

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。



超高速包缝机 B8510/B8500
SUPER HIGH-SPEED OVERLOCK SEWING MACHINE

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



为了安全

对于缝纫机本身及各种装置，我们充分考虑到他的安全性。请遵照基本的操作方法，安全的进行工作。

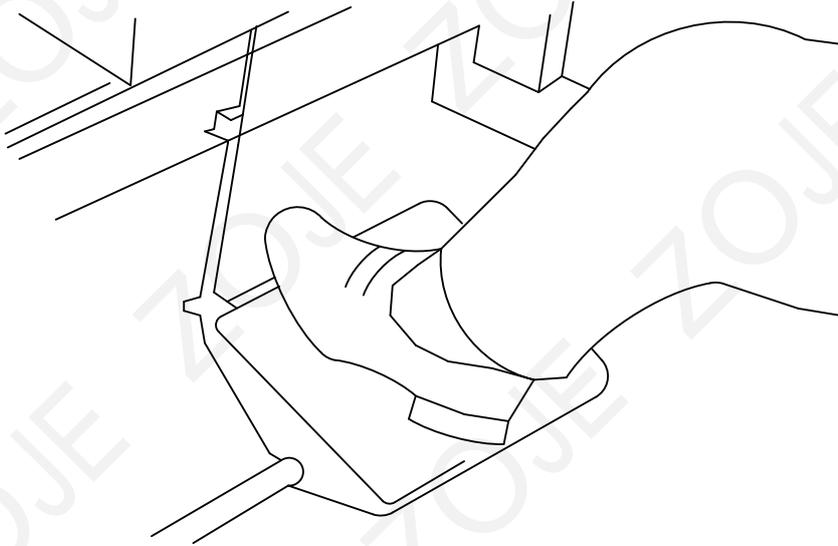
- 拆除为保证安全所设置的装置、零件的情况下使用，是非常危险的，请绝对不要拆除后使用。
- 缝纫机在使用时，请不要在缝纫机台板上放置工具及缝纫时不必要的东西。
- 在对缝纫机进行检修、调节、清扫、穿线、换针等时，为防止发生事故，务必请切断电源。在确定即使踩缝纫机踏板，缝纫机也不动之后，再进行操作。



CAUTION

Observe the safety precautions though takes the utmost care to produce safe sewing machines and devices,operstors should follow these basic safety rules.

- To prevent accidents,do not remove safety devices or parts while operating the machine.
- Do not leave tools or other unnecessary objects on the machine table while operating the machine.
- Before maintenance,adjusting,clearing, threading or replacing the needle,and to prevent accidents,be sure the power is turned dff.Check that the machine will not operate when the pedal is pressed.



- 在离开缝纫机台时，请务必关掉电源。
- 停电时也请务必关掉电源。
- 为了总是安全地、运转良好的使用缝纫机，经常的检查是不可缺少的。请予以注意。

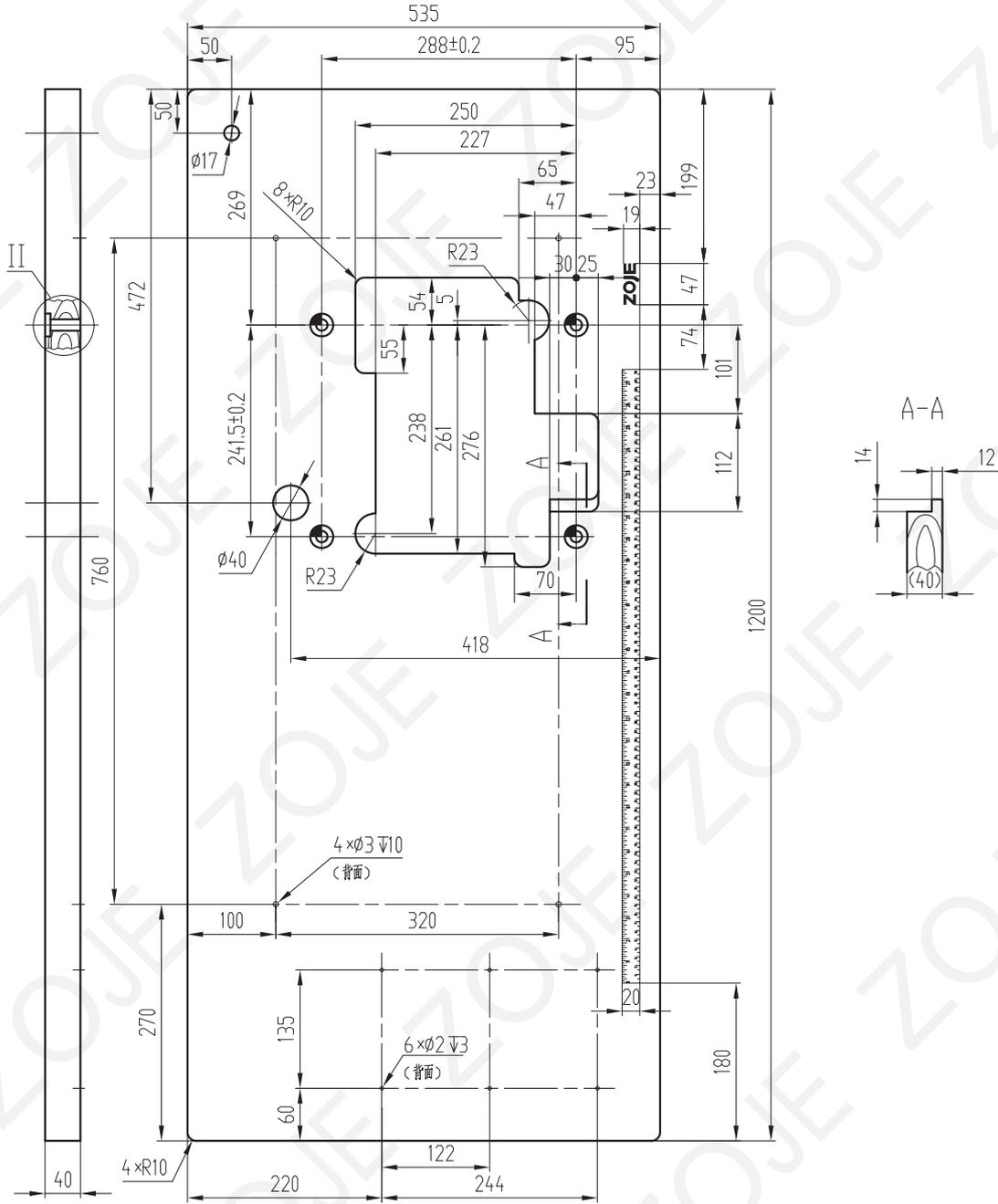
- Turn the power off before leaving the machine table.
- In the event of a power failure,be sure to turn the machine off.
- Check that the machine is securely grounded.

台板加工图

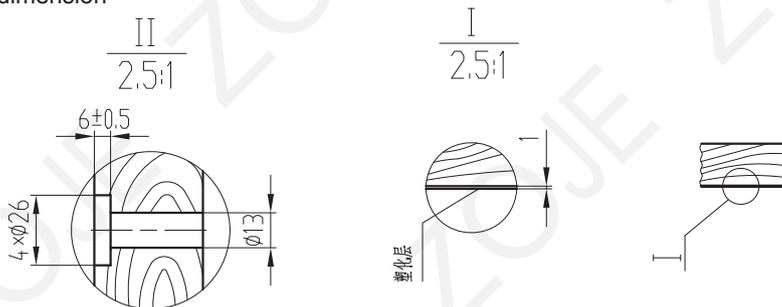
Schematic diagram of the machine table

请参照下图进行台板的加工

Cut the table referring to the diagram



标准尺寸
Standard dimension

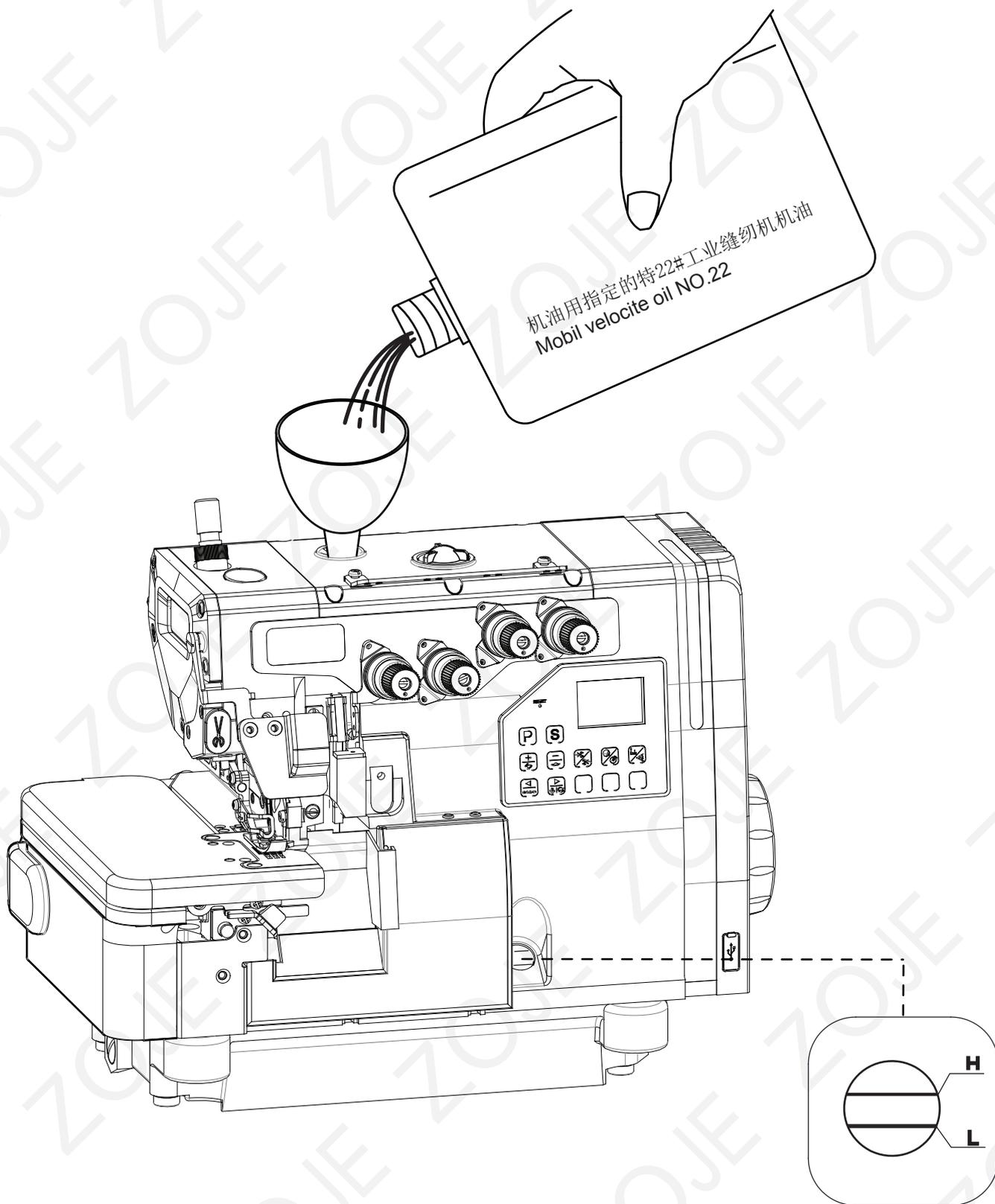


加润滑油 Lubrication

加油量是使油面处于H线与L线之间为好。
当油量低于L线时，就要及时补充机油。

After filling the oil , the top of the indicator
should lie between (H)and(L) lines.

Add oil,when the oil level indicator reaches or
goes below(L).



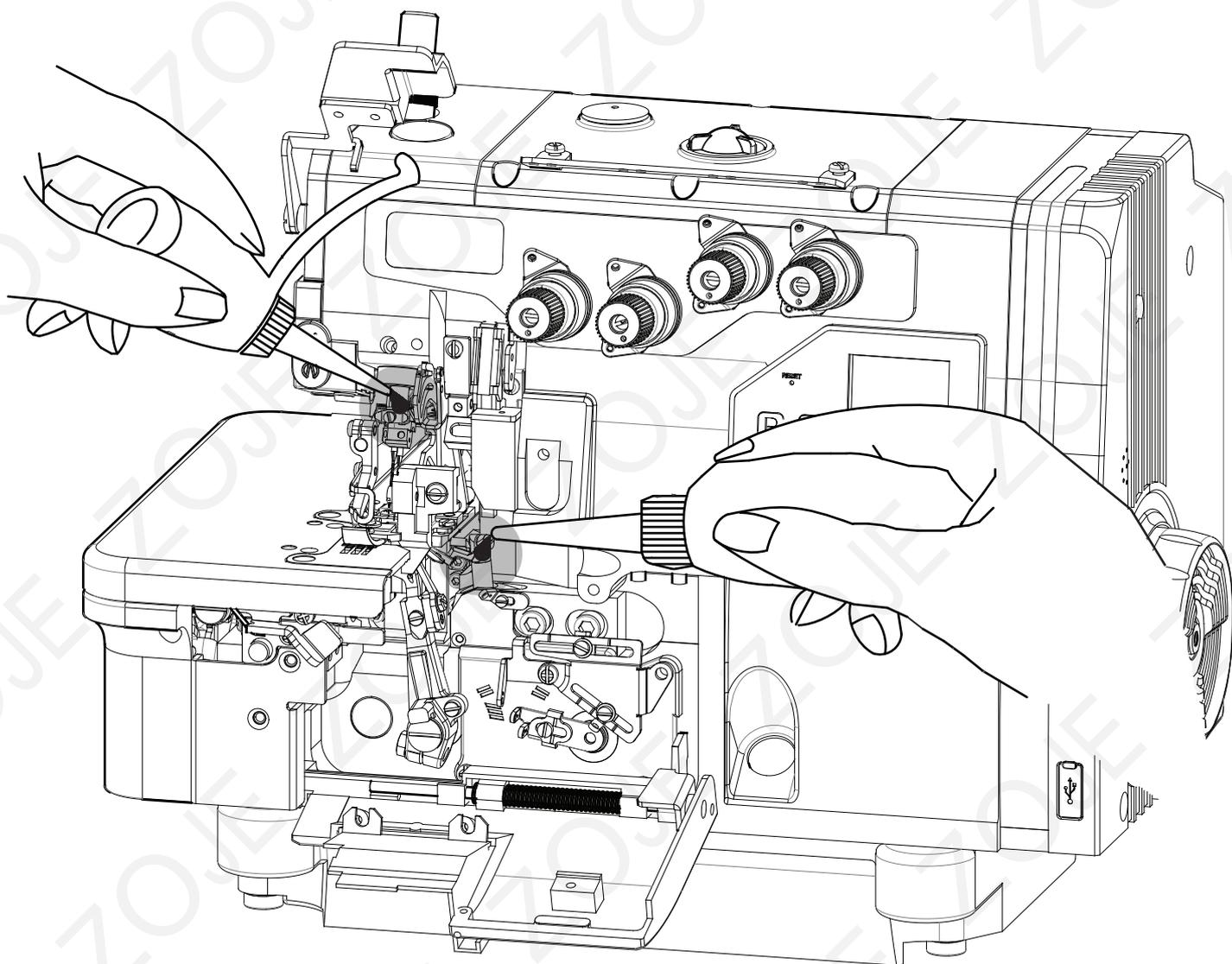
手动给油 Manual Lubrication

手动给油是在缝纫机最初开始使用时。
或相当一段时间没使用了时，请供给
2-3滴油。

Apply 2 or 3 drops of oil by hand when the
machine is used for the first time or has
been left unused for some time.



机油用特22#工业缝纫机油
Mobil velocite oil NO.22

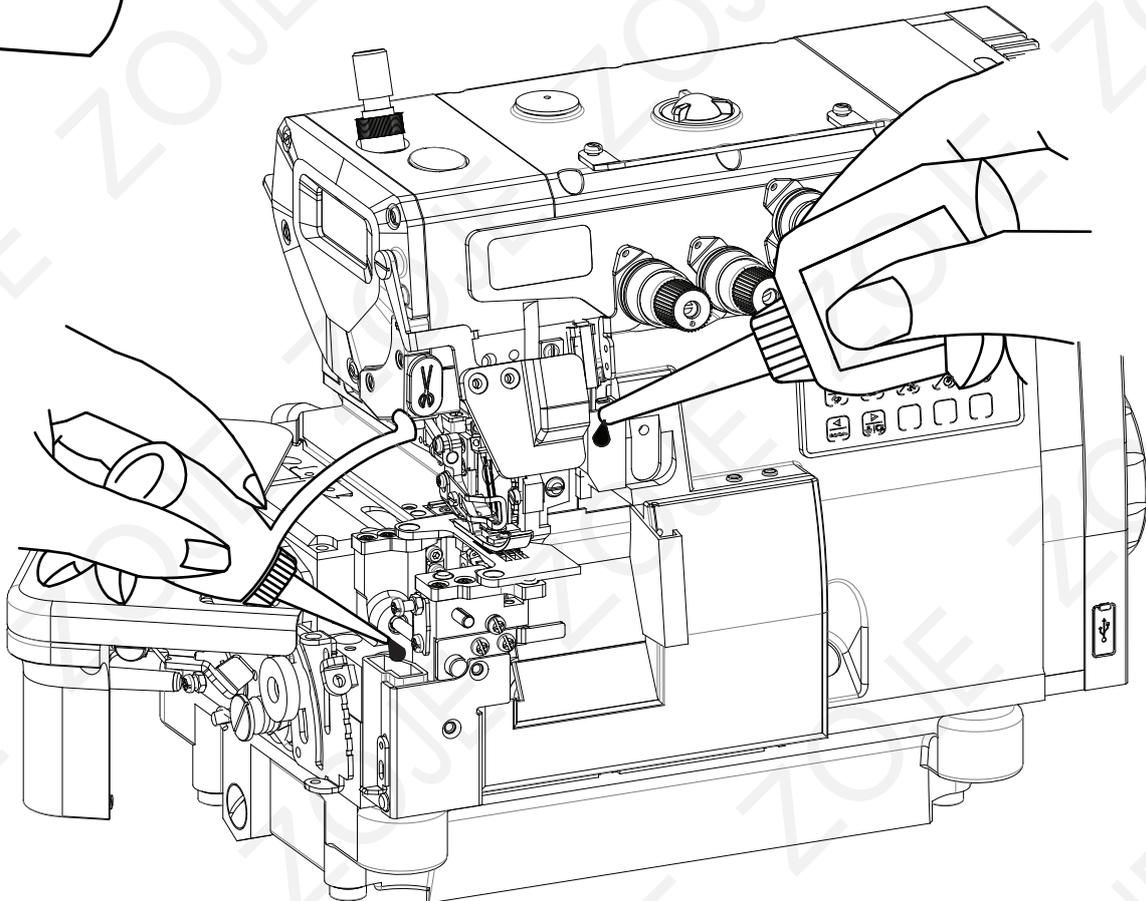


给HR装置供油 Filling the HR device with silicon oil

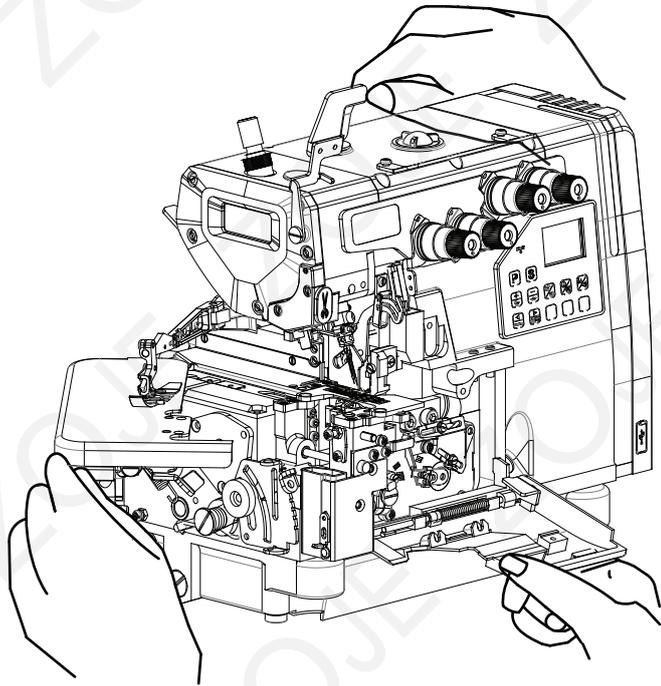
为了防止断线，尽早给HR装置供油。
注：关于购买硅油，请咨询代理店或公司
营业部联系。

Fill the HR device oil before it is too low in order
to prevent needle thread breakage and fabric
damage.

Note: Use Zoje recommended silicon oil.
[UNION CARBIDE CORPORATION]
UCC L-45(10)



穿线的方法 Threading

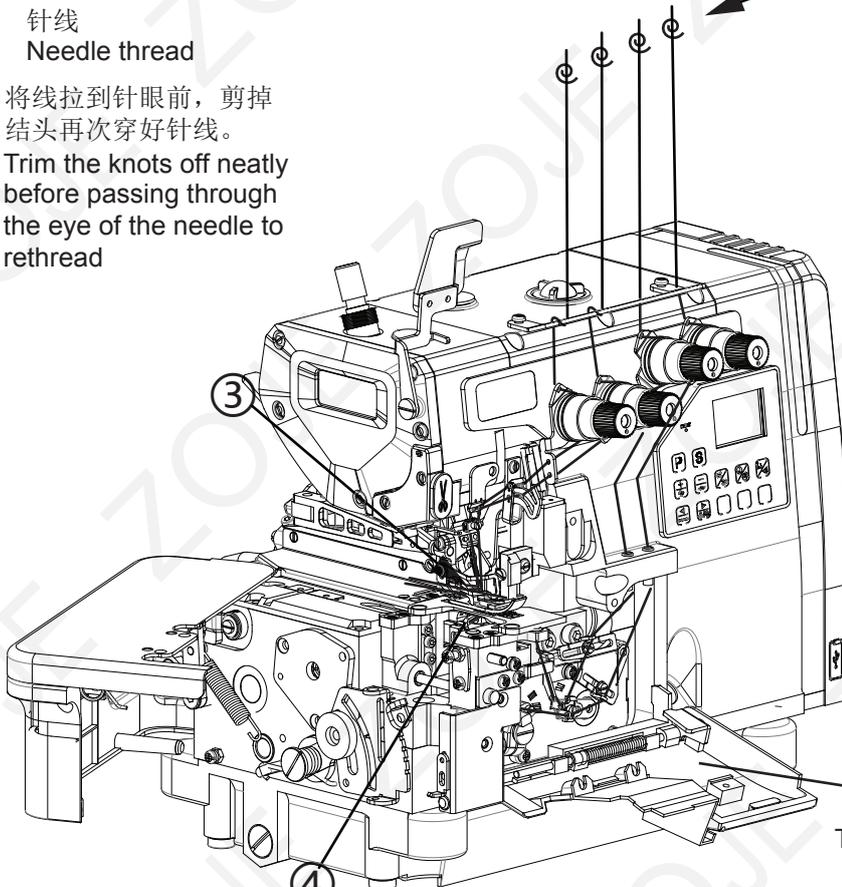


- ① 打开防护罩、大盖及前盖，再移开压脚
Open three covers and remove the presser foot aside.

- ② 把机器上原有的线与缝纫用线绑结在一起。
Knot the preset thread and the thread being used together to thread the machine.

针线
Needle thread

将线拉到针眼前，剪掉结头再次穿好针线。
Trim the knots off neatly before passing through the eye of the needle to rethread



若机上原来没有线，请参照穿线图正确进行穿线。

threaded correctly by referring to the threading diagram.

