



中国缝制机械协会理事单位 / 本企业已通过ISO9001管理体系认证
浙江科技型企业 台州著名商标 / ISO14001环境体系认证

JR60/70

超声波缝合机

Ultrasonic lace machine

使用说明·零件手册

INSTRUCTIONS MANUAL&PARTS BOOK

在使用此机器之前，请仔细阅读以下的说明，这样可以更好地帮到您了解此机器的相关操作。

这些说明是根据现行的条例明确阐述了正确的工作方法。

Thank you for purchasing this industrial sewing machine from IMB

Before using this automatic unit, please read the following instructions, which will help you to

understand how the machine operates.

These instructions illustrate the correct working methods to comply with current regulations.

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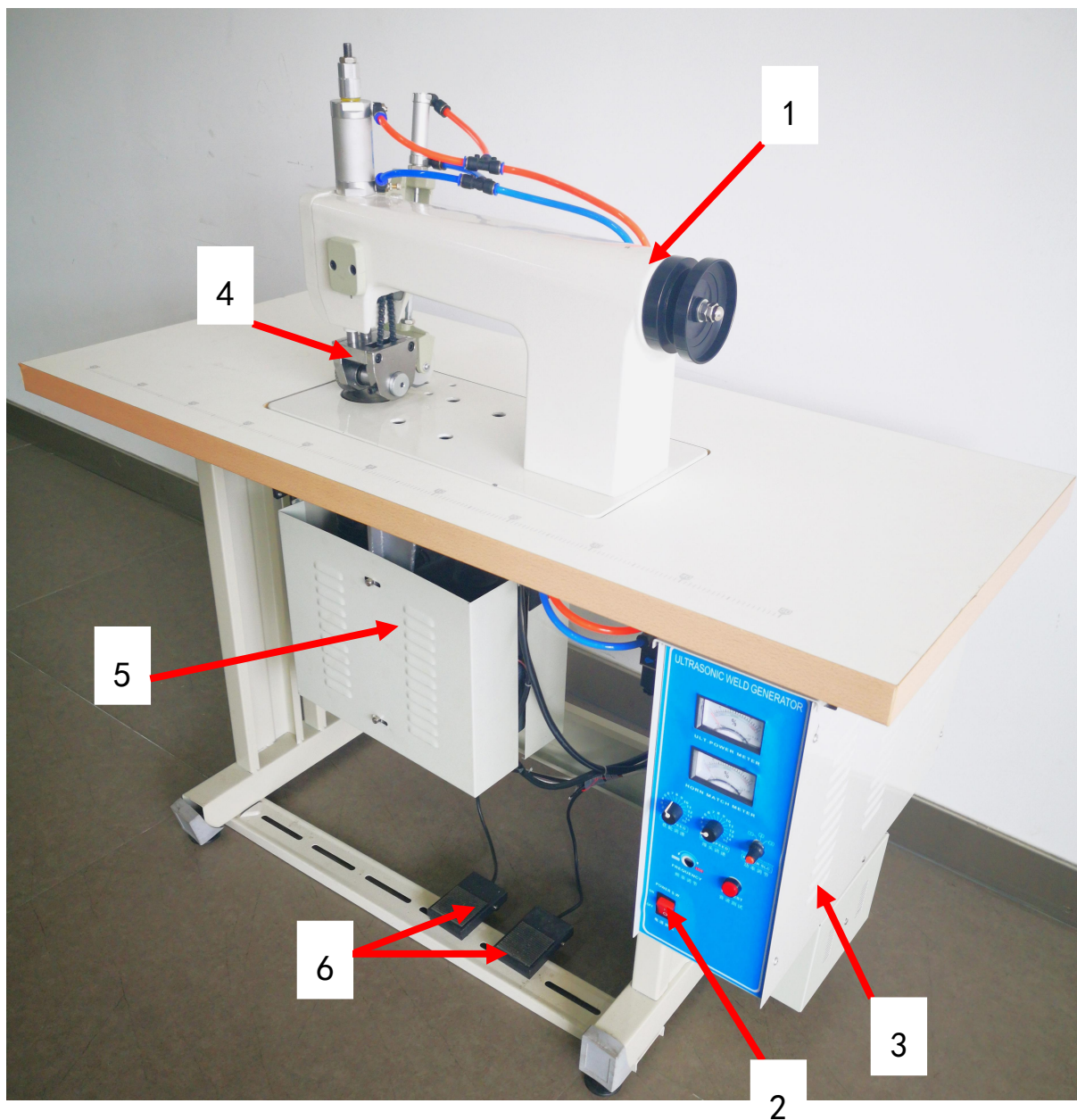
We are happy to receive suggestions and/or indications on ways we could improve this manual.

本机介绍说明分为三部分，具体请参照《JR70S超声波缝合一使用说明书》、《JR70S超声波缝合一零件手册》。

The introduction of this machine is divided into three parts. For details, please refer to 《MB9018B Operation manual》 and 《MB9018B Parts Manual》《MB9018B Touch screen interface operation instructions》

中文

一、设备基本信息



1: IMB 机头;
5: 超声波组件;

2: 电源开关;
6: 脚踏板;

3: 电控箱;



4: 花轮组件;

二、设备技术参数

JR70S 超声波缝合机		
1	机头配置	机头
2	输出电压	0-2000V AC
3	输出功率	0-2000W (功率可调)
4	工作频率	20KHz
5	工作电源	AC220V 50Hz
6	空气压力	0.3MPa
7	自动追频精度	±0.5Hz
8	花轮转速	0-16m/min
9	工作环境温度	+5°C~+50°C
10	外形尺寸	1200mmX500mmX1150mm
11	设备重量	90KG

三、安全注意事项

为了安全地使用自动机的注意事项

 危险	<ol style="list-style-type: none"> 1. 为了防止因触电造成的事故，在接通了电源的状态下，请不要打开马达电气箱的盖子，也不要触摸电气箱内的零件。
 注意	<ol style="list-style-type: none"> 1. 为了防止对人身的伤害，请不要在卸下了皮带护罩、手指防护器等安全装置的状态下运转机器。 2. 为了防止被卷入机器的人身事故，缝纫机运转中，请不要让手指、头发、衣服靠近皮带轮、V 型皮带、马达附近，也不要物品放到上面。 3. 为了防止对人身的伤害，打开电源时或缝纫机运转中，请不要把手指放到机针附近。 4. 为了防止对人身的伤害，缝纫机运转中，请不要把手指放到挑线杆护罩内。 5. 缝纫机运转时，是以高速转动。为了防止伤害到手，运转中请绝对不要让手靠近切布刀。另外，更换机线时，请一定关闭电源。 6. 为了防止对人身的伤害，缝纫机上下动作时或返回原来位置时，请一定注意不要夹到手指。 7. 缝纫机运转中，请不要切断电源或切断空气供给源。 8. 为了防止突然的起动造成的事故，当准备工作完了，达到可以进行缝制的状态时，请卸下布料导向器。 9. 为了防止因触电造成的事故，在卸下电源地线的状态下，请不要运转缝纫机。 10. 为了防止因触电和电气零件损坏造成的事故，插拔电源插头时，请一定先关掉电源开关。 11. 为了防止因电气零件损坏造成的事故，打雷时，为了安全请停止作业，并拔掉电源插头。 12. 为了防止因电气零件损坏造成的事故，从寒冷的地方立即移动到温暖的地方等时会发生结露现象，因此请待水滴万全干燥之后再接通电源。 13. 因为本产品属于精密机器，所以操作时请充分注意，不要把水、油溅到机器上面，也不要让机器掉落给与机器冲击。 14. 本机器是 A 级工业用机器。在家庭环境下使用此机器的话，有可能发生电波干扰的现象。此时，请使用人采取适当的措施解决电波干扰问题。 15. 堆积器动作时关闭了电源开关之后，堆积杆动作，因此请注意不要夹到手指等。 16. 布压脚动作中关闭了电源开关之后，布压脚动作，因此请注意不要夹到手指等。 17. 折边机动作中，把手指放到折边机内时，请注意不要让气缸夹到手指。

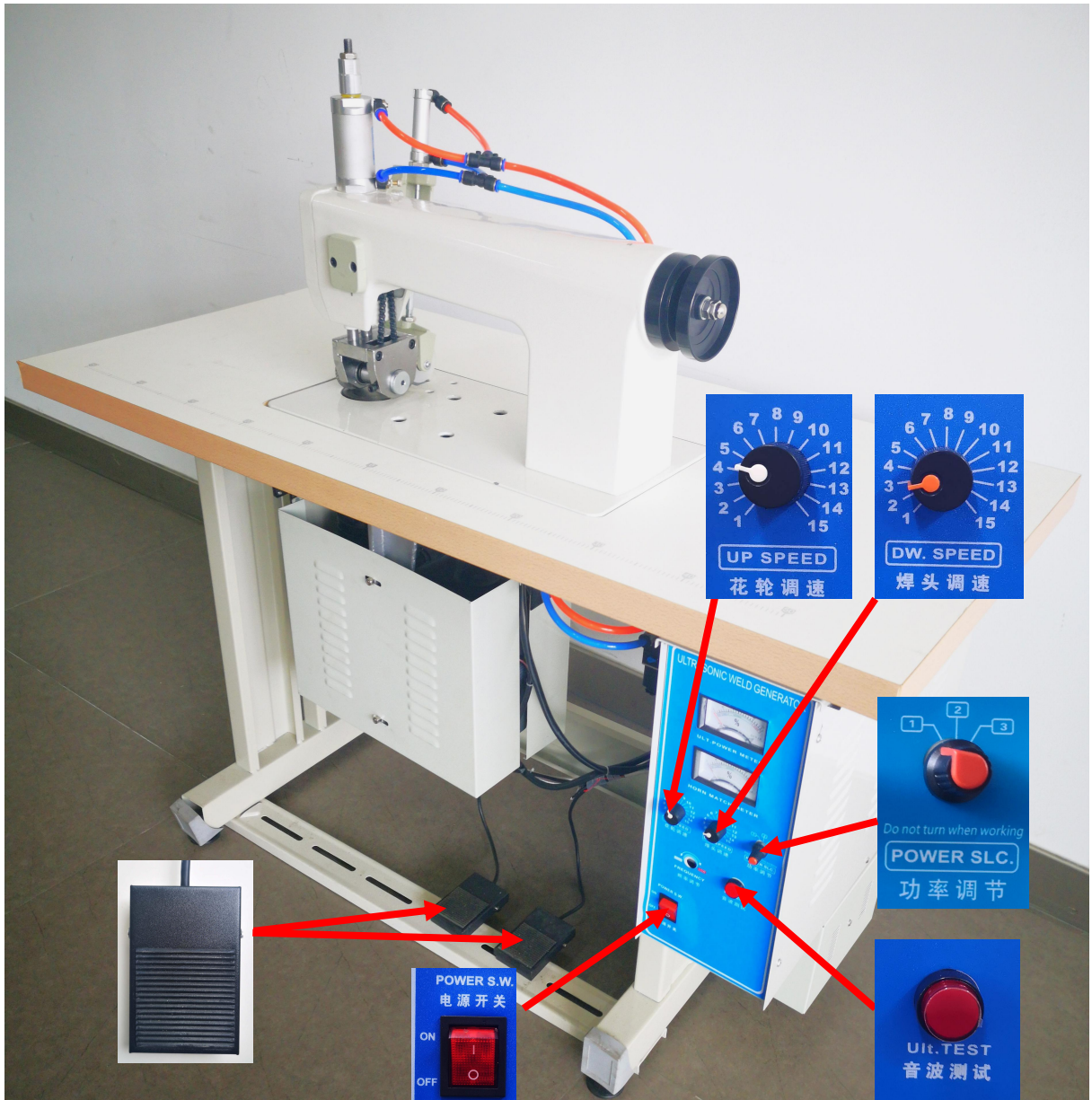
*重要安全信息：

√对机器操作不当可能会导致人身伤害，请在操作前仔细阅读本说明并正确操作。

- √ 机器正式运行通电前，请先通气。
- √ 严禁在通电状态下打开电控箱或触摸屏内部零件。
- √ 本机器需要在接受培训后或专人指导下使用，以确保使用者的人身安全。

