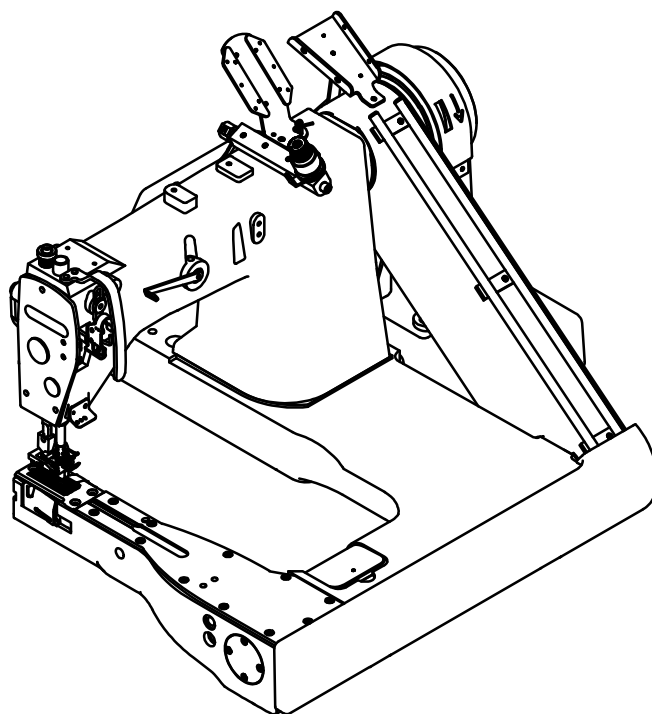


ZJ927/928

HIGH-SPEED FEED-OFF-THE-ARM CHAINSTITCH MACHINE SERIES



**V18.01 INSTRUCTION MANUAL AND
PARTS LIST**

INSTRUCTION MANUAL

SAFETY OPERATION

1、安全标志及其定义	
Safety symbols and definitions	1
2、警告牌及指示标识	
Warning label and show tag	1
3、安全措施的基本概念	
Basic concept for safety measures	2
1)、应用和目的	
Application and purpose	2
2)、工作环境	
Working environment	2
4、安全操作及其注意	
Safety operation and advert	3
1)、拆箱和运输	
Unpacking and transportation	3
2)、安装及准备	
Installation and preparation	3
3)、操作注意事项	
Operation advert item	3
4)、保养与检修	
Maintenance inspection and repair	4

INSTRUCTION MANUAL

1、警告牌及指示标识	
Warning label and show tag	5
1)、警告标识	
Warning symbol	5
2)、转向标识	
Direction of operation	5
3)、地线标识	
Earth wire symbol	5
4)、安全装置	
Safety devices	5
2、零部件名称	
Names of major parts	6
3、机器规格	
Machine Specification	6
4、台板与电机	
Work table and motor	7
1)、台板	
Work table	7
2)、电机与皮带	
Motor and V-belt	8
5、安装	
Installation	9
1)、机器安装简述	
Installation of sewing machine	9
2)、安装机头	
Installing the machine head	11

3)、地线连接	Ground wire connections	12
4)、安装皮带轮及护罩	Installing the pulley cover	12
5)、皮带松紧的调节	Belt tension adjustment	13
6)、线架的安装	Cotton stand	14
7)、安装皮带轮罩壳	Lubrication	14
8)、检测皮带轮转动的方向	Checking the machine pulley rotating direction	15
6、缝纫前的准备	Correct Operation	16
1)、针和线	Needles and Threads	16
2)、针的安装	Installing the Needles	16
3)、穿引下线	Threading the lower threads	17
4)、穿引上线	Threading the upper threads	17
7、缝纫	Sewing	18
8、缝制的调节	Thread Tension	19
1)、调节线的松紧	Adjusting the thread tension	19
2)、压脚压力调节	Presser Foot Pressure Adjustment	19
3)、调节缝迹的长度	Stitch Length Adjustment	20
9、清洗处理	Cleaning	22
1)、日常清洗	Daily cleaning	22
2)、润滑	Changing the lubrication oil	22
10、调节标准	Standard adjustments	23
1)、调节针杆	Needles bar height adjustment	24
2)、调节针和挑线叉	Needle and looper timing adjustment	25
3)、调节挑线叉和机针的间隙	Timing of loopers running clear of needles	26
4)、调节挡针块	Needle guard adjustment	27
5)、送料齿高度的调整	Feed dog height adjustment	28
6)、调整松线杆	Thread release lever adjustment	28
7)、调整上打线器	Upper thread take-up thread guide adjustment	29

8)、调整上线夹	
Upper thread nipper adjustment	29
9)、松线轴的调整	
Thread release shaft adjustment	30
10)、下打线器调整	
Lower thread take-up timing adjustment	30
11)、安装卷边器	
Installing the lapper	30
12)、拖轮高度的调节（配拖轮的机器）	
Puller height adjustment(Machines with puller)	31
13)、拖轮同步的调节（配拖轮的机器）	
Puller timing adjustment(Machines with puller)	31

安全手册

SAFETY OPERATION

1、安全标志及其定义

Safety symbols and definition



- (1)、警告、注意标志:操作机器时, 注意周边各相关部件或装置, 以避免由此部件或装置引起的损伤.

Warning、caution symbol:When you are operating the machine,please pay attention to the related parts or devices,to avoid get hurt by these parts or devices.



- (2)、警告、小心标志:机器操作时, 注意运动部件或装置, 避免手或其他人身部位受到损伤.

Warning、be careful symbol:When the machine is running,please pay attention to the moving parts or devices,to avoid the hands or body get hurt.



- (3)、接地线标志: 机器操作时, 确保与地线相连接.

Earth wire symbol:When the machine is running,please make sure the machine is connecting well with the earth wire.

2、警告牌及指示标识

Warning label and show tag



- (1)、护手装置: 机器操作时, 注意运动部件或装置, 避免手或其他人身部位受到损伤.

Finger guide:When the machine is running,please pay attention to the running parts or devices,to avoid the hands or body get hurt.



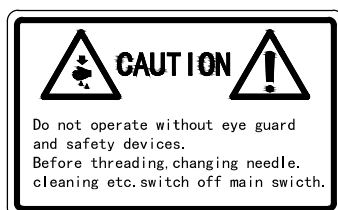
- (2)、地线标识: 确保地线接地良好, 以避免由于环境或其它因素产生的静电影响人身安全.

Earth wire symbol:Make sure the earth wire is connecting well,to avoid affect people's safety by environment or static from other factors.



- (3)、转向标识: 机器操作运转时确保机器正确的转向, 以避免由此引起的机器损坏.

Turning symbol:When the machine is running,please make sure the machine's running direction is correct,to avoid the machine get damage by this problem.



- (6)、警告标识: 机器操作运转时, 确保各 (如: 挡针板、皮带护罩、接地线等) 防护部件按装到位, 以保证人身安全.

Warning symbol:When the machine is running,please make sure (eg:needle guard、belt cover、earth wire ect.)the parts are in the correct places,to assure people's safety.

3、安全措施的基本概念

Basic concept for safety measures

1)、应用和目的

Application and purpose

本公司所开发的缝纫机是为提高缝制行业的生产效率，提升产品质量. 不推荐您使用与上述使用目的不相符合的缝纫机.

The industrial sewing machine developed by our company is for improving production's efficiency in sewing business,we don't recommend you to use the sewing machine which is not the same purpose for you sewing.

2)、工作环境

Working environment

(1) 不适合在温度与湿度较极端的工作环境.

The machine is not suitable for working in the extremely temperature and humidity environment.

(2) 不适合在户外，或光线照射较强的地方.

The machine is not suitable for working in outdoor,or the place where is strong sunlight.

(3) 不适合在带有灰尘，腐蚀性、放射性物质的环境中.

The machine is not suitable for working in the environment where is full of dust,or have causticity or radioactivity matter.

(4) 不适合在电压起伏超过上下10%幅度.

The machine is not suitable for working if the fluctuation of the voltage is exceed 10 %.

(5) 不符合马达规格标准的电压供电.

The machine is not suitable for working if the voltage not in accordance with the motor's standard.

(6) 不适合在高电流转换器，高频率焊机产生强电流、强磁声的区域内.

The machine is not suitable for working in the areas where is high electric current transducer,or strong electric current、strong magnetic-acoustic from high frequency soldering machine.

4、安全操作及其注意

Safety operation and advert

1)、拆箱和运输

Unpacking and transportation

- (1) 放置或转运时确认机器与向上标记摆放一致，拆箱时从箱子顶部打开.

When the machine is putting or transporting please make sure it is the same direction with the up sign, and unpacking the machine at the top of the carton.

- (2) 从箱子里取出机器时，不要用手握住靠针的部位.

When you are taking out the machine from the carton, please don't catch the place which is near of the needle by your hands.

- (3) 有车辆搬运时，切勿使机器遭受强烈震动或撞击.

Please don't let the machines get strong shock or hit when the machines are transporting.

2)、安装及准备

Installation and preparation

- (1) 确保台板安装坚固，避免台板在承重时由于安装不到位引起的状况.

Make sure the table is installed firmly, to avoid the table can't bear the weight because of the installation's mistake.

- (2) 安装摆放机器时，选择适当的光线与合理的摆设以保证舒适的工作环境.

Choose the proper sunlight place or reasonable place to installation the machine so make sure the environment comfortable.

- (3) 根据电机的使用说明来正确安装电机.

According the motor's instruction to install the motor.

- (4) 在未完成安装前，切勿触按电源.

If the installation is not completely finished, please don't connect the electric power.

- (5) 谨慎安装电线，连接好机器、电机和带电装置.

Install the wires carefully, and connect the machine, motor, and electrification devices well.

- (6) 不要在带电线路路上放置、施加任何物体.

Don't put anything on the electrification wires.

- (7) 电线需远离驱动器.

The wires should be far away from the drive.

- (8) 连接好接地线.

Connecting the earth wire well.

- (9) 对操作的员工需进行安全与技能方面的培训，以保证机器的正确使用与安全
的操作.

The operators should be get a safety and skilled training, to make sure the correct and safety operation.

3)、操作注意事项

Operation advert item

- (1) 切不可使润滑油、硅油等溅到眼睛.

The lubricant oil and silicon oil can not be spattered in the eyes.

- (2) 在添加润滑油时，应使用本机专用的润滑油.

Use the special lubricant oil when you are lubrication.

(3) 在接通电源时，切不可把手放到机器的运动部件上。

You can not put your hands in the moving parts when you want to turn on the electric power.

(4) 操作前确保机器转向与机器转向标志一致。

Make sure the machine's turning direction is the same with the turning direction sign before you operate.

(5) 如果机器配备了皮带护罩、挡针板等防护装置时，确保这些安全设备都已装配。

If the machine have belt cover、needle guard、ect please make sure they are all installed.

(6) 使用机器时，手指、头发等切勿靠近机针或其它运动部件。

Don't let your fingers、hair、ect near of the needle or moving parts when you are operating the machine.

(7) 穿线、换机针时，首先需关闭电源。

Turn off the electric power before you threading or changing the needle.

(8) 不使用机器时，一定要记得关闭电源。

Turn off the electric power when you don't need use the machine.

(9) 使用时，如遇到任何故障或有异常声响与气味，要立即切断电源。

When you are operating the machine,if the machine get any problems or unusual noise or strange smell,please turn off the electric power immediately.

4)、保养与检修

Maintenance inspection and repair

(1) 保证机器的维护与维修由专门的技术人员来完成。

Machine's maintenance inspection and repair should be finished by special technicians.

(2) 对机器的维护与维修必需在切断电源的状态下进行。

Turn off the electric power before to maintenance inspection and repair.

(3) 如果使用离合器马达，注意需将马达余电使用完后进行。

If use clutch motor,please make sure the motor's electricity is out.

(4) 维修过程中请使用指定本机专用零部件。

Use the special parts in your maintenance inspection and repair.

使用说明书 INSTRUCTION MANUEL

1、警告牌及指示标识

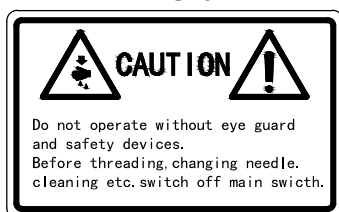
Warning label and show tag

使用机器时请遵循标识操作，若标识脱落或是难以识别，请及时与附近的经销商联系。

Please follow the instruction on the labels at all times when using the machine. if the labels have been removed or are difficult to read, please contact your nearest Brother dealer.

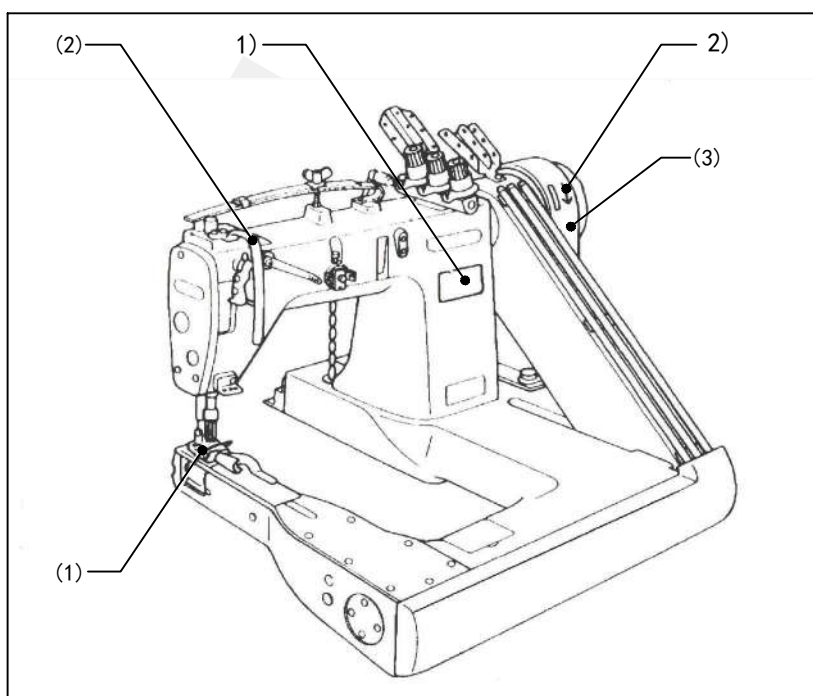
1)、警告标识

Warning symbol



2)、转向标识

Direction of operation



3)、地线标识

Earth wire symbol



4)、安全装置

Safety devices

(1) 护手装置

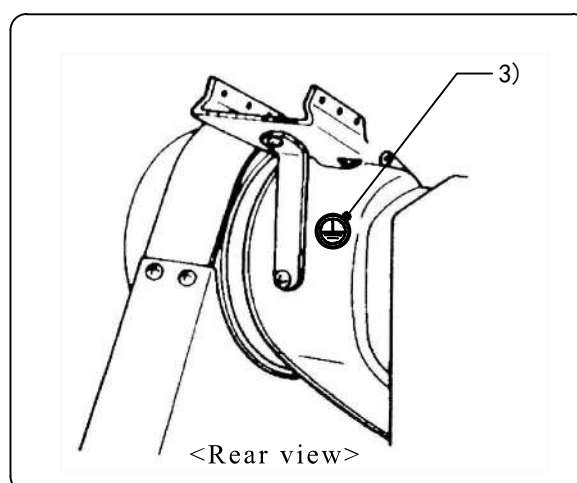
Finger guard

(2) 引线装置

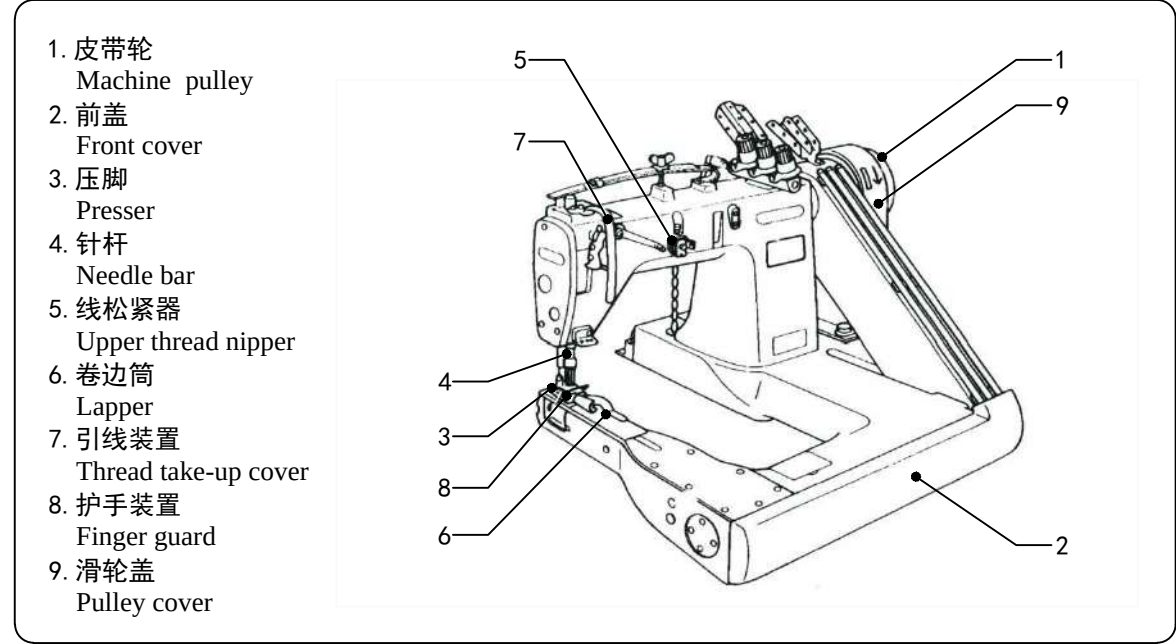
Thread take-up cover

(3) 皮带盖

Pulley cover, etc



2、零部件名称
Names of major parts



3、机器规格
Machine Specifications

性能规格 Specifications	机种分类 Type			
	双针薄料 Two Needles Thin Materials	双针中厚料 Two Needles Medium Materials	三针中厚料 Three Needles Medium Materials	三针厚料 Three Needles Heavy Materials
最高缝速（针/分） Max.sewing speed (spm)	3800	3800	3500	3500
最大线迹长度（mm） Max.stitch length (mm)	3.8	3.8	4.8	4.8
压脚膝提高度（mm） Feed dog lift height	≥10mm	≥10mm	≥10mm	≥10mm
缝制范围 Stitch Characteristic	薄料 Thin Materials	中厚料 Medium Materials	中厚料 Medium Materials	厚料、极厚料 Heavy Materials
采用机针 Needle	TVx64 14#	TVx64 18#	TVx5 18#	TVx5 21#
采用缝线规格 Thread Type	14 ~ 7.3 tex x 3 (42 ~ 80支/3股), 棉缝线或涤纶缝线			
针间距（标准） Needle gauge (Standard)	6.35mm	6.35mm	3.17mm	3.17mm
采用电机 Motor	2P/400W缝纫机专用电机 或 550W(伺服)直驱电机 2P/400W Motor OR 550W(Servo) Direct Drive Motor			

正常转速：双针 3200针/分 三针 3000针/分
Normal sewing speed (spm) : Two Needles 3200 Three Needles 3000

- | | |
|---|--------------------------|
| ① . 线架安装孔
Cotton stand Install Bore | ④ . 皮带槽
Belt Slot |
| ② . 电机安装孔
Motor stand Install Bore | ⑤ . 抬压脚链条孔
Chain bore |
| ③ . 机器侧面铰接固定孔
Machine connect stand Install bore | ⑥ . 线缆穿孔
Cable bore |

2)、电机与皮带
Motor and V-belt

⚠ 注 意 / CAUTION

- ❗ 所有与电机连接的电源插头要确保与其它任何移动物品保持至少25mm的距离。
All cords which are connected to the motor should be secured at least 25mm away from any moving parts.
- ⊘ 不能过于用力挤压插头，不能用铁制钩环固定电线、电缆，以避免引发火灾等事故。
Furthermore, do not excessively bend the cords or secure them too firmly with staples, otherwise there is the danger that fire or electric shocks could occur.
- ❗ 安装与使用电机相配的正确皮带盖。
Install the correct belt cover which corresponds to the motor being used.
- ❗ 请保证接地线的正确、有效连接，以避免电击事故的发生。
Be sure to connect the ground . if the ground connection is not secure , serious electric shocks will result.

(1) 正确选择电机.

Select the correct motor from those listed in the above table .

(2) 安装使用时，务必参照电机使用手册正确操作.

Refer to the instruction manual for the motor for details on installing and using the motor.

电 机 / Motor	
单相 两极 400W电机	Single-phase 2-pole , 400 W motor
三相 两极 400W电机	Three-phase 2-pole , 400 W motor
(伺服) 直驱电机 550W	(Servo) Direct Drive Motor 550W

(3) 电机动力与V型带

Motor pulley and V-belt

动力O. D. /Pulley O.D	85	90	95	100	105	110	115	120	125	130
皮带的尺寸 (英寸) Belt size (inches)	← M45 →			← M46 →				← M47 →		
缝速 (分/转)	50HZ				3100			3600		4000
Sewing speed (spm)	60HZ	3100			3600		4000			

(4) 皮带为M类V型带

The belt should be an M-type V-belt.

5、安装 Installation

1)、机器安装简述

Installation of sewing machine

- (1) 用附件里面两组M12的螺钉、垫片，把滑轮基座与机器相联接。

Use two sets of bolt of M12, mat slice of the inside of the enclosure, the pulley base and the machine mutually allied connect .

- (2) 将三件圆柱形减震橡胶垫塞入机器底座内，再将机器置于台板上。

Reduce three cylinder form earthquake rubber mat to stuff into a machine base, place machine again at the bedplate.

- (3) 用附件里面的三套角铁、螺钉支架按图示将机器固定在台板上。

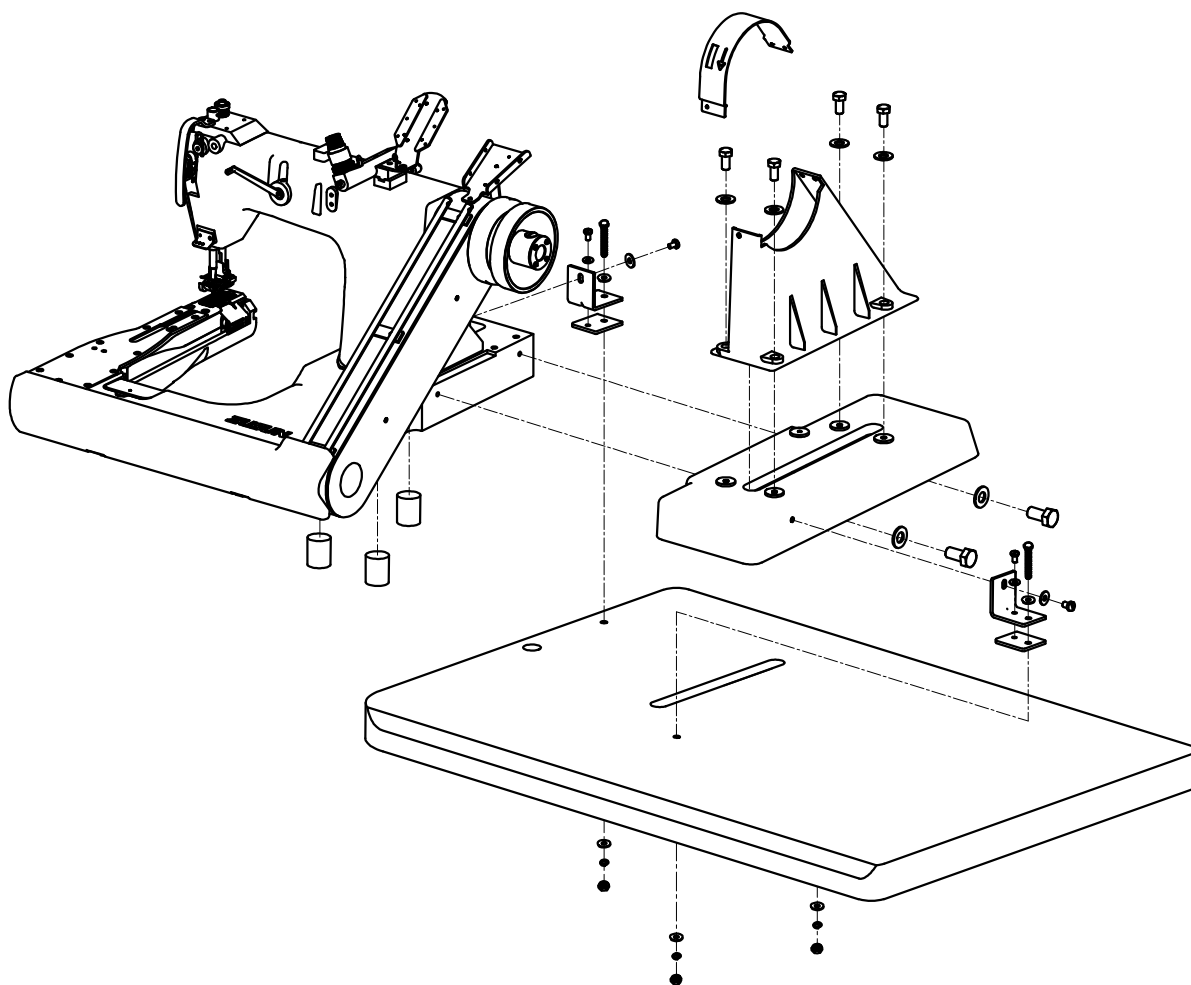
Three sets of Cape iron, bolt support used the inside of the enclosure press the diagram to show machine fix on the bedplate.

- (4) 按图示将皮带护罩固定在滑轮基座上。

Press the diagram to show to protect leather belt to place fix on the pulley base.

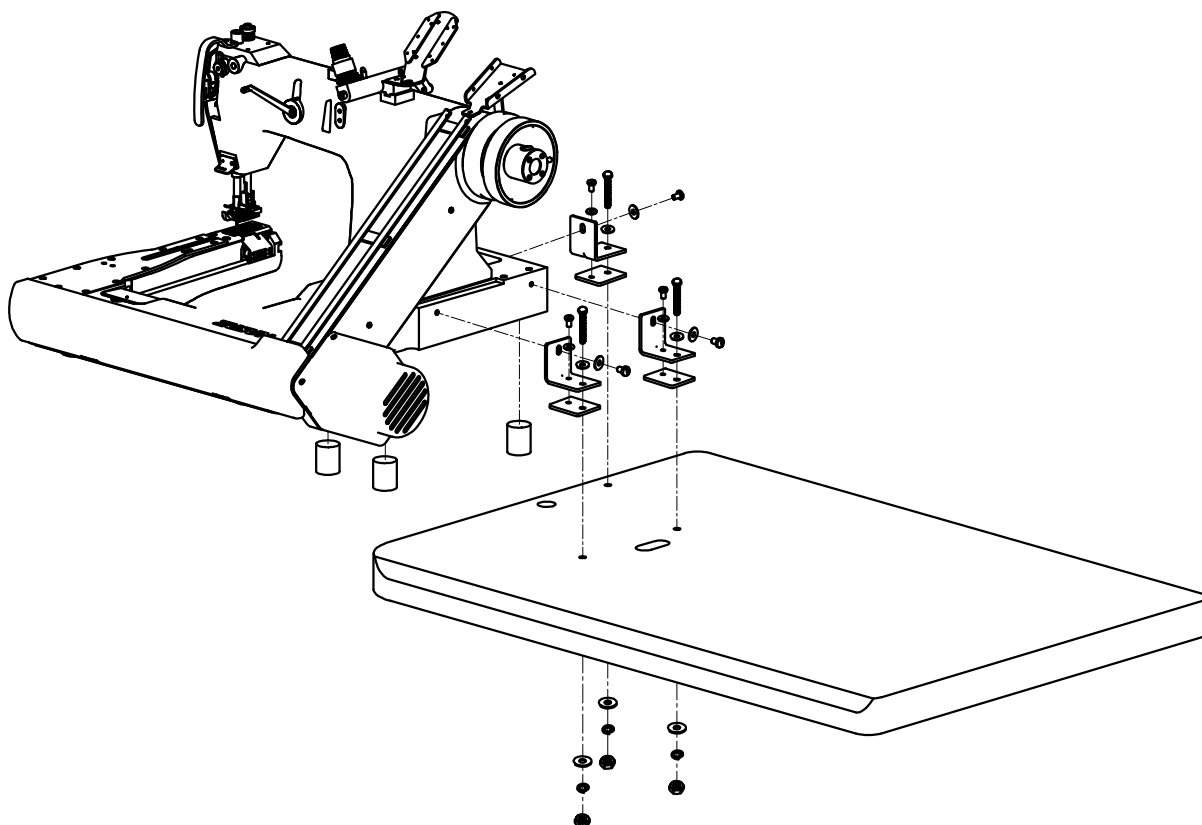
- (5) 机器固定安装时确保电机皮带轮与机器滑轮尽量平行，且无明显偏差。

Assuer the motor belt orller and machine roller in a same lever when fixing the machine.



普通曲腕机机器台板按装示意图

The common machine bedplate press to pack sketch map

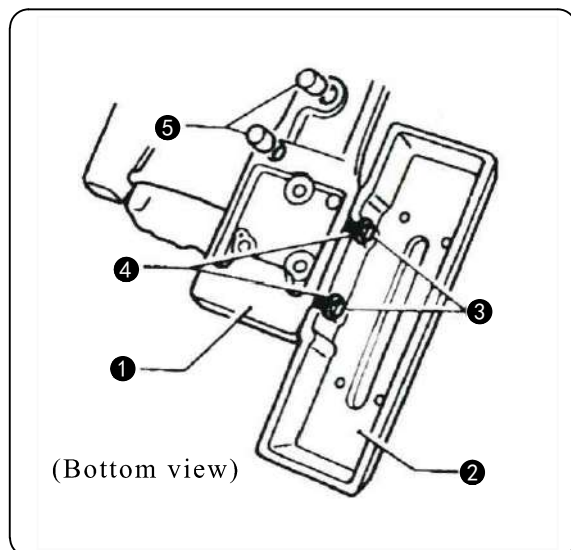


(伺服)直驱曲腕机器台板按装示意图
(Servo) Direct Drive machine bedplate press to pack sketch map

⚠ 注意 / CAUTION

- ⊘ 需由专业技术人员安装机器。
The sewing machine should only be installed by a qualified technician.
- ❗ 安装布置电线、电缆时需向附近的经销商或电工咨询有关线路的安置问题。
Ask your Brother dealer or a qualified electrician for any electrical work that may need to be done.
- ❗ 由于机器质量较重，安装时务必要两人以上共同作业。
The sewing machine weighs more than 49 kg. The installation should be carried out by two or more people.
- ❗ 安装完毕后，确认电气线路的安全及机器各运动零部件无干涉或阻碍运动的物体。
Do not connect the power cord until installation is complete, otherwise the machine will operate if the treadle is pressed by mistake, which could result in injury.
- ⚡ 确保地线的正确、有效连接，以避免可能引发的电击事故。
Be sure to connect the ground . if the ground connection is not secure , serious electric shocks will result.
- ❗ 确保皮带护罩、滑轮罩壳的安装。
Install the pulley cover to the machine head.

2)、安装机头 Installing the machine head

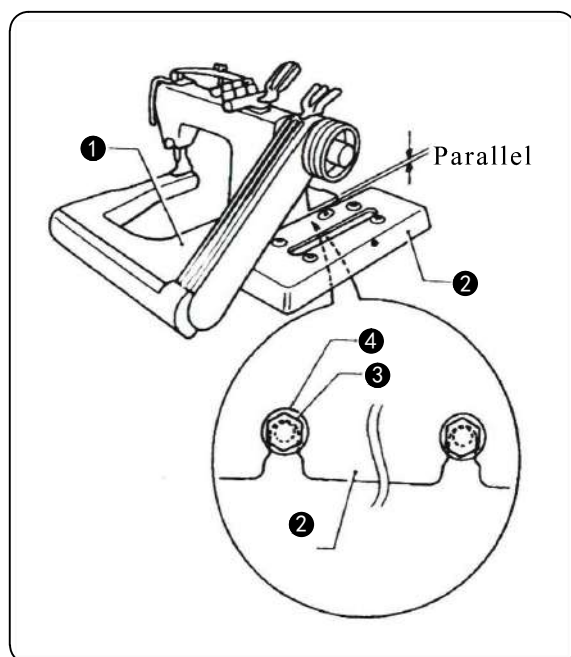


- (1) 机座①与滑轮基座②拼接，拧上六角头螺栓③(两件)，螺栓上放置平垫圈④(两件)。

Install pulley cover base ② on machine bed ① with two hexagonal bolts ③ and two washers ④.

- (2) 机座底部塞上减震橡胶塞⑤。

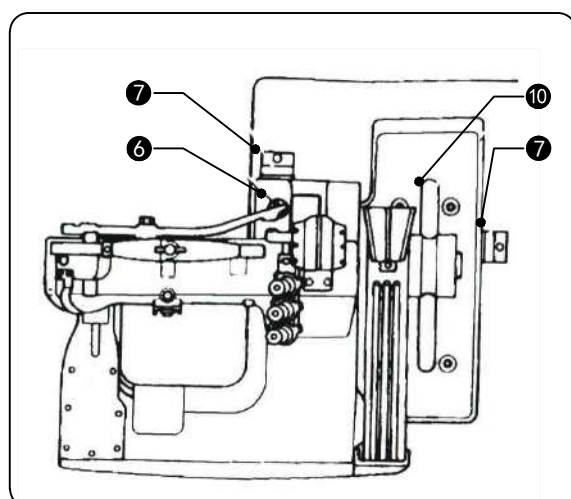
Insert two bar cushioners ⑤ into the bottom of the bed.



- * 将六角螺栓③拧紧，检查滑轮基座②是否与机器底座①平行。

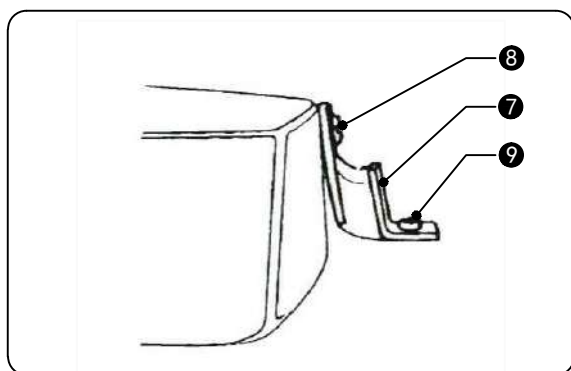
At this time, install the two hexagonal bolts ③ so that they go as far as possible into the notches in the pulley cover base ②.

Furthermore, check that the pulley cover base ② is parallel to the bed. (if it is not parallel, the pulley cover may touch the machine pulley.)



- (3) 将机头放置在台板上，向前后方面调整机器的位置使其位置与抬压杆链条⑥及皮带安装孔⑩协调。

Place the machine head on table. adjust its position in forward and backward directions by aligning it with the hole for presser bar lifter chain ⑥, and in sidewise directions by aligning it with belt hole ⑩.



(4) 机器底座塞上减震橡胶塞，安装好皮带护罩后，把机器固定在台板上。

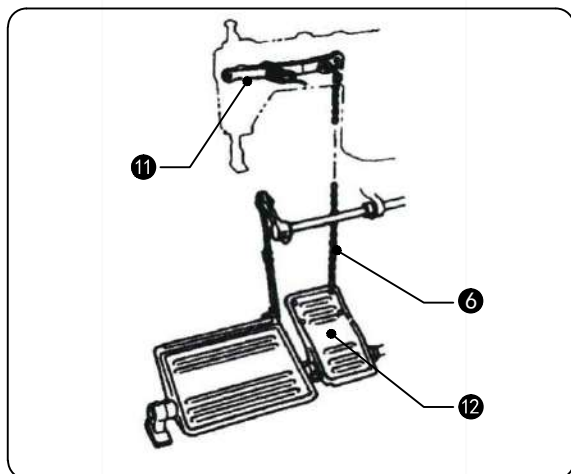
After fastening cushions 7 to the machine bed and pulley cover base with set screws 8, fix them to the table with screws 9.

* 安装机器及台板时，使机器尽可能保持水平状态。

若机器不能水平放置，可能会使润滑油达不到运动部件，影响机器润滑。

Place the work table so that the machine head is horizontal.

If the machine head is not horizontal, lubrication will not be carried out correctly.

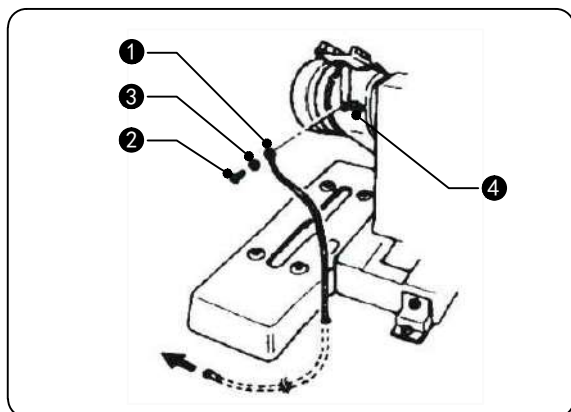


(5) 连接好抬压脚链条 6、压杆 11 及脚踏板 12

Connect the presser bar lifter chain 6 to the knee lifer lever 11 and the presser lifter pedal 12.

3)、地线连接

Ground wire connections



(1) 按照图示位置正确的连接地线与电机。

Connect the ground wire to the sewing machine head and motor.

(Use the correct type of ground wire and washer)

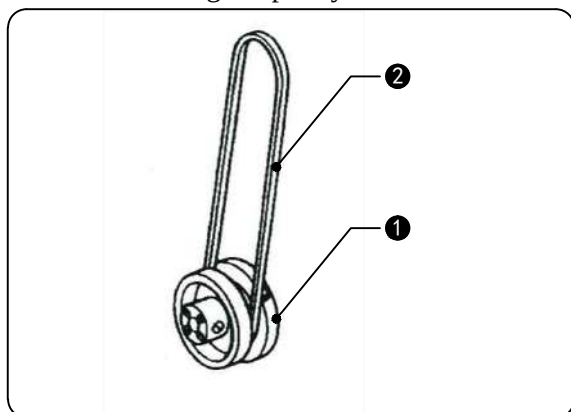
Remove lower thread guide holder screw 2.

Secure the ground wire 1 to the sewing machine head with screw 2 and washer 3. Pass the ground wire 1 through the hole in the table.

Connect the ground wire 1 to the motor in accordance with the instructions in the instruction manual for the motor.