弯针线
Looper thread

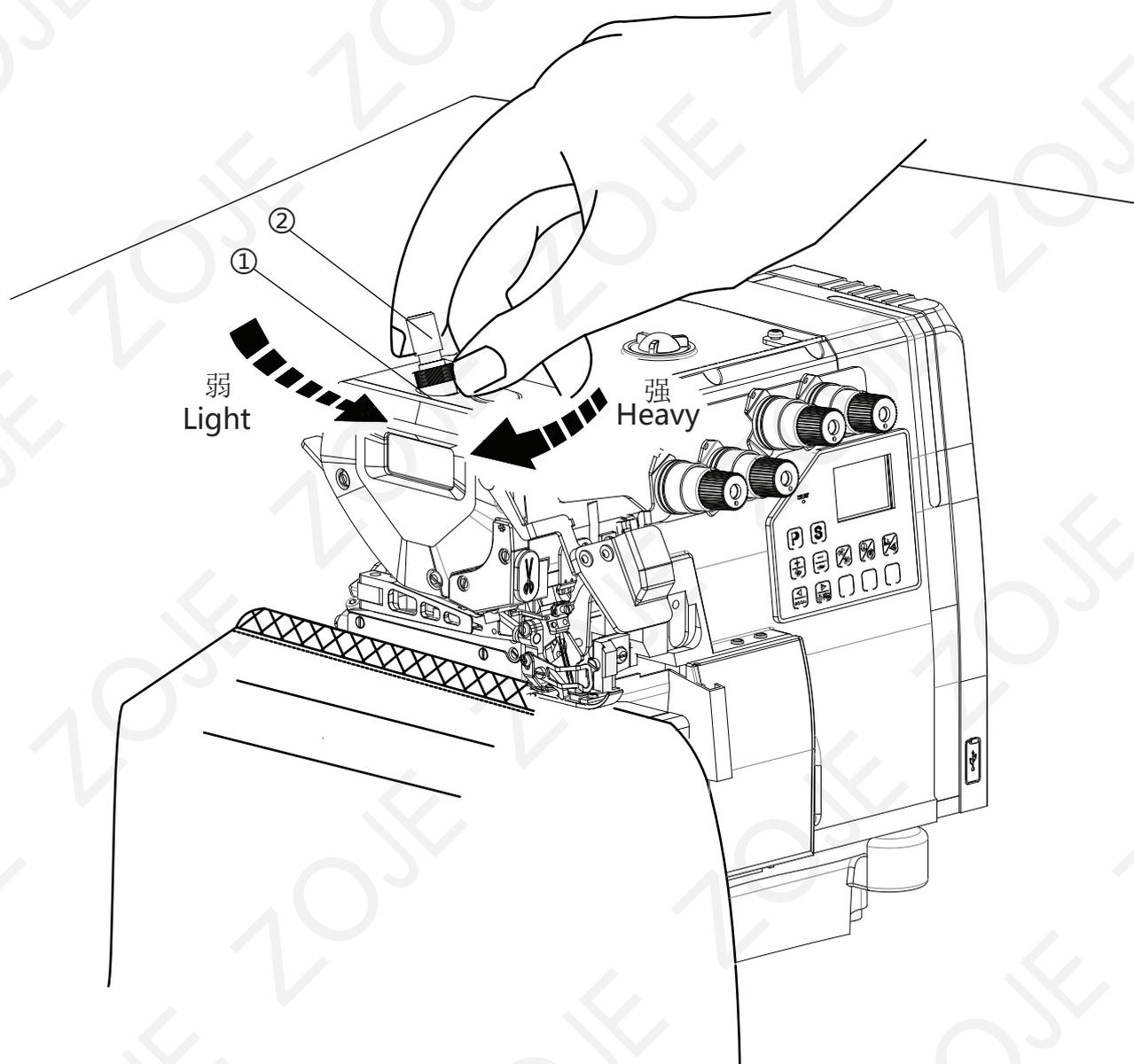
线拉出接头后，用剪刀齐接头。
Trim the knots off neatly after passing through the eye of the looper.

穿线图
Threading diagram

压脚压力的调节 Adjusting the presser foot pressure

压脚压力的调节，松动螺母①，调节螺母②，在送布得到稳定状态下尽可能使用较弱的压力为好。

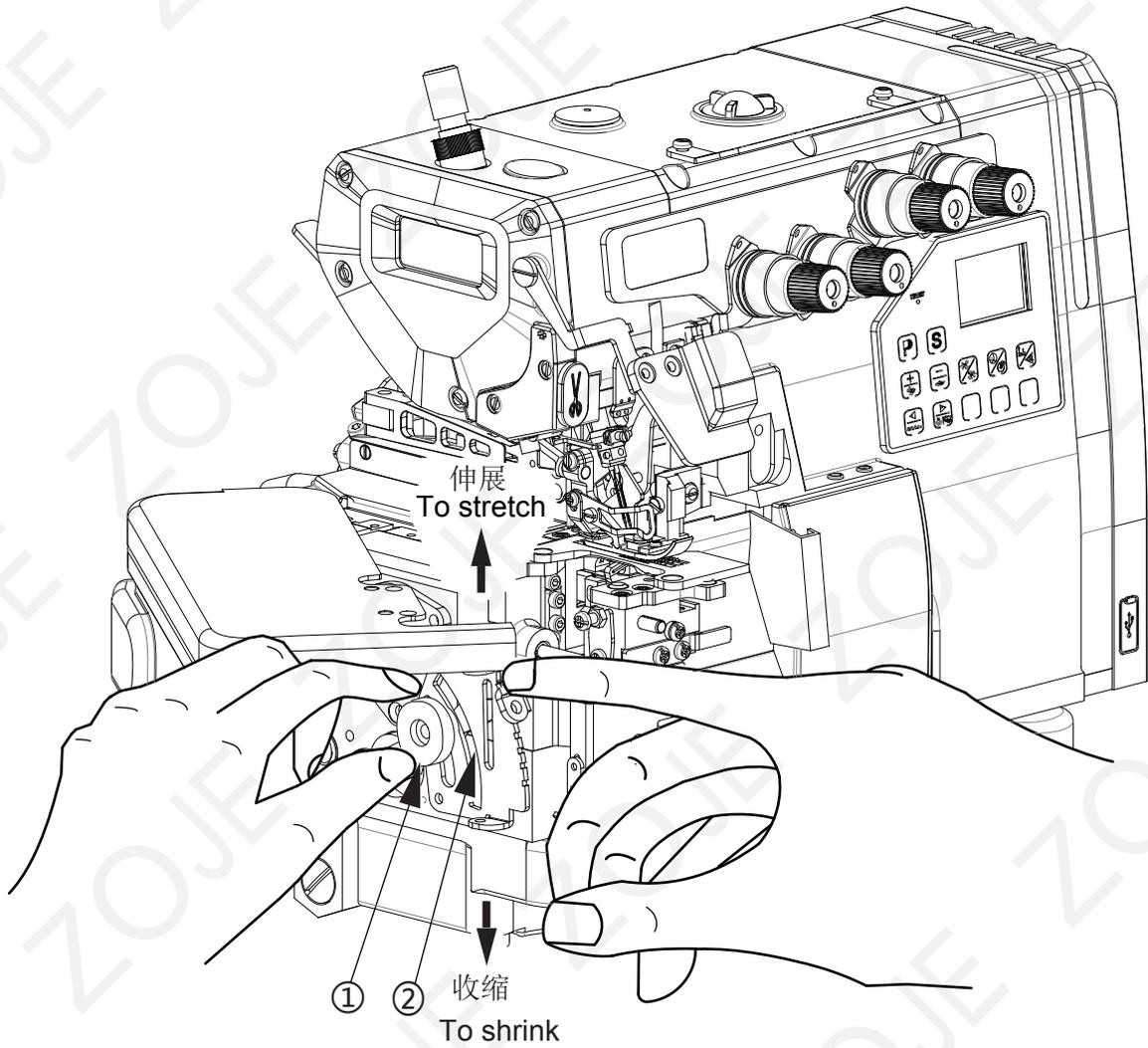
Loosen adjusting nut ① and turn adjusting nut ② to adjust the presser foot pressure. It should be as light as possible. Yet be sufficient to obtain the proper stitch formation.



差动比的调节 Adjusting the diff. feed ratio

差动比的调节
松开螺母①，然后调节差动调节杆②。

Loosen the nut ① and turn the adjusting rod ② to adjust the differential feed ratio .

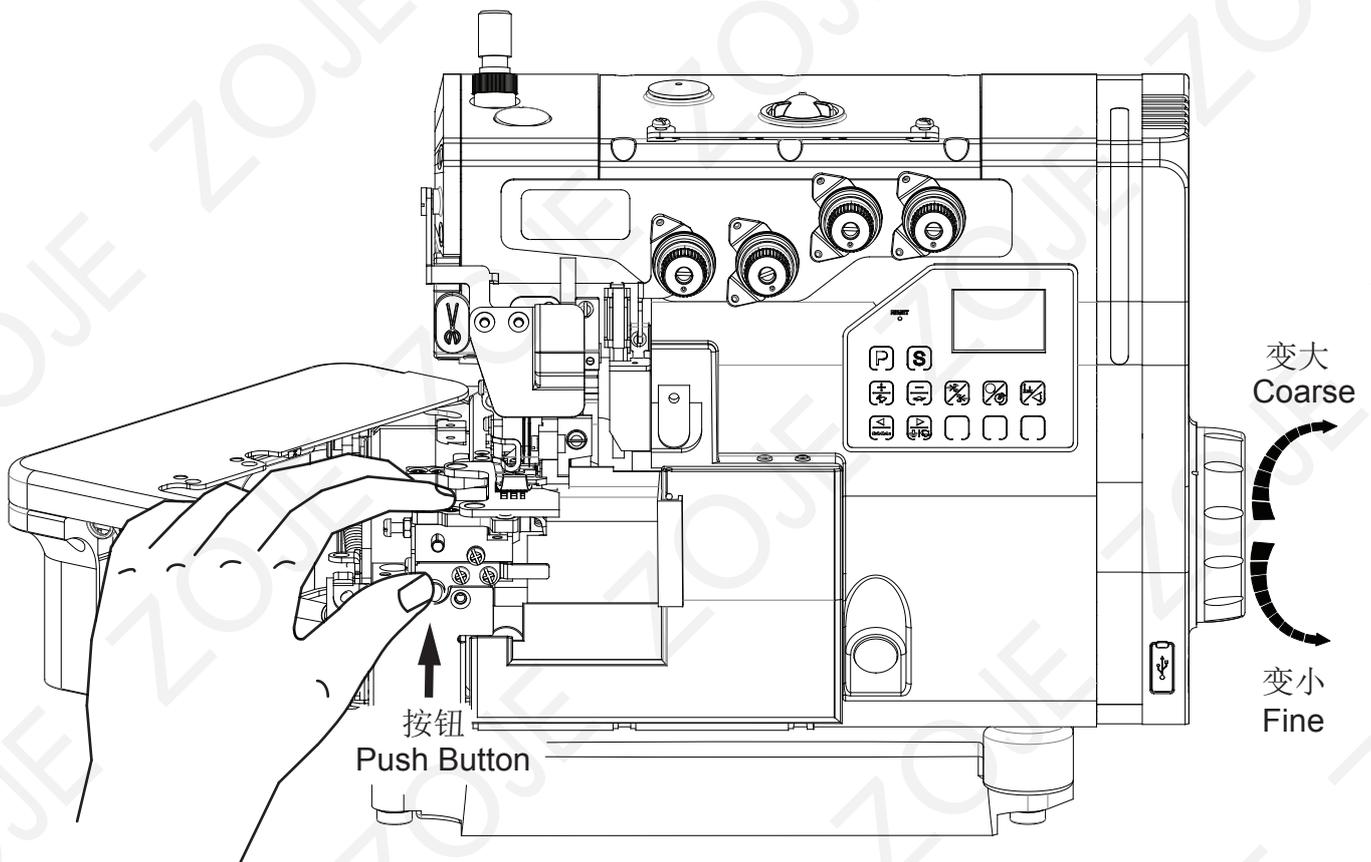


针脚长度的调节 Adjusting the stitch length

1. 摁住按钮，旋转手轮，按钮会陷进更深处。 ① While pressing the push button, turn the handwheel to seek the position at which the push button goes further into the depth.
2. 这时边摁住按钮，边转动手轮，使校准标记号对准所希望的数值。 ② Then, keeping the push button pressed, turn the handwheel and set the desired scale to the aligning mark.

注：针脚长度的调节务必请在调节差动比之后进行。

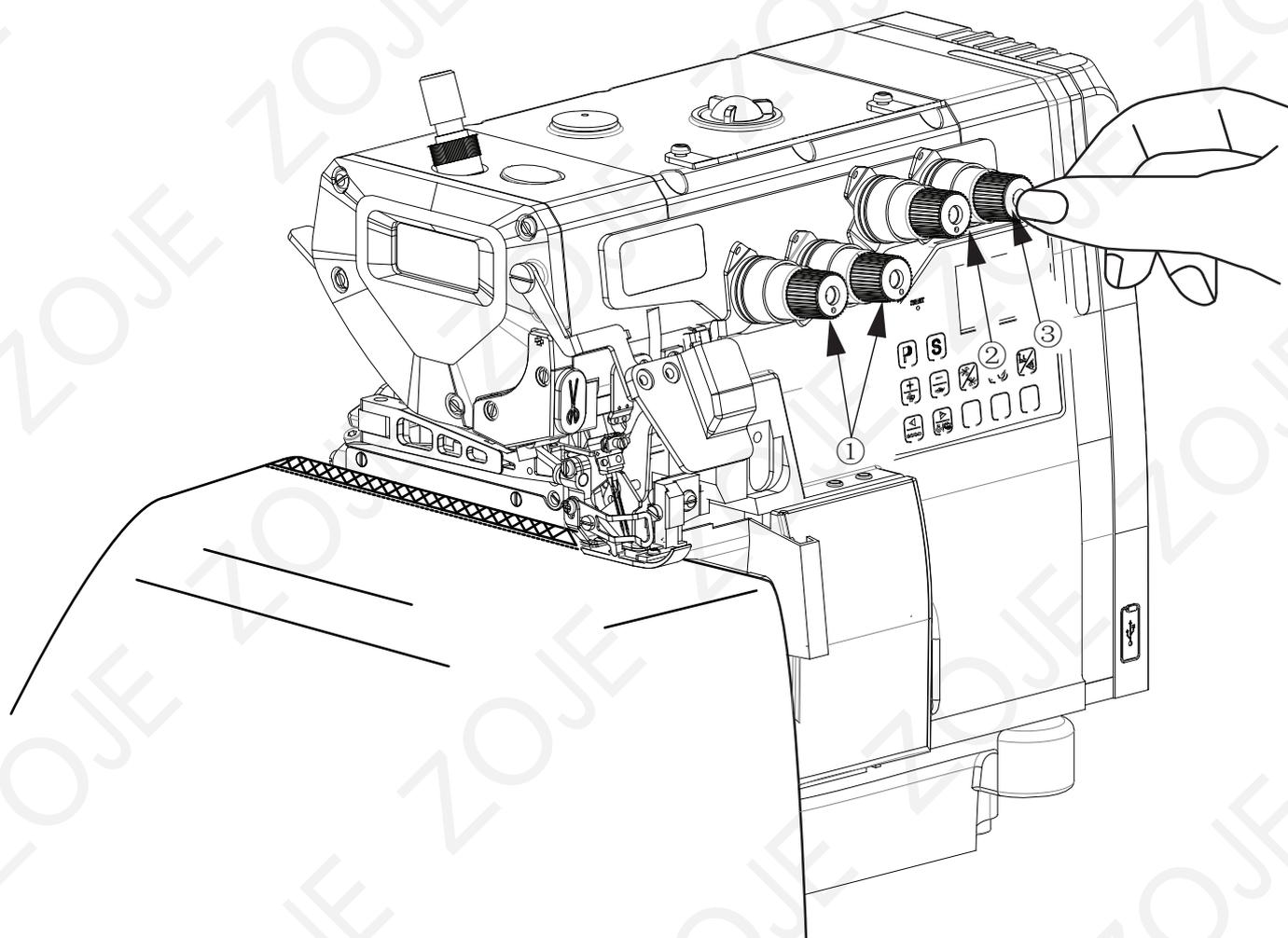
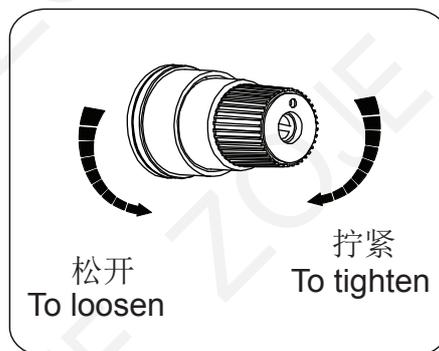
Note: Stitch length adjustment must only be made after the differential feed ratio has been changed.



线张力的调节 Adujsting the thread tension

线张力状态的调节，请用针线调节螺帽①、上弯针线调节螺帽②、弯针线调节螺帽③来进行调节。

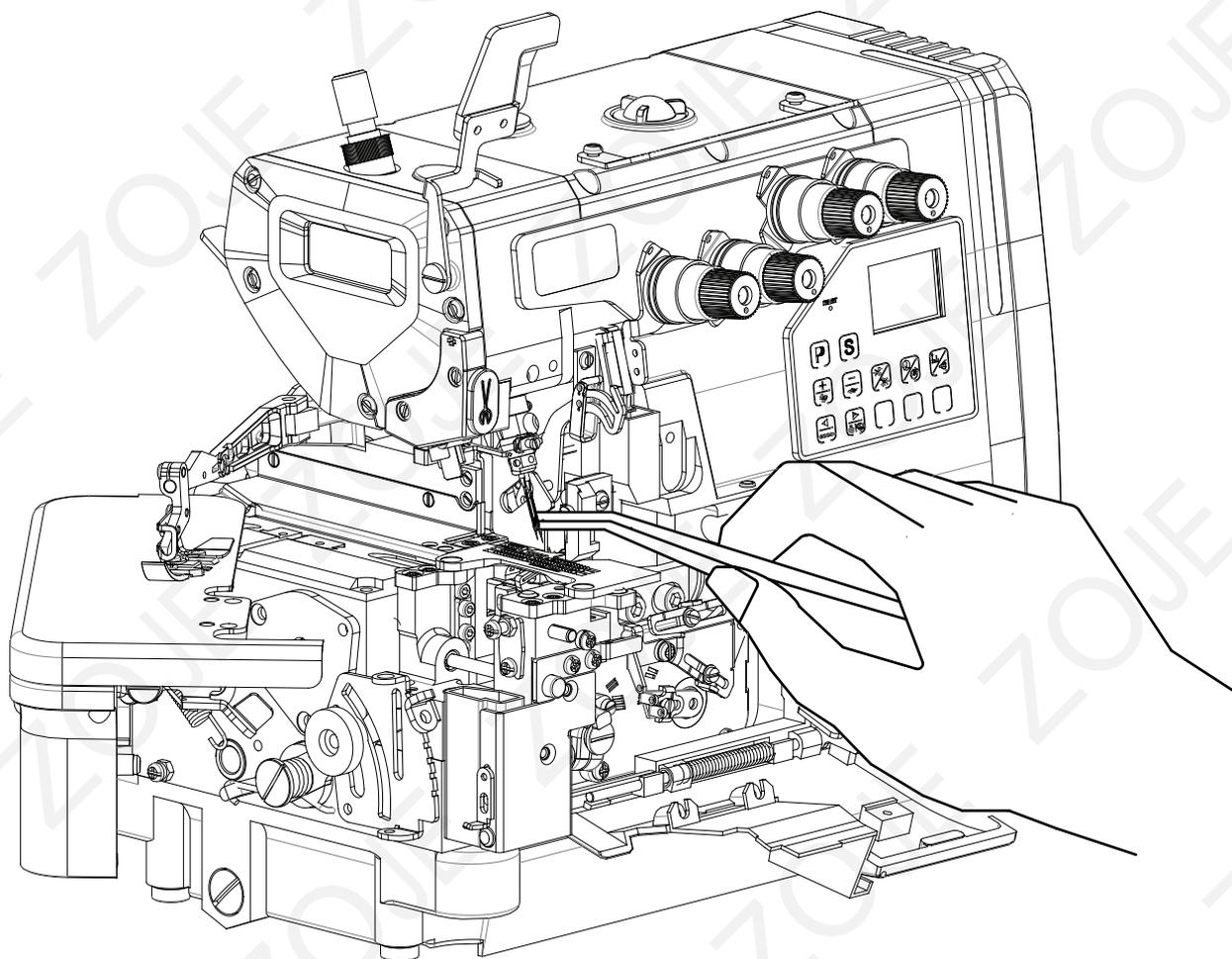
Make tension adjustments with the needle thread knob①、the upper looper knob②、and the lower looper knob③.



清洁缝纫机 Cleaning the machine

缝纫机的清扫，以针板槽及送布牙周围为主。

Mainly the slots of the needle plate and the feed rows should be cleaned



换机针 Replacing the needle

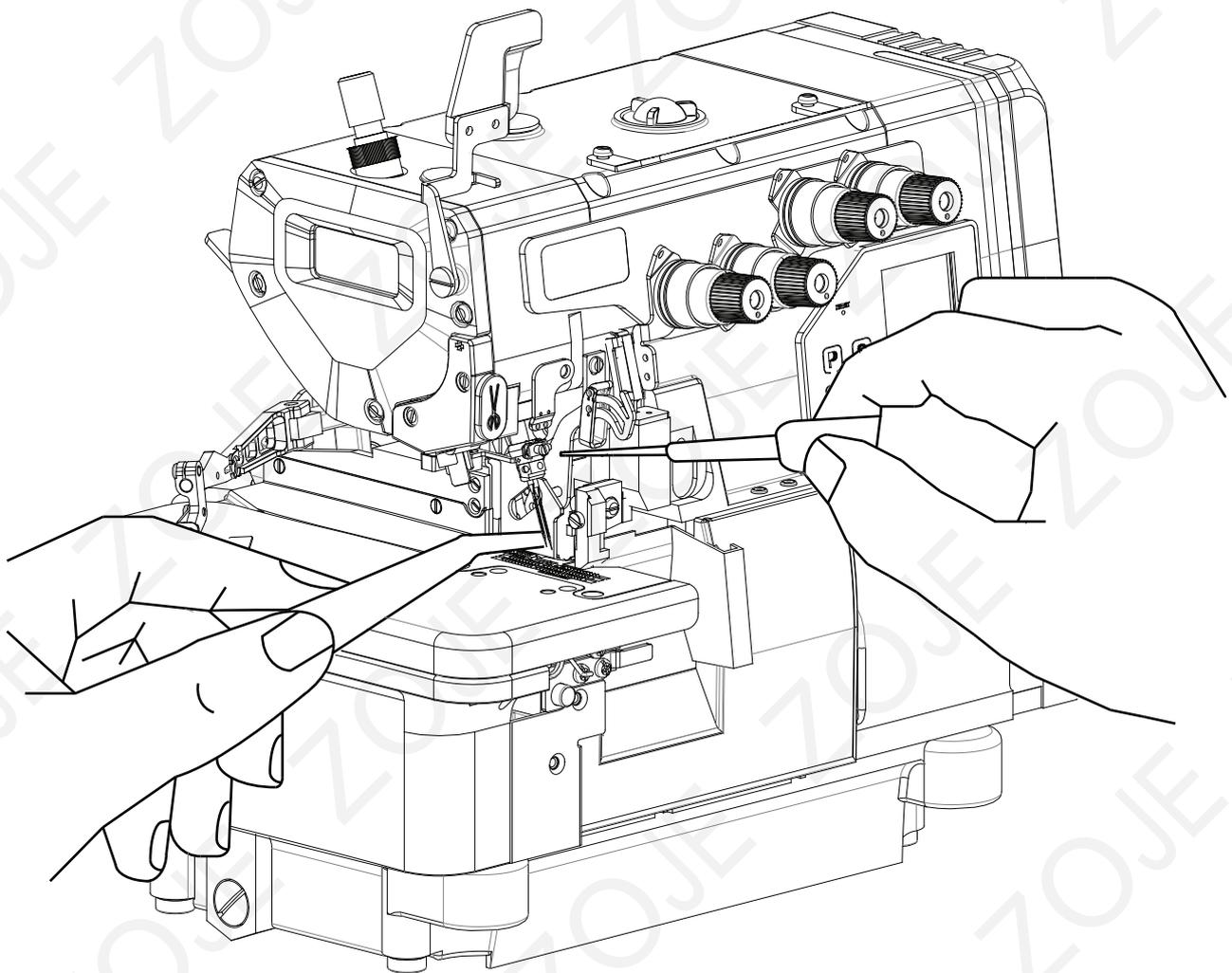
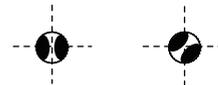
准确辨认针的前后，请将针凹向着后方，
即背向操作者进行安装。
针要牢固的插到孔的最深处。

- * Check the needle carefully to see that the scarf is turded to the rear of the machine.
- * Insert the needle to the proper depth, and fasten securely.

