

在使用缝纫机之前请阅读本使用说明书。
请将本使用说明书放在便于查阅的地方保管。



高速电子套结一体机 ZJ1900D-0605-V4
COMPUTER-CONTROLLED HIGH SPEED LOCKSTITCH BAR
TACKING MACHINE SERIES

使用说明书

OPERATION MANUAL

零件手册

PARTS BOOK



手机官网



官方订阅号

浙江中捷缝纫科技有限公司
ZOJE SEWING MACHINE CO.,LTD

为了创造更加美好的环境

请您协作

首先对您使用我们的产品表示衷心的感谢！

我们公司致力于关爱地球环境，制定了“智能制造、绿色制造”的基本方针。当地的公民在环境保护活动中也应该对当地社会、环境二方面尽每个人的微薄之力。

因此，希望您能配合这个计划，作为环境保护活动的一环，在平时处理废弃物的时候能多加注意。

- 1.不用的包装材料，为了能再次回收利用，请交付给当地相关回收公司进行处理。
- 2.使用完的润滑油、请根据相关的法律和规定进行妥善处理。
- 3.产品保养或修理需要更换零部件时，有不需要的电路板和电子零件，以及产品废弃时，请作为电子废弃物处理。

非常感谢您购买我们工业缝纫机。
在使用缝纫机之前，请仔细阅读<为了您的安全使用>和使用说明。
工业缝纫机的特性之一，因为要在机针和旋梭等运动零部件附近进行操作，而这些零部件很容易引起受伤的危险，所以请在受过培训的人或熟练人员的安全操作知识的指导下，正确地使用本缝纫机。

为了您的安全使用

[1] 安全使用的标记及其意义

本使用说明书及产品所使用的标记和图案记号是为了您的安全而正确地使用产品，防止您及其他人受到危害和损害。

表示方法及含意如下。

标记

 危险	该内容表示如果忽视此标志而进行错误的操作，必将导致死亡或重伤。
 警告	该内容表示如果忽视此标志而进行错误的操作，肯定会引起死亡或重伤。
 注意	如果忽视此标志而进行错误的操作，有可能会引起受到轻微或中度伤害。

图案和符号



…………… 该符号（△）表示“应注意事项”。
三角中的图案表示必须要注意的实质内容。
（例如，左边的内容表示“当心受伤”。）



…………… 该符号（⊘）表示“禁止”。



…………… 该符号（●）表示“必须”。

[2] 安全注意事项



危险



在关闭电源开关并将电源插头从插座上拔下后，至少等待 5 分钟，再打开控制箱盖。触摸带有高压的区域将会造成人员伤亡。



警告



缝纫机内不允许进入任何液体，否则会引起火灾，电击或操作故障。

如果缝纫机内（机头或控制箱）进入任何液体，请立即关闭电源，并将电源插座头从插座上拔出，然后联系销售商或资深技术人员。



注意

使用环境



请不要在有电源线干扰及静电干扰等有强电气干扰源影响的环下使用。

强电气干扰源可能会影响缝纫机正确操作。



电源电压的波动应该在额定电压的±10%以内的环境下使用。

电压大幅度的波动会影响缝纫机正确操作。



电源容量应大于缝纫机的消耗电量。电源容量不足会影响缝纫机的正确操作。



环境温度应在 5℃-35℃ 的范围内使用。

低温或者高温会影响缝纫机的正确操作。



相对湿度应在 45%-85% 的范围内，并且设备内不会结露的环境下使用。干燥或多湿的环境和结露会影响缝纫机的正确操作。



万一发生雷电暴风雨时，关闭电源开关，并将电源插头从插座上拔下。雷电可能会影响缝纫机的正确操作。



请勿将 USB 存储器以为的设备连接到 USB 连接端口上，否则有可能导致故障。

安装



请让受过培训的技术人员来安装缝纫机。



请委托购买商店或电气专业人员进行电气配线。



缝纫机重约 58kg，安装人员必须有两人以上来完成。



在安装完成前，请不要连接电源，如果误踩下脚踏板时，缝纫机动作会导致受伤。



请在切断电源后，在拔掉电插头。不然容易成为控制箱发生故障的原因。



必须接地。



接触地线不牢固，是造成触电误动作原因。



固定电缆时，不要过度弯曲电缆或用卡钉固定得过紧，会引起火灾或触电的危险。



如果使用带小脚轮的工作台，则应该固定小脚轮，使其不能移动。



缝纫机头倒下时，请一定要固定工作台，不可使其随意移动。



工作台移动易发生脚等被夹住之事故，是导致人身事故的原因。



缝纫机头倒下或竖起时，请用双手操作。

单手操作时因缝纫机的重量万一滑落易导致受伤。



使用润滑油和黄油时，务必戴好保护眼镜和保护手套等，以防润滑油落入眼中或沾在皮肤上，这是引起发炎的原因。

另外，润滑油或黄油不能饮用，否则会引起呕吐和腹泻。

将油放在小孩拿不到的地方。



注意

缝纫



本缝纫机仅限于接受过安全操作培训的人员使用



本缝纫机不能用于除缝纫外的任何其他用途。



使用缝纫机时必须戴上保护眼镜。

如果不戴保护眼镜，断针时就会有危险，机针的折断部分可能会弹入眼镜并造成伤害。



发生下列情况时，请切断电源。

否则误按开关缝纫机动作会导致受伤。

- 机针穿线时
- 更换机针或梭芯时
- 缝纫机不使用，或人离开缝纫机时



如果使用带小脚轮的工作台，则应该固定小脚轮，使其不能移动。



为了安全起见，在使用本缝纫机之前，请安装保护装置。如果未安装这些安全装置就使用缝纫机，会造成人身伤害及缝纫机损坏。



缝纫过程中，不要触摸任何运动部件或物件靠在运动部件上，因为这会导致人员受伤或缝纫机损坏。



缝纫机头倒下时，请一定要固定工作台，不可使其随意移动。

工作台移动容易发生脚等被夹住事故，是导致人身事故的原因。



缝纫机头倒下或竖起时，请用双手操作。

单手操作时因缝纫机的重量万一滑落容易导致受伤。



如果缝纫机操作中发生误操作，或听到异常的噪音或闻到异常的气味，应立即切断电源。然后请与购买商店或受过培训的技术人员联系。



如果缝纫机出现故障，请与购买商店或受过培训的技术人员联系

清洁



在开始清洁作业前，请切断电源。

如果误按开关缝纫机动作会导致人员受伤。



缝纫机头倒下时，请一定要固定工作台，不可使其随意移动。

工作台移动易发生脚等夹住事故，是导致人身事故的原因。



缝纫机头倒下或竖起时，请用双手操作。

单手操作时因缝纫机的重量万一滑落易导致受伤。



使用润滑油和黄油时，务必戴好保护眼镜和保护手套等，以防润滑油落入眼中或沾在皮肤上，这是引起发炎的原因。

另外，润滑油或黄油不能饮用，否则会引起呕吐和腹泻。

将油放在小孩拿不到的地方。

保养和检查



只有经过训练的技术人员才能进行缝纫机的维修、保养和检查。



与电气有关的维修、保养和检验请委托购买商店或电气专业人员维修。



发生下列情况时，请关闭电源，并从电源插座上拔下插头。

否则误按开关时缝纫机会导致误伤。

- 检查、调整和维修
- 更换旋梭，切刀容易损零部件



打开马达罩盖前，务必先关闭电源，等待一分钟后，再执行操作。

触摸马达表面可能会导致烫伤。



在接上电源开关进行调整时，务必切换到保养模式，遵守所有注意事项。



缝纫机头倒下时，请一定要固定工作台，不可使其随意移动。工作台移动易发生脚等被夹，导致人员事故。



缝纫机头倒下或竖起时，请用双手操作，单手操作万一滑落容易导致受伤。

更换零件或安装可选附件时，请务必使用正品零件。否则将不承担由使用非正品零件而造成的任何事故或故障责任。



安全保护装置再次安装时，请务必安装在原位上，并检查能正常发挥作用。



为防止发生事故及故障，请勿擅自改造本缝纫机。我们将不承担由改造缝纫机二造成的任何事故及故障责任。

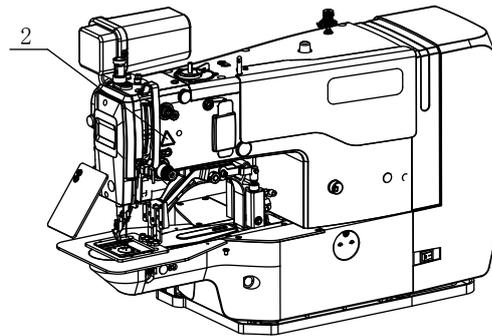
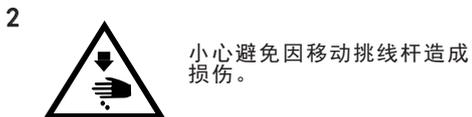
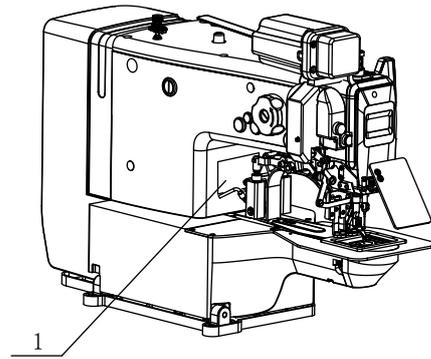


[3] 警告标签

产品上的所有的警告标签的含义及产品上警告标签的位置示意图

缝纫机上有下列警告标签。

当使用缝纫机时，请遵守标签上的说明。如果标签脱落或模糊不清，请和购买商店联系。



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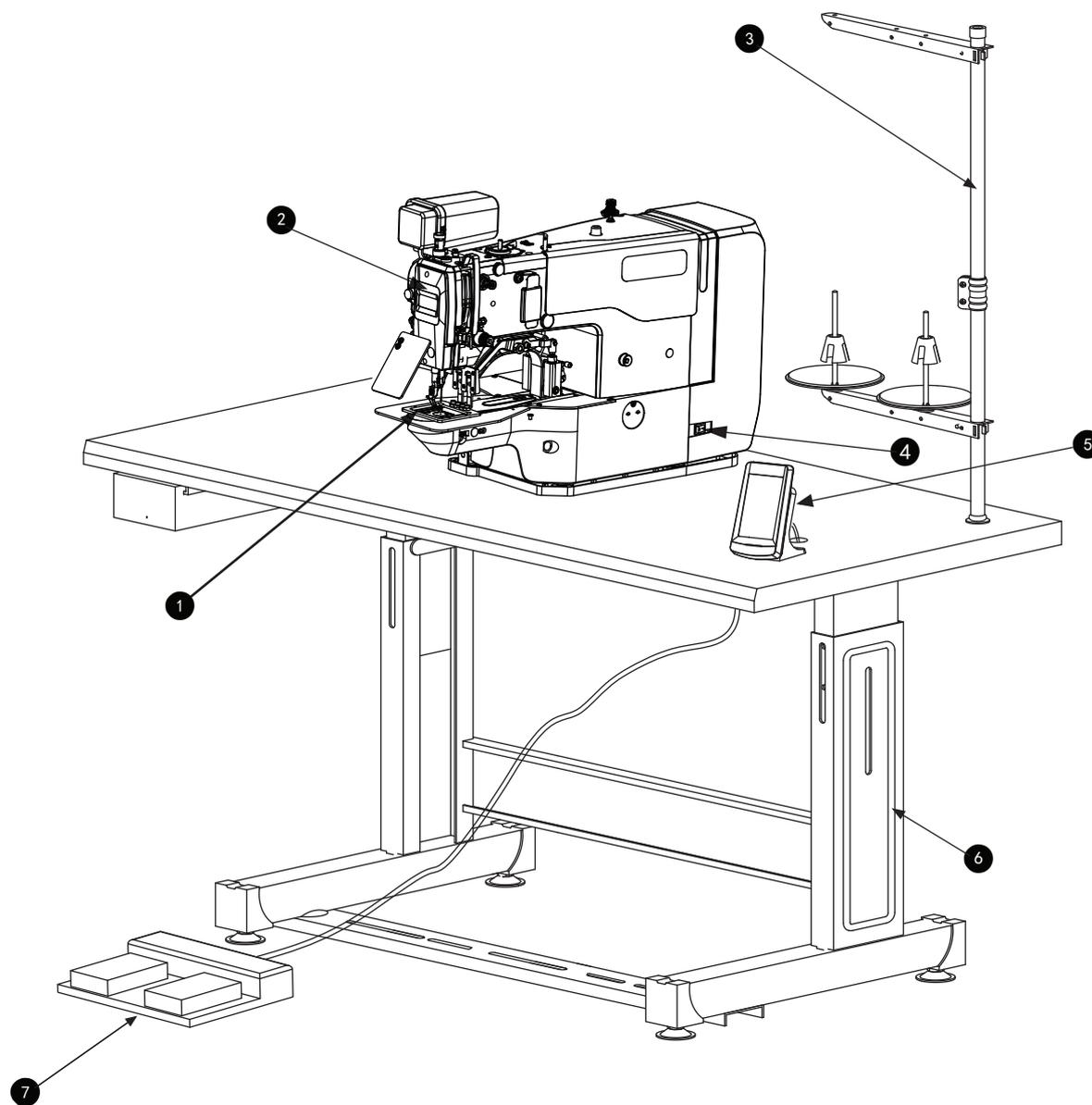
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I. 一体式高速电子套结机说明

[1] 规格

1. 缝制范围：X（左右）方向 60mm，Y（前后）方向 50mm
2. 缝纫速度:2700rpm
3. 线迹长度：0.1-10mm
4. 压脚送布：间断送布
5. 针杆行程：41.2mm
6. 使用机针：DP×5、DP×17
7. 压脚上升量：标准 13mm 最大 17mm
8. 旋梭：标准摆梭（油线润滑）
9. 使用机油：10#白油
10. 数据记录：EPROM
11. 放大、缩小功能：X 方向、Y 方向各为 20-200%
12. 放大、缩小方式：调整线迹长短方式
13. 缝纫速度限制：400-2700
14. 底线计数器：上升/下降方式（1-99999）
15. 缝纫机马达：550W 伺服马达
16. 外形尺寸：W: 1200mm L: 540mm H:1100mm
17. 重量：整机 58Kg
18. 功率：0.6KW
19. 使用温度范围：0℃-50℃
20. 使用湿度范围：35%-85%（无节露）
21. 电源电压：额定电机±10% 50-60Hz

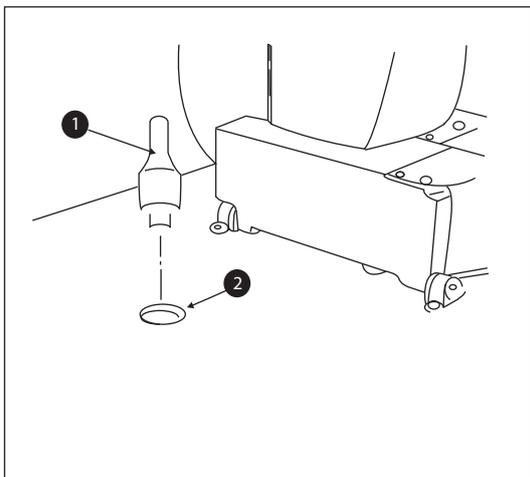
[2] 各部件名称



- (1). 送布压脚
- (2). 缝纫机机头
- (3). 线架
- (4). 电源开关
- (5). 操作面板
- (6). 机架
- (7). 脚踏开关

[3] 整机安装

1. 机头支撑杆的安装



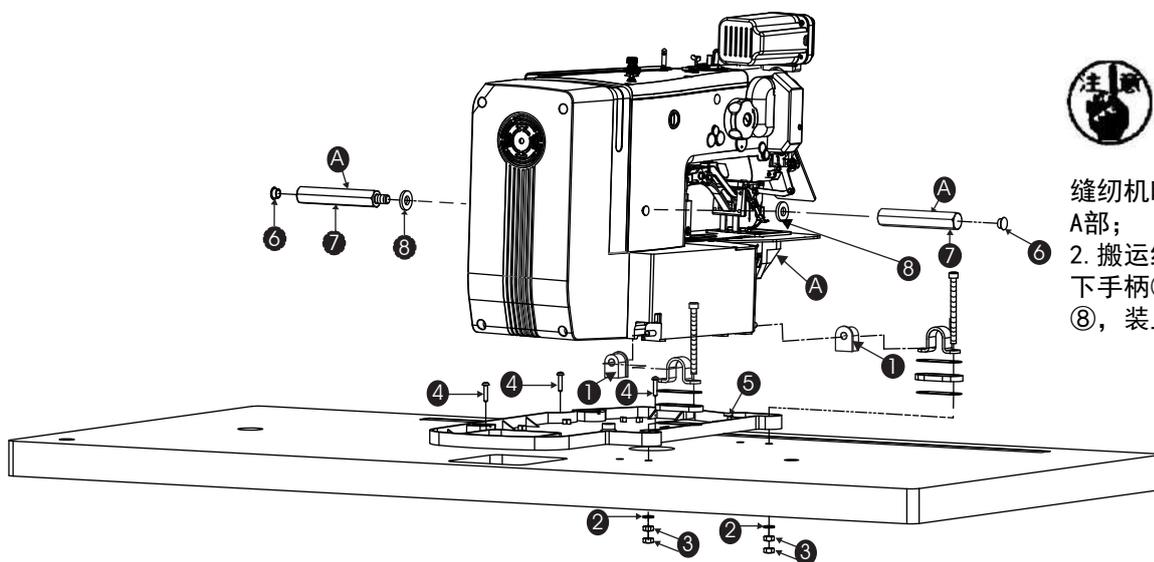
将机头支撑杆①装在台板孔②内。

2. 机头的安装



注意

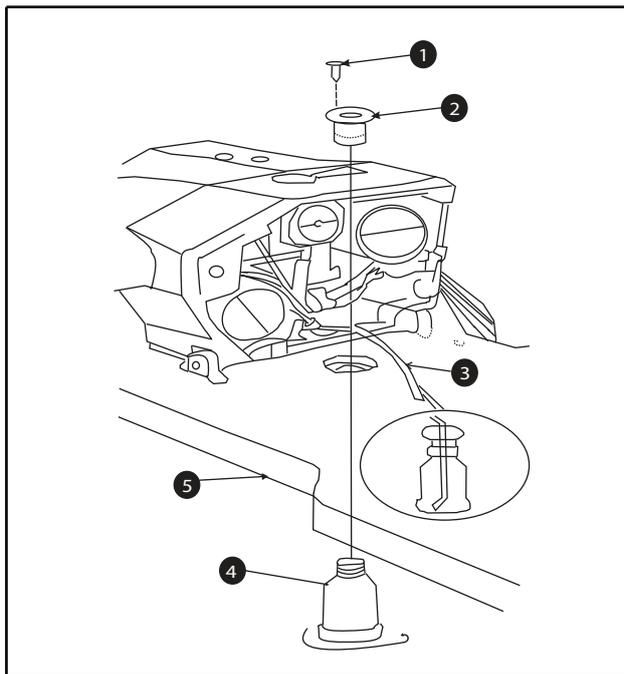
搬运缝纫机时，请一定是两人以上进行操作。



1. 搬运缝纫机时，请手持A部；
2. 搬运结束，请卸下手柄⑦及橡胶垫⑧，装上橡胶塞⑥。

- (1). 将油盘⑤用木螺钉④固定在台板相应位置上；
- (2). 将机头胶垫①穿在机器支撑轴上，固定缝纫机主体；
- (3). 将平垫②、螺母③按图示依次固定，注意螺母③的锁紧力量，如果拧的太紧，防震效果不理想

3. 废油壶的安装

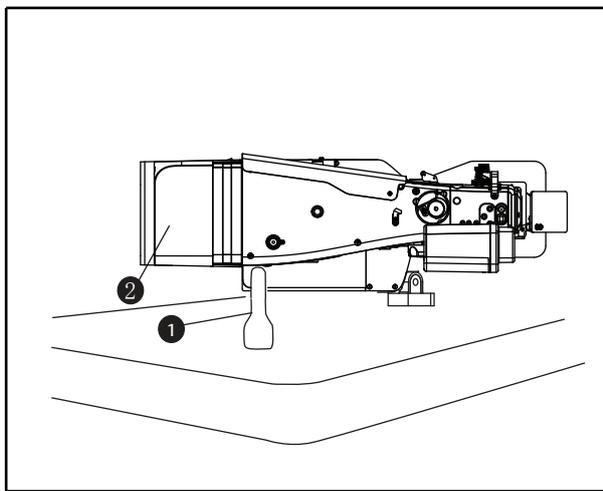


用四个木螺丝①把废油壶上节②固定到台板⑤孔内，将废油壶④从台板①下方旋进废油壶上节②中，并将机头回油管③装在废油壶中。



机头放倒后，回油管③不能从废油壶中脱落。

4. 机头的放倒

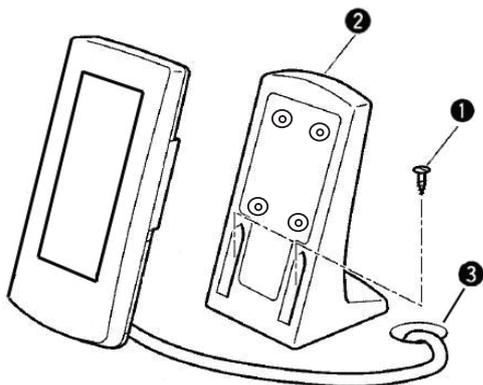


将机头②轻轻放倒，靠在机头支撑杆①上。



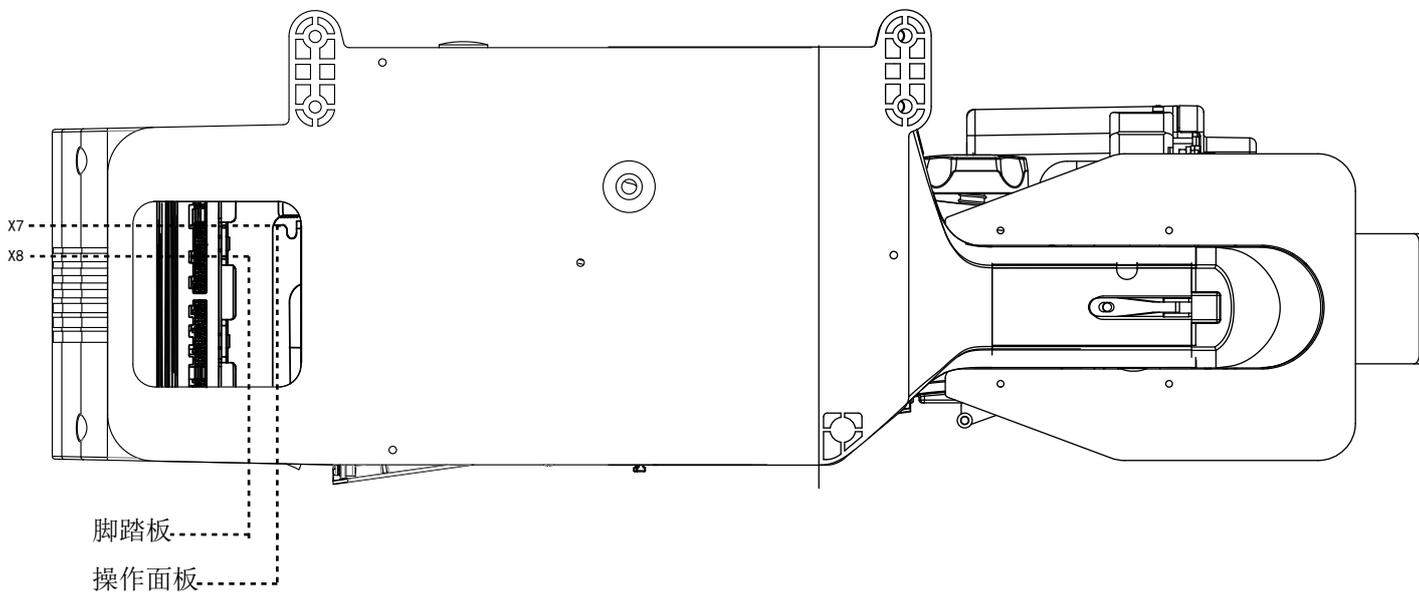
1. 放倒机头前，请先确认台板上是否有机头支撑杆；
2. 抬起机头时，请不要扳机头后罩，以免后罩受损；
3. 为防止机头侧翻，请确保台板水平。

5. 安装操作面板



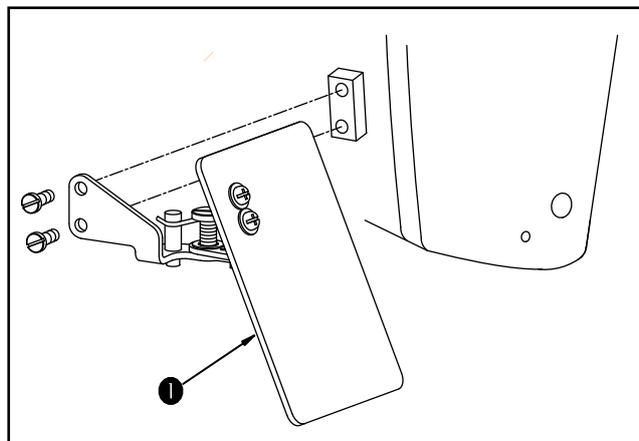
请用三个木螺丝①将操作面板②固定在台板③上操作者舒适的位置，然后将操作面板②导线穿过台板③相应孔，然后与另外端对接。

6. 电线的连接



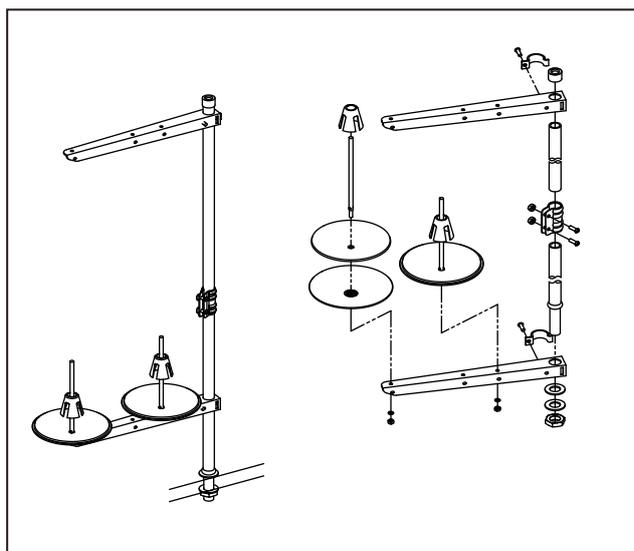
7. 眼睛防护罩的安装

	注意	为防止断针飞起弄伤眼睛，请一定安装起来。
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将附件箱中眼睛防护罩装在机头
如图所示左侧。

8. 线架的安装



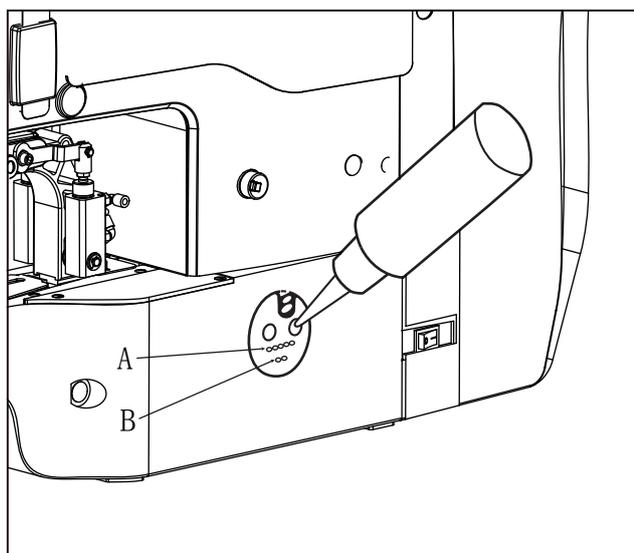
将附件箱中的线架如图装在台板孔上。

[4] 整机的准备

1. 加油



为了防止突然启动造成人身事故，请关掉电源后再进行。



请确认机油在下线 B 和上线 A 之间。如果机油过少时，请用附属的加油器进行加油。加油的油槽仅是向摆梭加油的。使用转速低时，如果摆梭的油量过多，可以把油量调小。（请参照 [5] 维修—8. 旋梭油量的调整。）

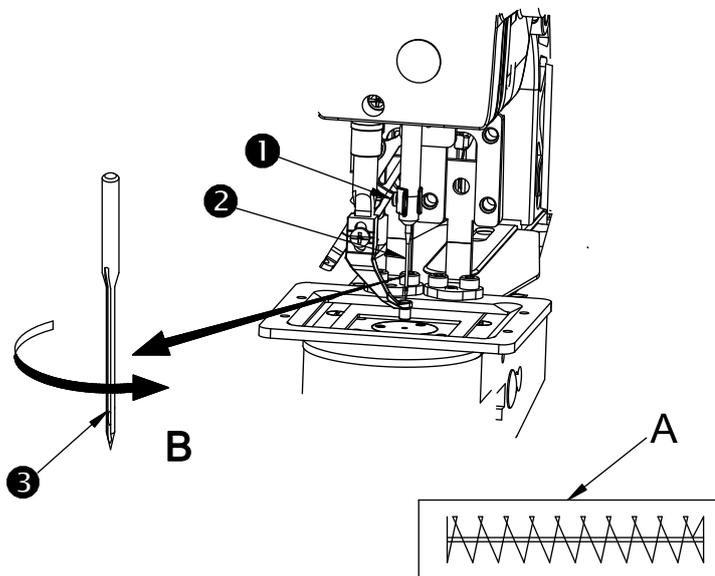


1. 请注意不要向油槽和下列注意 2 的旋梭以外的部位加油。否则会发生零件故障。
2. 初次使用缝纫机或较长时间没有使用缝纫机时，请向摆梭加少量的机油后在使用缝纫机。（请参照 [5] 维修—2. 机针和摆梭。）

2. 机针的安装



为了防止突然启动造成人身事故，请关掉电源后再进行。



安装机针时，请拧松固定螺钉①，把机针②的容线槽③朝向面前，插进针杆的深处，然后拧紧固定螺钉①。

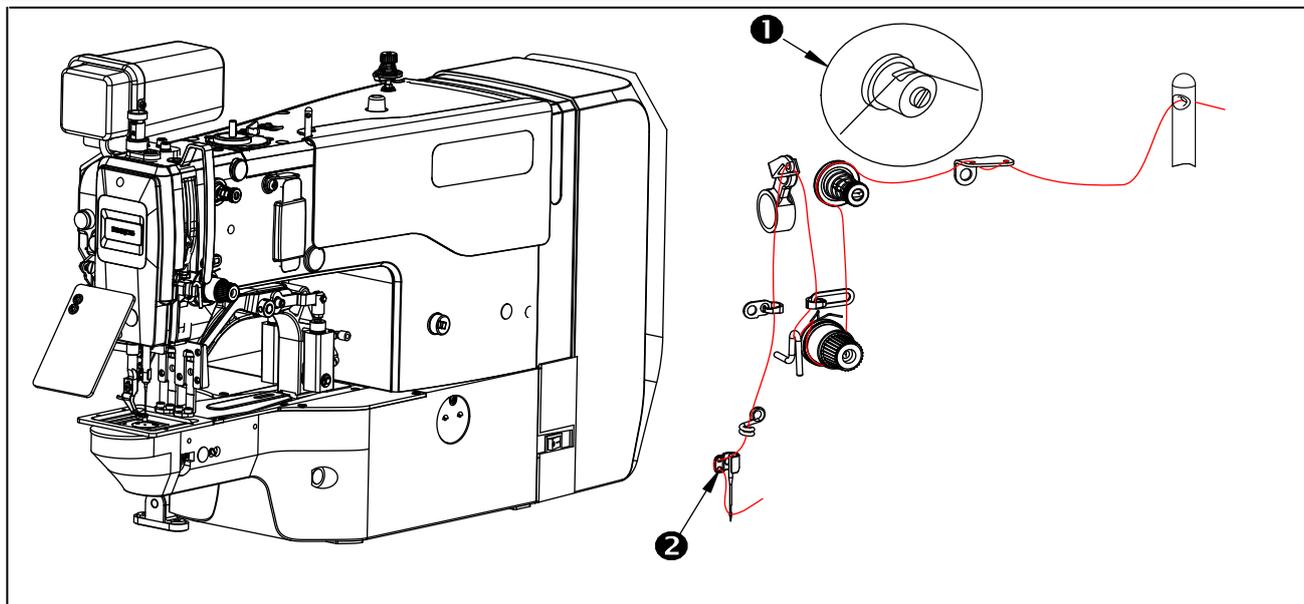


缝迹如 A 时，请把机针向 B 方向稍稍移动然后安装起来。

3. 上线穿线



为了防止突然启动造成人身事故，请关掉电源后再进行。



穿过机针的线应留出 4cm 左右。



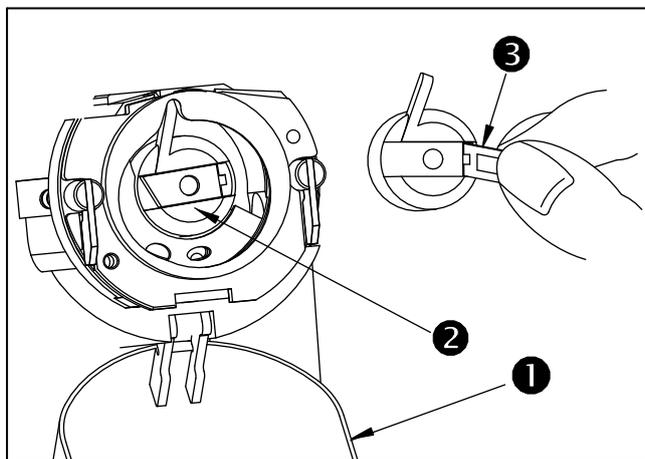
1. 使用硅油时，请把线穿过润滑导线器①。
2. 粗线时，请把机线只穿过针杆导线器②1 个孔。

4. 梭壳的取下插入



注意

为了防止突然启动造成人身事故，请关掉电源后再进行。



- (1). 打开梭床外罩①。
- (2). 拨起梭壳②的抓脚③，取出梭壳。
- (3). 插入时，请把梭壳深深插入摆梭轴，并关闭抓脚。



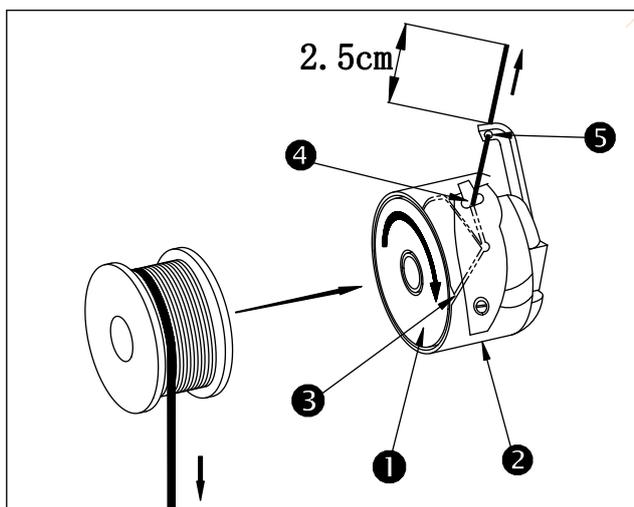
如果没有插到底，缝制途中梭壳②就有可能脱落。

5. 梭芯的插入方法



注意

为了防止突然启动造成人身事故，请关掉电源后再进行。

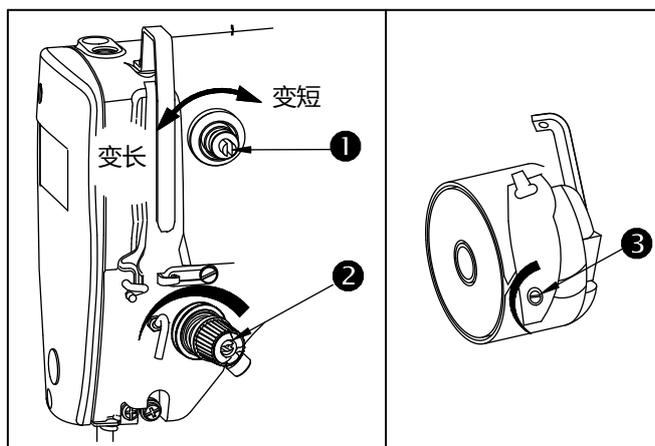


- (1). 把梭芯①按图示的方向插入梭壳②。
- (2). 把线穿过梭壳②的穿线口③，然后拉线，把线从线张力弹簧下面的穿线口④拉出来。
- (3). 把线从梭壳②的线孔⑤穿出，从线孔约拉出2.5cm。



底线的旋转方向请按照左图所示；如果相反的话底线的拉出就不稳定。

6. 线张力的调整

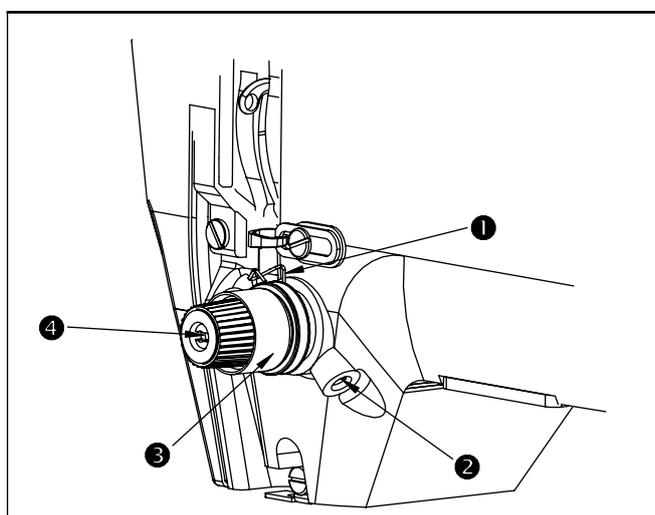


把第一线张力就旋钮①向右转动，切线后针尖上的残线长度变短，向左转动后变长。

请尽量在不脱线的情况下弄短残线。

用②调整面线张力，用③调整底线张力。

7. 挑线弹簧的调节



挑线弹簧①的标准移动量为 8~10mm 开始挑线时的强度为 0.1~0.3N。

(1). 移动量的调节

拧松固定螺钉②，转动夹线器挡圈③。

(2). 强度的调节

改变挑线弹簧的强度时，请在螺丝②拧紧的状态下，把细螺丝刀插到夹线器螺钉④的缺口部转动调节。向右转动之后，挑线弹簧的强度变强，向左转动之后，强度变弱。

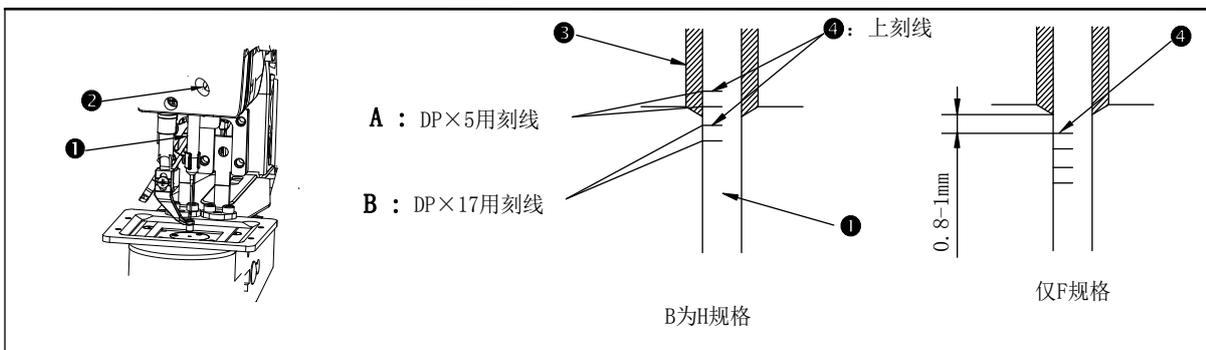
[5] 维修

1. 针杆高度



注意

为了防止突然启动造成人身事故，请关掉电源后再进行。



把针杆①设到最下点，拧松针杆紧固螺丝②，把针杆上刻线④和针杆下套③的下端调节成一致。



注意

请调节后一定确认不要有松动。有的缝制条件发生跳针时，请从针杆上刻线④往下调节 0.5mm-1mm。

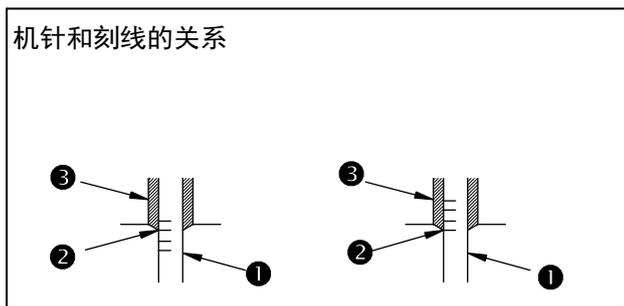
2. 机针与摆梭



注意

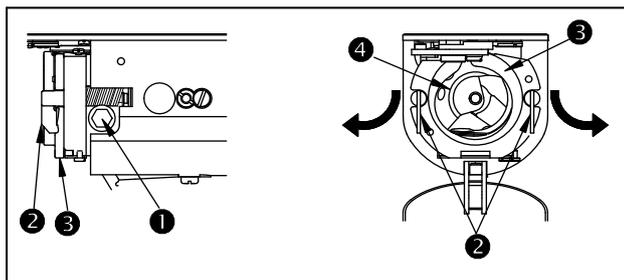
为了防止突然启动造成人身事故，请关掉电源后再进行。

机针和刻线的关系

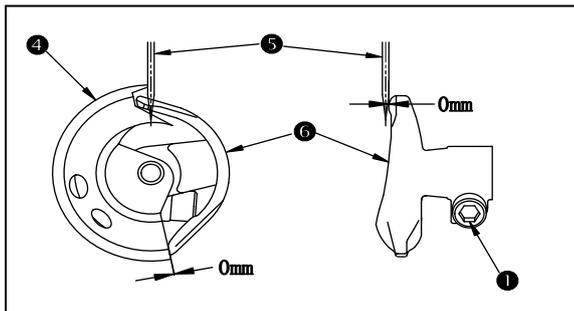


(1)用手转动手轮，针杆①上升时，把下刻线②对准针杆下套前端一致。

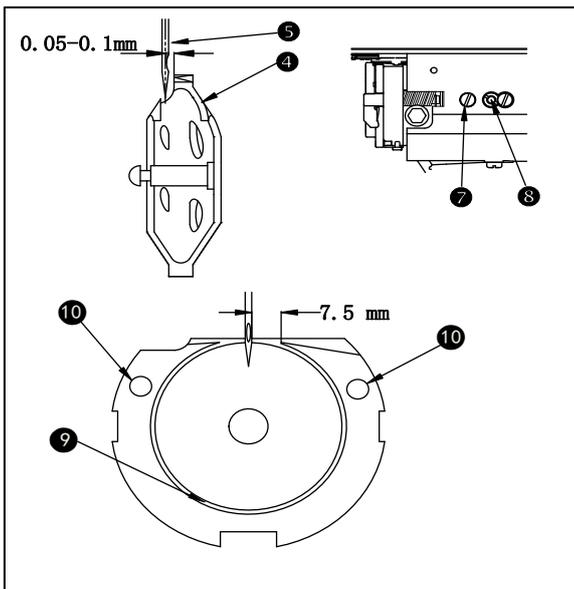
(2). 拧松驱动器固定螺丝①，左右打开梭床盖压片②，卸下梭床盖③。



此时请注意不要脱落摆梭④。



(3) 为了让摆梭④的梭尖与机针⑤的中心一致，同时防止驱动器⑥在前段面与机针相碰，弄弯机针，请把驱动器前端面与机针的间隙调整为 0mm，然后把驱动器固定螺丝①拧紧。



(4). 拧松梭床固定螺丝⑦，左右转动梭床调节轴⑧，调节梭床的前后位置，把机针⑤和摆梭④的梭尖的间隙调整为 0.05~0.1mm。
 (5). 调节完梭床的前位置后，机针和梭床的间隙应为 7.5mm，然后拧紧梭床固定螺丝⑦。

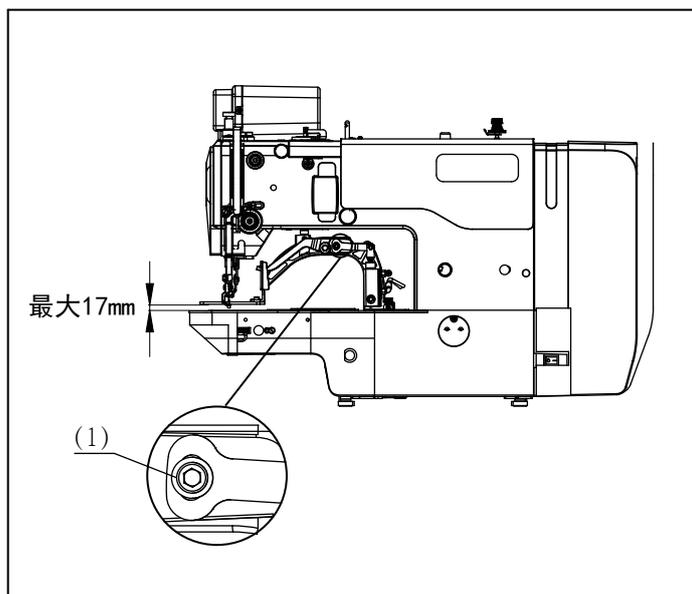


较长时间没有使用缝纫机或清扫过摆梭周围之后时，请往导轨部⑨和油芯⑩加少量的机油后再使用。

3. 压脚的高度



为了防止突然启动造成人身事故，请关掉电源后再进行。

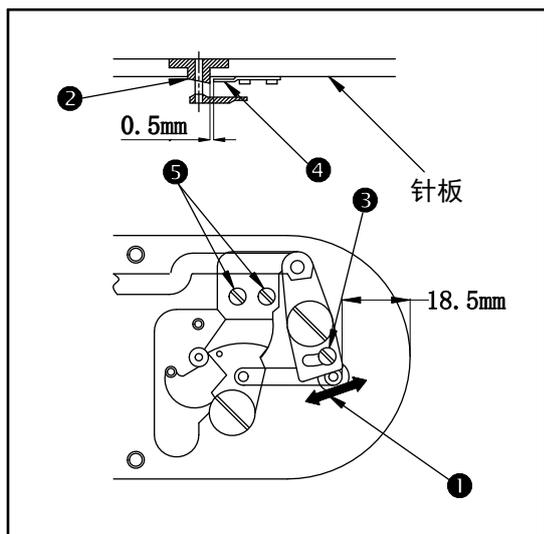


当气缸压缩时，拧松螺钉 (1)，调整压脚高度最大不超过17mm，调整完后拧紧螺钉 (1)。

4. 动刀和定刀

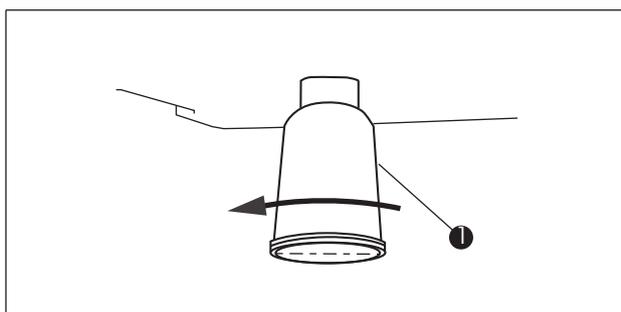


为了防止突然启动造成人身事故，请关掉电源后再进行。



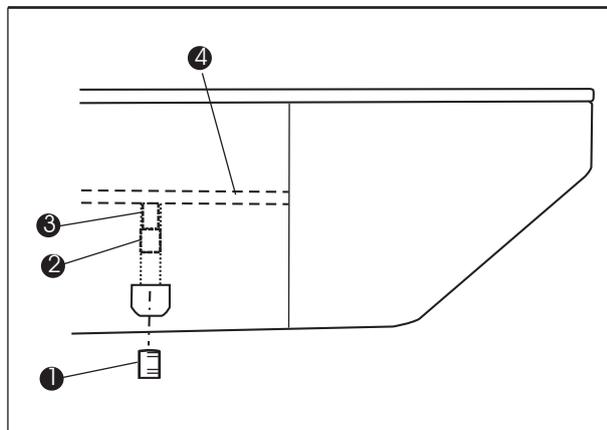
- (1). 拧松调节螺丝③，向箭头方向移动动刀，把从针板前段刀切线小拨杆①前段的距离调整为 18.5mm。
- (2). 拧松固定螺丝⑤，移动固定刀，把针孔导线器②和固定刀④之间的间隙调整为 0.5mm。

5. 废油的处理



积油杯①里积满了油之后，请卸下积油杯①排放出废油。

6. 旋梭油量调整



- (1). 拧松固定螺丝①，卸下固定螺丝①。
- (2). 拧紧调整螺丝②之后，加油管左④的油量杯弄小。
- (3). 调整后，拧紧固定螺丝①固定好。



1. 在标准出货状态，轻轻拧紧②回转 4 圈的位置。
2. 弄小油量时，不要一次拧紧，拧紧②回转 2 圈，待半日左右观看一下。拧得过紧的话会磨损旋梭。

7. 向指定部位补充润滑油

使用缝纫机进行了一定的缝制次数之后，打开电源时操作盘上会显示出异常代码 No. E221。这是通知需要向指定部位补充润滑油，此时请一定补充下列润滑油，叫出存储器开关 No. 245，用复位键复位到[0]。显示出异常 No. E221 显示后，按复位键可以解除异常，但再次打开电源后会再次显示出 No. E221。

而且，异常 No. E220 显示，继续缝制一定期间后会显示出异常 No. E221，按复位键不能解除异常，同时缝纫机变成不能动作。

因此，显示出异常 No. E221 以后，请一定向下列部位补充润滑油，然后启动存储器开关 No. 245，用复位键复位到[0]。

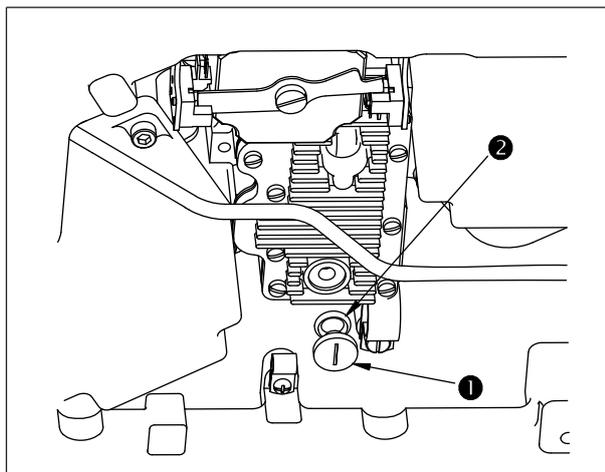


补充润滑油之后，如果不把存储器开关 No. 245 变更为[0]，异常 No. E220 或 No. E221 会被再次显示。



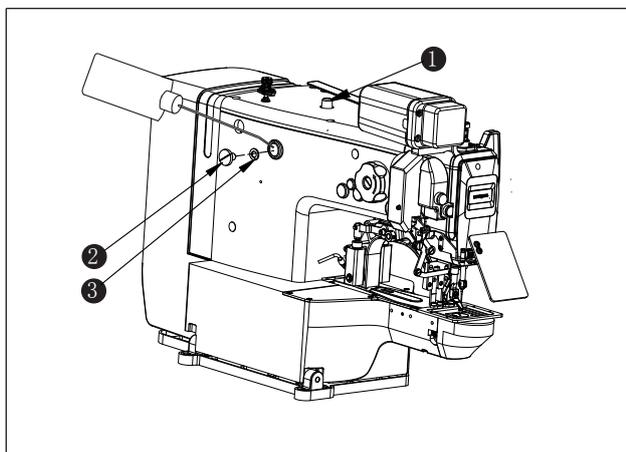
为了防止突然启动造成人身事故，请关掉电源后再进行。

(1). 将齿轮箱的废油放光



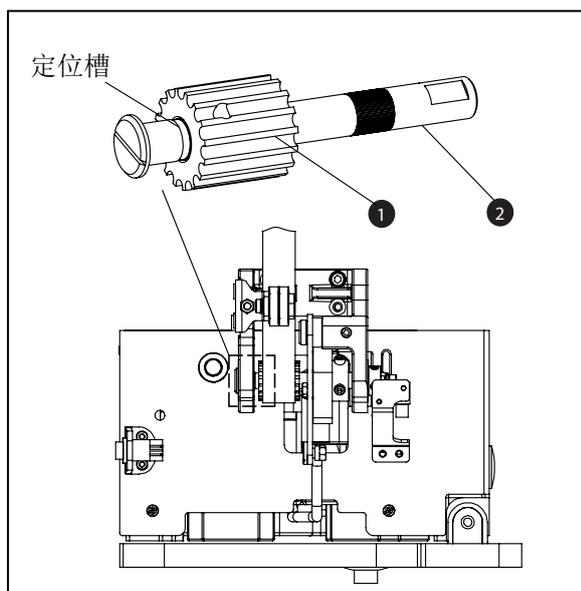
- A. 放倒缝纫机，卸下密封螺钉①和密封圈②。
- B. 放正缝纫机，把齿轮箱内的油放光。
- C. 放倒缝纫机，把密封圈②和密封螺钉①装回去，然后再放正缝纫机。

(2). 向齿轮箱中加入润滑油



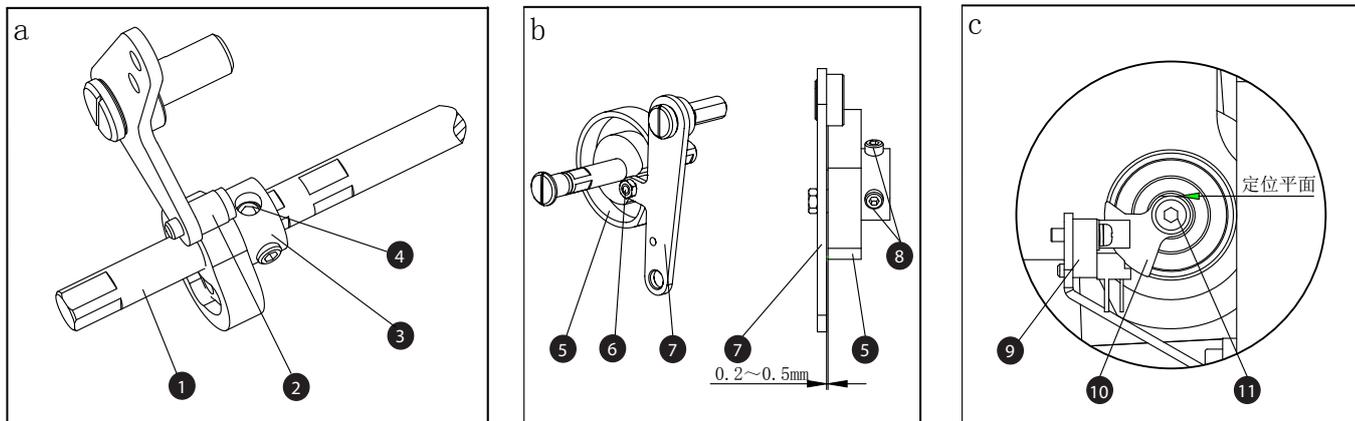
- A. 当通过油窗①观察到出油不明显或无出油时，应即时往齿轮箱内加油；
- B. 在停机状态下，取下螺钉②与橡胶垫圈③，加10#白油，无出油时，加100ml，出油不明显时，加50-70ml。装回②与③，启动机器观察出油是否明显。

8. 剪线驱动带轮位置的调整



按如图所示，将剪线驱动带轮①装配后，使带轮左端面与剪线驱动轴②上定位槽右端面对齐，拧紧带轮①上的两颗紧定螺钉。

9. 剪线凸轮和剪线安全传感片的调整

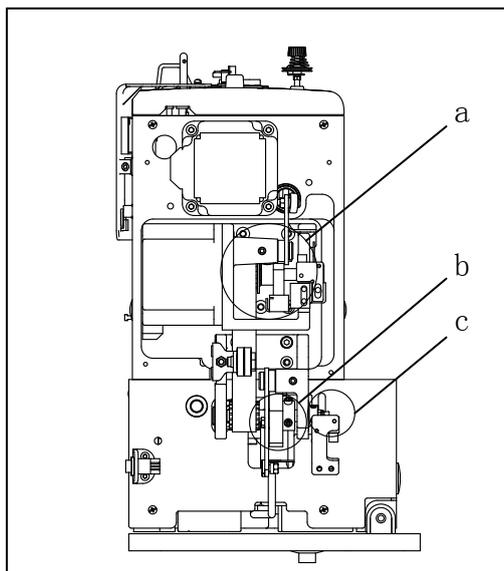


<1>剪线凸轮的调整

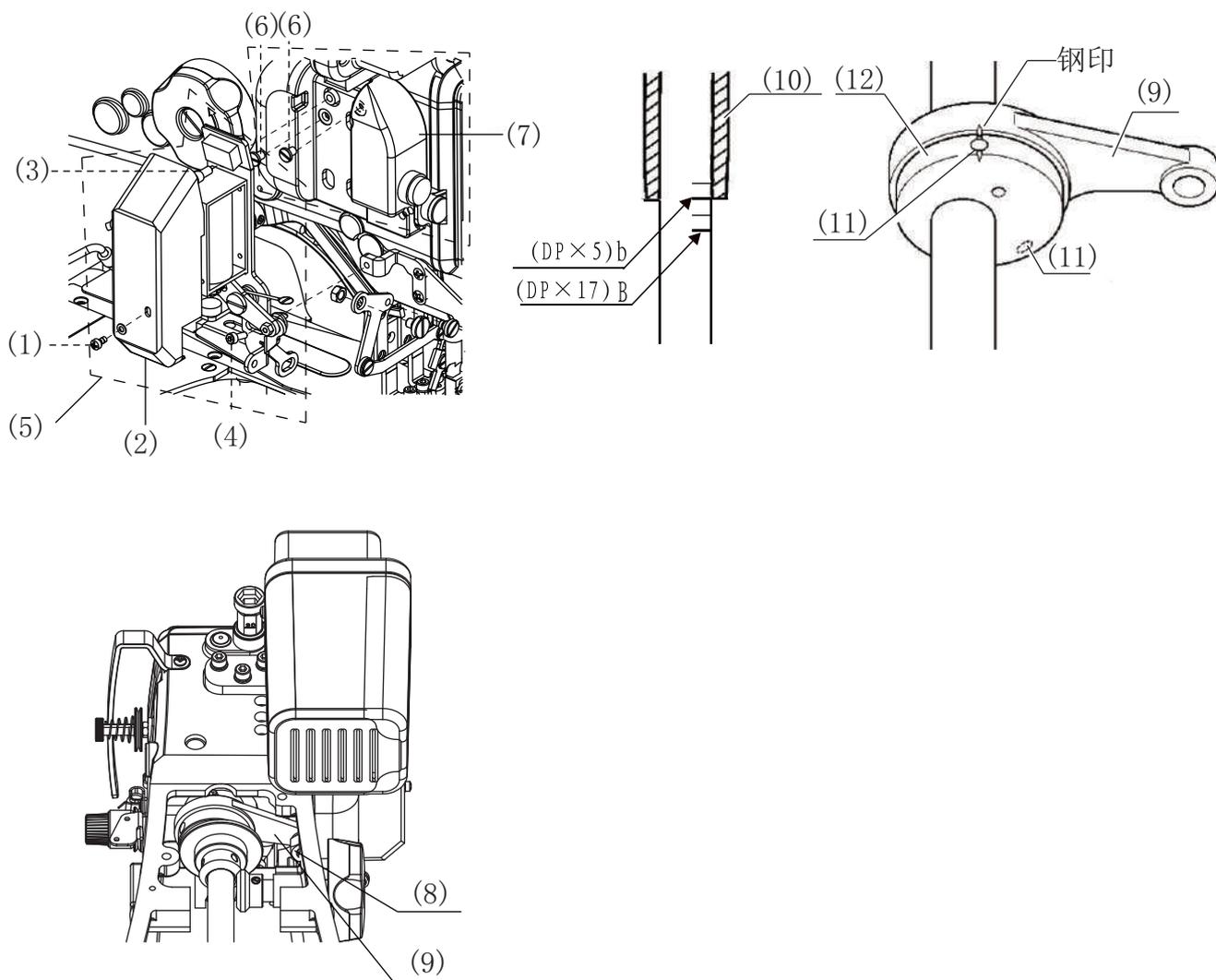
- (1) 转动抬压电机轴①，将抬压凸轮③转至与抬压滚柱②最低点接触时，即螺钉紧定螺钉④朝向正上方位置，如图所示。
- (2) 此时，调整剪线滚柱⑥在剪线凸轮⑤的凹槽最底部位。
- (3) 调整剪线曲柄⑦与剪线凸轮⑤端面距离0.2~0.5左右，如图所示锁紧剪线凸轮的两个螺钉⑧。

<2>剪线安全传感片的调整

- (4) 转动抬压电机轴①，将抬压凸轮③转至与抬压滚柱②最低点接触时，即螺钉紧定螺钉④朝向正上方位置，如图所示。
- (5) 此时，将剪线安全传感片⑩的定位平面水平朝正上方位置，并将剪线安全传感片⑩置于剪线安全传感器⑨内，如图所示，锁紧螺钉组件⑪，固定剪线安全传感片。
- (6) 当脚踏第一踏时，压脚下压，确保剪线安全传感器片⑩未进入剪线安全传感器⑨内，再第二踏开始缝制，此时缝制正常，若有报错剪线异常，请松开螺钉组件⑪顺时针方向调整剪线传感器片⑩的位置。



10. 中压脚连杆的位置调整



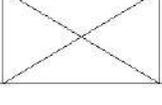
<1>中压脚行程调整

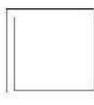
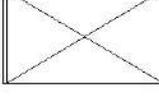
1. 旋出螺钉 (1) 把拨线罩 (2) 拆出, 再旋出螺钉 (3) 与螺钉 (4) 把拨线电磁铁组件 (5) 移开, 接着旋出2颗螺钉 (6) 把左罩壳组件 (7) 拆出。
2. 旋松螺母 (8), 调整连杆 (9) 的位置
 - ①、将连杆 (9) 往上移动, 中压脚行程变大, 最大行程为4.5mm。
 - ②、将连杆 (9) 往下移动, 中压脚行程变小, 最小行程为2mm。

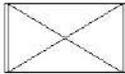
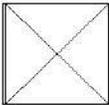
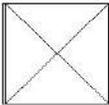
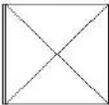
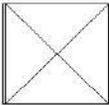
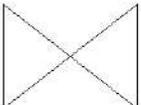
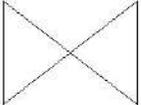
<2>针杆与中压脚同步调整

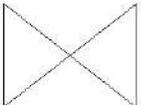
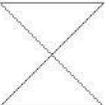
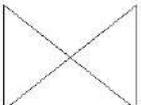
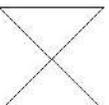
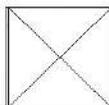
3. 旋转手轮使针杆从最低点往上升, 使针杆从上往下数第二条基线b与针杆轴套 (10) 一致。(如果是使用DP×17的机针时, 请与最下面的基线B对齐一致。)
4. 旋松2颗螺钉 (11), 使凸轮 (12) 与连杆 (9) 的钢印一致后, 拧紧螺钉 (11)。

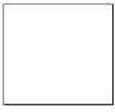
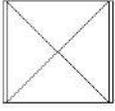
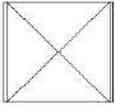
[6] 花样一览表

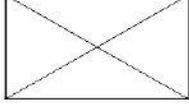
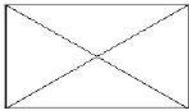
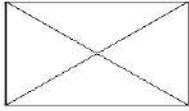
No.	落针图	针数	缝纫尺寸 mm		针距 mm
			纵	横	
1		62	50	60	4
2		80	50	60	3
3		94	50	60	2.5
4		128	50	60	4
5		168	50	60	3
6		198	50	60	2.5
7		48	25	25	3
8		48	25	25	3
9		38	20	20	3

No.	落针图	针数	缝纫尺寸 mm		针距 mm
			纵	横	
10		38	20	20	3
11		33	18	18	3
12		33	18	18	3
13		30	13	18	3
14		30	13	18	3
15		45	25	35	3.5
16		108	30	40	3
17		96	30	40	3.5
18		84	30	40	4

No.	落针图	针数	縫纫尺寸 mm		针距 mm
			纵	横	
19		66	25	35	4.5
20		62	25	30	4.5
21		58	20	30	4.5
22		68	28	28	4
23		66	20	28	3.5
24		66	20	25	3.5
25		52	20	20	4
26		42	30	40	4.5
27		38	25	35	4.5

No.	落针图	针数	縫纫尺寸 mm		针距 mm
			纵	横	
28		36	25	30	4.5
29		46	28	28	3.5
30		37	20	25	3.5
31		42	20	25	3.5
32		52	15	15	3
33		60	16	25	3.5
34		65	30	35	5
35		30	15	15	2.5
36		34	18	24	3

No.	落针图	针数	縫纫尺寸 mm		针距 mm
			纵	横	
37		36	20	24	3
38		36	16	25	3
39		42	25	25	3
40		42	25	35	3.5
41		48	20	40	3
42		54	30	40	3
43		46	30	30	3
44		107	20	38	2.5
45		91	20	28	2.5
46		78	20	19	2.5

No.	落针图	针数	縫纫尺寸 mm		针距 mm
			纵	横	
47		52	11	9	2
48		120	25	25	2
49		71	30	40	3
50		83	30	40	2.5
51		62	50	60	4
52		80	50	60	3
53		95	50	60	2.5
54		128	50	60	4
55		168	50	60	3
56		198	50	60	2.5

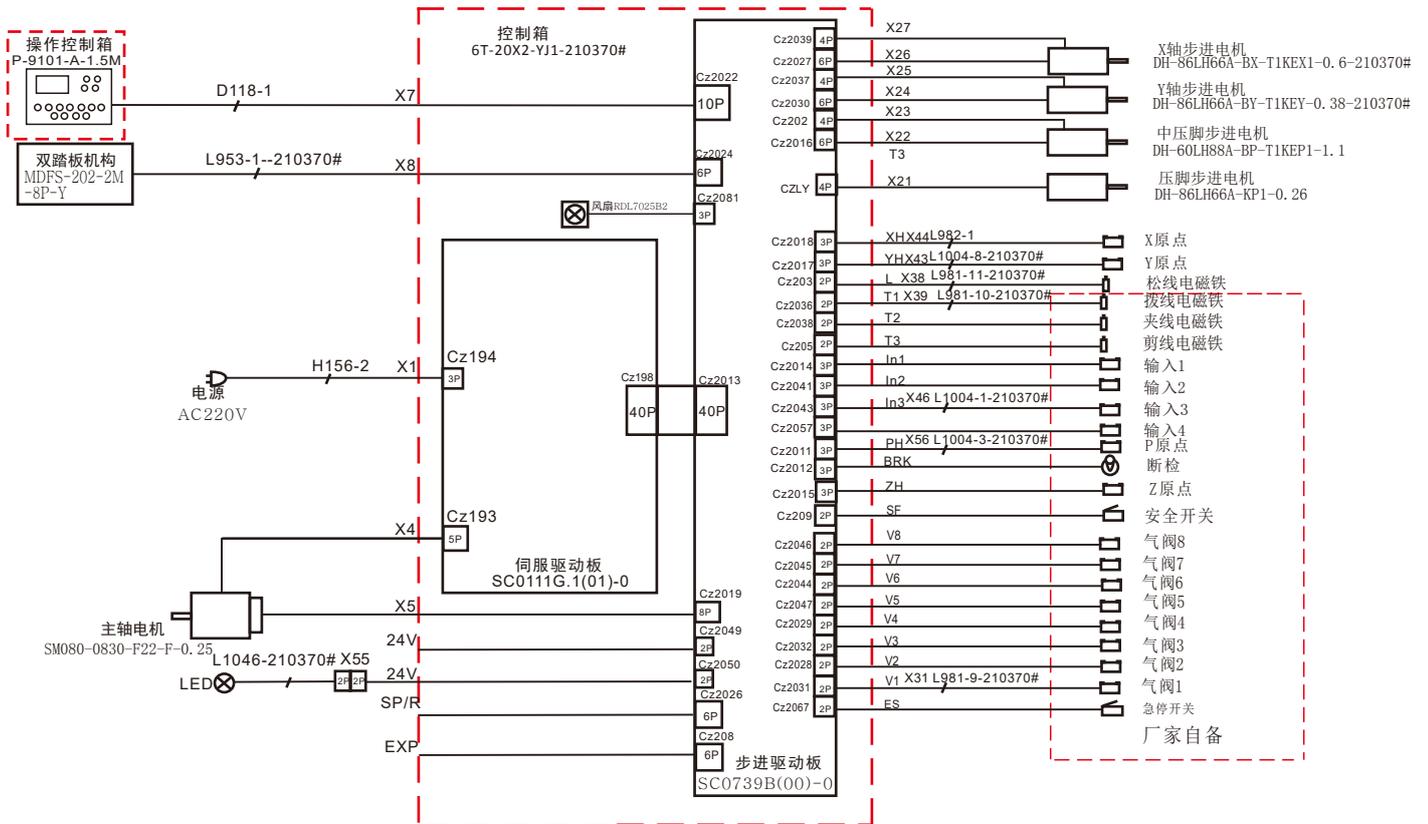
II. 缝纫时故障、原因及对策

象	现 因 原	策 对
1. 始缝时脱线	①始缝时跳针。 ②切线后上线长度短。 ③底线过短。 ④第一针的上线张力高。 ⑤抓线不稳定(布料容易伸长、线不滑、线粗等) ⑥第一针的间距小。	○机针和旋梭的间隙调整为 0.05~0.1mm ○设定始缝时软起动。 ○调节第 2 线张力器的浮线量。 ○把挑线弹簧弄强或把第一线张力盘的张力减弱。 ○减弱底线张力。 ○弄大针孔导向器和固定刀的间隙。 ○降低第一针的张力。 ○降低缝制开始第一针的转速。 ○增长第一针的间距。 ○下降第一针的上线张力。
2. 老断线。化纤纤维拉断	①旋梭、驱动器上有伤。 ②针孔导向器上有伤。 ③机针碰布压脚。 ④线头进入大旋梭的沟里。 ⑤上线张力过强。 ⑥挑线弹簧过强。 ⑦化纤纤维摩热而断。	○卸下用细磨时或挫刀磨平。 ○用锉刀磨, 或换新。 ○调节布压脚的位置。 ○卸下中旋梭, 清除线头。 ○减弱上线张力。 ○减弱挑线弹簧。 ○使用硅油。
3. 常断针	①针弯了。 ②针碰布压脚。 ③针过粗。 ④驱动器把针弄得过弯。 ⑤在缝制开始时压脚压住缝纫机线(机针弯曲)。	○更换机针。 ○调节布压脚。 ○根据缝制物选用适当的机针。 ○调整针和旋梭位置。 ○弄宽机针和挑线杠的距离。(23~25mm)
4. 切线不断(仅限底线)	①固定刀不快。 ②针孔导线器和固定刀高低差小。 ③动刀位置不好。 ④最终针跳线。 ⑤底线张力低。	○更换固定刀。 ○把固定刀再弄弯一些。 ○调整动刀位置。 ○调整针和旋梭的同步。 ○提高底线张力。
5. 常跳线	①针和旋梭调整不好。 ②针和中旋梭得间隙过大。 ③针弯了。 ④驱动器把针弄得过弯。	○调整针和摆梭的位置。 ○调整针和摆梭的位置。 ○更换机针。 ○调整驱动器的位置。
6. 上线从布的里侧露出来	①上线紧线不好。 ②线张力盘浮起机构不动作 ③切线后的上线过长。 ④针数少。 ⑤缝制长度短时(缝制背面上线头露出。) ⑥针数少。	○加强上线张力。 ○确认缝制中第 2 线张力盘是否浮起。 ○加强第 1 线张力。 ○使用暗缝式下板。

7. 切线时 短线	①动刀位置不好。	○调节动刀位置 ○调节剪线凸轮位置
8. 机线长度不一致	①挑线弹簧的张力低。	○提高挑线弹簧的张力。
9. 机线长度不能弄短	①第 1 线张力器的张力低。 ②挑线弹簧张力过强。 ③因为挑线弹簧的张力过低，所以动作不稳定。	○增强第 1 线张力器的张力。 ○降低挑线弹簧的张力。 ○增强挑线弹簧的张力，行程也变长。
10. 缝制开始第 2 针的底线结线部露出表面	①梭芯的空槽大。 ②底线张力低。 ③第 1 针的上线张力过强。	○调整活动刀的位置。 ○增强底线张力。 ○下降第 1 针的上线张力。

III. 电控系统框图

1. 电控系统框图(-04)



IMPORTANT SAFETY INSTRUCTIONS

Putting sewing systems into operation is prohibited until it has been ascertained that the sewing systems in which these sewing machines will be built into, have conformed with the safety regulations in your country. Technical service for those sewing systems is also prohibited.

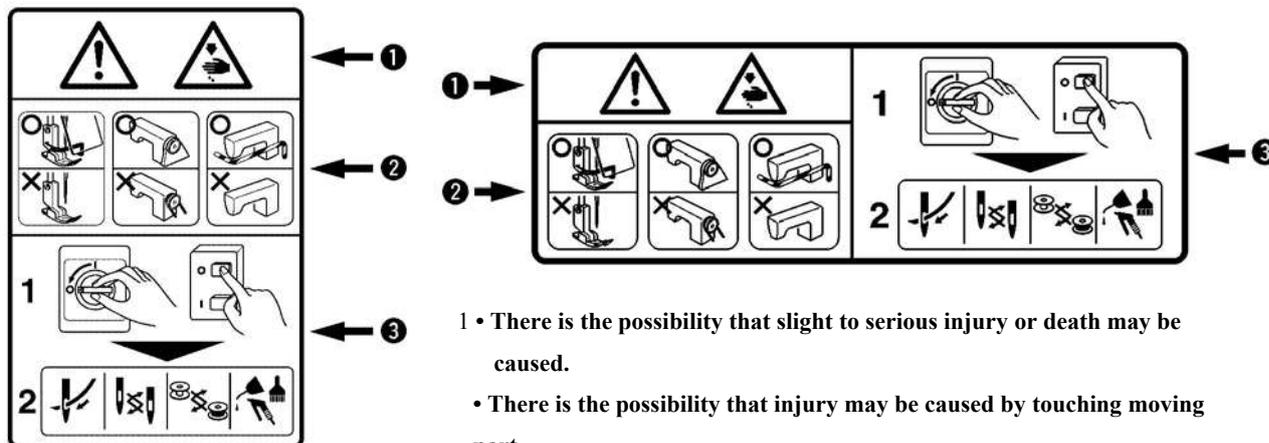
1. Observe the basic safety measures, including, but not limited to the following ones, whenever you use the machine.
2. Read all the instructions, including, but not limited to this Instruction Manual before you use the machine. In addition, keep this Instruction Manual so that you may read it at anytime when necessary.
3. Use the machine after it has been ascertained that it conforms with safety rules/standards valid in your country.
4. All safety devices must be in position when the machine is ready for work or in operation. The operation without the specified safety devices is not allowed.
5. This machine shall be operated by appropriately-trained operators.
6. For your personal protection, we recommend that you wear safety glasses.
7. For the following, turn off the power switch or disconnect the power plug of the machine from the receptacle.
 - 7-1 For threading needle(s), loopier, spreader etc. and replacing bobbin.
 - 7-2 For replacing part(s) of needle, presser foot, throat plate, loopier, spreader, feed dog, needle guard, folder, cloth guide etc.
 - 7-3 For repair work.
 - 7-4 When leaving the working place or when the working place is unattended.
 - 7-5 When using clutch motors without applying brake, it has to be waited until the motor stopped totally.
8. If you should allow oil, grease, etc. used with the machine and devices to come in contact with your eyes or skin or swallow any of such liquid by mistake, immediately wash the contacted areas and consult a medical doctor.
9. Tampering with the live parts and devices, regardless of whether the machine is powered, is prohibited.
10. Repair, remodeling and adjustment works must only be done by appropriately trained technicians or specially skilled personnel. Only spare parts designated by JUKI can be used for repairs.
11. General maintenance and inspection works have to be done by appropriately trained personnel.
12. Repair and maintenance works of electrical components shall be conducted by qualified electric technicians or under the audit and guidance of especially skilled personnel. Whenever you find a failure of any of electrical components, immediately stop the machine.
13. Before making repair and maintenance works on the machine equipped with pneumatic parts such as an air cylinder, the air compressor has to be detached from the machine and the compressed air supply has to be cut off. Existing residual air pressure after disconnecting the air compressor from the machine has to be expelled. Exceptions to this are only adjustments and performance checks done by appropriately trained technicians or especially skilled personnel.
14. Periodically clean the machine throughout the period of use.
15. Grounding the machine is always necessary for the normal operation of the machine. The machine has to be operated in an environment that is free from strong noise sources such as high-frequency welder.
16. An appropriate power plug has to be attached to the machine by electric technicians. Power plug has to be connected to a grounded receptacle.
17. The machine is only allowed to be used for the purpose intended. Other used are not allowed.
18. Remodel or modify the machine in accordance with the safety rules/standards while taking all the effective safety measures. Our company no responsibility for damage caused by remodeling or modification of the machine.
19. Warning hints are marked with the two shown symbols.



Danger of injury to operator or service staff



Items requiring special attention



- 1 • There is the possibility that slight to serious injury or death may be caused.
 - There is the possibility that injury may be caused by touching moving part.
- 2 • To perform sewing work with safety guard.
 - To perform sewing work with safety cover.
 - To perform sewing work with safety protection device.
- 3 • Turn OFF the power and perform “threading”, “replacement of bobbin or needle”, “cleaning”, “adjustment” and “lubrication”.

FOR SAFE OPERATION



1. To avoid electrical shock hazards, neither open the cover of the shell nor touch the components mounted inside the back cover.
2. After changing the pattern, make sure the needle entry point. If the pattern is protruded from the work clamp feet, the needle will interfere with the work clamp feet during sewing, and it is dangerous due to the needle breakage or the like.
3. Do not turn OFF the power in a state that the needle is lowered. Wiper may break the needle.



1. When nothing is displayed in the operation panel even when the power switch is turned ON, turn OFF the power switch and check the voltage and the type of the power source.
2. So as to prevent possible accidents caused by abrupt start of the sewing machine, depress the start switch after ascertaining that there is no interfering thing under the needle when winding the bobbin thread.
3. When turning OFF the power switch, turning ON the ready switch or turning ON the work clamp foot switch, the work clamp feet automatically come down. So, never place your fingers under the work clamp feet to prevent possible accidents caused by abrupt start of the sewing machine. During operation, be careful not to allow your fingers to come close to the work clamp feet.
4. So as to prevent possible accidents caused by the touch of the fingers with the needle, install a finger guard suitable for each work clamp foot when replacing the work clamp foot.

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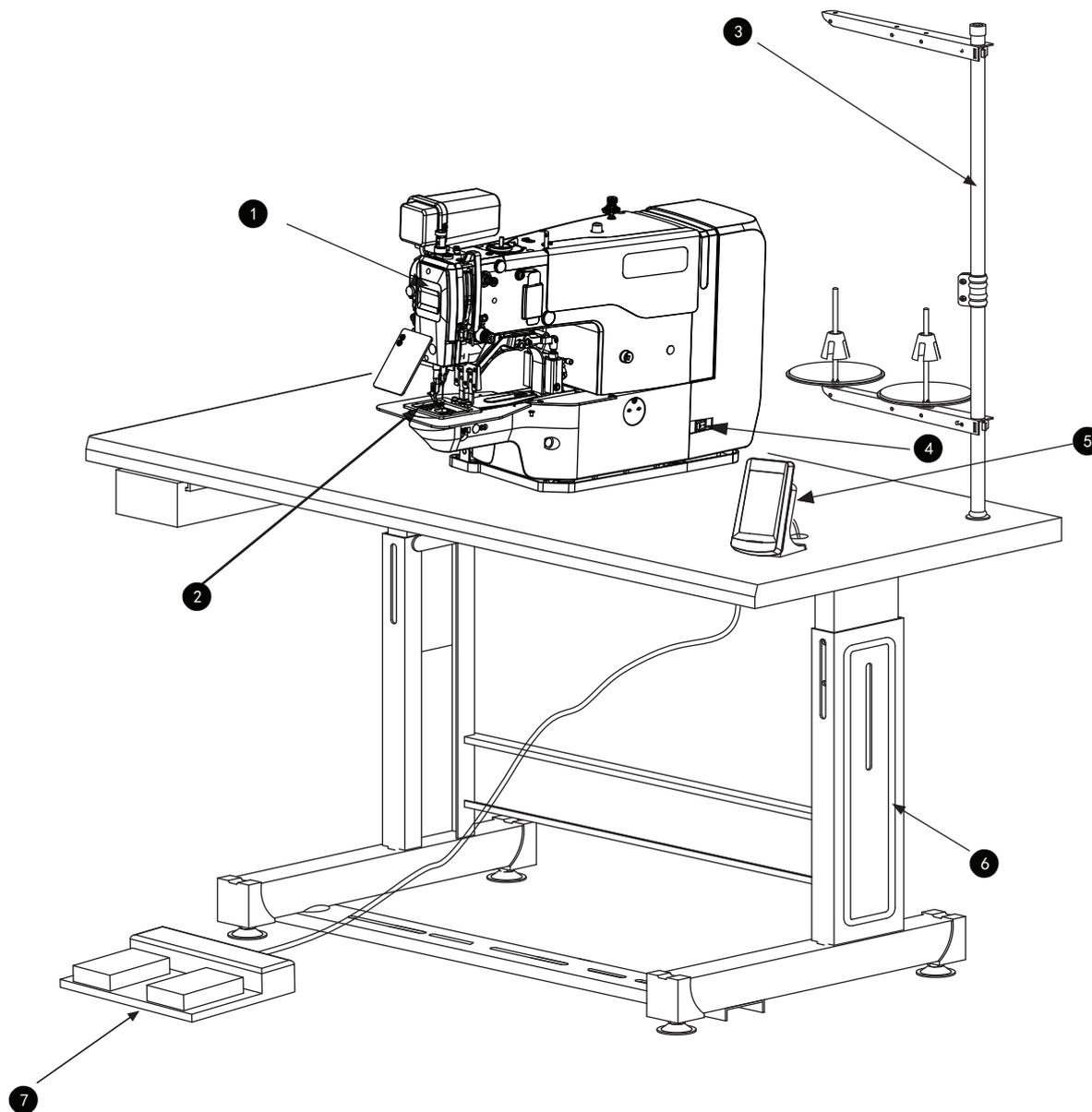
I . EXPLANATION OF 0605 BARTACKING SEWING MACHINE, COMPUTER-CONTROLLED HIGH-SPEED BAR TACKING MACHINE

[1] SPECIFICATIONS

- | | |
|------------------------------------|--------------------------------------------------------------------------------------------|
| 1. Sewing area: | X (lateral) direction 60mm
Y (longitudinal) direction 50mm |
| 2. Max. Sewing speed: | 2700rpm
(when sewing pitches are less than 5mm in X-direction and 3.5mm in Y-direction) |
| 3. Stitch length: | 0.1-10mm (adjustable in 0.1mm step) |
| 4. Feed motion of work clamp foot: | Intermittent feed (2-shaft drive by stepping motor) |
| 5. Needle bar stroke: | 41.2mm |
| 6. Needle: | DP×5、 DP×17 |
| 7. Lift of work clamp foot: | 13mm (standard) Max.17mm |
| 8. Shuttle: | standard semi-rotary hook (oil wick lubrication) |
| 9. lubricating: | oil 10# (supplied by oiler) |
| 10. Date recording: | EPROM |
| 11. Enlarging/Reducing facility: | 20% to 200% (1% step) in X-direction and Y-direction respectively |
| 12. Enlarging/Reducing: | Patten enlargement/reduction can be done by increasing/decreasing the stitch length |
| 13. Max. Sewing speed limitation: | 400 to 2700rpm (100rpm) |
| 14. Bobbin thread counter: | UP/DOWN type (1-99999) |
| 15. Sewing machine motor: | 550W Servo motor |
| 16. Dimensions: | W: 1200mm L: 540mm H: 1100mm |
| 17. Weight: | Machine 58Kg |
| 18. Power consumption: | 0.6KW |
| 19. Operating temperature range: | 0°C to 50°C |
| 20. Operating humidity range: | 35% to 85% (No dew condensation) |
| 21. Line voltage: | Rated voltage ±10% 50-60Hz |

[2] CONFIGURATION

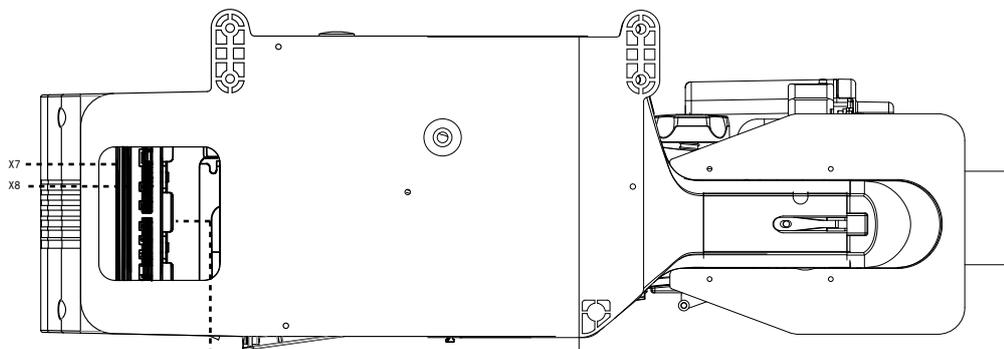
1. Names of main unit



- (1). Machine head
- (2). Work clamp feet
- (3). Thread stand
- (4). Power switch
- (5). Operation panel
- (6). Frame
- (7). Pedal switch

[3] INSTALLATION

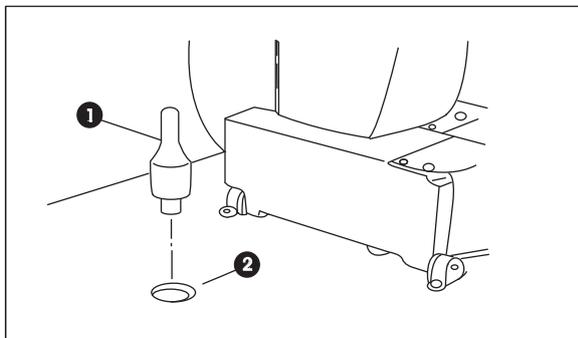
1. Connecting pedal switch



Pedal switch

Please let the pedal switch line connect with the electronic control box according to online identity, make sure the connection is correct.

2. Installing the head support rod

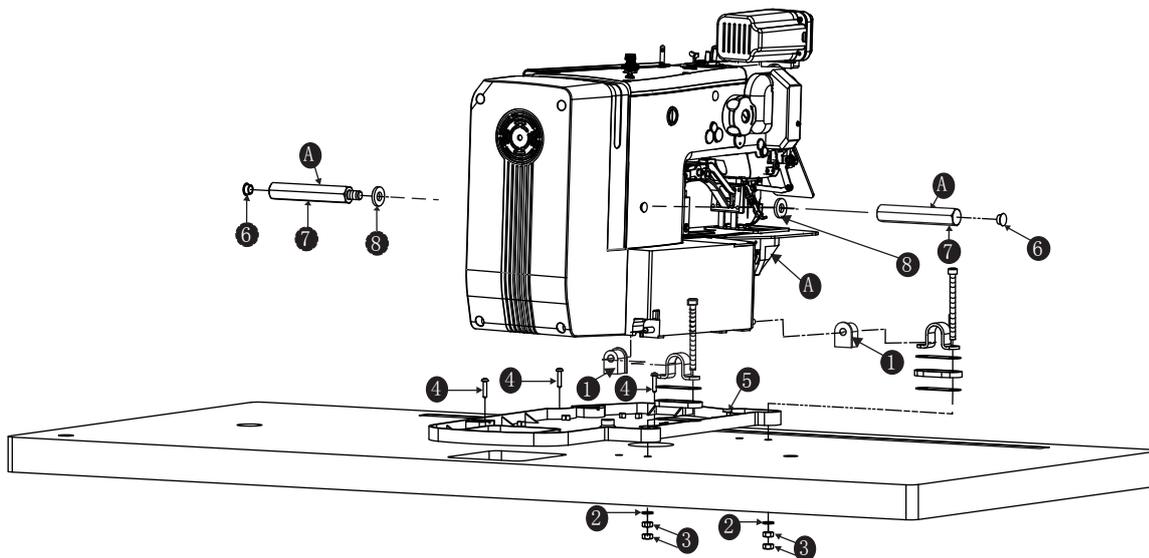


Drive head support rod① in hole② in the machine table.

3. Installation of the swing machine head



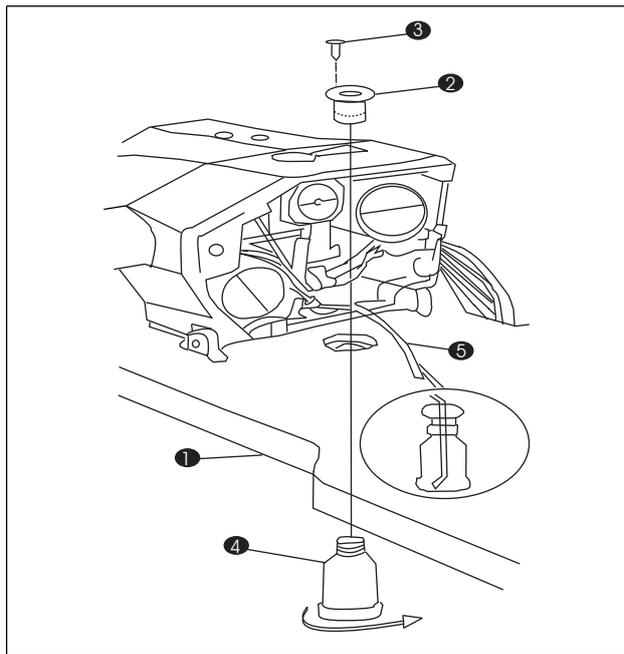
WARNING : To prevent possible accidents caused by the full of the sewing machine, perform the work by two persons or more when the machine is



- 1、 When handling sewing machine, please hold A Department
- 2、 After handling, please remove the handle⑦ and rubber pad⑧, fitted with rubber plug⑥

- (1). the oil plate ⑤ with wood screws ④ fixed in the corresponding position of the platen.
- (2). Fit hinge rubber ① to the hinge shaft, and fix the swing machine.
- (3). The flat pad ② , nut ③ , followed by a fixed, pay attention to the locking nut ③ force, if twisted too tightly, then the shock result is not satisfactory.

4. Installing the drain receiver

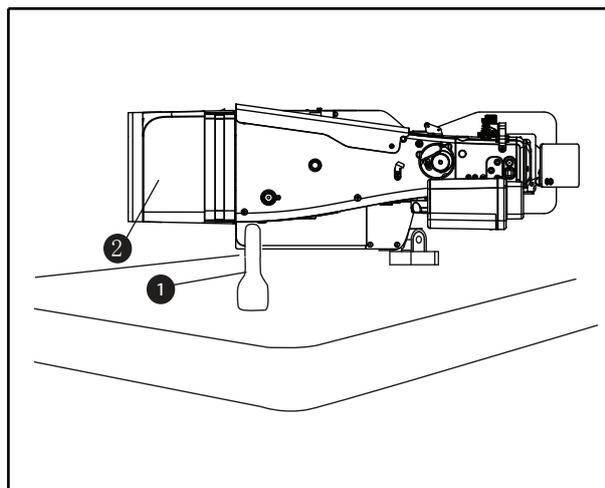


Fix drain receiver ② in the installing hole of table ① with four setscrews ③. Screw in drain bin ④ to drain receiver ②. Insert sewing machine drain pipe ⑤ into drain bin ④.



Insert drain pipe ⑤ until it will go on further so that it does not come off drain bin ④ when tilting the machine head

5. Tilting the sewing machine head

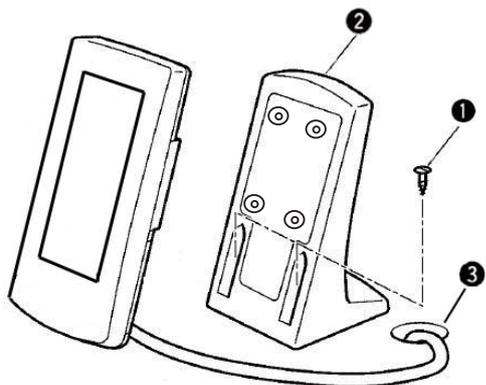


turn head ② gently down, and leaning the head on the head supporting bar at ①.



