调整。当机针插入或离开最厚截面时，机针行程会有微小的偏差。

To set needle feed with roller feed loosen needle frame drive segment locking nut. Set connection toward higher designated letter on segment for approximate setting. Vary the needle travel so as to obtain the least amount of needle deflection when the needle enters or leaves the thickest section to be sewn.

穿线图

THREADING CHART



63900CS电控系统箱及自动剪线调整说明

Instructions for 63900CS electric system auto trimmer adjustment

1. 进入参数修改设置: 按住 键开启 电源显示屏显示 , 再按 选择所需参数后按 键, 再按 键改变参数中的数值, 修改后再按 保存 (设置密码为1269)。

Setting for parameter amendment: press key and turn , the viewing screen displays , and then press to select the parameter you needed, press key and then key to change the value of the parameter, press key to save after amendment (the setting code is 1269).

参数 PARAMETER	数值设置 VALUE
001设置缝纫速度 Setting the speed	3000
007慢速起缝速度 (灯亮时开启) Low speed (turn on when light)	1500
008慢速起缝针数 Low speed stitches	2
040剪线后勾面线动作 (OF关、ON开) Hook upper-thread after trimmer (OFF.ON)	ON
061切线速度 Cutting speed	100
217开拉筒 (1.开 0.关) Oper the folder (1.open 0.close)	1

2. 恢复出厂参数设置: 按住 键同时开启 电源, 此时显示屏数字闪烁四次即可。

Reset the original parameter: at the same time press key and turn the power, the number of the viewing screen flashes four times.

3. 剪刀的调整: 把拉杆和气缸推尽到最左端, 动刀拉杆在最左端往右方向移约0.5mm间隙, 然后调整好气缸推动块和拉杆平行, 拧紧两个M5螺母。(注: 调整后请确保剪线拉杆动作顺畅)

The adjustment of the kmife: push the pull rod and the cylinder to the far left, the moving kmife rod moves 0.5mm from the far left to the right direction, adjust the cylinder push black and the pull rod in parallel direction, tighten the two M5 nuts (please make sure the trimmer pull rod moves smoothly after the adjustment).

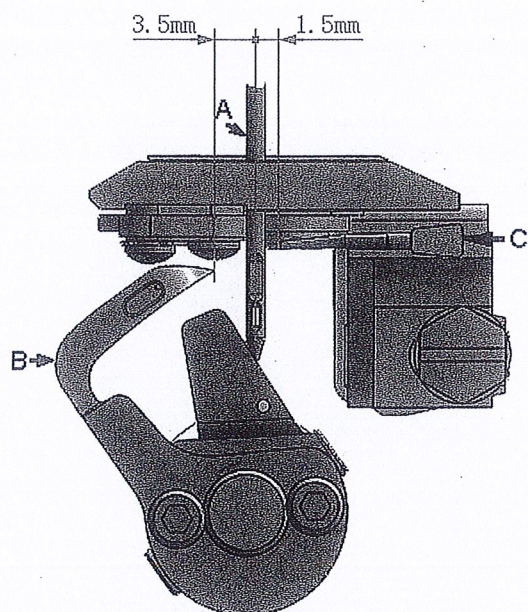
注: 机器使用的是最新款剪线气缸, 用2.5mm内六角工具拧松气缸后端固定块螺钉, 向上转动会使推动块与拉杆销轴分离, 拧松针板螺钉就可拆下针板, 待针板调整安装好, 向下转动推动块, 使拉杆销轴在推动块槽内, 调整推动块平行拧紧气缸后固定块螺钉即可。

ATTENTION: The new style trimmer cylinder used in the machine. Unscrew the setting serew behind the cylinder by hexagon wrench, turning up and separate the push block and the pull rod pin. Unscrew the screw of the needle plate to remove the needle plate. After adjusting the needle plate, install it. Turn down the push block to make the the pull rod pin in the groove of the push block. Adjust the push block in parallel direction, tighten the setting screw behind the cylinder.

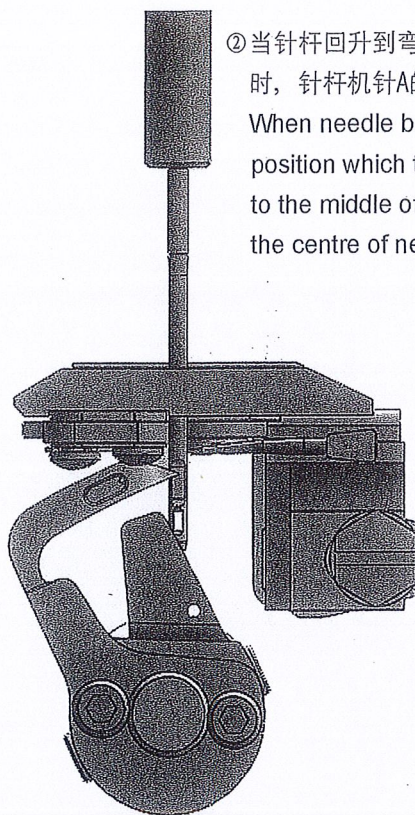
链式辘脚车针杆、弯针、拨叉标准调整

Chainstitch Hemming Machine: standard adjustment for needle bar、looper、spreader

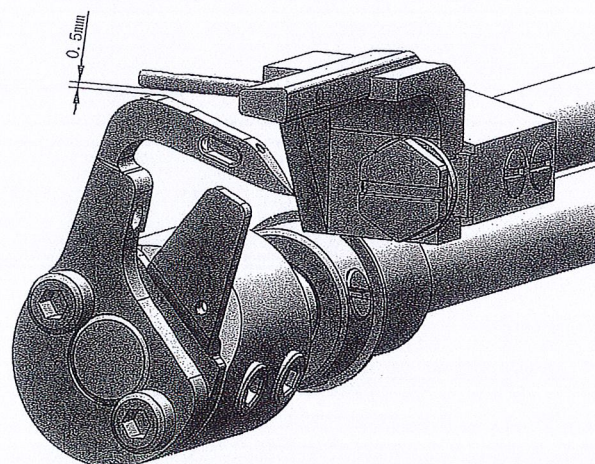
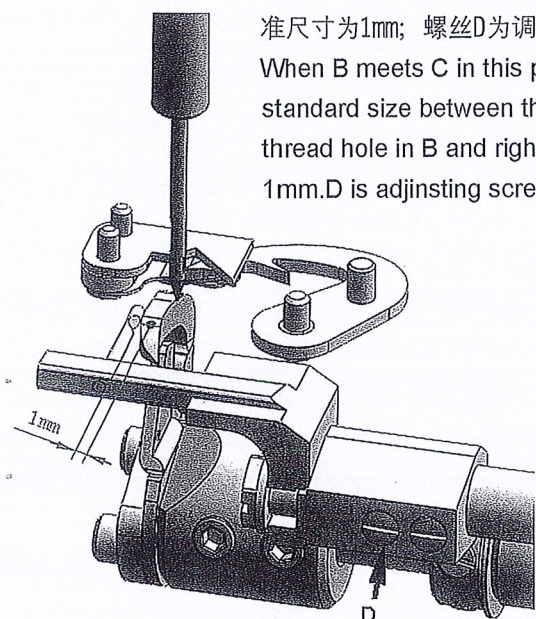
- ① 机针A下降最低时，弯针B退至最后，弯针B与机针A中心标准尺寸为3.5mm，机针A中线与拨叉C标准尺寸为1.5mm。
When needle A down to the lowest position, the looper B back to the end, the standard size between B and the middle of A is 3.5mm, the standard size between the middle of A and C is 1.5mm.



- ② 当针杆回升到弯针B的钩尖与机针A中线时，针杆机针A的高度为机针平面中心。
When needle bar rise again to the position which the point of B reaches to the middle of A, the height of A as the centre of needle plane.



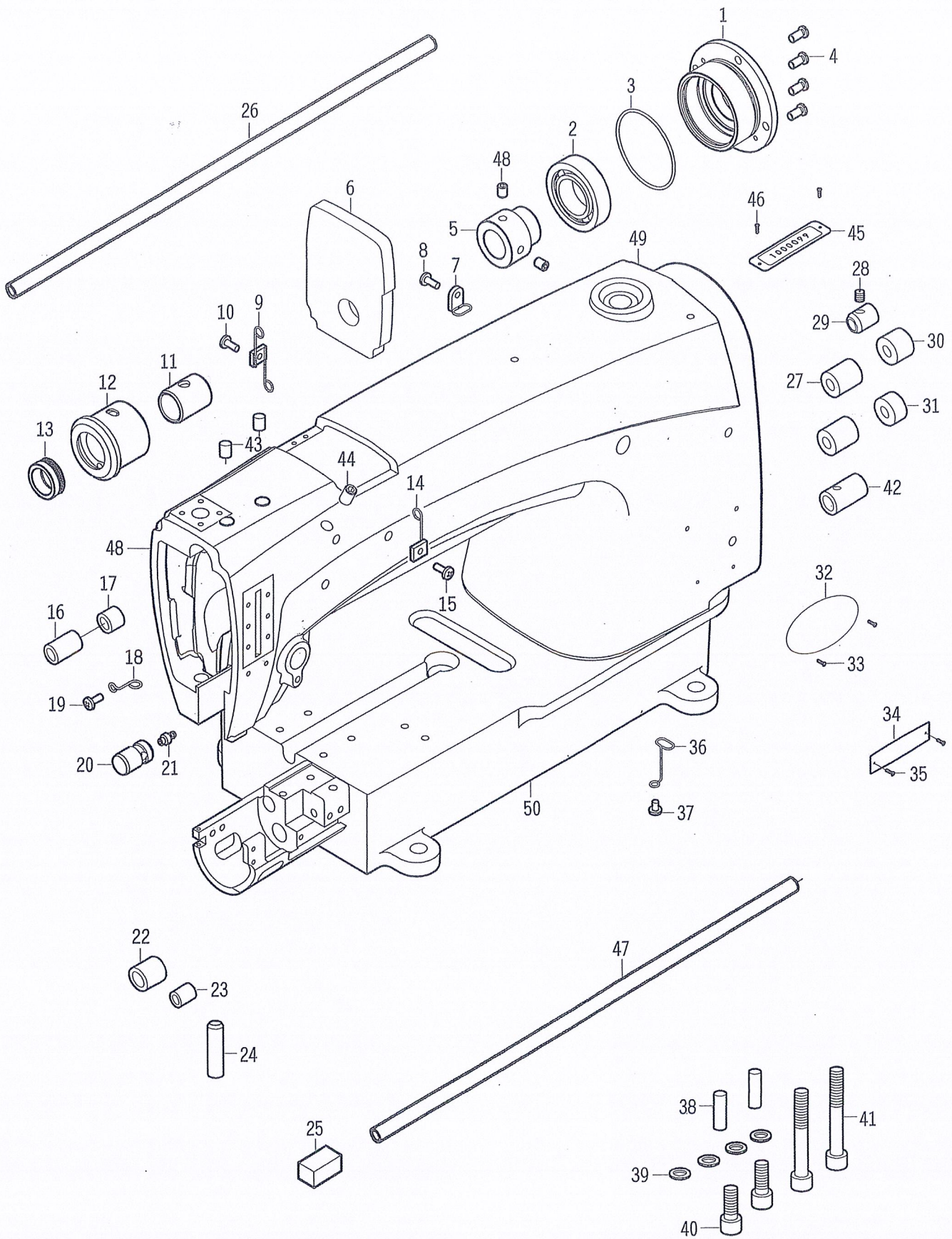
- ③ 当弯针B与拨叉C运动交叉在此位置时，弯针B出线孔中心与拨叉C右边圆边线标准尺寸为1mm；螺丝D为调整螺丝。
When B meets C in this position, the standard size between the centre of thread hole in B and right side of C is 1mm. D is adjusting screw.



