

GLOBAL

UP 1515 VF-AUT

**SINGLE NEEDLE, FLATBED, WALKING
FOOT SEWING MACHINE WITH SIDE
KNIFE**

**INSTRUCTION / OPERATING MANUAL
PARTS MANUAL**

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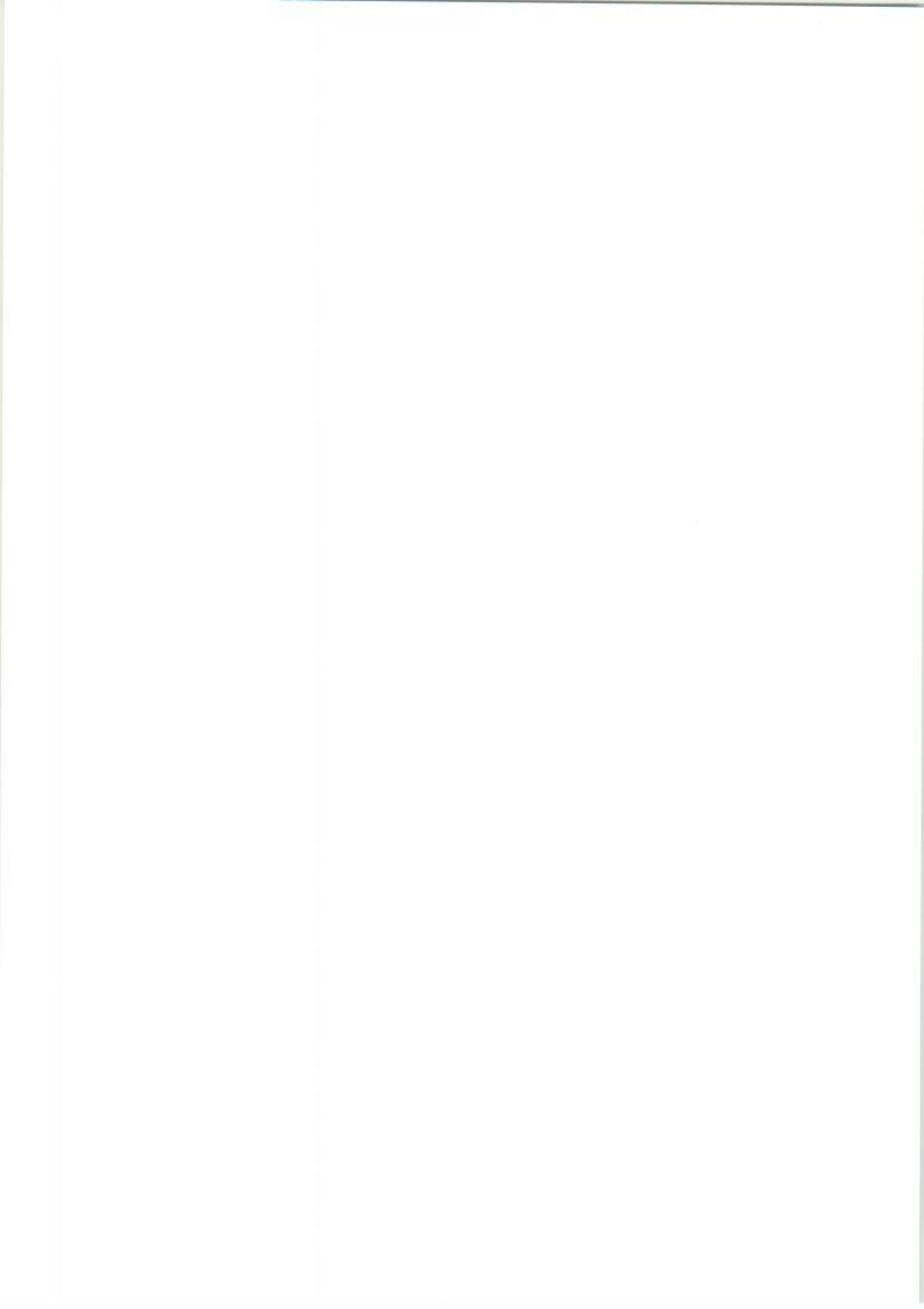
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使用说明 Manual



1. 机器简介

Machine introduction

本机采用三同步送料及独特的送布机构，使其爬坡性能优越，对厚料送布能力强、顺畅、线迹均匀、整齐、美观。采用卧式大旋梭勾线，滑杆机构挑线，上下轴同步带传动，保证了该机高速低噪音的性能。

该产品广泛适用于汽车坐垫、沙发、皮包、帐篷等厚料的缝制。

This machine adopts synchronous feeding and unique fabric feeding mechanism to optimize its climbing performance, and features powerful and smooth thick-fabric feeding, even stitches, tidy and nice-looking. Lines are drawn by horizontal-type hook, taken up by slide bar mechanism and driven by synchronous belts on upper and lower shafts, which has ensured high speed and low noise performance.

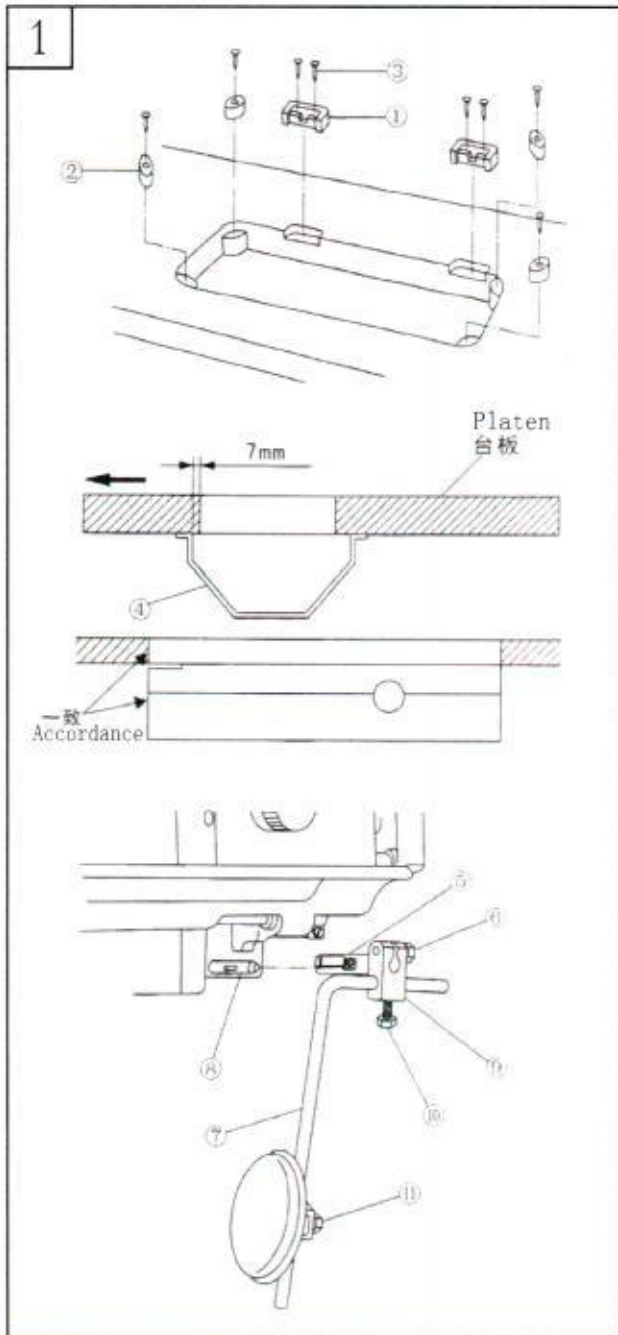
This product is widely applied in sewing thick materials such as automobile cushion, sofa, purse and tent etc.

2. 主要技术规格

Main technical specification

适用范围 Application	厚料 Thick fabric
最高缝纫速度 Maximum sewing speed	2500s. p. m
最大线迹长度 Longest stitch	9mm
针杆行程 Needle bar travel	36mm
采用机针 Needle used	DP×17(Nm125~Nm180)标准Nm180(24#) DP×17(Nm125~Nm180)Standard Nm180(24#)
润滑方式 Ways of lubrication	油线供油(旋梭自动加油) Oiling for oil line (automatic oiling for hook)
采用旋梭 Hook used	立式大型自动润滑旋梭 Automatic large vertical lubrication hook
压脚高度 Height of pressure foot	手动9mm, 膝控16mm Manual control: 9mm, kneel control: 16mm
电动机功率 Power of the motor	370瓦(缝纫机专用电机) 370W (specially for sewing machine motor)

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3. 安装 (见图1)

Installation (See Figure 1)

1. 机壳台板连接钩座, 机壳橡皮垫等的安装
用钉③把附属的连接钩座①, 机壳橡皮垫②固定到台板上。
2. 油盘的安装
用8个木螺钉按图示位置把油盘④固定到台板上。
3. 根据膝控提升杆轴⑧的朝向, 安装膝控接头⑤, 膝控提升安装曲柄⑨, 弯杆⑦。
4. 用固定螺钉⑥⑩⑪调整垫块的方向。

1. Installation of the frame bedplate connection hook block and the frame rubber cushion:

Fix the auxiliary connection hook block① and the frame rubber cushion② on the bedplate with nails③.

2. Fix the oil tray④ on the bedplate with eight screw nails according to the position indicated on the figure.

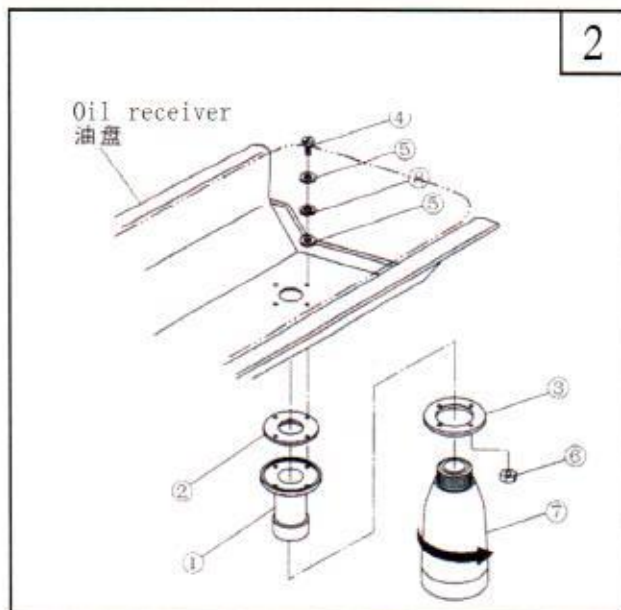
3. Install the kneel-controlled joint⑤, kneel-controlled lifting installation crank⑨ and curved bar⑦ according to the direction of the kneel-controlled lifting bar shaft⑧.

4. Adjust the direction of cushion blocks with fixed screws ⑥ and ⑩ and ⑪.

4. 废油容器的安装 (见图2)

Installation of waste oil container (See Figure 2)

1. 把排油栓①, 油封②, 垫片③安装到油盘上, 再把垫块⑤, 垫片⑧套到固定螺钉④上, 并用螺母⑥固定。
2. 固定之后, 把废油油壶⑦拧到排油转栓①上。
1. Install the oil discharge stopper①, oil seal② and the washer③ on the oil tray. Cover the cushion block⑤ and the washer⑧ on the fixed screw④. Then fix them with nut⑥.
2. Turn the waste oil pot⑦ to the oil discharge stopper① after fixing.



5. 皮带张力的调整 (见图3)

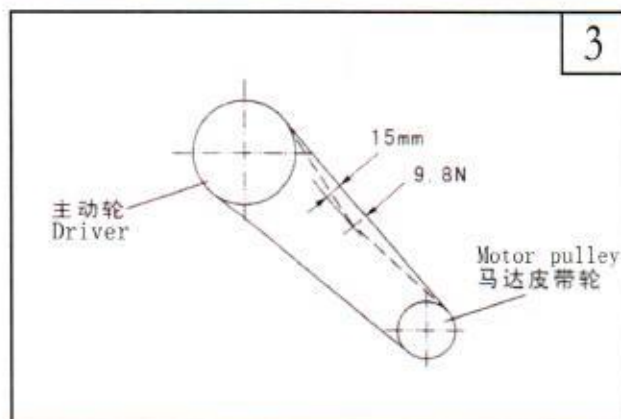
Adjusting the belt tension (See Figure 3)

调整皮带张力时, 请移动马达的高度, 用9.8N的力量按压皮带中间, 此时的松弛量为15mm。

注意: 调整前请先关闭电源, 确认马达停止转动后再进行。

Move the height of the motor when adjusting the belt tension. Press the middle part of the belt with force of 9.8N. The relaxation shall be 15mm at the moment.

Note: Before adjusting, please cut off the power and ensure that the motor has stopped.



6. 皮带罩的安装 (见图4)

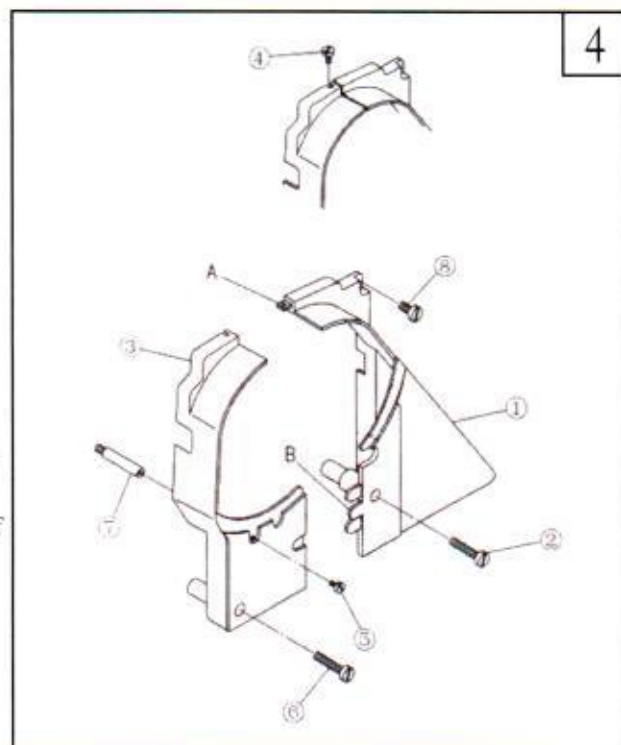
Installation of belt cover (See Figure 4)

1. 把皮带罩支柱⑦拧到机头的螺丝孔上。
2. 用固定螺丝②⑧把皮带罩(右)①安装到机头上。
3. 把皮带罩(左)③镶到皮带罩(右)①的爪部AB上。
4. 用固定螺丝④、⑤、⑥固定好皮带罩(左)③。

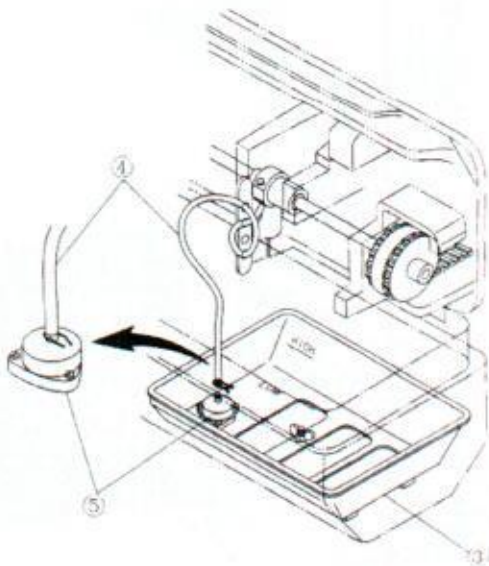
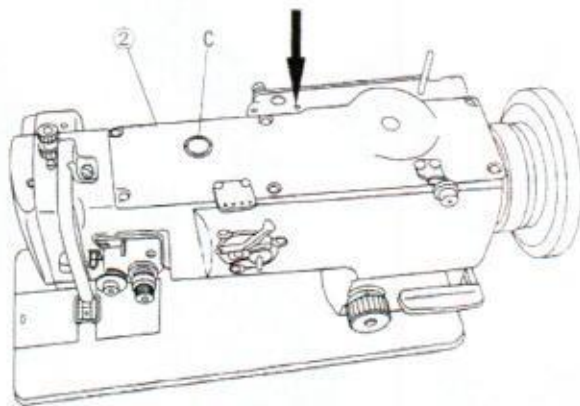
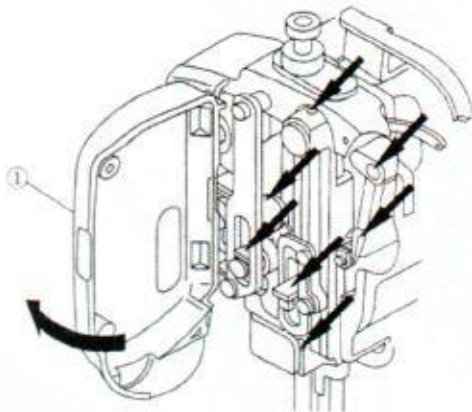
注意: 安装皮带罩后, 确认皮带罩没有碰到皮带和飞轮。

1. Screw the belt cover support⑦ to the bolt hole on the head.
2. Install the belt cover (right)① on the head with fixed screws ② and ⑧.
3. Mount the belt cover (left)③ on the claw AB of belt cover (right)①.
4. Fix the belt cover (left)③ with fixed screws ④, ⑤ and ⑥.

Note: Please confirm that the belt cover doesn't contact with the belt and the flywheel after installing the belt cover.



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7. 加油 (见图5)

Oiling (See Figure 5)

一. 面部加油

1. 拧下面板螺钉;
2. 向箭头方向打开面板①;
3. 每日在箭头指示的部位加适量的油;
4. 关闭面板;
5. 拧紧螺钉。

ONE. Oiling of surface

1. Screw off the panel bolts.
2. Open the panel ① to the direction of arrow.
3. Properly oil the part indicated by the arrow in every day.
4. Close the panel.
5. Tighten the bolts.

二. 机身加油

1. 每天按箭头指示的部位加适量的油;
2. 初次运转前或长时间没有使用时, 请在箭头指示的部位加油外, 另需卸下顶盖②, 向各毛毡和油线加适量的油。

TWO. Machine oiling

1. Add a proper amount of oil to the parts indicated by the arrow in every day.
2. Before the first operation or when the machine has not been in use for a long time, add oil to the parts indicated by the arrow, and dismantle head cover ② to add a proper amount of oil to each felt and oil line.

三. 油槽加油

1. 把油槽③底部的凸部插到接油的废油孔里。
2. 把加油管④插进油槽的滤油器⑤上, 然后用夹子夹紧固定。
3. 往油槽里加入缝纫机油, 加到HIGH的位置。
4. 油面低于LOW时, 就需要加油。
5. 加油后, 运转缝纫机, 正常时可以看到油窗C里的油在上下动。(转速在1500rpm以上)

THREE. Oil slot oiling

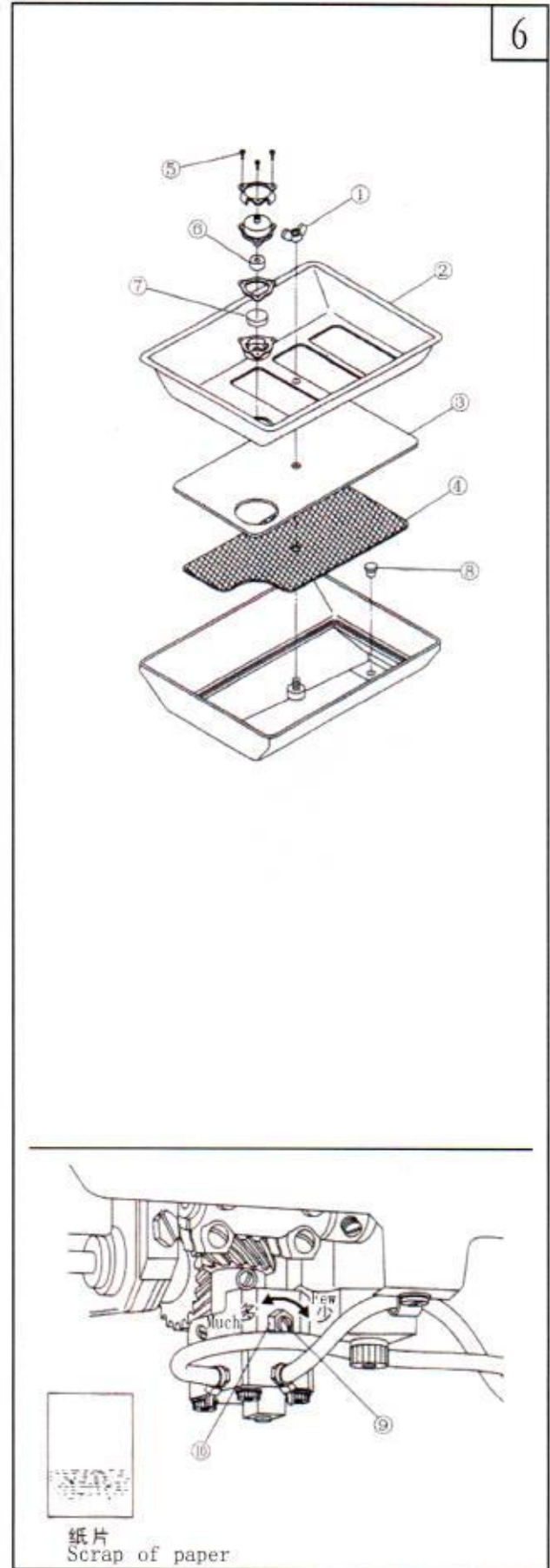
1. Insert the bulge at the bottom of the oil slot ③ into the waste oil hole which is used for receiving oil.
2. Connect the oil pipe ④ with the filter ⑤ of the oil slot. Then fix it with clamp.
3. Add sewing machine oil into the oil slot till the HIGH position.
4. Oil if the level is under LOW.
5. Run the sewing machine after oiling. You can see the oil moving up and down in oil window C in normal condition. (with the revolution more than 1500rpm)

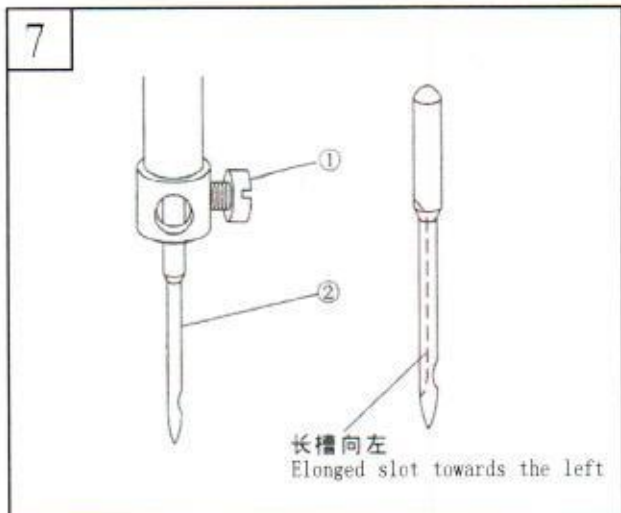
8. 油槽的清扫 (见图6)

Cleaning the oil slot (See Figure 6)

1. 把油槽的加油软管卸下来;
2. 卸下蝶形螺母①, 取下外罩(上)②, 滤清器③, 外罩(下)④进行清扫;
3. 取下滤清器盒固定螺丝⑤, 清扫滤清器盒内的过滤芯⑥和磁铁⑦;
4. 更换油槽内机油时, 把油槽的止流栓⑧卸下就可以把废油排放到废油容器里。排油后, 把止流栓⑧拧紧; (注意: 取出油槽时, 先排放机油后取出)
5. 把过滤芯⑥和磁铁⑦放入滤清器盒用固定螺丝⑤固定到外罩(上)②;
6. 按外罩(下)④, 滤清器③, 外罩(上)②的顺序放进去, 然后用蝶形螺丝①固定到油槽上;
7. 把加油软管插进油槽, 然后用夹固定。

1. Dismantle the oil tube on the oil slot.
2. Remove the butterfly nut ① and take down the cover (upper) ②, filter ③ and cover (lower) ④ to clean.
3. Take down the fixed screw ⑤ of the filter box and clean the filtering core ⑥ and magnet ⑦ inside it.
4. When changing the engine oil inside the oil slot, dismantle the stop bolt ⑧ and then the waste oil can be discharged into the waste oil container. Tighten the stop bolt ⑧ after discharging. (Note: Discharge the engine oil before taking out the oil slot.)
5. Put the filtering core ⑥ and magnet ⑦ into the filter box and fix them with fixed screw ⑤ on the cover (upper) ②.
6. Put with the order of cover (lower) ④, filter ③ and cover (upper) ② and then fix them on the oil slot with butterfly screw ①.
7. Insert the oil tube into the oil slot and fix with clamp.
8. 调节旋梭的油量时, 请拧松螺母⑩, 用油量调节螺丝⑨进行调节, 顺时针转动变少, 逆时针转动变多。
9. 把纸放到旋梭外周附近约 5 秒钟, 如果有了油迹如图那样即为适量。
8. Loosen the nut ⑩ when adjusting the oil quantity of the hook with adjusting screw ⑨. When loosening the nut clockwise, the oil quantity decreases; otherwise, it increases.
9. Put the paper near the periphery of the hook for about five seconds. It is proper for the oil quantity if there is oil stain on the paper as shown in the figure.



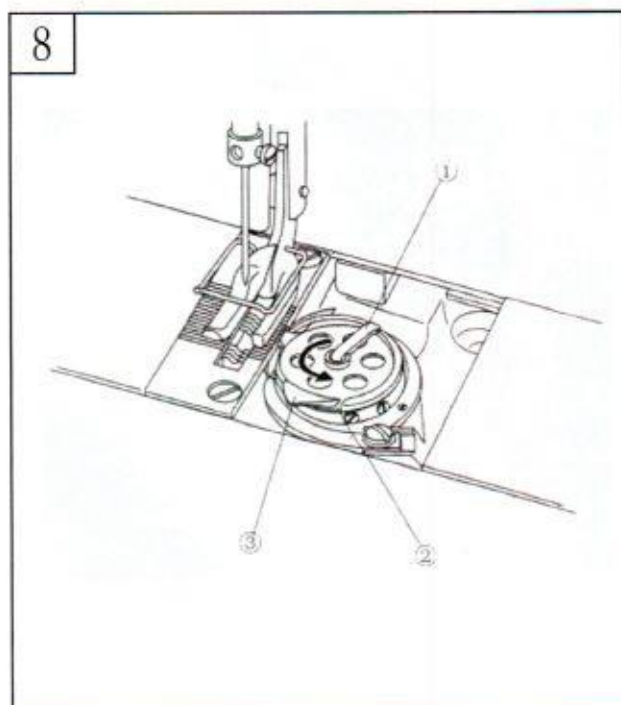


9. 机针的安装 (见图7)

Installation of needle (See Figure 7)

1. 转动主动轮, 把针杆上升到最高位置;
2. 拧松机针固定螺钉②, 让机针①的长槽朝向左侧;
3. 把机针插到最里面;
4. 拧紧机针固定螺钉②。

1. Run the driving wheel and lift the needle bar to the highest position.
2. Loosen the needle fixed bolt② to make the long slot of the needle① face the left.
3. Insert the needle into the innermost part.
4. Tighten the needle fixed bolt②.

