

LF 2381 AUT

User Instructions & Parts manual

Always switch off the electricity when working on the machine.

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Safety 1

1.01 Safety symbols



Danger! Points to be observed.



Danger of injury for operating and specialist personnel!



Before threading, changing bobbin and needle, cleaning etc. switch off main switch. en

Caution

Do not operate without finger guard and safety devices.

Before threading, changing bobbin and needle, cleaning etc. switch off main switch.

1.02 Important points for the user

- This Instruction Manual is a component of the machine and must be available to the operating personnel at all times.
- The Instruction Manual must be read before operating the machine for the first • time.
- The operating and specialist personnel must to be instructed in the safeguards of the machine and safe work methods.
- It is the duty of the user to operate the machine in perfect running order.
- It is the obligation of the user to ensure that none of the safety mechanisms are removed or deactivated.
- It is the obligation of the user to ensure that only authorized persons operate and work on the machine.

1.03 Danger



A working area of 1 meter is to be kept free both in front of and behind the machine in operation so that the machine is always easily accessible.



Never reach into the sewing area while sewing! Danger of injury by the needle!



Never leave objects on the table while adjusting the machine settings! Objects can become trapped or be slung away! Danger of injury!



Switch the machine off before tilting it backwards! Danger of injury if the machine is started accidentally!



Do not operate the machine without its take-up-lever guard 2! Danger of injury due to the motion of the take-up lever!



Do not operate the machine without tilt lock 2! Danger of crushing between sewing head and table top!



Specifications

2 Specifications▲

Stitch type	······301(lockstitch)
Clearance under roller presser·····	·····7 mm
Clearance width·····	·····245 mm
Clearance height ·····	•••••115 mm

Sewing head dimensions

Length·····approx.650	mm
Width with approx.240	mm
Height (above table)approx.320	mm
Bedplate dimensions	mm

Max. speed ·······2500 spm ◆

Connection data

Operating vol	tage⋯⋯⋯	··220V±10%,50/60 Hz
Max. power	consumption	·····1.2kVA

Net weight of sewing head ······a	pprox.55	kg
Gross weight of sewing headar	prox.66	kg

▲ Subject to alteration

Dependent on material, work operation and stitch length

3 Explanation of symbols

In this Instruction Manual, work to be carried out or important information is accentuated by symbols which have the following meanings:



Note, information



Cleaning, care

Lubrication



Maintenance, repairs, adjustment, service work (only to be carried out by technical staff)

Controls

4 Controls

4.01 Keys on the machine head



- As long as key 1 is pressed during sewing, the machine sews in reverse direction.
- Keys 2 is use to setting second stitch length, key 3 is use to compensate stitch, key 4 is use to scram.

4.02



0=Machine stop

1=Sewing

2=Raiser roller presser

3=Trim sewing threads

4.03

Lever for lifting roller presser



• The roller presser can be raised by turning lever 1.

4.04 Knee lever



 The roller presser can be raised by pressing the knee lever 1 in the direction of the arrow.

4.05 Swing out roller presser



 When the roller presser is raised, it can be swung out by pulling it lightly downwards.

Installation and commissioning

5

Installation and commissioning



The machine must only be installed and commissioned by qualified personnel!

All relevant safety regulations must be strictly adhered to!



If the machine is delivered without a table, be sure to use a stand and table top that can hold the weight of the machine with its motor. It is very important to ensure that the stand of the machine is firm and steady, also during sewing.

5.01 Installation

The site where the machine is installed must be provided with suitable connections for electric current.

It must be ensured that the standing surface of the machine site is firm and horizontal, and that sufficient lighting is provided for.



Due to reasons of packaging, the table top is lowered for transport. The following is a description of how to adjust the height of the table top.

5.01.01 Adjusting the table height



- Loosen screws 1 and 2 and set the table height as required.
- Firmly tighten screw 1.
- Set the required pedal position and tighten screw 2.

5.02 Fitting the reel stand



• Fit the reel stand as shown in Fig.

• Afterwards insert the stand in the hole of the table top and secure it with the nuts provided.

5.03 Fitting the tilt lock





Switch the machine off. Danger of injury if the machine is started accidentally

Fix the tilt lock 1 by screw 2 (Supplied with accessories)



Do not operate the machine without tilt lock 1. Danger of crushing between sewing head and table top!

5.04 Commissioning

- Check the machine, particularly the electrical wiring for any damage.
- Clean the machine thoroughly and then oil it or fill in oil.
- Have a mechanic check whether the motor of the machine can be operated with the available power supply, and that the motor is correctly connected in the junction box. If there are any discrepancies the machine must not be operated under any circumstances.



The machine only be connected to an earthed socket!

• When the machine is running, the balance wheel must turn towards the operator. If it does not, the motor connection must be changed by a mechanic.



5.05 Tilted work base

6 Preparation



All instructions and regulations in this Instruction Manual must be observed.

Special attention must be paid to all safety regulations!



All setting-up work must only be carried out by personnel with the appropriate training. For all setting-up work the machine must be disconnected from its power supply by turning off the on/off switch, or removing the plug from the electric power socket.

6.01 Inserting needle



Switch the machine off! Danger of injury if the machine is started accidentally!



Only use needles of system 134

- Raise the roller presser 1 and swing it out.
- Loosen screw 2 and insert the needles as far as possible. The long groove must face to the left.
- Tighten screw 2 and swing roller presser1 back to position.



The Choice of needle depends on the model of the machine and the thread and material used.

6.02 Winding the bobbin thread, adjusting the primary thread



- Place an empty bobbin 1 into bobbin winder spindle 2.
- Thread the bobbin as shown in Fig. And wind it clockwise around bobbin 1 a few times
- Switch on the bobbin winder while pressing bobbin winder spindle 2 and lever 3.



The bobbin is filled up during sewing.

- The thread tension of bobbin 1 can be adjusted by knurled screw 4.
- The bobbin winder stops automatically when bobbin 1 is full.

If the thread is wound unevenly:

- Loosen nut 5.
- Turn thread guide 6 accordingly.
- Tighten nut 5.

