

0302 系列
6202 SERIES
0303

上下复合送料平缝机

HEAVY DUTY TOP&BOTTOM FEEDING LOCKSTITCH
SEWING MACHINE

使用说明·零件手册

INSTRUCTIONS MANUAL& PARTS BOOK

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零件样本 The parts of the machine

1. 机壳部件Arm mechanism	17~18
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1. 主要技术规格 MAIN TECHNICAL SPECIFICATIONS

适用 Suitable for	中厚料、厚料 Middle thick material
缝速 Sewing speed	2000针/分 2000 needles/minute
针距 Needles distance	0-8毫米 0-8mm
压脚提升高度 Press foot promoting height	手动6.5毫米, 膝控 ≥13毫米
最大缝厚能力 The biggest sewing	Movement 6.5mm knee, control ≥13mm
文卷式压脚升降幅度 thickness ability	8毫米(一般人造革8层) 8mm (common man-made leather 8 floors)
摆压脚与送布牙同步 The cross foot raising and	3.5-5.5毫米 3.5-5.5mm
使用机针talling extent	最长行程不小于8毫米
使用旋梭 Using the revolving shuttle	The longest not less than 8mm
供油方式 Supplying the oil way	DP x 17,20#-23#
电动机功率 Electric motor power	自动润滑大旋梭 Automatic moist big revolving
	全自动铝合金供油系统 shuttle
	Full automatic aluminium alloy supplying oil system
	0.37千瓦(缝纫机专用电机) 0.37kw (sewing machine for special use electric motor)

2. 操作准备 OPERATION PREPARATIONS

(1) 试擦机器

机头装箱前为了防止机件生锈, 故各部件均涂有较厚的防锈油脂, 机头装箱后, 在较长的贮藏和长途运输阶段可能造成油脂硬化和机壳表面积聚灰尘, 所以必须将表面的油脂和灰尘用汽油或洁净的软布试擦干净。

(2) 检查

机器出厂时, 虽经过周密的检查和试验, 但在长途运输中也可能因强烈的振动使机件松动或歪曲, 所以应该做一次周密细致的检查, 并用手轻轻转动主动轮, 看机件之间有无转动障碍、碰撞等现象或其它不均匀的阻力, 不正常的声响, 如有应作适当的调整等机器一切都正常后方可正式试车。

(1) Cleaning the machine

Before leaving the factory the machine parts are coated. With rust preventive grease, which may be hardened and contaminated by dust during storage and shipment. This grease must be removed with gasoline.

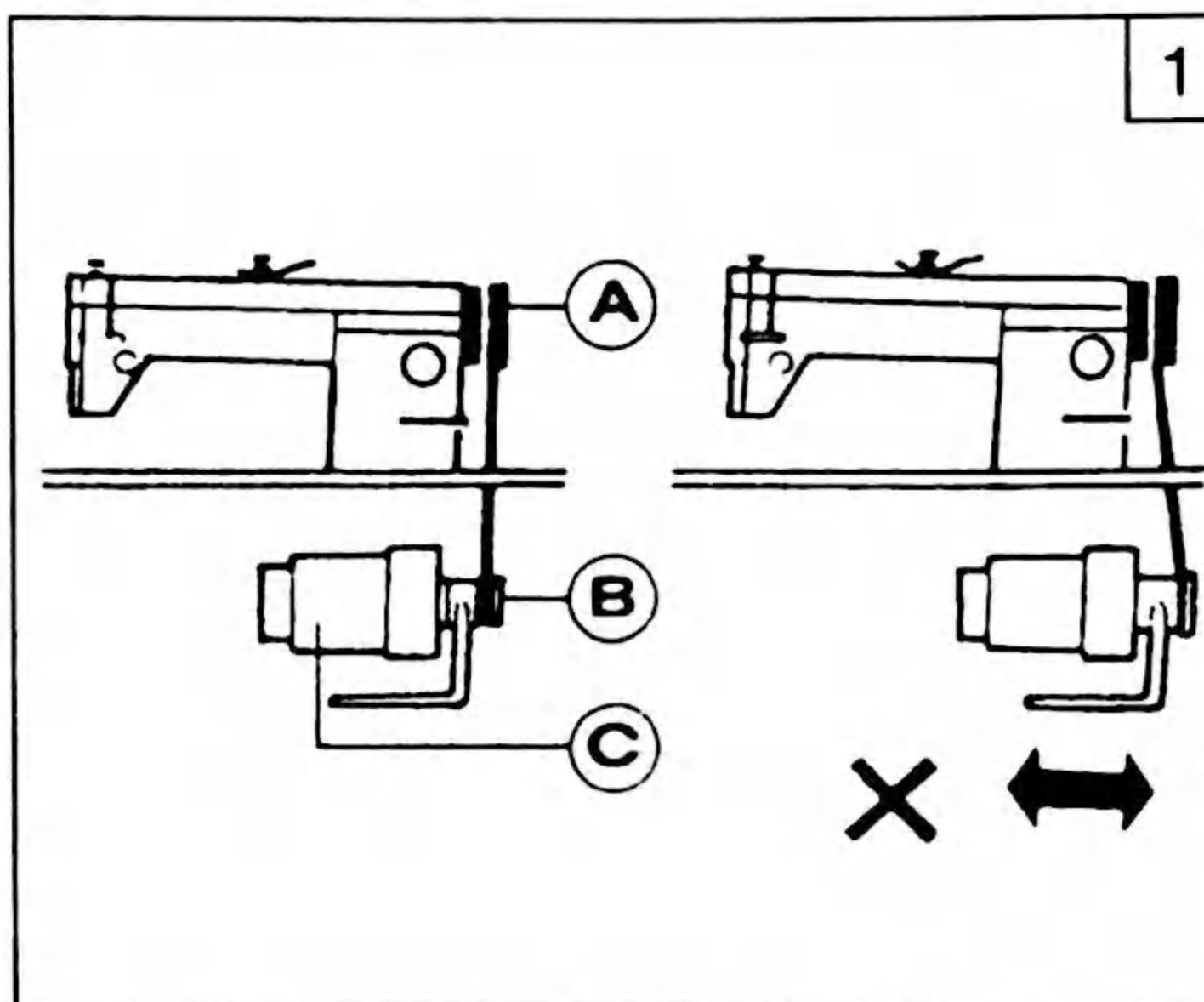
(2) Examination

Though every machine is confirmed by strict in section and test before leaving the factory. The machine parts may be loose or deformed after long distance transportation with jolt. A thorough examination must be performed after cleaning the machine. Turn the balance wheel to see if there is running obstruction, parts collision uneven resistance or abnormal noise. If these exist adjustment must be made accordingly before run-in operation.

3. 安装电机 INSTALL THE MOTOR (Fig. 1)

将电动机(C)左右移动, 使缝纫机主动轮槽(A)与电动机皮带轮槽(B)的位置调整成一直线即可。

Align motor pulley Groove (B) and Balance wheel Groove (A) by moving the motor left ward or right ward.



4. 踏脚板与离合器拉杆连接 CONNECT THE CINCH LEVER WITH THE PEDAL (Fig. 2)

1 踏脚板安装的倾斜度应与地面成15°夹角为宜。

2 调整电机离合器, 使缝纫机拉杆(F)与离合器拉杆(E)如图连成一直线, 这样可使电机运转平稳, 延长寿命。

3 缝纫机运转方向, 从机头主动轮外侧看, 应是逆时针方向。电动机的转身应一致, 其转向可用电动机插头调转180°来调整。

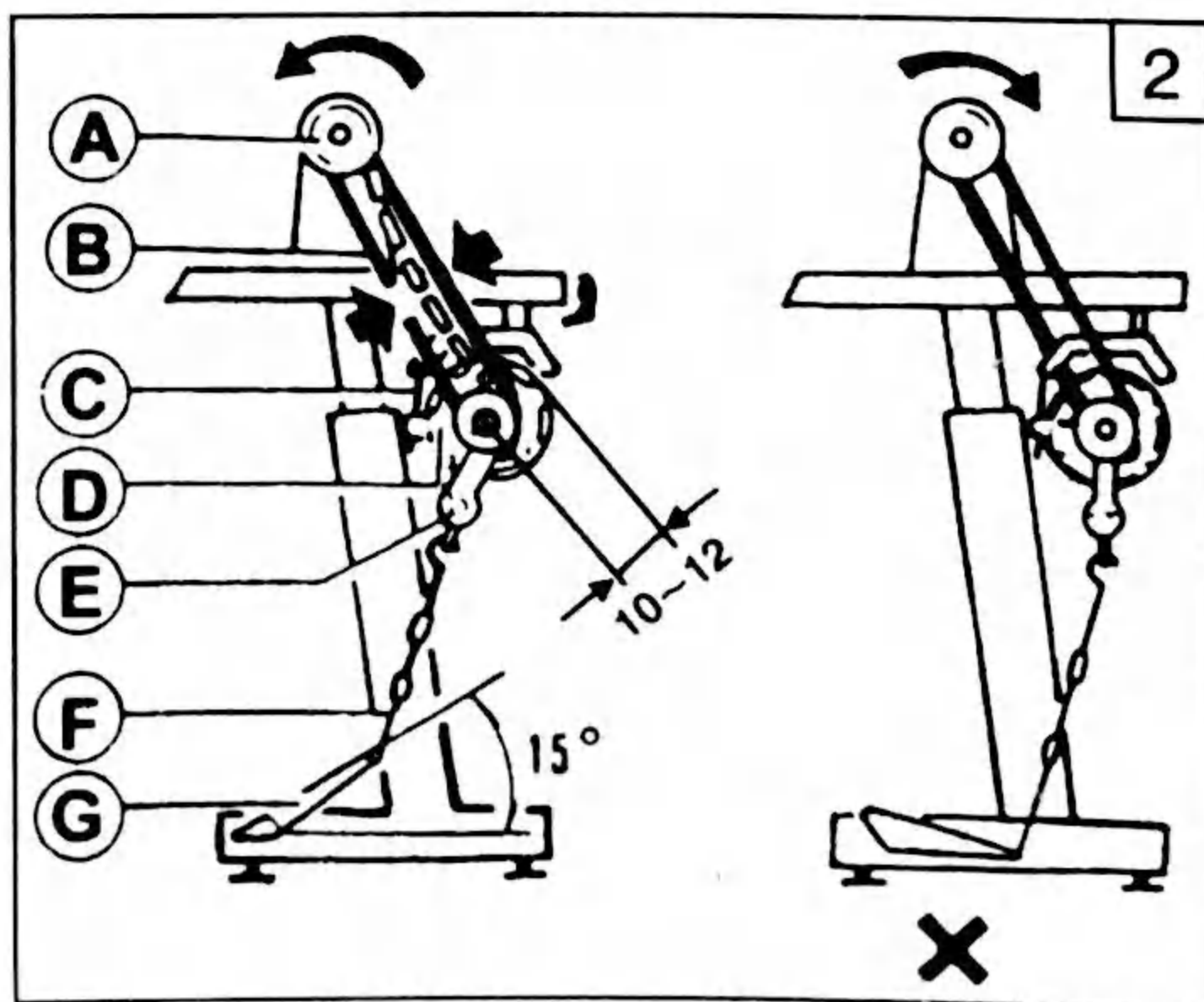
4 O型三角皮带F的张力调整, 可通过上下移动电机来完成。皮带张力的大小可用手指将皮带按下, 使皮带如图示弯曲成10-12毫米程度。

1. The optimum tilt angle of pedal (A) is approximately 15°.

2. Adjust clutch cover (D) so that clutch Lever (C) and Draw Bar (B) run in line.

3. The Balance Wheel Should rotate clockwise when viewed from the outside of Balance wheel (G) The direction of the motor pulley rotation can be reversed by reversing (turning over 180 den) The power plug of the mater.

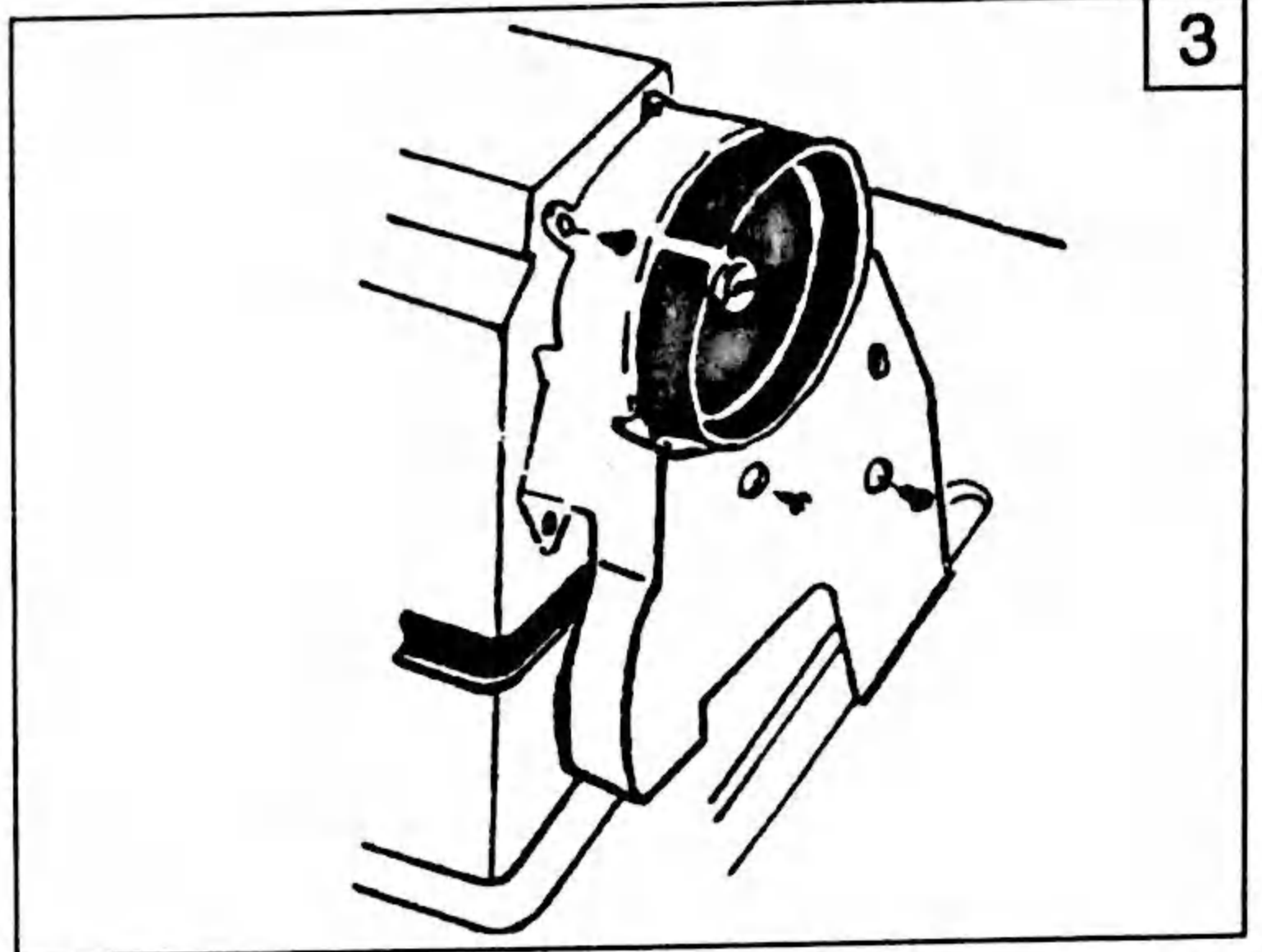
4. Adjust the tension of V-belt (F) by turning motor vertical position screw (E) The proper tension of the V-belt is a slack of 10-12mm. When the belt is depressed at the of the belt by finger



5. 安装皮带防护罩 BELT CORER INSTALLATION (Fig.3)

从安装角度考虑，应安装皮带防护罩。如右图所示。

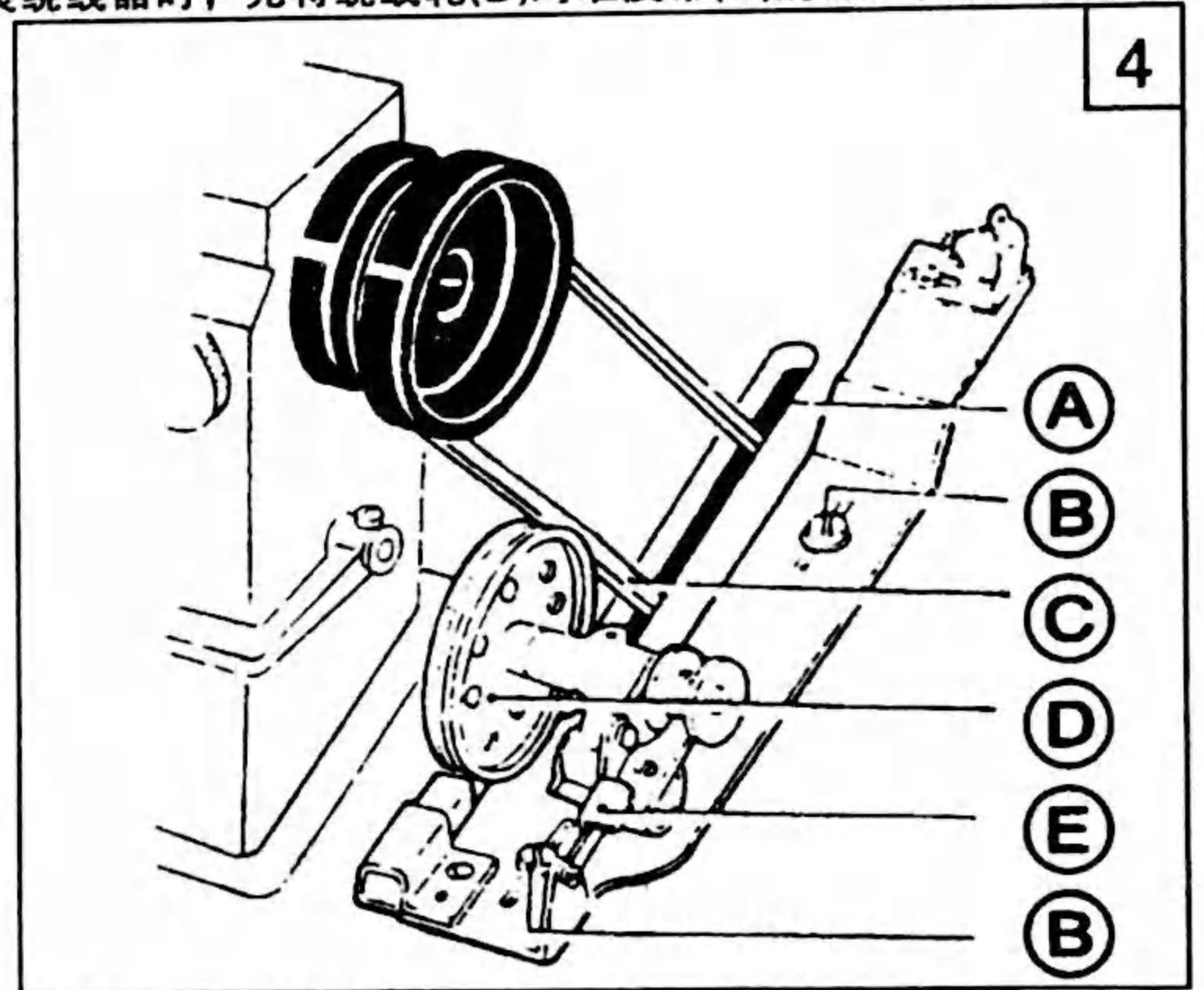
Install the belt corer for the sake of safety just showed in the right picture



6. 安装绕线器 WINDING INSTALLATION (Fig.4)

安装好机头，套上皮带后，就可以开始安装绕线器。安装绕线器时，先将绕线轮(D)对准皮带(C)的外边，绕线轮和皮带之间应有一定的间隙，并保证撤下绕线摆杆(E)时，绕线轮和皮带能保持相互接触。这样机器转动时，皮带将带动绕线轮一起转动，并注意绕线器安装之左右位置，应与台板皮带孔(A)平行，最后拧紧木螺钉(B)。

After installing the machine head and covering the belt It's time to install the entwining thread machine. While installing, at first entwining wed should be right to the leather belt(C) outside. There should be a certain distant between the entwining wheel and the belt. and make sure If you torch the entwining thread shaking pole down. They can keep touch so while the machine is manning The leather belt will revolve together with the wheel. and pay attention to the machine installing righter left positions should parallel the board leather belt hole (A). At last tighten the wood screw b)



7. 润滑 LUBRICATION (Fig.5)

(1) 油量
油量必须按油盘内标记加注。图中标记(A)是油量最高位。(B)是油量最低位。注意油量不得低于标记(B)，否则缝纫机各部位就会出现供油不足，造成发热咬死等现象。

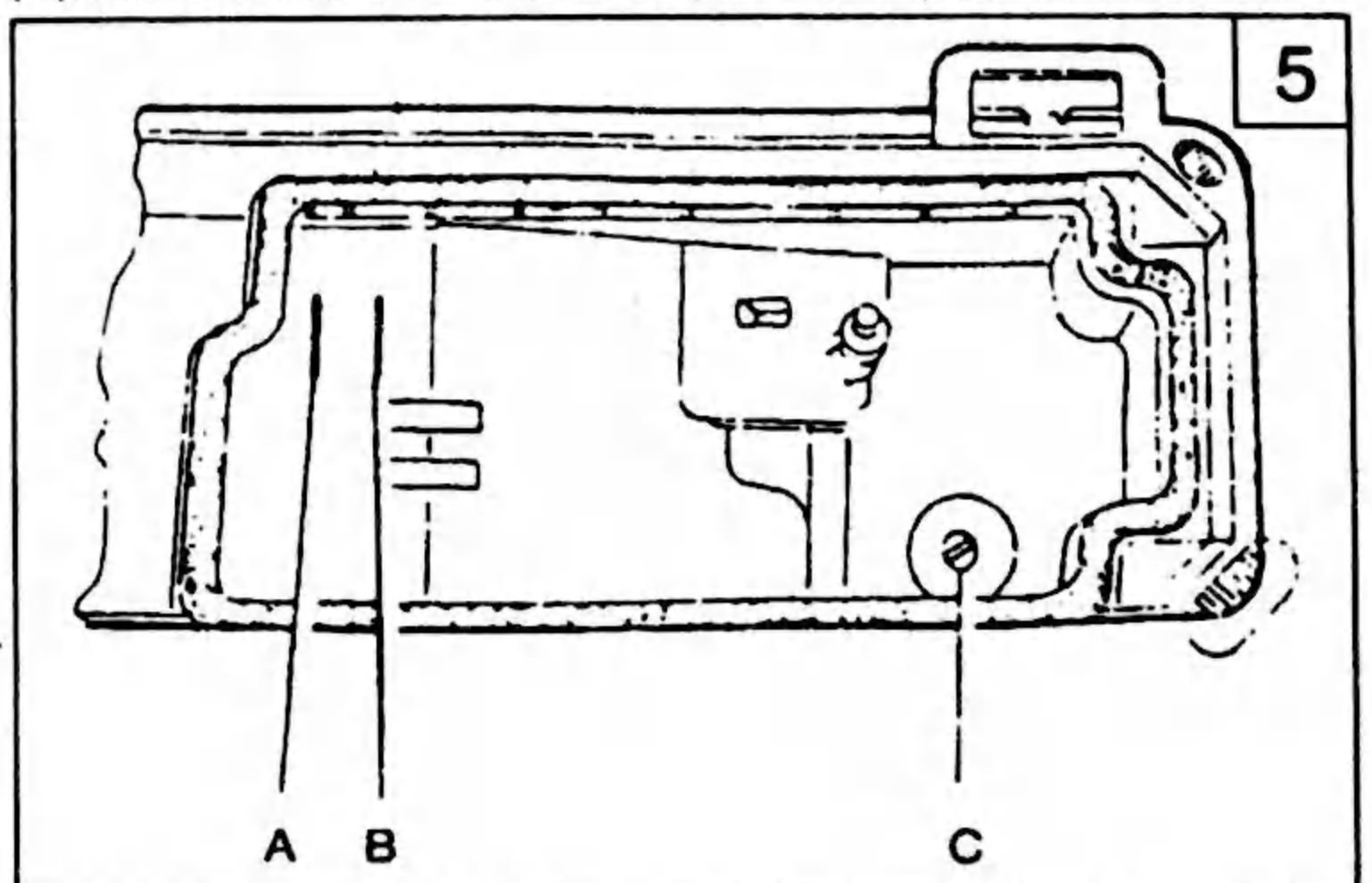
(2) 加油
必须使用特#18高速缝纫机润滑油，运转前油量加至标记(A)。

(3) 换油
① 旋下放油螺钉(C)，排净废油。
② 扫清油盘污尘，旋紧放油螺钉(C)，加注新油至油量最高标记(A)。

(1) Required amount of oil
Line (A) on the oil reservoir: Max oil lever.
Line (B) on the oil reservoir: Min oil lever.
If oil level goes down under Line (B) oil can't be distributed to each part of the machine thus causing the parts a seizure.

(2) Replenishing
Always use only No 18special machine oil for high speed sewing. Be sure to replenish oil to line (A) before starting operation.

(3) Replacing oil
To replace oil remove Screw (C)to drain oil after completely draining off oil clean the oil reservoir and securely tighten Screw (C) then fill the reservoir with fresh oil.



8. 试车 RUN-IN OPERATION (Fig. 6)

新机器在开始使用和长期搁置重新使用时，先卸下机头上部的红色橡皮塞和面板，按图示的位置充分加油。然后抬起压脚进行低速运转1000~1500spm，并观察油窗(B)的喷油情况，润滑正常后，仍须保持低速30分钟的运转试验，以后逐渐提高缝纫速度；经过一个月左右的使用，使机器充分跑合。然后根据工作的性质提高到一定的缝速。

Run in operation is required for a new Sewing machine or a sewing machine left out of operation for considerable length of time.

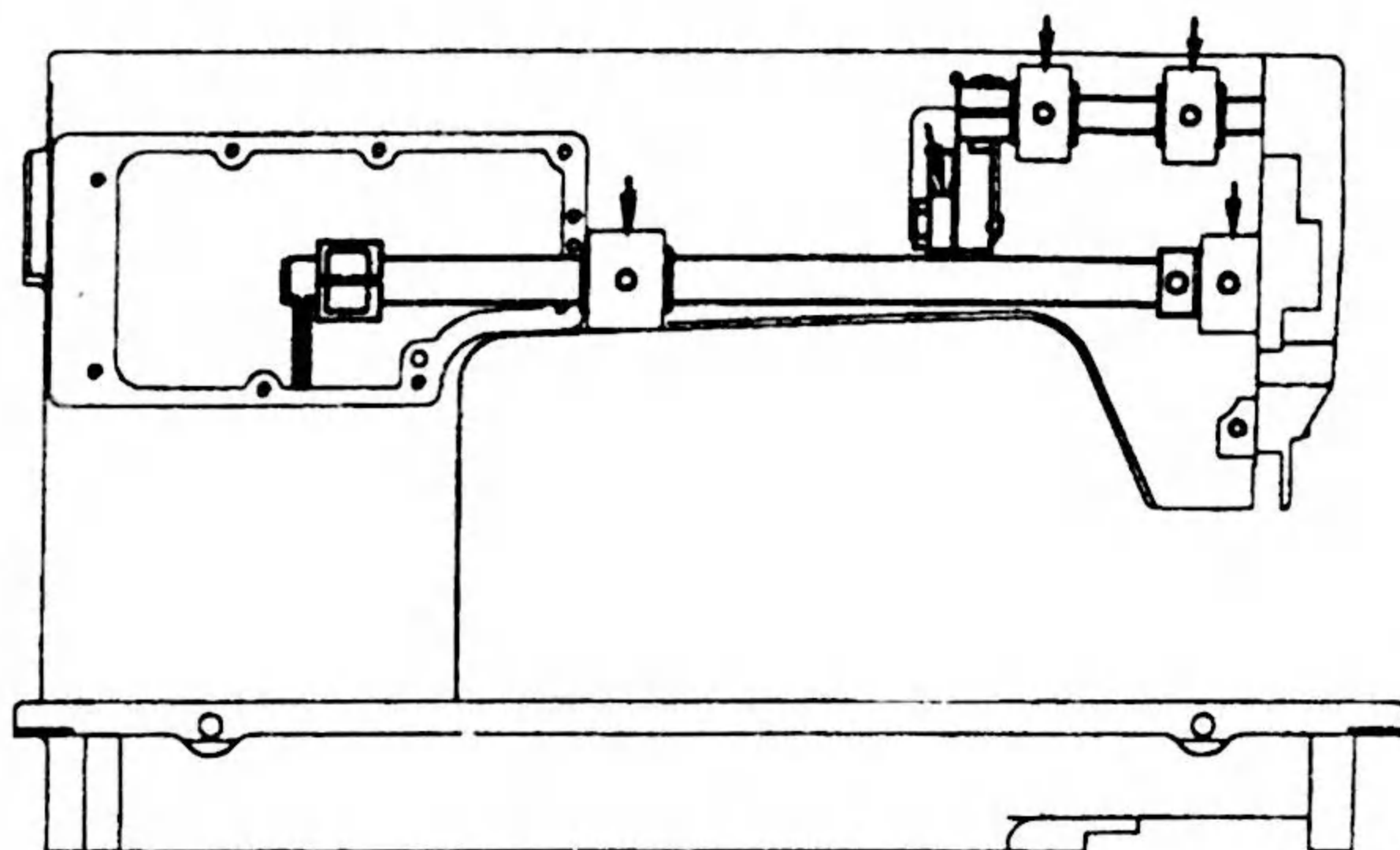
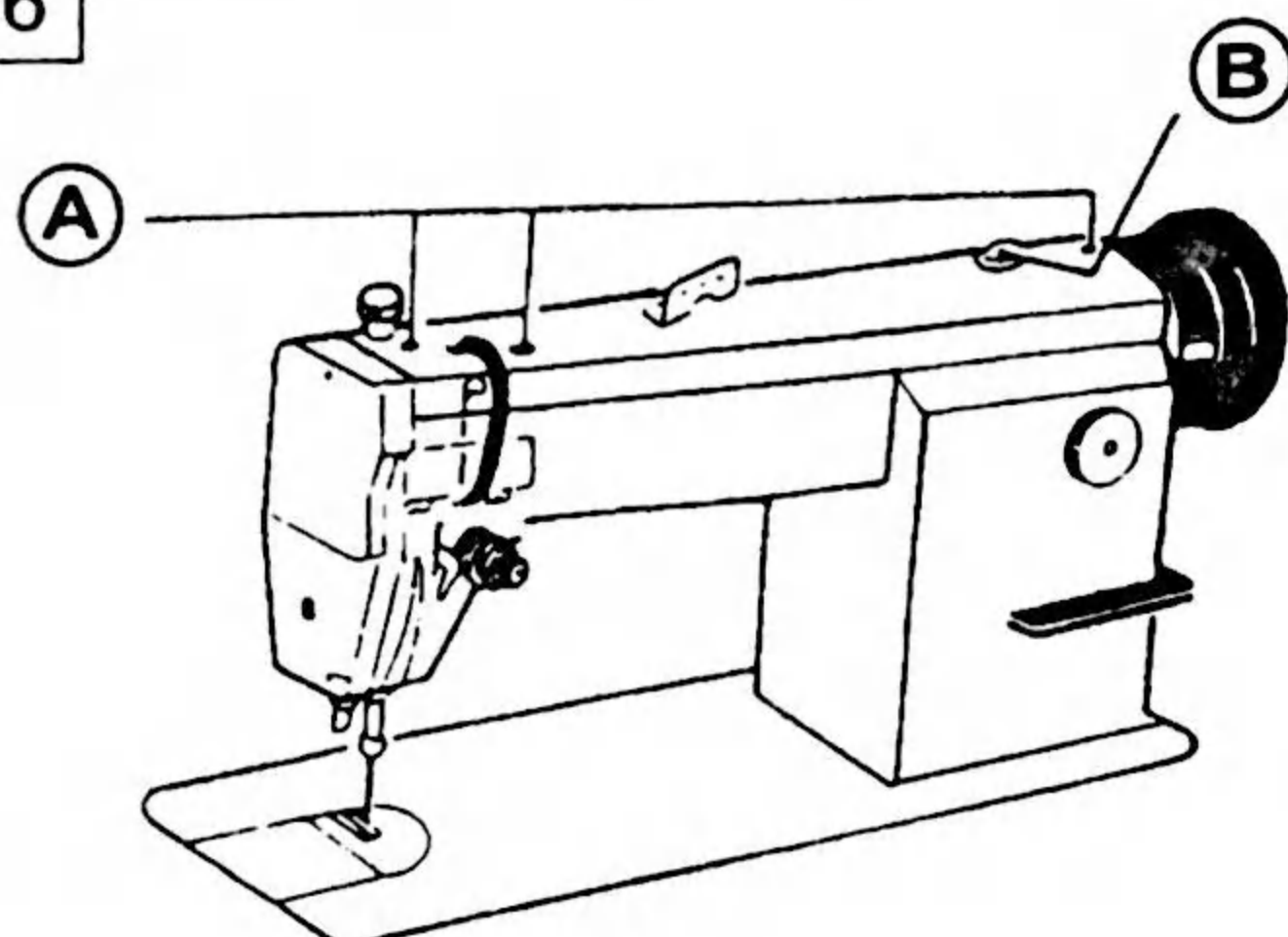
1) Remove Red Rubber plugs (A) on the top of the arm and replenish sufficient amount of oil.

