

高速双针链式平缝机

HIGH-SPEED DOUBLE-NEEDLE
CHAIN-STITCH SEWING MACHINE

使用 说 明

Operation Manual

零 件 图 册

Atlas of Parts

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重要安全指示说明 IMPORTANT SAFETY INSTRUCTIONS

为使您正确使用本机，须对本机的各种功能充分了解，以便安全操作。
使用前请仔细阅读使用说明书。我们希望您能长期愉快地使用本机，请保存好说明书，以备查阅。

To get the most out of the many functions of this machine and operate it in safety, it is necessary to use this machine correctly.
Please read this instruction Manual carefully before use. We hope you will enjoy the use of your machine for a long time.
Please remember to keep this manual in a safe place.

1. 无论您何时使用本机，须了解基本的安全事项，包括但不限于下列事项。
Observe the basic safety measures, including, but not limited to the following ones, whenever you use the machine.
2. 通读所有说明，并保存好使用说明书。如果需要，主动随时翻阅。
Read all the instructions, including, but not limited to this instruction Manual before you use the machine. In addition, keep this instruction Manual so that you may read it at anytime when necessary.
3. 使用本机前，必须弄清与本机有关安全规定，标准在您的国家是否适用。
Use the machine after it has been ascertained that it conforms with safety rules/standards valid in your country.
4. 使用本机前或使用本机时，所有安全装置必须配备齐全。机器运转时，无安全装置属违章操作，决不允许。
All safety devices must be in position when the machine is ready for work or in operation. The operation without the specified safety devices is not allowed.
5. 操作人员必须经过适当的培训。This machine shall be operated by appropriately-trained operators.
6. 为了您的人身安全，我们建议您戴上防护眼镜。
For your personal protection, we recommend that you wear safety glasses.
7. 下列情况，请关闭电源开关或拔下电源插头。
For the following, turn off the power switch or disconnect the power plug of the machine from the receptacle.
7-1 机针穿线。
For threading needle (s).
7-2 更换机针、压脚、针板、送料牙、布料导板等。
For replacing part (s) of needle, presser foot, throat plate, feed dog, cloth guide etc.
7-3 进行维修时。
For repair work.
7-4 操作区域无人时。
When leaving the working place of when the working place is unattended.
8. 在机器加油润滑时，若不小心让油碰到眼睛、皮肤或咽下机油或润滑油，请立即冲洗被沾部位去医院检查。
If you should spill oil, grease, etc. Used with the machine and devices to be in contact with your eyes or swallow any of such liquid by mistake, immediately wash the contacted area and consult a medical doctor.
9. 无论机器运转与否，严禁乱动机器零部件和配套装置。
Tampering with the live parts and devices, regardless of whether the machine is powered, is prohibited.
10. 机器的维修、改造和调整等工作必须由专业技术人员进行。
Repair, remodeling and adjustment works must only be done by appropriately trained technicians or specially personnel.

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11. 应由专业受训人员进行一般的维修和检验工作。
General maintenance and inspection works have to be done by appropriately trained personnel.
12. 必须在专业电器人员或专业技术人员的指导下进行有关电器部件的维修，任何电器部件一经发现受损，立即停止机器运转。
Repair and maintenance works of electrical components shall be conducted by qualified electric technicians or under the audit and guidance of specially skilled personnel.
13. 使用期间要定期全面彻底清洗机器。Periodically clean the machine throughout the period of use.
14. 正常操作本机时，必须进行试运转，工作环境远离强噪音源，如高频电焊机等。
Grounding the machine is always necessary for the normal operation of the machine. The machine has to be operated in an environment that is free from strong noise sources such as high-frequency welder.
15. 由电器人员选择合适的插头和有地线的插座。
An appropriate power plug has to be attached to the machine by electric technicians. Power plug has to be connected to a grounded receptacle.
16. 若需要改造或改进本机，请采用有效可行的安全措施。本公司对由此而产生的伤害不承担责任。
The machine is only allowed to be used for the purpose intended. Other used are not allowed.
17. 本机只适用于专业缝纫。
Remodel or modify the machine in accordance with the safety rules/standards while taking all the effective safety measures. We assume no responsibility for damage caused by remodeling or modification of the machine.
18. 两种警告提示符 Warning hints are marked with the two shown symbols.



操作人员或维修人员请注意 Danger of injury to operator or service staff



特别注意事项 Items requiring special attention

安全操作事项 FOR SAFE OPERATION



1. 为避免触电，请不要打开电机的电箱盖，也不要触摸电箱内部组件。
To avoid electrical shock hazards, neither open the cover of the electrical box for the motor nor touch the components mounted inside the electrical box.



1. 为避免人身伤害，移动皮带罩，护手挡或安全装置时，请不要开动机器。
To avoid personal injury, never operate the machine with any of the belt cover, finger guard or safety devices removed.
2. 为尽可能避免机器运转造成的人身伤害，手指、头部和衣服应远离上轮、皮带和电机周围不要放置任何物品。
To prevent possible personal injuries caused by being caught in the machine. Keep your fingers, head and clothes away from the handwheel, V belt and the motor while the machine is operation. In addition, place nothing around them.
3. 为避免人身伤害，当您打开电源开关或操作机器时，切勿将手放在机针下方。
To avoid personal injury, never put your hand under the needle when you turn "ON" the power switch or operate the machine.
4. 为避免人身伤害，机器运转时，切勿将手指放入挑线罩内。
To avoid personal injury, never put your fingers into the thread take-up cover while the machine is in operation.
5. 弯针高速运转时，勿将手指放在弯针附近。另外，换弯针时，请关掉机器电源开关。



- The looper rotates at a high speed while the machine is in operation. To prevent possible injury to hands, be sure to keep your hands away from the vicinity of the looper during operation. In addition, be sure to turn OFF the power to the machine when replacing the looper.
6. 为尽可能避免人身伤害，当翘起或抬升机头时，勿将手指放入机器内部。
To avoid possible personal injuries, be careful not to allow your fingers in the machine when tilting/raising the machine head.
 7. 为尽可能避免机器的突然启动所造成的事故，抬起机头或移动皮带罩或皮带时，请关掉机器的电源。
To avoid possible accidents because of abrupt start to be machine, turn OFF the power to the machine when tilting the machine head or removing the belt cover and the V belt.
 8. 如果您的机器配有伺服电机，机器未运转时，电机无噪音。为避免机器的突然启动所造成的事故，请关掉机器的电源开关。
If your machine is equipped with a servo-motor, the motor does not produce noise while the machine is at rest. To avoid possible accidents due to abrupt start of the machine, be sure to turn OFF the power to the machine.
 9. 为避免触电，移动电源线时，请勿让机器运转。
To avoid electrical shock hazards, never operate the sewing machine with the ground wire for power supply removed.
 10. 为尽可能避免触电或电器组件受损，在插上或拔下插头之前，请关掉电源开关。
To prevent possible accidents because of electric shock or damaged electrical component(s), turn OFF the power switch in prior to the connection/disconnection of the power plug.

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操作前的注意事项 BEFORE OPERATION

注意:

- 为避免机器受损或发生事故, 切记如下:
- 为首次使用本机前, 请彻底清洗, 除去运输过程中的全部灰尘, 并充分加油润滑。
- 确认电压是否正确, 插头与电源连接是否正确。
- 若你的固有电压与本机器设计电压不一致, 请勿使用本机。
- 确认电机转动方向是否正确。
- 使用本机的第一个月, 机器应在低于正常转速下运转。

CAUTION:

- To avoid malfunction and damage of the machine, confirm the following:
- Before you put the machine into operation for the first time after the set-up, clean it thoroughly.
- Remove all dust gathering during transportation and oil it well.
- Confirm that the voltage has been correctly set.
- Confirm that the power plug has been properly connected to the power supply.
- Never use the machine in the case where the voltage type is different from the designated one.
- Confirm that the direction of rotation of the motor pulley is correct.
- Operate your machine at the level of sewing speed in the first month.

一、机器规格 Specification

线迹形式	系列双针双链式缝	系列双针双链式缝	系列单针双链式缝	三针链式缝
速 度	最高每分钟5500转			最高每分钟3500转
针迹长度	1/16"~5/32"(1.4~4mm)			
针杆行程	30mm			
双线间距范围	1/8" 5/32" 3/16" 7/32" 1/4" 5/16" 3/8" 1/2"	3/16"	1/8" x 2	
线迹形式	针杆挑线			
旋机(机针)	TV x 798-21#			
弯 针	独立调节式 1/8"~1/2"通用			
保 针 架	驱动式、固定式使用			
挑线压脚	上升量 8~10mm			
供 油	叶轮泵			
润滑油	2号白油			

Stitch type	Two-needle double-row chain stitch	Two-needle double-line chain stitch	One-needle single-row chain stitch
Speed	Max. 5500 r.p.m.		
Stitch length	1/16"~5/32" (1.4~4mm)		
Stroke of needle bar	30mm		
Gauge of double-row chain stitch	1/8" 5/32" 3/16" 7/32" 1/4" 5/16" 3/8" 1/2"	3/16"	
Thread take-up type	Needle bar thread take up type		
Needle	TV x 7 98-21#		
Looper	Separately adjustable type, for the range of 1/8" to 1/2"		
Needle guard	Oscillating type and rigid type		
Light clearance of knee lifter	8~10mm		
Oil supply	Impeller-type pump		
Lubricating oil	2 white oil		

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二、开车前的注意事项 Pre-start check

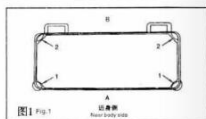
1. 油箱内未加油不能开车。
 2. 机器运转时, 从上方侧看转向应为逆时针方向, 注意, 不能倒转。
 3. 在最初使用的第一个月中, 应把速度降为每分钟4500针进行缝制作业。
 4. 按照电动机名牌上的标注, 检查电压、电压及单相、三相是否正确。
- 1) The machine shall not be started running until the completion of oiling.
- 2) The rotating direction of the balance wheel, when the machine is started running, shall be in counter-clockwise one. View from the right side of the balance wheel, a warning shall be given in advance against making the machine run while balance wheel turning clockwise.
- 3) The machine shall be under operation at less than 4,500 S.P.M. For the first month.
- 4) Check power source, voltage, and phase number to see whether they are in accordance with the ratings on the name plate of the motor to be used.