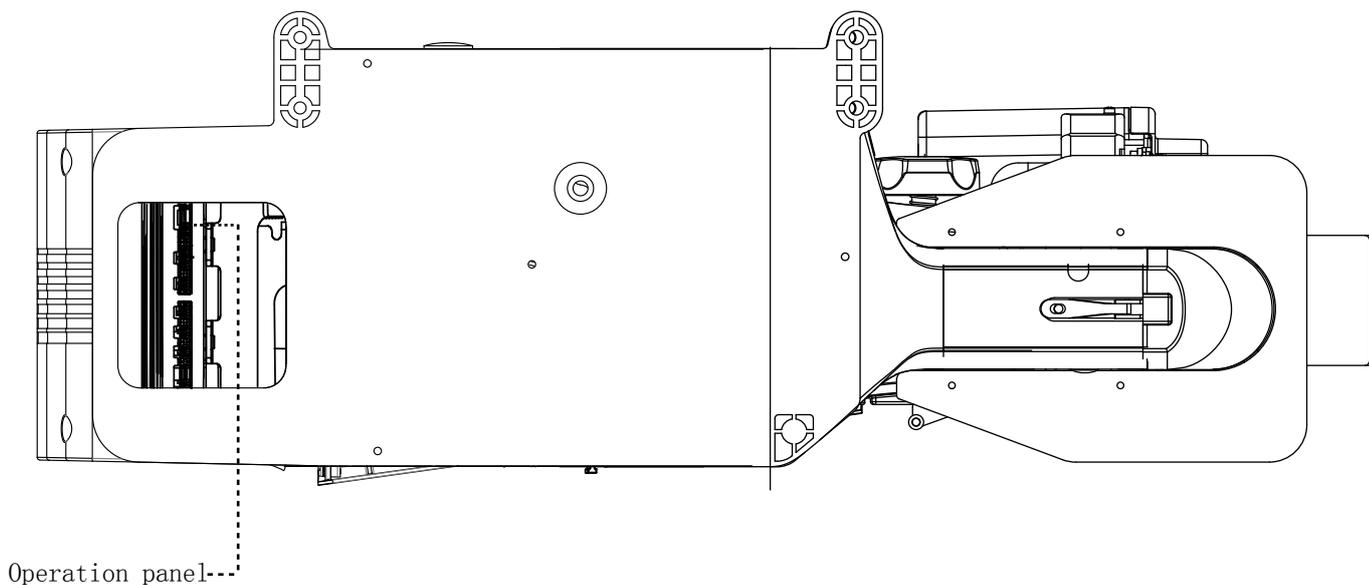
1. Before tilting the sewing machine head, make sure that head support rod ① is attached to the machine table;
2. When raising the sewing machine head, do not raise it while holding motor cover ②. It will be the cause of breakage of motor cover ②.
3. Be sure to tilt the sewing machine head on a flat place to prevent it from falling.

6. Installing the operation panel



Use four wood screws ① fix the operator panel ② on the table ③ in a comfortable operation position, then the operator panel ② corresponding wire hole through the table ③, and then dock with the other side.

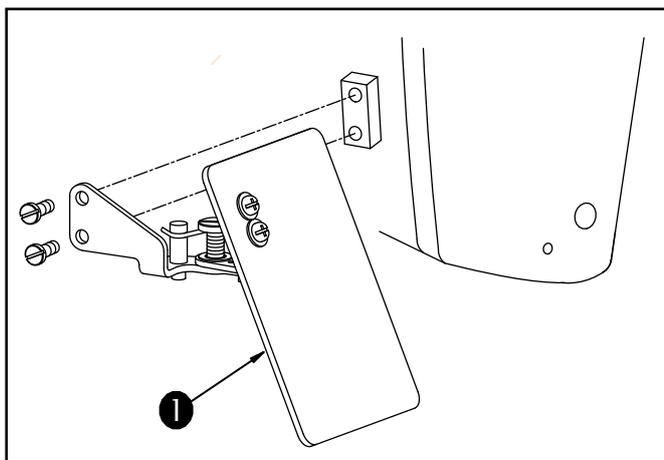
7. Connecting the operation panel



Please let the operation panel line connect with the electronic control box according to online identity, make sure the connection is correct.

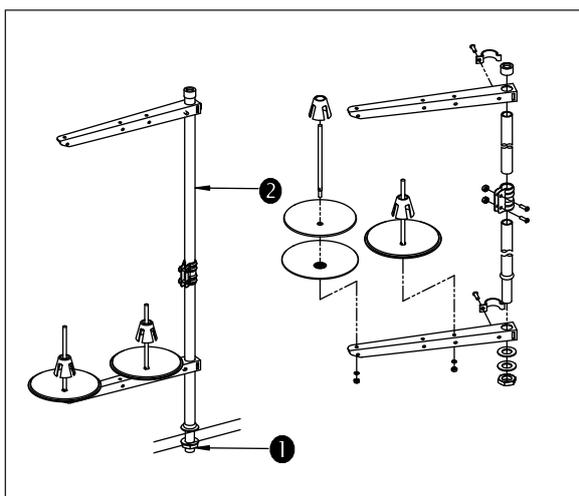
8. Installing the eye protection cover

 **WARNING :** Be sure to attach this cover to protect the eyes from the disperse of needle breakage.



The eye shield in the accessories box should be installed in the head on the left.

9. Installing the thread stand



The line frame in the accessory box should be installed in Table.

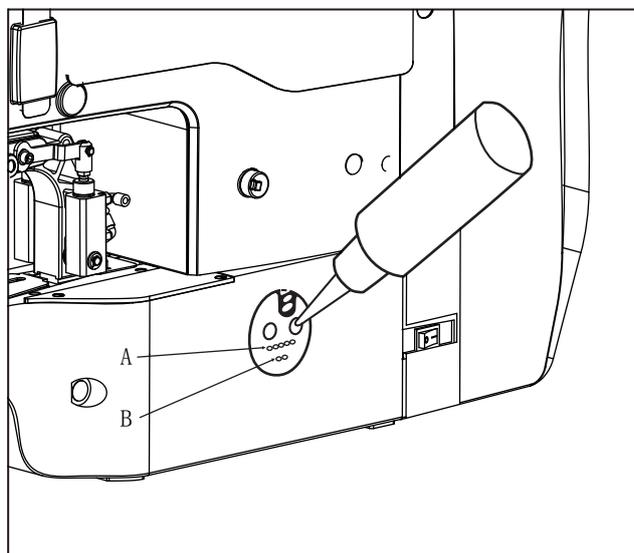
[4] OPERATION OF THE SEWING MACHINE

1. Lubrication



WARNING :

Turn of the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine



Check that the place between lower line Band upper line A is filled with oil . Fill there with oil using the oiler supplied with the machine as accessories when oil is short.
 *The oil tank which is filled with oil is only for lubricating to the hook portion. It is possible to reduce the oil amount when the number of rotation used is low and the oil amount in the hook portion is excessive.(Refer to 7.Amount of oil supplied to hen kook of [5] maintenance

1. DO not lubricate to the places other than the oil tank and the hook of Caution 2 below.

Trouble of components will be caused.

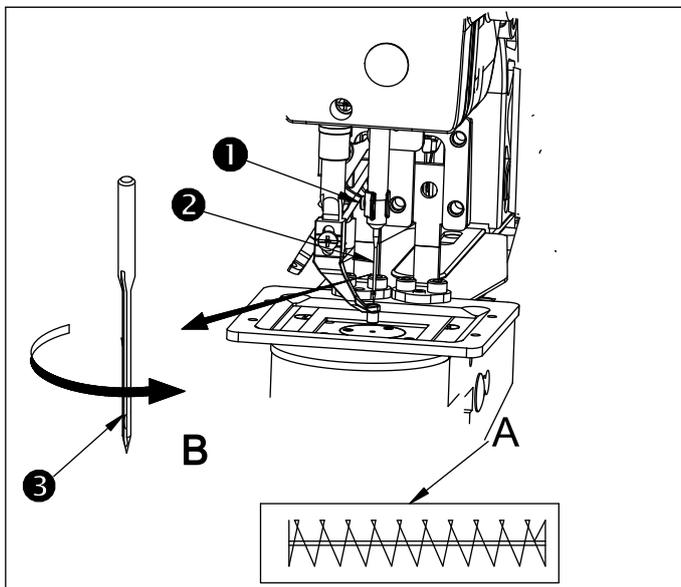


2. When using the sewing machine for the first time or after an extended period of disuse use the machine after lubricating a small amount of oil to the hook portion.(Refer to2.Adjusting the needle-to-shuttle relation of [5]MAINTENANCE

2. Attaching the needle



WARNING : Turn of the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine



Loosen setscrew① and hold needle② with the long groove facing toward you. Then fully insert it into the hole in the needle bar, and tighten setscrew①.

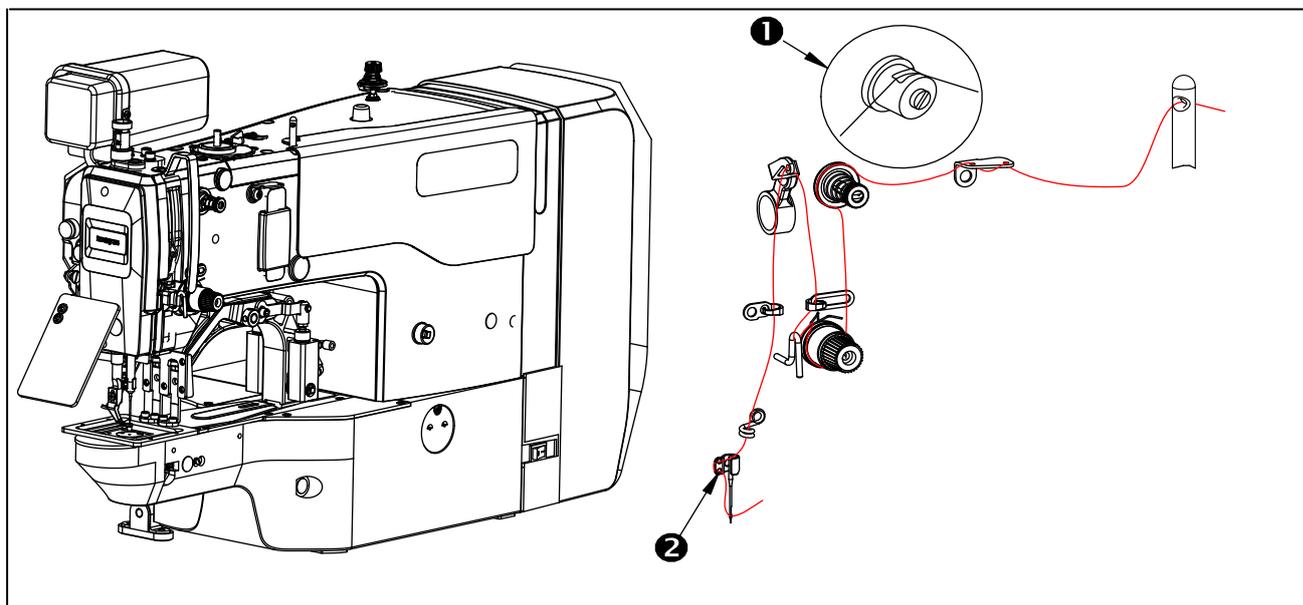


If the stitches are made as shown in "A", attach the needle facing to the direction "B" to a small extent.

3. Threading the machine head



WARNING : Turn of the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine



Pull out the thread by approximately 4cm from the needle after threading through the needle.

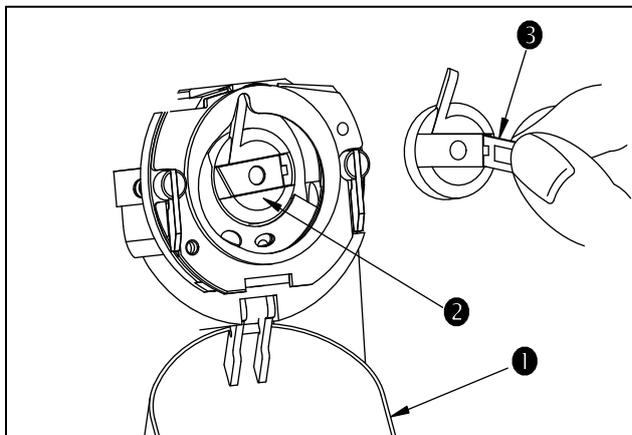


1. When the silicon oil is used, thread through thread guide for silicon①.
2. For thick thread, pass the thread through one hole only of needle bar thread guide②

4. Installing and removing the bobbin case



WARNING : Turn of the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



- (1). Open hook cover①。
- (2). Raise latch③ of bobbin case②, and remove the bobbin case.。
- (3). When installing the bobbin case, fully insert it into the shuttle shaft, and close the latch.

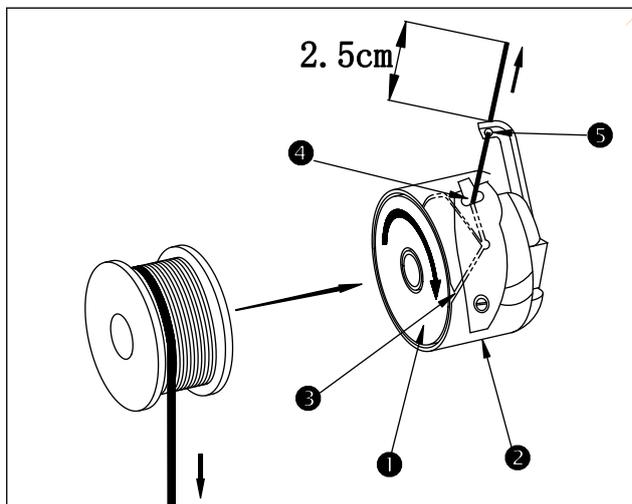


If it is not fully inserted, bobbin case ② may slip off during sewing.

5. Installing the bobbin



WARNING : Turn of the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine

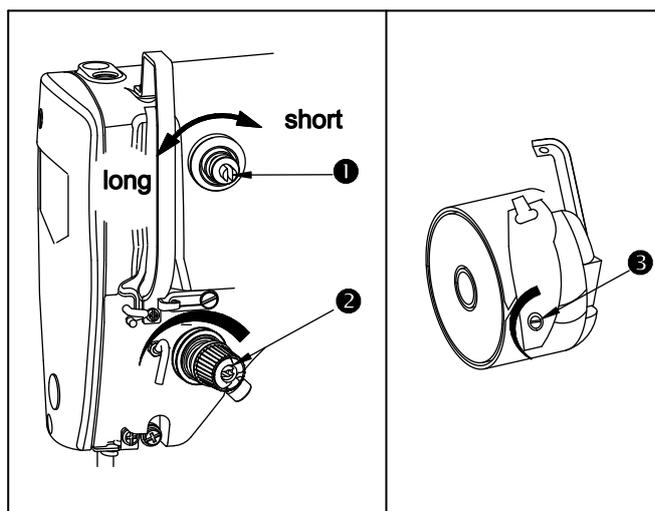


- (1). Set the bobbin ① into bobbin case ② in the direction shown in the figure.
- (2). Pass the thread through thread slit ③ of bobbin case ②, and pull the thread as it is. By so doing, the thread will pass under the tension spring and be pulled out from thread hole ④.
- (3). Pass the thread through thread hole ⑤ of the horn section, and pull out the thread by 2.5cm from the thread hole.



If the bobbin is installed in the bobbin case orienting the reverse direction, the bobbin thread pulling out will result in an inconsistent state.

6. Adjusting the thread tension

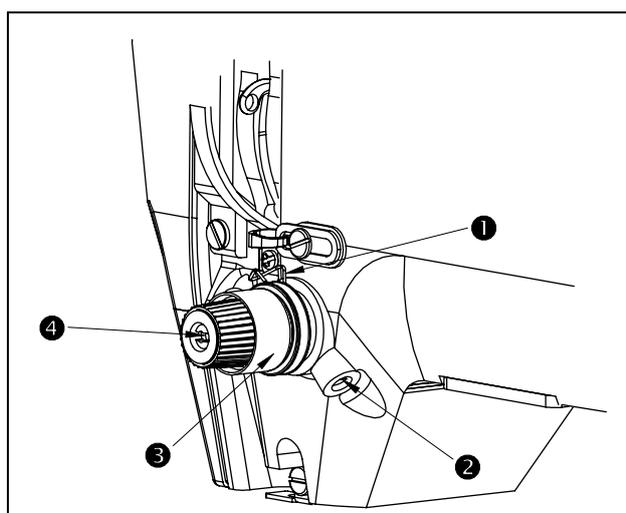


If thread tension controller No.1 ① is turned clockwise, the length of remaining thread on the needle after thread trimming will be shorter. If it is turned counterclockwise, the length will be longer.

Shorten the length to an extent that the thread is not slipped off.

with ② to adjust the upper thread tension, with ③ to adjust the bottom line tension.

7. Adjusting the thread take-up spring



The standard stroke of thread take-up spring ① is 8 to 10 mm, and the pressure at the start is 0.1 to 0.3N.

(1). Adjusting the stroke

Loosen setscrew ②, and turn thread tension asm. ③. Turning it clockwise will increase the moving amount and the thread drawing amount will increase.

(2). Adjusting the pressure

To change the pressure of the thread take-up spring, insert a thin screwdriver into the slot of thread tension post ② while screw ④ is tightened, and turn it. Turning it clockwise will increase the pressure of the thread take-up spring. Turning it counterclockwise will decrease the pressure.

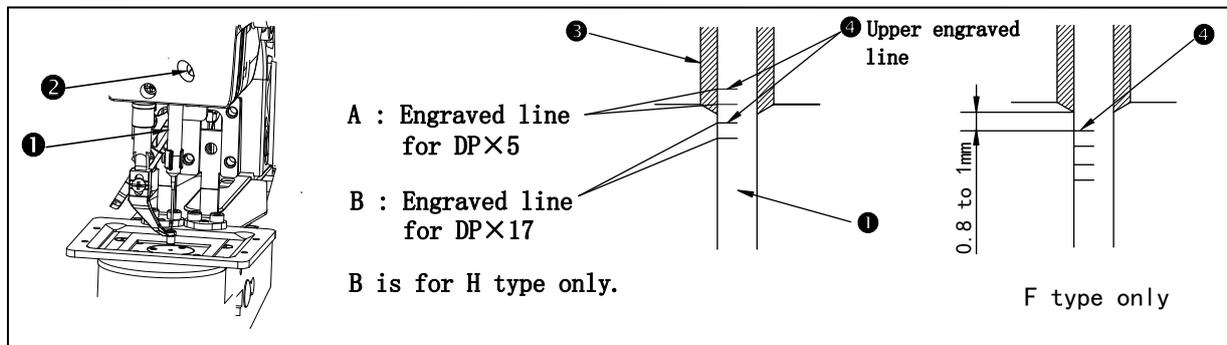
[5] MAINTENANCE

1. Adjusting the height of the needle bar



WARNING :

Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.



Bring needle bar ① to the lowest position of its stroke. Loosen needle bar connection screw ② and adjust so that upper marker line④ engraved on the needle bar aligns with the bottom end of needle bar bushing, lower ③. For F type only, adjust the needle bar to the position where it is lowered by 0.8 mm to 1 mm from the center of upper marker line ④ engraved on the needle bar.



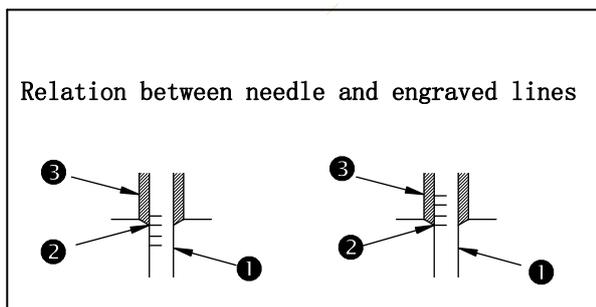
After the adjustment, make sure that there is no uneven torque. When stitch skipping occurs in accordance with the sewing conditions, adjust the height of the needle bar so as to lower it by 0.5 to 1 mm from the needle bar engraved line ④ .

2. Adjusting the needle-to-shuttle relation

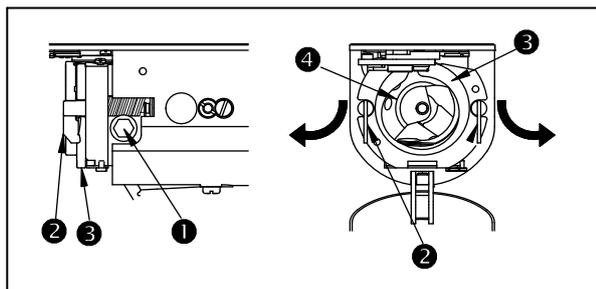


WARNING :

Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.



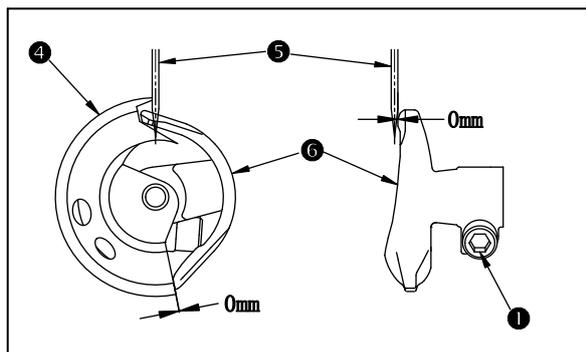
(1). Turn the hand wheel by hand. When needle bar① has gone up, adjust so that lower marker line② engraved on the needle bar aligns with the bottom end of the needle bar bushing ③ , lower.



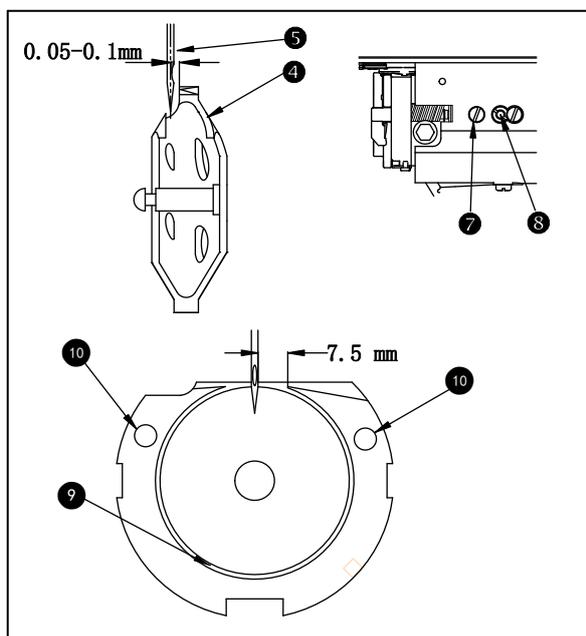
(2). Loosen setscrew ① in the driver. Open inner hook pressers ② to the right and left, and remove inner hook presser ③ .



At this time, be careful not to let inner hook ④ come off and fall.



(3). Adjust so that the blade point of inner hook ④ aligns with the center of needle ⑤, and that a clearance of 0 mm is provided between the front end of the driver and the needle as the front end face of driver ⑥ receives the needle to prevent the needle from being bent. Then tighten setscrew ① of



(4). Loosen setscrew ⑦ of the shuttle, and adjust the longitudinal position of the shuttle. To do this adjustment, turn shuttle race adjusting shaft ⑧ clockwise or counterclockwise to provide a 0.05 to 0.1 mm clearance between needle ⑤ and the blade point of inner hook ④ .

(5). After adjusting the longitudinal position of the shuttle, further adjust to provide a 7.5 mm clearance between the needle and the shuttle by adjusting the rotating direction. Then tighten setscrew ⑦ of the shuttle.



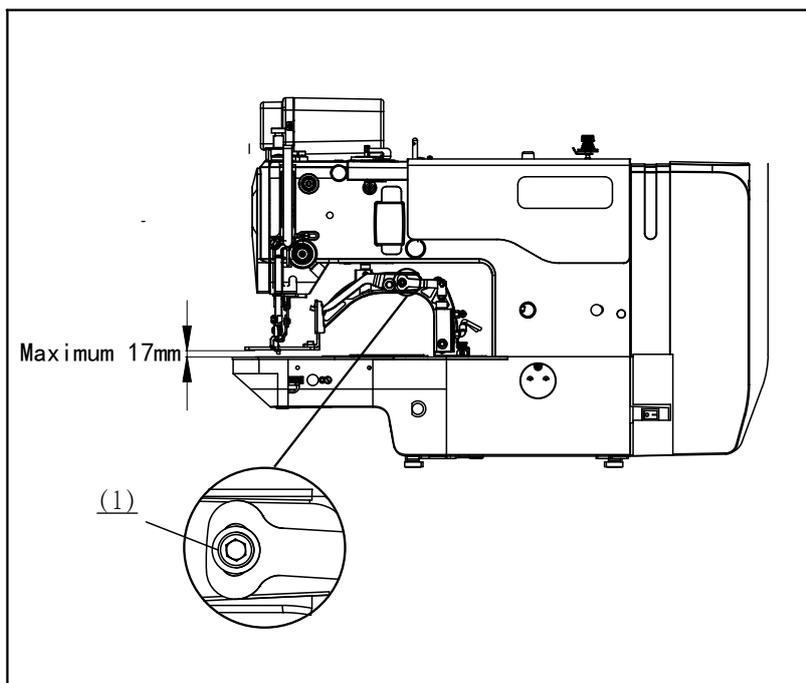
Apply a small amount of oil to race section ⑨ and oil wick ⑩ , and use the sewing machine after an extended period of disuse or cleaning the periphery of hook portion.

3. Adjusting the lift of the work clamp foot



WARNING :

Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.



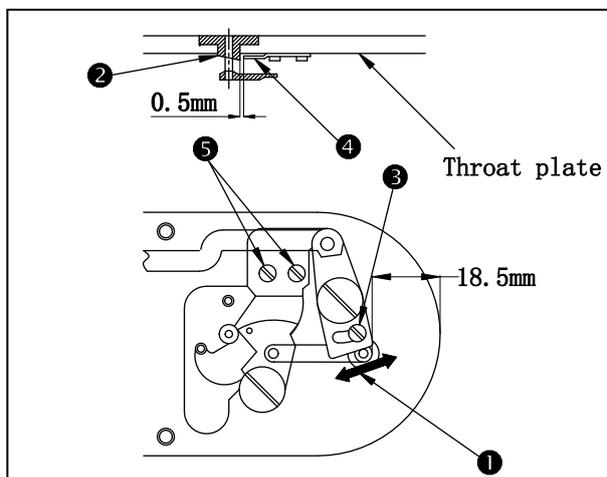
When the cylinder is compressed,loosen the screw(1) to adjust the height of the presser foot to a maximum of 17mm,and tighten the screw(1) after adjustment.

4. The moving knife and counter knife



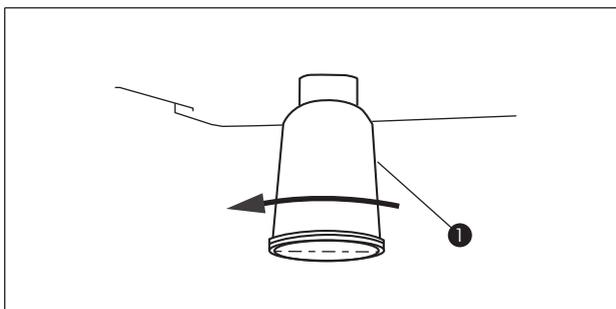
WARNING :

Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.

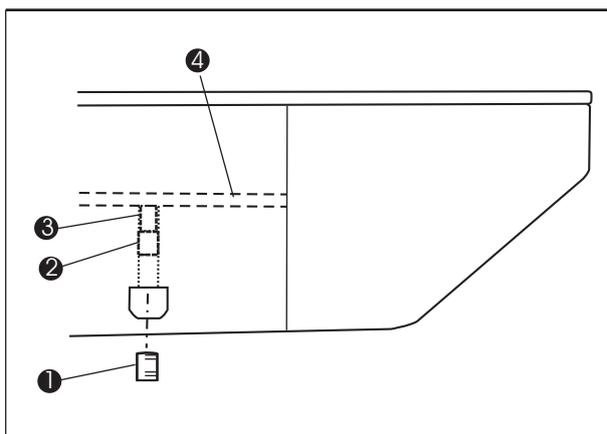


(1). Loosen adjusting screw ③ so that a clearance of 18.5 mm is provided between the front end of the throat plate and the top end of thread trimmer lever, small ① . To adjust, move the moving knife in the direction of arrow.

(2).Loosen setscrew⑤ so that a clearance of 0.5 mm is provided between needle hole guide ② and counter knife ④. To adjust, move the counter knife.

5. Draining waste oil

When polyethylene oiler ① becomes filled with oil, remove polyethylene oiler ① and drain the oil.

6. Amount of oil supplied to the hook

- 1) Loosen setscrew ① and remove setscrew ①.
- 2) When screwing in adjustment screw ②, the amount of oil of oil pipe, left ④ can be reduced.
- 3) After the adjustment, screw in setscrew ① and fix it.

1. The state of standard delivery is the position where ② is lightly screwed in and returned by 4 turns.



2. When reducing the amount of oil, do not screw in the screw at once. Observe the state for approximately half a day at the position where ② is screwed in and returned by 2 turns. If reducing is excessive, worn-out of the hook will result.

7. Replenishing the designated places with grease

When the sewing machine has been used for a certain number of times of sewing, error code No. E221 is displayed on the operation panel at the time of turning ON the power. This display informs the operator of the time of replenishing the designated places with oil. Be sure to replenish the places with the oil below. Then call the memory switch No. 245 and set it to "0" with the RESET key. Even after the display of the error No. E221, when the RESET key is pressed, the error is released, and the sewing machine can be continuously used. Afterwards, however, the error No. E221 is displayed every time the power is turned ON.

In addition, when the sewing machine is used further for a certain period of time after the display of error No. E220, the error No. E221 is displayed and the sewing machine fails to operate since the error cannot be released even when the RESET key is pressed.

When the error No. E221 is displayed, be sure to replenish the designated places below with oil. Then start up the memory switch and set No. 245 to "0" with the RESET key.

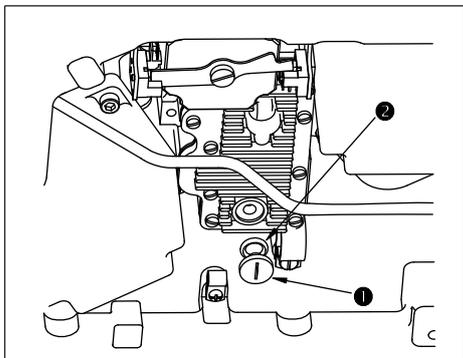


After replenishing the places with oil, the error No. E220 or No. E221 is displayed again unless the memory switch No. 245 is changed to "0".



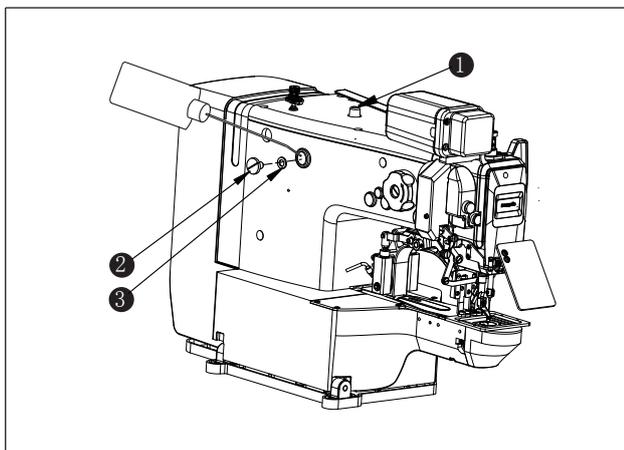
WARNING : Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.

(1) . Outflow the residual oil in gearbox



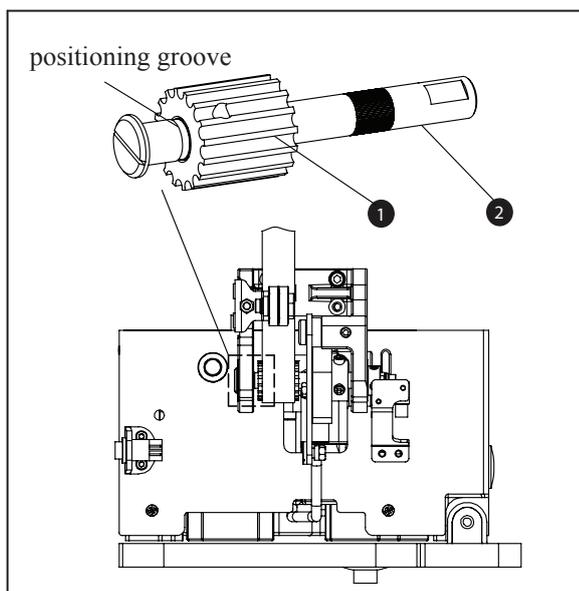
- 1) Tilt the machine, remove the screws ① and seal②.
- 2) put back sewing machine, outflow the residual oil in the gearbox.
- 3) tilt the machine again, put back the seals ②and screws ①, then put sewing machine back to the position.

(2) . Lubricate the upper gearbox



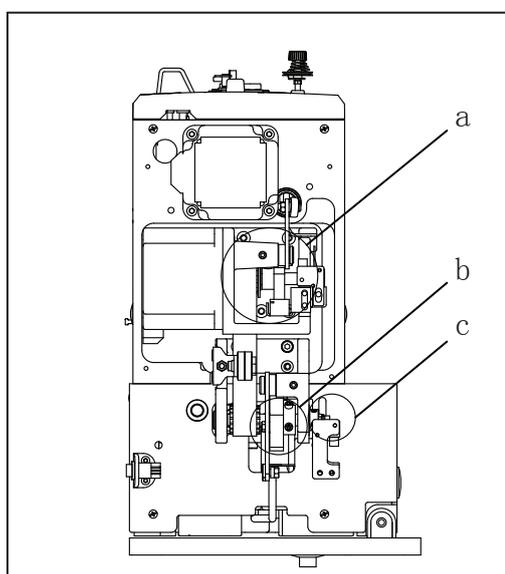
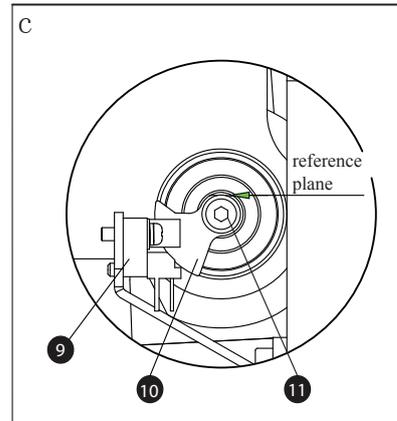
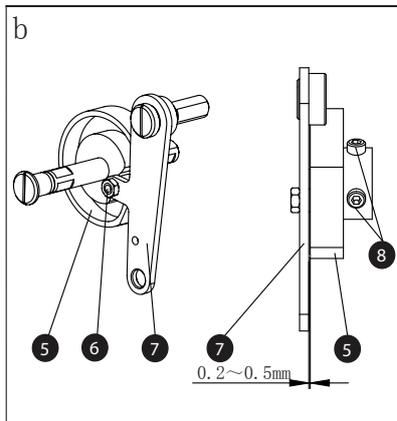
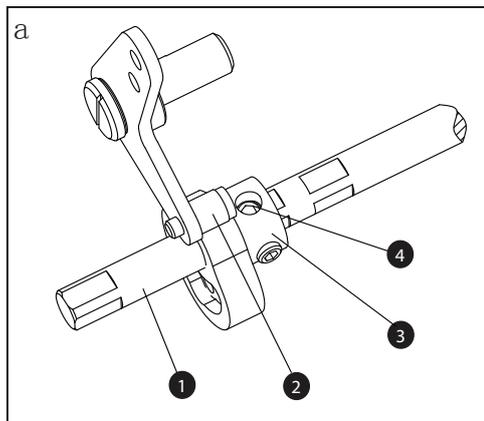
- 1) When through the oil window ①, you can not find oil outlet obviously, or it is without oil outlet, you should add the oil into the wheel gear box.
- 2) Turn off the machine, you can take down the screw ② and the rubber washer ③ ,when it is without oil outlet, please add 100ml 10# white oil; when it is not oil outlet obviously, please add 50-70ml.Please install back ② and ③ parts, turn on the machine and check whether it is happened to oil outlet or not.

8. Adjusting the position of the shear- driving pulley



Keep the left end of the shear-driving pulley ① aligned with the right end of the positioning groove that in the shear-driving shaft ②, Then tighten the screw on the shear-driving pulley.

9. Adjusting the wire-trimming cam and the wire-trimming safty plate



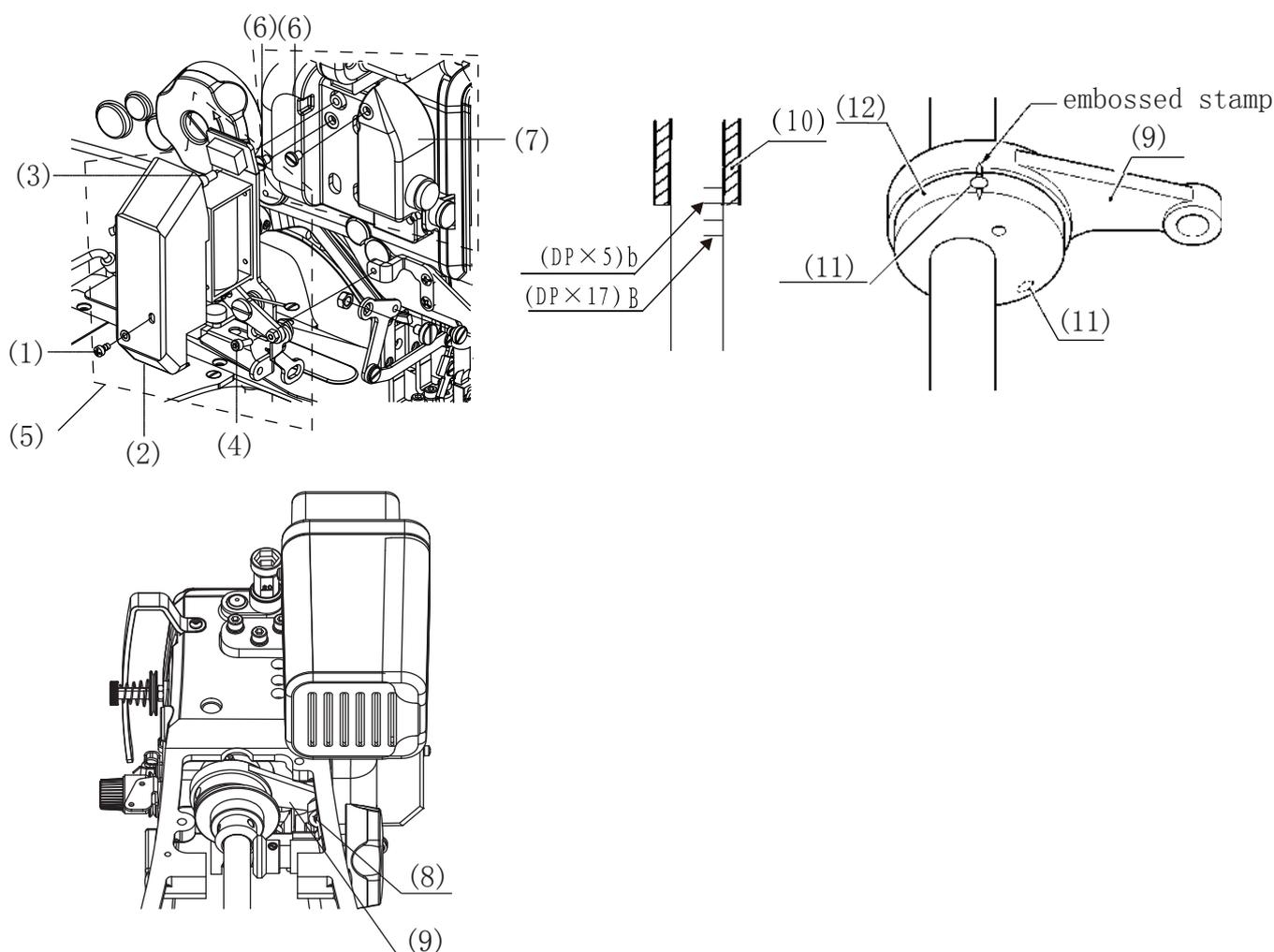
(1) Adjusting the wiretrimmin cam

- 1) Rotate the shaft of lifting motor ① to turn the lifting cam ③ to the lowest point of contact with the lift roller ② .The screw ④ is facing vertically upward ,as shown in the figure a.
- 2) Adjusting the roller ⑥ to the bottom of the the groove of the trimming cam ⑤ .
- 3) Tighten two screws ⑧ of the trimming cam after adjusting the distance between the trimming crank ⑦ and the end of trimmin -g cam ⑤ to be about 0.2-0.5mm,as shown in the figure b.

(2) Adjusting the wire-trimming safty plate

- 1) Rotatetheliftmotor shafttoturntheliftcam tothelowest pointofcontactwiththeliftroller, thinsent the screw is facing directabove.
- 2) Positioning reference plane of the trimming safety sensor horizontally upwards, and placing the trimming safety sensor in the trimming safety sensor, as shown in figure c, then loos screw to fix the trimming safety sensor.
- 3) Whenthefootpedalispresseedforthefirsttime, pressfootis presseddown, andthetrimmingsafety sensochipdoesnotenter the trimmingsafetysensorWhenthefootpedalispresseedfor the secondtime, themachine startstosew , andifthereisan alarmthatthemachine istrimmingabnormality, Pleasosen the screw andadjust the position of the trimming sensor chip i clockwise direction.

10. Position adjustment of presser foot connecting rod



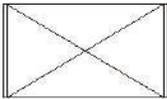
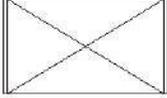
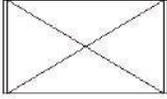
<1> Middle presser foot stroke adjustment.

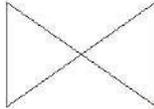
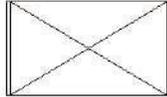
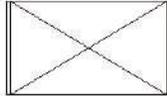
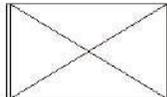
1. Unscrew the screw(1) to remove the wire pulling cover(2),and then unscrew the screw(3) and the screw(4) to remove the wire pulling electromagnet assembly(5) and then unscrew two screws(6) to remove the left housing assembly(7).
2. Loosen the nut(8)and adjust the position of the connecting rod(9).
 - ①、 Move the connecting rod(9) upward,and the stroke of the middle presser foot becomes larger,with the maximum stroke of 4.5mm.
 - ②、 Move the connecting rod(9) downward to reduce the stroke of the middle presser foot,and the minimum stroke is 2mm.

<2> Simultaneous adjustment of needle bar and middle presser foot.

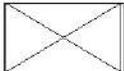
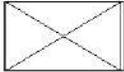
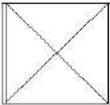
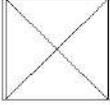
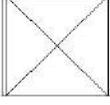
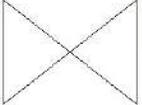
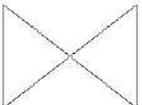
3. Rotate the handwheel to raise the needle bar from the lowest point,so that the second baseline b of the needle bar from top to bottom is aligned with the lower edge of the needle bar bushing(10).
(If the needle of DP×17 is used , please align with the bottom baseline B)
4. Unscrew the two screws(11),make the cam(12) consistent with the steel seal of the connecting rod(9),and then tighten the screw(11).

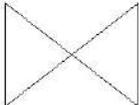
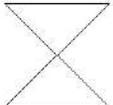
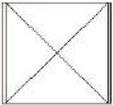
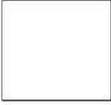
[6]. THE STANDARD PATTERNS

No.	Stitch diagram	Number of stitches	Sewing size mm		Needle distance mm
			Length-wise	Cross-wise	
1		62	50	60	4
2		80	50	60	3
3		94	50	60	2.5
4		128	50	60	4
5		168	50	60	3
6		198	50	60	2.5
7		48	25	25	3
8		48	25	25	3
9		38	20	20	3

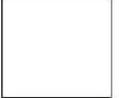
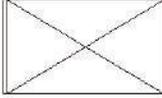
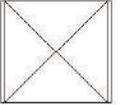
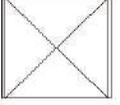
No.	Stitch diagram	Number of stitches	Sewing size mm		Needle distance mm
			Length-wise	Cross-wise	
10		38	20	20	3
11		33	18	18	3
12		33	18	18	3
13		30	13	18	3
14		30	13	18	3
15		45	25	35	3.5
16		108	30	40	3
17		96	30	40	3.5
18		84	30	40	4

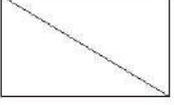
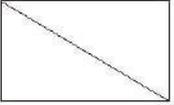
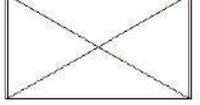
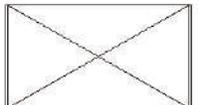
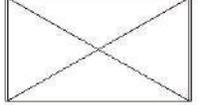
COMPUTER-CONTROLLED HIGH SPEED LOCKSTITCH BAR TACKING MACHINE

No.	Stitch diagram	Number of stitches	Sewing size mm		Needle distance mm
			Length-wise	Cross-wise	
19		66	25	35	4.5
20		62	25	30	4.5
21		58	20	30	4.5
22		68	28	28	4
23		66	20	28	3.5
24		66	20	25	3.5
25		52	20	20	4
26		42	30	40	4.5
27		38	25	35	4.5

No.	Stitch diagram	Number of stitches	Sewing size mm		Needle distance mm
			Length-wise	Cross-wise	
28		36	25	30	4.5
29		46	28	28	3.5
30		37	20	25	3.5
31		42	20	25	3.5
32		52	15	15	3
33		60	16	25	3.5
34		65	30	35	5
35		30	15	15	2.5
36		34	18	24	3

COMPUTER-CONTROLLED HIGH SPEED LOCKSTITCH BAR TACKING MACHINE

No.	Stitch diagram	Number of stitches	Sewing size mm		Needle distance mm
			Length-wise	Cross-wise	
37		36	20	24	3
38		36	16	25	3
39		42	25	25	3
40		42	25	35	3.5
41		48	20	40	3
42		54	30	40	3
43		46	30	30	3
44		107	20	38	2.5
45		91	20	28	2.5
46		78	20	19	2.5

No.	Stitch diagram	Number of stitches	Sewing size mm		Needle distance mm
			Length-wise	Cross-wise	
47		52	11	9	2
48		120	25	25	2
49		71	30	40	3
50		83	30	40	2.5
51		62	50	60	4
52		80	50	60	3
53		95	50	60	2.5
54		128	50	60	4
55		168	50	60	3
56		198	50	60	2.5

II. Troubles and corrective measures (sewing conditions)

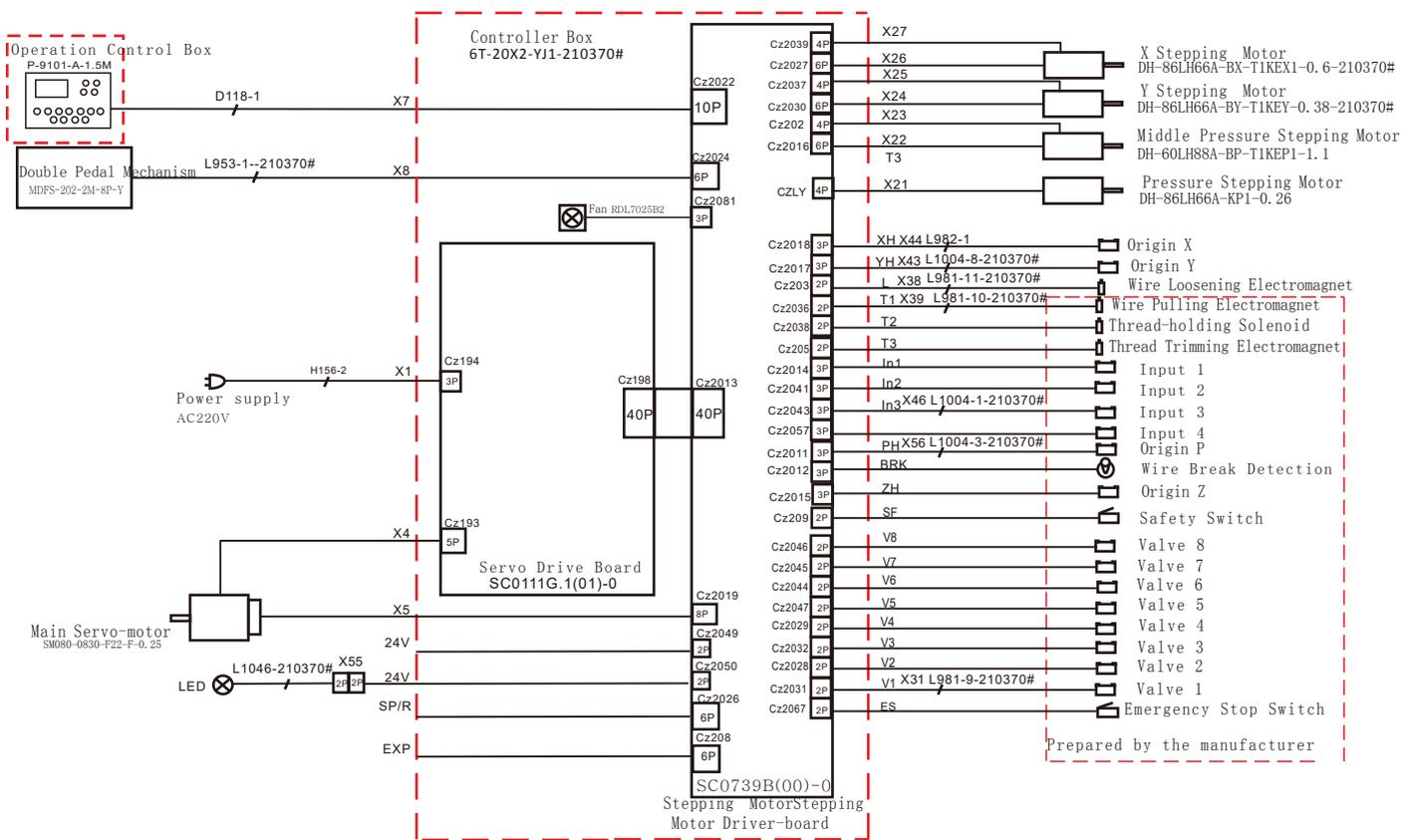
Trouble	Cause	Corrective measures
1.The needle thread slips off at the start of bar-tacking	<ul style="list-style-type: none"> ① Stitches are slipped at the start ② The needle thread remaining on the needle after thread trimming is too short. ③ The bobbin thread is too short. ④ Needle thread tension at 1st stitch is too high. ⑤ Pitch at 1st stitch is too small. 	<ul style="list-style-type: none"> ○ Adjust the clearance between the needle and the shuttle to 0.05 to 0.1mm. ○ Set soft-start sewing at the start of bar tacking. ○ Correct the thread tension release timing of the thread tension controller No.2. ○ Increase the tension of the thread take-up spring, or decrease the tension of the thread tension controller No.1. ○ Decrease the tension of the bobbin thread. ○ Increase the clearance between the needle hole guide and the counter knife. ○ Decrease the tension at 1st stitch. ○ Decrease the number of rotation at 1st stitch at the sewing start. ○ Make the pitch at 1st stitch longer. ○ Decrease the needle thread tension at 1st stitch.
2.Thread often breaks or synthetic fiber thread splits finely.	<ul style="list-style-type: none"> ①The shuttle or the driver has scratches. ②The needle hole guide has scratches. ③The needle strikes the work clamp foot. ④Fibrous dust is in the groove of the shuttle race. ⑤The needle thread tension is too high. ⑥The synthetic fiber thread take-up spring is too high. ⑦The synthetic fiber thread melts due to heat generated on the needle. 	<ul style="list-style-type: none"> ○Take it out and remove the scratches using a fine whetstone or buff. ○Buff or replace it. ○Correct the position of the work clamp foot. ○Take out the shuttle and remove the fibrous dust from the shuttle race. ○Reduce the needle thread tension. ○Reduce the tension. ○Use silicone oil .
3.The needle often breaks.	<ul style="list-style-type: none"> ①The needle is bent. ②The needle hits the work clamp foot. ③The needle is too thin for the material. ④the driver excessively bends the needle. 	<ul style="list-style-type: none"> ○Replace the bent needle. ○Correct the position of the work clamp foot. ○Replace it with a thicker needle according to the material. ○Correctly position the needle according to the material. ○Widen the distance between the needle and the

	⑤ Needle thread is stepped on by the work clamp foot at the start of sewing (Needle bend)	wiper.(23 to 25mm)
4. Threads are not trimmed.	① The counter knife is dull. ② The difference in level between the needle hole guide and the counter knife is not enough. ③ The moving knife has been improperly positioned. ④ The last stitch is skipped. ⑤ Bobbin thread tension is too low.	○ Replace the counter knife. ○ Increase the bend of the counter knife. ○ Correct the position of the moving knife. ○ Correct the timing between the needle and the shuttle. ○ Increase the bobbin thread tension.
5. Stitch skipping often occurs.	① The motions of the needle and shuttle are not properly synchronized. ② The clearance between the needle and shuttle is too large. ③ The needle is bent. ④ The driver excessively bends the needle.	○ Correct the positions of the needle and shuttle. ○ Correct the positions of the needle and shuttle. ○ Replace the bent needle. ○ Correctly position the driver.
6. The needle thread comes out on the wrong side of the material	① the needle thread tension is not high enough. ② The tension release mechanism fails to work properly. ③ The needle thread after thread trimming is too long. ④ Number of stitches is too few. ⑤ When sewing length is short (End of needle thread protrudes on the wrong side of sewing product.) ⑥ Number of stitches is too few.	○ Increase the needle thread tension. ○ Check whether or not the tension disc No.2 is released during bar-tracking. ○ Increase the tension of the thread tension controller No.1. ○ Correct the position of the moving knife. ○ Use the lower plate, the hole of which is larger than the presser.

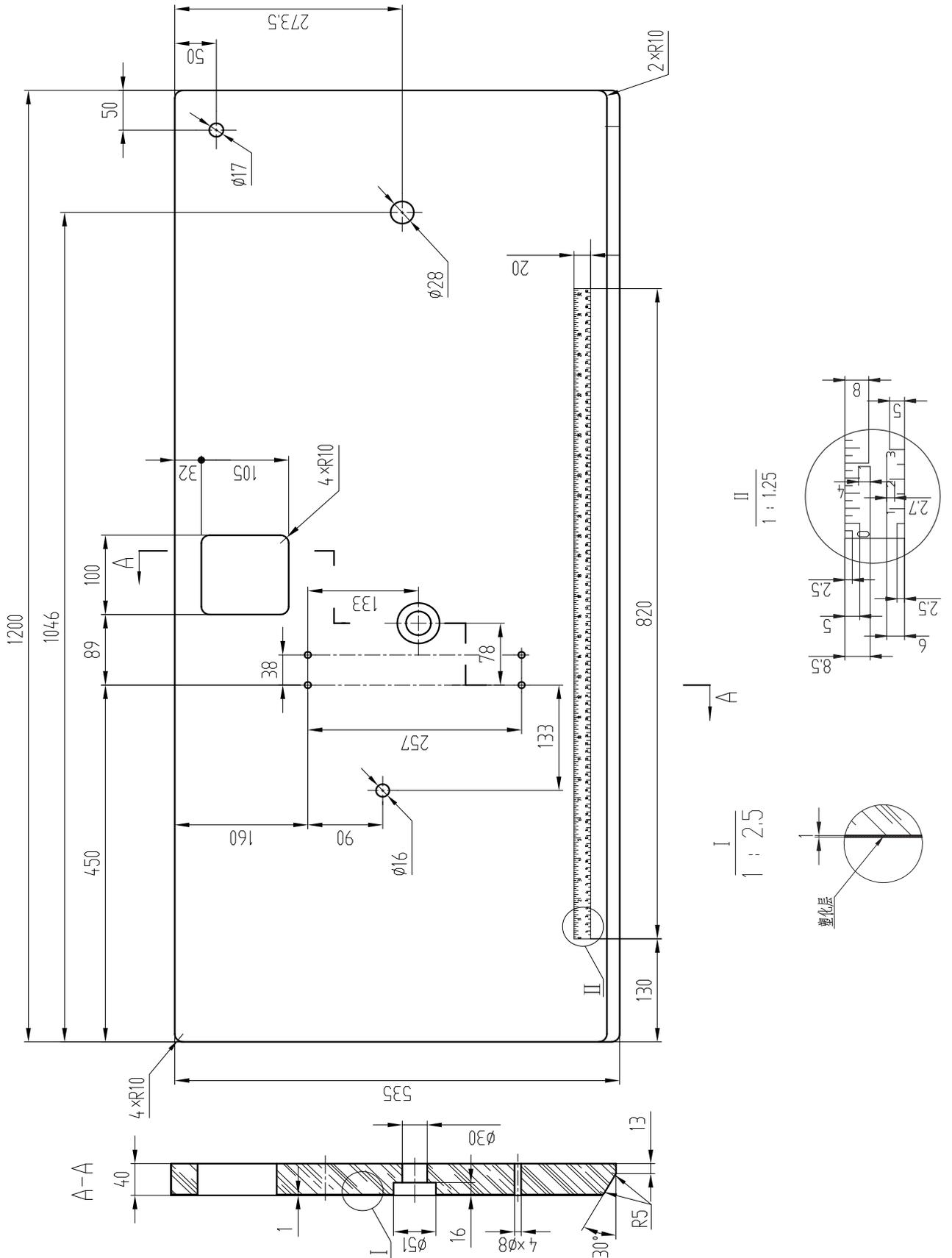
Trouble	Cause	Corrective measures
7. Threads break at time of thread trimming	①The moving knife has been improperly position.	○Correct the position of the moving knife.
8. Uneven length of the needle thread	①The tension of thread take-up spring is too low.	○Increase the tension of the thread take-up spring.
9. The length of needle thread does not become short	①The tension of thread tension controller No.1 is too low. ②The tension of thread take-up spring is too high. ③The tension of thread take-up spring is too low and motion is unstable.	○Increase the tension of thread tension controller No.1. ○Decrease the tension of thread take-up spring. ○Increase the tension of thread take-up spring and lengthen the stroke as well.

III. System diagram

1. System diagram of the electricity controls(-04)



IV.DRAWING OF THE TABLE



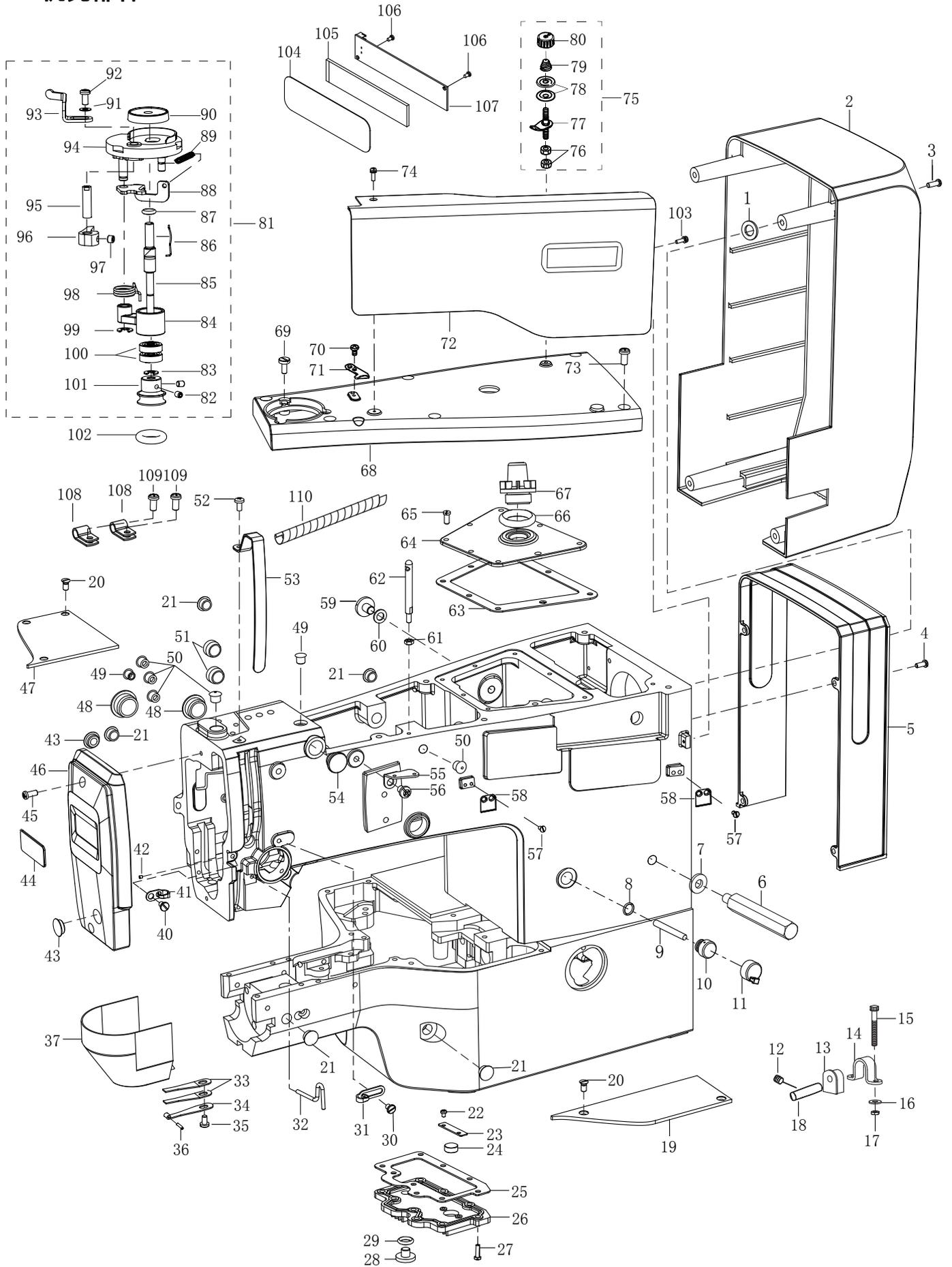
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1.FRAME&MISCELLANEOUS COVER COMPONENTS

机壳部件



1. 机壳部件FRAME&MISCELLANEOUS COVER COMPONENTS

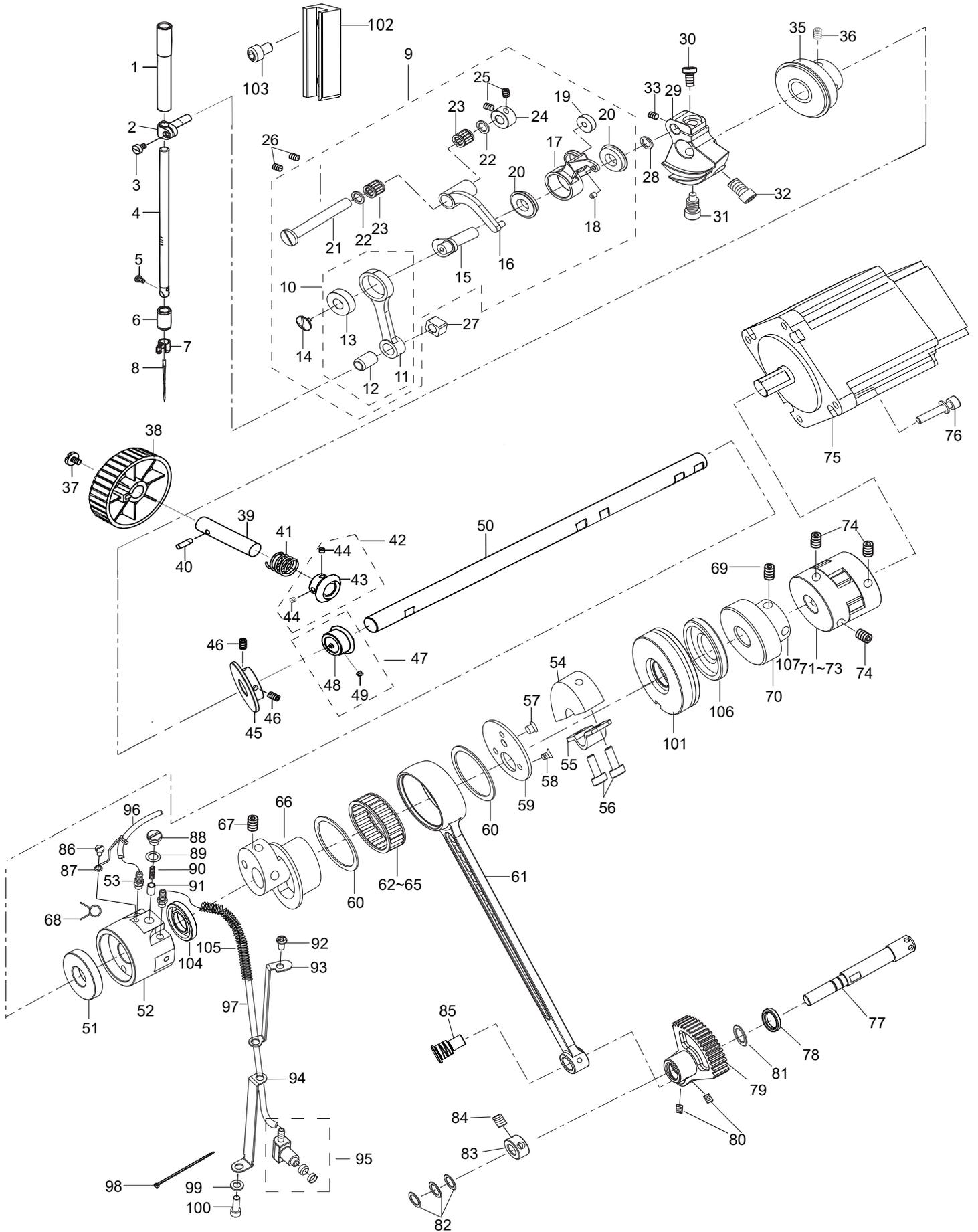
序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10011135	垫片	STOPPER	1
2	10062668	后罩	MOTOR COVER	1
3	10010900	螺钉 SM11/64"×40 L=12	SCREW SM11/64"×40 L=12	4
4	10042268	螺钉	SCREW M4×10	4
5	10071607	后装饰板☆	THE BACK PANEL	1
6	10052703	手柄	HAND SHANK	2
7	10028127	橡胶垫 $\phi 8 \times \phi 20 \times 3.5$	RUBER WASHER $\phi 8 \times \phi 20 \times 3.5$	2
8	10012139	O形圈	RUBBER RING	1
9	10021559	销	PIN	1
10	10002483	排气阀	EXHAUST VALVE	1
11	10008771	橡胶盖	RUBBER COVER	1
12	10011232	螺钉	SCREW	2
13	10011137	机头胶垫	HINGE RUBBER	2
14	10011160	支撑固定架	BED HINGE	2
15	10011147	螺钉	SCREW	4
16	10003076	垫圈	WASHER	4
17	10003084	螺母	NUT	8
18	10011141	销	PIN	2
19	20026582	底板右盖板	THE RIGHT BED PANEL	1
20	10011566	螺钉	SCREW	5
21	10011136	橡胶塞 $\phi 10.5$	RUBBER PLUG $\phi 10.5$	4
22	10042310	螺钉	SCREW	2
23	10001242	垫板	PLATE	1
24	10001096	磁铁	MAGNET	1
25	10037232	齿轮箱盖密封垫	GEAR BOX SEAL GASKET	1
26	10037233	齿轮箱底盖	GEAR BOX COVER	1
27	10000560	螺钉 SM11/64"×40 L=16	SCREW SM11/64"×40 L=16	9
28	10008783	螺钉	SCREW	1
29	10010204	O形圈	RUBBER RING	1
30	10011142	螺钉	SCREW	1
31	10008940	右线钩	THE RIGHT THREAD GUIDE	1
32	10037247	拦线钩	L-SHAPED THREAD GUIDE	1
33	10010807	梭床罩弹簧B	HOOK COVER PRESSER SPRING B	1
34	10011420	梭床罩弹簧A	HOOK COVER PRESSER SPRING A	1
35	10010808	螺钉	SCREW	1
36	10010815	销	PIN	1
37	20023956	梭床罩焊合	SHUTTLE RACE CAP	1
40	10011142	螺钉	SCREW	1
41	10014281	中线钩	THE MID THREAD GUIDE	1
42	10011887	螺钉	SCREW	1
43	10011099	橡胶塞 $\phi 12.5$	RUBBER PLUG $\phi 12.5$	2
44	10070679	面板装饰牌☆	PLATE	1
45	10011150	螺钉	SCREW	2
46	20026702	面板	FACE COVER	1
47	20026581	底板左盖板	THE LEFT BED PANEL	1
48	10011146	橡胶塞 $\phi 20.8$	RUBBER PLUG $\phi 20.8$	2
49	10011188	橡胶塞 $\phi 7.4$	RUBBER PLUG $\phi 7.4$	2
50	10010587	橡胶塞 $\phi 8.5$	RUBBER PLUG $\phi 8.5$	5
51	10014279	橡胶塞 $\phi 15.3$	RUBBER PLUG $\phi 15.3$	2
52	10011150	螺钉 SM11/64"×40 L=10	SCREW SM11/64"×40 L=10	1
53	10062652	挑线杆防护罩	BALANCE COVER	1
54	10011190	橡胶塞 $\phi 14.5$	RUBBER PLUG $\phi 14.5$	1

1. 机壳部件FRAME&MISCELLANEOUS COVER COMPONENTS

序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
55	10011200	上过线板	THREAD GUIDE PLATE	1
56	10011158	螺钉	SCREW	1
57	10053628	SM9/64"×40螺钉 L=5.5	SCREW SM9/64"×40 L=5.5	4
58	10062675	卡紧扣	THE LOCKING PLATE	2
59	10051608	螺钉 SM5/16"×24 L=10橡胶	SCREW SM5/16"×24 L=10	1
60	10009988	垫 φ 7.8×φ 13.5×1.3 M4螺	RUBBER WASHER φ 7.8×φ 13.5×1.3	1
61	10009471	母 (GB/T 6170-2000)	NUT (GB/T 6170-2000)	1
62	10062648	过线柱	THREAD GUIDE	1
63	10037218	上密封盖板垫	UPPER SEAL GASKET	1
64	10051609	上密封盖板	UPPER SEAL PLATE	1
65	10013977	螺钉	SCREW	7
66	10008939	O形圈	RUBBER RING	1
67	10012438	油窗	OIL TANK	1
68	20023812	上盖	TOP COVER	1
69	10011101	螺钉	SCREW	3
70	10011143	螺钉	SCREW	1
71	10011149	绕线切刀	THREAD CUTTER	1
72	20025162	右装饰板	THE RIGHT PANEL	1
73	10011161	螺钉	SCREW	6
74	10012599	螺钉 M5×7.8	SCREW M5×7.8	2
75	10062647	夹线器	BOBBIN THREAD TENSION ASM	1
76	10004507	螺母	NUT	2
77	10004504	中过线板组件	BOBBIN THREAD TENSION ROD ASM	1
78	10004393	夹线板	THEAD TENSION DISK	2
79	10004391	弹簧	CONNECTING ROD SPRING	1
80	10062660	夹线螺母组件	NUT	1
81	10002558	绕线器	BOBBIN WINDER ASM	1
82	10002896	螺钉	SCREW	2
83	10007895	挡圈	E-RING	1
84	10027388	摆动连杆	BOBBIN WINDER SHAFT COMPL	1
85	10031163	梭心卷绕轴	BOBBIN SHAFT	1
86	10031058	弹簧	SPRING	1
87	10027399	O型圈	RUBBER RING	1
88	10027391	控制板	ADJUSTING PLATE	1
89	10027394	弹簧	SPRING	1
90	10027390	卷绕轴垫	CUSHING	1
91	10003122	垫圈	WASHER	1
92	10009455	螺钉	SCREW	1
93	10030709	卷绕手柄	BOBBIN LEVER	1
94	10031087	梭心卷绕体组件	BOBBIN FITING BASIS COMPL	1
95	10006152	绕线凸轮轴	BOBBIN CAM SHAFT	1
96	10027395	绕线定位块	BOBBIN WINDER REGULATOR	1
97	10012014	螺钉	SCREW	1
98	10004501	弹簧	SPRING	1
99	10013038	挡圈	E-RING	1
100	10003517	625ZZ轴承	BEARING	1
101	10027392	绕线轮	BOBBIN WINDER WHEEL	1
102	10011097	橡胶轮	RUBBER RING	1
103	10011143	SM9/64"×40螺钉	SCREWM9/64"×40	1
104	10071604	发光LOGO贴膜☆	LOGO	1
105	10064763	LOGO电路板组件	CIRCUIT BOARD ASM	1
106	10063815	螺钉	SCREW	1
107	10043310	橡皮塞 φ 8.8	RUBBER PLUG φ 8.8	1
108	10001546	电线夹	CLAMP	2
109	10012892	M4×9.5螺钉	SCREW M4×9.5	2
110	10002458	卷式结束带KS-19	SPIRAL WRAPPING BAND KS-19	1

2.MAIN SHAFT&NEEDLE BAR COMPONENTS

挑线刺布部件



2. 挑线刺布部件MAIN SHAFT & NEEDLE BAR COMPONENTS

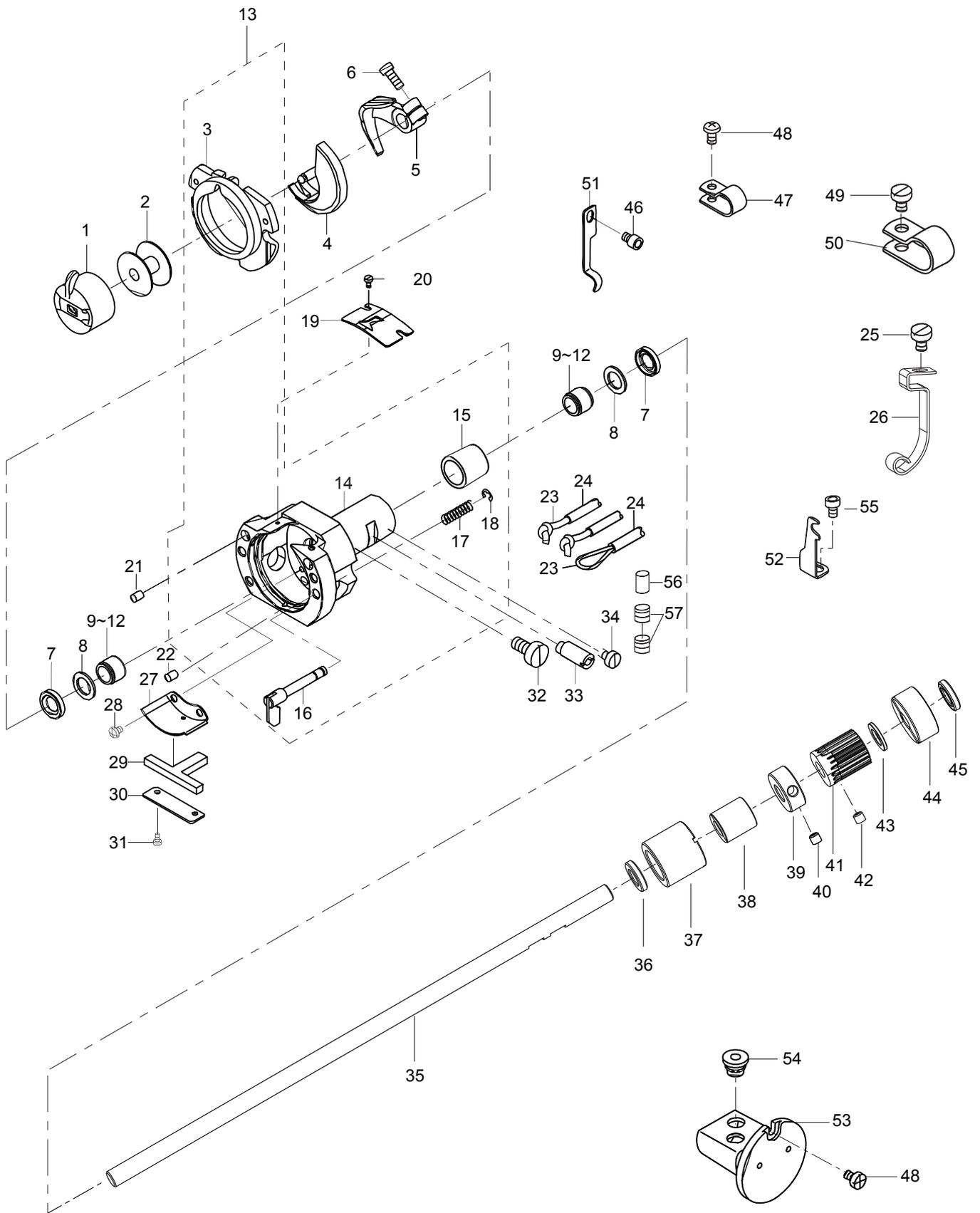
序号 Ref. No.	件号 Part No.	名称	Description	数量 QTY
1	10028715	轴套	NEEDLE ROD SLEEVE	1
2	10010590	针杆连接柱	NEEDLE BAR CONNECTING COLUMN	2
3	10030286	螺钉	SCREW	1
4	10052907	针杆	NEEDLE BAR	1
5	10011699	螺钉	SCREW	1
6	10028716	轴套	NEEDLE ROD LOWER METAL	1
7	10011701	针杆线钩	THREAD GUIDE	1
8	10023286	机针	NEEDLE DP? #16	1
9	10051398	挑线杆组件	THREAD TAKE UP COMPL	1
10	10007983	针杆连杆组件	NEEDLE BAR CRANK BOD ASM	1
11	10007986	针杆连杆	NEEDLE BAR CRANK ROD	1
12	10005793	针杆连杆轴套	NEEDLE BAR CRANK BOD METAL	1
13	10009777	轴承	BEARING	1
14	10010537	螺钉	SCREW	1
15	10008014	挑线曲柄	NEEDLE BAR CRANK	1
16	10052056	挑线连杆	THREAD TAKE UP CRANK	2
17	10052057	挑线杆	THREAD TAKE UP LEVER	1
18	10004161	挑线杆过线套	THREAD PASS BUSH	1
19	10003591	轴承	BEARING	1
20	10051399	轴承	BEARING	2
21	10007984	挑线连杆销	BALANCE CRANK PIN	1
22	10005786	挡圈	THRUST COLLAR	2
23	10005747	轴承	BEARING	2
24	10005745	挡圈	THRUST COLLAR	1
25	10004482	螺钉	SCREW	2
27	10011194	针杆连接柱滑块	SQUARE BLOCK	1
28	10011622	挡圈	THRUST COLLAR	1
29	10052054	针杆曲柄	COUNTER EIGHT	1
30	10014272	螺钉	SCREW	1
31	10014282	螺钉	SCREW	1
32	10014284	螺钉	SCREW	1
33	10050053	螺钉 M6×0.75 L=6	SCREW M6×0.75 L=6	1
35	10064390	轴承组件_6004	BEARING ASM 6004	1
36	10042442	螺钉	SCREW M6×8	2
37	10011225	螺钉	SCREW	1
38	10062644	手轮	PULLEY	1
39	10062650	手轮轴	HAND PULLEY SHAFT	1
40	10006073	销	PIN	1
41	10062651	弹簧	SPRING	1
42	10021312	弧齿锥齿轮组件_手轮轴	GEAR ASM.	1
43	10011235	齿轮	GEAR	1
44	10011226	螺钉	SCREW	2
45	10064387	绕线主动轮	BTW DRIVING WHEEL	1
46	10042511	下轴前衬套螺钉	SCREW	2
47	10027407	上轴齿轮组件	GEAR ASM.	1
48	10002413	齿轮	GEAR	1
49	10011226	螺钉	SCREW	2
50	10062903	上轴	MAIN SHAFT	1
51	10058049	油封	OIL SEAL	1

2. 挑线刺布部件MAIM SHAFT & NEEDLE BAR COMPONENTS

序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
52	10037249	油泵体组件	OIL PUMP ASM	2
53	10008779	油管接头	JOINT	1
54	10014337	上轴平衡轮	CRANK BALANCER	1
55	10014332	上轴平衡轮固定板	CRANK BALANCER FIX PLATE	1
56	10011644	螺钉	SCREW	2
57	10014266	橡胶塞	PUBBER PLUG	1
58	10009626	螺钉	SCREW	3
59	10014268	大连杆滚针轴承盖板	CRANK ROD SUPPORT PLATE	1
60	10014269	挡圈	RETAINING COLLAR	2
61	10037219	大连杆	CRANK ROD	1
62	10023508	轴承	BEARING	(1)
63	10023509	轴承	BEARING	(1)
64	10023510	轴承	BEARING	1
65	10023511	轴承	BEARING	(1)
66	10014265	偏心轮	ECCENTRIC WHEEL	1
67	10009187	螺钉	SCREW	2
68	10012160	弹簧	SPRING	2
69	10042442	螺钉	SCREW M6×8	2
70	10077967	6204NR-2RS-DC_BOM轴承	BEARING ASM 6204NR	1
71	10012615	电机端联轴器	COUPLING	1
72	10011227	传动连接橡胶块	RELAX	1
73	10012613	上轴端联轴器	COUPLING	1
74	10009187	螺钉	SCREW	4
75	10069823	上轴电机	AC SERVO MOTOR	1
76	10000157	螺钉	SCREW	4
77	10037229	销	PIN	1
78	10064708	油封	OIL SEAL	1
79	10037230	齿轮	BEARING	2
80	10011232	螺钉	SCREW	2
81	10037231	垫圈	WASHER	1
82	10010146	O形圈	RUBBER RING	3
83	10010803	挡圈	RETAINING COLLAR	1
84	10013590	螺钉	SCREW	2
85	10037228	销	PIN	1
86	10002129	螺钉	SCREW	1
87	10037260	油管定位架	FILLER PIPE HOLDER	1
88	10013232	螺钉	SCREW	1
89	10037261	防油纸垫	PAPER SPACER	1
90	10013238	活塞弹簧	SPRING	1
91	10012609	柱塞	PLUNGER	1
92	10046049	螺钉	SCREW	1
93	10037221	上油管架	UPPER FILLER PIPE BRACKET	1
94	10037222	下油管架	LOWER FILLER PIPE BRACKET	1
95	10000471	油管二接头	FILLER PIPE JOINT ASM.	1
96	10007800	φ3×φ5油管	φ3×φ5 FILLER PIPE	50mm
97	10007800	φ3×φ5油管	φ3×φ5 FILLER PIPE	310mm
98	40000363	扎带	BINDING TAPE	3
99	10006115	垫圈	WASHER	1
100	10013616	螺钉	SCREW	1
101	10070208	油封衬套	OIL SEAL METAL	1
102	10037240	滑块槽	SQUARE BLOCK TROUGH SCREW	1
103	10014477	螺钉	SCREW	2
104	10013448	油封	OIL SEAL	1
105	10051546	弹簧	SPRING	1
106	10058049	油封	OIL SEAL	1
107	10000313	上轴轴承挡圈	RETAINING RING	1

3. SHUTTLE DRIVER SHAFT COMPONENTS

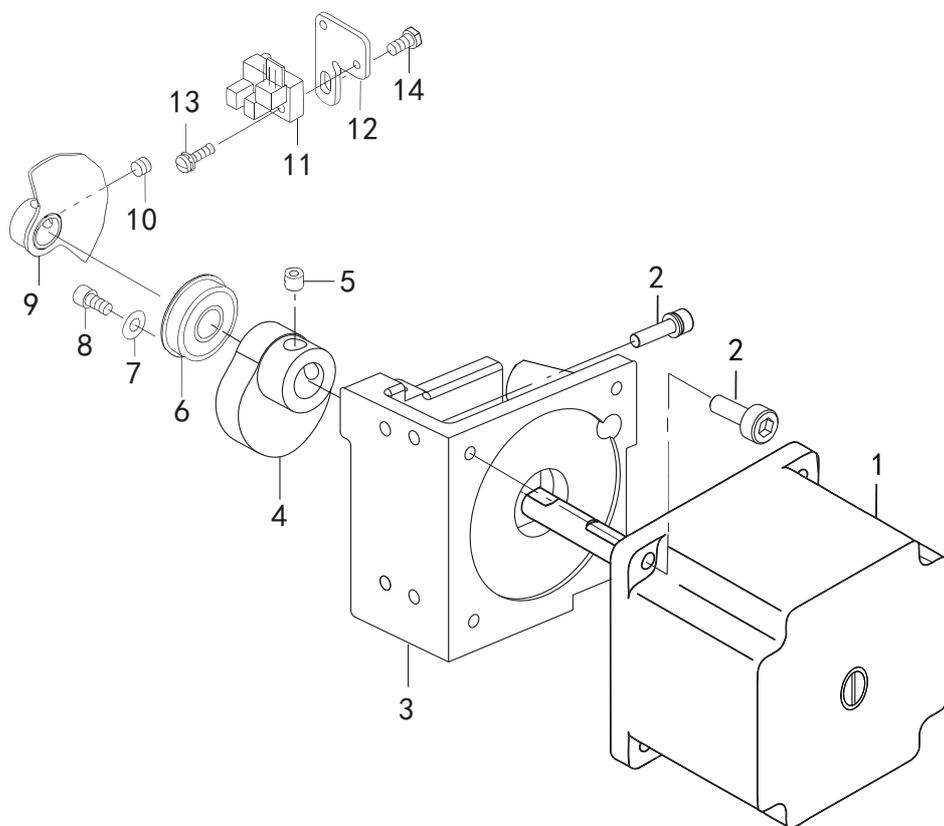
下轴部件



3. 下轴部件SHUTTLE DRIVER SHAFT COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10003781	梭壳	BOBBIN CASE ASM	1
2	10004592	锁芯	BOBBIN	1
3	10010738	梭床盖组件	SHUTTLE RACE RING ASM	1
4	10025068	摆梭	INNER HOOK	1
5	10004609	摆梭托	SHUTTLE DRIVER	1
6	10004611	螺钉	SCREW	1
7	10014297	油封	SHUTTLE OIL SEAL	2
8	10014295	挡圈	SHUTTLE BEARING RING	2
9	10023516	轴承	BEARING	2
10	10023517	轴承	BEARING	2
11	10023518	轴承	BEARING	2
12	10023519	轴承	BEARING	2
13	10026549	梭床与盖组件	SHUTTLE ASM.	1
14	10014248	梭床	SHUTTLE	1
15	10008576	梭床衬套	SHUTTLE BUSH	1
16	10004261	梭床锁紧钩组	INNER HOOK PRESSER ASM.	2
17	10004495	件弹簧	SPRING	2
18	10009669	挡圈	E-RING	2
19	10004596	梭床簧	SHUTTLE UPPER SPRING	1
20	10010744	螺钉	SCREW	2
21	10011427	毛毡	SHUTTLE OIL FELT	1
22	10011077	毛毡	SHUTTLE OIL FELT	1
23	10008103	油线	OIL WICK	2
24	10007795	油管	FILLER PIPE	2
25	10009849	M5×8 螺钉	SCREW M5×8	1
26	10026912	油管限位板C	OIL_PIPE HOLDER	1
27	10007926	油线夹板	SHUTTLE LUBRICATING PLATE	1
28	10010797	螺钉	SCREW	2
29	10010800	毛毡	SHUTTLE ONCE THROUGH OIL FELT	1
30	10010799	毛毡压板	ONCE THROUGH OIL LFELT PRESSER	1
31	10010744	螺钉	SCREW	2
32	10045298	螺钉	SCREW	1
33	10011426	螺钉	SCREW	1
34	10011425	螺钉	SCREW	1
35	10037224	下轴	LOWER SHAFT	1
36	10035171	油封	OIL SEAL	1
37	10037225	下轴前衬套	SLEEVE A	1
38	10037273	轴承	NUT	1
39	10037298	挡圈	WASHER	1
40	10013590	螺钉	SCREW	2
41	10037223	齿轮	GEARED	1
42	10011232	螺钉	SCREW	2
43	10037227	垫圈	WASHER	1
44	10037226	下轴后轴套	SLEEVE B	1
45	10035171	油封	OIL SEAL	1
46	10005107	螺钉	SCREW	1
47	10008228	SN-3A夹头	CABLE CLIP	1
48	10012892	螺钉	SCREW	2
49	10011101	螺钉	SCREW	1
50	10008229	SL-12N夹头	CABLE CLIP	1
51	10014294	油管限位板	OIL_PIPE HOLDER	1
52	10014288	油管限位板	TUBE_CLAMP	1
53	10021601	油窗组件	OIL TANK ASM.	1
54	10014296	油塞	RUBBER BUSH	2
55	10010685	螺钉	SCREW	2
56	10011916	油量调节销	NYLON BUSH 4.6×10	1
57	10011232	螺钉 M6×6	SCREW M6×6	2

4. PRESSER FOOT MOTOR COMPONENTS 压脚电机部件

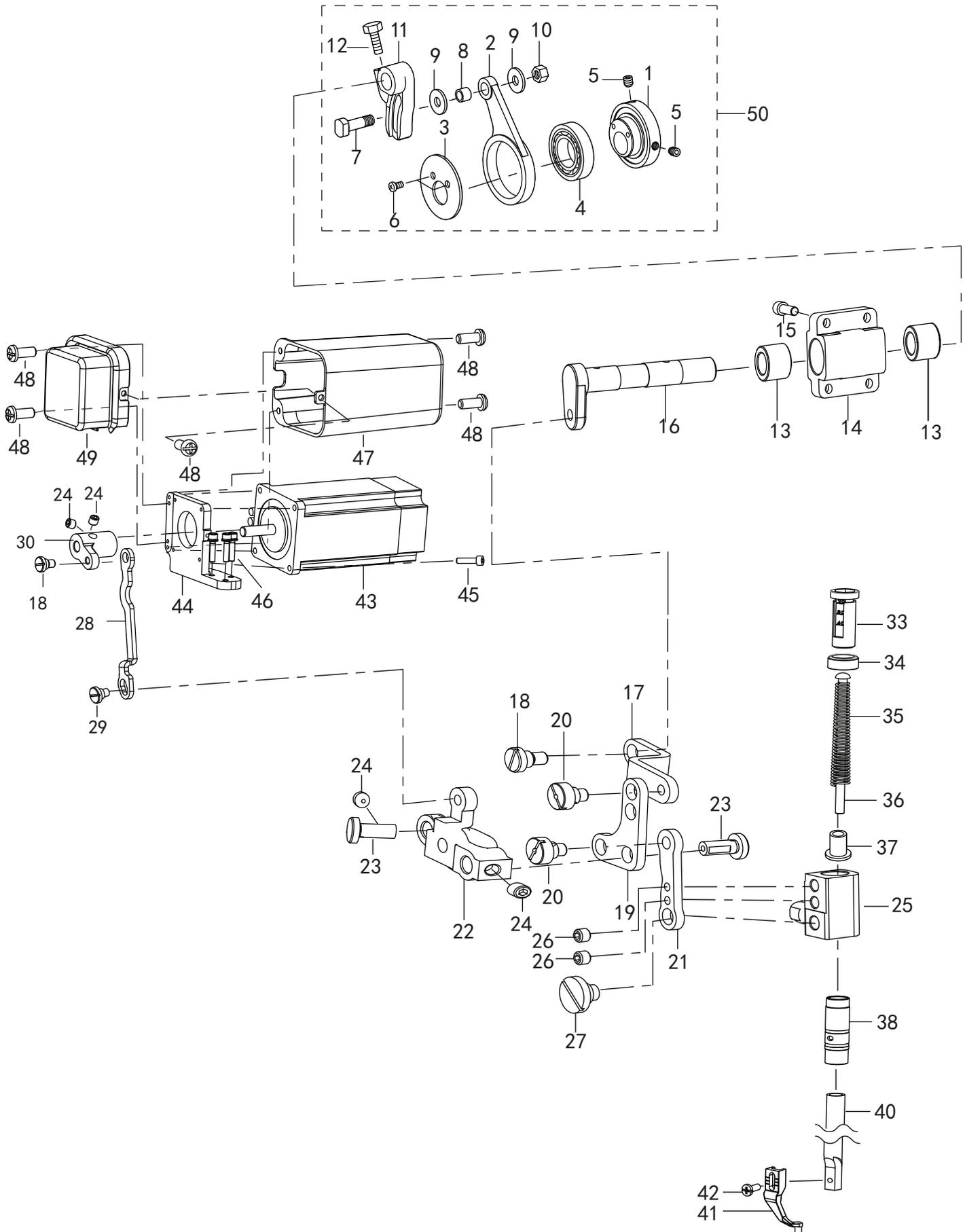


4. PRESSER FOOT MOTOR COMPONENTS

序号 Ref. No.	件号 Part No.	名 称	Description	数量 QTY
1	10069824	抬压电机	PRESSER LIFTING MOTOR	1
2	10000157	螺钉	SCREW	8
3	10062814	电机固定架	MOTOR HOLDER	1
4	10014287	抬压凸轮	LIFT TO PRESS THE CAM	1
5	10011232	螺钉	SCREW	2
6	10050516	轴承_6000NR-2RS_BOM	BEARING_6000NR-2RS_BOM	1
7	10010741	垫圈	WASHER	1
8	10010668	螺钉	SCREW	1
9	10014293	抬压电机传感片组件	SENSOR SLIT	1
10	10044814	螺钉	SCREW	2
11	10069195	传感器_带卡扣	SENSOR	1
12	10014291	抬压传感器安装板	SENSOR_INSTALLING_BASE	1
13	10010667	螺钉组件	SCREW	1
14	10009486	螺钉SM11/64"×40 L=8.5	SCREW SM11/64"×40 L=8.5	1