2) Lift presser Foot (B).

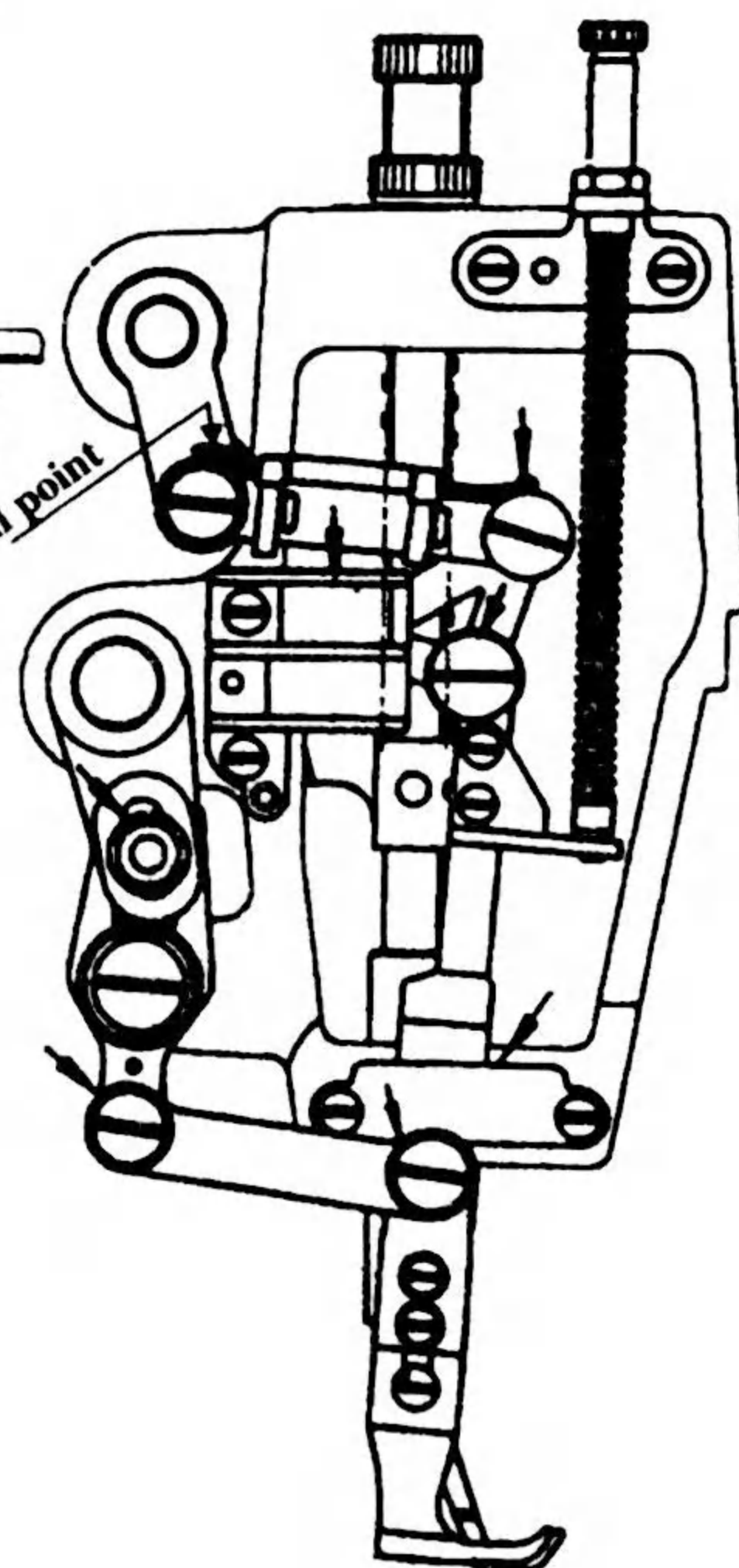
3) Run ted machine at a low speed (1000-1500SPM) to check oil distributing condition through oil check window (C).

4) Perform run-in operation at 1000-1500 SPM for 30 minutes. After a lapse of one month if service during which the working speed is increased gradually and the machine runs sufficiently well the high speed 2000 SPM can be adopted according to the nature of the work.

6



注油点
imbuing oil point

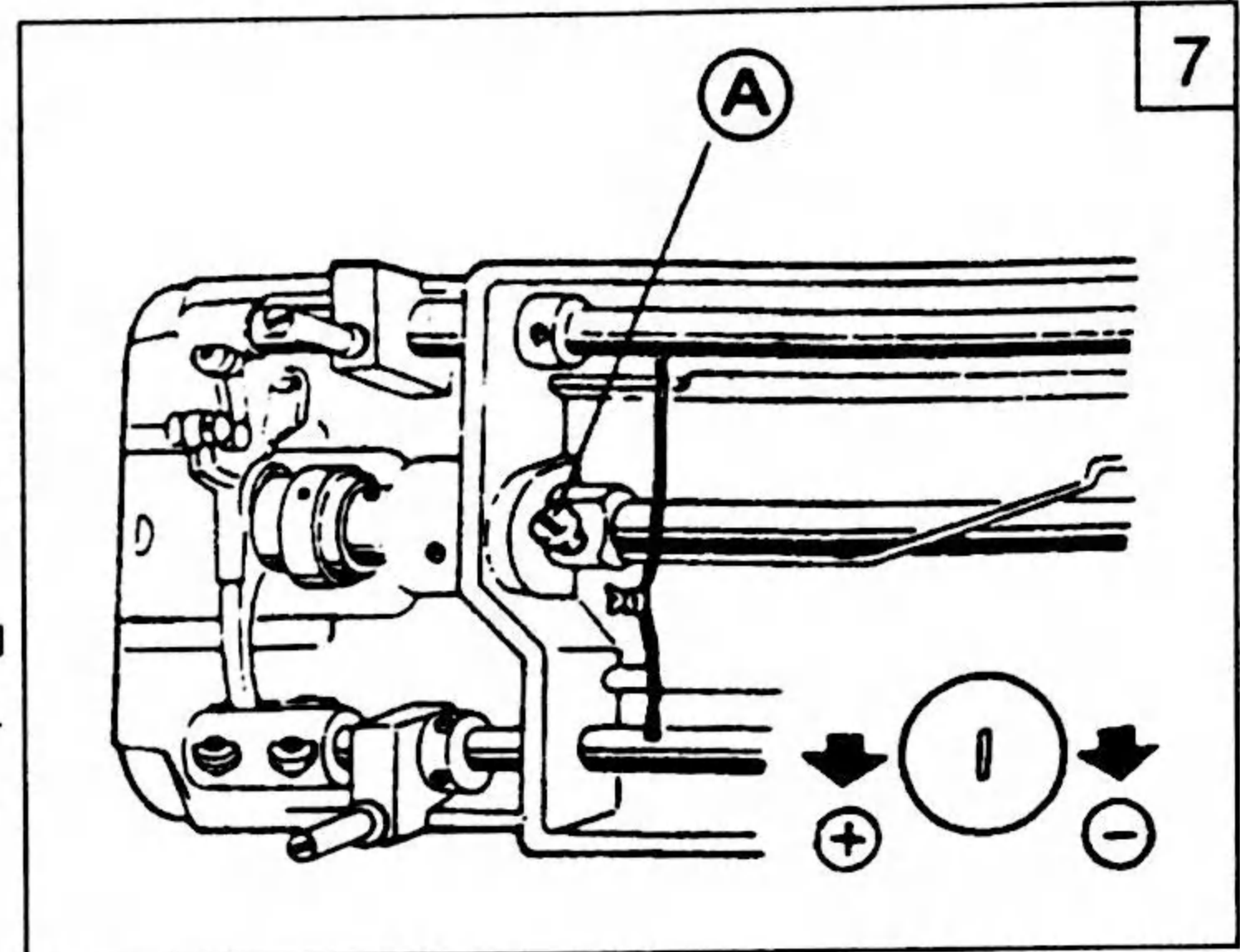


9. 旋梭油量调节 LUBRICATION ADJUSTMENT (Fig. 7)

旋梭的油量，可以用油量调节螺钉(A)加以调节。顺时针方向(“+”号方向)转动油量调节螺钉(A)。油量增多；逆时针方向(“-”号方向)转动油量调节螺钉，则油量减少，油量调节螺钉(A)在回转5圈范围内调节油量，旋向紧固位置时，油量最多，反之，油量最少。

The lubrication of the rotating hook can be adjusted by oil Adjusting Screw (A) as follow:

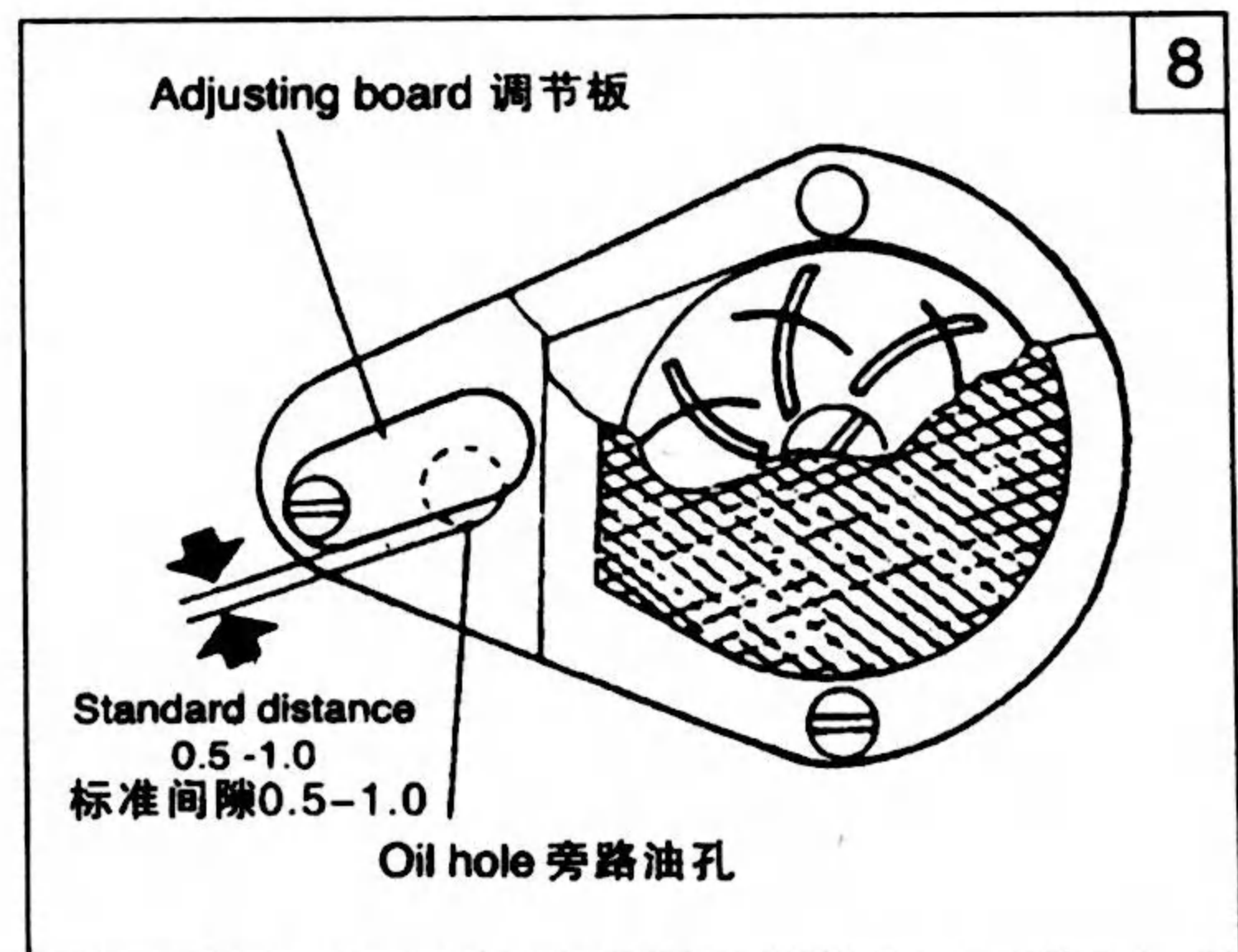
- 1) Turn oil Adjusting Screw (A) clockwise to increase oil and turn oil Adjustment Screw (A) counterclockwise to decrease oil.
- 2) Oil Adjusting Screw (A) adjusts oil amount within 5 turns. When oil Adjusting Screw (A) is fully tightened oil amount is maximum.



10. 油泵进油调节 OIL PUMP ENTERING OIL ADJUSTMENT. (Fig. 8)

通常情况下，不作油泵进油调节。在低速运转时，观察油窗，未见喷油现象时，请将旁路油孔间隙合拢。

Usually It's not necessary to adjust the oil pump enter oil. When it's running at low speed, observe the oil window. If you don't see the oil spraying. Please link the nearby oil holes distance.



11. 安装机针 REPLACE NEEDLE (Fig.9)

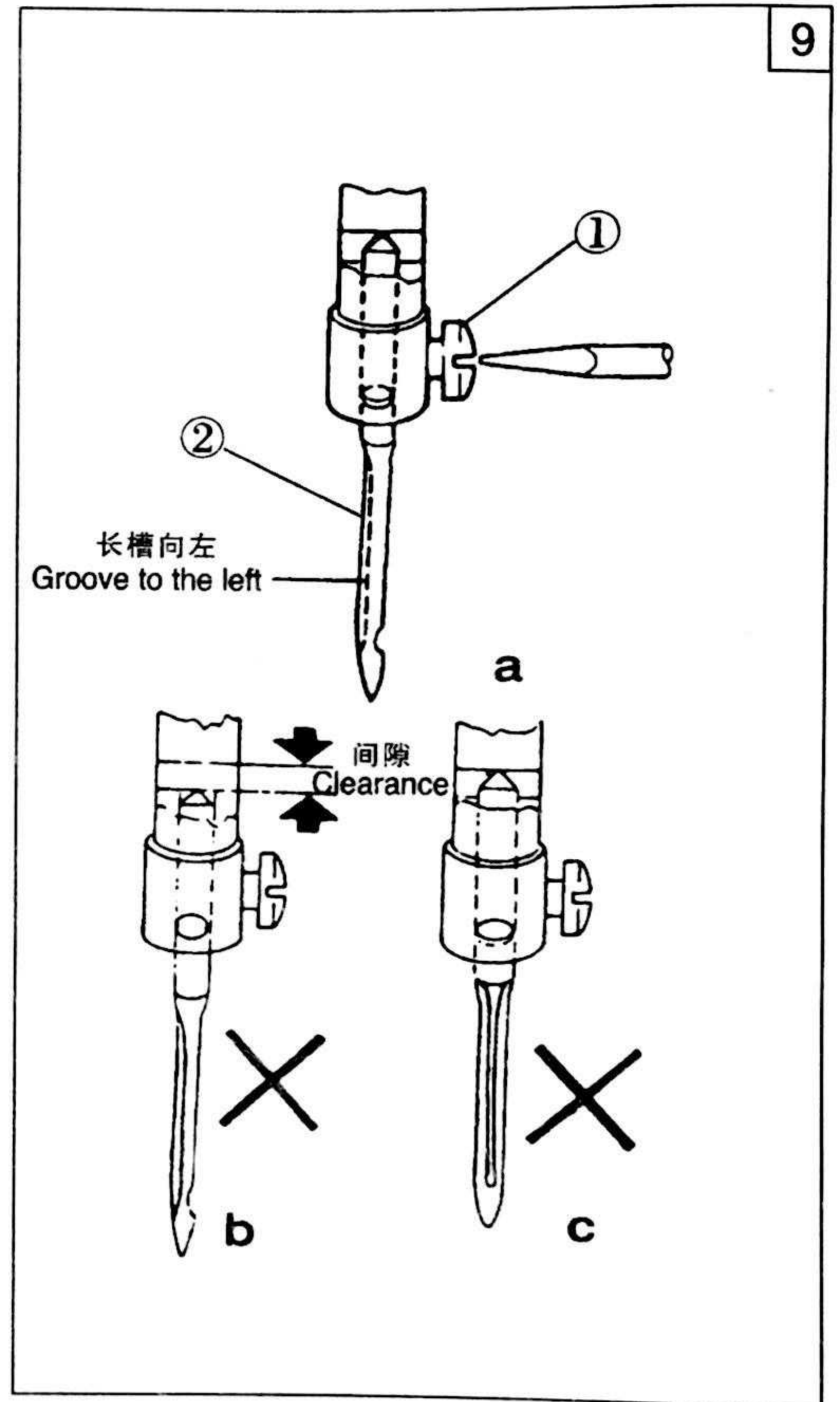
1. 转动缝纫机主动轮，使针杆停在最高位置。
2. 松开固定螺钉①。
3. 使机针②长槽面向左侧，一直插到最深上，旋紧固定螺钉①。

注意：如图(b)所示，机针没有插到底。如图(c)所示升槽方面面对操作者，以上两者都是错误的安装。

Turn the balance. Wheel to lift Needle bar to the upper end of its stroke. Loosen Needle clamp screw A. While Keeping the long groove of the needle left ward fully insert the needle shank up to the bottom of the needle socket. Then tighten Needle clamp screw A.

Note: Fit (b): insufficient insertion.

Fig (c): wrong direction of long groove



12. 穿面线 THREADING (Fig.10)

穿面线时针杆应在最高位置，然后从线架上引出线头按顺序穿线。

(a) 穿过上面三也线勾①

(b) 穿过机壳上部小夹线过线板②上的左过线孔，再通过小夹线板，然后穿过小夹线过线板②上的下过线孔。

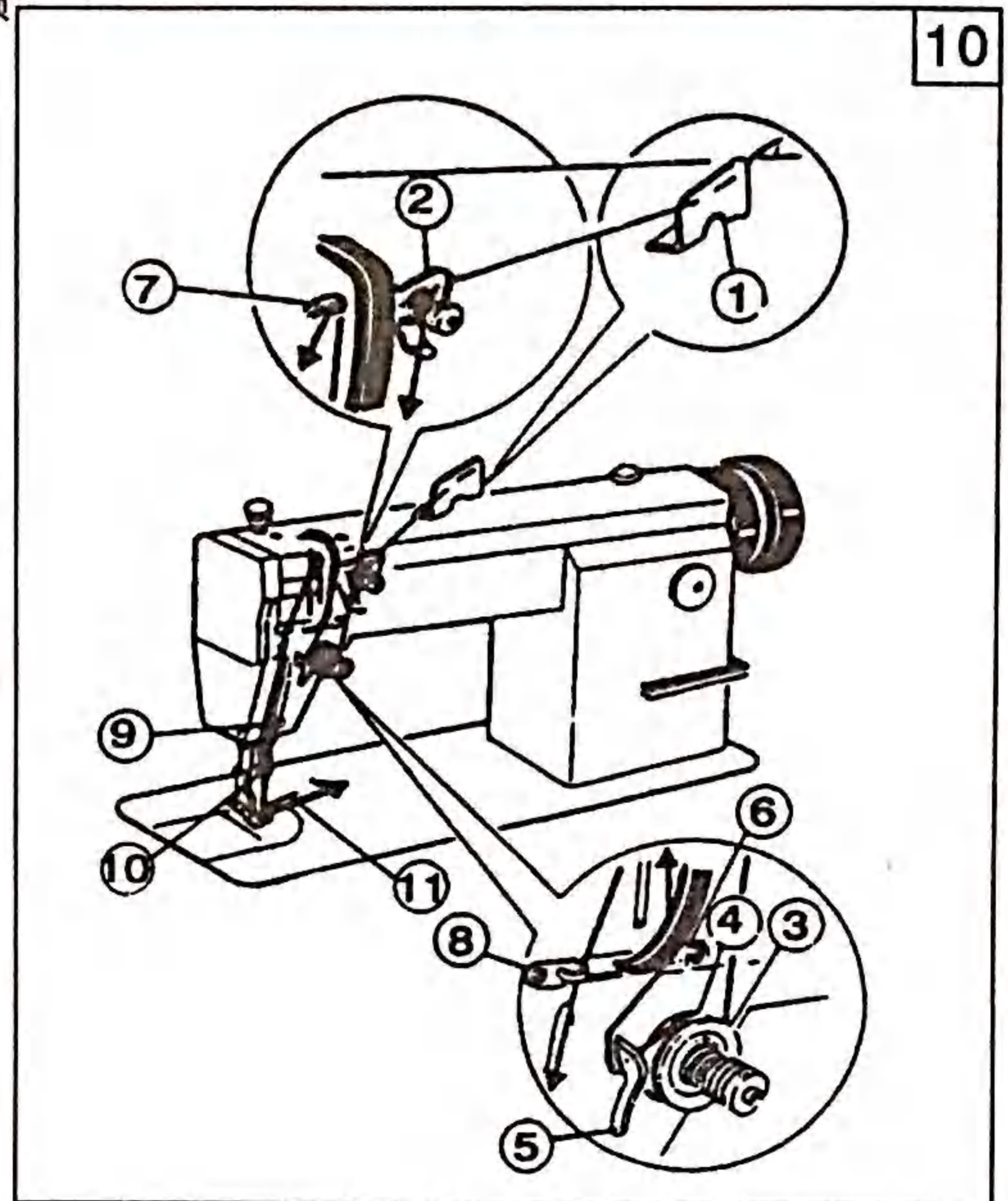
(c) 在夹线座的夹线板③之间通过。

(d) 向上穿过挑线簧④，经过大线勾⑤和线勾⑥，向上从右向左穿过挑线杆⑦的穿线孔。

(e) 向下通过面板线勾⑧，下线勾⑨，及针杆过线环⑩，从左面穿过机针⑪的针孔，并引出50毫米左右的线备用。

引底线时，先将面线头捏住，转动主动轮使针杆向下运动，再回升到最高位置，然后拉起捏住的面线线头，底线将被牵引上来，最后将底、面线一起置于压脚下前方。

To thread the needle thread raise needle bar to the upper end of its stroke, lead the thread from spool and perform threading as shown in Fig.6. To draw the bobbin thread, hold the end of the needle thread and turn the balance wheel to lower the needle bar and then to lift it to its highest position pull the needle thread and the bobbin thread is drawn up. Put the ends of needle thread and bobbin thread frontward under presser foot.



13. 绕线调节 WINDING ADJUSTMENT (Fig.11)

梭心线应排列整齐而紧密。如松浮不紧，可以加大过线架夹线板(A)的压力。如排列不齐，则要移动过线架(C)的位置进行调整。调整时，先松开过线架螺钉(B)单边绕线成图 (b)时，向右移动过线架；单边绕成(C)时向左移动过线架，使之能自动排列整齐成图(a)后，再紧固之。

注意：绕涤纶、尼龙线时，特别要放松绕线压力，否则梭心(D)就可能产生断裂变形。

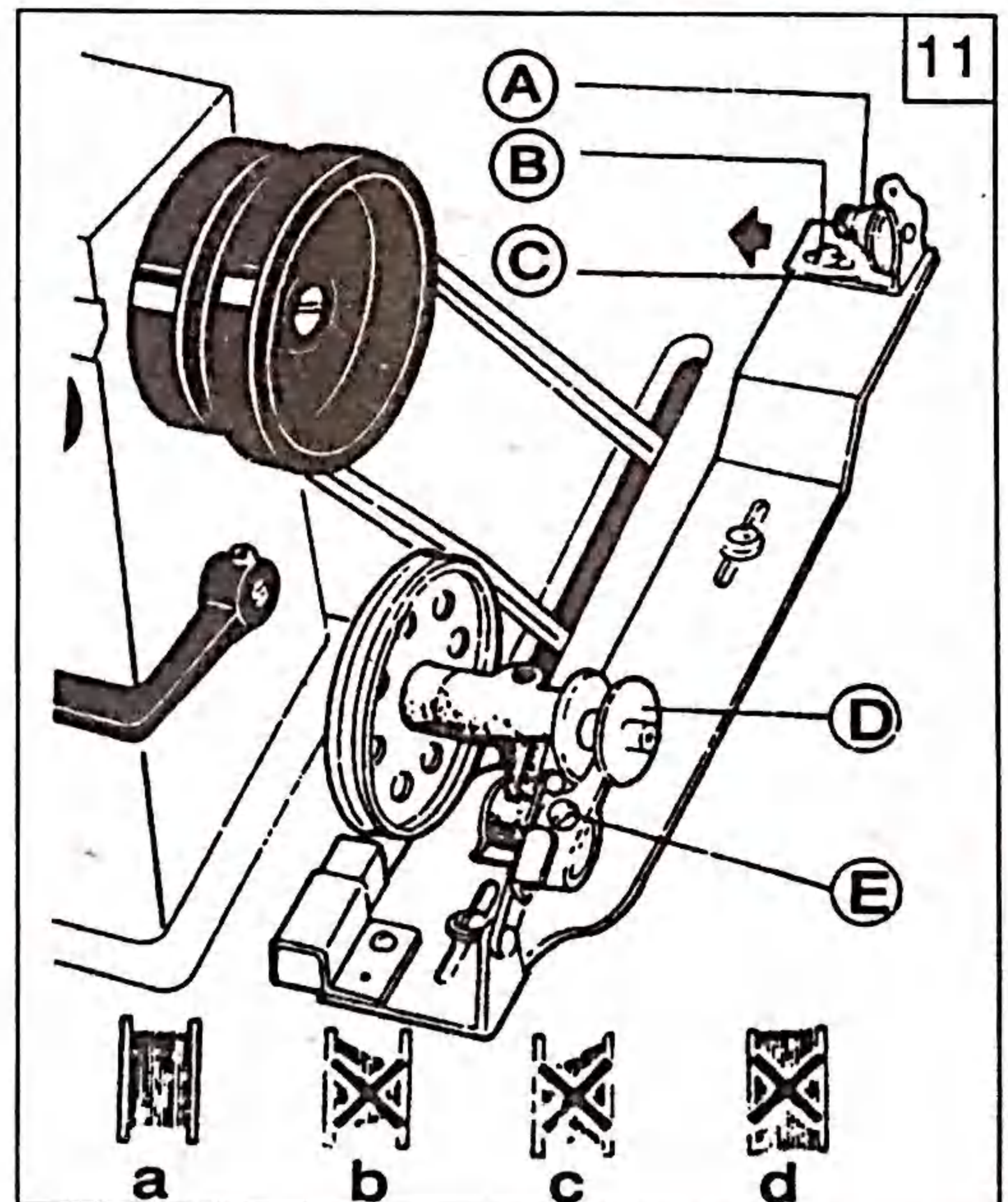
梭心线不要绕得过满，否则容易散落，适当的绕线量为平行绕线至梭心外径的80%。绕线量由满线跳板上的满线度调节螺钉(E)加以调节。

1) The wound bobbin thread should be neat and tight. If not adjust the winding tension by turning Tension stud (A) of bobbin winder tension bracket.

2) When the wound thread layer does not present a cylindrical shape as shown in Fig. 7(a) loosen Set screw (B) of bobbin winder tension bracket and slide Bracket (C) left ward or right ward. If thread is wound as shown in Fig.7 (b) move the bracket right ward. But if thread is wound as shown in Fig.7 (C) move the bracket left ward.

After adequately positioning the bracket tighten Set screw (B).

3) Do not overfill the bobbin. The optimum length of thread will fill about 80% of bobbin capacity. This can be adjusted by Adjusting screw (E) of bobbin winder stop latch.

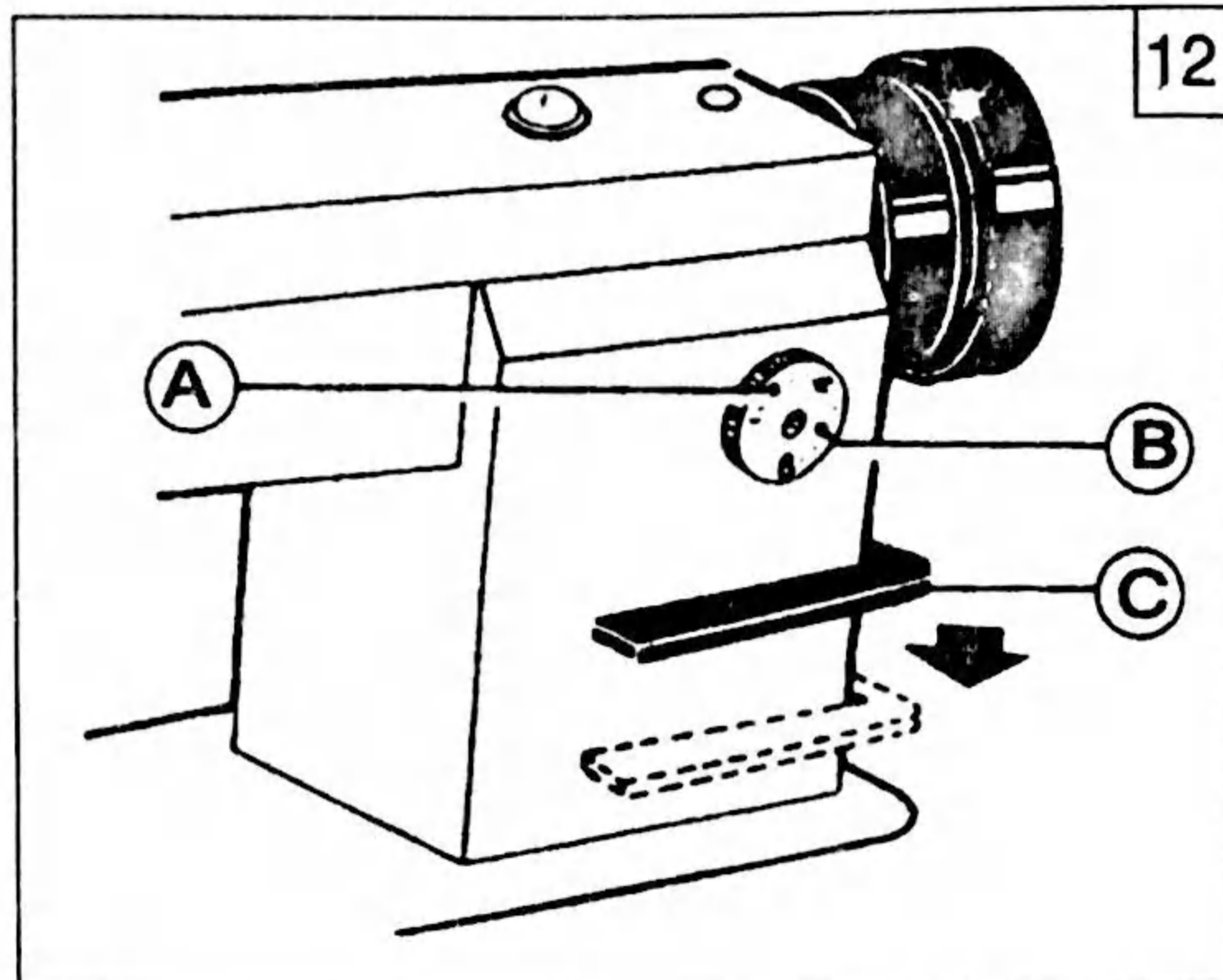


14. 针距、倒顺送料 SET STITCH LENGTH AND REVERSE FEEDING (Fig.12)

针距的长短，可以通过旋转针距标盘(A)来调节。针距标盘(A)的平面(B)上的数字表示针距长短尺寸(单位为毫米)。

倒向送料时，压下将倒缝操纵杆(C)，即能进行倒缝，手放松后，倒缝操纵杆(C)自动复位，恢复顺向送料。

- 1) Stitch length can be set by turning Dial (A).
- 2) The figures on Face (B) of dial show stitch length in mm.
- 3) Reverse feeding starts when Reverse Feed lever (C) is depressed, and the machine will feed forward again if Reverse Feed lever (C) is released.



