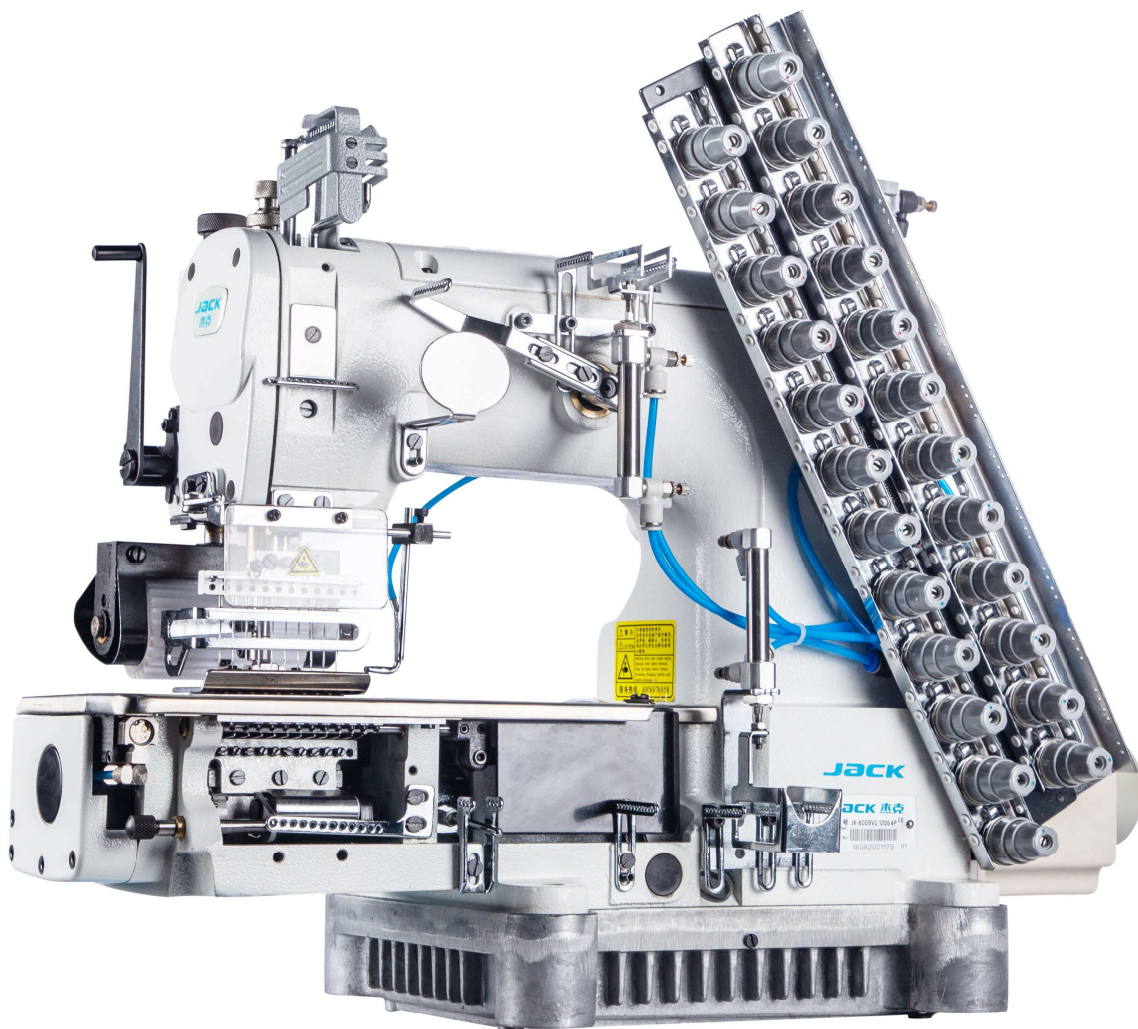




JK-8009VC

产品使用说明书&产品零件图册

Manual book & parts book

JACK 杰克

工业缝纫机安全使用注意事项：

1. 必须遵守基本措施；
2. 必须经过专业培训，对缝纫机设备性能、
3. 使用前应检查所有安全装置；
4. 在安装机针、更换机针、压脚、针板、送布牙、弯针、旋梭或修理时，应立即关闭电源；
5. 离开缝纫机或工作场所时应关闭电源；
6. 使用离合马达时，要等待马达完全停止后再进行；
7. 缝纫机及附属装置使用的机油，润滑油等液体流入眼睛或沾到皮肤上应立即清洗；
8. 禁止用手触摸缝纫机通电时的零件或装置；
9. 有关工业用平缝机与包缝机的修理、改造、主要机构的调整由专门技术人员来进行；
10. 一般的维修保养由专人进行；
11. 在电气方面的修理应在电气技术员的监督和指导下进行；
12. 缝纫机使用期间应定期清扫；
13. 为了正常安全运转，应安装地线，同时应在不受高频焊接机等强噪声源影响的环境下使用；
14. 电源插头应由专人安装；
15. 工业用平缝机、包缝机在指定用途以外不能使用。

环保要求：

1. 使用过程中产生的废油及其他废弃物请根据当地环保的要求进行合理的处置。
2. 请在使用完后及时关闭电源，减少电能的消耗。
3. 请在说明书要求的电压及环境下使用，已延长产品的使用寿命，减少废弃物的产生。
4. 机器报废后请勿将本机器及其附件作为普通的生活垃圾处理。请遵守本设备及其附件处理的本地法令，并支持回收行动。

Notes for safe use of industrial sewing machines:

1. Basic measures must be observed.
2. Pass the specialized training and master sewing machine equipment performance.
3. All safety devices should be checked before use.
4. When installing needle, and changing needle, presser foot, plate, feed dog, bent needle, hook or repairing, the power supply should be turned off immediately.
5. Power should be turned off when leaving the sewing machine or workplace.
6. When using the clutch motor, please wait until the motor stops completely.
7. The machine oil and other liquids used in sewing machines and ancillary devices should be cleaned immediately when they are put into eyes or touch skin.
8. Do not touch the parts or devices when the machine is powered by hand.
9. The repair, renovation and adjustment of the main mechanisms of the relevant industrial sewing machines and overseers shall be carried out by specialized technicians.
10. General maintenance is carried out by specially-assigned persons.
11. Electrical repairs should be performed under the supervision and direction of the electrical technician.
12. The machine should be cleaned regularly during operation.
13. In order to operate normally and safely, ground lines should be installed, and they should be used in an environment free from strong noise sources such as high frequency welding machine.
14. Power plug should be installed by specially-assigned person.
15. Industrial lockstitch sewing machine and overlock sewing machine can not be used except the designated use.

Environmental requirements:

- 1、Please dispose the waste oil and other waste products properly according to local environmental protection requirements.
- 2、Please turn off the power after use to reduce power consumption.
- 3、Please use under the voltage and environment required in the manual to extend the service life of the product and reduce waste generation.
- 4、Do not treat the machine and its accessories as ordinary household garbage after being scrapped. Please comply with local laws governing the disposal of the equipment and its accessories and support recycling operations.

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为了安全

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

- 拆除为保证安全所设置的装置，零件的情况下使用，是非常危险的，请绝对不要拆除后使用。

- 缝纫机在使用时，请不要在缝纫机台板上放置工具及缝纫时不必要的物品。

- 在对缝纫机进行检修、调节、清扫、穿线、换针等工作时，为防止发生事故，务必请切断电源，在确认即使踩下缝纫机踏板，缝纫机也不转动之后，再进行操作。

OBSERVE THESE SAFETY PRECAUTIONS

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

- To prevent accidents , do not remove safety devices or parts while operating the machine .

- Do not leave tools or other unnecessary objects on the machine table while operating the machine .

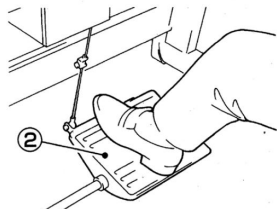
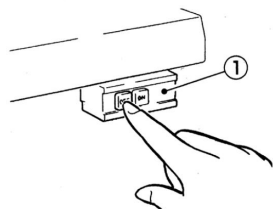
- Before maintenance , adjusting , cleaning , threading or replacing the needle , and to prevent accidents , be sure the power is turned off . Check that the machine will not operate when the pedal is pressed

注意

使用离合式马达的情况下，在关掉电源①后因惯性作用会继续旋转。这时如不注意踩动缝纫机踏板②时，缝纫机会突然动作，这是很危险的。请在关掉电源后，仍继续踩动踏板②，直至缝纫机完全停下来为止。

Note

In case a clutdh type motor is used , it will keep on rotating by inertia after turning off power supply . ①If the machine pedal ②is stepped on inadvertently , it is dangerous because the machine will move unexoectedly .keep on stepping on the pedal②until the machine comes to a stop after turning off power supply .



- 在离开缝纫机台时，务必请关掉电源。

- 停电时也请务必关掉电源。

- 为了总是安全地，运转良好的使用缝纫机，日常的点检是不可缺少的，请予以注意。

- Turn the power off before leaving the machine table .

- In the event of a power failure,be sure to turn the machine off.

- Check that the machine is securely ground

一、机器如何安装

1、依本机器所付桌板裁制图及零件组合图所列配件，依序安装防震机座及线架（图 1&2）

How to set up a machine

1、With reference to diagrams for table cutting and mounting part list,install vibration-reducing base and thread stand in sequence (Fig.1&2)

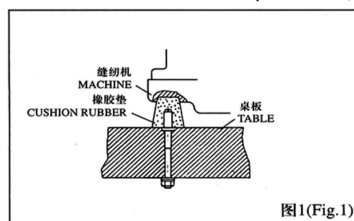


图1(Fig.1)

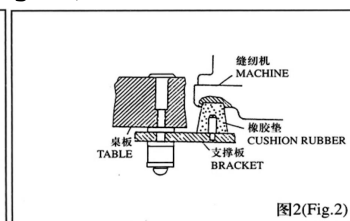


图2(Fig.2)

2、马达转向为顺时针方向，皮带的松紧度已手指向内压下 20mm 为宜，同时为安全起见，把皮带轮盖必须锁上（图 3&4）

2、Mount the machine head over the rest board
Connect the machine hand wheel to the clutch motor with the V-belt.Adjust the tension of the V-belt so that it can be about 20 mm bent inward when you press the center of V-belt and make sure the clutch motor turning direction is clockwise as shown Figure 3.Install the belt cover according to Figure 4.

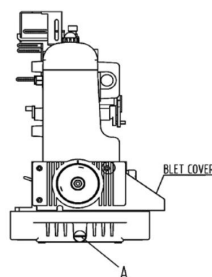


图3 (Fig.3)

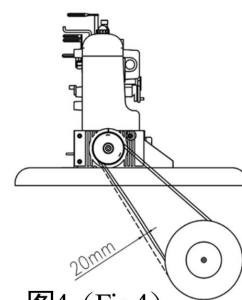


图4 (Fig.4)

3、皮带轮及缝纫转速，请参照（表 1）

3、Motor pulley size and sewing speed, please refer to table No 1

表 1(Table.1)

Machine Speed (s.p.m)转速/分	Motor Pulley Outer Diameter(mm)	
	60Hz	50Hz
4500	90	105
4000	80	95
3500	70	85

注意:

1、使用新机器最初一个月转速约为最高转速（表 1）的 80%，并请选择正确的马达皮带轮尺寸（表 1）。

2、桌板厚度为 40mm。

3、马达规格：离合器马达，3 相 2 级 400W（1/2HP）。

Note:

1、New machine run a speed approximately 80% of the Maximum speed in the first month (table.1).Be sure to choose proper motor pulley for your machine.

2、Table top is 40mm thick.

3.Specification of motor:clutchmotor3,phase,2poles, 400W(1/2HP)

二、润滑油的注入与更换

新机器运装前均已将油倒尽

(1) 润滑油的注入(图 5&6)

●将螺丝 A 旋开，以包装箱内所附的超高速润滑油或选用 MOBIL#10 或 AGIP 等相当的机油加入，使油面处于油标两刻度线之间为好，然后在锁紧螺丝 A；

●开箱新机器或久置未使用重新要用时，请在针棒、上钩针台、后拖轮传送轴(机器上涂红点的孔)等加油润滑(图 6-1、6-2、6-3)。

(2) 润滑油的更换(图 3)

●将螺丝 A 放松旋开，使油完全排出后再锁紧；

●为延长本机器的寿命，请于开始使用四个星期更换新油后约四个月更换一次。

(3) 滤油器的更换(图 7)

●本机器特别装有滤油器，约每使用一个月后卸下清洗，必要时更换新品。

Lubricant oil filling and change New machines are shipped out with empty chambers .please fill lubricant oil into new machines before run them.

1.Filling lubricant oil :(Fig.5&6)

● Loosen Knob (A) fill in with accompanied super-high-speed lubricant oil its equivalent such as

Mobil#10 or #32,until the oil up be-fween two marks on Insicator(C)

2. Lubricant oil change :(Fig.3)

● Loosen Knob (A) drain oil from the tank ,then tight it up.

● In order to p ro-long machine life ,please change lubricant oil after 4 week of operation.There after,change oil every 4 months.

3.Replacing oil filter:(Fig.7)

●Our machines are equipped with oil filters.Take our the filters and clean them up every month.Replace with new filters if necessary.

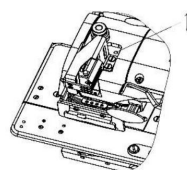


图6-1 (Fig.6-1)

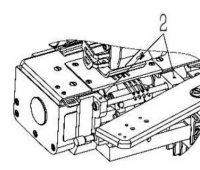


图6-2 (Fig.6-2)

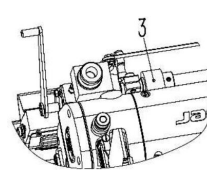


图6-3 (Fig.6-3)

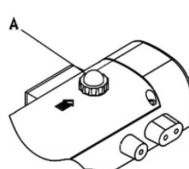


图5 (Fig.5)

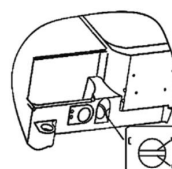


图6 (Fig.6)

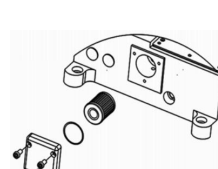


图7 (Fig.7)

三、针的更换

选用针的规格与尺寸请参照(表 2)

For specification and sizes of needles,please refer to(table.2)

NEEDLE SYSTEM 针规格	NEEDLE SIZE 针番号
SCHMETZ UY113GS	#70-#160
ORGAN UO113	#11-#18

1.拧下螺钉(A)并取下针。(图 8)

2.将新针插至含针孔最底端，并使针的凹面向自己。

3.重新锁紧螺钉(A)。

4.针与勾针有密切的关系。如果机针安装不正确，不但会引起跳针、断针、损伤勾针，务必注意。

How to replace needles

1.Loosen screw (A) and take out the used needle. (Fig.8)

2.Put new needle into the holder holes as they can go and left the long groove of needle face you and Fasten Screw (A)

3.Needle and loopers have close interaction.improper needle setting will skipping stitches,breaking Threads,and damaging loopers,please Pay fing attention to needle installation.

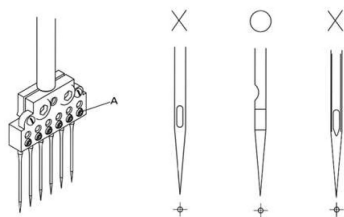


图8 (Fig.8)

四、穿线方法

- 1.按照图示穿线，错误穿线将引起断线、跳针或缝纫线迹不良等现象。(图 9)
- 2.在穿勾线时，将勾线座引出轴沿箭头方向拉出使勾线座向前弹出，然后进行穿线。(图 10)

Threading

- 1.Refer to the sewing type you need for correct threading .Any incorrect threading may cause thread brake 、uneven stitches or skip stitches. (Fig.9)
- 2.For looper threading ,pull out the lever of looper set the arron then thread properly .cause thread brake 、uneven stitches or skip stitches.(Fig.10)

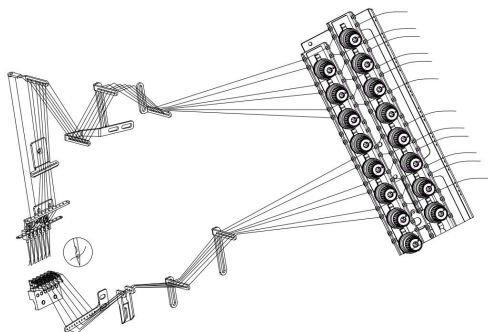


图9 (Fig.9)

五、控线的调整

- 1.控线强弱必须根据车缝材料种类，厚薄以及线与针距等不同来进行调整。将控线钮顺时针旋转时越紧，反之则越松。
- 2.针控线杆的调整(图 11)针线控线杆(B)根据缝线的种类来选择使用状态，放松螺钉(A)将(B)上下移动调整，在使用伸展性较大的缝线时将(B)上移，则针孔处的线环就会变大，利于勾线。

Thread tension adjustment

- 1.Thread temsion ,should be adjusted in regarding to kinds of threads fabrics,thickness of fabrics ,and stitch length efc. (Fig.9)

Turn thread knob clockwise for tighter tension and vice versa (Fig.11)

- 2.Adjustment.(Fig.12) The position for Needle thread Take-up Lever (B) is adjustable according to thread used. Loosen screw (A) ,move lever (B) up and down for the optimum position .For instance ,when using high extansion thread ,move lever (B) upward to make a bigger needle thread loop for lower to chain easily

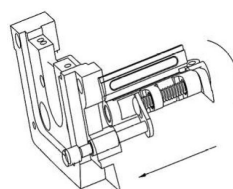


图10 (Fig.10)

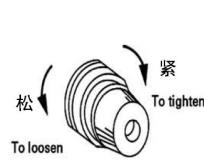


图11 (Fig.11)

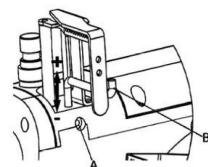


图12 (Fig.12)

六、机针高度调整

- 1.当针杆上升至最高点时，调整针尖与针板面的距离为 $13 \pm 0.5\text{mm}$ 。(图 13)
- 2.打开上方侧盖橡胶塞(A),并松开螺钉(B)，上下调整机针高度后在固定螺钉。(图 14)

注意：

机针高度调整后，必须确定每一根针是通过针板孔中央.(图 14)。

Needle position adjustment

- 1.Needle tip should be $13 \pm 0.5\text{mm}$ height from Needle plate when Needle Bar mores to its top position. (Fig.13)
- 2.The position of needle bar can be adjusted by [1] removing rubber cap (A) and loosening nut (B) ,[2] moving needle bar up and down ,to proper position and [3] tightening screw (B) ,and insert in cap (A). (Fig.14)

Note:

Be sure that every needle goes through the center of needle holes on Needle plate. (Fig.15)

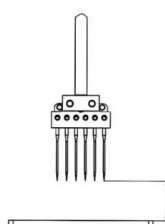


图13 (Fig.13)

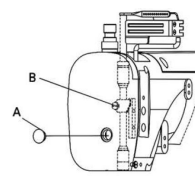


图14 (Fig.14)

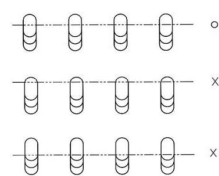


图15 (Fig.15)

七、护针的调整

拧松螺钉(A),调整护针使与机针的间隙为 0-0.1mm(图 16)后再锁紧螺钉(A)。

Needle guide adjustment

Loosen screw (A) to allow a gap of 0-0.1mm between needles and needle Guide (Fig.16) then tighten screw (A)。

八、针与弯针的调整

- 1.将弯针插入弯针架上,并稍微锁紧螺钉(A)。图(16)
- 2.转动手轮使针上升并使弯针尖向前至针的中心线。图(17)
- 3.调整弯针尖与机针侧的间隙为 0-0.5mm,再锁紧螺钉(A)

Adjustment between needles and looper

- 1.Put Loopers into Looper holder with screw (A) slightly tightened .(Fig.16)
- 2.Turn pulley to move looper point up to the center line of needle.(Fig.17)
- 3.Adjust the gap between needle tip and looper tip to be 0-0.05mm ,Tighten screw (A) up.

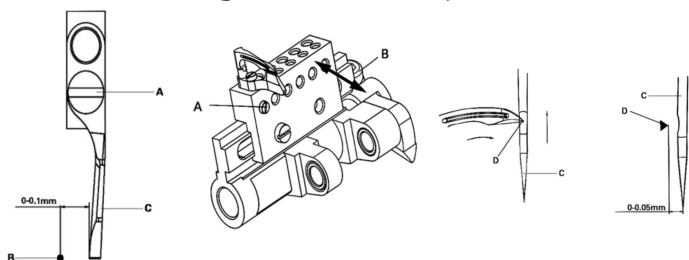


图16(Fig.16)

图17(Fig.17)

图18(Fig.18)

九、弯针的调整

当机针位于最低点时,弯针尖端与针中心线之间的间隙为 2.8mm(图 19)调整时将弯针底座驱动杆固定螺钉(B)放松,前后调整弯针座后在锁紧螺钉(B)。(图 17)

looper Adjustment

When needles are at the bottom end position ,the distance between looper tips and the center line of needles is 2.8mm. (Fig.19) To adjust the position of looper ,first loosen nut (B) on looper Holder and move back and forth to the proper position .Then tighten nut (B).(Fig.17)

十、针杆上下运动与弯针的位置关系

针棒由最低点开始往上移,且弯针尖由后死点往前移至右边如(图 20)(A) 所示位置时,弯针尖由前死点位置往后移

至针的右边如(图 19)(B)所示位置,弯针即为正确位置。

调整时将弯针前后带动偏心凸轮(A)(图 21)的固定螺钉(B)放松,前后调整偏心凸轮(A)的位置,向前移则针对弯针的时间较快,向后移则较慢。

Timing of needle and loopers movement

While needles move up from bottom end position and loopers also move forward from rear end position until looper point reach the right side edge of needle (Fig.20)(A) ,the looper point should be 1.5mm away from the top edge of needle eye .

While needles move down from top end position and loopers also move backward to front end position until same location as above shown on Fig.20(B). Looper point should be 3.0mm away from the top edge of needle eye .For adjustment by loosening screws (B) and move the position of Eccentric Cam (A) (Fig.21) back and forth ,the speeds of needles and loopers. Movement can be adjusted slower or faster coordinately

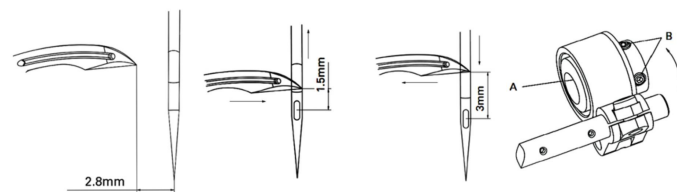


图19(Fig.19)

图20(Fig.20)

图21(Fig.21)

十一、弯针与拨线杆的关系

当拨线杆(A)于左死点位置时,拨线杆(A)右端与弯针右端之间的间隙为 0.5-1mm。(图 23)而弯针与拨线杆(A)之间的间隙 0-0.1mm。(图 24)

调整时:

- 1.先拧松在稍微锁紧拨线杆心轴固定螺钉(C)(图 23)。
- 2.旋转手轮使拨线杆心轴连杆(D)移至左死点位置。
- 3.调整使符合上述条件、再锁紧螺钉(C)

Interrelation of and thread weavers

When thread weavers are at the left dead end position ,the right side of thread weavers is away from the right side of loopers by 0.5-1mm (Fig.23) And ,the gap between loopers and Thread Weavers is 0-0.1mm(Fig.24)。

For adjustment:

- 1.Loosen but slightly screw (C) on the shaft of thread

weavers (Fig.23)

2.Turn belt pulley to move the lever of thread weavers (D) to left dead end.

3.Adjust loopers and thread weavers to meet all requirements mention above then tighten screw (C)

十二、拨线杆的固定

拨线杆(A)与机针间隙如图 22)所示为 0.2-0.4mm, 当针杆在下死点位置时, 将固定螺钉(B)(图 23)拧松, 并调整拨线杆(A)至图 22)所示尺寸并注意各杆的平行, 再锁紧螺钉。

Setting of thread weavers

The gap between thread weavers and needles is (Fig.22), about 0.2-0.4mm. Move needle bar to its low bottom end position then loosen screws (B) (Fig.23)

and move thread weaver .to position shoen

(Fig.22),then tight screw (B) Be sure all Thread

Weavers are paralleled when tightening screw (B)

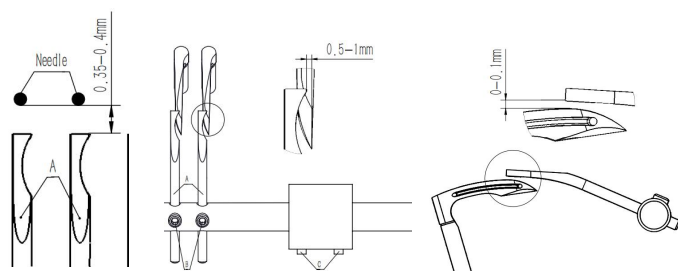


图22 (Fig.22)

图23 (Fig.23)

图24 (Fig.24)

十三、弯针线挑线量的调整

当针尖下降至弯针背面的中心位置时, 弯针线挑线杆(A)也正好由下死点开始往上抬。

挑线量调整: 图(25)

1.先放松偏心凸轮(F)固定螺钉(C)前后调整至正确位置, 再锁紧(C),往前往前摆动快, 往后摆动慢。

2.微调时, 拧松螺钉(E), 将过线器(B)上下移动调整再锁紧螺钉(E)。线的出线量因所使用的线而异, 其出线量为:

棉线, SP 线: 7-10mm(D)(图 26)。

伸缩尼龙线: 10-15(D)(D)(图 26)

Adjustment of looper thread take-up

When the needles tip were moved down to the position of the center of loopers back ,the looper thread take-up lever (A) starts to move upward from its bottom dead end 。

For adjustment (Fig.25)

1.Loosen screw (C) to release eccentric cam (F) and

move eccentric cam to a proper position ,by turning forward for faster and backward for slower take-up motion ,Then tighten screw.

2.For micro-adjustment:Loosen screw (E) and move Thread Guide (B) up and/or down to the proper position then tighten screw (E) .The quantity of thread feeded varies with the kinds of thread.

For refence:

Cotton \$ sp thread:7-10mm (D) (Fig.26)

Nylon thread :10-15mm(Fig.26)

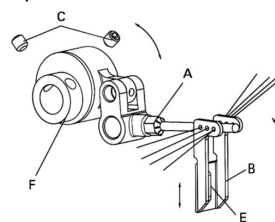


图25 (Fig.25)

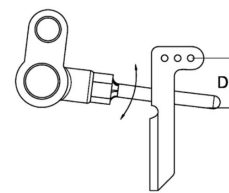


图26 (Fig.26)

十四、送布牙的调整

送布牙(C)升至最高点时, 送布牙齿顶与针板面的距离为 0.8-1.5mm, 平均为 1.2mm。(图 27)

送布牙的调整: (图 28)

1.拧松送布牙(C)的固定螺钉(A)。

2.上下移动送布牙(C)使符合上述条件时, 再锁紧螺钉(A)。

3.将高度固定销(D)的固定螺钉(B)松开, 调整固定销直到送布牙的底部再锁紧螺钉(B)。(图 28)

4.此时应该确认送布牙(C)左右方向的平行。

Feed dog adjustment

When feed dogs .(C) move to the highest position ,the distance from the tips of feed dogs to the face of Needle plate is 0.8-1.5mm.The average is 1.2mm (Fig.27)。

For adjustment: (Fig.28)

1.Loosen screw (A) on Feed Dog (C)。

2.Move Feed Gog (C) up and/or down to meet above requirement then tighten screw (A)。

3.Loosen screw (B) and move stop pin (D) upward to the bottom of Feed Dog (E) ,then fighten screw (B) (Fig.28)

4.Be sure to check the parallel among feed dogs。

十五、送布牙平行的调整

送布牙上升至最高时应与针板平行(图 27)。调整:

夹紧螺栓(F), 将螺帽(G)放松, 调整送布牙螺钉(E), 使送

布牙(C)与针板平行(图 28)再锁紧螺帽(G)。

Feed dog's parallel adjustmen

When the feed dogs are at the highest position they should be parallel to Needle plate surface (Fig.27)。 For adjustment:

Holding screw nut (F) firmly and loosen screw (G) then to adjust screw (E) for the teeth surface of Feed Dogs ,is paralleled needle plate (Fig.28)

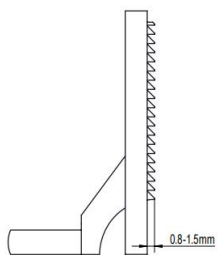


图27 (Fig.27)

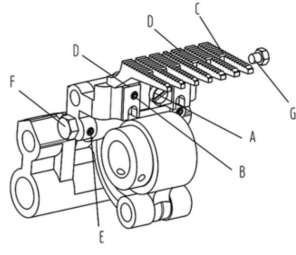


图28 (Fig.28)

十六、针距的调整

- 1.压下针距调整按钮(A),并转动手轮,使按钮卡住针距调整组件,再转动手轮至所需针距后,放松此按钮。(图 29)
- 2.欲增大针距时,将手轮往逆时针方向旋转,反之则小,调整针距时,马达需在停止状态。

Stitch length adjustme

- 1.Push stitch length regulator bottom (A) and turn pulley until the bottom lock inthe stitch regulator.Then ,turn pulley again to reach desired stitch length.then,release the bottom (Fig.29)。
- 2.Turn pulley clockwise for longer stitch length,vicever'sa.Be sure to turn off motor when adjusting。

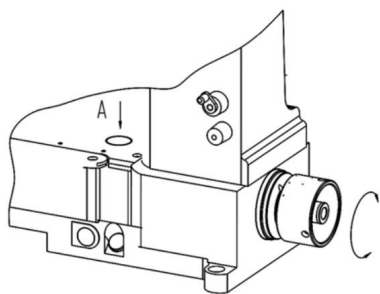


图29 (Fig.29)

十七、后拖轮的调整

当针杆由下极限位置往上移 24mm,后拉引轮开始转动,即为正确的位置关系。

调整: (图 30)

- 1.拧松偏心凸轮(B)固定螺钉(A)后,再稍微锁紧。
- 2.旋转手轮至上述条件后,再锁紧螺钉(A),往前转则变快,往后则变慢。

Rear puller adjustment

When needle bar moves upward from its dead bottom end about 24mm, the rear pulley cam starts moving 。 To adjust:(Fig.30)

- 1.Loosen screws (A) on eccentric cam (B) then tighten a little bit.
- 2.Turn pulley to have Needle Bar and rear puller reach their proper tinerrelat-ed position .Then tighten screw (A) .Turn eccentric cam forward to have faster motion .Vice ver'sa

十八、后拉引滚轮供给量的调整

- 1.取下上盖,拧松连杆(A)上的螺帽(B)。(图 31)
- 2.将连杆(A)前后移动,往前移动(C 方向)则供给量小,往后移(D 方向)则供给量大。
- 3.微调时,放松螺帽(A)将连杆(B)上下移动,往上量多。(图 32)

Feeding adjustment of rear puller

- 1.Take off cover and Release nut (B) on connector (A)。(Fig.31)
- 2.Move connector (A) back and forth for more or less feeding length ,toward (C) dilection reduce feeding length。
- 3.For micro adjustment .release nut (A) and move connector (B) upward for longer and downward for shorter feeding length respectively 。 (Fig.32)

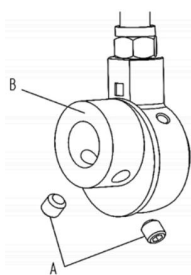


图30 (Fig.30)

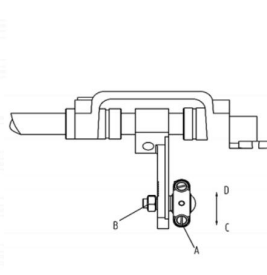


图31 (Fig.31)

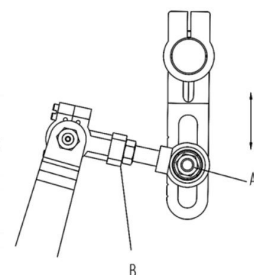


图32 (Fig.32)

十九、上下滚轮间隙的调整

上下滚轮的间隙: 将下滚轮放至下死点在自由状态时,上滚轮与下滚轮的齿间隙为 0.5mm(图 33),且两滚轮平行。调整:

- 1.两滚轮平行调整: 将螺钉(A)放松,调整两滚轮平行后,稍紧螺钉(A)上下移动固定座(C),使上下滑动顺畅,再锁紧螺钉(A)。(图 33)
- 2.间隙 0.5mm 的调整: 如图(图 34)所示,调整螺钉(H),

使上下滚轮的间隙为 0.5mm 再锁紧螺帽(D)(图 34)稍放松螺钉(K)并调整连杆(J)，使螺钉(L)与连杆(J)的长圆孔下方的间隙为 0.5mm，再锁紧螺钉(K)。

3.上滚轮压力的调整：将压力调整螺钉(A)往顺时针方向转动，则压力加大，反之压力减小。(图 35)

Gap adjustment of top and lower rollers

The feeth gap between top and lower rollers should be 0.5mm (Fig.33) ,when the lower roller is free and at its dead bottom end and parallel to the top roller.