- ④ 当弯针B与拨叉C运动交叉在此位置时，弯针B顶部最高点与拨叉C的最低点标准尺寸为0.5mm。
When B meets C in this position, the standard size between the top of B and the lowest of C is 0.5mm.

机头部件及润滑件

MAINFRAME AND MISCELLANEOUS OILING PARTS

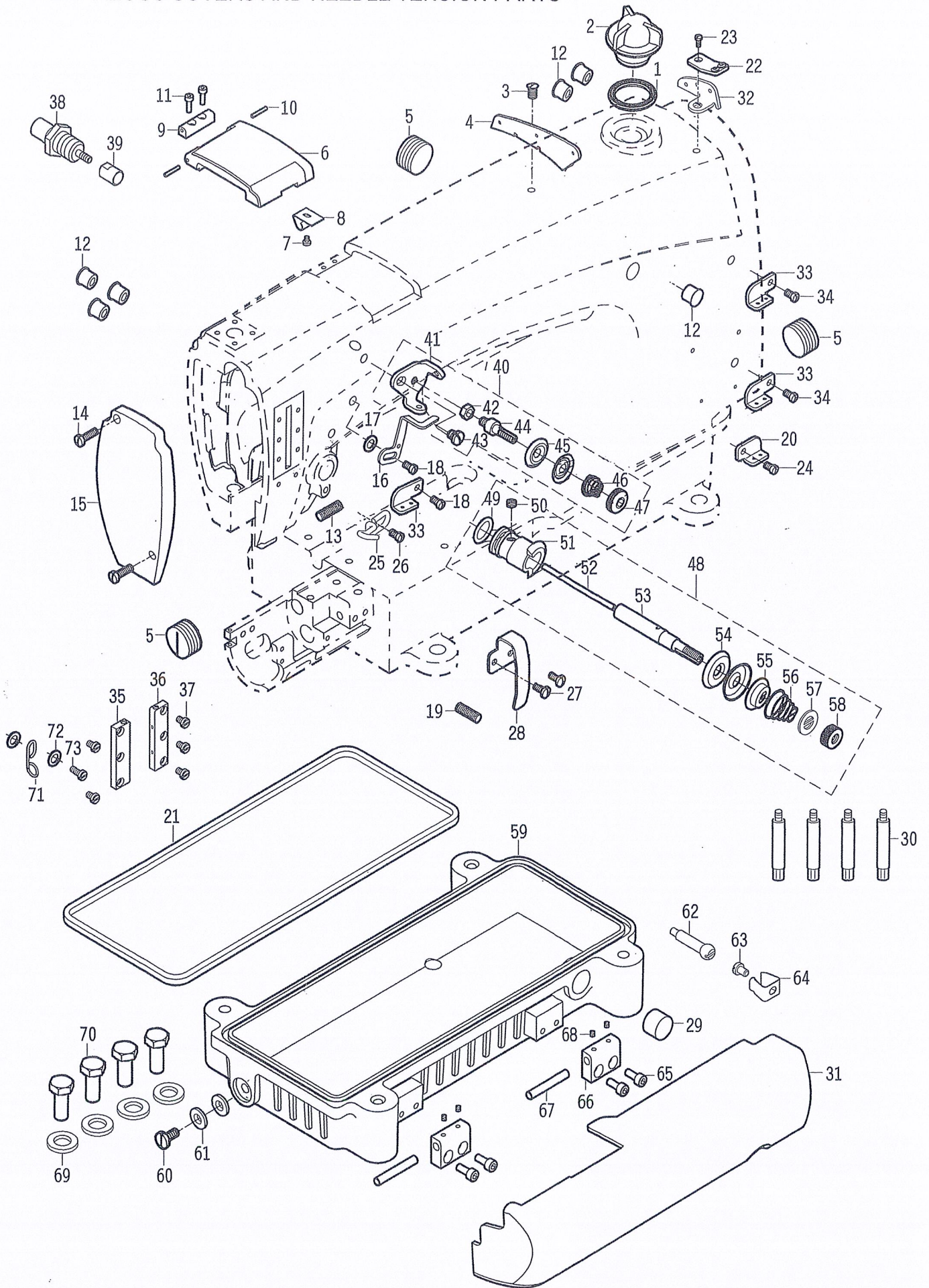


机头部件及润滑件.MAINFRAME AND MISCELLANEOUS OILING PARTS

序号	图号	零部件名称	NAME OF PARTS	数量
1	9A-1A	轴承座	Main Shaft Bushing Housing, including bushing	1
2	9A-2B	轴承	Ball Bearing	1
3	17A-44-2	O形密封圈	"O" Ring	1
4	9A-4A	螺钉	Screw	4
5	9A-1A-1	连接套	Bushing	1
6	9A-6B	油毡	Felt Baffle	1
7	9C-5B-13	管夹4合件	Cannulation Clip 4	1
8	C-50	螺钉	Screw	1
9	9C-5B-11	管夹2合件	Cannulation Clip 2	1
10	A-30	螺钉	Screw	1
11	9-3A-28-3	上轴前轴套	Upper Main Shaft Bushing	1
12	9-3A-28-2	上轴前轴承座	Upper shaft front bearing block	1
13	9-3A-28-1	甩油环	Oil throwing ring	1
14	9C-5B-12	管夹3合件	Cannulation Clip 3	1
15	A-30	螺钉	Screw	1
16	9A-20	针杆摆轴左轴套	Needle Bar Frame Rocker Shaft Bushing, left	1
17	9A-19a	针杆摆轴右轴套	Needle Bar Frame Rocker Shaft Bushing, right	1
18	9-3C-53	油管夹	Cannulation Clip	1
19	A-30	螺钉	Screw	1
20	9C-5B-15	过油塞	Oil plug	1
21	9C-5A-9	油管接头	Vitta Tie-in	1
22	9A-57a	弯针驱动轴左轴套	Looper Drive Shaft Bushing, left	1
23	9A-56a	弯针轴右轴套	Looper Shaft Bushing, right	1
24	9A-26	压紧杆轴套	Presser Bar Bushing, lower	1
25	9A-23	油毡	Felt Baffle	1
26	9C-5B-1	油管	Oil Siphon Priming Cup	1
27	9A-35b	齿轮轴左轴套	Reduction Gear Shaft Bushing, left	1
28	9A-41	油毡	Felt Baffle	1
29	9A-42	中间齿轮轴轴套	Middle Reduction Gear Stud Bushing	1
30	9A-43b	上齿轮轴右轴套	Upper Reduction Gear Shaft Bushing, right	1
31	9A-44b	下齿轮轴右轴套	Lower Reduction Gear Shaft Bushing, right	1
32	9A-75	铭牌	Lable	1
33	3A-22A	铆钉	Rivet	2
34	9A-67	铭牌	Lable	1
35	2A-14-14	铆钉	Rivet	2
36	9C-5B-10	管夹1合件	Cannulation Clip 1	1
37	7C-42	螺钉	Screw	1
38	9A-66	定位销	Pin	2
39	9A-65	垫圈	Washer	4
40	8A-34b	螺钉	Screw	2
41	9A-63	螺钉	Screw	2
42	9A-49a	弯针驱动轴右轴套	Looper Drive Shaft Bushing, right	1
43	9A-18	油毡	Felt Baffle	1
44	9A-16a	螺钉	Screw	1
45	9A-70	编号牌	Serial number	1
46	2A-14-14	铆钉	Rivet	2
47	9C-5B-1	油管	Oil Siphon Priming Cup	1
48	A-31	螺钉	Screw	2
49	9-3A-57CTR	机壳	Mainframe	1
50	9-3A-58CTR	底板	Bed	1