15. 压脚压力调节 PRESS FOOT. PRESSURE ADJUSTING (Fig.13)

压脚的压力，要根据缝料的厚度加以调节。首先旋松调压螺钉锁紧螺母(A)，缝厚料时，应加大压脚压力，这时将机头顶部的调压螺钉按图a所示箭头方向转动，反之，缝薄料时，可按图b所示的箭头方向转动。以减少压脚的压力。最后旋紧调压螺钉锁紧螺母(A)即可。

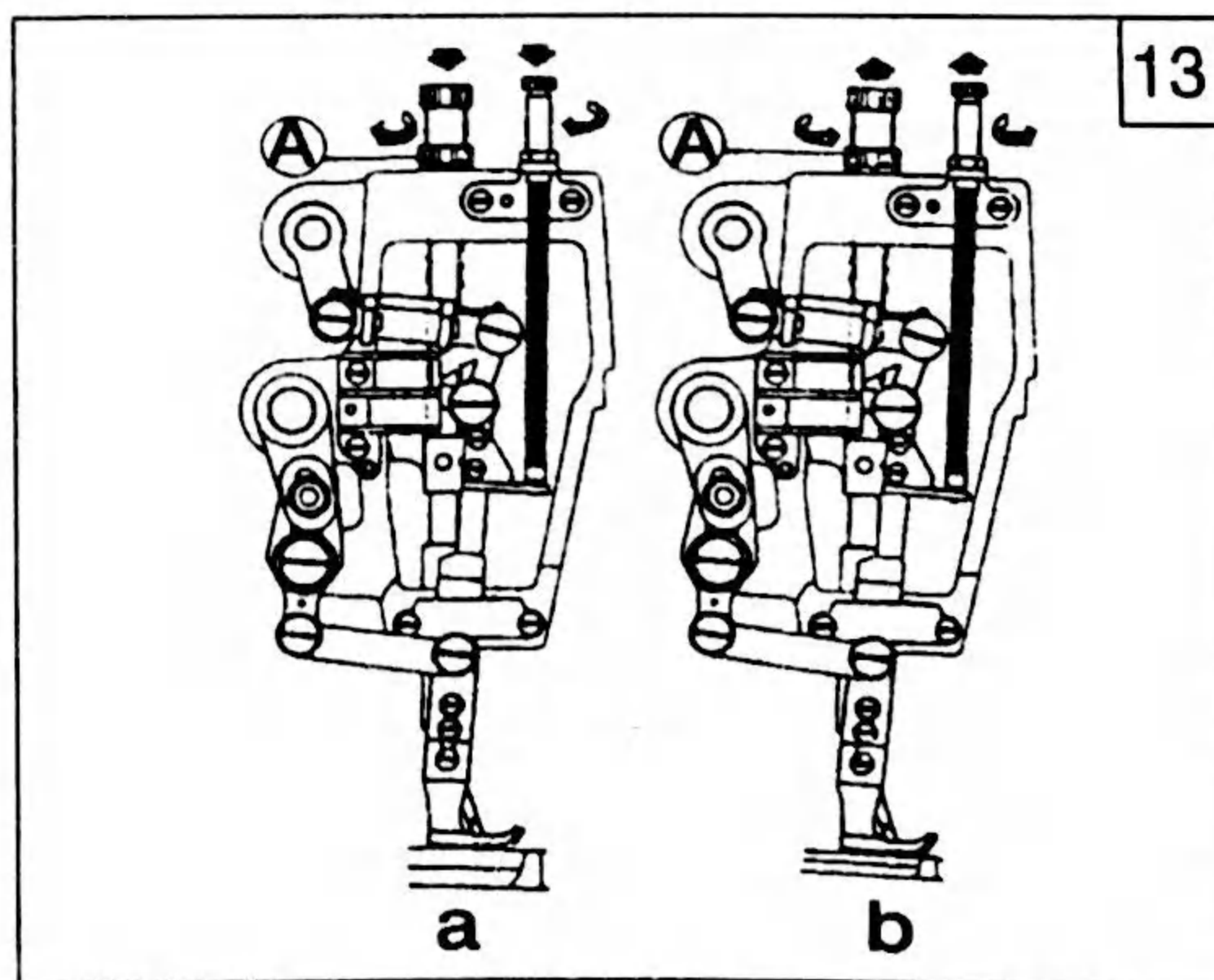
压脚的压力，应以能正常输送缝料为宜。

Pressure of presser foot is be adjusted in accordance with thickness of material to be Sewn.

First loosen Lock Nut (A). For heavy materials turn the pressure regulating thumb screw as shown in Fig. 10

(a) to increase the pressure. While for light materials turn the pressure regulating thumb screw as shown in Fig. 10

(b) to decrease the decrease the pressure. Then tighten Lock Nut (A).



16. 缝线张力(图14, 15) ADJUST THREAD TENSION (Fig.14,15)

缝线的张力要根据缝料的差别、缝线的粗细以及其他一些因素而变动。

实际使用中,是根据缝纫出来的线迹,来调整底、面线的张力,使之得到正常的线迹。

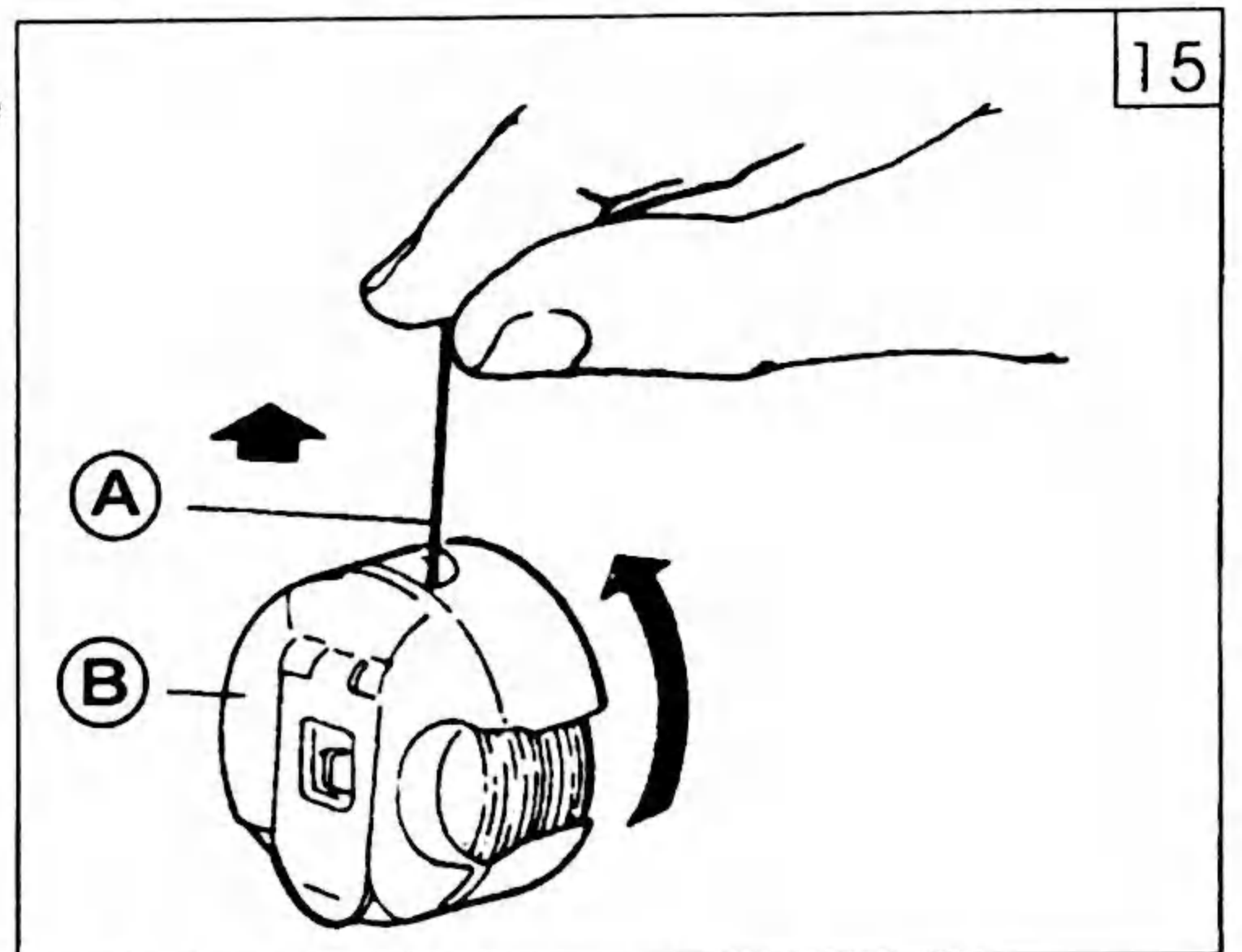
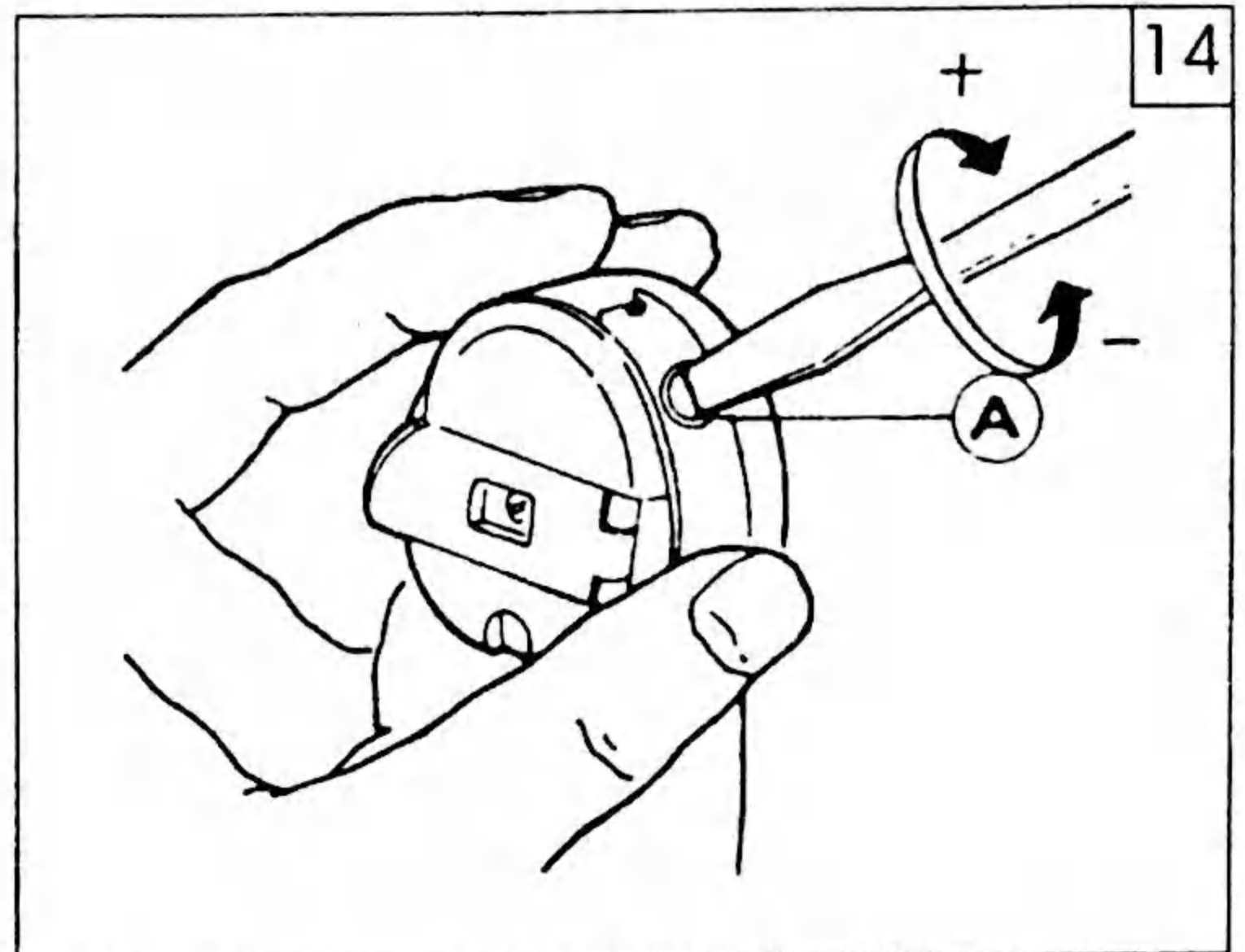
底线张力调整,用小号螺钉起子旋转梭心套上梭皮螺钉(A)来加大或减少底线压力。

一般来说,底线如果用50#涤纶线,梭心装入梭心套后,拉出缝线穿过梭习套线孔,捏住线头吊起梭心套,梭心套则能缓缓自由下落。

面线张力以底线张力为基础。交换夹线组件中挑线簧张力,挑线簧摆动幅度、夹线簧张力,夹线板及线勾的位置等来调整。

In principle thread tension is to be adjusted in accordance with materials thread and other factors. In practice thread tension should be adjusted with reference to the bobbin thread tension. Turn tension spring Regulating screw (A) of bobbin case clockwise for more tension, or turn the screw Counter-clockwise for less tension.

It is common practice to test the bobbin thread tension as shown in Fig. 12 Hold the end of the thread from delivery eye. If the bobbin case is falling lowly, the prop adjusted by setting (1) the thread take up spring tension (2) The thread take - up spring stork and (3) tension spring. All these adjustment will be described in the following.



17. 挑线簧调节 ADJUST THREAD TAKE-UP. SPRING (Fig.16,17)

挑线簧摆动幅度一般为5~8毫米。缝纫薄料(短针距)则要减弱挑线簧的张力和放宽摆动幅度,缝制特别厚的缝料则反之。

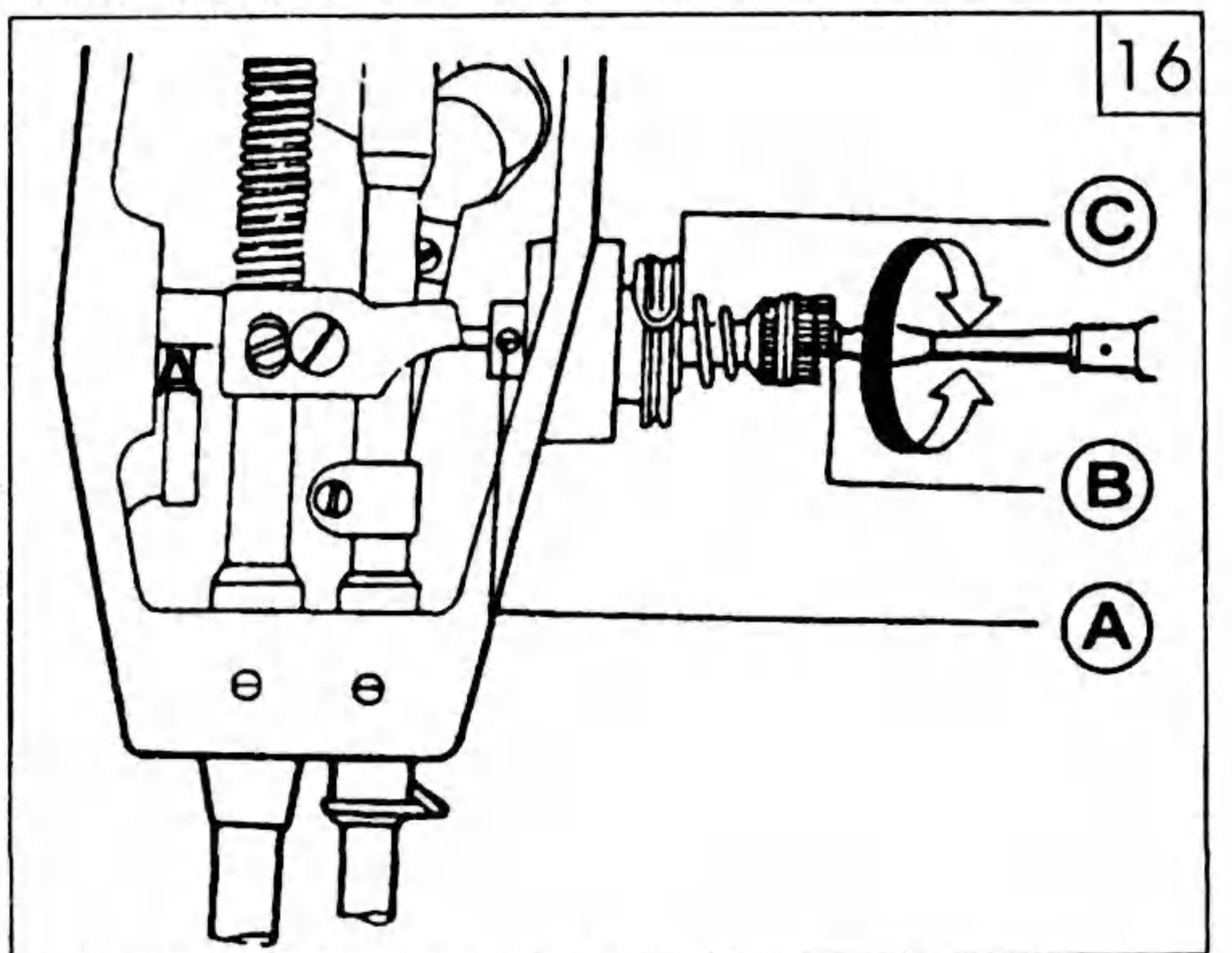
1、挑线簧张力调节

先旋松夹线调节座螺钉(A),旋转夹线螺钉(B),顺时针转动时张力增加,反之则减少,调节后,仍将夹线调节座螺钉(A)旋紧。

控制方法:

松开夹线调节座螺钉(A)夹线螺钉(B),逆时针转动,使挑线簧(C)的张力压缩到0,再把夹线螺钉(B)顺时针转动,至挑线簧(C)触及夹线调节止动缺口,然后,再逆时针回转二分之一角度即可,最后旋紧夹线调节螺钉座(A)。

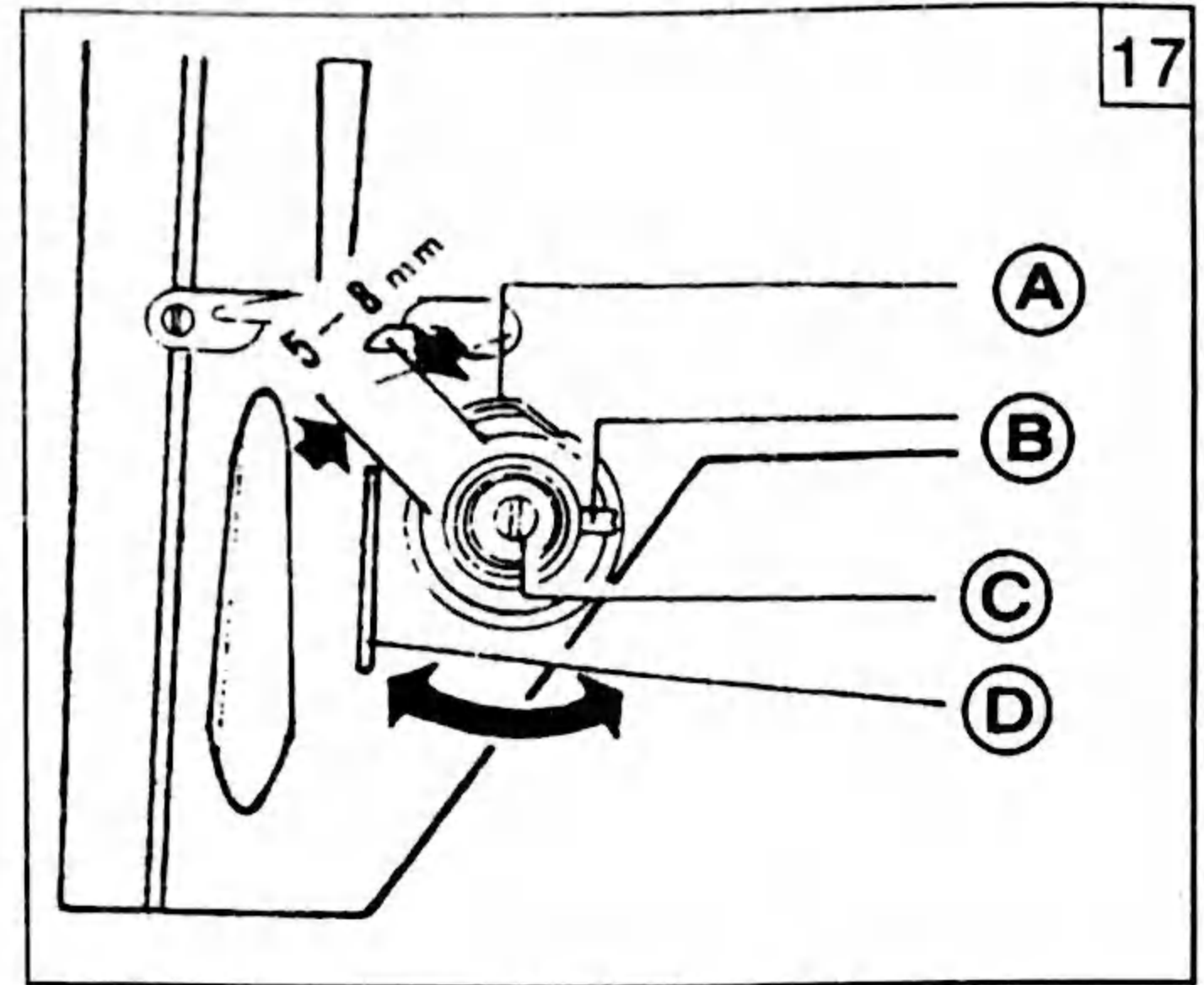
1) Adjusting the thread take-up spring tension Loosen Set Screw (A) turn Tension Stud (B) clock-wise to increase the spring tension, or turn the stud counter-clockwise to decrease the spring tension. After the adjustment be sure to tighten Set Screw (A) First Loosen set screw (A), turn Tension of Thread Take-up spring (C) to zero, then turn Tension Stud (B) clockwise until spring (C) comes to the notch of Thread tension regulating busing and again turn Tension Stud (B) halfway back (counter clockwise) After the Adjustment tighten Set Screw (A).



旋松夹线调节座固定螺钉(B), 转动夹线器(C), 调节其摆动幅度。夹线器(C)顺时针转动, 摆动幅度增大, 反之则减少。
通常, 机器在出厂前、挑线簧均已调整好。只是在缝纫特殊的缝料或特殊的缝线时, 才需要重新进行调整。

2) Adjusting the thread take-up (C) clockwise to increase the stroke or turn stud (C) Counter-clockwise to decrease the stroke. After the adjustment tighten Set Screw (B).

Before leaving the factory the thread take-up spring has properly been adjust. Re adjustment is needed only in the case of special material or special thread.

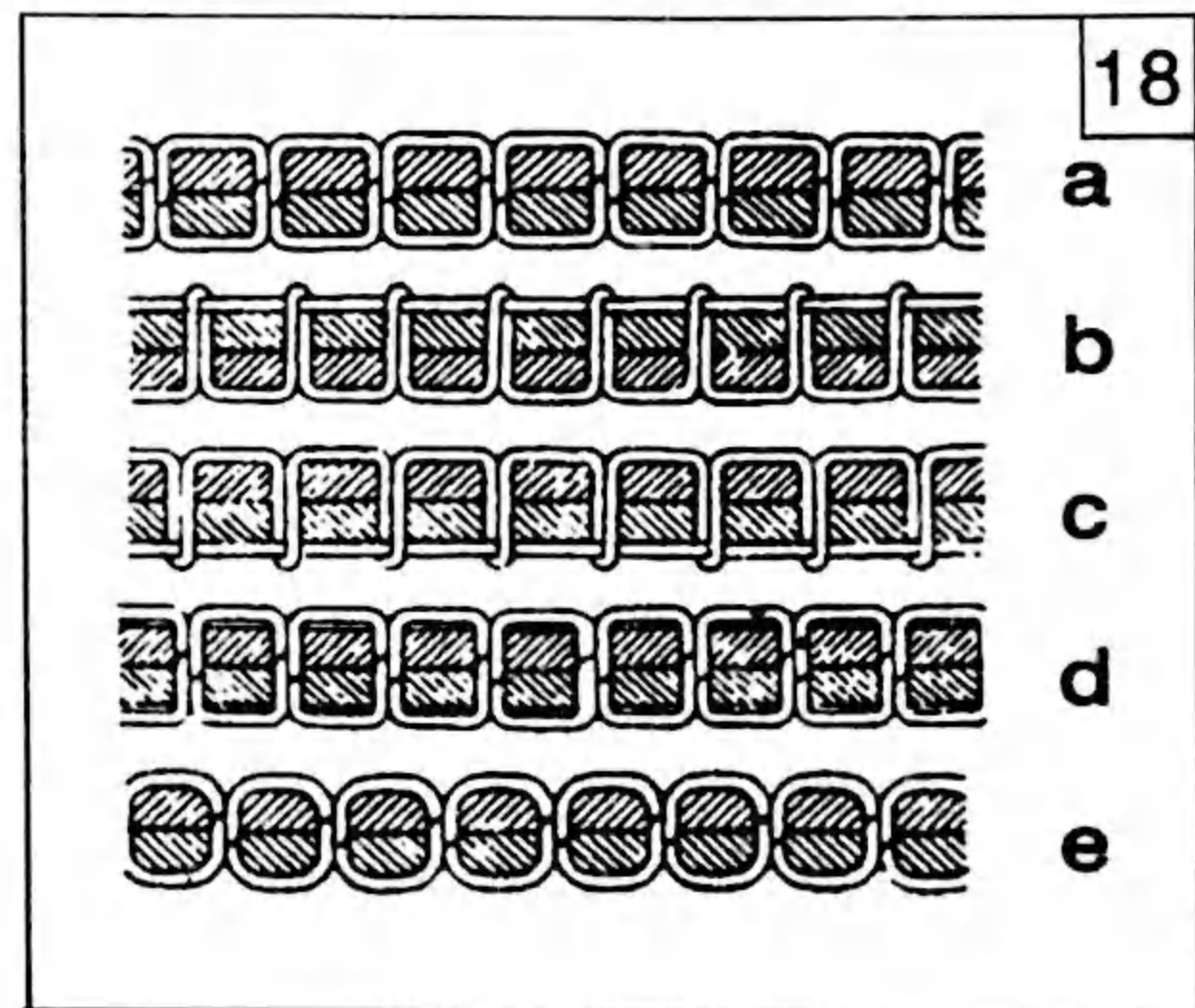


18. 底面线张力调节(图18,19,20) ADJUST THREAD GUIDE AND THREAD TENSION (Fig. 18,19,20)

线勾装配位置的调节, 关系到缝纫质量的优劣。线勾装配位置, 应适合缝料与缝纫条件。

The position of the thread guide affects stitch tightness and therefore must be adjusted according to sewing materials and sewing conditions.

	左勾 left side	中回 middle	右勾 right side
线勾位置 Thread hook position			
缝料 Sewing materials	厚料 thick materials	中厚料 thick materials	薄料 thin materials



缝纫机的正常线迹应该如图a, 如果线迹不正常, 会出现缝料起皱和断线现象, 应对底、面线的张力加以调节, 使之达到正常的线迹。

a 为正常标准线迹

b 为面线太紧底线太松的线迹

c 为面线太松底线太紧的线迹

d 为底面线太松

e 为底面线太紧

a. 如果面线太紧, 底线太松, 则应逆时针旋转夹线螺母, 放松面线的压力。或用小号螺钉起子、旋紧梭皮螺钉, 加大底线的压力。

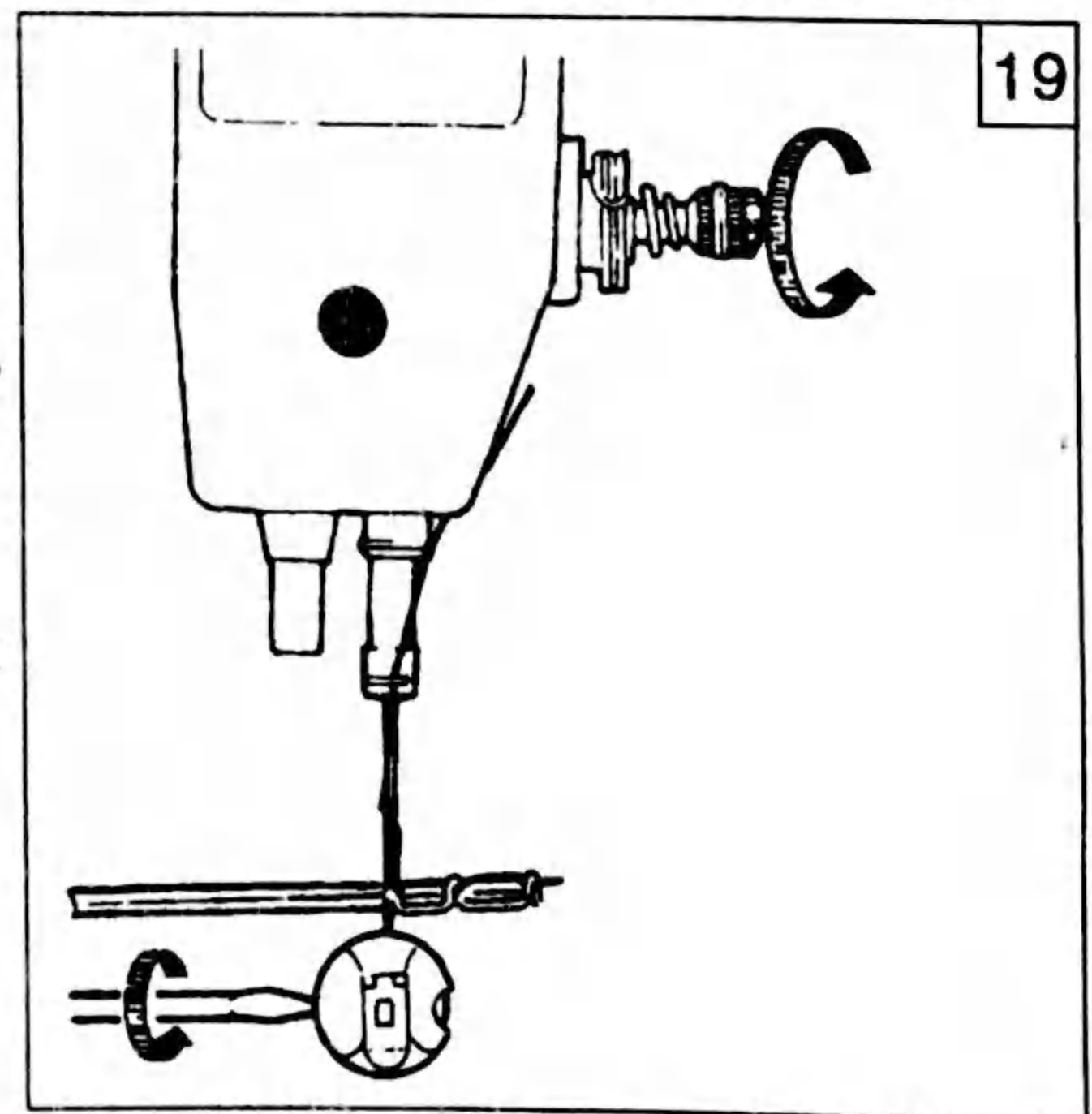
Fig.17 shows different different stitch forms. Normal stitch form should be as shown in Fig.17 (a). When abnormal stitch cause puckering and thread and thread break age.

The tension of needle thread and bobbin thread must be adjusted accordingly.

1) In case needle thread tension is too strong or bobbin thread tension is too weak. As shown in Fig.17 (b) turn the thumb nut counter clockwise to decrease. The needle thread tension or tighten the tension or tighten the tens on spring regulating screw of bobbin case to increase bobbin thread tension. (see Fig.18)

2) In case needle thread tension is too weak or baboon thread tension is too strong, as shown in Fig.17 (C), turn the thumb nut clockwise to increase the needle thread tension, or Loosen the tension spring regulating screw of bobbin case to decrease the bobbin threadtension.

3) In case of the stitch forms as shown in Fig.17(d) and (e) adjustment can be made with reference to the above means.

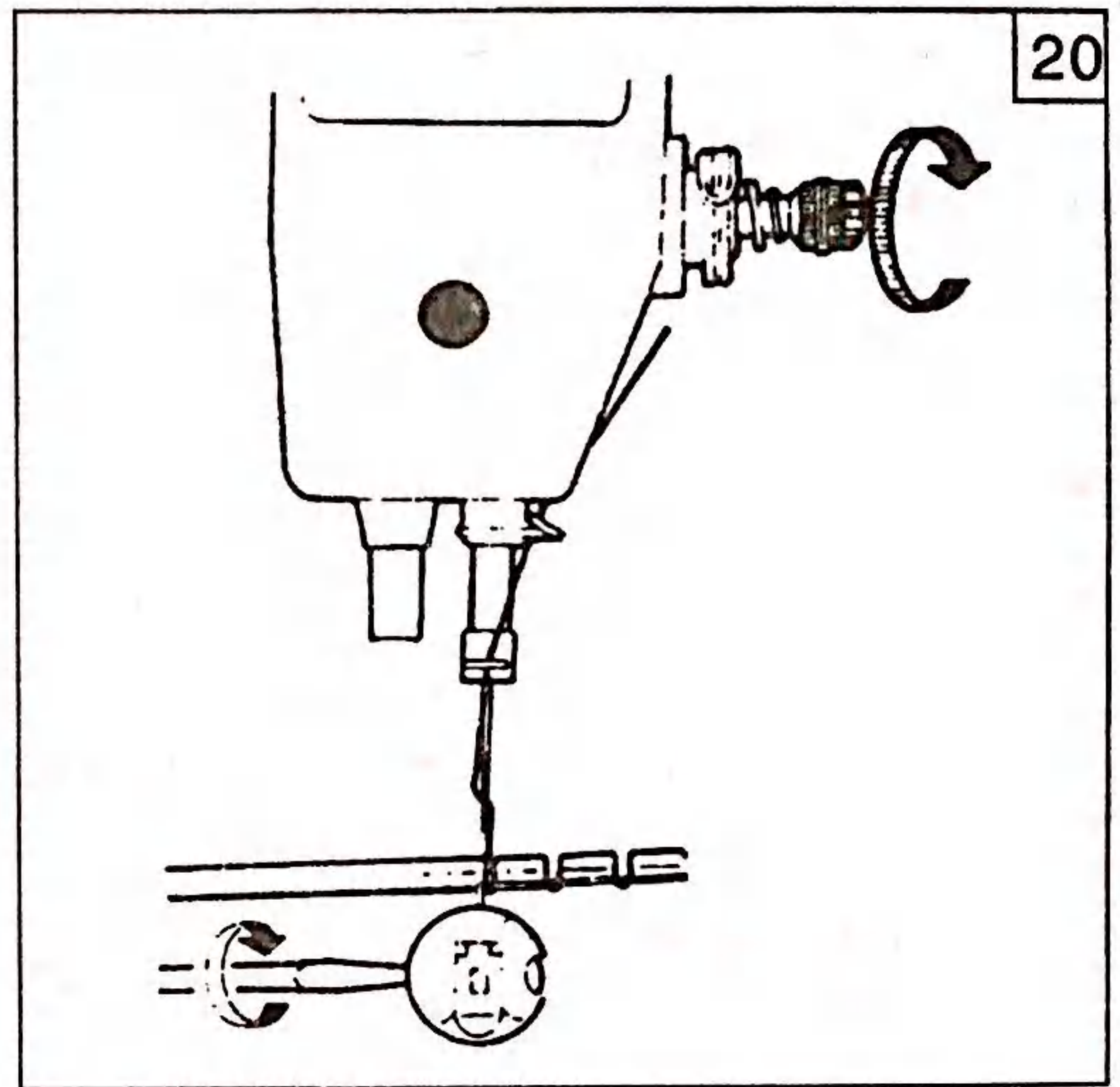


b. 如果面线太松，底线太紧，则应顺时针旋转夹线螺母，以加大面线的压力或用小号螺钉起子，旋松梭皮螺钉，减少底线的压力。

c. 如出现图d、e的线迹，也可以参照上述方法加以调节。

b. if the face thread is too loose. the bottom is too tighten. revolve the clipping thread screw conveniently. Strengthen face thread pressure or use little screw starter. Loosen shuttle screw reduce the bottom thread pressure.

c. if the tracks shaved in picture d. e. happen. You can adjust according to the above ways.