To adjust:

1.Paralleling adjustment :

Paralleling Loosen screw (A) .and top and lower rollers parallel .Tighten screw (A) slightly and move frame Base (C) up and down to its smooth .The tighten screw(A) 。 (Fig.33)

2.Gap referring (Fig.34):

Loosen nut (D) and turn screw (H) to reach 0.5mm gap between top and lower rollers .Then tighten screw nut (D) .(Fig34) release screws (K) slightly and adjust connector (J) to keep the space between the bottom edge of screw (L) and the edge of slot on connector (J) at 0.5mm.Then tighten screw (K)。

3.Pressure adjust:

Turn pressure control konb (A) clockwise to increase the pressure of top 。 roller,vice ver'sa (Fig.35)

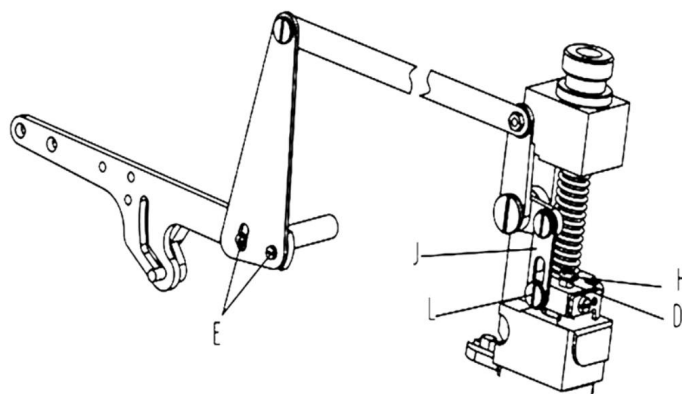


图34 (Fig.34)

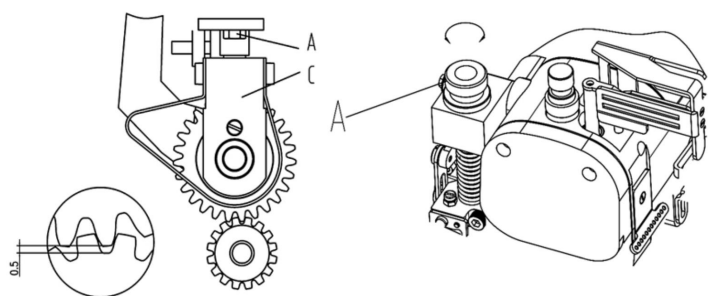


图33 (Fig.33)

图35 (Fig.35)

二十、气管连接示意图(图 36)

Diagrammatic sketch of trachea connection
(picture36)

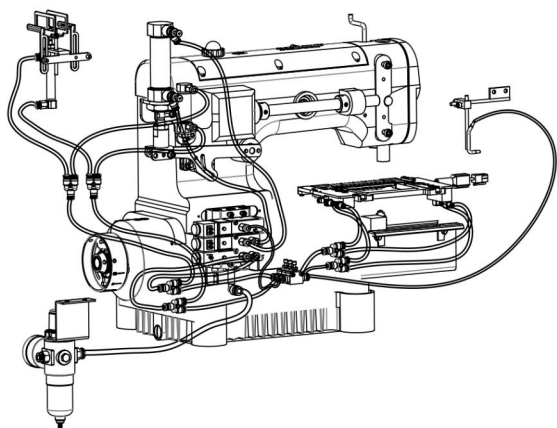


图 36

二十一、工作气压调整

Adjusting Air pressure

调节旋钮 A, 使气压达到 $0.45-0.55\text{kg/cm}^2$, 气压过高可能造成运动部件损坏(图 37)

Adjust knob A, make air pressure $4.5\sim 5.5\text{kgcm}^2$, to high pressure will damage moving parts(picture37)

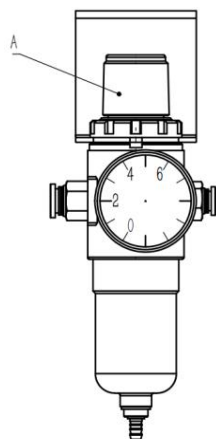


图 37

二十二、切线速度调整

Adjusting Cutting Speed

节流阀 AB 调整剪线动作时的速度。如果节流阀 A 调节过松, 将会导致切线速度过快和切入位置不准确, 造成切线错误; 如果节流阀 B 调节过松, 将会导致切线速度过快, 造成线头过短 (图 38)

Air valve A and B controls the speed of Cutting. If screw A is too loosened, the knife holder will protrude too fast and then the position of the knife holder will become unstable, causing cutting errors. If screw B is too loosened, the knife holder will retract too Fast and then the looper thread may not be held

properly.(picture38)

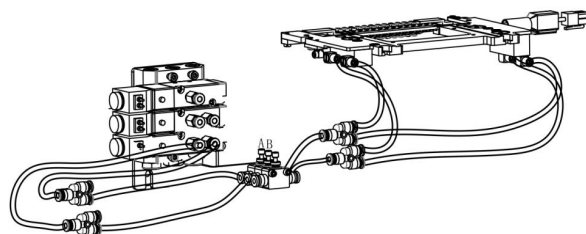


图 38

二十三、脚踏控制器 (图 39)

Pedal Control Asm(picture39)

A、前踏。机器启动, 根据前踏力度调整机器运行速度。

B、常态。机器不运转, 机针处于最高点。

C、后踏。机器运行后后踏, 剪线抬压脚; 机器未运行后踏, 只抬压脚

A、 Press foot pedal forward to start machine.Strength control speed.

B、 Foot pedal in normal position ,needle stop on the top.

C、 Press foot pedal backward after operation , cutting and raising the presser foot. Only press foot pedal backward, raising the presser foot.

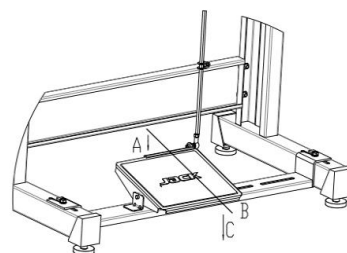


图 39

二十四、动刀位置调整

Adjusting The Movable Knife

松开螺钉 B, 调整动刀 A, 使得动刀的刀尖刚好对准机针 C 圆柱体的左边边缘, 然后拧紧螺钉 B。(图 40)

Release screw B, adjust the movable knife A, make the movable knife tip alignment needle left , then tighten screw B.(picture40)

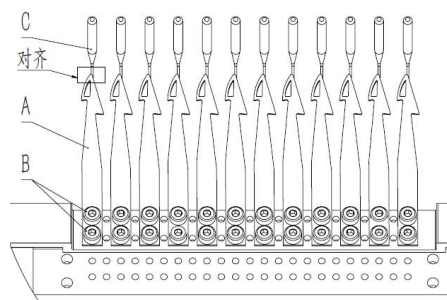


图 40

二十五、定刀位置调整

Adjusting The Stationary Knife

松开螺钉 C 调整定刀位置。要求动刀退到底时，动刀刃口距离定刀刃口不小于 0.6mm，然后拧紧螺钉 C (图 41)

Release screw C, adjust the stationary knife B. When the movable knife retracted fully, make the movable knife edge over the stationary knife edge greater than 0.6mm, then tighten screw C. (picture 41)

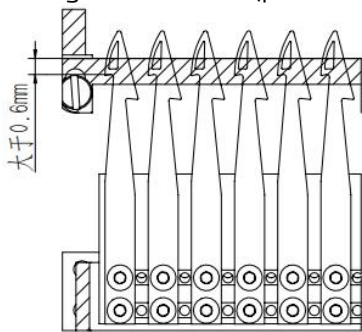


图 41

二十六、压线片位置调整

Adjusting the platen

拧松螺钉 C。调整压线片与动刀对齐紧靠，压线片 A 缺口位置在动刀槽的左边约 0.6mm，然后拧紧螺钉 C。(图 42)

Release screw C, adjust the platen alignment to the movable knife A, the gap of platen is on the left of the movable knife notch 0.6mm apart, then tighten screw C. (picture 42)

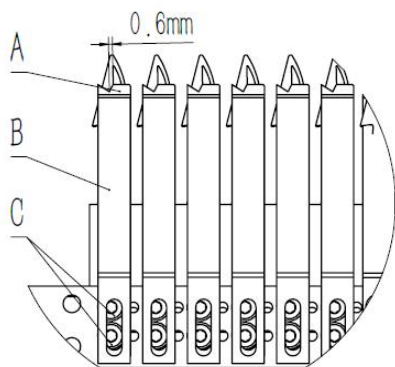


图 42

二十七、剪线动作示意图

Diagrammatic sketch of thread cutting

剪线时，动刀往前进入线环内，刃口 A 勾住左边面线，刃口 B 勾住底线往回退，与定刀刃口相碰剪断线，底线夹在动刀与压线片之间。(图 43)

To cut the thread, the movable knife move forward to the thread loop, the cutting edge A hooked on the needle thread, the cutting edge B hooked on the looper thread, then the movable knife move

backward to the stationary knife. Then the looper thread is held by the stationary knife and the back spring. (picture 43)

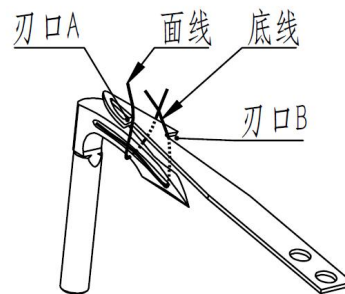


图 43

二十八、吹气位置调整

Adjusting The Air Outlet

拧松螺钉 A，调整吹气管 C 往左边靠，同时出气口与机针对齐，然后拧紧螺钉 A。

拧松螺钉 B，调整吹气口高度距离缝台面 3-5mm，然后拧紧螺钉 B。(图 44)

Release screw A, adjust the blowpipe C lean to the left and the air outlet alignment to the needle, then tighten screw A. Release screw A, adjust the air outlet 3-5mm above the sewing table, then tighten screw B. (picture 44)

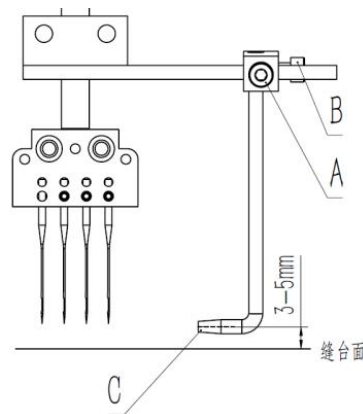


图 44

电控使用说明

Instruction Manual

一、安全说明:

Safety instructions

1、安装和调试前, 请认真仔细阅读本手册。

Please read this manual carefully before installation and debugging.

2、本产品须受过专业培训的人员来安装或操作。

This machine must be installed or operated by trained personnel

3、严禁用户改动控制器任何部分的结构, 否则, 由此而产生的一切后果, 由用户自己承担全部责任。

It is strictly forbidden for the user to modify the structure of any part of the controller. Otherwise, all consequences arising therefrom shall be solely the responsibility of the user.

4、确保电源安全接地并符合产品铭牌上标示的电压范围及技术要求。

Ensure that the power supply is safely grounded and meets the voltage range and technical requirements indicated on the product nameplate.

5、接通电源开关时, 请把脚移离机器脚踏板。

When turning on the power switch, please move your feet away from the machine pedal

6、在进行以下操作时, 必须先断开系统电源:

You must first power off the system when doing the following:

A 安装机器时;

When installing the machine;

B 在控制器上插拔任何连接插头时;

When plugging or unplugging any connector on the controller

C 穿针线、换机针及翻抬机头时;

Threading when changing the needle and lifting the machine head

D 机器维修及机器休息不用时;

When machine maintenance and machine breaks are not in use

7、设置系统控制参数或进行保养维修工作应由受过相关培训的人员来完成。

Setting system control parameters or performing maintenance work should be performed by trained personnel.

8、每次关闭电源后重启, 应在相隔 5 秒钟以上

Restart after turning off the power every 5 seconds

9、系统接地线必须可靠连接!

The system ground wire must be connected safely and reliably!

二、使用说明:

Operating instructions

1、显示及操作界面

Display and operation interface

本控制器使用双位数码管显示实现参数调整, 两个数码管和两个按键。

This controller uses a two-digit digital tube display for parameter adjustment, two digital tubes and two keys.



图 1 双显数码管操作界面

Figure 1 Dual display digital tube operation interface

2、用户参数设置

user parameter settings

开机显示为工作界面, 左数码管显示“P”, 右数码管段位不停旋转 (旋转的方向和电机的旋转方向相反)。

The start-up display is the work interface, the left digital tube displays "P", and the right digital tube rotates continuously (the direction of rotation is opposite to the direction of rotation of the motor).



图 2 用户参数界面 (正常开机显示界面)

Figure 2 user parameter interface (normal boot display interface)

短按左键 P, 进入用户参数设置界面后, 短按左键 P 变更参数项, 按右键 S 后, 显示对应参数值, 继续按 S 键可调节数值; 如果参数修改, 短按左键 P 保存, 显示“OK” (如图 3), 并回到下个参数显示界面, 如果参数值没有修改则直接回到下一个参数显示界面。在设置界面内电机运行将退出到待机界面。P 界面序列号按下面表格循环:

Short press the left button P, after entering the user parameter setting interface, short press the left button P to change the parameter item. After pressing the right button S, it is displayed of the corresponding parameter value. Continue to press the S button to adjust the value. If the parameter is modified, press the left button P to save it, "OK" will be displayed (as shown in Figure 3), and return to the next sequence number display interface. The motor running in the setting interface will exit to the standby interface. The serial number of the P interface is cycled according to the following table

用户参数 User parameters		
参数 parameters	参数作用 Parameter effect	参数说明 Parameter Description
V	速度参数 Speed parameter	速度=显示值 x100 (转/分) Speed = displayed value x 100 (rev / min)
M	自动停针 功能开关 Automatic needle stop function	0: 关闭自动停针功能 1: 打开自动停针功能 本系统无自动停针功能, 所以只为 0 0: Turn off the automatic needle stop function 1: Turn on the automatic needle stop function
B	旋转方向 参数 Rotation direction parameter	控制电机顺时针或者逆时针旋转 Control the motor to rotate clockwise or counterclockwise



图 3 显示 OK

Figure 3 Show OK

3、厂商参数设置

manufacturer settings

在待机界面长按右键 S 和左键 P 组合键 (约 3s) 可进入厂商参数设置界面, 第 1 位数码管显示 “F” 第 2 位数码管不显示 (以下简称 F 界面, 是设置界面之一) 如图 4 所示。

In the standby interface, long press the right button S and the left button P (about 3s) to enter the manufacturer parameter setting interface. The first digital tube displays "F" and the second digital tube does not display (hereinafter referred to as the F interface, which is the setting interface A) As shown in Figure 4.

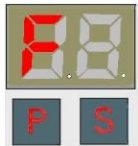


图 4 显示 F 界面

Figure 4 Show F

进入厂商参数设置界面后, 短按左键 P 变更参数项, 按右键 S 后, 显示对应参数值, 继续按 S 键可调节数值; 如果参数修改, 短按左键 P 保存, 显示 “oK” (如图 3), 并回到下一个序列号显示界面, 如果参数值没有修改, 则直接返回到下一个序列号显示界面。在设置界面运行电机时, 会退出到待机界面。F 界面序列号按下表格循环:

厂商参数 manufacturer parameter			
参数 Parameter	参数作用 Parameter function	参数范围 Parameter range	参数说明 Parameter description
L	最高转速 限制参数 Maximum speed limit parameter	05-45	如 L 为 40, 那 V 最大只能调节到 4000 转 If L is 40, then V can only be adjusted to 4000 rpm
C	起缝速度 Sewing speed	1-9(默认数值 1) (Default value 1)	数值越大提速越快 The larger the value, the faster the speed
n	点针参数 Needle point parameter	0-9(默认数值 3) (Default value 3)	数值越大点针区间越大 The larger the value,the larger the needle interval.
U	过压报错使能 Whether to display Over voltage error	0-1(默认数值 1) (Default value 1)	0: 不使能 1: 使能 0 : can not display 1:display
r	软件版本号 Software version	/	/
A	/	/	/

警告: 厂商参数禁止修改, 用户私自修改参数导致的任何问题, 一切后果由用承担。

Warning: It is forbidden to modify the manufacturer parameters. Any consequences caused by the user's unauthorized modification of the parameters shall be borne by the user.

4、恢复出厂设置

Restore factory settings

在待机界面, 长按右键 S 键 3s, 所有的参数恢复为用户保存的值, 数码管显示 “oK”。

In the standby interface, press and hold the right button S for 3s to restore all parameters to the values saved by the user. The digital tube displays "oK".

在显示版本号的界面, 长按右键 S 键 3s, 用户保存的参数恢复为出厂的值, 数码管显示 “oK”。

On the interface displaying the version number, press and hold the right button S for 3s to restore the parameters saved by the user to the factory values. The digital tube displays "OK".

5、用户参数保存

User parameter saving

在 “A” 界面, 长按右键 S 键 3s, 保存当前参数为恢复出厂设置时候的默认参数。

In the "A" interface, press and hold the right button S for 3s to save the current parameters as the default parameters when restoring factory settings.

6、报错一键清除
Error one-click clear

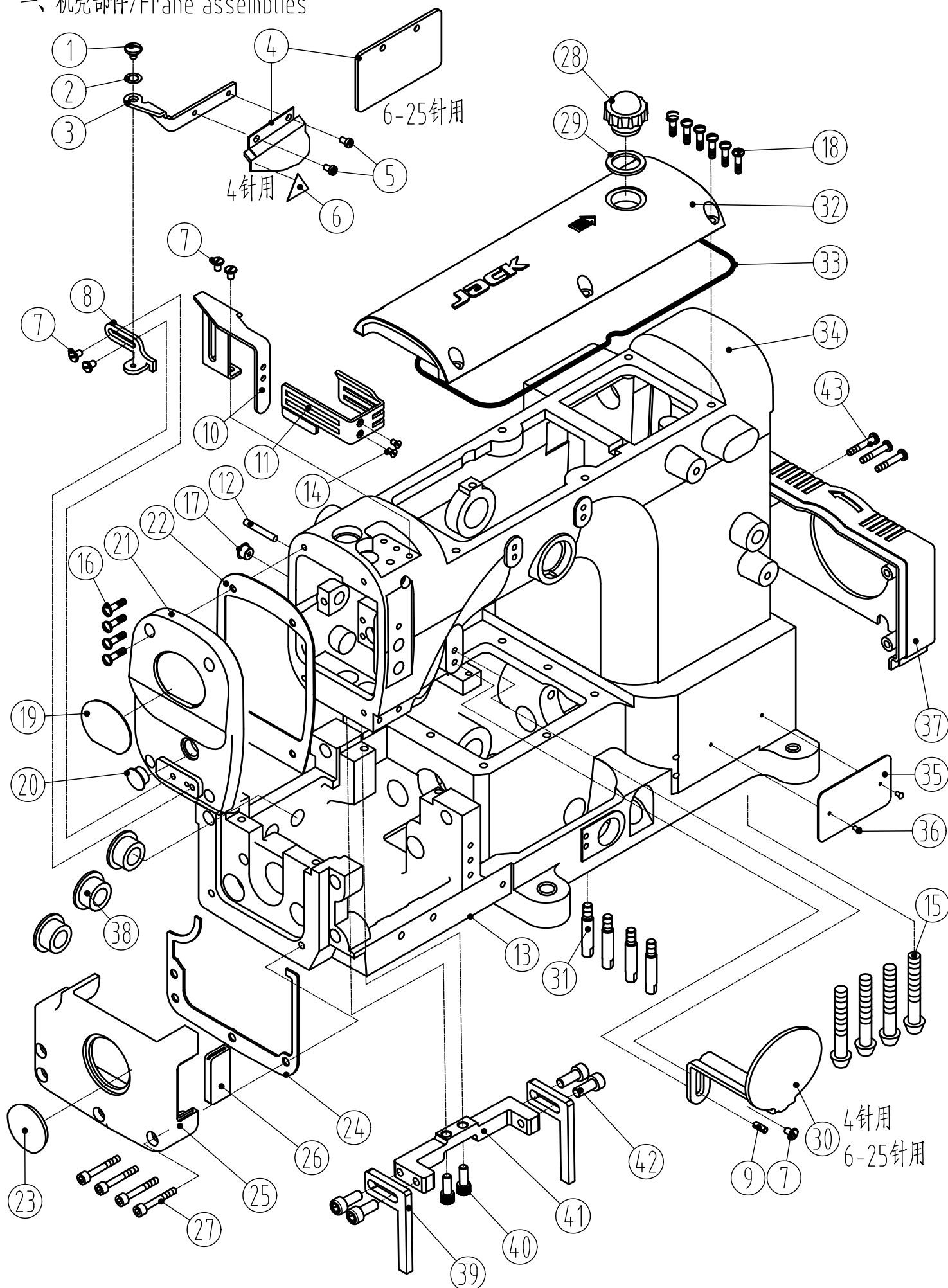
当系统报错显示错误报警 E4 后，解决问题后，按 P 键可清除报警。详细的报错代码表见错误代码说明表。

When the system reports error E4, after solving the problem, press and hold the left button P to clear. See the error code description table for detailed error code table.

7、错误码说明表
Error code description table

错误码 error code	内容 content
E1	电机堵转 Motor stalled System
E2	过流 Over current
E4	电机霍尔信号异常 Motor Hall signal abnormal
E6	调速器信号异常 speeder signal abnormal
Eb	系统过电压 over voltage

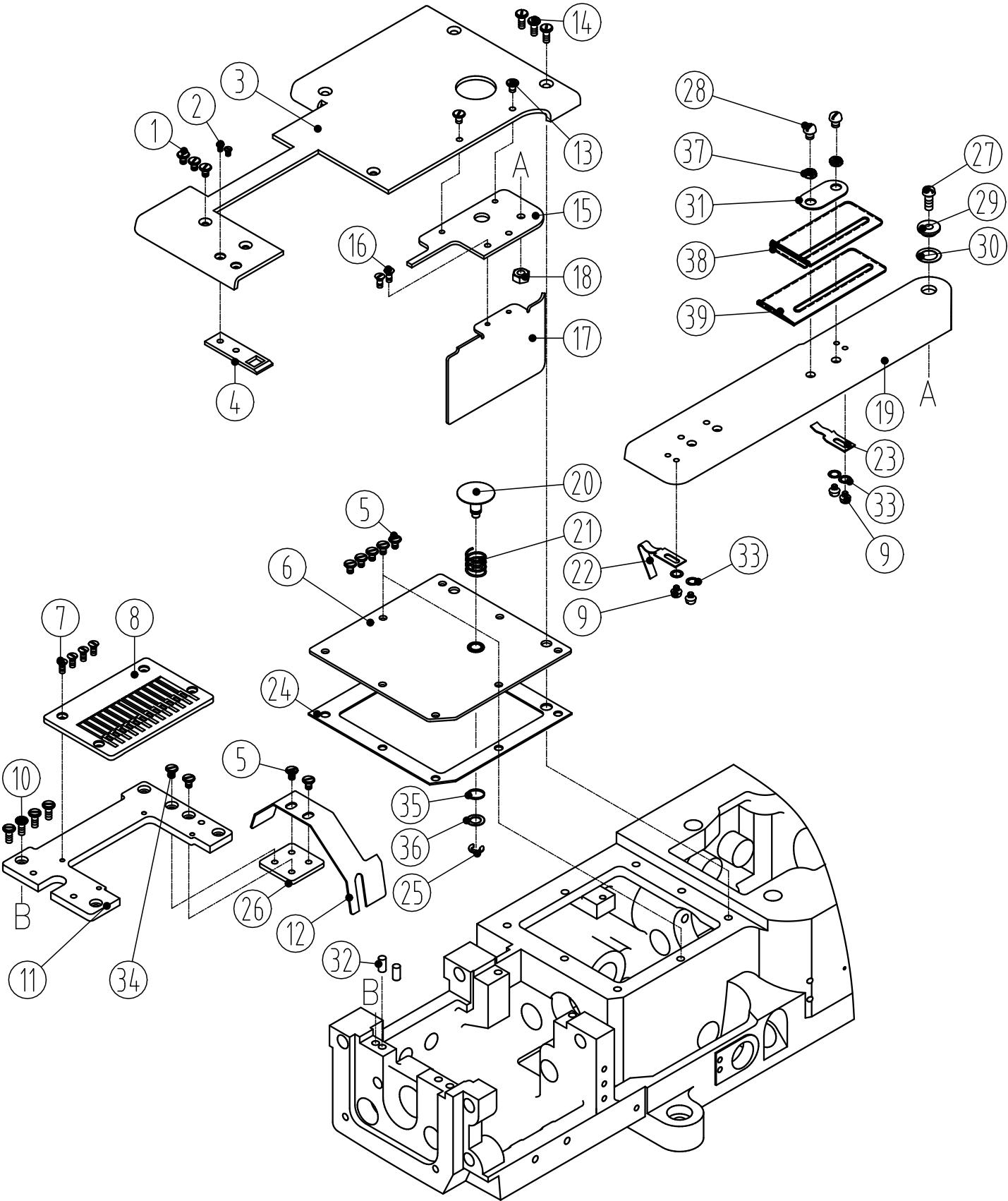
一、机壳部件/Frame assemblies



一、机壳部件/Frane assemblies

序号 No	件 号 ParNo.	参考件号 RefPartNo	名 称	Description	数 量 Number	备注 Remark
1	305S20001	SM 49E	轴位螺钉M 4	Screw	1	
2	30528001	KP60	波形弹性垫圈 $\phi 6.4 \times \phi 11 \times 0.3$	Washer	1	GB/T955
3	30512001	DA80	断针防护罩架	Eye Guide Assy.	1	
3	130512005	DA80	断针防护罩架 (2针)	Eye Guide Assy.	1	
4	30511001	KC69	断针防护罩 (4针)	Eye Guide Assy.	1	4针机专用
4	30511003	VA07P	断针防护罩(6-25针)	Eye Guide Assy.	1	6-25针专用
4	130511008	VA07P	断针防护罩(2针)	Eye Guide Assy.	1	2针专用
5	S04016	SM 132	复合槽圆柱头螺钉M 3.5×6	Screw	2	
6	20131063	MA84	警告牌	Brand	1	
7	113S11004	SM 433	开槽圆柱头螺钉M 4×8	Screw	5	
8	30512002	MA79	断针防护罩架座	Guide	1	
8	130512004	MA79	断针防护罩架座 (2针)	Guide	1	
9	P03025	PM 413	弹性圆柱销 $\phi 4 \times 12$	Pin	1	GB/T879.1
10	30512003	VA19P	针杆上挑线防护罩座 (喷漆)	Eye Guide Assy.	1	930001468
11	30512004	MA82	针杆上挑线防护罩 (喷漆)	Eye Guide Assy.	1	930001469
12	30526001	PM 404	抬压复位拉簧销	Pin	1	
13	30501005	VA01	机座	Lower Machine	1	930001769
14	301S17002	SM 152	开槽沉头螺钉SM 1/8 " ×4.4	Screw	2	
15	S05001	-----	内六角圆柱头螺钉M 10×30	Screw	4	GB/T70.1
16	S01057	-----	开槽圆柱头螺钉M4×15	Screw	4	GB/T 65
17	30522001	KH48	橡皮塞 $\phi 9.2$	Oil Seal	1	
18	S04019	SM 44B	十字槽盘头螺钉M 4×12	Screw	6	GB/T818
19	13837002	VA06	商标	Brand	1	
20	30322009	KH48	橡皮塞 $\phi 12.2$	Oil Seal	1	
21	30501047	VA05	机头左盖 (喷漆)	Left Cover	1	930001601
22	30501049	VA04	机头左盖密封垫	sticker	1	
23	30522004	VA24	机座右盖橡皮塞 $\phi 31.1$	Oil Seal	1	
24	30522003	VA24	机座右盖密封垫	sticker	1	
25	30501002	VA25	机座右盖 (喷漆)	Left Cover	1	930001471
26	30522005	VA25-2	机座右盖橡皮垫	sticker	1	
27	305S12002	SM 416	内六角圆柱头螺钉M 4×30	Screw	7	
28	20111005	KC57	油窗	Oil Sight Window	1	
29	20122018	KC58	油窗密封垫	sticker	1	
30	30512085	VA06	挑线过线板防护罩 (4针)	Eye Guide Assy.	1	4针机专用
30	30512086	VA06	挑线过线板防护罩 (6-25针)	Eye Guide Assy.	1	6-25针机专用
31	305S20003	SM 670	机头支撑螺钉M 6×11	Screw	4	
32	30501048	VA02	上盖 (喷漆)	Top Cover	1	930001602
33	30522024	A03	上盖密封圈	Oil Seal	1	
34	30501051	VA08	机头	Upper Machine	1	930001769
35	30537003	VA26	机型牌	Brand	1	
36	R03001	KA33	铆钉2.5*4	Screw	1	
37	30511002	VA23	带轮盖	Bel Cover Assy.	1	非直驱配备
38	13522008	-----	橡皮塞 $\phi 25.5$	Oil Seal	3	
39	130509002	-----	针夹头导向杆	Pin	2	21针专用
40	S05004	SM 670	内六角圆柱头螺钉M 5×14	Screw	2	21针专用
41	130501040	-----	导向杆固定座	Rivet Seat	1	21针专用
42	305S13004	SM 670	螺钉M 6×14.8	Screw	4	21针专用
43	305S20002	SM 670	内六角圆柱头螺钉M 4×35	Screw	3	非直驱配备