罩盖及夹线部件

MISCELLANEOUS COVERS AND NEEDLE TENSION PARTS



罩盖及夹线部件 . MISCELLANEOUS COVERS AND NEEDLE TENSION PARTS

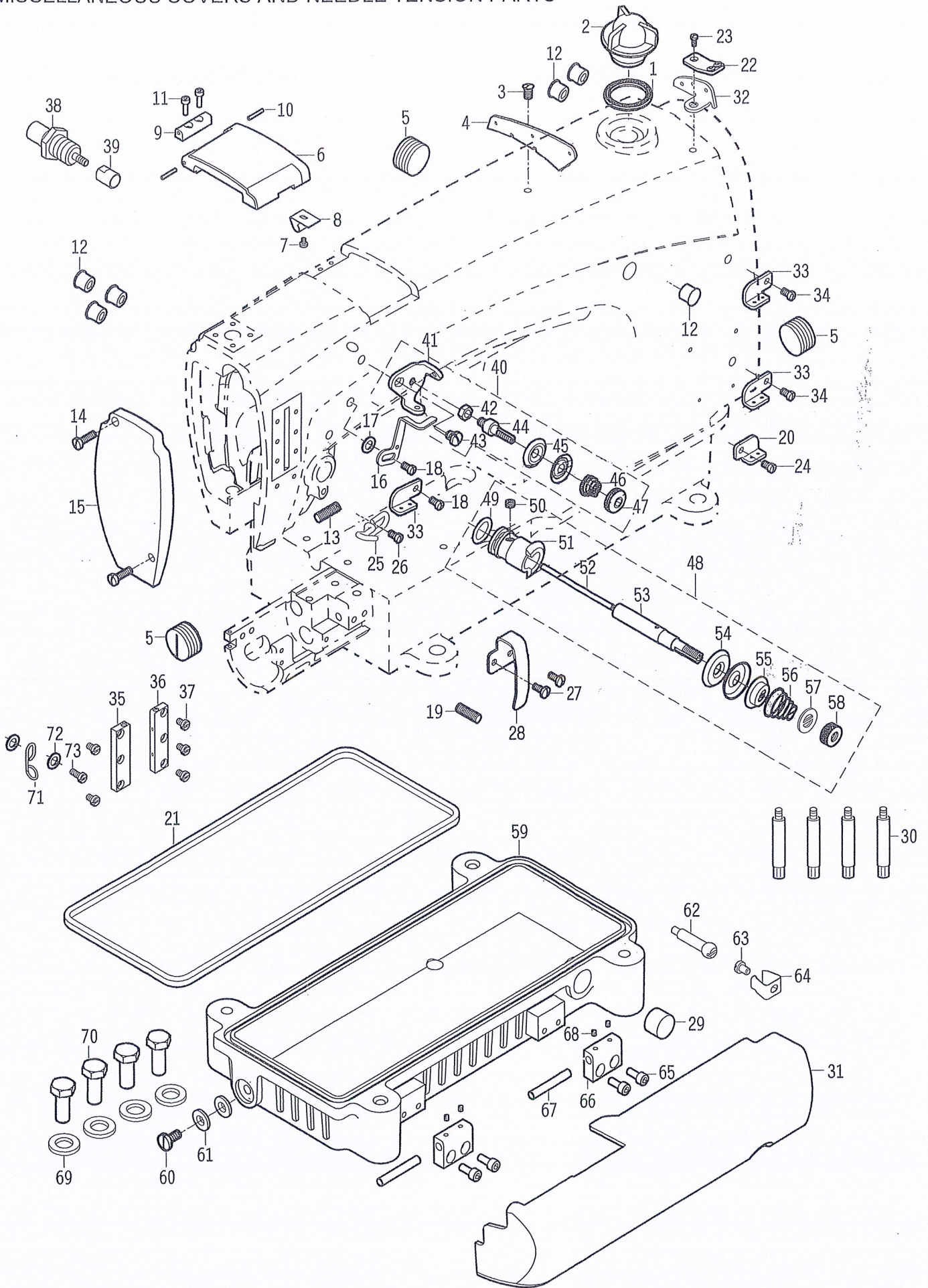
序号	图号	零部件名称	NAME OF PARTS	数量
1	9B-1A	油封垫圈	Gasket	1
2	9B-2A	油镜	Oil Lens	1
3	7 II B-46	螺钉	Screw	1
4	9B-4a	过线板	Frame Thread Eyelet	1
5	9B-5a	螺塞	Plug Screw	4
6	9B-6A	顶盖	Top Cover	1
7	9B-7a	螺钉	Screw	1
8	9B-8A	锁片	Spring Clip	1
9	9B-9A	上盖固定座	Top Cover Hinge	1
10	9B-10A	顶盖铰链销	Top Cover Hinge Pin	2
11	JGA-88	螺钉	Set Screw	2
12	9B-12a	胶塞	Plug, plastic	6
13	9B-25B	螺钉	Screw	1
14	C-50	夹紧螺钉	Pinch Screw	2
15	9B-15	面盖	Head Cover	1
16	9B-17	拦线钩	Thread Pull-up Bracket	1
17	C-71-4	垫圈	Washer	1
18	7B-34	螺钉	Screw	2
19	7E-24	紧定螺钉	Set Screw	1
20	9-3B-20	过线板	Thread Guide Plate	1
21	9B-57	密封垫	Gasket	1
22	9-3B-22	过线板	Thread Guide Plate	1
23	A-30	螺钉	Screw	1
24	7C-42	螺钉	Screw	1
25	9B-22	导线板	Thread Guide Plate	1
26	7C-42	螺钉	Screw	1
27	7C-42	螺钉	Screw	2
28	9-3B-28	挑线杆护罩	Take-up Lever Shield	1
29	9-3B-40	油镜	Oil Lens	1
30	9B-76	右支柱	Right a Mainstay	4
31	9-3B-41	侧盖	Tension Holder	1
32	9B-30	过线板	Thread Guide Plate	1
33	9-3B-33	过线板	Thread Guide Plate	3
34	7C-42	螺钉	Screw	2
35	9-3B-35	挑线杆导块L	Take-up Lever Guide Piece L	1
36	9-3B-36	挑线杆导块R	Take-up Lever Guide Piece R	1
37	7C-6	螺钉	Screw	5

38~73请见下页

38.thru 73.See following page.

罩盖及夹线部件

MISCELLANEOUS COVERS AND NEEDLE TENSION PARTS

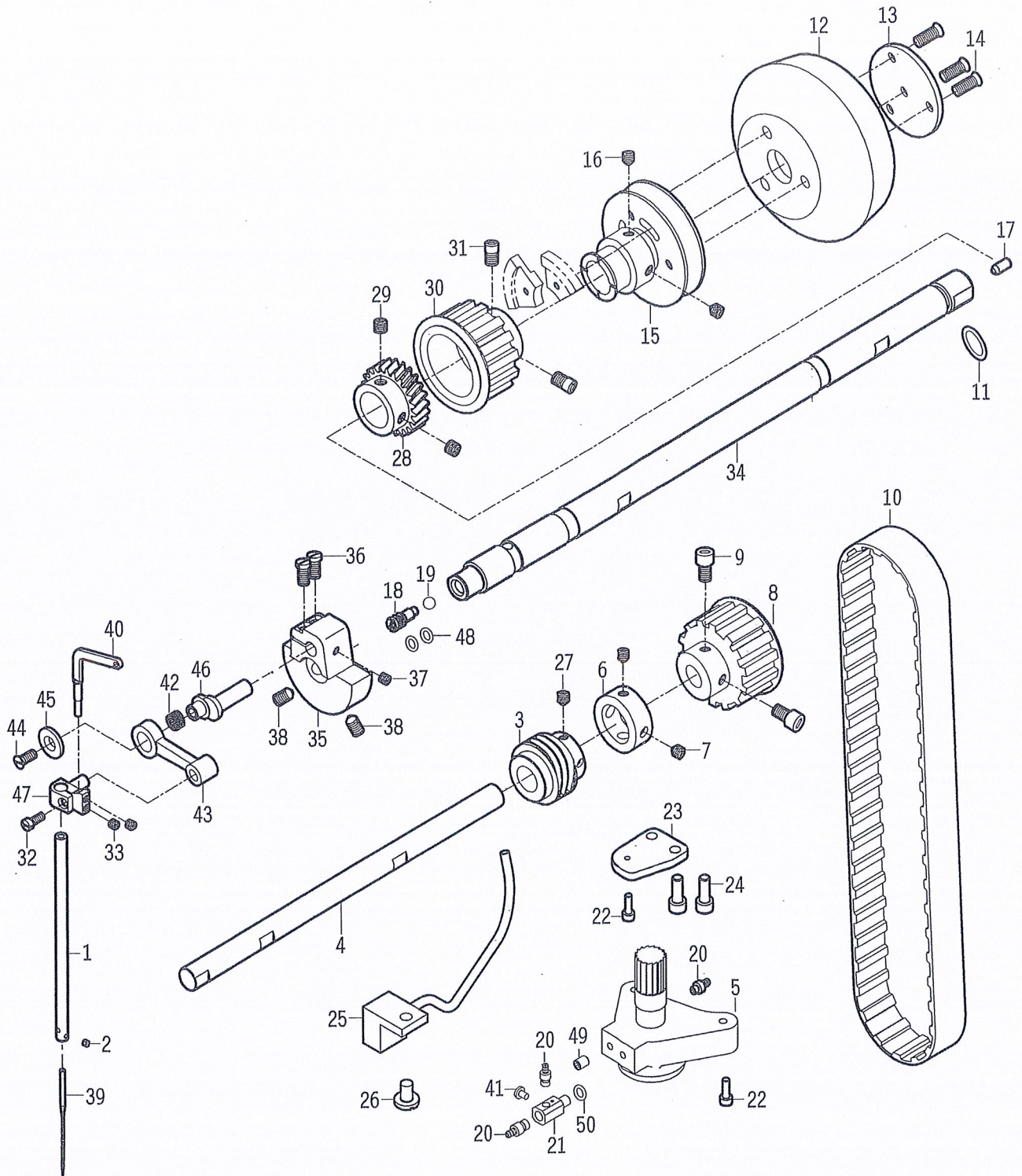


罩盖及夹线部件 (续) . MISCELLANEOUS COVERS AND NEEDLE TENSION PARTS (CONT)

序号	图号	零部件名称	NAME OF PARTS	数量
1~37请见上页				
1.thru 37. See preceding page.				
38	9-3B-38	气缸 LQJ-10x5-M	Cylinder LQJ-10x5-M	1
39	9-3B-39	撞击套	Bump sheath	1
40	9B-30	过线组件	Frame Thread Eyelet	1
41	9-4J-33	夹线座	Tension Holder	1
42	3F-14	螺母	Nut	1
43	7A-4	螺钉	Screw	1
44	9-3B-43	绕线器夹线螺杆	Tension Bolt	1
45	9-3B-45	夹线板	Tension Plate	2
46	9-4J-51	夹线簧	Tension Spring	1
47	9-3B-44	绕线器螺母	Tension Nut	1
48	9B-36	夹线组件	Thread Tension	1
49	9B-37a	密封O形圈	Quad Ring	1
50	9B-39	螺钉	Screw	1
51	9B-38a	夹线座	Tension Post Socket	1
52	9B-40a	松线销	Tension Release Washer	1
53	9B-41	夹线螺杆	Tension Post	1
54	9B-43	夹线板	Tension Plate	2
55	9B-44	松线垫圈	Quad Washer	1
56	10D-28	夹线簧	Tension Spring	1
57	9B-72	防转垫片	Ring	1
58	9B-46a	夹线螺母	Tension Nut	1
59	9B-55D	储油底盘	Oil Reservoir Bottom Cover	4
60	3G-5	螺塞	Screw	1
61	9B-73	密封垫圈	Quad Ring	2
62	9-3B-47	螺钉	Screw	1
63	A-30	螺钉	Screw	1
64	10B-39	卡簧	Face Plate Lock Spring Plate	1
65	7B-23	螺钉	Screw	4
66	9-3B-42	侧盖固定座	Side cover setting base	2
67	9-3B-46	固定轴	Setting shaft	2
68	B-40	螺钉	Screw	4
69	9-3B-51	垫圈	Washer	4
70	9-3B-50	螺钉	Screw	4
71	9-3B-52B	拦线钩	Thread Pull-up Bracket	1
72	9F-30	垫圈	Washer	2
73	9-3B-53	螺钉	Screw	1

