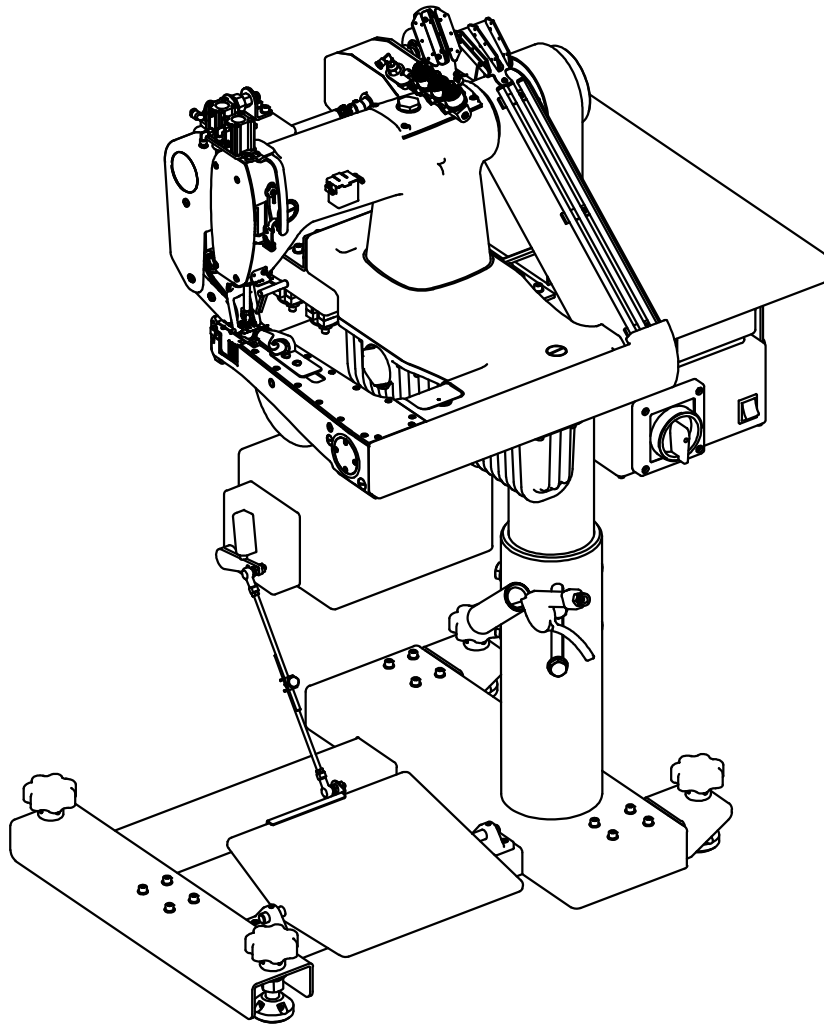


超高速智能曲腕机

Super High Speed Intelligent Wrist Bending Machine



使用说明和零件手册

INSTRUCTION MANUAL AND PARTS LIST

使用说明 INSTRUCTION MANUAL

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INSTRUCTION MANUEL

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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.



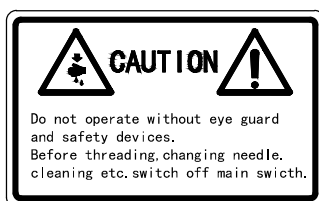
- (2) 、地线标识：确保地线接地良好，以避免由于环境或其它因素产生的静电影响人身安全。

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.



- (4) 、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 talbe 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.

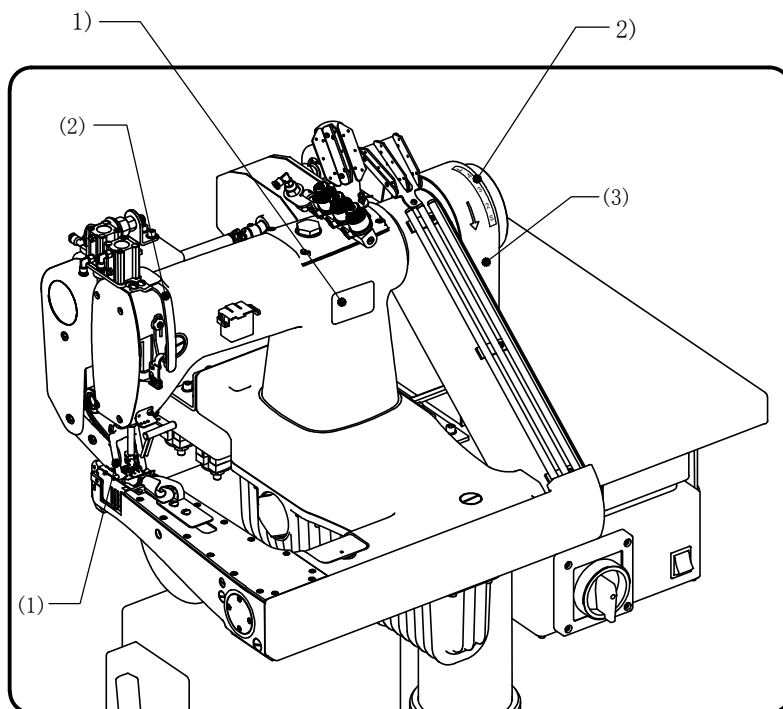
1) 、警告标识

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) 护指装置

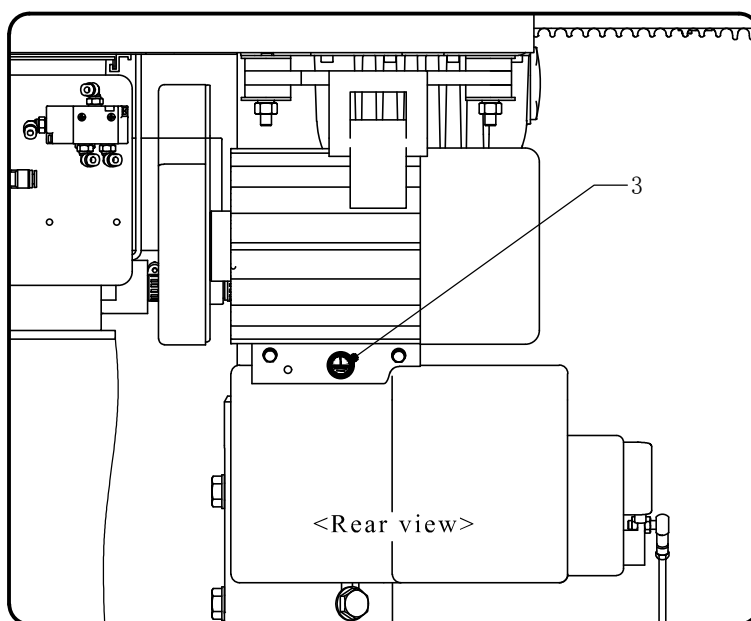
Finger guard

(2) 挑线防护装置

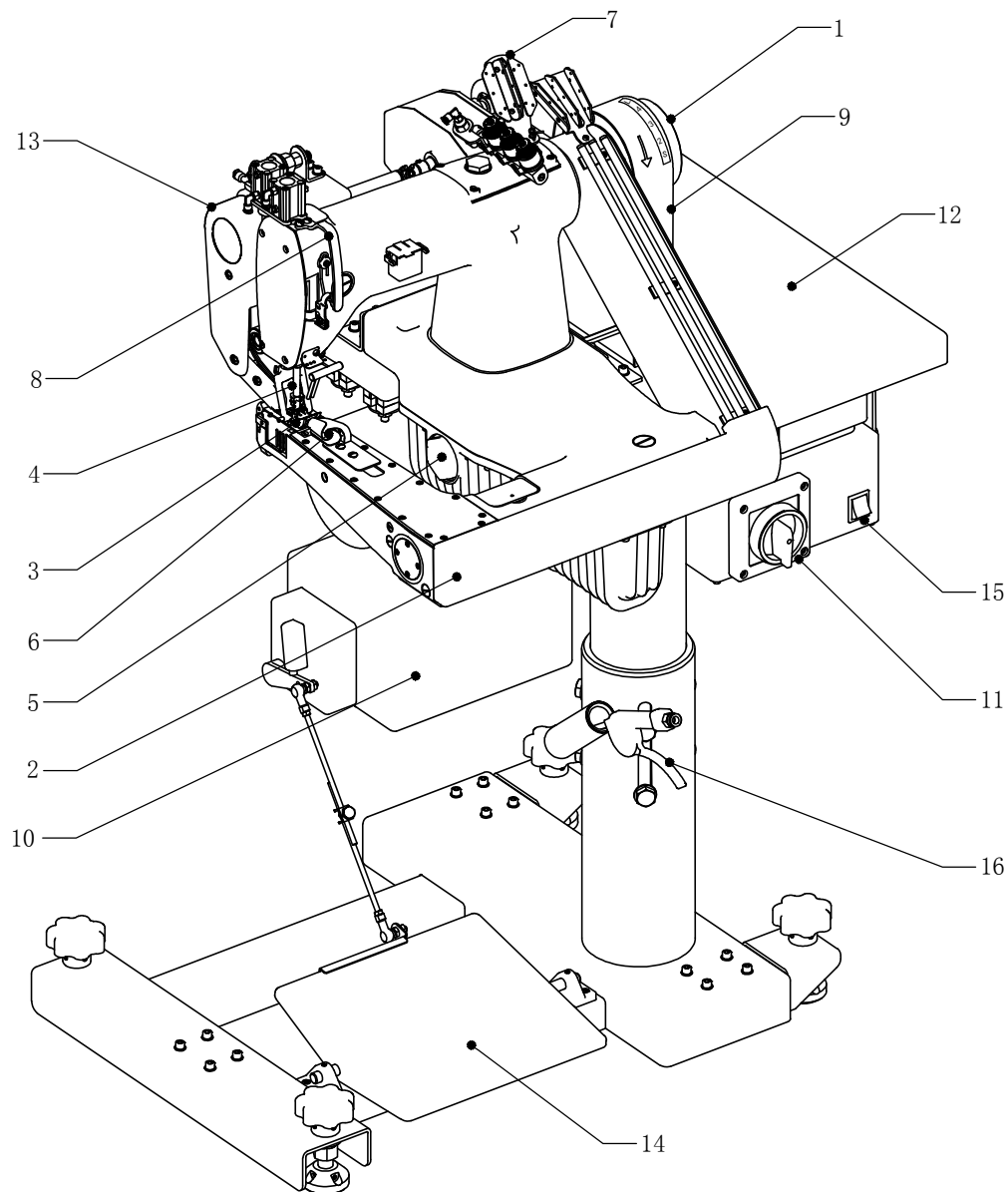
Thread take-up cover

(3) 皮带护罩

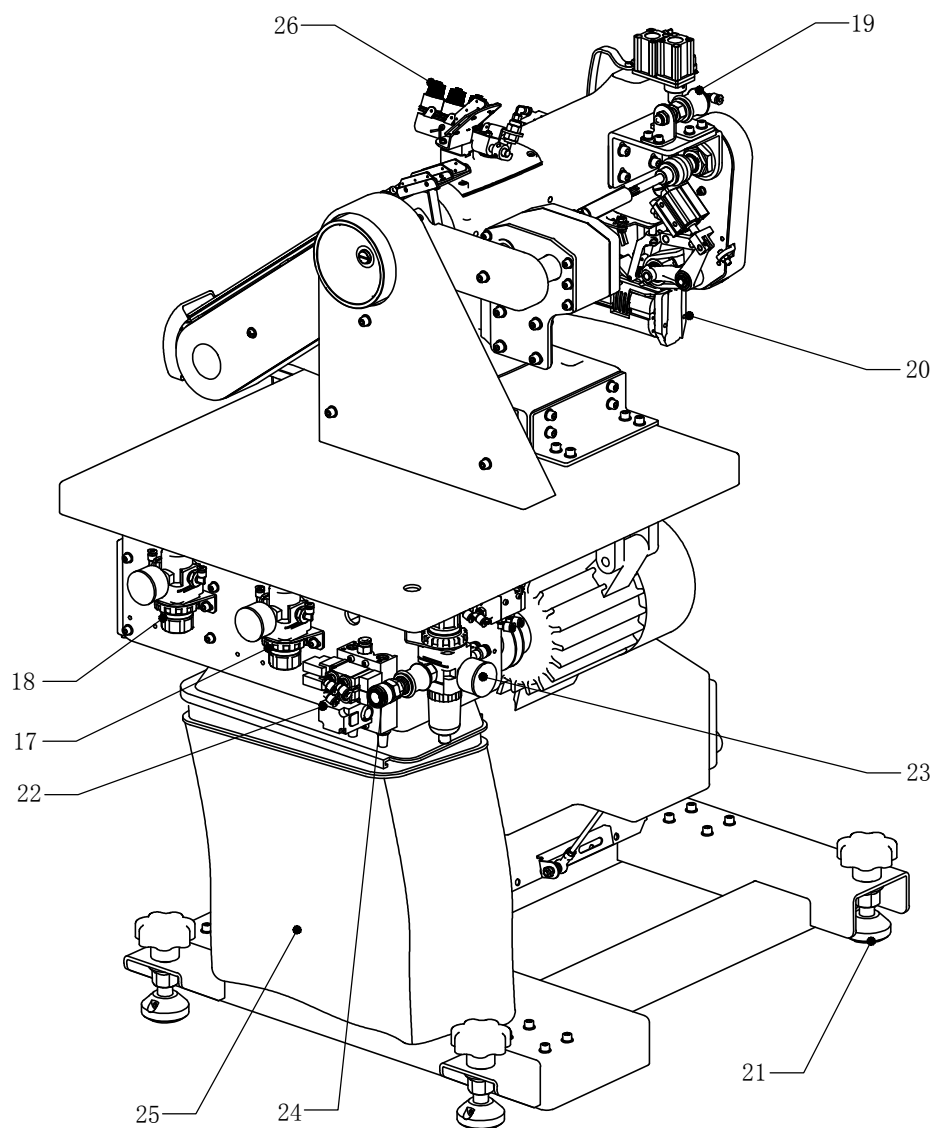
Pulley cover, etc



2 、 零 部 件 名 称 Names of major parts



- | | | | |
|--------------------------|---------------------------------|--------------------------|------------------------------|
| 1. 皮带轮
Machine pulley | 5. 油窗
Oil window | 9. 滑轮盖
Pulley cover | 13. 辅助拖轮
Assistance round |
| 2. 前盖
Front cover | 6. 卷边筒
Lapper | 10. 伺服马达
Motor | 14. 踏板
Pedal |
| 3. 压脚
Presser | 7. 引线装置
Thread take-up cover | 11. 电源开关
Switching | 15. 工作灯开关
Light switch |
| 4. 针杆
Needle bar | 8. 护手装置
Finger guard | 12. 钢结构台板
Steel table | 16. 气枪
Blow air gun |



17. 拖轮压力表
Press a Assistance round
manometer
18. 压脚压力表
Press a feet manometer
19. 拖轮控制阀
Assistance round control
20. 自动剪刀
Auto scissors

21. 脚座
Feet
22. 电磁阀
Electromagnetism valve
23. 过滤器
Filter
24. 总进气接口
Enter spirit

25. 储屑袋
Keep scraps bag
26. 线松紧器
Upper thread nipper

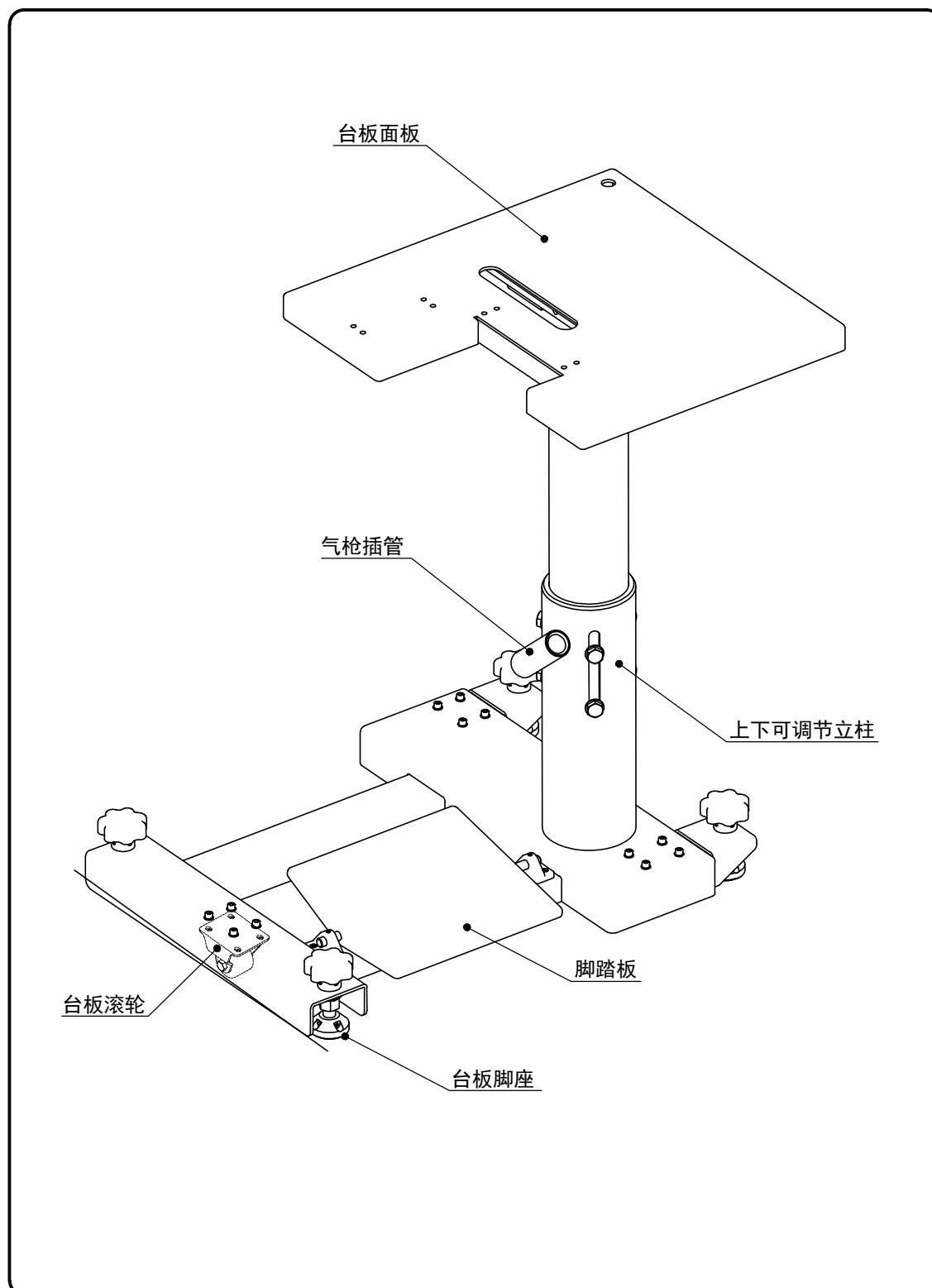
3 、机器规格 Machine Specifications

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)	4800	4800	4500	4500
最大线迹长度 (m m) Max.stitch length (mm)	3. 8	3. 8	4. 8	4. 8
压脚膝提高度 (m m) 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	下挂电机600W/750W 或 550W/750W(伺服) 直驱电机 Bottom hang Motor 600W/750W OR 550W /750W(Servo) Direct Drive Motor			

正常转速：双针 4300针/分 三针 4000针/分
Normal sewing speed (spm) : Two Needles 4300 Three Needles 4000

4 、台板与电机 Work table and motor

1) 、台 板 Work table



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
(伺服) 下挂电机 600W (Servo) Bottom hang Motor 600W
(伺服) 下挂节能电机 750W (Servo) Bottom hang economy energy Motor 750W
(伺服) 直驱电机 550W/750W (Servo) Direct Drive Motor 550W/750W

(3) 电机动力与V 型带

Motor pulley and V-belt

动力0 . DPulley O.D	85	90	95	100	105	110	115	120	125	130
皮带的尺寸 (英寸) Belt size (inches)		M 4 4			M 4 5				M 4 6	

(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) 用螺钉、垫片,把减震垫、侧固定角支架、后固定角支架与台板相联接。
Use sets of bolt ,Reduce earthquake mat, side fix Cape support, empress fix Cape support and bedplate 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) 用螺钉、垫片,把侧固定角支架、后固定角支架与机器相联接。
Use sets of bolt ,Side fix Cape support, empress fix Cape support and machine mutually allied connect
- (4) 按图示将机器固定在台板上。
Press the diagram to show machine fix on the bedplate.
- (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.



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.



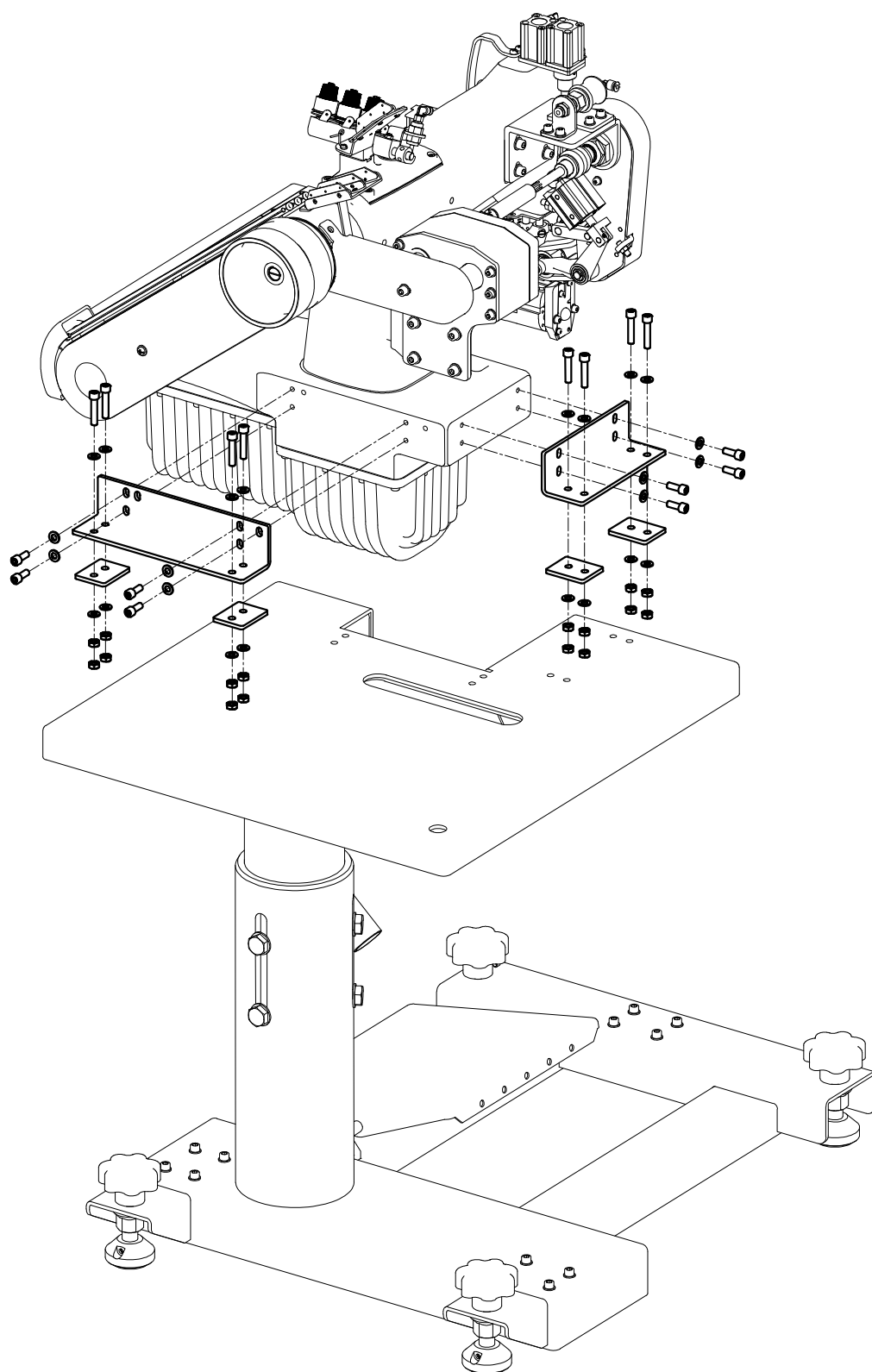
确保地线的正确、有效连接,以避免可能引发的电击事故。

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。

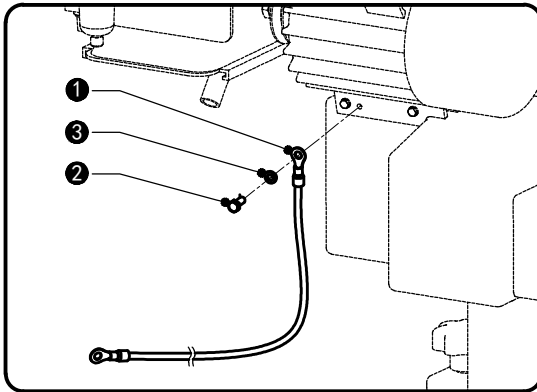
Install the pulley cover to the machine head.