6.03 Removing/Inserting the bobbin case



Switch the machine off. Danger of injury if the machine is started accidentally



Removing the bobbin case:

- Open the bed plate slide.
- Raise latch 1 and remove bobbin case 2

Inserting the bobbin case:

- Insert bobbin case 2.
- Close the latch and close the post



Do not run the machine with the bed slide open.

Danger of injury by moving parts.

6.04 Threading the bobbin case, adjusting the bobbin thread tension



- Insert the bobbin into the bobbin case 1.
- Pass the thread through the slot under spring 2.
- Pass the thread through the notch.
- Adjust the thread tension by turning screw 3.



When the thread is pulled, the bobbin must rotate in the direction of the arrow.

6.05 Threading the needle thread, adjusting the needle thread tension





Switch the machine off. Danger of injury if the machine is started accidentally

- Thread the needle thread as shown in Fig.
- Adjust the needle thread tension by turning milled screw 1.

6.06 Setting the stitch length



- Touch key 1 on screen lightly then screen unlocked.
- Adjust the stitch length (feed stroke) for the feed wheel by pressing the key 2 (key 3).
- Adjust the stitch length (feed stroke) for the roller presser by pressing the key 4 (key 5).
- Note: nether stitch length must equals upper stitch length.

7 Care and Maintenance

Clean ······daily, more frequently if in continuous operation	n
Oil leveldaily, before use	e
Oil the hook ······daily, before use	e
Lubricate the bevel gearsonce a year	ar



These maintenance intervals are calculated for the average running time of a single shift operation. If the machine is operated more than this, shorter intervals are recommended.

7.01 Cleaning

Clean the hook every day, several times if in continuous use



Switch the machine off! Danger of injury if the machine is started accidentally!





- Bring the needle bar to its highest position.
- Open the bed plate slide and remove the bobbin case cap and the bobbin.
- Unscrew hook gib 1.
- Turn the handwheel until the point of bobbin case 2 penetrates into the groove of the hook race approx. 5 mm.
- Remove bobbin case 2.
- Clean the hook race with paraffin.
- When inserting the bobbin case 2, ensure that the horn 3 of the bobbin case 2 meshes in the recess of the retaining lug 4.
- Screw hook gib 1 back on.
- Insert the bobbin and bobbin case and close the bed plate slide.

7.02 Filling oil in the hook



Switch the machine off! Danger of injury if the machine is started accidentally!



- Pour 1-2 drops of oil into hole 1 of the hook gib daily.
- Before commissioning the machine, and after long periods out of operation, pour a few drops of oil into the hook race (see arrow).

7.03 Oil bowl for hook lubrication





Check the oil level before each use. There must always be oil in reservoir 1.

• If required refill oil through hole.



Use only oil with a mean viscosity of 22.0mm²/s at 40 $^{\circ}$ C and a density of 0.865g/cm³ at 15 $^{\circ}$ C.

7.04 Lubricating the bevel gears



Switch the machine off! Danger of injury if the machine is started accidentally!



- The bevel gears of the hook drive are to be greased once a year
- Lay the machine head backwards.
- Unscrew the cover of the bevel gear case.
- Brush a little grease onto all of the tooth flanks (see arrow).
- Screw on the lid.
- To stand the machine head up again, press safety plate 1 to the rear and stand the machine head up using both hands.

8 Adjustment



Unless stated otherwise, during all adjustment work the machine must be disconnected from electric supply! Danger of injury if the machine is started accidentally!

8.01 Note on adjustment

- All following adjustment are based on a fully assembled machine and may only be carried out by expert staff trained for this purpose.
- Machine covers, which have to be removed and replaced to carry out check sand adjustments, are not mentioned in the text.
- The order of the following chapters corresponds to the most logical work sequence for machines which have to be completely adjusted. If only specific individual work steps are carried out, both the preceding and following chapters must be observed.
- Screws, nuts indicated in brackets () are fastenings for machine parts, which must be loosened before adjustment and tightened again afterwards.

Abbreviations TDC = top dead center BDC = bottom dead center

8.02 Tools, gauges and other accessories

- 1 set of screwdrivers with blade widths from 2 to 10 mm
- 1 set of open ended wrenches with opening sizes from 7 to 13 mm
- 1 set of alien keys from 1.5 to 6mm
- 1 clamp
- 1 metal ruler
- 1 gauge
- Sewing thread and test material

8.03 Adjusting the basic machine

8.03.01 Preliminary adjustment of the needle height

Requirement

With the needle bar at TDC there must be approx. 22 mm between the point of the needle and the needle plate



Adjust needle bar 1 (screw 2), without turning it, according to the Requirement.



Adjustment

8.03.02 Needle position in the direction of sewing

Requirement

In its front and rear point of reversal the needle should be the same distance from the inside edges of the needle hole.



• Turn the lever 2.

- A

• Adjust the needle bar frame (screw 1) in accordance with the requirement.

8.03.03 Needle position in vertical sewing direction

Requirement

With the needle bar at BDC, in vertical sewing direction, the needle must be at the center of the needle hole in needle plate.



- Loosen screws 1 (2 pcs).
- Turn on the on/off switch, Click the sewing confirmation key, the system will enter the sewing mode.
- Turn the lever 2 in accordance with requirement.
- Tighten screws 1.
- Turn off the on/off switch and tighten another screw.

8.03.04 Hook-to-needle clearance, needle rise, needle height

Requirement

With the needle at 2.0 after BDC:

1. The hook point must point to the middle of the needle and be 0.05 to 0.1 mm from the needle.

- 2. The top edge of the needle eye must be 0.8 to 1.0 mm beneath the hook point.
- 3. The needle guard 4 must lightly touch the needle.





- Loosen screws 1, 2 and 3.
- Move the hook bearing in accordance with requirement 1 taking care to ensure that the needle is not pressed by the needle guard 4.
- Tighten screws 1 and 2 while positioning the second screw 2 on the recess of the shaft in the direction of rotation.
- Loosen screws 5.
- Bring the needle bar to 2.0 after BDC.
- Position the hook point at the middle of the needle and tighten screws 5.
- Set the needle height in accordance with requirement 2.
- Align needle guard 4 in accordance with requirement 3 by turning the eccentric 7 (screw 8).



Screws 3 remain loosened for further adjustments.

8.03.05 Balancing weight

Requirement

With the needle bar at TDC, the largest eccentricity of the balancing weight 1 must be facing downwards.