四、按键功能说明

4.1 .按钮功能说明



- (1) : 电源开关---按动电源开关至 ON，设备通电、通气。
- (2) : 脚踏开关---左侧脚踏板控制压轮和花轮升降，右侧脚踏板控制花轮和焊头旋转。
- (3) : 花轮调速旋钮---左右旋转花轮调速旋钮，调节花轮转速。
- (4) : 焊头调速旋钮---左右旋转焊头调速旋钮，调节焊头转速。
- (5) : 音波测试按钮---切换超声短波和长波模式。
- (6) : 功率调节旋钮---调节超声波的功率。

五、操作说明

5.1. 操作前准备工作

- ✓ 操作人员检查时机头需处于停止状态
- ✓ 清理机器台面上的杂物，确保机器运行过程中不会有杂物阻碍运行
- ✓ 检查气压表压力，使其符合机器使用要求

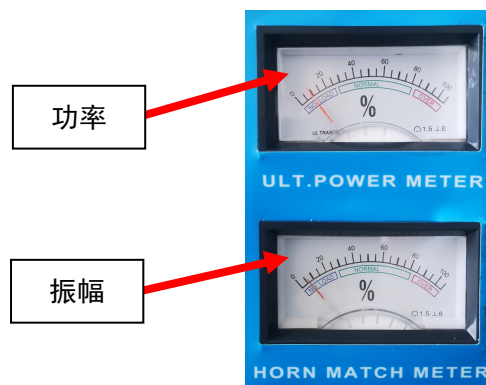
5.2. 操作过程说明

5.2.1 启动设备



按动 4. 4-(1) 电源开关至 ON 位置，设备通电开机。

5.2.2 超声波检测



踩 4.1-（2）中的左侧脚踏板抬起花轮，空载状态按下音波测试按钮，振幅在 10%以内，功率在 15%以内，机器正常

5.2.3 缝合

将布片放至缝合区域，踩下 4.1-（2）中的右侧脚踏板，机器开始缝合，松开脚踏板机器停止运行。

5.2.4 关机

操作完毕，按动电源开关至 OFF 位置，设备关机。

六、调试方法

6.1. 花轮速度调节



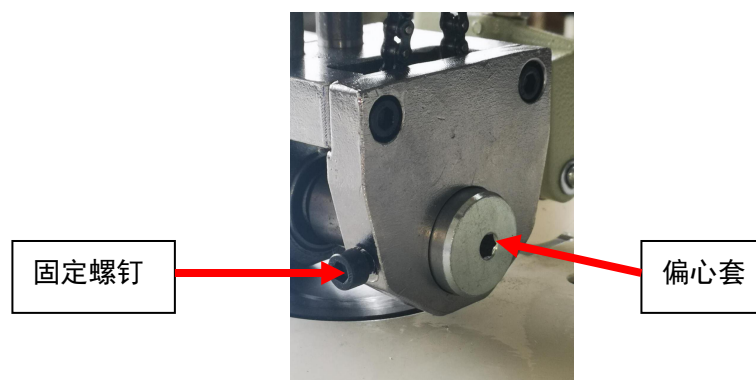
左旋花轮调速旋钮降低花轮转速，右旋花轮调速旋钮提高花轮转速。

6.2. 焊头速度调节



左旋焊头调速旋钮降低焊头转速，右旋焊头调速旋钮提高焊头转速。

6.3. 花轮角度调节



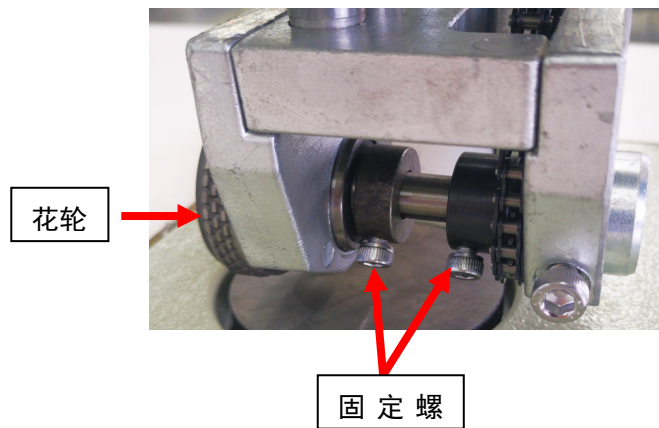
松开固定螺钉，旋转偏心套，可以调节花轮与焊头的角度，保证花轮的每一道压边厚度均等。

6.4. 花轮压痕深度调节



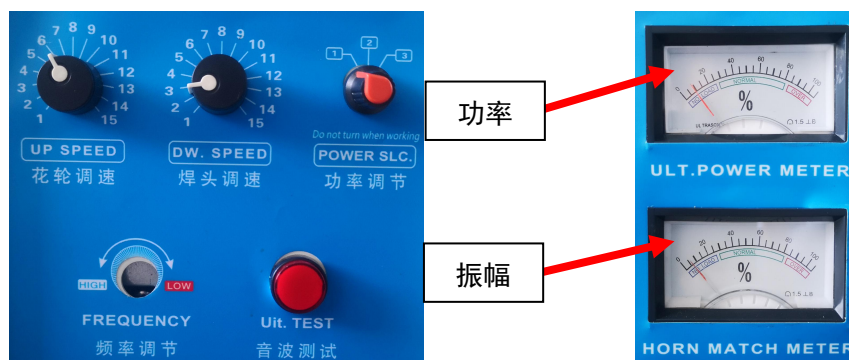
松开固定螺母，旋转限位套，调节气缸行程，改变花轮压痕深度。

6.5. 更换模具



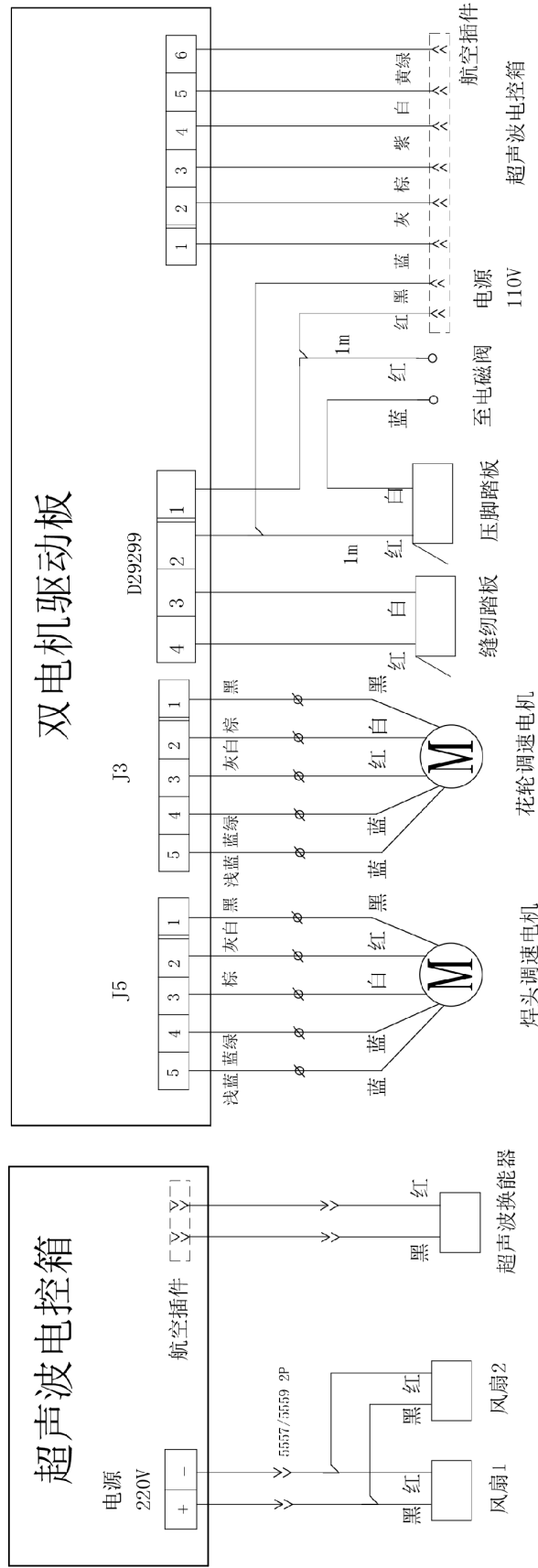
- 1) 拆卸两颗固定螺钉，抽出花轮；
- 2) 将要更换的新花轮穿进轴承，拧紧两颗固定螺钉；
- 3) 根据 6.3 步骤调节花轮角度，模具更换完成。

