



大森缝纫机

Products Manual 产品说明书

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5810D

电脑自动剪线 / 自动供加油
高台缝纫一体机

COMPUTERISED&MECHATRONICAL POSTBED MACHINE
(AUTO THREAD-CUTTING/AUTO LUBRICATION)

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主要技术参数表

Main Technical Specification

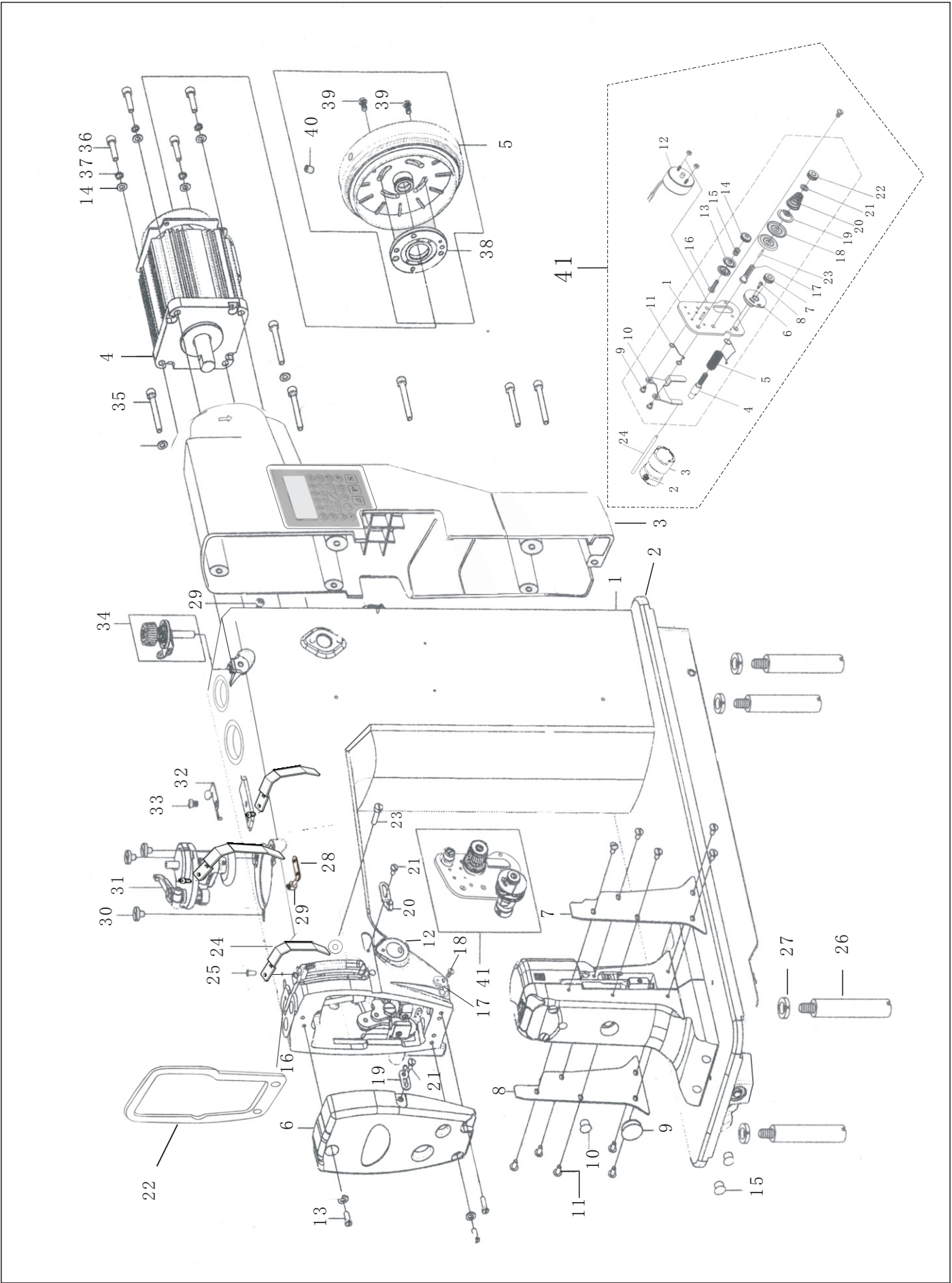
型 号 Model	5810D
适 用 范 围 Application	中厚料 厚料 Medium Heavy Materials
最 高 缝 速 Max Speed	2 5 0 0针 / 分 2500steps / min
针 距 Stitch Lenght	0-5毫米 0-5mm
压脚提升高度 Lift of Presser Foot	手动6.5毫米 膝控10毫米 6.5mm by hand / 16mm by knee
采用机针 Needle	DPX5 12-21# DPX5 12-21#
电 机 功 率 Power Of Motor	0 . 7千 瓦 0.7KM
针 间 距 Needle Gauge Set	标配 : 1.6毫米 Standard:1.6mm

零件配件
PARTS BOOK

一、机头部分 MACHINE HEAD ASSEMBLIES

序号 Ref. No.	编号 Part No.	名称 Part Name	数量 Qty	备注 Remarks
1	1-1	机头	1	
2	1-2	底板	1	
3	1-3	电机罩	1	
4	1-4	直驱电机	1	
5	1-5	手轮	1	
6	1-6	面盖板	1	
7	1-7	旋梭前盖板	1	
8	1-8	旋梭后盖板	1	
9	1-9	胶塞	1	
10	1-10	胶塞	1	
11	1-11	螺钉	10	M4×8
12	1-12	夹线器固定螺丝	1	SM15/64 # ×28L=7
13	1-13	面盖板螺丝	3	SM11/64 # ×40L=10
14	1-14	平垫片	4	
15	1-15	胶塞	2	
16	1-16	胶塞	1	
17	1-17	线挂	1	
18	1-18	螺钉	1	
19	1-19	左线勾	1	
20	1-20	右线勾	1	
21	1-21	螺丝	2	SM9/64 # ×40L=7
22	1-22	防油垫	1	
23	1-23	夹线器固定螺钉	1	SM11/64 # ×40L=13
24	1-24	挑线杆护罩	1	
25	1-25	螺钉	1	SM11/64 # ×40L=8
26	1-26	螺柱	4	
27	1-27	弹簧垫	4	
28	1-28	两眼线勾	1	
29	1-29	螺钉	2	SM11/64 # ×40L=6
30	1-30	绕线器螺钉	3	M5
31	1-31	绕线器组件	1	
32	1-32	割线刀	1	
33	1-33	螺钉	2	SM9/64 # ×40L=6十字盘头
34	1-34	绕线夹线器组件	1	
35	1-35	螺钉	5	M5×40 圆柱头内六角 hexagonal socket head cap screw
36	1-36	螺钉	4	M5×20 圆柱头内六角 hexagonal socket head cap screw
37	1-37	弹性垫圈	4	
38	1-38	码盘	1	
39	1-39	螺钉	2	M5×9 盘头螺钉 Pan head screw
40	1-40	螺钉	2	M6×8 无头内六角 hwexagon socket headless screw
41	1-41	夹线器组件	1	
42	1-41-1	夹线器固定板	1	fixing plate for thread tension asm.
43	1-41-2	夹线器调节座	1	adjusting holder for thread tension asm.
44	1-41-3	螺钉	1	
45	1-41-4	挑线簧轴	1	axis of thread take-up srping

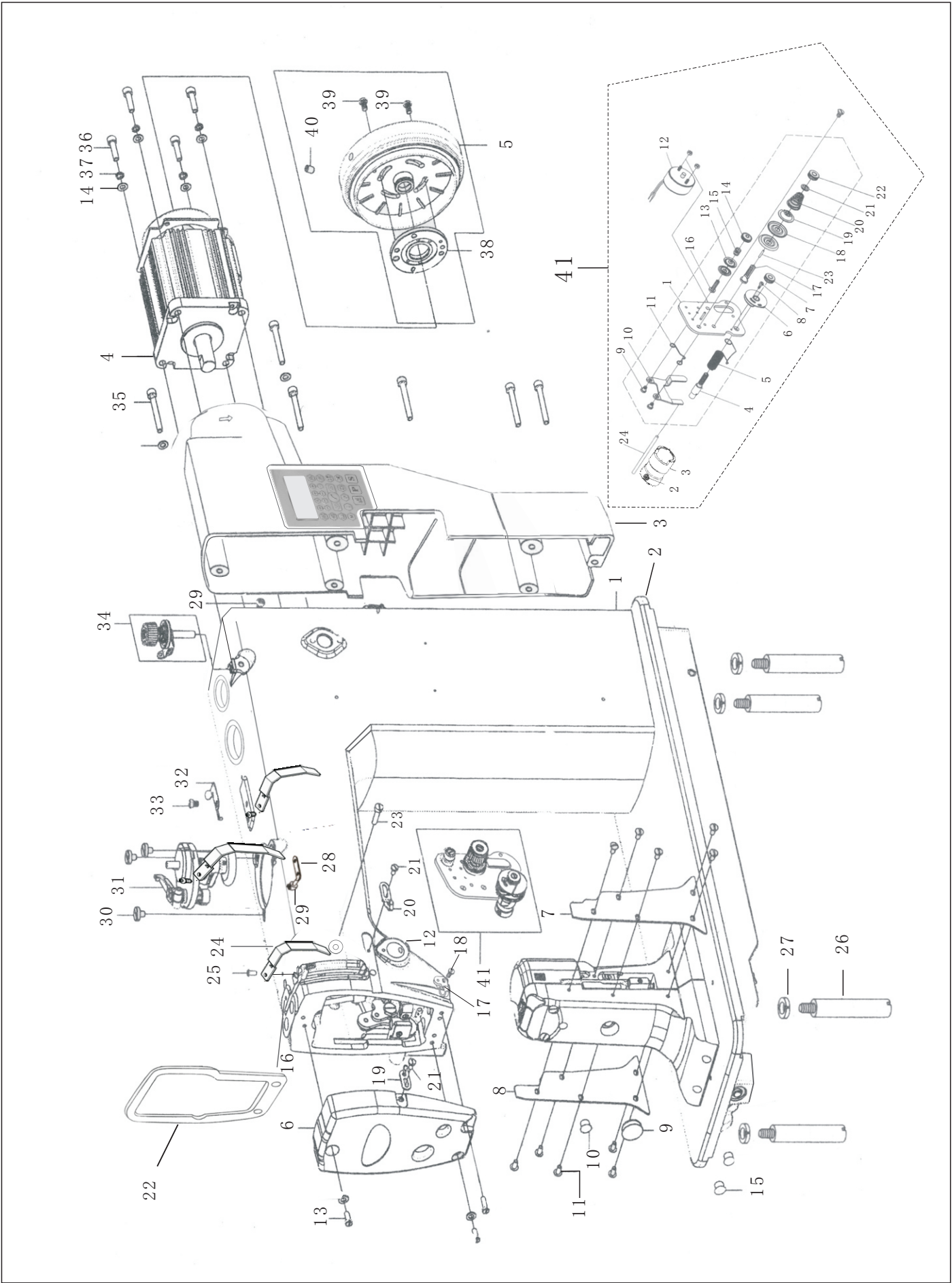
一、机头部分 MACHINE HEAD ASSEMBLIES



一、机头部分 MACHINE HEAD ASSEMBLIES

序号 Ref. No.	编号 Part No.	名称 Part Name	数量 Qty	备注 Remarks
1	1-41-5	挑线簧	1	
2	1-41-6	过线板	2	
3	1-41-7	调节螺母	2	
4	1-41-8	螺钉	1	
5	1-41-9	螺钉	2	
6	1-41-10	松线板	1	
7	1-41-11	松线板复位簧	1	
8	1-41-12	松线电磁阀	2	
9	1-41-13	压线盘	4	
10	1-41-14	线调整压盘	2	
11	1-41-15	弹簧	2	
12	1-41-16	螺钉	2	
13	1-41-17	定心轴	2	
14	1-41-18	夹线板	4	
15	1-41-19	压力调整器压盘	2	
16	1-41-20	调压簧	2	
17	1-41-21	夹线止动板	2	
18	1-41-22	调节螺母	2	
19	1-41-23	销	2	
20	1-41-24	松线销	1	