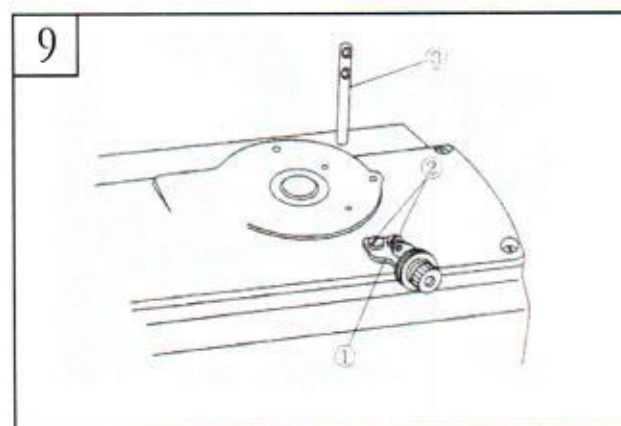


10. 底线的穿线方法 (见图8)

Threading of the bottom thread (See Figure 8)

1. 扳起旋梭的拨片①, 取梭芯;
2. 装入时, 正确地插入旋梭轴, 然后放倒拨片;
3. 把线嵌入旋梭穿线槽②, 再从突起部③的下面穿过去, 然后穿进线张力弹簧;
4. 拉底线之后, 梭芯应沿箭头方向转动。

1. Cock the washer① of the hook and draw the core out.
2. During installation, correctly insert the hook shaft and lay down the washer.
3. Inlay the thread into the threading slot② of the hook. Get past from the underside of the bulge③ and get into the thread tension spring.
4. The hook core shall turn along the arrow after pulling the bottom thread.



11. 绕线导线器的安装 (见图9)

Installation of thread winder guide (See Figure 9)

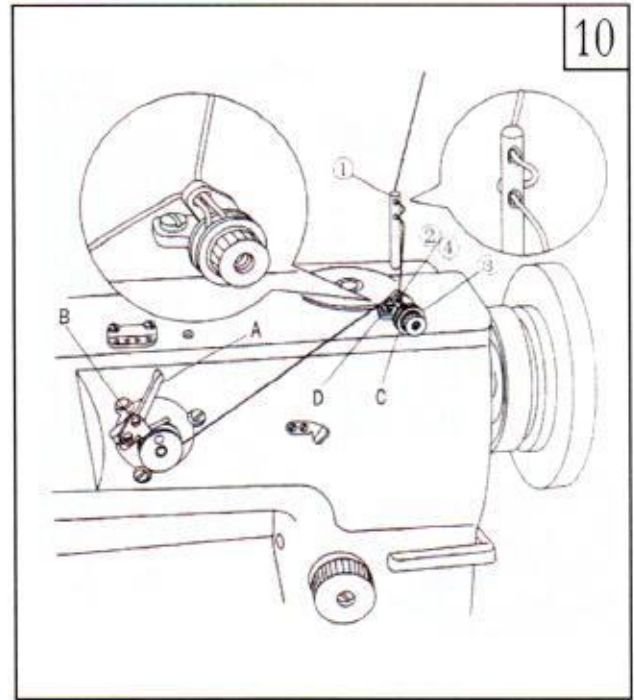
1. 用固定螺钉②把绕线导线器①安装到顶盖上。
2. 把底线导线杆③插到机架上。

1. Install the thread winder guide① on the cover with fixed screw②.
2. Insert the bottom thread guide bar③ into the stand.

12. 绕底线 (见图10)

Winding the bottom thread (See Figure 10)

1. 按①~④的顺序穿线, 然后在梭芯上绕线圈。
 2. 掀倒绕线杆A。
 3. 拧松固定螺钉B, 调整调节板直到让线绕到80%左右的位置。
 4. 绕线偏时, 前后移动绕线导向器C进行调整, 再用固定螺钉D固定。
 5. 绕线结束后, 绕线杆分离, 自动停止。
- 1.Thread according to the order of ①~④ and then wind the coil on the hook core.
2.Press down the winding bar A.
3.Loosen the fixed screw B and adjust the regulating panel to make the thread wind to the position of about 80%.
4.If the winding thread deviates from the course, move the thread winder guide C forward and backward to adjust and then fix with fixed screw D.
5.After the winding is over, the winding rod separates and stops automatically.

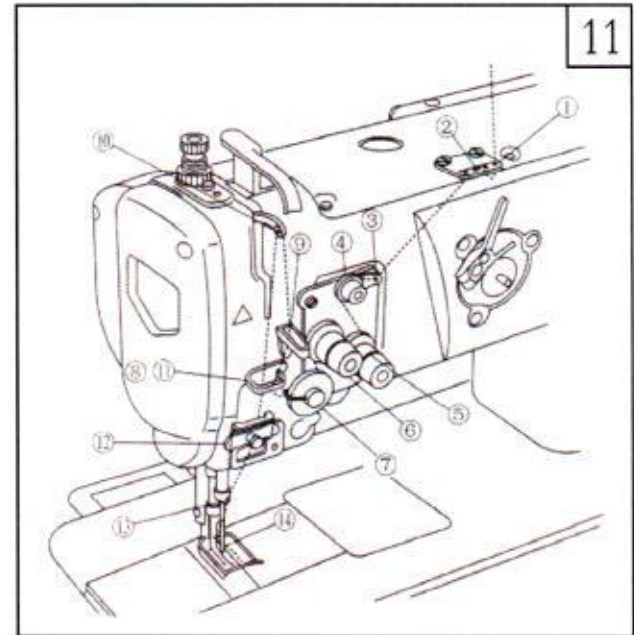


13. 穿线 (见图11)

Threading (See Figure 11)

按图示顺序穿线即可。

Thread according to the order indicated on the figure.



14. 线迹长度的调节 (见图12)

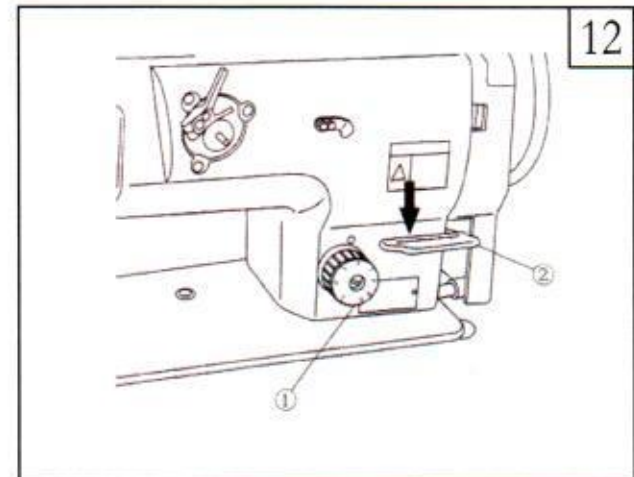
Adjusting the length of stitches (See Figure 12)

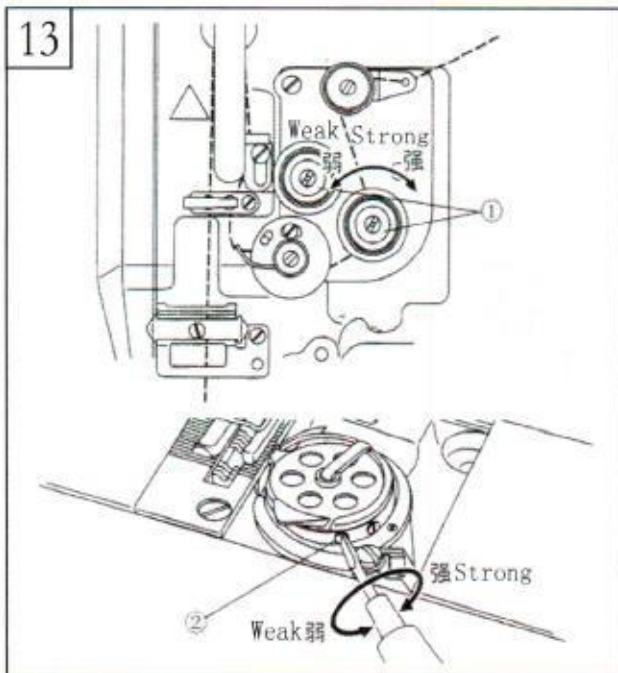
把送布调节盘①向左(右)转动, 让调节标记对准需要的数字即可。

向下按下倒缝扳手②即可开始倒缝, 放开恢复正常缝纫。

Turn the feed adjusting tray ① to the left (or right) and make the adjusting mark aim at the required number.

Press the backstitch spanner ② downward to start and release the spanner to resume the normal stitch.



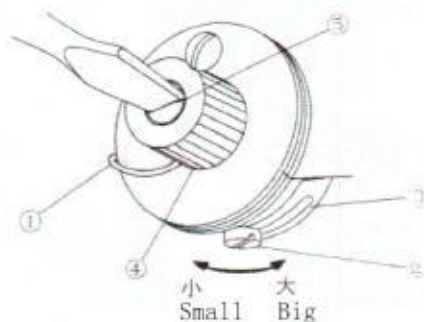


15. 线张力的调节 (见图13)

Adjusting the thread tension (Figure 13)

1. 上线张力的调节
顺时针方向转动线张力螺母①，上线张力变强；
逆时针方向转动张力变弱。
 2. 底线张力的调节
顺时针方向转动线张力螺钉②，底线张力变强；
逆时针方向转动张力变弱。
1. Adjusting the tension of feeding thread
Turn the thread tension nut ① clockwise, than the tension of feeding thread increases; otherwise, the tension decreases.
 2. Adjusting the tension of bottom thread
Turn the thread tension screw ② clockwise, than the tension of bottom thread increases; otherwise, the tension decreases.

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16. 挑线簧的调节 (见图14)

Adjusting the take-up spring (See Figure 14)

1. 变更挑线簧的移动量时
 - a. 拧松止动器固定螺丝②，左右移动止动器③，调节挑线弹簧①。
 - b. 向右移动止动器则挑线簧的移动量变大，向左移动变小。
 2. 变更挑线簧的强度时
拧松螺母④，把弹簧轴⑤向逆时针方向转动，强度变强，顺时针方向转动，强度变弱。
1. When changing the movement amount of the take-up spring
 - a. Loosen the fixed screw ② of the stopper and move the stopper ③ to the left or right in order to adjust the take-up spring ①.
 - b. The movement amount of the take-up spring increases if moving the stopper to the right; otherwise it decreases.
 2. When changing the strength of the take-up spring
Loosen the nut ④. Then turn the spring shaft ⑤ anticlockwise, the strength increases; otherwise, it decreases.

17. 压脚提升 (见图15)

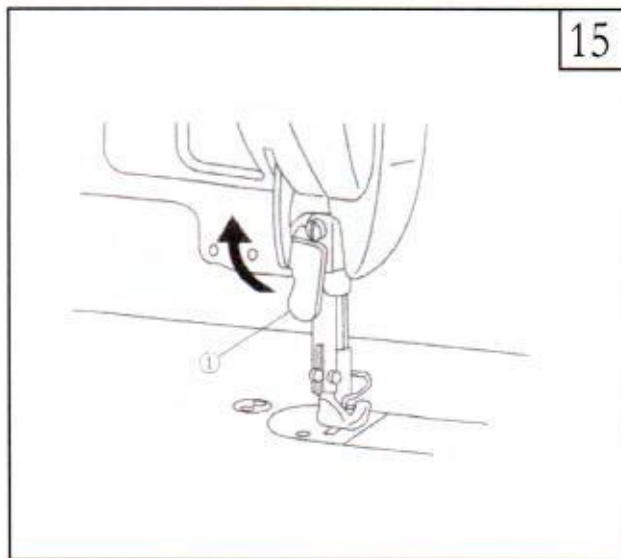
Lifting the pressure foot (See Figure 15)

1. 让压脚在上升的位置停止时, 把抬压扳手压脚提升杆①向箭头方向抬起。压脚上升9mm后停止。

2. 下降压脚时, 放下抬压扳手, 即返回原来位置。

1. When stopping the pressure foot in the rise position, uplift the pressure foot lifting bar① of presser spanner to the arrow position. Stop after the pressure foot rises 9mm.

2. Put down the presser spanner when lowering the pressure foot. It will be back to the original position.

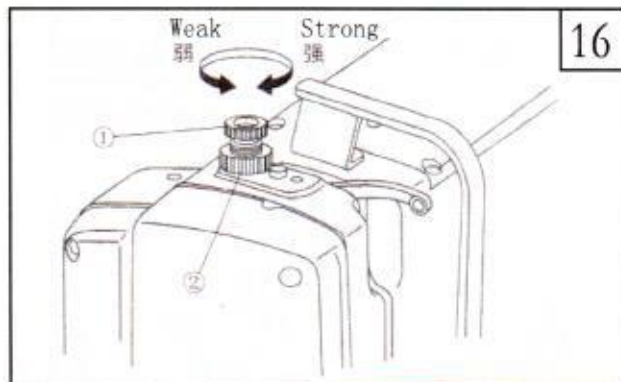


18. 压脚压力的调节 (见图16)

Adjusting the pressure of the pressure foot (See Figure 16)

向右转动压脚调节螺钉①压力变强, 向左转动压力变弱。调节后拧紧固定螺母②。

Move the pressure foot adjusting screw① to the right, than the pressure increases; otherwise, it decreases. Tighten the fixed nut② after adjusting.



19. 旋梭针座的调整 (见图17)

Adjusting the hook needle bed (See Figure 17)

更换了旋梭之后, 请确认针座位置。标准位置时, 旋梭针座②顶到机针①侧面, 离机针0.1~0.2mm的状态。如果不正确, 请弯曲旋梭针座进行调节。

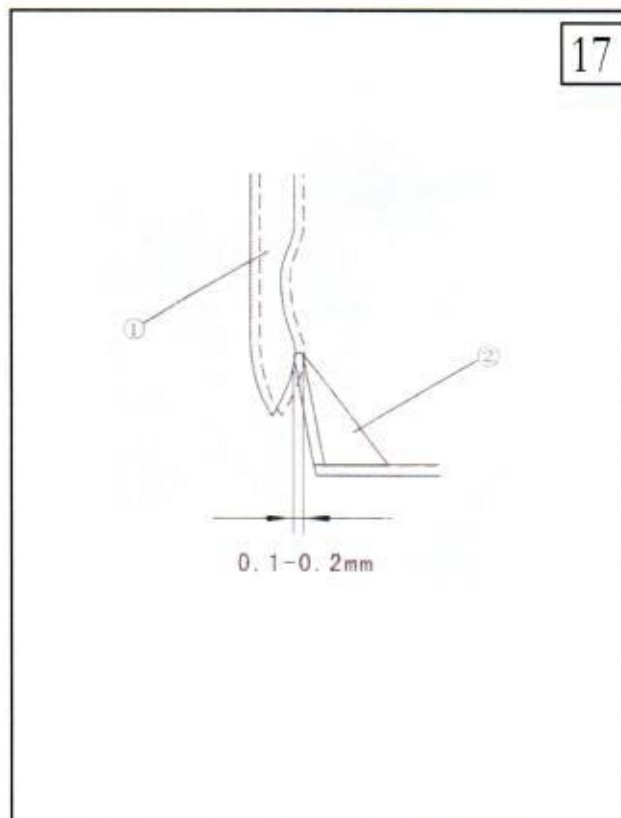
1. 旋梭针座往内侧弯曲时, 把螺丝刀插到旋梭针座的外侧。

2. 旋梭针座往外侧弯曲时, 把螺丝刀插到旋梭针座的内侧。

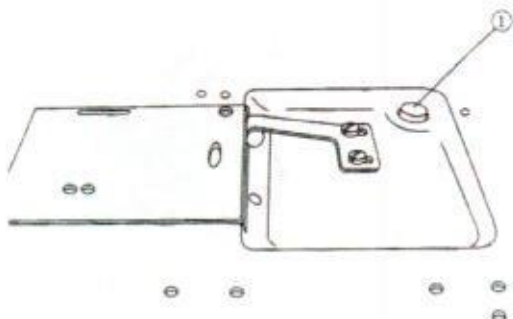
Please confirm the position of the needle bed after changing the hook. When it is in standard position, the hook needle bed② is about 0.1~0.2mm away from the side of the needle. If it is incorrect, please curve the hook needle bed for adjusting.

1. When curving the hook needle bed inwards, insert the screwdriver into the outside of the hook needle bed.

2. When curving the hook needle bed outwards, insert the screwdriver into the inside of the hook needle bed.



18



20. 安全装置的复位 (见图18)

Resetting of the safety device (See Figure 18)

缝制中, 如果向旋梭等施加过大的力, 安全装置就起动。这时转动主动轮旋梭也不转动。安全装置起动之后, 请先排除故障原因, 再进行复位。

1. 按住机头上面的按钮①, 用力反转主动轮;
2. 听到“喀嚓”的声音后, 复位完成。

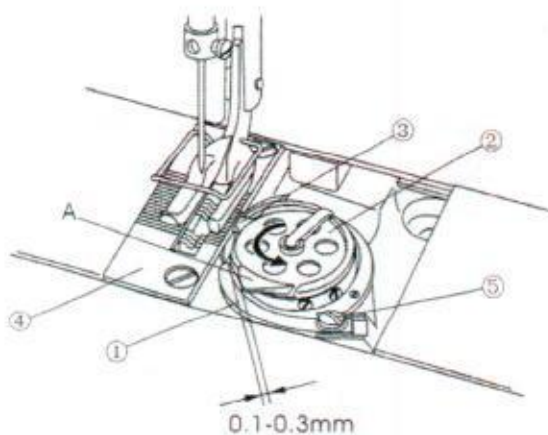
注意: 完成后用手转动主动轮, 确认按钮①是否复位。

During the sewing, the safety device starts if exerting over-force on the hook. The hook of driving wheel fails to work at the moment. Please eliminate the failures prior to resetting after the safety device starts.

1. Press the button① on the head and reverse the driving wheel with force.
2. Resetting is finished after you hear the sound of crack.

Note: Run the driving wheel with hands to confirm whether the button① is reset.

19



21. 线迹长度的调节 (见图19)

Adjusting the length of stitches (See Figure 19)

1. 向正常方向转动主动轮, 把中旋梭导向器①移送到最后位置。
2. 向箭头方向转动②, 把中旋梭止动器③顶到针④的沟。
3. 拧松中导向器固定螺丝⑤, 把中旋梭导向器和梭壳的突起部A之间的间隙调整为0.1~0.3mm。

1. Turn the driving wheel to the normal direction and transfer the middle hook guide① to the final position.
2. Turn ② to the arrow and make the middle hook stopper③ to the slot of the needle④.
3. Loosen the fixed screw⑤ of the middle guide. Adjust the clearance between the middle hook guide and the bulge A of the hook cover to 0.1~0.3mm.

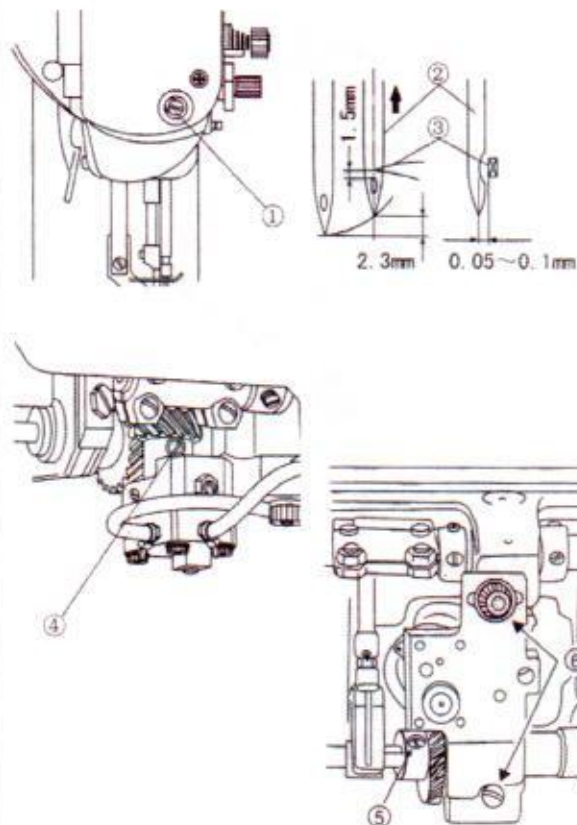
22. 针与旋梭的关系 (见图20)

Relations between the needle and the hook (See Figure 20)

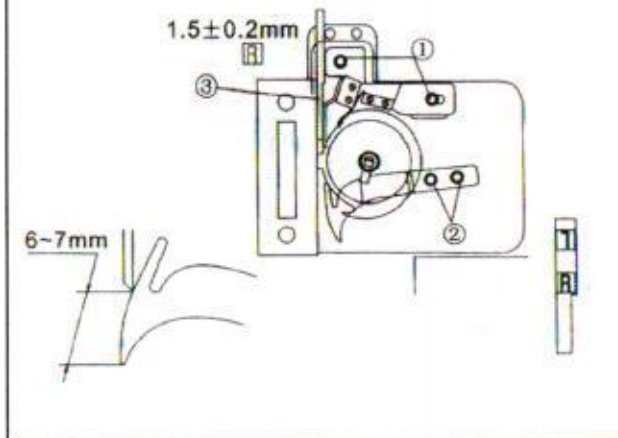
20

1. 把针距调节旋钮调整到0;
2. 转动主动轮, 从针杆最下点上升2.3mm后, 拧松针杆接头螺丝①, 把机针②的针孔上端到梭尖③的距离调整成1.5mm然后再拧紧;
3. 转动主动轮, 把针杆从最下点上升2.3mm。把旋梭尖③和机针②的中心调整的基本一致, 然后拧紧2个螺丝齿轮(小)的固定螺丝④。把2个固定螺丝④之中前端为V形的第一螺丝, 对准旋梭轴的V型沟, 然后拧紧固定。
4. 在旋梭尖③和机针②中心基本一致的位置, 拧松旋梭轴台的固定螺丝⑥, 左右移动旋梭轴台, 把旋梭尖和机针的间隙调整为0.05~0.1mm, 然后拧紧固定螺丝⑥。
5. 拧松2格螺丝齿轮(大)的固定螺丝⑤, 左右移动螺丝齿轮(大), 把旋梭尖③机针②的中心调整为一致, 然后拧紧固定螺丝⑤。把2个固定螺丝⑤中的第一螺丝对准下轴的平部, 然后拧紧。

1. Turn the adjusting knob of needle distance to 0.
2. Turn the driving wheel. After the lowest point of the needle bar rises to 2.3mm, loosen the needle bar joint screw①. Adjust the distance from the upper part of the needle hole of needle② to the hook top③ to 1.5mm and then tighten.
3. Turn the driving wheel. Rise the needle bar to 2.3mm from the lowest point. Adjust the centers of the hook top③ and the needle② to make them basically the same. Then tighten the fixed screws④ of two screw gears (smaller ones). Aim the first screw with V-shape front of the two fixed screws④ at the V-shape slot of the hook shaft. Then tighten and fix.
4. At the position where the centers of both the hook top③ and the needle② are basically the same, loosen the fixed screw⑥ of hook shaft pillow and then move it to the left or right in order to adjust the clearance between the hook top and the needle to 0.05~0.1mm. Then tighten the fixed screw⑥.
5. Loosen the fixed screw⑤ of two screw gears (bigger ones). Move the screw gear (bigger one) to the left or right to make the centers of the hook top③ and the needle② basically the same. Tighten the fixed screw⑤. Aim the first screw of two fixed screws⑤ at the flat part of the lower shaft and then tighten.



21



23. 切刀调整 (见图21)

Adjusting the cutter (See Figure 21)

固定刀的位置调整:

拧松固定刀座固定螺丝①, 左右方向为: 右侧离固定刀前端位置离针板端面 $1.5 \pm 0.2\text{mm}$, 前后方向, 顶到旋梭轴台的阶梯部, 然后拧紧固定螺丝①。距离的大小, 请使用附属的固定刀标尺③的R面。切刀压力的调整:

拧松活动刀固定螺丝②, 转动上轮, 移动活动刀调整切刀压力, 从活动刀前端到固定刀前端的距离为 $6 \sim 7\text{mm}$ 时, 切刀压力为标准压力。

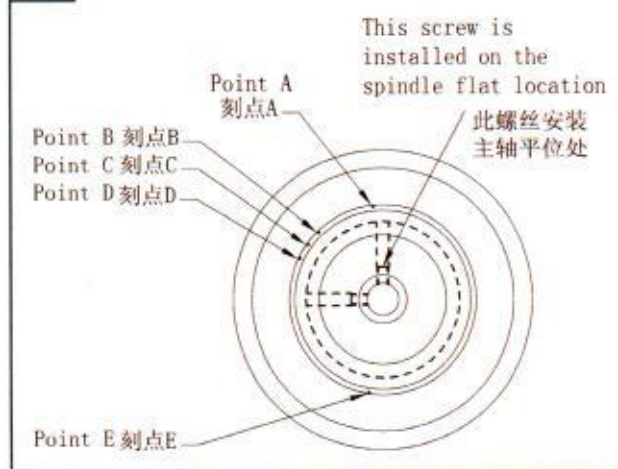
Adjusting the position of fixed cutter:

Loosen the fixed screw① of fixed cutter holder with the right and left sides of the fixed cutter front end respectively $1.5 \pm 0.2\text{mm}$ and $2 \pm 0.2\text{mm}$ away from the needle bed front end. The front and back of the cutter holder are up against the stairs of the shaft pillow and tighten the fixed screw①. Please use the face R of fixed cutter scale③ attached to determine the distance.

Adjust the pressure of cutter:

Loosen the fixed screw② of the moveable cutter. Turn the upper wheel and shift the moveable cutter to adjust its pressure. If the distance from the front end of moveable cutter to the front end of fixed cutter is $6 \sim 7\text{mm}$, the cutter pressure is standard.