6.6. 超声波调节



当振幅大于 10% 时，用十字螺丝刀旋转频率调节旋钮 ，无固定方向，需要左右旋转寻找中心点，调至振幅小于 10%，功率小于 15%。

七、电气配线



八、选配装置

花轮花型支持定制

九、附件箱明细

序号	附件名称	规格	数量
1	电源线		1
2	《JR70S超声波缝合机零件手册》		1
3	《JR70S超声波缝合机使用说明书》		1

十、常见问题及解决方法

10.1. 常见问题及解决方法详见下表

现象	原因分析	解决措施
花轮压边左右不均匀	花轮与焊头不垂直	按照 6.3 步骤调节花轮角度
花轮压痕浅或深	气缸行程小或大	按照 6.4 步骤调节气缸行程

十一、日常保养要求

11.1. 设备保养清单及要求详见下表

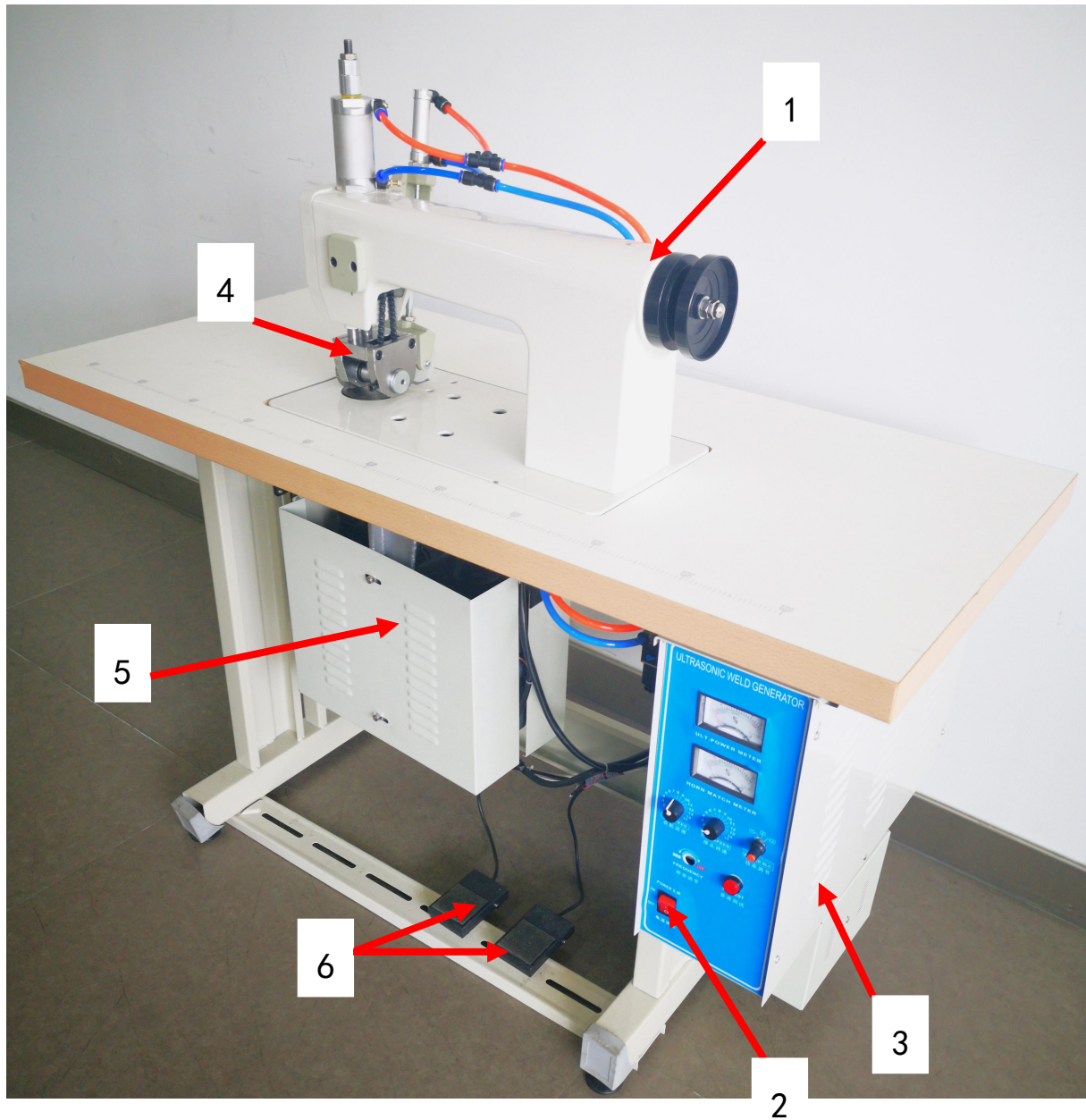
序号	项目	时间				要点描述
		每天	每周	每月	半年	
1	清理灰尘	√				清除设备表面及零部件灰尘
2	清理油污		√			清理台板油污
8	气管接口			√		气管接口紧密, 不漏气
13	滑动件				√	检查滑动件润滑, 如有需要则添加润滑剂
14	电控箱				√	散热风扇运转正常, 及时清理灰尘

ENGLISH

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1、 MACHINE PARTS DEMO



1: Machine head;

2: Power switch;

3: Control box;

4: Pattern roller assy;

5: Ultrasonic assy;



6: Pedal;

2、 Technical parameters of the equipment

JR70S Ultrasonic lace machine (single motor)		
1	Machine head	
2	Voltage	0-2000V AC
3	Power	0-2000W (adjustable)
4	Frequency	20KHz
5	Power Supply	AC220V 50Hz
6	Pressure	0.3MPa
7	Frequency tracking	± 0.5 Hz
8	Speed	0-16m/min
9	Temperature	+5°C~+50°C
10	Size	1200mmX500mmX1150mm
11	Weight	90KG

3、 Safety precautions

Considerations for safe use of automata

 危険	<p>1. In order to prevent accidents caused by electric shock, please do not open the cover of the electrical box of the motor or touch the parts in the electrical box when the power is connected.</p>
 注意	<p>1. In order to prevent personal injury, please do not operate the machine in the state of removing the belt guard, finger protector and other safety devices.</p> <p>2. In order to avoid being involved in the machine's personal accident, please do not let your fingers, hair, clothes near the pulley, v-belt, motor, and do not put items on it during the operation of the sewing machine.</p> <p>3. To prevent personal injury, please do not put your finger near the needle when turning on the power or running the machine.</p> <p>4. In order to prevent personal injury, please do not put your fingers in the wire pole guard during the operation of the sewing machine.</p> <p>5. When the machine is running, it turns at a high speed. To prevent damage to the hand, never let the hand near the cutter during operation. In addition, when changing the cable, please be sure to turn off the power.</p> <p>6. In order to prevent personal injury, please be careful not to pinch your fingers when the machine moves up and down or when you return to the original position.</p> <p>7. Please do not cut off the power or air supply while the machine is running.</p> <p>8. In order to prevent accidents caused by sudden starting, please remove the cloth guide when the preparation work is finished and the sewing state is reached.</p> <p>9. In order to prevent accidents caused by electric shock, please do not operate the sewing machine when the ground wire of the power supply is removed.</p> <p>10. In order to prevent accidents caused by electric shock and damage to electrical parts, be sure to turn off the power switch before inserting or unplugging the power plug.</p> <p>11. In order to prevent accidents caused by damage of electrical parts, please stop the operation for safety when it thunders and pull the power plug.</p> <p>12. In order to prevent accidents caused by damage to electrical parts, condensation will occur when moving from a cold place to a warm place immediately, so please wait until the water drops dry before switching on the power.</p> <p>13. As this product is a precision machine, please pay full attention to it during operation, do not splash water or oil on the machine, and do not let the machine fall and give the machine impact.</p> <p>This machine is A class A industrial machine. The use of this machine in the home environment may cause the phenomenon of radio interference. At this point, please take appropriate measures to solve the problem of radio interference.</p> <p>15. After the power switch is turned off when the accumulator moves, the accumulator lever moves, so please be careful not to clip your finger, etc.</p> <p>16. When the power switch is turned off during the foot press action, please</p>

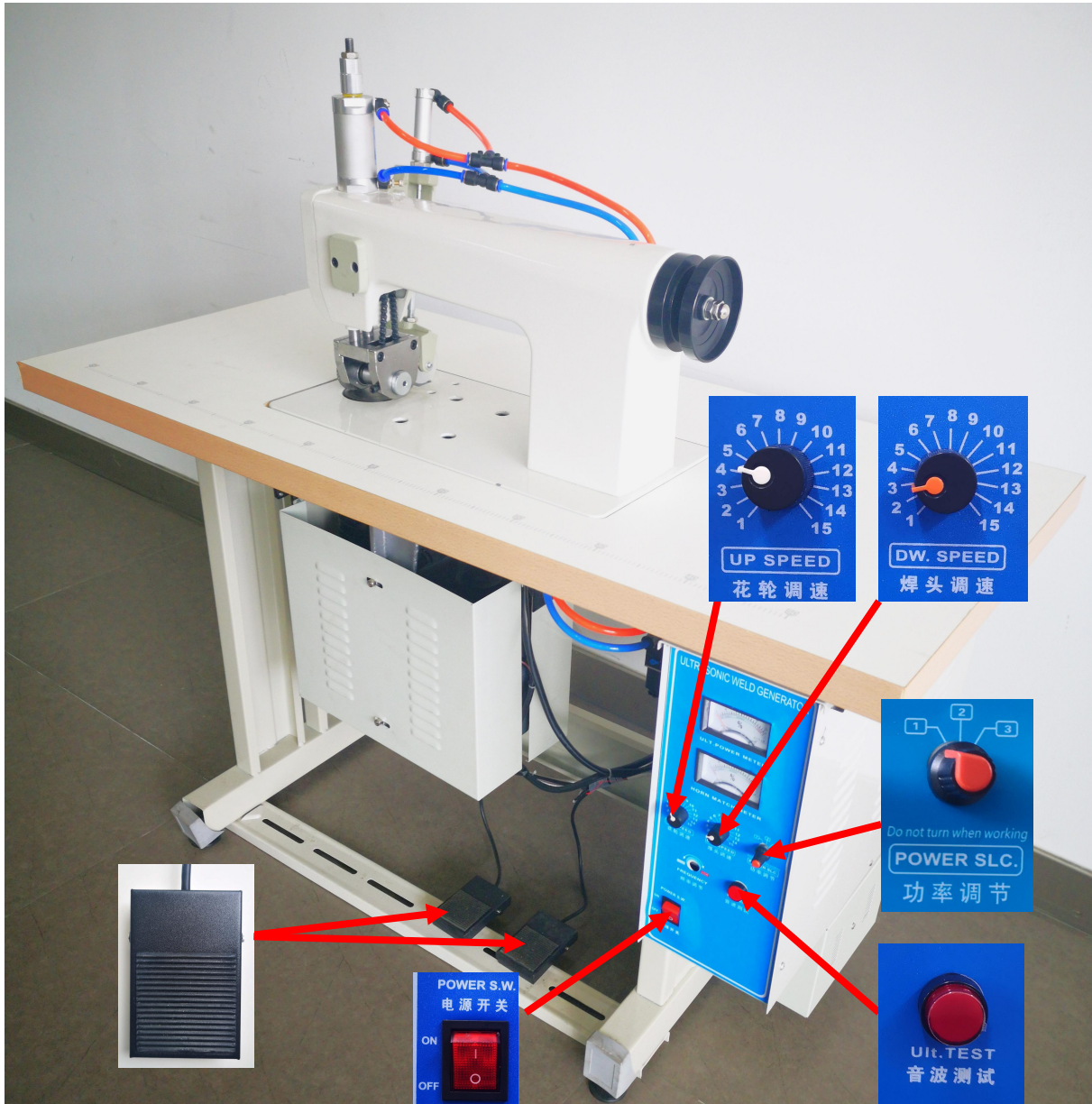
	<p>be careful not to pinch your fingers.</p> <p>17. During folding operation, please be careful not to clip the cylinder to your finger when putting your finger into the folding machine.</p>
--	--

*** important safety information:**

- ✓ improper operation of the machine may cause personal injury. Please read this instruction carefully and operate correctly before operation.
- ✓ Please ventilate the machine before it is officially powered on.
- ✓ do not turn on the internal parts of the electric cabinet or touch screen while the power is on.
- ✓ this machine should be used after receiving training or under special instruction to ensure the safety of the user.