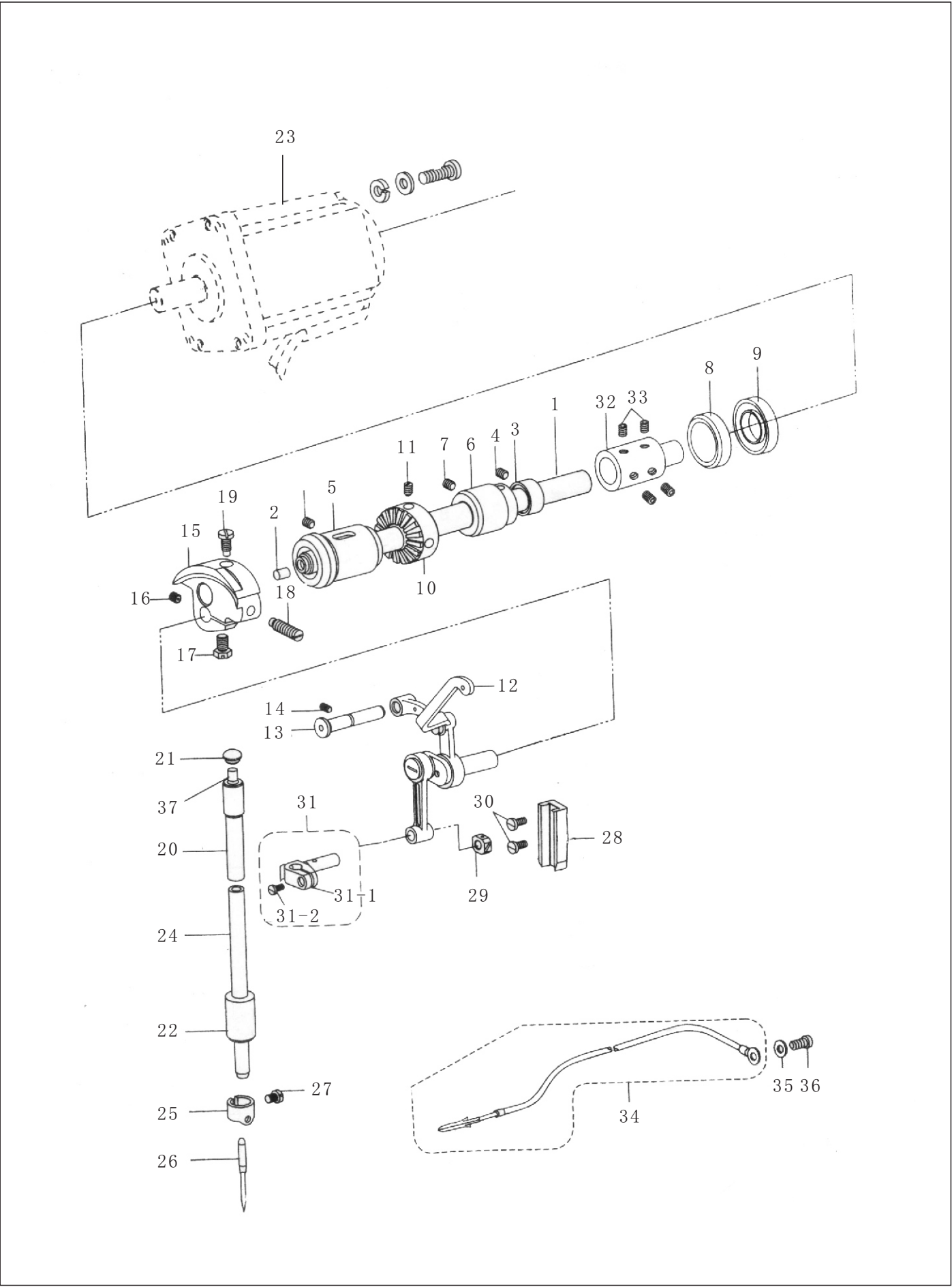
一、机头部分 MACHINE HEAD ASSEMBLIES



二、针杆挑线部件 NEEDLE BAR THREAD TAKE-UP COMPONENTS

序号 Ref. No.	编号 Part No.	名称 Part Name	数量 Qty	备注 Remarks
1	1-1	上轴	1	
2	1-2	上轴橡皮圈	1	
3	1-3	上轴紧圈	1	
4	1-4	上轴紧圈螺钉	2	SM1/4"×40L=6
5	1-5	上轴前轴套	1	
6	1-6	上轴中轴套	1	
7	1-7	上轴中轴套螺钉	1	SM15/64"×28L=7
8	1-8	上轴后轴承	1	Φ20×Φ64×42×12
9	1-9	上轴后油封组件	1	
10	1-10	绕线器摩擦轮	1	
11	1-11	摩擦轮螺钉	2	
12	1-12	挑线杆组件	1	
13	1-13	挑线连杆铰链轴	1	
14	1-14	挑线连杆铰链轴螺钉	2	SM15/64"×28L=7
15	1-15	针杆曲柄	1	
16	1-16	挑线曲柄螺钉	1	SM1/4"×40L=6
17	1-17	挑线曲柄定位螺钉	1	SM1/4"×40L=6
18	1-18	针杆曲柄螺钉	1	SM9/32"×28L=21
19	1-19	针杆曲柄定位螺钉	1	SM9/32"×28L=12.5
20	1-20	针杆上轴套	1	
21	1-21	针杆上轴套橡皮塞 (Φ8.8)	1	
22	1-22	针杆下轴套	1	
23	1-23	电机	1	
24	1-24	针杆	1	
25	1-25	针杆过线环	1	
26	1-26	机针	1	Dp×5 16#
27	1-27	夹针螺钉	1	
28	1-28	滑块槽	1	
29	1-29	针杆接头滑块	1	
30	1-30	滑块导轨螺钉	2	
31	1-31	针杆接头组件	1	
32	1-31-1	针杆接头	1	
33	1-31-2	针杆接头螺钉	1	
34	1-32	联轴器	1	
35	1-33	联轴器螺钉	4	
36	1-34	地线组件	1	
37	1-35	垫片	1	
38	1-36	地线螺钉	1	

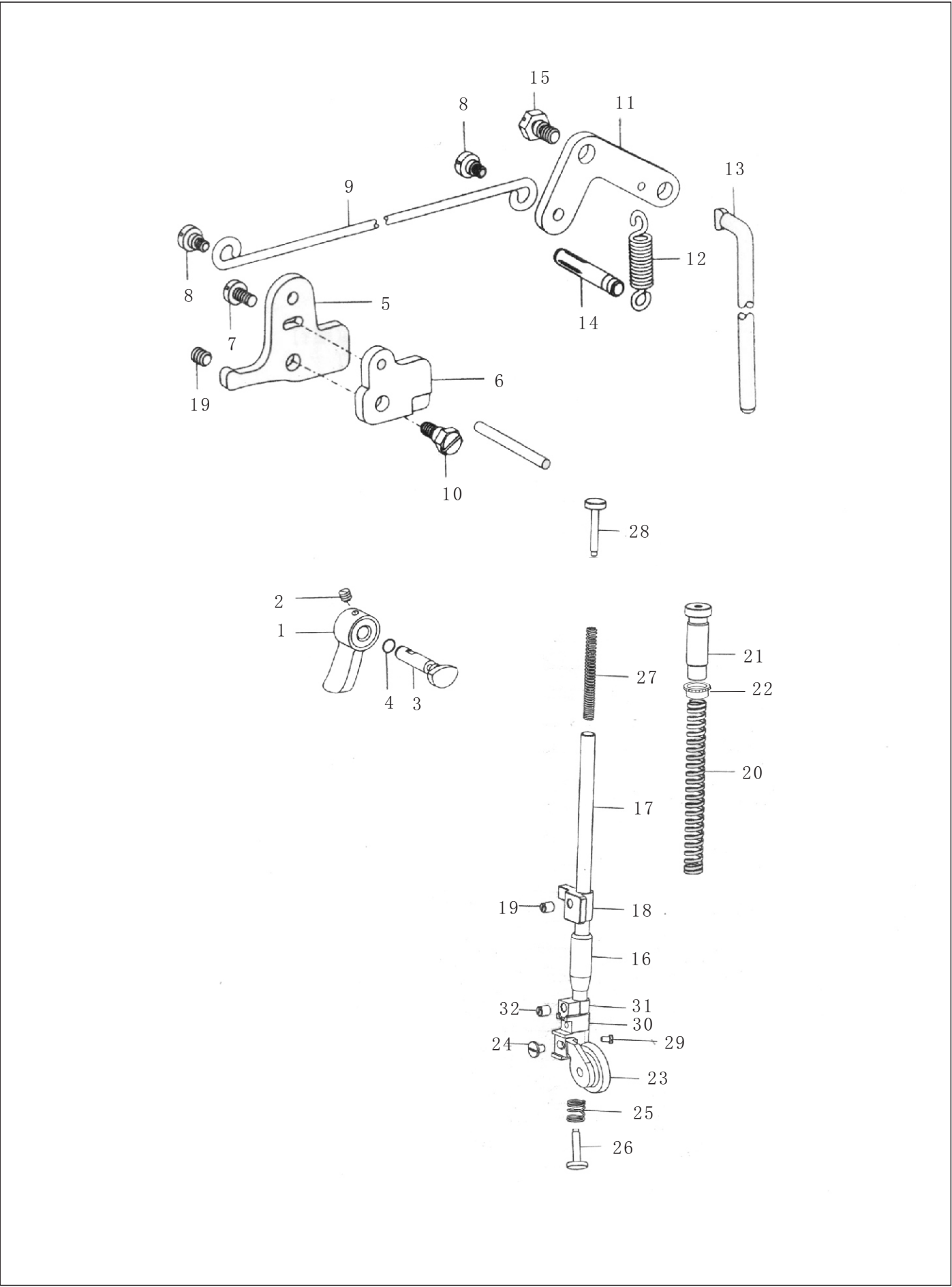
二、针杆挑线部件 NEEDLE BAR THREAD TAKE-UP COMPONENTS



三、压脚部件 PRESSER FOOT ASSEMBLIES

序号 Ref. No.	编号 Part No.	名称 Part Name	数量 Qty	备注 Remarks
1	1-1	压脚扳手	1	
2	1-2	压脚扳手螺钉	1	SM11/64"×40L=6.5
3	1-3	压紧杆提升凸轮	1	
4	1-4	压紧杆提升凸轮油封	1	Gb3452.1 4.5×1.8G
5	1-5	膝控提升杠杆（左）	1	
6	1-6	松线凸轮	1	
7	1-7	膝控提升杠杆（左）螺钉	1	SM11/64"×40L=6
8	1-8	铰链螺钉	2	SM3/16"×28
9	1-9	膝控提升杠杆	1	
10	1-10	松线凸轮螺钉	1	SM15/64"×28
11	1-11	膝控提升杠杆（右）	1	
12	1-12	膝控提升杠杆（右）弹簧	1	
13	1-13	膝控提升连杆	1	
14	1-14	弹簧销	1	
15	1-15	膝控提升杠杆（右）螺钉	1	SM15/64"×28
16	1-16	压紧杆轴套	1	
17	1-17	压紧杆	1	
18	1-18	压紧杆导架	1	
19	1-19	压紧杆导架螺钉	1	SM15/64"×28L=7
20	1-20	压紧杆弹簧	1	
21	1-21	调压螺钉	1	
22	1-22	调压螺钉锁紧螺母	1	
23	1-23	轮钱组	1	
24	1-24	轮钱固定螺钉	1	SM11/64"×40L=65
25	1-25	弹簧	1	
26	1-26	固定销	1	
27	1-27	（小）压紧杆弹簧	1	
28	1-28	小压脚螺钉垫片	1	
29	1-30	销固定螺钉	2	SM1/8"×44L=5
30	1-30	轮钱固定座	1	
31	1-31	轮钱固定座止座	1	
32	1-32	轮钱固定座螺钉	1	SM15/64"×28L=7