传动轴. 针杆及压脚提升机构

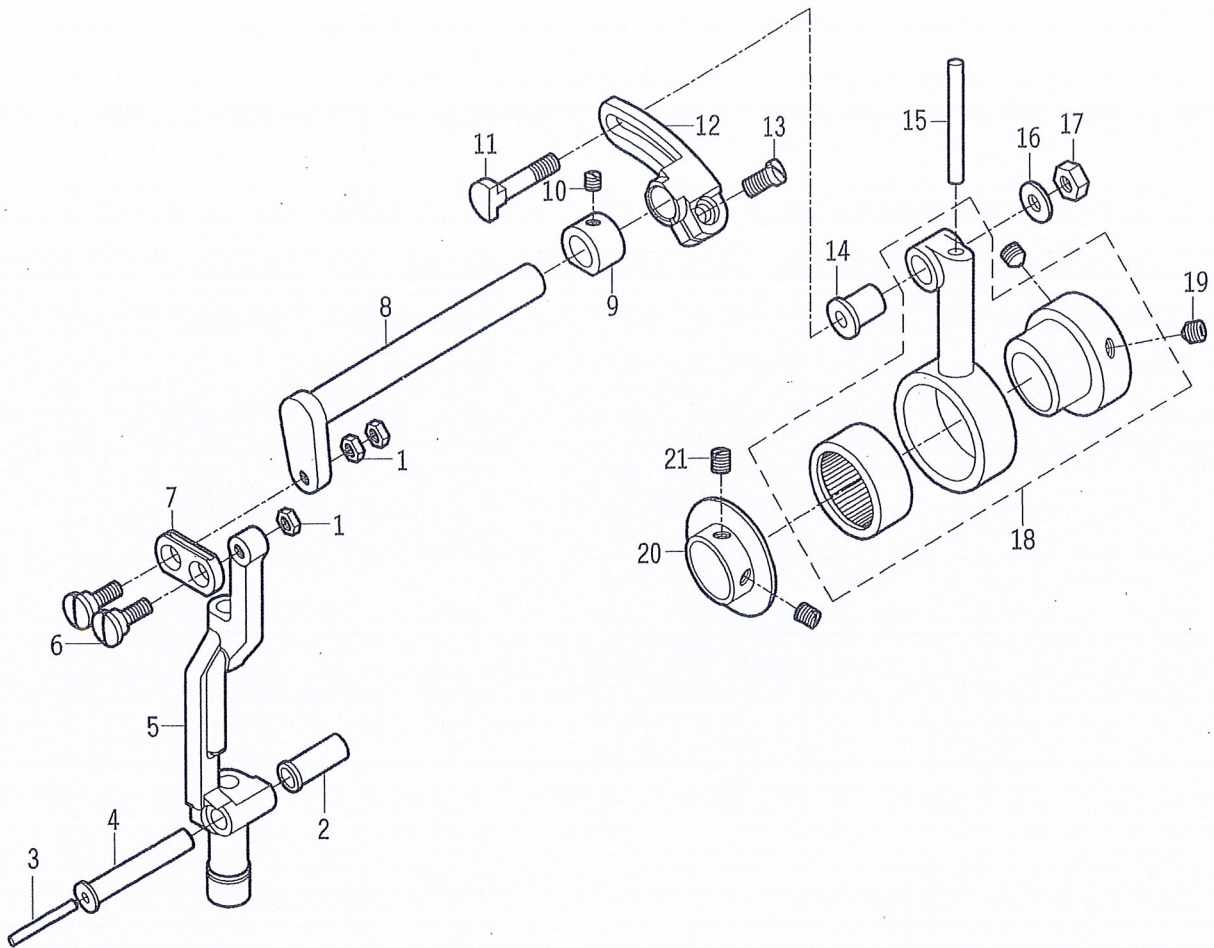
DRIVE SHAFTS .NEEDLE BAR .FOOT LIFTER MECHANISM



传动轴.针杆及压脚提升机构.DRIVE SHAFTS.NEEDLE BAR.FOOT LIFTER MECHANISM

序号	图号	零部件名称	NAME OF PARTS	数量
1	9C-1C	针杆	Needle Bar	1
2	9C-1C-1	螺钉	Screw	1
3	9C-5A-7	蜗杆	Worm	1
4	9-3C-4	传动轴	Driving Shaft	1
5	9C-5B-4	回油泵组件	Oil Return Pump	1
6	3G-6	轴环	Shaft Collar	1
7	8B-20	紧定螺钉	Set Screw	2
8	9C-8	下同步带轮	Driving Shaft Sprocket	1
9	9C-9a	螺钉	Screw M6×10	2
10	9C-10	同步带	Feed Driving Belt	1
11	9C-11a	密封O形圈	Quad Ring	1
12	9C-12a	手轮	Handwheel	1
13	9C-13	皮带轮压片	Hub Washer	1
14	9C-14	皮带轮压片螺钉	Screw	3
15	9-4I-22	定针皮带轮	Pulley	1
16	A-58	紧定螺钉	Set Screw	2
17	9C-61B	塞头	plug	1
18	9C-59	上轴针阀调节轴	Needle value adjusting shaft	1
19	14A-49a	钢球	Presser Bar Spring Arm Ball Bearing	1
20	9C-5-9	油管接头	Vitta Tie-in	3
21	9C-5A-1	三通接头	Triplexer connector	1
22	JGA-107	螺钉	Screw	2
23	9C-5B-6	油泵支承板	Oil pump bearing plate	1
24	A-48	螺钉	Screw	2
25	9C-5A-18-1A	分油架组件	Oil guide bracket complete	1
26	9E-2	螺钉	Screw	1
27	C-22-3	紧定螺钉	Set Screw	1
28	9C-28	主轴传动齿轮	Main Shaft Reduction Drive Gear	1
29	9C-29	紧定螺钉	Set Screw	2
30	9C-30	上同步带轮	Main Shaft Driving Sprocket	1
31	13C-48	紧定螺钉	Looper Set Screw	2
32	9C-51a	螺钉	Screw	1
33	9-3C-54	螺钉	Screw	2
34	9C-34C	主轴	Main Shaft	1
35	9C-35a	挑线凸轮	Counterweight	1
36	9C-36	螺钉	Screw	2
37	9E-13	紧定螺钉	Set Screw	1
38	B-17	紧定螺钉	Set Screw	2
39	13A-33	机针 DVx57	Needle DV×57	1
40	9-3C-40	挑线杆	Take-Up Lever	1
41	13A-19-8	螺钉	Screw	1
42	9C-42	滚针	Needle Bearing	1
43	9C-43	针杆连杆	Needle Bar Link	1
44	9C-44	螺钉	Screw	1
45	9C-45	止推垫圈	Thrust Washer	1
46	9-3C-46	挑线杆偏心轴	Take-Up Lever Crank Pin	1
47	9-3C-47	针杆接头	Needle Bar Connection	1
48	9A-51	密封O形圈	Quad Ring	2
49	A-31	螺钉	Screw	1
50	9-4J-29-2	密封O形圈	Quad Ring	1