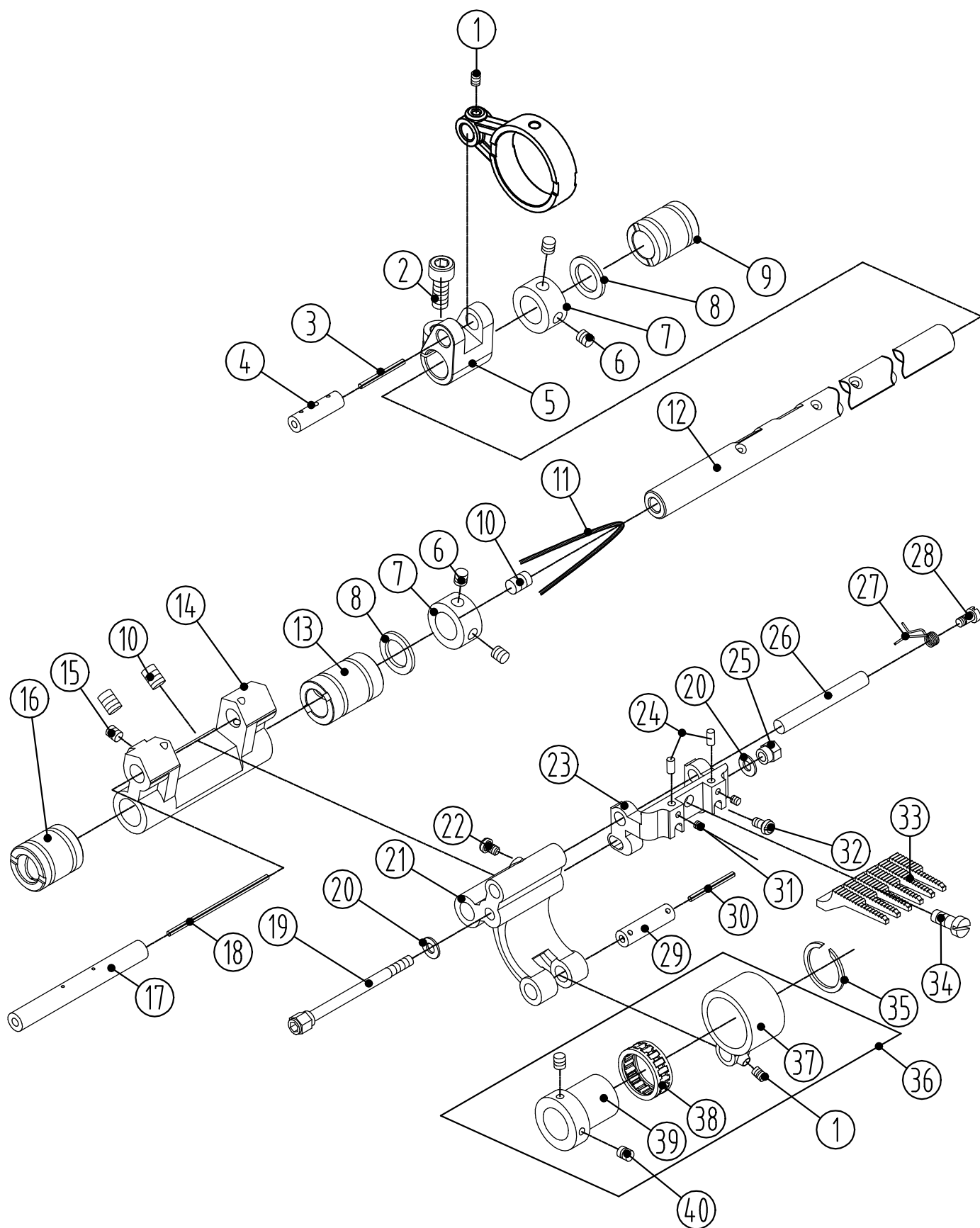
二、缝台盖部件/Cloth Plate assemblies



二、缝台盖部件/Cloth Plate assemblies

序号 No	件 号 No.	参考件号 RefPartNo	名 称	Description	数 量 Num ber	备注 Rem ark
1	S03002	SM 496	开槽半沉头螺钉M 4×3.5	Screw	3	
2	S02007	SM 152	开槽沉头螺钉M 3×5	Screw	2	
3	30512067	VB07	后缝台组件	Cloth Plate Cover	1	VW L、UT专用
3	13051206400	VB07	后缝台组件(喷漆)	Cloth Plate Cover	1	930001332
3	13051206600	VB07	后缝台组件(21针)	Cloth Plate Cover	1	930001972
4	30512008	VB12	前缝台限位板	Caiko	1	
5	L02003	SM 433	六角头螺栓M 4×7	Screw	7	
6	30512009	VB02	缝台下防油盖板组件	Cover	1	组件30512009
6	30512059	VB02	防油盖板	Cover	1	
6	30503037	VB02	针距调节按钮套	Cover	1	
7	301S17001	SM 160	开槽半沉头螺钉SM 9/64"×40×6.7(进口)	Screw	4	
8	30515009	E9xxx	针板 (04064)	Needle Plate	1	
8	30515019	E9xxx	针板 (04080)	Needle Plate	1	
8	30515001	E9xxx	针板 (04085)	Needle Plate	1	
8	30515013	E9xxx	针板 (04095)	Needle Plate	1	
8	30515012	E9xxx	针板 (06048)	Needle Plate	1	
8	30515003	E9xxx	针板 (06064)	Needle Plate	1	
8	30515011	E9xxx	针板 (06080)	Needle Plate	1	
8	30515051	E9xxx	针板 (06095)	Needle Plate	1	
8	30515015	E9xxx	针板 (08032)	Needle Plate	1	
8	30515021	E9xxx	针板 (08048)	Needle Plate	1	
8	30515004	E9xxx	针板 (08064)	Needle Plate	1	
8	30515017	E9xxx	针板 (08085)	Needle Plate	1	
8	30515018	E9xxx	针板 (12032)	Needle Plate	1	
8	30515010	E9xxx	针板 (12048)	Needle Plate	1	
8	30515002	E9xxx	针板 (12064)	Needle Plate	1	
8	30515005	E9xxx	针板 (13064-32)	Needle Plate	1	
8	30515006	E9xxx	针板 (17032)	Needle Plate	1	
8	130515004	E9xxx	针板 (21048)	Needle Plate	1	
8	30515016	E9xxx	针板 (23032)	Needle Plate	1	
8	30515008	E9xxx	针板 (25032)	Needle Plate	1	
9	S01073	SM 130	开槽圆柱头螺钉M 3.5×3	Screw	4	
10	S01005	SM 433	开槽圆柱头螺钉M 4×10	Screw	4	
11	30512021	VB07	针板座	Bracket	1	
11	130509023	VB07	针板座(21针)	Bracket	1	
12	3052200600	VB18	打线杆防油板组件	Feed Bar Oil Seal	1	组件3052200600
12	30512018	VB18	打线杆防油板	Cover	1	
12	30522007	VB18	打线杆防油板橡胶块	Cover	1	
13	305S11005	SM 152	开槽圆柱头螺钉SM 9/64"×40×4	Screw	2	
14	S01038	SM 435	开槽球面圆柱头螺钉M 4×10	Screw	3	
15	30512011	VB11	前后缝台连接板	Sheet Iron	1	
16	301S17001	SM 160	开槽半沉头螺钉SM 9/64"×40×6.7(进口)	Screw	2	
17	30512012	VB11-1	缝台前罩板	Blind	1	
18	N01004	NM 511	螺母M 5	Nut	1	
19	30512066	VB14	前缝台	Side Cover	1	VW L专用
19	130512063	VB14	前缝台	Side Cover	1	UT专用
19	130512065	VB14	前缝台(喷漆)	Side Cover	1	930001331
20	30502001	VB04	针距调节按钮	Button	1	
21	30527001	VB03	针距调节按钮复位弹簧	Spring	1	
22	30512014	VB15	前缝台左卡簧	Kaiko	1	
23	30512017	VB16	前缝台右卡簧	Kaiko	1	
24	30522012	VB01	缝台下防油盖板密封垫	Washer	1	
25	11329020	EM 050	开口挡圈5	Ring	1	
26	30512015	VB19	打线杆防油板固定板	Blind	1	
26	130512069	VB19	打线杆防油板固定板(21针)	Blind	1	21针专用
27	403S11023	SM 534	开槽球面圆柱头螺钉M 5×14	Screw	1	
28	S01060	SM 630	开槽圆柱头螺钉M 6×10	Screw	2	
29	30503001	VB13	前缝台旋转垫圈	Washer	1	不锈钢缝台用
29	130508006	VB13	前缝台旋转垫圈	Washer	1	喷漆缝台用
30	30528002	WM A40	波形弹性垫圈 $\phi 11 \times \phi 14.6 \times 0.3$	Washer	1	
31	30512016	VB17	卷边龙头压板	Washer	1	
32	P01006	-----	针板架定位销 $\phi 5 \times 10$	Pin	2	
33	W 01005	-----	垫圈3	Washer	4	
34	113S11004	-----	松线导管压板螺钉	Screw	2	
35	20622009	-----	O型圈	Sticker	1	
36	20628008	-----	垫片	Washer	1	
37	205S16002	-----	螺母	Nut	2	
38	130512056	-----	右导布板	Cloth Guide	1	
39	130512055	-----	左导布板	Cloth Guide	1	

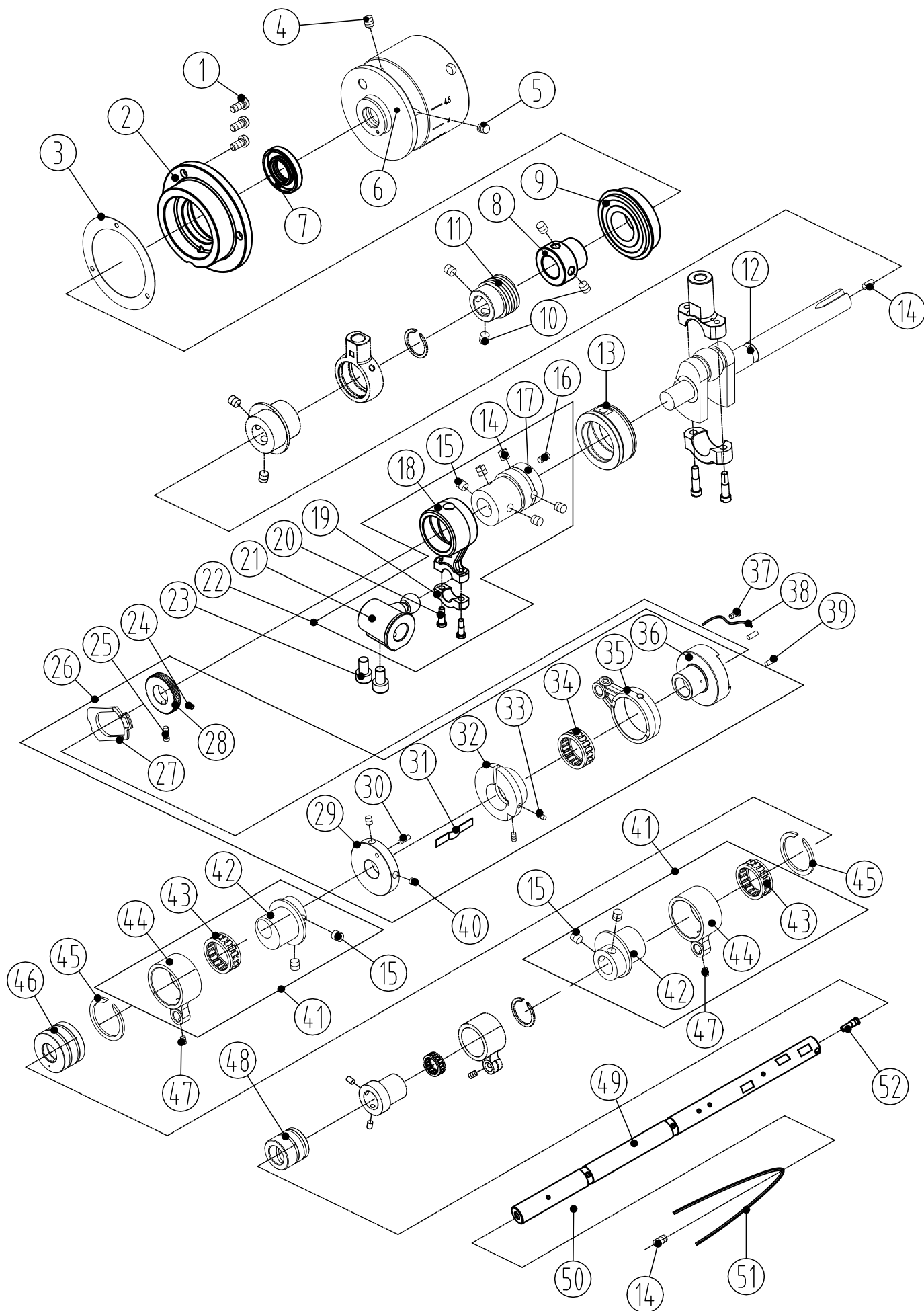
三、送料部件/Feed assemblies



三、送料部件/Feed assemblies

序号 No	件 号 Part No.	参考件号 Ref Part No	名 称	Description	数 量 Num ber	备注 Rem ark
1	305S14003	SM 103	内六角锥端紧定螺钉M 3.5×5	Screw	2	
2	S05002	SM 612	内六角圆柱头螺钉M 6×0.75×15.2	Screw	1	
3	20123021	VC11	油线	Oil Wick	1	
4	30526002	VC08	送布曲柄销	Pin	1	
5	30504001	VC07	送布曲柄	Crank	1	
6	S10014	SM 502	内六角凹端紧定螺钉M5×4	Screw	4	
7	30508001	M H 73	挡圈 $\phi 12 \times \phi 20 \times 10$	Ring	2	
8	20128031	CL13	垫圈 $\phi 12.1 \times \phi 18 \times 1.5$	Washer	2	
9	30503002	VC09S	送料轴右轴套	Sleeve	1	
10	S09002	-----	内六角平端紧定螺钉M6×6	Pin	3	
11	20523005	VD30D-2	油线	Oil Wick	1	
12	30502002	VC06	送料轴	Shaft	1	
13	30503004	VC03S	送料轴中轴套	Bushing	1	
14	30504002	VC02	牙架曲柄	Crank	1	
15	305S14001	SK270	内六角锥端紧定螺钉SM 11/64"×40×5	Screw	1	
16	30503005	VC01S	送料轴左轴套	Bushing	1	
17	30502003	VC12	牙架曲柄轴	Pin	1	
18	20123021	VC13	油线	Oil Wick	1	
19	305S12003	SK496	牙架固定螺钉	Screw	1	
20	W 01006	W K01	垫圈 $\phi 4.6 \times \phi 10 \times 0.8$	Washer	2	
21	30504003	VC14D	牙架座	Feed Bar	1	
22	S04041	SM 131	复合槽螺钉M 3.5×5	Screw	1	
23	30506001	VC16D	牙架	Feed	1	
24	30526005	PM 301	送布牙顶销	Pin	2	
25	305S16001	NK55	螺母SM 11/64"×40	Nut	1	
26	30526006	VC18D	牙架轴	Pin	1	
27	30527002	VC19	送布座复位扭簧	Spring	1	
28	305S20004	SK497	轴位螺钉M 3.5	Screw	1	
29	30526003	VC21	抬牙连杆销	Pin	1	
30	20123021	KM 15	油线	Oil Wick	1	
31	305S14002	SK216	内六角平端紧定螺钉SM 1/8"×44×3	Screw	2	
32	S01062	SK213	开槽球面圆柱头螺钉SM 1/8"×44×6.5	Screw	1	
33	30514009	D9xxx	牙齿 (04064)	Feed Dog	1	
33	30514020	D9xxx	牙齿 (04080)	Feed Dog	1	
33	30514001	D9xxx	牙齿 (04085)	Feed Dog	1	
33	30514013	D9xxx	牙齿 (04095)	Feed Dog	1	
33	30514012	D9xxx	牙齿 (06048)	Feed Dog	1	
33	30514003	D9xxx	牙齿 (06064)	Feed Dog	1	
33	30514011	D9xxx	牙齿 (06080)	Feed Dog	1	
33	30514024	D9xxx	牙齿 (06095)	Feed Dog	1	
33	30514015	D9xxx	牙齿 (08032)	Feed Dog	1	
33	30514022	D9xxx	牙齿 (08048)	Feed Dog	1	
33	30514004	D9xxx	牙齿 (08064)	Feed Dog	1	
33	30514018	D9xxx	牙齿 (08085)	Feed Dog	1	
33	30514019	D9xxx	牙齿 (12032)	Feed Dog	1	
33	30514010	D9xxx	牙齿 (12048)	Feed Dog	1	
33	30514002	D9xxx	牙齿 (12064)	Feed Dog	1	
33	30514005	D9xxx	牙齿 (13064-32)	Feed Dog	1	
33	30514006	D9xxx	牙齿 (17032)	Feed Dog	1	
33	130514005	D9xxx	牙齿 (21048)	Feed Dog	1	
33	30514017	D9xxx	牙齿 (23032)	Feed Dog	1	
33	30514008	D9xxx	牙齿 (25032)	Feed Dog	1	
34	305S11001	SK265	开槽圆柱头螺钉SM 11/64"×40×12	Screw	1	
35	30508004	VC23	无耳挡圈 $\phi 17.5 \times \phi 20.5 \times 1.1$	Spring	1	
36	3051000100	-----	抬牙连杆组件	Feet	1	组件3051000100
37	30505001	VC22D	抬牙连杆	Eccent	1	
38	30524001	VC24	滚针轴承K18×22×15.7	Bearing	1	
39	30510001	VC25	抬牙偏心凸轮	Eccent	1	
40	201S14002	-----	内六角凹端紧定螺钉SM 11/64"×40×5	Screw	2	

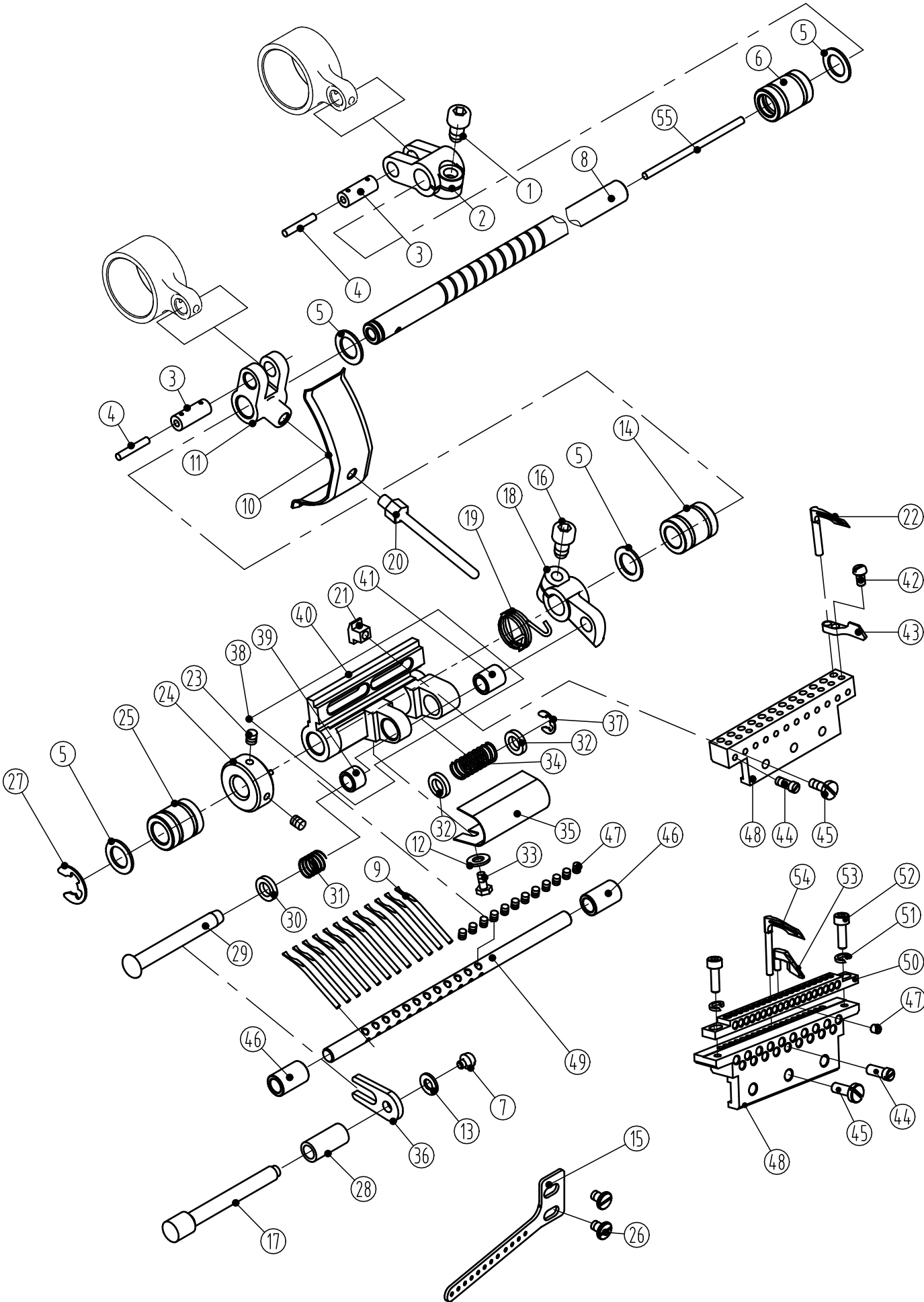
四、主轴部件/Crankshaft drive assemblies



四、主轴部件/Crankshaft Drive assemblies

序号 No	件 号 Part No.	参考件号 RefPartNo	名 称	Description	数 量 Num ber	备注
1	S01011	SM 532	开槽圆柱头螺钉M 5×10	Screw	3	
2	I30503004	-----	轴承座	Bearing Cover	1	
3	30522008	VD05	后主轴右轴套密封垫	Washer	1	
4	S12001	SM 604	内六角锥端紧定螺钉M 6×8	Screw	1	
5	S09007		内六角平端紧定螺钉M 6×8	Screw	1	
6	30535001	VD01	皮带轮（喷漆）	Machine Pulley	1	930001473
7	I3052200200	-----	油封组件	Oilwick	1	
8	I30503003	-----	后轴轴承套	Bearing Cover	1	
9	B10002	-----	深沟球轴承（6004-2RSNR）		1	
10	S10029	SM 602	内六角凹端紧定螺钉M6×0.75×5（进口）	Screw	4	
11	30525001	VD04	蜗杆	Worm	1	
12	30502004	VD07	后主轴	Crank Assembly	1	400056
13	30503009	VD08	后主轴左轴套	Bushing	1	
14	S09002	SM 606	内六角平端紧定螺钉M 6×6	Screw	6	
15	S09010	SM 602	内六角平端紧定螺钉M 6×5	Screw	5	GB/T77
16	P01007	PM 401	销子	Pin	1	组件3050402300
17	30510002	VD09	喂针摆动偏心凸轮	Eccent	1	
18	30505003	-----	喂针摆动球连杆杆部	Crank Assembly	1	
19	30505004	-----	喂针摆动球连杆头部	Crank Assembly	1	
20	305S14008	SM 139	螺钉	Screw	2	
21	30504010	VE42	喂针摆动球曲柄	Crank	1	
22	3050402300	-----	喂针摆动球连杆组件	Crank Assembly	1	
23	305S13006	SM 610	内六角圆柱头螺钉M 6×0.75×10	Screw	2	
24	305S14009	-----	内六角平端紧定螺钉M 3.5×5	Screw	1	
25	305S14010	-----	开槽圆柱头螺钉M 3.5×9	Screw	1	
26	3050502100	-----	送布连杆组件	Deliver Fabric Assy.	1	组件3050502100
27	30509020	KP74	针距调节滑块	Ratchet	1	
28	30525015	VD46	针距调节齿轮	Gear Wheel	1	
29	30510016	VD47	送布固定轮	Deliver Wheel	1	
30	30526030	KP18-1	送布凸轮定位销	Pin	1	
31	30508010	-----	送布凸轮弹簧片	Spring	1	
32	30510017	VD44	送布凸轮	Cam	1	
33	413S14004	-----	内六角平端紧定螺钉M 3×4	Screw	2	
34	30524005	-----	滚针轴承K32×28×10	Bearing	1	
35	30505024	VD45	送布连杆	Link	1	
36	30510018	VD43	针距调节凸轮	Cam	1	
37	S01024	-----	轴位螺钉SM 1/8"×44	Screw	1	
38	30527011	-----	针距调节滑块复位扭簧	Spring	1	
39	S07001	-----	轴肩螺钉M 3	Screw	2	
40	201S14002	-----	内六角凹端紧定螺钉SM 11/64"×40	Screw	2	
41	3051000500	-----	偏心凸轮组件	Eccent Assembly	2	组件3051000500
42	30510005	VD31	偏心凸轮	Eccent	2	
43	30524004	VD24	滚针轴承K28×24×15.5	Bearing	2	
44	30505006	VD25	连杆	Rod	2	
45	30508003	VD26	卡簧φ22×φ25.4×12	Spring	2	
46	30503011	VD27	前主轴右轴套	Bushing	1	
47	305S14003	SM 103	内六角锥端紧定螺钉M 3.5×5	Screw	2	
48	30503010	VD28	前主轴左轴套	Bushing	1	
49	I30502028	VD29	前主轴	Shaft	1	
50	20123021	VD30D-2	油线	Felt	2	
51	20523005	VD30D	油线	Oilwick	1	
52	I01S30005	-----	下轴限油螺钉	Screw	1	

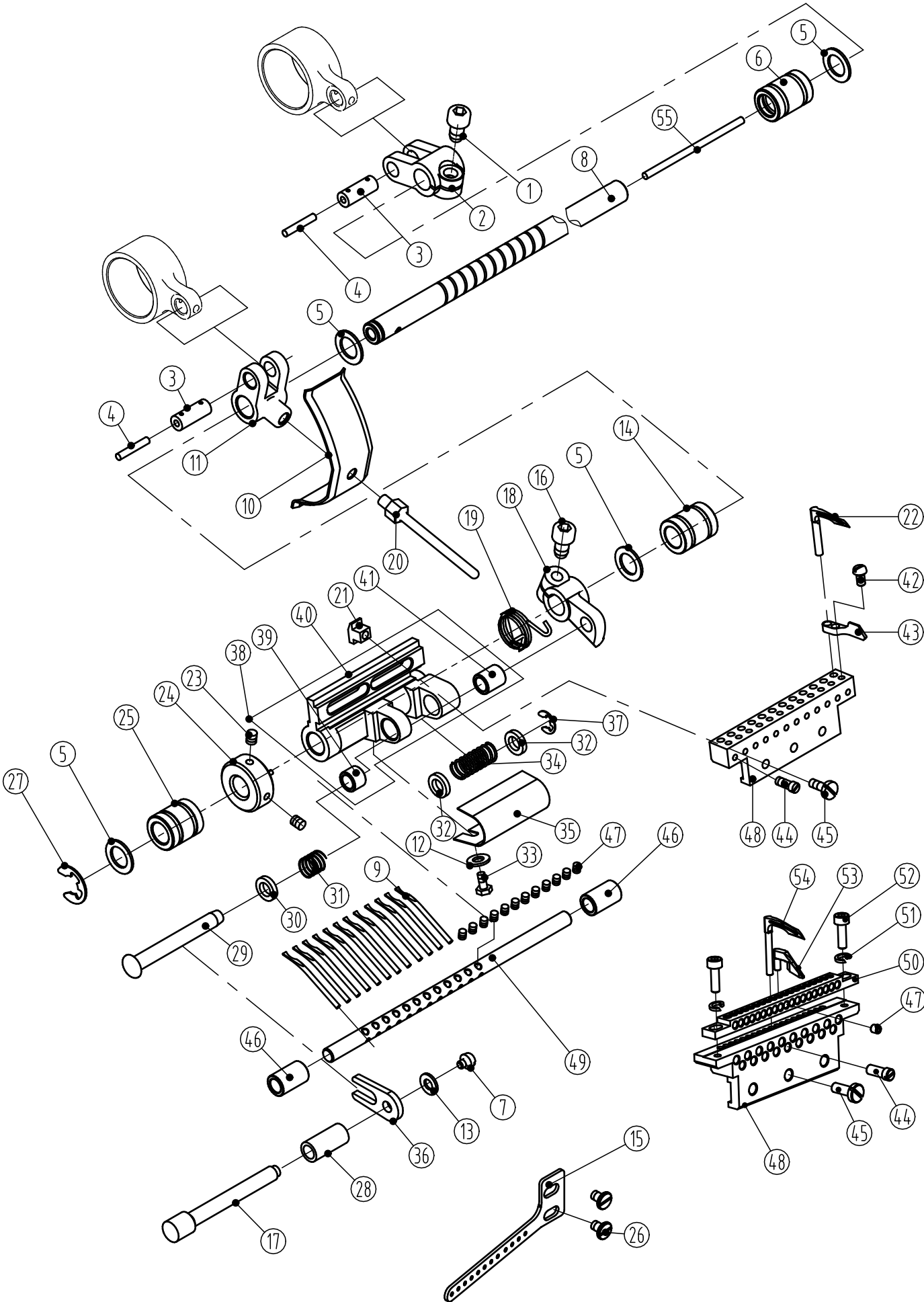
五、勾线部件/Thread takeup assemblies



五、勾线部件/Thread Takeup assemblies

序号 No	件 号 Part No.	参考件号 Ref.Part No	名 称	Description	数 量 Num ber	备注 Rem ark
1	S05018	SM 610	内六角圆柱头螺钉M 6×0.75×12	Screw	1	
2	30504004	VE01	弯针架座摆动曲柄	Crank	1	
3	30526008	VF10	销子	Pin	2	组件3050500900
4	20123021	VC11	油线	Oil Wick	1	
5	20128010	KL11	垫圈 $\phi 10.2 \times \phi 16 \times 1$	Washer	4	
6	30503012	VE09S	弯针架座轴右轴套	Bushing	1	
7	211S12002	-----	开槽六角头螺钉	Screw	1	
8	30502006	VE04	弯针架座轴	Shaft	1	
9	30517003	VE30	前拔线喂针	Spreader	4	
10	30512024	VE10D	挡油板	Feed Bar Oil Seal	1	
11	30504005	VE05	打线杆曲柄	Crank	1	
12	W 01005	W M 100	垫圈3	Washer	1	GB/T971
13	W 01005	W M 100	垫圈3	Washer	1	
14	30503013	VE03S	弯针架座轴中轴套	Bushing	1	
15	30513001	VE32	弯针过线板（4针）	Thread guide	1	4针机专用
15	30513002	VE32	弯针过线板（6-13针）	Thread guide	1	6-13针机用
15	30513028	VE32	弯针过线板（17-25针）	Thread guide	1	17-25针机用
16	S05017	SM 511	螺钉M 6×0.75×13.5	Screw	1	GB/T70.1
17	30502007	VE23	弯针架座倒前拉杆	Adjusting Bar	1	
18	30504006	VE07	弯针架座右挡圈	Crank	1	
19	30527004	VE08	弯针架座复位扭簧	Spring	1	
20	305S30002	VE06	打线杆	Thread Takeup	1	UT专用
20	130513025	VE06	打线杆	Thread Takeup	1	
21	30509004	VE45	弯针架左右调节块	Nut	2	
22	30517002	VE51	弯针	Looper	1	每台数量需乘相应机型针数
22	30517006	VE51	弯针（032用）	Looper	1	每台数量需乘相应机型针数
23	S10002	SK270	内六角凹端紧定螺钉M 5×5	Screw	2	
24	3050800400	VE13D	弯针架座左挡圈组件	Collar	1	
24	30508005	-----	弯针架座左挡圈	Collar	1	组件3050800400
24	30526009	-----	销2×10	Pin	1	
25	30503014	VE14S	弯针架座轴左轴套	Bushing	1	
26	113S11004	SM 431	开槽圆柱头螺钉M 4×8	Screw	2	GB/T65
27	H05011	EM 090	开口挡圈9	Spring	1	GB/T896
28	30503018	VE27S	弯针架座倒前拉杆轴套	Bushing	1	
29	30526022	VE15	弯针架座倒前离合轴	Link	1	
30	30528006	VE16	垫圈 $\phi 6.6 \times \phi 11 \times 2.2$	Washer	1	
31	30527006	VE17	弯针架座倒前拉杆左弹簧	Spring	1	
32	11628004	-----	垫圈 $\phi 7.5 \times \phi 12 \times 1$		2	
33	305S12005	SM 331	六角头螺栓SM 1/8"×44×7	Screw	1	
34	30527005	VE21	弯针架座倒前拉杆弹簧	Spring	1	
35	30512025	VE25	弯针架座护线罩	Band	1	
36	30512026	VE24	弯针架座倒前拉杆牙叉	Washer	1	
37	11329020	EM 060	开口挡圈5	Spring	1	GB/T896
38	3050403100	VE11	弯针架固定座组件	Rivet Seat	1	组件3050403100
39	30503016	VE18S	弯针架固定座左轴套	Bushing	1	
40	30504007	VE11	弯针架固定座	Rivet Seat	1	
41	30503015	VE22S	弯针架固定座右轴套	Bushing	1	
42	S01062	SK213	开槽球面圆柱头螺钉SM 1/8"×44×6.5	Screw	1	每台数量需乘相应机型针数
43	30517001	VE49	护针	Needle Guard	1	每台数量需乘相应机型针数
43	30517008	VE50	护针（13针）	Needle Guard	1	每台数量需乘相应机型针数
44	305S11002	SK532	开槽圆柱头螺钉SM 9/64"×40×8.5	Screw	1	每台数量需乘相应机型针数
45	101S11009	SK237	开槽圆柱头螺钉SM 9/64"×40×10.5	Screw	3	