22



24. 手轮刻点表示意图 (见图22)

Hand wheel points picture (See Figure 22)

如左图所示: 本书中所有提及的手轮刻点(A~E), 均以此图为准。

All mentioned hand wheel points (A-E) are subjected to the picture on the left.

25. 机器停止位置确认 (见图23)

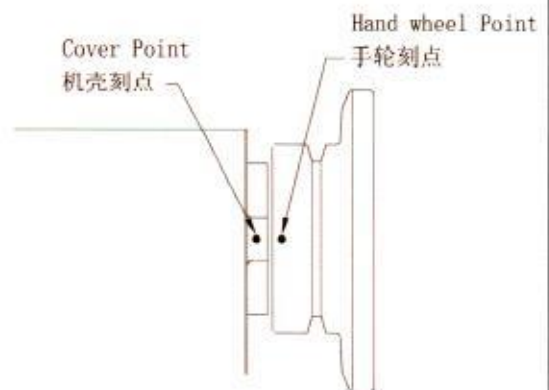
Suspension position confirmation
for the machine (See Figure 23)

各停止位置的调整, 以手轮刻点与机壳刻点一致时, 按下表所述进行调整。

When the points on the hand wheel are same as those on the cover, please adjust the every suspension position as follow.

手轮刻点 Hand wheel point	机器位置 Position of the machine
刻点B-C之间 Point B-C	上停针位置 Position of upper stop needle
刻点E Point E	下停针位置 Position of lower stop needle
刻点A Point A	剪线凸轮调整用 Thread cutting CAM adjustment
刻点A Point A	逆转提升机针位置 Reverse the position of lifting needle

23



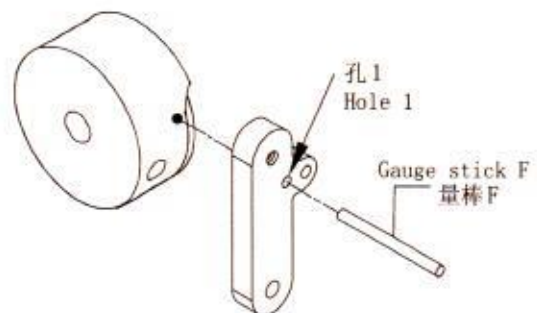
26. 剪线凸轮位置调节 (见图24)

Adjustment of thread cutting CAM
position (See Figure 24)

1. 使手轮刻点A到机壳刻点相对应位置。
2. 准备一根直径3mm量棒F(70mm长)。
3. 将量棒F插在零件的孔1中, 并对准剪线凸轮上的定位点(如右图所示)。
4. 固定好剪线凸轮螺丝, 取出量棒F。

1. Make sure the point A on the hand wheel is also on the corresponding position of the cover.
2. Prepare one gauge stick F with 3mm diameter and 70mm length.
3. Please put the gauge stick F into the hole 1 of the parts, and be directed at the thread cutting CAM setting points.
4. Please fix the thread cutting CAM screw, then put out the measurement stick F.

24



27. 缝制速度一览表 List of sewing speed

交替上下量 Up-and-down alternation amount	线迹6mm以下 Stitch: less than 6mm	线迹6mm以上9mm以下 Stitch: 6mm~9mm
~3mm以下 Less than 3mm	2,500rpm	2,000rpm
3~4mm以下 3mm~4mm	2,000rpm	2,000rpm
4~6.5mm以下 4mm~6.5mm	1,600rpm	1,600rpm

根据不同条件设定最高转速, 请不要超过设定值。

Set the maximum revolution according to different conditions. Please don't exceed the set value.

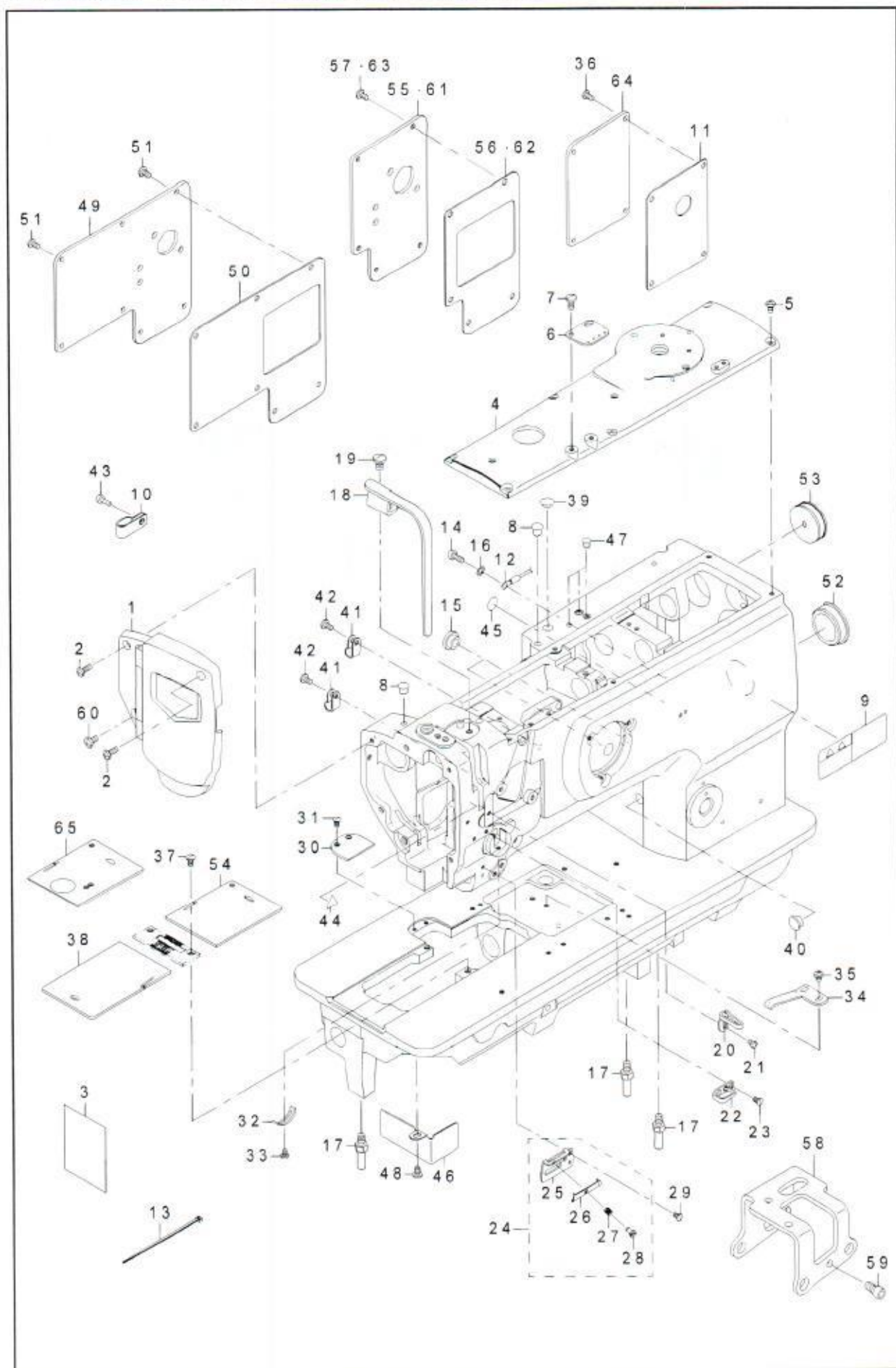
28. 缝制中出现的问题及处理方法 Sewing problems and troubleshooting

现象 Problems	原因 Causes	处理方法 Troubleshooting
<p>1. 断线 Broken stitching (布背面上线残留2~3mm) (feeding thread residue of 2~3mm on the back of the fabric)</p>	<p>①线道、针尖、旋梭尖、针板的中旋梭固定沟上有伤痕。 ②上线张力强。 ③机针与旋梭尖相碰。 ④旋梭部的油量少。 ⑤上线张力过弱。 ⑥挑线弹簧过强, 移送量少。 ⑦针与旋梭同步过快或过慢。</p> <p>①Scars on the thread, needle top, hook top and the fixed slot on the hook inner circle of the needle bed. ②Strong upper tension. ③The needle touches the hook top. ④The oil is insufficient in the hook. ⑤Weak feeding thread tension. ⑥Powerful take-up spring and small transfer amount. ⑦Over fast or over slow synchronization of the needle and the hook.</p>	<p>○用细砂纸打磨旋梭尖的伤痕。 用锉刀锉针板的旋梭内圈固定沟。 ○减弱上线张力。 ○参照(22. 针与旋梭的关系)。 ○调整油量(参照7. 加油)。 ○增加上线张力。 ○减弱挑线弹簧, 加大移动量。 ○参照(22. 针与旋梭的关系)。 ○Polish the scars on the hook top with fine sand paper. File the inner circle fixing slot of the hook of the needle bed. ○Reduce the feeding thread tension. ○Refer to the content in 19. Relations between the Needle and the Hook. ○Adjust the oil quantity (Refer to the content in 7. Oiling.) ○Increase the feeding thread tension. ○Weaken the take-up spring and increase the movement amount. ○Refer to the content in 19. Relations between the Needle and the Hook.</p>
<p>2. 跳线 Skipped stitching</p>	<p>①针与旋梭同步过快或过慢。 ②压脚压力过弱。 ③针孔上端和旋梭尖的间隙不正确。 ④机针号不对。</p> <p>①Over fast or over slow synchronization of the needle and the hook. ②Weak pressure for the pressure foot. ③Incorrect clearance between the upper part of the needle hole and the hook top. ④Wrong needle type.</p>	<p>○参照(22. 针与旋梭的关系)。 ○拧紧压脚调节螺丝。 ○参照(22. 针与旋梭的关系)。 ○更换为大一号的机针。</p> <p>○Refer to the content in 19. Relations between the Needle and the Hook. ○Tighten the adjusting screw of the pressure foot. ○Refer to the content in 19. Relations between the Needle and the Hook. ○Change to a little bit bigger needle.</p>
<p>3. 紧线不良 poor stringing</p>	<p>①梭壳的线张力弹簧下没有穿底线。 ②线道加工不好。 ③梭芯不滑动。 ④底线张力过弱。 ⑤底线绕线过强。 ⑥针尖损伤。</p> <p>①Not threading under the thread spring of the hook cover. ②Poor processing of the thread. ③The hook core doesn't slide. ④Weak bottom thread tension. ⑤Strong bottom thread winding. ⑥Damaged needle top.</p>	<p>○参照(10. 底线的穿线方法)。 ○用细砂纸打磨或用锉刀锉。 ○更换梭芯或更换旋梭。 ○加强底线张力。 ○减弱底线绕线张力。 ○更换机针。 ○Refer to the content in 9. Threading of the Bottom Thread. ○Polish with fine sand paper or file. ○Change the hook core or hook. ○Increase the bottom thread tension. ○Decrease the bottom thread winding tension. ○Change the needle.</p>

零件手册

A Handbook of Parts

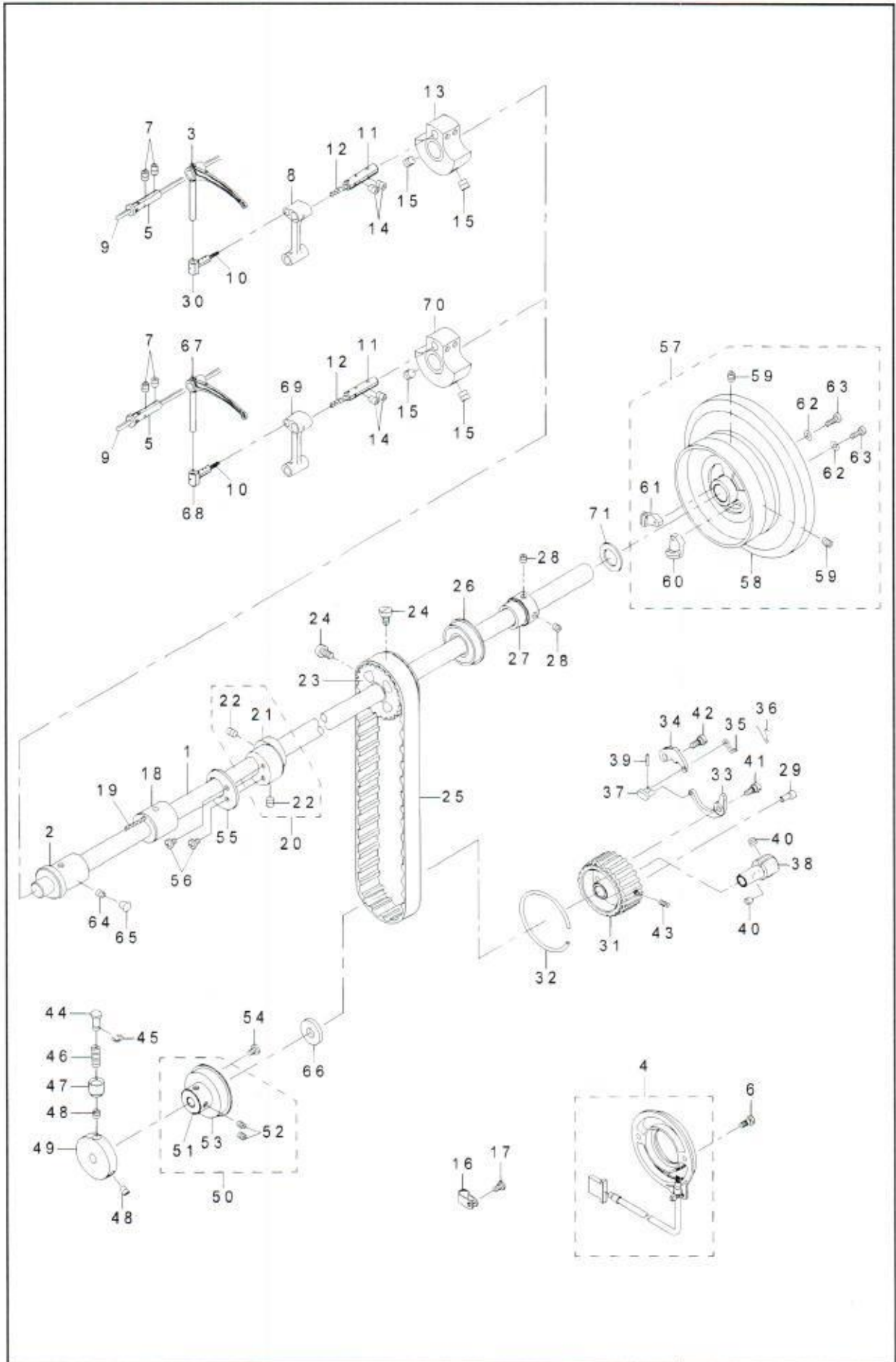
1. 机壳部件 Frame & miscellaneous cover components



1. 机壳部件 Frame & miscellaneous cover components

序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		40016798	FACE PLATE ASM.	面板	1
2		SS4111215SP	SCREW 11/64-40 L=12	螺钉11/64-40 L=12	2
3		40019114	LUBRICATION SUPPLEMENT	标签	1
4		21331301	TOP COVER B	顶盖	1
5		SS4110815SP	SCREW 11/64-40 L=8	螺钉11/64-40 L=8	6
6		21355904	ARM THREAD GUIDE	过线板	1
7		SS7621040SP	SCREW 3/16-32 L=9.5	螺钉3/16-32 L=9.5	2
8		TA0750704R0	RUBBER PLUG	橡皮塞	2
9		CM301300001	SAFETY LABEL	安全标志	1
10		D2112555B00	CORD HOLDER LARGE	电线固定夹	1
11		21437306	WINDOW PLATE E PACKING	油垫	1
12		22951552	GROUND WIRE ASM.	接地用端子	1
13		EA9500B0100	CABLE BAND	线卡	1
14		SS6111140SP	SCREW 11/64-40 L=11	接地用螺钉	1
15		TA1250504R0	RUBBER PLUG	橡皮塞	2
16		WT0530002KS	TOOTHED WASHER D=5.3	外齿弹性垫圈	1
17		22602601	BED SCREW STUD	底板支撑螺钉	3
18		21331608	BALANCE COVER	天平盖	1
19		SS7150910TP	SCREW 15/64-28 L=9	螺钉15/64-28 L=9	1
20		21355805	THREAD GUIDE	过线钩	1
21		SS5090610SP	SCREW 9/64-40 L=6	螺钉9/64-40 L=6	1
22		B1129051000	FRAME THREAD GUIDE UPPER	上过线	1
23		SS2090710TP	SCREW 9/64-40 L=7.2	螺钉9/64-40 L=7.2	2
24		21408554	THREAD GUIDE ASM.	过线组件	1
25		21408505	THREAD GUIDE PLATE	过线板	<1>
26		17912106	NEEDLE THREAD PRESSER PLATE	面线压板	<1>
27		B1132521000	THREAD PRESSER PLATE SPRING	压板弹簧	<1>
28		SD0380551SL	HINGE SCREW D=3.80 H=5.5	铰链螺钉D=3.80 H=5.5	<1>
29		SS2090710TP	SCREW 9/64-40 L=7.2	螺钉9/64-40 L=7.2	1
30		22651202	AUXILIARY COVER	辅助板	1
31		SS2090710TP	SCREW 9/64-40 L=7.2	螺钉9/64-40 L=7.2	2
32		B3138512000	TAKE-UP SPRING ADJUSTING PLATE	挑线簧调整板	1
33		SS7090520TP	SCREW 9/64-40 L=4.5	螺钉9/64-40 L=4.5	1
34		B1111563000	BED SLIDE SPRING	右推板托簧	1
35		SS4110515SP	SCREW 11/64-40 L=5	右推板托簧螺钉	2
36		SS4110815SP	SCREW 11/64-40 L=8	螺钉11/64-40 L=8	4
37		SS2110920TP	SCREW 11/64-40 L=8.5	螺钉11/64-40 L=8.5	2
38		21349600	SLIDING PLATE (LEFT)	左推板	1
39		TA1250504R0	RUBBER PLUG	橡皮塞	1
40		TA1050504R0	RUBBER PLUG	橡皮塞	1
41		HX00123000A	CABLE CLIP	电线固定夹	2
42		SS4110815SP	SCREW 11/64-40 L=8	螺钉11/64-40 L=8	2
43		SS6111140SP	SCREW 11/64-40 L=11	接地用螺钉	1
44		CM300200001	ATTENTION SEAL	安全标志	1
45		22901805	GROUND MARK	接地标记	1
46		21332200	OIL SHIELD (LEFT)	挡油板	1
47		TA0550604R0	RUBBER PLUG	橡皮塞	3
48		SS4110815SP	SCREW 11/64-40 L=8	螺钉11/64-40 L=8	1
49		21331905	WINDOW PLATE C	大后窗盖C	1
50		21332101	WINDOW PLATE PACKING C	窗盖板C垫	1
51		SS4110815SP	SCREW 11/64-40 L=8	螺钉11/64-40 L=8	7
52		22619100	CAP	橡皮塞	1
53		10201200	RUBBER PLUG	橡皮塞	1
54		21349808	THREAD CUTTING SLIDING PLATE	右推板	1
55		21348909	WINDOW PLATE D	大后窗盖	1
56		21332002	WINDOW PLATE PACKING B	窗盖板B垫	1
57		SS4110815SP	SCREW 11/64-40 L=8	螺钉11/64-40 L=8	5
58		21343207	KNEE LIFTER SHAFT BASIS	膝控提升上架	1
59		SM6061202TP	SCREW M6 L=12	膝控提升架固定螺钉	3
60		SS4150915SP	SCREW 15/64-28 L=9	螺钉	1
61		21348909	WINDOW PLATE D	大后窗盖	1
62		21332002	WINDOW PLATE PACKING B	窗盖板B垫	1
63		SS4110815SP	SCREW 11/64-40 L=8	螺钉11/64-40 L=8	5
64		21437108	WINDOW PLATE E	大后窗盖E	1
65		40092832	THREAD CUTTING SLIDING PLATE (RIGHT) ASM.	前推板	1

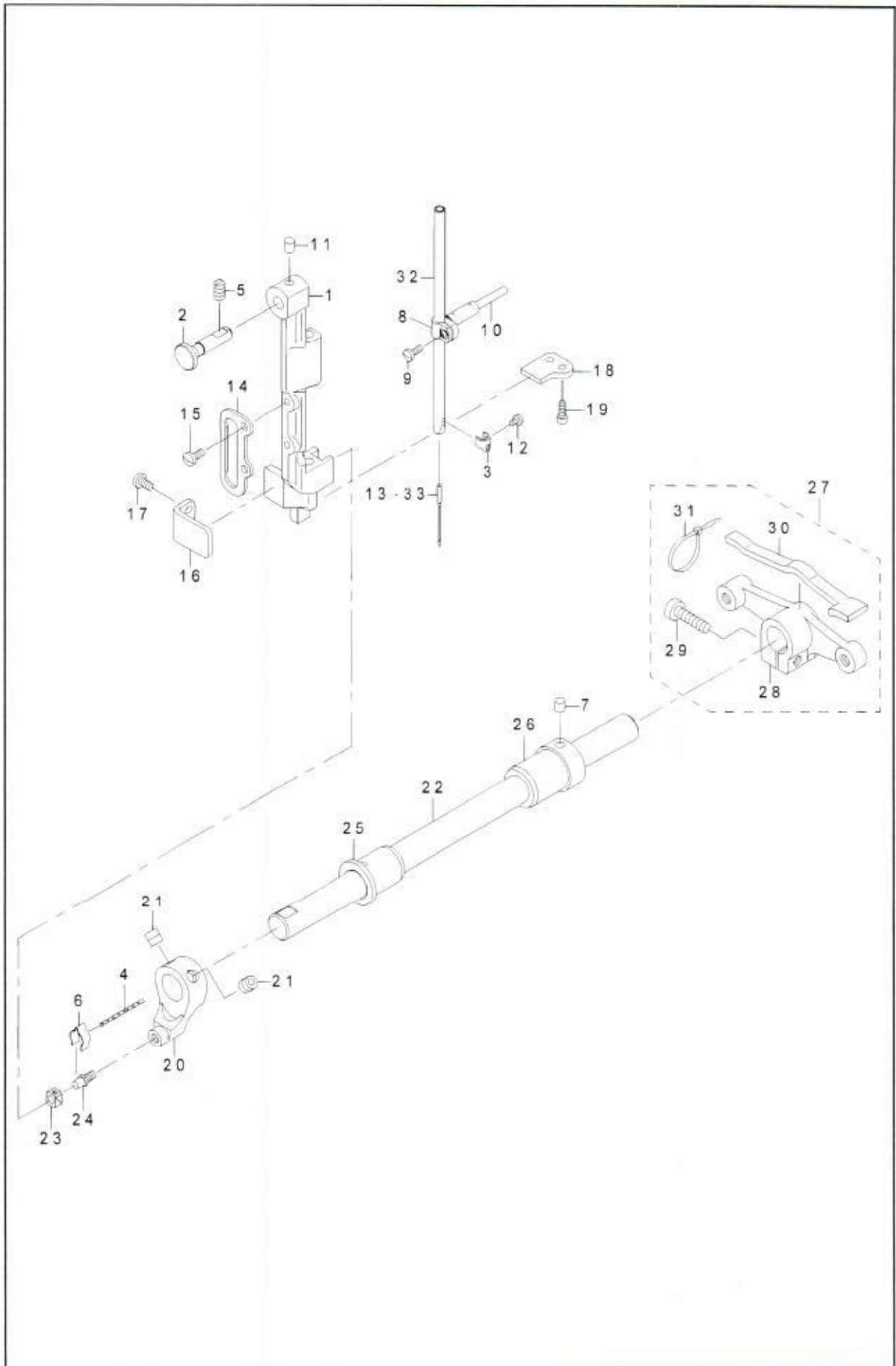
2. 上轴、下轴及挑线部件 Upper shaft, lower shaft driving & balance components