4、 Key function description

4.1 . Function description of the button



1) : Power switch: press the power switch to on, and the equipment is powered on and ventilated.

(2) : Pedal:the left foot pedal controls the lifting of the pressing wheel and the flower wheel, and the right foot pedal controls the rotation of the flower wheel and the welding head.

(3) : Flower wheel speed control knob: rotate the flower wheel speed control knob left and right to adjust the rotation speed of the flower wheel

(4) : Welding head speed control knob: rotate the welding head speed control knob left and right to adjust the welding head speed.

(5) : Sound wave test button – switch between ultrasonic short wave and long wave modes.

(6) : Power adjustment knob – adjust the power of ultrasonic.

5、 Operating instructions

5.1. Preparation before operation

- ✓ The machine head shall be in the stop state when the operator checks it
- ✓ Clean the sundries on the machine table to ensure that there are no sundries hindering the operation of the machine
- ✓ Check the pressure of the air pressure gauge to make it meet the use requirements of the machine

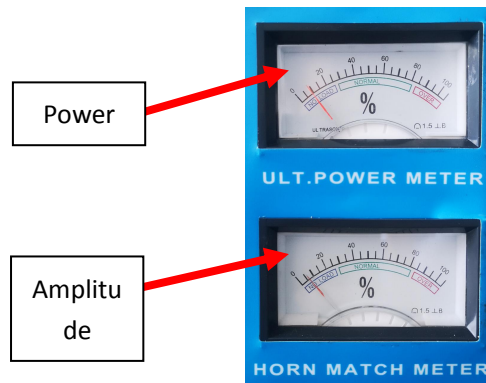
5.2. Operation process description

5.2.1 Boot device



Press 4.1-(1) power switch to ON, Power on the device.

5.2.2 Ultrasonic testing



step on Four point one -(2) The left foot pedal in the middle raises the flower wheel, press the sound wave test button under no-load state, the amplitude is within 10%, the power is within 15%, and the machine is normal,

5.2.3 Sewing

Place the cloth piece in the sewing area and press Four point one -(2) The right foot pedal in, the machine starts to sew, release the foot pedal and the machine stops.

5.2.4 Shutdown

After operation, press the power switch to the off position, and the equipment will be shut down.

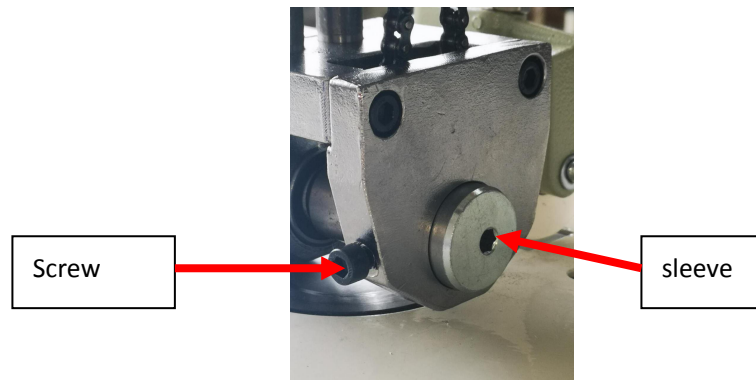
6、 Debugging method

6.1. Wheel speed adjustment



Turn the left wheel speed control knob to reduce the rotation speed of the wheel, and turn the right wheel speed control knob to increase the rotation speed of the wheel.

6.2. Flower wheel angle adjustment



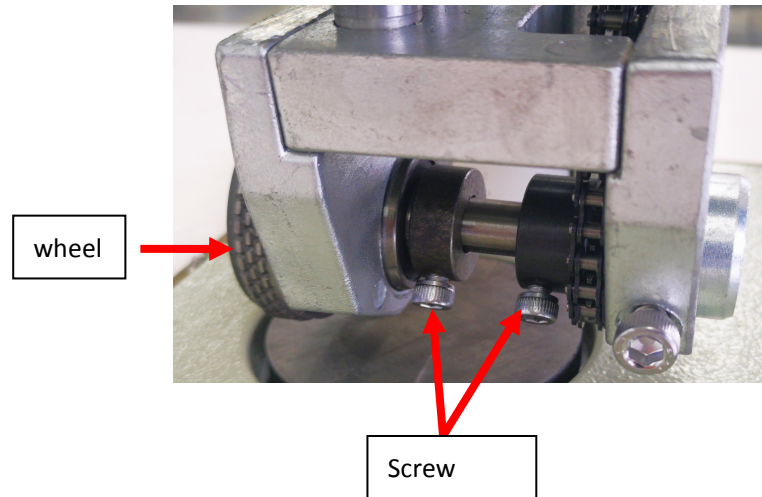
Loosen the fixing screw and rotate the eccentric sleeve to adjust the angle between the flower wheel and the welding head, so as to ensure that the thickness of each pressing edge of the flower wheel is equal.

6.3. Adjustment of depth of flower wheel indentation



Loosen the fixing nut, rotate the limit sleeve, adjust the stroke of the cylinder, and change the indentation depth of the flower wheel.

6.4. Mold replacement



- 4) Remove the two fixing screws and take out the flower wheel;
- 5) Insert the new flower wheel to be replaced into the bearing and tighten the two fixing screws;
- 6) According to Six point two Step to adjust the angle of the flower wheel and complete the mold replacement.

6.5. Ultrasonic adjustment

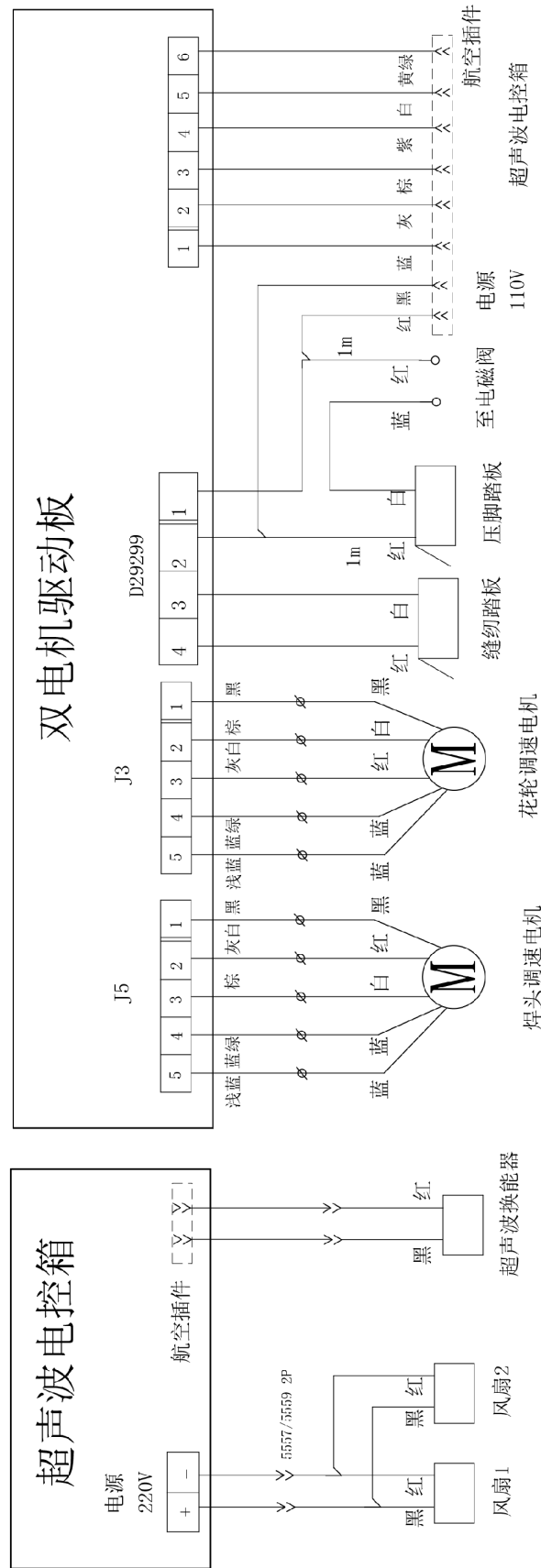


When the amplitude is greater than 10%, turn the frequency adjusting knob with a cross



screwdriver. There is no fixed direction. It needs to rotate left and right to find the center point. Adjust the amplitude to less than 10% and the power to less than 15%

7、Electrical wiring



8、 Optional device

Support customization of flower wheel and pattern

9、 Common problems and Solutions

9.1. See the table below for common problems and Solutions

Phenomenon	Cause analysis	Solutions
Uneven left and right edge pressing of flower wheel	The flower wheel is not vertical to the welding head	according to Six point two Step to adjust the flower wheel angle
Shallow or deep impression of flower wheel	Small or large cylinder stroke	according to Six point three Step adjust cylinder stroke

10、 Daily maintenance requirements

10.1. See the following table for the list and requirements of equipment maintenance

NO	Project	Frequency				Requirement
		Daily	Weekly	Monthly	Half year	
1	Dust removal	√				Remove dust from equipment surface and parts
2	Clean up oil		√			Clean the oil stain on the platform
8	Air pipe interface			√		The air pipe interface is tight without air leakage
13	Slide				√	Check the lubrication of sliding parts and add lubricant if necessary
14	Electric control box				√	Cooling fan operates normally, clean dust in time

11、 Knowledge product protection statement

JR70S trasonic lace machine (double motor) was designed by Changzhou wisdom & valley Electric Technology Co., Ltd. The intellectual property rights of this achievement belong to Changzhou wisdom & valley Electric Technology Co., Ltd. and are protected by national intellectual property laws and regulations. Without the written permission of the right holder, the patented technology of the achievement shall not be implemented, and the information related to the achievement shall not be copied, sold or disseminated through the network. For any illegal infringement, Changzhou wisdom & valley Electric Technology Co., Ltd. will pursue its legal responsibility according to law.