三、使用注意事项 Operating instructions

1. 机器运转时, 请勿将手放到针的下部。
 2. 机器运转时, 请勿将手指伸入挑线杆护套内。
 3. 机器确已停止后, 才能启动上轮。
 4. 关掉电动机开关后, 由于惯性上的缘故, 电动机还会继续旋转一段时间, 所以要注意, 未停止转动不能将机器倒侧。
 5. 机器运转时, 请勿将手、头发或其它东西靠近或接触上轮、"V"形皮带、电动机, 也不要把手放在它们附近。
 6. 装拆皮带罩及护指器时, 请勿开动机器, 更不得在将皮带罩卸下的状态下开动机器。
- 1) Do not put your hands under the lower part of the needle when the machine is running.
- 2) Do not put your fingers into the thread take-up lever cover when the machine is running.
- 3) Only when the machine stops can you turn the balance wheel by hand.
- 4) After the motor switch being turned off, due to inertia, the motor will continue to rotate for a while. Be careful not to have the machine tilted unless it stops.
- 5) Keep away from the balance wheel, V-belt, winder and the motor.
- 6) Do not start running the machine during mounting or replacing the belt cover, finger guard, etc.

四、机器的安装 (图1) Installation of the machine (Fig.1)

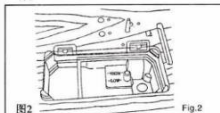
1. 将油箱支座1套在油箱近身侧(A边), 将油箱座垫套在油箱B侧, 再将油箱连同座套一起放入机架中。
 2. 将机头连接钩插入底板孔内, 与台板的机头连接钩相啮合, 再将机头放到四只角的缓冲垫上。
- 1) Nail the rubber washer on the operator's side of the table, lever the washers on the other side (B) then place the oil reservoir on top.
- 2) Put the machine connecting hooks into the holes to engage respectively two hinges seated in the table, then place the machine on the four cushions.



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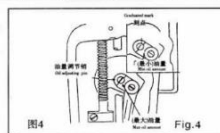
五、加油 (图2,图3) Oiling (Fig.2,3)

1. 向油箱内加缝制油(2号白油)至HIGH记号部位 (图2)。
 2. 如果油面低于LOW记号, 应再加油。
 3. 加油后开动机器, 润滑油正常时, 应看到油液喷到油窗上 (图3)。至于喷到油窗上的油量多少与总油量的多少有关, 所以不必担心。
 4. 如更换新油, 只要拆下油箱的排油螺钉, 油污就能排出。
 5. 使用新机或长期未使用的缝纫机时, 需抬起压脚以每分钟3500~4000针的速度空转约10分钟。
1. Oiling shall be made in oil reservoir and the oil surface also be made to level the mark "High" before machine is started running (Fig.2).
2. Oiling shall be kept on until the oil surface has been brought above the mark "Low" (Fig.3).
3. The normal condition of lubrication is that the oil shall spray onto the oil sight. The amount of oil spraying onto the oil sight is not at all proportional to the total amount of oil in the oil reservoir. There is nothing to worry about.
4. Only when the drain cover screw is loosened and taken off can old oil be drained out and new oil is supplied again.
5. When a new model or those standing idle for long time is to be operated, presser foot shall be lifted and run idle for about ten minutes.



六、面部油量调节 (图4) How to regulate oil amount by means of manipulating elements on the pace plate (Fig.4)

- 转动油量调节销, 可以调节针杆挑线的供油量, 调节销的刻点, 靠近针杆挑线销时, 油量最小, 反之, 则油量最大 (图4)。
- 注意: 调节油量时要十分注意, 供油量并不是随调节立刻变化的。
- To turn oil-amount adjusting pin to regulate oil amount of the thread take-up crank, min. oil amount will be supplied when the mark of adjusting pin moves to the thread take-up crank as near as you desire. Otherwise, max. oil amount will be supplied.



七、机针的安装 (图5,图6) Setting-up of the needle (Fig.5,6)

- 机针请使用TV x 7的9°或21°型机针, 装缝针时应使对应的针孔心线送料方向一致如图5中B。特别是在使用化纤线时, 机针针孔的方向不能如图5中C的方向安装。
- 用化纤线缝制时, 可按 (图6) 所示形式放置硅油, 油箱应另外定制。
- When thread of chemical fibre is used, the direction of the needle eye shall not be in that one, as shown in part C of Fig.5. Needle types to be desired fall within the range of 9° to 21° of TV x 7. Oil tank shall be custom-made when thread of chemical fibre is used; silicone oil can be placed like that, as indicated in Fig.6.



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八. 面线的穿法 (图7) The threading of needle thread. (Fig.7)

在针杆上升到最高位置时, 按图7所示顺序依次穿各线孔。

1. 线从操作者一侧向外穿过机针。

2. 面线穿过机针后必须再拉出100mm长线头。

To thread the eyes of the needles in the order as shown in Fig.7:
1) To make thread go through the eye of the needle outward. (View from the operator's side)
2) To pull out 100mm of the remaining thread after needle thread going through the eyes of the needles.

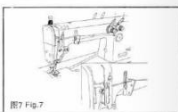


图7 Fig.7

九. 底线的穿法 (图8, 图9) The threading of bobbin thread (Fig.8,9)

底线按图示顺序依次穿各线孔。

1. 按 (图8) 所示穿过头夹线器单面导线板, 如用捻度大的线或缝纫时需用捻度大的时候应穿二个孔。

2. 按 (图9) 中的扳簧朝操作者侧拉, A就向上抬起。

3. 穿弯针线时, 用附件中的镊子按图所示将线穿入, 在弯针的前端拉出50mm长线头。

To make bobbin thread going through the eye of the needle in the order as shown in (Fig.8 and 9)
1) Make the bobbin thread go through the tension guide plate; go through the two holes when thread of harder twist fibre is used and feed gauge is wider than usual.
2) Pull the spring toward the operator, as shown in Fig.9 and part A will rise upwards.
3) When threading the looper, the thread shall be made go through the eye of the needle with a tweezer as shown in Fig.9 and 50mm of remaining thread be pulled out.

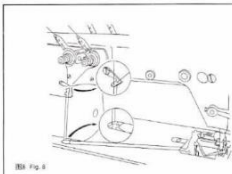


图8 Fig.8

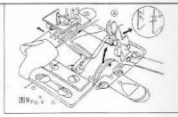


图9 Fig.9

十. 夹线器 (图10, 图11, 图12) Thread tension asm. (Fig.10,11,12)

面线张力的调节 (图10所示): 向右转动夹线螺母张力变大。

底线张力的调节 (图11所示): 向右转动夹线螺母张力变大。

底面线的关系 (图12所示) 为链式线迹的形成。

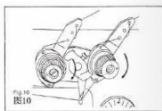


图10 Fig.10

To adjust needle thread tension is accordance what sewing working condition, we can adjust needle thread tension by tension spring. Turn the tension nut clockwise to increase the tension; turn counter-clockwise to decrease the tension.

To adjust bobbin thread tension:
Turn tension screw clockwise to increase the tension; turn tension screw counter-clockwise to tension; turn Tension screw counter-clockwise to decrease the tension.

The relation between the needle thread and the bobbin thread as shown in (Fig.12) depicts the forming of chain stitch.

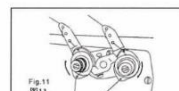


图11 Fig.11

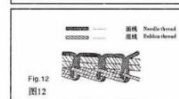


图12 Fig.12

十一. 压脚 (图13, 图14) Presser foot (Fig.13,14)

压脚压力的调节 (图13): 顺向转动压脚调压螺钉, 压力增强, 反之则压力减弱。对一般布料而言, 压脚调压的标准高度为37~30mm (此时压脚压力约为5kg) 左右。要使压脚保持在抬起位置, 只要把压脚扳手向左或向右转动90°即可 (图14)。

Adjustment of pressure on presser foot (Fig.13)
Turn pressure regulating thumb screw clockwise to increase the pressure; turn pressure-regulating thumb screw counter-clockwise to decrease the pressure. For general fabric the standard height of pressure regulating thumb screw is about 27-30mm (5kg).

The presser bar lifter shall be turned either leftward or rightward in order to keep the presser foot under the condition of lifting position.

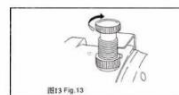


图13 Fig.13

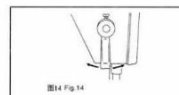


图14 Fig.14

十二. 针距的调节 (图15) To adjust stitch length (Fig.15)

1. 针迹长度的调节 (图15) 只要旋转针距调节旋钮至所需数字即可。旋钮上刻度的数字用mm表示。
2. 针迹从大到小改变送料速度时, 应一边将送料扳手手朝下压; 一边转动送料速度旋钮。
3. 针迹长度最大是4mm, 最小是1.4mm。
4. 按下送料速度扳手, 针迹变为紧密缝 (1.4mm) 该功能可用于起始缝和终止缝或需加强缝的部分。
5. 本机不能进行倒缝。

1. Turn feed regulating dial to the figure desired. The value of graduation is shown in millimetre (mm).
2. If you intend to change the stitch length, press down the reverse feed lever while turning the feed regulating dial.
3. Max. stitch length is 4mm; Min. stitch length is 1.4mm.
4. When reverse feed lever is pressed down, tight-needle stitch of 1.4mm will be formed; this version of stitch is suitable for beginning and end sewing or partaking.
5. The machine can not make reverse stitching.

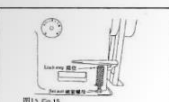


图15 Fig.15

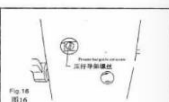


图16 Fig.16

十三. 压脚高度的调节 (图16) Adjustment of the height of the presser bar (Fig.16)

为了调换压脚或改变压脚高度、角度需要:

1. 拆下面板上的孔塞 (图16)

2. 旋松压脚导架的紧固螺钉进行调节。

3. 调节后旋紧紧固螺钉。

For the requirements of either replacing the presser foot or changing the height and angle of presser foot, the following shall be observed:
1. Take off the rubber plug in the hole from the face plate, as shown in Fig.16.
2. Loosen the presser bar guide bracket set screw, and adjust.
3. After adjusting, retighten the screw.