机器台板按装示意图
Machine bedplate press to pack sketch map

2) 、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

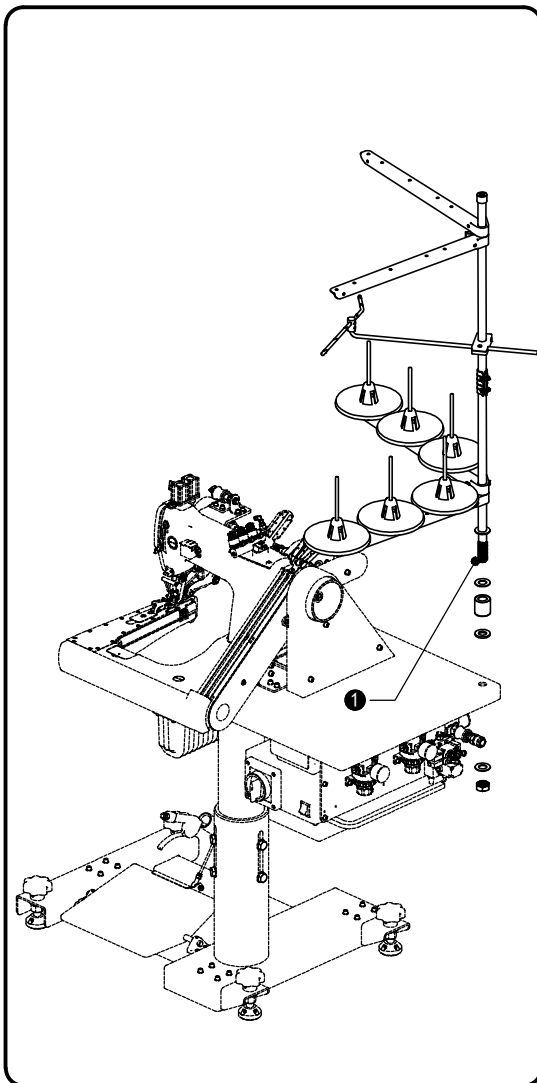
② .

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.

3) 、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.

4) 、机器的润滑 Lubrication

注 意 / CAUTION

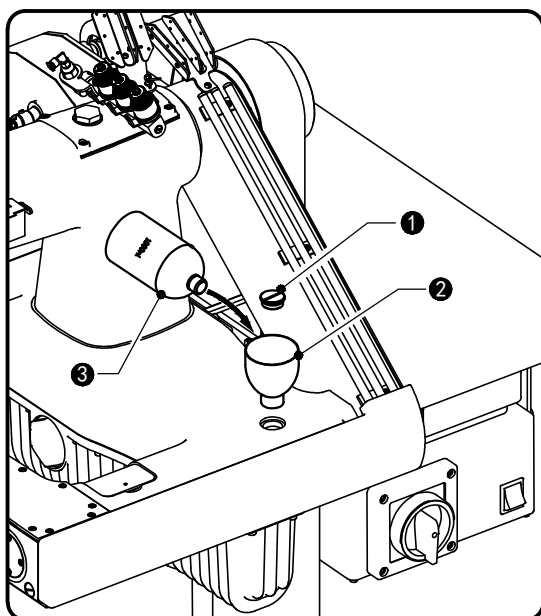
 加油时，务必带上护目镜和手套，以免油不慎掉入眼睛或是沾到皮肤，而造成伤害。
Be sure to wear protective goggles and gloves when handing the lubricating oil gets into your eyes or onto your skin, otherwise inflammation can result.

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) 旋开加油螺钉 ①

Screw on to encourage bolt ①.

(2) 将加油漏斗 ② 放置在机器加油孔上。

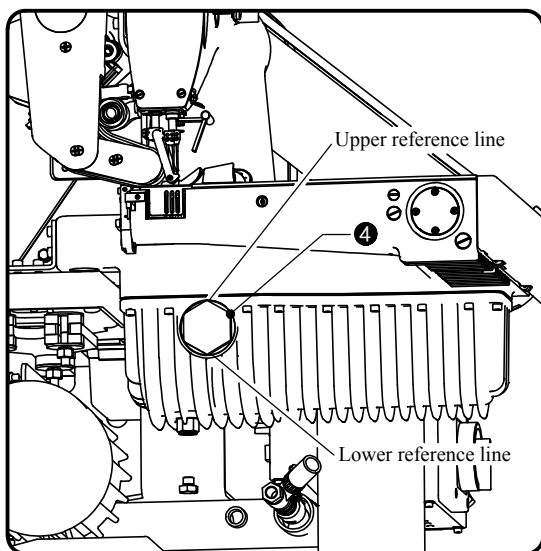
Will encourage funnel ② to place to encourage bore top in the machine.

(3) 通过加油漏斗 ② 往机器里加注润滑油 ③

Pass to encourage funnel ② to go toward to add to note lubricant ③ in machine.

(4) 加注润滑油 ③ 直至油量达到油窗 ④ 指示的位置。

Add to note lubricant ③ until the amount of oil attain an oil window ④ the position of the designation.



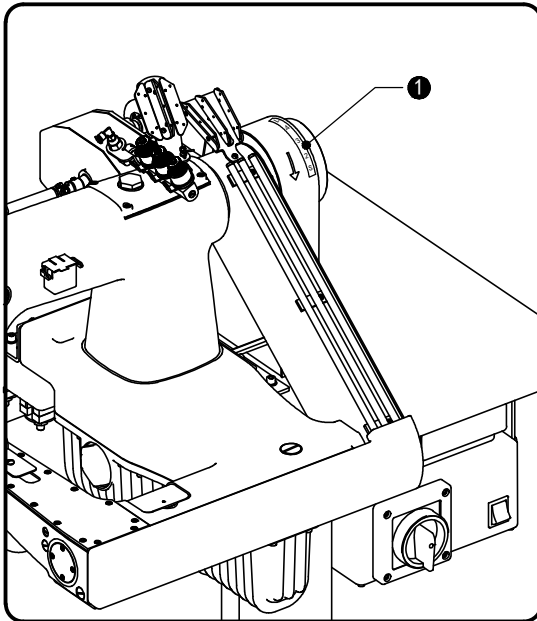
5) 、检测皮带轮转动的方向

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
1 4 #	纱线#50	纱线#60
1 8 #	纱线#30	纱线#50
2 1 #	纱线#20	纱线#30

2) 、针的安装
Installing the Needles

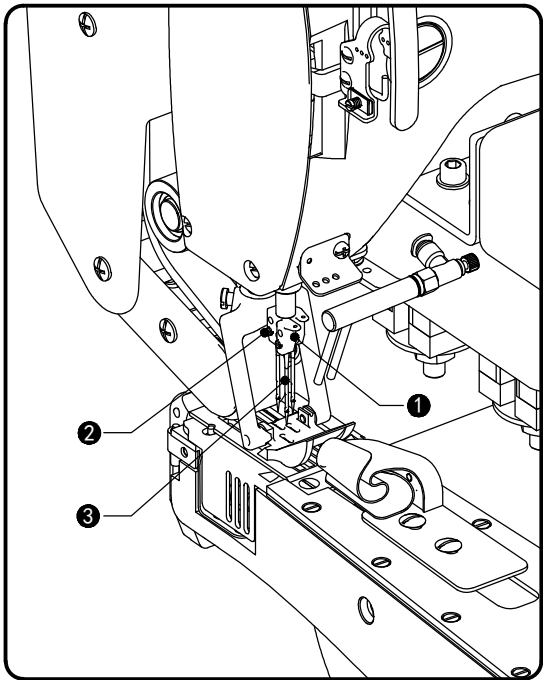


注 意 / CAUTION



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

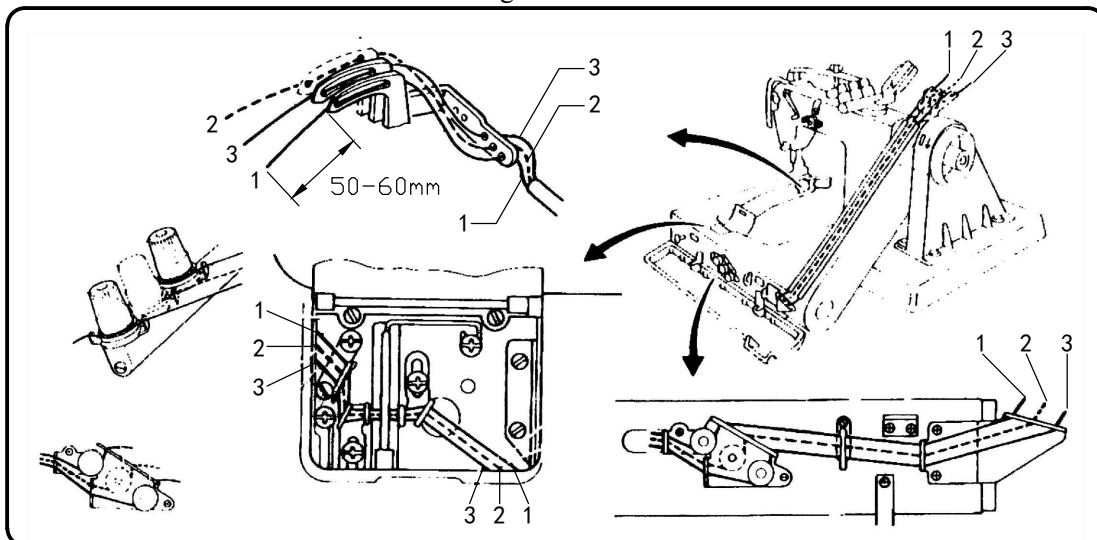


穿线时，先关闭电源，以免机器可能在不慎情况下开启，造成伤害。

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

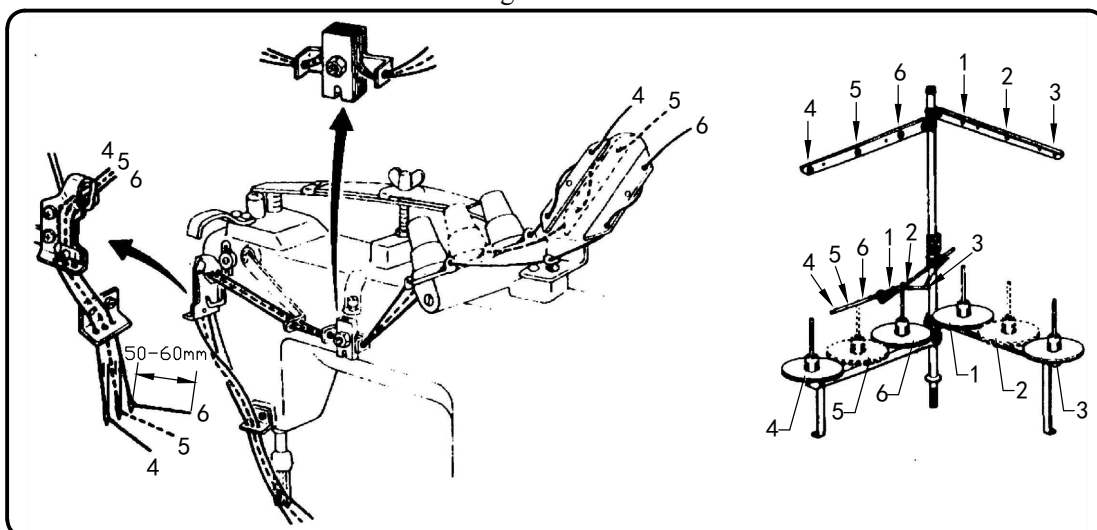


穿线时，先关闭电源，以免机器可能在不慎情况下开启，造成伤害。

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.

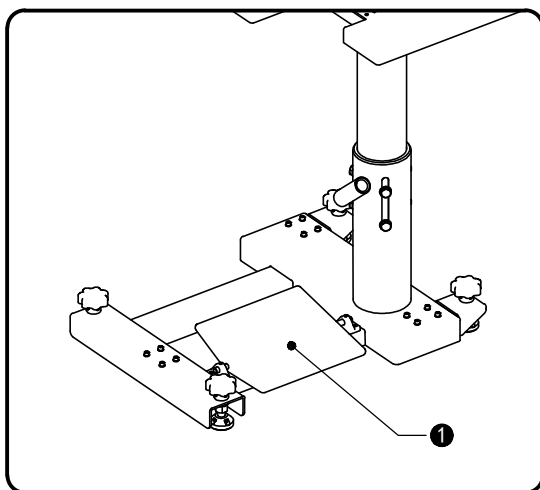
换针时.

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) 后踏抬压脚踏板 ① 抬起压脚，把缝制件放在压脚下，松开抬压脚踏板。

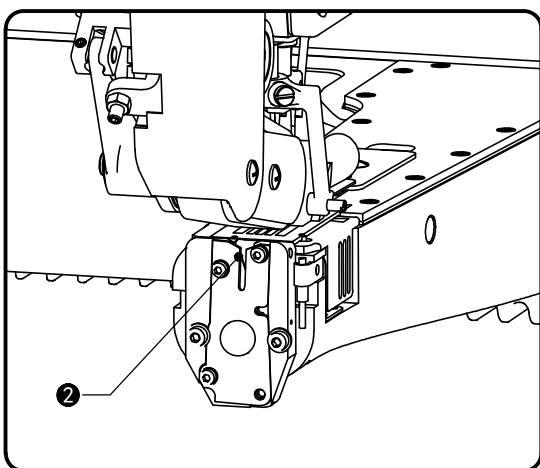
Switch the power on, step down on presser for lifter pedal ①, place a fabric under presser foot, and release presser foot lifter pedal ①.

(2) 前踏电机踏板 ①，机器开始运行。

Depress treadle ① 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 ②, and then cut the threads with thread cutter ②.

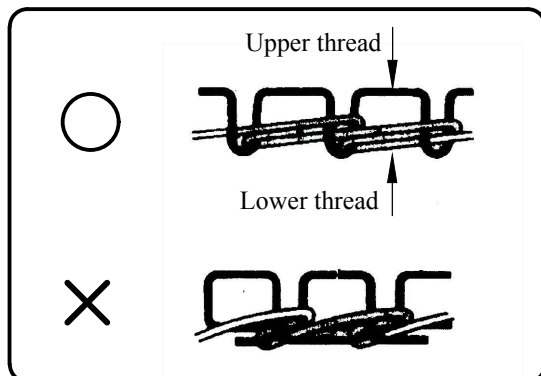


8、缝制的调节

Thread Tension

1)、调节线的松紧

Adjusting the thread tension

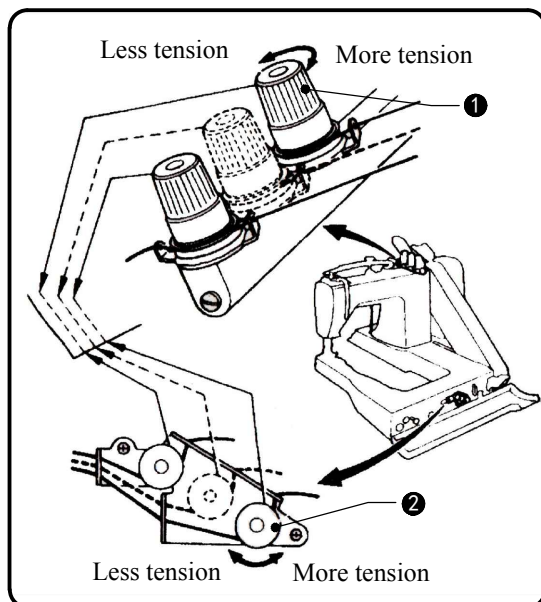


正确的缝迹/Good stitches

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

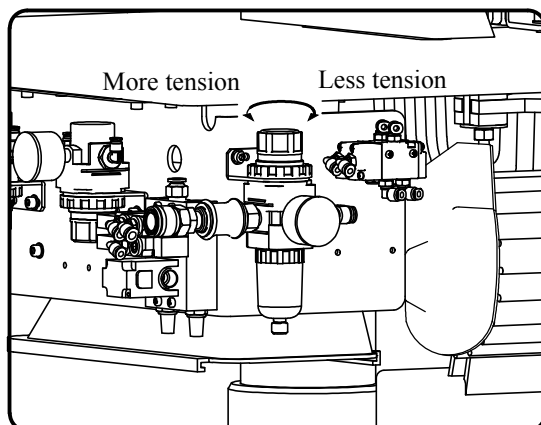


(1) 旋转上夹线器组件螺母，调节上线松紧。
Adjust the upper thread tension properly by turning upper thread adjusting screw ①.

(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)、总进气压力调节

Total enter air pressure the dint regulate

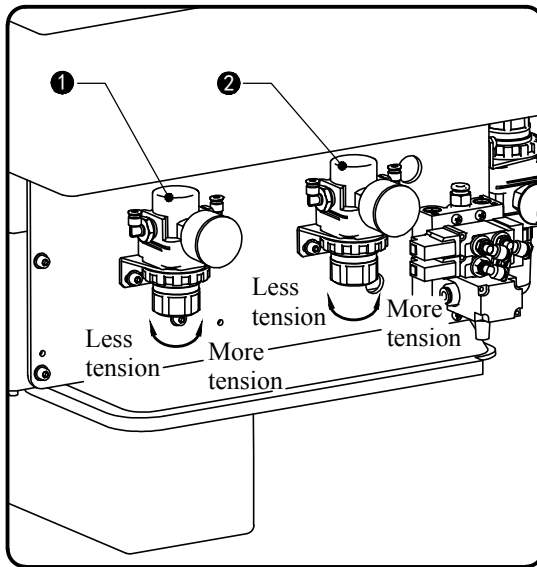


(1) 通过旋转调节旋钮 ①，调整总进气压力，使压力满足合理的缝制作业要求。

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

3) 、压脚和拖轮压力调节

Presser Foot and Drag along a round Pressure Adjustment



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

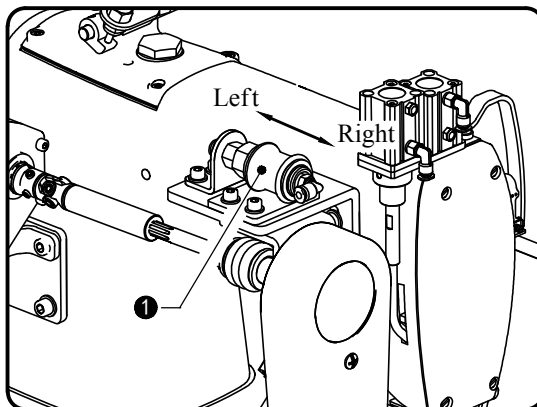
Adjust the presser foot pressure by turning wing nut ① to such a level that it is just enough to keep the work from slipping .

(2) 若机器配有辅助拖轮，拖轮的压力可以通过调节旋钮 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 .

4) 、压脚和拖轮抬起切换

Press feet and drag along a round to lift to cut over

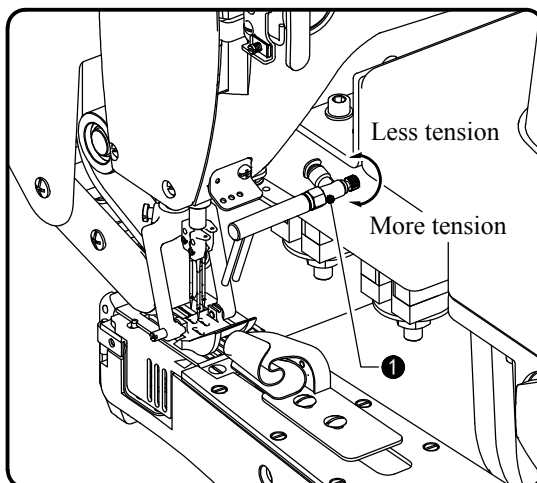


(1) 通过左右滑动手滑阀 ①，向右滑，后踏脚踏板压脚抬起，向左滑，后踏脚踏板压脚和拖轮同时抬起。

Pass an or so glide hand slide valve ① , To left slippery, The empress step pedal to press feet to lift, Rightwards slippery, The empress step pedal to press feet and drag along a round to lift in the meantime.

5) 、机针冷却流量调节

The machine needle cool off discharge to regulate



(1) 通过调节气嘴接头 ①，调整机针冷却气嘴的吹气量。

Pass to regulate a spirit mouth to deal with contact ① , Adjust the machine needle cool off spirit blow of mouth tolerance.

6) 、调节缝迹的长度
Stitch Length Adjustment

 注 意 / CAUTION

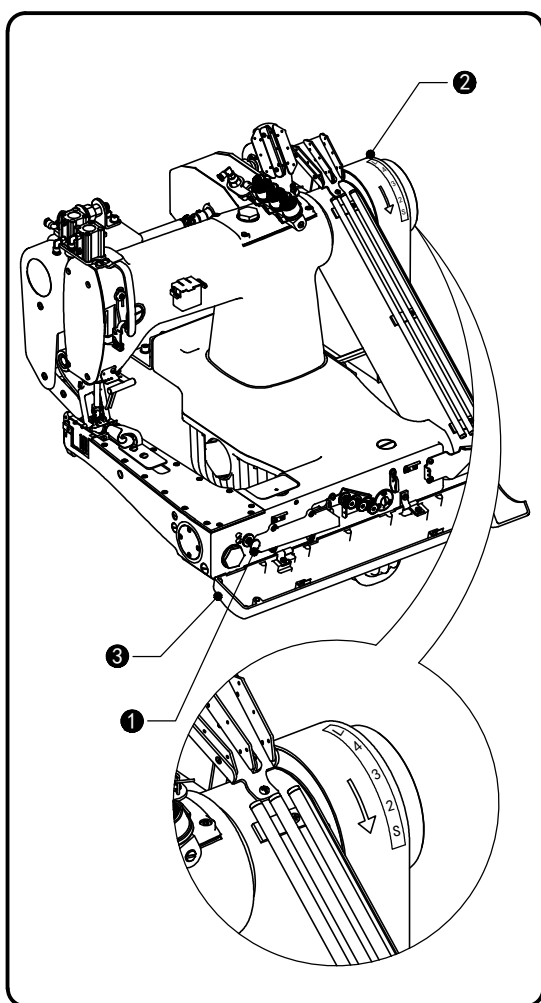


调节缝迹长度时，先关闭电源，以免机器可能在不慎情况下开启，造成伤害。

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.

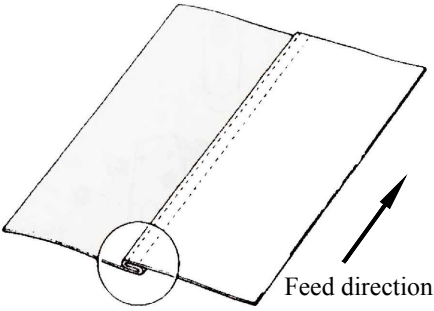
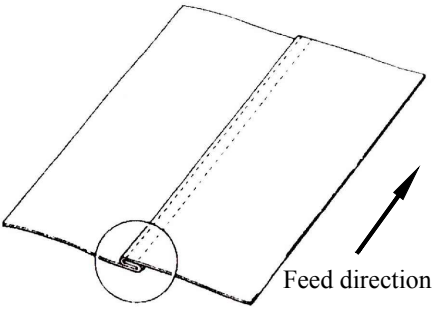
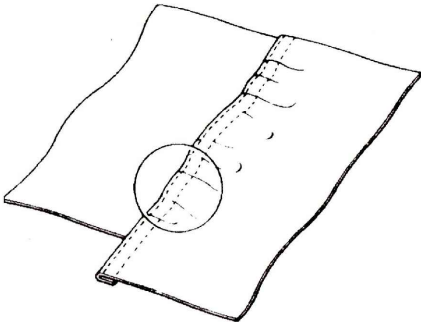
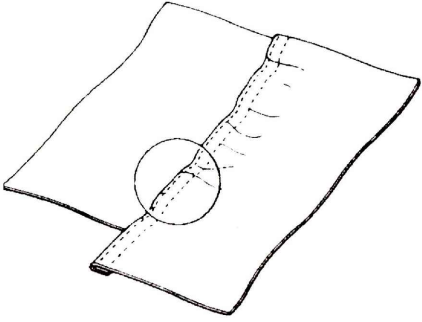
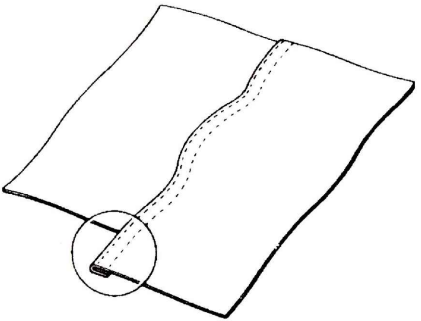
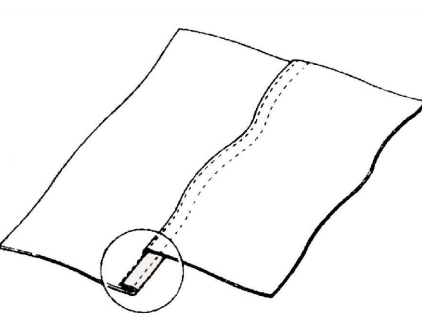
当把数字调到最大时，必须调节挡针块，使其与机针保持规定的间距。

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，电机会继续转动，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.



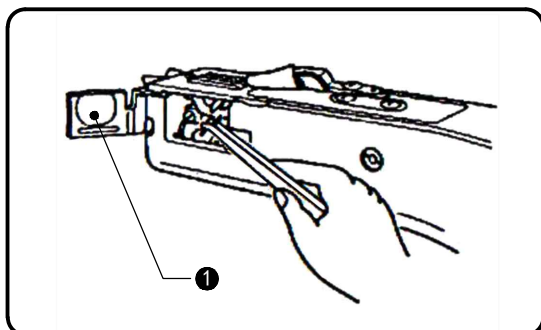
确保在处理润滑油的时候带上防目镜和手套，以防止油进入眼睛和皮肤而出现症状. 在任何情况下不能饮用此类润滑油，以免导致呕吐和腹泻. 谨记此类润滑油要放在儿童够不着的地方。

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 cheaning



(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

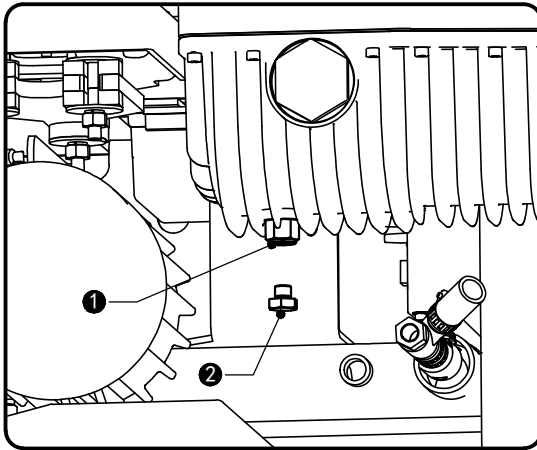
检查线是否已正确穿引。

h0ck that the threads are threaded correctly.