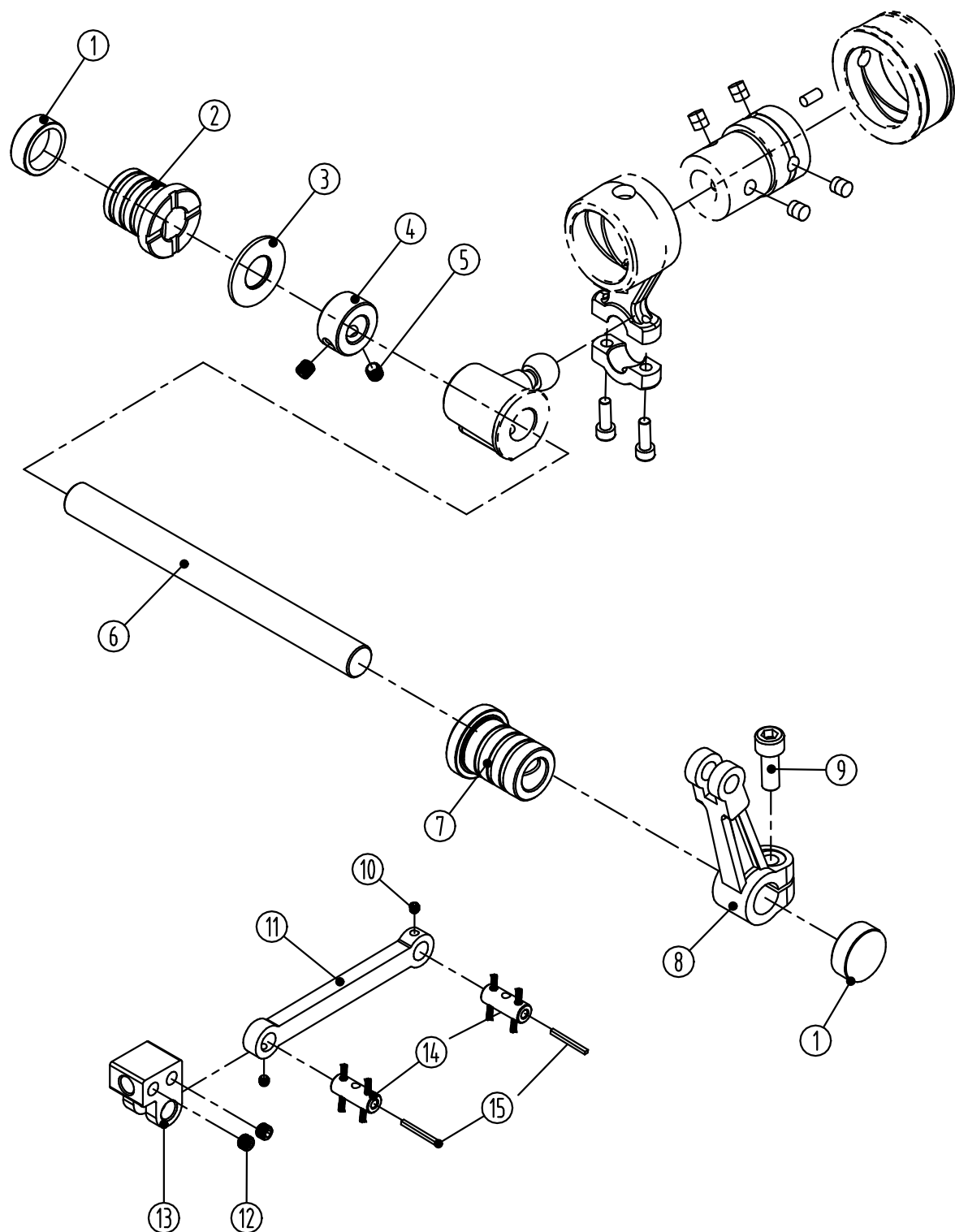
五、勾线部件/Thread takeup assemblies



五、勾线部件/Thread Takeup assemblies

序号 No	件 号 Part No.	参考件号 RefPartNo	名 称	Description	数 量 Number	备注 Remark
46	30503017	VE28S	喂针轴轴套	Bushing	2	
47	305S14002	SK329	内六角平端紧定螺钉SM 1/8 "x44x3	Screw	1	每台数量需乘相应机型针数
48	30504028	L9xxx	弯针架 (04064)	LooperHolder	1	
48	30504040	L9xxx	弯针架 (04080)	LooperHolder	1	
48	30504008	L9xxx	弯针架 (04085)	LooperHolder	1	
48	30504024	L9xxx	弯针架 (04095)	LooperHolder	1	
48	30504023	L9xxx	弯针架 (06048)	LooperHolder	1	
48	30504016	L9xxx	弯针架 (06064)	LooperHolder	1	
48	30504022	L9xxx	弯针架 (06080)	LooperHolder	1	
48	30504044	L9xxx	弯针架 (06095)	LooperHolder	1	
48	130504001	L9xxx	弯针架 (08032)	LooperHolder	1	
48	30504042	L9xxx	弯针架 (08048)	LooperHolder	1	
48	30504017	L9xxx	弯针架 (08064)	LooperHolder	1	
48	30504038	L9xxx	弯针架 (08085)	LooperHolder	1	
48	30504039	L9xxx	弯针架 (12032)	LooperHolder	1	
48	130504002	L9xxx	弯针架 (12032)	LooperHolder	1	
48	30504029	L9xxx	弯针架 (12048)	LooperHolder	1	
48	30504009	L9xxx	弯针架 (12064)	LooperHolder	1	
48	130504003	L9xxx	弯针架 (13064-32)	LooperHolder	1	
48	30504018	L9xxx	弯针架 (13064)	LooperHolder	1	
48	30504019	L9xxx	弯针架 (17032)	LooperHolder	1	
48	130504004	L9xxx	弯针架 (17032)	LooperHolder	1	
48	130504008	L9xxx	弯针架 (19032)	LooperHolder	1	
48	130504022	L9xxx	弯针架 (21048)	LooperHolder	1	
48	30504037	L9xxx	弯针架 (23032)	LooperHolder	1	
48	30504021	L9xxx	弯针架 (25032)	LooperHolder	1	
48	130504006	L9xxx	弯针架 (25032)	LooperHolder	1	
49	30502034	R9xx4	喂针轴 (04064)	Shaft	1	
49	30502050	R9xx4	喂针轴 (04080)	Shaft	1	
49	30502008	R9xx4	喂针轴 (04085)	Shaft	1	
49	30502032	R9xx4	喂针轴 (04095)	Shaft	1	
49	30502031	R9xx4	喂针轴 (06048)	Shaft	1	
49	30502024	R9xx4	喂针轴 (06064)	Shaft	1	
49	30502030	R9xx4	喂针轴 (06080)	Shaft	1	
49	30502054	R9xx4	喂针轴 (06095)	Shaft	1	
49	30502036	R9xx4	喂针轴 (08032)	Shaft	1	
49	30502052	R9xx4	喂针轴 (08048)	Shaft	1	
49	30502025	R9xx4	喂针轴 (08064)	Shaft	1	
49	30502037	R9xx4	喂针轴 (08085)	Shaft	1	
49	30502049	R9xx4	喂针轴 (12032)	Shaft	1	
49	30502035	R9xx4	喂针轴 (12048)	Shaft	1	
49	30502009	R9xx4	喂针轴 (12064)	Shaft	1	
49	30502026	R9xx4	喂针轴 (13064-32)	Shaft	1	
49	30502027	R9xx4	喂针轴 (17032)	Shaft	1	
49	130502037	R9xx4	喂针轴 (21048)	Shaft	1	
49	30502038	R9xx4	喂针轴 (23032)	Shaft	1	
49	30502029	R9xx4	喂针轴 (25032)	Shaft	1	
50	130504009	L9xxx	护针座 (09032)	LooperHolder	1	适用8/12/13/17/19针
51	W 02865	-----	弹簧垫圈3	Washer	2	
52	S05328	-----	内六角圆柱头螺钉M 3x10	Screw	2	
53	130517001	VE50	护针 (032)	Needle Guard	1	每台数量需乘相应机型针数
54	130517002	VE51	弯针 (032)	Looper	1	每台数量需乘相应机型针数
55	20523005	VD30D-2	油线	Oil Wick	1	

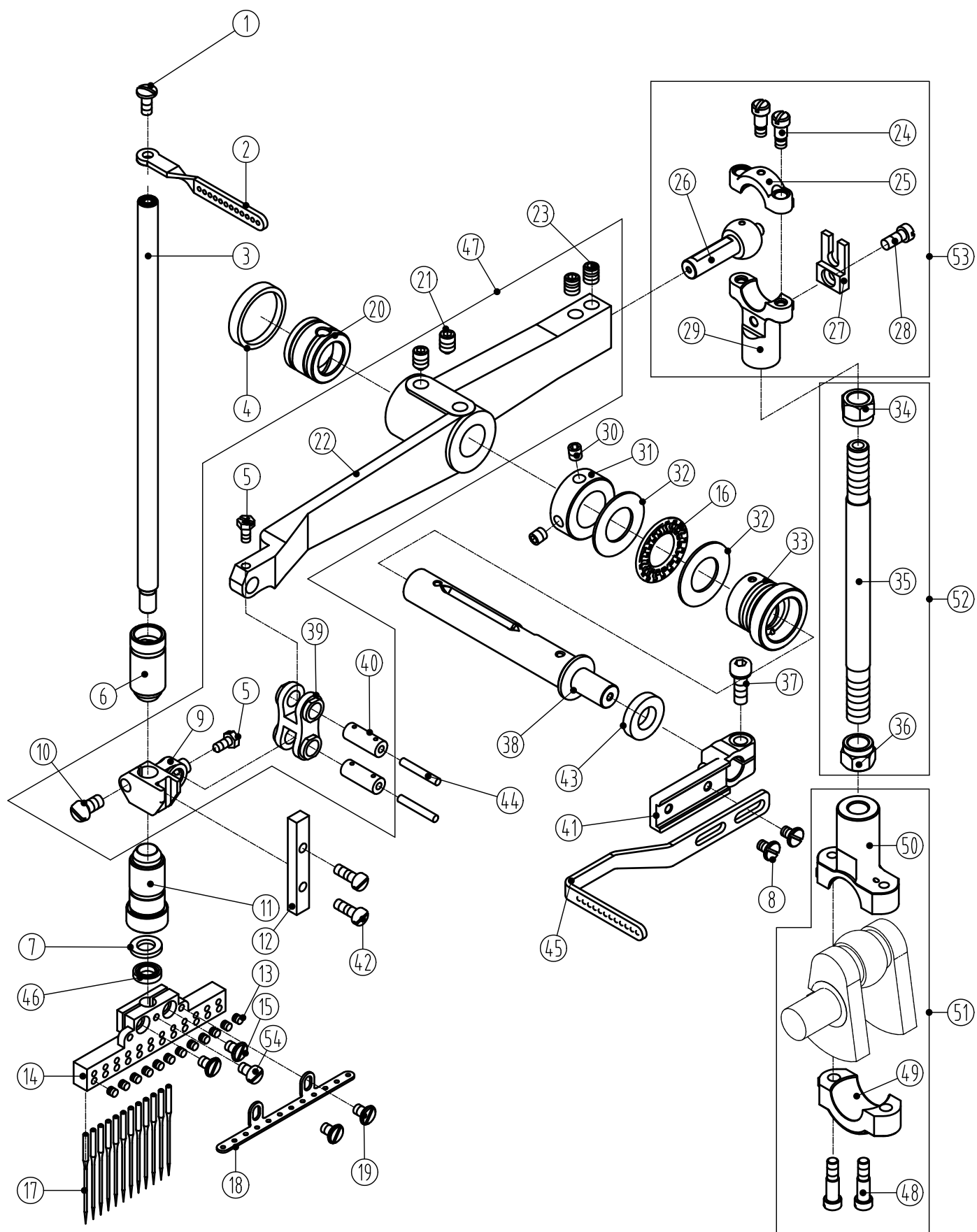
六、喂针部件/Needle feeding assemblies



六、喂针部件/Needle Feeding assemblies

序号 No	件 号 Part No.	参考件号 Ref.Part.No	名 称	Description	数 量 Number	备注 Remark
1	30522011	MQ21	喂针摆动横轴橡皮塞 $\phi 20$	Oil Seal	2	
2	30503019	VE44	喂针摆动横轴后轴套	Bushing	1	
3	20128008	MT29D	垫圈 $\phi 12 \times \phi 26 \times 1.5$	Washing	1	
4	30508001	MH73	挡圈 $\phi 12 \times \phi 20 \times 10$	Ring	1	
5	S10014	SM502	内六角凹端紧定螺钉M5 $\times$ 4	Screw	2	GB/T80
6	30502010	VE41	喂针摆动横轴	Shaft	1	
7	30503020	VE38	喂针摆动横轴前轴套	Bushing	1	
8	30505007	VE36D	喂针摆动横轴连杆	Link	1	
9	S05002	SM612	内六角圆柱头螺钉M6 $\times$ 0.75 $\times$ 15.2	Screw	1	GB/T70.1
10	305S14003	SM103	内六角锥端紧定螺钉M3.5 $\times$ 5	Screw	2	
11	30505008	VE34D	前拔线喂针轴固定座连杆	Link	1	
12	201S14002	SK270	内六角凹端紧定螺钉SM11/64" $\times$ 40 $\times$ 5	Screw	2	
13	30509005	VE33D	前拔线喂针轴固定座	Slider	1	
14	30526008	VF10	销子	Pin	2	通5-3
15	20123021	VC11	油线	Oil Wick	1	

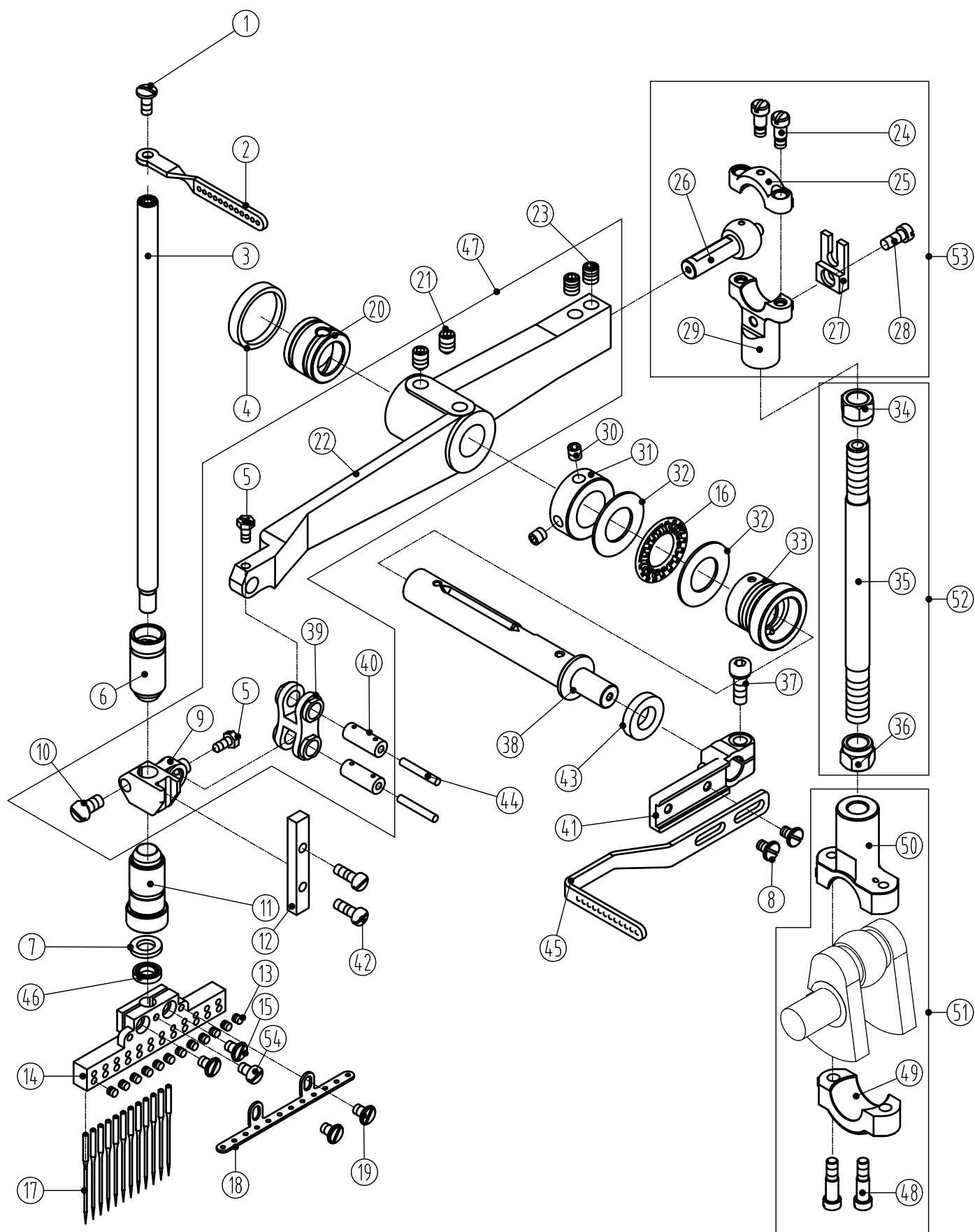
七、针杆部件/Needle bar assemblies



七、针杆部件/Needle Bar assemblies

序号 No	件 号 Part No.	参考件号 Ref Part No	名 称	Description	数 量 Number	备注 Remark
1	S01038	SM 132	开槽球面圆柱头螺钉M 4×10	Screw	1	
2	30513003	VF19	针杆上挑线(4针用)	Thread guide	1	4针机专用
2	30513006	VF19	针杆上挑线 (6-13针用)	Thread guide	1	6、8、12、13针机专用
2	30513026	VF19	针杆上挑线 (17-25针用)	Thread guide	1	17、23、25针机专用
3	30502011	VF12D	针杆	Needle bar	1	
4	3052201200	VF07	杠杆轴后轴套橡皮塞φ27	Oil Seal	1	
5	305S12004	SM 184	复合槽六角头锥端螺栓M 3.5×8.5	Screw	2	组件3050500900
6	30503021	VF13	针杆上铜套	Bushing	1	
7	30523013	-----	油棉	Oil Wick	1	
8	113S11004	SM 431	开槽圆柱头螺钉M 4×8	Screw	2	GB/T65
9	30509006	VF09	针杆止摆接头	Needle slider	1	组件3050500900
10	S01011	SM 532	开槽圆柱头螺钉M 5×10	Screw	1	
11	30503022	VF14	针杆下铜套	Bushing	1	
12	30509007	VF11D	针杆止摆导轨	Rivet	1	
13	305S14002	SK216	内六角平端紧定螺钉SM 1/8 "×44×3	Screw	4	
14	30534009	M 9**4	针夹头 (04064)	Needle Holder Assy	1	
14	30534018	M 9**4	针夹头 (04080)	Needle Holder Assy	1	
14	30534001	M 9**4	针夹头 (04085)	Needle Holder Assy	1	
14	30534013	M 9**4	针夹头 (04095)	Needle Holder Assy	1	
14	30534012	M 9**4	针夹头 (06048)	Needle Holder Assy	1	
14	30534003	M 9**4	针夹头 (06064)	Needle Holder Assy	1	
14	30534011	M 9**4	针夹头 (06080)	Needle Holder Assy	1	
14	30534022	M 9**4	针夹头 (06095)	Needle Holder Assy	1	
14	30534014	M 9**4	针夹头 (08032)	Needle Holder Assy	1	
14	30534020	M 9**4	针夹头 (08048)	Needle Holder Assy	1	
14	30534004	M 9**4	针夹头 (08064)	Needle Holder Assy	1	
14	30534016	M 9**4	针夹头 (08085)	Needle Holder Assy	1	
14	30534017	M 9**4	针夹头 (12032)	Needle Holder Assy	1	
14	30534010	M 9**4	针夹头 (12048)	Needle Holder Assy	1	
14	30534002	M 9**4	针夹头 (12064)	Needle Holder Assy	1	
14	30534005	M 9**4	针夹头 (13064-32)	Needle Holder Assy	1	
14	30534006	M 9**4	针夹头 (17032)	Needle Holder Assy	1	
14	13053400600	M 9**4	针夹头 (21048)	Needle Holder Assy	1	
14	30534015	M 9**4	针夹头 (23032)	Needle Holder Assy	1	
14	30534008	M 9**4	针夹头 (25032)	Needle Holder Assy	1	
15	305S11004	-----	开槽圆柱头螺钉SM 11/64 "×40×8	Screw	2	
16	30524002	-----	平面滚针轴承φ15×φ28×14	Bearing	1	
17	30517004	Uo113	机针 UO×113GS14/90)	Needle	1	64及以下针位用
17	30517005	Uo113	机针 UO×113GS16/100)	Needle	1	64以上针位用
18	30513004	M 9**4-1	针夹头过线板(4针用)	Thread guide	1	4针机专用
18	30513007	M 9**4-1	针夹头过线板(6-12针用)	Thread guide	1	6、8、12针专用
18	30513021	M 9**4-1	针夹头过线板(13-25针用)	Thread guide	1	13、17、23、25针机专用
18	130513011	M 9**4-1	针夹头过线板(2针用)	Thread guide	1	2针专用
19	305S11005	SK239	开槽圆柱头螺钉SM 9/64 "×40×4	Screw	2	
20	30503023	VF06	针杆驱动杠杆轴后轴套	Bushing	1	
21	305S14006	SM 601	内六角锥端紧定螺钉M 6×0.75×9	Screw	2	
22	30505009	VF01	针杆驱动杠杆	Lever	1	组件3050500900
23	305S14007	SM 600	内六角平端紧定螺钉M 6×0.75×8	Screw	2	
24	S05010	SK491	驱动杠杆球连杆螺钉	Screw	2	组件3050402400
25	30505010	-----	驱动杠杆上球连杆	Crank	1	
26	30526011	VF16	驱动杠杆球连杆球杆	Crank	1	
27	30512028	VF22	驱动杠杆球曲柄止摆块	Cover	1	
28	305S13019	SK277	驱动杠杆球曲柄止摆块螺钉	Screw	1	
29	30505011	-----	驱动杠杆下球连杆	Crank	1	
30	207S11042	SM 502	内六角平端紧定螺钉M 5×5	Screw	2	GB/T77

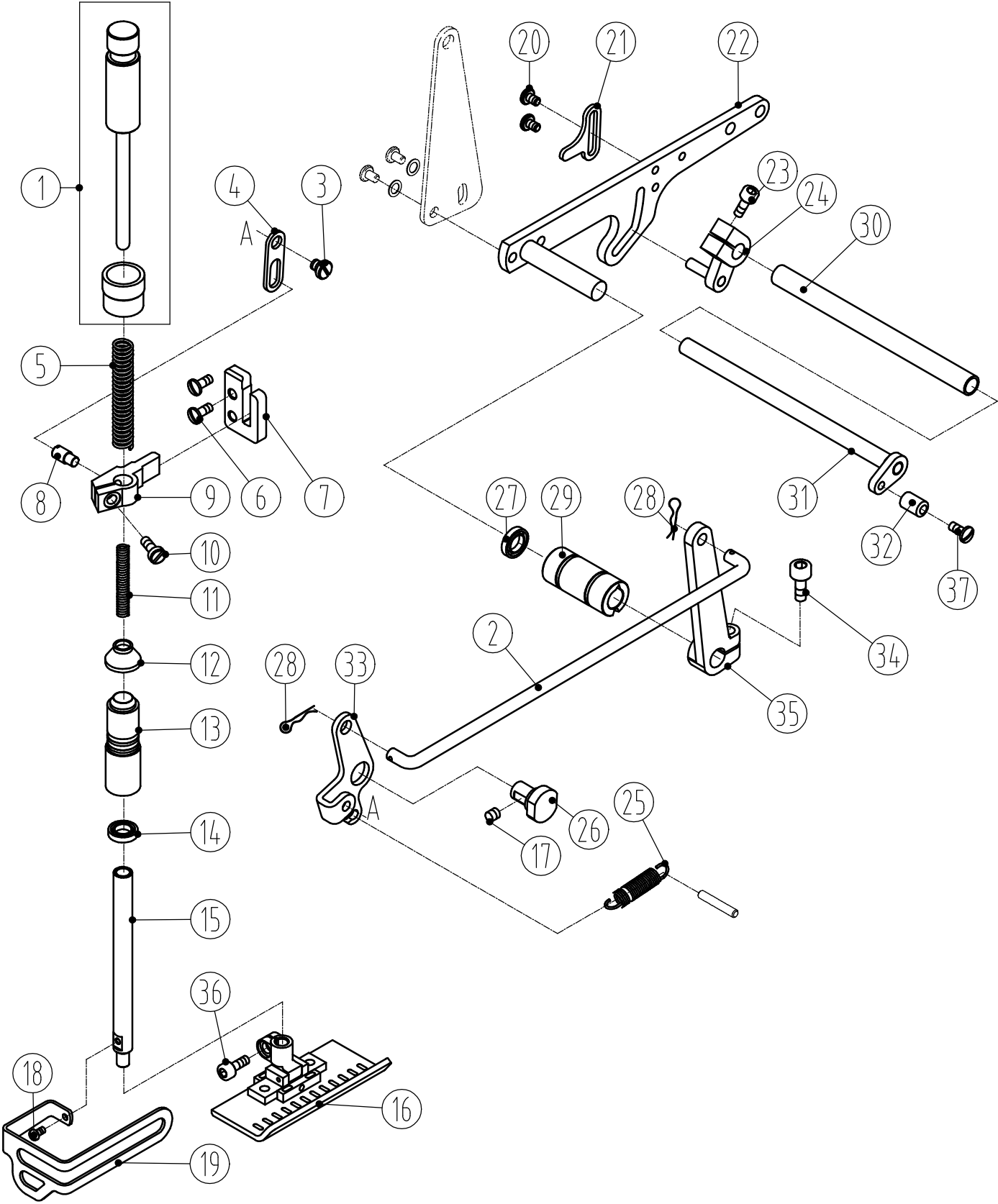
七、针杆部件/Needle bar assemblies



七、针杆部件/Needle Bar assemblies

序号 No	件 号 Part No.	参考件号 RefPartNo	名 称	Description	数 量 Num ber	备注 Rem ark
31	30508006	VF05	挡圈 $\phi 14 \times \phi 27 \times 10$	Ring	1	
32	30528003	VF04	垫圈 $\phi 15 \times \phi 27.8 \times 1$	Washer	2	
33	30503024	VF03	针杆驱动杠杆轴前轴套	Bushing	1	
34	305S16002	NK54	螺母SM 3/8 "x24x10左旋	Nut	1	组件3050203000
35	30502012	-----	主轴大连杆调节杆	Crank	1	
36	305S16003	NK53	螺母SM 3/8 "x24x10	Nut	1	
37	S05004	SM 511	内六角圆柱头螺钉M 5x14	Screw	1	GB/T701
38	30502013	VF02	针杆驱动杠杆轴	Shaft	1	
39	30505012	VF08	针杆链条节	Crank	1	组件3050500900
40	30526008	VF10	针杆链条节销	Pin	2	
41	30509010	VF17	上挑线过线板座	Thread Guide Rivet Seat	1	
42	207S11008	SM 438	开槽圆柱头螺钉M 4x12	Screw	2	GB/T65
43	21322019	-----	FB型骨架油封 $\phi 10 \times \phi 19 \times 4$	Oil iik	1	
44	20123021	VC11	油线	Oil Seal	1	
45	30513005	VF18	上挑线过线板(4针)	Thread guide	1	4针机专用
45	30513008	VF18P	上挑线过线板 (6-13针)	Thread guide	1	6、8、12、13针机专用
45	30513047	VF18P	上挑线过线板 (17-25针)	Thread guide	1	17、23、25针机专用
46	3052201500	-----	骨架油封 $\phi 7.8 \times \phi 14 \times 3$	Oil Seal	1	
47	3050500900	VF01	针杆驱动杠杆组件	Lever	1	
48	114S13001	-----	内六角圆柱头螺钉M 5x20	Screw	2	组件30605004
49	30505014	-----	后主轴下球连杆	Crank	1	
50	30505013	-----	后主轴上球连杆	Crank	1	
51	30605004	-----	后主轴球连杆组件	Crank Assem bly	1	
52	3050203000	VF23D	主轴大连杆调节杆组件	Connection assy.	1	组件3050203000
53	3050402400	-----	驱动杠杆球连杆组件	Crank Assem bly	1	组件3050402400
54	305S30004	SK239	开槽圆柱头螺钉SM 9/64 "x40x4	Screw	1	