- Bring the needle bar to TDC.
- Turn the balancing weight 1 in accordance with the requirement.
- Tighten screws 2.

8.03.06 bobbin case opener

Requirement

1. With the needle bar at BDC, the bobbin case opener 4 must be at its rear point of reversal.

2. When the bobbin case opener 4 is at its rear point of reversal, the width between the bobbin case carrier 5 and the stop spring 6 must be 0.3-0.5mm.3. The top edges of bobbin case opener 4 and bobbin case lug 7 must be at the same height.



Adjustment



- Bring the needle bar to BDC.
- Turn eccentric 1 (screws 2) in accordance with requirement 1.
- Loosen screw 3.
- Bring the bobbin case opener 4 to its rear point of reversal.
- Adjust the clearance between the bobbin case carrier 5 and stop spring 6 in accordance with requirement 3 by turning the bobbin case opener 4.
- Adjust the bobbin case height in accordance with requirement 2 by moving bobbin case opener 4.
- Tighten screw 3.



When tighten screws 2, press the hook downwards and eccentric 1 upwards so that the hook shaft does not exhibit any axial play.

8.03.07 Feed wheel

Requirement

The feed wheel 1 must

- 1. Protrude above the needle plate by the height of the teeth (approx. 0.8 mm).
- 2. Be in the middle of the needle plate cutout.





- Adjust the height of the feed wheel 1 by turning screw 2 in accordance with requirement 1.
- Move bearing case 5 (screws 3 and nut 4) in accordance with requirement 2.

8.03.08 Clearance between roller presser and feed wheel

Requirement

With lever 1 raised the clearance between the roller presser and the feed wheel must be 5 mm.





- Raise lever 1.
- Move bar 2 (screws 3) in accordance with the requirement. Take care to ensure that the roller presser is parallel to the feed wheel.

8.03.09 Roller presser

Requirement

When the roller presser 1 is resting on the feed wheel 5 it must

1. be parallel to the feed wheel 5 when viewed in the direction of sewing.

2. be in the middle of the needle when viewed in the direction of sewing.

3. be as close as possible to the needle when viewed across the direction of sewing.





- Always observe requirement 1 when carrying out the following adjustments.
- Move the roller presser 1 (screw 2) in accordance with requirement 2.
- Allow the roller presser 1 to come to rest on the feed wheel 5.
- Move the roller presser bracket 3 (screw 4) in accordance with requirement 3.



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When sewing very tight curves the roller presser 1 should be moved toward the operator a little.

8.03.10 Thread check spring

Requirement

- 1. The movement of thread check spring 3 should be completed when the needle point penetrates the fabric (spring stroke approx. 7 mm).
- 2. When the largest thread loop is formed while the thread is passed around the hook, the thread check spring 3 should rise slightly from its support.





- Adjust support 1 (screw 2) according to requirement 1.
- To adjust the spring tension of spring 3 turn bushing 4 (screw 2).
- Adjust the thread regulator 5 (screw 6) according to requirement 2.



For technical reasons it may be necessary to deviate from the specified spring stroke or spring tension.

Move the thread regulator 5 (screw 6) towards "+" (= more thread) or "-" (= less thread).
8.03.11 Bobbin winder

Requirement

- 1. When the bobbin winder is engaged, the winding spindle must be driven reliably. When the bobbin winder is disengaged, the friction wheel 5 must not be moved by drive wheel 1.
- 2. The bobbin winder must switch itself off, when the filled thread is about 1 mm from the edge of the bobbin.





- Position drive wheel 1 (screws 2) according to requirement 1.
- Position bolt 3 (screw 4) according to requirement 2.

8.03.12 Pressure of roller presser

Requirement

The material must be fed smoothly. No pressure marks should be visible on the material.





Adjust roller presser pressure with screw 1 according to the requirement.

8.04 Adjusting the thread trimmer

8.04.01 Pre adjusting the thread trimming cam

Requirement

- 1. With the needle bar at BDC, the recess 3 must be pointing downwards vertically.
- 2. The thread trimming cam 1 must be touching the retaining collar 4 on the left.





- Position the needle bar at BDC.
- Turn or move the thread trimming cam 1 (screws 2) in accordance with the requirements.

8.04.02 Roller lever

Requirement

1. With the roller lever 6 in resting position and the needle bar at TDC, there must be a clearance of 0.3 mm between roller 7 and thread trimming cam 8.

2. When the thread trimmer is on and the needle bar is at BDC, roller 7 must be in the middle of the recess in thread trimming cam 8.





- Position the needle bar at TDC.
- Bring the thread trimmer to resting position.
- Move eccentric 1 (screw 2) in accordance with requirement 1.
- Position the needle bar at BDC and disengage latch 3.
- Turn screw 4 (nut 5) in accordance with requirement 2.

8.04.03 Thread trimming solenoid

Requirement

With the roller lever 4 engaged and the thread trimming solenoid activated, there must be a clearance of approx. 1 mm between latch 1 and roller lever 4.





- Disengage latch 1 and push the thread trimming solenoid up as far as possible.
- Move the solenoid housing 2 (screw 3) in accordance with the requirement.

8.04.04 Thread trimming crank

Requirement

With the thread trimmer in resting position, the right hand side of the thread trimming crank 3 must be flush with the right side of thread trimming cam 4.



- Loosen screws 1 and 2.
- Move the thread trimming crank 3 in accordance with the requirement.
- Tighten screw 1.
- Slightly tighten screw 2.



S

Screw 2 remains slightly tightened for further adjustments.

8.04.05 Thread-catcher height

Requirement

The bottom edge of the thread catcher 3 must be 0.8 mm above the bobbin case 4.





- Loosen screws 1 and 2.
- Position thread catcher 3 over the middle of the bobbin case 4.
- Move the thread catcher 3 (screw 5) in accordance with the requirement.
- Find the vertical play of shaft 6, bring retaining collar 7 to rest against bearing case 8 and tighten screw 2.



Screw 1 remains loosened for further adjustments.

8.04.06 Thread-catcher position

Requirement

With the thread trimmer in resting position, the edges of the thread catcher 1 and knife 6 must be flush (see arrow).