4)、安装皮带轮及护罩

Installing the pulley cover

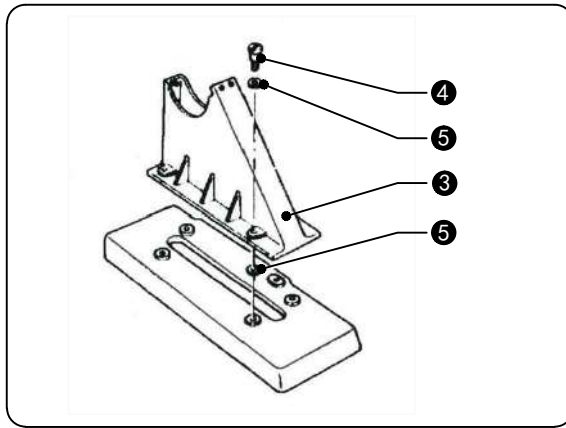


(1) 把皮带装在皮带轮上。

Place the belt 2 onto the machine pulley 1.

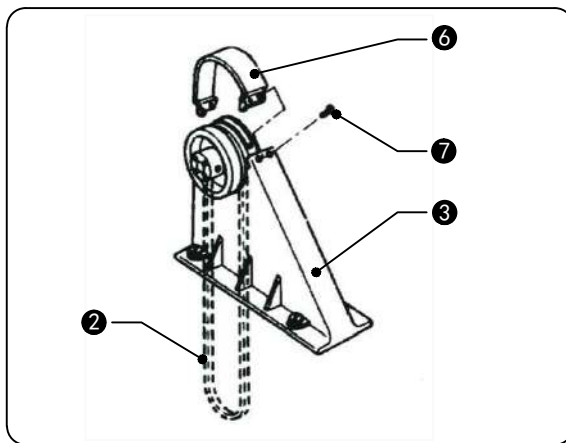
* 安装时，皮带朝上方拉。

Pull the belt 2 upward when installing pulley cover A 3.



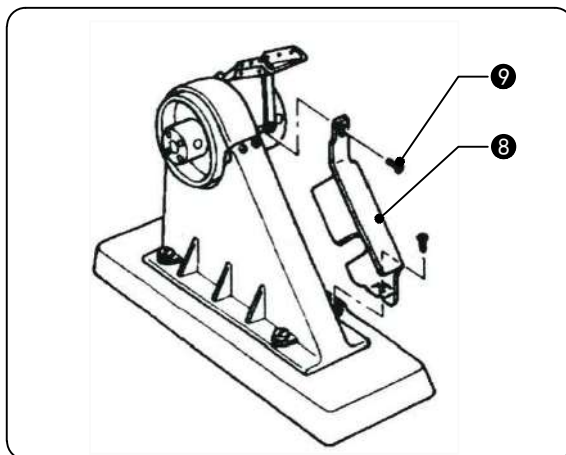
(2) 安装皮带护罩 ③, 旋上螺丝 ④

Place pulley cover A ③ so that it is in between the eight pulley cover seats ⑤, and then secure it to the pulley cover base with the four screws ④.



(3) 把皮带向下拉, 安装上皮带护罩板 ⑥

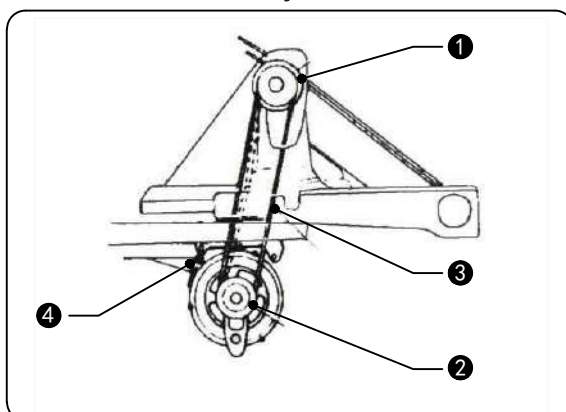
Push the belt ② downward, and then install pulley cover B ⑥ to pulley cover A ③ with the three screws ⑦.



(4) 若机器配有变速器皮带护罩 ⑧附件, 安装上变速器皮带护罩 ⑧, 旋上螺丝 ⑨

If the machine is being used with the puller attached, install the puller belt cover ⑧ with the two screws ⑨.

5)、皮带松紧的调节
Belt tension adjustment



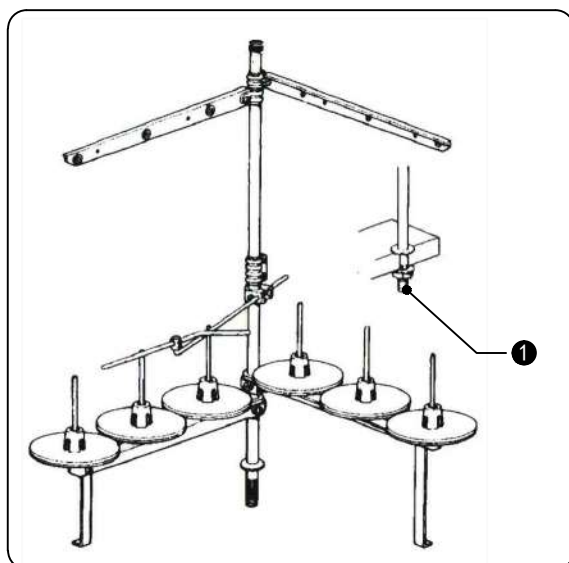
(1) 安装V型带 ③于电机皮带轮 ②与机器皮带轮 ①之间.

Place the V-belt ③ onto the motor pulley ②.

(2) 调节电机上下调整螺母 ④, 使以10N的力在皮带的中间按下, V型带产生约20mm-30mm的间距.

Turn the two nuts ④ to adjust so that there is 20 ~ 30mm of deflection in the V-belt ③ when it is pressed at the midway point with a force of 9.8 N (1kgf).

6)、线架的安装 Cotton stand



- (1) 按照线架组装说明书组装好线架.

Assemble the cotton stand while referring to the cotton stand instruction manual.

- (2) 把线架安装在台板线架固孔上 ①

Install the cotton stand to the cotton stand mounting hole in the work table with nut ①.

7)、安装皮带轮罩壳 Lubrication

⚠ 注 意 / CAUTION

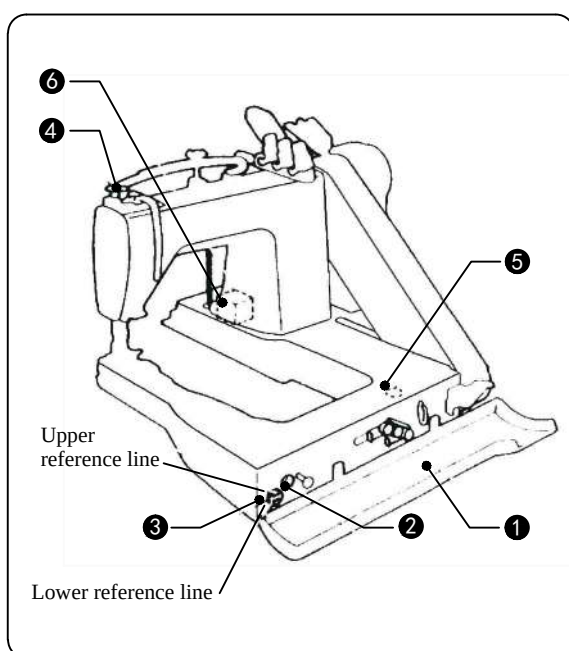
- ⊘ 加油时，务必带上护目镜和手套，以免油不慎掉入眼睛或是沾到皮肤，而造成伤害。
Be sure to wear protective goggles and gloves when handling the lubricating oil gets into your eyes or onto your skin, otherwise inflammation can result.

在任何情况下，切勿饮用润滑油，否则会导致呕吐和腹泻。

Furthermore, do not drink the oil under any circumstances, as it can cause vomiting and diarrhoea.

润滑油要放在儿童够不到的地方。

Keep the oil out of the reach of children.



- * 需定期给机器加润滑油，在机器使用或不使用时，都要保持其有一定的油量，使其在使用时能更好的润滑。

The sewing machine should always be lubricated and the oil supply replenished before it is used for the first time, and also after long periods of non-use.

- * 请使用推荐的润滑油。

Use only the lubricating oil (Nisseki Sewing Lube 15) specified by Brother.

- (1) 打开前盖，取下橡胶塞，往机体里面加注润滑油，直至油量达到油箱指示标签。

Open the front cover ①, remove the rubber plug ②, and then fill with oil until the oil level reaches the point in between the reference lines on the oil gauge ③.

* 若油量低于指示标签，请务必再往机体内加注润滑油。

Use only the lubricating oil

(2) 塞上橡胶塞 ②，盖上前盖 ①。

Insert the rubber plug ② and then close the front cover ①.

(3) 每周向针柱架的孔内加1至2滴的润滑油。

Add 1-2 drops of oil once a week to needle bar bracket lubrication hole ④.

(4) 定期旋开机器底座下的排油螺丝，排掉机座内的污油，排完后旋上螺丝。

Periodically loose the oil drain screw ⑤ to drain out any oil which collects the front bed oil sump. After draining the oil, tighten the oil drain screw ⑤.

(5) 定期用干净的布清除后机座的油。

Periodically wipe away any oil which collects in the rear bed oil sump ⑥ with a cloth.

(6) 转动机器皮带轮，使油孔朝上，旋开加油螺钉，加油，请保持油量在中线位置附近。

Turn the machine pulley, so that the oil hole cover ⑦ is facing upward, and then remove the oil hole cover ⑦ and fill the oil tank ⑧ with oil.

(7) 旋上加油螺钉 ⑪。

Attach the oil hole cover ⑪.

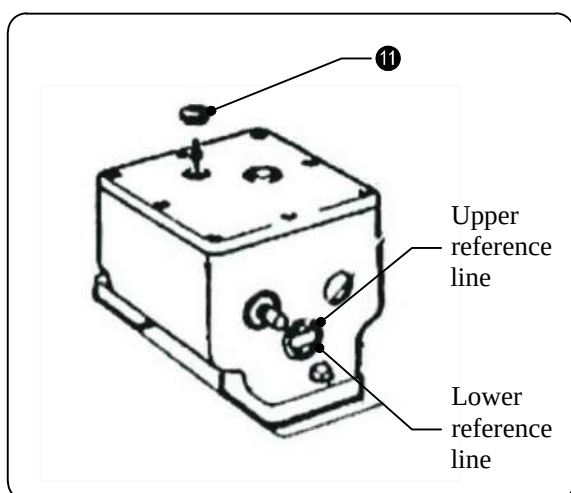
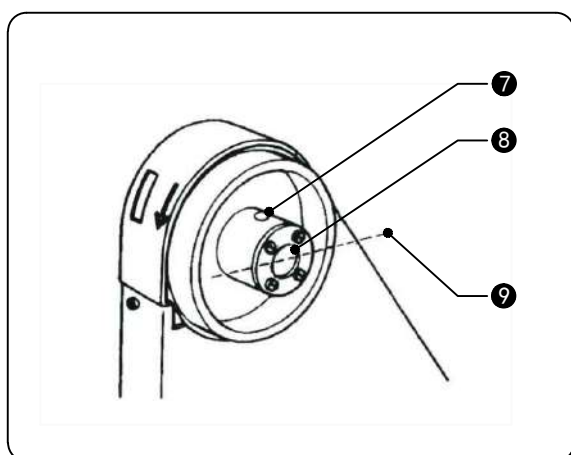
* 若是机器配有变速器，旋开变速器顶部加油螺丝，加油至油量标尺的上标线位置。

If the machine is being used with the puller attached, remove the cover screws and fill with oil until the level reaches the upper reference line in the oil sight glass.

* 若是油量低于下标线，务必再加油完毕后，旋上加油螺丝 ⑪。

If the oil level drops to the lower reference line, be sure to add more oil.

After lubrication is completed, tighten the cover screws ⑪.



8)、检测皮带轮转动的方向

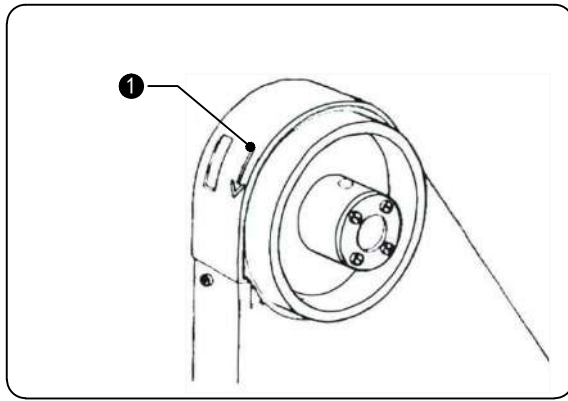
Checking the machine pulley rotating direction



注 意 / CAUTION



缝纫时，请不要触摸运动零部件或替换机器零部件，以免造成人身伤害或机器损坏。
Do not touch any of the moving parts or place any objects against the machine while sewing, as this may result in personal injury or damage to the machine.



- (1) 插好电源，开启开关，轻踩下踏板，查看皮带轮的转动方向 ①。
Insert the power cord plug into the wall outlet, and then turn on the power switch.

* 若是皮带轮反向转动，请按照电机说明书重新安装电机。

If the direction of rotation is reversed, change the direction of rotation to the correct direction while referring to the instruction manual for the motor.

- (2) 在前3-4天的使用中，不要使机器运转转速高于2500spm。

For the first 3-4 days of use, do not run the machine at 500 spm lower than the usual speed. This will help contribute to a longer service life for the machine.

6、缝纫前的准备

Correct Operation

1)、针和线

Needles and Threads

针和线的使用根据缝料而定，请正确使用。

The needle and threads to be used vary depending on sewing conditions. Select the correct ones by referring to the table below.

针/Needle	线/Thread	
	上线/Upper thread	下线/Lower thread
14#	纱线#50	纱线#60
18#	纱线#30	纱线#50
21#	纱线#20	纱线#30

2)、针的安装

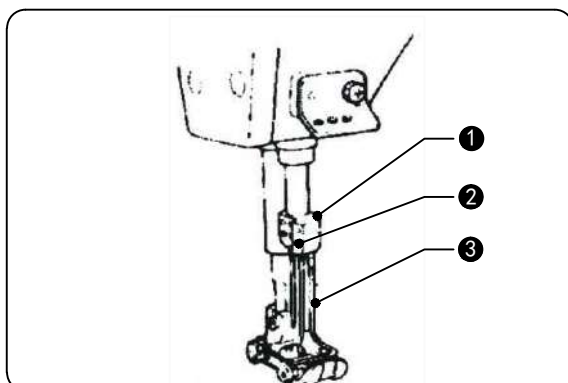
Installing the Needles

⚠ 注意 / CAUTION



安装机针前，先关闭电源，以免可能会因误踩脚踏板而造成伤害。

Turn off the power switch before installing the needle, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury.



- (1) 转动皮带轮直至针夹 ①到达最高点。

Turn the pulley until needle holder ① is raised to the highest position.

- (2) 松开机针紧定螺钉 ②，把机针 ③塞入针夹 ① 的针孔，旋紧紧定螺钉 ②。

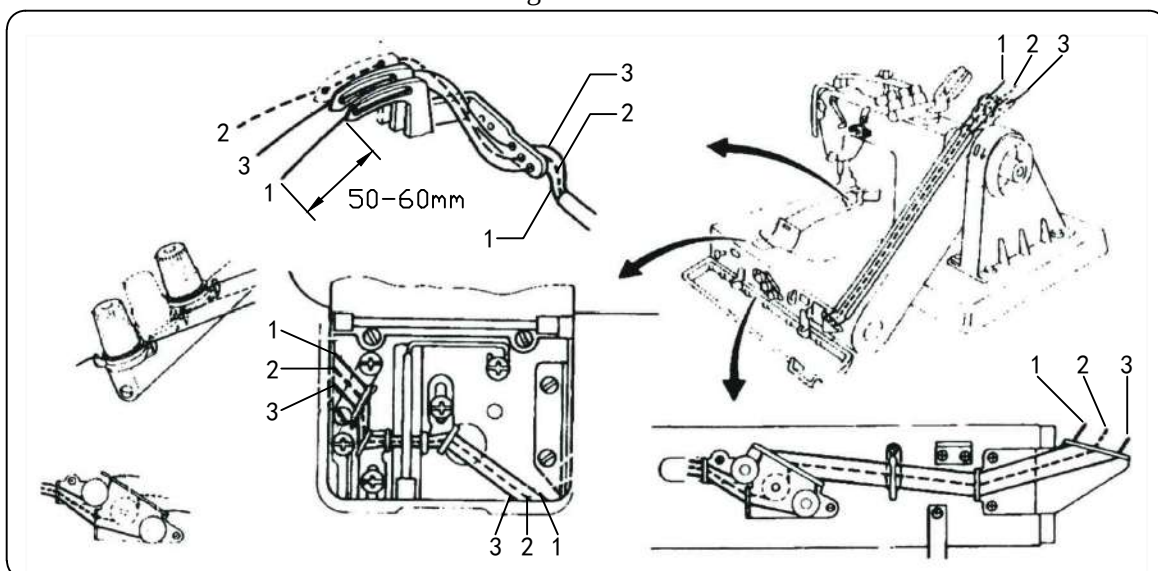
Loosen needle set screws ②, hold needles ③ with their long grooved side facing front, insert them into needle holder ① all the way, and fasten the needle with needle set screws.

3)、穿引下线 Threading the lower threads

⚠ 注意 / CAUTION

⚠ 穿线时，先关闭电源，以免机器可能在不慎情况下开启，造成伤害。
Turn off the power switch before threading the upper thread, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury.

按照下图的指示穿线
Pass the lower threads as shown in the figure below.

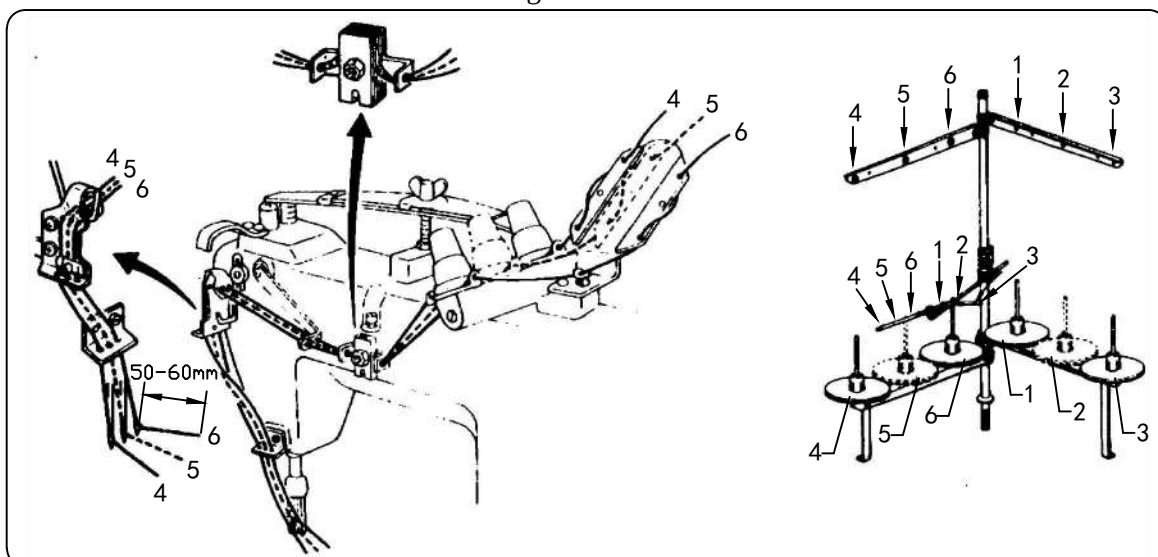


4)、穿引上线 Threading the upper threads

⚠ 注意 / CAUTION

⚠ 穿线时，先关闭电源，以免机器可能在不慎情况下开启，造成伤害。
Turn off the power switch before threading the upper thread, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury.

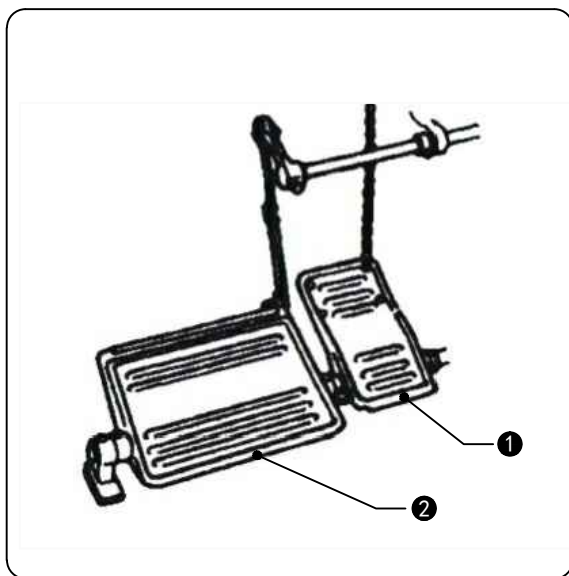
按照下图的指示穿线
Pass the lower threads as shown in the figure below.



7、缝纫 Sewing

注 意 / CAUTION

-  务必在使用前安装好所有的安全装置，以免造成伤害。
Attach all safety devices before using the sewing machine. if the machine is used without these devices attached, injury may result.
-  务必在下面的操作中切断电源，以免不慎操作，造成伤害。
Turn off the power switch at the following times, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury.
- 穿线时。
When threading the needle.
- 换针时。
When replacing the needle.
- 人离开时。
When not using the machine and when leaving the machine unattended.
-  缝纫时，请不要触摸移动件或替换零部件，以免造成人身伤害或是机器损坏。
Turn off the power switch before threading the upper thread, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury.



- (1) 踩下抬压脚踏板 ① 抬起压脚，把缝制件放在压脚下，松开抬压脚踏板。

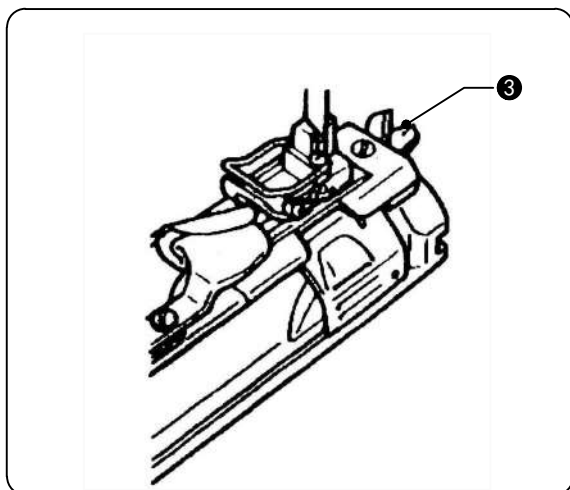
Switch the power on, step down on presser for lifter pedal ①, place a fabric under presser foot, and release presser foot lifter pedal ①.

- (2) 踩下电机踏板 ②，机器开始运行。

Depress treadle ② to start the machine.

- (3) 缝制结束后，剪断缝线。

After sewing the work, keep sewing until it reaches thread cutter ③, and then cut the threads with thread cutter ③.

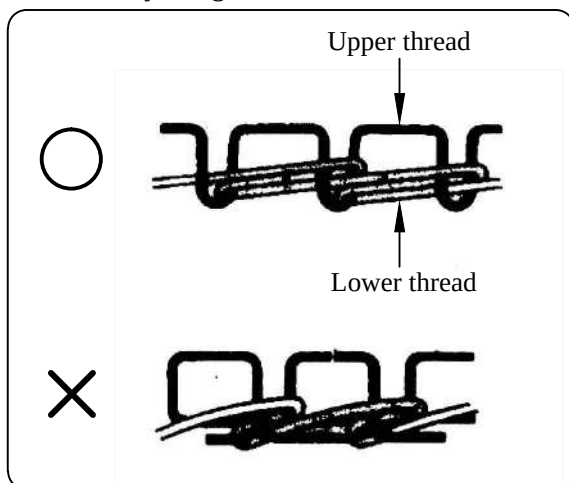


8、缝制的调节

Thread Tension

1)、调节线的松紧

Adjusting the thread tension

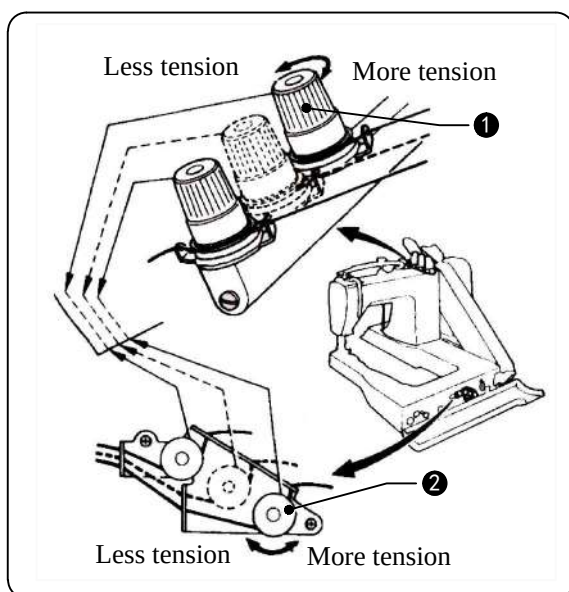


正确的缝迹/Good stitches

过松的缝迹/Loose , bad stitches

* 根据不同的缝制面料，需要调整面线、底线的松紧，以达到最佳的缝制效果。

Thread tension differs with sewing conditions.Adjust it to suit your particular sewing conditions



(1) 旋转上夹线器组件螺母，调节上线松紧。

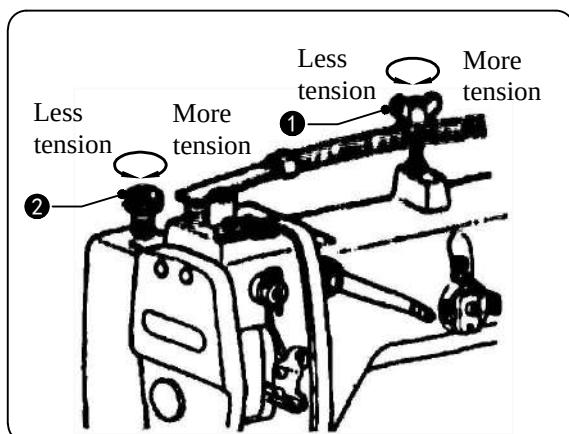
Adjust the upper thread tension properly by turning upper thread adjusting screw ①.

(2) 旋转下夹线器组件螺母，调节下线松紧。

Adjust the lower thread tension properly by turning lower thread adjusting screw ②.

2)、压脚压力调节

Presser Foot Pressure Adjustment



(1) 通过旋转调节螺母 ①，调整压脚的压力，使压力满足合理的缝制作业要求。

Adjust the presser foot pressure by turning wing nut ① to such a level that it is just enough to keep the work from slipping .

(2) 若机器配有辅助拖轮，拖轮的压力可以通过调节螺母 ② 进行调节。

In case of Model - SP and - PL , the puller pressure can be adjusted as appropriate to the work by loosening adjusting thumb-screw nut ② .

3)、调节缝迹的长度 Stitch Length Adjustment

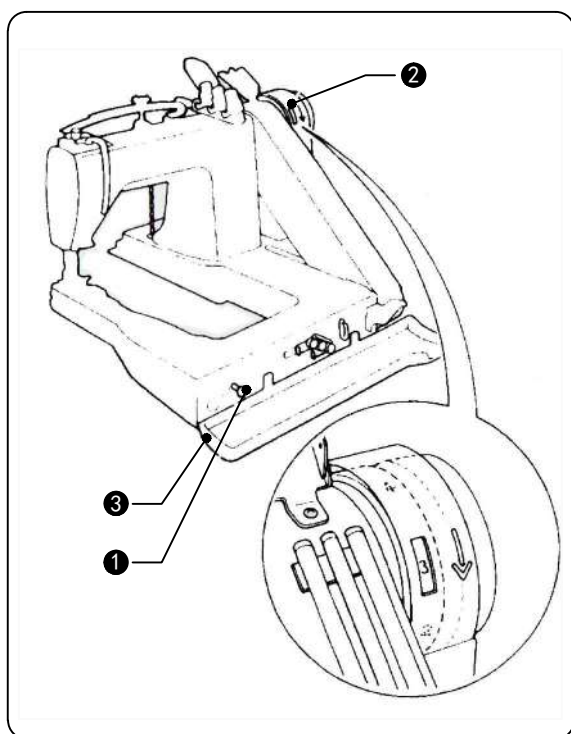
注 意 / CAUTION



调节缝迹长度时，先关闭电源，以免机器可能在不慎情况下开启，造成伤害。
关闭电源后，需确定电机完全处于停止状态，方可进行调节操作。

Turn off the power supply before adjusting the stitch length, otherwise the machine will operate if the treadle is pressed by mistake, which could result in injury. However the motor will keep turning even after the power is switched off as a result of the motor's inertia.

Wait until the motor stops fully before starting work.



* 机器皮带轮上显示的数字表示缝迹的长短，按照缝制的要求，可以调整缝迹的长度。
The numerals on the machine pulley scale represent the stitch length(mm) however the actual stitch length will vary depending on the type and thickness of material being used.

(1) 打开前盖 ③.

Open the front cover ③.

(2) 按下缝迹宽度调节钮 ①后，按箭头指示方向慢慢转动皮带轮。

While pressing the feed adjustment button ①, turn the machine pulley toward you slowly, (The feed adjustment button ① will move further inward.)

(3) 转到要求的数字，此时，数字对准皮带轮上盖的窗口 ②。

While still pressing the feed adjustment button ①, keep turning the machine pulley until the desired numeral appears in the center of the pulley cover windows ②.

* 数字越大，缝迹越长。松开调节按钮（确保调节按钮复位）

The higher the value of the numeral, the larger the stitch length becomes.

Release the feed adjustment button ①.

(Check that the feed adjustment button ① pops back out again.)

(4) 盖上前盖。

Close the front cover.

注意：

NOTE:

务必在机器完全停止运行后，按下缝迹调节钮，否则可能损坏机器零部件。

Do not press the feed adjustment button while the machine is operating, as doing so may damage the machine parts.

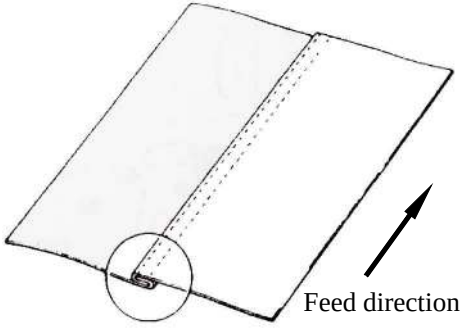
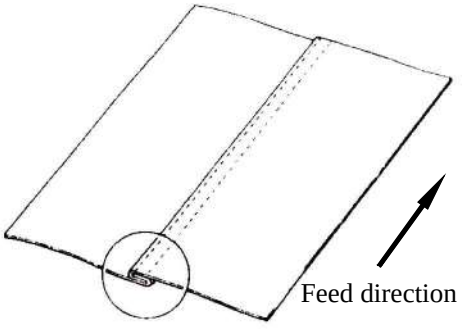
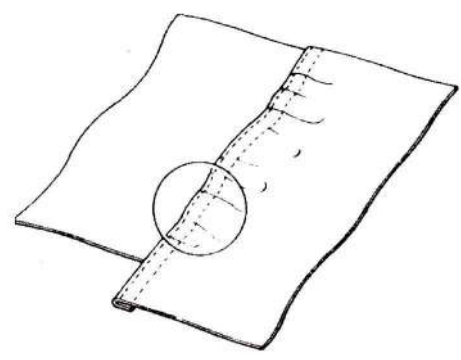
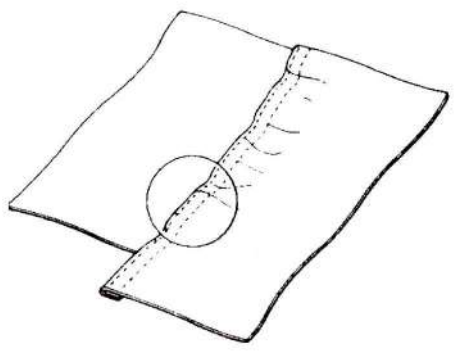
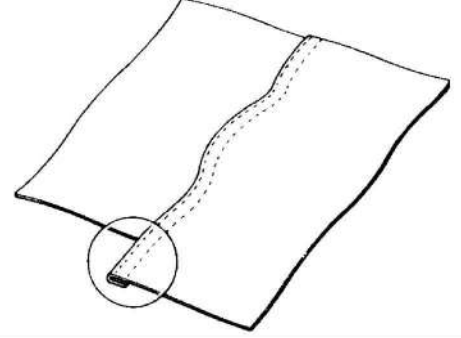
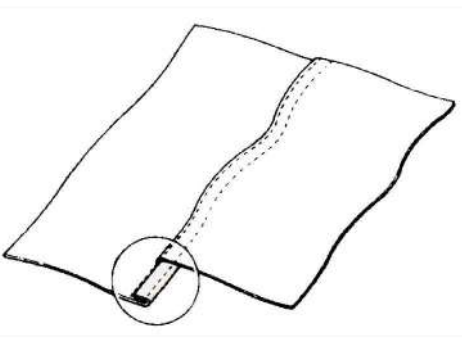
当把数字调到最大时，必须调节挡针块，使其与机针保持规定的间距。

When sewing with the stitch length set close to the maximum length, you will need to adjust the needle guard in accordance with the type of material and the type of thread being used.

* 以下表格是在调整托轮装置时所涉及到有弹性织物和低弹性织物的这示例图。

The table below shows samples of stitches made with a highly elastic fabric and a fabric which is not so elastic.

Adjust the puller feed by referring to this table.

调整拖轮装置 Puller feed	有弹性织物 Fabric with high elasticity	低弹性织物 Fabric with low elasticity
正 确 Correct	 线迹直而且没有打皱 Neither non-alignment not sewing wrinkles	 线迹直而且没有打皱 Neither non-alignment not sewing wrinkles
过 松 Insufficient	 线迹弯曲而且打皱 Non-alignment and wrinkles	 线迹弯曲而且打皱 Non-alignment and wrinkles
过 紧 Excessive	 线迹扭曲成波浪形 Non-alignment and very wavy	 线迹扭曲成波浪形 Non-alignment and very wavy

9、清洗处理

Cleaning

* 为了维护机器的性能和确保机器的使用寿命, 必需每天执行以下清洗操作.

The following cleaning operations should be carried out each day in order to intain the performance of this machine and to ensure a long service life.

⚠ 注 意 / CAUTION

⚠ 清洗之前必须拔掉电源, 在电源关掉后由于惯性的结果, 电机继续转动, 必须等到电机完全停止后才能开始清洗工作, 机器在运转中如果踏板误踩, 可能会导致意外伤害.

Turn off the power switch before carring out cleaning. The motor will keep turning even after the power is switched off as a result of the motor's inertia. Wait until the motor stops fully before starting work.

The machine may operate if the treadle is pressed by mistake, which could result in injury.

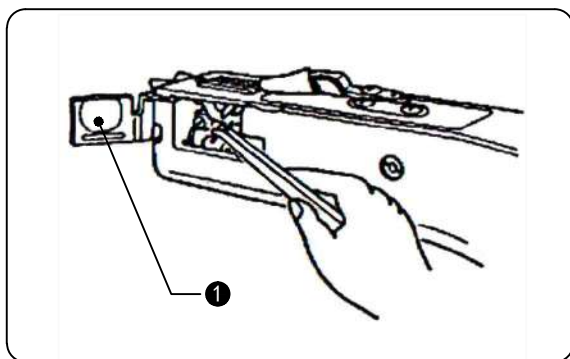
⊘ 确保在处理润滑油的时候带上防目镜和手套, 以防止油进入眼睛和皮肤而出现症状. 在任何情况下不能饮用此类润滑油, 以免导致呕吐和腹泻. 谨记此类润滑油要放在儿童够不着的地方.

Be sure to wear protective goggles and gloves when handling the lubricating oil, so that no oil gets into your eyes or onto your skin, otherwise inflammation can result. Furthermore, do not drink the oil under any circumstances, as it can cause vomiting and diarrhoea.

Keep the oil out of the reach of children.

1)、日常清洗

Daily cleaning



(1) 打开挑线叉盖 ①, 把里面的残留的线屑或杂物清洗出来.

Open the looper side plate and clean away any thread scraps and other rubbish.

(2) 清洗完毕后, 关闭挑线叉盖.

After cleaning, close the looper side plate ①.

(3) 检查

Checking

检查线是否已正确穿引.

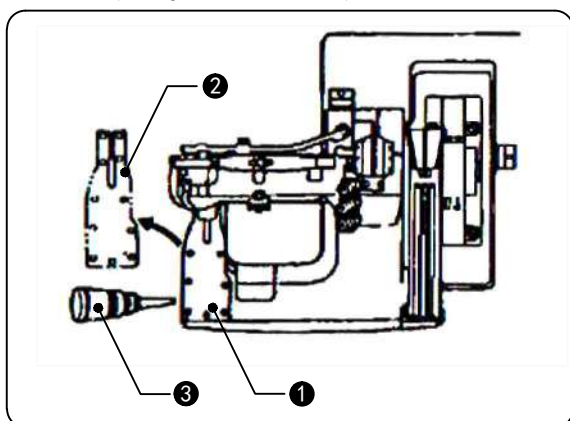
Check that the threads are threaded correctly.

如果针尖已损坏, 请更换机针.

If the tips of the needles are broken the broken needles.

2)、润滑

Changing the lubrication oil (every three months)



* 润滑油至少每三个月更换一次.

The lubricating oil should be changed at least once every three months.

(1) 拧开前臂盖螺钉 ①, 打开前臂盖 ②.

Remove the 11 screws ①, and then open the forward feed arm cover ②.

(2) 把机器里的润滑油用油壶吸出来 ③.

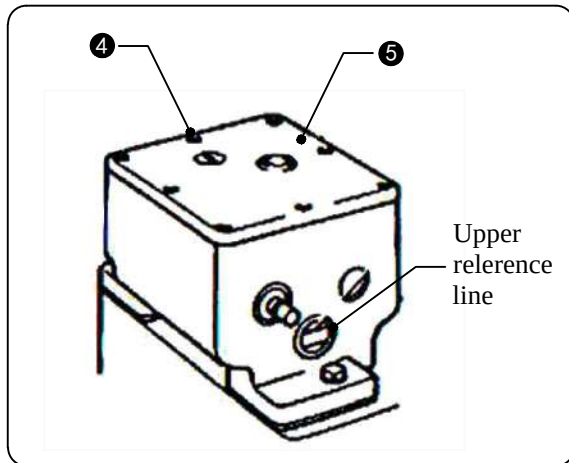
Draw up all of the lubricating oil inside the machine into the oil bottle ③.