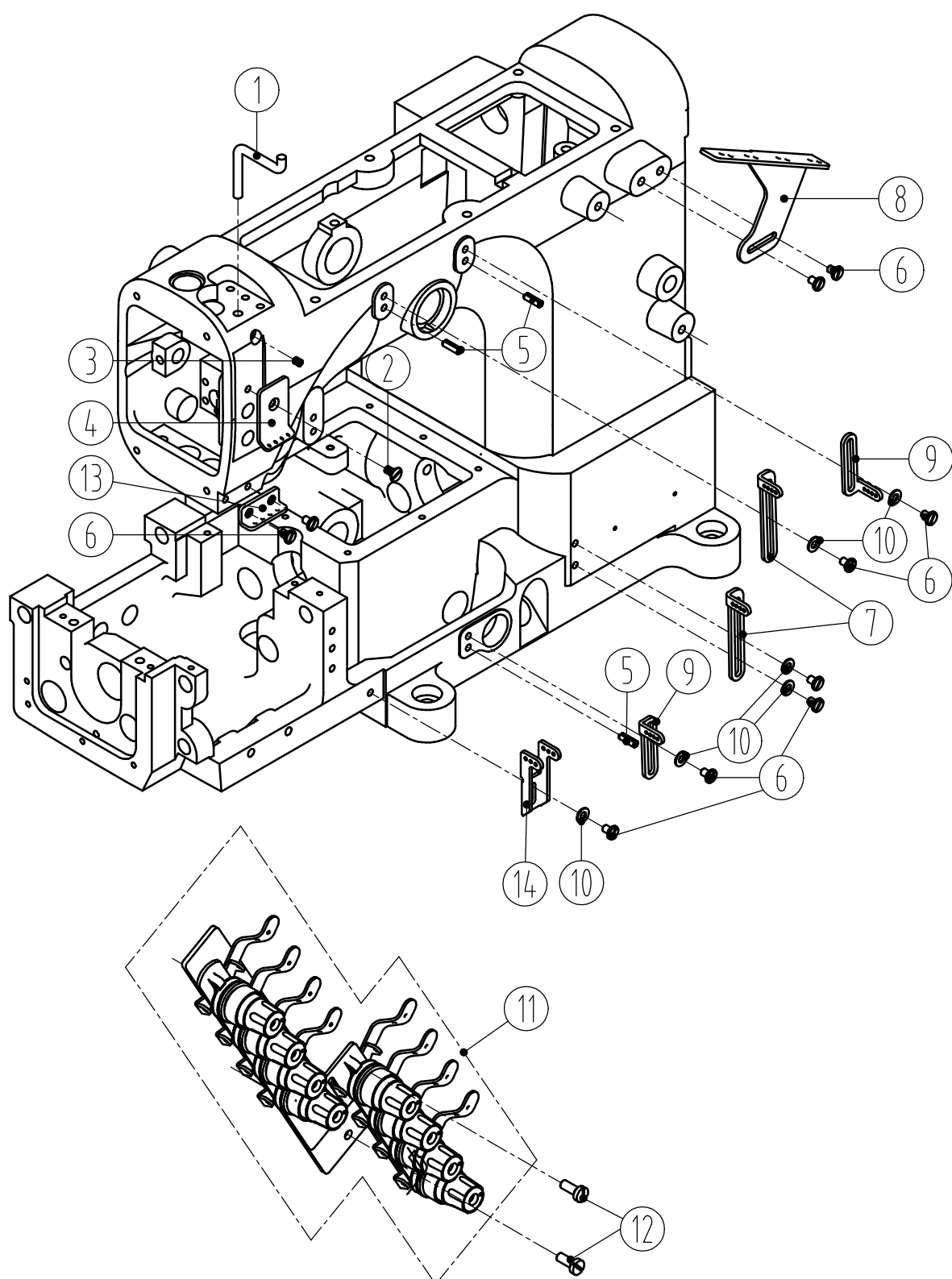
八、压脚部件/Presser foot assemblies



八、压脚部件/PresserFoot assemblies

序号 No	件 号 Part No.	参考件号 RefPartNo	名 称	Description	数 量 Number	备注 Remark
1	3013002500	VJL6	调压螺杆组件	Adjusting Bar Assy	1	
2	30512035	VJ09	抬压脚拉杆	Link	1	
3	305S20009	SK518	抬压脚吊板轴位螺钉M5	Screw	1	
4	30512029	VJL3	抬压脚吊板	Bracket	1	
5	30527007	MJ03	调压弹簧	Spring	1	
6	S01038	SM438	开槽球面圆柱头螺钉M4×10	Screw	2	
7	30509011	VJ20	压脚轴导架导轨	Slider	1	
8	305S11007	SK502	抬压脚吊板销钉M5	Screw	1	
9	30509012	VJ07	压脚轴导架	Slider	1	
10	113S11001	SK265	复合槽盘头螺钉SM11/64×40	Screw	1	
11	30527008	MJL2	压脚轴轴内弹簧	Spring	1	
12	30522014	MJL3	压脚轴轴套上防油套	Oil Seal	1	
13	30503025	VJ21	压脚轴轴套	Bushing	1	
14	3052201500	MJL7	骨架油封 $\phi 19 \times \phi 14 \times 3$	Oil Seal	1	
15	30502015	VJL8	压脚轴	Shaft	1	
16	30516009	P9****	压脚组件 (04064)	presser foot assy	1	
16	30516021	P9****	压脚组件 (04080)	presser foot assy	1	
16	30516001	P9****	压脚组件 (04085)	presser foot assy	1	
16	30516013	P9****	压脚组件 (04095)	presser foot assy	1	
16	30516012	P9****	压脚组件 (06048)	presser foot assy	1	
16	30516003	P9****	压脚组件 (06064)	presser foot assy	1	
16	30516011	P9****	压脚组件 (06080)	presser foot assy	1	
16	30516025	P9****	压脚组件 (06095)	presser foot assy	1	
16	30516016	P9****	压脚组件 (08032)	presser foot assy	1	
16	30516023	P9****	压脚组件 (08048)	presser foot assy	1	
16	30516004	P9****	压脚组件 (08064)	presser foot assy	1	
16	30516018	P9****	压脚组件 (08085)	presser foot assy	1	
16	30516020	P9****	压脚组件 (12032)	presser foot assy	1	
16	30516010	P9****	压脚组件 (12048)	presser foot assy	1	
16	30516002	P9****	压脚组件 (12064)	presser foot assy	1	
16	30516005	P9****	压脚组件 (13064-32)	presser foot assy	1	
16	30516006	P9****	压脚组件 (17032)	presser foot assy	1	
16	13051600700	P9****	压脚组件 (21048)	presser foot assy	1	
16	30516017	P9****	压脚组件 (23032)	presser foot assy	1	
16	30516008	P9****	压脚组件 (25032)	presser foot assy	1	
17	207S11042	SM502	内六角平端紧定螺钉M5×5	Screw	1	GB/T77
18	S01027	SM332	开槽圆柱头螺钉M3×6	Screw	1	GB/T65
19	30512030	VJ23	护指罩 (4针)	Eye Guide	1	4针用
19	30512037	VJ23	护指罩 (6-25针)	Eye Guide	1	6-25针用
20	113S11004	SM431	开槽圆柱头螺钉M4×8	Screw	2	GB/T65
21	30512031	VJ03	抬压挺线限位块	Bracket	1	
22	3051203200	VJ05-2	抬压挺线杠杆组件	Lever Assembly	1	组件3051203200
22	30512032	-----	杠杆	Lever	1	
22	30526013	-----	杠杆轴	Shaft	1	
23	S05004	SM534	内六角圆柱头螺钉M5×14	Screw	1	GB/T70.1
24	30504011	VJ04	抬压挺线后曲柄组件	Tighten	1	组件30504011
24	30504027	-----	紧固座		1	
24	30526012	-----	销子	Pin	1	
25	30527010	VJL4	抬压复位弹簧	Spring	1	
26	30526014	VJL2D	抬压脚前支点架销	Pin	1	
27	3052201700	KL20	骨架油封 $\phi 9.1 \times \phi 15 \times 3$	Oil Seal	1	
28	30527009	VJL0	抬压脚拉杆开口销	Pin	2	
29	30503026	VJ06D	抬压挺线杠杆轴轴套	Bushing	1	
30	30502016	VJ02	抬压挺线曲柄轴套	Thread Guide	1	
31	3050201700	VJ03	抬压挺线曲柄轴组件	Shaft	1	组件3050201700
31	30502018	-----	松线轴	Shaft	1	
31	30512034	-----	连接板	Cariko	1	
32	30510006	VJ01-3	抬压挺线曲柄偏心调节套	Eccent Bushing	1	
33	30512036	VJL1D	抬压脚前支点架	Crank	1	
34	S05002	SM612	内六角圆柱头螺钉M6×0.75×15.2	Screw	1	GB/T70.1
35	30504012	VJ08	抬压脚后曲柄	Crank	1	
36	305S13013	-----	内六角圆柱头螺钉M5×8	Screw	1	
37	207S11008	-----	开槽圆柱头螺钉M4×12	Screw	1	

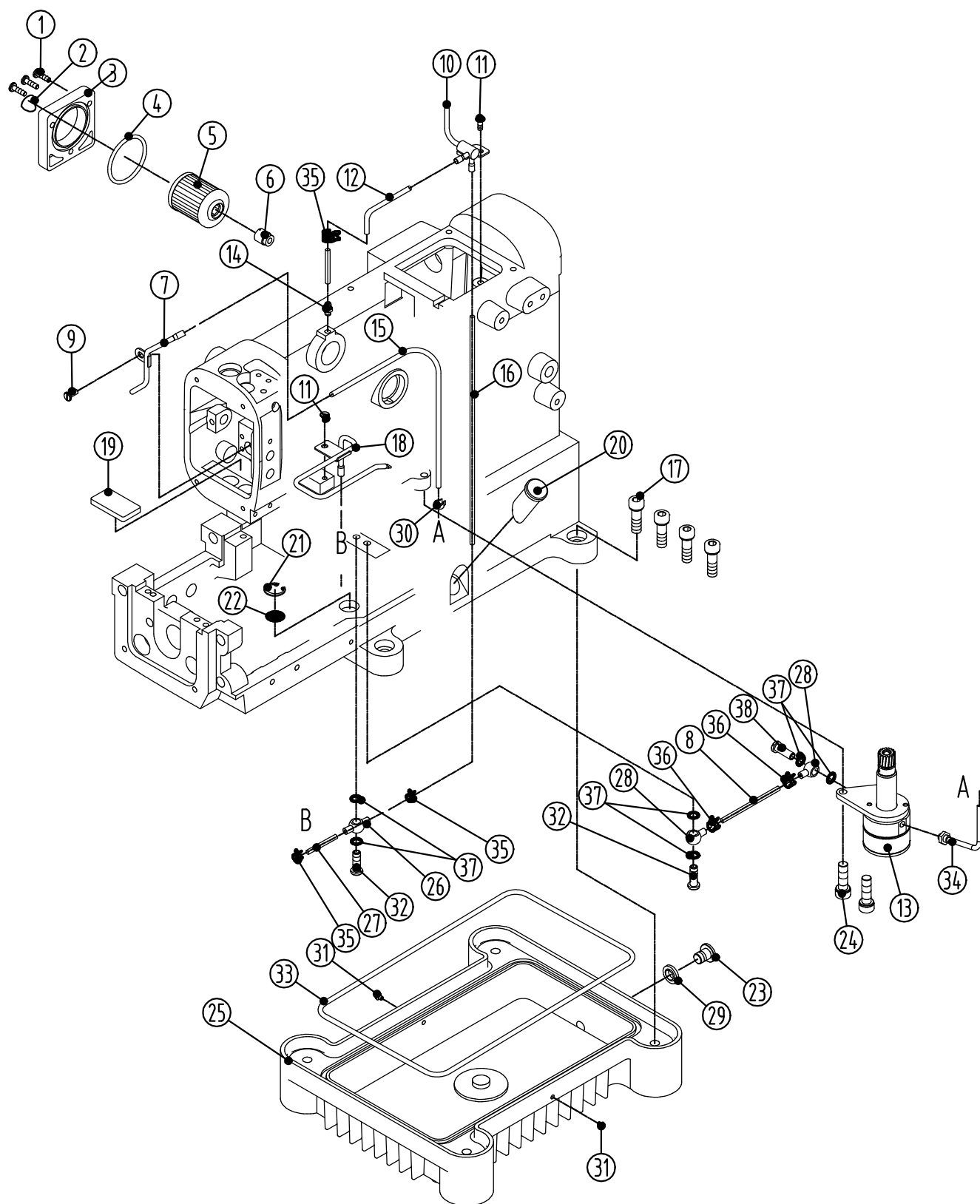
九、夹线器部件/Tension spring assemblies



九、夹线器部件/Tension Spring assemblies

序号 No	件 号 Part No.	参考件号 RefPartNo	名 称	Description	数 量 Num ber	备注 Rem ark
1	30512038	VK13	绷线紧勾	Bracket	1	4针机专用
1	30512039	VK13	绷线紧勾	Bracket	1	6-25针机用
2	S02003	SM 450	开槽沉头螺钉M 4×5	Screw	1	GB/T68
3	S09012	SM 404	内六角平端紧定螺钉M 4×5	Screw	1	GB/T77
4	30513009	VK15	针杆上过线板 (4针)	Thread Guide	1	
4	30513015	VK15	针杆上过线板 (6-13针)	Thread Guide	1	
4	30513025	VK15	针杆上过线板 (17-25针)	Thread Guide	1	
5	P03025	PM 413	弹性圆柱销 $\phi 4 \times 12$	Pin	3	GB/T879.1
6	113S11004	SM 450	开槽圆柱头螺钉M 4×8	Screw	6	GB/T65
7	30513010	VK18	长过线板 (4针)	Thread Guide	2	
7	30513016	VK18	长过线板 (6-13针)	Thread Guide	2	
7	30513022	VK18	长过线板 (17-25针)	Thread Guide	2	
8	30513011	SM 431	夹线器过线(4针)	Thread Guide	1	
9	30513012	VK11	短过线板 (4针)	Thread Guide	2	
9	30513017	VK11	短过线板 (6-13针)	Thread Guide	2	
9	30513023	VK11	短过线板 (17-25针)	Thread Guide	2	
10	20628012	M W 400	垫圈 $\phi 4.3 \times \phi 9 \times 0.8$	Washer	6	
11	30531047	VK06	夹线器组件(4针)	Tension Spring Assy	1	
11	3053104900	VK07	夹线器组件 (6针、8针)	Tension Spring Assy	1	
11	30531048	VK06	夹线器组件(12针)	Tension Spring Assy	1	
12	403S11023	SM 534	开槽球面圆柱头螺钉M 5×14	Screw	2	
13	30513013	VK17	针杆下过线板 (4针)	Thread Guide	1	
13	30513018	VK17	针杆下过线板 (6-13针)	Thread Guide	1	
13	30513027	VK17	针杆下过线板 (17-25针)	Thread Guide	1	
14	30513014	VK07	弯针打线过线板 (4针)	Thread Guide	1	
14	30513019	VK07	弯针打线过线板 (6-13针)	Thread Guide	1	
14	30513024	VK07	弯针打线过线板 (17-25针)	Thread Guide	1	

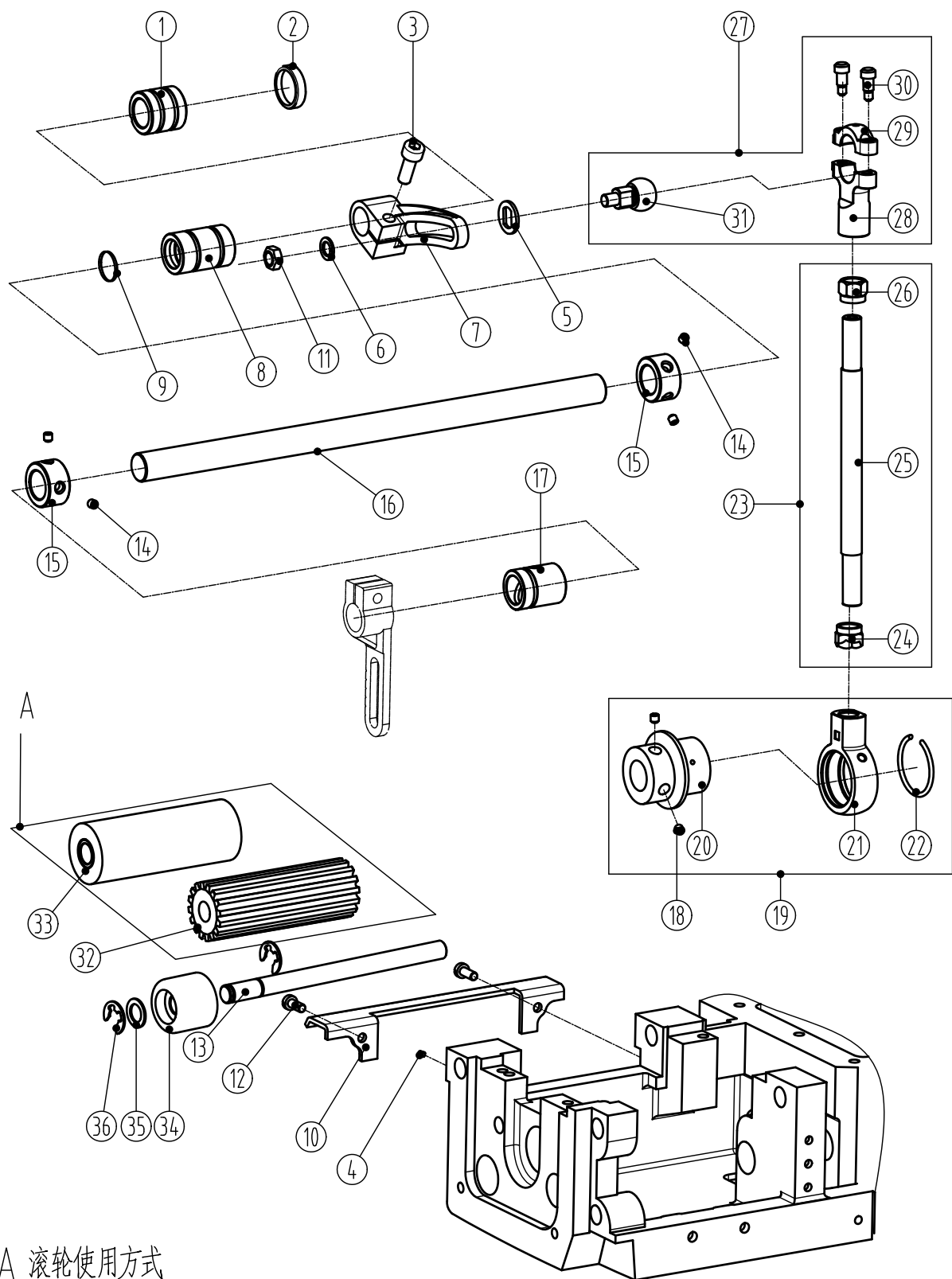
十、油泵部件/Lubrication assemblies



十、油泵部件/Lubrication assemblies

序号 No	件 号 Part No.	参考件号 RefPartNo	名 称	Description	数 量 Num ber	备注 Rem ark
1	S01057	SM 447	开槽球面圆柱头螺钉M 4×15	Screw	3	
2	20337005	KT18	商标	Brand	1	
3	20301005	KT16	滤油器盖(喷漆)	Cover	1	930001444
4	001010	KT17	O型圈 $\phi 39.5 \times \phi 45.7 \times \phi 3.1$	Sticker	1	GB/T1235
5	20736004	KT14	滤油器组件	Filter Element	1	
6	30503027	ML50	滤油器进油嘴	pipe	1	
7	30521012	VL14	机头下巴吸油嘴组件	Tube	1	
8	12921003	VL19	油管 $\phi 5 \times \phi 8$ L=100	Tube	1	
9	207S11011	SM 431	开槽圆柱头螺钉M 4×5	Screw	1	GB/T65
10	30521013	VL11	油窗喷油管组件	Tube	1	
11	113S11004	SM 435	开槽圆柱头螺钉M 4×8	Screw	2	GB/T65
12	12921005	VL16	油管 $\phi 4 \times \phi 6$ L=180	Tube	1	
13	3052000100	ML01	油泵组件	Pump	1	
14	30536001	VL12	杠杆轴后轴套供油嘴	Joint	1	
15	12921005	VL15	油管 $\phi 4 \times \phi 6$ L=450	Tube	1	
16	12921005	VL17	油管 $\phi 4 \times \phi 6$ L=450	Tube	1	
17	305S13003	SM 812	内六角圆柱头螺钉M 8×25	Screw	4	GB/T701
18	3052101300	VL07	机座供油管组件	Tube Assembly	1	
19	30523010	VL13	机头下巴回油毡	Felt	1	
20	30511004	VL06D	油量指示窗	Oil Window	1	
21	H01003	EM 164	孔用弹性挡圈17	Spring	1	GB/T8931
22	30512040	MB15	机座滤油网	filter	1	
23	207S13002	SK310	放油螺钉SM 3/8"×28×12	Screw	1	
24	305S13004	SM 611	内六角圆柱头螺钉M 6×15	Screw	2	GB/T701
25	30501006	VL01	油盘	Oil Reservoir Assy	1	
26	130536001	MW05	供油双通接头	Joint	1	
27	12921005	VL20	油管 $\phi 4 \times \phi 6$ L=115	Tube	1	
28	20736007	KT24	油管接头(塑料)	Joint	2	
29	20528014	KT56	放油螺钉密封圈	Sticker	1	
30	20129002	KT26*11	油管卡簧	Ring	1	
31	207S11011	-----	开槽圆柱头螺钉M 4×5	Screw	2	GB/T65
32	301S30013	SK304	供油接头螺钉SM 1/4"×40 (长)	Screw	3	
33	30522018	VL02	油盘密封圈	Oil Seal	1	
34	30521014	-----	油泵回油管组件	Tube	1	
35	20429001	-----	油管夹 $\phi 6.5$		4	
36	20729005	-----	油管夹 $\phi 8$		2	
37	20122033	-----	油管接头垫圈		6	
38	201S30004	-----	供油接头螺钉SM 1/4"×40 (短)		1	

十一、传送部件/Transmission assemblies



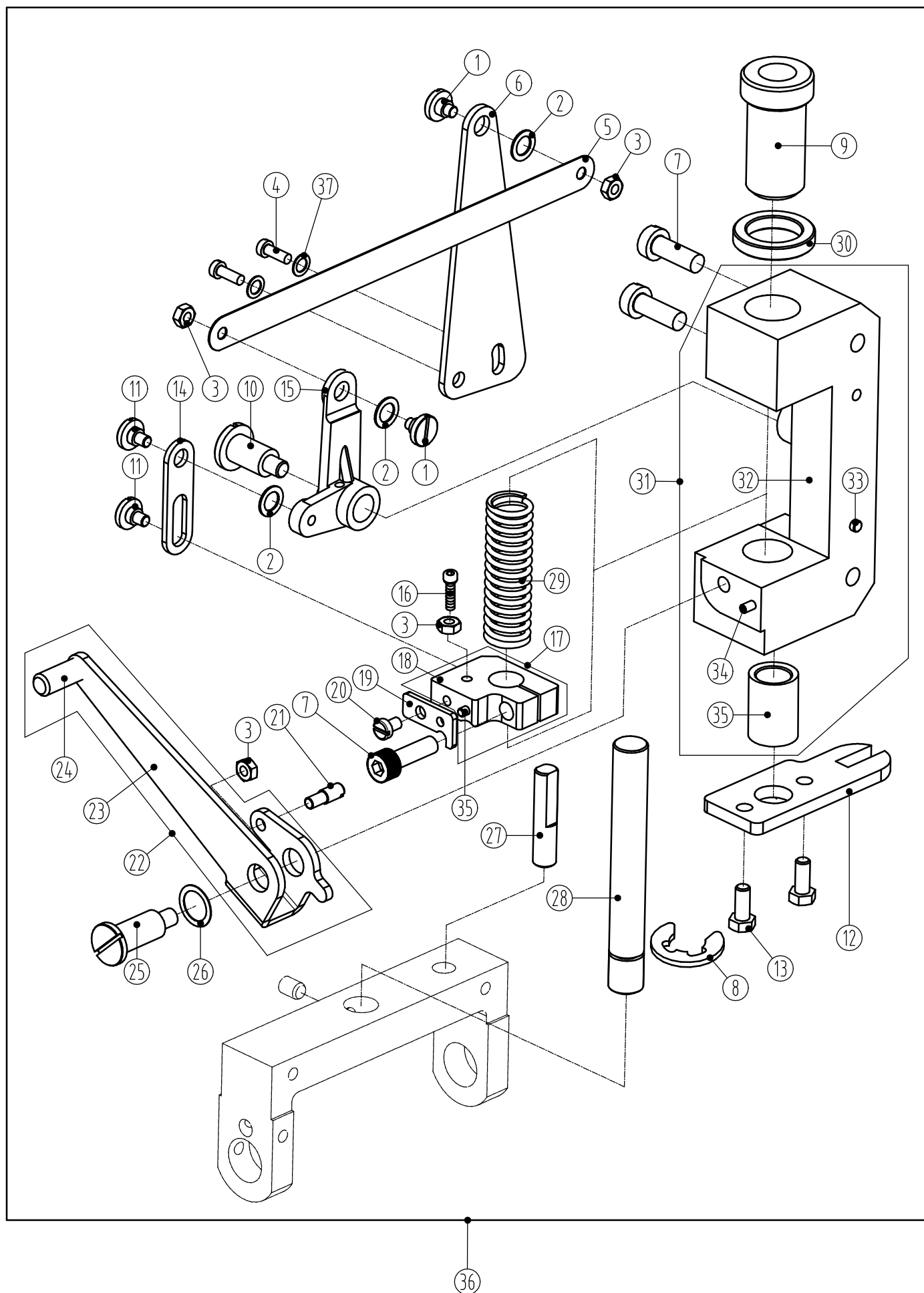
A 滚轮使用方式

代码 \ 齿形	平轮	齿轮(中)	齿轮(厚)
上滚轮代码	30525013	30525008	130525005
下滚轮代码	30525014	30525006	130525006

十一、传送部件/Transmission assemblies

序号 No	件 号 Part No.	参考件号 RefPartNo	名 称	Description	数 量 Num ber	备注 Rem ark
1	30503028	VCL07	后拖轮传送轴右轴套	Bushing	1	
2	30522019	CL14	传送轴后轴套橡皮塞 $\phi 21$	Oil Seal	1	
3	S05002	SM 617	内六角圆柱头螺钉M 6×0.75×15.2	Screw	1	GB/T70.1
4	S09012	-----	内六角平端紧定螺钉M 4×5	Screw	1	GB/T77
5	30512045	VCL05-1	传送轴右曲柄调节垫圈	Washer	1	
6	30328007	-----	垫圈 $\phi 6.5 \times \phi 16 \times 1.5$	Washer	1	
7	30504013	VCL06	后拖轮传动轴右曲柄	Crank	1	
8	30503029	VCL09	后拖轮传送轴中轴套	Bushing	1	
9	30522020	VCL10	O型圈 $\phi 13.6 \times \phi 18.4 \times \phi 2.4$	Oil Seal	1	GB/T 1235
10	30512046	VCL32	下拖轮护料板	Eye Guide	1	
10	130512067	VCL32	后拖轮护料板(21针)	Eye Guide	1	
11	305S16007	NM 611	螺母M 6×0.75	Nut	1	
12	113S11004	SM 431	开槽圆柱头螺钉M 4×8	Screw	2	GB/T65
13	30502019	VCL27	下拖轮轴	Shaft	1	
14	S10014	SM 501	内六角凹端紧定螺钉M 5×4	Screw	4	通用3-6
15	30508007	VCL11	挡圈 $\phi 14 \times \phi 22 \times 12$	Ring	2	
16	30502020	VCL12	后拖轮传送轴	Crank	1	
17	30503030	VCL13	后拖轮传送轴左轴套	Bushing	1	
18	S09002	SM 603	内六角平端紧定螺钉M 6×6	Screw	2	通用3-10
19	3051001100	VCL01	后拖轮传送偏心轮连杆组件	Eccent Assy	1	组件3051001100
20	30510010	VCL01	后拖轮传送偏心凸轮	Eccent	1	
21	30505016	-----	后拖轮传送连杆	Eccent Assy	1	
22	30508009	VCL03	卡簧	Spring	1	
23	3050203100	-----	后拖轮调节杆组件	connection Assy	1	
24	305S16003	NK53	螺母SM 3/8"×24×10	Screw	1	组件3050203100
25	30502021	VF23D	后拖轮调节杆	Connection	1	
26	305S16002	NK54	螺母SM 3/8"×24×10左旋	Nut	1	
27	3050402600	VCL05	传送轴球连杆组件	Crank Assembly	1	组件3050402600
28	30505015	-----	传送轴连杆底部	Crank Assembly	1	
29	30505010	-----	驱动杠杆上球连杆	Crank Assembly	1	
30	S05010	SK491	驱动杠杆球连杆螺钉	Screw	2	
31	305S30005	VCL05	传送轴球连杆球杆	Crank	1	
32	30525006	-----	齿轮下轮 (中)	Press Wheel Assy.	1	组件3050901500
32	130525006	-----	齿轮下轮 (厚)	Press Wheel Assy.	1	组件13050902700
33	30525014	VCL28	下拖轮组件 (平)	Press Wheel Assy.	1	组件3050901700
33-1	30525014-1	-----	橡胶轮内套	Press Wheel Assy.	1	
33-2	30525014-2	-----	橡胶轮	Press Wheel Assy.	1	
34	130544001	-----	辅助小轮	Press Wheel Assy.	1	
35	20128010	-----	垫圈10.2×16×1	Washer	1	
36	H05011	-----	卡簧9	Spring	2	
37	20108006	-----	压脚轴挡圈	Spring	1	

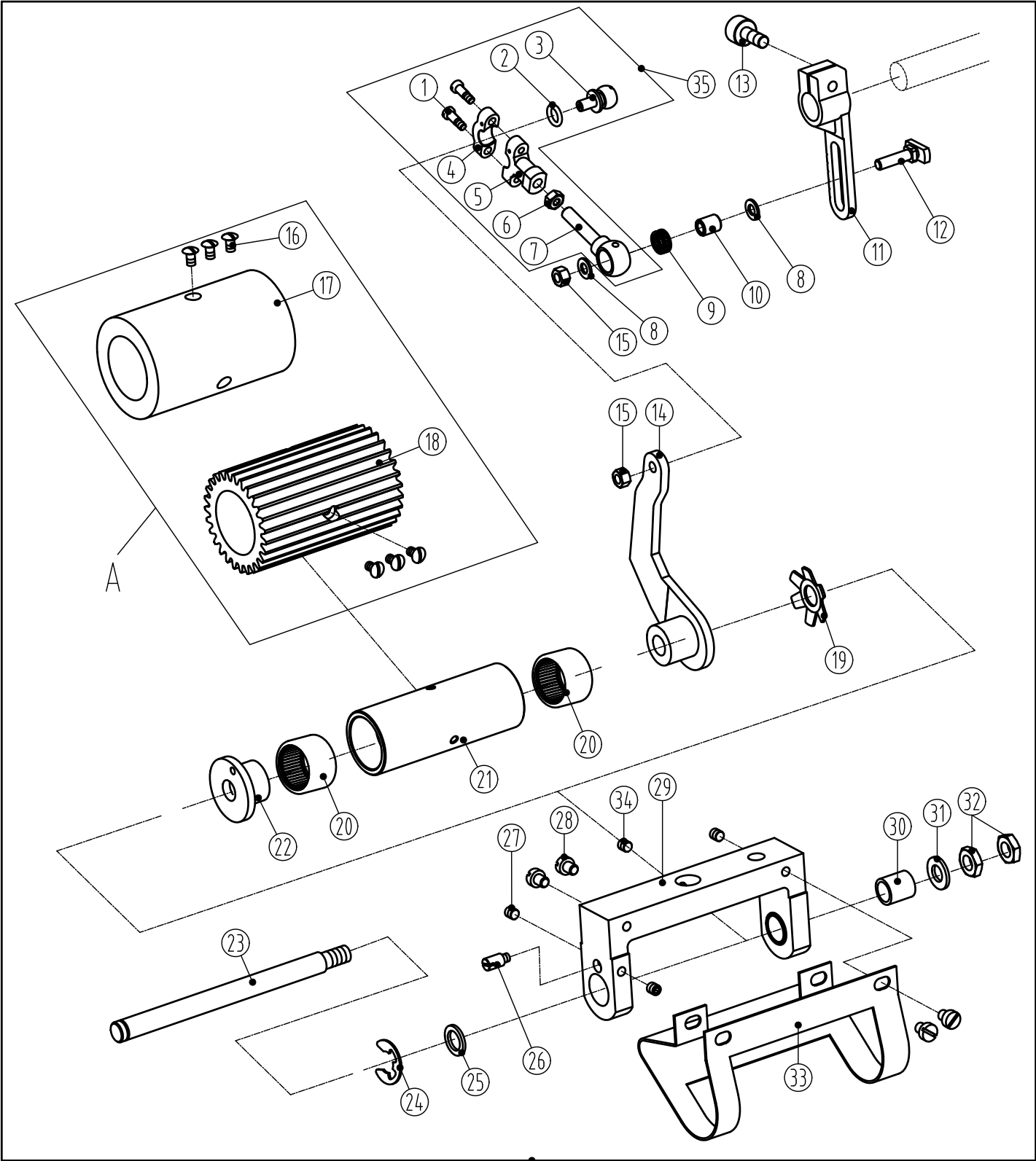
十二、后凸轮架部件/After cam Fight assemblies



十二、后凸轮架部件/AfterCam Fight assemblies

序号 No	件 号 Part No.	参考件号 RefPartNo	名 称	Description	数 量 Num ber	备注 Rem ark
1	305S20010	SM 491	轴位螺钉M 4	Screw	1	
2	30528011	CL31	橡胶垫圈 $\phi 7 \times \phi 11 \times 0.6$	Washer	4	
3	N01001	NM 410	六角螺母M 4	Nut	4	
4	305S13013	SM 531	内六角圆柱头螺钉M 5×8	Screw	2	GB/T65
5	30512047	VCL25	后拖轮提升长连杆	Sheet Iron Link	1	
6	30512048	VCL35	后拖轮提升长连杆连接板	Bracket	1	
7	S05240	SM 614	内六角圆柱头螺钉M 6×20	Screw	2	GB/T70.1
8	H05011	EM 123	开口挡圈9	Spring	1	
9	305S30006	CL25	后拖轮调压螺钉	Adjusting Screw	1	
10	305S20011	SM 681	轴位螺钉M 6	Screw	1	
11	305S20012	SM 492	轴位螺钉M 4	Screw	2	
12	30512053	CL33	后拖轮上下导轨	Regulator Plate	1	
13	207S1104	SM 520	开槽六角头螺栓M 5×9.5	Screw	2	
14	30512049	VCL23	后拖轮提升吊板	Bracket	1	
15	30504014	VCL24	后拖轮提升杠杆曲柄	Crank	1	
16	S05063	SM 440	内六角圆柱头螺钉M 4×25	Screw	1	GB/T70.1
17	30509013	-----	调压弹簧挡块组件	Spring Plate	1	组件30509013
18	30509015	VCL22	调压弹簧挡块	Spring Plate	1	
19	30512050	VCL34	后拖轮上下扳手限位板	Bracket	1	
20	S01055	SM 448	开槽圆柱头螺钉M 4×6	Screw	1	
21	305S11014	SM 472	轴肩螺钉M 4	Screw	1	
22	3051205100	CL33	后拖轮调节上下扳手组件	Regulator Plate	1	组件3051205100
23	30512052	-----	调节扳手	Regulator Plate	1	
24	30526016	-----	调节扳手柄	Regulator Plate	1	
25	305S20013	SM 682	轴位螺钉M6	Screw	1	
26	30528012	CL34	波形弹性垫圈 $\phi 11 \times \phi 15 \times 0.3$	Bracket	1	
27	30526020	VCL19	后拖轮架上下导杆	Pin	1	
28	30502022	VCL30	后拖轮架座轴	Shaft	1	
29	30527017	CL28	后拖轮调压弹簧	Spring	1	
30	305S16006	-----	后拖轮调节螺母	Screw	1	
31	30501042	VCL21	后拖轮架座组件	Finger Guide	1	组件30501042
32	30526018	-----	后拖轮架座	Finger Guide	1	
33	30526019	-----	后拖轮架座销	Finger Guide	1	
34	30526023	PM 302	销子	Pin	1	
35	30503031	CL26	后拖轮架座下铜套	Bushing	1	
36	3050901500	-----	后凸轮架座组件(齿轮式) (中)	AfterCam Assembly	1	
36	13050902700	-----	后凸轮架座组件(齿轮式) (厚)	AfterCam Assembly	1	
36	3050901700	-----	后凸轮架座组件(光滑式)	AfterCam Assembly	1	
36	13050103800	-----	光滑后拖轮组件(21针)	AfterCam Assembly	1	
37	W 03002	-----	弹簧垫圈5	Washer	2	