如果针尖已损坏，请更换机针。

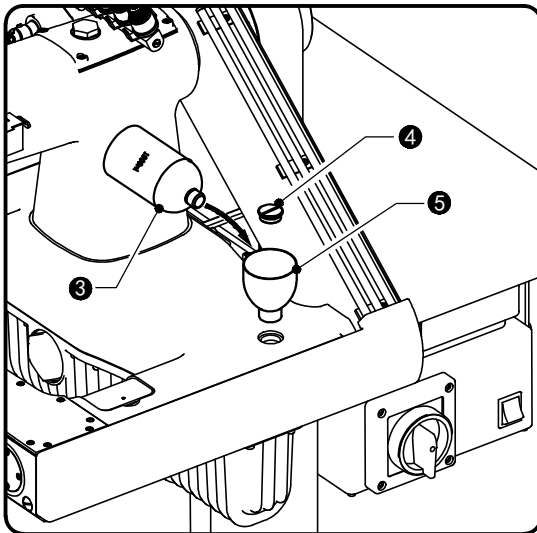
If the tips of the needles are broken the broken needles.

2) 、 润滑油更换 The lubricant replace

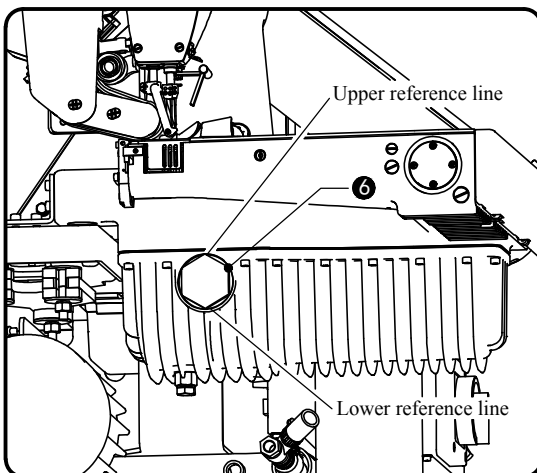


* 润滑油至少每六个月更换一次。
The lubricating oil should be changed at least once every six months.

- (1) 将接油盒放置在放油嘴 ① 下面。
Will connect an oil box to place is put glib-tongued ① an underneath.
- (2) 旋开放油螺钉 ②，将机器里的污油排出。
Screw on to put oil bolt ②, eject the dirty oil in the machine.
- (3) 放完油后旋上放油螺钉 ②。
Finish put empress the oil Xuan top to put oil bolt ②.



- (4) 旋开加油螺钉 ④。
Screw on to encourage bolt ④.
- (5) 将加油漏斗 ⑤ 放置在机器加油孔上。
Will encourage funnel ⑤ to place to encourage bore top in the machine.
- (6) 通过加油漏斗 ⑤ 往机器里加注润滑油 ③。
Pass to encourage funnel ⑤ to go toward to add to note lubricant ③ in machine.



- (7) 加注润滑油 ③ 直至油量达到油窗 ⑥ 指示的位置。
Add to note lubricant ③ until the amount of oil attain an oil window ⑥ the position of the designation.

10、调节标准

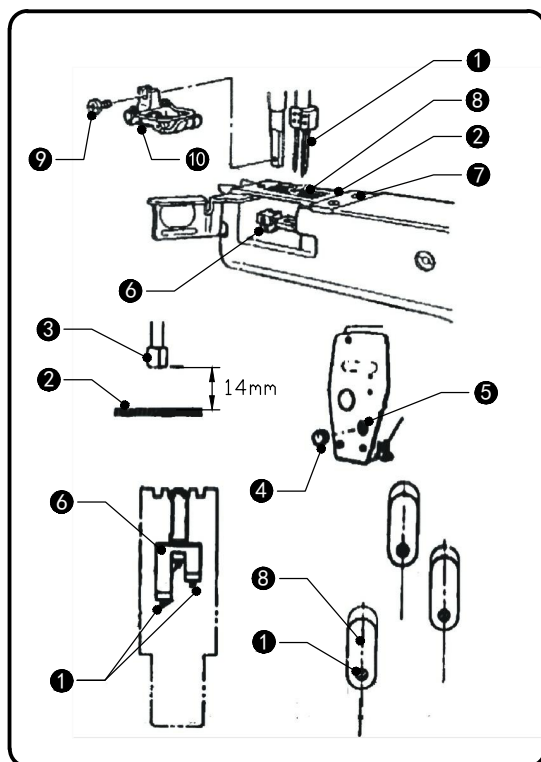
Standard adjustments

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 needle①is in the center of the needle hole⑧in the needle plate②.

- (1) 拧开螺钉⑨, 松开压脚⑩.

Remove the screw ⑨,and then remove the presser foot⑩.

- (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14mm.

Remove the rubber plug④,loosen the needle bar clamp screw⑤and adjust so that the distance between the bottom of the needle clamp③and the top of the needle plate②is 14mm.

* 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13mm.

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 13mm, when the needle clamp is raised to its highest position.

- (4) 拧开螺钉⑦, 取下针板②.

Remove the three screws⑦,and then remove the needle plate②.

- (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 needles①and the needle guard⑥are aligned,and then adjust the tilt of the needle clamp③so that there is no space between the left and right needles①and the needles①and the needle guard⑥at 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 .

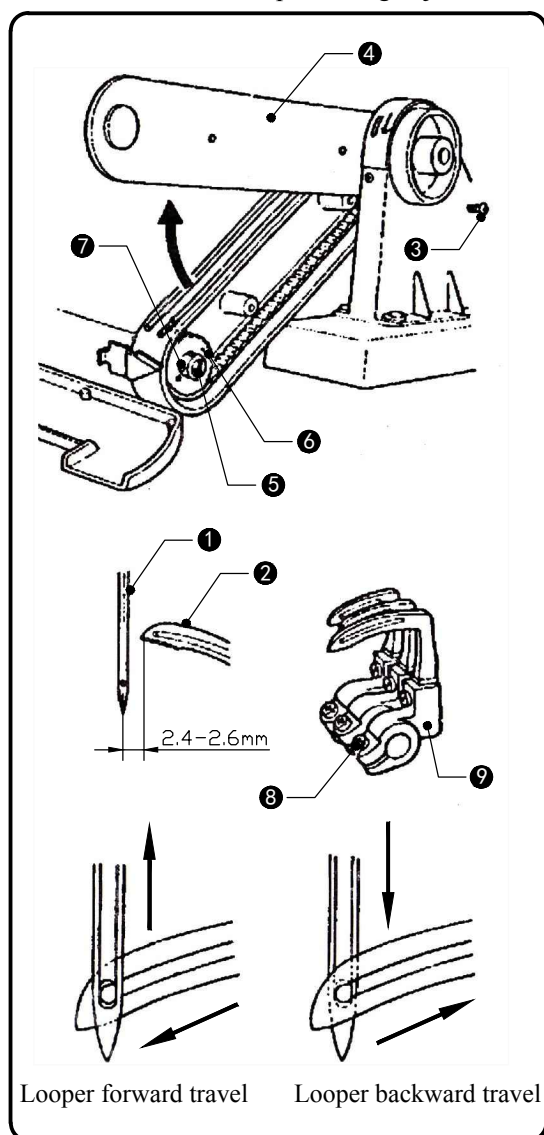
- (6) 塞上橡胶塞④.

Insert the rubber plug④.

- (7) 用螺钉⑨把压脚⑩按装在针杆上.

Install the presser foot⑩with the screw⑨.

2) 、调节针和挑线叉 Needle and looper timing adjustment



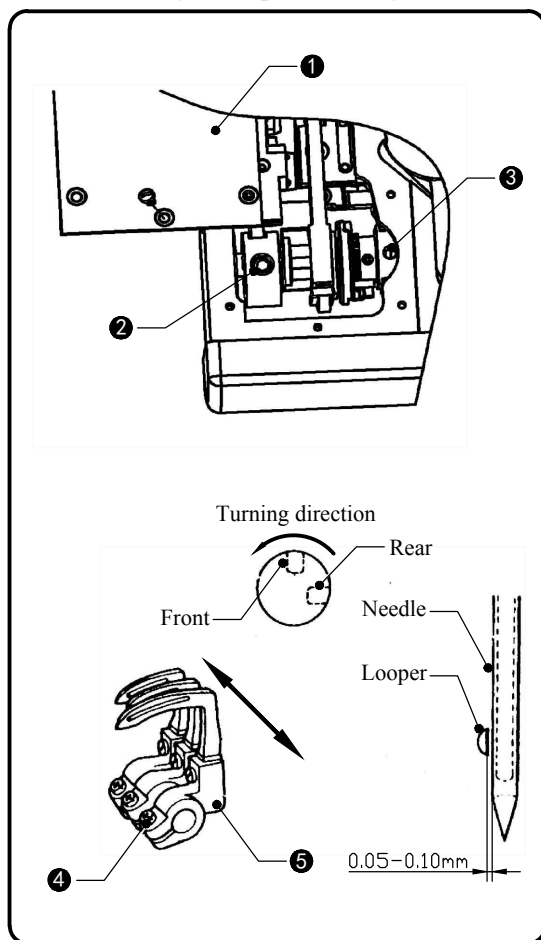
当机针①的位置下降到挑线叉②，挑线叉向后转到最后面，此时机针①的中心位置距离挑线叉②的顶端为2.4-2.6mm。

Make an adjustment so that, when needles are down lowest loopers② reach the end of their backward travel and the distance from the needle center to the looper tip is 2.4 to 2.6 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 looper② reach 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 screws⑦ on 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 needles① come 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 screws⑦ securely, 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2.4-2.6mm。
Loosen set screw⑧, move looper holder⑨ in the arrow direction until the distance between the needle center and the looper tip is 2.4 to 2.6 mm, and retighten set screw⑧ securely.
- (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 front 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5mm - 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.

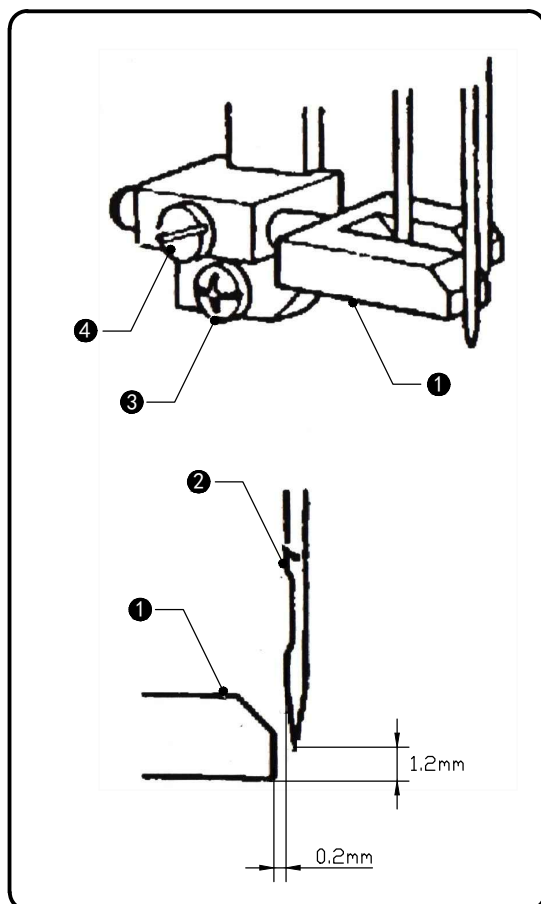
At this time, do not move the looper holder ⑤ in any direction except the direction indicated by the arrow. If it is moved in another direction.

(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 guard ① and the needles is 0.2mm.

(6) 拧紧螺钉 ④。

Tighten the set screw ④.

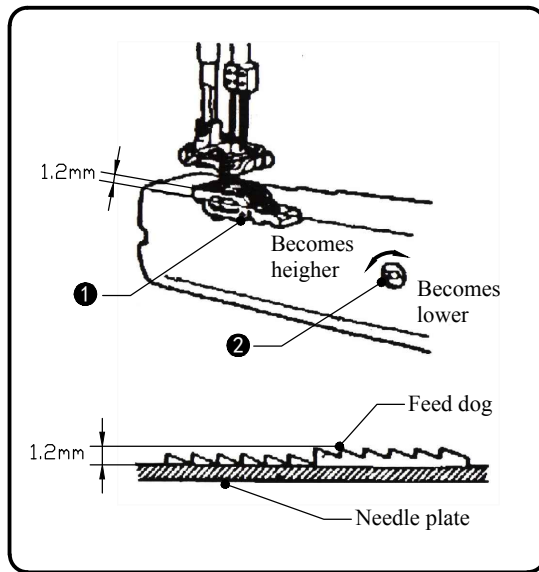
注意：

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。

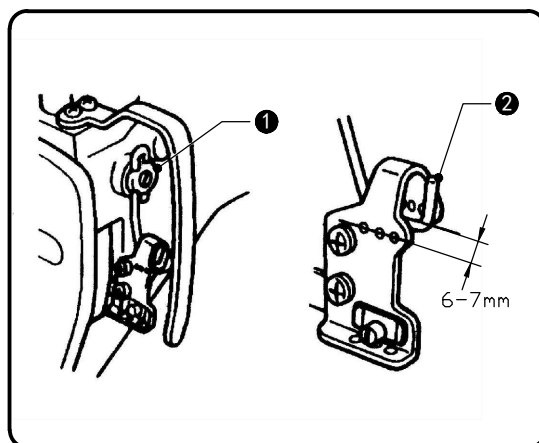
For some materials and threads, the best results can be obtained if the needle guard and the needle are touching slightly when stitch length is adjusted to the actual stitch length.

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 screw①, and then move the upper thread take-up thread guide② up or down to adjust so that the distance from the top of the upper thread take-up thread guide② 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。

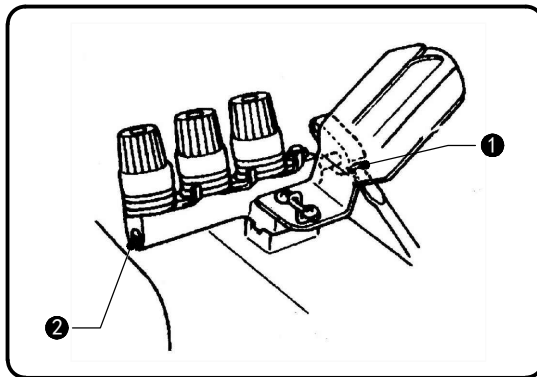
The higher the upper thread take-up thread guide②, the greater will be the upper thread loops.

(3) 拧紧螺钉①。

Tighten the screw①.

7) 、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。

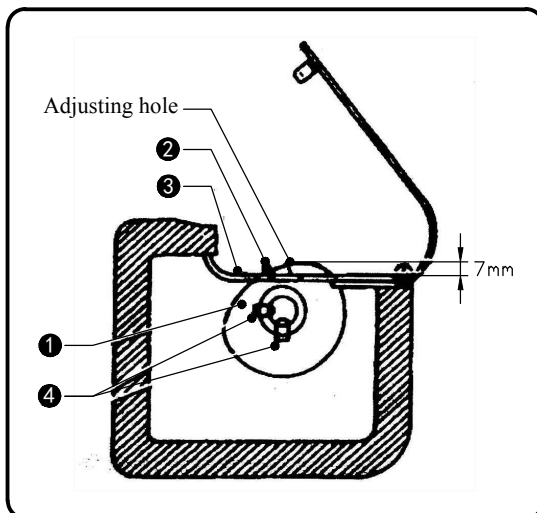
Make an adjustment by turning thread release shaft ② so that the thread tension discs begin to loosen when the presser foot rises 4mm above the top of the needle plate.

- (3) 调整结束后，拧紧紧固螺钉 ①.

After the adjustment, retighten set screw ① securely.

8) 、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.

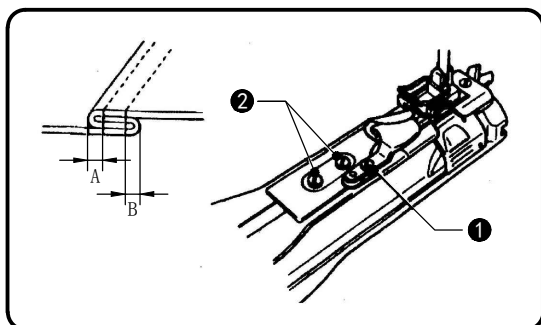
Raise lower thread take-up ① until it is 7mm up from thread take-up base ③.

- (3) 拧紧打线凸轮的固定螺钉 ④.

After the adjustment, retighten two set screws ④ securely.

9) 、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.

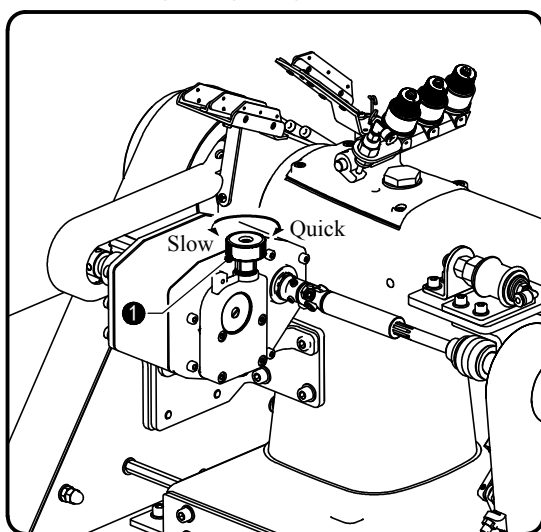
Adjust felling distance of point A by loosening set screw ①. After the adjustment, retighten set screw ①.

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.

10) 、拖轮的调节

Drag along a regulate of round



调节拖轮的快慢使得它同步于送布齿。

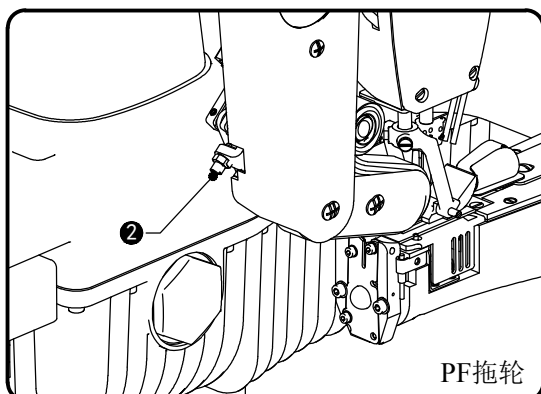
At the rate of speed which regulate to drag along a round make it synchronous in send cloth Chi.

(1) 调节旋钮 ①，顺时针旋转，拖轮变快，逆时针旋转，拖轮变慢。

Regulate a knob ①, The agreeable hour hand revolve, Drag along a round to become quick, The negative hour hand revolve, Drag along a round to become slow.

(3) 调节螺钉 ②的进出位置，相应限位拖轮的抬起高度。

Regulate pass in and out of bolt ② position, Correspond a limit drag along a round of lift height.



11)、增压参数调节
Pressurization parameter adjustment

此份为机器出厂参数，如有需求，可根据实际情况调节参数。
This part is the machine parameters, if there is a need, you can adjust the parameters according to the actual situation.

自动控制系统

生产数量:		清零
剪刀参数	增压参数	语言选择 Language selection
吸气参数	I/O监控	参数重置

剪刀参数

返回

前剪线开始	前剪线结束
3	25
后剪线开始	后剪线结束
3	30

吹气参数

返回

前吸气开始	前吸气结束
0	25
后吸气开始	后吸气结束
3	30

吸气自动

增压参数

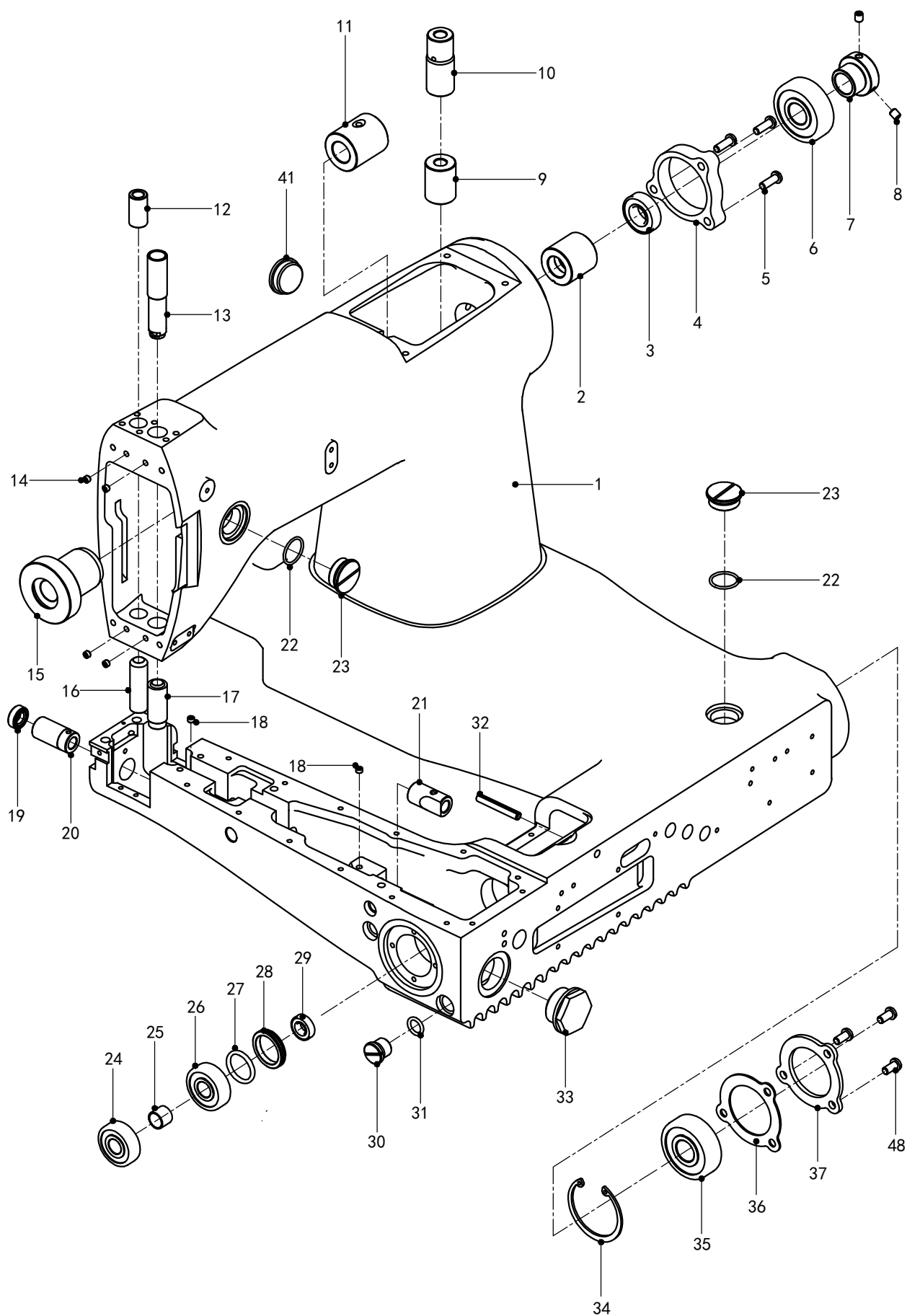
返回

增压起始针数	增压结束针数
2	7
前压起始针数	前压结束针数
2	7

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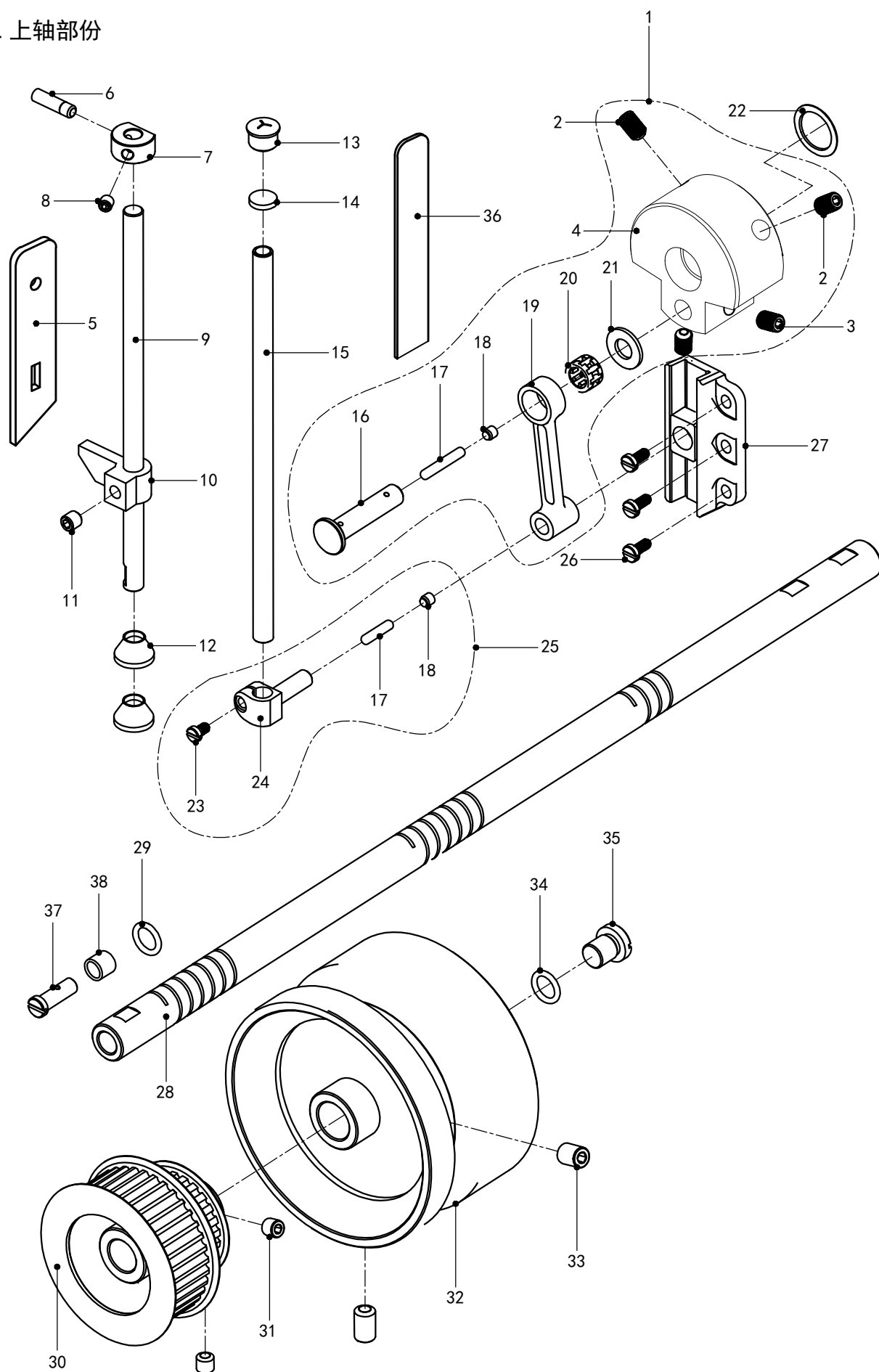
A. 机架部份