(3) 再把油装进机器, 直到在油量表的参考线范围内.

Fill the machine with oil until the oil level reaches the point in between the reference lines on the oil gauge .

- (4) 盖上前臂盖 ②，拧回前臂盖螺钉 ①。

Close the forward feed arm cover ② and secure it with the 11 screws ①.



- * 有拖轮装置的机器

Machines with puller

- (1) 拧开盖板螺钉 ④，打开盖板 ⑤

Remove the eight screws ④, and then open the puller top cover ⑤.

- (2) 把机器里的润滑油用油壶 ③吸出来。

Draw up all of the lubricating oil inside the machine into the oil bottle ③.

- (3) 再把油装进机器，直到在油量表的参考线范围内。

Fill the machine with oil until the oil level reaches the point in between the reference lines on the oil gauge .

- (4) 关上盖板，拧回螺钉。

Close the puller top cover and secure it with the eight screws .

10、调节标准

Standard adjustments

⚠ 注 意 / CAUTION

- ⊘ 机器的维护和检测只能由相关技术人员执行。
Maintenance and inspection of the sewing machine should only be carried out by qualified personnel.

- ❗ 在进行维护、检测、调整时，请咨询经销商或相关技术人员。
Ask your dealer or a qualified electrician to carry out any maintenance and inspection of the electrical system.

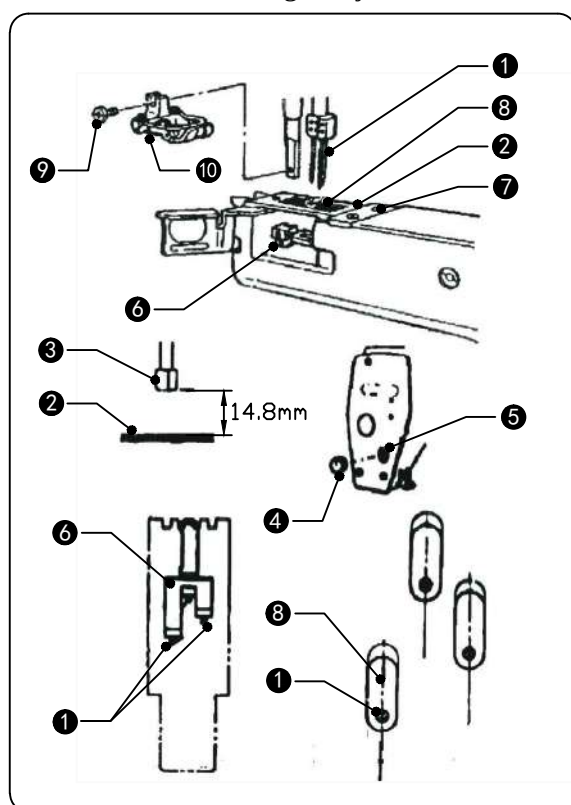
- ⚠ 断开电源同时把电线从电源接口上断开，否则会因误踩踏板而转机器，导致伤害。断电后，由于惯性电机将继续处在运转状态，此时要等电机完全停止后方可操作。
Turn off the power switch and disconnect the power cord from the wall outlet at the following times, otherwise the machine may operate if the treadle is pressed by mistake, which could result in injury.

- * 在执行检查、调整、维护时；在更换易损件，如挑线叉时。
When carrying out inspection, adjustment and maintenance.
When replacing consumable parts such as the looper.

- ⚠ 在做一些调整时，电源开关必须切断，并且谨慎地遵守安全防范措施。
If the power switch needs to be left on when carrying out some adjustment, be extremely careful to observe all safety precautions.

- ❗ 如果安全标识已脱落，必须重新张贴，以确保机器使用时的正确操作。
If any safety devices have been removed, be absolutely sure to re-install them to their original positions and check that they operate correctly before using the machine.

1)、调节针杆 Needle bar height adjustment



调节机针①的高度. 同时调整机针①使每根机针在针板②的针孔⑧中心位置.

Adjust the heights of the needles ①.

At this time,adjust so that each needle ① is in the center of the needle hole ⑧ in the needle plate ②.

- (1) 拧开螺钉⑨, 松开压脚⑩.

Remove the screw ⑨, and then remove the presser foot ⑩.

- (2) 转动皮带轮, 使针杆下降到其最低位置.

Turn the machine pulley to drop the needle bar to its lowest position.

- (3) 取下橡胶塞④, 松开针杆抱箍⑤, 调整使针夹的底部③距针板②的距离为14.8mm.

Remove the rubber plug ④, loosen the needle bar clamp screw ⑤ and adjust so that the distance between the bottom of the needle clamp ③ and the top of the needle plate ② is 14.8mm.

* 针夹如上设置, 当针夹上升至最高点时, 针尖到针板的距离约为14mm.

If the needle clamp is set in the way described above, the distance between the point of the needle and the top of the needle plate will be 14mm, when the needle clamp is raised to its highest position.

- (4) 拧开螺钉⑦, 取下针板②.

Remove the three screws ⑦, and then remove the needle plate ②.

- (5) 调整针杆使机针①与挡针块保持均等位置, 调整挡针块, 使机针①与挡针块⑥之间无手感间隙, 拧回螺钉⑦把针板②固定, 检查机针①是否在针孔中心⑧, 拧紧针杆抱箍⑤螺钉.

Turn the machine pulley so that the needles ① and the needle guard ⑥ are aligned, and then adjust the tilt of the needle clamp ③ so that there is no space between the left and right needles ① and the needles ① and the needle guard ⑥ at this time.

Install the needle plate with the three screws, and after checking that the needles are in the centers of the needle holes, tighten the needle bar clamp screw.

- (6) 塞上橡胶塞④.

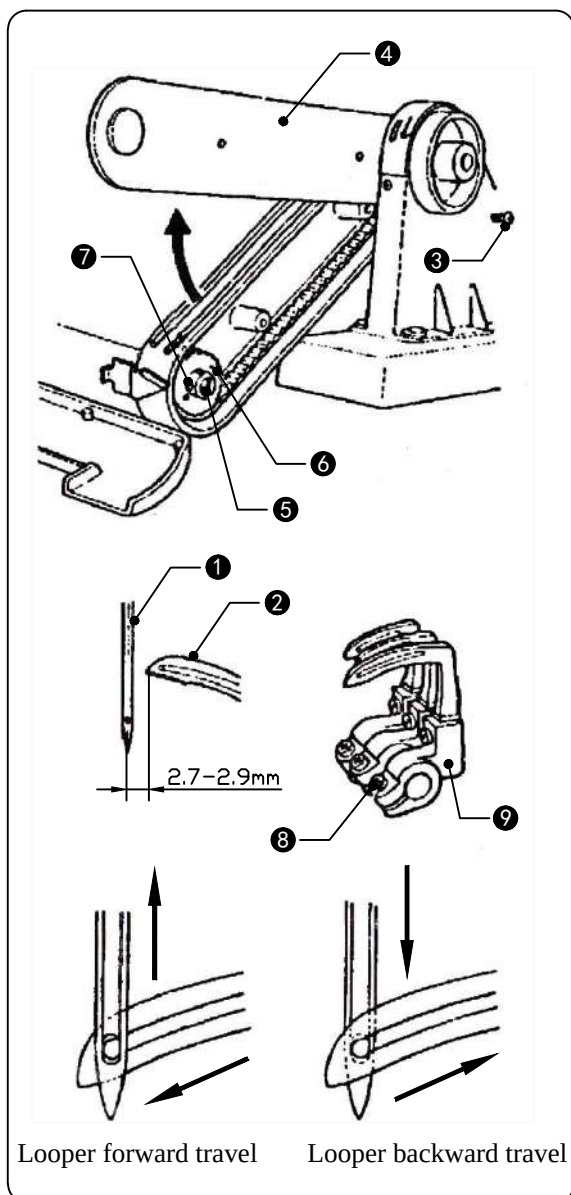
Insert the rubber plug ④.

- (7) 用螺钉⑨把压脚⑩按装在针杆上.

Install the presser foot ⑩ with the screw ⑨.

2)、调节针和挑线叉

Needle and looper timing adjustment



当机针①的位置下降到挑线叉②，挑线叉向后转到最后面，此时机针①的中心位置距离挑线叉②的顶端为2.7-2.9mm.

Make an adjustment so that,when needles are down lowest loopers②reach the end of their backward travel and the distance from the needle center to the looper tip is 2.7 to 2.9 mm.

(1) 取下压脚、针板.

Remove the presser foot,needle plate and feed dogs.

(2) 拧下螺钉③, 打开同步带盖④

Remove the two screws③,and then open the belt cover plate④.

(3) 转动皮带轮，直至挑线叉②向后并回转.

Turn the pulley toward yourself until looper②reach the end of their backward travel.

(4) 松开螺钉⑤，松开下同步轮⑥的紧定螺钉⑦.

Loosen cap screw⑤,and then loosen two set screws⑦on lower belt wheel⑥.

(5) 转动皮带轮直至机针①下降至最低点.

Turn the pulley toward yourself until needles①come down to the lowest position.

(6) 拧紧同步轮紧定螺钉⑦，然后拧紧螺钉⑤

Tighten two set screws⑦securely,and then tighten cap screw⑤.

(7) 松开螺钉⑧，转动挑线叉座⑨，按箭头的指示直到机针的中心和挑线叉的顶端距离为2.7-2.9mm.

Loosen set screw⑧,move looper holder⑨ in the arrow direction until the distance between the needle center and the looper tip is 2.7 to 2.9 mm,and retighten set screw⑧securely.

(8) 转动皮带轮，确定挑线叉的小孔与针孔基本相称.

Make sure that the looper thread eyes match the needle eyes in the forward and backward travels of the loopers.

(9) 装上同步带盖④，拧紧螺钉③

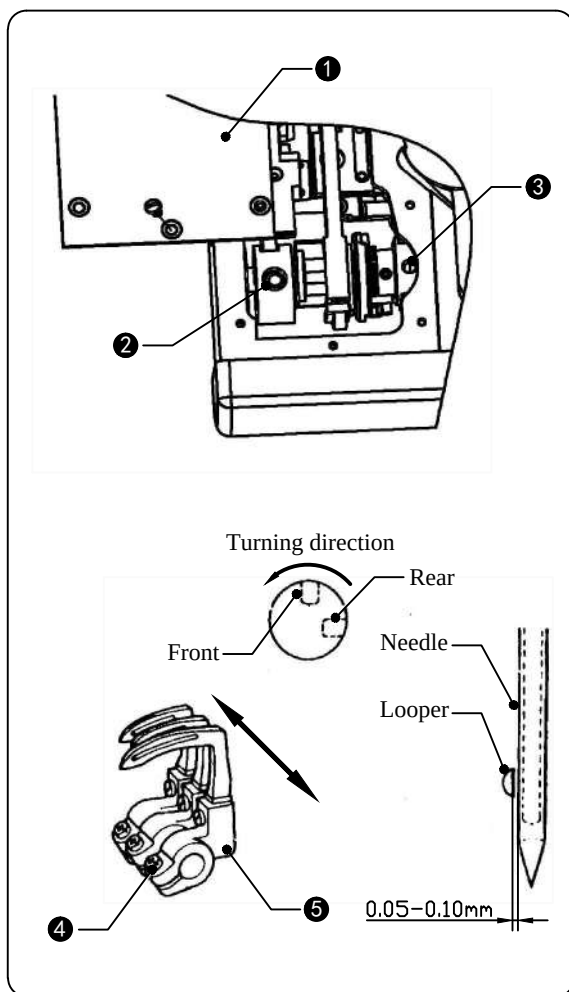
Close the belt cover plate④,and then tighten the two screws③.

(10) 装上压脚和针板.

Install the presser foot,needle plate and feed dogs.

3)、调节挑线叉和机针的间隙

Timing of loopers running clear of needles



当挑线叉向前运动时，挑线叉应运转到机针的后面；当挑线叉向后运动时，挑线叉应运转到机针的前面。在运动过程中，挑线叉与机针的间隙应为0.05mm-0.10mm之间。

The loopers run in back of the needle in their forward travel and in front of the needle in their backward travel. Adjust the clearance between the needles and the loopers to anywhere from 0.05 to 0.10 mm in the forward travel.

(1) 移开前臂盖.

Remove forward feed arm cover ①.

(2) 转动前后方向的偏心轮靠近固定螺钉，与挑线叉偏心调节孔排成一行时，挑线叉的前后应定时调整。调整时，松开转动方向的偏心轮前面的固定螺钉，再松开后面的固定螺钉，前后偏心轮就可以调整了，调整后，拧紧两个固定螺钉。

The forward/back looper timing should be adjusted so that the set screw which is at the rear relative to the forward/back cam turning direction is aligned with the screw adjustment hole ③ when the set screw which is at the rear relative to the up/down cam turning direction is aligned with the looper connecting rod adjustment hole ②.

To adjust, loosen the set screw which is at the rear relative to the forward/back cam turning direction, and then loosen the set screw at the rear just enough so that the forward/back cam can be adjusted.

(3) 松开固定挑线叉的螺钉，移动挑线叉座，按箭头方向调整，当挑线叉尖端和机针的中心相称时，它们的间隙应为0.05mm-0.10mm之间。

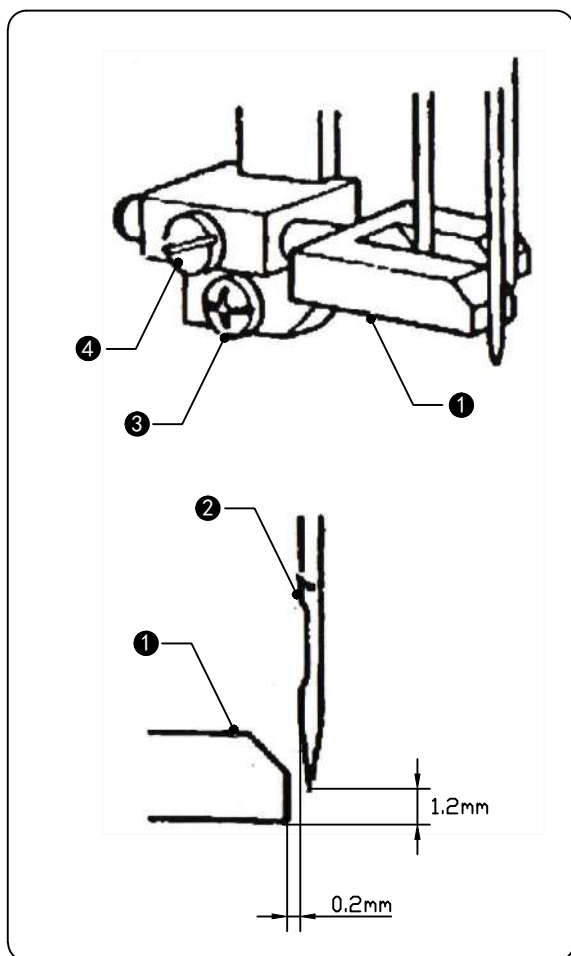
Loosen the looper holder screw ④, and then move the looper holder ⑤ in the direction of the arrow to adjust so that the clearance between the tip of the looper and the center of the needle is 0.05mm-0.10mm when the two are aligned.

At this time, do not move the looper holder ⑤ in any direction except the direction indicated by the arrow. If it is moved in another direction.

(4) 安装好前臂盖.

Install the forward feed arm cover ①.

4)、调节挡针块 Needle guard adjustment



当线迹长度设置最小时，而且挑线叉移向机针时，挡针块与机针的间隙应为0.2mm. 在不折断挑线叉的情况下，高度设置的尽可能低一些.

The clearance between the needle guard ① and the needles ② should be 0.2mm when the stitch length is at the minimum setting and the loopers are moving toward the needles.

The heights should be adjusted to as low a setting as possible without the loopers breaking.

(1) 调整线迹到最小设置.

Adjust the stitch length to the minimum setting.

(2) 将机器皮带轮按指示方向旋转，使挑线叉与机针的中心保持相称.

Turn the machine pulley toward yourself to align the loopers with the centers of the needles.

(3) 松开螺钉 ③，然后提升或降低挡针块使得挡针块的末端到针尖的距离为1mm - 2mm. Loosen the set screw ③, and then raise or lower the needle guard ① so that the distance from the bottom of the needle guard ① and the needle is 0.2mm.

(4) 拧紧螺钉 ③.

Tighten the set screw ③.

(5) 松开螺钉 ④，然后移动挡针块向左或向右调整使得挡针块与机针的间隙为0.2mm .

Loosen the set screw ④, and then move the needle guard to the left or right to adjust so that the clearance between the needle ① guard ① and the needles is 0.2mm .

(6) 拧紧螺钉 ④.

Tighten the set screw ④.

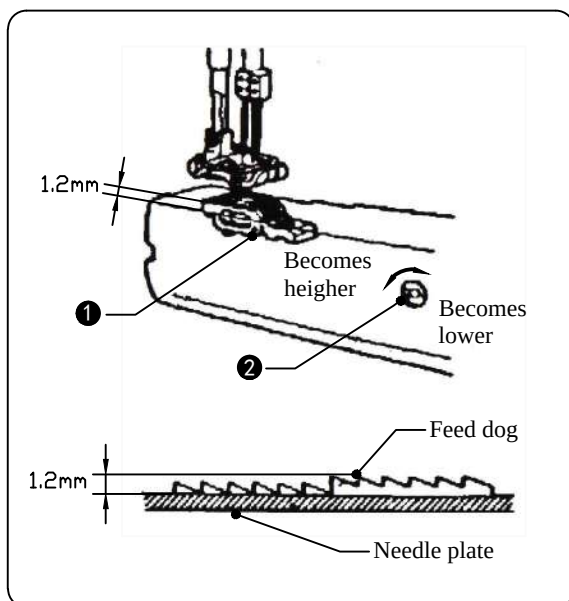
注意：

Note:

针对有些布料和线，可以得到的最好的缝制效果是当线迹长度调整到实际的线迹长度时，挡针块与机针轻微接触.

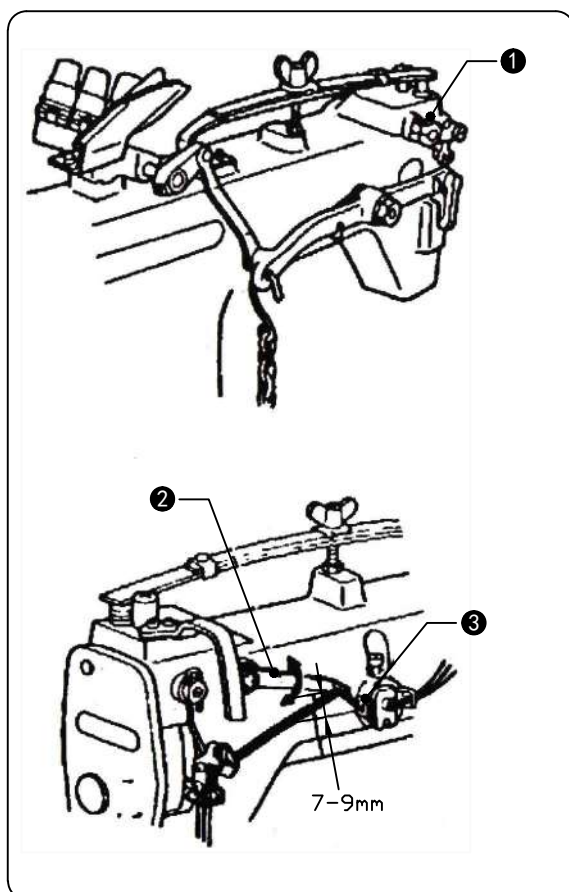
For some materials and threads, the best results can be obtained if the needle guard and the needle are touching slightly when stitch length is adjusted to the actual stitch length.

5)、送料齿高度的调整 Feed dog height adjustment



当送料齿①在最高位置时，调整使送料齿的最高位置处于针板顶面以上1.2mm。
通过转动送料杆偏心轴②来调整送料齿高度。
Make an adjustment so that the highest part of the feed dog will be 1.2 mm above the needle plate when feed dog① is at the highest position. Adjust the height of feed dog① by turning feed bar eccentric shaft②.

6)、调整松线杆 Thread release lever adjustment



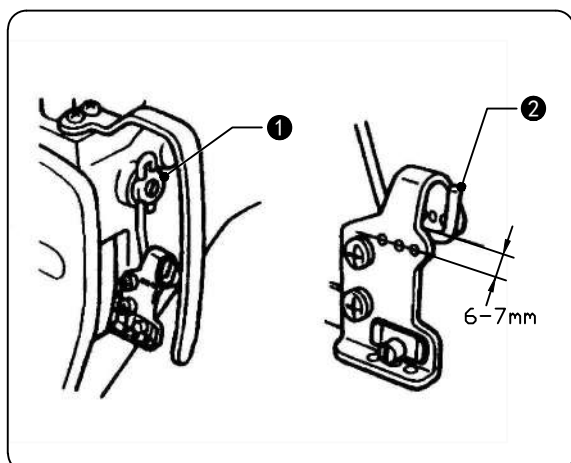
当针杆在最低位置时，调整松线杆使之在线压架上松线杆中心的线孔之上7-8mm。
Adjust so that the center of the thread release lever thread hole is 7-9mm above the center of the thread hole in the upper thread tension bracket when the needle bar is at its lowest position.

- (1) 转动皮带轮直到针杆向下到最低位置。
Turn the pulley until the needle bar is down at the lowest position.
- (2) 松开螺钉 ①，转动松线杆，向上或向下使得松线杆中心的线孔在线压架上部线孔中心之上7-9mm。
Loosen the screw ① and then move the thread release lever ② up or down to adjust so that the center of the thread release lever thread hole is 7-9mm above the center of the thread hole ③ in the upper thread tension bracket.
- (3) 拧紧紧固螺钉 ①。
Retighten set screw ①.

* 松线杆越高，线就越紧。
The higher the thread release lever, the tighter will be the stitches.

7)、调整上打线器

Upper thread take-up thread guide adjustment



调整上打线器的打线钩位置，使得和过线板的间距约为6-7mm左右。

Adjust the distance between the center of the upper thread take-up and top of the thread guide will be 6-7mm.

- (1) 转动皮轮直到针杆下降到最低位置。

Turn the pulley toward yourself until the needle bar is down at the lowest position.

- (2) 松开螺钉，上下移动打线钩，使得过线板的过线孔和打线钩的间距为6-7mm左右。

Loosen the screw ①, and then move the upper thread take-up thread guide ② up or down to adjust so that the distance from the top of the upper thread take-up thread guide ② to the center of the upper thread take-up hole is 6-7mm.

- * 打线钩调的越高，面线线量越大。

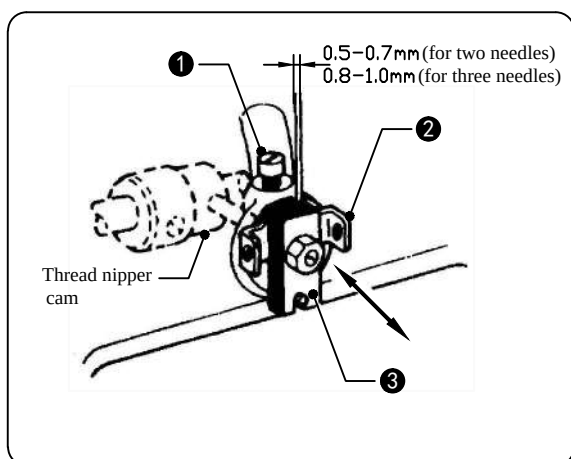
The higher the upper thread take-up thread guide ②, the greater will be the upper thread loops.

- (3) 拧紧螺钉 ①。

Tighten the screw ①.

8)、调整上线夹

Upper thread nipper adjustment



松开螺钉 ①，转动皮带轮，使得上线夹松开时的间隙为0.5-0.7mm（两针间隙）；使得上线夹松开时的间隙为0.8-1.0mm（三针间隙）。

Adjust so that the maximum clearance between the upper thread tension bracket ② and the thread tension plate ③ is 0.5-0.7mm (for two needles) or 0.8-1.0mm (for three needles).

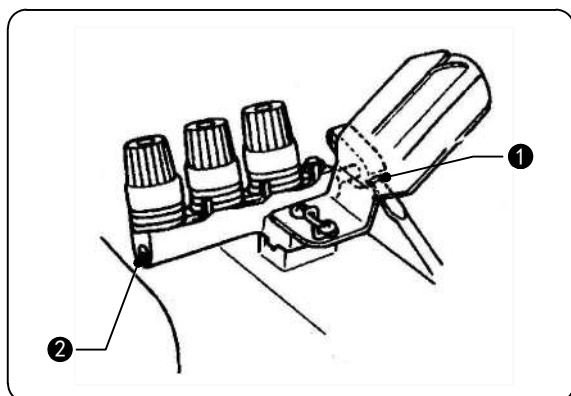
Loosen the set screw ①, and then move the upper thread tension bracket ② in or out to adjust so that the maximum clearance between it and the thread tension plate ③ is 0.5-0.7mm (for two needles) or 0.8-1.0mm (for three needles).

- * 如果上线夹的夹线板 ③ 上述间隙缩小，将会收紧面线。

The thread tension will become better if the clearance between the upper thread tension bracket ② and the thread tension plate ③ is reduced.

9)、松线轴的调整

Thread release shaft adjustment



调整松线轴使得当压脚降低时，夹线盘收紧；压脚提升时，夹线盘松开。

Adjust the thread release shaft so that thread tension discs loosen when the presser foot is raised and tighten when the presser foot is lowered.

(1) 松开紧固螺钉 ①.

Loosen set screw ①.

(2) 通过松线轴 ②调整，当夹线盘松开时，使得压脚提升到距针板4mm左右的位置。

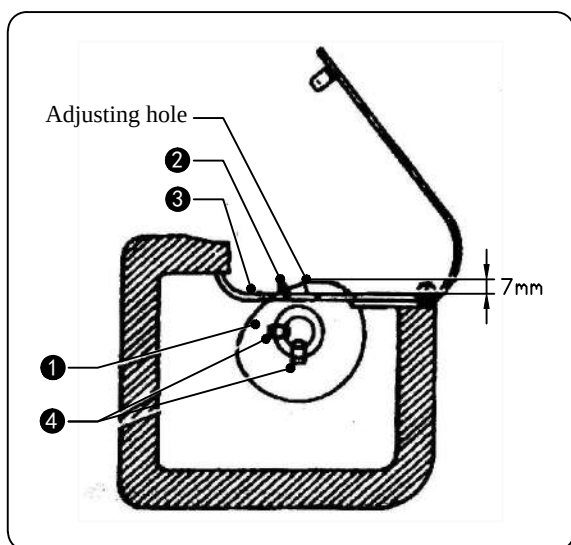
Make an adjustment by turning thread release shaft ② so that the thread tension discs begin to loosen when the presser foot rises 4mm above the top of the needle plate.

(3) 调整结束后，拧紧紧固螺钉 ①.

After the adjustment, retighten set screw ① securely.

10)、下打线器调整

Lower thread take-up timing adjustment



当挑线叉开始向后运动，下打线器接触到线时，调整使下打线凸轮 ①在下打线器平面 ③以上7mm.

Make an adjustment so that, when the loopers begin moving backward, lower thread take-up ① contacts thread ②, and is 7mm up from lower thread take-up base ③.

(1) 如图，松开打线凸轮的固定螺钉 ④.

Insert screw driver through the adjusting hole in the lower thread take-up base, and loosen two set screws ④.

(2) 转动打线凸轮，直到距打线器平面以上7mm.

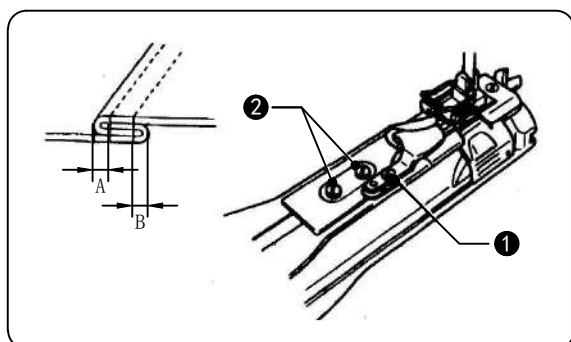
Raise lower thread take-up ① until it is 7mm up from thread take-up base ③.

(3) 拧紧打线凸轮的固定螺钉 ④.

After the adjustment, retighten two set screws ④ securely.

11)、安装卷边器

Installing the lapper



在前臂盖上，将卷边器上的导向滑块，嵌入前臂盖的滑槽内，使卷边器前端对正并贴近压脚。

Insert the lapper guide plate from the front into the oval slot in the forward feed arm cover, making sure that the end of lapper is clear of the presser foot.

*卷边器的调节

Lapper adjustment

通过松开固定螺钉 ①，调整缝距A. 调整后拧紧固定螺钉 ①.

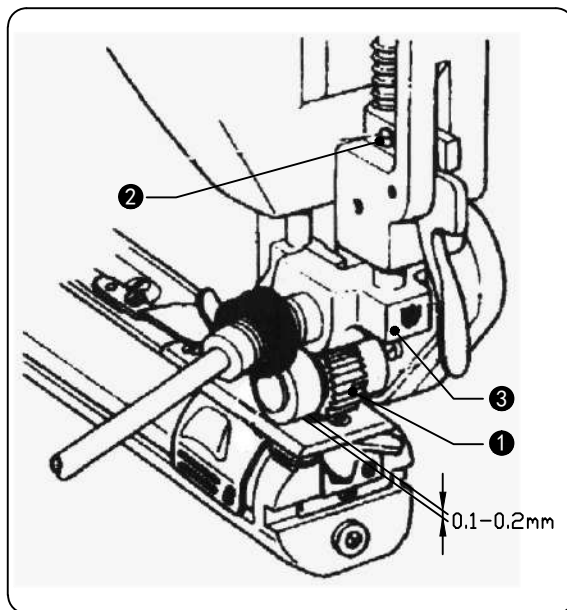
Adjust felling distance of point A by loosening set screw ①. After the adjustment, retighten set screw ①.

通过松开固定螺钉 ②，调整缝距B. 调整后拧紧固定螺钉 ②.

Adjust felling distance of point B by loosening set screw ②. After the adjustment, retighten set screw ②.

12)、拖轮高度的调节(配拖轮的机器)

Puller height adjustment (Machines with puller)



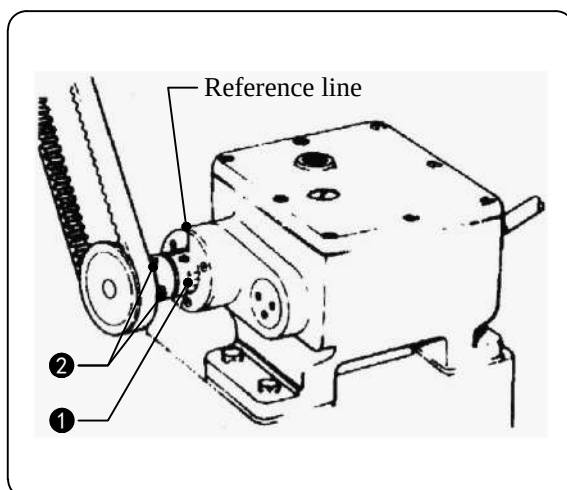
调节拖轮的高度使得它高于针板面0.1-0.2mm.
Adjust the height of puller ① so that it is 0.1 to 0.2 mm high from the top of the needle plate.

(1) 松开固定螺钉 ②，上下移动拖轮支架 ③，使拖轮 ① 在针板平面上0.1-0.2mm 之间。
Loosen set screw ②, and move puller support ③ up or down until puller ① is 0.1 to 0.2 mm above the top of the needle plate.

(2) 调整后，拧紧固定螺钉 ②。
After the adjustment, retighten set screw ②.

13)、拖轮同步的调节(配拖轮的机器)

Puller timing adjustment (Machines with puller)



调整使得当针杆向下到最底位置时，刻度盘上的标记 ① 正对参考线。

Make an adjust so that, when the needle bar is down at the lowest position, the mark on timing collar ① is in line with the reference line.

(1) 转动机器皮带轮，直至刻度盘上的标记 ① 正对参考线。

Turn the pulley toward yourself until the mark on timing collar ① meets the reference line.

(2) 松开两个固定螺钉 ②，转动机器皮带轮，直至针杆向下到最底位置。

Loosen two set screws ②, and turn the pulley toward yourself until the needle bar is lowered all the way down.

(3) 拧紧两个固定螺钉 ②。

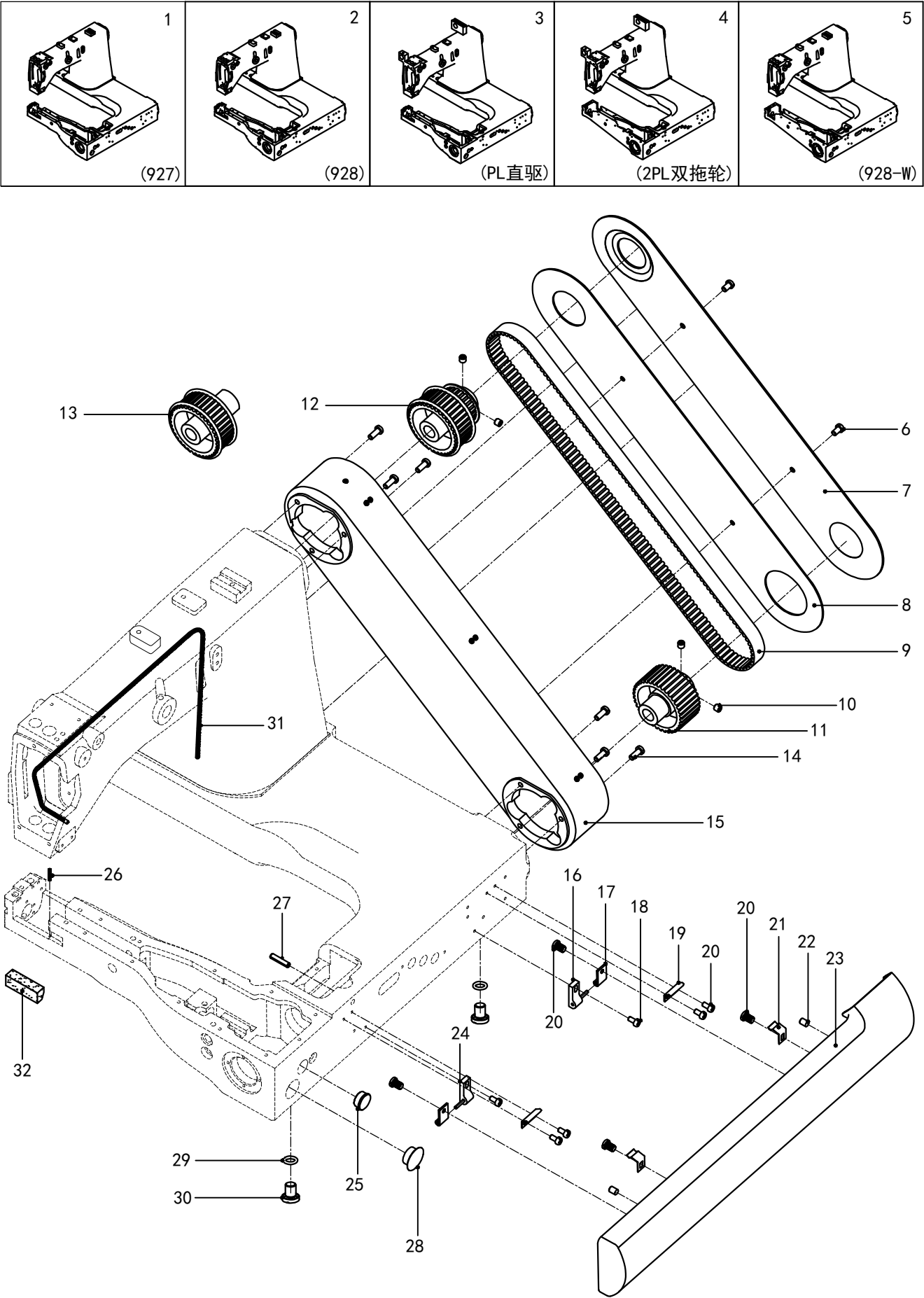
Retighten two set screws ②.