针送料操纵部件
NEEDLE FEED DRIVING PARTS

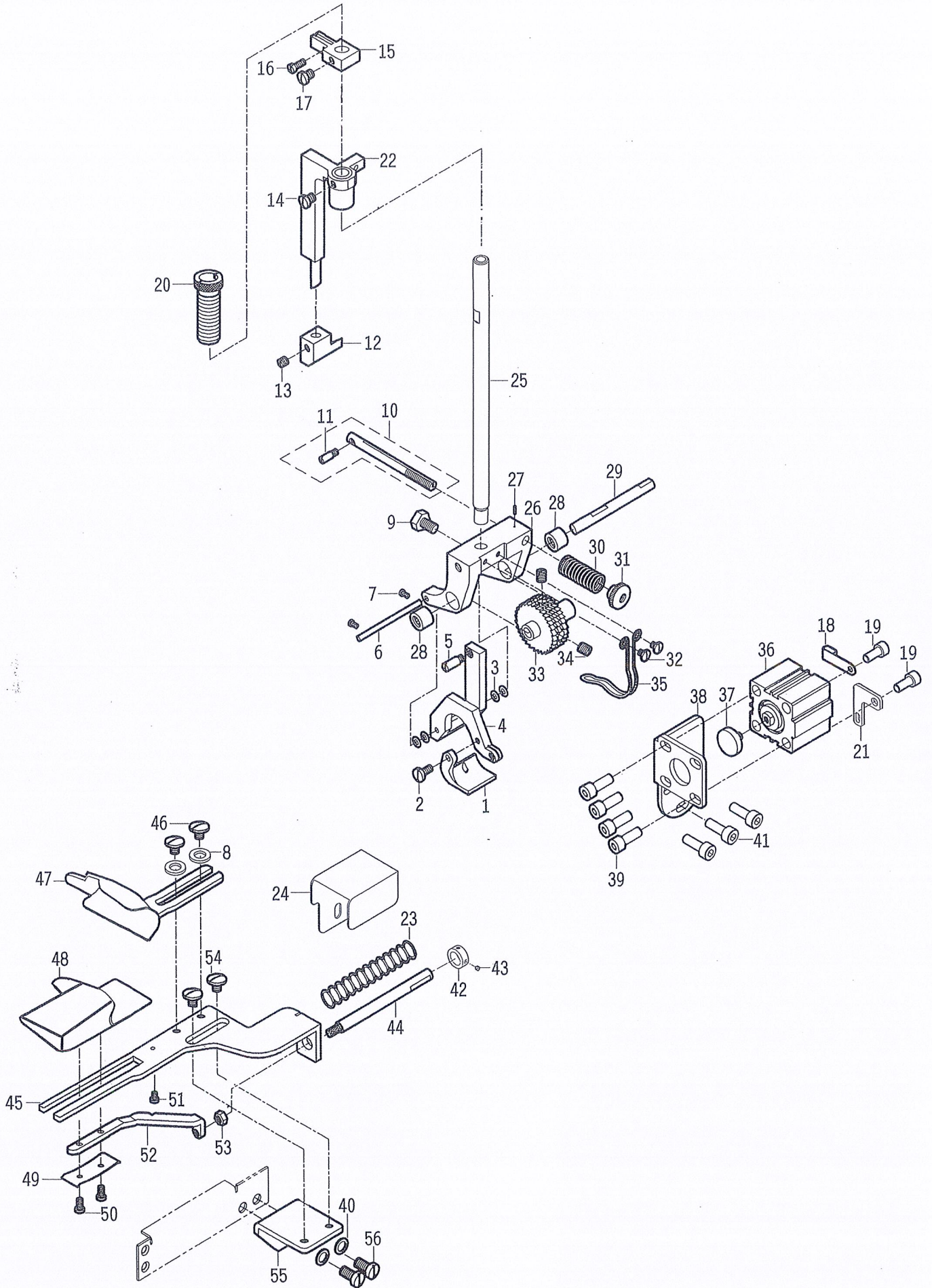


针送料操纵部件.NEEDLE FEED DRIVING PARTS

序号	图号	零部件名称	NAME OF PARTS	数量
1	9D-22	螺母	Nut	3
2	9D-2a	针杆架调整套	Needle Bar Frame Pivot Adjustable Bushing	1
3	9D-3	油绳	Oil Wick	1
4	9D-4	针杆架支轴	Needle Bar Frame Pivot Stud	1
5	9-3D-5A	针杆支架	Needle Bar Frame	1
6	9D-6	销轴螺钉	Hinge Screw	1
7	9D-7	连接板	Needle Bar Frame Rock Shaft Connecting Link	1
8	9D-8	摆针轴	Needle Bar Frame Rock Shaft	1
9	9D-9	挡圈	Collar	1
10	9E-13	紧定螺钉	Set Screw	1
11	9D-11	连接螺栓	Connecting Stud	1
12	9D-12	摆针轴传动杆	Needle Bar Frame Rock Shaft Driving Lever	1
13	9C-36	螺钉	Screw	1
14	9D-14	轴套	Bushing	1
15	9D-15	油绳	Oil Wick	1
16	9D-16	垫圈	Washer	1
17	9D-17	螺母	Nut	1
18	9D-18a	连杆组件	Needle Feed Drive Eccentric and Connecting Rod Assembly	1
19	A-58	紧定螺钉	Set Screw	2
20	9D-20	滚针轴承止动圈	Needle Bearing Retaining Collar	1
21	9D-21	紧定螺钉	Set Screw	2

压脚及上送料轮机构

PRESSER FEET AND TOP FEED ROLLER MECHANISM

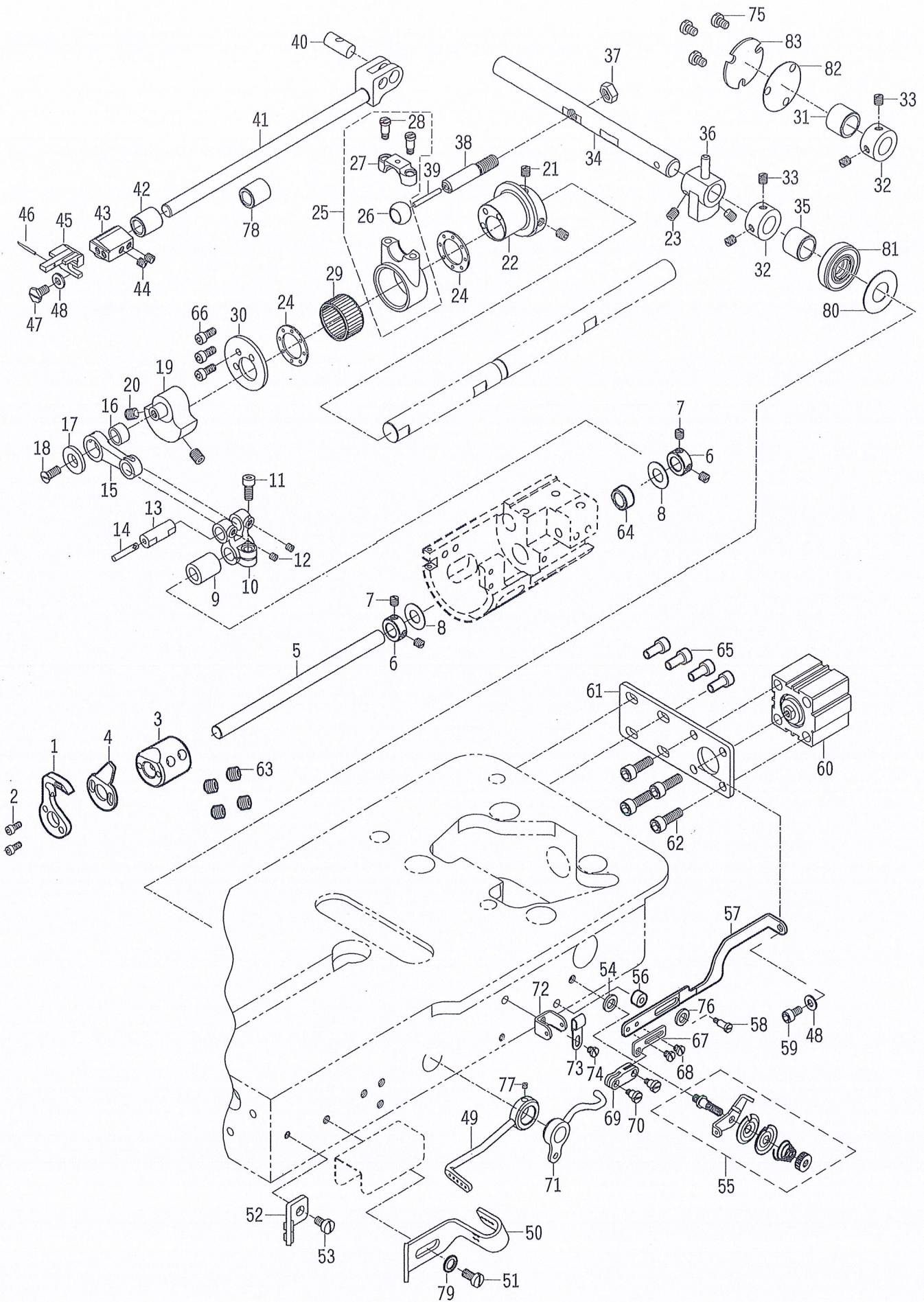


压脚及上送料轮机构.PRESSER FEET AND TOP FEED ROLLER MECHANISM

序号	图号	零部件名称	NAME OF PARTS	数量
1	9E-50Ab	压脚 1/2"	Presser Foot, for 1/2 inch hem	1
2	9E-2	螺钉	Screw	1
3	9E-3	垫圈	Washer	4
4	9E-4	压脚板支架	Presser Foot Shank	1
5	9E-5	螺钉销	Screw Pin	1
6	9E-6	铰链销	Presser Foot Shank Hinge Pin	1
7	9E-7a	螺钉	Screw	2
8	C-51	垫圈	Washer	2
9	9E-9	螺钉	Screw	1
10	9E-10	夹线螺杆合件	Presser Foot Tension Bar	1
11	9E-11	螺钉销	Screw Pin	1
12	9E-12	压脚提升滑块	Presser Foot Lifter Block	1
13	9E-13	紧定螺钉	Set Screw	1
14	8B-3	螺钉	Screw	1
15	9E-15a	压杆导架	Presser Bar Guide	1
16	2D-19	螺钉	Screw	1
17	9E-17	螺钉	Screw	1
18	9-3J-60B	气管支架	Pipe Fixation	1
19	JGA-107	螺钉	Screw	2
20	9-4J-71	压簧调节套	Presser Spring Regulator and Bushing	1
21	9-3J-66B	过线板	Frame Thread Eyelet	1
22	9E-22	提升杆合件	Presser Bar Connection	1
23	9E-66B	销	Roll Pin	1
24	9-3J-61A	防护罩	Safety Guard	1
25	9-4J-70	压杆	Presser Bar	1
26	9E-26a	上送料轮支架	Top Roller Bracket	1
27	9E-27	销	Pin	1
28	9E-28	滚针轴承	Needle Bearing	2
29	9E-29	上送料轮支轴	Top Feed Roller Shaft	1
30	9E-30	夹线调节弹簧	Presser Foot Tension Regulating Spring	1
31	9E-31	调节螺母	Presser Foot Tension Regulating Nut	1
32	9E-32a	螺钉	Screw	2
33	9E-33	上送料轮	Top feed Roller	1
34	9D-21	紧定螺钉	Set Screw	2
35	9E-35	上送料轮卸料器	Upper Roller Stripper	1
36	9-4I-1	气缸 CQ2A16-15D	Cylinder CQ2A16-15D	1
37	9-4I-4	防震胶螺钉	Rubber Screw	1
38	9-3E-38A	气缸支承架	Cylinder Support bracket	1
39	JGA-107	螺钉	Screw	4
40	8B-24	垫圈	Washer	2
41	7A-4	螺钉	Screw	3
42	9E-54	挡圈	Collar	1
43	9E-55	螺钉	Screw	1
44	9E-56B	卷边器操纵杆	Hemmer Operating Rod	1
45	9E-57B	卷边器底板	Hemmer Base	1
46	7C-42	螺钉	Screw	4
47	9-3E-59B	右卷筒	Hemmer Scroll, right	1
48	9E-60B	左卷筒	Hemmer Scroll, left	1
49	9E-61	卷筒滑动板簧	Hemmer Scroll Slide Spring	1
50	2C-15	螺钉	Screw	2
51	8F-10	螺钉	Stop Screw	1
52	9E-64B	卷筒导向板	Hemmer Scroll Slide	1
53	3F-14	螺母	Nut	1
54	9E-58	螺钉	Screw	2
55	9-3E-55B	卷边器支架	Hemmer Mounting Bracket	1
56	9-3E-56	螺钉	Screw	2