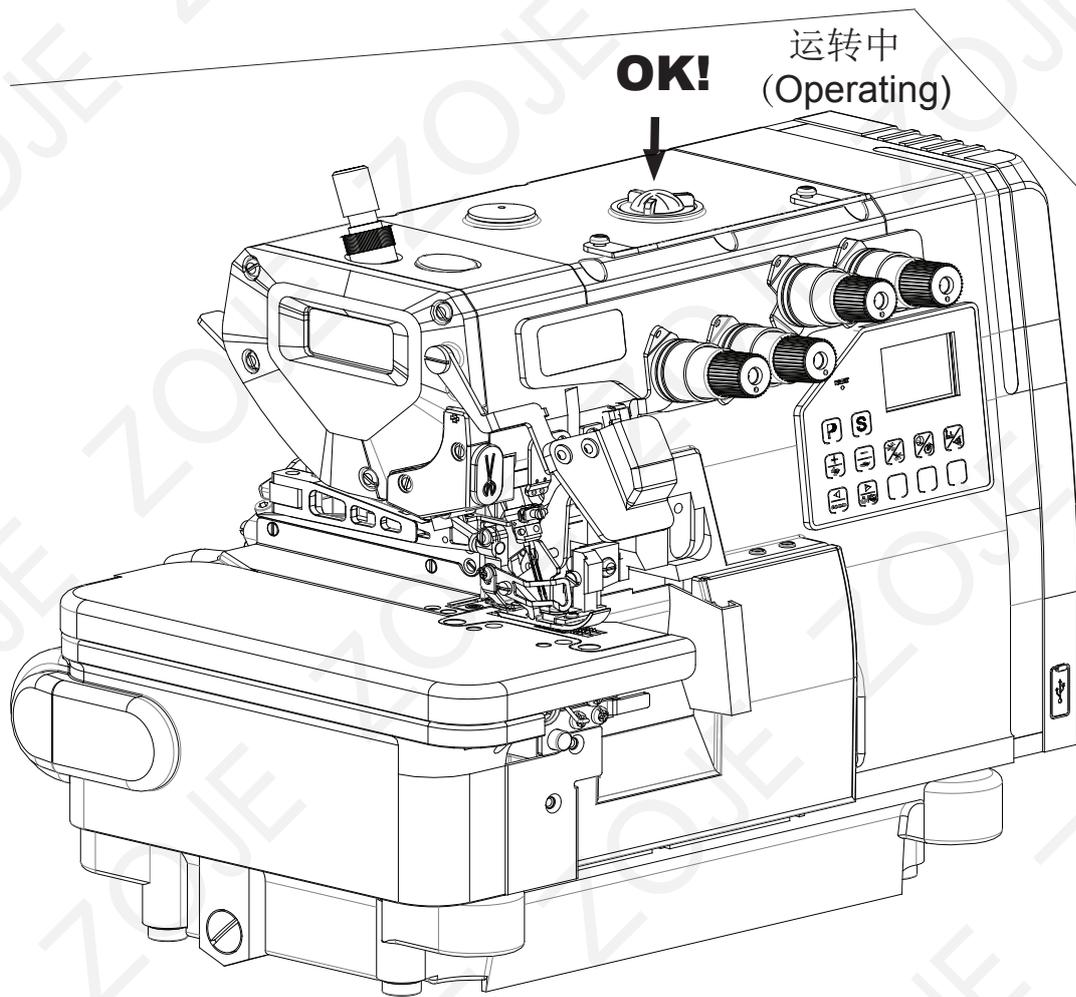
标准使用针：DC×27

Standard needle: DC×27

OK! NO!



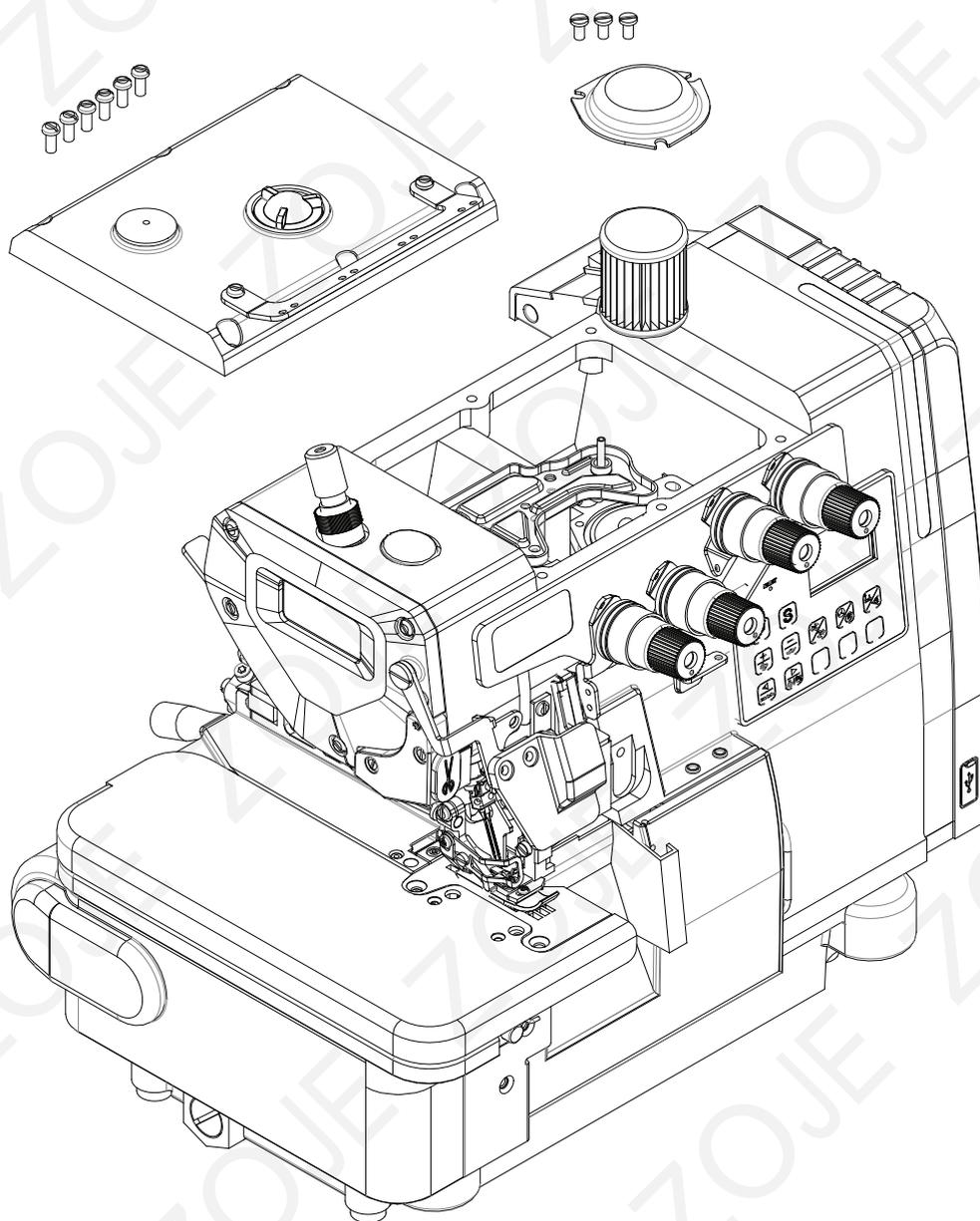
检查机油的循环
Checking the oil circulation



检查和更换滤油器 Checking and replacing the oil filter

滤油器每6个月检查并更换。

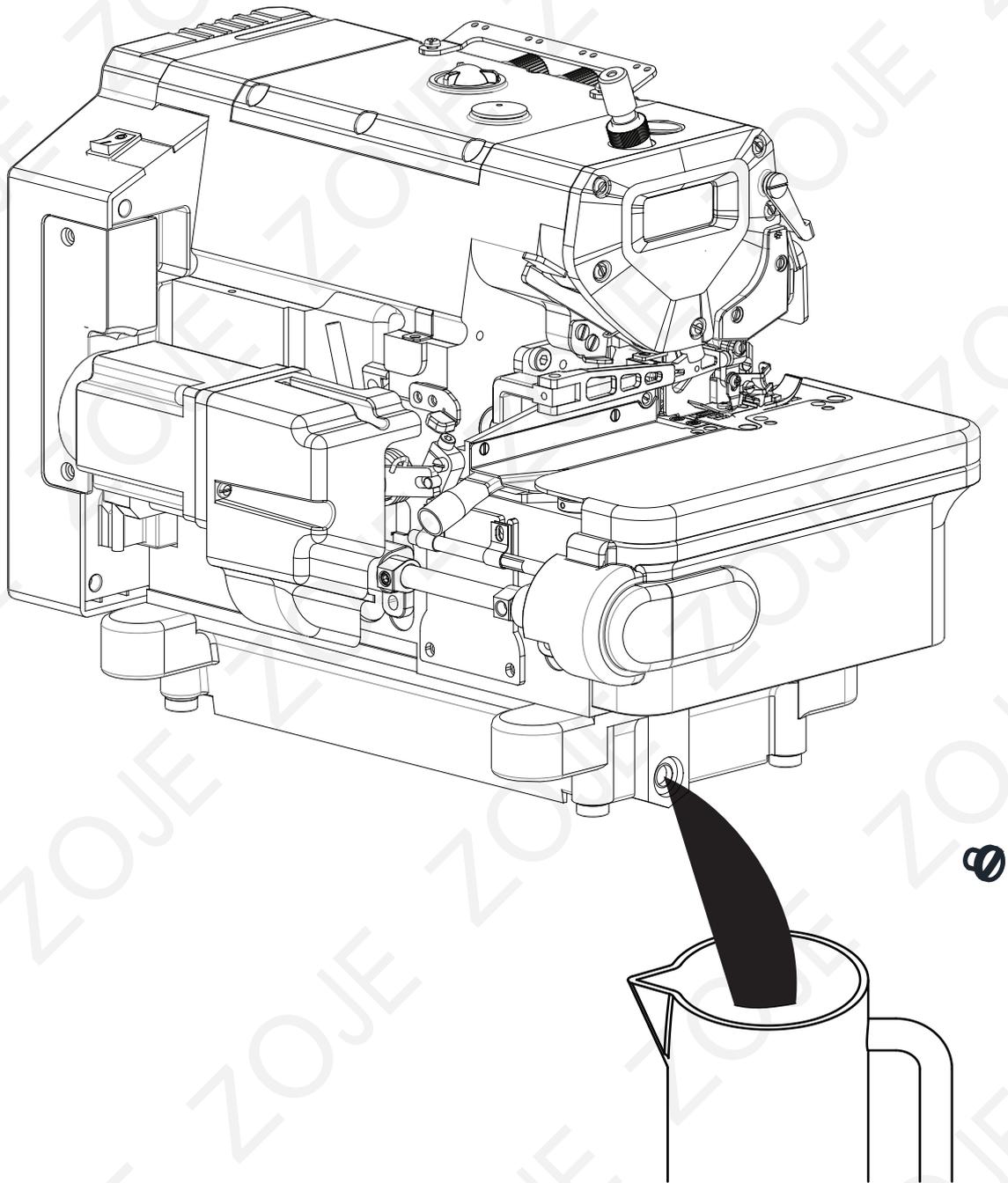
Check and replace the oil filter every six months.



换机油 Replacing the oil

机油的更换，请在使用开始1个月后更换一次。然后，每6个月更换一次。

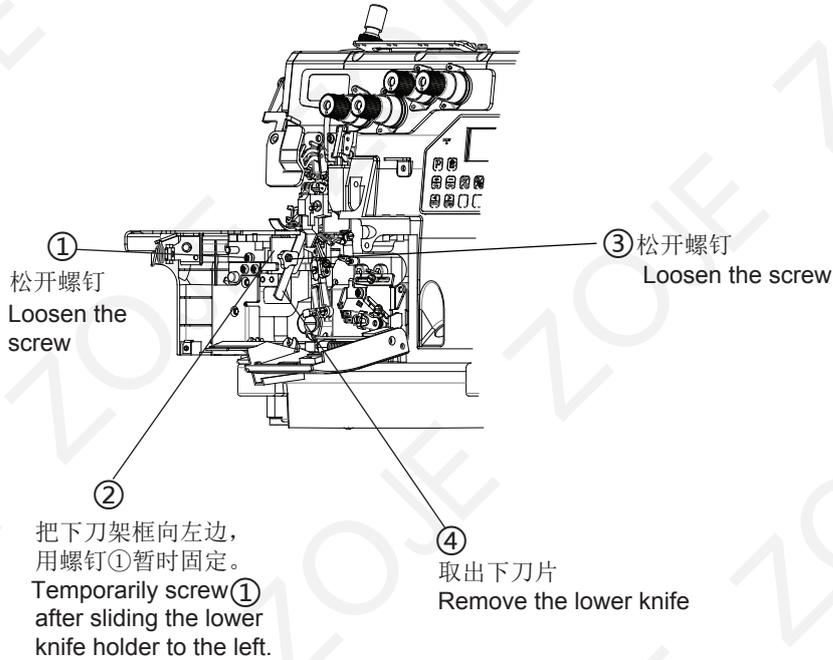
Replacing the oil one month after the first use and every six months thereafter.



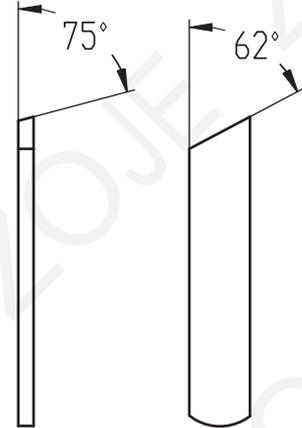
下刀片的更换 Replacing the lower knife

卸下下刀片

To remove the lower knife

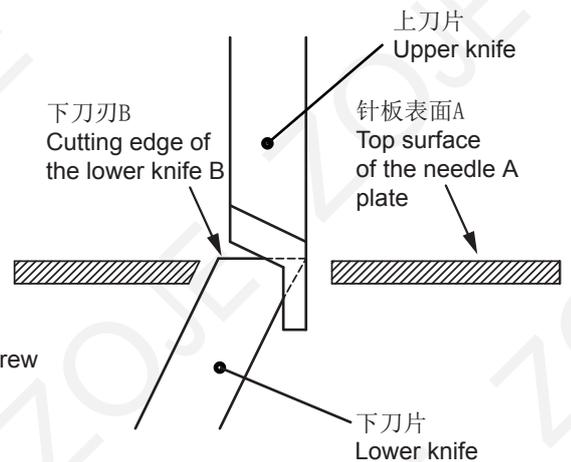
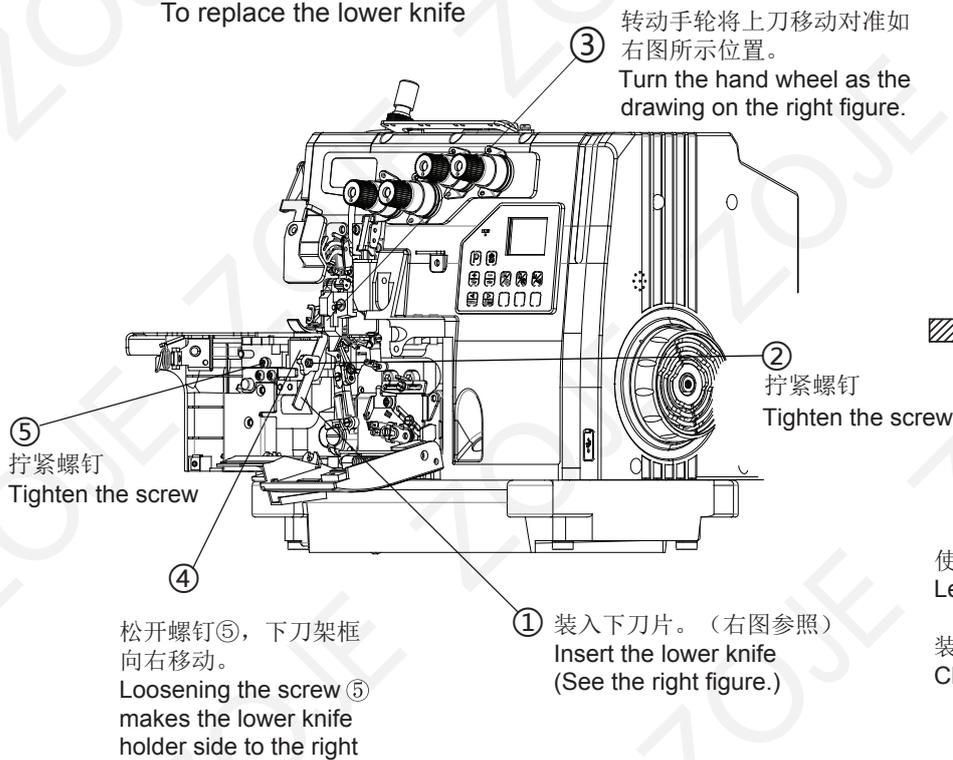


下刀片正确的研磨角度
Correct angles to resharpen the lower knife



安装下刀片

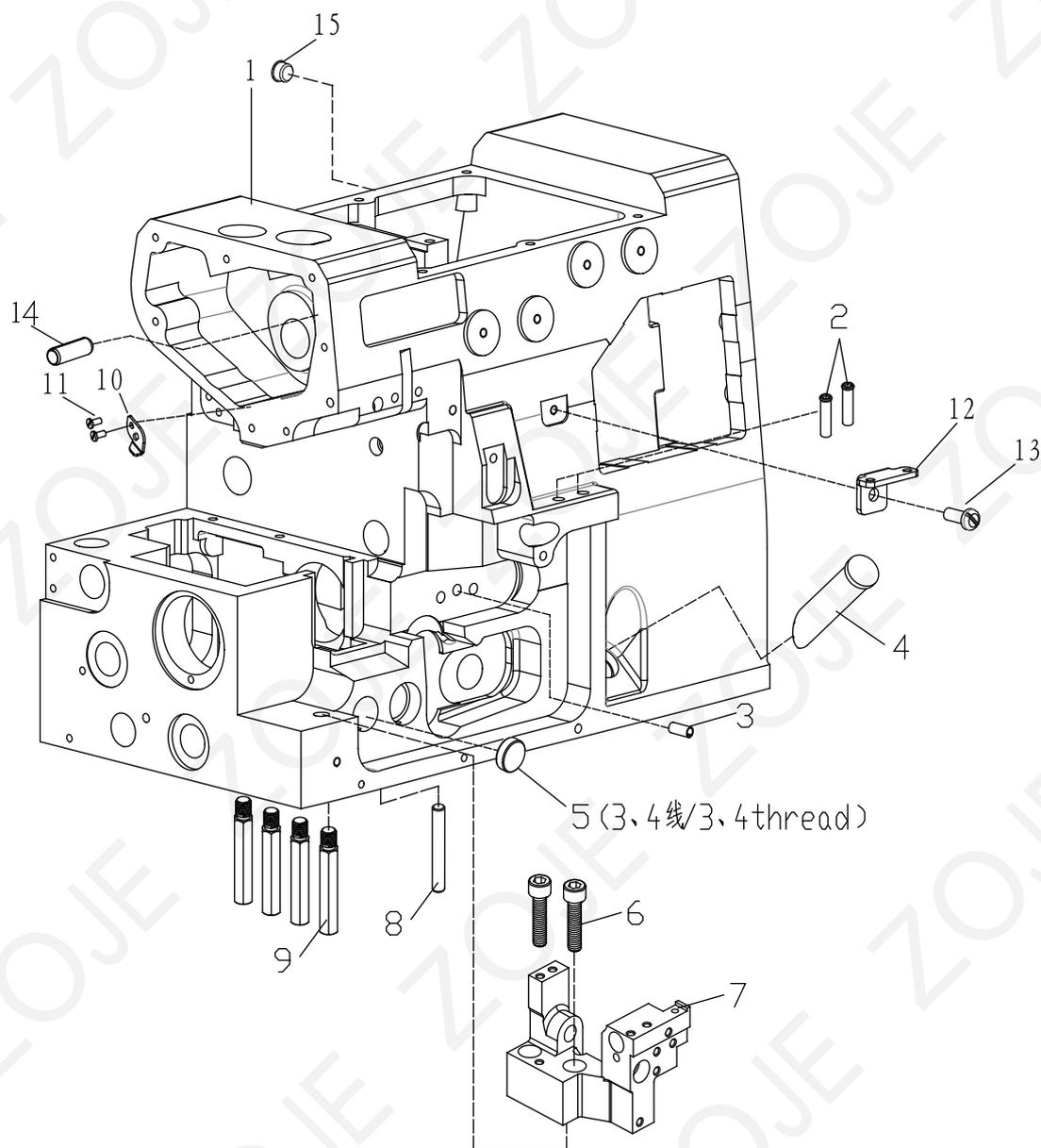
To replace the lower knife



使针板表面A与下刀刃B处于相同水平位置。
Level of [A]=Level of [B]

装好下刀片后进行剪线，确认剪线状况。
Check cutting action of knife.

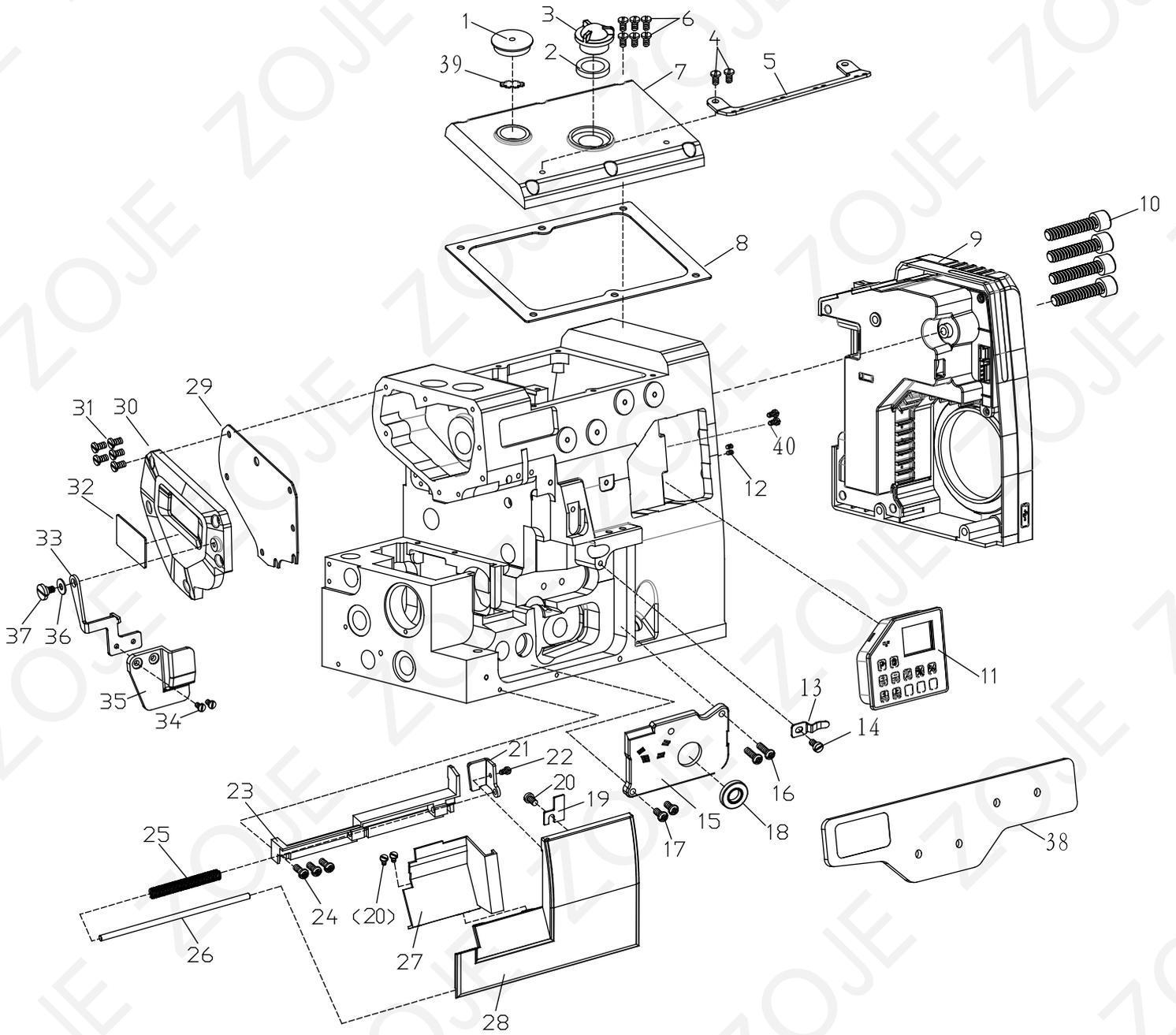
1. 机壳部件/HOUSING FRAME



1. 机壳部件/HOUSING FRAME

序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	20032854	机壳敲套组件	housing	1
2	10054228	上、下弯针穿线管	threading pipe for upper and lower loopers	2
3	10002836	销	pin	1
4	10072224	油窗	oil window	1
5	10008961	橡胶塞	Rubber Plug	1
6	10009171	螺钉M6×25	screw	2
7	10079666	下刀座	lower knife bed	1
8	10002830	销	pin	1
9	10011847	机壳支柱	support for housing	4
10	10074111	压脚限位板	limitation board	1
11	10010594	螺钉M4×7.5	Screw	2
12	10063877	导线板	Wireboard	1
13	10010594	螺钉M4×7.5	Screw	1
14	10002833	销	pin	1
15	10013586	橡胶塞	Rubber Plug	1