- Position the thread trimmer in resting position.
- Turn the thread catcher 1 in accordance with the requirement.
- Bring crank 2 to rest against the bearing case 3 and tighten screw 4, taking care to ensure that the shaft 5 exhibits neither vertical play nor binding.

8.04.07 Thread-catcher position

Requirement

When the point of the thread catcher 2 is 4 mm from the front edge of the knife 3, the knife 3 must be lightly touching the thread catcher 2.





- Disengage latch 1.
- Position the thread catcher 2 in front of the front edge of the knife 3 by turning the handwheel 4 mm.
- Move the knife 3 (screws 4) in accordance with the requirement.

8.04.08 Bobbin-thread clamp spring

Requirement

The clamp spring 1 must

1. not be pressed back during the thread catcher motion,

- 2. reliably clamp the bobbin thread after trimming,
- 3. not hinder the removal and insertion of the bobbin case.





- Bring the thread trimmer to resting position.
- Move the clamp spring 1 (screws 2) in such a way that the clamp lips are as close to the inner wall and the front edge of the thread catcher 3 as possible.
- By bending the clamp spring 1, adjust its height so that it is approx. 0.1 mm from the bottom of the thread catcher 3 and the bobbin thread is held reliably.

8.04.09 Thread trimming cam final adjustment

Requirement

The cutting process must be just completed when the take-up lever is at TDC.



- S
- Disengage the latch.
- Bring the take-up lever to TDC by turning the handwheel.
- Turn the thread trimming cam 1 (screws 2) in accordance with the requirement while ensuring that the thread trimming cam 1 is touching the retaining collar 3.

8.04.10 Manual cutting test

Requirement

1. The thread catcher 2 must not push the bobbin thread in front of it during its forwards movement.

2. At the front point of reversal of the thread catcher 2, the bobbin thread must be approx. 2 mm behind the lug of the thread catcher.

3. After completion of the cutting process, the needle and bobbin threads must be cut reliably and the bobbin thread must be clamped.



- Sew a few stitches.
- Turn off the on/off switch.
- Disengage latch 1.

-A

- Carry out the cutting process by turning the handwheel.
- Check requirement 1. If necessary, readjust the thread catcher in accordance with chapter 8.04.05 Thread-catcher height.
- Check requirement 2. If necessary, readjust the thread catcher in accordance with chapter 8.04.06 Thread-catcher position.
- Check requirement 3. If necessary, readjust the bobbin-thread clamp spring in accordance with chapter 8.04.08 Bobbin-thread clamp spring.

STEP MOTOR FEED DIRECT DRIVE FLAT BED SEWING MACHINE

PARTS LIST

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A. Casting and its accessories

No.	Part No.	Name	Qty.	Remark
1	7.02.11.641	Back cover plate	1	
2	7.02.15.960	Back cover plate screw	7	M5×10
3	7.02.16.408	Plastic plug	1	
4	7.02.16.407	Plastic plug	1	
5	7.02.16.418	Thread take up lever guard cover	1	
6	7.02.15.960	Screw	2	M5×10
7	7.02.16.563	Face plate	1	
8	7.02.15.1075	Face plate screw (Upper)	1	GB/T70.1 M5×55
9	7.02.15.731	Face plate screw (Lower)	1	GB/T70.1 M5×25
10	7.02.15.444	Bracket screw	2	GB/T70.1 M6×10
11	7.02.13.370	Bracket	1	
12	7.02.11.484	Fixed plate	1	
13	7.02.15.966	Screw	1	M6×20
14	7.02.15.067	Nut	1	GB/T6170 M6
15	7.02.15.444	Fixed plate screw	1	GB/T70.1 M6×10
16	7.02.11.483	Safety guard plate	1	
17	7.02.15.964	Safety guard plate screw	1	GB/T70.1 M5×6
18	7.02.10.451	Support screw pin (Short)	2	
19	7.02.11.482	Lower plate	1	
20	7.02.15.972	Lower plate screw	4	GB/T70.1 M5×8
21	7.02.02.652	Push plate (Left)	1	
22	7.02.02.650	Needle plate	1	
23	7.02.15.388	Needle plate screw	2	M4×8
24	7.02.02.651	Push plate (Right)	1	
25	7.02.11.431	Stop plate	1	
26	7.02.15.973	Stop plate screw	2	M4×6
			_	
			_	
L			_	
			_	
			_	
			_	
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Part No. No. Name Qty. Remark 7.02.05.01101 Presser foot lifting lever 1 1 2 7.02.15.056 Set screw 1 GB/T 77 M5×5 7.02.15.057 Set screw GB/T 77 M6×8 3 1 7.02.15.025 Screw 1 4 7.02.15.056 2 GB/T 77 M5×5 5 Set screw 7.02.08.032 Bushing (Upper) 1 6 1 7 7.02.08.033 Bushing (Lower) 7.02.03.009 Guide rail bar 1 8 Presser bar position bracket 7.02.08.007 1 9 10 7.02.15.050 2 Screw M6×0.75×8 7.02.03.420 Presser foot lifting lever shaft 11 1 12 7.02.09.117 Collar 1 13 7.02.15.047 Screw 1 GB/T 77 M4×4 7.02.12.280 Lift block 14 1 15 7.02.15.056 2 Screw GB/T 77 M5×5 7.02.03.421 Presser bar 1 16 7.02.10.457 Stopper pin 1 17 7.02.15.011 Screw 1 M4×8 18 Roller presser bracket 7.02.08.470 1 19 1 20 7.02.17.011 Spring Tailstock 1 21 7.02.05.009 22 7.02.18.071 Washer 1 GB/T 97.1 4 23 7.02.15.006 Screw 1 GB/T 65 M4×8 Small presser foot 1 2.4mm 24 7.02.02.008 7.02.17.009 Safety spring 1 25 7.02.15.026 Screw 1 M4×6 26 7.02.17.012 1 27 Spring 7.02.01.006 Thread tension regulator assy. 1 28