2. 上轴、下轴及挑线部件 Upper shaft, lower shaft driving & balance components

序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		21332705	UPPER SHAFT	上轴	1
2		21333000	UPPER SHAFT FRONT METAL	上轴前套	1
3		21333208	BALANCE	挑线杆	1
4		40024855	CONTAIN SYNCHRO ASM.	定针感应线圈组件	1
5		B1906051000	TAKE-UP LEVER PIN	挑线杆销	1
6		10604809	SCREW	螺钉	2
7		SS8150822TP	SCREW 15/64-28 L=8	螺钉15/64-28 L=8	2
8		21339106	NEEDLE BAR CRANK ROD	针杆曲柄	1
9		CQ303000000	OIL WICK	油线	0.45
10		CQ202000000	OIL WICK	油线	0.03
11		B1210051000	NEEDLE BAR CRANK PIN	针杆曲柄销	1
12		CQ505000000	OIL WICK	油线	0.03
13		21332507	COUNTER WEIGHT (A) (36MM)	针杆曲柄	1
14		SS8150822TP	SCREW 15/64-28 L=8	螺钉15/64-28 L=8	2
15		SM8080812TP	SCREW M8X8	螺钉M8X8	2
16		HX00123000A	CABLE CLIP	电线固定夹	1
17		SS4110815SP	SCREW 11/64-40 L=8	螺钉11/64-40 L=8	1
18		21333109	UPPER SHAFT INNER METAL	上轴内套	1
19		CQ202000000	OIL WICK	油线	0.15
20		21336557	ECCENTRIC CAM A ASM.	偏心凸轮A组件	1
21		21336508	ECCENTRIC CAM A	偏心凸轮A	<1>
22		SS8660810TP	SCREW 1/4-40 L=8	螺钉1/4-40 L=8	<2>
23		40038692	UPPER SPROCKET	上同步轮	1
24		SS6661110SP	SCREW 1/4-40 L=11	螺钉	2
25		22604300	TIMING BELT	同步带	1
26		B1203512000	BUSHING REAR	6005N轴承	1
27		21402300	UPPER SHAFT BEARING HOOK	上轴轴承套	1
28		SM8060602TP	SCREW M6X6	螺钉M6X6	2
29		21387907	ADJUSTING PIN (1, 2)	(下轮)偏心销	1
30		21333307	BALANCE SLIDE SHAFT	挑线杆滑块	1
31		21387501	LOWER SPROCKET	下轴同步带轮	1
32		B1214019000	SPROCKET RING	同步轮环	1
33		21387709	SAFETY CLUTCH SPRING	下轮板簧	1
34		21387600	SAFETY CLUTCH HOOK	下轮挂钩	1
35		B1308055000	SAFETY CLUTCH COUNTER-HOOK	下轮小钩	1
36		B1309055000	COUNTER-HOOK SPRING	下轮弹簧	1
37		B1310055000	SAFETY CLUTCH SMALL LINK	下轮小連結	1
38		21387808	SAFETY BASE	挂钩芯杆	1
39		B1314055000	SAFETY CLUTCH SMALL LINK PIN	开口销	1
40		SS8660612TP	SCREW 1/4-40 L=6	螺钉1/4-40L=6	2
41		SD0640322TP	HINGE SCREW D=6.35 H=3.2	板簧销钉	1
42		SD0640322TP	HINGE SCREW D=6.35 H=3.2	板簧销钉	1
43		SS8111010TP	SCREW 11/64-40 L=9.5	(下轮)偏心销支头螺钉	1
44		21333802	SAFETY CLUTCH PUSH BUTTON	按钮	1
45		RE0500000K0	E-RING 5	开口挡圈	1
46		B1639051000	SPRING	按钮簧	1
47		B1313055000	SAFETY CLUTCH KNOB SLEEVE	按钮架	1
48		SS8660530TP	SCREW 1/4-40 L=4.5	按钮卡轮支头螺钉	2
49		21333901	SAFETY CLUTCH DISC	按钮卡轮	1
50		40038700	THRUST COLLAR ASM.	下轴轴承芯棒组件	1
51		40038702	THRUST COLLAR	下轴轴承芯棒	<1>
52		SS8661030SP	SCREW 1/4-40 L=10	下轴轴承芯棒螺钉	<2>
53		SB120000200	BEARING 20X42	轴承	<1>
54		SS7120760SP	SCREW 3/16-28 L=7.0	下轴轴承固定螺钉	2
55		21353008	HORIZONTAL FEED CAM COVER	水平送料凸轮盖板	1
56		SS7110710SP	SCREW 11/64-40 L=7	螺钉11/64-40 L=7	2
57		21427059	FLYWHEEL	飞轮	1
58		21427000	FLYWHEEL	飞轮	<1>
59		SS8150822TP	SCREW 15/64-28 L=8	螺钉15/64-28 L=8	<2>
60		M40071100AA	MAGNET FITTING BASE A ASM.	定针感应块A	<1>
61		M40071100AB	MAGNET FITTING BASE B ASM.	定针感应块B	<1>
62		WP0450801SD	WASHER 4.5X10X0.8	平垫4.5X10X0.8	<2>
63		SS6111210SP	SCREW 11/64-40 L=12	螺钉11/64-40 L=12	<2>
64		SS8150710TP	SCREW 15/64-28 L=7	按钮卡轮支头螺钉	1
65		TA0750704R0	RUBBER PLUG	橡皮塞	1
66		40016148	THRUST COLLAR B WASHER	垫圈	1
67		40041734	THREAD TAKE-UP LEVER	挑线杆	1
68		B1907526000	TAKE-UP LEVER THRUST PIN	皮带轮	1
69		B1408051000	NEEDLE BAR CRANK ROD	针杆曲柄	1
70		21332606	COUNTER WEIGHT (B) (38MM)	针杆曲柄	1
71		22606206	SPACER Y	垫圈	1

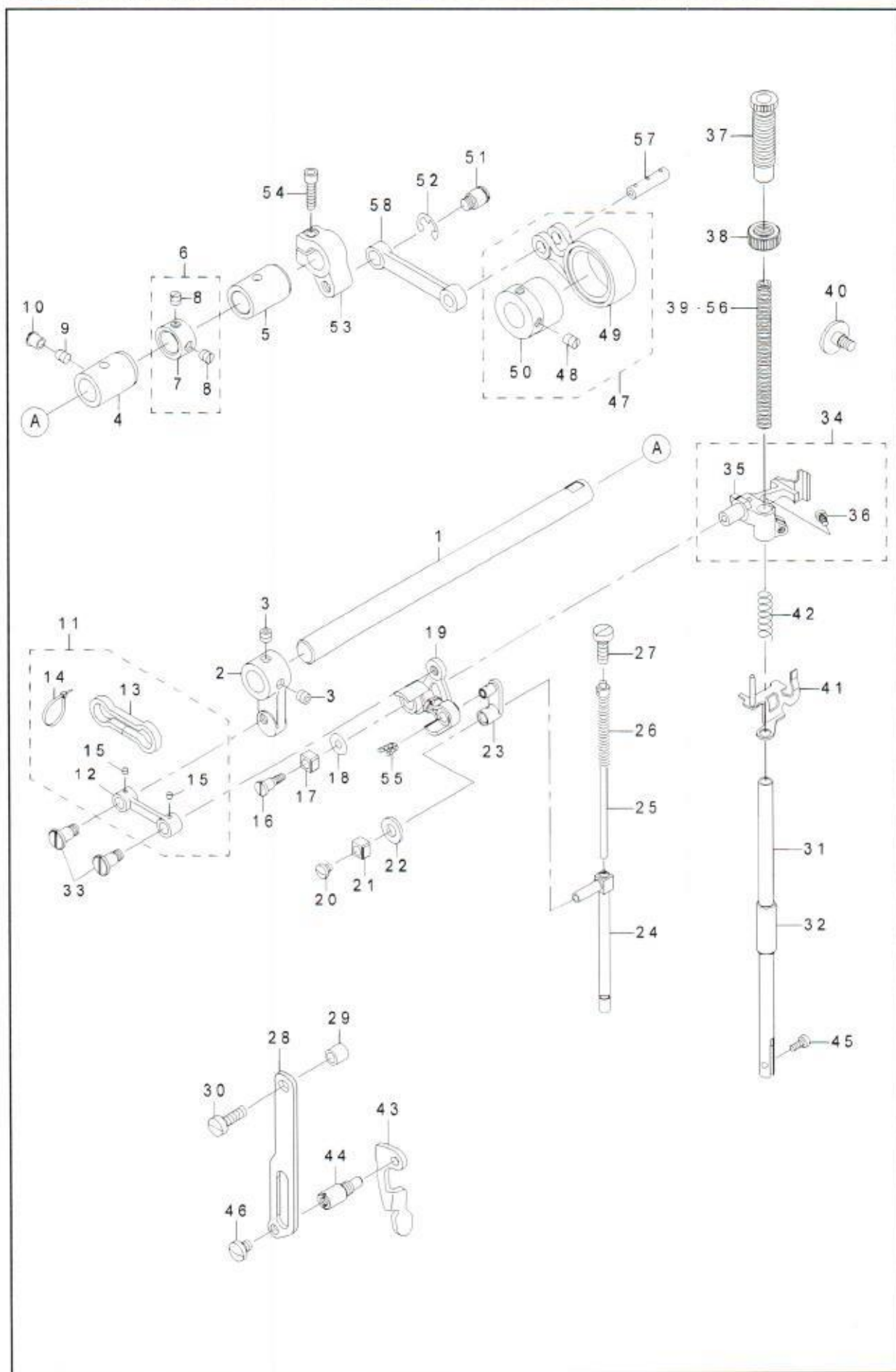
3. 针杆摆动部件 Needle bar rocking components



3. 针杆摆动部件 Needle bar rocking components

序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		B1420563000	NEEDLE BAR FRAME	针杆摇架	1
2		21405204	HINGE STUD	铰链销	1
3		21338504	NEEDLE BAR THREAD RACK	过线	1
4		CQ202000000	OIL WICK	油线	0.05
5		SS8151150TP	SCREW 15/64-28 L=10.5	螺钉15/64-28L=10.5	1
6		B1437051000	OIL WICK RETAINER	油线夹	1
7		21387402	FELT	油毡	1
8		B1411053000	NEEDLE BAR CONNECTION	针杆接头	1
9		SS7090910SP	SCREW 9/64-40 L=8.5	螺钉	1
10		B1412051000	FELT	油毡	1
11		22814909	FELT	油毡	1
12		SS7080510TP	SCREW 1/8-44 L=4.5	螺钉1/8-44L=8.5	1
13		M13517B1600	NEEDLE 135X17 #160	机针	1
14		B1467563000	UPPER FEED BAR GUIDE	上送料导向板	1
15		SS7110910TP	SCREW 11/64-40 L=8.5	螺钉11/64-40 L=8.5	2
16		21388400	ROCKING BASE GUIDE	滑块导向座	1
17		SS7110830SP	SCREW 11/64-40 L=7.5	螺钉11/64-40 L=8.5	2
18		21338603	ROCKING BASE GUIDE (B)	滑块导向座B	1
19		SS6091022TP	SCREW	螺钉	2
20		21338801	ROCKING FRONT ARM	摆动前臂	1
21		SM8080802TP	SCREW	螺钉	2
22		21338900	ROCKING SHAFT	摆轴	1
23		B1414232000	SQUARE BLOCK	方滑块	1
24		B1410771000	STUD	螺栓	1
25		21339304	ROCKING SHAFT FRONT METAL	摆轴前轴套	1
26		40027746	BUSHING REAR	6005N轴承	1
27		21339056	ROCKING REAR ARM ASM.	摆动后臂组件	1
28		21339007	ROCKING REAR ARM	摆动后臂	<1>
29		SS6152440SP	SCREW 15/64-28 L=23.5	螺钉15/64-28L=23.5	<1>
30		21347406	ROCKING REAR ARM FELT	摆动后臂油毡	<1>
31		EA9500B0100	CABLE BAND	线卡	<2>
32		21338405	NEEDLE BAR THREAD RACK	针杆	1
33		M13517B1200	NEEDLE 135X17 #120	机针	1

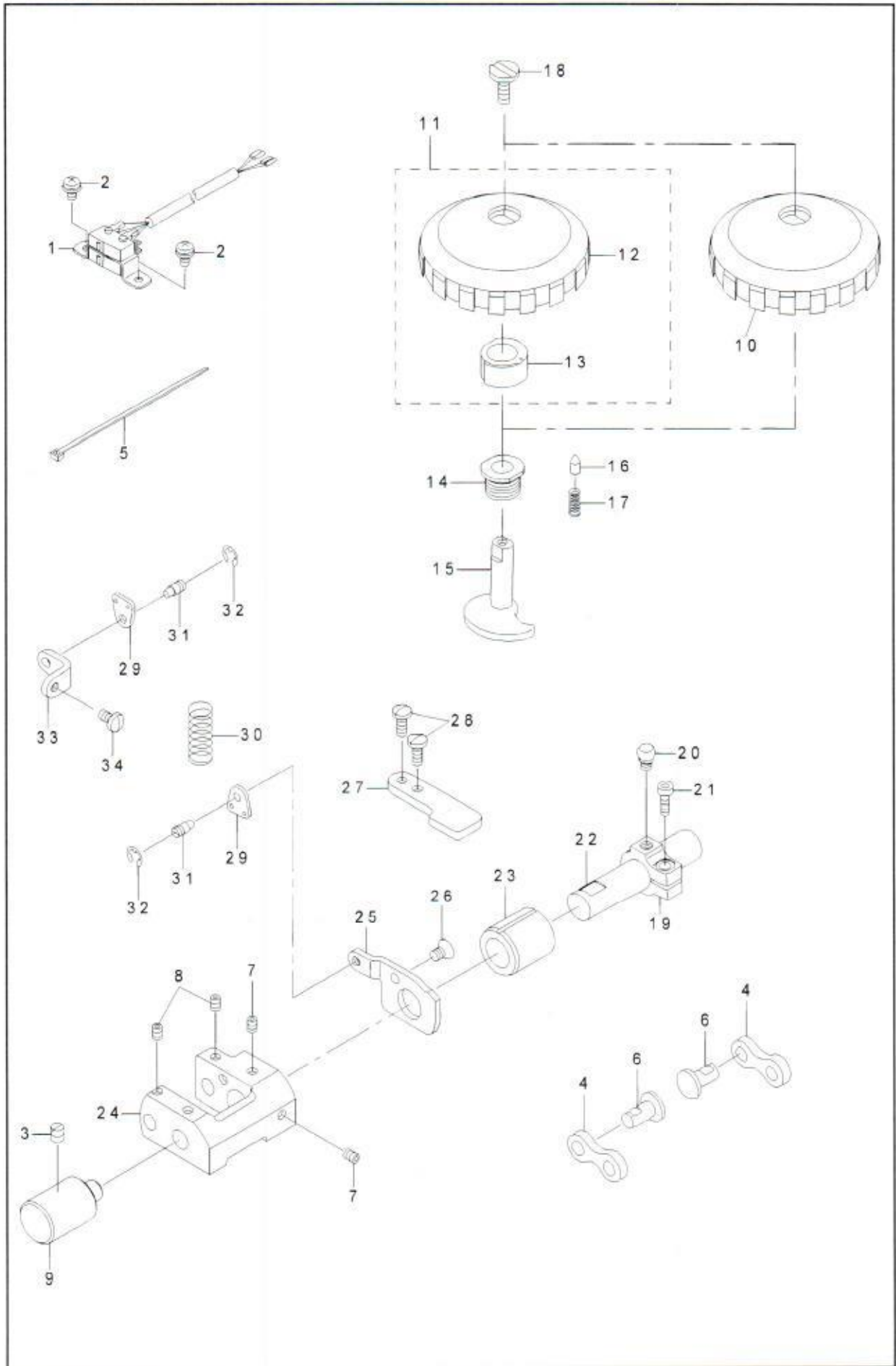
4. 上送料部件(1) Pressure adjusting & upper feed mechanism components(1)



4. 上送料部件(1) Pressure adjusting & upper feed mechanism components(1)

序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		21340401	UPPER FEED SHAFT	上送料轴	1
2		21340500	UPPER FEED FRONT ARM	上送料前臂	1
3		SS8660612TP	SCREW 1/4-40 L=6	螺钉1/4-40L=6	2
4		40039326	FRONT METAL	前轴套	1
5		21378302	FEED ROCK SHAFT METAL	送料轴套	1
6		22904155	MAIN SHAFT THRUST COLLAR ASM.	主轴止推紧圈组件	1
7		22904106	MAIN SHAFT THRUST COLLAR	主轴止推紧圈	<1>
8		SS8660610TP	SCREW 1/4-40 L=6	螺钉1/4-40L=6	<2>
9		SS8150710TP	SCREW 15/64-28 L=7	按钮卡轮支头螺钉	1
10		TA0750704RO	RUBBER PLUG	橡皮塞	1
11		40033027	UPPER FEED LINK ASM.	上送料连杆组件	1
12		40033026	UPPER FEED LINK	上送料连杆	<1>
13		21347109	FELT	油毡	<1>
14		EA9500B0000	CLIP CV-70S	线卡	<2>
15		CQ3000000FO	OIL FELT	油毡	<0.003>
16		40018339	SCREW	螺钉	1
17		B1414555000	SLIDE BLOCK	滑块	1
18		WP0501046SC	WASHER 5 X 13 X 1	垫圈5X13X1	1
19		40033029	TRIANGULAR LEVER ASM.	三角杠杆	1
20		SS7110510SP	SCREW 11/64-40 L=5	右推板托簧螺钉	1
21		B1414555000	SLIDE BLOCK	滑块	1
22		10509701	FELT	油毡	1
23		40018341	WALKING BAR DRIVING LINK	走步压杆驱动连杆	1
24		40033030	WALKING BAR A	走步压杆	1
25		B14670530AO	WALKING BAR ASM.	走步压杆组件	1
26		B1468053000	WALKING BAR SPRING	走步压杆簧	1
27		SS6151780SP	SCREW 15/64-28 L=17.0	螺钉15/64-28L=17.0	1
28		21406509	UPPER FEED GUIDE PLATE	送料导向板	1
29		26225201	ROLLER	滚柱	1
30		SS6151920SP	SCREW 15/64-28 L=19.0	螺钉15/64-28L=19.0	1
31		B1501241H00	PRESSER BAR	压杆	1
32		B1510155000	PRESSER BAR LOWER BUSHING	压杆下套	1
33		40018340	SCREW	螺钉	2
34		40033032	PRESSER BAR HOLDER A ASM.	压杆座组件	1
35		40033031	PRESSER BAR HOLDER A	压杆座	<1>
36		SS7110910TP	SCREW 11/64-40 L=8.5	螺钉11/64-40 L=8.5	<1>
37		21340906	PRESSER ADJUSTING SCREW	压力调节螺钉	1
38		22907604	PRESSER SPRING REGULATOR NUT	压力调节螺母	1
39		B1502246000	PRESSER SPRING	压簧	1
40		SD0800481SP	HINGE SCREW D=8 H=4.9	螺钉D=8 H=4.9	1
41		21341151	THREAD RELEASE HOLDING PLATE	松线支持板	1
42		B1462053000	THREAD RELEASE SPRING	松线簧	1
43		21406103	PRESSER LIFTER LEVER	抬压扳手	1
44		21406608	GUIDE PLATE SPACER	导向板垫	1
45		SS6090910TP	SCREW 9/64-40 L=9	螺钉9/64-40L=9	1
46		SS7150740SP	SCREW 15/64-28 L=7	螺钉15/64-28L=7	1
47		40075553	ECCENTRIC ROD(SET)	送料偏心凸轮组件	1
48		SS8660810TP	SCREW 1/4-40 L=8	螺钉1/4-40 L=8	<2>
49		10713758	UPPER FEED CAM ROD ASM.	送料连杆	<1>
50		10713600	UPPER FEED CUM	偏心凸轮	<1>
51		21048707	HINGE SCREW	压脚交替提升曲柄连杆螺钉	1
52		RE0800000K0	E-SHAPED SNAP RING (8MM)	压脚交替提升曲柄连杆挡圈	1
53		21340302	UPPER FEED REAR ARM (B)	压脚交替提升曲柄	1
54		SM6052002TP	SCREW M5 L=20	压脚交替提升曲柄并紧螺钉	1
55		CQ252000000	OIL WICK	油线	0.02
56		B1510141H00	PRESSER SPRING	压簧	1
57		10713808	CONNECTION LINK PIN B	压脚交替提长连杆销	1
58		21340005	UPPER FEED LINK (B)	压脚交替提升曲柄连杆	1

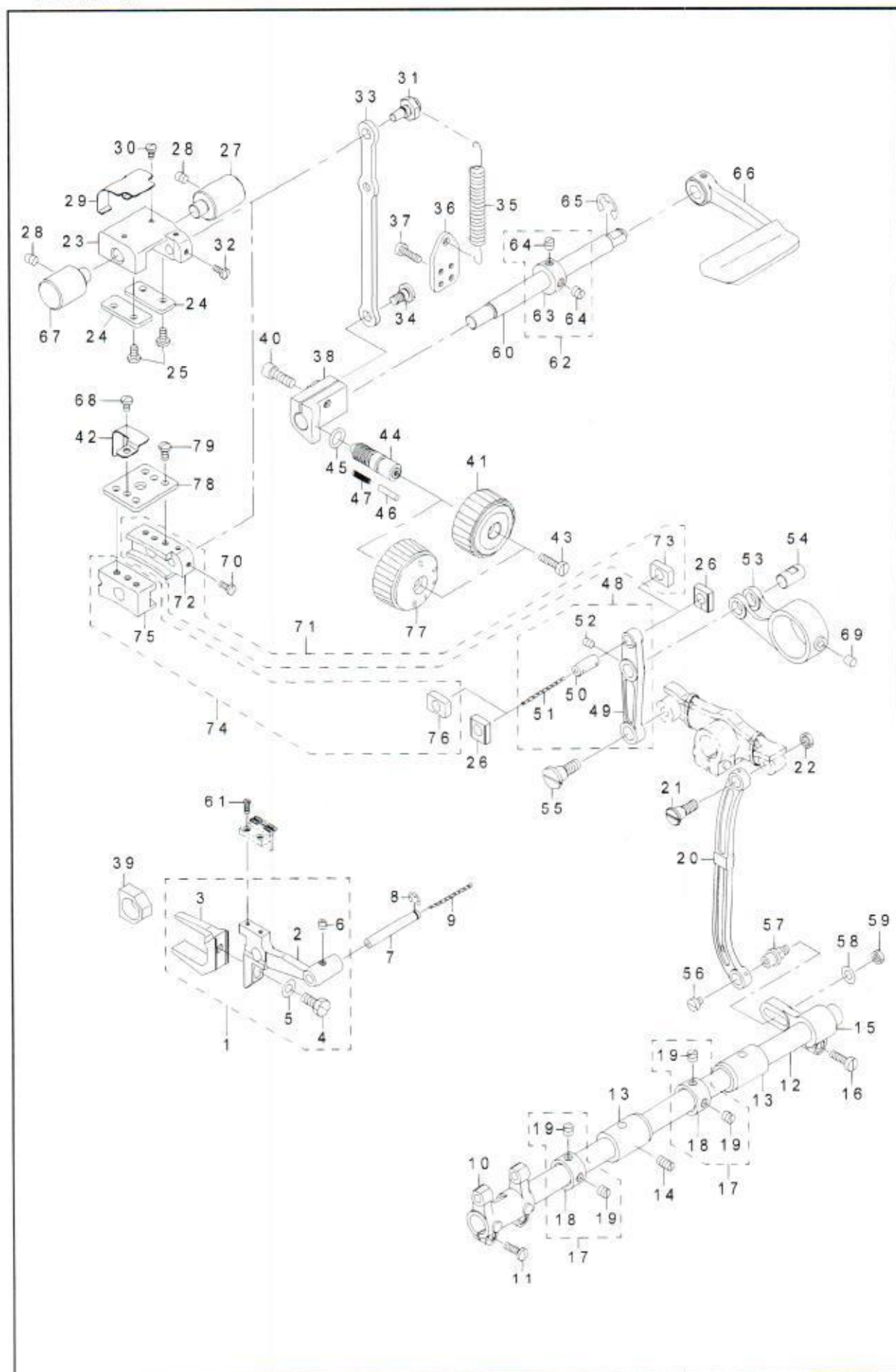
5. 上送料部件(2) Pressure adjusting & upper feed mechanism components(2)



5. 上送料部件(2) Pressure adjusting & upper feed mechanism components(2)

序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		40024852	VERTICAL DETECTOR SWITCH ASM.	开关座	1
2		SL4040881SC	SCREW M4 L=8	螺钉	2
3		SS8150710SP	SCREW 15/64-28 L=7	螺钉	1
4		10714509	CONNECTION LINK B	曲柄短连杆	2
5		EA9500B0100	CABLE BAND	线卡	1
6		10714608	CONNECTION LINK B SUPPORT PIN	曲柄短连杆销	2
7		SM8050602TP	SCREW M5 L=6	螺钉	2
8		SM8050602TP	SCREW M5 L=6	螺钉	2
9		21337803	FEED ADJUSTING BASE SUPPORT	送料调节座支架	1
10		10774305	VERTICAL DIAL	压脚胶替提升调节盘	1
11		10774354	UPPER AND LOWER DIAL ASM.	压脚胶替提升调节盘组件	1
12		10774305	VERTICAL DIAL	压脚胶替提升调节盘	<1>
13		10774404	VERTICAL CAM	凸轮	<1>
14		10715100	VERTICAL DIAL SHAFT BUSHING	压脚调节凸轮轴套	1
15		10715001	VERTICAL ADJUSTING CAM	压脚交替提升调节凸轮	1
16		10715704	VERTICAL DIAL PIN	压脚交替提升调节盘止动销	1
17		B152652700G	SPRING	压脚交替提升调节盘止动弹簧	1
18		SS6110630TP	SCREW 11/64-40 L=6	压脚交替提升调节凸轮螺钉	1
19		21341607	VERTICAL ADJUSTING ARM	压脚交替提升调节曲柄	1
20		10715308	PIN	压脚交替提升调节曲柄销	1
21		SM6051402TP	SCREW M5X0.8 L=14	压脚交替提升调节曲柄螺钉	1
22		21341508	VERTICAL CHANGE BASE SHAFT	压脚交替提升轴	1
23		10718203	FEED SHAFT FRONT METAL	压脚交替提升轴套	1
24		10714202	VERTICAL CHANGE BELT	压脚交替提升变动曲柄	1
25		21339601	UPPER FEED STOPPER PLATE (A)	支架板	1
26		SM1050801SR	SCREW M5 L=8	上送料弹簧支架螺钉	1
27		21339700	UPPER FEED STOPPER PLATE (B)	上送料止动板B	1
28		SS7111120TP	SCREW	螺钉	2
29		10713501	SPRING HOOK	曲柄拉簧支板	2
30		10716504	VERTICAL SHAFT SPRING	曲柄拉簧	1
31		B3416552000	CONNECTING ROD HINGE SCREW	簧板连接铰接螺栓	2
32		RE0500000K0	E-RING	开口挡圈	2
33		21339809	UPPER FEED DOG SPRING HOOK	上送料限位簧板	1
34		SS7110830SP	SCREW 11/64-40 L=7.5	螺钉11/64-40 L=8.5	1