A. 机架部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	998A-1	998A001	998机壳/998Machine frame	1
2	998A-2	998A040	上主轴后套/ Main Shaft Bushing,Rear	1
3	998A-3	YF00028	油封/Oil seal	1
4	998A-4	998A006	轴承座/Bearing block	1
5	998A-5	LD00133	螺钉SM4. 76-12/Screw SM4.76	3
6	998A-6	ZC00001	外球面轴承/Bearing	1
7	998A-7	998A005	轴承套/Bearing sleeve	1
8	998A-8	LD00002	紧定螺钉M5x6/Screw M5	2
9	998A-9	998A043	竖轴下套/The Shu stalk is next	1
10	998A-10	998A042	竖轴上套/The Shu stalk is last	1
11	998A-11	998A031	上轴中套/Top set in stalk	1
12	998A-12	998A111	压脚杆上套/Presser Bar,Upper	1
13	998A-13	9588A027	针杆上套/Needle Bar Bush,Upper	1
14	998A-14	LD00023	紧定螺钉SM4. 36-5/Screw SM4.36	4
15	998A-15	998A039	上主轴前套/Main Shaft Bushing,Front	1
16	998A-16	927D005	压脚杆下套/Presser Bar,Lower	1
17	998A-17	9588A028	针杆下套/Needle Bar Bush,Lower	1
18	998A-18	LD00178	紧定螺钉SM4. 36-3. 2/Screw SM4.36	2
19	998A-19	YF00007	油封8-15/Oil seal	1
20	998A-20	998A156	打环器轴前套/Ring shafts	1
21	998A-21	927G015	打环器轴套筒F/Ring shaft sleeve F	1
22	998A-22	□XQ00022	O形圈20X1. 5/O Ring	2
23	998A-23	998A032	螺钉/Screw	2
24	998A-24	ZC00011	轴承/ Bearing	1
25	998A-25	998A179	轴承嵌套/ Bearing nesting	1
26	998A-26	ZC00045	轴承/Bearing	1
27	998A-27	□XQ00058	O形圈31X1. 9/O Ring	1
28	998A-28	998A180	轴承外套	1
29	998A-29	YF00027	油封110X25X5/Oil seal	1
30	998A-30	998A096	螺钉M12X1/Screw M12	1
31	998A-31	□XQ00035	O形圈/O Ring	1
32	998A-32	TXX00011	弹性圆柱销5X18/Pin,Spring	1
33	998A-33	998A176	油窗/Oil Seal	1
34	998A-34	TDQ00004	弹性挡圈C42/Retaining Ring	1
35	998A-35	ZC00009	轴承/Bearing	1
36	998A-36	998A161	轴承防油垫/Packing	1
37	998A-38	927B010	轴承压板/Bearing Presser	1
38	998A-39	LD00137	螺钉SM4. 76-10/Screw SM4.76	3
39	998A-40	V01-43	橡胶塞23/Rubber Cap	1

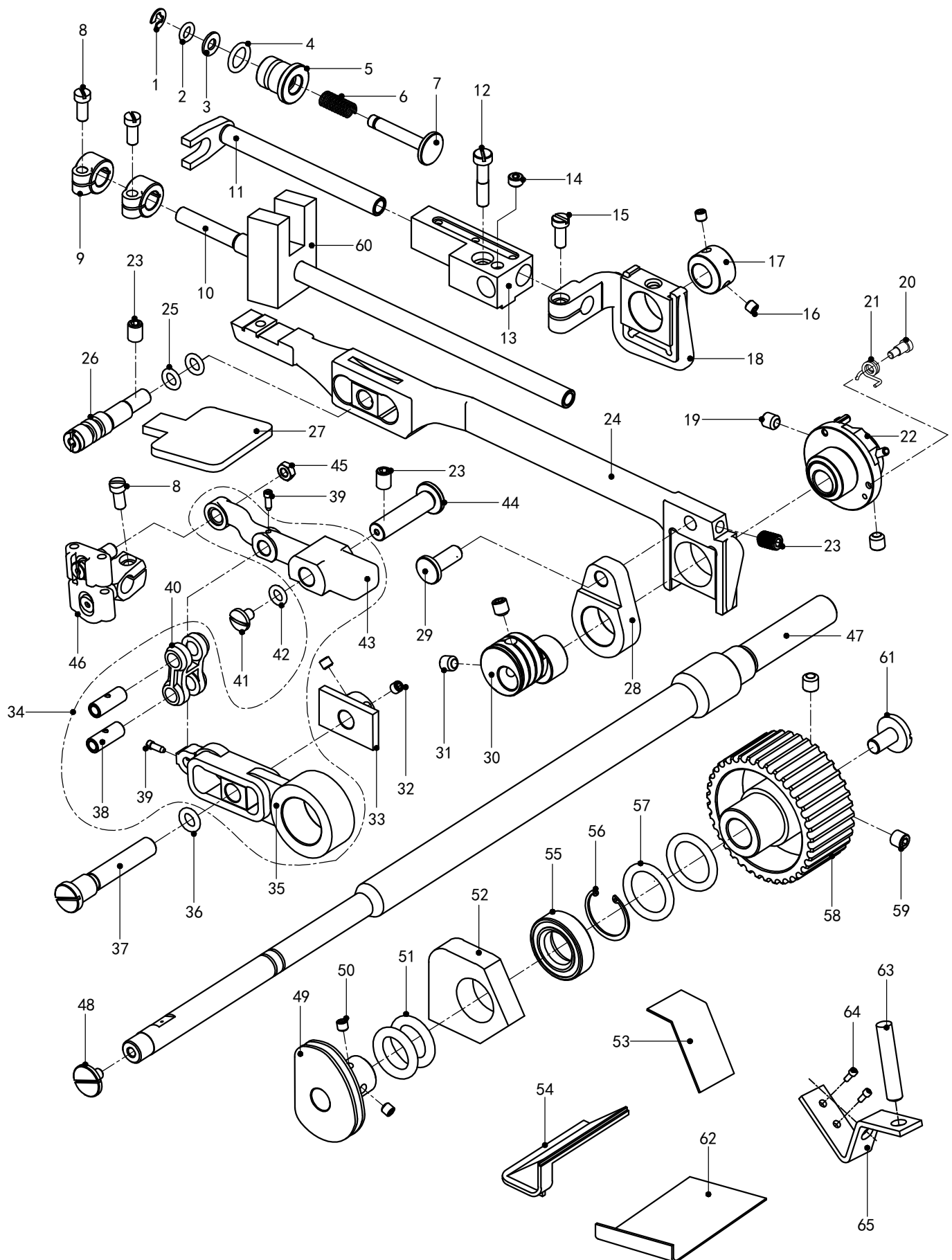
B. 上轴部份



B. 上轴部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	998B-1	9688B-ZJ-02	针杆连杆组件	1
2	998B-2	LD00063	内六角紧定螺钉15/64X28-10	2
3	998B-3	LD00245	内六角紧定螺钉SM6.35-5.4	2
4	998B-4	998B003	挑线杆曲柄	1
5	998B-5	998A159	压杆槽防油羊毛毡/ Felt	1
6	998B-6	998A158	羊毛毡限位销/Pin	1
7	998B-7	9588A109	羊毛毡限位挡圈/Collar	1
8	998B-8	LD00002	紧定螺钉M5-6/Screw M5	1
9	998B-9	998A139	压脚杆/Presser Bar	1
10	998B-10	998A038	压脚杆夹/Presser Bar Clamp	1
11	998B-11	LD00143	紧定螺钉SM5.95-6/Screw SM5.95	1
12	998B-12	928D033	压杆防油套/Presser Bar Defend Oil Set	2
13	998B-13	927C015	针杆上套油塞/Rubber Cap	1
14	998B-14	9588A130	针杆上套羊毛毡/ Felt	1
15	998B-15	998A003X	针杆/Needle Bai	1
16	998B-16	998B016	针杆销/Pin	1
17	998B-17	927C002	油线/Wick Ninpper	1
18	998B-18	927C003	橡胶塞/Rubber Cap	2
19	998B-19	927C005X	针杆连杆/Connecting Rod	1
20	998B-20	ZC00010X	滚针轴承/Ball Bearing	1
21	998B-21	DQ00033	垫圈8/Washer	1
22	998B-22	DQ00117	挑线杆曲柄垫片	1
23	998B-23	LD00140	螺钉SM3.57-7/Screw SM3.57	1
24	998B-24	927C013X	针杆抱箍/Needle Bar Clamp	1
25	998B-25	927C013XZJ	针杆抱箍组件	1
26	998B-26	LD00139	螺钉SM3.57/Screw SM3.57	3
27	998B-27	998A061	针杆滑块槽组件/Needle Bar GuideAssy	1
28	998B-28	998A009	上主轴/Upper Shaft	1
29	998B-29	□XQ00011	O型圈/O Ring	1
30	998B-30	998A00710	上同步轮组件	1
31	998B-31	LD00131	紧定螺钉SM6.35-6/Screw SM6.35	2
32	998B-32	998A045	皮带轮/Pelley	1
33	998B-33	LD00001	紧定螺钉M6-10/Screw M6	2
34	998B-34	□XQ00002	O型圈11/O Ring	1
35	998B-35	LD00311	螺钉SM9.52/Screw SM9.52	1
36	998B-36	998B038	挑线杆羊毛毡/Felt	1
37	998B-37	V02-14	油量调节销/Regulate to sell	1
38	998B-38	V02-15	油量调节销套/Sell a set	1

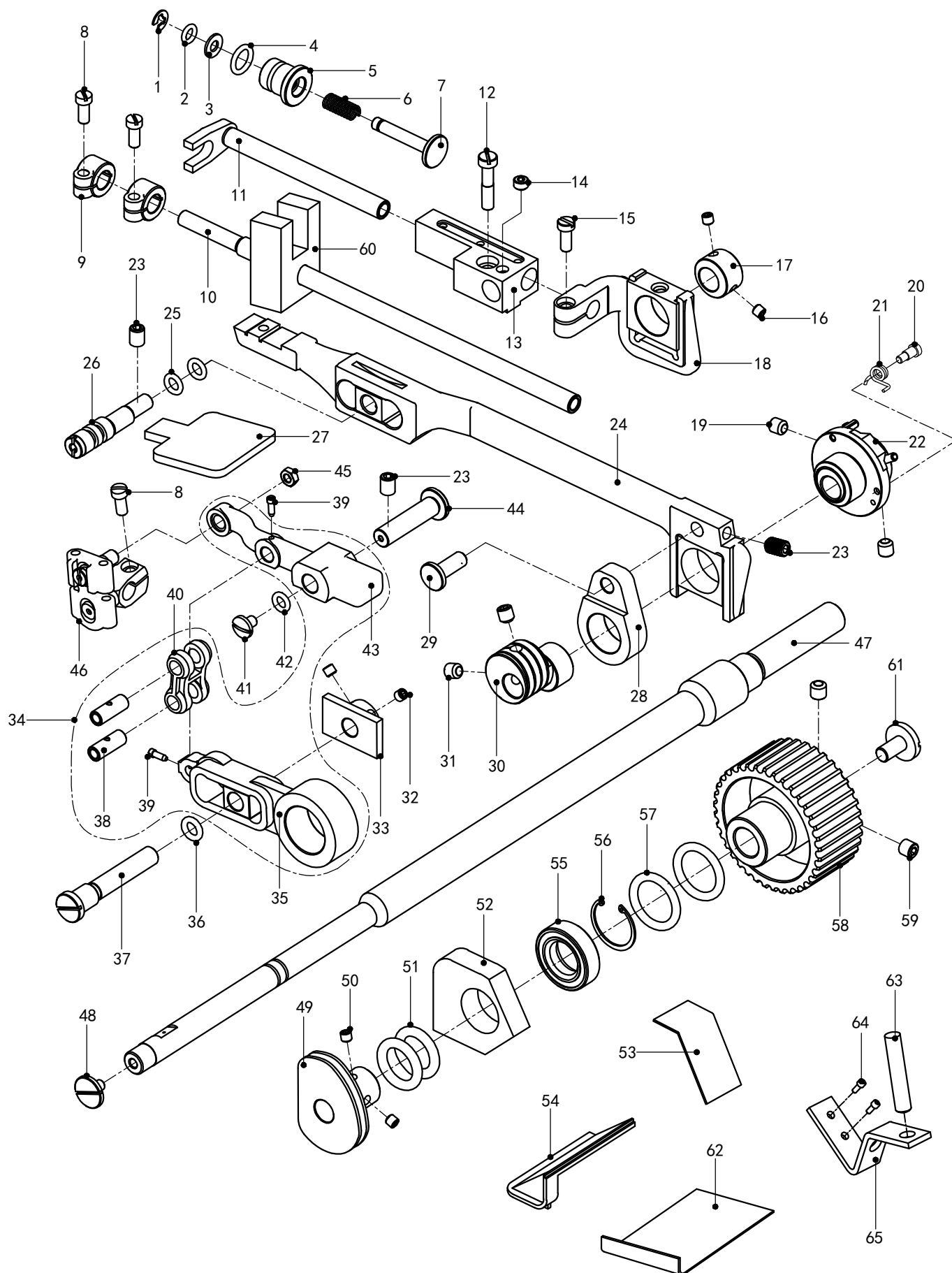
C. 下轴部份



C. 下轴部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	998C-1	TDQ00005	开口挡圈/Open ring	1
2	998C-2	□XQ00005	O形圈8/O Ring	1
3	998C-3	DQ00034	平垫圈5/Washer	1
4	998C-4	□XQ00023	O形圈/O Ring	1
5	998C-5	998A024	调节按钮套筒/Feed Regurate Button Bush	1
6	998C-6	TH00021	弹簧/Spring	1
7	998C-7	998A025	调节按钮/Push Button	1
8	998C-8	LD00265	螺钉SM4. 36/Screw SM4.36	3
9	998C-9	927G011	打环器轴挡圈/Lopper Shaft SetCollar	2
10	998C-10	927G013	打环器主轴/Lopper Shaft	1
11	998C-11	927G010	拔叉轴/Lopper peeding Fopk Shaft	1
12	998C-12	LD00153	螺钉SM4. 76/Screw SM4.76	1
13	998C-13	927G009	拔叉支座/Lopper Fopk Shaft Bracke	1
14	998C-14	LD00166	螺钉SM5. 95/Screw SM5.95	1
15	998C-15	LD00069	螺钉SM4. 36/Screw SM4.36	1
16	998C-16	LD00155	紧定螺钉SM4. 36/Screw SM4.36	2
17	998C-17	927G040X	偏心轮/ Eccentric Wheel	1
18	998C-18	927G004	拔叉组件/Lopper peeding Fopk Assy	1
19	998C-19	LD00143	紧定螺钉SM5. 95/Screw SM4.36	2
20	998C-20	927E021	扭簧螺钉/Screw	1
21	998C-21	927E022	扭簧/Twist Spring	1
22	998C-22	928E026	偏心调节器组件/ Eccentric Adjuster	1
23	998C-23	LD000146	紧定螺钉SM5. 95/Screw SM5.95	3
24	998C-24	927E004X	送料杆组件/Feeding Pole Module	1
25	998C-25	□XQ00004	O形圈9/O Ring	2
26	998C-26	928SPL023	送料杆偏心销/Feed Bar Eccentric Shaft	1
27	998C-27	9588A138	防油羊毛毡/Felt	1
28	998C-28	927E010	偏心轮连接块/Presser Bak Lifter	1
29	998C-29	927E008	连接块销子/Pin	1
30	998C-30	928E030X	偏心轮/Eccentric Wheel	1
31	998C-31	LD00003	紧定螺钉M6/Screw M6	2
32	998C-32	LD00023	紧定螺钉SM4. 36/Screw SM4.36	2
33	998C-33	927G020	滑块连杆挡板/Plate	1
34	998C-34	927G021X	打环器连杆组件	1
35	998C-35	927G025X	打环器滑块连杆组件/Looper Connecting Rod	1
36	998C-36	□XQ00007	O形圈/O Ring	1
37	998C-37	927G035	打环器滑块销/Slide Brock Shaft	1
38	998C-38	927G027X	短连杆销/Connecting Rod Pin	2
39	998C-39	927G02201	螺钉SM2. 38/Screw SM2.38	2
40	998C-40	927G026	打环器短连杆/Looper Connecting Rod	1
41	998C-41	LD00156	螺钉SM4. 36/Screw SM4.36	1
42	998C-42	□XQ00006	O型圈/O Ring	1

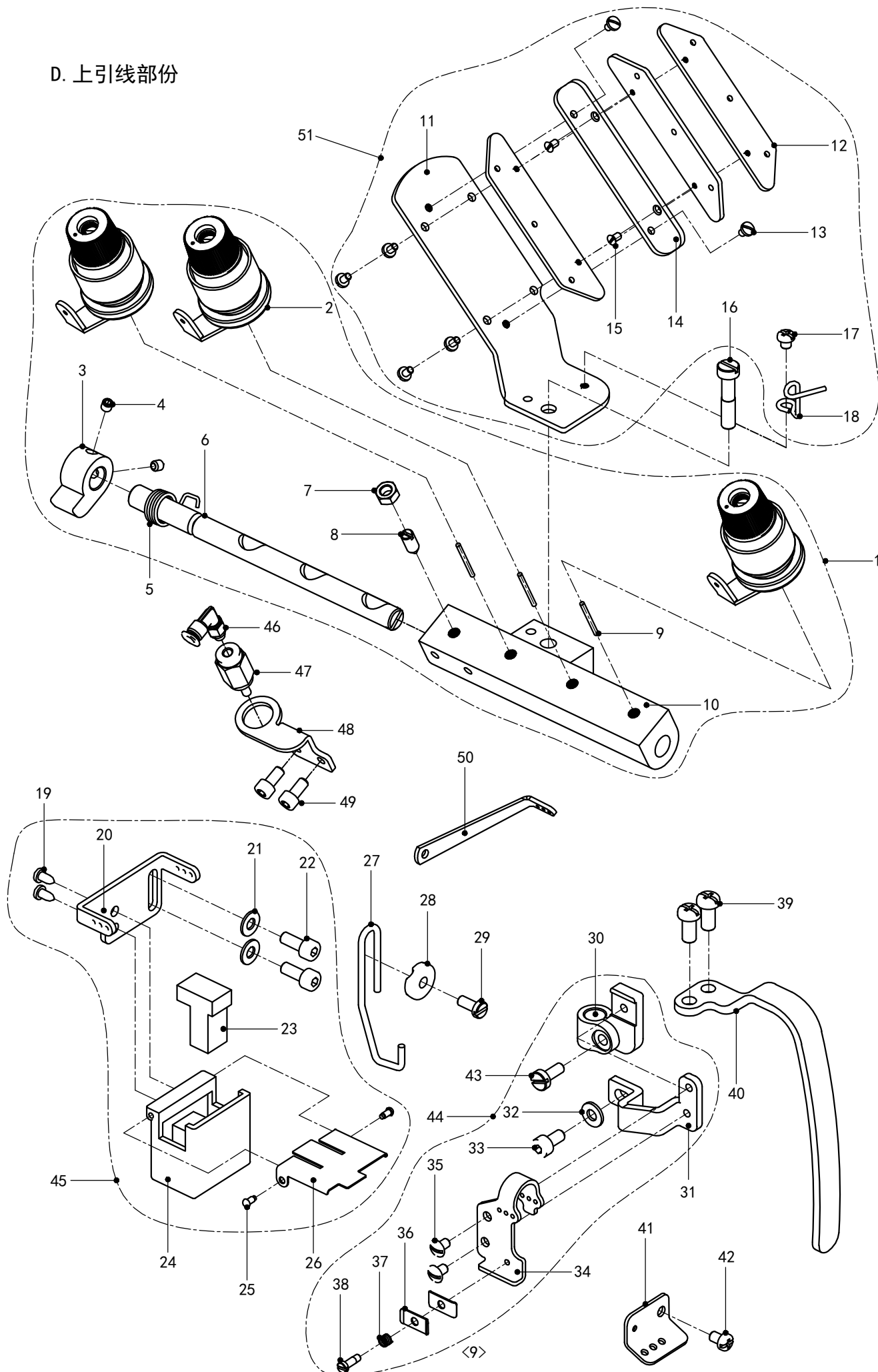
C. 下轴部份



C. 下轴部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
43	998C-43	927G023X	打环器连接杆/Looper Lever	1
44	998C-44	927G017X	打环器连接杆销/Looper Lever Pin	1
45	998C-45	LM00002	螺母SM5. 95/Nut SM5.95	1
46	998C-46	927G030	球头连杆组件/Ball Parts	1
47	998C-47	998A020	下主轴/Lower Shaft	1
48	998C-48	LD00149	螺钉SM4. 36/Screw SM4.36	1
49	998C-49	927I011	导线轮/Thread Guide	1
50	998C-50	LD00178	紧定螺钉SM4. 36/Screw SM4.36	2
51	998C-51	□XQ00052	O形圈18-3/O Ring	2
52	998C-52	998A11701	下过线器挡油羊毛毡/ Felt	1
53	998C-53	998A166	下轴挡油板/Oil baffle plate	1
54	998C-54	998A055	回油导油罩/Lead an oil cover	1
55	998C-55	YF00015	油封20X30X7/Oil seal	1
56	998C-56	TDQ00018	弹性挡圈20/Retaining Ring	1
57	998C-57	□XQ00051	O形圈25-4/O Ring	2
58	998C-58	927A011	下同步轮/Timing Belt Wheel Assy Lower	1
59	998C-59	LD00131	紧定螺钉SM6. 35/Screw SM6.35	2
60	998C-60	9588A129	间隔羊毛毡/Felt	1
61	998C-61	LD00150	螺钉SM6. 35/Screw SM6.35	1
62	998C-62	998C065	打线轮隔油板/Separate oil plank	1
63	998C-63	927EC-1-01	接近开关	2
64	998C-64	LD00168	螺钉SM3. 57-7. 5/Screw SM3.57	2
65	998C-65	998P020	感应器安装支架	1