B. Presser bar parts



No.	Part No.	Name	Qty.	Remark
1	7.02.01.353	Thread take up lever assy.	1	
2	7.02.10.462	Thread take up fixed pin	1	
3	7.02.09.003	Plastic stop ring	2	
4	7.02.04.005	Needle bearing	2	
5	7.02.05.003	Thread take up holder	1	
6	7.02.08.476	Thread take up shaft bushing	1	
7	7.02.15.065	Screw	1	
8	7.02.05.004	Thread take up lever	1	
9	7.02.04.004	Bearing	1	624-2Z
10	7.02.04.003	Bearing	2	628/8-2Z
11	7.02.18.030	Elastic retaining ring	2	GB/T 894.1 8
12	7.02.06.001	Thread take up crank	1	
13	7.02.05.005	Needle bar connector	1	
14	7.02.04.006	Bearing	1	HK 1010
15	7.02.18.009	Washer	1	
16	7.02.05.006	Needle bar fixer	1	
17	7.02.15.066	Needle bar fixer screw	1	M5×10
18	7.02.12.002	Needle bar guide slide block	1	
19	7.02.16.011	Oil felt	1	
20	7.02.12.001	Needle bar connector guide slot	1	
21	7.02.15.021	Guide slot screw	2	M4×6
22	7.02.16.012	Oil felt	1	
23	7.02.17.005	Oil felt holder	3	
24	7.02.15.022	Screw	3	M4×4.5
25	7.02.13.522	Needle bar holder	1	
26	7.02.09.119	Ring	1	
27	7.02.15.054	Screw	1	M6×0.75×5
28	7.02.03.401	Needle bar	1	
29	7.02.15.019	Screw	1	M3×4
30	7.02.14.005	Needle bar thread stand	1	
31	7.02.18.002	Washer	4	
32	7.02.04.010	Needle bearing	2	K 15×19×17
33	7.02.08.004	Bushing	2	
34	7.02.11.626	Needel bar limit plate	1	
35	7.02.15.964	Screw	2	GB/T 70.1 M5×6
36	7.02.15.049	Screw	2	GB/T 80 M5×8

C. Needle bar thread take up parts



No.	Part No.	Name	Qty.	Remark
1	7.02.19.345	Tension releasing solenoid	1	
2	7.02.16.410	Solenoid joint	1	
3	7.02.11.500	Tension releasing solenoid mounting plate	1	
4	7.02.15.976	Screw	2	GB/T 70.1 M3×5
5	7.02.15.003	Screw	2	M5×8
6	7.02.10.456	Tension releasing lever	1	
7	7.02.01.377	Thread guide plate	1	
8	7.02.15.973	Screw	2	M4×6
9	7.02.01.373	Thread tension regulator assy.	1	
9-1		Thread tension plate	1	
9-2		Thread tension plate (small)	2	
9-3		Adjusting spring	1	
9-4		Nut	1	
9-5		Screw	1	
9-6		Nut	1	
9-7		Thread tension disk	2	
9-8		Thread disk	1	
9-9		Adjusting spring	1	
9-10		Spring plate	1	
9-11		Nut	1	
9-12		Washer	1	
9-13		Fixed plate	1	
9-14		Thread guide disk	1	
9-15		Washer	1	
9-16		Washer	1	
9-17		Thread take-up spring	1	
9-18		Sleeve	1	
9-19		Pipe casing	1	
9-20		Washer	1	
9-21		Screw	1	
9-22		Thread guide plate	1	
9-23		Washer	1	
9-24		Screw	1	
9-25		Split washer	2	
9-26		Tension releasing plate	1	
9-27		Tension releasing pin	1	
10	7.02.15.960	Screw	1	M5×10
11	7.02.15.049	Screw	1	GB/T 80 M5×8

D. Thread tension regulator parts



No.	Part No.	Name	Qty.	Remark
1	7.02.06.002	Cam	1	
2	7.02.15.013	Cam position screw	1	M7
3	7.02.15.014	Cam set screw	1	M7×13
4	7.02.15.053	Screw	2	GB/T 70.1 M5×12
5	7.02.15.050	Set screw	1	M6×0.75×8
6	7.02.04.008	Bearing	1	6204-2ZNR
7	7.02.09.004	Upper shaft bushing	1	
8	7.02.03.538	Upper shaft	1	
9	7.02.07.262	Thread winder driven wheel	1	118 570
10	7.02.15.049	Set screw	2	GB/T 80 M5×8
11	7.02.07.338	Timing belt	1	680-5M12
12	7.02.07.350	Timing belt wheel (upper)	1	
13	7.02.15.050	Concave end set screw	3	M6×0.75×8
14	7.02.15.990	Flat set screw	3	M6×0.75×8
15	7.02.04.007	Bearing	1	6004-2ZNR
16	7.02.05.592	Coupling (left)	1	
17	7.02.05.593	Coupling (right)	1	
18	7.02.09.120	Stitch length indicating ring	1	
19	7.02.07.280	Pulley	1	
20	7.02.15.057	Screw	2	GB/T 77 M6×8
21	7.02.18.145	Elastic retaining ring	1	GB/T894.1 10
22	7.02.12.281	Tension wheel	1	
22-1		Tension wheel	1	
22-2	7.02.04.023	Bearing	1	6000-2Z
22-3	7.02.18.201	Elastic retaining ring	2	GB/T893.1 26
23	7.02.13.521	Tension wheel bracket	1	
24	7.02.15.594	Screw	2	GB/T70.1 M6×12

E. Upper shaft driving parts



Part No. Qty. No. Name Remark 7.02.13.523 Motor mounting bracket 1 1 2 7.02.15.053 Screw 2 GB/T 70.1 M5×12 7.02.04.240 626-2Z 3 Bearing 1 7.02.18.290 Washer 1 6×11×1.5 4 7.02.11.627 Fixed position plate 1 5 7.02.18.070 Washer 1 3×7×0.5 6 GB/T 70.1 M3×5 7 7.02.15.976 Screw 1 7.02.15.053 GB/T 70.1 M5×12 8 Screw 3 7.02.01.375 Needle bar vibrating link assy. 1 9 7.02.10.605 Needle bar vibrating eccentric shaft 10 1 11 Washer 2 10×18×1.0 12 Needle bearing 1 K 10×13×10 7.02.05.590 Needle bar vibrating link 1 13 7.02.15.056 Screw GB/T77 M5×5 14 1 7.02.18.028 Split retaining ring 1 15 GB/T896 8 Needle bar vibrating crank 7.02.05.591 1 16 7.02.04.009 Needle bearing 1 K 8×11×10 17 7.02.18.009 Washer 1 18 7.02.10.606 Link pin 1 19 20 7.02.18.030 Elastic retaining ring 1 GB/T 894.1 8 Screw 1 21 7.02.15.048 GB/T 70.1 M6×16 22 7.02.15.056 Screw 2 GB/T77 M5×5 23 7.02.09.006 Collar 1 7.02.15.054 1 M6×0.75×5 24 Screw 7.02.18.011 Washer 25 1