PARTS LIST

目 录

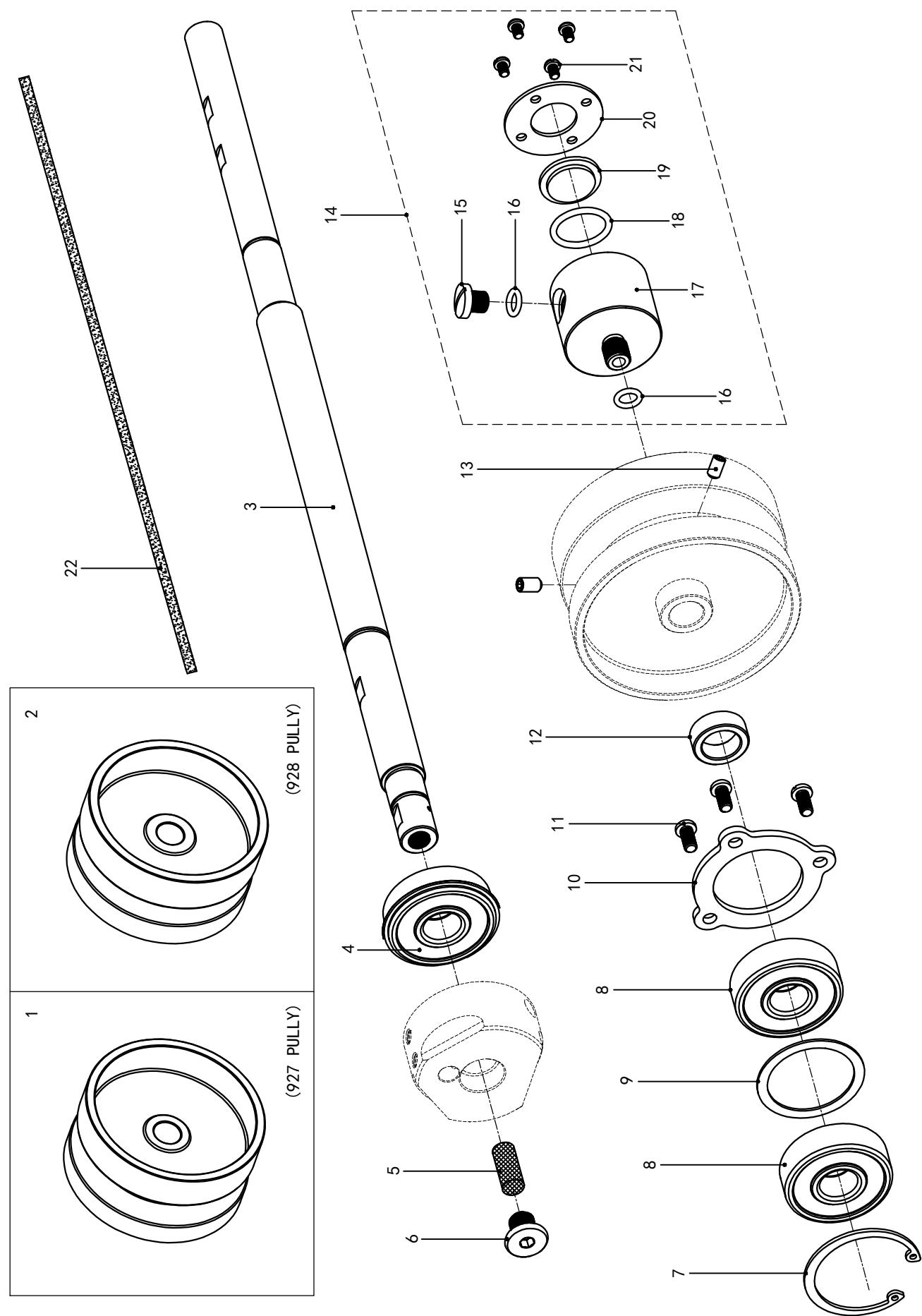
A、机体部份 Machine frame components	1
B、上轴机械装置 Upper shaft mechanism	3
C、针杆装置 Needle bar mechanism	5
D、压脚杆装置 Presser bar mechanism	7
E、送料装置 Feed mechanism	9
F、下轴装置 Lower shaft mechanism	11
G、挑线叉组件 Lopper mechanism	13
H、上引线装置 Upper threading mechanism	17
I、下引线装置 Lower threading mechanism	21
J、规格零部件表 Different parts list	25
PST、变速箱拖轮 Gear-box haul material wheel	35
PS、变速箱 Gear-box	37
PL、直驱拖轮 Direct drive haul material wheel	41
SPL、双拖轮 Double haul material wheel	45
CV、自动剪线装置 Auto wire cutters device	47
PF、气控拖轮装置 Gas control device	51
P、气动功能装置 Pneumatic device	53
SD、伺服直驱装置 Servo direct drive device	57
K、普通系列附件 Accessories	59
L、(伺服)直驱系列附件 Accessories	61

A、机体部份 Machine frame components



A、机体部份 Machine frame components

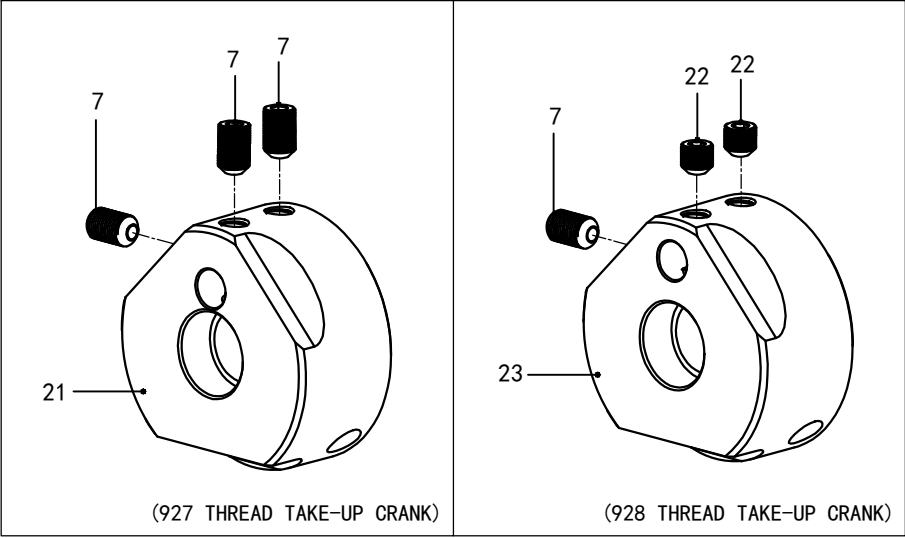
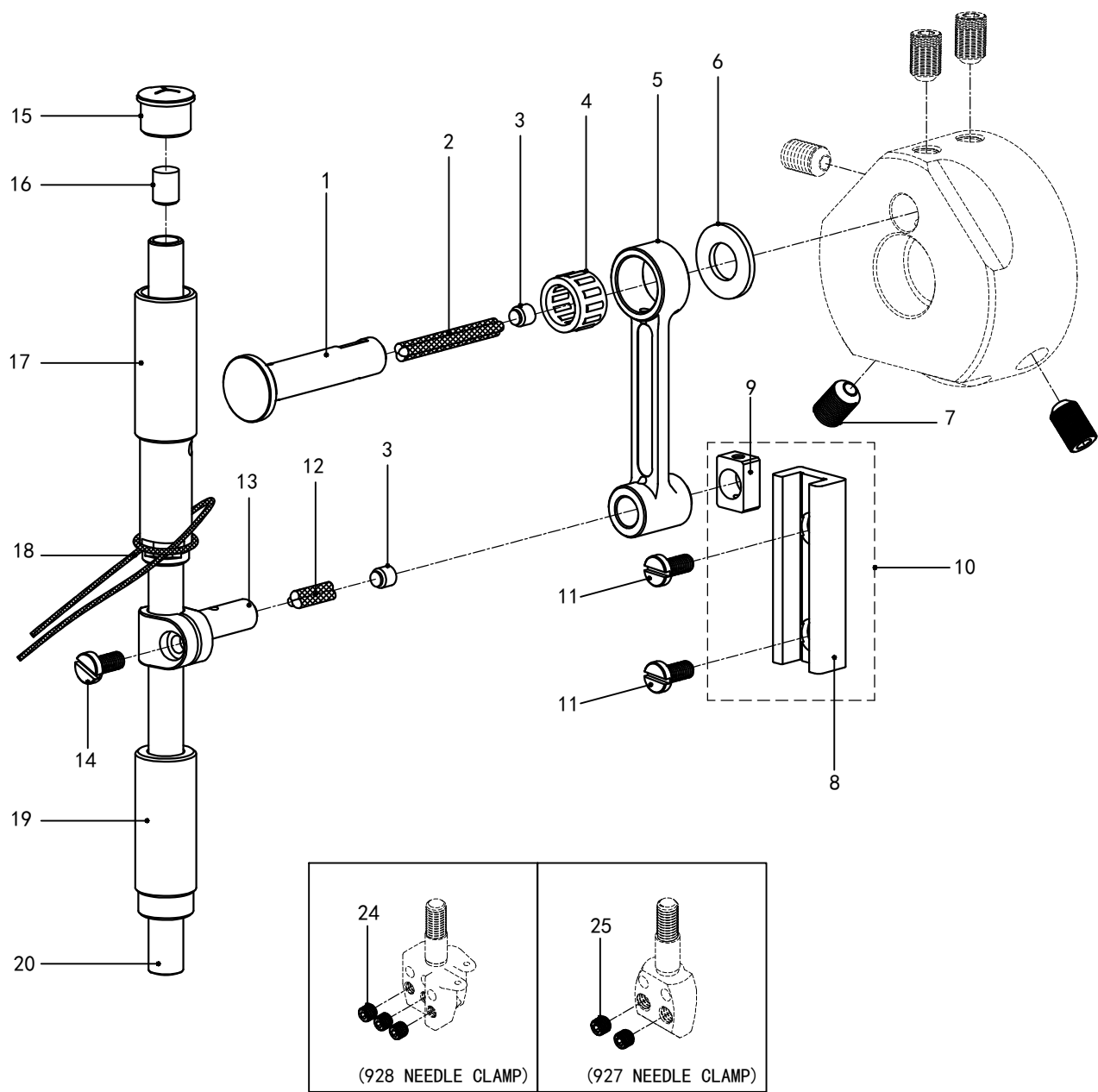
序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927A-1	927A001	927机壳/927 Machine frame	1
2	928A-2	928A002	928机壳/928 Machine frame	1
3	927A-3	927A003	PL直驱机壳/PL Machine frame	1
4	928A-4	928A004	2PL双拖轮机壳/2PL Machine frame	1
5	928A-5	928A005	928W宽臂机壳/928W Machine frame	1
6	927A-6	LD00137	螺钉SM4. 76-10/Screw SM4.76	2
7	927A-7	927A007	同步皮带罩盖板/Belt Corer Plate	1
8	927A-8	927A008	同步皮带罩盖板垫/Packing	1
9	927A-9	927A009	同步带/Timing Belt	1
10	927A-10	LD00131	紧定螺钉SM6. 35-6/Screw SM4.76	4
11	927A-11	927A011	下同步轮/Timing Belt Wheel Assy Lower	1
12	927A-12	927A012	上同步轮/Timing Belt Wheel Assy Upper	1
13	927A-13	927A013	上同步轮/Timing Belt Wheel Assy Upper	1
14	927A-14	LD00133	螺钉SM4. 76-12/Screw SM4.76	6
15	927A-15	927A015	同步皮带罩/Belt Cover	1
16	927A-16	927A016	长前盖右摇臂/L/Thread Guide Hinge Assy,R	1
17	927A-17	927A017	前盖摇臂座/Hinge	2
18	927A-18	LD00280	螺钉SM3. 57-15/Screw SM3.57	2
19	927A-19	927A019	前盖弹簧片钩/Font Cover Spring	2
20	927A-20	LD00135	螺钉SM3. 57-6/Screw SM3.57	8
21	927A-21	927A021	弹簧片/Font Cover Spring	2
22	927A-22	927A022	前盖橡胶垫/Rubber Cap	2
23	927A-23	927A023	长前盖/Front Cover	1
24	927A-24	927A024	前盖左摇臂/L/Thread Guide Hinge Assy,L	1
25	927A-25	927A025	橡胶塞/Rubber Cap	1
26	927A-26	TXX00009	弹性圆柱销2X10/Pin, Spring	1
27	927A-27	TXX00011	弹性圆柱销5X12/Pin, Spring	1
28	927A-28	927A028	标尺窗/Surveyor's rod Window	1
29	927A-29	OXQ00002	O形圈11/O Ring	2
30	927A-30	927A030	螺钉SM7. 94-10. 5/Screw SM7.94	2
31	927A-31	927A031	油线/Wick Ninpper	1
32	927A-32	927A032	机头羊毛毡/Felt	1



B-上轴机械装置 Upper shaft mechanism

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927B-1	927B001	927皮带轮/927Pulley	1
2	928B-2	928B002	928皮带轮/928Pelley	1
3	927B-3	927B003	上轴/Upper Shaft	1
4	927B-4	ZC00008	轴承/Ball Bearing	1
5	927B-5	927B005	主轴油毡/Felt	1
6	927B-6	LD00136	螺钉SM9. 52-9. 5/Screw SM9.52	1
7	927B-7	TDQ00004	弹性挡圈C42/Retaining Ring	1
8	927B-8	ZC00009	轴承/Ball Bearing	2
9	927B-9	DQ00032	平垫圈34/Washer	1
10	927B-10	927B010	轴承压板/Bearing Presser	1
11	927B-11	LD00137	螺钉SM4. 76-10/Screw SM4.76	3
12	927B-12	927B012	挡圈/Collar	1
13	927B-13	LD00001	紧定螺钉M6X10/Screw M6	2
14	927B-14	927B014	存油器组件/Oil Tank Assy	1
15	927B-15	927B015	螺钉SM7. 94-6. 5/Screw SM7.94	1
16	927B-16	□XQ00002	O形圈11/O Ring	2
17	927B-17	927B017	存油器/Oil Tank	1
18	927B-18	□XQ00003	O形圈24/O Ring	1
19	927B-19	927B019	存油器示窗/Oil Gauge Window	1
20	927B-20	927B020	示窗压板/Oil Gauge Cover	1
21	927B-21	LD00135	螺钉SM3. 57-6/Screw SM3.57	4
22	927B-22	927B022	油线/Wick Ninpper	1

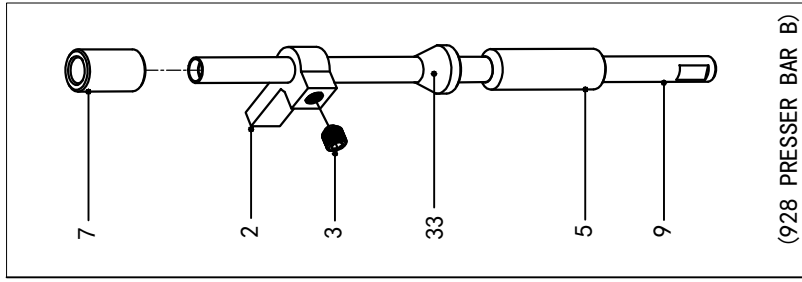
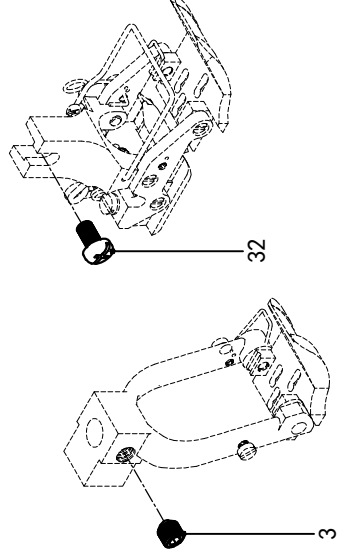
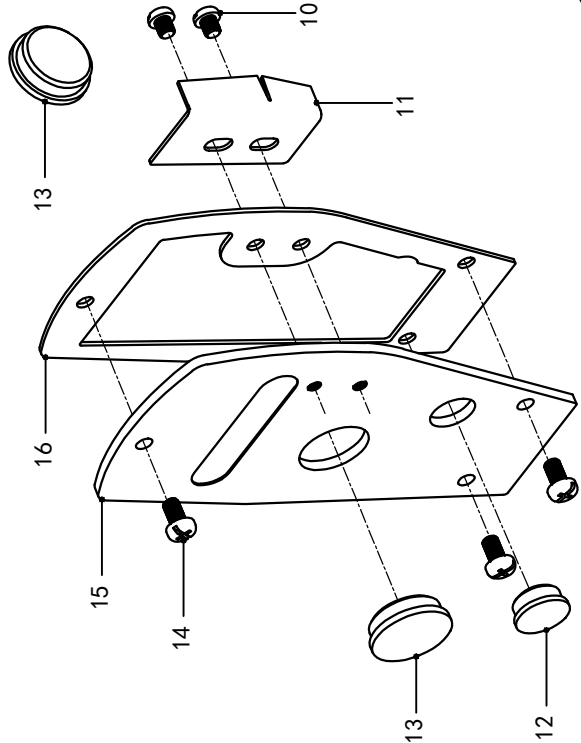
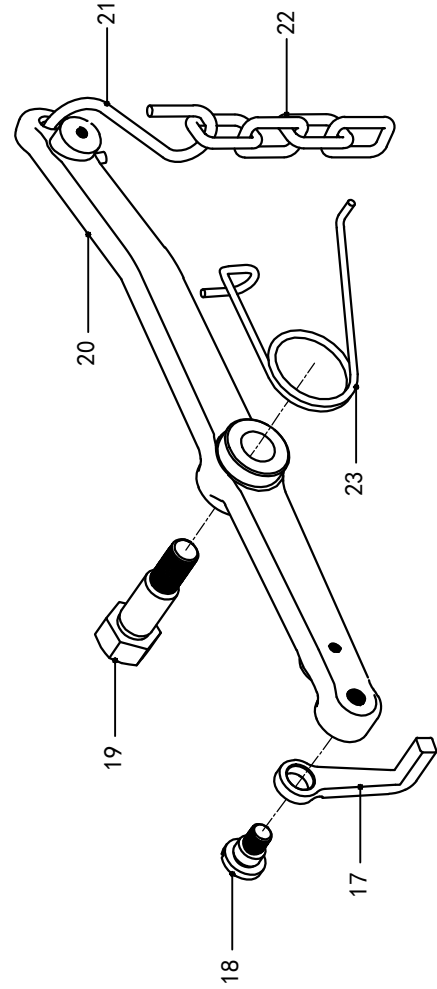
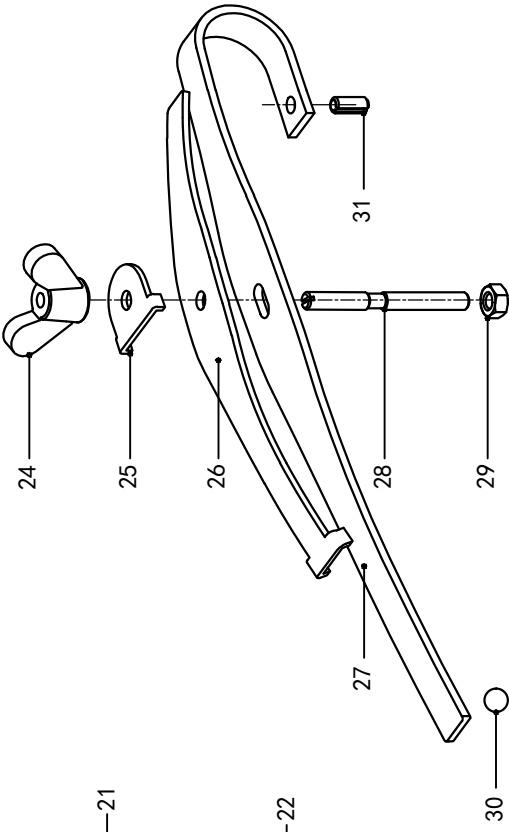
C-针杆装置 Needle bar mechanism



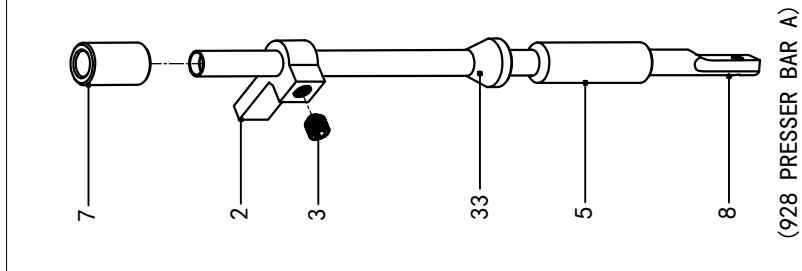
C-针杆装置 Needle bar mechanism

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927C-1	927C001	针杆销/Pin	1
2	927C-2	927C002	针杆销油线/Wick Ninpper	1
3	927C-3	927C003	橡胶塞/Rubber Cap	1
4	927C-4	ZC00010	滚针轴承/Ball Bearing	1
5	927C-5	927C005	针杆连杆/Connecting Rod	1
6	927C-6	DQ00033	平垫圈8/Washer	1
7	927C-7	LD00138	紧定螺钉SM6. 35-8/Screw SM6.35	5
8	927C-8	927C008	针杆滑块槽/Needle Bar Guide	1
9	927C-9	927C009	针杆滑块/Eccentric Wheel Sleeve	1
10	927C-10	927C010	针杆滑块槽组件/Needle Bar GuideAssy	1
11	927C-11	LD00139	紧定螺钉SM3. 57-8/Screw SM3.57	2
12	927C-12	927C012	针杆抱箍油线/Wick Ninpper	1
13	927C-13	927C013	针杆抱箍/Needle Bar Clamp	1
14	927C-14	LD00140	紧定螺钉SM3. 57-7/Screw SM3.57	1
15	927C-15	927C015	针杆上套油塞/Rubber Cap	1
16	927C-16	927C016	针杆塞/Needle Bar Cork	1
17	927C-17	927C017	针杆上套/Needle Bar Bush,Upper	1
18	927C-18	927C018	针杆油线/Wick Ninpper	1
19	927C-19	927C019	针杆下套/Needle Bar Bush,Lower	1
20	927C-20	927C020	针杆/Needle Bar	1
21	927C-21	927C021	927挑线杆曲柄/927 Thread Take-Up Crank	1
22	927C-22	LD00245	紧定螺钉SM6. 35-5. 4/Screw SM6.35	2
23	928C-23	928C023	928挑线杆曲柄/928 Thread Take-Up Crank	1
24	928C-24	LD00142	紧定螺钉SM3. 18-3. 2/Screw SM3.18	3
25	927C-25	LD00141	紧定螺钉SM4. 36-3. 5/Screw SM4.36	2

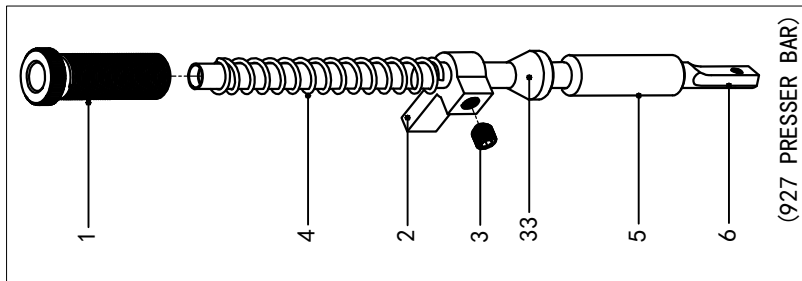
D-压脚杆装置 Presser bar mechanism



(928 PRESSER BAR B)



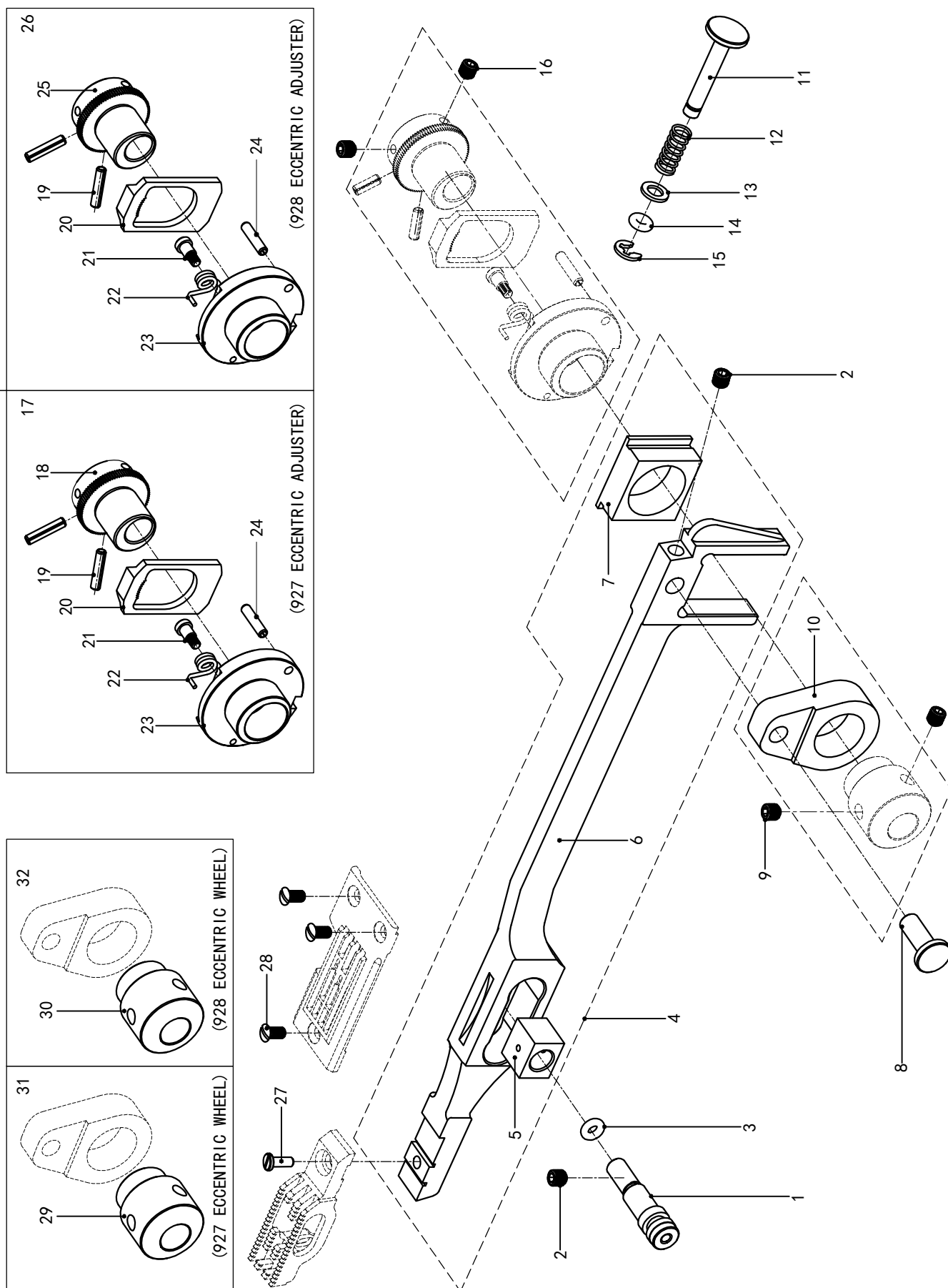
(928 PRESSER BAR A)



(927 PRESSER BAR)

D-压脚杆装置 Presser bar mechanism

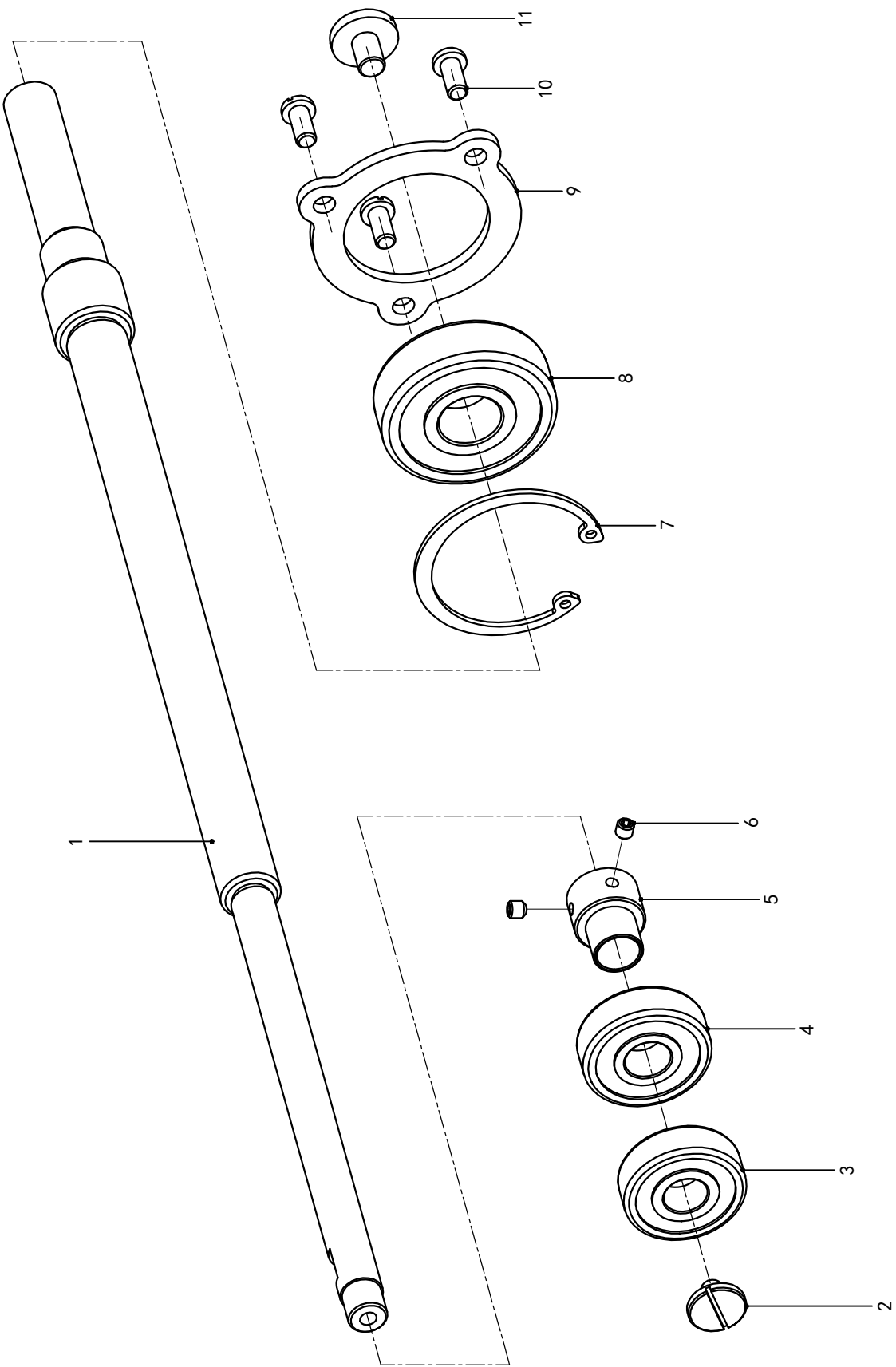
序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927D-1	927D001	调节螺栓/Adjust Screw	1
2	927D-2	927D002	压脚杆夹/Presser Bar Clamp	1
3	927D-3	LD00143	紧定螺钉SM5. 95-6/Screw SM5.95	2
4	927D-4	TH00020	压簧/Spring	1
5	927D-5	927D005	压脚杆下套/Presser Bar,Lower	1
6	927D-6	927D006	927压脚杆/Presser Bar	1
7	928D-7	928D007	928压脚杆上套/Presser Bar,Upper	1
8	928D-8	928D008	928压脚杆A/Presser Bar, A	1
9	928D-9	928D009	928压脚杆B/Presser Bar, B	1
10	927D-10	LD00144	螺钉SM4. 36-4. 8/Screw SM4.36	2
11	927D-11	927D011	侧盖/Cover	1
12	927D-12	927D012	橡胶塞13. 5/Rubber Cap	1
13	927D-13	927D013	橡胶塞20. 5/Rubber Cap	1
14	927D-14	LD00010	螺钉SM4. 36-8/Screw SM4.36	4
15	927D-15	927D015	端面盖/Face Plate	1
16	927D-16	927D016	端面盖密封垫/Facking	1
17	927D-17	927D017	抬压脚杆连接块/Presser Bak Lifter	1
18	927D-18	927D018	连接块轴位螺钉/Shoulder Screw	1
19	927D-19	927D019	抬压脚杆轴位螺钉/Shoulder Screw	1
20	927D-20	927D020	抬压脚杆/knee Lifter Lever	1
21	927D-21	927D021	链条挂钩/Chain Rod Hook	1
22	927D-22	927D022	链条/Chain	1
23	927D-23	927D023	抬压脚杆扭簧/Twist Spring	1
24	928D-24	928D024	蝶形螺母/Nut	1
25	928D-25	928D025	蝶形螺母垫片/Washer	1
26	928D-26	928D026	压板弹簧B/Presser Plate Spring,B	1
27	928D-27	928D027	压板弹簧A/Presser Plate Spring,A	1
28	928D-28	928D028	调节螺钉/Screw	1
29	928D-29	LM00008	螺母SM4. 76/Nut SM4.76	1
30	928D-30	GZ00004	钢珠/Bearing Ball	1
31	928D-31	TXX00005	弹性圆柱销/Pin, Spring	1
32	927D-32	LD00171	压脚螺钉SM3. 57-8/Screw	1
33	928D-33	928D033	压杆防油套/Presser Bar Defend Oil Set	1



E-送料装置 Feed mechanism

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927E-1	927E001	送料杆偏心销/FeedBarEccentricShaft	1
2	927E-2	LD00146	紧定螺钉SM5. 95-8/Screw SM5.95	1
3	927E-3	□XQ00004	O形圈10/O Ring	1
4	927E-4	927E004	送料杆组件/Feeding Pole Module	1
5	927E-5	927E005	送料杆小滑块/Eccentric Wheel Sleeve	1
6	927E-6	927E006	送料杆/Feeding Pole	1
7	927E-7	927E007	送料杆大滑块/Eccentric Wheel Sleeve	1
8	927E-8	927E008	连接块销子/Pin	1
9	927E-9	LD00003	紧定螺钉M6X6/Screw M6	2
10	927E-10	927E010	偏心轮连接块/Presser Bak Lifter	1
11	927E-11	927E011	调节按钮/Push Button	1
12	927E-12	TH00021	弹簧/Spring	1
13	927E-13	DQ00034	平垫圈5/Washer	1
14	927E-14	□XQ00005	O形圈/O Ring	1
15	927E-15	TDQ00005	开口挡圈4/Ring	1
16	927E-16	LD00143	紧定螺钉SM5. 95-6/Screw SM5.95	2
17	927E-17	927E017	927偏心调节器组件/927 Eccentric Adjuster	1
18	927E-18	927E018	偏心齿轮/Eccentric Wheel,Outside	1
19	927E-19	TXX00006	弹性圆柱销/Pin, Spring	2
20	927E-20	927E020	齿板/Rachter Stopper	1
21	927E-21	927E021	扭簧螺钉/Screw	1
22	927E-22	927E022	扭簧/Twist Spring	1
23	927E-23	927E023	角度槽偏心轮/Eccentric Wheel,Inside	1
24	927E-24	TXX00007	弹性圆柱销/Pin, Spring	1
25	928E-25	928E025	928偏心齿轮/928Eccentric Wheel,Outside	1
26	928E-26	928E026	928偏心调节器组件/928 Eccentric Adjuster	1
27	927E-27	LD00147	螺钉SM4. 76-8/Screw SM4.76	1
28	927E-28	LD00148	沉头螺钉SM4. 36-9/Screw SM4.36	3
29	927E-29	927E029	927偏心轮/927 Eccentric Wheel	1
30	928E-30	928E030	928偏心轮/928 Eccentric Wheel	1
31	927E-31	927E031	927偏心轮连接块组件/927 Eccentric Wheel	1
32	927E-32	927E032	928偏心轮连接块组件/928 Eccentric Wheel	1

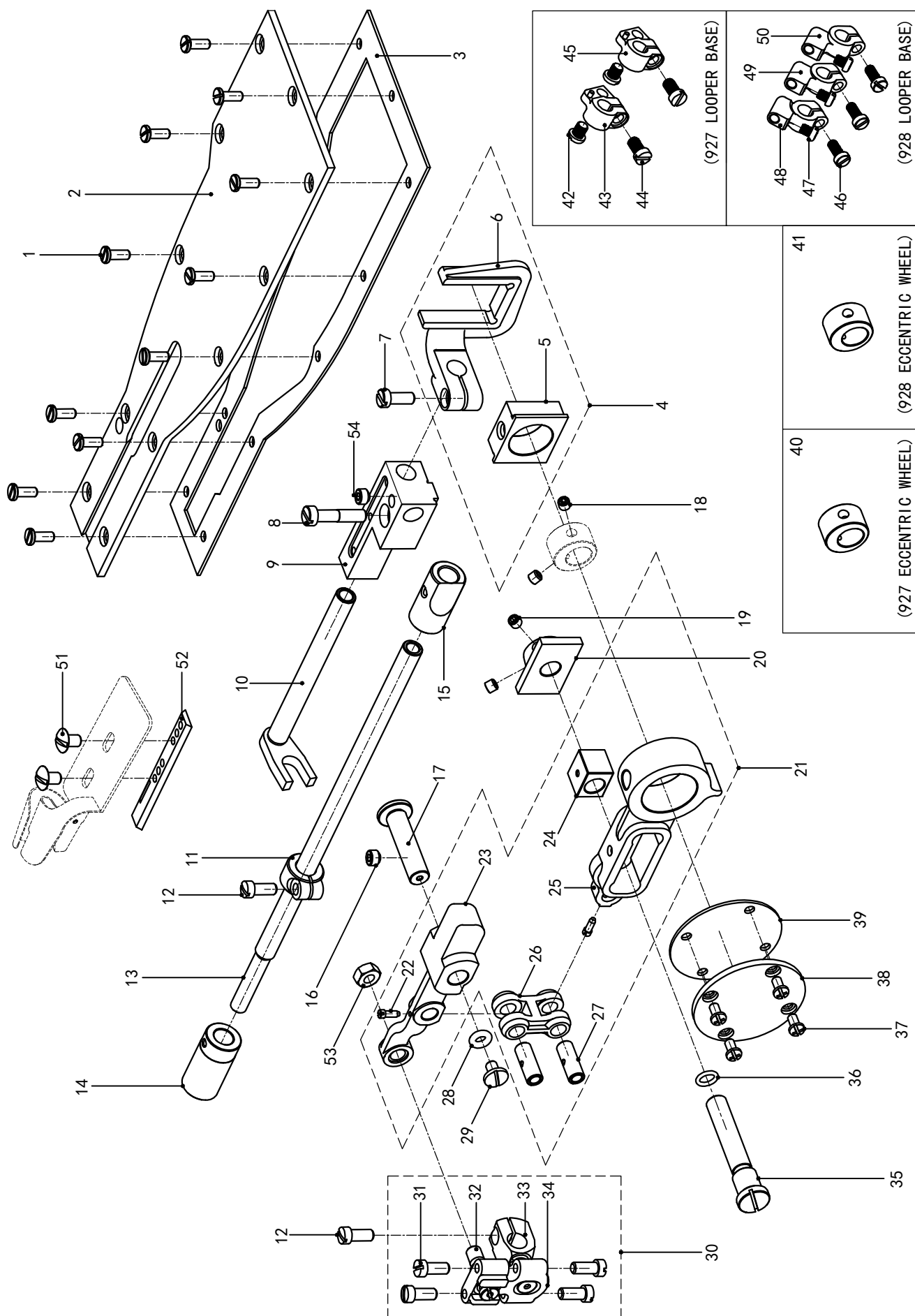
F-下轴装置 Lower shaft mechanism



F-下轴装置 Lower shaft mechanism

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927F-1	927F001	下轴/Lower Shaft	1
2	927F-2	LD00149	螺钉SM4. 36-9. 2/Screw SM4.36	1
3	927F-3	ZC00011	轴承/Ball Bearing	1
4	927F-4	ZC00012	轴承/Ball Bearing	1
5	927F-5	927F005	轴承套筒/Ball Bearing Bush	1
6	927F-6	LD00197	紧定螺钉M4X3. 2/Screw M4	2
7	927F-7	TDQ00004	弹性挡圈C42/Retaining Ring	1
8	927F-8	ZC00009	轴承/Ball Bearing	1
9	927F-9	927B010	轴承压板/Bearing Presser	1
10	927F-10	LD00137	螺钉SM4. 76-10/Screw SM4.76	3
11	927F-11	LD00150	螺钉SM6. 35-9/Screw SM6.35	1