5. PRESSER MECHANISM & PRESSER VARIABLE COMPONENTS

中压脚部件

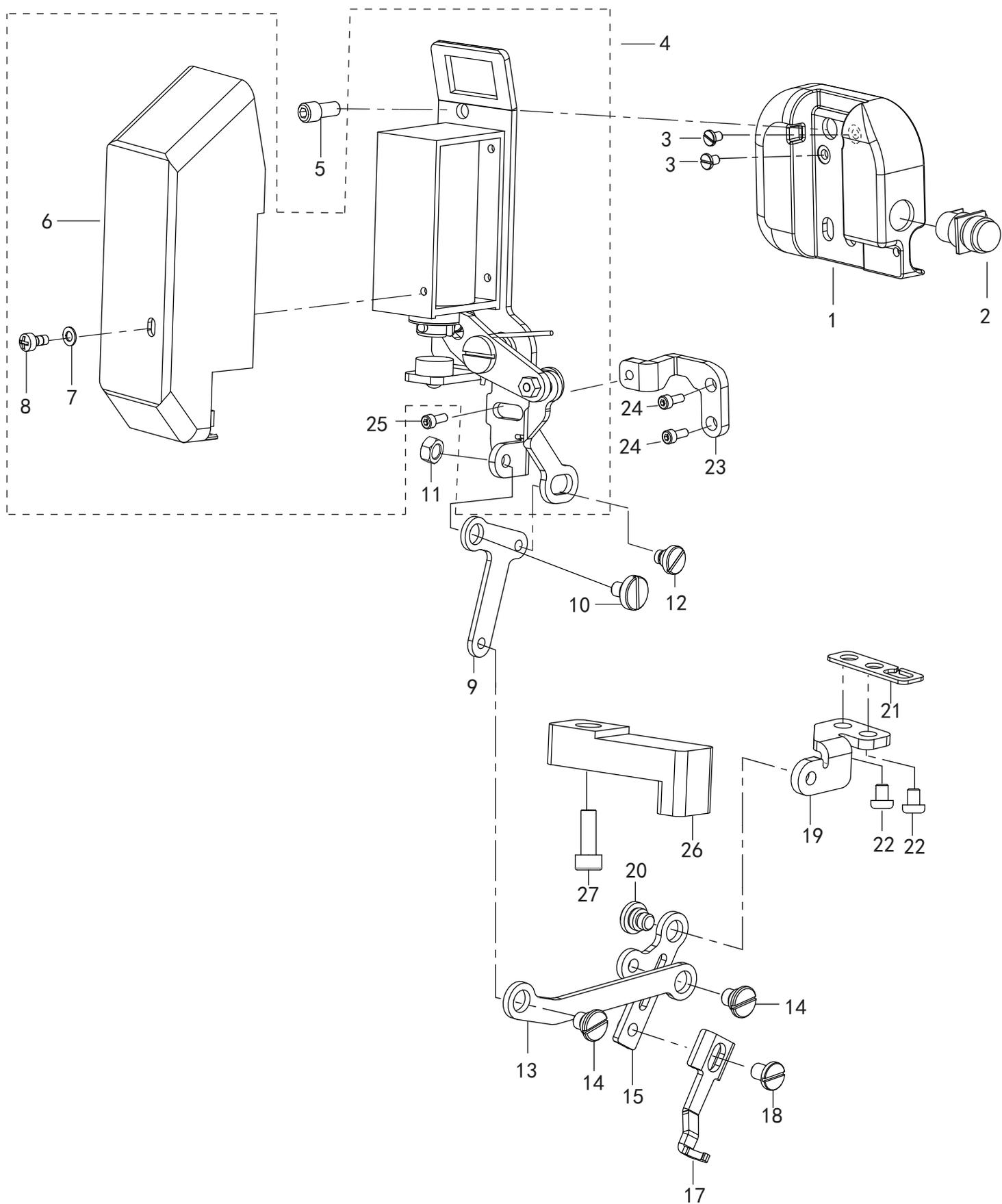


5. PRESSER MECHANISM & PRESSER VARIABLE COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10073676	凸轮	STEPPING CLAMP CAM	1
2	10073677	连杆	STEPPING CLAMP CON. ROD	1
3	10073678	垫圈	WASHER	1
4	10003597	6805VV轴承	BALL BEARING, 6805VV	1
5	10005300	M6×0.75×8螺钉	SCREW M6X0.75X8	2
6	10072210	M4×6螺钉	SCREW M4X6	2
7	10064435	滚轮轴	ROLLER SHAFT STEPPING CLAMP ROLLER	1
8	10064436	滚轮	STEPPING CLAMP	1
9	10073682	垫圈	WASHER	2
10	10003084	M6螺母	NUT 1 M6	1
11	10073707	压臂R	STEPPING CLAMP ARM R	1
12	10000865	惰轮组件调节螺钉	SCREW	1
13	10070516	压脚行程调节套	BUSH STEPPING CLAMP	2
14	10064395	压脚连杆安装座	MOUNTING BASE	1
15	10047852	螺钉	SCREW	4
16	10064394	中压脚摆动臂	STEPPING CLAMP ARM	1
17	10064396	间歇连杆A	STEPPING CLAMP LINK A	1
18	10027311	螺钉	SCREW	2
19	10064445	间歇连杆	STEPPING CLAMP LINK	1
20	10064443	轴位螺钉6	SHOULDER SCREW 6	2
21	10064402	中压脚提升连杆	STEPPING CLAMP LINK	1
22	10068778	摆动连杆	STEPPING CLAMP LIFTER LINK	1
23	10064446	连杆轴	SHAFT STEPPING CLAMP LIFT LINK	2
24	10011232	M6×6螺钉	SCREW M6×6	4
25	10064403	压杆导架	PRESSER BAR CLAMP	1
26	10012014	M5×4螺钉	SCREW M5×4	2
27	10027299	螺钉	SCREW	1
28	10068781	提升长连杆	CONNECTING ROD	1
29	10030834	螺钉	SCREW	1
30	10068779	电机提升曲柄	CRANK	1
33	10064455	调节螺栓M14	PRESSER ADJUSTING SCREW, M14 ADJUST	1
34	10064456	调节螺母M14	SCREW NUT, M14	1
35	10064457	弹簧	PRESSER BAR SPRING	1
36	10064458	弹簧导向	PRESSER BAR SPRING GUIDE	1
37	10064459	弹簧管套	COLLAR PRESSER BAR SPRING	1
38	10027306	压杆轴套	PRESSER BAR BUSH	1
40	10077586	压杆	PRESSER BAR	1
41	10030536	中压脚	PRESSER FOOT	1
42	10010650	SM9/64"×40螺钉	SCREW SM9/64"×40	1
43	10068824	中压脚步进电机	MEDIUM VOLTAGE STEPPING MOTOR	1
44	20026703	中压脚电机座	MOTOR BASE	1
45	10009103	M4×16螺钉	SCREW M4×16	4
46	10000157	M5×18.5螺钉	SCREW M5×18.5	3
47	10068787	中压脚电机后罩	MOTOR REAR COVER	1
48	10012892	M4×9.5螺钉	SCREW M4×9.5	5
49	10068786	中压脚电机前罩压	MOTOR FRONT COVER	1
50	10073680	脚凸轮连杆组件	PRESSER FOOT CAM LINKAGE ASM	1

6. WIPER MECHANISM COMPONENTS

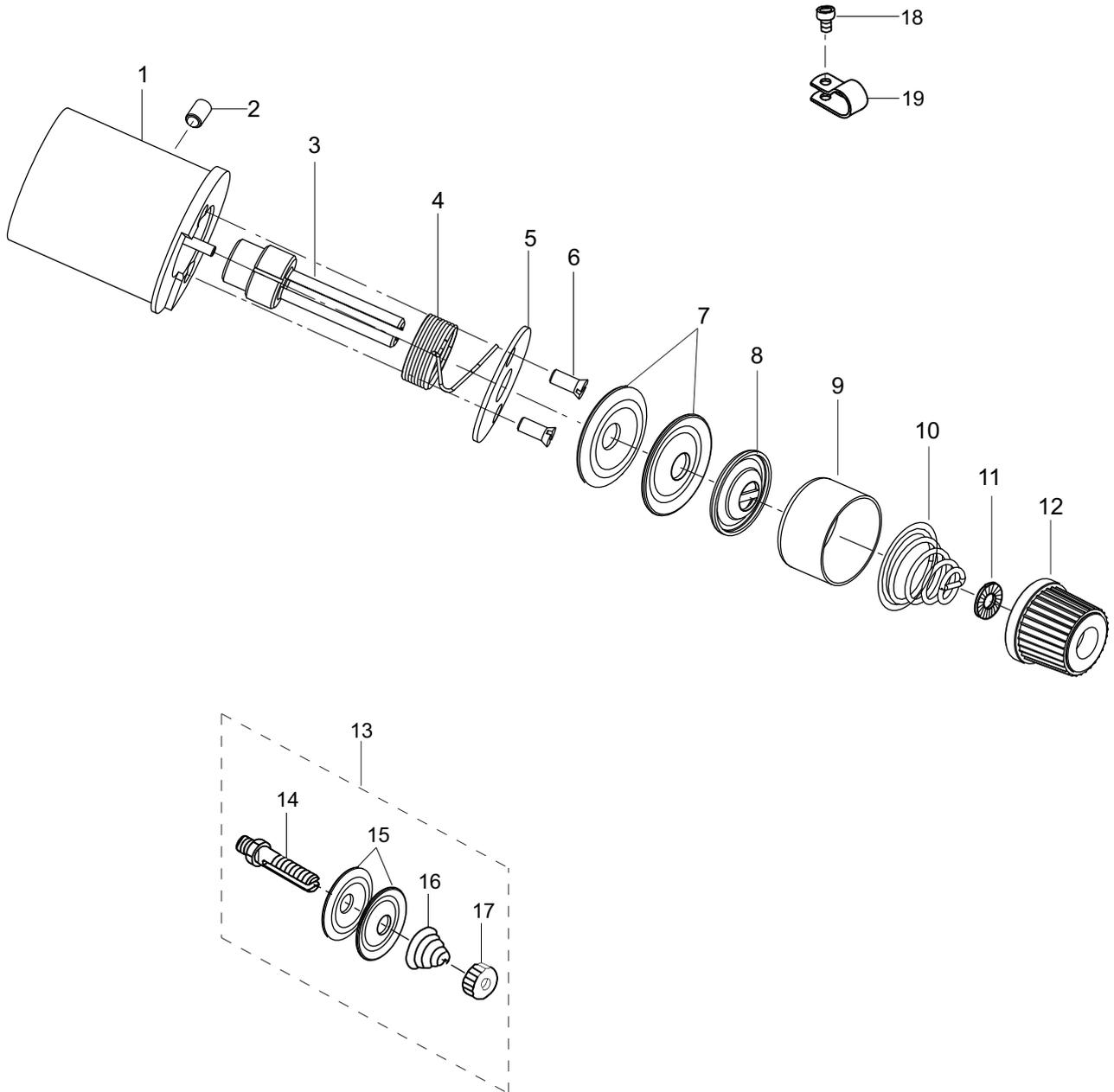
扫线部件



6. WIPER MECHANISM COMPONENTS

序号 Ref. No.	件号 Part No.	名 称	Description	数量 QTY
1	10068788	左罩壳	LEFT COVER	1
2	10028708	急停开关	EMERGENCY STOP SWITCH	1
3	10011142	SM11/64"×40螺钉	SCREW SM11/64"×40	2
4	10068309	0605拨线电磁铁组件	ELECTROMAGNET ASM	1
5	10013976	SM11/64"×40螺钉	SCREW SM11/64"×40	1
6	10005724	拨线器罩	THREAD FEEDER COVER	1
7	10003017	3垫圈	WASHER 3	1
8	10003036	M3×6螺钉	SCREW M3×6	1
9	10068121	扫线摆动支板	SWINGING SUPPORT PLATE	1
10	10027975	螺钉	SCREW	1
11	10042540	M5×3.8螺母	NUT M5×3.8	1
12	10000245	SM3/16"×32螺钉	SCREW SM3/16"×32	1
13	10068120	扫线中间连杆	CONNECTING ROD	1
14	10012181	SM3/16"×32螺钉	SCREW SM3/16"×32	2
15	10068118	扫线连接板	CONNECTING PLATE	1
17	10068784	扫线板1	SWEEPING BOARD	1
18	10011142	SM11/64"×40螺钉	SCREW SM11/64"×40	1
19	10068783	扫线固定架1	FIXED FRAME	1
20	10004593	SM3/16"×28螺钉	SCREW SM3/16"×28	1
21	10037421	下过线板	WIRE PASSING PLATE	1
22	10042310	下过线板螺钉	SCREW	2
23	10068777	扫线电磁铁支撑板	SUPPORT PLATE	1
24	10047852	螺钉	SCREW	2
25	10042268	螺钉	SCREW M4×8	1
26	10069943	拨线连杆限位块	STOP BLOCK	1
27	10000863	M4×12螺钉	SCREW M4×12	1

7. THREAD TENSION COMPONENTS 松线部件

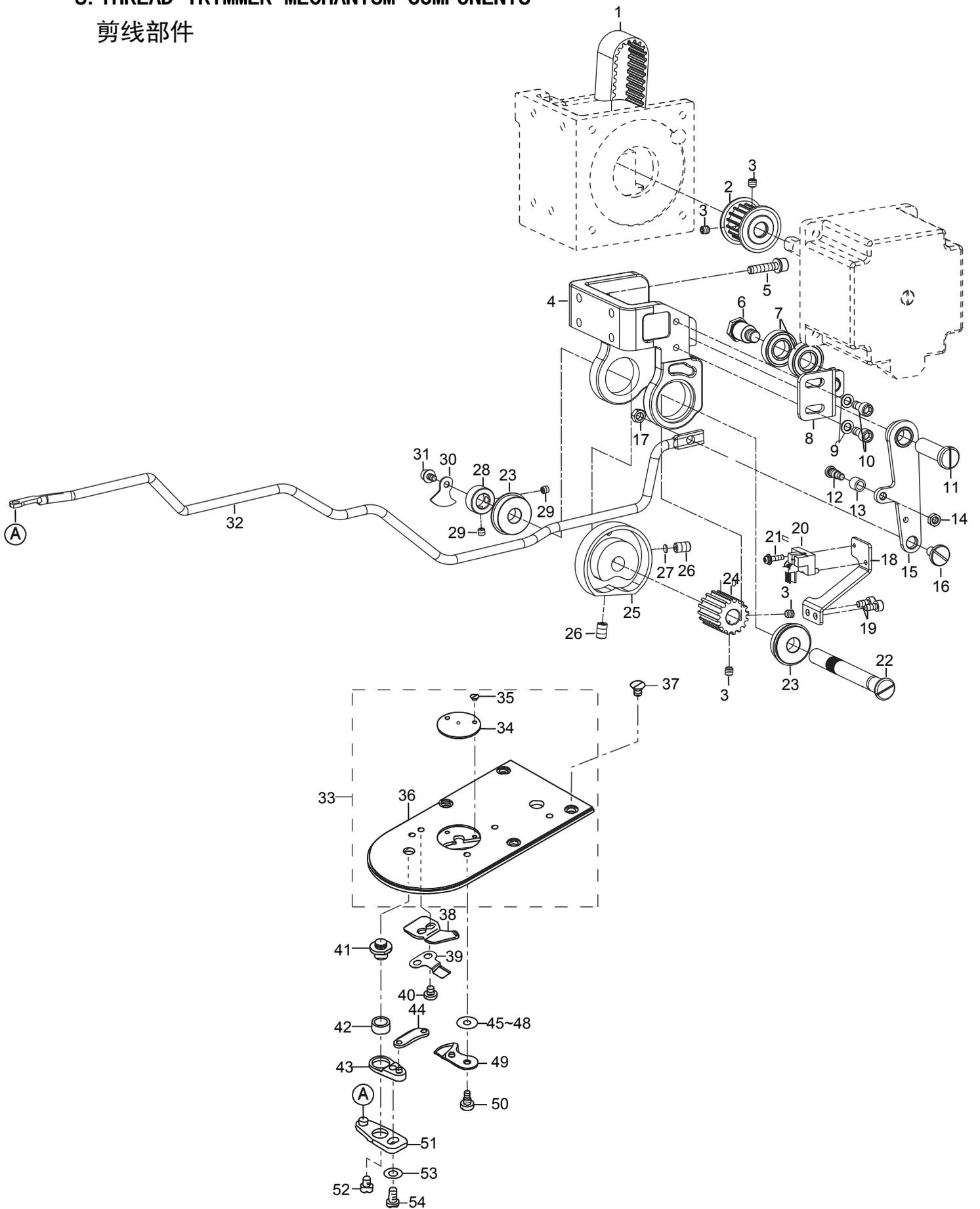


7. 松线部件THREAD TENSION COMPONENTS

序号 Ref. No.	件号 Part No.	名 称	Description	数量 QTY
1	10056036	电磁铁组件	THREAD TENSION ELECTROMAGNET	1
2	10026903	螺钉	SCREW	1
3	10042941	夹线螺钉	SCREW	1
4	10039203	弹簧	SPRING	1
5	10037243	锁紧块	LOCK PLATE	1
6	10052062	螺钉	SCREW	2
7	10005489	过线板	THREAD TENSION DISK	2
8	10004625	松线板	THREAD TENSION DISK PRESSER	1
9	10004598	夹线簧座	TENSION NUT	1
10	10004626	弹簧	SPRING	1
11	10004633	夹线制动板	ROTATING STOPPER	1
12	10062660	夹线螺母组件	THREAD TENSION NUT	1
13	10011493	夹线组件	FIRST THREAD TENSION ASM	1
14	10004666	螺钉	SCREW	1
15	10004393	夹线板	THREAD TENSION DISK	2
16	10004669	弹簧	SPRING	1
17	10004664	夹线螺母	TENSION NUT	1
18	10010685	螺钉	SCREW	2
19	10008228	SN-3A夹头	CABLE CLIP	3

8. THREAD TRIMMER MECHANISM COMPONENTS

剪线部件



8. 剪线部件THREAD TRIMMER MECHANISM COMPONENTS

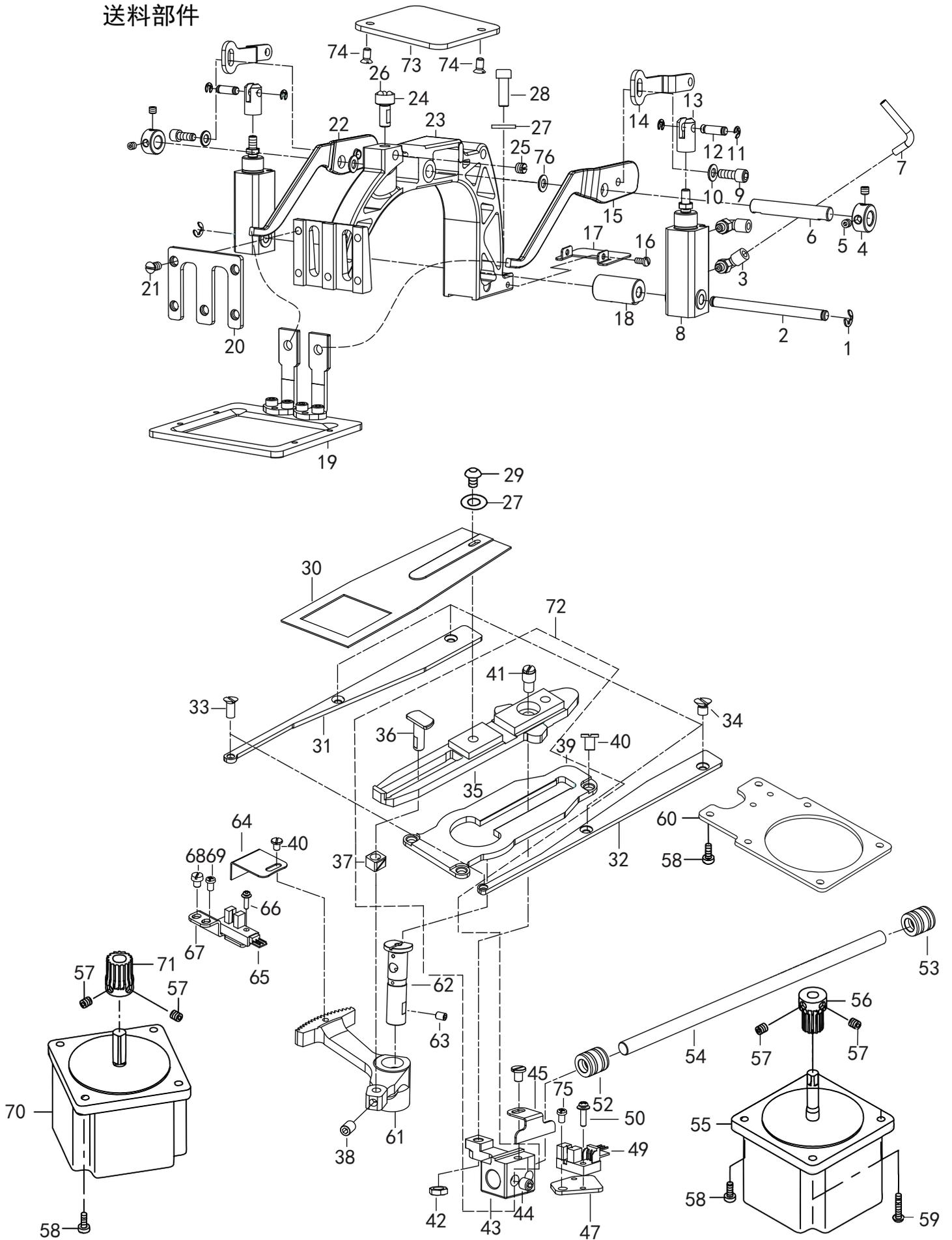
序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
1	10062809	剪线同步带	TRIMMING TIMING BELT	1
2	10062811	剪线主动带轮	ACTIVE SYNCHRONOUS PULLEY	1
3	10012162	螺钉 M5×5	SCREW M5×5	4
4	10062813	同步带轮安装座	SYNCHRONOUS PULLEY BASE	1
5	10000157	螺钉组件 M5×21	SCREW M5×21	4
6	10037642	销	SHOULDER SCREW	1
7	10026221	轴承	BEARING	2
8	10062816	带轮支紧调节板	TENSION PLATE	1
9	10006115	垫圈	WASHER	2
10	10014210	M5×12螺钉	SCREW M5×1	2
11	10027364	销	PIN	1
12	10014342	销	PIN	1
13	10034929	销套	NEEDLE CAM ROLLER	1
14	10010370	SM11/64"×40螺母	NUT SM11/64"×40	1
15	10014339	剪线曲柄	CRANK	1
16	10027367	M5螺钉	SCREW M5	1
17	10042540	螺母	NUT	1
18	10062817	剪线安全传感器座	THE SENSOR MOUNTING PLATE	1
19	10042268	螺钉	SCREW M4×8	2
20	10069195	传感器_带卡扣	PHOTO SENSOR	1
21	10010667	传感器螺钉组件	SCREW COMPONENTS	1
22	10062812	剪线凸轮轴	AXIS	1
23	10050516	轴承_6000NR-2RS_BOM	BEARING_6000NR-2RS_BOM	2
24	10062810	剪线驱动轴带轮	BELT PULLEY	1
25	10065660	剪线凸轮	TRIMMING CAM	1
26	10046048	螺钉	SCREW SM1/4"×40 L=10	2
27	10023739	剪线凸轮垫	GASKET	1
28	10010803	挡圈	RETAINING COLLAR	1
29	10013590	SM11/64"×40螺钉	SCREW SM11/64"×40	2
30	10062815	安全开关感应片	SENSOR SHEET	1
31	10003875	螺钉	SCREW ASM	1
32	10069767	0605剪线拉杆	CONNECTION BAR	1
33	10068766	针板组件	NEEDLE PATE ASM	1
34	10047532	小针板	NEEDLE HOLE GUIDE	1
35	10011509	螺钉	SCREW	2
36	10068767	针板	NEEDLE PLATE	1
37	10011511	螺钉	SCREW	4
38	10011501	定刀	FIXING KNIFE	1
39	10037254	底线夹线弹簧片	LOWER THREAD CLAMP SPRING	1
40	10011499	螺钉	SCREW	2
41	10011455	螺钉	SCREW	1
42	10011502	动刀杆销衬套簧	THREAD CUTTING LEVER RING	1
43	10010733	动刀曲柄分组件	THREAD CUTTER LEVER ASM	1
44	10011453	动刀连杆	MOVING KNIFE LINK	1
45	10007183	垫圈(0.5)	WASHER(0.5)	1
46	10007361	垫圈(0.6)	WASHER(0.6)	(1)
47	10007362	垫圈(0.7)	WASHER(0.7)	(1)
48	10007363	垫圈(0.8)	WASHER(0.8)	(1)

8. 剪线部件THREAD TRIMMER MECHANISM COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
49	10011513	动刀分组件	MOVING KNIFE ASM	1
50	10011500	螺钉	SCREW	1
51	10010737	动刀传动杆分组件	THREAD CUTTER LEVER ASM	1
52	10011503	螺钉	SCREW	1
53	10011506	垫圈	WASHER	1
54	10009906	螺钉	SCREW	1

9. FEED MECHANISM COMPONENTS

送料部件



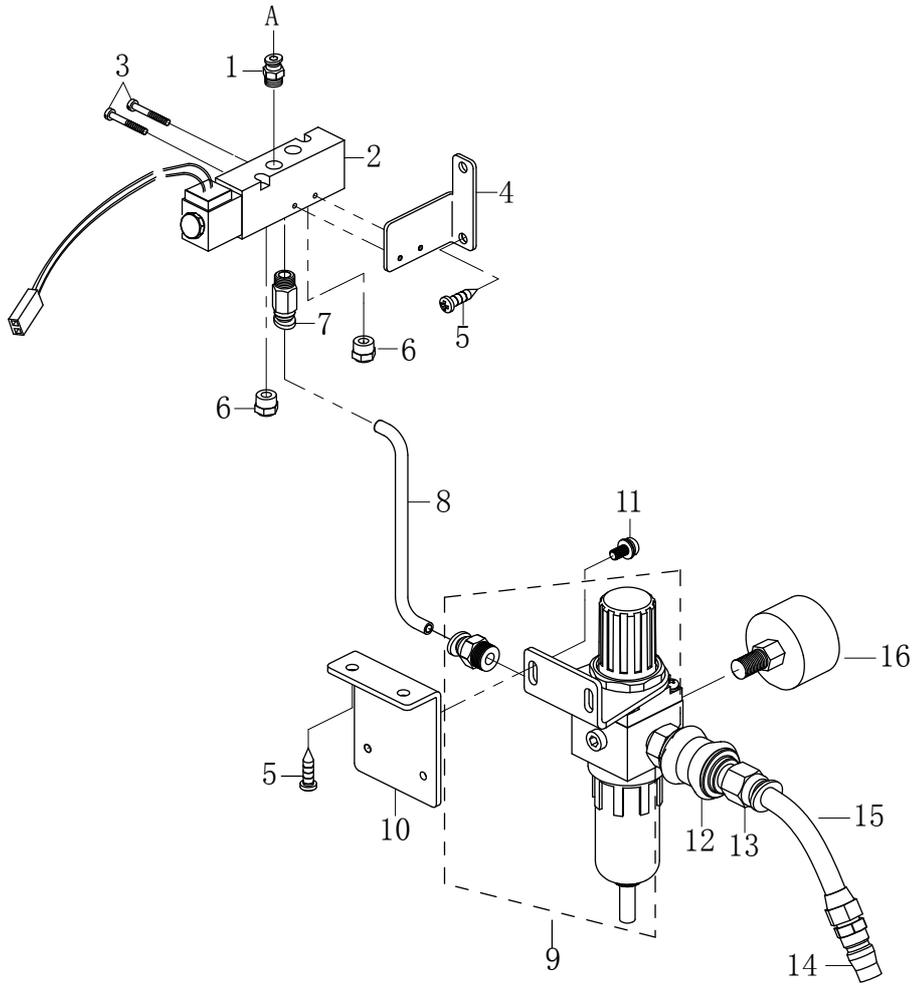
9. 送料部件FEED MECHANISM COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10009653	4挡圈	E-RING 4	2
2	10001262	6×78长销	PIN 6×78	1
3	10007681	气管接头	GAS PIPE CONNECTOR	4
4	10004600	8挡圈	RETAINING COLLAR	2
5	10013590	SM11/64"×40螺钉	SCREW SM11/64"×40	4
6	10028963	提升架	LIFTING FRAME	1
7	10008119	φ2.5×φ4气管	WINDPIPE φ2.5×φ4	2600
8	10001263	气缸组件	CYLINDER ASM	2
9	10004611	SM3/16"×28螺钉	SCREW SM3/16"×28	2
10	10010459	5×9.7×1垫圈	WASHER 5×9.7×1	2
11	10003248	3挡圈	E-RING 3	4
12	10000413	5×15.5短销	PIN 5×15.5	2
13	10001250	压料气缸接头	CONNECTOR	2
14	10064407	气缸连接板	CONNECTING PLATE	2
15	10068775	右压脚提升架	LIFTING FRAME	1
16	10002923	M3×6螺钉	SCREW M3×6	2
17	10068765	0605送料架后拖板	CARRIAGE	1
18	10064405	气缸支撑轴套	BUSHING	1
19	10068771	0605布压脚组件	PRESSER FOOT ASSEMBLY WORK CLAMP	1
20	10011557	压脚面板	FOOT FACE PLATE SCREW	1
21	10011510	SM11/64"×40螺钉	SM11/64"×40	5
22	10068774	左压脚提升架	LIFTING FRAME	1
23	10068776	0605送料架	FEEDING RACK	1
24	10011561	钢球座	STEEL BALL SEAT	1
25	10044062	螺钉	SCREW SM15/64"×28	1
26	10011574	钢球3.175	STEEL BALL 3.175	7
27	10006013	7×15×2垫圈	WASHER 7×15×2	2
28	10010735	M6×18螺钉	SCREW M6×18	1
29	10011569	M6×9螺钉	SCREW M6×9	1
30	10068764	0605送料板	FEEDING PLATE	1
31	10068762	左盖板	LEFT COVER PLATE	1
32	10068763	右盖板	RIGHT COVER PLATE	1
33	10009379	M2.5×4.8螺钉	SCREW M2.5×4.8	2
34	10011566	SM11/64"×40螺钉	SCREW SM11/64"×40	4
35	10068769	送料托架	FEEDING BRACKET	1
36	10030541	送料托架滑块轴	SLIDER SHAFT	1
37	10030540	送料托架滑块	SLIDER	1
38	10010678	SM15/64"×28螺钉	SCREW SM15/64"×28	1
39	10068770	送料托架支撑板	SUPPORT PLATE	1
40	10011142	SM11/64"×40螺钉	SCREW SM11/64"×40	5
41	10011568	Y向轴夹头铰轴	COLLET SHAFT	1
42	10010725	SM15/64"×28螺母	NUT SM15/64"×28	1
43	10030539	Y向驱动轴夹头	COLLET	1
44	10011642	SM1/4"×40螺钉Y	SCREW SM1/4"×40	2
45	10069433	向感应片	INDUCTION SHEET	1
47	10011572	Y轴传感器固定架	FIXED FRAME	1
49	10069195	传感器_带卡扣传	SENSOR	1
50	10010667	感器螺钉组件	SCREW ASM	1

9. 送料部件FEED MECHANISM COMPONENTS

序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
52	10024078	轴套	BUSHING	1
53	10011571	轴套	BUSHING	1
54	10014326	Y向驱动轴	DRIVE SHAFT	1
55	10069826	Y轴步进电机(六代)	Y FEED STEPPING MOTOR	1
56	10011640	齿轮	GEAR	1
57	10011232	M6×6螺钉	SCREW M6×6	4
58	10011644	M5×13螺钉M5×18.5	SCREW M5×13	8
59	10000157	螺钉	SCREW M5×18.5	2
60	10052686	Y轴电机垫板	BASE PLATE	1
61	10069842	0605杆杠齿轮	GEAR	1
62	10068789	X向铰轴	X-SHAFT	1
63	10010678	SM15/64"×28螺钉X	SCREW SM15/64"×28	1
64	10011517	向传感片	X-SENSOR PIECE	1
65	10069821	X传感器_带卡扣螺钉	X-SENSOR	1
66	10011199	组件M4×10	SCREW ASM	1
67	10011592	X轴传感器固定架	FIXED FRAME	1
68	10002957	M5×6螺钉	SCREW M5×6	1
69	10046049	SM11/64"×40螺钉	SCREW SM11/64"×40	1
70	10069825	X轴步进电机(六代)	X FEED STEPPING MOTOR	1
71	10011638	齿轮	GEAR	1
72	10068768	送料托架组件	FEEDING BRACKET ASM	1
73	10068759	送料架支撑板	SUPPORT PLATE	1
74	10011559	SM11/64"×40螺钉	SCREW SM11/64"×40	2
75	10046049	SM11/64"×40螺钉	SCREW SM11/64"×40	1
76	10014394	8.2×15×1垫圈	WASHER 8.2×15×1	2

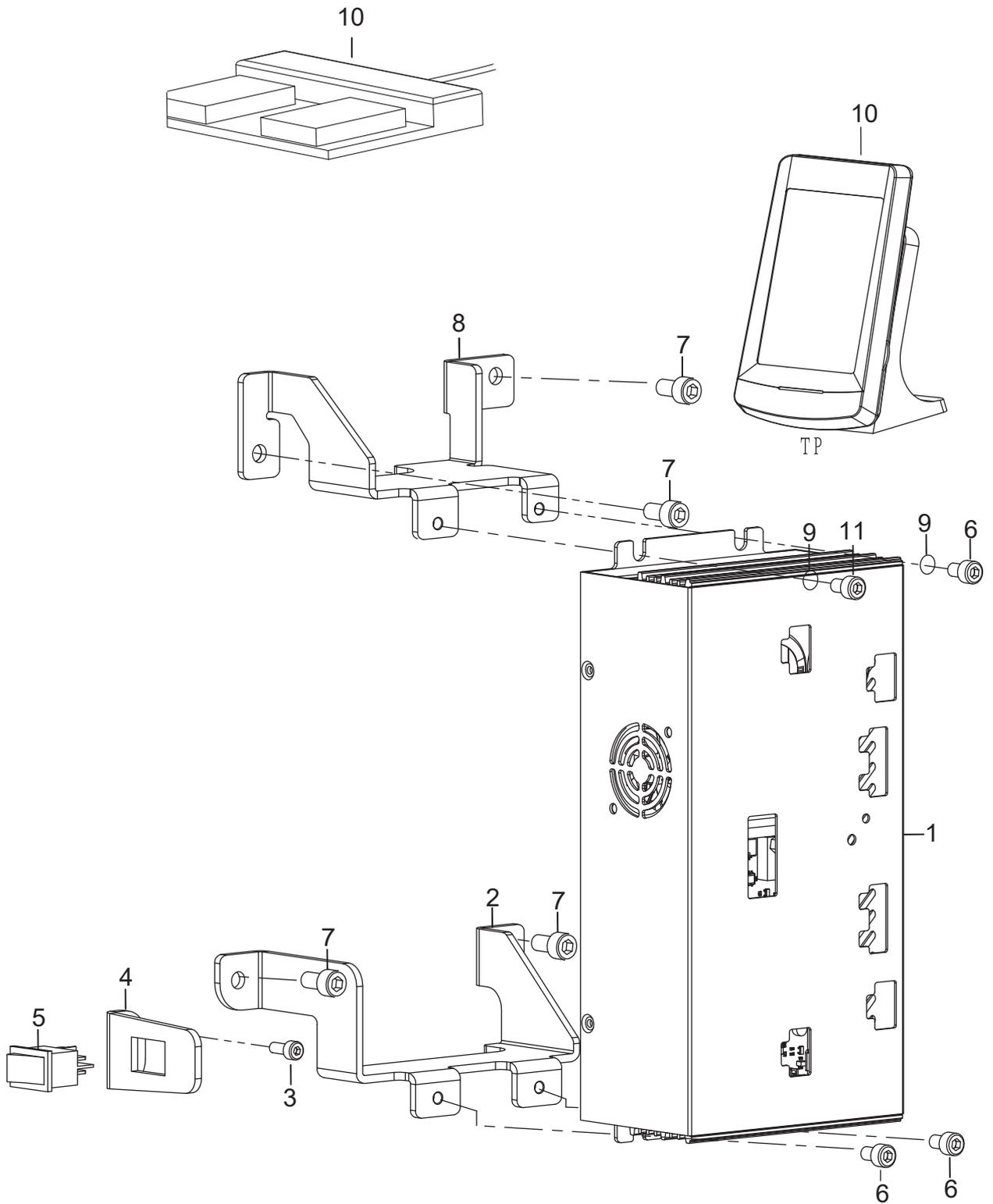
10. PNEUMATIC COMPONENTS
气动部件



10. 气动部件 PNEUMATIC COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10023253	快速接头 $\phi 4 \times R1/8$	HALF UNION $\phi 4 \times R1/8$	2
2	10007696	电磁阀	PORT SOLENOID VALVE	1
3	10002148	气阀安装螺钉 M3 L=25	SCREW M3 L=25	2
4	10007583	气阀安装板	SOLENOID_VALVE_FITTING_BASE	1
5	10026825	十字槽圆头木螺钉	SCREW	4
6	10001548	消声器	MUFFLER	2
7	10003724	快速接头 $\phi 6 \times R1/8$	HALF UNION $\phi 6 \times R1/8$	1
8	10008150	气管 $\phi 4 \times \phi 6$	TUBE $\phi 4 \times \phi 6$	1
9	10061784	过滤减压阀组件	FILTER REGULATOR ASM	1
10	10001107	固定板	FILTER_INSTALLING_PLATE	1
11	10003883	螺钉 M5 L=10	SCREW M5 L=10	2
12	10007534	手滑阀	HAND SLIDE VALVE	1
13	10003458	快速接头 $\phi 10 \times R1/4$	HALF UNION $\phi 10 \times R1/4$	1
14	10024399	接头 $\phi 10 \times R1/4$	PLUG $\phi 10 \times R1/4$	1
15	10008151	气管 $\phi 8 \times \phi 10$	TUBE $\phi 8 \times \phi 10$	1
16	10027968	压力表	AIR PRESSURE SWITCH	1

11. ELECTRONIC CONTROL SYSTEM COMPONENTS (-04)
电控部件 (-04)

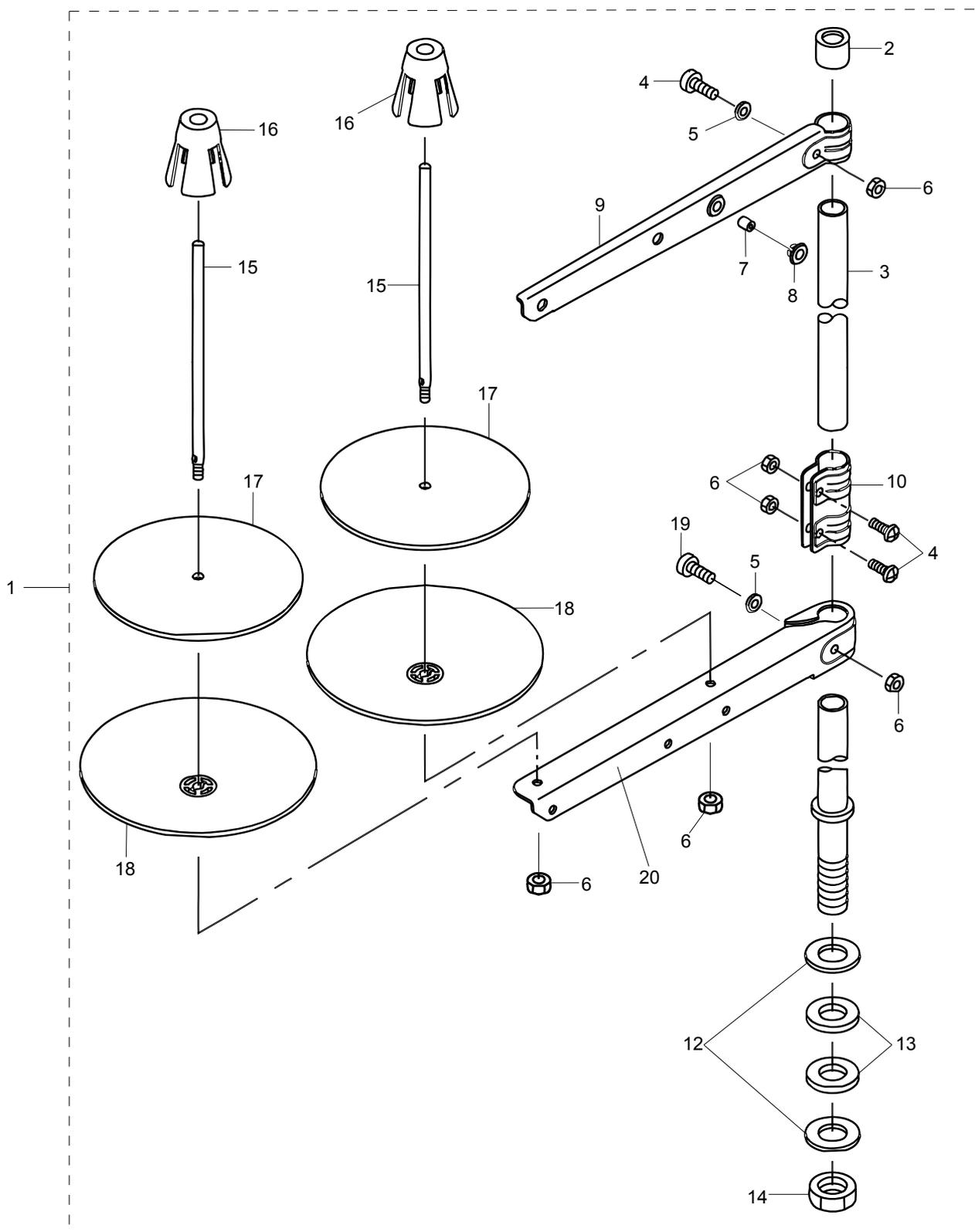


11. 自动控制部件ELECTRONIC CONTROL SYSTEM COMPONENTS (-04)

序号 Ref. No.	件号 Part No.	名称	Description	数量 QTY
1	10068822	大豪触屏电控组件	ELECTRONIC CONTROL SYSTEM ASM	1
2	10057430	电控下支撑板	CONTROL BOX INSTALLING BASE DOWN	1
3	10005041	螺钉 M4×10	SCREW M4×10	2
4	10057431	电源开关安装座	POWER SWITCH INSTALLING BASE	1
5	10057914	船形电源开关	POWER SWITCH	1
6	10012028	螺钉 M5×8	SCREW M5×8	3
7	10011824	螺钉 M6×12	SCREW M6×12	4
8	10057429	电控上支撑板	CONTROL BOX INSTALLING BASE UP	1
9	10011820	φ 5.2× φ 10.3×1垫圈	WASHER φ 5.2× φ 10.3×1	2
10	10068821	大豪触摸屏	OPERATION PANEL	1
11	10005539	M5×6螺钉	SCREW	1

12. THREAD STAND COMPONENTS

线架部件

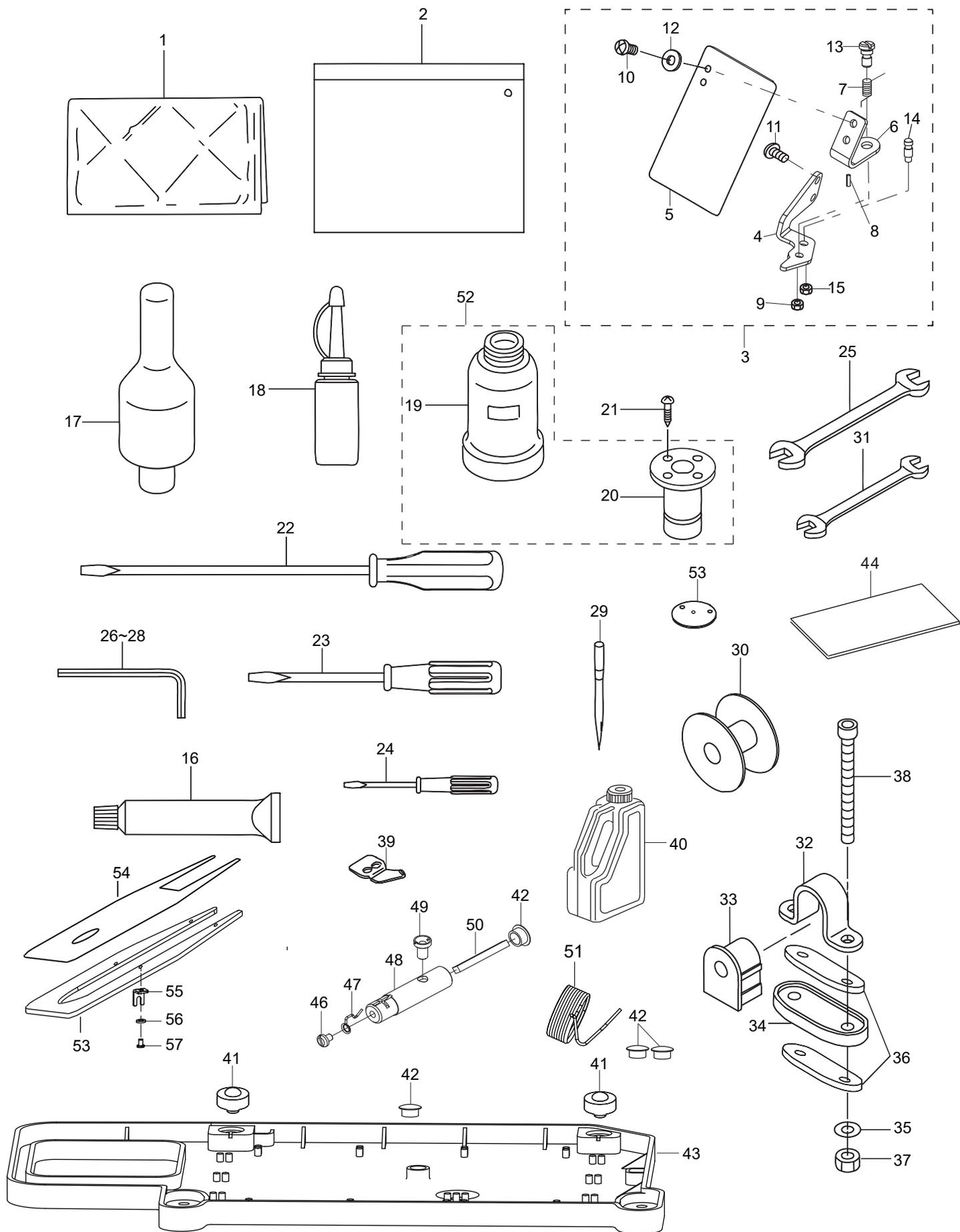


12. 线架部件 THREAD STAND COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10007130	二线架组件	THREAD STAND ASM	1
2	10004282	撑管套	COLUMN CAP	1
3	10004293	线架上撑管	COLUMN PIPE	1
4	10003301	上过线架螺钉	SCREW	2
5	10003022	上过线架垫圈	WASHER	2
6	10002953	上过线架螺母	NUT	5
7	10004289	过线管	THREAD GUIDE PIPE	2
8	10004285	过线管套	THREAD GUIDE BUSHING	2
9	10004298	上过线架	THREAD HANGER	1
10	10004286	撑管夹	COLUMN PIPE CONNECTOR	1
11	10004291	线架下撑管	COLUMN PIPE	1
12	10004295	线架下撑管垫圈	WASHER	2
13	10004290	垫圈	WASHER	2
14	10002985	下过线架螺母	NUT	1
15	10004288	线轴	SPOOL PIN	2
16	10004287	线盘塑料压块	SPOOL CUSHION	2
17	10004281	线盘软垫	SOFT CUSHION OF THREAD PLARE	2
18	10004299	线盘	THREAD PLATE	2
19	10003312	下过线架螺钉	SCREW	1
20	10004292	下过线架	THREAD HANGER	1

13. ACCESSORIES PART COMPONENTS

附件



13. 附件ACCESSORIE PART COMPONENTS

序号 Ref. No.	件号 Part No.	名 称	Description	数量 QTY
1	10001177	中捷机头罩	VINYL COVER	1
2	10004971	机头薄膜袋	ACCESSORY BOX	1
3	20004358	眼睛防护罩组件	SAFETY PLATE ASM.	1
4	10011632	安全板座	SAFETY PLATE INSTALLING BASE	1
5	10011636	安全板	SAFETY PLATE	1
6	10004725	安全板架	SAFETY PLATE INSTALLING PLATE	1
7	10011678	弹簧	SPRING	1
8	10002880	销	PIN	1
9	10010370	螺母	NUT	1
10	10046049	螺钉	SCREW	2
11	10046049	螺钉	SCREW	2
12	10011680	垫圈	WASHER	2
13	10011677	螺钉轴	HINGE SCREW	1
14	10011633	销	PIN	1
15	10011682	螺母	NUT	1
16	20009052	油脂软膏	GREASE	1
17	10011749	机头支承杆	HEAD SUPPORT BAR	1
18	10005356	油壶	OILER	1
19	10011681	油杯	OIL CAN	1
20	10011683	油杯座	OIL MANAGEMENT	1
21	10008197	螺钉	SCREW	6
22	10010994	大螺丝刀	SCREW DRIVER LARGE	1
23	10010995	中螺丝刀	SCREW DRIVER MIDDLE	1
24	10013185	小螺丝刀	SCREW DRIVER SMALL	1
25	10003368	呆板手	WRENCH	1
26	10009685	内六角扳手3	HEXAGONAL WRENCH SMALL	1
27	10009687	内六角扳手4	HEXAGONAL WRENCH LARGE	1
28	10009689	内六角扳手5	HEXAGONAL SPANNER	1
29	10023286	机针	NEEDLE	4
30	10004592	梭芯	BOBBIN	1
31	10003369	呆板手	WRENCH	1
32	10011160	支撑固定架	BED HINGE	2
33	10011137	机头胶垫	HINGE RUBBER	2
34	10014251	机头胶垫底座	BED HINGE RUBBER	2
35	10003076	垫圈	WASHER	4
36	10011747	垫片	WASHER	4
37	10003084	螺母	NUT	4
38	10011147	螺栓	SCREW	4
39	10011501	定刀	FIXING KNIFE	1
40	10004455	油箱	OIL BOX	1
41	10040431	机头座垫	SUPPORT RUBBER	2
42	10011136	橡胶塞	RUBBER PLUG	4
43	10062667	油盘	OIL TRAY	1
44	10068978	0605使用说明书及零件手册	INSTRUCTIONS	1
45	10011142	螺钉 SM11/64"×40 L=6	SCREW SM11/64"×40 L=6	1
46	10011918	硅油盒过线架	THREAD GUIDE SPRING	1
47	10011920	硅油盒	SOLICONE OIL BOX	1
48	10011917	螺钉 SM15/64"×40	SCREW SM15/64"×28	1
49	10011919	毛毡	OIL FELT	1
50	10039203	挑线簧	SPRING	1
51	10006185	油杯组件	OILER ASM	1
52	10004646	小针板 (φ 1.6)	NEEDLE HOLE GUIDE	1
53	10030551	压脚托板	BRACKET	1
54	10069838	0605压脚托板保护膜	PROTECTION FILM	1
55	10030552	压脚托板座	BRACKET SEAT	4
56	10010741	5.2×10×1.5垫圈	WASHER 5.2×10×1.5	4
57	10011142	SM11/64"×40螺钉	SCREW SM11/64"×40	4

在使用缝纫机之前请阅读本使用说明书。
请将本使用说明书放在便于查阅的地方保管。



高速电子套结一体机 ZJ1900D-V4 ZJ1903D-V4
COMPUTER-CONTROLLED HIGH SPEED LOCKSTITCH BAR
TACKING MACHINE SERIES

使用说明书

OPERATION MANUAL

零件手册

PARTS BOOK



手机官网



官方订阅号

浙江中捷缝纫科技有限公司
ZOJE SEWING MACHINE CO.,LTD

使用说明书

OPERATION MANUAL

为了创造更加美好的环境

请您协作

首先对您使用我们产品表示衷心的感谢！

我们公司致力于关爱地球环境，制定了“智能制造、绿色制造”的基本方针。当地的公民在环境保护活动中也应该对当地社会、环境二方面尽每个人的微薄之力。

因此，希望您能配合这个计划，作为环境保护活动的一环，在平时处理废弃物的时候能多加注意。

- 1.不用的包装材料，为了能再次回收利用，请交付给当地相关回收公司进行处理。
- 2.使用完的润滑油、请根据相关的法律和规定进行妥善处理。
- 3.产品保养或修理需要更换零部件时，有不需要的电路板和电子零件，以及产品废弃时，请作为电子废弃物处理。

非常感谢您购买我们业缝纫机。
在使用缝纫机之前，请仔细阅读<为了您的安全使用>和使用说明。
工业缝纫机的特性之一，因为要在机针和旋梭等运动零部件附近进行操作，而这些零部件很容易引起受伤的危险，所以请在受过培训的人或熟练人员的安全操作知识的指导下，正确地使用本缝纫机。

为了您的安全使用

[1] 安全使用的标记及其意义

本使用说明书及产品所使用的标记和图案记号是为了您的安全而正确地使用产品，防止您及他人受到危害和损害。

表示方法及含意如下。

标记

 危险	该内容表示如果忽视此标志而进行错误的操作，必将导致死亡或重伤。
 警告	该内容表示如果忽视此标志而进行错误的操作，肯定会引起死亡或重伤。
 注意	如果忽视此标志而进行错误的操作，有可能会引起受到轻微或中度伤害。

图案和符号



…………… 该符号（△）表示“应注意事项”。
三角中的图案表示必须要注意的实质内容。
（例如，左边的内容表示“当心受伤”。）



…………… 该符号（⊘）表示“禁止”。



…………… 该符号（●）表示“必须”。

[2] 安全注意事项



危险



在关闭电源开关并将电源插头从插座上拔下后，至少等待 5 分钟，再打开控制箱盖。触摸带有高压的区域将会造成人员伤亡。



警告



缝纫机内不允许进入任何液体，否则会引起火灾，电击或操作故障。

如果缝纫机内（机头或控制箱）进入任何液体，请立即关闭电源，并将电源插座头从插座上拔出，然后联系销售商或资深技术人员。



注意

使用环境



请不要在有电源线干扰及静电干扰等有强电气干扰源影响的环境下使用。

强电气干扰源可能会影响缝纫机正确操作。



电源电压的波动应该在额定电压的±10%以内的环境下使用。

电压大幅度的波动会影响缝纫机正确操作。



电源容量应大于缝纫机的消耗电量。电源容量不足会影响缝纫机的正确操作。



环境温度应在 5℃-35℃ 的范围内使用。

低温或者高温会影响缝纫机的正确操作。



相对湿度应在 45%-85% 的范围内，并且设备内不会结露的环境下使用。干燥或多湿的环境和结露会影响缝纫机的正确操作。



万一发生雷电暴风雨时，关闭电源开关，并将电源插头从插座上拔下。雷电可能会影响缝纫机的正确操作。



请勿将 USB 存储器以为的设备连接到 USB 连接端口上，否则有可能导致故障。

安装



请让受过培训的技术人员来安装缝纫机。



请委托购买商店或电气专业人员进行电气配线。



缝纫机重约 58kg，安装人员必须有两人以上来完成。



在安装完成前，请不要连接电源，如果误踩下脚踏板时，缝纫机动作会导致受伤。



请在切断电源后，在拔掉电插头。不然容易成为控制箱发生故障的原因。



必须接地。



接触地线不牢固，是造成触电误动作原因。



固定电缆时，不要过度弯曲电缆或用卡钉固定得过紧，会引起火灾或触电的危险。



如果使用带小脚轮的工作台，则应该固定小脚轮，使其不能移动。



缝纫机头倒下时，请一定要固定工作台，不可使其随意移动。



工作台移动易发生脚等被夹住之事故，是导致人身事故的原因。



缝纫机头倒下或竖起时，请用双手操作。

单手操作时因缝纫机的重量万一滑落易导致受伤。



使用润滑油和黄油时，务必戴好保护眼镜和保护手套等，以防润滑油落入眼中或沾在皮肤上，这是引起发炎的原因。

另外，润滑油或黄油不能饮用，否则会引起呕吐和腹泻。

将油放在小孩拿不到的地方。



注意

缝纫



本缝纫机仅限于接受过安全操作培训的人员使用



本缝纫机不能用于除缝纫外的任何其他用途。



使用缝纫机时必须戴上保护眼镜。

如果不戴保护眼镜，断针时就会有危险，机针的折断部分可能会弹入眼镜并造成伤害。



发生下列情况时，请切断电源。

否则误按开关缝纫机动作会导致受伤。

- 机针穿线时
- 更换机针或梭芯时
- 缝纫机不使用，或人离开缝纫机时



如果使用带小脚轮的工作台，则应该固定小脚轮，使其不能移动。



为了安全起见，在使用本缝纫机之前，请安装保护装置。如果未安装这些安全装置就使用缝纫机，会造成人身伤害及缝纫机损坏。



缝纫过程中，不要触摸任何运动部件或物件靠在运动部件上，因为这会导致人员受伤或缝纫机损坏。



缝纫机头倒下时，请一定要固定工作台，不可使其随意移动。

工作台移动容易发生脚等被夹住事故，是导致人身事故的原因。



缝纫机头倒下或竖起时，请用双手操作。

单手操作时因缝纫机的重量万一滑落容易导致受伤。



如果缝纫机操作中发生误操作，或听到异常的噪音或闻到异常的气味，应立即切断电源。然后请与购买商店或受过培训的技术人员联系。



如果缝纫机出现故障，请与购买商店或受过培训的技术人员联系

清洁



在开始清洁作业前，请切断电源。

如果误按开关缝纫机动作会导致人员受伤。



缝纫机头倒下时，请一定要固定工作台，不可使其随意移动。

工作台移动易发生脚等夹住事故，是导致人身事故的原因。



缝纫机头倒下或竖起时，请用双手操作。

单手操作时因缝纫机的重量万一滑落易导致受伤。



使用润滑油和黄油时，务必戴好保护眼镜和保护手套等，以防润滑油落入眼中或沾在皮肤上，这是引起发炎的原因。

另外，润滑油或黄油不能饮用，否则会引起呕吐和腹泻。

将油放在小孩拿不到的地方。

保养和检查



只有经过训练的技术人员才能进行缝纫机的维修、保养和检查。



与电气有关的维修、保养和检验请委托购买商店或电气专业人员维修。



发生下列情况时，请关闭电源，并从电源插座上拔下插头。

否则误按开关时缝纫机会导致误伤。

- 检查、调整和维修
- 更换旋梭，切刀容易损零部件



打开马达罩盖前，务必先关闭电源，等待一分钟后，再执行操作。

触摸马达表面可能会导致烫伤。



在接上电源开关进行调整时，务必切换到保养模式，遵守所有注意事项。



缝纫机头倒下时，请一定要固定工作台，不可使其随意移动。工作台移动易发生脚等被夹，导致人员事故。



缝纫机头倒下或竖起时，请用双手操作，单手操作万一滑落容易导致受伤。

更换零件或安装可选附件时，请务必使用正品零件。否则将不承担由使用非正品零件而造成的任何事故或故障责任。



安全保护装置再次安装时，请务必安装在原位上，并检查能正常发挥作用。

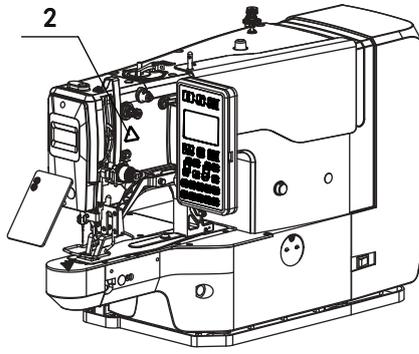
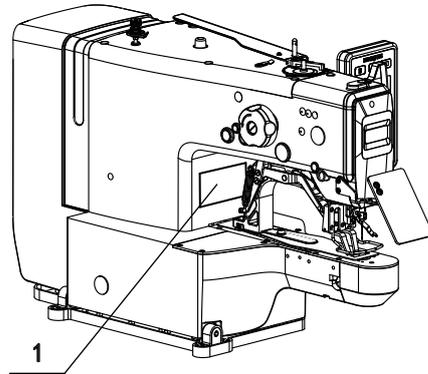
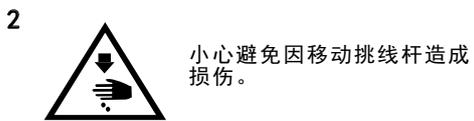


为防止发生事故及故障，请勿擅自改造本缝纫机。我们将不承担由改造缝纫机而造成的任何事故及故障责任。

[3] 警告标签

缝纫机上有下列警告标签。

当使用缝纫机时，请遵守标签上的说明。如果标签脱落或模糊不清，请和购买商店联系。



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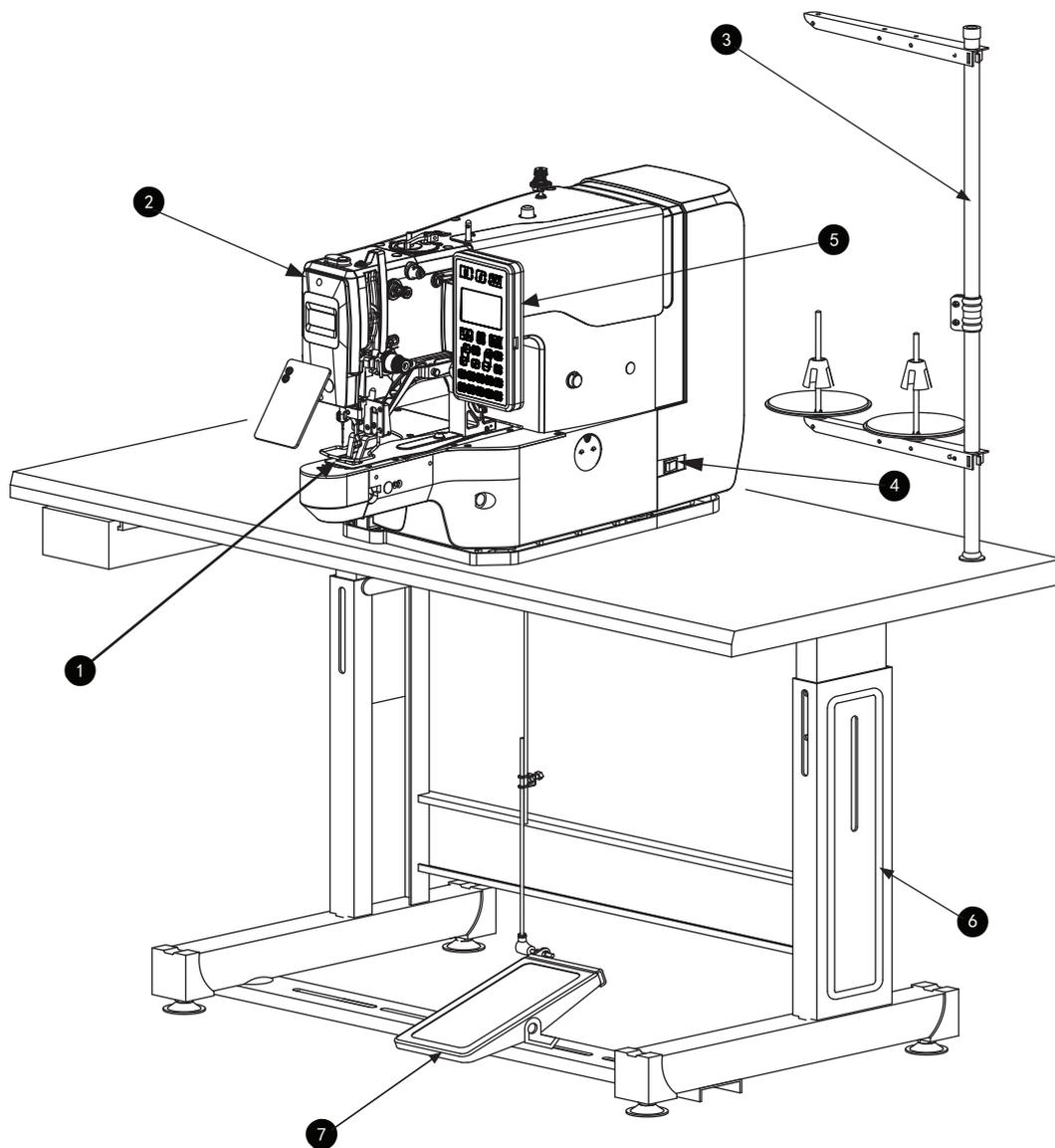
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I.一体式高速电子套结机说明

[1] 规格

1. 缝制范围：X（左右）方向 40mm，Y（前后）方向 30mm
2. 缝纫速度:3200rpm
3. 线迹长度：0.1-12.7mm
4. 压脚送布：间断送布
5. 针杆行程：41.2mm
6. 使用机针：DP×5、DP×17
7. 压脚上升量：标准 13mm 最大 17mm
8. 旋梭：标准摆梭（油线润滑）
9. 使用机油：10#白油
10. 数据记录：EPROM
11. 放大、缩小功能：X 方向、Y 方向各为 20-200%
12. 放大、缩小方式：调整线迹长短方式
13. 缝纫速度限制：400-3500，3500rpm（针距
X≤5，Y≤3.5）（100rpm）
14. 图案选择功能：图案 NO.指定（1-200）
15. 底线计数器：上升/下降方式（1-999999）
16. 缝纫机马达：550W 伺服马达
17. 外形尺寸：W: 1200mm L: 540mm H:1100mm
18. 重量：整机 57.4Kg
19. 功率：0.125KW
20. 使用温度范围：0℃-50℃
21. 使用湿度范围：35%-85%（无节露）
22. 电源电压：额定电机±10% 50-60Hz

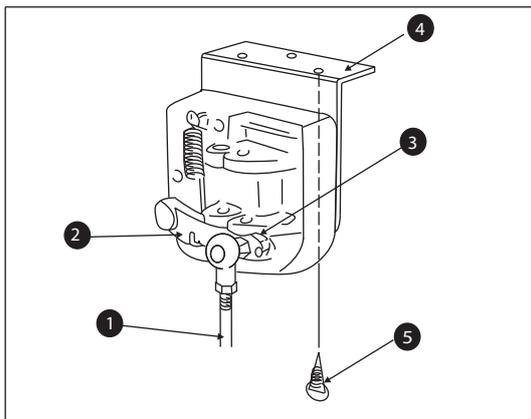
[2] 各部件名称



- (1). 送布压脚
- (2). 缝纫机机头
- (3). 线架
- (4). 电源开关
- (5). 操作面板
- (6). 机架
- (7). 脚踏开关

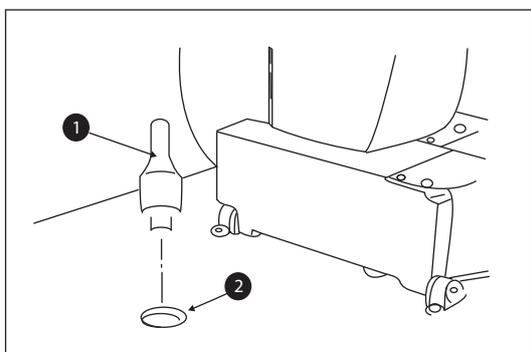
[3] 整机安装

1. 脚踏开关拉杆的安装



- (1). 将脚踏开关拉杆①穿过脚踏开关曲柄②孔，用螺母③固定，上下拉动脚踏开关拉杆①，运动灵活，调整踏板至合适位置。
- (2). 将脚踏安装板④用木螺丝⑤固定在合适的位置。

2. 机头支撑杆的安装

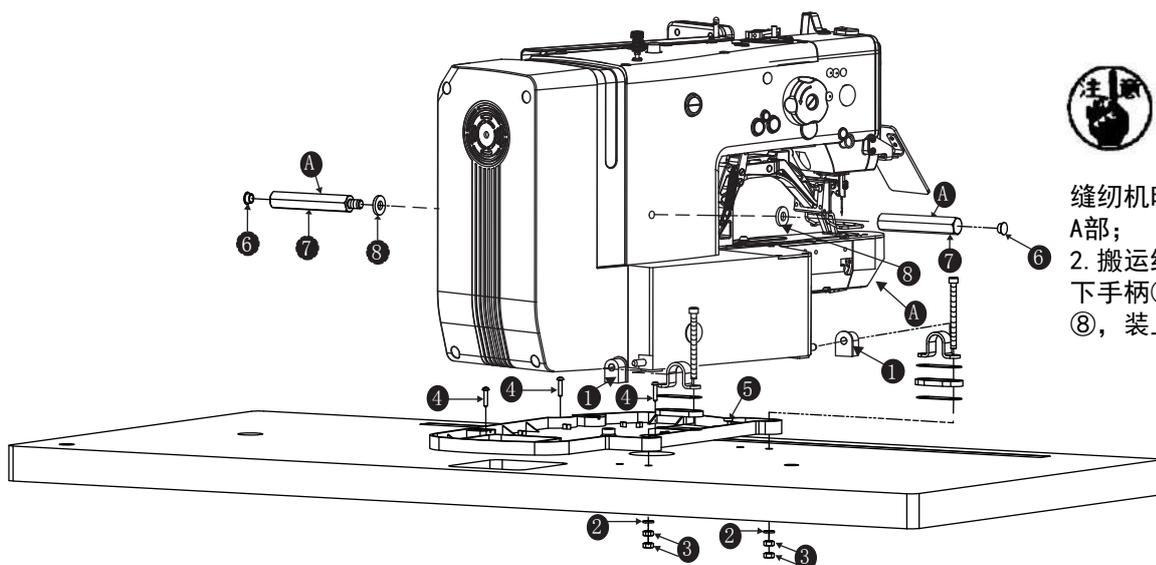


将机头支撑杆①装在台板孔②内。

3. 机头的安装



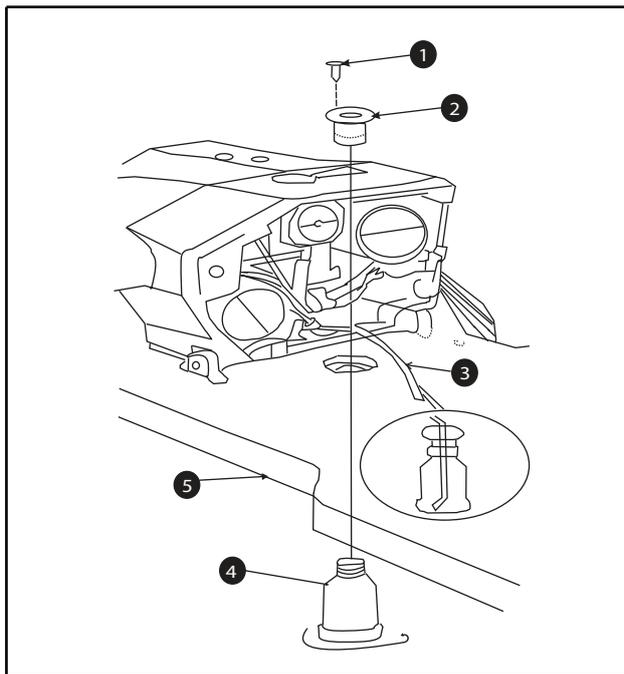
注意 搬运缝纫机时，请一定是两人以上进行操作。



1. 搬运缝纫机时，请手持A部；
2. 搬运结束，请卸下手柄⑦及橡胶垫⑧，装上橡胶塞⑥。

- (1). 将油盘⑤用木螺钉④固定在台板相应位置上；
- (2). 将机头胶垫①穿在机器支撑轴上，固定缝纫机主体；
- (3). 将平垫②、螺母③按图示依次固定，注意螺母③的锁紧力量，如果拧的太紧，防震效果不理想

4. 废油壶的安装

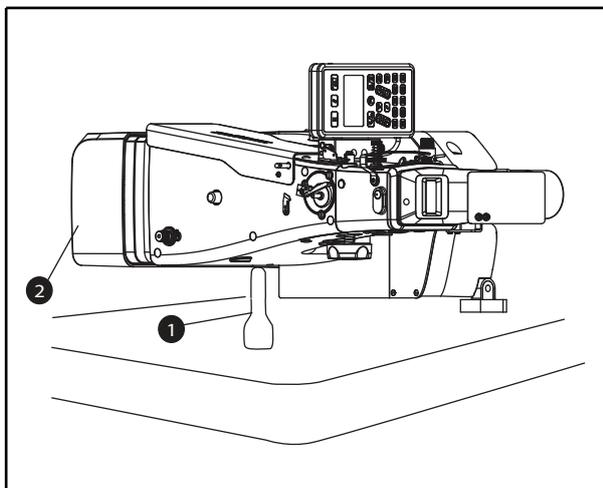


用四个木螺丝①把废油壶上节②固定到台板⑤孔内，将废油壶④从台板①下方旋进废油壶上节②中，并将机头回油管③装在废油壶中。



机头放倒后，回油管③不能从废油壶中脱落。

5. 机头的放倒

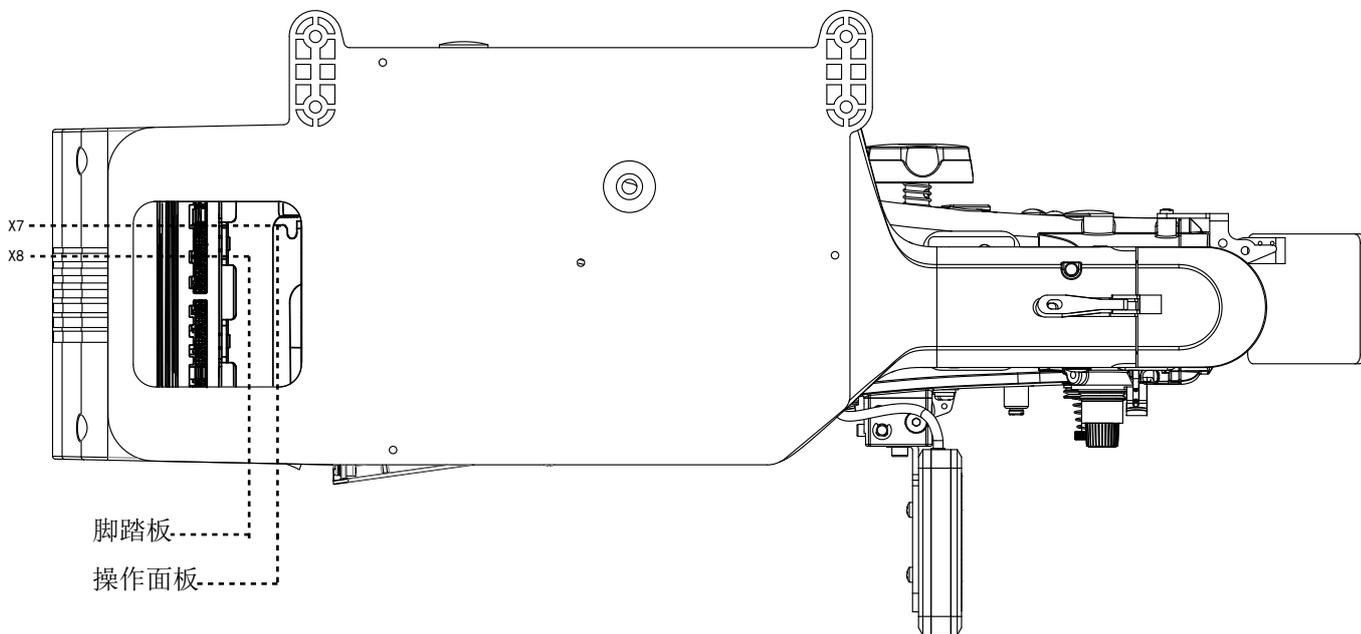


将机头②轻轻放倒，靠在机头支撑杆上①上。



1. 放倒机头前，请先确认台板上是否有机头支撑杆；
2. 抬起机头时，请不要扳机头后罩，以免后罩受损；
3. 为防止机头侧翻，请确保台板水平。

6.电线的连接

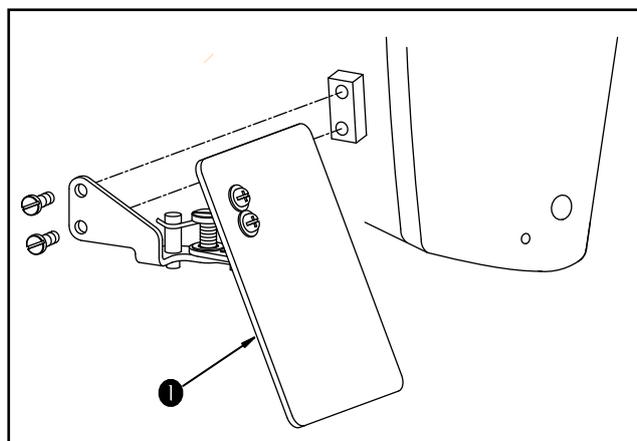


7.眼睛防护罩的安装



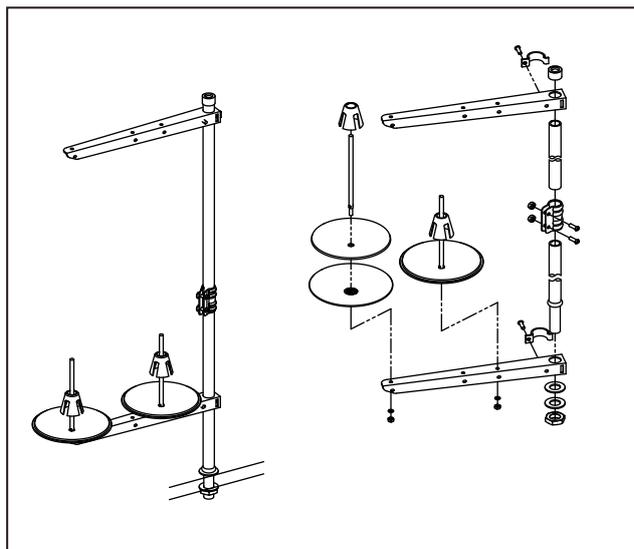
注意

为防止断针飞起弄伤眼睛，请一定安装起来。



将附件箱中眼睛防护罩装在机头
如图所示左侧。

8.线架的安装



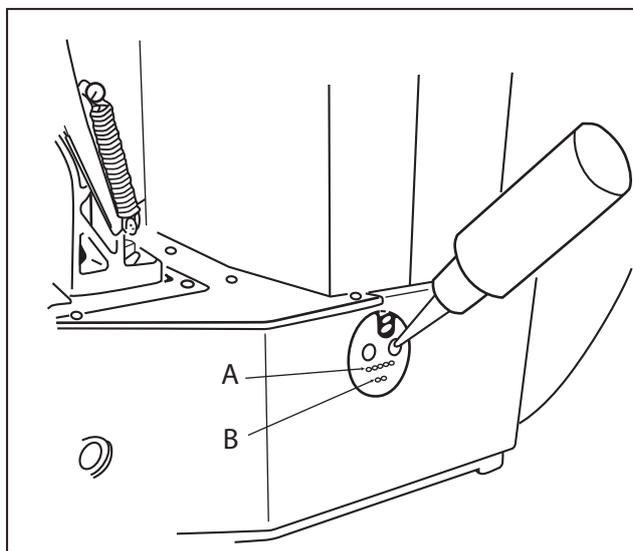
将附件箱中的线架如图装在台板孔上。

[4] 整机的准备

1. 加油



为了防止突然启动造成人身事故，请关掉电源后再进行。



请确认机油在下线 B 和上线 A 之间。如果机油过少时，请用附属的加油器进行加油。加油的油槽仅是向摆梭加油的。使用转速低时，如果摆梭的油量过多，可以把油量调小。（请参照[5]维修—7.摆梭油量的调整。）

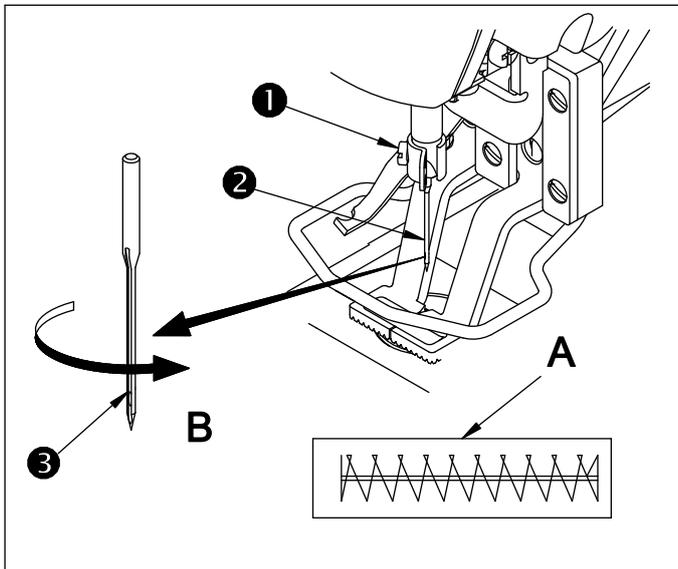


1. 请注意不要向油槽和下列注意 2 的摆梭以外的部位加油。否则会发生零件故障。
2. 初次使用缝纫机或较长时间没有使用缝纫机时，请向摆梭加少量的机油后在使用缝纫机。（请参照[5]维修—2.机针和摆梭）。

2. 机针的安装



为了防止突然启动造成人身事故，请关掉电源后再进行。



安装机针时，请拧松固定螺钉①，把机针②的容线槽③朝向面前，插进针杆的深处，然后拧紧固定螺钉①。

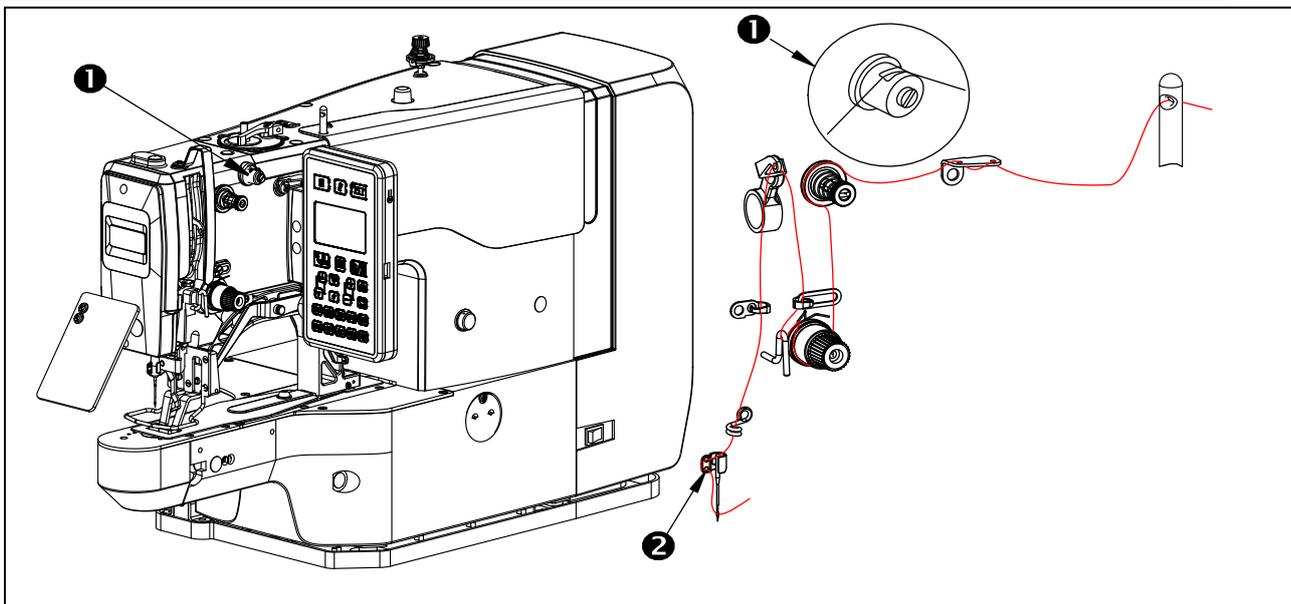


缝迹如 A 时，请把机针向 B 方向稍稍移动然后安装起来。

3. 上线穿线



为了防止突然启动造成人身事故，请关掉电源后再进行。



穿过机针的线应留出 4cm 左右。

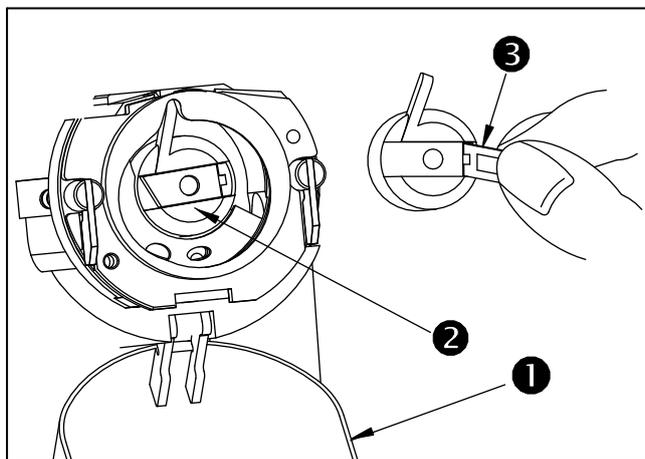


1. 使用硅油时，请把线穿过润滑导线器①。
2. 粗线时，请把机线只穿过针杆导线器②1 个孔。

4. 梭壳的取下插入



为了防止突然启动造成人身事故，请关掉电源后再进行。



- (1). 打开梭床外罩①。
- (2). 拨起梭壳②的抓脚③，取出梭壳。
- (3). 插入时，请把梭壳深深插入摆梭轴，并关闭抓脚。

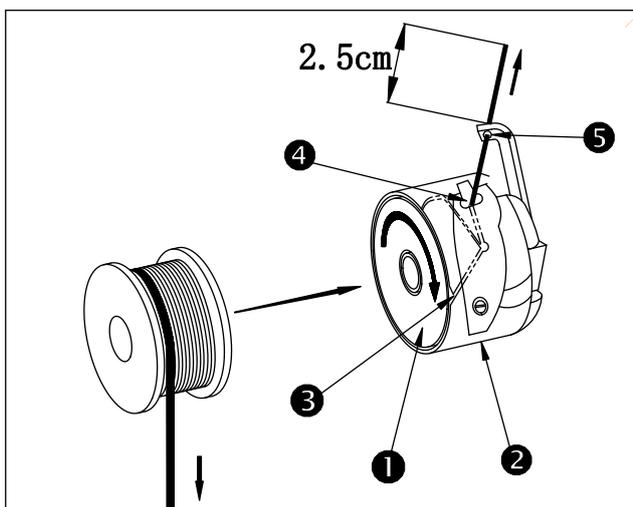


如果没有插到底，缝制途中梭壳②就有可能脱落。

5. 梭芯的插入方法



为了防止突然启动造成人身事故，请关掉电源后再进行。

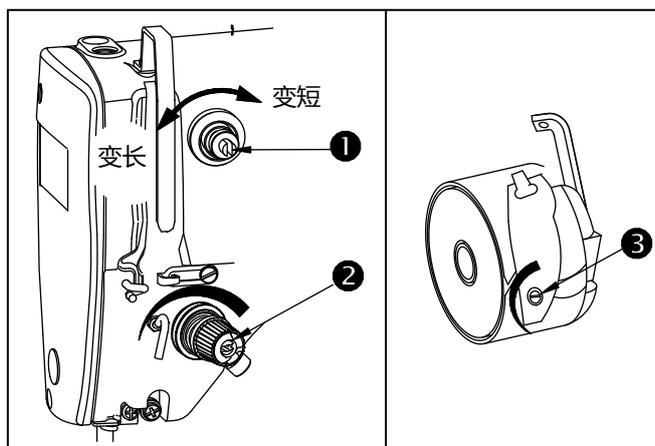


- (1). 把梭芯①按图示的方向插入梭壳②。
- (2). 把线穿过梭壳②的穿线口③，然后拉线，把线从线张力弹簧下面的穿线口④拉出来。
- (3). 把线从梭壳②的线孔⑤穿出，从线孔约拉出2.5cm。



底线的旋转方向请按照左图所示；如果相反的话底线的拉出就不稳定。

6. 线张力的调整

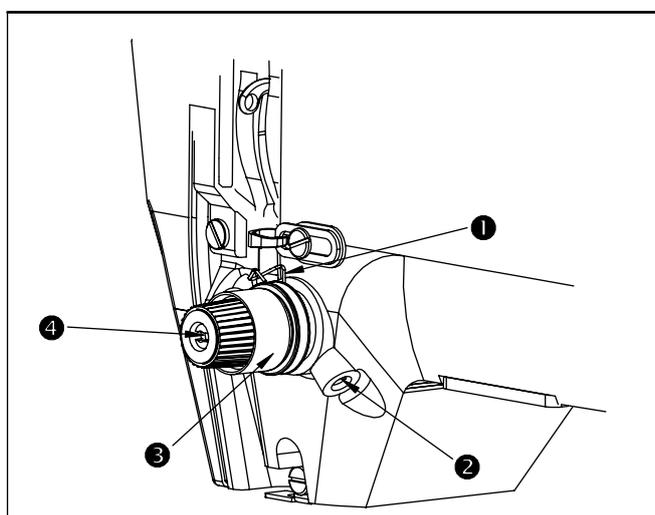


把第一线张力就旋钮①向右转动，切线后针尖上的残线长度变短，向左转动后变长。

请尽量在不脱线的情况下弄短残线。

用②调整面线张力，用③调整底线张力。

7. 挑线弹簧的调节



挑线弹簧①的标准移动量为8~10mm开始挑线时的强度为0.1~0.3N。

(1). 移动量的调节

拧松固定螺钉②，转动夹线器挡圈③。

(2). 强度的调节

改变挑线弹簧的强度时，请在螺丝②拧紧的状态下，把细螺丝刀插到夹线器螺钉④的缺口部转动调节。向右转动之后，挑线弹簧的强度变强，向左转动之后，强度变弱。

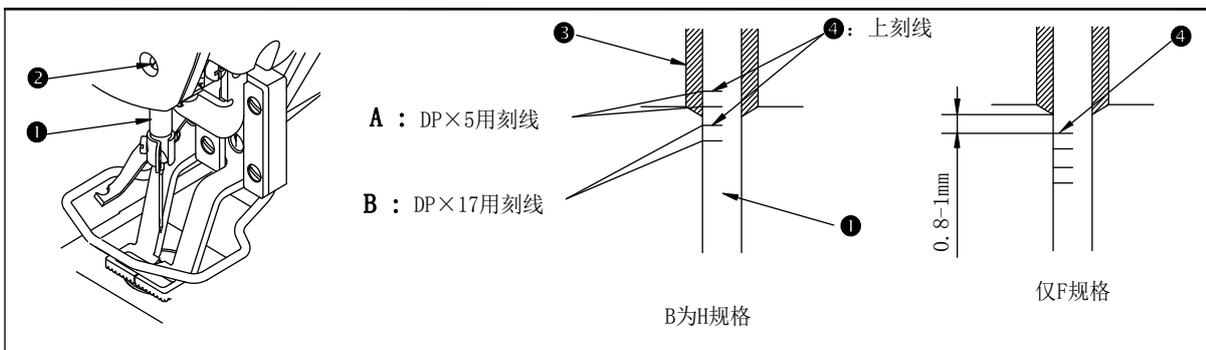
[5] 维修

1. 针杆高度



注意

为了防止突然启动造成人身事故，请关掉电源后再进行。



把针杆①设到最下点，拧松针杆紧固螺丝②，把针杆上刻线④和针杆下套③的下端调节成一致。



注意

请调节后一定确认不要有松动。有的缝制条件发生跳针时，请从针杆上刻线④往下调节 0.5mm-1mm。

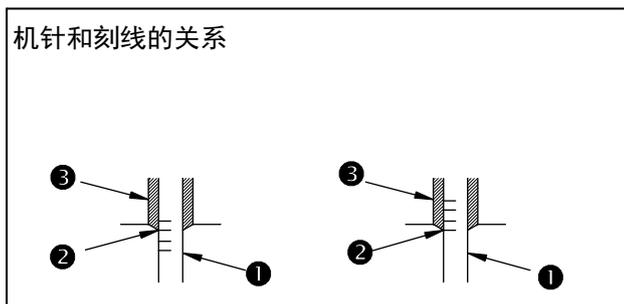
2. 机针与摆梭



注意

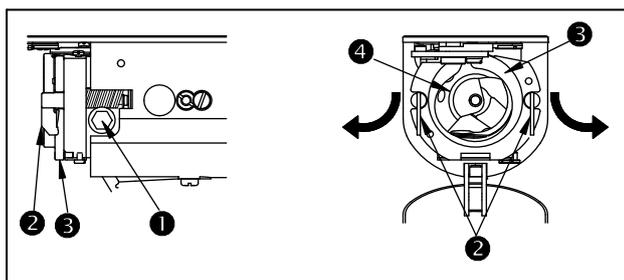
为了防止突然启动造成人身事故，请关掉电源后再进行。

机针和刻线的关系

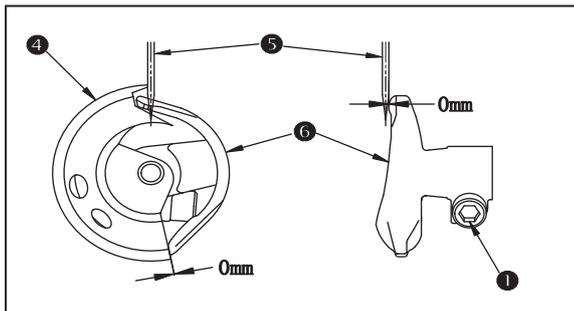


(1) 用手转动手轮，针杆①上升时，把下刻线②对准针杆下套前端一致。

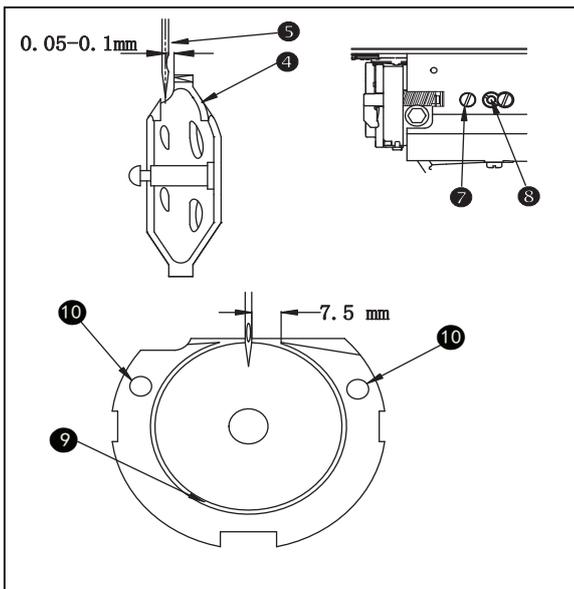
(2). 拧松驱动器固定螺丝①，左右打开梭床盖压片②，卸下梭床盖③。



此时请注意不要脱落摆梭④。



(3)为了让摆梭④的梭尖与机针⑤的中心一致，同时防止驱动器⑥在前段面与机针相碰，弄弯机针，请把驱动器前端面与机针的间隙调整为 0mm，然后把驱动器固定螺丝①拧紧。