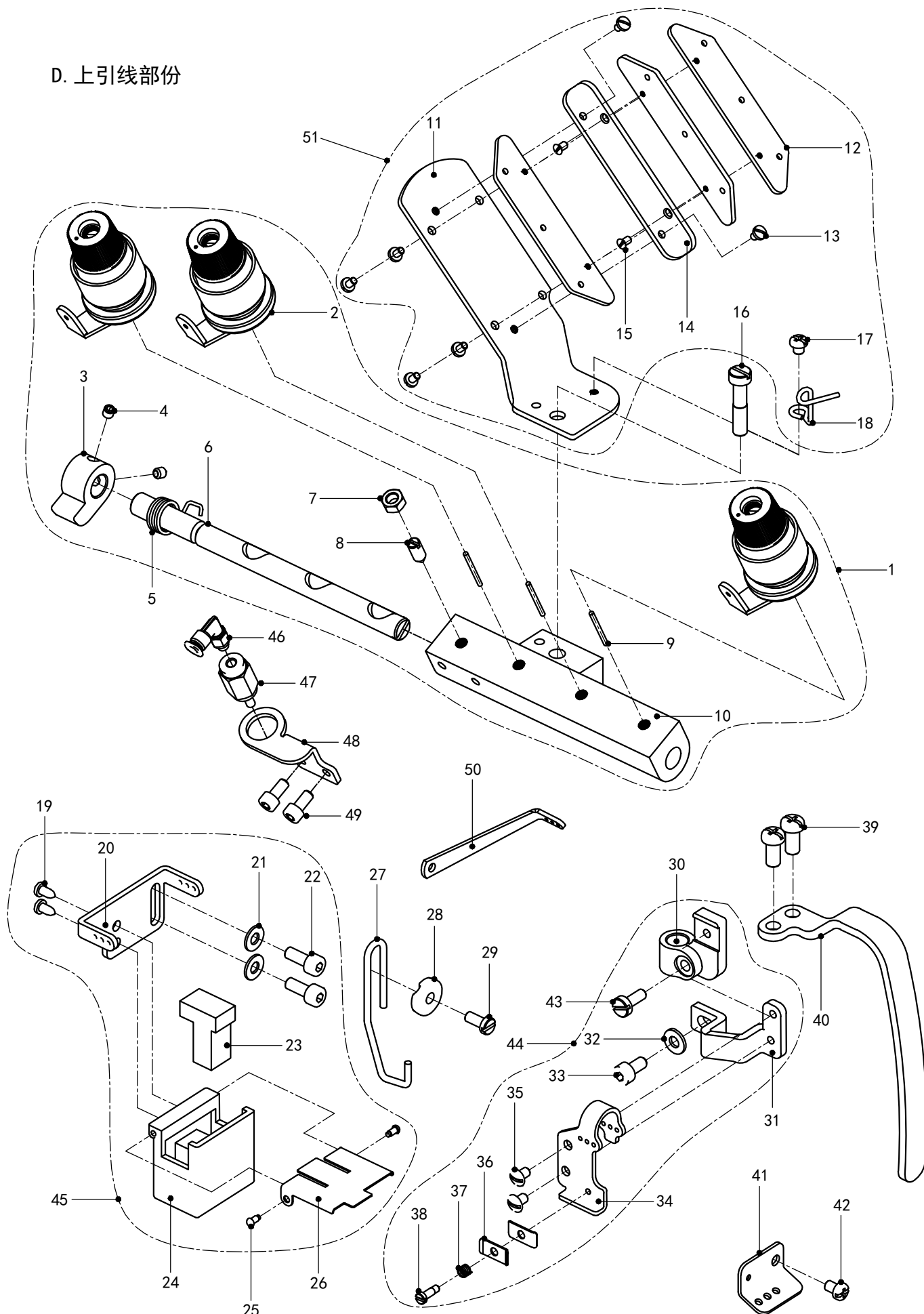
D. 上引线部份



D. 上引线部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	998D-1	9588A105ZJ	夹线器组件/Upper Thread Regulator Assy	1
2	998D-2	928H061	夹线器组件/Upper Thread Regulator Assy	3
3	998D-3	9588A106	松线凸轮/Loose the CAM	1
4	998D-4	LD00083	紧定螺钉M5X5/Screw M5	2
5	998D-5	9588A156	松线凸轮扭簧/Twist Spring	1
6	998D-6	927H020	夹线器支架轴/Tension Release Shaft	1
7	998D-7	LM00001	螺母SM4. 36/Nut SM4.36	1
8	998D-8	927H023	螺钉SM4. 36-11/Screw SM4.36	1
9	998D-9	927H011	夹线器顶销/Pin	3
10	998D-10	9588A193	夹线器支架/Upper Thread Tension Bracket	1
11	998D-11	927H018	上过线板支架/Upper Thread Guide	1
12	998D-12	927H013	过线板/Thread Retainer	3
13	998D-13	LD00161	螺钉SM2. 38-3. 6/Screw SM2.38	6
14	998D-14	927H014	过线板连接板/Thread Guide Set Plate	1
15	998D-15	LD00162	沉头螺钉SM2. 38-4/Screw SM2.38	2
16	998D-16	LD00282	螺钉SM4. 76-27/Screw SM4.76	1
17	998D-17	LD00067	螺钉SM3. 57-4/Screw SM3.57	1
18	998D-18	927H016	引线钩/Lead hook	1
19	998D-19	LD00252	自攻螺钉ST3/Screw ST3	2
20	998D-20	9588A097	硅油盒过线板/Lead line plank	1
21	998D-21	DQ00054	平垫圈/Washer	2
22	998D-22	LD00251	螺钉M4-8/Screw M4	2
23	998D-23	9588A09801	硅油盒羊毛毡/Felt	1
24	998D-24	9588A09803	硅油盒/Huo oil box	1
25	998D-25	9588H052	铆钉/Rivet	2
26	998D-26	9588A09802	硅油盒上盖/Upper cover	1
27	998D-27	927H056	上引线钩/Upper lead hook	1
28	998D-28	927H057	上引线钩垫块/Upper lead hook block	1
29	998D-29	LD00420	螺钉SM3. 57-9/Screw SM3.57	1
30	998D-30	9588A020	挑线杆夹/Raise wire pole Support	1
31	998D-31	9588A019	挑线杆/Raise wire Support	1
32	998D-32	DQ00064	平垫圈4/Washer	1
33	998D-33	LD00104	螺钉M4X8/Screw M4	1
34	998D-34	927H051	上引线板/Upper lead plate	1
35	998D-35	LD00164	螺钉SM3. 18-5/Screw SM3.18	2
36	998D-36	927H053	上引线板压线板/Thread Tension Disc	2
37	998D-37	TH00023	弹簧/Spring	1
38	998D-38	927H055	上引线板弹簧螺钉/Screw	1
39	998D-39	LD00137	螺钉SM4. 76-10/Screw SM4.76	2
40	998D-40	927H038D	上引线装置护手/Upper lead device	1
41	998D-41	927H058	下引线板/Lower lead plate	1

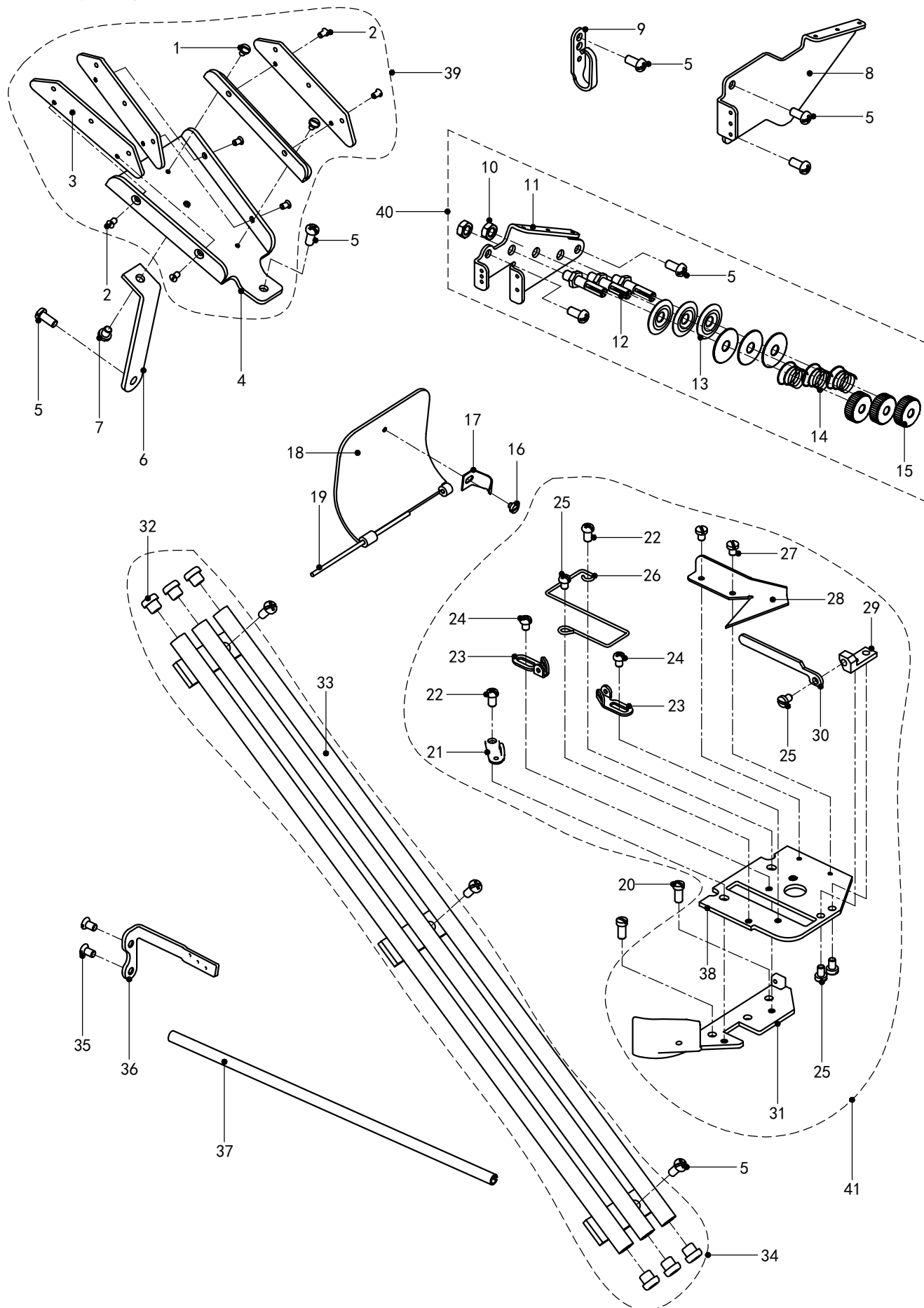
D. 上引线部份



D. 上引线部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
42	998D-42	LD00135	螺钉SM3. 57-6/Screw SM3.57	1
43	998D-43	LD00139	螺钉SM3. 57-8/Screw SM3.57	1
44	998D-44	9588A019ZJ	挑线杆组件	1
45	998D-45	9588A098ZJ	硅油盒组件	1
46	998D-46	927Q-2-29	L型接头PL04M5C/“L”Connector PL04M5C	1
47	998D-47	927Q.1.14	针形缸/The needle cylinder	1
48	998D-48	9588A105	松线气缸支架/Loose line cylinder bracket	1
49	998D-49	LD00104	螺钉M4-8/Screw M4	2
50	998D-50	927H041	夹松紧连杆	1
51	998D-51	928H062ZJ	上过线板组件	1

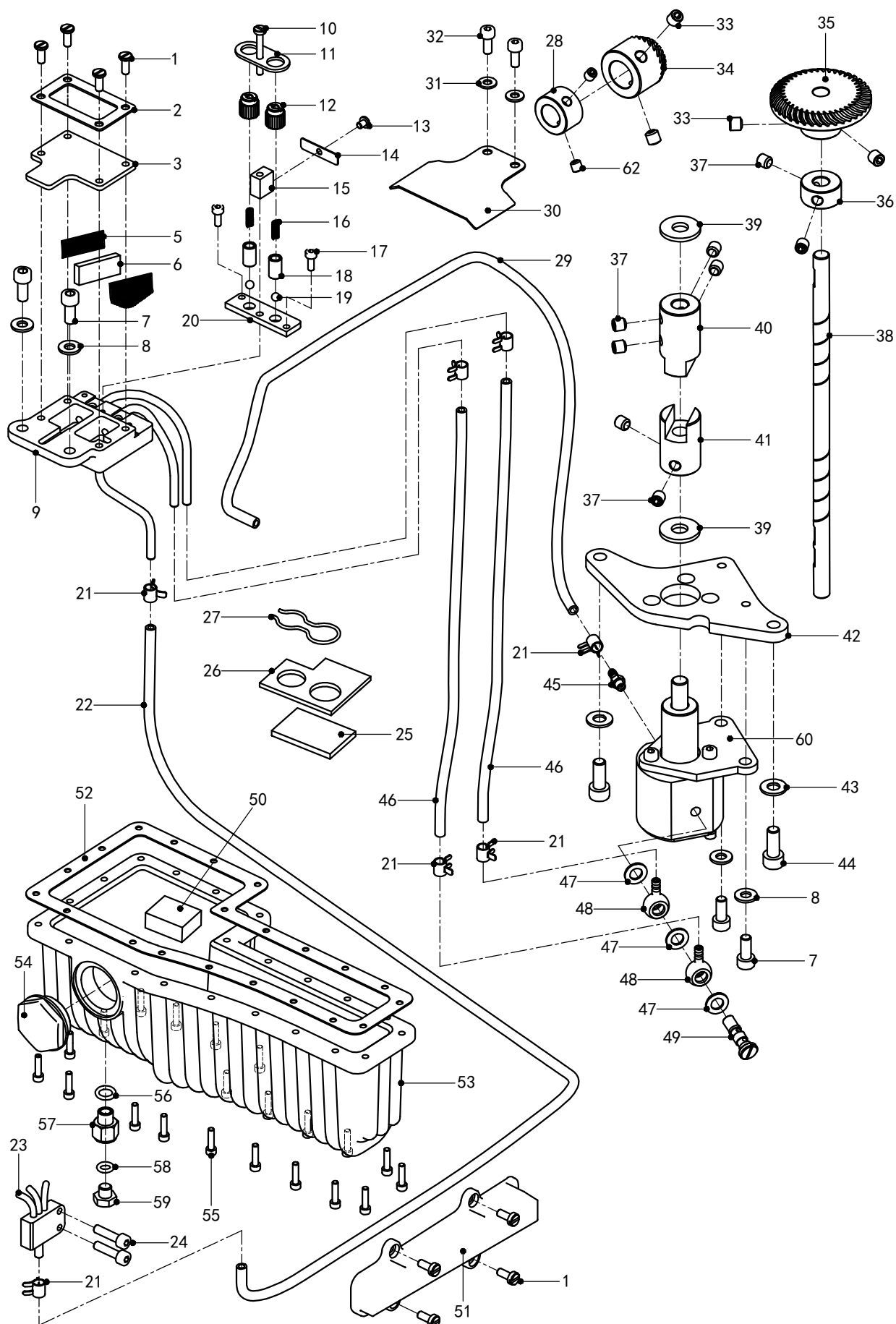
E. 下引线部份



E. 下引线部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	998E-1	LD00161	螺钉SM2. 38-3. 6/Screw SM2.38	2
2	998E-2	LD00162	沉头螺钉SM2. 38-4/Screw SM2.38	6
3	998E-3	927H013	过线板/Thread Retainer	3
4	998E-4	927I005	过线板支架/Lower Thread Guide Retainer	1
5	998E-5	LD00134	螺钉SM3. 57-8/Screw SM3.57	10
6	998E-6	927I006	过线板支架支撑条/LowerThreadGuide Support	1
7	998E-7	LD00067	螺钉SM3. 57-4/Screw SM3.57	1
8	998E-8	927I048	下引线板/Lower lead plate	1
9	998E-9	927I047	下引线钩/Lower lead hook	1
10	998E-10	LM00001	螺母SM4. 36/Nut	3
11	998E-11	927I042	下引线夹线板/Under the wire clamp	1
12	998E-12	927I043	下引线夹线器柱/Lower lead clamp	3
13	998E-13	927I044	夹线盘/Tension block	6
14	998E-14	927I045	下引线夹线器簧/Spring	3
15	998E-15	927I046	夹线器调节螺母/Nut	3
16	998E-16	LD00065	螺钉SM2. 38-2/Screw SM2.38	1
17	998E-17	927I027	下过线器盖弹簧片/Spring	1
18	998E-18	927I028	下过线器盖/Lower wire cover	1
19	998E-19	927I029	下过线器盖轴销/Pin	1
20	998E-20	LD00168	螺钉SM3. 57-7. 5/Screw SM3.57	2
21	998E-21	927I023	下过线器导线板二/Down wire traverse board	1
22	998E-22	LD00135	螺钉SM3. 57-6/Screw SM3.57	2
23	998E-23	927I014	下过线器导线板一/Down wire traverse board	2
24	998E-24	LD00179	螺钉SM3. 18-3. 2/Screw SM3.18	2
25	998E-25	LD00167	螺钉SM3. 18-4/Screw SM3.18	4
26	998E-26	927I021	下过线器导线钢丝/Wire wire	1
27	998E-27	LD00161	螺钉SM2. 38-3. 6/Screw SM2.38	1
28	998E-28	927I018	下过线器引线板/Down wire lead plate	1
29	998E-29	927I017	下过线器压线板支架/Press plate bracket	1
30	998E-30	927I016	下过线器压线板/Lower wire feeder	1
31	998E-31	927I025	下过线器支架/Lower wire rod support	1
32	998E-32	927I00801	过线管嵌套/Inglined Guide Tube Nesting	6
33	998E-33	928I009	过线管组件/Inglined Guide Tube Assy	1
34	998E-34	928I009XZJ	过线管组件	1
35	998E-35	LD00342	螺钉SM3. 18-7/Screw SM3.18	2
36	998E-36	927I034	弯针引线片/Curved needle lead	1
37	998E-37	927I040	前臂过线管/Lower thread Feer BarGuide	1
38	998E-38	927I013	下过线器支架板/Lower wire stenting plate	1
39	998E-39	928I052	下过线板组件	1
40	998E-40	928I033	下引线过线器组件(三线)/Wire feeder module	1
41	998E-41	9927I053	下过线组件	1

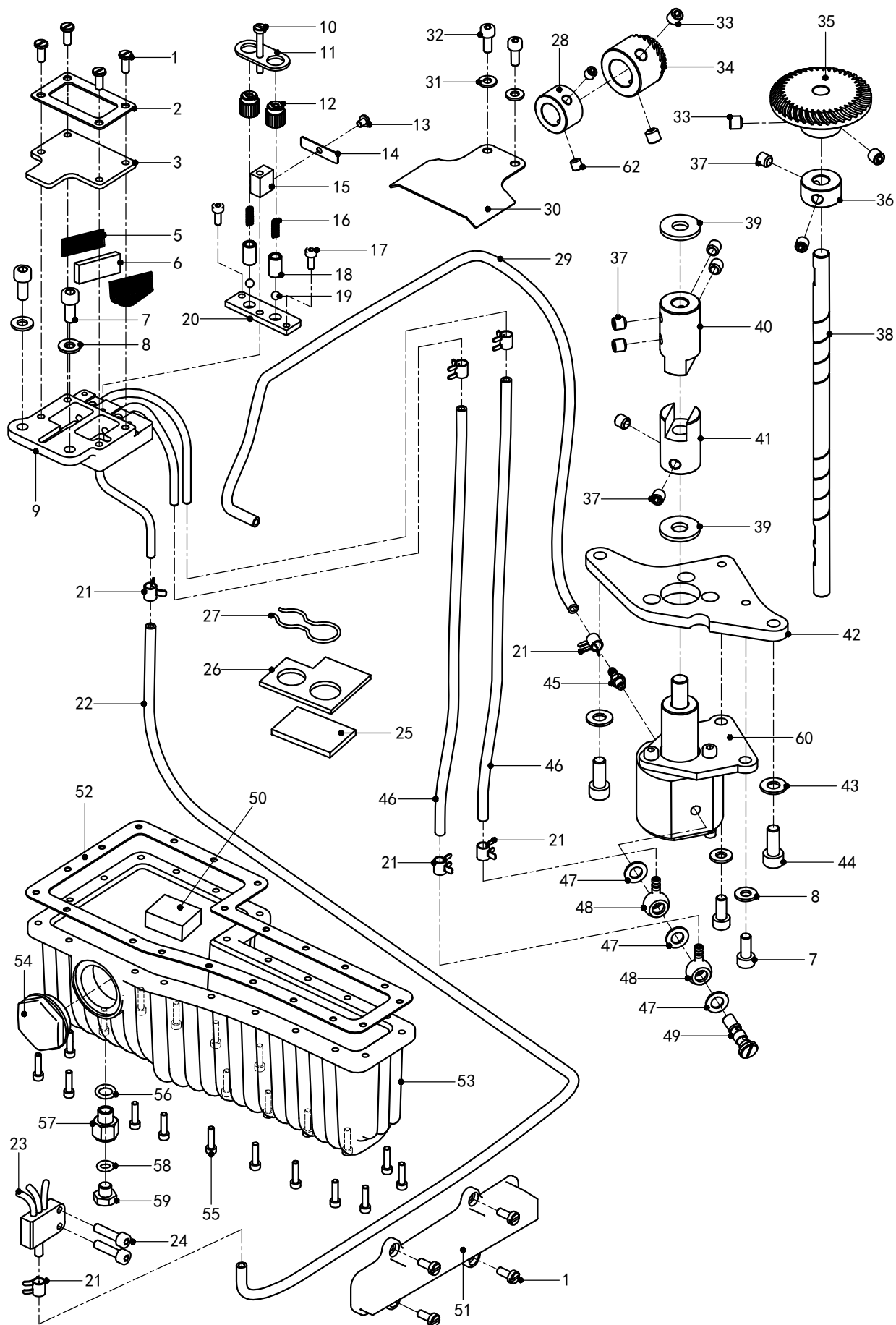
F. 供油回油部份



F. 供油回油部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	998F-1	LD00151	螺钉SM3. 57/Screw SM3.57	8
2	998F-2	998A103	滤油盒压板垫板/Oil filter box press plate	1
3	998F-3	998A102	滤油盒压板/Oil filter box press plate	1
4	998F-4	998A126	滤油羊毛毡/Oil filter wool felt	1
5	998F-5	998A129	机臂滤油网/Oil filter network	2
6	998F-6	998A128	机臂滤油羊毛毡/Wool filter wool felt	1
7	998F-7	LD00094	螺钉M5-12/Screw M5	4
8	998F-8	DQ00034	平垫圈5/Washer	4
9	998F-9	998A101	滤油盒组件/Oil filter box component	1
10	998F-10	LD00212	螺钉M3-22/Screw M3	1
11	998F-11	998A119	调节限位板/Regulating limit plate	1
12	998F-12	998A106	调节滚花螺母/Nut	2
13	998F-13	LD00293	螺钉M3-5/Screw M3	1
14	998F-14	998A120	限位弹簧片/Limit spring sheet	1
15	998F-15	998A121	限位板安装块/Limit plate mounting block	1
16	998F-16	TH00038	溢流钢珠压簧/Spring	2
17	998F-17	LD00111	螺钉M3-6/Screw M3	2
18	998F-18	998A105	钢珠螺套/Steel ball screw	2
19	998F-19	GZ00001	溢流钢珠/Overflow steel ball	2
20	998F-20	998A118	溢流安装板/Overflow mounting plate	1
21	998F-21	998A122	油管夹5. 5/Oil pipe clamp	7
22	998F-22	998F022	机臂供油管/Arm oil supply tube	1
23	998F-23	998A059	油嘴组件/Nozzle assembly	1
24	998F-24	LD00220	螺钉M4-16/Screw M4	2
25	998F-25	V08-21	回油除尘毡	1
26	998F-26	998A155	机头回油羊毛毡/Head back oil wool felt	1
27	998F-27	V08-23	回油毡夹/Linoleum clip	1
28	998F-28	998A054	主轴套挡圈/Spindle sleeve retaining ring	1
29	998F-29	998F029	机头回油管/Head back oil pipe	1
30	998F-30	998A018	挡油板/Oil baffle plate	1
31	998F-31	DQ00064	平垫圈4/Washer	2
32	998F-32	LD00104	螺钉M4-8/Screw M4	2
33	998F-33	LD00131	紧定螺钉SM6. 35/Screw SM6.35	4
34	998F-34	998A108	油泵齿轮(小)/Oil pump wheel gear(Small)	1
35	998F-35	998A109	油泵齿轮(大)/Oil pump wheel gear(Large)	1
36	998F-36	998A014	竖轴挡圈/Vartical shaft retaining ring	1
37	998F-37	LD00003	紧定螺钉M6-6/Screw M6	8
38	998F-38	998A041	油泵竖轴/Vartical shaft of oil pump	1
39	998F-39	DQ00003	油泵间隔垫片/Oil pump spacer	2
40	998F-40	998A012	油泵上连接/Oil pump connection	1
41	998F-41	998A010	油泵下连接/Oil pump connection	1
42	998F-42	998A013	油泵安装板/Oil pump mounting plate	1