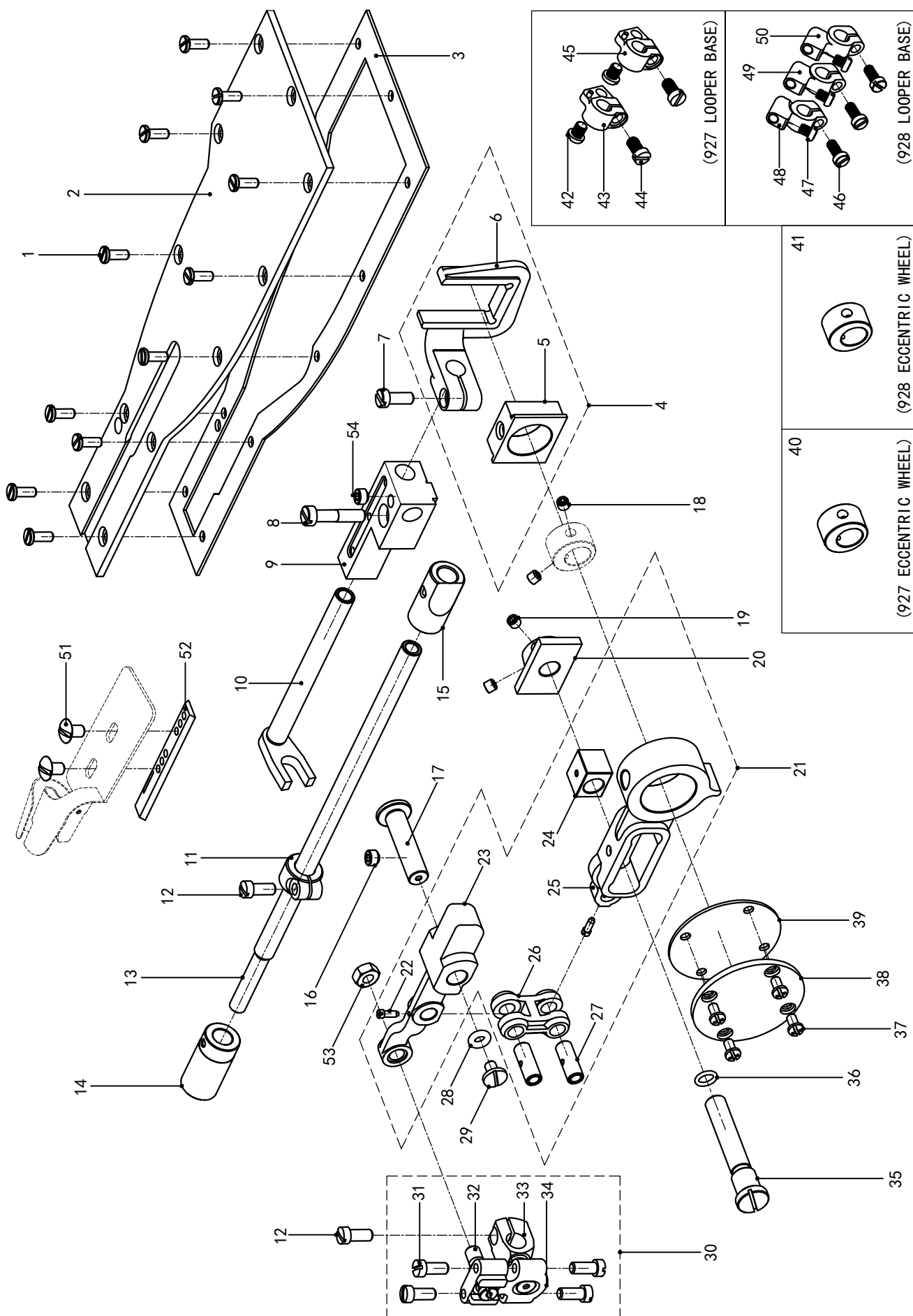
G-挑线叉组件 Lopper mechanism



G-挑线叉组件 Lopper mechanism

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927G-1	LD00151	螺钉SM3. 57-8. 9/Screw SM3.57	11
2	927G-2	927G002	前臂盖/Front Feed Arm Cap	1
3	927G-3	927G003	前臂盖防油垫/Packing	1
4	927G-4	927G004	拨叉组件/Lopper Peeding Fopk Assy	1
5	927G-5	927G005	拨叉滑块/Eccentric Wheel Sleeve	1
6	927G-6	927G006	拨叉/Lopper Peeding Fopk	1
7	927G-7	LD00069	螺钉SM4. 36-13/Screw SM4.36	1
8	927G-8	LD00153	螺钉SM4. 76-22/Screw SM4.76	1
9	927G-9	927G009	拨叉支座/Lopper F/Fopk Shaft Bracke	1
10	927G-10	927G010	拨叉轴/Lopper Peeding Fopk Shaft	1
11	927G-11	927G011	打环器轴挡圈/Looper Shaft SetCollar	1
12	927G-12	LD00265	螺钉SM4. 36-10/Screw SM4.36	2
13	927G-13	927G013	打环器轴/Looper Shaft	1
14	927G-14	927G014	打环器轴套筒B/Looper Shaft Bush,B	1
15	927G-15	927G015	打环器轴套筒F/Looper Shaft Bush,F	1
16	927G-16	LD00146	紧定螺钉SM5. 95-8/Screw SM5.95	1
17	927G-17	927G017	打环器连接杆销/Looper Lever Pin	1
18	927G-18	LD00155	紧定螺钉SM4. 36-3. 5/Screw SM4.36	2
19	927G-19	LD00023	紧定螺钉SM4. 36-5/Screw SM4.36	2
20	927G-20	927G020	滑块连杆挡板/Plate	1
21	927G-21	927G021	打环器连杆组件/LooperConnectingRodAssy	1
22	927G-22	927G022	螺钉SM2. 38/Screw SM2.38	2
23	927G-23	927G023	打环器连接杆/Looper Lever	1
24	927G-24	927G024	连杆滑块/Eccentric Wheel Sleeve	1
25	927G-25	927G025	打环器滑块连杆/Looper Connecting Rod	1
26	927G-26	927G026	打环器短连杆/Looper Connecting Rod	1
27	927G-27	927G027	短连杆销/Connecting Rod Pin	2
28	927G-28	□XQ00006	O形圈9/O Ring	1
29	927G-29	LD00156	螺钉SM4. 36/Screw SM4.36	1
30	927G-30	927G030	球头连杆组件/Ball parts	1
31	927G-31	LD00157	螺钉SM3. 57-10/Screw SM3.57	4
32	927G-32	927G032	球头螺栓/Steel Ball	1
33	927G-33	927G033	球头连杆/Ball head Connecting Rod	1
34	927G-34	927G034	球头外套连杆/BallHeadCoatConnectingRod	1
35	927G-35	927G035	打环器滑块销/Slide Brock Shaft	1

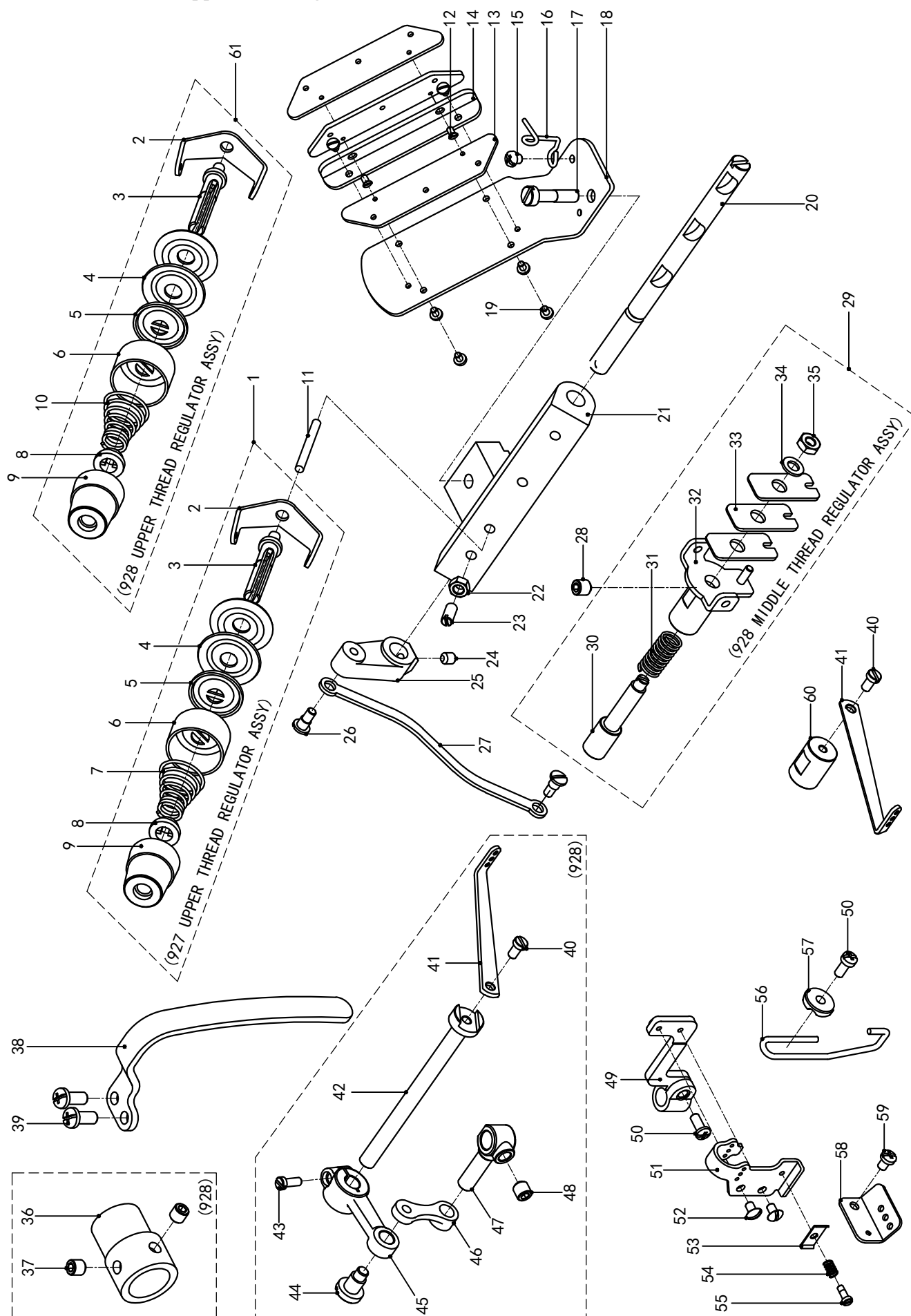
G-挑线叉组件 Lopper mechanism



G-挑线叉组件 Lopper mechanism

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
36	927G-36	□XQ00007	O形圈9/O Ring	1
37	927G-37	LD00135	螺钉SM3. 57-6/Screw SM3.57	4
38	927G-38	927G038	圆盖/Ball Bearing	1
39	927G-39	927G039	圆盖油垫/Packing	1
40	927G-40	927G040	927偏心轮/927 Eccentric Wheel	1
41	928G-41	928G041	928偏心轮/928 Eccentric Wheel	1
42	927G-42	LD00158	螺钉SM4. 36-5. 5/Screw SM4.36	2
43	927G-43	927G043	弯针座S/Looper Holder,S	1
44	927G-44	LD00159	螺钉SM4. 36-8/Screw SM4.36	2
45	927G-45	927G045	弯针座L/Looper Holder,L	1
46	928G-46	LD00145	螺钉SM3. 57-8/Screw SM3.57	3
47	928G-47	LD00160	螺钉SM3. 57-4. 4/Screw SM3.57	3
48	928G-48	928G048	弯针座L/Looper Holder,L	1
49	928G-49	928G049	弯针座M/Looper Holder,M	1
50	928G-50	928G050	弯针座R/Looper Holder,R	1
51	927G-51	LD00176	螺钉SM3. 57/Screw SM3.57	1
52	927G-52	927G052	卷边器滑块/Lapper Guide Plate	1
53	927G-53	LM00002	螺母SM5. 95/Nut SM5.95	1
54	927G-54	LD00166	螺钉SM5. 95/Screw SM5.95	1

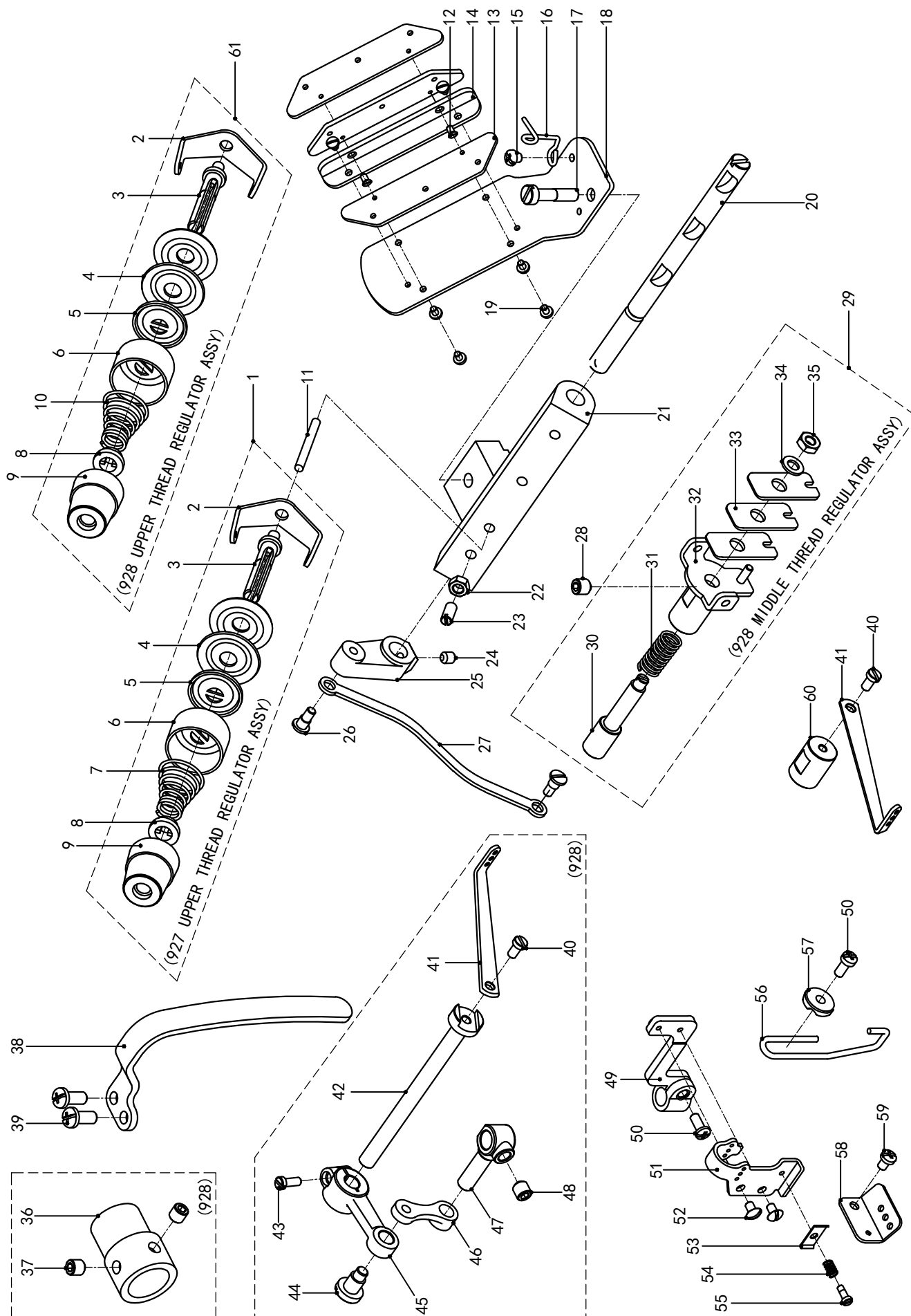
H-上引线装置 Upper threading mechanism



H-上引线装置 Upper threading mechanism

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927H-1	927H001	927夹线器组件/UpperThreadRegulatorAssy	3
2	927H-2	927H002	夹线器过线板/Needle Thread Guide	3
3	927H-3	927H003	夹线器柱/Tension Stud	6
4	927H-4	927H004	夹线板/Tension Disc	3
5	927H-5	927H005	夹线器顶销压盘/Tension Disc Presser	3
6	927H-6	927H006	夹线器弹簧压盘/Tension Disc Presser	3
7	927H-7	927H007	927夹线簧/Spring	2
8	927H-8	927H008	夹线器齿动齿圈/Tension Disc Washer	3
9	927H-9	927H009	夹线器调节螺母/Tension Nut	3
10	928H-10	928H010	928夹线簧/Spring	3
11	927H-11	927H011	夹线器顶销/Pin	3
12	927H-12	LD00162	螺钉SM2. 38-4/Screw SM2.38	2
13	927H-13	927H013	上过线板/Thread Retainer	3
14	927H-14	927H014	上过线板连接板/Thread Guide Set Plate	1
15	927H-15	LD00067	螺钉SM3. 57-4/Screw SM3.57	1
16	927H-16	927H016	上过线板引线钩/Thread Guide	1
17	927H-17	LD00177	螺钉SM4. 76-24/Screw SM4.76	1
18	927H-18	927H018	上过线板支架/Upper Thread Guide	1
19	927H-19	LD00161	螺钉SM2. 38-3. 6/Screw SM2.38	4
20	927H-20	927H020	夹线器支架轴/Tension Release Shaft	1
21	927H-21	927H021	夹线器支架/UpperThread Tension Bracket	1
22	927H-22	LM00001	螺母SM4. 36/Nut SM4.36	1
23	927H-23	927H023	螺钉/Screw	1
24	927H-24	LD00023	螺钉SM4. 36-4/Screw SM4.36	1
25	927H-25	927H025	松线曲柄/Tension Release Crank	1
26	927H-26	927H026	松线连杆螺钉/Screw	2
27	927H-27	927H027	松线连杆/Tension Release Connecting Rod	1
28	927H-28	LD00146	螺钉SM5. 95/Screw SM5.95	1
29	928H-29	928H029	中夹线器组件/MiddleThreadRegulatopAssy	1
30	928H-30	928H030	上线夹松紧支架/UpperThread Tension Bracket	1
31	928H-31	TH00022	弹簧/Spring	1
32	928H-32	928H032	中夹线器支架/Middle Thread Regulatop	1
33	928H-33	928H033	中夹线器夹线片/Tension Disc	3
34	928H-34	DQ00034	平垫圈5/Washer	1
35	928H-35	LM00008	螺母SM4. 36/Nut SM4.36	1

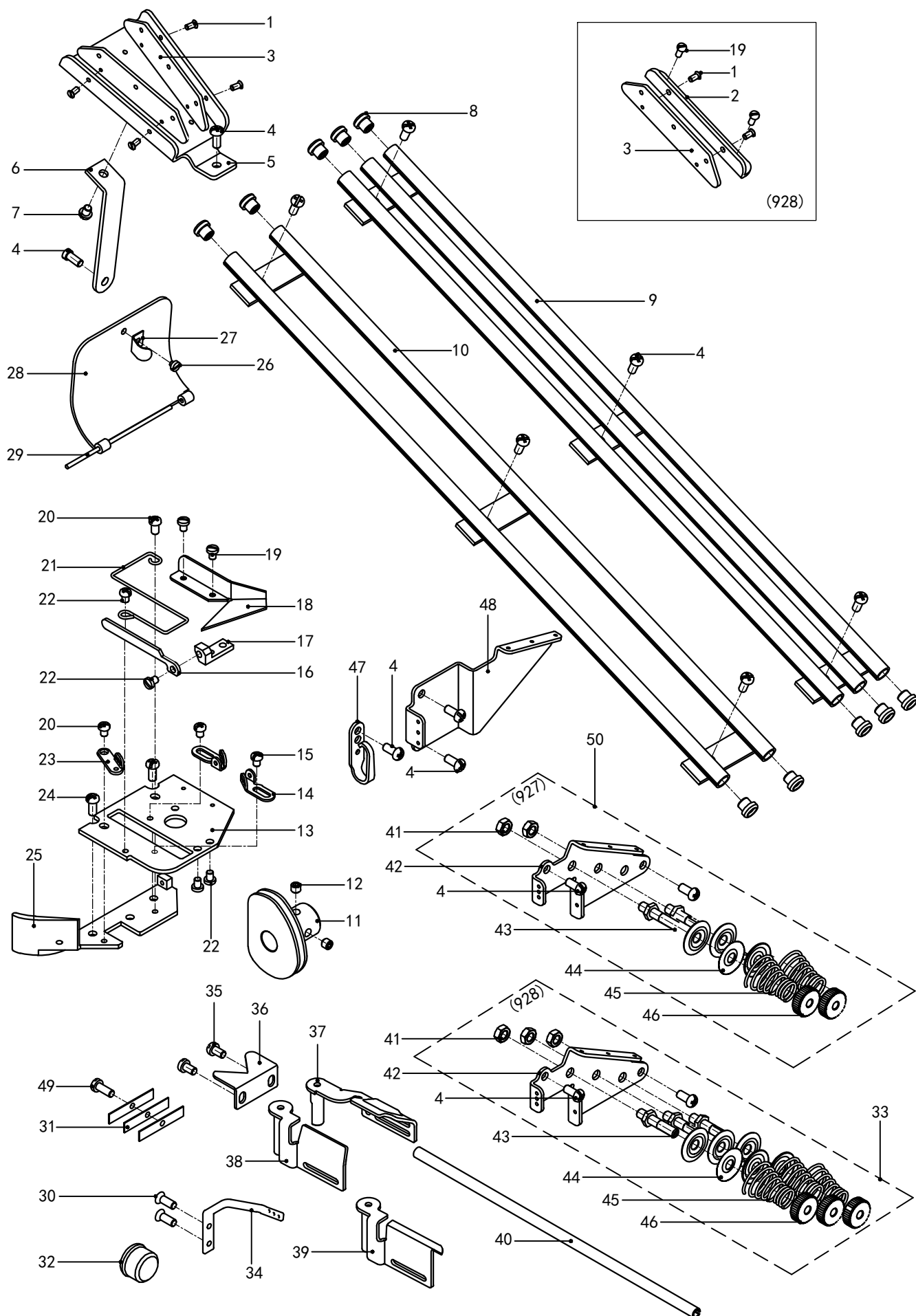
H-上引线装置 Upper threading mechanism



H-上引线装置 Upper threading mechanism

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
36	928H-36	928H036	中夹线器偏心套筒/Eccentric Wrench	1
37	928H-37	LD00166	螺钉SM5. 95-4/Screw SM5.95	2
38	927H-38	927H038	上引线装置护手/Thread Take-Up Cover	1
39	927H-39	LD00137	螺钉SM4. 76-10/Screw SM4.76	2
40	927H-40	LD00140	螺钉SM3. 57-7/Screw SM3.57	1
41	927H-41	927H041	中引线柄/Tension Release Lever	1
42	928H-42	928H042	中引线柄支架/Tension Release Lever Shaft	1
43	928H-43	LD00026	螺钉M4-10/Screw M4	1
44	928H-44	928H044	连杆轴位螺钉/Shoulder Screw	1
45	928H-45	928H045	中引线柄连杆/Connecting Rod	1
46	928H-46	928H046	短连杆/Short Connecting Rod	1
47	928H-47	928H047	短连杆连接柱/Tension Release Stud	1
48	928H-48	LD00143	紧定螺钉SM5. 95-6/Screw SM5.95	1
49	927H-49	927H049	上引线板支架/UpperThreadGuideBracket	1
50	927H-50	LD00139	螺钉SM3. 57-7. 5/Screw SM3.57	2
51	927H-51	927H051	上引线板/Upper Thread Guide	1
52	927H-52	LD00164	螺钉SM3. 18-5/Screw SM3.18	2
53	927H-53	927H053	上引线板压线板/Thread Tension Disc	1
54	927H-54	TH00023	弹簧/Spring	1
55	927H-55	927H055	上引线板弹簧螺钉/Screw	1
56	927H-56	927H056	上引线钩/Upper Thread Take-Up Guide	1
57	927H-57	927H057	上引线钩垫块/Washer	1
58	927H-58	927H058	下引线板/Upper Thread Guide	1
59	927H-59	LD00135	螺钉SM3. 57-6/Screw SM3.57	1
60	927H-60	927H060	中引线柄支架块/TensionReleaseLeverBracket	1
61	928H-61	928H061	928夹线器组件/UpperThreadRegulatorAssy	3

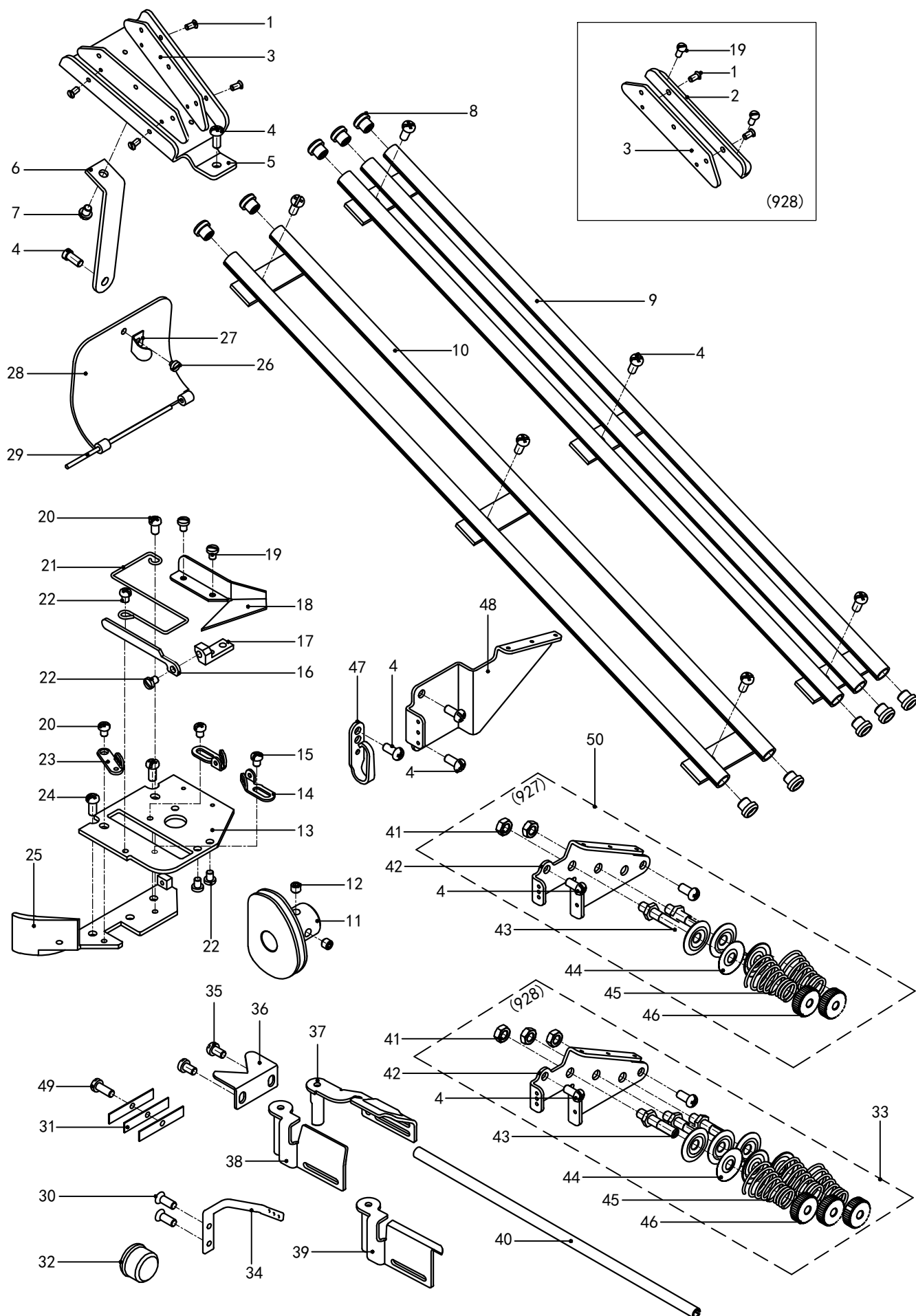
I-下引线装置 Lower threading mechanism



I-下引线装置 Lower threading mechanism

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927I-1	LD00162	沉头螺钉SM2. 38-4/Screw SM2.38	6
2	928I-2	927H014	过线板连接板/Thread Guide Set Plate	1
3	927I-3	927H013	过线板/Thread Retainer	3
4	927I-4	LD00134	螺钉SM3. 57-8/Screw SM3.57	10
5	927I-5	927I005	过线板支架/Lower Thread Guide Retainer	1
6	927I-6	927I006	过线板支架支撑条/LowerThreadGuideSupport	1
7	927I-7	LD00067	螺钉SM3. 57-4/Screw SM3.57	1
8	927I-8	927I008	过线管嵌套/Inglined Guide Tube Nesting	6
9	928I-9	928I009	928过线管组件/Inglined Guide Tube Assy	1
10	927I-10	927I010	927过线管组件/Inglined Guide Tube Assy	1
11	927I-11	927I011	导线轮/Thread Guide	1
12	927I-12	LD00178	紧定螺钉SM4. 36-3. 2/Screw SM4.36	2
13	927I-13	927I013	下过线器支架板/L/Tr.Take-UpLeverBracket	1
14	927I-14	927I014	下过线器导线板一/Lower Thread Guide	2
15	927I-15	LD00179	螺钉3. 18-3. 2/Screw SM2.38	2
16	927I-16	927I016	下过线器压线板/Lower Thread Presser	1
17	927I-17	927I017	下过线器压线板支架/Thread Release Base	1
18	927I-18	927I018	下过线器引线板/Guide Plate	1
19	927I-19	LD00161	螺钉SM2. 38-3. 6/Screw SM2.38	4
20	927I-20	LD00135	螺钉SM3. 57-5. 5/Screw SM3.57	2
21	927I-21	927I021	下过线器导线钢丝/Lower Thread Guide	1
22	927I-22	LD00167	螺钉SM3. 18-4/Screw SM3.18	4
23	927I-23	927I023	下过线器导线板二/Lower Thread Guide	1
24	927I-24	LD00168	螺钉SM3. 57-7. 5/Screw SM3.57	2
25	927I-25	927I025	下过线器支架/L/Tr.Take-UpLeverBracket	1
26	927I-26	LD00065	螺钉SM2. 38-2/Screw SM2.38	1
27	927I-27	927I027	下过线器盖弹簧片/Spring	1
28	927I-28	927I028	下过线器盖/L/ThreadTake-UpLeverCover	1
29	927I-29	927I029	下过线器盖轴销/Pin	1
30	927I-30	LD00342	螺钉SM3. 18-7/Screw SM3.18	2
31	927I-31	927I031	护罩弹簧片/Leaf Spring	3
32	927I-32	927I032	橡胶塞15. 5/Rubber Cap	1
33	928I-33	928I033	下引线过线器组件(三线)	1
34	927I-34	927I034	弯针引线板/Looper Thread Guide	1
35	927I-35	LD00067	螺钉SM3. 57-4/Screw SM3.57	2

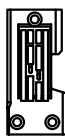
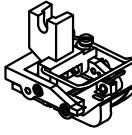
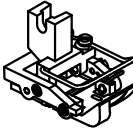
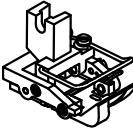
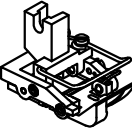
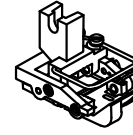
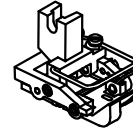
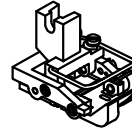
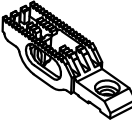
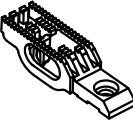
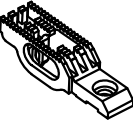
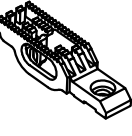
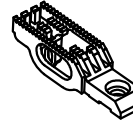
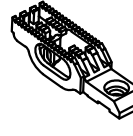
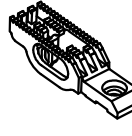
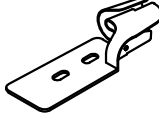
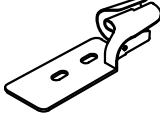
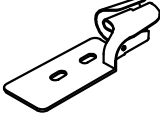
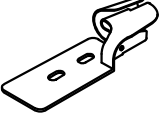
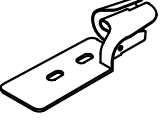
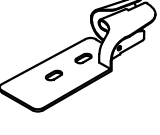
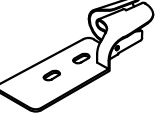
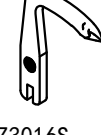
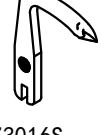
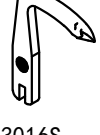
I-下引线装置 Lower threading mechanism

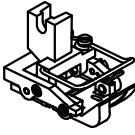
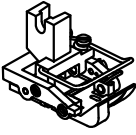
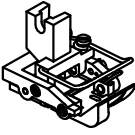
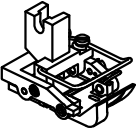
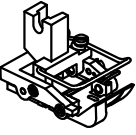
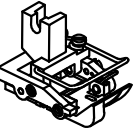
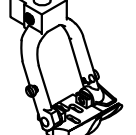
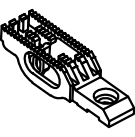
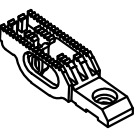
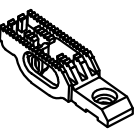
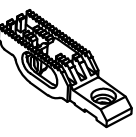
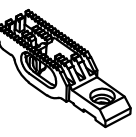
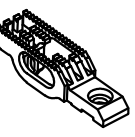
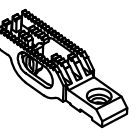
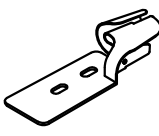
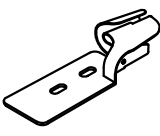
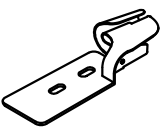
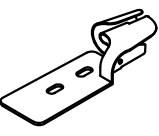
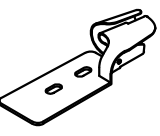
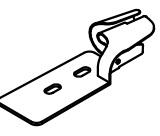
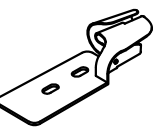


I-下引线装置 Lower threading mechanism

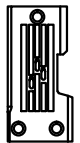
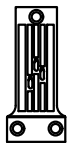
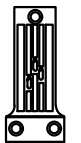
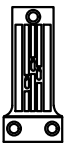
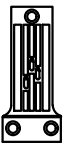
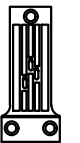
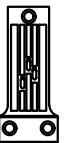
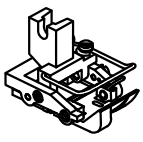
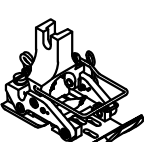
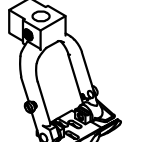
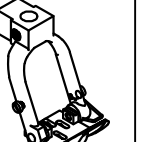
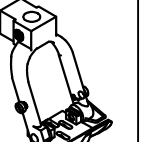
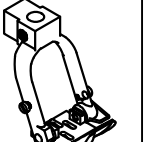
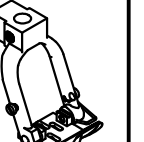
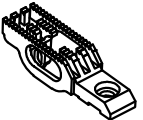
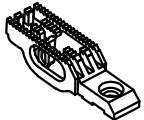
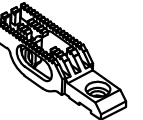
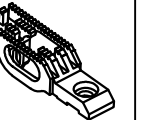
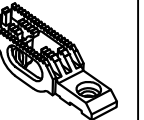
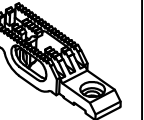
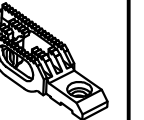
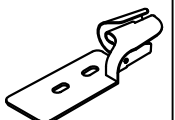
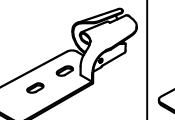
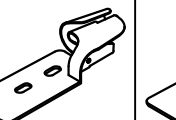
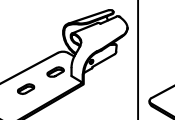
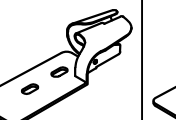
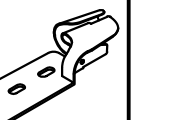
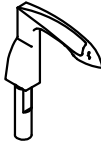
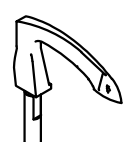
序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
36	927I-36	927I036	割线刀片/Thread Trimmer	1
37	927I-37	927I037	弯针护罩右/Looper Cover,Ra	1
38	927I-38	927I038	弯针护罩左/Looper Cover,La	1
39	928I-39	928I039	弯针护罩左928/Looper Cover,Lb	1
40	927I-40	927I040	前臂过线管/Lower Thread Feed BarGuide	1
41	927I-41	LM00001	螺母SM4. 36/Nut SM4.36	3
42	927I-42	927I042	下引线过线板/Thread Retainer	1
43	927I-43	927I043	下引线夹线器柱/Thread Nipper Prop	3
44	927I-44	927I044	夹线盘/Thread Guide Disc	6
45	927I-45	927I045	下引线夹线器簧/Spring	3
46	927I-46	927I046	下引线夹线器调节螺母/Nut	3
47	927I-47	927I047	下引线钩/Arm Thread Guide, M	3
48	927I-48	927I048	下引线板/Lower Thread Guide	1
49	927I-49	LD00191	螺钉SM3. 57-6/Screw SM3.57	1
50	927I-50	927I050	下引线过线器组件(两线)	1