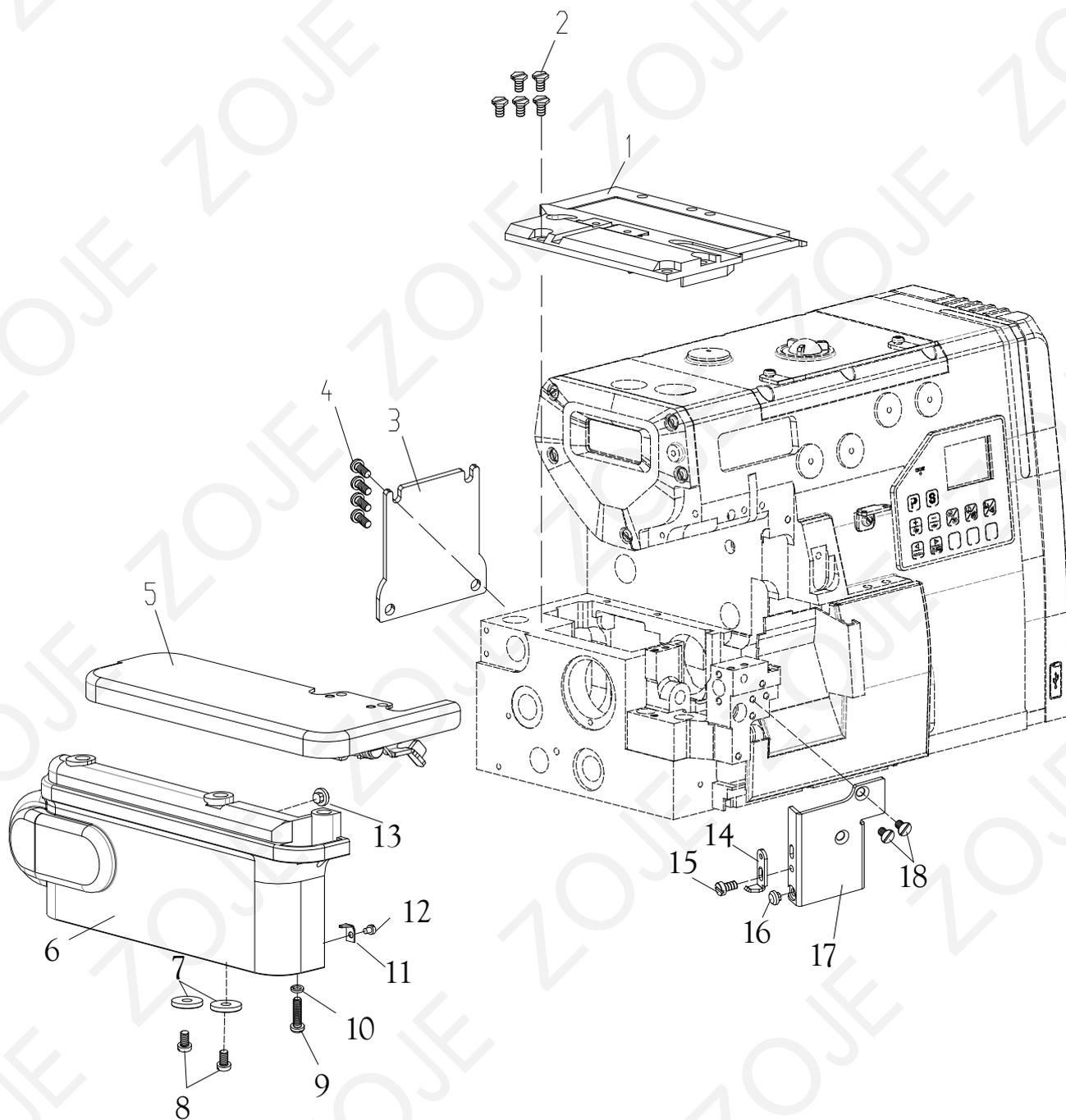
2. 外罩部件(1)/OUT COVER FRAME(1)



2. 外罩部件(1)/OUT COVER FRAME(1)

序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	10039396	橡胶塞	rubber plug	1
2	10008939	油窗橡胶圈	oil window rubber ring	1
3	10008938	油窗	oil window	1
4	10010554	螺钉M4×5.5	screw M4×5.5	2
5	10057453	过线架	a wire frame	1
6	10009104	螺钉M4×9.5	screw M4×9.5	6
7	20030667	上盖	upper cover	1
8	10074104	上盖密封垫	seal cushion for upper cover	1
9	*	电控	B8510 Step electric control	1
10	10062719	螺钉M5×45	screw M5×45	4
11	*	操作盒	operation box	1
12	10009042	螺钉M4-6h×8	screw M4-6h×8	2
13	10033682	弹簧板	spring plate	1
14	10004171	螺钉M4×4.5	screw M4×4.5	1
15	10008917	上弯针架盖	cover for upper looper stand	1
16	10008965	螺钉M4×13.5	screw M4×13.5	2
17	10011044	螺钉M4×10	screw M4×10	2
18	10009399	油封	grease seal	1
19	10059247	前盖右挡板	fender for right part of front cover	1
20	10010554	螺钉M4×5.5	screw M4×5.5	3
21	10079039	导向板	guiding plate	1
22	10063870	螺钉	screw	1
23	10072222	支架	supporting part	1
24	10009037	螺钉M4×12	screw M4×12	3
25	10009509	弹簧	spring	1
26	10062485	销	pin	1
27	10072225	前盖中	midle part of the front cover	1
28	20028601	前盖右	right part of the front cover	1
29	10078873	侧盖密封垫	side gasket	1
30	20030668	侧盖	side cover	1
31	10010595	螺钉M4×7.5	screw M4×7.5	5
32	10074110	面板装饰牌	decorative plate	1
33	10072494	护板支架	support plate	1
34	10009600	螺钉M3×6	screw M3×6	2
35	10008878	安全罩	safety cover	1
36	10010596	垫圈	washer	1
37	10068488	螺钉	screw	1
38	*	Logo灯组件	independent logo lamo cover	1
39	10039397	挡油架	Oil barrier	1
40	10010594	螺钉M4×7.5	Screw M4×7.5	2

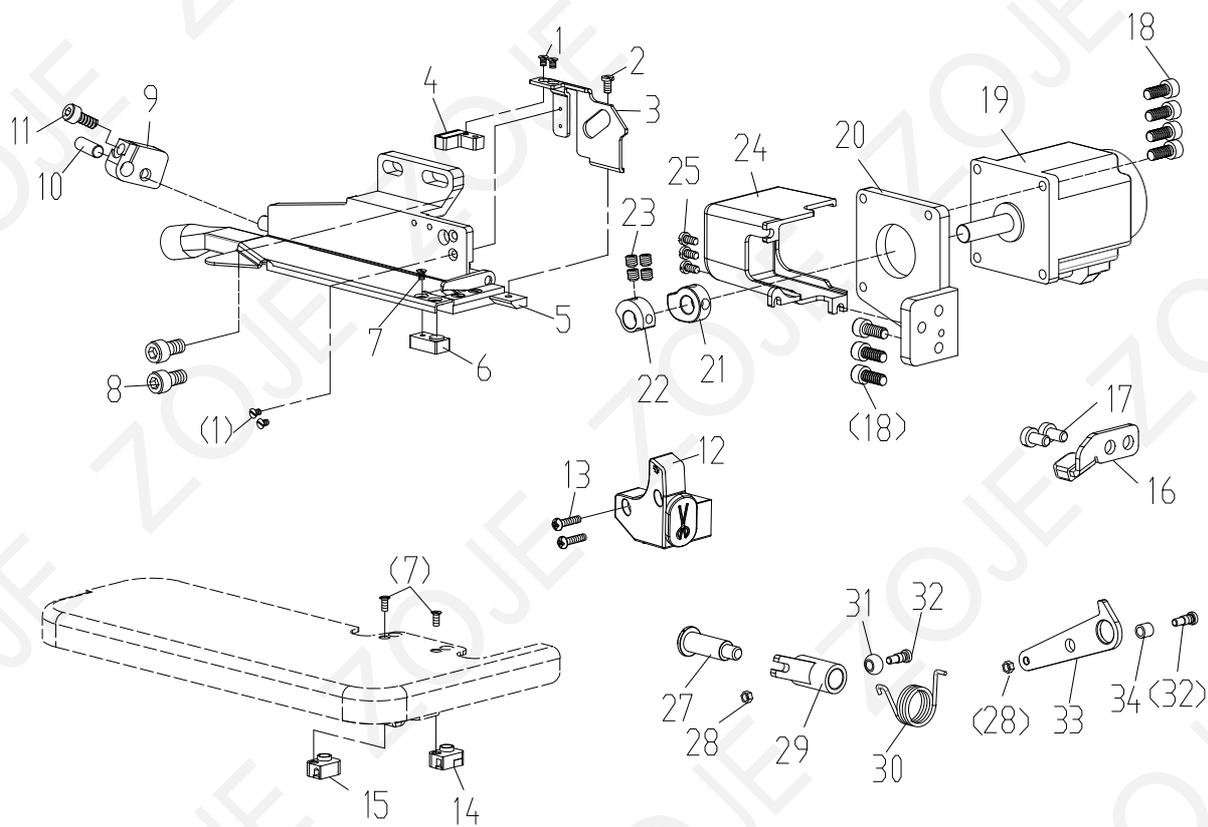
3. 外罩部件(2)/OUT COVER FRAME(2)



3. 外罩部件(2)/OUT COVER FRAME(2)

序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	10058546	左上盖	left upper cover	1
2	10009157	螺钉M4×7.5	screw M4×7.5	5
3	10033690	后盖板组件	comp on ent of back cover	1
4	10009104	螺钉M4×9.5	screw M4×9.5	4
5	10008967	大盖大组件	component of surface cover	1
6	10085075	横盖组件	lower left side cover	1
7	10009537	垫圈	washer	2
8	10010595	螺钉M4×7.5	screw M4×7.5	2
9	10009291	螺钉M4×19.5	screw M4×19.5	1
10	10008144	垫圈	washer	1
11	10033700	横盖限位板	position limiting plate	1
12	10009529	螺钉M3×3.8	screw M3×3.8	1
13	10037505	防震橡胶垫	rubber pad	1
14	10033689	挡板	baffle	1
15	10009514	螺钉M3.5×4.2	screw M3.5×4.2	1
16	10037505	防震橡胶垫	quake-proof rubber cushion	1
17	10008882	前盖左	left part of front cover	1
18	10009049	螺钉M4×5	screw M4×5	2

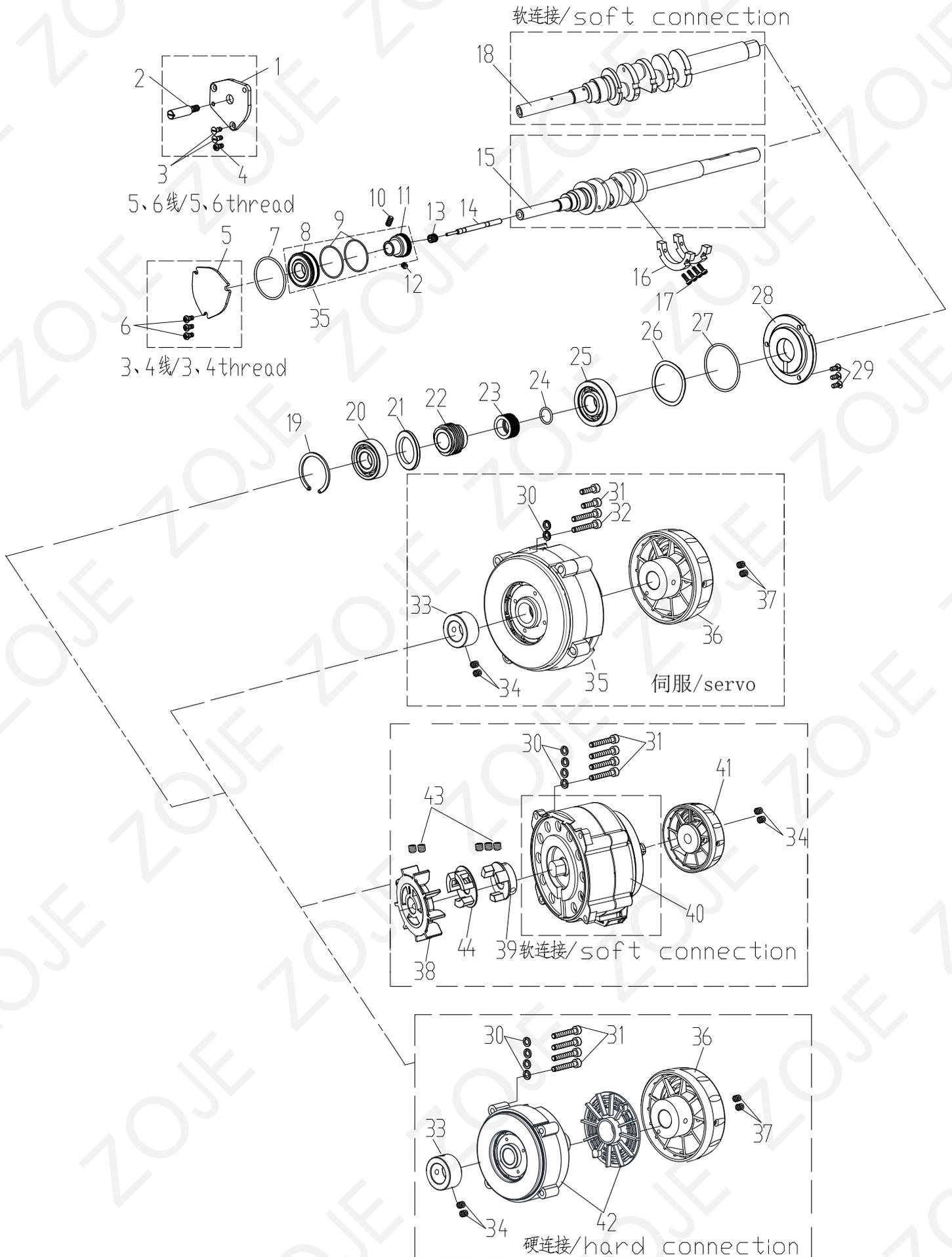
4. 三自动部件/THREE AUTOMATIC FRAME



4. 三自动部件/THREE AUTOMATIC FRAME

序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	10009379	螺钉M2.5×4.8	screw M2.5×4.8	4
2	10038921	螺钉M3×4.5	screw M3×4.5	1
3	10081697	压脚安全开关固定板	guiding plate for safety switch presser foot	1
4	10078965	压脚安全开关组件	safety switch component of the presser foot	1
5	10080834	切刀组件	knife assembly	1
6	10080836	后切接收传感器组件	sensor component of receivering the back cut	1
7	10070997	螺钉M3×5	screw M3×5	3
8	10003169	螺钉M6×12	screw M6×12	2
9	10081623	切刀连杆	connecting rod of cutter	1
10	10081964	销	pin	1
11	10012752	螺钉M4×10	screw M4×10	1
12	10078967	发射传感器组件	sensor component for emitter	1
13	10011044	螺钉M4×10	screw M4×10	2
14	10078968	前切接收传感器组件	sensor as-receive	1
15	10078970	抬压脚接收传感器组件	sensor as-receive	1
16	10082124	限位板组件	The limit board	1
17	10010595	M4×7.5螺钉	Screw	2
18	10065628	螺钉M5×16	screw M5×16	7
19	10068703	包缝步进电机	sewing stepper mptor	1
20	10068704	电机座	motor base	1
21	10068705	抬压脚凸轮	presser foot lifting cam	1
22	10068706	剪线凸轮	thread trimming acm	1
23	10011232	螺钉M6×6	screw M6×6	4
24	10069255	后罩壳	rear housing	1
25	10010594	螺钉M4×7.5	screw M4×7.5	3
27	10068711	轴位螺钉	Shoulder Screw	1
28	10010106	SM11/64"×40螺母	Nut	2
29	10068710	剪线曲柄	The trimming crank	1
30	10068709	剪线复位扭簧	The trimming and homing torsion spring	1
31	10068708	球销套	The ball pin sets	1
32	10014342	销	pin	2
33	10068707	抬压脚连杆	The lifting presser foot connecting rod	1
34	10034929	销套	Pin bush	1

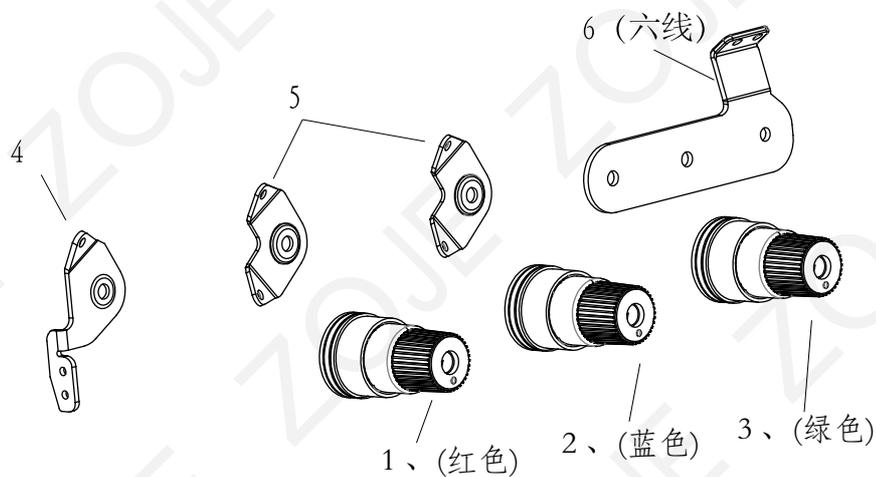
5. 主轴机构/MAIN SHAFT MECHANISM



5. 主轴机构/MAIN SHAFT MECHANISM

序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	10009643	左盖	left cover	1
2	10007842	螺钉M6×12.2	screw M6×12.2	1
3	10009195	螺钉M4×7.8	screw M4×7.8	2
4	10009104	螺钉M4×9.5	screw M4×9.5	1
5	10009519	左盖	left cover	1
6	10010595	螺钉M4×7.5	screw M4×7.5	3
7	10009448	O型圈	O ring	1
8	10025895	6202N2-RZ_BOM 轴承	bearing	1
9	10009334	O型圈	O ring	2
10	10012162	螺钉M5×5	screw M5×5	1
11	10002966	轴承套	bush mounted in bearing	1
12	10009167	螺钉M5×10	screw M5×10	1
13	10009187	螺钉M6×8	screw M6×8	1
14	10009479	主轴轴芯	the spindle axis core	1
15	10070268	主轴	connection spindle	1
16	10009402	平衡块	balance block	2
17	10003001	螺钉M3×10	screw M3×10	4
18	10071830	软连接主轴	soft connection spindle	1
19	10008898	主轴卡圈	main shaft retainer ring	1
20	10003543	6203V轴承	bearing	1
21	10078540	蜗杆垫圈	worm washer	1
22	10009362	蜗杆	worm bush	1
23	10071834	螺纹套	bush mounted in screw	1
24	10009360	O型圈	O ring	1
25	10055926	6303V轴承	bearing	1
26	10055918	右盖垫片	spring washer	1
27	10055919	O型圈	O ring	1
28	10055920	右盖	right cover	1
29	10009195	螺钉M4×7.8	screw M4×7.8	3
30	10005537	垫圈	washer	2
31	10053435	螺钉M5×25	screw	2
32	10007637	螺钉M5×40	screw	2
33	10078910	主轴隔套	Spindle spacer sleeve	1
34	10012162	螺钉M5×5	Screw	2
35	10078875	带编码器电机	Electric machinery	1
36	10079149	硬连接手轮组件	Hard link handwheel assembly	1
37	10003151	螺钉	Screw	2
38	10072596	主轴联轴器	spindle coupling	1
39	10078868	电机联轴器	motor coupling	1
40	10078976	伺服电机组件	servo motor assembly	1
41	10079145	软连接手轮组件	soft connection handwheel assembly	1
42	10078975	大饼电机	motor	1
43	10022863	螺钉	Screw	5
44	10072837	缓冲垫	cushion	1

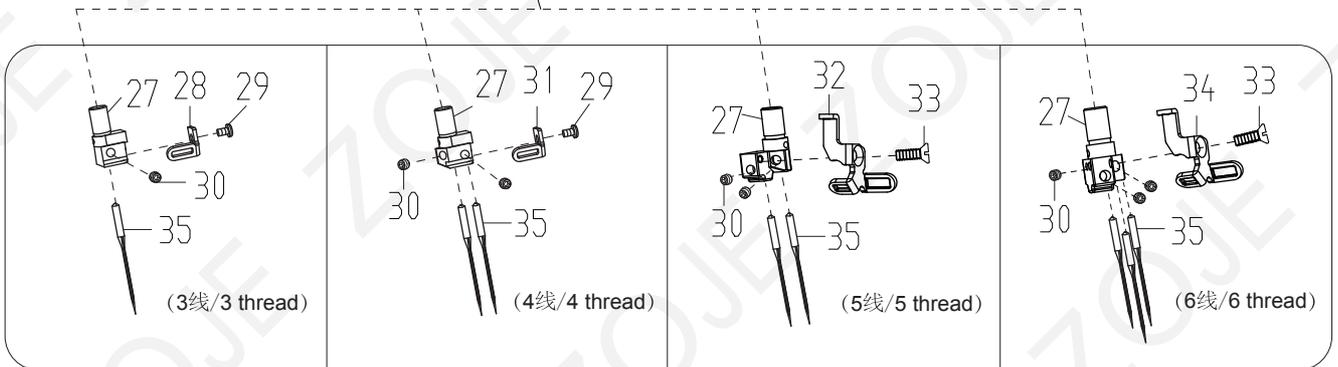
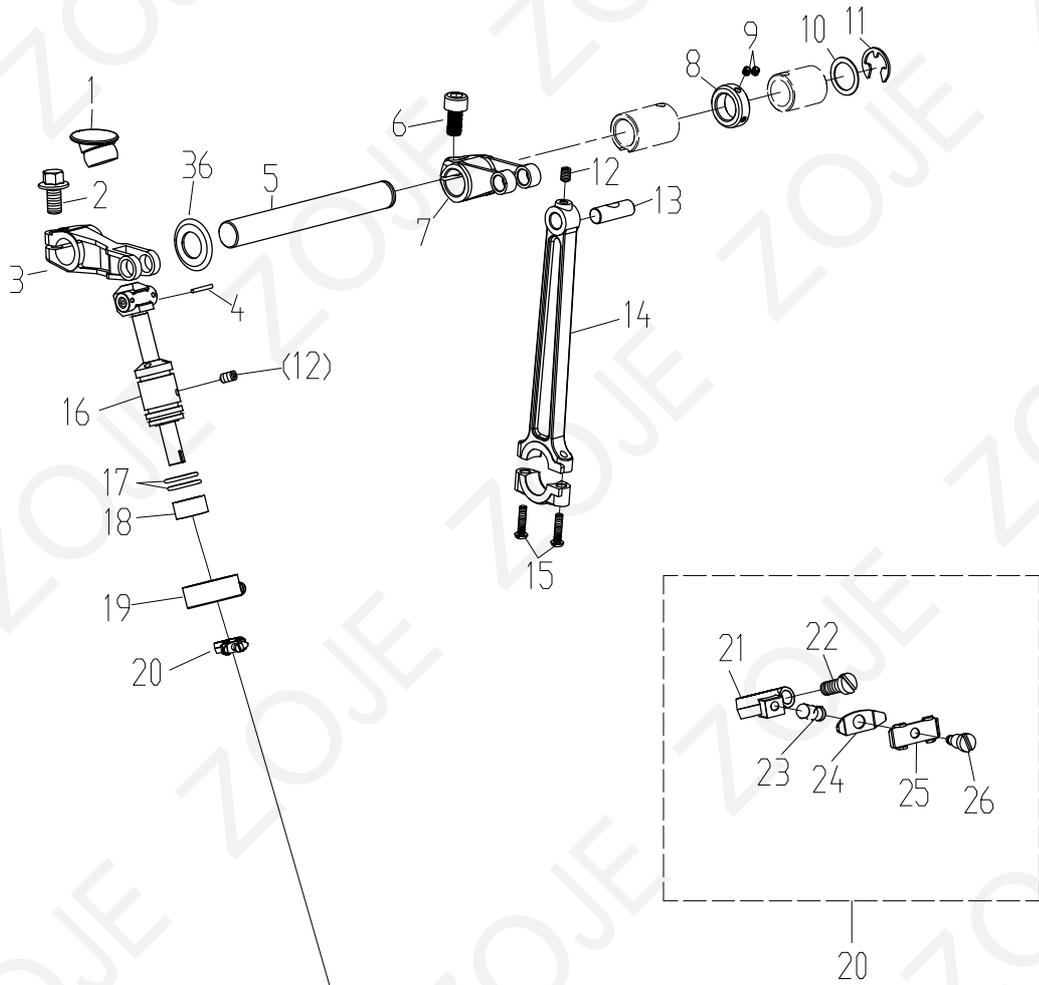
6. 线张力调节机构/THREAD TENSION MECHANISM