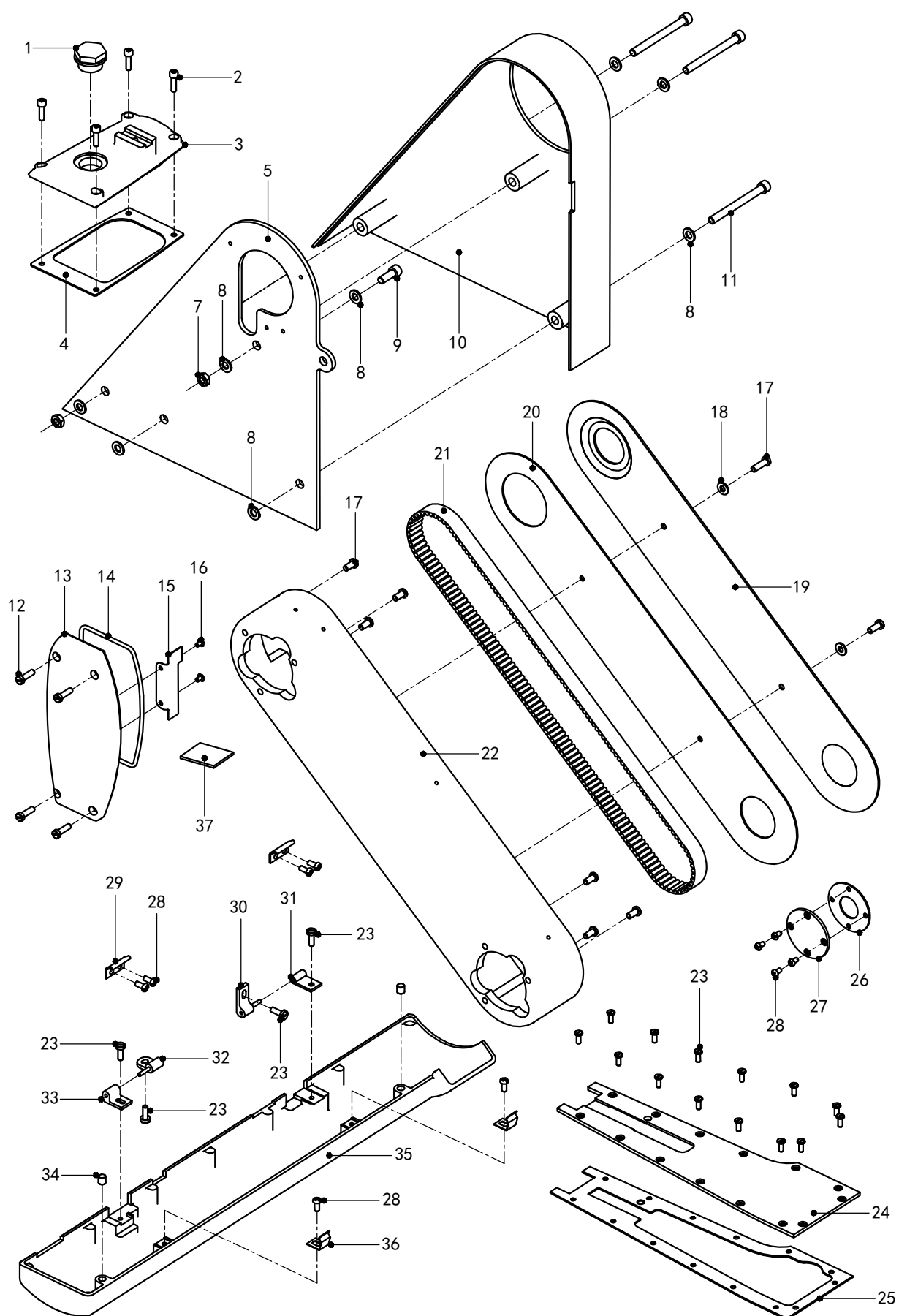
F. 供油回油部份



F. 供油回油部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
43	998F-43	DQ00029	平垫圈6/Washer	2
44	998F-44	LD00535	螺钉M6-14/Screw M6	2
45	998F-45	998A022	油嘴/Choke	1
46	998F-46	998F046	供油管/Oil supply nozzle	2
47	998F-47	DQ00103	红钢纸垫圈6.5/Washer	3
48	998F-48	998A136	油泵供油嘴/Oil pump oil supply nozzle	2
49	998F-49	J20-01	油嘴	1
50	998F-50	998F076	海绵块	1
51	998F-51	998A017	回油罩/Return oil cover	1
52	998F-52	998A083	油盘防油垫/Packing	1
53	998F-53	998A035	油盘/Oil dish	1
54	998F-54	9588A031	油窗/Oil Seal	1
55	998F-55	LD00317	螺钉M5-18/Screw M5	21
56	998F-56	□XQ00054	O形圈1602D5/O Ring	1
57	998F-57	998A174	油盘放油嘴/Oil pan	1
58	998F-58	□XQ00057	O形圈130204/O Ring	1
59	998F-59	998A175	油盘放油螺钉/Screw	1
60	998F-60	998A056	油泵/Oil pump	1
61	998F-61	LD00083	紧定螺钉M5X5/Screw M5	2

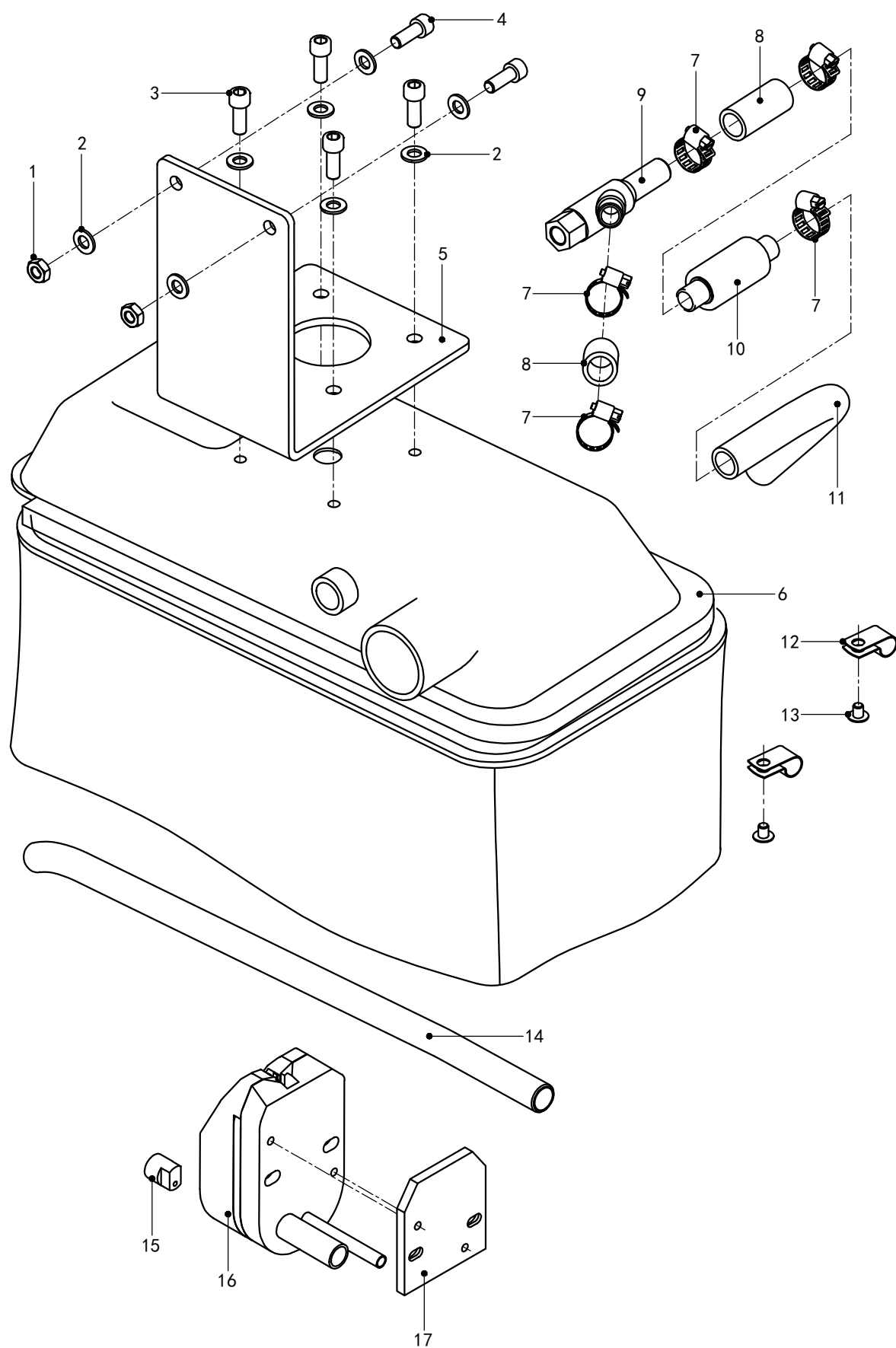
G. 罩壳、盖板部份



G. 罩壳、盖板部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	998G-1	927A028	油窗/Oil Seal	1
2	998G-2	LD00247	螺钉M4-14/Screw M4	4
3	998G-3	998A034	顶盖/Top cap	1
4	998G-4	998A084	顶盖防油垫/Packing	1
5	998G-5	998A082	皮带护罩安装板/Pulley Cover fix	1
6	998G-6			
7	998G-7	LM00027	螺母M6/Nut M6	2
8	998G-8	DQ00050	平垫圈/Washer	8
9	998G-9	LD00249	螺钉M6-12/Screw M6	1
10	998G-10	998A092	皮带护罩/Pulley Cover	1
11	998G-11	LD00264	螺钉M6-60/Screw M6	3
12	998G-12	LD00330	螺钉SM4. 36-15/Screw M4.36	4
13	998G-13	998A029	端面盖/Face Plate	1
14	998G-14	998G014	端面盖密封圈/Facking	1
15	998G-15	998A110	挑线杆挡油板/Oil baffle plate	1
16	998G-16	LD00164	螺钉SM3. 18-5/Screw SM3.18	2
17	998G-17	LD00133	螺钉SM4. 76-12/Screw SM4.76	8
18	998G-18	DQ00034	平垫圈5/Washer	2
19	998G-19	927A007	同步皮带罩盖板/Belt Corer Plate	1
20	998G-20	927A008	同步皮带罩盖板垫/Facking	1
21	998G-21	927A009	同步带M5/Timing Belt	1
22	998G-22	998A008	同步皮带罩/Belt Cover	1
23	998G-23	LD000151	螺钉SM3. 57/Screw SM3.57	18
24	998G-24	998A004	前臂盖/Front Feed Arm Cap	1
25	998G-25	928SPL021	前臂盖垫/Facking	1
26	998G-26	927G03901	圆盖油垫/Facking	1
27	998G-27	927G03801	圆盖/Ball Bearing	1
28	998G-28	LD00135	螺钉SM3. 57-6/Screw SM3.57	10
29	998G-29	927A019	前盖弹簧片钩/Font Cover Spring	2
30	998G-30	998A098	前盖右摇臂座/Right rocker seat of front cover	1
31	998G-31	998A182	前盖右摇臂/Right rocker arm of front cover	1
32	998G-32	998A100	前盖左摇臂座/Left rocking arm seat of front cover	1
33	998G-33	998A099	前盖左摇臂/Left rocker arm of front cover	1
34	998G-34	927A022	前盖橡胶垫/Rubber Cap	2
35	998G-35	998A033	长前盖/Front Cover	1
36	998G-36	927A021	前盖弹簧片/Front Cover Spring	2
37	998G-37	998G037	端面盖羊毛毡/Felt	1

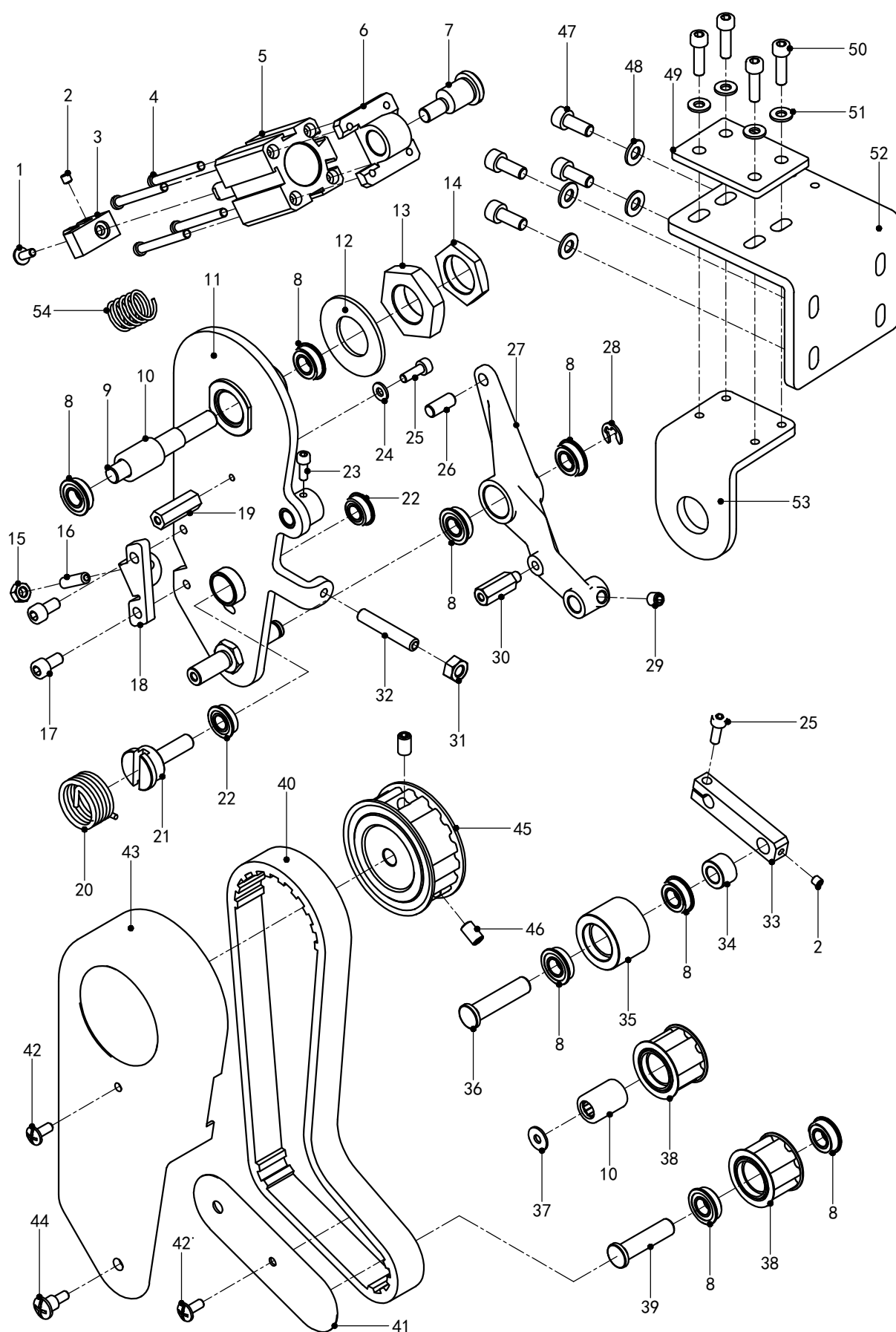
H. 自动剪线部份



H. 自动剪线部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	998H-1	LM00027	螺母M6/Nut M6	2
2	998H-2	DQ00050	平垫圈/Washer	8
3	998H-3	LD00238	螺钉M6-10/Screw M6	4
4	998H-4	LD00236	螺钉M6-14/Screw M6	2
5	998H-5	998A107	储屑袋支架/Canvas sack Support	1
6	998H-6	927PA027	储屑袋套件/Canvas sack	1
7	998H-7	9588A160	软管抱箍/Embrace hoop	5
8	998H-8	927CV048	转接软管/Transfer a soft tube	2
9	998H-9	927CV034	吸屑三通/Three-way Pipe	1
10	998H-10	927CV047	消声器/Eliminate a machine	1
11	998H-11	927CV054	消声软管/Eliminate a soft tube	1
12	998H-12	927CV031	吸屑软管卡扣/Button	2
13	998H-13	LD00244	垫片螺钉M5/Screw M5	2
14	998H-14	927CV030	吸屑软管/Absorb Scraps Soft Tube	1
15	998H-15	998P035	剪刀偏心帽	1
16	998H-16	HCV001	气动剪刀	1
17	998H-17	998P036	剪刀安装版	1

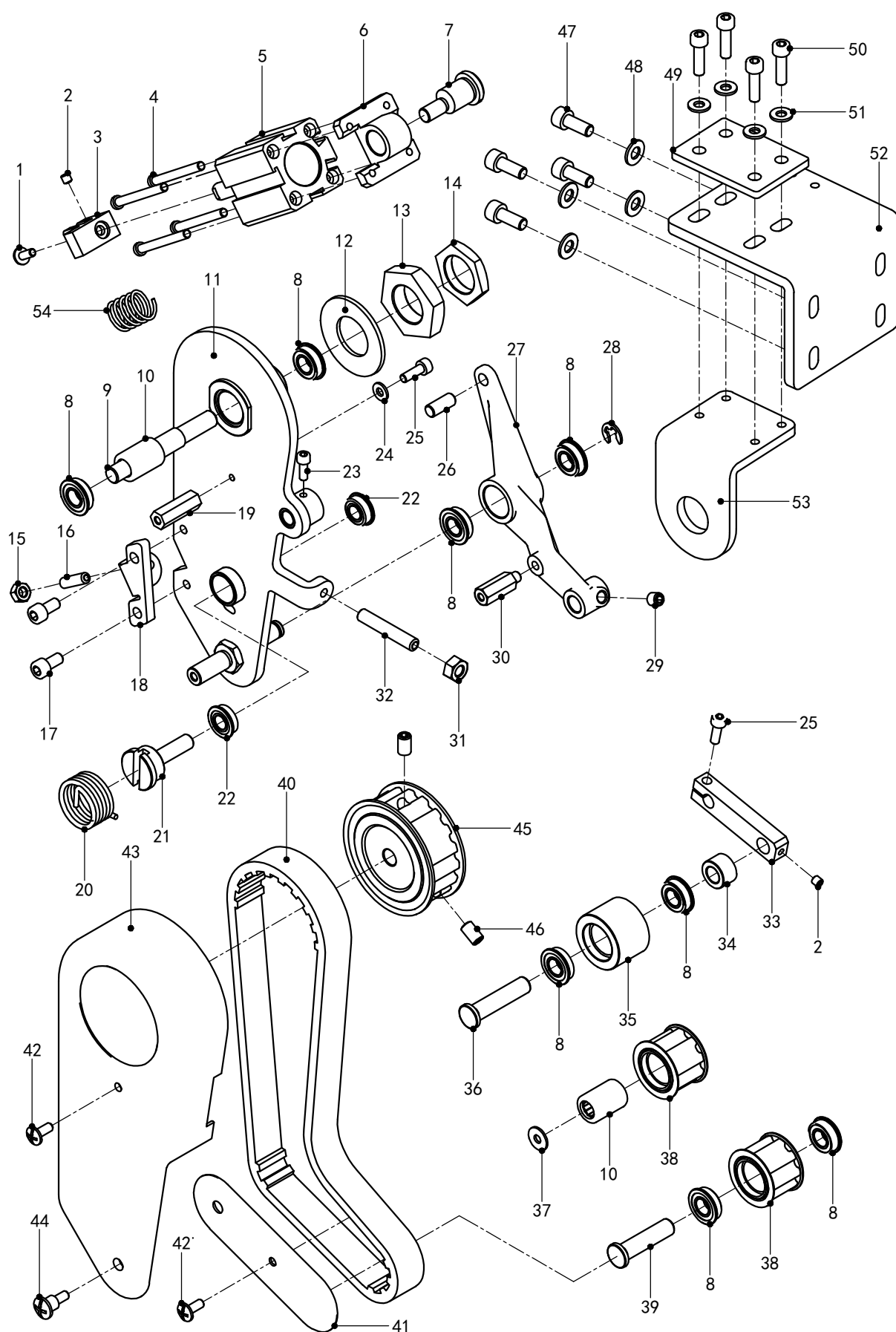
I. PF拖轮部份



I. PF拖轮部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	998I-1	LD00272	螺钉M4-10.5/Screw M4	1
2	998I-2	LD00074	紧定螺钉M4-5/Screw M4	2
3	998I-3	9588PF020	气缸连接块/Cylinder connecting piece	1
4	998I-4	LD00227	螺钉M4-40/Screw M4	4
5	998I-5	927Q-1-16	气缸SDA20X20/Cylinder SDA20X20	1
6	998I-6	9588PF021	气缸连接座/Cylinder connecting seat	1
7	998I-7	9588PF026	气缸限位轴销/Shaft pin	1
8	998I-8	ZC00024	带挡边深沟球轴承8/16/Bearing	8
9	998I-9	9588PF023	大同步轮轴/Large synchronous shaft	1
10	998I-10	ZC00028	单向滚针轴承/Bearing	2
11	998I-11	9588PF009	拖轮安装板组件/Mounting plate component	1
12	998I-12	9588PF029	盘形垫圈/Disc washer	1
13	998I-13	LM00033	大螺母M20X1/Nut M20	1
14	998I-14	LM00034	小螺母M20X1/Nut M20	1
15	998I-15	LM00017	螺母/Nut	1
16	998I-16	LD00268	螺钉M5X25/Screw M5	1
17	998I-17	LD00044	螺钉M5-10/Screw M5	2
18	998I-18	9588PF010	限位角支架/Limit Angle bracket	1
19	998I-19	9588PF027	皮带罩安装柱/Lnstall the column	1
20	998I-20	9588PF033	压紧轮扭簧/Pinch roller torsional spring	1
21	998I-21	9588PF030	扭簧轴销/Torsional spring shaft pin	1
22	998I-22	ZC00025	带挡边深沟球轴承7/14/Bearing	2
23	998I-23	LD00182	螺钉M4X6/Screw M4	1
24	998I-24	DQ00064	平垫圈4/Washer	1
25	998I-25	LD00116	螺钉M4-12/Screw M4	2
26	998I-26	9588PF025	连接块销/Connection piece pin	1
27	998I-27	9588PF028	小同步轮摆动连杆/Swinging rod	1
28	998I-28	TDQ00006	开口挡圈6/Open ring	1
29	998I-29	LD00003	紧定螺钉M6-6/Screw M6	1
30	998I-30	9588PF068	挡板安装柱/Lnstall the column	1
31	998I-31	LM00006	螺母M6/Nut M6	1
32	998I-32	LD00269	紧定螺钉M6X35/Screw M6	1
33	998I-33	9588PF019	压紧轮连杆/Pinch roller connecting rod	1
34	998I-34	9588PF017	压紧轮垫圈/Pinch roller washer	1
35	998I-35	9588PF016	压紧轮/Pinch roller	1
36	998I-36	9588PF018	压紧轮轴销/Pressure shaft pin	1
37	998I-37	DQ00065	平垫圈/Washer	1
38	998I-38	9588PF002	PF小同步轮/Small synchronous wheel	2
39	998I-39	9588PF022	小同步轮轴销/Shaft pin	1
40	998I-40	9588PF073	同步带210L/Synchronous belt	1
41	998I-41	9588PF070	小同步轮挡板/Baffle	1
42	998I-42	LD00271	螺钉M4-10/Screw M4	2

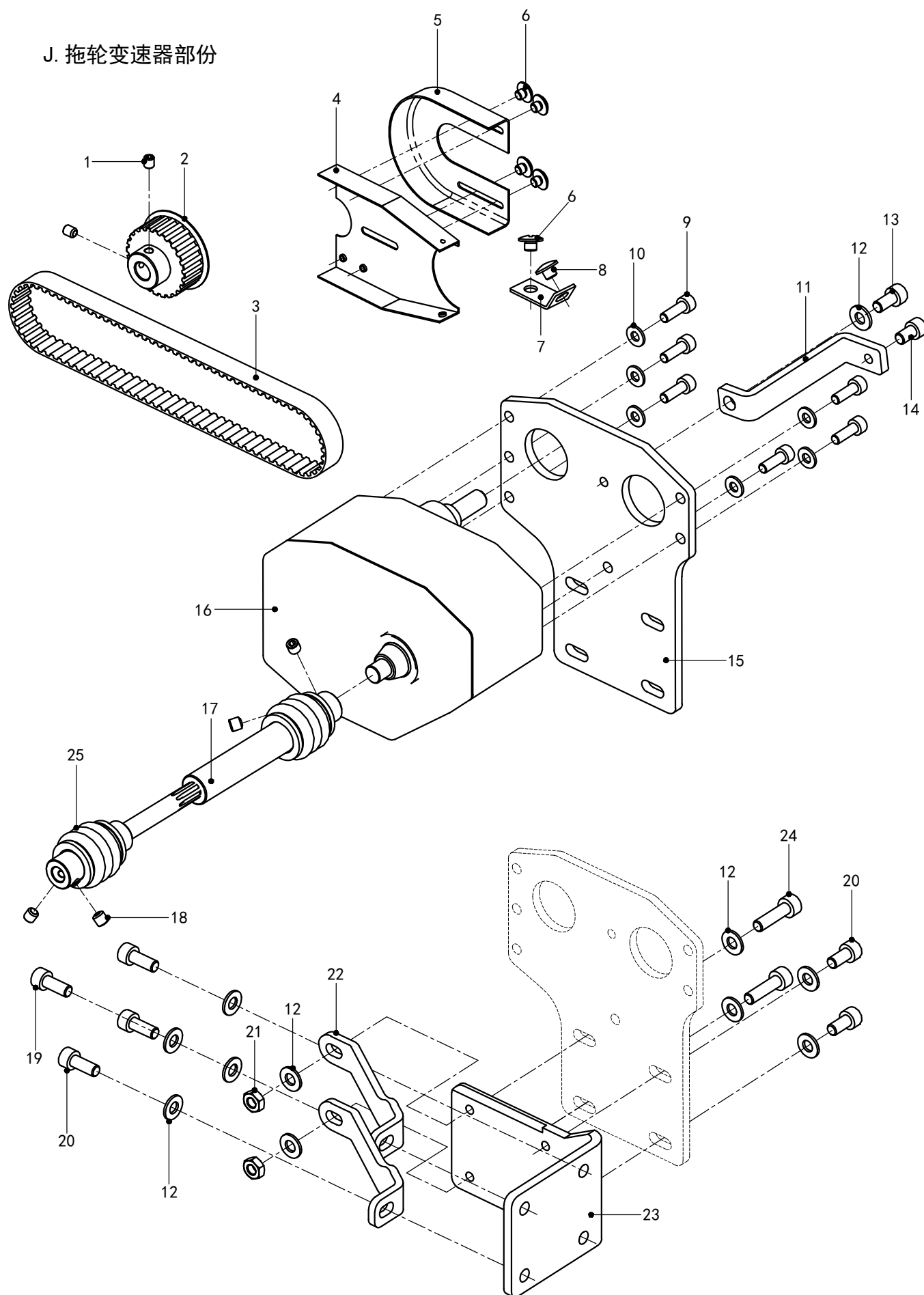
I. PF拖轮部份



I. PF拖轮部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
43	998I-43	9588PF071	拖轮罩壳/Tug housings	1
44	998I-44	9588PF052	轴位螺钉/Stalk bolt	1
45	998I-45	9588PF001	PF大同步轮/Large synchronous wheel	1
46	998I-46	LD00001	紧定螺钉M6-10/Screw M6	2
47	998I-47	LD00535	螺钉M6-14/Screw M6	4
48	998I-48	DQ00029	平垫圈6/Washer	4
49	998I-49	998A065	拖轮安装压板/Tugboat mounting press plate	1
50	998I-50	LD00092	螺钉M5-16/Screw M5	4
51	998I-51	DQ00034	平垫圈5/Washer	4
52	998I-52	998A027	拖轮安装角支架/Tugboat mounting bracket	1
53	998I-53	998A064	拖轮角支架/Tugboat angle bracket	1
54	998I-54	TH00037	气缸弹簧/Spring	1