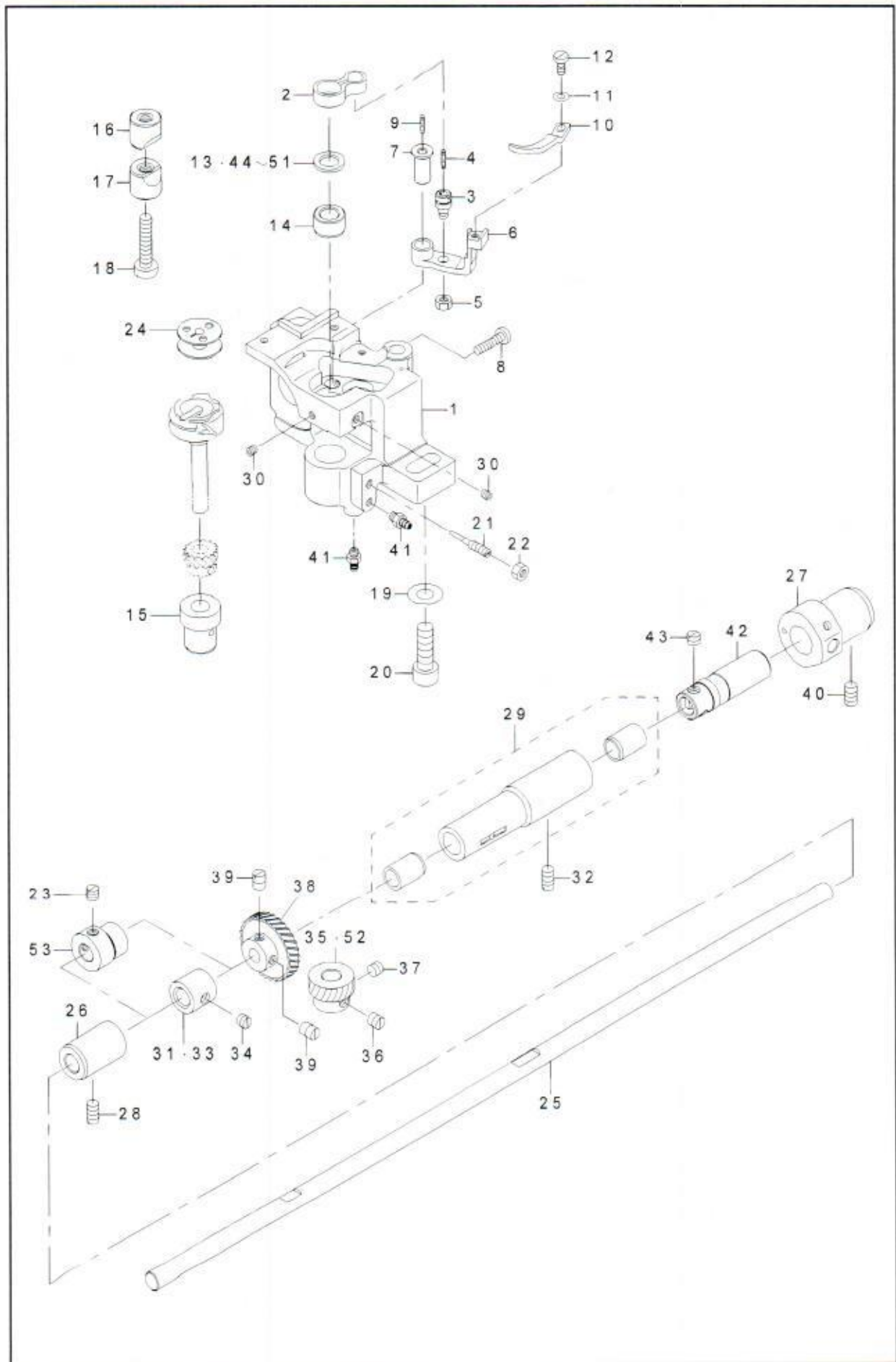
6. 送料部件 Feed mechanism components



6. 送料部件 Feed mechanism components

序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		21336060	FEED BASE ASM. (B)	牙架组件	1
2		21336003	FEED BASE	牙架	<1>
3		10107902	FEED BAR FORK	抬牙叉	<1>
4		SS9151440CP	SCREW 15/64-28 L=14	抬牙叉螺钉	<1>
5		WP0621016SD	WASHER 6. 2X13X1	抬牙叉垫圈	<1>
6		SM8050502TP	SCREW M5 L=5	螺钉 M5L=5	<1>
7		B1604012000A	FEED BAR SHAFT	送料座轴	1
8		RE0500711KP	SNAP RING 5	开口挡圈5	1
9		CQ202000000	OIL WICK	油线	0.14
10		21364104	FEED ROCKER	送料摇臂	1
11		SS7111410SP	SCREW 11/64-40 L=14	螺钉	2
12		22609408	FEED ROCK SHAFT	送料摇臂轴	1
13		21378302	FEED ROCK SHAFT METAL	送料轴套	2
14		SS8151150TP	SCREW 15/64-28 L=10.5	螺钉15/64-28L=10.5	1
15		B3025141H00A	CONNECTING ARM	送步轴驱动曲柄	1
16		SS6121610TP	SCREW 3/16-28 L=15.5	螺钉3/16-28L=15.5	1
17		22904155	MAIN SHAFT THRUST COLLAR ASM.	主轴止推紧圈组件	2
18		22904106	MAIN SHAFT THRUST COLLAR	主轴止推紧圈	<1>
19		SS8660610TP	SCREW 1/4-40 L=6	螺钉1/4-40L=6	<2>
20		10205201	NEEDLE BAR FRAME ROD	针杆连杆	1
21		SD0900701TP	HINGE SCREW D=9 H=7	螺钉D=9 H=7	1
22		NS6680320SP	NUT 9/32-28	螺母 9/32-28	1
23		21337506	FEED ADJUSTING BASE	送料调节座	1
24		21337704	FEED ADJUSTING BASE COVER	送料调节座盖板	2
25		SS7110910TP	SCREW 11/64-40 L=8.5	螺钉11/64-40 L=8.5	4
26		21337407	SQUARE BLOCK	方滑块	2
27		21337803	FEED ADJUSTING BASE SUPPORT	送料调节座支架	1
28		SS8150822TP	SCREW 15/64-28 L=8	螺钉15/64-28 L=8	2
29		21338306	FELT SUPPORT	毛毡座	1
30		SS7090610SP	SCREW 9/64-40 L=6	螺钉	2
31		21337902	ECCENTRIC PIN	偏心销	1
32		SS7090910TP	SCREW 9/64-40 L=8.5	螺钉	2
33		21337308	FEED ADJUSTING ROD	送料调节连杆	1
34		SD0800402TP	HINGE SCREW D=8 H=4	螺钉 D=8 H=4	1
35		21337605	SPRING	弹簧	1
36		40019926	SPRING HOOK	弹簧钩板	1
37		SS6111610SP	SCREW 11/64-40 L=16	安装座螺钉	2
38		21337209	FEED ADJUSTING A	送料调节块A	1
39		B1610512000	FEED DRIVING SLIDE BLOCK	送布凸轮滑块	1
40		SM6061802TP	SCREW M6 L=18	螺钉M6 L=18	1
41		21336805	FEED DIAL A	送料刻度盘	1
42		40038712	FELT HOLDER	毛毡座	1
43		SS6121860SP	SCREW 3/16-28 L=18	螺钉3/16-28L=18	1
44		22911804	FEED REGULATOR SCREW	送布凸轮螺钉	1
45		RO092270200	RUBBER RING	橡胶圈	1
46		22912000	FEED REGULATOR PIN	销	1
47		22912109	FEED REGULATOR PIN SPRING	送料调节器销弹簧	1
48		21336656	FEED LINK ASM.	送料连杆组件	1
49		21336607	FEED LINK	送料连杆	<1>
50		40009103	CONNECTING FORKED LINK PIN	叉形连杆销	<1>
51		CQ202000000	OIL WICK	油线	<0.04>
52		SM8050612TP	SCREW M5X6	滑块轴	<1>
53		21336706	FEED ROD A	送料连杆A	1
54		21378906	FEED LINK PIN	送料连杆销	1
55		SD1000801SH	HINGE SCREW D=10 H=8	螺钉D=10 H=8	1
56		SS6110520TP	SCREW 11/64-40 L=4.5	螺钉	1
57		21378203	FEED ROCK SHAFT HINGE SCREW	送步驱动曲柄连杆铰链螺钉	1
58		WP0650876SD	WASHER 6. 5X13X0.8	垫圈	1
59		NS6150310SP	NUT 15/64-28	螺母15/64-28	1
60		21336300	BACKWARD FEED LEVER SHAFT	反向送料连杆轴	1
61		B1611055000	SCREW FEED ROCK SHAF	送步牙螺钉	2
62		CS1201010SH	THRUST COLLAR ASM. D=12 W=10	止推紧圈组件D=12 W=10	1
63		CS1201011SH	THRUST COLLAR D=12 W=10	止推紧圈D=12 W=10	<1>
64		SS8660610TP	SCREW 1/4-40 L=6	螺钉1/4-40L=6	<2>
65		RE0900000K0	E-RING 9	开口挡圈9	1
66		21388004	REVERSE FEED ROCK SHAFT	倒缝控制杆	1
67		21430400	FEED ADJUSTER SUPPORT	送料调节座支架	1
68		SS7110710SP	SCREW 11/64-40 L=7	螺钉11/64-40 L=7	1
69		21387402	FELT	油毡	1
70		SS7090910TP	SCREW 9/64-40 L=8.5	螺钉	2
71		40081970	FEED ADJUSTING BASE	送料调节座	1
72		21407200	FEED ADJUSTING BASE	送料调节右座	<1>
73		21407309	SQUARE BLOCK	滑块(带圆弧)	<1>
74		40081969	FEED ADJUSTING BASE B SET		1
75		40038711	FEED ADJUSTING BASE B	送料调节左座	<1>
76		21407309	SQUARE BLOCK	滑块(带圆弧)	<1>
77		40049663	FEED DIAL (P=7) ASM.	送料调节	1
78		21407408	FITTING PLATE	送料调节座连接板	1
79		SS7110910TP	SCREW 11/64-40 L=8.5	螺钉11/64-40 L=8.5	4

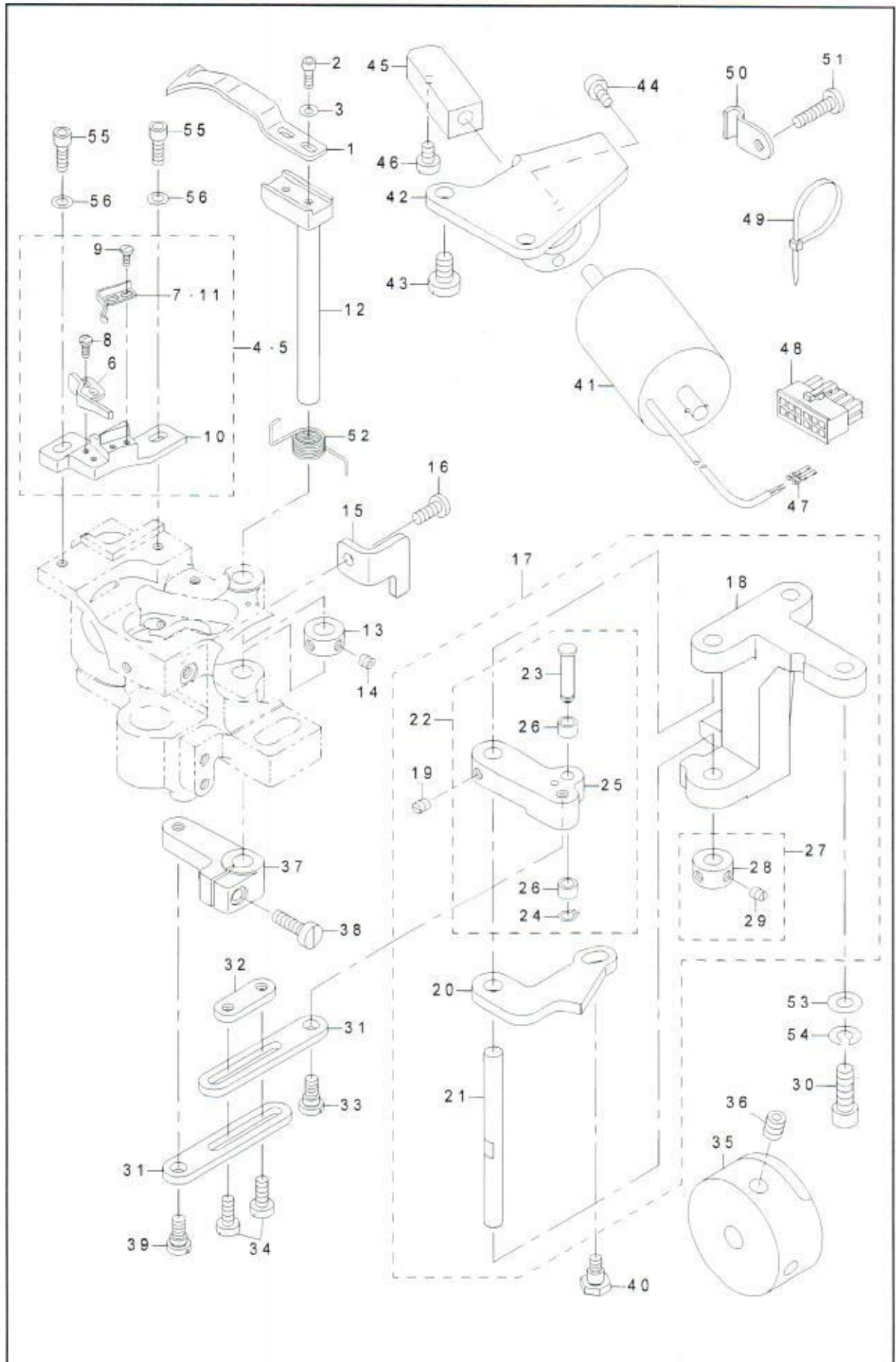
7. 下轴、旋梭轴部件 Hook shaft & lower shaft components



7. 下轴、旋梭轴部件 Hook shaft & lower shaft components

序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		21390000	HOOK SHAFT BASE (RIGHT)	右旋梭架	1
2		21334909	INNER HOOK GUIDE LINK	分线勾连杆	1
3		B1821051000	CRANK SCREW STUD	分线座滚柱螺钉	1
4		CQ202000000	OIL WICK	油线	0.01
5		NS6110420SP	NUT 11/64-40	分线座滚柱螺母	1
6		21335500	GUIDE ARM (FOR THREAD CUTTING)	分线勾座	1
7		21335708	INNER HOOK GUIDE ARM SHAFT	分线勾连杆销	1
8		SS7111810TP	SCREW 11/64-40 L=18	分线座铰链轴支紧螺钉	1
9		CQ202000000	OIL WICK	油线	0.01
10		21335807	INNER HOOK GUIDE	分线勾	1
11		WP0371016SD	WASHER 3.7X8X1	分线勾垫片	1
12		SS6090810SP	SCREW 9/64-40 L=7.5	分线勾螺钉	1
13		10111102	THRUST WASHER 1.3	旋梭架上套垫圈	1
14		21378401	HOOK SHAFT UPPER METAL	旋梭架上套	1
15		21334701	HOOK SHAFT LOWER METAL	旋梭架下套	1
16		10109908	SADDLE INSTALLING BLOCK UPPER	旋梭架紧固套2	1
17		10112407	SADDLE INSTALLING BLOCK LOWER	旋梭架紧固套1	1
18		SS6153040SP	SCREW 15/64-28 L=30	螺钉15/64-28 L=30	1
19		WP0850002SP	WASHER 8.5X18X1.6	梭架固定垫片	1
20		SM6082502TP	SCREW M8 L=25	梭架固定螺钉	1
21		B1834512000A	OIL ADJUSTING SCREW	调节螺钉	1
22		NS6110420SP	NUT 11/64-40	分线座滚柱螺母	1
23		SS8150710TP	SCREW 15/64-28 L=7	按钮卡轮支头螺钉	2
24		21334800	ALUMINUM BOBBIN WITH KNURL	梭芯	1
25		21333604	LOWER SHAFT	单针下轴	1
26		21427307	LOWER SHAFT METAL REAR	下轴后套	1
27		22611701	PLUNGER BUSHING B	下轴右套	1
28		SS8151150TP	SCREW 15/64-28 L=10.5	螺钉15/64-28L=10.5	1
29		B18035150A0	BUSHING ASM. INTERMEDIATE	梭架右套组件	1
30		SS8110422TP	SCREW 11/64-40 L=4	旋梭轴套支头螺钉	2
31		B1840051000	FEED DRIVING ECCENTRIC	轴套	1
32		SS8151150TP	SCREW 15/64-28 L=10.5	螺钉15/64-28L=10.5	1
33		21378104	VERTICAL FEED CAM	抬牙凸轮	1
34		SS8150510TP	SCREW 15/64-28 L=4.7	抬牙凸轮螺钉	1
35		B1817051000	HOOK DRIVING SHAFT GEAR SMALL	螺旋小齿轮	1
36		SS8660670SP	SCREW 1/4-40 L=6.1	旋梭齿轮定位螺钉	1
37		SS8660530TP	SCREW 1/4-40 L=4.5	按钮卡轮支头螺钉	1
38		B1816051000	HOOK DRIVING SHAFT GEAR LARGE	螺旋大齿轮	1
39		SS8660810TP	SCREW 1/4-40 L=8	螺钉1/4-40 L=8	2
40		SS8151150SP	SCREW 15/64-28 L=10.5	支头螺钉	1
41		SQ1110401MZ	CONNECTING SCREW	油管连接小螺钉	2
42		22611909	OIL PUMP SHAFT	油泵轴	1
43		SS8660530TP	SCREW 1/4-40 L=4.5	按钮卡轮支头螺钉	3
44		10112704	THRUST WASHER 1.8	旋梭架上套垫圈	1
45		10109700	THRUST WASHER A	旋梭架上套垫圈	1
46		10109809	THRUST WASHER B	旋梭架上套垫圈	1
47		10110906	BUSHING THRUST 1.1	旋梭架上套垫圈	1
48		10111003	THRUST WASHER 1.2	旋梭架上套垫圈	1
49		10111201	THRUST WASHER F	旋梭架上套垫圈	1
50		10112506	THRUST WASHER 1.6	旋梭架上套垫圈	1
51		10112605	THRUST WASHER 1.7	旋梭架上套垫圈	1
52		40042611	HOOK DRIVING SHAFT GEAR	螺旋小齿轮	1
53		23024409	VERTICAL FEED CAM (1.5)	轴套	1

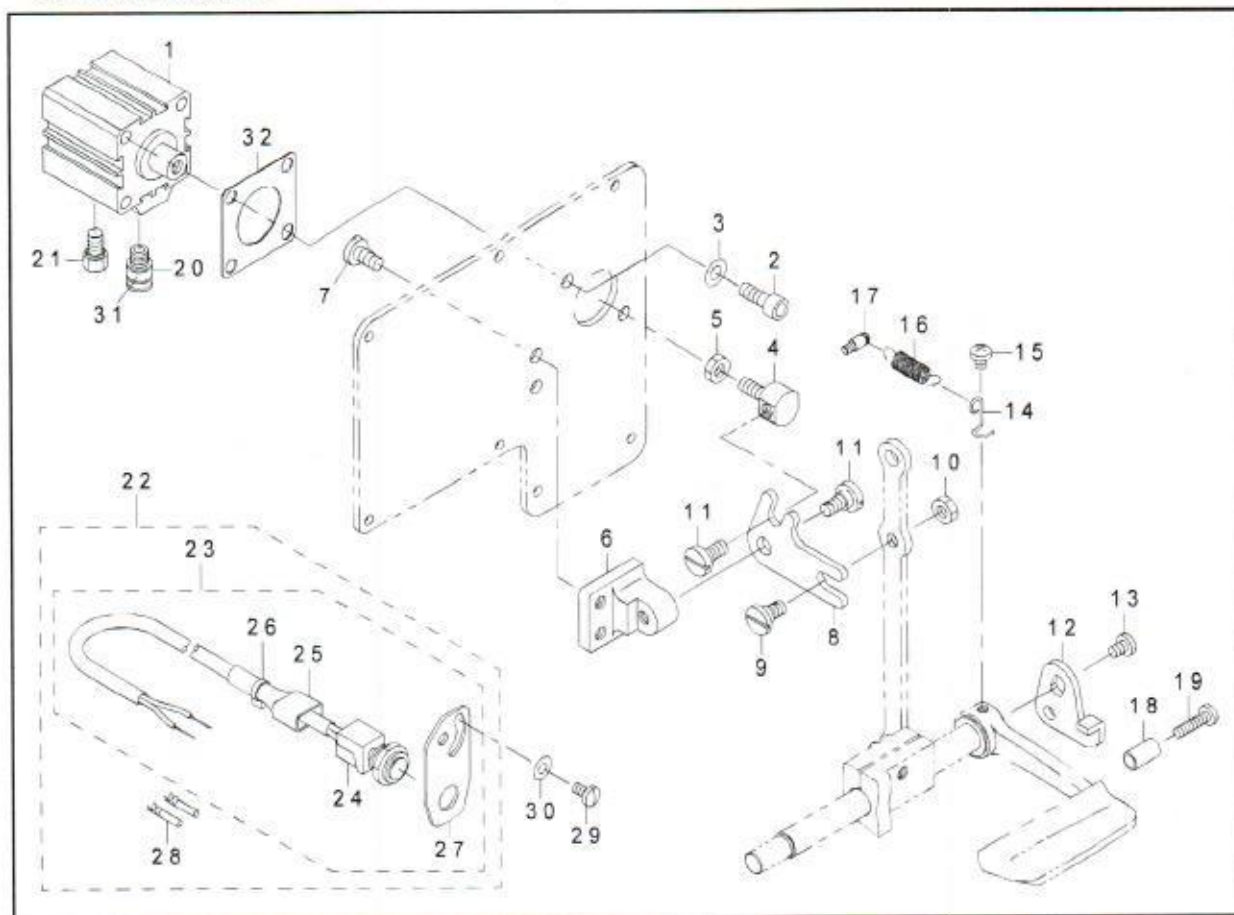
8.切线部件 Thread cutting components



8.切线部件 Thread cutting components

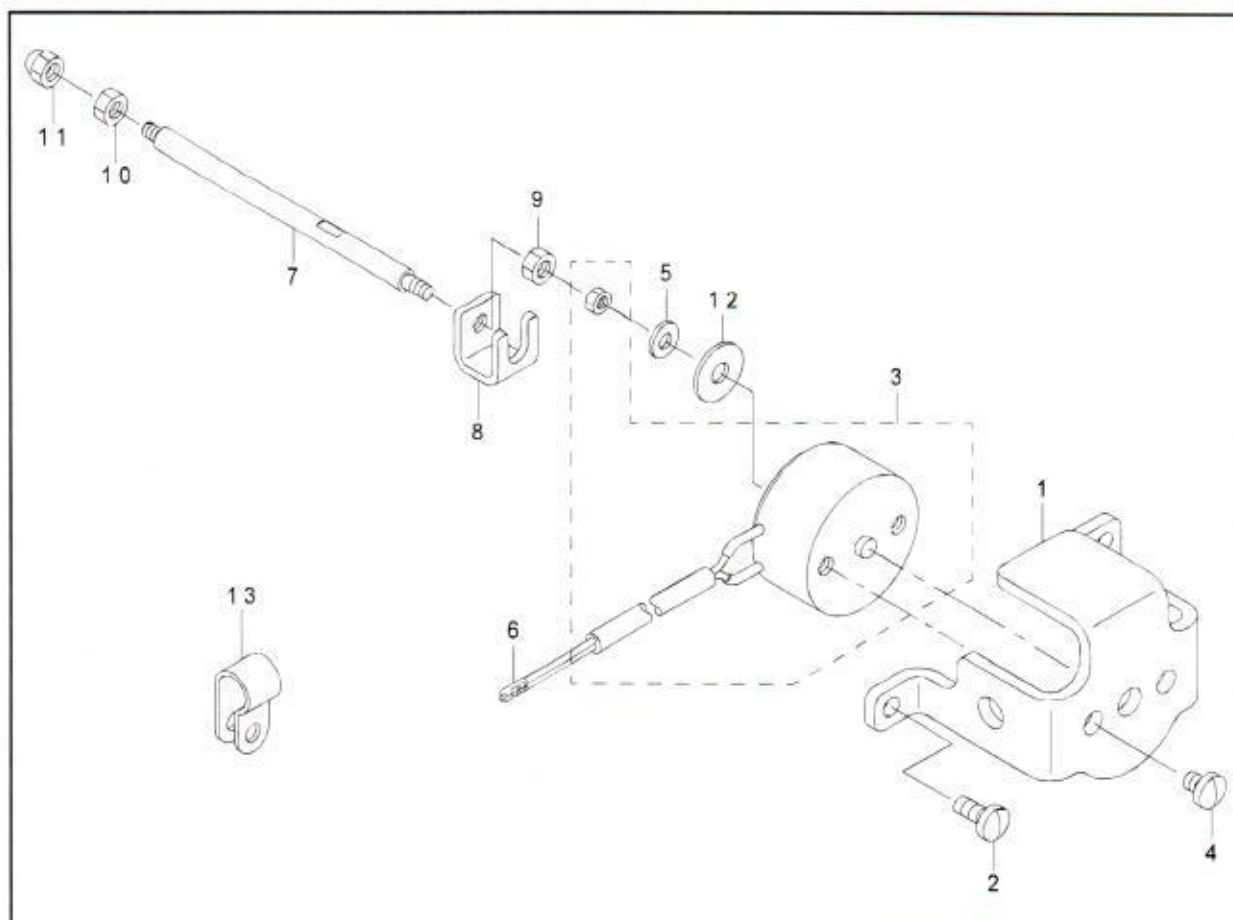
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1		21389200	MOVING KNIFE	动刀	1
2		SM6030802TP	SCREW M3X0.5 L=8	动刀螺钉	2
3		WP0320501SC	WASHER M3	平垫	2
4		21389556	FIXING KNIFE BASE (RIGHT) ASM.	定刀安装座组件(右)	1
5		40062181	FIXING KNIFE BASE (RIGHT) ASM.	定刀安装座组件(右)	1
6		21389309	FIXING KNIFE	定刀	<1>
7		21389408	CLAMP SPRING	支架簧	<1>
8		SS7060610SP	SCREW 3/32-56 L=5.5	定刀螺钉	<2>
9		SS7060610SP	SCREW 3/32-56 L=5.5	定刀螺钉	<2>
10		21389507	FIXED KNIFE BASE (RIGHT)	定刀架安装座(右)	<1>
11		40062182	CLAMP SPRING	定刀架安装座(左)	<1>
12		21354907	MOVING KNIFE SHAFT	活动刀架	1
13		CS0790731SH	THRUST COLLAR	活动刀架推力紧圈	1
14		SS8110422TP	SCREW 11/64-40 L=4	旋梭轴套支头螺钉	2
15		21354501	THREAD CUTTING STOPPER (RIGHT)	动力限位板(右)	1
16		SS7111120SP	SCREW 11/64-40 L=10.5	动力限位板(右)螺钉	1
17		21353750	VERTICAL FITTING BASIS ASM.	剪刀驱动曲柄座组件	1
18		21353701	VERTICAL FITTING BASIS	剪刀驱动曲柄座	<1>
19		SS8110510SP	SCREW 11/64-40 L=5	剪刀驱动曲柄螺钉	<2>
20		21354006	THREAD CUTTING DRIVING PLATE	剪线驱动连杆	<1>
21		10116804	SHAFT	剪线支架轴	<1>
22		21353859	THREAD CUTTING ROLLER ARM	剪刀驱动曲柄组件	<1>
23		21353909	CAM ROLLER SHAFT	剪线凸轮滚子销钉	<1>
24		D2430555B00	SNAP RING	剪线凸轮滚子销钉挡圈	<1>
25		21353800	THREAD CUTTING ROLLER ARM	剪线驱动曲柄	<1>
26		D2427555B00B	CAM ROLLER	剪线凸轮滚子	<2>
27		CS070081BSH	THRUST COLLAR ASM. D=7 W=8	剪线支架轴轴套组件	<1>
28		CS0700811SH	THRUST COLLAR D=7 W=8	剪线支架轴轴套	<1>
29		SS8110510SP	SCREW 11/64-40 L=5	剪刀驱动曲柄螺钉	<2>
30		SS6151812TP	SCREW 15/64-28 L=18	剪线驱动曲柄座螺钉	2
31		21354105	CONNECTING PLATE	剪线调节短连杆	2
32		21354204	STOPPING PLATE	剪线调节连杆锁紧板	1
33		SD0640325SP	HINGE SCREW	剪线调节短连杆连接螺钉	1
34		SS6111140SP	SCREW 11/64-40 L=11	接地用螺钉	2
35		21389911	THREAD TRIMMER CAM	切线凸轮	1
36		SS8660612TP	SCREW 1/4-40 L=6	螺钉1/4-40L=6	2
37		21389705	ROCKING ARM (RIGHT)	活动刀架传动曲柄(右)	1
38		SS6121610TP	SCREW 3/16-28 L=15.5	螺钉3/16-28L=15.5	1
39		SD0640325SP	HINGE SCREW	剪线调节短连杆连接螺钉	1
40		SD0610482SP	HINGE SCREW D=6.35 H=4.8	剪线驱动连杆螺钉	1
41		21355102	THREAD CUTTING SOLENOID	剪线电磁铁	1
42		21354600	SOLENOID FITTING PLATE	剪线电磁铁座	1
43		SS6151040SP	SCREW 15/64-28 L=10	剪线电磁铁座螺钉	2
44		SM6040802TP	SCREW M4X0.7 L=8	剪线电磁铁螺钉	2
45		21354709	SOLENOID CONNECTING PLATE	剪线驱动连杆连接块	1
46		SS6110710TP	SCREW 11/64-40 L=6.5	内压脚螺钉	2
47		HK03464000A	TERMINAL FEMALE	接线用端子	2
48		HK034610120	HOUSING 12P	剪线电磁铁接线柱套	1
49		EA9500B0100	CABLE BAND	线卡	1
50		22620801	PIPE HOLDER	管状压线板	1
51		SS7111810TP	SCREW 11/64-40 L=18	分线座铰链轴支紧螺钉	1
52		21390208	MAINTENANCE SPRING	扭簧	1
53		WP0621016SD	WASHER 6.2X13X1	抬牙叉垫圈	2
54		WS0610002KP	SPRING WASHER	连接器	2
55		SM6041202TP	SCREW M4X0.7 L=12	定刀架安装座螺钉	2
56		WP0430800SC	WASHER M4	定刀架安装座螺钉垫圈	2