十三、后凸轮部件/After cam assemblies



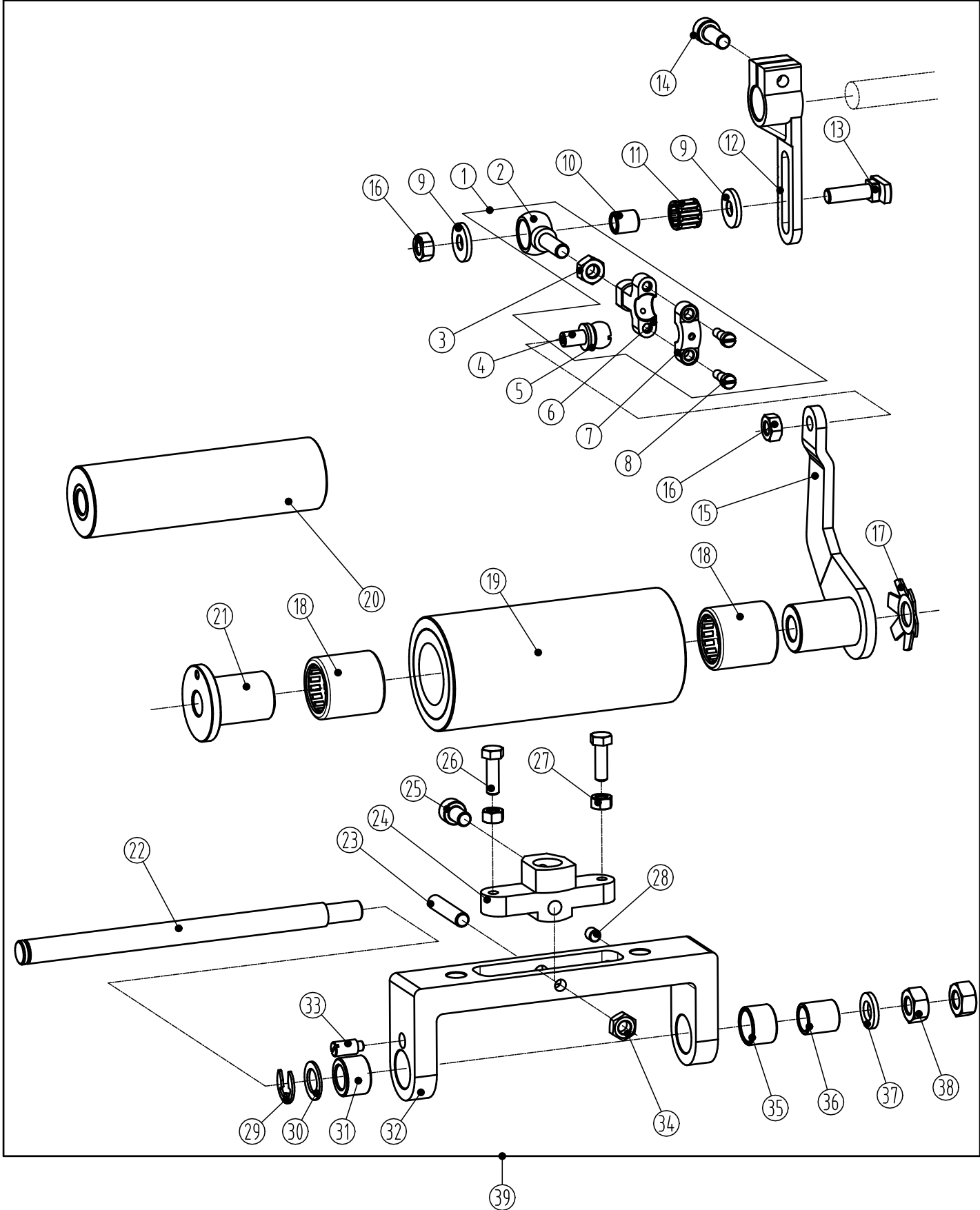
A 滚轮使用方式

代码 \ 齿形	平轮	齿轮(中)	齿轮(厚)
上滚轮代码	30525013	30525008	130525005
下滚轮代码	30525014	30525006	130525006

十三、后凸轮部件/AfterCam assemblies

序号 No	件 号 PartNo.	参考件号 RefPartNo	名 称	Description	数 量 Num ber	备注 Rem ark
1	305S20014	SM 524	后拖轮球连杆螺钉M 5×8.5	Screw	2	组件3050501700
2	30522021	CL48	O型圈 $\phi 7 \times \phi 10 \times \phi 1.9$	Washer	1	
3	305S30007	CL49	球连杆球杆	Iron Cover	1	
4	30505018	-----	后拖轮球连杆头部	Iron Cover	1	
5	30505019	CL50	后拖轮球连杆杆体	Bearing	1	
6	305S16008	-----	六角螺母M 6	Nut	1	
7	30505020	CL50	连接连杆	Bearing	1	
8	W 01090	CL48	垫圈5	Washer	2	
9	B07011	CL49	滚针轴承K8×11×10	Iron Cover	1	
10	30503034	-----	轴承滚套	Bushing	1	
11	30504015	VCL14	后拖轮传送轴左曲柄	Crank	1	
12	305S30009	CL47	传动轴左曲柄调节柱	Screw	1	
13	S05037	SM 612	内六角圆柱头螺钉 M 6×15	Screw	1	
14	130512001	CL37	后拖轮传动板组件	Job	1	
15	N01004	NM 511	六角螺母M 5	Nut	1	
16	137S17001	SM 451	十字槽半沉头螺钉 M 4×9	Screw	3	
17	30525013	VCL16	光滑式上轮	AfterCam Assy	1	上平轮
18	30525008	VCL08	齿轮式上轮	Press Wheel	1	上齿轮(中)
18	130525005	VCL08	齿轮式上轮	Press Wheel	1	上齿轮(厚)
19	30512056	CL38	蝶形卡簧	Spring	1	
20	B07054	-----	单向滚针轴承NSK FC-20	Bearing	2	
21	30503035	VCL15	后上轮内套	Gear Wheel Cover	1	
22	30512057	CL45	单向轴承止动轮	Bracket	1	
23	30502023	VCL17	压轮轴	Shaft	1	
24	H05008	CL41	开口挡圈8	Washer	5	
25	20128010	CL41	垫圈10	Washer	1	
26	305S11012	SM 470	轴肩螺钉M 4	Screw	1	
27	207S11042	SM 502	内六角平端紧定螺钉M 5×5	Screw	2	GB/T77
28	208S15002	-----	开槽圆柱头螺钉M 5×5.5	Screw	4	
29	3050100800	VCL18	后压轮架组件	Press Wheel Fight	1	组件3050100800
29	30501041	-----	后压轮架	Press Wheel Fight	1	
29	30503032	-----	后压轮架厚铜套	Bushing	1	
29	30503033	-----	后压轮架薄铜套	Bushing	1	
30	30503036	VCL31	后轮挤压套	Bushing	1	
31	W 01010	WM 800	垫圈8	Washer	1	
32	N01008	NM 810	六角螺母 M 8	Nut	2	
33	30512054	-----	后拖轮防护罩	Plate	1	
34	S09002	SM 603	内六角平端紧定螺钉M 6×6	Screw	1	GB/T77
35	3050501700	CL51	后拖轮球连杆组件	connection Assy	1	
36	3050901500	-----	后凸轮组件(齿轮式) (中)	AfterCam Assembly	1	
36	13050902700	-----	后凸轮架座组件(齿轮式) (厚)	AfterCam Assembly	1	
36	3050901700	-----	后凸轮组件(光滑式)	AfterCam Assembly	1	
36	13050103800	-----	光滑后拖轮组件(21针)	AfterCam Assembly	1	

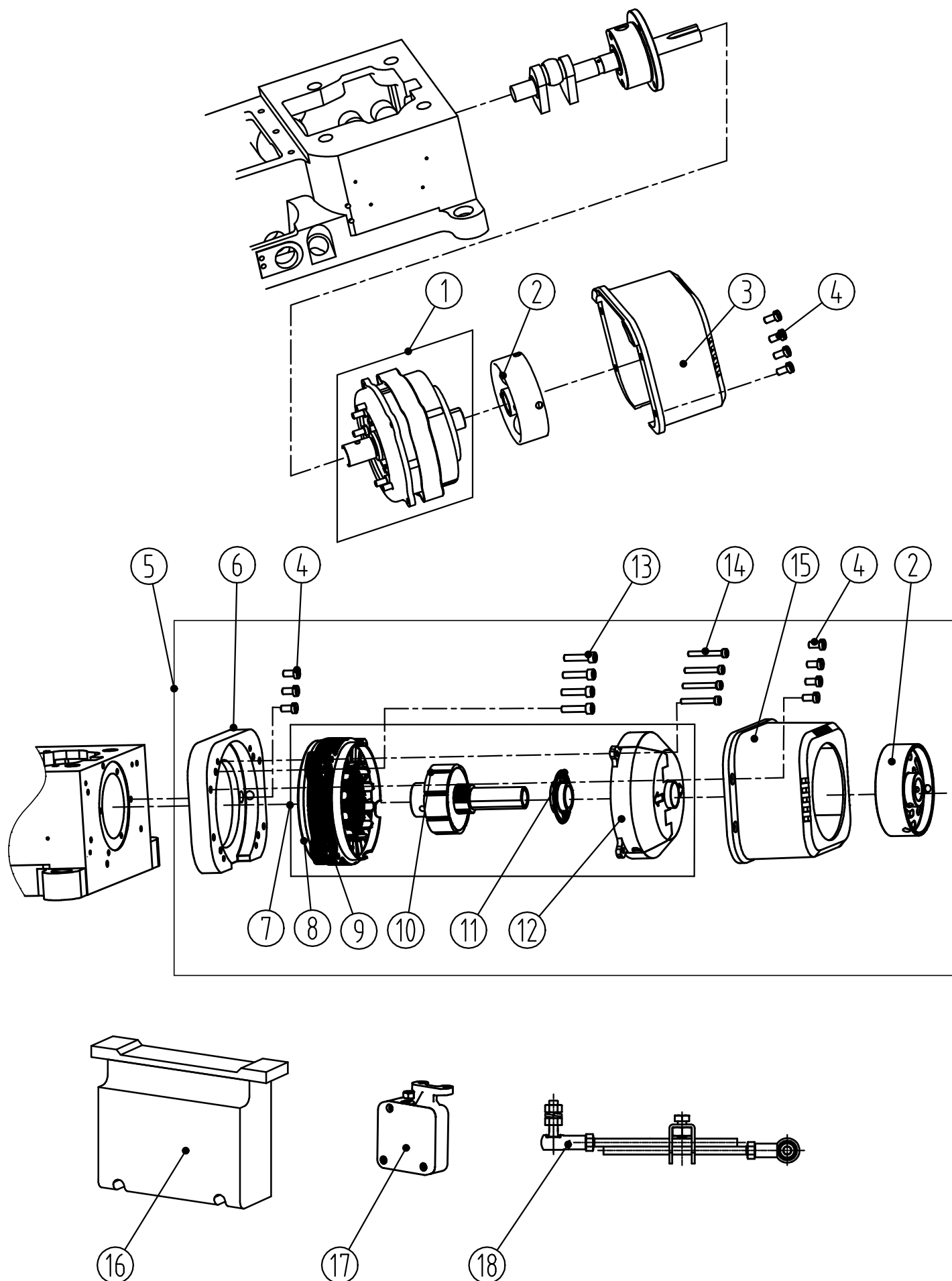
十三、后凸轮部件(21针)/After cam assemblies



十三、后凸轮部件(21针)/After Cam assemblies

序号 No	件 号 Part No.	参考件号 Ref.Part.No	名 称	Description	数 量 Number	备注 Remark
1	3050501700	CL51	后拖轮球连杆组件	connection Assy	1	组件3050501700
2	30505020	CL50	连接连杆	Bearing	1	
3	305S16008	-----	六角螺母M6	Nut	1	
4	305S30007	CL49	球连杆球杆	Iron Cover	1	
5	30522021	CL48	O型圈 $\phi 7 \times \phi 10 \times \phi 1.9$	Washer	1	
6	30505019	CL50	后拖轮球连杆杆体	Bearing	1	
7	30505018	-----	后拖轮球连杆头部	Iron Cover	1	
8	305S20014	SM524	后拖轮球连杆螺钉M5×8.5	Screw	2	
9	W01090	CL48	垫圈5	Washer	2	
10	30503034	-----	轴承滚套	Bushing	1	
11	B07011	CL49	滚针轴承K8×11×10	Iron Cover	1	
12	30504015	VCL14	后拖轮传送轴左曲柄	Crank	1	
13	305S30009	CL47	传动轴左曲柄调节柱	Screw	1	
14	S05037	SM612	内六角圆柱头螺钉 M6×15	Screw	1	
15	130512001	CL37	后拖轮传动板组件	Jib	1	
16	N01004	NM511	六角螺母M5	Nut	1	
17	30512056	CL38	蝶形卡簧	Spring	1	
18	B07054	-----	单向滚针轴承NSK FC-20	Bearing	2	
19	130525004	VCL16	光滑上拖轮	After Cam Assy	1	
20	130525003	VCL08	光滑下拖轮	Press Wheel	1	
21	30512057	CL45	单向轴承止动轮	Bracket	1	
22	130502038	VCL17	压轮轴	Shaft	1	
23	1305NS20002	-----	轴位螺钉	Screw	1	
24	130509008	-----	后拖轮调节块	Block	1	
25	S05023	-----	螺钉M6×10	Screw	1	
26	L02006	SM433	六角头螺栓	Screw	2	
27	N01004	NM511	螺母M5	Nut	2	
28	S09008	SM103	内六角平端紧定螺钉	Screw	1	
29	H05008	CL41	开口挡圈8	Washer	5	
30	20128010	CL41	垫圈10	Washer	1	
31	30503032	-----	后压轮架厚铜套	Bushing	1	
32	130501035	-----	后压轮架	Press Wheel Fight	1	
33	305S11012	SM470	轴肩螺钉M4	Screw	1	
34	305S16008	NM511	六角螺母M6	Nut	1	
35	30503033	-----	后压轮架薄铜套	Bushing	1	
36	30503036	VCL31	后轮挤压套	Bushing	1	
37	W01010	WM800	垫圈8	Washer	1	
38	N01027	-----	六角螺母M8	Nut	1	
39	13050103800	-----	光滑后拖轮组件(21针)	After Cam Assembly	1	

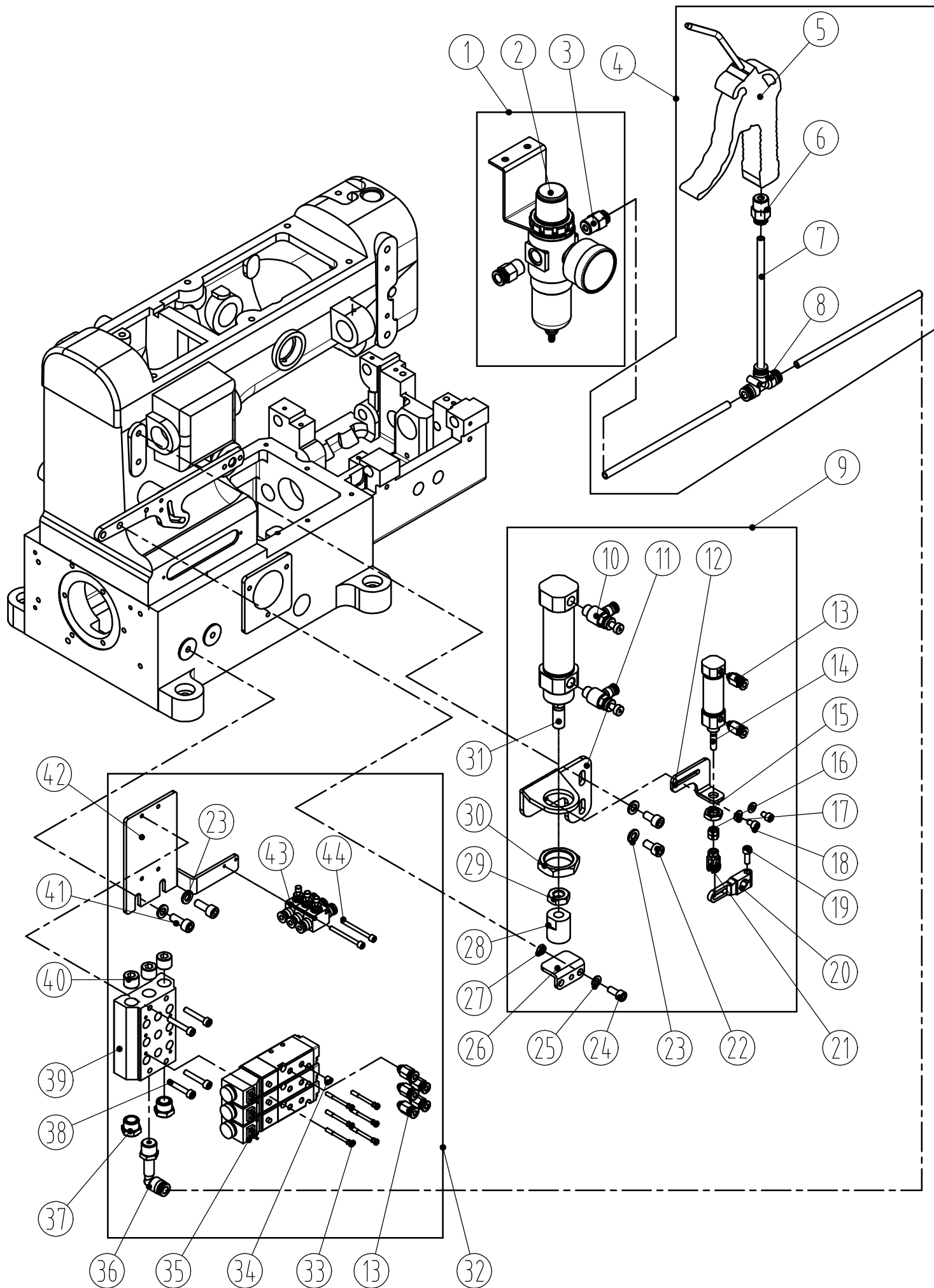
十四、驱动部件/Drive assemblies



十四、驱动部件/Drive assemblies

序号 No	件 号 Part No.	参考件号 RefPartNo	名 称	Description	数 量 Num ber	备注 Rem ark
1	13053300100	-----	直驱电机	Motor direct drive	1	D 直驱部件
2	304027/930001819	-----	电机手轮	Machine Pulley	1	
3	130511006	-----	电机护罩	Motor cover	1	
4	S01011	SM 534	开槽球面圆柱头螺钉M 5×10	Screw	7	
5	-	-----	12UTL驱动部件	12UTL drive assemblies	1	
6	130501004	-----	无壳电机安装座	Mounting base	1	
7	13053300400	-----	多针UTL电机	electrical machinery	1	D 直驱部件 组件13053300400
8	95211058	-----	绝缘罩壳	housing	1	
9	195300046	-----	电机定子	motor stator	1	
10	195300047	-----	电机转子	motor rotor	1	
11	95300018	-----	光栅片	grating filter	1	
12	195300045	-----	编码器罩壳	housing	1	
13	S05166	-----	内六角圆柱头螺钉M 5×22	screw	4	
14	305S12002	-----	内六角圆柱头螺钉M 4×30	screw	4	
15	30511011	-----	电机护罩	housing	1	
16	13053000800	-----	控制器	Direct-drive interlock control	1	D 电控
16	703728	-----	控制器	Direct-drive interlock control	1	D 电控
17	20730338	-----	调速器	eccentric retainer	1	适配D 电控
18	11543100300	-----	拉杆	Link	1	

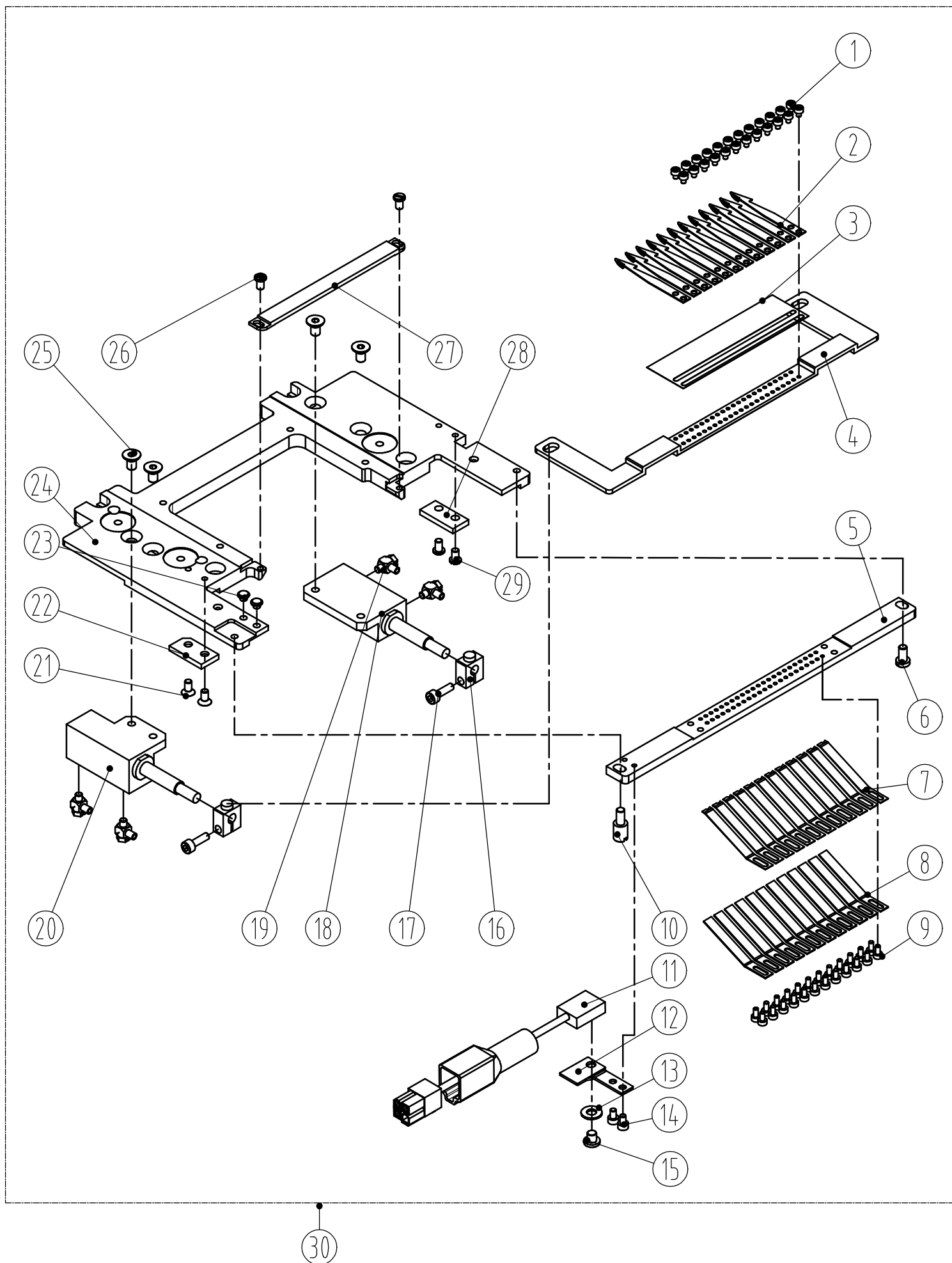
十五、12UTL 抬压脚部件/12UTL Presser Foot Takeup assemblies



十五、12UTL抬压脚部件/12UTL Presser Foot Takeup Assemblies

序号 No	件号 Part No	参考件号 Ref.Part.No	名称	Description	数量 Number	备注
1	I3054507400	-----	气压表组件	Gas-pressure Meter Assy	1	组件I3054507400
2	I30545074	-----	调压过滤器AFR2000	Gas-pressure Meter	1	
3	I30545081	-----	管接头BPC602	Pipe Connector	2	
4	I3054510800	-----	气枪组件	Air Gun Assy	1	组件I3054510800
5	I30545104	-----	气枪	Air Gun	1	
6	I30545105	-----	管接头PC602	Pipe Connector	1	
7	I30545106	-----	气管(Φ6×1000)	Tube	3	
8	I30545107	-----	管接头PE6	Pipe Connector	1	组件I3054506700
9	I3054506700	-----	抬压脚及松线组件	Thread Loose Assy	1	
10	I30545064	-----	调速阀PSL401A	Valve	2	
11	I30512029	-----	抬压脚气缸安装板	Plate	1	
12	I30512030	-----	夹线器气缸安装板	Plate	1	
13	I30545091	-----	管接头PC4M5	Pipe Connector	7	
14	I30545112-1	-----	夹线器松线气缸PB16×15U	Air Cylinder	1	气缸组件I3054511200
15	I30545112-2	-----	六角螺母M10	Nut	1	
16	I30545112-3	-----	六角螺母M5	Nut	2	
17	W01151	-----	平垫圈4.3×9×0.8	Washer	2	
18	S05115	-----	内六角圆柱头螺钉M4×6(滚花)	Screw	2	
19	S05133	-----	内六角圆柱头螺钉M4×12	Screw	1	
20	I30504018	-----	气缸松线曲柄	Crank	1	
21	I3054512600	-----	Y接头	Connector	1	
22	S05033	-----	内六角螺钉M6×12	Screw	2	
23	W01156	-----	垫圈6	Washer	2	
24	S05087	-----	内六角圆柱头螺钉M5×12	Screw	1	
25	W01047	-----	平垫圈5	Washer	1	
26	I30512031	-----	抬压脚扳手挡板	Plate	1	
27	N01043	-----	六角螺母M5	Nut	1	
28	I30544003	-----	抬压脚调节块	Block	1	
29	I30545111-3	-----	六角螺母M10	Nut	1	气缸组件I3054511100
30	I30545111-2	-----	六角螺母M26	Nut	1	
31	I30545111-1	-----	抬压脚气缸MF25×40U	Air Cylinder	1	
32	I3054507900	-----	电磁阀组件	Valve Assy	1	组件I3054507900
33	I305NS11001	-----	复合槽带垫组件螺钉M3×8	Screw	6	
34	S09019	-----	紧定螺钉M5×5(进口)	Screw	1	
35	I30545079	-----	电磁阀4V110M5BI	Valve	3	
36	I30545076	-----	管接头PLL602示意图	Pipe Connector	1	
37	I30545075	-----	消声器BSLM02	Silencer	2	
38	S05063	-----	内六角圆柱头螺钉M4×25	Screw	4	
39	I30501007	-----	电磁阀底座100M3F	Seat	1	
40	41845219	-----	内六角堵头ABP02	Screw	3	
41	S05964	-----	内六角圆柱头螺钉M6×16	Screw	2	
42	I30512042	-----	电磁阀安装板	Plate	1	
43	I30545080	-----	调速阀PSA4D	Valve	3	
44	I305NS13003	-----	内六角圆柱头螺钉M3×35	Screw	2	

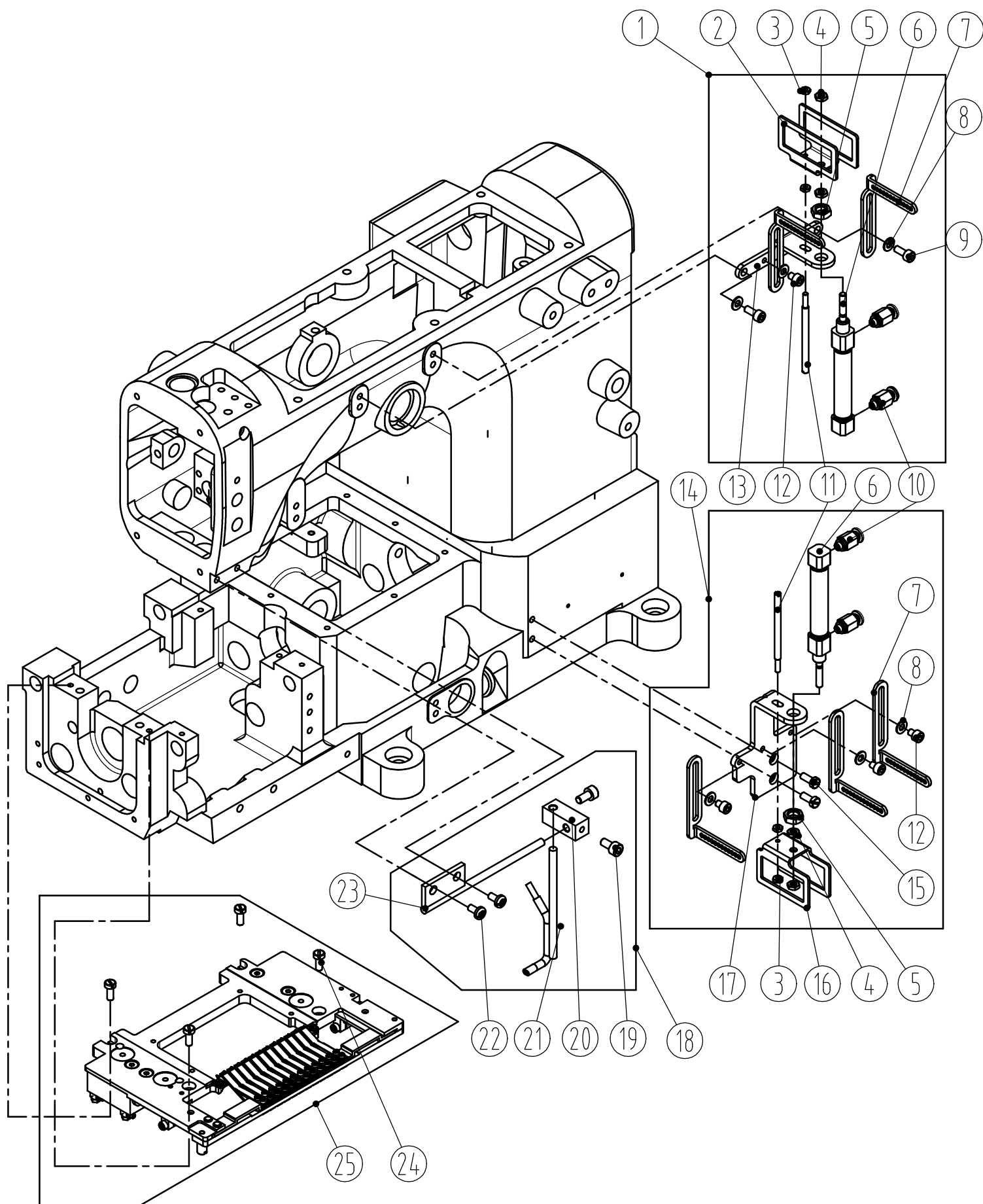
十六、12UTL剪线刀盘部件/12UTL Thread cutting assemblies