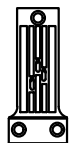
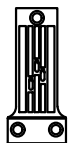
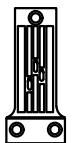
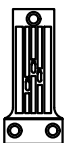
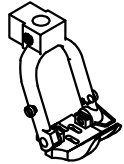
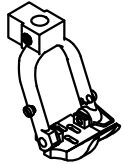
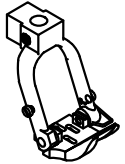
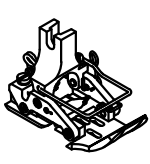
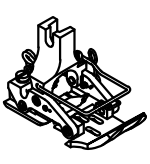
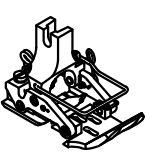
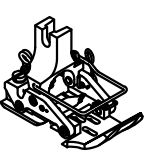
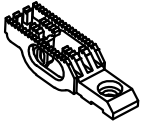
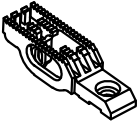
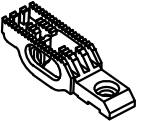
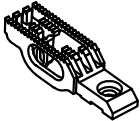
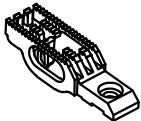
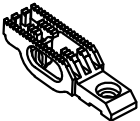
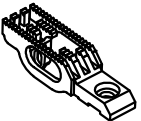
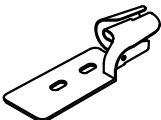
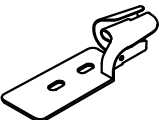
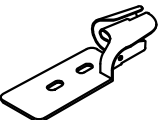
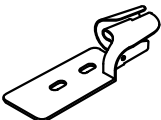
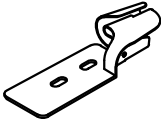
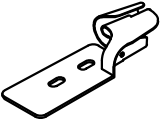
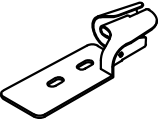
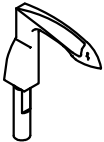
J1-规格零部件表 Different parts list

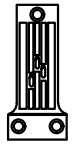
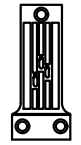
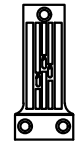
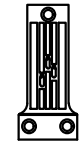
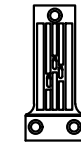
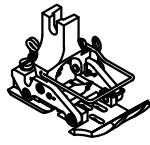
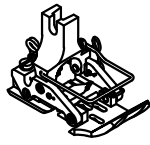
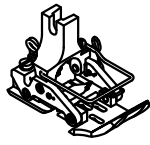
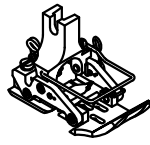
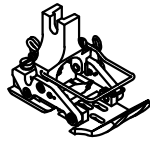
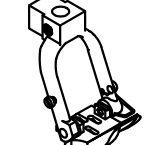
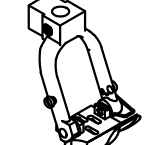
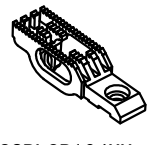
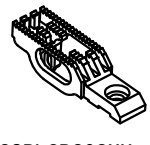
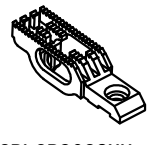
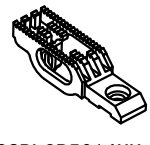
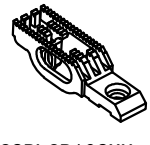
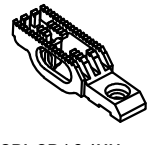
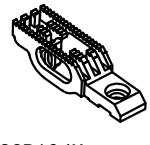
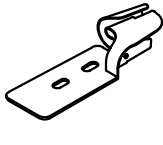
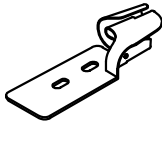
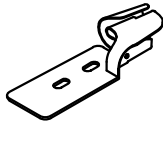
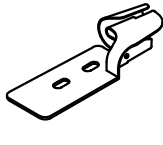
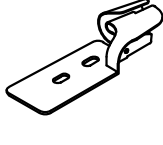
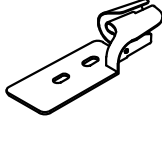
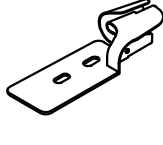
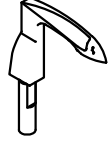
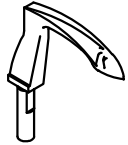
927 Thin Materials / Medium Materials							
针位类型 Type	1/4 (6.4mm)	3/16 (4.8mm)	1/8 (3.2mm)	7/32 (5.6mm)	PS1/4 (6.4mm)	PS3/16 (4.8mm)	PS1/8 (3.2mm)
针夹ZJ Needle Clamp	 2ZJ104	 2ZJ3016	 2ZJ108	 2ZJ7032	 2ZJ104	 2ZJ3016	 2ZJ108
机针JZ Needles	TVx64#14	TVx64#14	TVx64#14	TVx64#14	TVx64#14	TVx64#14	TVx64#14
针板ZB Needle Plate	 2ZB104	 2ZB3016	 2ZB108	 2ZB7032	 2ZB104	 2ZB3016	 2ZB108
压脚YJ Presser Foot Assy	 2YJ104	 2YJ3016	 2YJ108	 2YJ7032	 2YJ104	 2YJ3016	 2YJ108
送布牙SB Feed Dog	 2SB104	 2SB3016	 2SB108	 2SB7032	 2SB104	 2SB3016	 2SB108
卷边器JB Lapper Assy	 2JB104	 2JB3016	 2JB108	 2JB7032	 2JB104	 2JB3016	 2JB108
挑线叉(S) Looper (S)	 2WZ104S	 2WZ3016S	 2WZ3016S	 2WZ104S	 2WZ104S	 2WZ3016S	 2WZ3016S
挑线叉(M) Looper (M)							
挑线叉(L) Looper (L)	 2WZ104L	 2WZ3016L	 2WZ3016L	 2WZ104L	 2WZ104L	 2WZ3016L	 2WZ3016L

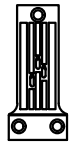
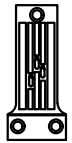
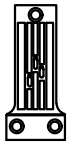
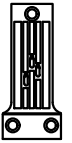
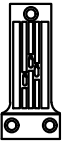
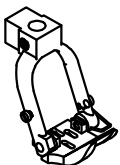
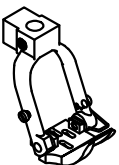
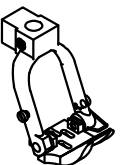
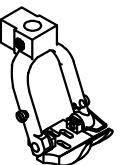
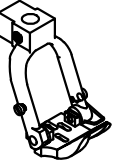
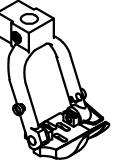
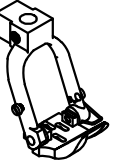
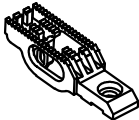
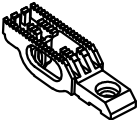
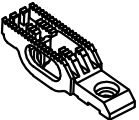
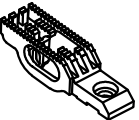
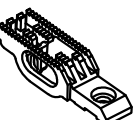
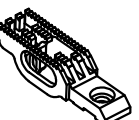
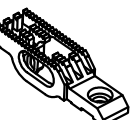
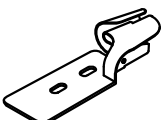
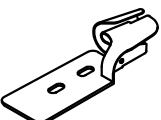
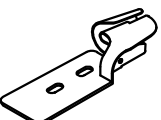
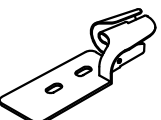
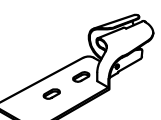
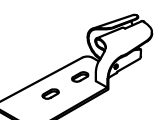
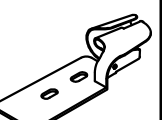
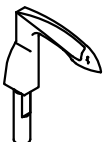
927 Thin Materials / Medium Materials							
针位类型 Type	PS7/32 (5.6mm)	PL1/4 (6.4mm)	PL3/16 (4.8mm)	PL1/8 (3.2mm)	PL7/32 (5.6mm)	3/16C (4.8mm)	3/16A (4.8mm)
针夹ZJ Needle Clamp	 2ZJ7032	 2ZJ104	 2ZJ3016	 2ZJ108	 2ZJ7032	 2ZJ3016C	 2ZJ3016
机针JZ Needles	TVx64#14	TVx64#14	TVx64#14	TVx64#14	TVx64#14	TVx64#14	TVx64#14
针板ZB Needle Plate	 2ZB7032	 2ZB104	 2ZB3016	 2ZB108	 2ZB7032	 2ZB3016C	 2ZB3016A
压脚YJ Presser Foot Assy	 2YJ7032	 2YJ104	 2YJ3016	 2YJ108	 2YJ7032	 2YJ3016C	 2YJ3016A
送布牙SB Feed Dog	 2SB7032	 2SB104	 2SB3016	 2SB108	 2SB7032	 2SB3016C	 2SB3016A
卷边器JB Lapper Assy	 2JB7032	 2JB104	 2JB3016	 2JB108	 2JB7032	 2JB3016	 2JB3016
挑线叉(S) Looper (S)	 2WZ104S	 2WZ104S	 2WZ3016S	 2WZ3016S	 2WZ104S	 2WZ3016S	 2WZ3016S
挑线叉(M) Looper (M)							
挑线叉(L) Looper (L)	 2WZ104L	 2WZ104L	 2WZ3016L	 2WZ3016L	 2WZ104L	 2WZ3016L	 2WZ3016L

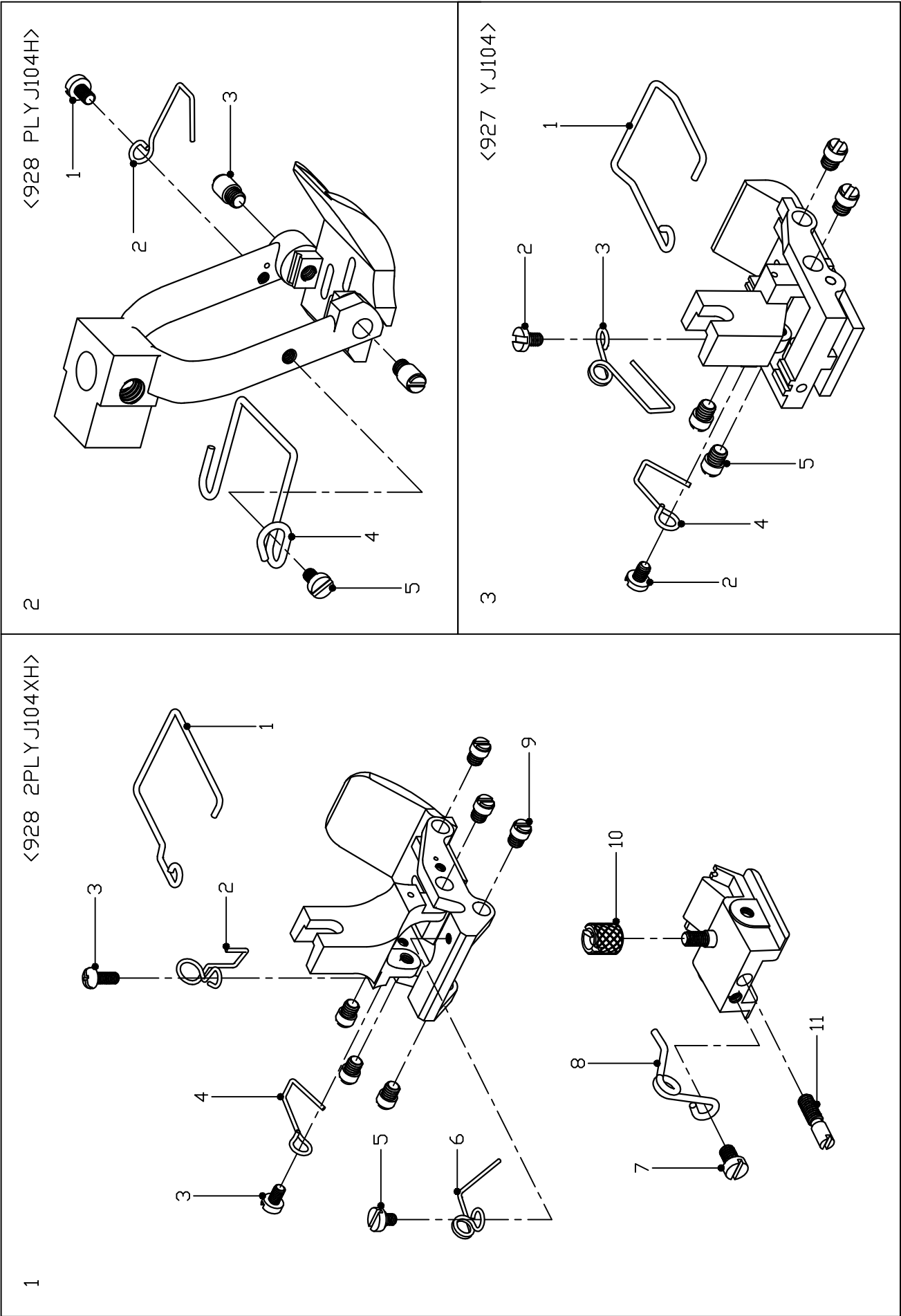
928 Medium Materials / Heavy Materials

针位类型 Type	1/4 (6.4mm) Thin Materials	1/4 (6.4mm) Medium Materials	PL1/4 (6.4mm) Medium Materials	PL3/8 (9.5mm) Medium Materials	PL9/32 (7.1mm) Medium Materials	PL5/16 (7.9mm) Medium Materials	PL1/4 (6.4mm) Heavy Materials
针夹ZJ Needle Clamp	 3ZJ104L	 3ZJ104H	 3ZJ104H	 3PLZJ308H	 3PLZJ9032H	 3PLZJ5016H	 3ZJ104H
机针JZ Needles	TVx64#14	TVx5 #18	TVx5 #18	TVx5 #18	TVx5 #18	TVx5 #18	TVx5 #21
针板ZB Needle Plate	 3ZB104L	 3ZB104H	 3ZB104H	 3PLZB308H	 3PLZB9032H	 3PLZB5016H	 3PLZB104XH
压脚YJ Presser Foot Assy	 3YJ104L	 3YJ104H	 3YJ104H	 3PLYJ308H	 3PLYJ9032H	 3PLYJ5016H	 3PLYJ104XH
送布牙SB Feed Dog	 3SB104L	 3SB104H	 3SB104H	 3PLSB308H	 3PLSB9032H	 3PLSB5016H	 3PLSB104XH
卷边器JB Lapper Assy	 3JB104L	 3JB104H	 3JB104H	 3PLJB308H	 3PLJB9032H	 3PLJB5016H	 3PLJB104XH
挑线叉(S) Looper (S)	 3WZS40375	←	←	←	←	←	←
挑线叉(M) Looper (M)	 3WZS40376	←	←	←	←	←	←
挑线叉(L) Looper (L)	 3WZS40377	←	←	←	←	←	←

928 Medium Materials / Heavy Materials							
针位类型 Type	PL3/8 (9.5mm) Heavy Materials	PL9/32 (7.1mm) Heavy Materials	PL5/16 (7.9mm) Heavy Materials	2PL1/4 (6.4mm) Medium Materials	2PL3/8 (9.5mm) Medium Materials	2PL9/32 (7.1mm) Medium Materials	2PL5/16 (7.9mm) Medium Materials
针夹ZJ Needle Clamp	 3PLZJ308XH	 3PLZJ9032XH	 3PLZJ5016XH	 3ZJ104H	 32PLZJ308H	 32PLZJ9032H	 32PLZJ5016H
机针JZ Needles	TVx5 #21	TVx5 #21	TVx5 #21	TVx5 #18	TVx5 #18	TVx5 #18	TVx5 #18
针板ZB Needle Plate	 3PLZB308XH	 3PLZB9032XH	 3PLZB5016XH	 3ZB104H	 32PLZB308H	 32PLZB9032H	 32PLZB5016H
压脚YJ Presser Foot Assy	 3PLYJ308XH	 3PLYJ9032XH	 3PLYJ5016XH	 3YJ104H	 32PLYJ308H	 32PLYJ9032H	 32PLYJ5016H
送布牙SB Feed Dog	 3PLSB308XH	 3PLSB9032XH	 3PLSB5016XH	 3SB104H	 32PLSB308H	 32PLSB9032H	 32PLSB5016H
卷边器JB Lapper Assy	 3PLJB308XH	 3PLJB9032XH	 3PLJB5016XH	 3JB104H	 32PLJB308H	 32PLJB9032H	 32PLJB5016H
挑线叉(S) Looper (S)	 3WZS40375	←	←	←	←	←	←
挑线叉(M) Looper (M)	 3WZS40376	←	←	←	←	←	←
挑线叉(L) Looper (L)	 3WZS40377	←	←	←	←	←	←

928 Medium Materials / Heavy Materials							
针位类型 Type	2PL1/4 (6.4mm) Heavy Materials	2PL3/8 (9.5mm) Heavy Materials	2PL9/32 (7.1mm) Heavy Materials	2PL5/16 (7.9mm) Heavy Materials	2PL1/2 (12.7mm) Heavy Materials	PF/CV1/4 (6.4mm) Heavy Materials	PS1/4 (6.4mm) Medium Materials
针夹ZJ Needle Clamp	 3ZJ104H	 32PLZJ308XH	 3PLZJ9032XH	 32PLZJ5016XH	 32PLZJ102XH	 3ZJ104H	 3ZJ104H
机针JZ Needles	TVx5 #21	TVx5 #21	TVx5 #21	TVx5 #21	TVx5 #21	TVx5 #21	TVx5 #18
针板ZB Needle Plate	 32PLZB104XH	 32PLZB308XH	 3PLZB9032XH	 32PLZB5016XH	 32PLZB102XH	 3PLZB104XH	 3ZB104H
压脚YJ Presser Foot Assy	 32PLYJ104XH	 32PLYJ308XH	 32PLYJ9032XH	 32PLYJ5016XH	 32PLYJ102XH	 3PLYJ104XH	 3YJ104H
送布牙SB Feed Dog	 32PLSB104XH	 32PLSB308XH	 3PLSB9032XH	 32PLSB5016XH	 32PLSB102XH	 3PLSB104XH	 3SB104H
卷边器JB Lapper Assy	 3PLJB104XH	 3PLJB308XH	 3PLJB9032XH	 3PLJB5016XH	 32PLJB102XH	 3PLJB104XH	 3JB104H
挑线叉 (S) Looper (S)	 3WZS40375						
挑线叉 (M) Looper (M)	 3WZS40376						
挑线叉 (L) Looper (L)	 3WZS40377						

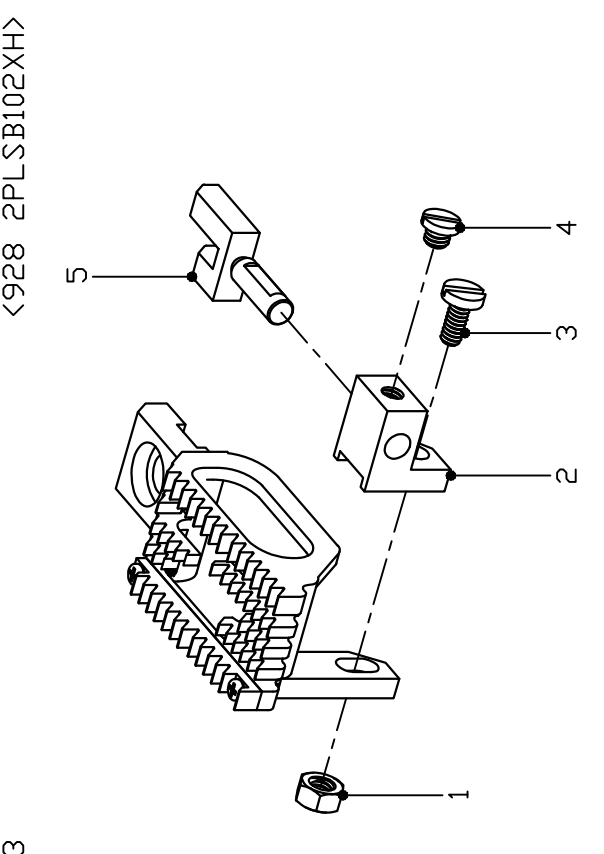
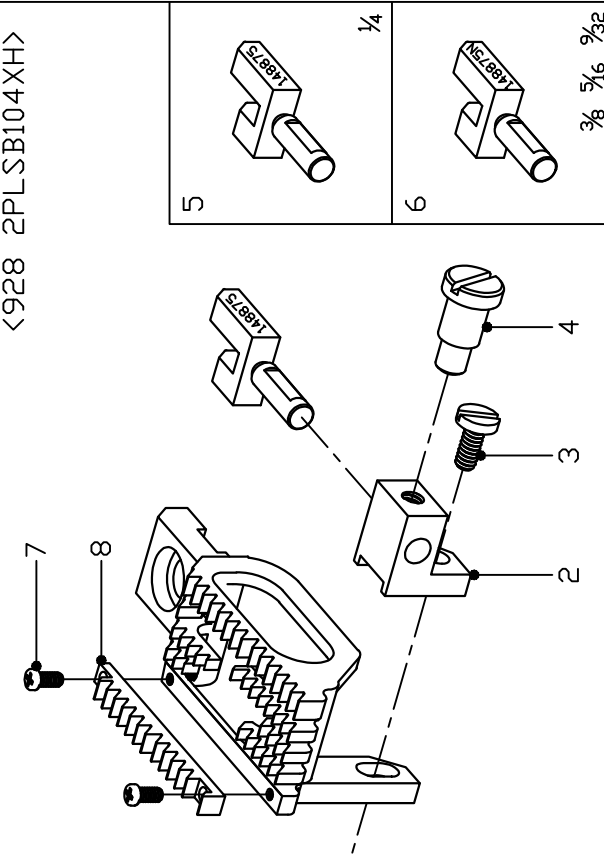
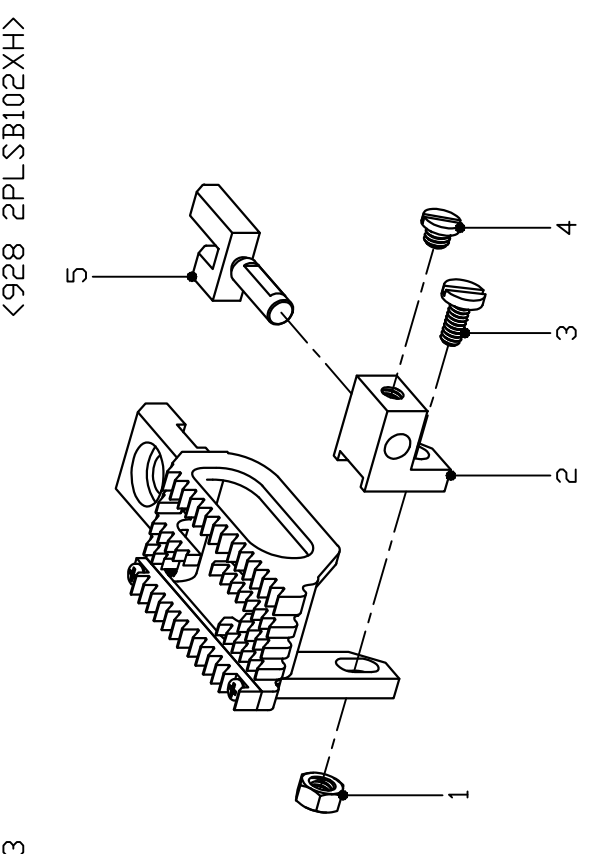
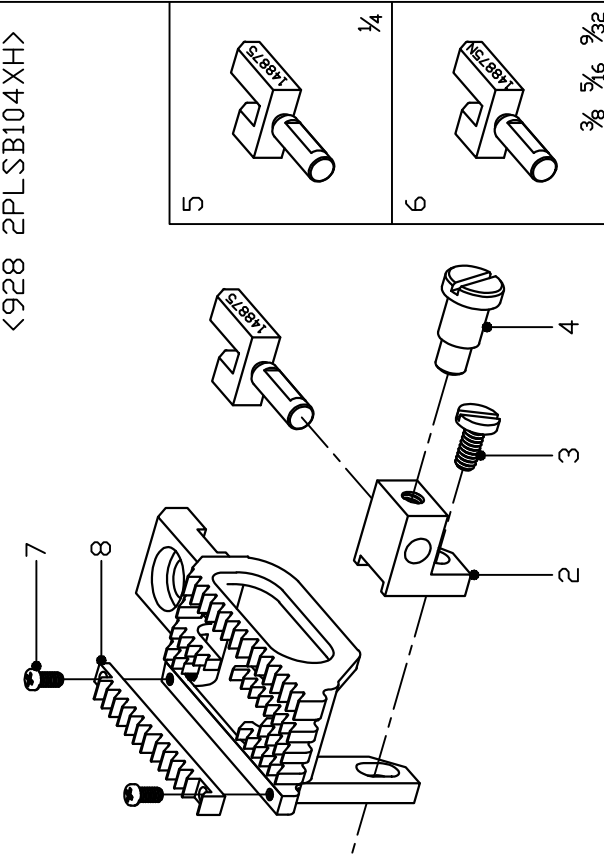
928 Medium Materials / Heavy Materials							
针位类型 Type	PS3/8 (9.5mm) Medium Materials	PS9/32 (7.1mm) Medium Materials	PS5/16 (7.9mm) Medium Materials	PS1/4 (6.4mm) Heavy Materials	PS3/8 (9.5mm) Heavy Materials	PS9/32 (7.1mm) Heavy Materials	PS5/16 (7.9mm) Heavy Materials
针夹ZJ Needle Clamp	 3PLZJ308H	 3PSZJ9032H	 3PLZJ5016H	 3ZJ104H	 3PLZJ308XH	 3PLZJ9032XH	 3PLZJ5016XH
机针JZ Needles	TVx5 #18	TVx5 #18	TVx5 #18	TVx5 #21	TVx5 #21	TVx5 #21	TVx5 #21
针板ZB Needle Plate	 3PLZB308H	 3PSZB9032H	 3PLZB5016H	 3PLZB104XH	 3PLZB308XH	 3PLZB9032XH	 3PLZB5016XH
压脚YJ Presser Foot Assy	 3PLYJ308H	 3PSYJ9032H	 3PLYJ5016H	 3PLYJ104XH	 3PLYJ308XH	 3PLYJ9032XH	 3PLYJ5016XH
送布牙SB Feed Dog	 3PLSB308H	 3PSSB9032H	 3PLSB5016H	 3PLSB104XH	 3PLSB308XH	 3PLSB9032XH	 3PLSB5016XH
卷边器JB Lapper Assy	 3PSJB308H	 3PSJB9032H	 3PLJB5016H	 3PLJB104XH	 3PLJB308XH	 3PLJB9032XH	 3PLJB5016XH
挑线叉(S) Looper (S)	 3WZS40375	←	←	←	←	←	←
挑线叉(M) Looper (M)	 3WZS40376	←	←	←	←	←	←
挑线叉(L) Looper (L)	 3WZS40377	←	←	←	←	←	←



J2-规格零件分解部份

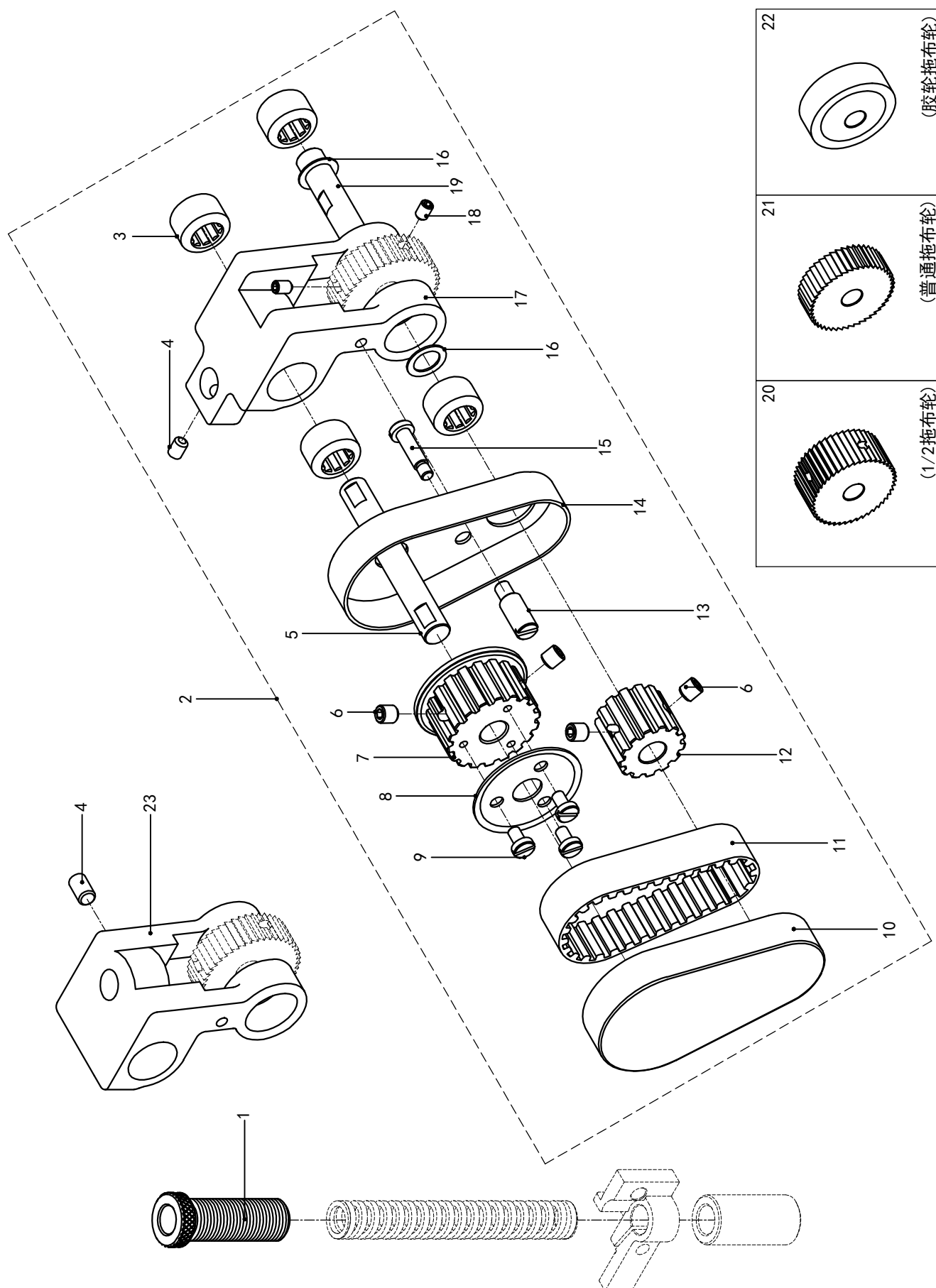
序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	928J2-1-1	928J20101	护指钢丝/Protect a steel wire	1
2	928J2-1-2	928J20102	压脚桥扭簧/Press the feet bridge twist Huang	1
3	928J2-1-3	928J20103	扭簧螺钉/Twist Huang bolt	2
4	928J2-1-4	928J20104	前压脚板扭簧/ Press the sole twist Huang	1
5	928J2-1-5	928J20105	扭簧螺钉/ Twist Huang bolt	1
6	928J2-1-6	928J20106	后压脚板扭簧/ Press the sole twist Huang	1
7	928J2-1-7	928J20107	扭簧螺钉/ Twist Huang bolt	1
8	928J2-1-8	928J20108	中压脚板扭簧/ Press sole to twist Huang	1
9	928J2-1-9	928J20109	压脚板螺钉/ Press sole bolt	6
10	928J2-1-10	928J20110	滚花螺母/ Roll flower Luo a mother	1
11	928J2-1-11	928J20111	中压脚板锁紧螺钉/ Lock tight bolt	1
12	928J2-2-1	928J20201	扭簧螺钉/ Twist Huang bolt	1
13	928J2-2-2	928J20202	压脚板扭簧/ Press the sole twist Huang	1
14	928J2-2-3	928J20203	压脚板螺钉/ Press sole bolt	2
15	928J2-2-4	928J20204	护指钢丝/ Protect a steel wire	1
16	928J2-2-5	928J20205	护指钢丝螺钉/ Protect steel wire bolt	1
17	927J2-3-1	927J20301	护指钢丝/ Protect a steel wire	1
18	927J2-3-2	928J20103	扭簧螺钉/ Twist Huang bolt	2
19	927J2-3-3	927J20303	压脚桥扭簧/ Press the feet bridge twist Huang	1
20	927J2-3-4	927J20304	前压脚板扭簧/ Front press sole to twist Huang	1
21	927J2-3-5	927J20305	压脚板螺钉/ Press sole bolt	4

J3-规格零件分解部份

3 <928 2PLSB102XH>  1 2 3 4 5 1/4 3/8 5/16 9/32	4 <927 SB104>  1 2 3 4 5 1/4 3/8 5/16 9/32
1 <928 2PLSB104XH>  1 2 3 4 5 6 7 8 1/4 3/8 5/16 9/32	2 <928 PLSB104H>  1 2 3 4 5 1/4 3/8 5/16 9/32

J3-规格零件分解部份

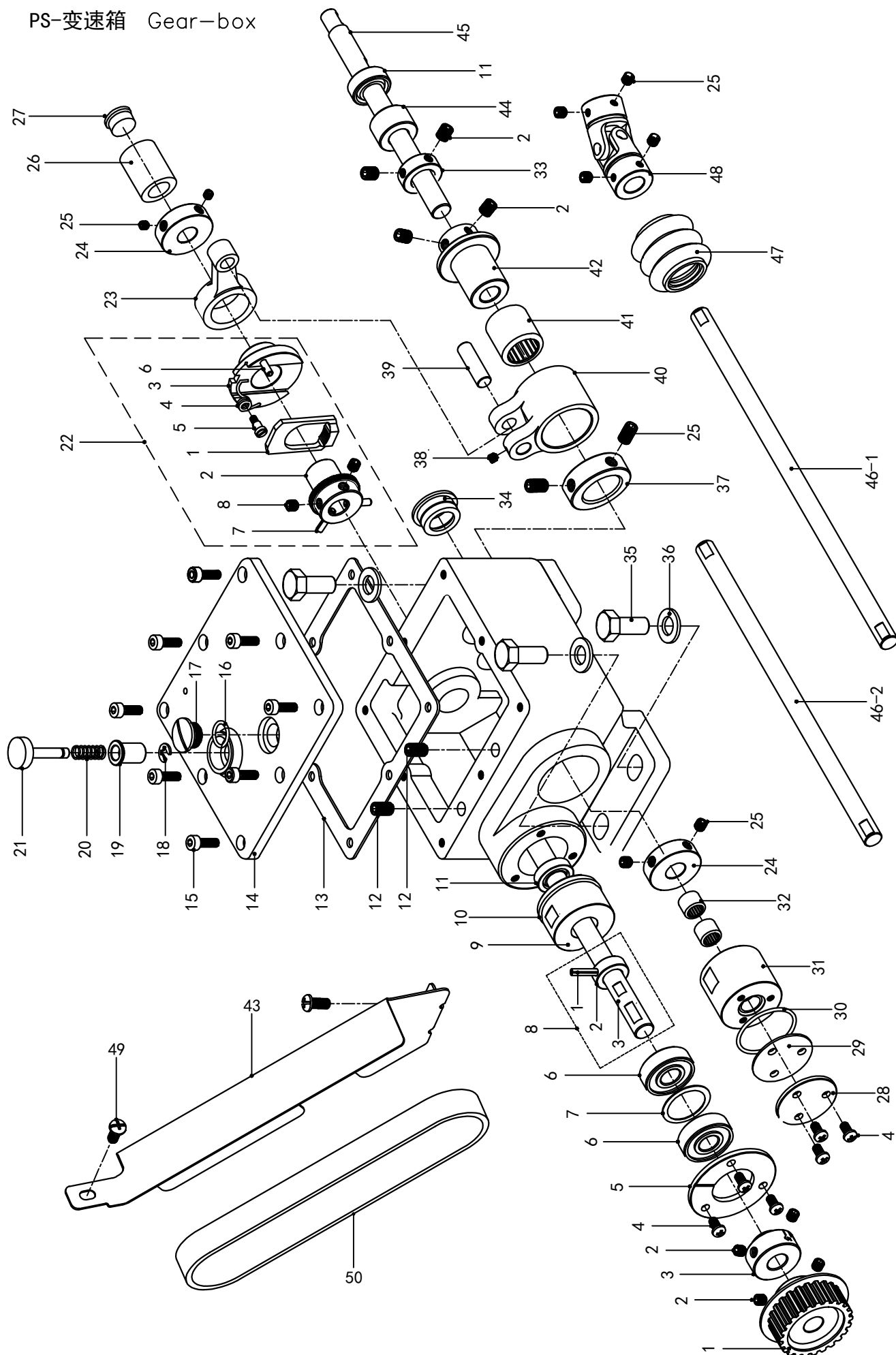
序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	928J3-1-1	928J30101	螺母/Nut	1
2	928J3-1-2	928J30102	导针块支架/Support	1
3	928J3-1-3	928J30103	导针块支架螺钉/Support bolt	1
4	928J3-1-4	928J30104	轴位螺钉/Stalk bolt	1
5	928J3-1-5	928J30105	导针块/Lead a needle piece	1
6	928J3-1-6	928J30106	导针块/Lead a needle piece	1
7	928J3-1-7	928J30107	齿条螺钉/Chi bolt	2
8	928J3-1-8	928J30108	齿条/Chi	1
9	928J3-2-1	928J30101	螺母/Nut	1
10	928J3-2-2	928J30202	导针块支架/Support	1
11	928J3-2-3	928J30103	导针块支架螺钉/Support bolt	1
12	928J3-2-4	928J30204	导针块螺钉/Lead a needle piece bolt	1
13	928J3-2-5	928J30105	导针块/Lead a needle piece	1
14	928J3-2-6	928J30106	导针块/Lead a needle piece	1
15	928J3-3-1	928J30101	螺母/Nut	1
16	928J3-3-2	928J30202	导针块支架/Support	1
17	928J3-3-3	928J30103	导针块支架螺钉/Support bolt	1
18	928J3-3-4	928J30204	导针块螺钉/Lead a needle piece bolt	1
19	928J3-3-5	928J30305	导针块/Lead a needle piece	1
20	928J3-4-1	928J30101	螺母/Nut	1
21	928J3-4-2	927J30402	导针块支架/Support	1
22	928J3-4-3	928J30103	导针块支架螺钉/Support bolt	1
23	928J3-4-4	928J30204	导针块螺钉/Lead a needle piece bolt	1
24	928J3-4-5	927J30405	导针块/Lead a needle piece	1
25	928J3-4-6	927J30406	导针块/Lead a needle piece	1