12、 Knowledge product protection statement

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浙江科技型企业 台州著名商标 / ISO14001环境体系认证

JR70S

超声波缝合机

Ultrasonic lace machine

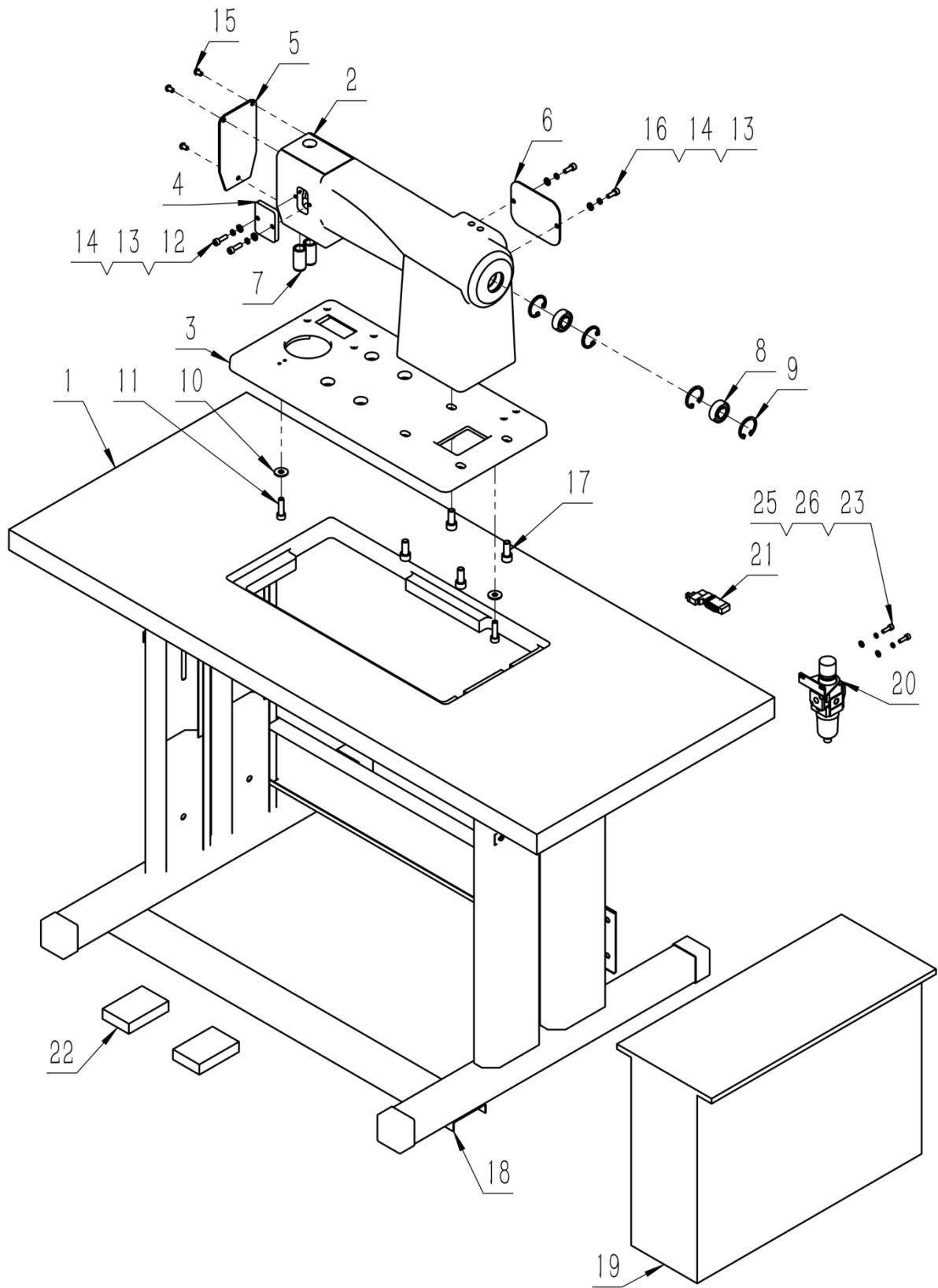
零件手册

PARTS BOOK

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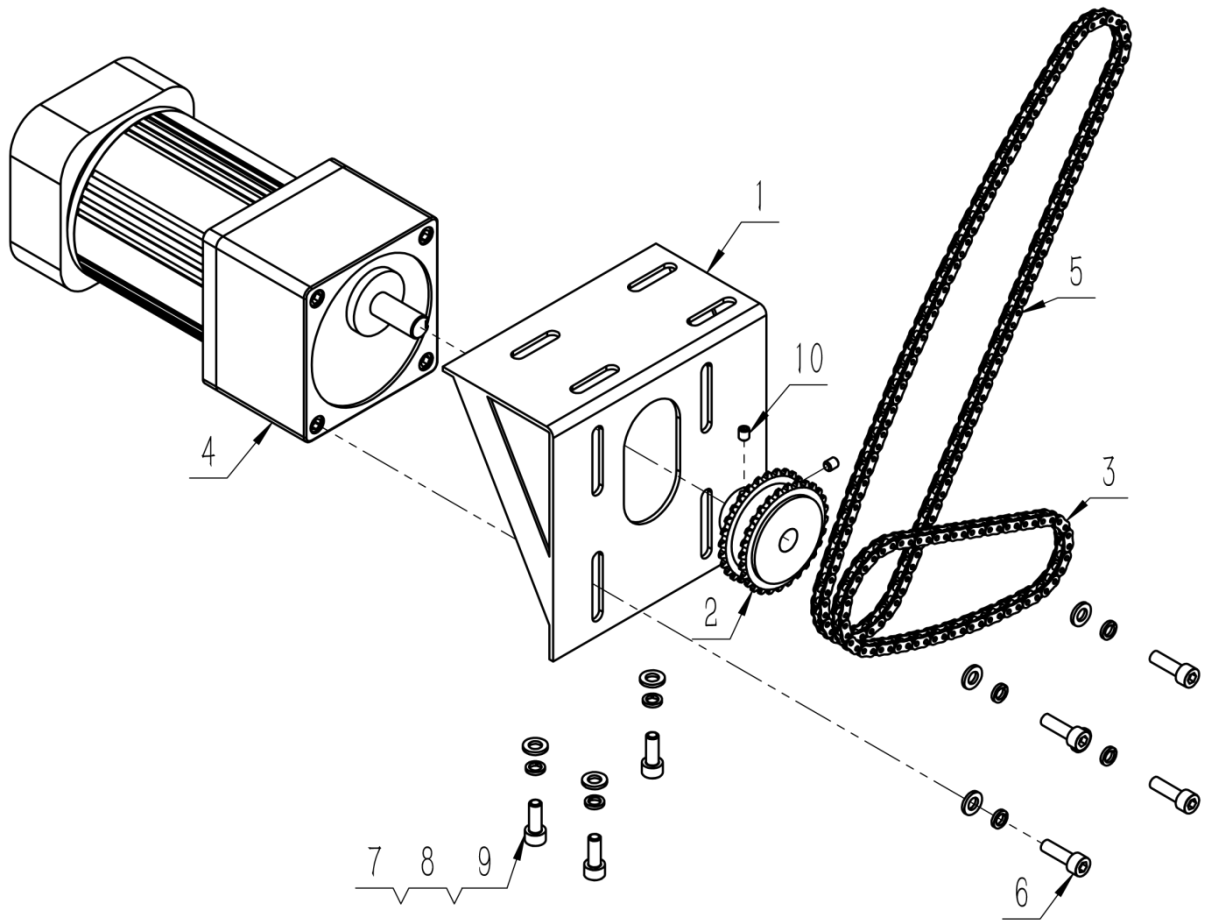
1、机架组件



1、机架组件

序号/No.	图号/Parts No.	名称/Description	数量/Qty
1	50901012	台板	1
2	50901062	机壳	1
3	50901063	底板	1
4	50901069	张紧压板	1
5	50901067	前盖	1
6	5001068	视窗盖	1
7	50901013	导杆套	2
8	509B02011	深沟球轴承 6202-2Z	2
9		孔用弹性挡圈 A 型 35	4
10	418W04037	大垫圈 8	2
11	418S02094	内六角圆柱头螺钉 M8×30	2
12	418S02104	内六角圆柱头螺钉 M6×20	2
13	418W04017	平垫圈 C 级 6×1.6	4
14	418W04037	标准型弹性垫圈(装配)6×1.6	4
15	416S03026	内六角平圆头螺钉 M6×10	3
16	418S04010	内六角圆柱头螺钉 M6×16	2
17	41007031	内六角圆柱头螺钉 M10×25	4
18	50901012-1	机架	1
19	50901064	超声波电控箱	1
20	50902037	过滤减压阀 AW20-01	1
21	50703033	电磁阀	1
22	50902007	脚踏板	2
23	418S02090	内六角圆柱头螺钉 M5×16	2
24	419N06069	1 型六角螺母 C 级 M5	2
25	418W04017	平垫圈 C 级 5×1	2
26	418W04037	标准型弹性垫圈(装配)5×1.3	2