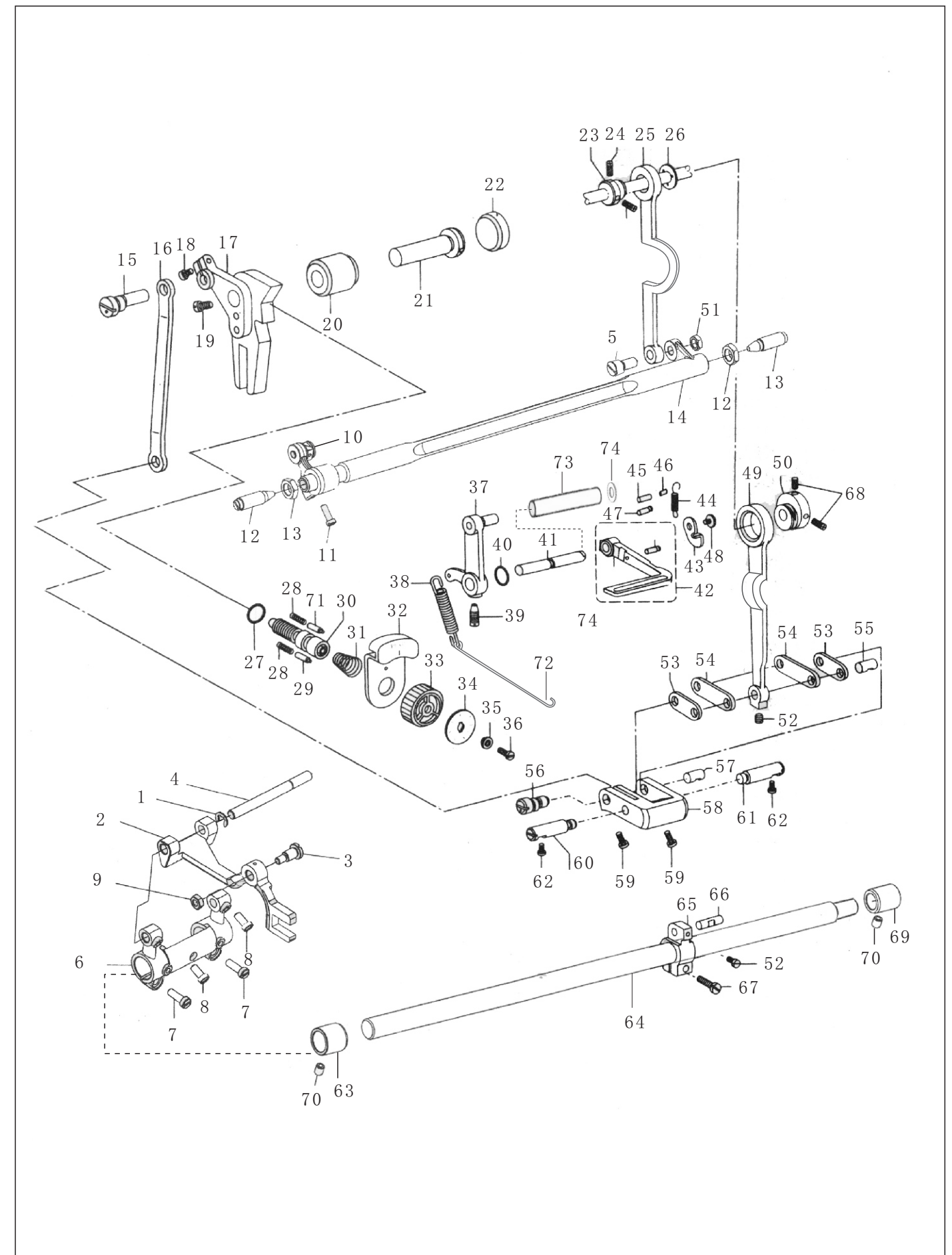
三、要脚部件 PRESSER FOOT ASSEMBLIES



四、送料部件 FEEDING ASSEMBLIES

序号	编号	名称		数量	备注
Ref. No.	Part No.	Part Name		Qty	Remarks
1	1-1	卡簧	snap ring	1	
2	1-2	牙架	feed dog holder	1	
3	1-3	送料座螺钉	feed dog holder screw	1	
4	1-4	牙架曲柄轴	feed dog holder crank shaft	1	
5	1-5	抬压连接螺钉	feed dog lift connecting screw	1	
6	1-6	牙架曲柄	feed dog holder crank	1	
7	1-7	牙架曲柄螺钉	feed dog holder crank screw	2	
8	1-8	牙架曲柄轴螺钉	feed dog holder crank shaft screw	2	
9	1-9	送料连接螺母	feeding connecting nut	1	SM11/64"×40L=12.7
10	1-10	抬牙组件	feed dog lifting asm.	1	
11	1-11	抬牙夹紧螺钉	feed dog lifting asm. Clamping screw	1	
12	1-12	抬压轴固定螺钉	feed dog lifting shaft fixing screw	2	
13	1-13	抬牙轴固定螺母	feed dog lifting shaft fixing nut	1	SM11/64"×40L=9
14	1-14	抬压轴	feed dog lifting shaft	1	
15	1-15	针距调节连杆销	stitch length adjustment connecting lever pin	1	
16	1-16	针距调节连杆	stitch length adjustment connecting lever	1	
17	1-17	针距座	feed dial holder	1	SM11/64"×40L=12.7
18	1-18	针距座长螺钉	feed dial long screw	1	
19	1-19	针距座短螺钉	feed dial short screw	1	
20	1-20	针距座衬套	feed dial lining	1	
21	1-21	针距座轴	feed dial shaft	1	SM11/64"×40L=9
22	1-22	橡皮塞（Φ8.8）	rubber stopper (Diameter 8.8mm)	1	
23	1-23	抬牙凸轮	feed dog lifting cam	1	
24	1-24	抬牙凸轮螺钉	feed dog lifting cam screw	3	
25	1-25	抬牙连杆	feed dog lifting cam connecting lever	1	SM15/64"×28L=7
26	1-26	凸轮隔离片	cam separation slice	1	
27	1-27	O型橡胶圈	O type rubber ring	1	
28	1-28	止动销弹簧	stopper pin spring	2	
29	1-29	针距盘挡销	feed dial stop pin	1	14×2.4特制
30	1-30	针距调节螺杆	stitch length adjustment screw	1	
31	1-31	针距按键簧	feed dial button spring	1	
32	1-32	针距按键	feed dial locking button	1	
33	1-33	针距盘	feed dial knob	1	
34	1-34	针距标盘	feed dial	1	
35	1-35	标盘螺钉衬套	feed dial screw lining	1	
36	1-36	针距盘螺钉	feed dial screw	1	
37	1-37	倒缝操纵杆曲柄组件	reverse feeding control lever crank asm.	1	SM3/16"×28
38	1-38	倒缝操纵杆曲柄弹簧	reverse feeding control lever crank spring	1	
39	1-39	倒缝操纵杆螺钉	reverse feeding control lever screw	1	
40	1-40	倒缝扳手轴o型圈	reverse feeding spanner shaft O ring	1	
41	1-41	倒缝扳手轴	reverse feeding spanner shaft	1	SM15/64"×28
42	1-42	倒缝扳手	reverse feeding spanner	1	
43	1-43	倒缝扳手板	reverse feeding spanner plate	1	
44	1-44	倒缝扳手拉簧	reverse feeding spanner tension spring	1	
45	1-45	倒缝扳手限位销	reverse feeding spanner stop pin	1	6.3×1.8G GB34521.1-92
46	1-46	套销	pint	1	
47	1-47	弹簧挂销	spring hanging pin	1	
48	1-48	倒缝扳手轴螺钉	reverse feeding spanner	1	

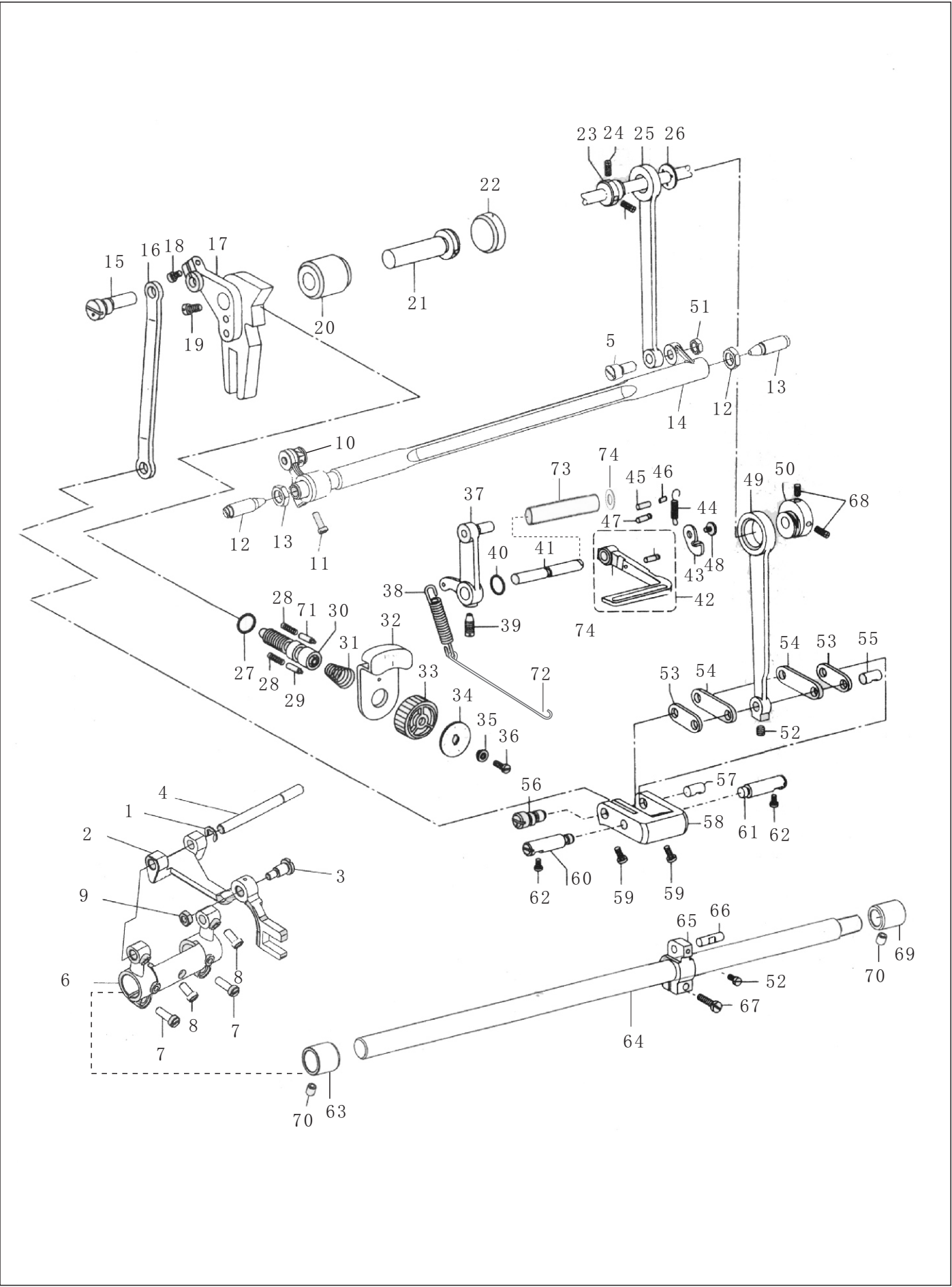
四、送料部件 FEEDING ASSEMBLIES



四、送料部件 FEEDING ASSEMBLIES

序号 Ref. No.	编号 Part No.	名称 Part Name	数量 Qty	备注 Remarks
1	1-49	送布连杆	feeding connecting lever	1
2	1-50	送布凸轮	feeding cam	1
3	1-51	抬牙连接螺母	connecting nut for feed dot lifting	1
4	1-52	送布连杆螺钉	connecting lever screw for feeding	2
5	1-53	曲柄短连杆	crank short linking lever	2
6	1-54	曲柄长连杆	crank long linking lever	2
7	1-55	曲柄连杆长销	long pin of crank linking lever	1
8	1-56	连杆偏心轴	eccentric shaft of linking lever	1
9	1-57	曲柄连杆短销	short pin of crank linking lever	1
10	1-58	针距调节曲柄	feed dial adjustment crank	1
11	1-59	短连杆销螺钉 连杆偏心轴螺钉	short linking lever pin screw / eccentric shaft screw	1
12	1-60	针距调节曲柄定位销 (左)	feed dial adjustment crank positioning pin (left)	1
13	1-61	针距调节曲柄定位销 (右)	feed dial adjustment crank positioning pin (right)	1
14	1-62	左右定位销螺钉	left & right positioning pin screw	2
15	1-63	送布轴前轴套	feeding shaft front bushing	1
16	1-64	送布轴	feeding shaft	1
17	1-65	送布轴曲柄 (右)	feeding shaft crank (right)	1
18	1-66	曲柄连杆短销	crank linking lever short pin	1
19	1-67	送布轴曲柄 (右) 螺钉	feeding shaft crank (right) screw	1
20	1-68	送布凸轮螺钉	feeding cam screw	3
21	1-69	送料轴后套	feeding shaft back bushing	1
22	1-70	送布轴前后轴螺钉	feeding shaft front and back bushing screw	2
23	1-71	止动销	stop pin	1
24	1-72	挂簧钩	hanging spring hook	1
25	1-73	倒缝轴套	reverse feeding bushing	1
26	1-74	倒缝扳手弹性垫片	reverse feeding spanner spring washer	1