F. Needle bar vibrating parts



No. Part No. Name Qty. Remark 7.02.15.1098 Presser regulating screw M8×0.75 1 1 2 7.02.17.409 Spring pressure plate 1 7.02.15.791 Spring pressure plate support screw 3 1 4 7.02.18.039 Split retaining ring 1 GB/T 896-5 2 7.02.15.058 GB/T 70.1 M5×16 5 Screw Presser regulating screw fixed position block 7.02.12.360 1 6 7.02.15.989 **Restrict screw** 2 7 M6×25 7.02.15.067 2 GB/T6170 M6 8 Nut Knee lifting lever connecting rod 9 7.02.17.410 1 Split retaining ring 7.02.18.031 GB/T 896-4 10 1 7.02.06.270 Presser foot lifting crank 11 1 2 12 7.02.15.053 Crank screw GB/T 70.1 M5×12 7.02.17.003 Spring fixed plate 1 13 7.02.17.414 Tension spring 14 1 15 7.02.15.972 Screw 1 GB/T 70.1 M5×8 7.02.10.006 Fixed pin 1 16 7.02.15.068 Nut 1 GB/T 6170 M5 17 7.02.18.055 Spring washer 1 GB/T93 5 18 7.02.10.146 Presser foot lifting crank pink 1 19 7.02.12.081 1 20 Slide post Split retaining ring 1 21 7.02.18.031 GB/T 896-4 22 7.02.03.402 Presser foot lifting shft 1 23 7.02.18.023 Elastic retaining ring 1 GB/T894.1 12 7.02.10.006 1 24 Fixed pin

G. Presser foot lifting parts



No.	Part No.	Name	Qty.	Remark
1	7.02.21.029	Thread post	1	
2		Nut	1	
3	7.02.01.302	Bobbin winder thread tension assy.	1	
4	7.02.01.281	Bobbin winder assy.	1	
4-1		Stop screw	1	
4-2		Stop block	1	
4-3		Rubber ring	1	
4-4		Driven wheel	1	
4-5		Spring	1	
4-6		Adjusting plate	1	
4-7		Bobbin winder seat	1	
4-8		Reseting spring	1	
4-9		Bearing	2	
4-10		Bobbin winder shaft bushing	1	
4-11		Bobbin winder shaft	1	
4-12		Spring	1	
4-13		Plastic plug	1	
4-14		Elastic retaining ring	1	
4-15		Spring	1	
4-16		Split retaining ring	1	
4-17		Adjusting seat	1	
4-18		Adjusting bar	1	
4-19		Washer	1	
4-20		Screw	1	
4-21		Cutter	1	
4-22		Cutter screw	1	
4-23		Screw	1	
5	7.02.15.032	Screw	1	

H. Bobbin winder parts



No. Part No. Name Qty. Remark 7.02.03.535 Lower shaft (left) 1 1 Coupling (left) 2 7.02.08.013 1 Inner hexagonalconcave end set screw 7.02.15.050 M6×0.75×8 3 6 4 7.02.15.990 Inner hexagonal flat end set screw 6 M6×0.75×8 5 7.02.11.001 Connecting plate 1 7.02.01.008 Clutch assy. 1 6 Bearing bushing (right) 7 7.02.08.010 1 Screw 7.02.15.054 8 4 M6×0.75×5 Ball bearing 9 7.02.04.012 1 7.02.03.530 Lower shaft (right) 10 1 Synchronous belt wheel(lower) 11 7.02.07.351 1 12 7.02.04.013 Ball bearing 1 13 7.02.08.011 Bearing bushing (right) 1 Oil box assy. 7.02.16.430 14 1 15 7.02.15.973 Screw 1 M4×6 16 Oil tube 1 ø3×ø5×600 17 7.02.17.029 Oil tube clamp 1 18 7.02.16.596 Oil volume regulating valve 1 19 Oil tube 1 20 Oil tube joint 1

1. Lower shaft driving	parts
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No.	Part No.	Name	Qty.	Remark
1	7.02.19.041	Presser foot lifting solenoid	1	
2	7.02.15.268	Nut	1	
3	7.02.15.098	Screw	1	M4×20
4	7.02.15.105	Presser foot lifting solenoid screw	3	M6×9
5	7.02.11.642	Presser foot lifting solenoid fixed plate	1	
6	7.02.15.960	Rear cover plate screw	4	M5×10
7	7.02.13.373	Spring fixed plate	1	
8	7.02.15.972	Screw	2	GB/T 70.1 M5×8
9	7.02.13.374	Top post assy.	1	
10	7.02.13.376	Bend lever assy.	1	
11	7.02.13.375	Foot preeser lifting post assy.	1	
12	7.02.17.414	Tension spring	1	
13	7.02.17.415	Shell fragment assy.	1	
14	7.02.15.026	Screw	2	M4×6
15	7.02.21.461	Knee lifting lever assy.	1	
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J. Solenoid for presser foot lifting parts


No.	Part No.	Name	Qty.	Remark
1	7.02.11.628	Motor fixed plate (upper)	1	
2	7.02.16.568	Rubber insert	2	
3	7.02.15.1097	Fixed plate screw	2	
4	7.02.15.803	Screw	3	GB/T70.1 M5×10
5	7.02.01.376	Connecting lever assy.	1	
5-1		Connector	2	
5-2		Screw	4	M4×3
5-3		Connecting pin	4	
5-4		Connecting block	2	
5-5		Connecting lever assy.	1	
5-6		Spring	1	
5-7		Connecting shaft	1	
5-8		Pin	1	
6	7.02.05.002	Connecting seat	1	
7	7.02.02.670	Roller presser foot	1	
8	7.02.15.011	Screw	1	
•	1			