(4). 拧松梭床固定螺丝⑦，左右转动梭床调节轴⑧，调节梭床的前后位置，把机针⑤和摆梭④的梭尖的间隙调整为 0.05~0.1mm。
 (5). 调节完梭床的前位置后，机针和梭床的间隙应为 7.5mm，然后拧紧梭床固定螺丝⑦。

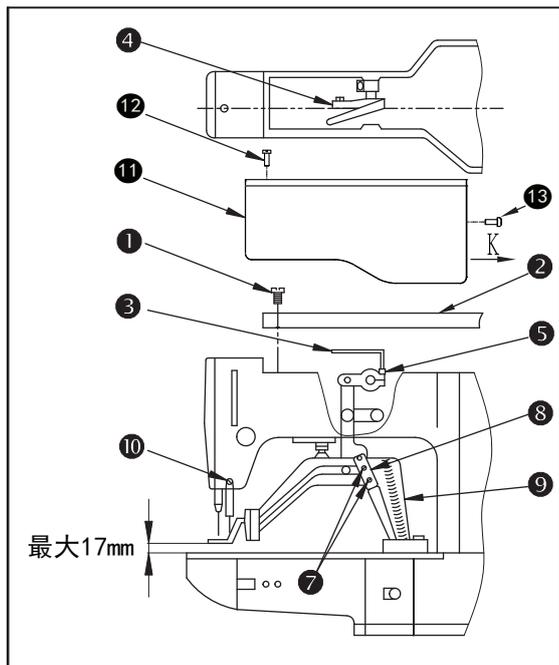


较长时间没有使用缝纫机或清扫过摆梭周围之后时，请往导轨部⑨和油芯⑩加少量的机油后再使用。

3. 压脚的高度



为了防止突然启动造成人身事故，请关掉电源后再进行。



(1)在停止状态，卸下右装饰板⑪上的⑫、⑬ 两颗螺钉，然后往K方向卸下右装饰板⑪。
 (2)卸下 6 只机壳上盖固定螺丝①，然后卸下机壳上盖②。
 (3)把 L 形扳手插入中央的紧固筒的六角孔螺栓⑤，把它拧松。
 (4)把 L 形扳手③向下压布压脚升高，向上抬布压脚降低。
 (5)调节后，把六角孔螺栓⑤确实拧紧。
 (6)左右压脚不一致时拧松固定螺丝，⑦调节压脚杆挡板⑧调整高度。



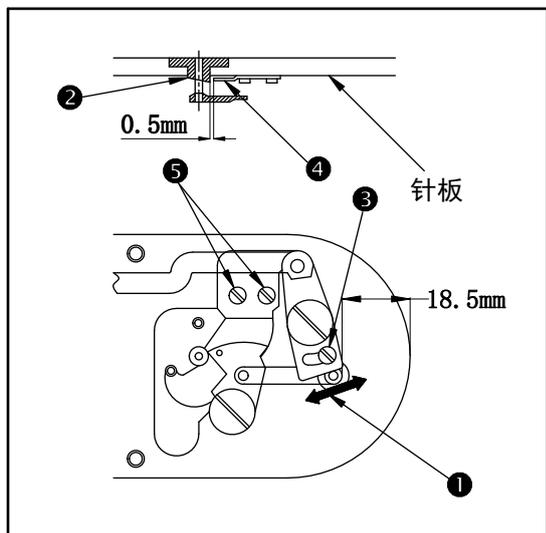
此时，请不要让布压脚拨档杆板⑧与送料架⑨相碰。如果和拨线杆相碰，请用拨线杆安装台固定螺丝⑩调节拨线杆高度。

4. 动刀和定刀



注意

为了防止突然启动造成人身事故，请关掉电源后再进行。



(1). 拧松调节螺丝③，向箭头方向移动动刀，把从针板前段刀切线小拨杆①前段的距离调整为 18.5mm。

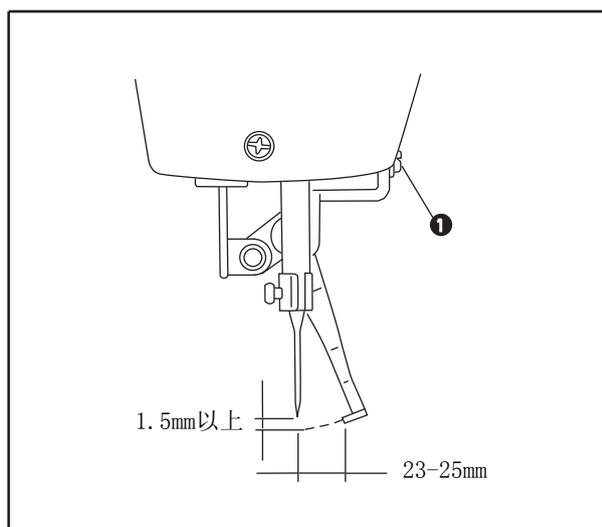
(2). 拧松固定螺丝⑤，移动固定刀，把针孔导线器②和固定刀④之间的间隙调整为 0.5mm。

5. 扫线杆的调整



注意

为了防止突然启动造成人身事故，请关掉电源后再进行。

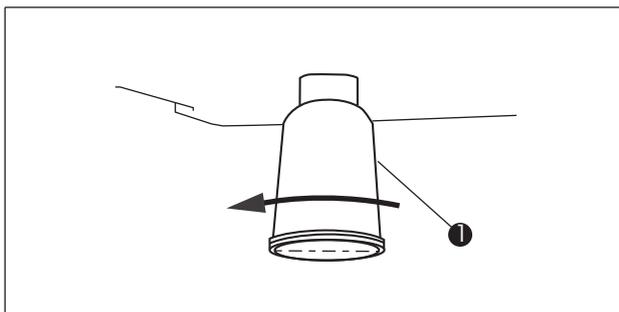


拧松螺丝①把挑线杆和机针的间隙调整为 1.5mm 以上。此时的扫线杆和机针的距离大约为 23~25mm 通过较宽的调整，在压脚下降时可以防止压到纫机线。

特别是使用细针时，请调宽到 23mm 左右。

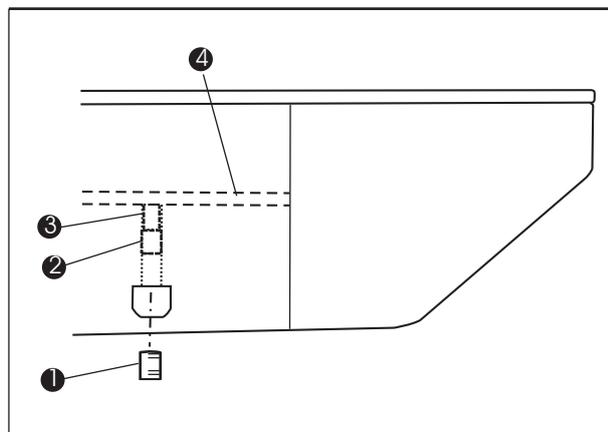
※ 机针为缝制结束停止的位置。

6. 废油的处理



积油杯①里积满了油之后，请卸下积油杯①排放出废油。

7. 旋梭油量调整



- (1). 拧松固定螺丝①，卸下固定螺丝①。
- (2). 拧紧调整螺丝②之后，加油管左④的油量杯弄小。
- (3). 调整后，拧紧固定螺丝①固定好。



1. 在标准出货状态，轻轻拧紧②回转 4 圈的位置。
2. 弄小油量时，不要一次拧紧，拧紧②回转 2 圈，待半日左右观看一下。拧得过紧的话会磨损旋梭。

8. 向指定部位补充润滑油

使用缝纫机进行了一定的缝制次数之后，打开电源时操作盘上会显示出异常代码 No. E221。这是通知需要向指定部位补充润滑油，此时请一定补充下列润滑油，叫出存储器开关 No. 245，用复位键复位到[0]。显示出异常 No. E221 显示后，按复位键可以解除异常，但再次打开电源后会再次显示出 No. E221。

而且，异常 No. E220 显示，继续缝制一定期间后会显示出异常 No. E221，按复位键不能解除异常，同时缝纫机变成不能动作。因此，显示出异常 No. E221 以后，请一定向下列部位补充润滑油，然后启动存储器开关 No. 245，用复位键复位到[0]。

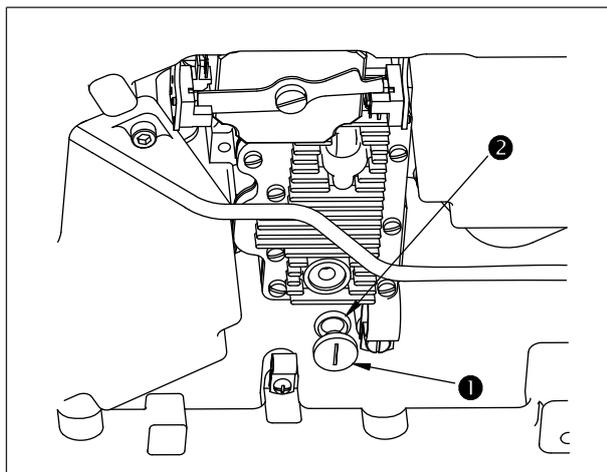


补充润滑油之后，如果不把存储器开关 No. 245 变更为[0]，异常 No. E220 或 No. E221 会被再次显示。



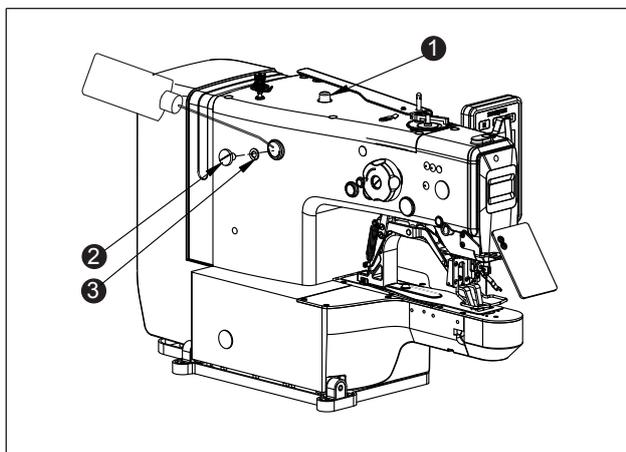
为了防止突然启动造成人身事故，请关掉电源后再进行。

(1). 将齿轮箱的废油放光



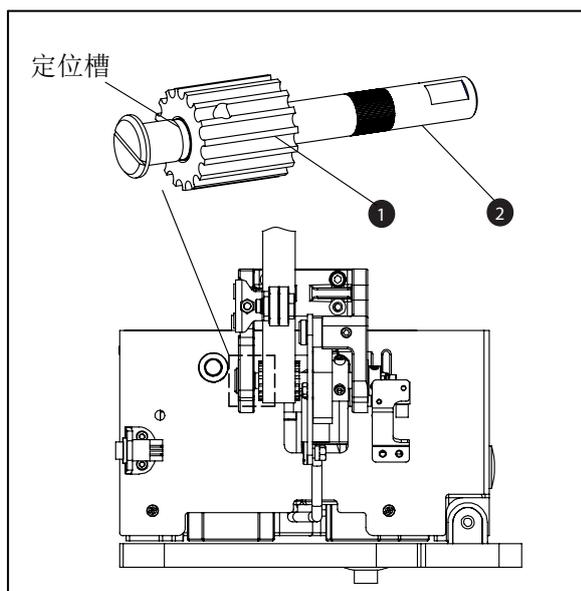
- A. 放倒缝纫机，卸下密封螺钉①和密封圈②。
- B. 放正缝纫机，把齿轮箱内的油放光。
- C. 放倒缝纫机，把密封圈②和密封螺钉①装回去，然后再放正缝纫机。

(2). 向齿轮箱中加入润滑油



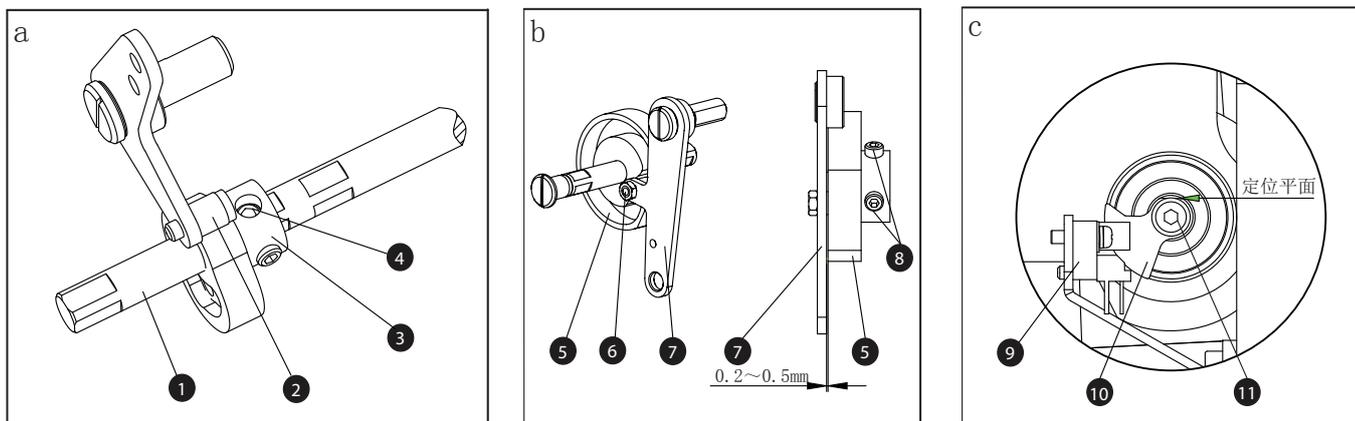
- A. 当通过油窗①观察到出油不明显或无出油时，应即时往齿轮箱内加油；
- B. 在停机状态下，取下螺钉②与橡胶垫圈③，加10#白油，无出油时，加100ml，出油不明显时，加50-70ml。装回②与③，启动机器观察出油是否明显。

9. 剪线驱动带轮位置的调整



按如图所示，将剪线驱动带轮①装配后，使带轮左端面与剪线驱动轴②上定位槽右端面对齐，拧紧带轮①上的两颗紧定螺钉。

10. 剪线凸轮和剪线安全传感片的调整

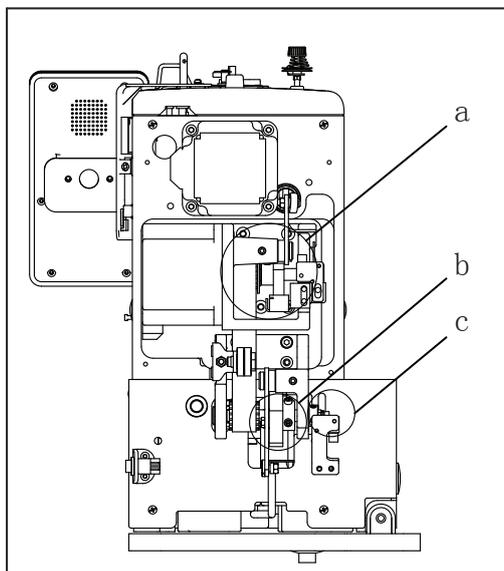


<1>剪线凸轮的调整

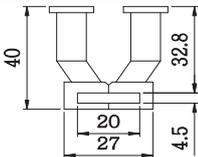
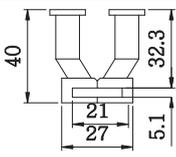
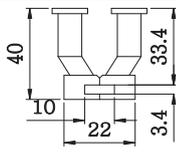
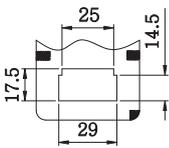
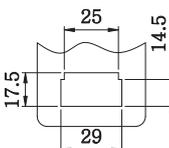
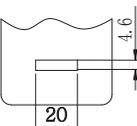
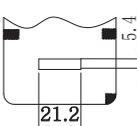
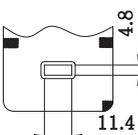
- (1) 转动抬压电机轴①，将抬压凸轮③转至与抬压滚柱②最低点接触时，即螺钉紧定螺钉④朝向正上方位置，如图a所示。
- (2) 此时，调整剪线滚柱⑥在剪线凸轮⑤的凹槽最底部位。
- (3) 调整剪线曲柄⑦与剪线凸轮⑤端面距离0.2~0.5左右，如图b所示锁紧剪线凸轮的两个螺钉⑧。

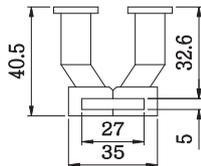
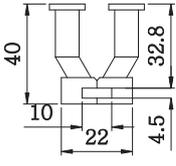
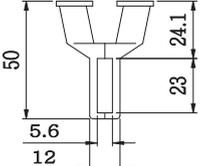
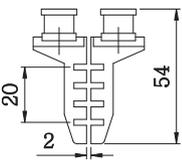
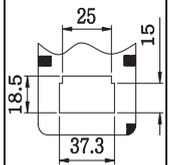
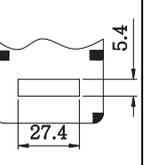
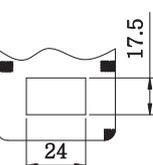
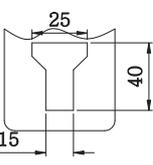
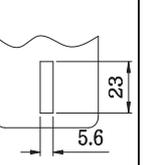
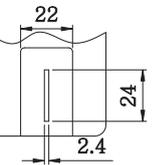
<2>剪线安全传感片的调整

- (4) 转动抬压电机轴①，将抬压凸轮③转至与抬压滚柱②最低点接触时，即螺钉紧定螺钉④朝向正上方位置，如图a所示。
- (5) 此时，将剪线安全传感片⑩的定位平面水平朝正上方位置，并将剪线安全传感片⑩置于剪线安全传感器⑨内，如图c所示，锁紧螺钉组件⑪，固定剪线安全传感片⑩。
- (6) 当脚踏第一踏时，压脚下压，确保剪线安全传感片⑩未进入剪线安全传感器⑨内，再第二踏开始缝制，此时缝制正常，若有报错剪线异常“E-018”，请松开螺钉组件⑪顺时针方向调整剪线传感片⑩的位置。



[7]. 标准压脚一览表

压脚号码	1	2	3	4	5
压布压脚	左: 10011508 右: 10011505			左: 10011687 右: 10011691	左: 10011758 右: 10011759
					
压布底板	10011565	10012300	10012279	10011751	10011755
	有齿牙	无齿牙	无齿牙	有齿牙	有齿牙
					
缝制规格	S	F	F	H	M
护指器	10011556(S、M、F)、10011695(H)				
备注	S(标准)规格机头上标准装备。	F(内衣)规格机头上装备。(根据出口地)		选购品	M(针织)规格机头上标准装备。

压脚号码	6	7	8	9	10	11
压布压脚	左: 10012349 右: 10012342		左: 10012339 右: 10012346	左: 10012341 右: 10012348		左: 10026244 右: 10026245
						
压布底板	10012277	10012302	10012286	10012296	10012301	10026246
	有齿牙	有齿牙	有齿牙	无齿牙	无齿牙	无齿牙
						
缝制规格	S	H/W	S	F	F	F
护指器	10011556(S、M、F)、10011695(H、W)					
备注	选购品	H(厚料)、W(倍旋梭)规格机头上标准装备		选购件	F(内衣)规格选购品。(根据出口地)	选购品

压脚号码	12	13	14	15	16
压布压脚	左: 10026247 右: 10026248	左: 10026250 右: 10026251	左: 10012344 右: 10012345	左: 10026253 右: 10026254	左: 10026256 右: 10026257
压布底板	10026249	10026252	10012338	10026255	10026258
	有齿牙	无齿牙	无齿牙	有齿牙	有齿牙
缝制规格	F	S	S	S	S
护指器	10011556				
备注	选购品	选购品	选购品	选购品	选购品

※更换压脚时，请安装合适各压脚的手指保护器。

[8] 选购件一览表

零件名称	种类	货号	备考
送料板 t=1.2 	有齿牙 / 有表面处理 缝制范围 纵 20× 横 40	10012303	
	有齿牙 / 有表面处理 缝制范围 纵 30× 横 40	10014401	
小针板 	A=1.9 B=2.8 无槽	10047532	S 规格
	A=1.6 B=2.0 无槽	10011757	F. M 规格
	A=2.3 B=4.0 无槽	10004727	H 规格
	A=3 B=7 无槽	10007281	渔网机用
	A=1.6 B=2.6 有槽	10004646	选用件

II. 一体式高速电子钉扣机的说明

[1] 规格

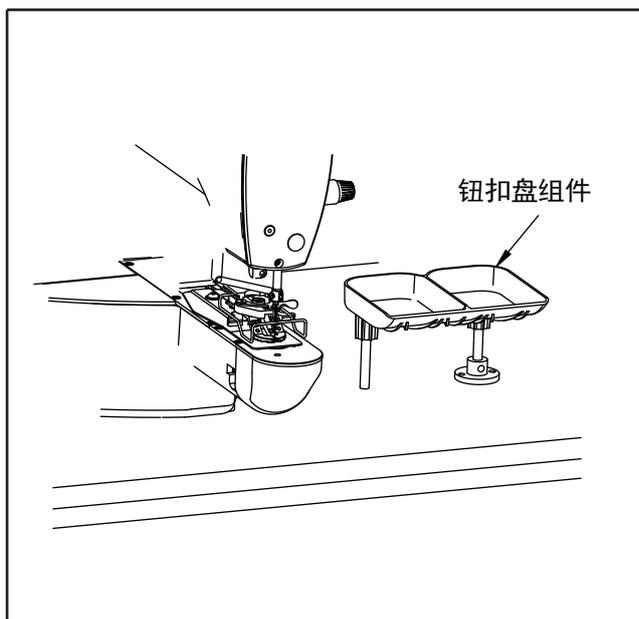
这里只记述与套结机不同部位的说明内容。

- (1). 转速..... 最高 2700rpm
- (2). 使用机针..... DP X 17 #14
- (3). 压脚提升方式..... 脉冲马达
- (4). 压脚上升量..... 最大 13mm
- (5). 记忆数据数量..... 50 种
- (6). 拨线方式..... 脉冲马达压脚提升连动

[2] 安装和缝纫前的准备



注意 搬运缝纫机时，一定要 2 人以上来搬运。



- (1). 机头的安装与套结机相同，请参照套结机使用说明书。
- (2). 附属品安装在纽扣盘架上，请安装到容易作业的位置。



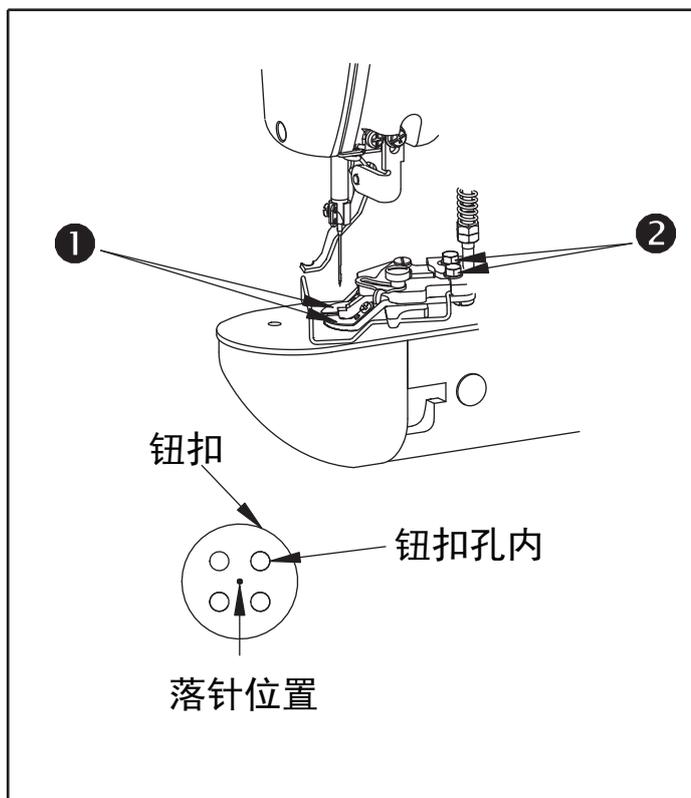
运转前请转动手轮确认机针是否与纽扣相碰。

[3] 机针和缝线

机针	上线	底线
DPx17 #14	#60	#80
	#60	#60
	#50	#60
	#40	#60

机针和机线，因缝制条件不同而不同，使用时请参照左表选择，最好使用棉线、缝纫机线。

[4] 纽扣夹的位置



- (1). 把纽扣放入纽扣抓脚①。
- (2). 在缝制 LED 灭灯的状态，按操作盘  键，再按  键，各部件找零。
- (3). 转动手轮，确认机针中心是否在纽扣中心。确认原点位置。
- (4) 如果机针没有在纽扣中心位置时，请拧松纽扣抓脚安装台固定螺丝②，进行调整。
- (5) 调节后，请确认图案形状。确认机针是否正好落在纽扣孔内。



注意

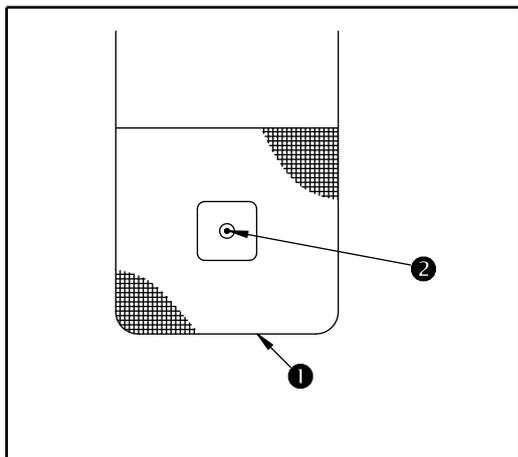
变更了纽扣的形状、图案，或利用扩大缩小功能变更了缝纫宽度之后，请一定要确认落针位置。如果机针落到纽扣外，图案超出抓起装置，机针在缝制中会发生断针的危险。

[5] 送料板的调整



注意

变更了钮扣形状、图案，或利用扩大缩小功能变更了缝纫宽度之后，请一定要确认落针位置。如果布压脚与针孔导板相碰，会发生断针的危险。另外，调整中如果踩了踏板，爪脚装置会上下移动，请注意危险。



(1). 在缝制 LED 灭灯的状态，按操作盘



键，再按



键，各部件回零。

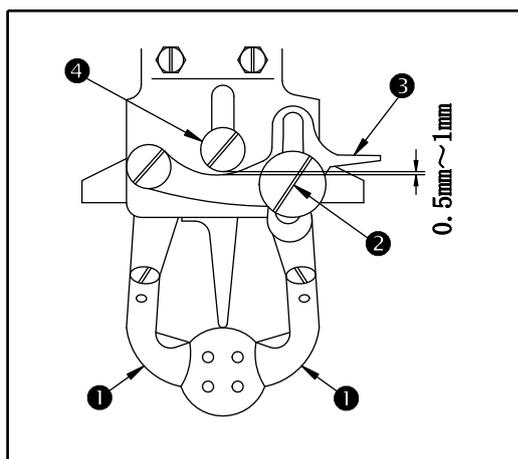
(2)调整布压脚底板①，使针孔导板②正好在布压脚底板①的H部的中心。

[6] 纽扣夹张开角度调整



注意

为了防止突然的启动造成人身事故，请关掉电源，确认马达完全停止后在进行操作。

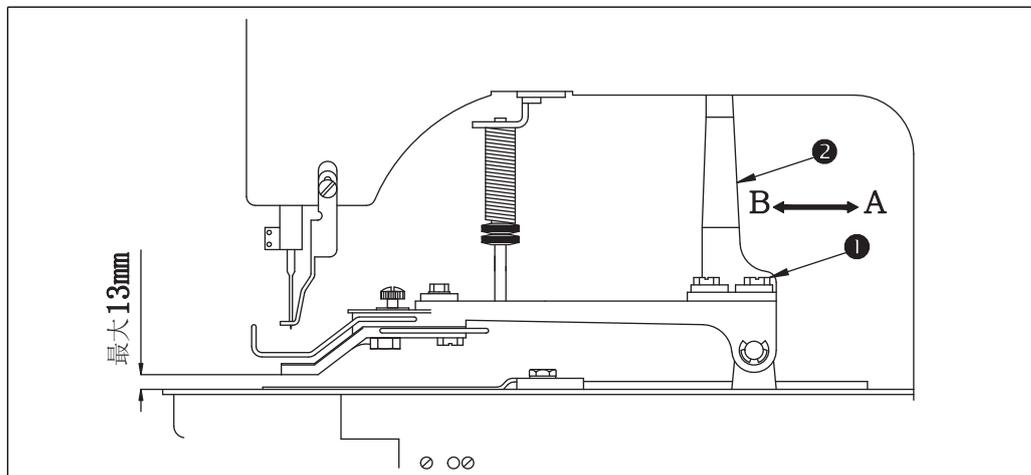


在让停止位置的抓脚①上升的状态，拧松开关抓脚拨杆固定螺丝②，让纽扣设定到抓脚②，把抓脚打开拨杆③和塔形螺丝④之间的间隙为 0.5~1mm，然后拧紧打开抓脚拨杆固定螺丝②。

[7] 纽扣夹上升高度的调整

**注意**

为了防止突然的启动造成人身事故，请关掉电源，确认马达完全停止后在进行操作。

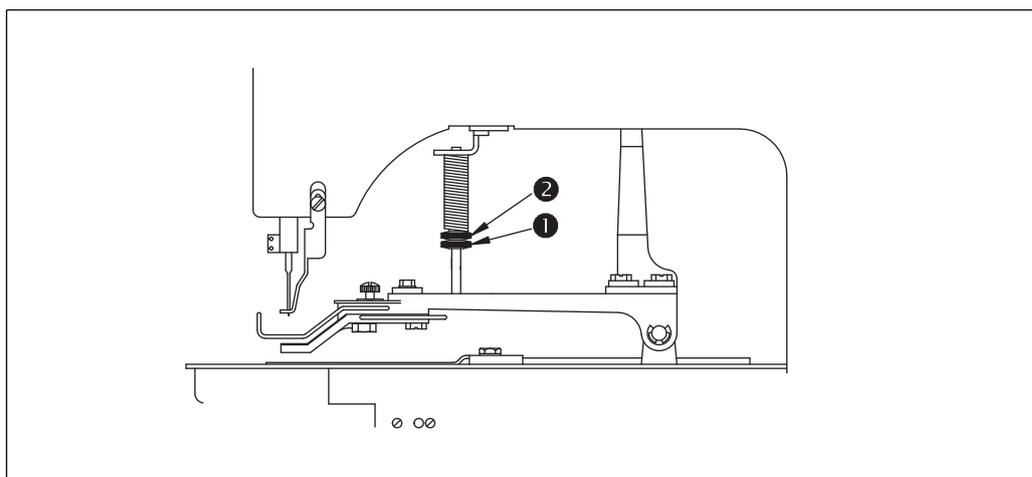


请拧松 2 个固定螺丝①，前后调整压脚的提升动作板②进行调整。把压脚提升动作板②向 A 方向移动后，提升量变低，向 B 方向移动后，则变高。调整后把固定螺丝确实拧紧固定。

[8] 压脚压力的调整

**注意**

为了防止突然的启动造成人身事故，请关掉电源，确认马达完全停止后在进行操作。



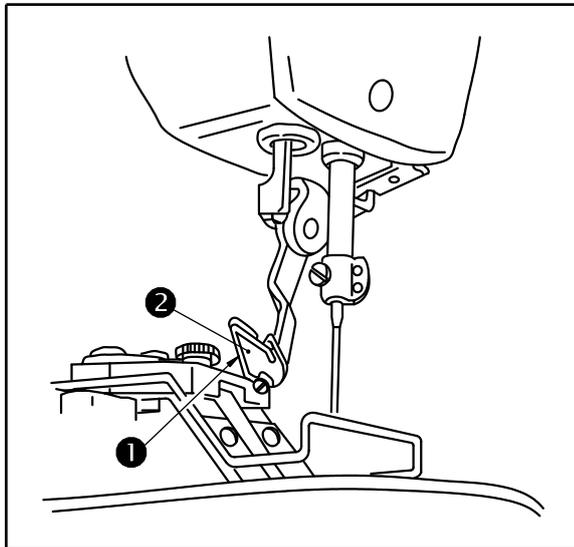
拧松调整螺丝①，转动调节螺丝②，使布料运转中尽量不要偏斜。

[9] 扫线杆弹簧的调整



注意

为了防止突然的启动造成人身事故，请关掉电源，确认马达完全停止后在进行操作。



调整扫线杆弹簧①，使扫线杆弹簧①把切线后的上线保持到挑线杆②之间，这时的强度为 20~30g（比从梭壳出来的底线稍强）。



保持过强的话，旋梭上的线就会脱落。

[10] 缝制范围

机种名称		钉扣机	
纽扣尺寸分类		中小纽扣用	
可以缝制的纽扣外径 (mm)		Ø8~Ø22	
缝制尺寸 (mm)	纵	0~3.5	
	横	0~3.5	

III. 缝纫时故障、原因及对策

现象	原因	对策
1. 始缝时脱线	①始缝时跳针。 ②切线后上线长度短。 ③底线过短。 ④第一针的上线张力高。 ⑤第一针的间距小。	○机针和旋梭的间隙调整为 0.05~0.1mm ○设定始缝时软起动。 ○调节第 2 线张力器的浮线量。 ○把挑线弹簧弄强或把第一线张力盘的张力减弱。 ○减弱底线张力。 ○弄大针孔导向器和固定刀的间隙。 ○降低第一针的张力。 ○降低缝制开始第一针的转速。 ○增长第一针的间距。 ○下降第一针的上线张力。
2. 老断线。 化纤纤维拉断	①摆梭、驱动器上有伤。 ②针孔导向器上有伤。 ③机针碰布压脚。 ④线头进入大旋梭的沟里。 ⑤上线张力过强。 ⑥挑线弹簧过强。 ⑦化纤纤维摩热而断。	○卸下用细磨时或挫刀磨平。 ○用锉刀磨，或换新。 ○调节布压脚的位置。 ○卸下摆梭，清除线头。 ○减弱上线张力。 ○减弱挑线弹簧。 ○使用硅油。
3. 常断针	①针弯了。 ②针碰布压脚。 ③针过粗。 ④驱动器把针弄得过弯。 ⑤在缝制开始时压脚压住缝纫机线（机针弯曲）。	○更换机针。 ○调节布压脚。 ○根据缝制物选用适当的机针。 ○调整针和摆梭位置。 ○弄宽机针和挑线杆的距离（23~25mm）。
4. 切线不断（仅限底线）	①固定刀不快。 ②针孔导线器和固定刀高低差小。 ③动刀位置不好。 ④最终针跳线。 ⑤底线张力低。	○更换固定刀。 ○把固定刀再弄弯一些。 ○调整动刀位置。 ○调整针摆梭的同步。 ○提高底线张力。
5. 常跳线	①针和摆梭调整不好。 ②针和摆梭的间隙过大。 ③针弯了。 ④驱动器把针弄得过弯。	○调整针和摆梭的位置。 ○调整针和摆梭的位置。 ○更换机针。 ○调整驱动器的位置。
6. 上线从布的里侧露出来	①上线紧线不好。 ②线张力盘浮起机构不动作 ③切线后的上线过长。 ④针数少。 ⑤缝制长度短时（缝制背面上线头露出）。	○加强上线张力。 ○确认缝制中第 2 线张力盘是否浮起。 ○加强第 1 线张力。 ○使用暗缝式下板。

7. 切线时 短线	①动刀位置不好。	○调节动刀位置 ○调节剪线凸轮位置
8. 机线长 度不一 致	①挑线弹簧的张力低。	○提高挑线弹簧的张力。
9. 机线长 度不能 弄短	①第 1 线张力器的张力低。 ②挑线弹簧张力过强。 ③因为挑线弹簧的张力过低，所以动作不稳定。	○增强第 1 线张力器的张力。 ○降低挑线弹簧的张力。 ○增强挑线弹簧的张力，行程也变长。
10. 缝制开 始第 2 针的底 线结线 部露出 表面	①梭芯的空槽大。 ②底线张力低。 ③第 1 针的上线张力过强。	○调整活动刀的位置。 ○增强底线张力。 ○下降第 1 针的上线张力。

In order to create a better environment

Please cooperate with you

First of all, I would like to express my heartfelt thanks to you for using our products.

Our company is committed to caring for the earth's environment and has formulated the basic policy of "intelligent manufacturing and green manufacturing". Local citizens in environmental protection activities should also do little to the local community, the environment two aspects of everyone's contribution.

Therefore, I hope you can cooperate with this plan, as part of the environmental protection activities, when dealing with wastes in peacetime can pay more attention.

1. Unused packaging materials, in order to be recycled again, please send them to the local recycling company for disposal.
2. Lubricants used shall be properly handled according to relevant laws and regulations.
3. When parts need to be replaced in product maintenance or repair, there are unnecessary circuit boards and electronic parts, and when products are discarded, please treat them as electronic waste.

Thank you very much for purchasing our industrial sewing machine
 Before using the sewing machine, please read <for your safe use> and use instructions carefully

The characteristic of industrial sewing machine is that it should be operated near the moving parts such as needles and spindles, which are easy to cause injury, so please use the sewing machine correctly under the guidance of the safety operation knowledge of trained or skilled personnel.

For Your Safe Use

[1] Safety Usage Marking And Its Significance

The labels and pattern marks used in this instructions and products are for your safety and correct use of the products to prevent you and others from being harmed and damaged.

The methods and implications are as follows.

Sign

	Danger This content indicates that if this mark is mishandled, it will cause death to become serious.
	Warning This content indicates that if this mark is mishandled, people will die or be seriously injured.
	Note That if this mark is mishandled, it may cause minor or moderate injuries.

Patterns And Symbols



..... The symbol (△) indicates “points for attention”.
 The pattern in the triangle represents the essential content that must be paid attention to.
 (For example, the pattern on the left shows “watch out for injuries”.)



..... The symbol (⊘) indicates “prohibition”.



..... The symbol (●) indicates “must”.
 The pattern in the circle indicates the substance of what must be done.
 (For example, the pattern on the left shows “must be grounded”.)

[2] Safety Precautions

Danger



After closing the power switch and unplugging the power plug from the socket, wait for at least 5 minutes before opening the control box cover. Touching areas with high voltage can cause casualties.

Warning



No liquid is allowed to enter the sewing machine, otherwise it will cause fire, electric shock and operation failure.



If any liquid enters the sewing machine (head or control box), turn off the power supply immediately, pull the plug out of the socket, and contact the vendor or senior technicians.

Be Careful

Use Environment



Please don't use in the environment with strong electrical interference sources such as power line interference and electrostatic interference.

Strong electrical interference sources may affect the correct operation of sewing machines.



The fluctuation of power supply voltage should be used in the environment of rated voltage less than $\pm 10\%$.

The large fluctuation of voltage will affect the correct operation of sewing machine.



The power supply capacity should be greater than the power consumption of the sewing machine. Insufficient power supply capacity will affect the correct operation of sewing machine.



The ambient temperature should be used in the range of 5-35 degrees Celsius.

Low or high temperature will affect the correct operation of sewing machine.



Relative humidity should be in the range of 45% - 85%, and the equipment will not form condensation environment. Dry or wet environment and dew will affect the correct operation of sewing machine.



In case of thunderstorm, turn off the power switch and pull the power plug off the socket. Lightning may affect the correct operation of sewing machine.



Do not connect devices other than USB memory to USB connection ports. Otherwise, it may lead to failure.

Install



Ask trained technicians to install sewing machines.



Please commission the purchase shop or electrical professionals for electrical wiring.



The sewing machine weighs about 35Kg. Installation must be completed by more than two people.



Please do not connect the power supply before the installation is completed. If you step on the pedal by mistake, the sewing machine will cause injury.



Please unplug the plug after cutting off the power supply. Otherwise, it will easily become the cause of the failure of the control box.



It must be grounded.

Insufficient ground connection is the cause of electric shock or misoperation.



When fixing the cable, do not bend the cable excessively or fix it too tightly with clamps, which may cause fire or electric shock.



If a worktable with casters is used, the casters should be fixed so that they cannot move.



When the head of the sewing machine falls down, please make sure that the worktable is fixed and not moved at will. Accidents such as foot clamping have occurred in the movement of worktable, which is the cause of personal accidents.



When the sewing machine head falls down or stands up, please operate with both hands.

One-handed operation can easily cause injury if the weight of the sewing machine slips.



When lubricating oil and butter are used, it is necessary to wear protective glasses and gloves to prevent lubricating oil from falling into serious or sticking to the skin, which is the cause of inflammation.

In addition, lubricants or butter should not be drunk, otherwise vomiting and diarrhea will occur.

Keep oil out of reach of children

Be careful

Sewing



This sewing machine is only used by persons trained in safe operation.



This sewing machine cannot be used for any purpose other than sewing.



Protective glasses must be worn when sewing machines are used.

If you don't wear protective glasses, there will be danger when you break the needle. The broken part of the needle may pop into your eyes and cause injury.



When the following happens, please cut off the power supply. Otherwise, when you step on the pedal, the sewing machine will cause injury.

·When the needle goes through the thread

·When changing needle or shuttle core

·When a sewing machine is not in use or when a person leaves the sewing machine



If a worktable with casters is used, the casters should be fixed so that they cannot move.



For the sake of completeness, please install protective device before using this sewing machine. If these safety devices are not installed, use sewing opportunities to cause personal injury and sewing machine damage.



During the sewing process, do not touch any moving parts or place the objects on the moving parts, because this will cause injuries to people or damage to the sewing machine.



When the head of the sewing machine falls down, please make sure that the worktable is fixed and not moved at will.

Accidents such as foot clamping have occurred in the movement of worktable, which is the cause of personal accidents.



When the sewing machine head falls down or stands up, please operate with both hands.

One-handed operation can easily cause injury if the weight of the sewing machine slips.



If the sewing machine operates incorrectly, or hears abnormal noise or smells abnormal odor, the power supply should be cut off immediately. Then contact the shop or trained technicians.



If the sewing machine breaks down, please contact the shop or trained technicians.

Clean



Please cut off the power supply before starting the cleaning operation.

If you step on the pedal by mistake, the sewing machine will cause injury.



When the head of the sewing machine falls down, please make sure that the worktable is fixed and not moved at will.

Accidents such as foot clamping have occurred in the movement of worktable, which is the cause of personal accidents.



When the sewing machine head falls down or stands up, please operate with both hands.

One-handed operation can easily cause injury if the weight of the sewing machine slips.



When lubricating oil and butter are used, it is necessary to wear protective glasses and gloves to prevent lubricating oil from falling into serious or sticking to the skin, which is the cause of inflammation.

In addition, lubricants or butter should not be drunk, otherwise vomiting and diarrhea will occur.

Keep oil out of reach of children

Maintenance And Inspection



Only trained technicians can repair, maintain and inspect sewing machines.



Maintenance, maintenance and inspection related to electricity should be entrusted to purchasing shops or electrical professionals.



Turn off the power supply when the following happens. Pull the plug from the power outlet.

Otherwise, when you step on the pedal, the sewing machine will cause injury.

·Inspection, adjustment and maintenance

·Replacement of fragile parts such as spindle and cutter



Before opening the motor cover, be sure to turn off the power supply, wait a minute, and then perform the operation.

Touching the motor surface can cause burns.



When the power switch must be connected to adjust, be sure to switch to maintenance mode.

Be careful to observe all safety precautions



When the head of the sewing machine falls down, please make sure that the worktable is fixed and not moved at will.

Accidents such as foot clamping have occurred in the movement of worktable, which is the cause of personal accidents.



When the sewing machine head falls down or stands up, please operate with both hands.

One-handed operation can easily cause injury if the weight of the sewing machine slips.



When replacing parts or installing optional accessories, be sure to use only genuine parts.

The Company will not be liable for any accident or malfunction caused by the use of non-authentic parts.



When removing the safety protection device and installing it again, be sure to install it in situ and check whether it can work properly.



In order to prevent accidents and malfunctions, please do not alter the sewing machine without authorization.

The Company will not be liable for any accident or malfunction caused by the modification of the sewing machine.

[3] Warning Label

The following warning labels are on the sewing machine

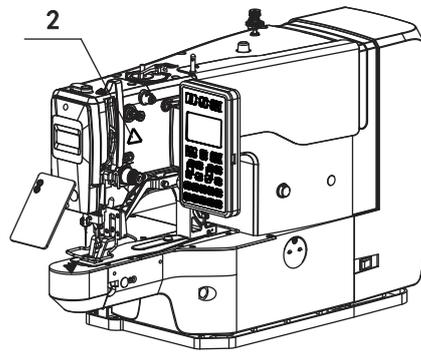
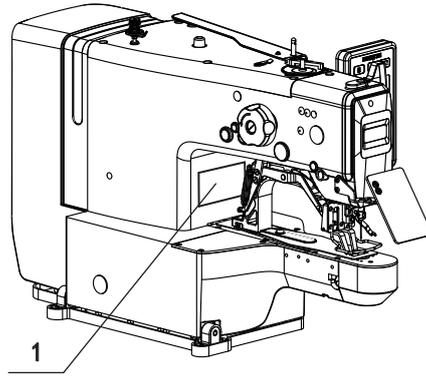
When using the sewing machine, please follow the instructions on the label. If the label falls off or is ambiguous, please contact the purchase shop.

1

	CAUTION
	Moving parts may cause Injury Operate with safety devices. Turn off main switch before threading changing bobbin and needle, cleaning etc. 在穿线; 更换梭芯、机针; 清洁机器时务必关闭电源。

2

	Be careful to avoid the damage by moving the Thread take-up lever.
-----------------------------------------------------------------------------------	--------------------------------------------------------------------



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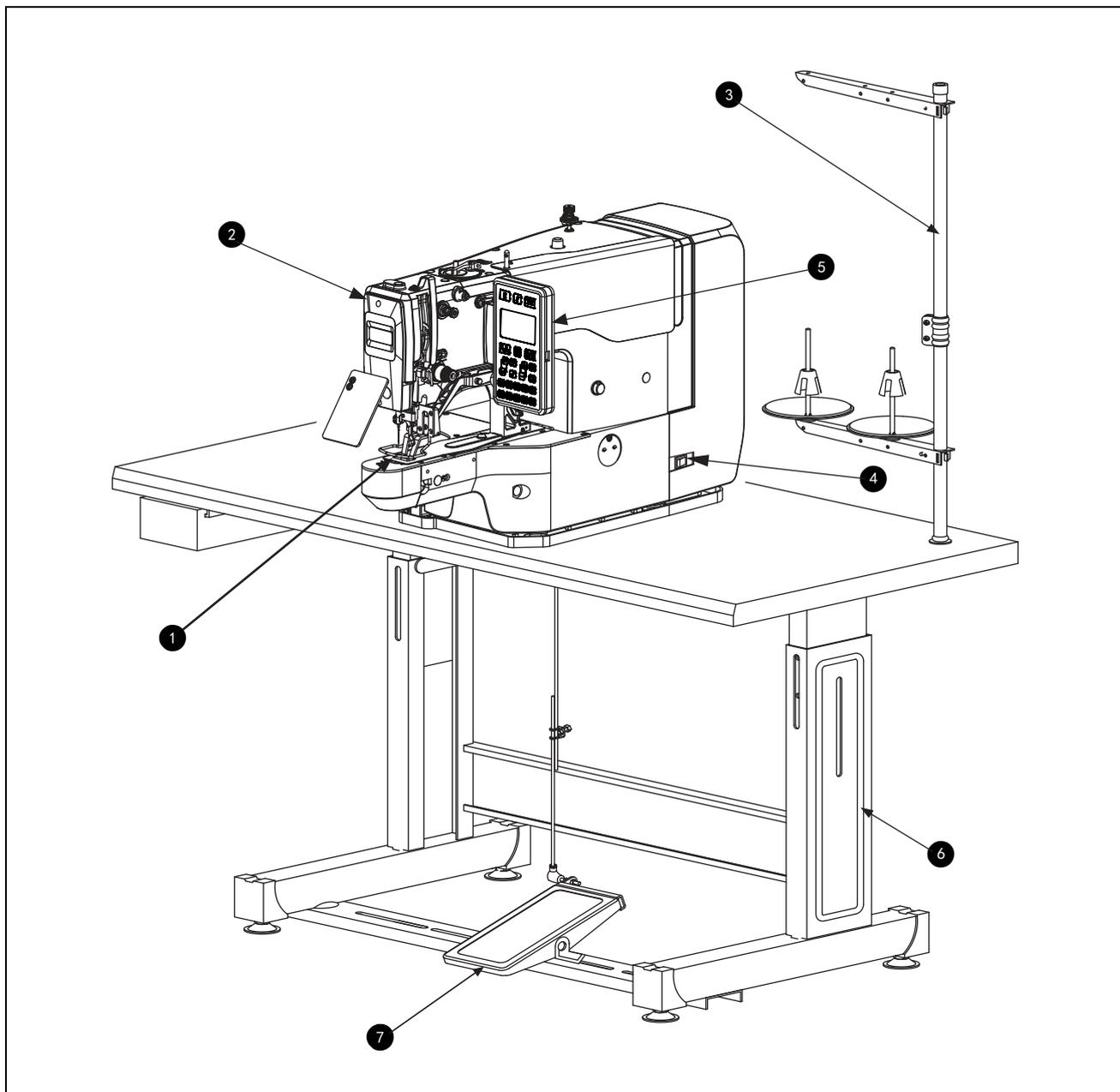
I . EXPLANATION OF COMPUTER-CONTROLLED HIGH-SPEED LOCKSTITCH BAR TACKING MACHINE

[1] SPECIFICATIONS

- | | |
|-------------------------------------------|----------------------------------------------------------------------------------------------------|
| 1. Sewing area: | X (lateral) direction 40mm,
Y (longitudinal) direction 30mm |
| 2. Max. Sewing speed: | 3200rpm
(when sewing pitches are less than 5mm in X-direction and 3.5mm in Y-direction) |
| 3. Stitch length: | 0.1-10mm (adjustable in 0.1mm step) |
| 4. Feed motion of work clamp foot: | Intermittent feed (2-shaft drive by stepping motor) |
| 5. Needle bar stroke: | 41.2mm |
| 6. Needle: | DP×5、 DP×17 |
| 7. Lift of work clamp foot: | 13mm (standard) Max.17mm |
| 8. Shuttle: | standard semi-rotary hook (oil wick lubrication) |
| 9. lubricating: | oil 10# (supplied by oiler) |
| 10. Date recording: | EPROM |
| 11. Enlarging/Reducing facility: | 20% to 200% (1% step) in X-direction and Y-direction respectively |
| 12. Enlarging/Reducing: | Patten enlargement/reduction can be done by increasing/decreasing the stitch length |
| 13. Max. Sewing speed limitation: | 400 to 3500rpm (100rpm) |
| 14. Pattern selection: | Specifying pattern No. type (1 to 200) |
| 15. Bobbin thread counter: | UP/DOWN type (1-999999) |
| 16. Sewing machine motor: | 550W Servo motor |
| 17. Dimensions: | W: 1200mm L: 540mm H: 1100mm |
| 18. Weight: | Machine 57.4Kg |
| 19. Power consumption: | 0.125KW |
| 20. Operating temperature range: | 5°C to 35°C |
| 21. Operating humidity range: | 35% to 85% (No dew condensation) |
| 22. Line voltage: | Rated voltage ±10% 50-60Hz |

[2] CONFIGURATION

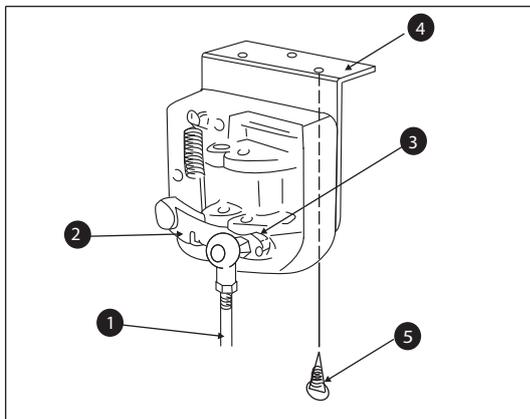
1. Names of main unit



- (1). Work clamp feet
- (2). Machine head
- (3). Thread stand
- (4). Power switch
- (5). Operation panel
- (6). Frame
- (7). Pedal switch

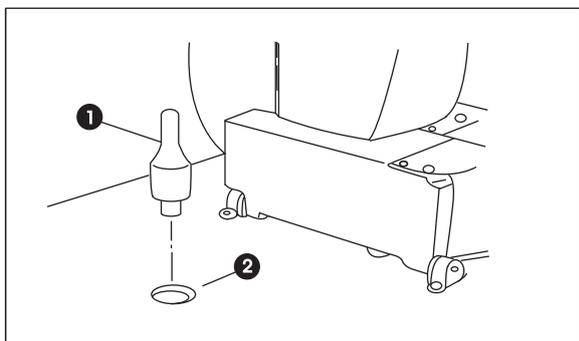
[3] INSTALLATION

1. Attaching the connecting rod



- (1) FIX connecting rod ① to installing hole B of pedal lever ② with nut ③. When connecting rod ① is installed in installing hole A, the depressing stroke of the pedal is increased.
- (2) Secure the pedal ④ with a wooden screw ⑤ in place.

2. Installing the head support rod

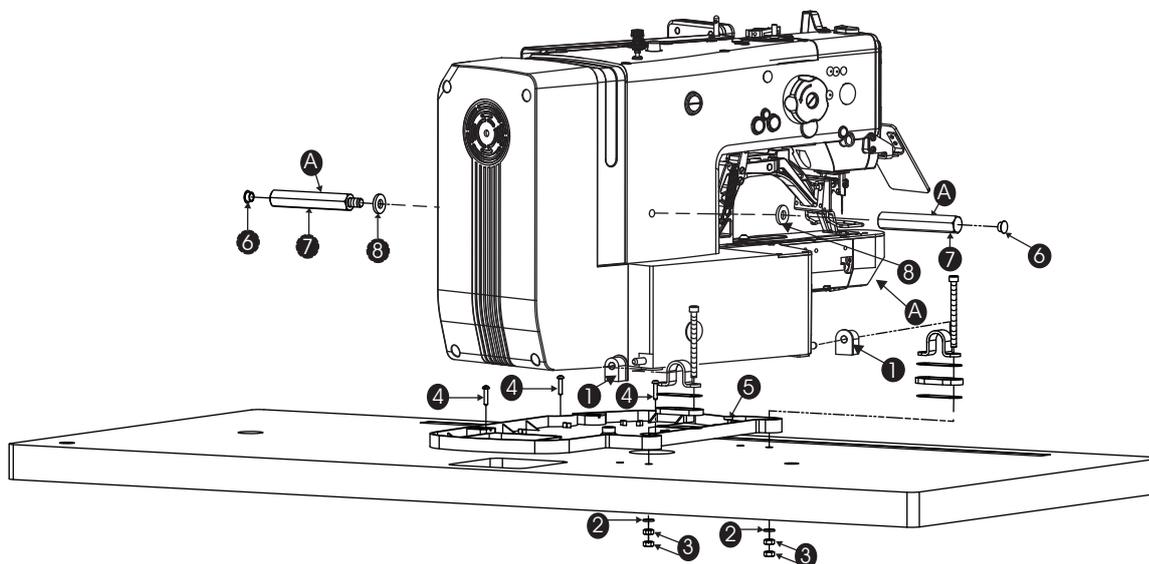


Drive head support rod ① in hole ② in the machine table.

3. Installation of the swing machine head



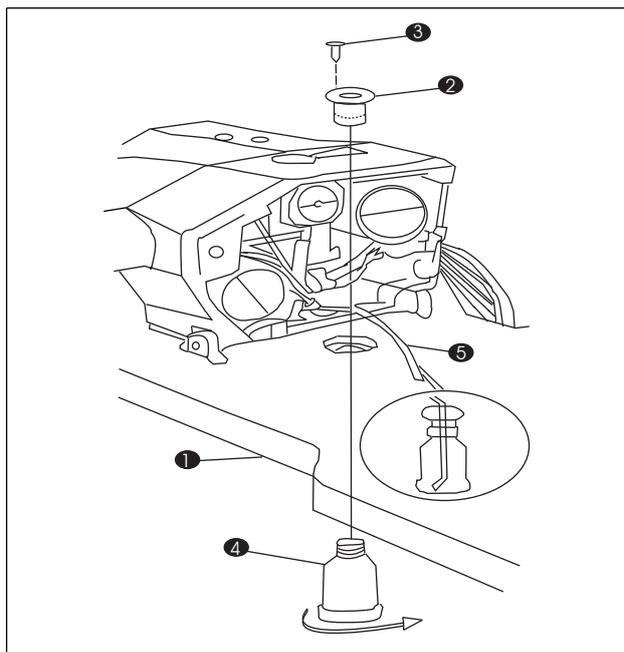
WARNING : To prevent possible accidents caused by the full of the sewing machine, perform the work by two persons or more when the machine is



- 1、 When handling sewing machine, please hold A Department
- 2、 After handling, please remove the handle⑦ and rubber pad⑧, fitted with rubber plug⑥

- (1). The oil plate⑤ with wood screws④ fixed in the corresponding position of the platen.
- (2). Fit hinge rubber ① to the hinge shaft, and fix the swing machine.
- (3). The flat pad ② , nut③ , followed by a fixed, pay attention to the locking nut③ force, if twisted too tightly, then the shock result is not satisfactory.

4. Installing the drain receiver

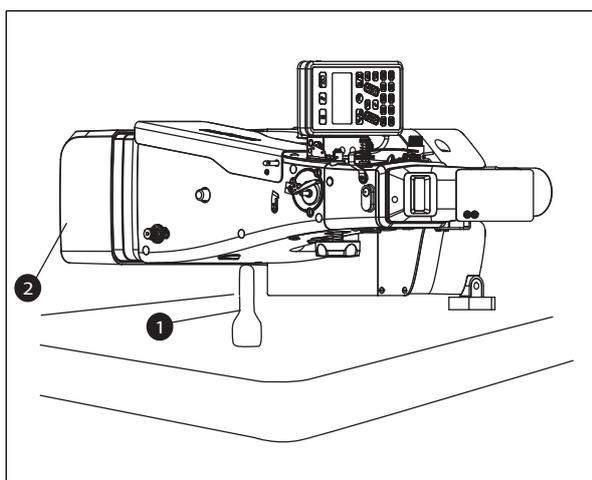


Fix drain receiver ② in the installing hole of table ① with four setscrews③. Screw in drain bin ④ to drain receiver②. Insert sewing machine drain pipe⑤ into drain bin ④ .



Insert drain pipe⑤ until it will go on further so that it does not come off drain bin ④ when tilting the machine head

5. Tilting the sewing machine head

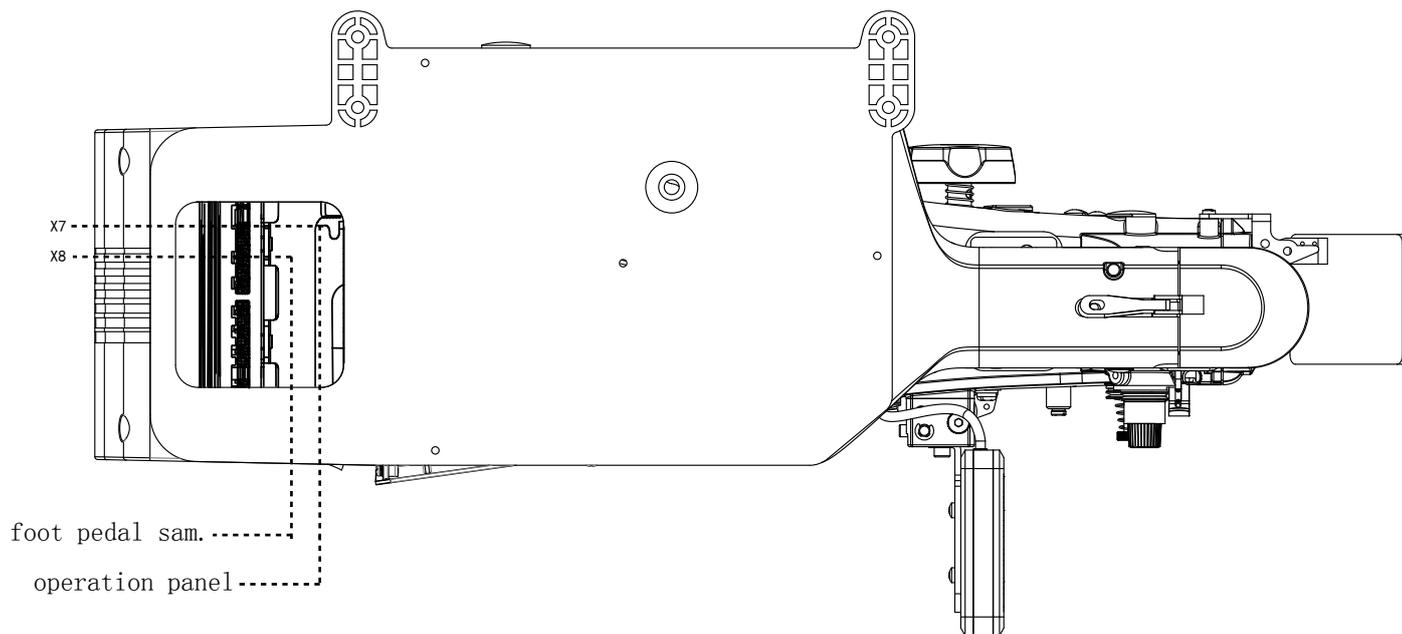


turn head ② gently down , and leaning the head on the head supporting bar at ①.



1. Before tilting the sewing machine head, make sure that head support rod ① is attached to the machine table;
2. When raising the sewing machine head, do not raise it while holding motor cover ②. It will be the cause of breakage of motor cover②.
3. Be sure to tilt the sewing machine head on a flat place to prevent it from falling.

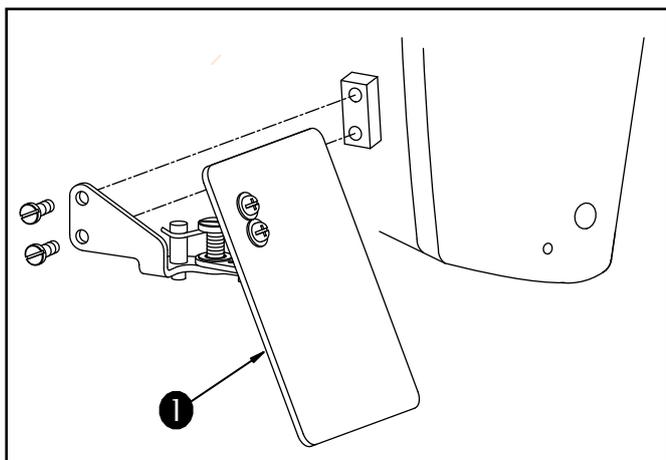
6 Connecting the operation panel



Please let the operation panel line connect with the electronic control box according to online identity, make sure the connection is correct.

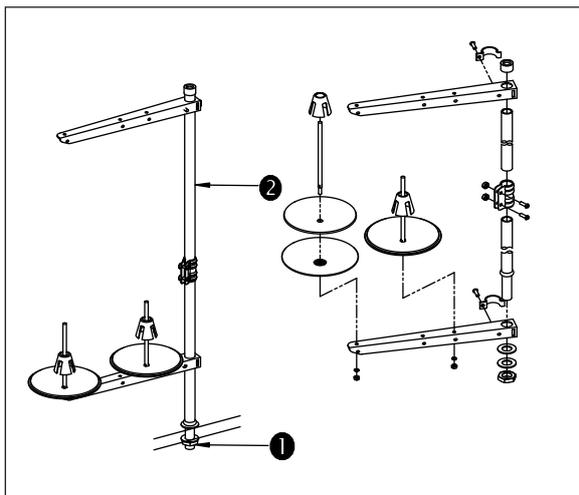
7. Installing the eye protection cover

 **WARNING :** Be sure to attach this cover to protect the eyes from the disperse of needle breakage.



The eye shield in the accessories box should be installed in the head on the left.

8. Installing the thread stand



The line frame in the accessory box should be installed in Table.

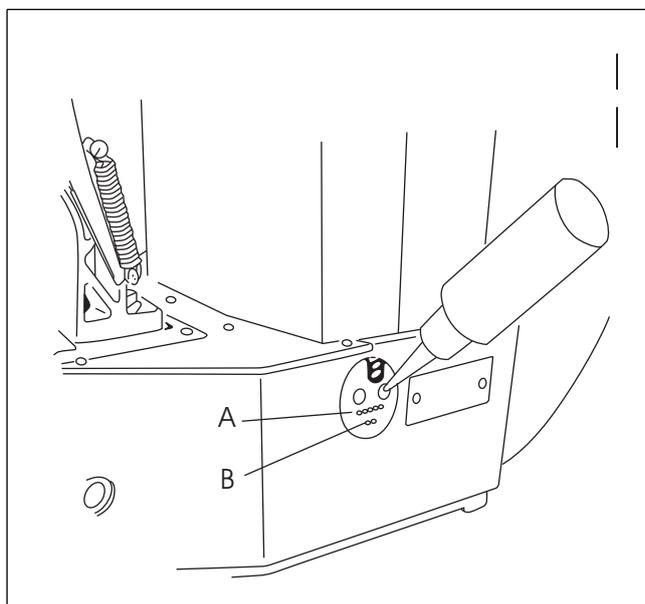
[4] OPERATION OF THE SEWING MACHINE

1. Lubrication



WARNING :

Turn of the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine



Check that the place between lower line Band upper line A is filled with oil . Fill there with oil using the oiler supplied with the machine as accessories when oil is short.

*The oil tank which is filled with oil is only for lubricating to the hook portion. It is possible to reduce the oil amount when the number of rotation used is low and the oil amount in the hook portion is excessive.

(Refer to 7.Adjusting the amount of oil supplied to the hook of[5] MAINTENANCE)

1. DO not lubricate to the places other than the oil tank and the hook of Caution 2 below.

Trouble of components will be caused.

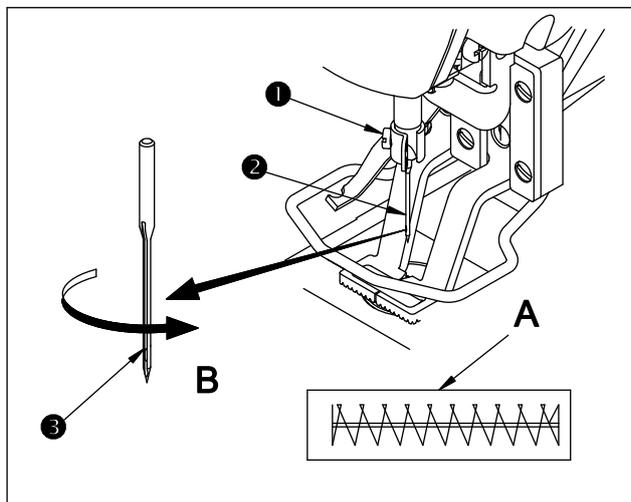


2. When using the sewing machine for the first time or after an extended period of disuse use the machine after lubricating a small amount of oil to the hook portion.(Refer to2.Adjusting the needle-to-shuttle relation of [7]MAINTENANCE

2. Attaching the needle



WARNING : Turn of the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine



Loosen setscrew① and hold needle② with the long groove facing toward you. Then fully insert it into the hole in the needle bar, and tighten setscrew①.

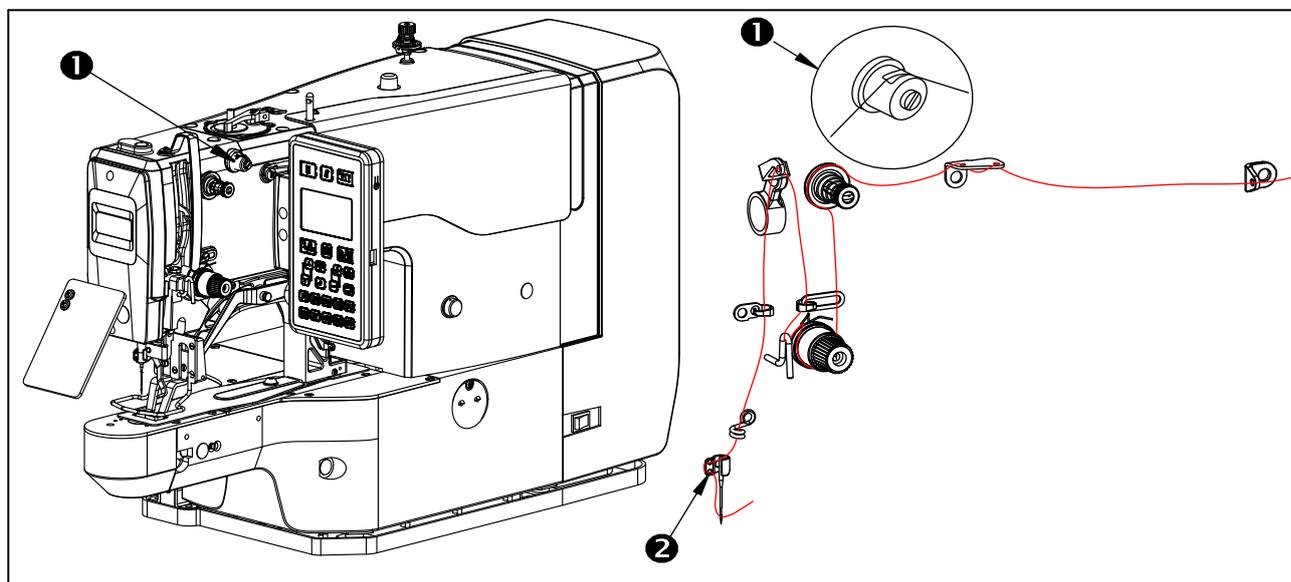


If the stitches are made as shown in "A", attach the needle facing to the direction "B" to a small extent.

3. Threading the machine head



WARNING : Turn of the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine



Pull out the thread by approximately 4cm from the needle after threading through the needle.

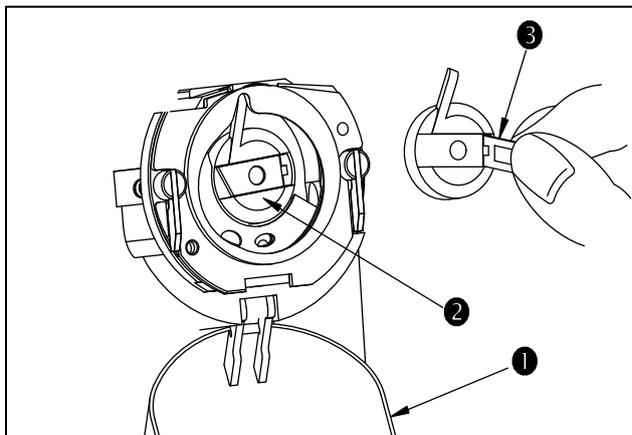


1. When the silicon oil is used, thread through thread guide for silicon①.
2. For thick thread, pass the thread through one hole only of needle bar thread guide②

4. Installing and removing the bobbin case



WARNING : Turn of the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



- (1). Open hook cover①。
- (2). Raise latch③ of bobbin case②, and remove the bobbin case.。
- (3). When installing the bobbin case, fully insert it into the shuttle shaft, and close the latch.

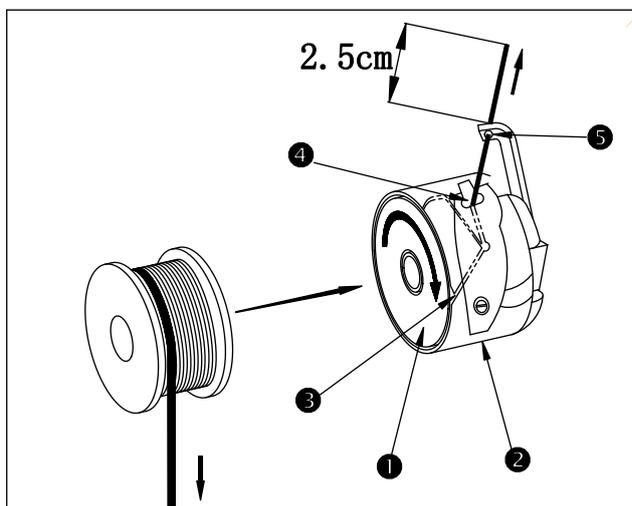


If it is not fully inserted, bobbin case ② may slip off during sewing.

5. Installing the bobbin



WARNING : Turn of the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine

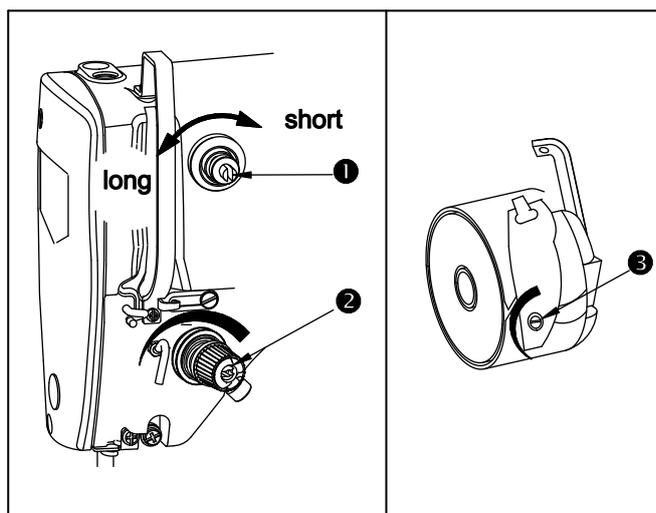


- (1). Set the bobbin ① into bobbin case ② in the direction shown in the figure.
- (2). Pass the thread through thread slit ③ of bobbin case ②, and pull the thread as it is. By so doing, the thread will pass under the tension spring and be pulled out from thread hole ④.
- (3). Pass the thread through thread hole ⑤ of the horn section, and pull out the thread by 2.5cm from the thread hole.



If the bobbin is installed in the bobbin case orienting the reverse direction, the bobbin thread pulling out will result in an inconsistent state.

6. Adjusting the thread tension

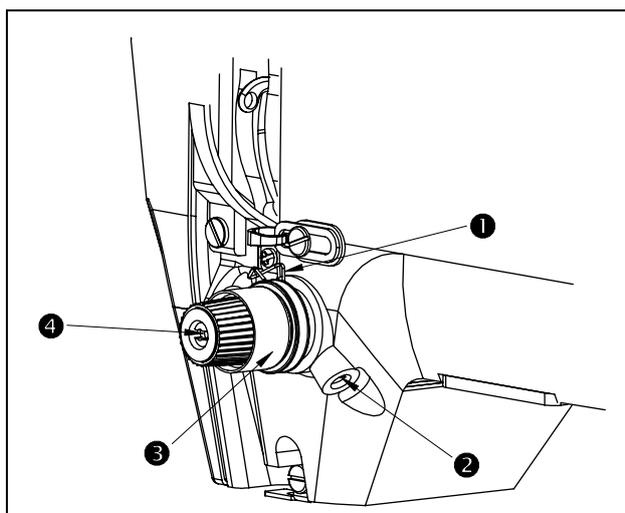


If thread tension controller No.1 ① is turned clockwise, the length of remaining thread on the needle after thread trimming will be shorter. If it is turned counterclockwise, the length will be longer.

Shorten the length to an extent that the thread is not slipped off.

with ② to adjust the upper thread tension, with ③ to adjust the bottom line tension.

7. Adjusting the thread take-up spring



The standard stroke of thread take-up spring ① is 8 to 10 mm, and the pressure at the start is 0.1 to 0.3N.

(1). Adjusting the stroke

Loosen setscrew ②, and turn thread tension asm. ③. Turning it clockwise will increase the moving amount and the thread drawing amount will increase.

(2). Adjusting the pressure

To change the pressure of the thread take-up spring, insert a thin screwdriver into the slot of thread tension post ② while screw ④ is tightened, and turn it. Turning it clockwise will increase the pressure of the thread take-up spring. Turning it counterclockwise will decrease the pressure.

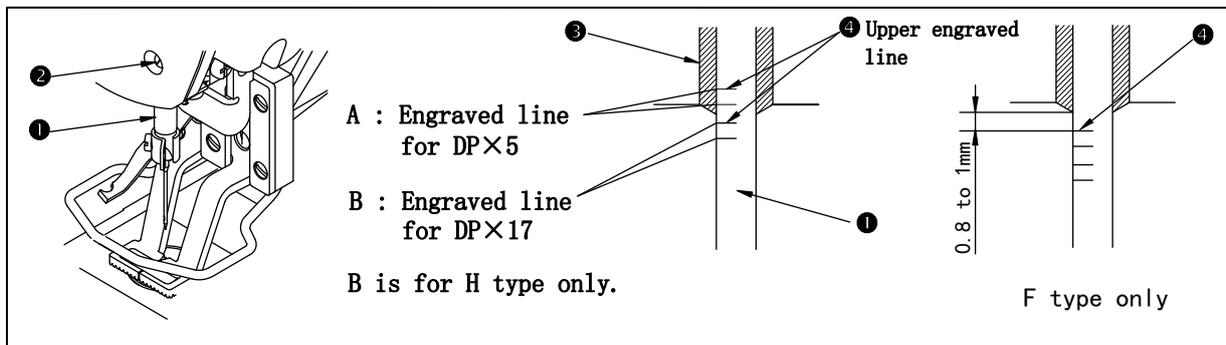
[5] MAINTENANCE

1. Adjusting the height of the needle bar



WARNING :

Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.



Bring needle bar ① to the lowest position of its stroke. Loosen needle bar connection screw ② and adjust so that upper marker line④ engraved on the needle bar aligns with the bottom end of needle bar bushing, lower ③. For F type only, adjust the needle bar to the position where it is lowered by 0.8 mm to 1 mm from the center of upper marker line ④ engraved on the needle bar.



After the adjustment, make sure that there is no uneven torque. When stitch skipping occurs in accordance with the sewing conditions, adjust the height of the needle bar so as to lower it by 0.5 to 1 mm from the needle bar engraved line ④ .

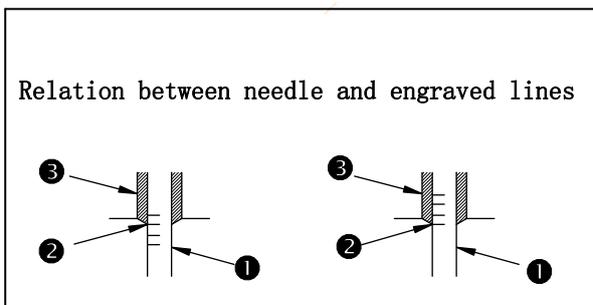
2. Adjusting the needle-to-shuttle relation



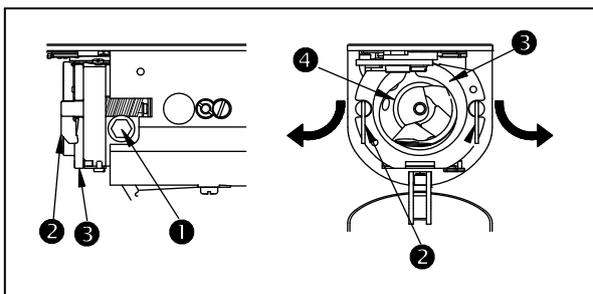
WARNING :

Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.

Relation between needle and engraved lines



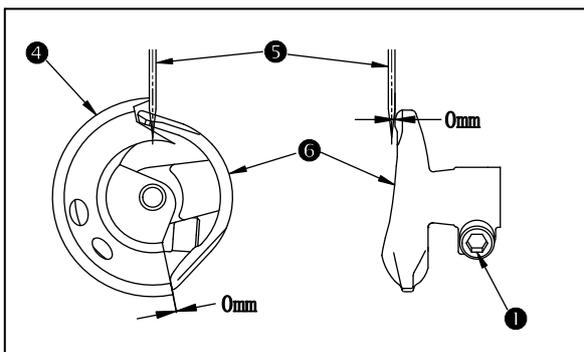
(1). Turn the hand wheel by hand. When needle bar① has gone up, adjust so that lower marker line② engraved on the needle bar aligns with the bottom end of the needle bar bushing ③ , lower.



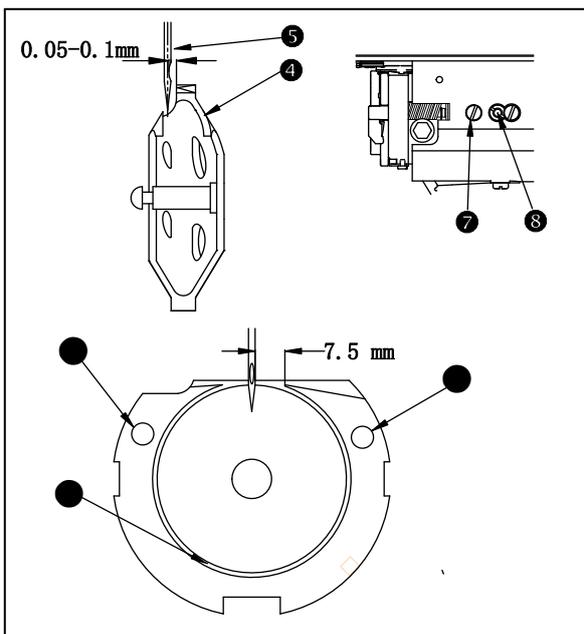
(2). Loosen setscrew ① in the driver. Open inner hook pressers ② to the right and left, and remove inner hook presser ③ .



At this time, be careful not to let inner hook ④ come off and fall.



(3). Adjust so that the blade point of inner hook ④ aligns with the center of needle ⑤, and that a clearance of 0 mm is provided between the front end of the driver and the needle as the front end face of driver ⑥ receives the needle to prevent the needle from being bent. Then tighten setscrew ① of



(4). Loosen setscrew ⑦ of the shuttle, and adjust the longitudinal position of the shuttle. To do this adjustment, turn shuttle race adjusting shaft ⑧ clockwise or counterclockwise to provide a 0.05 to 0.1 mm clearance between needle ⑤ and the blade point of inner hook ④ .

(5). After adjusting the longitudinal position of the shuttle, further adjust to provide a 7.5 mm clearance between the needle and the shuttle by adjusting the rotating direction. Then tighten setscrew ⑦ of the shuttle.



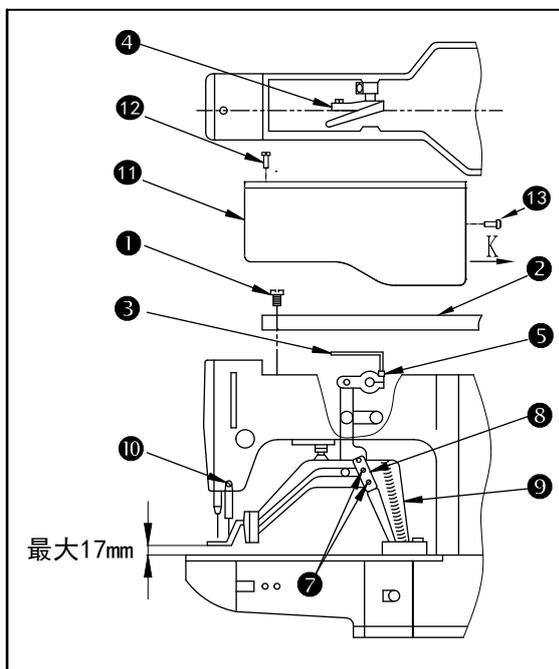
Apply a small amount of oil to race section ⑨ and oil wick ⑩ , and use the sewing machine after an extended period of disuse or cleaning the periphery of hook portion.

3. Adjusting the lift of the work clamp foot



WARNING :

Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.



- (1). With the machine in stop mode, remove two set screws ⑫、⑬ of the right decorative panel⑪, then remove the decorative panel⑪ along the K direction.
- (2). Remove six set screws ① of the top cover, and take off top cover.
- (3). Apply L-shaped wrench ③ to socket bolt ⑤ of clamp ④, and loosen the socket bolt.
- (4). Push down L-shaped wrench ③ to increase the lift of the work clamp foot, or pull it up to decrease the lift.
- (5). After the adjustment, securely tighten socket bolt ⑤.
- (6). If the right and left work clamp feet are not leveled, loosen fixing screw ⑦ and adjust the position of the work clamp foot lever support plate ⑧ to level them.



At this time, be careful not to cause work clamp foot lever support plate ⑧ to interfere with feed bracket ⑨.

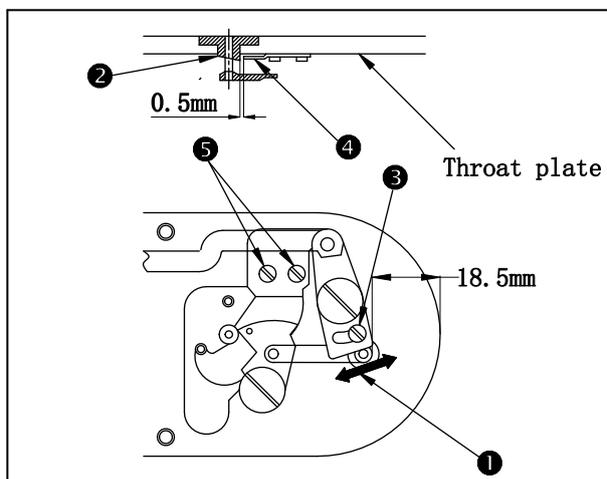
If the work clamp foot lever support plate interferes with the wiper, readjust the height of the wiper using setscrew ⑩ in the wiper installing base.

4. The moving knife and counter knife



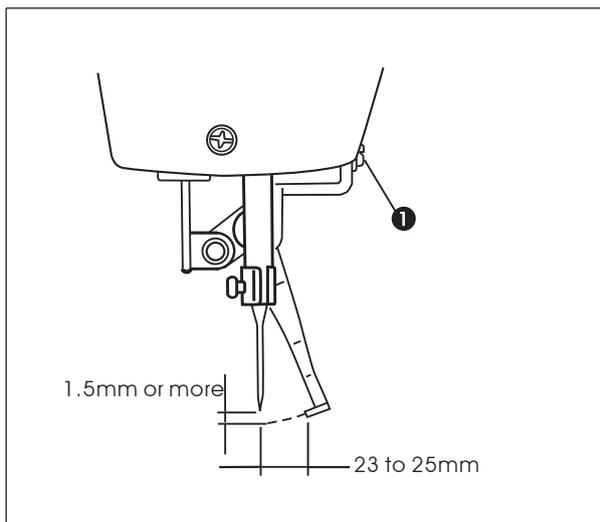
WARNING :

Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.



- (1). Loosen adjusting screw ③ so that a clearance of 18.5 mm is provided between the front end of the throat plate and the top end of thread trimmer lever, small ①. To adjust, move the moving knife in the direction of arrow.
- (2). Loosen setscrew ⑤ so that a clearance of 0.5 mm is provided between needle hole guide ② and counter knife ④. To adjust, move the counter knife.

5. Adjusting the wiper



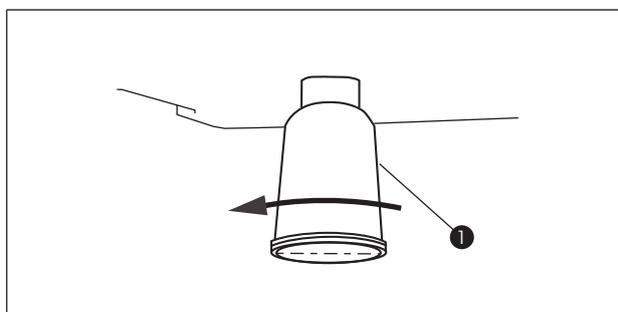
Loosen screw ① to adjust so that a clearance of 1.5 mm or more is provided between the wiper and the needle.

At this time, the standard of the distance between the wiper and the needle is 23 to 25 mm. By adjusting the distance wide, the work clamp foot can prevent stepping on needle thread when it comes down.

Especially when the thin needle is used, adjust the distance wide to such an extent of 23 mm.

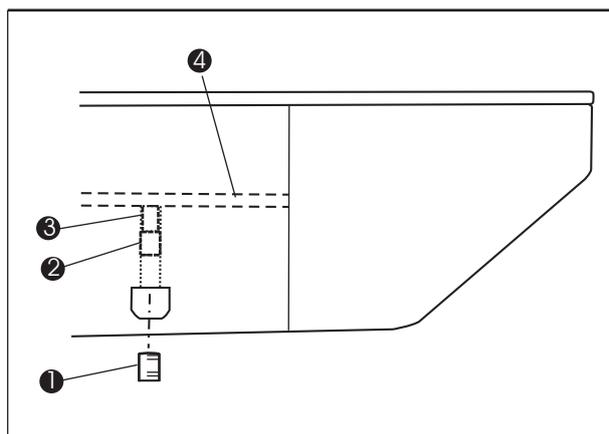
※The position of the needle is when the sewing machine has stopped after the sewing finished.

6. Draining waste oil



When polyethylene oiler ① becomes filled with oil, remove polyethylene oiler ① and drain the oil.

7. Adjusting the amount of oil supplied to the hook



- 1) Loosen setscrew ① and remove setscrew ①.
- 2) When screwing in adjustment screw ②, the amount of oil of oil pipe, left ④ can be reduced.
- 3) After the adjustment, screw in setscrew ① and fix it.

1. The state of standard delivery is the position where ② is lightly screwed in and returned by 4 turns.



2. When reducing the amount of oil, do not screw in the screw at once. Observe the state for approximately half a day at the position where ② is screwed in and returned by 2 turns. If reducing is excessive, worn-out of the hook will result.

8. Replenishing the designated places with grease

When the sewing machine has been used for a certain number of times of sewing, error code No. E221 is displayed on the operation panel at the time of turning ON the power. This display informs the operator of the time of replenishing the designated places with oil. Be sure to replenish the places with the oil below. Then call the memory switch No. 245 and set it to "0" with the RESET key. Even after the display of the error No. E221, when the RESET key is pressed, the error is released, and the sewing machine can be continuously used. Afterwards, however, the error No. E221 is displayed every time the power is turned ON.

In addition, when the sewing machine is used further for a certain period of time after the display of error No. E220, the error No. E221 is displayed and the sewing machine fails to operate since the error cannot be released even when the RESET key is pressed.

When the error No. E221 is displayed, be sure to replenish the designated places below with oil. Then start up the memory switch and set No. 245 to "0" with the RESET key.

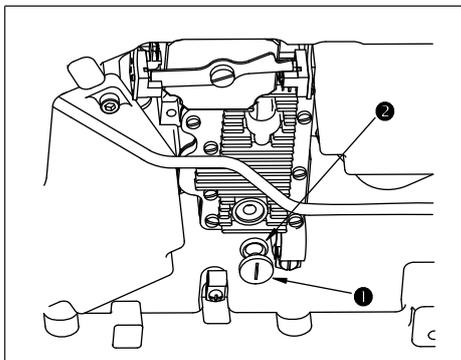


After replenishing the places with oil, the error No. E220 or No. E221 is displayed again unless the memory switch No. 245 is changed to "0".



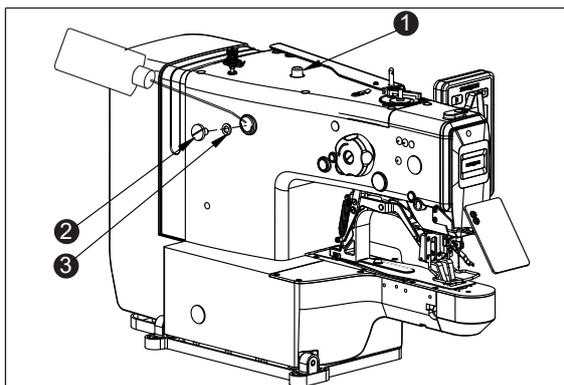
WARNING : Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.

(1) . Outflow the residual oil in gearbox



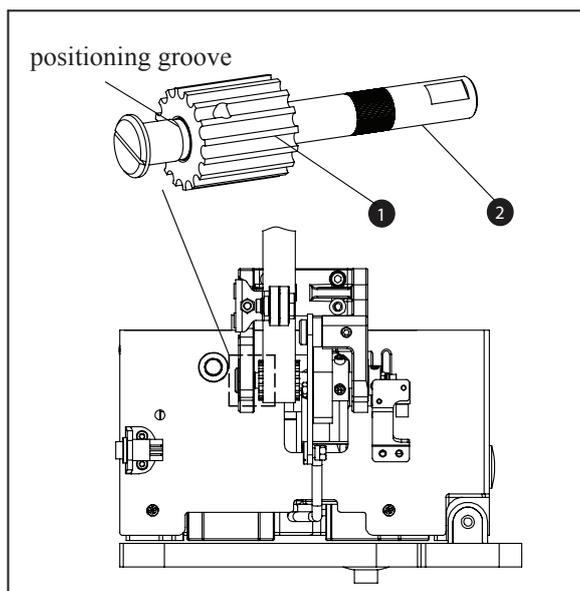
- 1) Tilt the machine, remove the screws ① and seal ②.
- 2) put back sewing machine, outflow the residual oil in the gearbox.
- 3) tilt the machine again, put back the seals ② and screws ①, then put sewing machine back to the position.