弯针及松线部件

LOOPER AND TENSION RELEASE PARTS



弯针及松线部件 .LOOPER AND TENSION RELEASE PARTS

序号	图号	零部件名称	NAME OF PARTS	数量
1	9-3F-1B	弯针	Looper	1
2	JGA-88	螺钉	Screw	2
3	9-3F-3A	弯针夹	Looper Holder	1
4	9-3F-1-2A	护针片	Needle Guard	1
5	9-3F-5A	弯针轴	Looper Carrier Shaft	1
6	9F-21	挡圈	Thrust Collar	2
7	9E-13	紧定螺钉	Set Screw	4
8	9C-48	垫圈	Washer	2
9	9A-56a	弯针轴右轴套	Looper Carrier Shaft Bushing, right	1
10	9-3F-10	弯针曲柄	Looper Crank	1
11	12P-3	螺钉	Screw	1
12	C-68	紧定螺钉	Set Screw	2
13	9-3F-13	铰链销	Hinge Pin	1
14	13B-6	油绳	Oil Packing (wick)	1
15	9-3F-15	弯针连杆	Looper Connecting link	1
16	9-3F-16	轴套	Bushing	1
17	9C-45	止推垫圈	Thrust Washer	1
18	9C-44	螺钉	Screw	1
19	9-3F-19	凸轮	Cam	1
20	12B-32	紧定螺钉	Set Screw	1
21	C-22-3	紧定螺钉	Set Screw	2
22	9-3F-22	叉针偏心轮	Spreader Driving Eccentric	1
23	C-22-3	紧定螺钉	Set Screw	2
24	9-3F-24	止推垫圈	Thrust Washer	2
25	9-3F-25	叉针连杆组件	Spreader Driving Connection	1
26	13D-30	球体	Ball Roller	1
27	9-3F-27	叉针连杆盖	Spreader Driving Connection Cap	1
28	13D-32	螺钉	Screw	2
29	9-3F-29	滚针轴承	Needle Bearing	1
30	9-3F-30	止推挡圈	Throat Plate	1
31	9-3F-31	轴套	Bushing	1
32	8D-28	挡圈	Collar	2
33	8D-29	紧定螺钉	Set Screw	4
34	9-3F-34	叉针轴	Spreader Driving Rock Shaft	1
35	9-3F-31A	轴套	Bushing	1
36	9-3F-36	叉针曲柄	Spreader Driving Crank	1
37	2D-15	螺母	Nut	1
38	9-3F-38	叉针轴螺栓	Spreader Driving Rock Shaft Stud	1
39	13D-13	油绳	Oil Packing (wick)	1
40	13D-1	叉针销	Spreader Driving Pin	1
41	9-3F-41	叉针杆	Spreader Bar	1
42	9-3F-42	叉针杆轴套	Spreader Bar Bushing	1
43	13D-5	叉针夹	Spreader Holder	1
44	3C-14	紧定螺钉	Set Screw	2
45	9-3J-45	叉针	Spreader	1
46	9-3J-46	叉针尖	Spreader Point	1
47	13D-8	叉针螺钉	Spreader Screw	1
48	C-51	垫圈	Washer	2
49	9-3F-49	弯针挑线杆组件	Looper Thread take-up Rod Component	1
50	9-3F-50	弯针导线板	Looper Thread Guide	1

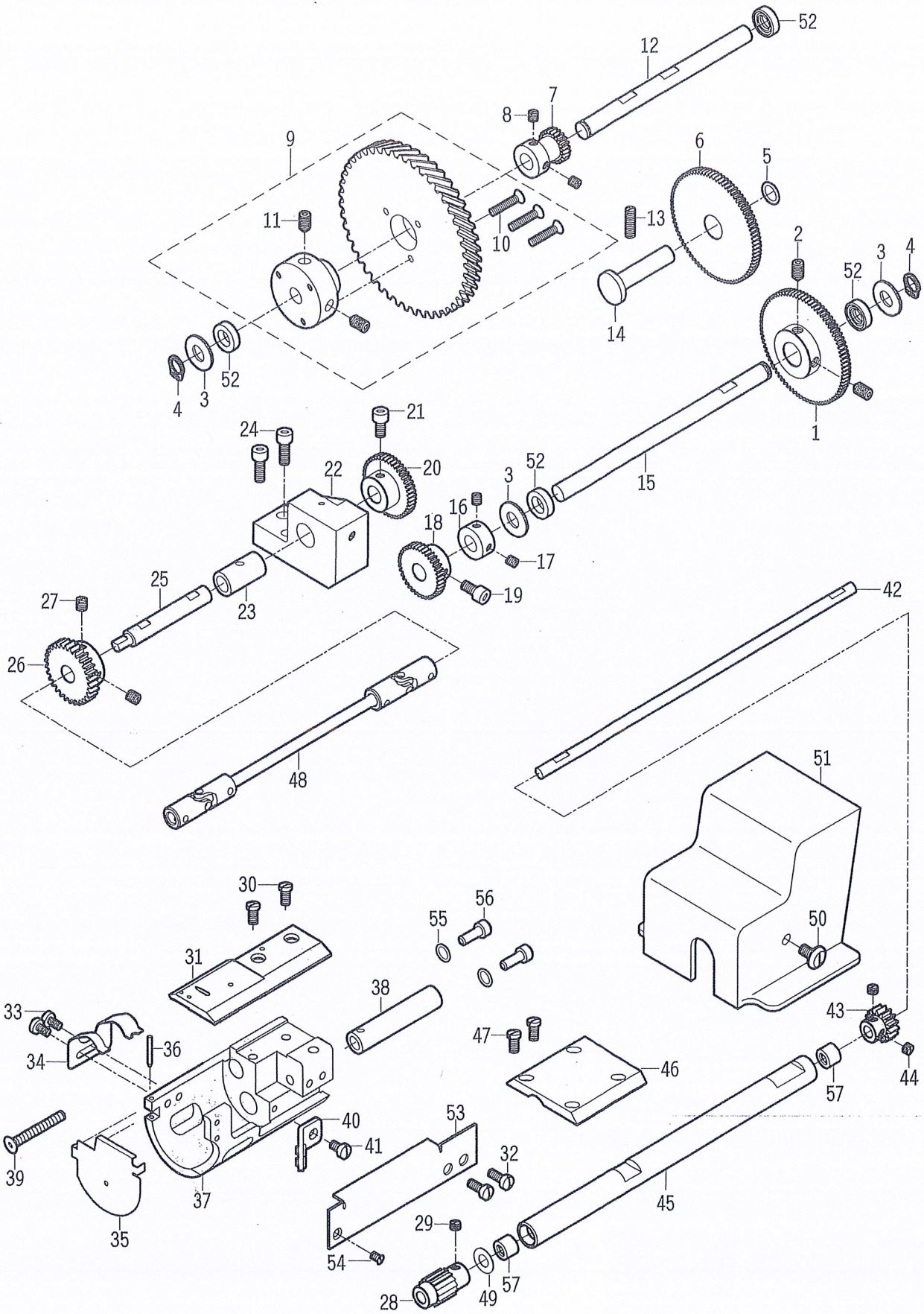
51-85请见下页

51.thru 85.See following page.

弯针及松线部件 (续) . LOOPER AND TENSION RELEASE PARTS (CONT)

序号	图号	零部件名称	NAME OF PARTS	数量
1~50请见上页				
1.thru 50. See preceding page.				
51	13C-23	螺钉	Screw	1
52	9-3B-22	过线板组件	Thread Guide Plate complete	1
53	7C-42	螺钉	Screw	1
54	8B-24	垫圈	Washer	2
55	13E-56	弯针夹线器组件	Looper Thread Tension complete	1
56	9-3J-56A	松线支板	Tension Releasing Support Plate	1
57	9-3J-57A	松线插板	Tension Releasing Plate	1
58	10A-9	螺钉	Screw	1
59	JGA-107	螺钉	Screw	1
60	9-3F-60	松线气缸 CQ2A16-10D	Tension Releasing Cylinder CQ2A16-10D	1
61	9-3F-61	气缸支承板	Cylinder Support Plate	1
62	JGA-107	螺钉	Screw	4
63	13D-18	螺钉	Screw	4
64	9-3M-7	隔圈	Collar	1
65	7F-2	螺钉	Screw	4
66	9-3F-66	螺钉	Screw	3
67	9-3J-51	调节板	Adjustment Board	1
68	7C-42	螺钉	Screw	2
69	9-3J-50	连接杆	Connecting Link	1
70	9-3J-53	螺钉	Screw	2
71	9-3J-49	挑线杆组件	Take-up Rod Component	1
72	9-3J-52-1	挑线导向板	Guide Bracket	1
73	9-3J-54	气管支架	Cylinder Bracket	1
74	7C-42	螺钉	Screw	1
75	7C-42	螺钉	Screw	3
76	8B-24	垫圈	Washer	1
77	8D-29	螺钉	Screw	2
78	9-3F-78	密封套	Airproof Bushing	1
79	10A-6	垫圈	Washer	1
80	9-3F-35A-1	垫圈	Washer	1
81	9-3F-35A-2	骨架油封	Oil Envelop	1
82	9-3F-35A-3	密封垫片	Washer	1
83	9-3F-35A-4	压板	Press Board	1