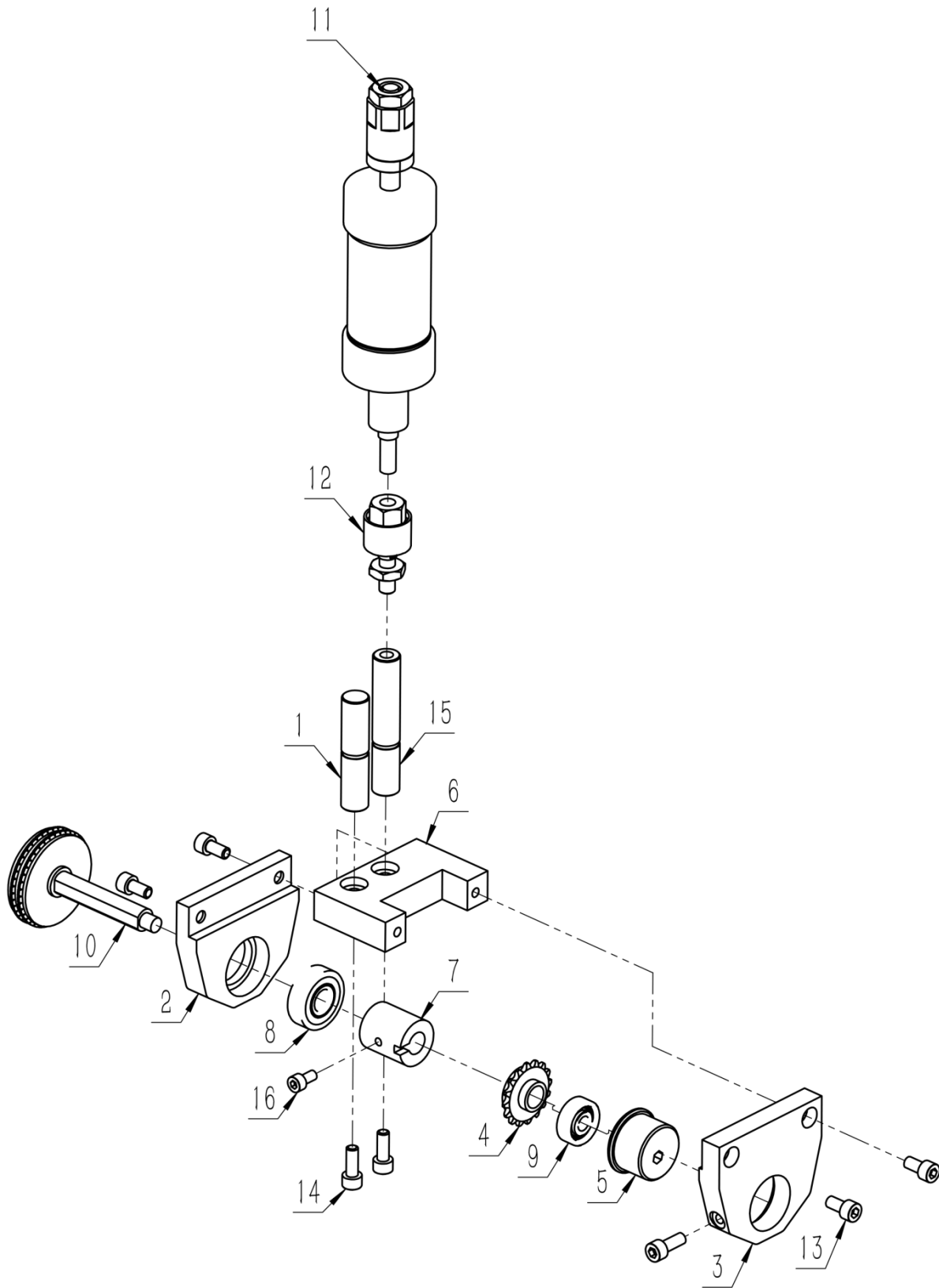
2、主电机组件



2、主电机组件

序号/No.	图号/Parts No.	名称/Description	数量/Qty
1	50901008	主电机座	1
2	50902020	单排链轮 04C-28	1
3	50702007	链条 04C 节距 6.35 节数 58	1
4	50902043	调速电机	1
5	50702007	主链 04C 节距 6.35 节数 112	1
6	418S02104	内六角圆柱头螺钉 M6×20	4
7	418W04017	平垫圈 C 级 6×1.6	7
8	418W04037	标准型弹性垫圈(装配)6×1.6	7
9	418S04010	内六角圆柱头螺钉 M6×16	3
10	418S02090	内六角平端紧定螺钉 M5×6	2

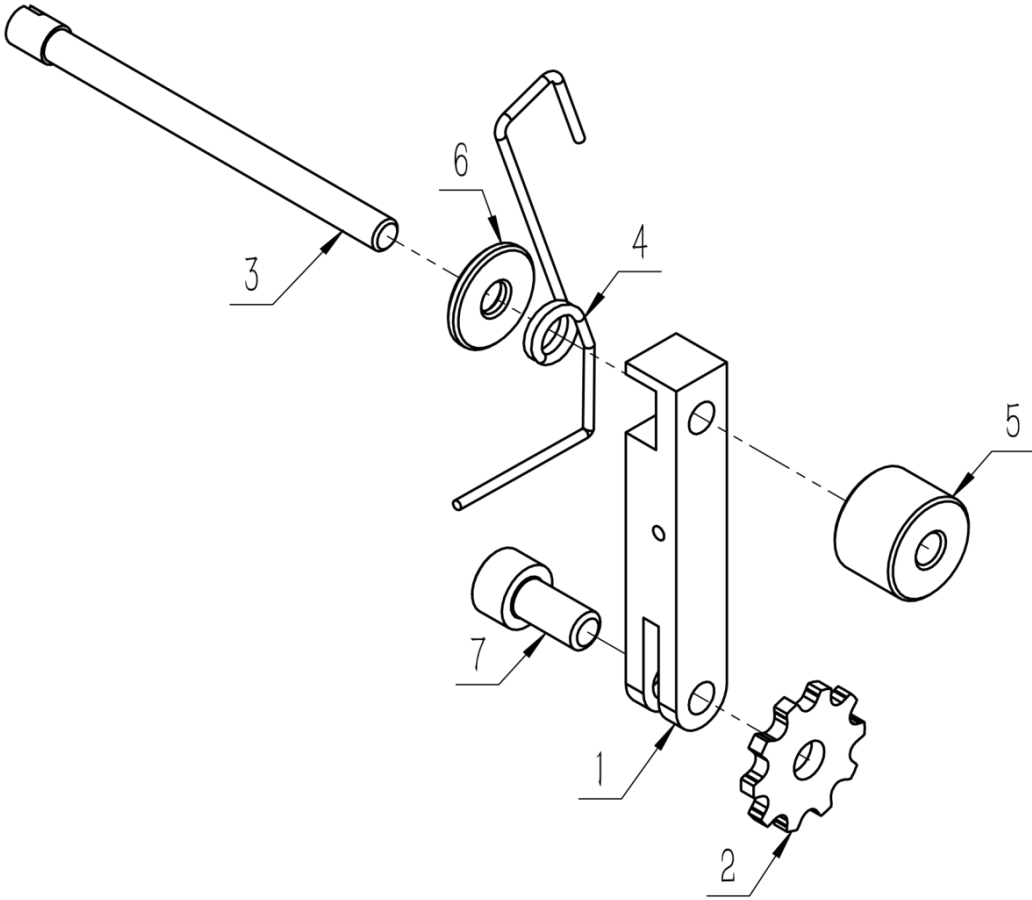
3、花轮组件



3、花轮组件

序号/No.	图号/Parts No.	名称/Description	数量/Qty
1	50901006	导向轴	1
2	50901042	花轮固定法兰	1
3	50901043	花轮调节法兰	1
4	50902018	花辊链轮	1
5	50901056	偏心套	1
6	50901041	导柱连板	1
7	50901053	隔套	1
8	509B02025	深沟球轴承 6201-2Z	1
9	509B02014	深沟球轴承 628-2Z	1
10	50902001	花轮	1
11	50902036	压脚气缸 MALJ40X15-15	1
12	50901005	浮动接头 F-1008-FJ	1
13	416S03026	内六角圆柱头螺钉 M6×12	4
14	418S04010	内六角圆柱头螺钉 M6×16	3
15	50901007	导向连接轴 2	1
16	418S02090	内六角圆柱头螺钉 M5×10	1

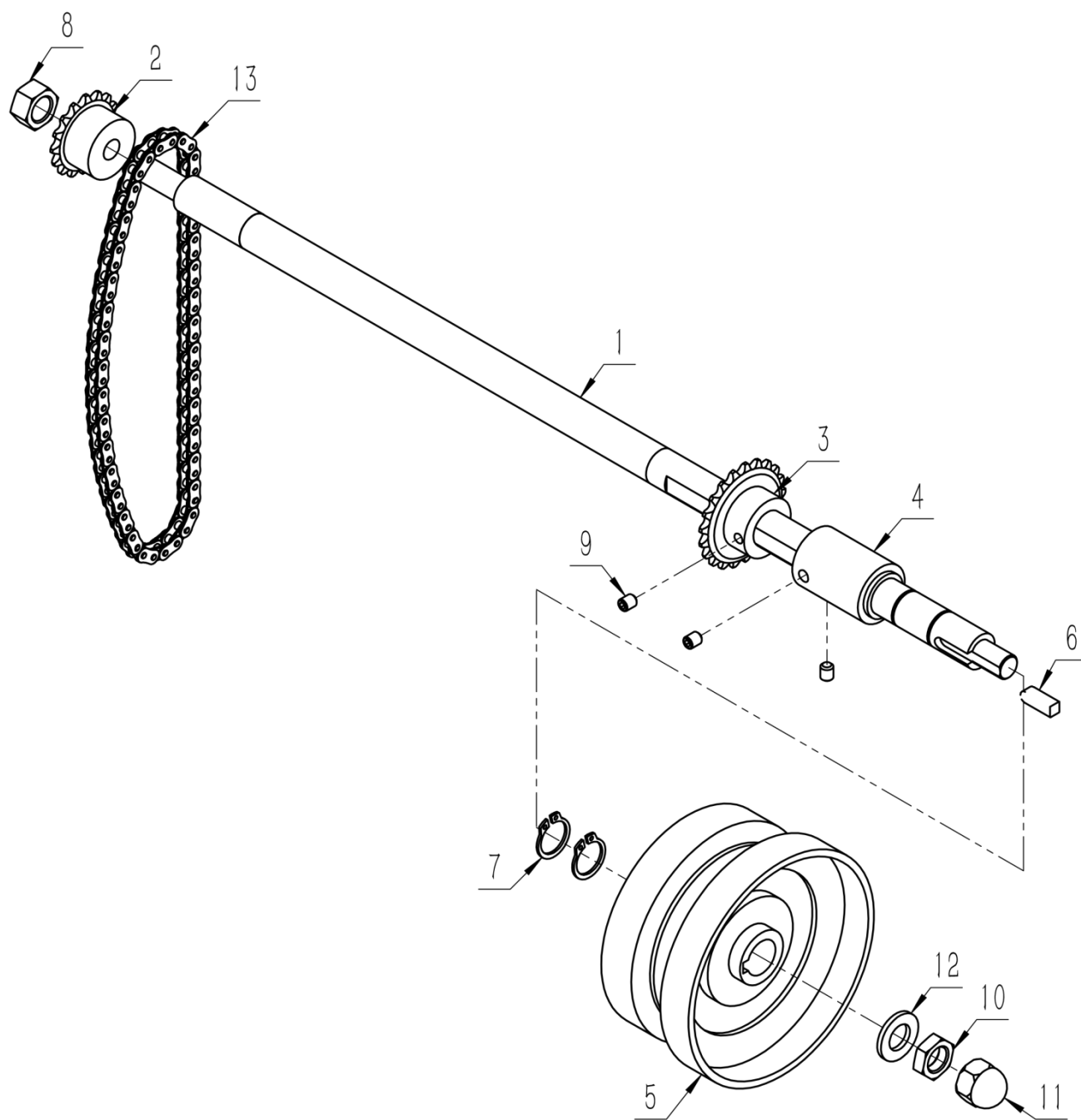
4、张紧组件



4、张紧组件

序号/No.	图号/Parts No.	名称/Description	数量/Qty
1	50902003	张紧杆	1
2	50902002	从动链轮	1
3	50901014	涨紧销	1
4	50901044	弹簧	1
5	50902002-1	尼龙短隔套	1
6	50902002-2	尼龙长隔套	1
7	416S03026	内六角圆柱头螺钉 M6×12	1