6. 线张力调节机构/THREAD TENSION MECHANISM

序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	10080799	直针夹线器组件	thread tension aggregate for needle	*
2	10080937	上弯针夹线器组件	thread tension aggregate for upper needle	*
3	10080800	下弯针夹线器组件	thread tension aggregate for lower needle	*
4	10071826	二孔过线板	thread guide plate with two hole	*
5	10057503	过线板	thread guide plate	*
6	10066938	六线夹线器板	thread guide plate	*

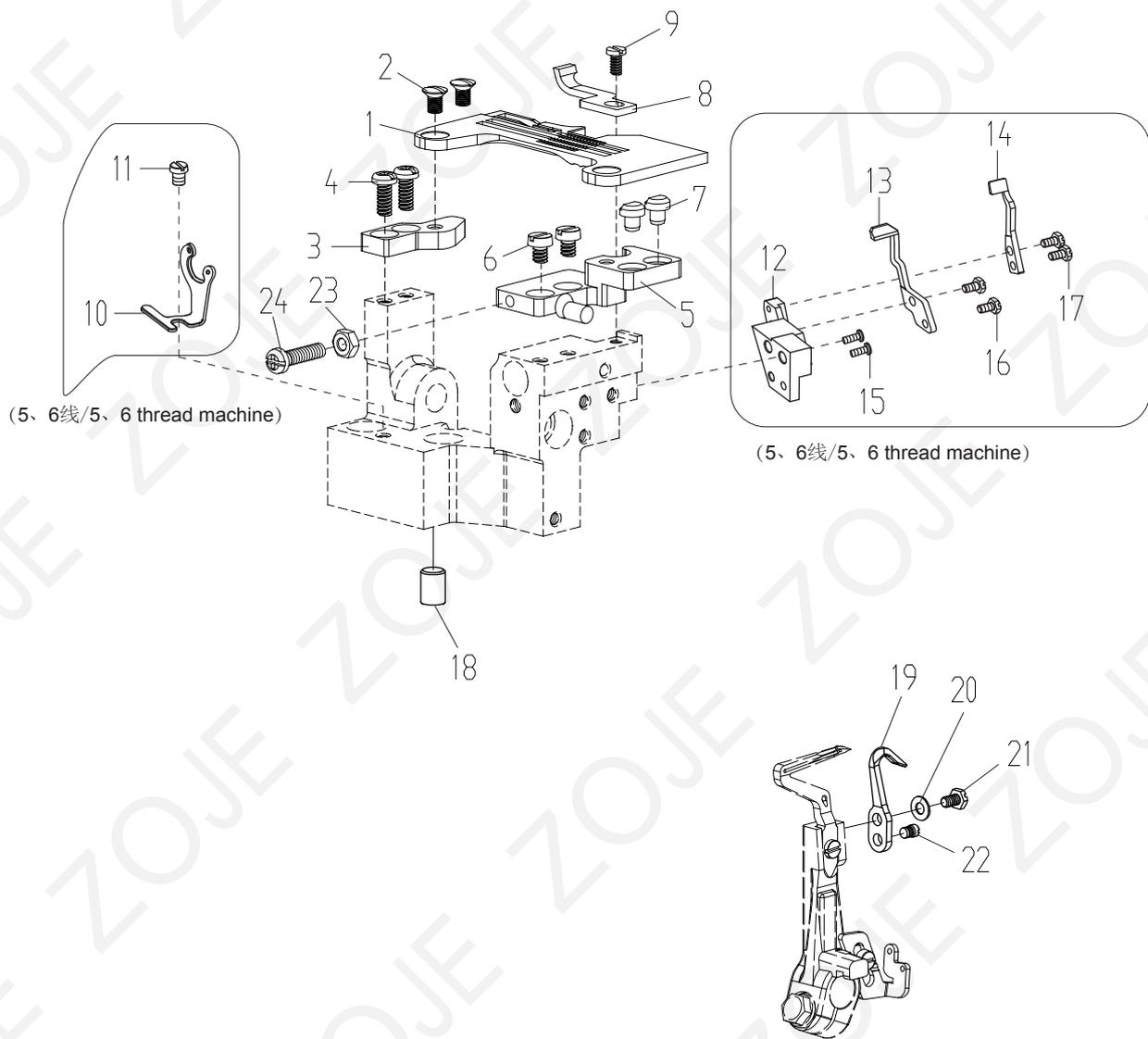
7. 针杆传动机构(1)/NEEDLE DRIVE MECHANISM(1)



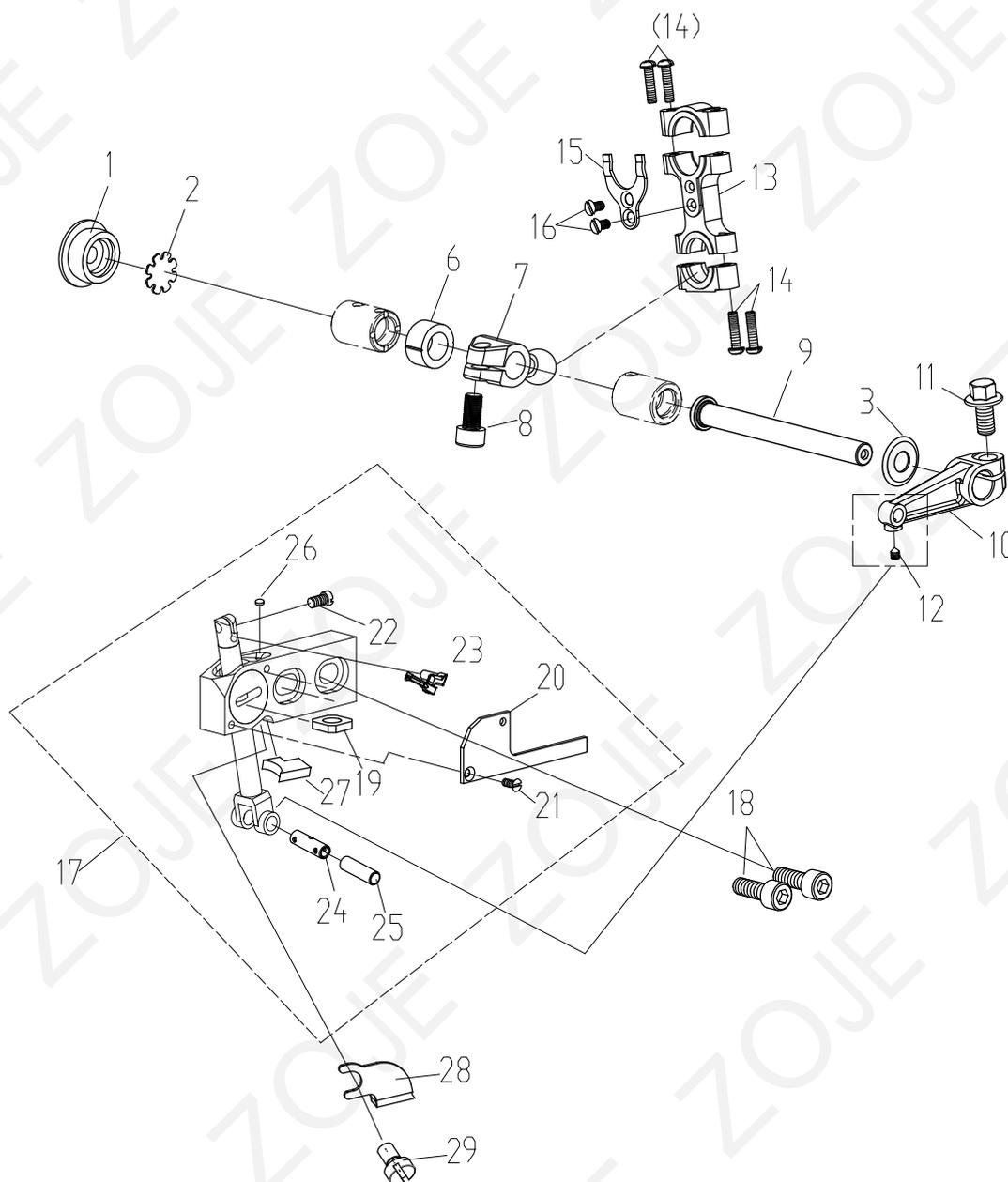
7. 针杆传动机构(1)/NEEDLE DRIVE MECHANISM(1)

序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	10077404	橡胶塞	rubber plug	1
2	10009245	螺钉M6×12	screw M6×12	1
3	10009374	直针曲柄	crank on needle bar	1
4	10008090	油线	oil wick	1
5	10009423	针杆传动轴	driving shaft for needle bar	1
6	10009164	螺钉M6×12	screw M6×12	1
7	10009433	针杆传动曲柄	crank on needle bar drive shaft	1
8	10009357	挡圈	retaining ring	1
9	10009074	螺钉M4×4	screw M4×4	2
10	10033718	垫圈	washer	1
11	10003273	挡圈	retaining ring	1
12	10009109	螺钉M4×6	screw M4×6	2
13	10009432	直针连杆销	pin for connecting rod	1
14	10002961	直针传动连杆	connecting rod for needle bar	1
15	10002939	螺钉M4×15.5	screw M4×15.5	2
16	10009386	针杆组件	needle bar	1
17	10009391	O型圈	O ring	2
18	10009356	针杆套毛毡	Felt	1
19	10072234	针杆回油套	felt	1
20	20001229	针夹头夹组件	the needle clamp clip	1
21	10009344	针夹头夹	the needle clamp clip	1
22	10010888	螺钉M3×6.6	screw M3×6.6	1
23	10009400	夹线簧	spring	1
24	10009341	下夹线板	lower thread tension plate	1
25	10009384	上夹线板	upper thread tension plate	1
26	10009383	螺钉	screw	1
27	*	针夹头	needle holder	1
28	10003431	针夹头过线板	thread guide plate of needle holder	1
29	10009422	螺钉M2×2.8	screw M2×2.8	1
30	10009255	螺钉SM1/8"×44	screw SM1/8"×44	*
31	10009339	针夹头过线板	thread guide plate of needle holder	1
32	10009644	针夹头过线板	thread guide plate of needle holder	1
33	10009664	螺钉M2-6h	screw M2-6h	1
34	10008205	针夹头过线板	thread guide plate of needle holder	1
35	*	机针	needle	*
36	10010112	O形圈	O ring	1
		*: 参看专用件表/see the guage list		

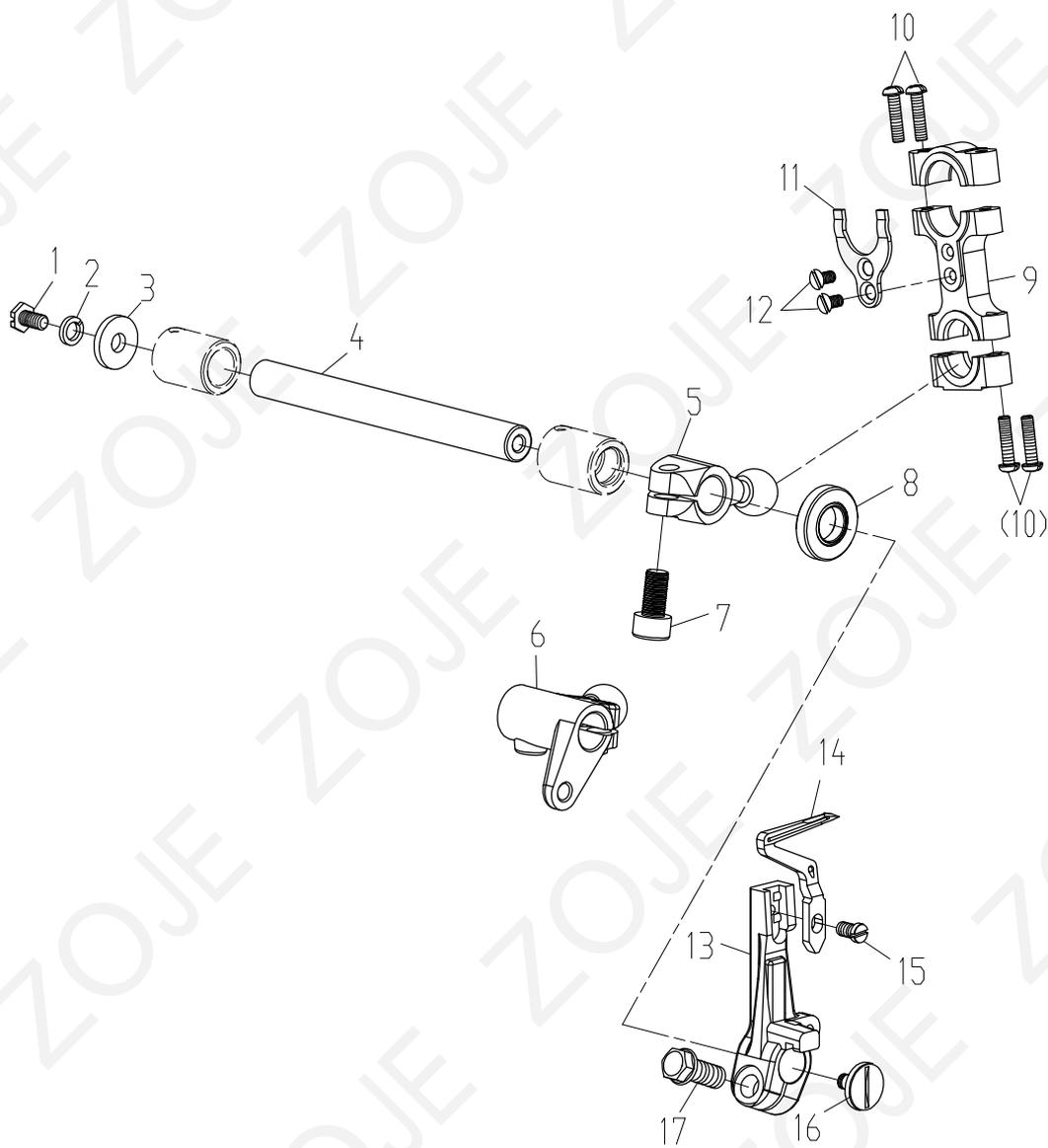
8. 针杆传动机构(2)/NEEDLE DRIVE MECHANISM(2)



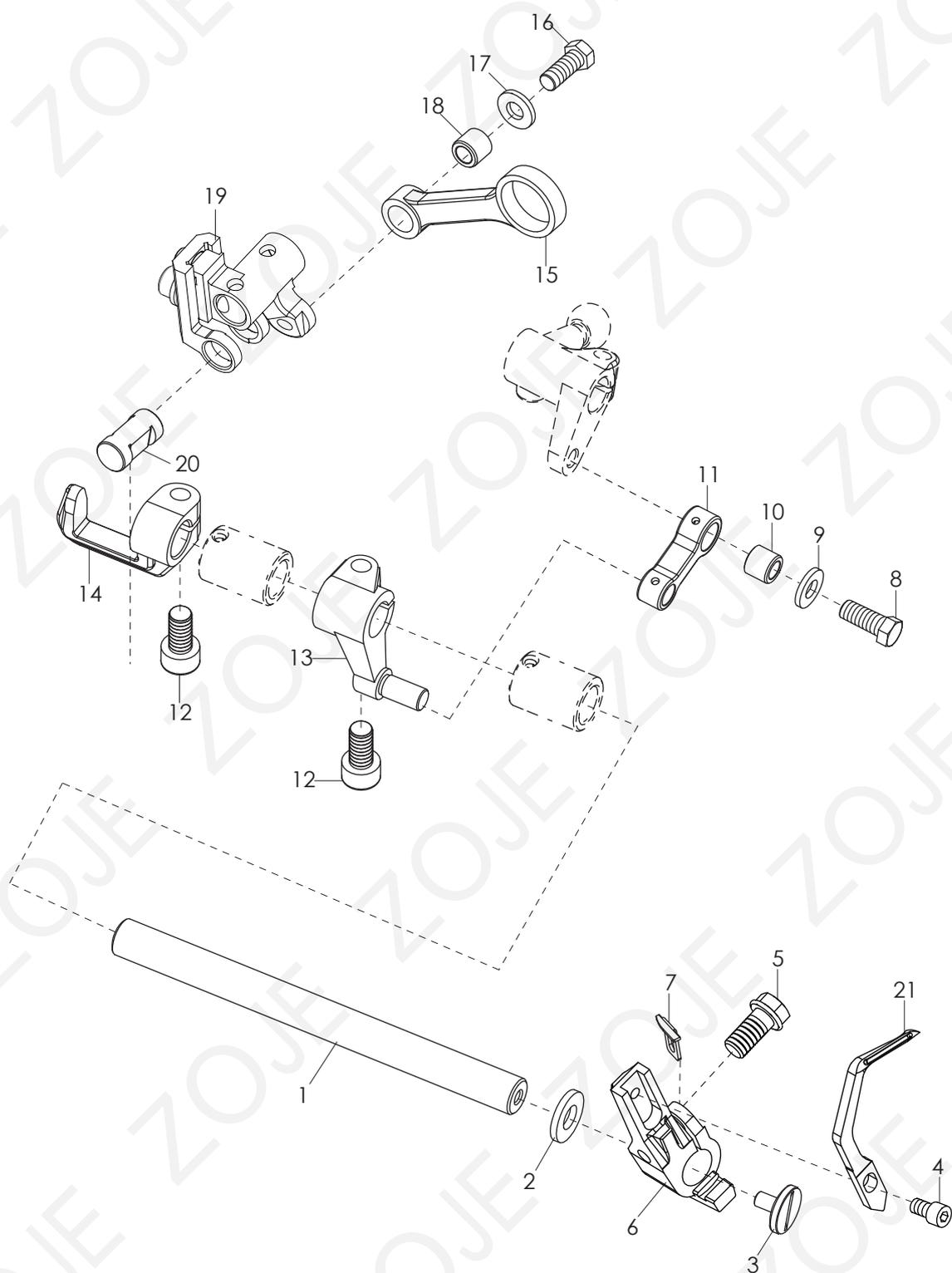
9. 上弯针传动机构/UPPER LOOPER DRIVE MECHANISM



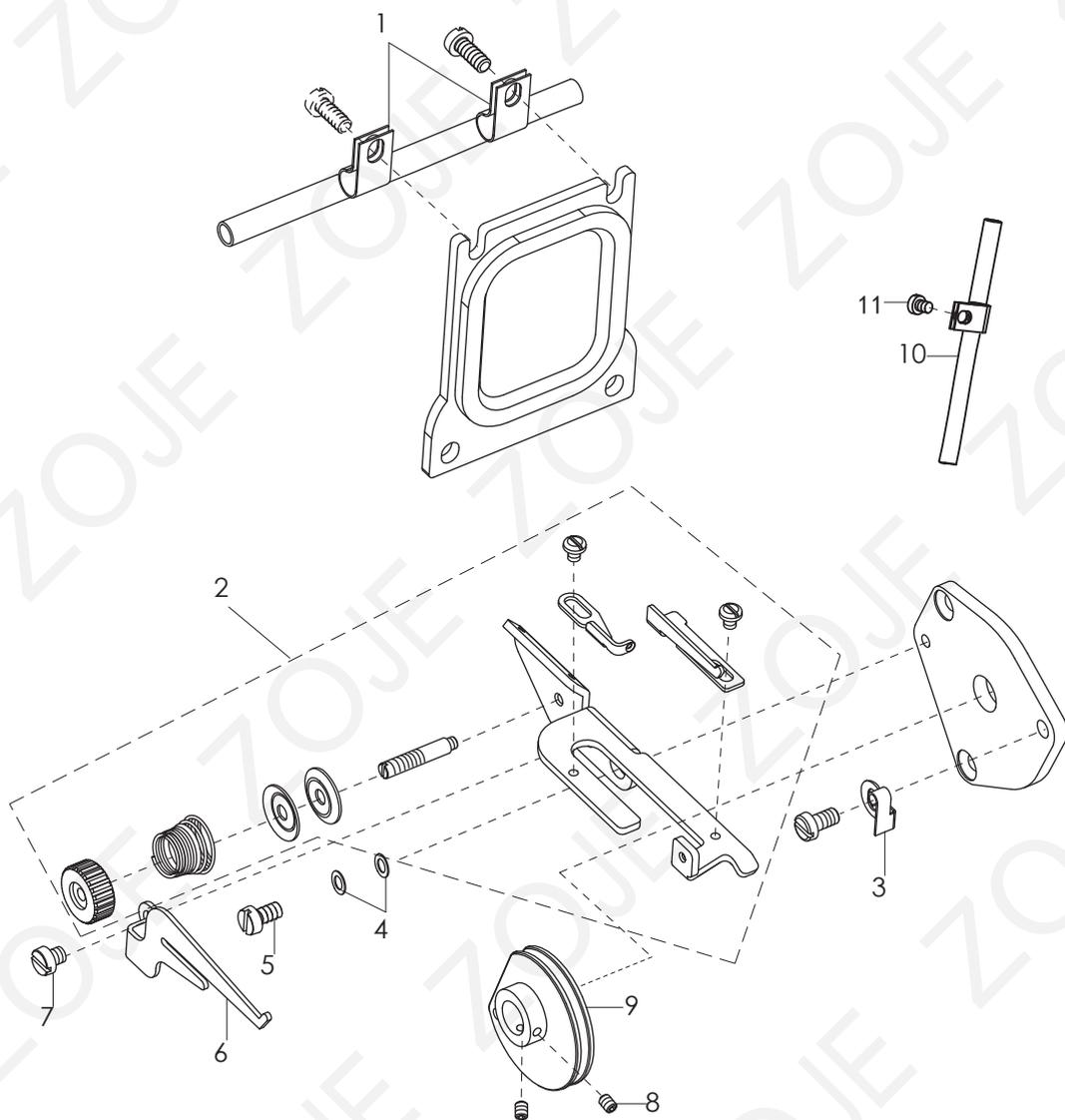
10. 下弯针传动机构/LOWER LOOPER DRIVE MECHANISM



11. 链弯针机构/CHAINSTITCH LOOPER FRAME



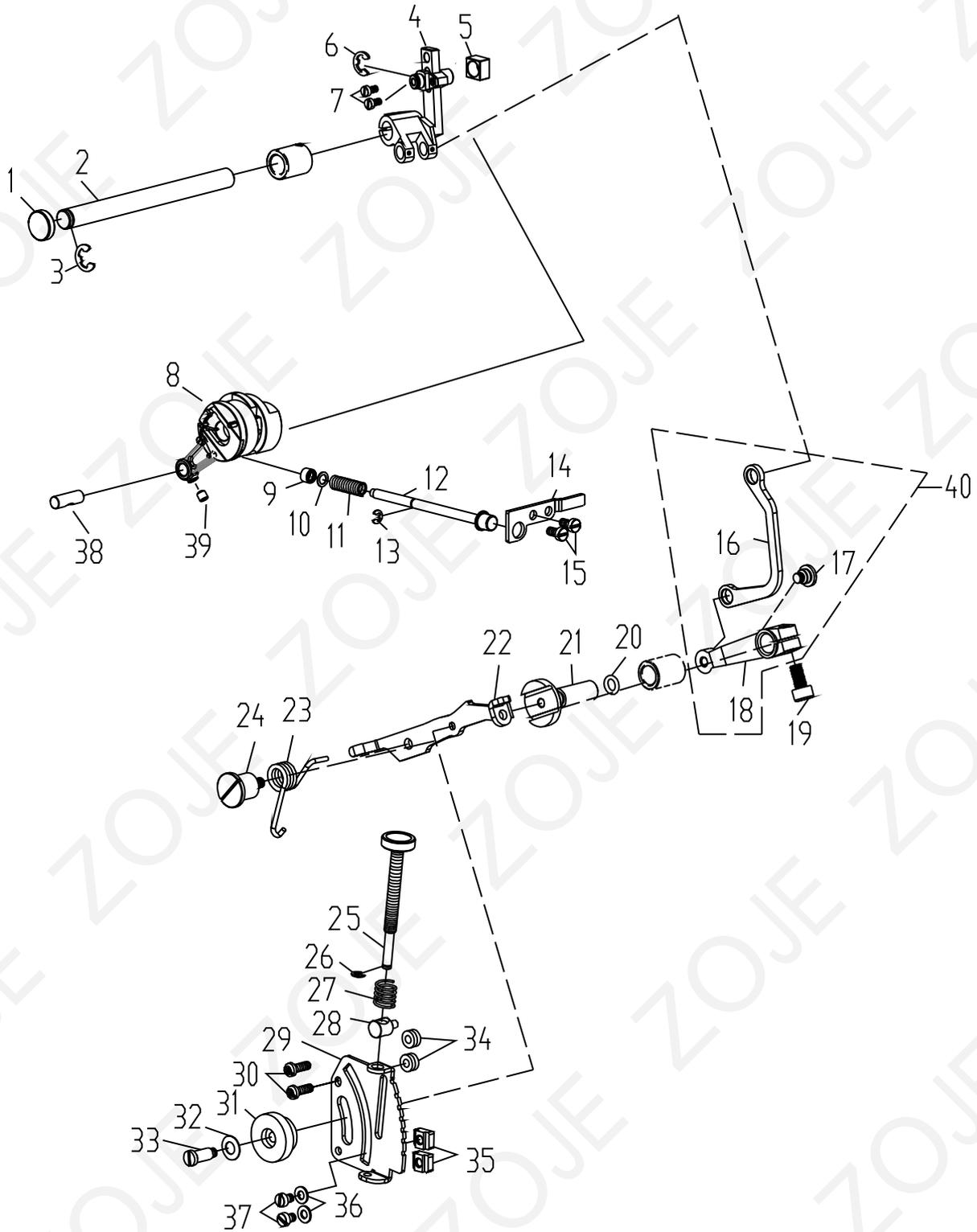
12. 打线凸轮机构/CAM ASSEMBLY



12. 打线凸轮部件/CAM ASSEMBLY

序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	10055261	横过线管组件	elastic clamp for thread guide	1
2	10034163	夹线架组件	thread tension nut	1
3	10033742	弹簧	Spring	1
4	10010596	垫圈	washer	2
5	10010556	螺钉	screw	1
6	10033740	打线架	thread take-up stand	1
7	10004171	螺钉	screw	1
8	10010196	螺钉	screw	2
9	10010664	打线凸轮组件	thread take-up cam assembly	1
10	10055262	竖过线管组件	the vertical line pipe	1
11	10009556	螺钉	screw	1