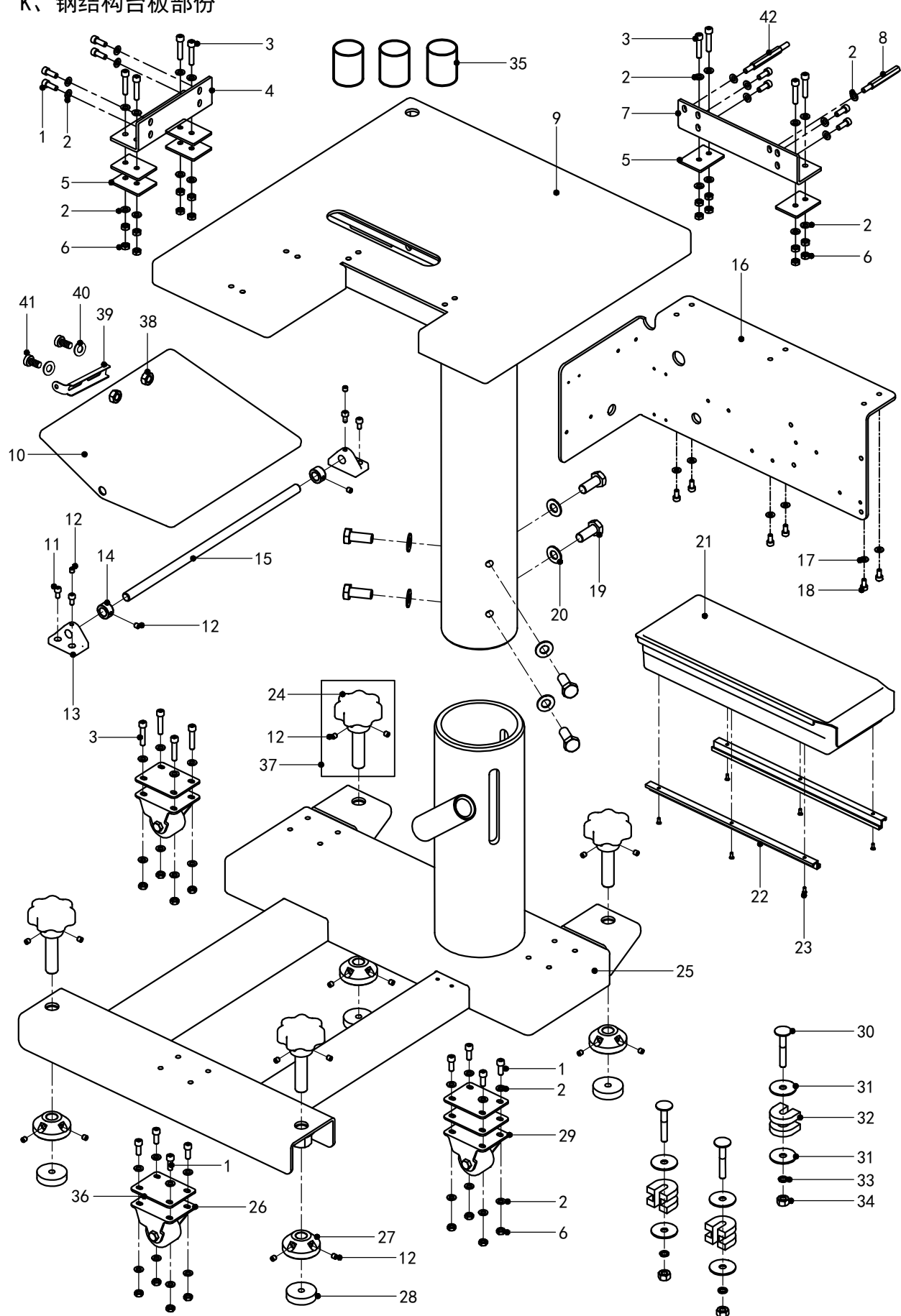
J. 拖轮变速器部份



J. 拖轮变速器部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	998J-1	LD00003	紧定螺钉M6-6/Screw M6	2
2	998J-2	998A210	同步轮组件/Timing Belt Wheel Assy	1
3	998J-3	998J024	同步带XL186/Synchronous belt	1
4	998J-4	998PF07102	同步带罩壳中段	1
5	998J-5	998PF071	同步带罩壳上段	1
6	998J-6	LD00381	螺钉M4-4/Screw M4	5
7	998J-7	998J021	安装支架	1
8	998J-8	LD00027	螺钉SM4. 76-8/Screw SM4. 76	1
9	998J-9	LD00267	螺钉M5-14/Screw M5	6
10	998J-10	DQ00034	平垫圈5/Washer	6
11	998J-11	998J022	皮带支架	1
12	998J-12	DQ00029	平垫圈6/Washer	11
13	998J-13	LD00355	螺钉M6-8/Screw M6	1
14	998J-14	LD00258	螺钉M5-8/Screw M5	1
15	998J-15	998A036	变速器安装板/Mounting Plate	1
16	998J-16	998PF2	变速箱/Gear Box	1
17	998J-17	998PF001	万向花键轴组件/UniversalSplineShaftAssembly	1
18	998J-18	LD00083	紧定螺钉M5-5/Screw M5	4
19	998J-19	LD00185	螺钉M6-16/Screw M6	2
20	998J-20	LD00316	螺钉M6-12/Screw M6	4
21	998J-21	LM00006	螺母M6/Nut M6	2
22	998J-22	998A133	支架加强条/Bracket reinforcing bar	2
23	998J-23	998A026	变速器安装角支架/Installation angle bracket	1
24	998J-24	LD00226	螺钉M6-20/Screw M6	2
25	998J-25	MA6-01	万向节护套/Protect a set	2

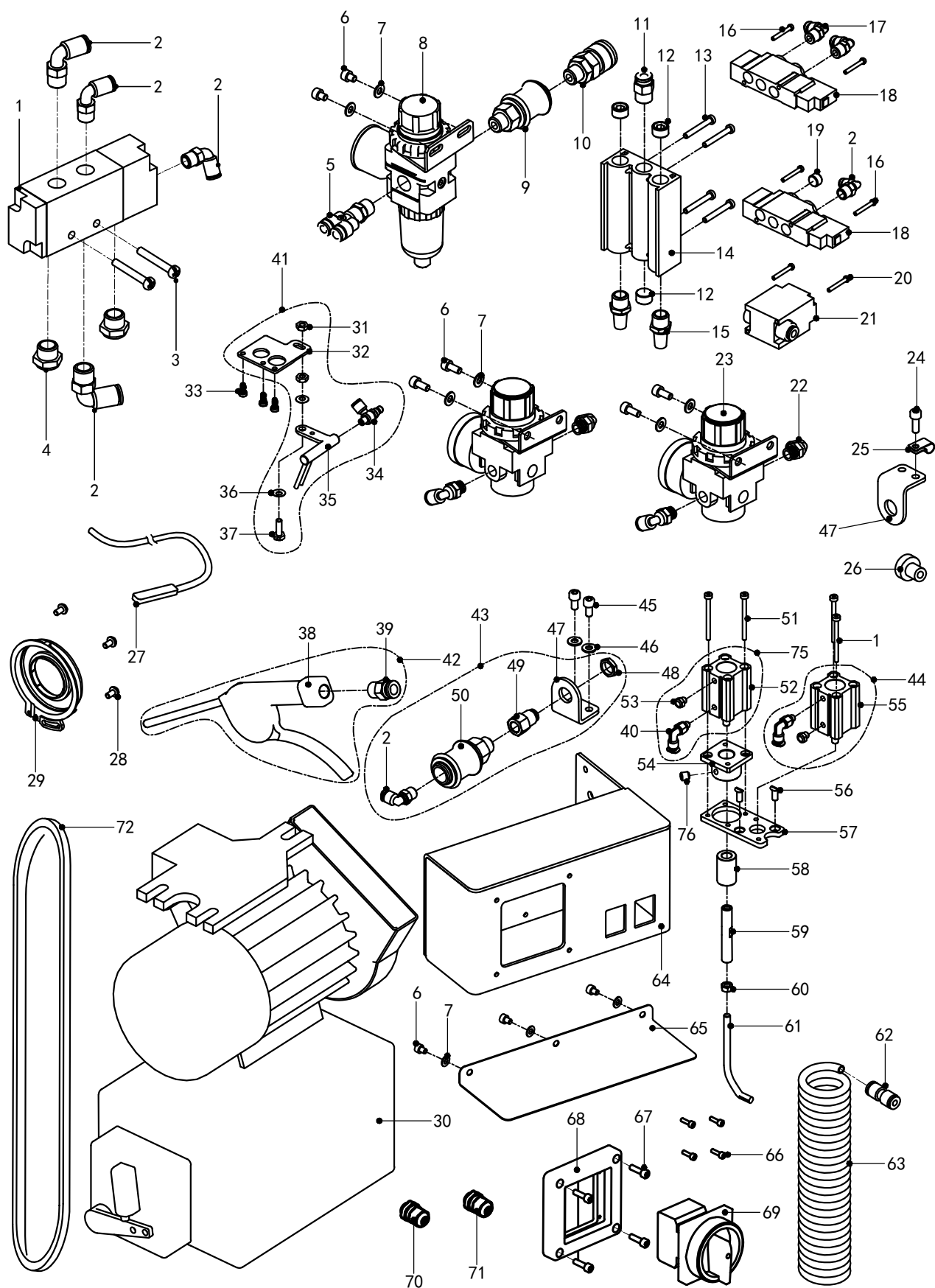
K、钢结构台板部份



K、钢结构台板部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	998K-1	LD00236	螺钉M6-14/Screw M6	16
2	998K-2	DQ00050	平垫圈/Washer	50
3	998K-3	LD00400	螺钉M6-30/Screw M6	12
4	998K-4	998A066	机架后固定角支架/Fixed Support	1
5	998K-5	927PA009	减震垫/Cushion Rubber	6
6	998K-6	LM00027	螺母M6/Nut M6	28
7	998K-7	998A067	机架侧固定角支架/Fixed Support	1
8	998K-8	998A052	皮带护罩六角螺杆/Screw arbor	1
9	998K-9	998TB00101	上台板/Board	1
10	998K-10	927TB031	脚踏板/Footstep	1
11	998K-11	LD00044	螺钉M5-10/Screw M5	4
12	998K-12	LD00003	紧定螺钉M6-6/Screw M6	20
13	998K-13	927TB033	踏板脚座/Footstep seat	2
14	998K-14	9588A124	挡圈/Stop collar	2
15	998K-15	927TB036	踏板轴/Footstep Shaft	1
16	998K-16	998A074	调压阀支架板/ Support plank	1
17	998K-17	DQ00052	平垫圈/Washer	6
18	998K-18	LD00233	螺钉M5-10/Screw M5	6
19	998K-19	LD00231	螺钉M12-30/Screw M12	6
20	998K-20	DQ00122	平垫圈/Washer	6
21	998K-21	998A150	工具箱/Tool box	1
22	998K-22	998A15001	工具箱滑轨/Tool box slippery track	2
23	998K-23	LD000342	螺钉SM3. 18-7/Screw SM3.18	6
24	998K-24	927TB045	调节法兰/Adjust Flange	4
25	998K-25	998TB00102	台板脚座/Bedplate feet	1
26	998K-26	927TB042	定轮/Calm wheel	2
27	998K-27	927TB051	脚座/Feet	4
28	998K-28	927TB004	橡胶垫/Rubber mat	4
29	998K-29	927TB040	动轮/Move wheel	1
30	998K-30	998K030	电机固定螺栓/Stud bolt	3
31	998K-31	DQ00048	平垫圈/Washer	6
32	998K-32	998K037	橡胶垫/Rubber mat	3
33	998K-33	DQ00057	弹性垫圈8/Flexibility washer	3
34	998K-34	LM00057	螺母M8/Nut M8	3
35	998K-35	927K010	橡皮块/Rubber piece	3
36	998K-36	927TB056	垫板/Pad	4
37	998K-37	927TB064	调节法兰组件/Adjusting flange assemblies	4
38	998K-38	LM00027	螺母M6/Nut M6	2
39	998K-39	998K036	拉杆片/Pull rod tablets	1
40	998K-40	DQ00050	平垫圈/Washer	2
41	998K-41	LD00238	内六角圆柱头螺钉/Screw M6×10	2
42	998K-42	998A05201	皮带护罩六角螺杆/Screw arbor	1

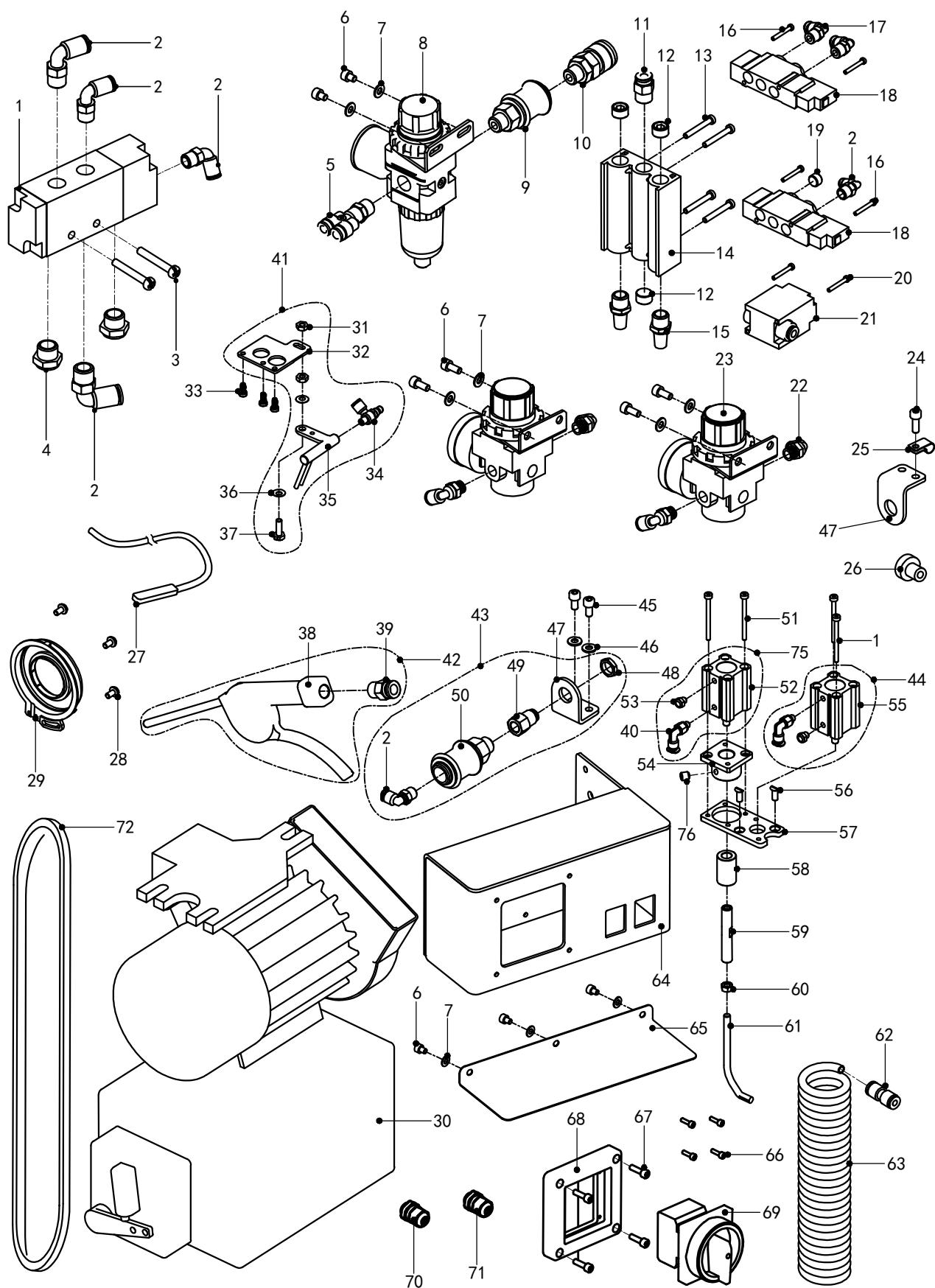
L、控制部份



L、控制部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	998L-1	927Q-3-03	气控阀/Valve	1
2	998L-2	927Q-2-28	L型接头PL0401C/“L”Connector PL0401C	6
3	998L-3	LD00318	内六角圆柱头螺钉M3X40/ Screw M3	2
4	998L-4	927Q-5-07	消声器BSLM01/Elimination machineBSLM01	2
5	998L-5	927Q-2-41	Y型螺纹三通APX6-02/“Y”transition connector	1
6	998L-6	LD00258	螺钉M5-8/Screw M5	9
7	998L-7	DQ00052	平垫圈/Washer	9
8	998L-8	927Q-4-08	空气洁净器/Air cleanness machine	1
9	998L-9	927Q-3-07	手滑阀HSV08/Valve HSV08	1
10	998L-10	927Q-2-31	快换接头SMD-20-ZN/Connector	1
11	998L-11	927Q-2-30	螺纹直通APC6-02/Thread keep APC6-02	1
12	998L-12	927PB012	堵头02/Block up	3
13	998L-13	LD00024	螺钉M4-30/Screw M4	4
14	998L-14	927Q-3-13	电磁阀底座/Valve base	1
15	998L-15	927Q-5-05	消声器BSL02/Elimination machineBSLM02	2
16	998L-16	998L016	螺钉/Screw	4
17	998L-17	927Q-2-27	L型接头PL0601C/“L”Connector PL0601C	1
18	998L-18	927Q-3-11	五通电磁阀/Five electromagnetism valve	2
19	998L-19	927PB018	堵头01/Block up	1
20	998L-20	998L020	螺钉/Screw	2
21	998L-21	927Q-3-12	二通电磁阀/Two electromagnetism valve	1
22	998L-22	927Q-2-53	L型接头PL04-G02C/“L”Connector PL04-G02C	4
23	998L-23	927Q-4-12	SMC减压阀	2
24	998L-24	LD00316	螺钉M6-12/Screw M6	1
25	998L-25	998L075	抱箍	1
26	998L-26	927TB057	线护套	1
27	998L-27	998A154	工作灯/Work light	1
28	998L-28	LD00230	垫片螺钉M4-5/Screw M4	3
29	998L-29	998L029	定位器/Fixed position machine	1
30	998L-30	I90C-4-BR-220-1	贺欣电机/Servo Electric motor	1
31	998L-31	LM00036	螺母SM4. 36/Nut SM4.36	2
32	998L-32	9588A164	冷却气嘴支架/Coding gas nozzle stents	1
33	998L-33	LD00275	螺钉SM3. 18/Screw SM3.18	3
34	998L-34	927Q-2-19	进气节流阀ASL4-M5B/Valve ASL6-M5B	1
35	998L-35	927P042	冷却气嘴/Air cock	1
36	998L-36	DQ00051	盘形垫片/Washer	2
37	998L-37	LD00274	螺钉SM4. 36/Screw SM4.36	1
38	998L-38	927Q-5-12	塑料气枪/Air rifle	1
39	998L-39	927Q-2-40	螺纹直通APC8-02/Thread keep APC8-02	1
40	998L-40	927Q-2-29	L型接头PL04M5C/“L”Connector PL04M5C	2
41	998L-41	9588A164ZJ	气嘴组件	1
42	998L-42	9688Q-ZJ-06	气枪组件	1

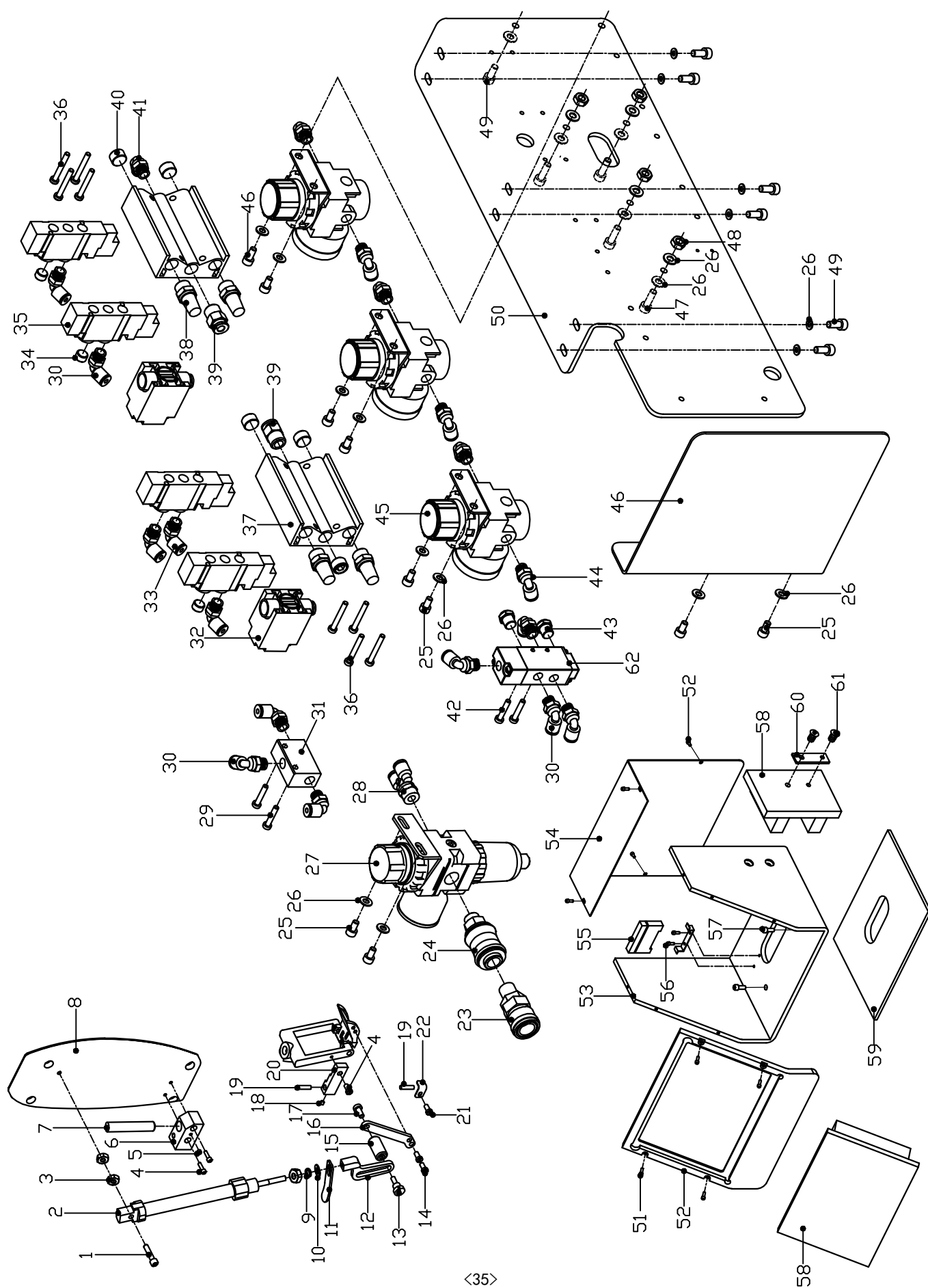
L、控制部份



L、控制部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
43	998L-43	9688Q-ZJ-07	手滑阀组件	1
44	998L-44	9688Q-ZJ-08	抬压脚气缸组件	1
45	998L-45	LD00094	螺钉M5-8/Screw M5	2
46	998L-46	DQ00034	平垫圈5/Washer	2
47	998L-47	9588A003	手滑阀固定支架/Valve fix	2
48	998L-48	LD00318	螺钉M3-40/Screw M3	2
49	998L-49	927Q-2-44	直通内牙接头/Thread Connector	1
50	998L-50	927Q-3-06	手滑阀HSV06/Valve HSV06	1
51	998L-51	LD00175	螺钉M3-45/Screw M3	2
52	998L-52	927Q.1.22	气缸/Cylinder	1
53	998L-53	927Q-5-08	V型消声器/Elimination machine	2
54	998L-54	998A047	抬压脚气缸安装座/Install plank	1
55	998L-55	927Q-1-23	气缸/Cylinder	1
56	998L-56	LD00148	螺钉SM4. 36/Screw SM4.36	2
57	998L-57	998A028	压杆气缸安装板/Install plank	1
58	998L-58	998L058	直线轴承/Bearing	1
59	998L-59	998A062	抬压脚连接轴/Conjunction stalk	1
60	998L-60	LM00042	螺母M5/Nut M5	1
61	998L-61	998A063	抬压脚连接杆/Conjunction pole	1
62	998L-62	927Q-2-11	减径直通APG8-6/Connector keep APG8-6	1
63	998L-63	927Q-5-16	螺旋气管UCS8/Windpipe UCS8	1
64	998L-64	998A172	开关安装支架/Switch mounting bracket	1
65	998L-65	998A173	开关支架盖板/Switch bracket cover plate	1
66	998L-66	LD00116	螺钉M4-12/Screw M4	4
67	998L-67	LD00250	螺钉M5-12/Screw M5	4
68	998L-68	927TB055	电源开关安装板/Mounting plate	1
69	998L-69	927TB013	电源开关/Switch	1
70	998L-70	998L073	线护套PG9/Line sheath PG9	2
71	998L-71	998L074	线护套PG7/Line sheath PG7	1
72	998L-72	998A152-01	O型带/ O type band	1
73	998L-73	9688Q-ZJ-09	压杆气缸组件	1
74	998L-74	LD00004	紧定螺钉M4-4/Screw M4	1