19. 机针与旋梭同步调整(图21,22,23,24) TIME NEEDLE TO ROTATING HOOK (Fig.21,22,23,24)

A. 机针位置的调节 Adjusting the needle position

用手转动主动轮，使针杆(C)下降至最低位置，卸下面板(A)上的橡皮塞，旋松针杆(C)上的针杆接头螺钉(B)，上下移动针杆(C)，初步定出同步位置(针杆的同步位置，当针杆下降至最低位置时，机针线孔的中心(D)应与旋梭内周面(E)在同一位置上。如图24所示位置)。旋紧针杆接头螺钉(B)，塞上橡皮塞即成。

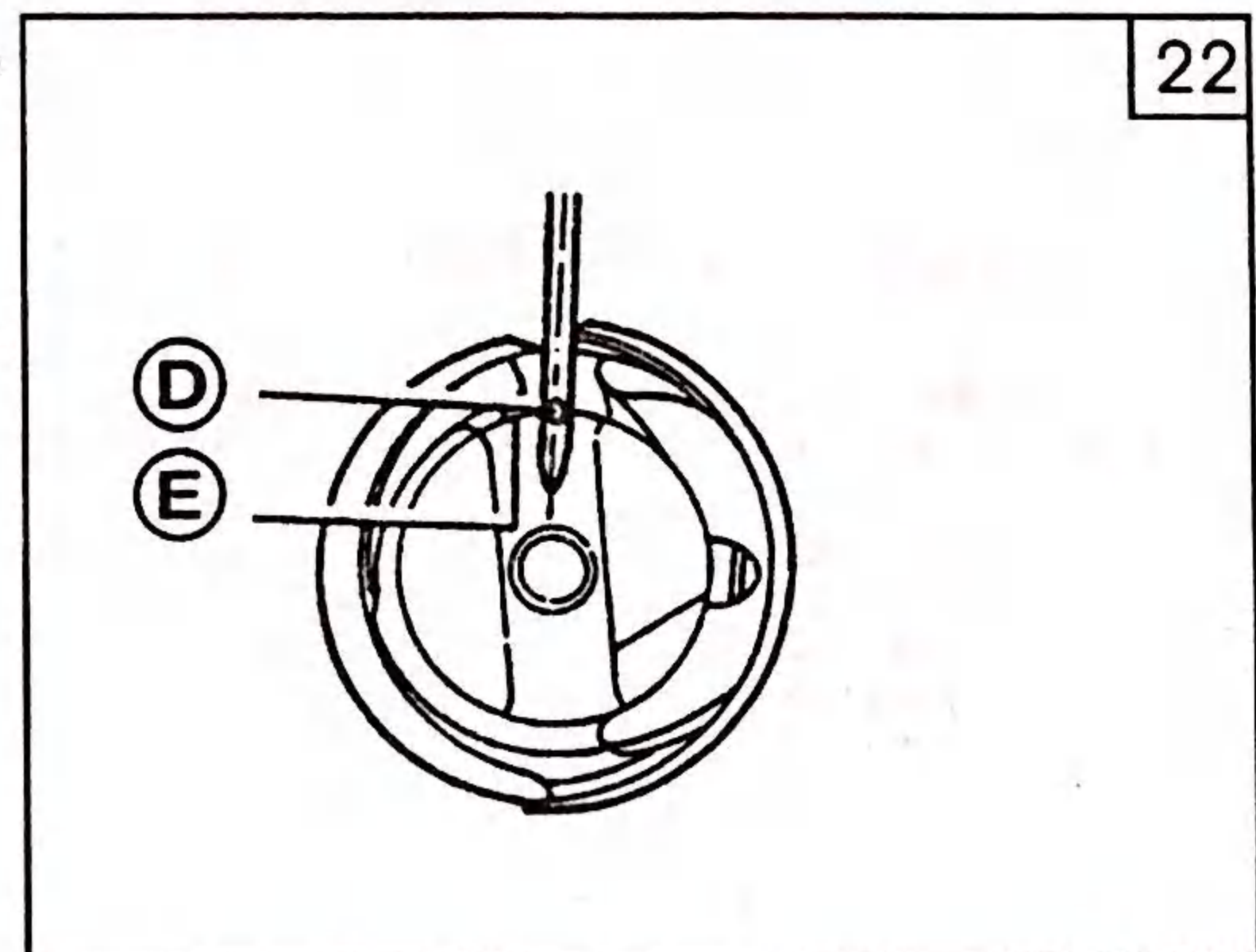
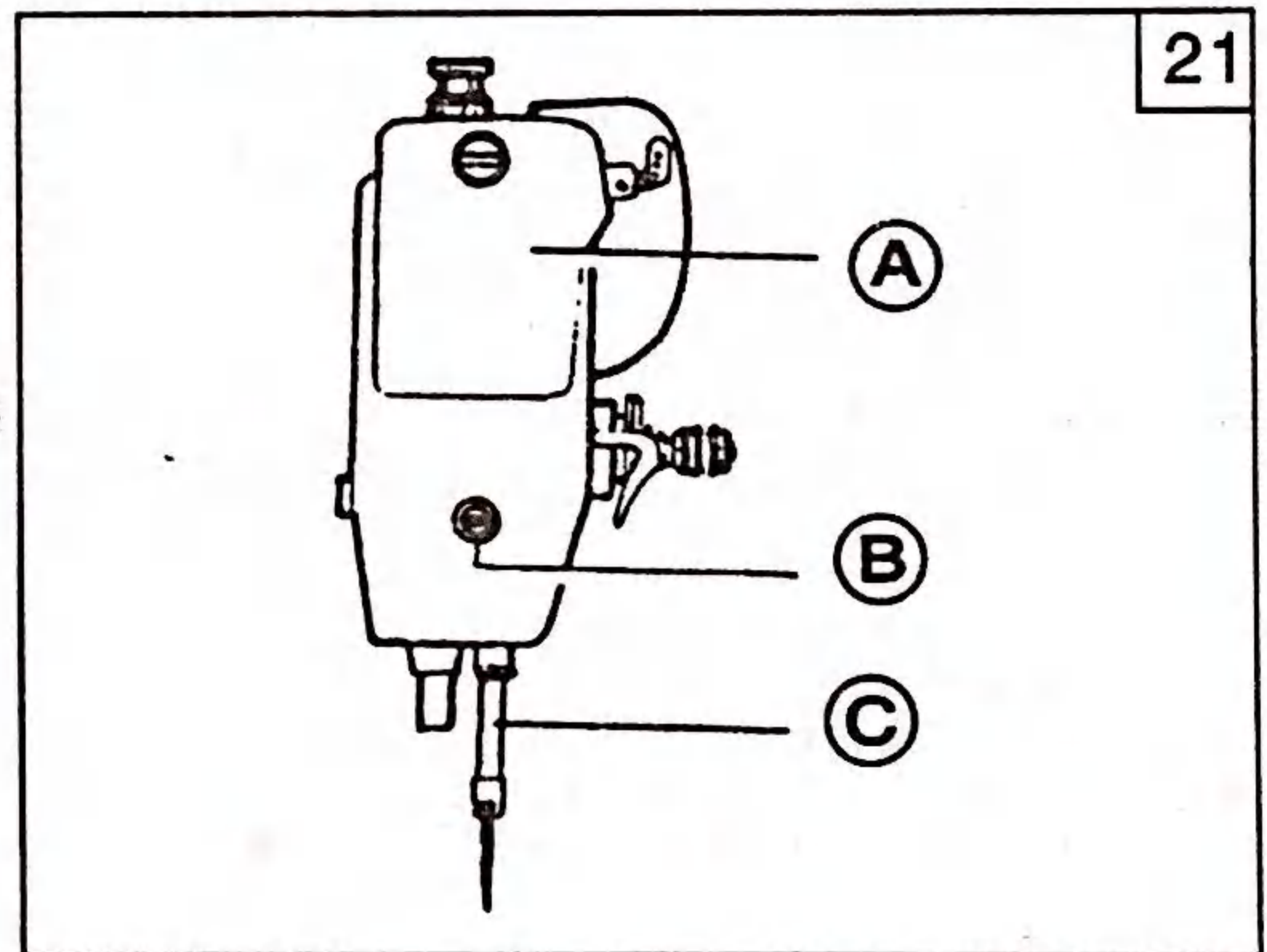
1) Turn balance wheel by hand to bring needle Bar (C) to the lowest position of its stroke.

2) Remove rubber plug from Face plate (A).

3) Loosen Set Screw (B) of needle bar adaptor.

4) Move Needle Bar (C) vertically to adjust needletiming.

5) After the Adjustment tighten set screw (B) and put in the rubber plug. The standard needle timing (see Fig. 18) is to align Tinning Mark (B) on the needle bar and the bottom of needle Bar Bushing (A) and meanwhile align the Inner Surface (E) of the hook and the canter of needle Eye (D) when the needle bar gets down to its lowest position.



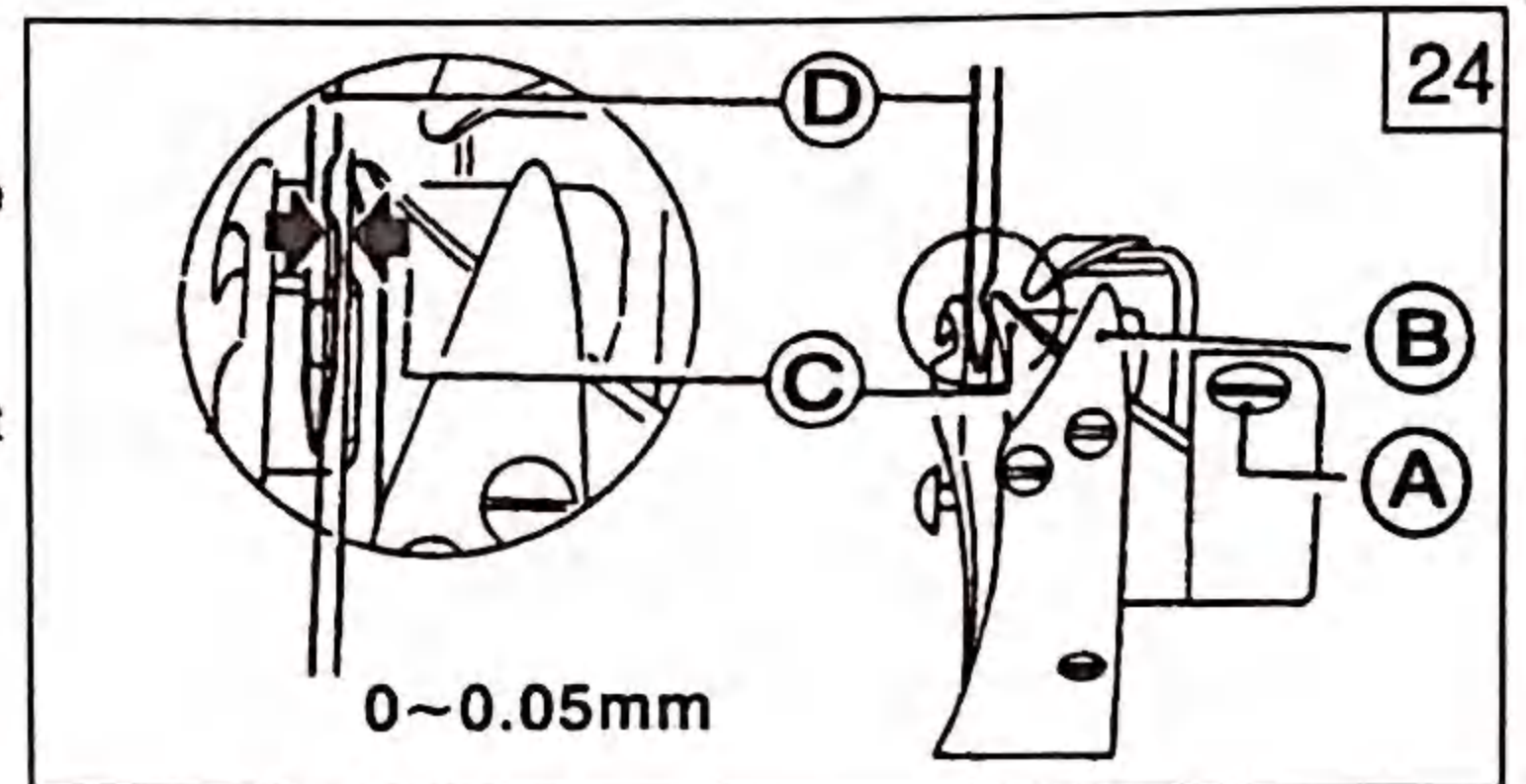
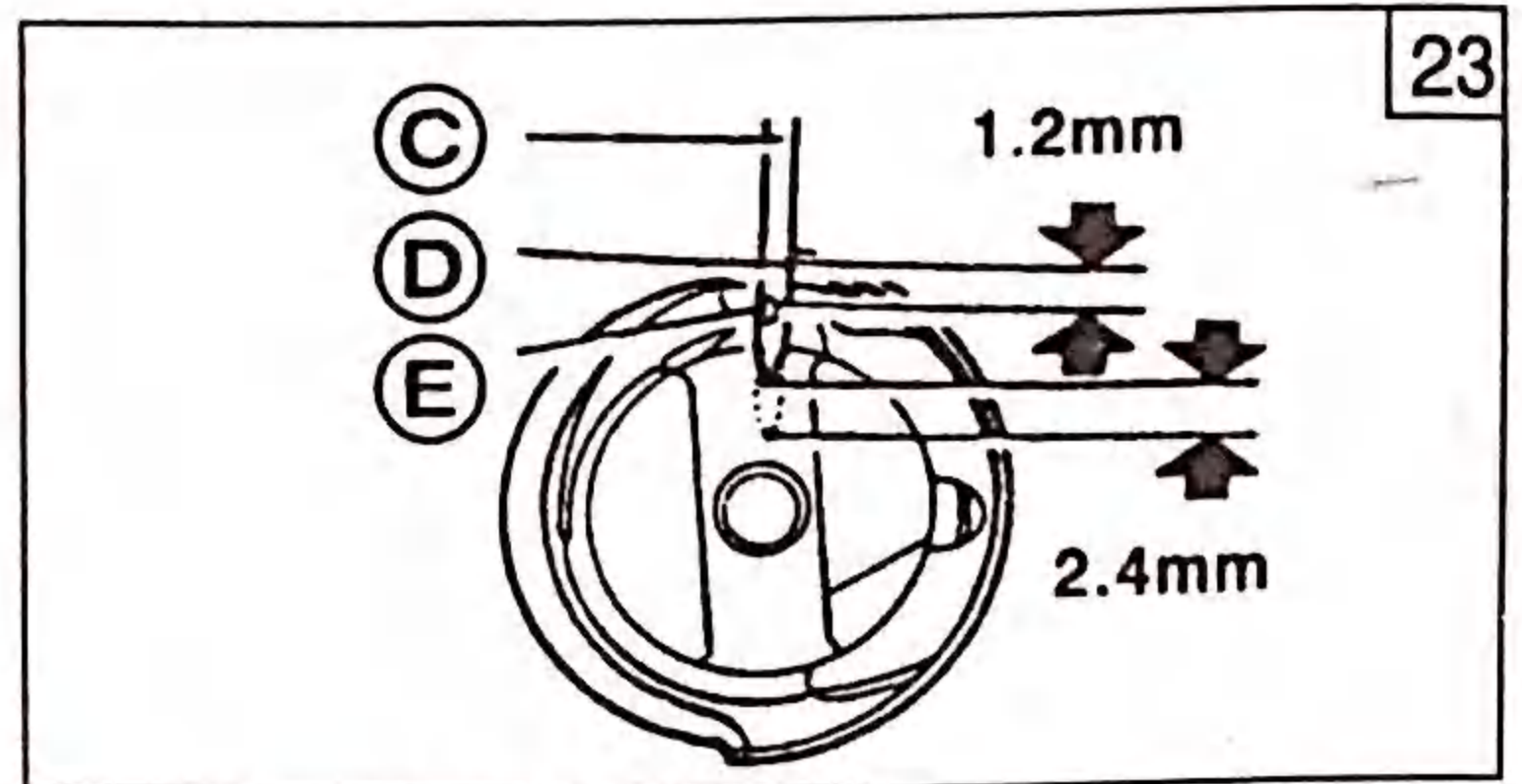
2. 旋梭同步的调节 Adjusting the hook point timing

旋梭和机针之间的相互运动，对缝纫性能有很大影响。标准的同步关系是：用手转动上轮，使机针向下运动到最低位置后再向上回升2.4毫米，这时旋梭钩线尖(D)，应与机针的中心线(C)一致，在此位置时，钩线尖(D)的下线与针孔的上线间距为0~0.5mm。

在调节旋梭的同步关系时，还要注意到旋梭尖与机针的侧面间隙。机针(D)缺口，与旋梭钩线尖(C)的间隙为0.05毫米。

Timing of needle motion to rotating hook motion has a great effect on sewing performance. The standard hook point timing is to align Hook Point (D) and Needle Centreline (C) when Needle Bar (B) is lifted by 2.4mm from the lower end of its stroke Besides Hook Point (D) should be 1.0-1.5mm above the upper end of Needle eye (E).

When adjusting the hook point timing also notice that the clearance between the bottom of needle notch and Hook point (C) should be approx 0.05mm.

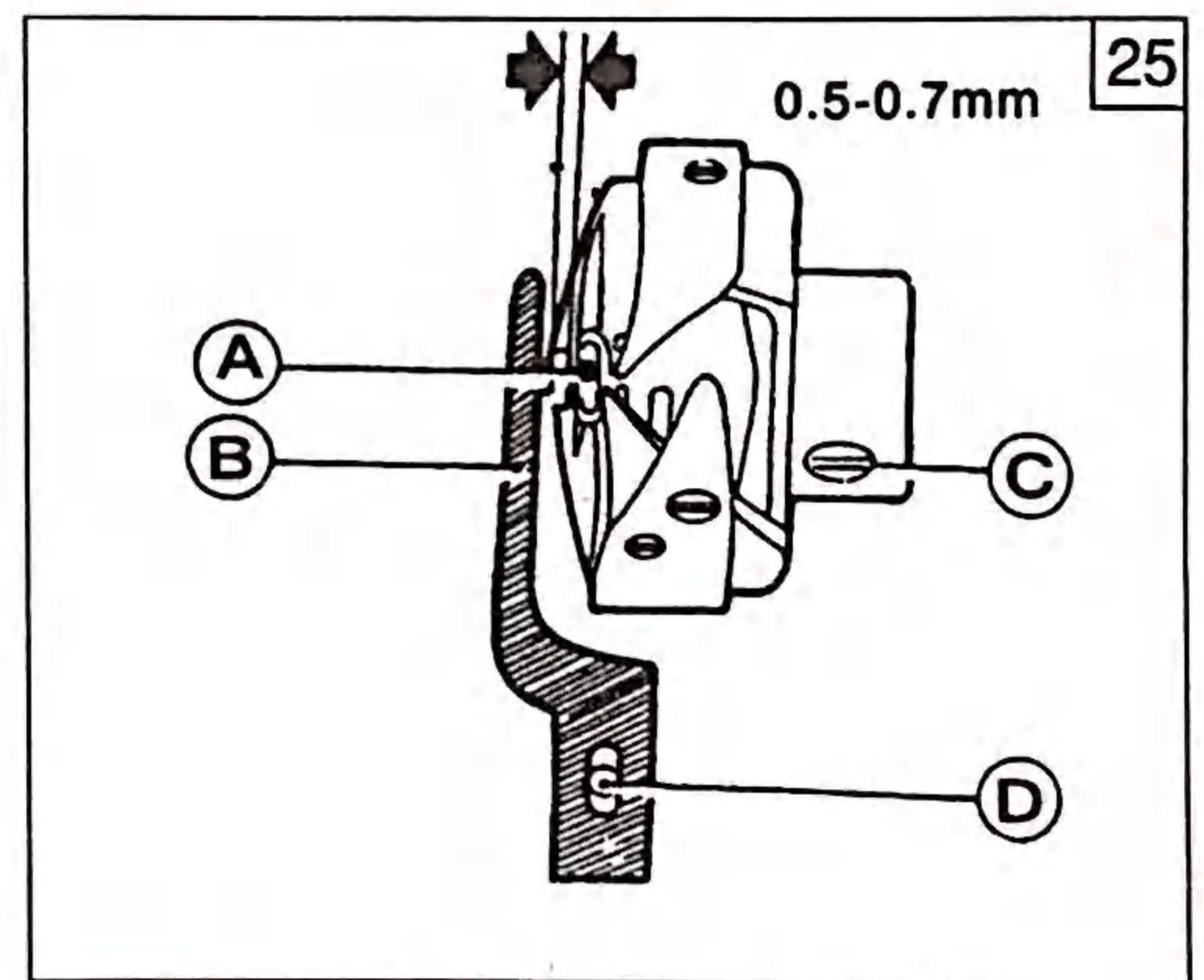


20. 旋梭装卸(图25) REPLACE ROTATING HOOK (Fig.25)

先将针杆上升到最高位置，拆下针板，取下机针和梭心套。旋开旋梭定位勾螺钉(D)，把旋梭定位勾(B)取下。再旋松旋梭螺钉(C)。使旋梭在轴上能够自由转动，接着用手转动上轮，使送料牙架走向高处。此时，可以用手旋转旋梭，把它取出。安装旋梭过程与上述过程相反。

旋梭定位勾的安装位置应是旋梭定位勾(B)的勾尖侧面与机针(A)的侧面应成一致。另外其两侧面之间隙为0.5~0.7毫米。

- 1) Lift needle bar to the highest position of its stroke.
- 2) Remove throat plate take down needle and bobbin case.
- 3) Loosen Screw (D) of hook positioner and take down Hook positioner (B).
- 4) Loosen two Screw (C) of rotating hook.
- 5) Turn balance wheel to raise feed bar to its highest position, then take down the rotating hook by turning it away from feed bar.
- 6) In stalling the hook can be done in reverse sequence. Note that Needle (A) should align with a clearance of 0.5-0.7mm between them.

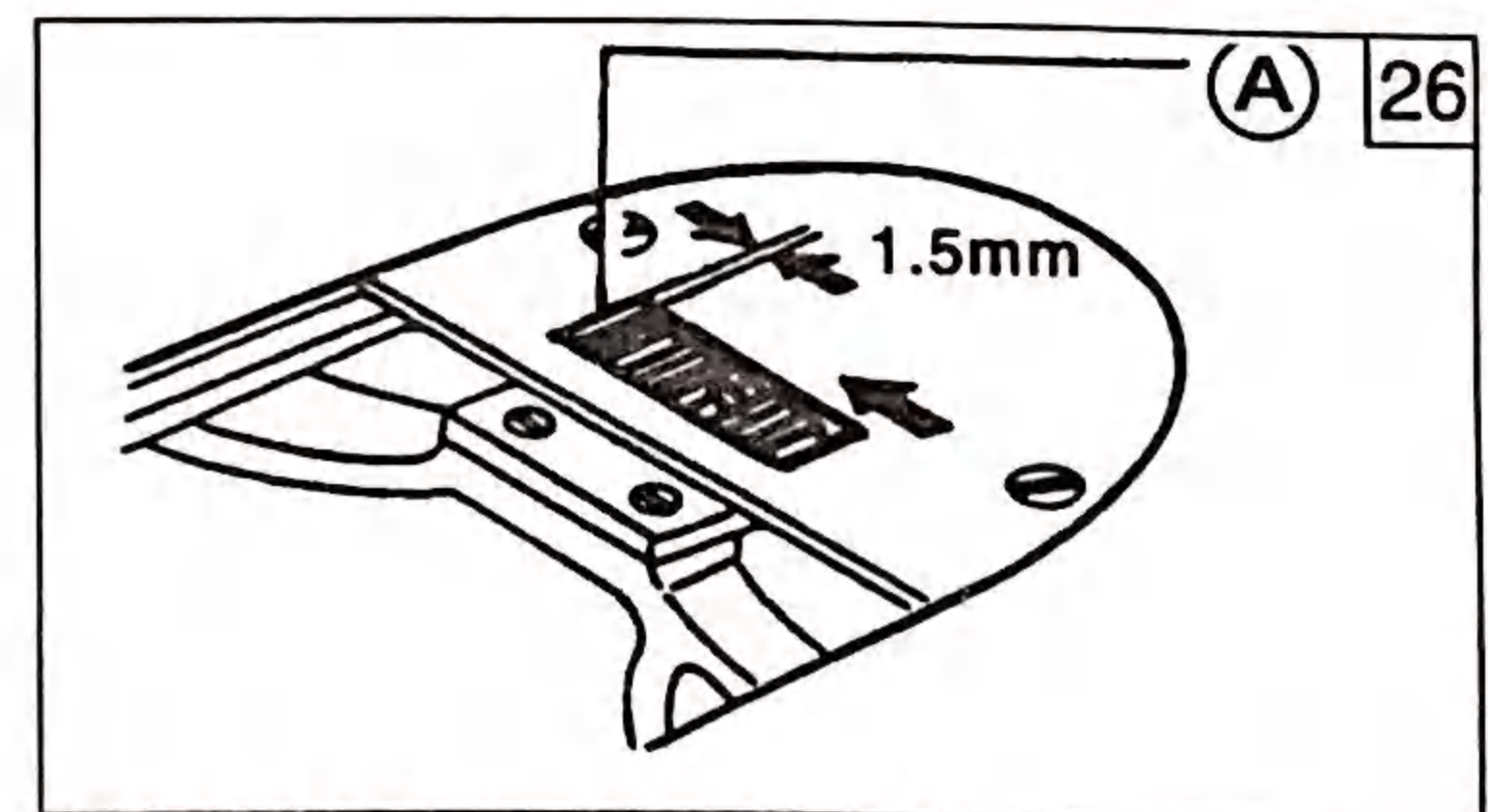


21. 送布牙安装(图26) ADJUST THE POSITION OF FEED DOG (Fig.26)

a.当送布量最大，送布牙(A)前端靠近针板槽前侧时，送布牙前端与针板槽前侧的间距为1.5毫米，这是标准的送布牙安装位置。

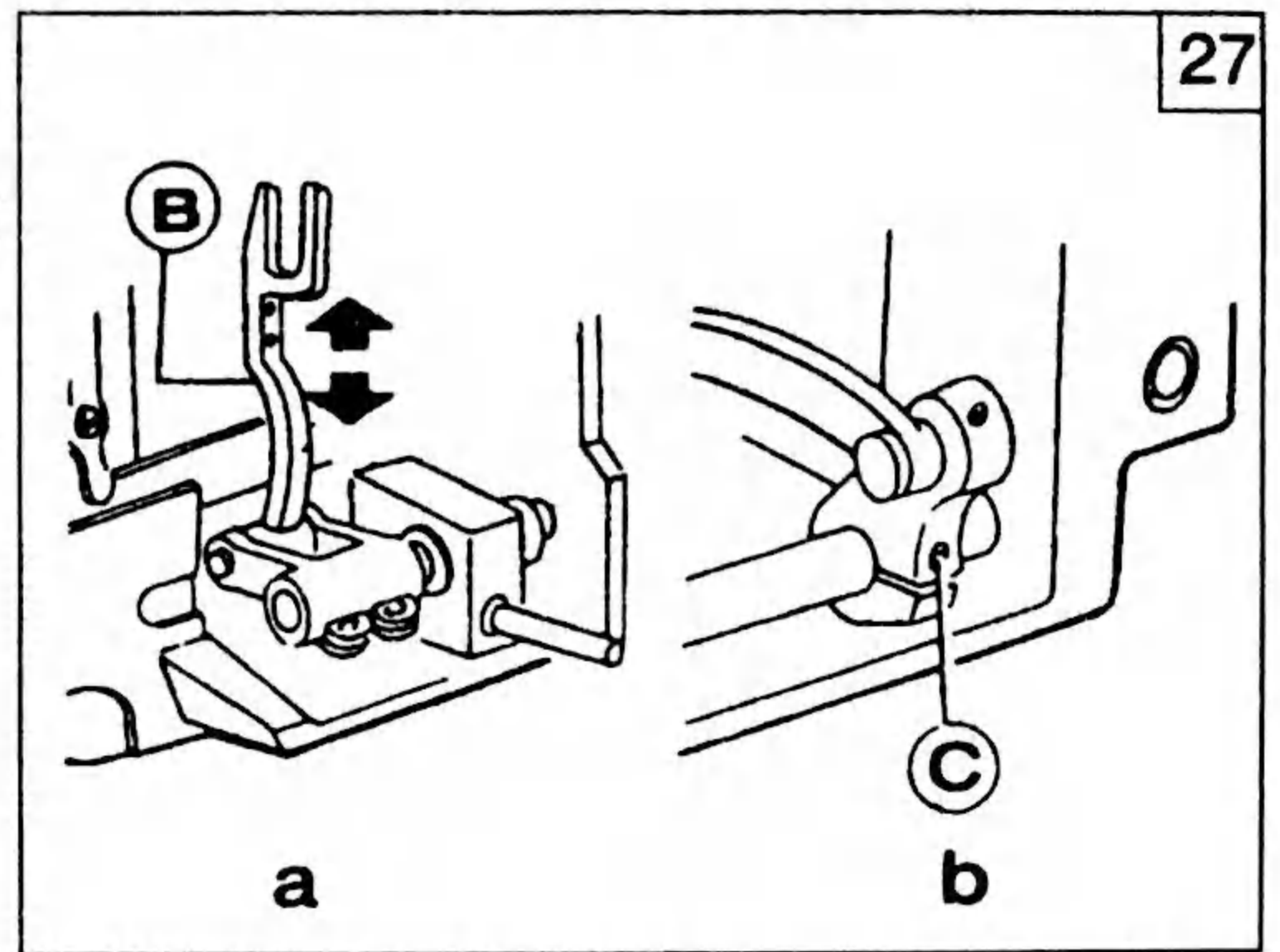
The standard position of feed dog is that the clearance between the front end of the throat plate slot and the first tooth of the fully advanced feed dog is 0.8mm.