(2) . Lubricate the upper gearbox



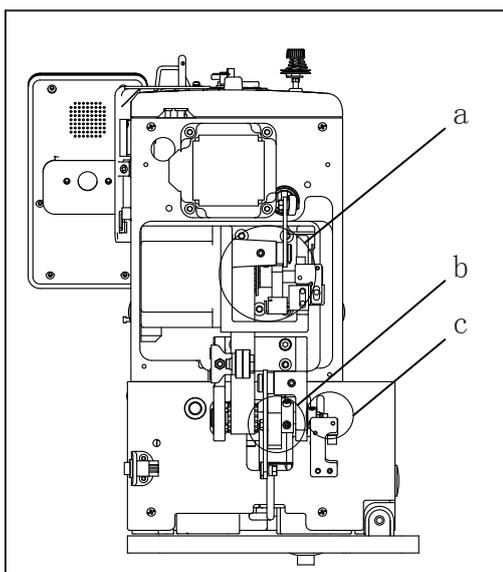
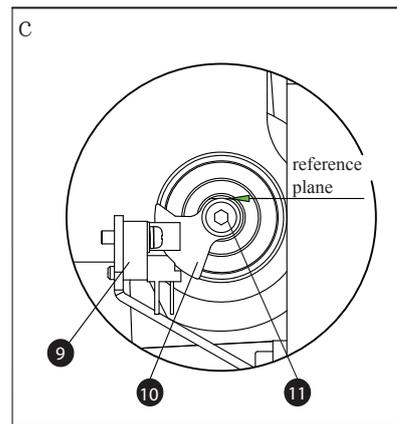
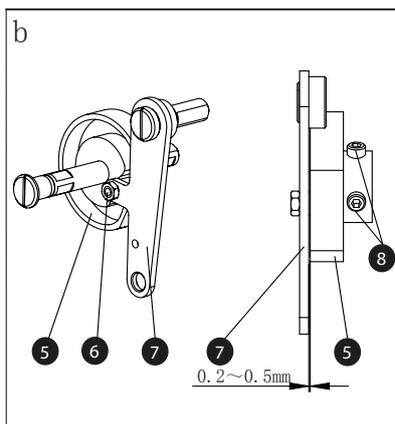
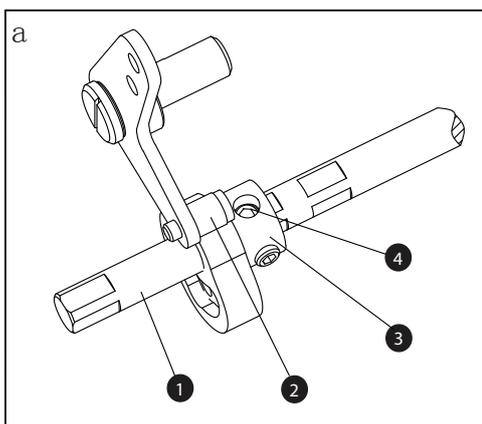
- 1) When through the oil window ①, you can not find oil outlet obviously, or it is without oil outlet, you should add the oil into the wheel gear box.
- 2) Turn off the machine, you can take down the screw ② and the rubber washer ③, when it is without oil outlet, please add 100ml 10# white oil; when it is not oil outlet obviously, please add 50-70ml. Please install back ② and ③ parts, turn on the machine and check whether it is happened to oil outlet or not.

9. Adjusting the position of the shear- driving pulley



Keep the left end of the shear-driving pulley ① aligned with the right end of the positioning groove that in the shear-driving shaft ②, Then tighten the screw on the shear-driving pulley.

10. Position the wire-trimming cam and the wire-trimming safty plate



(1) Adjusting the wire-trimming cam

- 1) Rotate the shaft of lifting motor ① to turn the lifting cam ③ to the lowest point of contact with the lift roller ②. The screw ④ is facing vertically upward, as shown in the figure a.
- 2) Adjusting the roller ⑥ to the bottom of the the groove of the trimming cam ⑤.
- 3) Tighten two screws ⑧ of the trimming cam after adjusting the distance between the trimming crank ⑦ and the end of trimmin ④ g cam ⑤ to be about 0.2-0.5mm, as shown in the figure b.

(2) Adjusting the wire-trimming safty plate

- 1) Rotate the lift motor shaft to turn the lift cam to the lowest point of contact with the lift roller, this moment the screw is facing directly above.
- 2) Positioning reference plane of the trimming safety sensor ch horizontally upwards, and placing the trimming safety sensor chip in the trimming safety sensor, as shown in figure c, then locking the screw to fix the trimming safety sensor.

3)When the foot pedal is pressed for the first time,presser foot is pressed down, and the trimming safety sensor chip does not enter the trimming safety sensor. When the foot pedal is pressed for the second time, the machine starts to sew ,and if there is an alarm that the machine is trimming abnormality,Please loosen the screw and adjust the position of the trimming sensor chip in the clockwise direction.

[6]. Table of the standard clamp foot

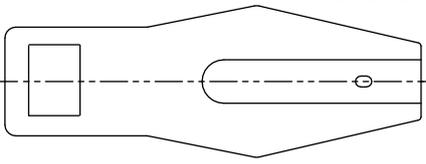
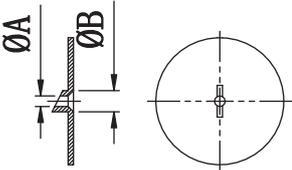
	1	2	3	4	5
Work clamp foot	Left: 10011508 Right: 10011505			10011687、10011691	10011758、10011759
Feed plate	10011565	10012300	10012279	10011751	10011755
	With knurl	Without knurl	Without knurl	With knurl	With knurl
Sewing specification	S	F	F	H	M
Finer guard	10011556(S、M、F)、10011695 (H)				
Remarks	Standard accessory for S type machine head.	Supplied with F type machine head. (Depends on the destination)		Optional	Standard accessory for M (knit goods) type machine head.

	6	7	8	9	10	11
Work clamp foot	10012349(L) 10012342(R)		10012339(L) 10012346(R)	10012341(L) 10012348(R)		10026244(L) 10026245(R)
Feed plate	10012277	10012302	10012286	10012296	10012301	10026246
	With knurl	With knurl	With knurl	Without knurl	Without knurl	Without knurl
Sewing specification	S	H/W	S	F	F	F
Finer guard	10011556(S、M、F)、10011695 (H、W)					

Remarks	Optional	Standard accessory for H type(heavy-weight material) machine head.	Optional	Accessory part for F(foundation)type.(Depends on the destination)	Optional
	12	13	14	15	16
Work clamp foot	10026247(L) 10026248(R)	10026250(L) 10026251(R)	10012344(L) 10012345(R)	10026253(L) 10026254(R)	10026256(L) 10026257(R)
Feed plate	10026249	10026252	10012338	10026255	10026258
	Without knurl	Without knurl	Without knurl	Without knurl	Without knurl
Sewing specification	F	S	S	S	S
Finger guard	10011556				
Remarks	Optional	Optional	Optional	Optional	Optional

※ Install a finger suitable for each work clamp foot when replacing the work clamp foot.

[7] Table of the optional parts

Name of Parts	Type	Part No.	Remarks
Feed plate blank t=1.2 	With knurl / processed Sewing area lengthwise 20 X crosswise 40	10012303	
	With knurl / processed Sewing area lengthwise 30 X crosswise 40	10014401	
Needle hole guide 	A=1.9 B=2.8 Without relief slit	10047532	Standard type
	A=1.6 B=2.0 Without relief slit	10011757	F and M types
	A=2.3 B=4.0 Without relief slit	10004727	H and W types
	A=3 B=7 Without relief slit	10007281	For net machine
	A=1.6 B=2.6 With relief slit	10004646	Selective spare part

II. EXPLANATION OF THE COMPUTER-CONTROLLED HIGH SPEED LOCKSTITCH BUTTON SEWING MACHINE

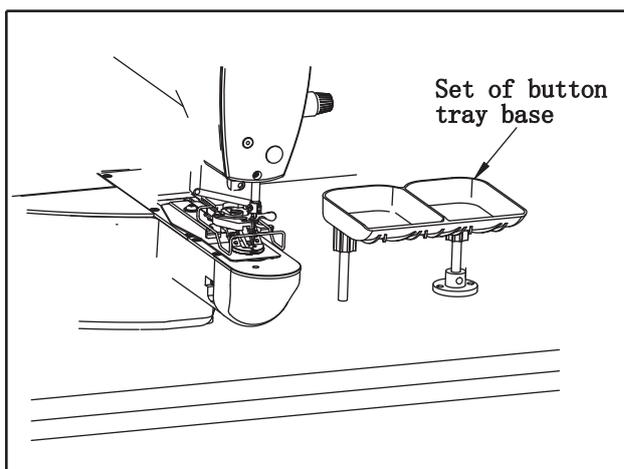
[1] Specifications

Different specifications from those of the bartacking machine only are described.

- 1) Sewing speed Max. 2700rpm
- 2) Needle DPx17 #14
- 3) Lifting method of the work clamp foot..... Stepping motor
- 4) Lift of the work clamp foot Max. 13mm
- 5) Number of standard patterns50 patterns
- 6) Wiper method Interlocked with work clamp foot lifter driven by stepping motor

[2] Installation of the sewing machine and preparation of the operation

 **WARNING :** Be sure to perform the work with two persons or more when moving the sewing machine



(1). Installation of the sewing machine head is same as that of the bartacking machine.

Refer to the instruction manual for the bartacking machine.

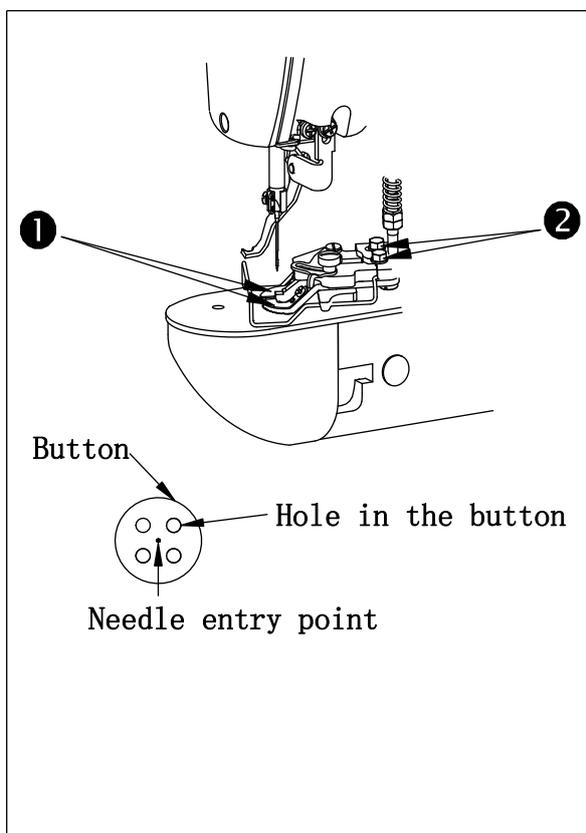
(2). Install a set of the button tray base to a convenient place for the work as the set is included in the accessories

 **Make sure before operation that the needle does not strike against the button hole .**

[3] Needle and thread

Needle	Needle thread	Bobbin thread
DPx17 #14	#60	#80
	#60	#60
	#50	#60
	#40	#60

Needle and thread will vary in accordance with the sewing conditions. when using the needle and the thread, select them referring to the left table. Cotton thread and polyester spun thread are recommended.

[4] Position of the button clamp jaw lever

1). Place a button in button clamp jaw levers ①.

2). With sewing LED goes off, press  key in the operation panel, then press  key to make machine find the zero position.

3). Turn the hand pulley and check that the center of the needle enters the center of the button.

4). If the center of the needle is not located in the center of the button, loosen screws ② in the button clamp jaw lever base to adjust so that the center of the needle enters the center of the button.

5). After the adjustment, perform the confirmation of the pattern shape and make sure that the needle surely has entered the button hole.

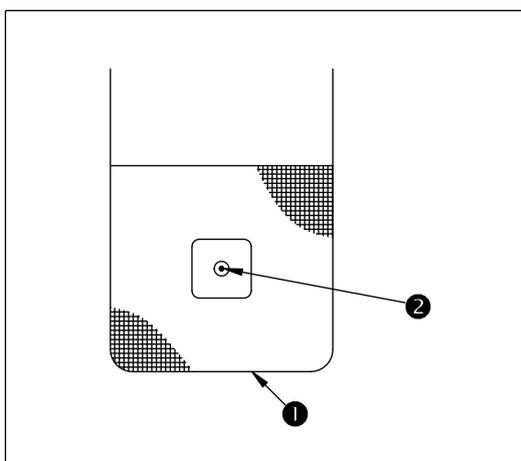
WARNING: When change of the shape of button, change of the sewing pattern or



enlargement/reduction of the sewing width is performed, make sure the needle entry point. If the needle extends outside the button hole or the sewing pattern extends outside the button clamp unit, the needle interferes with the button hole or the button clamp unit, resulting in the danger of the needle breakage or the like.

[5] Adjusting the feed plate

WARNING: When change of the shape of the button, change of the sewing pattern or enlargement/reduction of the sewing width is performed, make sure of the shape of the sewing pattern. If the feed plate interferes with the needle hole guide, it will result in the danger of the needle breakage or the like. Also, if the pedal is depressed during the adjustment, the button clamp unit will go up or come down. So, be careful.



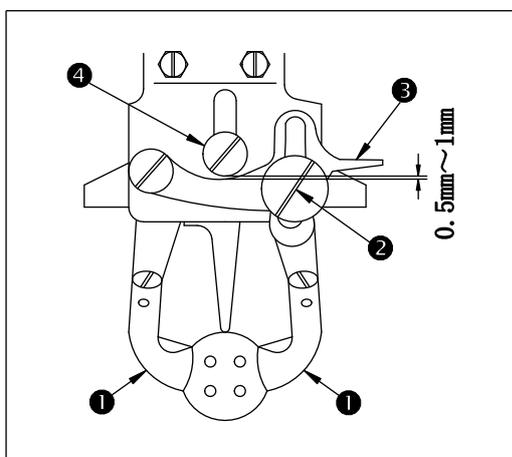
1) .With sewing LED goes off ,press  key in the operation panel,then press  key to make machine find the zero position.

2). adjust the feed plate ①, so the needle hole guide ② comes to the center of the recessed part of feed plate ①H.

[6] Adjusting the open angle of the button clamp jaw lever



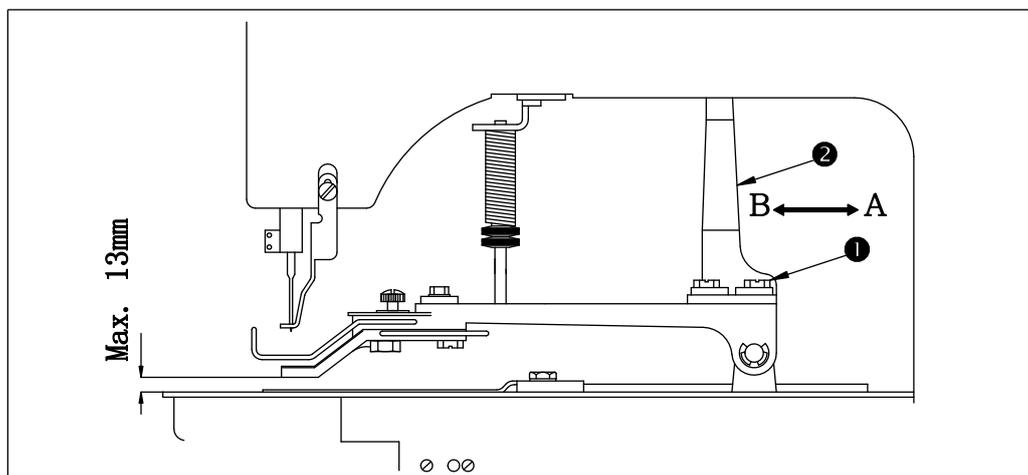
WARNING : Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.



Bring the machine to its stop-motion state. Then lift button clamp ①. Loosen screw ② in the button clamp jaw lever and adjust so that a clearance of 0.5 to 1mm is provided between button clamp jaw lever ③ and hinge screw ④ when placing a button in between button clamps ①. Then tighten screw ② in the button clamp jaw lever.

[7] Adjusting the lifting amount of the button clamp

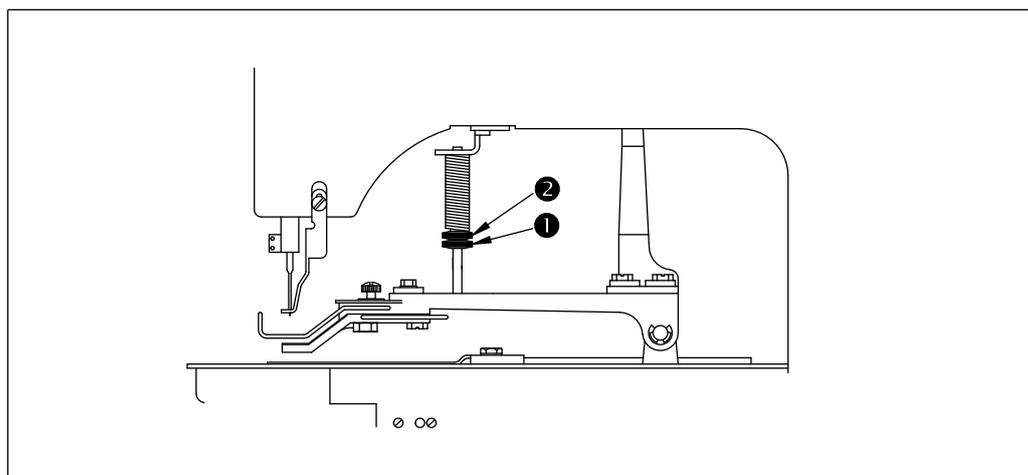
WARNING : Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.



Loosen two setscrews ①, and move moving plate ② back and forth in the direction of arrow to adjust. The lifting amount of the button clamp will be decreased when moving plate ② is moved in the direction "A", and be increased when it is moved in the direction of "B". After the adjustment, securely tighten setscrews ①.

[8] Adjustment of the pressure of the work clamp unit

WARNING : Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.

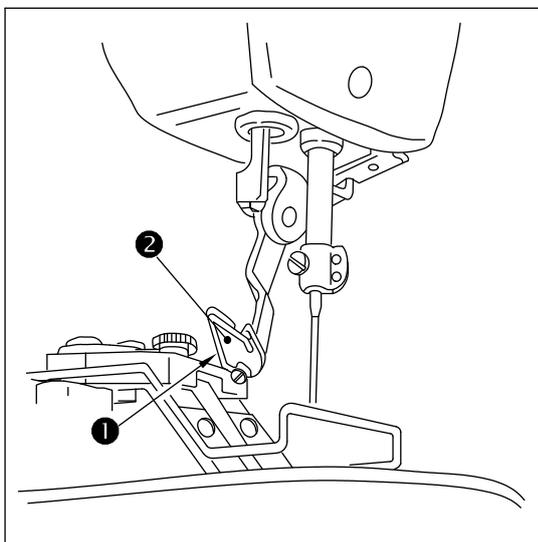


The pressure of the work clamp unit should be minimized as long as the material does not warp during sewing. Loosen adjusting screw ① and turn adjusting screw ② to obtain the aforementioned pressure.

[9] Adjusting the wiper spring



WARNING : Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.



Wiper spring① retains the needle thread after thread trimming in between wiper② and the wiper spring. Correct properly the tension after wiper spring ① so that the tension at that time becomes 20 to 30 g(a little higher tension than that of the bobbin thread coming out of the bobbin case.



If the retaining of the needle thread is excessive, the thread may protrude from the upper side of the button.

[10] Button sewing scope

Model		Button sewing Machine	
Button size classification		For medium-sized buttons	
Outside diameter of applicable buttons (mm)		Ø8~Ø22	
Sewing size (mm)	0~3.5	0 to 3.5	
	0~3.5	0 to 3.5	

III.TROUBLES AND CORRECTIVE MEASURES(SEWING CONDITIONS)

Trouble	Cause	Corrective measures
1.The needle thread slips off at the start of bar-tacking	<ul style="list-style-type: none"> ① Stitches are slipped at the start ② The needle thread remaining on the needle after thread trimming is too short. ③ The bobbin thread is too short. ④ Needle thread tension at 1st stitch is too high. ⑤ Pitch at 1st stitch is too small. 	<ul style="list-style-type: none"> ○ Adjust the clearance between the needle and the shuttle to 0.05 to 0.1mm. ○ Set soft-start sewing at the start of bar tacking. ○ Correct the thread tension release timing of the thread tension controller No.2. ○ Increase the tension of the thread take-up spring, or decrease the tension of the thread tension controller No.1. ○ Decrease the tension of the bobbin thread. ○ Increase the clearance between the needle hole guide and the counter knife. ○ Decrease the tension at 1st stitch. ○ Decrease the number of rotation at 1st stitch at the sewing start. ○ Make the pitch at 1st stitch longer. ○ Decrease the needle thread tension at 1st stitch.
2.Thread often breaks or synthetic fiber thread splits finely.	<ul style="list-style-type: none"> ①The shuttle or the driver has scratches. ②The needle hole guide has scratches. ③The needle strikes the work clamp foot. ④Fibrous dust is in the groove of the shuttle race. ⑤The needle thread tension is too high. ⑥The synthetic fiber thread take-up spring is too high. ⑦The synthetic fiber thread melts due to heat generated on the needle. 	<ul style="list-style-type: none"> ○Take it out and remove the scratches using a fine whetstone or buff. ○Buff or replace it. ○Correct the position of the work clamp foot. ○Take out the shuttle and remove the fibrous dust from the shuttle race. ○Reduce the needle thread tension. ○Reduce the tension. ○Use silicone oil .
3.The needle often breaks.	<ul style="list-style-type: none"> ①The needle is bent. ②The needle hits the work clamp foot. ③The needle is too thin for the material. ④the driver excessively bends the needle. 	<ul style="list-style-type: none"> ○Replace the bent needle. ○Correct the position of the work clamp foot. ○Replace it with a thicker needle according to the material. ○Correctly position the needle according to the material. ○Widen the distance between the needle and the

	⑤Needle thread is stepped on by the work clamp foot at the start of sewing (Needle bend)	wiper.(23 to 25mm)
4. Threads are not trimmed.	①The counter knife is dull. ②The difference in level between the needle hole guide and the counter knife is not enough. ③The moving knife has been improperly positioned. ④The last stitch is skipped. ⑤Bobbin thread tension is too low.	○Replace the counter knife. ○Increase the bend of the counter knife. ○Correct the position of the moving knife. ○Correct the timing between the needle and the shuttle. ○Increase the bobbin thread tension.
5. Stitch skipping often occurs.	①The motions of the needle and shuttle are not properly synchronized. ②The clearance between the needle and shuttle is too large. ③The needle is bent. ④The driver excessively bends the needle.	○Correct the positions of the needle and shuttle. ○Correct the positions of the needle and shuttle. ○Replace the bent needle. ○Correctly position the driver.
6. The needle thread comes out on the wrong side of the material	①the needle thread tension is not high enough. ②The tension release mechanism fails to work properly. ③The needle thread after thread trimming is too long. ④Number of stitches is too few. ⑤When sewing length is short(End of needle thread protrudes on the wrong side of sewing product.) ⑥Number of stitches is too few.	○Increase the needle thread tension. ○Check whether or not the tension disc No.2 is released during bar-tracking. ○Increase the tension of the thread tension controller No.1. ○Correct the position of the moving knife. ○Use the lower plate, the hole of which is larger than the presser.

Trouble	Cause	Corrective measures
7. Threads break at time of thread trimming	①The moving knife has been improperly position.	○Correct the position of the moving knife.
8. Uneven length of the needle thread	①The tension of thread take-up spring is too low.	○Increase the tension of the thread take-up spring.
9. The length of needle thread does not become short	①The tension of thread tension controller No.1 is too low. ②The tension of thread take-up spring is too high. ③The tension of thread take-up spring is too low and motion is unstable.	○Increase the tension of thread tension controller No.1. ○Decrease the tension of thread take-up spring. ○Increase the tension of thread take-up spring and lengthen the stroke as well.

零件手册

PARTS BOOK

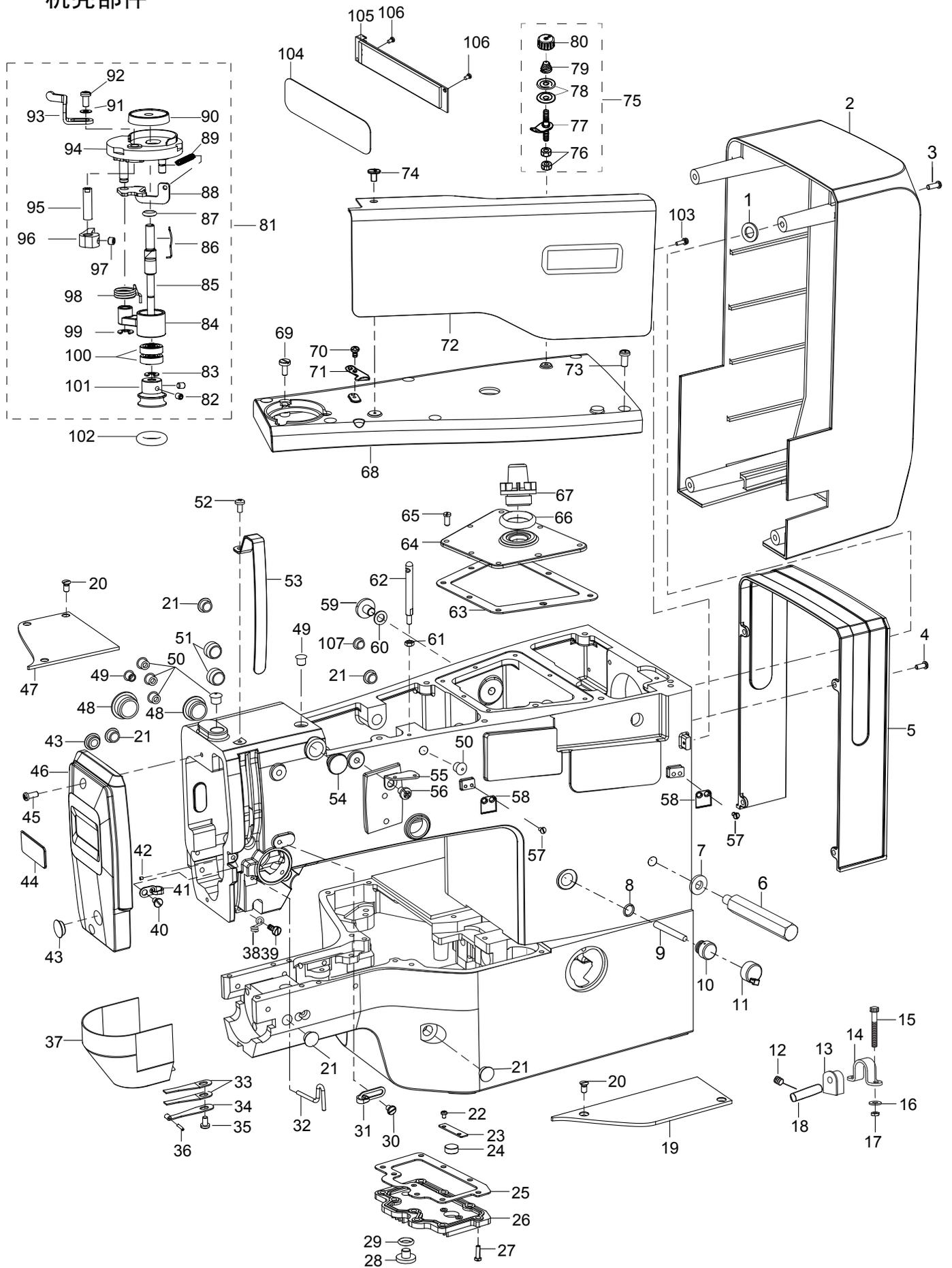
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1. FRAME&MISCELLANEOUS COVER COMPONENTS

机壳部件



1. 机壳部件FRAME&MISCELLANEOUS COVER COMPONENTS

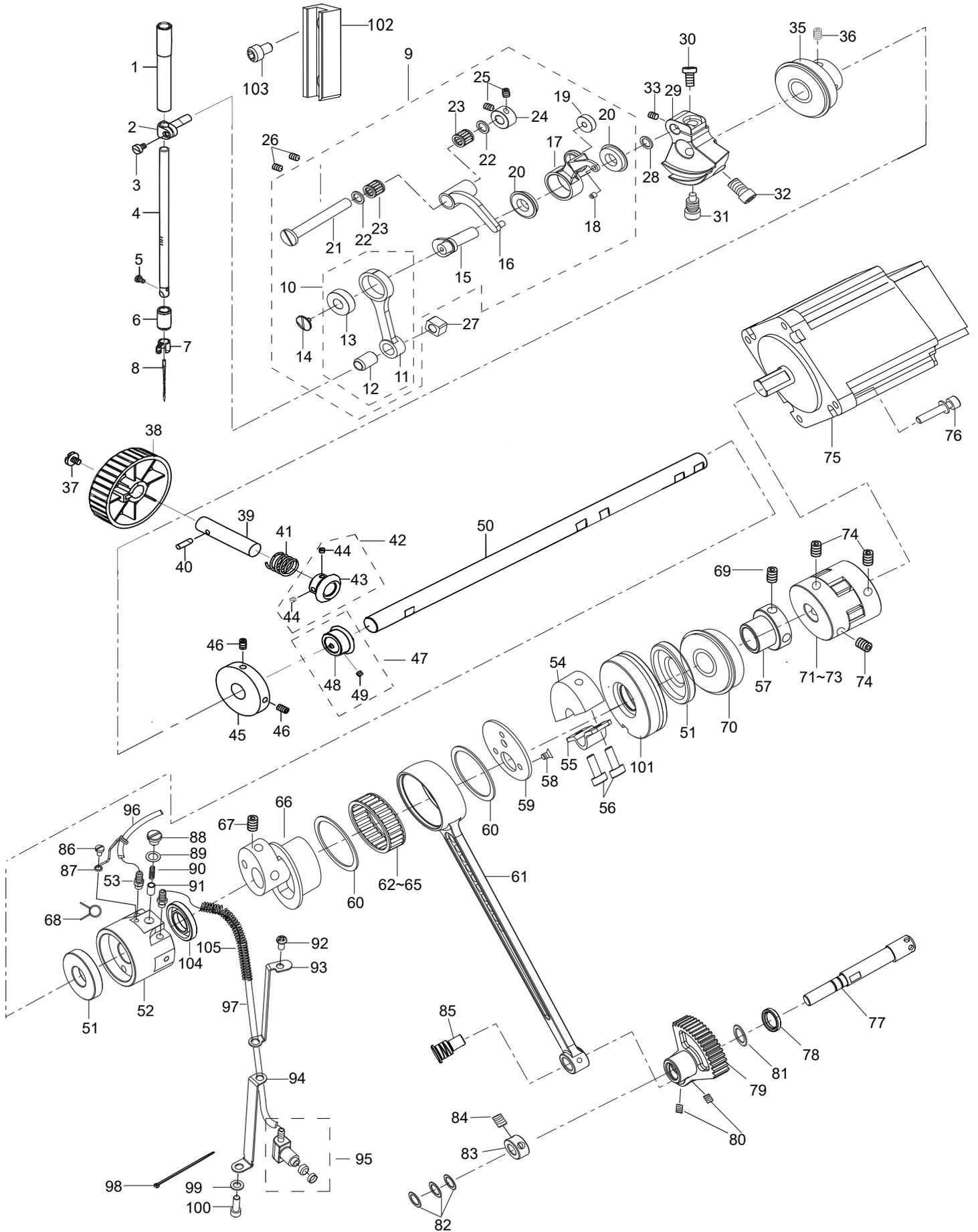
序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10011135	垫片	STOPPER	1
2	10062668	后罩	MOTOR COVER	1
3	10010900	螺钉 SM11/64"×40 L=12	SCREW SM11/64"×40 L=12	4
4	10042268	止退圈紧固螺钉	SCREW M4×10	4
5	10071607	后装饰板☆	THE BACK PANEL	1
6	10052703	手柄	HAND SHANK	2
7	10028127	橡胶垫 $\phi 8 \times \phi 20 \times 3.5$ 0	RUBER WASHER $\phi 8 \times \phi 20 \times 3.5$	2
8	10012139	形圈	RUBBER RING	1
9	10021559	销	PIN	1
10	10002483	排气阀	EXHAUST VALVE	1
11	10008771	橡胶盖	RUBBER COVER	1
12	10011232	螺钉	SCREW	2
13	10011137	机头胶垫	HINGE RUBBER	2
14	10011160	支撑固定架	BED HINGE	2
15	10011147	螺钉	SCREW	4
16	10003076	垫圈	WASHER	4
17	10003084	螺母	NUT	8
18	10011141	销	PIN	2
19	20026582	底板右盖板	THE RIGHT BED PANEL	1
20	10011566	螺钉	SCREW	5
21	10011136	橡胶塞 $\phi 10.5$	RUBBER PLUG $\phi 10.5$	4
22	10042310	下过线板螺钉	SCREW	2
23	10001242	垫板	PLATE	1
24	10001096	磁铁	MAGNET	1
25	10037232	齿轮箱盖密封垫	GEAR BOX SEAL GASKET	1
26	10037233	齿轮箱底盖	GEAR BOX COVER	1
27	10000560	螺钉 SM11/64"×40 L=16	SCREW SM11/64"×40 L=16	9
28	10008783	螺钉	SCREW	1
29	10010240	O形圈	RUBBER RING	1
30	10011142	螺钉	SCREW	1
31	10008940	右线钩	THE RIGHT THREAD GUIDE	1
32	10037247	拦线钩	L-SHAPED THREAD GUIDE	1
33	10010807	梭床罩弹簧B	HOOK COVER PRESSER SPRING B	1
34	10011420	梭床罩弹簧A	HOOK COVER PRESSER SPRING A	1
35	10010808	螺钉	SCREW	1
36	10010815	销	PIN	1
37	20023956	梭床罩焊合	SHUTTLE RACE CAP	1
38	10011139	下过线勾	THREAD GUIDE	1
39	10010668	螺钉	SCREW	1
40	10011142	螺钉	SCREW	1
41	10014281	中线钩	THE MID THREAD GUIDE	1
42	10011887	螺钉	SCREW	1
43	10011099	橡胶塞 $\phi 12.5$	RUBBER PLUG $\phi 12.5$	2
44	10070679	面板装饰牌☆	PLATE	1
45	10011150	螺钉	SCREW	2
46	20023811	面板	FACE COVER	1
47	20023934	底板左盖板	THE LEFT BED PANEL	1
48	10011146	橡胶塞 $\phi 20.8$	RUBBER PLUG $\phi 20.8$	2
49	10011188	橡胶塞 $\phi 7.4$	RUBBER PLUG $\phi 7.4$	2
50	10010587	橡胶塞 $\phi 8.5$	RUBBER PLUG $\phi 8.5$	5
51	10014279	橡胶塞 $\phi 15.3$	RUBBER PLUG $\phi 15.3$	2
52	10011150	螺钉 SM11/64"×40 L=10	SCREW SM11/64"×40 L=10	1
53	10062652	挑线杆防护罩	BALANCE COVER	1
54	10011190	橡胶塞 $\phi 14.5$	RUBBER PLUG $\phi 14.5$	1

1. 机壳部件FRAME&MISCELLANEOUS COVER COMPONENTS

序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
55	10011200	上过线板	THREAD GUIDE PLATE	1
56	10011158	螺钉	SCREW	1
57	10053628	SM9/64"×40螺钉 L=5.5	SCREW SM9/64"×40 L=5.5	4
58	10062675	卡紧扣	THE LOCKING PLATE	2
59	10051608	螺钉 SM5/16"×24 L=10	SCREW SM5/16"×24 L=10	1
60	10009988	橡胶垫 $\phi 7.8 \times \phi 13.5 \times 1.3$	RUBBER WASHER $\phi 7.8 \times \phi 13.5 \times 1.3$	1
61	10009471	M4螺母 (GB/T 6170-2000)	NUT (GB/T 6170-2000)	1
62	10062648	过线柱	THREAD GUIDE	1
63	10037218	上密封盖板垫	UPPER SEAL GASKET	1
64	10051609	上密封盖板	UPPER SEAL PLATE	1
65	10013977	螺钉	SCREW	7
66	10008939	O形圈	RUBBER RING	1
67	10012438	油窗	OIL TANK	1
68	20023812	上盖	TOP COVER	1
69	10011101	螺钉	SCREW	3
70	10011143	螺钉	SCREW	1
71	10011149	绕线切刀	THREAD CUTTER	1
72	20025162	右装饰板	THE RIGHT PANEL	1
73	10011161	螺钉	SCREW	6
74	10012599	螺钉	SCREW M5×7.8	2
75	10062647	M5×7.8夹线器	BOBBIN THREAD TENSION ASM	1
76	10004507	螺母	NUT	2
77	10004504	中过线板组件	BOBBIN THREAD TENSION ROD ASM	1
78	10004393	夹线板	THEAD TENSION DISK	2
79	10004391	弹簧	CONNECTING ROD SPRING	1
80	10062660	夹线螺母组件	NUT	1
81	10002558	绕线器	BOBBIN WINDER ASM	1
82	10002896	螺钉	SCREW	2
83	10007895	挡圈	E-RING	1
84	10027388	摆动连杆	BOBBIN WINDER SHAFT COMPL BOBBIN	1
85	10031163	梭芯卷绕轴弹	SHAFT	1
86	10031058	簧	SPRING	1
87	10027399	O型圈	RUBBER RING	1
88	10027391	控制板	ADJUSTING PLATE	1
89	10027394	弹簧	SPRING	1
90	10027390	卷绕轴垫	CUSHING	1
91	10003122	垫圈	WASHER	1
92	10009455	螺钉	SCREW	1
93	10027397	手柄	BOBBIN LEVER	1
94	10031087	梭芯卷绕体组件	BOBBIN FITING BASIS COMPL BOBBIN	1
95	10027396	定位块轴	CAM SHAFT	1
96	10027395	绕线定位块	BOBBIN WINDER REGULATOR	1
97	10012014	螺钉	SCREW	1
98	10027397	扭簧	SPRING	1
99	10013038	挡圈	E-RING	1
100	10003517	625ZZ轴承	BEARING	1
101	10004684	绕线轮	BOBBIN WINDER WHEEL	1
102	10011097	橡胶轮	RUBBER RING	1
103	10011143	SM9/64"×40螺钉	SCREWM9/64"×40	1
104	10071604	发光LOGO贴膜☆	LOGO	1
105	10074316	LOGO电路板组件☆	CIRCUIT BOARD ASM	1
106	10042310	螺钉	SCREW	2
107	10043310	橡皮塞 $\phi 8.8$	RUBBER PLUG $\phi 8.8$	1

2.MAIN SHAFT&NEEDLE BAR COMPONENTS

挑线刺布部件



2. 挑线刺布部件MAIN SHAFT & NEEDLE BAR COMPONENTS

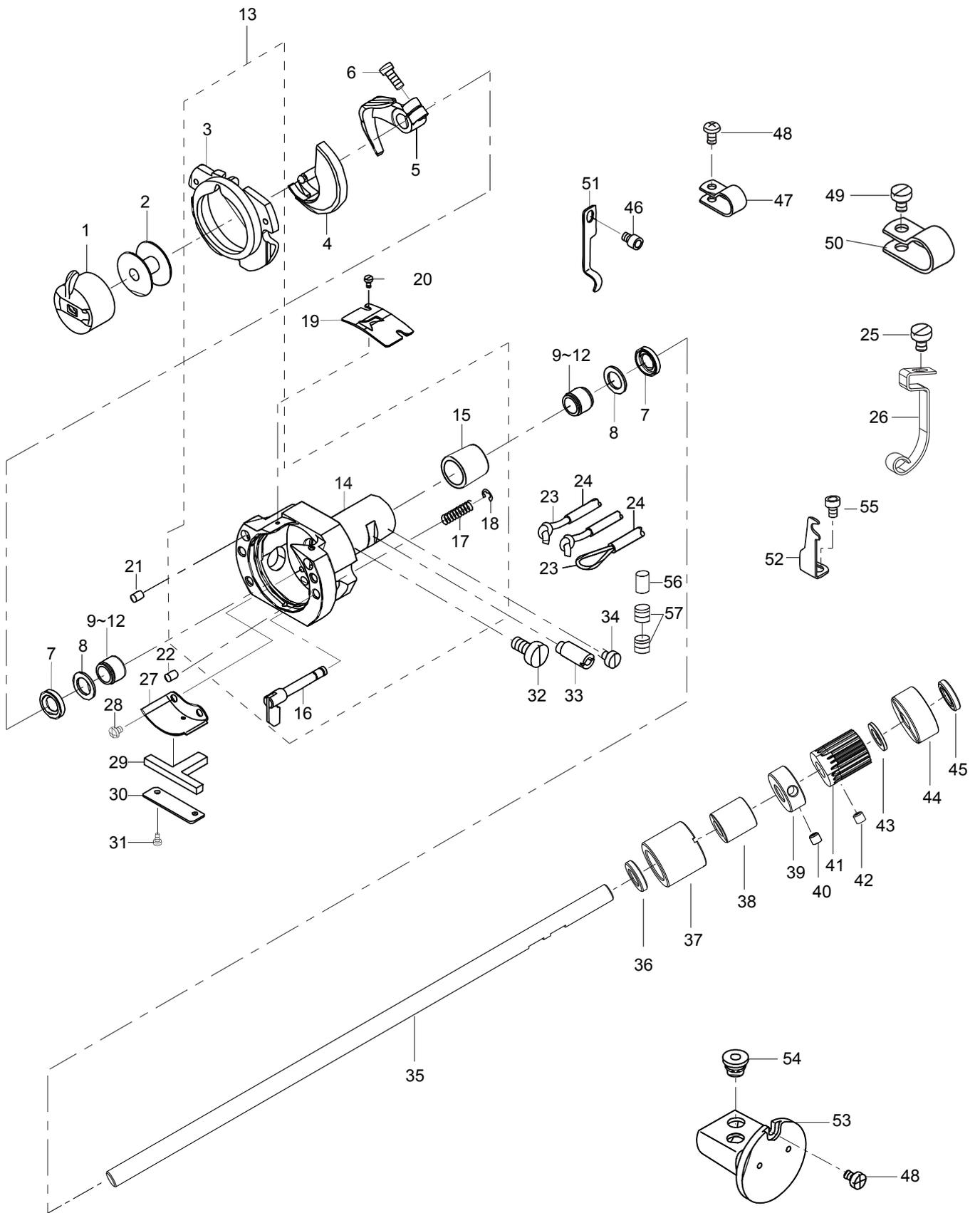
序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
1	10028715	轴套	NEEDLE ROD SLEEVE	1
2	10010590	针杆连接柱	NEEDLE BAR CONNECTING COLUMN	2
3	10030286	螺钉	SCREW	1
4	10014277	针杆	NEEDLE BAR	1
5	10011699	螺钉	SCREW	1
6	10028716	轴套	NEEDLE ROD LOWER METAL	1
7	10011701	针杆线钩	THREAD GUIDE	1
8	10023286	机针	NEEDLE DP? #16	1
9	10051398	挑线杆组件	THREAD TAKE UP COMPL	1
10	10007983	针杆连杆组件	NEEDLE BAR CRANK BOD ASM	1
11	10007986	针杆连杆	NEEDLE BAR CRANK ROD	1
12	10005793	针杆连杆轴套	NEEDLE BAR CRANK BOD METAL	1
13	10009777	轴承	BEARING	1
14	10010537	螺钉	SCREW	1
15	10008014	挑线曲柄	NEEDLE BAR CRANK	1
16	10052056	挑线连杆	THREAD TAKE UP CRANK	2
17	10052057	挑线杆	THREAD TAKE UP LEVER	1
18	10004161	挑线杆过线套	THREAD PASS BUSH	1
19	10003591	轴承	BEARING	1
20	10052090	轴承	BEARING	2
21	10007984	挑线连杆销	BALANCE CRANK PIN	1
22	10005786	挡圈	THRUST COLLAR	2
23	10005747	轴承	BEARING	2
24	10005745	挡圈	THRUST COLLAR	1
25	10004482	螺钉	SCREW	2
26	10042442	从动轮紧定螺钉	SCREW	2
27	10011194	针杆连接柱滑块	SQUARE BLOCK	1
28	10011622	挡圈	THRUST COLLAR	1
29	10052054	针杆曲柄	COUNTER EIGHT	1
30	10014272	螺钉	SCREW	1
31	10014282	螺钉	SCREW	1
32	10014284	螺钉	SCREW	1
33	10050053	螺钉M6×0.75	SCREW M6×0.75 L=6	1
35	10051864	轴承组件_6004	BEARING ASM 6004	1
36	10042442	从动轮紧定螺钉	SCREW M6×8	2
37	10011225	螺钉	SCREW	1
38	10062644	手轮	PULLEY	1
39	10062650	手轮轴	HAND PULLEY SHAFT	1
40	10006073	销	PIN	1
41	10062651	弹簧	SPRING	1
42	10021312	弧齿锥齿轮组件_手轮轴	GEAR ASM.	1
43	10011235	齿轮	GEAR	1
44	10011226	螺钉	SCREW	2
45	10009172	绕线主动轮	BTW DRIVING WHEEL	1
46	10011223	螺钉	SCREW	2
47	10027407	上轴齿轮组件	GEAR ASM.	1
48	10002413	齿轮	GEAR	1
49	10011226	螺钉	SCREW	2
50	10062903	上轴	MAIN SHAFT	1
51	10058049	油封	OIL SEAL	2

2. 挑线刺布部件MAIM SHAFT & NEEDLE BAR COMPONENTS

序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
52	10037249	油泵体组件	OIL PUMP ASM	2
53	10008779	油管接头	JOINT	1
54	10014337	上轴平衡轮	CRANK BALANCER	1
55	10014332	上轴平衡轮固定板	CRANK BALANCER FIX PLATE	1
56	10011644	螺钉	SCREW	2
57	10000313	上轴轴承挡圈	BALL BEARING BUSH	1
58	10009626	螺钉	SCREW	3
59	10014268	大连杆滚针轴承盖板	CRANK ROD SUPPORT PLATE	1
60	10014269	挡圈	RETAINING COLLAR	2
61	10037219	大连杆	CRANK ROD	1
62	10023508	轴承	BEARING	(1)
63	10023509	轴承	BEARING	(1)
64	10023510	轴承	BEARING	1
65	10023511	轴承	BEARING	(1)
66	10014265	偏心轮	ECCENTRIC WHEEL	1
67	10009187	螺钉	SCREW	2
68	10012160	弹簧	SPRING	2
69	10042442	从动轮紧定螺钉	SCREW M6×8	2
70	10077967	6204NR-DC轴承	BEARING ASM 6204NR-DC	1
71	10012615	电机端联轴器	COUPLING	1
72	10011227	传动连接橡胶块	RELAX	1
73	10012613	上轴端联轴器	COUPLING	1
74	10009187	螺钉	SCREW	4
75	10053840	上轴电机-04	AC SERVO MOTOR-04	1
76	10000157	螺钉	SCREW	4
77	10037229	销	PIN	1
78	10064708	油封	OIL SEAL	1
79	10037230	齿轮	BEARING	2
80	10011232	螺钉	SCREW	2
81	10037231	垫圈	WASHER	1
82	10010146	O形圈	RUBBER RING	3
83	10010803	挡圈	RETAINING COLLAR	1
84	10013590	螺钉	SCREW	2
85	10037228	销	PIN	1
86	10002129	螺钉	SCREW	1
87	10037260	油管定位架	FILLER PIPE HOLDER	1
88	10013232	螺钉	SCREW	1
89	10037261	防油纸垫	PAPER SPACER	1
90	10013238	活塞弹簧	SPRING	1
91	10012609	柱塞	PLUNGER	1
92	10046049	螺钉	SCREW	1
93	10037221	上油管架	UPPER FILLER PIPE BRACKET	1
94	10037222	下油管架	LOWER FILLER PIPE BRACKET	1
95	10000471	油管二接头	FILLER PIPE JOINT ASM.	1
96	10007800	φ3×φ5油管	φ3×φ5 FILLER PIPE	50mm
97	10007800	φ3×φ5油管	φ3×φ5 FILLER PIPE	310mm
98	40000363	扎带	BINDING TAPE	3
99	10006115	垫圈	WASHER	1
100	10013616	螺钉	SCREW	1
101	10070208	油封衬套	OIL SEAL METAL	1
102	10037240	滑块槽	SQUARE BLOCK TROUGH SCREW	1
103	10014477	螺钉	SCREW	2
104	10013448	油封	OIL SEAL	1
105	10051546	弹簧	SPRING	1

3. SHUTTLE DRIVER SHAFT COMPONENTS

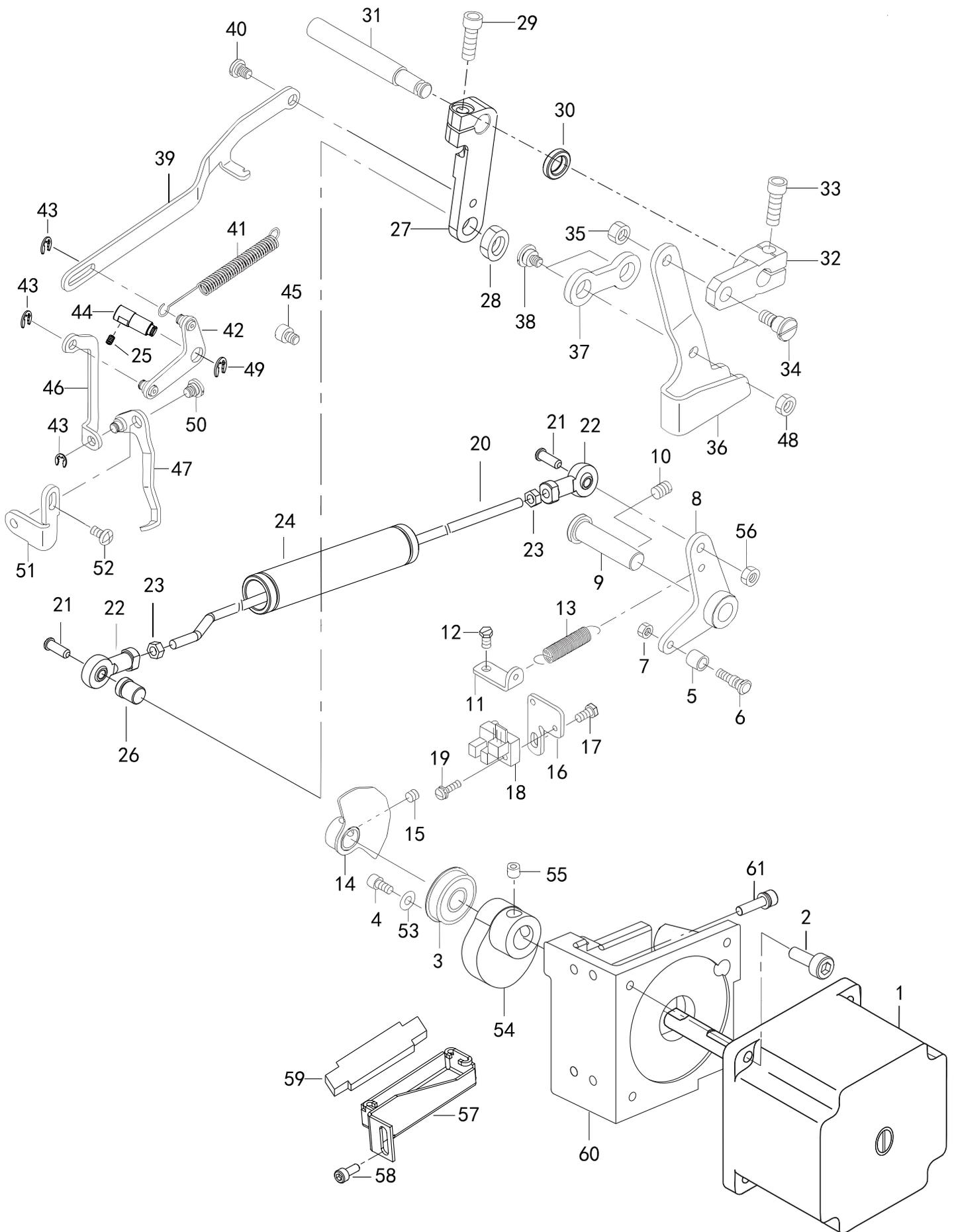
下轴部件



3. 下轴部件SHUTTLE DRIVER SHAFT COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10003781	梭壳	BOBBIN CASE ASM	1
2	10004592	锁芯	BOBBIN	1
3	10010738	梭床盖组件	SHUTTLE RACE RING ASM	1
4	10025068	摆梭	INNER HOOK	1
5	10004609	摆梭托	SHUTTLE DRIVER	1
6	10004611	螺钉	SCREW	1
7	10014297	油封	SHUTTLE OIL SEAL	2
8	10014295	挡圈	SHUTTLE BEARING RING	2
9	10023516	轴承	BEARING	2
10	10023517	轴承	BEARING	2
11	10023518	轴承	BEARING	2
12	10023519	轴承	BEARING	2
13	10026549	梭床与盖组件	SHUTTLE ASM.	1
14	10014248	梭床	SHUTTLE	1
15	10008576	梭床衬套	SHUTTLE BUSH	1
16	10004261	梭床锁紧钩组	INNER HOOK PRESSER ASM.	2
17	10004495	件弹簧	SPRING	2
18	10009669	挡圈	E-RING	2
19	10004596	梭床簧	SHUTTLE UPPER SPRING	1
20	10010744	螺钉	SCREW	2
21	10011427	毛毡	SHUTTLE OIL FELT	1
22	10011077	毛毡	SHUTTLE OIL FELT	1
23	10008103	油线	OIL WICK	2
24	10007800	油管	FILLER PIPE	2
25	10009849	M5×8 螺钉	SCREW M5×8	1
26	10026912	油管限位板C	OIL_PIPE HOLDER	1
27	10007926	油线夹板	SHUTTLE LUBRICATING PLATE	1
28	10010797	螺钉	SCREW	2
29	10010800	毛毡	SHUTTLE ONCE THROUGH OIL FELT	1
30	10010799	毛毡压板	ONCE THROUGH OIL LFELT PRESSER	1
31	10010744	螺钉	SCREW	2
32	10045298	螺钉	SCREW	1
33	10011426	螺钉	SCREW	1
34	10011142	螺钉	SCREW	1
35	10037224	下轴	LOWER SHAFT	1
36	10035171	油封	OIL SEAL	1
37	10037225	下轴前衬套	SLEEVE A	1
38	10037273	轴承	NUT	1
39	10037298	挡圈	WASHER	1
40	10013590	螺钉	SCREW	2
41	10037223	齿轮	GEARED	1
42	10011232	螺钉	SCREW	2
43	10037227	垫圈	WASHER	1
44	10037226	下轴后轴套	SLEEVE B	1
45	10035171	油封	OIL SEAL	1
46	10005107	螺钉	SCREW	1
47	10008228	SN-3A夹头	CABLE CLIP	1
48	10012892	螺钉	SCREW	2
49	10011101	螺钉	SCREW	1
50	10008229	SL-12N夹头	CABLE CLIP	1
51	10014294	油管限位板	OIL_PIPE HOLDER	1
52	10014288	油管限位板	TUBE_CLAMP	1
53	10021601	油窗组件	OIL TANK ASM. RUBBER	1
54	10014296	油塞	BUSH	2
55	10010685	螺钉	SCREW	2
56	10011916	油量调节销	NYLON BUSH 4.6×10	1
57	10011232	螺钉 M6×6	SCREW M6×6	2

4. LEFT PRESSER&WIPER MECHANISM COMPONENTS 抬压扫线部件



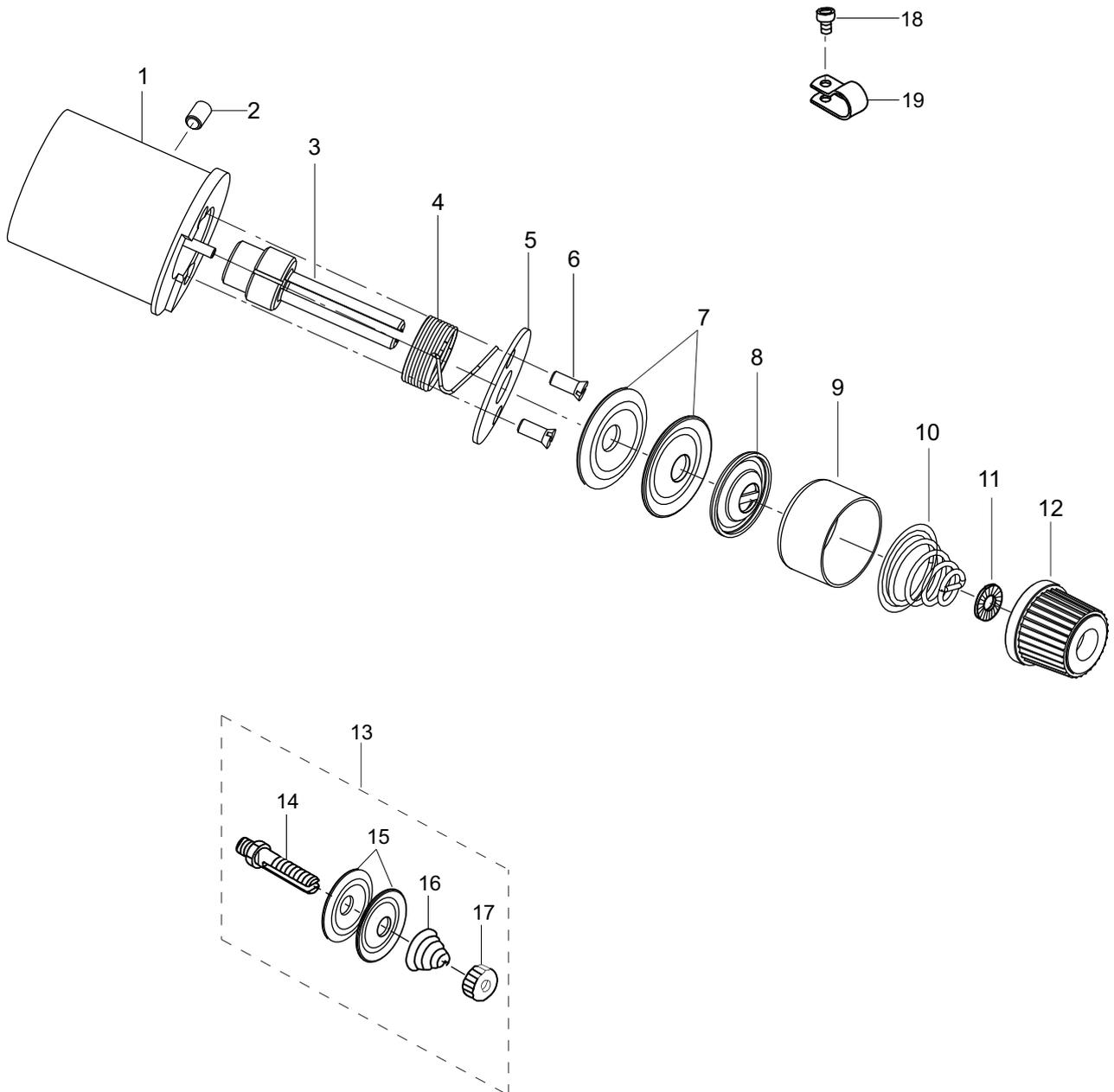
4. 抬压扫线部件LIFT PRESSER&WIPE MECHANISM COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10062819	抬压电机-04	PRESSER LIFTING MOTOR-04	1
2	10000157	螺钉	SCREW	4
3	10050516	轴承	BEARING	1
4	10010668	螺钉	SCREW	1
5	10028245	销套	NEEDLE CAM ROLLER A	1
6	10014342	销	UTT CAM ROLLER SHAFT	1
7	10010370	螺母	NUT	1
8	10037252	抬压曲柄组件	LIFTER LINK A ASM THREAD	1
9	10052771	抬压曲柄轴	TRIMMER SHAFT	1
10	10011232	螺钉	SCREW	1
11	10014343	拉板	SIDE COVER THREAD GUIDE	1
12	10011005	螺钉M4=9	SCREW M4 L=9	1
13	10014356	弹簧	SPRING	1
14	10014293	抬压电机传感片组件	SENSOR SLIT	1
15	10044814	螺钉	SCREW	2
16	10014291	抬压传感器安装板	SENSOR_INSTALLING_BASE	1
17	10009486	螺钉SM11/64"×40 L=8.5	SCREW SM11/64"×40 L=8.5	1
18	10069195	传感器_带卡扣	SENSOR	1
19	10010667	螺钉组件	SCREW	1
20	10037234	抬压拉杆	LIFTER LINK B	1
21	10037250	螺钉	SCREW	2
22	10011586	万能接头组件	UNIVERSAL CONTACT JOINT	2
23	10003075	螺母	NUT	2
24	10037235	抬压拉杆套	PULL-ROD BUSH	1
25	10005295	螺钉	SPRING	1
26	10037238	螺钉	SCREW	1
27	10037236	拨线曲柄	CONNECTING ARM	1
28	10037825	螺母	NUT	1
29	10010735	螺钉	SCREW	1
30	10037237	垫圈	WASHER	1
31	10011914	曲柄轴	CONNECTING SHAFT LOWERING	1
32	10014340	抬压驱动曲柄	ARM	1
33	10010735	螺钉	SCREW	1
34	10010674	螺钉	SCREW	1
35	10010725	螺母	NUT	1
36	10014355	抬压传动板	LOWERING FOOT CONNECTING	1
37	10010684	抬压脚定位连杆	LINK	1
38	10010727	螺钉	SCREW	2
39	10014346	扫线调节杆	WIPER CONNECTING LINK	1
40	10004594	螺钉	SCREW	1
41	10004604	弹簧	SPRING	1
42	10037255	扫线连接板组件	WIPER_CONNECTING_ARM_ASM	1
43	10009653	卡簧	RETAINING RING	3
44	10037257	扫线曲柄支撑销	SHAFT	1
45	10014345	螺钉	SCREW	1
46	10014353	扫线拉板	WIPER_CONNECTING_PLATE	1
47	10014348	扫线杆组件	WIPER C ASM	1
48	10010725	螺母	NUT	1
49	10007859	卡簧	RETAINING RING	1

4. 抬压扫线部件LIFT PRESSER&WIPE MECHANISM COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
50	10004593	螺钉	SCREW	1
51	10014341	扫线固定架	WIPER BASE PLATE	1
52	10010668	螺钉	SCREW	1
53	10010741	垫圈	WASHER	1
54	10014287	抬压凸轮	LIFT TO PRESS THE CAM	1
55	10011232	螺钉	SCREW	2
56	10042540	弯针调节柱螺母	NUT	1
57	10053640	抬压凸轮油槽	GREASE SLOT	1
58	10010685	螺钉	SCREW	2
59	10028676	毛毡	OIL FLET	1
60	10062814	电机固定架	MOTOR HOLDER	1
61	10000157	螺钉M5 L=18.5	SCREW M5 L=18.5	4

5. THREAD TENSION COMPONENTS
松线器组件

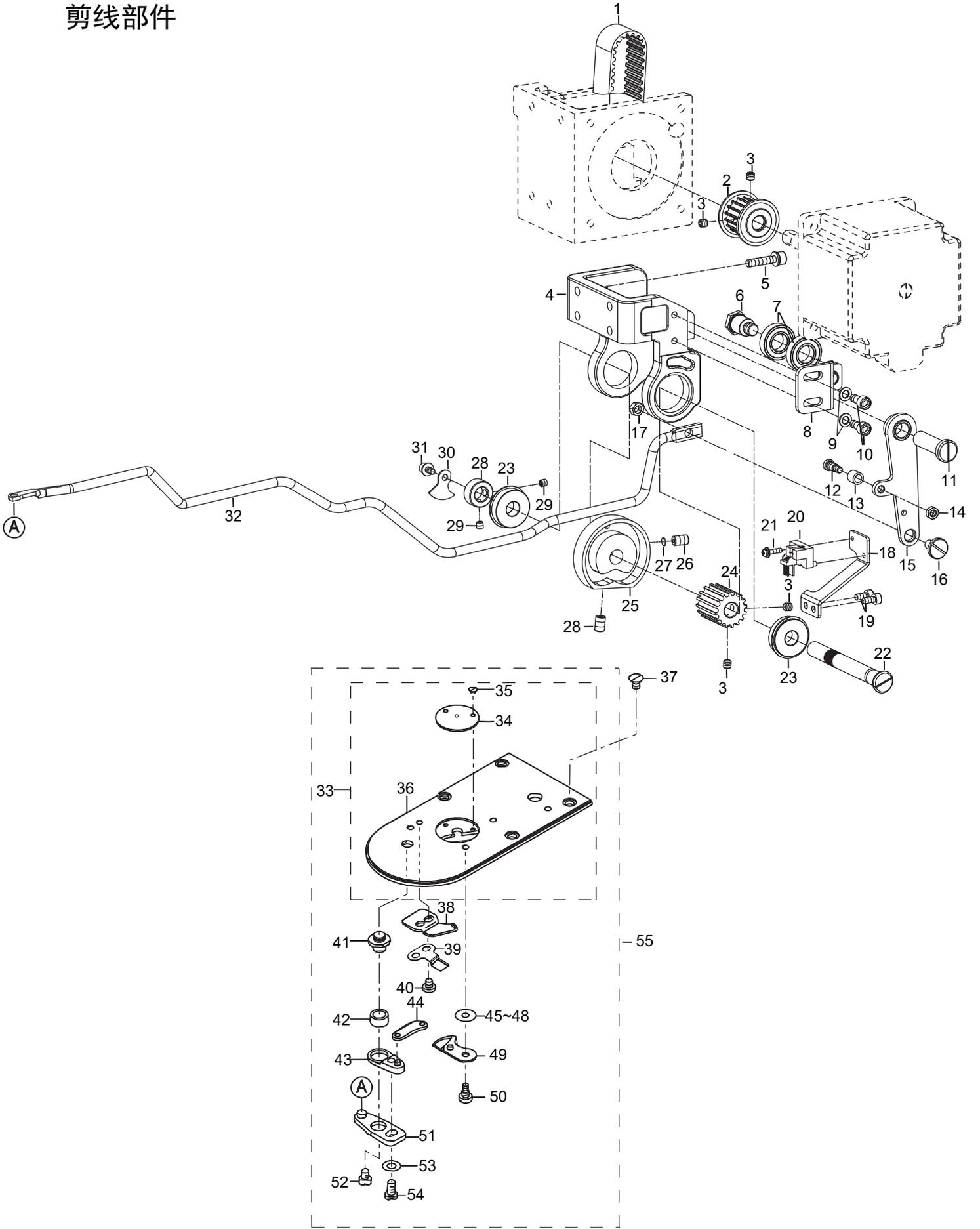


5. 松线部件THREAD TENSION COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10056036	电磁铁组件	THREAD TENSION ELECTROMAGNET	1
2	10026903	螺钉	SCREW	1
3	10042941	夹线螺钉	SCREW	1
4	10039203	弹簧	SPRING	1
5	10037243	锁紧块	LOCK PLATE	1
6	10052062	螺钉	SCREW	2
7	10005489	过线板	THREAD TENSION DISK	2
8	10004625	松线板	THREAD TENSION DISK PRESSER	1
9	10004598	夹线簧座	TENSION NUT	1
10	10004626	弹簧	SPRING	1
11	10004199	夹线制动板	ROTATING STOPPER	1
12	10062660	夹线螺母组件	THREAD TENSION NUT	1
13	10011493	夹线组件	FIRST THREAD TENSION ASM	1
14	10004666	螺钉	SCREW	1
15	10004393	夹线板	THREAD TENSION DISK	2
16	10004669	弹簧	SPRING	1
17	10004664	夹线螺母	TENSION NUT	1
18	10010685	螺钉	SCREW	2
19	10008228	SN-3A夹头	CABLE CLIP	3

6.THREAD TRIMMER MECHANISM COMPONENTS

剪线部件



6. 剪线部件THREAD TRIMMER MECHANISM COMPONENTS

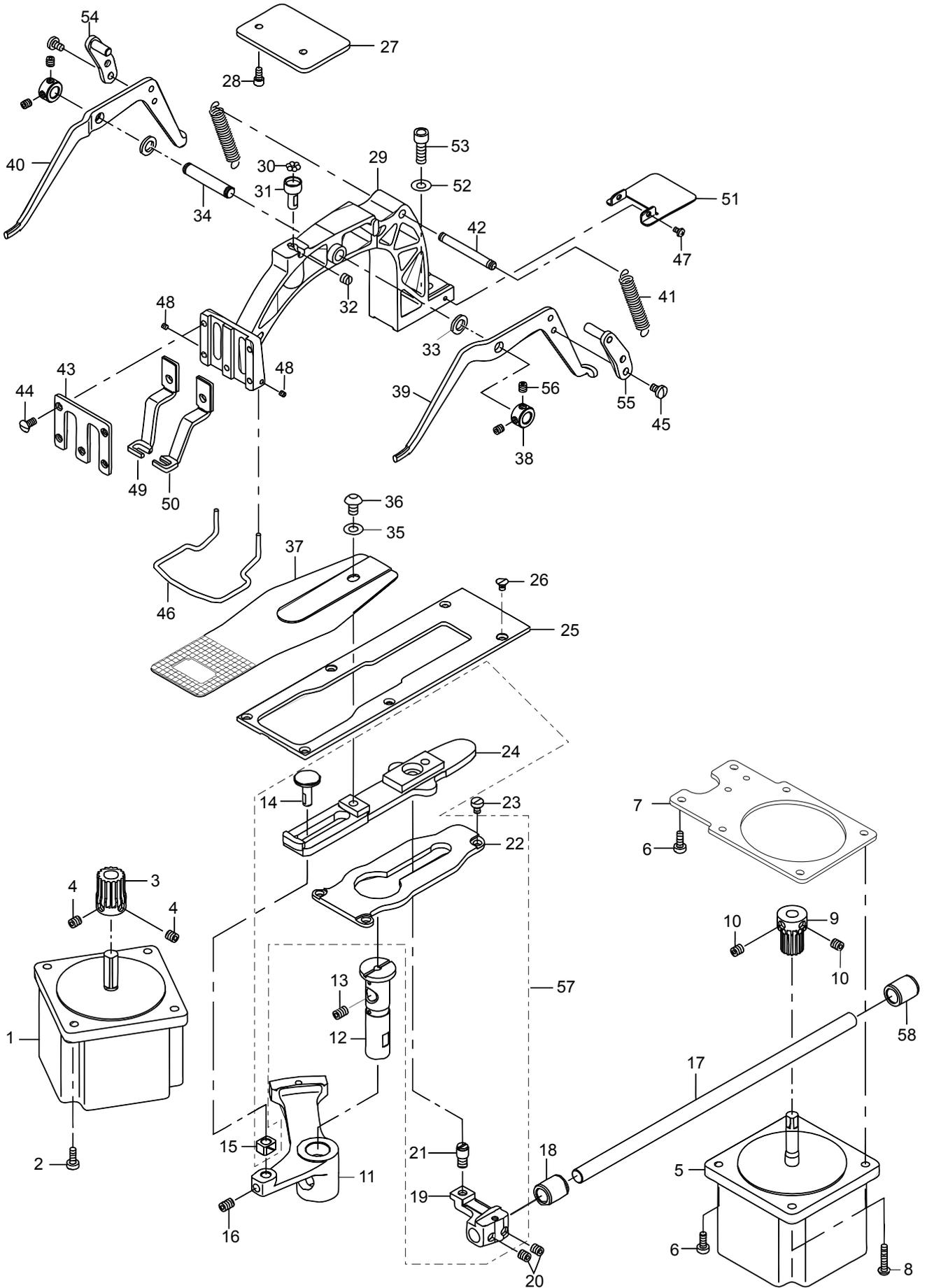
序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10062809	剪线同步带	TRIMMING TIMING BELT	1
2	10062811	剪线主动带轮	ACTIVE SYNCHRONOUS PULLEY	1
3	10012162	螺钉 M5×5	SCREW M5×5	4
4	10062813	同步带轮安装座	SYNCHRONOUS PULLEY BASE	1
5	10000157	螺钉组件 M5×21	SCREW M5×21	4
6	10037642	销	SHOULDER SCREW	1
7	10026221	轴承	BEARING	2
8	10062816	带轮支紧调节板	TENSION PLATE	1
9	10006115	垫圈	WASHER	2
10	10014210	M5×12螺钉	SCREW M5×1	2
11	10027364	销	PIN	1
12	10014342	销	PIN	1
13	10034929	销套	NEEDLE CAM ROLLER	1
14	10010370	SM11/64"×40螺母	NUT SM11/64"×40	1
15	10014339	剪线曲柄	CRANK	1
16	10027367	M5螺钉	SCREW M5	1
17	10042540	弯针调节柱螺母	NUT	1
18	10062817	剪线安全传感器座	THE SENSOR MOUNTING PLATE	1
19	10042268	止退圈紧固螺钉	SCREW M4×8	2
20	10069195	传感器_带卡扣	PHOTO SENSOR	1
21	10010667	传感器螺钉组件	SCREW COMPONENTS	1
22	10062812	剪线凸轮轴	AXIS	1
23	10050516	轴承_6000NR-2RS_BOM	BEARING_6000NR-2RS_BOM	2
24	10062810	剪线驱动轴带轮	BELT PULLEY	1
25	10065660	剪线凸轮	TRIMMING CAM	1
26	10046048	螺钉	SCREW SM1/4"×40 L=10	2
27	10023739	剪线凸轮垫	GASKET	1
28	10010803	挡圈	RETAINING COLLAR	1
29	10013590	SM11/64"×40螺钉	SCREW SM11/64"×40 SENSOR	2
30	10062815	安全开关感应片	SHEET	1
31	10003875	螺钉	SCREW ASM	1
32	10062818	剪线拉杆(同步带款)针	CONNECTION BAR	1
33	10014298	板组件	NEEDLE PATE ASM	1
34	10047532	小针板	NEEDLE HOLE GUIDE	1
35	10011509	螺钉	SCREW	2
36	10008027	针板	NEEDLE PLATE	1
37	10011511	螺钉	SCREW	4
38	10011501	定刀	FIXING KNIFE	1
39	10037254	底线夹线弹簧片	LOWER THREAD CLAMP SPRING	1
40	10011499	螺钉	SCREW	2
41	10011455	螺钉	SCREW	1
42	10011502	动刀杆销衬套簧	THREAD CUTTING LEVER RING	1
43	10010733	动刀曲柄分组件	THREAD CUTTER LEVER ASM	1
44	10011453	动刀连杆	MOVING KNIFE LINK	1
45	10007183	垫圈(0.5)	WASHER(0.5)	1
46	10007361	垫圈(0.6)	WASHER(0.6)	(1)
47	10007362	垫圈(0.7)	WASHER(0.7)	(1)
48	10007363	垫圈(0.8)	WASHER(0.8)	(1)

6. 剪线部件THREAD TRIMMER MECHANISM COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
49	10011513	动刀分组件	MOVING KNIFE ASM	1
50	10011500	螺钉	SCREW	1
51	10010737	动刀传动杆分组件	THREAD CUTTER LEVER ASM	1
52	10011503	螺钉	SCREW	1
53	10011506	垫圈	WASHER	1
54	10009906	螺钉	SCREW	1
55	10069251	针板大组件_套结S	NEEDLE PLATE ASM S	1

7. FEED MECHANISM COMPONENTS

送料部件



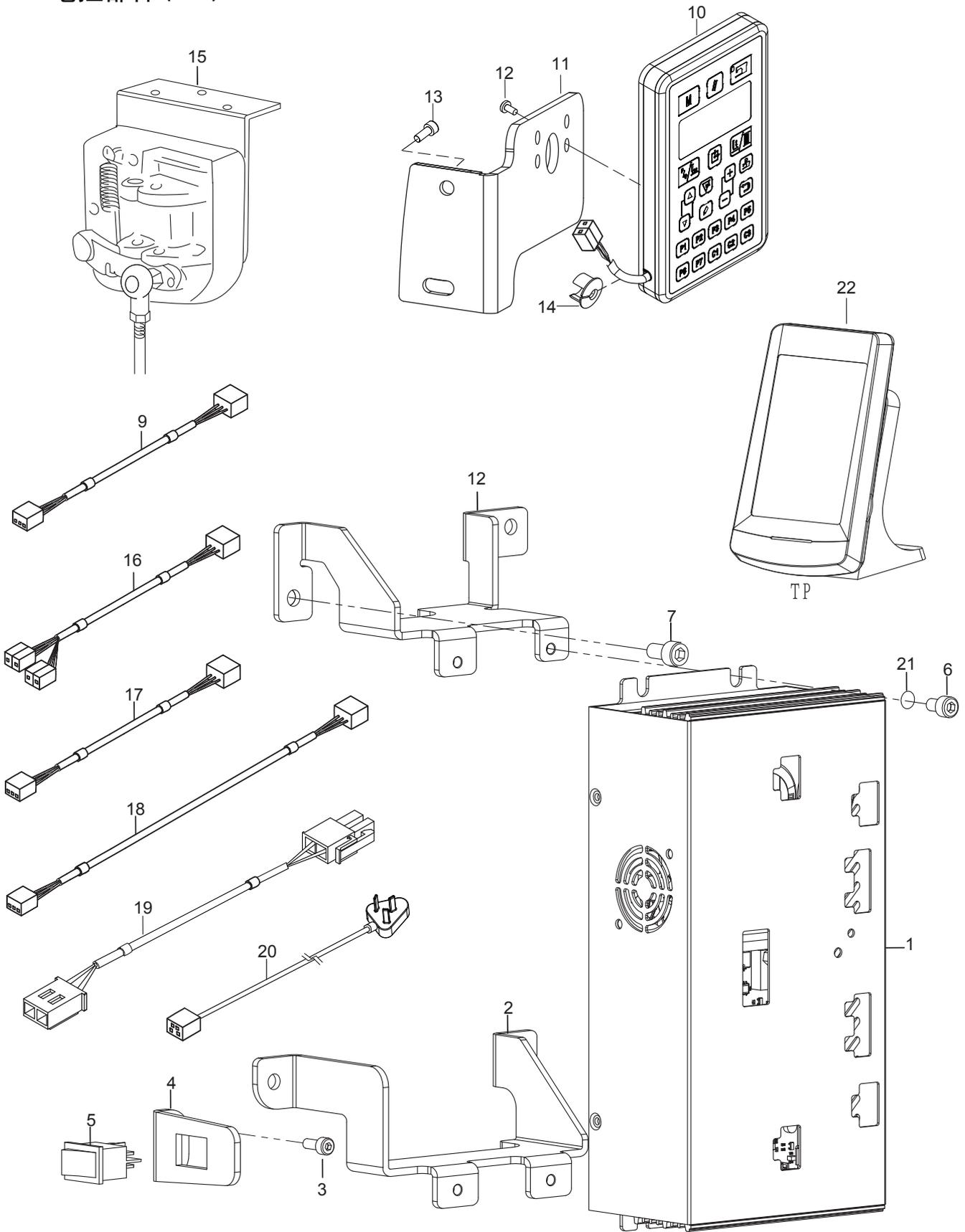
7. 送料部件FEED MECHANISM COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10053841	闭环X轴步进电机-04	X FEED STEPPING MOTOR	1
2	10011644	螺钉	SCREW	4
3	10011638	齿轮	GEAR	1
4	10011232	螺钉	SCREW	2
5	10053842	闭环Y轴不及电机-04	Y FEED STEPPING MOTOR	1
6	10011644	螺钉	SCREW	2
7	10052686	Y轴步进电机安装板	Y-AXIS MOTOR MOUNTING PLATE	1
8	10000157	螺钉	SCREW	4
9	10011640	齿轮	GEAR	1
10	10011232	螺钉	SCREW	2
11	10014318	齿轮	GEAR	1
12	10011573	X向铰轴	X HINGE AXIS	1
13	10010678	螺钉	SCREW	1
14	10011562	X向滑块轴	SLIDE BLOCK STUD	1
15	10011194	X向滑块	SQUARE BLOCK	1
16	10010678	螺钉	SCREW	1
17	10014326	Y向驱动轴	Y-DRIVING SHAFT	1
18	10011571	轴套	BUSHING, FORE	1
19	10011645	Y向驱动轴夹头	LENGTHWISE FEED ARM	1
20	10011642	螺钉	SCREW	2
21	10011568	螺钉	SCREW	1
22	10014325	送料托架支撑板	CLOTH FEED SUPPORT PLATE SCREW	1
23	10011142	螺钉	CLOTH FEED PLATE	3
24	10014321	送料托架	CLOTH FEED PRESSER PLATE SCREW	1
25	10063066	盖板	SUPPORT PLATE	1
26	10011566	螺钉	SCREW	6
27	10014300	送料架支撑板	FEED BRACKET	1
28	10011559	螺钉	SCREW	2
29	10014357	送料架	FEEDING FRAME	1
30	10011574	钢球	BALL	7
31	10011561	钢球座	SUPPORT	1
32	10044062	钢球座螺钉	SCREW	1
33	10014394	垫圈	WASHER	2
34	10028963	提升架轴	LIFTING LEVER SHAFT	1
35	10011646	垫圈	WASHER	2
36	10011569	螺钉	SCREW	1
37	10011565	送料板	FEED PLATE	1
38	10004600	挡圈	THRUST COLLAR	2
39	10011454	右压脚提升架	RIGHT LEVER	1
40	10011567	左压脚提升架	LIFT LEVER	1
41	10011558	弹簧	SPRING	2
42	10011456	拉簧支撑柱	SPRING SUSPENSION	1
43	10011557	压脚面板	WORK CLAMP FOOT FACE PLATE	1
44	10011510	螺钉	SCREW	5
45	10009906	螺钉	SCREW	4
46	10011556	护手圈	FINGER GUARDE	1
47	10002923	M3×6螺钉	SCREW	2
48	10003383	螺钉	SCREW	2

7. 送料部件FEED MECHANISM COMPONENTS

序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
49	10011508	左压脚	WORK CLAMP FOOT, LEFT	1
50	10011505	右压脚	WORK CLAMP FOOT, RIGHT	1
51	10014359	送料架后托板	HIDDEN_PLATE	1
52	10006013	垫圈	WASHER	1
53	10010735	螺钉	SCREW	1
54	10024705	左压脚提升导向板组件	LEVER DRIVING PLATE ASM.	1
55	10024706	右压脚提升导向板组件	LEVER DRIVING PLATE ASM.	1
56	10013590	螺钉	SCREW	4
57	10025161	送料托架组件	CLOTH FEED PLATE ASM	1
58	10024078	轴套	BUSHING, REAR	1

8. ELECTRONIC CONTROL SYSTEM COMPONENTS (-04) 电控部件(-04)

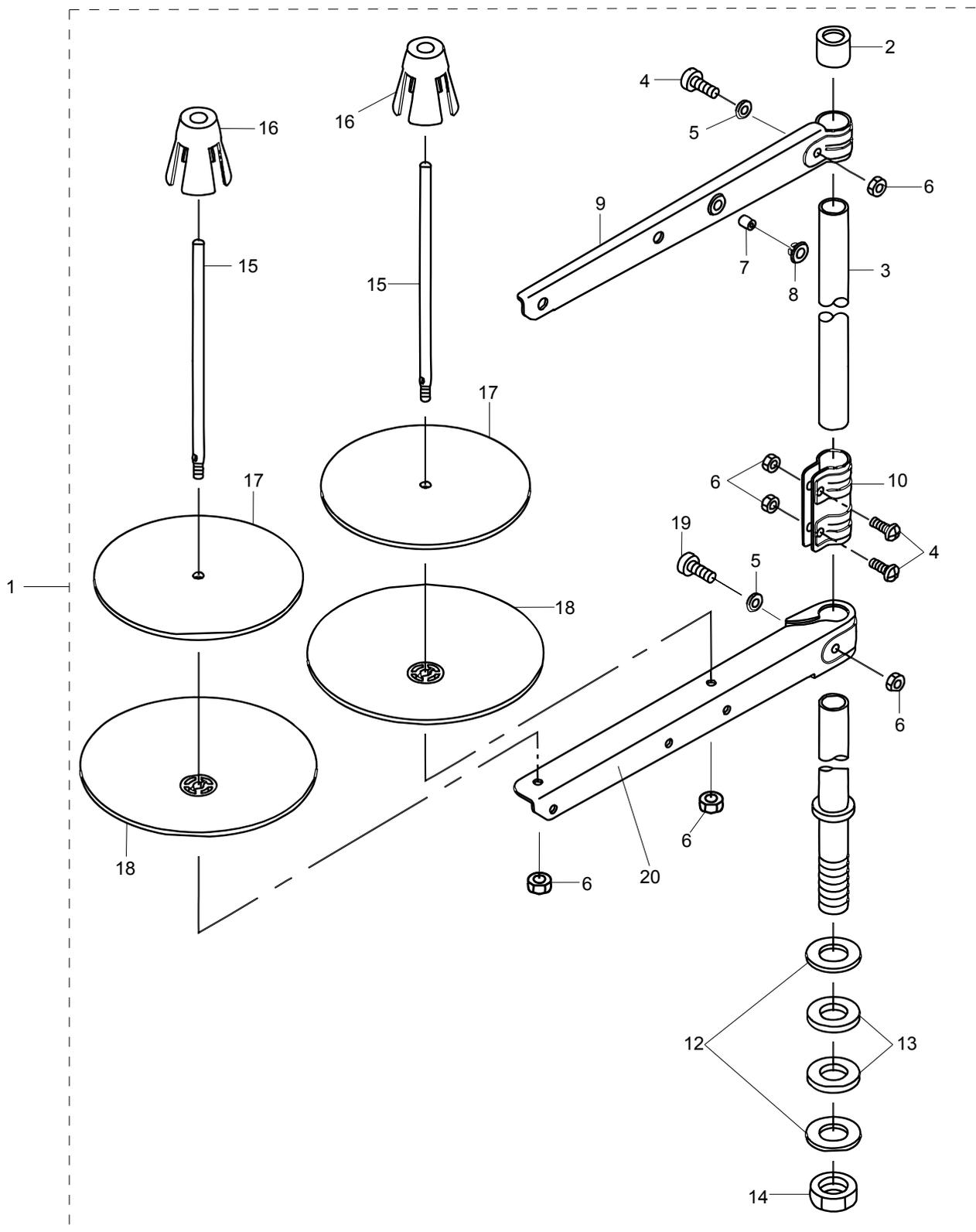


8. 自动控制部件ELECTRONIC CONTROL SYSTEM COMPONENTS (-04)

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10063211	一体机大豪点阵屏电控组件	ELECTRONIC CONTROL SYSTEM ASM	1
2	10057430	电控下支撑板	CONTROL BOX INSTALLING BASE DOWN	1
3	10005041	螺钉 M4×10	SCREW M4×10	2
4	10057431	电源开关安装座	POWER SWITCH INSTALLING BASE	1
5	10057914	船形电源开关	POWER SWITCH	1
6	10012028	螺钉 M5×8	SCREW M5×8	4
7	10011824	螺钉 M6×12	SCREW M6×12	4
8	10057429	电控上支撑板	CONTROL BOX INSTALLING BASE UP	1
9	10069197	抬压传感线_带卡扣	TT SENSOR CABLE ASM	1
10	10073823	大豪点阵屏操作面板	OPERATION PANEL	1
11	10062657	操作面板安装板(1900)	OPERATION PANEL MOUNTING PANEL	1
11	10066318	操作面板安装板(1903)	OPERATION PANEL MOUNTING PANEL	1
12	10012892	M4×9.5螺钉	SCREW M4×9.5	2
13	10007096	M5×10螺钉	SCREW M5×10	2
14	10062653	面板过线塞	RUBBER STOPPER	1
15	10059376	脚踏开关组件	FOOT PEDAL ASM	1
16	10064709	夹线电磁铁转接线缆	CONNECTING CABLES ASM	1
17	10069196	剪线传感线_带卡扣	SAFETY SENSOR OF TRIM THREAD	1
18	10073822	操作面板连接线缆	WIRE FOR OPERATION PANEL	1
19	10064194	发光LOGO电路板连接线缆	WIRE FOR LOGO	1
20	10058510	电源开关线缆	WIRE FOR POWER SWITCH	1
21	10011820	φ 5.2× φ 10.3×1垫圈	WASHER φ 5.2× φ 10.3×1	2
22	10066908	触摸屏-V4	OPERATION PANEL	1

9. THREAD STAND COMPONENTS

线架部件

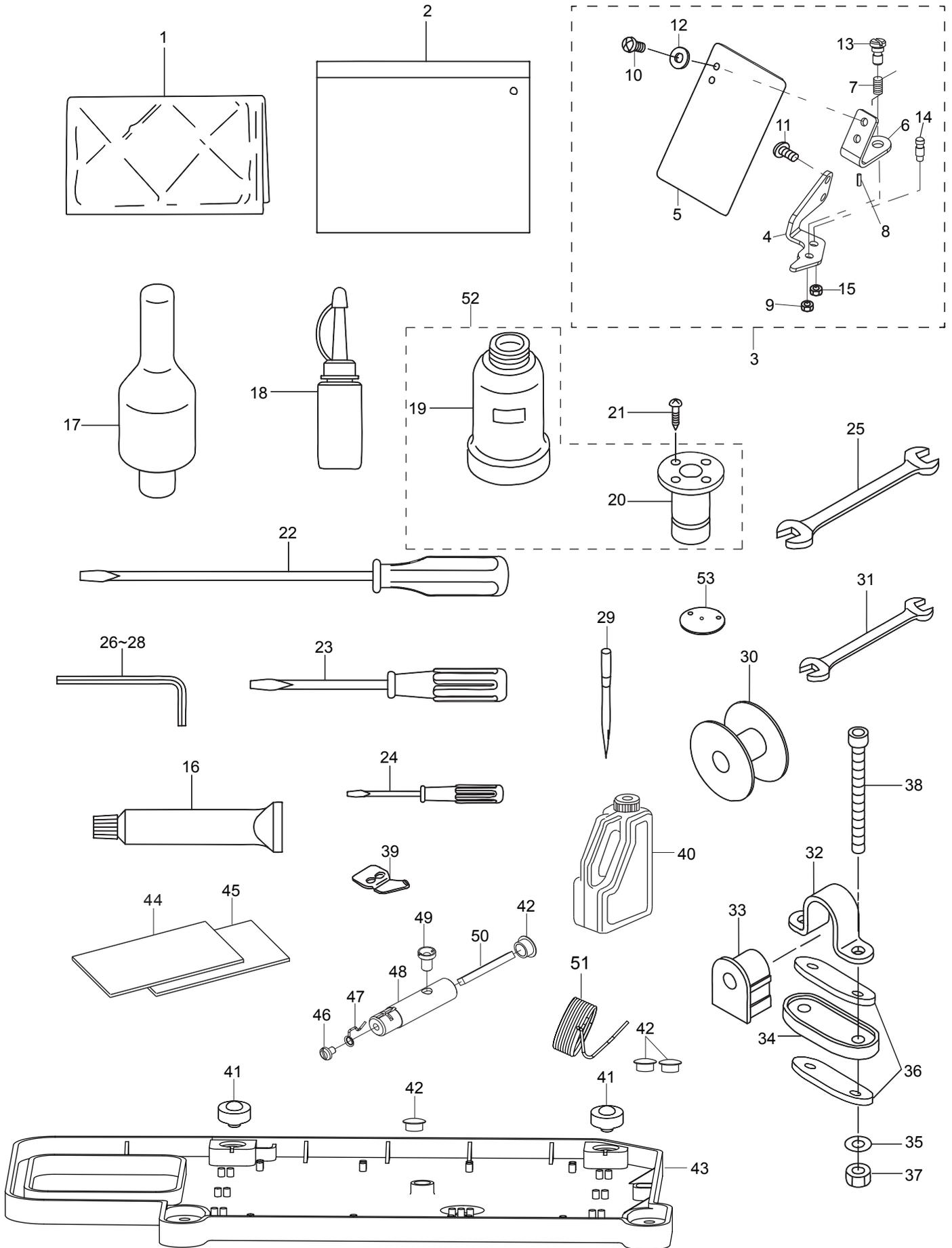


9. 线架部件THREAD STAND COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10007130	二线架组件	THREAD STAND ASM	1
2	10004282	撑管套	COLUMN CAP	1
3	10004293	线架上撑管	COLUMN PIPE	1
4	10003301	上过线架螺钉	SCREW	2
5	10003022	上过线架垫圈	WASHER	2
6	10002953	上过线架螺母	NUT	5
7	10004289	过线管	THREAD GUIDE PIPE	2
8	10004285	过线管套	THREAD GUIDE BUSHING	2
9	10004298	上过线架	THREAD HANGER	1
10	10004286	撑管夹	COLUMN PIPE CONNECTOR	1
11	10004291	线架下撑管	COLUMN PIPE	1
12	10004295	线架下撑管垫圈	WASHER	2
13	10004290	垫圈	WASHER	2
14	10002985	下过线架螺母线	NUT	1
15	10004288	轴	SPOOL PIN	2
16	10004287	线盘塑料压块线	SPOOL CUSHION	2
17	10004281	盘软垫	SOFT CUSHION OF THREAD PLARE	2
18	10004299	线盘	THREAD PLATE	2
19	10003312	下过线架螺钉下	SCREW	1
20	10004292	过线架	THREAD HANGER	1