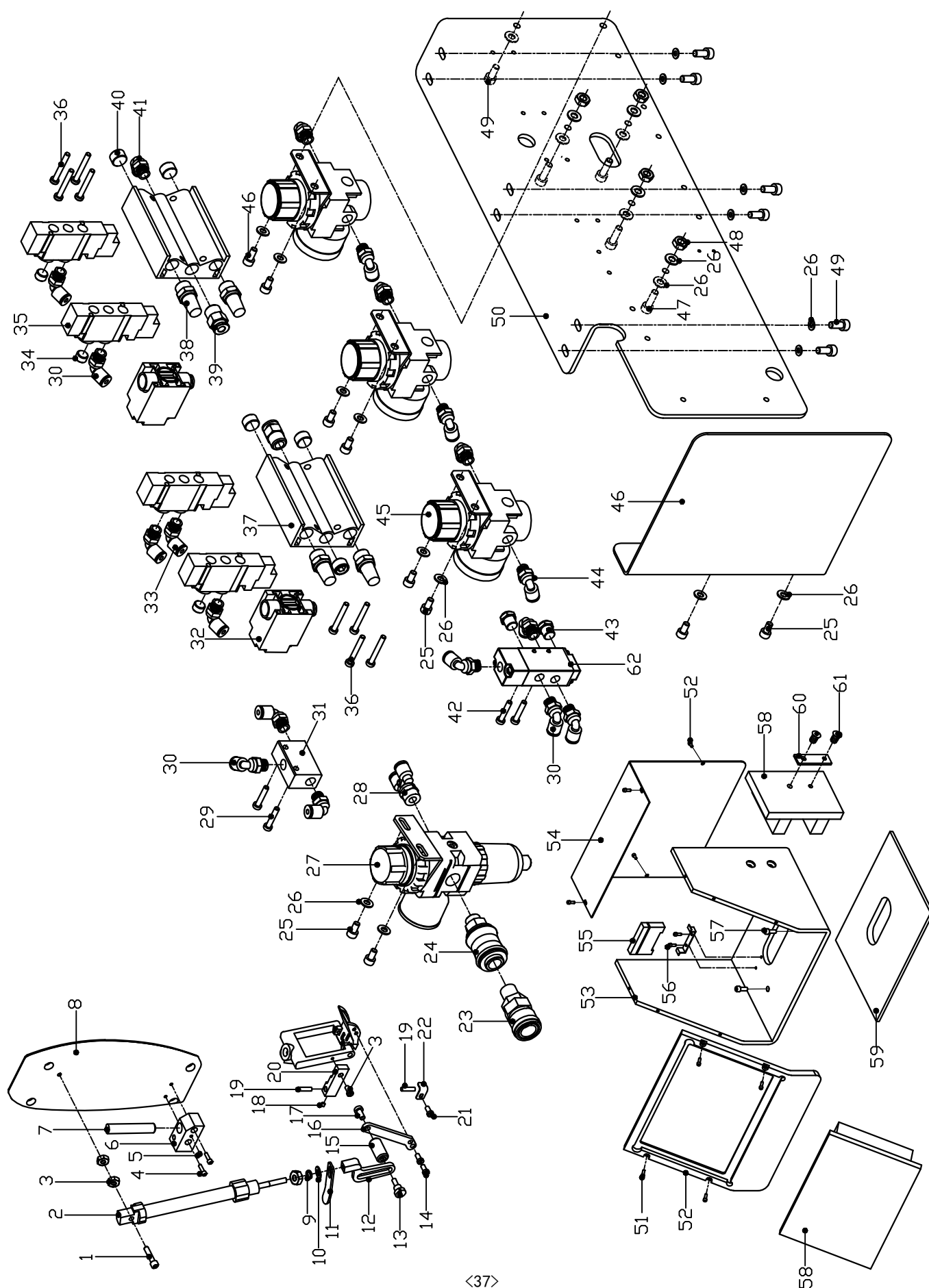
M、增压部份



M、增压部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	998M-1	LD00254	螺钉M4-25/Screw M4	1
2	998M-2	927Q-1-47	笔形气缸	1
3	998M-3	LM00014	螺母M3/Nut M3	2
4	998M-4	LD00256	螺钉M3-16/Screw M3	3
5	998M-5	LD00040	螺钉M3-3/Screw M3	1
6	998M-6	998P032	气缸感应器支架	1
7	998M-7	927EC-1-01	接近开关	2
8	998M-8	998A029	端面盖/Face Plate	1
9	998M-9	DQ00070	弹簧垫片4	1
10	998M-10	DQ00054	垫片4	1
11	998M-11	998P025-1	感应器挡片	1
12	998M-12	998P023-1	调节曲柄	1
13	998M-13	998P037	轴位螺钉M4/Screw M4	1
14	998M-14	LD00263	一字圆柱头螺钉SM3. 18-6	2
15	998M-15	998P024-1	螺纹连接套	1
16	998M-16	998P013-1	压脚上压杆	1
17	998M-17	LD00104	内六角圆柱头螺钉/Screw M4×8	1
18	998M-18	LD00289	内六角紧定螺钉SM3. 18-3. 2	1
19	998M-19	927EC-1-04	光纤头	2
20	998M-20	998P030	感应器上支架	1
21	998M-21	LD00085	一字球面圆柱头螺钉SM3. 18-3. 2	1
22	998M-22	998P031	感应器下支架	1
23	998M-23	927Q-2-31	快换接头SMD-20-ZN/Connector	1
24	998M-24	927Q-3-07	手滑阀HSV08/Valve HSV08	1
25	998M-25	LD00258	螺钉M5-8/Screw M5	22
26	998M-26	DQ00052	平垫圈/Washer	33
27	998M-27	927Q-4-08	空气洁净器/Air cleanness machine	1
28	998M-28	927Q-2-41	Y型螺纹三通APX6-02/“Y”transition connector	1
29	998M-29	LD00404	螺钉M4-22/Screw M4	2
30	998M-30	927Q-2-28	L型接头/L joint APL4-01	12
31	998M-31	J12-17	膝提三通阀/Knee lift three way valve	1
32	998M-32	927Q-3-12	二通电磁阀/Two electromagnetism valve	2
33	998M-33	927Q-2-27	L型接头PL0601C/“L”Connector PL0601C	1
34	998M-34	927PB018	堵头01/Block up	3
35	998M-35	927Q-3-11	五通电磁阀/Five electromagnetism valve	4
36	998M-36	LD00024	螺钉M4-30/Screw M4	6
37	998M-37	927Q-3-13	电磁阀底座/Valve base	1
38	998M-38	927Q-5-05	消声器BSL02/Elimination machineBSLM02	4
39	998M-39	927Q-2-30	螺纹直通APC6-02/Thread keep APC6-02	2
40	998M-40	927PB012	堵头02/Block up	5
41	998M-41	927Q-2-05	L型接头/L joint APL6-02	1
42	998M-42	LD00241	螺钉M3-22/Screw M3	2

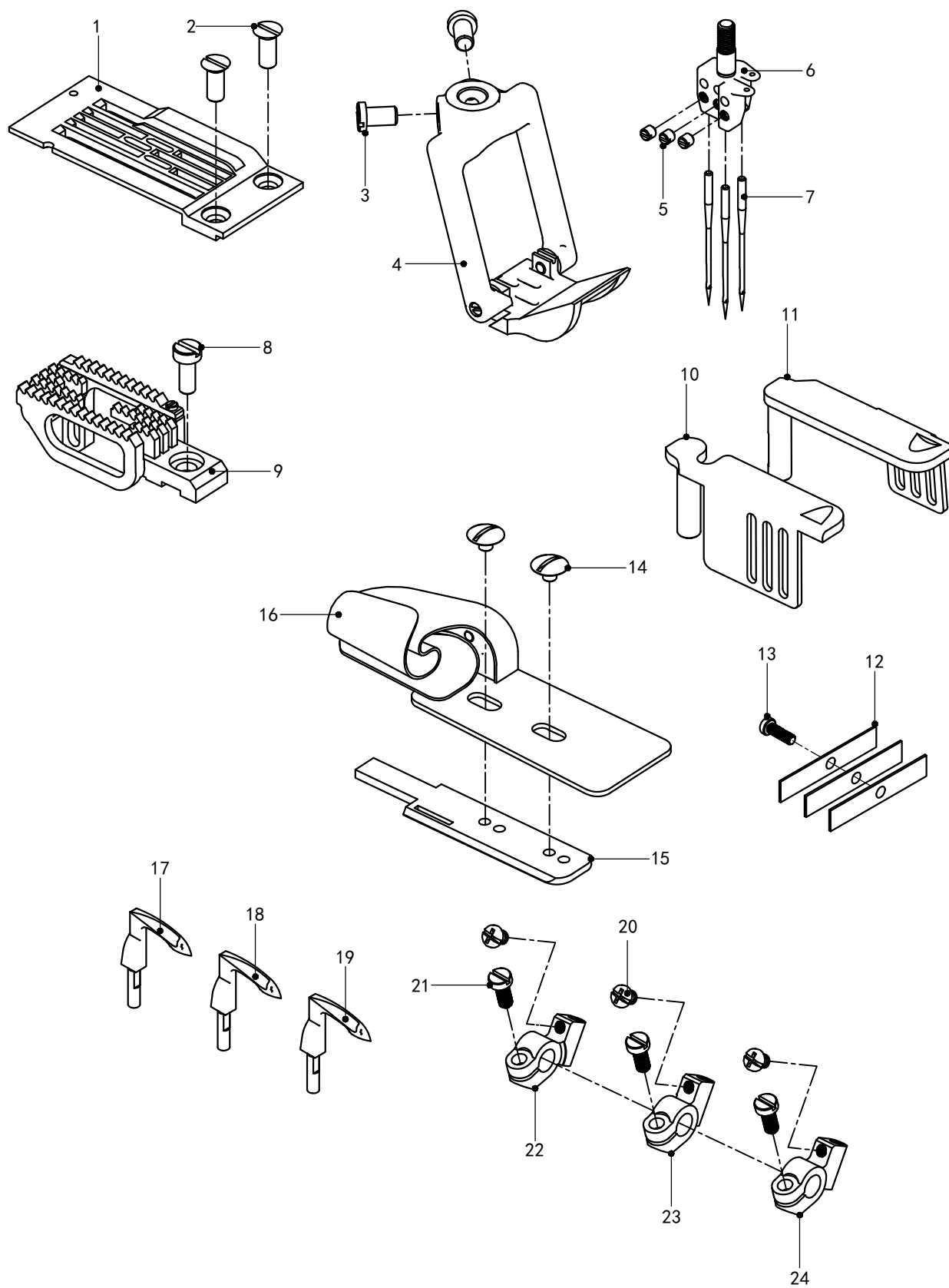
M、增压部份



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序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
43	998M-43	927Q-5-07	消声器BSLM01/Elimination machineBSL01	2
44	998M-44	927Q-2-53	L型接头PL04-G02C/“L”Connector PL04-G02C	8
45	998M-45	927Q-4-12	SMC减压阀	3
46	998M-46	998P018	气阀挡板	1
47	998M-47	LD00267	螺钉M5-14/Screw M5	4
48	998M-48	LM00042	螺母M5/Nut M5	4
49	998M-49	LD00233	螺钉M5-10/Screw M5	6
50	998M-50	998P016	气阀安装板	1
51	998M-51	LD00235	螺钉M3-8/Screw M3	8
52	998M-52	998P027-1	显示器面板	1
53	998M-53	998P027-2	显示器支架	1
54	998M-54	998P028	后盖板	1
55	998M-55	927EC-1-03	光纤放大器	1
56	998M-56	LD00293	螺钉M3-5/Screw M3	2
57	998M-57	LD00267	螺钉M5-14/Screw M5	2
58	998M-58	927EC-2-01	控制器整套	1
59	998M-59	998P029	显示器支架垫	1
60	998M-60	998A214	垫块	1
61	998M-61	LD00544	内六角沉头螺钉/Screw M5×12	2
62	998M-62	927Q-3-03	气控阀4A110-06/PF-12	2

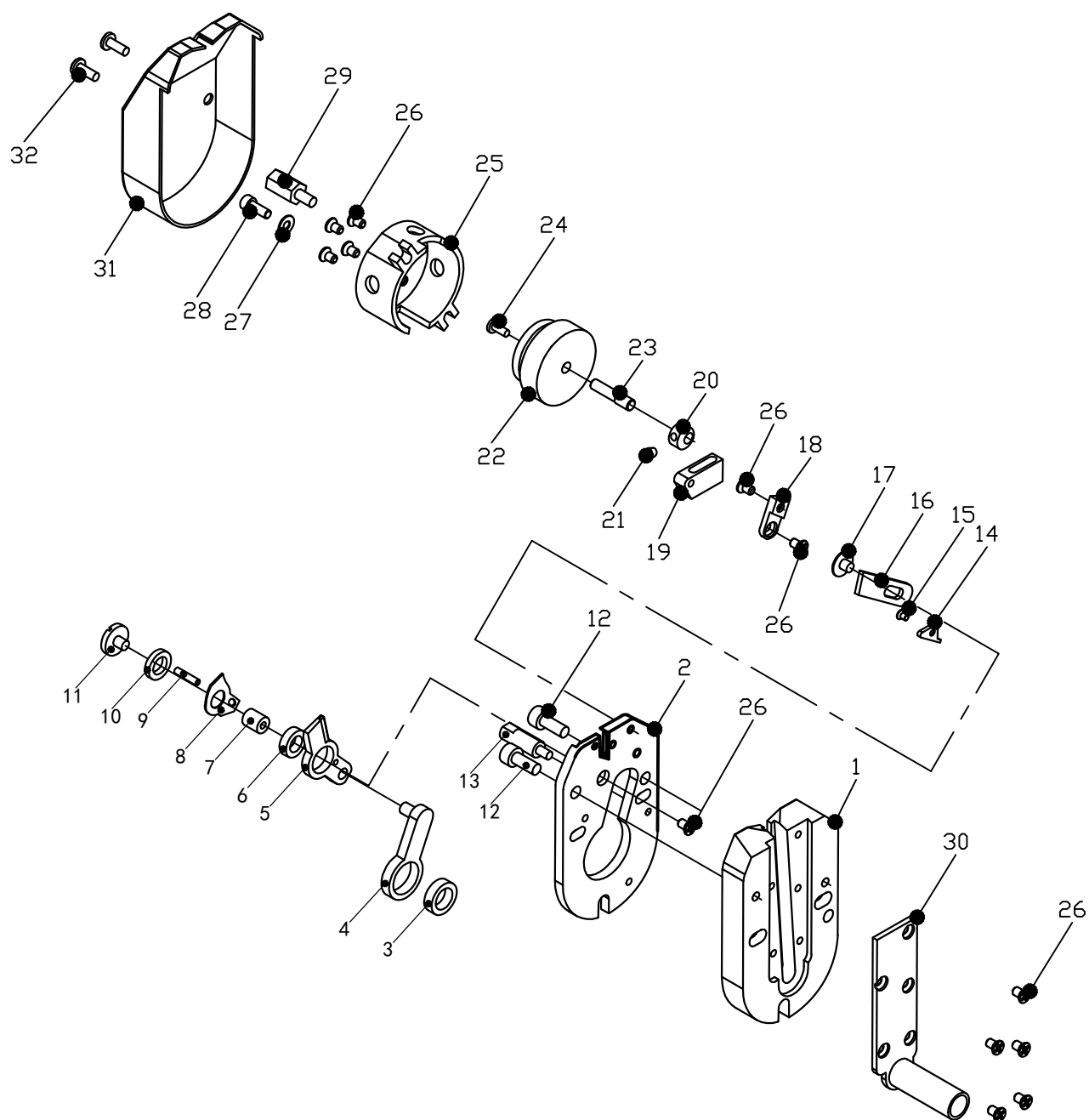
N、针位配件部份



N、针位配件部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	998N-1	998A085	针板	1
2	998N-2	LD00148	螺钉SM4.36-11/Screw SM4.36	2
3	998N-3	LD00305	螺钉SM4.76-7/Screw SM4.76	2
4	998N-4	998PLYJ104XH	过骨位压脚组件	1
5	998N-5	LD00142	紧定螺钉SM3.18/Screw SM3.18	3
6	998N-6	928ZJ104H	针夹	1
7	998N-7	BZ1-9	机针/Needle	1
8	998N-8	LD00147	螺钉SM4.76-8/Screw SM4.36	1
9	998N-9	998A09101	牙齿	1
10	998N-10	998A093	弯针左护罩/Looper Cover, Ra	1
11	998N-11	998A094	弯针右护罩/Looper Cover, La	1
12	998N-12	928SPL026	护罩弹簧片/Leaf Spring	3
13	998N-13	LD00191	螺钉SM3.57-6/Screw SM3.57	1
14	998N-14	LD00176	螺钉SM3.57/Screw SM3.57	2
15	998N-15	998A130	卷边器滑块/Lapper Guide Plate	1
16	998N-16	928PLJB104XH	卷边筒	1
17	998N-17	928WZS40375X	挑线叉(弯针)	1
18	998N-18	928WZS40376X	挑线叉(弯针)	1
19	998N-19	928WZS40377X	挑线叉(弯针)	1
20	998N-20	LD00160	螺钉SM3.57/Screw SM3.57	3
21	998N-21	LD00145	螺钉SM3.57/Screw SM3.57	3
22	998N-22	928G048	弯针座L/Looper Holder, L	1
23	998N-23	928G049	弯针座M/Looper Holder, M	1
24	998N-24	928G050	弯针座R/Looper Holder, R	1

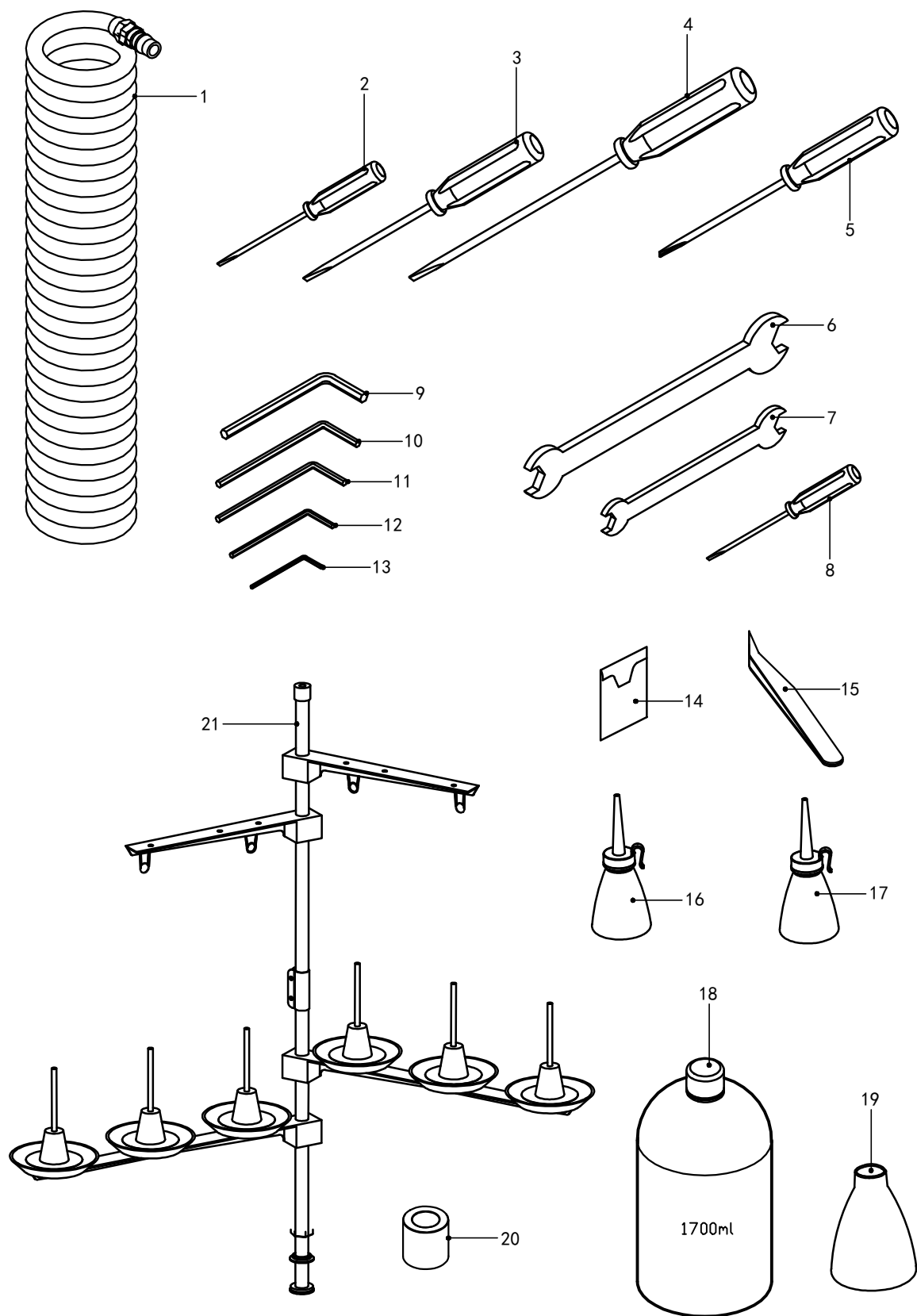
0、DCV电动剪刀组件



0、DCV电动剪刀组件

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	998□-1	998CV001	剪刀固定底板	1
2	998□-2	998CV002	电动剪刀底板	1
3	998□-3	ZC00066	动刀连杆轴承(内8外12厚3.5)	1
4	998□-4	998CV003	动刀连杆	1
5	998□-5	998CV004	电动剪刀动刀	1
6	998□-6	ZC00067	动刀轴承(内6外10厚3)	1
7	998□-7	998CV005	动刀定位轴	1
8	998□-8	998CV006	动刀加压片	1
9	998□-9	J02-011	弹簧销	1
10	998□-10	998CV007	增压垫	1
11	998□-11	LD00638	M3*4一字圆柱头(大圆头)	1
12	998□-12	LD00026	M4*10内六角圆柱头	1
13	998□-13	998CV014	底板固定螺钉	1
14	998□-14	998CV008	剪刀槽挡线块	1
15	998□-15	LD00639	M2*3十字沉头	1
16	998□-16	998CV009	电动剪刀定刀	1
17	998□-17	LD00176	一字球面螺钉	1
18	998□-18	998CV010	剪刀油盒固定板	1
19	998□-19	998CV011	剪刀油盒	1
20	998□-20	998CV012	剪刀偏心轮	1
21	998□-21	LD00040	M3*3内六角紧定	1
22	998□-22	998CV019	剪刀电机	1
23	998□-23	998CV018	电机轴	1
24	998□-24	XXXXXX	十字圆头螺钉 (M2.5×6)	1
25	998□-25	998CV013	转子固定支架	1
26	998□-26	LD00641	M3*5十字沉头	12
27	998□-27	DQ00055	Φ3平垫片	1
28	998□-28	LD00456	内六角圆柱头螺钉M3×8	1
29	998□-29	998CV015	六角支柱	1
30	998□-30	998CV017	压板组件	1
31	998□-31	998CV016	剪刀罩壳	1
32	998□-32	LD00640	M3*8内六角半圆头	2

P、附件部份



P、附件部份

序号/NO	代号/Assemble NO	件号/Part NO	名称/Description	数量/Num
1	998P-1	927PA035	气管/The trachea	1
2	998P-2	9588F J07	小号螺丝刀/ScrewDriver(small)	1
3	998P-3	9588F J06	中号螺丝刀/ScrewDriver(medium)	1
4	998P-4	9588F J05	大号螺丝刀/ScrewDriver(large)	1
5	998P-5	9588F J08	十字螺丝刀/ScrewDriver	1
6	998P-6	F J4-3-1	17-19开口扳手/17-19 Spanner	1
7	998P-7	9588F J02	8-10开口扳手/8-10 Spanner	1
8	998P-8	F J8-5	一字螺丝刀/ScrewDriver	1
9	998P-9	927K011	5mm内六角扳手/5mm Allen Key	1
10	998P-10	927K012	4mm内六角扳手/4mm Allen Key	1
11	998P-11	927K013	3mm内六角扳手/3mm Allen Key	1
12	998P-12	927K014	2.5mm内六角扳手/2.5mm Allen Key	1
13	998P-13	927K015	2mm内六角扳手/2mm Allen Key	1
14	998P-14	BZ1-9	机针/Needle	1
15	998P-15	9588F J04	镊子/Thread Tweezers	1
16	998P-16	998□016	硅油壶/Oiler	1
17	998P-17	F J7-28	小油壶/Oiler	1
18	998P-18	998□018	大油壶/Oiler	1
19	998P-19	998A171	加油漏斗/Encourage funnel	1
20	998P-20	9588A120	线架套管/Line set tube	1
21	998P-21	F J4-19	线架组件/Line module	1