十六、12UTL剪线刀盘部件/12UTL Thread Cutting assemblies

序号 No	件号 Part No	参考件号 Ref.Part.No	名称	Description	数量 Number	备注
1	1305NS13001		内六角圆柱头螺钉M2×2.5	Screw	24	
2	130519006		动刀	Thread Cutting	12	
3	130512035		推线片	plate	1	
4	13050901100		动刀架	Seat	1	
5	130512036		定刀架	Seat	1	
6	S01090		开槽圆柱头螺钉M3.5×7	Screw	1	
7	130512038		夹线片	plate	12	
8	130512037		压板	plate	12	
9	1305NS13002		内六角圆柱头螺钉M2×4	Screw	24	
10	1305NS15001		开槽圆柱头螺钉M3.5×7	Screw	1	
11	13054512800		安全开关连接线	Wire	1	
12	130545127		安全开关固定板	Plate	1	
13	W01006		平垫圈4.3×9×0.8	Washer	1	
14	S05254		内六角圆柱头螺钉M2.5×4	Screw	2	
15	S01103		开槽圆柱头螺钉M4×3.5	Screw	1	
16	130504019		气缸连接块	Block	2	
17	S05328		内六角圆柱头螺钉M3×10	Screw	2	
18	13054507000		刀盘右气缸	Air Cylinder	1	
19	13054506900		气管接头组件	Pipe Connector Assy	4	
20	13054506800		刀盘左气缸	Air Cylinder	1	
21	S05217		内六角沉头螺钉M3×3.5	Screw	2	
22	130509012		动刀架压板（左）	Block	1	
23	130522005		防震垫	Rubber Plug	2	
24	130543001		刀盘架	Seat	1	
25	S14002		内六角沉头螺钉M4×4	Screw	2	
26	1305NS11002		开槽圆柱头螺钉M3×5	Screw	2	
27	130519005		定刀	Thread Cutting	1	
28	130509013		动刀架压板（右）	Block	1	
29	S01027		开槽圆柱头螺钉M3×6	Screw	2	
30	13051900700		多针机剪线刀盘组件	Thread Cutting Assemblies	1	组件13051900700

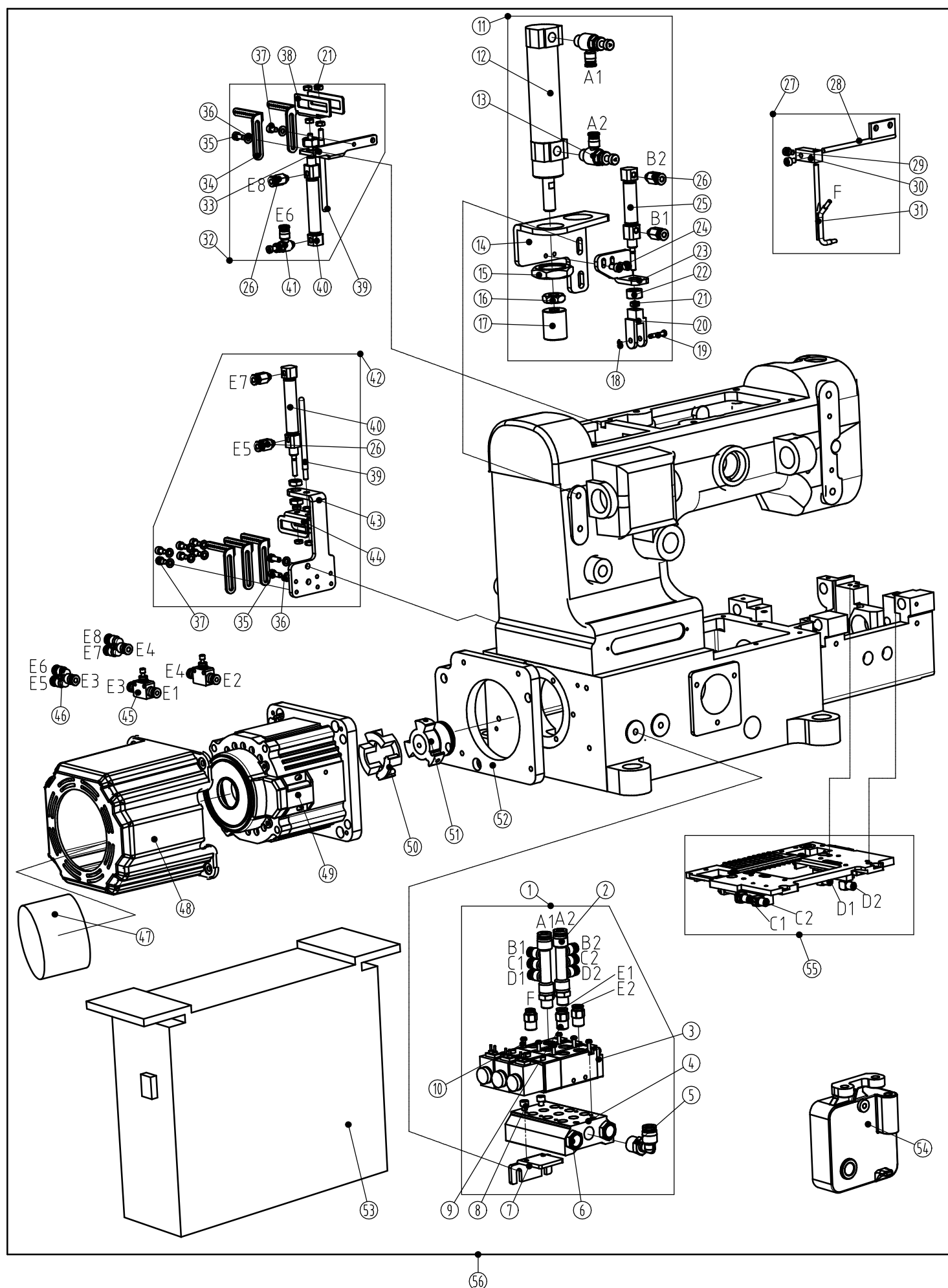
十七、12UTL上下松线部件/12UTL Thread Loose assemblies



十七、12UTL上下松线部件/12UTL Thread Loose Assemblies

序号 No	件号 Part No	参考件号 Ref.Part.No	名称	Description	数量 Number	备注
1	13054507300		上松线气缸组件	Thread Loose Assy	1	组件13054507300
2	130512043		上松线气缸松线架	Plate	1	
3	N01143		六角螺母M3	Nut	2	
4	-		六角螺母M4	Nut	4	气缸组件130545071
5	-		六角螺母M8	Nut	2	
6	130545071		松线气缸PB10×30U	Air Cylinder	2	
7	130513016		长过线板	Thread Guide	5	
8	30228009		垫片	Washer	6	
9	S05648		内六角圆柱头螺钉M4×10	Screw	2	
10	130545091		管接头PC4M5	Pipe Connector	4	
11	130509015		松线架导杆	Stick	2	
12	S05646		内六角圆柱头螺钉M4×5	Screw	4	
13	130512041		上松线气缸安装板	Plate	1	
14	13054507200		下松线气缸组件	Thread Loose Assy	1	组件13054507200
15	S01646		开槽圆柱头螺钉M4×10	Screw	2	
16	130512052		下松线气缸松线架	Plate	1	
17	130512039		下松线气缸安装板	Plate	1	
18	13054513000		吹气组件	Blow Assy	1	组件13054513000
19	413S13016		内六角圆柱头螺钉M4×8	Screw	1	
20	130545132		支架连接块	Block	1	
21	13054512900		吹气管组件	pipe Assy	1	
22	113S11004		松线导管压板螺钉	Screw	2	
23	13054513100		吹气管安装板	Plate	1	
24	S01005		开槽圆柱头螺钉M4×10	Screw	4	
25	13051900700		多针机剪线刀盘组件	Thread Cutting Assmblies	1	组件13051900700

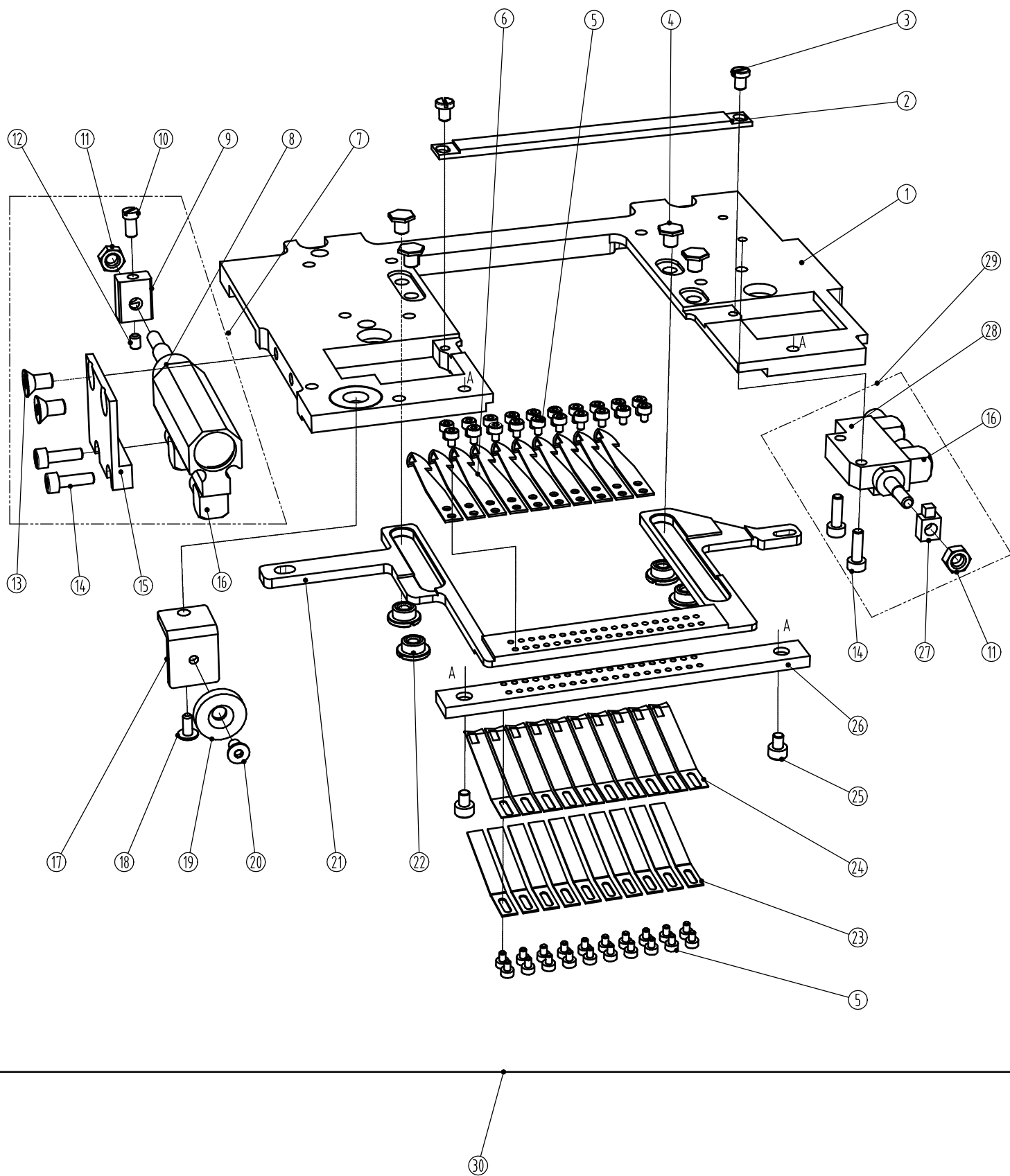
十八、UTL直驱专用部件/UTL Special for direct drive assemblies



十八、UTL直驱专用部件/UTL direct drive assemblies

序号 No	件 号 Part No.	参考件号 Ref.Part.No	名 称	Description	数 量 Number	备注 Remark
1	13053000400	-----	电磁阀组件	Cover	1	组件13053000400
2	130545089	-----	气管接头	Joint	2	
3	130545086	-----	电磁阀	Solenoid	3	
4	130501007	-----	电磁阀底座	Slider	1	
5	130545087	-----	气管接头	Joint	1	
6	130545075	-----	消声器	Muffler	1	
7	130512046	-----	电磁阀安装板	Rest board	1	
8	S05063	-----	内六角圆柱头螺钉M4×25	Screw	2	
9	130545088	-----	气管接头	Joint	3	
10	1305NS11001	-----	螺钉带垫圈	Screw	6	
11	13054506000	-----	抬压脚气缸组件	Cover	1	组件13054506000
12	13054511100	-----	抬压脚气缸MF25×40U	Cylinder	1	
13	130545064	-----	调速阀PSL401A	Valve	2	
14	130512044	-----	抬压脚气缸安装板	Rest board	1	
15	N01119	-----	螺母M26	Nut	1	
16	301S16018	-----	螺母M10	Nut	1	
17	130511010	-----	抬压脚调节块	Block	1	
18	H05024	-----	开口挡圈	Ring	1	
19	130526002	-----	松线曲柄架销	Pin	1	
20	130501014	-----	松线曲柄连接架	Support	1	
21	N01001	-----	六角螺母M4	Nut	9	
22	N01027	-----	六角螺母M8	Nut	1	
23	130512045	-----	松线气缸安装板	Rest board	1	
24	S05116	-----	内六角螺钉M4×8	Screw	2	
25	13054511200	-----	夹线器松线气缸PU16×15U	Air Cylinder	1	
26	130545091	-----	管接头PC4M5	Joint	5	
27	13054513000	-----	吹气组件	Blow Assy	1	组件13054513000
28	13054513100	-----	吹气管安装板	Plate	1	
29	S01005	-----	开槽圆柱头螺钉M4×10	Screw	2	
30	130545132	-----	支架连接块	Block	1	
31	13054512900	-----	吹气管组件	pipe Assy	1	
32	13054505800	-----	上松线气缸组件	Cover	1	组件13054505800
33	130501012	-----	上松线气缸安装板	Rest board	1	
34	30513016	-----	长过线板	Thread guide	5	
35	S05048	-----	内六角圆柱头螺钉M4×10	Screw	3	
36	W01139	-----	垫片	Washer	10	
37	S05115	-----	内六角圆柱头螺钉M4×6	Screw	7	
38	130512043	-----	上松线架	Support	1	
39	130509016	-----	松线气缸导向杆	Pin	1	
40	130545071	-----	松线气缸PB10×30U	Air Cylinder	2	
41	130545090	-----	调气阀	Valve	1	
42	13054505900	-----	下松线气缸组件	Cover	1	组件13054505900
43	130512051	-----	下打线架安装座	Slider	1	
44	130513019	-----	下松线架	Support	1	
45	130545095	-----	调气阀	Valve	2	
46	130545093	-----	三通	Valve	2	
47	130533006	-----	电机手轮	Machine Pulley	1	
48	130511009	-----	电机护罩	Motor cover	1	
49	13053300500	-----	直驱电机	Motor direct drive	1	
50	131622009	-----	电机三爪垫	shaft sleeve gasket	1	
51	130501015	-----	电机三爪	shaft sleeve	1	
52	130512020	-----	电机安装座	Rest board	1	
53	13053000500	-----	控制器	Direct-drive interlock controller	1	
54	13053000600	-----	调速器	eccentric retainer	1	
55	13051900100	-----	刀盘组件	Thread cutting assemblies	1	
56	13053300200	-----	UTL直驱专用部件	UTL direct drive assemblies	1	

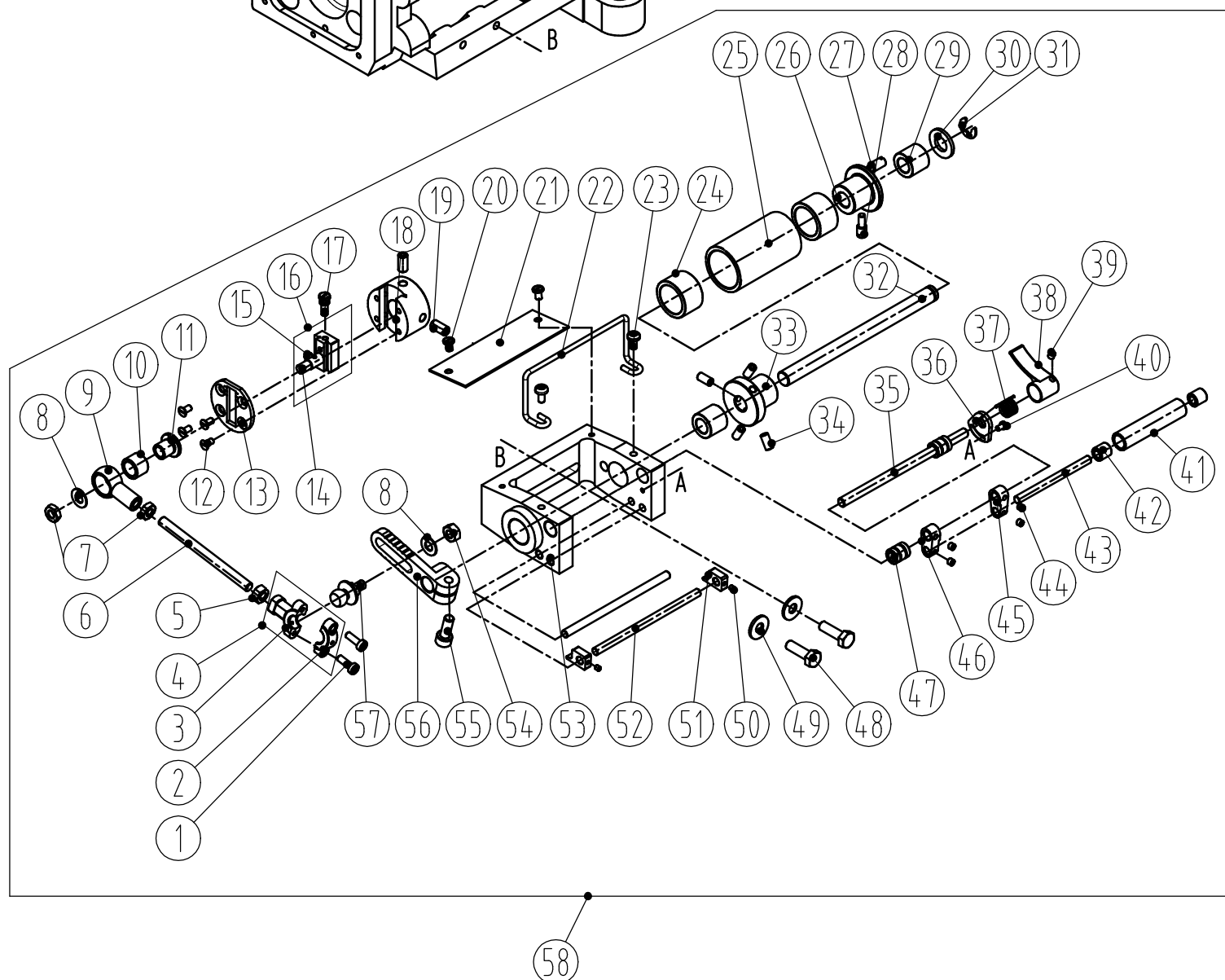
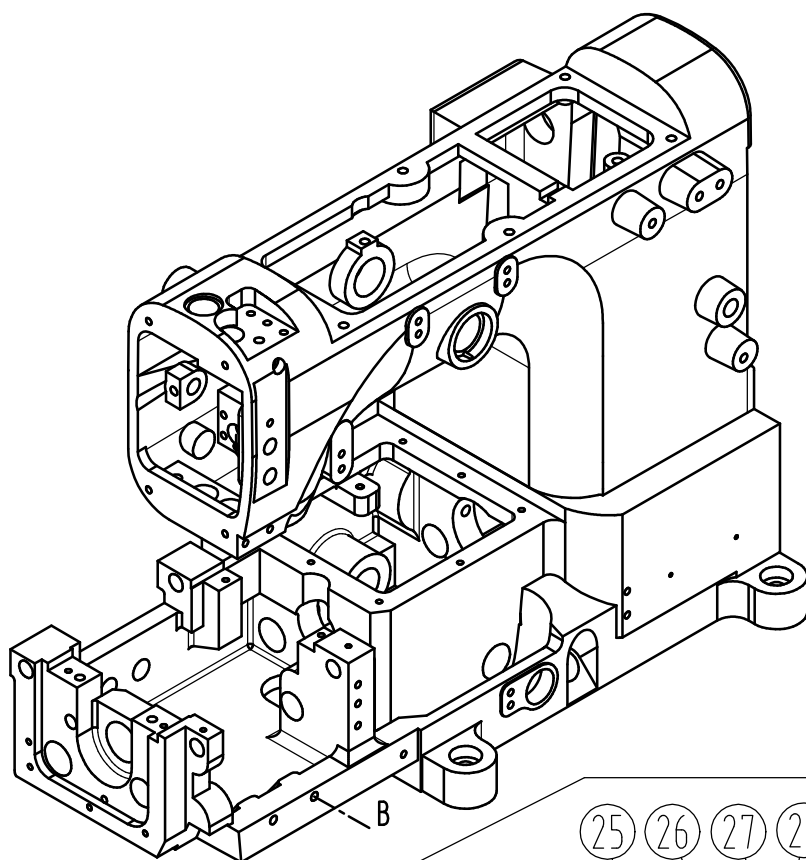
十九、UTL剪线刀盘部件/UTL Thread cutting assemblies



十九、UTL剪线刀盘部件/UTL Thread cutting assemblies

序号 No	件 号 Part No.	参考件号 Ref.Part.No	名 称	Description	数 量 Number	备注 Remark
1	130545020		定刀座	Fixed knife Seat	1	
2	130545021		定刀	Fixed knife	1	
3	1305NS11002		开槽圆柱头螺钉M3×5	Screw	2	
4	1305NS12004		外六角螺钉M4×4.5	Screw	4	
5	1305NS13002		内六角圆柱头螺钉M2×4	Screw	40	
6	130545022		动刀	Moving knife	10	
7	130545018		大气缸组件	Air Cylinder	1	组件130545018
8	130545050		大气缸	Air Cylinder	1	
9	130545043		限位块	Cover	1	
10	207S11023		固定螺钉M3×6	Screw	1	
11	130545042		锁紧螺母	Cover	2	
12	S09042		内六角平端紧定螺钉M3×4	Screw	1	
13	S14002		内六角沉头螺钉M4×5	Screw	2	
14	S05328		内六角圆柱头螺钉M3×10	Screw	4	
15	130545051		安装板	Rest board	1	
16	13054506900		气管接头组件	Joint	4	
17	130545028		磁铁安装板	Rest board	1	
18	130545055		十字半圆头螺钉	Screw	1	
19	130545027		磁铁	Magnet	2	
20	S05217		内六角沉头螺钉M3×3.5	Screw	1	
21	130545019		动刀座	Moving knife Seat	1	
22	1305NS30001		动刀限位螺钉	Screw	4	
23	130545025		调压压板	Pressure liate	10	
24	130545024		夹线片	Tension disc	10	
25	S05047		内六角圆柱头螺钉M3×4	Screw	2	
26	130545023		夹线片安装板	Rest board	1	
27	130545035		小限位块	Cover	1	组件130545017
28	130545033		小气缸	Air Cylinder	1	
29	130545017		小气缸组件	Air Cylinder	1	
30	13051900100		UTL剪线刀盘组件	Thread Cutting Assmblies	1	组件13051900100

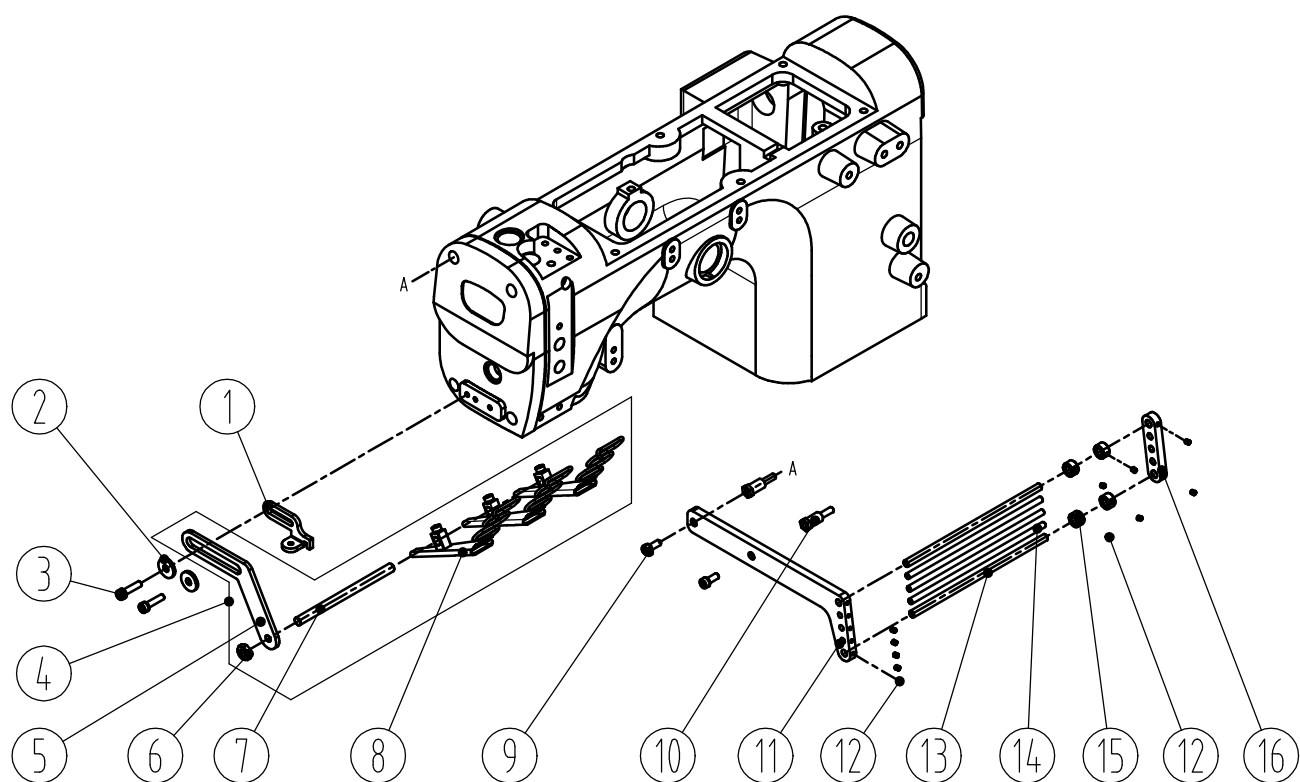
二十、前松紧带装置(VWL)/Front elastic band assemblies(VWL)



二十、前松紧带装置(VWL)/Front elastic band assemblies(VWL)

序号 No	件 号 Part No.	参考件号 Ref.Part.No	名 称	Description	数 量 Number	备注 Remark
1	S04019	-----	十字槽盘头螺钉M4×12	Screw	2	
2	30505028-02	-----	松紧带传动球连杆小头	Connecting rod	1	组件30505028
3	30505028-01	-----	松紧带传动球连杆大头	Connecting rod	1	
4	30505028	-----	松紧带传动球连杆	Connecting rod	1	
5	306S16002	-----	螺母M6(左旋)	Nut	1	
6	30502047	-----	螺杆	Screw	1	
7	N01012	-----	六角螺母M6(进口)	Nut	2	
8	14428002	-----	平垫圈6.5×13×0.8	Washer	2	
9	30505029	-----	轴承连杆	Connecting rod	1	
10	B09012	-----	冲压外圈滚针轴承HK101410	Bearing	1	
11	30503043	-----	轴承滚套	Bushing	1	
12	305S02001	-----	开槽沉头螺钉SM9-64×40×5.3	Screw	4	
13	30512064	-----	刻线板	Plate	1	
14	30509030	-----	偏心调节滑块	Block	1	组件3050903300
15	30526003	-----	抬牙连杆销	Pin	1	
16	3050903300	-----	偏心滑块组件	Eccentric slider assembly	1	
17	305S01001	-----	调节螺钉M4×9	Screw	1	
18	30509029	-----	主轴连接块	Block	1	
19	305S10002	-----	内六角凹端紧定螺钉M6×12	Screw	2	
20	S01055	-----	开槽圆柱头螺钉M4×6	Screw	2	
21	30512080	-----	护线板	Plate	1	
22	130501026	-----	过布架	Shelf	1	
23	113S11004	-----	松线导管压板螺钉	Screw	2	
24	B09010	-----	冲压外圈单向滚针轴承HF2016	Bearing	2	
25	30525018	-----	大滚轮	Roller	1	
26	30503045	-----	止动轮	Roller	1	
27	305S30010	-----	限位螺钉M4×3	Screw	1	
28	305S30011	-----	限位螺钉M4×8.5	Screw	1	
29	B09011	-----	冲压外圈滚针轴承HK101715	Bearing	2	
30	W01018	-----	垫圈10.5×20×2	Washer	1	
31	H05001	-----	开口挡圈7	Retaining ring	1	
32	30502058	-----	传送轴	Shaft	1	
33	30503046	-----	转动轮	Roller	1	
34	207S11041	-----	内六角凹端紧定螺钉	Screw	4	
35	30502057	-----	上夹带轴	Axle	1	
36	30509038	-----	调节块	Block	1	
37	30527020	-----	压紧弹簧	Spring	1	
38	30512083	-----	调节扳手	Wrench	1	
39	S10007	-----	内六角凹端紧定螺钉M4X4	Screw	1	
40	207S11009	-----	开槽圆柱头螺钉	Screw	1	
41	30525017	-----	小滚轮	Roller	1	
42	B09009	-----	冲压外圈滚针轴承HK050909	Bearing	2	
43	30502055	-----	小滚轮轴	Axle	1	
44	305S10001	-----	内六角凹端紧定螺钉M4×3	Screw	4	
45	30509033	-----	小滚轮左固定块	Block	1	
46	30509032	-----	小滚轮右固定块	Block	1	
47	30503044	-----	上夹带轴轴套	Bushing	2	
48	L02004	-----	螺栓M6×20	Screw	2	
49	30328007	-----	垫片	Washer	2	
50	S10026	-----	内六角凹端紧定螺钉M3×3(进口)	Screw	2	
51	30509031	-----	带宽限位块	Block	2	
52	30502056	-----	引带轴	Shaft	2	
53	30501059	-----	松紧带传送架	Shelf	1	
54	305S16007	-----	螺母M6×0.75	Nut	1	
55	S05019	-----	内六角圆柱头螺钉M6×16.3	Screw	1	
56	30504045	-----	传动曲柄	Crank	1	
57	30505027		松紧带传动球头	Connecting rod	1	
58	30500121		前松紧带装置(VWL)	Front elastic band assemblies(VWL)	1	组件30500121