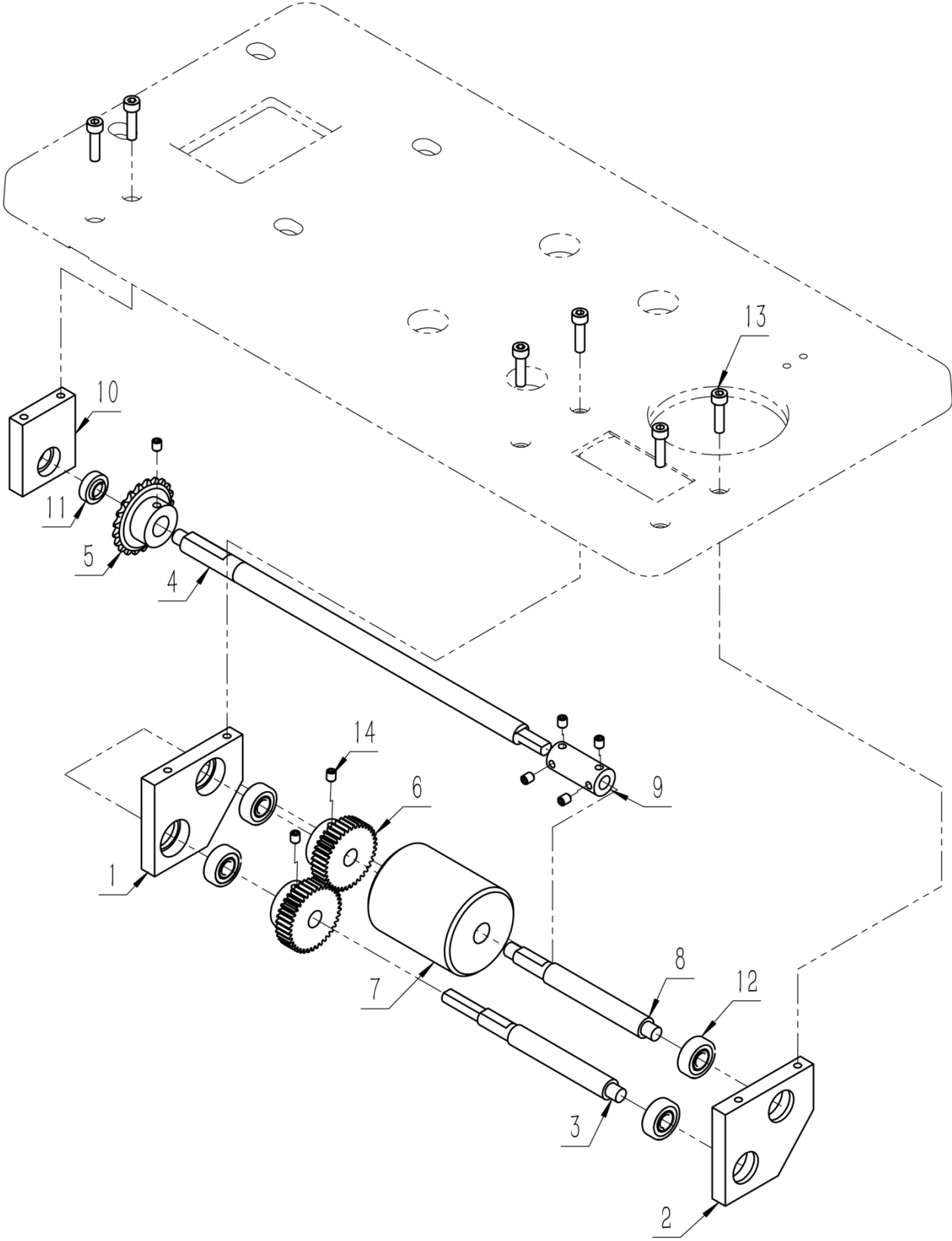
5、主传动组件



5、主传动组件

序号/No.	图号/Parts No.	名称/Description	数量/Qty
1	50901020	芯轴	1
2	50902018	芯轴头链轮	1
3	50902020	芯轴传动链轮	1
4	50901020-1	主轴限位套	1
5	301718002	手轮	1
6		普通平键 C 型键 C5×5×16]	1
7		轴用弹性挡圈 A 型 φ 15	2
8	41012006	反牙螺母 M10	1
9	419S10005	内六角平端紧定螺钉 M5×6	3
10	41012066	六角薄螺母 M10	1
11	41012066	盖形螺母 M10	1
12	41002023	平垫圈 C 级 10×2	1
13	50702007	链条 04C 节距 6.35 节数 70	1

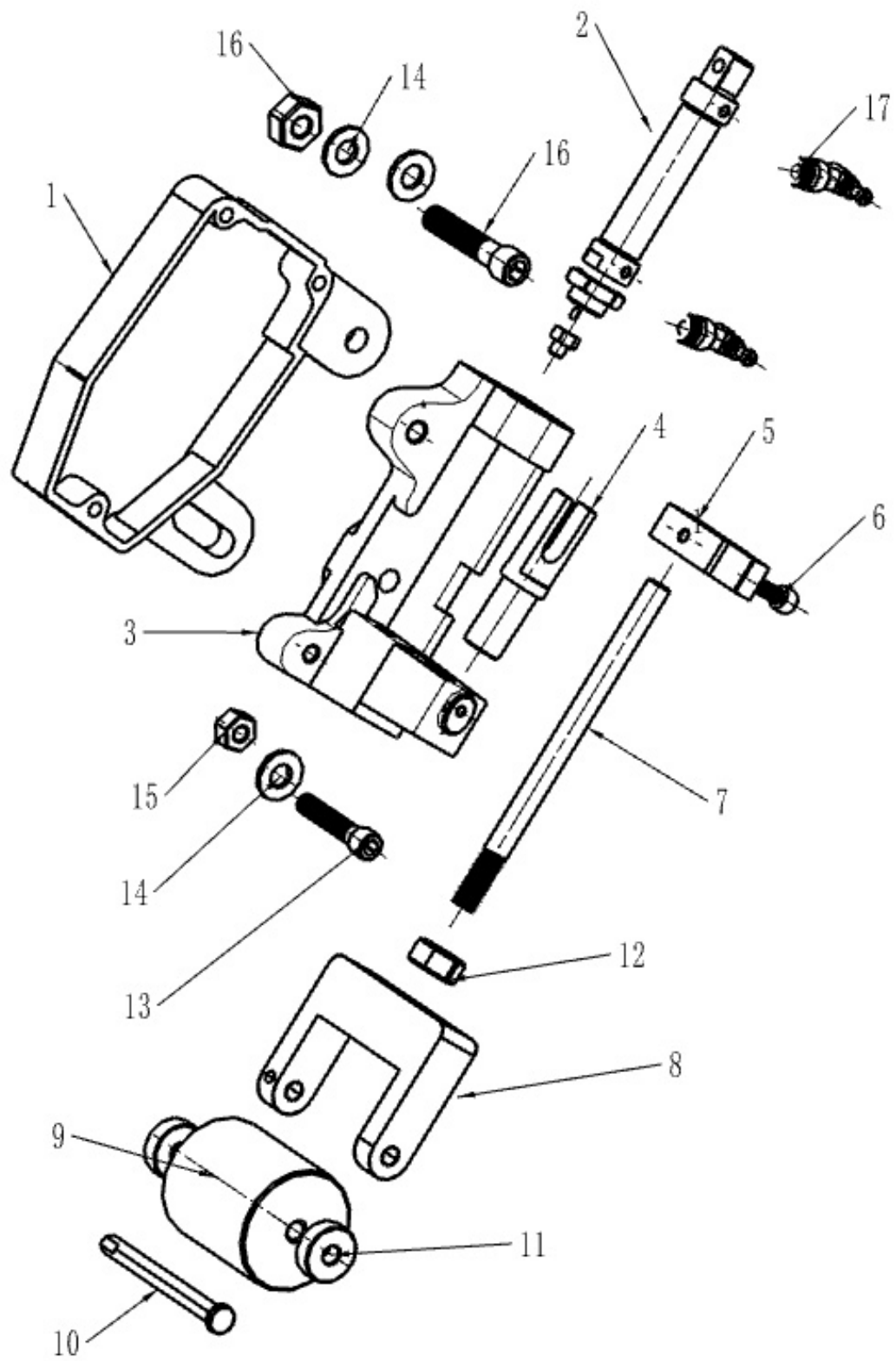
6、输送辊组件



6、输送辊组件

序号/No.	图号/Parts No.	名称/Description	数量/Qty
1	50901045	送料左连片	1
2	50901046	送料右连片	1
3	50901050	传动轴	1
4	50901049	下链轴	1
5	50902020	辊传动链轮	1
6	50901061	辊连齿轮	2
7	50902041	尼龙辊	1
8	50902041-1	辊轴	1
9	50901051	联轴器	1
10	50901048	端头固定座	1
11	50902035	轴承 UC8	1
12	509B02012	深沟球轴承 608-2Z	4
13	418S02090	内六角圆柱头螺钉 M5×20	6
14	419S10005	内六角平端紧定螺钉 M5×6	7