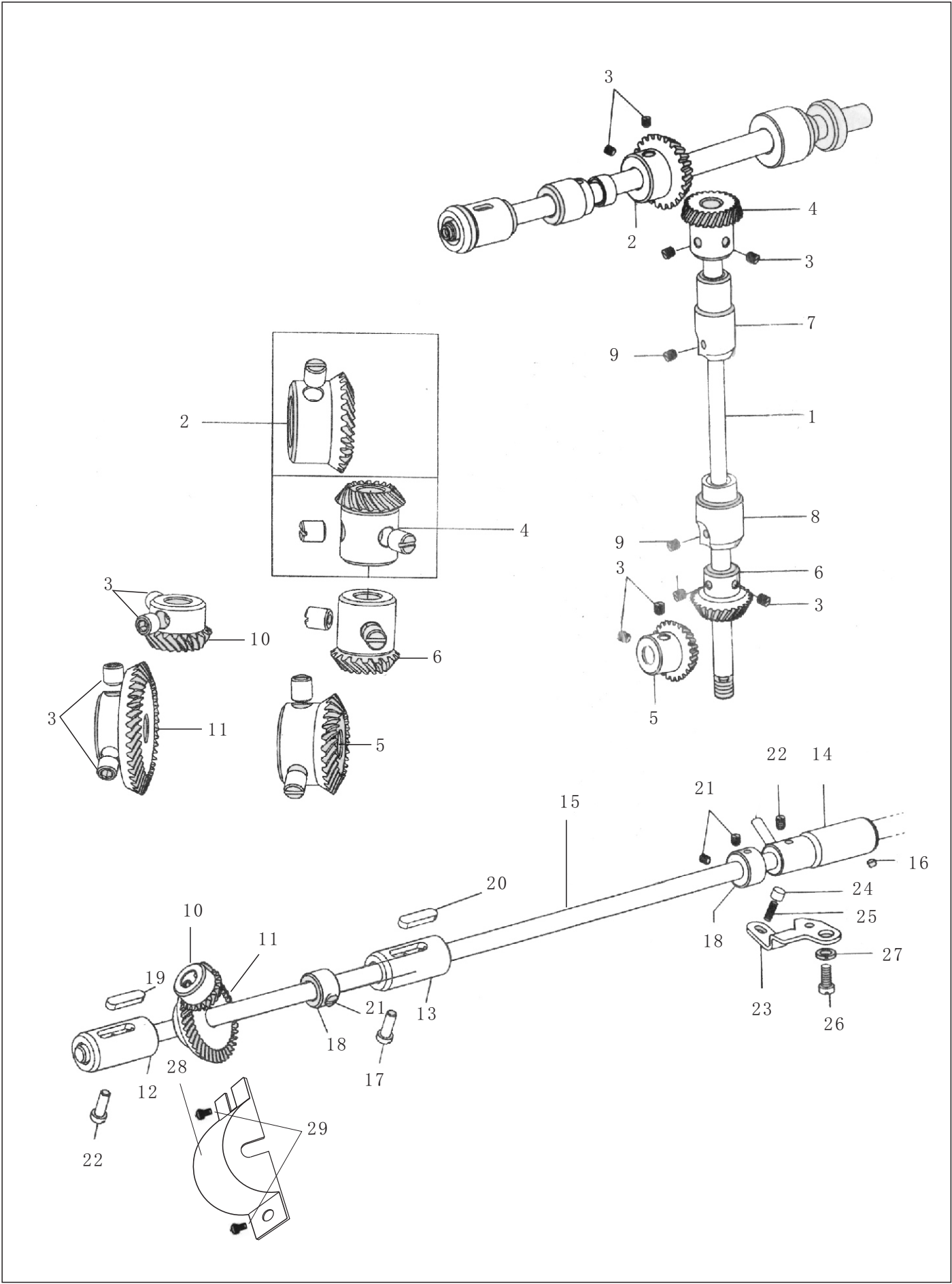
四、送料部件 FEEDING ASSEMBLIES



五、齿轮传动部件 GEAR DRIVING ASSEMBLIES

序号 Ref. No.	编号 Part No.	名称 Part Name	数量 Qty	备注 Remarks
1	1-1	竖轴 vertical shaft	1	
2	1-2	上轴伞齿轮 upper shaft bevel gear	1	
3	1-3	伞齿轮螺钉 bevel gear screw	8	SM1/4"×40L=6
4	1-4	竖轴伞齿轮（上） vertical shaft bevel gear (upper)	1	
5	1-5	下轴伞齿轮 lower shaft bevel gear	1	
6	1-6	竖轴伞齿轮（下） vertical shaft bevel gear (lower)	1	
7	1-7	竖轴上轴套 vertical shaft upper bushing	1	
8	1-8	竖轴下轴套 vertical shaft lower bushing	1	
9	1-9	竖轴轴套螺钉 vertical shaft bushing screw	2	SM15/64"×28L=7
10	1-10	大釜齿轮（小） bevel gear (small)	1	
11	1-11	大釜齿轮（大） bevel gear (big)	1	
12	1-12	下轴前套 lower shaft front bushing	1	
13	1-13	下轴中套 lower shaft middle bushing	1	
14	1-14	下轴轴套（右） lower shaft bushing (right)	1	
15	1-15	下轴 lower shaft	1	
16	1-16	下轴轴套油管 lower shaft bushing oil tube	1	
17	1-17	下轴套（中）螺钉 lower shaft bushing (middle) screw	1	
18	1-18	下轴紧圈 lower shaft compressing ring	2	
19	1-19	下轴左套油棉 lower shaft left bushing oil-absorbing cotton	1	
20	1-20	下轴中套油棉 lower shaft middle bushing oil-absorbing cotton	1	
21	1-21	下轴紧圈螺钉 lower shaft compressing screw	4	SM11/64"×40
22	1-22	下轴轴套螺钉 lower shaft bushing screw	2	SM15/64"×28L=7
23	1-23	挡板 dam-board	1	
24	1-24	柱塞 plunger	1	
25	1-25	柱塞弹簧 plunger spring	1	
26	1-26	挡板螺钉 dam-board screw	1	SM15/64"×28L=14
27	1-27	挡板螺钉弹簧垫圈 dam-board screw spring washer	1	
28	1-28	齿轮油槽 gear oil slot	1	
29	1-29	固定螺丝 fixing screw	2	11/64X2

五、齿轮传动部件 GEAR DRIVING ASSEMBLIES



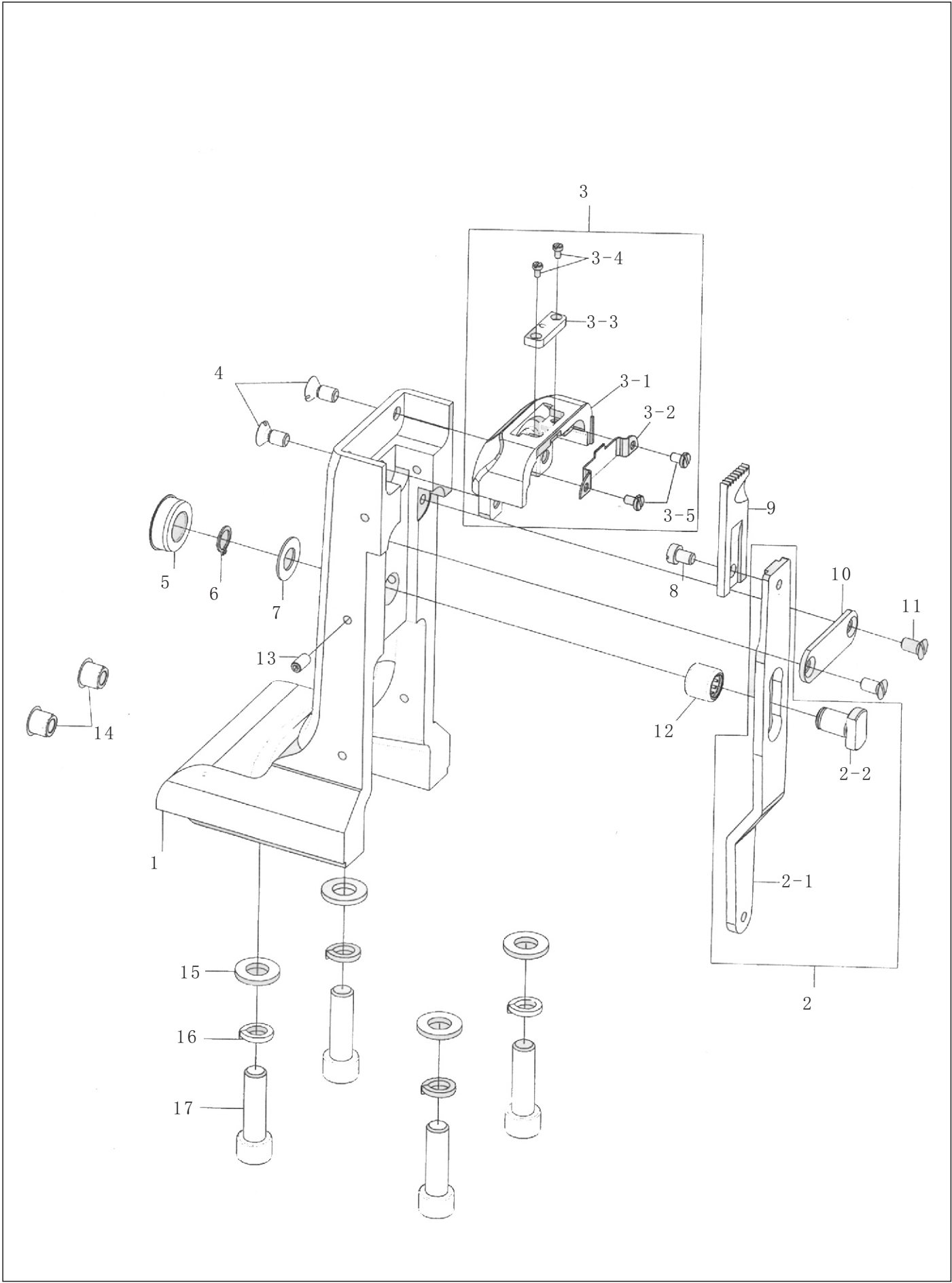
六、边座部件

SIDE FRAME ASSEMBLIES

序号 Ref. No.	编号 Part No.	名称 Part Name	数量 Qty	备注 Remarks
1	1-1	边座 side frame	1	
2	1-2	送料板组件 feeding plate asm.	1	
3	1-2-1	送料板 feeding plate	1	
4	1-2-2	送料板滑块 feeding plate sliding block	1	
5	1-3	针板组件 needle plate asm.	1	
6	1-3-1	针板架 needle plate holder	1	
7	1-3-2	护针架 needle protector holder	1	
8	1-3-3	针板 needle plate	1	
9	1-3-4	螺钉 screw	2	M2
10	1-3-5	螺钉 screw	2	M3
11	1-4	螺钉 screw	2	M5x10沉头
12	1-5	胶塞 rubber stopper	1	1-5
13	1-6	轴用弹性挡圈 spring stop ring for shaft	1	
14	1-7	垫片 washer	1	
15	1-8	螺钉 screw	1	SM11/64"×40
16	1-9	送布牙 feed dog	1	
17	1-10	送料板压板 pressing plate for feed plate	1	
18	1-11	螺钉 screw	2	SM11/64"×40
19	1-12	滚针轴承 needle bearing	1	
20	1-13	螺钉 screw	1	M4x8无头内六角
21	1-14	胶塞 rubber stopper	2	1-9
22	1-15	垫片 washer	4	
23	1-16	弹簧垫片 spring washer	4	
24	1-17	螺钉 screw	4	M8×29