PST-变速箱拖轮 Gear-box haul material wheel

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927PST-1	927PST001	调压螺母/Presser Adjust Screw	1
2	927PST-2	927PST002	PS拖轮组件/Puller Support Assy	1
3	927PST-3	ZC00014	冲压外圈滚针轴承/Ball Bearing	4
4	927PST-4	LD00131	紧定螺钉SM6. 35-6/Screw SM6.35	1
5	927PST-5	927PST005	上轴/Upper Shaft	1
6	927PST-6	LD00083	紧定螺钉M5-5/Screw M5	4
7	927PST-7	927PST007	上同步轮/Timing Belt Wheel Assy Upper	1
8	927PST-8	927PST008	上同步轮挡片/Flange	1
9	927PST-9	LD00050	螺钉SM3. 57-7/Screw SM3.57	3
10	927PST-10	927PST010	上罩壳/Timing Belt Cover,U	1
11	927PST-11	927PST011	同步带/Timing Belt	1
12	927PST-12	927PST012	下同步轮/Timing Belt Wheel Assy Lower	1
13	927PST-13	927PST013	罩壳定位螺钉/Screw	1
14	927PST-14	927PST014	下罩壳/Timing Belt Cover,D	1
15	927PST-15	927PST015	上罩壳固定螺钉/Screw	1
16	927PST-16	DQ00036	平垫圈16/Washer	2
17	928PST-17	928PST017	拖轮支架/Puller Bracket	1
18	927PST-18	LD00270	紧定螺钉M4-8/Screw M4	2
19	927PST-19	927PST019	下轴/Lower Shaft	1
20	928PST-20	928PST020	1/2拖布轮/1/2 Wheel	1
21	928PST-21	928PST021	普通拖布轮/Wheel	1
22	927PST-22	927PST022	胶轮拖布轮/Wheel	1
23	927PST-23	927PST023	双轮上拖轮支架/Upper Wheel Stent	1

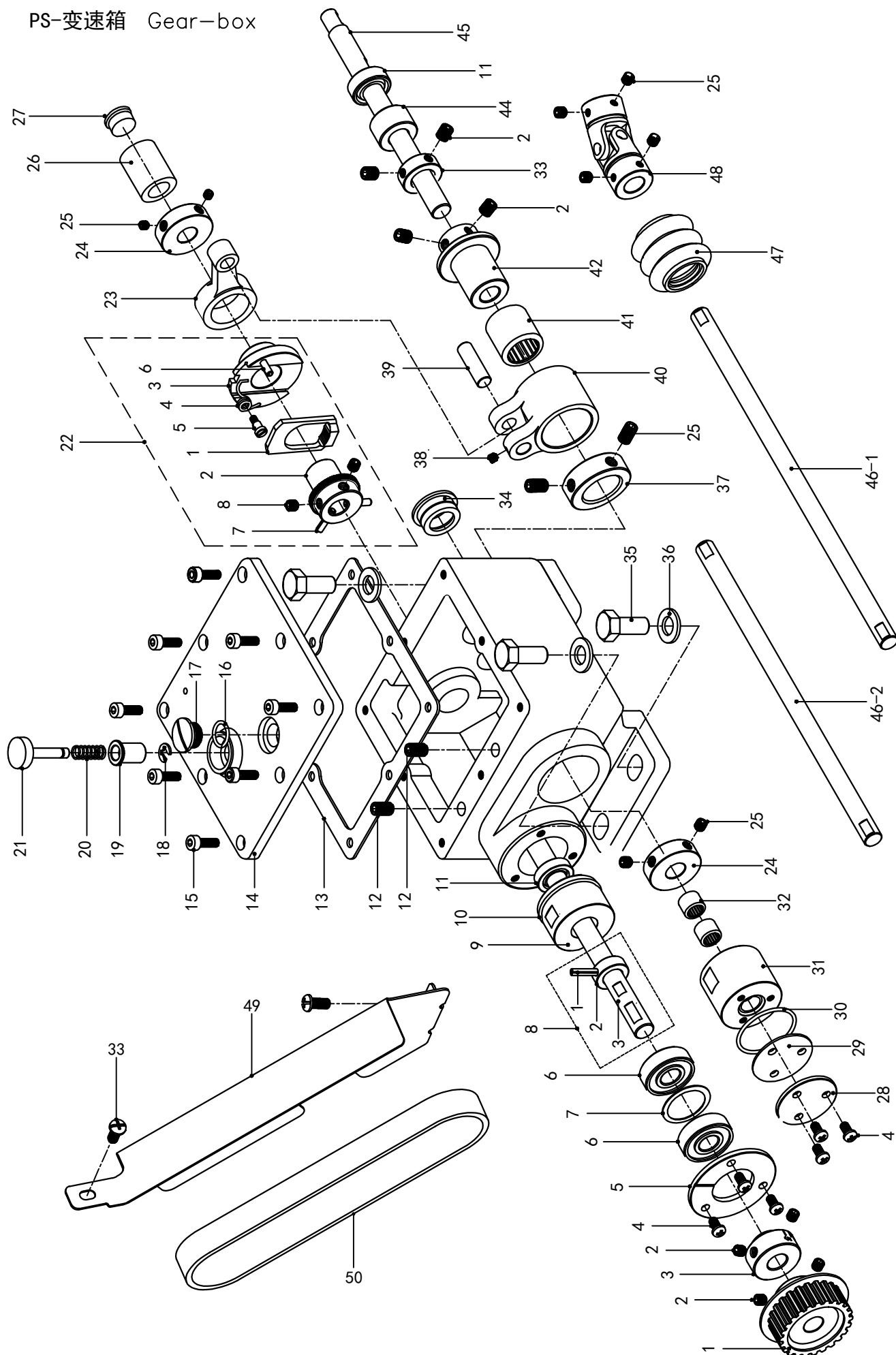
PS-变速箱 Gear-box



PS-变速箱 Gear-box

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927PS-1	927PS001	同步轮组件/Timing Belt Wheel Assy	1
2	927PS-2	LD00003	紧定螺钉M6-6/Screw M6	8
3	927PS-3	927PS003	针距号码圈/Timing Collar	1
4	927PS-4	LD00172	螺钉M4-8/Screw M4	6
5	927PS-5	927PS005	轴承刻线压板/Bearing Cover	1
6	927PS-6	ZC00013	深沟球轴承/Ball Bearing	2
7	927PS-7	DQ00035	轴承间隔垫圈/Bearing Spacer	1
8	927PS-8	927PS008	输入轴组件/Eccentric Wheel Shaft Assy	1
9	927PS-9	927PS009	输入轴前套/Bearing Bush	1
10	927PS-10	□XQ00008	O形圈1.5X25/O Ring	1
11	927PS-11	927PS011	油封/Oil Seal	2
12	927PS-12	LD00001	紧定螺钉M6-10/Screw M6	2
13	927PS-13	927PS013	箱体密封垫/Packing	1
14	927PS-14	927PS014	箱体/Puller Device Top Cover	1
15	927PS-15	LD00116	螺钉M4-12/Screw M4	8
16	927PS-16	□XQ00017	O型圈/O Ring	1
17	927PS-17	LD00180	油孔螺丝/Screw	1
18	927PS-18	TDQ00005	开口挡圈4/Ring	1
19	927PS-19	927PS019	调节钮套筒/Feed Regurate Button Bush	1
20	927PS-20	TH00017	压簧6.5-17/Spring	1
21	927PS-21	927PS021	偏心调节钮/Feed Adjust Button	1
22	927PS-22	927PS022	偏心调节器/Eccentric Adjuster	1
23	927PS-23	927PS023	连杆/Connecting Rod	1
24	927PS-24	927PS024	挡圈/Collar	2
25	927PS-25	LD00083	紧定螺钉M5-5/Screw M5	14
26	927PS-26	927PS026	输入轴后套/Eccentric Wheel Shaft Bush	1
27	927PS-27	927PS027	箱体螺柱/Screw	1
28	927PS-28	927PS028	压板/Clutch Bush Cap	1
29	927PS-29	□XQ00017	O形圈/O Ring	1
30	927PS-30	□XQ00010	O形圈/O Ring	1
31	927PS-31	927PS031	输出轴后套/Clutch Bush	1
32	927PS-32	ZC00015	单向滚针轴承/Ball Bearing	1
33	927PS-33	K2-7	输出轴前套挡圈/Collar	2
34	927PS-34	927PS034	油窗组件/Oil GAauge Window	1
35	927PS-35	LD00181	螺钉M8-20/Screw M8	3

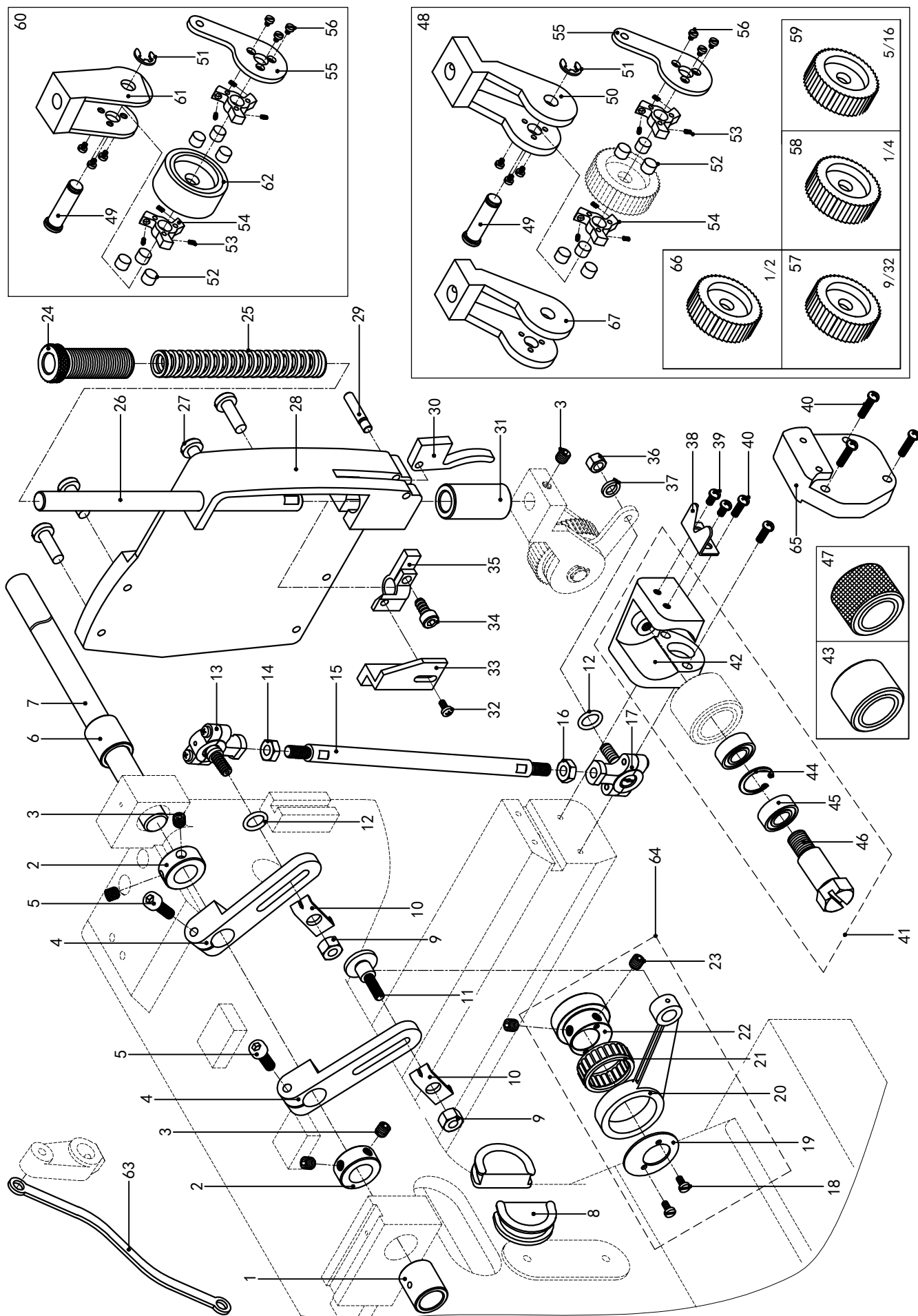
PS-变速箱 Gear-box



PS-变速箱 Gear-box

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
36	927PS-36	DQ00037	平垫圈8/Washer	3
37	927PS-37	927PS037	挡圈/Collar	1
38	927PS-38	LD00124	紧定螺钉M4-5/Screw M4	1
39	927PS-39	927PS039	连杆销/Pin	1
40	927PS-40	927PS040	轴承座/Bearings	1
41	927PS-41	ZC00016	单向滚针轴承/Ball Bearing	1
42	927PS-42	927PS042	驱动轴套筒/Bush	1
43	927PS-43	927PS043	同步带罩/Feed Shaft Bush	1
44	927PS-44	927PS044	轴出轴前套/Belt Cover	1
45	927PS-45	927PS045	输出轴/Feed Shaft	1
46	927PS-46	927PS046	传动轴/Universal Joint Shaft	1
47	927PS-47	927PS047	万向节护套/Universal coupling guard	2
48	927PS-48	927PS048	万向接头组件/Universal Joint Assy	2
49	927PS-49	LD00133	螺钉SM4. 76/Screw	2
50	927PS-50	927PS050	同步带/Timing Belt	1

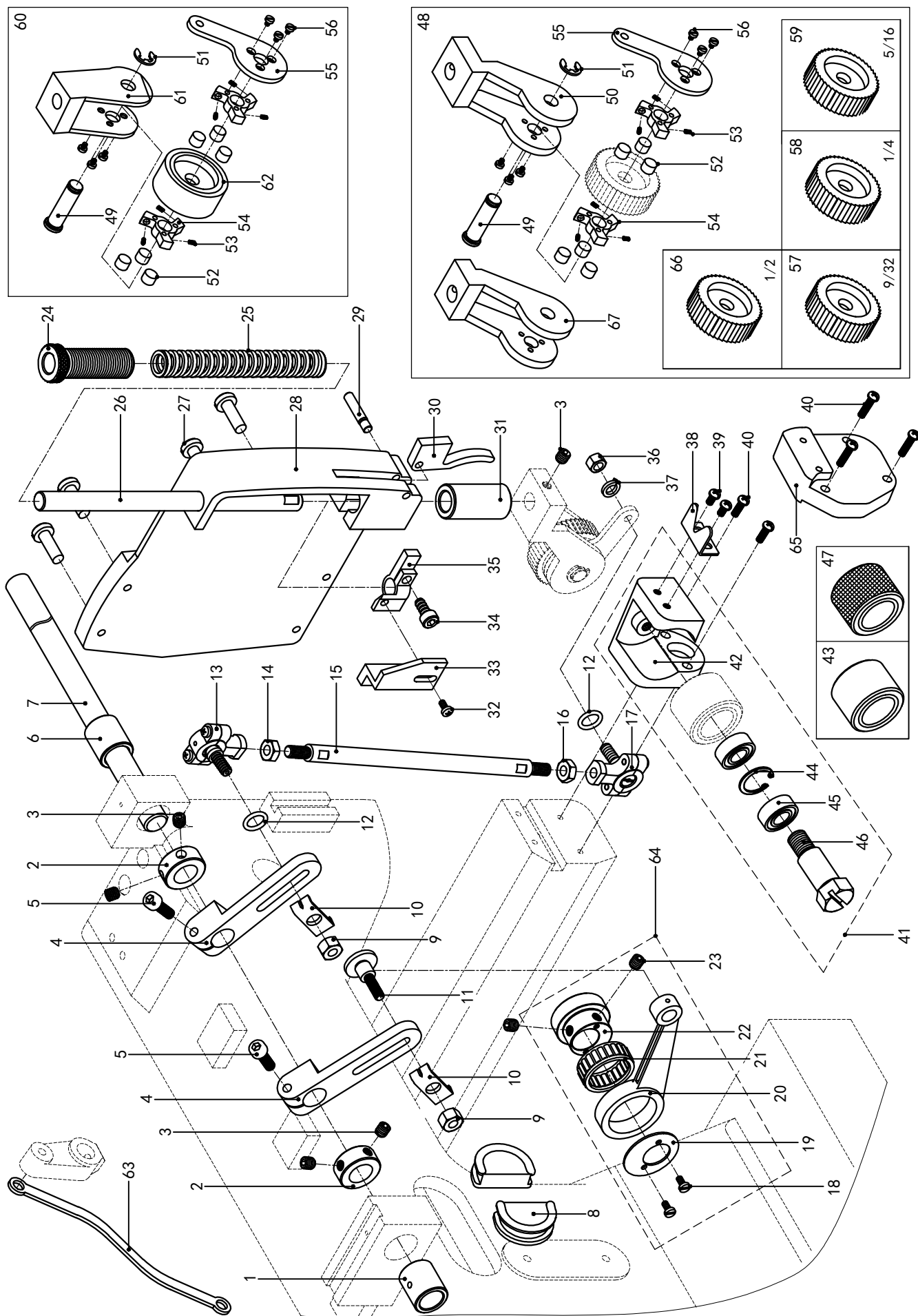
PL-直驱拖轮 Direct drive haul material wheel



PL-直驱拖轮 Direct drive haul material wheel

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927PL-1	927PL001	后轴套/Rear Bush	1
2	927PL-2	927PL002	挡圈/Collar	2
3	927PL-3	LD00003	紧定螺钉M6-6/Screw M6	5
4	927PL-4	927PL004	调节连杆/Adjusting Rod Assembly	2
5	927PL-5	LD00092	螺钉M5-16/Screw M5	2
6	927PL-6	927PL006	前轴套/Front Bush	1
7	927PL-7	927PL007	直驱轴/Shaft	1
8	927PL-8	927PL008	橡胶塞/Rubber Cap	2
9	927PL-9	LM00002	螺母5.95/Nut	2
10	927PL-10	927PL010	刻度指示片/Calibration Instruction Tablets	2
11	927PL-11	927PL011	轴位螺钉/Axial Screws	1
12	927PL-12	□XQ00012	O型圈/O Ring	2
13	927PL-13	927PL013	关节轴承组件(上)/Ball parts(Upper)	1
14	927PL-14	LM00006	螺母M6/Nut M6	1
15	927PL-15	927PL015	连接轴/Shaft for linking balls	1
16	927PL-16	LM00018	螺母M6左旋/Nut M6-LH	1
17	927PL-17	927PL017	关节轴承组件(下)/Ball parts(Lower)	1
18	927PL-18	LD00165	螺钉SM3.18-8/Screw SM3.18	2
19	927PL-19	927PL019	偏心轮挡片/Crank cover	1
20	927PL-20	927PL020	连杆/Connecting Rod	1
21	927PL-21	ZC00017	滚针轴承/Ball Bearing	1
22	927PL-22	927PL022	偏心轮/Eccentric Wheel	1
23	927PL-23	LD00138	紧定螺钉SM6.35-8/Screw SM6.35	2
24	927PL-24	927PL024	调节螺丝/Presser Adjust Screw	1
25	927PL-25	TH00028	弹簧/Spring	1
26	927PL-26	927PL026	压杆轴/Presser Bar	1
27	927PL-27	LD00192	螺钉SM4.36-11/Screw SM4.36	4
28	927PL-28	927PL028	端面盖/Face Plate	1
29	927PL-29	927PL029	扳手销/Support Stud	1
30	927PL-30	927PL030	扳手/Presser Foot Lifter	1
31	927PL-31	927PL031	压杆轴套/Presser Bar Bush, D	1
32	927PL-32	LD00128	螺钉SM5.95-8/Screw SM5.95	1
33	927PL-33	927PL033	连接片/Puller Presser Bar lifter	1
34	927PL-34	LD00044	螺钉M5-10/Screw M5	1
35	927PL-35	927PL035	调压杆夹/Presser Bar Clamp	1

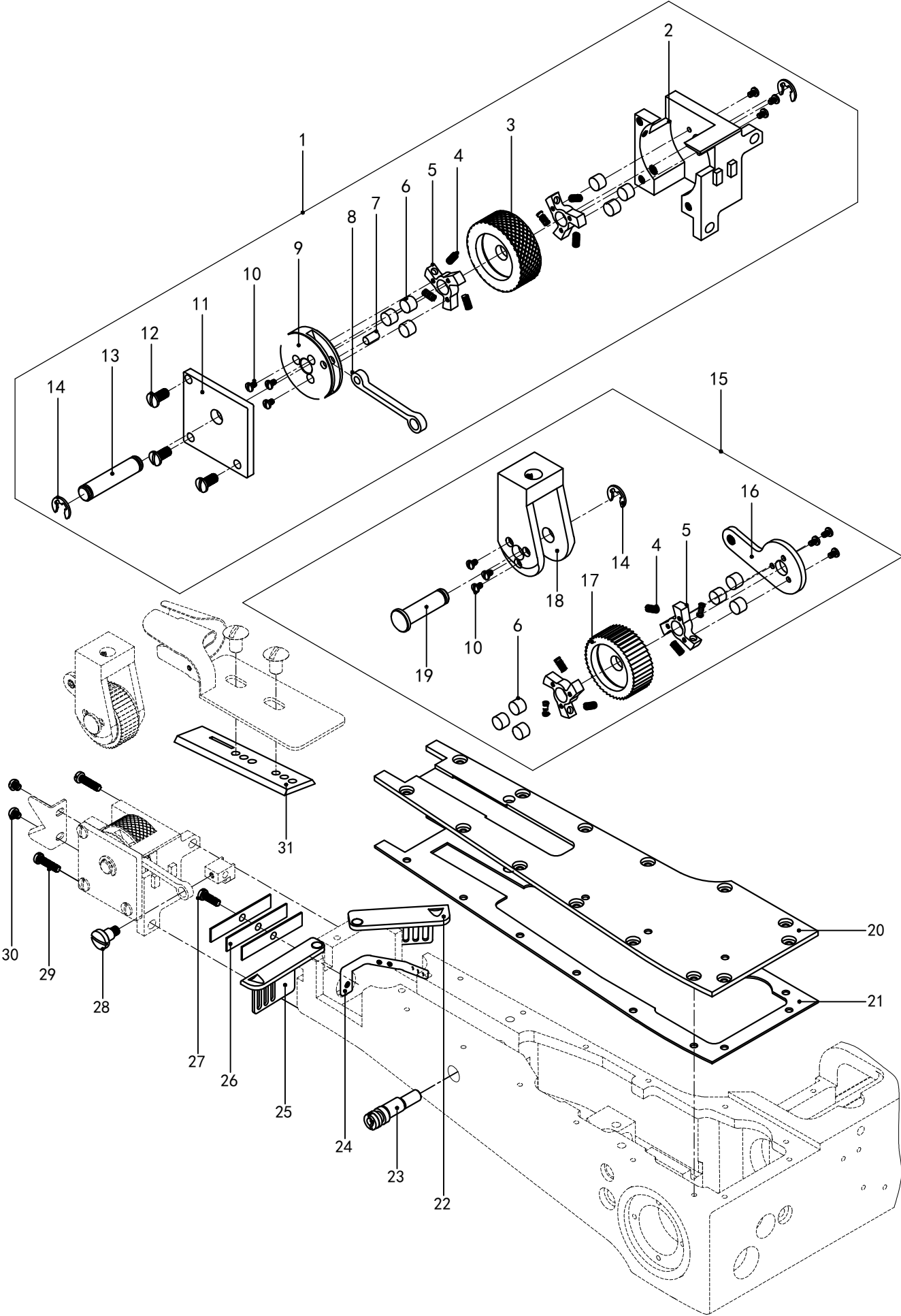
PL-直驱拖轮 Direct drive haul material wheel



PL-直驱拖轮 Direct drive haul material wheel

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
36	927PL-36	LM00004	螺母SM5. 55/Nut SM5.55	1
37	927PL-37	DQ00014	弹簧垫圈6/Spring Washer	1
38	927PL-38	927I036	割线刀片/line Cutting Blades	1
39	927PL-39	LD00135	螺钉SM3. 57-6/Screw SM3.57	2
40	927PL-40	LD00189	螺钉SM3. 57-15/Screw SM3.57	3
41	927PL-41	927PL041	下胶轮组件/Lower Puller Component	1
42	927PL-42	927PL042	下胶轮座/Lower Puller Bedket	1
43	927PL-43	927PL043	胶轮组件/Puller Component	1
44	927PL-44	TDQ00008	弹性挡圈C19/Retaining Ring	1
45	927PL-45	ZC00030	深沟球轴承/Ball Bearing	2
46	927PL-46	927PL046	轴位螺钉/Axial Screw	1
47	927PL-47	927PL047	下轮/Lower Puller	1
48	928PL-48	928PL048	上拖轮组件/LowerPullerComponentPicture	1
49	927PL-49	927PL049	拖布轮轴/Puller Shaft	1
50	927PL-50	927PL050	上拖轮支架/Upper Puller Stent	1
51	927PL-51	TDQ00006	开口挡圈6/Ring	1
52	927PL-52	927PL052	滚子/Rolling Shaft	6
53	927PL-53	TH00024	弹簧/Spring	6
54	927PL-54	927PL054	星轮/Star Ferry	2
55	927PL-55	927PL055	星轮连杆/Star Ferry Link	1
56	927PL-56	LD00266	螺钉M3/Screw M3	6
57	928PL-57	928PL057	拖布轮9/32/Wheel 9/32	1
58	928PL-58	928PL058	拖布轮1/4/Wheel 1/4	1
59	928PL-59	928PL059	拖布轮5/16/Wheel 5/16	1
60	927PL-60	927PL060	上拖轮组件(上下轮)/LowerPullerComponent	1
61	927PL-61	927PL061	上拖轮支架(上下轮)/Upper Puller Stent	1
62	927PL-62	927PL062	上胶轮(上下轮)/Upper Puller	1
63	927PL-63	927PL063	松线连杆/Lane Link	1
64	927PL-64	927PL064	偏连杆组件/Connecting Rod Component	1
65	927PL-65	927PL065	拖布轮垫块/Round mat piece	1
66	928PL-66	928PL066	拖布轮1/2/Wheel 1/2	1
67	927PL-67	927PL067	上拖轮支架PLA/Upper Puller Stent	1

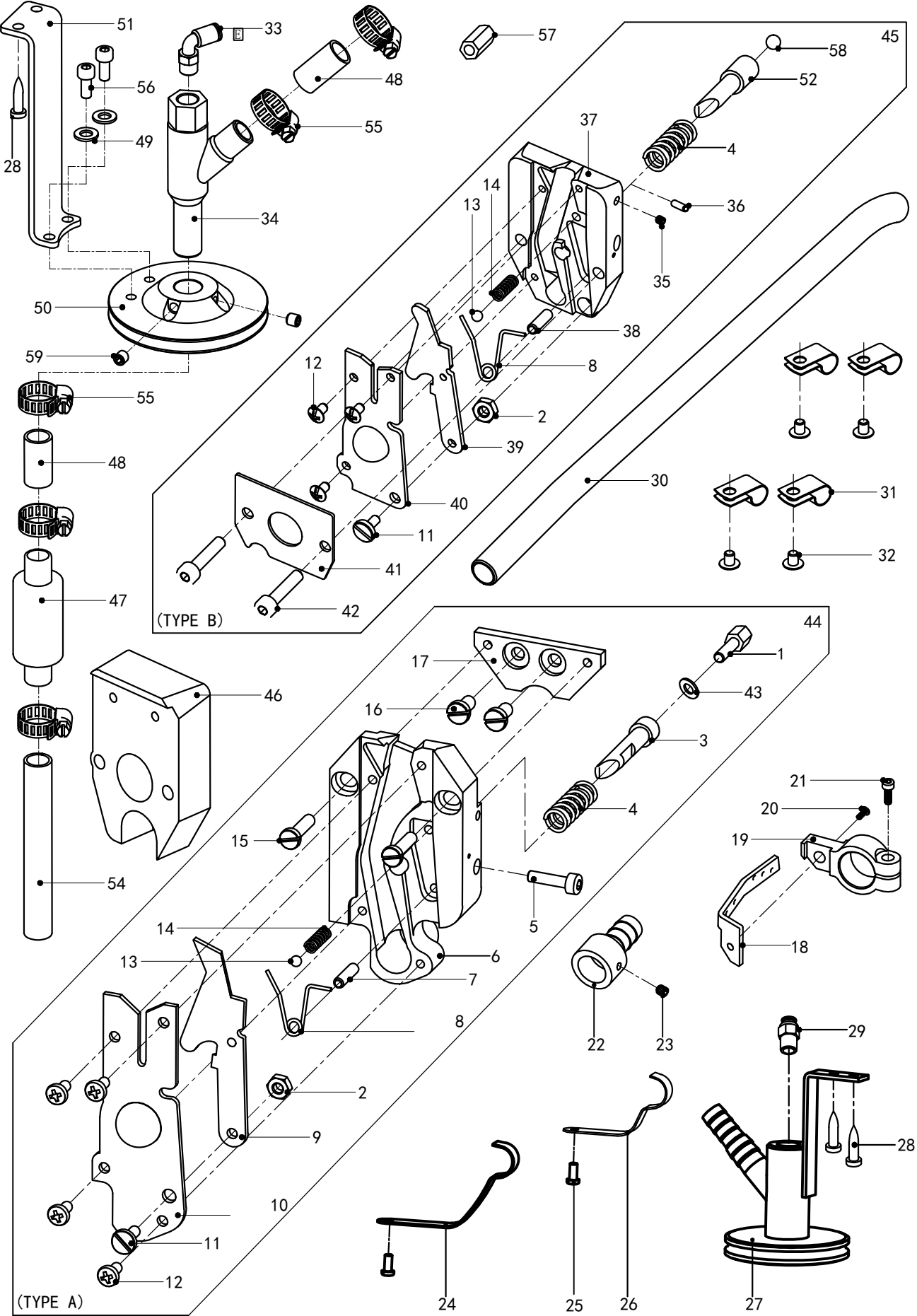
SPL-双拖轮 Double haul material wheel



SPL-双拖轮 Double haul material wheel

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	928SPL-1	928SPL001	下拖轮组件/Lower Wheel Component	1
2	928SPL-2	928SPL002	下拖轮座/Lower Wheel Seat	1
3	928SPL-3	928SPL003	下拖轮/Lower Wheel	1
4	928SPL-4	TH00024	压簧/Spring	12
5	928SPL-5	927PL054	星轮/Star Ferry	4
6	928SPL-6	927PL052	滚子/Rolling Shaft	12
7	928SPL-7	928SPL007	拔盘销/Pin	1
8	928SPL-8	928SPL008	拖轮连杆/ Wheel Link	1
9	928SPL-9	928SPL009	拔盘/One May Pushing Plate	1
10	928SPL-10	LD00266	螺钉M3/Screw M3	12
11	928SPL-11	928SPL011	盖板/Cover	1
12	928SPL-12	LD00190	螺钉SM4. 36-7. 5/Screw SM4.36	3
13	928SPL-13	928SPL013	拖轮轴销/ Wheel Shaft Pin	1
14	928SPL-14	TDQ00006	开口挡圈/Ring	3
15	928SPL-15	928SPL015	上拖轮组件/Upper Wheel Component	1
16	928SPL-16	927PL055	星轮连杆/Star Ferry Link	1
17	928SPL-17	928SPL017	上拖轮/Upper Wheel	1
18	928SPL-18	927PL061	上拖轮支架(上下轮)/Upper Wheel Stent	1
19	928SPL-19	927PL049	拖布轮轴/Wheel Shaft	1
20	928SPL-20	928SPL020	前臂盖/Front Feed Arm Cap	1
21	928SPL-21	928SPL021	前臂盖垫/Packing	1
22	928SPL-22	928SPL022	弯针右护罩/Looper Cover,Ra	1
23	928SPL-23	928SPL023	送料杆偏心销/Feed Bar Eccentric Shaft	1
24	928SPL-24	927I034	弯针引线板/Looper Thread Guide	1
25	928SPL-25	928SPL025	弯针左护罩/Looper Cover,La	1
26	928SPL-26	928SPL026	弹簧片/Leaf Spring	3
27	928SPL-27	LD00191	螺钉SM3. 57-6/Screw SM3.57	1
28	928SPL-28	928SPL028	轴位螺钉/Axial Screw	1
29	928SPL-29	LD00192	螺钉SM4. 36-13/Screw SM4.36	2
30	928SPL-30	LD00135	螺钉SM3. 57-6/Screw SM3.57	2
31	928SPL-31	928SPL031	卷边器滑块/Lapper Guide Plate	1

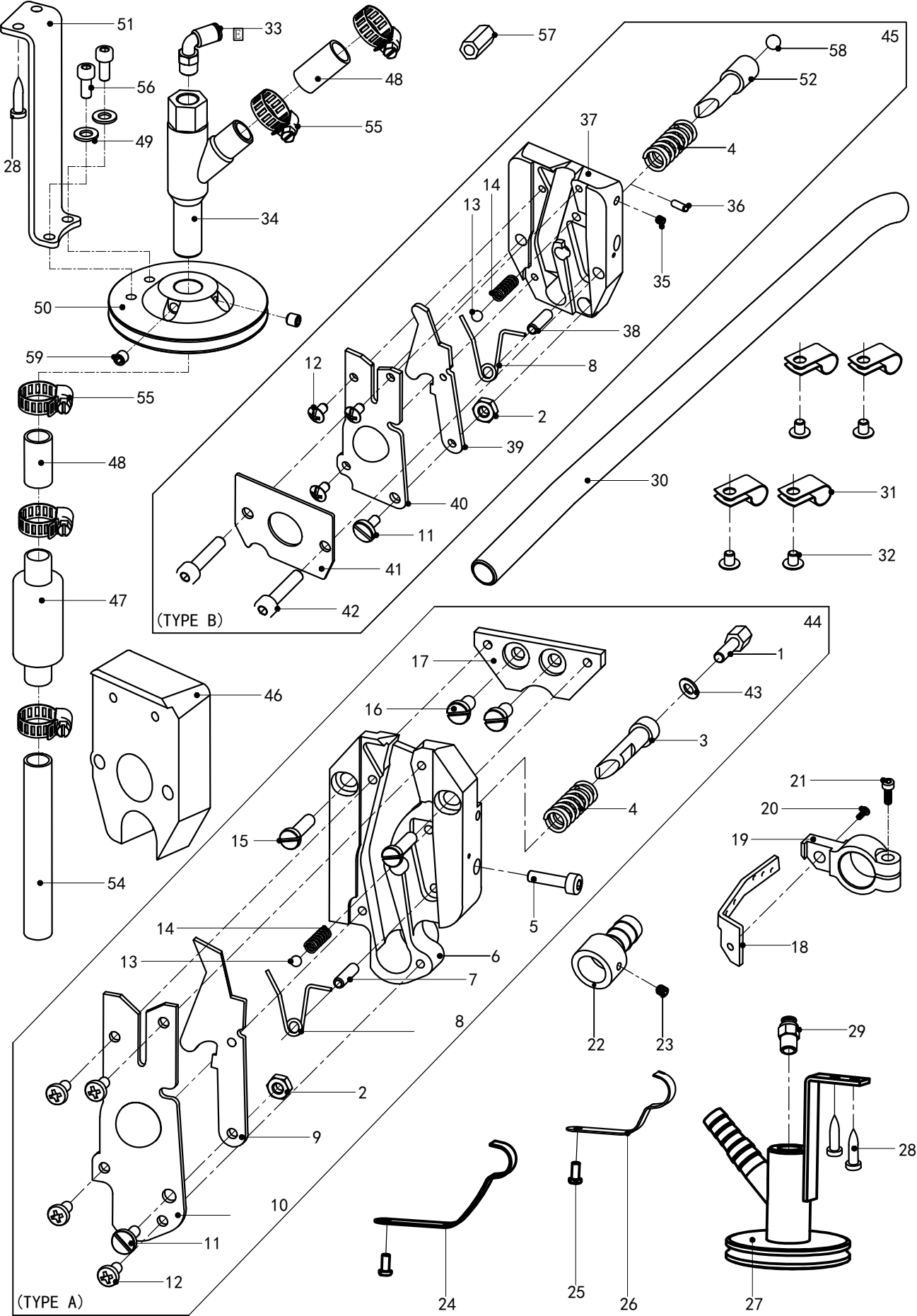
CV-自动剪线装置 Auto wire cutters device



CV-自动剪线装置 Auto wire cutters device

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927CV-1	927CV001	动刀顶杆调节螺钉/Presser Adjust Screw	1
2	927CV-2	LM00014	螺母M3/Nut M3	1
3	928CV-3	928CV003	动刀顶杆/Movable Knife Crest pole	1
4	927CV-4	TH00025	压簧6.2-25/Spring	1
5	928CV-5	LD00091	螺钉M3X12/Screw M3	1
6	928CV-6	928CV006	剪刀座/Scissors support	1
7	928CV-7	TXX00009	弹簧销/Spring Pin	1
8	927CV-8	927CV008	动刀扭簧/Spring	1
9	928CV-9	928CV009	动刀组件/Movable Knife Component	1
10	928CV-10	928CV010	定刀组件/Fixed Knife Component	1
11	927CV-11	927CV011	剪刀轴位螺钉/Axial Screws	1
12	927CV-12	LD00173	螺钉M3-6/Screw M3	4
13	927CV-13	GZ00003	动刀压紧钢珠/Movable Knife Pin	1
14	927CV-14	TH00026	动刀顶簧/Movable Knife Spring	1
15	928CV-15	LD00193	螺钉M3-10/Screw M3	2
16	928CV-16	LD00175	螺钉SM3.57-6.8/Screw M3.57	2
17	928CV-17	928CV017	剪刀固定片/Scissors Fix Slice	1
18	927CV-18	927CV018	弯针引线片/Looper Thread Guide	1
19	927CV-19	927CV019	弯针引线片支架/Looper Thread Guide Bracket	1
20	927CV-20	LD00198	螺钉M3-5/Screw M3	1
21	927CV-21	LD00174	螺钉M3-9/Screw M3	1
22	928CV-22	928CV022	连接套/Conjunction set	1
23	928CV-23	LD00040	紧定螺钉M3-3/Screw M3	1
24	928CV-24	928CV024	气管限位片长/WindpipeLimitSlice(Long)	1
25	928CV-25	LD00134	螺钉SM3.57/Screw SM3.57	2
26	928CV-26	928CV026	气管限位片短/WindpipeLimitSlice(Short)	1
27	928CV-27	928CV027	导流吸屑座/Lead To Flow Absorb Scraps	1
28	928CV-28	LD00051	自攻螺钉/Wood Screw	2
29	928CV-29	927Q.2.30	螺纹直通APC6-02/Thread Keep APC6-02	1
30	927CV-30	927CV030	吸屑软管/Absorb Scraps Soft Tube	1
31	927CV-31	927CV031	吸屑软管卡扣/Button	4
32	927CV-32	LD00244	垫片螺钉M4/Screw M4	4
33	927CV-33	927Q.2.27	L型接头PL0601C/"L"Connector PL0601C	1
34	927CV-34	927CV034	吸屑三通/Three-way Pipe	1
35	927CV-35	LD00125	内六角紧定螺钉M3X5/Screw M3	1