9. 自动倒缝部件 Automatic back components



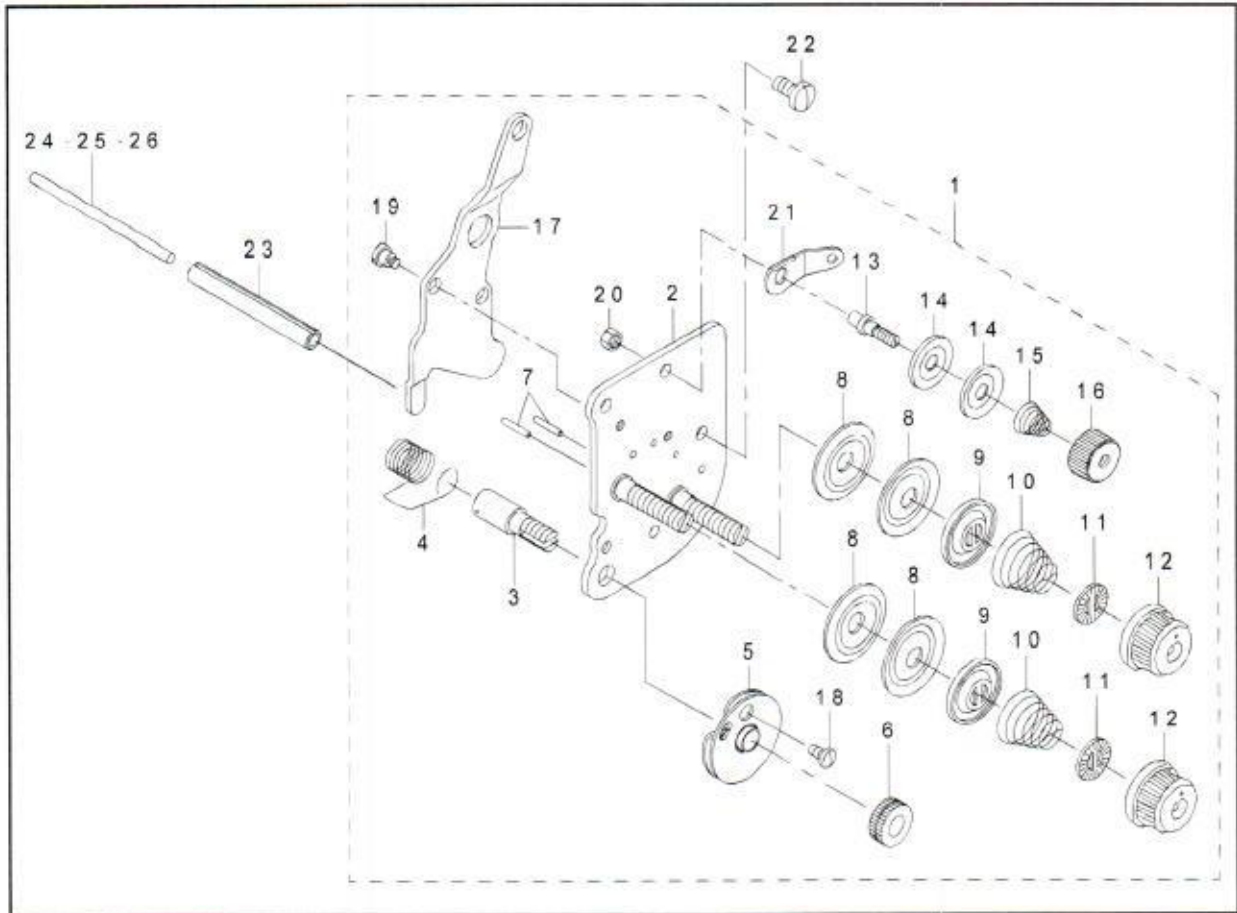
序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		PA320150200	JIG CYLINDER	倒缝气缸	1
2		SM6061602TP	SCREW M6 L=16	气缸安装螺钉	2
3		WP0641601SD	WASHER M6	垫圈	2
4		21348602	CYLINDER CONNECTING SCREW	倒顺针距气缸传动螺钉	1
5		NM6060003SC	NUT M6	螺母	1
6		21348503	FITTING BASE	倒缝拨叉座	1
7		SS7151210SP	SCREW 15/64-28 L=12	倒缝拨叉座螺钉	2
8		21348701	BACKWARD FEED LINK	倒缝针距拨叉	1
9		SD0800402TP	HINGE SCREW D=8 H=4	螺钉 D=8 H=4	1
10		NS6150430SP	NUT 15/64-28	螺母	1
11		SD0800352SP	HINGE SCREW D=8 H=3.5	倒缝针距拨叉传动螺钉	2
12		22656102	REVERSE FEED LINK (1)	倒缝扳手连接板	1
13		SS7120760SP	SCREW 3/16-28 L=7.0	下轴轴承固定螺钉	1
14		22656003	SPRING SUSPENSION	倒缝扳手拉簧勾	1
15		SS4120615SP	SCREW 3/16-28 L=6	拉簧勾螺钉	1
16		26226209	SPRING	弹簧	1
17		10120004	SPRING SUSPENSION	拉簧螺钉	1
18		22952501	BACK LEVER STOPPER	限位套	1
19		SS7111810SP	SCREW 11/64-40 L=18	螺钉	1
20		PJ301065104	HALF UNION	直接头	1
21		PX015101000	MUFFLER	消音器	1
22		40056366	BT SWITCH C ASM.	按钮组件	1
23		40056365	BT SWITCH B ASM.	按钮A	<1>
24		40056364	BT SWITCH A ASM.	按钮B	<1>
25		GTS01037000	CONNECTOR COVER	胶套	<1>
26		EA9500B0100	CABLE BAND	线卡	<1>
27		21388608	CABLE BAND	线卡	<1>
28		HK03464000A	TERMINAL FEMALE	接线用端子	<2>
29		SS7110840SP	SCREW 11/64-40 L=7.8	螺钉	2
30		WP0501016SD	WASHER 5X10.5X1	平垫	2
31		HX002950000	WIRE MARK(1)	消声器	1
32		21349105	CYLINDER PACKING	防油垫	1

10. 松线部件 Thread release components



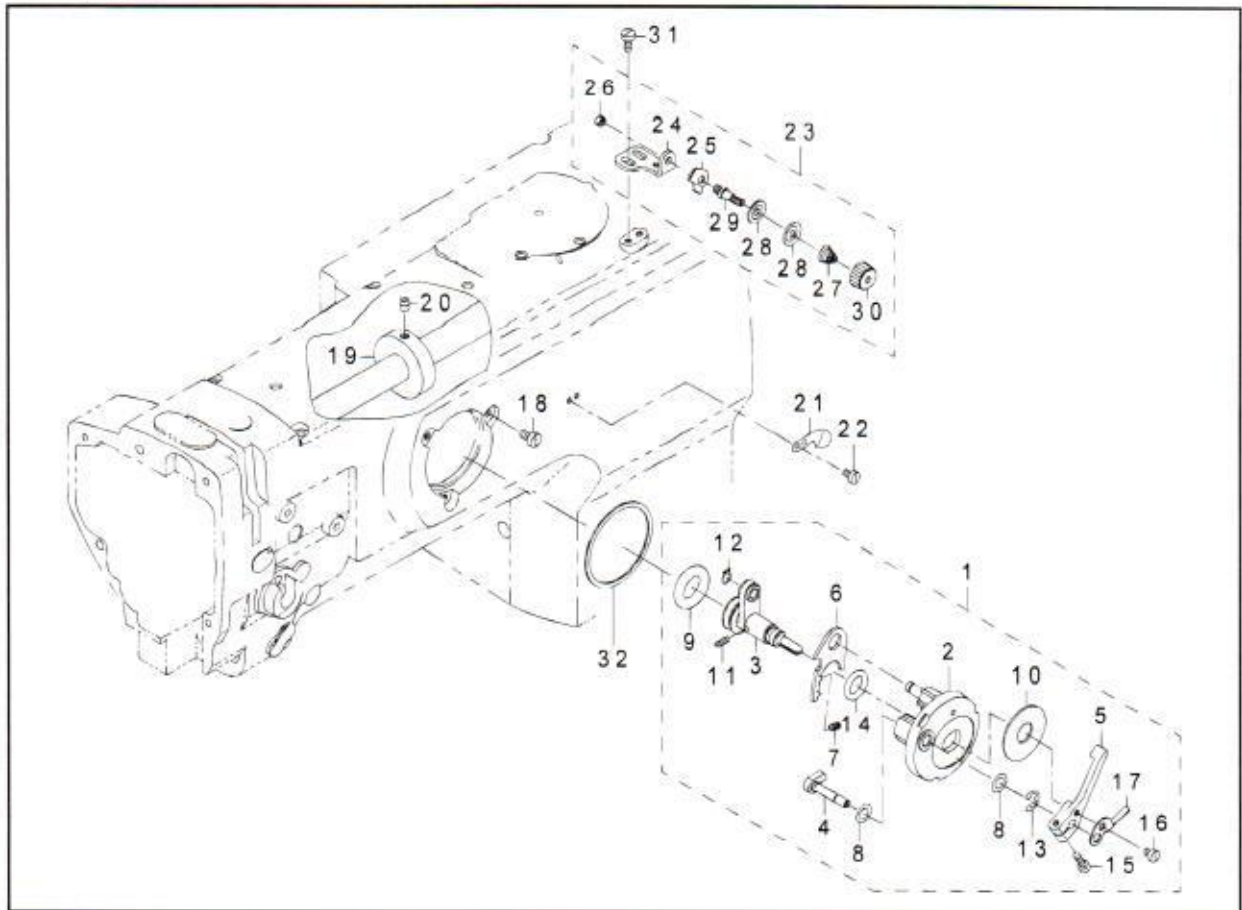
序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		21441407	SOLENOID INSTALLING PLATE	挺线电磁铁安装座	1
2		SS7110910TP	SCREW 11/64-40 L=8.5	螺钉11/64-40 L=8.5	2
3		21363106	TENSION RELEASE SOLENOID	挺线电磁铁	1
4		SS7110570SP	SCREW 11/64-40 L=4.8	挺线电磁铁安装螺钉	2
5		40062388	WASHER	小垫圈	1
6		HK03464000B	PIN CONTACT	挺线电磁铁连接杆	2
7		21441209	TENSION RELEASE BAR	松线螺杆	1
8		21441308	COUPLING	松线螺杆连接架	1
9		NM6040001SN	NUT M4X0.7	GB/T6170-2000松线螺杆螺母	1
10		NM6040001SN	NUT M4X0.7	GB/T6170-2000松线螺杆螺母	1
11		NM7040062SB	NUT M4	GB/T6170-2000松线螺杆圆头螺母	1
12		WP0501046SC	WASHER 5 X 13 X 1	垫圈5X13X1	1
13		HX00123000A	CABLE CLIP	电线固定夹	1

11. 夹线调节部件 Thread tension components



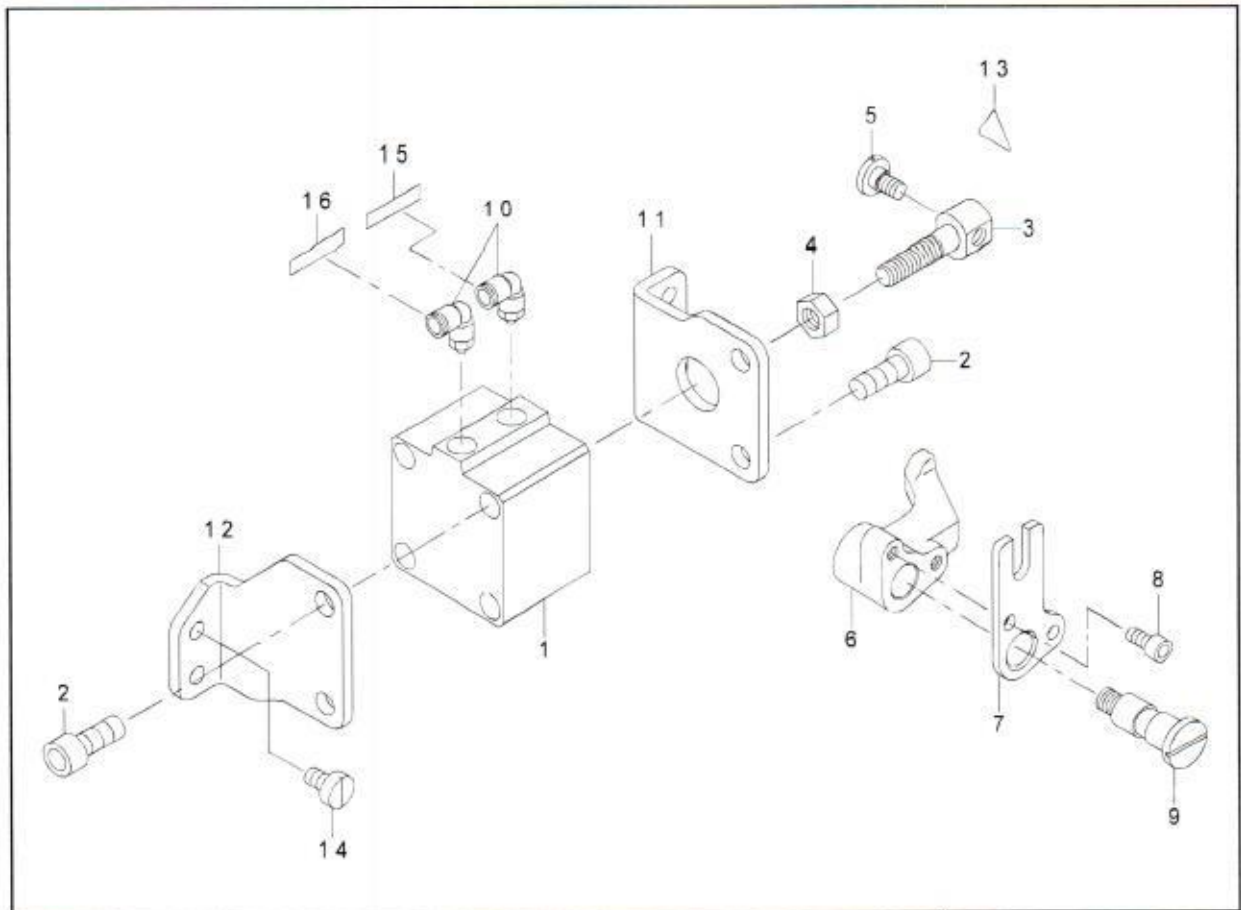
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1		21441068	THREAD TENSION ASM.	夹线器组件	1
2		21441050	TENSION POST COMPL.	夹线器底板	<1>
3		10320109	SCREW STUD	螺钉	<1>
4		B3128520000	TENSION SPRING	挑线簧	<1>
5		B31375270A0	TAKE-UP SPRING GUIDE ASM.	过线轮	<1>
6		B3125012000	THREAD TENSION NUT	螺母	<1>
7		22618201	TENSION RELEASE PIN A	松线杆	<2>
8		B3126012000	THREAD TENSION DISK	夹线板	<4>
9		22617906	THREAD TENSION DISK PRESSER	松线板	<2>
10		B3129526000	TENSION SPRING (1. 2)	压力簧	<2>
11		B3120125000	ROTATING STOPPER	止动垫片	<2>
12		11956802	THREAD TENSION KNOB BLUE	螺母	<2>
13		10124204	THREAD TENSION POST A	螺钉	<1>
14		10741106	FIRST THREAD TENSION PLATE	夹线板	<2>
15		11045101	THREAD TENSION SPRING	压力簧	<1>
16		11072402	THREAD TENSION NUT	螺母	<1>
17		21441100	TENSION RELEASE PLATE	松线板	<1>
18		SS4080610SP	SCREW 1/8-44 L=6.4	螺钉	<1>
19		SD0470281SP	HINGE SCREW D=4.7 H=2.8	螺钉	<2>
20		NS6110310SP	NUT 11/64-40	螺母11/64-40	<1>
21		D3162555B00	THREAD GUIDE	过线钩	<1>
22		SS7110910TP	SCREW 11/64-40 L=8.5	螺钉11/64-40 L=8.5	2
23		PS0600502KP	SPRING PIN	挺线钉套管	1
24		21348206	TENSION RELEASE BAR	挺线钉	1
25		10321107	TENSION RELEASE BAR	挺线钉	1
26		23006406	TENSION RELEASE BAR	挺线钉	1

12. 绕线部件 Lower thread winder mechanism components



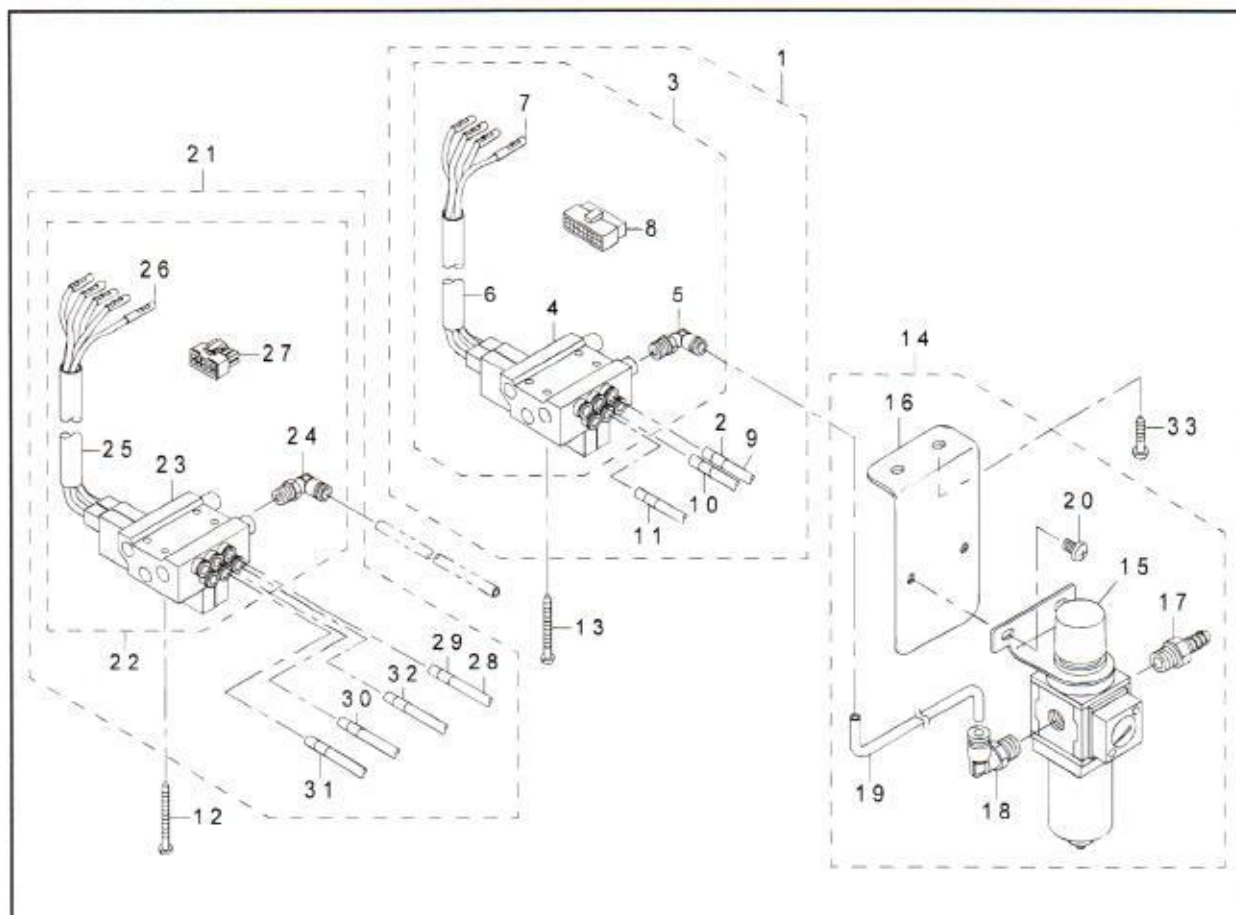
序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		21357967	BOBBIN DEVICE ASM.	梭芯装置组件	1
2		22537658	BOBBIN FITTING BASIS COMPL.	绕线座	<1>
3		21357959	BOBIN SHAFT COMPL.	绕线轴组件	<1>
4		22538151	BOBBIN CAM SHAFT COMPL.	绕线凸轮	<1>
5		23636202	BOBBIN LEVER	绕线扳手	<1>
6		21356001	ADJUSTING PLATE	绕线叉形控制板	<1>
7		B152989000CA	PRESSUR FOOT SPRING	弹簧	<1>
8		10618304	VERTICAL ROLLER WASHER	绕线器扳手轴垫圈	<2>
9		21358205	BOBBIN FRICTION GEAR	橡皮圈	<1>
10		B3205210000	CUSHION	缓冲垫	<1>
11		B1148555000	SPRING	弹簧	<1>
12		RC0560711KP	RETAINING RING	绕线轮曲柄铰链轴轴用挡圈	<1>
13		RE0500000K0	E-RING	开口挡圈	<1>
14		R0092270200	RUBBER RING	橡胶圈	<1>
15		SS7091410SP	SCREW 9/64-40 L=13.5	螺钉	<1>
16		SS6090520SP	SCREW 9/64-40 L=5.0	螺钉	<1>
17		14512503	BOBBIN ADJUSTING PLATE	绕线控制板	<1>
18		SS6110810TP	SCREW 11/64-40 L=8	螺钉11/64-40L=8	3
19		10704807	BOBBIN FRICTION WHEEL	梭芯摩擦轮	1
20		SM8050602TP	SCREW M5 L=6	螺钉	2
21		10502300	THREAD CUTTER	剪线器	1
22		SS6090620SP	SCREW 9/64-40 L=6	下过线组件	2
23		21355755	LOWER THREAD GUIDE ASM.	下过线组件	1
24		21355706	FITTING BASE	倒缝拨叉座	<1>
25		D3162555B00	THREAD GUIDE	过线钩	<1>
26		NS6110310SP	NUT 11/64-40	螺母11/64-40	<1>
27		D3168555H0B	TENSION SPRING NO.1	过线夹线簧	<1>
28		B3214047000	BOBBIN WINDER TENSION DISC	过线夹线板	<2>
29		21378708	THREAD TENSION POST	过线桩	<1>
30		11072402	THREAD TENSION NUT	过线调节螺母	<1>
31		SM6040800SP	SCREW	螺钉	2
32		22538706	PACKING	衬垫	1