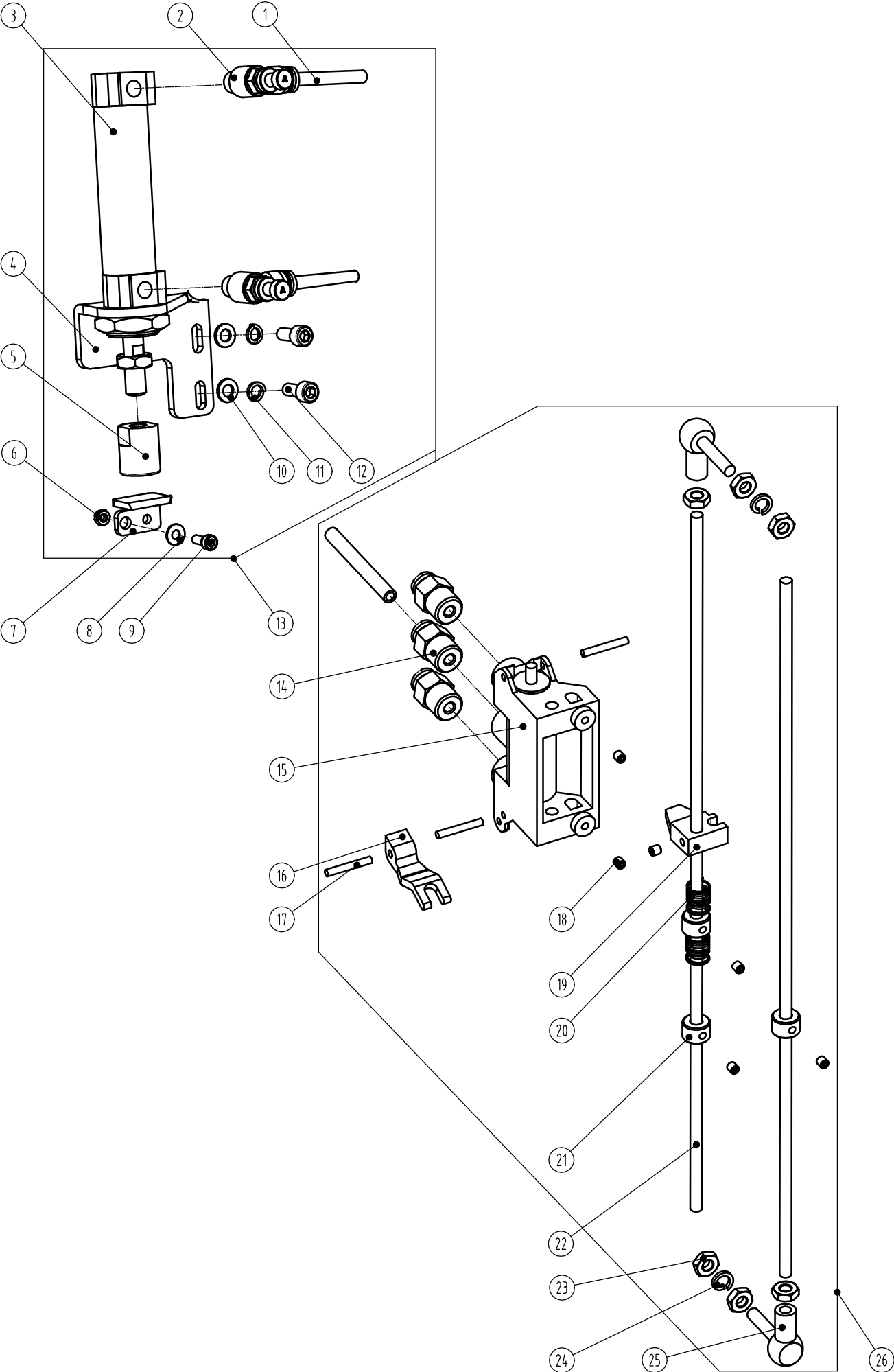
二十一、贴条装置(VPL)/Stick strip assemblies(VPL)



二十一、贴条装置(VPL)/Stick strip assemblies(VPL)

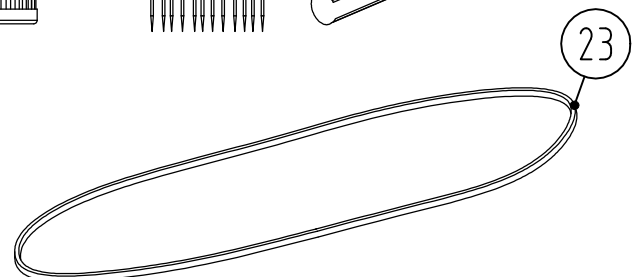
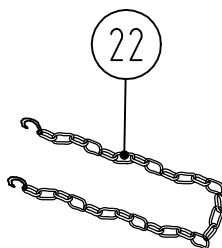
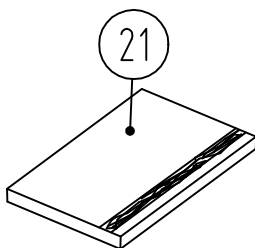
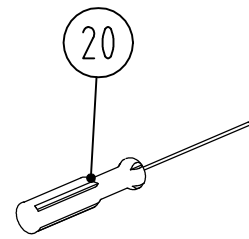
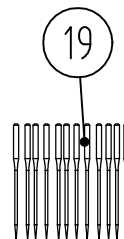
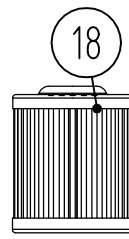
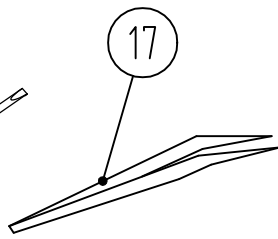
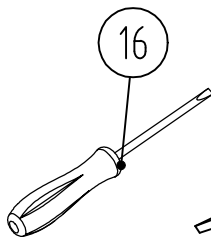
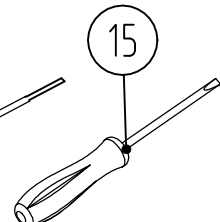
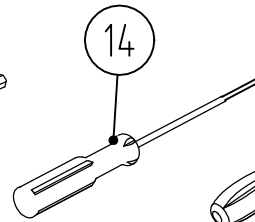
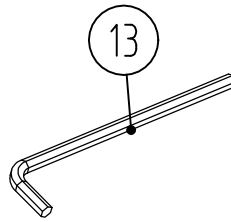
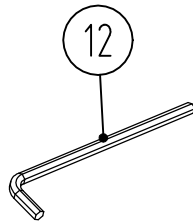
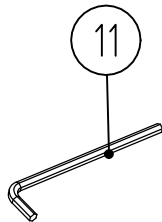
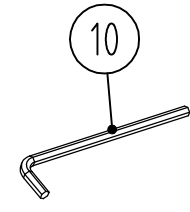
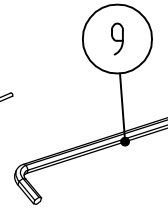
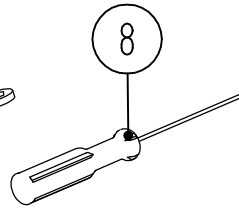
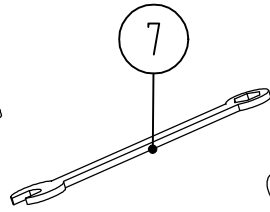
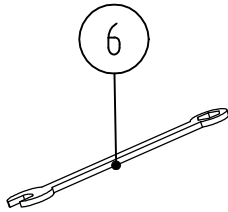
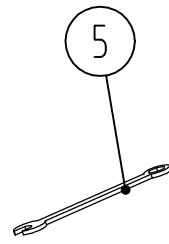
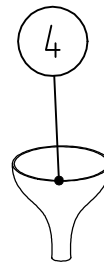
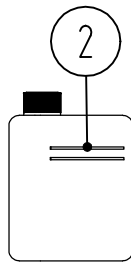
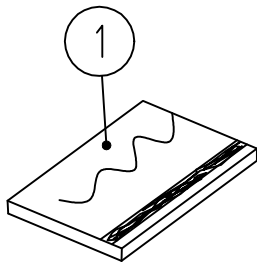
序号 No	件 号 Part No.	参考件号 Ref.Part.No	名 称	Description	数 量 Number	备注 Remark
1	30512002		断针防护罩架座	Frame	1	
2	20628006		垫圈	Washer	2	
3	207S13008		内六角圆柱头螺钉	Screw	2	
4	3053100500		多针面贴筒	Crimper Assy	1	组件3053100500
5	130531013		贴条拉筒固定架	Plate	1	
6	N01012		六角螺母M6(进口)	Nut	1	
7	130531012		贴条拉筒固定螺柱	Screw	1	
8	13053101100		卷边器组件示意图	Crimper	3	
9	413S13017		内六角圆柱头螺钉	Screw	2	
10	301S30041		刀座安装板连接螺钉	Screw	2	
11	3053103700		贴条柱固定架	Plate	1	
12	305S14002		内六角平端紧定螺钉	Screw	11	
13	3053103900		贴条柱(大)	pole	2	
14	3053104000		贴条柱(小)	pole	3	
15	3053104100		贴条固定挡圈	Retaining ring	4	
16	3053103800		贴条柱右固定架	Plate	1	

二十二、气动抬压脚装置(A1)/Pneumatic Presser Foot Takeup assemblies(A1)



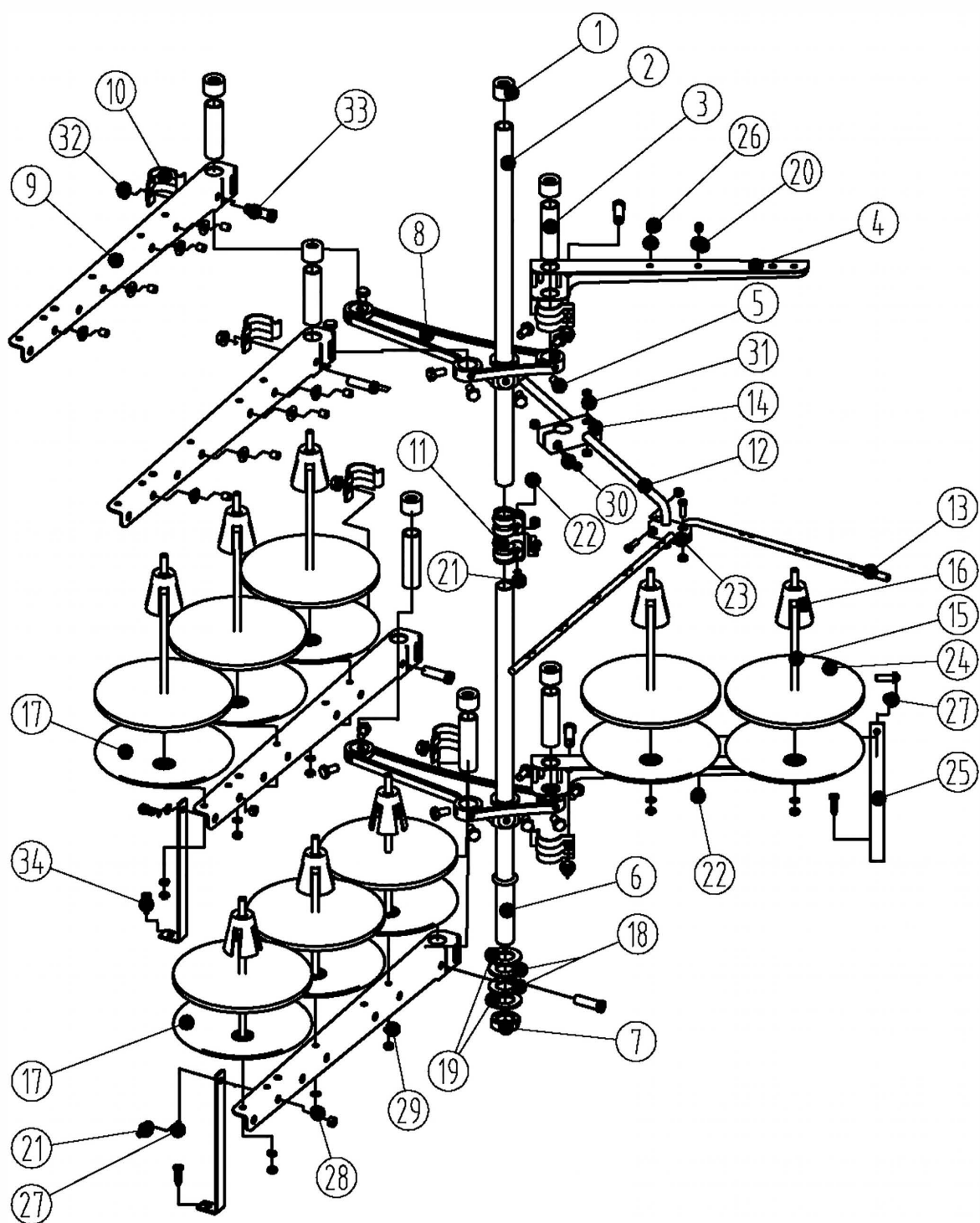
二十二、气动抬压脚装置(A1)/Pneumatic Presser Foot Takeup assemblies(A1)

序号 No	件 号 Part No.	参考件号 Ref.Part.No	名 称	Description	数 量 Number	备注 Remark
1	130545106	-----	气管(Φ6×1000)	Tube	3	组件13054513400
2	130545136	-----	调速阀PSL601A	Valve	2	
3	130845084	-----	抬压脚气缸	Air Cylinder	1	
4	130512044	-----	抬压脚气缸安装板	Plate	1	
5	130544003	-----	抬压脚调节块	Block	1	
6	N01001	-----	六角螺母M4	Nut	1	
7	130509021	-----	抬压脚气缸挡板	Plate	1	
8	W01139	-----	平垫片	Washer	1	
9	S05048	-----	内六角圆柱头螺钉M4×10	Screw	2	
10	42128023	-----	垫圈	Washer	2	
11	W02004	-----	弹簧垫圈	Washer	2	
12	S05028	-----	内六角圆柱头螺钉M6×14	Screw	2	
13	13054513400	-----	抬压脚组件(气动)	Presser Foot Takeup Assemblies	1	
14	130545081	-----	管接头BPC602	Pipe Connector	3	组件13054513500
15	130545137	-----	气阀	Valve	1	
16	130513021	-----	挡板	Plate	1	
17	130526003	-----	销子	Pin	3	
18	207514001	-----	内六角平端紧定螺钉	Screw	6	
19	130513022	-----	挡板	Plate	1	
20	30227023	-----	弹簧	Spring	2	
21	130508002	-----	挡圈	Crank	3	
22	130513020	-----	拉杆	Link	2	
23	N01012	-----	六角螺母M6	Nut	6	
24	W02868	-----	弹簧垫圈	Washer	2	
25	130504020	-----	连接球头	Crank	2	
26	13054513500	-----	拉杆组件(气动)	Link Assemblies	1	



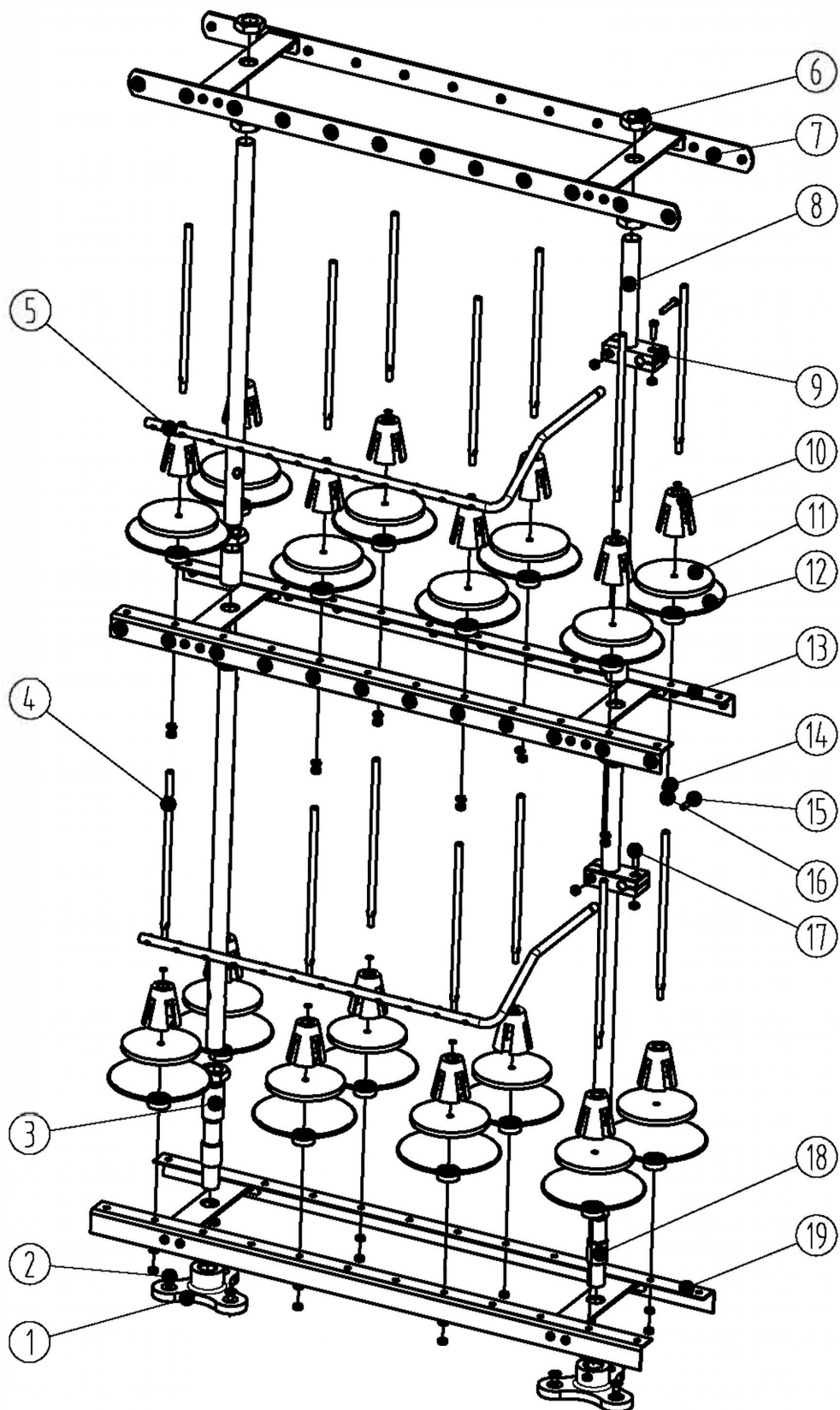
二十三、附件部件(1)/Accessories Assemblies (1)

序号 No	件 号 PartNo.	参考件号 RefPartNo	名 称	Description	数 量 Num ber	备注 Rem ark
1	40131017	-----	防尘罩	dust guard	1	
2	20131037	MY02	油壶	Oil Can	1	
3	20131038	MY03	小油壶	Oil Can	2	
4	20131039	KY04	漏斗	Oil Funnel	1	
5	20131041	KY07	6mm 六角扳手	Spanner(6mm)	1	
6	20131042	KY08	7mm 六角扳手	Spanner(7mm)	1	
7	20131043	KY09	8mm 六角扳手	Spanner(8mm)	1	
8	20131044	MY09	内六角螺丝刀15mm	Inner-hexagon Driver(15mm)	1	
9	20131046	MY08	2mm 内六角扳手	Inner-hexagon Driver(2mm)	1	
10	30131010	MY10	3mm 内六角扳手	Inner-hexagon Driver(3mm)	1	
11	30131012	MY11	4mm 内六角扳手	Inner-hexagon Driver(4mm)	1	
12	20131047	MY12	5mm 内六角扳手	Inner-hexagon Driver(5mm)	1	
13	20131056	KY11	6mm 内六角扳手	Inner-hexagon Driver(6mm)	1	
14	10131002	KY14	大号一字螺钉刀	Screw Driver	1	
15	10131003	KY17	中号一字螺钉刀	Screw Driver	1	
16	10131004	KY16	小号一字螺钉刀	Screw Driver	1	
17	20131051	KY18	镊子	Tweezer	1	
18	20136001	KT14	滤油器	Oil Filter	1	
19	30517004	Uo113	机针	Needle	10	
20	20131045	MY09	内六角螺丝刀16mm	Inner-hexagon Driver(16mm)	1	
21	30531029	-----	说明书零件样本	Parts list Instruction book	1	
22	30131018	KY21	链条	Chain	1	
23	30135004	-----	皮带	Leather belt	1	非直驱配备



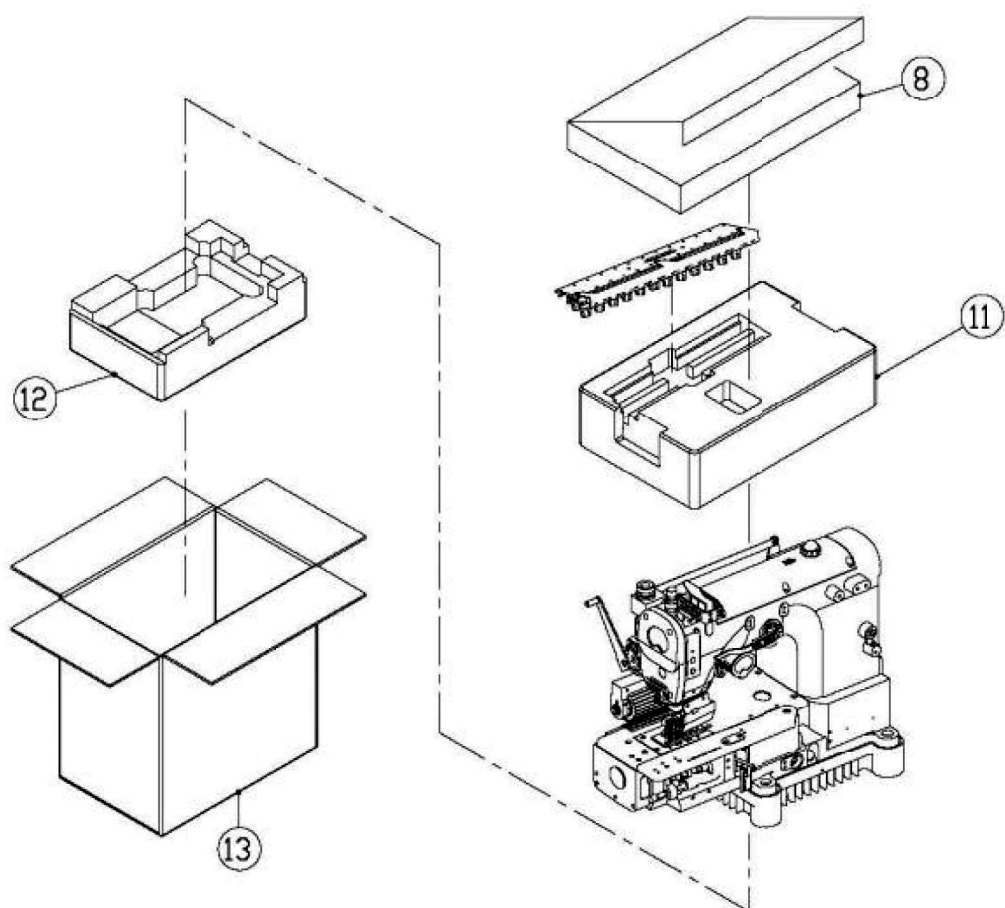
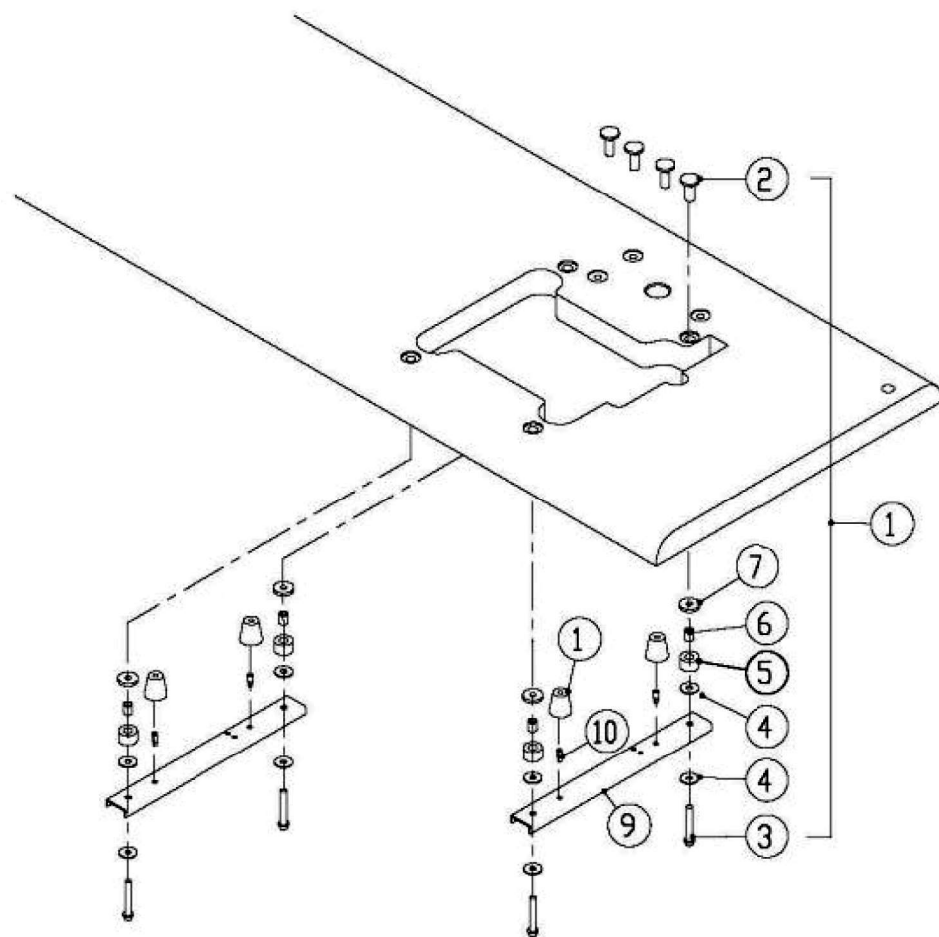
二十四、附件部件(2)/Accessories Assemblies (2)

序号 No	件 号 PartNo.	参考件号 RefPartNo	名 称	Description	数 量 Number	备注 Rem ark
1	30531031	-----	棒帽	Cushion	7	4针用线架组件30532002
2	30531062	-----	线架上管	Tube	1	
3	30531064	-----	短管	Tube	6	
4	30531067	-----	短过线架	Takeup	2	
5	421S12002	-----	六角头螺柱	Screw	16	
6	30531061	-----	线架下管	Tube	1	
7	305S16009	-----	螺母M 16×15	Nut	1	
8	30531063	-----	支座	Slider	2	
9	30531068	-----	长过线架	Takeup	4	
10	30531069	-----	夹板	Band	6	
11	30531070	-----	锁紧卡固	Slider	1	
12	30531065	-----	导线棒	Takeup	1	
13	30531066	-----	过线棒	Takeup	1	
14	30531032	-----	固定器	Slider	1	
15	20131006	-----	线托棒	Takeup	8	
16	20131008	-----	线圈定位套	Spacer	8	
17	20631025	-----	线托盘	Washer	8	
18	30531075	-----	橡胶垫圈	Washer	2	
19	30531077	-----	垫圈17	Washer	2	
20	30531078	-----	过线套	Spacer	10	
21	S04050	-----	十字槽凹穴六角头螺栓M 5×16	Screw	5	
22	N01030	-----	套螺母M 5	Nut	5	
23	21131013	-----	导线棒固定块	Slider	1	
24	20131010	-----	线盘垫	Washer	8	
25	30531074	-----	支撑板	Band	3	
26	10113011	-----	过线圈(内圈)	Tube	10	
27	W 01048	-----	平垫圈5	Washer	3	
28	201S16004	-----	螺母	Nut	12	
29	20128018	-----	线盘垫圈	Washer	8	
30	20131022	-----	棒架螺钉	Screw	1	
31	20131021	-----	棒架螺钉	Screw	3	
32	201S16006	-----	导线环螺母	Nut	6	
33	20131020	-----	导线环螺钉	Screw	6	
34	301S30020	-----	十字槽盘头自攻螺钉ST4 2×19	Screw	3	



二十四、附件部件(2)/Accessories Assemblies (2)

1	30531052	-----	底座	Slider	2	8针用线架组件30532004
2	301530022	-----	木螺钉	Screw	6	
3	30531079	-----	连接套	Spacer	4	
4	20131006	-----	线托棒	Takeup	16	
5	30531033	-----	过线棒	Takeup	2	
6	30531053	-----	螺母5	Nut	12	
7	30531046	-----	线架上架连体组件	Assembly	1	
8	30531055	-----	支撑管	Tube	4	
9	30531032	-----	固定器	Slider	2	
10	20131008	-----	线固定套	Spacer	16	
11	30531037	-----	线盘垫	Washer	16	
12	30531036	-----	线托盘	Washer	16	
13	30531076	-----	线架中支架连体组件	Assembly	1	
14	20128018	-----	线盘垫圈	Washer	15	
15	201516004	-----	螺母	Nut	20	
16	20131021	-----	棒架螺钉	Screw	2	
17	20131022	-----	棒架螺钉	Screw	2	
18	30531054	-----	双头螺柱	Screw	2	
19	30531041	-----	线架下支架连杆组件	Assembly	1	
20	30532003	-----	12线线架	Frame	1	6针用
21	30532005	-----	24线线架	Frame	1	12-25针用



二十五、附件部件(3)/Accessories Assemblies (3)

序号 No	件 号 Part No.	参考件号 RefPartNo	名 称	Description	数 量 Num ber	备注 Rem ark
1	30122029	206338	油盘减振垫	Rubber cushion	4	
2	20131028	206336	托盘固定螺母	Nut	4	
3	20131027	4512	托板内六角螺钉	Bolt	4	
4	20131029	KX08	金属垫圈	Washer	8	
5	30122029	KX09	托板减振垫	Rubber cushion	4	
6	30103078	-----	减振垫支撑套	Spacer	4	
7	30122031	-----	减震垫圈	Rubber cushion	4	
8	30531028	-----	附件盒	Accessory Box	1	
9	30532001	VN01	安装板	Rest board	2	
10	301S30018	-----	螺钉	Screw	4	
11	130531002	-----	泡沫箱 (上)	Box	1	泡沫箱组件 13053100100
12	130531003	-----	泡沫箱 (下)	Box	1	
13	30531027	-----	纸箱	Paper Box	1	

标准度量零件表 Standard Measurement Part List

机型MODEL	针距 SYB CLASS	针位 NEEDLE HOLDER	针夹头 NEEDLE CLAMP	针板 NEED PLATE	牙齿 FEED DOG	压脚 PRESSER FOOT	喂针轴 PETAINER HOLDER	弯针架 LOOPER HOLDER	弯针 looper	护针 Needle Guard	针规格 NEEDLE
JK-8009VC-040	64P	1/4 "	30534009	30515009	30514009	30516009	30502034	30504028	30517002	30517001	30517004
	80P	5/16 "	30534018	30515019	30514020	30516021	30502050	30504040	30517002	30517001	30517005
	85P	1/3 "	30534001	30515001	30514001	30516001	30502008	30504008	30517002	30517001	30517005
	95P	3/8 "	30534013	30515013	30514013	30516013	30502032	30504024	30517002	30517001	30517005
JK-8009VC-060	48P	3/16 "	30534012	30515012	30514012	30516012	30502031	30504023	30517002	30517001	30517004
	64P	1/4 "	30534003	30515003	30514003	30516003	30502024	30504016	30517002	30517001	30517004
	80P	5/16 "	30534011	30515011	30514011	30516011	30502030	30504022	30517002	30517001	30517005
	95P	3/8 "	30534022	30515051	30514024	30516025	30502054	30504044	30517002	30517001	30517005
JK-8009VC-080	32P	1/8 "	30534014	30515015	30514015	30516016	30502036	13050400700	130517002	130517001	30517004
	48P	3/16 "	30534020	30515021	30514022	30516023	30502052	30504042	30517002	30517001	30517004
	64P	1/4 "	30534004	30515004	30514004	30516004	30502025	30504017	30517002	30517001	30517004
	85P	1/3 "	30534016	30515017	30514018	30516018	30502037	30504038	30517002	30517001	30517005
JK-8009VC-120	32P	1/8 "	30534017	30515018	30514019	30516020	30502049	13050400700	130517002	130517001	30517004
	48P	3/16 "	30534010	30515010	30514010	30516010	30502035	30504029	30517002	30517001	30517004
	64P	1/4 "	30534002	30515002	30514002	30516002	30502009	30504009	30517002	30517001	30517004
JK-8009VC-130	64-32P	1/4 "-1/8 "	30534005	30515005	30514005	30516005	30502026	13050400700	130517002	130517001	30517004
JK-8009VC-170	32P	1/8 "	30534006	30515006	30514006	30516006	30502027	13050400700	130517002	130517001	30517004
JK-8009VC-180	64	1/4 "	13053400100	130515001	130514001	130516001	130502008	130504012	30517002	30517001	30517004
JK-8009VC-210	48	3/16 "	13053400600	130515004	130514005	13051600700	130502037	130504022	30517002	30517001	30517005
JK-8009VC-230	32P	1/8 "	30534015	30515016	30514017	30516017	30502038	130504005	30517006	130517001	30517004
JK-8009VC-250	32P	1/8 "	30534008	30515008	30514008	30516008	30502029	130504006	30517006	130517001	30517004

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