K. Upper feed parts



Part No. No. Name Qty. Remark 7.02.13.495 1 Feed gear seat 1 2 7.02.01.384 Fixed plate 1 3 7.02.15.594 Screw 2 GB/T70.1 M6×12 7.02.17.381 1 4 Spring 7.02.18.290 Washer 2 GB/T 97.1 6 5 7.02.15.067 Nut 2 GB/T6170 M6 6 7 7.02.03.405 Connecting shaft 1 Connecting shaft bushing 1 8 7.02.08.461 7.02.15.056 1 M5×5 9 Screw 10 7.02.15.057 Screw 1 M6×8 Fixed plate pad block 11 7.02.12.348 1 12 7.02.15.416 Screw 2 M5×12 7.02.11.643 Motor fixed plate 1 13 M4×8 7.02.15.032 Screw 3 14 7.02.07.010 15 Bevel gear (big) 1 7.02.15.054 2 M6×0.75×5 16 Screw Screw 3 GB/T70.1 M5×10 17 7.02.15.803 7.02.18.027 Elastic retaining ring 18 1 ø22 627-2Z 7.02.04.242 19 Bearing 1 Split retaining ring 20 7.02.18.072 1 GB/T896 6 Bevel gear (small) 21 7.02.07.009 1 22 7.02.15.054 Screw 2 M6×0.75×5 23 7.02.15.049 Screw 1 M5×8 Feed gear assy. 1 24 7.02.07.254 1 25 7.02.04.009 Bearing K 8×11×10 7.02.10.443 Feed gear eccentric pin 1 26 7.02.09.002 1 27 Ring 7.02.15.036 Screw 2 M5×4 28 7.02.04.023 1 6000-2Z 29 Bearing 30 7.02.18.026 Elastic retaining ring 1 ø26 7.02.07.342 1 31 Gear shaft

L. Lower feed parts



Part No. Qty. No. Name Remark 7.02.02.630 1 Hook assy. 1 2 7.02.21.385 Bobbin 1 M5×20 3 7.02.15.038 Hook screw 1 7.02.18.436 1 4 Hook washer (small) 7.02.03.531 Hook shaft assy. 1 5 7.02.17.504 Spring 1 6 7.02.18.437 Hook washer (big) 1 7 7.02.11.639 1 8 Bearing cover 9 7.02.15.432 Screw 2 GB/T65 M3×8 10 Oil tube 1 11 Oil wick 1 12 7.02.13.490 Hook saddle 1 7.02.18.290 Washer 2 13 7.02.15.1130 Hook saddle screw 2 GB/T70.1 M6×35 14 7.02.08.610 15 Lower shaft bushing 1 7.02.15.990 Flat end set screw 1 16 M6×0.75×8 7.02.15.050 Concave set screw 1 M6×0.75×8 17 7.02.04.007 Bearing 2 6004-2ZNR 18 Hook gear (big) 7.02.07.340 19 1 20 7.02.07.341 Hook gear (small) 1 21 7.02.15.054 Set screw 8 M6×0.75×5 22 7.02.18.434 Gear retaining ring 1 23 7.02.12.346 Balanced block 1 7.02.16.550 Hook saddle oil plug 1 24 7.02.11.634 Hook saddle cover plate 2 25 7.02.15.006 4 GB/T65 M4×8 26 Screw

M. Hook driving parts (1)



N. Hook driving parts (2)

No.	Part No.	Name	Qty.	Remark
1	7.02.02.653	Thread distributing claw	1	
2	7.02.15.063	Screw	1	GB/T70.1 M4×10
3	7.02.15.1132	Stop block screw	1	GB/T65 M4×20
4	7.02.11.635	Stop block pad plate	1	
5	7.02.12.345	Hook stop block	1	
6	7.02.18.433	Retaining ring	1	
7	7.02.18.432	Retaining ring	1	ø6.2×ø11.8×0.5
8	7.02.04.231	Needle bearing	2	K 6×9×8
9	7.02.18.431	Retaining ring	1	ø6×ø16×8
10	7.02.15.056	Screw	2	M5×5
11	7.02.18.030	Retaining ring	1	GB/T894.1 8
12	7.02.18.010	Washer	1	ø8.3×ø14×0.4
13	7.02.13.491	Thread distributing claw bracket	1	
14	7.02.15.1131	Screw	2	GB/T70.3 M5×16
15	7.02.03.536	Movable knife shaft (short)	1	
16	7.02.09.191	Movable knife collar (small)	1	ø5×ø10×6
17	7.02.15.666	Screw	1	M3×3
18	7.02.06.480	Thread distributing cam	1	
19	7.02.15.056	Screw	2	M5×5
20	7.02.04.230	Bearing	1	GB/T276-61802-2Z
21	7.02.06.481	Thread distributing link	1	
22	7.02.04.005	Needle bearing	1	K 7×10×8
23	7.02.10.583	Link pin	1	
24	7.02.03.532	Thread distributing crank shaft	1	
25	7.02.18.295	Elastic retaining ring	1	GB/T894.1 7
26	7.02.04.016	Bearing	2	608-2Z
27	7.02.18.027	Elastic retaining ring	2	ø22
28	7.02.13.493	Fixed knife seat	1	
29	7.02.15.572	Screw	1	GB/T 70.1 M4×16
30	7.02.20.111	Fixed knife	1	
31	7.02.15.800	Screw	4	GB/T70.1 M3×6
32	7.02.18.260	Washer	4	ø3.2×ø6×0.5
33	7.02.11.644	Thread clamping plate	1	
34	7.02.20.113	Thread clamping shell fragment	1	
35	7.02.15.1155	Shell fragment screw	1	M2×1.8
36	7.02.10.585	Rivet	1	
37	7.02.20.110	Movable knife	1	
38	7.02.15.1133	Movable knife screw	1	M4×6
39	7.02.03.534	Movable knife shaft	1	
40	7.02.11.638	Connecting plate	1	
41	7.02.10.584	Connecting screw	2	
42	7.02.13.492	Movable knife vibraing seat	1	
43	7.02.15.056	Screw	1	M5×5
44	7.02.09.190	Movable knife shaft collar	1	
45	7.02.15.047	Screw	2	M4×4