13. 压脚自动提升部件 Automatic presser lifter mechanism components



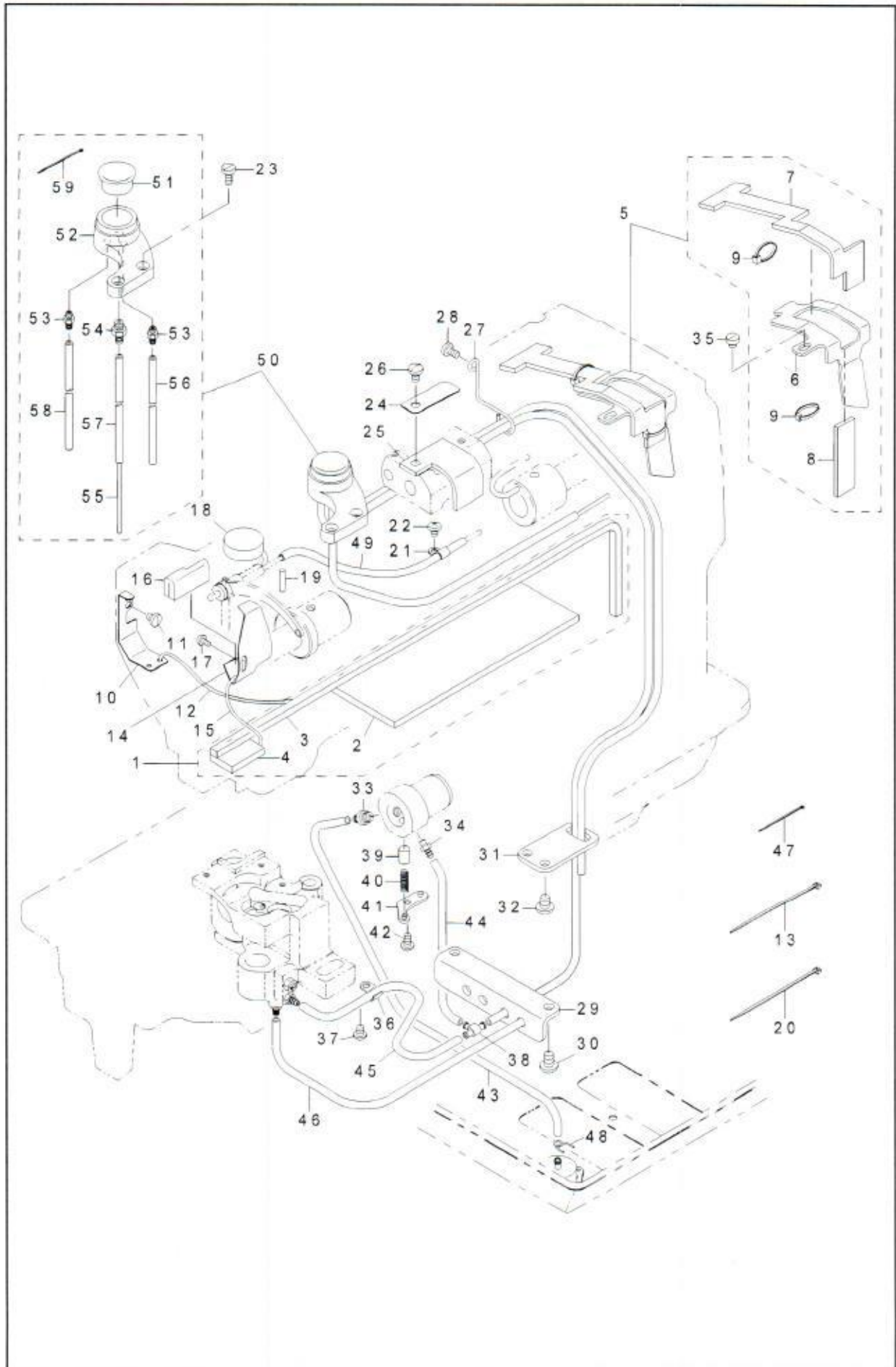
序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		PA400150100	AIR CYLINDER	抬压脚气缸M8	1
2		SM6082002TP	SCREW M8 L=20	气缸安装螺钉	4
3		21356506	CYLINDER CONNECTING SCREW	抬压脚气缸接头	1
4		NM6080001SE	NUT M8	螺母	1
5		SD0720331SP	HINGE SCREW D=7.24 H=3.3	抬压脚气缸接头螺钉	1
6		21388509	PRESSER LIFTER LEVER A	抬压脚曲柄	1
7		21356803	PRESSER LIFTER LEVER B	气动抬压脚拨叉	1
8		SM6051002TP	SCREW M5X0.8 L=10	拨叉固定螺钉	2
9		21356704	SHAFT	气动抬压脚曲柄螺钉	1
10		PJ304065101	ELBOW UNION 6XPT1/8	弯接头	2
11		21356308	CYLINDER STAY (FRONT)	抬压脚气缸安装架(前)	1
12		21356407	CYLINDER STAY (REAR)	抬压脚气缸安装架(后)	1
13		CM300200001	ATTENTION SEAL	安全标志	1
14		SS6151040SP	SCREW 15/64-28 L=10	剪线电磁铁座螺钉	4
15		HX00295000A	WIRE MARK (2)	标签	1
16		HX0029500	WIRE MARK (3)	标签	1

14. 供气部件 Air mechanism components



序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		40024965	AIR APPARATUS (B) ASM.	供气系统	1
2		HX002950000	WIRE MARK (1)	气管	<2>
3		40024857	ELECTROMAGNETIC VALVE (B) ASM.	电磁阀组件	<1>
4		GAKA2302B00	ELECTROMAGNETIC VALVE A	电磁阀	<1>
5		GAK29010000	ELBOW B	弯接头	<1>
6		GAKA1503000	INSULATION TUBE	胶套	<1>
7		HK03464000A	TERMINAL FEMALE	接线用端子	<4>
8		HK034610160	16-POLE RECEPTACLE	#N/A	<1>
9		BT0600401EB	TUBE	车头稳定螺杆胶套	<3>
10		HX00295000A	WIRE MARK (2)	气管	<2>
11		HX00295000B	WIRE MARK (3)	气管	<2>
12		SK3385001SE	WOOD SCREW D=3.8 L=50	木螺钉	4
13		SK3385001SE	WOOD SCREW D=3.8 L=50	木螺钉	4
14		40038722	FILTER REGULATAR ASM.	供气系统	1
15		PF0552170A0	FILTER REGULATOR	减压阀	<1>
16		40038723	FILTER REGULATOR MOUNTING PLATE	固定座	<1>
17		GAK29011000	NIPPLE	接头	<1>
18		GAK29009000	ELBOW	弯接头	<1>
19		BT0600401EB	TUBE	车头稳定螺杆胶套	<1>
20		SM4061001SB	SCREW M6 L=10	螺钉	<1>
21		40024966	AIR APPARATUS (C) ASM.	电磁阀组件	1
22		40024858	ELECTROMAGNETIC VALVE (C) ASM.	气动控制组件	<1>
23		GAKA2302C00	ELECTROMAGNETIC VALVE C	电磁阀	<1>
24		GAK29010000	ELBOW B	弯接头	<1>
25		GAKA1503000	INSULATION TUBE	胶套	<1>
26		HK03464000A	TERMINAL FEMALE	接线用端子	<5>
27		HK034610100	10P CONNECTOR	插头	<1>
28		BT0600401EB	TUBE	车头稳定螺杆胶套	<4>
29		HX002950000	WIRE MARK (1)	气管	<2>
30		HX00295000A	WIRE MARK (2)	气管	<2>
31		HX00295000B	WIRE MARK (3)	气管	<2>
32		HX00295000C	WIRE MARK (4)	气管标记	<2>
33		SK3482501SE	WOOD SCREW D=4.8 L=25	木螺钉D=4.8 L=2.5	2

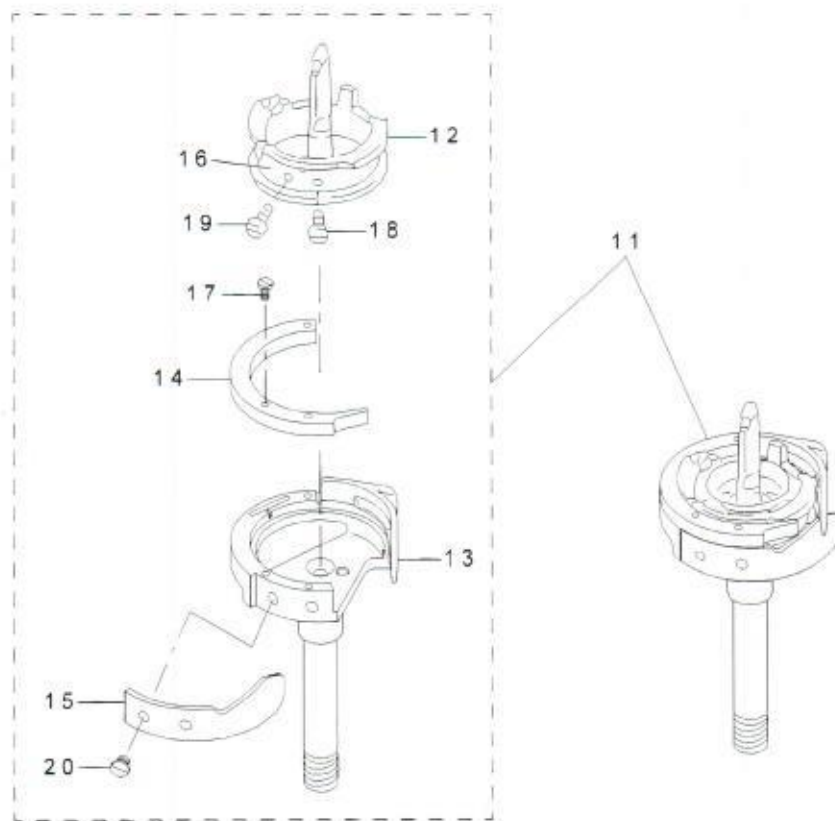
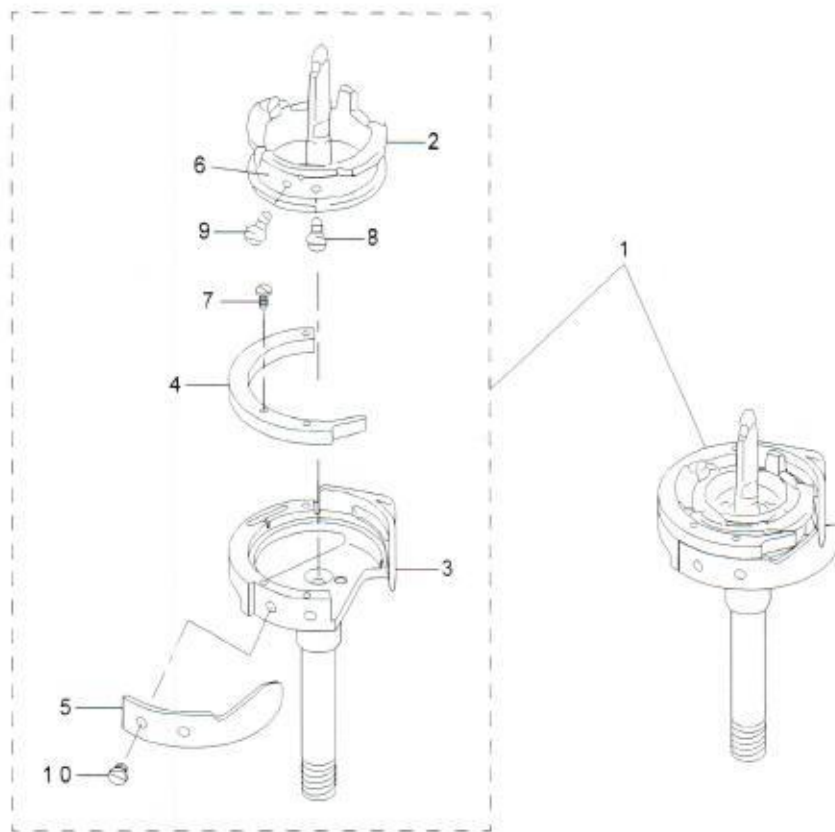
15. 供油部件 Lubrication components



15. 供油部件 Lubrication components

序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		21345756	ARM ONCE THROUGH OIL FELT ASM.	机壳油毡组件	1
2		21345707	ARM ONCE THROUGH FELT A	机壳油毡A	<1>
3		21345806	FELT B	油毡B	<1>
4		21345905	FACE ONCE THROUGH FELT	机壳油毡	<1>
5		21346358	FELT SUPPORT ASM.	油毡支架组件	1
6		21346309	FELT	油毡座	<1>
7		21346507	FEED CHANGE FELT	送料油毡	<1>
8		21346408	FELT	油毡	<1>
9		EA9500B0000	CLIP CV-70S	线卡	<2>
10		21340708	UPPER FEED OIL BAR PLATE	上送料油板	1
11		SS7110510SP	SCREW 11/64-40 L=5	螺丝	1
12		CQ202000000	OIL WICK	油线	0.2
13		EA9500B0100	CABLE BAND	线卡	1
14		21347000	TAKE-UP OIL PLATE	挑线杆内板	1
15		CQ202000000	OIL WICK	油线	0.25
16		21347208	TAKE-UP LUBRICATION FELT	挑线杆润滑油毡	1
17		SS3090610SP	SCREW 9/64-40 L=6	螺丝	1
18		21346002	FELT	毛毡	1
19		B1412051000	FELT	油毡	1
20		A407855000A	CLIP BAND	线卡	1
21		B3538112000	OIL RETURN TUBE HOLDER	油管固定板	1
22		SS4110615SP	SCREW 11/64-40 L=6	油管固定板螺钉	1
23		SS6111010SP	SCREW 11/64-40 L=9.5	螺钉11/64-40 L=9.5	2
24		21346101	LUBRICATION FELT PRESSER	油毡压片	1
25		21346200	MUTUAL VERTICAL CHANGE FELT	垂直油毡	1
26		SS7120760SP	SCREW 3/16-28 L=7.0	下轴轴承固定螺钉	1
27		21346606	PIPE SUPPORT	油管支架	1
28		SS7110830SP	SCREW 11/64-40 L=7.5	螺钉11/64-40 L=8.5	1
29		21345103	LUBRICATION BRACKET	润滑架	1
30		SS4150915SP	SCREW 15/64-28 L=9	螺钉	2
31		21345202	OIL PIPE STAY	油管支板	1
32		SS4150915SP	SCREW 15/64-28 L=9	螺钉	2
33		40064409	CONNECTION SCREW ASM.	油管连接大螺钉	1
34		SQ1110401MZ	CONNECTING SCREW	油管连接小螺钉	1
35		SS6110480SP	SCREW 11/64-40 L=4.3	上牙螺丝	1
36		B3538112000	OIL RETURN TUBE HOLDER	油管固定板	1
37		SS4110615SP	SCREW 11/64-40 L=6	油管固定板螺钉	1
38		13765607	OIL CONNEC. ARM	三通油管接头	1
39		B3534155000	PLUNGER	吸油柱塞	1
40		B1214038000	PLUNGER SPRING	柱塞簧	1
41		B3524552000	PLUNGER THRUST PLATE	柱塞挡板	1
42		SS4110815SP	SCREW 11/64-40 L=8	螺钉11/64-40 L=8	1
43		23630007	TUBE	车头稳定螺杆胶套	0.36
44		23630007	TUBE	车头稳定螺杆胶套	0.16
45		23630007	TUBE	车头稳定螺杆胶套	0.22
46		23630007	TUBE	车头稳定螺杆胶套	0.35
47		EA9500B0100	CABLE BAND	线卡	11
48		10126803	OIL TUBE HOLDER	吸油管弹簧夹	1
49		BT0600402EA	OIL TUBE	油管	0.12
50		40051503	ARM OIL TANK ASM.	储油箱组件	1
51		B3520586000	OIL SIGHT WINDOW	油窗	<1>
52		21345608	ARM OIL TANK	储油箱	<1>
53		SQ1110401MZ	CONNECTING SCREW	油管连接小螺钉	<2>
54		SQ1150451MZ	CONNECTING SCREW	油管连接小螺钉	<1>
55		CQ252000000	OIL WICK	油线	<0.7>
56		23630007	TUBE	车头稳定螺杆胶套	<0.5>
57		23630007	TUBE	车头稳定螺杆胶套	<0.2>
58		23630007	TUBE	车头稳定螺杆胶套	<0.6>
59		EA9500B0100	CABLE BAND	线卡	<3>

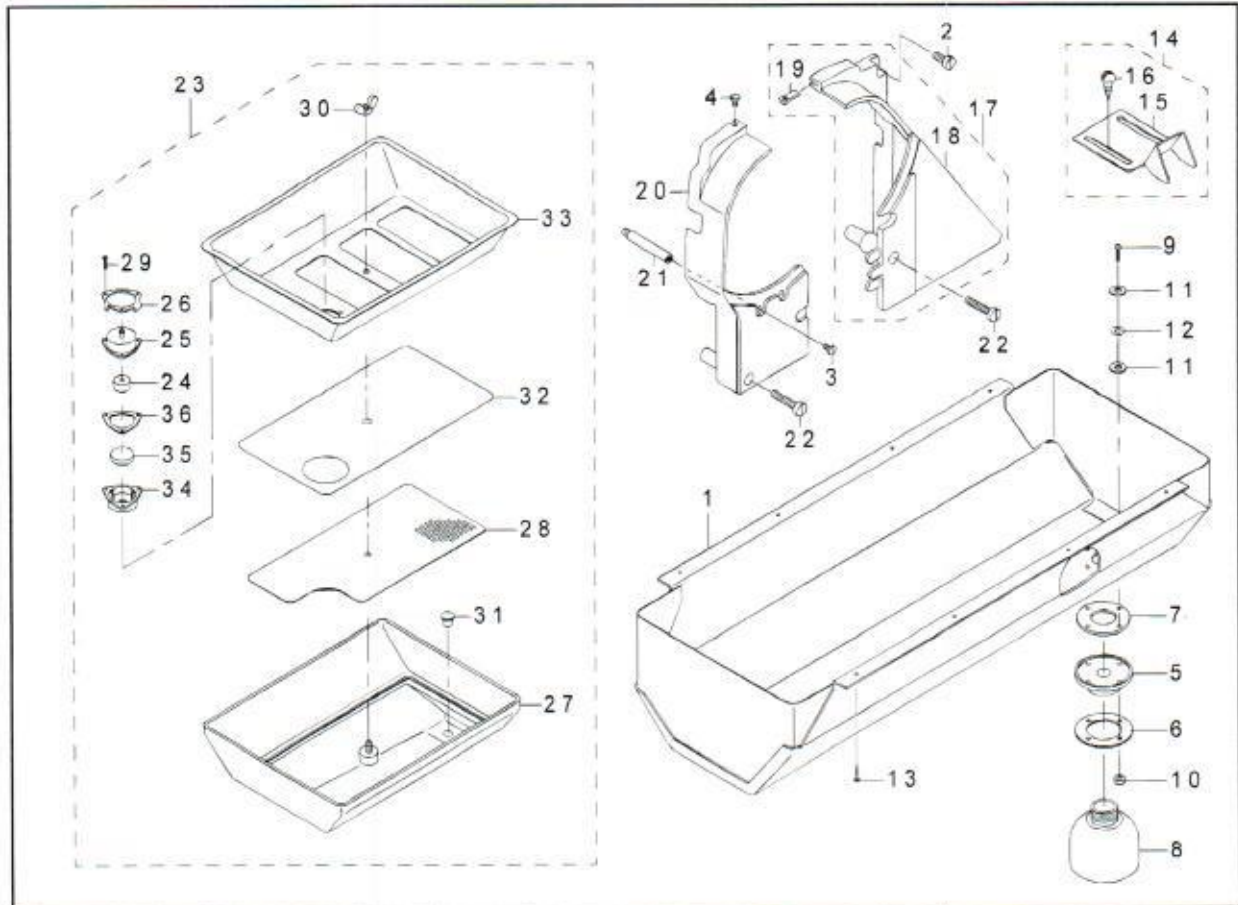
16. 旋梭部件 Hook components



16. 旋梭部件 Hook components

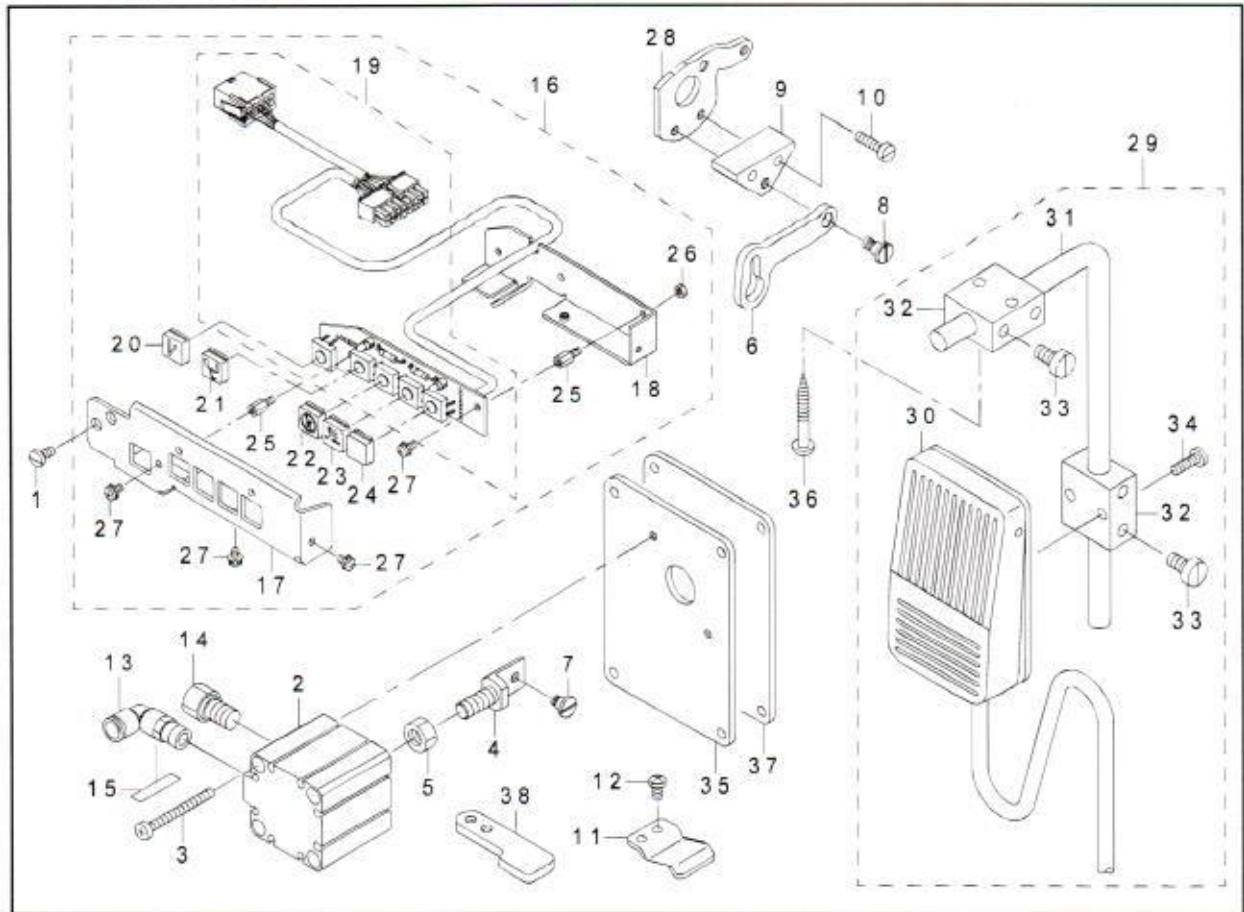
序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		21387055	THREAD TRIMMER HOOK ASM.	旋梭	1
2		21387006	INNER HOOK	内梭	<1>
3		21334503	OUTER HOOK	外梭	<1>
4		B1830563B0A	INNER HOOK HOLDER B	旋梭压板	<1>
5		21334206	NEEDLE HOLDER	护针片	<1>
6		10722908	TENSION SPRING	梭皮	<1>
7		10112803	SCREW	螺钉	<3>
8		10723302	ADJUSTING SCREW	螺钉	<1>
9		10723401	TENSION SPRING SETSCREW	螺钉	<1>
10		22814008	SCREW	螺钉	<2>
11		40079022	THREAD TRIMMER HOOK ASM.	旋梭	1
12		40079895	INNER HOOK	内梭	<1>
13		40079894	OUTER HOOK	外梭	<1>
14		40079897	INNER HOOK HOLDER	旋梭压板	<1>
15		40079896	NEEDLE HOLDER	护针片	<1>
16		40079898	TENTION SPRING	梭皮	<1>
17		40079904	INNER HOOK HOLDER SETSCREW	螺钉	<3>
18		40079899	ADJUSTING SCREW	螺钉	<1>
19		40079900	TENTION SPRING SETSCREW	螺钉	<1>
20		40079905	NEEDLE HOLDER SETSCREW	螺钉	<2>