十四. 送料牙的调节 (图17, 18) Adjustment of the height of the feed dog (Fig.17,18)

旋松 (图18) 所示螺钉②, 送料牙的倾角可调节成标准型、A型、B型, 送料牙最大突出量是0.8mm, 用 (图17) 中螺钉①调节。
Loosen the set screw ②, as shown in Fig.18, the angle of the feed dog can be adjusted to the specified one of standard version, A version, and B version. The Max. Height of 0.8mm of the projection from dog is adjustable by the adjusting of screw ① as shown in Fig.17.



图17 Fig.17

图18 Fig.18

十五. 送料牙与针的同步 (图19) The timing of feed dog and needle (Fig.19)

针尖下降至针板上平面3mm时, 送料牙 When the point of needle lowering down to the location 刚好全部下降至针板上平面以下, 此时正好 3mm from the upper surface of the throat plate, the feed dog is right at the position below the upper surface of the throat plate, viz. The timing of feed dog being well regulated in relation to the motion of needle.



图19 Fig.19

十六. 针杆高度的调节 (图20) Adjustment of the height of needle bar (Fig.20)

使用TVX7机针时, 可用针杆上的刻线,

针杆在下死点时, 针杆上刻线应对准针杆下衬套的下端面。 (如图20所示)

When the needle of TVX7 is used, if the graduation on the needle bar is at the bottom dead centre, the mark of graduation shall be in line with the lower end of the needle bar bushing, lower, as indicated in Fig.20.



图20 Fig.20

十七. 机针和弯针的调节 (图21, 图22) Adjustment of the needle and looper (Fig.21,22)

弯针前后运动量的调节:

按如下顺序调节可得弯针椭圆运动中 (图21)

所示的B尺寸, 通常B的尺寸在最大时为3.7mm, 各种规格的机针都能缝纫。

1. 拆下弯针由柄罩上的橡胶塞 (图22)

Adjustment of forward & backward motion of the looper: The dimension of part B of the looper in an elliptic motion can be measured, (refer to Fig.21). The max. dimension of part B is usually 3.7mm, suitable for sewing operation of needles of all kinds of sizes.

The adjusting procedure is as follows:
1) Take off the rubber plug on the crank case of the looper (refer to Fig.22)

2. 用手转动上轮。
3. 先旋松定位螺钉和紧固螺钉, 调节有标号的螺钉。
4. 把调节螺钉上的冲印标记向右旋转, 则B的尺寸就会变大, 反之变小。
5. 旋紧固定螺钉和紧固螺钉。

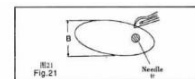


图21 Fig.21

2) Turn the balance wheel by hand.
3) First loosen set screw and positioning screw, and then adjust marked screw.
4) Turn clockwise the adjustable screw on which punch mark is printed, and the dimension of part B will be increased in value.
5) Tighten set screw and positioning screw.

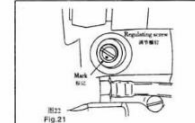


图22 Fig.22

十八. 弯针相对机针的同步 (图23) The timing of looper in reference to needle (Fig.23)

机针在最低点时, 弯针退到最后, 旋松图示齿轮的螺钉进行同步调整 (如图23)。
The looper shall be moved backward to the lowest position while the needle is at the bottom dead centre; loosen the screw on the gear and make timing adjustment of the looper in relation to the needle (refer to Fig.23).



图23 Fig.23

十九. 弯针的勾取量 (图24) Thread-guiding amount of the looper (refer to Fig.24)

1. 弯针的针尖到达机针的中心位置时, 弯针针尖离机针上端的距离标准值是2mm, 此时针杆下刻线和针杆下衬套下端面对齐。 (如图24)
2. 弯针的后退量约3.5mm。
3. 机针孔和弯针孔的相对关系如 (图24) 所示。 (左右弯针可以分别调整)

1) The standard value of the vertical distance of the point of the looper away from the upper end of the eye of the needle is 2mm, then the graduation mark on the lower part of the needle bar shall be in line with the lower end of the needle bar bushing, lower. (Refer to Fig.24)
2) The value of the stroke moved backward by the looper is about 3.5mm.
3) The relation between the eye of the needle and the eye of the looper is indicated in Fig.24. (Note that the left looper and the right one can be separately adjusted.)

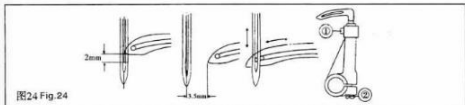


图24 Fig.24

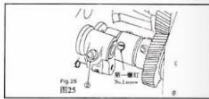
二十. 弯针和机针间的间隙 The clearance of looper and needle

保持针调整后, 机针和弯针间应留有一定间隙, 即用手指轻压机针, 机针也不应碰到弯针针尖。如果间隙太小了, 机针的侧面与弯针针尖就会因相互碰撞而损伤。
After adjusting the needle guard, the clearance of a given value between the needle and the looper shall be kept unchanged; the needle shall not touch at the point of the looper when it is pressed down softly. If the clearance is narrower than usual. The side of the needle and the point of the looper are apt to incur breakage due to the impact of the needle side against the looper point.

二十一. 保针架的同步 (图25) The timing of needle guard (Fig.25)

保针架的同步, 由 (图25) 中第一螺钉旋入弯针轴上的平面而决定。

The timing of the needle guard depends on the condition of the plane on the rock shaft of the looper when no.1 screw has been screwed into this rock shaft.



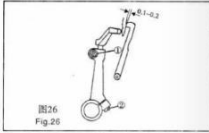
二十二. 保针架的位置 (图26) Position of needle guard (Fig.26)

摆动保针架位置, 使弯针勾取面线时让机针的针尖轻轻触及保针架, 其高度应调整到不触及固定保针架范围, 旋松 (图26) 中螺钉①后即可进行调节。

Oscillating the needle guard to make the needle tip contact with needle gauge slightly.
It is recommended that the height adjustment shall not fall within the area of the left counter needle guard. The adjustment can be made by loosening screw ① and ②. The relation between left counter needle guard and the counter needle guard is as represented in Fig.26; the clearance from the needle falls within the range of 0.1 to 0.2mm.

Note that the forced clamp of the needle shall be prohibited when the machine is in motion.

固定保针架和摆动保针架之间的关系 (如图26) 所示, 与机针的间隙为 0.1-0.2 mm, 缝制机运转时不能强行夹住机针。



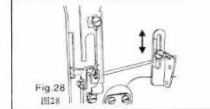
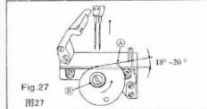
二十三. 底线打线凸轮的 (图27) Looper thread take-up cam (Fig.27)

底线打线凸轮的位置如图 (图27) 所示。机针在最高点时, 打线凸轮平面部分和铜丝平行部分的夹角为18°-20°, 旋松螺钉B进行调整, 位置决定后再旋紧。

调整时请注意下列事项: 底线从打线凸轮的夹脚A脱出时, 针尖要完全进入底线弯针的线环中。

Its position can be seen as shown in Fig.27 when the needle bar is at the top dead centre, the planes of the cam and steel wire are parallel; the projecting part of the cam can slightly rise at the angle of 18 to 20 degrees. First loosen screw B, and then make adjustment, finally tighten the make adjustment, finally tighten the screw firmly. Pay close attention to the following: the needle tip shall entirely come into the thread loop of the looper when the bobbin thread rejecting from the projecting part of the cam.

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二十四. 挑线杆线量调节板的位置 (图28) The position of the thread take-up plate (Fig.28)

针杆在最低点时, 如图 (图28) 所示, 用挑线杆线量调节板挡住面线, 这样勾取面线时, 面线线环变大。

此外, 针杆在最低点时, 也有拉紧面线线环的作用, 通常在使用较细的面线时, 应把线量调节板调到最低点。

The thread-take-up adjusting plate will retain the bobbin at thread when the needle bar is the bottom dead center; in such a way the loop of the needle thread is to become bigger when the needle thread is hooked. In addition to the foregoing there is a function of the tight pulling of the needle thread loop. The thread-take-up adjusting plate usually reduces to the lowest point when a thread finer than normal is used. Note that take-up thread tension lever is another name for thread-take-up adjusting plate.

二十五. 中间导线钩 (图29) Frame thread eyelet (Fig.29)

中间导线钩的位置也关系到跳针现象的发生, 一般把下列位置作为基准 (图29)

棉线 #80-#50 中间导线钩刻度 2-3 化纤线 #80-#50 中间导线钩刻度 1-2

棉线 #30-#20 中间导线钩刻度 3-4 化纤线 #30-#20 中间导线钩刻度 2-3

The improper-positioning of the frame thread eyelet may be the cause of occurrence of skipping stitch.

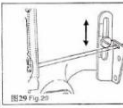
The following locations are generally regarded as criteria (refer to Fig.2)

Cotton thread #80-50 Graduation marked on the frame thread eyelet 2-3

Cotton thread #30-50 Graduation marked on the frame thread eyelet 3-4

Thread of chemical fibre #80-50 Graduation marked on the frame thread eyelet 1-2

Thread of chemical fibre #30-50 Graduation marked on the frame thread eyelet 2-3



二十六. 针板的调换 (图30) Replacement of throat plate (Fig.30)

The standard size of the throat plate in parts book, which is stipulated by the manufacturer, is 1/4", equivalent to 6.4mm. (Fig.30)

The replacement of the following components is usually needle at the time when changing the gauge of double-row thread stitch.

1. Needle clamp
2. Hinged foot
3. Throat plate
4. Feed dog
5. Rear moving needle guard
6. Curler

The left and right looper within the range of the sizes of 1/8" to 1/2" are interchangeable.

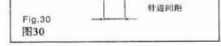
In addition to the aforesaid, the replacement of slide plate and cam cover shall be made when the width of thread plate is on the increase.