送料轮操纵部件
FEED ROLLER DRIVING PARTS

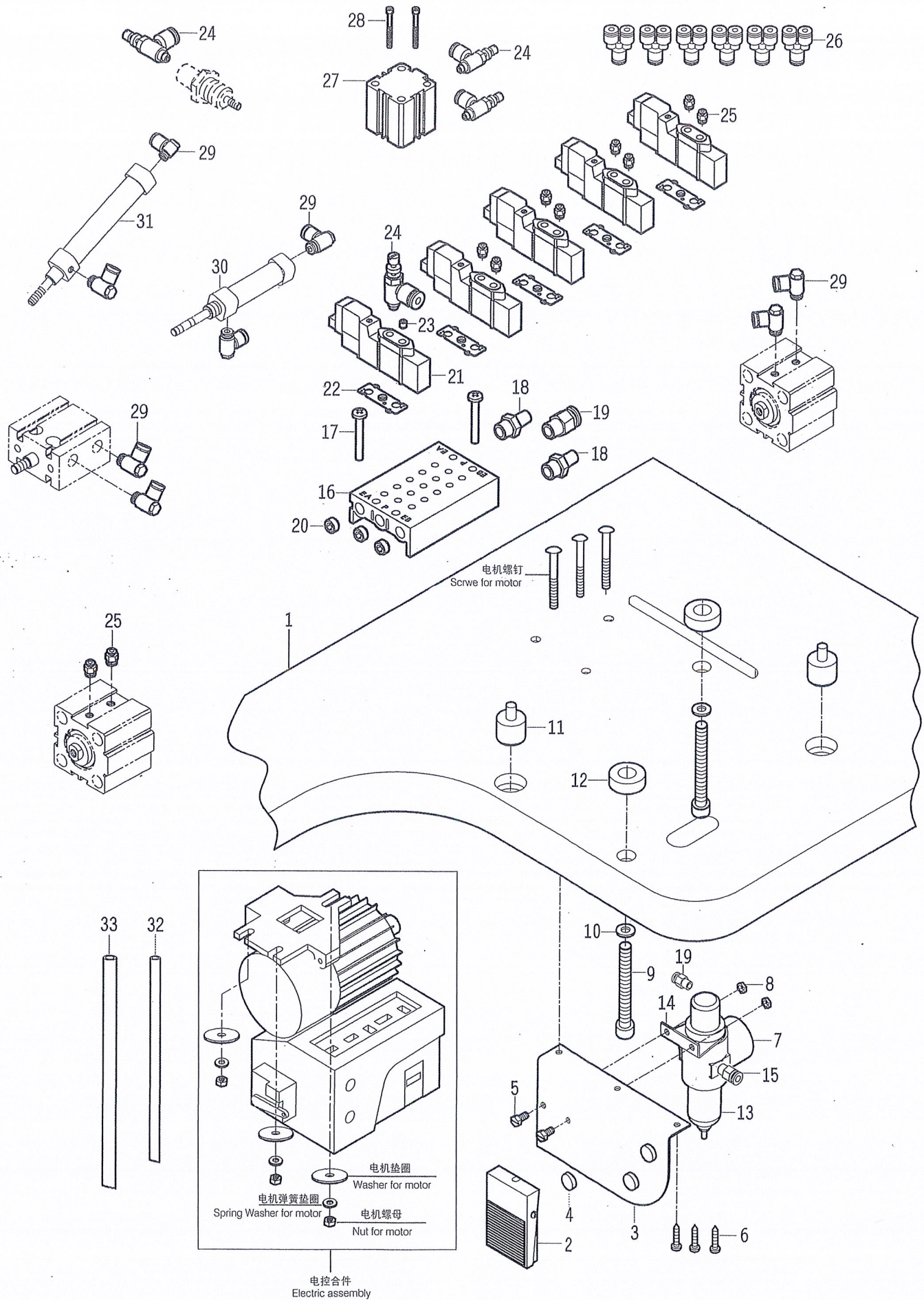


送料轮操纵部件 .FEED ROLLER DRIVING PARTS

序号	图号	零部件名称	NAME OF PARTS	数量
1	9G-1b	下减速齿轮	Lower Reduction Gear	1
2	B-17	紧定螺钉	Set Screw	2
3	9G-3a	垫圈	Washer	3
4	9G-4a	轴用弹性挡圈	Truarc Ring	2
5	9G-5	O形圈	O Ring	1
6	9G-6	中间减速齿轮	Middle Reduction Gear	1
7	9G-7a	上减速驱动齿轮	Upper Reduction Drive Gear	1
8	8D-29	紧定螺钉	Set Screw	2
9	9G-9	齿轮组件	Upper Reduction Driven Gear	1
10	9G-10a	螺钉	Screw	3
11	B-17	紧定螺钉	Set Screw	2
12	9G-12	上减速齿轮轴	Upper Reduction Gear Shaft	1
13	9G-13	紧定螺钉	Set Screw	1
14	9G-14	中间减速齿轮销轴	Middle Reduction Gear Stud	1
15	9G-15	下减速齿轮轴	Lower Reduction Gear Shaft	1
16	9G-16	挡圈	Thrust Collar	1
17	9E-55	螺钉	Screw	2
18	9G-18b	面线调节齿轮	Upper Stitch Regulating Gear	1
19	9G-19a	螺钉	Screw	1
20	9G-20b	底线调节齿轮	Lower Stitch Regulating Gear	1
21	9G-19a	螺钉	Screw	1
22	9G-22a	支承座	Top Feed Roller Drive Shaft Bushing Housing	1
23	9G-23a	轴套	Top Feed Roller Drive Shaft Bushing	1
24	7B-23	螺钉	Screw	2
25	9G-25	上送料轮驱动轴	Top Feed Roller Drive Shaft	1
26	9G-26a	下送料驱动齿轮	Lower Feed Roller Drive Gear	1
27	9D-21	紧定螺钉	Set Screw	2
28	9G-30	下送料轮	Lower Feed Roller	1
29	9G-31	紧定螺钉	Set Screw	1
30	9G-32	螺钉	Screw	2
31	9-3J-1	针板	Throat Plate	1
32	9C-36	螺钉	Screw	2
33	9G-36	螺钉	Screw	2
34	9-3G-34	导布板	Lower Feed Roller Stripper	1
35	9G-38	弯针座护盖	Looper Housing Cover	1
36	9G-39	销	Roll Pin	1
37	9-3G-37A	弯针座	Looper Shaft Bushing Housing	1
38	9G-41a	弯针轴左轴套	Looper Shaft Bushing	1
39	9G-42a	沉头螺钉	Screw	1
40	9-3F-52	过线板	Thread Guide Plate	1
41	13A-19-8	螺钉	Screw	1
42	9G-43	下送料轮驱动轴	Lower Feed Roller Drive Shaft	1
43	9G-44a	下送料被动齿轮	Lower Feed Roller Driven Gear	1
44	9G-31	紧定螺钉	Set Screw	2
45	9-3G-45	下送料驱动轴外套	Lower Feed Drive Shaft Housing	1
46	9G-47	夹紧板	Clamp Plate	1
47	9G-32	螺钉	Screw	2
48	9G-49A	铰链联轴组件	Top Feed Roller Flexible Drive Shaft	1
49	9-3G-49	垫圈	Washer	1
50	9E-69	螺钉	Screw	1
51	9G-52	齿轮盖	Feed Drive Gear Cover	1
52	9G-53	防油圈	Oil Guard	4
53	9-3G-53	盖板	Cover	1
54	9B-21	螺钉	Screw	1
55	10F-32	垫圈	Washer	2
56	C-18	螺钉	Screw	2
57	9E-28	轴承	Bearing	2