六、边座部件

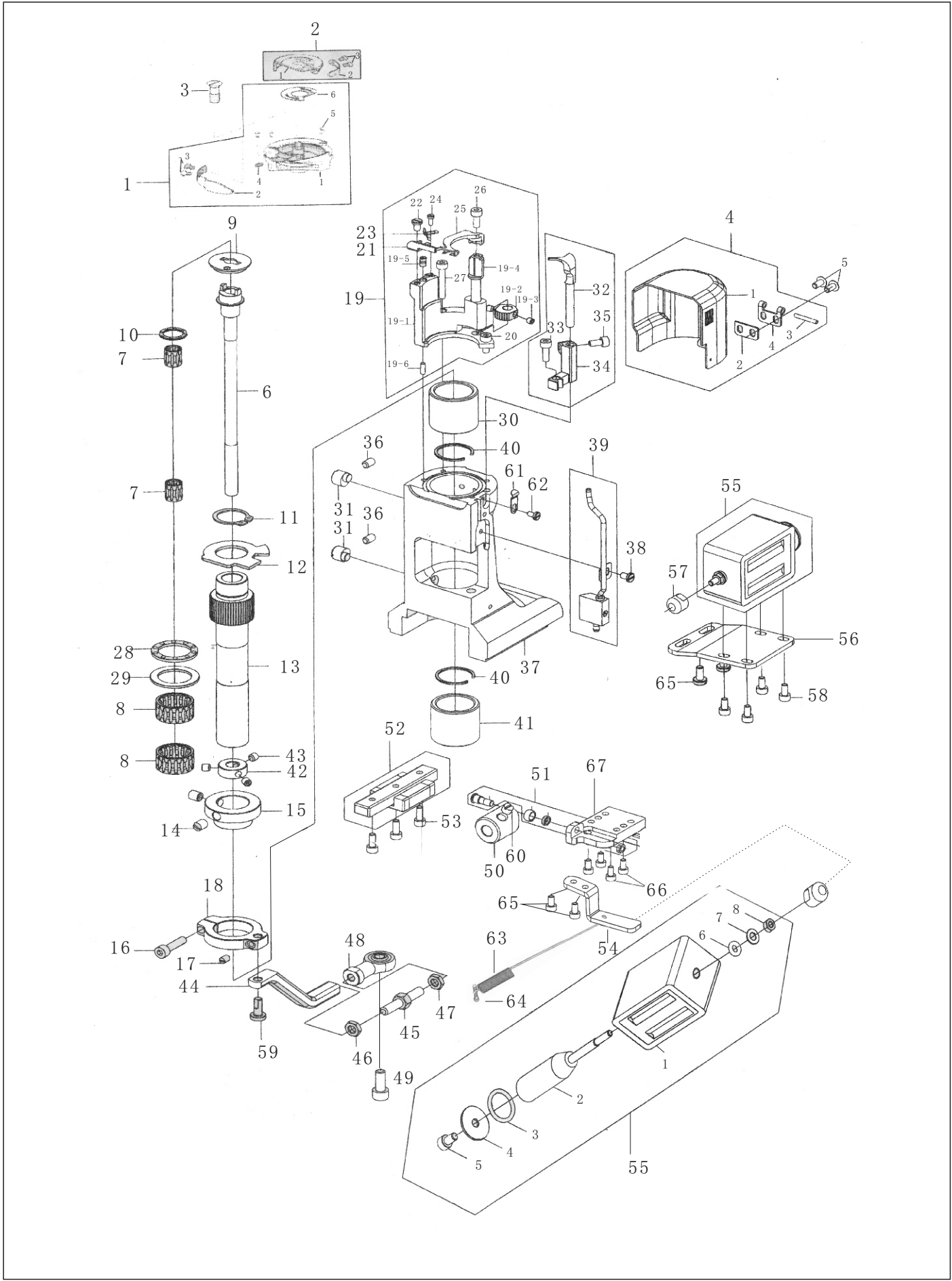
SIDE FRAME ASSEMBLIES



七、旋梭及剪线机构 HOOK AND THREAD CUTTING MECHANISM

序号 Ref. No.	编号 Part No.	名称 Part Name	数量 Qty	备注 Remarks
1	1-1	旋梭组	1	rotating hook hook asm.
2	1-1-1	梭体	1	hook body
3	1-1-2	内梭头舌	1	inner hook tongue
4	1-1-3	螺钉	2	screw
5	1-1-4	螺钉	1	screw
6	1-1-5	螺钉	3	screw
7	1-1-6	弹片	1	clip
8	1-2	梭壳组	1	bobbin case asm.
9	1-2-1	梭壳	1	bobbin case
10	1-2-2	调节板	2	adjusting plate
11	1-2-3	螺钉	1	screw
12	1-3	螺钉	1	M5沉头螺钉 sunk screw
13	1-4	翻盖组件	1	flip cover asm.
14	1-4-1	翻盖	1	flip cover
15	1-4-2	垫片	1	cushion
16	1-4-3	销	1	pin
17	1-4-4	活叶	1	flap
18	1-5	螺钉	2	M4x8
19	1-6	旋梭轴	1	rotating hook shaft
20	1-7	轴承	2	bearing
21	1-8	轴承	2	bearing
22	1-9	挡油片	1	oil prevent plate
23	1-10	轴承	1	bearing
24	1-11	轴用弹性挡圈	1	spring snap ring for shaft
25	1-12	防尘板	1	dust preventing plate
26	1-13	套管	1	drive pipe
27	1-14	螺钉	2	SM1/4"×40L=8
28	1-15	驱动管挡圈	1	snap ring of driving pipe
29	1-16	螺钉	1	M5X16圆柱头内六角 hexagonal socket head cap screw
30	1-17	螺钉	1	SM11/64"×40L=6.5
31	1-18	连接座	1	connecting holder
32	1-19	动刀组件	1	moving knife asm.
33	1-19-1	动刀安装座	1	moving knife installation holder
34	1-19-2	齿轮	1	gear
35	1-19-3	螺钉	2	M4x4无头内六角 hexagonal socket headless screw
36	1-19-4	动刀固定轴	1	moving knofe fixing shaft
37	1-19-5	定刀调节偏心销	1	fixed knife adjusting eccentric pin
38	1-19-6	定位销	1	positioning pin
39	1-20	螺钉	1	M4X10圆柱头内六角 hexagonal socket head cap screw
40	1-21	定刀	1	fixed knife
41	1-22	螺钉	1	M4x6
42	1-23	挡线板	1	stopping thread board
43	1-24	螺钉	1	M2.5x6
44	1-25	动刀	1	moving knife
45	1-26	螺钉	1	M4X10圆柱头内六角 hexagonal socket head cap screw
46	1-27	螺钉	1	M4X25圆柱头内六角 hexagonal socket head cap screw
47	1-28	轴承	1	bearing
48	1-29	调整片	1	washer

七、旋梭及剪线机构 HOOK AND THREAD CUTTING MECHANISM



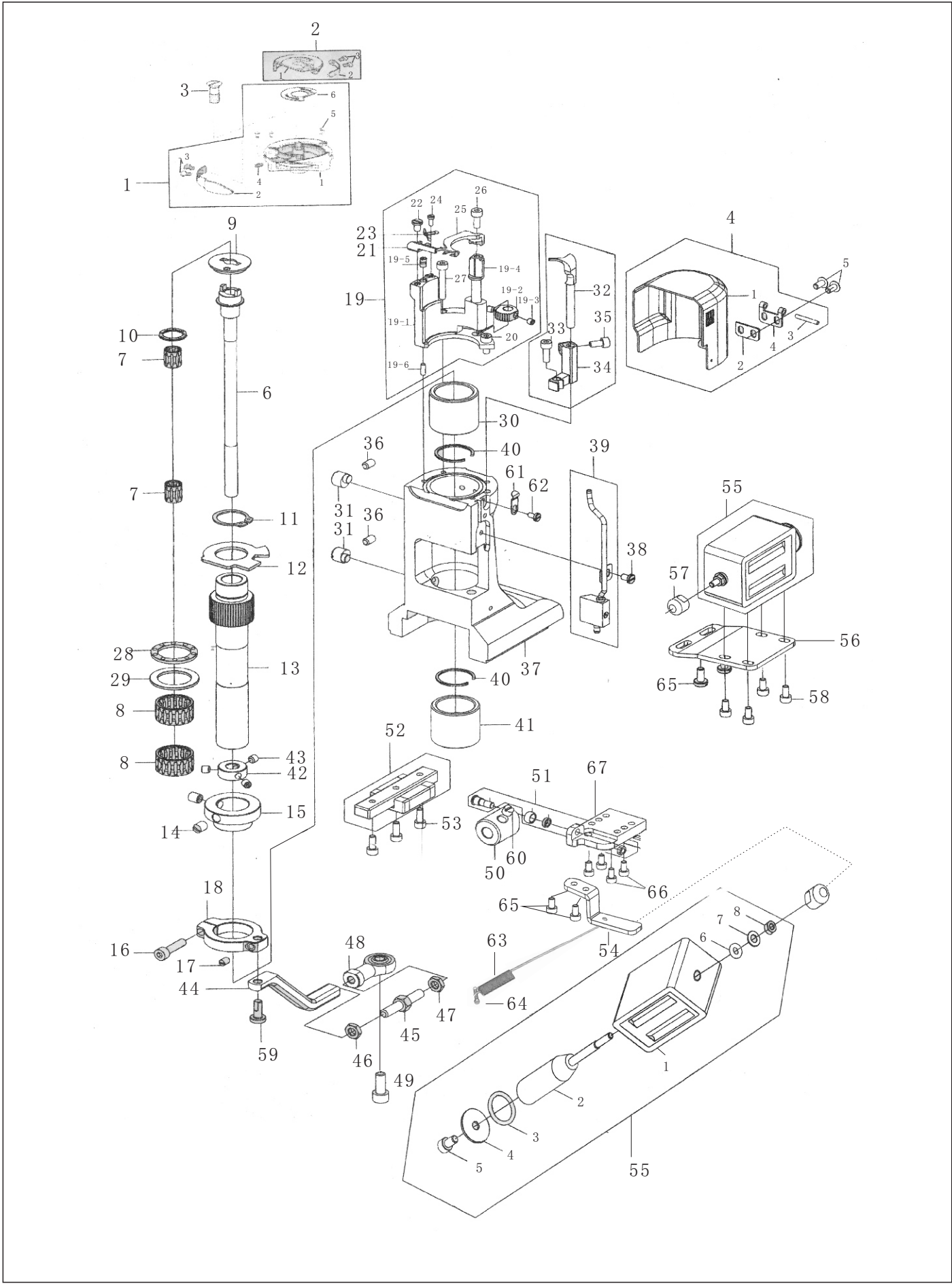
七、旋梭及剪线机构

HOOK AND THREAD CUTTING MECHANISM

序号 Ref. No.	编号 Part No.	名称 Part Name	数量 Qty	备注 Remarks
1	1-30	旋梭上轴套	1	
2	1-31	调节偏心销	2	
3	1-32	分线勾	1	
4	1-33	螺钉	2	M4X12 圆柱头内六角 hexagonal socket head cap screw
5	1-34	分线勾	1	
6	1-35	螺钉	1	M4X8圆柱头内六角 hexagonal socket head cap screw
7	1-36	螺钉	2	M5X8无头内六角 hexagonal socket headless screw
8	1-37	旋梭座	1	
9	1-38	螺钉	1	
10	1-39	油量调节组件	2	
11	1-40	轴套内卡	1	
12	1-41	旋梭轴套（下）	1	
13	1-42	旋梭轴挡圈	1	
14	1-43	螺钉	3	
15	1-44	驱动连杆	1	
16	1-45	连接螺杆	1	
17	1-46	螺母	1	
18	1-47	螺母（反牙）	1	
19	1-48	万向接头组件	1	
20	1-49	螺钉	1	M5×0.5
21	1-50	剪线凸轮	1	
22	1-51	滚柱组件	1	
23	1-51-1	轴位螺钉	1	
24	1-51-2	滚柱	1	
25	1-51-3	垫片	1	
26	1-51-4	螺母	1	
27	1-52	直线导轨滑台组件	1	
28	1-53	螺钉	1	M3X10
29	1-54	剪线连杆连接座	1	
30	1-55	剪线电磁铁组件	1	
31	1-55-1	主体	1	
32	1-55-2	芯轴	1	
33	1-55-3	缓冲胶	1	
34	1-55-4	垫片	1	
35	1-55-5	螺钉	2	M5x8
36	1-55-6	缓冲胶垫	1	
37	1-55-7	螺母	1	
38	1-55-8	垫片	1	
39	1-56	剪线电磁铁安装架	1	
40	1-57	缓冲胶	1	
41	1-58	螺钉	4	M4x8
42	1-59	剪线连杆销	1	
43	1-60	螺钉	3	SM1 / 4x40L=7
44	1-61	旋梭盖固定弹片	1	
45	1-62	螺钉	1	M4X0.8
46	1-63	切线弹簧	1	
47	1-64	切线弹簧固定销	1	
48	1-65	切线电磁阀座固定螺钉	1	M5X0. 8
49	1-66	切线座固定螺钉	4	M3X10
50	1-67	切线座	1	