并到双针缝制机缝距出厂标准规格为 1/4" (6.4mm)。(图30)

改变缝线间距通常同时要更换:

1. 针夹
2. 活压脚
3. 针
4. 送料牙
5. 摆动护针杆
6. 卷边器左弯针和右弯针

在 1/8" - 1/2" 针板规格之内都通用。针板宽度大时, 除上述零件外还要调换压板板凸轮盖。



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二十七. 缝制机的保养 Maintenance of the machine

为了使缝制机保持良好的工作状态, 要做到以下事项:

(一) 每日必须检查的事项:

1. 运转时, 油室内有油在飞溅。
2. 运转时, 一听到有异常声音, 应立即停止运转, 并沿修理工来检查。

(二) 每周一次检查部位:

1. 拆下针板、推板、凸轮盖, 用刷子清洗送料牙槽中的灰尘。
2. 把机头翻转, 去除除油过滤网上的垃圾及油室内的灰尘。
3. 发现漏油现象时, 只需拧下油盒的排油螺钉排空污油, 擦去沾在油盒和磁铁上的油污, 再紧固排油螺钉后, 注入新的润滑油。
4. 油面必须高于最低线 (LOW)

The following shall be adhered to in order to keep the machine in good working condition.
(1) Daily checking
I. The oil shall spray onto the oil sight when the machine is running.
II. Repairman shall be sent for when abnormal sound is heard during the operation of the machine.
(2) Locations to be checked once a week:
I. To make off throat plate, slide plate, and cam cover; to clean dust of the slotted feed dog with a brush.
II. To turn over the over the head to rid both the oil filter screen on the oil pump and the interior of the oil reservoir of oil stain and dust.
III. Loosen drain hole screw and take it off; drain all the dirty oil from the oil reservoir and refill it.
IV. Oil level must be above the lowest oil-level-indicating line marked "Low".
V. The black powder, adhering to the magnet in the oil reservoir shall be wiped with sponge cloth.

二十八. 故障和措施 Common breakdowns and measures of trouble shooting

序号	事故内容	原因	对策
1	断线	1. 缝线质量差 2. 缝线太粗 (线比针槽粗) 3. 机针过钝或弯曲 4. 缝线张力太强 5. 机针、弯针、针板、保针架过线部位损伤 6. 线量未调节好	1. 使用质量好的缝线 2. 调修合适的缝线 3. 使用钝油或降低转速 4. 旋松夹线螺母 5. 用油石磨光并抛光 6. 调节线量调节板
2	跳针	1. 面线跳针 2. 底线跳针 3. 使用化纤线时的跳针 4. 使用合成纤维线时的跳针	1. 调整弯针勾取量 2. 调整弯针与机针的间隙 3. 调整机针同弯针的同步 4. 根据缝线的情况调整线量调节板 5. 调整中间导线钩的位置 6. 检查机针安装是否正确 7. 检查保针架的位置和同步是否正确 8. 检查缝线是否正确
3	断针	1. 面线跳针 2. 底线跳针 3. 使用化纤线时的跳针 4. 使用合成纤维线时的跳针	1. 按上述面线跳针, 2. 检查 2. 检查底线跳针的同步 3. 稍带增强底线的张力 4. 检查缝线是否正确
4	断针	1. 面线跳针 2. 底线跳针 3. 使用化纤线时的跳针 4. 使用合成纤维线时的跳针	1. 使用钝油 2. 降低转速 3. 使用化纤线时的机针 4. 降低转速 5. 使用钝油

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No.	Breakdown	Cause	Measures to be taken
3	断针	1. 面线张力太强 2. 底线张力太强 3. 缝线太粗 4. 中间导线钩的位置不够正确 5. 挑线杆位置调节板位置不正确 6. 针板 7. 机针 8. 送料和机针不同步 9. 压脚的安装有问题	1. 旋松面线夹线螺母 2. 旋松底线夹线螺母 3. 调修大号机针 4. 调整中间导线钩的位置 5. 调整线量调节板的位置 6. 使用针孔大的针板 7. 换针 8. 调整送料和机针不同步 9. 调整压脚的安装
4	断针	1. 面线张力太强 2. 底线张力太强 3. 缝线太粗 4. 中间导线钩的位置不够正确 5. 挑线杆位置调节板位置不正确 6. 针板 7. 机针 8. 送料和机针不同步 9. 压脚的安装有问题	1. 旋松面线夹线螺母 2. 旋松底线夹线螺母 3. 调修大号机针 4. 调整中间导线钩的位置 5. 调整线量调节板的位置 6. 使用针孔大的针板 7. 换针 8. 调整送料和机针不同步 9. 调整压脚的安装
5	起皱	1. 面线张力太强 2. 底线张力太强 3. 缝线太粗 4. 中间导线钩的位置不够正确 5. 挑线杆位置调节板位置不正确 6. 针板 7. 机针 8. 送料和机针不同步 9. 压脚的安装有问题	1. 旋松面线夹线螺母 2. 旋松底线夹线螺母 3. 调修大号机针 4. 调整中间导线钩的位置 5. 调整线量调节板的位置 6. 使用针孔大的针板 7. 换针 8. 调整送料和机针不同步 9. 调整压脚的安装
1	Thread breakage	1. Poor thread quality 2. Thread being too thick 3. Fusing thread due to high temperature of needle caused by machine operation at high speed 4. Tension being too higher 5. Breakage of needle, looper, throat plate, and needle guard at the location of thread guide 6. Failure to adjust thread amount	1. Quality thread to be used 2. Replacement to be made by an appropriate thread 3. Silicone oil to be lubricated 4. The tension not to be too high 5. First grinding with oil stone and then polishing 6. Adjusting the thread amount adjusting plate 7. Adjusting thread-backing amount of looper 8. Adjusting clearance between looper and needle 9. The timing of needle in reference to looper, or thread amount adjusting condition 10. Adjusting the timing of thread eyelet 11. Checking whether the mounting position of the needle is proper or not 12. To see if the location of needle guard is in an appropriate way and the timing of it is well adjusted in relation to needle 13. To see if the timing of needle thread is in a proper position
2	Skipping stitch	1. Skipping stitch of needle thread (hooking of one stitch, needle failure to enter the looper eyelet) 2. Skipping stitch of bobbin thread (hooking of one stitch, needle failure to enter the looper eyelet) 3. Skipping stitch when thread of chemical fibre being in use 4. Skipping stitch when thread of polyester fibre being in use	1. Reference to the above items 1 and 2, to no skipping stitch of the needle thread 2. To see if the timing of bobbin thread can be well regulated 3. Increasing tension of bobbin thread a bit higher 4. To see if the timing of bobbin thread is in a correct way 5. Using silicone oil 6. Reducing speed 7. Using needle for thread of chemical fibre 8. Reducing speed 9. Silicone oil to be used
3	Twisted stitches	1. Needle thread tension being too low 2. Bobbin thread tension being too low 3. Sewing thread being too thick 4. Inappropriate position of the frame thread eyelet 5. Inappropriate position of thread take-up tension plate 6. Throat plate	1. Tightening tension nut of needle thread 2. Tightening tension nut of bobbin thread 3. Needle of large size to be used 4. Redesigning it to a proper position 5. Readjusting its position in an appropriate way 6. The thread take-up tension plate to be used being bigger than normal one 7. Needle to be replaced by another of proper size 8. Redesigning the timing to feed dog to respect to the needle 9. To make both the center of the hole of the throat plate and the center of the thread eyelet to be in a straight line 10. Redesigning & the timing of the needle guard to be used in an appropriate way 11. Reducing needle thread 12. Reducing speed 13. To see if the timing of bobbin thread can be well regulated 14. Increasing tension of bobbin thread a bit higher 15. To see if the timing of bobbin thread is in a correct way 16. Using silicone oil 17. Reducing speed 18. Using needle for thread of chemical fibre 19. Reducing speed 20. Silicone oil to be used
4	Breakage of needle	1. Needle being too thin 2. The operation of feed dog being not well regulated in reference to the motion of needle 3. Winding up of the press foot 4. The problem of the timing of needle guard mounting mechanism 5. Needle thread tension being too high 6. Needle being too thick	1. Needle of large size to be used 2. To make both the center of the hole of the throat plate and the center of the thread eyelet to be in a straight line 3. Redesigning & the timing of the needle guard to be used in an appropriate way 4. Reducing needle thread 5. Reducing speed 6. To see if the timing of bobbin thread can be well regulated 7. Increasing tension of bobbin thread a bit higher 8. To see if the timing of bobbin thread is in a correct way 9. Using silicone oil 10. Reducing speed 11. Using needle for thread of chemical fibre 12. Reducing speed 13. Silicone oil to be used
5	Puckering	1. Thread tension being too high 2. The problem of the timing of the bobbin thread eyelet for thread guiding failing to be solved 3. The problem of surface finish entering from bobbin thread going through the press on the throat guide 4. Press force on the press foot being too big	1. Decreasing thread tension, esp. Tension of bobbin thread 2. Redesigning of the very case said to solve the timing problem 3. Surface finishing all the parts on the throat guide 4. Pressing counter-clockwise the pressure-regulating screw

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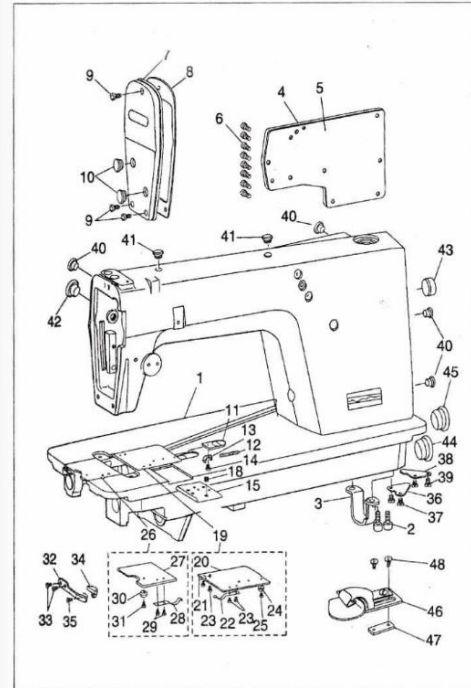
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(本样本中图样、件号、名称、结构仅供参考, 如有变动, 以产品实物为准)

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1. 机壳分组件 Arm bed components



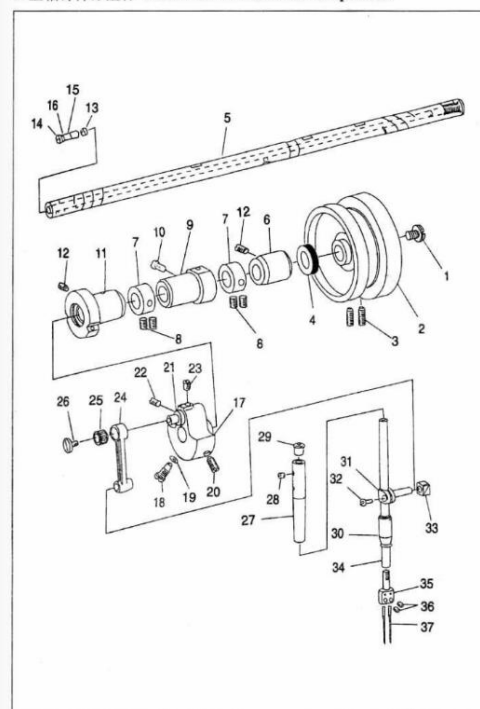
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1. 机壳分组件 Arm bed components