- 1) Fully advance the Feed dog toward the front end of the throat plate slot.
- 2) Loosen Feed Rok shaft crank Screw (A) see Fig.25 (b)
- 3) Move Feed Bar (B) in the direction shown by the arrow in Fig.25 (a) to adjust the feed dog position.
- 4) After the adjustment be sure to tighten Screw (A).



b. 调节送布牙位置时, 先让送布运动至针板最前侧停止, 然后旋松送布轴曲柄螺钉(C)(见图29b), 将牙架(B)按图29a所示箭头方向移动, 以调节其前后位置, 调节好后, 再把螺钉(C)旋紧。

b. While adjusting the sending cloth teeth position At first stop the sending cloth movement to the needle board front Then loosen the sending cloth axis circuitous handle screw (C) (see in picture 296b) move the teeth frame (B) according to the picture 29a as the arrows direction Then adjust its front and book positions After adjusting well tighten the screw (c)



22. 送布牙斜度的调节(图28) FEED DOG HAIRLINE TALLY ADJUSTMENT (Fig. 28)

送布牙一般是水平位置, 高于针板平面0.8~1.2毫米, 当缝制条件需倾斜时应调节。

a. 旋松牙架曲柄轴螺钉(A)

b. 把螺丝刀放在牙架曲柄偏心轴(B)的槽里, 使偏心轴左右转动。

c. 调整好后将螺钉(A)拧紧。

当送布牙前面高时, 可防止布料皱缩, 不容易出现空针。

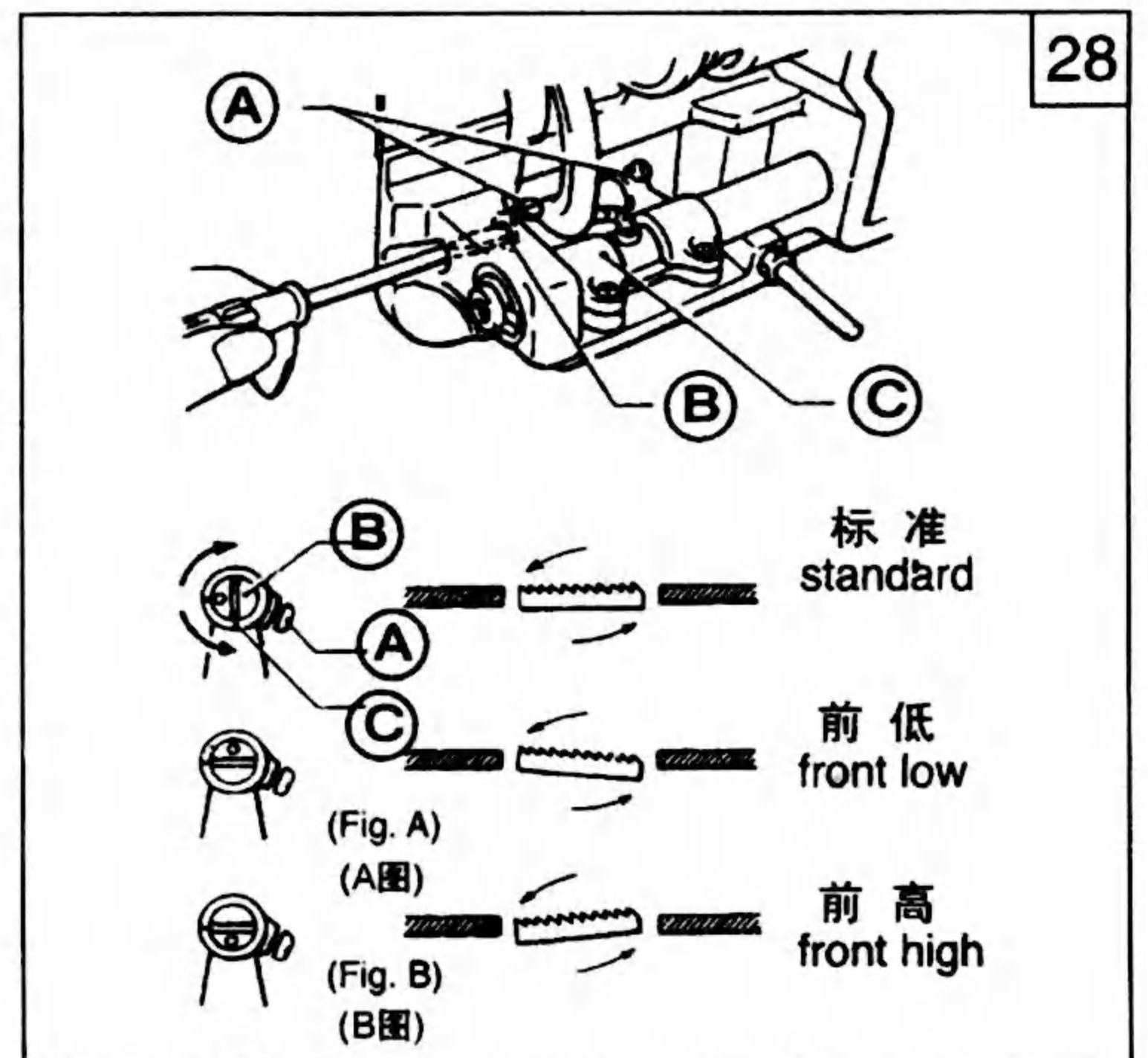
当送布牙前面低时, 可防止布料跑偏, 底线不易断。
Feed dog is common level recession 0.8~1.2mm higher than needle plate: Adjust as the following. When feed bog needs horizontally.

a. Loosen screw (A) of feed lifting rook shaft crank right.

b. After the adjusting pin to adjust the height of the feed dog.

c. After the adjusting be sure to tighten screw (A) Heighten the front of feed dog to me vent fabric from winking:

Lower the front of feed dog to me vent fabric from defection. Breaking of hook thread.



23. 针距误差调节(图31) STITCH LENGTH ERROR ADJUSTMENT (Fig. 29)

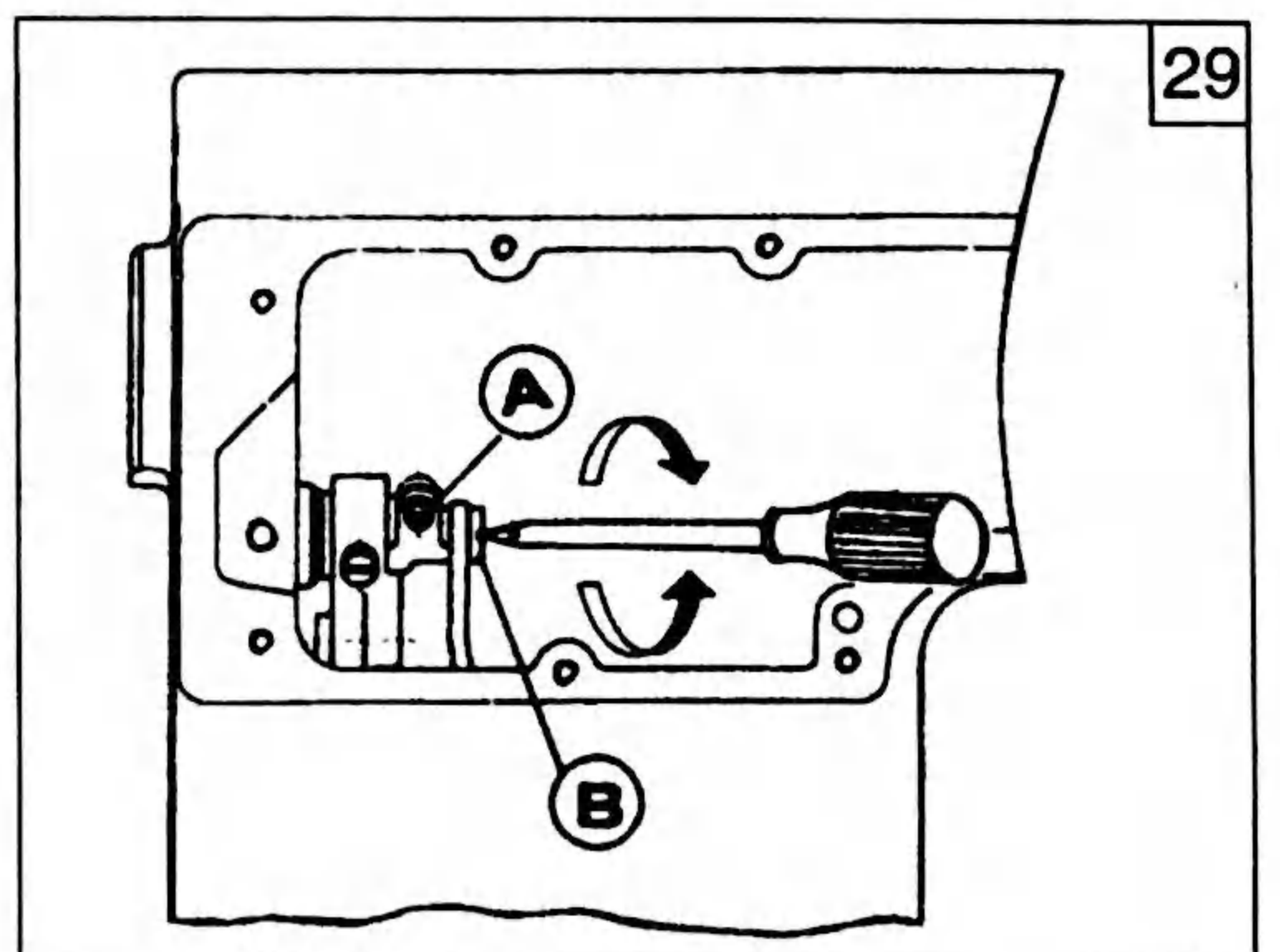
旋松螺钉(A)转动针距调节凸轮(B)。

顺时针转: --顺缝针距变大。
倒缝针距变小。

逆时针转: --顺缝针距变小。
倒缝针距变大。

Loosen screw (A) to adjust stitch length Adjusting can (B), Turn it rings ward to narrow the stitch length as forward sewing.

and widen the stitch length as forward sewing and narrow it as reverse sewing.



24. 送布同步调节(图30、31、32) TIME FEED SAM STEP ADJUSTMENT (Fig.30,31,32)

1. 标准位置 Standard position (fig.32)

让送布牙(B)从最高点下降与针板(A)的上面一致时, 针尖(C)呈以下状态时, 为标准状态。

中厚料: (见图a)

送布牙(B)的上面与针板(A)上面一致, 针尖正好与针板上面相平。

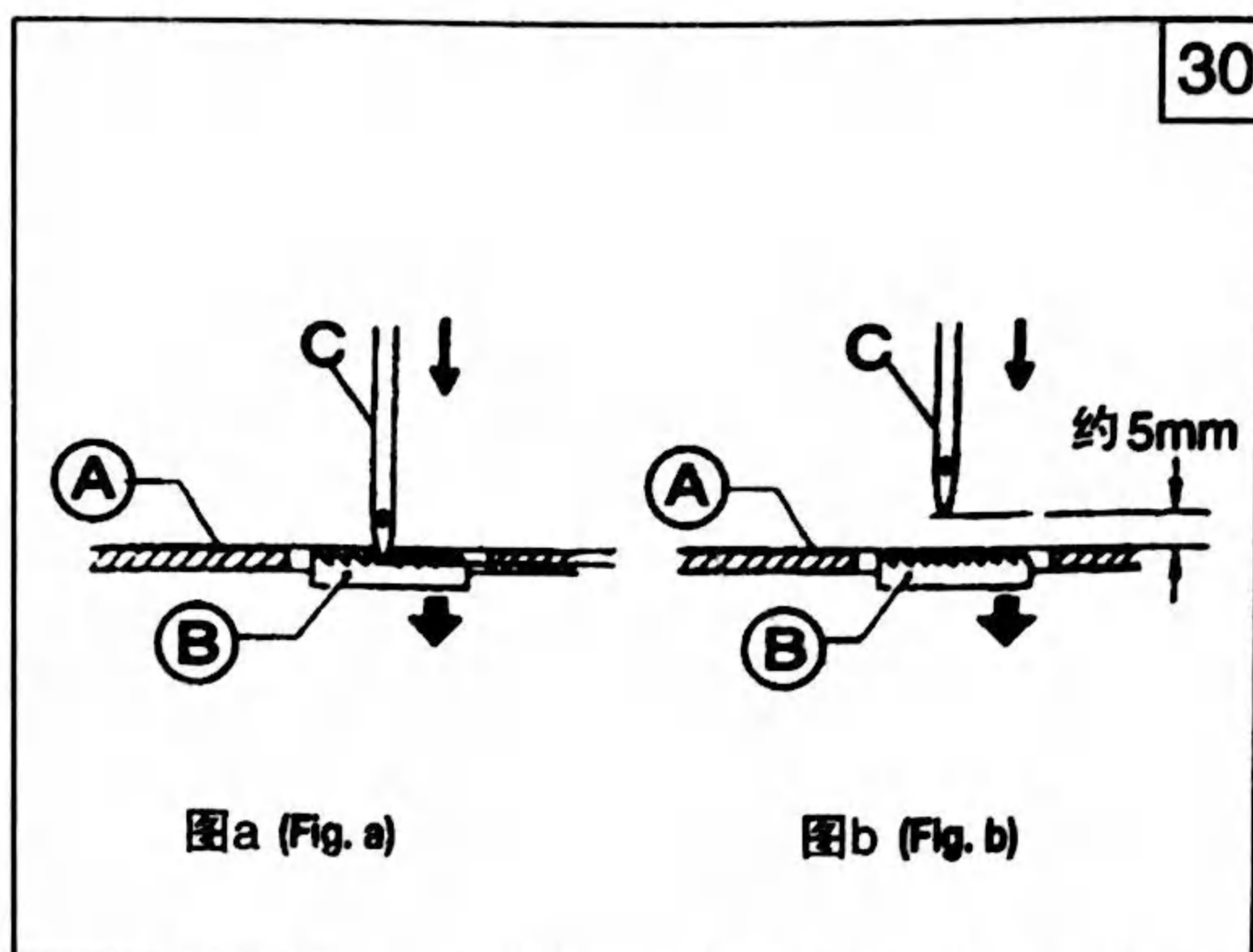
厚料及特厚料: (见图b)

送布牙(B)上面与针板(A)上面一致时, 针尖与针板(A)上面约有5mm间隙。

When feed dog (B) descends to the top-level of needle plate, needle goes down and needle point reaches.

(1) For medium material: needle point should arrive at the top-level of needle plate also

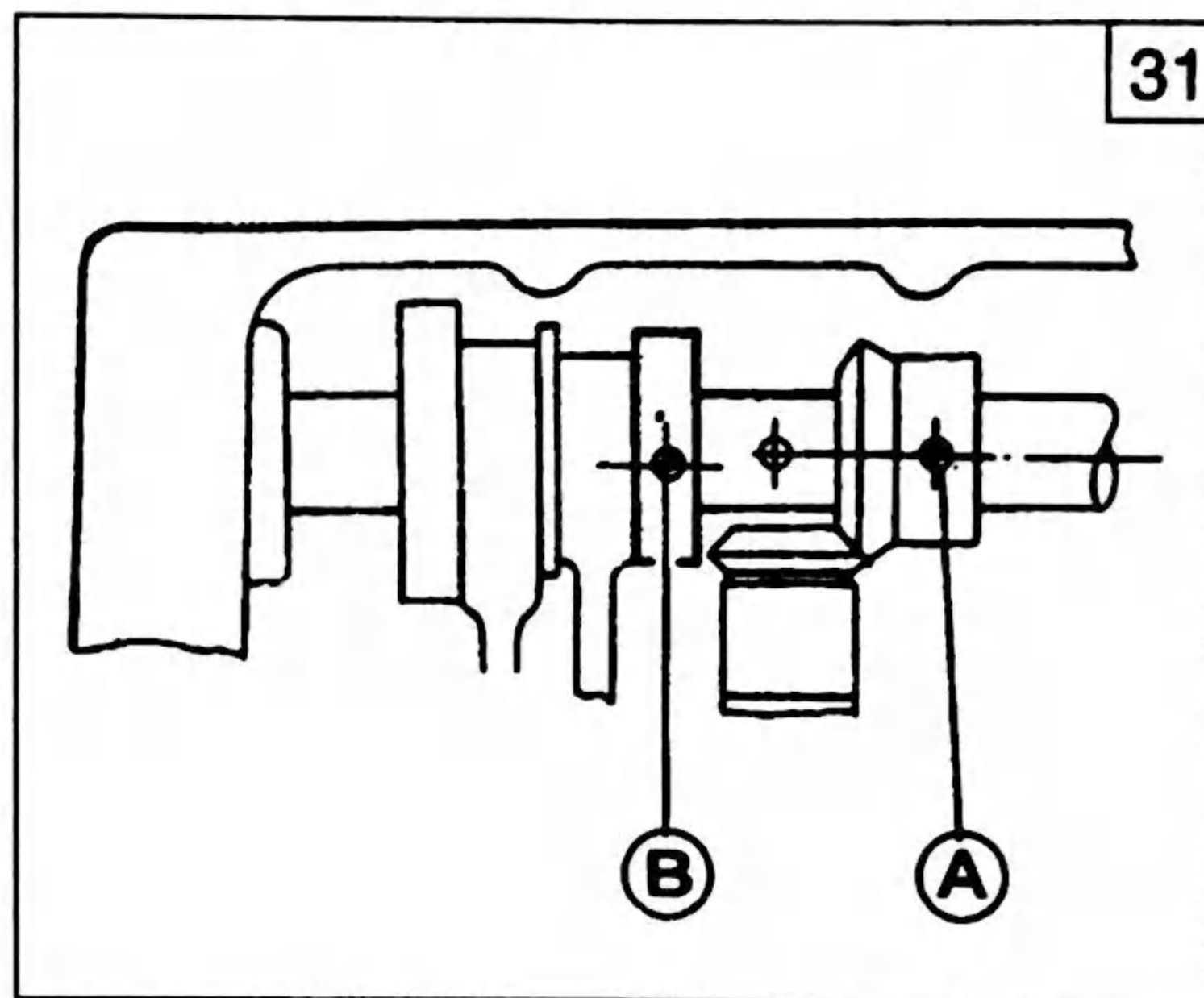
(2) for heavy material & super-heavy material: needle point should be 5mm above the needle palte.



2. 抬牙凸轮的安裝 To the feed-lifting cam (fig.33)

打开后盖板, 卸下挡油板, 用左手逆时针转动上轮, 以上轴齿轮第一只固定螺钉(A)为基准, 抬牙凸轮的第二只固定螺钉(B)中心, 将与其对齐, 稍微向下偏一点。

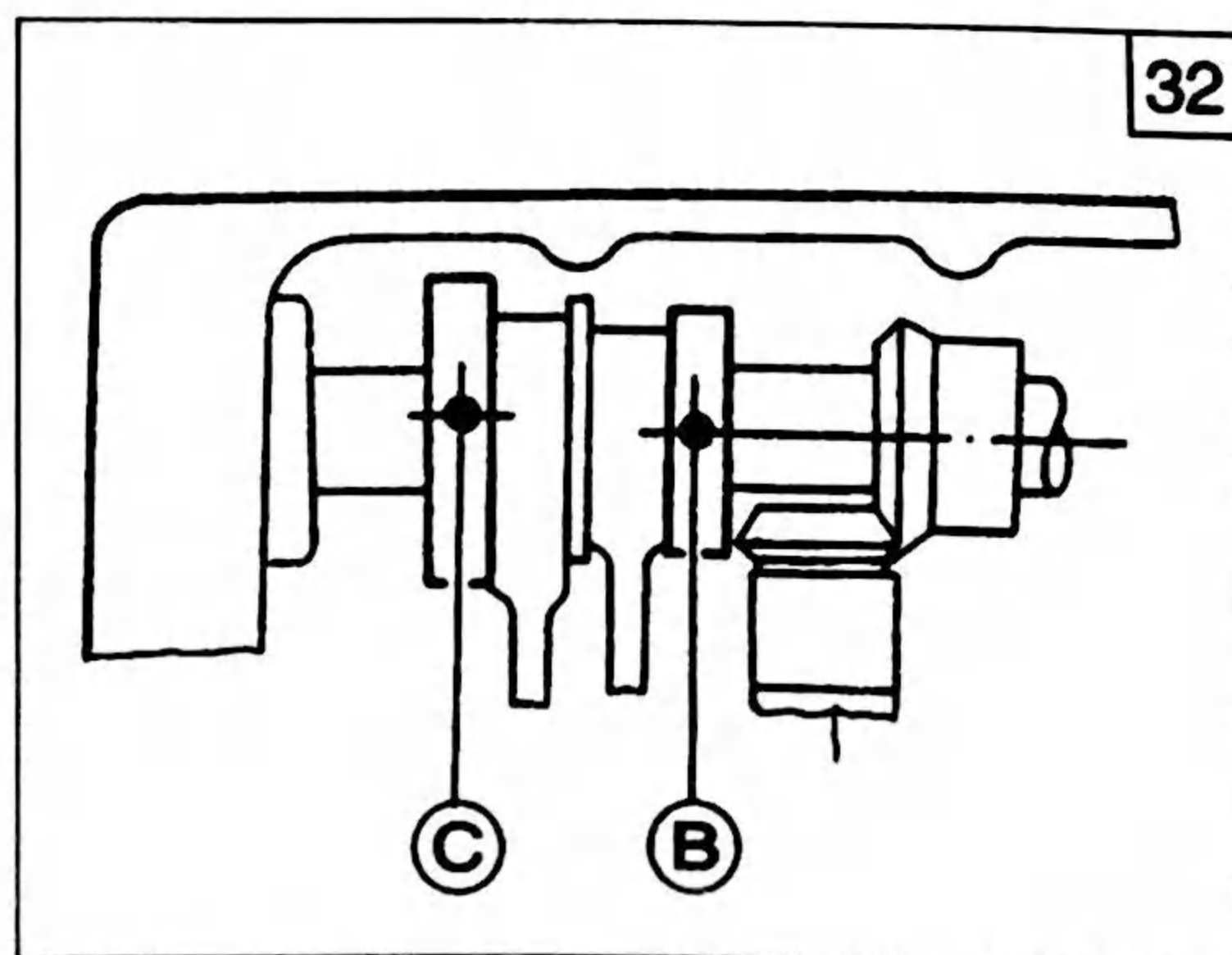
Disassemble the rear cover and the oil-stopping plate, turn balance wheel anti-clockwise, adjust the 3rd set screw of the upper spiral gear (B).



3. 送布凸轮的安裝 To set the feed-rock cam (fig.34)

继续逆时针转动上轮, 以抬牙凸轮第二只紧固螺钉(B)为基准, 送布凸轮的第三只紧固螺钉(C)中心, 将与其对齐, 稍微向上偏一点。

Turn the balance wheel anti-clockwise, adjust the screw (C) of feed-rock cam to keep line with (a little bit higher) the 2nd set screw of feed-lifting cam.

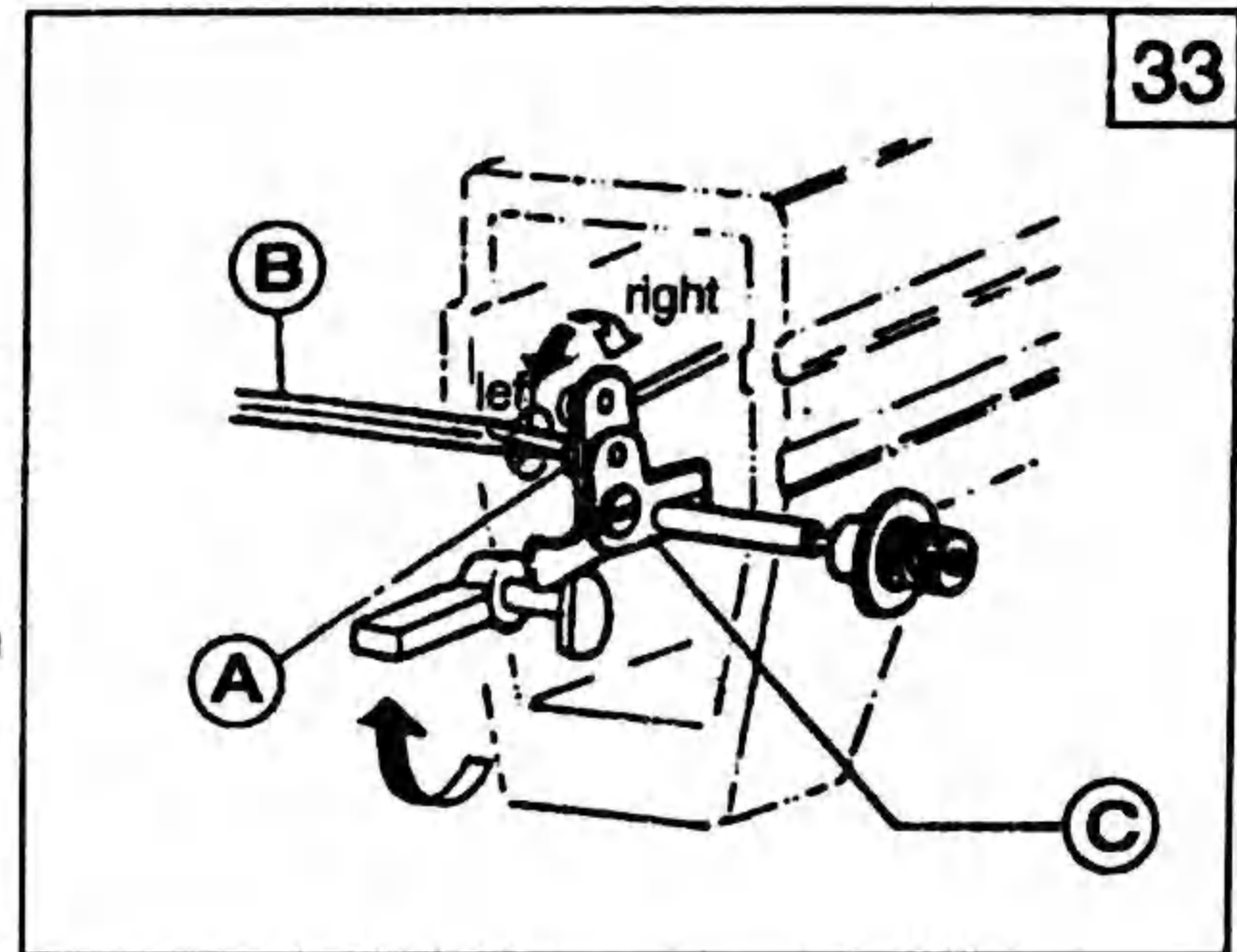


25. 松线器挺线调节(图33) ADJUST OPENING TIME OF THE TENSION DISCS (Fig.33)

压脚在提升范围内, 夹线器上的夹线板有一个张开期, 挺线的时间可进行调节。调节时, 先卸下机头背面的橡皮塞, 用螺丝刀(B)旋松膝控提升杠杆(左)螺钉(A), 这时松线凸轮(C)可以左右移动, 向右移挺线变慢; 向左移挺线变快。

Within the promoting range, there's an opening term on the clipping thread board of clip thread machine. The press foot can be adjusted during the sticking thread time. While adjusting, unload the rubber cork on the back of machine head first. Use the screw knife (B) to loosen the knee controlling promoting pole (left) screw (A).

At this time the relaxing thread convex wheel (C) can move to the left or right. To the right sticking threads slowly To the left sticking threads quickly.



26. 上送料机构的调节(图34) UP FEED MATERIAL ORGANISATION ADJUSTMENT (Fig.34)

上、下同步送料是该产品的重要性能之一。在缝纫过程中, 应根据各种缝料的摩擦系数和缝纫工艺的不同, 对上送料机构的摆压滑块与摆压脚轴的中心距(L)进行调节。

调节方法:

增大中心距L-上送料量增大。

减小中心距L-上送料量减少。

对于某些制品的特殊缝纫要求, 如缝件上层的送料量要求大于(或小于)下层的送料量, 也可以根据以上原理在一定范围内进行调节。

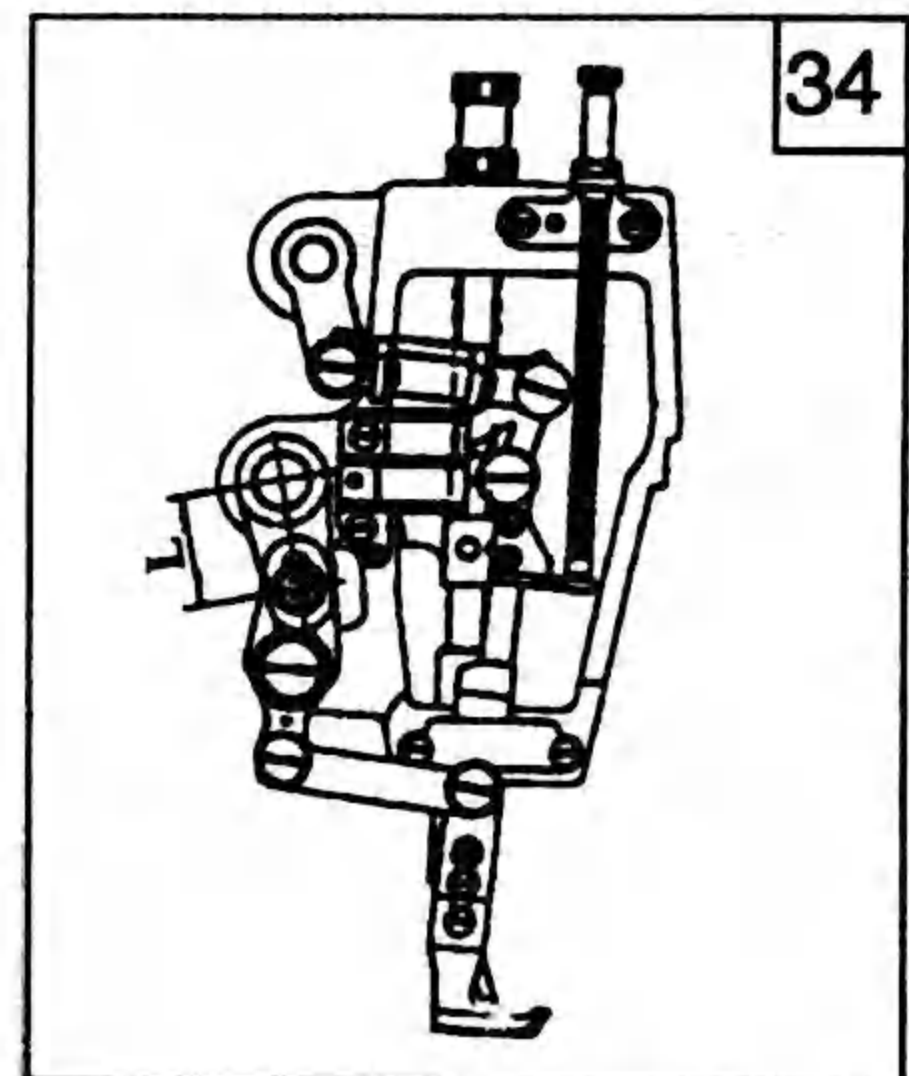
Synchronism of upper and lower feed mechanism is one important characteristic of this machine.

Operator should adjust the central-distance (L) between the upper feed rock shaft and feed rock slide block according to different material and stitch requirement method:

upper feed increase when enlarge L

upper feed decrease when shorten L

This can be applied accordingly when need upper feed more or less than lower feed.



27. 压脚交替提升机构调节(图35) PRESSER FOOT CROSS PROMOTING ORGANISATION ADJUSTMENT (Fig.35)

根据缝料疏松和致密程度的不同, 在缝纫中, 对摆压脚, 小压脚的交替提升量, 可在一定的范围内进行适当的调节。在一般的中厚料缝纫中, 摆压脚提升量在5.5mm之内, 小压脚提升量在3.5mm左右。当其它机构不变的情况下, 两压脚的提升量之和基本上是一定值。两提升量的变化近似于反比定律变化。即: 摆压脚的提升量增加, 则小压脚的提升量就减少, 反之亦然。

调节方法: 旋松偏心轮连杆调节曲柄螺钉A, 按图示顺时针转动压脚升降前曲柄, 摆压脚的提升量增大, 反之, 逆时针转动, 摆压脚的提升量减小。但其调节量有一定的范围限制, 不宜过大。调好后, 将螺钉拧紧, 用手转动上轮, 检查一切正常后方可使用。

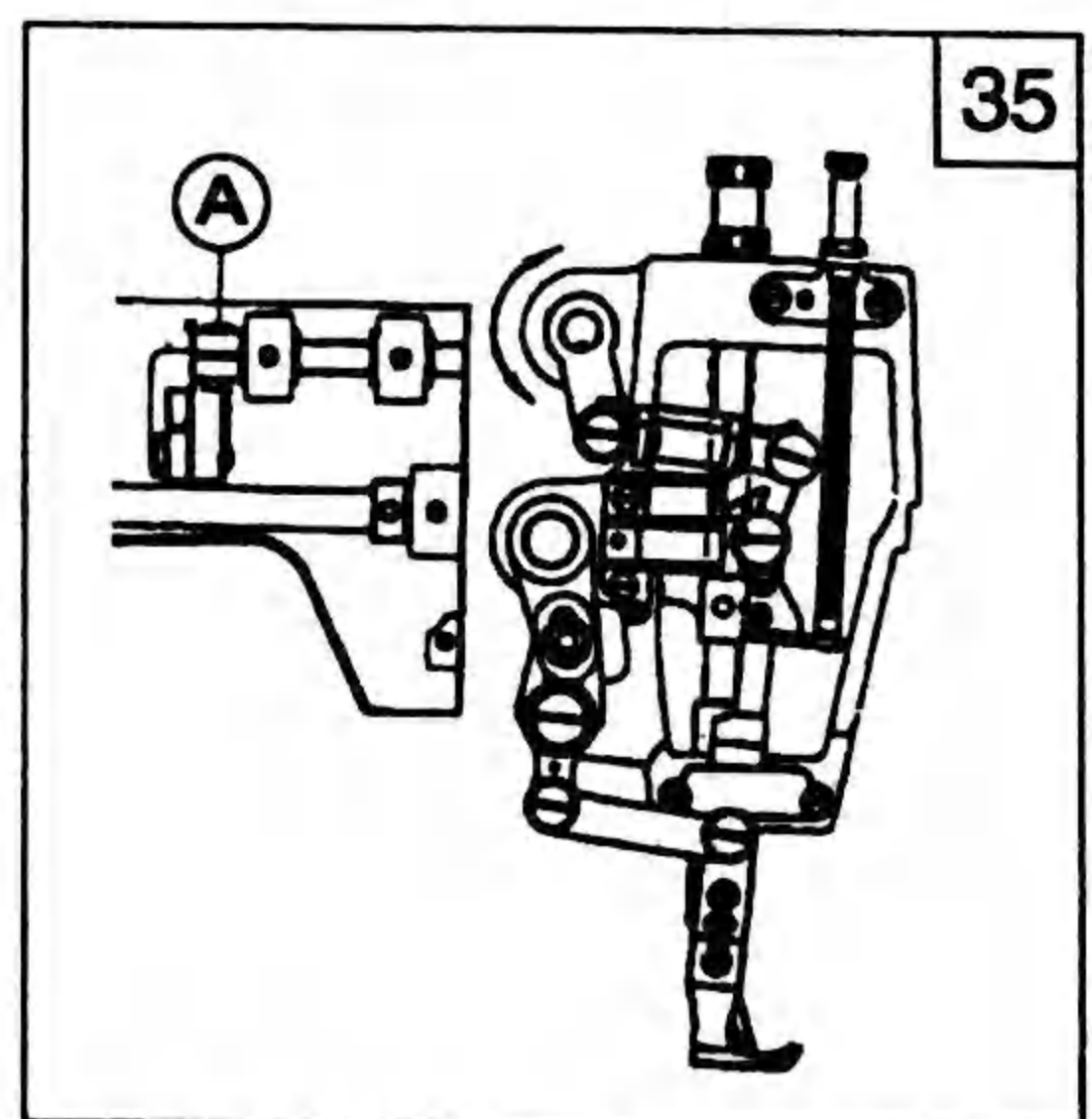
Principle: adjust the lifting height of inner and outer presser according to different material when necessary. For medium material, the outer presser lifting height should be less than 5.5mm. Generally the sum of these two height is certain. And when former increase the later decrease, and conversely.