10. ACCESSORIES PART COMPONENTS

附件



10. 附件ACCESSORIE PART COMPONENTS

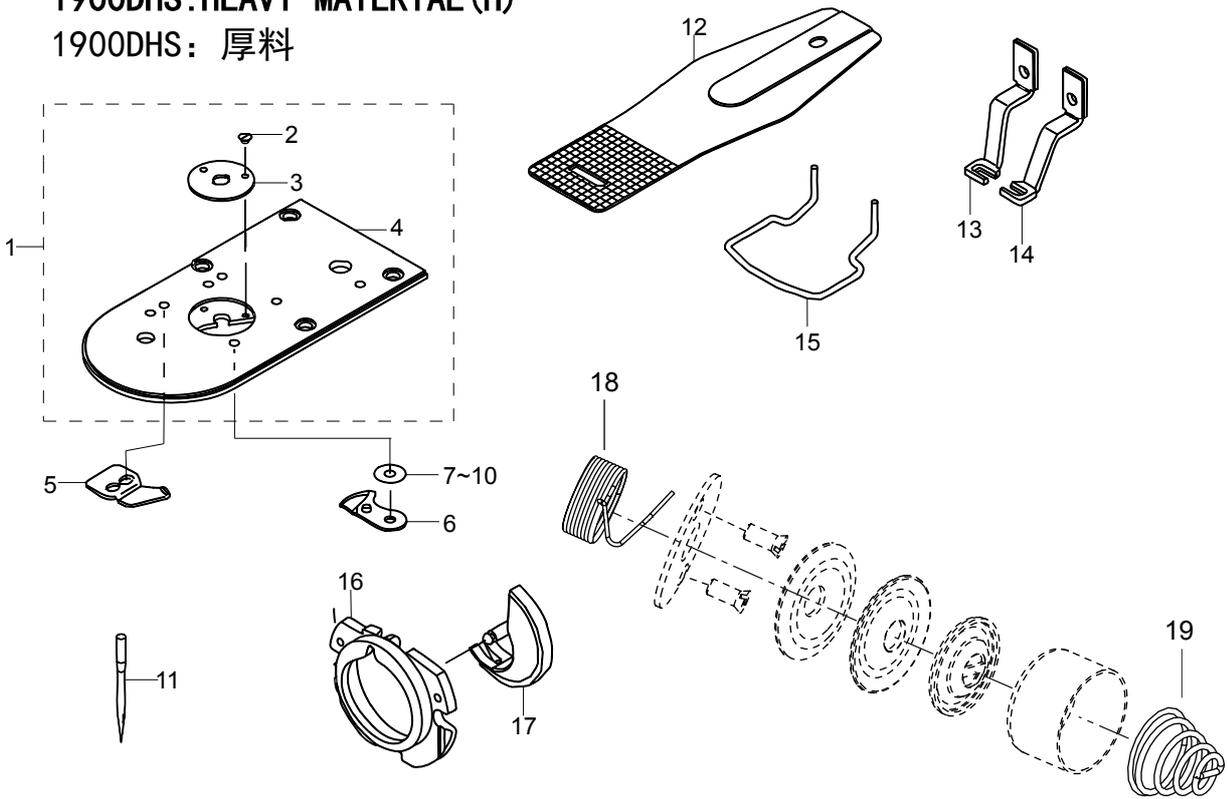
序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
1	10071554	机头罩☆	VINYL COVER	1
2	10004971	机头薄膜袋	ACCESSORY BOX	1
3	20004358	眼睛防护罩组件	SAFETY PLATE ASM.	1
4	10011632	安全板座	SAFETY PLATE INSTALLING BASE	1
5	10011636	安全板	SAFETY PLATE	1
6	10004725	安全板架	SAFETY PLATE INSTALLING PLATE	1
7	10011678	弹簧	SPRING	1
8	10002880	销	PIN	1
9	10010370	螺母	NUT	1
10	10046049	螺钉	SCREW	2
11	10046049	螺钉	SCREW	2
12	10011680	垫圈	WASHER	2
13	10011677	螺钉轴	HINGE SCREW	1
14	10011633	销	PIN	1
15	10011682	螺母	NUT	1
17	10011749	支承杆	HEAD SUPPORT BAR	1
18	10005356	油壶	OILER	1
19	10011681	油杯	OIL CAN	1
20	10011683	油杯座	OIL MANAGEMENT	1
21	10008197	螺钉	SCREW	6
22	10010994	大螺丝刀	SCREW DRIVER LARGE	1
23	10010995	中螺丝刀	SCREW DRIVER MIDDLE	1
24	10013185	小螺丝刀	SCREW DRIVER SMALL	1
25	10003368	呆板手	WRENCH	1
26	10009685	内六角扳手3	HEXAGONAL WRENCH SMALL	1
27	10009687	内六角扳手4	HEXAGONAL WRENCH LARGE	1
28	10009689	内六角扳手5	HEXAGONAL SPANNER	1
29	10023286	机针	NEEDLE	4
30	10004592	梭芯	BOBBIN	1
31	10003369	呆板手	WRENCH	1
32	10011160	支撑固定架	BED HINGE	2
33	10011137	机头胶垫	HINGE RUBBER	2
34	10014251	机头胶垫底座	BED HINGE RUBBER	2
35	10003076	垫圈	WASHER	4
36	10011747	垫片	WASHER	4
37	10003084	螺母	NUT	4
38	10011147	螺栓	SCREW	4
39	10011501	定刀	FIXING KNIFE	1
40	10060847	油壶 300ml	OIL BOX	1
41	10040431	机头座垫	SUPPORT RUBBER	2
42	10011136	橡胶塞	RUBBER PLUG	4
43	10062667	油盘	OIL TRAY	1
44	10071606	使用说明书及零件手册☆	INSTRUCTIONS ELECTRONIC	1
45	10063288	电控用说明书	INSTRUCTIONS	1
46	10011142	螺钉 SM11/64"×40 L=6	SCREW SM11/64"×40 L=6	1
47	10011918	硅油盒过线架	THREAD GUIDE SPRING	1
48	10011920	硅油盒	SOLICONE OIL BOX	1
49	10011917	螺钉 SM15/64"×40	SCREW SM15/64"×28	1
50	10011919	毛毡	OIL FELT	1
51	10039203	挑线簧	SPRING	1
52	10006185	油杯组件	OILER ASM	1
53	10004646	小针板 (φ 1.6)	NEEDLE HOLE GUIDE	1

11. 1900D SERIES COMPONENTS

1900D系列机零件

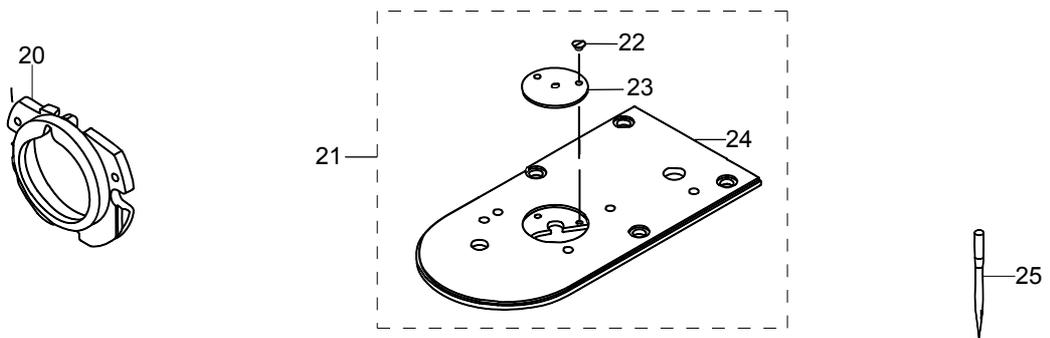
1900DHS:HEAVY MATERIAL (H)

1900DHS: 厚料



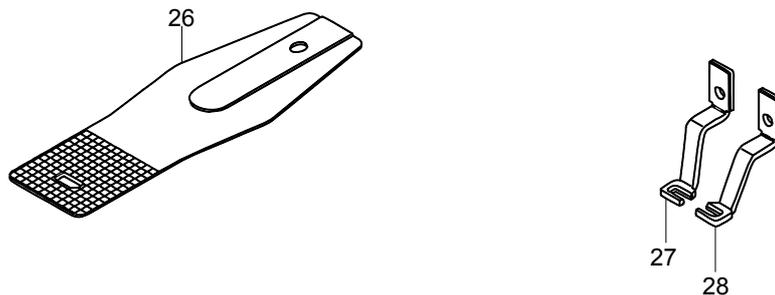
1900DFS:UNDERWEAR(F) & 1900DMS:KNITTING(M)

1900DFS: 内衣料 与 1900DMS: 针织料



1900DMS:KNITTING(M)

1900DMS: 针织料



11. 1900D系列机零件1900D SERIES PARTS

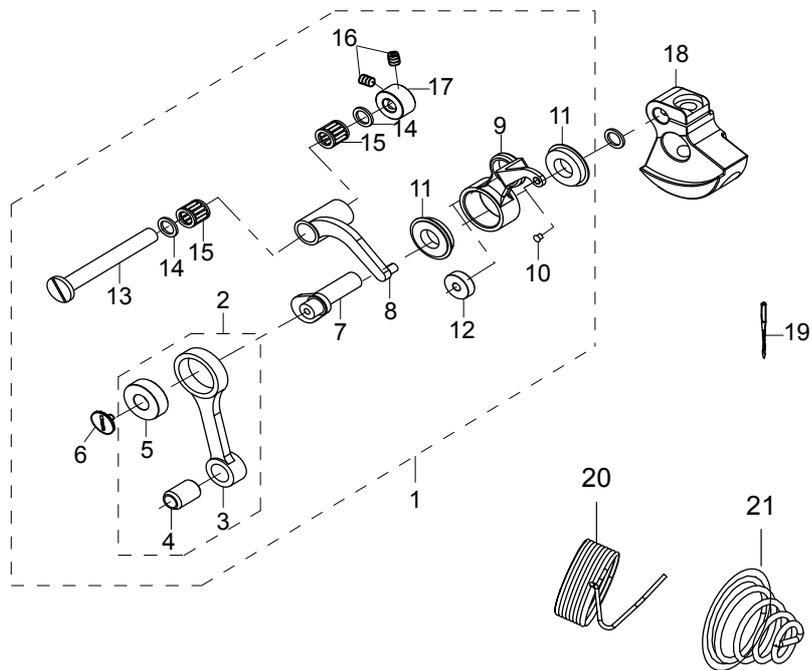
序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10024626	针板组件	NEEDLE PLATE ASM.	1
2	10011509	螺钉	SCREW	2
3	10004727	小针板	NEEDLE HOLE GUIDE	1
4	10008027	针板	NEEDLE PLATE	1
5	10011748	定刀	FIXING KNIFE	1
6	10011694	动刀分组件	MOVING KNIFE ASM.	1
7	10007183	垫圈	WASHER	(1)
8	10007361	垫圈	WASHER	(1)
9	10007362	垫圈	WASHER	1
10	10007363	垫圈	WASHER	(1)
11	10004897	机针 DP×17 19#	NEEDLE DP×17 19#	1
12	10011751	送料板	FEED PLATE	1
13	10011687	左压脚	WORK CLAMP FOOT, LEFT	1
14	10011691	右压脚	WORK CLAMP FOOT, RIGHT	1
15	10011695	护手圈	FINGER GUARDE	1
16	10031317	梭床盖组件	SHUTTLE BACE RING ASM.	1
17	10003834	旋梭	INNER HOOK	1
18	10037427	弹簧	SPRING	1
19	10011827	弹簧	SPRING	1
20	10011760	梭床盖组件	SHUTTLE BACE RING ASM.	1
21	10026087	针板组件	NEEDLE PLATE ASM.	1
22	10011509	螺钉	SCREW	2
23	10011757	小针板	NEEDLE HOLE GUIDE	1
24	10008027	针板	NEEDLE PLATE	1
25	10004857	机针 DP×5 11#	NEEDLE DP×5 11#	1
26	10011755	送料板	FEED PLATE	1
27	10011758	左压脚	WORK CLAMP FOOT, LEFT	1
28	10011759	右压脚	WORK CLAMP FOOT, RIGHT	1

12. 1903D-301 PARTS

1903D-301零件1

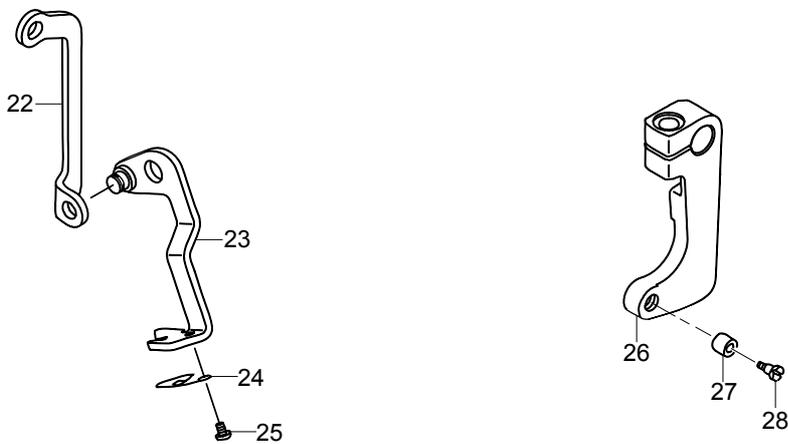
MAIN SHAFT & NEEDLE BAR COMPONENTS

挑线刺布部件



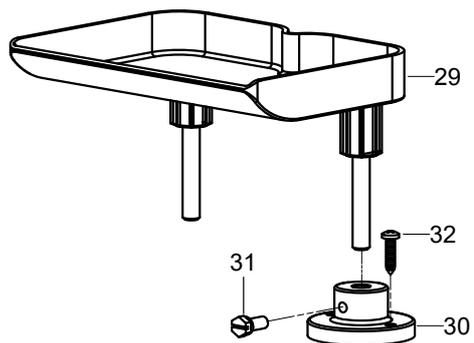
WIPER MECHANISM COMPONENTS

拨线部件



ACCESSORIES PART COMPONENTS

附件



12. 1903D-301零件1 1903D-301 PARTS 1

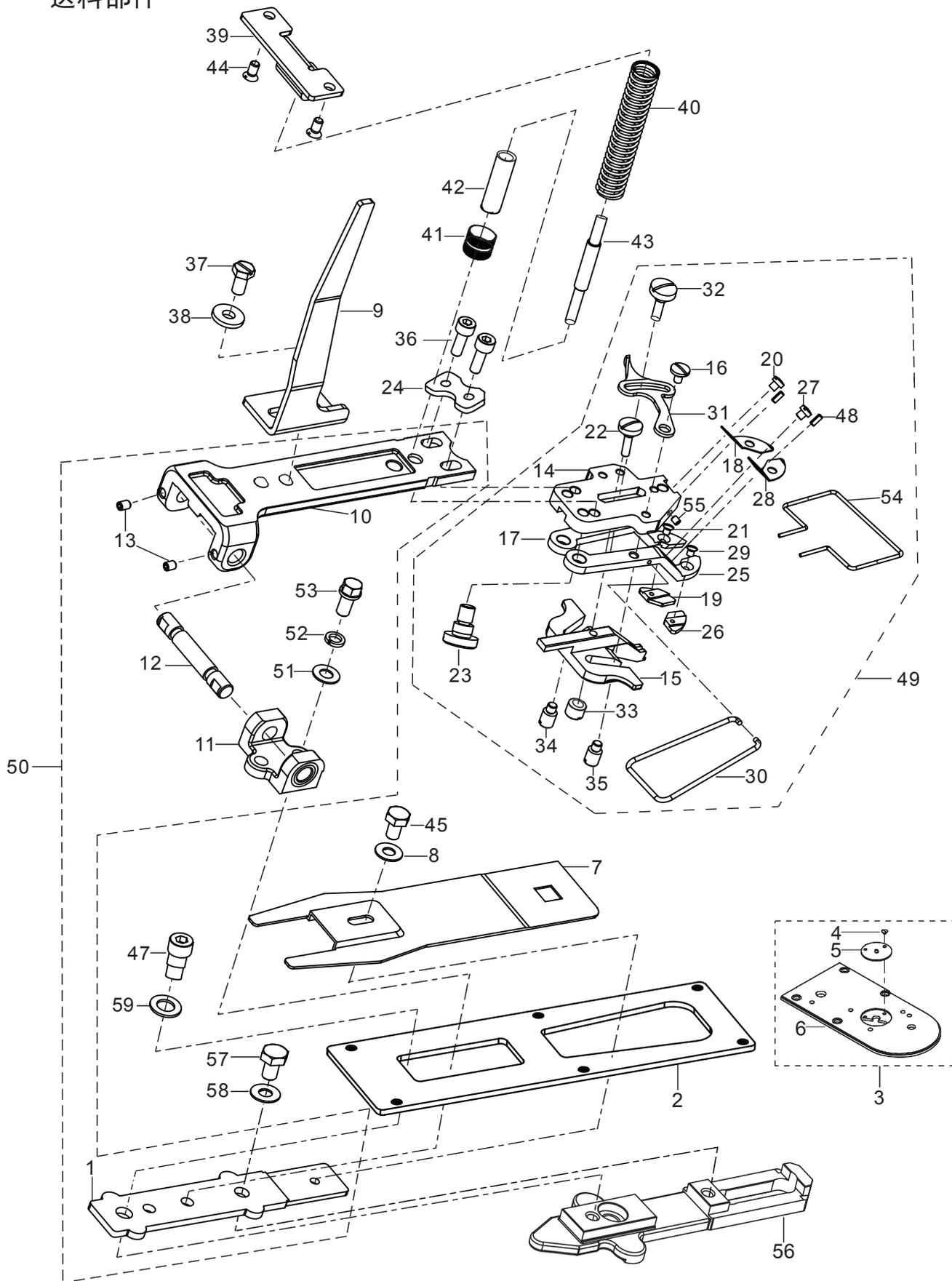
序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10052059	挑线杆组件	THEAD TAKE-UP COMPL	1
2	10007983	针杆连杆组件	NEEDLE BAR CRANK ROD ASM.	1
3	10007986	杆连杆	NEEDLE BAR CRANK ROD	1
4	10005793	针杆连杆轴套	NEEDLE BAR CRANK ROD METAL	1
5	10009777	轴承	BEARING	1
6	10010537	螺钉	SCREW	1
7	10023931	挑线曲柄	NEEDLE BAR CRANK	1
8	10052056	挑线连杆	THREAD TAKE-UP CRANK THREAD	1
9	10023930	挑线杆	TAKE-UP LEVER THREAD PASS	1
10	10004161	挑线杆过线套	BUSH	1
11	10009776	轴承	BEARING	2
12	10003591	轴承	BEARING	1
13	10007984	挑线杆铰链轴	BALANCE CRANK PIN	1
14	10005786	挡圈	THRUST COLLAR	2
15	10005747	轴承	BEARING	2
16	10004482	螺钉	SCREW	2
17	10005745	挡圈	RETAINING COLLAR	1
18	10023932	针杆曲柄	COUNTER EIGHT	1
19	10056816	机针	NEEDLE	1
20	10037427	弹簧	SPRING	1
21	10004626	弹簧	SPRING	1
22	10023928	扫线拉杆	WIPER LINK	1
23	10023927	扫线杆组件	WIPER ASM.	1
24	10011706	弹簧	SPRING	1
25	10011714	螺钉	SCREW	2
26	10037834	扣夹抬压曲柄	CONNECTING ARM	1
27	10037835	抬压曲柄滚子	CONNECTING ARM SLEEVE	1
28	10011707	螺钉	SCREW	1
29	10004665	纽扣盆组件	BUTTON SEAT ASSEMBLY	1
30	20004014	纽扣架底座	BUTTON SEAT	1
31	10011530	M6×12螺钉	SCREW M6×12	1
32	10008323	ST4. 2×20-C-H螺钉	TAPPING SCREW ST4. 2×20	2

13. 1903D-301 PARTS 2

1903D-301零件2

FEED MECHANISM COMPONENTS

送料部件



13. 1903D-301 PARTS 2

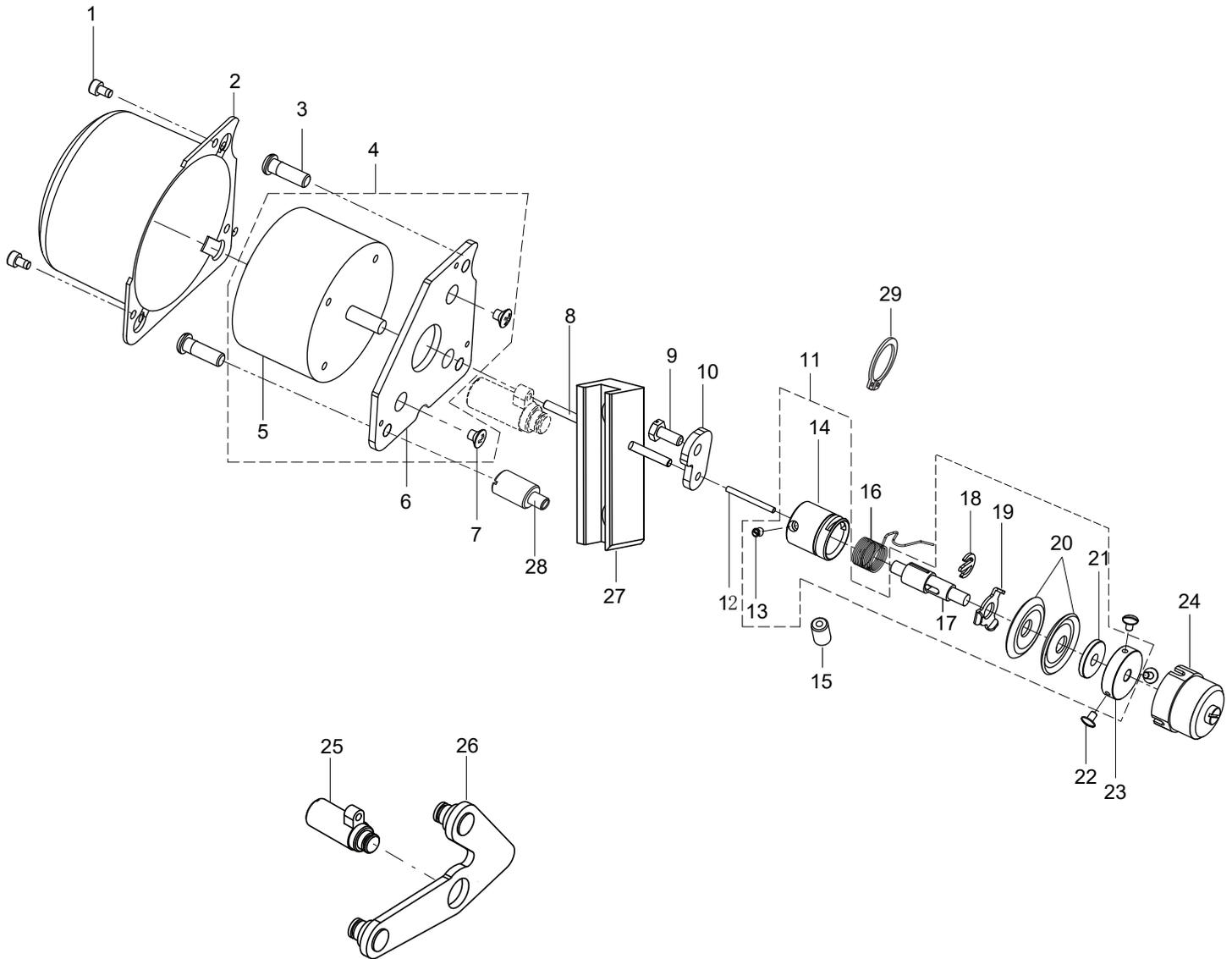
序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
1	10047339	送料板座	CLOTH FEED PLATE	1
2	10063067	盖板	FEED PLATE PRESSER	1
3	10026088	针板组件	NEEDLE PLATE ASM.	1
4	10011509	螺钉	SCREW	2
5	10011133	小针板	NEEDLE HOLE GUIDE	1
6	10008027	针板	NEEDLE PLATE	1
7	10011844	送料板	PRESSURE PLATE	1
8	10011820	垫圈	WASHER	1
9	10047343	抬压挡板	MOVING PLATE	1
10	10047338	扣夹座	BUTTON FOOT	1
11	10047340	扣夹支承座	BUTTON INSTALLING BASE	1
12	10047341	扣夹座铰轴	BUTTON FOOT INSTALLING SHAFT	1
13	10047342	螺钉	SCREW	2
14	10059165	压脚连接座	PICK-UP FOOT INSTALLING BASE	1
15	10059164	压脚导向座	BUTTON CLAMP SLIDE	1
16	10011559	螺钉	SCREW	1
17	10059163	右压脚座	SMALL CLAMP JAW LEVER, ASM. R	1
18	10059173	纽扣右定位板	SPRING, RIGHT	1
19	10059162	右压脚	PLATE K, R	1
20	10059171	螺钉	SCREW	1
21	10059175	螺钉	SCREW	1
22	10059178	螺钉	SCREW	1
23	10059168	螺钉	SCREW	2
24	10011761	抬压挡板座压板	PRESSER PLATE	2
25	10059159	左压脚座	SMALL CLAMP JAW LEVER, L	1
26	10059160	左压脚	PLATE K, L	1
27	10059171	螺钉	SCREW	1
28	10059172	纽扣左定位板	SPRING, LEFT	1
29	10059175	螺钉	SCREW	1
30	10059170	护指器	FINGER PROTECTOR	1
31	10059166	压脚调节扳手	SNAP FASTENER CLAMP STOP LEVER	1
32	10059176	螺钉	SCREW	1
33	10059193	螺母	NUT	1
34	10059194	压脚座导向柱	BUTTON CLAMP STOP PIN	1
35	10059194	压脚座导向柱	BUTTON CLAMP STOP PIN	1
36	10009818	螺钉	SCREW	2
37	10011828	螺钉	SCREW	2
38	10011821	垫圈	WASHER	2
39	10023934	压脚导杆导板	ACCETP PLATE, UPPER	1
40	10011593	弹簧	SPRING	1
41	10011526	螺母	NUT	2
42	10011528	压脚导杆套	SLEEVE	1
43	10011519	压脚导杆	ADJUSTING SHAFT	1
44	10011559	螺钉	SCREW	2
45	10011832	螺钉	SCREW	1
46	10014394	垫圈	WASHER	1
47	10047345	螺钉	SCREW	1
48	10059177	销	PIN	2
49	10032432	扣夹分组件	BUTTON CLAMP ASM.	1
50	10047337	扣夹座分组件	BUTTON FOOT CLAMP ASM.	1
51	10011646	垫圈	WASHER	2
52	10003077	垫圈	WASHER	2
53	10047342	螺钉	SCREW	2
54	10059170	手指保护器	FINGER GUARDE	1
55	10047342	螺钉	SCREW	2
56	10047346	送料托架	CLOTH FEED PLATE	1
57	10000809	螺钉 M6 L=10	SCREW M6 L=10	1
58	10011646	垫圈 $\phi 6.5 \times \phi 13 \times 0.8$	WASHER $\phi 6.5 \times \phi 13 \times 0.8$	1
59	10014394	垫圈 $\phi 8.2 \times \phi 15 \times 1$	WASHER $\phi 8.2 \times \phi 15 \times 1$	1

14. 1900D-T PARTS

1900D-T 零件

THREAD TENSION COMPONENTS

夹线分组件



14. 19000D-T零件 19000D-T PARTS

序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
1	10001616	M3×4螺钉	SCREW M3×4	3
2	10064296	夹线电磁铁罩壳	HOUSING	1
3	10000512	螺钉	SCREW	3
4	10064290	电磁铁组件	THREAD TENSION ELECTROMAGNET	1
5	10064291	电磁铁	ELECTROMAGNET	1
6	10064295	安装板	MOUNTING PLATE	1
7	10030192	M4×8螺钉	SCREW M4×8	3
8	10064300	顶杆	PUSH ROD	1
9	10011005	M4×9螺钉	SCREW M4×9	1
10	10064293	导向板	GUIDE PLATE	1
11	10064299	夹线器座组件	IRST THREAD TENSION ASM	1
12	10064301	夹线针	SPINDLE	1
13	10000746	M3×4螺钉	SCREW M3×4	1
14	10000749	夹线器座	THREAD TENSION POST BASE	1
15	10010678	螺钉	SCREW	1
16	10067020	挑线簧(薄料)	SPRING(S)	1
16	10069688	挑线簧(厚料)	SPRING(H)	1
17	10064306	夹线器芯轴	AXIS	1
18	10064305	夹线器活动卡簧	RETAINER RING	1
19	10064304	夹线三爪盘	CLAW	1
20	10000768	夹线板	HREAD TENSION DISK	2
21	10064292	垫圈	RUBBER RING	1
22	10000743	M2.5×4外盖螺钉	SCREWM2.5×4	3
23	10064303	夹线器挡块	LINK STOPPER	1
24	10000756	夹线器外盖	COVER	1
25	10067383	扫线曲柄支撑销	SHAFT	1
26	10064297	扫线连接板组件	WIPER_CONNECTING_ARM_ASM	1
27	10067175	针杆滑块槽	SQUARE BLOCK TROUGH SCREW	1
28	10064294	螺柱	SCREW	1
29	10050674	Φ17挡圈	RETAINING RING	1

在使用缝纫机之前请阅读本使用说明书。
请将本使用说明书放在便于查阅的地方保管。



高速电子套结一体机 ZJ1900D-V4 ZJ1903D-V4
COMPUTER-CONTROLLED HIGH SPEED LOCKSTITCH BAR
TACKING MACHINE SERIES

使用说明书

OPERATION MANUAL

零件手册

PARTS BOOK



手机官网



官方订阅号

浙江中捷缝纫科技有限公司
ZOJE SEWING MACHINE CO.,LTD

使用说明书

OPERATION MANUAL

为了创造更加美好的环境

请您协作

首先对您使用我们产品表示衷心的感谢！

我们公司致力于关爱地球环境，制定了“智能制造、绿色制造”的基本方针。当地的公民在环境保护活动中也应该对当地社会、环境二方面尽每个人的微薄之力。

因此，希望您能配合这个计划，作为环境保护活动的一环，在平时处理废弃物的时候能多加注意。

- 1.不用的包装材料，为了能再次回收利用，请交付给当地相关回收公司进行处理。
- 2.使用完的润滑油、请根据相关的法律和规定进行妥善处理。
- 3.产品保养或修理需要更换零部件时，有不需要的电路板和电子零件，以及产品废弃时，请作为电子废弃物处理。

非常感谢您购买我们业缝纫机。
在使用缝纫机之前，请仔细阅读<为了您的安全使用>和使用说明。
工业缝纫机的特性之一，因为要在机针和旋梭等运动零部件附近进行操作，而这些零部件很容易引起受伤的危险，所以请在受过培训的人或熟练人员的安全操作知识的指导下，正确地使用本缝纫机。

为了您的安全使用

[1] 安全使用的标记及其意义

本使用说明书及产品所使用的标记和图案记号是为了您的安全而正确地使用产品，防止您及其他人受到危害和损害。

表示方法及含意如下。

标记

 危险	该内容表示如果忽视此标志而进行错误的操作，必将导致死亡或重伤。
 警告	该内容表示如果忽视此标志而进行错误的操作，肯定会引起死亡或重伤。
 注意	如果忽视此标志而进行错误的操作，有可能会引起受到轻微或中度伤害。

图案和符号



…………… 该符号（△）表示“应注意事项”。
三角中的图案表示必须要注意的实质内容。
（例如，左边的内容表示“当心受伤”。）



…………… 该符号（⊘）表示“禁止”。



…………… 该符号（●）表示“必须”。

[2] 安全注意事项



危险



在关闭电源开关并将电源插头从插座上拔下后，至少等待 5 分钟，再打开控制箱盖。触摸带有高压的区域将会造成人员伤亡。



警告



缝纫机内不允许进入任何液体，否则会引起火灾，电击或操作故障。



如果缝纫机内（机头或控制箱）进入任何液体，请立即关闭电源，并将电源插座头从插座上拔出，然后联系销售商或资深技术人员。



注意

使用环境



请不要在有电源线干扰及静电干扰等有强电气干扰源影响的环下使用。



强电气干扰源可能会影响缝纫机正确操作。



电源电压的波动应该在额定电压的±10%以内的环下使用。

电压大幅度的波动会影响缝纫机正确操作。

电源容量应大于缝纫机的消耗电量。电源容量不足会影响缝纫机的正确操作。



环境温度应在 5℃-35℃ 的范围内使用。



低温或者高温会影响缝纫机的正确操作。



相对湿度应在 45%-85% 的范围内，并且设备内不会结露的环境下使用。干燥或多湿的环境和结露会影响缝纫机的正确操作。



万一发生雷电暴风雨时，关闭电源开关，并将电源插头从插座上拔下。雷电可能会影响缝纫机的正确操作。

请勿将 USB 存储器以为的设备连接到 USB 连接端口上，否则有可能导致故障。

安装



请让受过培训的技术人员来安装缝纫机。



请委托购买商店或电气专业人员进行电气配线。



缝纫机重约 58kg，安装人员必须有两人以上来完成。



在安装完成前，请不要连接电源，如果误踩下脚踏板时，缝纫机动作会导致受伤。



请在切断电源后，在拔掉电插头。不然容易成为控制箱发生故障的原因。



必须接地。



接触地线不牢固，是造成触电误动作原因。



固定电缆时，不要过度弯曲电缆或用卡钉固定得过紧，会引起火灾或触电的危险。



如果使用带小脚轮的工作台，则应该固定小脚轮，使其不能移动。



缝纫机头倒下时，请一定要固定工作台，不可使其随意移动。



工作台移动易发生脚等被夹住之事故，是导致人身事故的原因。



缝纫机头倒下或竖起时，请用双手操作。

单手操作时因缝纫机的重量万一滑落易导致受伤。



使用润滑油和黄油时，务必戴好保护眼镜和保护手套等，以防润滑油落入眼中或沾在皮肤上，这是引起发炎的原因。

另外，润滑油或黄油不能饮用，否则会引起呕吐和腹泻。

将油放在小孩拿不到的地方。



注意

缝纫



本缝纫机仅限于接受过安全操作培训的人员使用



本缝纫机不能用于除缝纫外的任何其他用途。



使用缝纫机时必须戴上保护眼镜。

如果不戴保护眼镜，断针时就会有危险，机针的折断部分可能会弹入眼镜并造成伤害。



发生下列情况时，请切断电源。

否则误按开关缝纫机动作会导致受伤。

- 机针穿线时
- 更换机针或梭芯时
- 缝纫机不使用，或人离开缝纫机时



如果使用带小脚轮的工作台，则应该固定小脚轮，使其不能移动。



为了安全起见，在使用本缝纫机之前，请安装保护装置。如果未安装这些安全装置就使用缝纫机，会造成人身伤害及缝纫机损坏。



缝纫过程中，不要触摸任何运动部件或物件靠在运动部件上，因为这会导致人员受伤或缝纫机损坏。



缝纫机头倒下时，请一定要固定工作台，不可使其随意移动。

工作台移动容易发生脚等被夹住事故，是导致人身事故的原因。



缝纫机头倒下或竖起时，请用双手操作。

单手操作时因缝纫机的重量万一滑落容易导致受伤。



如果缝纫机操作中发生误操作，或听到异常的噪音或闻到异常的气味，应立即切断电源。然后请与购买商店或受过培训的技术人员联系。



如果缝纫机出现故障，请与购买商店或受过培训的技术人员联系

清洁



在开始清洁作业前，请切断电源。

如果误按开关缝纫机动作会导致人员受伤。



缝纫机头倒下时，请一定要固定工作台，不可使其随意移动。

工作台移动易发生脚等夹住事故，是导致人身事故的原因。



缝纫机头倒下或竖起时，请用双手操作。

单手操作时因缝纫机的重量万一滑落易导致受伤。



使用润滑油和黄油时，务必戴好保护眼镜和保护手套等，以防润滑油落入眼中或沾在皮肤上，这是引起发炎的原因。

另外，润滑油或黄油不能饮用，否则会引起呕吐和腹泻。

将油放在小孩拿不到的地方。

保养和检查



只有经过训练的技术人员才能进行缝纫机的维修、保养和检查。



与电气有关的维修、保养和检验请委托购买商店或电气专业人员维修。



发生下列情况时，请关闭电源，并从电源插座上拔下插头。

否则误按开关时缝纫机会导致误伤。

- 检查、调整和维修
- 更换旋梭，切刀容易损零部件



打开马达罩盖前，务必先关闭电源，等待一分钟后，再执行操作。

触摸马达表面可能会导致烫伤。



在接上电源开关进行调整时，务必切换到保养模式，遵守所有注意事项。



缝纫机头倒下时，请一定要固定工作台，不可使其随意移动。工作台移动易发生脚等被夹，导致人员事故。



缝纫机头倒下或竖起时，请用双手操作，单手操作万一滑落容易导致受伤。

更换零件或安装可选附件时，请务必使用正品零件。否则将不承担由使用非正品零件而造成的任何事故或故障责任。



安全保护装置再次安装时，请务必安装在原位上，并检查能正常发挥作用。



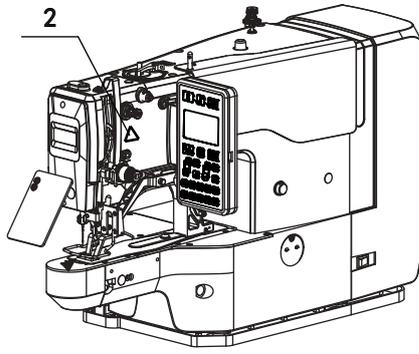
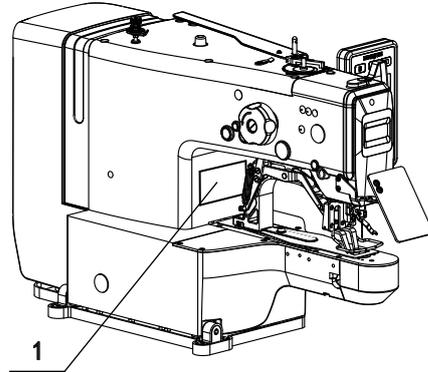
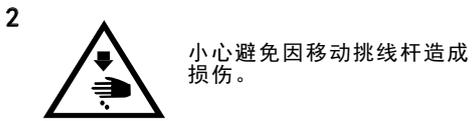
为防止发生事故及故障，请勿擅自改造本缝纫机。我们将不承担由改造缝纫机而造成的任何事故及故障责任。



[3] 警告标签

缝纫机上有下列警告标签。

当使用缝纫机时，请遵守标签上的说明。如果标签脱落或模糊不清，请和购买商店联系。



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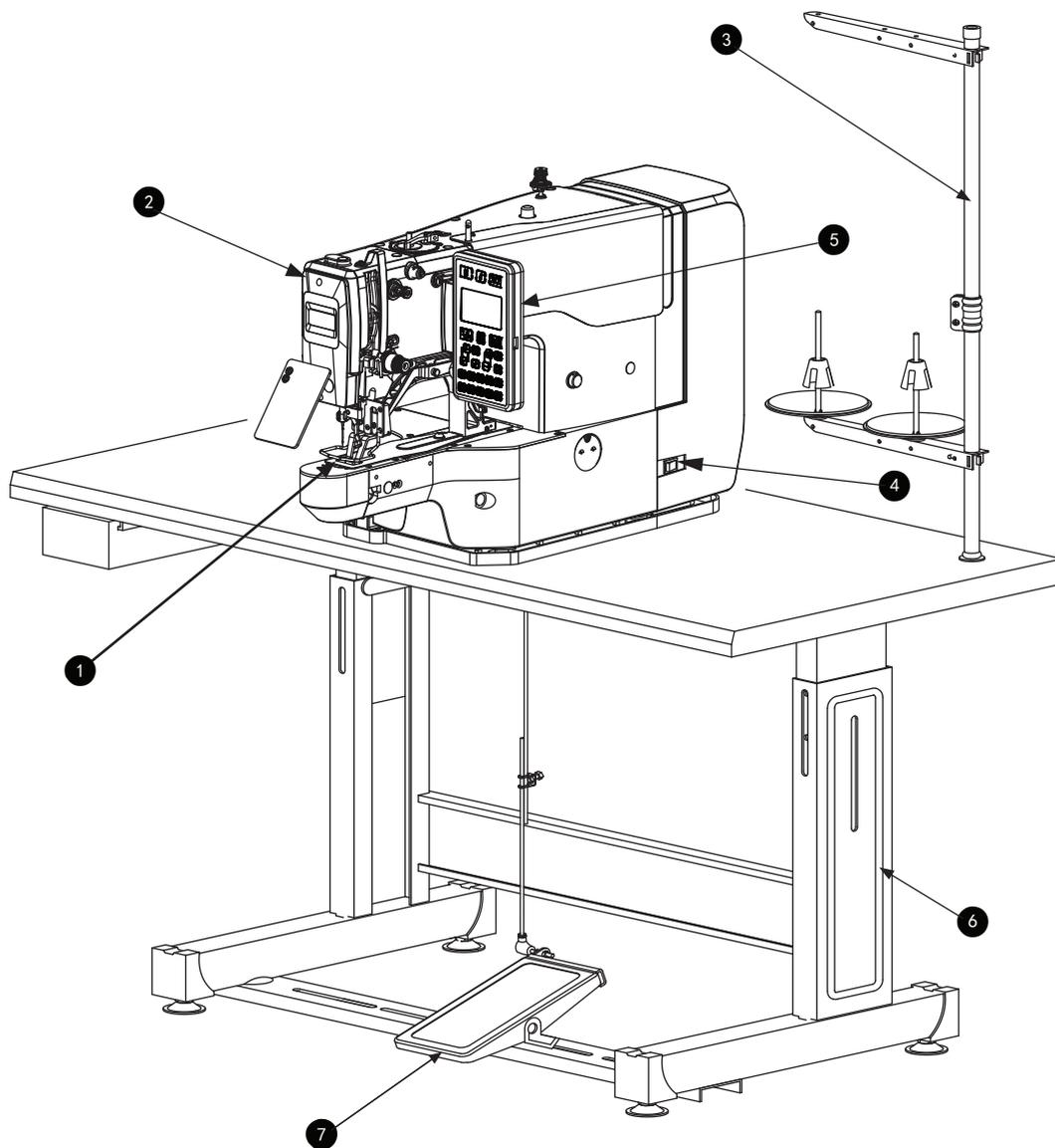
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I.一体式高速电子套结机说明

[1] 规格

1. 缝制范围：X（左右）方向 40mm，Y（前后）方向 30mm
2. 缝纫速度:3200rpm
3. 线迹长度：0.1-12.7mm
4. 压脚送布：间断送布
5. 针杆行程：41.2mm
6. 使用机针：DP×5、DP×17
7. 压脚上升量：标准 13mm 最大 17mm
8. 旋梭：标准摆梭（油线润滑）
9. 使用机油：10#白油
10. 数据记录：EPROM
11. 放大、缩小功能：X 方向、Y 方向各为 20-200%
12. 放大、缩小方式：调整线迹长短方式
13. 缝纫速度限制：400-3500，3500rpm（针距
X≤5，Y≤3.5）（100rpm）
14. 图案选择功能：图案 NO.指定（1-200）
15. 底线计数器：上升/下降方式（1-999999）
16. 缝纫机马达：550W 伺服马达
17. 外形尺寸：W：1200mm L：540mm H:1100mm
18. 重量：整机 57.4Kg
19. 功率：0.125KW
20. 使用温度范围：0℃-50℃
21. 使用湿度范围：35%-85%（无节露）
22. 电源电压：额定电机±10% 50-60Hz

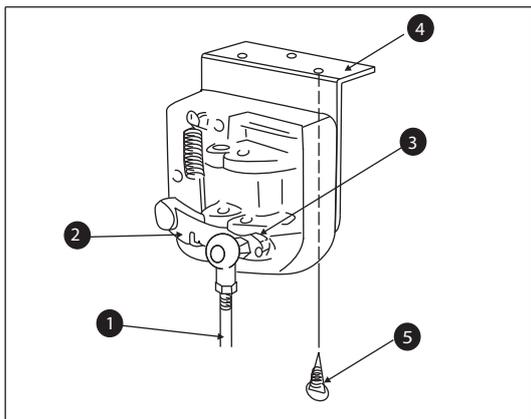
[2] 各部件名称



- (1). 送布压脚
- (2). 缝纫机机头
- (3). 线架
- (4). 电源开关
- (5). 操作面板
- (6). 机架
- (7). 脚踏开关

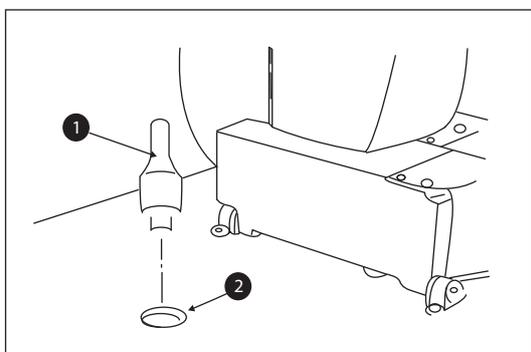
[3] 整机安装

1. 脚踏开关拉杆的安装



- (1). 将脚踏开关拉杆①穿过脚踏开关曲柄②孔，用螺母③固定，上下拉动脚踏开关拉杆①，运动灵活，调整踏板至合适位置。
- (2). 将脚踏安装板④用木螺丝⑤固定在合适的位置。

2. 机头支撑杆的安装

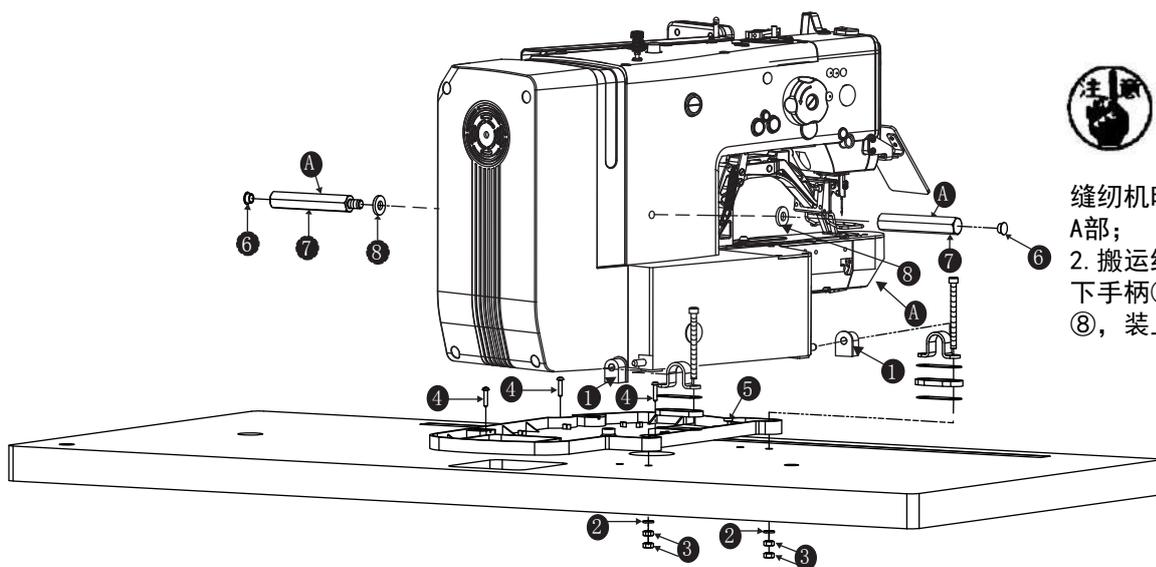


将机头支撑杆①装在台板孔②内。

3. 机头的安装



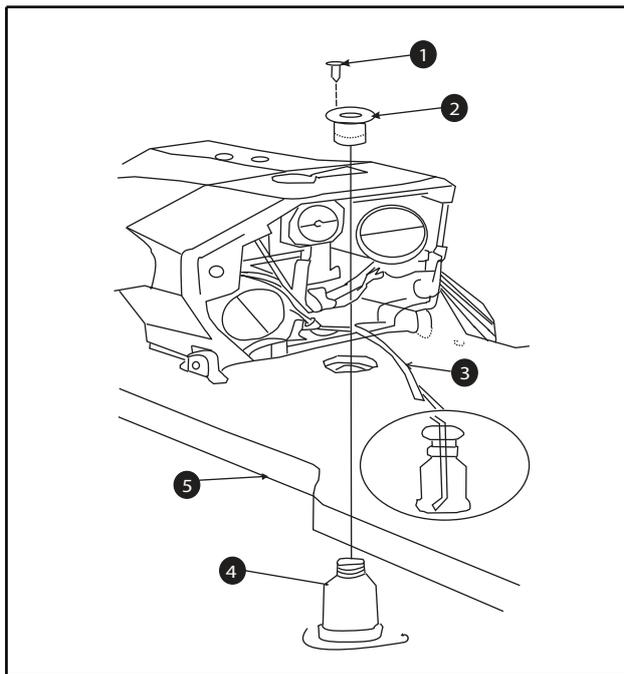
注意 搬运缝纫机时，请一定是两人以上进行操作。



1. 搬运缝纫机时，请手持A部；
2. 搬运结束，请卸下手柄⑦及橡胶垫⑧，装上橡胶塞⑥。

- (1). 将油盘⑤用木螺钉④固定在台板相应位置上；
- (2). 将机头胶垫①穿在机器支撑轴上，固定缝纫机主体；
- (3). 将平垫②、螺母③按图示依次固定，注意螺母③的锁紧力量，如果拧的太紧，防震效果不理想

4. 废油壶的安装

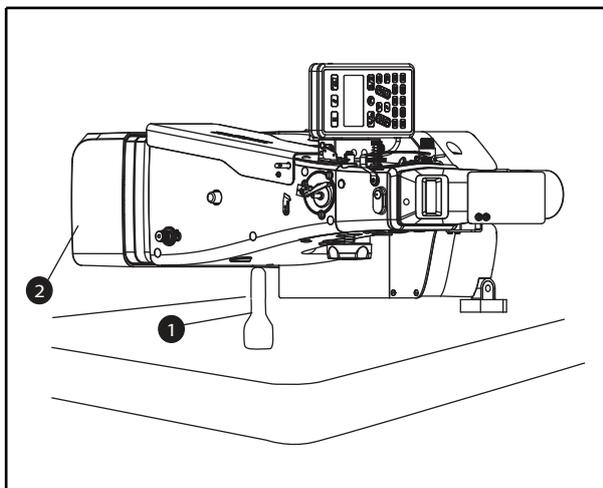


用四个木螺丝①把废油壶上节②固定到台板⑤孔内，将废油壶④从台板①下方旋进废油壶上节②中，并将机头回油管③装在废油壶中。



机头放倒后，回油管③不能从废油壶中脱落。

5. 机头的放倒

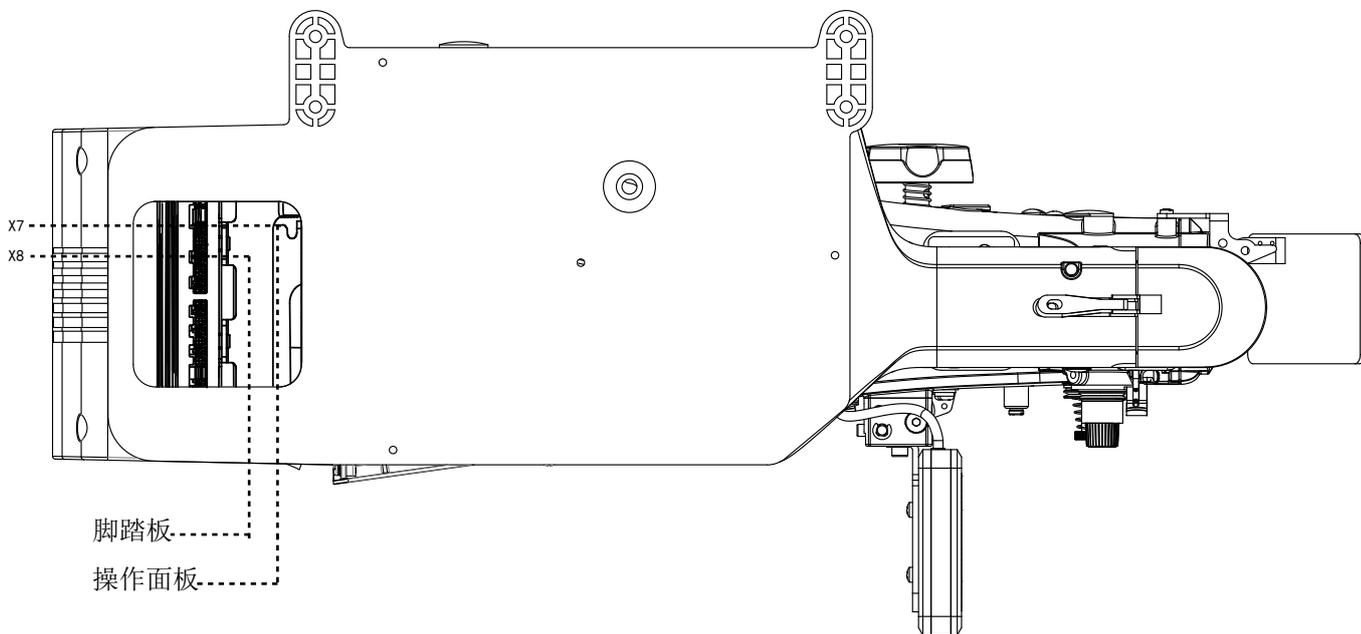


将机头②轻轻放倒，靠在机头支撑杆上①上。



1. 放倒机头前，请先确认台板上是否有机头支撑杆；
2. 抬起机头时，请不要扳机头后罩，以免后罩受损；
3. 为防止机头侧翻，请确保台板水平。

6.电线的连接

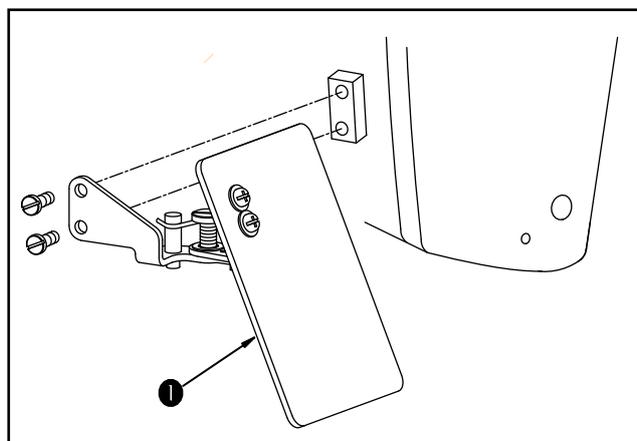


7. 眼睛防护罩的安装



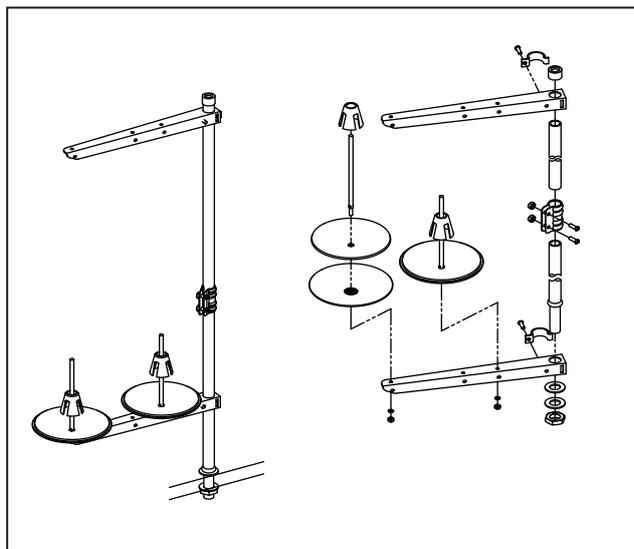
注意

为防止断针飞起弄伤眼睛，请一定安装起来。



将附件箱中眼睛防护罩装在机头
如图所示左侧。

8. 线架的安装



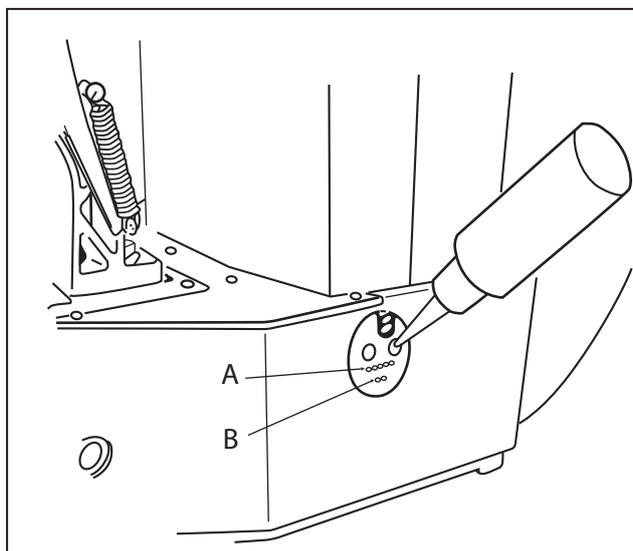
将附件箱中的线架如图装在台板孔上。

[4] 整机的准备

1. 加油



为了防止突然启动造成人身事故，请关掉电源后再进行。



请确认机油在下线 B 和上线 A 之间。如果机油过少时，请用附属的加油器进行加油。加油的油槽仅是向摆梭加油的。使用转速低时，如果摆梭的油量过多，可以把油量调小。（请参照[5]维修—7.摆梭油量的调整。）

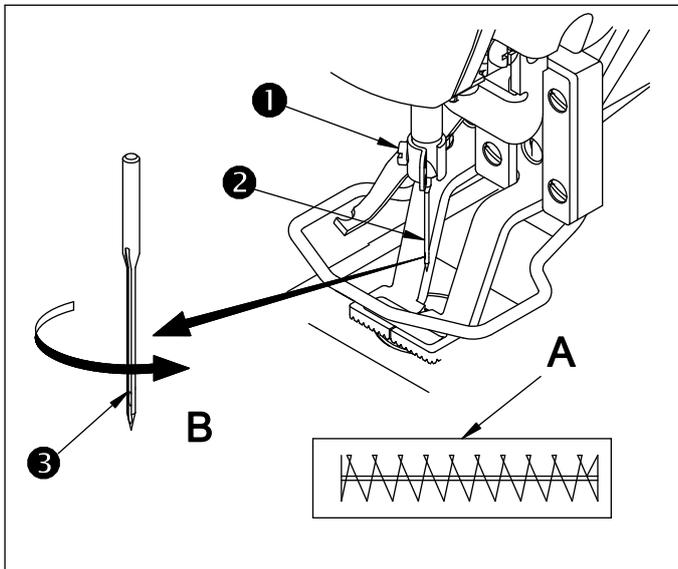


1. 请注意不要向油槽和下列注意 2 的摆梭以外的部位加油。否则会发生零件故障。
2. 初次使用缝纫机或较长时间没有使用缝纫机时，请向摆梭加少量的机油后在使用缝纫机。（请参照[5]维修—2. 机针和摆梭）。

2. 机针的安装



为了防止突然启动造成人身事故，请关掉电源后再进行。



安装机针时，请拧松固定螺钉①，把机针②的容线槽③朝向面前，插进针杆的深处，然后拧紧固定螺钉①。

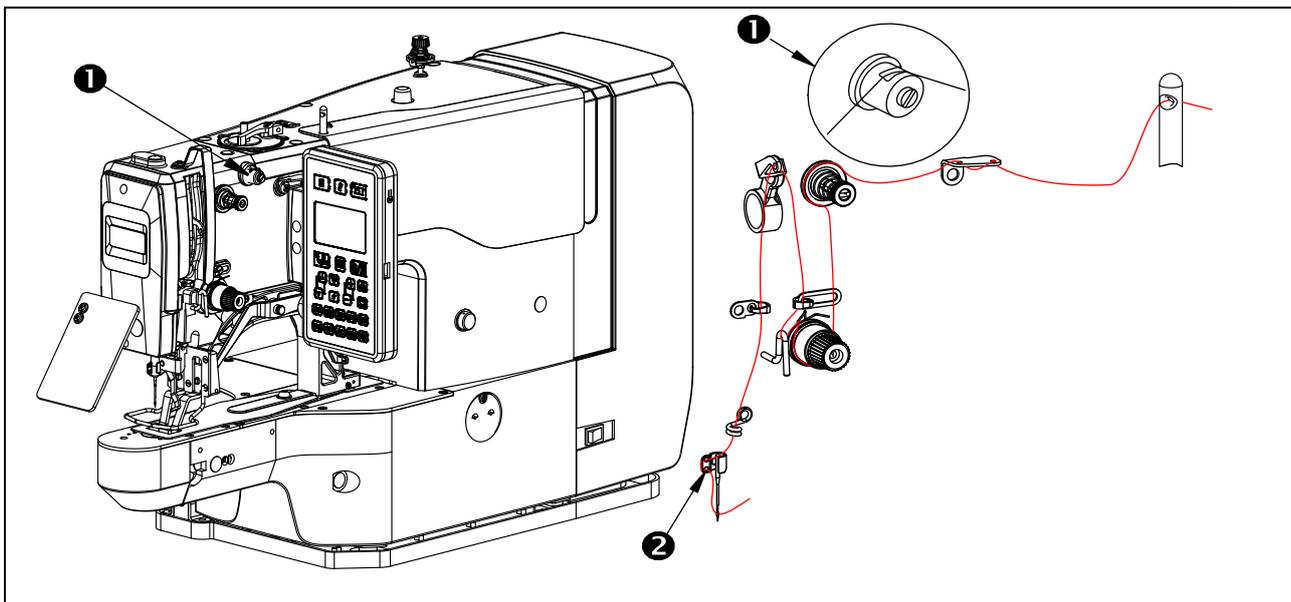


缝迹如 A 时，请把机针向 B 方向稍稍移动然后安装起来。

3. 上线穿线



为了防止突然启动造成人身事故，请关掉电源后再进行。



穿过机针的线应留出 4cm 左右。

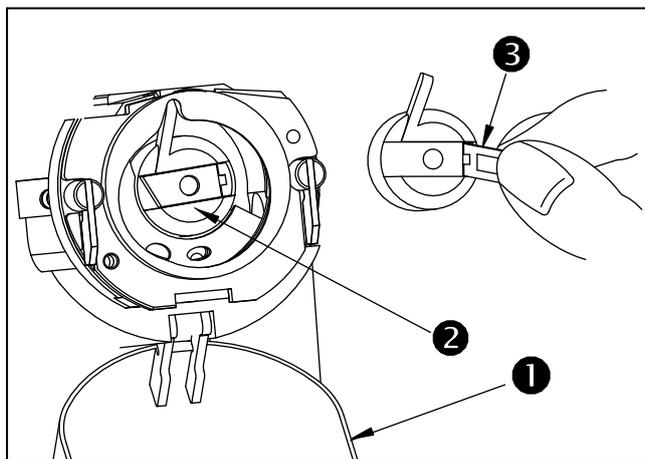


1. 使用硅油时，请把线穿过润滑导线器①。
2. 粗线时，请把机线只穿过针杆导线器②1 个孔。

4. 梭壳的取下插入



为了防止突然启动造成人身事故，请关掉电源后再进行。



- (1). 打开梭床外罩①。
- (2). 拨起梭壳②的抓脚③，取出梭壳。
- (3). 插入时，请把梭壳深深插入摆梭轴，并关闭抓脚。

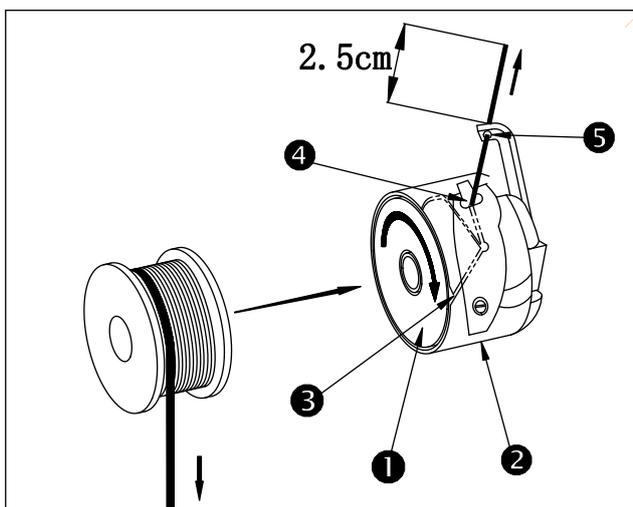


如果没有插到底，缝制途中梭壳②就有可能脱落。

5. 梭芯的插入方法



为了防止突然启动造成人身事故，请关掉电源后再进行。

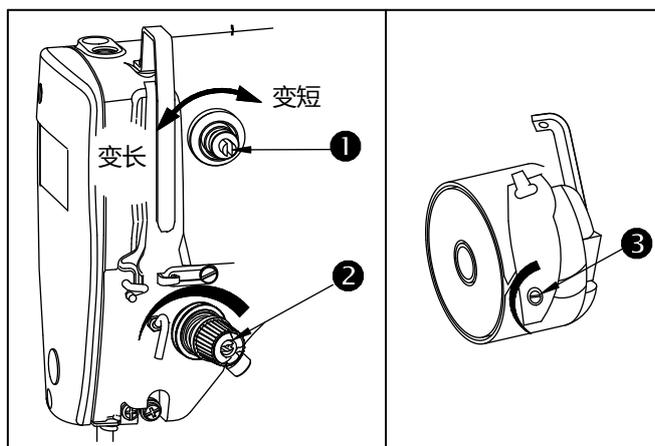


- (1). 把梭芯①按图示的方向插入梭壳②。
- (2). 把线穿过梭壳②的穿线口③，然后拉线，把线从线张力弹簧下面的穿线口④拉出来。
- (3). 把线从梭壳②的线孔⑤穿出，从线孔约拉出2.5cm。



底线的旋转方向请按照左图所示；如果相反的话底线的拉出就不稳定。

6. 线张力的调整

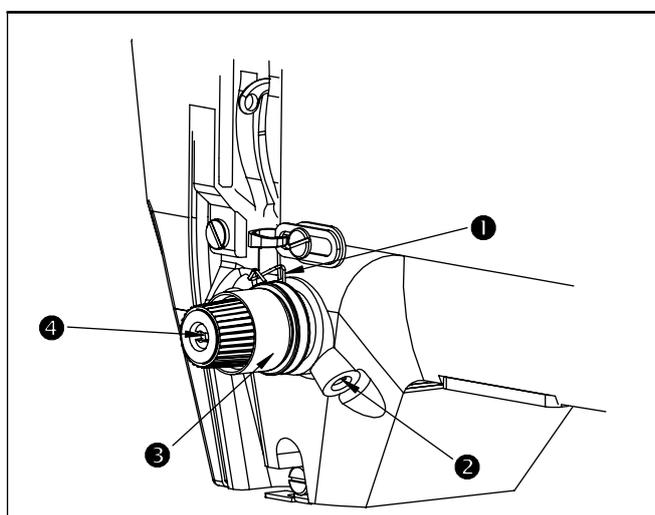


把第一线张力就旋钮①向右转动，切线后针尖上的残线长度变短，向左转动后变长。

请尽量在不脱线的情况下弄短残线。

用②调整面线张力，用③调整底线张力。

7. 挑线弹簧的调节



挑线弹簧①的标准移动量为 8~10mm 开始挑线时的强度为 0.1~0.3N。

(1). 移动量的调节

拧松固定螺钉②，转动夹线器挡圈③。

(2). 强度的调节

改变挑线弹簧的强度时，请在螺丝②拧紧的状态下，把细螺丝刀插到夹线器螺钉④的缺口部转动调节。向右转动之后，挑线弹簧的强度变强，向左转动之后，强度变弱。

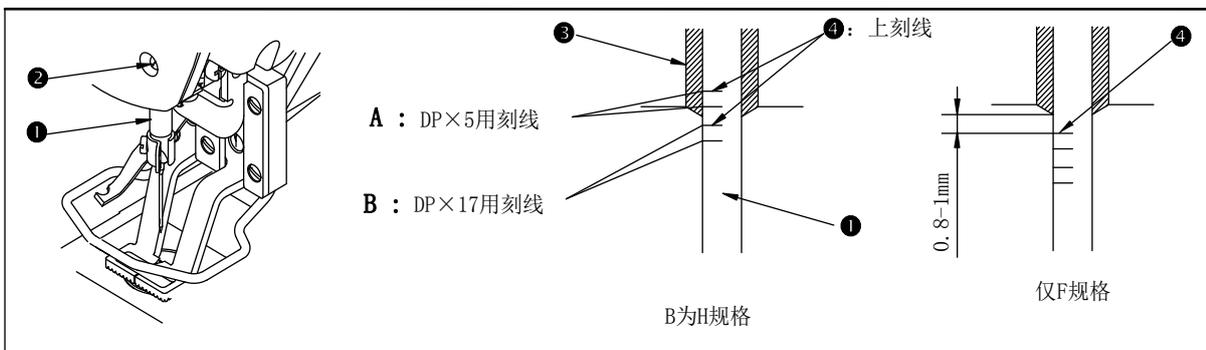
[5] 维修

1. 针杆高度



注意

为了防止突然启动造成人身事故，请关掉电源后再进行。



把针杆①设到最下点，拧松针杆紧固螺丝②，把针杆上刻线④和针杆下套③的下端调节成一致。



注意

请调节后一定确认不要有松动。有的缝制条件发生跳针时，请从针杆上刻线④往下调节 0.5mm-1mm。

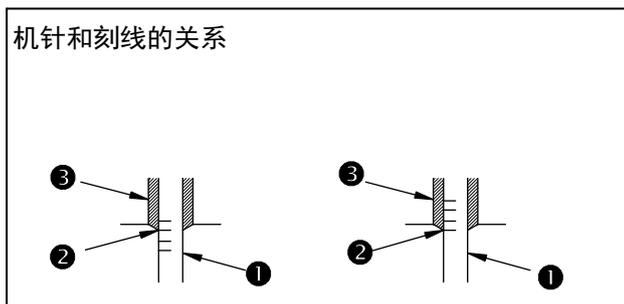
2. 机针与摆梭



注意

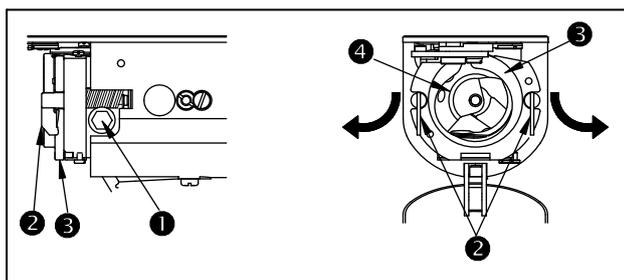
为了防止突然启动造成人身事故，请关掉电源后再进行。

机针和刻线的关系

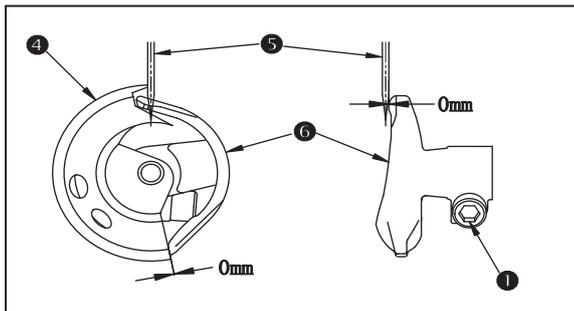


(1) 用手转动手轮，针杆①上升时，把下刻线②对准针杆下套前端一致。

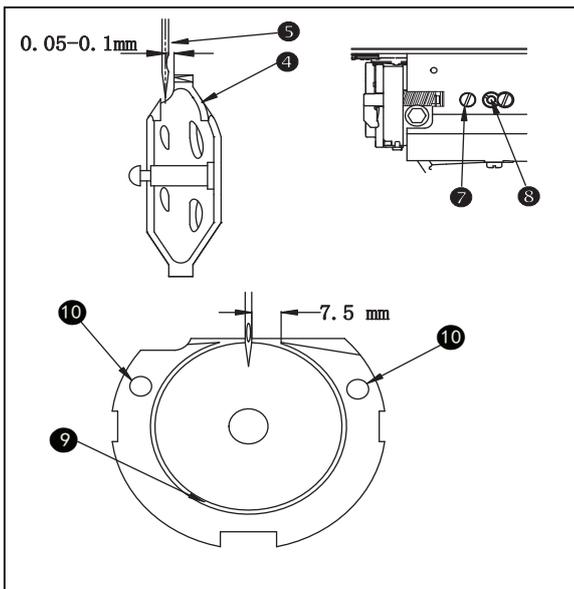
(2). 拧松驱动器固定螺丝①，左右打开梭床盖压片②，卸下梭床盖③。



此时请注意不要脱落摆梭④。



(3)为了让摆梭④的梭尖与机针⑤的中心一致，同时防止驱动器⑥在前段面与机针相碰，弄弯机针，请把驱动器前端面与机针的间隙调整为 0mm，然后把驱动器固定螺丝①拧紧。



(4). 拧松梭床固定螺丝⑦，左右转动梭床调节轴⑧，调节梭床的前后位置，把机针⑤和摆梭④的梭尖的间隙调整为 0.05~0.1mm。
 (5). 调节完梭床的前位置后，机针和梭床的间隙应为 7.5mm，然后拧紧梭床固定螺丝⑦。

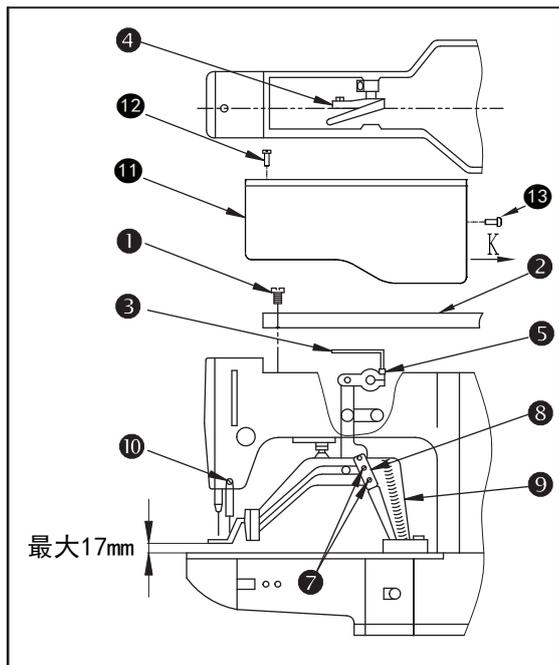


较长时间没有使用缝纫机或清扫过摆梭周围之后时，请往导轨部⑨和油芯⑩加少量的机油后再使用。

3. 压脚的高度



为了防止突然启动造成人身事故，请关掉电源后再进行。



(1)在停止状态，卸下右装饰板⑪上的⑫、⑬ 两颗螺钉，然后往K方向卸下右装饰板⑪。
 (2)卸下 6 只机壳上盖固定螺丝①，然后卸下机壳上盖②。
 (3)把 L 形扳手插入中央的紧固筒的六角孔螺栓⑤，把它拧松。
 (4)把 L 形扳手③向下压布压脚升高，向上抬布压脚降低。
 (5)调节后，把六角孔螺栓⑤确实拧紧。
 (6)左右压脚不一致时拧松固定螺丝，⑦调节压脚杆挡板⑧调整高度。

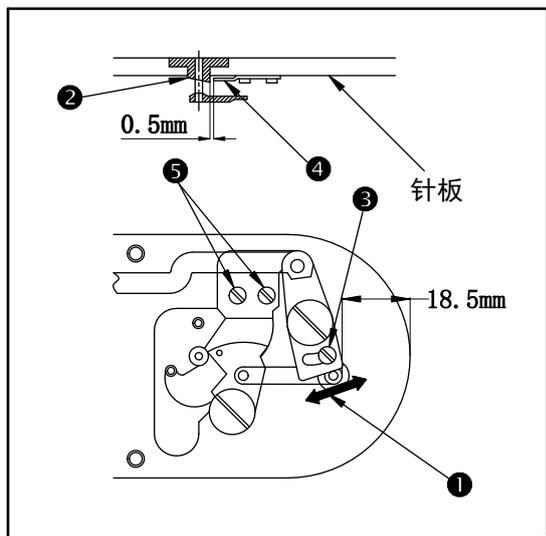


此时，请不要让布压脚拨档杆板⑧与送料架⑨相碰。如果和拨线杆相碰，请用拨线杆安装台固定螺丝⑩调节拨线杆高度。

4. 动刀和定刀



为了防止突然启动造成人身事故，请关掉电源后再进行。

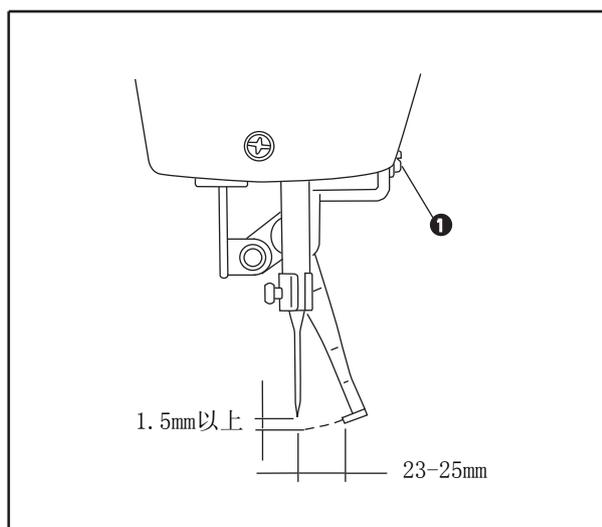


- (1). 拧松调节螺丝③，向箭头方向移动动刀，把从针板前段刀切线小拨杆①前段的距离调整为 18.5mm。
- (2). 拧松固定螺丝⑤，移动固定刀，把针孔导线器②和固定刀④之间的间隙调整为 0.5mm。

5. 扫线杆的调整



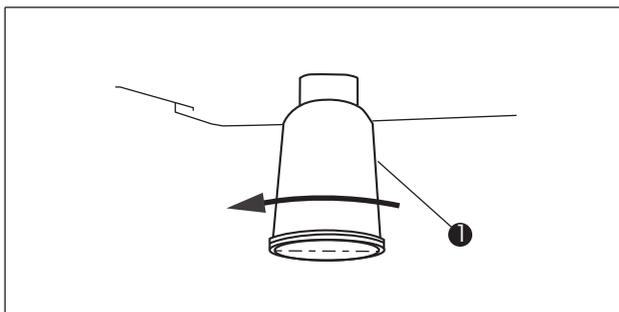
为了防止突然启动造成人身事故，请关掉电源后再进行。



拧松螺丝①把挑线杆和机针的间隙调整为 1.5mm 以上。此时的扫线杆和机针的距离大约为 23~25mm 通过较宽的调整，在压脚下降时可以防止压到纫机线。特别是使用细针时，请调宽到 23mm 左右。

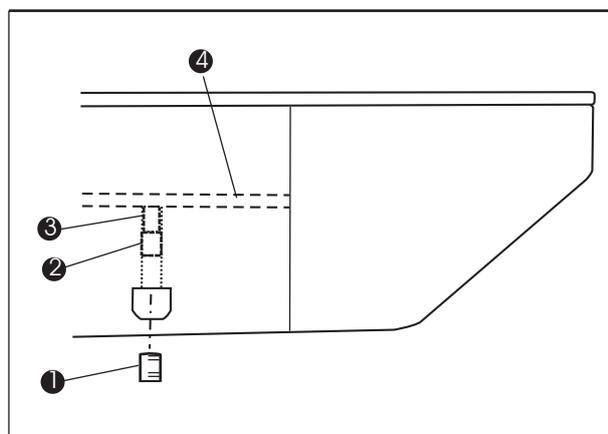
※ 机针为缝制结束停止的位置。

6. 废油的处理



积油杯①里积满了油之后，请卸下积油杯①排放出废油。

7. 旋梭油量调整



- (1). 拧松固定螺丝①，卸下固定螺丝①。
- (2). 拧紧调整螺丝②之后，加油管左④的油量杯弄小。
- (3). 调整后，拧紧固定螺丝①固定好。



1. 在标准出货状态，轻轻拧紧②回转 4 圈的位置。
2. 弄小油量时，不要一次拧紧，拧紧②回转 2 圈，待半日左右观看一下。拧得过紧的话会磨损旋梭。

8. 向指定部位补充润滑油

使用缝纫机进行了一定的缝制次数之后，打开电源时操作盘上会显示出异常代码 No. E221。这是通知需要向指定部位补充润滑油，此时请一定补充下列润滑油，叫出存储器开关 No. 245，用复位键复位到[0]。显示出异常 No. E221 显示后，按复位键可以解除异常，但再次打开电源后会再次显示出 No. E221。

而且，异常 No. E220 显示，继续缝制一定期间后会显示出异常 No. E221，按复位键不能解除异常，同时缝纫机变成不能动作。因此，显示出异常 No. E221 以后，请一定向下列部位补充润滑油，然后启动存储器开关 No. 245，用复位键复位到[0]。

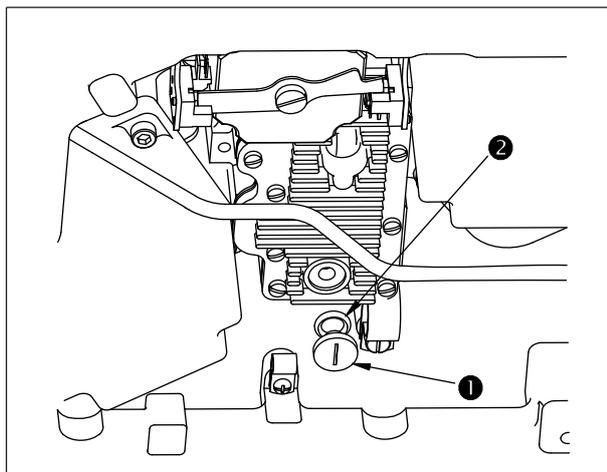


补充润滑油之后，如果不把存储器开关 No. 245 变更为[0]，异常 No. E220 或 No. E221 会被再次显示。



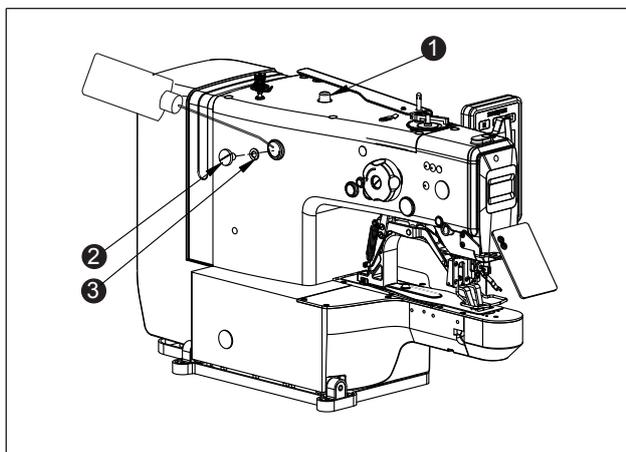
为了防止突然启动造成人身事故，请关掉电源后再进行。

(1). 将齿轮箱的废油放光



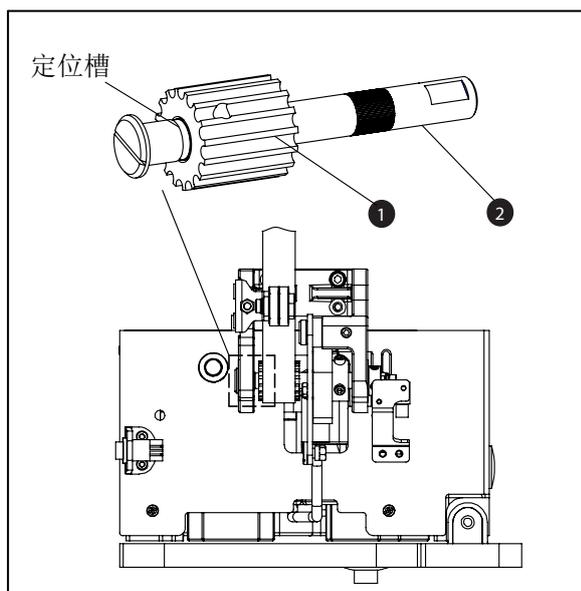
- A. 放倒缝纫机，卸下密封螺钉①和密封圈②。
- B. 放正缝纫机，把齿轮箱内的油放光。
- C. 放倒缝纫机，把密封圈②和密封螺钉①装回去，然后再放正缝纫机。

(2). 向齿轮箱中加入润滑油



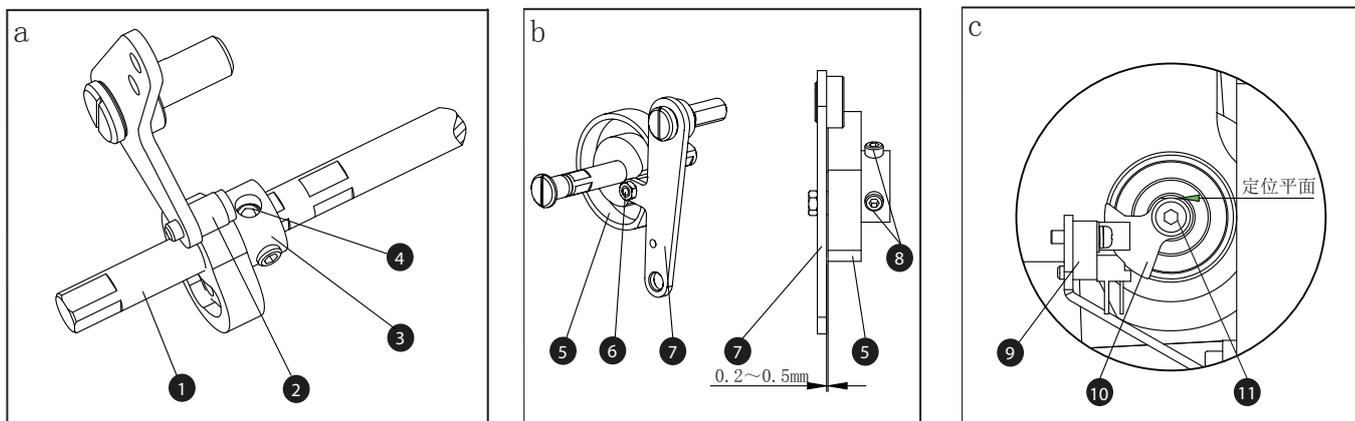
- A. 当通过油窗①观察到出油不明显或无出油时，应即时往齿轮箱内加油；
- B. 在停机状态下，取下螺钉②与橡胶垫圈③，加10#白油，无出油时，加100ml，出油不明显时，加50-70ml。装回②与③，启动机器观察出油是否明显。

9. 剪线驱动带轮位置的调整



按如图所示，将剪线驱动带轮①装配后，使带轮左端面与剪线驱动轴②上定位槽右端面对齐，拧紧带轮①上的两颗紧定螺钉。

10. 剪线凸轮和剪线安全传感片的调整

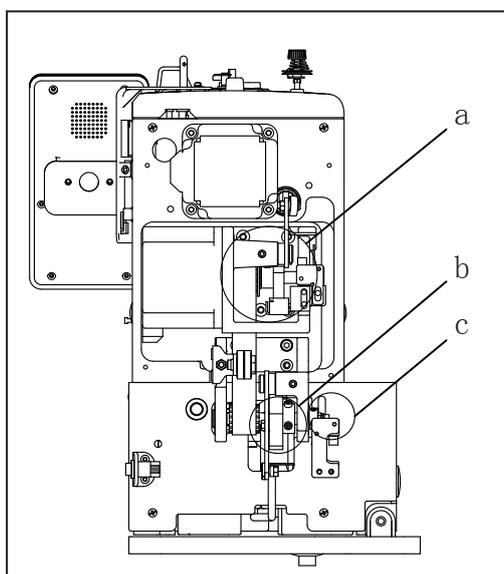


<1>剪线凸轮的调整

- (1) 转动抬压电机轴①，将抬压凸轮③转至与抬压滚柱②最低点接触时，即螺钉紧定螺钉④朝向正上方位置，如图a所示。
- (2) 此时，调整剪线滚柱⑥在剪线凸轮⑤的凹槽最底部位。
- (3) 调整剪线曲柄⑦与剪线凸轮⑤端面距离0.2~0.5左右，如图b所示锁紧剪线凸轮的两个螺钉⑧。

<2>剪线安全传感片的调整

- (4) 转动抬压电机轴①，将抬压凸轮③转至与抬压滚柱②最低点接触时，即螺钉紧定螺钉④朝向正上方位置，如图a所示。
- (5) 此时，将剪线安全传感片⑩的定位平面水平朝正上方位置，并将剪线安全传感片⑩置于剪线安全传感器⑨内，如图c所示，锁紧螺钉组件⑪，固定剪线安全传感片⑩。
- (6) 当脚踏第一踏时，压脚下压，确保剪线安全传感片⑩未进入剪线安全传感器⑨内，再第二踏开始缝制，此时缝制正常，若有报错剪线异常“E-018”，请松开螺钉组件⑪顺时针方向调整剪线传感片⑩的位置。



[7]. 标准压脚一览表

压脚号码	1	2	3	4	5
压布压脚	左: 10011508 右: 10011505			左: 10011687 右: 10011691	左: 10011758 右: 10011759
压布底板	10011565	10012300	10012279	10011751	10011755
	有齿牙	无齿牙	无齿牙	有齿牙	有齿牙
缝制规格	S	F	F	H	M
护指器	10011556(S、M、F)、10011695(H)				
备注	S(标准)规格机头上标准装备。	F(内衣)规格机头上装备。(根据出口地)		选购品	M(针织)规格机头上标准装备。

压脚号码	6	7	8	9	10	11
压布压脚	左: 10012349 右: 10012342		左: 10012339 右: 10012346	左: 10012341 右: 10012348		左: 10026244 右: 10026245
压布底板	10012277	10012302	10012286	10012296	10012301	10026246
	有齿牙	有齿牙	有齿牙	无齿牙	无齿牙	无齿牙
缝制规格	S	H/W	S	F	F	F
护指器	10011556(S、M、F)、10011695(H、W)					
备注	选购品	H(厚料)、W(倍旋梭)规格机头上标准装备		选购件	F(内衣)规格选购品。(根据出口地)	选购品

压脚号码	12	13	14	15	16
压布压脚	左: 10026247 右: 10026248	左: 10026250 右: 10026251	左: 10012344 右: 10012345	左: 10026253 右: 10026254	左: 10026256 右: 10026257
压布底板	10026249	10026252	10012338	10026255	10026258
	有齿牙	无齿牙	无齿牙	有齿牙	有齿牙
缝制规格	F	S	S	S	S
护指器	10011556				
备注	选购品	选购品	选购品	选购品	选购品

※更换压脚时，请安装合适各压脚的手指保护器。

[8] 选购件一览表

零件名称	种类	货号	备考
送料板 t=1.2 	有齿牙 / 有表面处理 缝制范围 纵 20× 横 40	10012303	
	有齿牙 / 有表面处理 缝制范围 纵 30× 横 40	10014401	
小针板 	A=1.9 B=2.8 无槽	10047532	S 规格
	A=1.6 B=2.0 无槽	10011757	F.M 规格
	A=2.3 B=4.0 无槽	10004727	H 规格
	A=3 B=7 无槽	10007281	渔网机用
	A=1.6 B=2.6 有槽	10004646	选用件

II. 一体式高速电子钉扣机的说明

[1] 规格

这里只记述与套结机不同部位的说明内容。

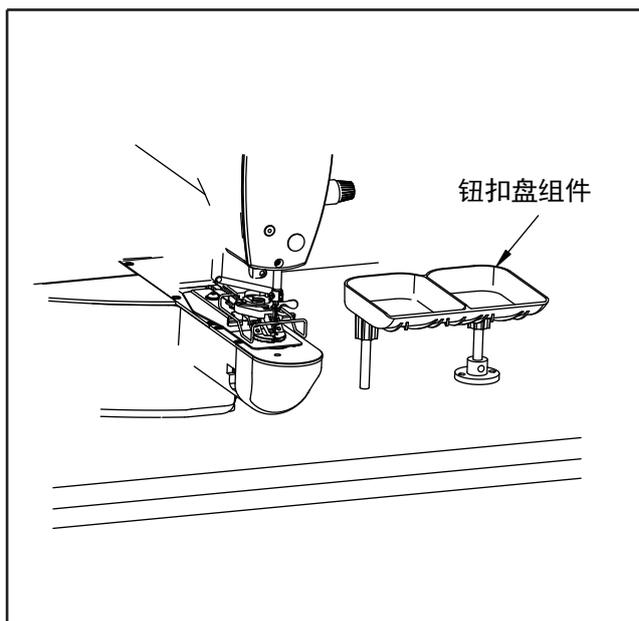
- (1). 转速..... 最高 2700rpm
- (2). 使用机针..... DP X 17 #14
- (3). 压脚提升方式..... 脉冲马达
- (4). 压脚上升量..... 最大 13mm
- (5). 记忆数据数量..... 50 种
- (6). 拨线方式..... 脉冲马达压脚提升连动

[2] 安装和缝纫前的准备



注意

搬运缝纫机时，一定要 2 人以上来搬运。



- (1). 机头的安装与套结机相同，请参照套结机使用说明书。
- (2). 附属品安装在纽扣盘架上，请安装到容易作业的位置。



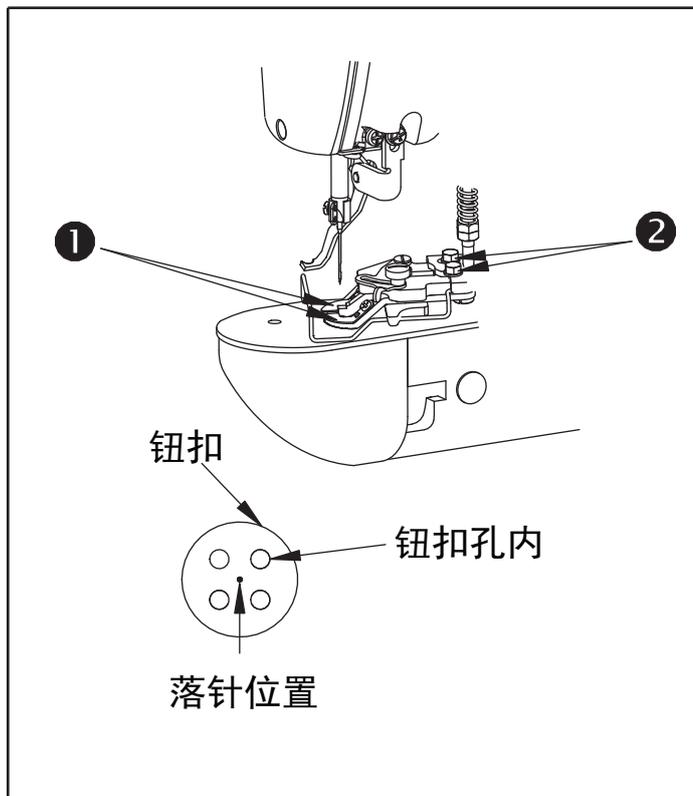
运转前请转动手轮确认机针是否与纽扣相碰。

[3] 机针和缝线

机针	上线	底线
DPx17 #14	#60	#80
	#60	#60
	#50	#60
	#40	#60

机针和机线，因缝制条件不同而不同，使用时请参照左表选择，最好使用棉线、缝纫机线。

[4] 纽扣夹的位置



- (1). 把纽扣放入纽扣抓脚①。
- (2). 在缝制 LED 灭灯的状态，按操作盘  键，再按  键，各部件找零。
- (3). 转动手轮，确认机针中心是否在纽扣中心。确认原点位置。
- (4) 如果机针没有在纽扣中心位置时，请拧松纽扣抓脚安装台固定螺丝②，进行调整。
- (5) 调节后，请确认图案形状。确认机针是否正好落在纽扣孔内。



注意

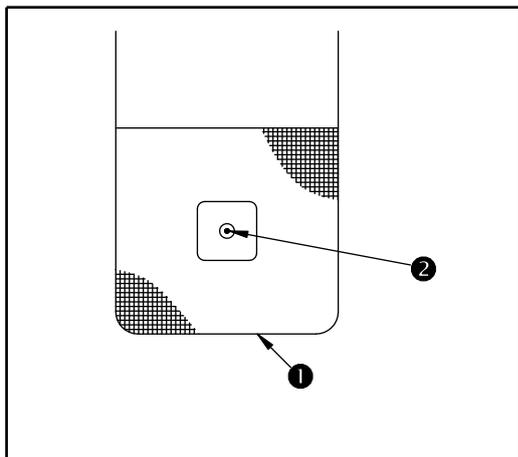
变更了纽扣的形状、图案，或利用扩大缩小功能变更了缝纫宽度之后，请一定要确认落针位置。如果机针落到纽扣外，图案超出抓起装置，机针在缝制中会发生断针的危险。

[5] 送料板的调整



注意

变更了钮扣形状、图案，或利用扩大缩小功能变更了缝纫宽度之后，请一定要确认落针位置。如果布压脚与针孔导板相碰，会发生断针的危险。另外，调整中如果踩了踏板，爪脚装置会上下移动，请注意危险。



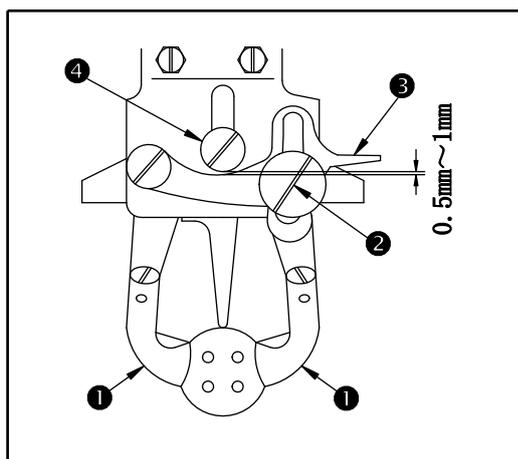
- (1). 在缝制 LED 灭灯的状态，按操作盘  键，再按  键，各部件回零。
- (2)调整布压脚底板①，使针孔导板②正好在布压脚底板①的H部的中心。

[6] 纽扣夹张开角度调整



注意

为了防止突然的启动造成人身事故，请关掉电源，确认马达完全停止后在进行操作。

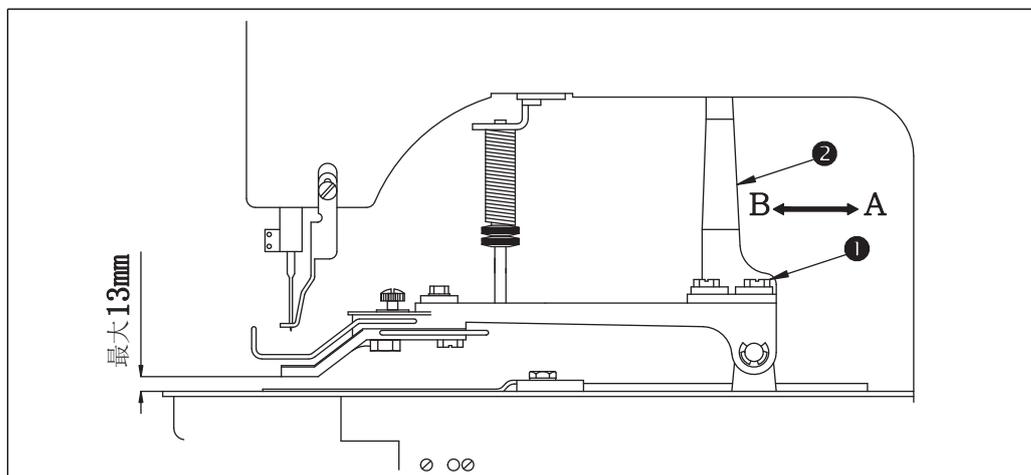


在让停止位置的抓脚①上升的状态，拧松开关抓脚拨杆固定螺丝②，让纽扣设定到抓脚②，把抓脚打开拨杆③和塔形螺丝④之间的间隙为 0.5~1mm，然后拧紧打开抓脚拨杆固定螺丝②。

[7] 纽扣夹上升高度的调整

**注意**

为了防止突然的启动造成人身事故，请关掉电源，确认马达完全停止后在进行操作。

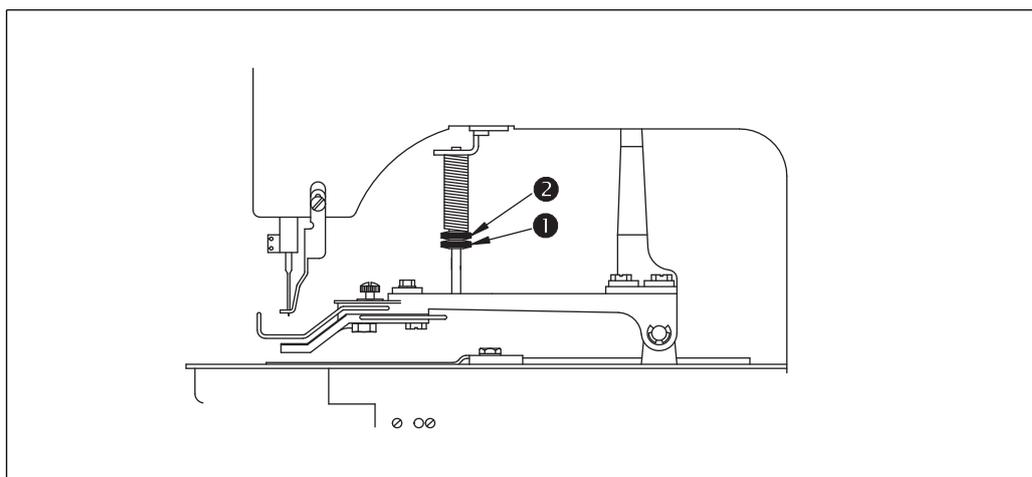


请拧松 2 个固定螺丝①，前后调整压脚的提升动作板②进行调整。把压脚提升动作板②向 A 方向移动后，提升量变低，向 B 方向移动后，则变高。调整后把固定螺丝确实拧紧固定。

[8] 压脚压力的调整

**注意**

为了防止突然的启动造成人身事故，请关掉电源，确认马达完全停止后在进行操作。



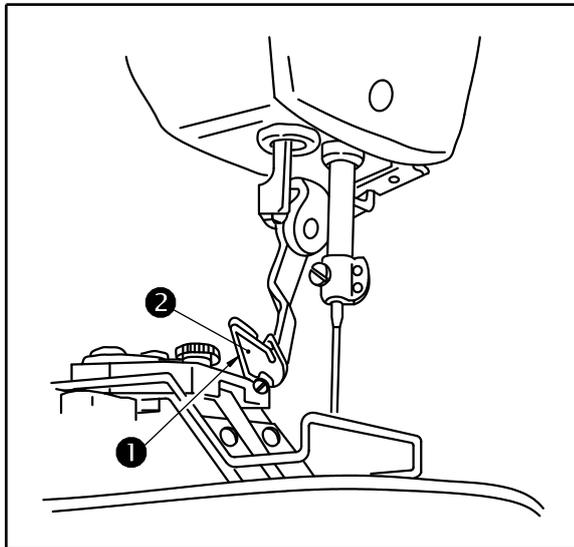
拧松调整螺丝①，转动调节螺丝②，使布料运转中尽量不要偏斜。

[9] 扫线杆弹簧的调整



注意

为了防止突然的启动造成人身事故，请关掉电源，确认马达完全停止后在进行操作。



调整扫线杆弹簧①，使扫线杆弹簧①把切线后的上线保持到挑线杆②之间，这时的强度为 20~30g（比从梭壳出来的底线稍强）。



保持过强的话，旋梭上的线就会脱落。

[10] 缝制范围

机种名称		钉扣机	
纽扣尺寸分类		中小纽扣用	
可以缝制的纽扣外径 (mm)		Ø8~Ø22	
缝制尺寸 (mm)	纵	0~3.5	
	横	0~3.5	

III. 缝纫时故障、原因及对策

现象	原因	对策
1. 始缝时脱线	①始缝时跳针。 ②切线后上线长度短。 ③底线过短。 ④第一针的上线张力高。 ⑤第一针的间距小。	○机针和旋梭的间隙调整为 0.05~0.1mm ○设定始缝时软起动。 ○调节第 2 线张力器的浮线量。 ○把挑线弹簧弄强或把第一线张力盘的张力减弱。 ○减弱底线张力。 ○弄大针孔导向器和固定刀的间隙。 ○降低第一针的张力。 ○降低缝制开始第一针的转速。 ○增长第一针的间距。 ○下降第一针的上线张力。
2. 老断线。 化纤纤维拉断	①摆梭、驱动器上有伤。 ②针孔导向器上有伤。 ③机针碰布压脚。 ④线头进入大旋梭的沟里。 ⑤上线张力过强。 ⑥挑线弹簧过强。 ⑦化纤纤维摩热而断。	○卸下用细磨时或挫刀磨平。 ○用锉刀磨，或换新。 ○调节布压脚的位置。 ○卸下摆梭，清除线头。 ○减弱上线张力。 ○减弱挑线弹簧。 ○使用硅油。
3. 常断针	①针弯了。 ②针碰布压脚。 ③针过粗。 ④驱动器把针弄得过弯。 ⑤在缝制开始时压脚压住缝纫机线（机针弯曲）。	○更换机针。 ○调节布压脚。 ○根据缝制物选用适当的机针。 ○调整针和摆梭位置。 ○弄宽机针和挑线杆的距离（23~25mm）。
4. 切线不断（仅限底线）	①固定刀不快。 ②针孔导线器和固定刀高低差小。 ③动刀位置不好。 ④最终针跳线。 ⑤底线张力低。	○更换固定刀。 ○把固定刀再弄弯一些。 ○调整动刀位置。 ○调整针摆梭的同步。 ○提高底线张力。
5. 常跳线	①针和摆梭调整不好。 ②针和摆梭的间隙过大。 ③针弯了。 ④驱动器把针弄得过弯。	○调整针和摆梭的位置。 ○调整针和摆梭的位置。 ○更换机针。 ○调整驱动器的位置。
6. 上线从布的里侧露出来	①上线紧线不好。 ②线张力盘浮起机构不动作 ③切线后的上线过长。 ④针数少。 ⑤缝制长度短时（缝制背面上线头露出）。	○加强上线张力。 ○确认缝制中第 2 线张力盘是否浮起。 ○加强第 1 线张力。 ○使用暗缝式下板。

7. 切线时 短线	①动刀位置不好。	○调节动刀位置 ○调节剪线凸轮位置
8. 机线长 度不一 致	①挑线弹簧的张力低。	○提高挑线弹簧的张力。
9. 机线长 度不能 弄短	①第 1 线张力器的张力低。 ②挑线弹簧张力过强。 ③因为挑线弹簧的张力过低，所以动作不稳定。	○增强第 1 线张力器的张力。 ○降低挑线弹簧的张力。 ○增强挑线弹簧的张力，行程也变长。
10. 缝制开 始第 2 针的底 线结线 部露出 表面	①梭芯的空槽大。 ②底线张力低。 ③第 1 针的上线张力过强。	○调整活动刀的位置。 ○增强底线张力。 ○下降第 1 针的上线张力。

In order to create a better environment

Please cooperate with you

First of all, I would like to express my heartfelt thanks to you for using our products.