序号 Ref. No.	件号 Part No	名称 Description	数量 Arm Req.
1	40-1-1	机壳部件	1
2	40-1-2	底座支承螺钉	2
3	40-1-3	底座支承板	1
4	40-1-4	后盖板	1
5	40-1-5	后盖板垫	1
6	40-1-6	后盖板螺钉	8
7	40-1-7	面版	1
8	40-1-8	面版垫	1
9	40-1-9	面版螺钉	3
10	40-1-10	面版橡胶垫	2
11	40-1-11	凸轮盖压板	1
12	40-1-12	凸轮盖压板弹簧	1
13	40-1-13	凸轮盖压板弹簧座	1
14	40-1-14	凸轮盖压板座螺钉	1
15	40-1-15	附件安装板	1
16	40-1-16	附件安装板定位螺钉	1
17	40-1-17	凸轮盖部件	(1)
18	40-1-18	凸轮盖	1
19	40-1-19	凸轮盖托板	1
20	40-1-20	凸轮盖弹簧	1
21	40-1-21	凸轮盖弹簧螺钉	4
22	40-1-22	凸轮盖导轮	1
23	40-1-23	凸轮盖导轮螺钉	1
24	40-1-24	推板部件	(1)
25	40-1-25	推板	1
26	40-1-26	推板簧	1
27	40-1-27	推板簧螺钉	2
28	40-1-28	推板导轮	1
29	40-1-29	推板导轮螺钉	1
30	40-1-30	推板锁簧	1
31	40-1-31	推板锁簧螺钉	2
32	40-1-32	推板簧垫手	1
33	40-1-33	推板簧垫手螺钉	1
34	40-1-34	送料轴油板挡油板	1
35	40-1-35	底座挡油板螺钉	2
36	40-1-36	抬牙轴底挡油板	1
37	40-1-37	底座挡油板螺钉	2
38	40-1-38	轴套定位螺孔塞	4
39	40-1-39	上轴套油线孔塞	2
40	40-1-40	针杆曲柄螺孔塞	1
41	40-1-41	送料针能调节螺孔塞	1
42	40-1-42	抬牙轴孔塞	1
43	40-1-43	下轴孔塞	1
44	40-1-44	卷边器部件(1/4")	1
45	40-1-45	卷边器垫块	1
46	40-1-46	卷边器螺钉	2

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2. 上轴针杆分组件 Main shaft & needle bar components



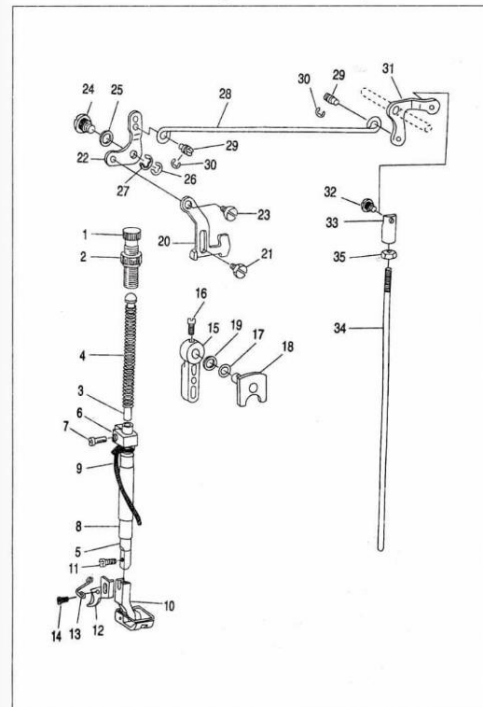
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2. 上轴针杆组件 Main shaft & needle bar components

序号 Ref. No.	件号 Part No	名称 Description	数量 Arm. Req.
1	40-2-1	上轴安全螺钉	1
2	40-2-2	上轮	1
3	40-2-3	上轮螺钉	2
4	40-2-4	上轮油封	1
5	40-2-5	上轴	1
6	40-2-6	上轴后轴套部件	1
7	40-2-7	上轴挡圈	2
8	40-2-8	上轴挡圈螺钉	4
9	40-2-9	上轴中轴套部件	1
10	40-2-10	中轴套螺钉	1
11	40-2-11	上轴前轴套部件	1
12	40-2-12	轴套螺钉	2
13	40-2-13	曲柄油压限制毡	1
14	40-2-14	曲柄油量调节销	1
15	40-2-15	曲柄油量调节销套	1
16	40-2-16	曲柄油量调节销O形圈	1
17	40-2-17	针杆曲柄	1
18	40-2-18	针杆曲柄定位螺钉	1
19	40-2-19	定位螺钉O形圈	1
20	40-2-20	针杆曲柄紧固螺钉	1
21	40-2-21	针杆连杆	1
22	40-2-22	挑线曲柄定位螺钉	1
23	40-2-23	挑线曲柄螺钉	1
24	40-2-24	针杆连杆	1
25	40-2-25	针杆连杆滚针轴承	1
26	40-2-26	针杆连杆左旋螺钉	1
27	40-2-27	针杆上衬套	1
28	40-2-28	针杆上衬套螺钉	1
29	40-2-29	针杆上衬套孔塞	1
30	40-2-30	针杆下衬套	1
31	40-2-31	针杆连接柱	1
32	40-2-32	针杆连接柱螺钉	1
33	40-2-33	针杆连接柱滑块	1
34	40-2-34	针杆	1
35	40-2-35	针夹(1/4")	1
36	40-2-36	支针螺钉	2
37	40-2-37	机针	2

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3. 压料分组件 Presser bar components



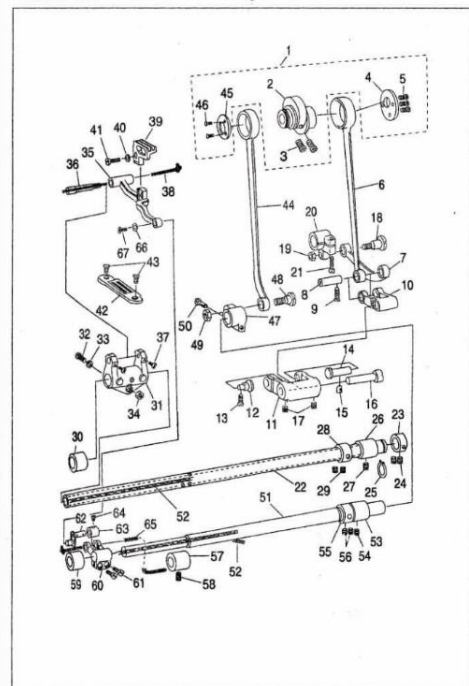
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3. 压料分组件 Presser bar components

序号 Ref. No.	件号 Part No	名称 Description	数量 Arm. Req.
1	40-3-1	调压螺钉	1
2	40-3-2	调压螺钉螺母	1
3	40-3-3	调压导杆	1
4	40-3-4	调压簧	1
5	40-3-5	压杆	1
6	40-3-6	压杆导架	1
7	40-3-7	压杆导架螺钉	1
8	40-3-8	压杆衬套	1
9	40-3-9	压杆油线	1
10	40-3-10	压脚部件1/4"	1
11	40-3-11	压脚螺钉	1
12	40-3-12	切线刀	1
13	40-3-13	切线刀导钩	1
14	40-3-14	切线刀导钩螺钉	1
15	40-3-15	压脚扳手	1
16	40-3-16	压脚扳手螺钉	1
17	40-3-17	压脚扳手垫圈	1
18	40-3-18	压脚提升凸轮	1
19	40-3-19	压脚扳手轴O形圈	1
20	40-3-20	压脚升降板	1
21	40-3-21	升降板轴位螺钉	1
22	40-3-22	抬压脚前杆	1
23	40-3-23	前杆杆轴位螺钉	1
24	40-3-24	前杆杆轴位销	1
25	40-3-25	前杆杆轴位销套圈	1
26	40-3-26	前杆杆轴位开口挡圈	1
27	40-3-27	前杆杆轴位挡圈	1
28	40-3-28	抬压脚拉杆	1
29	40-3-29	抬压脚拉杆螺钉	2
30	40-3-30	抬压脚拉杆开口挡圈	2
31	40-3-31	抬压脚后杆	1
32	40-3-32	后杆杆轴位螺钉	1
33	40-3-33	抬压脚顶杆接头	1
34	40-3-34	抬压脚顶杆	1
35	40-3-35	抬压脚顶杆螺母	1

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4. 送料分组件 Feed mechanism components



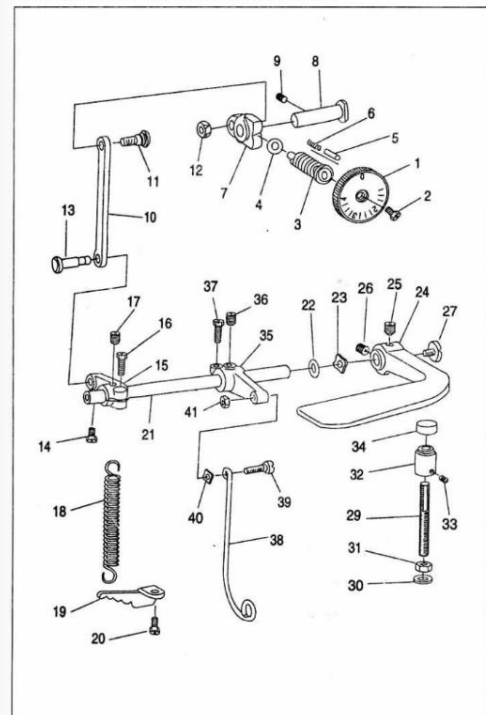
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4. 送料分组件 Feed mechanism components