Adjusting method: loose screw A

(1) when need to increase the outer presser height, turn clockwise the right presser-lifting crank

(2) when need to decrease the outer presser height, turn anti-clockwise the right presser-lifting crank.

But the amount of adjustment is limited. Adjustment, then the screw A. Turn the balance wheel to check whether the presser function well.



28. 摆压脚、小压脚总提升量的调节 OUT PRESSER FOOT AND INNER PRESSER FOOT LIFTING AMOUNT ADJUSTMENT.(Fig.36)

在缝纫过程中，要改变摆压脚、小压脚的总提升量，其调节方法是：先将偏心轮连杆螺钉(A)旋松，然后调节该螺钉与压脚升降轴中心距L：如果要使摆压脚、小压脚的总提升量都增加，则使中心距L变小；反之，则使中心距L变大。调节量有一定的范围，调节的幅度不宜过大，调节好后，将螺钉(A)拧紧，转动主动轮，检查有无异常声响，一切正常后方可使用。

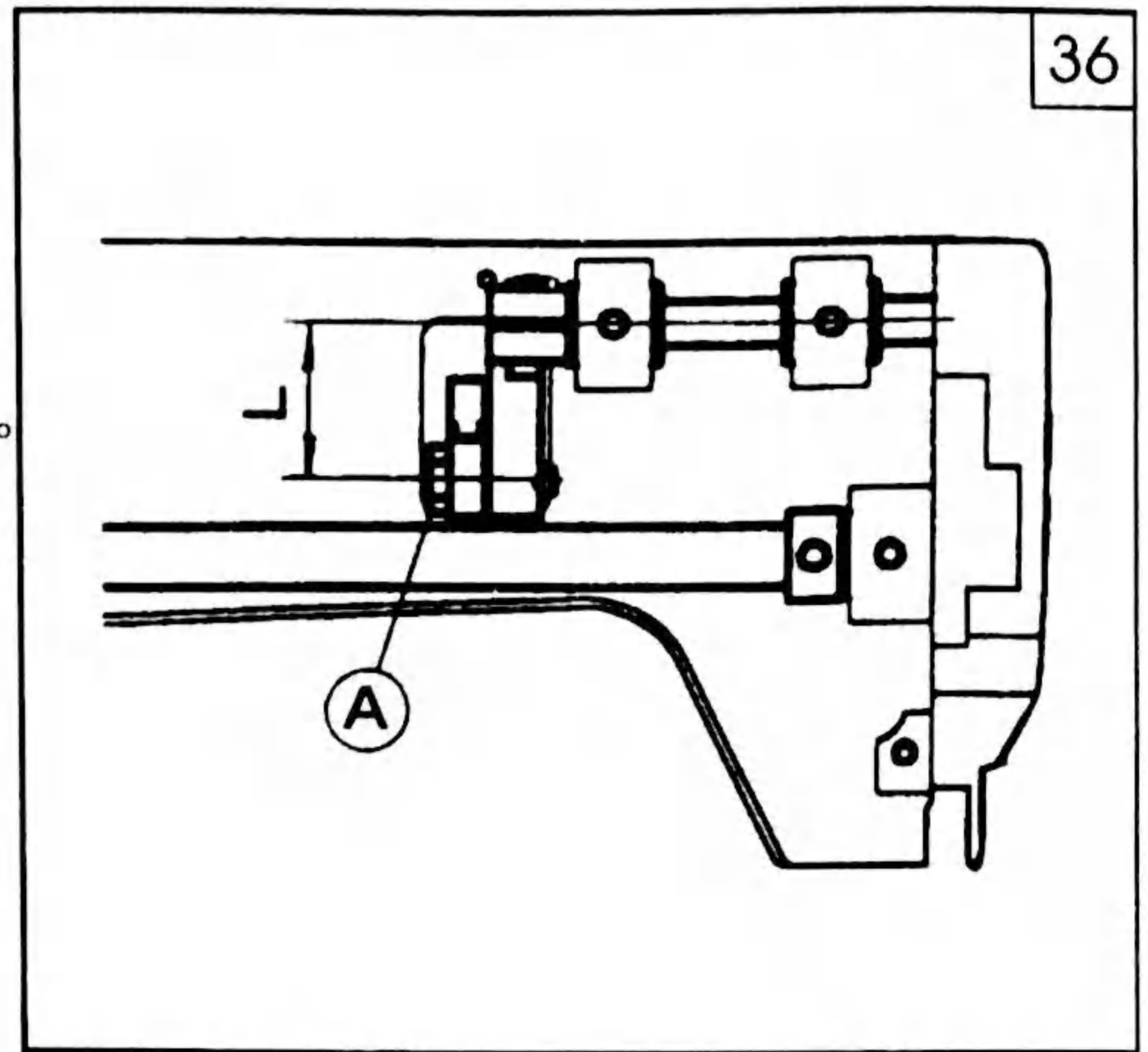
To adjust the total lifting height of outer and inner presser (Fig.36) Method: loose the screw A and adjust the central distance (L) between screw A and the presser lifting shaft.

(1) To increase the total height: to shorten L

(2) To decrease the total height: to enlarge L

The total adjusting amount is limited.

After adjustment, tighten screw A, turn balance wheel to check whether any -function occurs



29. 摆压脚、压脚前后方向间隙的调节(图37) OUT PRESSER FOOT AND INNER PRESSER FOOT FRONT AND BACK SPACING ADJUSTMENT.(Fig.37)

在缝纫过程中，有时用大针距缝纫、有时用小针距缝纫，在大针距缝纫时，摆压脚前后的行程比较大。反之，就小了。为了在缝纫过程中，使摆压脚槽的前端与小压脚后端面不碰撞，且保证有一定的间隙B(一般取1.5mm左右)。故在小针距缝纫时，需要摆压脚向上转动压脚摆动轴，则摆压脚就向针杆靠拢，调节时，应该注意间隙B的定值要求。

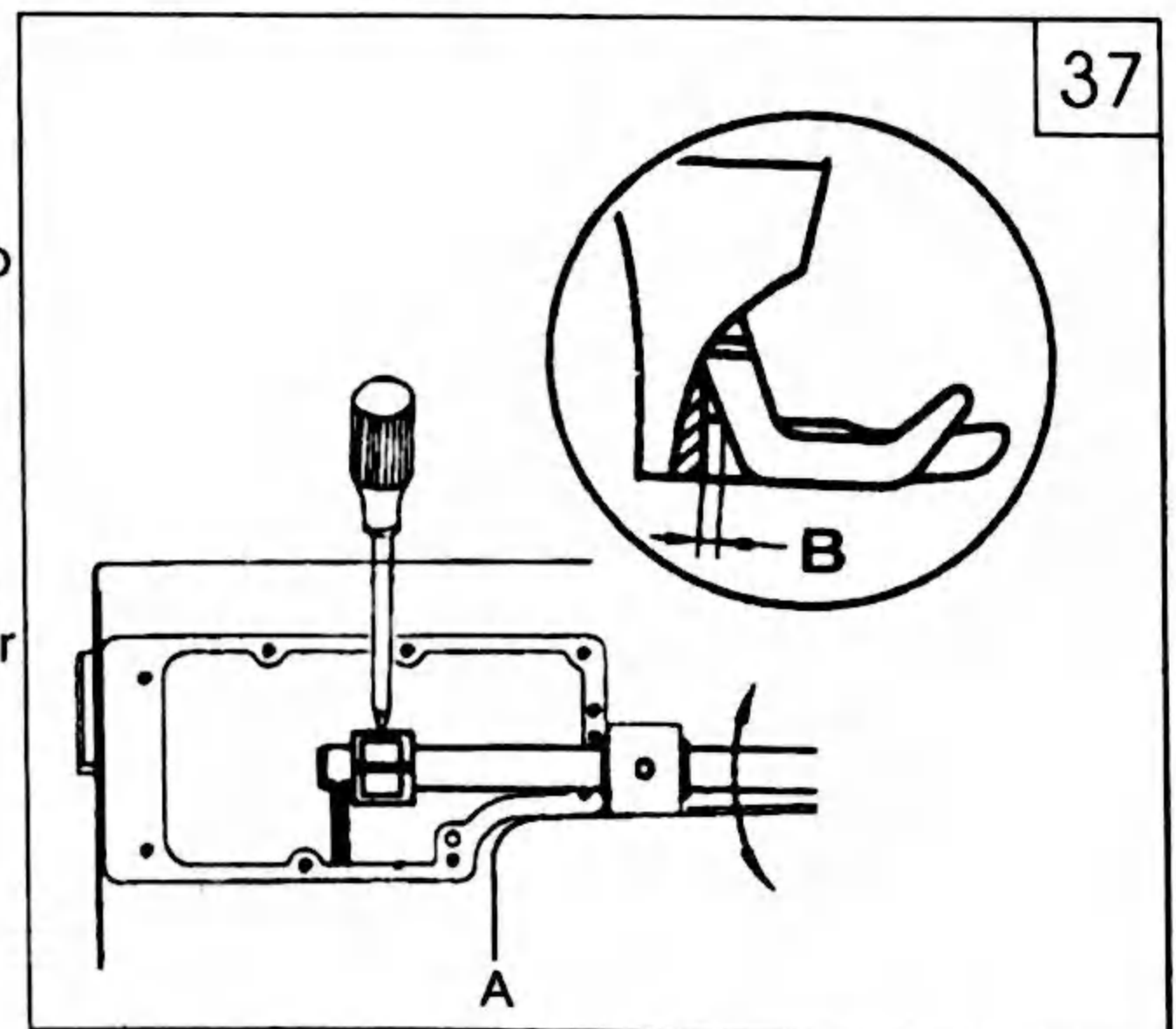
Since that different stitch length demanded according to different material and purpose, It is necessary to adjust the distance between the rear of inner presser and the trough valley of out presser, hence could the operator secure that the two presser keep certain space (generally around 1.5mm) and not to collide with each other. Therefore when sewing with short stitch, we need to made the outer presser be closer to the needle bar

Method:

loose the screw (A) as shown in fig.37, then turn the presser-lifting shaft

up-ward:

when adjusting, operator shall pay attention to the rehired space between the two presser.



30. 定期清扫(图38、39、40) CLEANING (Fig.38,39,40)

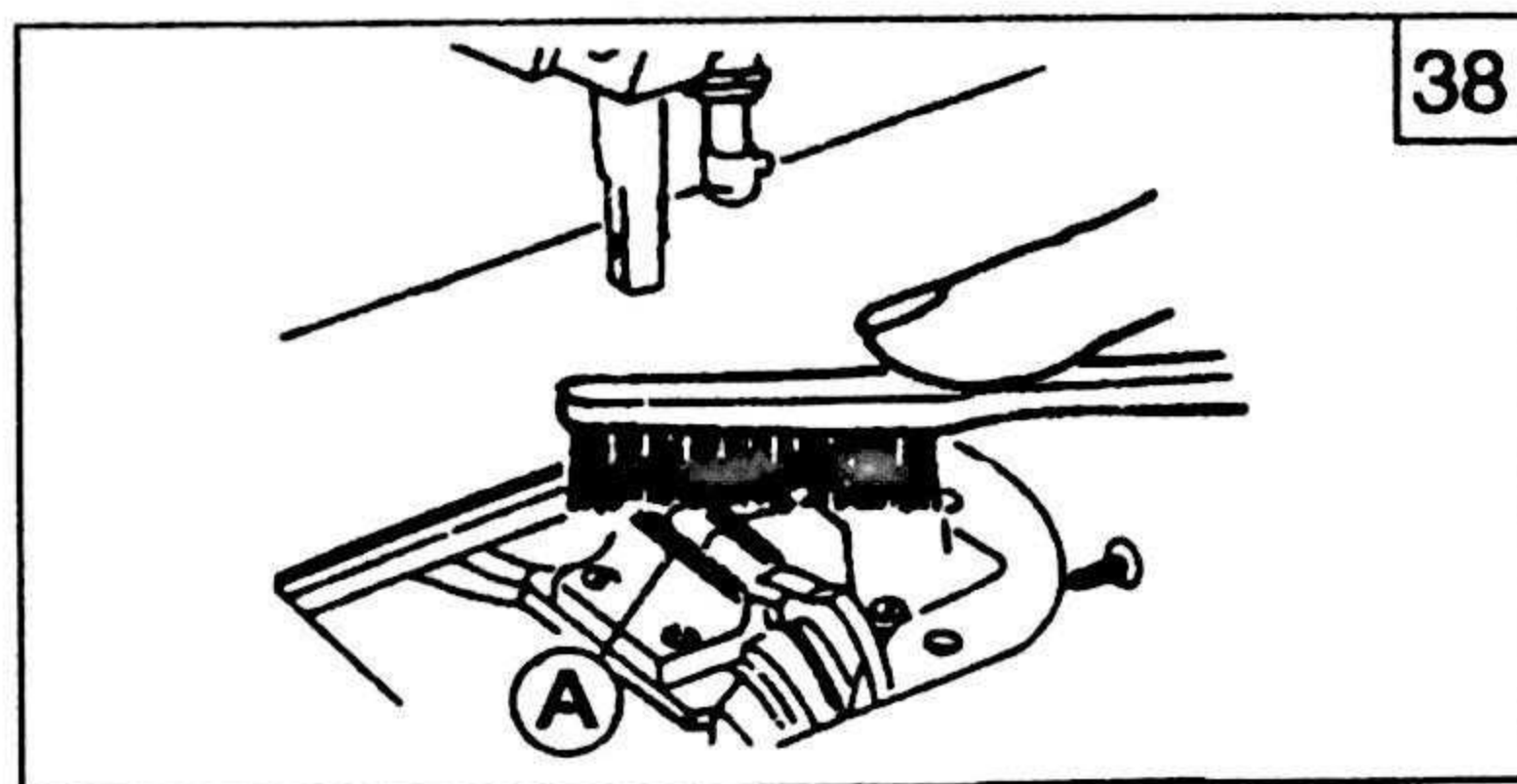
请根据使用程度，定期进行清扫送布牙，旋梭、梭心套和油泵滤网等。

According to the using degree. Please clean the sending cloth teeth revolving shuttle. shuttle heart set, oil pump filter net and so on in the foxed term.

1.送布牙的清扫Cleaning feed dog

先卸下针板，清除送布牙(A)间距(牙槽)内的污垢，然后再安好针板。

Remove the throat plate and clear off the dust and lint between feed dog tooth slots.

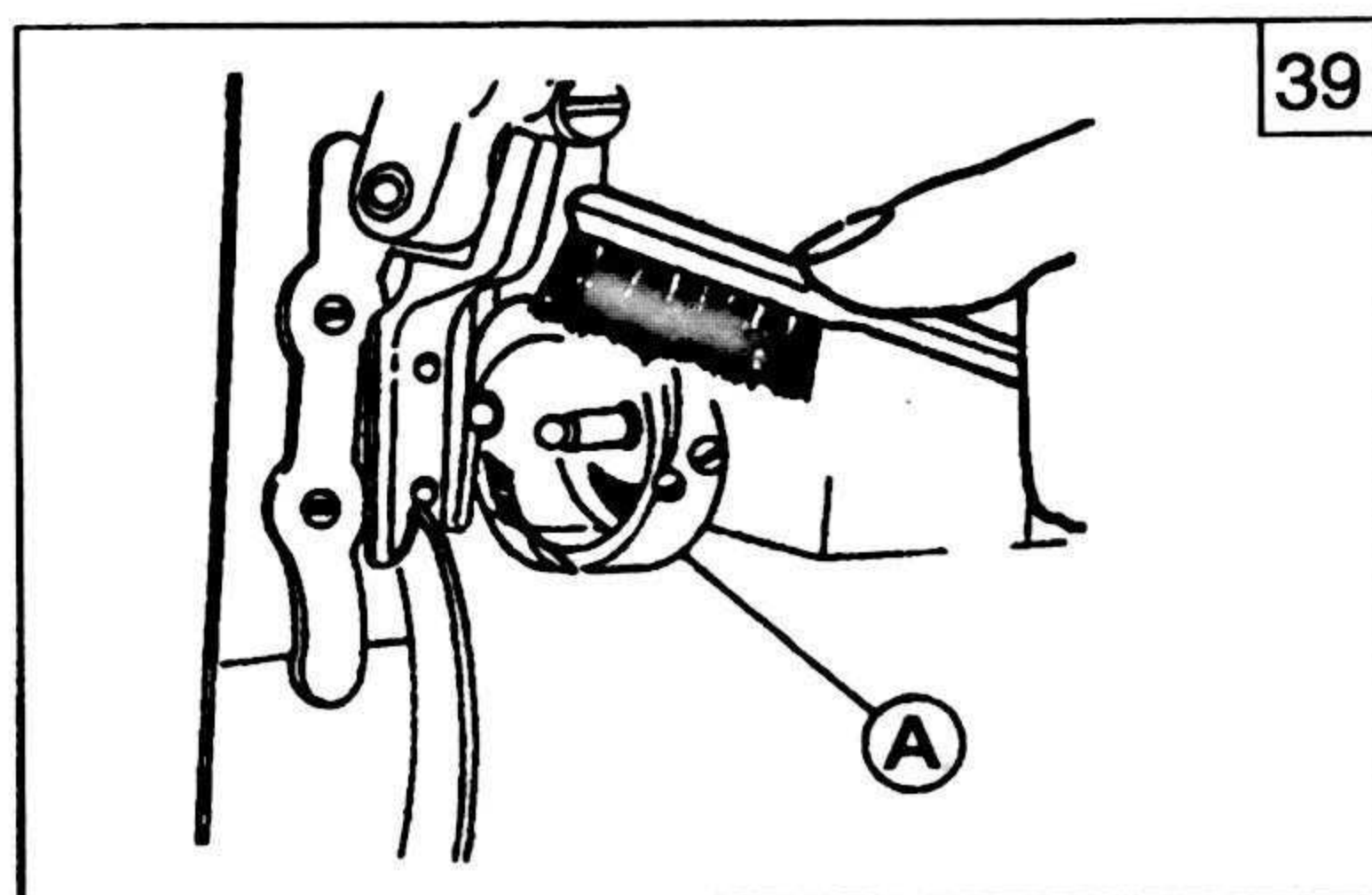


38

2.旋梭的清扫Cleaning rotating hook

清除旋梭(A)周围的尘垢，如图所示，同时用软布试擦梭心套

Swing out the machine head and clean the hookup the bobbin case with soft cloth.

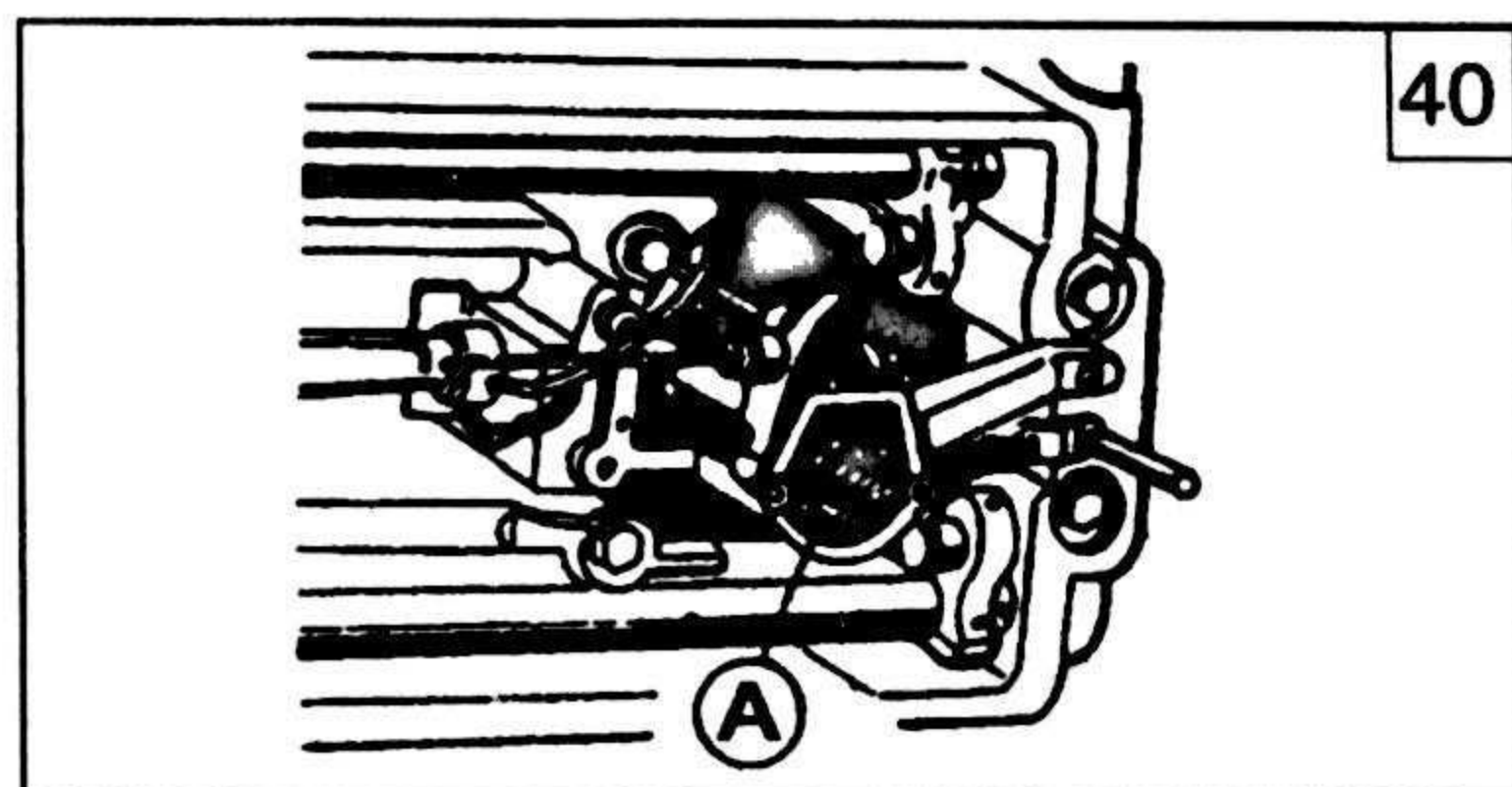


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3.油泵滤网的清扫Cleaning oil pump screen

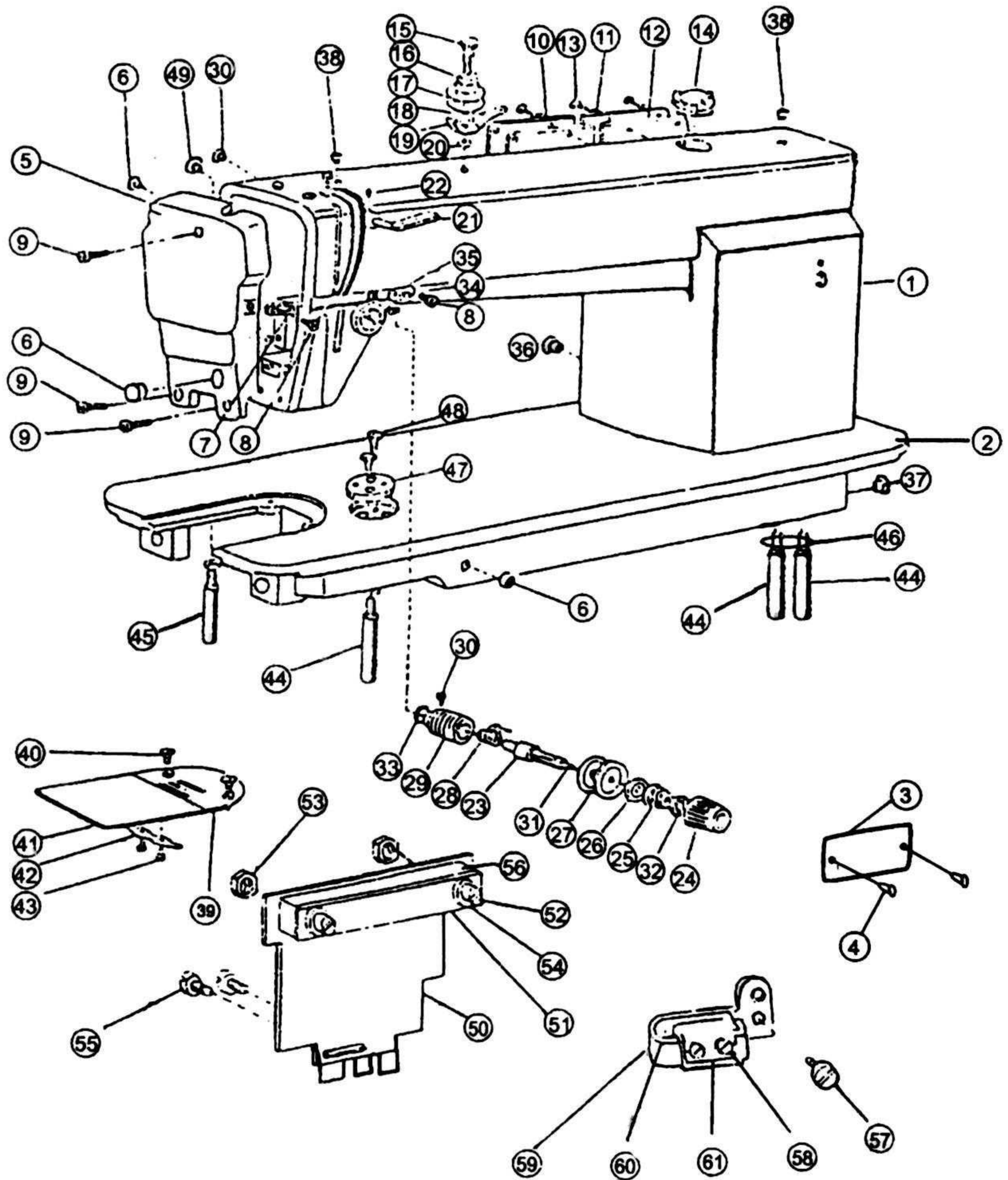
如图所示，清除滤网(A)上的尘屑。

Swing out the machine head and clear off the dust and dirt on the oil pump screen.



40

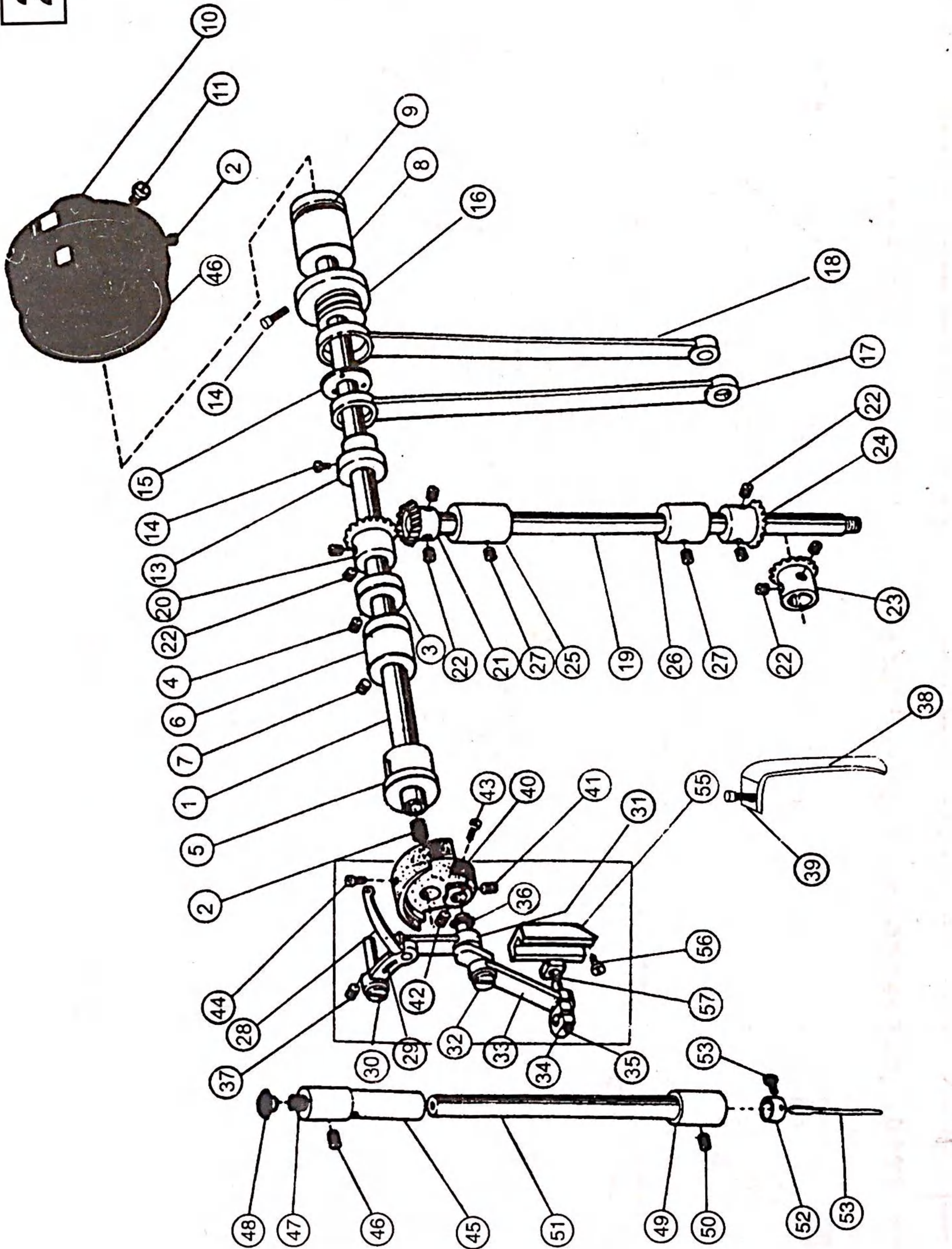
1



1.机壳部件 ARM MECHANISM

序号 No.	图号 Ref. No.	名称 Description	数量 Pes	备注 Remarks
1	618T1-001A1	机壳Arm	1	
2	330011002	底板Bed	1	
3	618T1-00B1	型号牌Trade mark plate	1	
4	628DT1-002B2	型号牌铆钉Trade mark plate rivet	1	
5	618T1-003C1	面板Face plate	1	
6	628DT1-003C4	面板橡皮塞Rubber plug	1	φ 11.8
		抬牙轴紧圈螺钉孔橡皮塞Rubber plug	1	φ 11.8
		机壳顶部橡皮塞Rubber plug	1	φ 11.8
		膝控提升杠杆(左)螺钉橡皮塞Rubber plug	1	φ 11.8
7	628DT1-003C5	面板线勾Thread guide on face plate	1	
8	628DT1-003C6	面板线勾螺钉Set screw SM3.57	1	SM9/64" (3.57)X40/6
9	618T1-004	面板螺钉Set screw SM4.37	3	SM11/64" (4.37)X40/10
10	330010040	后盖板(右)Rear cover (ringlet)	1	
11	330010041	后盖板(左)Rear cover (left)	1	
12	330010042	后盖板垫片Gasket for arm side cover	1	
13	628DT1-006	后盖板螺钉Set screw	8	SM11/64" (4.37)X40/9
14	628DT1-008H1	油窗Oil check window	1	
15	628DT1-009E1	小夹线器螺钉Screw type tension stud	1	
16	628DT1-009E2	小夹线器弹簧Spring for pretension	1	
17	628DT1-009E3	小夹线器板Disc for pretension	1	
18	628DT1-009E4	小夹线板垫块Space for pretension	2	
19	628DT1-009E5	小夹线过线板Pretension thread guide	1	
20	GB896-76	开口挡圈Stop ring	1	挡圈BLOCKING CIRCLE-3
21	628DT1-010	三眼线勾Three-hole thread guide	1	
22	628DT1-011	三眼线勾螺钉Set screw	1	SM11/64" (4.37)X40/5
23	628DT1-012F1	夹线螺钉Thread tension stud	1	
24	628DT1-012F2	夹线螺母Thumb nut	1	
25	628DT1-012F3	夹线弹簧Thread tension spring	1	
26	628DT1-012F4	松线板Thread tension releasing disc	1	
27	628DT1-012F5	夹线板Thread tension disc	2	
28	628DT1-012F6	挑线簧Thread take-up spring	1	
29	628DT1-012F7	夹线调节座Thread tension regulating bus	1	
30	628DT1-012F8	夹线调节座螺钉Set screw	1	SM9/64" (3.57)X40/6
31	628DT1-012F9	松线钉Thread tension releasing pin	1	
32	628DT1-012F10	夹线螺母止动板Stop disc	1	
33	628DT1-012F11	O型圈Rubber ring	1	
34	628DT1-013	夹线调节座固定螺钉Set screw	1	SM15/64" (5.95)X28/6
35	628DT1-014	线勾Thread guide at arm canter	1	
36	628DT1-015	橡皮塞Rubber plug	2	φ 88
37	628DT1-016	橡皮塞Rubber plug	1	φ 27
38	628DT1-017	橡皮塞Rubber plug	1	φ 5.7
39	628DT1-019	针板Needle plate	1	
40	628DT1-020	针板螺钉Needle plate screw	2	SM11/64" (4.37)X40/4.5
41	628DT1-021G1	推板Slide plate	1	
42	628DT1-021G2	推板簧Slide plate spring	1	
43	628DT1-021G3	推板簧螺钉Set screw	2	SM3/32" (2.38)X56/22
44	330010044	短底板撑杆Shor leg	3	
45	330010045	长底板撑杆long leg	1	
46	330010043	垫圈Washer	1	
47	628DT1-025	卷边器座Cloth guide plate	1	
48	628DT1-026	卷边器座螺钉Set screw	2	SM11/64" (4.37)X40/5
49	628DT1-003C3	回油观察孔橡皮塞Rubber plug	1	φ 19
50	330010031	挡油板Oil seal plate	1	
51	618T1-028	压脚板Press plate	1	
52	GB67	压脚板固定螺钉Set screw	2	M4X8
53	GB52	压脚板螺母Nut	2	M4
54	GB97	垫圈Washer	2	
55	628DT2-017	压脚板螺钉Set screw	2	SM1/8" (3.18)X44/4.5
56		毡垫Felt cushion	1	
57	628DT1-003C6	导线杆架固定螺钉Set screw	1	SM9/64" (3.57)X40/5
58	628DT1-021G3	导线板螺钉Set screw	2	SM3/32 (2.38)X56/4.5
59	618T1-032	导线杆架Thread guide bracket	1	
60	618T1-033	毛毡Felt	1	
61	618T1-034	导线板Thread guide plate	1	