电控部件

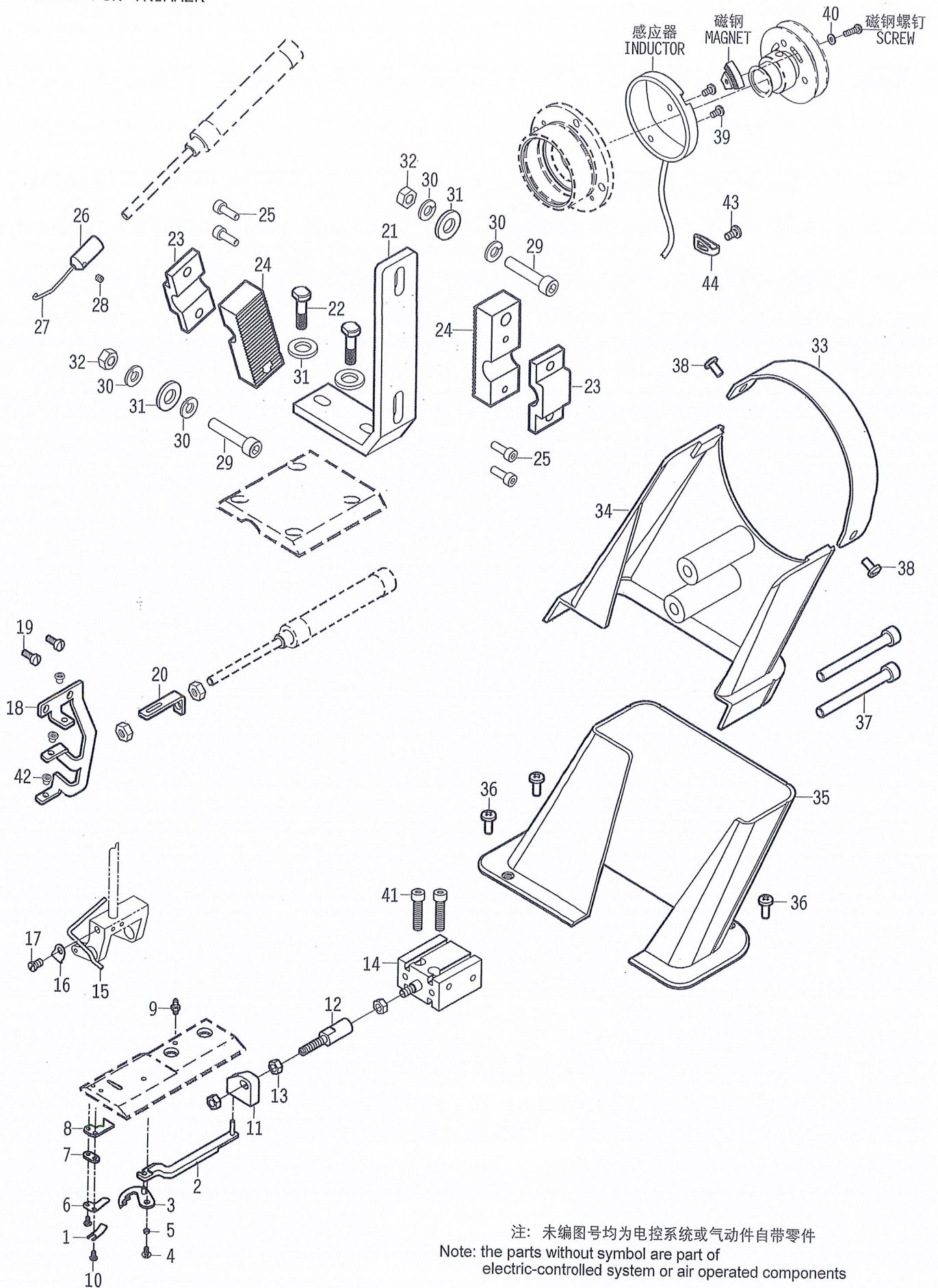
COMPONENT FOR ELECTRIC CONTROLLER



电控部件. COMPONENT FOR ELECTRIC CONTROLLER

序号	图号	零部件名称	NAME OF PARTS	数量
1	63900CTR	63900CTR新型台板	Table	1
2	14-1L-8	膝控开关	Knee-Switch	1
3	9-4I-18	三联件支架	Bracket	1
4	14F-23-1	磁块	Magnet	3
5	7A-57	六角头螺钉	Screw	2
6	2H-10	十字圆头自攻螺钉	Wood Screw	3
7	-	压力表 R1/8DIN2999	Pressure gauge R1/8DIN2999	1
8	7A-26	螺母	Nut	2
9	9H-42	内六角螺栓	Screw	2
10	17K-19	垫圈	Washer	2
11	9H-20	机座垫	Rubbermat For Base	2
12	9H-43	机座垫	Rubbermat For Base	2
13	-	减压阀 AW20-01-A	Air Source Processing Element AW20-01-A	1
14	-	托架 AR22P-270AS	Bracket AR22P-270AS	1
15	-	螺纹直通接头 APC8-01	Joint APC8-01	1
16	-	汇流板 SS5Y3-20-05	Conflux Plate SS5Y3-20-05	1
17	16L-2-8	十字槽圆头螺钉	Screw	2
18	14E-14-9	消声器 BSL-01	Silencer BSL-01	2
19	-	螺纹直通接头 APC6-01	Joint APC6-01	2
20	-	内六角堵头 ABP-01	Plug ABP-01	3
21	-	电磁阀 SY3120-5LOZD-M5	Electromagnetic Valve SY3120-5LOZD-M5	5
22	-	阀板 SY100-30-4A-6	Value plate SY100-30-4A-6	5
23	13D-18	螺钉	Screw	1
24	-	单向节流阀 ASL4-M5	One-way Throttle Valve	4
25	-	螺纹直通接头 APC4-M5C	Joint APC4-M5C	10
26	-	Y型三通接头 APY4	Y-type Joint APY4	6
27	-	气缸 CQ216-Z1T510-13	Cylinder Asm CQ216-Z1T510-13	1
28	9-4J-76	螺钉	Screw	2
29	-	六角肘节接头 APH4-M5	Elbow Joint APH4-M5	8
30	-	气缸 CJ2KB10-40Z	Cylinder CJ2KB10-40Z	1
31	-	气缸 CJ2Z10-Z1T662-40	Cylinder CJ2Z10-Z1T662-40	1
32	-	φ4气管	Tube 4	-
33	-	φ6气管	Tube 6	-

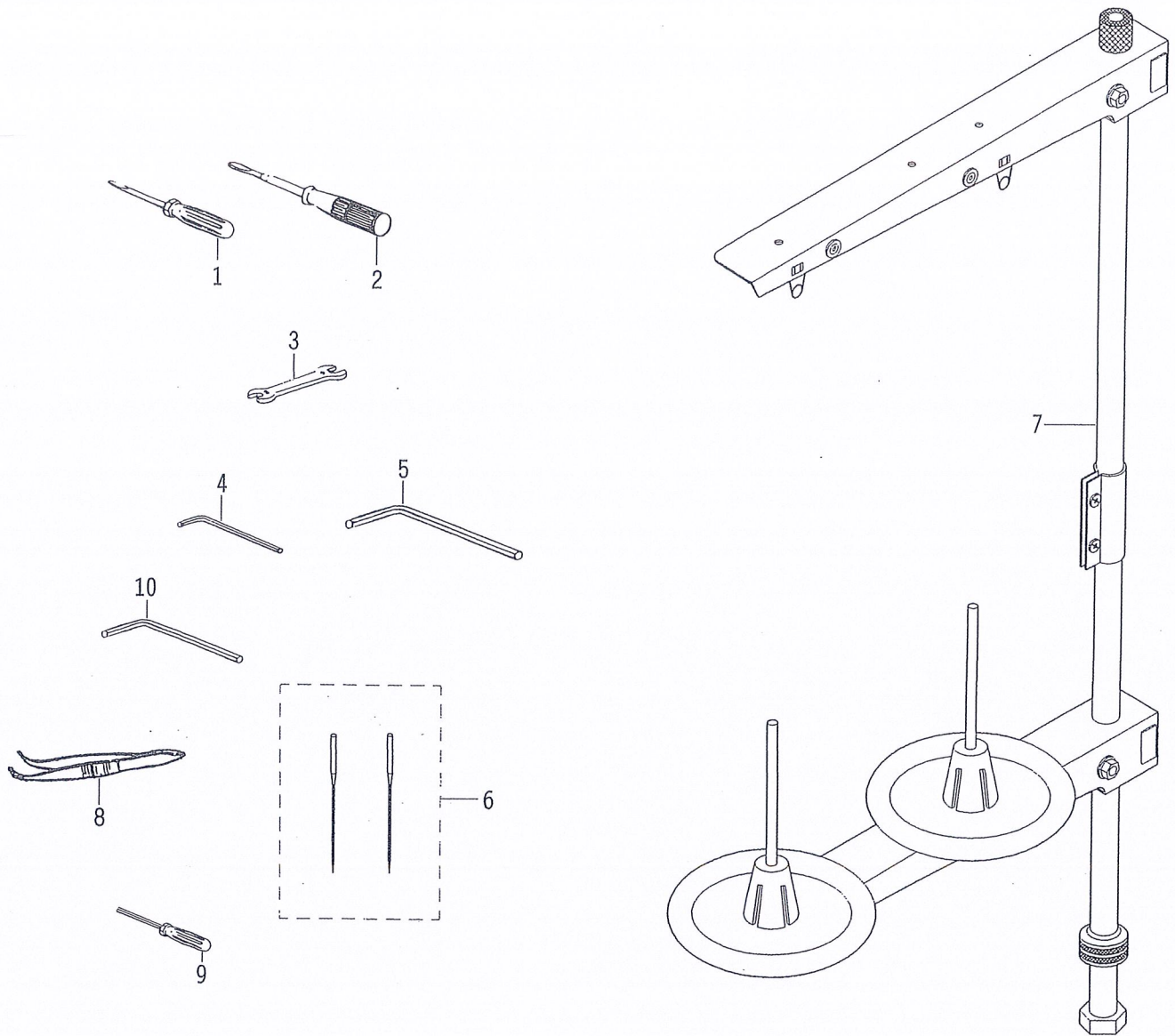
自动剪线部件
COMPONENT FOR TRIMMER



自动剪线部件.COMPONENT FOR TRIMMER

序号	图号	零部件名称	NAME OF PARTS	数量
1	9-3J-6-1	压片	Presser Spring Plate	1
2	9-3J-2	剪线拉杆组件	Thre Ad Trimmer Connecting Rod	1
3	9-3J-3	动刀组件	Movable Knife Assy	1
4	9-4J-4	螺钉	Screw	1
5	9-3J-5	轴套	Sleeve	1
6	9-3J-6	弹簧片	Spring Leaf	1
7	9-3J-7	垫块	Block	1
8	9-3J-8	固定刀	Fixes Knife	1
9	9-4J-9	气嘴	Air Ap	1
10	9-4J-32	螺钉	Screw	2
11	9-4J-11	推动块	Pushing Plate	1
12	9-4J-12	垫块	Block	1
13	7A-26	螺母	Nut	2
14	9-3J-14	剪线气缸 MD20x12-F1	Trimmer Cylinder MD20x12-F1	1
15	9-4J-24	吹针导管	Tube For Blowing Needle	1
16	9-4J-25	铜管夹	Copper Pipe Clamp	1
17	9-4J-26	螺钉	Screw	1
18	9-3M-5	过线架	Thread bracket	1
19	7C-42	螺钉	Screw	2
20	9-3M-6	线量杆	Thread rod	1
21	9-3M-3	支架	Support	1
22	9-3M-4	螺钉	Screw	2
23	9-3M-1-1	固定上座	Fixed bracket up	2
24	9-3M-1-2	固定底座	Fixed bracket down	2
25	JGA-107	螺钉	Screw	4
26	9-3M-2	连接轴	Connecting shaft	1
27	9-4J-18-1	钩线杆	Thread Hooking Rod	1
28	JGA-44	螺钉	Screw	1
29	9-3J-67	螺钉	Screw	2
30	13C-44	弹簧垫圈	Spring Washer	4
31	9-4J-43	垫圈	Washer	4
32	7A-18	螺母	Nut	2
33	9-3J-36B	皮带罩(上)	Belt cover up	1
34	9-3J-37B	皮带罩(中)	Belt cover middle	1
35	9-3J-38B	皮带罩(下)	Belt cover down	1
36	9-4J-40	螺钉	Screw	3
37	9-3J-68	螺钉	Screw	2
38	7C-42	螺钉	Screw	2
39	9-3B-23	螺钉	Screw	2
40	C-71-4	垫圈	Washer	1
41	9-3J-67	螺钉	Screw	2
42	16K-3-3	瓷珠	Thread Guide	3
43	7C-42	螺钉	Screw	1
44	8G-54	电线夹	Fastening Band	1

附件
ACCESSORIES



附件.ACCESSORIES

序号	图号	零部件名称	NAME OF PARTS	数量
1	3H-6	小螺批	Screw Driver (Small)	1
2	3H-7	中螺批	Screw Driver (Medium)	1
3	8H-1	小扳手 6×7	Small Wrench 5×25	1
4	D-6-1	六角匙 2.5	Hexagonal Wrench 2.5	1
5	D-4	六角匙 5	Hexagonal Wrench 5	1
6	13A-33	机针 DV×57	Needle DV×57	2
7	9H-19	线架组件	Thread Stand Assembly	1
8	D-8	镊子	Tweezers	1
9	-	六角匙 1.5	Hexagonal Wrench 1.5	1
10	-	六角匙 4	Hexagonal Wrench 4	1