七、旋梭及剪线机构

HOOK AND THREAD CUTTING MECHANISM



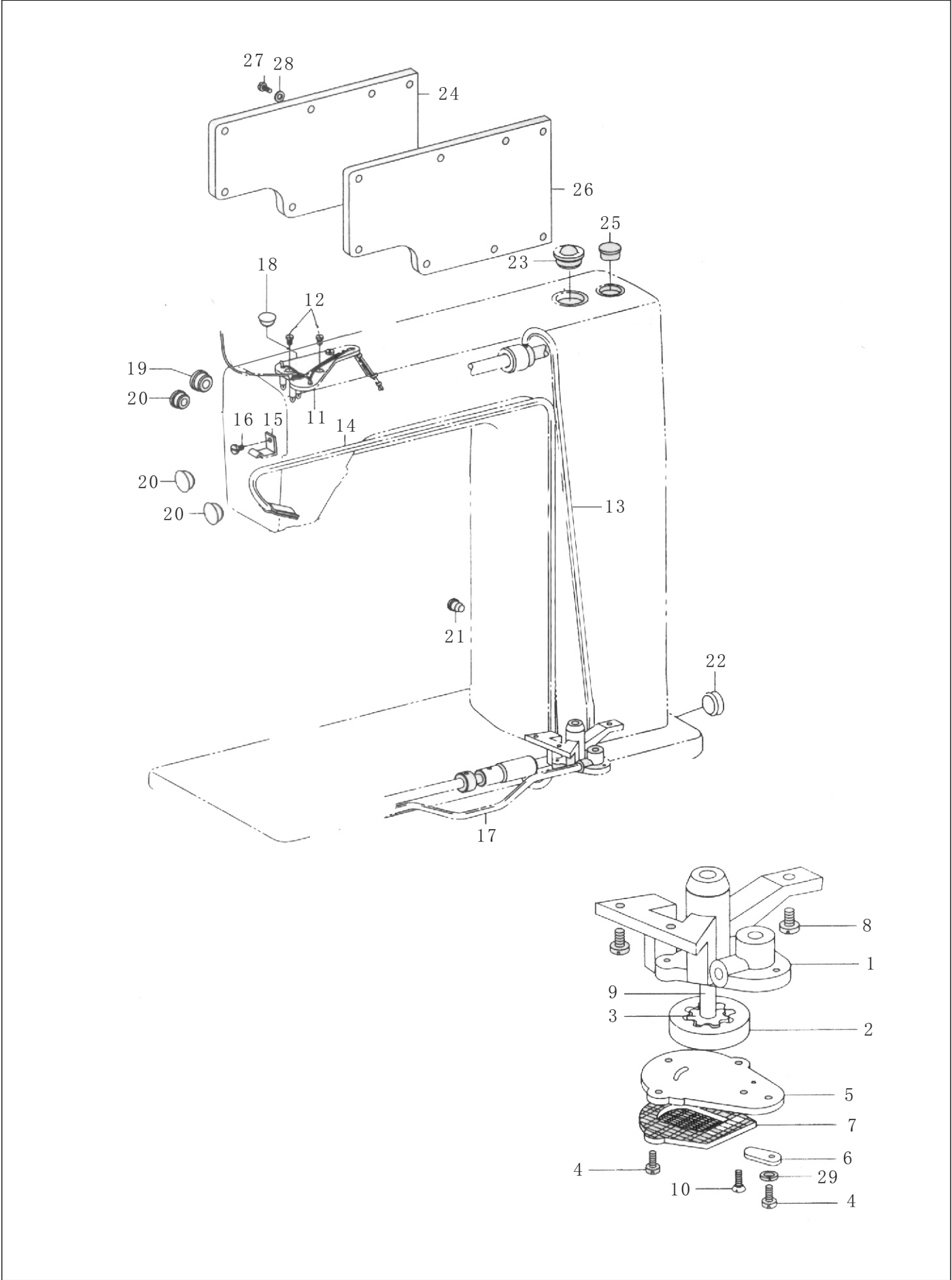
八、供油润滑部件

LUBRICATION ASSEMBLIES

序号 Ref. No.	编号 Part No.	名称 Part Name		数量 Qty	备注 Remarks
1	1-1	油泵体	oil pump asm.	1	M3X10
2	1-2	油泵大齿轮	oil pump big gear	1	
3	1-3	油泵小齿轮	oil pump small gear	1	
4	1-4	油泵调节板螺钉	oil pump adjusting plate screw	1	
5	1-5	油泵体盖板	oil pump cover plate	1	SM11/64"×40L=20
6	1-6	油泵调节板	oil pump adjusting plate	1	
7	1-7	油泵滤网组件	oil pump filting asm.	1	
8	1-8	油泵体螺钉	oil pump screw	3	
9	1-9	油泵体短轴	oil pump short shaft	1	M3x10
10	1-10	油泵体盖板螺钉	oil pump cover plate screw	2	
11	1-11	油线固定板大组件	oil thread fixing plate big asm.	1	
12	1-12	油线固定板螺钉	oil thread fixing plate screw	1	
13	1-13	上轴油管组件	upper shaft oil pipe asm.	1	SM9/64"×40L=13
14	1-14	回油管组件	oil return pipe asm.	1	
15	1-15	回油管夹	oil return pipe clamp	1	
16	1-16	回油管夹螺钉	oil return pipe clamp screw	1	
17	1-17	下轴油管组件	lower oil pipe asm.	1	SM11/64"×40
18	1-18	橡胶塞	rubber stopper	1	
19	1-19	橡胶塞 (Φ19)	rubber stopper (D19mm)	1	
20	1-20	橡胶塞 (Φ11.8)	rubber stopper (D11.8mm)	3	
21	1-21	橡胶塞 (Φ8.8)	rubber stopper (D8.8mm)	1	
22	1-22	橡胶塞 (Φ27)	rubber stopper (D27mm)	1	
23	1-23	油窗组件	oil window asm.	1	
24	1-24	后盖板	back cover plate	1	
25	1-25	橡胶塞 (Φ25.5)	rubber stopper (D25.5mm)	1	SM3/16"×28L=12
26	1-26	后盖板密封垫片	back cover plate sealing cushiong	1	
27	1-27	后盖板螺钉	back cover plate screw	8	
28	1-28	后盖板螺钉垫片	back cover plate screw washer	8	
29	1-29	弹簧垫圈	spring washer	1	

八、供油润滑部件

LUBRICATION ASSEMBLIES



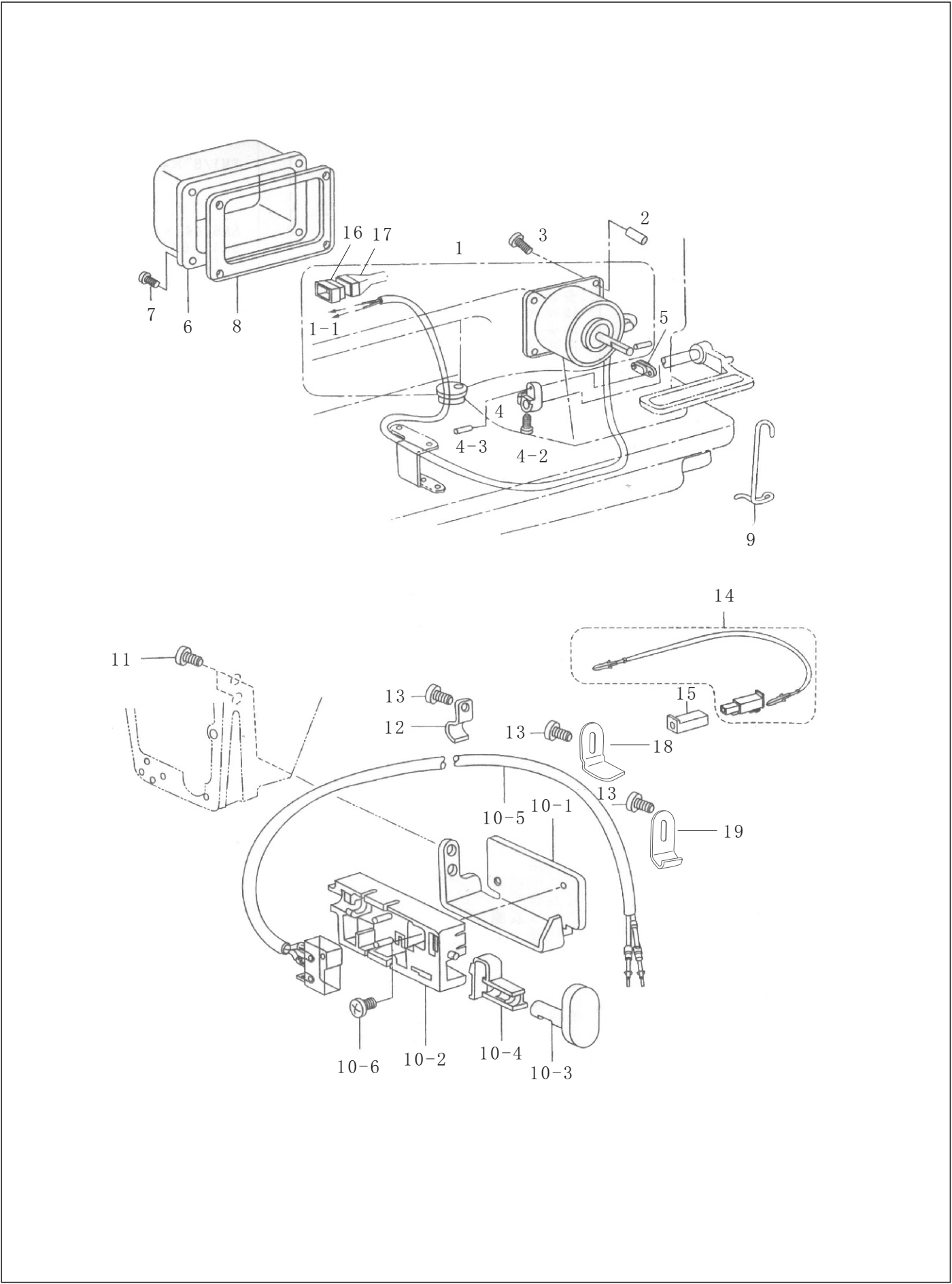
九、倒缝部件

REVERSE FEEEDING ASSEMBLIES

序号 Ref. No.	编号 Part No.	名称 Part Name		数量 Qty	备注 Remarks
1	1-1	倒缝电磁铁组件	reverse feeding electromagnet asm.	1	SM11/64"×40L=25
2	1-1-1	插头	plug	2	
3	1-2	衬管	liner tube	4	
4	1-3	衬管螺钉	liner tube screw	4	
5	1-4	倒缝电磁铁曲柄	reverse feeding electromagnet crank	1	SM3/16"×32L=13.5
6	1-4-2	曲柄螺钉	crank screw	1	
7	1-4-3	倒缝电磁铁曲柄连杆销	reverse feeding electromagnet crank linking lever pin	1	
8	1-5	倒缝电磁铁连杆	reverse feeding electromagnet linking lever	1	
9	1-6	倒缝电磁铁罩	reverse feeding electromagnet protection cover	1	SM3/16"×28L=15
10	1-7	倒缝电磁铁螺钉	reverse feeding electromagnet screw	4	
11	1-8	倒缝电磁铁罩垫片	reverse feeding electromagnet protection cover washer	1	
12	1-9	倒缝操纵曲柄弹簧钩	reverse feeding controlling crank spring hook	1	
13	1-10-1	倒缝电磁铁开关安装架	reverse feeding electromagnet switch bracket	1	
14	1-10-2	倒缝按键开关座	reverse feeding button switch bracket	1	
15	1-10-3	倒缝按键开关	reverse feeding button switch	1	
16	1-10-4	倒缝电磁铁开关触件	reverse feeding electromagnet switch contact component	1	
17	1-10-5	倒缝开关组件	reverse feeding switch asm.	1	M3×6
18	1-10-6	倒缝按键开关座螺钉	reverse feeding button switch screw	1	
19	1-11	开关安装架螺钉	reverse feeding button switch installation bracket screw	2	
20	1-12	线夹	thread clamp	3	
21	1-13	线夹螺钉	thread clamp screw	3	SM11/64"×40L=6
22	1-14	倒缝电磁铁组件	reverse feeding electromagnet asm.	1	
23	1-15	接头（2）	connecting joint (2)	1	
24	1-16	插头	plug	1	
25	1-17	插头	plug	1	
26	1-18	线夹	thread clamp	1	
27	1-19	线夹	thread clamp	2	