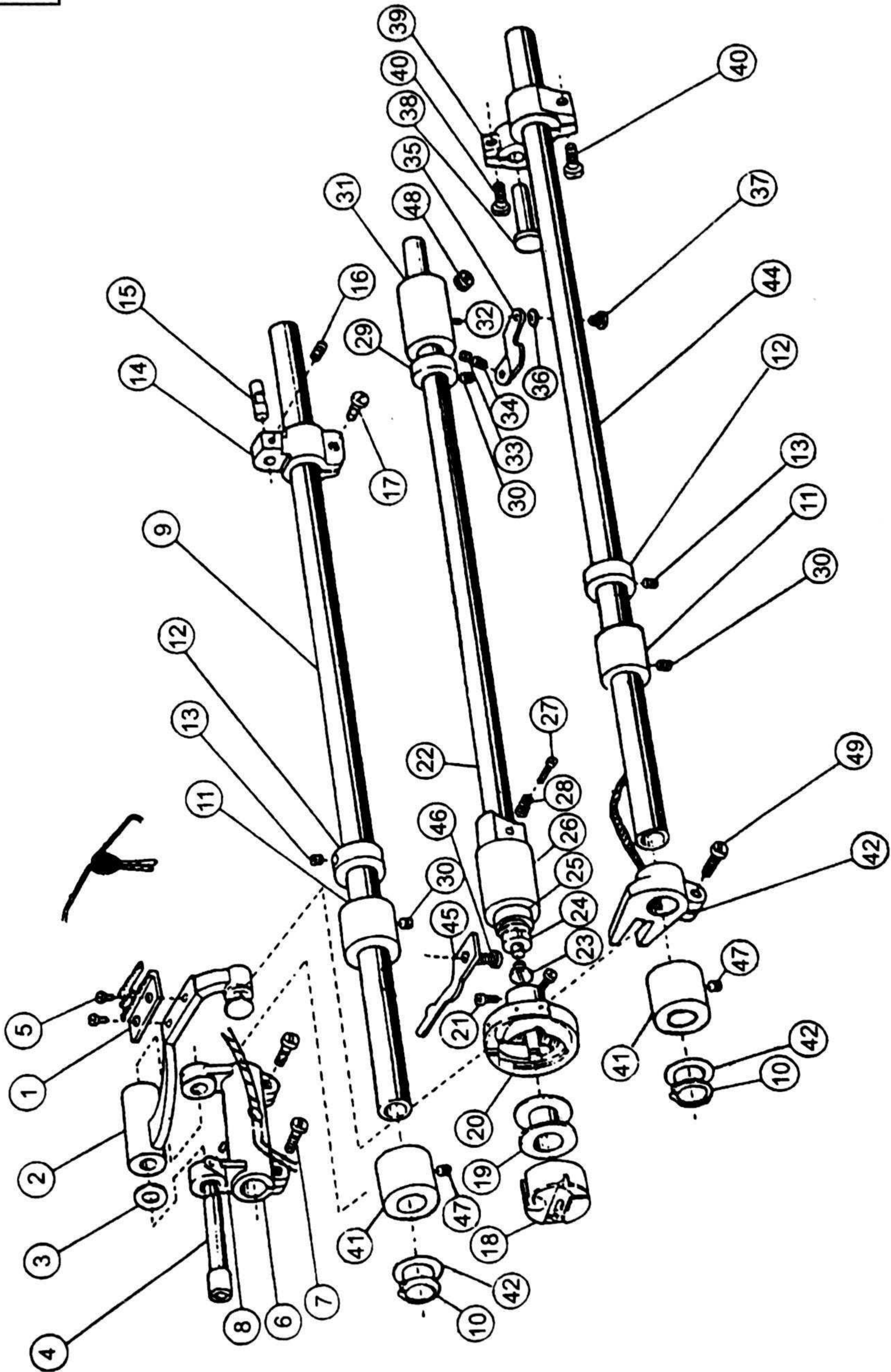
2



2.上轴、竖轴、针杆挑线部件 ARM SHAFT AND THREAD TAKE-UP MECHANISM

序号 No.	图号 Ref. No.	名称 Description	数量 Pes	备注 Remarks
1	330010002	上轴Arm shaft	1	
2	628DT3-001A2	上轴橡皮塞Rubber plug	2	φ 7.4X10
3	628DT3-002B1	上轴紧圈Collar for arm shaft	1	
4	628DT3-002B2	上轴紧圈螺钉Set screw	2	SM1/4" (6.35)X40/4
5	628DT3-003	上轴前轴套Arm shaft bushing (left)	1	
6	628DT3-004	上轴中轴套Arm shaft bushing (middle)	1	
7	628DT2-002	上轴中轴套螺钉Set screw	1	SM15/64" (5.95)X28/10
8	628DT3-005	上轴后轴套Arm shaft bushing (right)	1	
9	628DT3-006F	上轴后轴套油封Oil seal	1	
10	628T3-007C1	主动轮Balance wheel	1	
11	628DT3-007C2	主动轮螺钉Set screw	2	SM15/64" (5.95)X28/12
12	628DT3-008	上轴油封螺钉Screw	1	SM11/32" (8.73)X28/8
13	330010024	抬牙凸轮Feed and feed lifting eccentric	1	
14	330010038	抬牙送布凸轮螺钉Set screw	6	SM11/64" (4.37)X40/10
15	330010008	凸轮隔离板Eccentric sleeve	1	
16	330010007	送布凸轮Retaining ring	1	
17	628DT3-009D1c	抬牙连杆Crank rod for feed lifting rock shaft	1	
18	330010005	送布连杆Feed forked connection	1	
19	628T3-009E1	竖轴Vertical shaft	1	
20	628DT3-010E2a1	上轴伞齿轮Bevel gear for arm shaft	1	Z=27
21	628DT3-010E2b2	竖轴伞齿轮(上)Bevel gear for vertical shaft (upper)	1	Z=18
22	628DT2-005B3	伞齿轮螺钉Set screw	8	SM1/4" (6.35)X40/5
23	628DT3-010E2b1	下轴伞齿轮Bevel gear for hook shaft	1	Z=21
24	628DT3-010E2b2	竖轴伞齿轮(下)Bevel gear for vertical shaft (lower)	1	Z=28
25	628DT3-011	竖轴轴套(上)Vertical shaft bushing (upper)	1	
26	628DT3-012	竖轴轴套(下)Vertical shaft bushing (lower)	1	
27	628DT2-002	竖轴轴套螺钉Set screw	2	SM15/64" (5.95)X28/10
28	330010009	挑线杆Thread take-up lever	1	
29	330020007	挑线连杆Thread take-up lever link	1	
30	628DT2-001A3	挑线杆铰链轴Hinge pin	1	
31	330020008	挑线曲柄Thread take-up crank	1	
32	628DT2-001A6	挑线曲柄螺钉Set screw (left-handed)	1	SM9/64" (3.57)X40/4.8
33	330020006	针杆曲柄连杆Needle bar link	1	
34	330020003	针杆接头Needle bar adaptor	1	
35	628DT2-001A9	针杆接头螺钉Set screw	1	SM9/64" (3.57)X40/6
36		挑线曲柄弹性垫圈Washer	1	
37	628DT2-002	挑线连杆铰链轴螺钉Set screw	1	SM15/64" (5.95)X28/10
38	628DT2-003	挑线连杆防护罩Thread take-up guard	1	
39	628DT2-004	挑线连杆防护罩螺钉Screw	1	SM11/64" (4.37)X240/4
40	330010003	针杆曲柄Needle bar crank	1	
41	628DT2-005B2		1	SM1/4" (6.35)X40/5
42	628DT2-005B3	挑线曲柄定位螺钉Set screw	1	SM1/4" (6.35)X40/6
43	330020005	针杆曲柄螺钉Set screw	1	SM9/32" (7.14)X28/11
44	628DT2-007	针杆曲柄定位螺钉Set screw	1	SM9/32" (7.14)X28/10
45	628DT2-008	针杆上套Needle bar bushing (upper)	1	
46	628DT2-009	针杆上套螺钉Set screw	1	SM15/64" (5.95)X28/5
47	628DT2-010	针杆上套毡塞Felt plug	1	
48	628DT2-011	针杆上套橡皮塞Rubber plug	1	φ 8.8
49	330020002	针杆下轴套Needle bar bushing (lower)	1	
50	618T2-013	针杆下轴套螺钉Set screw	1	SM11/64" (4.37)X40/7
51	330010001	针杆Needle bar	1	
52	628DT2-015	针杆过线环Thread guide for needle bar	1	
53	628T2-016	机针Needle DBX1	1	DMX 1-2# 22
54	628DT2-017	夹针螺钉Needle clamp screw	1	SM1/8" (3.18)X44/44.5
55	628DT2-018	针杆接头滑块导轨Guide for slide block	1	
56	628DT2-019	滑块导轨螺钉Set screw	2	SM11/64" (4.37)X40/8
57	628DT2-020	针杆接头滑块Slide blood	1	

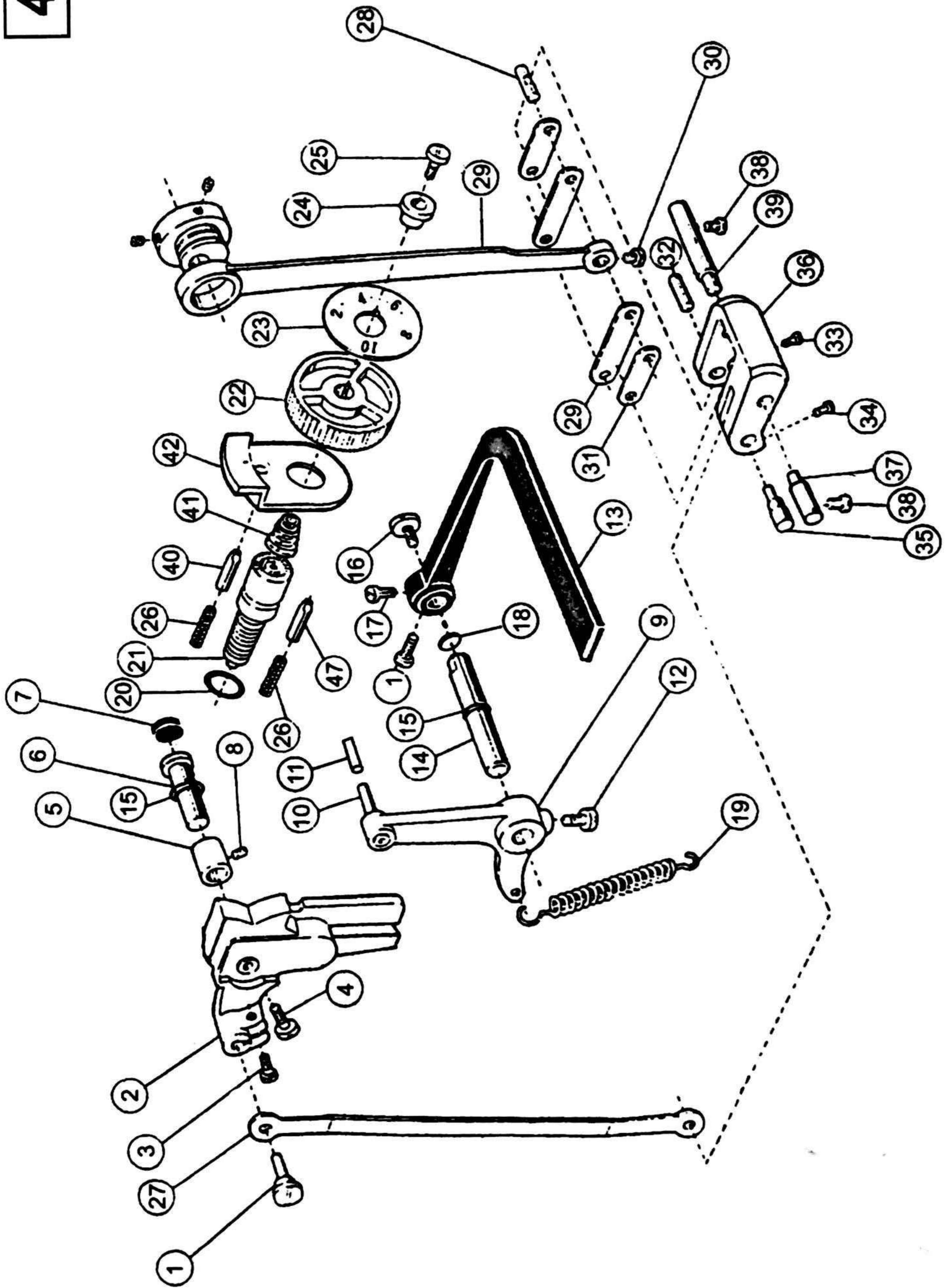
3



3. 抬牙、送布勾线部件 FEEDING AND FEED LIFTING MECHANISM

序号 No.	图号 Ref. No.	名称 Description	数量 Pes	备注 Remarks
1	330010032	送布牙 Feed dog	1	
2	330010030	牙架 Feed bar	1	
3	628DT6-001A6	牙架垫圈 Washer	1	
4	330010029	牙架曲柄偏心轴 Shaft for feed bar	1	
5	628DT-001A4	送布牙螺钉 Screw	2	SM1/8" (3.18) X44/6
6	330010028	牙架曲柄 Feed rock crank	1	
7	628DT6-001A1b	牙架曲柄螺钉 Screw	2	SM3/16" (4.76) X28/15
8	628DT2-019	牙架偏心轴螺钉 Screw SM 4.37	1	SM11/64" (4.37) X40/8
9	330010011	送布轴 Feed rock shaft	1	
10	GB894-76	轴用弹性挡圈 C-type stop ring	1	挡圈 BLOCKING CIRDE 15 GB894-74
11	330010026	抬牙送布轴套 Bushing for feed rock shaft (middle)	1	
12	628DT6-005B1	送布轴紧圈 Collar for feed lifting rock shaft	1	
13	628DT3-002B2	送布轴紧圈螺钉 Screw	2	SM1/4" (6.35) X40/4
14	330010006-1	送布曲柄 Feed rock shaft craned (right)	1	
15	330010009	曲柄连杆短销 Hinge pin	1	
16	628DT2-019	曲柄连杆短销螺钉 Screw SM 4.37	1	SM11/64" (4.37) X40/8
17	628DT6-008D4	送布曲柄夹紧螺钉 Screw	2	SM11/64" (4.37) X40/12
18	628DT4-0164F	旋梭套组件 Bobbin case	1	
19	628DT4-016F2	旋心 Bobbin	1	
20	628DT4-011E	旋梭组件 Rotating hook complete	1	
21		旋梭螺钉 Set screw	2	
22	628DT4-001A1	下轴 Rotating hook shaft	1	
23	628DT4-001A1a1	下轴滤油螺钉 Filter screw	1	SM3/16" (4.76) X32/8
24	628DT4-001A1a2	下轴滤油塞 Filter	1	
25	628DT4-003G	下轴油封 Oil seal for rotating hook shaft	1	
26	628DT4-004	下轴前轴套 Hook shaft bushing (left)	1	
27	628DT4-005	油量调节螺钉 Oil adjusting screw	1	
28	628DT4-006	油量调节弹簧 Spring for oil adjust	1	
29	628DT4-002B1	下轴紧圈 Collar for hook shaft	1	
30	628DT2-009	下轴紧圈螺钉 Set screw	2	SM15/64" (5.95) X28/4
31	628DT4-007C1	下轴后轴套 Hook shaft bushing bright	1	
32	628DT4-007C2	下轴轴套油管 Oil pipe for hook shaft bushing	1	
33	628DT4-008	柱塞 Plunger	1	
34	628DT-009	柱塞弹簧 Plunger spring	1	
35	628DT4-010	挡板 Guide plate	1	
36	GB93-76	挡板螺钉弹簧垫圈 Spring washer	1	挡圈 6 GB894-76
37	628DT8-009	挡板螺钉 Screw	1	
38	628DT4-015	抬牙轴曲柄铰链轴 Hinge pin	1	
39	628DT4-014G	抬牙轴曲柄(右) Feed lifting rock shaft crank (right)	1	
40	628DT4-Alb	抬牙曲柄螺钉 Screw	2	SM3/16" (4.76) X28/12
41	330010027	抬牙送布轴前轴套 Bushing for feed lifting rock shaft	3	
42	628DT6-013	抬牙送布轴套垫圈 Washer	1	
43	330010019	抬牙叉 Feed lifting shaft crank	1	
44	330010025	抬牙轴 Feed rock lifting shaft	1	
45	628DT4-013	旋梭定位钩 Rotating hook posit snev	1	
46	628DT4-014	旋梭定位钩螺钉 Screw	1	SM11/16" (4.37) X40/10
47	628DT2-002	送布轴轴套螺钉 Screw	1	SM15/64" (5.95) X28/10
48	628DT2-002	下轴轴套螺钉 Hook shaft bushing screw	1	SM15/64" (5.95) X28/10
49	618T7-040BLB	抬牙叉夹紧螺钉 Lifting tooth tore tag tang screw	1	

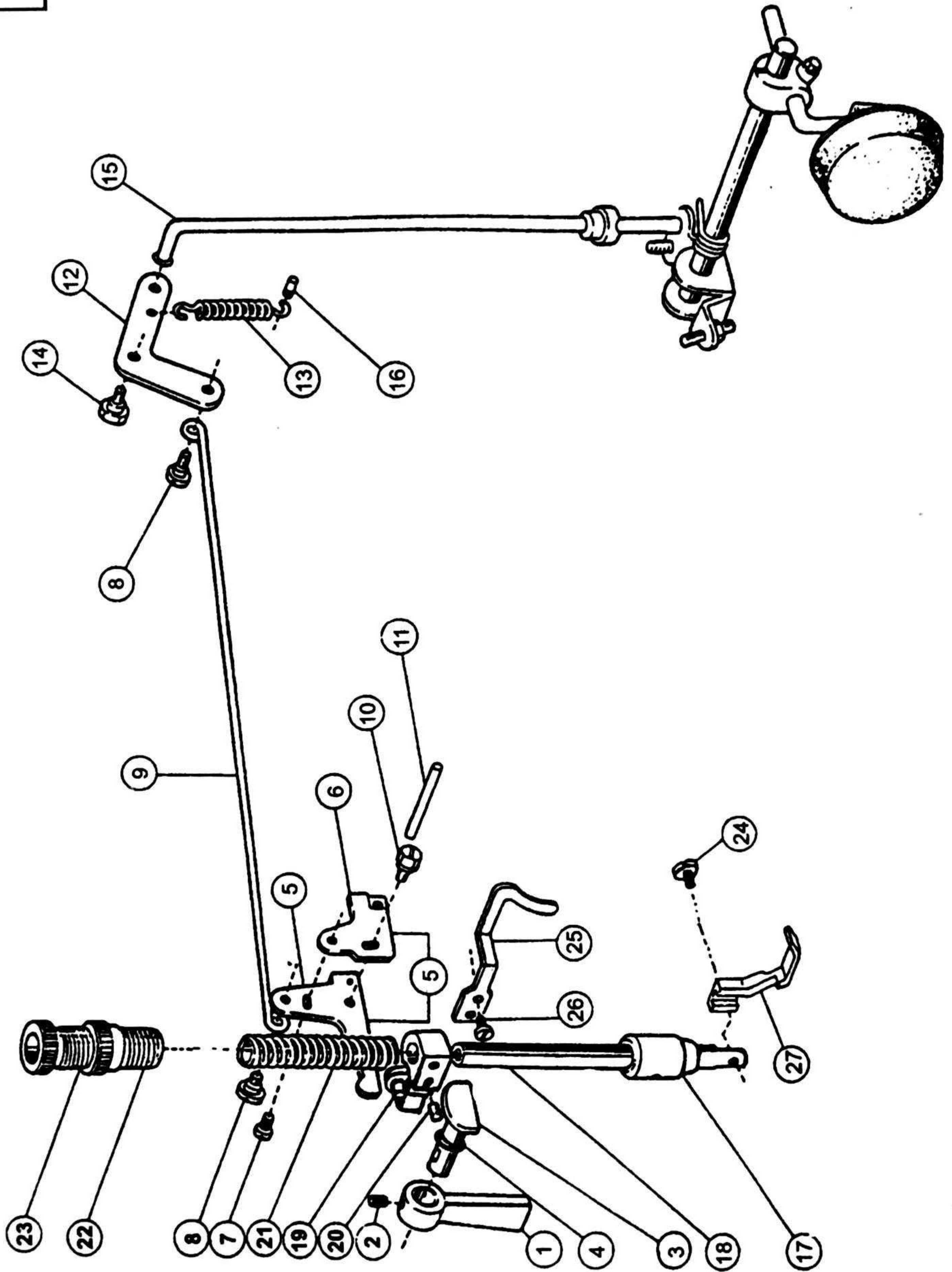
4



4. 送布调节部件 STITCH LENGTH REGULATING MECHANISM

序号 No.	图号 Ref. No.	名称 Description	数量 Pes	备注 Remarks
1	330010015	针距调节连杆销Connecting stud	1	
2	330010012	针距座Feed regulator	1	
3	618T1-004	针距座长螺钉Screw	1	SM11/64" (4.37)X40/10
4	628DT5-001A4	针距座短螺钉Screw of feed regulator	1	SM15/64" (5.95)X28/8.5
5	330020001	针距座轴套Feed regulator bushing	1	
6	628DT5-004	针距座轴Feed regulator shaft	1	
7	628DT5-005	橡皮塞Rubber play	1	φ 20X4
8	628DT5-002	针距座轴套紧固螺钉Set screw	1	SM15/64" (5.95)X28/10
9	330010021	倒缝操纵杆曲柄Buck tucking crank	1	
10	628DT5-012E1a1	操纵杆曲柄滑块轴Slide block pin	1	
11	330010022	操纵杆曲柄滑块Crank slide block	1	
12	628DT5-013	操纵杆曲柄螺钉Set screw	1	SM15/64" (5.95)X28/6.7
13		倒缝操纵杆Back tacking lever	1	
14	330010020	倒缝操纵杆轴Buck tucking lever shaft	1	
15	628DT5-006C4	O型密封圈O-ring	1	φ 9X1.9
16	628DT5-010D3	倒缝操纵吊紧螺钉Screw	1	SM3/16" (4.76)X28/6.5
17	628DT5-001A4	倒缝操纵杆螺钉Screw	2	SM15/64" (5.95)X28/8.53
18	628DT5-011	倒缝操纵杆垫圈Washer	1	
19	330010046	倒缝操纵杆曲柄弹簧Lever spring	1	
20	200045004	O型橡胶圈O-ring	1	14X2.4
21	330010033	针距调节螺杆Feed regulator screw	1	
22	330010034	针距盘Knob	1	
23	330010034-1	针距标盘Dial	1	
24	200045005	针距标盘套Bushing	1	
25	200045003	针距盘螺钉Screw	1	SM4.76X28
26	628DT5-009	止动销弹簧Spring for stopper pin	1	
27	330010014	针距调节连杆Feed regulator link	1	
28	330010010	曲柄连杆长销Sink shaft	1	
29	330010018	曲柄长连杆Lever feed connecting rod	2	
30	330010038	长连杆销螺钉Screw	1	SM11/64" (4.37) X40/10
31	330010018	曲柄短连杆Feed rock link	2	
32	330010019	曲柄短连杆销Pin	1	
33	628DT1-012F8	短连杆销螺钉Screw	1	SM9/64" (3.57) X40/6
34	628DT1-012F8	连杆偏心轴螺钉Screw	1	SM9/64" (3.57) X40/6
35	330010016	连杆偏心轴Lever link eccentric shaft	1	
36	330010013	针距调节曲柄Lever regulator	1	
37	330010017	针距调节曲柄定位销(左)Pin (left)	1	
38	200043006	针距调节曲柄定位销螺钉Screw	2	SM5.95
39	330010017	针距调节曲柄定位销(右)Pin (right)	1	
40	628DT5-008	止动销Stopper pin	1	
41		针距按键簧Spring	1	
42		针距盘挡销Pin for knob	1	

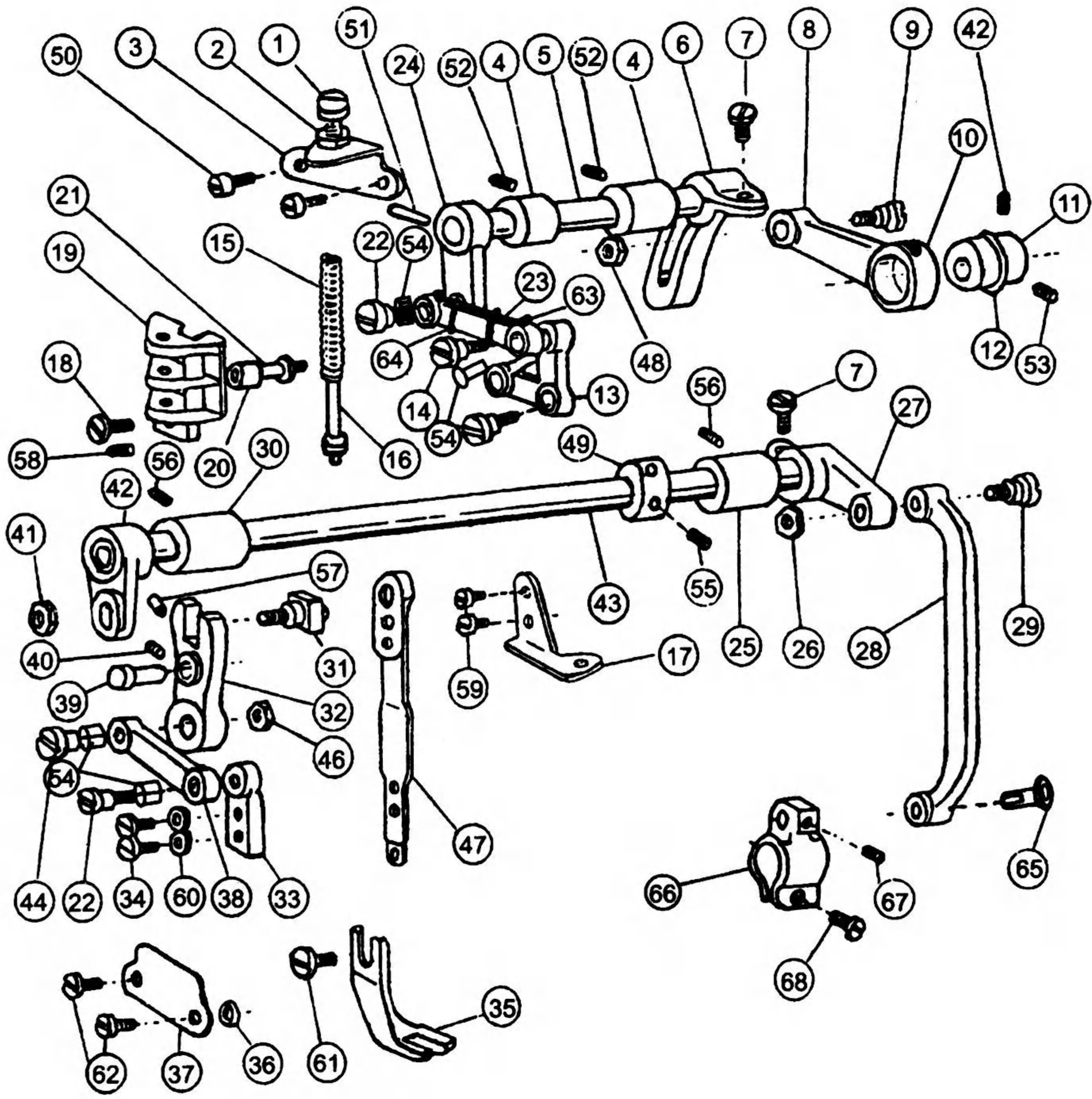
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5. 压脚部件 PRESSER FOOT MECHANISM

序号 No.	图号 Ref. No.	名称 Description	数量 Pes	备注 Remarks
1	618T7-001A1	压脚扳手Presser bar lifter	1	
2	628DT1-011	压脚扳手螺钉Set screw	1	SM11/64" (4.37)X40/5
3	628DT7-002	压脚提升凸轮Presser bar lifting cam	1	
4	628DT7-003	压脚提升凸轮O型圈O-ring	1	φ 8X1.9
5	628DT7-004B1a	压脚提升杠杆(左)Knee lifter lever (left)	1	
6	628DT7-004B1b	松线凸轮Tension releasing cam	1	
7	628DT7-004B1c	膝控提升杠杆(左)螺钉Scar	1	
8	628DT7-004B2	铰链螺钉Hinge screw	2	SM3/16" (4.76)X28/13
9	628DT7-004B3	膝控提升拉杆Knee lifter rod	1	
10	628DT7-005	松线凸轮螺钉Bolt	1	SM15/64" (5.95)X28/13
11	628DT7-006	松线杆Tension releasing pin	1	
12	628DT7-007C1	膝控提升杠杆(右)Knee lifter lever (right)	1	
13	628DT7-007C2	膝控提升杠杆弹簧Spring	1	
14	628DT7-005	膝控提升杠杆(右)螺钉Bolt for knee lifter lever	1	SM15/64" (5.95)X28/10
15	628DT7-007C3	膝控提升连杆Knee lifter connecting rod	1	
16	628DT7-008	弹簧销Pin for spring	1	
17	628DT7-009	压紧杆轴套Presser bar bushing	1	
18	628DT7-010	压紧杆Presser bar	1	
19	618T7-011D1	压紧杆导架Presser bar lifting bracket	1	
20	628DT1-013	压紧杆导架螺钉Set screw	1	SM15/64" (5.95)X28/7
21	628DT7-013	压紧杆弹簧Presser bar spring	1	
22	330010061	调压螺钉Presser regulating thumb screw	1	
23	330010062	调压螺钉锁紧螺母Lock nut	1	
24	628DT7-015	压脚螺钉Set screw	1	SM9/64" (3.57)X40/11
25	628DT7-016	大线勾Upper thread guide	1	
26	628DT2-004	大线勾螺钉Screw	1	SM11/16" (4.37)X40/7
27	618T7-017	内压脚Inner passer	1	