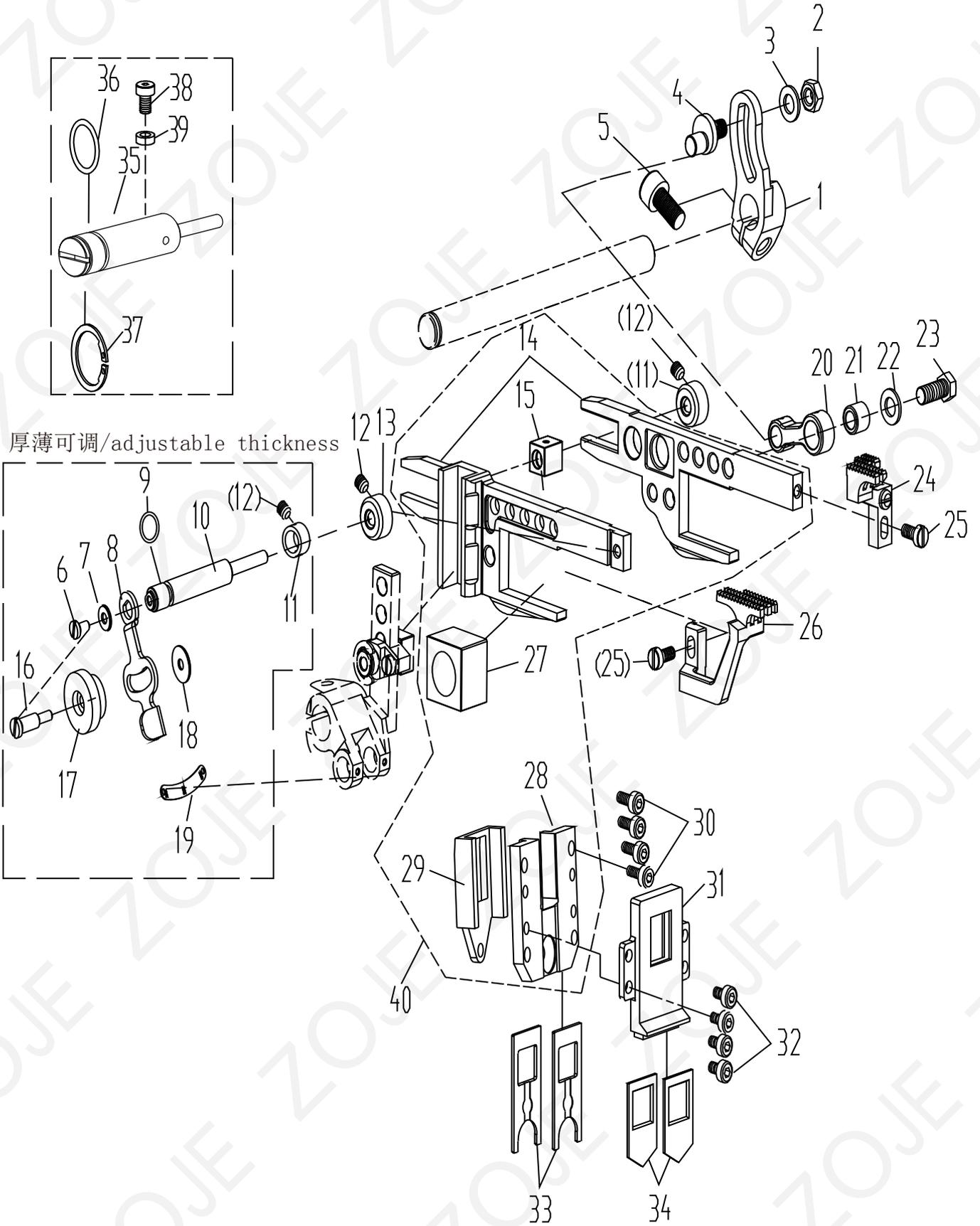
13. 差动送布机构(1)/DIFFERENTIAL FEED ASSEMBLY(1)



13. 差动送布机构(1)/DIFFERENTIAL FEED ASSMEBLY(1)

序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	10008961	橡胶塞	rubber plug	1
2	10009198	送料轴	feeding shaft	1
3	10009239	挡圈	retaining spring	1
4	10009000	差动调节右曲柄组件	right crank assembly of differential regulato	1
5	10009139	差动牙架滑块	sliding block	1
6	10008989	挡圈	rataining spring	1
7	10009625	螺钉	screw	2
8	10008816	送布偏心轮组件	eccentric as-feed	1
9	10053036	针距按钮轴密封圈	oil seal	1
10	10009246	垫圈	washer	1
11	10009248	针距按钮轴弹簧	spring	1
12	10009249	针距调节按钮轴	button shaft	1
13	10003248	挡圈	retaining spring	1
14	10009040	针距按钮挡板	plate	1
15	10010595	螺钉	screw	2
16	10008995	差动调节连杆	differential regulating connecting rod	1
17	10009624	螺钉	screw	1
18	10009256	差动调节左曲柄	left crank of differential regulator	1
19	10009164	螺钉	screw	1
20	10009608	O型圈	O ring	2
21	10086611	差动调节轴	shaft of differential regulator	1
22	10009224	调节杆	adjusting bar	1
23	10009563	扭簧	spring	1
24	10009558	螺钉	screw	1
25	10009218	微调螺柱	screw	1
26	10009669	挡圈	retaining spring	1
27	10009205	弹簧	spring	1
28	10009203	螺母	nut	1
29	10009223	调节指示板	indication plate of adjustment	1
30	10009037	螺钉	screw	2
31	10009565	螺母	nut	1
32	10009564	垫片	washer	1
33	10009562	螺钉	screw	1
34	10009200	垫圈	washer	2
35	10010894	调节滑块	adjusting block	2
36	10003083	垫片	washer	2
37	10010554	螺钉	screw	2
38	10034610	销	Pin	1
39	10009109	螺钉	screw	1
40	10082031	差动调节曲柄连杆组件	differential adjustment crank connecting rod assembly	1

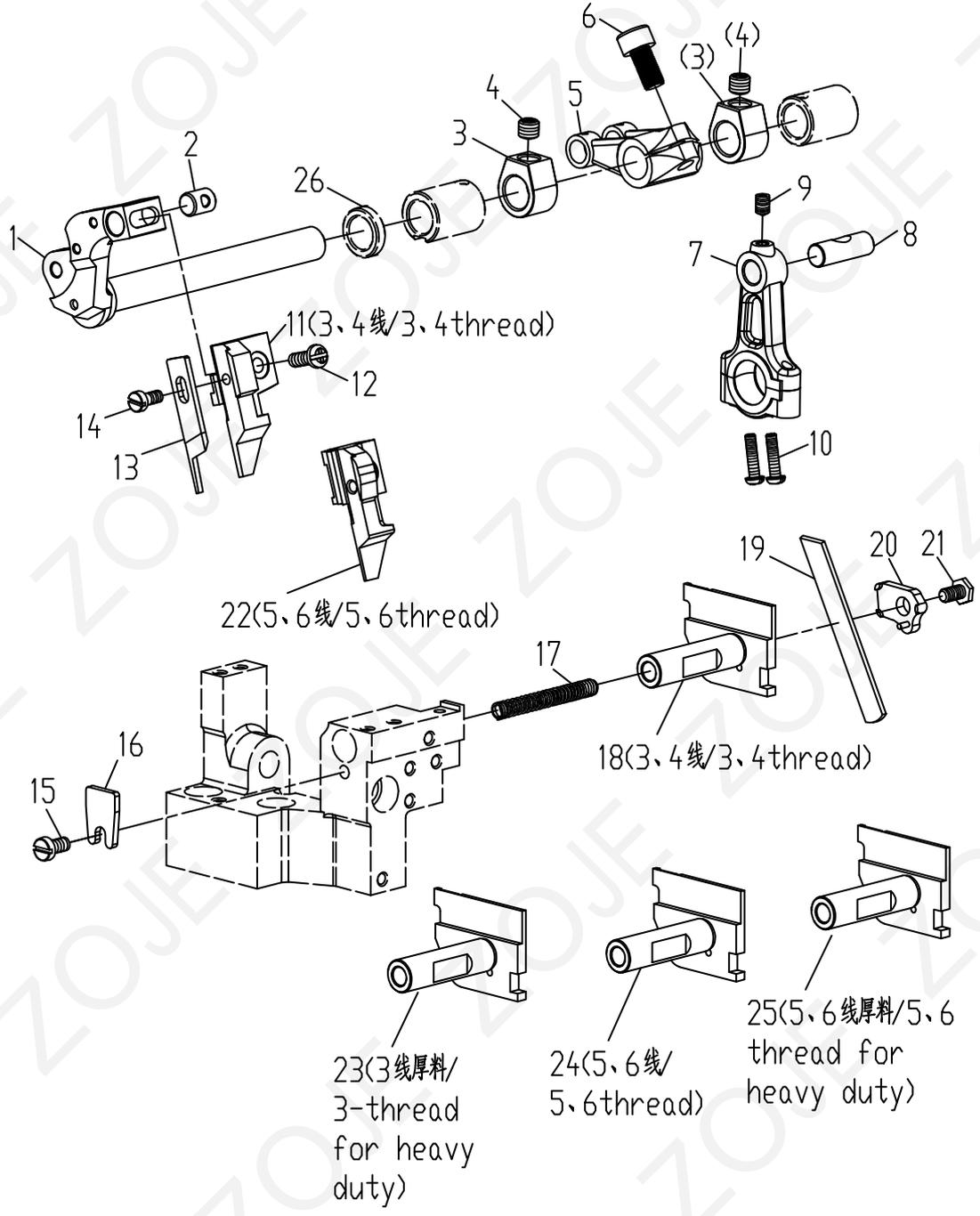
14. 差动送布机构(2)/DIFFERENTIAL FEED ASSEMBLY(2)



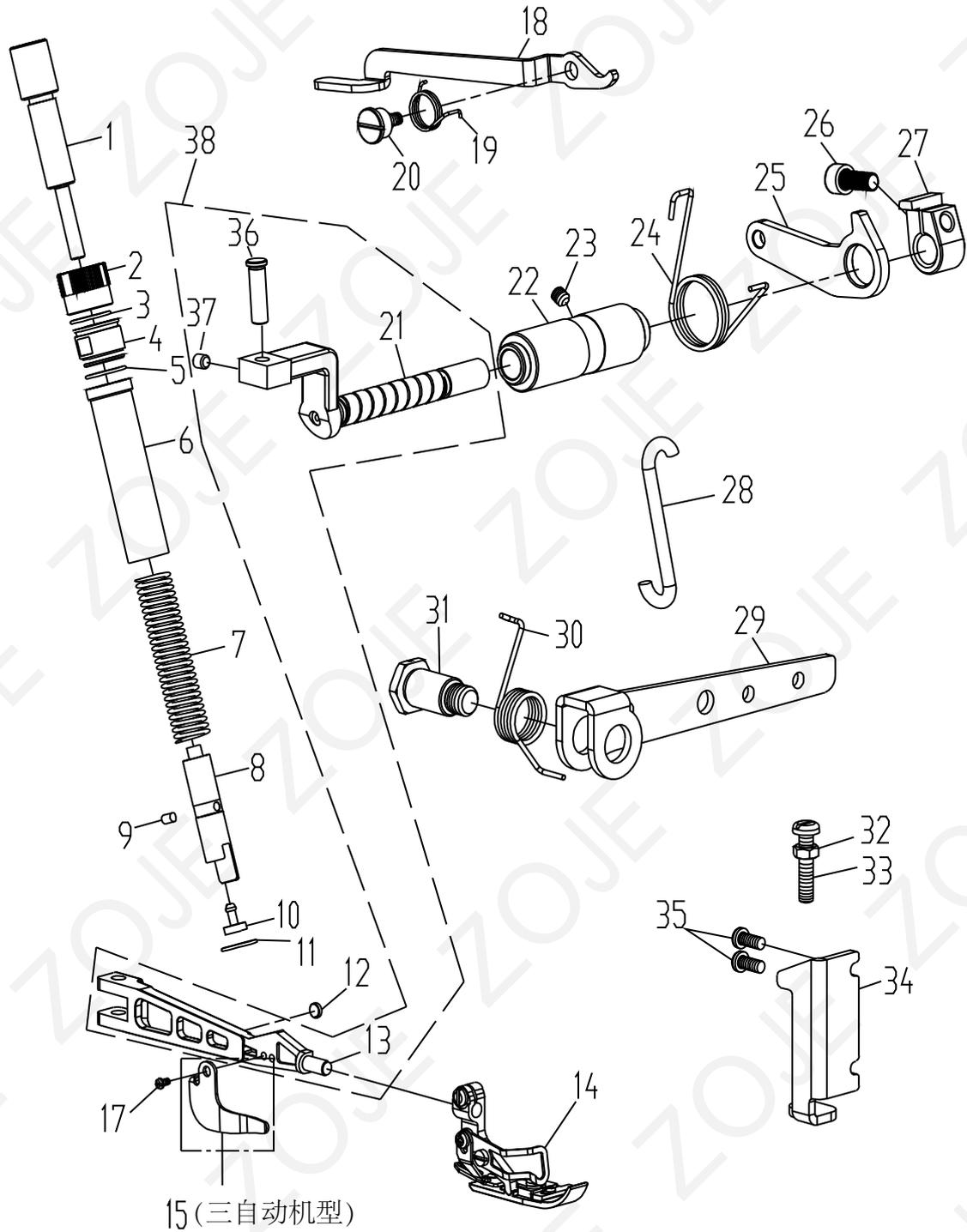
14. 差动送布机构(2)/DIFFERENTIAL FEED ASSEMBLY (2)

序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	10009194	方口曲柄	crank with rectangular shaft	1
2	10009467	螺母	nut	1
3	10009192	垫圈	washer	1
4	10009193	送料连杆销	pin with thread for feeding connecting rod	1
5	10009164	螺钉	screw	1
6	10074460	SM1/8"×44螺钉	screw	1
7	10074447	垫圈	Washer	1
8	10072915	调节扳手	Adjusting wrench	1
9	10009608	O形圈	O-ring	1
10	10072913	抬牙偏心轴	Tooth lifting eccentric shaft	1
11	10074459	挡圈	Retaining ring	1
12	10009074	螺钉	screw	1
13	10009166	挡圈	washer	4
14	10006869	牙架组件	dental rack assembly	1
15	10009134	抬牙调节滑块	sliding block	1
16	10074363	轴位螺钉	Axial screw	1
17	10009565	M6×0.75螺母	Nut	1
18	10072914	螺钉锁紧片	screw locking piece	1
19	10072911	标牌	signboard	1
20	10066197	送料连杆	feeding connecting rod	1
21	10023487	连杆销套	bush connecting rod	1
22	10009192	垫圈	washer	1
23	10009142	螺钉	screw	1
24	*	主送料牙组件	body of main feed dog	1
25	10009586	螺钉	screw	2
26	*	差动送料牙	differential feed dog	1
27	10009133	抬牙滑块	sliding block for feed dog lifting	1
28	10071159	牙架导轨	rack guide	1
29	10071160	油封盖板	oil seal cover plate	1
30	10009102	螺钉	screw	4
31	10009161	外油封架	outer oil seal stand	1
32	10002975	螺钉	screw	4
33	10009081	牙架油封	oil seal	2
34	10037823	牙架油封	oil seal	2
35	10009137	抬牙调节偏心轴	eccentric shaft	1
36	10009135	O型圈	O ring	1
37	10009136	挡圈	spring	1
38	10009117	偏心轴锁紧螺钉	screw	1
39	10009114	偏心轴锁紧螺钉橡胶垫	rubber cushion	1
40	10082075	牙架导轨组件	dental rack guide rail component	1
		*: 参看专用件表/see the guage list		

15. 切料机构/KNIFE DRIVE ASSEMBLY



16. 压脚机构/PRESSER FOOT ASSEMBLY



15 (三自动机型)



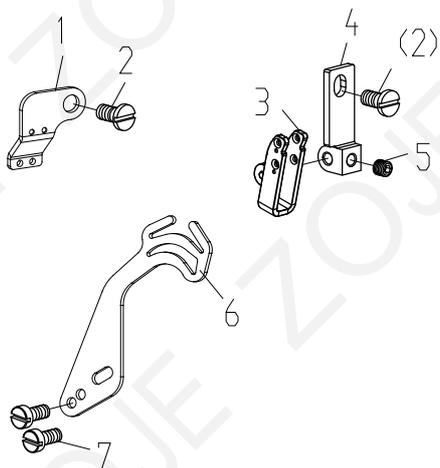
16 (普通机型)

16. 压脚机构/PRESSER FOOT ASSEMBLY

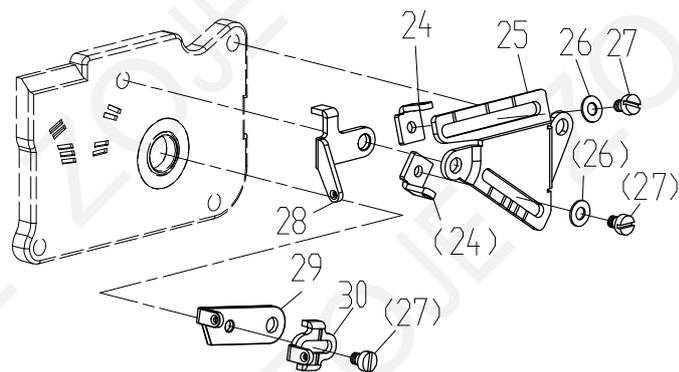
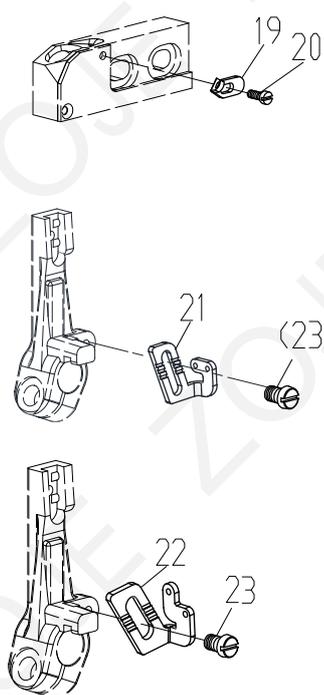
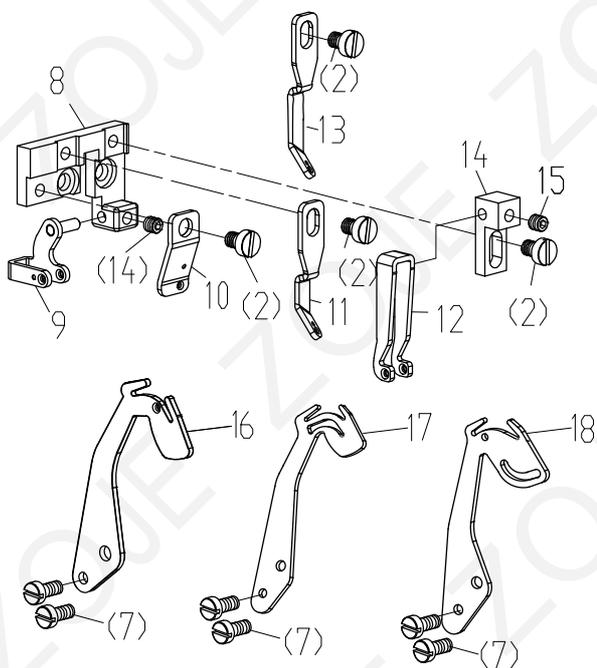
序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	10058290	调压螺钉	screw for adjusting pressure of presser foot	1
2	10057465	调压螺母	nut for adjusting pressure of presser foot	1
3	10057462	O型圈	O ring	1
4	10057460	压脚杆螺纹套	press pin threaded sleeve	1
5	10057464	O型圈	O ring	1
6	10062471	压脚杆塑料套	press pin plastic cover	1
7	10062472	弹簧	spring	1
8	10057455	压脚杆	bar of presser foot	1
9	10002844	销	pin	1
10	10009454	塑料垫	plastic mat	1
11	10057463	O型圈	O ring	1
12	10061365	压脚安全开关磁铁	foot safety switch magnet	1
13	10058563	压脚臂	arm of presser foot lifting	1
14	*	压脚组件	presser foot components	1
15	10037480	切刀防护板	guard plate of cutter	1
16	10011912	割线刀	secant knife	1
17	10009529	螺钉	screw	1
18	10062481	压脚扳手	hand lifter of presser foot	1
19	10063382	压脚扳手扭簧	spring	1
20	10057459	扳手螺钉	screw	1
21	10009032	压脚轴	shaft of presser foot	1
22	10061300	压脚轴套	bush of presser foot lifting	1
23	10023463	螺钉M4×4	screw M4×4	1
24	10037485	扭簧	spring	1
25	10033721	抬压脚连杆	connecting bar for presser foot lifting	1
26	10009616	螺钉M6×14	screw M6×14	1
27	10034616	抬压脚曲柄	crank for presser foot lifting	1
28	10009622	抬压脚拉杆	pulling lever for presser foot	1
29	10009158	抬压脚杠杆	lever for the presser foot	1
30	10009036	杠杆扭簧	torsing spring for lever	1
31	10036965	螺钉	screw	1
32	10009623	螺钉M5×24	screw M5×24	1
33	10009467	螺母	nut	1
34	10068687	制动板	brake plate	1
35	10009104	螺钉M4×9.5	screw M4×9.5	2
36	10009319	销	pin	1
37	10014216	螺钉M4×0.5×4	Screw	1
38	10079730	压脚轴组件	pressure foot shaft component	1
		*: 参看专用件表/see the guage list		