九、倒缝部件

REVERSE FEEEDING ASSEMBLIES



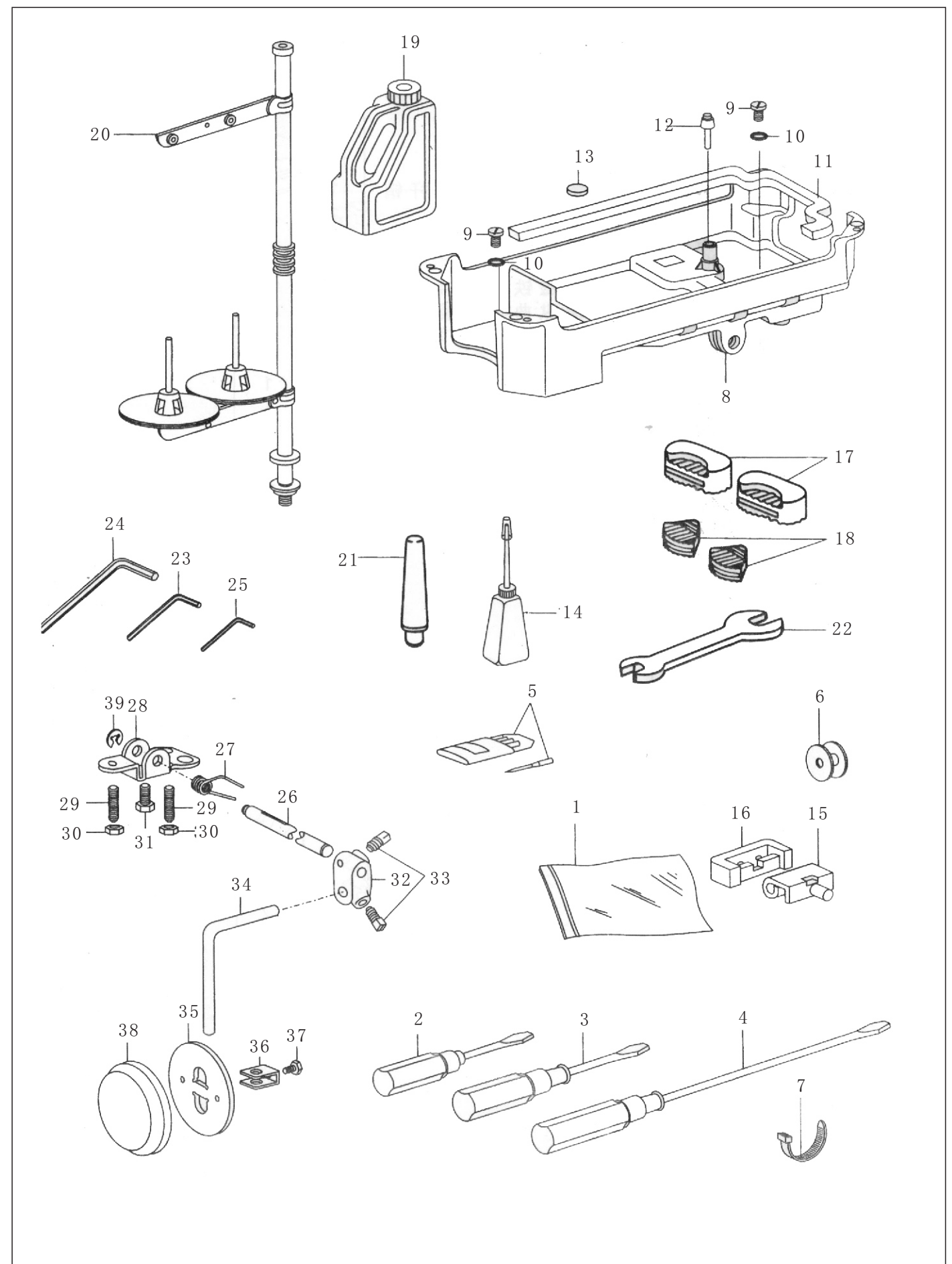
十、附件

ACCESSORIES

序号	编号	名称		数量	备注
Ref. No.	Part No.	Part Name		Qty	Remarks
1	1-1	零件袋	accessory bag	1	DPX5 16#
2	1-2	一字开刀（小）	- type screw driver (small)	1	
3	1-3	一字开刀（中）	- type screw driver (middle)	1	
4	1-4	一字开刀（大）	- type screw driver (big)	1	
5	1-5	机针	needle	4	
6	1-6	梭芯	bobbin	3	
7	1-7	捆扎带	fastening string	3	
8	1-8	油盘	oil pan	1	
9	1-9	放油螺钉	oil adjusting screw	2	
10	1-10	放油螺钉垫圈	oil adjusting screw washer	2	
11	1-11	油盘垫	oil pan cushion	1	
12	1-12	膝控提升顶杆	knee controled lifting lever	1	
13	1-13	磁块	magnet block	1	
14	1-14	油壶	small oil pot	1	
15	1-15	机壳铰链	machine frame hinges	2	
16	1-16	机壳铰链套	machine frame hinges bushing	2	
17	1-17	机头防针垫块（大）	vibration proof rubber block (big)	2	
18	1-18	机头防针垫块（小）	vibration proof rubber block (small)	2	
19	1-19	油箱	oil can	1	
20	1-20	线架组件	spool holder asm	1	
21	1-21	机头撑杆	head resting bar	1	
22	1-22	呆扳手	solid wrench	1	
23	1-23	2MM内六角扳手	2mm internal hexagonal wrench	1	2GB/T5356-1998发黑 black coating 3GB/T5356-1998发黑 black coating 2.5GB/T5356-1998发黑 black coating
24	1-24	3MM内六角扳手	3mm internal hexagonal wrench	1	
25	1-25	2.5MM内六角扳手	2.5mm internal hexagonal wrench	1	
26	1-26	膝控铰链轴	knee controled hinge axis	1	
27	1-27	膝控复位弹簧	knee controled returning spring	1	
28	1-28	膝控限位架	knee controled position fixing bracket	1	
29	1-29	膝控限位调节螺钉	knee controled position fixing adjustment screw	2	
30	1-30	调节螺母	adjustment screw	2	
31	1-31	膝控限位架螺钉	knee controled position fixing bracket screw	1	
32	1-32	碰块弯杆接头	bumper block curved bar joint	1	
33	1-33	碰块弯杆接头螺钉	bumper block curved bar joint screw	1	
34	1-34	膝控碰块弯杆	knee controled bumper block curved bar	1	
35	1-35	膝控碰块	knee controled bumper block	1	
36	1-36	碰块架	bumper block bracket	1	
37	1-37	碰块架螺钉	bumper block bracket screw	1	
38	1-38	碰块垫	bumper block washer	1	
39	1-39	开口挡圈	split washer	1	

十、附件

ACCESSORIES



常见故障 Trouble	产生原因 Cause	处理方法 Remedy
跳针 Trouble	(1) 由机针引起的： 机针弯曲 机针与缝线规格不符 (2) 由机针安装错误引起的： 插入不足 插入偏针 (1) Reasons caused by needle Needle curving Needle not fit thethickness of Thread. (2)Reasons caused by wrongly installing needle. When inserting needle,the depth of itIs not enough. When inserting needle,the needle is inclined	换机针 换上与缝线粗细相符的机针 插入至针杆的定位面 重新装机针 Replace needle Replace a needle xhich fit the thickness of thread. Insert needle to the fixed-position plane of needle bar. Re-installing needle.
浮线 Trouble	(1) 面线张力过轻 (2) 挑线簧过松 (3) 底线张力过大 (1)Tension of needle thread is too small. (2)Taks-up spring is too loosen. (3)Tension of bobbin thread is toobig.	把夹线调节螺母顺时针方向旋转，调整面线挑节挑线簧张力，缝厚料（针距长）时，应增强张力旋紧松心套梭皮螺钉调节。 Turnn round tension adjusting nut clockwise to regulate Needle thread. Adjusting the tension of take-up spring, when sewing thickermateriall(stitchlength is long), the tension of. Take-up spring should be increased. Tighten the spring plate screw of hook case.
断线 Trouble	(1) 缝线质量低劣 (2) 由机针引起 机针弯曲 安装有误 机针过细（相对缝线来说） (3) 面线张力过紧 (1)The quality of thread is pool.... (2)Caused by needie Needie curving Needie installing wrong Needle is too small (compared with thread) (3)The tension of needle thread is too big.	换上优质缝线。粗细不匀，有接头的缝线不能使用。 换新机针。 重新装机针 换上与缝线粗细相符的机针。 调松夹线螺母。 Replace thread which is very good.if the thickness of thread isnot even or there is some joint in thread,do not use it. Replace anew needle Re-installing needle. Replace a needle which fit the thickness of thread. Looseing threading nut.

参数项	内容（仅供参考）	注释	备注
P01	最高转速（spm）	车缝时的最高转速设定	
P02	加速曲线调整（%）	控速器的加速爬升斜率设定 斜率值越大，速度加速越快；斜率值越小，速度加速越慢	
P03	针停定位选择	UP：上停针 DN：下停针	
P04	起始回缝速度（spm）	起始回缝的速度设定	
P05	终止回缝速度（spm）	终止回缝的速度设定	
P06	连续回缝速度（spm）	连续回缝的速度设定	
P07	慢速起缝速度（spm）	慢速起缝的速度设定	
P08	慢速起缝针数	慢速起缝的针数设定	
P09	自动定针缝速度（spm）	定针缝自动触发功能打开时的速度设定	
P10	定针缝后自动执行终止回缝功能（不补针功能设定）	ON：在执行完最后一段定针缝后，将自动执行终止回缝动作。 注：即在任何缝制模式下，终止回缝前不能作补针功能。 OFF：在执行完最后一段定针缝后，将无法自动执行终止回缝功能，必须重新再作前或全后踏动作时才可执行终止回缝或进行补针功能。	
P11			
P12	起始回缝运动模式选择	范围（0 - 2） 0：人工，受踏板控制，可任意停止与启动 1：自动，轻触踏板，自动执行回缝动作 2：停顿	
P13	起始回缝结束点操作模式选择	CON：起始回缝段完成后，自动连续下一段功能 STP：起始回缝段针数完成后自动停止	
P14	慢速启动	ON：慢速启动功能开启 OFF：慢速启动功能关闭	
P15	补针方式	范围（0 - 4）补针方式，0：半针，1：一针，2：连续补半针，3：连续补一针，4：连续补针，快速停车（杰克模式）	
P16			
P17	自动计件选择	0：P41项自动计数 1：P41项不自动计数	
P18	起始回缝补偿1	起始回缝A段针迹补偿，0~200动作逐步滞后	
P19	起始回缝补偿2	起始回缝B段针迹补偿，0~200动作逐步滞后	
P20	终止回缝运动模式选择	范围（1 - 2） 1：自动，轻触踏板，自动执行回缝动作 2：停顿	
P21			
P22			
P23			
P24	脚踏板反踏点电压	脚踏板反踏点位置调整	
P25	终止回缝补偿3	起始回缝C段针迹补偿，0~200动作逐步滞后	
P26	终止回缝补偿4	起始回缝D段针迹补偿，0~200动作逐步滞后	