序号 Ref. No.	件号 Part No.	名称 Description	数量 Arm. Req.
1	40-4-1	送料偏心凸轮	1
2	40-4-2	送料偏心凸轮	1
3	40-4-3	送料偏心轴衬套	2
4	40-4-4	送料偏心轴衬套	1
5	40-4-5	送料偏心轴衬套	3
6	40-4-6	送料偏心轴衬套	1
7	40-4-7	送料偏心轴衬套	1
8	40-4-8	送料偏心轴衬套	1
9	40-4-9	送料偏心轴衬套	1
10	40-4-10	送料偏心轴衬套	1
11	40-4-11	送料偏心轴衬套	1
12	40-4-12	送料偏心轴衬套	1
13	40-4-13	送料偏心轴衬套	1
14	40-4-14	送料偏心轴衬套	1
15	40-4-15	送料偏心轴衬套	1
16	40-4-16	送料偏心轴衬套	1
17	40-4-17	送料偏心轴衬套	1
18	40-4-18	送料偏心轴衬套	1
19	40-4-19	送料偏心轴衬套	1
20	40-4-20	送料偏心轴衬套	1
21	40-4-21	送料偏心轴衬套	1
22	40-4-22	送料偏心轴衬套	1
23	40-4-23	送料偏心轴衬套	1
24	40-4-24	送料偏心轴衬套	2
25	40-4-25	送料偏心轴衬套	1
26	40-4-26	送料偏心轴衬套	1
27	40-4-27	送料偏心轴衬套	1
28	40-4-28	送料偏心轴衬套	1
29	40-4-29	送料偏心轴衬套	2
30	40-4-30	送料偏心轴衬套	1
31	40-4-31	送料偏心轴衬套	1
32	40-4-32	送料偏心轴衬套	1
33	40-4-33	送料偏心轴衬套	1
34	40-4-34	送料偏心轴衬套	1
35	40-4-35	送料偏心轴衬套	1
36	40-4-36	送料偏心轴衬套	2
37	40-4-37	送料偏心轴衬套	2
38	40-4-38	送料偏心轴衬套	1
39	40-4-39	送料偏心轴衬套	1
40	40-4-40	送料偏心轴衬套	1
41	40-4-41	送料偏心轴衬套	1
42	40-4-42	送料偏心轴衬套	1
43	40-4-43	送料偏心轴衬套	2
44	40-4-44	送料偏心轴衬套	1
45	40-4-45	送料偏心轴衬套	1
46	40-4-46	送料偏心轴衬套	2
47	40-4-47	送料偏心轴衬套	1
48	40-4-48	送料偏心轴衬套	1
49	40-4-49	送料偏心轴衬套	1
50	40-4-50	送料偏心轴衬套	1
51	40-4-51	送料偏心轴衬套	1
52	40-4-52	送料偏心轴衬套	1
53	40-4-53	送料偏心轴衬套	1
54	40-4-54	送料偏心轴衬套	1
55	40-4-55	送料偏心轴衬套	2
56	40-4-56	送料偏心轴衬套	1
57	40-4-57	送料偏心轴衬套	1
58	40-4-58	送料偏心轴衬套	1
59	40-4-59	送料偏心轴衬套	1
60	40-4-60	送料偏心轴衬套	1
61	40-4-61	送料偏心轴衬套	2
62	40-4-62	送料偏心轴衬套	1
63	40-4-63	送料偏心轴衬套	1
64	40-4-64	送料偏心轴衬套	1
65	40-4-65	送料偏心轴衬套	1
66	40-4-66	送料偏心轴衬套	1
67	40-4-67	送料偏心轴衬套	1

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5. 送料调节分组件 Feed regulating components

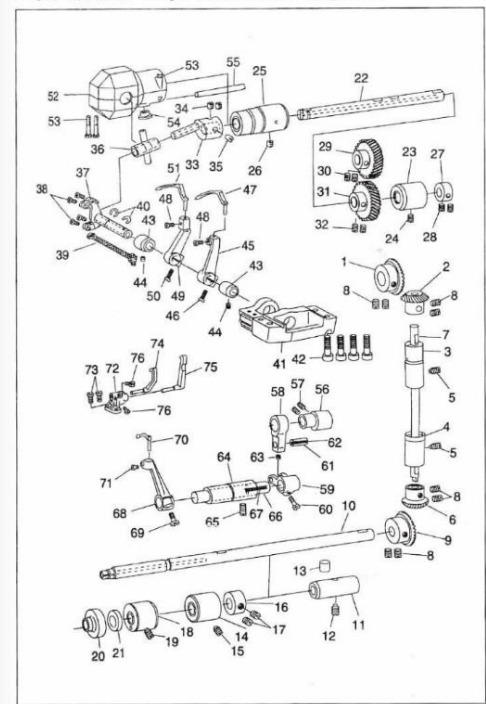


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序号 Ref. No.	件号 Part No.	名称 Description	数量 Arm. Req.
1	40-5-1	送料调节螺母	1
2	40-5-2	送料调节螺母	1
3	40-5-3	送料调节螺母	1
4	40-5-4	送料调节螺母	1
5	40-5-5	送料调节螺母	1
6	40-5-6	送料调节螺母	1
7	40-5-7	送料调节螺母	1
8	40-5-8	送料调节螺母	1
9	40-5-9	送料调节螺母	1
10	40-5-10	送料调节螺母	1
11	40-5-11	送料调节螺母	1
12	40-5-12	送料调节螺母	1
13	40-5-13	送料调节螺母	1
14	40-5-14	送料调节螺母	1
15	40-5-15	送料调节螺母	1
16	40-5-16	送料调节螺母	1
17	40-5-17	送料调节螺母	1
18	40-5-18	送料调节螺母	1
19	40-5-19	送料调节螺母	1
20	40-5-20	送料调节螺母	1
21	40-5-21	送料调节螺母	1
22	40-5-22	送料调节螺母	1
23	40-5-23	送料调节螺母	1
24	40-5-24	送料调节螺母	1
25	40-5-25	送料调节螺母	1
26	40-5-26	送料调节螺母	1
27	40-5-27	送料调节螺母	1
28	40-5-28	送料调节螺母	1
29	40-5-29	送料调节螺母	1
30	40-5-30	送料调节螺母	1
31	40-5-31	送料调节螺母	1
32	40-5-32	送料调节螺母	1
33	40-5-33	送料调节螺母	1
34	40-5-34	送料调节螺母	1
35	40-5-35	送料调节螺母	1
36	40-5-36	送料调节螺母	1
37	40-5-37	送料调节螺母	1
38	40-5-38	送料调节螺母	1
39	40-5-39	送料调节螺母	1
40	40-5-40	送料调节螺母	1
41	40-5-41	送料调节螺母	1

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6. 弯针勾线分组件 Loooper thread retainer components



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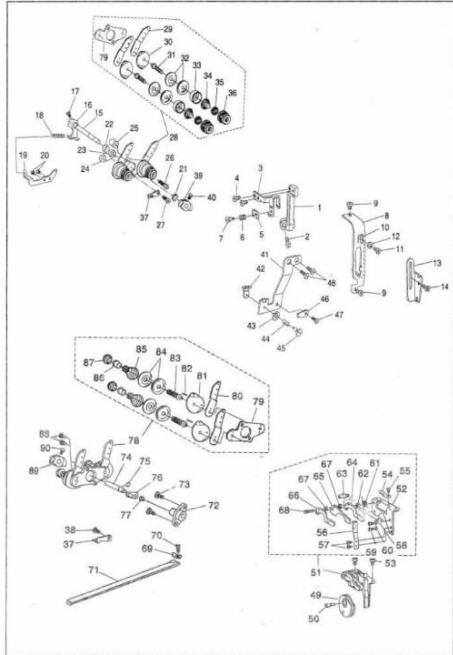
序号 Ref. No.	件号 Part No.	名称 Description	数量 Arm. Req.
1	40-1-1	下轴衬套	1
2	40-1-2	下轴衬套	1
3	40-1-3	下轴衬套	1
4	40-1-4	下轴衬套	1
5	40-1-5	下轴衬套	1
6	40-1-6	下轴衬套	1
7	40-1-7	下轴衬套	1
8	40-1-8	下轴衬套	1
9	40-1-9	下轴衬套	1
10	40-1-10	下轴衬套	1
11	40-1-11	下轴衬套	1
12	40-1-12	下轴衬套	1
13	40-1-13	下轴衬套	1
14	40-1-14	下轴衬套	1
15	40-1-15	下轴衬套	1
16	40-1-16	下轴衬套	1
17	40-1-17	下轴衬套	1
18	40-1-18	下轴衬套	1
19	40-1-19	下轴衬套	1
20	40-1-20	下轴衬套	1
21	40-1-21	下轴衬套	1
22	40-1-22	下轴衬套	1
23	40-1-23	下轴衬套	1
24	40-1-24	下轴衬套	1
25	40-1-25	下轴衬套	1
26	40-1-26	下轴衬套	1
27	40-1-27	下轴衬套	1
28	40-1-28	下轴衬套	1
29	40-1-29	下轴衬套	1
30	40-1-30	下轴衬套	1
31	40-1-31	下轴衬套	1
32	40-1-32	下轴衬套	1
33	40-1-33	下轴衬套	1
34	40-1-34	下轴衬套	1
35	40-1-35	下轴衬套	1
36	40-1-36	下轴衬套	1
37	40-1-37	下轴衬套	1
38	40-1-38	下轴衬套	1
39	40-1-39	下轴衬套	1
40	40-1-40	下轴衬套	1
41	40-1-41	下轴衬套	1
42	40-1-42	下轴衬套	1
43	40-1-43	下轴衬套	1
44	40-1-44	下轴衬套	1
45	40-1-45	下轴衬套	1
46	40-1-46	下轴衬套	1
47	40-1-47	下轴衬套	1
48	40-1-48	下轴衬套	1
49	40-1-49	下轴衬套	1
50	40-1-50	下轴衬套	1
51	40-1-51	下轴衬套	1
52	40-1-52	下轴衬套	1
53	40-1-53	下轴衬套	1
54	40-1-54	下轴衬套	1
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63	40-1-63	下轴衬套	1
64	40-1-64	下轴衬套	1
65	40-1-65	下轴衬套	1
66	40-1-66	下轴衬套	1
67	40-1-67	下轴衬套	1
68	40-1-68	下轴衬套	1
69	40-1-69	下轴衬套	1
70	40-1-70	下轴衬套	1
71	40-1-71	下轴衬套	1
72	40-1-72	下轴衬套	1
73	40-1-73	下轴衬套	1
74	40-1-74	下轴衬套	1
75	40-1-75	下轴衬套	1
76	40-1-76	下轴衬套	1
77	40-1-77	下轴衬套	1
78	40-1-78	下轴衬套	1
79	40-1-79	下轴衬套	1
80	40-1-80	下轴衬套	1
81	40-1-81	下轴衬套	1
82	40-1-82	下轴衬套	1
83	40-1-83	下轴衬套	1
84	40-1-84	下轴衬套	1
85	40-1-85	下轴衬套	1
86	40-1-86	下轴衬套	1
87	40-1-87	下轴衬套	1
88	40-1-88	下轴衬套	1
89	40-1-89	下轴衬套	1
90	40-1-90	下轴衬套	1