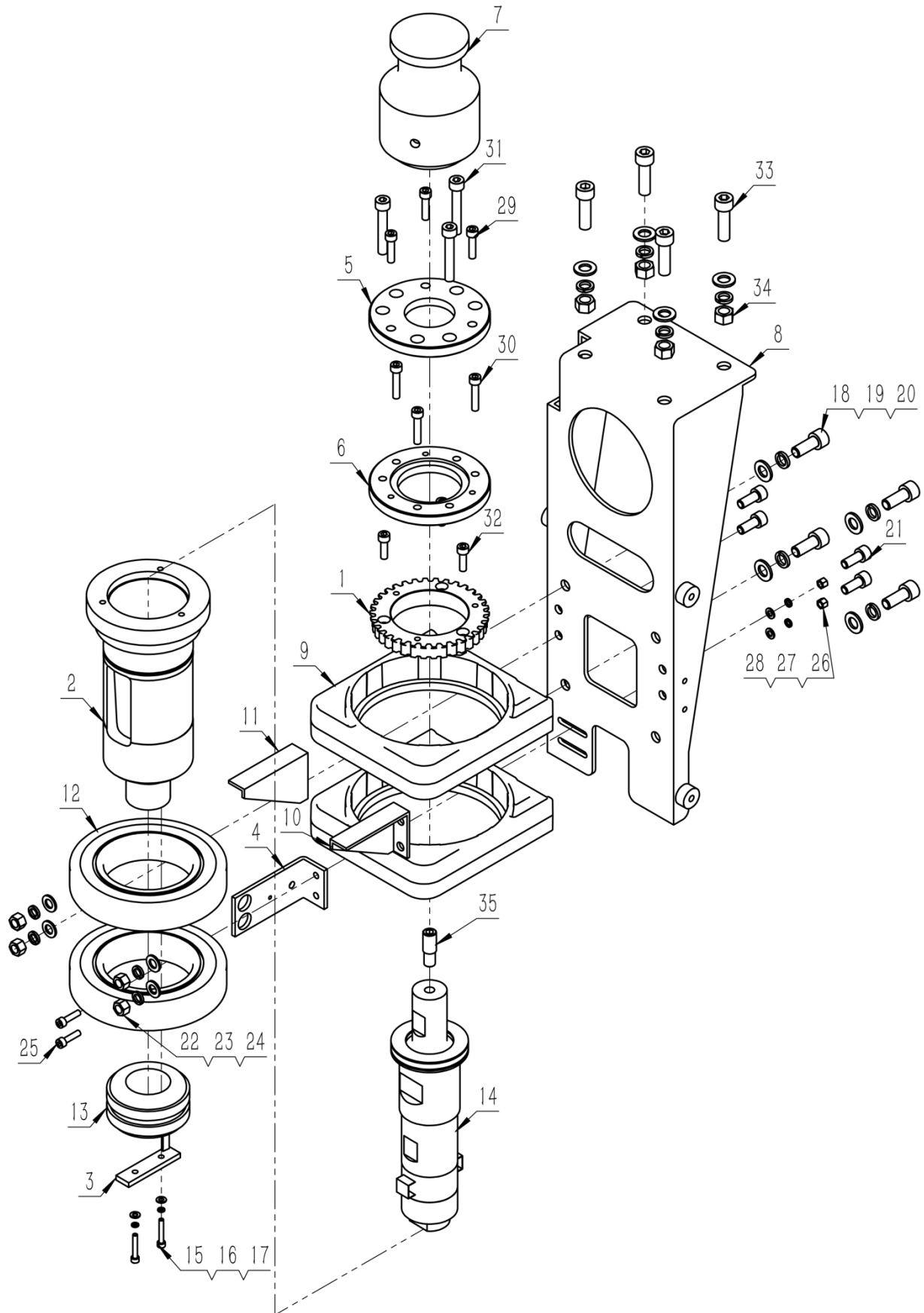
7、压辊组件



7、压辊组件

序号/No.	图号/Parts No.	名称/Description	数量/Qty
1	50901067	面板	1
2	50902044	拖轮气缸	1
3	50901070	气缸座	1
4	50901017	鱼叉	1
5	50901018	拖轮导架	1
6	418S04010	M6螺丝	1
7	50901052	拖布轮轴	1
8	50901047	拖布轮架	1
9	50902040	拖布轮	1
10	50901054	拖轮销	1
11	509B02014	轴承G28	2
12	41012066	M10螺母	1
13	418S04022	M8螺丝	1
14		垫片	3
15	418N04001	M8螺母	1
16	28080246	M10螺丝	1
17	50902032	气管接头	2
18			
19			
20			

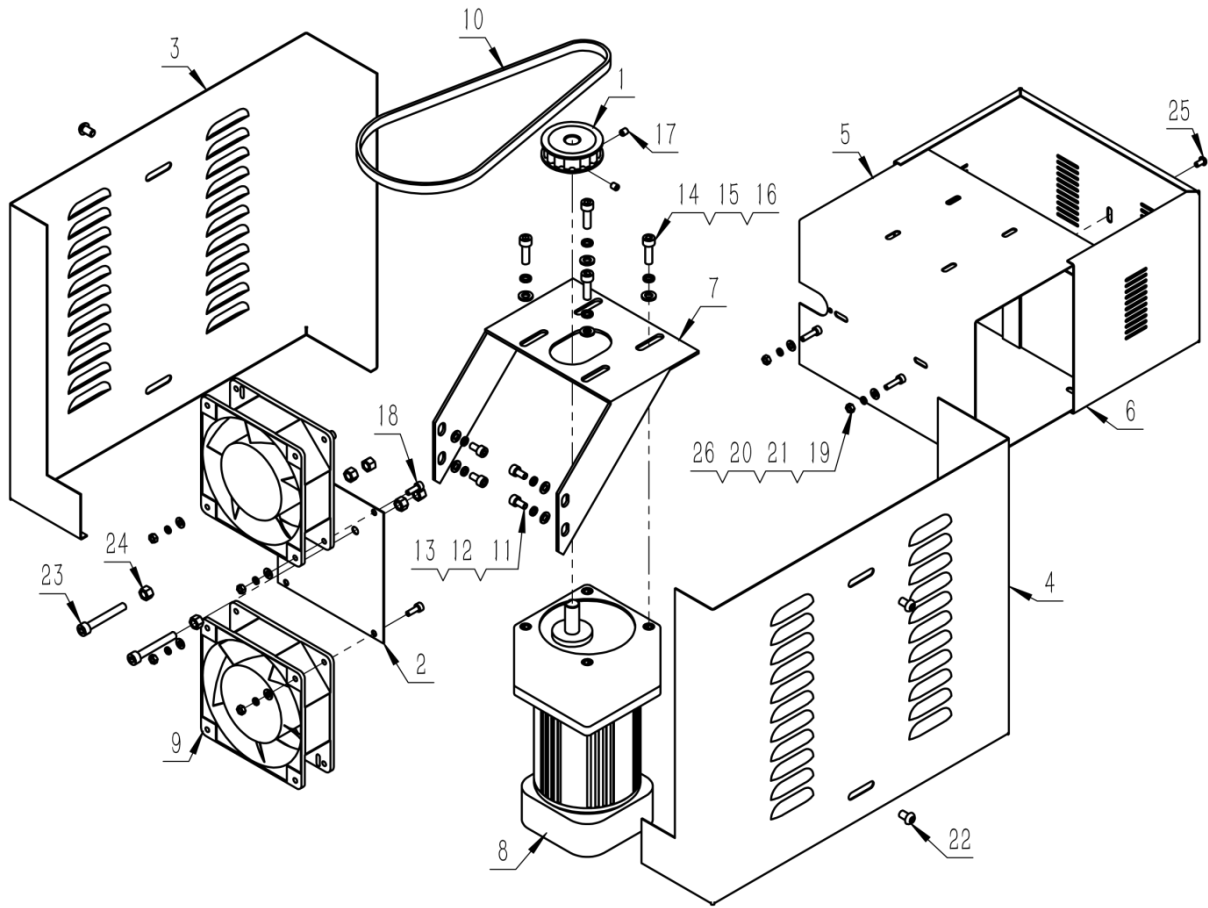
8、转筒组件



8、转筒组件

序号/No.	图号/Parts No.	名称/Description	数量/Qty
1	50901071	大带轮	1
2	50901064-1	轴筒	1
3	50902023	铜环拉紧板	1
4	50901058	电刷安装板	1
5	50901064-2	换能器上法兰片	1
6	50901064-3	换能器下法兰片	1
7	50901064-4	花轮底盘	1
8	50901075	纵向电机座	1
9	50901075-1	轴承座	2
10	50901075-2	右筋	1
11	50901075-3	左筋	1
12	509B02025	深沟球轴承 6216-2Z	2
13	50902031	集电环	1
14	50901064-8	换能器组件	1
15	418S06082	内六角圆柱头螺钉 M4×25	2
16	418W02025	平垫圈 C 级 4×0. 8	2
17	418W03002	标准型弹性垫圈(装配)4×1. 1	2
18	41007031	内六角圆柱头螺钉 M10×25	4
19	41002023	平垫圈 C 级 10×2	8
20	41002023	标准型弹性垫圈(装配)10×2. 6	8
21	418S04022	内六角圆柱头螺钉 M8×20	4
22	418N04001	1 型六角螺母 C 级 M8	4
23	41002023	平垫圈 C 级 8	4
24	41002023	标准型弹性垫圈(装配)8×2. 1	4
25	418S02090	内六角圆柱头螺钉 M5×20	2
26	419N06069	1 型六角螺母 C 级 M5	2
27	418W04017	平垫圈 C 级 5×1	2
28	418W04037	标准型弹性垫圈(装配)5×1. 3	2
29	418S02014	内六角圆柱头螺钉 M6×25	3
30	418S02094	内六角圆柱头螺钉 M6×30	3
31	418S04022	内六角圆柱头螺钉 M8×50	3
32	418S02104	内六角圆柱头螺钉 M6×20	3
33	28080246	内六角圆柱头螺钉 M10×35	4
34	41012066	1 型六角螺母 C 级 M10	4
35	50901064-9	双螺纹接头	1

9、转筒附件



9、转筒附件

序号/No.	图号/Parts No.	名称/Description	数量/Qty
1	50901072	小带轮	1
2	50901055	筒风扇联板	1
3	50901060	罩壳一	1
4	50901060-1	罩壳二	1
5	50901065	小电箱底	1
6	50901065-1	小电箱盖	1
7	50901059	转筒电机座	1
8	50902043	调速电机	1
9	41012080	风扇 120x120	2
10	50902017	同步带 240L	1
11	418S03030	内六角圆柱头螺钉 M5×10	4
12	418W04017	平垫圈 C 级 5×1	4
13	418W04037	标准型弹性垫圈(装配)5×1. 3	4
14	418S02104	内六角圆柱头螺钉 M6×20	4
15	418W04017	平垫圈 C 级 6×1. 6	4
16	418W04037	标准型弹性垫圈(装配)6×1. 6	4
17	419S10005	内六角平端紧定螺钉 M5×6	2
18	418S02048	内六角圆柱头螺钉 M4×12	4
19	419N06069	六角薄螺母 M4	6
20	418W02025	平垫圈 C 级 4×0. 8	6
21	418W03002	标准型弹性垫圈(装配)4×1. 1	6
22	416S01005	内六角平圆头螺钉 M6×10	4
23	418S02094	内六角圆柱头螺钉 M6×45	2
24		六角螺母 C 级 M6	6
25	418S02048	内六角平圆头螺钉 M4×8	1
26	418S02048	内六角圆柱头螺钉 M4×16	2