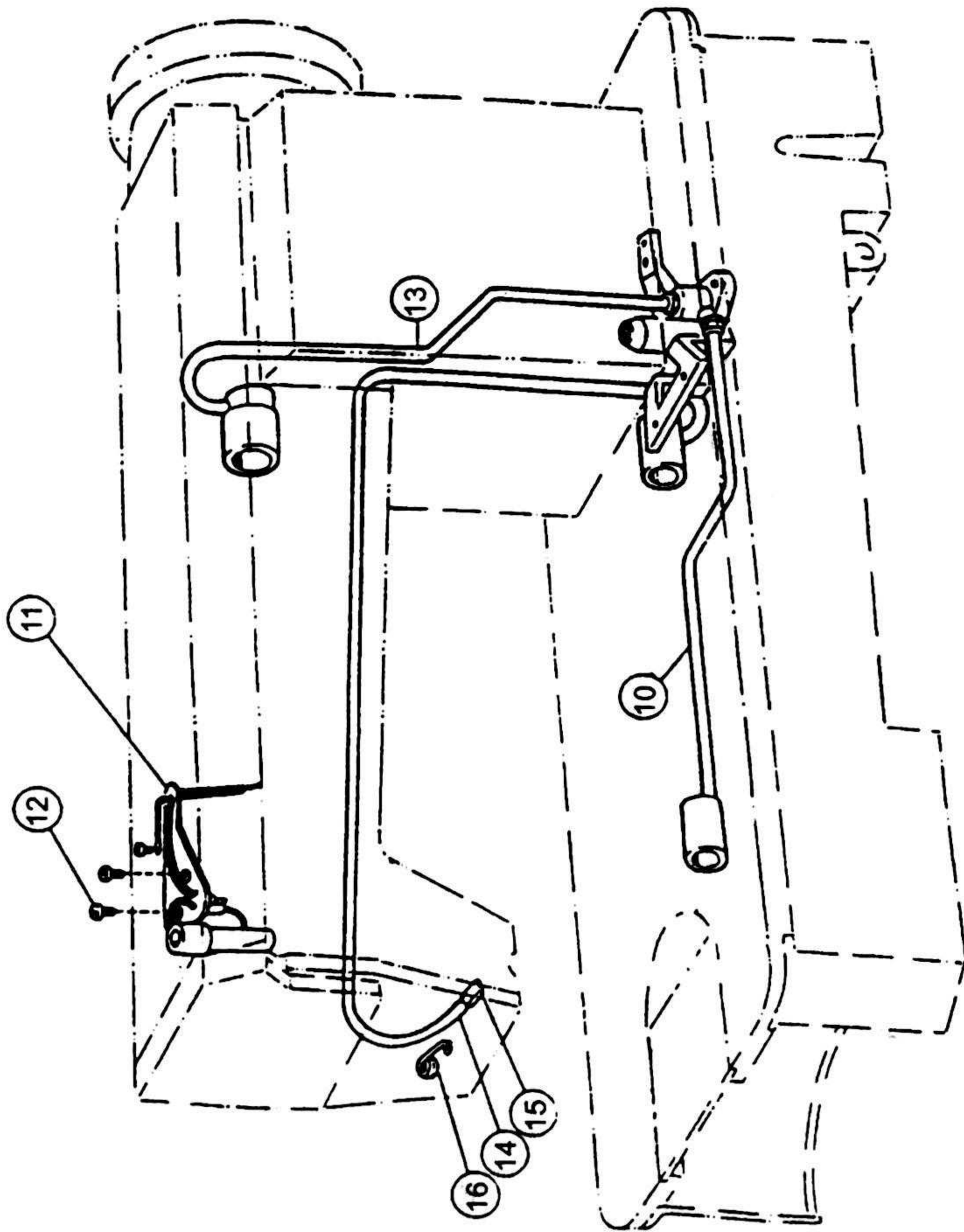
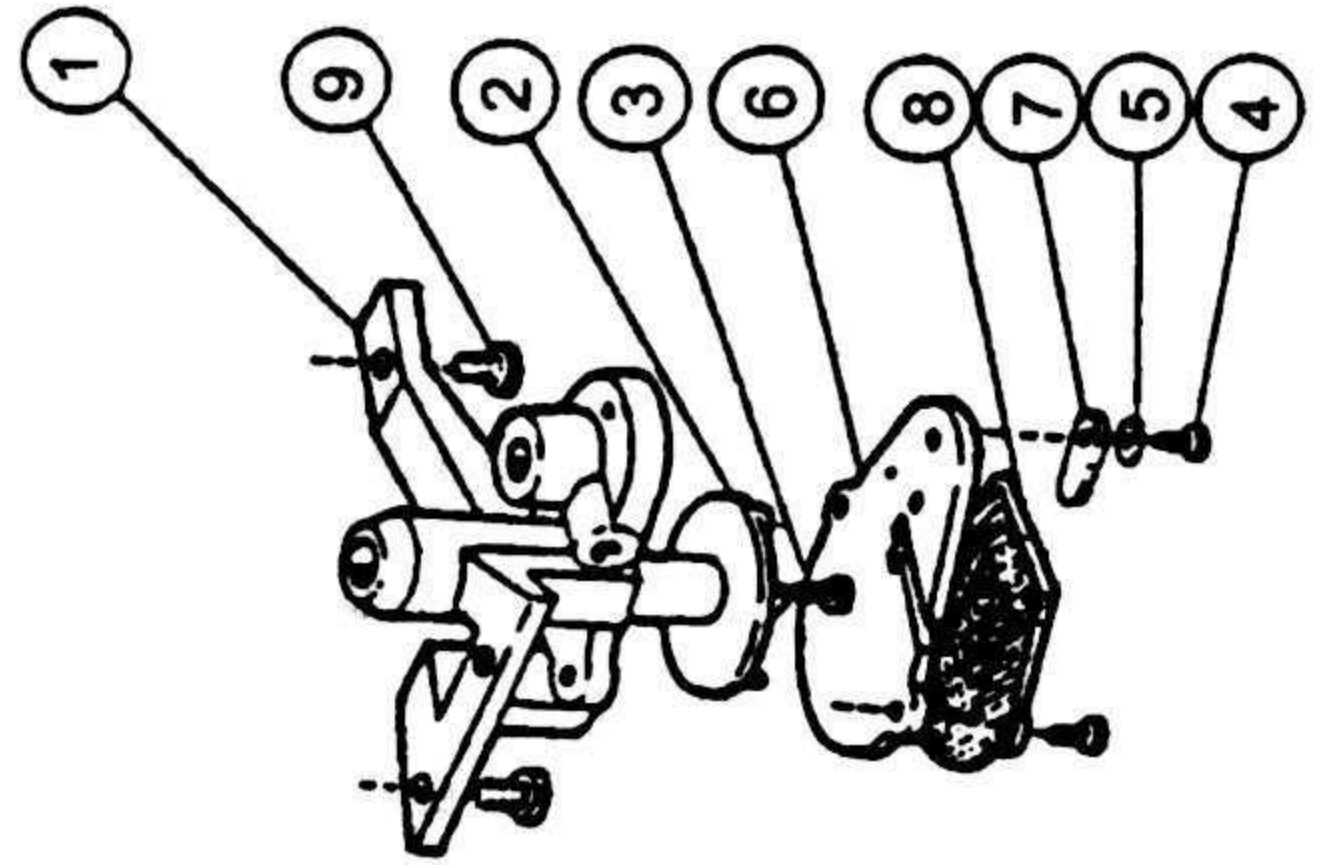
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6. 压脚提升、送料部件 PRESSER LIFTING FEEDING MECHANISM

序号 No.	图号 Ref. No.	名称 Description	数量 Pes	备注 Remarks
1	330010053	提升压脚调节螺钉 Lifting presser adjusting screw	1	
2	330010054	提升压脚调节螺母 Nut	1	
3	618T7-020b1	提升压脚弹簧架 Lifting presser bracket for spring	1	
4	618T7-020a1	压脚提升轴轴套 Presser lifting shaft bushing	2	
5	618T7-020	压脚提升轴 Presser lifting shaft	1	销 4X20
6	618T7-021	偏心连杆调节曲柄 Adjusting crank for eccentric wheel rod	1	
7	330010057	偏心连杆调节曲柄螺钉 Set screw	2	SM1/4"(6.35)X40/17
8	618T7-022	偏心轮连杆 Eccentric wheel rod	1	
9	330010055	偏心轮连杆螺钉 Set screw	1	
10	618T7-023	油毡夹 Oil felt clamp	1	
11	618T7-024	偏心轮 Eccentric wheel	1	
12	GB894-86	轴用C型挡圈 Washer	1	挡圈 25
13	618T7-025	压脚送料曲柄 Presser feed crank	1	
14	618T7-0215a1	压脚送料曲柄螺钉 Screw	1	SM3/16"(4.76)X28/10
15	618T7-026	提升压脚簧 Lifting Presser spring	1	
16	618T7-027	压脚簧导柱 Presser spring guide	1	
17	618T7-028	提升压脚导柱定位板 Lifting Presser guide blade	1	
18	618DT7-006	提升压脚导位板螺钉 Screw	2	
19	618T7-029	提升压脚导位板 Lifting presser plate	1	
20	618T7-030	提升压脚簧导位轴滚柱 Lifting presser spring guide pin	1	
21	618T7-031	送料曲柄导柱轴 Feed crank guide shaft	1	
22	330010050	压脚送料曲柄连杆螺钉 Screw	1	
23	618T7-032	压脚送料曲柄连杆 Presser feed crank link	1	
24	618T7-033	压脚提升曲柄 Presser lifting crank	1	
25	618T7-034	压脚摆动轴轴套(右) Presser swing shaft bushing (right)	1	
26	330010049	压脚摆动曲柄连接螺母 Screw	1	
27	618T7-035	压脚摆动曲柄(右) Presser swing crank (right)	1	
28	330010023-1	压脚摆动曲柄(右)连杆 Presser swing crank (right) rod	1	
29	330010048	压脚摆动曲柄(右)连杆螺钉 Screw	1	
30	618T7-036	压脚摆动轴轴套(左) Presser swing shaft bushing (left)	1	
31	330010058	滑块轴 Lifting presser sway crank shaft complete	1	
32	330010063	提升压脚变动曲柄 Lifting presser sway crank	1	
33	618T7-038	摆动连杆座 Presser rod guide	1	
34	618T7-038A1	摆动连杆座螺钉 Screw	2	
35	618T7-039	外压脚 Out presser	1	
36	618T7-040B1a	压脚连杆压板垫块 Space for presser rod plate	2	
37	618T7-040B1	提升压脚连杆压板 Lifting preset rod plate	1	
38	618T7-040	提升压脚变动曲柄连杆 Presser swing crank link	1	
39	618T7-041	提升压脚变动曲柄导柱 Lifting presser sawy crank guide pin	1	
40	618DT7-013	提升压脚变动曲柄导柱螺钉 Screw	1	
41	330010060	压脚曲柄连杆螺母 Presser crank connecting nut	1	
42	618T7-043	压脚摆动曲柄(左) Presser swing crank (left)	1	
43	330010012	压脚摆动轴 Presser swing shaft	1	
44	330010051	压脚送料变动连杆螺钉 Screw	1	
45	618T7-046	封油板 Oil seal plate	1	
46	330010052	压脚送料变动连杆螺母 Lock nut	1	
47	618T7-047	压脚连杆 Presser rod	1	
48	330010056	偏心轮连杆螺钉螺母 Nut	1	
49	618T7-048	压脚摆动轴紧圈 Collar for presser swing shaft	1	
50	618DT7-006	提升压脚弹簧架螺钉 Screw	2	
51	GB117-76	圆锥销 Pin	1	
52	618DT1-011	压脚提升轴轴套螺钉 Screw	2	SM1/64"(4.37)X40/5
53	628DT2-005B3	偏心轮螺钉 Screw	2	
54	618T7-049	滚针轴承 Needle bearing	1	
55	618T7-050	压脚摆动轴紧圈螺钉 Screw	1	
56	628DT1-011	压脚摆动轴套螺钉 Screw	2	
57	GB117-76	压脚摆动曲柄(右)销 Pin	1	
58	618T7-029a2	提升压脚导位板销 Pin	1	
59	618T1-028B1	提升压脚导柱定位板螺钉 Screw	2	
60	618T7-038A2	摆动连杆座螺钉垫圈 Washer	2	
61	628DT7-015	压脚螺钉 Screw	1	
62	618T7-040B1b	提升压脚连杆压板螺钉 Screw	2	
63		油线 wick	1	
64		油线夹 Wick support	3	
65	330010047-1	送布曲柄铰链轴 Feed rock crank shaft	1	
66	33001006-2	送布轴曲柄(中) Feed rook crank (min)	1	
67	628DT2-019	连杆曲柄连接销钉 Screw SM 4.37	1	SM11/16"(4.37)X40/8
68	628DT6-008D4	送布曲柄(中)螺钉 Screw SM 4.37	1	SM11/16"(4.37)X40/12

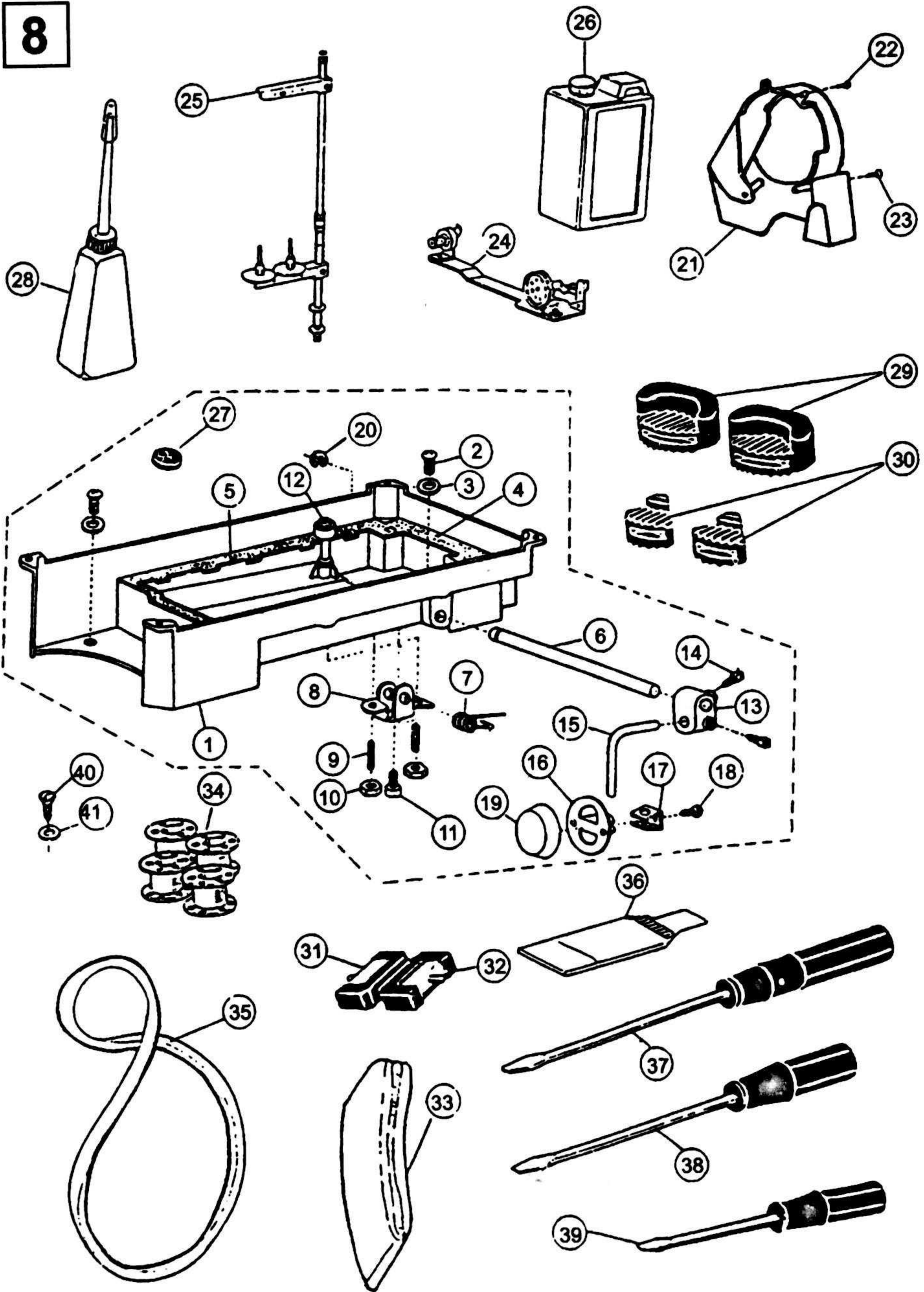
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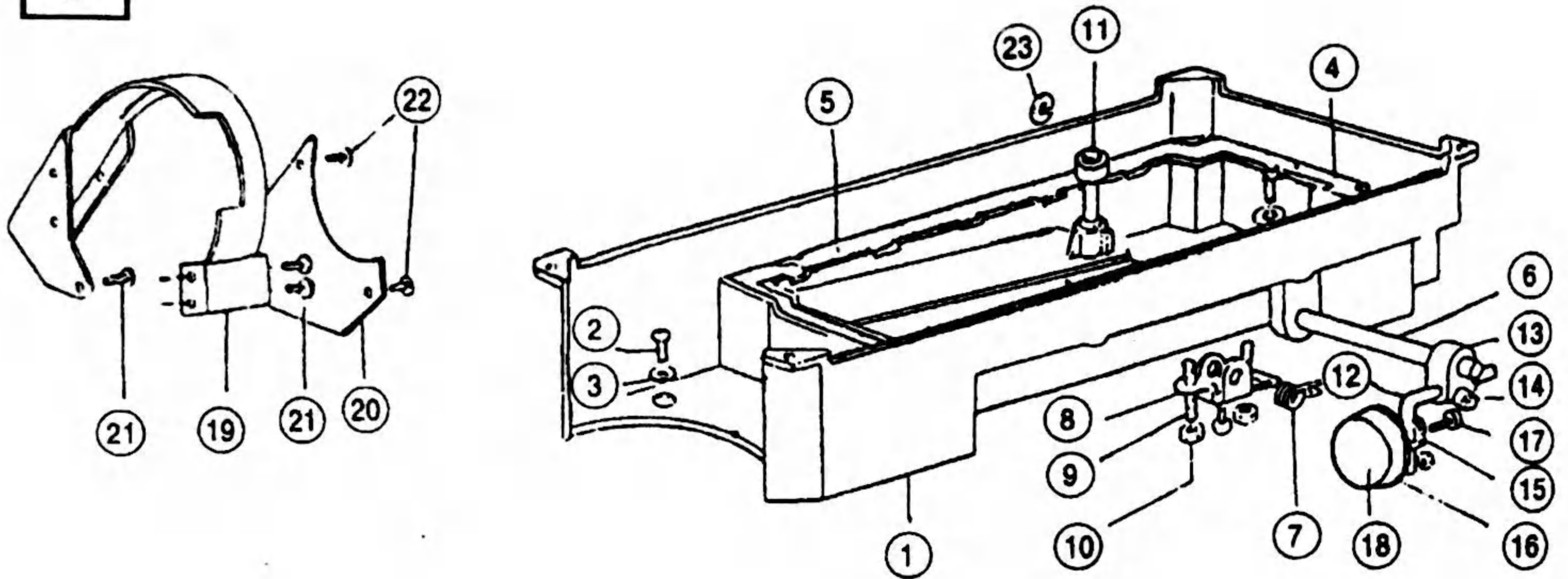
7. 油泵部件 LUBRI CATION MECHANISM

序号 No.	图号 Ref. No.	名称 Description	数量 Pes	备注 Remarks
1	628DT8-001	油泵体Oil pump body	1	
2	628DT8-002	油泵叶轮Oil pump impeller	1	
3	628DT8-003	油泵叶轮螺钉Screw	1	
4	628DT8-004	油泵调节板螺钉Screw	3	SM1/8" (3.18)X44/13
5	628DT8-005	油泵调节板螺钉弹簧垫圈Spring washer	1	
6	628DT8-006	油泵体盖板Oil pump felting plate	1	
7	628DT8-007	油量调节板Oil adjusting plate	1	
8	628DT8-008A	油泵网组件Oil pump screen complete	1	
9	628DT8-009	油泵体螺钉Screw	3	SM11/64" (4.37)X40/13
10	628DT8-010B	下轴油管组件Oil pipe for hook shaft	1	
11	628DT8-011C	油线固定板大组件Oil braid fitting plate	1	
12	628DT8-012	油线固定板螺钉Screw	2	SM11/64" (3.57)X40/11
13	628DT8-013D	上轴油管组件Oil pipe for arm shaft	1	
14	628DT8-014	回油管Oil returning pipe	1	φ 3X650
15	628DT8-015	回油管滤油毡Felt pouch for return oil filter	1	
16	628DT8-016	回油管弹簧夹Oil returning pipe holder	1	

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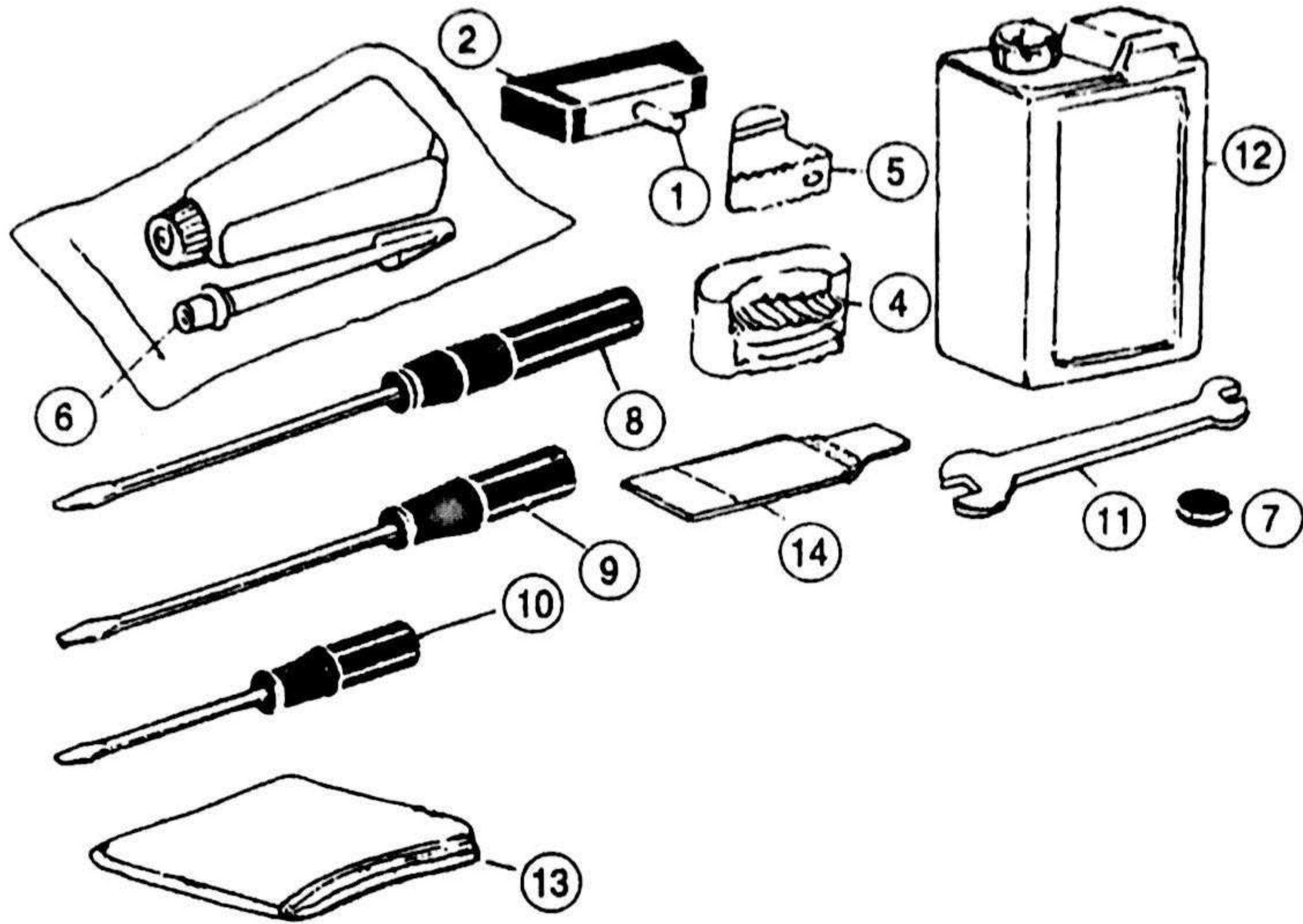
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8. 油盘部件OIL RESERVOIR AND OTHER ACCESSORIES

序号 No.	图号 Ref. No.	名称 Description	数量 Pes	备注 Remarks
1	628DT9-001A1	油盘Oil reservoir	1	
2	628DT9-001A2	放油螺钉Oil drain screw	1	SM5/16" (7.94) X28/10
3	628DT9-001A3	放油螺钉垫圈Washer	1	
4	628DT9-001A4	油盘垫(小)Gasket for oil reservoir (small)	1	
5	628DT9-001A5	油盘垫(大)Gasket for oil reservoir (big)	1	
6	628DT9-001A6	膝控铰链轴Hinge pin for knee lifter	1	
7	628DT9-001A7	膝控复位弹簧Back spring for knee lifter	1	
8	628DT9-001A8	膝控限位架Knee lifter stop bracket	1	
9	628DT9-001A9	膝控限位调节螺钉Adjusting screw	2	SM15/64" (5.94) X28/25.5
10	628DT9-001A10	调节螺母Lock nut	2	
11	628DT9-001B1	膝控提杠杆Knee lifter lifting rod	1	
12	628DT9-001B2	膝控提升弯杆Knee lifter bell crank	1	
13	628DT9-001B3	碰块弯杆接头Joint for knee lifter bell crank	1	
14	628DT9-001B4	碰块弯杆接头螺钉Set screw	2	SM5/16" (7.94) X28/10
15	628DT9-001B5	碰块架Knee lifter plate	1	
16	628DT9-001B6	膝控碰块Bracket for knee lifter plate	1	
17	628DT9-001B7	碰块架螺钉Set screw	1	SM15/64" (5.94) X28/6.8
18	628DT9-001B8	碰块垫Pad for knee lifter plate	1	
19	628DT9-001C1	皮带罩架Belt guard	1	
20	628DT9-001C2	皮带罩板Belt guard	1	
21	628DT1-006	皮带罩螺钉(小)Screw (small)	1	SM11/64" (4.37) X40/9
22	618T9-005	皮带罩螺钉(大)Screw (big)	1	
23	GB896-76	开口挡圈C-type stop ring	1	挡圈9

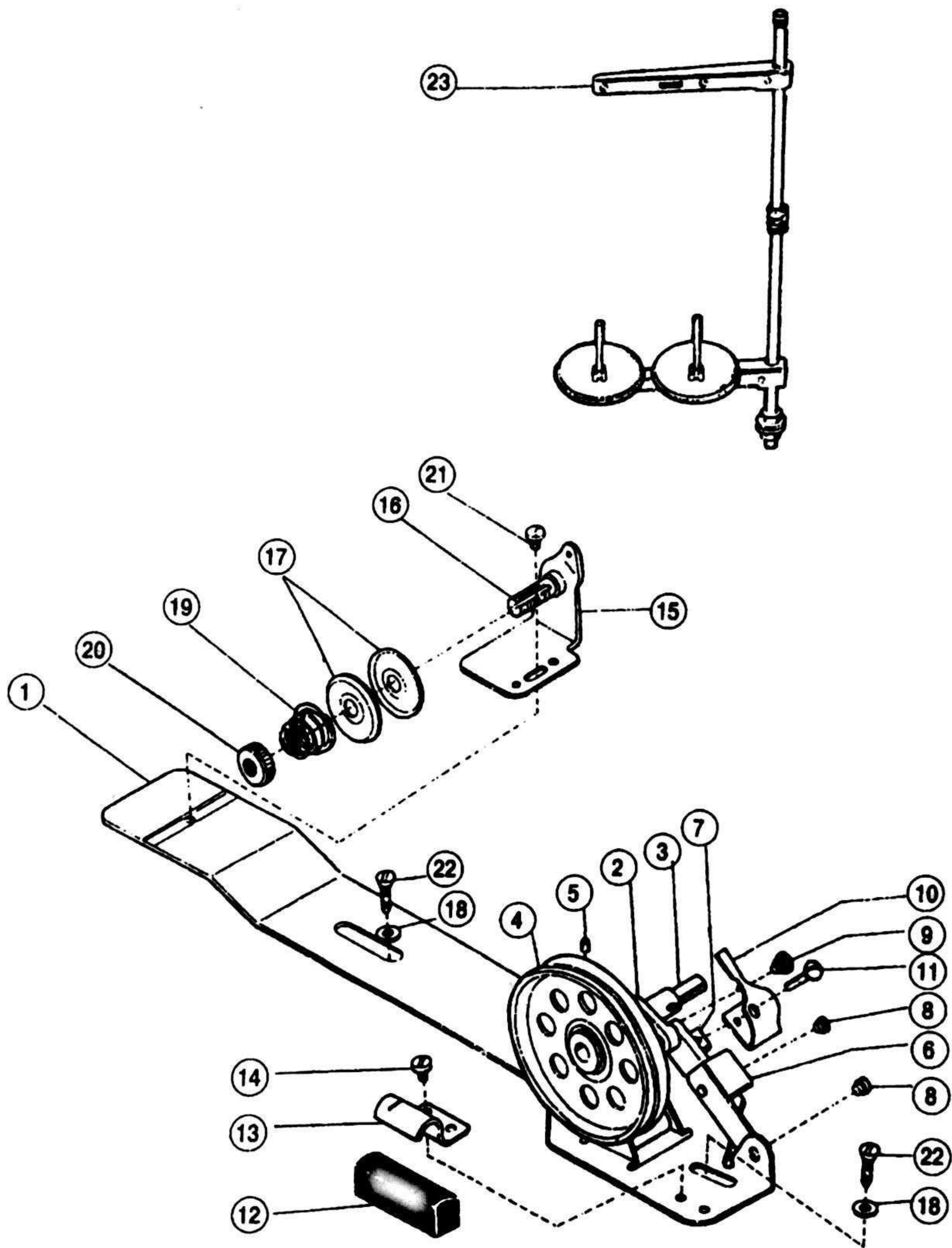
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9. 附件 OTHER ACCESSORIES

序号 No.	图号 Ref. No.	名称 Description	数量 Pes	备注 Remarks
1	628DT10-001A1	机壳铰链Hinge of machine head	2	
2	628DT10-001A2	机壳铰链套Rubber socket for hinge	2	
4	628DT10-002	机壳防震垫块(大)Rubber cushion (big)	2	
5	628DT10-003	机壳防震垫块(小)Rubber cushion (small)	2	
6		小油壶Oiler	1	
7	628DT10-004	磁块Magnet	1	
8	628DT10-005	螺钉起子(大)Screw driver (Long)	1	
9	628DT10-006	螺钉起子(中)Screw driver (medium)	1	
10	628DT10-007	螺钉起子(小)Screw driver (short)	1	
11	628DT10-008	双头扳手Double-end wrench	1	
12	628DT10-009	油箱Oil container	1	
13	628DT10-010	机头罩Vinyl cover	1	
14	628DT10-011	机针Needle	1	
15	628DT10-012	说明书Instruction book	1	

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10. 绕线器、线架 BOBBIN WINDER MECHANISM

序号 No.	图号 Ref. No.	名称 Description	数量 Pes	备注 Remarks
1	628DT11-001A1	绕线器底座Bobbin winder base	1	
2	628DT11-001A2	绕线架组件Bobbin winder arm	1	
3	628DT11-001A3	绕线轴Bobbin winder spindle	1	
4	628DT11-001A4	绕线轮Bobbin winder pulley	1	
5	628DT11-001A5	绕线轮螺钉Screw	1	
6	628DT11-001A6	绕线摆杆Bobbin winder stop latch lever	1	
7	628DT11-001A7	绕线连杆Bobbin winder enacting bar	1	
8	628DT11-001A8	铆钉Rivet	2	
9	628DT11-001A9	绕线连杆螺钉Screw	1	
10	628DT11-001A10	满线跳板Bobbin winder stop latch	1	
11	628DT11-001A11	满线度调节螺钉Adjusting screw	1	
12	628DT11-001A12	制动块Stopper block	1	
13	628DT11-001A13	制动块固定勾Fixture for stopper block	1	
14	628DT11-006	制动块固定勾螺钉Set screw	1	SM11/64" (4.37)X40/9
15	628DT11-001A14	过线架Bobbin winder tension bracket	1	
16	628DT11-001A15	过线架夹线螺钉Bobbin winder tension stud	1	
17	628DT1-001E3	过线架夹线板Bobbin winder tension disc	2	
18	GB95-85-6	绕线架木螺钉垫圈Tension stud bushing	2	
19	628DT11-001A16	夹线簧Bobbin winder tension spring	1	
20	628DT1-012F2	夹线螺母Tension stud nut	1	
21	628DT1-006	过线架螺钉Tension bracket screw	2	SM11/64" (4.37)X40/9
22	GB99-86	绕线架木螺钉Wood screw	2	φ 6X25
23	628DT11-002B	绕线架组件Washer	1	