Our company is committed to caring for the earth's environment and has formulated the basic policy of "intelligent manufacturing and green manufacturing". Local citizens in environmental protection activities should also do little to the local community, the environment two aspects of everyone's contribution.

Therefore, I hope you can cooperate with this plan, as part of the environmental protection activities, when dealing with wastes in peacetime can pay more attention.

1. Unused packaging materials, in order to be recycled again, please send them to the local recycling company for disposal.
2. Lubricants used shall be properly handled according to relevant laws and regulations.
3. When parts need to be replaced in product maintenance or repair, there are unnecessary circuit boards and electronic parts, and when products are discarded, please treat them as electronic waste.

Thank you very much for purchasing our industrial sewing machine
 Before using the sewing machine, please read <for your safe use> and use instructions carefully

The characteristic of industrial sewing machine is that it should be operated near the moving parts such as needles and spindles, which are easy to cause injury, so please use the sewing machine correctly under the guidance of the safety operation knowledge of trained or skilled personnel.

For Your Safe Use

[1] Safety Usage Marking And Its Significance

The labels and pattern marks used in this instructions and products are for your safety and correct use of the products to prevent you and others from being harmed and damaged.

The methods and implications are as follows.

Sign

	Danger This content indicates that if this mark is mishandled, it will cause death to become serious.
	Warning This content indicates that if this mark is mishandled, people will die or be seriously injured.
	Note That if this mark is mishandled, it may cause minor or moderate injuries.

Patterns And Symbols



..... The symbol (△) indicates “points for attention”.
 The pattern in the triangle represents the essential content that must be paid attention to.
 (For example, the pattern on the left shows “watch out for injuries”.)



..... The symbol (⊘) indicates “prohibition”.



..... The symbol (●) indicates “must”.
 The pattern in the circle indicates the substance of what must be done.
 (For example, the pattern on the left shows “must be grounded”.)

[2] Safety Precautions

Danger



After closing the power switch and unplugging the power plug from the socket, wait for at least 5 minutes before opening the control box cover. Touching areas with high voltage can cause casualties.

Warning



No liquid is allowed to enter the sewing machine, otherwise it will cause fire, electric shock and operation failure.



If any liquid enters the sewing machine (head or control box), turn off the power supply immediately, pull the plug out of the socket, and contact the vendor or senior technicians.

Be Careful

Use Environment



Please don't use in the environment with strong electrical interference sources such as power line interference and electrostatic interference.

Strong electrical interference sources may affect the correct operation of sewing machines.



The fluctuation of power supply voltage should be used in the environment of rated voltage less than $\pm 10\%$.

The large fluctuation of voltage will affect the correct operation of sewing machine.



The power supply capacity should be greater than the power consumption of the sewing machine. Insufficient power supply capacity will affect the correct operation of sewing machine.



The ambient temperature should be used in the range of 5-35 degrees Celsius.

Low or high temperature will affect the correct operation of sewing machine.



Relative humidity should be in the range of 45% - 85%, and the equipment will not form condensation environment. Dry or wet environment and dew will affect the correct operation of sewing machine.



In case of thunderstorm, turn off the power switch and pull the power plug off the socket. Lightning may affect the correct operation of sewing machine.



Do not connect devices other than USB memory to USB connection ports. Otherwise, it may lead to failure.

Install



Ask trained technicians to install sewing machines.



Please commission the purchase shop or electrical professionals for electrical wiring.



The sewing machine weighs about 35Kg. Installation must be completed by more than two people.



Please do not connect the power supply before the installation is completed. If you step on the pedal by mistake, the sewing machine will cause injury.



Please unplug the plug after cutting off the power supply. Otherwise, it will easily become the cause of the failure of the control box.



It must be grounded. Insufficient ground connection is the cause of electric shock or misoperation.



When fixing the cable, do not bend the cable excessively or fix it too tightly with clamps, which may cause fire or electric shock.



If a worktable with casters is used, the casters should be fixed so that they cannot move.



When the head of the sewing machine falls down, please make sure that the worktable is fixed and not moved at will. Accidents such as foot clamping have occurred in the movement of worktable, which is the cause of personal accidents.



When the sewing machine head falls down or stands up, please operate with both hands. One-handed operation can easily cause injury if the weight of the sewing machine slips.



When lubricating oil and butter are used, it is necessary to wear protective glasses and gloves to prevent lubricating oil from falling into serious or sticking to the skin, which is the cause of inflammation.

In addition, lubricants or butter should not be drunk, otherwise vomiting and diarrhea will occur.

Keep oil out of reach of children

Be careful

Sewing



This sewing machine is only used by persons trained in safe operation.



This sewing machine cannot be used for any purpose other than sewing.



Protective glasses must be worn when sewing machines are used.

If you don't wear protective glasses, there will be danger when you break the needle. The broken part of the needle may pop into your eyes and cause injury.



When the following happens, please cut off the power supply. Otherwise, when you step on the pedal, the sewing machine will cause injury.

·When the needle goes through the thread

·When changing needle or shuttle core

·When a sewing machine is not in use or when a person leaves the sewing machine



If a worktable with casters is used, the casters should be fixed so that they cannot move.



For the sake of completeness, please install protective device before using this sewing machine. If these safety devices are not installed, use sewing opportunities to cause personal injury and sewing machine damage.



During the sewing process, do not touch any moving parts or place the objects on the moving parts, because this will cause injuries to people or damage to the sewing machine.



When the head of the sewing machine falls down, please make sure that the worktable is fixed and not moved at will.

Accidents such as foot clamping have occurred in the movement of worktable, which is the cause of personal accidents



When the sewing machine head falls down or stands up, please operate with both hands.

One-handed operation can easily cause injury if the weight of the sewing machine slips.



If the sewing machine operates incorrectly, or hears abnormal noise or smells abnormal odor, the power supply should be cut off immediately. Then contact the shop or trained technicians.



If the sewing machine breaks down, please contact the shop or trained technicians.

Clean



Please cut off the power supply before starting the cleaning operation.

If you step on the pedal by mistake, the sewing machine will cause injury.



When the head of the sewing machine falls down, please make sure that the worktable is fixed and not moved at will.

Accidents such as foot clamping have occurred in the movement of worktable, which is the cause of personal accidents.



When the sewing machine head falls down or stands up, please operate with both hands.

One-handed operation can easily cause injury if the weight of the sewing machine slips.



When lubricating oil and butter are used, it is necessary to wear protective glasses and gloves to prevent lubricating oil from falling into serious or sticking to the skin, which is the cause of inflammation.

In addition, lubricants or butter should not be drunk, otherwise vomiting and diarrhea will occur.

Keep oil out of reach of children

Maintenance And Inspection



Only trained technicians can repair, maintain and inspect sewing machines.



Maintenance, maintenance and inspection related to electricity should be entrusted to purchasing shops or electrical professionals.



Turn off the power supply when the following happens. Pull the plug from the power outlet.

Otherwise, when you step on the pedal, the sewing machine will cause injury.

·Inspection, adjustment and maintenance

·Replacement of fragile parts such as spindle and cutter



Before opening the motor cover, be sure to turn off the power supply, wait a minute, and then perform the operation.

Touching the motor surface can cause burns.



When the power switch must be connected to adjust, be sure to switch to maintenance mode.

Be careful to observe all safety precautions



When the head of the sewing machine falls down, please make sure that the worktable is fixed and not moved at will.

Accidents such as foot clamping have occurred in the movement of worktable, which is the cause of personal accidents



When the sewing machine head falls down or stands up, please operate with both hands.

One-handed operation can easily cause injury if the weight of the sewing machine slips.



When replacing parts or installing optional accessories, be sure to use only genuine parts.

The Company will not be liable for any accident or malfunction caused by the use of non-authentic parts.



When removing the safety protection device and installing it again, be sure to install it in situ and check whether it can work properly.



In order to prevent accidents and malfunctions, please do not alter the sewing machine without authorization.

The Company will not be liable for any accident or malfunction caused by the modification of the sewing machine.

[3] Warning Label

The following warning labels are on the sewing machine

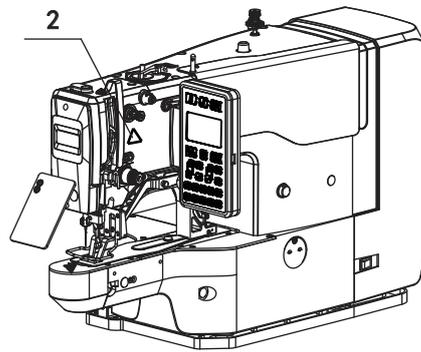
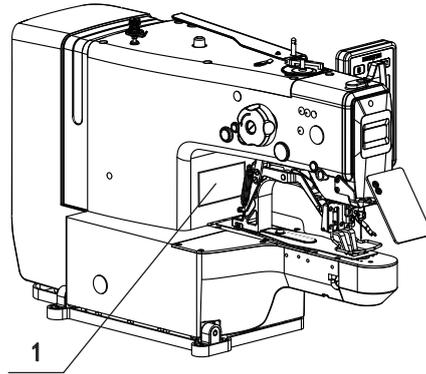
When using the sewing machine, please follow the instructions on the label. If the label falls off or is ambiguous, please contact the purchase shop.

1

	CAUTION
	Moving parts may cause Injury Operate with safety devices. Turn off main switch before threading changing bobbin and needle, cleaning etc. 在穿线; 更换梭芯、机针; 清洁机器时务必关闭电源。

2

	Be careful to avoid the damage by moving the Thread take-up lever.
-----------------------------------------------------------------------------------	--------------------------------------------------------------------



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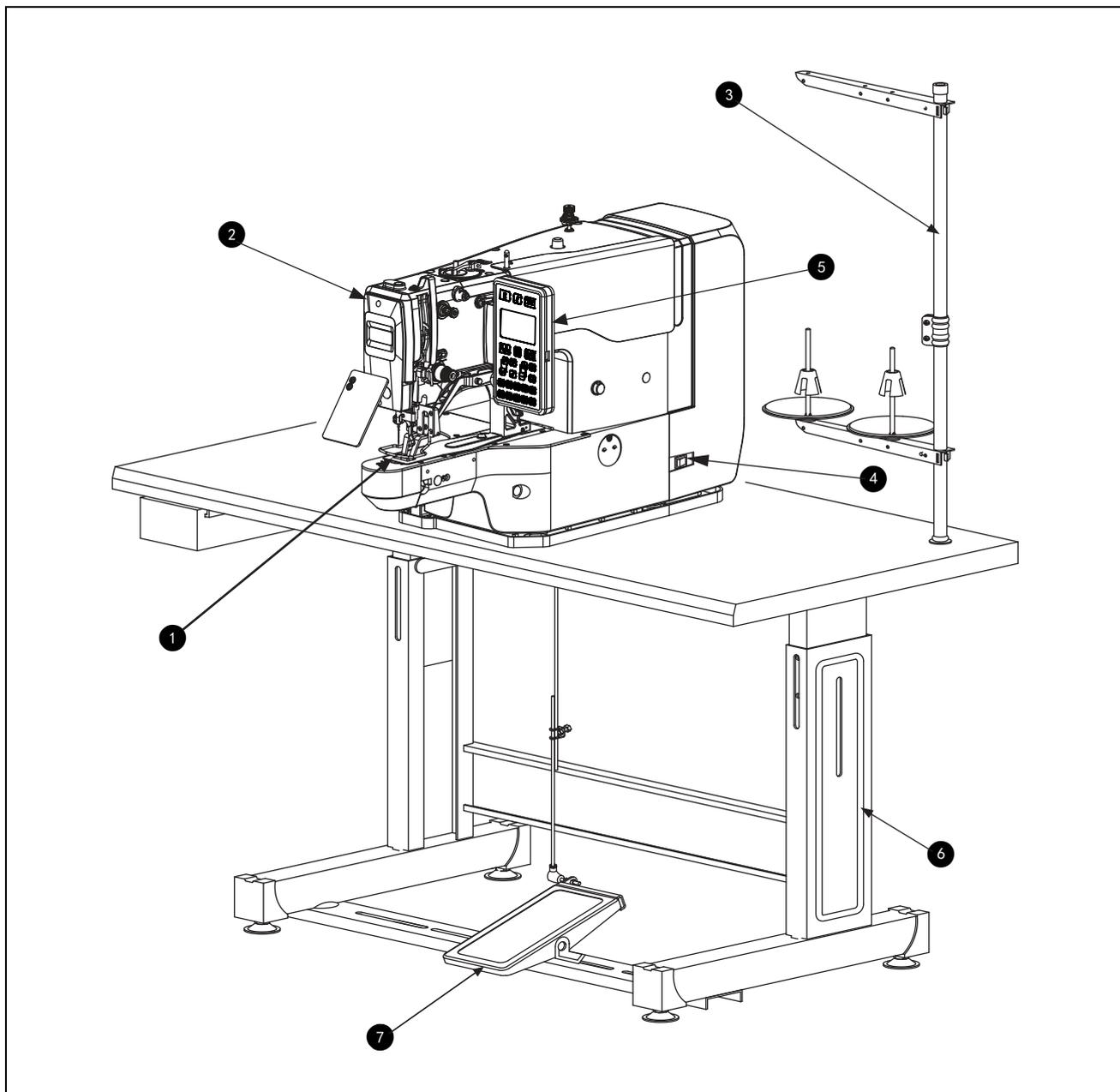
I . EXPLANATION OF COMPUTER-CONTROLLED HIGH-SPEED LOCKSTITCH BAR TACKING MACHINE

[1] SPECIFICATIONS

- | | |
|-------------------------------------------|--------------------------------------------------------------------------------------------------------|
| 1. Sewing area: | X (lateral) direction 40mm,
Y (longitudinal) direction 30mm |
| 2. Max. Sewing speed: | 3200rpm
(when sewing pitches are less than 5mm in
X-direction and 3.5mm in Y-direction) |
| 3. Stitch length: | 0.1-10mm (adjustable in 0.1mm step) |
| 4. Feed motion of work clamp foot: | Intermittent feed (2-shaft drive by stepping motor) |
| 5. Needle bar stroke: | 41.2mm |
| 6. Needle: | DP×5、 DP×17 |
| 7. Lift of work clamp foot: | 13mm (standard) Max.17mm |
| 8. Shuttle: | standard semi-rotary hook (oil wick lubrication) |
| 9. lubricating: | oil 10# (supplied by oiler) |
| 10. Date recording: | EPROM |
| 11. Enlarging/Reducing facility: | 20% to 200% (1% step) in X-direction
and Y-direction respectively |
| 12. Enlarging/Reducing: | Patten enlargement/reduction can be done
by increasing/decreasing the stitch length |
| 13. Max. Sewing speed limitation: | 400 to 3500rpm (100rpm) |
| 14. Pattern selection: | Specifying pattern No. type (1 to 200) |
| 15. Bobbin thread counter: | UP/DOWN type (1-999999) |
| 16. Sewing machine motor: | 550W Servo motor |
| 17. Dimensions: | W: 1200mm L: 540mm H: 1100mm |
| 18. Weight: | Machine 57.4Kg |
| 19. Power consumption: | 0.125KW |
| 20. Operating temperature range: | 5°C to 35°C |
| 21. Operating humidity range: | 35% to 85% (No dew condensation) |
| 22. Line voltage: | Rated voltage ±10% 50-60Hz |

[2] CONFIGURATION

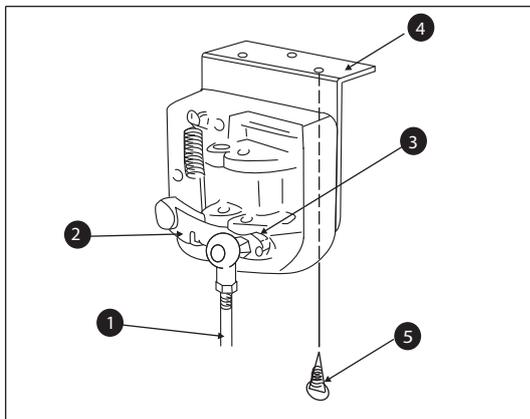
1. Names of main unit



- (1). Work clamp feet
- (2). Machine head
- (3). Thread stand
- (4). Power switch
- (5). Operation panel
- (6). Frame
- (7). Pedal switch

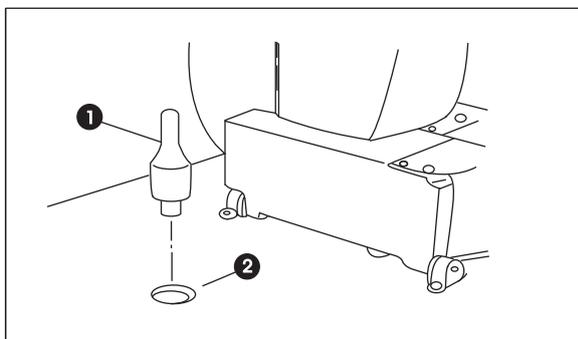
[3] INSTALLATION

1. Attaching the connecting rod



- (1) FIX connecting rod① to installing hole B of pedal lever ② with nut③. When connecting rod ① is installed in installing hole A, the depressing stroke go the pedal is increased.
- (2) Secure the pedal④ with a wooden screw⑤ in place.

2. Installing the head support rod

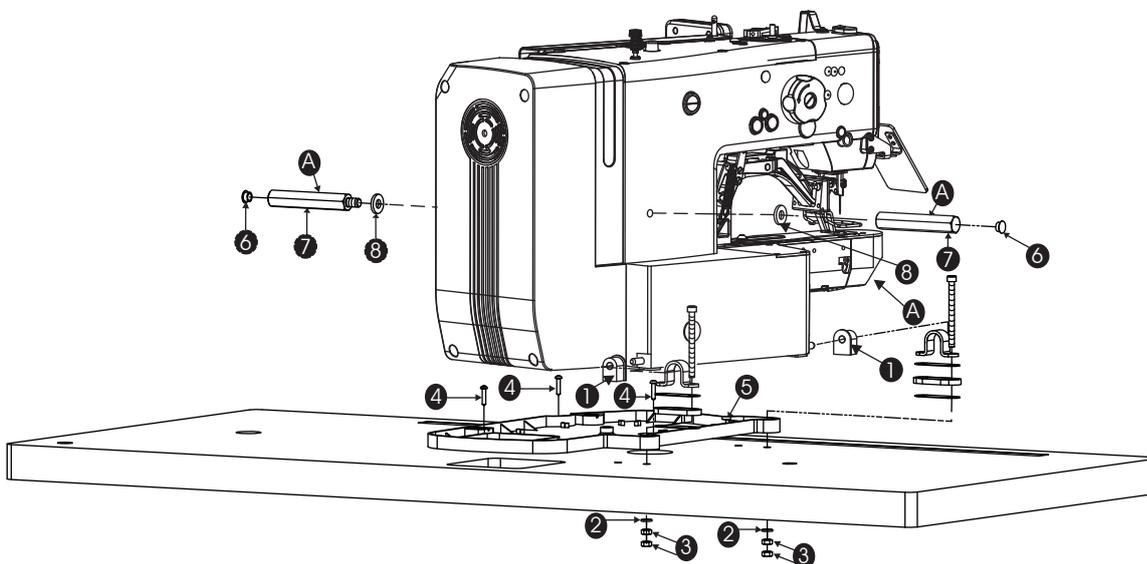


Drive head support rod① in hole② in the machine table.

3. Installation of the swing machine head



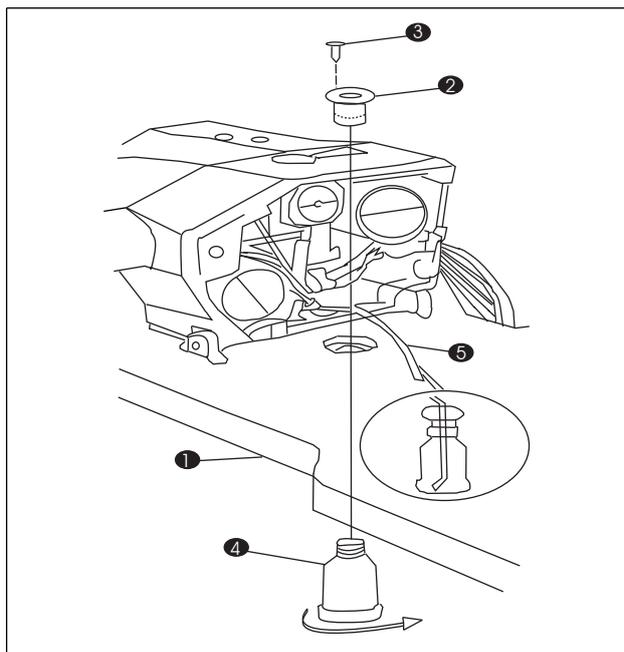
WARNING : To prevent possible accidents caused by the full of the sewing machine, perform the work by two persons or more when the machine is



- 1、 When handling sewing machine, please hold A Department
- 2、 After handling, please remove the handle⑦ and rubber pad⑧, fitted with rubber plug⑥

- (1). The oil plate⑤ with wood screws④ fixed in the corresponding position of the platen.
- (2). Fit hinge rubber ① to the hinge shaft, and fix the swing machine.
- (3). The flat pad ② , nut③ , followed by a fixed, pay attention to the locking nut③ force, if twisted too tightly, then the shock result is not satisfactory.

4. Installing the drain receiver

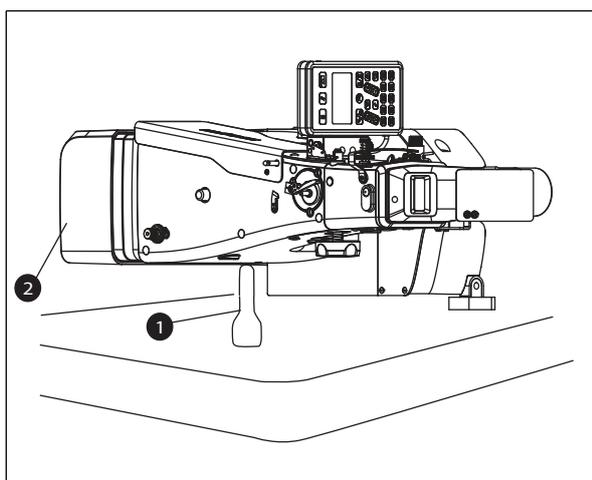


Fix drain receiver ② in the installing hole of table ① with four setscrews③. Screw in drain bin ④ to drain receiver②. Insert sewing machine drain pipe⑤ into drain bin ④ .



Insert drain pipe⑤ until it will go on further so that it does not come off drain bin ④ when tilting the machine head

5. Tilting the sewing machine head

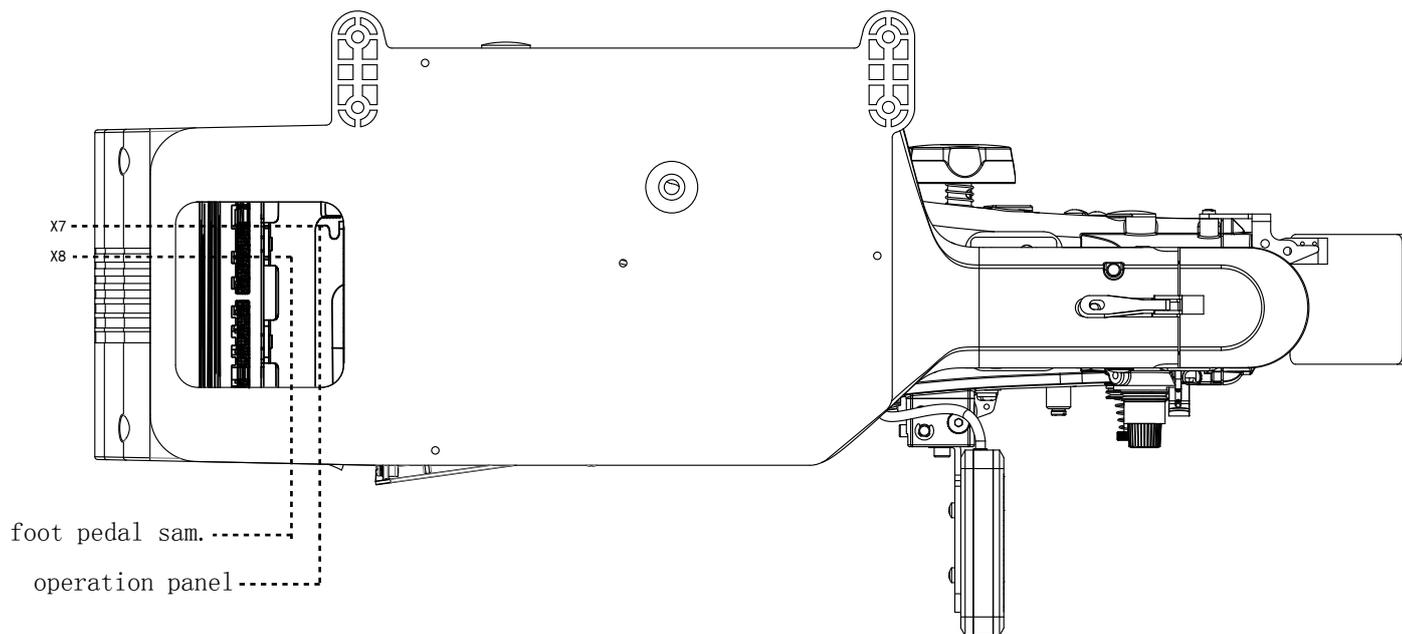


turn head ② gently down , and leaning the head on the head supporting bar at ①.



1. Before tilting the sewing machine head, make sure that head support rod ① is attached to the machine table;
2. When raising the sewing machine head, do not raise it while holding motor cover ②. It will be the cause of breakage of motor cover②.
3. Be sure to tilt the sewing machine head on a flat place to prevent it from falling.

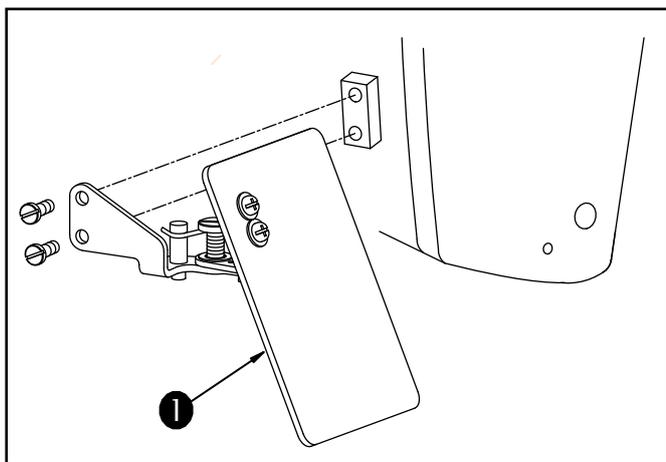
6 Connecting the operation panel



Please let the operation panel line connect with the electronic control box according to online identity, make sure the connection is correct.

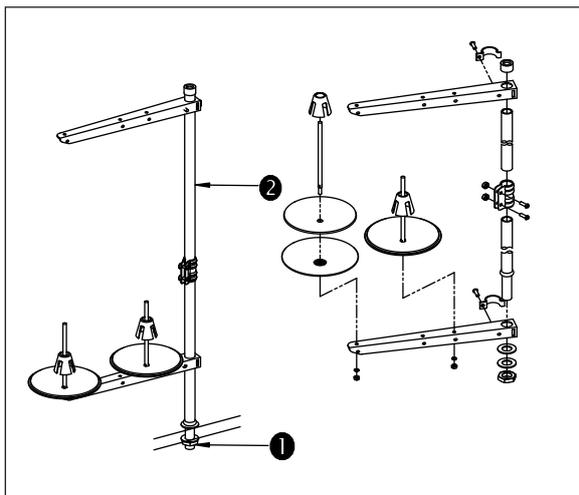
7. Installing the eye protection cover

	WARNING : Be sure to attach this cover to protect the eyes from the disperse of needle breakage.
-------------------------------------------------------------------------------------	---------------------------------------------------------------------------------------------------------



The eye shield in the accessories box should be installed in the head on the left.

8. Installing the thread stand



The line frame in the accessory box should be installed in Table.

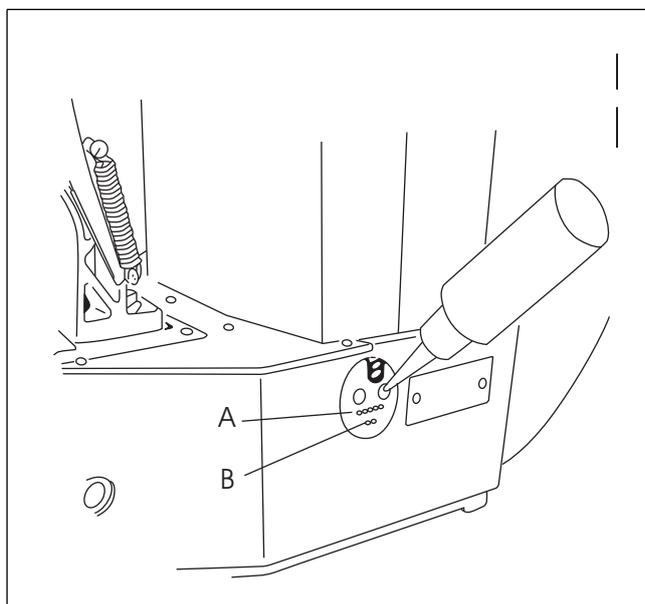
[4] OPERATION OF THE SEWING MACHINE

1. Lubrication



WARNING :

Turn of the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine



Check that the place between lower line Band upper line A is filled with oil . Fill there with oil using the oiler supplied with the machine as accessories when oil is short.

*The oil tank which is filled with oil is only for lubricating to the hook portion. It is possible to reduce the oil amount when the number of rotation used is low and the oil amount in the hook portion is excessive.

(Refer to 7.Adjusting the amount of oil supplied to the hook of[5] MAINTENANCE)

1. DO not lubricate to the places other than the oil tank and the hook of Caution 2 below.

Trouble of components will be caused.

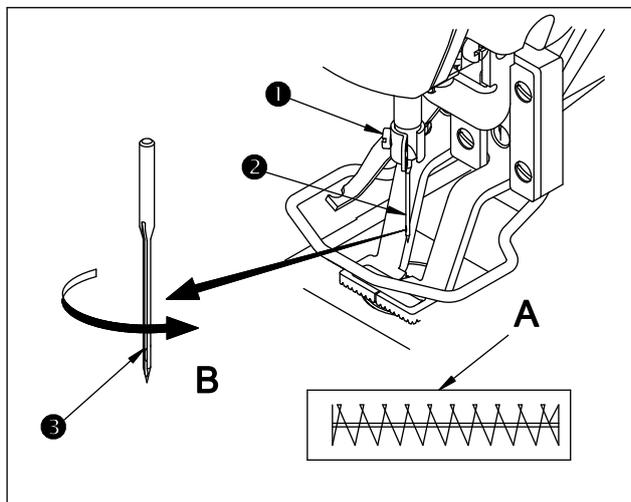


2. When using the sewing machine for the first time or after an extended period of disuse use the machine after lubricating a small amount of oil to the hook portion.(Refer to2.Adjusting the needle-to-shuttle relation of [7]MAINTENANCE

2. Attaching the needle



WARNING : Turn of the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine



Loosen setscrew① and hold needle② with the long groove facing toward you. Then fully insert it into the hole in the needle bar, and tighten setscrew①.

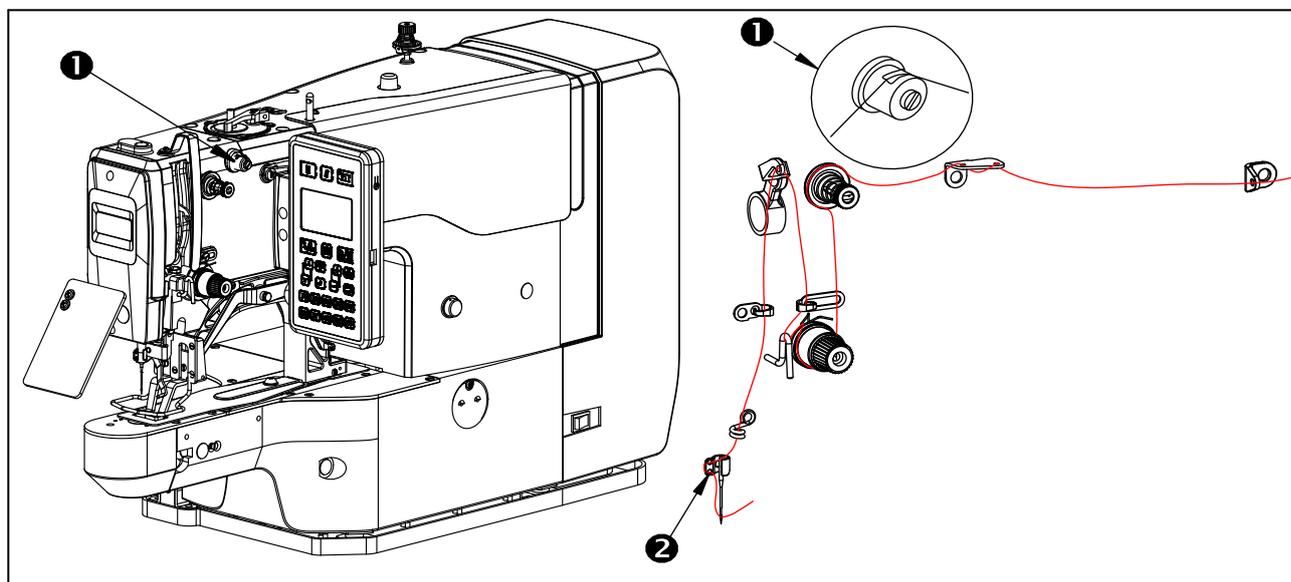


If the stitches are made as shown in "A", attach the needle facing to the direction "B" to a small extent.

3. Threading the machine head



WARNING : Turn of the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine



Pull out the thread by approximately 4cm from the needle after threading through the needle.

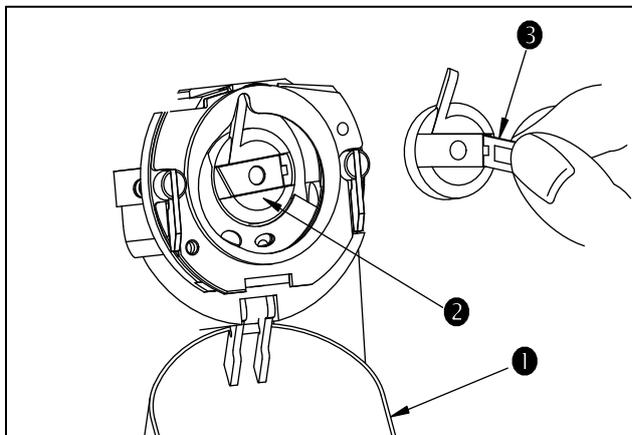


1. When the silicon oil is used, thread through thread guide for silicon①.
2. For thick thread, pass the thread through one hole only of needle bar thread guide②

4. Installing and removing the bobbin case



WARNING : Turn of the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine.



- (1). Open hook cover①。
- (2). Raise latch③ of bobbin case②, and remove the bobbin case.。
- (3). When installing the bobbin case, fully insert it into the shuttle shaft, and close the latch.

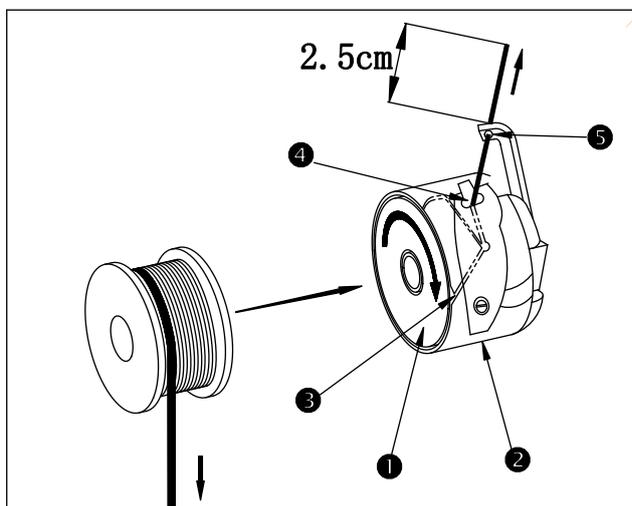


If it is not fully inserted, bobbin case ② may slip off during sewing.

5. Installing the bobbin



WARNING : Turn of the power before starting the work so as to prevent accidents caused by abrupt start of the sewing machine

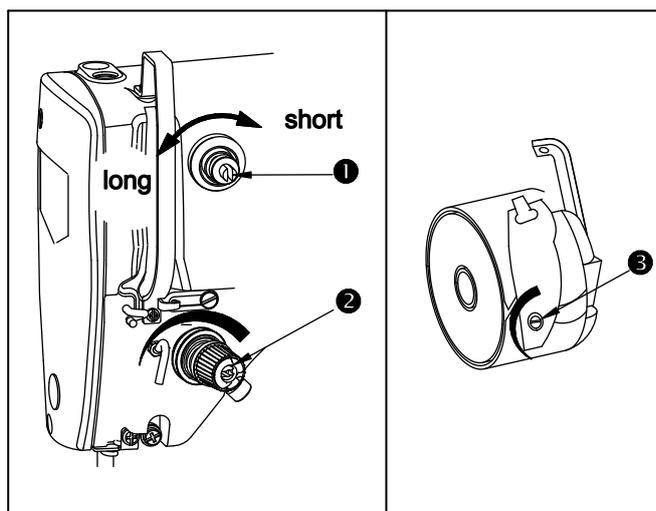


- (1). Set the bobbin ① into bobbin case ② in the direction shown in the figure.
- (2). Pass the thread through thread slit ③ of bobbin case ②, and pull the thread as it is. By so doing, the thread will pass under the tension spring and be pulled out from thread hole ④.
- (3). Pass the thread through thread hole ⑤ of the horn section, and pull out the thread by 2.5cm from the thread hole.



If the bobbin is installed in the bobbin case orienting the reverse direction, the bobbin thread pulling out will result in an inconsistent state.

6. Adjusting the thread tension

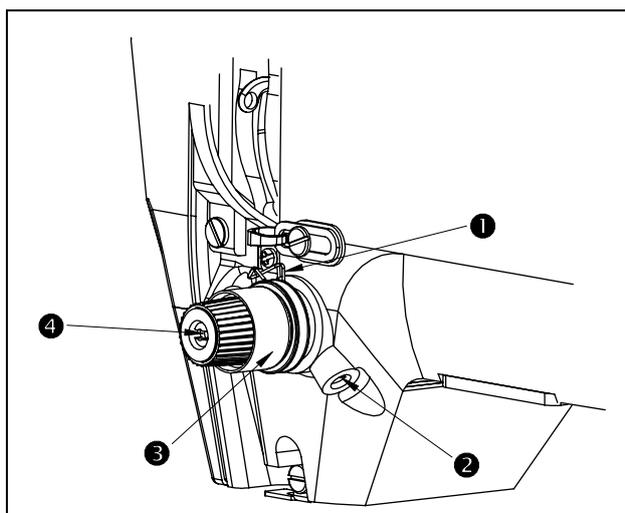


If thread tension controller No.1 ① is turned clockwise, the length of remaining thread on the needle after thread trimming will be shorter. If it is turned counterclockwise, the length will be longer.

Shorten the length to an extent that the thread is not slipped off.

with ② to adjust the upper thread tension, with ③ to adjust the bottom line tension.

7. Adjusting the thread take-up spring



The standard stroke of thread take-up spring ① is 8 to 10 mm, and the pressure at the start is 0.1 to 0.3N.

(1). Adjusting the stroke

Loosen setscrew ②, and turn thread tension asm. ③. Turning it clockwise will increase the moving amount and the thread drawing amount will increase.

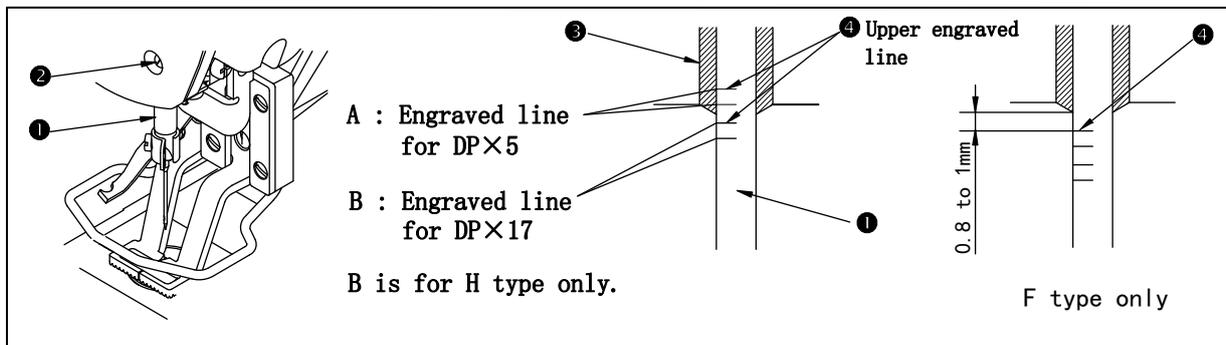
(2). Adjusting the pressure

To change the pressure of the thread take-up spring, insert a thin screwdriver into the slot of thread tension post ② while screw ④ is tightened, and turn it. Turning it clockwise will increase the pressure of the thread take-up spring. Turning it counterclockwise will decrease the pressure.

[5] MAINTENANCE

1. Adjusting the height of the needle bar

 **WARNING :** Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.

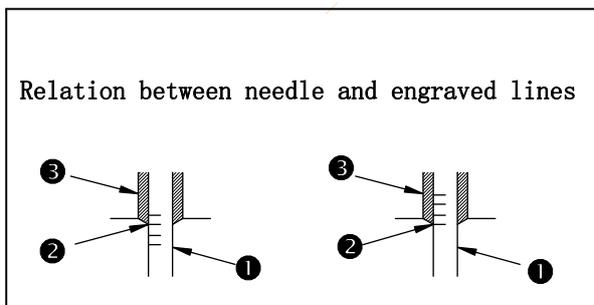


Bring needle bar ① to the lowest position of its stroke. Loosen needle bar connection screw ② and adjust so that upper marker line④ engraved on the needle bar aligns with the bottom end of needle bar bushing, lower ③. For F type only, adjust the needle bar to the position where it is lowered by 0.8 mm to 1 mm from the center of upper marker line ④ engraved on the needle bar.

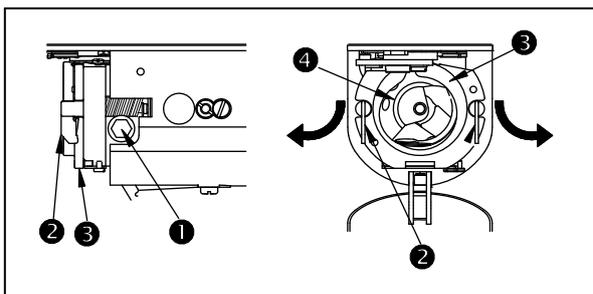
 After the adjustment, make sure that there is no uneven torque. When stitch skipping occurs in accordance with the sewing conditions, adjust the height of the needle bar so as to lower it by 0.5 to 1 mm from the needle bar engraved line ④ .

2. Adjusting the needle-to-shuttle relation

 **WARNING :** Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.



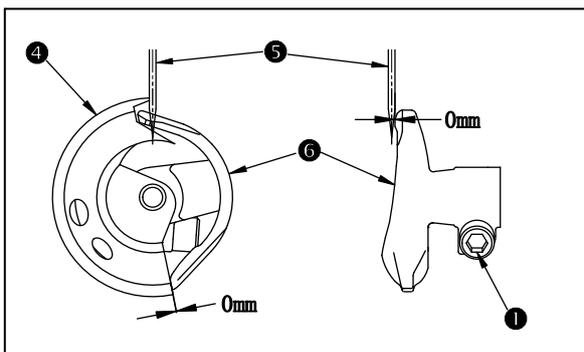
(1). Turn the hand wheel by hand. When needle bar① has gone up, adjust so that lower marker line② engraved on the needle bar aligns with the bottom end of the needle bar bushing ③ , lower.



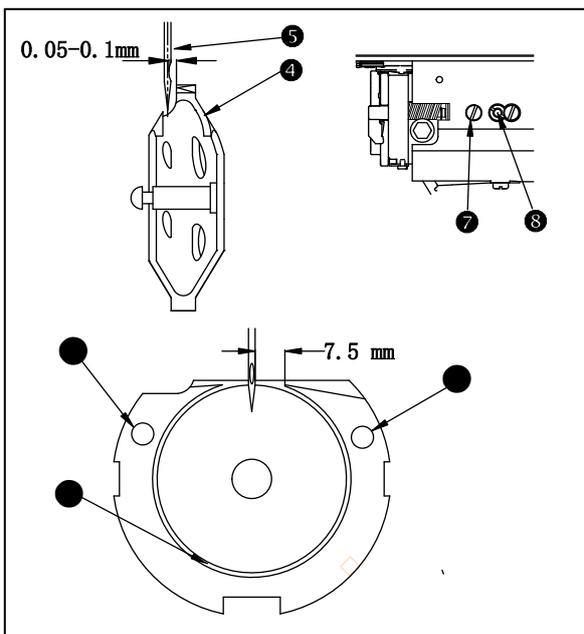
(2). Loosen setscrew ① in the driver. Open inner hook pressers ② to the right and left, and remove inner hook presser ③ .



At this time, be careful not to let inner hook ④ come off and fall.



(3). Adjust so that the blade point of inner hook ④ aligns with the center of needle ⑤, and that a clearance of 0 mm is provided between the front end of the driver and the needle as the front end face of driver ⑥ receives the needle to prevent the needle from being bent. Then tighten setscrew ① of



(4). Loosen setscrew ⑦ of the shuttle, and adjust the longitudinal position of the shuttle. To do this adjustment, turn shuttle race adjusting shaft ⑧ clockwise or counterclockwise to provide a 0.05 to 0.1 mm clearance between needle ⑤ and the blade point of inner hook ④ .

(5). After adjusting the longitudinal position of the shuttle, further adjust to provide a 7.5 mm clearance between the needle and the shuttle by adjusting the rotating direction. Then tighten setscrew ⑦ of the shuttle.



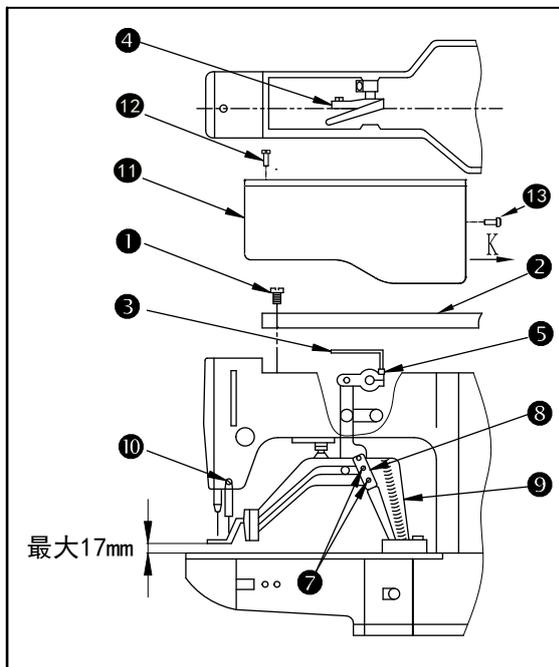
Apply a small amount of oil to race section ⑨ and oil wick ⑩ , and use the sewing machine after an extended period of disuse or cleaning the periphery of hook portion.

3. Adjusting the lift of the work clamp foot



WARNING :

Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.



- (1). With the machine in stop mode, remove two set screws ⑫、⑬ of the right decorative panel⑪, then remove the decorative panel⑪ along the K direction.
- (2). Remove six set screws ① of the top cover, and take off top cover.
- (3). Apply L-shaped wrench ③ to socket bolt ⑤ of clamp ④, and loosen the socket bolt.
- (4). Push down L-shaped wrench ③ to increase the lift of the work clamp foot, or pull it up to decrease the lift.
- (5). After the adjustment, securely tighten socket bolt ⑤.
- (6). If the right and left work clamp feet are not leveled, loosen fixing screw ⑦ and adjust the position of the work clamp foot lever support plate ⑧ to level them.



At this time, be careful not to cause work clamp foot lever support plate ⑧ to interfere with feed bracket ⑨.

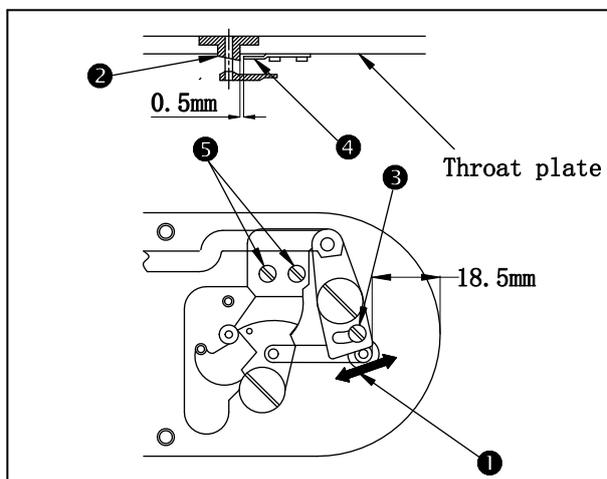
If the work clamp foot lever support plate interferes with the wiper, readjust the height of the wiper using setscrew ⑩ in the wiper installing base.

4. The moving knife and counter knife



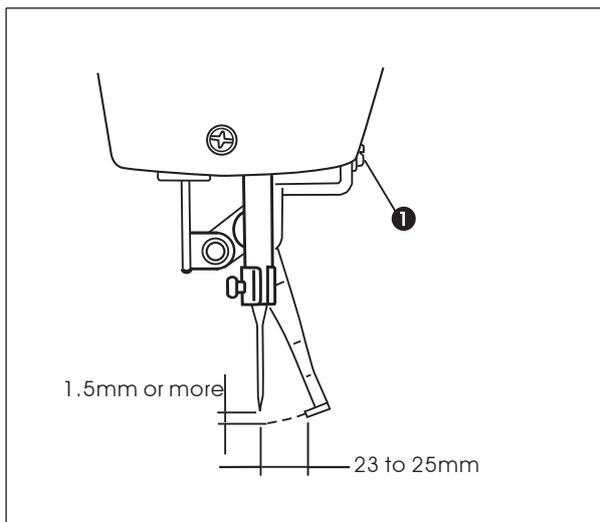
WARNING :

Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.



- (1). Loosen adjusting screw ③ so that a clearance of 18.5 mm is provided between the front end of the throat plate and the top end of thread trimmer lever, small ①. To adjust, move the moving knife in the direction of arrow.
- (2). Loosen setscrew ⑤ so that a clearance of 0.5 mm is provided between needle hole guide ② and counter knife ④. To adjust, move the counter knife.

5. Adjusting the wiper



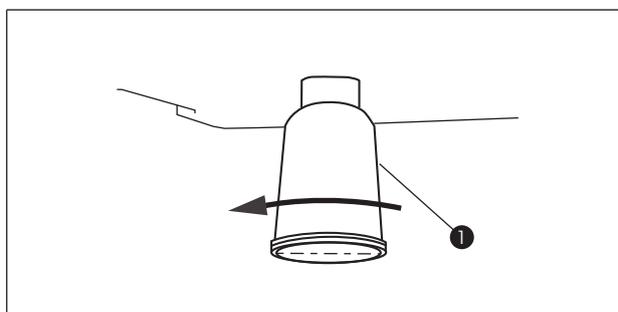
Loosen screw ① to adjust so that a clearance of 1.5 mm or more is provided between the wiper and the needle.

At this time, the standard of the distance between the wiper and the needle is 23 to 25 mm. By adjusting the distance wide, the work clamp foot can prevent stepping on needle thread when it comes down.

Especially when the thin needle is used, adjust the distance wide to such an extent of 23 mm.

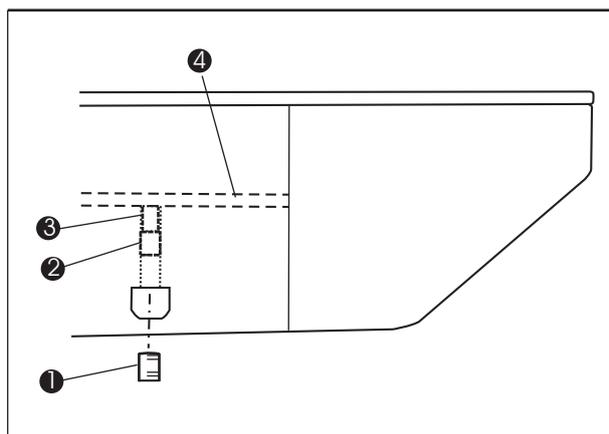
※The position of the needle is when the sewing machine has stopped after the sewing finished.

6. Draining waste oil



When polyethylene oiler ① becomes filled with oil, remove polyethylene oiler ① and drain the oil.

7. Adjusting the amount of oil supplied to the hook



- 1) Loosen setscrew ① and remove setscrew ①.
- 2) When screwing in adjustment screw ②, the amount of oil of oil pipe, left ④ can be reduced.
- 3) After the adjustment, screw in setscrew ① and fix it.

1. The state of standard delivery is the position where ② is lightly screwed in and returned by 4 turns.



2. When reducing the amount of oil, do not screw in the screw at once. Observe the state for approximately half a day at the position where ② is screwed in and returned by 2 turns. If reducing is excessive, worn-out of the hook will result.

8. Replenishing the designated places with grease

When the sewing machine has been used for a certain number of times of sewing, error code No. E221 is displayed on the operation panel at the time of turning ON the power. This display informs the operator of the time of replenishing the designated places with oil. Be sure to replenish the places with the oil below. Then call the memory switch No. 245 and set it to "0" with the RESET key. Even after the display of the error No. E221, when the RESET key is pressed, the error is released, and the sewing machine can be continuously used. Afterwards, however, the error No. E221 is displayed every time the power is turned ON.

In addition, when the sewing machine is used further for a certain period of time after the display of error No. E220, the error No. E221 is displayed and the sewing machine fails to operate since the error cannot be released even when the RESET key is pressed.

When the error No. E221 is displayed, be sure to replenish the designated places below with oil. Then start up the memory switch and set No. 245 to "0" with the RESET key.

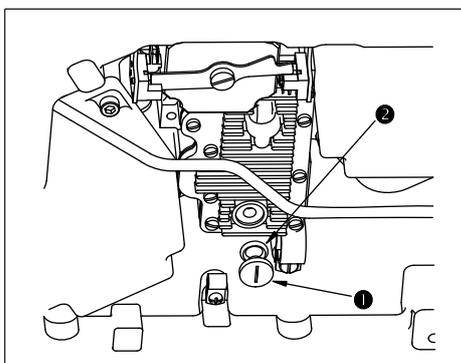


After replenishing the places with oil, the error No. E220 or No. E221 is displayed again unless the memory switch No. 245 is changed to "0".



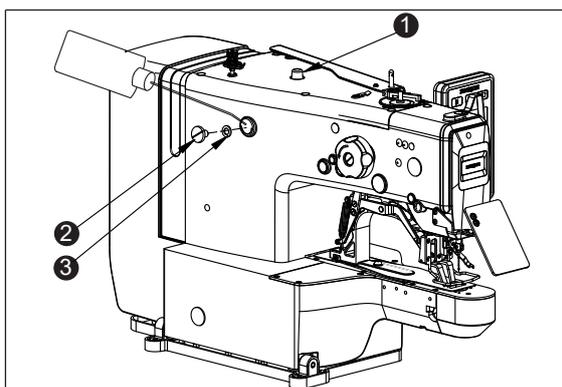
WARNING : Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.

(1) . Outflow the residual oil in gearbox



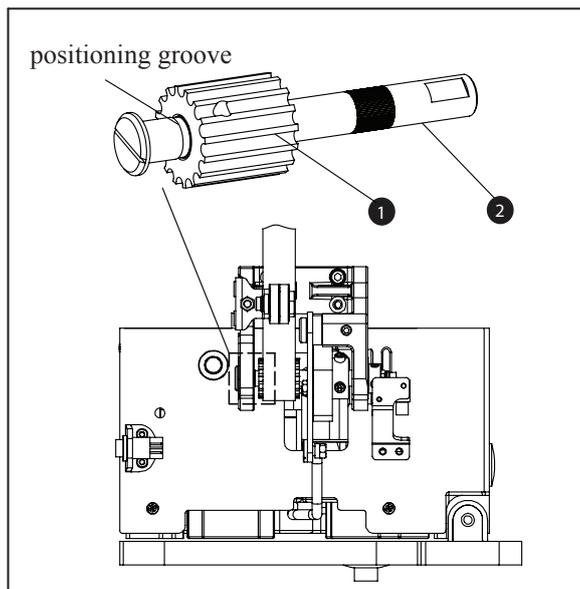
- 1) Tilt the machine, remove the screws ① and seal ②.
- 2) put back sewing machine, outflow the residual oil in the gearbox.
- 3) tilt the machine again, put back the seals ② and screws ①, then put sewing machine back to the position.

(2) . Lubricate the upper gearbox



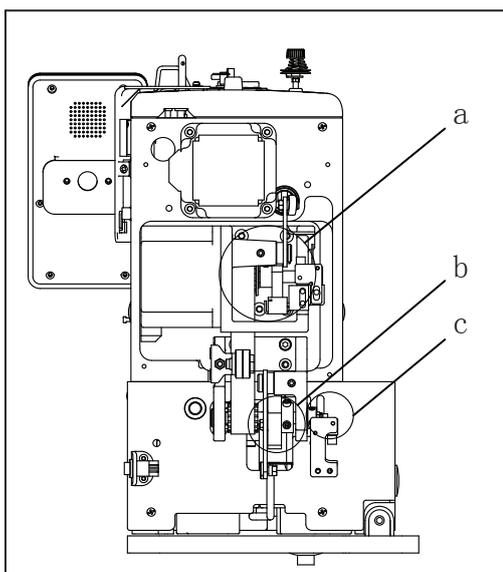
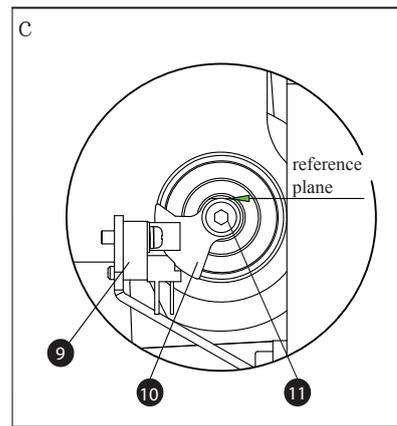
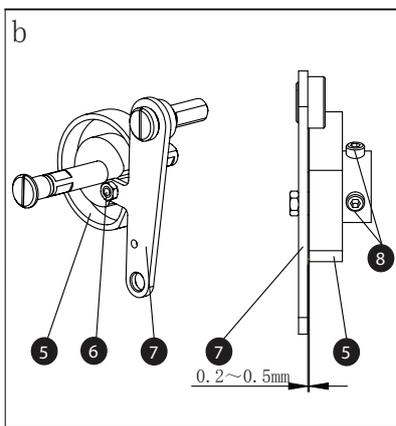
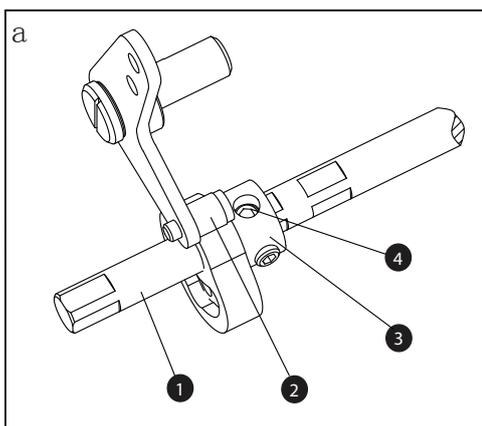
- 1) When through the oil window ①, you can not find oil outlet obviously, or it is without oil outlet, you should add the oil into the wheel gear box.
- 2) Turn off the machine, you can take down the screw ② and the rubber washer ③, when it is without oil outlet, please add 100ml 10# white oil; when it is not oil outlet obviously, please add 50-70ml. Please install back ② and ③ parts, turn on the machine and check whether it is happened to oil outlet or not.

9. Adjusting the position of the shear- driving pulley



Keep the left end of the shear-driving pulley ① aligned with the right end of the positioning groove that in the shear-driving shaft ②, Then tighten the screw on the shear-driving pulley.

10. Position the wire-trimming cam and the wire-trimming safty plate



(1) Adjusting the wire-trimming cam

- 1) Rotate the shaft of lifting motor ① to turn the lifting cam ③ to the lowest point of contact with the lift roller ② .The screw ④ is facing vertically upward ,as shown in the figure a .
- 2) Adjusting the roller ⑥ to the bottom of the the groove of the trimming cam ⑤ .
- 3) Tighten two screws ⑧ o f the trimming cam after adjusting the distance between the trimming crank ⑦ and the end of trimmin ④ g cam ⑤ to be about 0.2-0.5mm,as shown in the figure b .

(2) Adjusting the wire-trimming safty plate

- 1) Rotate the lift motor shaft to turn the lift cam to the lowest point of contact with the lift roller,this moment the screw is facing directly above.
- 2) Positioning reference plane of the trimming safety sensor ch horizontally upwards,and placing the trimming safety sensor chip in the trimming safety sensor,as shown in figure c,then locking the screw to fix the trimming safety sensor.

3)When the foot pedal is pressed for the first time,presser foot is pressed down, and the trimming safety sensor chip does not enter the trimming safety sensor. When the foot pedal is pressed for the second time, the machine starts to sew ,and if there is an alarm that the machine is trimming abnormality,Please loosen the screw and adjust the position of the trimming sensor chip in the clockwise direction.

[6]. Table of the standard clamp foot

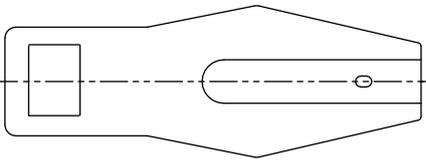
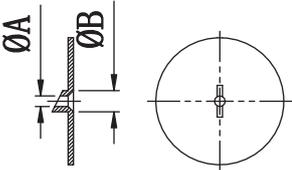
	1	2	3	4	5
Work clamp foot	Left: 10011508 Right: 10011505			10011687、10011691	10011758、10011759
Feed plate	10011565	10012300	10012279	10011751	10011755
	With knurl	Without knurl	Without knurl	With knurl	With knurl
Sewing specification	S	F	F	H	M
Finer guard	10011556(S、M、F)、10011695 (H)				
Remarks	Standard accessory for S type machine head.	Supplied with F type machine head. (Depends on the destination)		Optional	Standard accessory for M (knit goods) type machine head.

	6	7	8	9	10	11
Work clamp foot	10012349(L) 10012342(R)		10012339(L) 10012346(R)	10012341(L) 10012348(R)		10026244(L) 10026245(R)
Feed plate	10012277	10012302	10012286	10012296	10012301	10026246
	With knurl	With knurl	With knurl	Without knurl	Without knurl	Without knurl
Sewing specification	S	H/W	S	F	F	F
Finer guard	10011556(S、M、F)、10011695 (H、W)					

Remarks	Optional	Standard accessory for H type(heavy-weight material) machine head.	Optional	Accessory part for F(foundation)type.(Depends on the destination)	Optional
	12	13	14	15	16
Work clamp foot	10026247(L) 10026248(R)	10026250(L) 10026251(R)	10012344(L) 10012345(R)	10026253(L) 10026254(R)	10026256(L) 10026257(R)
Feed plate	10026249	10026252	10012338	10026255	10026258
	Without knurl	Without knurl	Without knurl	Without knurl	Without knurl
Sewing specification	F	S	S	S	S
Finger guard	10011556				
Remarks	Optional	Optional	Optional	Optional	Optional

※ Install a finger suitable for each work clamp foot when replacing the work clamp foot.

[7] Table of the optional parts

Name of Parts	Type	Part No.	Remarks
Feed plate blank t=1.2 	With knurl / processed Sewing area lengthwise 20 X crosswise 40	10012303	
	With knurl / processed Sewing area lengthwise 30 X crosswise 40	10014401	
Needle hole guide 	A=1.9 B=2.8 Without relief slit	10047532	Standard type
	A=1.6 B=2.0 Without relief slit	10011757	F and M types
	A=2.3 B=4.0 Without relief slit	10004727	H and W types
	A=3 B=7 Without relief slit	10007281	For net machine
	A=1.6 B=2.6 With relief slit	10004646	Selective spare part

II. EXPLANATION OF THE COMPUTER-CONTROLLED HIGH SPEED LOCKSTITCH BUTTON SEWING MACHINE

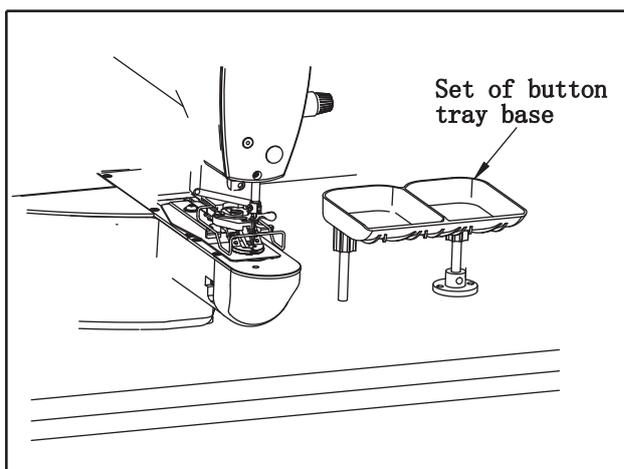
[1] Specifications

Different specifications from those of the bartacking machine only are described.

- 1) Sewing speed Max. 2700rpm
- 2) Needle DPx17 #14
- 3) Lifting method of the work clamp foot..... Stepping motor
- 4) Lift of the work clamp foot Max. 13mm
- 5) Number of standard patterns50 patterns
- 6) Wiper method Interlocked with work clamp foot lifter driven by stepping motor

[2] Installation of the sewing machine and preparation of the operation

 **WARNING :** Be sure to perform the work with two persons or more when moving the sewing machine



(1). Installation of the sewing machine head is same as that of the bartacking machine.

Refer to the instruction manual for the bartacking machine.

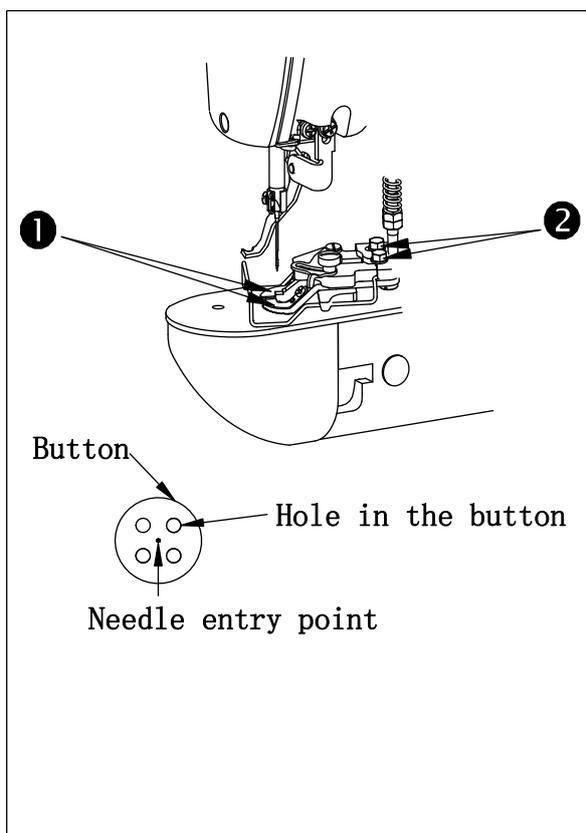
(2). Install a set of the button tray base to a convenient place for the work as the set is included in the accessories

 **Make sure before operation that the needle does not strike against the button hole .**

[3] Needle and thread

Needle	Needle thread	Bobbin thread
DPx17 #14	#60	#80
	#60	#60
	#50	#60
	#40	#60

Needle and thread will vary in accordance with the sewing conditions. when using the needle and the thread, select them referring to the left table. Cotton thread and polyester spun thread are recommended.

[4] Position of the button clamp jaw lever

1). Place a button in button clamp jaw levers ①.

2). With sewing LED goes off, press  key in the operation panel, then press  key to make machine find the zero position.

3). Turn the hand pulley and check that the center of the needle enters the center of the button.

4). If the center of the needle is not located in the center of the button, loosen screws ② in the button clamp jaw lever base to adjust so that the center of the needle enters the center of the button.

5). After the adjustment, perform the confirmation of the pattern shape and make sure that the needle surely has entered the button hole.

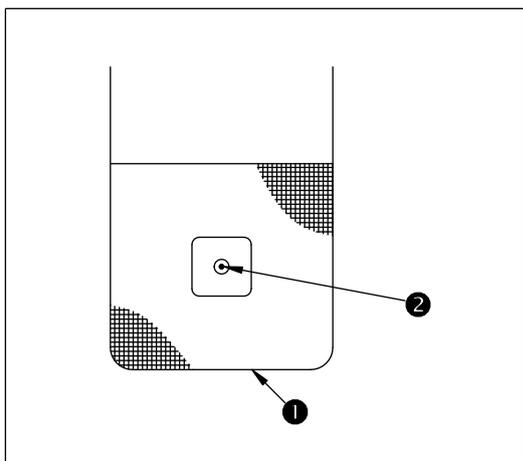
WARNING: When change of the shape of button, change of the sewing pattern or



enlargement/reduction of the sewing width is performed, make sure the needle entry point. If the needle extends outside the button hole or the sewing pattern extends outside the button clamp unit, the needle interferes with the button hole or the button clamp unit, resulting in the danger of the needle breakage or the like.

[5] Adjusting the feed plate

WARNING: When change of the shape of the button, change of the sewing pattern or enlargement/reduction of the sewing width is performed, make sure of the shape of the sewing pattern. If the feed plate interferes with the needle hole guide, it will result in the danger of the needle breakage or the like. Also, if the pedal is depressed during the adjustment, the button clamp unit will go up or come down. So, be careful.



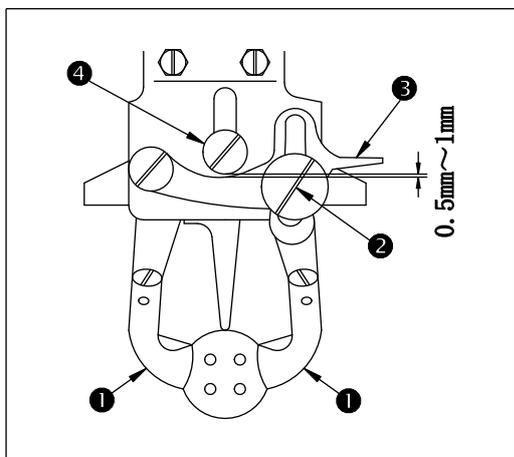
1) .With sewing LED goes off ,press  key in the operation panel,then press  key to make machine find the zero position.

2). adjust the feed plate ①, so the needle hole guide ② comes to the center of the recessed part of feed plate ①H.

[6] Adjusting the open angle of the button clamp jaw lever



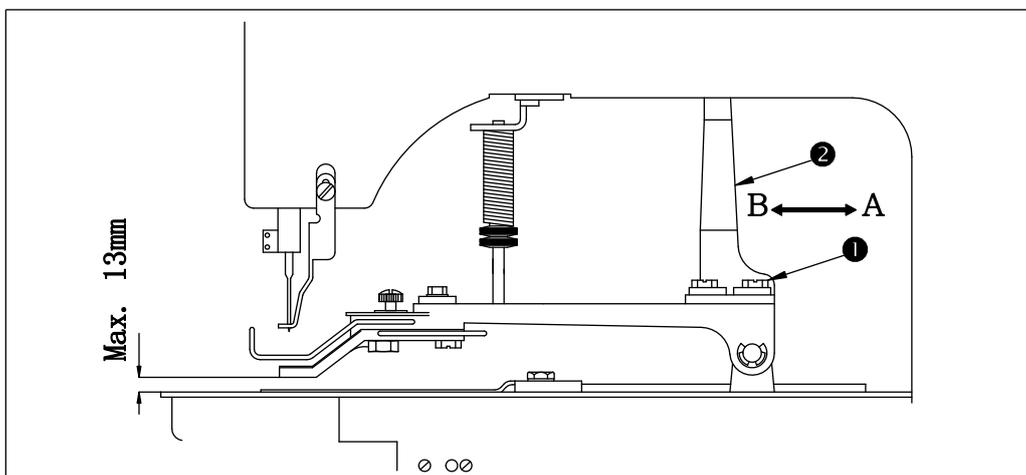
WARNING : Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.



Bring the machine to its stop-motion state. Then lift button clamp ①. Loosen screw ② in the button clamp jaw lever and adjust so that a clearance of 0.5 to 1mm is provided between button clamp jaw lever ③ and hinge screw ④ when placing a button in between button clamps ①. Then tighten screw ② in the button clamp jaw lever.

[7] Adjusting the lifting amount of the button clamp

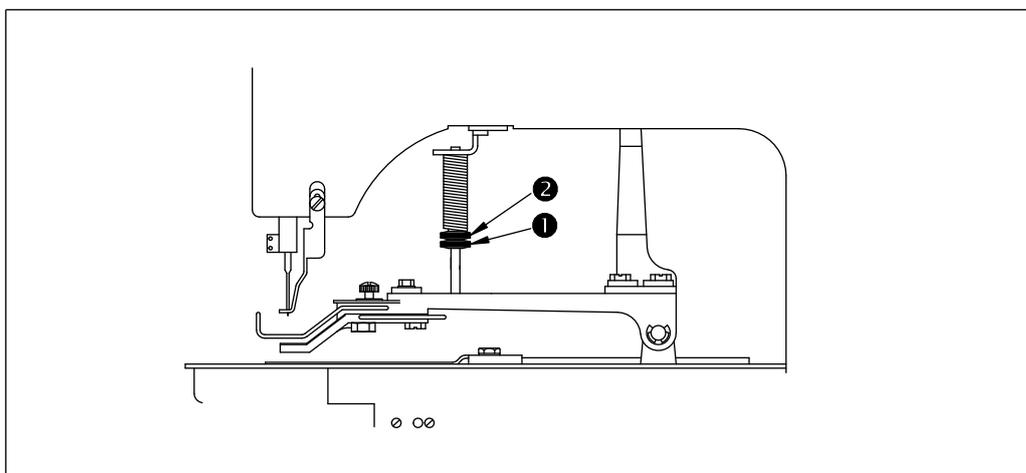
WARNING : Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.



Loosen two setscrews ①, and move moving plate ② back and forth in the direction of arrow to adjust. The lifting amount of the button clamp will be decreased when moving plate ② is moved in the direction "A", and be increased when it is moved in the direction of "B". After the adjustment, securely tighten setscrews ①.

[8] Adjustment of the pressure of the work clamp unit

WARNING : Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.

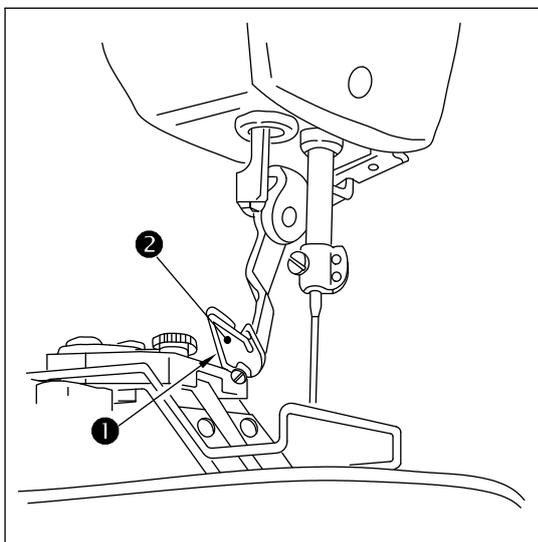


The pressure of the work clamp unit should be minimized as long as the material does not warp during sewing. Loosen adjusting screw ① and turn adjusting screw ② to obtain the aforementioned pressure.

[9] Adjusting the wiper spring



WARNING : Turn OFF the power before starting the work so as to prevent accidents cause by abrupt start of the sewing machine.



Wiper spring① retains the needle thread after thread trimming in between wiper② and the wiper spring. Correct properly the tension after wiper spring ① so that the tension at that time becomes 20 to 30 g(a little higher tension than that of the bobbin thread coming out of the bobbin case.



If the retaining of the needle thread is excessive, the thread may protrude from the upper side of the button.

[10] Button sewing scope

Model		Button sewing Machine	
Button size classification		For medium-sized buttons	
Outside diameter of applicable buttons (mm)		Ø8~Ø22	
Sewing size (mm)	0~3.5	0 to 3.5	
	0~3.5	0 to 3.5	

III.TROUBLES AND CORRECTIVE MEASURES(SEWING CONDITIONS)

Trouble	Cause	Corrective measures
1.The needle thread slips off at the start of bar-tacking	<ul style="list-style-type: none"> ① Stitches are slipped at the start ② The needle thread remaining on the needle after thread trimming is too short. ③ The bobbin thread is too short. ④ Needle thread tension at 1st stitch is too high. ⑤ Pitch at 1st stitch is too small. 	<ul style="list-style-type: none"> ○ Adjust the clearance between the needle and the shuttle to 0.05 to 0.1mm. ○ Set soft-start sewing at the start of bar tacking. ○ Correct the thread tension release timing of the thread tension controller No.2. ○ Increase the tension of the thread take-up spring, or decrease the tension of the thread tension controller No.1. ○ Decrease the tension of the bobbin thread. ○ Increase the clearance between the needle hole guide and the counter knife. ○ Decrease the tension at 1st stitch. ○ Decrease the number of rotation at 1st stitch at the sewing start. ○ Make the pitch at 1st stitch longer. ○ Decrease the needle thread tension at 1st stitch.
2.Thread often breaks or synthetic fiber thread splits finely.	<ul style="list-style-type: none"> ①The shuttle or the driver has scratches. ②The needle hole guide has scratches. ③The needle strikes the work clamp foot. ④Fibrous dust is in the groove of the shuttle race. ⑤The needle thread tension is too high. ⑥The synthetic fiber thread take-up spring is too high. ⑦The synthetic fiber thread melts due to heat generated on the needle. 	<ul style="list-style-type: none"> ○Take it out and remove the scratches using a fine whetstone or buff. ○Buff or replace it. ○Correct the position of the work clamp foot. ○Take out the shuttle and remove the fibrous dust from the shuttle race. ○Reduce the needle thread tension. ○Reduce the tension. ○Use silicone oil .
3.The needle often breaks.	<ul style="list-style-type: none"> ①The needle is bent. ②The needle hits the work clamp foot. ③The needle is too thin for the material. ④the driver excessively bends the needle. 	<ul style="list-style-type: none"> ○Replace the bent needle. ○Correct the position of the work clamp foot. ○Replace it with a thicker needle according to the material. ○Correctly position the needle according to the material. ○Widen the distance between the needle and the

	⑤Needle thread is stepped on by the work clamp foot at the start of sewing (Needle bend)	wiper.(23 to 25mm)
4. Threads are not trimmed.	①The counter knife is dull. ②The difference in level between the needle hole guide and the counter knife is not enough. ③The moving knife has been improperly positioned. ④The last stitch is skipped. ⑤Bobbin thread tension is too low.	○Replace the counter knife. ○Increase the bend of the counter knife. ○Correct the position of the moving knife. ○Correct the timing between the needle and the shuttle. ○Increase the bobbin thread tension.
5. Stitch skipping often occurs.	①The motions of the needle and shuttle are not properly synchronized. ②The clearance between the needle and shuttle is too large. ③The needle is bent. ④The driver excessively bends the needle.	○Correct the positions of the needle and shuttle. ○Correct the positions of the needle and shuttle. ○Replace the bent needle. ○Correctly position the driver.
6. The needle thread comes out on the wrong side of the material	①the needle thread tension is not high enough. ②The tension release mechanism fails to work properly. ③The needle thread after thread trimming is too long. ④Number of stitches is too few. ⑤When sewing length is short(End of needle thread protrudes on the wrong side of sewing product.) ⑥Number of stitches is too few.	○Increase the needle thread tension. ○Check whether or not the tension disc No.2 is released during bar-tracking. ○Increase the tension of the thread tension controller No.1. ○Correct the position of the moving knife. ○Use the lower plate, the hole of which is larger than the presser.

Trouble	Cause	Corrective measures
7. Threads break at time of thread trimming	①The moving knife has been improperly position.	○Correct the position of the moving knife.
8. Uneven length of the needle thread	①The tension of thread take-up spring is too low.	○Increase the tension of the thread take-up spring.
9. The length of needle thread does not become short	①The tension of thread tension controller No.1 is too low. ②The tension of thread take-up spring is too high. ③The tension of thread take-up spring is too low and motion is unstable.	○Increase the tension of thread tension controller No.1. ○Decrease the tension of thread take-up spring. ○Increase the tension of thread take-up spring and lengthen the stroke as well.