17. 附件 Belt cover & oil reservoir components



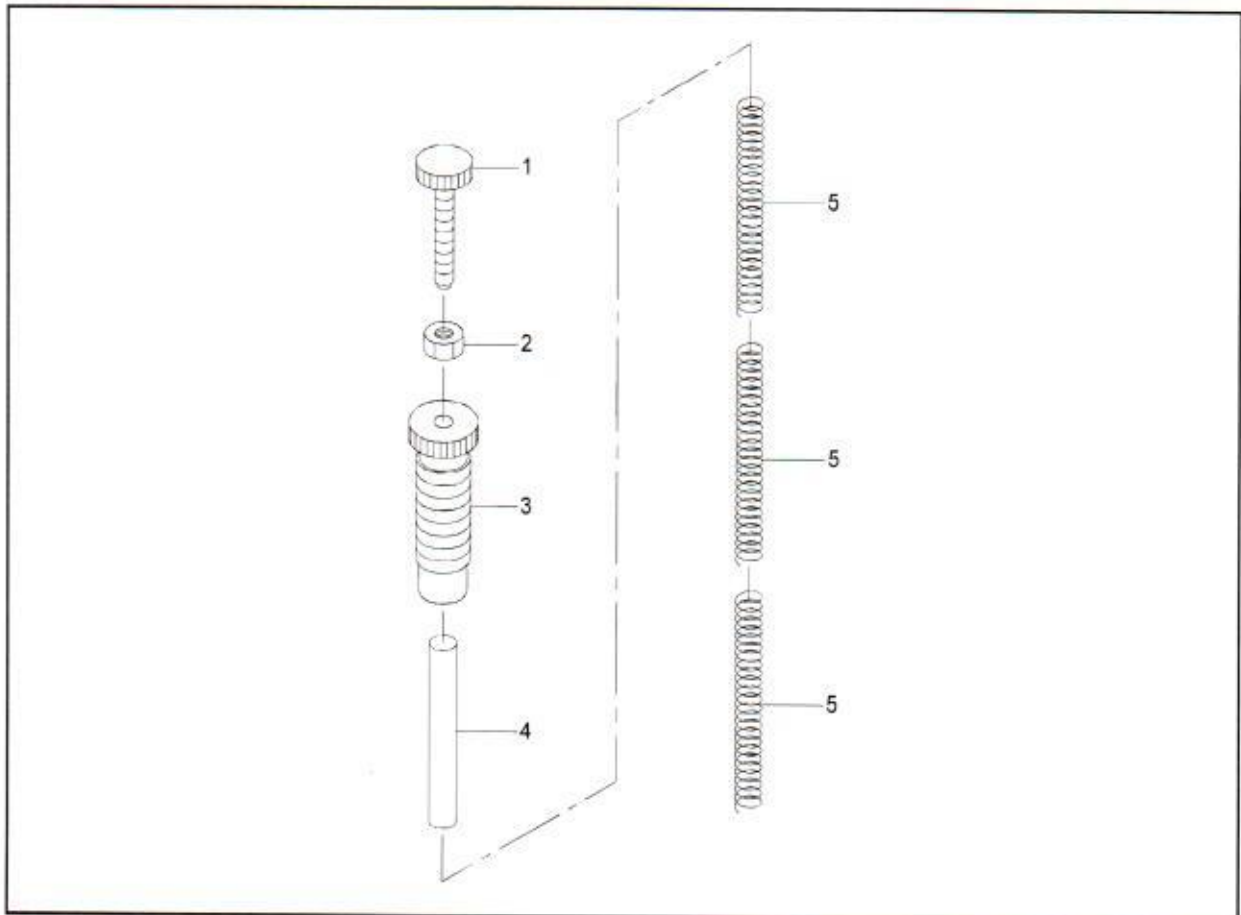
序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		21351457	OIL RESERVOIR ASM.	大油盘	1
2		SS6151440SP	SCREW 15/64-28 L=14	螺钉15/64-28 L=14	1
3		SS7110840SP	SCREW 11/64-40 L=7.8	螺钉	1
4		SS5110740TP	SCREW 11/64-40 L=6.5	螺钉11/64-40 L=6.5	1
5		40025299	OIL POT JOINT	集油壶接头	1
6		21379003	OIL MANAGEMENT WASHER	油封压板	1
7		B8112220000	OIL SEAL	油封	1
8		40025300	OIL POT	油壶	1
9		SM3031401SE	SCREW M3X0.5 L=14	油封压板螺钉	4
10		NM6030001SC	NUT M3	螺母	4
11		10748101	OIL REMOVING SETSCREW PACKING	排油螺钉垫	8
12		WP0320501SC	WASHER M3	平垫	4
13		SK3241601SC	WOOD SCREW D=2.4 L=16	铁钉	8
14		10755254	BELT COVER C ASM. (FOR IE)	皮带罩C组件(用于FOR IE)	1
15		10755205	BELT COVER C (IE)	皮带罩C(用于IE)	<1>
16		SK3482500SC	WOOD SCREW D=4.8 L=25	木螺钉D=4.8 L=2.5	<2>
17		21351150	BELT COVER ASM. (RIGHT)	皮带罩组件(右)	1
18		21351101	BELT COVER (RIGHT)	皮带罩(右)	<1>
19		21351002	BELT COVER AUXILIARY PLATE	皮带罩辅助板	<1>
20		21351200	BELT COVER (LEFT)	皮带罩(左)	1
21		D8232241E00	BELT COVER SUPPORT A	皮带罩支架A	1
22		SS6153040SP	SCREW 15/64-28 L=30	螺钉15/64-28 L=30	2
23		21345350	OIL TANK ASM.	油盒组件	1
24		10727303	FILTER	滤油器	<1>
25		10727204	FILTER CAP	吸油接头	<1>
26		10753002	FILTER PLATE	滤油器压板	<1>
27		21345301	OIL TANK	塑料油盒	<1>
28		21346804	COVER (LOWER)	过滤网	<1>
29		SM6021000TP	SCREW	过滤器螺钉	<3>
30		NM9050001SC	WING NUT M5X0.8	蝶型螺母	<1>
31		TA0800704R0	RUBBER PLUG	油盒油塞	<1>
32		21346903	FILTER	过滤网(锦纶0)	<1>
33		21346705	COVER (REAR)	油盒	<1>
34		21345509	FILTER CASE	滤油器	<1>
35		B8228125000	OIL RESERVOIR MAGNET	磁铁	<1>
36		10739209	FILTER PACKING	橡胶垫	<1>

18.DL部件 (可选) DI mechanism (option) components



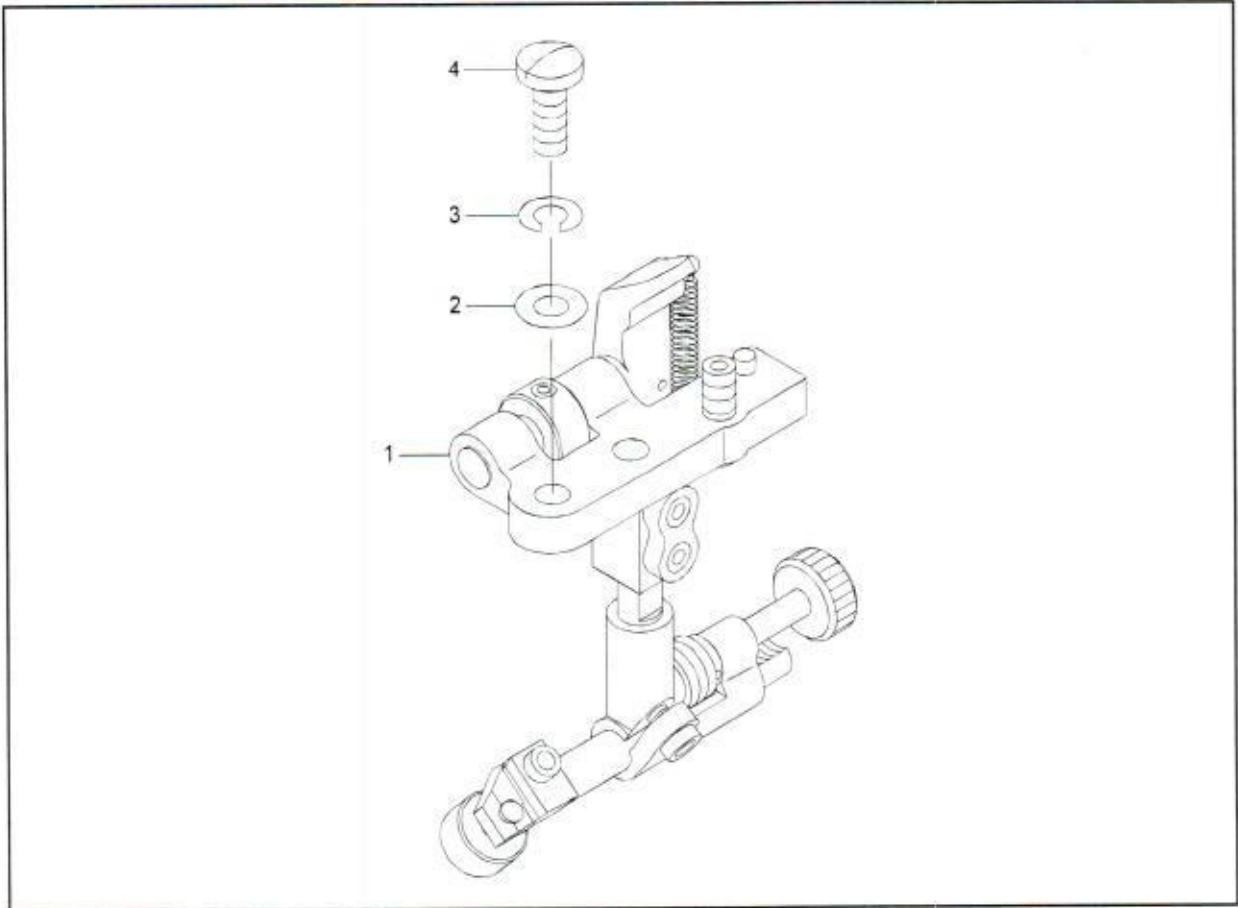
序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		SS7110840SP	SCREW 11/64-40 L=7.8	螺钉	2
2		PA320200100	TIG CYLINDER	气缸	1
3		SM6044002TP	SCREW	气缸安装螺钉	2
4		21438403	CYLYNDER CONNECTING SCREW	控制连接螺钉M6	1
5		NM6080721SE	NUT M8	螺母	1
6		21438502	MUTUAL VERTICAL LINK	连杆	1
7		SD0600403TP	HINGE SCREW	螺钉	1
8		SD0600454TP	SHOULDER SCREW	螺钉	1
9		21438601	MUTUAL VERTICAL LINK SPASER	连接安装座	1
10		SS6111610SP	SCREW 11/64-40 L=16	安装座螺钉	2
11		21438700	MUTUAL VERTICAL LINK SUPPORT	支撑板	1
12		SS4110815SP	SCREW 11/64-40 L=8	螺钉11/64-40 L=8	2
13		PJ304065101	ELBOW UNION 6XPT1/8	弯接头	1
14		PX015101000	MUFFLER	消音器	1
15		HX00295000C	WIRE MARK(4)	气管标记	1
16		40024849	5RANGE SWITCH ASM.	面板操作按钮组件	1
17		21442603	SWITCH COVER	按钮安装板	<1>
18		21442702	SWITCH CIRCUIT FITTING BASE	按钮护罩	<1>
19		40024848	5RANGE SWITCH SUB(A) ASM.	按钮座	<1>
20		21442900	KEY TOP A	按钮A	<1>
21		21443007	KEY TOP B	指示灯	<1>
22		21443106	KEY TOP C	按钮	<1>
23		21443205	KEY TOP D	按钮	<1>
24		21443809	KEY TOP F	按钮	<1>
25		HX00354000N	SPACER	支撑螺钉	<4>
26		NM6030001SC	NUT M3	螺母	<3>
27		SL4030631SC	SCREW M3X6	安装螺钉	<4>
28		21438106	STOPPER PLATE B	支架板	1
29		40025036	KNEE SWITCH ASM.	膝控系统	1
30		40025035	KNEE SWITCH ASM.	膝控组件	<1>
31		MAT80231T00	DRIVING BAR T002	驱动杆	<1>
32		MAT80230T00	KNEE SWITCH SUPPORT BASE	膝控固定块	<2>
33		SS6151220SP	SCREW 15/64-28 L=11.5	螺钉	<4>
34		SS7111410SP	SCREW 11/64-40 L=14	螺钉	<2>
35		21437207	WINDOW PLATE F	后窗板	1
36		SK3514000SC	WOOD SCREW D=5.1 L=40	木螺钉	2
37		21437306	WINDOW PLATE E PACKING	油垫	1
38		21438205	UPPER FEED STOPPER PLATE	挡板	1

20. 双层压力调节部件 (可选) Optional parts (additional spring for presser bar) components



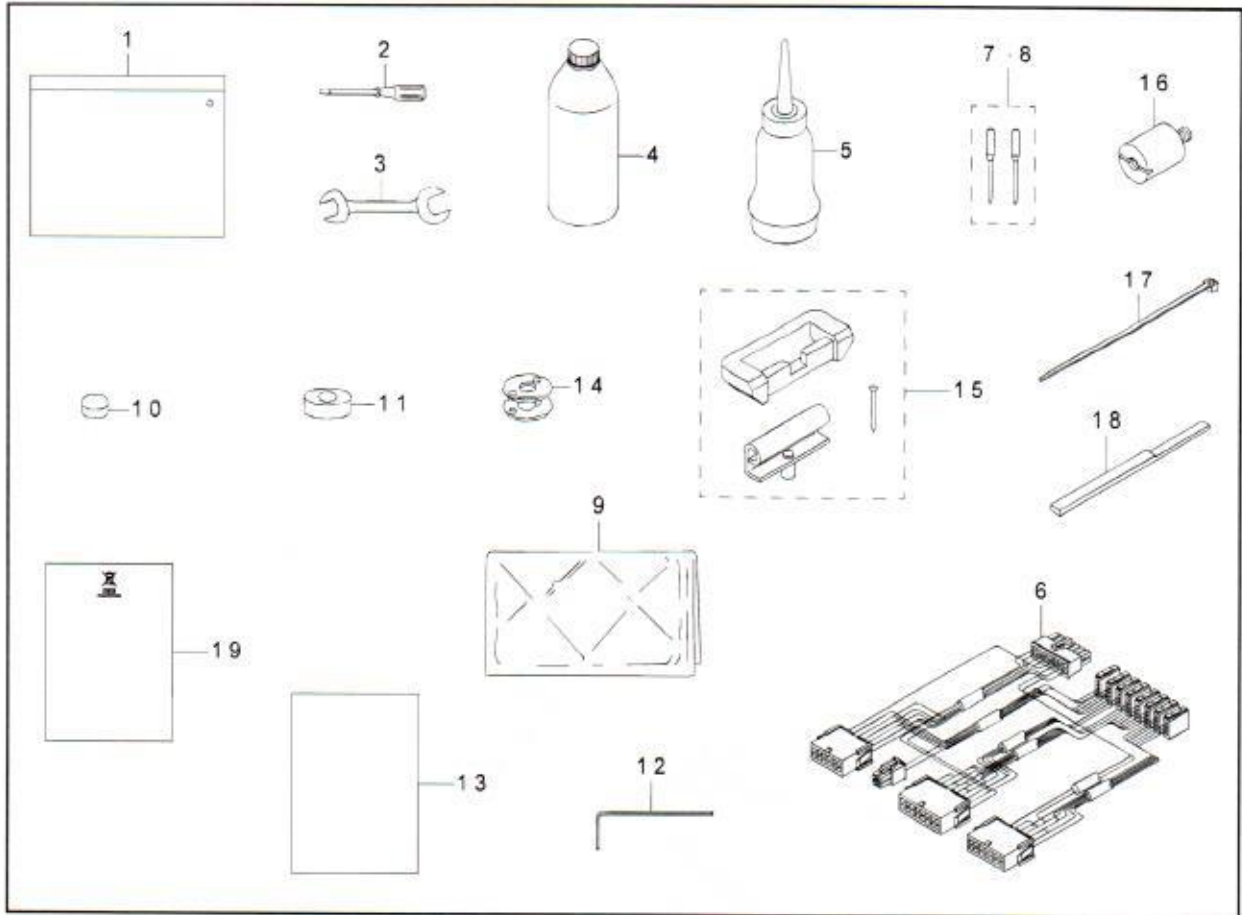
序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		21006507	ADJUST SCREW B	调压小螺杆	1
2		NS6110530SP	NUT 11/64-40	螺母11/64-40	1
3		21006408	ADJUST SCREW A	调压大螺杆	1
4		21342407	GUIDE SHAFT	压杆	1
5		21006002	ADJUST SPRING B	弹簧	3

21.吊傍（可选） Suspension square (option) components



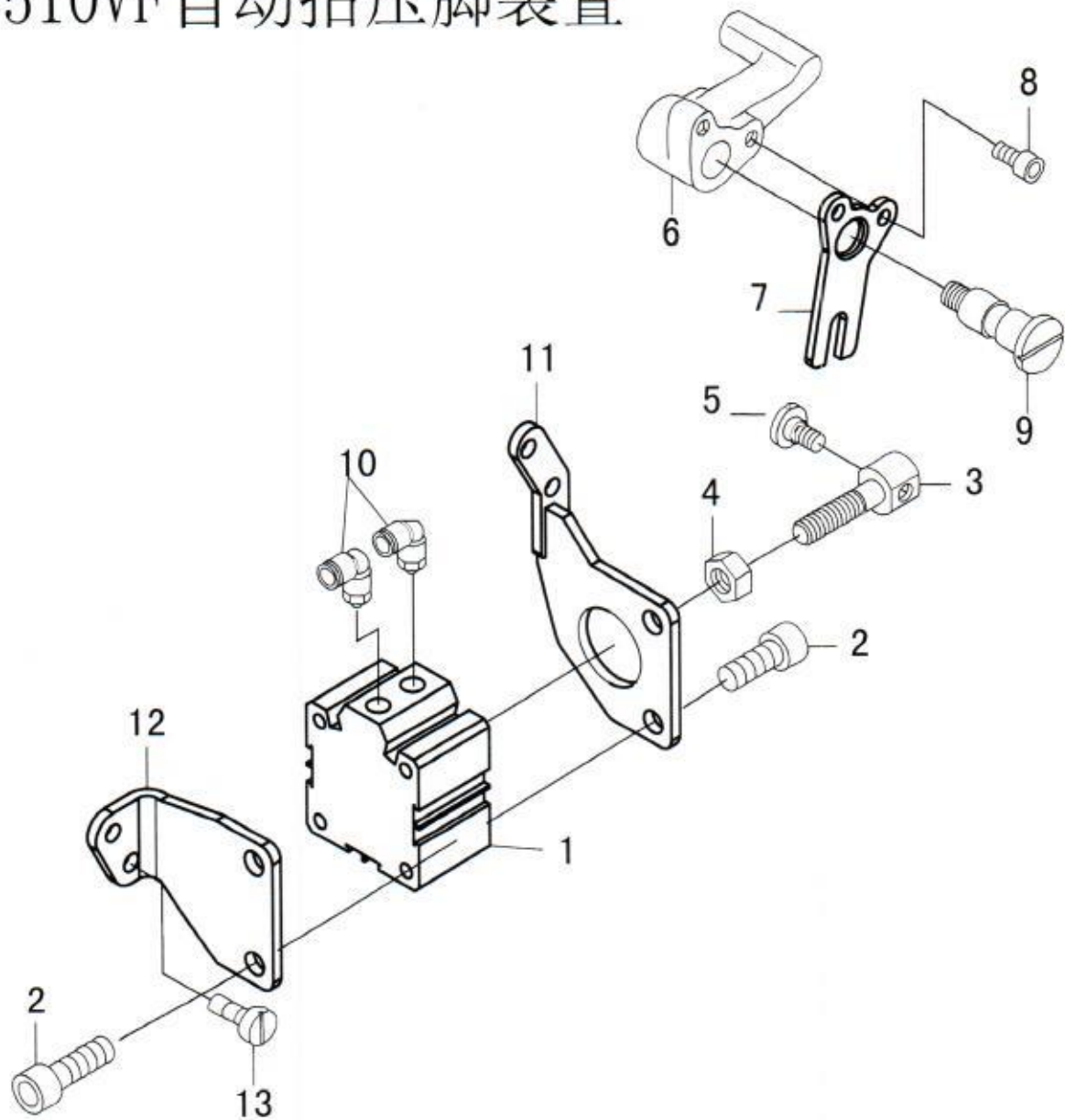
序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		MAH152010A0	RULER	靠边组件	1
2		WP0621016SD	WASHER 6.2X13X1	拍牙叉垫圈	2
3		WS0610002KN	SPRING WASHER 6.1X12.2X1.5	弹簧垫	2
4		SS7151610SP	SCREW 15/64-28 L=16	螺钉	2

22. 附件 Accessories parts components



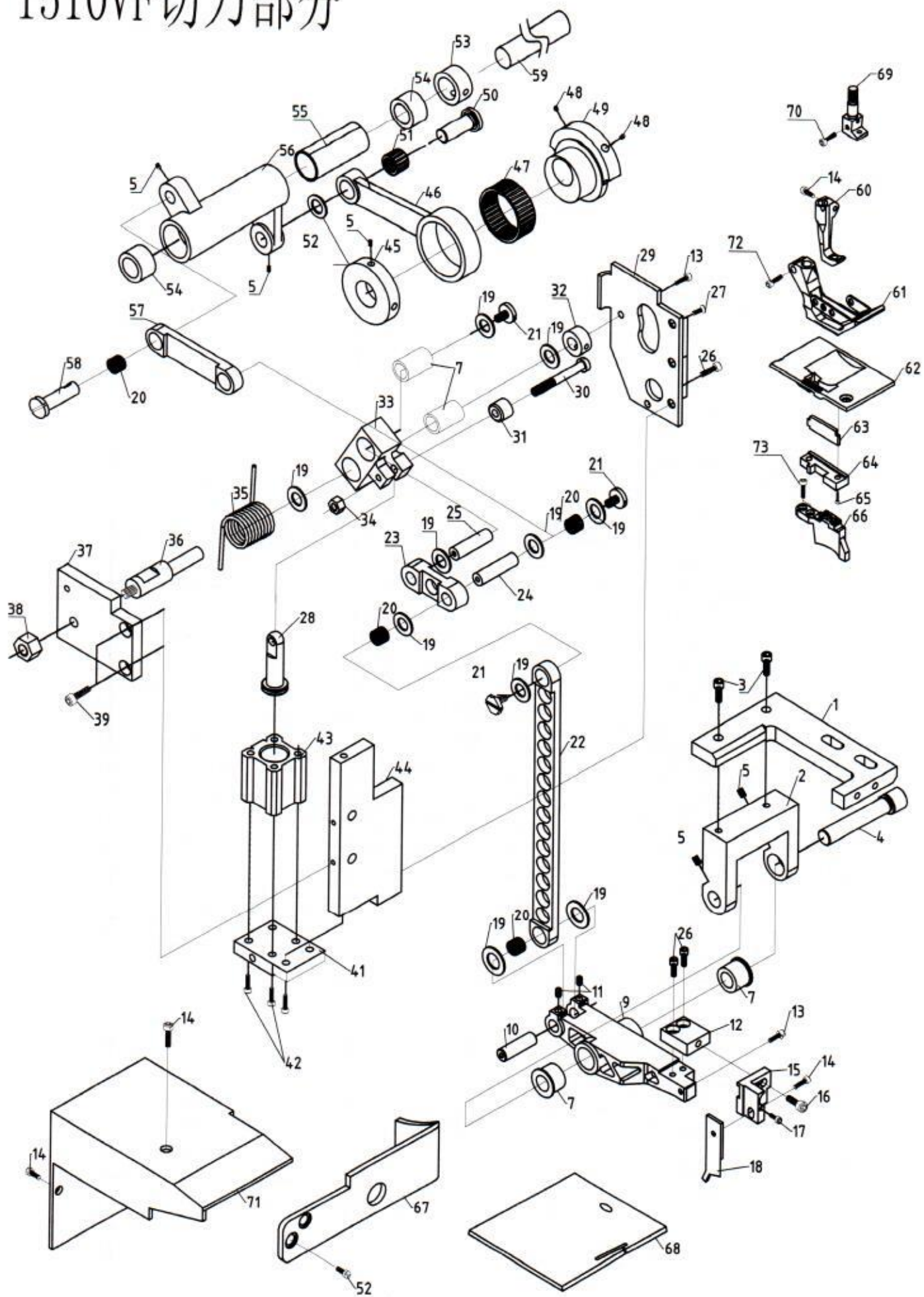
序号	说明	编码及型号	DESCRIPTION	名称及规格	数量
1		21413158	ACCESSORY BAG ASM.	附件塑料袋	1
2		22933006	SCREW DRIVER LARGE	中起子	1
3		B9113012000	WRENCH (9X10)	呆扳手	1
4		MDFRX2700C0	NEW DEFRIX OIL NO. 2 (700CC)	油壶(含2升机油)	1
5		J1067000000	OILER	小油壶	1
6		40064512	RELAY CORD F ASM.	连接线	1
7		M13517B1602	NEEDLE 135X17 #160-2	机针	1
8		M13517B1202	NEEDLE 135X17 #120-2	机针	1
9		22933303	VINYL COVER	机壳外罩	1
10		B8206012000	FELT CUSHION	防震垫	4
11		B8209012000	RUBBER CUSHION	防震块	4
12		40079298	WRENCH	六角扳手	1
13		40079080	INSTRUCTION MANUAL (REVISED)	说明书	1
14		21334800	ALUMINUM BOBBIN WITH KNURL	梭芯	1
15		21413257	RUBBER HINGE ASM.	铰链组件	1
16		B8404352000	BELT COVER SUPPORT STUD	连接线	2
17		EA9500B0100	CABLE BAND	线卡	3
18		21390307	FIXING KNIFE GAUGE	压板	1
19		CM600100201	WEEE INFORMATION SHEET	附件清单	1

1510VF自动抬压脚装置



序号	名称	型号规格	数量	备注
1	抬压脚气缸	PA400150100	1	
2	气缸安装螺丝	SM6082002TP	4	
3	抬压脚气缸接头		1	
4	螺母	M8	1	
5	抬压脚气缸接头螺钉	SD0720331SP	1	
6	气动抬压脚曲柄	21356605	1	
7	气动抬压脚拨叉		1	
8	拨叉固定螺钉	SM6051002TP	1	
9	气动抬压脚曲柄螺钉	21356704	1	
10	弯接头	PJ304065102	2	
11	抬压脚气缸安装架(前)		1	
12	抬压脚气缸安装架(后)		1	
13	抬压脚气缸安装架固定螺丝	SS6151040SP	4	

1510VF切刀部分



序号	名称	型号规格	数量	备注
1	座		1	
2	动刀摇臂轴架		1	
3	圆柱头内六角螺钉	M6X20	2	
4	动刀摇臂轴		1	
5	紧定螺丝	M5X5	6	
6	摇臂垫		2	
7	摇臂轴承(套)	HK1014(GB/T2900)	2	
8	套筒		1	
9	动刀摇臂		1	
10	摇臂连接轴		1	
11	紧定螺钉	M4X5	2	
12	刀架座		1	
13	调节螺钉	M3X11	1	
14	圆柱头内六角螺钉	M4X8	5	
15	动刀架		1	
16	圆柱头内六角螺钉	M5X8	2	
17	圆柱头内六角螺钉	M3X6	1	
18	动刀		1	
19	尼龙垫圈		12	
20	轴承	K081108	8	
21	压脚交替提升调节凸轮螺钉	SM11/64-T40	4	
22	长连杆		1	
23	摆架与长连杆连接杆		1	
24	长连杆连接轴		1	
25	摆架连接轴		1	
26	圆柱头内六角螺钉	M4X12	5	
27	沉头内六角螺钉	M5X10	3	
28	气缸杆		1	
29	侧导板		1	
30	圆柱头内六角螺钉	M5X40	1	
31	螺钉垫块		1	
32	挡圈		1	
33	摆架		1	
34	六角螺母	M5	1	
35	扭簧		1	
36	摆架销轴		1	
37	侧板		1	
38	六角螺母	M8	1	
39	圆柱头内六角螺钉	M5X12	2	
40	圆柱头内六角螺钉	M4X40	1	
41	气缸座		1	
42	圆柱头内六角螺钉	M4X20	4	
43	气缸		1	
44	背板		1	
45	挡圈		1	
46	凸轮传动连杆		1	
47	滚针轴承	K30X34X13	1	

48	紧定螺钉	SM1/4"XT40-6	2	
49	切刀凸轮		1	
50	传动臂连杆销		1	
51	滚针轴承	K9X12X10	1	
52	机螺钉	SM11/64-T40L=7.8	2	
53	上送布轴紧圈		1	
54	铜套	φ 14. 72X φ 20X12	2	
55	毛毡		1	
56	摆套		1	
57	摆套与长连杆连接杆		1	
58	连轴		1	
59	上送料轴		1	
60	走步压脚(5mm)		1	
61	外压脚(5mm)		1	
62	针板(5mm)		1	
63	定刀		1	
64	定刀压铁		1	
65	圆柱头内六角螺钉	M3X10	2	
66	牙齿(5mm)		1	
67	气动开关座		1	
68	右推板		1	
69	针杆头		1	
70	机针螺钉	SM9/64-T40X3.5	1	
71	罩		1	
72	螺钉	M4X10	1	
73	螺钉	SM1/8-T40L=7	2	