17. 挑线 • 过线机构/THREAD TAKEUP AND THREADING FRAME

3,4线/3,4thread



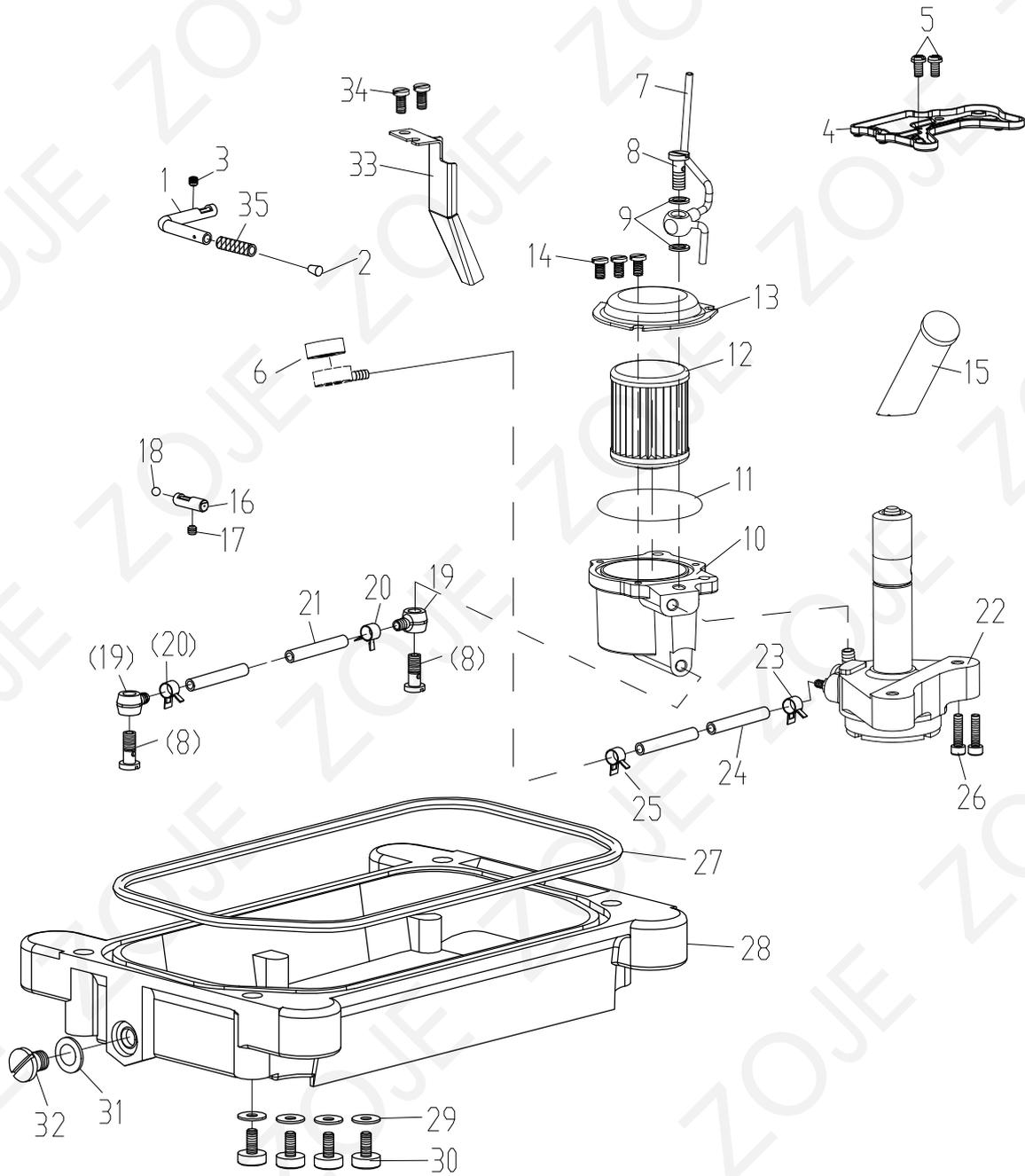
5,6线/5,6thread



17. 挑线·过线机构/THREAD TAKEUP AND THREADING FRAME

序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	10072227	直针过线板	thread guide plate on the needle bar	1
2	10010594	螺钉M4×7.5	screw M4×7.5	2
3	10009058	挑线夹组件	thread tension plate	1
4	10074571	挑线夹固定架	fixing stand for thread take-up clamp	1
5	10023463	螺钉M4×4	screw M4×4	1
6	10072226	挑线架	thread take-up stand	1
7	10009600	螺钉	screw	2
8	10074572	固定板	fixing plate	1
9	10009663	下挑线夹组件	lower thread tension plate	1
10	10009280	左过线板	thread guide plate of left	1
11	10003252	右过线板	thread guide plate of right upper	1
12	10002756	上挑线夹组件	thread tension plate	1
13	10077866	右过线板(厚料)	thread guide plate of right upper	1
14	10074573	挑线夹固定架	fixing stand for thread take-up clamp	1
15	10009074	螺钉M4×4	screw M4×4	2
16	10072226	挑线架	thread take-up stand	1
17	10080252	挑线架(六线)	thread take-up stand	1
18	10072632	挑线架(五线厚料)	thread take-up stand	1
19	10009369	上弯针小过线板	small thread guide plate of upper looper	1
20	10009353	螺钉M2.5×7	screw M2.5×7	1
21	10065093	下弯针过线板(三、四线)	thread guide plate for lower looper	1
22	10009018	下弯针过线板(五、六线)	thread guide plate for lower looper	1
23	10009363	螺钉SM9/64"×40	screw SM9/64"×40	1
24	10009013	弯针小过线板	thread guide plate of looper	2
25	10009154	弯针下过线板架	stand of lower thread guide plate	1
26	10009599	垫圈	washer	2
27	10009529	螺钉M3×3.8	screw M3×3.8	3
28	10009153	上弯针过线板	thread guide plate of upper looper	1
29	10009147	上弯针轴内过线板	inner thread guide plate mounted on the shaft	1
30	10009012	上弯针轴外过线板	outer thread guide plate mounted on the shaft	1

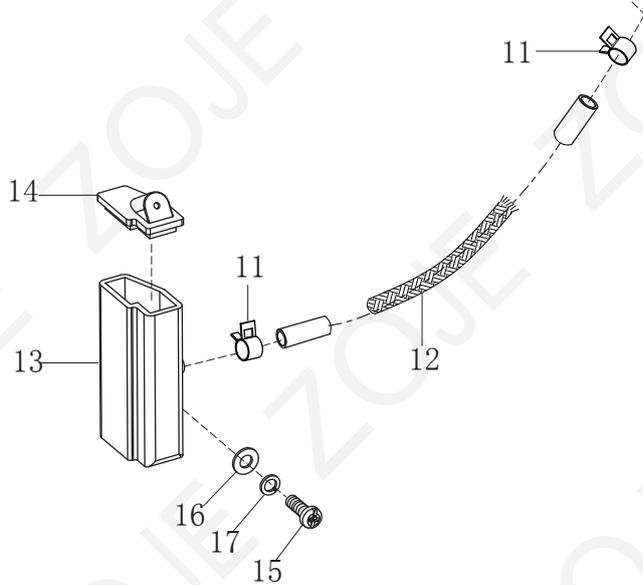
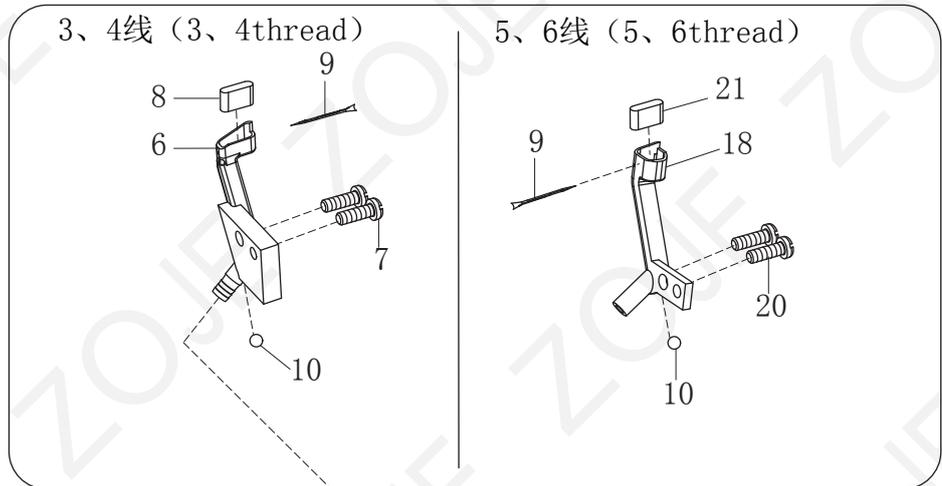
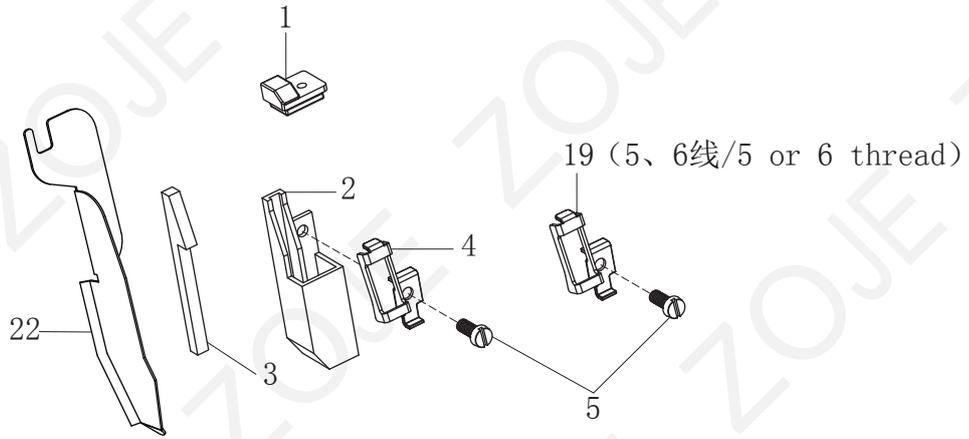
18. 润滑部件/LUBRICATION ASSEMBLY



18. 润滑部件/LUBRICATION ASSEMBLY

序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	10008992	针杆给油销	oil pin for needle bar	1
2	10009039	针杆给油销橡胶塞	rubber plug	1
3	10023463	螺钉M4×4	screw M4×4	1
4	10058564	分油板	oil distributing plate	1
5	10012710	螺钉M4×14	screw M4×14	2
6	10072480	针杆回油套毛毡	Felt	1
7	10071817	上喷油管	upper fuel injection pipe	1
8	10009592	螺钉接头	joint part	3
9	10012086	垫圈	washer	2
10	10072223	油分配器	oil distributor	1
11	10009144	油分配器密封圈	oil distributor sealing ring	1
12	10043169	滤油器	oil filter	1
13	10072425	油分配器盖	oil distributor cover	1
14	10010554	螺钉M4×5.5	screw M4×5.5	1
15	10072224	油窗	oil window	1
16	10012322	给油销	pin for oiling	1
17	10009074	螺钉M4×4	screw M4×4	1
18	10009826	钢球	steel ball	1
19	10009588	塑料接头	joint part	2
20	10011471	油管夹	fastening ring	2
21	10007796	油管	hose	250
22	10009146	油泵组件	assembly of oil pump	1
23	10009469	油管夹	fastening ring	1
24	10007800	油管	hose	285
25	10012160	弹簧	spring	1
26	10009103	螺钉M4×16	screw M4×16	2
27	10052381	油盘垫	washer for oil tray	1
28	10052380	油盘	oil tray	1
29	10009447	垫圈	washer	4
30	10009095	螺钉M5×12	screw M5×12	4
31	10009263	垫圈组件	washer assembly	1
32	10009264	螺钉SM3/8"×28	screw SM3/8"×28	1
33	10073223	涡轮导油板	turbine oil deflector	1
34	10009264	螺钉M4×7.5	screw M4×7.5	2
35	10008062	油线	oil wick	13

19. H · R装置/H · R DEVICE



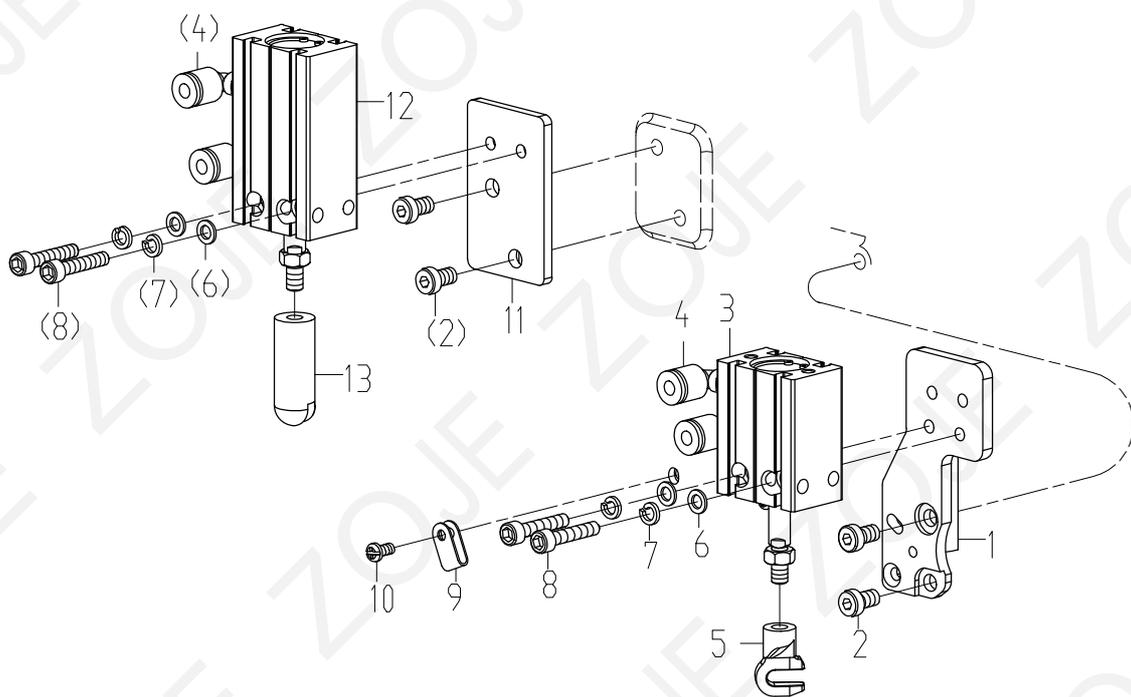
19. H · R装置/H · R DEVICE

序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	10008925	盒盖	box cover	1
2	10009094	上硅油盒	upper silicon oil box	1
3	10008924	毛毡	felt	1
4	10008923	毛毡压板	presser plate for felt	1
5	10009104	螺钉M4×9.5	screw M4×9.5	1
6	10008931	硅油盒	silicon oil box	1
7	10009037	螺钉M4×12	screw M4×12	2
8	10008922	毛毡	felt	1
9	10003344	大头针	pin	1
10	10009826	钢球	steel ball	1
11	10011471	紧固圈	fastening ring	2
12	10008072	油线	oil wick	1
13	10008971	下硅油盒	lower silicon oil box	1
14	10008883	盒盖	Box lid	1
15	10002934	螺钉M4×12	screw M4×12	1
16	10003133	垫圈	washer	1
17	10009503	垫圈	washer	1
18	10009661	硅油盒	silicon oil box	1
19	10023474	毛毡压板	presser plate for felt	1
20	10009042	螺钉M4×8	screw M4×8	2
21	10009659	毛毡	felt	1
22	10008884	挡油板	seal plae	1

20. 厚薄可调部件/Thick and thin adjustable Parts

序号 No.	件号 Parts No.	名称	Description	数量 Number
1	10084104	销套螺钉	screw	2
2	10084103	销套	pin sleeve	2
3	10068707	抬压脚连杆	lift the pressure foot bridge	1
4	10065628	M5×16组合螺钉	M5×6 screw	7
5	10084100	包缝步进电机	Stepper motor	1
6	10084734	电机安装座	Motor installation seat	1
7	10011232	M6×6螺钉	M6×6 screw	2
8	10084101	抬压脚凸轮	Lift the foot cam	1
9	10084866	剪线凸轮组件	Cutting cam assembly	1
10	10012162	M5×5螺钉	M5×5 screw	2
11	10084102	驱动连杆	Drive connecting rod	1
12	10027875	轴位螺钉	screw	1
13	10010106	SM11/64"×40螺母	SM11/64"×40 nut	2
14	10080719	短连杆	short lever	1
15	10010761	垫圈	grommet	1
16	10080722	短轴位螺钉	short axis screw	3
17	10009074	M4×4螺钉	M4×4 screw	2
18	10080718	抬牙主动曲柄	teeth lifting active crank	1
19	10080716	安装块	installation block	2
20	10009078	上刀轴挡圈	upper cutter shaft retaining ring	2
21	10080721	长轴位螺钉	long axis screw	1
22	10003162	M5×12螺钉	M5×12 screw	2
23	10022863	M6×0.75螺钉	M6×0.75 screw	2
24	10084115	后罩壳	Back housing	1
25	10010594	M4×7.5螺钉	M4×7.5 screw	2
26	10082120	限位挡板	limit stop	1
27	10009195	M4×7.80螺钉	M4×7.8 screw	2
28	10084735	驱动轴	tooth lifting drive shaft	1
29	10080715	抬牙从动曲柄	teeth lifting driven crank	1
30	10012752	M4×10螺钉	M4×10 screw	1
31	10080714	长连杆	long connecting rod	1
32	10009104	M4×9.5螺钉	M4×9.5 screw	2
33	10009471	M4螺母	M4 nut	2
34	10080713	抬牙偏心轴连杆	tooth lifting eccentric shaft bridge	1
35	10011802	SM11/64"×14螺钉	SM11/64"×14 screw	1
36	10074447	垫圈	ring	1
37	10074460	SM1/8"×44螺钉	SM1/8"×44 screw	1
38	10080723	油封	oil seal	1
39	10080711	抬牙偏心轴	eccentric axis for lifting teeth	1
40	10045761	针距座销O型圈	needle pitch seat O-ring	1
41	10080809	挡圈	ring	1
42	10023463	M4×4螺钉	M4×4 screw	2
43	10080756	短偏心轴轴套	short eccentric shaft sleeve	1
44	10078156	拉簧	tension spring	1
45	10084986	横盖组件	Cross cover assembly	1

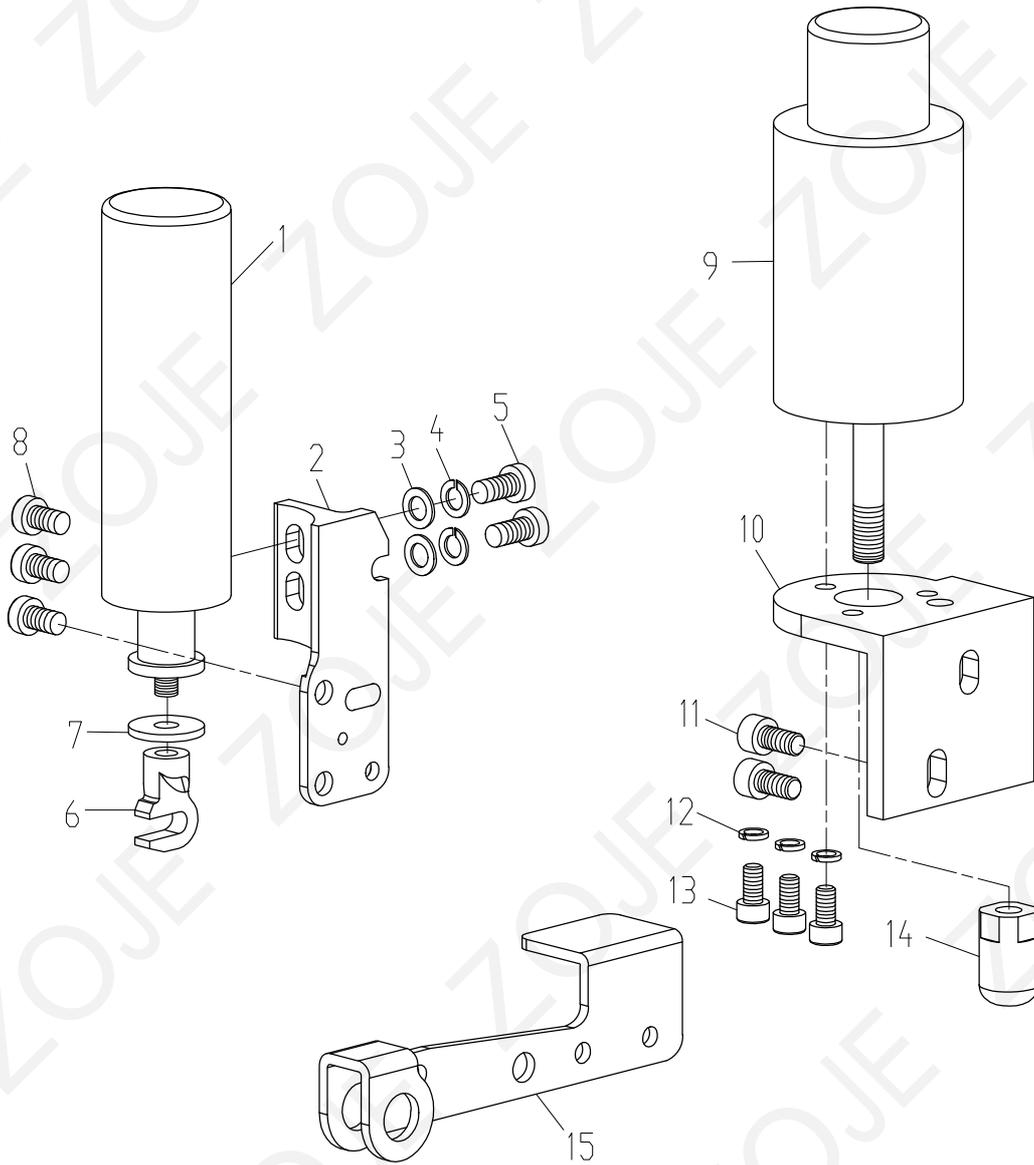
21. 气动驱动抬压脚、剪线机构/TRIM AND LIFT PRESSER FOOT MECHANISM WITH AIR CYLINDER



21. 气动驱动抬压脚、剪线机构/TRIM AND LIFT PRESSER FOOT MECHANISM WITH AIR CYLINDER

序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	10037033	剪线气缸固定板	plate	1
2	10003165	螺钉	screw	4
3	10049556	剪线气缸	air cylinder	1
4	10037851	接头APL6-M5	joint	4
5	10037484	剪线气缸接头	joint of air cylinder	1
6	10006115	垫圈	washer	4
7	10005537	垫圈	spring washer	4
8	10006118	螺钉	screw	4
9	10053084	电线夹	line card	1
10	10014441	螺钉	screw	1
11	10001839	抬压脚气缸固定板	plate	1
12	10049555	抬压脚气缸	air cylinder	1
13	10037034	抬压脚顶杆	mandril for lefting presser foot	1

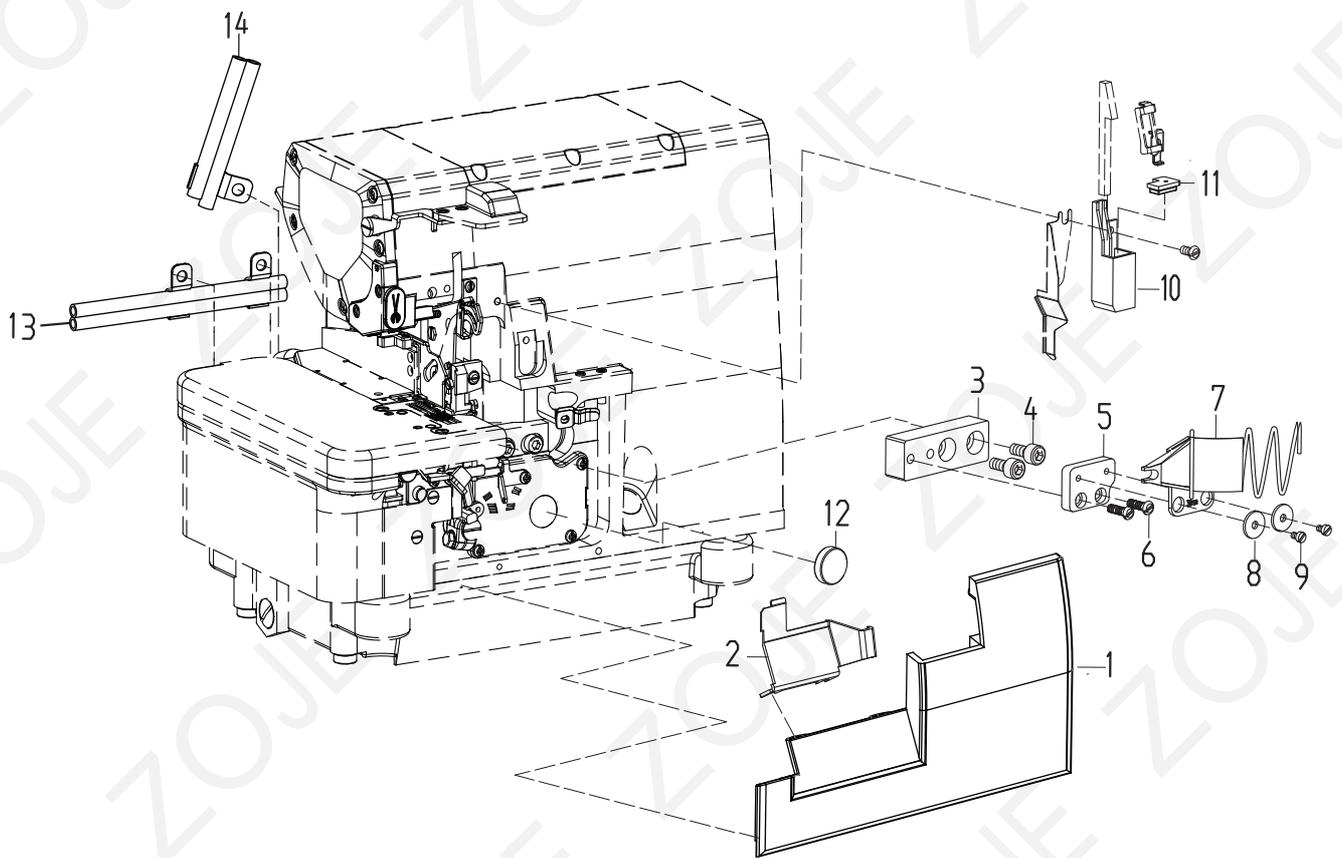
22. 电磁铁驱动抬压脚、剪线机构/TRIM AND LIFT PRESSER FOOT MECHANISM WITH ELECTROMAGNET