零件手册

PARTS BOOK

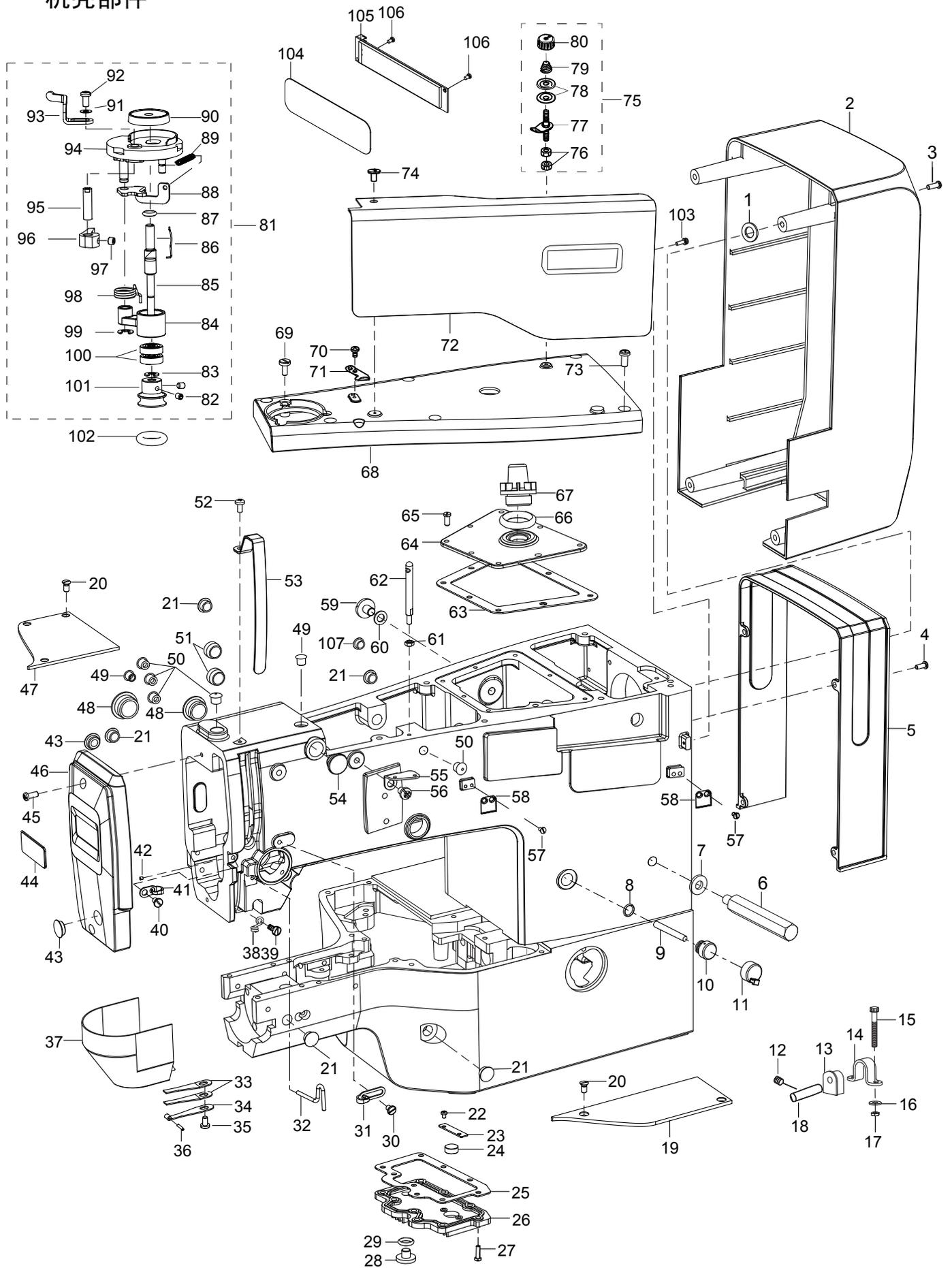
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1. FRAME&MISCELLANEOUS COVER COMPONENTS

机壳部件



1. 机壳部件FRAME&MISCELLANEOUS COVER COMPONENTS

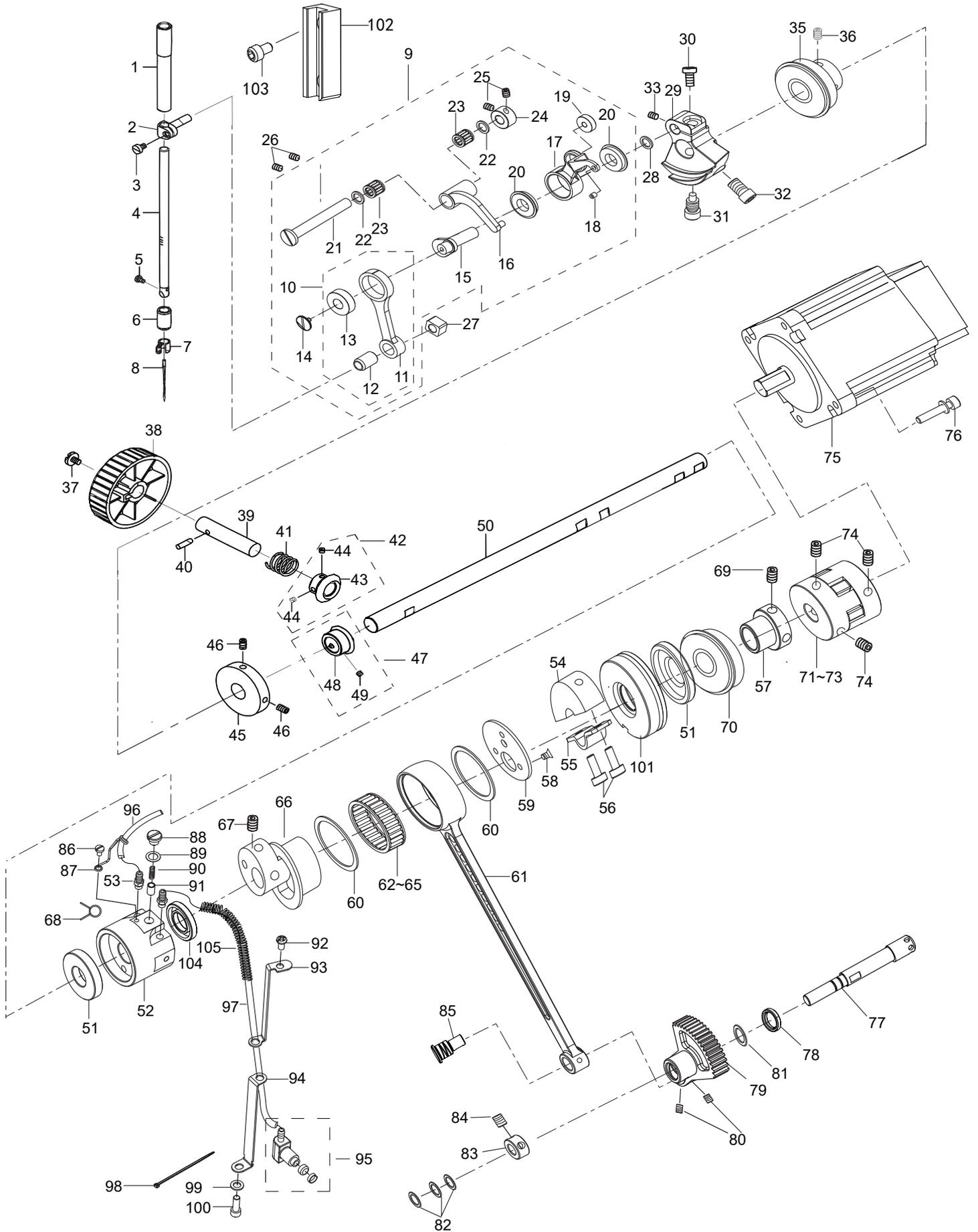
序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10011135	垫片	STOPPER	1
2	10062668	后罩	MOTOR COVER	1
3	10010900	螺钉 SM11/64"×40 L=12	SCREW SM11/64"×40 L=12	4
4	10042268	止退圈紧固螺钉	SCREW M4×10	4
5	10071607	后装饰板☆	THE BACK PANEL	1
6	10052703	手柄	HAND SHANK	2
7	10028127	橡胶垫 $\phi 8 \times \phi 20 \times 3.5$ 0	RUBER WASHER $\phi 8 \times \phi 20 \times 3.5$	2
8	10012139	形圈	RUBBER RING	1
9	10021559	销	PIN	1
10	10002483	排气阀	EXHAUST VALVE	1
11	10008771	橡胶盖	RUBBER COVER	1
12	10011232	螺钉	SCREW	2
13	10011137	机头胶垫	HINGE RUBBER	2
14	10011160	支撑固定架	BED HINGE	2
15	10011147	螺钉	SCREW	4
16	10003076	垫圈	WASHER	4
17	10003084	螺母	NUT	8
18	10011141	销	PIN	2
19	20026582	底板右盖板	THE RIGHT BED PANEL	1
20	10011566	螺钉	SCREW	5
21	10011136	橡胶塞 $\phi 10.5$	RUBBER PLUG $\phi 10.5$	4
22	10042310	下过线板螺钉	SCREW	2
23	10001242	垫板	PLATE	1
24	10001096	磁铁	MAGNET	1
25	10037232	齿轮箱盖密封垫	GEAR BOX SEAL GASKET	1
26	10037233	齿轮箱底盖	GEAR BOX COVER	1
27	10000560	螺钉 SM11/64"×40 L=16	SCREW SM11/64"×40 L=16	9
28	10008783	螺钉	SCREW	1
29	10010240	O形圈	RUBBER RING	1
30	10011142	螺钉	SCREW	1
31	10008940	右线钩	THE RIGHT THREAD GUIDE	1
32	10037247	拦线钩	L-SHAPED THREAD GUIDE	1
33	10010807	梭床罩弹簧B	HOOK COVER PRESSER SPRING B	1
34	10011420	梭床罩弹簧A	HOOK COVER PRESSER SPRING A	1
35	10010808	螺钉	SCREW	1
36	10010815	销	PIN	1
37	20023956	梭床罩焊合	SHUTTLE RACE CAP	1
38	10011139	下过线勾	THREAD GUIDE	1
39	10010668	螺钉	SCREW	1
40	10011142	螺钉	SCREW	1
41	10014281	中线钩	THE MID THREAD GUIDE	1
42	10011887	螺钉	SCREW	1
43	10011099	橡胶塞 $\phi 12.5$	RUBBER PLUG $\phi 12.5$	2
44	10070679	面板装饰牌☆	PLATE	1
45	10011150	螺钉	SCREW	2
46	20023811	面板	FACE COVER	1
47	20023934	底板左盖板	THE LEFT BED PANEL	1
48	10011146	橡胶塞 $\phi 20.8$	RUBBER PLUG $\phi 20.8$	2
49	10011188	橡胶塞 $\phi 7.4$	RUBBER PLUG $\phi 7.4$	2
50	10010587	橡胶塞 $\phi 8.5$	RUBBER PLUG $\phi 8.5$	5
51	10014279	橡胶塞 $\phi 15.3$	RUBBER PLUG $\phi 15.3$	2
52	10011150	螺钉 SM11/64"×40 L=10	SCREW SM11/64"×40 L=10	1
53	10062652	挑线杆防护罩	BALANCE COVER	1
54	10011190	橡胶塞 $\phi 14.5$	RUBBER PLUG $\phi 14.5$	1

1. 机壳部件FRAME&MISCELLANEOUS COVER COMPONENTS

序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
55	10011200	上过线板	THREAD GUIDE PLATE	1
56	10011158	螺钉	SCREW	1
57	10053628	SM9/64"×40螺钉 L=5.5	SCREW SM9/64"×40 L=5.5	4
58	10062675	卡紧扣	THE LOCKING PLATE	2
59	10051608	螺钉 SM5/16"×24 L=10	SCREW SM5/16"×24 L=10	1
60	10009988	橡胶垫 $\phi 7.8 \times \phi 13.5 \times 1.3$	RUBBER WASHER $\phi 7.8 \times \phi 13.5 \times 1.3$	1
61	10009471	M4螺母 (GB/T 6170-2000)	NUT (GB/T 6170-2000)	1
62	10062648	过线柱	THREAD GUIDE	1
63	10037218	上密封盖板垫	UPPER SEAL GASKET	1
64	10051609	上密封盖板	UPPER SEAL PLATE	1
65	10013977	螺钉	SCREW	7
66	10008939	O形圈	RUBBER RING	1
67	10012438	油窗	OIL TANK	1
68	20023812	上盖	TOP COVER	1
69	10011101	螺钉	SCREW	3
70	10011143	螺钉	SCREW	1
71	10011149	绕线切刀	THREAD CUTTER	1
72	20025162	右装饰板	THE RIGHT PANEL	1
73	10011161	螺钉	SCREW	6
74	10012599	螺钉	SCREW M5×7.8	2
75	10062647	M5×7.8夹线器	BOBBIN THREAD TENSION ASM	1
76	10004507	螺母	NUT	2
77	10004504	中过线板组件	BOBBIN THREAD TENSION ROD ASM	1
78	10004393	夹线板	THEAD TENSION DISK	2
79	10004391	弹簧	CONNECTING ROD SPRING	1
80	10062660	夹线螺母组件	NUT	1
81	10002558	绕线器	BOBBIN WINDER ASM	1
82	10002896	螺钉	SCREW	2
83	10007895	挡圈	E-RING	1
84	10027388	摆动连杆	BOBBIN WINDER SHAFT COMPL BOBBIN	1
85	10031163	梭芯卷绕轴弹	SHAFT	1
86	10031058	簧	SPRING	1
87	10027399	O型圈	RUBBER RING	1
88	10027391	控制板	ADJUSTING PLATE	1
89	10027394	弹簧	SPRING	1
90	10027390	卷绕轴垫	CUSHING	1
91	10003122	垫圈	WASHER	1
92	10009455	螺钉	SCREW	1
93	10027397	手柄	BOBBIN LEVER	1
94	10031087	梭芯卷绕体组件	BOBBIN FITING BASIS COMPL BOBBIN	1
95	10027396	定位块轴	CAM SHAFT	1
96	10027395	绕线定位块	BOBBIN WINDER REGULATOR	1
97	10012014	螺钉	SCREW	1
98	10027397	扭簧	SPRING	1
99	10013038	挡圈	E-RING	1
100	10003517	625ZZ轴承	BEARING	1
101	10004684	绕线轮	BOBBIN WINDER WHEEL	1
102	10011097	橡胶轮	RUBBER RING	1
103	10011143	SM9/64"×40螺钉	SCREWM9/64"×40	1
104	10071604	发光LOGO贴膜☆	LOGO	1
105	10074316	LOGO电路板组件☆	CIRCUIT BOARD ASM	1
106	10042310	螺钉	SCREW	2
107	10043310	橡皮塞 $\phi 8.8$	RUBBER PLUG $\phi 8.8$	1

2.MAIN SHAFT&NEEDLE BAR COMPONENTS

挑线刺布部件



2. 挑线刺布部件MAIN SHAFT & NEEDLE BAR COMPONENTS

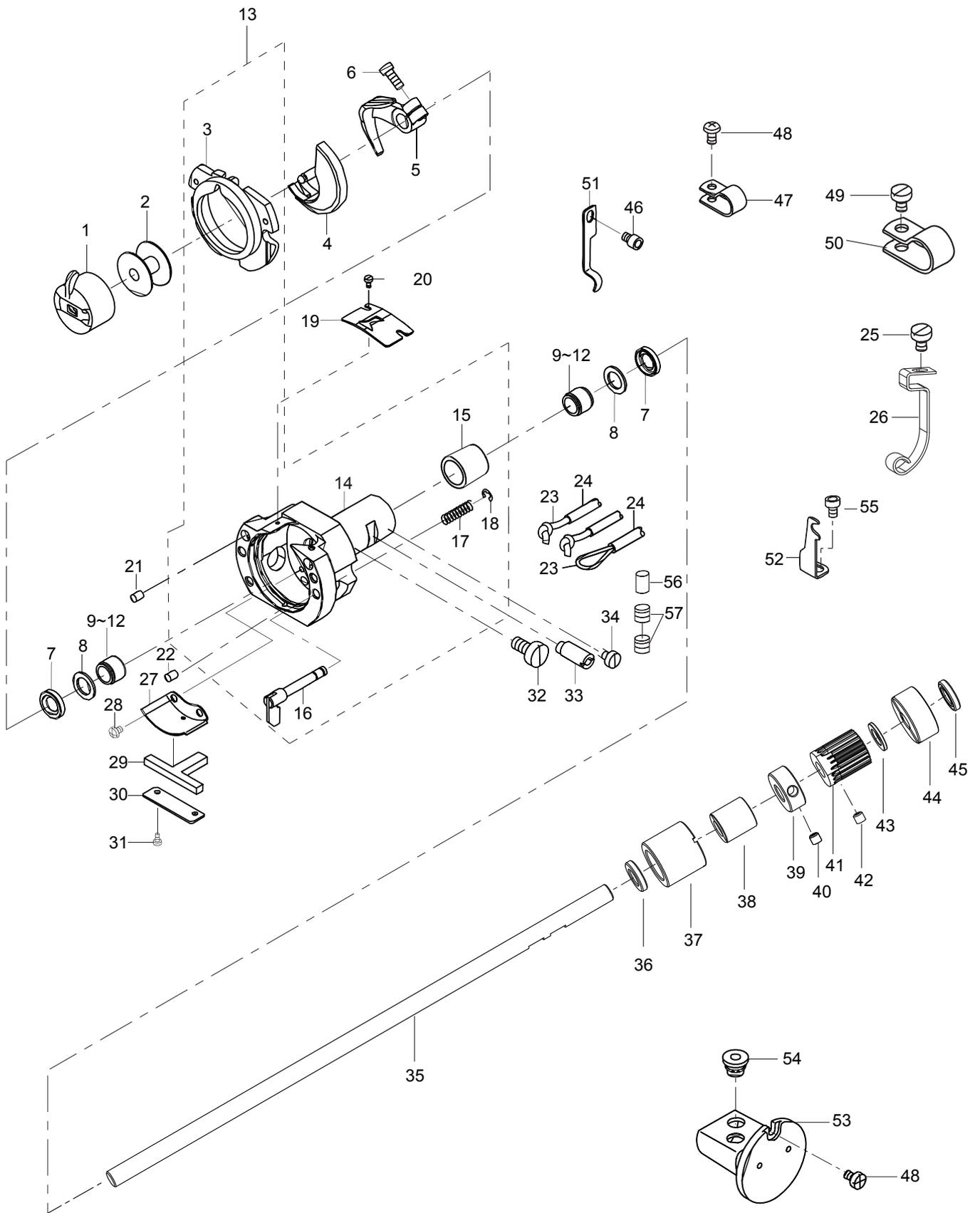
序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
1	10028715	轴套	NEEDLE ROD SLEEVE	1
2	10010590	针杆连接柱	NEEDLE BAR CONNECTING COLUMN	2
3	10030286	螺钉	SCREW	1
4	10014277	针杆	NEEDLE BAR	1
5	10011699	螺钉	SCREW	1
6	10028716	轴套	NEEDLE ROD LOWER METAL	1
7	10011701	针杆线钩	THREAD GUIDE	1
8	10023286	机针	NEEDLE DP? #16	1
9	10051398	挑线杆组件	THREAD TAKE UP COMPL	1
10	10007983	针杆连杆组件	NEEDLE BAR CRANK BOD ASM	1
11	10007986	针杆连杆	NEEDLE BAR CRANK ROD	1
12	10005793	针杆连杆轴套	NEEDLE BAR CRANK BOD METAL	1
13	10009777	轴承	BEARING	1
14	10010537	螺钉	SCREW	1
15	10008014	挑线曲柄	NEEDLE BAR CRANK	1
16	10052056	挑线连杆	THREAD TAKE UP CRANK	2
17	10052057	挑线杆	THREAD TAKE UP LEVER	1
18	10004161	挑线杆过线套	THREAD PASS BUSH	1
19	10003591	轴承	BEARING	1
20	10052090	轴承	BEARING	2
21	10007984	挑线连杆销	BALANCE CRANK PIN	1
22	10005786	挡圈	THRUST COLLAR	2
23	10005747	轴承	BEARING	2
24	10005745	挡圈	THRUST COLLAR	1
25	10004482	螺钉	SCREW	2
26	10042442	从动轮紧定螺钉	SCREW	2
27	10011194	针杆连接柱滑块	SQUARE BLOCK	1
28	10011622	挡圈	THRUST COLLAR	1
29	10052054	针杆曲柄	COUNTER EIGHT	1
30	10014272	螺钉	SCREW	1
31	10014282	螺钉	SCREW	1
32	10014284	螺钉	SCREW	1
33	10050053	螺钉M6×0.75	SCREW M6×0.75 L=6	1
35	10051864	轴承组件_6004	BEARING ASM 6004	1
36	10042442	从动轮紧定螺钉	SCREW M6×8	2
37	10011225	螺钉	SCREW	1
38	10062644	手轮	PULLEY	1
39	10062650	手轮轴	HAND PULLEY SHAFT	1
40	10006073	销	PIN	1
41	10062651	弹簧	SPRING	1
42	10021312	弧齿锥齿轮组件_手轮轴	GEAR ASM.	1
43	10011235	齿轮	GEAR	1
44	10011226	螺钉	SCREW	2
45	10009172	绕线主动轮	BTW DRIVING WHEEL	1
46	10011223	螺钉	SCREW	2
47	10027407	上轴齿轮组件	GEAR ASM.	1
48	10002413	齿轮	GEAR	1
49	10011226	螺钉	SCREW	2
50	10062903	上轴	MAIN SHAFT	1
51	10058049	油封	OIL SEAL	2

2. 挑线刺布部件MAIM SHAFT & NEEDLE BAR COMPONENTS

序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
52	10037249	油泵体组件	OIL PUMP ASM	2
53	10008779	油管接头	JOINT	1
54	10014337	上轴平衡轮	CRANK BALANCER	1
55	10014332	上轴平衡轮固定板	CRANK BALANCER FIX PLATE	1
56	10011644	螺钉	SCREW	2
57	10000313	上轴轴承挡圈	BALL BEARING BUSH	1
58	10009626	螺钉	SCREW	3
59	10014268	大连杆滚针轴承盖板	CRANK ROD SUPPORT PLATE	1
60	10014269	挡圈	RETAINING COLLAR	2
61	10037219	大连杆	CRANK ROD	1
62	10023508	轴承	BEARING	(1)
63	10023509	轴承	BEARING	(1)
64	10023510	轴承	BEARING	1
65	10023511	轴承	BEARING	(1)
66	10014265	偏心轮	ECCENTRIC WHEEL	1
67	10009187	螺钉	SCREW	2
68	10012160	弹簧	SPRING	2
69	10042442	从动轮紧定螺钉	SCREW M6×8	2
70	10077967	6204NR-DC轴承	BEARING ASM 6204NR-DC	1
71	10012615	电机端联轴器	COUPLING	1
72	10011227	传动连接橡胶块	RELAX	1
73	10012613	上轴端联轴器	COUPLING	1
74	10009187	螺钉	SCREW	4
75	10053840	上轴电机-04	AC SERVO MOTOR-04	1
76	10000157	螺钉	SCREW	4
77	10037229	销	PIN	1
78	10064708	油封	OIL SEAL	1
79	10037230	齿轮	BEARING	2
80	10011232	螺钉	SCREW	2
81	10037231	垫圈	WASHER	1
82	10010146	O形圈	RUBBER RING	3
83	10010803	挡圈	RETAINING COLLAR	1
84	10013590	螺钉	SCREW	2
85	10037228	销	PIN	1
86	10002129	螺钉	SCREW	1
87	10037260	油管定位架	FILLER PIPE HOLDER	1
88	10013232	螺钉	SCREW	1
89	10037261	防油纸垫	PAPER SPACER	1
90	10013238	活塞弹簧	SPRING	1
91	10012609	柱塞	PLUNGER	1
92	10046049	螺钉	SCREW	1
93	10037221	上油管架	UPPER FILLER PIPE BRACKET	1
94	10037222	下油管架	LOWER FILLER PIPE BRACKET	1
95	10000471	油管二接头	FILLER PIPE JOINT ASM.	1
96	10007800	φ3×φ5油管	φ3×φ5 FILLER PIPE	50mm
97	10007800	φ3×φ5油管	φ3×φ5 FILLER PIPE	310mm
98	40000363	扎带	BINDING TAPE	3
99	10006115	垫圈	WASHER	1
100	10013616	螺钉	SCREW	1
101	10070208	油封衬套	OIL SEAL METAL	1
102	10037240	滑块槽	SQUARE BLOCK TROUGH SCREW	1
103	10014477	螺钉	SCREW	2
104	10013448	油封	OIL SEAL	1
105	10051546	弹簧	SPRING	1

3. SHUTTLE DRIVER SHAFT COMPONENTS

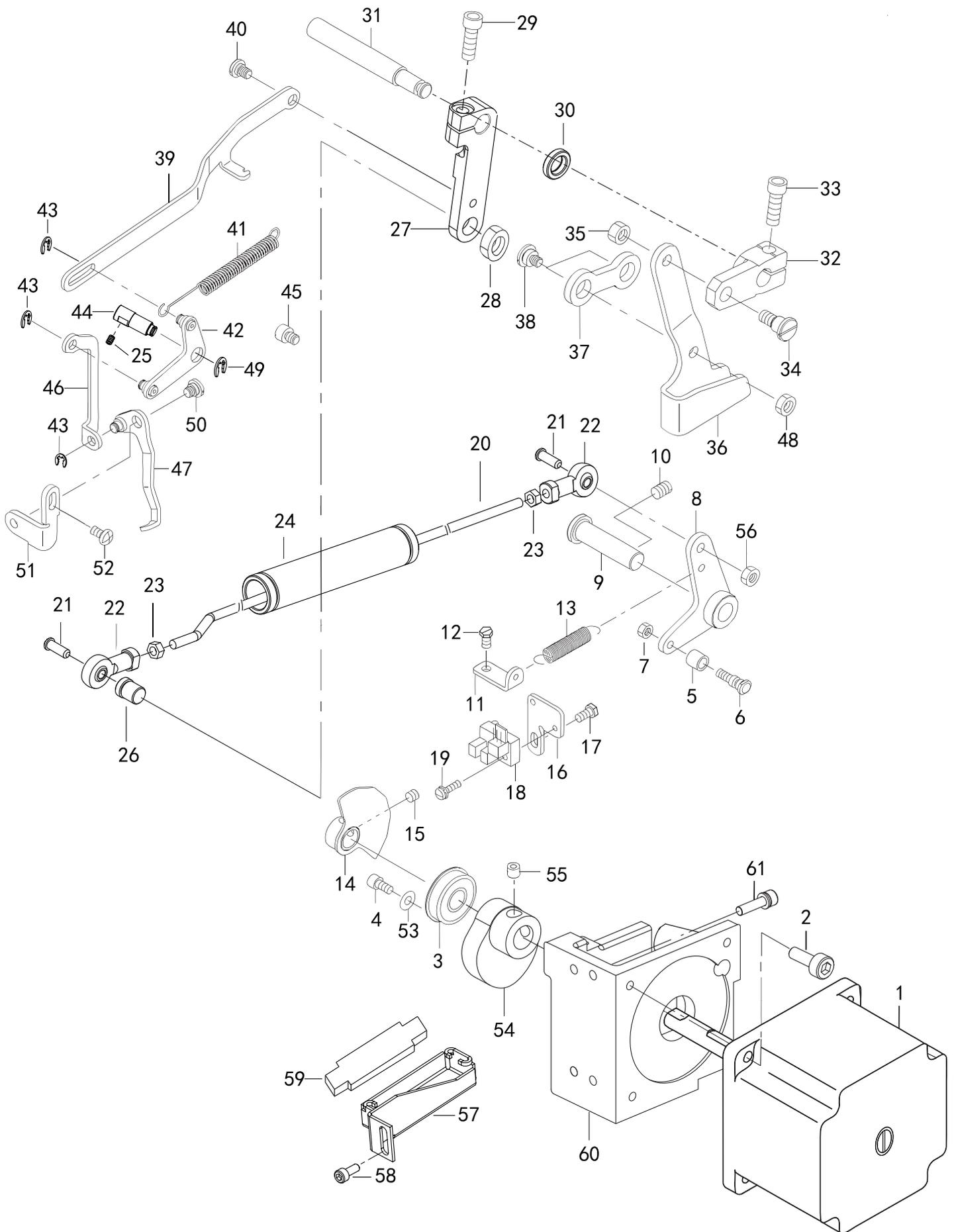
下轴部件



3. 下轴部件SHUTTLE DRIVER SHAFT COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10003781	梭壳	BOBBIN CASE ASM	1
2	10004592	锁芯	BOBBIN	1
3	10010738	梭床盖组件	SHUTTLE RACE RING ASM	1
4	10025068	摆梭	INNER HOOK	1
5	10004609	摆梭托	SHUTTLE DRIVER	1
6	10004611	螺钉	SCREW	1
7	10014297	油封	SHUTTLE OIL SEAL	2
8	10014295	挡圈	SHUTTLE BEARING RING	2
9	10023516	轴承	BEARING	2
10	10023517	轴承	BEARING	2
11	10023518	轴承	BEARING	2
12	10023519	轴承	BEARING	2
13	10026549	梭床与盖组件	SHUTTLE ASM.	1
14	10014248	梭床	SHUTTLE	1
15	10008576	梭床衬套	SHUTTLE BUSH	1
16	10004261	梭床锁紧钩组	INNER HOOK PRESSER ASM.	2
17	10004495	件弹簧	SPRING	2
18	10009669	挡圈	E-RING	2
19	10004596	梭床簧	SHUTTLE UPPER SPRING	1
20	10010744	螺钉	SCREW	2
21	10011427	毛毡	SHUTTLE OIL FELT	1
22	10011077	毛毡	SHUTTLE OIL FELT	1
23	10008103	油线	OIL WICK	2
24	10007800	油管	FILLER PIPE	2
25	10009849	M5×8 螺钉	SCREW M5×8	1
26	10026912	油管限位板C	OIL_PIPE HOLDER	1
27	10007926	油线夹板	SHUTTLE LUBRICATING PLATE	1
28	10010797	螺钉	SCREW	2
29	10010800	毛毡	SHUTTLE ONCE THROUGH OIL FELT	1
30	10010799	毛毡压板	ONCE THROUGH OIL LFELT PRESSER	1
31	10010744	螺钉	SCREW	2
32	10045298	螺钉	SCREW	1
33	10011426	螺钉	SCREW	1
34	10011142	螺钉	SCREW	1
35	10037224	下轴	LOWER SHAFT	1
36	10035171	油封	OIL SEAL	1
37	10037225	下轴前衬套	SLEEVE A	1
38	10037273	轴承	NUT	1
39	10037298	挡圈	WASHER	1
40	10013590	螺钉	SCREW	2
41	10037223	齿轮	GEARED	1
42	10011232	螺钉	SCREW	2
43	10037227	垫圈	WASHER	1
44	10037226	下轴后轴套	SLEEVE B	1
45	10035171	油封	OIL SEAL	1
46	10005107	螺钉	SCREW	1
47	10008228	SN-3A夹头	CABLE CLIP	1
48	10012892	螺钉	SCREW	2
49	10011101	螺钉	SCREW	1
50	10008229	SL-12N夹头	CABLE CLIP	1
51	10014294	油管限位板	OIL_PIPE HOLDER	1
52	10014288	油管限位板	TUBE_CLAMP	1
53	10021601	油窗组件	OIL TANK ASM. RUBBER	1
54	10014296	油塞	BUSH	2
55	10010685	螺钉	SCREW	2
56	10011916	油量调节销	NYLON BUSH 4.6×10	1
57	10011232	螺钉 M6×6	SCREW M6×6	2

4. LEFT PRESSER&WIPER MECHANISM COMPONENTS
抬压扫线部件



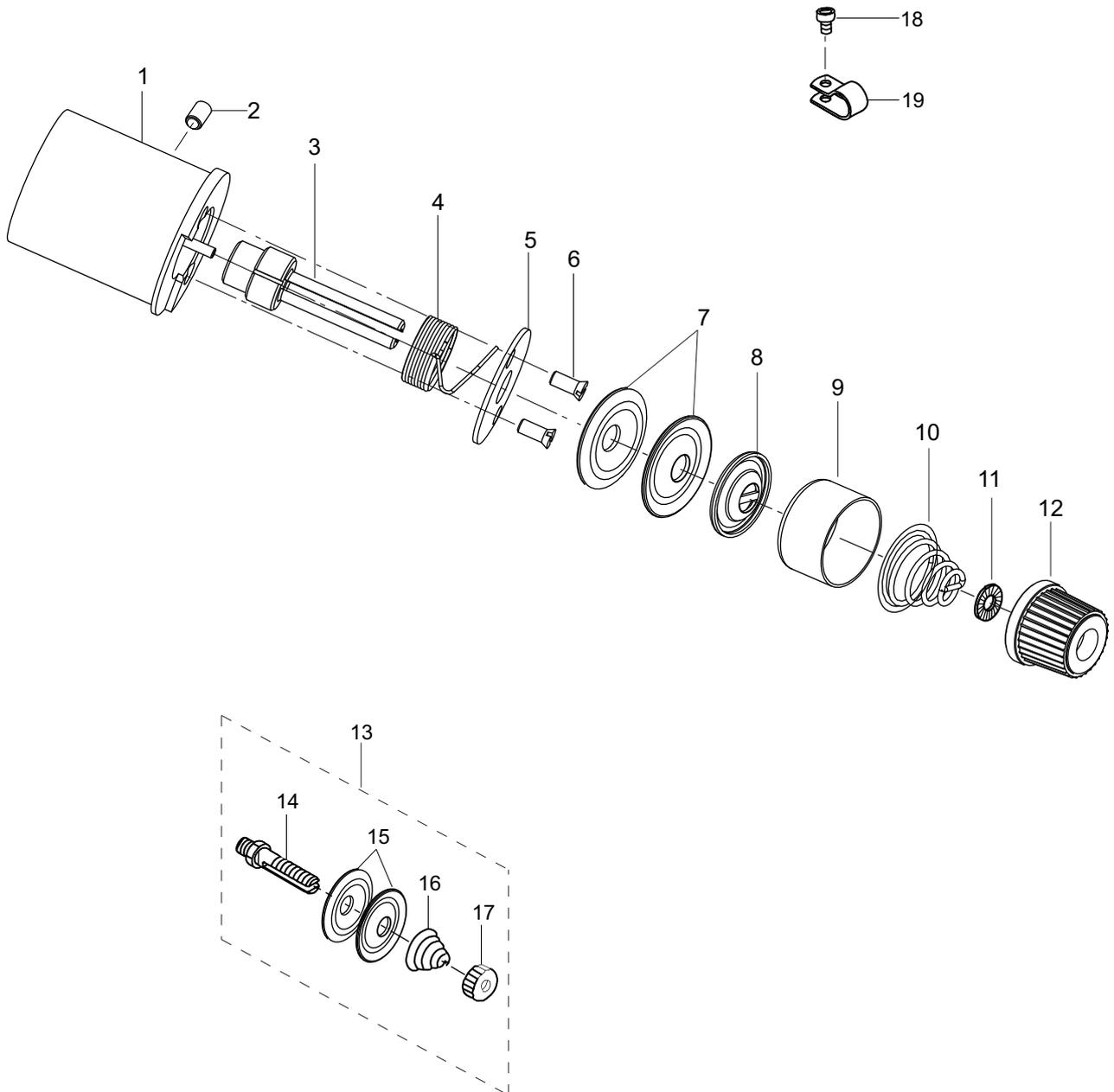
4. 抬压扫线部件LIFT PRESSER&WIPE MECHANISM COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10062819	抬压电机-04	PRESSER LIFTING MOTOR-04	1
2	10000157	螺钉	SCREW	4
3	10050516	轴承	BEARING	1
4	10010668	螺钉	SCREW	1
5	10028245	销套	NEEDLE CAM ROLLER A	1
6	10014342	销	UTT CAM ROLLER SHAFT	1
7	10010370	螺母	NUT	1
8	10037252	抬压曲柄组件	LIFTER LINK A ASM THREAD	1
9	10052771	抬压曲柄轴	TRIMMER SHAFT	1
10	10011232	螺钉	SCREW	1
11	10014343	拉板	SIDE COVER THREAD GUIDE	1
12	10011005	螺钉M4=9	SCREW M4 L=9	1
13	10014356	弹簧	SPRING	1
14	10014293	抬压电机传感片组件	SENSOR SLIT	1
15	10044814	螺钉	SCREW	2
16	10014291	抬压传感器安装板	SENSOR_INSTALLING_BASE	1
17	10009486	螺钉SM11/64"×40 L=8.5	SCREW SM11/64"×40 L=8.5	1
18	10069195	传感器_带卡扣	SENSOR	1
19	10010667	螺钉组件	SCREW	1
20	10037234	抬压拉杆	LIFTER LINK B	1
21	10037250	螺钉	SCREW	2
22	10011586	万能接头组件	UNIVERSAL CONTACT JOINT	2
23	10003075	螺母	NUT	2
24	10037235	抬压拉杆套	PULL-ROD BUSH	1
25	10005295	螺钉	SPRING	1
26	10037238	螺钉	SCREW	1
27	10037236	拨线曲柄	CONNECTING ARM	1
28	10037825	螺母	NUT	1
29	10010735	螺钉	SCREW	1
30	10037237	垫圈	WASHER	1
31	10011914	曲柄轴	CONNECTING SHAFT LOWERING	1
32	10014340	抬压驱动曲柄	ARM	1
33	10010735	螺钉	SCREW	1
34	10010674	螺钉	SCREW	1
35	10010725	螺母	NUT	1
36	10014355	抬压传动板	LOWERING FOOT CONNECTING	1
37	10010684	抬压脚定位连杆	LINK	1
38	10010727	螺钉	SCREW	2
39	10014346	扫线调节杆	WIPER CONNECTING LINK	1
40	10004594	螺钉	SCREW	1
41	10004604	弹簧	SPRING	1
42	10037255	扫线连接板组件	WIPER_CONNECTING_ARM_ASM	1
43	10009653	卡簧	RETAINING RING	3
44	10037257	扫线曲柄支撑销	SHAFT	1
45	10014345	螺钉	SCREW	1
46	10014353	扫线拉板	WIPER_CONNECTING_PLATE	1
47	10014348	扫线杆组件	WIPER C ASM	1
48	10010725	螺母	NUT	1
49	10007859	卡簧	RETAINING RING	1

4. 抬压扫线部件LIFT PRESSER&WIPE MECHANISM COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
50	10004593	螺钉	SCREW	1
51	10014341	扫线固定架	WIPER BASE PLATE	1
52	10010668	螺钉	SCREW	1
53	10010741	垫圈	WASHER	1
54	10014287	抬压凸轮	LIFT TO PRESS THE CAM	1
55	10011232	螺钉	SCREW	2
56	10042540	弯针调节柱螺母	NUT	1
57	10053640	抬压凸轮油槽	GREASE SLOT	1
58	10010685	螺钉	SCREW	2
59	10028676	毛毡	OIL FLET	1
60	10062814	电机固定架	MOTOR HOLDER	1
61	10000157	螺钉M5 L=18.5	SCREW M5 L=18.5	4

5. THREAD TENSION COMPONENTS
松线器组件

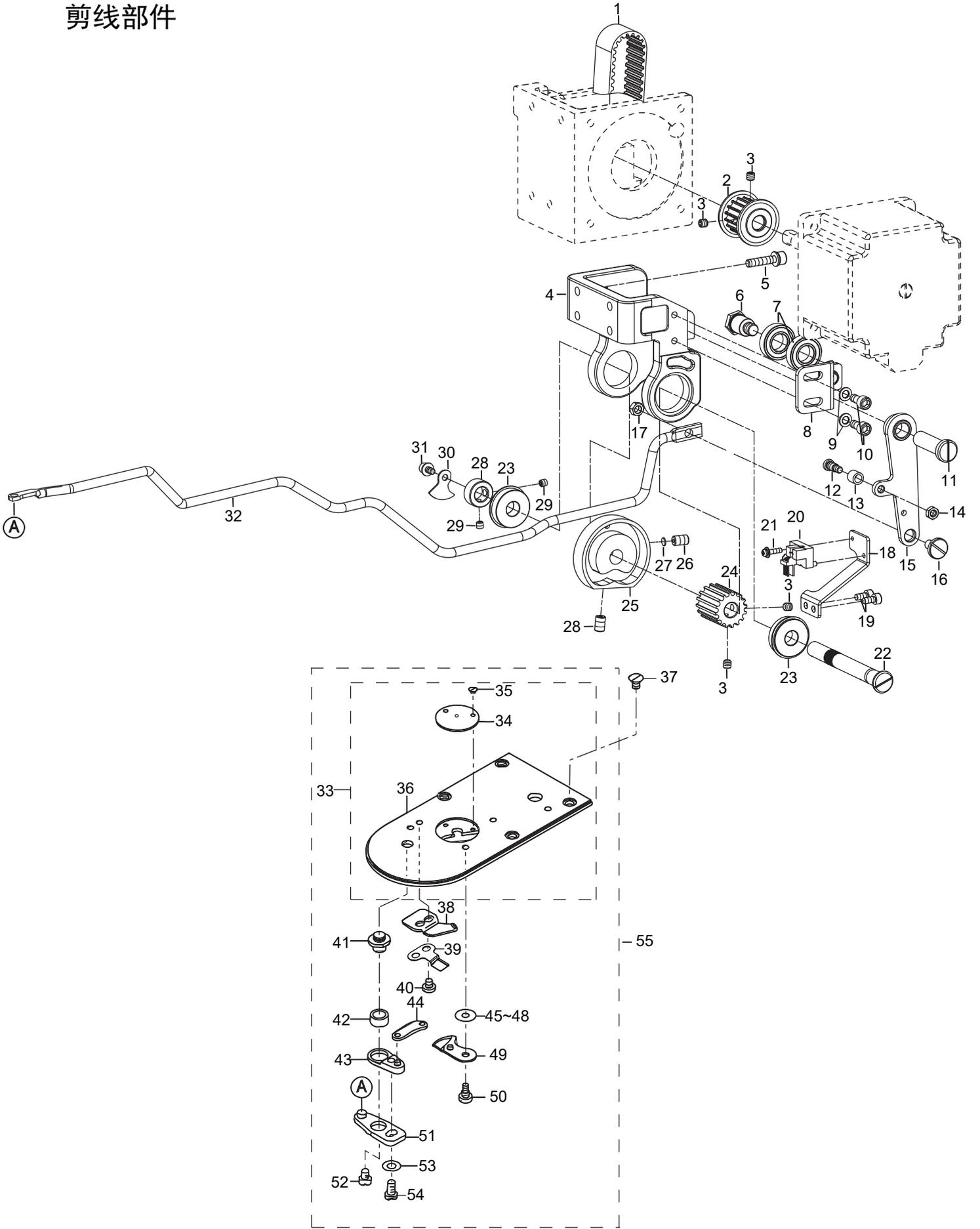


5. 松线部件THREAD TENSION COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10056036	电磁铁组件	THREAD TENSION ELECTROMAGNET	1
2	10026903	螺钉	SCREW	1
3	10042941	夹线螺钉	SCREW	1
4	10039203	弹簧	SPRING	1
5	10037243	锁紧块	LOCK PLATE	1
6	10052062	螺钉	SCREW	2
7	10005489	过线板	THREAD TENSION DISK	2
8	10004625	松线板	THREAD TENSION DISK PRESSER	1
9	10004598	夹线簧座	TENSION NUT	1
10	10004626	弹簧	SPRING	1
11	10004199	夹线制动板	ROTATING STOPPER	1
12	10062660	夹线螺母组件	THREAD TENSION NUT	1
13	10011493	夹线组件	FIRST THREAD TENSION ASM	1
14	10004666	螺钉	SCREW	1
15	10004393	夹线板	THREAD TENSION DISK	2
16	10004669	弹簧	SPRING	1
17	10004664	夹线螺母	TENSION NUT	1
18	10010685	螺钉	SCREW	2
19	10008228	SN-3A夹头	CABLE CLIP	3

6.THREAD TRIMMER MECHANISM COMPONENTS

剪线部件



6. 剪线部件THREAD TRIMMER MECHANISM COMPONENTS

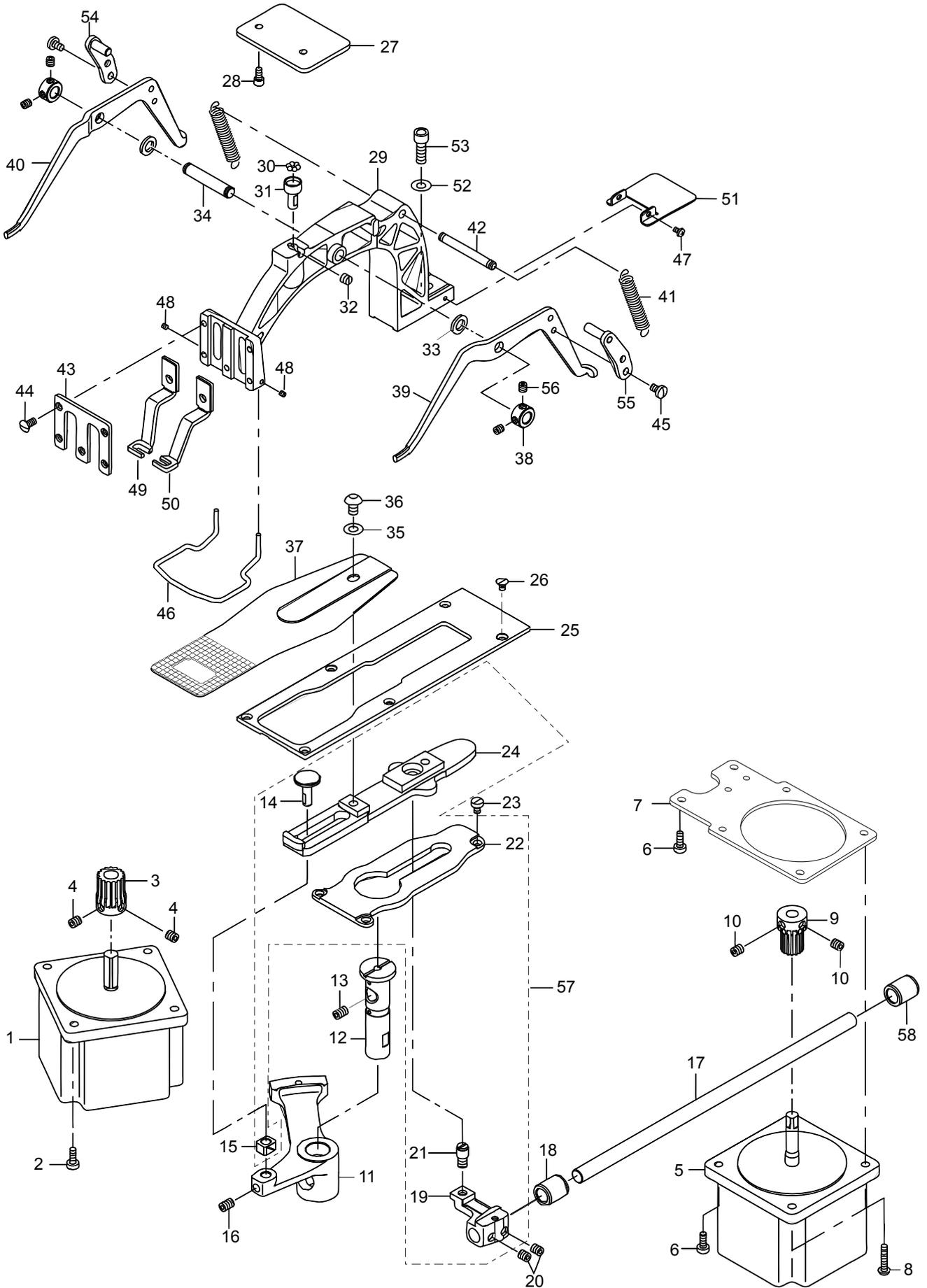
序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10062809	剪线同步带	TRIMMING TIMING BELT	1
2	10062811	剪线主动带轮	ACTIVE SYNCHRONOUS PULLEY	1
3	10012162	螺钉 M5×5	SCREW M5×5	4
4	10062813	同步带轮安装座	SYNCHRONOUS PULLEY BASE	1
5	10000157	螺钉组件 M5×21	SCREW M5×21	4
6	10037642	销	SHOULDER SCREW	1
7	10026221	轴承	BEARING	2
8	10062816	带轮支紧调节板	TENSION PLATE	1
9	10006115	垫圈	WASHER	2
10	10014210	M5×12螺钉	SCREW M5×1	2
11	10027364	销	PIN	1
12	10014342	销	PIN	1
13	10034929	销套	NEEDLE CAM ROLLER	1
14	10010370	SM11/64"×40螺母	NUT SM11/64"×40	1
15	10014339	剪线曲柄	CRANK	1
16	10027367	M5螺钉	SCREW M5	1
17	10042540	弯针调节柱螺母	NUT	1
18	10062817	剪线安全传感器座	THE SENSOR MOUNTING PLATE	1
19	10042268	止退圈紧固螺钉	SCREW M4×8	2
20	10069195	传感器_带卡扣	PHOTO SENSOR	1
21	10010667	传感器螺钉组件	SCREW COMPONENTS	1
22	10062812	剪线凸轮轴	AXIS	1
23	10050516	轴承_6000NR-2RS_BOM	BEARING_6000NR-2RS_BOM	2
24	10062810	剪线驱动轴带轮	BELT PULLEY	1
25	10065660	剪线凸轮	TRIMMING CAM	1
26	10046048	螺钉	SCREW SM1/4"×40 L=10	2
27	10023739	剪线凸轮垫	GASKET	1
28	10010803	挡圈	RETAINING COLLAR	1
29	10013590	SM11/64"×40螺钉	SCREW SM11/64"×40 SENSOR	2
30	10062815	安全开关感应片	SHEET	1
31	10003875	螺钉	SCREW ASM	1
32	10062818	剪线拉杆(同步带款)针	CONNECTION BAR	1
33	10014298	板组件	NEEDLE PATE ASM	1
34	10047532	小针板	NEEDLE HOLE GUIDE	1
35	10011509	螺钉	SCREW	2
36	10008027	针板	NEEDLE PLATE	1
37	10011511	螺钉	SCREW	4
38	10011501	定刀	FIXING KNIFE	1
39	10037254	底线夹线弹簧片	LOWER THREAD CLAMP SPRING	1
40	10011499	螺钉	SCREW	2
41	10011455	螺钉	SCREW	1
42	10011502	动刀杆销衬套簧	THREAD CUTTING LEVER RING	1
43	10010733	动刀曲柄分组件	THREAD CUTTER LEVER ASM	1
44	10011453	动刀连杆	MOVING KNIFE LINK	1
45	10007183	垫圈(0.5)	WASHER(0.5)	1
46	10007361	垫圈(0.6)	WASHER(0.6)	(1)
47	10007362	垫圈(0.7)	WASHER(0.7)	(1)
48	10007363	垫圈(0.8)	WASHER(0.8)	(1)

6. 剪线部件THREAD TRIMMER MECHANISM COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
49	10011513	动刀分组件	MOVING KNIFE ASM	1
50	10011500	螺钉	SCREW	1
51	10010737	动刀传动杆分组件	THREAD CUTTER LEVER ASM	1
52	10011503	螺钉	SCREW	1
53	10011506	垫圈	WASHER	1
54	10009906	螺钉	SCREW	1
55	10069251	针板大组件_套结S	NEEDLE PLATE ASM S	1

7. FEED MECHANISM COMPONENTS

送料部件



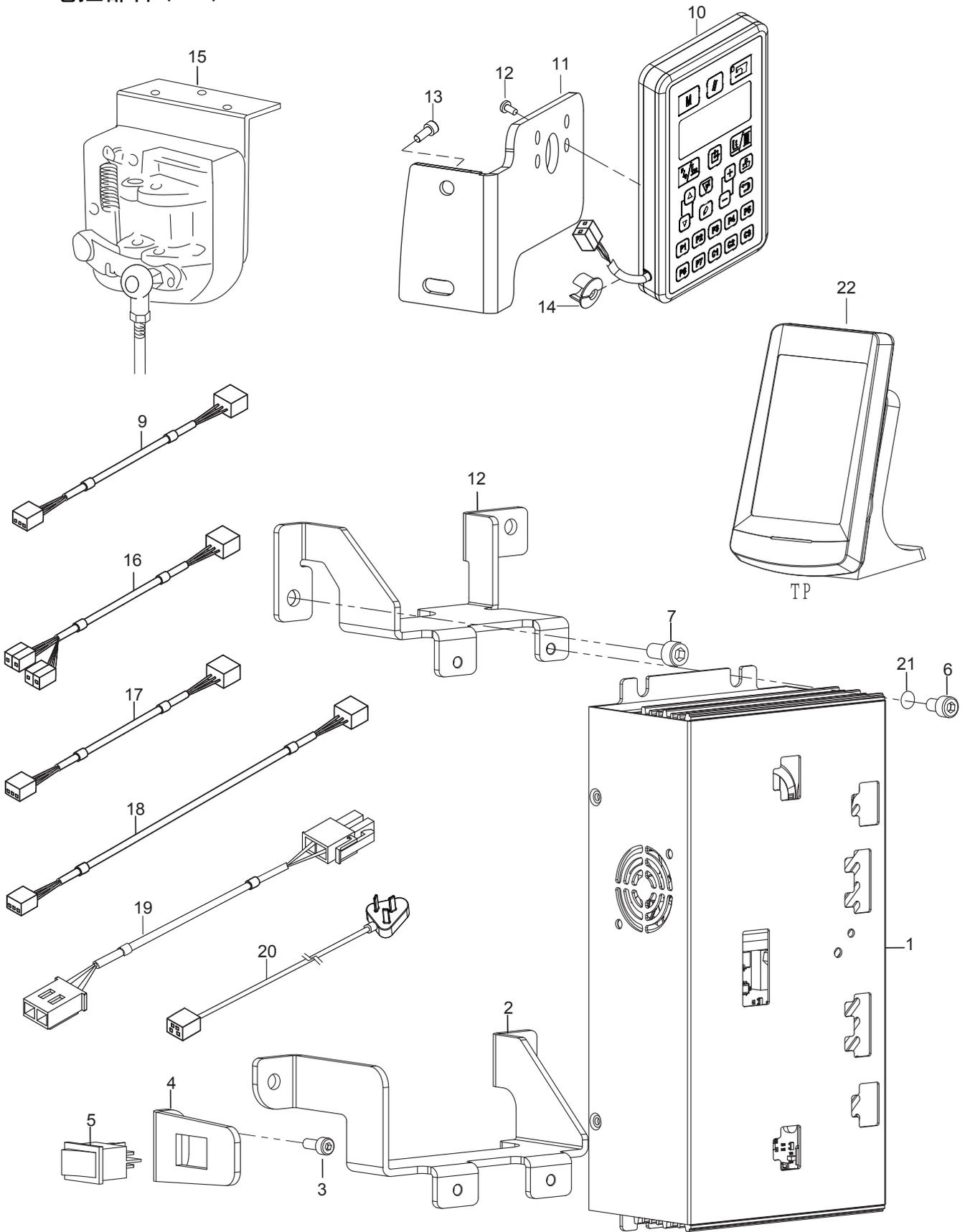
7. 送料部件FEED MECHANISM COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10053841	闭环X轴步进电机-04	X FEED STEPPING MOTOR	1
2	10011644	螺钉	SCREW	4
3	10011638	齿轮	GEAR	1
4	10011232	螺钉	SCREW	2
5	10053842	闭环Y轴不及电机-04	Y FEED STEPPING MOTOR	1
6	10011644	螺钉	SCREW	2
7	10052686	Y轴步进电机安装板	Y-AXIS MOTOR MOUNTING PLATE	1
8	10000157	螺钉	SCREW	4
9	10011640	齿轮	GEAR	1
10	10011232	螺钉	SCREW	2
11	10014318	齿轮	GEAR	1
12	10011573	X向铰轴	X HINGE AXIS	1
13	10010678	螺钉	SCREW	1
14	10011562	X向滑块轴	SLIDE BLOCK STUD	1
15	10011194	X向滑块	SQUARE BLOCK	1
16	10010678	螺钉	SCREW	1
17	10014326	Y向驱动轴	Y-DRIVING SHAFT	1
18	10011571	轴套	BUSHING, FORE	1
19	10011645	Y向驱动轴夹头	LENGTHWISE FEED ARM	1
20	10011642	螺钉	SCREW	2
21	10011568	螺钉	SCREW	1
22	10014325	送料托架支撑板	CLOTH FEED SUPPORT PLATE SCREW	1
23	10011142	螺钉	CLOTH FEED PLATE	3
24	10014321	送料托架	CLOTH FEED PRESSER PLATE SCREW	1
25	10063066	盖板	SUPPORT PLATE	1
26	10011566	螺钉	SCREW	6
27	10014300	送料架支撑板	FEED BRACKET	1
28	10011559	螺钉	SCREW	2
29	10014357	送料架	FEEDING FRAME	1
30	10011574	钢球	BALL	7
31	10011561	钢球座	SUPPORT	1
32	10044062	钢球座螺钉	SCREW	1
33	10014394	垫圈	WASHER	2
34	10028963	提升架轴	LIFTING LEVER SHAFT	1
35	10011646	垫圈	WASHER	2
36	10011569	螺钉	SCREW	1
37	10011565	送料板	FEED PLATE	1
38	10004600	挡圈	THRUST COLLAR	2
39	10011454	右压脚提升架	RIGHT LEVER	1
40	10011567	左压脚提升架	LIFT LEVER	1
41	10011558	弹簧	SPRING	2
42	10011456	拉簧支撑柱	SPRING SUSPENSION	1
43	10011557	压脚面板	WORK CLAMP FOOT FACE PLATE	1
44	10011510	螺钉	SCREW	5
45	10009906	螺钉	SCREW	4
46	10011556	护手圈	FINGER GUARDE	1
47	10002923	M3×6螺钉	SCREW	2
48	10003383	螺钉	SCREW	2

7. 送料部件FEED MECHANISM COMPONENTS

序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
49	10011508	左压脚	WORK CLAMP FOOT, LEFT	1
50	10011505	右压脚	WORK CLAMP FOOT, RIGHT	1
51	10014359	送料架后托板	HIDDEN_PLATE	1
52	10006013	垫圈	WASHER	1
53	10010735	螺钉	SCREW	1
54	10024705	左压脚提升导向板组件	LEVER DRIVING PLATE ASM.	1
55	10024706	右压脚提升导向板组件	LEVER DRIVING PLATE ASM.	1
56	10013590	螺钉	SCREW	4
57	10025161	送料托架组件	CLOTH FEED PLATE ASM	1
58	10024078	轴套	BUSHING, REAR	1

8. ELECTRONIC CONTROL SYSTEM COMPONENTS (-04) 电控部件(-04)



8. 自动控制部件ELECTRONIC CONTROL SYSTEM COMPONENTS (-04)

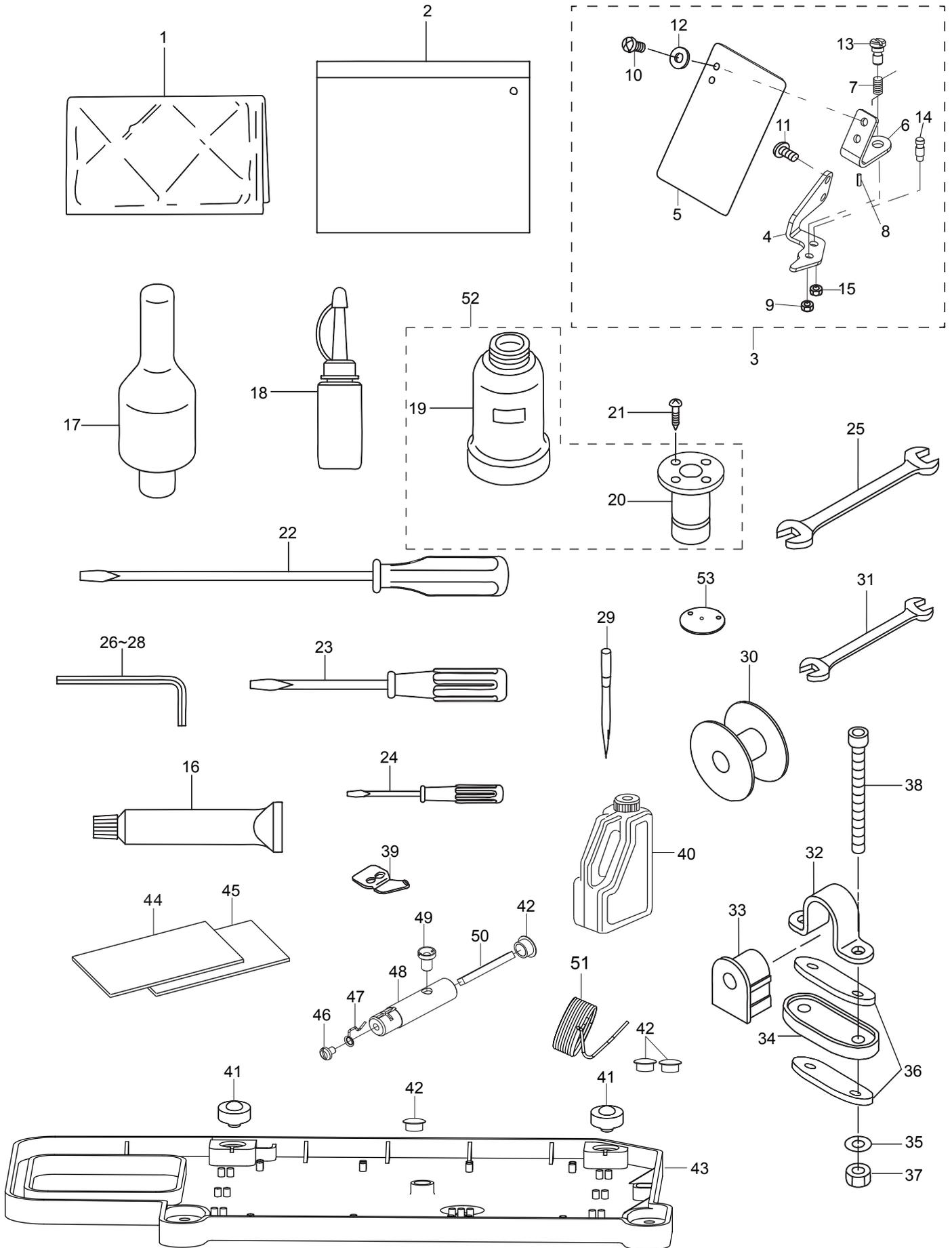
序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10063211	一体机大豪点阵屏电控组件	ELECTRONIC CONTROL SYSTEM ASM	1
2	10057430	电控下支撑板	CONTROL BOX INSTALLING BASE DOWN	1
3	10005041	螺钉 M4×10	SCREW M4×10	2
4	10057431	电源开关安装座	POWER SWITCH INSTALLING BASE	1
5	10057914	船形电源开关	POWER SWITCH	1
6	10012028	螺钉 M5×8	SCREW M5×8	4
7	10011824	螺钉 M6×12	SCREW M6×12	4
8	10057429	电控上支撑板	CONTROL BOX INSTALLING BASE UP	1
9	10069197	抬压传感线_带卡扣	TT SENSOR CABLE ASM	1
10	10073823	大豪点阵屏操作面板	OPERATION PANEL	1
11	10062657	操作面板安装板(1900)	OPERATION PANEL MOUNTING PANEL	1
11	10066318	操作面板安装板(1903)	OPERATION PANEL MOUNTING PANEL	1
12	10012892	M4×9.5螺钉	SCREW M4×9.5	2
13	10007096	M5×10螺钉	SCREW M5×10	2
14	10062653	面板过线塞	RUBBER STOPPER	1
15	10059376	脚踏开关组件	FOOT PEDAL ASM	1
16	10064709	夹线电磁铁转接线缆	CONNECTING CABLES ASM	1
17	10069196	剪线传感线_带卡扣	SAFETY SENSOR OF TRIM THREAD	1
18	10073822	操作面板连接线缆	WIRE FOR OPERATION PANEL	1
19	10064194	发光LOGO电路板连接线缆	WIRE FOR LOGO	1
20	10058510	电源开关线缆	WIRE FOR POWER SWITCH	1
21	10011820	φ 5.2× φ 10.3×1垫圈	WASHER φ 5.2× φ 10.3×1	2
22	10066908	触摸屏-V4	OPERATION PANEL	1

9. 线架部件THREAD STAND COMPONENTS

序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10007130	二线架组件	THREAD STAND ASM	1
2	10004282	撑管套	COLUMN CAP	1
3	10004293	线架上撑管	COLUMN PIPE	1
4	10003301	上过线架螺钉	SCREW	2
5	10003022	上过线架垫圈	WASHER	2
6	10002953	上过线架螺母	NUT	5
7	10004289	过线管	THREAD GUIDE PIPE	2
8	10004285	过线管套	THREAD GUIDE BUSHING	2
9	10004298	上过线架	THREAD HANGER	1
10	10004286	撑管夹	COLUMN PIPE CONNECTOR	1
11	10004291	线架下撑管	COLUMN PIPE	1
12	10004295	线架下撑管垫圈	WASHER	2
13	10004290	垫圈	WASHER	2
14	10002985	下过线架螺母线	NUT	1
15	10004288	轴	SPOOL PIN	2
16	10004287	线盘塑料压块线	SPOOL CUSHION	2
17	10004281	盘软垫	SOFT CUSHION OF THREAD PLARE	2
18	10004299	线盘	THREAD PLATE	2
19	10003312	下过线架螺钉下	SCREW	1
20	10004292	过线架	THREAD HANGER	1

10. ACCESSORIES PART COMPONENTS

附件



10. 附件ACCESSORIE PART COMPONENTS

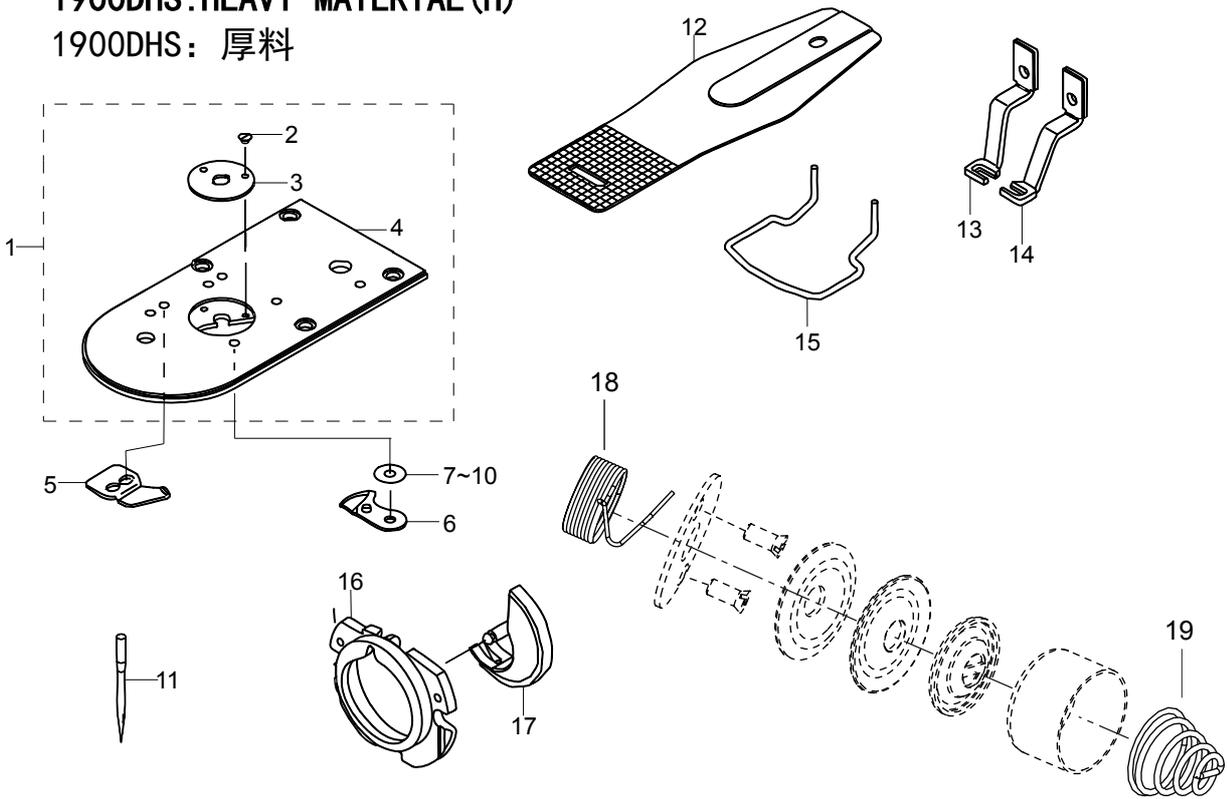
序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
1	10071554	机头罩☆	VINYL COVER	1
2	10004971	机头薄膜袋	ACCESSORY BOX	1
3	20004358	眼睛防护罩组件	SAFETY PLATE ASM.	1
4	10011632	安全板座	SAFETY PLATE INSTALLING BASE	1
5	10011636	安全板	SAFETY PLATE	1
6	10004725	安全板架	SAFETY PLATE INSTALLING PLATE	1
7	10011678	弹簧	SPRING	1
8	10002880	销	PIN	1
9	10010370	螺母	NUT	1
10	10046049	螺钉	SCREW	2
11	10046049	螺钉	SCREW	2
12	10011680	垫圈	WASHER	2
13	10011677	螺钉轴	HINGE SCREW	1
14	10011633	销	PIN	1
15	10011682	螺母	NUT	1
17	10011749	支承杆	HEAD SUPPORT BAR	1
18	10005356	油壶	OILER	1
19	10011681	油杯	OIL CAN	1
20	10011683	油杯座	OIL MANAGEMENT	1
21	10008197	螺钉	SCREW	6
22	10010994	大螺丝刀	SCREW DRIVER LARGE	1
23	10010995	中螺丝刀	SCREW DRIVER MIDDLE	1
24	10013185	小螺丝刀	SCREW DRIVER SMALL	1
25	10003368	呆板手	WRENCH	1
26	10009685	内六角扳手3	HEXAGONAL WRENCH SMALL	1
27	10009687	内六角扳手4	HEXAGONAL WRENCH LARGE	1
28	10009689	内六角扳手5	HEXAGONAL SPANNER	1
29	10023286	机针	NEEDLE	4
30	10004592	梭芯	BOBBIN	1
31	10003369	呆板手	WRENCH	1
32	10011160	支撑固定架	BED HINGE	2
33	10011137	机头胶垫	HINGE RUBBER	2
34	10014251	机头胶垫底座	BED HINGE RUBBER	2
35	10003076	垫圈	WASHER	4
36	10011747	垫片	WASHER	4
37	10003084	螺母	NUT	4
38	10011147	螺栓	SCREW	4
39	10011501	定刀	FIXING KNIFE	1
40	10060847	油壶 300ml	OIL BOX	1
41	10040431	机头座垫	SUPPORT RUBBER	2
42	10011136	橡胶塞	RUBBER PLUG	4
43	10062667	油盘	OIL TRAY	1
44	10071606	使用说明书及零件手册☆	INSTRUCTIONS ELECTRONIC	1
45	10063288	电控用说明书	INSTRUCTIONS	1
46	10011142	螺钉 SM11/64"×40 L=6	SCREW SM11/64"×40 L=6	1
47	10011918	硅油盒过线架	THREAD GUIDE SPRING	1
48	10011920	硅油盒	SOLICONE OIL BOX	1
49	10011917	螺钉 SM15/64"×40	SCREW SM15/64"×28	1
50	10011919	毛毡	OIL FELT	1
51	10039203	挑线簧	SPRING	1
52	10006185	油杯组件	OILER ASM	1
53	10004646	小针板 (φ 1.6)	NEEDLE HOLE GUIDE	1

11. 1900D SERIES COMPONENTS

1900D系列机零件

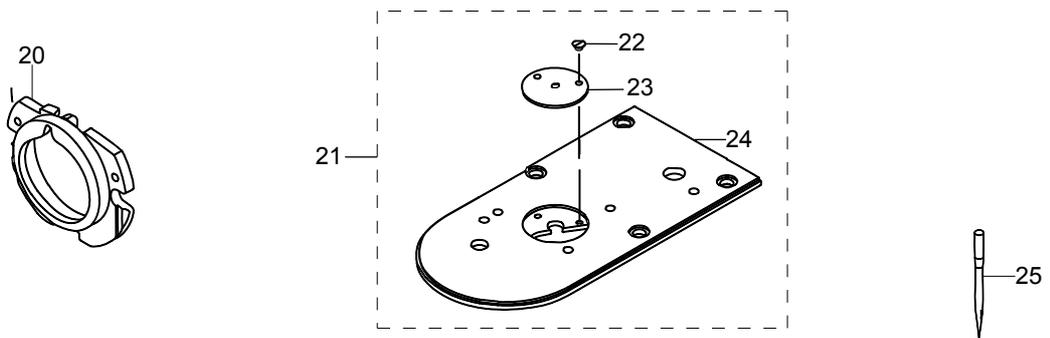
1900DHS:HEAVY MATERIAL (H)

1900DHS: 厚料



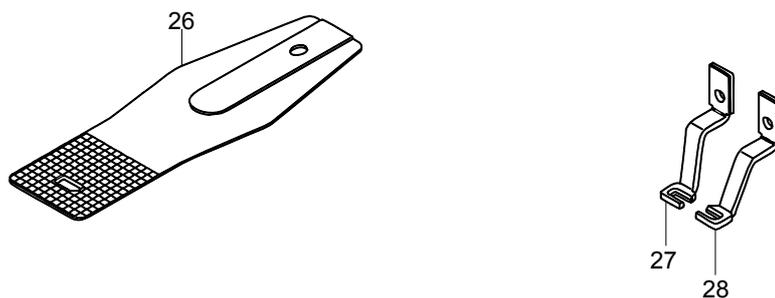
1900DFS:UNDERWEAR(F) & 1900DMS:KNITTING(M)

1900DFS: 内衣料 与 1900DMS: 针织料



1900DMS:KNITTING(M)

1900DMS: 针织料



11. 1900D系列机零件1900D SERIES PARTS

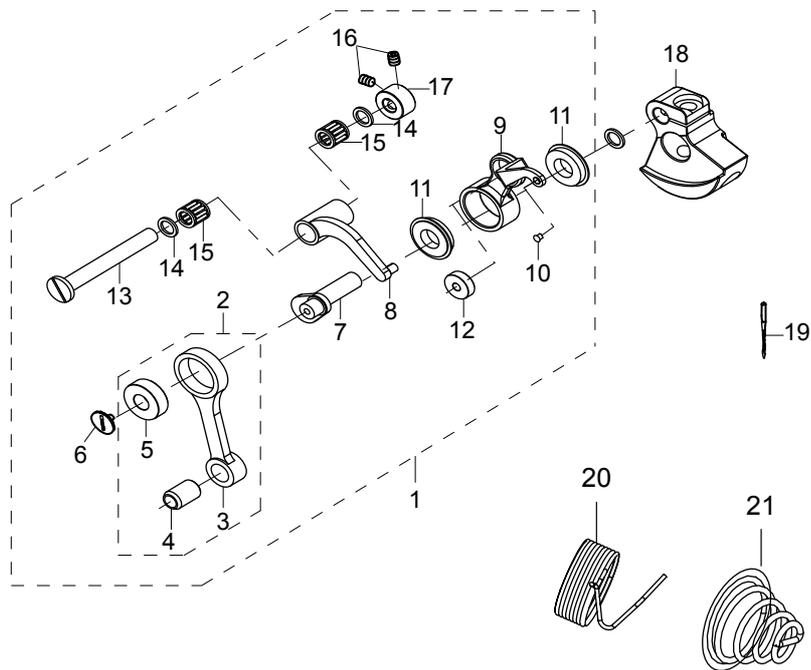
序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10024626	针板组件	NEEDLE PLATE ASM.	1
2	10011509	螺钉	SCREW	2
3	10004727	小针板	NEEDLE HOLE GUIDE	1
4	10008027	针板	NEEDLE PLATE	1
5	10011748	定刀	FIXING KNIFE	1
6	10011694	动刀分组件	MOVING KNIFE ASM.	1
7	10007183	垫圈	WASHER	(1)
8	10007361	垫圈	WASHER	(1)
9	10007362	垫圈	WASHER	1
10	10007363	垫圈	WASHER	(1)
11	10004897	机针 DP×17 19#	NEEDLE DP×17 19#	1
12	10011751	送料板	FEED PLATE	1
13	10011687	左压脚	WORK CLAMP FOOT, LEFT	1
14	10011691	右压脚	WORK CLAMP FOOT, RIGHT	1
15	10011695	护手圈	FINGER GUARDE	1
16	10031317	梭床盖组件	SHUTTLE BACE RING ASM.	1
17	10003834	旋梭	INNER HOOK	1
18	10037427	弹簧	SPRING	1
19	10011827	弹簧	SPRING	1
20	10011760	梭床盖组件	SHUTTLE BACE RING ASM.	1
21	10026087	针板组件	NEEDLE PLATE ASM.	1
22	10011509	螺钉	SCREW	2
23	10011757	小针板	NEEDLE HOLE GUIDE	1
24	10008027	针板	NEEDLE PLATE	1
25	10004857	机针 DP×5 11#	NEEDLE DP×5 11#	1
26	10011755	送料板	FEED PLATE	1
27	10011758	左压脚	WORK CLAMP FOOT, LEFT	1
28	10011759	右压脚	WORK CLAMP FOOT, RIGHT	1

12. 1903D-301 PARTS

1903D-301零件1

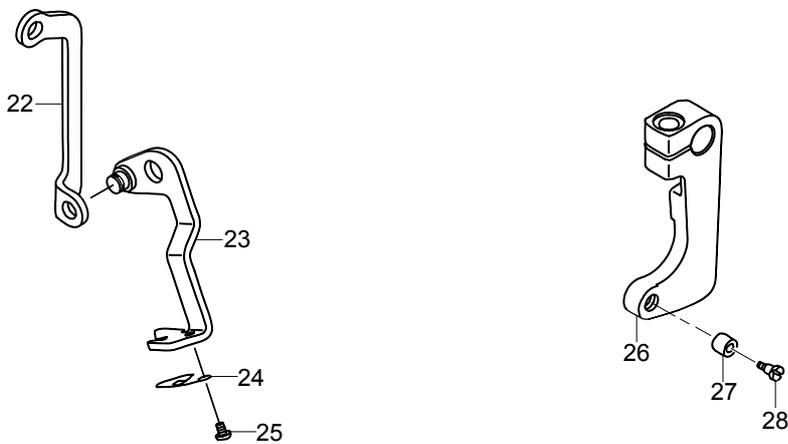
MAIN SHAFT & NEEDLE BAR COMPONENTS

挑线刺布部件



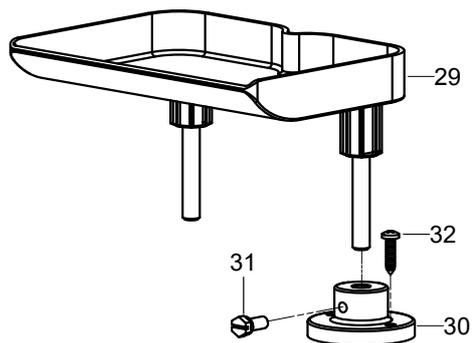
WIPER MECHANISM COMPONENTS

拨线部件



ACCESSORIES PART COMPONENTS

附件



12. 1903D-301零件1 1903D-301 PARTS 1

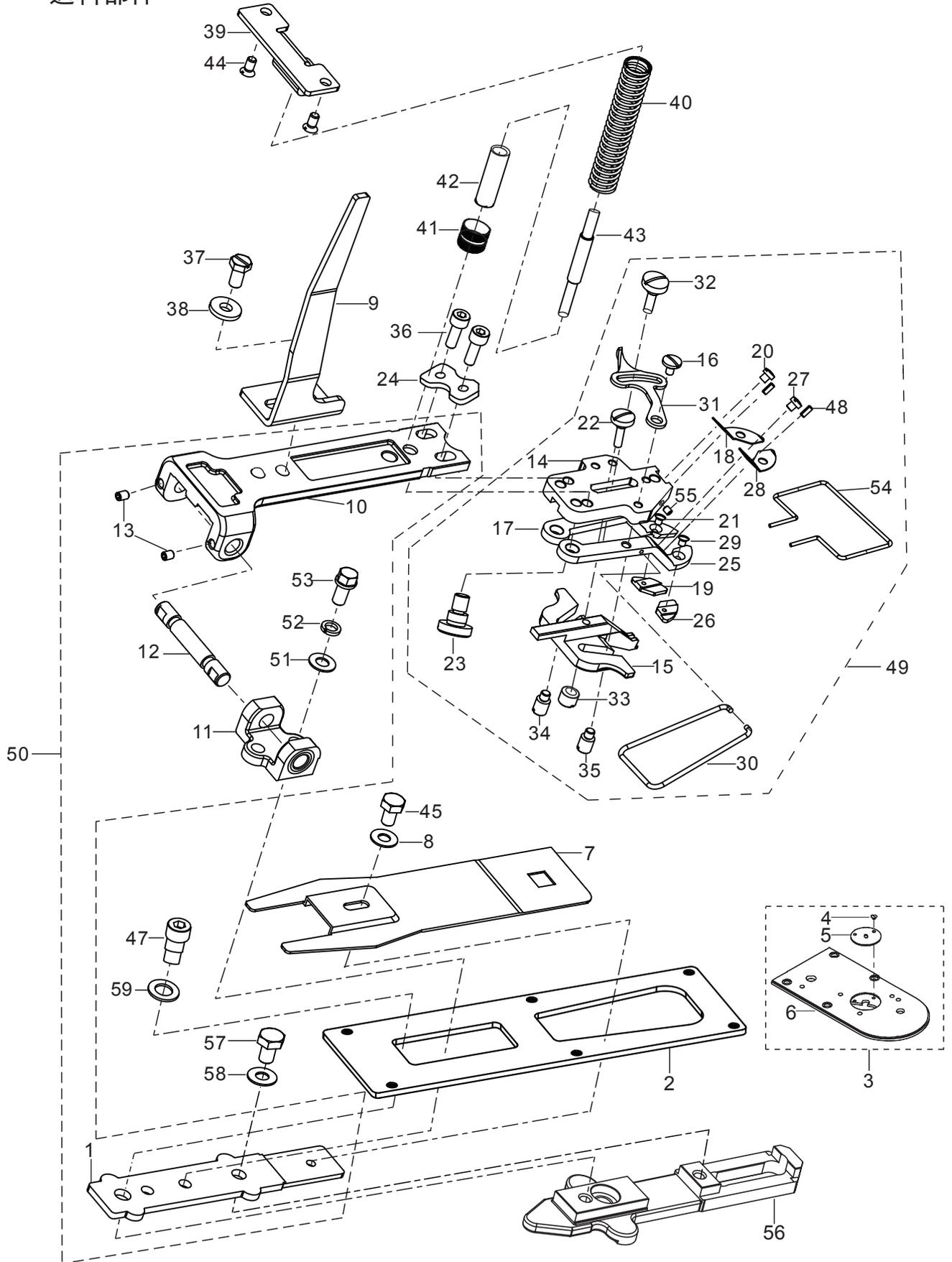
序号 Ref.No.	件号 Part No.	名 称	Description	数量 QTY
1	10052059	挑线杆组件	THEAD TAKE-UP COMPL	1
2	10007983	针杆连杆组件	NEEDLE BAR CRANK ROD ASM.	1
3	10007986	杆连杆	NEEDLE BAR CRANK ROD	1
4	10005793	针杆连杆轴套	NEEDLE BAR CRANK ROD METAL	1
5	10009777	轴承	BEARING	1
6	10010537	螺钉	SCREW	1
7	10023931	挑线曲柄	NEEDLE BAR CRANK	1
8	10052056	挑线连杆	THREAD TAKE-UP CRANK THREAD	1
9	10023930	挑线杆	TAKE-UP LEVER THREAD PASS	1
10	10004161	挑线杆过线套	BUSH	1
11	10009776	轴承	BEARING	2
12	10003591	轴承	BEARING	1
13	10007984	挑线杆铰链轴	BALANCE CRANK PIN	1
14	10005786	挡圈	THRUST COLLAR	2
15	10005747	轴承	BEARING	2
16	10004482	螺钉	SCREW	2
17	10005745	挡圈	RETAINING COLLAR	1
18	10023932	针杆曲柄	COUNTER EIGHT	1
19	10056816	机针	NEEDLE	1
20	10037427	弹簧	SPRING	1
21	10004626	弹簧	SPRING	1
22	10023928	扫线拉杆	WIPER LINK	1
23	10023927	扫线杆组件	WIPER ASM.	1
24	10011706	弹簧	SPRING	1
25	10011714	螺钉	SCREW	2
26	10037834	扣夹抬压曲柄	CONNECTING ARM	1
27	10037835	抬压曲柄滚子	CONNECTING ARM SLEEVE	1
28	10011707	螺钉	SCREW	1
29	10004665	纽扣盆组件	BUTTON SEAT ASSEMBLY	1
30	20004014	纽扣架底座	BUTTON SEAT	1
31	10011530	M6×12螺钉	SCREW M6×12	1
32	10008323	ST4. 2×20-C-H螺钉	TAPPING SCREW ST4. 2×20	2

13. 1903D-301 PARTS 2

1903D-301零件2

FEED MECHANISM COMPONENTS

送料部件



13. 1903D-301 PARTS 2

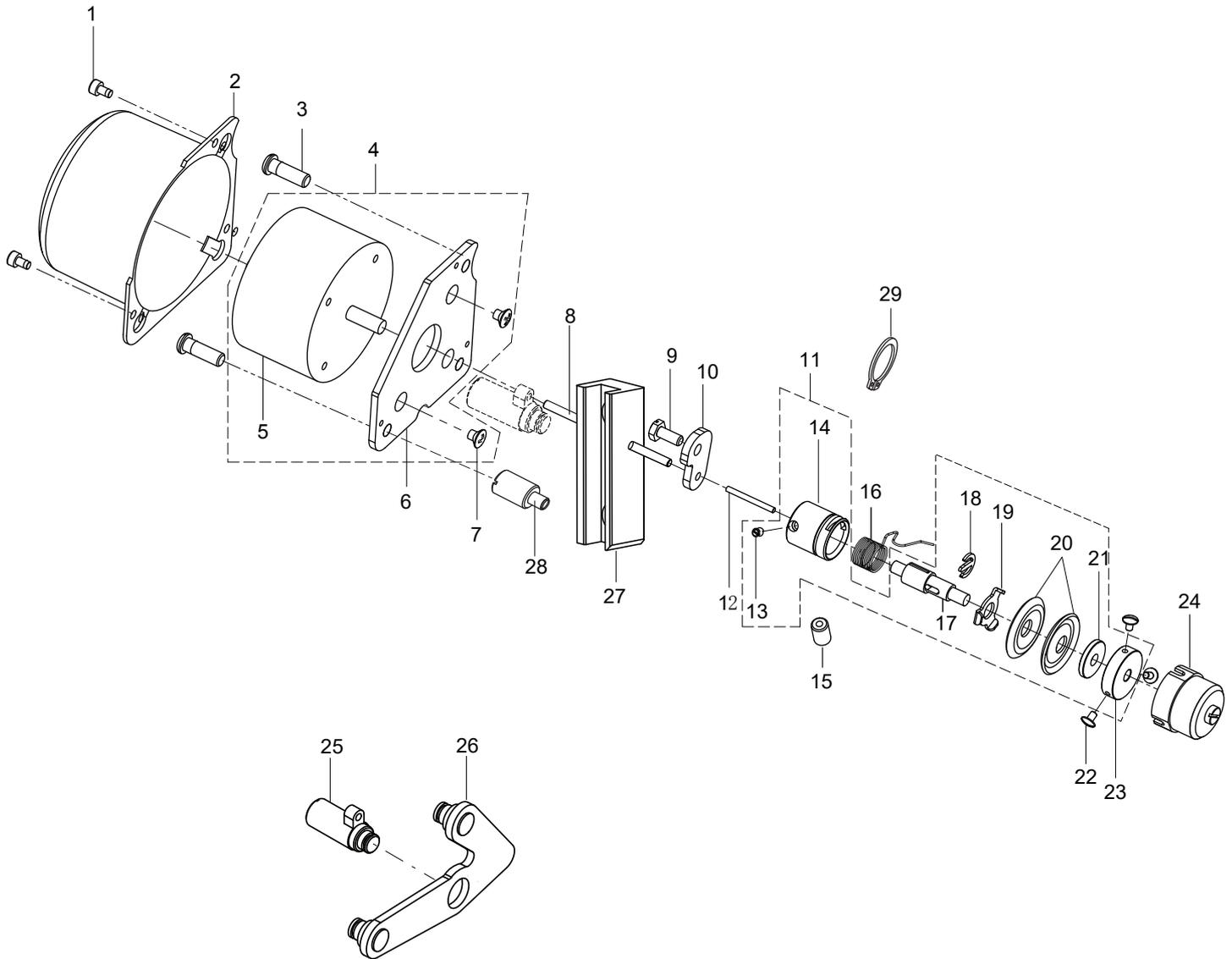
序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
1	10047339	送料板座	CLOTH FEED PLATE	1
2	10063067	盖板	FEED PLATE PRESSER	1
3	10026088	针板组件	NEEDLE PLATE ASM.	1
4	10011509	螺钉	SCREW	2
5	10011133	小针板	NEEDLE HOLE GUIDE	1
6	10008027	针板	NEEDLE PLATE	1
7	10011844	送料板	PRESSURE PLATE	1
8	10011820	垫圈	WASHER	1
9	10047343	抬压挡板	MOVING PLATE	1
10	10047338	扣夹座	BUTTON FOOT	1
11	10047340	扣夹支承座	BUTTON INSTALLING BASE	1
12	10047341	扣夹座铰轴	BUTTON FOOT INSTALLING SHAFT	1
13	10047342	螺钉	SCREW	2
14	10059165	压脚连接座	PICK-UP FOOT INSTALLING BASE	1
15	10059164	压脚导向座	BUTTON CLAMP SLIDE	1
16	10011559	螺钉	SCREW	1
17	10059163	右压脚座	SMALL CLAMP JAW LEVER, ASM. R	1
18	10059173	纽扣右定位板	SPRING, RIGHT	1
19	10059162	右压脚	PLATE K, R	1
20	10059171	螺钉	SCREW	1
21	10059175	螺钉	SCREW	1
22	10059178	螺钉	SCREW	1
23	10059168	螺钉	SCREW	2
24	10011761	抬压挡板座压板	PRESSER PLATE	2
25	10059159	左压脚座	SMALL CLAMP JAW LEVER, L	1
26	10059160	左压脚	PLATE K, L	1
27	10059171	螺钉	SCREW	1
28	10059172	纽扣左定位板	SPRING, LEFT	1
29	10059175	螺钉	SCREW	1
30	10059170	护指器	FINGER PROTECTOR	1
31	10059166	压脚调节扳手	SNAP FASTENER CLAMP STOP LEVER	1
32	10059176	螺钉	SCREW	1
33	10059193	螺母	NUT	1
34	10059194	压脚座导向柱	BUTTON CLAMP STOP PIN	1
35	10059194	压脚座导向柱	BUTTON CLAMP STOP PIN	1
36	10009818	螺钉	SCREW	2
37	10011828	螺钉	SCREW	2
38	10011821	垫圈	WASHER	2
39	10023934	压脚导杆导板	ACCETP PLATE, UPPER	1
40	10011593	弹簧	SPRING	1
41	10011526	螺母	NUT	2
42	10011528	压脚导杆套	SLEEVE	1
43	10011519	压脚导杆	ADJUSTING SHAFT	1
44	10011559	螺钉	SCREW	2
45	10011832	螺钉	SCREW	1
46	10014394	垫圈	WASHER	1
47	10047345	螺钉	SCREW	1
48	10059177	销	PIN	2
49	10032432	扣夹分组件	BUTTON CLAMP ASM.	1
50	10047337	扣夹座分组件	BUTTON FOOT CLAMP ASM.	1
51	10011646	垫圈	WASHER	2
52	10003077	垫圈	WASHER	2
53	10047342	螺钉	SCREW	2
54	10059170	手指保护器	FINGER GUARDE	1
55	10047342	螺钉	SCREW	2
56	10047346	送料托架	CLOTH FEED PLATE	1
57	10000809	螺钉 M6 L=10	SCREW M6 L=10	1
58	10011646	垫圈 $\phi 6.5 \times \phi 13 \times 0.8$	WASHER $\phi 6.5 \times \phi 13 \times 0.8$	1
59	10014394	垫圈 $\phi 8.2 \times \phi 15 \times 1$	WASHER $\phi 8.2 \times \phi 15 \times 1$	1

14. 1900D-T PARTS

1900D-T 零件

THREAD TENSION COMPONENTS

夹线分组件



14. 19000D-T零件 19000D-T PARTS

序号 Ref.No.	件号 Part No.	名称	Description	数量 QTY
1	10001616	M3×4螺钉	SCREW M3×4	3
2	10064296	夹线电磁铁罩壳	HOUSING	1
3	10000512	螺钉	SCREW	3
4	10064290	电磁铁组件	THREAD TENSION ELECTROMAGNET	1
5	10064291	电磁铁	ELECTROMAGNET	1
6	10064295	安装板	MOUNTING PLATE	1
7	10030192	M4×8螺钉	SCREW M4×8	3
8	10064300	顶杆	PUSH ROD	1
9	10011005	M4×9螺钉	SCREW M4×9	1
10	10064293	导向板	GUIDE PLATE	1
11	10064299	夹线器座组件	IRST THREAD TENSION ASM	1
12	10064301	夹线针	SPINDLE	1
13	10000746	M3×4螺钉	SCREW M3×4	1
14	10000749	夹线器座	THREAD TENSION POST BASE	1
15	10010678	螺钉	SCREW	1
16	10067020	挑线簧(薄料)	SPRING(S)	1
16	10069688	挑线簧(厚料)	SPRING(H)	1
17	10064306	夹线器芯轴	AXIS	1
18	10064305	夹线器活动卡簧	RETAINER RING	1
19	10064304	夹线三爪盘	CLAW	1
20	10000768	夹线板	HREAD TENSION DISK	2
21	10064292	垫圈	RUBBER RING	1
22	10000743	M2.5×4外盖螺钉	SCREWM2.5×4	3
23	10064303	夹线器挡块	LINK STOPPER	1
24	10000756	夹线器外盖	COVER	1
25	10067383	扫线曲柄支撑销	SHAFT	1
26	10064297	扫线连接板组件	WIPER_CONNECTING_ARM_ASM	1
27	10067175	针杆滑块槽	SQUARE BLOCK TROUGH SCREW	1
28	10064294	螺柱	SCREW	1
29	10050674	Φ17挡圈	RETAINING RING	1