No. Part No. Name Qty. Remark 7.02.13.494 1 Thread trimming seat 1 2 7.02.15.445 Screw 2 GB/T70.1 M6×25 GB/T6170 M6 3 7.02.15.067 Nut 1 7.02.15.1134 1 M6×30 4 Stop screw Thread trimming crank shaft 1 5 7.02.03.533 7.02.06.482 Thread trimming crank 1 6 7 7.02.15.048 Screw 1 GB/T70.1 M6×16 7.02.10.582 1 8 Connecting pin 2 7.02.18.072 Split retaining ring GB/T896-6 9 10 7.02.17.502 Vibrating plate reseting spring 1 11 7.02.11.637 Thread trimming vibrating plate 1 12 7.02.06.485 Thread trimming cam 1 7.02.15.050 Screw 2 M6×0.75×8 13 Bearing bushing 7.02.08.010 14 1 Screw 2 15 7.02.15.056 7.02.04.012 1 16 Bearing 6202-2ZNR Two hole connection terminal 1 17 7.02.19.335 7.02.15.948 Screw 1 M3×10 18 7.02.17.500 Solenoid connecting ring 1 19 20 7.02.19.430 Thread trimming solenoid 1 1 21 7.02.11.636 Stop plate 7.02.17.501 Stop plate reseting spring 1 22 23 7.02.18.039 Split retaining ring 1 GB/T896-5 1 24 7.02.10.581 Eccentric pin Screw 1 7.02.15.056 GB/T 77 M5×5 25 7.02.18.054 Flat washer ø10×ø17.5×1.5 26 1 7.02.18.028 1 GB/T896 8 27 Split retaining ring 7.02.15.068 1 28 Nut GB/T6170 M5 GB/T70.1 M5×25 29 7.02.15.731 Screw 1 30 7.02.17.503 Thread trimming reseting spring 1 Thread trimming crank (right) 1 31 7.02.06.483 7.02.15.048 Screw 1 GB/T70.1 M6×16 32 7.02.05.093 Thread trimming link 2 33 Thread trimming connecting rod 7.02.10.193 1 34 7.02.15.622 35 Nut 1 M5(left) Thread trimming link 36 7.02.10.382 1 7.02.15.068 Nut 1 GB/T6170 M5 37 7.02.15.058 GB/T70.1 M5×16 38 Screw 2 39 7.02.06.484 Thread trimming crank (left) 1 40 7.02.15.048 Screw 1 GB/T70.1 M6×16

0. Thread trimming parts



P. Backstitch lever parts

No.	Part No.	Name	Qty.	Remark
1	7.02.05.585	Backstitch lever	1	
2	7.02.15.058	Backstitch lever screw	1	GB/T70.1 M5×16
3	7.02.17.117	Reseting spring	1	
4	7.02.11.088	Fixed plate	1	
5	7.02.15.420	Screw	1	M4×6
6	7.02.16.562	Backstitch lever handle	1	
7	7.02.15.006	Screw	2	GB/T 65 M4×8
8	7.02.09.130	Collar	1	
9	7.02.15.056	Screw	1	GB/T 77 M5×5
10	7.02.05.596	Backstitch lever shaft	1	
11	7.02.15.988	Backstitch lever stop screw	2	
12		Plastic bushing	2	
13	7.02.19.356	Backstitch switch	1	
14	7.02.15.802	Screw	2	M3×13
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Q. Electronic control parts

No.	Part No.	Name	Qty.	Remark
1	7.02.19.455	Electronic control assy.	1	琦星
2	7.02.16.551	Control box cover	1	
3		Control box	1	
4		Main shaft motor	1	
5		Screen panel	1	
6		Panel pick-up pin box transfer line	1	
7		Panel burning transfer line	1	
8		Vibrating needle step motor	1	
9		Vibrating needle setp motor transfer line	1	
10		Vibrating needle encoder line	1	
11		Knee by stitch length transfer line (Y1)	1	
12		Head change stitch length transfer line (Y2)	1	
13		5V transfer line (Y3)	1	
14		Function transfer line (Y4)	1	
15		Manual backstitch transfer line (Y5)	1	
16		Presser foot lifting solenoid transfer line (X2)	1	
17		Thread tension releasing solenoid transfer line (X5)	1	
18		Thread trimming solenoid transfer line (X6)	1	
19		Upper feed step motor	1	
20		Upper feed step motor transfer line	1	
21		Lower feed step motor	1	
22		Lower feed step motor transfer line	1	
23		Foot pedal	1	
24		Foot pedal mounting screw	3	
25		Foot pedal transfer line	1	
26		Drawbar	1	
27		Power transfer line	1	
28	7.02.15.047	Screen panel set screw	3	M4×4
29	7.02.15.731	Main shaft motor mounting screw	4	GB/T 70.1 M5×25
30	7.02.15.798	Control box screw	2	GB/T 70.1 M5×30
31	7.02.15.1126	Control box screw (long)	1	GB/T 70.1 M5×35
32	7.02.19.395	Two color light switch assy.	1	
33	7.02.15.555	Screw	2	GB/T 70.1 M4×8
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Q. Electronic control parts



R. Accessories

No.	Part No.	Name	Qty.	Remark
1	7.02.21.001	Screw driver (small)	1	
2	7.02.21.002	Screw driver (middle)	1	
3	7.02.21.003	Screw driver (large)	1	
4	7.02.21.004	Hinge pin	2	
5	7.02.21.005	Hinge connecting seat	2	
6	7.02.21.027	Parallel pin	2	
7	7.02.21.464	Rubber block (big)	2	
8	7.02.21.016	Needle	1	
9	7.02.21.385	Bobbin	4	
10	7.02.21.100	5# inner hexagon spanner	1	
11	7.02.21.099	4# inner hexagon spanner	1	
12	7.02.21.209	3# inner hexagon spanner	1	
13	7.02.21.098	2.5# inner hexagon spanner	1	
14	7.02.21.474	Oil can	1	
15	7.02.21.018	Head packing bag (neutral)	1	
16	7.02.21.050	Thread stand	1	
17	7.02.01.357	Swing on guide assy.	1	
18	7.02.21.46501	0il reservior	1	
19	7.02.21.033	Screw (small)	4	