22. 电磁铁驱动抬压脚、剪线机构/TRIM AND LIFT PRESSER FOOT MECHANISM WITH ELECTROMAGNET

序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	10049858	剪线电磁铁组件	electromagnet of shearing line	1
2	10053101	电磁铁安装座	the saddle of the electormagnet for shear	1
3	10010835	垫圈	washer	2
4	10052480	轻型弹簧垫圈	spring washer	2
5	10054136	螺钉	screw	2
6	10037484	剪线气缸接头	contact	1
7	10022739	垫圈	washer	1
8	10001839	螺钉	screw	3
9	10052112	抬压脚电磁铁	electormagnet of the lifting	1
10	10052113	抬压脚电磁铁固定板	plate of the fixing	1
11	10003169	螺钉	screw	2
12	10005537	垫圈	washer	3
13	10003165	螺钉	screw	3
14	10051758	抬压脚顶杆	plunger	1
15	10051759	抬压脚杠杆	lever of the lifting presser foot	1

23. 外罩部件(双链缝专用件)/OUT COVER FRAME(Special for double chain sewing)

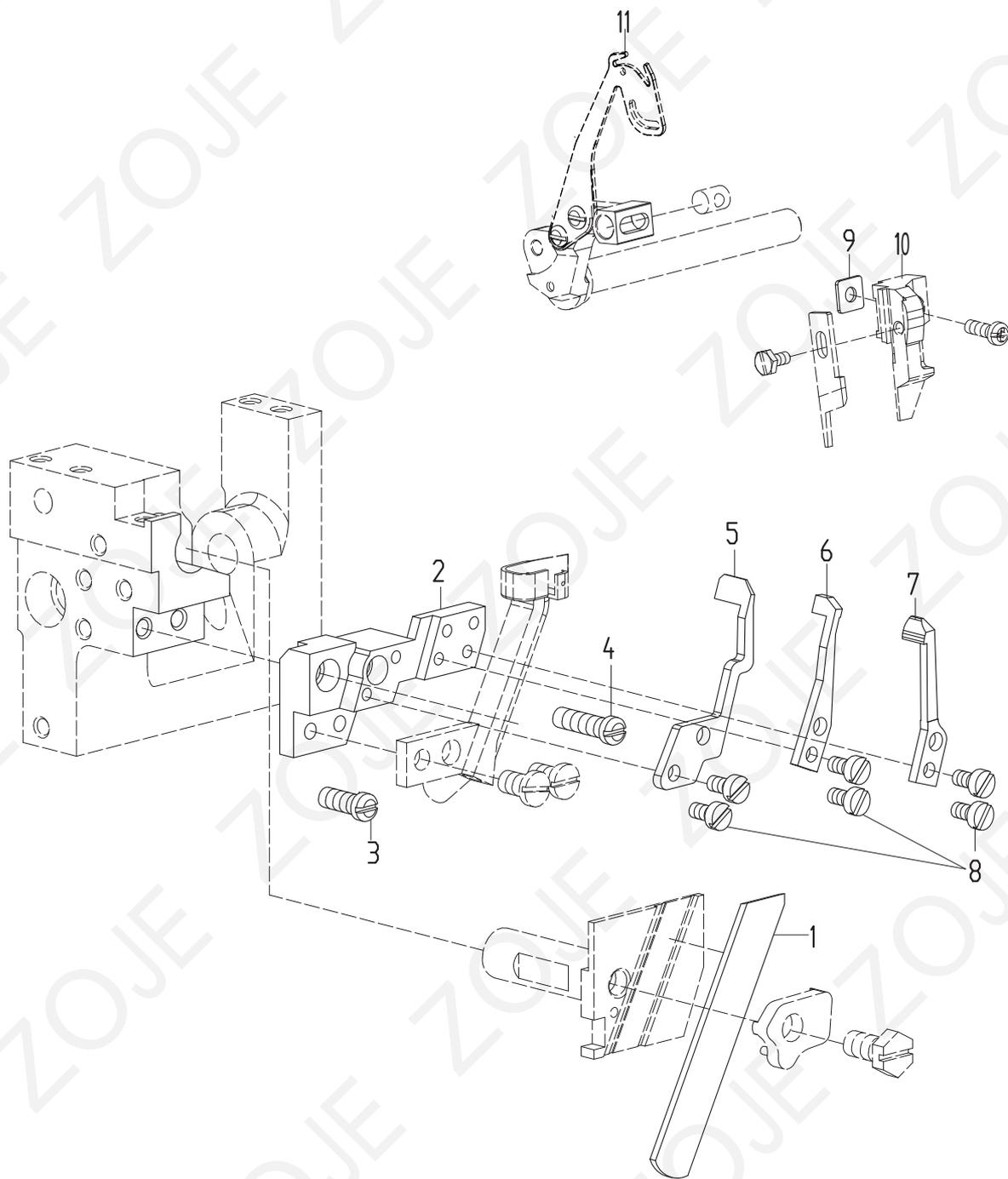


23. 外罩部件 (双链缝专用件)

Out cover frame (Special for double chain sewing)

序号 No.	件号 Pars No.	名称	Description	数量 Number
1	20031695	前盖右涂装	right part of the front	1
2	10081063	前盖中	midle part of the front	1
3	10063910	滑杆座	bracket	1
4	10009008	螺钉M6×16	screw	2
5	10063931	卷带器安装座	guide	1
6	10009104	螺钉M4×9.5	screw	2
7	10013199	卷带器	coiler	1
8	10005415	垫圈	washer	2
9	10012509	螺钉M3.5×8	screw	2
10	10068699	上硅油盒(双链缝)	upper silicon oil box	1
11	10068700	盒盖(双链缝)	box cover	1
12	10013138	上弯针轴前堵	rubber plug	1
13	10067385	横过线管组件	cross line tube	1
14	10012954	上过线管	top line tube	1

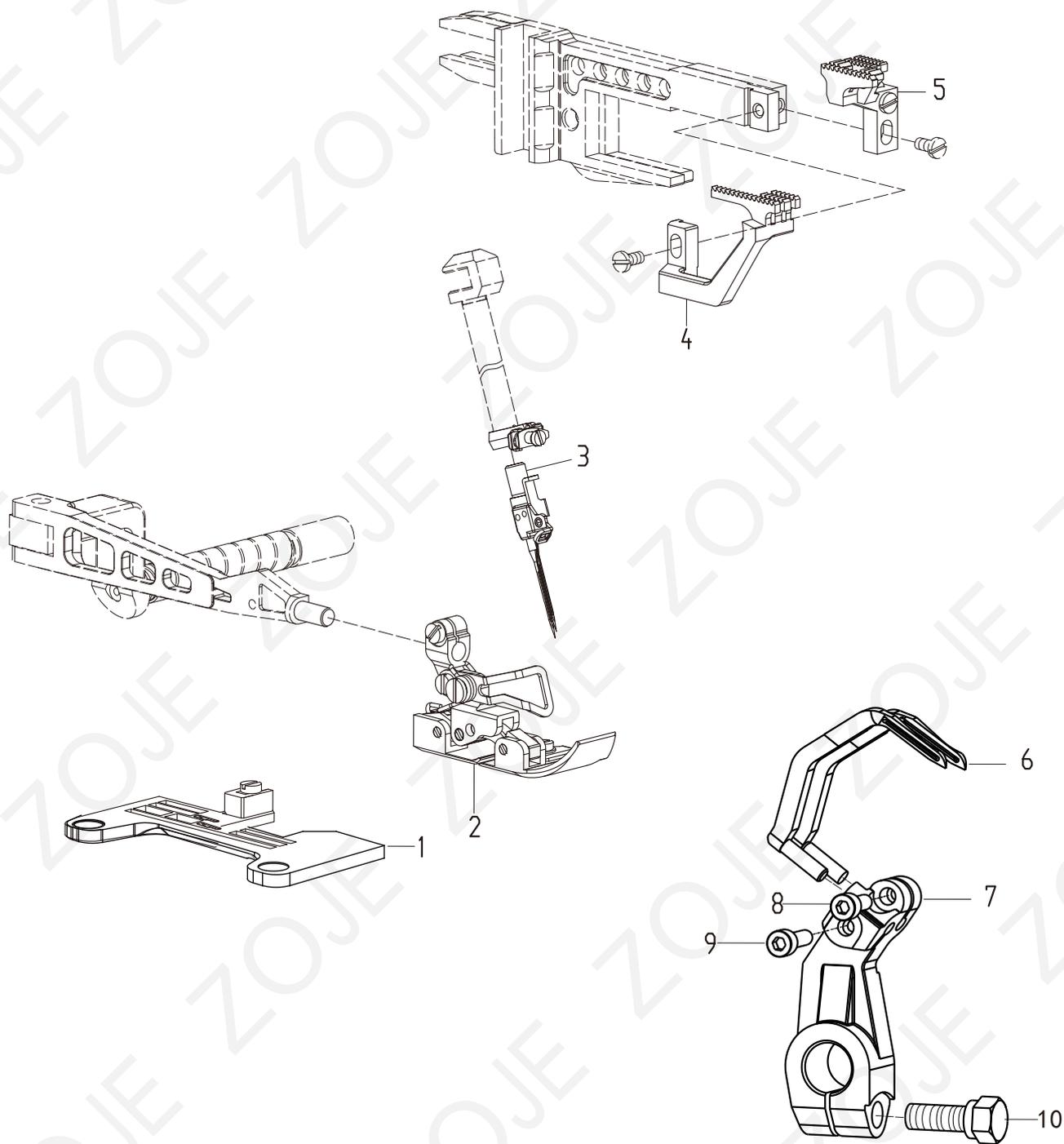
24. 切料、护针组件(双链缝专用)/Cutting and needle guard assembly
(Special for double chain sewing)



24. 切料、护针组件(双链缝专用件)/Cutting and needle guard frame(Special for double chain sewing)

序号 No.	件号 Pars No.	名称	Description	数量 Number
1	10063919	下刀	Knife(double chain sewing)	1
2	10063932	护针座(双链线)	guide(double chain sewing)	1
3	10009638	螺钉M4×9.5	screw	1
4	10063907	螺钉M4×13.5	screw	1
5	10009636	链弯针后护针	back guard left needle	1
6	10063933	右直针前护针(双链线)	front guard of right needle	1
7	10063934	右直针后护针(双链线)	back guard of right needle	1
8	10010555	螺钉M3×5.5	screw	6
9	10063929	垫片	washer	1
10	10079633	上刀架(双链缝)	top rest(double chain sewing)	1
11	10072632	挑线架	thread stand	1

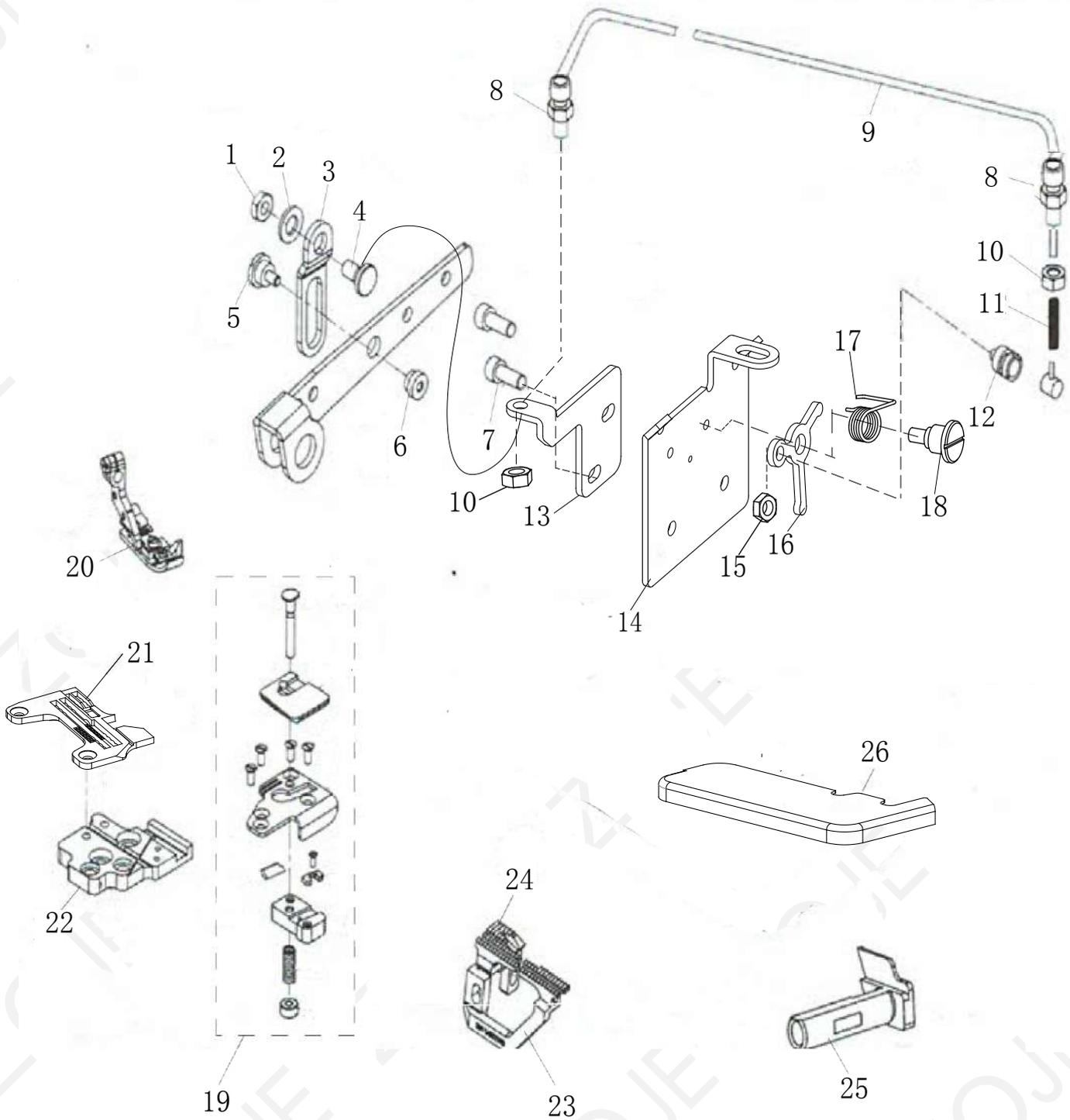
25. 针位组件(双链缝专用件)/Needle position assembly(Special for double chain sewing)



25. 针位组件(双链缝专用件)/Needle position assembly(Special for double chain sewing)

序号 No.	件号 Pars No.	名称	Description	数量 Number
1	10078002	针板组件 (双链缝长针板)	needle plate	1
2	10063916	压脚组件 (双链缝)	presser foot assembly	1
3	10003293	针夹头	needle holder	1
4	10063921	主送料牙组件 (双链缝)	main feed dog assembly	1
5	10063924	差动送料牙 (双链缝)	differential feed dog	1
6	10063927	链弯针	chain stitch looper	2
7	10063912	链弯针架	stand of chain stitch looper	1
8	10022620	螺钉	screw	1
9	10001033	螺钉M3×10	screw	1
10	10009310	螺钉	screw	1

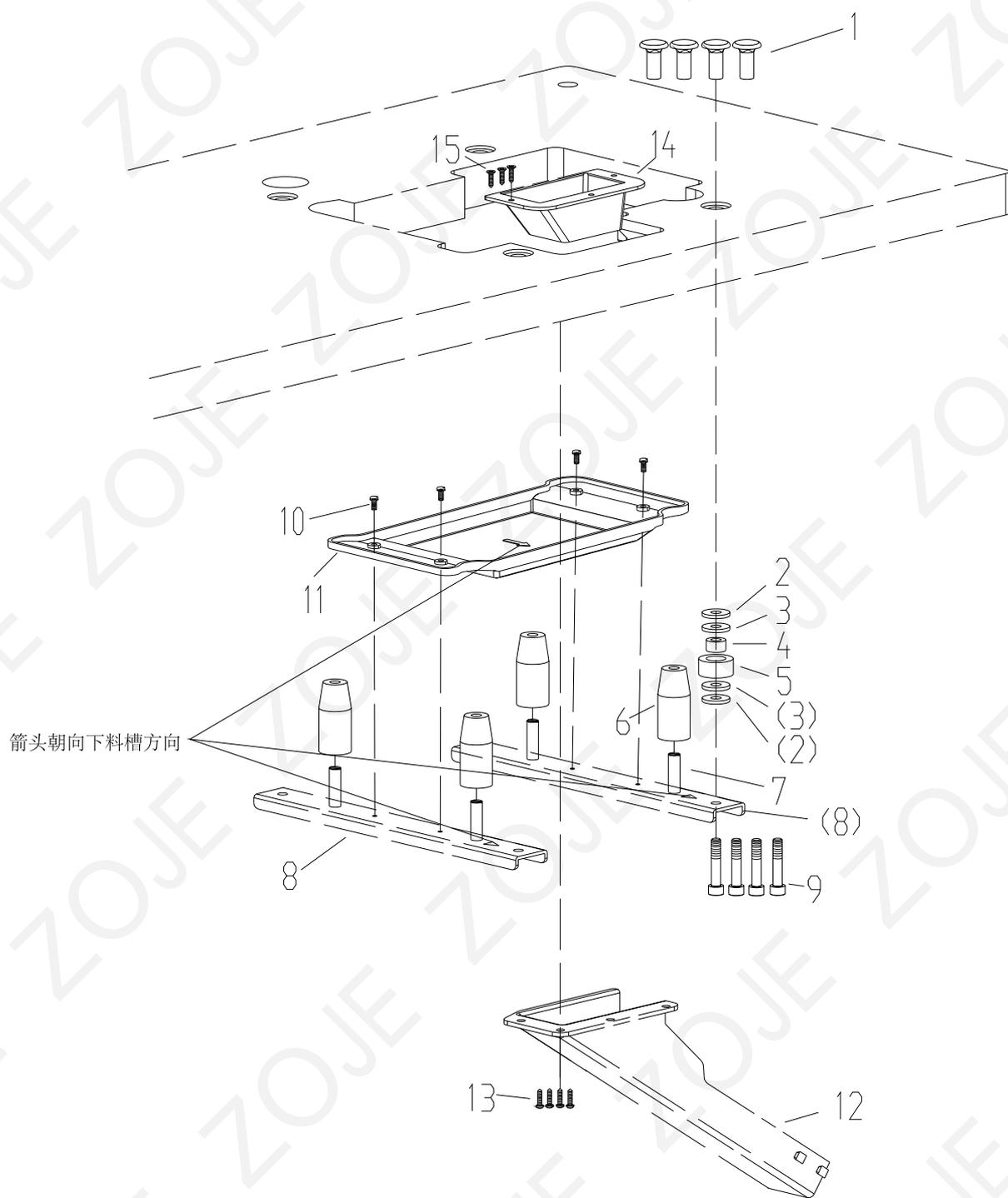
26. 倒回缝部件/Back Latch Components



26.倒回缝部件/Back Latch Components

序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	10012855	螺母M6×3.5	Nut M6×3.5	1
2	10012856	夹线器垫片	Washer	1
3	10012851	后连接板	Connecting plate	1
4	10012854	螺钉M6×9	Screw M6×9	1
5	10012818	螺钉	Screw	1
6	10012816	螺母M4×6	Nut M4×6	1
7	10009104	螺钉M4×9.5	Screw M4×9.5	2
8	10012849	螺钉M6×16.6	Screw M6×16.6	2
9	10068184	钢丝绳套	Steel wire rope sleeve	1
10	10012850	螺母M6	Nut M6	4
11	10012822	弹簧(倒回缝)	Spring	1
12	10012821	钢丝连接头槽	Steel wire connector groove	1
13	10023729	后固定板	Rear fixing plate	1
14	10064016	固定板	fixing plate	1
15	10003027	螺母M4	Nut M4	1
16	10012820	松线板	Thread tension plate	1
17	10012822	弹簧	Spring	1
18	10012817	螺钉	Screw	1
19	10072636	割线组件	Secant assembly	1
20	10009768	压脚组件(三线倒回缝)	Pressure foot form Pressure	1
	10071238	压脚组件(四线倒回缝)	foot form	1
21	10008252	针板(三线倒回缝)	Needle plate	1
	10008543	针板(四线倒回缝)	Needle plate	1
22	10008206	倒缝针板座	Reverse sewing needle plate seat	1
23	10073235	差动送料牙	Differential feeding tooth	1
24	10073232	主送料牙组件	Main feeder assembly	1
25	10009045	下刀架	Knife rack	1
26	10053174	大盖中组件	Middle assembly of large cover	1

27. 油盘托架/OIL TANK BRACKET



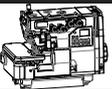
27. 油盘托架/OIL TANK BRACKET

序号 No.	件号 Parts No.	名称	Description	数量 QT.
1	10009596	螺套	bush with inner thread	4
2	10059968	塑料垫片	plastic mattress	8
3	10009272	垫圈	washer	8
4	10059967	橡胶垫钢圈	rubber cushion steel ring	4
5	10059966	橡胶垫	rubber blanket	4
6	10059964	托盘橡胶垫	pallet rubber mat	4
7	10059965	支柱	brace	4
8	10059963	托盘支架	the tray support	2
9	10003106	螺钉M8×45	screw M8×45	4
10	10009104	螺钉M4×9.5	screw M4×6	4
11	10085889	包缝托盘	tray	1
12	10033825	下料槽包装组件	the manger packing assembly	1
13	10004981	螺钉	screw	4
14	10033756	下料口	feed opening	1
15	10051357	螺钉M4.2×16	screw M4.2×16	3

规格件表 GAUGE PARTS LIST

							
MODEL	NEEDLE PLATE	MAIN FEED DOGASSY	DIFF. FEED DOG	PRESSER FOOT	UPPER LOOPER	LOWER LOOPER	CHAINSTITCH DOGASSY
机型	针板	主送料牙组	差动送料	压脚组件	上弯针	下弯针	链弯针
三线普通缝*	10061908	10009112	10009107	10009768	10009368	10008565	-
四线普通缝*	10058559	10009112	10009107	10054662	10009368	10008565	-
四线厚料缝*	10058558	10008662	10008566	10052572	10008633	10008565	-
五线普通缝*	10058560	10009767	10009288	10009289	10009368	10008565	10009304
五线宽边缝*	10061893	10009767	10009645	10009281	10009368	10008565	10009304
五线厚料缝*	10061901	10008572	10008569	10008646	10008602	10008565	10008612
六线普通缝*	10063700	10009767	10009645	10008167	10009368	10008565	10009304

规格件表 GAUGE PARTS LIST

							
MODEL	UPPER KNIFE	LOWER KNIFE	FRONT NEEDLE	REAR NEEDLE	NEEDLE HOLDER	NEEDLE	THREAD STAND PARTS
机型	上刀	下刀	前护针	后护针	针夹	机针	线架
三线普通缝*	10009611	10080426	10009377	10074020	10003434	DC×27#11	10008015
四线普通缝*	10009611	10080426	10009377	10074020	10009340	DC×27#11	10007906
四线厚料缝*	10009611	10080426	10009377	10074020	10009340	DC×27#11	10007906
五线普通缝*	10009611	10080426	10009637	10074020	10009284	DC×27#14	10004956
五线宽边缝*	10009611	10080426	10009637	10074020	10003293	DC×27#14	10004956
五线厚料缝*	10008556	10008604	10009637	10074020	10008549	DC×27#21	10004956
六线普通缝*	10009611	10080426	10009637	10074020	10008162	DC×27#11	10005969

注：上述规格表中的“*”代表“MD2”、“MED3”、“MPD3”、“ED”、“ED2”、“ED3”、“PD3”、“D3”、“SD3”、MD4、MPD4、MD5、MPD5 等机型