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序号 Ref. No.	件号 Part No.	名称 Description	数量 Arm. Req.
1	40-7-1	挑线连杆	1
2	40-7-2	挑线连杆螺钉	1
3	40-7-3	挑线杆	1
4	40-7-4	挑线杆紧固螺钉	2
5	40-7-5	挑线杆夹板	1
6	40-7-6	挑线杆夹板螺钉	1
7	40-7-7	挑线杆夹板轴衬套	1
8	40-7-8	挑线杆护罩	1
9	40-7-9	挑线杆护罩螺钉	2
10	40-7-10	挑线杆护罩螺钉	2
11	40-7-11	挑线杆护罩螺钉	1
12	40-7-12	挑线杆护罩螺钉	1
13	40-7-13	挑线杆护罩螺钉	1
14	40-7-14	挑线杆护罩螺钉	1
15	40-7-15	挑线杆护罩螺钉	1
16	40-7-16	挑线杆护罩螺钉	1
17	40-7-17	挑线杆护罩螺钉	1
18	40-7-18	挑线杆护罩螺钉	1
19	40-7-19	挑线杆护罩螺钉	1
20	40-7-20	挑线杆护罩螺钉	1
21	40-7-21	挑线杆护罩螺钉	1
22	40-7-22	挑线杆护罩螺钉	1
23	40-7-23	挑线杆护罩螺钉	1
24	40-7-24	挑线杆护罩螺钉	1
25	40-7-25	挑线杆护罩螺钉	1
26	40-7-26	挑线杆护罩螺钉	1
27	40-7-27	挑线杆护罩螺钉	1
28	40-7-28	挑线杆护罩螺钉	1
29	40-7-29	挑线杆护罩螺钉	1
30	40-7-30	挑线杆护罩螺钉	1
31	40-7-31	挑线杆护罩螺钉	1
32	40-7-32	挑线杆护罩螺钉	1
33	40-7-33	挑线杆护罩螺钉	1
34	40-7-34	挑线杆护罩螺钉	1
35	40-7-35	挑线杆护罩螺钉	1
36	40-7-36	挑线杆护罩螺钉	1
37	40-7-37	挑线杆护罩螺钉	1
38	40-7-38	挑线杆护罩螺钉	1
39	40-7-39	挑线杆护罩螺钉	1
40	40-7-40	挑线杆护罩螺钉	1
41	40-7-41	挑线杆护罩螺钉	1
42	40-7-42	挑线杆护罩螺钉	1
43	40-7-43	挑线杆护罩螺钉	1
44	40-7-44	挑线杆护罩螺钉	1
45	40-7-45	挑线杆护罩螺钉	1

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7. 挑线、松线、夹线分组件 Thread take-up, tension, and tension releasing assembly complete

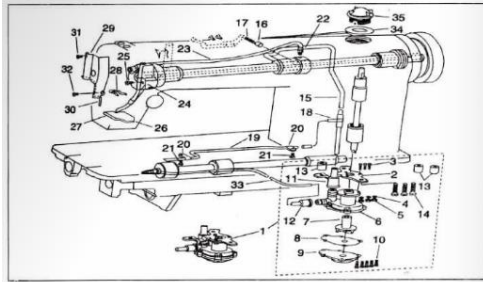


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序号 Ref. No.	件号 Part No.	名称 Description	数量 Arm. Req.
46	40-7-46	挑线板	1
47	40-7-47	挑线板螺钉	1
48	40-7-48	挑线板螺钉	2
49	40-7-49	挑线板螺钉	1
50	40-7-50	挑线板螺钉	1
51	40-7-51	挑线板螺钉	1
52	40-7-52	挑线板螺钉	1
53	40-7-53	挑线板螺钉	1
54	40-7-54	挑线板螺钉	1
55	40-7-55	挑线板螺钉	1
56	40-7-56	挑线板螺钉	1
57	40-7-57	挑线板螺钉	1
58	40-7-58	挑线板螺钉	1
59	40-7-59	挑线板螺钉	1
60	40-7-60	挑线板螺钉	1
61	40-7-61	挑线板螺钉	1
62	40-7-62	挑线板螺钉	1
63	40-7-63	挑线板螺钉	1
64	40-7-64	挑线板螺钉	1
65	40-7-65	挑线板螺钉	1
66	40-7-66	挑线板螺钉	1
67	40-7-67	挑线板螺钉	1
68	40-7-68	挑线板螺钉	1
69	40-7-69	挑线板螺钉	1
70	40-7-70	挑线板螺钉	1
71	40-7-71	挑线板螺钉	1
72	40-7-72	挑线板螺钉	1
73	40-7-73	挑线板螺钉	1
74	40-7-74	挑线板螺钉	1
75	40-7-75	挑线板螺钉	1
76	40-7-76	挑线板螺钉	1
77	40-7-77	挑线板螺钉	1
78	40-7-78	挑线板螺钉	1
79	40-7-79	挑线板螺钉	1
80	40-7-80	挑线板螺钉	1
81	40-7-81	挑线板螺钉	1
82	40-7-82	挑线板螺钉	1
83	40-7-83	挑线板螺钉	1
84	40-7-84	挑线板螺钉	1
85	40-7-85	挑线板螺钉	1
86	40-7-86	挑线板螺钉	1
87	40-7-87	挑线板螺钉	1
88	40-7-88	挑线板螺钉	1
89	40-7-89	挑线板螺钉	1
90	40-7-90	挑线板螺钉	1

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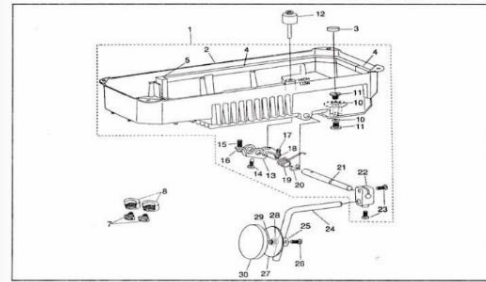
8. 润滑分组件 Lubrication



序号 Ref. No.	件号 Part No	名称 Description	数量 Arm. Req.
1	40-8-1	油泵部件	Lubricating oil pump asm. (1)
2	40-8-2	油泵安装板	Oil pump installing base 1
3	40-8-3	油泵安装螺母	Washer 3
4	40-8-4	油泵安装螺母	Nut 3
5	40-8-5	油泵体	Lubricating oil 1
6	40-8-6	油泵叶轮	Oil pump impeller 1
7	40-8-7	油泵叶轮托板	Oil pump impeller cover 1
8	40-8-8	油泵盖	Lubricating oil pump cover 1
9	40-8-9	油泵盖螺钉	Screw 5
10	40-8-10	上轴供油管接头	Rubber joint 1
11	40-8-11	下轴供油管接头	Rubber joint 1
12	40-8-12	油泵垫圈	Gasket 3
13	40-8-13	油泵螺钉	Screw 3
14	40-8-14	上轴供油管	Main shaft oil tube 1
15	40-8-15	回油泵柱塞	Oil return pump plunger 1
16	40-8-16	柱塞弹簧	Plunger spring 1
17	40-8-17	齿轮供油管橡皮接头	Oil sight window base 1
18	40-8-18	齿轮供油管	Gear oil pipe 1
19	40-8-19	齿轮供油管夹	Holder 2
20	40-8-20	齿轮供油管夹螺钉	Screw 2
21	40-8-21	回油管	Oil return tube asm. 1
22	40-8-22	回油管夹	Oil return tube holder 1
23	40-8-23	回油管夹螺钉	Screw 1
24	40-8-24	回油罩	Oil felt 1
25	40-8-25	回油罩垫圈	Oil felt 1
26	40-8-26	回油罩垫圈	Oil felt 1
27	40-8-27	回油罩垫圈	Oil felt 1
28	40-8-28	回油罩垫圈	Oil felt 1
29	40-8-29	回油罩垫圈	Oil felt 1
30	40-8-30	回油罩垫圈	Oil felt 1
31	40-8-31	回油罩垫圈	Oil felt 1
32	40-8-32	回油罩垫圈	Oil felt 1
33	40-8-33	回油罩垫圈	Oil felt 1
34	40-8-34	回油罩垫圈	Oil felt 1
35	40-8-35	回油罩垫圈	Oil felt 1

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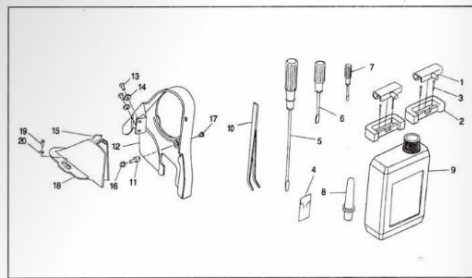
9. 油盘、膝抬压脚分组件 Oil reservoir & knee lifter components