P27	感应开关	0：关感应 1：剪线后感应 2：一般感应 7：感应抬压脚保护时间8：接收感应AD 9：传感器灵敏度	
P28	连续回缝运动模式选择	范围（0 - 2） 0：人工，受踏板控制，可任意停止与启动 1：自动，轻触踏板，自动执行回缝动作 2：停顿	
P29	剪线后刹车力度	数值越大力度越大	
P30	厚料加力	数值越大力度越大	
P31	剪线加力	数值越大力度越大	
P32	连续回缝补偿5	起始回缝A、C段针迹补偿，0~200动作逐步滞后	
P33	连续回缝补偿6	起始回缝B、D段针迹补偿，0~200动作逐步滞后	
P34	定针缝运动模式选择	A：轻触脚踏板，自动执行定针缝动作 M：受脚踏板控制，可任意停止与启动	
P35	吸气选择	暂无	
P36	松线功能开关选择	0：松线功能关闭 1：松线功能开启	
P37	拨线、夹线功能设定	0：功能关闭 1：拨线功能开启	
	（夹线器力度设置）	2~11 夹线功能开启，数值越大动作力度越大	
P38	剪线功能设定	ON：剪线功能开启 OFF：剪线功能关闭	
P39	车缝途中停止时，压脚出力选择		
P40	剪线后，压脚出力选择		
P41	车缝完成件数显示		
P42	信息显示	按“S”键进入，P键退出 N01 电控版本序列号 N02 选针盒版本号 N03 转速 N04 脚踏板AD N05 上定位角度 N06 下定位角度 N07 母线电压AD	
P43	马达转动方向设定（正反转）		
P44	刹车力度		
P45	倒缝出力动作的周期信号（%）		
P46	剪线后，反转提针角度的功能选择		
P47	剪线后，反转提针角度的调整		
P48	低速（定位速度）（spm）		
P49	剪线速度（spm）		
P50	抬压脚提升时间（ms）		
P51	压脚出力动作的周期信号（%）		
P52	压脚下放时间（ms）		
P53	半后踏取消抬压脚功能		不可恢复

P54	剪线动作时间（ms）		
P55	拨 / 扫线（或吹风）动作时间/		
P56	开电后自动找上定位		
P57	抬压脚保护时间（s）		
P58	上定位调整		不可恢复
P59	下定位调整		不可恢复
P60	测试速度（spm）		
P61	A项测试		
P62	B项测试		
P63	C项测试		
P64	测试B、C导通时间		
P65	测试B、C停车时间		
P66	机头保护开关检测		
P67	剪线保护开关检测		
P69	倒缝释放缓冲占空比（%）		
P70	机型选择		
P71	压脚下放缓冲		
P72	上停针位校正		
P73	下停针位校正		
P74			
P75			
P76	倒缝全额出力时间		
P77	自由缝连终止回缝停顿时间		
P78	夹线器起夹角度		
P79	夹线器结束角度		
P80	剪线进刀角度（下定位0度）	（下定位0度）	
P81	剪线开始加力角度（下定位0度）	（下定位0度）	
P82	剪线退刀角度（下定位0度）	（下定位0度）	
P83			
P84	厚料开始加力角度（上定位0度）	（上定位0度）	

P85	厚料结束加力角度（上定位0度）	（上定位0度）	
P86	上下定位距离		
P87	扫线回程延迟		
P88	刹车距离		
P89	交流过压值设定		
P90			
P91			
P92	编码器起始角度	参数值不可手动修改	不可恢复
P93	半反踏延迟时间		
P94	最大电流		
P95	加力低速		
P96			
P97	堵转时间		
P98	倒缝释放时间		
P99	语音切换	0：关闭，1：中文，2：英文	
P100	感应压脚保持时间		
P101	松线开始角度		
P102	松线结束角度		
P103	无布感应压脚保持时间		
P104	停顿延时时间	起始回缝运动模式选择，终止回缝运动模式选择，连续回缝运动模式选择，选2的时候生效	
P105	电动气动选择	0： 电动，1：气动	
P106	平时电流		
P107	机器类型	0：平缝，1：绷缝	
P108	绷缝吸气选择		
P109	扫线前延迟时间		
P110	剪线回程时间		
P111	编码器类型选择，0：无磁环，1：有磁环		
P112	剪线全额出力时间		
P113	剪线出力动作的周期信号（%）		
P114	剪线释放缓冲占空比（%）		

P115	剪线释放缓冲时间		
P116			
P117			
P118			
P119			
P120			

Parameter	Contents (for reference only)	Details	Remarks
P01	Max. speed (spm)	Setting the max. speed	
P02	Acceleration curve adjustment (%)	Setting the slope rate of speed controller in accelerating and climbing, the bigger the slope rate, the faster the speed acceleration; the smaller the slope rate, the slower the speed acceleration	
P03	Needle positioning	UP: Upper needle positioning DN: Lower needle positioning	
P04	Initial reverse stitching speed (spm)	Speed setting for initial reverse stitching	
P05	Terminated reverse stitching speed (spm)	Speed setting for terminated reverse stitching	
P06	Continuous reverse stitching speed (spm)	speed setting for continuous reverse stitching	
P07	Slow start stitching speed (spm)	Setting the speed in slow start sewing	
P08	Slow start stitching amount	Setting the stitching amount in slow start sewing	
P09	Speed of auto fixed stitch amount sewing (spm)	The initial speed setting of automatic trigger function in fixed stitch amount sewing	
P10	After fixed stitch amount sewing, automatically stop the reverse stitching (No remedial stitch setup)	ON: After finishing the last section of fixed amount sewing, it will stop reverse stitching automatically. (Note: In any sewing mode, before stop reverse stitching, cannot do remedial stitch) OFF: After finishing the last section of fixed amount sewing, the reverse stitching will not stop automatically, the operator should stamp forward or backward to end the reverse stitching or remedial stitching.	
P11			
P12	Working Mode selection when start reverse stitching	Range (0 - 2) 0: By hand, controled by pedal, can start and stop at any time. 1: Automatic, slightly touch the pedal, automatically reverse stitching. 2: Pause	
P13	Operation mode selection in the end of initial reverse stitching	CON: After finishing the initial reverse stitching, it will start with the next section automatically.	
P14	Slow start	ON: Open the slow start function OFF: Close the slow start function	
P15	Remedial stitch	Range: (0 - 4) Remedial stitch, 0: half-stith, 1: 1 stitch, 2: continuous 2 half-stitches, 3: continuous 1 stitch , 4: continuous remedial stitch, quick stop (JACK MODE)	
P16			
P17	Auto stitch amount calculating	0: P41 Open auto stitch amount calculating 1: P41 Close auto stitch amount calculating	
P18	Initial reverse stitch remedial stitch 1	Remedial stitch in section A of initial sewing, 0~200 the movement gradually lagged	
P19	Initial reverse stitch remedial stitch 2	Remedial stitch in section B of initial sewing, 0~200 the movement gradually lagged	
P20	Selective mode for stop reverse stitching	Range (1 - 2) 1: Automatic, slightly touch the pedal, automatically start reverse stitching 2: Pause	
P21			
P22			
P23			
P24	Voltage of Countertrample point on the pedal	Position adjustment on the voltage of countertrample point on the pedal	
P25	After stop reverse stitching, make up 3 stitches	Remedial stitch in section C of initial sewing, 0~200 the movement gradually lagged	

P26	After stop reverse stitching, make up 4 stitches	Remedial stitch in section D of initial sewing, 0~200 the movement gradually lagged	
P27	inductive switch	0: Close sensor 1: Sense after cutting thread 2: General sense 7: Sense the protection time of presser foot lifting 8: Receiving sense AD 9: Sensor sensitivity	
P28	Selective mode of continuous reverse stitching	Range (0-2) 0: By hand, controled by pedal, can stop or start at any time. 1: Automatic, slightly touch the pedel, it will do reverse stitching automatically.	
P29	Stitch brake power after thread cutting	The bigger the data,the bigger the power	
P30	Heavy-duty material power strenthen	The bigger the data, the bigger the power	
P31	Thread cutting power strenthen	The bigger the data, the bigger the power	
P32	Continuous reverse stitching, 5 remedial stitches	Remedial stitch in section A and C of initial sewing, 0~200 the movement gradually lagged	
P33	Continuous reverse stitching, 6 remedial stitches	Remedial stitch in section B and D of initial sewing, 0~201 the movement gradually lagged	
P34	Selective model of fixed stitch amount sewing	A: Slightly touch the pedal, it will start fixed stitch amount sewing automatically. M: Controled by pedal, can stop and start at any time.	
P35	Air absorption	No	
P36	Thread slack function on/off switch	0: Thread slack function off. 1: Thread slack function on.	
P37	Thread wipping/thread nipping function setting (Strength of thread clamp setup)	0: Function off 1: Thread wipping function on 2~11 Thread nipping function on, the bigger the data, the bigger the power	
P38	Thread cutting set up	ON: Thread cutting mode on OFF: Thread cutting mode off	
P39	Pause during sewing,presser foot action selection		
P40	Presser foot action selection after thread cutting		
P41	The sewing finish quantity display		
P42	Message display	Press"S"to enter, and "P" to exit: N01 Control system Version No. N02 Needle box Version No. N03 Speed N04 Pedal AD N05 Upper location angle N06 Lower location angle N07 busbar voltage AD	
P43	Motor rotation direction setup (Normal & Reverse rotation setup)		
P44	Sewing brake force		
P45	Periodic signal of reverse stitch action (%)		
P46	Inverted needle lifting angle selection after thread cutting		
P47	Inverted needle lifting angle adjustment after thread cutting		
P48	Low speed (locating speed) (spm)		
P49	Thread cutting speed (spm)		

P50	Presser foot lifting time (ms)		
P51	periodic signal of presser foot action (%)		
P52	Presser foot lay down time (ms)		
P53	Half-step backward to cancel the auto presser foot lifting		unrecoverable
P54	thread cutting time (ms)		
P55	Thred wipping / thread sweeping (blow up) time		
P56	Automatically locating the upper position when power on		
P57	Presser foot protection time (s)		
P58	Upper location adjustment		unrecoverable
P59	Lower location adjustment		unrecoverable
P60	Test speed (spm)		
P61	Item A Testing		
P62	Item B Testing		
P63	Item C Testing		
P64	Item B, C conduction time		
P65	Item B, C stop runing time		
P66	Inspection on safty switch		
P67	Inspection on thread cutting protection switch		
P69	Reverse stitching release buffer duty ratio (%)		
P70	Machine type		
P71	Presser foot lay down buffering		
P72	Upper needle position correction		
P73	Lower needle position correction		
P74			
P75			
P76	Full effort time of reverse stitching		
P77	Pause time between free sewing and terminate reverse stitching		
P78	Thread clamp device start Angle		
P79	Thread clamp device finish angle		
P80	Cutting knife engage angle (Lower location 0 degree)	(Lower location 0 degree)	

P81	Thread cutting start strengthen angle (Lower location 0 degree)	(Lower location 0 degree)	
P82	Cutting knife retracting angle (Lower location 0 degree)	(Lower location 0 degree)	
P83			
P84	Heavy-duty material start strenghen angle (Upper location 0 degree)	(Upper location 0 degree)	
P85	Heavy-duty material finish strenghen angle (Upper location 0 degree)	(Upper location 0 degree)	
P86	Upper & down distance location		
P87	Thread sweeping return delayed		
P88	Sewing brake distance		
P89	Ac overvoltage value		
P90			
P91			
P92	Initial angle of encoder	The parameter is not allowed to be adjusted by users	unrecoverable
P93	half-counterstep delayed time		
P94	Max. current		
P95	Sthengthen the low speed power		
P96			
P97	Stall time		
P98	Reverse stitching release time		
P99	Language selection	0: Closed 1: Chinese, 2: English	
P100	Inductive presser foot retention time		
P101	Thread slack start angle		
P102	Thread slack stop angle		
P103	Cloth inductive presser foot retention time		
P104	Pause delay time	Mode selection in initial reverse stitching, mode selection in terminated reverse stitching, mode selection in continuous reverse stitching, when	
P105	Electric & Pneumatic selection	0: electric, 1: pneumatic	
P106	ordinary current		
P107	Machine type	0: Lock stitch, 1: cover stitch	
P108	Interlock machine air absorption		
P109	The delayed time before thread sweeping		
P110	The return time of thread cutting		

P111	Encoder type selection, 0: without megnetic ring, 1: with magnetic ring		
P112	Full effort time of thread cutting		
P113	periodic signal of thread cutting action (%)		
P114	Thread cutting telease the buffer duty ratio (%)		
P115	Thread cutting release buffering time		
P116			
P117			
P118			
P119			
P120			