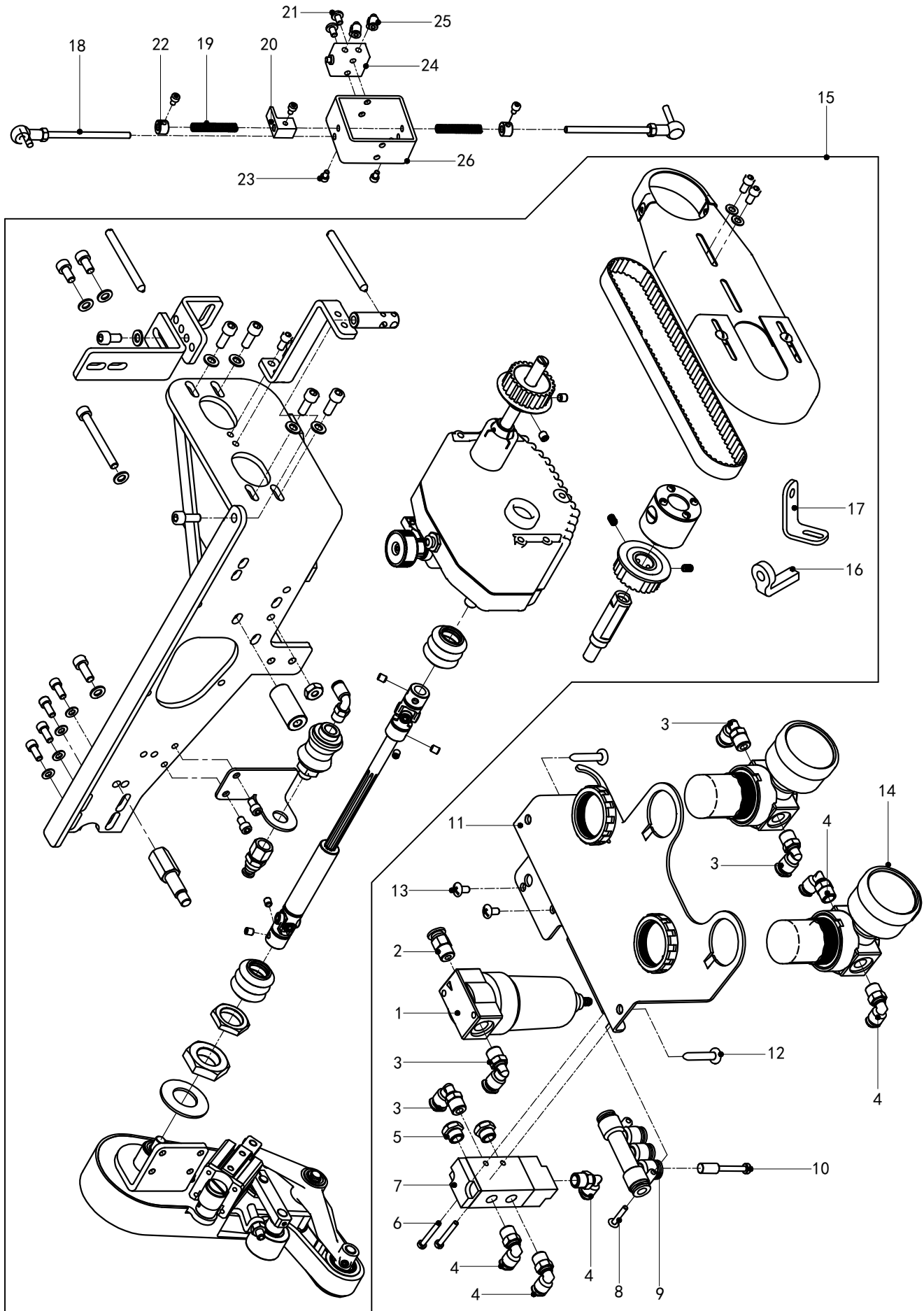
CV-自动剪线装置 Auto wire cutters device



CV-自动剪线装置 Auto wire cutters device

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
36	927CV-36	TXX00017	限位销/Spring Pin	1
37	927CV-37	927CV037	剪刀座/Scissors support	1
38	927CV-38	TXX00014	弹性圆柱销 $\phi 2$ /Spring Pin	1
39	927CV-39	927CV039	动刀组件/Movable Knife Component	1
40	927CV-40	927CV040	定刀组件/Fixed Knife Component	1
41	927CV-41	927CV041	剪刀压板/Scissors Cover	1
42	927CV-42	LD00105	内六角圆柱头螺钉M4X20/Screw M4X20	2
43	927CV-43	DQ00044	平垫圈/Washer	2
44	927CV-44	927CV044	剪刀组件(A型)/Scissors Type A	1
45	927CV-45	927CV045	剪刀组件(B型)/Scissors Type B	1
46	927CV-46	9588A158	剪刀垫块/Mat piece	1
47	927CV-47	927CV047	消声器/Eliminate a machine	1
48	927CV-48	927CV048	转接软管/Transfer a soft tube	2
49	927CV-49	DQ00052	平垫圈6/Washer 6	2
50	927CV-50	927CV050	储屑袋底座/Base	1
51	927CV-51	927CV051	储屑袋底座支架/Base support	1
52	927CV-52	927CV052	动刀顶杆/Crest pole	1
53	927CV-53	927CV053	储屑袋/Bag	1
54	927CV-54	927CV054	消声软管/Eliminate a soft tube	1
55	927CV-55	9588A160	软管抱箍/Embrace hoop	5
56	927CV-56	LD00250	内六角圆柱头螺钉M5X12/Screw M5X12	2
57	927CV-57	927CV057	动刀顶套/Crest set	1
58	927CV-58	GZ00005	钢珠5/Ball bearing 5	1
59	927CV-59	LD00099	紧定螺钉M5/Screw M5	2

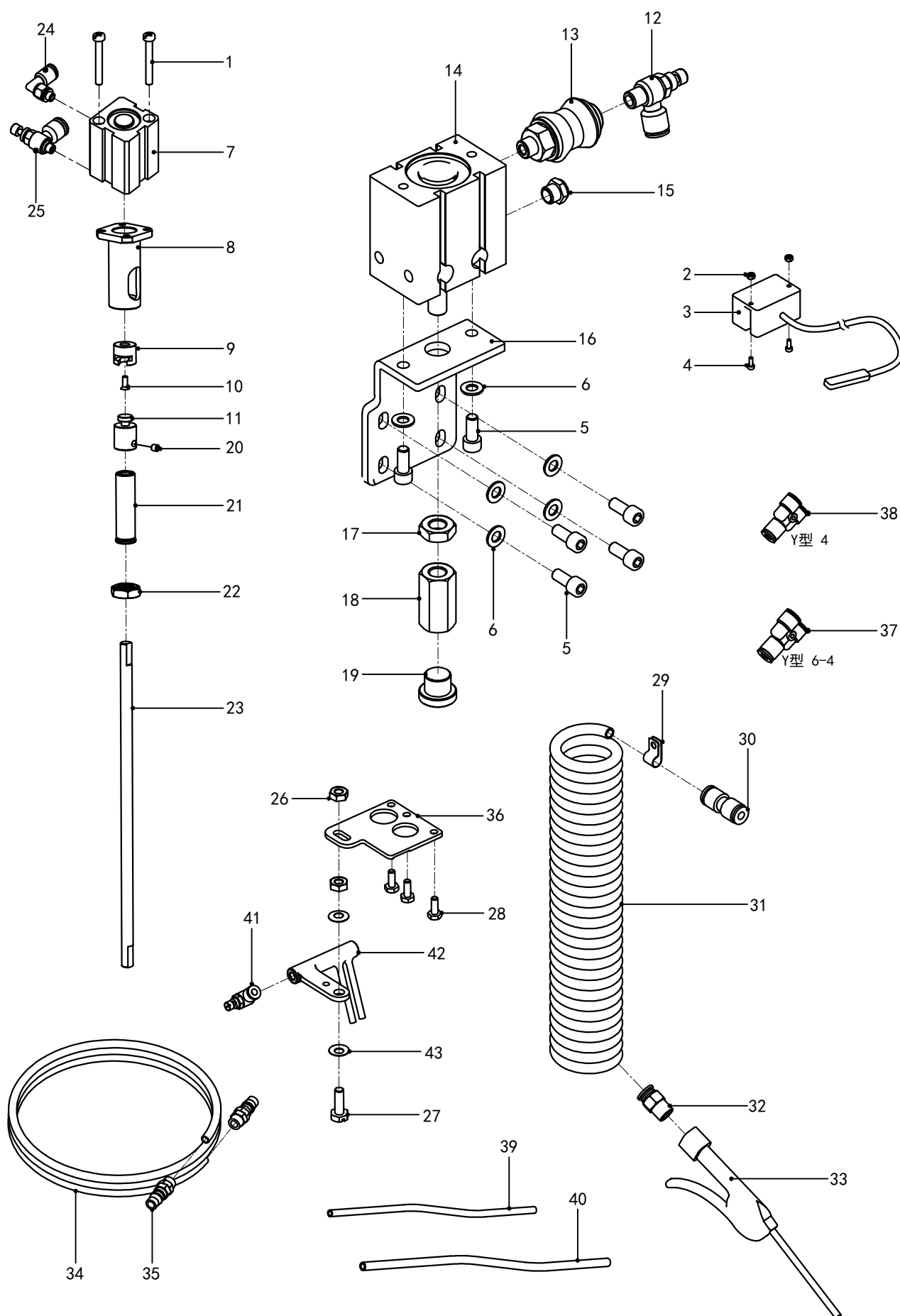
PF-气控拖轮装置 Gas control device



PF-气控拖轮装置 Gas control device

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927PF-1	927Q.4.05	过滤器AF1500/Filter AF1500	1
2	927PF-2	927Q.2.15	螺纹直通APC6-01/Thread Keep APC6-01	1
3	927PF-3	927Q.2.27	L型接头PL0601C/"L"Connector PL0601C	3
4	927PF-4	927Q.2.28	L型接头PL0401C/"L"Connector PL0401C	5
5	927PF-5	927Q.5.07	消声器BSLM01/Elimination machine BSLM01	2
6	927PF-6	LD00241	螺钉M3/Screw M3	2
7	927PF-7	927Q.3.03	气控阀4A110-06/Valve 4A110-06	1
8	927PF-8	LD00309	螺钉M3/Screw M3	2
9	927PF-9	927Q.2.09	五通APK6/APK6	1
10	927PF-10	927Q.5.04	管塞/Tube Fill	1
11	927PF-11	927PF011	气压表固定架/Barometer fix	1
12	927PF-12	LD00187	自攻螺钉ST4. 8/Wood Screw ST4.8	2
13	927PF-13	LD00196	螺钉M4-8/Screw M4	2
14	927PF-14	927Q.4.01	调压阀AR1500/Valve AR1500	2
15	927PF-15	927PF015	气控拖轮/PF Wheel	1
16	927PF-16	927PF016	连接块/Presser Bak Lifter	1
17	927PF-17	927PF017	角支架/Cape Stent	1
18	927PF-18	927PF018	球头拉杆组件/Ball parts	2
19	927PF-19	TH00022	弹簧/Spring	2
20	927PF-20	927PF020	气阀挡块/Spirit Valve Plate	1
21	927PF-21	LD00096	螺钉M5-8/Screw M5	2
22	927PF-22	927PF022	挡圈/Collar	2
23	927PF-23	LD00182	内六角圆柱头螺钉M4X6/Screw M4x6	5
24	927PF-24	927Q.3.05	机械阀S3B-M5/Machine valve S3B-M5	1
25	927PF-25	927Q.2.29	L型接头PL04M5C/"L"Connector PL04M5C	2
26	927PF-26	927PF026	机械阀固定架/Machine valve fix	1

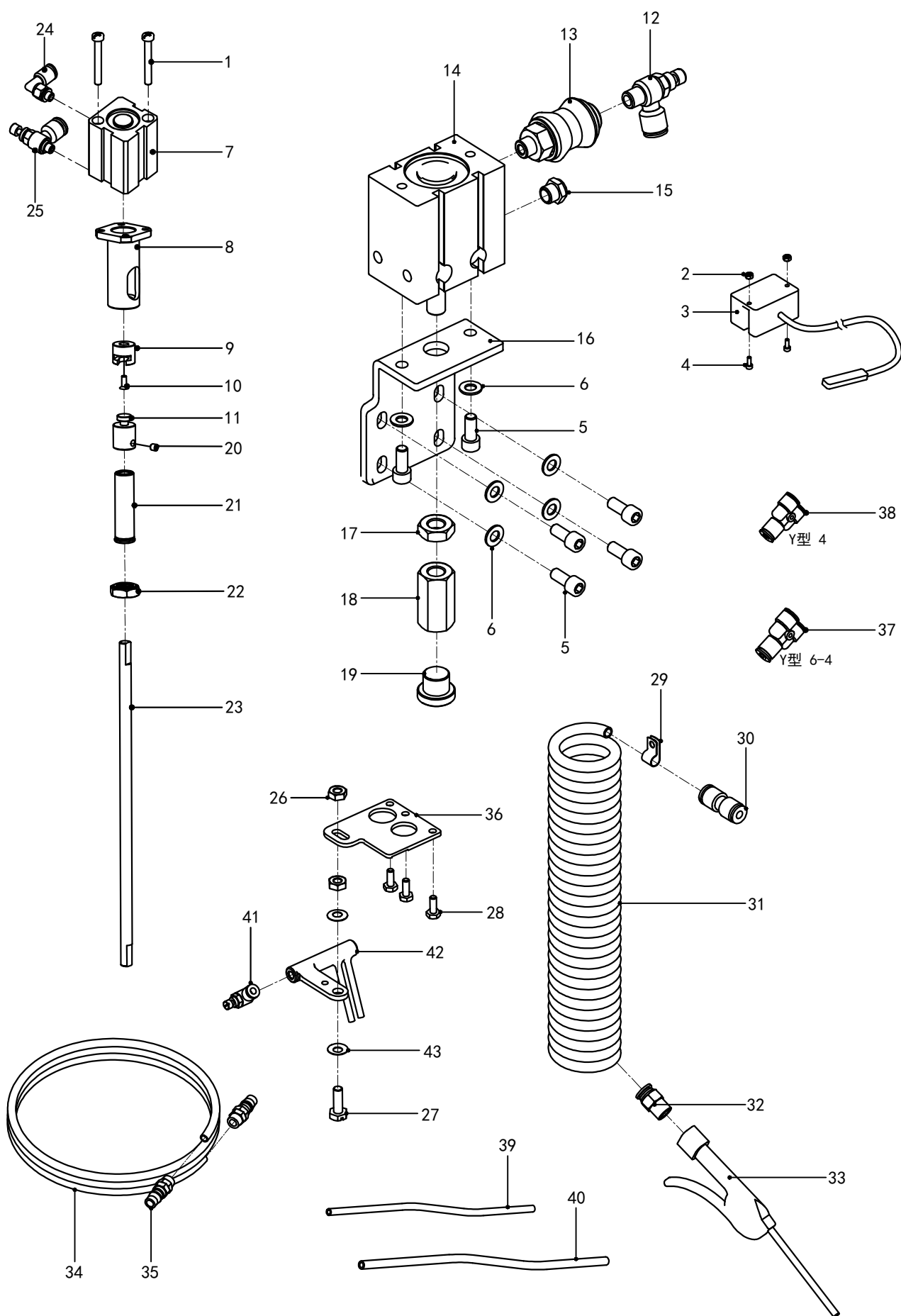
P-气动功能装置 Pneumatic device



P-气动功能装置 Pneumatic device

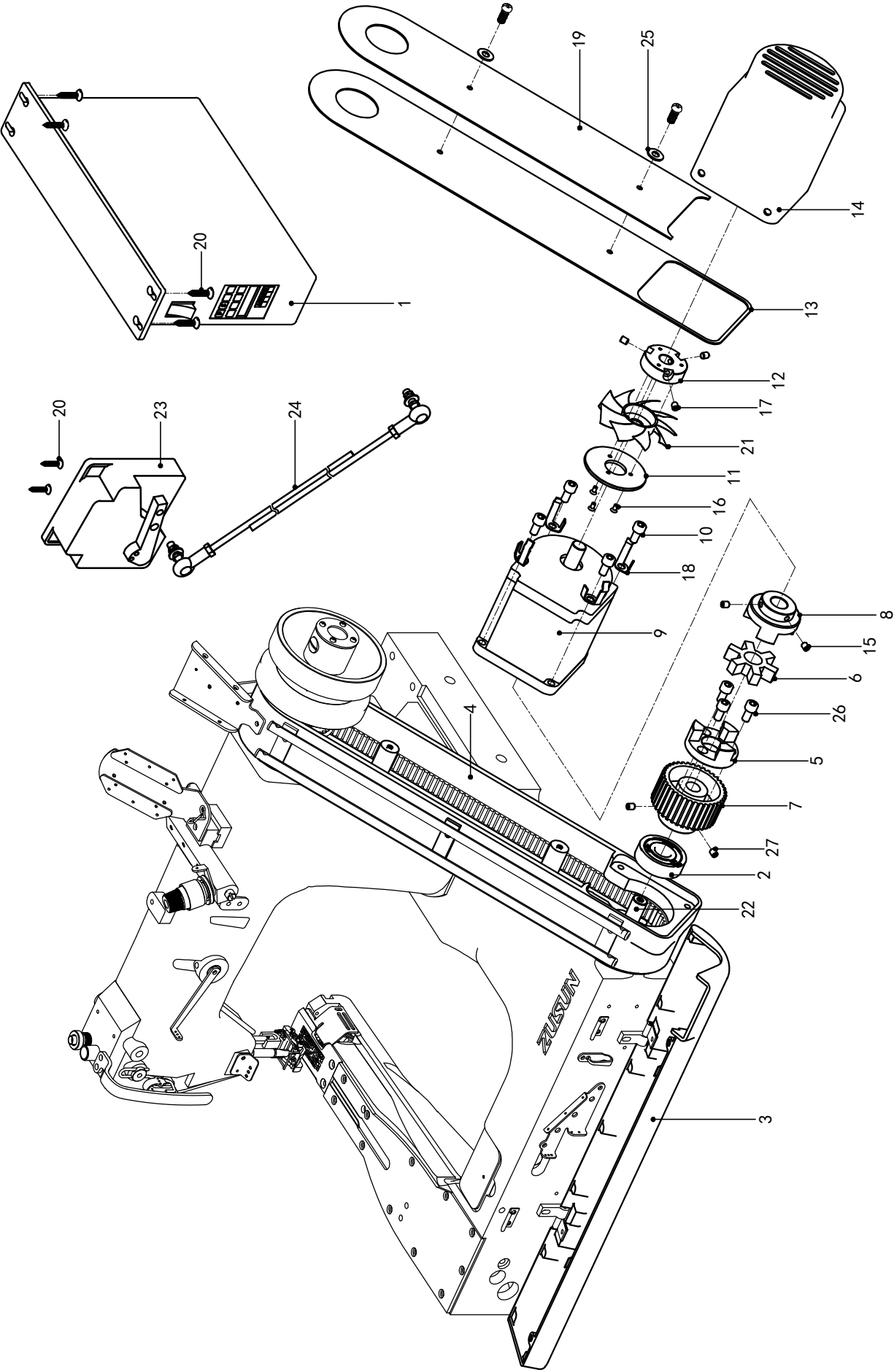
序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927P-1	LD00227	螺钉M4-38/Screw M4	2
2	927P-2	LM00014	外六角螺母/Nut	2
3	927P-3	927P003	工作灯/Lamp	1
4	927P-4	LD00235	内六角圆柱头螺钉M3X8/Screw M3	2
5	927P-5	LD00236	内六角圆柱头螺钉M6X14/Screw M6	20
6	927P-6	DQ00050	平垫圈6/Washer	36
7	927P-7	927Q.1.07	气缸SDA16X20/Cylinder SDA16X20	1
8	927P-8	927P008	气缸座/Air cylinder	1
9	927P-9	927P009	上连接块/Upper Presser Bak Lifter	1
10	927P-10	LD00193	沉头螺钉M3-8Screw M3	1
11	927P-11	927PA011	下连接块/Lower Presser Bak Lifter	1
12	927P-12	927Q.2.43	排气节流阀ASL6-01/Valve ASL6-01	1
13	927P-13	927Q.3.06	手滑阀HSV06/Valve HSV06	1
14	927P-14	927Q.1.15	多位置固定气缸MD32X20/Cylinder MD32X20	1
15	927P-15	P27Q.5.07	消声器BSLM01/Elimination machine BSLM01	1
16	927P-16	927P016	抬压脚气缸支架/Cylinder Support	1
17	927P-17	LM00025	六角螺母M10X1.25/Nut M10	1
18	927P-18	927P018	六角螺帽/Nut	1
19	927P-19	927P019	缓冲垫块/Buf Pad	1
20	927P-20	LD00004	紧定螺钉M4X4/Screw M4	2
21	927P-21	927P021	压脚杆上套/Presser Bar,Upper	1
22	927P-22	927P022	螺母M12X1/Nut M12	1
23	927P-23	927P023	压脚杆/Presser Bar	1
24	927P-24	927Q.2.29	L型接头PL04M5C/"L"Connector PL04M5C	1
25	927P-25	927Q.2.18	单向节流阀ASL4-M5/Valve ASL4-M5	1
26	927P-26	LM00036	六角螺母SM4.36/Nut SM4.36	2
27	927P-27	LD00274	六角螺钉SM4.36/Screw M4.36	1
28	927P-28	LD00275	六角螺钉SM3.18/Screw M3.18	3
29	927P-29	927P029	气管尼龙扣8/Clip	1
30	927P-30	927Q.2.11	减径直通APG8-6/Connector Keep APG8-6	1
31	927P-31	927Q.5.16	螺旋气管UCS8/Windpipe UCS8	1
32	927P-32	927Q.2.40	螺纹直通APC8-02/Thread Keep APC8-02	1
33	927P-33	927Q.5.12	塑料气枪AG-Y/Air rifle AG-Y	1
34	927P-34	927Q.5.17	PUφ8气管US98A080/Windpipe PU8	1
35	927P-35	927Q.2.32	快换接头(母体)PHD-20-ZN/Connector	2

P-气动功能装置 Pneumatic device



P-气动功能装置 Pneumatic device

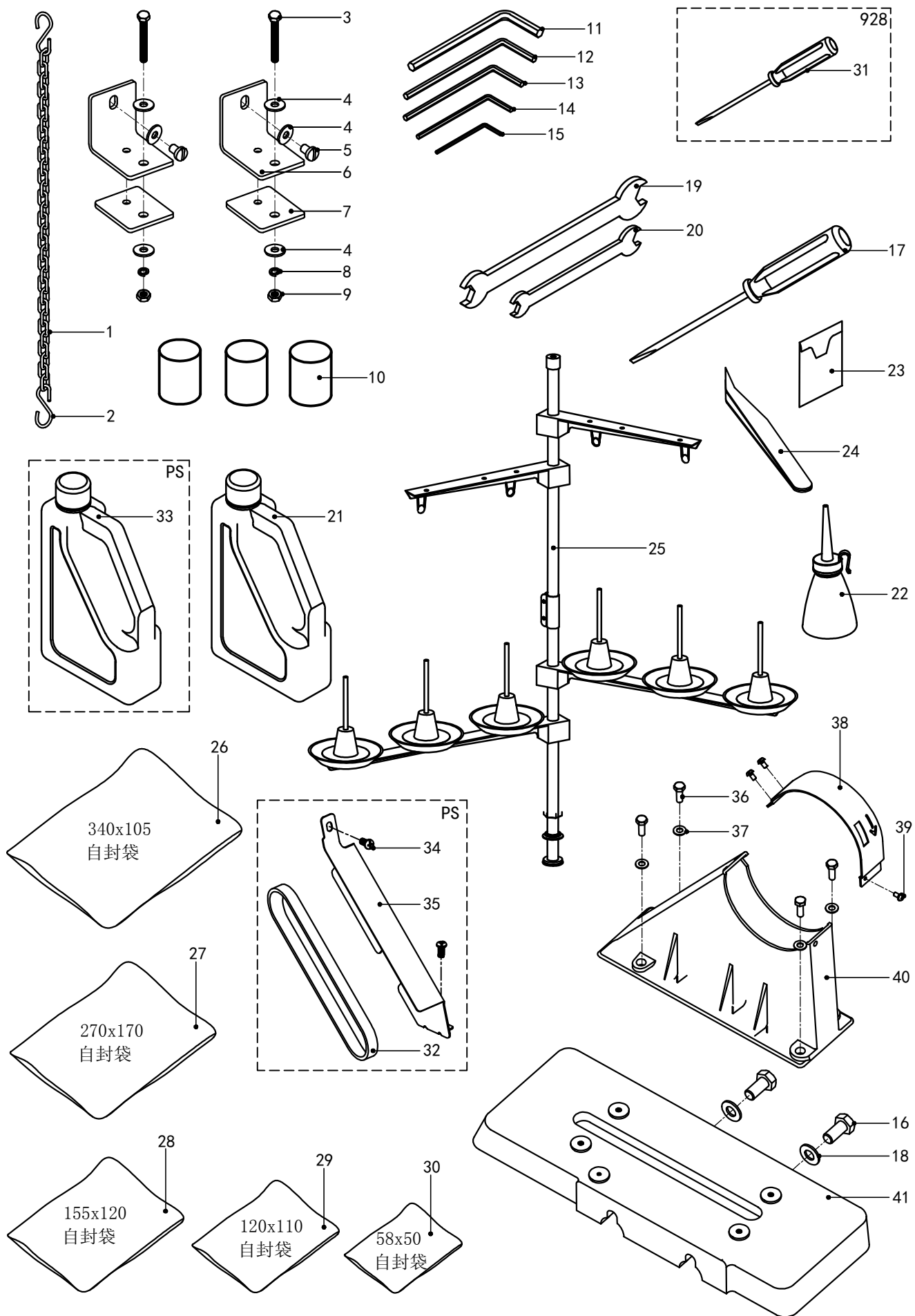
序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
36	927P-36	9588A164	冷却气嘴支架/Support	1
37	927P-37	927Q.2.06	Y型减径三通/"Y"transition connector	1
38	927P-38	927Q.2.07	Y型三通APY4/"Y"transition connector	1
39	927P-39	927Q.5.13	Ø4气管/Ø4 Windpipe	1
40	927P-40	927Q.5.14	Ø6气管/Ø6 Windpipe	1
41	927P-41	927Q.2.19	进气节流阀ASL4-M5B/Valve ASL6-M5B	1
42	927P-42	927P042	冷却气嘴/Air cock	1
43	927P-43	DQ00051	盘形垫片5/Washer 5	1



SD-伺服直驱装置 Servo direct drive device

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927SD-1	927SD001	电控箱/Control Box	1
2	927SD-2	ZC00009	轴承/Ball Bearing	1
3	927SD-3	927SD003	长前盖/Front Cover	1
4	927SD-4	927SD004	直驱同步带罩/Belt Cover	1
5	927SD-5	927SD005	联轴器A/Shaft coupling A	1
6	927SD-6	927SD006	联轴器橡胶法兰/Shaft coupling Flange	1
7	927SD-7	927SD007	下同步轮组件/HookDrivingShaftSprocket	1
8	927SD-8	927SD008	联轴器B/Shaft coupling B	1
9	927SD-9	927SC009	马达/Motor	1
10	927SD-10	LD00407	内六角圆柱头螺钉M6X18/Screw M6	4
11	927SD-11	927SD011	定位磁盘/Fixed Position Disk	1
12	927SD-12	927SD012	磁盘座/Disk	1
13	927SD-13	927SD013	盖板垫/Packing	1
14	927SD-14	927SD014	直驱电机罩壳/Motor Timing Belt Cover	1
15	927SD-15	LD00003	紧定螺钉M6X6/Screw M6	2
16	927SD-16	LD00234	一字沉头螺钉M3X12/Screw M3	3
17	927SD-17	LD00074	紧定螺钉M4/Screw M4	3
18	927SD-18	927SD018	罩壳弹簧片/Leaf Spring	4
19	927SD-19	927SD019	皮带盖/Belt Corer Plate	1
20	927SD-20	LD00051	自攻螺钉ST4. 2/Wood Screw ST4.2	6
21	927SD-21	927SD021	风叶/Vane wheel	1
22	927SD-22	927SD022	下轴/Lower Shaft	1
23	927SD-23	927SD023	控速器/Speed Control Box	1
24	927SD-24	927SD024	拉杆/Lever Link	1
25	927SD-25	DQ00034	平垫圈/Washer	2
26	927SD-26	LD00030	内六角圆柱头螺钉M5X8/Screw M5	3
27	927SD-27	LD00143	紧定螺钉SM5. 95/Screw SM5.95	3

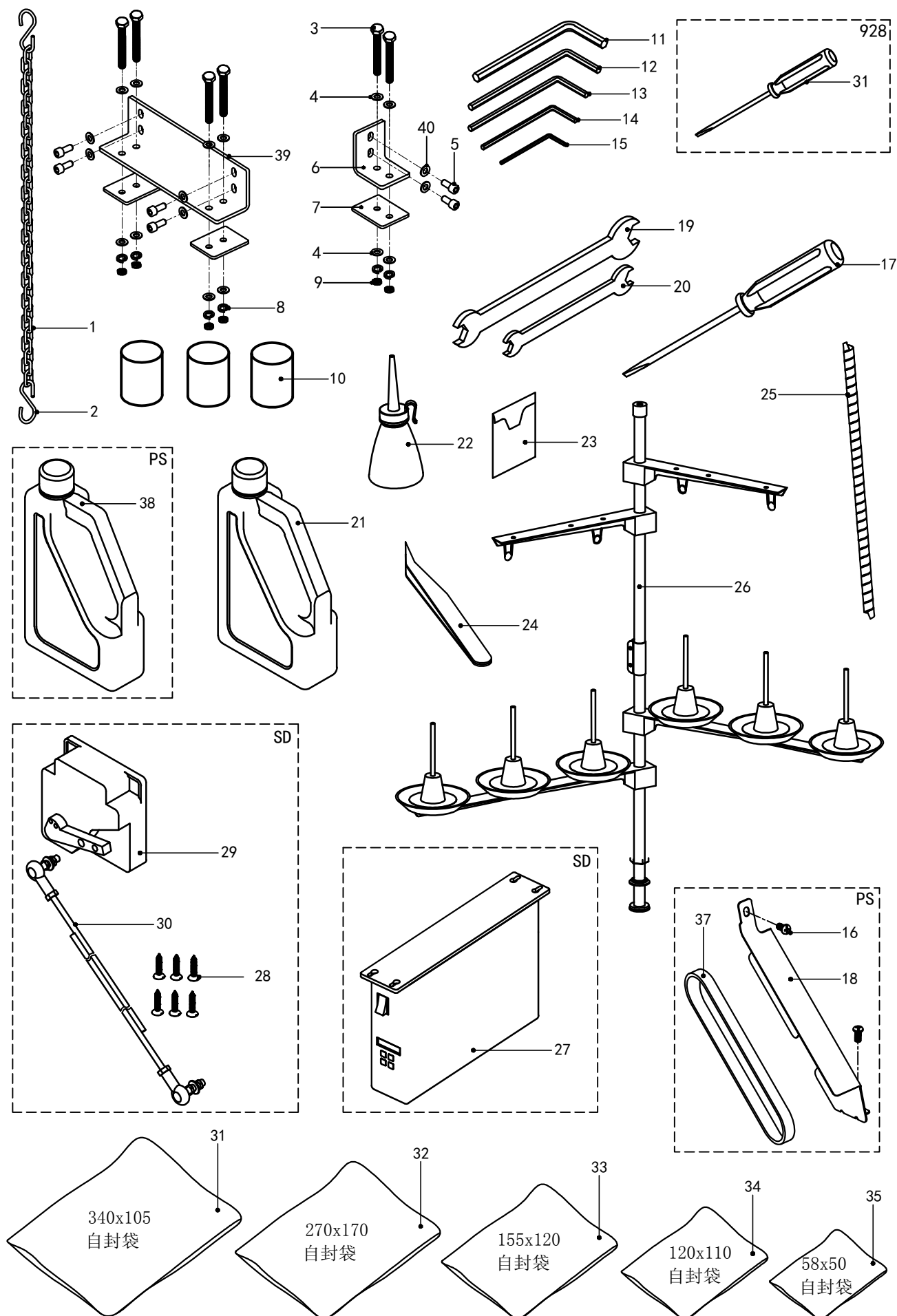
K-普通系列附件 Accessories



K-普通系列附件 Accessories

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927K-1	927D022	铁链/Chain	1
2	927K-2	927D021	S挂钩/"S" Hook	2
3	927K-3	FJ-H-14	六角头螺钉M6X60/Screw M6	2
4	927K-4	FJ1-14	平垫圈6/Washer	6
5	927K-5	LD00128	螺钉SM5.95/Screw SM5.95	2
6	927K-6	927K006	机架固定片/Cushion Assy	2
7	927K-7	927K007	减震垫/Cushion Rubber	2
8	927K-8	DQ00014	弹簧垫片/Spring Washer	2
9	927K-9	LM00006	螺母M6/Nut M6	2
10	927K-10	927K010	橡皮块/Base Cushion	3
11	927K-11	927K011	5mm内六角扳手/5mm Allen Key	1
12	927K-12	927K012	4mm内六角扳手/4mm Allen Key	1
13	927K-13	927K013	3mm内六角扳手/3mm Allen Key	1
14	927K-14	927K014	2.5mm内六角扳手/2.5mm Allen Key	1
15	927K-15	927K015	2mm内六角扳手/2mm Allen Key	1
16	927K-16	FJ-H-13	六角头螺钉M12-25/Screw M12	2
17	927K-17	FJ8-7	中号螺丝刀/ScrewDriver(medium)	1
18	927K-18	DQ00031	平垫圈12/Washer	2
19	927K-19	FJ4-3-1	17-19开口扳手/17-19 Spanner	1
20	927K-20	FJ4-3	8-10开口扳手/8-10Spanner	1
21	927K-21	FJ8-11	大油壶/Oiler	1
22	927K-22	FJ7-28	小油壶/Oiler	1
23	927K-23	927K023	机针/Needle	1
24	927K-24	FJ4-8	镊子/Thread Tweezers	1
25	927K-25	927K025	线架/Thread Stand	1
26	927K-26	927K026	340X105自封袋/340X105 Accessory bag	1
27	927K-27	927K027	270X170自封袋/270X170 Accessory bag	1
28	927K-28	927K028	155X120自封袋/155X120 Accessory bag	1
29	927K-29	927K029	120X110自封袋/120X110 Accessory bag	3
30	927K-30	927K030	58X50自封袋/58X50Accessory bag	2
31	927K-31	FJ8-5	一字螺丝刀/ScrewDriver	1
32	927K-32	927PS050	同步带/Puller Timing Belt	1
33	927K-33	FJ8-11	大油壶(PS用油)/Oiler	1
34	927K-34	LD00133	螺钉4.76/Screw SM4.76	2
35	927K-35	927PS043	同步带护罩/Pulley Belt Cover	1
36	927K-36	FJ5-4	六角头螺钉M6-18/Screw M6	4
37	927K-37	K1-36	平垫圈6/Washer	8
38	927K-38	927K039	皮带护罩板/Pulley Cover	1
39	927K-39	LD00172	垫片螺钉M4-8/Screw M4	3
40	927K-40	927K041	皮带护罩/Pulley Cover	1
41	927K-41	927K044	滑轮基座/Pulley Cover Base	1

L-直驱系列附件 Accessories



L-直驱系列附件 Accessories

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	927L-1	927D022	铁链/Chain	1
2	927L-2	927D021	S挂钩/"S" Hook	2
3	927L-3	FJ-H-14	六角头螺钉M6X60/Screw M6	6
4	927L-4	FJ1-14	平垫圈6/Washer	12
5	927L-5	LD000236	内六角圆柱头螺钉M6X14/Screw M6	6
6	927L-6	927PA011	后固定角支架/Fixed Support	1
7	927L-7	927K007	减震垫/Cushion Rubber	3
8	927L-8	DQ00014	弹簧垫片/Spring Washer	6
9	927L-9	LM00006	螺母M6/Nut M6	3
10	927L-10	927K010	橡皮块/Base Cushion	3
11	927L-11	927K011	5mm内六角扳手/5mm Allen Key	1
12	927L-12	927K012	4mm内六角扳手/4mm Allen Key	1
13	927L-13	927K013	3mm内六角扳手/3mm Allen Key	1
14	927L-14	927K014	2.5mm内六角扳手/2.5mm Allen Key	1
15	927L-15	927K015	2mm内六角扳手/2mm Allen Key	1
16	927L-16	LD00133	螺钉4.76/Screw SM4.76	2
17	927L-17	FJ8-7	中号螺丝刀/ScrewDriver(medium)	1
18	927L-18	927PS043	同步带护罩/Pulley Belt Cover	1
19	927L-19	FJ4-3-1	17-19开口扳手/17-19 Spanner	1
20	927L-20	FJ4-3	8-10开口扳手/8-10 Spanner	1
21	927L-21	FJ8-11	大油壶/Oiler	1
22	927L-22	FJ7-28	小油壶/Oiler	1
23	927L-23	927K023	机针/Needle	1
24	927L-24	927K024	镊子/Thread Tweezers	1
25	927L-25	927L025	电线护套/Guard	1
26	927L-26	927K025	线架/Thread Stand	1
27	927L-27		电控箱/Control Box	1
28	927L-28	LD00051	自攻螺钉ST4.2/Wood Screw ST4.2	6
29	927L-29		控速器/Speed Control Box	1
30	927L-30	927SD024	拉杆/Lever Link	1
31	927L-31	927K026	340X105自封袋/340X105 Accessory bag	1
32	927L-32	927K027	270X170自封袋/270X170 Accessory bag	1
33	927L-33	927K028	155X120自封袋/155X120Accessory bag	1
34	927L-34	927K029	120X110自封袋/120X110 Accessory bag	3
35	927L-35	927K030	58X50自封袋/58X50Accessory bag	2
36	927L-36	FJ8-5	一字螺丝刀/ScrewDriver	1
37	927L-37	927PS050	同步带/Puller Timing Belt	1
38	927L-38	FJ8-11	大油壶(PS用油)/Oiler	1
39	927L-39	927PA008	侧固定角支架/Fixed Support	1
40	927L-38	DQ00050	平垫圈6/Washer	6