序号 Ref. No.	件号 Part No	名称 Description	数量 Arm. Req.
1	40-9-1	油盘部件	Oil reservoir asm. (1)
2	40-9-2	油盘	Oil reservoir 1
3	40-9-3	油盘磁块	Oil reservoir magnet 1
4	40-9-4	油盘垫圈	Gasket 1
5	40-9-5	油盘垫圈	Gasket 1
6	40-9-6	油盘垫圈	Oil reservoir felt cushion 2
7	40-9-7	油盘支座	Oil reservoir rubber cushion 2
8	40-9-8	排油螺钉O形圈	Oil drain cap gasket 2
9	40-9-9	排油螺钉	Oil drain screw 2
10	40-9-10	抬压脚顶销	Knee press lifter rod 1
11	40-9-11	抬压脚双向曲柄	Lifting 1
12	40-9-12	双向曲柄螺钉	Positioning screw 1
13	40-9-13	双向曲柄定位螺钉	Positioning screw 1
14	40-9-14	双向曲柄定位螺母	Nut 1
15	40-9-15	双向曲柄定位螺钉	Positioning screw 1
16	40-9-16	双向曲柄定位螺母	Nut 1
17	40-9-17	抬压脚轴	Thrust ring 1
18	40-9-18	抬压脚轴开口挡圈	Thrust ring 1
19	40-9-19	抬压脚轴	Knee press rod 1
20	40-9-20	抬压脚轴螺母	Bearing bracket 1
21	40-9-21	抬压脚轴螺母	Clamp screw 2
22	40-9-22	抬压脚轴螺母	Knee lifter plate rod 1
23	40-9-23	抬压脚轴螺母	Knee press plate cover joint 1
24	40-9-24	抬压脚轴螺母	Knee press plate 1
25	40-9-25	抬压脚轴螺母	Knee press plate spring 1
26	40-9-26	抬压脚轴螺母	Knee press plate 1
27	40-9-27	抬压脚轴螺母	Knee press plate cover 1
28	40-9-28	抬压脚轴螺母	Knee press plate cover 1

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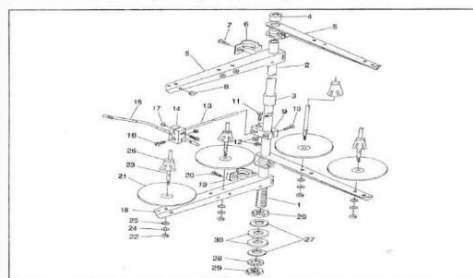
10. 机头附件 Machine head accessories



序号 Ref. No.	件号 Part No	名称 Description	数量 Arm. Req.
1	40-10-1	机头连接板	Machine hinge plate asm. 2
2	40-10-2	机头连接板	Machine hinge plate 4
3	40-10-3	机头连接板	Nail 1包
4	40-10-4	机头连接板	Needle 1
5	40-10-5	螺丝刀(大)	Screw driver (L) 1
6	40-10-6	螺丝刀(中)	Screw driver (M) 1
7	40-10-7	螺丝刀(小)	Screw driver (S) 1
8	40-10-8	机头支柱	Machine rest pin 1
9	40-10-9	油桶部件	Lubricating unit case asm. 1
10	40-10-10	油桶	Tweezer 1
11	40-10-11	罩壳支柱	Bel cover support stud 1
12	40-10-12	上轮罩壳	Bel-cover A 1
13	40-10-13	罩壳螺钉	Screw 2
14	40-10-14	罩壳螺钉垫圈	Washer 2
15	40-10-15	罩壳螺钉	Bel-cover b cover asm. 1
16	40-10-16	罩壳支柱螺母	Nut 1
17	40-10-17	罩壳支柱螺母	Screw 1
18	40-10-18	上轮罩壳	Bel-cover B 1
19	40-10-19	传动带罩壳水螺钉	Driving belt cover wood screw 2
20	40-10-20	罩壳水螺钉垫圈	Wood screw washer 2

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11. 四线团架分组件 Quadruple-thread spool stand asm.

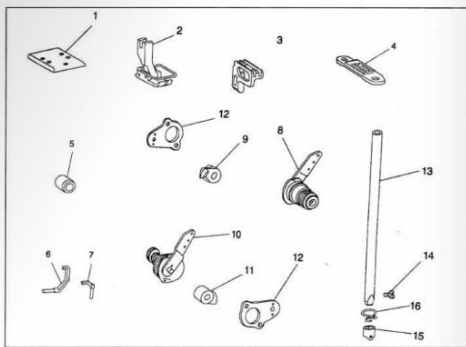


序号 Ref. No.	件号 Part No	名称 Description	数量 Arm. Req.
1	40-11-1	线架杆下节	Spool rest rod (upper) 1
2	40-11-2	线架杆上节	Spool rest rod (lower) 1
3	40-11-3	线架杆接头	Spool rested joint 1
4	40-11-4	线架杆橡胶护套	Spool rest rod rubber cap 1
5	40-11-5	线架杆过线杆	Thread guide asm. 2*
6	40-11-6	线架杆过线杆	Thread guide asm joint 2*
7	40-11-7	线架杆过线杆	Screw 2*
8	40-11-8	导线圈	Thread guide ring 6**
9	40-11-9	线架杆过线杆	Thread guide arm holder 1
10	40-11-10	线架杆过线杆	Screw 1
11	40-11-11	线架杆过线杆	Screw 1
12	40-11-12	线架杆过线杆	Nut 1
13	40-11-13	线架杆过线杆	Thread guide arm 1
14	40-11-14	线架杆过线杆	Thread guide arm holder 1
15	40-11-15	线架杆过线杆	Lower thread guide 1
16	40-11-16	线架杆过线杆	Screw 2
17	40-11-17	线架杆过线杆	Nut 2
18	40-11-18	线架杆过线杆	Spool rest arm 2*
19	40-11-19	线架杆过线杆	Thread guide arm joint 2*
20	40-11-20	线架杆过线杆	Screw 2*
21	40-11-21	线架杆过线杆	Spool rest 2*
22	40-11-22	线架杆过线杆	Nut 2*
23	40-11-23	线架杆过线杆	Spool pin 2***
24	40-11-24	线架杆过线杆	Spring washer 2***
25	40-11-25	线架杆过线杆	Washer 2***
26	40-11-26	线架杆过线杆	Speed cushion 4
27	40-11-27	线架杆过线杆	Washer 2
28	40-11-28	线架杆过线杆	Spring washer 1
29	40-11-29	线架杆过线杆	Nut 2
30	40-11-30	线架杆过线杆	Rubber washer 2

注：* 单行线架杆；** 双行线架杆；*** 三行线架杆；**** 四行线架杆

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12. 单针链缝机与双针相对应更换之零件
Model one-needle high speed chainstitcher



序号 Ref. No.	件号 Part No.	名称 Description	数量 Arm. Req.
1	40-12-1	附件安装板	1
2	40-12-2	压脚部件	1
3	40-12-3	送料牙	1
4	40-12-4	针板	1
5	40-12-5	弯针曲柄挡圈	1
6	40-12-6	驱动护针杆	1
7	40-12-7	固定护针杆	1
8	40-12-8	面线夹线器部件	1
9	40-12-9	面线松线爪	1
10	40-12-10	底线夹线器部件	1
11	40-12-11	底线松线爪	1
12	40-12-12	夹线器安装板	2
13	40-12-13	针杆	1
14	40-12-14	支杆螺钉	1
15	40-12-15	针杆线钩	1
16	40-12-16	针杆下衬套线钩	1

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双针双列与双针单列对应零件变化表 List of parts change

双针双列 Two-needle double-row chain stitch:

名称 Name	针板 Throat plate	针类 Needles clamp	压脚 Presser foot asm.	送料牙 Feed dog	驱动护针杆 Rear moving needle guard asm.	右固定护针杆 Right fix needle guard	左固定护针杆 Left needle guard
规格 Specifications							
*1 1/8"(3.2mm)	40-4-68	40-2-38	40-3-36	40-4-76			
2 5/32"(4.0mm)	40-4-69	40-2-39	40-3-37	40-4-77	40-6-71		
3 3/16"(4.8mm)	40-4-70	40-2-40	40-3-38				
4 7/32"(5.6mm)	40-4-71	40-2-41	40-3-39	40-4-39	40-6-70		40-6-74
5 1/4"(6.4mm)	40-4-72	40-2-42	40-3-40	40-4-78			
6 5/16"(7.9mm)	40-4-73	40-2-43	40-3-41	40-4-79	40-6-72		
7 3/8"(9.5mm)	40-4-74	40-2-44	40-3-42	40-4-80	40-6-73		
8 1/2"(12.7mm)							
双针单列 Two-needle double-line chain stitch:							
9 0	40-4-75	40-2-45	40-3-43	40-4-81	40-6-74		40-6-77

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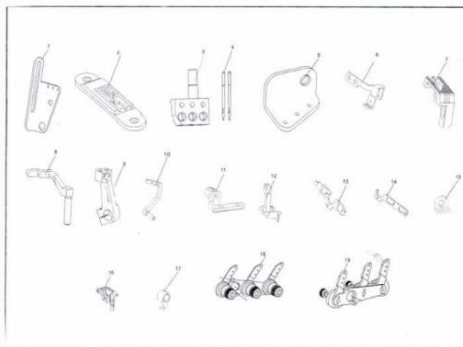
双针双列、双针单列附件一览表 List throat of & its accessories

双针双列 Two-needle double-row chain stitch

名称 Name	右弯针 Right looper	左弯针 Left looper	推板 Bed slide	凸轮盖 Cam cover	卷边器 Folder
规格 Specifications					
*1 1/8"(3.2mm)					40-1-47
2 5/32"(4.0mm)					40-1-48
3 3/16"(4.8mm)				40-1-18	40-1-49
4 7/32"(5.6mm)			40-1-25		40-1-50
5 1/4"(6.4mm)					40-1-44
6 5/16"(7.9mm)					40-1-51
7 3/8"(9.5mm)				40-1-40	40-1-52
8 1/2"(12.7mm)			40-1-47	40-1-50	
双针单列 Two-needle double-line chain stitch					
9 0	40-6-78	40-6-79	40-1-48	40-1-51	

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15. 三针链缝机与双针机相对应更换之零件
Model three-needle high speed chainstitcher



序号 Ref. No.	件号 Part No.	名称 Description	数量 Arm. Req.
1	48-1-1	中间导线钩	1
2	48-1-2	针板	1
3	48-2-1	针类	1
4	48-2-2	针板 18#	1
5	48-2-3	针板过线架	1
6	48-2-4-1	挑线杆	1
7	45-3-1-1	送料牙	1
8	48-4-1	驱动护针杆 1/4	1
9	48-4-2	左弯针曲柄	1
10	48-4-3	固定护针杆	1
11	48-4-4	护针杆套	1
12	48-6-1	压脚部件	1
13	48-7-2	面线松线板	1
14	48-7-3	面线松线板	1
15	48-7-4	面线夹线器部件	1
16	48-7-5	凸轮导线钩部件	1
17	48-7-6	松线曲柄部件	1
18	48-7-7	面线夹线器部件	1
19	48-7-8	面线夹线器部件	1

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